

FINISHED PRODUCT DEFECT INDEX
QUALITY CONTROL OFFICE

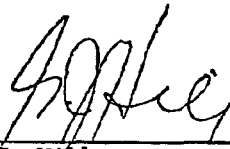
J. R. SWEDEKOR

August 27, 1975

FINISHED PRODUCT DEFECT INDEX

This booklet contains a list of typical
demerit items used by Quality Audit.

Please use as a reference for your
areas.



G. J. Hill
Supervisor Quality Control

GJH/kmk

DATES A REASONS FOR REVISIONS

4/2/75 - Revised - CAK/bdm

DESCRIPTIVE INFORMATION

Finished Product Defect Index - Classification & Demerit Values

<u>I. Demerit Value</u>	<u>Definition</u>	<u>Examples</u>	<u>Model</u>
100	1. Safety hazard	Bbl. bracket separated from Barrel.	M/600, 700
	2. Product inoperable	Bbl. lug separated from bbl.	M/742, 760
	3. Proof mark missing on Bbl.	Bbl. separated from bbl. guide ring.	M/870
		Barrel separated from bbl. gas cylinder.	M/1100
		Broken firing pin.	All models
		Cracked extension.	M/11-48, 742, 760
		Fires on safe.	All models
		Fires when closing.	All models
		Jars off.	All models
		Action jams on live round	All models

PART NAME Finished Product Defect Index SOLANT SET UP MODEL No. All models OPER. No. TIME

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DESCRIPTIVE INFORMATION

Finished Product Defect Index - Classification & Demerit Values

II. <u>Demerit Value</u>	<u>Definition</u>	<u>Examples</u>	<u>Model</u>
50	1. Intermittently fails to function causing inconvenience in operation.	Action binds (major)	All models
		Action jam.	All models
	2. Repeating firearm only functions as a single shot.	Bar lock out of position	M/870, 760, 572
		Bolt stems shell in mag.	All box mag. rifles
	3. Defects in components present imminent functional failure.	Can't load magazine	All models
		Carrier catches.	All tubular magazine firearms
	4. Foreign material in action makes product inoperable.	Doesn't blow back.	All autoloaders
		Doesn't feed back.	M/1100, 11-48, 870, 552, 572, N/66
		Doesn't feed up.	All models
		Doesn't lock back.	M/11-48, 1100
		Doesn't lock open.	M/1100, 11-48, 742
		Doesn't lock up.	M/1100, 11-48, 742, 760, 572, 870
		Drops shells.	All models

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Finished Product Defect Index - Classification & Demerit Values

II. Demerit Value	Definition	Examples	Model
50 (cont.)		Fails to connect.	All models
		Fails to extract - ejects. part time.	All models
		Fails to feed from mag.	M/1100, 11-48, 870, 552, 572, N/66, N/10C
		Fails to fire.	All models
		Hammer follows down.	All models
		Interceptor latch catches on head of shell.	M/1100
		Jumps cartridge stop	M/552, 572, N/66
		Mag. follower sticks.	All tubular mag. firearms
		Ext. Max. or Ext. Min. header	All models
		Outer mag. tube pulls out	M/552, 572, N/66, 582
		Over rides	All repeating rifles except M/742
		Shells jam in mag.	M/700, 600, 742, 760

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 11/2/75 - Revised - CAR/bdm

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II. <u>Demerit Value</u>	<u>Definition</u>	<u>Examples</u>	<u>Model</u>
50 (cont.)		Shells jump carrier latch	All tubular magazine firearms
		Shells jump magazine	M/700, 600, 742, 760
		Shells stem chamber	All models
		Shells tip down	All models
		Shells tip up	M/552, 572
		Stems incline	M/742, 760, 700, 600, 788
		Stems port	M/552, 572, N/66
		Stem over rides	M/742, 760, 700, 600
		Won't close up	M/552, N/66

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Finished Product Defect Index - Classification & Demerit Items

