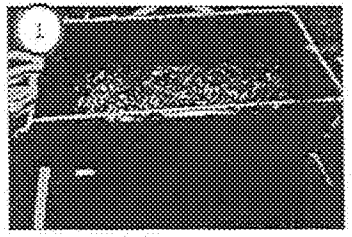
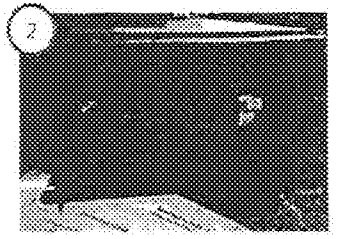
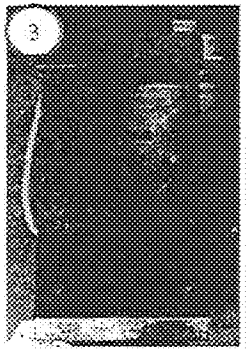
Standardized Work Sheet

SWI #	Department	Operation	Part Name	Part NO.	JES #	Time
1	XMP	OP 5	Springs			

Demagnetize Springs

Safety	Quality Check	KPC	Ergonomic	Critical Operation	PMP	Written By:	N. Kline
	Q	K	E		PMP	Date:	5/21/2014

MCNEIL 1063

Visuals	Sequence #	Symbol	Major Step (what)	Key Point (how)
	1		Place Springs in Pans (See image 1)	-Place Sear Spring, Safety Detent Springs, and Trigger Pull Springs in separate non-metallic pans. -Pan not to Exceed 6"x3"x2"
	2		Turn Demagnetizer ON (See image 2)	- Confirm red light is on.
	3	▽	Demagnetize (See image 3)	-Pass pan across the effective area between the black guides. -Move pan from right to left, then remove.
	4		Turn Demagnetizer OFF	-Do not turn off with pan in contact with demagnetizer. This may magnetize parts.

Buyoff		Team Leader	Supervisor	Department Head
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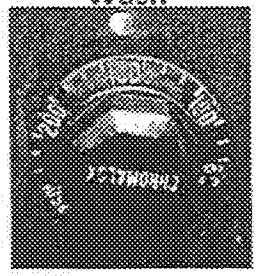
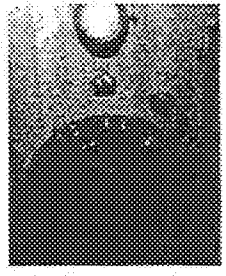
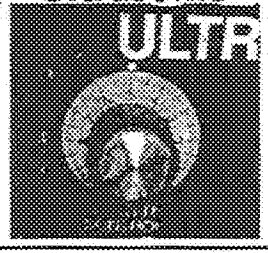
Revision Log			Confirmation by Shifts		
Date	Name	Change Description	Initials and Date		

Standardized Work Sheet

SWI #	Department	Operation	Part Name	Part NO.	JES #	Time
1 of 2	8772	OP 8		306365, 306366, 300664, 300914, 300696, 410450		

Ultrasonic Clean & Rinse

Safety	Quality Check	KPC	Ergonomic	Critical Operation	PMP	Written By:	N. Kline
	Q	K	E		PMP	Date:	6/3/2014

Visuals	Sequence #	Symbol	Major Step (what)	Key Point (how)
1 Wash 	1		Turn tanks ON (See image 1 & 2)	- Wash Tank Temperature : 150°F - Rinse Tank Temperature: 180°F
	2		Allow Tanks to Reach Temperature	
	3		Place Parts in Appropriate Basket	-Basket should allow no parts to pass through
2 Rinse 	4		Place Basket in Wash Tank	- Wintech 758 Concentration 8% (12 Parts Water 1 Part Wintech 758)
	5		Turn on Ultrasonic Control (See image 3)	- Set knob to 5
	6		Wash	-Leave in wash tank for 10 minutes.
3 Ultrasonic 	7		Remove Basket From Tank	-Lift basket from wash solution -Hold for short period to drain cleaner from parts.
	8		Turn OFF Ultrasonic Generator	
	9		Rinse	-Place in hot water rinse. -Move basket up and down several times.

Signoff		Team Leader	Supervisor	Department Head
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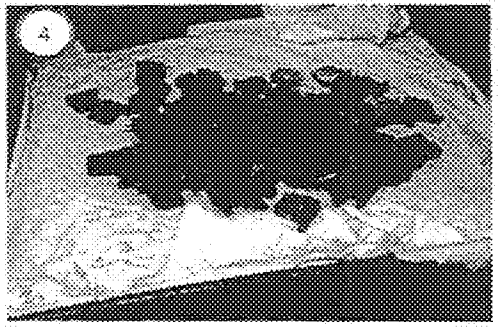
Revision Log			Confirmation by Shifts		
Date	Name	Change Description	Initials and Date		

Standardized Work Sheet

SWS #	Department	Operation	Part Name	Part NO.	JES #	Time
2 of 2	XMP	OP 8	XMP	306865, 306866, 300664, 300914, 300698, 410450		

Ultrasonic Clean & Rinse

Safety	Quality Check	KPC	Ergonomic	Critical Operation	PMP	Written By:	M. Kline
	Q	KPC	E		XMP	Date:	6/3/2014

Visuals	Sequence #	Symbol	Major Step (what)	Key Point (how)
	10		Remove from Rinse	-Lift basket out of rinse and allow to drain for short period.
	11	▽	Cool (See image ④)	-Dump on clean rag/towel to cool. -Do not blow off with compressed air!
	12		Turn OFF	-When complete, turn off Ultrasonic Wash and Hot Water Rinse tank.

Buyoff		Team Leader	Supervisor	Department Head
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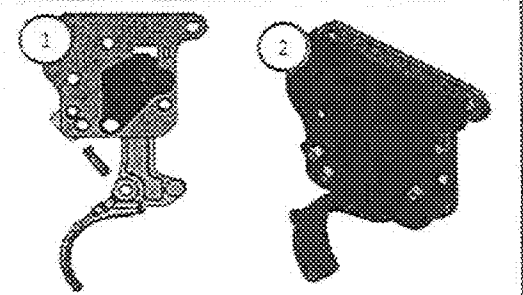
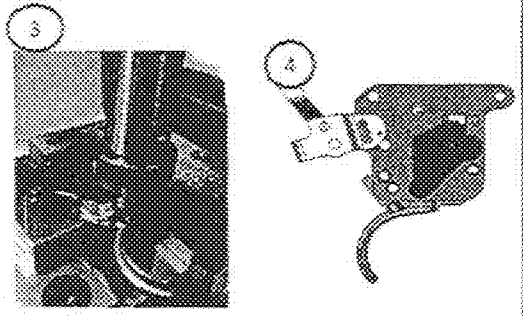
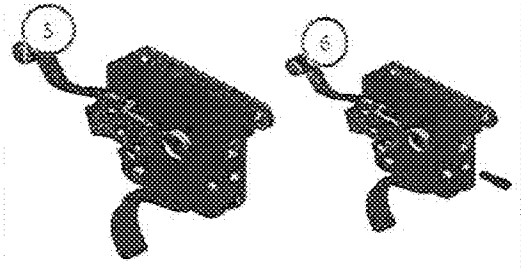
Revision Log			Confirmation by Shifts		
Date	Name	Change Description	Initials and Date		

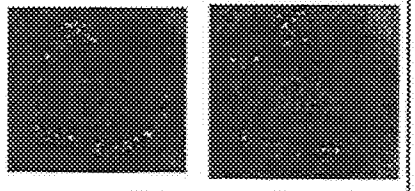
Standardized Work Sheet

SWI #	Department	Operation	Part Name	Part NO.	IES #	Time
1 of 2	KMP	OP 10	M700			

Assemble Trigger Assembly - Stage 1

Safety	Quality Check	KPC	Ergonomic	Critical Operation	PMP	Written By:	N. Kline
	Q	K	E		PMP	Date:	6/6/2014

Visuals	Sequence #	Symbol	Major Step (what)	Key Point (how)
	1	▽	Install Trigger and Secondary Trigger Pull Spring into Housing (See image 1)	*Secondary Trigger pull spring is only applicable to Externally Adjustable triggers
	2		Install Trigger Pivot Pin (See image 2)	*Insert pin through the lower hole in the blocker, the right hand side plate, and the trigger. *Secondary trigger pull spring must remain captured between trigger and hole in rear spacer.
	3		Press Pivot Pin (See image 3)	*Place housing into press fixture so that top and side are against stops. Also, trigger pivot pin should be protruding upward. *Press. *Verify trigger moves freely.
	4		Insert Safe Arm (See image 4)	*Bias the camming leg of the safety against the inside surface of the right hand side plate of the trigger housing.
	5		Insert Safety Detent Spring (See image 5)	*Align offset leg of safe arm over the post on the blocker. *Insert the long leg of the safety detent spring into the small hole of the safe arm. *Using favorable hand tool, slide short leg of the safety detent spring into hole in the blocker. *Squeeze safe arm and housing together, allowing the post to snap into safety slot.
	6	▽	Install Trigger Pull Screw and Trigger Pull Spring (See image 6)	*Place primary trigger pull spring over post on the trigger pull screw. NOTE: FOR NON-ADJUSTABLE MODEL, THE END OF THE SPRING OPPOSITE THE BURR MUST GO ON THE TRIGGER PULL SCREW'S POST *Insert into hole in the front spacer. *Adjust inward until screw head is about 2 to 3 turnsbelow the outer edge of the spacer.



Buyoff		Team Leader	Supervisor	Department Head
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Revision Log			Confirmation by Shifts
Date	Name	Change Description	Initials and Date

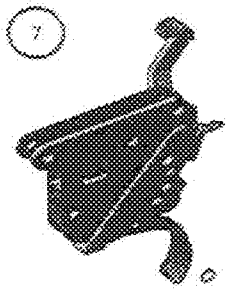
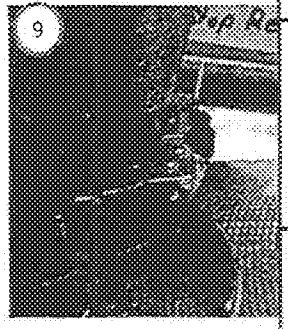
MCARTHUR 1956

Standardized Work Sheet

SWS #	Department	Operation	Part Name	Part NO	JES #	Time
2 of 2	KMP	OP 10	M700			

Assemble Trigger Assembly - Stage 1

Safety	Quality Check	KPC	Ergonomic	Critical Operation	PMP	Written By:	N. Kline
	Q	K	E		PMP	Date:	6/5/2014

Visuals	Sequence #	Symbol	Major Step (what)	Key Point (how)
	7		Install Bolt Stop Release (See image 7)	*RH Model: Place the bolt stop release against the left hand side plate of housing. *LH Model: Place the bolt stop release against the right hand side plate of housing. *Upper hole should be aligned with the safety pivot hole in the trigger housing and the lower hole should be over end of the trigger pin.
	8		Install Trigger Pivot Pin Retaining Ring (See image 8 & 9)	*Using assembly tool C-56251, insert the trigger pivot pin retaining ring over the trigger pivot pin.
 	9		Inspect Retaining Ring	*Verify that retaining ring is fully seated in slot of trigger pivot pin
	10		Place Out	*Place trigger assembly next to station 2

Buyoff		Team Leader	Supervisor	Department Head
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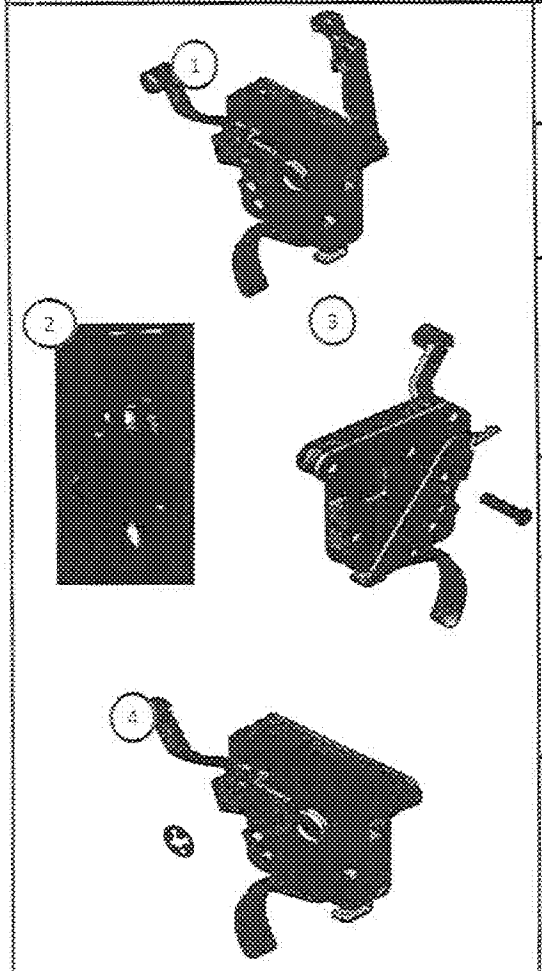
Revision Log			Confirmation by Shifts
Date	Name	Change Description	Initials and Date

