

SEQUENCE OF OPERATIONS

OP. NO.	OPERATION	DEPT.	OPERATION	DEPT.
1.	CHECK FOR SAFETY CLEARANCE IN JUCK.			
2.	VERIFY CORRECT SEAR LIFT WITH DIAL GAGE.			
3.	PERFORM TRICK TEST (TO NEXT INSPECTION STATION)			
4.	CHECK FOR TIGHT BEDDINGS TO STARK AT REAR TANG.			
5.	STAMP "O" ON ALL GUNS PASSING PROCESS.			
6.	CONTINUE WITH STANDARD AKIP SERVICE PRACTICE.			
7.	PACK WITH NEW INSTRUCTION FOLDER.			

BARBER - PRESALE R 0130242

DATES AND REASONS FOR REVISIONS

DATES AND REASONS FOR REVISIONS

1/8/19 - NEW 2-8-79 REVISED

MODEL	PART NAME	PART NO.	GA. OR CAL.	PART NO.	PAGE	OF
XP-100	Arms Service Final Inspection				1	1
	(Recall only)					

ES AND REA. N° FOR REVISIONS 1/31/79 - NEW

CRITICAL INFORMATION

NOTE: ALL ARMS SERVICE STANDARD PRACTICES
TO BE FOLLOWED AS USUAL.

1. PICK PISTOL.
2. DO TRICK TEST

ELEMENTS FOR TRICK TEST

- I. COCK PISTOL
- II. MOVE SAFETY LEVER TO "ON SAFE" POSITION.

OPERATION DESCRIPTION

ARMS SERVICE RECALL
REPAIR PROCEDURE.
(FINAL INSPECTION)

QCC. No.
STD. HRS/G
STD. No.
EFF. DATE
PART No.
GA.

T NAME FINAL ASSEMBLY COOLANT

SET UP
TIME

MODEL No. XP-100

OPER. No. 3

MACH. HRS

DEPT. No.

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OF

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PROCESS RECORDS ASSEMBLY SHEET

YES AND READ FOR REVISIONS

1/21/79 - NEW

BARBER - PRESALE R 0130244

DESCRIPTIVE INFORMATION

EQUIPMENT - TOOLS & GAGES

ELEMENTS FOR TRICK TEST CONT.

II CONT.

- THERE MUST BE NO BIND.
- THERE MUST BE A GOOD SHARP SINGLE DETENT.
- IN THE "ON SAFE" POSITION, THE SAFETY MUST HAVE AN OBSERVABLE "SPRING BACK", FROM THE FALLEST REARWARD AND FORWARD POSITION.

III. PULL TRIGGER

- THERE MUST BE NO CLICK OR CATCH IN PULL.
- FIRING PIN MUST NOT FALL.

OPERATION DESCRIPTION

ARMS SERVICE RECALL
REPAIR PROCEDURE
(FINAL INSPECTION)

QCC. No.

STD. HRS/C

STD. No.

EFF. DATE

PART No.

GA.

NT NAME FINAL ASSEMBLY

COOLANT

SET UP
TIME

MACH. HRS.

MODEL No. XP-100

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OPER. No.

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PROCESS RECORDS ASSEMBLY SHEETS

TESTS AND REAS

FOR REVISIONS

1/31/79 - NEW

DESCRIPTIVE INFORMATION

IV RELEASE TRIGGER SLOWLY.

- TRIGGER MUST MOVE TO FULL FORWARD POSITION WHEN RELEASED.

V MOVE SAFETY LEVER TO "OFF SAFE" POSITION.

- FIRING PIN MUST NOT FALL.

VI RECOCK PISTOL.

VII MOVE SAFETY LEVER FROM "OFF SAFE" POSITION TO THE FORWARD MOST NULL LOCATION.

(TWO FINGERS MAY BE NECESSARY TO POSITION SAFETY)

EQUIPMENT - TOOLS & GAGES

OPERATION DESCRIPTION

OCC. No.

STD. HRS/C

STD. No.

EFF. DATE

ARMS SERVICE RECALL
REPAIR PROCEDURE
(FINAL INSPECTION)

PART No.

GA.

RT NAME FINAL ASSEMBLY

COOLANT

SET UP
TIME

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OPER. No. 3

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DEPT. No.

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BARBER - PRESALE R 0130245

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

BARBER - PRESALE R 0130245
R2531233

FOR REVISIONS

1/31/79 - NEW

CRPTIVE INFORMATION	TRICK TEST CONT.
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EQUIPMENT—TOOLS & GADGETS

* NOTE: FORWARD MOST NULL LOCATION -

IS THAT "JUST STABLE" PLACE, BETWEEN
"ON" AND "OFF" SAFE, - CLOSEST TO
"OFF SAFE", - WHERE THE SAFETY
LEVER WILL NOT SPRING FORWARD TO
THE "OFF SAFE" POSITION WHEN
RELEASED.

WILL PULL TRIGGER HARD AND UPWARD.

* THERE MUST BE NO CLICK OR
DASH IN FULL.

[illegible]

GET UP

COOLANT:

NAME EVAN ASSMUND

MODEL No. XP-100

OPER. NO.

MACH. HRS.

DEPT. No.

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of

ITEMS AND REVISIONS FOR REVISIONS

1/31/79 - NEW

DESCRIPTIVE INFORMATION

EQUIPMENT - TOOLS & GAGES

TRICK TEST CONT.

IV. RELEASE TRIGGER SLOWLY.

- TRIGGER MUST NOT AND MUST RETURN TO ^{FW} FORWARD POSITION WHEN RELEASED.
- FIRING PIN MUST NOT FALL.

X. PUSH SAFETY LEVER TO 'OFF SAFE' POSITION.

- FIRING PIN MUST NOT FALL.
- SAFETY LEVER MUST SPRING TO 'OFF SAFE' POSITION BY ITSELF WHEN PUSHED FROM THE NULL LOCATION

OPERATION DESCRIPTION

OCC. No.

STD. HRS/C

STD. No.

EFF. DATE

ARMS SERVICE RECALL
REPAIR PROCEDURE
(FINAL INSPECTION)

PART No.

GA.

ART NAME FINAL ASSEMBLY

COOLANT

SET UP
TIMEMODEL No. XP-100OPER. No. 3

PE

MACH. HRS

DEPT. No.

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PROCESS RECORDS ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 1/31/79 - NEW

DESCRIPTIVE INFORMATION

EQUIPMENT - TOOLS & GAGES

TRICK TEST CONT.

X. CONT.

- IN THE "OFF SAFE" POSITION, THE SAFETY MUST HAVE AN OBSERVABLE "SPRING BACK," FROM THE FULLEST FORWARD AND REARWARD POSITION.

XI. PULL TRIGGER

- FIRING PIN MUST FALL

XII OPEN ACTION AND CLOSE BOLT FIRMLY TO RE-COCK.

- FIRING PIN MUST NOT FALL.

XIII REPEAT STEPS 7 THRU 12.

OPERATION DESCRIPTION	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
ARMS SERVICE RECALL REPAIR PROCEDURE (FINAL INSPECTION)							
	PART No.						
	GA.						

ART NAME FINAL ASSEMBLY COOLANT _____ SET UP TIME _____ MODEL No. XP-100 OPER. No. 3
MACH. HRS. _____ DEPT. No. _____ PAGE 6 OF 9

BARBER - PRESALE R 0130248

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

BARBER - PRESALE R 0130248
R2531236

TES AND RE. FOR REVISIONS

1/31/79 - NEW

SCRIPTIVE INFORMATION

EQUIPMENT - TOOLS & GAGES

TRUCK TEST CONT.

FOR THE THIRD AND LAST TRIAL -

XIV MOVE SAFETY TO "ON SAFE" POSITION.

XV FROM THE "ON SAFE" POSITION, MOVE
THE SAFETY LEVER TO THE FORWARD
MOST NULL LOCATION (PREVIOUSLY DEFINED).

XVI PULL TRIGGER HARD AND UPWARD.

XVII RELEASE TRIGGER SLOWLY.

• THERE MUST BE NO CLICK OR CATCH IN PULL

OPERATION DESCRIPTION

OCC. No.

STD. HRS/C

STD. No.

EFF. DATE

PART No.

GA.

ARMS SERVICE RECALL
REPAIR PROCEDURE
(FINAL INSPECTION)RT NAME FINAL ASSEMBLY COOLANTSET UP
TIMEMODEL No. XP-100OPER. No. 3

MACH. HRS.

DEPT. No.

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OF

FOR REVISIONS

1/31/79 - ALEN

BARBER - PRESALE R 0130250

SCRIPTIVE INFORMATION

EQUIPMENT - TOOLS & GAGES

1. RICK TEST CONF.

XVII CONF.

- TRIGGER MUST HIT AND MUST RETURN TO ^{FALL} FORWARD POSITION WHEN RELEASED.
- FIRING PIN MUST NOT FALL.

XVIII PUSH SAFETY LEVER TO "OFF SAFE" POSITION.

- FIRING PIN MUST NOT FALL.
- SAFETY MUST SPRING TO "OFF SAFE" POSITION BY ITSELF WHEN PUSHED FROM THE NULL LOCATION.
- IN THE "OFF SAFE" POSITION, THE SAFETY LEVER MUST HAVE AN OBSERVABLE

OPERATION DESCRIPTION

OCC. No.

STD. HRS/G

STD. No.

EFF. DATE

ARMS SERVICE RECALL
REPAIR PROCEDURE
(FINAL INSPECTION)

PART No.

GA.

RT NAME FINAL ASSEMBLY

SET UP

TIME

MODEL No. XP-100

OPER. No. 3

MACH. HRS.

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ES AND REASONS FOR REVISIONS

1/31/79-NEN

CRITICAL INFORMATION

EQUIPMENT - TOOLS & GAGES

TRUCK TEST CONT.

WILL CONT.

- SPENDING BACK, FROM THE FULL EST FORWARDED AND REARWARD POSITION.

XIV PULL TRIGGER

- FIREM AN MUST FALL.

XV OPEN ACTION AND CLOSE GAT FIRMLY TO RE-COCK.

- FIRING PW MUST NOT FALL.

TRICK TEST COMPLETE.

OPERATION DESCRIPTION

OCC. No.

STD. HRS/G

STD. No.

EFF. DATE

PART No.

GA.

ARMS SERVICE RECALL
REPAIR PROCEDURE
(FINAL INSPECTION)

NAME FINAL ASSEMBLY

COOLANT

SET UP
TIME

MODEL No. XP-100

OPER. No.

MACH. HRS.

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PROCESS RECORDS ASSEMBLY SHEETS

REASON FOR REVISIONS 1/31/79 - NEW

DESCRIPTIVE INFORMATION

NOTE: ALL ADDITIONAL ARMS SERVICE STANDARD PRACTICES TO BE FOLLOWED AS USUAL.

1. PICK PISTOL.
2. DO TRICK TEST 100% - PERMANENTLY RECORD RESULTS.

ELEMENTS FOR TRICK TEST

- I. COCK PISTOL
- II MOVE SAFETY LEVER TO "ON SAFE" POSITION.

EQUIPMENT - TOOLS & GAGES

OPERATION DESCRIPTION	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
ARMS SERVICE RECALL REPAIR PROCEDURE.							
	PART No.						
	GA.						

T NAME FINAL ASSEMBLY COOLANT _____ SET UP TIME _____ MODEL No. XP-100 OPER. No. _____
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CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

BARBER - PRESALE R 0130252
R2531240

BARBER - PRESALE R 0130252

PROCESS RECORDS ASSEMBLY SHEETS

TESTS AND REAS

FOR REVISIONS

1/31/79 - NEW

DESCRIPTIVE INFORMATION

EQUIPMENT - TOOLS & GAGES

ELEMENTS FOR TRICK TEST CONT.

II CONT.

- THERE MUST BE NO BIND.
- THERE MUST BE A GOOD SHARP SINGLE DETENT.
- IN THE "ON SAFE" POSITION, THE SAFETY MUST HAVE AN OBSERVABLE "SPRINGS BACK", FROM THE FULLEST REARWARD AND FORWARD POSITION.

III. PULL TRIGGER

- THERE MUST BE NO CLICK OR CATCH IN PULL.
- FIRING PIN MUST NOT FALL.

OPERATION DESCRIPTION	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
ARMS SERVICE RECALL REPAIR PROCEDURE							
	PART No.						
	GA.						

RT NAME FINAL ASSEMBLY COOLANT _____ SET UP TIME _____ MODEL No. XP-100 OPER. No. _____
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BARBER - PRESALE R 0130253

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER

KINZER V. REMINGTON

BARBER - PRESALE R 0130253
R2531241

PROCESS RECORDS ASSEMBLY SHEETS

YES AND REAS

FOR REVISIONS

1/31/79 - NEW

SCRIPTIVE INFORMATION

EQUIPMENT - TOOLS & GAGES

IV RELEASE TRIGGER SLOWLY.

