Remington Arms Company, Inc.
Manufacturing Process Document

Document ID: Trig Assy 7 700   **Effective Date:**   29-Nov-05

Product Line: Centerfire Rifle   **Origination Date:**   12-Mar-93

General Instructions:

Use the Control Buttons above and below to access the various sections of this process. If your screen is not wide enough to display all the section data, use the arrows at the lower right to pan the desired data into view. Simply click on a tab or a button to move to that section of the document.
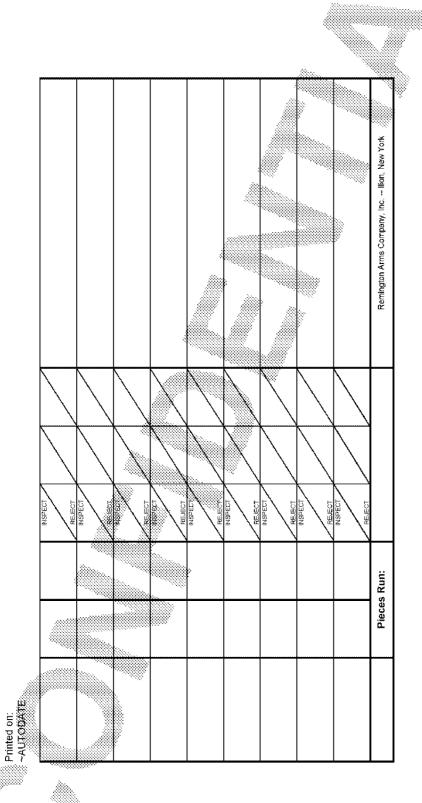
Process Routing Table:

Click on the button below containing the operation number you wish to view.

```
Demagnetize Springs
preventative.
Tap (3) Holes in Trigger Housing
Chase Threads and Ream Ball Hole
Inspect Connector 100% - Inspect Trigger 100%
Assemble Trigger Assembly - Stage Two
Assemble Trigger Assembly - Stage Two
Adjust Trigger Assembly on Comparator 100%
Assemble Trigger Assembly - Stage Three
Function Check Complete Trigger Assembly 100%
Trigger Assembly With Assemblers Identification
Repair Rejected Trigger Assemblies
```

Printed on:
~AUTODATE

(Enter Oper #) (Enter the Operation Name in this field)

CONFIDENTIAL

ILE00076463

Printed on:
~AUTODATE

PROCESS CONTROL INSPECTION RECORD THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES			Revision Date: 29-Nov-05			Processed by:	
Part No:	Part Name:	Trig Assy 7 700	Centerfire Rifle			Date:	8/14/2006
Operation No: (Enter Oper #)	Operation:	(Enter the Operation Name in this field)				Work Center:	
Prod. Qty:	Prod. Order #:		**Operator**			Setup inspected by & Date:	
Gage Description and Characteristic	Gage Number	Gage Frequency	**1st Shift**	**2nd Shift**	**3rd Shift**	Remarks, Causes, Action Taken, Etc.	
VISUAL	VISUAL	100%	INSPECT REJECT				
			INSPECT REJECT				
			INSPECT REJECT				

INSPECT	REJECT	INSPECT	REJECT	INSPECT	REJECT	INSPECT	REJECT	INSPECT	REJECT	INSPECT	REJECT	INSPECT	REJECT	INSPECT	REJECT

Pieces Run:

Remington Arms Company, Inc. -- Ilion, New York

CONFIDENTIAL

Printed on:
~AUTODATE

140   Demagnetize Springs

Step   Operation / Step Description

Demagnetize Springs

Procedure:
1. Place Sear Springs and Trigger Springs in separate non-metallic pans
   not to exceed 6"X3"X2" in size.

2. Turn demagnetizer "ON".

3. Pass pan across the effective area located between the handles. Start
   the pan over the right side and pass to the left side and remove.

4. Turn Demagnetizer "OFF". Do not turn switch off with pan in contact
   with demagnetizer, " THIS MAY MAGNETIZE PARTS ".

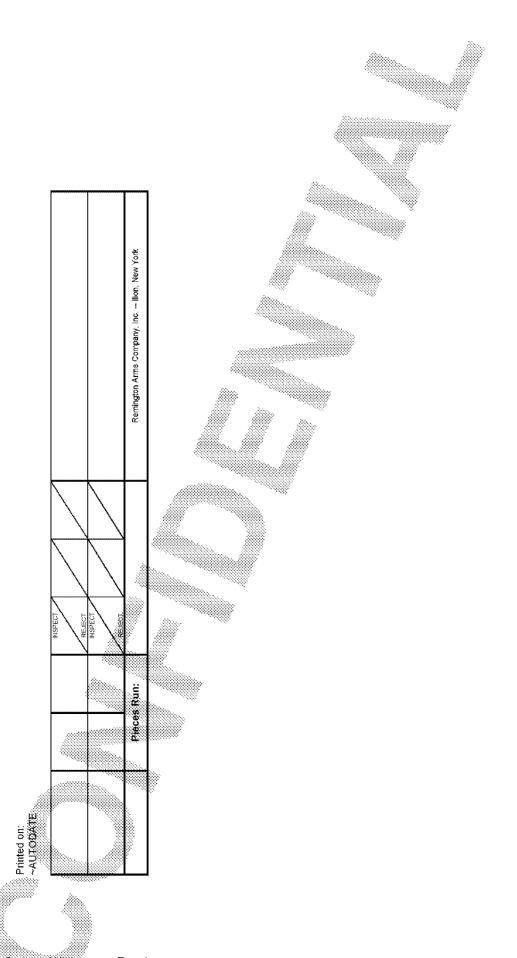Tool Number   Tooling Description

STD.   PAN 6"X3"X2"

Std.   Machine-Electr-Matic Type A13

PROCESS CONTROL INSPECTION RECORD THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES	Revision Date: 29-Nov-05	Processed by:

Printed on:
~AUTODATE

Part No:	Part Name:	Trig Assy 7 700		Centerfire Rifle		Date:	8/14/2006
Operation No: 140	Operation:	Demagnetize Springs				Work Center:	
Prod. Qty.	Prod. Order #			Operator		Setup Inspected by & Date:	
Gage Description and Characteristic	Gage Number	Gage Frequency	1st Shift	2nd Shift	3rd Shift	Remarks, Causes, Action Taken, Etc.	
VISUAL	VISUAL	100%	INSPECT / REJECT				
			INSPECT / REJECT				
			INSPECT / REJECT				
			INSPECT / REJECT				
			INSPECT / REJECT				
			INSPECT / REJECT				
			INSPECT / REJECT				
			INSPECT / REJECT				
			INSPECT / REJECT				
			INSPECT / REJECT				

				INSPECT			
		Pieces Run:		REJECT	INSPECT		Remington Arms Company, Inc. -- Ilion, New York
					REJECT		

Printed on:
~AUTODATE

143   **Clean Trigger Housing Assembly and apply rust preventative.**

Step   Operation / Step Description

Clean Trigger Housing Assembly and apply rust preventative.

