

**John Trull**

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**From:** Schoppman, Ed D.  
**Sent:** 05/27/2005 12:39:44 PM  
**To:** Foster, Greg; Nagle, Thomas J.  
**CC:** Perniciaro, Stephen; Mead, Joseph P.; McGlory, Jeffrey; Orf, Robert J.; Trull, John; Allen, Gerald R.; Shoemaker, Christopher D.; Longo, Robert W.; McCormack, Timothy J.; Streeter, Michael F.; Haugen, Michael  
**BCC:**  
**Subject:** RE: Two objectives I would like to put on the target radar

Tom,

Do not change anything on the M24 as it is fine as it is. As you know, we cannot unilaterally change the configuration of the system just because we want to.

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Phone 336-548-8521  
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**From:** Foster, Greg  
**Sent:** Friday, May 27, 2005 7:40 AM  
**To:** Nagle, Thomas J.  
**Cc:** Perniciaro, Stephen; Mead, Joseph P.; McGlory, Jeffrey; Orf, Robert J.; Trull, John; Allen, Gerald R.; Shoemaker, Christopher D.; Longo, Robert W.; McCormack, Timothy J.; Streeter, Michael F.; Schoppman, Ed D.  
**Subject:** RE: Two objectives I would like to put on the target radar

If you are happy with the M-24 performance - I can live with holding back on the change and meeting what SAAMI calls for on it until further reviewed. However, my stand for the 700P Police rifle and the 40XS still hold firm. I will be back to Steve on his answers shortly.

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God Bless America

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**From:** Nagle, Thomas J.  
**Sent:** Tuesday, May 24, 2005 1:41 PM  
**To:** Perniciaro, Stephen; Foster, Greg  
**Cc:** Mead, Joseph P.; McGlory, Jeffrey; Orf, Robert J.; Trull, John; Allen, Gerald R.; Shoemaker, Christopher D.; Longo, Robert W.; McCormack, Timothy J.; Streeter, Michael F.

Subject: RE: Two objectives I would like to put on the target radar

FYI

In the SWS area, we don't use the Inspection Max plug at final inspection. All headspace is evaluated using the Bench Max plug only (1.635). In fact, we don't have an Inspection Max plug issued to the "floor".

With regards to reducing the free-bore in the M-24 barrels, I'm against it until we understand if it's going to be a detriment to the accuracy. Our customers have nothing but praise for that rifle's accuracy, while using the same free-bore standard that's used in all other 308's.

Thomas J. Nagle  
Supervisor, Parts & Repairs  
M-24 SWS, Contract Coordinator  
Remington Arms Co., Inc.  
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Ilion, NY 13357  
315-895-3289 Voice  
315-895-3209 FAX

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

From: Perniciaro, Stephen  
Sent: Tuesday, May 24, 2005 11:55 AM  
To: Foster, Greg  
Cc: Mead, Joseph P.; McGlory, Jeffrey; Orf, Robert J.; Trull, John; Allen, Gerald R.; Shoemaker, Christopher D.; Longo, Robert W.; Nagle, Thomas J.; McCormack, Timothy J.; Streeter, Michael F.  
Subject: RE: Two objectives I would like to put on the target radar

Greg,

In response;

1. We do not want to change the trigger pull on LE rifles at this time. However, we will be switching to the new fire control this fall and it will have a trigger pull of 3 ½ to 5 ½ pounds. We are shooting for a max of 4 ½ pounds. I suggest that we wait until then.

2. 308 Win headspace – SAAMI range is 1.630" to 1.640"  
Remington range is 1.6302" to 1.635" before proofing. It can go to 1.637" after proofing.

Arms Service uses a max of 1.639" for used guns.  
All of our 308 Win chambers are made to these specifications including SWS, the exception being the Custom Shop.  
We will take a look at what is involved in holding the headspace to 1.632" max. for LE and SWS rifles.

