

John Trull

From: Foster, Greg
Sent: 05/27/2005 07:40:13 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.
BCC:
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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>
> 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
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> Ilion, NY 13357
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>
> -----Original Message-----
> From: Perniciaro, Stephen

>
> 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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