B-202540

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TOLERANCES ON DECIMAL DIMENSIONS ARE:
1 PLACE (.1) - TOLERANCE ± .015
2 PLACE (.01) - TOLERANCE ± .010
3 PLACE (.001) - TOLERANCE ± .005
& ON FRACTIONAL DIMENSIONS ± 1/64
& ON ANGULAR DIMENSIONS ± 00° -30'
FINISHES ARE DESIGNATED BY ROOT MEAN SQUARE (R.M.S.) MICRO-INCH ROUGHNESS VALUES AND ARE THE MAXIMUM ROUGHNESS ACCEPTABLE. UNLESS OTHERWISE SPECIFIED,

FINISH ROUGHNESS TO BE $\sqrt{}^{125}$ OR BETTER.

MATERIAL AND HEAT TREAT

MATERIAL	AISI 440A OR 440C STAINLESS
HEAT TREAT	VACUUM QUENCH AND TEMPER
HARDNESS	HRC 45-50 OR H45n 45-55
FINISH	BRIGHT

~~HEAT TREAT AND COLOR TO BE DONE BY REMINGTON~~ (1)

ALTERATIONS

ALT.	WAS	REF.	BY	DATE
0	INITIAL TRANSMITTAL. WAS ON PRINT C-24475. MATERIAL WAS AISI 1095 HR45n 43-49. REMOVED BLANK NUMBER.	15663	RAW	12-16-04
1	CORRECTED PART NO. FOR ALTERATION #0. (C-24475 WAS C-25575)	15713	RAW	1-19-05

NOTE:

1. □ DIMENSIONS SHOWN WITH THIS SYMBOL WILL BE SUBJECT TO CONTROL AND INSPECTION AS SPECIFIED IN THE PROCESS RECORD OR PURCHASED PARTS INSPECTION DOCUMENTATION.

2. (ST) DIMENSION SHOWN WITH THIS SYMBOL ARE SIGNIFICANT AND MUST HAVE CpK VALUES GREATER THAN 1.33.

3. FOR VENDED COMPONENTS ALL SAMPLE SUBMISSIONS ARE TO BE SUBMITTED IN ACCORDANCE TO THE PUBLICATION "PRODUCTION PART APPROVAL PROCESS" AS PUBLISHED BY THE AUTOMOTIVE INDUSTRY ACTION GROUP (AIAG), 1993, LEVEL 3.

4. ALL GEOMETRIC TOLERANCES AND GAGE DIMENSION IMPLY INSPECTION FOR CONFORMANCE.

40 X	202540	TRIGGER PIN
700	202540	TRIGGER PIN
7	202540	TRIGGER PIN
MODEL	PART NO.	PART USE

DES. BY DATE	DRN. BY DATE	CHK. BY DATE
	RAW 11-3-04	

TITLE: TRIGGER PIN

NUMBER	SCALE	SUPERSEDES	REFERENCE
B-202540	4:1		DCR# 15663

Remington

SOLIDWORKS FILENAME - 202540 - Trigger Pin

1

M24 00000199

B-14630

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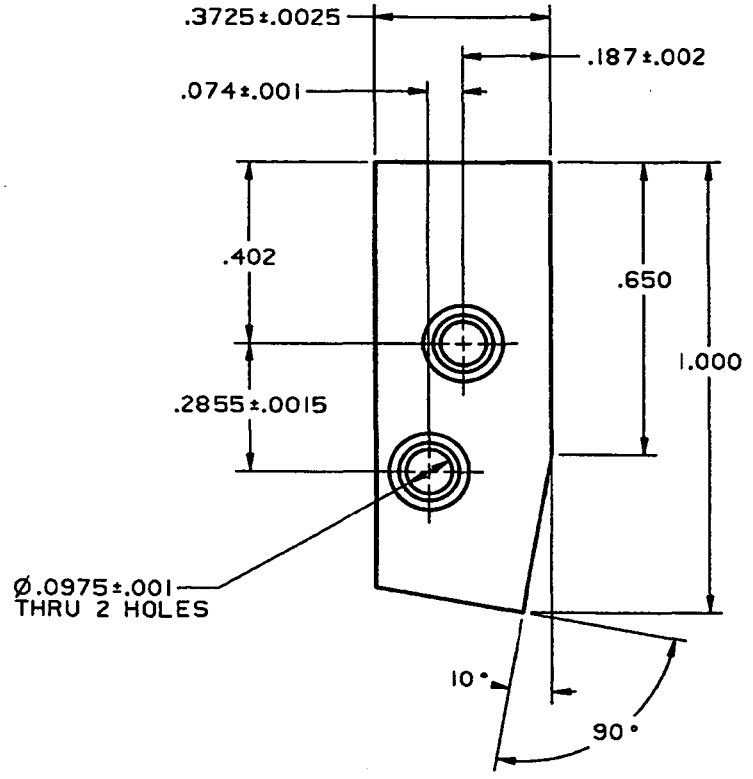
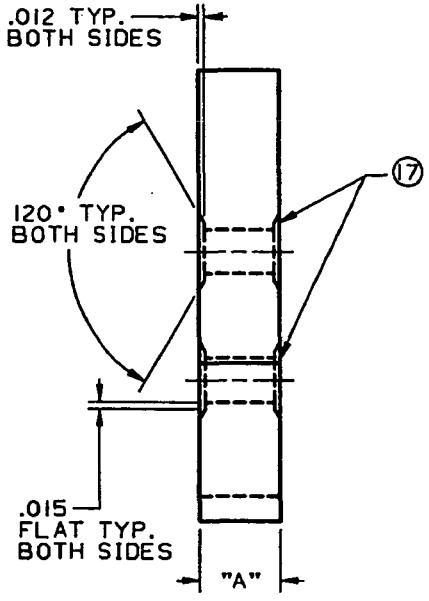
FINISH ROUGHNESS TO BE 125 √ OR BETTER.

RECOMMENDED MATERIAL AND HEAT TREAT
MATERIAL SEE BELOW
HEAT TREAT
HARDNESS 7.1 MIN. DENSITY
COLOR
HEAT TREAT AND COLOR TO BE DONE BY REMINGTON F.E.S 11/30/89

MAT'L.- PLAIN IRON POWDER
PREFERRED MAT'L. HOEGANAES 1000B
ANCHOR STEEL
NOTE: RESIN IMPREGNATE





	DIM. "A"
BLANK DIM.	.182/.178
FINISH DIM.	.176/.174

NOTE: FOR BLANK ORDER PART NO. 91923

CV FILENAME - RES.700.B14630.FRONT-SPACER.EAK

ALTERATIONS

ALT.	WAS	REF.	BY	DATE	
17	ADDED RECESSED CHAMFERS THIS SIDE	13313	EAK	2-1-95	
18	REVISED AND REDRAWN ON CAD	13312	EAK	2-1-95	M
19	ADD USE XP-100 R	13770	RAH	8-11-97	M

XP-100 R	14630	TRIGGER HOUSING FRONT SPACER
7 LWT	14630	TRIGGER HOUSING FRONT SPACER
7 LWT	14630	TRIGGER HOUSING FRONT SPACER
700 VAR.	14630	
700 BDL	14630	
700 ADL	14630	
40XCF	14630	
40XB	14630	TRIGGER HOUSING FRONT SPACER
MODEL	PART NO.	PART USE

DES. BY DATE	DRN. BY DATE	CHK. BY DATE	APP. BY DATE
	EAK 2-1-95		

TITLE FRONT SPACER

NUMBER	SCALE	SUPERSEDES	REFERENCE
B-14630	4X		

REMINGTON ARMS CO. INC.
ELION RESEARCH DIV.

17 19

M24 00000200

B-14631

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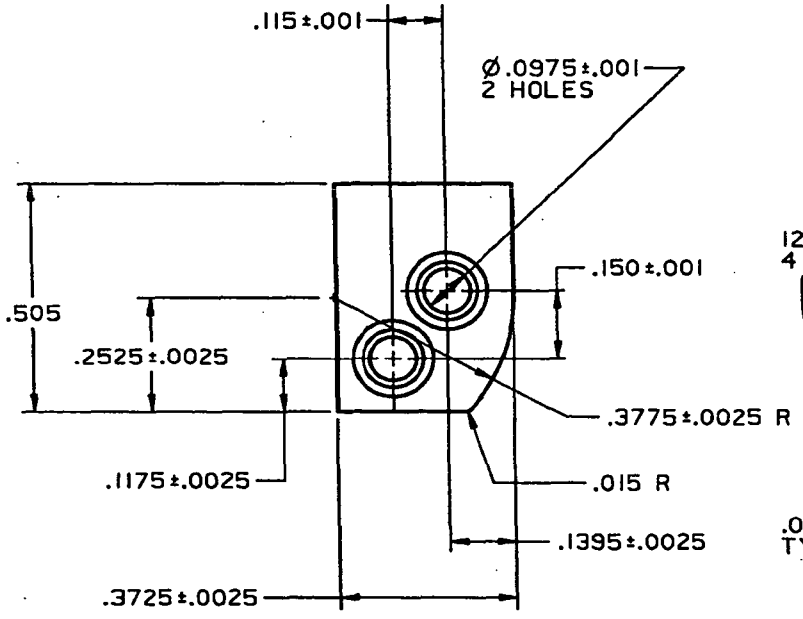
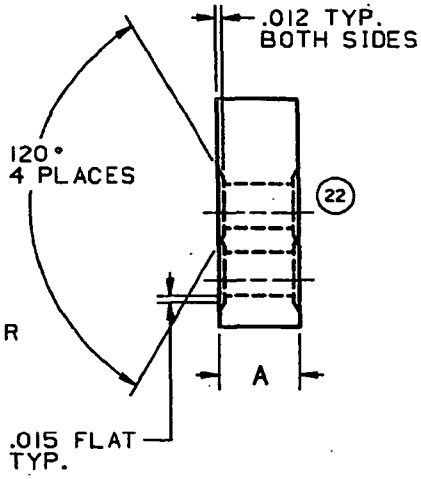
FINISH ROUGHNESS TO BE 125 √ OR BETTER.

RECOMMENDED MATERIAL AND HEAT TREAT
MATERIAL SEE BELOW
HEAT TREAT
HARDNESS 7.1 G/CC MIN. DENSITY
COLOR
HEAT TREAT AND COLOR TO BE DONE BY REMINGTON
G.D.S. 1-6-95

MAT'L.:PLAIN IRON POWDER
PREFERRED- HOEGANAES 1000B
ANCHOR STEEL





	DIM. "A"
FINISH DIM.	.176/.174
BLANK DIM.	.182/.178

NOTE:
FOR BLANK ORDER PART NO. 91924
RESIN IMPREGNATE
MINIMUM RADIUS EXTERNAL CORNERS .030 MIN

CV FILENAME - RES.NBA.814631.TRIG-PLATE-SPACER.REAR.FEM

ALTERATIONS

ALT.	WAS	REF.	BY	DATE
21	REVISED & REDRAWN ON CAD	13236	EAK	12-29-94
22	ADDED C'SINK	13296	EAK	12-29-94
23	ADD USE XP-100 R	13770	RAW	8-11-97

	MODEL	PART NO.	PART USE
(23)	XP-100 R	14631	TRIGGER PLATE SPACER REAR
	NBA	14631	TRIGGER PLATE SPACER REAR
	7LWT	↑	↑
	MOHAWK 600		
	700 VAR		
	700 BDL		
	700 ADL		
	40XCF	↓	↓
	40XB	14631	TRIGGER PLATE SPACER REAR

DES. BY DATE	DRN. BY DATE	CHK. BY DATE	APP. BY DATE
	EAK 12-29-94		

TITLE: TRIGGER PLATE SPACER REAR

NUMBER	SCALE	SUPERSEDES	REFERENCE
B-14631	4X		

REMINGTON ARMS CO. INC.
ILION RESEARCH DIV.

22 23

M24 00000201

B-14632

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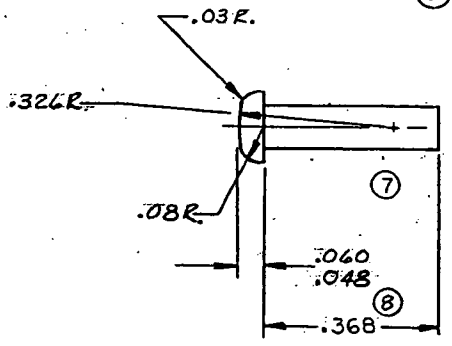
FINISH ROUGHNESS TO BE $\frac{125}{\sqrt{}}$ OR BETTER.

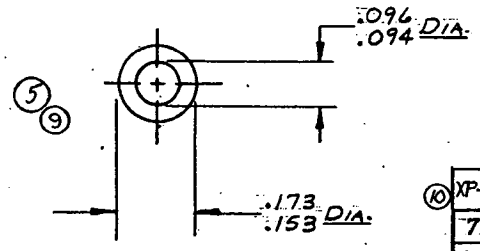
(6) RECOMMENDED MATERIAL AND HEAT TREAT
MATERIAL .05-.12 CARBON STEEL
HEAT TREAT
HARDNESS
COLOR
HEAT TREAT AND COLOR TO BE DONE BY REMINGTON KES 2/22/94

ALTERATIONS					
ALT.	WAS	REF.	BY	DATE	
4	REVISED/REDRAWN WAS A-14632	12166	H.P.	8/11/87	(M)
5	REVISED DIM. TO MAA SPEC	12208	RAW	8/21/87	(M)
6	WAS "STEEL" TO .05-.12 CARBON STEEL"	12518	RAW	3/6/90	(M)
7	REMOVED .025/.035 x 90° CHAMF.	13129	RAW	3/11/94	
8	WAS .383	13129	RAW	3/11/94	
9	WAS .080 DIA. REF.	13129	RAW	3/11/94	(M)
10	ADD USE XP-100R	13770	RJS	8/8/97	(M)

NOTE:
ALL RADII ARE APPROXIMATE

(5)





RIVET: AMERICAN STANDARD SMALL SOLID
TYPE: PAN HEAD

MODEL	PART NO.	PART USE
(K) XP-100R	14632	TRIGGER HOUSING RIVET
7LWT	14632	TRIGGER HOUSING RIVET
700VAR	14632	TRIGGER HOUSING RIVET
700BDL	14632	TRIGGER HOUSING RIVET
700ADL	14632	TRIGGER HOUSING RIVET
40XCF	14632	TRIGGER HOUSING RIVET
40XP	14632	TRIGGER HOUSING RIVET

DES. BY DATE	DRN. BY DATE	CHK. BY DATE	APP. BY DATE
	W.P. 2-11-87		

TITLE: RIVET

NUMBER	SCALE	SUPERSEDES	REFERENCE
B-14632	4-X	A-14632	REV 3

REMINGTON ARMS CO. INC.
ILION RESEARCH DIV.

FORM TPS REV. 2/80 N.H.S. 19 1153

M24 00000202

B-15368

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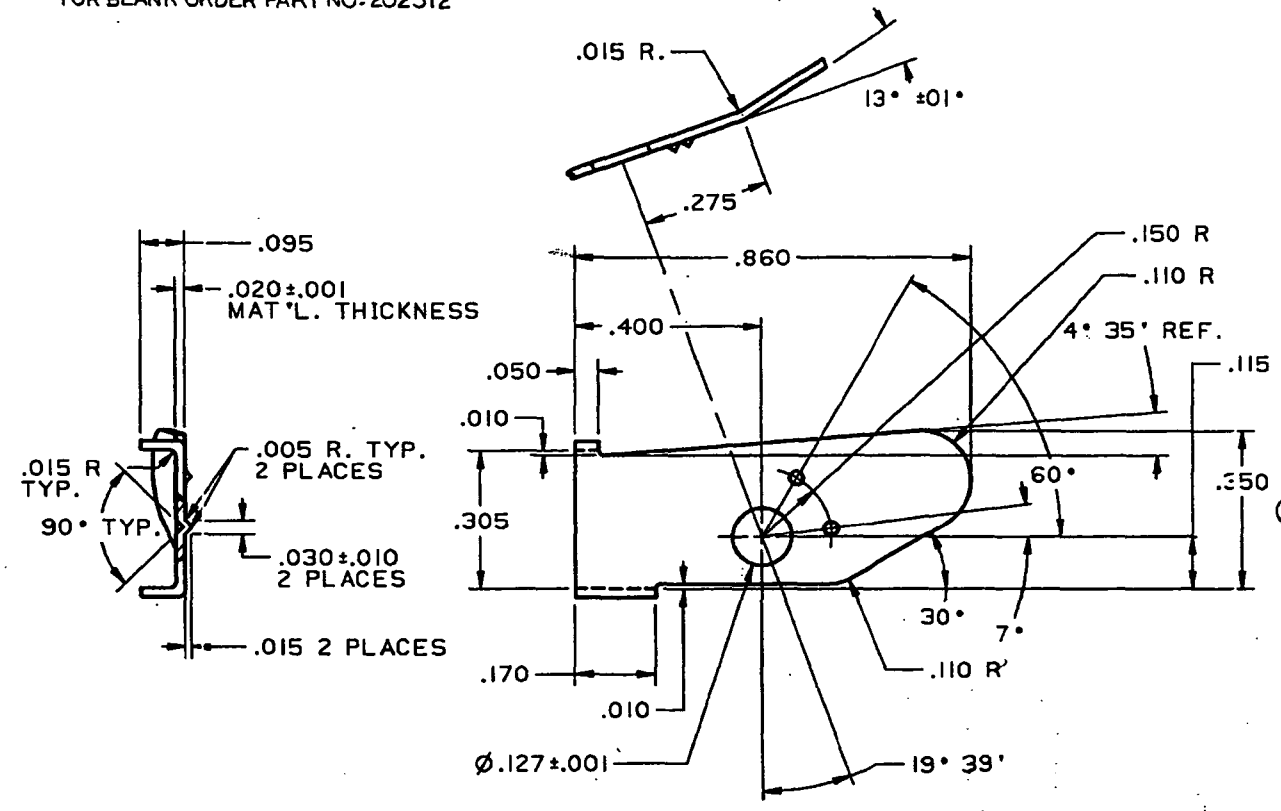
FINISH ROUGHNESS TO BE $\sqrt{125}$ OR BETTER.