III. Demerit Value	Definition	Examples	Model
10	1. Visual, dimensional or adjustment defects presenting potential functional failures.	<u>A. Barrel Assembly</u> Barrel doesn't seat at front of Stock.	M/700, 500 Series, 788
	2. Major damaged or objectionable visual, dimensional or adjustment items - not presenting potential functional failures.	Barrel extension loose. Barrel lays off center. Barrel loose in Receiver. Barrel marred. Bead flat. Bore oversize. Bore pitted. Bore undersize. Burr on edge of chamber. Cases swell under rim. Chamber rough.	M/11-48, 742, 760 M/600, 700, 500 Series, 788 M/500 Series All models M/1100, 11-48, 870, 552, 572 All models All models All models All models All centerfire and rimfire rifles All models

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III. Demerit Value	Definition	Examples	Model
10 (cont.)		<u>A. Barrel Assembly - (cont)</u>	
		Crooked Barrel.	All models
		Ejector only partially brazed to Barrel.	M/1100, 11-48
		Ejector spring broken.	M/870
		Ejector spring loose.	M/870
		Flat crown on Barrel.	All models
		Front sight crooked.	All models
		Front sight ivory bead broken	M/1100, 11-48, 870
		Front sight damaged.	All models
		Front sight loose.	All centerfire and rimfire, 1100 Deer Gun, 11-48 Brushmaster
		Front sight marred.	All centerfire and rimfire, 1100 Deer Gun, 11-48 Brushmaster
		Front sight not fitted properly.	M/552, 572, all center-fire.

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III. <u>Demerit Values</u>	<u>Definition</u>	<u>Examples</u>	<u>Model</u>
10 (cont.)		<u>A. Barrel Assembly (cont.)</u>	
		Front sight ramp marred.	All centerfire, 1100 Deer Gun, 11-48 Brushmaster
		Front sight screw loose.	All centerfire, 1100 Deer Gun, 11-48 Brushmaster
		Front sight screw missing.	All centerfire, 1100 Deer Gun, 11-48 Brushmaster
		Gas cylinder miscut.	M/1100
		Inclusion in bore.	All models
		Incorrect front sight.	All centerfire and rimfire
		Last shell shaves lead.	M/600, 700
		Light roll on Barrel.	All models.
		Lock notch on extension damaged.	M/1100, 11-48, 870

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Finished Product Defect Index - Classification & Demerit Values

III. Demerit Values	Definition	Examples	Model
10 (cont.)		<u>A. Barrel Assembly (cont.)</u>	
		Matting light on vent rib	M/1100, 11-48, 870, 600
		Nick in chamber.	All models
		Poor finish on Barrel.	All models
		Poor grind on Barrel.	All models
		Poor polish on Barrel.	All models
		Rear sight screw & step. missing.	All centerfire and rimfire, 1100 Deer Gun, 11-48 Brushmaster
		Rear Sight elevating screw not functioning properly.	All centerfire and rimfire, 1100 Deer Gun, 11-48 Brushmaster
		Rear sight elevating screw loose.	All centerfire and rimfire, 1100 Deer Gun, 11-48 Brushmaster
		Rear sight tips left/right.	All models
		Rings in bore.	All models
		Rings in cone angle of Barrel guide ring.	M/11-48

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III. Demerit Value	Definition	Examples	Model
10 (cont.)		A. Barrel Assembly (cont.)	
		Rings in cone angle of gas cylinder.	M/1100
		Ripples on Barrel.	All models
		Scant choke.	M/1100, 11-48, 870
		Scratch in bore.	All models
		Seam in Barrel.	All models
		Step in chamber.	All models
		Tear in bore.	All models
		Tear in chamber.	All models
		Test stamp missing	All models
		Vent rib marred	M/1100, 870, 11-48, 600
		Void in Barrel bracket	M/11-48, 870
		Wavy bore	All models
		Wrong choke	M/1100, 11-48, 870

VISUALLY OBJECTIONABLE

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Finished Product Defect Index - Classification & Demerit Values

III. Demerit Value	Definition	Examples	Model
10 (cont.)		<u>B. Breech Bolt Assembly</u>	
		Bolt binds	M/600, 700, 500 Series, 788
		Bolt binds on front trigger guard screw	M/600, 700
		Bolt catches moving forward	M/600, 700, 500 Series, 788
		Bolt closes hard	M/600, 700, 500 Series, 788
		Bolt fails to lock with safe on	M/600, 700
		Bolt pulls out	M/600, 700, 500 Series, 788
		Bolt numbered incorrectly	M/600, 700
		Bolt release binds	M/600, 700, 788
		Bolt return plunger loose	M/1100
		Bolt sleeve cracked	M/500 Series
		Bolt stop pin loose	M/600, 700

