

John Trull

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**From:** Golem, Todd E.  
**Sent:** 10/22/2003 08:43:49 AM  
**To:** Shoemaker, Christopher D.  
**CC:** Joy, Robert L.; Trull, John; Perniciaro, Stephen  
**BCC:**  
**Subject:** RE: Problem with Rifle for Sports Afield Test.

Chris,

I will begin to look into the fire control issue, but it would be VERY helpful to have an example of one of these rifles with a hard force safety. Would it be possible to get one to me?

Regards,  
Todd E Golem  
Quality Engineer  
Ext.-3364  
Pager-157

-----Original Message-----

**From:** Shoemaker, Christopher D.  
**Sent:** Tuesday, October 21, 2003 5:37 PM  
**To:** Perniciaro, Stephen  
**Cc:** Golem, Todd E.  
**Subject:** FW: Problem with Rifle for Sports Afield Test.

Steve, I think the action on the take down screw torque and length is a process issue and belongs to your group. I will ask Todd Golem to add the fire control quality issue to his list of to do's when he is not tied down with 2100 tasks.

-----Original Message-----

**From:** Trull, John  
**Sent:** Tuesday, October 21, 2003 5:20 PM  
**To:** Shoemaker, Christopher D.  
**Cc:** Perniciaro, Stephen; Joy, Robert L.; Bunnell, Jim  
**Subject:** RE: Problem with Rifle for Sports Afield Test.

Chris,

Please let me know what corrective actions are being taken. I can confirm on the rifle that I had a problem with the bolt closing that the wrong screw was used. I compared the front takedown screw that gave me a problem with one from a gun that didn't and there was probably 0.200" difference in length. I would certainly prefer that we assemble each rifle to the same torque specification rather than making it technique sensitive. Backing the front take down screws down can lead to their own problems with inconsistent bedding from gun to gun and grinding the bolt to correct an improper fit absolutely makes me cringe. I guess my point is this. Everyone knows that many factors contribute to a gun's accuracy. Why not control every variable we can to make the process and product as consistent as possible?

Please let me know what it will take to implement this in our assembly process. To Bob's point about us not knowing if someone improperly re-torques the screws to the wrong torque setting, we can't prevent that internally. But we need to make sure that our guns are torqued to the proper torque setting and that they work at that setting. Based on what I am hearing, it is possible for a consumer to take apart and re-torque the take down screws to the 35 inch lb specification and have a rifle that they can't close the bolt on. That we can control. Our guns should go together at the proper torque setting and work every time. Grinding, filing and cutting parts so they will go together is indicative of a short term solution to a