
From: Norton, Vince
Sent: Thursday, September 11, 2008 10:36 AM
To: Boyles, Derek
Cc: Vicars, Gerald; Williams, Gary
Subject: RE: E-301898 Safety Arm - M770 Fire Control
Attachments: 301898 Safety Arm.PDF

Follow Up Flag: Follow up
Flag Status: Completed

Unfortunately, yes. That is going to require a change. I'm afraid the hole is too far off from its intended diameter to even attempt to use them and modify the print. I have attached a new print, now at revision A. Let me know the impact of this change.

From: Boyles, Derek
Sent: Thursday, September 11, 2008 10:01 AM
To: Norton, Vince
Cc: Vicars, Gerald; Williams, Gary
Subject: RE: E-301898 Safety Arm - M770 Fire Control

Vince, hole size measures .1282 - .1287. I would assume this would require a dwg revision / tool change?

Regards,

Derek Boyles
Quality Engineer
 Remington Arms Company, Inc.
 22 Rifle Trail
 Hickory, KY 42051
 Phone: 270-856-4227
 Fax: 270-856-3233
www.remington.com

From: Norton, Vince
Sent: Thursday, September 11, 2008 7:43 AM
To: Boyles, Derek
Cc: Ronkainen, Jim
Subject: RE: E-301898 Safety Arm - M770 Fire Control

That tolerance is a mistake on the print. It should be +/- .0004, same as the X-Mark Pro safety arm #300674. Where did the new safety arms come in on that dimension?
 VN

From: Boyles, Derek
Sent: Thursday, September 11, 2008 8:25 AM
To: Norton, Vince
Cc: Williams, Gary; Vicars, Gerald; Tipton, Don; Ronkainen, Jim
Subject: E-301898 Safety Arm - M770 Fire Control

Vince,

At your earliest convenience please take a look at the pivot hole dimensions and tolerances on the subject part. Of particular interest is the -D- datum hole tolerance of +/- .004. This is the pivot hole for the cam. Current part #300408 has a tolerance of +/- .0004 for the same hole.

300408 Safety Arm (Current)
 Front hole .132 +/- .001

Back hole (cam) .1260 +/- .0005

301898 Safety Arm (New)

Front hole .128 +/- .001

Back hole (cam) .1258 +/- .004

Unless I am mistaken, both parts will assemble with the same safety pivot pin 300932 having size/tol .124 +/- .001. Is this tolerance scheme the desired outcome?

Regards,

Derek Boyles

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