

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.  |

R. L. HALL

-2-

January 26, 1979

Date      Event

12-18-79    The trick test was re-evaluated and it was found that  
Contd.      the engineer and gunsmith were using different techniques  
              - standardized test. The shim test was also re-evaluated  
              for consistent and easier operation.

It was also found that some customers had made altera-  
tions 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 wound not passshim 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 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 Sear were used and pistols were audited -  
              process verified.

1-12-79     Repair verified on customer pistols - pistols started  
              being returned to customers.

Production started using low lift 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 inter-  
              feres with Sear Housing Pin.

1-23-79     Safety levers ground to mean model drawing - still bind-  
              ing. Drawing change made to grind clearance on Sear -  
              parts tried, mechanism worked.

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-3-

January 26, 1979

| <u>Date</u> | <u>Event</u>   |
|-------------|--|
| 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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