

22616-B

THIS DRAWING OR INFORMATION IS  
PROPRIETARY INFORMATION TO THE  
REMINGTON ARMS COMPANY, INC.

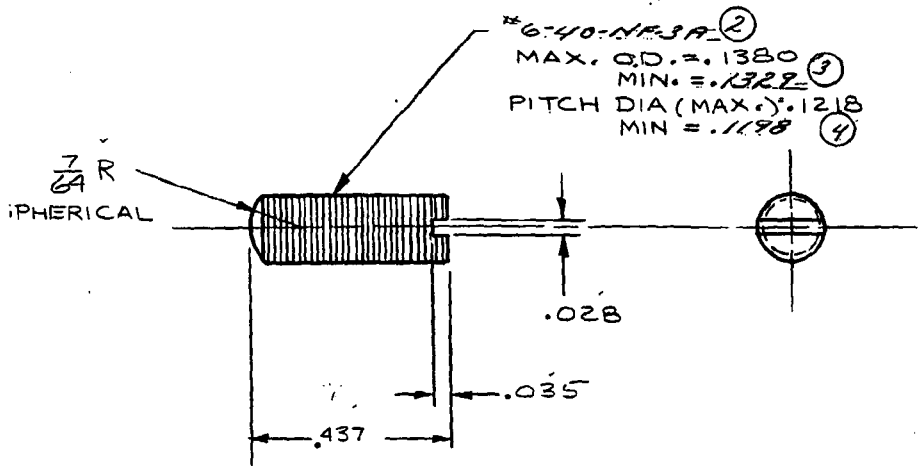
DO NOT SCALE THIS DRAWING: WORK TO FIGURES  
UNLESS OTHERWISE NOTED.  
TOLERANCES ON DECIMAL DIMENSIONS ARE:  
1 PLACE (.1) — TOLERANCE  $\pm .015$   
2 PLACE (.01) — TOLERANCE  $\pm .010$   
3 PLACE (.001) — TOLERANCE  $\pm .005$   
& ON FRACTIONAL DIMENSIONS  $\pm 1/64$   
& ON ANGULAR DIMENSIONS  $\pm 90^\circ - 30'$   
FINISHES ARE DESIGNATED BY ROOT MEAN  
SQUARE (R.M.S.) MICRO-INCH ROUGHNESS  
VALUES AND ARE THE MAXIMUM ROUGHNESS  
ACCEPTABLE, UNLESS OTHERWISE SPECIFIED,  
FINISH ROUGHNESS TO BE  $125$  OR BETTER.

RECOMMENDED MATERIAL AND HEAT TREAT

MATERIAL .08%20 CARB STEEL  
HEAT TREAT \_\_\_\_\_  
HARDNESS \_\_\_\_\_  
COLOR \_\_\_\_\_  
HEAT TREAT AND COLOR TO BE DONE BY  
REMINGTON P&J. 9/11/80

ALTERATIONS

| ALT. | WAS            | REF.  | BY  | DATE    |
|------|----------------|-------|-----|---------|
| 1    | ADD USE 7LWT   | 11667 | 628 | 12/1/82 |
| 2    | #6-34-NF-2     |       | 628 | 12/1/82 |
| 3    | .1380/.1382    |       | "   | "       |
| 4    | .1218/.1194    |       | "   | "       |
| 5    | ADD Use XP-100 | 12337 | 448 | 1/8/83  |
|      |                |       |     |         |
|      |                |       |     |         |



FOR FINISH DRAWING  
SEE B-91128

|                         |              |                         |
|-------------------------|--------------|-------------------------|
| 5                       | XP-100       | 3ena Block Stop Screw   |
| 1                       | 7LWT         | TRIGGER ENGAGEMENT SCR. |
| 40XB                    |              | TRIGGER ENGAGEMENT SCR. |
| 40XR                    |              |                         |
| 40XC                    |              |                         |
| 40XB                    |              |                         |
| 700                     |              | TRIGGER ENGAGEMENT SCR. |
| ALL                     |              |                         |
| MODEL                   | PART NO.     | PART USE                |
| DES. BY DATE            | ORN. BY DATE | CHK. BY DATE            |
| 134-15-80               | HAET         | 4-16-80                 |
|                         |              | 448 4/18/80             |
| TITLE                   |              |                         |
| SCREW BLANK             |              |                         |
| NUMBER                  | SCALE        | SUPersedes              |
| B-91922                 | 4X           | 11/83                   |
| REMINGTON ARMS CO. INC. |              |                         |
| ILION RESEARCH DIV.     |              |                         |

