

M600 & 700 TRIGGER ASSEMBLY IMPROVEMENTS

I. RESTORE COMMONALITY.

A. PARTS. SEAR SAFETY CAMS

1. .005" DIFFERENCE IN TAIL HEIGHT
2. .029" " " PIN CLEARANCE

B. DIMENSIONS. ESTABLISH COMMON SAFETY CAM LIFT. MUST BE DERIVED FROM & CONSISTENT WITH MODEL DRAWINGS.

C. SPECIFICATIONS.

1. SEAR LIFT.

- a. REVISE ON M600 TRIGGER ASS'T DRAWING TO ELIMINATE THEORETICAL GEOMETRIC POSSIBILITY OF TRAPPING CONNECTOR FORWARD OF SEAR.

- b. ADD ABOVE TO M700 TRIGGER ASS'T DRAWING.

2. "SCREW DRIVER" TEST SIGNIFICANCE. THIS IS CURRENTLY PART OF M700 FINAL INSPECTION PROCESS. IT IS NOT BEING DONE.

- a. DIMENSIONAL IMPLICATIONS AND/OR
- b. FUNCTIONAL IMPLICATIONS

M600 & 700 TRIGGER ASSEMBLY IMPROVEMENTS

II. ADJUSTMENTS. DEFINE PICTORIAL/GEOMETRICALLY, THE CORRECT AMOUNT (AND RANGE) OF TRIGGER OVERTRAVEL, M600 & 700, FOR COMPARATOR SETTING.

III. SAFETY ASSEMBLY

A. INCOMING PART INSPECTION OF SAFETY. ADD VIEWING HOLE TO M700. THIS WOULD ALLOW OPTICAL COMPARATOR PROJECTION INSPECTION OF SAFETY CAM GEOMETRY (SIMILAR TO M600).

B. SAFETY BUTTON CLEARANCE

1. MORE TO CLEAR BOLT PLUG

2. MORE TO CLEAR STOCK

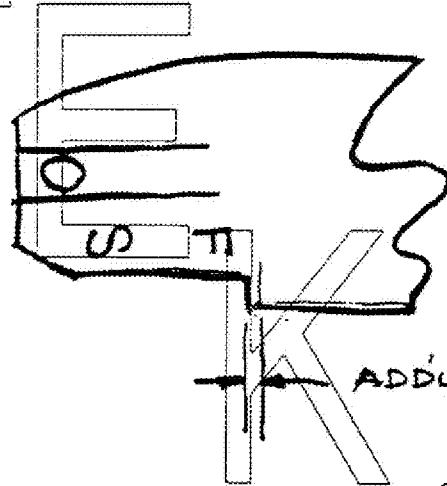
C. DEFINE: BEYOND-DETENT-POSITION STROKE REQUIREMENTS (IF ANY) IN ASSEMBLED GUN.

AL0014710

WOOD & TOOL TRIGGER ASSEMBLY IMPROVEMENTS

II. A.

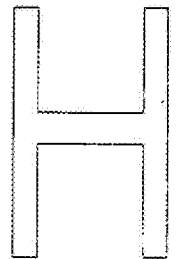
1. IF MOTION FORWARD OF "F" DETENT POSITION IS REQUIRED, THEN INVESTIGATE ADDITIONAL RECEIVER CLEARANCE. ASSEMBLERS ARE OFTEN NOW FILING RECEIVER TO PROVIDE THIS.



2. IF MOTION REARWARD OF "S" DETENT POSITION IS REQUIRED, THEN INVESTIGATE PRESENT INTERFERENCE(S). THIS IS NOW DIFFICULT TO ATTAIN.

IV. STOCK-RECEIVER RELATIONSHIP

- A. SEAR PIN. SHORTEN PIN TO ELIMINATE RIGHT END HITTING WOOD. LEFT END DRIVEN SLIGHTLY BELOW FLUSH WITH BOLT STOP SLOT TO ELIMINATE POSSIBILITY OF BINDING BOLT STOP.



M600 & 700 TRIGGER ASSEMBLY IMPROVEMENTS

V. B. ELIMINATE LEFT REAR SIDE RECEIVER PLUG SCREW - WOOD INTERFERENCE.

VI. LUBRICATION. "MOLYKOTE TYPE GN" PASTE IS PROPOSED FOR BOLT PLUG THREAD AND COCKING CAM LUBRICATION ON PRODUCTION. IT WOULD REPLACE PRESENT MoS_2 POWDER. MOLYKOTE SPECIFIES LOWER TEMPERATURE LIMIT OF 0°F . R&D HAS BEEN USED TO TEST (AND SUPPLIED WITH MAT'L) FOR ANY ADVERSE EFFECTS @ -20°F (SAR BIND DOWN, ETC.)

VII AUSTRALIAN GUNS. THESE ARE SUBJECTED TO UNUSUAL "SAFETY TESTS" & CUSTOMS.

A. PROVIDE PARTS LISTS FOR ALL AUSTRALIAN MODEL VARIATIONS; RIMFIRE, CENTERFIRE; SPORTING & TARGET.

AND/OR

B. DEFINE ALL CUSTOMS TESTS SO WE MAY DUPLICATE @ ILION

AND/OR

C. PROVIDE MODIFIED SPECIFICATIONS TO MEET CUSTOMS REQUIREMENTS.

6-14-79

P 5 OF 5

A
M600 & 700 TRIGGER ASSEMBLY IMPROVEMENTS

VII MISCELLANEOUS

- A. SAFETY SNAP WASHER- SAFETY DETENT SPRING RADIAL RELATIONSHIP: S.S.W. HAS BEEN OBSERVED TO ROTATE IN USE WITHIN OPENING AS PERMITTED BY SINGLE DIMPLE ON S.D.S. IF CLOSER RELATIONSHIP IS NEEDED, S.D.S. SHOULD HAVE SECOND DIMPLE.

E K S I C H

AL 0014713