

September production issues – Rifle Assembly, Gallery, Pack

ESB/Shell sticking to bolt face on New Gens. Saw it on 243's, 7MM-08, 25-06, and now 270's. On 270 blew a gun apart, it is under investigation

202715 Brown Laminate thumb hole. Late delivery, then reject, accepted, and finally failed for dead safes. 90+ guns removed from the box and had the stocks removed, repaired and replaced. Another 80+ guns built up, but not boxed went through the same process.

Shortages of 94657 sight ramp for 7615's and 201985 of the models 7's. We have added heat treat to process to reduce sights falling off. This has increase the turn around time when short as we were this month.

6.8 Bolt heads, struggled most of the month replacing extractors in commercial products to get guns to pass. LE product held for bolt redesign. First attempt failed. Second redesign looks promising, bolts available for production 9/26/05.

XR-100 stocks cracking at target. No gauges on clamps. Gauges were installed to one jack. Cracking continued and led to targeting issues. Seals in clamps damaged during gallery fire, yet no replaced. No seals in maintenance. Cut down seals from another clamp. These lasted one day. Torn down second jack to make one functioning jack.

XR-100 trigger assemble flow poor.

Many XR-100 trigger assemblies would not adjust properly. Additional reaming needed in hole. Retrained operators on stamping operation also.

10-20% of all XR-100's need to be chamfered to pass targeting.

Sear lift gauge hit screw on XR-100's. Used an alternate (shorter) screw  
5735's were missing the 20 degree chamfer, would not feed properly.

5735's group size originally put out at 1.5". We could not hold this. Process was changed to a 2.5" group size.

All left hand CDL's were structured with the right hand bolt stop spring. Caused part shortages and 3 days wait for proper spring.

6449's were calling out the wrong mag. box.

Slings did not show up on the DMS screen at pack for the San Berardino order and also on the 4475's

7615's Latches are not drilled at 90 degree angle.

100 yard range flooding due to plugged storm drain outside. Replaced target rolles and periodic pump outs for a day.

Supermag shotgun stocks cracking in gallery. Backer plate was not heat treated. Stocks still cracked after this. Used a jelly filled boot during proofing to test the guns.

Speedfeed stock 114400 sent in with Gold Logo on grip cap. Not acceptable for 7615 police guns.

Used up old style Model 7 synthetic stocks. Large butt pad margin. Pad had been redesigned since last use. Change pads on 100+ guns.

Struggled with overrides on 7615's

BV tester had not been in use in gallery on police guns in many years, yet still called out on the process. Decision made to begin using it again on 1187 police. The device is being repaired and a backup being made.

Pitting seen on stainless safety handles. Began oiling process to prevent spreading.

Erratic part flow through out month. bolts, barrels, fire controls and stocks