

**Keeney, Mike**

To: Santillo, Michael R  
Cc: Mead, Joseph P  
Subject: RE Bolt Handle

Good info.

Instead of the braze, how about an internal swedging/riveting stle operation? The male portion of the bolt handle that is inserted into the bolt body is c'bored. The bolt handle is pressed into the bolt body and then a secondary pressing flares out the bolt handle inside of the bolt body. With a soft bolt handle it should not be to difficult to flare? I'll send a sketch for you to think about, what's your fax #?

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From: Santillo, Michael R  
Sent: Friday, August 28, 1998 2:42 PM  
To: Keeney, Mike  
Cc: Mead, Joseph P  
Subject: RE: Bolt Handle

I looked at an archived M/788 today. The bolt handle is a screw machine part that was pressed into the bolt body and induction brazed using a TOCCO unit. I haven't located a copy of the process but I do have a photo of the bolt ass'y and have reviewed an old parts list. In speaking with several people (J. Hennings, D. Sanita, K. Rowlands, R. Smithson, D. Findlay) the major issue with the bolt handle was its tendency to break free from the bolt body when opening the bolt after firing many rounds. Hennings states that he remembers having to re-braze handles throughout a dry-cycle test he performed when the striker was changed to a PM part.

We don't have any accurate cost data associated with the bolt handle but I will use the 788 bolt handle form as a guide when quoting the blank. We can either quote the assembly as a brazed unit or plan to alter the handle to press fit and pin/screw the handle to the body. Let me know your preference. I believe brazing will be a much costlier process. I will fax a Xerox copy of the picture I have for your review. Please advise.

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From: Keeney, Mike  
Sent: Friday, August 28, 1998 9:00 AM  
To: Santillo, Michael R  
Cc: Mead, Joseph P  
Subject: Bolt Handle

Take a look at the m/788 bolt handle, it may be a good style to use. Screw machine part as David suggested, pressed into the bolt body. If you would, pull the old process for the assembly to see if it is brazed? (Send a copy to me) Talk to the older guys to see if there were any major process/function issues with the bolt handle, if not use that process for your estimate?

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