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III. Demerit Value	Definition	Examples	Model
10 (cont.)		<u>B. Breech Bolt Assembly (cont.)</u>	
		Bolt stop won't depress full stroke	M/600, 700
		Bolt won't close over full magazine.	M/600, 700, 788
		Braze test missing on bolt handle.	M/600, 700
		Burr at firing pin hole.	All models
		Burr on extractor.	All models
		Burr on face of bolt.	All models
		Can't remove bolt.	M/700, 600, 500 Series, 788
		Closes hard over rim.	All models
		Concaves shell heads	M/1100, 11-48, 870
		Corner of slide broken	M/1100, 11-48, 870
		Ejector binds	All centerfire rifles
		Extractor drops shells (minor)	M/500 Series

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III. Demerit Value	Definition	Examples	Model
10 (cont.)		<u>B. Breech Bolt Assembly (cont.)</u>	
		Extractor loose.	All centerfire & shotgun
		Wrong extractor	Shotgun
		Feeds hard under extractor	M/500 Series
		Firing pin hits face of Barrel	All rimfire
		Firing pin point flat	All centerfire & shotgun
		Firing pin protrusion over max.	All models
		Firing pin protrusion under min.	All models
		Firing pin point sharp.	All shotgun & centerfire
		Firing pin retracting spring missing.	M/1100, 11-48, 742
		Left extractor loose.	All centerfire & rimfire
		Magnaflux mark missing on bolt.	M/600, 700
		Nib on firing pin point	All centerfire & shotgun

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<u>III. Demerit Value</u>	<u>Definition</u>	<u>Examples</u>	<u>Model</u>
10 (cont.)		<u>B. Breech Bolt Assembly (cont.)</u>	
		No tension on extractor	All models
		Operating handle detent missing.	M/1100, 11-48
		Operating handle retaining pin missing/high.	M/742
		Poor ejection.	M/600, 700
		Poor filing on bolt.	M/600, 700
		Proof mark missing on bolt.	M/600, 700, 870
		Slide block buffer loose.	M/1100
		Slide broken.	M/1100, 11-48, 870
		Wrong ejector (i.e. 222 in 35 Cal.)	M/600, 700
		Wrong locking block	M/1100, 11-48, 870
		Plate peeling	All shotguns

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Finished Product Defect Index - Classification & Demerit Values

III. Demerit Value	Definition	Examples	Model
10 (cont.)		<u>C. Final Assembly</u>	
		Action binds (minor)	All models
		Action opens hard	All models
		Action opens hard on fired shells	M/600, 700, 760, 572, 870
		Caliber marking missing on magazine box	M/742, 760, 600, 700
		Code and/or final stamps missing	Any model
		Excessive wood or steel margin.	Any model
		Magazine box bent	M/600, 700, 742, 760, N/10C
		Operating handle hits Fore End (severe)	M/552
		Rear lip of magazine box damaged	M/600, 700, 742, 760
		Shells load hard in magazine	M/600, 700, 742, 760, N/10C

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<u>III. Demerit Value</u>	<u>Definition</u>	<u>Examples</u>	<u>Model</u>
10 (cont.)		<u>C. Final Assembly (cont.)</u>	
		Take down screw doesn't hold.	M/600, 700, 500 Series
		Trigger plate removes hard.	M/1100, 11-48, 870, 742, 760, 552, 572
		Wrong fire control.	M/1100, 11-48, 870, 742, 760, 552, 572
		Wrong magazine box	M/600, 700, 742, 760,
		Wrong magazine lock	M/600, 700, 742, 760, N/10C
		Wrong stock (grade)	All models
		Wrong ticket (i.e. carbine on regular)	All models