- TRIGGER MUST MOVE TO FULL FORWARD POSITION WHEN RELEASED.

V MOVE SAFETY LEVER TO "OFF SAFE" POSITION.

- FIRING PIN MUST NOT FALL.

VI RE-COCK PISTOL.VII MOVE SAFETY LEVER FROM "OFF SAFE" POSITION TO THE FORWARD MOST NULL LOCATION.

(TWO FINGERS MAY BE NECESSARY TO POSITION SAFETY)

OPERATION DESCRIPTION	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
ARMS SERVICE RECALL REPAIR PROCEDURE							
	PART No.						
	GA.						

RI NAME FINAL ASSEMBLY

COOLANT

SET UP
TIMEMODEL No. XP-100

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MACH. HRS.

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BARBER - PRESALE R 0130254

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER

KINZER V. REMINGTON

BARBER - PRESALE R 0130254
R2531242

PROCESS RECORDS ASSEMBLY SHEETS

ES AND REASO

FOR REVISIONS

1/31/79 - NEW

SCRIPTIVE INFORMATION

TRICK TEST CONF.

* NOTE: FORWARD MOST NULL LOCATION -

IS THAT "JUST STABLE" PLACE, BETWEEN
"ON" AND "OFF" SAFE, - CLOSEST TO
"OFF SAFE", - WHERE THE SAFETY
LEVER WILL NOT SPRING FORWARD TO
THE "OFF SAFE" POSITION WHEN
RELEASED.

PULL TRIGGER HARD AND UPWARD.

- THERE MUST BE NO CLICK OR
CATCH IN PULL.

EQUIPMENT - TOOLS & GAGES

OPERATION DESCRIPTION	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
ARMS SERVICE REGAL REPAIR PROCEDURE							
	PART No.						
	GA.						

IT NAME FINAL ASSEMBLY COOLANT _____ SET UP TIME _____ MODEL No. XP-100 OPER. No. _____
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MACHINE

BARBER - PRESALE R 0130255

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER

KINZER V. REMINGTON

BARBER - PRESALE R 0130255
R2531243

PROCESS RECORDS ASSEMBLY SHEETS

TES AND REASC

FOR REVISIONS

1/31/79 - NEW-

SCRIPTIVE INFORMATION

EQUIPMENT - TOOLS & GAGES

TRICK TEST CONT.

IV. RELEASE TRIGGER SLOWLY.

- TRIGGER MUST NOT BIND AND MUST RETURN TO ^{FULL} FORWARD POSITION WHEN RELEASED.
- FIRING PIN MUST NOT FALL.

X. PUSH SAFETY LEVER TO "OFF SAFE" POSITION.

- FIRING PIN MUST NOT FALL.
- SAFETY LEVER MUST SPRING TO "OFF SAFE" POSITION BY ITSELF WHEN PUSHED FROM THE NULL LOCATION

OPERATION DESCRIPTION	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
ARMS SERVICE RECALL REPAIR PROCEDURE							
	PART No.						
	GA.						

RT NAME FINAL ASSEMBLY

COOLANT

SET UP
TIME

MODEL No. XP-100

OPER. No.

FE

MACH. HRS.

DEPT. No.

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MACHINE

BARBER - PRESALE R 0130256

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER

KINZER V. REMINGTON

BARBER - PRESALE R 0130256
R2531244

PROCESS RECORDS ASSEMBLY SHEETS

TEST AND REAS

FOR REVISIONS

1/31/79 - NEW

BARBER - PRESALE R 0130257

SCRIPTIVE INFORMATION

TRICK TEST CONT.

X. CONT.

- IN THE "OFF SAFE" POSITION, THE SAFETY MUST HAVE AN OBSERVABLE "SPRING BACK," FROM THE FULLEST FORWARD AND REARWARD POSITION.

XI. DULL TRIGGER.

- FIRING PIN MUST FALL.

XII. OPEN ACTION AND CLOSE BOLT FIRING TO RE-COCK.

- FIRING PIN MUST NOT FALL.

XIII. REPEAT STEPS 7 thru 12.

EQUIPMENT - TOOLS & GAGES

OPERATION DESCRIPTION	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
ARMS SERVICE RECALL REPAIR PROCEDURE							
	PART No.						
	QA.						

HT NAME FINAL ASSEMBLY COOLANT _____ SET UP TIME _____ MODEL No. XP-100 OPER. No. _____
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MACHINE

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER

BARBER - PRESALE R 0130257
K2531245
KINZER V. REMINGTON

PROCESS RECORDS & ASSEMBLY SHEETS

BARBER - PRESALE R 0130258

ITEMS AND REAS FOR REVISIONS

1/31/79 - NEW

DESCRIPTIVE INFORMATION

EQUIPMENT - TOOLS & GAGES

TRUCK TEST CONT.

FOR THE THIRD AND LAST TRIAL -

XI MOVE SAFETY TO "ON SAFE" POSITION.

XII FROM THE "ON SAFE" POSITION, MOVE

THE SAFETY LEVER TO THE FORWARD

MOST NULL LOCATION (PREVIOUSLY DEFINED).

XIII PULL TRIGGER HARD AND UPWARD.

XIV RELEASE TRIGGER SLOWLY.

• THERE MUST BE NO CLICK OR CATCH IN PULL.

OPERATION DESCRIPTION

OCC. No.

STD. HRS/C

STD. No.

EFF. DATE

ARM'S SERVICE RECALL
REPAIR PROCEDURE

PART No.

GA.

ART NAME FINAL ASSEMBLY

COOLANT

SET UP
TIME

MODEL No. XP-100

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1/PE

MACH. HRS.

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PROCESS RECORDS ASSEMBLY SHEETS

TES AND REAS

FOR REVISIONS

1/21/79 - ALEN

BARBER - PRESALE R 0130259

SHIFTIVE INFORMATION

EQUIPMENT - TOOLS & GAGES

TRICK TEST CONF.

TRICK CONF.

- TRIGGER MUST HIT END AND MUST RETURN TO FORWARD POSITION WHEN RELEASED.
- FIRING PIN MUST NOT FALL.

TRICK PUSH SAFETY LEVER TO "OFF SAFE" POSITION.

- FIRING PIN MUST NOT FALL.
- SAFETY MUST SPRING TO "OFF SAFE" POSITION BY ITSELF WHEN PUSHED FROM THE NULL LOCATION.
- IN THE "OFF SAFE" POSITION, THE SAFETY LEVER MUST HAVE AN OBSERVABLE

OPERATION DESCRIPTION

ARMS SERVICE RECALL
REPAIR PROCEDURE

OCC. No.

STD. HRS/C

STD. No.

EFF. DATE

PART No.

GA.

RT NAME FINAL ASSEMBLY COOLANT

SET UP
TIME

MODEL No. XP-100

OPER. No.

PE MACH. HRS.

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PROCESS RECORDS ASSEMBLY SHEETS

ES AND REASO

FOR REVISIONS

1/31/79-NEW

SCRIPTIVE INFORMATION

EQUIPMENT-TOOLS & GAGES

TRICK TEST CONT.

XIII CONT.

- "SPRINGS BACK," FROM THE FULLEST FORWARD AND REARWARD POSITION.

XIV PULL TRIGGER

- FIRING PIN MUST FALL.

XV OPEN ACTION AND CLOSE BOLT FIRMLY TO RE-COCK.

- FIRING PIN MUST NOT FALL.

TRICK TEST COMPLETE.

OPERATION DESCRIPTION	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
ARMS SERVICE RECALL REPAIR PROCEDURE							
	PART No.						
	QA.						

IT NAME FINAL ASSEMBLY COOLANT _____ SET UP TIME _____ MODEL No. XP-100 OPER. No. _____
 E _____ MACH. HRS. _____ DEPT. No. _____ PAGE 9 OF 24

BARBER - PRESALE R 0130260

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER

KINZER V. REMINGTON

BARBER - PRESALE R 0130260
R2531248

PROCESS RECORDS ASSEMBLY SHEETS

ES AND REASO FOR REVISIONS 1/31/79 - NEW

SCRIPTIVE INFORMATION

3. REMOVE BOLT ASSEMBLY FROM GUN.
4. REMOVE STOCK ASSEMBLY FROM ACTION.
5. REMOVE: SAFETY SWAP WASHER
SAFETY DETENT SPRING
SAFETY DETENT BALL
SAFETY PILOT PIN
SAFETY ASSEMBLY
6. DRIVE OUT THE TWO (2) SEAR PINS AT
REAR OF RECEIVER TANG.
7. DROP SEAR HOUSING DOWN FROM RECEIVER SLOT.

EQUIPMENT - TOOLS & GAGES

OPERATION DESCRIPTION	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
CUSTOMER SERVICE RECALL REPAIR PROCEDURE.							
	PART No.						
	GA.						

IT NAME FINAL ASSEMBLY COOLANT SET UP TIME MODEL No. XP-100 OPER. No.
 E MACH. HRS. DEPT. No. PAGE 10 OF 24

BARBER - PRESALE R 0130261

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

BARBER - PRESALE R 0130261
R2531249

PROCESS RECORDS ASSEMBLY SHEETS

ES AND REASO

FOR REVISIONS

1/31/79 - NEW

CRIPITIVE INFORMATION

8. DRIVE OUT TRIGGER PIN FROM TRIGGER HOUSING ASSEMBLY AND REMOVE SEAR HOUSING ASSEMBLY.
9. PUT REMOVED SEAR HOUSING ASSEMBLY INTO LABELED CONTAINER FOR FURTHER DISPENSATION.
10. PICK NEW SEAR HOUSING ASSEMBLY.
11. POSITION SEAR HOUSING ASSEMBLY INTO RECEIVER.
12. PICK SEAR PIN AND START, CHAMFERED END FIRST. DRIVE REAR PIN FIRST,

EQUIPMENT - TOOLS & GAGES

OPERATION DESCRIPTION	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
ARMS SERVICE RECALL REPAIR PROCEDURE							
	PART No.						
	GA.						

IT NAME FINAL ASSEMBLY COOLANT _____ SET UP TIME _____ MODEL No. XP-100 OPER. No. _____
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MACHINE

BARBER - PRESALE R 0130262

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

BARBER - PRESALE R 0130262
K2531250

PROCESS RECORDS ASSEMBLY SHEETS

BARBER - PRESALE R 0130263

IES AND REAS' FOR REVISIONS

1/31/79 - NEW

SCRIPTIVE INFORMATION

EQUIPMENT - TOOLS & GAGES

12. CONT.

TO JUST ABOVE FLUSH WITH INSIDE OF
BOLT STOP SLOT. (TO CLEAR SAFETY ASSEMBLY
ON OPPOSITE SIDE).

DRIVE FRONT PIN SLIGHTLY BELOW FLUSH
WITH BOLT STOP SLOT.

• BOLT STOP MUST BE FREE TO ROTATE.

13. STAKE RECEIVER BELOW BOTH PINS.

14. INSERT TRIGGER INTO TRIGGER HOUSING AND
ALIGN HOLES.

15. PICK TRIGGER PIN.

OPERATION DESCRIPTION

OCC. No.

STD. HRS/C

STD. No.

EFF. DATE

PART No.

GA.

ARM SERVICE RECALL
REPAIR PROCEDURE

RT NAME FINAL ASSEMBLY COOLANT

SET UP
TIME

MACH. HRS.

MODEL No. XP-100

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MACHINE

PROCESS RECORDS ASSEMBLY SHEETS

TES AND REAS/ FOR REVISIONS 1/31/79 - NEW

SCRIPTIVE INFORMATION

16. POSITION AND DRIVE PIN THROUGH TRIGGER SO THAT PIN IS FLUSH WITH OUTSIDE OF TRIGGER HOUSING.

- TRIGGER MUST NOT BIND IN HOUSING - MUST RETURN FULLY FORWARD.

17. STAKE BOTH SIDES OF TRIGGER HOUSING. TO RETAIN PIN.

- PULL TRIGGER AND RELEASE SLOWLY.

- TRIGGER MUST NOT BIND IN HOUSING - MUST RETURN FULLY FORWARD.

18. INSERT BOLT ASSEMBLY - COCK ACTION.

19. ADJUST SEAR SAFETY CAIK - SEAR BLOCK ENGAGEMENT.

EQUIPMENT - TOOLS & GAGES

OPERATION DESCRIPTION	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
ARMS SERVICE RECALL REPAIR PROCEDURE							
	PART No.						
	QA.						