Procedure:

1. Load parts

     a) Receive trigger housings from crib #29.

     b) Gently load trigger housings from pan into expanded metal basket.

     c) Truck basket of housings to dept. 8551.

     d) Place basket of housings in the PROCECO washer. Remember to place
        wire cover over basket. Washer has enough force to blow parts
        out.

2. Set wash time – 2 min.

3. Set rinse time – 2 min.

4. Start Cycle

5. Transfer Parts to dryer

6. Set Temperature to 350 deg. F

Printed on:
~AUTODATE

7. Dry time – 20 min.

8. Check housings carefully, and be sure they are clean and dry.
   If necessary, use shop air to blow off housings. Always aim air
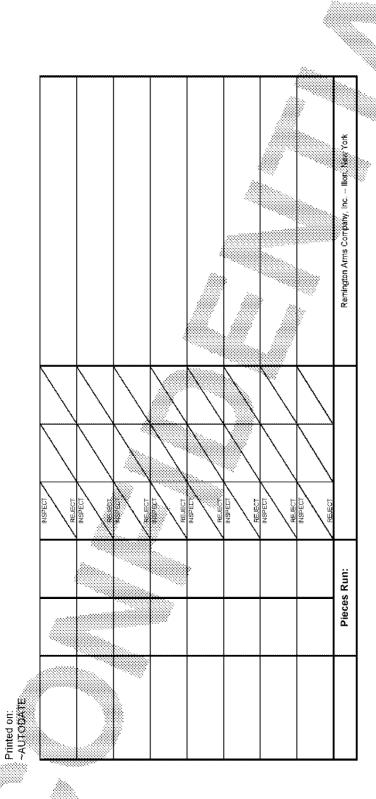   flow into recepticles, never into the general atmosphere.

Tool Number	Tooling Description
STD.	PROCECO Wash Unit Model #AP-24-24-S-300-2
Std.	WINTECH 295 Rust Protector

PROCESS CONTROL INSPECTION RECORD THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES		Revision Date: **29-Nov-05**			Processed by:	
Part No:	Part Name: Trig Assy 7 700	Centerfire Rifle			Date: 8/14/2006	
Operation No: 143	Operation: Clean Trigger Housing Assembly and apply rust preventative.				Work Center:	
Prod. Qty:	Prod. Order #:	**Operator**			Setup inspected by & Date:	
Gage Description and Characteristic	Gage Number	Gage Frequency	**1st Shift**	**2nd Shift**	**3rd Shift**	Remarks, Causes, Action Taken, Etc.
VISUAL	VISUAL	100%	INSPECT / REJECT			
			INSPECT / REJECT			
			INSPECT / REJECT			
			INSPECT / REJECT			

Printed on:
~AUTODATE

	INSPECT	REJECT	INSPECT	REJECT	INSPECT	REJECT	INSPECT	REJECT	INSPECT	REJECT	INSPECT	REJECT	INSPECT	REJECT	INSPECT	REJECT

Pieces Run:

Remington Arms Company, Inc. -- Ilion, New York

Printed on:
~AUTODATE

145   Tap (3) Holes in Trigger Housing

    Step   Operation / Step Description

        Tap (3) Holes in Trigger Housing

    Tool Number   Tooling Description

STD   2 Flute #6-40 NF-GH2 H.S. Cobalt Tap

STD   Pneumatic Bench Top Tapper

PROCESS CONTROL INSPECTION RECORD THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES			Revision Date: 29-Nov-05			Processed by:	
Part No:	Part Name:	Trig Assy 7 700		Centerfire Rifle		Date:	8/14/2006
Operation No: 145	Operation:	Tap (3) Holes in Trigger Housing				Work Center:	
Prod. Qty:	Prod. Order #:		**Operator**			Setup inspected by & Date:	
Gage Description and Characteristic	Gage Number	Gage Frequency	**1st Shift**	**2nd Shift**	**3rd Shift**	Remarks, Causes, Action Taken, Etc.	
VISUAL	VISUAL	100%	INSPECT / REJECT				
			INSPECT / REJECT				

Printed on:
~AUTODATE

INSPECT	REJECT	INSPECT	REJECT	INSPECT	REJECT	INSPECT	REJECT	INSPECT	REJECT	INSPECT	REJECT	INSPECT	REJECT

Pieces Run:

Remington Arms Company, Inc. -- Ilion, New York

Printed on:
~AUTODATE

147   Chase Threads and Ream Ball Hole

   Step   Operation / Step Description

          Chase Threads and Ream Ball Hole

          Procedure:
          1. Chase Threads in Trigger Stop Screw Hole

          2. Chase Threads in Engagement Screw Hole

          3. Chase Threads in Field Adjustment Screw Hole

          4. Ream Field Adjustment Screw Hole

          5. Ream Trigger Ball Screw Hole

     Tool Number   Tooling Description

   STD   2 Flute #6-40 NF-GH2 H.S. Cobalt Tap

   STD   .1425 DIA REAMER

   STD   Pneumatic Bench Top Tapper

   C-90059-R   HSS TAP #8-36 NF-2

Printed on:
~AUTODATE

PROCESS CONTROL INSPECTION RECORD		Revision Date:		Processed by:	
THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES			29-Nov-05		
Part No:	Part Name: Trig Assy 7 700	Centerfire Rifle		Date:	8/14/2006
Operation No: 147	Operation: Chase Threads and Ream Ball Hole			Work Center:	

Prod. Qty:	Prod. Order #		Operator			Setup Inspected by & Date:
Gage Description and Characteristic	Gage Number	Gage Frequency	1st Shift	2nd Shift	3rd Shift	Remarks, Causes, Action Taken, Etc.
VISUAL	VISUAL	100%	INSPECT / REJECT			
			INSPECT / REJECT			
			INSPECT / REJECT			
			INSPECT / REJECT			
			INSPECT / REJECT			
			INSPECT / REJECT			
			INSPECT / REJECT			
			INSPECT / REJECT			
			INSPECT / REJECT			

Printed on: ~AUTODATE

INSPECT	REJECT	INSPECT	REJECT
INSPECT	REJECT		

Pieces Run:

Remington Arms Company, Inc. -- Ilion, New York

151   Assemble Trigger Assembly - Stage One -
             Inspect Connector 100% - Inspect Trigger 100%
             and Check Connector to Trigger Fit 100%

Operation Step Detail   Operation: 151

Step   Operation / Step Description

Assemble Trigger Assembly - Stage One
Inspect Connector 100%, inspect Trigger 100% and check Connector to
Trigger fit 100%.