Standardized Work Sheet

SWS #	Department	Operation	Part Name	Part NO.	IES #	Time
1 of 1	8772	OP 20	XMP			

Assemble Trigger Assembly - Stage 2

Safety	Quality Check	KPC	Ergonomic	Critical Operation	PMP	Written By:	N. Kline
	Q	K	E		PMP	Date:	6/3/2014

Visuals	Sequence #	Symbol	Major Step (what)	Key Point (how)
	1		Pick Assembly	*Pick partially assembled trigger assembly from Station 1
	2		Assemble Sear (See image 1)	*Visually inspect Sear surface for damage. *Place front end of Sear into the trigger housing so that the holes align. *Retain Sear by inserting a slave pin into hole.
	3	▽	Insert Sear Spring (See image 2)	*Place sear spring on the sear spring support in housing. *Rotate tail of sear safety cam downward until it clears the holes in the back of the housing. *Insert slave pin through hole in housing to hold sear down.
	4	▽	Verify Spring is Seated (See Image 2)	* Looking thru the blocker window, verify that the sear spring is properly seated on post of spring support and captured by correct face on sear. Make correct if out of position.
	5		Install Safety Pivot Pin (See image 3)	*Insert safety pivot pin (left to right) through the holes in the bolt stop release, trigger housing, and safety. *Push it until the shoulder contacts the left hand side plate of the trigger housing.
	6		Install Safety Retainer (See image 4)	*Orient the safety retainer so that the legs stick up and away from the safety assembly. *Using hand assembly tool C-56220, seat the safety retainer. *Verify that all of the retainer's legs are snapped into the groove in the safety pivot pin. *NEVER REUSE RETAINER AFTER REMOVING

Signoff		Team Leader	Supervisor	Department Head
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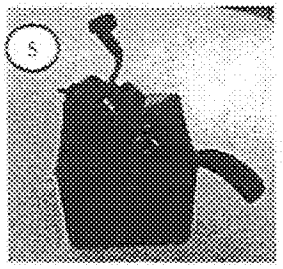
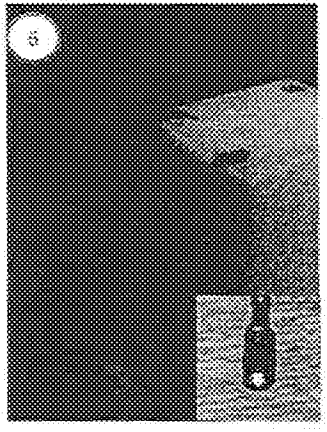
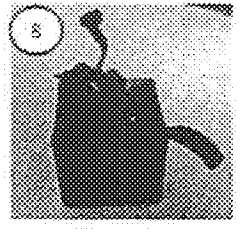
Revision Log			Confirmation by Shifts		
Date	Name	Change Description	Initials and Date		

Standardized Work Sheet

SWS #	Department	Operation	Part Name	Part NO.	JES #	Time
2 of 3	8777	OP 20	AMP			

Assemble Trigger Assembly - Stage 2

Safety	Quality Check	KPC	Ergonomic	Critical Operation	PMP	Written By:	N. Kline
	Q	K	E		SME	Date:	6/3/2014

Visuals	Sequence #	Symbol	Major Step (what)	Key Point (how)
	7		Place in Cup (See image 5)	*Place in red cup
	8		Pick Blocker Screw and Place on Tip of Power Bit	
	9	▽	Apply Loctite To Blocker Screw (See image 6)	*Firmly press the nose of the blocker screw against the center of the slot on loctite application block 68187. *Slide blocker screw (while still held against fixture) to the right approximately .25" *Apply 1 drop of Loctite 263 to the first few visible threads adjacent to the application block using the automated Loctite dispenser. *Loctite contacting screw face is NOT permissible.
	10	▽	Insert Blocker Screw (See image 7)	*Pick Assembly from red cup *Holding trigger assembly in hand, insert blocker screw into blocker using Milwaukee cordless screw driver. *Thread the screw in until approximately 2-3 thread are protruding from the back of the blocker.
 	11		Place in Cup (See image 8)	*Place in red cup after blocker screw is installed.
	12		Pick Engagement Screw and Place on Tip of Power Bit	

Sign-off		Team Leader	Supervisor	Department Head
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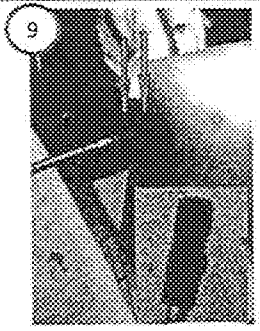
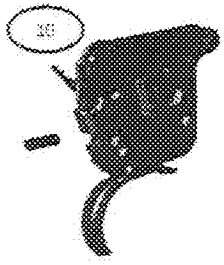
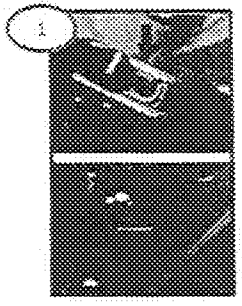
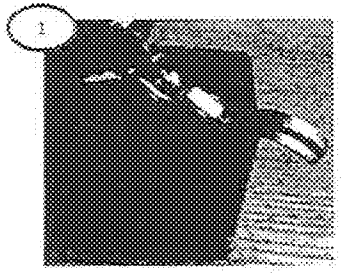
Revision Log			Confirmation by Shifts		
Date	Name	Change Description	Initials and Date		

Standardized Work Sheet

SWI #	Department	Operation	Part Name	Part NO.	JES #	Time
3 of 3	8772	OP 20	XMP			

Assemble Trigger Assembly - Stage 2

Safety	Quality Check	KPC	Ergonomic	Critical Operation	PMP	Written By:	N. Kline
	Q	K	E		PMP	Date:	6/3/2014

Visuals	Sequence #	Symbol	Major Step (what)	Key Point (how)
	13	▽	Apply Loctite To Engagement Screw (See image 9)	* Firmly press the nose of the engagement screw against the center of the slot on Loctite application block 68187. * Slide engagement screw (while still held against fixture) to the left approximately .25" * Apply 1 drop of Loctite 263 to the first few visible threads adjacent to the application block using automated Loctite dispenser. * Apply the second drop centered approximately half way between the previous drop and the rear of the screw using the Loctite dispenser (See arrows in image 9) * Loctite contacting screw face is NOT permissible.
 	14	▽	Insert Trigger Engagement Screw (See image 10)	* Holding trigger assembly in hand, insert engagement screw into rear spacer using Milwaukee cordless screw driver. * Thread the screw in until the rear of the screw is flush with the spacer.
	15	▽	Wipe Excess Loctite (See image 11)	* Wipe Excess Loctite from surfaces of housing and blocker using a swab.
	16		Place Out (See image 12)	* Place fire control into Green cup.

Buyoff	Team Leader	Supervisor	Department Head
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Shift 3 Date			

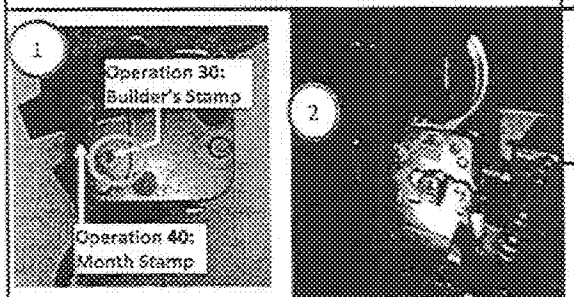
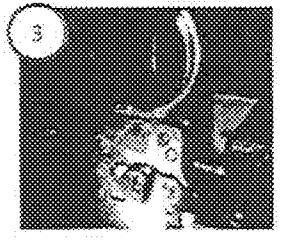
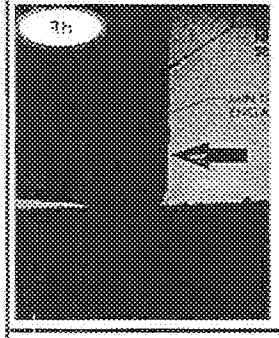
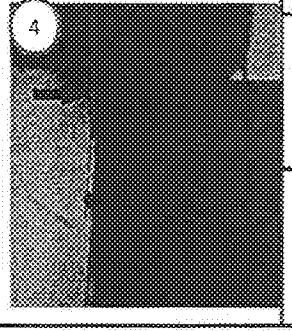
Revision Log			Confirmation by Shifts		
Date	Name	Change Description	Initials and Date		

Standardized Work Sheet

SWI #	Department	Operation	Part Name	Part NO.	JES #	Time
1 of 3	18772	OP 30	XMP	All		

Adjust Trigger Assembly on Comparator

Safety	Quality Check	KPC	Ergonomic	Critical Operation	PMP	Written By:	N. Kline
	Q	K	E		PMP	Date:	6/6/2014

Visuals	Sequence #	Symbol	Major Step (what)	Key Point (how)
	1		Stamp (See Image 1)	*Place trigger assembly in stamping fixture. *Locate Builder Specific stamp to the right of the top rivet, and above the bottom rivet.
	2	▼	Load Assy. In Fixture (See Image 2)	*Press assembly firmly against rear stops. *Engage clamp to hold assembly in place.
	3	▼	Focus Lens	*Turn focus knob until the image is clear.
	4	▼	Align Sear W/ Set Line (See Image 3 &3b)	*Tap rear of trigger forward (away from weight system) *Safety in "Fire" position. *Using knob on side of comparator fixture, position fire control so Sear edge is aligned with appropriate comp. screen set line.
 	5	▼	Set Trigger/Sear Engagement (See Image 4)	*With safety off, turn engagement screw to position the trigger edge within the .021" MAX and .019" MIN lines on screen. *Ideally, set at .021"
	6	▼	Hang Appropriate Weight from Trigger	*Sear must be held against trigger. *Safety in FIRE position. *EA assemblies, hang 2.5 lb load from trigger. *NON EA assemblies, hang 5 lb load from trigger.