RECOMMENDED MATERIAL AND HEAT TREAT
MATERIAL C-1095
(22) HEAT TREAT AUSTEMPER
HARDNESS HRISN 83-86
COLOR TEMPER COLORED
HEAT TREAT AND COLOR TO BE DONE BY REMINGTON

(21) FOR BLANK ORDER PART NO-202312



ALTERATIONS

ALT.	WAS	REF.	BY	DATE	
19	REVISED AND REDRAWN ON CAD	13311	EAK	1-24-95	(M)
20	ADD USE XP-100 R	13770	RAW	8-11-97	(M)
21	ADDED NOTE	15329	RAW	1-13-04	
22	UPDATED HEAT TREAT	15329	RAW	1-13-04	(M)

(20)

MODEL	PART NO.	PART USE
XP-100 R	15368	SAFETY DETENT SPRING
700 VAR.	15368	SAFETY DETENT SPRING
40XB IFR 40XCF	15368	SAFETY DETENT SPRING
40X-B	15368	SAFETY DETENT SPRING
700 BDL	15368	SAFETY DETENT SPRING
700 ADL	15368	SAFETY DETENT SPRING

DES. BY DATE	DRS. BY DATE	CHK. BY DATE	APP. BY DATE
	EAK 1-23-95		

TITLE: SAFETY DETENT SPRING

NUMBER: B-15368

SCALE: 4X

SUPERSEDES: B-15368

REFERENCE

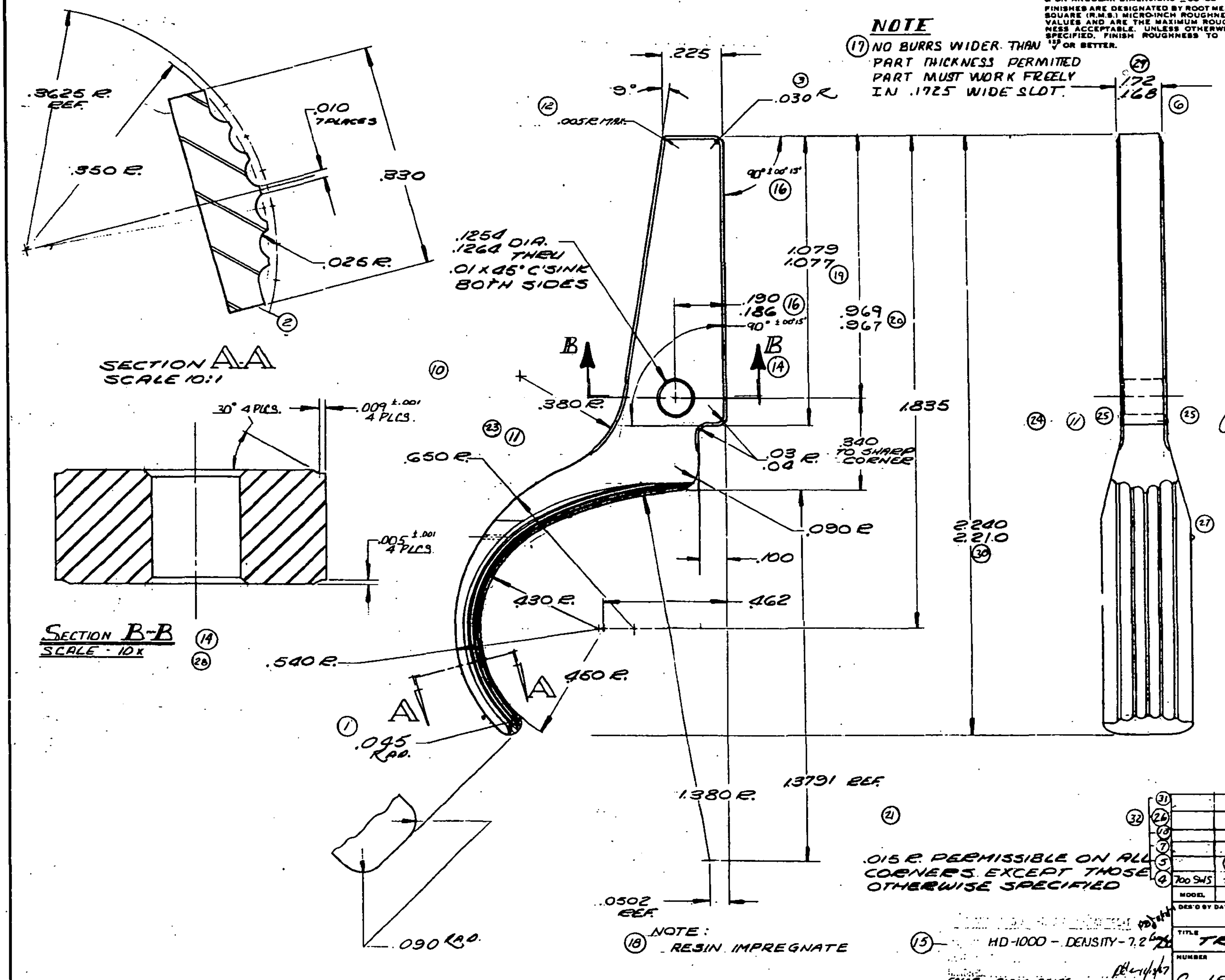
REMINGTON ARMS CO. INC.
ILION RESEARCH DIV.

CV FILENAME - RES.NBA.B15368.SAFETY-DETENT-SPG.EAK

21 22 20

M24 00000203

C-15280



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ALTERATIONS

LET.	WAS	REFERENCE	BY	DATE
1	FLAT BOTTOM	4210	G/S	5-5-61
2	RADIUS	4219	"	6-5-61
3	ADDED	"	"	"
4	700	4445	DFS	1-23-62
5	ADD USE 40X-B	5129	"	1-29-63
6	.172/.168	5364	RG	4/25/66
7	ADDED USE	6479	DD	3-15-66
8	WAS BLANK	7110	DD	7-1967
9	Removed 40XB	8008	JK	6-17-68
10	.275@15°	8041	JK	7-2-69
11	Added	8041	JK	7-2-69
12	ADDED .005 R MAX.	8143	JK	9-26-69
13	Add Used	8179	JK	9-31-69
14	ADD SECT. BB	10521	[illegible]	13 Oct. 77
15	Powder Metal	"	"	"
16	ADD 90°	"	"	"
17	ADD Note	"	"	"
18	- -	10768	FN	11/3/78
19	1.076	11109	[illegible]	1-30-80
20	.772 .771	[illegible]	"	"
21	DELETED [illegible]	[illegible]	[illegible]	[illegible]
22	ADDED [illegible]	[illegible]	[illegible]	[illegible]
23	.320	[illegible]	[illegible]	[illegible]
24	.210	[illegible]	[illegible]	[illegible]
25	.025	"	[illegible]	[illegible]
26	ADD USED	"	"	[illegible]
27	ADDED IDENT. MARK	11698	[illegible]	[illegible]
28	REMOVED NOTE	"	"	[illegible]
29	.172-.170 DIM.	11878	[illegible]	[illegible]
30	2.240/2.210	11992	[illegible]	[illegible]
31	ADD USE XP 100R	13770	FK	8/4/97
32	REMOVED ALL BUT SWS USAGE	15721	RAJ	4/21/05

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MODEL	PART USE	QUAN	REF
700 SWS	TRIGGER		

DES'G BY DATE	DRAWN BY DATE	CHECK BY DATE	APPR. BY DATE
	GASZCZUK 3-6-60	RJS 1-23-61	[illegible]

TITLE: TRIGGER
NUMBER: C-15280
SCALE: 4:1
SUPERSEDES—REFERENCE:
REMINGTON ARMS CO. INC.
RESEARCH & DEV. DEPT.

B-15368

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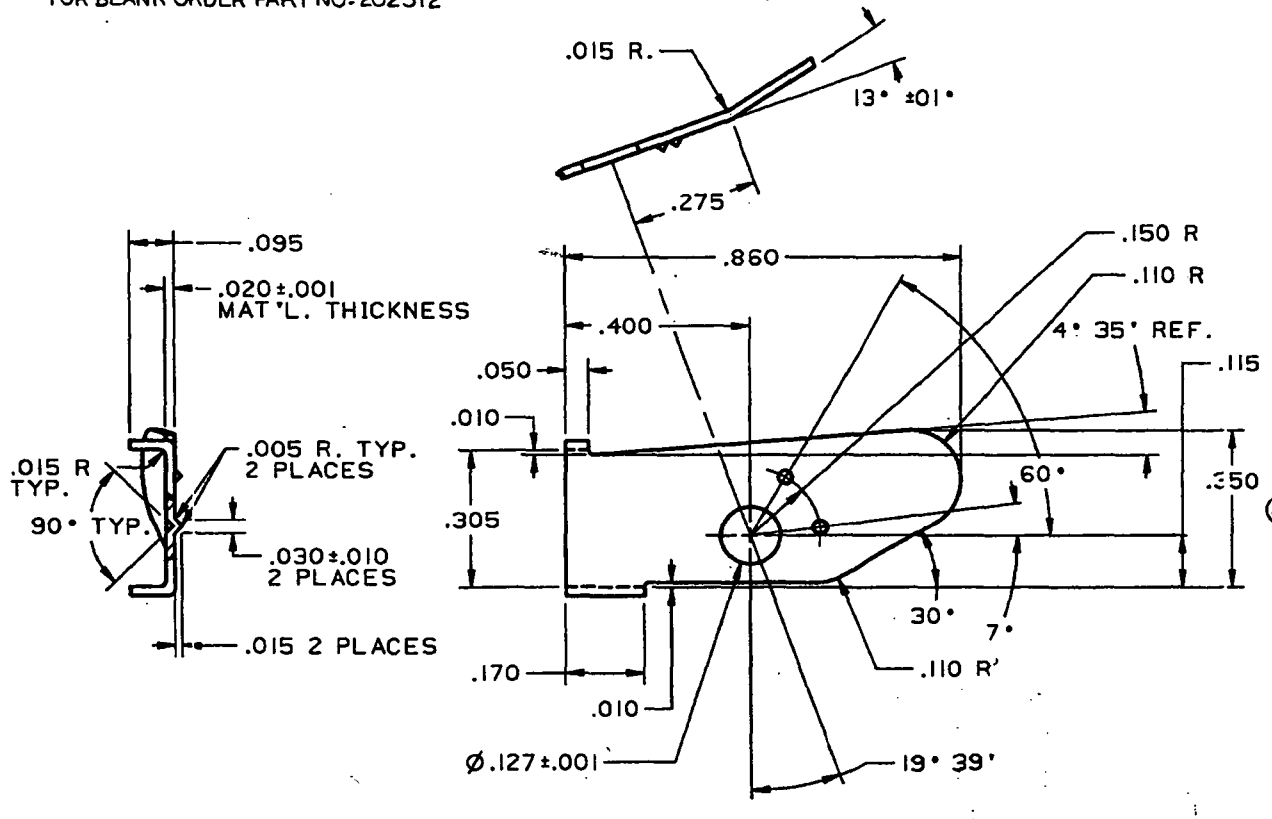
RECOMMENDED MATERIAL AND HEAT TREAT (22)
MATERIAL C-1095
HEAT TREAT AUSTEMPER
HARDNESS HR15N 83-86
COLOR TEMPER COLORED
HEAT TREAT AND COLOR TO BE DONE BY REMINGTON

(21) FOR BLANK ORDER PART NO. 202312



ALTERATIONS

ALT.	MADE	REF.	BY	DATE	
19	REVISED AND REDRAWN ON CAD	13311	EAK	1-24-95	(M)
20	ADD USE XP-100 R	13770	RAW	8-11-97	(M)
21	ADDED NOTE	15329	RAW	1-13-04	
22	UPDATED HEAT TREAT	15329	RAW	1-13-04	(M)

MODEL	PART NO.	PART USE
XP-100 R	15368	SAFETY DETENT SPRING
700 VAR.	15368	SAFETY DETENT SPRING
40XB IFR 40XCF	15368	SAFETY DETENT SPRING
40X-B	15368	SAFETY DETENT SPRING
700 BDL	15368	SAFETY DETENT SPRING
700 ADL	15368	SAFETY DETENT SPRING

(20)

DES. BY DATE	DRN. BY DATE	CHK. BY DATE	APP. BY DATE
	EAK 1-23-95		

TITLE: SAFETY DETENT SPRING

NUMBER: B-15368
SCALE: 4X
SUPERSEDES B-15368
REFERENCE
REMINGTON ARMS CO. INC. R.I.O.N. RESEARCH DIV.

CV FILENAME - RES.NBA.B15368.SAFETY-DETENT-SPG.EAK

21 22 20

M24 00000205

NUMBER A-15400

REMINGTON ARMS CO. INC.
RESEARCH & DEV. DEPT.

SCALE —

SUPERCEDES REFERENCE A-17378

TITLE SPRING

DES. BY DATE	DRN. BY DATE	CHK. BY DATE	APP. BY DATE
	RJS 10-11-61	RJS 10-11-61	10/4/61

FOR DETAILS, SEE PROCESS RECORD

	MODEL	PART USE	QUAN.	SEE
(2)	700 ADL 700 BDL	TRIGGER SPRING	1	D-26345
(5)	7LWT	" "	1	P.L.
	40XB IFA	TRIGGER ADJUSTING SPRING 2 OF TRIGGER	1	D-27565
(4)	700 VAR	TRIGGER SPRING	1	P.L.
(6)				
(11)	XP100R	TRIGGER SPRING		

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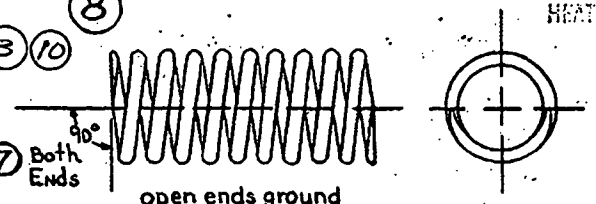
RECOMMENDED MATERIAL AND HEAT TREAT

MATERIAL MUSIC WIRE
HEAT TREAT STRESS RELIEVE
HARDNESS
COLOR
HEAT TREAT AND COLOR TO BE DONE BY REMINGTON

(8) (3) (10)



open ends ground

NOTE: (9) END COIL OUTSIDE DIAMETER NOT TO EXCEED O.D. OF SPRING (9)

INSPECTION

1. To work freely in .117 dia. hole
2. To work freely on .060 dia. pin
3. *Load 5.0 to 6.7 lb. at .177 length (~~with set removed~~) (1)
4. Solid Height .150 max.
5. Free Length .200 min.
6. Ends - OPEN ENDS GROUND (8)
7. Wind L H
8. Remove set (~~Yes~~ (No (~~except for inspection~~

* Approximate length limits to nearest 64th inch at constant load in lbs. and nearest 1/4 oz. Load ____ lbs. ____ ozs. at ____ to ____ in. length

MANUFACTURE

9. Wire dia. .027
10. Outside dia. .114
11. Free Length .203
12. Coils 5 Active 5 1/2 Total

DESIGN DATA

13. Rate .226 lb./in.
14. Solid Stress 202,000 lb/sq.in.
15. Solid Load 11.9 lb.
16. Spring Index 3.2
17. Torsional Mod. G= 11.5 x 10⁶ lb/sq.in.
18. WAHL FACTOR ~~Concentric Coor~~. 1.53

This Spring must meet the requirements in the "Inspection" section. Figures given in the "Manufacture" section indicate the preferred Spring, but the Manufacturer may deviate from these at his own discretion. Figures in the "Design Data" section are based on those in the "Manufacture" section.

A-15400

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ALT.	WAS	REFERENCE	BY	DATE
(12) 11	ADD USE XP100R	13770	RJS	8/8/97
(M) 10	ADD USE 7LWT	11667	DEB	12/8/72
9	ADDED NOTE	11030	SAF	11-15-78
8	GROUND & ADD VIEW	11000	SAF	10-24-77
7	40XB & 40XCF	8179	JTT	10-31-69
6	Added	8005	JK	6-17-69
5	40XB & 40XCF	7110	DD	7NOV67
4	ADDED USE	6479	DD	3-15-66
3	ADD USE 40X-B	5129	DEB	1-25-63
2	700	4445	DEB	11/24/62
1	WITH SET REMOVED	4382	RJS	11/3/61

ALTERATIONS

TFA-3 REV. 1

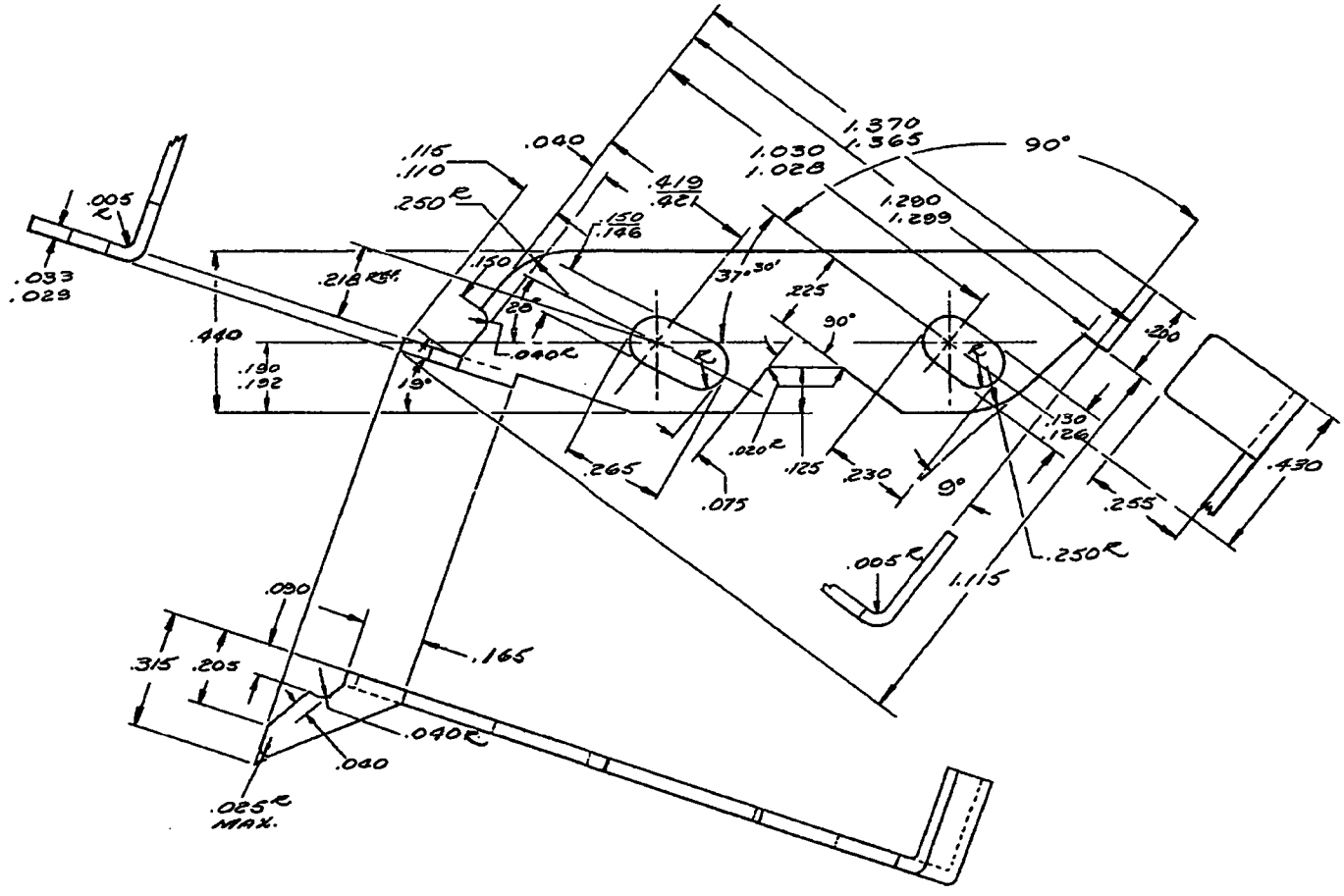
(10) (8)

THIS DRAWING IS CAD MAINTAINED AND SHALL NOT BE SCALED

REVISIONS		
REV.	DATE	ECO NUMBER
15	9/12/2006	06-0147
SHEET	ZONE	DESCRIPTION
1 OF 1	F-7	REVISED HEAT TREAT

NOTES

1. MATERIAL: C-1010 (15)
2. HEAT TREATMENT: CARBURIZE .75% CARBON POTENTIAL
3. HARDNESS: H15N 75-85
4. FINISH: NITRE BLACK
5. FOR BLANK DRAWING SEE C-91917



M24 00000207

ANSI Y14.5M REV 1994 APPLIES
UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES

	APPROVED	DATE
DRAWN BY	D.E.B.	12-13-61
CHECKED	R.J.S.	12-14-61
DESIGN	webster	N/A
ENGINEERING	N/A	N/A
MFG	N/A	N/A
MATERIAL	N/A	N/A

TOLERANCES
UNLESS OTHERWISE SPECIFIED:
X.XX ± 0.01
X.XXX ± 0.005
ANGLES ± 1°
FILLET/EDGE .005 - .015
SURF FINISH .125 RMS
THIRD ANGLE PROJECTION

Remington Arms Company
14 Hoefler Ave, Bon, New York 13357

TITLE:
BOLT STOP RELEASE

SIZE C DWG. NO. 15478 REV 15
WEIGHT: N/A lbs. SHEET 1 OF 1

NUMBER	REMINGTON ARMS CO. INC.	
A-15481	RESEARCH & DEV. DEPT.	
	SCALE 4X	~~SUPERSEDES~~ REFERENCE B-17053

TITLE: SCREW

DES. BY DATE	DRN. BY DATE	CHK. BY DATE	APP. BY DATE
	12-19-61	RJS 12-21-61	12/26/61

FOR DETAILS, SEE PROCESS RECORD

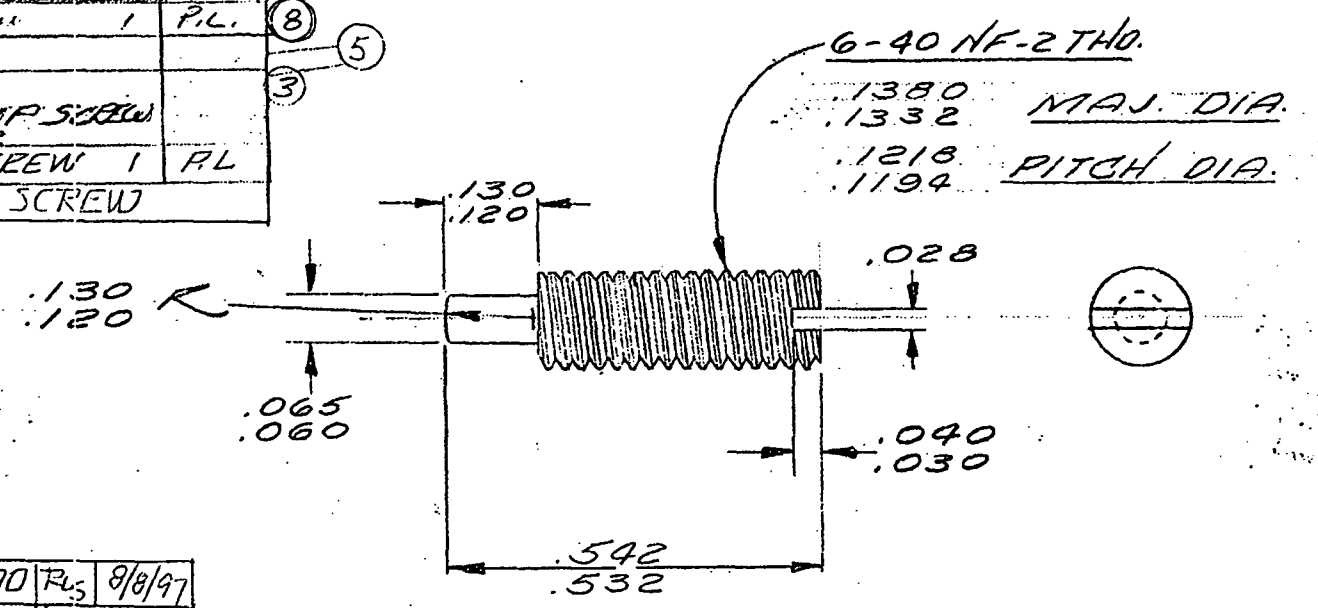
	MODEL	PART USE	QUAN.	SEE
1	700 BDL	TRIG. STOP SCREW	1	D-26345
1	700 BDL	" " "	1	"
6	7LWT	" " "	1	P.L.
2				
	40XB LFR	TRIGGER STOP SCREW 2 OZ TRIGGER		
A	700 VAR	TRIG. STOP SCREW	1	P.L.
9	XP-100R	TRIGGER STOP SCREW		

DO NOT SCALE THIS DRAWING: WORK TO FIGURES UNLESS OTHERWISE NOTED, TOLERANCES ON DECIMAL DIMENSIONS ARE ±.005 & ON FRACTIONAL DIMENSIONS ± 1/64 & ON ANGULAR DIMENSIONS ±00°-30'

FINISHES ARE DESIGNATED BY ROOT MEAN SQUARE (R.M.S.) MICRO-INCH ROUGHNESS VALUES AND ARE THE MAXIMUM ROUGHNESS ACCEPTABLE. UNLESS OTHERWISE SPECIFIED, FINISH ROUGHNESS TO BE 125 √ OR BETTER.

