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**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

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.

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**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*  
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 Hickory, KY 42051  
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**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

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**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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