

FINISHED PRODUCT DEFECT INDEX
QUALITY CONTROL OFFICE

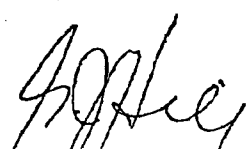
R. SWEDEKER

August 27, 1975

FINISHED PRODUCT DEFECT INDEX

This booklet contains a list of typical
demerit items used by Quality Audit.

Please use as a reference for your
areas.



G. J. Hill
Supervisor Quality Control

GJH/kmk

DATES A REASONS FOR REVISIONS

4/2/75 - Revised - CAK/bdm

DESCRIPTIVE INFORMATION

Finished Product Defect Index - Classification & Demerit Values

<u>I. Demerit Value</u>	<u>Definition</u>	<u>Examples</u>	<u>Model</u>
100	1. Safety hazard	Bbl. bracket separated from Barrel.	M/600, 700
	2. Product inoperable	Bbl. lug separated from bbl.	M/742, 760
	3. Proof mark missing on Bbl.	Bbl. separated from bbl. guide ring.	M/870
		Barrel separated from bbl. gas cylinder.	M/1100
		Broken firing pin.	All models
		Cracked extension.	M/11-48, 742, 760
		Fires on safe.	All models
		Fires when closing.	All models
		Jars off.	All models
		Action jams on live round	All models

PART NAME Finished Product Defect Index

SET UP TIME

MODEL No. All models

OPER. No.

TYPE

MACH. HRS.

DEPT. No.

PAGE 1 OF 48

MACHINE

DATES AT REASONS FOR REVISIONS
4/2/75 - Revised - CAK/bdm

DESCRIPTIVE INFORMATION

Finished Product Defect Index - Classification & Demerit Values

II. Demerit Value	Definition	Examples	Model
50	1. Intermittently fails to function causing inconvenience in operation.	Action binds (major) Action jam.	All models All models
	2. Repeating firearm only functions as a single shot.	Bar lock out of position Bolt stems shell in mag.	M/870, 760, 572 All box mag. rifles
	3. Defects in components present imminent functional failure.	Can't load magazine Carrier catches.	All models All tubular magazine firearms
	4. Foreign material in action makes product inoperable.	Doesn't blow back. Doesn't feed back.	All autoloaders M/1100, 11-48, 870, 552, 572, N/66
		Doesn't feed up.	All models
		Doesn't lock back.	M/11-48, 1100
		Doesn't lock open.	M/1100, 11-48, 742
		Doesn't lock up.	M/1100, 11-48, 742, 760, 572, 870
		Drops shells.	All models

PART NAME Fin. Product Defect Index COOLANT SET UP TIME MODEL No. All models OPER. No.
TYPE MACH. HRS. DEPT. No. PAGE 2 OF 118
MACHINE

REASONS FOR REVISIONS

4/2/75 - Revised - CAK/bdm

DESCRIPTIVE INFORMATION

Finished Product Defect Index - Classification & Demerit Values

II. Demerit Value Definition

50 (cont.)

Examples	Model
Fails to connect.	All models
Fails to extract - ejects. part time.	All models
Fails to feed from mag.	M/1100, 11-48, 870, 552, 572, N/66, N/100
Fails to fire.	All models
Hammer follows down.	All models
Interceptor latch catches on head of shell.	M/1100
Jumps cartridge stop	M/552, 572, N/66
Mag. follower sticks.	All tubular mag. firearms
Ext. Max. or Ext. Min. header	All models
Outer mag. tube pulls out	M/552, 572, N/66, 582
Over rides	All repeating rifles except M/742
Shells jam in mag.	M/700, 600, 742, 760

PART NAME Fin. Product Defect Index COOLANT

SET UP TIME

MODEL No. All Models

OPER. No.

TYPE

MACH. HRS.

DEPT. No.

PAGE 3

OF 48

MACHINE

DATES / REASONS FOR REVISIONS
11/2/75 - Revised - CMK/bdm

DESCRIPTIVE INFORMATION

Finished Product Defect Index - Classification & Demerit Values

II. Demerit Value Definition

50 (cont.)

<u>Examples</u>	<u>Model</u>
Shells jump carrier latch	All tubular magazine firearms
Shells jump magazine	M/700, 600, 742, 760
Shells stem chamber	All models
Shells tip down	All models
Shells tip up	M/552, 572
Stems incline	M/742, 760, 700, 600, 788
Stems port	M/552, 572, N/66
Stem over rides	M/742, 760, 700, 600
Won't close up	M/552, N/66

PART NAME Fin. Product Defect Index COOLANT

SET UP
TIME

MODEL No. All Models

OPER. No.

TYPE

MACH. HRS.

DEPT. No.

PAGE 4 OF 48

MACHINE

REASONS FOR REVISIONS
4/2/75 - Revised - CAK/bdm

DESCRIPTIVE INFORMATION

Finished Product Defect Index - Classification & Demerit Items

III. Demerit Value	Definition	Examples	Model
10	1. Visual, dimensional or adjustment defects presenting potential functional failures.	A. Barrel Assembly Barrel doesn't seat at front of Stock.	M/700, 500 Series, 788
	2. Major damaged or objectionable visual, dimensional or adjustment items - not presenting potential functional failures.	Barrel extension loose. Barrel lays off center. Barrel loose in Receiver. Barrel marred. Head flat. Bore oversize. Bore pitted. Bore undersize. Burr on edge of chamber. Cases swell under rim. Chamber rough.	M/11-48, 742, 760 M/600, 700, 500 Series, 788 M/500 Series All models M/1100, 11-48, 870, 552, 572 All models All models All models All models All centerfire and rimfire rifles All models

PART NAME Fin. Product Defect Index COOLANT SET UP TIME MODEL No. All Models OPER. No. _____
TYPE _____ MACH. HRS. _____ DEPT. No. _____ PAGE 5 OF 48
MACHINE

DATES A REASONS FOR REVISIONS
11/22/75 - Revised - CAK/bdm

DESCRIPTIVE INFORMATION

Finished Product Defect Index - Classification & Demerit Values

III. Demerit Value
10 (cont.)

<u>Examples</u>	<u>Model</u>
A. <u>Barrel Assembly</u> - (cont)	
Crooked Barrel.	All models
Ejector only partially brazed to Barrel.	M/1100, 11-48
Ejector spring broken.	M/870
Ejector spring loose.	M/870
Flat crown on Barrel.	All models
Front sight crooked.	All models
Front sight ivory bead broken	M/1100, 11-48, 870
Front sight damaged.	All models
Front sight loose.	All centerfire and rimfire, 1100 Deer Gun, 11-48 Brushmaster
Front sight marred.	All centerfire and rimfire, 1100 Deer Gun, 11-48 Brushmaster
Front sight not fitted properly.	M/552, 572, all centerfire.

PART NAME Fin. Product Defect Index COOLANT

SET UP
TIME

MODEL No. All Models

OPER. No.

MACH. HRS

DEPT. No.