RECOMMENDED MATERIAL AND HEAT TREAT

MATERIAL: .08-.20 CARBON
HEAT TREAT: .003-.006 CASE.
HARDNESS:
COLOR: NITRE BLACK
HEAT TREAT AND COLOR TO BE DONE BY REMINGTON



⑦ FOR BLANK DRAWING SEE A-91926

ALT.	WAS	REFERENCE	BY	DATE
9	ADD USE XP-100R	13770	RLS	8/8/97
8	ADD USE 7LWT	11667	DEB	12/8/82
7	ADDED	11198	VCB	A 15 80
6	40XB	8179	JIT	10-31-69
5	40XB & 40XCF	7110	DD	7/10/67
4	ADDED USE	6479	DD	3-15-66
3	ADD USE 40X-B	5129	DEB	1-25-63
2	ADD USE 40X CF	4832	DEB	7-11-62
1	700 A & 700 ADL	4445	DEB	1-25-62

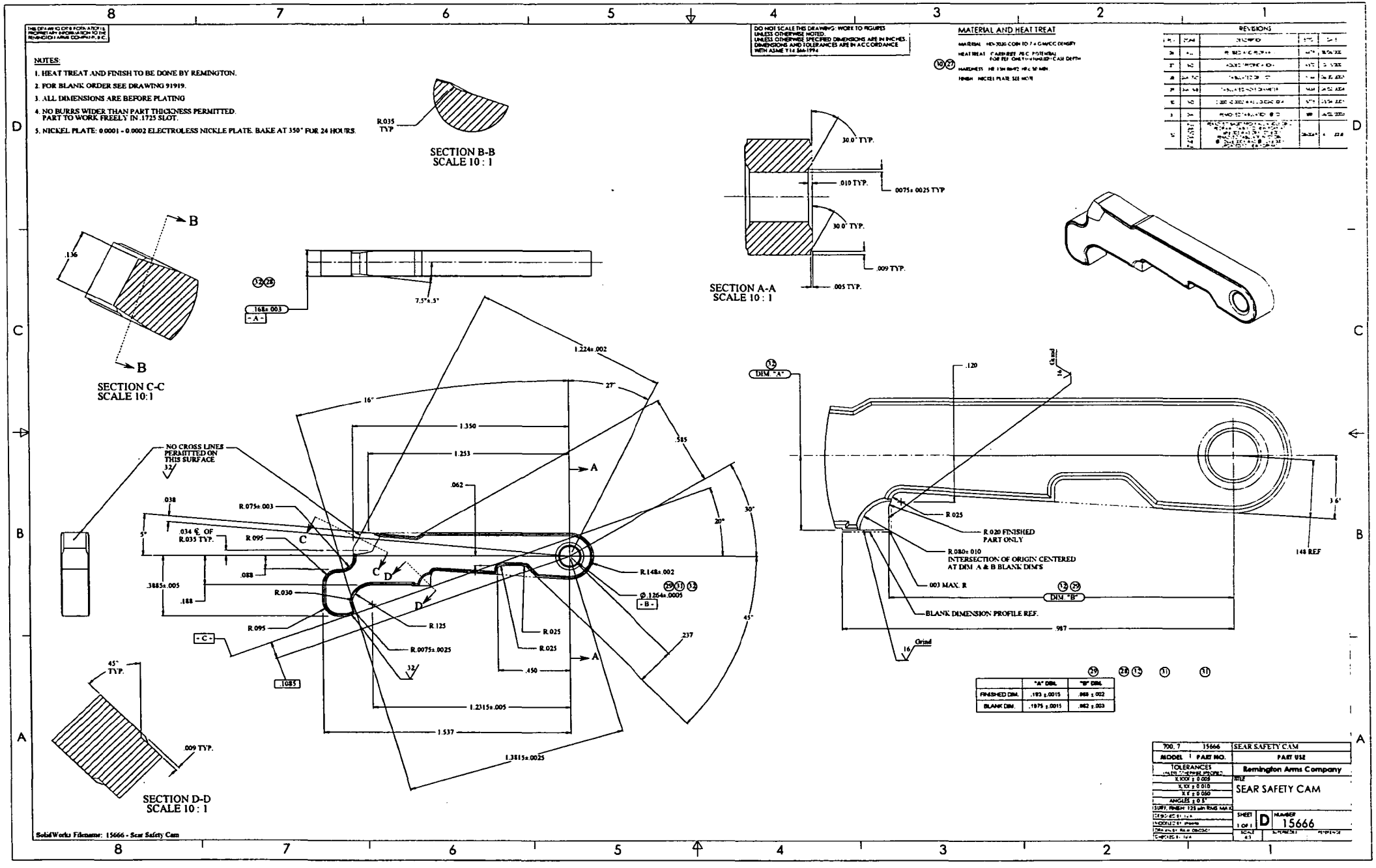
ALTERATIONS

TFA-3 REV. 1

A-15481

8 ⑦

M24 00000208



M24 00000209

B-17044

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

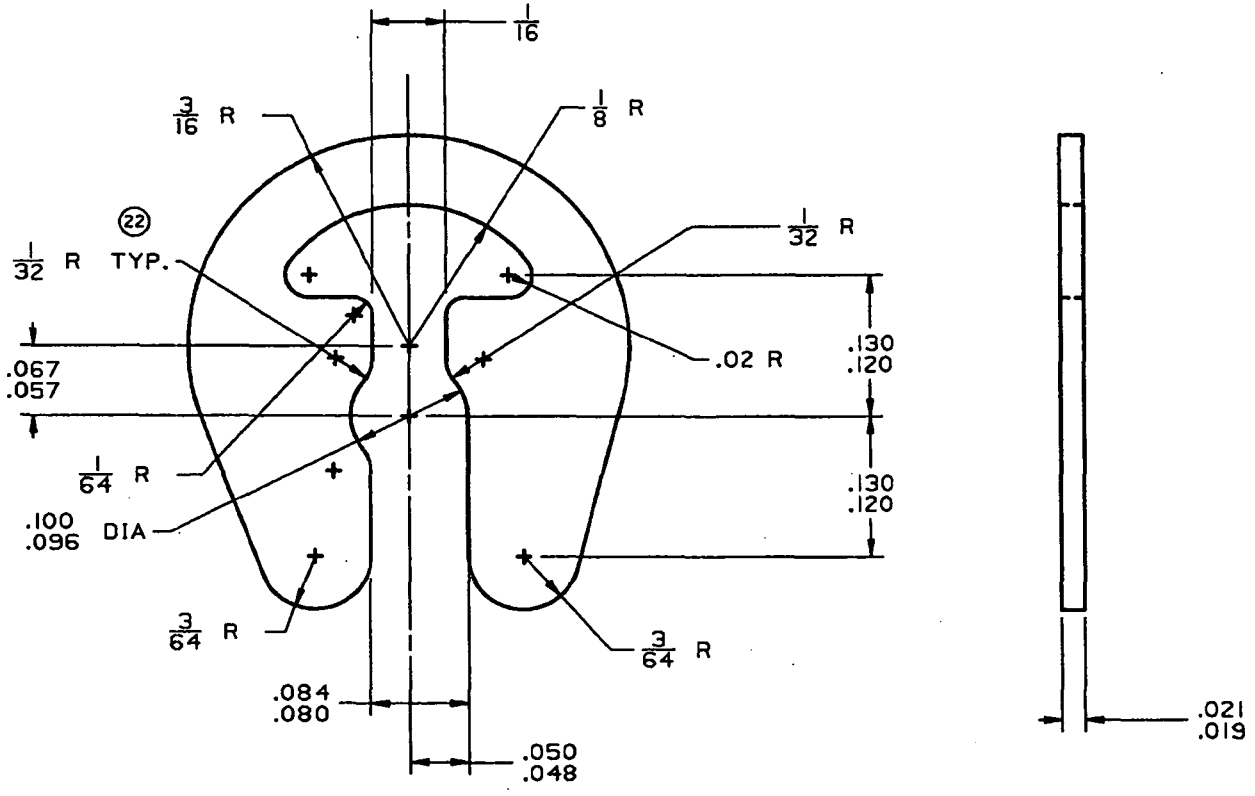
DO NOT SCALE THIS DRAWING: WORK TO FIGURES UNLESS OTHERWISE NOTED.
TOLERANCES ON DECIMAL DIMENSIONS ARE:
1 PLACE (.1) - TOLERANCE ± .015
2 PLACE (.01) - TOLERANCE ± .010
3 PLACE (.001) - TOLERANCE ± .005
& ON FRACTIONAL DIMENSIONS ± 1/64
& ON ANGULAR DIMENSIONS ± 00°-30'
FINISHES ARE DESIGNATED BY ROOT MEAN SQUARE (R.M.S.) MICRO-INCH ROUGHNESS VALUES AND ARE THE MAXIMUM ROUGHNESS ACCEPTABLE. UNLESS OTHERWISE SPECIFIED, FINISH ROUGHNESS TO BE 125 OR BETTER.

RECOMMENDED MATERIAL AND HEAT TREAT

(23) MATERIAL C-1095 C.R. SPRING STEEL
HEAT TREAT NEUTRAL SALT, LOW NITRE QUENCH
HARDNESS R 30 N 66-69
COLOR TEMPER COLOR

(24) HEAT TREAT & COLOR TO BE DONE BY REMINGTON

(25) FOR BLANK ORDER PART #200042



REF. A 736 X

ALTERATIONS

ALT.	WAS	REF.	BY	DATE	
21	REDRAWN	12046	TJP	8-8-85	(M)
22	ADDED TYP.	13156	JRR	3-29-94	(M)
23	WAS H.T.	13760	RAM	7-16-97	
24	WAS H.T. AND COLOR TO BE DONE BY VENDOR	13760	RAM	7-16-97	
25	ADD BLANK #200042	13760	RAM	7-16-97	
26	ADD USE XP-100 R	13770	RAM	8-11-97	(V)

(26)

MODEL	PART NO.	PART USE
XP-100 R	17044	SAFETY SNAP WASHER
40X, XB, XCF, 40XB IFR	17044	SAFETY SNAP WASHER
XP 100	17044	SAFETY SNAP WASHER
7 LWT	17044	SAFETY SNAP WASHER
700 (ALL)	17044	SAFETY SNAP WASHER

DES. BY DATE	DRN. BY DATE	CHK. BY DATE	APP. BY DATE
	TJP 11-11-85	DSF 11-12-85	DSF 11-12-85

TITLE SAFETY SNAP WASHER

NUMBER B-17044

SCALE 10:1 | SUPERSEDES A-17044 REV. 29 | REFERENCE DCR #12046

REMINGTON ARMS CO. INC.
ILION RESEARCH DIV.

CV FILENAME - RES.700.B17044.SAFETY-CLIP.TJP

25 24 23 24 26

M24 00000210

NUMBER A-17047

REMINGTON ARMS CO. INC.
RESEARCH & DEV. DEPT.

SCALE 2/1 | SUPERSEDES-REFERENCE SK-A-1950

TITLE SPRING, HELICAL COMP.

DES. BY DATE	DRN. BY DATE	CHK. BY DATE	APP. BY DATE
	JWB 6/19/69		

FOR DETAILS, SEE PROCESS RECORD

MODEL	PART USE	QUAN.	SEE
700	SEAR SPRING		
40XB	SEAR SPRING		
40XCF	SEAR SPRING		
660	SEAR SPRING		
40XB-IFR	SEAR SPRING 20B TRIGGER		
(22) MOHAWK 600	SEAR SPRING		
7LWT	" "		(23)
SP-10 MAG.	MAGAZINE FOLLOWER PLUNGER SPRING		(24)
(26) XP-100R	SEAR SPRING		

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

RECOMMENDED MATL. & HEAT TREAT
Material .....
Heat Treat .....
Approval (By Date) .....

(21)

INSPECTION

1. To work freely in .151 dia. hole
2. To work freely on — dia. pin
3. (25) Load 5.8 to 7.0 lb. at .330 length (with set removed)
4. Solid Height .303 max.
5. Free Length .460 min.
6. Ends SQ + GR
7. Wind R H
8. Remove set (No [except for inspection)

MANUFACTURE

9. Wire dia. .026
10. Outside dia. .146
11. Free Length .485 (with set removed)
12. Coils 9.6 Active 11.6 Total

DESIGN DATA

13. Rate 41.14 lb./in.
14. Solid Stress 179,684 lb./sq. in.
15. Solid Load 7.46 lb.
16. Spring Index 4.62
17. Torsional Mod. G= 11.5 X 10⁶ lb./sq. in.
18. Concentric Corr. 1.341

This Spring must meet the requirements in the "Inspection" section. Figures given in the "Manufacture" section indicate the preferred Spring, but the Manufacturer may deviate from these at his own discretion. Figures in the "Design Data" section are based on those in the "Manufacture" section.

ALT.	WAS	REFERENCE	BY	DATE
(VA) 26	ADD USE XP-100R	13770	RLS	8/8/97
(M) 25	6.0 TO 6.8	12096	JWR	8-16-91
(M) 24	ADD USE	12316	TGB	10-12-88
(M) 23	ADD USE 7LWT	11667	DGB	12/8/82
22	ADD MOHAWK USE 600	8445	RCE	9-11-70
21	.153		JK	1/8/70
20	REVISED PER DRAWING	8179	JK	10-31-69

ALTERATIONS

TFA-3 REV. 2

A17047

22 24 23 25 21

M24 00000211

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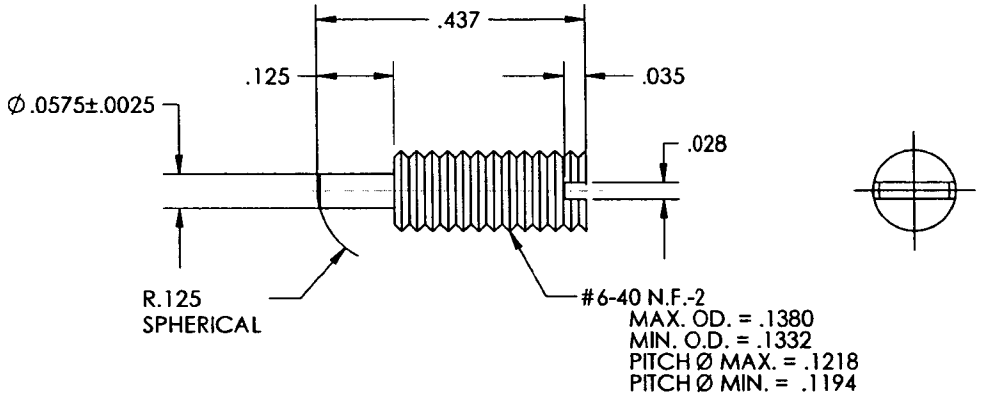
THIS DRAWING IS CAD MAINTAINED AND SHALL NOT BE SCALED

REVISIONS		
REV.	DATE	ECO NUMBER
35	04-30-07	07-0082
SHEET	ZONE	DESCRIPTION
1 OF 1	ALL	REDRAWN ON SOLIDWORKS
1 OF 1	8-D	UPDATE MATERIAL SPEC.
1 OF 1	8-D	UPDATE MATERIAL SPEC.

NOTES

1. MATERIAL: SAE/AISI 10XX,11XX,12XX SERIES STEEL .08-020% CARBON. NO LEADED MATERIAL.
2. HEAT TREATMENT: CARBURIZE .75% CARBON POTENTIAL
3. HARDNESS: H15n 80-92
4. FINISH: BLACK OXIDE
5. FOR BLANK DRAWING SEE B-91920
6. HEAT TREAT AND FINISH TO BE DONE BY REMINGTON



MODEL	PART NO.	PART USE
MOHAWK 600	17053	TRIGGER STOP SCREW
660	17053	TRIGGER STOP SCREW
I-FR	17053	SEAR SPRING STOP SCREW 2 OZ. TRIGGER
725	17053	TRIGGER STOP SCREW
722	17053	TRIGGER STOP SCREW
721	17053	TRIGGER STOP SCREW
40 XCF	17053	TRIGGER ENGAGEMENT SCREW 2 OZ. TRIGGER
40 XB	17053	TRIGGER ENGAGEMENT SCREW 2 OZ. TRIGGER
700	17053	FRONT TRIGGER SCREW
7	17053	FRONT TRIGGER SCREW

ANSI Y14.5M REV 1994 APPLIES
UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES

TOLERANCES
UNLESS OTHERWISE SPECIFIED:
X.X ± 0.030
X.XX ± 0.010
X.XXX ± 0.005
ANGLES ± 00° - 30'
SURF FINISH: 125 µin RMS
THIRD ANGLE PROJECTION

DESIGN DEPT.		DATE
DRAWN BY	RAW	04-30-07
MODELED BY	N/A	N/A
DESIGNED BY	N/A	02-01-62

Remington Arms Company
14 Hoefler Ave. Ilion, New York 13357

TITLE: SCREW

SIZE B | DWG. NO. 17053 | REV 35

SCALE: 5:1 | SHEET 1 OF 1

M24 00000212

19461 ⑤

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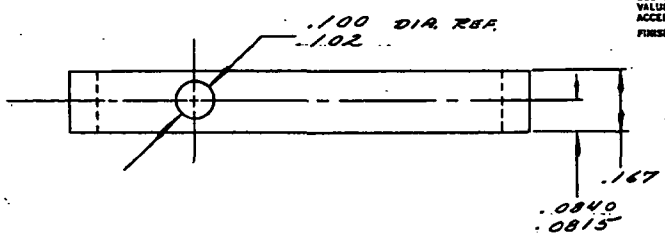
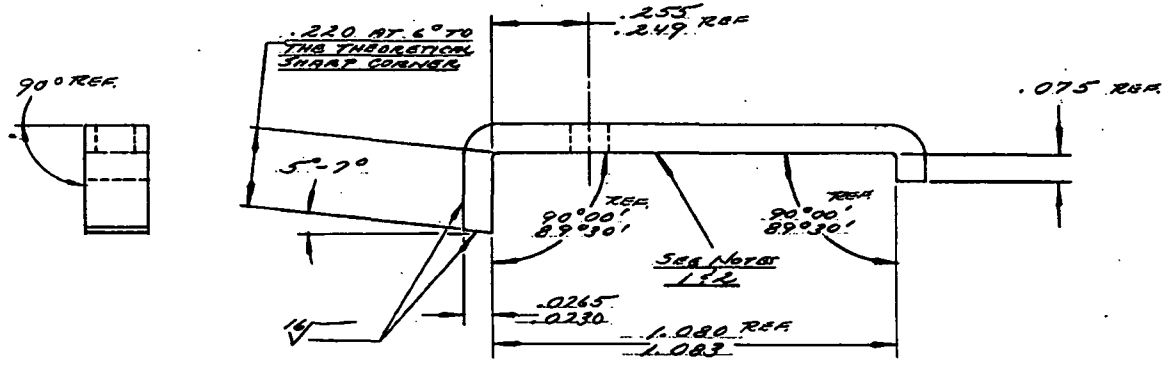
2 PLACE (.01) — TOLERANCE ± .010
3 PLACE (.001) — TOLERANCE ± .005
& ON FRACTIONAL DIMENSIONS ± 1/64
& ON ANGULAR DIMENSIONS ± 00° - 30'
FINISHES ARE DESIGNATED BY ROOT MEAN SQUARE (R.M.S.) MICRO-INCH ROUGHNESS VALUES AND ARE THE MAXIMUM ROUGHNESS ACCEPTABLE. UNLESS OTHERWISE SPECIFIED.
FINISH ROUGHNESS TO BE 125 OR BETTER.

