

February 1, 1971

Mr. Mark Simenson  
899 Lincoln Avenue  
St. Paul, Minnesota 55105

Dear Mr. Simenson:

As a prelude to answering your questions concerning the conversion of your "Model 600 High-Power Carbine" to a Half-Bullpup --- as a matter of Company Policy, we do not recommend the altering of our products. However, we understand that this conversion has been successfully accomplished. The conversion should not be attempted unless you have a complete understanding of basic gunsmithing.

As you are aware, the Model 600 must be fitted with a Model XP-100 fire control assembly, which necessitates the use of a Model XP-100 recoil lug (barrel bracket) or the modification of the Model 600 barrel bracket. In either case, if the Fajen Laminated Half-Bullpup stock is used and the receiver and barrel bracket are properly glass-bedded, there should be sufficient strength in the area to withstand the recoil from this .243 Winchester cartridge.

The glass-bedding should extend from the rear tang of the receiver forward, completely around the barrel bracket and approximately 5/8 of an inch down the barrel until the barrel taper begins. The barrel forward of this point should be fully free-floated. To firmly seat the receiver into the bedding, as an aid in recoil absorption and vital to accuracy, the rear guard screw should be used. It is easiest to use a special long screw (8-36 N.P. - 2), but existing rear guard screw may be used in a very deep counterbore.

In using the XP-100 fire control assembly, the counterweight pin and spring (trigger balance assembly) must be used. The omission of the trigger balance would result in an unsafe rifle. The purpose of the trigger balance is to counteract the mass of the trigger link if the gun is dropped muzzle down --- to prevent accidental firing.

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Page 2

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For the greatest accuracy from your rifle, it is desirable to allow the barrel to vibrate freely without the restraint from a scope mount. However, if this mounting is solid, its effect will be fairly consistent and the rifle's accuracy will not be badly impaired. If the rifle is fired rapidly, the heating of the barrel will cause the point of impact to raise because the bridge type scope mount will not expand at the same rate as the barrel.

Very truly yours,

James C. Hutton  
Design Engineer  
Ilion Research Division

JCH:sp