

Franz, Scott

From: Franz, Scott
Sent: Wednesday, June 04, 2003 3:46 PM
To: Reesor, Phillip K.
Subject: RE: M710 Mag. Project Summary

Let's wait until next weeks meeting before we order anything. Wouldn't hurt to check warehouse inventory position on both calibers in the interim.

-----Original Message-----

From: Reesor, Phillip K.
Sent: Wednesday, June 04, 2003
To: Snedeker, Jim; Franz, Scott
Subject: FW: M710 Mag. Project

Just a reminder of the ammo we

-----Original Message-----

From: Reesor, Phillip K.
Sent: Tuesday, March 25, 2003 1
To: Franz, Scott
Cc: Snedeker, Jim
Subject: RE: M710 Mag. Project

Ammo in stock & available for t
 11949.

-----Original Message-----

From: Franz, Scott
Sent: Monday, March 24, 2003 3:3
To: Reesor, Phillip K.
Subject: FW: M710 Mag. Project

A heads up. Note Dale's comment
 to check ammo inventory and get

Let me know if there are any iss

Scott

-----Original Message-----

From: Danner, Dale
Sent: Monday, March 24, 2003 2:33 PM
To: Urbon, James E; Franz, Scott; Golemboski, Matt R.; Snedeker, Jim
Subject: FW: M710 Mag. Project Summary

Matt -- Timeline works for Etown. . . . We will fold it in as quickly
 as possible in parallel with the 504 if need be. . .

Scott / Jim U. / Jim S. -- Per attached timeline we need to be ready to
 restart DAT on the M/710 Magnum product once the headspace issues has
 been demonstrated resolved. . . . Please plan for a quick strain gauge
 test like we did during the first trial -- and assuming that passes lets
 be ready to execute the DAT plan immediately afterward. . . . Have we
 returned the original 710 Magnum DAT product to Mayfield yet ?? If
 not, lets get the actions sent back for "re-barreling". Also, please
 check for ammo availability for the DAT (both 7mmRemMag and 300WinMag).
 Dale

ET28239

Franz, Scott

From: Franz, Scott
Sent: Wednesday, June 04, 2003 3:46 PM
To: Reesor, Phillip K.
Subject: RE: M710 Mag. Project Summary

Let's wait until next weeks meeting before we order anything. Wouldn't hurt to check warehouse inventory position on both calibers in the interim.

-----Original Message-----

From: Reesor, Phillip K.
 Sent: Wednesday, June 04, 2003 3:44 PM
 To: Snedeker, Jim; Franz, Scott
 Subject: FW: M710 Mag. Project Summary

Just a reminder of the ammo we have in stock "see below message".

-----Original Message-----

From: Reesor, Phillip K.
 Sent: Tuesday, March 25, 2003 1:04 PM
 To: Franz, Scott
 Cc: Snedeker, Jim
 Subject: RE: M710 Mag. Project Summary

Ammo in stock & available for this testing is; 7mm RM 2562, 300 WM 11949.

-----Original Message-----

From: Franz, Scott
 Sent: Monday, March 24, 2003 3:34 PM
 To: Reesor, Phillip K.
 Subject: FW: M710 Mag. Project Summary

A heads up. Note Dale's comment on 710 Magnum DAT guns and ammo. Need to check ammo inventory and get guns to Mayfield if we still have them.

Let me know if there are any issues.

Scott

-----Original Message-----

From: Danner, Dale
 Sent: Monday, March 24, 2003 2:33 PM
 To: Urbon, James E; Franz, Scott; Golemboski, Matt R.; Snedeker, Jim
 Subject: FW: M710 Mag. Project Summary

Matt -- Timeline works for Etown. . . . We will fold it in as quickly as possible in parallel with the 504 if need be. . .

Scott / Jim U. / Jim S. -- Per attached timeline we need to be ready to restart DAT on the M/710 Magnum product once the headspace issues has been demonstrated resolved. . . . Please plan for a quick strain gauge test like we did during the first trial -- and assuming that passes lets be ready to execute the DAT plan immediately afterward. . . . Have we returned the original 710 Magnum DAT product to Mayfield yet ?? If not, lets get the actions sent back for "re-barreling". Also, please check for ammo availability for the DAT (both 7mmRemMag and 300WinMag).
 Dale

ET28240

-----Original Message-----

From: Golemboski, Matt R.
Sent: Friday, March 21, 2003 1:31 PM
To: Diaz, Danny; Danner, Dale; Trull, John
Cc: Cahan, Paul L.; Bristol II, Ronald H
Subject: FW: M710 Mag. Project Summary

Please review the attached M710 magnum barrel project summary and timeline.

Matt

-----Original Message-----

From: Riley, Gary D.
Sent: Wednesday, March 19, 2003 1:43 PM
To: Golemboski, Matt R.; Thweatt, Ed T.
Subject: M710 Mag. Project Summary

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Franz, Scott

From: Franz, Scott
Sent: Friday, June 06, 2003 11:49 AM
To: Thweatt, Ed T.; Riley, Gary D.; Keeney, Mike
Cc: Golemboski, Matt R.; Urbon, James E; Diaz, Danny; Snedeker, Jim; Reesor, Phillip K.
Subject: HT Barrel Blank Dimensions-6June03.xls



HT Barrel Blank
Dimensions-6Ju...