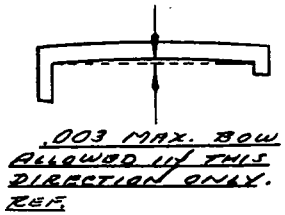
(22) RECOMMENDED MATERIAL AND HEAT TREAT
MATERIAL SEE C-91937
HEAT TREAT SEE BELOW
HARDNESS RISN-88/92
COLOR NONE
HEAT TREAT AND COLOR TO BE DONE BY REMINGTON P&S J. 3/21/84

(24) HEAT TREAT
CARBURIZE .70 C POTENTIAL
REF. ONLY .008/.015 CASE

ALTERATIONS					
ALT.	WAS	REF.	BY	DATE	
19	REVISED & REARRANGED	11839	TP	9/4/84	(17)
20	ADDED 40X	12643	WE	8-8-92	
21	ADD USE XP 100 R	13770	RLS	8/8/97	(19)
22	C-91921 ("A") (2) PL.	14332	RLS	7/14/06	
23	REMOVED ("B")	"	"	"	(21)
24	CYN. .008/.010 CASE	14AGT	RLS	7/12/11	(M)







FOR BLANK DRAWINGS SEE: C-91937 (23) (22)

NOTES:
1- PARTS MUST BE SMOOTH, CLEAN AND FREE OF BURRS.
2- PARTS MUST NOT ROCK WHEN INSIDE SURFACE RESTS ON A FLAT SURFACE. MAX. BEND, TWIST OR BOW ALLOWED IS .003.
3- PART MUST PASS FREELY BETWEEN PARALLEL SURFACES .1725 MAX APART.

(21) XP100R	19461	TRIGGER CONNECTOR	
(20) 40X ALL	19461	TRIGGER CONNECTOR	
M-7 ALL	19461	TRIGGER CONNECTOR	
700 ALL	19461	TRIGGER CONNECTOR	
MODEL	PART NO.	PART USE	

DES. BY DATE | DRN. BY DATE F. Remington 4-11-83 | CHK. BY DATE R. Anthony 4-6-83 | APP. BY DATE [illegible] 4/6/83

TITLE CONNECTOR

NUMBER C-19461 | SCALE 4:1 | SUPERSEDES C-19461 REV. 21 | REFERENCE

REMINGTON ARMS CO. INC. ILION RESEARCH DIV.

23 22 2A 22 21 20

M24 00000213

B-23220

DO NOT SCALE THIS DRAWING: WORK TO FIGURES UNLESS OTHERWISE NOTED.
TOLERANCES ON DECIMAL DIMENSIONS ARE:
1 PLACE (.1) - TOLERANCE ± .015
2 PLACE (.01) - TOLERANCE ± .010
3 PLACE (.001) - TOLERANCE ± .005
& ON FRACTIONAL DIMENSIONS ± 1/64
& ON ANGULAR DIMENSIONS ± 00°-30'
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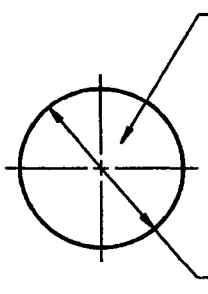
FINISH ROUGHNESS TO BE 125 √ OR BETTER.

RECOMMENDED MATERIAL AND HEAT TREAT
MATERIAL MFGR'S SPEC'S
HEAT TREAT
HARDNESS
COLOR
HEAT TREAT AND COLOR TO BE DONE BY REMINGTON

ALTERATIONS

ALT.	ITEM	REF.	BY	DATE
53	REVISED & REDRAWN	12778	WFP	2-7-92 (M)
54	ADD USE XP-100 R	13778	RAM	8-11-97
55	ADDED PART # 201797	14634	RJ	1-17-02
56	ADDED NOTE	14634	RJ	1-17-02 (MP)

DIMENSION "A"	PART NO.
3/32	23220
1/8	23221
5/32	23222
9/64 (.1406)	23223
1/4	23224
3/16	23225



(56) NOTE:
PART NO. 201797 SAME AS PART NO. 23223 EXCEPT TO BE PLATED WITH 0.0002 - 0.0004" HIGH PHOS. ELECTROLESS NICKEL. (BAKE AT 375°F FOR 24 HOURS). TO BE DONE BY REMINGTON.

MODEL	PART NO.	PART USE
7400	23223	ORIFICE BALL
1100	23222	OP. HANDLE DETENT BALL
40XB 40XC	23223	TRIGGER BALL FRONT
40XB 40XC	23222	SAFETY DETENT BALL
700 M-24	23225	SAFETY DETENT BALL
7 LW	23222	SAFETY DETENT BALL
700	23222	SAFETY DETENT BALL
XP-100	23222	SAFETY DETENT BALL
N-66	23224	SAFETY DETENT BALL
522	23223	SAFETY DETENT BALL
552/572	23223	SAFETY DETENT BALL
7400	23223	SAFETY DETENT BALL
7600	23223	SAFETY DETENT BALL
SP-10 MAG	23223	SAFETY DETENT BALL
M/870-1100	23223	SAFETY DETENT BALL

DES. BY DATE	DRN. BY DATE	CHK. BY DATE	APP. BY DATE
	TJP 8-8-87	DSF 6-9-87	TCD 2-6-89

TITLE: BALL

NUMBER	SCALE	SUPERSEDES	REFERENCE
B-23220	10X	B23220 6-8-87	

REMINGTON ARMS CO. INC.
ILION RESEARCH DIV.

(55)

MODEL	PART NO.	PART USE
7400	201797	ORIFICE BALL PLATED
XP-100 R	23222	SAFETY DETENT BALL

CV FILENAME - RES.1100.B23220.SAFETY-DETENT-BALL.TJP

56 55 54

C-26655

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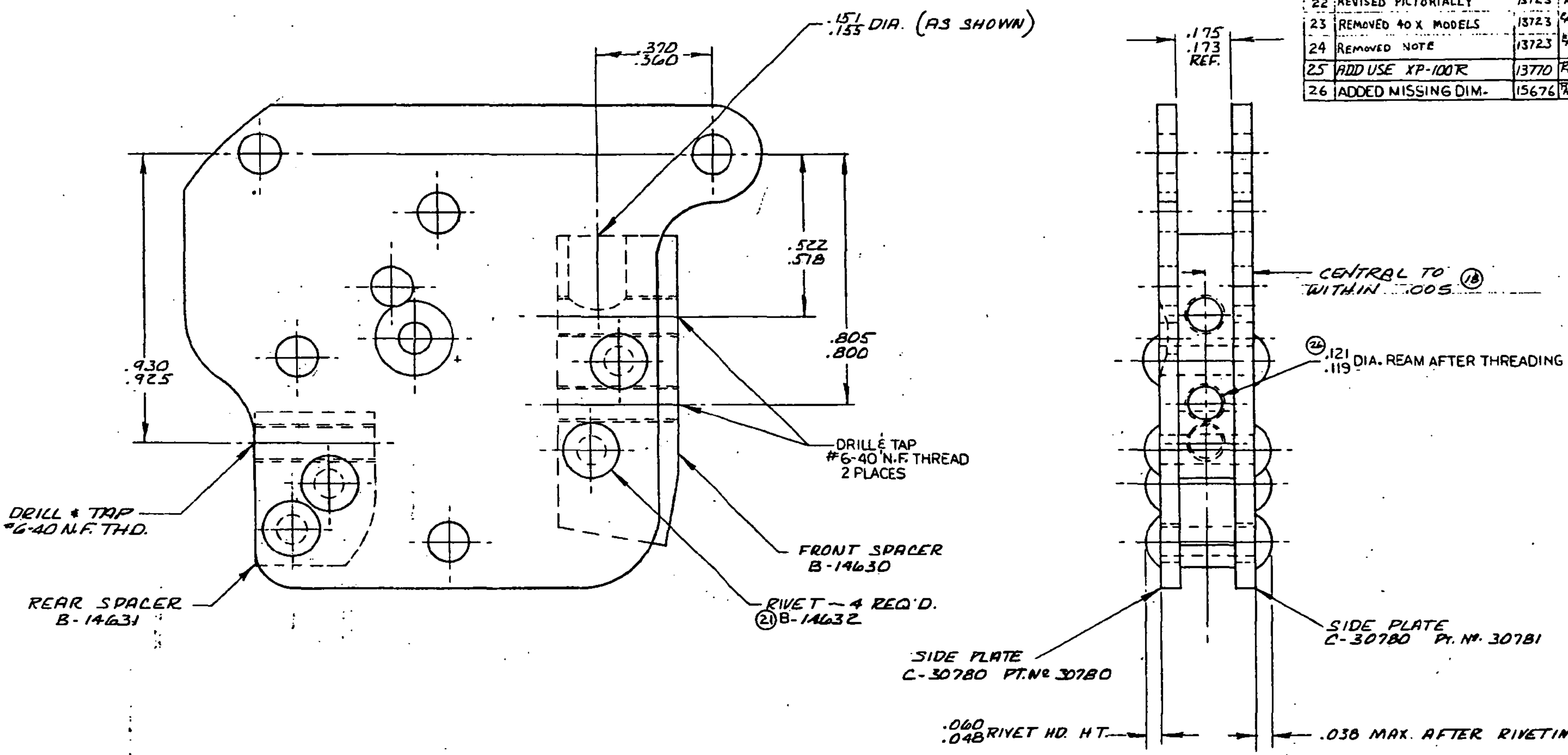
TOLERANCES ON DECIMAL DIMENSIONS ARE:
1 PLACE (.1) — TOLERANCE ± .010
2 PLACE (.01) — TOLERANCE ± .010
3 PLACE (.001) — TOLERANCE ± .002
± ON FRACTIONAL DIMENSIONS ± 1/64
± ON ANGULAR DIMENSIONS ± 0°-30'
FINISHES ARE DESIGNATED BY ... MICRO-INCH ROUGHNESS VALUES AND ARE THE MAXIMUM ROUGHNESS ACCEPTABLE UNLESS OTHERWISE SPECIFIED.
FINISH ROUGHNESS TO BE 125 OR BETTER.

RECOMMENDED MATERIAL AND HEAT TREAT
MATERIAL
HEAT TREAT
HARDNESS
COLOR BLACK OXIDE
HEAT TREAT AND COLOR TO BE DONE BY REMINGTON pg. 7/2/76

ALTERATIONS

NO.	ALTERATION	NO.	BY	DATE
17	REV. & REDWN.	10195		3/2/76
18	WAS CENTRAL TO WITHIN .005	10750		8/13/77
19	ADDED	11395		5-1-81
20	ADDED M-7 LWT.	11834		4/10/84
21	WAS A-14632	13102		1/13/88
22	REVISED PICTORIALLY	13723		4-3-97
23	REMOVED 40 X MODELS	13723		4-3-97
24	REMOVED NOTE	13723		4-3-97
25	ADD USE XP-100R	13770		8/8/97
26	ADDED MISSING DIM.	15676		11/24/...



MODEL	PART NO.	PART NAME
XP-100R		TRIGGER HOUSING ASSY COMPLETE
M-7 LWT. ALL		TRIGGER HOUSING ASSY. COMPLETE
M-700 ADL BDL VAR	"	TRIGGER HOUSING ASSY. COMPLETE
MOHAWK 600	26655	TRIGGER HOUSING ASS'Y. COMPLETE

E. MARTIN 4/23/68 — 22 JUNE 76
TRIGGER HOUSING ASS'Y (COMPLETE)
C-26655
REMINGTON ARMS CO., INC.

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

M24 00000215

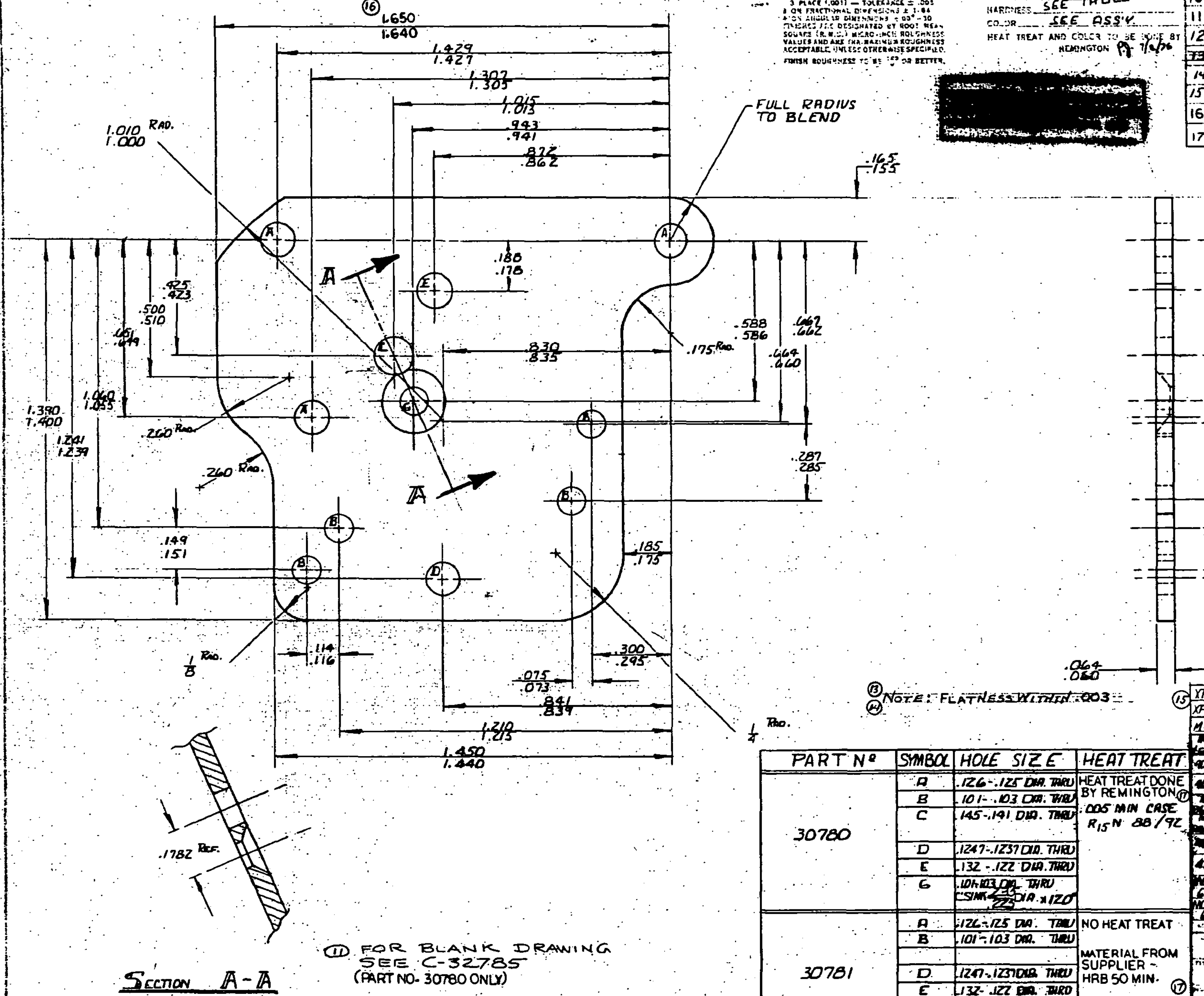
C-30780

DO NOT SCALE THIS DRAWING. WORK TO FIGURES UNLESS OTHERWISE NOTED: TOLERANCES ON DECIMAL DIMENSIONS ARE: 1 PLACE (.1) — TOLERANCE ± .010; 2 PLACE (.01) — TOLERANCE ± .010; 3 PLACE (.001) — TOLERANCE ± .005; ± ON FRACTIONAL DIMENSIONS ± 1/64; ± ON ANGULAR DIMENSIONS ± 0°-30'. FINISHES ARE DESIGNATED BY ROOT MEAN SQUARE (R.M.S.) MICRO-INCH ROUGHNESS VALUES AND ARE THE MAXIMUM ROUGHNESS ACCEPTABLE, UNLESS OTHERWISE SPECIFIED. FINISH ROUGHNESS TO BE 125 OR BETTER.

