

To: W. E. Beck
From: J. P. Linde

5-7-75

-2-

Evaluation of the Bolt Action Rifle Safety Mechanisms - M/580, 788, 600 & 700

The guns are being checked to give at least .008 inches min. lift between the trigger-connector surface and the sear.

The holes on the fire control housing on some of the samples tested were out of control. Corrective action is being taken.

Proposed Design and Process Changes

Design

1. The safety levers have been redimensioned to give better manufacturing control of critical dimensions.
2. The dimensions on the safety lever cam were changed to give greater lift on the sear and maintain the lift longer when the safety is moved from "on safe" to "off safe".
3. The fire control housing will be changed to be common with the Model 700. It has two separate side plates which are riveted together, while the 600 has a folded assembly. The M/700 housing has a heat treated side plate with the detent hole, which gives more positive safety. The folded assembly is not heat treated and the detent holes wear and become less positive.
4. The sear has to be altered to eliminate a potential interference with the rear housing assembly pin.

Process

1. A production gage has been designed and is being built which will measure the sear lift due to the safety lever operation before the fire controls are assembled to the gun.
2. An inspection hole has been added to the new design safety lever so the cam form and its position on the safety lever can be readily inspected in purchase parts inspection.