Remington Arms Company, Inc.
Manufacturing Process Document

Document ID:	Trig Assy 700ML	**Effective Date:**	29-Nov-05
Product Line:	Centerfire Rifle	**Origination Date:**	8-Aug-95

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
Tap Hole in Trigger Housing
Inspect Connector 100% - Inspect Trigger 100%
Assemble Trigger Assembly - Stage Two
Adjust Trigger Assembly on Comparator 100%
No bolt release to be assembled for 700ML
Function Check Complete Trigger Assembly 100%
Trigger Assembly with Assemblers Identification
Repair Rejected Trigger Assemblies

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

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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 700ML			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			
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140 Demagnetize Springs

Operation Step Detail Operation: 140

Step Operation / Step Description

Demagnatize Springs

Procedure:
1. Place Sear Springs and Trigger Springs in separate non-metalic 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 Demagnatizer "OFF". Do not turn switch off with pan in contact with demagnetizer, " THIS MAY MAGNETIZE PARTS ".

Operation Tool Detail Operation: 140

Tool Number	Tooling Description
STD.	PAN 6"X3"X2"
Std.	Machine-Electr-Matic Type A13

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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 700ML		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			
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145 Tap Hole in Trigger Housing in Trigger Spring Hole

Tooling Tap #6-40 NF Thread

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Part No:	Part Name: Trig Assy 700ML		Centerfire Rifle			Date: 8/14/2006
Operation No: 145	Operation: Tap Hole in Trigger Housing in Trigger Spring 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			
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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

*** See Sketch ***

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

NOTE: Do all elements 100% and use white paper background for all visual checks.

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.

   * 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

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* 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. Check Connectors - See sketch #151

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:
* Good black 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.

* 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.

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.

Operation Tool Detail **Operation: 151**

Tool Number	Tooling Description
D-44608	File Fixture
C-44604	Flatness Block

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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 700ML	Centerfire Rifle	Date: 8/14/2006

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Operation No: 151	Operation: Assemble Trigger Assembly - Stage One -					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			
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154 Assemble Trigger Assembly - Stage Two

Operation Step Detail Operation: 154

Step Operation / Step Description

Assembly Trigger Assembly - Stage Two

1. 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 "Steelgard" and be free of foreign material.

2. 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 position(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.

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* Grip Trigger and rotate housing around Trigger Pin.
  Trigger must rotate freely in housing without bind.

3. Install:

   *** 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 agitation, add more screws to the bag and re-agitate.
   c) Visually inspect in the same way indicated in step 4 after any re-agitation.

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

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

* Use drop gage C-44522 to inspect for straightness. Any sear safety cams that do not pass through the gage 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.

Operation Tool Detail **Operation: 154**

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 gage for Sear Safety Cam Width.

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Part No:	Part Name:	Trig Assy 700ML	Centerfire Rifle			Date: 8/14/2006	
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				
Drop gage for Sear Safety Cam Width.	C-44522-A	100%	INSPECT / REJECT				
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155 Adjust Trigger Assembly on Comparator 100%

Operation Step Detail Operation: 155

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

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

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

   Comparator fixture dead weight - 4 lbs.

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.

Operation Tool Detail **Operation: 155**

Tool Number	Tooling Description
Std.	DELTRONIC 14" COMPARATOR (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:

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Part No:	Part Name: Trig Assy 700ML	Centerfire Rifle	Date: 8/14/2006
Operation No: 155	Operation: Adjust Trigger Assembly on Comparator 100%		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			
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160 **Assemble Trigger Assembly - Stage Three**
No bolt release to be assembled for 700ML

Operation Step Detail **Operation: 160**

Step Operation / Step Description

*** See Sketch ***

Assembly Trigger Assembly - Stage Three

1. Pick correctly adjusted Trigger Sub-Assembly.

2. Assemble:

NO Bolt Stop Release to be assembled for 700ML Trig Assy.

Safety Assembly - Check minimum width of "U" bend between safety arm and cam with .140" plug, 100%.

Safety Detent Ball

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

Safety Pivot Pin

Safety Snap Washer
* Orient the Snap Washer such that the notched side of the Pivot Pin channel is on the left after assembly. This places the die

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break on the under side of the Snap Washer.(See sketch #160.)

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

* Both raised dimples on Safety Detent Spring must be within opening of Safety Snap Washer.

3. Place assemblies in tray.

Operation Tool Detail **Operation: 160**

Tool Number	Tooling Description
Std	.140 Plug gage

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 700ML		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			

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140 Plug gage	Std	100%	INSPECT / REJECT			
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165 Function Check Complete Trigger Assembly 100%

Operation Step Detail Operation: 165

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:

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* Safety must spring-return rearward to detent position.