RECOMMENDED MATERIAL AND HEAT TREAT
MATERIAL C-1010 OR C-1020
HEAT TREAT SEE TABLE BELOW
HARDNESS SEE ASS'Y.
COLOR
HEAT TREAT AND COLOR TO BE DONE BY REMINGTON

[redacted]

ALTERATIONS				
10	REV. & REDWN.	10775		
11	ADDED	11198		
12	ADDED M-7 LWT.	11839		
13	ADDED FLATNESS NOTE	12[illegible]		
14	REVISED FLATNESS SPEC	12619		2/6/90
15	ADD USE XP-100R (2) PLC.	13770		8/8/9[illegible]
16	WAS 1.660/1.650	14256		8/25/00
17	ADDED HEAT TREAT NOTES	15729		3/2/05



MODEL	PART NO.	DESCRIPTION
XP-100R	30780	TRIGGER SIDE PLATE RIGHT
XP-100R	30781	TRIGGER SIDE PLATE LEFT
M-7 LWT	30780	TRIG. SIDE PLATE RE
[illegible]	30781	TRIG. SIDE PLATE - RIGHT
40X-CF	30781	" - LEFT
40X-CF	30780	" - RIGHT
[illegible]	30781	- LEFT
[illegible]	30780	" - RIGHT
[illegible]	30781	" - LEFT
40-XB	30780	" - RIGHT
MOHAWK 6.00	30781	TRIG. SIDE PLT. - LEFT
MOHAWK 600	30780	TRIG. SIDE PLT. - RIGHT

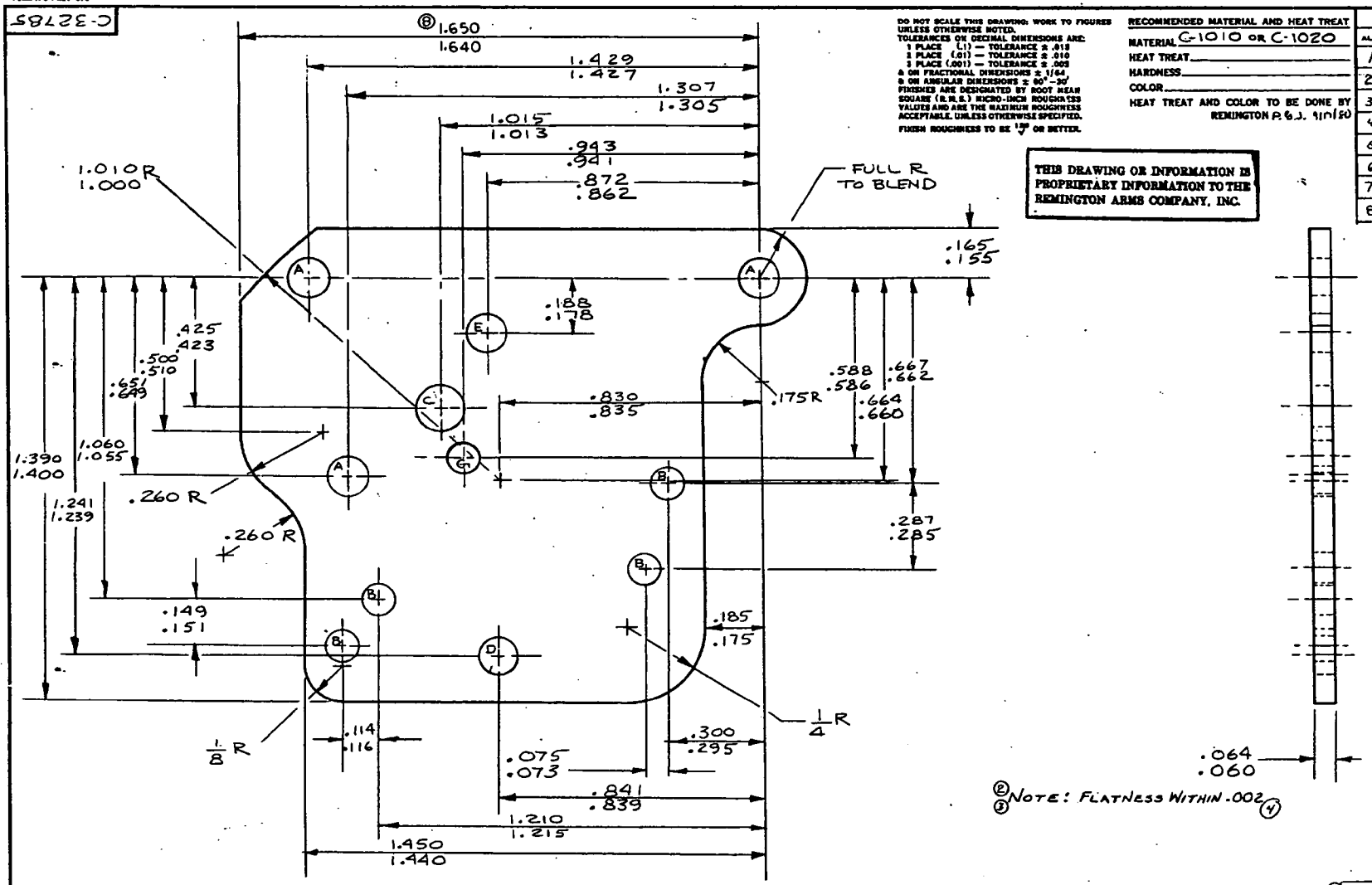
PART Nº	SYMBOL	HOLE SIZE	HEAT TREAT
30780	A	.126-.125 DIA. THRU	HEAT TREAT DONE BY REMINGTON (17) .005 MIN CASE $R_{15}N$ 88/92
	B	.101-.103 DIA. THRU	
	C	.145-.141 DIA. THRU	
	D	.1247-.1237 DIA. THRU	
	E	.132-.122 DIA. THRU	
	G	.101-.103 DIA. THRU CSINK .233/.223 DIA. x 120°	
30781	A	.126-.125 DIA. THRU	NO HEAT TREAT MATERIAL FROM SUPPLIER - HRB 50 MIN. (17)
	B	.101-.103 DIA. THRU	
	D	.1247-.1237 DIA. THRU	
	E	.132-.122 DIA. THRU	

F. MARTIN 6-15-76
TITLE: PLATE
SCALE 4X
C-30780
REMINGTON ARMS CO. INC.

M24 00000216

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

C-32785



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2 PLACE (.01) — TOLERANCE ± .010
3 PLACE (.001) — TOLERANCE ± .005
& ON FRACTIONAL DIMENSIONS ± 1/64
& ON ANGULAR DIMENSIONS ± 30' - 30"
FINISHES ARE DESIGNATED BY ROOT MEAN SQUARE (R.M.S.) MICRO-INCH ROUGHNESS VALUES AND ARE THE MAXIMUM ROUGHNESS ACCEPTABLE. UNLESS OTHERWISE SPECIFIED.
FINISH ROUGHNESS TO BE 125 OR BETTER.

RECOMMENDED MATERIAL AND HEAT TREAT
MATERIAL C-1010 OR C-1020
HEAT TREAT
HARDNESS
COLOR
HEAT TREAT AND COLOR TO BE DONE BY REMINGTON P.&.J. 9/10/50

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

ALTERATIONS					
ALT.	WAS	REF.	BY	DATE	
1	ADDED	11834	JWB	3/11/64	(17)
2	ADDED FLATNESS NOTE	12174	W.P.	8/7/68	(16)
3	REVISE FLATNESS SPEC	12519	RWM	3/6/70	(15)
4	CODE ERROR MADE ON PREVIOUS DCR	13526	RWM	12/1/71	(14)
5	REMOVED 40 XCF	13723	JWK	4-3-97	
6	REMOVED 40 XB	13723	JWK	4-3-97	(13)
7	ADD USE XP-100R	13770	RJS	8/8/77	(12)
8	WAS 1.660 / 1.650	14255	RWJ	8/25/00	

(2)(3) NOTE: FLATNESS WITHIN .002 (4)

PART NO.	SYMBOL	HOLE SIZE	HEAT TREAT
32785	A	.126-.125 DIA THRU	
	B	.101-.103 DIA THRU	
	C	.145-.141 DIA THRU	
	D	.1247-.1237 DIA THRU	
	E	.132-.122 DIA THRU	
	G	.101-.103 DIA THRU	

FOR FINISH DRAWING SEE C-30780

MODEL	PART NO.	PART USE
(7) XP-100R	32785	TRIGGER SIDE PLATE
M-7 LWT.		TRIG. SIDE PLT. (1)
700 CLASSIC	"	" " " RIGHT
M-700 LH	32785	" " " LEFT
(5)		
M-700 RH	"	" " " "
(6)		
MOHAWK 600	32785	TRIG. SIDE PLT. RIGHT

DES. BY DATE	DRN. BY DATE	CHK. BY DATE	APP. BY DATE
	VB 4-18-80	F.G.M. 4-29-80	JWB 5/2/80

TITLE PLATE, BLANK

NUMBER	SCALE	SUPERSEDES	REFERENCE
C-32785	4X		DCC #11193

REMINGTON ARMS CO. INC.
ILION RESEARCH DIV.

M24 00000217

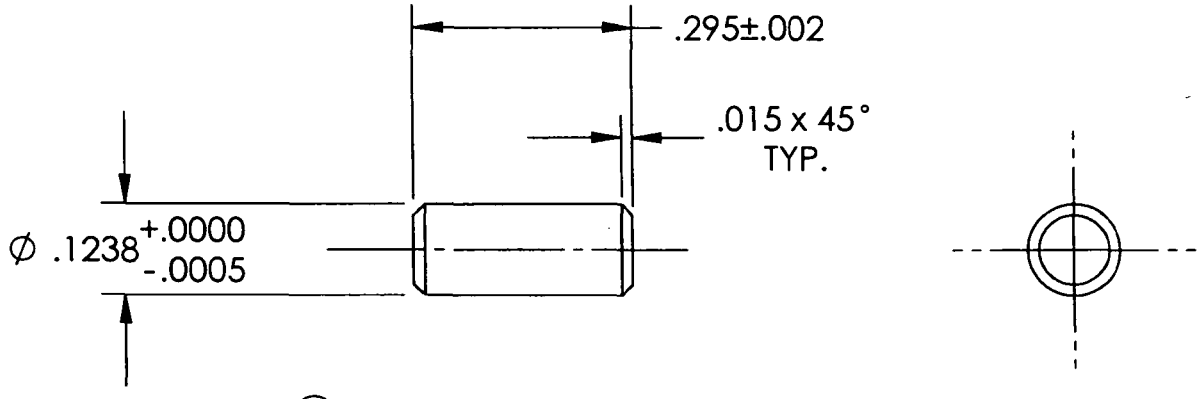
SCAN ④

DRAWING No. A-51468	REMINGTON ARMS COMPANY, INC ILION, N.Y.	ADDITIONAL USES	RECORD OF ALTERATIONS
			③ REDRAWN FOR PREVIOUS REVISIONS
MODEL 700 SCALE 4 X PART No.			SEE SAME DATED 5/1/46 & ADDED HEAT
PART TRIGGER ASSEMBLY			TREAT TO BE DONE AT REMINGTON & MAT'L
TOOL DUMMY ASSEMBLY PIN			W1 DRILL ROD WAS REM SPEC 19(DLK/AJL-019
OPERATION ASSEMBLE			(12/6/04)) ④ REMOVED R/C 58-60, HARDEN
			& GRIND, HEAT TREAT TO BE DONE AT REMINGTON
SUP'D's DWG. No. A-51468 CHECKED BY DATE			DLK/GHB 12/13/06)
DESIGNED BY DATE TRACED			
DRAWN DLK 12/6/04 APPROVED			

TOLERANCES NOT OTHERWISE GIVEN

1 PLACE (.1) TOLERANCE ± .05
2 PLACE (.01) TOLERANCE ± .015
3 PLACE (.001) TOLERANCE ± .005
ANGULAR DIMEMSIONS TOLERANCE ± 0° 30'

SW FILE NAME 51468 REV 4
ARC: PDMW TOOL DESIGN
RIFLES_TOOL (C'FIRE_TOOL)
FILE: TCF-BOLT ACTION DIR M700_TOOL
TDR No. GH BENNETT



③④ MAT'L: W1 DRILL ROD

NOTE:
SEE B-24475
PART # 24484
FOR BLANK

M24 00000218

B-91128

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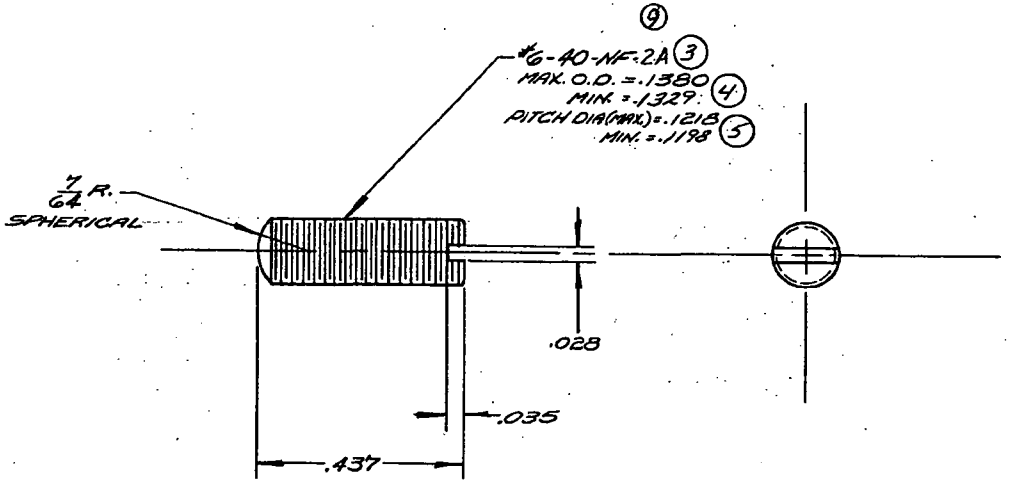
TOLERANCES ON DECIMAL DIMENSIONS ARE:
1 PLACE (.1) — TOLERANCE ± .015
2 PLACE (.01) — TOLERANCE ± .010
3 PLACE (.001) — TOLERANCE ± .005
& ON FRACTIONAL DIMENSIONS ± 1/64
& ON ANGULAR DIMENSIONS ± 00°-30'
FINISHES ARE DESIGNATED BY ROOT MEAN SQUARE (R.M.S.) MICRO-INCH ROUGHNESS VALUES AND ARE THE MAXIMUM ROUGHNESS ACCEPTABLE, UNLESS OTHERWISE SPECIFIED.
FINISH ROUGHNESS TO BE $\frac{125}{}$ OR BETTER.

RECOMMENDED MATERIAL AND HEAT TREAT
MATERIAL 08/.20 CARB. STEEL
(8) HEAT TREAT Carburize (.75% Potential)
HARDNESS
COLOR NITRE BLACK
HEAT TREAT AND COLOR TO BE DONE BY REMINGTON
JDS 5-15-00 DEC 6/5/74

ALTERATIONS

ALT.	WAS	REF.	BY	DATE	
1	ADDED	11198	VB	4/15/80	
2	ADD USE 7LWT	11667	DEB	11/5/81	
3	#6-40-NF-2		JTP	6/12-83	
4	.1380/.1332		"	"	
5	.1218/.1194		"	"	
6	Add use XP-100	12337	MMH	1/6/87	(6)
7	ADD USE XP-100R	13770	RLS	9/8/97	(7)
8	CYN. HDN. .002/.005 Case	14205	RLS	5/15/00	
9	3A	"	"	"	(9)



(1) FOR BLANK DRAWING SEE B-91922

(7) XP-100R		TRIGGER ENGAGEMENT SCREW
(6) XP-100		SEAR BLOCK STOP SCREW
(1) 7LWT		TRIGGER ENGAGEMENT SCR.
40XB-BR		TRIGGER ENGAGEMENT SCR.
40XR		" " "
40XC		" " "
40XB		" " "
700ALL		TRIGGER ENGAGMENT SCR.

MODEL	PART NO.	PART USE	SEE
DES. BY DATE	DRN. BY DATE	CHK. BY DATE	APP. BY DATE
	J. KAST 6-5-74	JWB 6/11/74	JWB 6/11/74

TITLE: SCREW

NUMBER	SCALE	SUPERSEDES	REFERENCE
B-91128	4:1		

REMINGTON ARMS CO. INC. ELION RESEARCH DIV.

M24 00000219

C- 91852

ISO VIEWS
SCALE 5:1

DO NOT SCALE THIS DRAWING; WORK TO FIGURES UNLESS OTHERWISE NOTED.
TOLERANCES ON DECIMAL DIMENSIONS ARE:
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3 PLACE (.001) - TOLERANCE ± .005
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& ON ANGULAR DIMENSIONS ± 00° -30'
FINISHES ARE DESIGNATED BY ROOT MEAN SQUARE (R.M.S.) MICRO-INCH ROUGHNESS VALUES AND ARE THE MAXIMUM ROUGHNESS ACCEPTABLE, UNLESS OTHERWISE SPECIFIED.

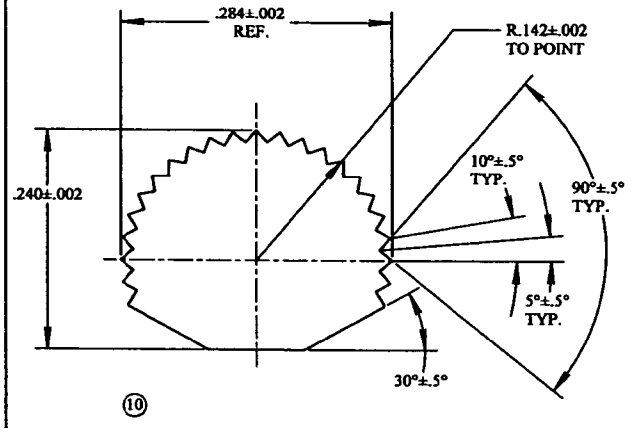
FINISH ROUGHNESS TO BE 125 OR BETTER.

MATERIAL AND HEAT TREAT

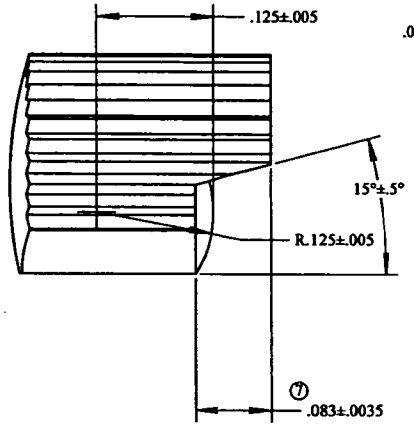
MATERIAL: HD 1000
HEAT TREAT:
HARDNESS:
FINISH:

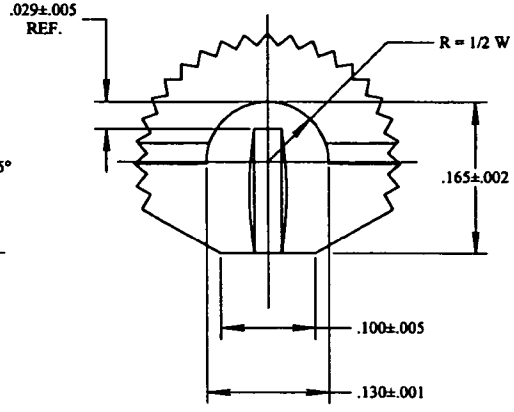
HEAT TREAT AND COLOR TO BE DONE BY REMINGTON

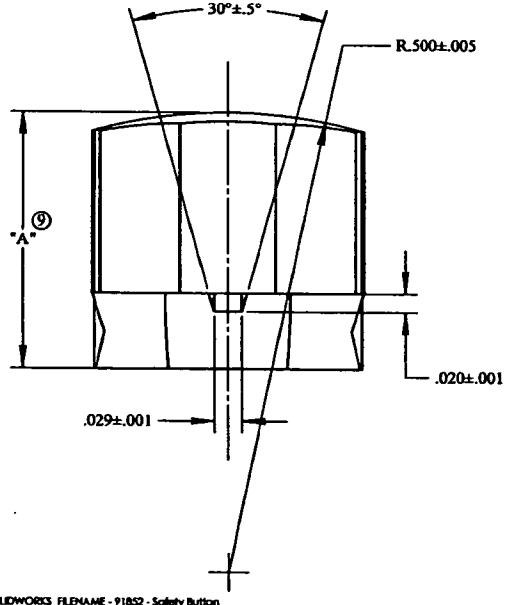
ALTERATIONS				
ALT.	WAS	REF.	BY	DATE
6	REDRAWN ON SOLIDWORKS	15462	RAW	4-22-04
7	.083±.0035 WAS .080±.002	15462	RAW	4-22-04 (M)
8	ADDED PART NO. 202904	16095	RAW	11-7-05
9	TABULATED "A" DIM.	16095	RAW	11-7-05
10	REMOVED NOTE	16095	RAW	11-7-05 (#7)



(10)







(9)

PART NO.	"A" DIM.
91852	.280±.002
202904	.330±.002

NOTE:

1. □ DIMENSIONS SHOWN WITH THIS SYMBOL WILL BE SUBJECT TO CONTROL AND INSPECTION AS SPECIFIED IN THE PROCESS RECORD OR PURCHASED PARTS INSPECTION DOCUMENTATION.

2. (ST) DIMENSION SHOWN WITH THIS SYMBOL ARE SIGNIFICANT AND MUST HAVE CpK VALUES GREATER THAN 1.33.

3. FOR VENDED COMPONENTS ALL SAMPLE SUBMISSIONS ARE TO BE SUBMITTED IN ACCORDANCE TO THE PUBLICATION "PRODUCTION PART APPROVAL PROCESS" AS PUBLISHED BY THE AUTOMOTIVE INDUSTRY ACTION GROUP (AIAG), 1993, LEVEL 3.

4. ALL GEOMETRIC TOLERANCES AND GAGE DIMENSION IMPLY INSPECTION FOR CONFORMANCE.

MODEL	PART NO.	PART USE
(8) M-40 SSA	202904	SAFETY BUTTON
40 X	91852	SAFETY BUTTON
7	91852	SAFETY BUTTON
700	91852	SAFETY BUTTON

DES. BY DATE | DRN. BY DATE: RAW 4-22-04 | CHK. BY DATE

TITLE: SAFETY BUTTON

NUMBER: C- 91852 | SCALE 10:1, 5:1 | SUPERSEDES | REFERENCE

Remington

SOLIDWORKS FILENAME - 91852 - Safety Button

9 10 9 7 8

21616-J

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& ON ANGULAR DIMENSIONS ± 00° - 30'
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FINISH ROUGHNESS TO BE $\frac{125}{\sqrt{}}$ OR BETTER.