<u>*** See Sketch ***</u>

          NOTE: Do all elements 100%

1.   Inspect long inside Connector surface, and inside surface of long
     (top) leg for flatness.

     Hold Connector against flatness block with light finger pressure.

     * If no light shows between inside surfaces of back and long leg
       of Connector and block surface, Connector is good.

     (See Figure #1)

     * If light gap shows, measure gap with a .006 shim.   If gap accepts
       shim without moving Connector - Reject Connector.   (See Fig. #2)

          * Note : .006 Shim - Make new shim as required

* If Connector rocks on flatness block - reject Connector. (See Fig. #3)

* Front edge of long (top) leg, must be square with shoulder of flatness block. (See Fig. #4)

2. Polish Connectors

        Surface must be:
        *   Smooth
        *   Burr - Free at top and bottom corners and hole.
        *   Dead flat within 1/32" (Minimum of end)

    Check for burrs and smoothness with fingertip.

3. INSPECT TRIGGER.

    Trigger Must Have:
    *   Uniform Metallic Satin Finish and Color.
    *   No bleed out (white material on surface)
    *   No burrs
    *   No cracks or damage at pivot hole.

4. Fit passed Connector to passed Trigger and check for MIN. WORKING CLEARANCE. (Slip Fit)

    *   Connector must rotate freely around bottom (short) leg, without binding on top of Trigger.

            *   Ref. Sketch # 151-2

    *   If additional clearance is needed, file bottom notch on Trigger. Filed surface must be FLAT and SQUARE with sides of trigger. Use filing fixture only. DO NOT FILE FREE HAND.

Printed on:
~AUTODATE

5. With the same Trigger and Connector, check for Max. Working
   clearance.

   * Push Connector tight to Trigger at bottom, and hold it
     parallel to sides of Trigger.

   * Insert shim stock in clearance from back to front.

     * .006 shim MUST NOT GO

   * If shim enters without moving Connector SCRAP TRIGGER.

   * Keep trigger and connector together in container ready for
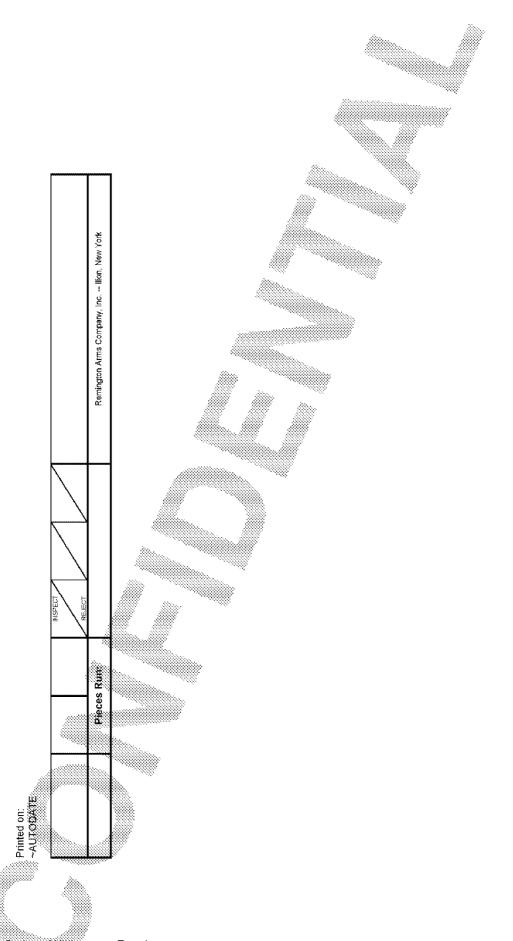   Stage Two.

     * Ref. Sketch 151-3

Operation Tool Detail   **Operation: 151**

   Tool Number   Tooling Description

   D-44608   File Fixture
   C-44604   Flatness Block

PROCESS CONTROL INSPECTION RECORD THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES		Revision Date: 29-Nov-05		Processed by:
Part No:	Part Name: Trig Assy 7 700	Centerfire Rifle		Date: 8/14/2006
Operation No: 151	Operation: Assemble Trigger Assembly - Stage One -			Work Center:

Gage Description and Characteristic	Prod. Qty.	Prod. Order #	Gage Number	Gage Frequency	Operator			Setup inspected by & Date.
					1st Shift	2nd Shift	3rd Shift	Remarks, Causes, Action Taken, Etc.
VISUAL			VISUAL	100%	INSPECT			
					REJECT			
					INSPECT			
					REJECT			
					INSPECT			
					REJECT			
					INSPECT			
					REJECT			
					INSPECT			
					REJECT			
					INSPECT			
					REJECT			
					INSPECT			
					REJECT			
					INSPECT			
					REJECT			
					INSPECT			
					REJECT			
					INSPECT			
					REJECT			

	Pieces Run		INSPECT			REJECT	Remington Arms Company, Inc. -- Ilion, New York

Printed on:
~AUTODATE

154   Assemble Trigger Assembly - Stage Two

Step   Operation / Step Description

2. Inspect Trigger Housing:

    * Black color
    * No bleedout (White Material)
    * Check inside Housing - No burrs at holes.
    * Clean and free of excess oil and foreign material.
    * Parts should have a light coating of "GEO GUARD" and be free of
       foreign material.

3. Position Trigger in Housing and install Trigger Pin:
        * See Sketch *****
    * Use fixture B-37211 to hold Housing.
    * While holding the Connector on the Trigger in the assembled pos-
       ition(see sketch#151-3), dip the long leg of the Connector and
       top of the Trigger into Molykote powder, dry, Type "Z".
    * Use Pin holding punch A-35645 to start the Trigger Pivot Pin
       in the housing after locating Trigger and Connector.
    * Assemble Trigger and Connector into the Housing by driving the
       Pin by hammer until it is flush to the Housing on the Safety
       detent side.
    * Grip Trigger and rotate housing around Trigger Pin.
       Trigger must rotate freely in housing without bind.   +

4. Install:

Printed on:
~AUTODATE

*** See Sketch ***
* Trigger Stop Screw - Flush with hole.
* Trigger Spring.
* Trigger Screw Front - Flush with hole or below.
  (There must be spring force on Connector
  while adjusting Trigger Engagement Screw.)
* Trigger Engagement Screw - flush with hole.
  Screw should have been precoated with loctite sealant
  before assembly - see PROCEDURE.