3. An item you don't mention is freebore. I am sure that Iron Brigade will admit that free bore is as important, if not more important, to accuracy than headspace.

308 Win free bore length - SAAMI is 0.090"  
Remington is 0.1462"

We are looking at what is involved to reduce the free bore on all 308 Win rifles to SAAMI

I will get back to you with a timeline for our action items in 2 and 3 above.

Steve P.

-----Original Message-----  
From: Foster, Greg

Sent: Wednesday, April 06, 2005 10:24 PM  
To: Perniciaro, Stephen  
Cc: Mead, Joseph P.; McGlory, Jeffrey; Shoemaker, Christopher D.; Orf, Robert J.;

Trull, John

Subject: Two objectives I would like to put on the target radar

I would have sworn we established a trigger pull variance and headspace variance back mid summer last year but have searched my computer and cannot find anything. I found the Shotgun trigger pull guidelines but nothing on rifles.

Trigger pull on 700 Police rifles:

Several recent encounters with professionals within the LE industry has directed my thinking toward this issue. During my trip this week to the plant, a quality audit was conducted which involved 10 - 700P LTR rifles. Chris S told me that the factory process calls for 4 3/4 lbs. - 6 3/4 lbs. Of the 10 guns, 7 were over 6 lbs and 5 were 6 1/2 or over. None were over the 6 3/4 ceiling but 2 were right at it.

For a police sniper, it comes down to the trigger and above 5 1/2 is just too much. This is one complaint we hear regularly and when we hear it my team just tells the customer to send the rifle back to Tom Nagle or one of our warranty stations and get it adjusted. If they want it below 4lbs. We tell them to send the request on department letterhead. I know we are moving toward a new trigger in the fall for the SG guns and eventually the Police guns that will allow for a better /more consistent trigger, but in the meantime, I would like to have you guys consider moving the Police gun process for trigger pull to 4 - 5 1/2 lbs.

If we need "Legal" approval for this I will be happy to pursue this.

While they still have a long row to hoe, Savage has certainly made some headway with their external adjustable trigger on their STANDARD police rifle. Fortunately for us, the trigger does not hold well and their consistency of accuracy just isn't there.

Chris, Bob and Jeff told me that it is the nature of the beast within the trigger build process so I would like for you guys to compile the list of issues and lets discuss it in the future.

Police / Military rifle Headspace: (.308 WIN)

Again, with recent solicitations and work with the 40XS, FBI contract rifle and work with Iron Brigade, I have been gaining a better understanding of the importance of proper head spacing. While it may not be as crucial in sporting rifles, with the police rifles and the level of use they experience, the better the head spacing, the better the consistency of the accuracy will stay.

According to Chris, the way I understood him, was that they only use a min and max go / no go gage in the production process - and am speculating that the min is a 1.630 and the max is the 1.638. You can certainly verify this and you can get from Chris what their spec is for both.

I do not have the "range" of the .308 WIN sporting and police guns but it is my understanding guns are passed up to a 1.639 headspace gage. (1.640 is considered unserviceable / unsafe according to SAAMI). Checking the headspace of 6 of the LTR rifles in the custom shop ( for the Davidson's project) we found some that gaged as low as 1.633 and as high as 1.636. Yet in the quality inspection today of the 10 LTR's checked NONE went over 1.632.

This is another subject that I thought we had already established a police gun range but apparently not. Therefore, my request for you to consider is that;

1) NO 700P model headspace exceed 1.632

\* For the 40XB, 40XS - it is established in the custom shop that these guns NOT exceed 1.631.

\* I do not know what the M-24 is but it should not exceed 1.631 either

Once this is accomplished for the 308 we need to look at the other calibers as well but they are not nearly as critical due to volumes.

Again, please get back to me with the feasibility of establishing this within the process for 700 Police rifles and the issues we would encounter.

There is no urgency on these but I would like to get them on the radar and certainly be able to have them in place as we get the 700 build area up and running in the next few months.

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