RECOMMENDED MATERIAL AND HEAT TREAT
MATERIAL HD 1000 DENSITY 7.2 GM/CC
HEAT TREAT
(13) HARDNESS RF 65-85
COLOR
[redacted] COLOR TO BE DONE BY REMINGTON P.S.J. 4/10/80

ALTERATIONS

ALT.	WAS	REF.	BY	DATE	
1	.025	11694	[illegible]	3/24/82	
2	.320	"	"	"	
3	REDIMENSIONED 1.179 / 1.175	"	"	"	
4	ADD USED 7 LWT	"	"	"	
5	ADDED 1.433	"	"	"	(5A)
6	" VIEW	11698	"	4/5/83	
7	" 1.485	"	"	"	
8	" RESIN IMPREGNATE	"	"	"	
9	1.179 / 1.175	"	"	"	(9A)
10	.172 - .170 DIM.	11878	R.A.	7/14/86	
11	ADDED 1.308 DIM.	"			
12	REMOVED .380 DIM.	"			
13	REMOVED .969-.967 DIM.	"	R.A.	4/28/87	(11)
14	2.240/2.220	11992	RS		(12)
15	ADDED HARDNESS SPEC.	12441	RLS	8-16-88	(13)
16	ADDED 15° ANGLE	12527	[illegible]	7/27/90	(14)
17	ADD USE XP-100R	13770	RLS	8/8/97	(15)

NOTE
NO BURRS WIDER THAN PART THICKNESS PERMITTED PART MUST WORK FREELY IN .1725" WIDE SLOT

.3625 R REF
.350 R
.330
.010 7 PLACES
.025 R

SECTION A-A
SCALE 10:1

.225
9°
.030 R
.005 R MAX.
90° ± 00°15'
1.079 1.077
1.308 TO SHARP CORNER
1.129 1.125
1.485
1.835
1.433
.050 R
.380 R
.03 .04 R
.090 R
.100
.462
2.240 2.210
.172 .168
.010 .005
.020 R
.005 R TYP
16½°

30° 4 PLACES
.009 ± .001 4 PLACES
.650 R
.005 ± .001 4 PLACES

SECTION IB-IB
SCALE 10X
RELIEF SHOWN IN SECTION B-B TO RUN ENTIRE PERIPHERY OF THE .170 - .172 DIM - TO RUN OUT ON .050 R & 1.129 - 1.125 DIM. (9) TO BE DONE BY POWDER METAL BOTH SIDES

.430 R
.540 R
.450 R
.045 R
.090 R
1.3791 REF
1.380 R
.0502 REF

.015 R PERMISSIBLE ON ALL CORNERS EXCEPT THOSE OTHERWISE SPECIFIED.

FOR FINISH DRAWING SEE C-15280

(8) RESIN IMPREGNATE

MODEL	PART NO.	PART USE
(11) XP-100R		TRIGGER
(4) 7 LWT		TRIGGER
700 CLASSIC		TRIGGER
40XB		TRIGGER
700 VAR		TRIGGER
700 ADL 700 BDL		TRIGGER

DES. BY DATE	DRN. BY DATE	CHK. BY DATE	APP. BY DATE
	B 4-1-80	F.G.W. 4-3-80	JWB 4/5/80

TITLE TRIGGER BLANK

NUMBER	SCALE	SUPERSEDES	REFERENCE
C-91912	4:1		Doc #11193

REMINGTON ARMS CO. INC.
ILION RESEARCH DIV.

M24 00000221

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

L1616-D

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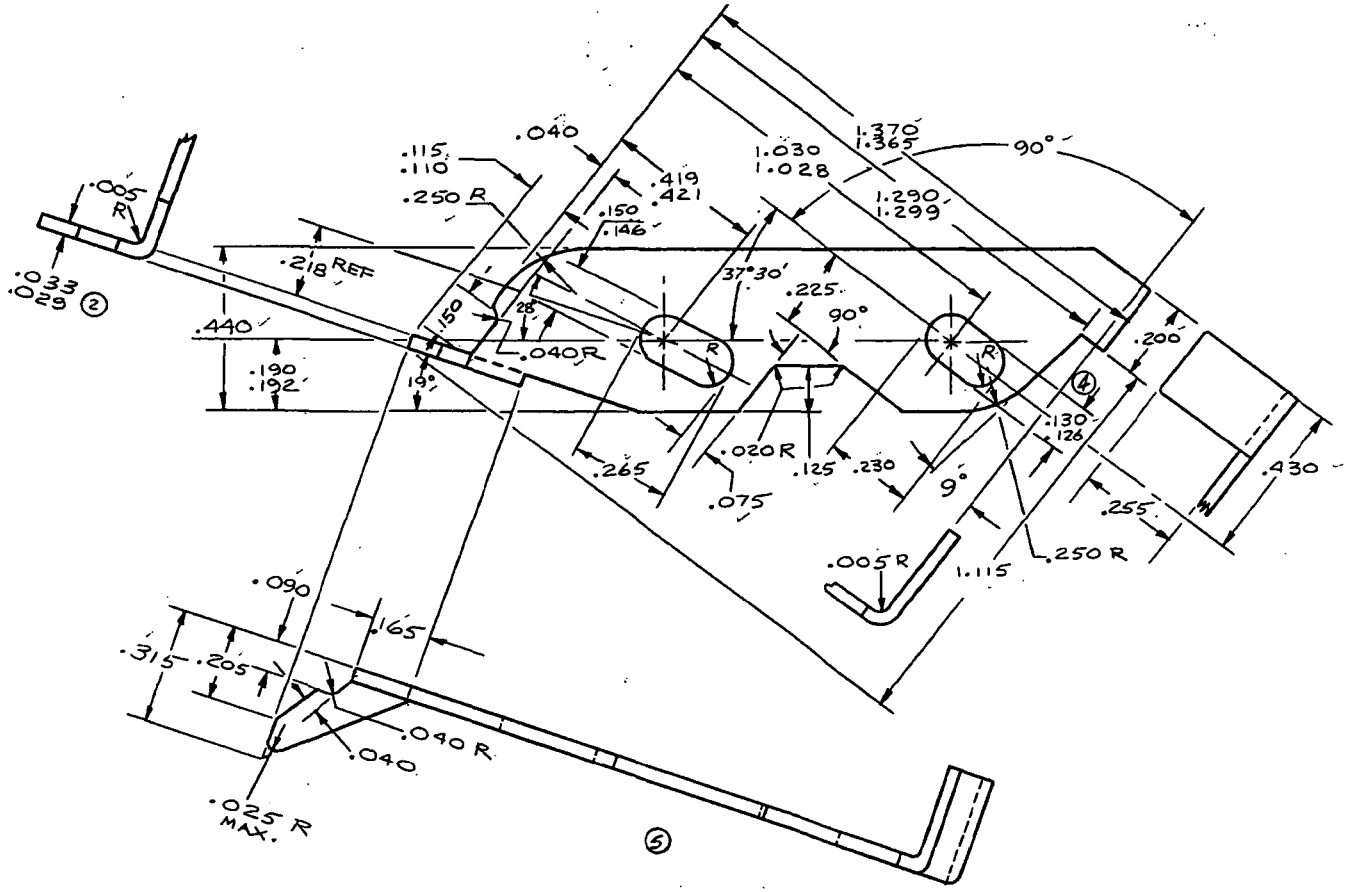
FINISH ROUGHNESS TO BE 125 OR BETTER.

RECOMMENDED MATERIAL AND HEAT TREAT
MATERIAL C-1010-1020
HEAT TREAT
HARDNESS
COLOR
HEAT TREAT AND COLOR TO BE DONE BY REMINGTON

ALTERATIONS				
ALT.	WAS	REF.	BY	DATE
1	C-91717	11335	PH	2-19-81
2	.035/.031	11525	KB	3-27-81
3	REMOVED NOTE	"	"	"
4	.136-.126	11879	RB	8-7-84
5	REMOVED COINED AREA	"	RB	8-7-84
6	REMOVED .035-.031 DIA.	"	RB	8-7-84

FOR FINISH DRAWING SEE C-15478



700 CLASSIC		BOLT STOP RELEASE
700 VAR		BOLT STOP RELEASE
40X-B		" " "
700 ADL 700 BDL		BOLT STOP RELEASE
MODEL	PART NO.	PART USE

DES. BY DATE	DRN. BY DATE	CHK. BY DATE	APP. BY DATE
	VB 4-16-80	HART 4-17-80	JWB 4/19/80

TITLE: BOLT STOP RELEASE BLANK

NUMBER	SCALE	SUPERSEDES	REFERENCE
C-91917	4X		DCE #11193

REMINGTON ARMS CO. INC. ILION RESEARCH DIV.

02616-8

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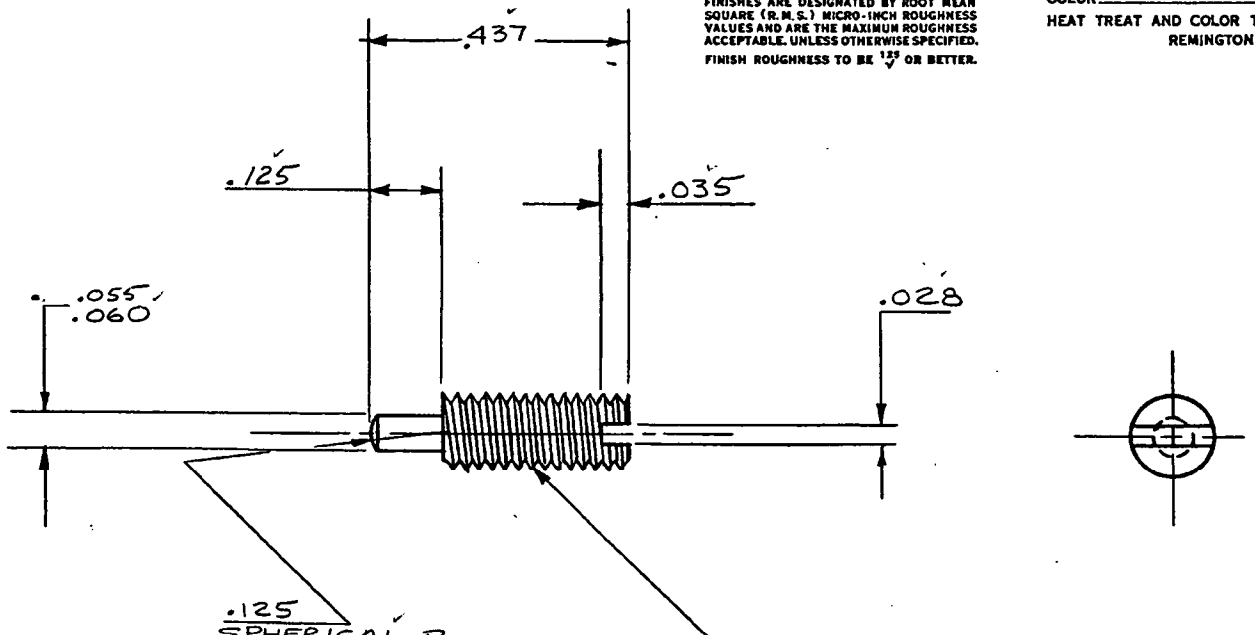
FINISH ROUGHNESS TO BE 125 OR BETTER.

RECOMMENDED MATERIAL AND HEAT TREAT
MATERIAL 08/.20 CARB STEEL
HEAT TREAT
HARDNESS
COLOR
HEAT TREAT AND COLOR TO BE DONE BY REMINGTON

ALTERATIONS				
ALT.	WAS	REP.	BY	DATE
1	ADD USE 7LW7	11667	DES	12/8/82
2	Removed XR100 Part Use	12357	[illegible]	1/6/87 (4)
3	ADD USE XP-100R	13770	TRLS	8/8/97 (5)



FOR FINISH DRAWING
SEE B-17053

MODEL	PART NO.	PART USE
(3) XP-100R		TRIGGER SCREW FRONT BLANK
(1) 7LW7		TRIG. SCREW FRONT
MOHAWK 600		TRIGGER STOP SCR
700 VAR		TRIGGER SCR FRONT
(5) ~~XP100~~		~~SEAR BLOCK STOP SCREW~~
700ADL 700BDL		TRIGGER SCR. FRONT

DES. BY DATE	DRN. BY DATE	CHK. BY DATE	APP. BY DATE
	V B 4-15-80	HART 4-17-80	JWB 4/18/80

TITLE: SCREW BLANK

NUMBER	SCALE	SUPERSEDES	REFERENCE DAL
B-91920	5X		#11204

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ILION RESEARCH DIV.

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3 2 1

FORM-TFB REV. 477 U.S.A.

M24 00000223

22616-8

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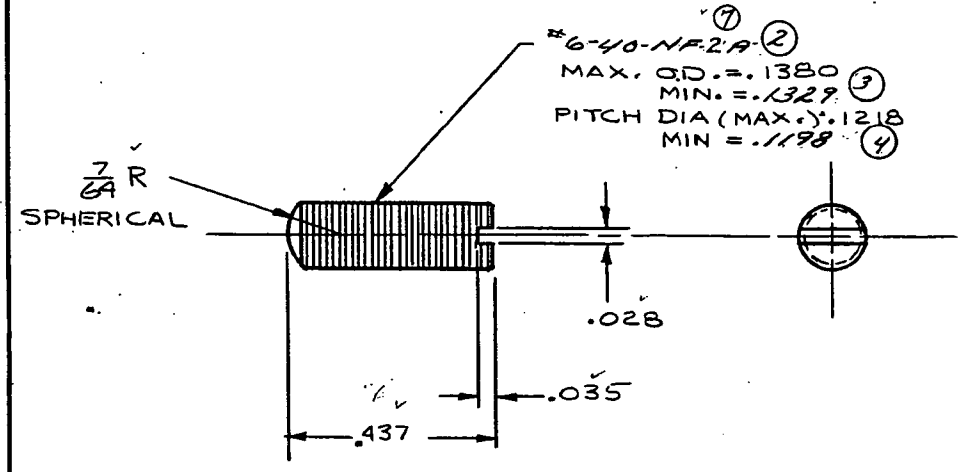
FINISH ROUGHNESS TO BE 125 OR BETTER.

RECOMMENDED MATERIAL AND HEAT TREAT
MATERIAL: 08/20 CARB STEEL
HEAT TREAT
HARDNESS
COLOR
HEAT TREAT AND COLOR TO BE DONE BY REMINGTON P&J. 9/17/80

ALTERATIONS

ALT.	WAS	REF.	BY	DATE	
1	ADD USE 7LWT	11667	DCB	11/9/82	
2	#6-34-NF-2		TJT	4/19/82	
3	.1380/.1282		"	"	
4	.1218/.1194		"	"	
5	ADD USE XP-100	12337	[illegible]	1/16/84	(H)
6	ADD USE XP-100R	13770	RLS	8/8/87	(M)
7	3A	14205	RLS	5/15/88	(N)



FOR FINISH DRAWING
SEE B-91128

MODEL	PART NO.	PART USE
(6) XP-100R		TRIGGER ENGAGEMENT SCREW
(5) XP-100		SEAR BLOCK STOP SCREW
(1) 7LWT		TRIGGER ENGAGEMENT SCR.
40XB-BR		TRIGGERENGAGEMENT-SCR.
40XR		↕
40XC		↕
40XB		↕
700 ALL		TRIGGERENGAGEMENT-SCR

DES. BY DATE	DRN. BY DATE	CHK. BY DATE	APP. BY DATE
	BA 4-15-80	HART 4-16-80	JWB 4/18/80

TITLE: SCREW BLANK

NUMBER	SCALE	SUPERSEDES	REFERENCE
B-91922	4X		# 11193

REMINGTON ARMS CO. INC.
ILION RESEARCH DIV.

FORM TFB REV. 477 N.H.S. 19 1953

M24 00000224

DES. BY DATE	DRN. BY DATE	CHK. BY DATE	APP. BY DATE
	V B 4-15-80	HART 4-16-80	J W B 4/18/80

TITLE: SCREW BLANK

NUMBER	SCALE	SUPERSEDES	REFERENCE
A-91926	4X		DCR # 11193

REMINGTON ARMS CO. INC.
ILION RESEARCH DIV.

MODEL	PART NO.	PART USE
700 ADL		TRIGGER STOP SCREW
700 BDL		〃
700 VAR		〃
700 CLASSIC		〃
7LW7		〃 (1)
XP-100R		TRIGGER STOP SCREW (2)

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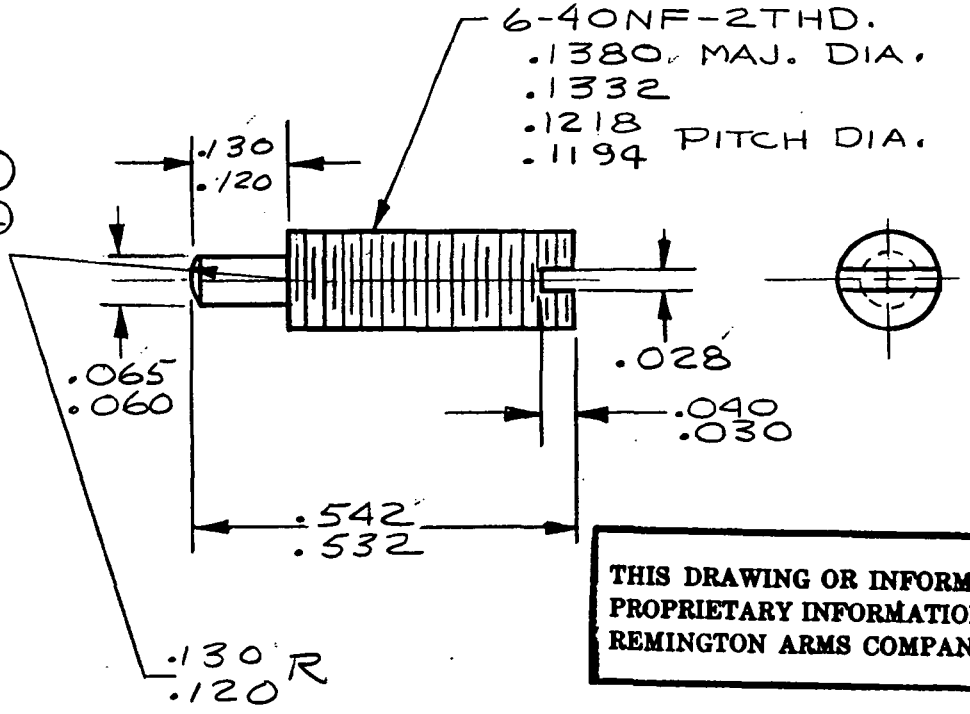
FINISH ROUGHNESS TO BE $\frac{125}{\sqrt{}}$ OR BETTER.

RECOMMENDED MATERIAL AND HEAT TREAT
MATERIAL 08-.20 CARBON STL
HEAT TREAT
HARDNESS
COLOR
HEAT TREAT AND COLOR TO BE DONE BY REMINGTON P.S.J. 9/17/80



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FOR FINISH DRAWING SEE A-15481

ALT.	WAS	REF.	BY	DATE
(W) 2	ADD USE XP-100R	13770	RS	8/8/97
1	ADD USE 7LW7	11667	DEB	12/6/82

ALTERATIONS

92616-A

1/2

FORM TFA REV 170 H.H.S 19 1153•

M24 00000225

C- 91937

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TOLERANCES ON DECIMAL DIMENSIONS ARE:
1 PLACE (.1) ±.015
2 PLACE (.01) ±.010
3 PLACE (.001) ±.005
FRACTIONS ±1/64
ANGLES ±0.50°
FINISHES ARE DESIGNATED BY ROOT MEAN SQUARE (RMS) MICRO-INCH ROUGHNESS VALUES AND ARE THE MAXIMUM ROUGHNESS ACCEPTABLE. UNLESS OTHERWISE SPECIFIED.

FINISH ROUGHNESS TO BE 125μin OR BETTER.