Signoff		Team Leader	Supervisor	Department Head
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Revision Log			Confirmation by Shifts
Date	Name	Change Description	Initials and Date

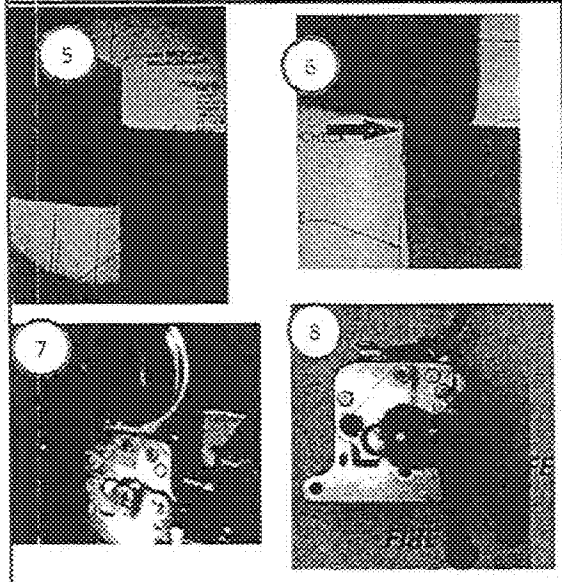
Standardized Work Sheet

SWI #	Department	Operation	Part Name	Part NO	IES #	Time
2 of 3						

Adjust Trigger Assembly on Comparator

Safety	Quality Check	KPC	Ergonomic	Critical Operation	PMP	Written By:	N. Kline
	Q	K	E		PMP	Date:	6/6/2014

MCNSTL 1072

Visuals	Sequence #	Symbol	Major Step (what)	Key Point (how)
	7	▼	Adjust Primary Trigger Pull Screw (See Image 5)	*Adjust primary trigger pull screw in counter clockwise direction until the trigger rotates from underneath the sear safety cam, allowing the sear to drop.
	8		Cycle and Recheck	*Remove weight from the trigger. *Release toggle clamp and allow sear and trigger to re-engage. *Recheck engagement and trigger pull using weight. (NOT LESS THAN 2.5 LBS) *Adjust as necessary.
	9		Refocus Lens	*Weight is removed *Bring trigger edge to sharp focus
	10	▼	Align Trigger W/ Deflection Set Line (See Image 6 & 7)	*Tap rear of trigger forward (away from weight system) *safety in "Fire" position *Zero load on trigger *Using knob on side of comparator fixture, position fire control so Trigger edge is aligned with appropriate comp. screen set line.
	11	▼	Move Safety to "Safe" Position (See Image 8)	
	12		Apply 7lb Load (See Image 9)	*FOR EA & Non Adjustable: Hang 7lb load from trigger using weight system.
	13	▼	Set Blocker Screw (See Image 10)	*Adjust the blocker screw inward (Image moves from right to left) until there is .000" MIN to .003" MAX visible deflection of the trigger *Deflection to be set at MIN (.000") *Note: It is acceptable for trigger to return past MIN when weight is removed

Buyoff		Team Leader	Supervisor	Department Head
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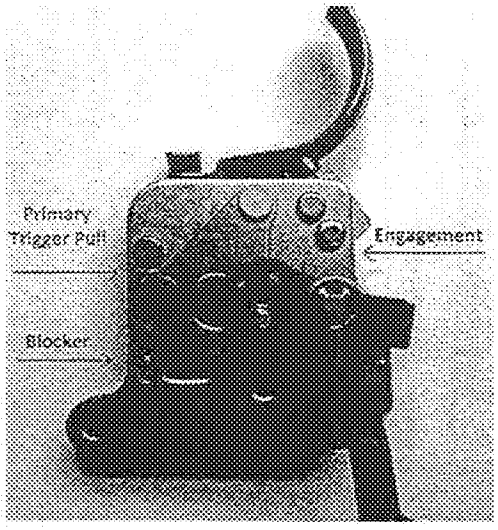
Revision Log			Confirmation By Shifts		
Date	Name	Change Description	Initials and Date		

Standardized Work Sheet

SWI #	Department	Operation	Part Name	Part NO.	IES #	Time
3 of 3						

Adjust Trigger Assembly on Comparator

Safety	Quality Check	KPC	Ergonomic	Critical Operation	PMP	Written By:	N. Kline
	Q	K	E		PMP	Date:	6/6/2014

Visuals	Sequence #	Symbol	Major Step (what)	Key Point (how)
	14		Move Safe Arm to "Fire" (See Image 5)	
	15		Align Trigger W/ Deflection Set Line (See Image 6)	*Tap rear of trigger forward (away from weight) *safety in "Fire" position *Zero load on trigger *Using knob on side of comparator fixture, position fire control so Trigger edge is aligned with appropriate comp. screen set line.
	16		Move Safety to "Safe" Position (See Image 5)	
	17		Recheck Blocker Setting and Adjust as Necessary	*Adjust the blocker screw inward (image moves from right to left) until there is .000" MIN to .003" MAX visible deflection of the trigger when 7 lb load is applied. *Ideally, blocker screw setting should be made to show visible motion just past the MIN position line on the comparator screen.
	18		Cure	*Loctite cure time: 24 hrs

Signoff		Team Leader	Supervisor	Department Head
Shift	Sign			
	Date			
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	Date			

Revision Log			Confirmation by Shifts		
Date	Name	Change Description	Initials and Date		

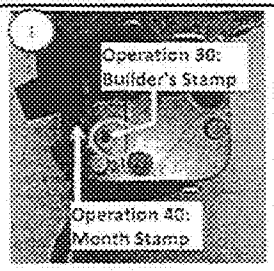
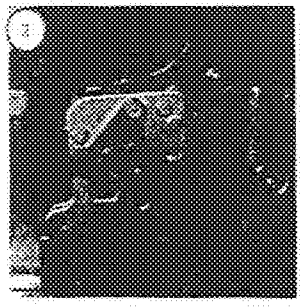
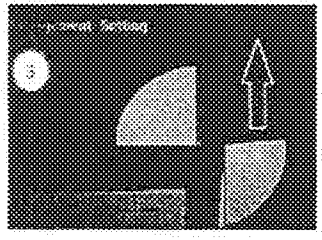
Standardized Work Sheet

SWI #	Department	Operation	Part Name	Part NO.	IES #	Time
1 of 3						

Adjust Trigger Assembly (COGNEX)

Safety	Quality Check	KPC	Ergonomics	Critical Operation	SQP	Written by:	N. Klise
	Q	K	E		CMQ	Date:	8/19/2014

MCNEIL 1074

Visuals	Sequence #	Symbol	Major Step (what)	Key Point (how)
	1		**Stamp** (See Image 1)	*Place trigger assembly in stamping fixture. *Locate Builder Specific stamp to the right of the top rivet, and above the bottom rivet.
	2	▽	**Place in fixture/Cycle** (See Image 2)	*Cycle trigger assembly by holding at front sear pin with left thumb, apply finger pressure to trigger near pivot pin approximately 4 times.
	3	▽	**Clamp Assy. In Fixture**	*While still holding front sear pin with left hand against stop surface of fixture, engage clamp to hold assembly in place.
	4		**Verify Screen**	*Verify system is measuring engagement. If not, push "Engagement"
	5	▽	**Position Set Line**	*Safety in "Fire" position. *Tap [redacted] to automatically position the set line. NOTE: If set line does not appear, adjust engagement screw inward until lines appear.
	6	▽	**Set Trigger/Sear Engagement** (See Image 3)	*Turn engagement screw to position the trigger edge within the targeted region. This is achieved when the lines turn green and [redacted] is displayed on the screen. *NOTE: SETTING MUST BE DONE FROM RIGHT TO LEFT. IF ADJUSTED PAST MIN SPEC, MUST BACK SCREW OUT SLIGHTLY AND ATTEMPT TO SET AGAIN FROM RIGHT TO LEFT. *Acceptable Zone: .0190" - .0210" *Targeted Zone: .0205" - .0210"

Signoff		Team Leader	Supervisor	Department Head
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shift	Sign:			
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Revision Log				Confirmation by Shifts		
Date		Name	Change Description	Initials and Date		

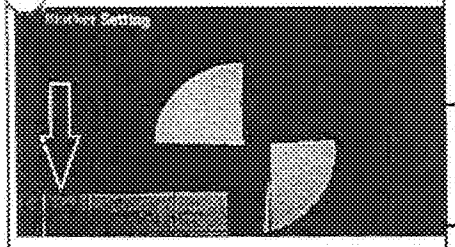
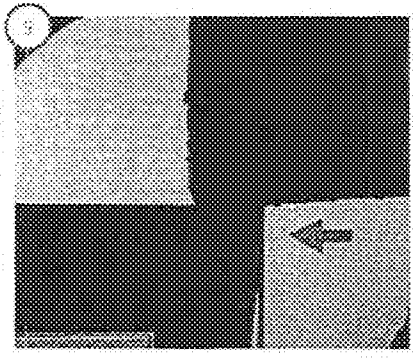
Standardized Work Sheet

Shift #	Department	Operation	Part Name	Part NO.	TES #	Time
2nd S						

Adjust Trigger Assembly (COGNEX)

Safety	Reading Sheet	KPC	Ergonomic	Critical Operation	PMP	Written by:	R. Allen
■	C	K	E	▽	PMP	Date:	6/10/2014

MCHEM 1075

Visuals	Sequence #	Symbol	Major Step (what)	Key Point (how)
	7	▽	**Hang Appropriate Weight from Trigger**	*Sear must be held against trigger. *Safety in FIRE position. *EA assemblies, hang 3 lb load from trigger. *NA assemblies, hang 5 lb load from trigger.
	8		**Adjust Primary Trigger Pull Screw**	*Adjust primary trigger pull screw in counter clockwise direction until the trigger rotates from underneath the sear safety cam, allowing the sear to drop.
	9		**Cycle**	*Remove weight from the trigger. *Hold front sear pin with left hand. (Same as step 2) *Release toggle clamp and allow sear and trigger to re-engage with right hand.
	10		**Recheck**	*Recheck engagement. Adjust as necessary.
	11	▽	**Switch System To Blocker Mode** (See Image 4)	*Tap [redacted] to switch to blocker adjustment mode.
	12	▽	**Position Set Line** (See Image 5)	*Safety in "Fire" position *Zero load on trigger *Tap SET LINE to automatically position the set line.
	14		**Reposition Safety**	*Move safety to "Safe" position.
	15	▽	**Apply 7lb Load**	*VERY GENTLY, Hang 7lb load from trigger using weight system.

Present	Team Leader	Supervisor	Department Head
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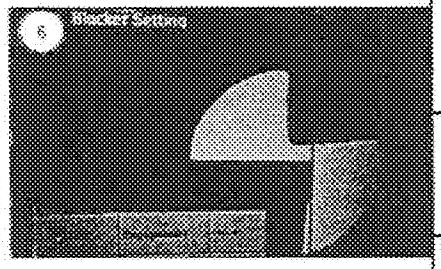
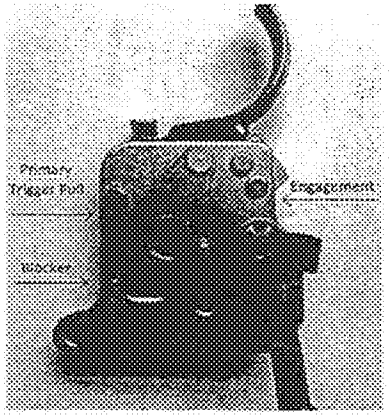
Revision Log			Confirmation by Shifts
Date	Name	Change Description	Initials and Date

Standardized Work Sheet

SWS #	Department	Operation	Part Name	Part NO.	YES #	Time
3 of 3						

Adjust Trigger Assembly (COGNEX)

Safety	Quality Check	KPC	Ergonomic	Critical Operation	PPE	Written By:	N. Rios
	Q		E			Date:	9/15/2014

Visuals	Sequence #	Symbol	Major Step (what)	Key Point (how)
	16	▼	**Set Blocker Screw** (See image 6)	*With safety on, turn blocker screw to position the trigger edge within the targeted region. This is achieved when the lines turn green and [redacted] is displayed on the screen. *Acceptable Zone: .000" - .003" *Targeted Zone: .000" - .0005"
	17		**Remove/Reapply Weight**	*Lift weight from trigger and reapply to display accurate blocker measurment. *Readjust as necessary. *Once finished, remove weight from trigger.
	18		**Cycle**	*Move safety to "Fire" *Apply finger pressure to trigger to allow sear to drop. *Hold front sear pin and reengage toggle.
	19	▼	**Recheck Engagement**	*Push "Engagement" button. *Press "Set Line" button. *Engagement must be .0190" - .0210"
	20	▼	**Recheck Blocker**	*Push "Blocker"button. *Press "Set Line" button. *Move Safe arm to "Safe" position. *Gently apply 7 lb weight to trigger. Deflection must be .0000" - .0030"
	21		**Adjust as Necessary**	*If either setting is out of spec. adjust as necessary. *If adjustment required, repeat steps 19 & 20.
	22	▼	**Cure**	*Loctite cure time: 24 hrs

Shift		Team Leader	Supervisor	Department Head
1st	Sign			
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2nd	Sign			
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Revision Log			Confirmation by Shifts
Date	Name	Change Description	Initials and Date