RT NAME FINAL ASSEMBLY COOLANT _____ SET UP TIME _____ MODEL No. XP-100 OPER. No. _____

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MACHINE

BARBER - PRESALE R 0130264

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

BARBER - PRESALE R 0130264
K2531252

IES AND REA. N° FOR REVISIONS

1/31/79 - NEW

SCRIPTIVE INFORMATION

EQUIPMENT - TOOLS & GAGES

19. CONT.

- TURN TRIGGER ADJUSTING SCREW UNTIL FEELS AN "JUST" FALLS.
 - BACK OUT TRIGGER ADJUSTING SCREW 1/4 TURNS.
 - THIS PRODUCES .020 ENGAGEMENT.
 - VISUALLY CHECK FOR CORRECT ENGAGEMENT.
20. ADJUST SEAR BLOCK OVERTRAVEL.
- RE-COCK ACTION.
 - TURN DEAR BLOCK STOP SCREW CLOCKWISE UNTIL GUN WILL NOT FIRE.

OPERATION DESCRIPTION

OCC. No.

STD. HRS/C

STD. No.

EFF. DATE

ARMS SERVICE RECALL
REPAIR PROCEDURE

PART No.

GA.

IT NAME FINAL ASSEMBLY

COOLANT

SET UP TIME

MODEL No. XP-100

OPER. No.

E

MACH. HRS.

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PROCESS RECORDS ASSEMBLY SHEETS

IS AND REASON

OR REVISIONS

1/31/79 - NEW

SCRIPTIVE INFORMATION

20. CONT.

- HOLD TRIGGER BACK AND TURN SEAR BLOCK STOP SCREW COUNTER-CLOCKWISE UNTIL FIRING PIN "JUST" FALLS.
- TURN SCREW ANOTHER 1/16 OF A TURN.
- THIS PRODUCES APPROX. .005 OVERTRAVEL BETWEEN SEAR SAFETY CAM AND SEAR BLOCK AFTER DISENGAGEMENT.

EQUIPMENT - TOOLS & GAGES

OPERATION DESCRIPTION	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
ARMS SERVICE REGAL REPAIR PROCEDURE.							
	PART No.						
	GA.						

T NAME FULL ASSEMBLY COOLANT _____ SET UP TIME _____ MODEL No. XP-100 OPER. No. _____
MACH. HRS. _____ DEPT. No. _____ PAGE 15 OF 24
MACHINE _____

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER

BARBER - PRESALE R 0130266
KINZER V. REMINGTON
R2531254

BARBER - PRESALE R 0130266

PROCESS RECORDS ASSEMBLY SHEETS

IES AND REAS

FOR REVISIONS

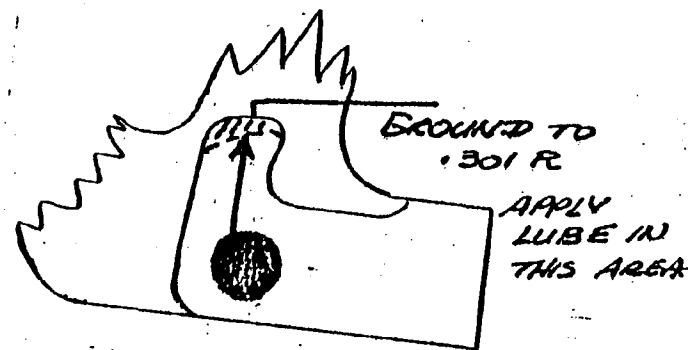
1/31/79 NEW

SCRIPTIVE INFORMATION

21. SEAL TRIGGER ADJUSTING SCREW
AND SEAR BLOCK STOP SCREW.
22. LUBRICATE SEAR HOUSING AT DETENT INTERSECTIONS,
AND REASSEMBLE: (ALL NEW PARTS)
SAFETY ASSEMBLY - LUBRICATE CAM SURFACE
SAFETY PIVOT PIN
SAFETY DETENT BALL
SAFETY DETENT SPRING
SAFETY SNAP WASHER - ROUNDED SIDE TO BE
TOWARD SAFETY
DETENT SPRING
• SAFETY SNAP WASHER MUST BE

EQUIPMENT - TOOLS & GAGES

MOLYNKOTE TYPE 'C' OR 'BN' PASTE.



OPERATION DESCRIPTION	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
ARMS SERVICE RECALL REPAIR PROCEDURE							
	PART No.						
	GA.						

RT NAME FINAL ASSEMBLY COOLANT SET UP TIME MODEL No. XP-100 OPER. No.
 PE MACH. HRS. DEPT. No. PAGE 16 OF 24

BARBER - PRESALE R 0130267

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

BARBER - PRESALE R 0130267
R2531255

PROCESS RECORDS - ASSEMBLY SHEET

DATE AND REAS

FOR REVISIONS

1/24/79 - NEW

DESCRIPTIVE INFORMATION

EQUIPMENT - TOOLS & GAGES

22 CONT.

COMPLETELY CONTAINED WITHIN PIVOT
PIN GROOVE.

- THE RAISED END OF DIMPLE ON SAFETY
DETENT SPRINGS MUST BE AT THE
LEFT END OF THE OPENING AT THE
CLOSED END OF SAFETY SWAP WASHER.

23. FUNCTION CHECK SAFETY ASSEMBLY.

- SAFETY SHOULD SWAP FREELY FORWARD AND REVERSE
- THERE MUST BE GOOD SHARP DETENTS IN
BOTH POSITIONS.

24. TRY SHIM TEST.

OPERATION DESCRIPTION

ARMS SERVICE RECALL
REPAIR PROCEDURE

OCC. No.

STD. HRS/G

STD. No.

EFF. DATE

PART No.

QA.

ART NAME FINAL ASSEMBLY COOLANT

SET UP
TIME

MACH. HRS.

MODEL No.

XP-100

OPER. No.

TYPE

MACH. HRS.

DEPT. No.

PAGE

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OF

24

126 AND REAS

FOR REVISIONS

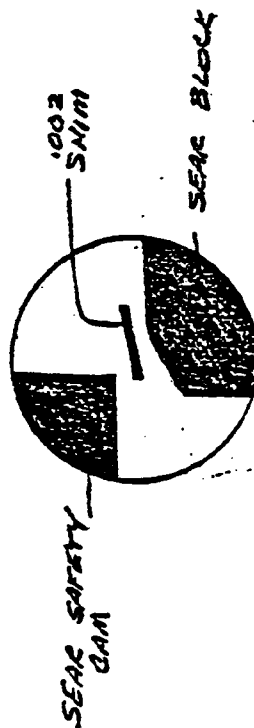
12/3/79-NEW

BARBER - PRESALE R 0130269

SCRIPTIVE INFORMATION

SHIM TEST

- I. PUT SAFETY LEVER TO "ON SAFE" POSITION.
- II. INSERT .002 SHIM FULLY INTO CHEN HOKE, LEFT SIDE OF SEAR HOUSING.
- SHIM MUST BE BETWEEN SEAR SAFETY CAM AND SEAR BLOCK.



EQUIPMENT - TOOLS & GAGES

.002 SHIM STOCK

NOTE: WORK, BURIED OR DAMAGED SHIM WILL BIND AND GIVE A FALSE READING. REPLACE SHIM FREQUENTLY. SHIM MUST BE NARROW ENOUGH TO PASS THRU CHEN HOKE IN SEAR HOUSING.

OPERATION DESCRIPTION

ARMS SERVICE RECALL
REPAIR PROCEDURE

QCC. No.
STD. HRS/C
STD. No.
EFF. DATE
PART No.
QA.

ART NAME FINAL ASSEMBLY

COOLANT

SET UP
TIMEMODEL No. XP-100

OPER. No.

TYPE

MACH. HRS.

DEPT. No.

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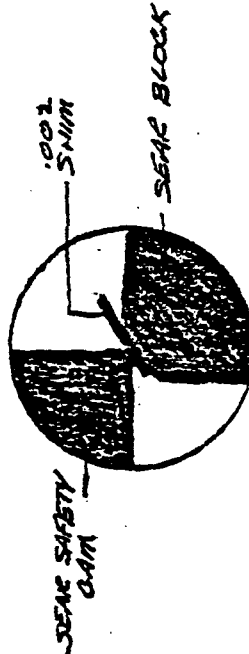
YES AND REASONS FOR REVISIONS 12/13/79 - NEW

DESCRIPTIVE INFORMATION

EQUIPMENT - TOOLS & GAGES

THE MOUSE SAFETY LEVER TO "OFF SAFE" POSITION.
LIGHTLY PULL ON SHIM WITH THUMB
AND FINGER:

- SHIM MUST REMAIN TRAPPED BETWEEN SEAR SAFETY CAM AND SEAR BLOCK.
- IF SHIM IS FREE - RETURN TO ELEMENT #2.



OPERATION DESCRIPTION

QCC. No.

STD. HRB/C

STD. No.

EFF. DATE

ARMS SERVICE RECALL
REPAIR PROCEDURE

PART No.
QA.

RT NAME FINAL ASSEMBLY

COOLANT

SET UP
TIME

MODEL No. XP-100

OPER. No.

PE

MACH. HRS.

DEPT. No.

PAGE

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FOR REVISIONS 12/3/79 - NEW

CRYPTIVE INFORMATION

1. MOVE SAFETY LEVER FROM "OFF SAFE" POSITION TOWARD "ON SAFE" POSITION, TO LOCATE AND STOP SAFETY LEVER AT THE FORWARD MOST NULL LOCATION.*

- IF NULL LOCATION IS PASSED (TOO FAR TOWARD "ON SAFE"), THEN RETURN TO "OFF SAFE" POSITION, AND APPROACH NULL LOCATION FROM THE "OFF SAFE" POSITION AGAIN.

* FORWARD MOST NULL LOCATION - IS THAT "JUST-STABLE" PLACE BETWEEN "ON" AND "OFF" SAFE - CLOSEST TO "OFF SAFE" - WHERE THE SAFETY LEVER WILL NOT SPRING FORWARD TO THE "OFF SAFE" POSITION WHEN RELEASED.

OPERATION DESCRIPTION	OCC. No.																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																										</
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IT NAME FNAC ASSEMBLY COOLANT

SET UP TIME

MODEL No. 1A-100

OPER. No.

MACH. HRS

DEPT. No.

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CRITICAL INFORMATION

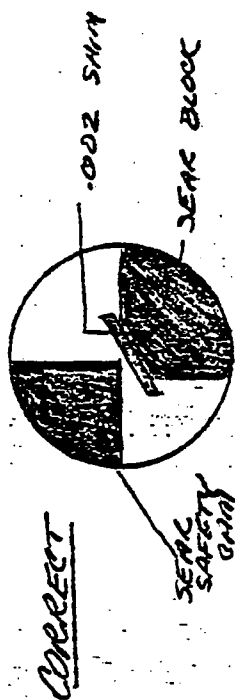
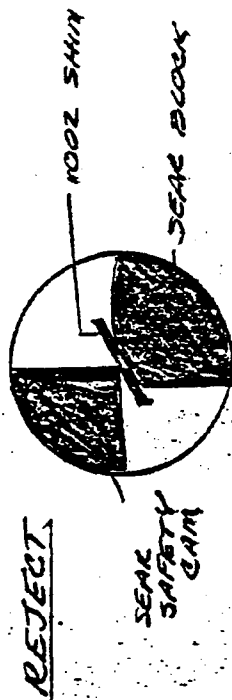
PULL WITH THE SAFETY LEVER IN THE FORWARD MOST RAIL LOCATION, AND PULL ON SHIM WITH THUMB AND FINGER.

- ◆ IF SHIM BINDS OR HANGS UP
BETWEEN SEAR SAFETY CAN AND
SEAR BLOCK -

REJECT AND REWORK.

REPLACE COMPLETE SEAR HOUSING ASSEMBLY
(ELEMENTS 4 & 5 ON)

- IF SKIN REMOVES FREELY
CLEARANCE IS CORRECT.

[illegible]

T NAME EDVAK ASSEMBLY

COOLANT-

८१

MODEL No.

XP-100

OPER. No.

МАШ. НАВ.

DEPT. NO.

PAGE:

10

NOTES AND REAS 1 FOR REVISIONS 1/31/79 - NEW

DESCRIPTIVE INFORMATION

EQUIPMENT - TOOLS & GAGES

25. TRY TRICK TEST (PREVIOUSLY DEFINED - PAGES #1 THRU #9.)

- IF ACTION FAILS TRICK TEST - REPAIR BY REPLACING COMPLETE SEAR HOUSING ASSEMBLY (ELEMENTS #3 ON)

26. PICK ORIGINAL STOCK ASSEMBLY

27. ROUTE STOCK OUT AT SAFETY CLEARANCE CUTS

- THERE SHOULD BE NO BURS AT ROUTED CUTS. - SCRAPE IF NECESSARY.
- CLEAN STOCK WITH COMPRESSED AIR TO REMOVE ANY NYLON BURS INSIDE STOCK.

