

TITLE: Stock Escutcheon XP100

Process Header

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Document ID: Stk Escutcheon XP100	Remington Arms Company
Part Name: Stock Escutcheon XP100	
Product Line: C/F Rifle	Effective Date: 03-Nov-1992-09:00:00
Engineering Group: Rifle	Origination Date: 07-Oct-1992

Process Revision Reasons

Date:	Reason For Revision:	Eng Log #:
07-Oct-1992	New	GLC 293105
31-Oct-1992	Add part#15451	MMP 293293

Process Approval List

Approved By:	Badge #:	Date:	Designation:
JacksonRA			

Process General Notes

Notes:

Process Material

Part Number	Qty	Description
97751		Stock Escutcheon - XP100
97760		Blank
15451		Stock Escutcheon - XP100
16875		Blank

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Process Routing

Oper	Operation Description	Part Numbers
8551 20	Black Oxide Color	97751,15451
	To MRP Crib #29	97751,15451

Operation Step Detail

Operation: 20

Step	Operation / Step Description
	Black Oxide Color

Operation Procedure Notes

Operation: 20

Description

SMALL PARTS BLACK OXIDE COLOR

BLACK OXIDE RACK/FIXTURE:

LOAD SIZE:

STEP	PROCESS SEQUENCE	TEMPERATURE	CONCENTRATION	IMERSION TIME
1	Alkaline Clean	212 F	7-9%	3-5 Minutes
2	Cold Water Rinse	Ambient	-----	1 Minute
3	Muriatic Acid	Ambient	15-17%	10-15 Seconds
4	Cold Water Rinse	Ambient	-----	1 Minute
5	Black Oxide #1	290 F	6.5-6.8 lbs/gal	30 Minutes
6	Cold Water Rinse	Ambient	-----	1 Minute
7	Black Oxide #2	300 F	7.0-7.3 lbs/gal	30 Minutes
8	Hot Water Rinse	212 F	-----	1 Minute
9	Braze Color	185 F	1.0-1.3 lbs/gal	30 Minutes
10	Hot Water Rinse	212 F	-----	1 Minute
11	Steelgard	Ambient	15-20%	30 Seconds

NOTE FOR POWDER METAL AND M.I.M. PARTS

- * Increase immersion time on step #3 to 30-45 seconds.
- * Increase immersion time on step #8 to 30 minutes.

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