

Remington Arms Company, Inc.
Manufacturing Process Document

Document ID: Trig Assy 700SS 7SS
Product Line: Centerfire Rifle

Effective Date: 29-Nov-05
Origination Date: 31-Aug-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
Tap Hole in Trigger Housing
Connector, Trigger, & Connector to Trigger Fit
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

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

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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 700SS 7SS		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				
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			REJECT				

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140 Demagnetize Springs

Step Operation / Step Description

Demagnetize Springs

Procedure:

1. Place Sear Springs and Trigger Springs separately in a pan. The amount should be based on daily requirements.
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 switch to "OFF". Do not turn switch off with pan in contact with demagnetizer, "THIS MAY MAGNETIZE PARTS".

Tool Number Tooling Description

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:
Part No:	Part Name: Trg Assy 700SS 7SS	Centerfire Rifle	Date: 8/14/2006
Operation No: 140	Operation: Demagnetize Springs	Work Center:	

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145 Tap Hole in Trigger Housing in Trigger Spring Hole
Tooling Tap #5-40 NF Thread

PROCESS CONTROL INSPECTION RECORD			Revision Date: 29-Nov-05			Processed by:
THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES						
Part No:	Part Name: Trig Assy 700SS 7SS	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 INSPECT	/	/	
			REJECT INSPECT	/	/	
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151 Assemble Trigger Assembly - Stage One - Inspect
Connector, Trigger, & Connector to Trigger Fit
100%

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%

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

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Fig. #3)

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

2. Check 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.

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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

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

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

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154 Assemble Trigger Assembly - Stage Two

Step Operation / Step Description

Assemble Trigger Assembly - Stage Two

1. Inspect Trigger Housing:

- * Uniform Metallic 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 Trigger and rotate housing around Trigger Pin. Trigger must rotate freely in housing without bind.
- * Use fixture B-37211

3. Install:

*** See Sketch ***

- * Same Connector as fitted to Trigger (Op. #151)
- * Trigger Stop Screw - Flush with hole.
- * Trigger Spring

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- * Trigger Screw Front - Flush with hole or below.
(There must be adequate spring force on Connector while adjusting Trigger Engagement Screw.)
(except with Australian)
- * Trigger Engagement Screw - flush with hole.
(except with Australian)
- * Screw should have been prepacked with loctite sealant before assembly - see PROCEDURE.

PROCEDURE FOR COATING TRIGGER ENGAGEMENT SCREW WITH LOCTITE SEALANT:

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

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 to coat all screws.
4. If screws are too moist, add more screws and re-agitate.
If screws are too dry, add more sealant and re-agitate.

Screws may be used immediately or stored if required.

4. 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.

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Tool Number	Tooling Description
A-35645	Pin Holder Drive Punch
A-51469	Dummy Pins
B-37211	Housing Fixture
C-44522-A	Drop gage for Sear Safety Cam width

PROCESS CONTROL INSPECTION RECORD			Revision Date: 29-Nov-05			Processed by:
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Part No:	Part Name: Trig Assy 700SS 7SS		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	/	/	
Drop gage for Sear Safety Cam width	C-44522-A	100%	REJECT INSPECT	/	/	
			REJECT INSPECT	/	/	
			REJECT INSPECT	/	/	
			REJECT INSPECT	/	/	
			REJECT	/	/	

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155 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.

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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 contact 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		Revision Date:	Processed by:
THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES		29-Nov-05	
Part No:	Part Name: Trig Assy 700SS 7SS	Centerfire Rifle	Date: 8/14/2006
Operation No: 155	Operation: Adjust Trigger Assembly on Comparator 100%	Work Center:	

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Prof. Qty.	Prof. Order #	Gage Number	Gage Frequency	Operator			Setup inspected by & Date:	Remarks, Causes, Action Taken, Etc.
				1st Shift	2nd Shift	3rd Shift		
VISUAL			100%	INSPECT				
Comparator Fixture	E-42271		100%	REJECT INSPECT				
0	E-42271-A		100%	REJECT INSPECT				
				REJECT INSPECT				
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160 Assemble Trigger Assembly - Stage Three

Step Operation / Step Description

*** See Sketch 700 RH ***

*** See Sketch 700 LH ***

*** See Sketch 7 LW ***

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.

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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 Dia plug gage

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

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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.

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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 TWICES

* 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

Part No:	Part Name: Trig Assy 700SS 7SS	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:	
Gage Description and Characteristic	Gage Number	Gage Frequency	1st Shift 2nd Shift 3rd Shift	Remarks, Causes, Action Taken, Etc.

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

Step Operation / Step Description

*** See Sketch - M/7 TR ASSY Used as Reference ***

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
- * Use 1/16" size character

Tool Number	Tooling Description
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B-53512	Holding Block For Stamp
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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 700SS 7SS	Centerfire Rifle	Date: 8/14/2006

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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 700SS 7SS		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.	