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III. Demerit Value	Definition	Examples	Model
10 (cont.)		<u>D. Fire Control Assembly</u>	
		Action bar lock binds	M/870, 572, 760
		Action bar lock doesn't hold.	M/870, 572, 760
		Action bar lock doesn't release.	M/870, 572, 760,
		Action bar lock spring broken.	M/870, 572, 760
		Broken lug on trigger plate.	M/1100, 11-48, 870, 742, 760, 572, 552
		Carrier dog cracked.	M/1100, 11-48, 870
		Carrier release broken.	M/1100
		Carrier release slips off latch.	M/1100
		Carrier tab catches on Receiver.	M/1100
		Disconnecter binds.	M/742, 552, N/66, 11-48, 1100
		Disconnecter loose.	M/742, 552, N/66, 11-48 1100

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III. Demerit Values	Definition	Examples	Model
10 (cont.)		<u>D. Fire Control Assembly (cont.)</u>	
		Disconnecter spring broken	M/742
		Double click in trigger	All models
		Excess play at action bar lock and disconnecter left	M/870, 572, 760
		Excessive opening at disconnecter and connector left	M/742, 552, 11-48, 1100
		Excess play at trigger and bushing	M/1100, 11-48, 870, 742 760, 572, 552
		Hammer pin loose	M/1100, 11-48, 870, 552 742, 760
		Hammer pin shifted	M/1100, 11-48, 870, 572 552, 742, 760
		Hammer plunger slips by action bar lock	M/870, 572, 760
		Heavy trigger pull	Any model
		Less than .030 play at disconnecter and connector left	M/742-760 - .020, 552, 11-48, 1100, 870, 572

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Finished Product Index - Classification & Demerit Values

<u>III. Demerit Value</u>	<u>Definition</u>	<u>Examples</u>	<u>Model</u>
10 (cont.)		<u>D. Fire Control Assembly (cont.)</u>	
		Long carrier	M/1100, 11-48, 870, 552, 572
		Light trigger pull	All models
		Long trigger pull	All models
		No clearance at action bar lock and connector left	M/870, 572
		No trigger play at bushing	All models
		Poor finish on trigger guard.	All models
		Poor staking on action tube cap.	M/760
		Reinforcing ribs on carrier tab missing.	M/1100
		Safe binds	All models
		Safe goes on after firing	M/500 Series
		Safe not adjusted properly	M/700, 600, 500 Series
		Scant red on safety	M/500 Series, N/66, N/10, 1100, 870, 742, 760

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III. <u>Demerit Value</u>	<u>Definition</u>	<u>Examples</u>	<u>Model</u>
		<u>D. Fire Control Assembly (cont.)</u>	
		Sear case screw not staked properly	M/1100, 11-48, 870, 742, 760.
		Sear spring out of position	M/600, 700
		Sharp burr on trigger guard	All models
		Step in sear notch	All models
		Striations missing on safe	All models
		Trigger adjusting screws not sealed	M/600, 700, 788
		Trigger guard cracked	All models
		Trigger pin loose	All models
		Trigger pull creepy	All models
		Won't cock with safety on	All models

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Finished Product Defect Index - Classification & Demerit Values - (cont.)

III. Demerit Value	Definition	Examples	Model
		<u>D. Fire Control Assembly (cont.)</u>	
		Carrier peeling	M/1100, 11-48, 870
		Trigger plate pin bushing broken	M/1100, 870, 11-48, 742, 760, 552, 572
		<u>E. Fore End Assembly</u>	
		Checkering on Fore End light.	M/11-48, 1100, 870, 742, 760, 552 BDL, 572 BDL

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<u>III. Demerit Value</u>	<u>Definition</u>	<u>Examples</u>	<u>Model</u>
10 (cont.)		<u>E. Fore End Assembly - (cont.)</u>	
		Checkering off center	M/1100, 11-48, 870, 742, 760, 552 BDL, 572 BDL
		Checkering missing	M/1100, 11-48, 870, 742, 760, 552 BDL, 572 BDL
		Excess fill on Fore End	M/1100, 11-48, 870, 742, 760, 552, 572
		Excess lacquer	M/552, 572, 742, 760
		Excess RK-W	M/1100, 11-48, 870, 742 BDL, 760 BDL, 572 BD 552 BDL
		Excess stain	All models except N/66, N/10C
		Fore End bushing not staked properly	M/742
		Fore End checked	All models except 600, 700, 788, 552, 500 Series N/66, 10C
		Fore End checkering burned	All models except 600, 700, 788, 552, 500 Series N/66, N/10C

