

CC: H. J. Hackman  
~~S. M. Alvin~~  
M. H. Walker  
R. B. Hurley

Ilion, New York  
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*Design*  
*EB*

D. E. Miller

PILOT ASSEMBLY MODEL 700

In the assembly of ten (10) Model 700 "ADL" 30-06 Actions in slave stocks, the following conditions were found. The list does not include the riveted Extractor and possible change to a pinned Safety Button to safety which are being developed by Design.

1. Bolt Stop Release difficult to operate.

Action taken:

- a. New longer Bolt Stop Release. ✓

2. Bolt Stop bind in Receiver slot.

Action taken:

- a. New Bolt Stop Spring lengthened to increase tension and reduce side force.

3. Follow-down of the Firing Pin.

Action taken:

- a. Investigating the Sear and Safety Cam engagement with the Firing Pin Assembly. A grind change may be required.
- b. Investigate the warpage of the tail of the Receiver. A pilot lot of stress relieved Receivers are ready for finishing operations to determine if warpage can be reduced. This is being followed by Chem. & Met.
- c. Investigate the Housing hole dimensions in the Receiver and Housing.

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4. In the "ABL" Stock, there was a scoring of the first cartridge out of the Magazine.

Action taken:

- a. Increase the inletting cuts in the Stock.
  - b. Magazine Follower changed the ears; tests by Process Engineering indicated that the revision could cause spring catching. Work was held and the problem referred back to Research.
  - c. Smoother finish now specified on Receiver rails.
5. The length of the Trigger Adjusting Screw did not permit adequate staking.

Action taken:

- a. A longer screw is being provided. — *Tried to use old screw*
6. Soft Safety - reported by Sales.

Action taken:

- a. Chem. & Met. to experimental harden Housings to prevent breakdown of the Safety Detent Ball countersink.
  - b. Design is considering increasing the tension of the Safety Detent Spring.
  - c. As part of the XC-13 and XP-700 design, the use of a nylon instead of a steel ball is being investigated.
7. Accuracy testing required the use of a #7 sight step.

Action taken:

- a. Investigation of the Front Sight height.

  
H. J. Hackman, Supt.  
Product Eng. & Control Section

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