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Bridgeport, Connecticut
March 5, 1964

TO: GAIL EVANS
R. A. WILLIAMSON
S. M. ALVIS

FROM: L. D. COX

SUBJECT: MODEL 700, 760, and 742 RIFLE BARRELS

Proposed Modifications For Pinned-On Front Site Ramps In All Calibers

This will confirm the arrangements discussed among Sales, Research and Production to increase the muzzle diameter of Model 700, 742, and 760 barrels to accommodate pinned-on front site ramps on all calibers. At present, the only ones not pinned on are caliber 30-06 Springfield, 308 Winchester, 280 Remington, and 270 Winchester. The proposed change will both improve quality and lower cost. The accuracy will be better by eliminating heating of the last few inches of the muzzle. Costs will be lowered by making a machine to automatically assemble pinned on front site ramps economically justified.

Production wishes to get the change approved to make the conversion at the same time our 20 inch barrels are increased to 22 inches. This depends on Sales approving increasing the muzzle diameter of the Models 700, 742 and 760 to get adequate thread engagement for the pins on the ~~front~~ calibers. The calibers that will be affected are:

Calibers With Braised-On Front Site Ramps To Be Converted To Pinned-On.

✓ 270 Winchester	✓ 30-06 Springfield
✓ 280 Remington	✓ 308 Winchester
	✓ 35 Remington

Calibers Presently Supplied With Pinned-On Front Site Ramps.

222 Remington	6 mm Remington
222 Remington Magnum	243 Winchester
223 Remington	

The other calibers are not affected by the proposed change.

-2-

Though the muzzle diameter is adequate for the barrels now supplied with pinned on front site ramps, their diameter will also be increased to continue the common diameter we have now for manufacturing simplicity. Research has prepared or is preparing samples for Sales to see the extent of the change. These will include:

<u>MODEL</u>	<u>BARREL LENGTH</u>	<u>CALIBER</u>
700	24 inch	222 Remington
700	22 inch	30-06 Springfield
7420	18 1/2 inch	30-06 Springfield
742	22 inch	30-06 Springfield
760	22 inch	30-06 Springfield

In addition, samples of present production for comparison will be provided.

Gail Evans plans to be in Ilion late Monday, March 9, to see and approve these samples before the Operations Committee on Tuesday. Hopefully, he will feel that the change is small enough that only agreement between Sales, Research and Production is needed and that it need not take the Committee's time. Should this not be true, however, the late Monday discussion will let us be in position for any discussion that may be needed at Tuesday's Committee meeting.

I volunteered that Ilion Production and Research would be willing for the key people involved to be available after 4:30 if Mr. Evans should be late arriving. In addition to seeing the present and proposed rifles, he will be interested in knowing any new problems the gunsmiths may face with the pinned on front site ramps, such as removal or replacement due to breakage. These should not be any different than present pinned-on front site ramps.

By copy of this memo, I presume Ilion Production and Research Management will co-operatively develop and have available the samples and information we will need next Monday afternoon.

Please call me if you have any questions.

LDG:mau