OPERATION DESCRIPTION	QCC. No.								PART No.	GA.
	STD. HRS/C									
	STD. No.									
	EFF. DATE									
ARMS SERVICE RECALL REPAIR PROCEDURE.										

ART NAME FINAL ASSEMBLY COOLANT SET UP TIME 10-100 DEPT. No. 88 OF 24

MACH. HRS. 1.000000

PROCESS RECORDS ASSEMBLY SHEETS

ITEMS AND REAS

FOR REVISIONS

1/31/79 - NEW

SCRIPTIVE INFORMATION

28. RESTOCK ACTION.
29. CHECK FOR SAFETY CLEARANCE IN STOCK
 - SAFETY SHOULD SNAP FREELY FORWARD AND REARWARD WITH NO BIND.
30. CHECK FOR TRIGGER CLEARANCE IN TRIGGER GUARD.
 - TRIGGER MUST NOT TOUCH TRIGGER GUARD AT ANY POINT.
31. TRY TRICK TEST. (PREVIOUSLY DEFINED - PAGES #1 THRU #9)

EQUIPMENT - TOOLS & GAGES

OPERATION DESCRIPTION

OCC. No.

STD. HRS/C

STD. No.

EFF. DATE

ARMS SERVICE RECALL
REPAIR PROCEDURE

PART No.

GA.

RT NAME FINAL ASSEMBLY

COOLANT

SET UP
TIME

MODEL No.

OPER. No.

PE

MACH. HRS.

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BARBER - PRESALE R 0130274

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

BARBER - PRESALE R 0130274
R2531262

FOR REVISIONS

13179 - NEW

CRITICAL INFORMATION

EQUIPMENT - TOOLS & GAGES

31. CONTINUE WITH STANDARD PRACTICE.
33. SEND TO GALLERY FOR FUNCTION TESTING.

OPERATION DESCRIPTION

OCC. No.

STD. HRS/C

STD. No.

EFF. DATE

ARMS SERVICE RECALL
REPAIR PROCEDURE

PART No.

GA.

T NAME FINAL ASSEMBLY COOLANTSET UP
TIME

MODEL No.

OPER. No.

MACH. HRS

DEPT. No.

PAGE 24

OF 24

MACHINE

SEQUENCE OF OPERATIONS

[illegible]

BARBER - PRESALE R 0130276
P9531264

KINZER V. REMINGTON

PR2531264

SEQUENCE OPERATIONS

OP. No.	OPERATION	DEPT.	OP. No.	OPERATION	DEPT.
	FOR TRIGGER HOUSING ASSEMBLY DRAW THE PARTS SHOWN:				
	Trigger Housing Ass'y. 221 & 7MM BR				
	Trigger Housing				
	Trigger Housing Screw Front				
30	Coat threads of Trigger Housing Screw and install.	15			
	TO FINAL ASSEMBLY - CRIB #29				
DATES AND REASONS FOR REVISIONS			DATES AND REASONS FOR REVISIONS		
9/29/80 - New - RLJ - 279133					
MODEL XP-100		PART NAME	Trigger Housing Assembly		PAGE 1 OF 1
		GA. OR CAL.	221.7MM BR		
		PART No.	16876		

RD 6460

COMPONENTS		221	MMBR					
		PART NUMBERS						
Barrel Assembly Complete	31560	31561						
Firing Pin Assembly	25600	----						
Bolt Stop	15446	11767						
Bolt Stop Spring	15415	----						
Bolt Stop Pin	24484	----						
Forward Receiver Screw	15447	----						
Forward Rec. Scr. Washer	15485	----						
Rear Receiver Screw	15450	----						
Rear Rec. Scr. Washer	15484	----						
Rear Sight Assembly	26840	None						
Rear Sight Nut	15418	None						
Receiver Plug Screw	17034	----	221 (3)	MM (5)				
Rib	26785	None						
Rib Screw (2)	15417	None						
Sight Screw Washer (4)	16968	None						
Sight Screw (4)	15416	None						
Front Sight	15449	None						
Front Sight Ramp	None	91763						
Front Sight Ramp Screw	None	28505						
Safety Assembly	91496	----						
Safety Detent Ball	23222	----						
Safety Detent Spring	15432	----						
Safety Pivot Pin	17043	----						
Safety Snap Washer	17044	----						
Sear Housing Assembly	26790	----						
Sear Pin (2)	24476	----						
Stock Assembly	26805	91765						
Trigger Housing Assembly	16876	----						
Trigger Balance	15470	----						
Trigger Balance Pin	15471	----						
Trigger Balance Spring	15472	----						
Trigger Housing Screw	15474	----						
Trigger Pin	24483	----						
Rear Sight Wrench	15776	None						
REMARKS								
FINAL ASSEMBLY								

PROCESS RECORDS ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 9/29/80HP New - MRP - RLJ - 279162

DESCRIPTIVE INFORMATION

EQUIPMENT-TOOLS & GAGES

NOTE: Unless otherwise stated - All relative directions, (up, down, clockwise, etc.) are from shooter's point of view, with gun held in normal firing position.

- Action**
1. Pick Barreled ~~WFF/FF~~ and inspect:

- Good uniform black color
- No mars or scratches
- Proper roll marks
- Legible, uniform serial number
- Bore must be concentric to muzzle

OPERATION DESCRIPTION		OCC. No.					
Final Assembly	STD. HRS/C						
	STD. No.						
	EFF. DATE						
		* NOTE: For 7MM BR, IAMAC 925471, See Sheet 37 of this Operation					
PART No.	925470	925471*					
GA.	221	7MM BR					

PART NAME Final Pistol Assembly COOLANT _____ SET UP TIME _____ MODEL No. XP-100 OPER. No. 575
 TYPE _____ MACH. HRS. _____ DEPT. No. 15 PAGE 2 OF 37
 MACHINE _____

PROCESS RECORD ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 9/29/80 - New - MRP - BL01-2279162

DESCRIPTIVE INFORMATION

2. Clamp in Vise.
3. Assemble three (3) Receiver Plug Screws into Receiver.
 - Edge of screws must be flush to Receiver (925470, 221, Only)
4. Pick Bolt Stop Spring. Place one end of spring into detent in bottom of bolt stop slot.
5. Pick Bolt Stop and Inspect:
 - Black Color
 - Free of burrs

EQUIPMENT - TOOLS & GAGES

OPERATION DESCRIPTION

Final Assembly

OCC. No.

STD. HRS/C

STD. No.

EFF. DATE

PART NO.

GA.

PART NAME Final Pistol Assembly COOLANT _____ SET UP TIME _____ MODEL No. XP-100 OPER. No. 575

TYPE _____ MACH. HRS. _____ DEPT. No. 15 PAGE 3 OF 37

MACHINE _____

PROCESS RECORD ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 3/19/79 - Revised - WAW - 277724
 9/29/80 - Updated - MRP - 279162

DESCRIPTIVE INFORMATION

EQUIPMENT - TOOLS & GAGES

6. Insert Bolt Stop Into Receiver slot, fitting Bolt Stop Spring into slot in rear of Bolt Stop.
7. Pick Bolt Stop pin, Position and drive into Receiver from left to right.
- End of pin must be just above flush with Bolt Stop.
 - Opposite end of pin must not protrude into Sear Housing slot.

OPERATION DESCRIPTION

OCC. No.

STD. HRS/C

STD. No.

EFF. DATE

Final Assembly

PART No.

GA.

PART NAME Final Pistol Assembly

COOLANT

SET UP TIME

MODEL No. XP-100

OPER. No. 575

TYPE

MACH. HRS.

DEPT. No. 15

PAGE 4

OF 37

MACHINE

PROCESS RECORD. ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 3/19/79 - Revised - WAW - 277724

5/21/79 - Added file - WAW - 277931

9/29/80 - New - MRP - RLJ - 279162

DESCRIPTIVE INFORMATION

8. Push upward on rear end of Bolt Stop and release slowly;
- Bolt Stop must rotate freely and return fully,

File Receiver slot if necessary.

Repeat but release quickly under spring tension;

- Bolt Stop Spring must remain in place.

9. Pick Trigger Housing and inspect:

- Black color
- No burrs or damage to inside surfaces which could interfere with proper Trigger rotation.

If Trigger Housing is slightly closed in, spread with special holding plug, to align holes with Barrel Bracket holes.

EQUIPMENT - TOOLS & GAGES

OPERATION DESCRIPTION	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
Final Assembly							
	PART NO.						
	GA.						

PART NAME Final Pistol Assembly COOLANT _____ SET UP TIME _____ MODEL No. XP-100 OPER. No. 575
 TYPE _____ MACH. HRS. _____ DEPT. No. 15 PAGE 5 OF 37
 MACHINE _____

PROCESS RECORD ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 3/19/79 - Revised - WAW - 277724

5/21/79 - Added tool number - WAW - 277931

9/29/80 - Updated - MRP - RLJ - 279162

DESCRIPTIVE INFORMATION

10. Assemble Trigger Housing to Barrel Bracket with two (2) Trigger Housing Screws;

- Trigger Housing ears must be flush to bottom and both sides of Barrel Bracket.

Reject for serious mismatch.

EQUIPMENT - TOOLS & GAGES

Special Holding Plug or B-86362

OPERATION DESCRIPTION

Final Assembly

OCC. No.

STD. HRS/C

STD. No.

EFF. DATE

PART No.

GA.

PART NAME Final Pistol Assembly

COOLANT

SET UP
TIME

MODEL No. XP-100

OPER. No. 575

TYPE

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DATES AND REASONS FOR REVISIONS 3/19/79 - Revised - WAW - 277724
5/21/79 - Remove item 11 - transferred to oper. 103 - WAW - 277931
9/29/80 - Updated - MRP - RLJ - 279162

DESCRIPTIVE INFORMATION

~~AA// /A&A&N&M&E/A&G&C&t/A&M&P&S/I&B/S&C/I&Y/W/I&P/V&A&B&E&T/I&P&U&S/I&V&Y.~~

~~TATN ACCEP ADDI ATV THEN DATN OF IVIS SEAS THE~~
~~NATD THE COMPOUNDING~~

EQUIPMENT-TOOLS & GAGES

12. Pick Sear Housing Assembly and inspect :

- Swaged end of Trigger Link Pin must be flush or below right side surface of Link on Sear Housing end.
- Ears of Link must be straight.

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PROCESS RECORD ASSEMBLY SHEETS

DATE AND REASONS FOR REVISIONS 3/19/79 - Revised - WAW - 277724
 9/29/80 - Update - MRP - RLCJ - 279162

DESCRIPTIVE INFORMATION

EQUIPMENT - TOOLS & GAGES

12. Cont.
- Link and Sear Block Assembly must move freely in housing.
 - Trigger must rotate freely.
13. Insert Sear Housing into Receiver and align Sear Pin holes of Receiver and Housing.
14. Pick Sear Pin and start, chamfered end first. Drive rear pin first, left to right, to just above flush with inside surface of Bolt Stop Slot (To clear Safety Assembly on opposite side.)

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DATES AND REASONS FOR REVISIONS 3/19/79 - Revised - WAW - 277724
 9/29/80 - Update - MRP - RLJ - 279162

DESCRIPTIVE INFORMATION

EQUIPMENT - TOOLS & GAGES

Drive front pin, chamfered and flat, left to right,
 to slightly below flush with inside surface of Bolt Stop
 Slot. (To clear Bolt Stop),

15. Push upward on rear end of Bolt Stop and release
 slowly;

- Bolt Stop must rotate freely and return
 fully without bind.

OPERATION DESCRIPTION

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Form R. D. 6169

Karen B. D. 6461

PROCESS RECORDS ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 3/19/79 - Revised - WAW - 277724
 9/29/80 - Updated - MRP - KLCJ - 279162

DESCRIPTIVE INFORMATION

18. (Cont.)

Push forward on Trigger to verify Trigger has returned fully.

File and/or adjust to free Trigger if necessary.

19. Stake both sides of Trigger Housing to retain Trigger Pin.

20. Retighten Trigger Housing Screws.

21. Stake Barrel Bracket at Trigger Housing screw slots to prevent screws loosening.

EQUIPMENT - TOOLS & GAGES

Center Punch

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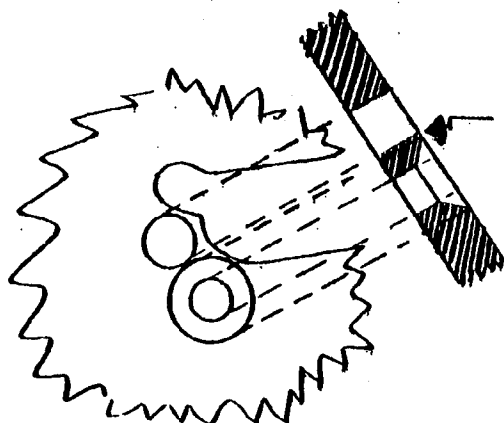
PROCESS RECORD ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 3/19/79 - Revised - WAW - 277724
 9729780 - Update - MRP - RLD - 279162

DESCRIPTIVE INFORMATION

22. Lubricate Sear Housing at detent holes intersection:

- Only a small amount of lubricant is required.