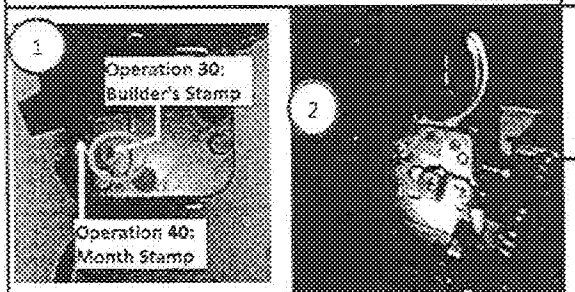
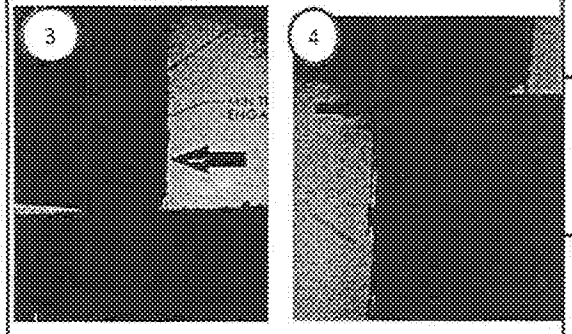
9701 ITEM 1

Standardized Work Sheet

SWI #	Department	Operation	Part Name	Part NO.	JES #	Time
1 of 3	18772	OP 30	XMP	All		

Adjust Trigger Assembly on Comparator

Safety	Quality Check	KPC	Ergonomic	Critical Operation	PMP	Written By:	N. Kline
	Q	K	E		PMP	Date:	6/6/2014

Visuals	Sequence #	Symbol	Major Step (what)	Key Point (how)
	1		Stamp (See Image 1)	*Place trigger assembly in stamping fixture. *Locate Builder Specific stamp to the right of the top rivet, and above the bottom rivet.
	2	▼	Load Assy. In Fixture (See Image 2)	*Press assembly firmly against rear stops. *Engage clamp to hold assembly in place.
	3	▼	Focus Lens	*Turn focus knob until the image is clear.
	4	▼	Align Sear W/ Set Line (See Image 3)	*Tap rear of trigger forward (away from weight system) *Safety in "Fire" position. *Using knob on side of comparator fixture, position fire control so Sear edge is aligned with appropriate comp. screen set line.
	5	▼	Set Trigger/Sear Engagement (See Image 4)	*With safety off, turn engagement screw to position the trigger edge within the .021" MAX and .019" MIN lines on screen. *Ideally, set at .021"
	6	▼	Hang Appropriate Weight from Trigger	*Sear must be held against trigger. *Safety in FIRE position. *EA assemblies, hang 2.5 lb load from trigger. *NON EA assemblies, hang 5 lb load from trigger.

Buyoff		Team Leader	Supervisor	Department Head
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Revision Log			Confirmation by Shifts
Date	Name	Change Description	Initials and Date

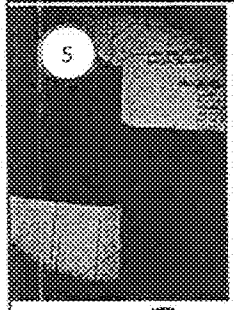
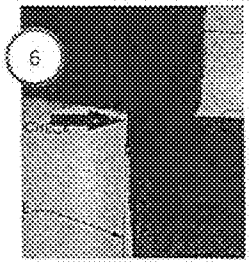
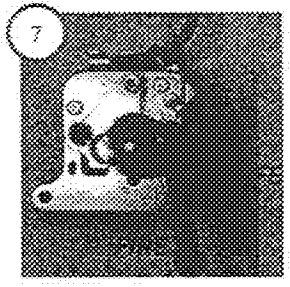
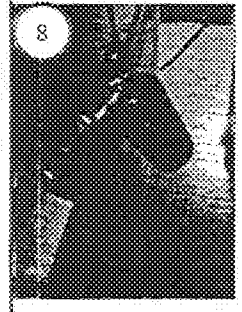
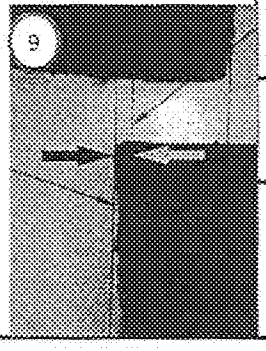
MCWELL 1077

Standardized Work Sheet

SWI #	Department	Operation	Part Name	Part NO.	JES #	Time
2 of 3						

Adjust Trigger Assembly on Comparator

Safety	Quality Check	KPC	Ergonomic	Critical Operation	PMP	Written By:	M. Kline
	Q	K	E		PMP	Date:	6/6/2014

Visuals	Sequence #	Symbol	Major Step (what)	Key Point (how)
 	7	▼	Adjust Primary Trigger Pull Screw (See Image 5)	*Adjust primary trigger pull screw in counter clockwise direction until the trigger rotates from underneath the sear safety cam, allowing the sear to drop.
	8		Cycle and Recheck	*Remove weight from the trigger. *Release toggle clamp and allow sear and trigger to re-engage. *Recheck engagement and trigger pull using weight. (NOT LESS THAN 2.5 LBS) *Adjust as necessary.
	9		Refocus Lens	*Weight is removed *Bring trigger edge to sharp focus
	10	▼	Align Trigger W/ Deflection Set Line (See Image 6)	*Tap rear of trigger forward (away from weight system) *safety in "Fire" position *Zero load on trigger *Using knob on side of comparator fixture, position fire control so Trigger edge is aligned with appropriate comp. screen set line.
	11	▼	Move Safety to "Safe" Position (See image 7)	
 	12		Apply 7lb Load (See Image 8)	*FOR EA & Non Adjustable: Hang 7lb load from trigger using weight system.
	13	▼	Set Blocker Screw (See Image 9)	*Adjust the blocker screw inward (Image moves from right to left) until there is .000" MIN to .003" MAX visible deflection of the trigger *Deflection to be set at MIN (.000") *Note: It is acceptable for trigger to return past MIN when weight is removed

Signoff		Team Leader	Supervisor	Department Head
Shift	Sign			
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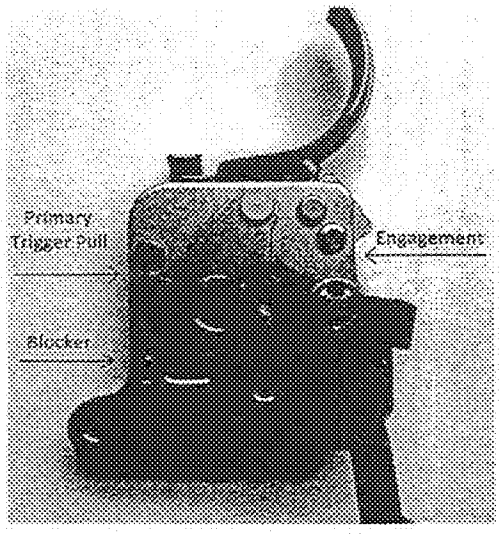
Revision Log			Confirmation by Shifts		
Date	Name	Change Description	Initials and Date		

Standardized Work Sheet

SWS #	Department	Operation	Part Name	Part NO.	JES #	Time
3 of 3						

Adjust Trigger Assembly on Comparator

Safety	Quality Check	KPC	Ergonomic	Critical Operation	PMP	Written By:	N. Kline
	Q	K	E		PMP	Date:	6/6/2014

Visuals	Sequence #	Symbol	Major Step (what)	Key Point (how)
	14		Move Safe Arm to "Fire" (See Image 8)	
	15		Align Trigger W/ Deflection Set Line (See Image 6)	*Tap rear of trigger forward (away from weight) *safety in "Fire" position *Zero load on trigger *Using knob on side of comparator fixture, position fire control so Trigger edge is aligned with appropriate comp. screen set line.
	16		Move Safety to "Safe" Position (See Image 9)	
	17		Recheck Blocker Setting and Adjust as Necessary	*Adjust the blocker screw inward (Image moves from right to left) until there is .000" MIN to .003" MAX visible deflection of the trigger when 7 lb load is applied. *Ideally, blocker screw setting should be made to ... show visible motion just past the MIN position line on the comparator screen.
	18		Cure	*Loctite cure time: 24 hrs

Signoff		Team Leader	Supervisor	Department Head
Shift	Sign			
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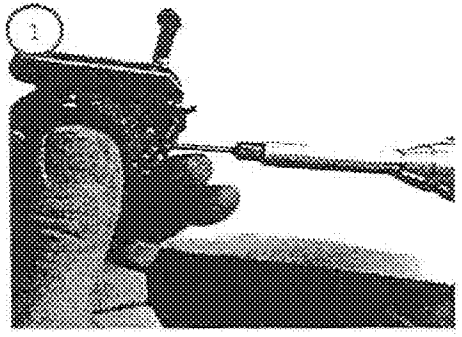
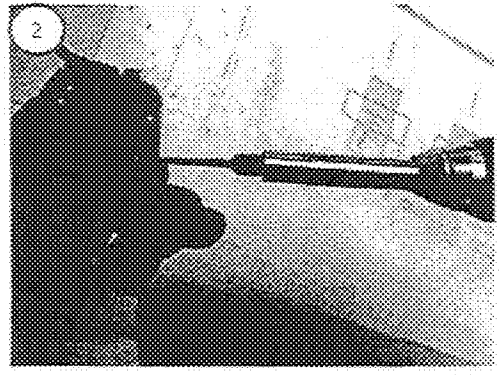
Revision Log			Confirmation by Shifts		
Date	Name	Change Description	Initials and Date		

Standardized Work Sheet

SWI #	Department	Operation	Part Name	Part NO.	JES #	Time
1 of 3	8772		XMP	ALL		

Apply Torque to Screws

Safety	Quality Check	KPC	Ergonomic	Critical Operation	PMP	Written By:	N. Kline
	Q	K	E		PMP	Date:	6/5/2018

Visuals	Sequence #	Symbol	Major Step (what)	Key Point (how)
	1		Check For Trigger Engagement Screw Movement (See image 1)	*Using a 1/16" hex power bit and click style torque analyzer, lightly torque (24 in.oz) the trigger engagement screw in counter clockwise direction until torque wrench clicks. *Screw must NOT move. If detectable movement, remove screw completely and reject.
	2		Check For Blocker Screw Movement (See image 2)	*Using a 1/16" hex power bit and click style torque analyzer, lightly torque (24 in.oz) the blocker screw in counter clockwise direction until torque wrench clicks. *Screw must NOT move. If detectable movement, remove screw completely and reject.

Buyoff		Team Leader	Supervisor	Department Head
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Revision Log			Confirmation By Shifts		
Date	Name	Change Description	Initials and Date		

ORDER EXHIBIT

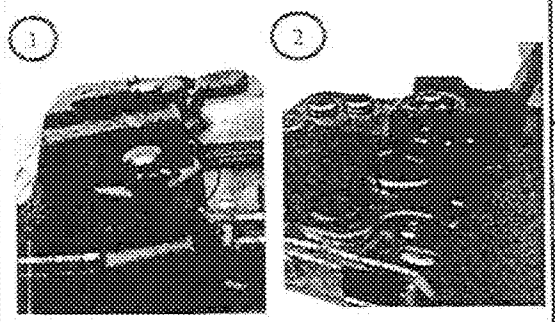
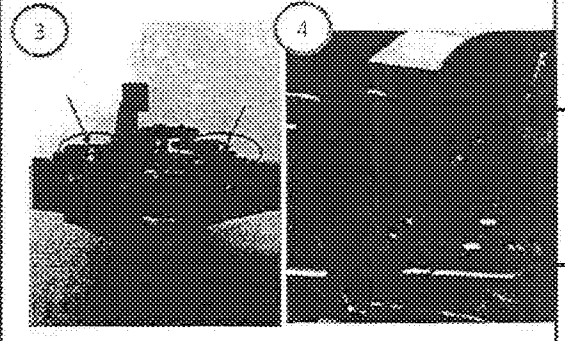
Standardized Work Sheet

SWS #	Department	Operation	Part Name	Part NO.	JSS #	Time
1 of 3	XMP	Inspection	XMP	All		

Function Check / Inspection

Safety	Quality Check	KPC	Ergonomic	Critical Operation	PMP	Written By:	R. Kline
	Q	K	E		XMP	Date:	5/23/2014

MCNEIL LLC 1021

Visuals	Sequence #	Symbol	Major Step (what)	Key Point (how)
	1	▼	Visual Inspection	*Verify absence of marrs, chips, etc.. on housing and components
	2	▼	Check Safety Retainer (See image 1)	* Make sure that all of the retainer's legs are snapped into the groove in the safety pivot pin.
	3	▼	Check Safety Detent Spring (See image 2)	*Make sure each end of the spring is securely located in the holes in the blocker and safety.
	4	▼	Check Bolt Stop Release	*The bolt stop release should be free to move the entire range of the slotted holes.
	5	▼	Check Blocker Hold Down Stud and Trigger Pivot Pin (See image 3)	*The head of each pin should be raised slightly from the surface of the blocker to allow movement.
	6	▼	Check Retaining Ring (See image 4)	* The retaining ring should be seated securely within the notch of the trigger pivot pin.