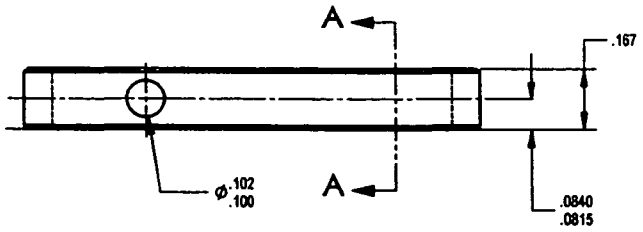
MATERIAL AND HEAT TREAT

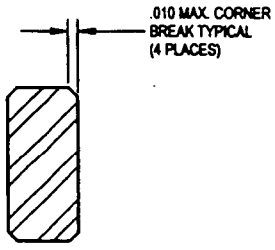
MATERIAL A.I.S.I. 1010
HEAT TREAT CARBURIZE .039/.015" DEPTH, .70C POTENTIAL
HARDNESS FILE HARD
(7) FINISH BRIGHT
~~HEAT TREAT AND COLOR TO BE DONE BY REMINGTON~~

ALTERATIONS				
ALT.	WAS	REF.	BY	DATE
6	REVISED AND REDRAWN	14188	RAW	3-14-00
7	ADDED BRIGHT-REMOVED NOTE.	16176	RAW	2-7-06

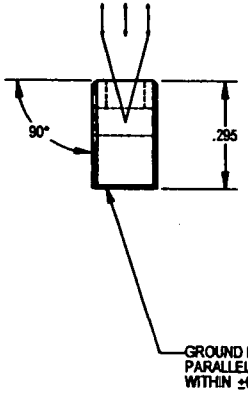
NOTES:

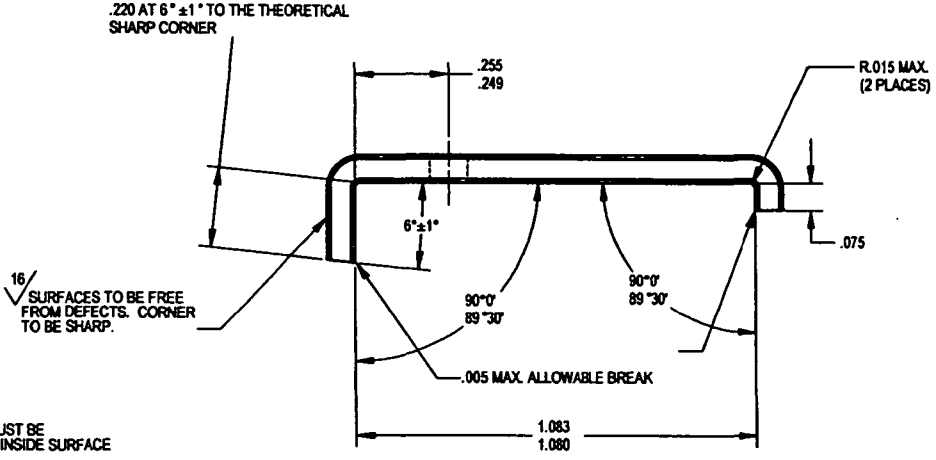
1. PARTS MUST NOT ROCK WHEN INSIDE SURFACE RESTS ON AN FLAT SURFACE. MAX. BEND, TWIST, OR BOW ALLOWED IS .003
2. PARTS MUST BE SMOOTH, CLEAN AND FREE OF BURRS.
3. PART MUST PASS FREELY BETWEEN PARALLEL SURFACES .1725 MAX. APART
4. THE HEAT TREATMENT SPECIFIED AT THE TOP OF THIS DRAWING IS AN INTERMEDIATE HEAT TREATMENT
5. NOTES 1, 2, AND 3 APPLY BOTH BEFORE AND AFTER INTERMEDIATE HEAT TREATMENT (SEE NOTE #4)

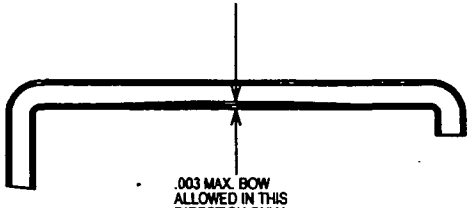


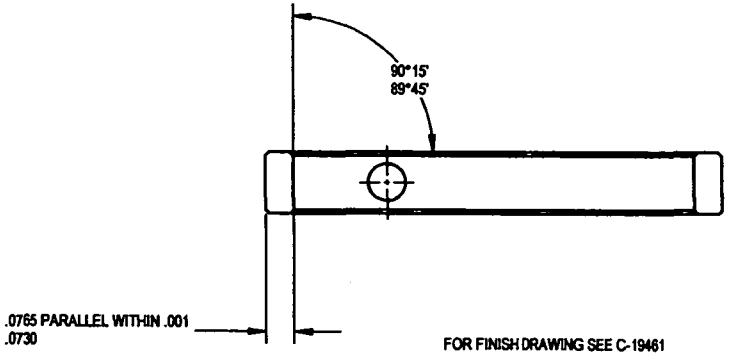


SECTION A-A
SCALE 10 : 1









FOR FINISH DRAWING SEE C-19461

M/7	91937	TRIGGER CONNECTOR
700	91937	TRIGGER CONNECTOR
MODEL	PART NO.	PART USE
DES. BY DATE	DRN. BY DATE RAW 3-14-00	CHK. BY DATE
TITLE	CONNECTOR - BLANK	
NUMBER C- 91937	SCALE 4:1	SUPERSEDES
	REFERENCE DCR 14166	

Remington

SOLIDWORKS FILENAME - c-91937

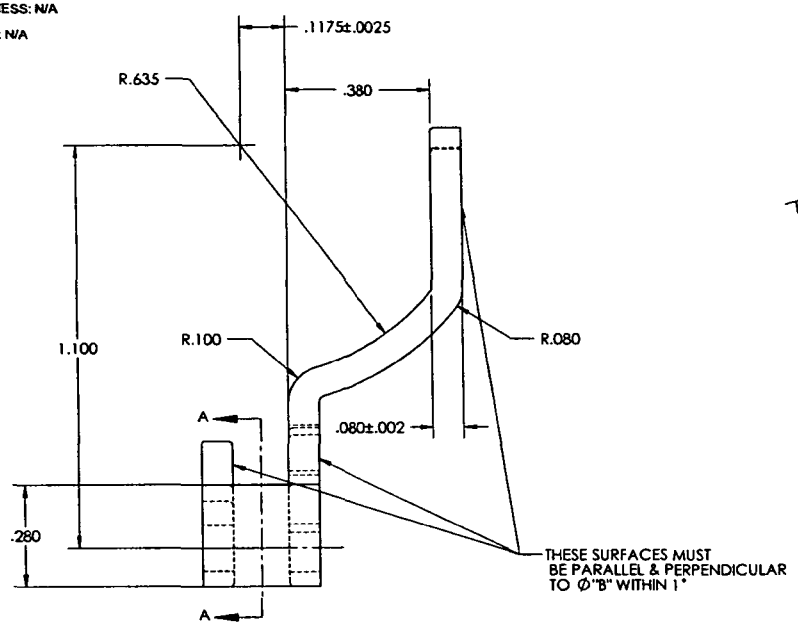
7

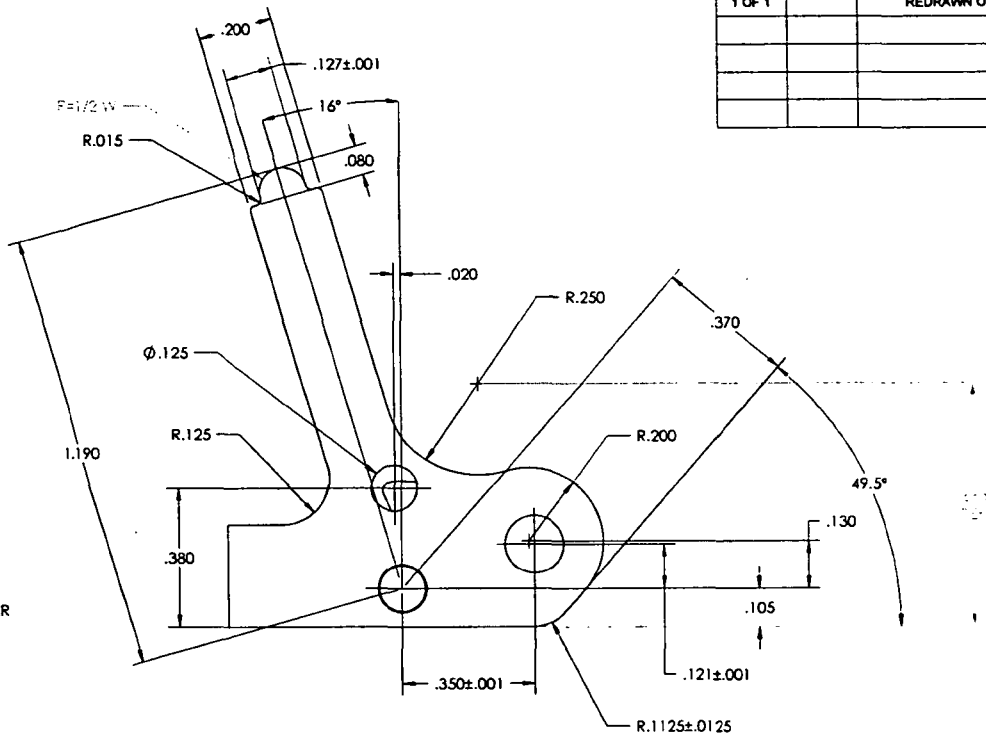
THIS DRAWING IS CAD MAINTAINED AND SHALL NOT BE SCALED

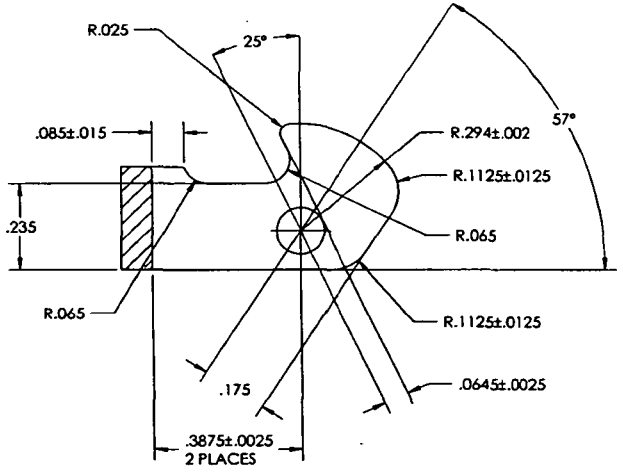
NOTES

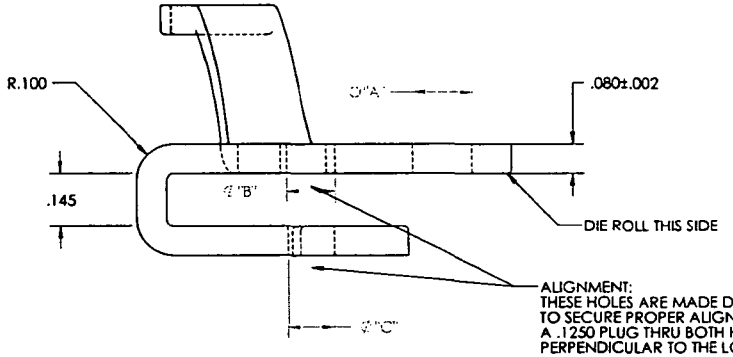
1. MATERIAL: C 1020 ANNEALED
2. HEAT TREATMENT: STRESS RELIEF AFTER BENDING
3. HARDNESS: N/A
4. FINISH: N/A

REVISIONS		
REV.	DATE	ECO NUMBER
03	11/7/2006	06-0194
SHEET	ZONE	DESCRIPTION
1 OF 1		REDRAWN ON SOLIDWORKS









M24 00000227

PART NO.	Ø "A" MFG. DIM'S.	Ø "B" MFG. DIM'S.	Ø "C" MFG. DIM'S.	Ø "A" AFTER HEAT TREAT DIM'S.	Ø "B" AFTER HEAT TREAT DIM'S.	Ø "C" AFTER HEAT TREAT DIM'S.
92212	.1593 .1573	.1335 .1315	.1267 .1259	.1586 .1566	.133 .131	.1262 .1254
96026	.1908 .1883	.1335 .1315	.1267 .1259	.190 .188	.133 .131	.1262 .1254

ANSI Y14.5M REV 1994 APPLIES
UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES

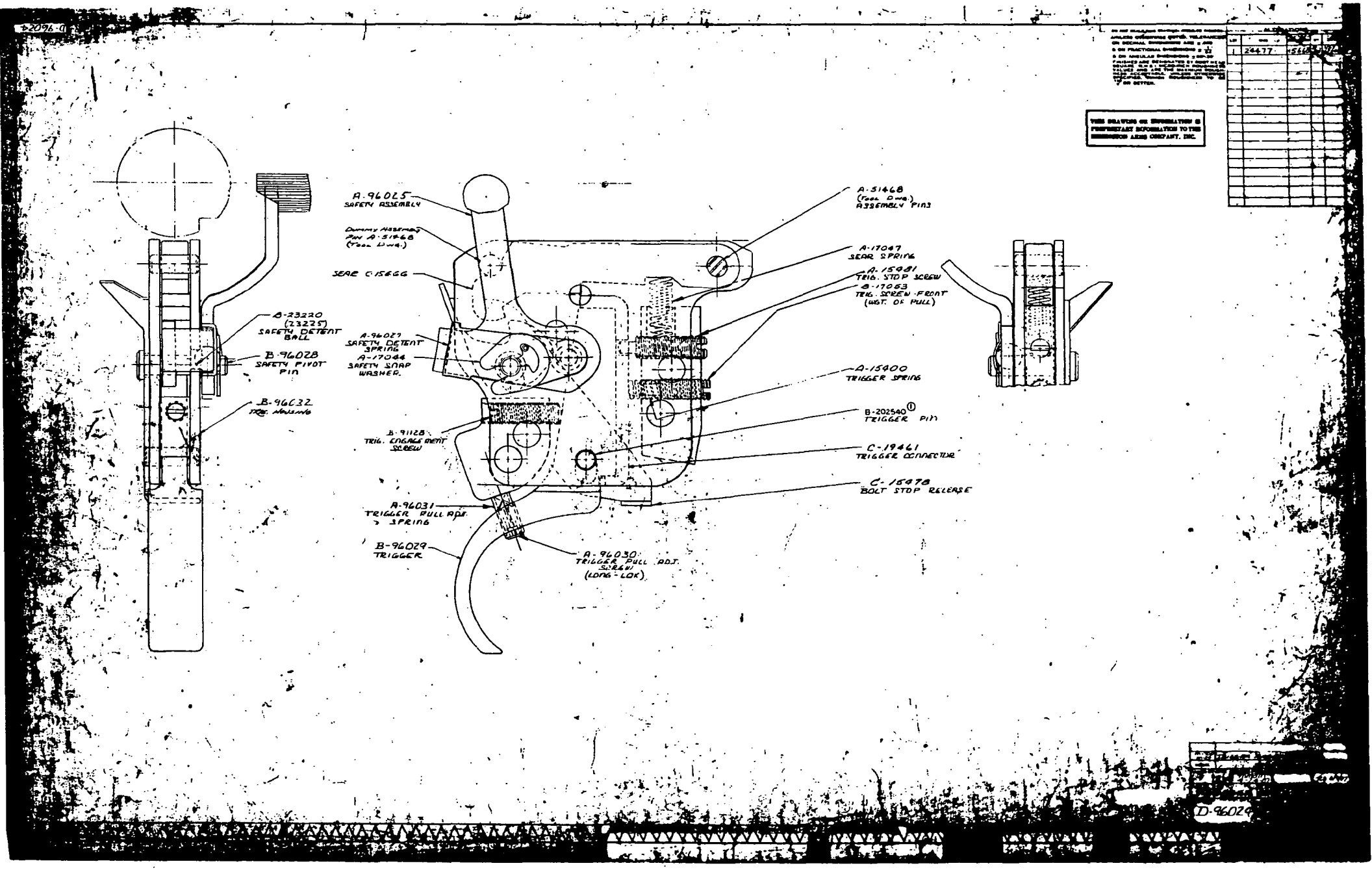
APPROVED		DATE
DRAWN BY	D.E.B.	09-23-81
CHECKED	T.J.PLUNKETT	10-08-81
DESIGN	webster	N/A
ENGINEERING	J.W.B.	10-20-81
MFG	N/A	N/A
MATERIAL	N/A	N/A

TOLERANCES
UNLESS OTHERWISE SPECIFIED:
X.XX ± 0.01
X.XXX ± 0.005
ANGLES ± 00' - 30'
FILLET/EDGE .005 - .015
SURF FINISH 125 µin RMS
THIRD ANGLE PROJECTION

Remington Arms Company
14 Hoefler Ave, Ilion, New York 13357

TITLE: SAFETY

SIZE C DWG. NO. 92212 REV 03
WEIGHT: lbs. SHEET 1 OF 1



DES. BY DATE	DRN. BY DATE	CHK. BY DATE	APP. BY DATE
	MARTIN 4-24-87		TCD 6/9/87

TITLE: ASSEMBLY

NUMBER	SCALE	SUPERSEDES	REFERENCE
A-96025	~		DCR 12189

REMINGTON ARMS CO. INC.
ILION RESEARCH DIV.

MODEL	PART NO.	PART USE	SEE
M-700 M-24	96025	SAFETY ASSEMBLY	

DO NOT SCALE THIS DRAWING: WORK TO FIGURES UNLESS OTHERWISE NOTED.
TOLERANCES ON DECIMAL DIMENSIONS ARE:
1 PLACE (.1) — TOLERANCE ± .015
2 PLACE (.01) — TOLERANCE ± .010
3 PLACE (.001) — TOLERANCE ± .005
& ON FRACTIONAL DIMENSIONS ± 1/64,
& ON ANGULAR DIMENSIONS ± 00° – 30'
FINISHES ARE DESIGNATED BY ROOT MEAN SQUARE (R.M.S.) MICRO-INCH ROUGHNESS VALUES AND ARE THE MAXIMUM ROUGHNESS ACCEPTABLE. UNLESS OTHERWISE SPECIFIED.
FINISH ROUGHNESS TO BE $\sqrt{125}$ OR BETTER.

RECOMMENDED MATERIAL AND HEAT TREAT

MATERIAL
HEAT TREAT CARBO NITRIDE
HARDNESS R$_c$N 88-92
COLOR BLACK OXIDE

HEAT TREAT AND COLOR TO BE DONE BY REMINGTON JP Mud 6/9/87

PART NAME	PART NO.
SAFETY BUTTON	91852
SAFETY	96026

ALT.	WAS	REF.	BY	DATE

(M) ALTERATIONS

A-96025

FORM TFA REV 170

DES. BY DATE	DRN. BY DATE	CHK. BY DATE	APP. BY DATE
	MARTIN 4-29-87		ICD 4/30/87

TITLE: SPRING

NUMBER	SCALE	SUPERSEDES	REFERENCE
A-96027	~		DCR 12189

REMINGTON ARMS CO. INC.
ILION RESEARCH DIV.

MODEL	PART NO.	PART USE	SEE
M-700 M-24	96027	SAFETY DETENT SPRING	

DO NOT SCALE THIS DRAWING: WORK TO FIGURES UNLESS OTHERWISE NOTED.
TOLERANCES ON DECIMAL DIMENSIONS ARE:
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3 PLACE (.001) — TOLERANCE ± .005
& ON FRACTIONAL DIMENSIONS ± 1/64
& ON ANGULAR DIMENSIONS ± 00°-30'
FINISHES ARE DESIGNATED BY ROOT MEAN SQUARE (R.M.S.) MICRO-INCH ROUGHNESS VALUES AND ARE THE MAXIMUM ROUGHNESS ACCEPTABLE. UNLESS OTHERWISE SPECIFIED.
FINISH ROUGHNESS TO BE $\overset{125}{\vee}$ OR BETTER.

