

cc: R. A. Williamson  
 D. E. Geiss  
 W. J. Thresher ) In  
 E. B. Beattie, Jr. ) turn  
 E. B. Wallin  
 Ilion Change No. 7

Ilion, New York  
 May 16, 1969

P. H. BURDETT  
 Bridgeport, Conn.

MASTER PROJECT 81-00000  
Request for Change in 1969 Project Authorizations

<u>Project</u>	<u>1969 Budget</u>	<u>Change Letter Authorization</u>	<u>Requested Authorization Change</u>	<u>Proposed Authorization</u>
TD C-1450 Investigation of Bolt Unlocking Force - Center Fire Rifles (Improvement of Established Business - Arms Design - Center Fire)	-	-	\$20,000 (Increase)	\$20,000
TD E-0700 Investigation of Bolt Action Rifles Left Hand Action	\$ 5,000	-	\$ 5,000	-
TD E-0900 Barrel Development	\$10,000	-	10,000	-
Provision for Probables (Improvement of Established Business - Arms Design - General)	\$40,000	\$17,000	5,000	\$12,000
		Total	\$20,000 (Decrease)	

Problems have continued within the Plant on hard unlocking of center fire rifles, especially involving such calibers as 6mm and similar ones. Although the most recent was in the Model 783-6mm production, the Plant has reported the same difficulties being experienced with M/760, 700 and 660. Some of this has been traced to misalignments, lack of concentricity between bolt and chamber, distortion from heat treat, and other. Some relief has been experienced by free boring ahead of the chamber to reduce pressure without affecting accuracy and velocity. Further work needs to be done for investigating the condition in models other than the M/783. Also, results will be used to guide future designs.

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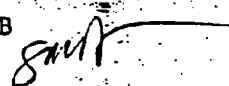
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Your approval of this letter will authorize reallocation of funds within the  
Ilion Research Budget for 1969 for this project.

G. M. Calhoun  
Director of Supporting Research

WEL:SMA:B



/s/ Philip H. Burdett 5/20/69

Approved

Date