

Mal.  
% of Def.

## Causes

## Action being taken

Receiver

1. Tenon gage not on job

1. Production has gage on order

Trigger

1. Trigger Plate interference
- 
- (vertical)

1. Need dimensional check on all incoming parts to know which ones need filing (Bennett)
2. Need pinning gage to confirm clearance at filing operation. At Tool Design 5/29 (Kratzert)
3. Estimate on milling operation for clearance cuts (Kratzert)
4. Electronic gaging being tried and audited by Q.C. on seven characteristics. (Kratzert)

2. Trigger Plate interference
- 
- (horizontal)

1. Dials being added to stock base gage. TDR in design. Need schedule. (Orf)
2. W.O. written for filler plugs for 7400. Need completion date (Palmer)

Barrel

1. Braze in nozzle

1. Braze not flowing around locating pin. New sample looks good. Additional samples to be sectioned. (McCormack)

Barrel Extention

1. Tri-Ordinate cut on bolt deepened to reduce hang-up

1. Need M/D change (Martin)
2. Running to deviation

2. Primary extraction cam causes interference and requires filing 30-40% of assemblies

1. Operations are controllable but interference still present. Need design assistance (Martin)

2. New Locators in T/R

45401-7	90290-N2
45494	90290-G2
43580-2	85167-E4
43556	90290-C4

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Magazine

## 1. Heavy Magazine Spring

3. "Try" Bolt gage to be designed to check bbl assemblies 100% in Bbl Shop. TDR issued. Need schedule (McCormack)

1. The production lot of 600 springs tested good. Measurements taken are shown below;

At one cartridge 4.8#  $\pm$  .6#  
At four cart's 7.5#  $\pm$  1#

2. Similar specifications will be incorporated into M/D  
(Martin)

3. Techniques for vendor gaging to be developed (Korba)

## 2. Master Box

## a. Master part

1. Completed and O.K.  
2. 2nd to be built? (Hill)

## b. Dial base gage

1. Use of Master Box led to redesign of two locators. In T/R for alteration. (Joy)

2. When dial gage and master agree, Bosquet and Findley are to visit vendor and develop program to have production parts made to our gage. (Bosquet)

## 3. Re-Work old boxes

1. Purchase order has been issued to H & P and "M" order written. (Ricci)

Final Assembly

## 1. Action Bar riveting

1. Shorter rivets due 6/10/81.  
(White)  
2. Process records to be changed (White)

## 2. Heading Machine #2

1. Schedule for build to be released about 6/12/81  
Project is RI-1185 (Douglass)

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Model Group 7400

Date. 6/11/81

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Causes

Action being taken

Bolt

1. Gage for position of extractor
2. New rivetless extractor  
(correct lenght)

1. Due from Brookfield 7/9/81  
(Lewis)
1. Need for start-up of .270  
run. (Bosquet)

Wood

1. Alignment of fore end bushing
2. Fore end cap margin
3. Grip caps shooting off

1. Gaged fore ends available
2. Need gaged liner to try with  
fore end. (Bennett)
1. Add gage and frequency to  
P/R (Parker)
1. Test stocks look good and  
report to be issued (Mroz)
2. Cap shot off on one 100 round  
test gun reported 6/8/81.  
Quality audit procedure to  
be set up. (Warren)

Test

1. New Proof Ammo. (.270)
2. Review coding on .270

1. Being tested by R & D (Burns)
1. Mroz

Quality

1. 100 Round Gun
2. Plot monthly Gallery results  
of overall and five leading  
malfunction categories

This week .8%  
YTD 1.2%

1. Mroz

Fire Control

1. Fails to fire

1. Disconnecter too long. Being  
belt sanded to gage.
2. Two checks are being made;  
one at Fire Control Assembly  
and one at Final Assembly

7600 Action Bars

1. To be investigated (Joy)