PROCEDURE FOR COATING TRIGGER ENGAGEMENT SCREW WITH LOCTITE SEALANT:

1. Place approximately 1000 clean, dry screws in a plastic bag.
2. Pour sufficient loctite sealant into bag to evenly coat screws
    with a thin film of sealant.
3. Agitate bag by hand to coat all screws.
4. Visually inspect screws to see if coating is adequate. Remove
    5 coated screws from the bag and compare to a dry uncoated
    screw under a 5X magnifying lamp:
    a) All threads must be entirely coated with Loctite.
    b) Threads should not be dripping excess Loctite.
    c) Threads should not be filled completely from the base(root)
        of the thread to the top(O.D.) of the thread.
5. If screws are not entirely coated;
    a) After full agitation(determined by the visual inspection),
        add more sealant to the bag of screws and re-agitate.
    b) If screws have excess coating of Loctite after full agita-
        tion, add more screws to the bag and re-agitate.
    c) Visually inspect in the same way indicated in step 4 after
        any re-agitation.

Screws may be used immediately or stored if required. The Loctite
sealant is anaerobic and will only dry in the absence of air.

Printed on:
~AUTODATE

5. Install Sear Spring and *Sear Safety Cam using Two Dummy Pins.
   *** See Sketch ***
   * Use drop gauge C-44522 to inspect for straightness.
     Any sear safety cams that do not pass through the gauge are to
     be scrapped.
   * Visually inspect Sear Safety Cam. This must have a sharp,
     burr-free, square edge at the connector contact surface.(Look
     for a sharp ground surface on the verticle side of this edge.)
   * Depress Sear Safety Cam - must move freely.
   * Sear must not have dimple.

      * Sear Safety Cam - Part #15666 does not have a recessed
        dimple.

Tool Number	Tooling Description
B-37211	Housing Fixture
A-35645	Pin Holder Drive Punch
A-51468	Dummy Pins
Std.	5X magnifying fluorescent lamp
Std.	Hammer - Stanley Compo-Cast 8oz.
C-44522-A	Drop Guage for Sear Safety Cam Width

PROCESS CONTROL INSPECTION RECORD THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES	Revision Date: 29-Nov-05	Processed by:
Part No:	Part Name: Trig Assy 7 700	Centerfire Rifle	Date: 8/14/2006

Printed on:
~AUTODATE

Operation No: 154	Operation:	Assemble Trigger Assembly - Stage Two				Work Center:
Prod. Qty:	Prod. Order #:		Operator			Setup inspected by & Date:
Gage Description and Characteristic	Gage Number	Gage Frequency	1st Shift	2nd Shift	3rd Shift	Remarks, Causes, Action Taken, Etc.
VISUAL	VISUAL	100%	INSPECT / REJECT			
			INSPECT / REJECT			
			INSPECT / REJECT			
			INSPECT / REJECT			
			INSPECT / REJECT			
			INSPECT / REJECT			
			INSPECT / REJECT			
			INSPECT / REJECT			
			INSPECT / REJECT			
			INSPECT / REJECT			

Printed on:
~AUTODATE

Pieces Run:

INSPECT REJECT INSPECT REJECT

Remington Arms Company, Inc. -- Ilion, New York

Printed on:
~AUTODATE

155   Assemble Trigger Assembly - Stage Two
           Check for Burrs and Polish 100 %

Operation Step Detail   Operation: 154

Step   Operation / Step Description

                        *** See Sketch ***
                        *** See Sketch ***
                        *** See Sketch ***

Assembly Trigger Assembly - Stage Two

1. Inspect Trigger Housing:

    * Uniform Metalic Satin Finish and Color
    * No bleedout (White Material)
    * Check inside Housing - No burrs at holes.
    * Clean and free of excess oil and foreign material.

2. Position Trigger in Housing and install Trigger Pin:

    * Apply Dry Molykote to long leg of connector
            * Molykote Powder - Dry type " Z "
    * Pin must be flush to housing on right side, left side
       for left hand.
    * Grip Housing and rotate Trigger around Trigger Pin.
       Trigger must rotate freely under its own weight.
    * Use fixture B-37211

Printed on:
~AUTODATE

3. Install:

* Same Connector as fitted to Trigger (Op. #151)
* Trigger Stop Screw #14633 (Dwg. A-14633)
* Trigger Spring #14635 (Dwg. A-14635)
* Trigger Spring Front #14634 (Dwg. A-14634)
* Trigger Screw Front #90568 (Dwg. B-90568)
* Trigger Ball #23223 (Dwg. B-23220)
* Trigger Engagement Screw #91128 (Dwg. B-91128)

4. Install Sear Spring and *Sear Safety Cam using Two Dummy Pins.

* Polish Sear pad - Must be flat and have surface finish of 16 um or better

        Surface must be:
        * Smooth
        * Burr - Free at top and bottom corners and hole.
        * Dead flat within 1/32" (Minimum of end.

    Check for burrs and smoothness with fingertip.

* Use drop gauge C-44522 to inspect for straightness.
  Any sear safety cams that do not pass through the gauge are to
  be scrapped.
* Visually inspect Sear Safety Cam. This must have a sharp,
  burr-free, square edge at the connector contact surface.(Look
  for a sharp ground surface on the verticle side of this edge.)
* Depress Sear Safety Cam - must move freely
* Sear must not have dimple.

    * Sear Safety Cam - Part #15666 does not have a recessed
      dimple.

5. Adjust trigger pull by turning Trigger Adjusting Screw slowly

Printed on:
~AUTODATE

counter-clockwise until Sear just disengages (fires).

6. Check For Adjustability
    To ensure that the spring and ball are not restricted
    Turn Trigger Adjusting Screw clock-wise and repeat step #5

    * Adjust Trigger Assy. in Comparator Fixture dead weight Equivelent
      as required to meet Final Inspection Requirements of 2.5 - 3.5 lbs.

7. Adjust Overtravel and Connector engagement to .018 to .020
    Ensure there is NO creep

8. Hold Trigger in fired position firmly with finger and:

    * Set OVER-TRAVEL by turning Trigger Stop Screw SLOWLY CLOCKWISE,
      until Trigger Connector touches correct line in comparator
      screen.

