

March 4, 1963

M. H. WALKER

Weekly Progress Report
week ending Mar. 1-'63

Customer Complaints

D. E. SULLIS

1. M/725 .222 Rem. had a bent barrel and bad stock. Replaced action and stock.
2. M/700 7mm - complaint of tight chamber - checks out all right. Snelis jump out on feeding - staked him follow up and readjusted magazine. Accuracy was spot with 6 power Redfield scope and is well within specs.

Special Rifle Selection

Two rifles are now being worked on and being readied for Tom Frye:

1. .222 Rem. Mag. M/700 BDL
2. 6mm M/700 ADL

Sear and Safety Cam Assembly

This report is in letter form.

.22 Rim Fire Varmint : awaiting word for go ahead.

6mm Accuracy

1. Velocities were taken to determine load to use on accuracy.
2. 200 rounds have been prepared to load for Plant accuracy.

Actual 40.00

Photo sent to provide for Henry Bader - will be sent to a friend.

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2-Ounce TriggerP. J. SANZO

Parts needed for the 3 modified new 2 ounce trigger assemblies have not been completed as yet. A new sear lever should be back from heat treat Friday afternoon. The sear lever will be incorporated into an old assembly to see if 2 ounce is near obtainable.

It was found that a M/700 safety assembly could be used in our design but certain changes would have to be made: 1. Use a shortened safety cam in place of one of the Sear; 2. Cut the sear lever down to clear the safety cam and safety assembly; 3. A revised sear lever spring would be necessary. The M/700 Safety Assembly will be incorporated into the 3 trigger assemblies now being made up.

Remington Reloading ManualNICK DAM

I spoke with Harvey Bunn regarding cover material and cost. He recommended we get together with the Beaverite Company. I met with Mr. Holmes of that company and obtained full particulars regarding their covers; he gave me some color and material samples. He also promised to bring two free covers in 5-1/2 x 8-1/2 sheet size. These are to be flexible and semi-flexible in red and green. Available within the next two weeks.

M/11-'48 Recoil

Conducted function experiments using the 28° cones which were not tried before. Combination of 23° - 30° cones gave satisfactory results. I am getting reports of the experiments conducted years ago regarding recoil reduction so I won't duplicate previous experiments.

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High Pressure Rim FireNick Jim

Master patterns were returned to us from Gray-Syracuse, Inc. New drawings are being sent out to Hitchiner and Precision Casting, Inc.

M/415 Stan Safe RifleJOHN BROCKE

Two more rifles came in for refurbishing for the warehouse. We now have approximately 12 of these to update and put in new condition.

Stan Safe Rifle No. 122 was returned from field testing. It had 6000 rounds on it. Everything was in good condition; however, the receiver was still being cold worked by the bolt lug. Saw Kelly Chadwick and because of lack of time for another field test it was decided to heat treat receiver to a file hardness to stop cold work as much as possible. The trigger tube on this rifle had a small piece broken off one side of the working end. This did not interfere with the operation of the tool however. The take down screw was loose a couple of turns.

The Bear Block parts from Federal Short Run Stamping were received. They were returned to the vendor for reworking except for approximately 25 which we reworked here to keep our updating program going.

We are still waiting for stamp from vendor to mark "SAFE" on bolts.

Bullet Manufacture

A new lead core drawing punch has been received from the grinding room. We are waiting core sizer and bullet forming punches.

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Custom Shop.223 Pressure BarrelsPAUL GOGOL

Pressure barrel tolerances are being worked out. This required lapping the rifling plug down.

M/40X Center Fire Stocks

We should get some stocks by Tuesday, March 5th.

M/40X C.F. Barrels

The 6mm (30) and .222 (50) barrels have been rifled without Cuproline. These are in the process of being turned and ground.

Douglas Barrels

Barrels were checked and results of checking the ten barrels received:

1	.2239 groove diameter
1	.2245
1	.2244
7	.2240 - .2242

These barrels were lapped very lightly and it was noted that they open up very fast.

Pressure Barrel Tooling

All tooling should be ready this week.