The attached file contains the measurements taken on the 10 additional E-town heat treated barrel blanks and then the three Ilion processed blanks. The blanks were cut in two and then a small section was cut from one side of the blank, mounted and polished for the groove width measurements, which were taken on the microVu. The Bore and Groove diameters and locations were taken using our CMM, .150" in from the cut off end. Note that the X location and Y location measurements collectively give a measure of the concentricity of the id to the od at the point of measure. One of the Ilion processed blanks measured more than .030" out on concentricity. This is highlighted in red. In summary it looks like both groups of barrels are similar. Looks like the Groove diameter may be slightly undersize on the Ilion blanks however. I'll let you draw your own conclusions. Please call if you have any questions.

Scott

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June 6th, 2003
Measured by J. Carson

Sample		1	2	3	4	5	6	7	8	9	10	Avg.	S.D.
Bore (CMM)	X Location	0.3002	0.3002	0.3002	0.3002	0.3002	0.3002	0.3002	0.3002	0.3002	0.3002		
	Y Location	0.3002	0.3002	0.3002	0.3002	0.3002	0.3002	0.3002	0.3002	0.3002	0.3002		
	Diameter	0.3000	0.3000	0.3000	0.3000	0.3000	0.3000	0.3000	0.3000	0.3000	0.3000	0.3001	0.0002
Groove (CMM)	X Location	0.3074	0.3074	0.3074	0.3074	0.3074	0.3074	0.3074	0.3074	0.3074	0.3074		
	Y Location	0.3074	0.3074	0.3074	0.3074	0.3074	0.3074	0.3074	0.3074	0.3074	0.3074		
	Diameter	0.3083	0.3083	0.3083	0.3083	0.3083	0.3083	0.3083	0.3083	0.3083	0.3083	0.3083	0.0001
Groove Width (MicroVu)	Groove 1	0.1105	0.1105	0.1105	0.1105	0.1105	0.1105	0.1105	0.1105	0.1105	0.1105	0.1105	0.0009
	Groove 2	0.1102	0.1102	0.1102	0.1102	0.1102	0.1102	0.1102	0.1102	0.1102	0.1102	0.1102	0.0008
	Groove 3	0.1102	0.1102	0.1102	0.1102	0.1102	0.1102	0.1102	0.1102	0.1102	0.1102	0.1102	0.0010
	Groove 4	0.1104	0.1104	0.1104	0.1104	0.1104	0.1104	0.1104	0.1104	0.1104	0.1104	0.1104	0.0006
	Groove 5	0.1104	0.1104	0.1104	0.1104	0.1104	0.1104	0.1104	0.1104	0.1104	0.1104	0.1104	0.0007
	Groove 6	0.1103	0.1103	0.1103	0.1103	0.1103	0.1103	0.1103	0.1103	0.1103	0.1103	0.1103	0.0008
		0.1103	0.1103	0.1103	0.1103	0.1103	0.1103	0.1103	0.1103	0.1103	0.1103	0.1103	0.0008

Note: Bore and Groove locations are relative to barrel blank O.D.
Parts were not referenced rotationally, during measurement.

Barrel specifications per Remington chamber drawing B-506.

Bore Diameter 0.300 - 0.301
Groove Diameter 0.308 - 0.309
Groove Width 0.115 - 0.120

Barrel specifications per SAAMI chamber drawing 11-300.34

Bore Diameter 0.300 - 0.302
Groove Diameter 0.308 - 0.310
Groove Width 0.110 - 0.112

1000 Processed Barrel Blanks					A	B	C	Avg.	S.D.
					-0.0128	0.0077	-0.0142		
					-0.0133	-0.0002			
					0.3000	0.2998	0.2995	0.2997	0.0002
					-0.0128	0.0077	-0.0140		
					-0.0133	-0.0001			
					0.3074	0.3074	0.3072	0.3074	0.0001
					0.1115	0.1111	0.1113	0.1113	0.0002
					0.1107	0.1108	0.1122	0.1112	0.0008
					0.1101	0.1109	0.1102	0.1104	0.0004
					0.1107	0.1108	0.1113	0.1109	0.0003
					0.1098	0.1120	0.1107	0.1108	0.0011
					0.1115	0.1106	0.1110	0.1110	0.0005
								0.1110	

Franz, Scott

From: Urbon, James E
Sent: Thursday, June 05, 2003 3:59 PM
To: Thweatt, Ed T.; Riley, Gary D.; Keeney, Mike; Franz, Scott
Cc: Diaz, Danny; Golemboski, Matt R.
Subject: Ilion heat treated M/710 barrel microhardness.

I have completed the microhardness evaluation of the three Ilion heat treated barrels that were sent to us here in Elizabethtown. I ran my microhardness indents in a comparable layout to the previous barrels measured. I found the average hardness of the Ilion heat treated barrel to be HRc 24.6. This is 3 HRc points harder than the e-town heat treated barrels that were measured last week at an average hardness of HRc 21.5. This hardness increase will result in a barrel that is stronger than the e-town barrel and should not pose a problem for chamber growth; however, this could effect manufacturing.

If any one has any questions regarding the hardness data please let me know this afternoon. I will be out of the office tomorrow. The lab is finishing the dimensional inspection and Scott will forward all of the data to everyone tomorrow.

Thanks,
Jim

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