Buyoff		Team Leader	Supervisor	Department Head
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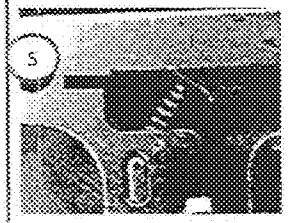
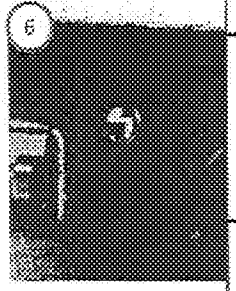
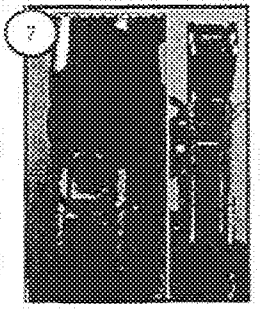
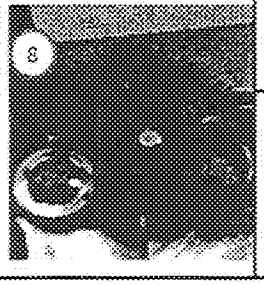
Revision Log			Confirmation by Shifts		
Date	Name	Change Description	Initials and Date		

Standardized Work Sheet

SWS #	Department	Operation	Part Name	Part NO.	JES #	Time
2 of 3	XMP	Inspection	XMP	All		

Function Check / Inspection

Safety	Quality Check	KPC	Ergonomic	Critical Operation	PMP	Written By:	N. Kline
	Q	K	E		SMP	Date:	5/21/2014

Visuals	Sequence #	Symbol	Major Step (what)	Key Point (how)
 	7	▼	Check Trigger Retraction	*Pull Trigger and Release. *Trigger must return freely to original position WITH SPRING FORCE. * Trigger must not rattle in housing.
	8	▼	Verify Sear Freedom (See image 5)	*Pull trigger and hold. Depress sear FULLY and release. *Sear must move freely in housing. *Sear must return upward under sear spring force. *Seat spring in correct orientation below sear.
	9	▼	Check Safety Function (See image 6)	*Move safe arm to "Fire" position and back to "Safe" *Repeat again. *Apply finger pressure to trigger. No movement of trigger from under sear should be felt or visible.
	10	▼	Apply Contact Adhesive (See image 7)	*Apply sealing layer of contact adhesive to the head of the trigger engagement AND blocker screws.
	11	▼	Apply RemOil (See image 8)	*Apply 1 - 2 drops to the contact point of the safety slot and blocker post.

Sign Off		Team Leader	Supervisor	Department Head
Shift:	Sign			
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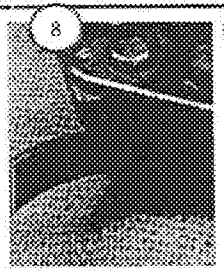
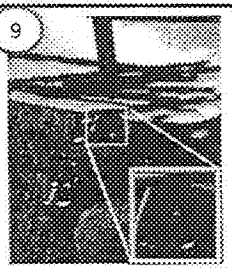
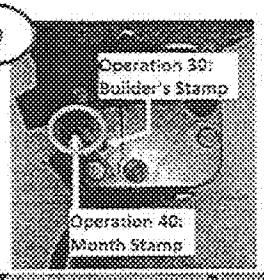
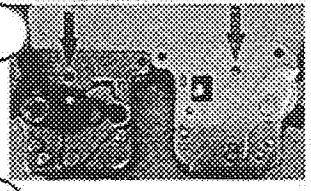
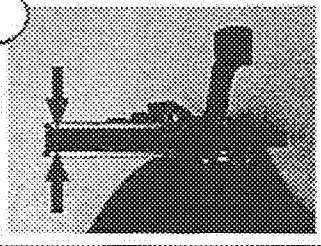
Revision Log			Confirmation by Shifts		
Date	Name	Change Description	Initials and Date		

Standardized Work Sheet

Function Check / Inspection

Shift #	Department	Operation	Part Name	Part NO.	JES #	Time
3 of 3	XMP	Inspection	XMP	All		

Safety	Quality Check	KPC	Ergonomic	Critical Operation	PMP	Written By:	M. Kline
	Q	K	E		PMP	Date:	9/23/2014

Visuals	Sequence #	Symbol	Major Step (what)	Key Point (how)
8  9 	12		Insert Secondary Trigger Pull Screw (EA) (See image 8)	*Tighten 2-3 turns. *Do not compress secondary trigger pull spring.
	13		Prick Punch Bolt Stop Release (See image 9)	*Using spring loaded punch to dimple bottom arm of bolt stop release.
10 	14	▼	Stamp (See image 10)	*Place trigger assembly in stamping fixture. *Locate the appropriate month stamp (BLACKPOWDERX)directly above the top rivet.
11  12 	15		Apply Molycoat (See image 11 & 12)	*Safety in "Fire" position. *Apply to top surface of trigger through window in side plate from both sides. *Apply to top surface of sear where contacted by firing pin head. *Apply to slot between sear and side plates at front pivot

Sign-off		Team Leader	Supervisor	Department Head
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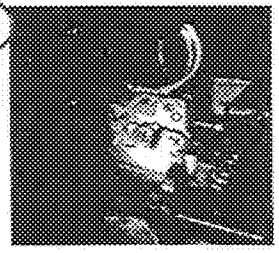
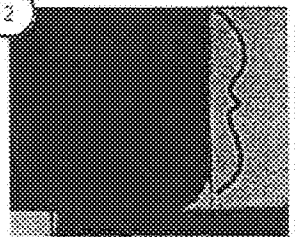
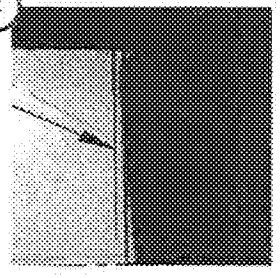
Revision Log			Confirmation by Shifts		
Date	Name	Change Description	Initials and Date		

Standardized Work Sheet

SWI #	Department	Operation	Part Name	Part NO.	JES #	Time
1 of 2						

Post-Torque Comparator Check

Safety	Quality Check	KPC	Ergonomic	Critical Operation	PMP	Written by:	N. Kline
	Q	K	E		PMP	Date:	5/21/2014

Visuals	Sequence #	Symbol	Major Step (what)	Key Point (how)
	1		Pick Trigger Assembly	*Pick completed trigger assembly from previous operation.
	2		Move Safe Arm To "Fire" Position	
	3		Load Assy. In Fixture (See Image 1)	*Press assembly firmly against rear stops. *Engage Destaco clamp to hold assembly in place.
	4		Focus Lens	*Turn knob until the image is clear.
	5		Align Sear W/ Set Line (See Image 2)	*Safety in "Fire" position. *Using knob on side of comparator fixture, position fire control so Sear edge is aligned with appropriate comp. screen set line.
	6		Verify Engagement (See Image 3)	*Verify trigger edge is between min and max engagement set lines on comparator screen.

Buyoff		Team Leader	Supervisor	Department Head
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Revision Log			Confirmation by Shifts
Date	Name	Change Description	Initials and Date

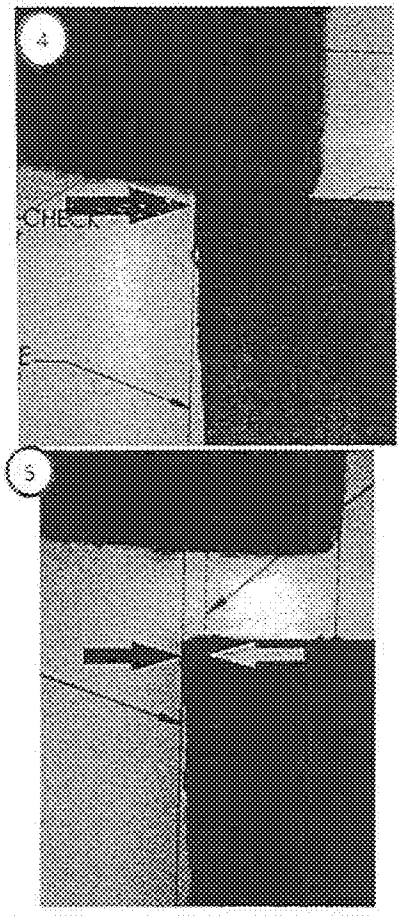
Standardized Work Sheet

SWI #	Department	Operation	Part Name	Part NO.	JES #	Time
2 of 2						

Post-Torque Comparator Check

Safety	Quality Check	KPC	Ergonomic	Critical Operation	PMP	Written By:	N. Kline
	Q	K	E		PMP	Date:	5/21/2014

MCNEIL 1085

Visuals	Sequence #	Symbol	Major Step (what)	Key Point (how)
	7		Align Trigger W/ Set Line (See Image 4)	*Using knob on side of comparator fixture, position fire control so Trigger edge is aligned with appropriate comp. screen set line.
	8		Move Safe Arm to "Safe" Position	
	9		Hang 7lb Weight from Trigger	*Add required amount of weight to current amount to result in 7 lb force.
	10		Verify Deflection (See image 5)	*Verify trigger edge is between the min and max set lines on comparator screen.
	11		Place Out	*IF ACCEPTABLE: Place completed fire control into outgoing tray. *IF NOT ACCEPTABLE: Place in red "Scrap" bin.

Buyoff		Team Leader	Supervisor	Department Head
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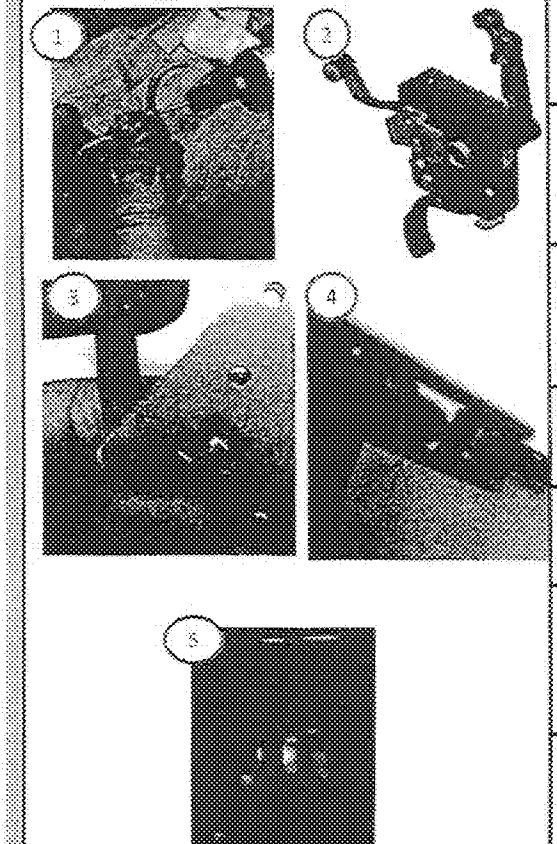
Revision Log			Confirmation by Shifts		
Date	Name	Change Description	Initials and Date		

Standardized Work Sheet

SWS #	Department	Operation	Part Name	Part NO.	JES #	Time
1 of 3	8772	OP 20R	XMP (Repair)			

REPAIR - Stage 2R (Customer 263) [OHL]

Safety	Quality Check	KPC	Ergonomic	Critical Operation	PMP	Written By:	R. Kline
	Q	K	E		BM8	Date:	6/3/2015

Visuals	Sequence #	Symbol	Major Step (what)	Key Point (how)
	1		Pick Assembly	*Pick partially assembled trigger assembly from Station 1
	2	▽	Verify Engagement/Blocker Screws Are Absent	*If either screws are present, place in red scrap bin.
	3	▽	Seat Spring (EA Models Only) (See image 3)	*Using spring seating tool, apply force secondary trigger pull spring. *Access spring thru secondary trigger pull screw hole in trigger.
	4		Assemble Sear (See image 4)	*Visually inspect Sear surfece for damage. *Place front end of sear safety cam into the trigger housing so that the holes align.
	5		Insert Slave Pin (See image 5)	*Insert slave pin into the mated hole of the sear and housing.
	6		Insert Sear Spring (See image 6)	*Place sear spring on the sear spring support in housing. *Rotate tail of sear safety cam downward until it clears the holes in the back of the housing.
	7		Insert Slave Pin	*Insert second slave pin into hole (above sear) in order to retain sear in position.
	8	▽	Verify Spring is Seated (See image 8)	* Looking thru the blocker window, verify that the sear spring is properly seated on post of spring support and captured by correct face on sear. Make correct if out of position.

