

M/700 - Fire Control

REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE



cc: C. B. Workman
J. P. Linde
C. F. Prosser

"CONFINE YOUR LETTER TO ONE SUBJECT ONLY" _____

March 18, 1975

✓ E. R. CARR

PROGRESS REPORT - M/600 - 700 FIRE CONTROL

All assemblers have been instructed in how to check for the gun firing when the Safety is released. Included in this instruction is the technique of attempting to hang the Safety up halfway between the on and off positions. The instructions will be included in the Process Records by 3/21.

An operation to swage the coming surface of the M/600 Safety is being done. This provides additional lift on the Sear.

Research is contemplating several design changes on the M/600. These include the following:

1. Heat treating the Housing stamping. This is currently soft and the Safety Detent Ball wears a groove in it which facilitates the Safety hanging up.
2. A change in the Safety to provide additional lift of the Sear.
3. A redesign of the countersink on the Housing to provide a minimum flat between the on and off position, which will mean a more positive Safety.
4. Eliminating the stamped Housing and going to side plates and spacers similar to the M/700. Costs are being developed on this proposal to determine if it is economically feasible.


J. W. Bower
Sr. Process Engineer

JWB:jc



M1700 Fire Control
TITLE OF PROJ. M1700 TRIAL USE OF LPS INSTEAD PROJ NO

SUBJECT OF MOLYCOTE FOR CONTROL OF TRIGGER PULL

COMPUTER

DATE 5-18 19 74

REPORTED BY LOADS OF TWENTY RIFLES.

REJECTED
FOR CREEP

PASSED

Lay,

11	8
2	15
4	15
13	7
5	15
6	14
3	17
9	11
12	8
5	15
4	16
4	16
7	13
4	16
4	16

This is a report on using LPS lubricant instead of Moly-cote. It doesn't look very good. This is about the reject rate we get with no lube.

Jim

19/700 TRIGGER & TRIGGER NO. CONN. WORKS

WORKS

— 19 —

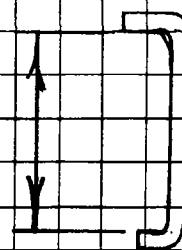
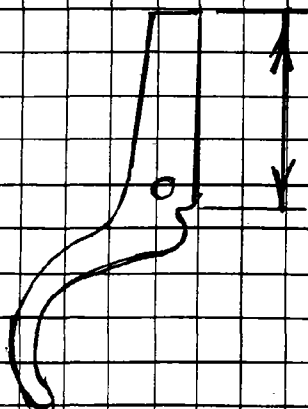
TRIG.
CONNECTOR

$$D_{17} = 1.080 / 1.083$$

↑
TOL
↓

1
1
11
~~1111~~
~~1111~~ 1
~~1111~~ 1111
1111
1

↑
TOL
↓



M/200 Fire Control

Car

G-88

DON'T SAY IT—WRITE IT

To A. Byrnes

DATE 5/3/71

FROM W. Thompson

Re: - Comparator for setting M/200 & 600 Trig. Housing
Purchase Jones and Lamson Model TC-10 optical
Comparator and following accessories:-

1 - A-7167 TC-10 Table Comparator with 10" rec. glass -	630 ⁰⁰
1 - AC-3149 Tungsten Elec. System 110V. 50-60 Cycle A.C.	290 ⁰⁰
1 - AC 3445 5" x 16" Hard Chrome plated Platen Table	330 ⁰⁰
1 - AC 3834 Lens System for 10 magnification 1.000 Dia. -	230 ⁰⁰
Total -	\$ 1480 ⁰⁰