Lubricate this detent
intersection

EQUIPMENT - TOOLS & GAGES

Moly Kote Type 'GN' Paste

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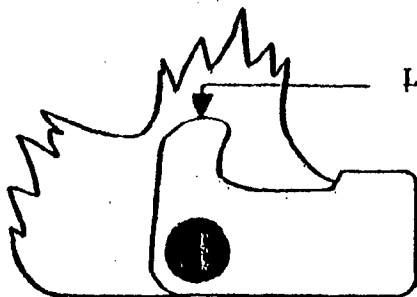
PROCESS RECORD - ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 3/19/79 - Revised - WAW - 277724
 9/29/80 - Update - MRP - HLG - 279162

DESCRIPTIVE INFORMATION

23. Lubricate cam surface of Safety Assembly:

- Only a small amount of lubricant is required.



Lubricate Cam Surface

EQUIPMENT - TOOLS & GAGES

Moly Kote Type "GN" Paste

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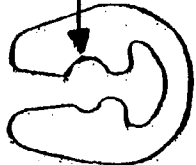
MACH. HRS.

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PROCESS RECORD ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 3/19/79 - Revised - WAW - 277724 5/21/79 - Add Pin Seating - WAW - 277931 9/29/80 - Update - MRP - 279162							
DESCRIPTIVE INFORMATION 24. Assemble: Safety Assembly Safety Detent Ball Safety Detent Spring - Visually check for correct size dimple Safety Pivot Pin - Seat pin head lightly against left side of Sear Housing, Safety Snap Washer - Side with deep notch (for Safety Pivot Pin) must be on top. • Safety Snap Washer <u>must</u> be completely contained within Pivot Pin groove.				EQUIPMENT - TOOLS & GAGES  Deep Notch <u>Must</u> be on top.			
Cont.							
OPERATION DESCRIPTION		OCC. No.					
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DATES AND REASONS FOR REVISIONS 3/19/79 - Revised - WAW - 277724
 9/29/80 - Update - MRP - RLS - 279162

DESCRIPTIVE INFORMATION

24. (Cont.)

- The raised end of dimple on Safety Detent Spring must be at the left of the opening, at the closed end of the Safety Snap Washer,



Dimple here

EQUIPMENT - TOOLS & GAGES

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PROCESS RECORD: ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 3/19/79 - Revised - WAW - 277724
 9/29/80 - Updated - MRP - RLJ - 279162

DESCRIPTIVE INFORMATION

25. Function check Safety Assembly components.

Push Safety Thumb Piece fully forward beyond detent position;

- Safety must spring return to detent position.

Push Safety Thumb Piece fully rearward beyond detent position;

- Safety must spring forward to detent position.

Move safety from "On Safe" to "Off Safe" position and back. Do this twice;

- Safety must spring forward into "Off Safe" position when pushed. Cont.

EQUIPMENT - TOOLS & GAGES

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DATES AND REASONS FOR REVISIONS 3/19/79 - Revised - WAW - 277724

5/21/79 - Correct part name - WAW - 277931

9/29/80 - Update - MRP - RLJ - 279162

DESCRIPTIVE INFORMATION

25. (Cont.)

- There must be no hang-up or hesitation between detent positions.
- The flat arm of the Safety Assembly must work freely. It must not bind on housing, Receiver slot, Link, Trigger Link Pin, or Bear Block Pin.

Adjust if necessary.

EQUIPMENT - TOOLS & GAGES

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DATE AND REASONS FOR REVISIONS 3/19/79 - Revised - WAW -277724
9/29/80 - Update - MRP - RLJ - 279162

DESCRIPTIVE INFORMATION

26. Pull Trigger several times and release slowly?
- Trigger must return freely and fully.
- Push forward on Trigger to verify Trigger has returned fully,

27. Stake left side of Receiver, below both Sear Pins, and Bolt Stop Pin.

EQUIPMENT - TOOLS & GAGES

Center Punch

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DATES AND REASONS FOR REVISIONS

3/19/79 - Revised - WAW - 277724

5/21/79 - Add lubrication element - WAW - 277931

9/29/80 - Update - MRP - RLJ - 279162

DESCRIPTIVE INFORMATION

28. Pick Bring Pin Assembly and inspect;

- Firing Pin point must not be marred,
- Bolt Plug must have good color and appearance. No marks or scratches.
- No rusty parts,
- No miscut or incorrect parts.

Lubricate Bolt Plug threads and Cocking Cam surface, before assembly into Bolt.

29. Assemble Firing Pin Assembly to Bolt and remove washer, so that Bolt Final Assembly is in fired position.

30. Check Bring Pin protrusion.

- 0.045 Min.
- 0.075 Max.

EQUIPMENT - TOOLS & GAGES

Molykote type "GN" paste

Protrusion Gage - #B-52089

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PROCESS RECORD: ASSEMBLY SHEETS

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BARBER - PRESALE R 0130297
R2531285

PROCESS RECORD ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 3/19/79 - Revised - WAW - 277724
 9/29/80 - Update - MHP - RLJ - 279162

DESCRIPTIVE INFORMATION

33. (Cont.)

Visually check for correct engagement.

34. Initially adjust Sear Block overtravel. Re-cock action.

Turn Sear Block Stop Screw in until Firing Pin will not fall when Trigger is pulled.

Hold Trigger back and turn Sear Block Stop Screw out slowly until Firing Pin "just" falls

EQUIPMENT - TOOLS & GAGES

Cont.

OPERATION DESCRIPTION

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DATES AND REASONS FOR REVISIONS

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9/29/80 - Update - MRP - RLJ - 279162

DESCRIPTIVE INFORMATION

34. (Cont.)

- Back out screw another 1/2 turn,

(This produces extra overtravel between Sear
Safety Cam and Sear Block after disengagement.)

35. Inspect for correct Sear Safety Cam - Sear Block
clearance with shim,

- Put safety lever to "On Safe" position.

EQUIPMENT - TOOLS & GAGES

.002 tempered steel shim stock

Note: Worn, burred or damaged shim,
will bind.

Replace shim frequently. Shim must
be narrow enough to pass thru view
hole in Sear Housing.

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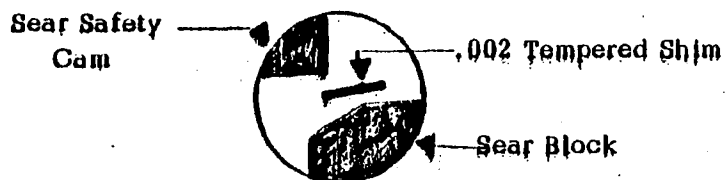
DATES AND REASONS FOR REVISIONS 3/19/79 - Revised - WAW - 277724
 9/29/80 - Update - MRP - HLD - 279162

DESCRIPTIVE INFORMATION

35. (Cont.)

II. Insert .002 shim fully into view hole in left side of Sear Housing.

- Shim must be between Sear Safety Cam and Sear Block,



Cont.

EQUIPMENT - TOOLS & GAGES

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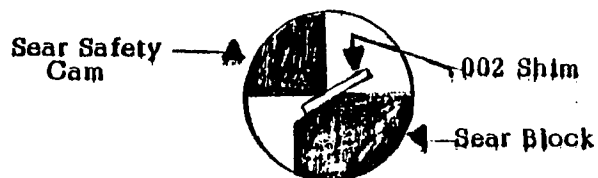
DATES AND REASONS FOR REVISIONS 3/19/79 - Revised - WAW
 9/29/80 - Update - MRP - RLJ - 279162

DESCRIPTIVE INFORMATION

35. (Cont.)

III. Move Safety lever to "Off Safe" position.
 Lightly pull on shim with thumb and finger:

- Shim must remain trapped between Sear Safety Cam and Sear Block.
- If shim is free - return to element #2.



Cont.

EQUIPMENT - TOOLS & GAGES

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DATES AND REASONS FOR REVISIONS
9/29/80 - Update - MRP - R.J. - 2/9/82

3/19/79 - Revised - WAW - 27724

DESCRIPTIVE INFORMATION

EQUIPMENT - TOOLS & GAGES

35. Cont.

IV. Move Safety Lever from "Off Safe" position toward "On Safe" position, to locate and stop Safety Lever at the forward most null location.*

o If null location is passed (too far toward "On Safe"), then return to "Off Safe" position, and approach null location from the "Off Safe" position again.

* Forward Most Null Location is that "just - stable" place between "On" and "Off" safe, closest to "Off Safe", where the Safety Lever will not spring forward to the "Off Safe" position when released.

Cont.

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DATES AND REASONS FOR REVISIONS 3/1/79 - Revised - WAW - 277724
 9/29/80 - Update - MRP - RLJ - 279162

DESCRIPTIVE INFORMATION

35. Cont.

V. With the Safety Lever in the forward most pull location, lightly pull on Shlm with thumb and finger.

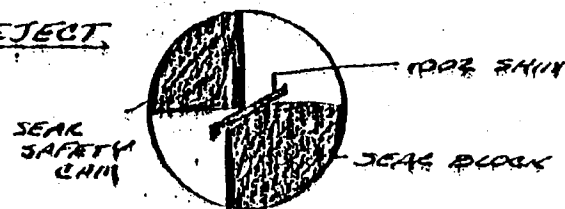
- If Shlm binds or hangs up between Sear Safety Cam and Sear Block -

Reject and rework as per process.

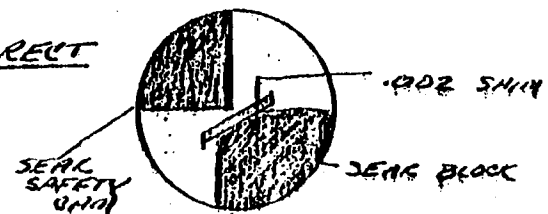
- If Shlm removes freely, clearance is correct.

EQUIPMENT - TOOLS & GAGES

REJECT



CORRECT



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DATES AND REASONS FOR REVISIONS

3/19/79 - Revised - WAW - 277724
 9/29/80 - Updated - MRP - RLD - 2/9/82

DESCRIPTIVE INFORMATION

36. Perform Trick Test,

I. Cock PistolII. Move Safety Lever to "On Safe" Position;

- There must be no bind.
- There must be a good sharp single detent.
- In the "On Safe" position, the Safety must have an observable "spring back", from the fullest rearward and forward positions.

III. Pull Trigger ;

- There must be no click or catch in pull.
- Firing Pin must not fall.

EQUIPMENT - TOOLS & GAGES

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DATES AND REASONS FOR REVISIONS 3/19/79 - Revised - WAW

5/21/79 - Added to element V - WAW - 277931

9/29/80 - Update - MHR - RLJ - 279162

DESCRIPTIVE INFORMATION

36. (Cont.)

IV. Release Trigger Slowly;

- Trigger must move to full forward position when released.

V. Move Safety Lever to "Off Safe" Position:

- Firing Pin must not fall.
- Pull Trigger. Firing Pin must fall.

VI. Re-cock Pistol

Position to the Forward Most Null Location.
(Previously defined in element #35, Page 24.

Two fingers may be necessary to position Safety)

Cont.

EQUIPMENT - TOOLS & GAGES

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3/19/79 - Revised - WAW - 277724

9/29/80 - New - MRP - 279162

DESCRIPTIVE INFORMATION

EQUIPMENT - TOOLS & GAGES

36. (Cont.)

VIII. Pull Trigger Hard;

- There must be no click or catch in pull,

IX. Release Trigger Slowly;

- Trigger must not bind,
- Trigger must move to full forward position when released,
- Firing Pin must not fall,

X. Push Safety Lever to "Off Safe" Position;

- Firing Pin must not fall.
- Safety Lever must spring to "Off Safe" position by itself when pushed from the null location.

Cont.

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DATES AND REASONS FOR REVISIONS 3/19/79 - Revised - WAW - 277724
 9/29/80 - Update - MRP - RLJ - 279162

DESCRIPTIVE INFORMATION

36. (Cont.)

- In the "Off Safe" position, the Safety must have an observable "spring back" from the fullest forward and rearward position.

XI. Pull Trigger;

- Firing Pin must fall.

XII. Open action and close Bolt firmly to re-cock,

- Firing Pin must not fall.