9. Prick punch Housing at Trigger Screw Front & glue Trigger Engagement
    Screw and Trigger Stop Screw.

10. Prick punch Housing at Front Ball Hole

Operation Tool Detail   Operation: 155

Tool Number	Tooling Description
A-35645	Pin Holder Drive Punch
A-51468	Dummy Pins
B-37211	Housing Fixture
Std.	5X magnifying fluorescent lamp
Std.	Hammer - Stanley Compo-Cast 8oz.
c-44522-A	Drop Gage for Sear Safety Cam Width
Std.	Deltronics Comparator 14" (50x)

Printed on:
~AUTODATE

L-42271   Comparator Fixture
C-700-CL-170   Comparator Screen

PROCESS CONTROL INSPECTION RECORD THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES				Revision Date: **29-Nov-05**			Processed by:	
Part No:	Part Name: Trig Assy 7 700			Centerfire Rifle			Date:	8/14/2006
Operation No: 155	Operation: Assemble Trigger Assembly - Stage Two						Work Center:	
Prod. Qty:	Prod. Order #:			**Operator**			Setup inspected by & Date:	
Gage Description and Characteristic	Gage Number	Gage Frequency	1st Shift	2nd Shift	3rd Shift		Remarks: Causes, Action Taken, Etc.	
VISUAL	VISUAL	100%	INSPECT REJECT					
Drop Gage for Sear Safety Cam Width	c-44522-A	100%	INSPECT REJECT					
			INSPECT REJECT					
			INSPECT REJECT					
			INSPECT REJECT					
			INSPECT REJECT					
			INSPECT REJECT					

Printed on:
~AUTODATE

INSPECT	REJECT	INSPECT	REJECT	INSPECT	REJECT	INSPECT	REJECT

Pieces Run:

Remington Arms Company, Inc. – Ilion, New York

Printed on:
~AUTODATE

158   Adjust Trigger Assembly on Comparator 100%

Step   Operation / Step Description

* Align set edge on master (E-42271-A) to horizontal centerline on comparator
  screen C-700-CL-170.

Adjust Trigger Assembly on Comparator 100~

1. Pick Trigger Sub-Assembly. Position in comparator fixture
    and clamp:

    * Housing must properly contact all locators.
    * Top of Housing must be flat on fixture.
    * Push with thumb on rear of Trigger (toward left)
      This seats Trigger firmly against end of Trigger Adjusting
      Screw.

2. Adjust fixture to locate Sear on "set" line of comparator screen.

3. Adjust Sear/Connector engagement (.018 - .020), to correct
    comparator screen line by turning Trigger Engagement Screw
    SLOWLY CLOCKWISE (to reduce engagement).

    * Trigger must fall within min./max. trigger lines on comparator screen.

         AFTER CORRECTLY ADJUSTING SEAR/CONNECTOR ENGAGEMENT

4. Hang dead weight roller assembly in radius of trigger.

Printed on:
~AUTODATE

5. Adjust trigger pull by turning Trigger Adjusting Screw slowly counter-clockwise until Sear just disengages (fires).

   Comparator fixture dead weight - 4.5 lbs.
   (NOTE: Use this spec as a general guide and adjust as needed to satisfy the finished rifle spec.)

6. Remove dead weight assembly from Trigger.

7. Hold Trigger in fired position firmly with finger and:

   * Set OVER-TRAVEL by turning Trigger Stop Screw SLOWLY CLOCKWISE, until Trigger Connector touches correct line in comparator screen.

8. Remove Trigger Sub-Assembly from comparator fixture.

9. Seal all three screws with "Duco" Cement, including screw slots.

Tool Number	Tooling Description
Std.	Deltronics Comparator 14" (50x)
E-42271	Comparator Fixture
E-42271-A	Set block
C-700-CL-170	Comparator Screen

PROCESS CONTROL INSPECTION RECORD THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES	Revision Date: **29-Nov-05**	Processed by:
Part No:	Part Name: Trig Assy 7 700	Centerfire Rifle	Date: 8/14/2006
Operation No: 158	Operation: Adjust Trigger Assembly on Comparator 100%	Work Center:

Prod. Qty.	Gage Description and Characteristic	Prod. Order #	Gage Number	Gage Frequency	Operator			Setup inspected by & Date.
					1st Shift	2nd Shift	3rd Shift	Remarks, Causes, Action Taken, Etc.
	VISUAL		VISUAL	100%	INSPECT / REJECT			
					INSPECT / REJECT			
					INSPECT / REJECT			
					INSPECT / REJECT			
					INSPECT / REJECT			
					INSPECT / REJECT			
					INSPECT / REJECT			
					INSPECT / REJECT			
					INSPECT / REJECT			
					INSPECT / REJECT			

Pieces Run	INSPECT	REJECT			Remington Arms Company, Inc. – Ilion, New York

160   Assemble Trigger Assembly - Stage Three

*** See Sketch for 700 RH ***
*** See Sketch for 700 LH ***
*** See Sketch for 7 LW ***

Step   Operation / Step Description

Assemble Trigger Assembly - Stage Three

1. Pick correctly adjusted Trigger Sub-Assembly.

2. Assemble:

    Bolt Stop Release - Do not use twisted or bent parts.
    File inside surface flat if necessary.
    Safety Assembly - Check minimum width of "U" bend between safety arm
                      and cam with .140" plug, 100%.
                    - While holding the safety assembly by the safety
                      arm button, dip the "U" bend of the safety
                      assembly into Molykote powder, dry, Type "Z".

    Safety Detent Ball - Visually inspect ball for flats or mars on
                         ball surface.
                       - Check to make sure Safety Detent Ball slides
                         freely through mating hole in safety assembly.

    Safety Detent Spring - Visually check for the presence of 2 dimples.

Printed on:
~AUTODATE

Safety Pivot Pin

Safety Snap Washer.

    A) Orient the Snap Washer such that the notched side of the Pivot
       Pin channel is on the left after assembly. This places the die
       break on the under side of the Snap Washer.(See sketch #160.)

    B) When assembling SAFETY SNAP WASHER to PIVOT PIN, make sure the
       SNAP WASHER is in the GROOVE on the PIVOT PIN before sliding it
       into position. If the SNAP WASHER rides out of groove and
       becomes distorted remove and discard.

    C) Safety Snap Washer MUST be completely contained within Pivot
       Pin Groove.

    D) Both raised dimples on Safety Detent Spring must be within
       opening of Safety Snap Washer

3. Push Bolt Stop Release up and down to ends of Travel several times.

    * Bolt Stop Release must move smoothly and freely without bind.

