

REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE



"CONFINE YOUR LETTER TO ONE SUBJECT ONLY" _____

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February 6, 1979

REMINGTON ARMS CO.
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J. P. LINDE

FEB 6 1979

MODEL XP-100 MODIFICATIONS

ILION RESEARCH DIVISION

R & D completed testing on latest modifications to components and gave verbal approval on 2/2/79. Model drawing changes are to be completed on 2/5/79. These changes are:

1. Sear safety cam - .020 additional clearance at pin.
M/D .236 dim. changed to .256 Drawing C-14269.
2. Safety arm - cam radius changed to .301 on Drawing C-91494.
3. Trigger - ears removed on front to provide clearance for screw. Drawing C-15457.

Plan of action to modify all guns in Plant.

Assembly

1. 174 Barrel actions and 48 guns ready for pack are all to be disassembled and modified with all three corrected parts. All guns retested.
2. All three components removed from these guns to be held and sorted. They will be modified and reused, if possible.
3. All converted guns - Mark "A" on label.

MODEL XP-100 MODIFICATIONS

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Plan of action to modify all guns in Plant - contd.

Warehouse

1. All warehouse guns (224 quantity) to be converted with three modifications. All guns retested.
2. Mark "A" on label.

Custom Repair

1. All returned guns to be modified with 3 corrected parts. This will be done by removing old sear housing assembly and replacing with new one. Old parts will be held by Custom Repair.
2. All guns to be retested. Guns will be retested with Stocks assembled.

Shipment of Guns

- No guns will be shipped until approval from Bridgeport.

Process Engineering

1. Process Record to be issued 2/5/79.
2. Operators in Assembly and Custom Repair to be reinstructed to latest modifications.

R & D

- R & D personnel to sample initial production and conversion of customer's guns.

Production

1. Daily production rate to start at 100. Components to be available. Production to supply Custom Repair from this daily rate.
2. Work Order # 51075 to be used for any Special Work on this model.

Components

1. Safe Arms - Conversion to be done in R & D. 1,000 parts available 2/5/79. Daily rate to be in excess of 100. 2,000 more parts due from vendor.

MODEL XP-100 MODIFICATIONS

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Plan of action to modify all guns in Plant

Components - contd.

2. Sear Safety Cam - conversion to be done in two places:
 - Tool Room or Cutter Grind. Fixture available to grind 12 at a time.
 - Production - Fixture available to mill one at a time.
3. Triggers - Conversion to be done in Production Dept. 02. Completed parts to be remilled - new parts to be milled to new configuration.

by

G. J. Hill 7/6/73
G. J. Hill, Supervisor
Process Engineering -
Current Products

GJH/bdm