

Remington Arms Company, Inc.
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CONFIDENTIAL

Research and Development Technology Center
Elizabethown, Kentucky

Final Inspect and Pack

- The final step was to review the cosmetics of the final product prior to packing. Action finishes were very uniform and consistent from firearm to firearm. The stock fit to action was fairly consistent, within Trial and Pilot expectations. The sidewall sink of the stock was present, noticeable but not exaggerated. Trigger position relative to the clearance in the stock was fairly centered and consistent. The rack talker label stood out but looked good. Hand tags and ISS keys were present.

As stated in the initial paragraph, overall I was pleased/impressed at the level of consistency in components and completed firearms, as well as current build rates. Ramp-up issues seem to have been minimized. During review of my notes with the Mayfield Staff prior to my departure, the topic of bolt camming and sliding forces was discussed. Although the current production bolt assemblies cammed fairly reasonable, improved camming will be a resultant of implementation of the next generation of bolt heads, probably beginning in early February. Bolt sliding forces remain higher than desired and will be addressed in a couple of ways. The current bolt bodies as supplied by the vendor are running on the maximum acceptable diameter. The subsequent glass beading operation slightly increases the outside diameter as well, while also roughening the surface. The combination of slightly oversized bolt bodies and the rough surface are the contributing factors to the "tight" feel of the bolt assembly in the action. The vendor has been instructed to reduce the nominal diameter to mean model drawing. Mayfield will investigate elimination of the glass beading operation. Although originally specified as a cosmetic operation, it does cleanse the surfaces of brazing residue prior to coloring. If the brazing residue can be eliminated without the glass beading operation, the bolt bodies could be produced with a smooth surface which would significantly reduce the sliding forces.

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Subject to Protective Order - Williams v. Remington

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