4. Place assemblies in tray.

Tool Number   **Tooling Description**

Std   .140 Plug gage

Printed on:
~AUTODATE

PROCESS CONTROL INSPECTION RECORD THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES			Revision Date:		29-Nov-05	Processed by:	
Part No:	Part Name:	Trig Assy 7 700	Centerfire Rifle			Date:	8/14/2006
Operation No: 160	Operation:	Assemble Trigger Assembly - Stage Three				Work Center:	
Prod. Qty:	Prod. Order #		**Operator**			Setup Inspected by & Date:	
Gage Description and Characteristic	Gage Number	Gage Frequency	1st Shift	2nd Shift	3rd Shift	Remarks, Causes, Action Taken, Etc.	
VISUAL	VISUAL	100%	INSPECT / REJECT				
.140 Plug gage	Std	100%	INSPECT / REJECT				
			INSPECT / REJECT				
			INSPECT / REJECT				
			INSPECT / REJECT				
			INSPECT / REJECT				
			INSPECT / REJECT				
			INSPECT / REJECT				
			INSPECT / REJECT				

Printed on:
~AUTODATE

INSPECT	REJECT	INSPECT	REJECT	INSPECT	REJECT

Pieces Run

Remington Arms Company, Inc. -- Ilion, New York

CONFIDENTIAL

165   Function Check Complete Trigger Assembly 100%

Step   Operation / Step Description

Function check completed Trigger Assembly 100%

    NOTE: Do Steps 1&2 100%

1. Put Safety in "OFF SAFE" position.

    Check for:

    TRIGGER RETRACTION
    Pull Trigger and release:

    * Trigger and Connector must return freely to original position
      WITH SPRING FORCE.

    SEAR FREEDOM
    Pull Trigger and hold. Depress Sear FULLY and release:

    * Sear must move freely in housing without binding. The Sear
      must return upward under Sear Spring force.

2. Operation of Safe

    Push Safety Thumb Piece fully forward beyond detent position:

    * Safety must spring-return rearward to detent position.

Printed on:
~AUTODATE

Push Safety Thumb Piece fully rearward beyond detent position:

* Safety must spring-return 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.

* There must be no hang-up or hesitation between detent positions.

3. Check Sear Lift

    - check 10~ per tray, if any are found out of spec then check entire tray 100%.

Sear lift must be between .008 min and .018 max.

* Place Trigger Assembly in gage, pump locating pins into position and clamp.
  Zero the dial and pull safety to "On" or "S" position and read dial.

Tool Number   **Tooling Description**

D-42614   Dial Base Gage - "Sear Lift"   .008 to .018

PROCESS CONTROL INSPECTION RECORD THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES		Revision Date: **29-Nov-05**		Processed by:
Part No:	Part Name: Trig Assy 7 700	Centerfire Rifle		Date: 8/14/2006
Operation No: 165	Operation: Function Check Complete Trigger Assembly 100%			Work Center:
Prod. Qty.	Prod. Order #:	**Operator**	Setup inspected by & Date:	

Printed on:
~AUTODATE

Gage Description and Characteristic	Gage Number	Gage Frequency	1st Shift	2nd Shift	3rd Shift	Remarks, Causes, Action Taken, Etc.
VISUAL	VISUAL	100%	INSPECT REJECT			
Dial Base Gage - "Sear Lift" .008 to .018	D-42614	100%	INSPECT REJECT			
			INSPECT REJECT			
			INSPECT REJECT			
			INSPECT REJECT			
			INSPECT REJECT			
			INSPECT REJECT			
			INSPECT REJECT			
			INSPECT REJECT			
			INSPECT REJECT			
			INSPECT REJECT			

Printed on:
~AUTODATE

Pieces Run:		Remington Arms Company, Inc. -- Ilion, New York

Printed on:
~AUTODATE

170   Mark Correctly Assembled, Adjusted and Checked
        Trigger Assembly with Assemblers Identification
                    To MRP Crib #29

Step   Operation / Step Description

        *** See Sketch ***

Mark correctly assembled, adjusted and checked Trigger Assembly, with
Assembler's Identification.

1. Locate trigger assembly on stamping fixture.

2. Stamp lower left corner (as shown) with correct Assemblers
    Identification.

    * Holding block for stamp B-53512
    * Use 1/16" size character

PROCESS CONTROL INSPECTION RECORD THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES			Revision Date:	29-Nov-05		Processed by:	
Part No:	Part Name:	Trig Assy 7 700	Centerfire Rifle			Date:	8/14/2006
Operation No: 170	Operation:	Mark Correctly Assembled, Adjusted and Checked				Work Center:	
Prod. Qty:	Prod. Order #:		Operator			Setup Inspected by & Date:	
Gage Description and Characteristic	Gage Number	Gage Frequency	1st Shift	2nd Shift	3rd Shift	Remarks, Causes, Action Taken, Etc.	

Printed on: ~AUTODATE

VISUAL	VISUAL 100%	INSPECT	REJECT	INSPECT	REJECT	INSPECT	REJECT	INSPECT	REJECT	INSPECT	REJECT	INSPECT	REJECT	INSPECT	REJECT	INSPECT	REJECT	INSPECT	REJECT	INSPECT	REJECT

Pieces Run:

Remington Arms Company, Inc. -- Ilion, New York

Printed on:
~AUTODATE

175R   Repair Rejected Trigger Assemblies

Step   Operation / Step Description

Repair Rejected Trigger Assemblies

NOTE: Each repair Trigger Assembly is to go to Assembler who
        originally built it.

1. Make corrections as required.
   Disassemble and scrap all questionable parts.

   Note: If part of the repair sequence involves removal of the
         SAFETY SNAP WASHER discard washer after removal and
         replace with NEW SAFETY SNAP WASHER.

2. Return Trigger Assembly to process at point where it will
   again receive all applicable adjustments and function checks.

PROCESS CONTROL INSPECTION RECORD THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES	Revision Date:	29-Nov-05		Processed by:	
Part No:	Part Name: Trig Assy 7 700	Centerfire Rifle		Date: 8/14/2006	
Operation No: 175R	Operation: Repair Rejected Trigger Assemblies			Work Center:	
Prod. Qty:	Prod. Order #:	Operator		Setup Inspected by & Date:	
Gage Description and Characteristic	Gage Number	Gage Frequency	1st Shift	2nd Shift	3rd Shift	Remarks, Causes, Action Taken, Etc.

Printed on: ~AUTODATE

VISUAL

VISUAL | 100%

INSPECT | REJECT | INSPECT | REJECT | INSPECT | REJECT | INSPECT | REJECT | INSPECT | REJECT | INSPECT | REJECT | INSPECT | REJECT | INSPECT | REJECT | INSPECT | REJECT | INSPECT | REJECT | INSPECT | REJECT

Pieces Run:

Remington Arms Company, Inc. -- Ilion, New York

Dept	Oper	Operation Description	Part Numbers		
9132	1	Issue from Crib	26345	32895	92458
			202446	27591	
8773	140	Demagnetize Springs	92458	26345	32895
			202446	27591	
8773	143	Clean Trigger Housing Assembly and apply rust preventative.	92458	26345	32895
			202446	27591	
8773	145	Tap Hole in Trigger Housing	92458	26345	32895
8773	147	Chase Threads and Ream Ball Hole	202446	27591	
8773	151	Assemble Trigger Assembly - Stage One Inspect Connector 100% - Inspect Trigger 100% and Check Connector to Trigger Fit 100%	92458	26345	32895
			202446	27591	
8773	154	Assemble Trigger Assembly - Stage Two	92458	26345	32895
8773	155	Assemble Trigger Assembly - Stage Two	202446	27591	
8773	158	Adjust Trigger Assembly on Comparator 100%	92458	26345	32895
8773	160	Assemble Trigger Assembly - Stage Three	92458	26345	32895
			202446	27591	
8773	165	Function Check Complete Trigger Assembly 100%	92458	26345	32895
			202446	27591	
8773	170	Mark Correctly Assembled, Adjusted and Checked Trigger Assembly with Assemblers Identification To MRP Crib #29	92458	26345	32895
			202446	27591	
8773	175R	Repair Rejected Trigger Assemblies	92458	26345	32895
			202446	27591	