PAGE 6

OF 48

MACHINE

DATES A REASONS FOR REVISIONS
4/2/75 - Revised - CAK/bdm

DESCRIPTIVE INFORMATION

Finished Product Defect Index - Classification & Demerit Values

III. Demerit Values Definition

10 (cont.)

Examples

A. Barrel Assembly (cont.)

Model

All centerfire, 1100
Deer Gun, 11-48
Brushmaster

Front sight ramp marred.

All centerfire, 1100
Deer Gun, 11-48
Brushmaster

Front sight screw loose.

All centerfire, 1100
Deer Gun, 11-48
Brushmaster

Front sight screw missing.

M/1100

Gas cylinder miscut.

All models

Inclusion in bore.

All centerfire and
rimfire

Incorrect front sight.

M/500, 700

Last shell shaves lead.

All models.

Light roll on Barrel.

M/1100, 11-48, 870

Lock notch on extension
damaged.

PART NAME Fin. Product Defect Index COOLANT

SET UP
TIME

MODEL No. All Models

OPER. No.

TYPE

MACH. HRS.

DEPT. No.

PAGE 7

OF 48

MACHINE

DATES AND REASONS FOR REVISIONS
4/2/75 - Revised - CAK/bdm

DESCRIPTIVE INFORMATION

Finished Product Defect Index - Classification & Demerit Values

III. Demerit Values Definition

10 (cont.)

Examples	Model
A. Barrel Assembly (cont.)	
Matting light on vent rib	M/1100, 11-48, 870, 600
Nick in chamber.	All models
Poor finish on Barrel.	All models
Poor grind on Barrel.	All models
Poor polish on Barrel.	All models
Rear sight screw & step missing.	All centerfire and rimfire, 1100 Deer Gun, 11-48 Brushmaster
Rear Sight elevating screw not functioning properly.	All centerfire and rimfire, 1100 Deer Gun, 11-48 Brushmaster
Rear sight elevating screw loose.	All centerfire and rimfire, 1100 Deer Gun, 11-48 Brushmaster
Rear sight tips left/right.	All models
Rings in bore.	All models
Rings in cone angle of Barrel guide ring.	M/11-48

PART NAME Fin. Product Defect Index COOLANT SET UP TIME MODEL No. All models OPER. No. 8
TYPE MACH. HRS. DEPT. No. 8 PAGE 8 OF 48
MACHINE

REASONS FOR REVISIONS

11/2/75 - Revised - CAK/bdm

DESCRIPTIVE INFORMATION

Finished Product Defect Index - Classification & Demerit Values

III. Demerit Value Definition

10 (cont.)

Examples Model

A. Barrel Assembly (cont.)

Rings in cone angle of gas cylinder. M/1100

Ripples on Barrel. All models

Scant choke. M/1100, 11-48, 870

Scratch in bore. All models

Seam in Barrel. All models

Step in chamber. All models

Tear in bore. All models

Tear in chamber. All models

Test stamp missing All models

Vent rib marred M/1100, 870, 11-48, 600

Void in Barrel bracket M/11-48, 870

Wavy bore All models

Wrong choke M/1100, 11-48, 870

VISUALLY OBJECTIONABLE

PART NAME Fin. Product Defect Index COOLANT

SET UP TIME

MODEL No. All models

OPER. NO.

TYPE

MACH. HRS.

DEPT. No.

PAGE 9

OF 118

MACHINE

DATES A. REASONS FOR REVISIONS
4/2/75 - Revised - CAK/hdm

DESCRIPTIVE INFORMATION

Finished Product Defect Index - Classification & Demerit Values

III. Demerit Value Definition

10 (cont.)

Examples

Model

B. Breech Bolt Assembly

Bolt binds

M/600, 700, 500 Series,
788

Bolt binds on front trigger
guard screw

M/600, 700

Bolt catches moving forward

M/600, 700, 500 Series,
788

Bolt closes hard

M/600, 700, 500 Series,
788

Bolt fails to lock with
safe on

M/600, 700

Bolt pulls out

M/600, 700, 500 Series,
788

Bolt numbered incorrectly

M/600, 700

Bolt release binds

M/600, 700, 788

Bolt return plunger loose

N/1100

Bolt sleeve cracked

M/500 Series

Bolt stop pin loose

M/600, 700

PART NAME Fin. Product Defect Index COOLANT

SET UP
TIME

MODEL No. All models

OPER. No.

TYPE

MACH. HRS.

DEPT. No.

PAGE 10

OF 48

MACHINE

DATES A. REASONS FOR REVISIONS

11/2/75 - Revised - GAK/ldm

DESCRIPTIVE INFORMATION

Finished Product Defect Index - Classification & Demerit Values

III. Demerit Value Definition

10 (cont.)

Examples Model

P. Breech Bolt Assembly (cont.)

Bolt stop won't depress full stroke M/600, 700

Bolt won't close over full magazine. M/600, 700, 788

Braze test missing on bolt handle. M/600, 700

Burr at firing pin hole. All models

Burr on extractor. All models

Burr on face of bolt. All models

Can't remove bolt. M/700, 600, 500 Series, 788

Closes hard over rim. All models

Concaves shell heads M/1100, 11-48, 870

Corner of slide broken M/1100, 11-48, 870

Ejector binds All centerfire rifles

Extractor drops shells (minor) M/500 Series

PART NAME Fin. Product Defect Index COOLANT

SET UP TIME

MODEL No. All models

OPER. No.

TYPE

MACH. HRS.

DEPT. No.

PAGE 11

OF 48

MACHINE

DATE 4/2/75 REASONS FOR REVISIONS
4/2/75 - Revised - CAK/bdm

DESCRIPTIVE INFORMATION

Finished Product Defect Index - Classification & Demerit Values

III. Demerit Value Definition

10 (cont.)

Examples

Model

B. Breech Bolt Assembly (cont.)

Extractor loose.	All centerfire & shotgu
Wrong extractor	Shotgun
Feeds hard under extractor	M/500 Series
Firing pin hits face of Barrel	All rimfire
Firing pin point flat	All centerfire & shotgun
Firing pin protrusion over max.	All models
Firing pin protrusion under min.	All models
Firing pin point sharp.	All shotgun & centerfire
Firing pin retracting spring missing.	M/1100, 11-48, 742
Left extractor loose.	All centerfire & rimfire
Magnaflux mark missing on bolt.	M/600, 700
Nib on firing pin point	All centerfire & shotgun

PART NAME Fin. Product Defect Index COOLANT

TYPE

SET UP TIME

MODEL No. All models

OPER. No.

MACH. HRS.

DEPT. No.

PAGE 12 OF 48

MACHINE

DATES AND REASONS FOR REVISIONS
4/2/75 - Revised - CAK/bdm

DESCRIPTIVE INFORMATION

Finished Product Defect Index - Classification & Demerit Values

III. Demerit Value Definition

Examples Model

10 (cont.)