TO BE SAFE, FIRST THINK YOU MIGHT NOT BE

M/700 Fire Control

P.I. No GUN EXAMINATION REPORT NUMBER: _____ MODEL: 700 ADL
GENERAL CONDITION: Good R #: 22760
OUTSIDE WORK: ALL TRIGGER ADJUSTING DATE: 10-16-70
SCREWS UNSEALED, ADJUSTMENTS CHANGED FROM: CENTRALIA,
FIRED AMMO TYPE: - 1LL IN 015.
& CONDITION: _____ GUN #: 193587
PROOF: R.E.P. INSP.: 9 TEST: _____ CODE: W13 = 3/70
HEADING: _____ GA./CAL.: 222
BREECH OPENING: _____ CHECKED BY: C. PROSSER
RECOIL SHOULDERS: _____ APPROVED: _____
CHAMBER: _____ APPROVED: _____
TEST: _____ APPROVED: _____
COMPONENT CONDITION: (Damaged, Broken, Old Style) APPROVED: _____
OLD STYLE SEAR-SAFETY CAM, (HEAVY OIL USED)
TRIGGER CONNECTOR BROKEN.

COMPLAINT: FOLLOWS DOWN.

INCIDENT: _____

COMMENTS: FOLLOW DOWN WAS CAUSED BY THE BROKEN CONNECTOR.

P.I. NO GUN EXAMINATION REPORT NUMBER: _____ MODEL: 700
GENERAL CONDITION: NEW R #: 22775
OUTSIDE WORK: NO DATE: 10-15-70
FROM: MARKLEYSBURG,
FIRED AMMO TYPE: _____ PA.
& CONDITION: _____ GUN #: 6262918
PROOF: R.E.P. INSP.: 9 TEST: _____ CODE: OS = 7/69
HEADING: O.K. GA./CAL.: 22-250
BREECH OPENING: _____ CHECKED BY: C. PROSSER
RECOIL SHOULDERS: _____ APPROVED: _____
CHAMBER: _____ APPROVED: _____
TEST: FUNCTION ONLY APPROVED: _____
COMPONENT CONDITION: (Damaged, Broken, Old Style) APPROVED: _____

COMPLAINT: FOLLOWS DOWN WHEN SAFETY IS PUSHED OFF.

INCIDENT: _____

COMMENTS: THE DIMENSION FROM THE TOP OF THE TRIGGER TO
CENTER OF TRIGGER PIN HOLE BEING .011 OVERSIZE
ELIMINATES MOST OF THE CLEARANCE NEEDED FOR THE
TRIGGER-CONNECTOR TO RETRACT WITH THE SAFETY ON

P.I. NO GUN EXAMINATION REPORT NUMBER: _____ MODEL: 700 ADL
 GENERAL CONDITION: NEW R #: 22730
 OUTSIDE WORK: NO DATE: 10-16-70
 FROM: LIVONIA, MICH.
 FIRED AMMO TYPE: _____ GUN #: 6278113
 & CONDITION: _____ CODE: _____
 PROOF: -R.E.P. INSP.: _____ TEST: _____
 HEADING: _____ GA./CAL.: 3006
 BREECH OPENING: _____ CHECKED BY: C. PROSSER
 RECOIL SHOULDERS: _____ APPROVED: _____
 CHAMBER: _____ APPROVED: _____
 TEST: FUNCTION ONLY APPROVED: _____
 COMPONENT CONDITION: (Damaged, Broken, Old Style) APPROVED: _____

CONNECTOR IS .005 UNDERSIZE ON ^{1.080}1.083 DIMENSION (TRIGGER CLEARANCE)

COMPLAINT: FOLLOWS DOWN

INCIDENT: _____

COMMENTS: CONNECTOR BEING TIGHT ON TRIGGER DID NOT RETRACT, ACTION WOULD NOT COCK. AS LONG AS THE CONNECTOR STAYED IN POSITION ON THE TRIGGER THE RIFLE WOULD WORK O.K.