RECOMMENDED MATERIAL AND HEAT TREAT

MATERIAL SEE DRWG. B-15368
HEAT TREAT
HARDNESS
COLOR

HEAT TREAT AND COLOR TO BE DONE BY REMINGTON

SAME AS SAFETY DETENT SPRING 15368 EXCEPT NOSE ANGLE IS 8° INSTEAD OF 13°

BLANK No. 15368

ALT.	WAS	REF.	BY	DATE

ALTERATIONS

(M)

A-96027

FORM TFA REV 170

M24 00000230

B-96028

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

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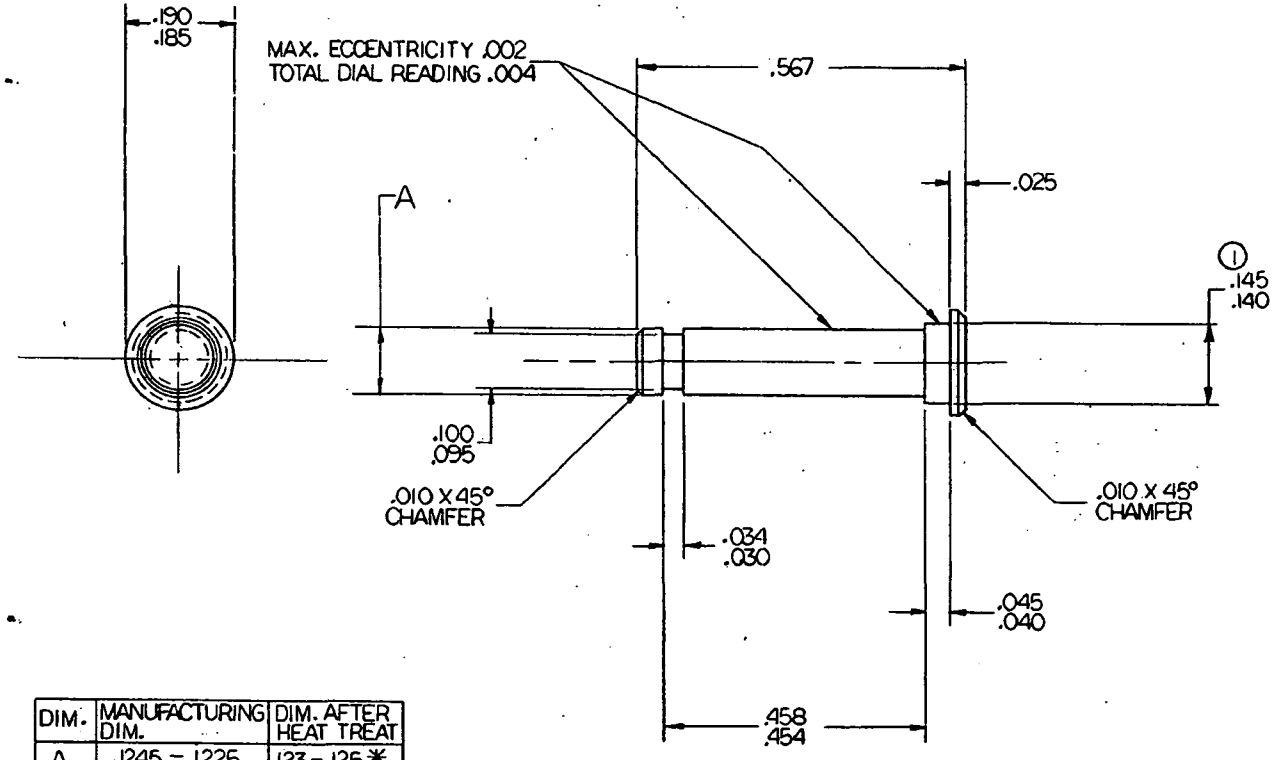
3 PLACE (.001) — TOLERANCE ± .005
& ON FRACTIONAL DIMENSIONS ± 1/64
& ON ANGULAR DIMENSIONS ± 00° – 30'
FINISHES ARE DESIGNATED BY ROOT MEAN SQUARE (R.M.S.) MICRO-INCH ROUGHNESS VALUES AND ARE THE MAXIMUM ROUGHNESS ACCEPTABLE, UNLESS OTHERWISE SPECIFIED.
FINISH ROUGHNESS TO BE 125 OR BETTER.

RECOMMENDED MATERIAL AND HEAT TREAT
MATERIAL 08/20 PL. CARBON STEEL
HEAT TREAT .003-.006 CASE
HARDNESS
COLOR NITRE BLACK
HEAT TREAT AND COLOR TO BE DONE BY R.W.L. 6-5-87 REMINGTON P MWD 6/4/87

ALTERATIONS					
ALT.	WAS	REF.	BY	DATE	
1	DIMENSION CLARIFICATION	12214	RAW	8.14.87	(H) (M)



DIM.	MANUFACTURING DIM.	DIM. AFTER HEAT TREAT
A	.1245 – .1225	.123 – .125 *

* NOTE: THIS DIA. MUST PASS THRU A .125 DIA. RING GAGE FREELY

FOR BLANK ORDER PART NO. 96214

M-700 M-24	96028	SAFETY PIVOT PIN
MODEL	PART NO.	PART USE

DES. BY DATE	DRN. BY DATE	CHK. BY DATE	APP. BY DATE
	RAW 4-23-87	4-24-87	TCD 6/9/87

TITLE: SAFETY PIVOT PIN

NUMBER	SCALE	SUPERSEDES	REFERENCE
B-96028	5X		DCR 12189

REMINGTON ARMS CO. INC.
ILION RESEARCH DIV.

FORM TYB REV. 2/80 N.S.N. 10 1153

M24 00000231

67096-B

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

DO NOT SCALE THIS DRAWING: WORK TO FIGURES UNLESS OTHERWISE NOTED.
TOLERANCES ON DECIMAL DIMENSIONS ARE:
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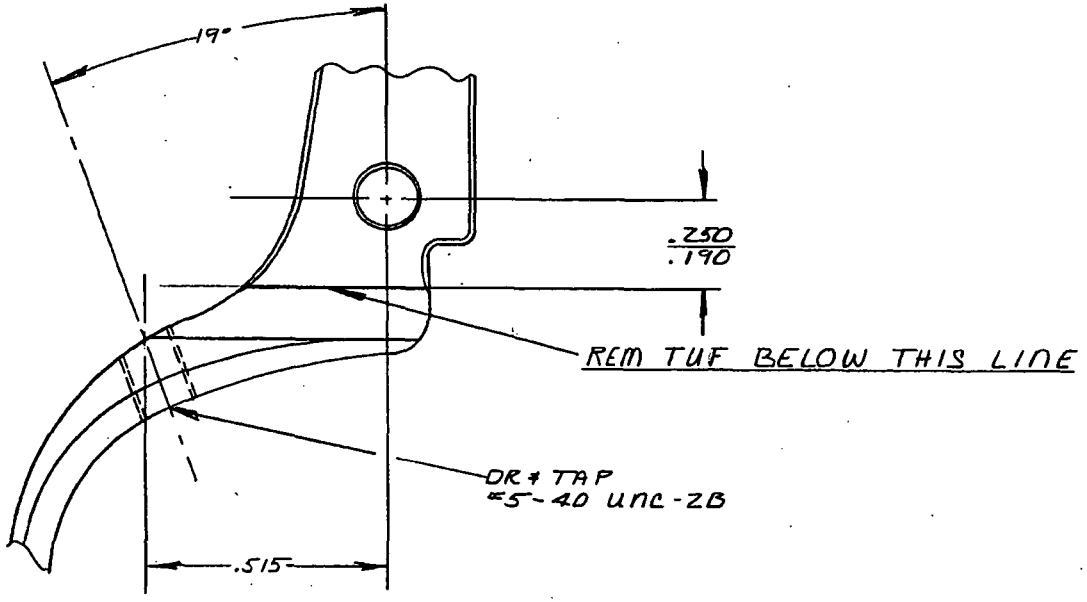
2 PLACE (.01) — TOLERANCE ± .010
3 PLACE (.001) — TOLERANCE ± .005
& ON FRACTIONAL DIMENSIONS ± 1/64
& ON ANGULAR DIMENSIONS ± 00°-30'
FINISHES ARE DESIGNATED BY ROOT MEAN SQUARE (R.M.S.) MICRO-INCH ROUGHNESS VALUES AND ARE THE MAXIMUN ROUGHNESS ACCEPTABLE. UNLESS OTHERWISE SPECIFIED.
FINISH ROUGHNESS TO BE 125 OR BETTER.

RECOMMENDED MATERIAL AND HEAT TREAT
MATERIAL C-15280
HEAT TREAT SEE DWG.
HARDNESS BLACK OXIDE
COLOR REM TUF THERMOSET EPOXY BLACK - MATTE FINISH
HEAT TREAT AND COLOR TO BE DONE BY REMINGTON SPIN-O 4-87

ALTERATIONS

ALT.	WAS	REF.	BY	DATE

(H)



SAME AS C-15280
EXCEPT AS SHOWN

M-700 M-24	96029	TRIGGER
MODEL	PART NO.	PART USE

DES. BY DATE	DRN. BY DATE	CHK. BY DATE	APP. BY DATE
	MARTIN 5-18-87		TCD 6/9/87

TITLE: TRIGGER

NUMBER	SCALE	SUPERSEDES	REFERENCE
B-96029	4X		DCR 12189

REMINGTON ARMS CO. INC.
ILION RESEARCH DIV.

FORM TFB REV. 2/80 N.R.S. 19 053

M24 00000232

DES. BY DATE	DRN. BY DATE	CHK. BY DATE	APP. BY DATE
	MARTIN 4-27-87		TCD 6/9/87

TITLE: SCREW

NUMBER	SCALE	SUPERSEDES	REFERENCE
A-96030	~		DCR 12189

REMINGTON ARMS CO. INC.
ILION RESEARCH DIV.

MODEL	PART NO.	PART USE	SEE
M-700 M-24	96030	TRIG. PULL ADJ. SCREW	

DO NOT SCALE THIS DRAWING: WORK TO FIGURES UNLESS OTHERWISE NOTED.
TOLERANCES ON DECIMAL DIMENSIONS ARE:
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2 PLACE (.01) — TOLERANCE ± .010
3 PLACE (.001) — TOLERANCE ± .005
& ON FRACTIONAL DIMENSIONS ± 1/64
& ON ANGULAR DIMENSIONS ± 00° −30'
FINISHES ARE DESIGNATED BY ROOT MEAN SQUARE (R.M.S.) MICRO-INCH ROUGHNESS VALUES AND ARE THE MAXIMUM ROUGHNESS ACCEPTABLE. UNLESS OTHERWISE SPECIFIED.
FINISH ROUGHNESS TO BE $\frac{125}{\sqrt{}}$ OR BETTER.

RECOMMENDED MATERIAL AND HEAT TREAT
(1) MATERIAL SS 18-8
HEAT TREAT
HARDNESS VENDOR'S SPEC
COLOR
HEAT TREAT AND COLOR TO BE DONE BY REMINGTON

PURCHASE
CONE POINT SOCKET
SET SCREW
#5-40 x .250 LONG
VENDORS NO.
LP56XB50I4

LONG-LOK FASTENER CORP.
10630 CHESTER RD.
CINCINNATI, OHIO 45215

ALT.	WAS	REF.	BY	DATE
(M) 1	ADD MAT'L. SPEC	12226	MARTIN	10/3/87

ALTERATIONS

A-96030

FORM TFA REV 170

M24 00000233

DES. BY DATE	DRN. BY DATE	CHK. BY DATE	APP. BY DATE
	MARTIN 4-27-87		TCD 6/9/87

TITLE: SPRING

NUMBER	SCALE	SUPERSEDES	REFERENCE
A-96031	~		DCR 12189

REMINGTON ARMS CO. INC.
ILION RESEARCH DIV.

MODEL	PART NO.	PART USE	SEE
M-700 M-24	96031	TRIG. PULL ADJ. SPRING.	

DO NOT SCALE THIS DRAWING: WORK TO FIGURES UNLESS OTHERWISE NOTED.
TOLERANCES ON DECIMAL DIMENSIONS ARE:
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2 PLACE (.01) — TOLERANCE ± .010
3 PLACE (.001) — TOLERANCE ± .005
& ON FRACTIONAL DIMENSIONS ± 1/64,
& ON ANGULAR DIMENSIONS ± 00°-30'
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FINISH ROUGHNESS TO BE $\frac{125}{\sqrt{}}$ OR BETTER.

(1)

RECOMMENDED MATERIAL AND HEAT TREAT
MATERIAL: MUSIC WIRE
HEAT TREAT:
HARDNESS:
COLOR:
HEAT TREAT AND COLOR TO BE DONE BY REMINGTON

PURCHASE
STOCK PRECISION ENGINEERED SPRING
VENDORS PART no.
C0120-022-0310-M
FREE LNGTH. - .31
LOAD — 4.48 lbs.
(1) LNGTH L. — .226
SOLID HGT. — .209
SPRING RATE — 53.3 lbs.
WIRE Dia. — .022
O.D. — .120
ASSOCIATED SPRING
18 MAIN ST.
BRISTOL, CT. 06010

ALT.	WAS	REF.	BY	DATE
(M) 1	ADD MAT'L & Design Spec	12226	MARTIN	10/18/87

ALTERATIONS

A-96031

FORM TFA REV 170

M24 00000234

B-96032

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2 PLACE (.01) — TOLERANCE ± .010
3 PLACE (.001) — TOLERANCE ± .005
& ON FRACTIONAL DIMENSIONS ± 1/64
& ON ANGULAR DIMENSIONS ± 00°-30'.
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FINISH ROUGHNESS TO BE $\sqrt{125}$ OR BETTER.

RECOMMENDED MATERIAL AND HEAT TREAT
MATERIAL
HEAT TREAT
HARDNESS
COLOR BLACK OXIDE
HEAT TREAT AND COLOR TO BE DONE BY REMINGTON SPMLD 4-87

ALTERATIONS

ALT.	WAS	REP.	BY	DATE

(M)

PART NAME	PART No.
TRIG. HOUSING RIVET (4 REQ'D.)	14632
TRIG. HOUS. SPACER FRONT	14630
TRIG. HOUS. SPACER REAR	96033
TRIG. SIDE PLATE RIGHT	96034
TRIG. SIDE PLATE LEFT	30781

NOTE
FOR DIMENSIONS SEE DRWG. C-26655

M-100 M-24	96032	TRIG. HOUSING ASS'Y.
MODEL	PART NO.	PART USE

DES. BY DATE	DRN. BY DATE	CHK. BY DATE	APP. BY DATE
	MARTIN 4-27-87		TCD 6/9/87

TITLE: ASSEMBLY

NUMBER	SCALE	SUPERSEDES	REFERENCE
B-96032	2		DCR 12189

REMINGTON ARMS CO. INC.
ILION RESEARCH DIV.

FORM TPB REV. 2/80 N.H.S. ID 1153

M24 00000235

B-96033

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

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TOLERANCES ON DECIMAL DIMENSIONS ARE:
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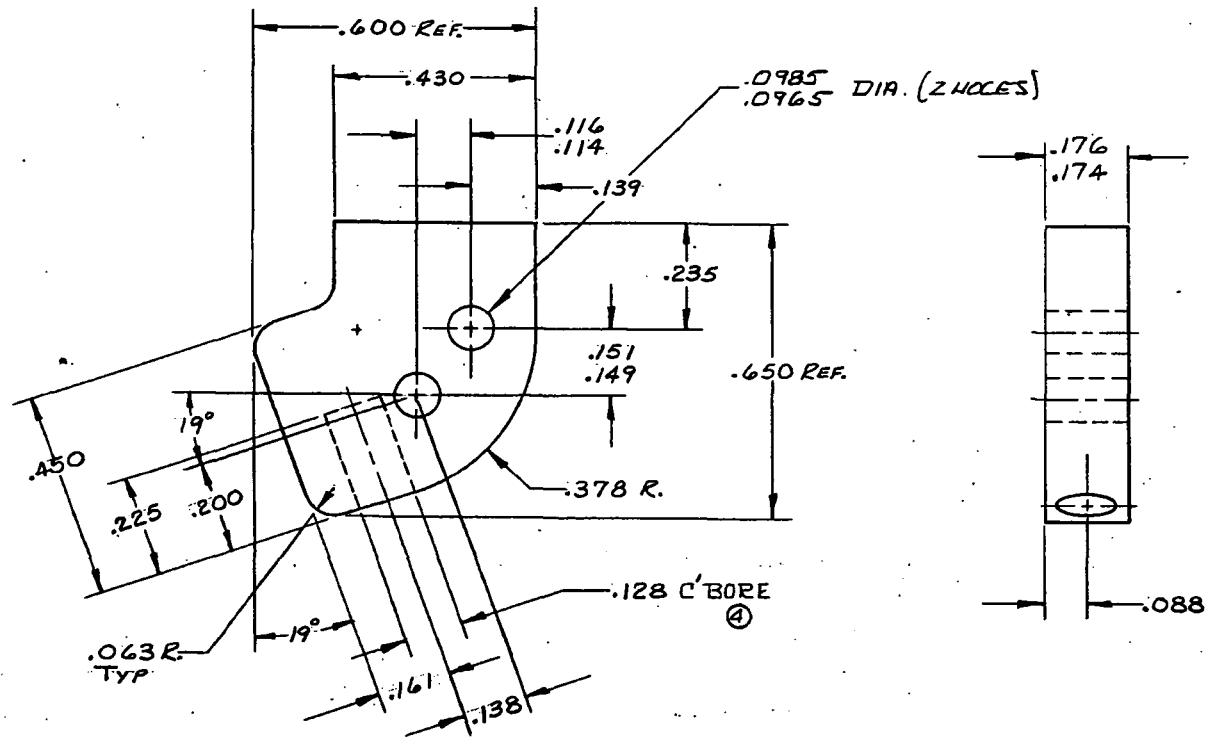
2 PLACE (.01) — TOLERANCE ± .010
3 PLACE (.001) — TOLERANCE ± .003
& ON FRACTIONAL DIMENSIONS ± 1/64
& ON ANGULAR DIMENSIONS ± 00° - 30'
FINISHES ARE DESIGNATED BY ROOT MEAN SQUARE (R.M.S.) MICRO-INCH ROUGHNESS VALUES AND ARE THE MAXIMUM ROUGHNESS ACCEPTABLE, UNLESS OTHERWISE SPECIFIED.
FINISH ROUGHNESS TO BE 125 OR BETTER.

RECOMMENDED MATERIAL AND HEAT TREAT
MATERIAL .08-.20 CARB. STL
HEAT TREAT ①
HARDNESS
COLOR
HEAT TREAT AND COLOR TO BE DONE BY KWL 6-5-87 REMINGTON

ALTERATIONS					
ALT.	WAS	REF.	BY	DATE	
1	SEE ASSY. B-96032	14594	RLS	11/6/01	(H)
2	REMOVED DIM "A"	"	"	"	
3	REMOVED BLANK NO.	"	"	"	
4	TO BE DONE BY REMINGTON	"	"	"	(M)



M-700 M-24	96033	TRIGGER HOUSING SPACER REAR
MODEL	PART NO.	PART USE

DES. BY DATE	DRN. BY DATE	CHK. BY DATE	APP. BY DATE
FEM 9-22-86	WP 9-23-86		TCD 6/9/87

TITLE: SPACER, REAR

NUMBER	SCALE	SUPERSEDES	REFERENCE
B-96033	4:1		DCR 12189

REMINGTON ARMS CO. INC.
ILION RESEARCH DIV.

FORM TFB REV. 2/80 N.S.N. 13 053

DES. BY DATE	DSN. BY DATE	CHK. BY DATE	APP. BY DATE
	MARTIN 4-27-87		TCD 6/9/87

TITLE: PLATE

NUMBER	SCALE	SUPERSEDES	REFERENCE
A-96034	~		DCR 12189

REMINGTON ARMS CO. INC.
ILION RESEARCH DIV.

MODEL	PART NO.	PART USE	SEE
M-700 M-24	96034	TRIG. SIDE PLATE RIGHT	

DO NOT SCALE THIS DRAWING: WORK TO FIGURES UNLESS OTHERWISE NOTED.
TOLERANCES ON DECIMAL DIMENSIONS ARE:
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2 PLACE (.01) — TOLERANCE ± .010
3 PLACE (.001) — TOLERANCE ± .005
& ON FRACTIONAL DIMENSIONS ± 1/64,
& ON ANGULAR DIMENSIONS ± 00°-30'
FINISHES ARE DESIGNATED BY ROOT MEAN SQUARE (R.M.S.) MICRO-INCH ROUGHNESS VALUES AND ARE THE MAXIMUM ROUGHNESS ACCEPTABLE. UNLESS OTHERWISE SPECIFIED.
FINISH ROUGHNESS TO BE $\sqrt{125}$ OR BETTER.

RECOMMENDED MATERIAL AND HEAT TREAT

MATERIAL C-1010 or 1020
HEAT TREAT SEE DRWG. C-30780
HARDNESS " " "
COLOR SEE ASSY B-96032

HEAT TREAT AND COLOR TO BE DONE BY REMINGTON

SAME AS PART NO. 30780
EXCEPT COUNTERSINK DIMS. "G"
ARE .225-.235 DIA x 130°
INCLUDED

ALT.	WAS	REF.	BY	DATE

ALTERATIONS

(H)

A-96034

FORM TFA REV 170