B. Breech Bolt Assembly (cont.)

No tension on extractor All models

Operating handle detent missing. M/1100, 11-48

Operating handle retaining pin missing/high. M/742

Poor ejection. M/600, 700

Poor filing on bolt. M/600, 700

Proof mark missing on bolt. M/600, 700, 870

Slide block buffer loose. M/1100

Slide broken. M/1100, 11-48, 870

Wrong ejector (i.e. 222 in 35 Cal.) M/600, 700

Wrong locking block M/1100, 11-48, 870

Plate peeling All shotguns

PART NAME Fin. Product Defect Index COOLANT

SET UP TIME

MODEL No. All models

OPER. No.

TYPE

MACH. HRS.

DEPT. No.

PAGE 13

OF 48

MACHINE

REASONS FOR REVISIONS

11/2/75 - Revised - CAK/jdm

DESCRIPTIVE INFORMATION

Finished Product Defect Index - Classification & Demerit Values

III. Demerit Value Definition

10 (cont.)

Examples Model

C. Final Assembly

Action binds (minor) All models

Action opens hard All models

Action opens hard on fired shells M/600, 700, 760, 572, 870

Caliber marking missing on magazine box M/742, 760, 600, 700

Code and/or final stamps missing Any model

Excessive wood or steel margin. Any model

Magazine box bent M/600, 700, 742, 760, N/10C

Operating handle hits Fore End (severe) M/552

Rear lip of magazine box damaged M/600, 700, 742, 760

Shells load hard in magazine M/600, 700, 742, 760, N/10C

PART NAME Fin. Product Defect Index COOLANT

SET UP TIME

MODEL No. All Models

OPER. No.

TYPE

MACH. HRS

DEPT. No.

PAGE 11 OF 48

MACHINE

REASONS FOR REVISIONS
4/2/75 - Revised - CAK/bdm

DESCRIPTIVE INFORMATION

Finished Product Defect Index - Classification & Demerit Values

III. Demerit Value Definition

Examples Model

10 (cont.)

C. Final Assembly (cont.)

Take down screw doesn't hold. M/600, 700, 500 Series

Trigger plate removes hard. M/1100, 11-48, 870, 742, 760, 552, 572

Wrong fire control. M/1100, 11-48, 870, 742, 760, 552, 572

Wrong magazine box M/600, 700, 742, 760,

Wrong magazine lock M/600, 700, 742, 760, N/10C

Wrong stock (grade) All models

Wrong ticket (i.e. carbine on regular) All models

PART NAME Fin. Product Defect Index COOLANT

SET UP TIME

MODEL No. All Models

OPER. No.

TYPE

MACH. HRS.

DEPT. No.

PAGE 15

OF 48

MACHINE

DATES AN. EASONS FOR REVISIONS
11/2/75 - Revised - CANK/hdm

DESCRIPTIVE INFORMATION

Finished Product Defect Index - Classification & Demerit Values

III. Demerit Value

Definition

Examples

Model

10 (cont.)

D. Fire Control Assembly

Action bar lock binds M/870, 572, 760

Action bar lock doesn't hold. M/870, 572, 760

Action bar lock doesn't release. M/870, 572, 760,

Action bar lock spring broken. M/870, 572, 760

Broken lug on trigger plate. M/1100, 11-48, 870, 742, 760, 572, 552

Carrier dog cracked. M/1100, 11-48, 870

Carrier release broken. M/1100

Carrier release slips off latch. M/1100

Carrier tab catches on Receiver. M/1100

Disconnecter binds. M/742, 552, N/66, 11-48, 1100

Disconnecter loose. M/742, 552, N/66, 11-48, 1100

PART NAME Fin. Product Defect Index COOLANT

SET UP TIME

MODEL No. All Models

OPER. No.

TYPE

MACH. HRS.

DEPT. No.

PAGE 16

OF 48

MACHINE

DATE, J REASONS FOR REVISIONS

11/2/75 - Revised - CAK/hdm

DESCRIPTIVE INFORMATION

Finished Product Defect Index - Classification & Demerit Values

III. Demerit Values Definition

10 (cont.)

Examples Model

D. Fire Control Assembly (cont.)

Disconnect spring broken M/742

Double click in trigger All models

Excess play at action bar lock and disconnect left M/870, 572, 760

Excessive opening at disconnect and connector left M/742, 552, 11-48, 1100

Excess play at trigger and bushing M/1100, 11-48, 870, 742 760, 572, 552

Hammer pin loose M/1100, 11-48, 870, 552 742, 760

Hammer pin shifted M/1100, 11-48, 870, 572 552, 742, 760

Hammer plunger slips by action bar lock M/870, 572, 760

Heavy trigger pull Any model

Less than .030 play at disconnect and connector left M/742-760 - .020, 552, 11-48, 1100, 870, 572

PART NAME Fin. Product Defect Index COOLANT

SET UP TIME MODEL No. All Models

OPER. No.

MACH. HRS.

DEPT. No.

PAGE 17

OF 48

MACHINE

DATES A. REASONS FOR REVISIONS
4/2/75 - Revised - CAK/jdm

DESCRIPTIVE INFORMATION

Finished Product Index - Classification & Demerit Values

III. Demerit Value Definition

10 (cont.)

Examples

Model

D. Fire Control Assembly (cont.)

Long carrier

M/1100, 11-48, 870, 552, 572

Light trigger pull

All models

Long trigger pull

All models

No clearance at action bar lock and connector left

M/870, 572

No trigger play at bushing

All models

Poor finish on trigger guard.

All models

Poor staking on action tube cap.

M/760

Reinforcing ribs on carrier tab missing.

M/1100

Safe binds

All models

Safe goes on after firing

M/500 Series

Safe not adjusted properly

M/700, 600, 500 Series

Scant red on safety

M/500 Series, N/66, N/10, 1100, 870, 742, 760

PART NAME Fin. Product Defect Index COOLANT

SET UP TIME

MODEL No. All Models

OPER. No.

TYPE

MACH. HRS.

DEPT. No.

PAGE 18

OF 48

MACHINE

REASONS FOR REVISIONS
1/2/75 - Revised - CAK/hdm

DESCRIPTIVE INFORMATION

Finished Product Defect Index - Classification & Demerit Values

III. Demerit Value Definition

Examples	Model
D. Fire Control Assembly (cont.)	
Sear case screw not staked properly	M/1100, 11-48, 870, 742, 760.
Sear spring out of position	M/600, 700
Sharp burr on trigger guard	All models
Step in sear notch	All models
Striations missing on safe	All models
Trigger adjusting screws not sealed	M/600, 700, 788
Trigger guard cracked	All models
Trigger pin loose	All models
Trigger pull creepy	All models
Won't cock with safety on	All models

PART NAME Fin. Product Defect Index COOLANT

SET UP TIME

MODEL No. All Models

OPER. No.

TYPE

MACH. HRS.

DEPT. No.

PAGE 19 OF 48

MACHINE

DATE 4 REASONS FOR REVISIONS

4/2/75 - Revised - CAK/bdm

DESCRIPTIVE INFORMATION

Finished Product Defect Index - Classification & Demerit Values - (cont.)