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Finished Product Defect Index - Classification & Demerit Values

III. Demerit Value	Definition	Examples	Model
10 (cont.)		<u>L. Fore End Assembly (cont.)</u>	
		Fore End checkering run out	All models except 600, 700, 788, 552, 500 Serie N/66, N/10C
		Fore End chipped	All models except 600, 700, 788, 552, 500 Serie N/66, N/10C
		Fore End detent missing	M/1100, 11-48, add to Barrel
		Fore End grooves damaged	M/572
		Fore End hanger split	M/552, 572
		Fore End hits Barrel guide ring	M/870
		Fore End loose on tube	M/1100, 11-48, 552, 742, 870
		Fore End rubs Receiver	M/870, 760, 572
		Fore End split	All models except 600, 700, 788, 500 Series, N/66, N/10C
		Fore End spring broken	M/742

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III. Demerit Value	Definition	Examples	Model
10 (cont.)		<u>E. Fore End Assembly (cont.)</u>	
		Fore End support block loose	M/1100
		Fore End support out of position	M/1100, 552
		No border on checkering	Any Fore End with checkering
		Open grain in Fore End	All models
		Poor checkering on Fore End	Any Fore End with checkering
		Poor finish on Fore End	M/1100, 11-48, 870, 572, 552, 742, 760
		Poor repair on Fore End	M/1100, 11-48, 870, 572, 552, 742, 760
		Poor sanding on Fore End	M/1100, 11-48, 870, 572, 552, 742, 760
		Vertical grooves in Fore End mutilated and run out.	M/572

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DESCRIPTIVE INFORMATION

Finished Product Defect Index - Classification & Demerit Value - (cont.)

III. <u>Demerit Value</u>	<u>Definition</u>	<u>Examples</u>	<u>Model</u>
10 (cont.)		<u>F. Receiver Assembly</u>	
		Action spring follower bent.	M/11-48
		Bearing plate missing.	M/742, 760, & all shotguns
		Can't remove inner magazine tube.	M/552, 572, 500 series, N/66
		Chamfer missing on recoil spring.	M/11-48
		Deflector loose.	M/552
		Dent in Receiver.	M/1100, 11-48, 870, 742, 760, 552, 572
		Ejector brazed out of pos.	M/11-48
		Ejector chipped.	Any model
		Ejector port cover broken.	M/742, 760
		Ejector screws not staked.	500 series
		Ejector screws staked out of position.	500 series

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DESCRIPTIVE INFORMATION

Finished Product Defect Index - Classification & Demerit Values - (cont.)

III. Demerit Value	Definition	Examples	Model
10 - cont.		<u>F. Receiver Assembly - (cont.)</u>	
		Ejector spring loose.	M/870
		Fiber washer loose in action tube.	M/760
		Gas hole in Rec plugged.	M/600, 700
		Mag. follower out of pos.	M/552, 572, 500 series N66
		Mag. tube cracked.	M/552, 572, 500 series N66
		Mag. tube damaged.	M/552, 572, 500 series N66
		Mag. tube marred.	M/552, 572, 500 series N66
		Mag. spring buckled.	M/1100, 11-48, 870, 552, 572, N66
		Mag. feed plug doesn't feed back.	M/1100, 11-48, 870
		Min. feed plug jumps magazine latch.	M/1100, 11-48, 870, 552, 572, 500 series, N66

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DESCRIPTIVE INFORMATION

Finished Product Defect Index - Classification & Demerit Values - (cont.)

III. Demerit Value	Definition	Examples	Model
10 - (cont.)		<u>F. Receiver Assembly - (cont.)</u>	
		No tension on mag. tube.	M/1100, 11-48, 870, 552, 572, 500 series, N66
		Nylon washer missing on take down nut.	M/742
		Outer mag. tube loose.	M/552, 572, 500 series
		Outer mag. tube marred.	M/552, 572, 500 series
		Poor filing on Rec.	All models
		Poor finish on Rec.	All models
		Poor polish on Rec.	All models
		Rear of mag. tube open at barrel support.	M/N66
		Receiver bushing loose.	M/552, 572
		Rec. bushing not staked.	M/552, 572
		Rec. cover screw broken off at slot.	M/N66, N10-C
		Rec. marred.	All models
		Rec. pitted.	All models

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DESCRIPTIVE INFORMATION

Finished Product Defect Index - Classification & Demerit Values - (cont.)

