Ilion Quality – Shotguns

Shotgun POI

OBJECTIVE: Conformance to SAAMI spec

ACTION: Ilion to provide status of this project. Priority of shotguns in which to incorporate these changes first:

1. All 1100 Target, 1100 Classic Field and Synthetic
2. 11-87 Premier and SP/SPS
3. 870 Wingmaster and SPS
4. 870 Express
5. SP-10

Findlay presented prototype of proposed new rib design to bring our POI in line with SAAMI.

- Tooling & Gauging to be complete by June 2004
- T&P Scheduled September 2004 for 870/1187

11-87 Super Mag

OBJECTIVE: Determine necessary changes to make this product to the performance requirements as originally specified.

Action: Engineering to provide update on design recommendations and timeline for implementation. What testing needs to be done and when can we expect to make the transition in production?

Findlay presented new gas collar design to give a better seal.

- (10) 12 gauge barrels in test with new design
- Objective to reduce 3" & 3 ½" terminal velocities and improve function
- Testing to be completed by 2.15.04
- MIM , gas cylinder prototype-10 weeks and $15K
- 30 piece 12 gauge machined sample to transmit April 30, 2004

ACTION: **Report on test status**

- **Range of 350 Max and 150 Min. Still testing different gas cylinder designs.**
- **By 3.30.04 start MIM Gas Cylinder**

- Choke Tube Constriction/Patterning Concerns

OBJECTIVE: Conformance to SAAMI spec/product enhancement.

Testing with the M1100 Tournament Skeet 20 GA showed that we had a problem with the extended choke tubes patterning too tight. This has sparked discussion of a full scale audit of all of our 12 and 20 GA choke tubes to verify patterns are correct. Findlay has proposed drawing changes that will be confirmed through a test plan.

ACTION: **Review test results at January PTM.**

Corrective action date.

New Tube Identification-Need some sort of symbol or marking to differentiate new tubes from older tubes.

- **Complete shooting of 12/20/28 gauge extended Briley tubes by end of February**
- **Old fixed skeet was "bow tie" configuration all others tapered to .5" flat; why?**

ACTION: Pursue making tubes meet SAAMI specs. Gain an understanding of old fixed choke dimensions and performance. Get hardcopy of specs to J. Fink and J. Bunting

- **Better to error on the side of tighter constrictions**
- **Engineering to start with 410/28/20 to get choke tubes patterning to spec.**