

REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE



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Ilion, New York
January 26, 1979

R. L. HALL

MODEL XP-100 SEQUENCE OF EVENTS

Model XP-100 sequence of events in modifying customer return guns and insuring integrity of production Trigger Assemblies is listed chronologically below:

| <u>Date</u> | <u>Event</u> |
|-------------|--|
| 10-24-78 | Remington announced recall of M/600 and XP-100 pistol. |
| 11-78 | Engineering and Production effort concentrated on M/600. Gunsmith write-up - assemblies for gunsmith - establishing process for Trigger Assemblies to be shipped. |
| 11-17-78 | Present process reviewed - trick test for XP-100 reviewed with assemblers - shim test added (check for clearance between Sear and Sear Block with shim Stock, with Safety in null position). |
| 12-1-78 | Initial work on defining situation for customer repair XP-100's started - process reviewed, additions and clarifications were made. |
| 12-15-78 | Process developed for customer repair pistols; Engineers tried sample run. Customer repair gunsmith trained. |
| 12-18-78 | Initial lot of 25 customer guns modified to repair process. Lot rejected, two guns failed test. (1) Shim test and (1) trick test. |

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12-18-78 Contd.

The trick test was re-evaluated and it was found that the engineer and gunsmith were using different techniques on standardized test. The shim test was also re-evaluated for consistent and easier operation.

It was also found that ^{same} customers had made alterations to the Sear Housing Assemblies and they had to be readjusted to standards.

- 12-28-78 A second lot of 25 was modified to revised process. A large percent of pistols would not pass shim test and the new gaging technique was questioned - parts measured.
- 1-4-79 Engineering analysis showed second lot of pistols was using a new shipment of Safety Assemblies which had .006" less lift on Sear. R & D altered drawing to increase lift - parts were ordered with higher lift. Shim test results were ^{ANALYZED} ~~verified~~ by using dial gage which fits into back of Receiver. ^{RESULTS WERE CORRELATED}
- 1-10-79 New lot of 25 pistols started to process for modification - high lift Sears were used and pistols were audited - process verified.
- 1-12-79 Repair verified on customer pistols - pistols ^{STARTED} being returned to customers. ^{STARTED} Production ^{20W LIFT} using ~~new~~ Safety levers; reject rate increased dramatically \approx 50%.
- 1-19-79 New safety levers delivered to Ilion - found to have too much Sear lift, .002" over max. model drawing.
- 1-22-79 New Safety levers in Assemblies - mechanism would lock up when put on Safe. Safety levers ground down to max. model drawing. Mechanism worked but rear of Sear interferes with Sear Housing Pin.
- 1-23-79 Safety levers ground to mean model drawing - still binding. Drawing change made to grind clearance on Sear - parts tried, mechanism worked.

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|-------------|--|
| 1-24-79 | Parts modified, Assemblies put together. Safety worked hard. Lubrication technique developed - parts delivered to Final Assembly - pistols put up. |
| 1-25-79 | Pistols tested satisfactorily. More parts were modified. Pistols which had been rejected were refitted with new Sear and lever. |
| 1-26-79 | More parts being modified - permanent process for part modification being developed. |
| 1-29-79 | Parts delivered to Customer Repair - to continue modifying guns - 147 shipped to date. |

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P E & C Section

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