

To: W.E. Leek 5-7-75
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Evaluation of the Bolt Action Rifle Safety Mechanisms - M/560, 788, 600 & 700

Model 788 and 580 Series Continued

When the problem appeared all the parts involved in the safety mechanism were measured to determine why there was insufficient sear lift. The following items were found:

1. The powder metal trigger was out of tolerance. Powder Metal has been contacted.
2. The safety lever dimensioning did not tie the critical dimensions together.
3. The holes in the trigger housing were not to locational dimension.

Corrective Action Taken to Maintain Production

1. The triggers were ground to provide more clearance when the safety was operated.
2. The gaging technique was established to measure the sear lift with the safety operation when the gun is assembled.
3. All the assemblers were reinstructed on what to look for -- proper lift and can the gun be tricked.

Corrective Action Being Taken

1. Correct the parts out of gage and establish controls.
2. Redimension safety levers for both the 580 Series and 788 to tie the critical surfaces together. The vendor has been contacted on what surfaces are critical and how they can best be maintained.
3. The dimensions on the safety lever were altered to give greater lift to insure in all tolerance conditions there is adequate lift with an allowance for wear.
4. Process Engineering is designing a gage to measure the sear lift from the safety lever operation to insure that the fire control will have adequate lift before it is assembled to the gun.