John Trull			
From: Sent: To: CC:	Foster, Greg 05/27/2005 07:40:13 AM Nagle, Thomas J. Perniciaro, Stephen; Mead, Joseph F John; Allen, Gerald R.; Shoemaker, G		
BCC:	Streeter, Michael F.; Schoppman, Ed	D.	
Subject:	RE: Two objectives I would like to pu y with the M-24 performance - I can live w		*
what SAAMI ca	Ils for on it until further reviewed. Howev firm. I will be back to Steve on his answe ter er is nforcement lencies O FAX Mobile WEB om	er, my stand for the 70	00P Police rifle and the
>			
<ul><li>&gt; To: Pernici</li><li>&gt; Cc: Mead,</li></ul>	Nagle, Thomas J. ny, May 24, 2005 1:41 PM aro, Stephen; Foster, Greg Joseph P.; McGlory, Jeffrey; Orf, Robert J Longo, Robert W.; McCormack, Timothy RE: Two objectives I would like to put or	ට.; Streeter, Michael F	Gerald R.; Shoemaker, F.
> In the SWS a using the Benc	irea, we don't use the Inspection Max plug h Max plug only ct, we don't have an Inspection Max plug		II headspace is evaluated
going to be a d	to reducing the free-bore in the M-24 ban etriment to the accuracy. Our customers h same free-bore standard that's used in al	ave nothing but praise	
<ul><li>&gt; Thomas J. Na</li><li>&gt; Supervisor, F</li></ul>	Parts & Repairs Contract Coordinator rms Co., inc /e 57 3 Voice 3 FAX		

Subject to Protective Order - Williams v. Remington

> Sent: Tuesday, May 24, 2005 11:55 AM > To: Foster, Greg	
<ul> <li>&gt; Cc: Mead, Joseph P.; McGlory, Jeffrey; Orf, Robert J.; Trull, John; Allen, Gerald Christopher D.; Longo, Robert W.; Nagle, Thomas J.; McCormack, Timothy J.; St</li> <li>&gt; Subject: RE: Two objectives I would like to put on the target radar</li> </ul>	
> > Greg,	
> > In response;	
> > 1. We do not want to change the trigger pull on LE rifles at this time. However, the new fire control this fall and it will have a trigger pull of 3 ½ to 5 % pounds. W max of 4 ½ pounds. I suggest that we wait until then. >	
<ul> <li>2. 308 Win headspace – SAAMI range is 1.630" to 1.640"</li> <li>Remington range is 1.6302" to 1.635" before proofing. It</li> </ul>	can go to 1.637" after
proofing. > Arms Service uses a max of 1.639" for used guins.	-
> All of our 308 Win chambers are made to these specifications including SWS, th Custom Shop.	
> We will take a look at what is involved in holding the headspace to 1.632" max.	
> 3. An item you don't mention is freebore. I am sure that from Brigade will admit important, if not more important, to accuracy that headspace.	that free bore is as
> 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 t >	to SAAMI
> > I will get back to you with a timeline for our action items in 2 and 3 above.	
> > Steve P.	
>	
<u>}</u>	
>Original Message	
<ul> <li>From: Foster, Greg</li> <li>Sent: Wednesday, April 08, 2005 10:24 PM</li> </ul>	
> To: Perniciaro, Stephen	Pabort I: Trull John
<ul> <li>Subject: Two objectives I would like to put on the target radar</li> </ul>	Robert J., Truit, John
<u>}</u>	
I would have swore we established a trigger pull variance and headspace summer last year but have searched my computer and cannot find anything. I fou pull guidelines but nothing on rifles.	
<ul> <li>Trigger pull on 700 Police attes</li> <li>&gt; Several recent encounters with professionals within the LE industry has</li> </ul>	directed my thinking
<ul> <li>toward this issue. During my trip this week to the plant, a quality audit was conduce</li> <li>700P LTR rifles. Chris S told me that the factory process cal&gt; Is for 4 3/4 lbs.</li> </ul>	cted which involved 10 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	
For a police sniper, it comes down to the trigger and above 5 1/2 is just to complaint we hear regularly and when we hear it my team just tells the customer t Tom Nagle drivene of our warranty stations and get it adjusted. If they want it below send the request on department letterhead. I know we are moving toward a new t SG guns and eventually the Police guns that will allow for a better /more consister meantime, I would like to have you guys consider moving the Police gun process 1/2 lbs.	o send the rifle back to w 4lbs. We tell them to rigger in the fall for the nt trigger, but in the

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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 consistancy of accuracy just isn't there.

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>

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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- God Bless America...
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