

To Jim
from Randy

10-10-85

The NBAR program is presently building ten engineering evaluation rifles in 30-06 caliber. To ensure that each part is accounted for I have outlined the status of every part on the attached pages.

As we discussed the receiver/barrel assembly is the critical path item that will determine when we have rifles for test. After the receivers are machined, heat treat, assemble barrel, chamber, crown, polish and color operations remain. These steps must be followed closely to prevent any lost time.

I feel the trigger assembly is the next most critical item that should be monitored. Several components must be made and provided that they all aren't run on a single machine (such as the wire EDM) there should be sufficient time.

Stock fabrication should be monitored but I do not expect any delays from a lack of handles for test.

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Barrel Assembly

Receiver - 6-8 weeks in Model Shop + N.C.
- all other work (except what depends on receiver) should be done in this timeframe

Barrel: - Curry has 10 barrels turned, lugged and threaded (and crowned?) we need two of these for focus panel guns. Two more are needed, probably should make 5

Bolt Assembly - Skip has 10(?) out with 6 Engert in production to be turned, cam cuts machined and bolt handle brazed,
- they should be returned before color
- when they are returned bolt lock cuts must be added to bolt handle (also check threads)
- color

Bolt Plug Assembly

Bolt Plug - Larry is correcting the detailed drawing. This must get to the Model Shop asap since this is a time consuming part.

Bolt Lock - bolt locks are being made in the Model Shop without talents. Matt is updating and plotting the drawing

Bolt Lock Detent Spring - Fred is designing
- must be made

Bolt Lock Detent Plunger - in the Model Shop

Bolt Lock Detent Pin - can a roll pin be used?
- check for drawing (x63 dia)
and make sure we have some
available before we need them

Ejector
Ejector Pin
Ejector Spring } withdraw from production

Extractor - Ship has approx 8 virgin parts and
2 or 3 with rounds on them
- magnum and small caliber extractors
(and bolts, etc) can be made and
independently tested

Firing Pin Assembly

Firing Pin - 10 firing pins have been made
- heat treat before assembly

Bolt Plug Washer - ?

Firing Pin Cross Pin - 10 have been made

Firing Pin Head - 10 have been made however
the cross pin hole has not been drilled
in all ten. - this can be done at
assembly

Main Spring - add use H/200
- withdraws from production

Bolt Stop - 10 have been made
- heat treat and color required

Bolt Stop Pin - add use H/200
- withdraws from production

Bolt Stop Spring - Fred is designing
- must be made

Front Guard Screw - withdraws from production

Magazine Assembly

Magazine - H+P is fabricating
- expected delivery in mid-October
- must send 10 magazine bottoms to H+P
for assembly
- balance of magazines to be sent
unassembled

(4)

Magazine Bottom - 10 have been made

Magazine Follower - 10 are being made

Magazine Spring - DSF has oval compression springs that will be used for development. trial and error will determine correct center of pressure and force.

Magazine Latch - 10 are being made

- when they are complete a dry cycle fatigue test must be requested to determine life

Magazine Latch Screw - drawing required

Magazine Release - 10 have been made

Magazine Release Pivot - roll pin drawing required

Rear Guard Screw - add use H/720

- withdraw from production

Rear Pin - add use H/720

- withdraw from production

(5)

Stock Assembly

Stock - Dan/Dan Williams is fabricating 10.
When they are thru the Dan Allen they
must be sanded and finished, Sefewer
is a good candidate

Recoil Pad - withdraws Mountain Rifle or M/700
recoil pads for test guns

Scope Mount Assembly

Scope Mount } injectable parts are available
Scope Mount Ring } for 30 sets - some have been
Scope Mount Clamp } used for focus panel guns - remainder
can be colored

Scope Mount Nut - 30 have been made
- must be colored

Scope Mount Screws - purchase 5-40 x 1/4 cap screws
or filister head screws.

Trigger Assembly

Bolt Stop Release - add-use M/700
- withdraws from production

(5)

Safety Assembly - must be assembled and stored

Safety - 10 are being made

Safety Button - withdraw from production

Safety Detent Ball

Safety Detent Spring

Safety Pin

Safety Snap Washer

Sear Spring

- add use H/700

- withdraw from production

Sear Safety Cam - drawing is now complete

- compare against old parts for possible re-use or make new

Trigger - 10 are being made

Trigger Block Plunger - 10 have been made

- must be heat treated

Trigger Block Plunger Spring - 2

Trigger Housing Assembly - ribband holes must be added after assembly

- must be colored after assembly

Left Side Plate - 10 have been made

Right Side Plate - 10 are being made - heat treat

Front Spacer - add-use H/700

required

Rivets - add use H/700

Rear Spacer - 10 are being made

Trigger Pist Pin - add-use H/700
- withdraw from production

Trigger Pull Adjustment Plunger - drawing required - RSM

Trigger Pull Adj Screw - plot required
- parts must be altered

Trigger Pull Adj Spring - drawing required RSM

Trigger Spring - 10 have been made

Trigger Guard - 10 have been received
- 3 are being checked in Model Shop
- must be colored (parter coated)