P.I. NO GUN EXAMINATION REPORT NUMBER: _____ MODEL: 700
GENERAL CONDITION: GOOD R #: 21196
OUTSIDE WORK: SCOPE MOUNTED DATE: 10-2-70
FROM: DAVISON,
FIRED AMMO TYPE: — MICHIGAN
& CONDITION: _____ GUN #: 6216922
PROOF: R.E.P. INSP.: 9 TEST: 87 CODE: LS = 2/69
HEADING: O.K. GA./CAL.: 243 WIN.
BREECH OPENING: — CHECKED BY: _____
RECOIL SHOULDERS: — APPROVED: _____
CHAMBER: O.K. APPROVED: _____
TEST: NO APPROVED: _____
COMPONENT CONDITION: (Damaged, Broken, Old Style) APPROVED: _____

TRIGGER CONNECTOR BROKEN.

COMPLAINT: FIRING PIN FOLLOWS DOWN

INCIDENT: _____

COMMENTS: THE CONNECTOR BEING BROKEN, ENGAGEMENT
BETWEEN IT AND THE SEAR WAS UNLIKELY THEREFORE
THE FIRING PIN WAS FREE TO FOLLOW DOWN.

REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE

**"CONFINE YOUR LETTER TO ONE SUBJECT ONLY"**

XC: K. W. Augustine R. L. Joy
 S. D. Bennett M. J. Kantor
 L. R. Blackhurst H. C. Munson
 L. B. Bosquet C. O. Pardee
 H. K. Boyle D. F. Polley
 J. W. Brooks D. D. Ricci
 J. J. Burns D. I. Roark
 G. D. Campbell D. J. Sanita
 W. L. Ganey D. S. Valent
 B. H. Gilbert W. C. VanSickle
 M. C. Hardy L. G. Wilke
 P. G. Johnson

February 8, 1982

J. H. CARTER, G. E. FLETCHER, J. P. LINDE

M/700 FIRE CONTROL - REMOVE BOLT LOCK

MEETING HELD 2/8/82 TO REVIEW IMPLEMENTATION

BELOW IS AGREED UPON SCHEDULE

START DATE - FEBRUARY 26, 1982


A. Items needing completion to meet above date:

1. Process Record needed, new Part Numbers for components - Issue by 2/12/82. S. Bennett
J. Brooks
2. Push new safe arms thru production:
 - 9,700 in Stores, 3,000 of these issued 2/5/82. M. Kantor
 - 10,000 more to be sent to Vendor for clipping. S. Bennett
D. Ricci
 - Additional sent to Vendor for clipping as needed to meet schedule. M. Kantor
3. New instruction folders available. J. Carter
4. A quantity of 5,000 old style safe arms to be sent to Arms Service for use on customer guns. D. Roark
J. Carter
5. Old Instruction Folders - Gather up and dispose of. D. Roark
W. Ganey

M/700 FIRE CONTROL - REMOVE BOLT LOCK - Contd.

- B. On starting date, Final Assembly area will do the following:
1. All assembled guns, repairs included, will be torn down and a new Safe Arm will be assembled to the Fire Control.
 2. All guns packed on February 26, 1982 and thru March, will be stamped AC (March 82). This includes guns and packing labels.
 3. Mark gun labels "S".
 4. Guns must have modified Safe Arm and new instruction folder.
 5. Custom Gun Shop to use new Safe Arms in Fire Controls in guns from February 26th forward. New instruction folders must also be used.

by


G. J. Hill, Supervisor
Process Engineering
Current Products

GJH/cac

M/700 FIRE CONTROL CONVERSION - REMOVE BOLT LOCK

- Start Date - Beginning of March (February 26th)
- Push clipped arms thru process
- Process needed
- All assembled guns/in stocks - complete to warehouse - old instruction folders
- All assembled actions and fire control remove old safe arm, replace new safe arm
 - Perform any required tests
 - Send fire controls to Custom Repair
- Mark gun labels -
 - Insert new instruction folders
- How many old style safe arms to send to square stamping
- How many for Custom Repair.

GJH/cac

A handwritten signature, possibly reading 'GJH', is written below the typed name 'GJH/cac'.

REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE

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 G. D. Campbell D. J. Sanita
 W. L. Ganey D. S. Valent
 B. H. Gilbert W. C. VanSickle
 M. C. Hardy L. G. Wilke
 P. G. Johnson

February 17, 1982

J. H. CARTER, G. E. FLETCHER, J. P. LINDE

M/700 FIRE CONTROL - REMOVE BOLT LOCK

Review meeting held 2/17/82 to review implementation and
 review minutes of 2/8/82 meeting.