ILE00076521

Dept	Oper	Operation Description	Part Numbers

Printed on:
~AUTODATE

Dept	Oper	Operation Description	Part Numbers

Printed on:
~AUTODATE

Dept	Oper	Operation Description	Part Numbers

Printed on:
~AUTODATE

Dept	Oper	Operation Description	Part Numbers

Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
							92458 Trigger Assembly - 7
							26345 TRIGGER ASSEMBLY - 700
							32895 TRIGGER ASSEMBLY - 700 LH
							202446 Trigger Assembly - XR-100
							27591 Trigger Assembly - XR-100P
92458							Trigger Assembly - 7
		91828	150	160	1		Bolt Stop Release
		91853	160	160	1		Safety Assembly
		23222	110	160	1		Safety Detent Ball
		15368	20	140	1		Safety Detent Spring
		17043	60	160	1		Safety Pivot Pin
		17044	70	160	1		Safety Snap Washer
		15666	50	154	1		Sear Safety Cam
		17047	80	140	1		Sear Spring
		109835	10	151	1		Trigger
		17053	90	154	1		Trigger Screw Front
		19461	100	151	1		Trigger Connector
		91128	140	154	1		Trigger Engagement Screw
		26655	130	151	1		Trigger Housing Assembly
		202540	120	154	1		Trigger Pin
		15400	30	140	1		Trigger Spring
		15461	40	154	1		Trigger Stop Screw
26345							TRIGGER ASSEMBLY - 700
		15478	40	160	1		Bolt Stop Release
		92297	160	160	1		Safety Assembly
		23222	120	160	1		Safety Detent Ball
		15368	20	140	1		Safety Detent Spring
		17043	70	160	1		Safety Pivot Pin
		17044	80	160	1		Safety Snap Washer
		15666	60	154	1		Sear Safety Cam
		17047	90	140	1		Sear Spring
		109835	10	151	1		Trigger
		17053	100	154	1		Trigger Screw Front
		19461	110	151	1		Trigger Connector
		91128	150	154	1		Trigger Engagement Screw
		26655	140	151	1		Trigger Housing Assembly
		202540	130	154	1		Trigger Pin
		15400	30	140	1		Trigger Spring
		15461	50	154	1.000		Trigger Stop Screw

ILE00076526

Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
32895							TRIGGER ASSEMBLY 700 L.H.
		90555	130	160	1.000		Bolt Stop Release
		92296	150	160	1.000		Safety Assembly
		23222	100	160	1.000		Safety Detent Ball
		92546	160	140	1.000		Safety Detent Spring
		17043	50	160	1.000		Safety Pivot Pin
		17044	60	160	1.000		Safety Snap Washer
		15666	40	154	1.000		Sear Safety Cam
		17047	70	140	1.000		Sear Spring
		109835	10	151	1.000		Trigger
		17053	80	154	1.000		Trigger Screw Front
		19461	90	151	1.000		Trigger Connector
		91128	140	154	1.000		Trigger Engagement Screw
		32905	120	151	1.000		Trigger Housing Assembly
		202540	110	154	1.000		Trigger Pin
		15400	20	140	1.000		Trigger Spring
		15481	30	154	1.000		Trigger Stop Screw
202446							Trigger Assembly - XR-100
		91828	150	160	1		Bolt Stop Release
		91853	160	160	1		Safety Assembly
		23222	110	160	1		Safety Detent Ball
		15368	20	140	1		Safety Detent Spring
		17043	60	160	1		Safety Pivot Pin
		17044	70	160	1		Safety Snap Washer
		15666	50	155	1		Sear Safety Cam
		17047	80	140	1		Sear Spring
		109835	10	151	1		Trigger
		23223	170	155	1		Trigger Ball Front
		19461	180	151	1		Trigger Connector
		91128	140	155	1		Trigger Engagement Screw
		30785	130	151	1		Trigger Housing Assembly
		202540	120	155	1		Trigger Pin
		13753	90	155	1		Trigger Screw Front
		14688	30	140	1		Trigger Spring
		14634	100	140	1		Trigger Spring Front
		14633	40	155	1		Trigger Stop Screw
27591							Trigger Assembly - XR-100
		15478	150	160	1		Bolt Stop Release
		92297	160	160	1		Safety Assembly
		23222	110	160	1		Safety Detent Ball
		15368	20	140	1		Safety Detent Spring
		17043	60	160	1		Safety Pivot Pin
		17044	70	160	1		Safety Snap Washer
		15666	50	155	1		Sear Safety Cam

Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
		17047	80	140	1		Sear Spring
		109835	10	151	1		Trigger
		23223	170	155	1		Trigger Ball Front
		19461	100	151	1		Trigger Connector
		91128	140	155	1		Trigger Engagement Screw
		30785	130	151	1		Trigger Housing Assembly
		202540	120	155	1		Trigger Pin
		13753	90	155	1		Trigger Screw Front
		14635	30	140	1		Trigger Spring
		14634	180	140	1		Trigger Spring Front
		14633	40	155	1		Trigger Stop Screw

