

FIREARMSWOOD PRESS FORMINGMODEL 870, 12-16-20 GAUGE FORE-ENDS

Production reported that work has been directed at producing Model 870 press formed Fore-ends with full wraparound checkering, requiring die parting lines on the checkering. An alternative is to change to a 3-part pattern to simplify pressing problems.

Fore-ends of both types have been produced. Last month a major improvement was made in eliminating the parting line in a wrap-around sample, however, some crushing at the fleur-de-lis still needs correcting. Samples will be available for the April meeting.

Machine modifications will be reviewed for a production process. Process economics will be reviewed.

SHOTGUNSMODEL 1100, 20 GAUGE LIGHTWEIGHT SHOTGUN

R & D reported that testing of second Model 1100, 20 gauge lightweight shotgun with Receiver of 1140 modified steel has reached 35,000 rounds. There is no Receiver cracking. The sample of two Receivers will not provide conclusive information on the effect of using 1140 modified steel.

A machine process has been developed for polishing ejection ports to eliminate tool mark stress raisers.

Analysis of all weaknesses of this gun has not been completed. Expected life, in rounds fired, of some components are:
Locking Block - 17,000; Barrel Assembly - 20,000; Bolt - 25,000;
Action Bar Assembly - 30,000; Link - 25,000; Fore-end Liner - 20,000; Operating Handle Detent Assembly - 10,000; Firing Pin Retractor Spring - 8,000; Receiver - 20,000.

83