Signoff		Team Leader	Supervisor	Department Head
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Revision Log			Confirmation by Shifts		
Date	Name	Change Description	Initials and Date		

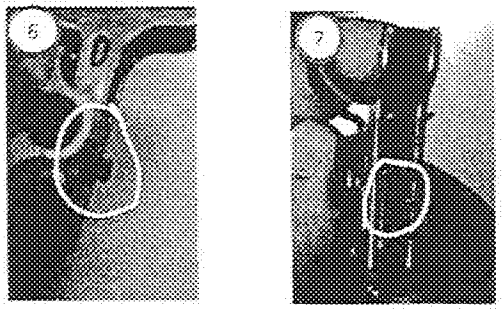
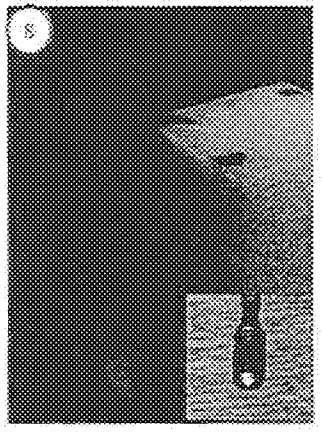
KCNHL1 10869

Standardized Work Sheet

SWS #	Department	Operation	Part Name	Part NO.	JES #	Time
2 of 3	8772	OP 20R	ZMP (Repair)			

REPAIR - Stage 2R (Customer 263) [OHL]

Safety	Quality Check	KPC	Ergonomic	Critical Operation	PMP	Written By:	N. Kline
	Q	K	E		ZMP	Date:	6/3/2014

Visuals	Sequence #	Symbol	Major Step (what)	Key Point (how)
	9	▼	Check For Trigger Pull Spring (See Image 6)	*Using tool, investigate presence of primary trigger pull spring. *If absent, continue to step 9. *If present, remove and discard. Proceed to step 9.
	10	▼	Install Trigger Pull Spring	*Place primary trigger pull spring into appropriate threaded hole. * For NA Model: Confirm end of spring with burr goes into hole first
	11	▼	Install Primary Trigger Pull Screw (See Image 7)	* Using Milwaukee cordless driver, install primary trigger pull screw into appropriate threaded hole. *Adjust inward until screw head is about 2 to 3 turns below the outer edge of the spacer.
	12		Pick Blocker Screw and Place on Tip of Power Bit	*Place reassembled fire control in designated area next to comparator.
	13	▼	Apply Loctite To Blocker Screw (See Image 8)	* Firmly press the nose of the blocker screw against the center of the slot on Loctite application block 68187. * Slide blocker screw (while still held against fixture) to the right approximately .25" * Apply 1 drop of Loctite 263 to the first few visible threads adjacent to the application block Loctite dispenser. * Loctite contacting screw face is NOT permissible.

Buyoff		Team Leader	Supervisor	Department Head
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Revision Log			Confirmation by Shifts
Date	Name	Change Description	Initials and Date

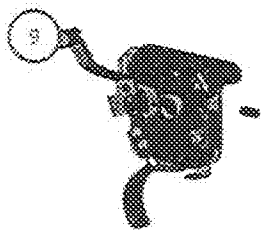
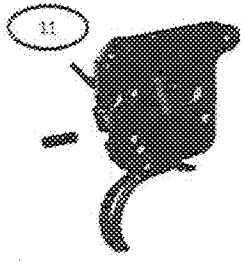
HCNDLL 11887

Standardized Work Sheet

SWS #	Department	Operation	Part Name	Part NO.	JES #	Time
3 of 3	8772	OP 20R	XMP (Repair)			

REPAIR - Stage 2R (Customer 263) [OHL]

Safety	Quality Check	KPC	Ergonomic	Critical Operation	PMP	Written By:	N. Kline
	Q	K	E		PMP	Date:	6/3/2014

Visuals	Sequence #	Symbol	Major Step (what)	Key Point (how)
	14		Insert Blocker Screw (See image 9)	*Holding trigger assembly in hand, insert Blocker screw into blocker using Milwaukee cordless screw driver. *Thread the screw in until 1 to 2 threads protrude from the inside of the blocker toward the trigger.
	15		Pick Engagement Screw and Place on Tip of Power Bit	
	16	▼	Apply Loctite To Engagement Screw (See image 10)	* Firmly press the nose of the engagement screw against the center of the slot on Loctite application block 68187. * Slide engagement screw (while still held against fixture) to the left approximately .25" * Apply 1 drop of Loctite 263 to the first few visible threads adjacent to the application block using Loctite dispenser *Apply 1 drop of Loctite 263 approximately half way between the previous drop and the rear of the screw using Loctite dispenser * Loctite contacting screw face is NOT permissible.
	17		Insert Trigger Engagement Screw (See image)	*Holding trigger assembly in hand, insert Engagement screw into rear spacer using Milwaukee cordless screw driver. *Thread the screw in until the rear of the screw is flush with the spacer.
	18	▼	Wipe Excess Loctite	*Wipe Excess Loctite from surfaces of housing and blocker using a Q-Tip
	19		Place Out	*Place reassembled fire control in designated area next to comparator.

Sign Off		Team Leader	Supervisor	Department Head
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Revision Log			Confirmation by Shifts		
Date	Name	Change Description	Initials and Date		

8801 LH Bench

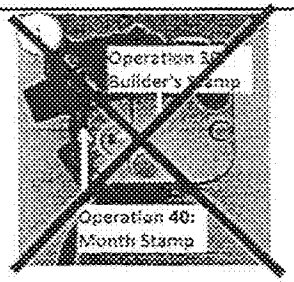
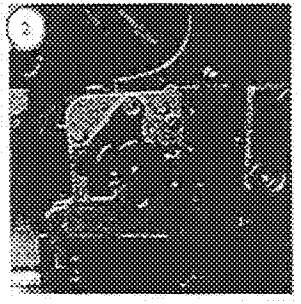
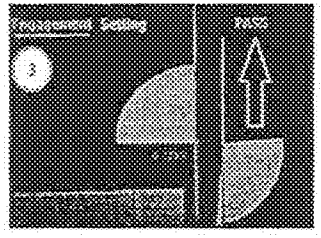
Standardized Work Sheet

Sheet #	Department	Operation	Part Name	Part NO.	JES #	Time
1 of 3						

Adjust Trigger Assembly (COGNEX)

Safety	Quality Check	KPC	Ergonomic	Critical Operation	PMP	Written By:	N. Klee
					EMP	Date:	9/15/2014

MCNEIL 1089

Visuals	Sequence #	Symbol	Major Step (what)	Key Point (how)
	1		~~Stamp~~ (See Image 1)	~~*Place trigger assembly in stamping fixture.~~ ~~*Locate Builder Specific stamp to the right of the top rivet, and above the bottom rivet.~~
	2	▼	Place in fixture/Cycle (See Image 2)	*Cycle trigger assembly by holding at front sear pin with left thumb, apply finger pressure to trigger near pivot pin approximately 4 times.
	3	▼	Clamp Assy. In Fixture	*While still holding front sear pin with left hand against stop surface of fixture, engage clamp to hold assembly in place.
	4		Verify Screen	*Verify system is measuring engagement. If not, push "Engagement"
	5	▼	Position Set Line	*Safety in "Fire" position. *Tap [redacted] to automatically position the set line. NOTE: If set line does not appear, adjust engagement screw inward until lines appear.
	6	▼	Set Trigger/Sear Engagement (See Image 3)	*Turn engagement screw to position the trigger edge within the targeted region. This is achieved when the lines turn green and PASS is displayed on the screen. *NOTE: SETTING MUST BE DONE FROM RIGHT TO LEFT. IF ADJUSTED PAST MIN SPEC, MUST BACK SCREW OUT SLIGHTLY AND ATTEMPT TO SET AGAIN FROM RIGHT TO LEFT. *Acceptable Zone: .0190" - .0210" *Targeted Zone: .0205" - .0210"

Shift #		Team Leader	Supervisor	Department Head
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Revision Log				Confirmation by Shifts
Date		Name	Change Description	Initials and Date

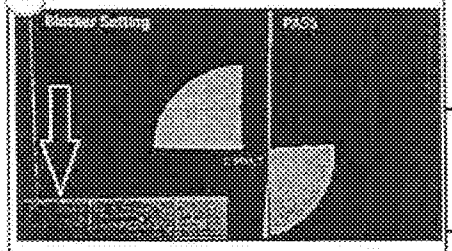
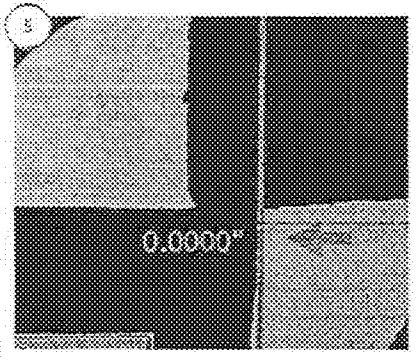
Standardized Work Sheet

SWI #	Department	Operation	Part Name	Part NO.	REV #	Time
2 of 2						

Adjust Trigger Assembly (COGNEX)

Safety	Quality Check	KPC	Ergonomic	Critical Operation	PPE	Written By:	N. Klos
	Q		E		PPE	Date:	8/15/2014

MCNEIL 1090

Visuals	Sequence #	Symbol	Major Step (what)	Key Point (how)
	7	▼	**Hang Appropriate Weight from Trigger**	*Sear must be held against trigger. *Safety in FIRE position. *EA assemblies, hang 3 lb load from trigger. *NA assemblies, hang 5 lb load from trigger.
4 	8		**Adjust Primary Trigger Pull Screw**	*Adjust primary trigger pull screw in counter clockwise direction until the trigger rotates from underneath the sear safety cam, allowing the sear to drop.
	9		**Cycle**	*Remove weight from the trigger. *Hold front sear pin with left hand. (Same as step 2) *Release toggle clamp and allow sear and trigger to re-engage with right hand.
	10		**Recheck**	*Recheck engagement. Adjust as necessary.
5 	11	▼	**Switch System To Blocker Mode** (See Image 4)	*Tap [redacted] to switch to blocker adjustment mode.
	12	▼	**Position Set Line** (See Image 5)	*Safety in "Fire" position *Zero load on trigger *Tap [SET LINE] to automatically position the set line.
	14		**Reposition Safety**	*Move safety to "Safe" position.
	15	▼	**Apply 7lb Load**	*VERY GENTLY, Hang 7lb load from trigger using weight system.

