

**John Trull**

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**From:** Shoemaker, Christopher D.  
**Sent:** 10/21/2003 04:28:50 PM  
**To:** Trull, John  
**CC:** Perniciaro, Stephen; Joy, Robert L.; Bunnell, Jim  
**BCC:**  
**Subject:** FW: Problem with Rifle for Sports Afield Test.

John,

Please see Bob Joy's note below. I reviewed the assembly process today, we do not torque the take down screws. We use an air powered driver and each operator has his own technique of how tight he drives the takedown screw. They are trained to test the bolt and if the screw is interfering they back it off until it works freely, or in some cases may even grind down the bolt. The issue may be compounded by the tolerance stack ups between the receiver (bolt hole and OD), the stock (barrel channel and bottom inletting), the trigger guard and the screw length. It is also possible to have even used the wrong take down screw. The stock on this model does not have an aluminum bedding block so some (minimal) compression of the stock is possible if the screw is over tightened. The stock is made by ORC and we did experience some inletting issues after they modified the mold to eliminate a visual defect on the top rails. They produced a quantity of stocks to a deviation on the inletting dimensions until they had a chance to repair their molds. This deviation caused us to have to grind some take down screws to prevent them from protruding too far. It is possible that this stock was one produced to the deviation and the take down screw was ground improperly or not at all.

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

From: Joy, Robert L.  
Sent: Tuesday, October 21, 2003 7:38 AM  
To: Perniciaro, Stephen  
Cc: Shoemaker, Christopher D.  
Subject: RE: Problem with Rifle for Sports Afield Test.

Steve / Chris,

RE: Takedown screw - We have a process specification of 35 in-lbs (Max) for takedown screw torque. A screw can bind the bolt lugs if it is the wrong screw (too long), the stock inletting is incorrect, the screw is over-torqued, or similar reasons. There are many opportunities in our process to catch this condition, if it exists. We will not know, however, if someone improperly re-torques the screws outside of the plant.

RE: Safety force - The safety always moves easily back and forth with the bolt open, or out of the rifle. This is true because little work is being done by the safety cam in lifting the sear when the bolt is removed. With the bolt in the action and closed down, the act of lifting the sear is also pushing back the firing pin against the compression of the firing pin spring. Thus, the sensation of higher safety force. When the rifles are function tested in our gallery, the safety is operated 3-times and operating effort is considered. At final inspection we control the most important attribute - sear lift. It is held between .008 and .018. Safety force is a product of sear lift. The higher the amount of lift, the higher the perceived safe operating force. Sear lift is a measure of the distance that the safety cam lifts the sear off the top of the trigger connector (more is better in terms of safety function.) If the safety operating force "feels" heavy, sear lift is probably in the .015 - .018 range.

Chris: Next step? We might audit some rifles to see where our sear lift is running. A few years ago we had trigger holes high in the triggers and sear lift was running around .020. The safeties did feel heavy and we brought things back into control by attacking the trigger process. Your call...

Bob

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

From: Perniciaro, Stephen

Sent: Monday, October 20, 2003 1:51 PM  
To: Trull, John; Shoemaker, Christopher D.; Bunnell, Jim; Longo, Robert W.; Evans, Danny; Joy, Robert L.  
Subject: RE: Problem with Rifle for Sports Afield Test.

Bob Joy,

Please work with Chris on this and answer John's questions.

Steve P.

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

From: Trull, John  
Sent: Monday, October 20, 2003 8:48 AM  
To: Shoemaker, Christopher D.; Perniciaro, Stephen; Bunnell, Jim; Longo, Robert W.; Evans, Danny  
Subject: FW: Problem with Rifle for Sports Afield Test.

Gentlemen,

Please see the comment below regarding the front takedown screw on a M700 BDL SS. I just encountered the same issue with a M700 I have here. It appears that the front take down screw is too long, extending into the locking lug area of the receiver. Please look into this. Do we torque all take down screws to a specific torque setting? I would imagine that if we did, this condition would show itself pretty readily.

Also, I noticed on the M700 Classic and M700 CDL samples that I received that it is extremely difficult to move the safety from Fire back to Safe with the bolt closed in battery. Seems that there is some sort of tolerance stack up that is causing this as the safety arm moves pretty easily with the bolt out of the gun. What checks do we make in assembly for this condition? These guns were not acceptable to put in the field.

Please advise.

Thanks,

John Trull  
Product & Planning Manager, Firearms  
Remington Arms Co., Inc.  
(336) 548-8737 Phone  
(336) 548-7737 Fax  
john.trull@remington.com  
www.remington.com

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

From: Powell, Linda  
Sent: Monday, October 20, 2003 8:18 AM  
To: Trull, John  
Subject: FW: Problem with Rifle for Sports Afield Test.

Your thoughts?

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

From: John Ross [mailto:jross@crosslink.net]  
Sent: Tuesday, October 14, 2003 11:53 PM  
To: Powell, Linda  
Subject: Problem with Rifle for Sports Afield Test.

Linda,

Received BDL-SS rifle #56464393 in .300 SA Ultra Mag. While I like the configuration of the rifle, when

I tighten the front guard screw thoroughly, the bolt binds in the action and will not open. I suspect that the action is warping as the stock compresses. Can't possibly write a favorable review of this model. Most hunters won't travel with a torque wrench.

Do you have another which has a firmer bedding system?

Sorry to be a pill, but for a traveling hunter, one needs to be able to remove and return the barreled action from the stock with a reasonable assumption that the guard screws can be tightened completely and the rifle will return close to zero.

Thoughts?

John Ross,  
Contributing Editor  
Sports Afield

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

From: Powell, Linda [mailto:Linda.Powell@remington.com]  
Sent: Tuesday, September 30, 2003 1:22 PM  
To: John Ross  
Subject: RE: All-weather Rifle

John,

We always need exposure on our existing core group of products. I would prefer the Model 700 BDL SS in the caliber of your choice. We can supply a couple of boxes of ammo as well. Since I am on the road, I will ask Teresa to check inventory for the two BDL SS models and contact you regarding availability. We should have no problem getting the rifle to you within 7 to 10 days.

Thanks for your support and good luck on your hunt!

Best

regards,

Linda Powell

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

From: John Ross [mailto:jross@crosslink.net]  
Sent: Tuesday, September 30, 2003 10:11 AM  
To: Powell, Linda  
Subject: All-weather Rifle

Dear Linda,

Doing a piece for Sports Afield on extreme weather hunting -- in this case woodland caribou in Newfoundland in November.

Just got off the phone with your colleague who suggested that the 700 BDL -- SS is the ideal rifle in 300 SA Ultra Mag (#26436) or 300 Win Mag (#29694) for lousy weather hunting. Other possibilities include the Model 7 Alaska Wilderness Rifle in 300 SA Ultra Mag (#29561) because of its lighter weight and matte black finish.

As a traveling hunter, availability of ammo in foreign countries is a real concern. Thus my tendency to opt for a standard caliber. However, if you'd rather I reported on the SA Ultra Mag, I can do that and mention that the rifle is also available in other chamberings.

Is it possible to obtain one of these rifles and ammo for testing on the trip? I'm leaving on 1 Nov.

Hope we can work something out.

Thanks,

John Ross, Contributing Editor  
Sports Afield  
PO Box 680  
Upperville VA 20185  
540/592-7020

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