III. Demerit Value	Definition	Examples	Model
10 - (cont.)		<u>F. Receiver Assembly - (cont.)</u>	
		Rec. rail sharp (marks cases).	M/600, 700
		Recoil spring ring loose.	M/11-48
		Scale on recoil spring ring.	M/11-48
		Scant threads in take down screw hole.	M/552, 572
		Scope grooves in Rec. shallow.	All rim fires
		Seam in Rec.	All models
		Latches loose in Rec.	M/870, 1100
		Tight between latches.	M/870
		Two followers in inner mag. tube.	M/552, 572, 500 series, N66
		<u>G. Stock Assembly</u>	
		Action loose in stock.	M/700, 600, 500 series
		Butt plate cracked.	All models except magnum

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Finished Product Defect Index - Classification & Demerit Values - (cont.)

III. <u>Demerit Value</u>	<u>Definition</u>	<u>Examples</u>	<u>Model</u>
10 - cont.		<u>G. Stock Assembly - (cont.)</u>	
		Butt plate deformed.	All models except magnum
		Butt plate discolored.	All models except magnum
		Checkering on stock light.	All models with checkering
		Checkering off center.	All models with checkering
		Checkering missing on stock.	All models with checkering
		Dull spot on stock.	All models
		Excess filler on stock.	All models
		Excess lacquer.	M/552, 572, 742, 600 760, 500 series
		Excess RK-W.	M/1100, 11-48, 870, 742 BDL, 600 laminated, 700, 760 BDL, 552 BDL, 572 BDL
		Excess stain.	All models

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DESCRIPTIVE INFORMATION

Finished Product Defect Index - Classification & Demerit Values - (cont.)

III. <u>Demerit Value</u>	<u>Definition</u>	<u>Examples</u>	<u>Model</u>
10 - (cont.)		<u>G. Stock Assembly - (cont.)</u>	
		Grip cap poorly fitted.	M/1100, 11-48, 870, 700-BDL, 760, 552 BDL, 572 BDL, NGG, N 10-C
		Hole in butt plate.	All models except magnum
		Hole in stock.	All models
		No border on checkering on stock.	All models except 500 series.
		Open grain in stock.	All models
		Poor checkering on stock.	All models with checkering.
		Poor color on mag. guide plate.	500 series
		Poor finish on stock.	All models
		Poor repair on stock.	All models
		Poor sanding on stock.	All models
		Raised grain on stock.	All models
		Rec. cut too long in stock (full stock).	M/600, 700, 788, 500 series

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DESCRIPTIVE INFORMATION

Finished Product Defect Index - Classification & Demerit Value - (cont.)

III. Demerit Value	Definition	Examples	Model
10- (cont)		G. Stock Assembly - (cont.)	
		Recoil pad open on stock.	Any model with recoil pad
		Stock bolts missing.	M/600, 700, 788, 500 series
		Stock checked.	Any model
		Stock checkering burned.	Any model with checkering
		Stock chipped.	Any model
		Stock discolored.	Any model
		Stock split.	Any model
		Take down screw cross threaded.	M/552, 572, 500 series
		Tang support missing.	M/600
		Stock loose.	Any model

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DESCRIPTIVE INFORMATION

Finished Product Defect Index - Classification & Demerit Values - (cont.)

IV. Demerit Value	Definition	Examples	Model
1	1. Minor damaged, objectionable visual dimensional or adjustment not presenting potential functional failures.	(A. Barrel Assembly) Barrel bracket rough. Barrel lays left/right. Barrel marred. Barrel rusty. Bore pitted (minor.) Bulge in bore. Burr on barrel extension. Double roll on barrel. Front sight bead loose. Front sight assembled improperly. Front sight damaged. Front sight pitted.	M/600, 700 All rimfire rifles All models All models All models All rimfire rifles M/11-48 All models All shotguns. All centerfire, rimfire, M/870 Brushmaster, 1100 Deer Gun All models All models except shot- guns with beaded sights.

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Finished Product Defect Index - Classification & Values - (cont.)

