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 >John Trull  
 >Product Manager - Rifles  
 >Remington Arms Co., Inc.  
 >(336) 548-8737 Phone  
 >(336) 548-7737 Fax  
 >john.trull@remington.com  
 >www.remington.com

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 >-----Original Message-----

>From: Franz, Scott  
 >Sent: Friday, January 10, 2003 4:37 PM  
 >To: Trull, John  
 >Cc: Murphy, Randall S.; Diaz, Danny; Danner, Dale; Snedeker, Jim; Reesor, Phillip K.  
 >Subject: FW: Guide Gun DAT Status

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 >The following summarizes status on the Guide Gun DAT as of today, 1/10/03. As everyone knows there have been issues around stock failure (cracking and recoil lug area setback), malfunction issues and ammo availability that has delayed completion of this DAT as originally planned. The remaining tests yet to be completed are the two trigger tests (SAAMI & Remington tests using a 40 lb. load), obstructed bore and high pressure. The two trigger tests and the obstructed bore test are scheduled to be run today. The high pressure test will be completed early next week after load development for the 120 ksi load is complete. The main issue with DAT was and still is the cracking and setback of the recoil lug area of the stock. Thermal testing does accelerate this failure, however testing under normal shooting conditions also generates the failure. A design change was tested (double enforcement screw up front), however failures of the stock occurred with this design as well. The earliest stock failure during normal shooting occurred at just over 300 rounds with a single enforcement screw and at about 600 rounds on two stocks with double enforcement screws. A picture of these two failed stocks is shown at the bottom of this e-mail. When this failure occurs the action moves rearward in the stock resulting in damage to the magazine box. In addition the stock just behind the bolt handle breaks off from impact with the handle. The second picture shows this failure area on the two double enforcement screw stocks that failed. Other cracks in the stock inletting area around the take down screw holes have consistently occurred. Stock cracking and more specifically the recoil lug area setback is a DAT Exit issue. The Test Lab cannot support transmittal of this product without Marketing's formal acceptance of this condition. Randy Murphy is currently pursuing a riveted design. Test Lab supports this action and will do whatever it can to evaluate this as a potential fix. Timing on availability of test samples is unknown at this time.

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 >Since the last update the following activities have occurred.

- >1 Engineering evaluation of ejection malfunctions on four guns
  - >Extractor tension on bolts measured under specification by Ilion.
  - >Extractor cut in Bolt Head also measured under specification per Ilion.
  - >New extractors fitted to bolts and retested solved issues on all but one gun. A new bolt with a new extractor (extractor tension OK) was fitted to this gun and again retested, solving the ejection issue with this gun. >
  - >An additional 500 rds. was put on two of these guns to see if extractors took a set, resulting in ejection issues reappearing. Guns functioned fine during this 500 rd. test. Extractor tension could not be measured but seemed to be OK after the 500 rounds.
- >2 Rib Tolerance Extreme Test - Pass
  - >This test was run to determine if extremes in tolerance of the rib attachment to the barrel adversely effected group size. Tolerance extremes were simulated by using thick and thin o-rings to result in tight versus loose attachment conditions of the rib to the barrel. Although some vertical stringing was present the groups recorded were in-line with results generated with the nominal floating rib condition.
- >3 Drop Tests (SAAMI and Extended) - Pass
  - >Four guns of each caliber were tested and all passed SAAMI Jar-Off, Rotation and Drop tests