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Dept	Oper	Operation Description	Part Numbers
9132	1	Issue from Crib	99861 97490 97954
8773	140	Demagnetize Springs	99861 97490 97954
8773	145	Tap Hole in Trigger Housing	99861 97490 97954
8773	151	Assemble Trigger Assembly - Stage One - Inspect Connector, Trigger, & Connector to Trigger Fit 100%	99861 97490 97954
8773	154	Assemble Trigger Assembly - Stage Two	99861 97490 97954
8773	155	Adjust Trigger Assembly on Comparator 100%	99861 97490 97954
8773	160	Assemble Trigger Assembly - Stage Three	99861 97490 97954
8773	165	Function Check Complete Trigger Assembly 100%	99861 97490 97954
8773	170	Mark Correctly Assembled, Adjusted, & Checked Trigger Assembly with Assemblers Identification To MRP Crib #29	99861 97490 97954
8773	175R	Repair Rejected Trigger Assemblies	99861 97490 97954

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Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
							PART# DESCRIPTION
							97490 TRIGGER ASSEMBLY - 700SS
							97954 TRIGGER ASSEMBLY - 7SS
							99861 TRIGGER ASSEMBLY - 700SS LH
99861							TRIGGER ASSEMBLY - 700SS LH
		99862	10	160	1.000		Bolt Stop Release
		99863	20	160	1.000		Safety Assembly
		23222	30	160	1.000		Safety Detent Ball
		99864	40	140	1.000		Safety Detent Spring
		97494	50	160	1.000		Safety Pivot Pin
		17044	60	160	1.000		Safety Snap Washer
		15666	70	154	1.000		Sear Safety Cam
		17047	80	140	1.000		Sear Spring
		109836	90	151	1.000		Trigger
		17053	100	154	1.000		Trigger Screw Front
		97497	110	151	1.000		Trigger Connector
		91128	120	154	1.000		Trigger Engagement Screw
		99903	130	151	1.000		Trigger Housing Assembly
		202540	140	154	1.000		Trigger Pin
		15400	150	140	1.000		Trigger Spring
		15481	160	154	1.000		Trigger Stop Screw
97490							TRIGGER ASSEMBLY - 700SS
		97491	40	160	1.000		Bolt Stop Release
		97492	100	160	1.000		Safety Assembly
		23222	60	160	1.000		Safety Detent Ball
		97493	110	140	1.000		Safety Detent Spring
		97494	120	160	1.000		Safety Pivot Pin
		17044	130	160	1.000		Safety Snap Washer
		15666	30	154	1.000		Sear Safety Cam
		17047	40	140	1.000		Sear Spring
		109836	140	151	1.000		Trigger
		17053	50	154	1.000		Trigger Screw Front
		97497	150	151	1.000		Trigger Connector
		91128	80	154	1.000		Trigger Engagement Screw
		97498	160	151	1.000		Trigger Housing Assembly
		202540	70	154	1.000		Trigger Pin
		15400	10	140	1.000		Trigger Spring
		15481	20	154	1.000		Trigger Stop Screw

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Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
97954							TRIGGER ASSEMBLY - 7SS
		97955	10	160	1.000		Bolt Stop Release
		97956	20	160	1.000		Safety Assembly
		23222	30	160	1.000		Safety Detent Ball
		97493	40	140	1.000		Safety Detent Spring
		97494	50	160	1.000		Safety Pivot Pin
		17044	60	160	1.000		Safety Snap Washer
		15666	70	154	1.000		Sear Safety Cam
		17047	80	140	1.000		Sear Spring
		109836	90	151	1.000		Trigger
		17053	110	154	1.000		Trigger Screw Front
		97497	120	151	1.000		Trigger Connector
		91128	130	154	1.000		Trigger Engagement Screw
		97498	140	151	1.000		Trigger Housing Assembly
		202540	150	154	1.000		Trigger Fin
		15400	160	140	1.000		Trigger Spring
		15481	170	154	1.000		Trigger Stop Screw

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Date:	Reason for Revision:	Eng:	Log #:
23-Apr-01	Copied entire process from VAXcamps #202374	RLJ	304220
04-Oct-01	Revised hanging weight specification in operation 155.	RLJ	305072
14-Feb-03	Add OP #145 (Tap Hole)	AFH	308578
13-Jan-05	Trigger pin p/n 202540 was 24477	AJL	313551
04-Nov-05	DEPT#8773 WAS 8772 FOR OP#140, 145, 151, 154, 155, 160, 165, 170, & 175R	GLC	316021
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 & gage D-42614.	PJZ	316077

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Date:	Reason for Revision:	Eng:	Log #:
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Dept	Num	Procedure by Steps	Safety Key Points
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CONFIDENTIAL

			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: 29-Nov-05		Inspected by:	
THIS RECORD MUST REMAIN IN HEAT TREAT INSPECTION FOR ONE YEAR				Date:		Production Order #:	
Part Name: Trig Assy 700SS 7SS		Centre Fire Rifle		Part No.:		Prod. Qty:	
Operation No. Part No.:		Operation: Part Name:		Work Center:		Inspec. Date: 8/14/2006	
Furnace and Load Number		Draw Temp	Furnace Date	Hardness Specification		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			
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49		74	95	51			
50		75	96	52			
51		76	97	53			
52		77	98	54			
53		78	99	55			
54		79	100	56			
					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

85	80	101	57	Rev 0
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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:

Inspection

- Hardness:
- Break Test:
- Color Only:
- Appearance of Parts:

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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