IV. Demerit Value	Definition	Examples	Model
1 (cont.)		<u>A. Barrel Assembly - (cont.)</u>	
		Front sight ramp marred.	All centerfire, 1100 Deer Gun, 870 Brushmaster
		Matting light on vent rib. (minor.)	M/1100, 11-48, 870, 600
		Nick on base of barrel face at chamber.	All models
		Poor color on front sight.	All models
		Poor color on rear sight base.	All centerfires, rimfires, 1100 Deer Gun, 870 Bushmaster
		Poor crown on barrel.	All models
		Poor finish at comb.	All models
		Poor grind on barrel at front sight.	All models
		Poor plating (chrome) on barrel.	M/N66, N10-C

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Finished Product Defect Index - Classification & Demerit Values - (cont.)

<u>IV. Demerit Value</u>	<u>Definition</u>	<u>Example</u>	<u>Model</u>
1 (cont.)		<u>A. Barrel Assembly - (cont.)</u>	
		Poor polish on breech ring.	M/742, 760
		Rear sight eyepiece off center.	All centerfire, rimfire, 1100 Deer gun, 870 Brushmaster
		Rear sight rivot high.	M/N66, 500 series, 10-C
		Rear sight screw holes not counter sunk.	M/552, 572
		Ring in bore.	All models
		Rough bore.	All models
		Rough chamber.	All models
		Rough groove in bore and muzzle.	All models
		Rough lands - breech bolt.	All models
		Scratch in bore at muzzle end.	All models
		Swell in chamber.	All models
		Target stamp missing.	All center fire

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Finished Product Defect Index - Classification & Demerit Values - (cont.)

IV. Demerit Value	Definition	Examples	Model
1 - (cont.)		<u>A. Barrel Assembly - (cont.)</u>	
		Tear in bore (minor.)	All rimfire rifles
		Tight chamber.	All models
		Vent rib marred.	All shotguns (with vent ribs) & M/600
		White diamond on eyepiece off center.	M/700, 742, 760
		Wink in bore.	All rimfire rifles
		Wrong front sight ramp.	All centerfire, M/1100 Deer Gun, 870 Brushmaster
		<u>B. Breech Bolt Assembly</u>	
		Bolt discolored.	All models
		Bolt lugs rough.	M/600, 700, 742, 760
		Bolt marred.	All models
		Bolt marred at extractor pin.	All models
		Bolt sharp on bottom edge.	All models

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Finished Product Defect Index - Classification & Demerit Values - (cont.)

IV. <u>Demerit Value</u>	<u>Definition</u>	<u>Examples</u>	<u>Model</u>
1 - (cont.)		<u>B. Breech Bolt Assembly (cont.)</u>	
		Bolt sleeve marred.	500 series
		Bolt rusty.	All models
		Braze spot on bolt handle.	All models
		Breech ring pitted.	M/742, 760
		Burr at lock notch.	All shotguns
		Burr on bolt handle.	M/600, 700, 500 series
		Cocking cam rough.	M/600, 700, 500 series
		Extractor binds.	All models
		Face of bolt rough.	All models
		Operating handle removes hard.	M/1100, 11-48, 742, N66
		Poor chamfer - front of bolt.	All centerfire, rimfire rifles
		Poor color on bolt handle.	M/500 series

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Finished Product Defect Index - Classification & Demerit Values - (cont.)

IV. <u>Demerit Value</u>	<u>Definition</u>	<u>Examples</u>	<u>Model</u>
1 - (cont.)		<u>B. Breech Bolt Assembly - (cont.)</u>	
		Poor grind on bolt.	All models
		Poor plating on bolt.	M/600, 700, All shot-guns, 788, 500 series
		Two carrier dog notches in slide.	M/1100, 11-48, 870
		<u>C. Final Assembly</u>	
		Barrel beds on front swivel screw.	M/600, 700
		Breech ring & Rec. mismatched.	M/742, 760
		Excessive trigger plate margin.	M/1100, 11-48, 552, 572, 870, 742, 760
		Fore end removes hard.	M/1100, 11-48, 870, 742, 760, 552, 572
		Fore end strikes Rec. (minor).	M/870, 572
		Magazine box assembles hard.	M/600, 700, 742, 760, 10-C

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Finished Product Defect Index - Classification & Demerit Values - (cont.)

