

**Insert*

- ① ~~Contact~~ pin not central with contact button of primer in six guns.

Field remedy: To machine a block to limit the upward travel of the operating lever.

Remington remedy: To hold operating arm pin hole and operating arm surface to a closer tolerance and from firing pin hole.

- ② Ejection problem with all 12 guns. Shell was extracted but not thrown clear.

Field remedy: To remove metal from breech block to allow clearance.

Remington remedy: To remove extra metal from slot in bolt and to allow bolt to drop further. Also to reduce the severity of heat treat so that warpage is held to a minimum.

- ③ Erosion of ~~contact~~ points caused by too high capacitance in hand held blaster.

Remedy: Specify maximum allowable capacitance for longer pin life.

- ④ Weak pin springs, pin "wobble" and other contact pin problems. After sealing with a silicone rubber compound, several blocks *by Mapco* were found to have weak firing pin springs and excessive pin "wobble".

~~Field repair:~~ →

The rubber compound was removed and spring action was improved although wobble remained a problem. The insulating cups were removed and examined out of the gun. The ~~contact~~ pins were found to have a radius at the base of the pins that interfered with the opening of the insulating cup, ~~(see drawing)~~.

4 ~~11~~ Field remedy of
Pin Wobble:

To ream the insulating cup to allow the contact pin to seat properly. This also seemed to eliminate the weak spring problem.

Remington remedy:

To alter the breech block to accept a back cover plate. This will remove the necessity to fill the back of the breech block with rubber compounds. The firing pin hole will be enlarged to allow greater clearance between ~~contact~~^{firing} pin and breech block. Also the ~~contact~~^{firing} pin hole and insulating cup will be drilled from the same side for better concentricity control. The ~~contact~~^{firing} pin radius in question was found on one sample of the lot in the breech blocks to be not of the specified dimensions on the model drawing. It is proposed that the radius be held to closer tolerances by the model makers.

WE PLAN TO
~~I propose that we~~ replace the 12 breech blocks in service at the present time with 12 new breech blocks containing these proposed changes after they have been fully tested and accepted.

J.R.Palmer:T
Ilion Research Division
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