III. Demerit Value Definition

Examples

Model

D. Fire Control Assembly (cont.)

Carrier peeling

M/1100, 11-48, 870

Trigger plate pin bushing broken

M/1100, 870, 11-48, 742, 760, 552, 572

E. Fore End Assembly

Checking on Fore End light.

M/11-48, 1100, 870, 742, 760, 552 BDL, 572 BDL

PART NAME Finished Prod. Defect Index COOLANT

SET UP TIME

MODEL No. All Models

OPER. No.

MACH. HRS.

DEPT. No.

PAGE 20

OF 48

MACHINE

DATES A. REASONS FOR REVISIONS
4/2/75 - Revised - CLK/bdm

DESCRIPTIVE INFORMATION

Finished Product Defect Index - Classification & Demerit Values - (cont.)

III. Demerit Value	Definition	Examples	Model
10 (cont.)			
		E. Fore End Assembly - (cont.)	
		Checkering off center	M/1100, 11-48, 870, 742, 760, 552 BDL, 572 BDL
		Checkering missing	M/1100, 11-48, 870, 742, 760, 552 BDL, 572 BDL
		Excess fill on Fore End	M/1100, 11-48, 870, 742, 760, 552, 572
		Excess lacquer	N/552, 572, 742, 760
		Excess RK-W	M/1100, 11-48, 870, 742 BDL, 760 BDL, 572 BDL 552 BDL
		Excess stain	All models except N/66, N/10C
		Fore End bushing not staked properly	N/742
		Fore End checked	All models except 600, 700, 788, 552, 500 Series N/66, 10C
		Fore End checkering burned	All models except 600, 700, 788, 552, 500 Series N/66, N/10C

PART NAME Fin. Product Defect Index COOLANT SET UP TIME

MODEL No. All Models

OPER. No.

TYPE

MACH. HRS.

DEPT. No.

PAGE 21 OF 48

MACHINE

REASONS FOR REVISIONS

4/2/75 - Revised - CAK/bdm

DESCRIPTIVE INFORMATION

Finished Product Defect Index - Classification & Demerit Values

III. Demerit Value Definition

10 (cont.)

Examples Model

I. Fore End Assembly (cont.)

Fore End checkering run out

All models except 600, 700, 788, 552, 500 Serie N/66, N/10C

Fore End chipped

All models except 600, 700, 788, 552, 500 Serie N/66, N/10C

Fore End detent missing

M/1100, 11-48, add to Barrel

Fore End grooves damaged

N/572

Fore End hanger split

M/552, 572

Fore End hits Barrel guide ring

N/870

Fore End loose on tube

M/1100, 11-48, 552, 742, 870

Fore End rubs Receiver

M/870, 760, 572

Fore End split

All models except 600, 700, 788, 500 Series, N/66, N/10C

Fore End spring broken

N/742

PART NAME Fin. Product Defect Index COOLANT

SET UP TIME

MODEL No. All Models

OPER. No.

TYPE

MACH. HRS.

DEPT. No.

PAGE 22

OF 48

MACHINE

DATES A. REASONS FOR REVISIONS

11/2/75 - Revised - CAK/bdm

DESCRIPTIVE INFORMATION

Finished Product Defect Index - Classification & Demerit Value

III. Demerit Value

Definition

Examples

Model

10 (cont.)

E. Fore End Assembly (cont.)

Fore End support block
loose

M/1100

Fore End support out of
position

M/1100, 552

No border on checkering

Any Fore End with
checkering

Open grain in Fore End

All models

Poor checkering on Fore End

Any Fore End with
checkering

Poor finish on Fore End

M/1100, 11-48, 870, 572,
552, 742, 760

Poor repair on Fore End

M/1100, 11-48, 870, 572,
552, 742, 760

Poor sanding on Fore End

M/1100, 11-48, 870, 572,
552, 742, 760

Vertical grooves in Fore
End mutilated and run out.

M/572

PART NAME Fin. Product Defect Index

COOLANT

SET UP
TIME

MODEL No. All Models

OPER. No.

MACH. HRS.

DEPT. No.

PAGE 23

MACHINE

OF 48

DATES . J REASONS FOR REVISIONS
8/17/75 - Revised - CAK/kmk

DESCRIPTIVE INFORMATION

Finished Product Defect Index - Classification & Demerit Value - (cont.)

III. Demerit Value Definition

10 (cont.)

Examples

Model

I. Receiver Assembly

Action spring follower bent.

M/11-48

Bearing plate missing.

M/742, 760, & all shotguns

Can't remove inner magazine tube.

M/552, 572, 500 series, N/66

Chamber missing on recoil spring.

M/11-48

Deflector loose.

M/552

Dent in Receiver.

M/1100, 11-48, 870, 742, 760, 552, 572

Ejector brazed out of pos.

M/11-48

Ejector chipped.

Any model

Ejector port cover broken.

M/742, 760

Ejector screws not staked.

500 series

Ejector screws staked out of position.

500 series

PART NAME Fin. Product Defect Index COOLANT

SET UP TIME

MODEL No. All Models

OPER. No.

TYPE

MACH. HRS.

DEPT. No.

PAGE 24

OF 48

MACHINE

REASONS FOR REVISIONS

8/17/75 - Revised - CAK/kmk

DESCRIPTIVE INFORMATION

Finished Product Defect Index - Classification & Demerit Values - (cont.)

III. Demerit Value
10 - cont.

Examples	Model
F. Receiver Assembly - (cont.)	
Ejector spring loose.	M/870
Fiber washer loose in action tube.	M/760
Gas hole in Rec plugged.	M/600, 700
Mag. follower out of pos.	M/552, 572, 500 series N66
Mag. tube cracked.	M/552, 572, 500 series N66
Mag. tube damaged.	M/552, 572, 500 series N66
Mag. tube marred.	M/552, 572, 500 series N66
Mag. spring buckled.	M/1100, 11-48, 870, 552, 572, N66
Mag. feed plug doesn't feed back.	M/1100, 11-48, 870
Min. feed plug jumps magazine latch.	M/1100, 11-48, 870, 552, 572, 500 series, N66

Index

PART NAME Finished Product Defect COOLANT

SET UP TIME

MODEL No. All Models

OPER. No.

TYPE

MACH. HRS.

DEPT. No.

PAGE 25

OF 48

MACHINE

DATE 1 REASONS FOR REVISIONS

8/17/75 - Revised - CAK/kmk

DESCRIPTIVE INFORMATION

Finished Product Defect Index - Classification & Demerit Values - (cont.)

III. Demerit Value Definition

10 - (cont.)