22616-8

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TOLERANCES ON DECIMAL DIMENSIONS ARE:  
1 PLACE (.1) — TOLERANCE  $\pm .015$   
2 PLACE (.01) — TOLERANCE  $\pm .010$   
3 PLACE (.001) — TOLERANCE  $\pm .008$   
4 ON FRACTIONAL DIMENSIONS  $\pm 1/64$   
5 ON ANGULAR DIMENSIONS  $\pm 30' - 30''$   
FINISHES ARE DESIGNATED BY ROOT MEAN  
SQUARE (R.M.S.) MICRO-INCH ROUGHNESS  
VALUES AND ARE THE MAXIMUM ROUGHNESS  
ACCEPTABLE, UNLESS OTHERWISE SPECIFIED.  
FINISH ROUGHNESS TO BE  $1.25$  OR BETTER.

RECOMMENDED MATERIAL AND HEAT TREAT

MATERIAL .08 / 20 CARB STEEL

HEAT TREAT

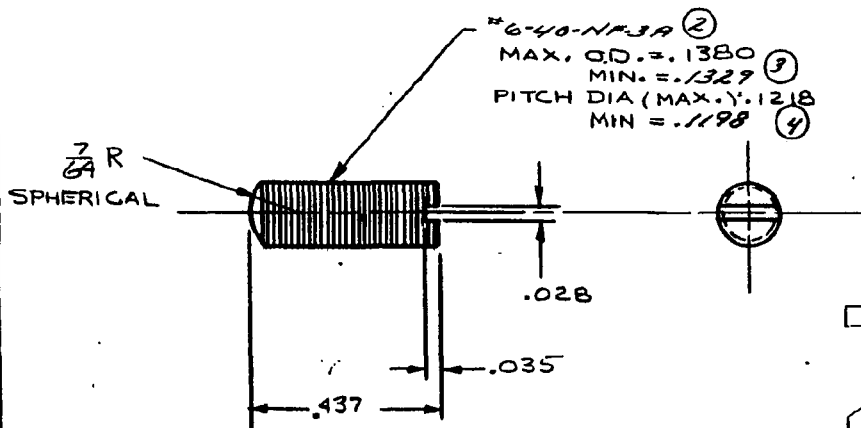
HARDNESS

COLOR

HEAT TREAT AND COLOR TO BE DONE BY  
REMINGTON P&J. 9/11/80

ALTERATIONS

| ALT. | WAS             | REF.  | BY     | DATE |
|------|-----------------|-------|--------|------|
| 1    | ADD USE 7LWT... | 11667 | 1/1/82 |      |
| 2    | #6-34-NF-.2     | 11667 | 1/1/82 |      |
| 3    | 1.1280 / 1.1284 |       | "      | "    |
| 4    | 1.1218 / 1.1294 |       | "      | "    |
| 5    | A00 Uge XP-100  | 12337 | 1/1/81 |      |



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FOR FINISH DRAWING  
SEE B-91128

|                         |                        |              |              |
|-------------------------|------------------------|--------------|--------------|
| ① XP-100                | Sema Block Stop Screw  |              |              |
| ① 7LWT                  | TRIGGER ENGAGEMENT SCR |              |              |
| 40XB                    | TRIGGER ENGAGEMENT-SCR |              |              |
| -BR                     |                        |              |              |
| 40XR                    | ↑                      |              |              |
| 40XC                    | ↓                      |              |              |
| 40XB                    |                        |              |              |
| 700                     | TRIGGER ENGAGEMENT-SCR |              |              |
| ALL                     |                        |              |              |
| MODEL                   | PART NO.               | PART USE     |              |
| DES. BY DATE            | BRN. BY DATE           | CHG. BY DATE | APP. BY DATE |
|                         | 54-15-80               | 4-16-80      | 4-18-80      |
| TITLE SCREW BLANK       |                        |              |              |
| NUMBER                  | SCALE                  | SUPERSEDED   | REFERENCE    |
| B-91922                 | 4X                     |              | 11667        |
| REMINGTON ARMS CO. INC. |                        |              |              |
| ILION RESEARCH DIV.     |                        |              |              |