

## Laura Watson

---

**From:** Phillips, Rena  
**Sent:** 05/14/2003 12:58:58 PM  
**To:** Watson, Laura M.  
**CC:**  
**BCC:**  
**Subject:** Training

Here is the remainder. I attached it to the Rifle notes!!

---

Dec. 1st starts new year for parts.

Credit card orders normally ship after 2 days, check or money order – orders usually ship within 5 business days.

If you receive a credit card denial contact customer ask for a different credit card for the order.

Open accounts – discount and payment terms – line of credit – R#'s to get open accounts have to apply – credit app and parts dept. app. – then goes to accounting. Discount depends on amount dealer spends per year. For dealer pricing have to spend at least \$500 each year, \$1,000 or more a year to get MSP pricing. RARC's do not get parts at no charge.

LE (Law Enforcement) orders have to be faxed in on department letterhead – LE wholesalers only have to sign limited sales agreement. All government orders go to Jessica.

EDI – Electronic Data Invoicing – Sports, Inc., Ace Hardware, True Value/True Serve and Gander Mountain.

Bill to orders go to Dell.

When taking orders always ask if business or individual.

Sports, Inc. fax in on an order form with P.O.

We do not take international orders – send to George McHugh (George can not do onesie, twosies).

Shahoud's is our receiving center for repairs.

Guns that are still worked on at factory:

Model 552

Model 541

Model 581

Model 1196-Parts from 11-87 will interchange

Model 600 (only for recall and safety modification program)

3200 – (Update)

Repairs can not ship to a different address than originated.

Model 597

If consumer has repair issue, suggest Mann & Son, if customer insists on sending to the factory then send to Ilion.

The 597 has the last shot hold open feature, bolt is made out of nickel plated metal. 597 is the only 22 that has a rounded off firing pin.

If the gun is not re-cocking – most always the trigger linkage. If jamming, try sending customer new magazine box. If consumer has a magazine box with red follower, the red follower is defective, send new mag box.

Jan. 2001, 597's should have old style ejector, if having problems with ejecting send new style ejector. There is a small hole in the bolt, it is part of the manufacturing process and also aids in production.

The Model 597, 552, and 572 all have aluminum receivers.

#### Model 552 & 572

552 & 572 are the most reliable firearms that we make. Both have inner and outer tubes. The 552 is the only U.S. made 22 that will shoot both short and long rifle ammunition. 17 rounds of short ammo and 15 rounds of long ammo. New York City and New Jersey residents can not purchase 22's. BDL name was kept on the 552 & 572 because of the cosmetics (stock, fore-end, & bbl finish).

#### Model 700

700 was first produced in 1962 – used as sniper rifle in Vietnam.

Magnum stock have two screws, non-magnum stocks have one reinforcement screw. Magnum calibers come with recoil pad non-magnum come with butt plate.

Pressure point helps bbl to settle back down in same spot which helps w/accuracy (all wood stocks have pressure point) Synthetic stocks have aluminum bedding block and are free floated (heavy bbl synthetic).

H.S. Precision stocks are used on our cataloged items and police firearms. McMillan stocks are used on custom shop guns.

700 receiver has the three rings of steel which are: (1) bolt, (2) barrel, and (3) receiver.

If consumer loses bolt, the gun has to come back in to the factory or to replace the bolt. (head spacing issue).

#### Model 700 cont'd

Magnum extractor is riveted non-magnum is not riveted, snaps in. Older (non-magnum) models have riveted extractors, send to Jack First or send to factory to have new bolt assembly fitted.

When bolt is locked in engagement do not use the ISS system – this will cause the firing pin to bind and jamb. Will have to be sent to the factory for repair.

#### Model Seven

The Model Seven is right hand only and short action only. Receiver is shorter and in theory makes it more rigid or more accurate. In '98 we changed from one scope base hole to two scope base holes.

Up until 1999 all Sevens had 18" bbl now have 20" bbls.

#### XP-100

We do not sell parts – send it in XP-100 is a Model 600 action made from the 60's to 95'.

#### XP-100R

Made from 93 -98 based off of the Model Seven.

#### Model 7600

Pump action centerfire rifle with detachable magazine – 1st manufactured in 1960 as the 760.

Receiver is engraved and made of steel (block of steel) based off of an 870 shotgun receiver butt stock off of 870 20 gauge will interchange. (Wingmaster satin finish).

7600 & 7400 all come with Monte Carlo stock. Same extractor and ejector as the 700. All of our firearms are push-fed.

7600 parts do not interchange with 760, only part that will interchange is the butt stock.