Buyoff	Team Leader	Supervisor	Department Head
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Revision Log			Confirmation by Shifts
Date	Name	Change Description	Initials and Date

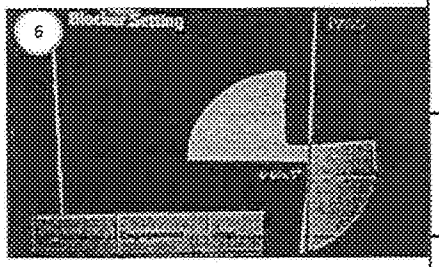
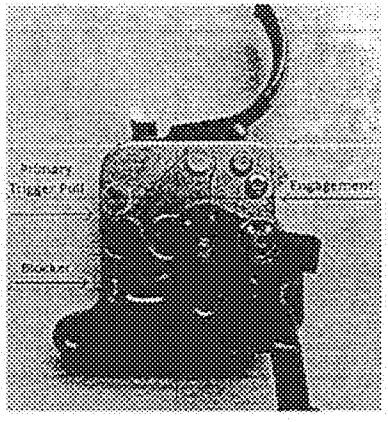
Standardized Work Sheet

Shift #	Department	Operation	Part Name	Part NO.	RS #	Time
3 of 3						

Adjust Trigger Assembly (COGNEX)

Safety	Quality Check	EPC	Ergonomic	Critical Operation	PMP	Written By:	R. Kline
	Q		E		PMP	Date:	8/19/2024

MNEL-1091

Visuals	Sequence #	Symbol	Major Step (what)	Key Point (how)
	16	▼	**Set Blocker Screw** (See image 6)	*With safety on, turn blocker screw to position the trigger edge within the targeted region. This is achieved when the lines turn green and [redacted] is displayed on the screen. *Acceptable Zone: .000" - .003" *Targeted Zone: .000" - .0005"
	17		**Remove/Reapply Weight**	*Lift weight from trigger and reapply to display accurate blocker measurment. *Readjust as necessary. *Once finished, remove weight from trigger.
	18		**Cycle**	*Move safety to "Fire" *Apply finger pressure to trigger to allow sear to drop. *Hold front sear pin and reengage toggle.
	19	▼	**Recheck Engagement**	*Push "Engagement" button. *Press "Set Line" button. *Engagement must be .0190" - .0210"
	20	▼	**Recheck Blocker**	*Push "Blocker"button. *Press "Set Line" button. *Move Safe arm to "Safe" position. *Gently apply 7 lb weight to trigger. Deflection must be .0000" - .0030"
	21		**Adjust as Necessary**	*If either setting is out of spec. adjust as necessary. *If adjustment required, repeat steps 19 & 20.
	22	▼	**Cure**	*Loctite cure time: 24 hrs

Signoff		Team Leader	Supervisor	Department Head
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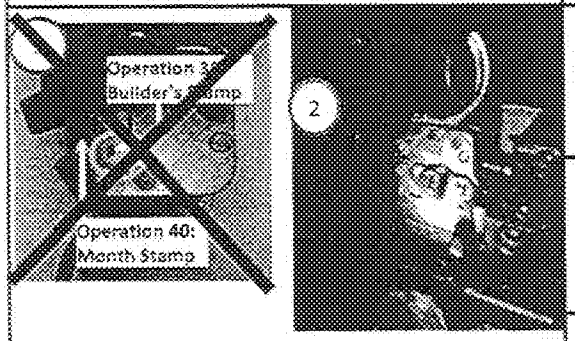
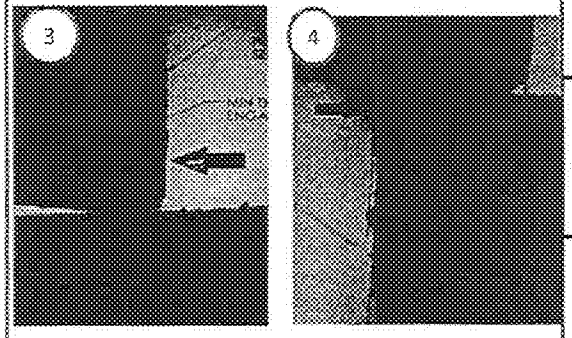
Revision Log			Confirmation by Shifts		
Date	Name	Change Description	Initials and Date		

Standardized Work Sheet

SWI #	Department	Operation	Part Name	Part NO.	JES #	Time
1 of 3	18772	OP 30	KMP	A8		

Adjust Trigger Assembly on Comparator

Safety	Quality Check	KPC	Ergonomic	Critical Operation	PMP	Written By:	N. Kline
	Q	KPC	E		PMP	Date:	6/6/2014

Visuals	Sequence #	Symbol	Major Step (what)	Key Point (how)
	1		~~Stamp~~ (~~See Image 1~~)	~~*Place trigger assembly in stamping fixture.~~ ~~*Locate Builder Specific stamp to the right of the top rivet, and above the bottom rivet.~~
	2	▼	Load Assy. In Fixture (See Image 2)	*Press assembly firmly against rear stops. *Engage clamp to hold assembly in place.
	3	▼	Focus Lens	*Turn focus knob until the image is clear.
	4	▼	Align Sear W/ Set Line (See image 3)	*Tap rear of trigger forward (away from weight system) *Safety in "Fire" position. *Using knob on side of comparator fixture, position fire control so Sear edge is aligned with appropriate comp. screen set line.
	5	▼	Set Trigger/Sear Engagement (See Image 4)	*With safety off, turn engagement screw to position the trigger edge within the .021" MAX and .019" MIN lines on screen. *Ideally, set at .021"
	6	▼	Hang Appropriate Weight from Trigger	*Sear must be held against trigger. *Safety in FIRE position. *EA assemblies, hang 2.5 lb load from trigger. *NON EA assemblies, hang 5 lb load from trigger.

Buyoff		Team Leader	Supervisor	Department Head
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Revision Log			Confirmation by Shifts		
Date	Name	Change Description	Initials and Date		

MCW11F 10022

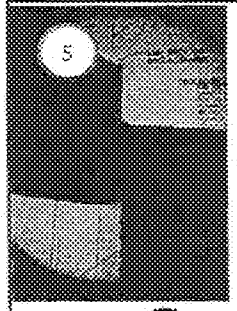
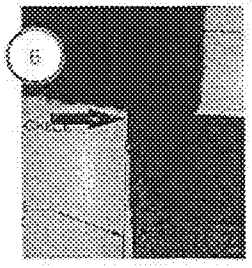
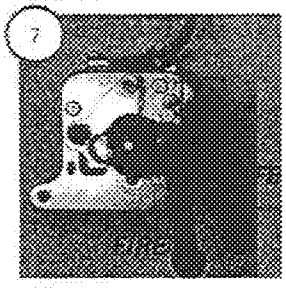
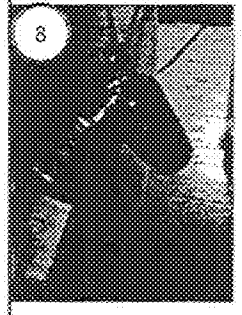
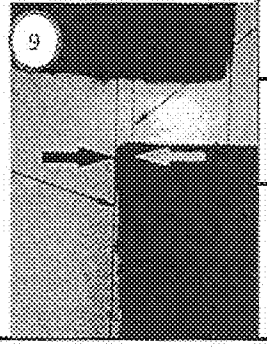
Standardized Work Sheet

SWI #	Department	Operation	Part Name	Part NO.	JES #	Time
2 of 3						

Adjust Trigger Assembly on Comparator

Safety	Quality Check	KPC	Ergonomic	Critical Operation	PMP	Written By:	N. Kline
	Q	K	E		PMP	Date:	6/6/2014

MCWD11 10093

Visuals	Sequence #	Symbol	Major Step (what)	Key Point (how)
 	7	▼	Adjust Primary Trigger Pull Screw (See Image 5)	*Adjust primary trigger pull screw in counter clockwise direction until the trigger rotates from underneath the sear safety cam, allowing the sear to drop.
	8		Cycle and Recheck	*Remove weight from the trigger. *Release toggle clamp and allow sear and trigger to re-engage. *Recheck engagement and trigger pull using weight. (NOT LESS THAN 2.5 LBS) *Adjust as necessary.
	9		Refocus Lens	*Weight is removed *Bring trigger edge to sharp focus
	10	▼	Align Trigger W/ Deflection Set Line (See image 6)	*Tap rear of trigger forward (away from weight system) *safety in "Fire" position *Zero load on trigger *Using knob on side of comparator fixture, position fire control so Trigger edge is aligned with appropriate comp. screen set line.
 	11	▼	Move Safety to "Safe" Position (See image 7)	
	12		Apply 7lb Load (See image 8)	*FOR EA & Non Adjustable: Hang 7lb load from trigger using weight system.
	13	▼	Set Blocker Screw (See Image 9)	*Adjust the blocker screw inward (image moves from right to left) until there is .000" MIN to .003" MAX visible deflection of the trigger *Deflection to be set at MIN (.000") *Note: It is acceptable for trigger to return past MIN when weight is removed

Buyoff		Team Leader	Supervisor	Department Head
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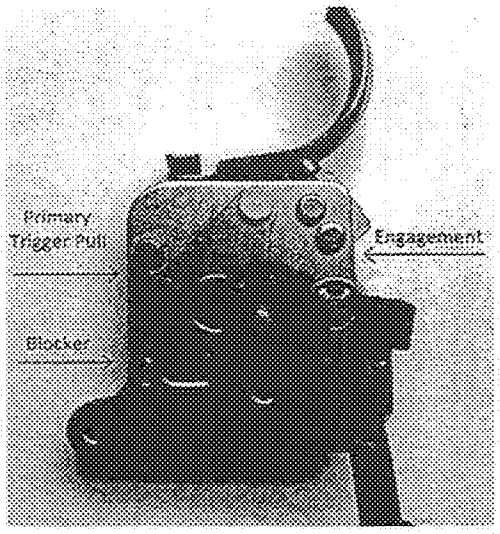
Revision Log			Confirmation by Shifts
Date	Name	Change Description	Initials and Date

Standardized Work Sheet

SWI #	Department	Operation	Part Name	Part NO.	JES #	Time
3 of 3						

Adjust Trigger Assembly on Comparator

Safety	Quality Check	KPC	Ergonomic	Critical Operation	PMP	Written By:	N. Kline
	Q	K	E		PMP	Date:	6/6/2014

Visuals	Sequence #	Symbol	Major Step (what)	Key Point (how)
	14		Move Safe Arm to "Fire" (See Image 8)	
	15		Align Trigger W/ Deflection Set Line (See image 5)	*Tap rear of trigger forward (away from weight) *safety in "Fire" position *Zero load on trigger *Using knob on side of comparator fixture, position fire control so Trigger edge is aligned with appropriate comp. screen set line.
	16		Move Safety to "Safe" Position (See Image 9)	
	17		Recheck Blocker Setting and Adjust as Necessary	*Adjust the blocker screw inward (Image moves from right to left) until there is .000" MIN to .003" MAX visible deflection of the trigger when 7 lb load is applied. *Ideally, blocker screw setting should be made to show visible motion just past the MIN position line on the comparator screen.
	18		Cure	*Loctite cure time: 24 hrs

Buyoff		Team Leader	Supervisor	Department Head
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Revision Log			Confirmation by Shifts
Date	Name	Change Description	Initials and Date

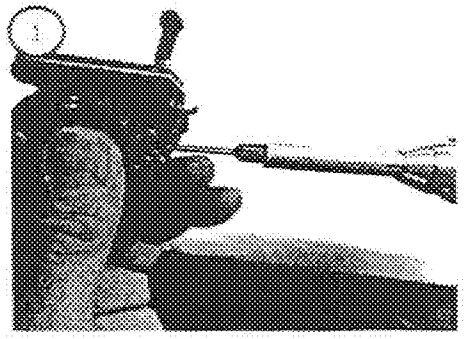
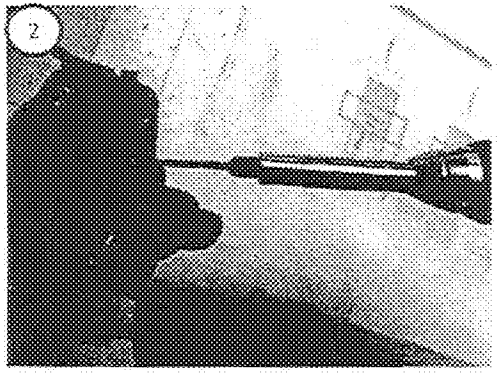
REMINGTON 1694

Standardized Work Sheet

SWI #	Department	Operation	Part Name	Part NO.	JES #	Time
1 of 3						

Apply Torque to Screws

Safety	Quality Check	KPC	Ergonomic	Critical Operation	PMP	Written By:	N. Kline
	Q	K	E		PMP	Date:	5/19/2014

Visuals	Sequence #	Symbol	Major Step (what)	Key Point (how)
	1		Check For Trigger Engagement Screw Movement (See image 1)	- Using a 1/16" hex power bit and click style torque analyzer, lightly torque (24 in.oz) the trigger engagement screw in counter clockwise direction until torque wrench clicks. -Screw must NOT move.
	2		Check For Blocker Screw Movement (See image 2)	- Using a 1/16" hex power bit and click style torque analyzer, lightly torque (24 in.oz) the blocker screw in counter clockwise direction until torque wrench clicks. - Screw must NOT move.
	3			
	4			
	5			

