

Bolt Action Maintenance Review

August 19, 2002
Elizabethtown, KY

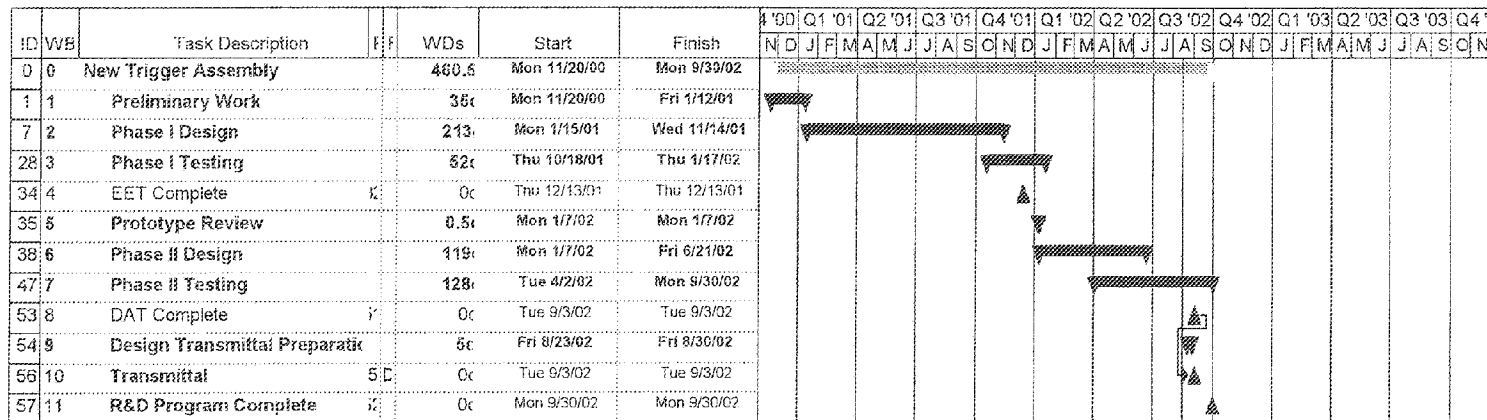
Agenda

- R&D Status & Schedule Ronkainen
- DAT Status Danner
- Manufacturing Status & Schedule Perniciaro
- Review Action Items Team
- Next Meeting Date Team

Project Status

- **Design complete**
- **Formal DAT Activity nearing Completion**
 - Corrosion Test Incomplete (Risk believed Low)
 - Target DAT Completion Date: 9/3/02 (or before)
 - Final Report Available: 9/30/02
- **Non-DAT Evaluation Activity**
 - Lubricant Variability Assessment
 - Test Activity Complete: 8/30/02
 - New MIM Firing Pin Head
 - Limited sample size SAAMI jar-off sensitivity test planned
 - Successful Performance is **not** a DAT exit requirement
 - Test Activity Complete: 8/21/02
- **Drawings being readied for transmittal**
 - Transmittal Target Date: 9/3/02 (or before)

Project Schedule



Key Dates

- EET Design Review with Manufacturing
- EET Complete
- EET Prototype Review and Design Selection
- Initial DAT Design Review with Manufacturing
- Final DAT Design Review with Manufacturing
- DAT Complete
- Final Design Transmittal

* Or earlier if DAT is complete

Original

4/20/01
10/3/01
9/27–10/5/01
11/1/01
12/17/01
4/17/02
4/18/02

Current

4/20/01
12/13/01
1/7/02
2/6/02
NA
9/3/02*
9/3/02*

Key DAT Activity

- **Component / Assembly Build and Inspection**
 - Extensive Component Dimensional Inspection
 - LARGE Sample size → 60 trigger assemblies
 - Repetitive Tracking of Trigger Pull, Engagement, and Blocker Adjustments
- **Full breadth of M/700 and Seven product lines**
 - 57 guns // 24 SKUs // 10 calibers plus ML
- **Jar, Drop, Rotation, and Slam Sensitivity**
 - 840 SAAMI Jar/Drop/Rotation Drops Completed
 - Over 1000 Extended SAAMI Jar/Drop/Rotation Drops Completed
 - Slam Test Completed
- **Endurance Testing:**
 - 53 guns = 500 rnds // 24 Guns = 1K rnds // 4 guns = 2K rnds
 - 42500 total endurance rounds fired
 - Dry Cycle (3 Firecontrols thru 10K cycles each)
- **Extensive environmental testing**
 - -20F through +120F including Thermal Cycling
 - Dust and Debris

Specifications / Process Limits

- **Engagement**
 - Current 0.018 – 0.020
 - New 0.019 – 0.021
 - Both User Adjustable
- **Trigger Pull**
 - Current 4.0 – 5.5 lbs.
 - New 3.5 – 5.5 lbs.
 - Both User Adjustable
- **Blocker**
 - Current Not Applicable
 - New 0.003 Max.
 - Not Adjustable by User
- **Overtravel**
 - Current 0.025 Max.
 - New Not Applicable
 - User Adjustable
- **Sear Lift**
 - Current 0.008 – 0.018
 - New 0.008 – 0.018
 - Not Adjustable by User

Issues /Action Items

- Coloring visible portion of Safety Arm black for black oxidized actions
- Adjustment limits and customer adjustability
- Manufacturing transition plan