Examples

Model

F. Receiver Assembly - (cont.)

No tension on mag. tube. M/1100, 11-48, 870, 552, 572, 500 series, N56

Nylon washer missing on take down nut. M/742

Outer mag. tube loose. M/552, 572, 500 series

Outer mag. tube marred. M/552, 572, 500 series

Poor filing on Rec. All models

Poor finish on Rec. All models

Poor polish on Rec. All models

Rear of mag. tube open at barrel support. M/N66

Receiver bushing loose. M/552, 572

Rec. bushing not staked. M/552, 572

Rec. cover screw broken off at slot. M/N66, N10-C

Rec. marred. All models

Rec. pitted. All models

PART NAME Finished Prod. Defect Index COOLANT

SET UP TIME

MODEL No. All Models

OPER. No.

TYPE

MACH. HRS.

DEPT. No.

PAGE 26

OF 48

MACHINE

DATE AN EASONS FOR REVISIONS
8/17/75 - Revised - CAK/kmk

DESCRIPTIVE INFORMATION

Finished Product Defect Index - Classification & Demerit Values - (cont.)

III. Demerit Value Definition

10 - (cont.)

Examples

Model

F. Receiver Assembly - (cont.)

Rec. rail sharp (marks cases). M/600, 700

Recoil spring ring loose. M/11-48

Scale on recoil spring ring. M/11-48

Scant threads in take down screw hole. M/552, 572

Scope grooves in Rec. shallow. All rim fires

Seam in Rec. All models

Latches loose in Rec. M/870, 1100

Tight between latches. M/870

Two followers in inner mag. tube. M/552, 572, 500 series, N66

G. Stock Assembly

Action loose in stock. M/700, 600, 500 series

Butt plate cracked. All models except magnum

PART NAME Finished Prod Defect Index COOLANT
TYPE

SET UP
TIME

MODEL No. All Models

OPER. NO.

MACH. HRS.

DEPT. No.

PAGE 27 OF 48

MACHINE

DATES A REASONS FOR REVISIONS
8/17/75 - Revised - CLK/kmk

DESCRIPTIVE INFORMATION

Finished Product Defect Index - Classification & Demerit Values - (cont.)

III. Demerit Value Definition

10 - cont.

Examples

Model

G. Stock Assembly - (cont.)

Butt plate deformed.

All models except
magnum

Butt plate discolored.

All models except
magnum

Checkering on stock light.

All models with
checkering

Checkering off center.

All models with
checkering

Checkering missing on stock.

All models with
checkering

Dull spot on stock.

All models

Excess filler on stock.

All models

Excess lacquer.

M/552, 572, 742, 600
760, 500 series

Excess RK-W.

M/1100, 11-48, 870,
742 BDL, 600 laminated,
700, 760 BDL, 552 BDL,
572 BDL

Excess stain.

All models

PART NAME Finished Prod. Defect Index COOLANT

SET UP
TIME

MODEL NO. All models

OPER. NO.

MACH. HRS

DEPT. NO.

PAGE 28 OF 118

MACHINE

DATES AND REASONS FOR REVISIONS
8/17/75 - Revised - CAK/kmk

DESCRIPTIVE INFORMATION

Finished Product Defect Index - Classification & Demerit Values - (cont.)

III. Demerit Value Definition

10 - (cont.)

Examples

Model

G. Stock Assembly - (cont.)

Grip cap poorly fitted.

M/1100, 11-48, 870, 700-
BDL, 760, 552 BDL,
572 BDL, N6G, N 10-C

Hole in butt plate.

All models except magnum

Hole in stock.

All models

No border on checkering on
stock.

All models except 500
series.

Open grain in stock.

All models

Poor checkering on stock.

All models with checker-
ing.

Poor color on mag. guide
plate.

500 series

Poor finish on stock.

All models

Poor repair on stock.

All models

Poor sanding on stock.

All models

Raised grain on stock.

All models

Rec. cut too long in stock
(full stock).

M/600, 700, 788, 500
series

PART NAME Finished Prod. Defect Index COOLANT

SET UP
TIME

MODEL No. All Models

OPER. No.

MACH. HRS.

DEPT. No.

PAGE 29

OF 48

MACHINE

DATES AND REASONS FOR REVISIONS
8/17/75 - Revised - CAK/kmk

DESCRIPTIVE INFORMATION

Finished Product Defect Index - Classification & Demerit Value - (cont.)

III. Demerit Value

Definition

Model

10- (cont)

G. Stock Assembly - (cont.)

Recoil pad open on stock.

Any model with recoil pad

Stock bolts missing.

M/600, 700, 788, 500 series

Stock checked.

Any model

Stock checkering burned.

Any model with checkering

Stock chipped.

Any model

Stock discolored.

Any model

Stock split.

Any model

Take down screw cross threaded.

M/552, 572, 500 series

Tang support missing.

M/600

Stock loose.

Any model

PART NAME Finished Prod. Defect Index COOLANT

SET UP TIME

MODEL No. All Models

OPER. NO.

TYPE

MACH. HRS

DEPT. No.

PAGE 30

OF 48

MACHINE

DATES AND REASONS FOR REVISIONS
8/17/75 - Revised - CAK/kmk

DESCRIPTIVE INFORMATION

Finished Product Defect Index - Classification & Demerit Values - (cont.)

IV. Demerit Value	Definition	Examples	Model
1	1. Minor damaged, objectionable visual dimensional or adjustment not presenting potential functional failures.	(A. Barrel Assembly) Barrel bracket rough. Barrel lays left/right. Barrel marred. Barrel rusty. Bore pitted (minor.) Bulge in bore. Burr on barrel extension. Double roll on barrel. Front sight bead loose. Front sight assembled improperly. Front sight damaged. Front sight pitted.	M/600, 700 All rimfire rifles All models All models All models All rimfire rifles M/11-48 All models All shotguns. All centerfire, rimfire, M/870 Brushmaster, 1100 Deer Gun All models All models except shot- guns with beaded sights.

PART NAME Finished Prod. Defect Index COOLANT SET UP TIME MODEL No. All Models OPER. NO. 31
TYPE MACH. HRS. DEPT. NO. 31 OF 48
MACHINE

REASONS FOR REVISIONS
8/17/75 - Revised - CAK/kmk

DESCRIPTIVE INFORMATION

Finished Product Defect Index - Classification & Values - (cont.)

IV. Demerit Value
1 (cont.)

Definition

Examples

Model

A. Barrel Assembly - (cont.)

Front sight ramp marred.

All centerfire, 1100
Deer Gun, 870 Brush-
master

Matting light on vent rib.
(minor.)

N/1100, 11-48, 870, 600

Nick on base of barrel
face at chamber.

All models

Poor color on front sight.

All models

Poor color on rear sight
base.

All centerfires, rimfires,
1100 Deer Gun, 870
Bushmaster

Poor crown on barrel.

All models

Poor finish at comb.

All models

Poor grind on barrel at
front sight.

All models

Poor plating (chrome) on
barrel.

M/N66, N10-C

ART NAME: Finished Prod. Defect Index COOLANT

SET UP
TIME

MODEL No. All Models

OPER. No.

MACH. HRS.

DEPT. No.

PAGE 32

OF 48

DATES AND REASONS FOR REVISIONS
8/17/75 - Revised - CAK/kmk

DESCRIPTIVE INFORMATION

Finished Product Defect Index - Classification & Demerit Values - (cont.)