Buyoff		Team Leader	Supervisor	Department Head
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Revision Log			Confirmation by Shifts		
Date	Name	Change Description	Initials and Date		

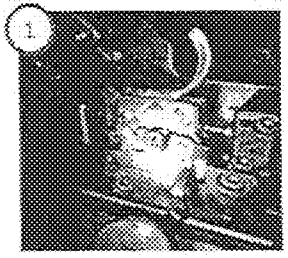
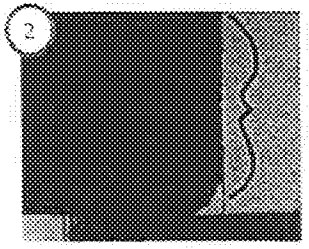
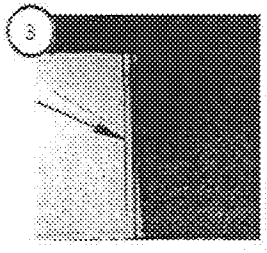
MCNELLY 1095

Standardized Work Sheet

SWI #	Department	Operation	Part Name	Part NO.	JES #	Time
1 of 2						

Post-Torque Comparator Check

Safety	Quality Check	KPC	Ergonomic	Critical Operation	PMP	Written By:	N. Kline
	Q	H	E		PMP	Date:	5/21/2014

Visuals	Sequence #	Symbol	Major Step (what)	Key Point (how)
	1		Pick Trigger Assembly	*Pick completed trigger assembly from previous operation.
	2		Move Safe Arm To "Fire" Position	
	3		Load Assy. In Fixture (See image 1)	*Press assembly firmly against rear stops. *Engage Destaco clamp to hold assembly in place.
	4		Focus Lens	*Turn knob until the image is clear.
	5		Align Sear W/ Set Line (See Image 2)	*Safety in "Fire" position. *Using knob on side of comparator fixture, position fire control so Sear edge is aligned with appropriate comp. screen set line.
	6		Verify Engagement (See image 3)	- Verify trigger edge is between min and max engagement set lines on comparator screen.

Buyoff		Team Leader	Supervisor	Department Head
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Revision Log			Confirmation by Shifts		
Date	Name	Change Description	Initials and Date		

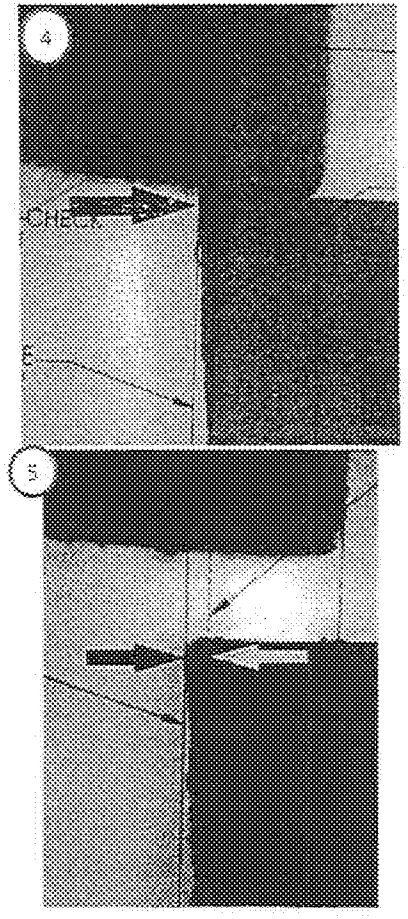
MCARTL 1096

Standardized Work Sheet

SWS #	Department	Operation	Part Name	Part NO.	JES #	Time
2 of 2						

Post-Torque Comparator Check

Safety	Quality Check	KPC	Ergonomic	Critical Operation	PMP	Written By:	N. Kline
	Q	K	E		PMP	Date:	5/21/2014

Visuals	Sequence #	Symbol	Major Step (what)	Key Point (how)
	7		Align Trigger W/ Set Line (See Image 4)	*Using knob on side of comparator fixture, position fire control so Trigger edge is aligned with appropriate comp. screen set line.
	8		Move Safe Arm to "Safe" Position	
	9		Hang 7lb Weight from Trigger	*Add required amount of weight to current amount to result in 7 lb force.
	10		Verify Deflection (See image 5)	*Verify trigger edge is between the min and max set lines on comparator screen.
	11		Place Out	*IF ACCEPTABLE: Place completed fire control into outgoing tray. *IF NOT ACCEPTABLE: Place in red "Scrap" bin.

Buyoff		Team Leader	Supervisor	Department Head
Shift	Sign			
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Revision Log			Confirmation by Shifts
Date	Name	Change Description	Initials and Date

RCNEW 1097

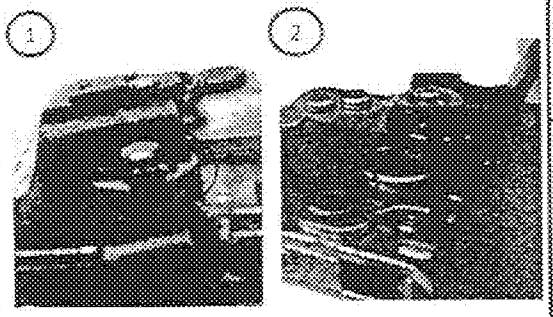
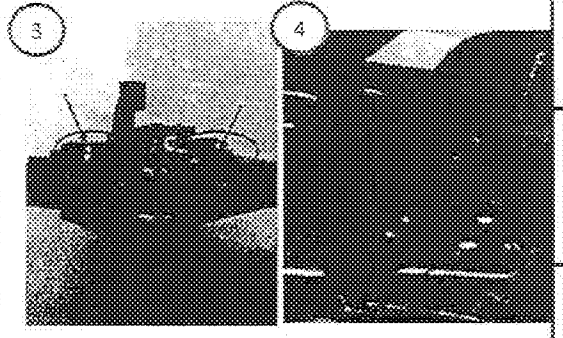
Standardized Work Sheet

SWI #	Department	Operation	Part Name	Part NO.	JES #	Time
3 of 3	XMP	Inspection	XMP	All		

Function Check / Inspection

Safety	Quality Check	KPC	Ergonomic	Critical Operation	PMP	Written By:	N. Kline
	Q	K	E		PMP	Date:	5/21/2014

MCNEIL 1098

Visuals	Sequence #	Symbol	Major Step (what)	Key Point (how)
	1		Visual Inspection	*Verify absence of marrs, chips, etc.. on housing and components
	2		Check Safety Retainer (See image 1)	* Make sure that all of the retainer's legs are snapped into the groove in the safety pivot pin.
	3		Check Safety Detent Spring (See image 2)	*Make sure each end of the spring is securely located in the holes in the blocker and safety.
	4		Check Bolt Stop Release	*The bolt stop release should be free to move the entire range of the slotted holes.
	5		Check Blocker Hold Down Stud and Trigger Pivot Pin (See image 3)	*The head of each pin should be raised slightly from the surface of the blocker to allow movement.
	6		Check Retaining Ring (See image 4)	* The retaining ring should be seated securely within the notch of the trigger pivot pin.

Buyoff		Team Leader	Supervisor	Department Head
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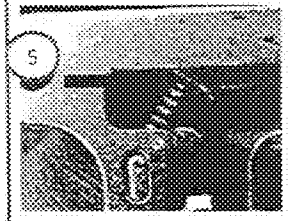
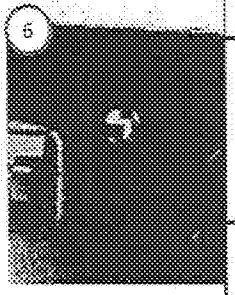
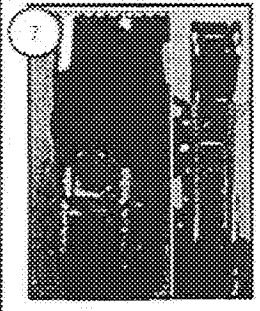
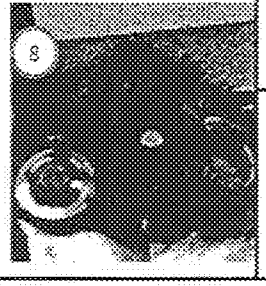
Revision Log			Confirmation by Shifts		
Date	Name	Change Description	Initials and Date		

Standardized Work Sheet

SWS #	Department	Operation	Part Name	Part NO.	JES #	Date
2 of 3	XMP	Inspection	XMP	All		

Function Check / Inspection

Safety	Quality Check	KPC	Ergonomic	Critical Operation	PMP	Written By:	M. Kline
	Q	K	E		PMP	Date:	5/21/2014

Visuals	Sequence #	Symbol	Major Step (what)	Key Point (how)
 	7		Check Trigger Retraction	*Pull Trigger and Release. *Trigger must return freely to original position WITH SPRING FORCE. * Trigger must not rattle in housing.
	8		Verify Sear Freedom (See image 5)	*Pull trigger and hold. Depress sear FULLY and release. *Sear must move freely in housing. *Sear must return upward under sear spring force. *Seat spring in correct orientation below sear.
	9		Check Safety Function (See image 5)	*Move safe arm to "Fire" position and back to "Safe" *Repeat again. *Apply finger pressure to trigger. No movement of trigger from under sear should be felt or visible.
	10		Apply Contact Adhesive (See image 7)	*Apply sealing layer of contact adhesive to the head of the trigger engagement AND blocker screws.
	11		Apply RemOil (See image 8)	*Apply 1 - 2 drops to the contact point of the safety slot and blocker post.

Ryvoff		Team Leader	Supervisor	Department Head
Shift	Sign			
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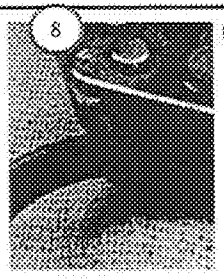
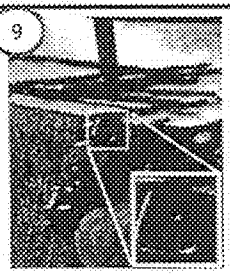
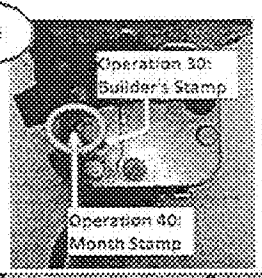
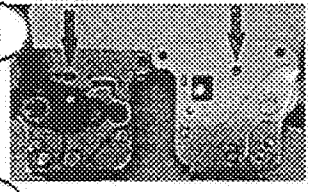
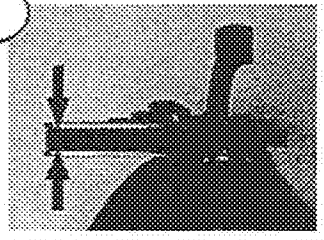
Revision Log			Confirmation by Shifts
Date	Name	Change Description	Initials and Date

Standardized Work Sheet

SWI #	Department	Operation	Part Name	Part NO.	IES #	Time
3 of 3	XMP	Inspection	XMP	All		

Function Check / Inspection

Safety	Quality Check	KPC	Ergonomic	Critical Operation	PMP	Written By:	R. Kline
	Q		E		EMP	Date:	3/21/2014

Visuals	Sequence #	Symbol	Major Step (what)	Key Point (how)
8  9 	12		Insert Secondary Trigger Pull Screw (EA) (See image 8)	*Tighten 2-3 turns. *Do not compress secondary trigger pull spring.
	13		Prick Punch Bolt Stop Release (See image 9)	*Using spring loaded punch to dimple bottom arm of bolt stop release.
10 	14	▽	Stamp (See image 10)	*Place trigger assembly in stamping fixture. *Locate the appropriate month stamp (BLACKPOWDERX)directly above the top rivet.
11  12 	15		Apply Molycoat (See image 11 & 12)	*Safety in "Fire" position. *Apply to top surface of trigger through window in side plate from both sides. *Apply to top surface of sear where contacted by firing pin head. *Apply to slot between sear and side plates at front pivot

Buyoff		Team Leader	Supervisor	Department Head
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Revision Log			Confirmation by Shifts		
Date	Name	Change Description	Initials and Date		