

M. H. Walker

March 11, 1963

PROGRESS REPORT
Week Ending March 8, 1963

M/40X 2 OZ. TriggerBob Sanzo

A revised 2-ounce trigger has been completed. The trigger pull is about 2-1/2 ounces. This pull was obtained by adjustment only and not by the additional honing of connector and sear lever. A change to the sear and sear lever should eliminate the excessive sear lever travel.

Reloading ManualNick Dam

Approximate printing time and cover quotations were obtained. These quotations being approved, I started to write the first draft of the "written matter".

Sabot and Projectile

Broaches are hardened ready to be ground; expect the mold to be done by the end of this week.

High Pressure Rim Fire

Still waiting for quotations from Hitchiner and Precision Casting.

Model 700: ExtractorPete Hagen

Extractor for 222 caliber bolt head and body assembled, pinned and brazed. Will wait for production to change over to 222 Cal. to finish these bolts (6).

M/700 Strength Test

Had a new Receiver plug made. This is in heat treat.

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Plant AssistancePete Hagen

Checked gallery accuracy guns to determine poor accuracy. Barrels are larger at muzzle than at breech. Plant had some (3) barrels leaded; these checked out the same.

Checking parts to determine cause of complaint "shells pop out of magazine".

M/415 Stun Safe RifleJohn Brooks

Six rifles have been updated with the new sear block mechanism. Two have been repaired, and four have been refurbished rifles for the Park Forest warehouse with one going directly to a customer at the request of Sales. Several more will be ready for warehousing this week.

Stun Safe Rifles from all Armour & Company plants have arrived in Ilion. They will be checked and an estimate prepared and sent to C. W. Doerter on the cost to bring them back to new condition. This cost will be submitted to Armour & Company by Sales.

The SAFE stamp has been received from the vendor and 50 bolts are to be procured from in process to be stamped before finish machining and heat treat.

A complete set of the latest prints and parts sheets for the Stun Safe Rifle were prepared and sent to Park Forest per their request.

Bullet Manufacture

Core seating and bullet forming punches are in the grinding room.

A new feed system eliminating air operated cylinders has been developed for feeding cores to the die. The ejection system is now being developed to work in conjunction with the above feed system.

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CUSTOM SHOPPressure Barrels

223 Caliber, 12" twist, Pressure Barrels for Frankford Arsenal are in process. Bridgeport has also ordered six 223 caliber barrels, 14" twist, and these are ready for shipment but we have not received the formal order for them. No official order for the F.A. Barrels either.

Tooling on pressure barrels is not complete as was thought in previous report.

Model 40X

Stocks have been received.

Barrels (222 and 6mm) are in process. In the 6mm caliber we will be required to make 9", 10", and 12" twist in both light and heavy weight. Barrels are being rifled without Cuprodine.

The 4-groove 30 caliber rifling plug has been lapped and first test barrel appears to be in SAAMI specs on bore and groove. Pressures during rifling were same as for 6 groove. (no Cuprodine - standard steel barrel).

Primer Test

3 rifles are being shot today using our standard load and #42 and #92 primers. The bullets used are Hollidge. The next test rifles will be shot using bullets made by D. Bullis.

6mm Rem. : The four M/700 barrels were lapped to eliminate the tight breech. It is too difficult to do a proper job with the chamber in the barrel. The 4 rifles were shot but complete figures on accuracy are not available. There is some possibility that the bedding on these rifles is not correct. One rifle has no fore-end pressure on barrel. Barrel may be moved from side to side. Groups shot were 5" spread.

5-Shot M/40X - Preliminary work has been done on a standard M/40X Stock inletted for 5-shot. Appears to work out ok.