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

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170 **Mark Correctly Assembled, Adjusted and Checked**
Trigger Assembly with Assemblers Identification
To MRP Crib #31

Operation Step Detail **Operation: 170**

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 700ML	Centerfire Rifle	Date: 8/14/2006
Operation No: 170	Operation: Mark Correctly Assembled, Adjusted and Checked		Work Center:

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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			
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175R Repair Rejected Trigger Assemblies

Operation Step Detail Operation: 175R

Step Operation / Step Description

Repair Rejected Trigger Assemblies

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

1. Disassemble and scrap all questionable parts.
2. Scrap Trigger Housing if it has another person's stamp on it.
3. Rebuild Trigger Assembly from the beginning, per the process.
   * Demagnetize parts
   * Clean parts
   * Check all fits, dimensions, and comparator settings
   * Follow all processes completely and exactly as if beginning with new parts.

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 700ML		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:	

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Gage Description and Characteristic	Gage Number	Gage Frequency	1st Shift	2nd Shift	3rd Shift	Remarks, Causes, Action Taken, Etc.
VISUAL	VISUAL	100%	INSPECT / REJECT			
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Dept	Oper	Operation Description	Part Numbers
9132	001	Issue from Crib	99294
8773	140	Demagnetize Springs	99294
8773	145	Tap Hole in Trigger Housing	99294
8773	151	Assemble Trigger Assembly - Stage One - Inspect Connector 100% - Inspect Trigger 100% and Check Connector to Trigger Fit 100%	99294
8773	154	Assemble Trigger Assembly - Stage Two	99294
8773	155	Adjust Trigger Assembly on Comparator 100%	99294
8773	160	Assemble Trigger Assembly - Stage Three No bolt release to be assembled for 700ML	99294
8773	165	Function Check Complete Trigger Assembly 100%	99294
8773	170	Mark Correctly Assembled, Adjusted and Checked Trigger Assembly with Assemblers Identification To MRP Crib #31	99294
8773	175R	Repair Rejected Trigger Assemblies	99294

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Dept	Oper	Operation Description	Part Numbers

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Dept	Oper	Operation Description	Part Numbers

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Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
							PART# DESCRIPTION
							99294 TRIGGER ASSEMBLY - 700ML
							Stainless Steel for both carbon & s.s
							models.
99294							TRIGGER ASSEMBLY - 700ML
		97492	10	160	1.000		Safety Assembly
		23222	20	160	1.000		Safety Detent Ball
		97493	30	140	1.000		Safety Detent Spring
		97494	40	160	1.000		Safety Pivot Pin
		17044	50	160	1.000		Safety Snap Washer
		15666	60	154	1.000		Sear Safety Cam
		17047	70	140	1.000		Sear Spring
		109836	80	151	1.000		Trigger
		17053	90	154	1.000		Trigger Screw Front
		97497	100	151	1.000		Trigger Connector
		91128	110	154	1.000		Trigger Engagement Screw
		97498	120	151	1.000		Trigger Housing Assembly
		202540	130	154	1.000		Trigger Pin
		15400	140	140	1.000		Trigger Spring
		15481	150	154	1.000		Trigger Stop Screw

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Parent	Rv	Child	Fnd	Oper	Qty	UM	Description

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Date:	Reason for Revision:	Eng:	Log #:
29-Nov-01	Copied entire process from VAXcamps #303578	RLJ	304220
14-Feb-03	Add OP #145 (Tap Hole) to Routing	AFH	308579
13-Jan-05	Trigger pin p/n 202540 was 24477	AJL	313548
04-Nov-05	DEPT#8773 WAS 8772 FOR OP#140, 145, 151, 154, 155, 160, 165, 170, & 175R	GLC	316020
29-Nov-05	Op. 155 - 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 within min/max trigger lines on comparator screen." Op. 165 - added detail step #3 to check sear lift & added gage D-42614.	PJZ	316078

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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 700ML		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 700ML	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 Specificaton HRc	INSPECT / REJECT	Hardness Specificaton H15n	INSPECT / REJECT	Hardness Specificaton H45n	INSPECT / REJECT	Break Test INSPECT	REJECT

HRc Tester No	H15n Tester No	H15n Tester No	H45n 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
45	70	91	47
46	71	92	48
47	72	93	49
48	73	94	50
49	74	95	51
50	75	96	52
51	76	97	53
52	77	98	54
53	78	99	55
54	79	100	56

Break Test Results (lbs)

Sample Plan

Lot Size	Sample Size	Allowable Outside
1-5	All	0
6 - 50	6	0
51 - 100	7	0
101 - 200	7	0
201 - 800	16	1
801 - 3000	17	1
3001 - 20000	27	2

55	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:

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