#### Model 7400

Inertia energy – this model has to have shoulder to operate firearm properly. Very important to lean into the gun and take brunt of recoil. 7400 parts will interchange with the Model Four, butt stock will interchange with Model 742.

Very important to keep chamber clean – clean with chamber brush. Clean (7400 & 7600) from bore of bbl in.

#### Shotgun Notes

##### 870

Pump action – shell latches hold shells in magazine tube, ejector & ejector spring replacement has to be done by gunsmith.

Receiver is cut –machined from a block of steel – only manufacturer to do this. If receiver cracks, send in to factory, will have to have the receiver assembly replaced.

Magazine cap detent has to be installed on new bbl on guide ring on pre-1987 shotguns, 12 gauge; only take to competent gunsmith or RARC. Police guns still use magazine cap detent, also Marine Magnum. Flexi-tab kit can only be purchased by LE, action bar tube assembly and carrier assembly – look for d-shape.

Super mag ejection opening and bolt are larger, has its own ejector, shell latches and trigger assembly.

If consumer calls in and action bars are broken (40 year old gun) need new flexi-tab system. New style fore-ends will fit older model shotguns. 12 gauge – everything is interchangeable (except for 870 Special Field and Competition Trap).

870 Competition Trap was a gas compensated pump action shotgun – Gun Parts Corporation has parts.

Pre-1977 - 870 20 gauges were built off of the 12 gauge standard frame – serial number will end in an X or an N.

LT is a 20 gauge frame. A lot of 12 gauge parts will interchange with 16 gauge, 16 gauges also have to have detent installed on barrel. 28 gauge and 410 gauges have not changed much.

If consumer asks about drilling and tapping receiver make to sure tell them that it is suggested.

##### 870 Cont'd

Light contour barrels have a smaller diameter outside than standard contour barrels. Light contour bbls (1993) decrease outside diameter made light for dove and/or quail hunting. Headspacing on shotgun is based off of locking block.

870 Express (matte finished) bead sights are staked-in, blued are screwed in.

#### 1100

Very 1st fully gas operated shotgun. Barrel seal is a high temperature plastic; o-rings from hardware store will not work.

1100 Magnum – 12 and 20 3" chambered barrel will not cycle 2 3/4".

1100 is normally 2 3/4 only. Fore-end insert on Pre-1987 needs to be replaced, Gun Parts Corp. has part.

If consumer calls and receiver stud has broken off, it is not needed, gun is still safe to shoot.

Ejector is in the bbl – Trap bbl's have defectors – competition guns will only use light loads.

1100 steel shot bbls will chamber 2 3/4 and 3" shells whether it is 1100 magnum or not – no 3" lead.

The difference between the 1100 and the 11-87 bbls is the gas cylinder spring on bbls.

#### 11-87

Pressure compensated, magazine tube is stainless steel. If consumer has a light contour bbl on original firearm, and change to a standard contour bbl, will have to have a standard contour fore-end. Can offer the fore-end to the customer for \$25.00.

If gun is not chambering or cycling check bbl seal, check piston and piston seal, make sure expansion joints are on opposite sides. Check to see if magazine tube is clean and also check to see if action spring is clean.

11-87 fore-ends have problems cracking, if under warranty replace at no charge.

11-87 super mag parts do not interchange with standard 11-87.

Barrel seal activator is for use only with 2 3/4" shells, must be removed when shooting 3" and 3 1/2" shells.

#### 11-87 cont'd

11-87 Gas Cylinder spring is set to take 8 lbs. of pressure. 11-87 will shoot any field load or hunting load reliably, least amount 3 1/4 and 1 1/8.

Super mags have the gas cylinder collar built in to the fore-end. Bbl seal activator only on super mag goes in between piston seal and bbl seal.

#### SP-10

Semi-auto gas-operated 10 gauge based off of the Ithaca Mag 10. Parts from SP-10 do not interchange with the Mag 10.

Carrier release is on the side of the firearm, if consumer has problem must take to RARC or send in to the factory. Magazine follower is in three pieces. Swivel stud on fore-end nut breaks loose, fore-end nut assembly with stud would be needed.

#### 332

12 gauge only with bottom box lock. What is normally called a receiver is called a frame on this model. Fore-end controls everything on a break-action shotgun, it is actually called a fore-end iron. Mechanical trigger.

#### 3200

We do fix the bbl sets & please send all bbl sets with gun. Bbls do not have choke tubs, consumer needs to specify what choke they want, (can specify specific diameter).

We still do the 3200 update, takes 8 – 12 weeks on repairs. 1977 needed to make adjustments to the 3200. Strengthens the receiver \$350 for the update. When in reality we use \$900 worth of parts and labor.

Factory only performs update on 3200. Laib's Gunsmithing has all parts and will repair.