

# REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE



"CONFINE YOUR LETTER TO ONE SUBJECT ONLY" \_\_\_\_\_

Ilion, New York  
October 26, 1978

## RECALL OF MOHAWK 600 RIFLES

### UPDATED STATUS

#### Trigger Assembly

The main consideration on the Trigger Assembly is that they are assembled, and safety checks are performed to insure that a safe reliable Trigger Assembly is shipped to the gunsmith. Presently, the Trigger Assembly is a separate operation and the unit is transferred to the Final Assembly area, where the final assembler assembles it to the Barrel Action.

A series of safety checks are performed at this step and the Stock is installed. Another set of checks are made - the rifle is then taken into the Gallery where the gun is tested and the safety is again checked. At the final inspection, the safety procedure is rechecked and a certain percent are audited, again checking the safety function.

In the recall of the Mohawk 600 guns, the Trigger Assemblies will be shipped directly to the gunsmiths and the subsequent safety operations that we perform at present, will have to be incorporated into our sub-assembly operation.

The Process Record and Industrial Engineering sheets have been reviewed, operation by operation. This review was performed with representatives of Research and Process Engineering who are familiar with this model. The Process Record was also clarified. Any statements in the Process Record which could be misread or misinterpreted are being rewritten and pictures and illustrations are being included.

There were a number of areas where answers were not known in the meeting on Wednesday, October 25. By today, October 26, a number of considerations have been resolved and there are very few items which have yet to be answered.

Items Covered in the Discussion:

The fit of the Connector to the Trigger was analyzed in great detail. Specifications were determined on the correct fit, with a tentative .005" max. clearance established between the Connector and the Trigger. Fitting procedure was also analyzed and the correct method to fit the Connector was determined.

Two gages (one to be made and one now being made) will check the straightness and squareness of the Connector to insure that is correct before being assembled to the Trigger.

A fixture designed and built to measure the clearance between the Sear and Connector is going to be utilized on the job, such that the clearance can be analyzed when the Safety is put in the middle or null position. In this way, every Trigger Assembly shipped to a gunsmith, will be checked for the null position, to make sure that it is on Safe and cannot be tricked. The amount of clearance when the Safety lever is in the null position, is being determined and should be completed later this afternoon.

The assembler, as with the common Trigger Plate Assembly, will identify his work with a stamp. The Trigger Assemblies will be marked with a stamp (alpha or numerical) on the back of the Trigger. In this way, any Model 600 or XP-100, can readily be checked without disassembly, to verify that it has the new Trigger Assembly.

The comparator check wasn't analyzed and the Trigger pull section of it will be revised. The correlation will be determined between what the operator gets on the assembly bench as far as Trigger pull, and what the sub-assembler gets in adjusting the Trigger pull screw. This correlation will be done so that the sub-assemblies should require no adjusting by the gunsmith.

Process for Retrofitting Customer Guns in the Field by  
Recommended Remington Gunsmiths:

To make sure that the new Trigger Assemblies are assembled to the rifle in the correct procedure, a complete Process Record is being developed to give the gunsmiths step-by-step instructions on the proper disassembly and assembly procedures.

Trigger Assemblies of the revised process including additional safety inspections, will be taken to Customer Repair and fitted to Model 600's, to verify the revised process.

The following considerations have come to light and answers are being determined:

On the original Trial and Pilot, the Stock reinforcing screw was interfering with the redesigned Trigger Assembly. Research is digging out all records on the Trial and Pilot on the interference, and have stated that the situation can be corrected by adjusting the soft brass screw. They are working up the process that the individual using the gun would use, that is, upsetting the screw slightly, to give the additional clearance required. They will also take pictures of the operations so that we can include them in the write-up that goes to the gunsmiths.

The Safety lever on the original Trial and Pilot also had an interference with the wood on the Stock. The levers now have been redesigned to give more clearance with the wood, but there is a potential for wood interference. Research is checking to make sure that there is an interference on a number of models, and if there is, the gunsmith will be instructed on how to rout out or clean out the area where there is an interference. It is an easily executed operation, which should not affect the program.

It should also be noted that the Mohawk 600's for a period of years, were fitted with a gold Trigger - the replacement assemblies will have the black Triggers. The original Remington 600 and 660's did not have gold Triggers, however, so the gold Triggers are definitely in the minority. This should not be a problem.

RECALL OF MOHAWK 600 RIFLES - UPDATED STATUS

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When the gunsmiths repair the recalled rifles, we will insist that they send all of the Trigger Assemblies back which are replaced. We do not want these assemblies left out in the field where the parts can be scavanged off these and cause the old Safety levers and incorrect Sears to be put into rifles which can cause problems in the future. The assemblies will be scrapped and accounted for when they are returned to Ilion.

The gunsmiths will be requested to stamp a letter or alphabetical character on the Receiver externally, where it can be seen, to identify without Stock disassembly, that the rifle has been converted to the new Trigger Assembly. Also, it would be our recommendation that the gunsmith put another stamp on the rifle, indicating at what repair station or what repairman actually modified the rifle.

To insure that all the rifles of this type in the plant, meet the required specifications, all the final assemblers, Gallery personnel, inspectors, Customer Repair checkers, Customer Repair gunsmiths, Customer Repair final inspector, 40XR or Custom Shop assemblers and XP-100 assemblers are being reinstructed on the trick test.

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