XIII. Repeat steps 7 thru 12.

Cont.

EQUIPMENT - TOOLS & GAGES

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DATES AND REASONS FOR REVISIONS 3/19/79 - Revised - WAW - 277724
 9/29/80 - Update - MRP - RLJ - 279162

DESCRIPTIVE INFORMATION

36.(Cont.)

For the Third and Last Trial:XIV. Move Safety to "On Safe" position,

XV. From the "On Safe" position, move the Safety Lever to the forward most null location. (Previously defined element #35, page 24.)

XVI. Pull Trigger hard,XVII. Release Trigger slowly;

- There must be no click or catch in pull.

Cont.

EQUIPMENT - TOOLS & GAGES

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EQUIPMENT-TOOLS & GAGES

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DATES AND REASONS FOR REVISIONS 3/19/79 - Revised - WAW - 277724
 5/21/79 - Revised element 37 - WAW - 277931
 9/29/80 - Update - MHP - RLJ - 279162

DESCRIPTIVE INFORMATION

EQUIPMENT - TOOLS & GAGES

36. (Cont.)

XIX. Pull Trigger;

- Firing Pin must fall.

XX. Open Action and close Bolt firmly to re-cock.

- Firing Pin must not fall.

37. Put Safe in "Off Safe" position.

Re-cock action,

Push with steady pressure on the end of Firing Pin

head. ~~XXXXXXXXXXXXXXXXXXXX~~ (Use suitable non - marking means);

- Firing Pin must not fall.

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 9/29/80 - Update - MRP - RLJ - 279162

DESCRIPTIVE INFORMATION

38. Check Notch Escape.

Put Safe in "Off Safe" Position
 Hold Trigger Back.
 Close Bolt Slowly.

- Firing Pin Must Follow Down.

39. Use dummy cartridges to check feeding, extraction
 and ejection.

Adjust if necessary.

40. Assemble Rear Sight Nut and Rear Sight to Rib with
 Rear Sight Screw. (925470, 221, Only)

EQUIPMENT - TOOLS & GAGES

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	GA.						

PART NAME Final Pistol Assembly COOLANT _____ SET UP TIME _____ MODEL No. XP-100 OPER. No. 575
 TYPE _____ MACH. HRS. _____ DEPT. No. 15 PAGE 34 OF 37
 MACHINE _____

PROCESS RECORD ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 3/19/79 - Revised - WAW - 277724
 5/21/79 - Included washers - WAW - 277931
 9/29/80 - Update - MRP - RLJ - 279162

DESCRIPTIVE INFORMATION

41. Assemble Rib to Barrel Assembly with 2 Rib Screws,
 Do not tighten, (925470, 221, Only)
42. Assemble Front Sight to Rib with Front Sight Screws and
 Sight Washers, (925470, 221, Only)
43. Assemble Rear Sight Screw and Sight Washer to Rib
 thru Rear Sight, (925470, 221, Only)
44. Position Rib in extreme rear position, and tighten
 all screws. (925470, 221, Only)

EQUIPMENT - TOOLS & GAGES

OPERATION DESCRIPTION	OCC. No.						
Final Assembly	STD. HRS/C						
	STD. No.						
	EFF. DATE						
	PART No.						
	GA.						

PART NAME Final Pistol Assembly COOLANT SET UP TIME MODEL No. XP-100 OPER. No. 575
 TYPE MACH. HRS. DEPT. No. 15 PAGE 35 OF 37
 MACHINE

PROCESS RECORD ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 3/19/79 - Revised - WAW - 277724

5/14/79 - Added letter "O" - WAW - 277906

5/21/79 - Modified element 45 - WAW - 277931

9/29/80 - Update - MRP - RLJ - 279162

DESCRIPTIVE INFORMATION

45. Mark Assembler's identification on gun ticket.
Hand stamp letter "O" on left rear horizontal flat
of Receiver Tang,
46. Pick correct ticket and fill in.
47. If repairs from test are necessary, work must be
done by the assembler who built and stamped the
action.

EQUIPMENT - TOOLS & GAGES

1/16" Stamp

OPERATION DESCRIPTION	DCC. No.						
Final Assembly	STD. HRS/C						
	STD. No.						
	EFF. DATE						
	PART No.						
	GA.						

PART NAME Final Pistol Assembly COOLANT SET UP TIME MODEL No. XP-100 OPER. No. 575

TYPE MACH. HRS. DEPT. No. 15 PAGE 36 OF 37

MACHINE

PROCESS RECORD ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 2/26/80 - New Operation - ZJK - 278589
 9/29/80 - Update - MRP - RLJ - 279162

DESCRIPTIVE INFORMATION

NOTE:

Same as Sheets 1-36 except for the following elements.

3. Assemble (5) Rec, plug Screws into Receiver.
40. OMIT - Assemble rear Sight Nut & Rear Sight to Rib with R. S. Screw.
41. OMIT - Assemble Rib to Barrel with 2 Rib Screws.
42. OMIT - Assemble Front Sight to Rib.
43. OMIT - Assemble Rear Sight Screw, etc, to Rib.
44. OMIT - Position Rib & tighten all screws.
- 44-5 Assemble Front Sight Ramp to Barrel with Front Sight Screw. (925471, 7MM BR, only)

EQUIPMENT - TOOLS & GAGES

OPERATION DESCRIPTION

Final Assembly
 (7MM BR Rem. only)

OCC. No.

STD. HRS/C

STD. No.

EFF. DATE

PART No.

GA. 7MM BR

925471

PART NAME Final Pistol Assembly COOLANT

SET UP
TIME

MODEL No. XP-100

OPER. No. 575

TYPE

MACH. HRS.

DEPT. No. 15

PAGE 37 OF 37

MACHINE Bench

PROCESS RECORDS ASSEMBLY SHEETS

24

DATES AND REASONS FOR REVISIONS 5/13/61 - Made regular

3/1/68 - Chg. reading - MT - 265929

9/29/80 - Update - MRP - RLJ - 279162

DESCRIPTIVE INFORMATION

Proof Test, Test and Target Pistol

EQUIPMENT - TOOLS & GAGES

Proof Test, Test
Targeting Jack

OPERATION DESCRIPTION

Proof Test, Test and Target

OCC. No.

STD. HRS/C

STD. No.

EFF. DATE

PART No.

925470

925471

QA.

221

7MM BR

PART NAME Final Pistol Assembly

COOLANT

SET UP
TIME

MODEL No.

IP100

OPER. No.

603

TYPE

MACH. HRS.

DEPT. No.

85

PAGE

1

OF 1

MACHINE

BARBER - PRESALE R 0130316

5/21/79 - Added word to item 1 - WAW - 277931
9/29/80 - Update - MRP - RLS - 279182

EQUIPMENT—TOOLS & GAGES

- ### Comparator Fixture

NOTE: Realign lamphouse each time bulb is replaced. This centralizes bulb filament on optical axis. Light beam from condensing lens to projection lens must be parallel. Adjust as required. Refer to Pg. 7 of J & L Operating Manual.

PART NAME Final Pistol Assembly COOLANT _____ SET UP TIME _____ MODEL No. XP-100 OPER. No. 620
TYPE _____ MACH. HRS. _____ DEPT. No. 15 PAGE 1 OF 7
MACHINE _____

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER

BARBER - PRESALE R 0130316
R2531304

PROCESS RECORD. ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 4/23/79 - New - WAW - 277804
 9/29/80 - Update - MRP - RLJ - 279162

DESCRIPTIVE INFORMATION

4. Put Safety Lever in "OFF SAFE" position.
5. Place action in fixture and secure.
6. Push Bolt Stop to free position and secure with a non-marring means.
7. Close Bolt.
8. Move fixture to position Sear Safety Cam vertical surface to engagement set line of comparator overlay.

EQUIPMENT - TOOLS & GAGES

OPERATION DESCRIPTION

Adjust Sear Housing Assembly
on Comparator 100%.

OCC. NO.

STD. HRS/C

STD. No.

EFF. DATE

PART NO.

GA.

PART NAME Final Pistol Assembly COOLANT _____ SET UP TIME _____ MODEL No. XP-100 OPER. No. 620
 TYPE _____ MACH. HRS. _____ DEPT. No. 15 PAGE 2 OF 7

MACHINE

PROCESS RECORD - ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 4/23/79 - New - WAW - 277804
 9/29/80 - Update - MRP - RLJ - 279162

DESCRIPTIVE INFORMATION

9. Check Sear Safety Cam - Sear Block engagement
 (.015 - .020);

♦ Must be within tolerance lines of Comparator overlay.

A. If engagement is more than max. line:

Turn Trigger Adjusting Screw slowly clockwise (viewed from Muzzle end) until engagement comes within tolerance lines,

EQUIPMENT - TOOLS & GAGES

OPERATION DESCRIPTION

Adjust Sear Housing Assembly
 on Comparator 100% ,

OCC. No.

STD. HRS/C

STD. No.

EFF. DATE

PART NO.

GA.

PART NAME Final Pistol Assembly COOLANT _____ SET UP TIME _____ MODEL No. XP-100 OPER. No. 620
 TYPE _____ MACH. HRS. _____ DEPT. No. 15 PAGE 3 OF 7

MACHINE

PROCESS RECORD ASSEMBLY SHEETS

DATE AND REASONS FOR REVISIONS 4/23/79 - New - WAW - 277804
 9/29/80 - Update - MRP - RLJ - 279162

DESCRIPTIVE INFORMATION

9. (Cont'd.)

B. If engagement is less than min. line:

Raise Bolt Handle (actually lowering handle while
 action is in the fixture) and turn Adjusting Screw
 counter clock-wise,

Close Bolt Handle (Sear Block will not always follow
 as Trigger Adjusting Screw is turned counter-clockwise
 with Bolt closed),

Return to 9A

10. Pull Trigger to drop Firing Pin.

EQUIPMENT - TOOLS & GAGES

OPERATION DESCRIPTION	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
Adjust Sear Housing Assembly on Comparator 100%.							
	PART No.						
	GA.						

PART NAME Final Pistol Assembly COOLANT SET UP TIME MODEL No. XP-100 OPER. No. 620
 TYPE MACH. HRS. DEPT. No. 15 PAGE 4 OF 7
 MACHINE

PROCESS RECORD ASSEMBLY SHEETS

DATE AND REASONS FOR REVISIONS 4/23/79 - New - WAW - 277804
 9/29/80 - Update - MRP - RLJ - 279162

DESCRIPTIVE INFORMATION

11. Move fixture to position Sear Safety Cam vertical surface to overtravel "set" line on Comparator overlay.

12. Hold Trigger back firmly against Stop Screw.

- Clearance between Sear Safety Cam and Sear Block must be within overtravel tolerance lines on Comparator overlay (.005 - .015).

A. If overtravel is less than min. line;

Turn Sear Block Stop Screw counter-clockwise until clearance is within tolerance lines.

EQUIPMENT - TOOLS & GAGES

OPERATION DESCRIPTION	OCC. No.						
Adjust Sear Housing Assembly on Comparator 100%.	STD. HRS/C						
	STD. No.						
	EFF. DATE						
PART No.							
GA.							

PART NAME Final Pistol Assembly COOLANT SET UP TIME MODEL No. XP-100 OPER. No. 620
 TYPE MACH. HRS. DEPT. No. 15 PAGE 5 OF 7
 MACHINE

PROCESS RECORD - ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 4/23/79 - New - WAW - 277804
 5/21/79 - Add to element 15 - WAW - 277931
 9/29/80 - Update - MRP - 279162

DESCRIPTIVE INFORMATION

12. (Cont'd)

B. If overtravel is more than max, line:

Turn Sear Block Stop Screw clockwise until clearance
 is within tolerance lines.

13. Remove Bolt Stop means.

14. Remove Action from fixture.

15. Seal both screws with "Duco" cement, including screw slots.
 • Cement must not interfere with link freedom.

EQUIPMENT - TOOLS & GAGES

"Duco" Cement

OPERATION DESCRIPTION	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
Adjust Sear Housing Assembly on Comparator 100%.							
	PART NO.						
	GA.						

PART NAME Final Pistol Assembly COOLANT SET UP TIME MODEL No. XP-100 OPER. No. 620
 TYPE MACH. HRS. DEPT. No. 15 PAGE 6 OF 7
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DATES 9/29, 4/23/79 - New - WAW - Update - MRP - R.L.J. - 279162	REASONS FOR REVISIONS	830		PART NAME Final Pistol Assembly	MODEL No. XP-100	OPER. No. 620
DESCRIPTIVE INFORMATION			MACH. HRS. 15			
TYPE			MACHINE			

Form R. D. 446a

PROCESS RECORD: ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 4/23/79 - New - WAW - 277804

5/21/79 - Corrected name & added element - WAW - 277931

9/29/80 - Update - MRP - RLJ - 279162

DESCRIPTIVE INFORMATION

EQUIPMENT - TOOLS & GAGES

1. Pick Barreled Action and inspect,

◆ No mars or scratches.