Starting Date: Feb. 26, 1982 - M/700 RH & LH

TBD - M/40X

TBD - M/600

1. Process Record - needed:

- Safety S. Bennett
- Assembly - Final Insp. R. Joy
- Gallery - QA J. Burns

To be issued by 2/26/82

2. New Safe Arms:

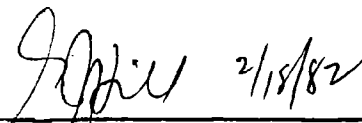
- 3,000 ready 2/19 D. Valent
- Additional scheduled by Planning

M/700 FIRE CONTROL - REMOVE BOLT LOCK - Contd.

3. New instruction folders available.
4. Old style safe arms and Trigger Housing Assemblies to be removed by production to Arms Service on 2/26/82. J. Carter
C. Pardee
5. Old instruction folders - Pick up on 2/26. Deliver to Arms Service. W. Ganey
W. VanSickle
6. New instruction folder needed for M/40X. J. Brooks

On 2/26/82, Final Assembly Area will do the following:

1. All assembled guns, repairs included, will be torn down and a new Safe Arm will be assembled to the Fire Control.
2. Check sear lift after new Safe Arm installed.
3. All guns packed on February 26, 1982 and thru March, will be stamped AC (March 82). This includes guns and packing labels.
4. Mark gun labels "S".
5. Guns must have modified Safe Arm and new instruction folder.
6. Custom Gun Shop to use new Safe Arms in Fire Controls in guns from February 26th forward. New instruction folders must also be used.

by  2/18/82
G. J. Hill, Supervisor
Process Engineering
Current Products

GJH/cac _

REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE



Xc:

*FILE
700 FIRE CONTROL*

C.F. Prosser
D.J. Anderson
J.W. Bower
K.R. Chadwick
J.P. Linde
A.A. Hugick
W.R. Googin - File

"CONFINE YOUR LETTER TO ONE SUBJECT ONLY"

Ilion, New York

November 24, 1975

SUBJECT: MODEL 700 SEAR LUBRICANT EVALUATION

Date Started November 12, 1975
Date Completed: November 19, 1975
Work Order: 90245

INTRODUCTION

Request received from C.F. Prosser to evaluate a possible substitute lubricant for the sear of the Model 700 fire control. Plant presently uses Moly-cote Dry Type "Z", and the new product is labeled Lifelube dry lubricant. Test to consist of cock and fire dry cycle at rate of 30 cycles per minute with trigger pull measurements every 500 cycles. Test to stop at 10,000 cycles. Two rifles were supplied for test: M/700, Serial No. A6223479 with current Moly-cote, and M/700, Serial No. A6210935 with new product on sear.

RESULTSA. Moly-cote Dry Type "Z" (current)

1. Trigger pull averages varied .70# during test. Neither failures to fire nor excessive wear were noticed.
2. Trigger pull at start: 4.65# -0- cycles
Trigger pull at finish: 5.35# 10,000 cycles
3. No breakages occurred during test.

B. Lifelube dry lubricant (possible substitute)

1. Trigger pull averages varied .70# during test.
No failures to fire were noticed.
2. Bolt cam surface experienced galling and had to be stoned at 7,500 cycles.

November 24, 1975

RESULTS Continued

B. 3. Trigger pull at start: 4.90# -0- cycles
Trigger pull at finish: 5.40# 10,000 cycles
4. No breakages occurred during test.

A.
JHHennings:T
Research Test Lab
Ilion Research Division

M-700 SERR LUBRICANT EVALUATION 11-19-75 J. Williams

K&E 10 X 10 TO THE INCH 46 0703
7 X 10 INCHES
KEUFFEL & ESSER CO. MADE IN U.S.A.

TESTED
CYCLES