IV. Demerit Value

Example

Model

1 (cont.)

A. Barrel Assembly - (cont.)

Poor polish on breech ring. M/742, 760

Rear sight eyepiece off center. All centerfire, rimfire, 1100 Deer Gun, 870 Brushmaster

Rear sight rivot high. M/N66, 500 series, 10-C

Rear sight screw holes not counter sunk. M/552, 572

Ring in bore. All models

Rough bore. All models

Rough chamber. All models

Rough groove in bore and muzzle. All models

Rough lands - breech bolt. All models

Scratch in bore at muzzle end. All models

Swell in chamber. All models

Target stamp missing. All center fire

PART NAME Finished Prod. Defect Index-COOLANT

SET UP TIME

MODEL No. All Models

OPER. No.

TYPE

MACH. HRS.

DEPT. No.

PAGE 33

OF 48

MACHINE

DATES AND REASONS FOR REVISIONS
8/17/75 - Revised - CAK/lmk

DESCRIPTIVE INFORMATION

Finished Product Defect Index - Classification & Demerit Values - (cont.)

IV. Demerit Value Definition

1 - (cont.)

Examples Model

A. Barrel Assembly - (cont.)

Tear in bore (minor.) All rimfire rifles

Tight chamber. All models

Vent rib marred. All shotguns (with vent ribs) & M/600

White diamond on eyepiece off center. M/700, 742, 760

Wink in bore. All rimfire rifles

Wrong front sight ramp. All centerfire, M/1100 Deer Gun, 870 Brushmaster

B. Breech Bolt Assembly

Bolt discolored. All models

Bolt lugs rough. M/600, 700, 742, 760

Bolt marred. All models

Bolt marred at extractor pin. All models

Bolt sharp on bottom edge. All models

PART NAME Finished Prod. Defect Index

SET UP TIME

MODEL No. All Models

OPER. No.

TYPE

MACH. HRS.

DEPT. No.

PAGE 34

OF 48

MACHINE

REASONS FOR REVISIONS
8/17/75 - Revised - CAK/kmk

DESCRIPTIVE INFORMATION

Finished Product Defect Index - Classification & Demerit Values - (cont.)

IV. Demerit Value

Definition

Examples

Model

1 - (cont.)

B. Breech Bolt Assembly (cont.)

Bolt sleeve marred.	500 series
Bolt rusty.	All models
Braze spot on bolt handle.	All models
Breech ring pitted.	M/742, 760
Burr at lock notch.	All shotguns
Burr on bolt handle.	M/600, 700, 500 series
Cocking cam rough.	M/600, 700, 500 series
Extractor binds.	All models
Face of bolt rough.	All models
Operating handle removes hard.	M/1100, 11-48, 742, N66
Poor chamfer - front of bolt.	All centerfire, rimfire rifles
Poor color on bolt handle.	M/500 series

PART NAME Finished Prod. Defect Index COOLANT

SET UP TIME

MODEL No. All Models

OPER. No.

TYPE

MACH. HRS.

DEPT. No.

PAGE 35 OF 48

MACHINE

DATES AND REASONS FOR REVISIONS
8/17/75 - Revised - CAK/kmk

DESCRIPTIVE INFORMATION

Finished Product Defect Index - Classification & Demerit Values - (cont.)

IV. Demerit Value

Examples

Model

1 - (cont.)

B. Breech Bolt Assembly - (cont.)

Poor grind on bolt.

All models

Poor plating on bolt.

M/600, 700, All shot-guns, 788, 500 series

Two carrier dog notches in slide.

M/1100, 11-48, 870

C. Final Assembly

Barrel beds on front swivel screw.

M/600, 700

Breech ring & Rec. mismatched.

M/742, 760

Excessive trigger plate margin.

M/1100, 11-48, 552, 572
870, 742, 760

Fore end removes hard.

M/1100, 11-48, 870, 742, 760, 552, 572

Fore end strikes Rec. (minor).

M/870, 572

Magazine box assembles hard.

M/600, 700, 742, 760, 10-C

PART NAME Finished Prod., Defect Index COOLANT

SET UP
TIME

MODEL No. All Models

OPER. No.

TYPE

MACH. HRS.

DEPT. No.

PAGE 36

OF 48

MACHINE

DATES AND REASONS FOR REVISIONS
8/17/75 - Revised - CAV/kmk

DESCRIPTIVE INFORMATION

Finished Product Defect Index - Classification & Demerit Values - (cont.)

IV. Demerit Value

1 - (cont.)

Examples

C. Final Assembly - (cont.)

Model

Magazine box dirty. M/600, 700, 742, 760,
10-C.

No clearance at fore end
and barrel. M/1100, 11-48, 870, 742,
760, 552, 572

Operating handle hits fore
end (slight.) M/552

Poor repair. All models

Poor polish on magazine
follower. M/600, 700, 742, 760,
500 series

Trigger plate assemblies
hard. M/1100, 11-48, 870, 742,
760, 552, 572

Trigger plate pin holes
don't match Rec. M/1100, 11-48, 870, 742,
760, 552, 572

Trigger plate removes hard. M/1100, 11-48, 870, 742,
760, 552, 572

Wood or steel margin (minor.) All models

PART NAME Finished Prod. Defect Index

SET UP
TIME

MODEL No. All Models

OPER. No.

TYPE

MACH. HRS.

DEPT. No.

PAGE 37

OF 48

MACHINE

DESCRIPTIVE INFORMATION

Finished Product Defect Index - Classification & Demerit Values - (cont.)

IV. Demerit Value Definition

Examples

Model

I - (cont.)

D. Fire Control Assembly

M/N66

Firing pin retaining pin
not bent.

Firing pin retaining pin short.

M/552, 572

Hammer & carrier rusty.

Left connector damaged. M/1100, 11-48, 870, 742, 760, 552, 572

Nick in left connector.

Plating peeling on carrier
release.

Poor color on trigger plate. All models

Poor plating on carriers. M/11-48, 870

Poor polish on trigger guard. All models

Trigger guard bow marred. All models

Trigger plate damaged.