● Legible proof, test, target stamps,
Tighten Barreled Action in vise.

2. Insert Receiver Screw Washers in C'Bore on underside of Receiver.

3. Assemble Trigger Balance Pin and Spring to Trigger balance.

OPERATION DESCRIPTION	OCC. No.						
Assemble Stock to Action.	STD. HRS/C						
	STD. No.						
	EFF. DATE						
PART No.	925470	925471					
GA.	221	7MM BR					

PART NAME Final Pistol Assembly COOLANT _____ SET UP TIME _____ MODEL No. XP-100 OPER. No. 625

TYPE _____ MACH. HRS. _____ DEPT. No. 15 PAGE 1 OF 10

MACHINE _____

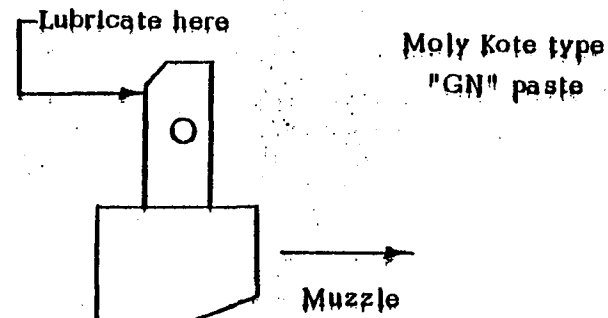
PROCESS RECORD ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 4/23/79 - New - WAW - 277804
9/29/80 - Update - MRP - RLJ - 279162

DESCRIPTIVE INFORMATION

4. Lubricate Trigger balance - See Illustration.
5. Select Stock Assembly and Inspect:
 - Reasonably uniform medium lustre.
 - No splits, cracks or breaks.
 - No mars or scratches.
 - No missing parts.
6. Assemble Trigger balance sub-assembly to Stock:
 - Trigger balance must be installed correctly (See Illustration).

EQUIPMENT - TOOLS & GAGES



OPERATION DESCRIPTION	OCC. No.						
	STD. HRS/C						
	STD. NO.						
	EFF. DATE						
Assemble Stock to Action,							
	PART No.						
	GA.						

PART NAME Final Pistol Assembly COOLANT SET UP TIME MODEL No. XP-100 OPER. No. 625
TYPE MACH. HRS. DEPT. No. 15 PAGE 2 OF 10
MACHINE

DESCRIPTIVE INFORMATION

EQUIPMENT—TOOLS & GAGES

- Trigger must be central in Trigger Guard, It must not touch at any point,
- Receiver Tang must be fully seated in Stock at rear,
- Safety must snap freely forward and rearward with no bind on Stock or Receiver.

PART NAME Final Pistol Assembly COOLANT _____ SET UP TIME _____ MODEL No. XP-100 OPER. No. 625
TYPE _____ MACH. HRS. _____ DEPT. No. 15 PAGE 3 OF 10
MACHINE _____

PROCESS RECORD ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 4/23/79 - New - WAW - 277804
 5/21/79 - Corrected number - WAW - 277931
 9/29/80 - Update - MRP - RLJ - 279162

DESCRIPTIVE INFORMATION

8. Perform trick test.

I. Cock PistolII. Move Safety Lever to "ON SAFE" position;

- There must be no bind,
- There must be a good, sharp single detent.
- In the "ON SAFE" position, the Safety must have an observable "spring back" from the fullest rearward and forward positions.

III. Pull Trigger:

- There must be no click or catch in pull.
- Firing Pin must not fall,

EQUIPMENT - TOOLS & GAGES

OPERATION DESCRIPTION	OCC. No.						
Assemble Stock to Action,	STD. HRS/C						
	STD. No.						
	EFF. DATE						
PART No.							
GA.							

PART NAME Final Pistol Assembly COOLANT _____ SET UP TIME _____ MODEL No. XP-100 OPER. No. 625
 TYPE _____ MACH. HRS _____ DEPT. No. 15 PAGE 4 OF 10
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PROCESS RECORD: ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 4/23/79 - New - WAW - 277804
 5/21/79 - Added item to V and corrected VIII - WAW - 277931
 9/29/80 - Update - MRP - RLJ - 279162

DESCRIPTIVE INFORMATION

8. Cont'd.

IV. Release Trigger Slowly;

- Trigger must move to full forward position when released.

V. Move Safety Lever to "OFF SAFE" position,

- Firing Pin must not fall.
- Pull Trigger, Firing Pin must fall,

VI. Re-cock Pistol

VII. Move Safety Lever from "OFF SAFE" position to the forward most null location. (Previously defined in Element #175, Page 24. Two fingers may be necessary to position Safety.),

EQUIPMENT - TOOLS & GAGES

OPERATION DESCRIPTION	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
Assemble Stock to Action,							
	PART No.						
	GA.						

PART NAME Final Pistol Assembly COOLANT _____ SET UP TIME _____ MODEL No. XP-100 OPER. No. 625
 TYPE _____ MACH. HRS. _____ DEPT. No. 15 PAGE 5 OF 10
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DESCRIPTIVE INFORMATION

8. Cont.

VIII. Pull Trigger Hard;

- There must be no click or catch in pull.

IX. Release Trigger slowly:

- Trigger must not bind,
- Trigger must move to full forward position when released,
- Firing Pin must not fall.

EQUIPMENT—TOOLS & GAGES

OPERATION DESCRIPTION

Assemble Stock to Action,

QCC. No.

\$TP. HR6/C

STD. No.**EFF. DATE**

PART No.

GA.

PART NAME Final Pistol Assembly COOLANT _____ SET UP TIME _____ MODEL No. XP-100 OPER. No. 625
TYPE _____ MACH. HRS. _____ DEPT. No. 15 PAGE 6 OF 10
MACHINE _____

PROCESS RECORD ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 4/23/79 - New - WAW - 277804
 9/29/80 - Update - MRP - RLD - 2/9/82

DESCRIPTIVE INFORMATION

8. X. Push Safety Lever to "OFF SAFE" Position:

- Firing Pin must not fall.
- Safety Lever must spring to "OFF SAFE" position by itself when pushed from this pull location.
- In the "OFF SAFE" position, the Safety must have an observable "spring back" from the fullest forward and rearward positions.

XI. Pull Trigger:

- Firing Pin must fall.

XII. Open Action and close Bolt forcibly to re-cock:

- Firing Pin must not fall.

EQUIPMENT - TOOLS & GAGES

OPERATION DESCRIPTION	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
Assemble Stock to Action,							
	PART NO.						
	GA.						

PART NAME Final Pistol Assembly COOLANT _____ SET UP TIME _____ MODEL No. XP-100 OPER. No. 625
 TYPE _____ MACH. HRS. _____ DEPT. No. 15 PAGE 7 OF 10
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PROCESS RECORD ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 4/23/79 - New - WAW - 277804
9/29/80 - Update - MRP - RLJ - 279162

DESCRIPTIVE INFORMATION

B. Cont.

XIII. Repeat Steps 7 thru 12 once.

FOR THE THIRD AND LAST TRIAL

XIV. Move Safety to "ON SAFE" position.

XV. From the "ON SAFE" position, move the Safety Lever to the forward most null location, (Previously defined Element 175, Page 24.)

XVI. Pull Trigger hard.

EQUIPMENT - TOOLS & GAGES

OPERATION DESCRIPTION	OCC. No.						
Assemble Stock to Action.	STD. HRS/C						
	STD. No.						
	EFF. DATE						
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PART NAME Final Pistol Assembly COOLANT SET UP TIME MODEL No. XP-100 OPER. No. 625
TYPE MACH. HRS. DEPT. No. 15 PAGE 8 OF 10
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PROCESS RECORD: ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 4/23/79 - New WAW - 277804
 9729/80 - Update - MRP - RLJ - 279162

DESCRIPTIVE INFORMATION

8. Cont.XVII. Release Trigger slowly;

- There must be no click or catch in pull,
- Trigger must not bind,
- Trigger must return to full forward position when released,
- Firing Pin must not fall,

XVIII. Push Safety Lever to "OFF SAFE" position.

- Firing Pin must not fall.
- Safety must spring to "OFF SAFE" position when pushed from the null location,

EQUIPMENT - TOOLS & GAGES

OPERATION DESCRIPTION	OCC. No.						
Assemble Stock to Action,	STD. HRS/C						
	STD. No.						
	EFF. DATE						
PART No.							
GA.							

PART NAME Final Pistol Assembly COOLANT _____ SET UP TIME _____ MODEL No. XP-100 OPER. No. 625
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PROCESS RECORD ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 4/23/79 - New - WAW - 277804
 9/29/80 - Update - MRP - RLJ - 279162

DESCRIPTIVE INFORMATION

8. Cont.XIX. Pull Trigger

- Firing Pin must fall.

XX. Open Action and close Bolt forcibly to re-cock:

- Firing Pin must not fall.

EQUIPMENT - TOOLS & GAGES

OPERATION DESCRIPTION	OCC. No.						
Assemble Stock to Action,	STD. HRS/C						
	STD. No.						
	EFF. DATE						
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GA.							

PART NAME Final Pistol Assembly COOLANT _____ SET UP TIME _____ MODEL No. XP-100 OPER. No. 625
 TYPE _____ MACH. HRS. _____ DEPT. No. 15 PAGE 10 OF 10
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PROCESS RECORDS ASSEMBLY SHEETS

DATES AND REASONS FOR REVISIONS 9/29/80 - Update - MRP - RLJ - 279162

DESCRIPTIVE INFORMATION

See Sheets 2 thru 14 for Procedure

EQUIPMENT - TOOLS & GAGES

OPERATION DESCRIPTION

Final Inspection

OCC. No.

STD. HRS/C

STD. No.

EFF. DATE

PART No.

GA.

925470

221

925471

7MM BR

PART NAME Final Pistol Assembly COOLANT

SET UP
TIME

MODEL No. XP-100

OPER. No. 630

TYPE

MACH. HRS.

DEPT. No. 15

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MACHINE

DATES AND REASONS FOR REVISIONS		4/23/79 - Revised - WAW - 277804											
9/29/80 - Update - MRP - RLJ - 279162													
DESCRIPTIVE INFORMATION													
I. <u>Ammunition Inspection</u> Inspect Gun for live ammunition: ● Chamber must be empty and there must be no live ammunition present.													
II. <u>Receiver Roll Markings</u> Must be present, clear, distinct and visible above Stock. <table style="width: 100%; margin-top: 20px;"> <thead> <tr> <th style="text-align: left; width: 50%;"><u>Type</u></th> <th style="text-align: left; width: 50%;"><u>Location</u></th> </tr> </thead> <tbody> <tr> <td>● Remington - In Script</td> <td>Left side, center.</td> </tr> <tr> <td>● Model XP-100</td> <td>Left side, below "Remington".</td> </tr> <tr> <td>● Serial Number and alphabetic prefix</td> <td>Left side, forward of above items.</td> </tr> </tbody> </table>				<u>Type</u>	<u>Location</u>	● Remington - In Script	Left side, center.	● Model XP-100	Left side, below "Remington".	● Serial Number and alphabetic prefix	Left side, forward of above items.		
<u>Type</u>	<u>Location</u>												
● Remington - In Script	Left side, center.												
● Model XP-100	Left side, below "Remington".												
● Serial Number and alphabetic prefix	Left side, forward of above items.												
III. <u>Barrel Roll Markings</u> Must be present, clear, distinct and visible above side of Stock. <table style="width: 100%; margin-top: 20px;"> <thead> <tr> <th style="text-align: left; width: 50%;"><u>Type</u></th> <th style="text-align: left; width: 50%;"><u>Location</u></th> </tr> </thead> <tbody> <tr> <td>● Remington Arms Co., Inc. Ilion, New York Made in U.S.A.</td> <td>Left side</td> </tr> <tr> <td>● .221 Rem. Fireball</td> <td>Left side, rear of above item.</td> </tr> <tr> <td>● Des. 201, 366</td> <td>Right side, toward rear,</td> </tr> <tr> <td>● Pat. 3,255,545</td> <td>Right side, below above item.</td> </tr> </tbody> </table>				<u>Type</u>	<u>Location</u>	● Remington Arms Co., Inc. Ilion, New York Made in U.S.A.	Left side	● .221 Rem. Fireball	Left side, rear of above item.	● Des. 201, 366	Right side, toward rear,	● Pat. 3,255,545	Right side, below above item.
<u>Type</u>	<u>Location</u>												
● Remington Arms Co., Inc. Ilion, New York Made in U.S.A.	Left side												
● .221 Rem. Fireball	Left side, rear of above item.												
● Des. 201, 366	Right side, toward rear,												
● Pat. 3,255,545	Right side, below above item.												
<table style="width: 100%; border: none;"> <tr> <td style="width: 30%;">PART NAME <u>Final Pistol Assembly</u></td> <td style="width: 15%;">COOLANT <u> </u></td> <td style="width: 15%;">SET UP TIME <u> </u></td> <td style="width: 15%;">MODEL No. <u>XP-100</u></td> <td style="width: 25%;">OPER. No. <u>630</u></td> </tr> <tr> <td>TYPE <u>Final Inspection</u></td> <td>MACH. HRS. <u> </u></td> <td>DEPT. No. <u>15</u></td> <td>PAGE <u>2</u></td> <td>OF <u>14</u></td> </tr> </table>				PART NAME <u>Final Pistol Assembly</u>	COOLANT <u> </u>	SET UP TIME <u> </u>	MODEL No. <u>XP-100</u>	OPER. No. <u>630</u>	TYPE <u>Final Inspection</u>	MACH. HRS. <u> </u>	DEPT. No. <u>15</u>	PAGE <u>2</u>	OF <u>14</u>
PART NAME <u>Final Pistol Assembly</u>	COOLANT <u> </u>	SET UP TIME <u> </u>	MODEL No. <u>XP-100</u>	OPER. No. <u>630</u>									
TYPE <u>Final Inspection</u>	MACH. HRS. <u> </u>	DEPT. No. <u>15</u>	PAGE <u>2</u>	OF <u>14</u>									
MACHINE													