Printed on:
~AUTODATE

Parent	Rv	Child	Fnd	Oper	Qty	UM	Description

Printed on:
~AUTODATE

Parent	Rv	Child	Fnd	Oper	Qty	UM	Description

ILE0007653C

Printed on:
~AUTODATE

Parent	Rv	Child	Fnd	Oper	Qty	UM	Description

Parent	Rv	Child	Fnd	Oper	Qty	UM	Description

Printed on:
~AUTODATE

Parent	Rv	Child	Fnd	Oper	Qty	UM	Description

Printed on:
~AUTODATE

Parent	Rv	Child	Fnd	Oper	Qty	UM	Description

Printed on:
~AUTODATE

Parent	Rv	Child	Fnd	Oper	Qty	UM	Description

ILE00076535

Printed on:
~AUTODATE

Parent	Rv	Child	Fnd	Oper	Qty	UM	Description

Parent	Rv	Child	Fnd	Oper	Qty	UM	Description

Parent	Rv	Child	Fnd	Oper	Qty	UM	Description

Printed on:
~AUTODATE

Parent	Rv	Child	Fnd	Oper	Qty	UM	Description

Parent	Rv	Child	Fnd	Oper	Qty	UM	Description

Parent	Rv	Child	Fnd	Oper	Qty	UM	Description

Parent	Rv	Child	Fnd	Oper	Qty	UM	Description

Printed on:
~AUTODATE

Parent	Rv	Child	Fnd	Oper	Qty	UM	Description

Parent	Rv	Child	Fnd	Oper	Qty	UM	Description

Parent	Rv	Child	Fnd	Oper	Qty	UM	Description

Printed on:
~AUTODATE

Parent	Rv	Child	Fnd	Oper	Qty	UM	Description

Parent	Rv	Child	Fnd	Oper	Qty	UM	Description

Parent	Rv	Child	Fnd	Oper	Qty	UM	Description

Date:	Reason for Revision:	Eng:	Log #:
23-Apr-01	Copied entire process from VAXcamps #303575.	RLJ	304220
4-Oct-01	Revised hanging weight specification in operation 155.	RLJ	305072
16-Mar-02	Added gage D-42614 to operation 165 for records.	RLJ	305776
14-Feb-03	Added OP #145 (Tap Hole) to reflect current process.	AFH	308577
13-Jul-04	202446 - Trigger Assembly - XR-100	GLC	312191
13-Jan-05	Trigger Pin p/n 202540 was 24477	AJL	313546
10-Feb-05	Added OP#143 Clean Trigger Housing Assembly and Apply Rust Preventative.	AJL	313561
11-Feb-05	Added Details to OP#143 and OP#145	AJL	313564
15-Feb-05	Op#143 Dept. 8772 was 8448	AJL	313842
15-Feb-05	Revised OP#143 Details, Added OP#147 Added Details to OP#151, Added OP#155 Changed Old OP#155 to OP#158	AJL	313843
17-Feb-05	Op#143 Dry Time was 2 min. Now 20 min.	AJL	313844
18-Feb-05	Added Trigger Pull Weight to OP#155	AJL	313845
19-Apr-05	XR-100 Replace Trigger with 109835 was 15280	ERF	311643
25-Apr-05	Op#143 Tap (3) Holes was Spring Hole only	AJL	313859
15-Sep-05	Material section: 202446 (XR-100) - changed trigger screw from 90568 to 13753 per DCR# 16011.	PJZ	314610
28-Oct-05	Added part #27591 per NPP #2005-ML73, DCR #16082.	MFS	315950
4-Nov-05	DEPT 8773 WAS 8772 FOR OP#140, 143, 145, 147, 151, 154, 155, 158, 160, 165, 170, & 175R	GLC	316017
29-Nov-05	Op. 158 - added Set Block E-42271-A and detail to "align set edge on master to horizontal centerline on comparator screen", & added detail in step #3 "trigger must fall	PJZ	316076

Date:	Reason for Revision:	Eng:	Log #:
	within min/max trigger lines on comparator screen." Op. 165 - added detail to step #3 to check sear lift 10% per tray, if any are found out of spec then check entire tray 100%.		

Printed on:
~AUTODATE

Date:	Reason for Revision:	Eng:	Log #:

Printed on:
~AUTODATE

Date:	Reason for Revision:	Eng:	Log #:

Dept	Num	Procedure by Steps	Safety Key Points

PROCESS CONTROL INSPECTION RECORD THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES			Revision Date:	29-Nov-05			Processed by:	
Part No:	Part Name:	Trig Assy 7 700		Centerfire Rifle			Date:	8/14/2006
Operation No. Part No:	Operation:	Part Name:					Work Center:	
Prod. Qty:	Prod. Order #:			Operator		Setup Inspected by & Date:		
Gage Description and Characteristic	Gage Number	Gage Frequency	1st Shift	2nd Shift	3rd Shift	Remarks, Causes, Action Taken, Etc.		
VISUAL	VISUAL	100%	INSPECT REJECT					
			INSPECT REJECT					
			INSPECT REJECT					
			INSPECT REJECT					
			INSPECT REJECT					
			INSPECT REJECT					
			INSPECT REJECT					
			INSPECT REJECT					
			INSPECT REJECT					
			INSPECT REJECT					

			INSPECT			
			REJECT			
			INSPECT			
			REJECT			
	Pieces Run:				Remington Arms Company, Inc. -- Ilion, New York	

Type "Ctrl+h" *from the desired destination* to insert this form. Execute *before* the next form below.

PROCESS CONTROL INSPECTION RECORD		Revision Date:	29-Nov-05	Inspected by:					
THIS RECORD MUST REMAIN IN HEAT TREAT INPSECTION FOR ONE YEAR		Part No:		Prod. Qty:		Production Order #:			
	Part Name:	Trig Assy 7 700		Centerfire Rifle					
Operation No: Part No:	Operation:	Part Name:			Work Center:		Inspec. Date:	8/14/2006	

Furnace and Load Number	Draw Temp	Furnace Date	Hardness Specification		Hardness Specification		Hardness Specificaton		Break Test
			HRc	INSPECT REJECT	H15n	INSPECT REJECT	H45n	INSPECT REJECT	INSPECT REJECT

HRc		H15n	H15n	H45n	Break Test Results (lbs)		
Tester No		Tester No	Tester No	Tester No			
35		60	81	37			
36		61	82	38			
37		62	83	39			
38		63	84	40			
39		64	85	41			
40		65	86	42			
41		66	87	43			
42		67	88	44			
43		68	89	45			
44		69	90	46	Sample Plan		
45		70	91	47	Lot	Sample	Allowable
46		71	92	48	Size	Size	Outside
47		72	93	49			
48		73	94	50	1-5	All	0
49		74	95	51	6 - 50	6	0
50		75	96	52	51 - 100	7	0
51		76	97	53	101 - 200	7	0
52		77	98	54	201- 800	16	1
53		78	99	55	801 - 3000	17	1
54		79	100	56	3001 - 20000	27	2

35	80	101	57	
				Rev 0

Type "Ctrl+r" *from the desired destination* **to insert this form. Execute** *after* **the HTPCIR above.**

```
PROCESS RECORD - HEAT TREAT SPECIFICATION
----------------------------------------------------------------
```

Process

```
          Material:
           Furnace:
              Rack:
      Maximum Load:

       Temperature:
         Soak Time:
          Carbon %:
            Quench:
              Wash:
             Notes:
```

Inpsection

```
          Hardness:


        Break Test:
        Color Only:
 Appearance of Parts:
```

CONFIDENTIAL

Unassigned Button Clicked

You have clicked a button that is not assigned to a process sheet

Click the button to return to the Header Sheet