PART NAME	Finished Prod.	Defect	Index	COOLANT
1	100	0	100	100
2	100	0	100	100
3	100	0	100	100
4	100	0	100	100
5	100	0	100	100
6	100	0	100	100
7	100	0	100	100
8	100	0	100	100
9	100	0	100	100
10	100	0	100	100
11	100	0	100	100
12	100	0	100	100
13	100	0	100	100
14	100	0	100	100
15	100	0	100	100
16	100	0	100	100
17	100	0	100	100
18	100	0	100	100
19	100	0	100	100
20	100	0	100	100
21	100	0	100	100
22	100	0	100	100
23	100	0	100	100
24	100	0	100	100
25	100	0	100	100
26	100	0	100	100
27	100	0	100	100
28	100	0	100	100
29	100	0	100	100
30	100	0	100	100
31	100	0	100	100
32	100	0	100	100
33	100	0	100	100
34	100	0	100	100
35	100	0	100	100
36	100	0	100	100
37	100	0	100	100
38	100	0	100	100
39	100	0	100	100
40	100	0	100	100
41	100	0	100	100
42	100	0	100	100
43	100	0	100	100
44	100	0	100	100
45	100	0	100	100
46	100	0	100	100
47	100	0	100	100
48	100	0	100	100
49	100	0	100	100
50	100	0	100	100
51	100	0	100	100
52	100	0	100	100
53	100	0	100	100
54	100	0	100	100
55	100	0	100	100
56	100	0	100	100
57	100	0	100	100
58	100	0	100	100
59	100	0	100	100
60	100	0	100	100
61	100	0	100	100
62	100	0	100	100
63	100	0	100	100
64	100	0	100	100
65	100	0	100	100
66	100	0	100	100
67	100	0	100	100
68	100	0	100	100
69	100	0	100	100
70	100	0	100	100
71	100	0	100	100
72	100	0	100	100
73	100	0	100	100
74	100	0	100	100
75	100	0	100	100
76	100	0	100	100
77	100	0	100	100
78	100	0	100	100
79	100	0	100	100
80	100	0	100	100
81	100	0	100	100
82	100	0	100	100
83	100	0</		

SET UP
TIME

MODEL No. All Models

OPER. NO. 1

TYPE

MACH. HRS.

DEPT. NO.

PAGE 38 OF 118

MACHINE

DATES AND REASONS FOR REVISIONS
8/17/75 - Revised - CAK/kmk

DESCRIPTIVE INFORMATION

Finished Product Defect Index - Classification & Demerit Value - (cont.)

IV. Demerit Value Definition

Examples Model

1 - (cont.)

D. Fire Control Assembly - (cont.)

Trigger Plate pin bushing
damaged. M/1100, 11-48, 870, 742,
760, 552, 572

Trigger plate pitted. M/1100, 11-48, 870, 742,
760, 552, 572

E. Fore End Assembly

Bad spot in fore end. M/1100, 11-48, 870, 742,
760, 552 BDL, 572 BDL

Check at checkering on
fore end. (minor) M/1100, 11-48, 870, 742,
760, 552 BDL, 572 BDL

Checkering border run out
on fore end. M/1100, 11-48, 870, 742,
760, 552 BDL, 572 BDL

Checkering light on fore end. M/1100, 11-48, 870, 742,
760, 552 BDL, 572 BDL

Excess filler on fore end. M/1100, 11-48, 870, 742,
760, 552 BDL, 572 BDL

Excess lacquer on fore end. M/742, 760, 552, 572

Excess RK-W on fore end. M/1100, 11-48, 870,
742 BDL, 760 BDL, 552-
BDL, 572 BDL

PART NAME Finished Product Defect Index INDEX

SET UP
TIME

MODEL No. All Models

OPER. No.

TYPE

MACH. HRS.

DEPT. No.

PAGE 39

OF 118

MACHINE

REASONS FOR REVISIONS
8/17/75 - Revised - CAK/kmk

DESCRIPTIVE INFORMATION

Finished Product Defect Index - Classification & Demerit Values - (cont.)

IV. Demerit Value Definition

Examples Model

1 - (cont.)

E. Fore End Assembly - (cont.)

Flaw in action bar. M/870

Fore end checkering cracked. (minor) M/1100, 11-48, 870, 742, 760, 552 BDL, 572 BDL

Fore end checkering crushed. (minor) M/1100, 11-48, 870, 742, 760, 552 BDL, 572 BDL

Fore end chipped. M/1100, 11-48, 870, 742, 760, 552 BDL, 572 BDL

Fore end color light. M/1100, 11-48, 870, 742, 760, 552 BDL, 572 BDL

Fore end escutcheon marred. M/552, 572

Fore end marred. (minor) M/1100, 11-48, 870, 742, 760, 552, 572

Fore end screw high. M/760, 572

Lacquer chipped on fore end. M/742, 760, 552, 572

Lacquer run on fore end. M/742, 760, 552, 572

PART NAME Finished Prod. Defect Index COOLANT

SET UP
TIME

MODEL No. All Models

OPER. No.

MACH. HRS.

DEPT. No.

PAGE 40 OF 48

MACHINE

REASONS FOR REVISIONS
8/17/75 - Revised - CAK/kmk

DESCRIPTIVE INFORMATION

Finished Product Defect Index - Classification & Demerit Values - (cont.)

IV. Demerit Value

Definition

Examples

Model

I - (cont.)

E. Fore End Assembly - (cont.)

Open grain on fore end.

M/1100, 11-48, 870, 742,
760, 552, 572

Pin hole in fore end.

M/1100, 11-48, 870, 742,
760, 552, 572

Poor finish on fore end.

M/1100, 11-48, 870, 742,
760, 552, 572

Poor patch (color) on fore
end.

M/1100, 11-48, 742, 760,
552, 870, 572

Poor repair on fore end.

M/1100, 11-48, 870, 742,
760, 552, 572

RW-W bubble on fore end.

M/1100, 11-48, 870, 742-
BDL, 760 BDL, 552 BDL,
572 BDL

Run out of finish on fore
end.

M/1100, 11-48, 870, 742,
760, 552, 572.

F. Receiver Assembly

Burr at ejection port.

M/1100, 11-48, 870, 742,
760, 552, 572, N66

PART NAME Finished Prod. Defect Index COOLANT

SET UP
TIME

MODEL No. All Models

OPER. No.

TYPE

MACH. HRS

DEPT. No.

PAGE 41 OF 48

MACHINE

DATES AND REASONS FOR REVISIONS
8/17/75 - Revised - CAK/kmk

DESCRIPTIVE INFORMATION

Finished Product Defect Index - Classification & Demerit Values - (cont.)

IV. Demerit Values Definition

1 - (cont.)

Examples

Model

E. Receiver Assembly - (cont.)

Burr on Receiver.

All models

Color off Rec. bottom.

M/1100, 11-48, 870, 742,
760, 552, 572

Color worn off take down screw. M/552, 572, 500 series

Deflector marred.

M/552

Ejection port sharp:

M/1100, 11-48, 870, 742,
760, 552, 572, N66,
10-C

Front trigger plate pin
loose.

M/1100, 11-48, 870, 742,
760, 552, 572

Outer magazine tube bent at
tension slot.

M/552, 572, 500 series

Poor color on Rec. (minor).

All models

Poor color on Rec. bottom.

All models

Poor finish at rail.

M/600, 700, 500 series

Poor finish on Rec.

All models

PART NAME Finished Prod. Defect Index: COOLANT

SET UP
TIME

MODEL No. All Models

OPER. No.

TYPE

MACH. HRS.

DEPT. No.

PAGE

112 OF 118

MACHINE

DATES AND REASONS FOR REVISIONS

8/17/75 - Revised - CAK/nmk

DESCRIPTIVE INFORMATION

Finished Product Defect Index - Classification & Demerit Values - (cont.)