DATES AND REASONS FOR REVISIONS 4/23/79 - Revised - WAW - 277804
 9/29/80 - Update - MRP - RLJ - 279162

DESCRIPTIVE INFORMATION

IV. Barrel Stamp Markings

Must be present, clear, distinct and visible above Stock.

<u>Type</u>	<u>Location</u>	<u>Example</u>
• Magnaflux mark	Right side, rear	
• Proof	Right side, near Barrel Bracket, above center- line of Barrel	
• Test and Target	Just forward of Proof Stamp	X
• Assembler	Left side, forward of Receiver, above centerline of Barrel	2

V. Bolt Markings

Must be present, clear and distinct.

<u>Type</u>	<u>Location</u>
• Bolt head pull test - Prick Punch	Right side Lug
• Proof mark - Prick Punch	Bottom of Bolt Handle
• Bolt Handle braze test - Prick Punch	Rear of Bolt Handle
• Magnaflux Bolt Assembly Inspection - Prick Punch	Left side Lug
• Serial Number, must match Receiver, Last 4 digits	Bottom rear of Bolt body

PART NAME Final Pistol Assembly COOLANT _____ SET UP TIME _____ MODEL No. XP-100 OPER. No. 630
 TYPE Final Inspection MACH. HRS. _____ DEPT. No. 15 PAGE 3 OF 14
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DATES AND REASONS FOR REVISIONS		4/23/79 - Revised - WAW - 277804	
2/26/80 - Added .221 Rem only - ZJK - 278589			
9/29/80 - Update - MRP - RLJ - 279162			
DESCRIPTIVE INFORMATION			
VI. <u>Barrel Finish</u>			
- Must be uniform, Black color, medium lustre finish - free of seams and stress marks, - Muzzle crown must be reasonably smooth with no burrs, jams or deformation in bore, - Bore must be concentric with muzzle O.D,			
VII. <u>Rib</u> (.221 Rem. only)			
- Barrel Rib, (Black Nylon), must present a reasonably uniform lustre, oiled, clean and free of breaks, splits, cracks or flashing, - No bad scratches or abrasions, - Rib tight to Barrel and screw slots not mutilated, - Rib must conform to contour of Barrel full length. No excessive openings at sides, - As viewed from rear, top of Rib must be straight and reasonably flat full length,			
PART NAME	Final Pistol Assembly	COOLANT	
TYPE	Final Inspection	MACH. HRS.	
		SET UP TIME	
		MODEL No.	XP-100
		DEPT. No.	15
		OPER. No.	630
		PAGE	4
		OF	14
MACHINE			

Form R. D. 6466

DATES AND REASONS FOR REVISIONS 4/23/79 - Revised - WAW - 277804
 2/26/80 - Added .221 Rem. - ZJK - 278589
 9/29/80 - Update - MRP - RLJ - 279162

DESCRIPTIVE INFORMATION

VIII. Sights

- Front sight screwed tightly to Barrel, central on Rib and parallel with line of sight - not bent, tipped or deformed, (.221 Rem, only)
- Rear Sight Ramp screwed tightly - reasonably central to Rib or Barrel
- Rear Sight Leaf reasonably central crosswise on ramp - set screw tight in position,
- Rear Sight Eye Piece - top approximately flush with top surface of Leaf - set screw tight.
- Rear Sight Assembly must be level, crosswise, with Front Sight and with line of sight, as viewed from rear - not tipped, twisted or bent.

IX. Receiver Finish

- All outside exposed surfaces must have a smooth, polished finish, uniform black in color, free of burrs, jams, or dents,
- Ejection port edges must not be sharp, chipped or marred,
- Receiver Plug Screws must be present in front (2) and top rear (1). Slots not mutilated.
- Gas escape hole must be present at front right side of Receiver and show a minimum of 1/2 of hole above Stock.

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DATES AND REASONS FOR REVISIONS 4/23/79 - Revised - WAW - 277804
 9/29/80 - Update - MRP - 279162

DESCRIPTIVE INFORMATION

X. Barrel and Receiver Fit

- Barrel, Barrel Bracket and Receiver must be tight at joint.
- Must be in alignment lengthwise.

XI. Stock Assembly

A. Stock and Trigger Guard

- Stock must present a reasonably uniform brown-grained medium lustre; clean and free of breaks, splits and cracks.
- Any dull spots must not sharply contrast.
- Slight acid marks (at sides of striations) permissible, but no blisters or bubbles.
- No bad scratches or abrasions.
- Trigger Guard must present good uniform black finish - not chipped or marred.
- Trigger Guard must fit well in Stock at sides and around ends.
- Molding mark inside guard must not be sharp - no protruding flash.
- Trigger opening clean, not broken through or chipped at edges.

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DESCRIPTIVE INFORMATION

XI. Stock Assembly - (Cont'd)

B. Striations

- Must be distinct, uniform and complete full length. Spacer and Grip Diamond not striated.

C. Checkering

- Must be distinct and good form - not abraded or flattened - complete on both sides of Grip.

D. Fore End Spacer and Tip

- Must be tight to Stock.
- Spacer must not be broken and must conform to contour of Stock and Tip.

E. Diamond Inserts

- Must be clean white in color and tight in Stock.
- Must be a good fit in cavities. No appreciable openings.

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DATES AND REASONS FOR REVISIONS 4/23/79 - Revised - WAW - 277804
 5/21/79 - Delete "Free Float" test - WAW - 277931
 9/29/80 - Update - MRP - BLJ - 279162

DESCRIPTIVE INFORMATION

XII. Stock Fit

A. To Receiver

- Receiver must fit tightly in Stock.
- Receiver Tang must seat fully in Stock at rear. It must not protrude beyond Stock at rear.
- Must be a good fit at both sides full length.

B. To Barrel

- Must show a reasonably uniform opening on both sides for full length forward of Barrel Bracket.

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DATES AND REASONS FOR REVISIONS 4/23/79 - Revised - WAW - 277804
 9/29/00 - Update - MRP - RLJ - 279162

DESCRIPTIVE INFORMATION

XIII. Bolt Assembly

- Bolt Plug and Firing Pin Head - Good smooth finish with uniform Black color,
- Bolt Handle, Bolt Body, Bolt Head have good smooth bright finish. No rust, excess braze, bad nicks or burrs, Rub marks on body are acceptable,
- Bottom "half ball" of "S" Bolt Handle - serrated with no burrs or sharp edges,
- Sear notch at front of Firing Pin Head - good smooth finish - no deep lines.
- Rear surfaces of Locking Lugs must be smooth - no deep lines.
- Gas escape hole must be present in bottom front,
- Bolt face must be smooth - no deep rings,
- Extreme front face of Bolt (shroud) must be smooth and flat.
- Extractor and rivet present - good claw - not broken or damaged.

Depress Ejector with hand punch and release:

- Must depress at least flush with Bolt face and return to forward position freely under spring tension
- Must be retained by Ejector Pin.

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4/23/79 - Revised - WAW - 277804

5/21/79 - Added to element XVI - WAW - 277931

2/26/80 - Added Gages - ZJK - 278589

9/29/80 - Update - MRP - RLJ - 279162

DESCRIPTIVE INFORMATION

XIV. Heading

Cock Pistol, Place Heading Plug into Chamber, Move Bolt to forward position and rotate clockwise,

Do not use excessive force,

- A. On Min. Plug B-85239 - .221 Rem.
 B-45160 - 7MM BR Rem.
 • Bolt must fully close,

- B. On Max. Plug B-85240 - .221 Rem.
 B-45161 - 7MM BR Rem.
 • Bolt must not fully close,

XV. Function

With dummy cartridges, check for proper feeding, extraction and ejection.

XVI. Trigger Pull

MEASURE pull with spring scale:

- Gun must fire with 1 1/2 to 2 3/4 lbs. force.
- Trigger must be central in Trigger Guard. It must not touch at any point, Adjust if necessary.

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DATES AND REASONS FOR REVISIONS 4/23/79 - Revised - WAW - 277804
5/21/79 - Add to element 5 - WAW - 277931
9/29/80 - Update - MRP - RLJ - 279162

DESCRIPTIVE INFORMATION

XVII. Perform Trick Test

1. Cock Pistol
2. Move Safety Lever to "ON SAFE" position;
 - There must be no bind.
 - There must be a good, sharp single detent.
 - In the "ON SAFE" position, the Safety must have an observable "spring back" from the fullest rearward and forward positions.
3. Pull Trigger
 - There must be no click or catch in pull,
 - Firing Pin must not fall,
4. Release Trigger slowly;
 - Trigger must move to full forward position when released.
5. Move Safety Lever to "OFF SAFE" position;
 - Firing Pin must not fall
 - Pull Trigger, Firing Pin must fall,
6. Re-cock Pistol

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DESCRIPTIVE INFORMATION

7. Move Safety Lever from "OFF SAFE" position to the forward most null location
 (Two fingers may be necessary to position Safety).

DEFINITION; Forward Most Null Location

Is that "Just Stable" place, between "ON" and "OFF " Safe, closest to
 "OFF SAFE", where the Safety Lever will not spring forward to the
 "OFF SAFE" position when released.

8. Pull Trigger Hard;

- There must be no click or catch in pull.

9. Release Trigger slowly;

- Trigger must not bind.
- Trigger must move to full forward position when released.
- Firing Pin must not fall.

10. Push Safety Lever to "OFF SAFE" position;

- Firing Pin must not fall.
- Safety Lever must spring to "OFF SAFE" position by itself when pushed from the null position.
- In the "OFF SAFE" position, the Safety must have an observable "spring back" from the fullest forward and rearward positions.

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DATES AND REASONS FOR REVISIONS 3/15/79 - Revised - WAW - 277804
 9/29/80 - Update - MRP - RLJ - 279162

DESCRIPTIVE INFORMATION

XVII. Trick Test Cont.

11. Pull Trigger:

- Firing Pin must fall,

12. Open Action and close Bolt forcibly to re-cock:

- Firing Pin must not fall,

13. Repeat Steps 7 thru 12 once.

FOR THE THIRD AND LAST TRIAL

14. Move Safety to "ON SAFE" position.

15. From the "ON SAFE" position, move the Safety Lever to the forward most null location.

16. Pull Trigger hard

17. Release Trigger slowly

- There must be no click or catch in pull.
- Trigger must not bind,
- Trigger must return to full forward position when released.
- Firing Pin must not fall.

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DATES AND REASONS FOR REVISIONS

4/23/79 - Revised - WAW - 277804

5/21/79 - Chg. wording in item XIX - WAW - 277931

9/29/80 - Update - MRP - RLJ - 279162

DESCRIPTIVE INFORMATION

XVII. Trick Test - (Cont'd)18. Push Safety Lever to "OFF SAFE" position:

- Firing Pin must not fall.
- Safety must spring to "OFF SAFE" position when pushed from the null location.

19. Pull Trigger:

- Firing Pin must fall.

20. Open Action and close Bolt forcibly to re-cock.

- Firing Pin must not fall.

XIX. Stamp Receiver

If pistol meets all inspection requirements, stamp ^{assembler's} mark and date
code stamp on left rear side of Receiver,

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