

The Hanson Group, LTD.
100 State Street, Gate 3
Ludlow, MA 01056

May 4, 1999

Mr. Mike D. Keeney
Lead Engineer
R & D Technical Center
Remington Arms Co., Inc.
315 W. Ring Road
Elizabethtown, KY 42701

Re: Receiver Insert

Dear Mike,

Per our telephone discussion on May 4, 1999 I am sending you six Receiver Inserts for your perusal, as well as for fit and function between the Bolt and Insert. As I mentioned the mold has been modified from a .055 to .080 gate opening to provide a more efficient flow of material. The process was stabilized and in control when the mold was sampled.

I want to thank you for sending me the prototype Bolt, it has provided me with an opportunity to understand how the unit will function upon assembly. I inserted the Bolt into the Receiver Inserts a number of times, the Bolt seemed to follow the geometry rather well. As a suggestion would it be feasible to add a .005 to .010 radius to the steel lobe geometry on the Bolt to both the inside and outside of the tool. This addition would assist the Bolt to make its way through the length of the Insert as well as its return back into the Insert.

I will be instructing our engineering and tooling support staff here at The Hanson Group to concentrate on modifying the Receiver Insert hole locations taken from Datum "d" on print number (2E-300327). We will address the .701 diameter as well as all other dimensions upon your inspection of the part after mold correction and any other concerns you may have.

Thank you for your consideration in this program, please do not hesitate to call if you have any questions

Sincerely,
Rich Kosko

Rich Kosko
Program Manager
cc: Bobby Liles

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