

BARBER - PRESALE R 0119661

TITLE: Bolt Handle XP100

Process Header**Process Header**

Document ID: Bolt Handle XP100	Remington Arms Company
Part Name: Bolt Handle XP100	
Product Line: C/F Rifle	Effective Date: 07-Oct-1992-09:00:00
Engineering Group: Rifle	Origination Date: 06-Oct-1992

Process Revision Reasons

Date:	Reason For Revision:	Eng Log #:
06-Oct-1992	Retype Entire Process From 279170 - Replaces Old Paper Process	GLC 293091

Process Approval List

Approved By:	Badge #:	Date:	Designation:
Jacksora			

Process General Notes**Notes:**

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Process Material

Part Number	Qty	Description
15408	1	Bolt Handle - XP100
D-16510	1	Blank

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Process Routing

Dept	Oper	Operation Description	Part Numbers
8551	2	Carburize and Anneal	15408
8579	3	Lorco Vibrate (To Remove Deposit)	15408
8560	4	Mill Radius and Deburr	15408
8560	12	Polish to Remove Die Marks, Pits, Etc. on Stamping	15408
		To Bolt Assembly	15408

Operation Step Detail

Operation: 2

Step

Operation / Step Description

	Carburize and Anneal
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Operation Tool Detail

Operation: 2

Tool Number

Tooling Description

Std	Pit Type "Micro Carb" Furnace
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Operation Procedure Notes

Operation: 2

Description

PROCESS RECORD - HEAT TREAT SPECIFICATION

MATERIAL & SPECIFICATION: AISI C-1010

TEMPERATURE: 1700 Degrees F

MAXIMUM LOAD:

TIME: Carbuize @ .45C for 8 Hrs.

QUENCH: Cool Under Atmosphere to 300 Degrees F

REMARKS:

INSPECT FOR:

HEAT TREAT INSPECTION:

STANDARD PRACTICE NO:

HARDNESS LIMITS:

APPEARANCE OF PARTS:

Operation Step Detail

Operation: 3

Step

Operation / Step Description

Lorco Vibrate (To Remove Deposit)

Operation Tool Detail

Operation: 3

Tool Number

Tooling Description

#4 Chip - (#-1/2 AL Oxide)

Std Hand Magnetic Screen

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Operation Procedure Notes

Operation: 3

Description

Procedure:

1. With Drain Cover On Rinse Chips Until Clean and Drain Off All Water
- Chip #4 (3-1/2 AL Oxide) No. Parts per Load - 1000 Max.
2. Mix Compound (5 Mil.) and Measured Amount of Water (12 Qts.)
3. Start Vibrator and Run at 900 V.P.M.
4. Pour in Compound Mixture and Run - 5 Min. - to Mix Chip and Compound
5. Place Parts in Vibrator and Run at 900 V.P.M.
- 15 Min. Forward & 15 Min. Reverse
6. Use Hand Magnetic Screen to Separate Parts and Oil
7. Replace Chip in Vibrator

Operation Step Detail

Operation: 4

Step

Operation / Step Description

Mill Radius and Deburr

Operation Tool Detail

Operation: 4

Tool Number

Tooling Description

Std	Vise
C-85969	Vise Jaws
Std	File
C-37099	Form Cutter
B-85970	Disc (Use with Form Cutter C-37099)
	Gages:
D-35108	Dial Base Gage
Std	Bbl. Mics. - .140/.136 - (Set-Up Only)
A-83423	Snap Gage

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Operation Step Detail

Operation: 12

Step

Operation / Step Description

Polish to Remove Die Marks, Pits, Etc. on Stamping

Operation Tool Detail

Operation: 12

Tool Number

Tooling Description

Std	Polishing Jack
180 Grit	Belt
Std	1x14 Formed Rag Wheel - 150 Grit
Std	3" Ball Formed Rag Wheel - 150 Grit
Std	Rawhide Wheel

Operation Procedure Notes

Operation: 12

Description

Procedure:

1. Polish Part of Front and Back Edges, Also Edges of Ball
2. Polish Bolt Handle
3. Polish Ball
4. Polish Braze Locating Surface

NOTE: Polish per Temporary Sample

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