IV. Demerit Value Definition

Index

Model

1 - (cont.)

E. Receiver Assembly - (cont.)

Magazine plug pin loose. M/552, 572, 500 series
N66

Rear trigger plate pin loose. M/1100, 11-48, 870, 552,
572, 742, 760

Receiver cover damaged. M/N66, 10-C

Receiver cover screw broken. M/N66, 10-C

Receiver marred. All models

Rec. plug screws mutilated. M/600, 700, 742, 760

Rec. rail rough. M/700, 600, 500 series

Rec. rough inside at bolt. M/700, 600, 500 series

Rec. shows stress at
interceptor latch. M/1100, 11-48, 870, 742,
760, 552, 572

Scope cut on Rec. rough. M/552, 572, 500 series

Serial number light fill (gold) All anniversary models

PART NAME Finished Prod. Defect Index COOLANT

SET UP
TIME

MODEL No. All Models

OPER. No.

TYPE

MACH. HRS.

DEPT. No.

PAGE 113 OF 148

MACHINE

DATES AND REASONS FOR REVISIONS
8/17/75 - Revised - CAK/kmk

DESCRIPTIVE INFORMATION

Finished Product Defect Index - Classification & Denerit Values - (cont.)

IV. Denerit Value

Examples

Model

1 - (cont)

F. Receiver Assembly - (cont.)

Take down screws mutilated.

M/552, 572, 500 series

Trigger plate pin short.

M/1100, 11-48, 870, 742,
760, 552, 572

G. Stock Assembly

Acid spot at tip.

M/N66, 10-C

Bad spot in stock.

All models

Butt plate cracked. (minor)

All models except mag-
nums

Butt plate loose.

All models except
magnums

Butt plate screw loose.

Rimfire, centerfire

Butt plate spacer loose.

M/1100, N66

Check at checkering. (minor)

All models with check-
ering

Checkering border run out.

All models with
checkering

PART NAME Finished Prod. Defect Index

SET UP
TIME

MODEL No. All Models

OPER. No.

TYPE

MACH. HRS.

DEPT. No.

PAGE 44

OF 48

MACHINE

DATES AND REASONS FOR REVISIONS
 8/17/75 - Revised - CAK/rmk

DESCRIPTIVE INFORMATION

Finished Product Defect Index - Classification & Demerit Values - (cont.)

IV. Demerit Value

Definition.

Examples

Model

1 - (cont.)

G. Stock Assembly - (cont.)

Dirty butt plate. (minor)

All models except
magnum

Epoxy filler piece margin.

M/600 (.35 Cal. & 6.5mm)

Excess filler on stock.

All models

Excess filler piece margin.

All models

Excess lacquer on stock.

M/742, 760, 552, 572,
500 series

Excess lacquer on butt
plate.

M/742, 760, 552, 572,
500 series

Excess RK-W on butt plate.

M/1100, 11-48, 870, 742-
BDL, 760 BDL, 552 BDL,
572 BDL

Excess RK-W on grip cap.

M/1100, 11-48, 870,
742 BDL, 760 BDL, 552 -
BDL, 572 BDL

Excess RK-W on stock.

M/1100, 11-48, 870, 742-
BDL, 760 BDL, 552 BDL,
572 BDL

Floor plate dirty.

N/700 BDL

PART NAME Finished Prod. Defect Index COOLANT

SET UP
TIME

MODEL NO.

All Models

OPER. NO.

TYPE

MACH. HRS.

DEPT. NO.

PAGE 45

OF 48

MACHINE

DATES AND REASONS FOR REVISIONS
18/17/75 - Revised - CAK/kmk

DESCRIPTIVE INFORMATION

Finished Product Defect Index - Classification & Demerit Values - (cont.)

IV. Demerit Value	Definition	Examples	Model
1 - (cont.)		C. Stock Assembly - (cont.)	
		Floor plate binds.	M/700 BDL
		Grip cap spacer loose.	M/1100, 742 BDL, 760 BDL
		Incorrect epoxy mixture.	M/600 (.35 Cal. & 6.5 mm)
		Knot in stock.	M/600 (.35 Cal. & 6.5 mm)
		Lacquer bubble on stock.	M/742, 760, 552, 572, 500 series
		Lacquer chipped at floor plate.	M/742, 760, 552, 572, 500 series
		Lacquer chipped on stock.	M/742, 760, 552, 572, 500 series
		Lacquer run on stock.	M/742, 760, 552, 572, 500 series
		Over .012 filler piece.	All models
		Paper on butt plate.	All models
		Pencil mark on stock.	All models
		Pin hole in stock.	All models
		Poor color on stock.	All models

PART NAME Finished Prod. Defect Index COOLANT SET UP TIME MODEL No. All Models OPER. No. _____
TYPE _____ MACH. HRS. _____ DEPT. No. 46 PAGE 46 OF 48
MACHINE

REASONS FOR REVISIONS
8/17/75 - Revised - CAK/kmk

DESCRIPTIVE INFORMATION

Finished Product Defect Index - Classification & Demerit Values - (cont.)

IV. Demerit Value Definition

1 - (cont.)

<u>Examples</u>	<u>Model</u>
C. Stock Assembly - (cont.)	
Poor finish on stock.	All models
Poor finish at bolt clearance cut.	M/600, 700, 500 series
Poor patch (color) on stock.	All models
Poor repair on stock.	All models
Poor sanding on stock.	All models
Poor sanding at butt plate.	All models
Porous recoil pad.	M/600, 700 mag., 1100, 11-48, 870
Margin at grip cap. (minor)	All models
RK-W bubble on stock.	M/1100, 11-48, 870, 742 BDL, 760 BDL, 552 - BDL, 572 BDL, 600, 700
Rough trigger slot in stock.	M/700, 500 series
Stock checkering crushed. (minor)	All models with checkering.
Stock checkering marred. (minor)	All models with checkering

PART NAME Finished Prod. Defect Index-COOLANT

SET UP TIME

MODEL No

All Models

OPER. No

TYPE

MACH. HRS.

DEPT. No

PAGE 47

OF 48

MACHINE

DATES AND REASONS FOR REVISIONS

8/17/75 - Revised - CAK/mnk

DESCRIPTIVE INFORMATION

Finished Product Defect Index - Classification & Demerit Values - (cont.)

IV. Demerit Value	Definition	Examples	Model
1- (cont)		G. Stock Assembly - (cont.)	
		Stock chipped. (minor)	All models
		Stock color light.	All models
		Stock marred.	All models
		Stock rough inside.	All models
		Swivel on stock (uncalled for)	All models
		Tip & spacer uneven.	M/700 BDL, N66, 10-C
		Trigger guard & plate screw marred.	M/600, 700, 500 series

PART NAME Finished Prod. Defect Index COOLANT

SET UP TIME

MODEL No. All Models

OPER. No.

TYPE

MACH. HRS.

DEPT. No.

PAGE 48 OF 48

MACHINE