
From: Norton, Vince
Sent: Monday, March 23, 2009 10:04 AM
To: Boyles, Derek
Subject: FW: 301756 Trigger
Attachments: 301756 Trigger Rev F.PDF; 301756 Trigger Rev F.EDRW

I have revised the Trigger drawing to reflect an increase in the surface roughness allowable on the back edge of the sear engagement surface. Please forward to the appropriate personnel.
 VN

From: Goto, Gregory [mailto:ggoto1@pamtech.com]
Sent: Friday, March 20, 2009 5:49 PM
To: Boyles, Derek
Cc: Norton, Vince; Lauck, Dan
Subject: RE: 301756 Trigger

Derek,
 Per our phone discussion:
 Items 1-2 are OK
 Item 3 - Requirement on .079 face can be opened to a 64 microinch surface.
 Item 4 - Corner requirement can be relaxed to allow some radius. Value TBD. Pamtech will investigate corner condition in the tool, in the green state and the pre Tumble state to see if improvements can be made to the corner.
 Item 5 - Master to be built for 1.048 and .079 grind face dimensions. Pamtech to find source to build master gage.

Regards,
 Greg

From: Boyles, Derek [mailto:Derek.Boyles@remington.com]
Sent: Friday, February 13, 2009 10:44 AM
To: Goto, Gregory
Cc: Vicars, Gerald; Tipton, Don; Norton, Vince; James, Will
Subject: 301756 Trigger

Greg,

Here are the findings with respect to the triggers sent in ground and polished:

1. The surface finish at the top (1.048 from the hole) was well within the finish requirement of 16 RMS. The average was 2.5 Ra (2.7 RMS). The highest reported finish was 6.3.
2. The hole size fell within specification by way of pins and CMM inspection.
3. The surface finish on the side (.079 from the hole) did not meet the finish req't of 32 RMS. The average was 46.5 RMS. The highest reported value was 51.3. The additional concern here is the convergence of two distinctly different finishes and the likely ill effect on trigger function.
4. The edge where the two surfaces converge did not clean up on >50% of the parts submitted. Pictures are attached.
5. The 1.048 +/- .002 dimension does not meet the profile requirement. Results ranged from 1.0448 to 1.0461. Data is attached.

If you would like to discuss the results in a conference call, please let me know.

Regards,

Derek Boyles
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