IV. Demerit Value	Definition	Examples	Model
1 - (cont.)		<u>C. Final Assembly - (cont.)</u>	
		Magazine box dirty.	M/600, 700, 742, 760, 10-C.
		No clearance at fore end and barrel.	M/1100, 11-48, 870, 742, 760, 552, 572
		Operating handle hits fore end (slight.)	M/552
		Poor repair.	All models
		Poor polish on magazine follower.	M/600, 700, 742, 760, 500 series
		Trigger plate assemblies hard.	M/1100, 11-48, 870, 742, 760, 552, 572
		Trigger plate pin holes don't match Rec.	M/1100, 11-48, 870, 742, 760, 552, 572
		Trigger plate removes hard.	M/1100, 11-48, 870, 742, 760, 552, 572
		Wood or steel margin (minor.)	All models

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Finished Product Defect Index - Classification & Demerit Values - (cont.)

IV. <u>Demerit Value</u>	<u>Definition</u>	<u>Examples</u>	<u>Model</u>
1 - (cont.)		<u>D. Fire Control Assembly</u>	
		Firing pin retaining pin not bent.	M/N66
		Firing pin retaining pin short.	All models
		Hammer & carrier rusty.	M/552, 572
		Left connector damaged.	M/1100, 11-48, 870, 742, 760, 552, 572
		Nick in left connector.	M/1100, 11-48, 870, 742, 760, 552, 572
		Plating peeling on carrier release.	M/1100
		Poor color on trigger plate.	All models
		Poor plating on carriers.	M/11-48, 870
		Poor polish on trigger guard.	All models
		Trigger guard bow marred.	All models
		Trigger plate damaged.	M/1100, 11-48, 870, 742, 552, 572, 760

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Finished Product Defect Index - Classification & Demerit Value - (cont.)

IV. <u>Demerit Value</u>	<u>Definition</u>	<u>Examples</u>	<u>Model</u>
1 - (cont.)			
		<u>D. Fire Control Assembly - (cont.)</u>	
		Trigger Plate pin bushing damaged.	M/1100, 11-48, 870, 742, 760, 552, 572
		Trigger plate pitted.	M/1100, 11-48, 870, 742, 760, 552, 572
		<u>E. Fore End Assembly</u>	
		Bad spot in fore end.	M/1100, 11-48, 870, 742, 760, 552 BDL, 572 BDL
		Check at checkering on fore end. (minor)	M/1100, 11-48, 870, 742, 760, 552 BDL, 572 BDL
		Checkering border run out on fore end.	M/1100, 11-48, 870, 742, 760, 552 BDL, 572 BDL
		Checkering light on fore end.	M/1100, 11-48, 870, 742, 760, 552 BDL, 572 BDL
		Excess filler on fore end.	M/1100, 11-48, 870, 742, 760, 552 BDL, 572 BDL
		Excess lacquer on fore end.	M/742, 760, 552, 572
		Excess RK-W on fore end.	M/1100, 11-48, 870, 742 BDL, 760 BDL, 552-BDL, 572 BDL

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Finished Product Defect Index - Classification & Demerit Values - (cont.)

IV. <u>Demerit Value</u>	<u>Definition</u>	<u>Examples</u>	<u>Model</u>
1 - (cont.)		<u>E. Fore End Assembly - (cont.)</u>	
		Flaw in action bar.	M/870
		Fore end checkering cracked. (minor)	M/1100, 11-48, 870, 742, 760, 552 BDL, 572 BDL
		Fore end checkering crushed. (minor)	M/1100, 11-48, 870, 742, 760, 552 BDL, 572 BDL
		Fore end chipped.	M/1100, 11-48, 870, 742, 760, 552 BDL, 572 BDL
		Fore end color light.	M/1100, 11-48, 870, 742, 760, 552 BDL, 572 BDL
		Fore end escutcheon marred.	M/552, 572
		Fore end marred. (minor)	M/1100, 11-48, 870, 742, 760, 552, 572
		Fore end screw high.	M/760, 572
		Lacquer chipped on fore end.	M/742, 760, 552, 572
		Lacquer run on fore end.	M/742, 760, 552, 572

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Finished Product Defect Index - Classification & Demerit Values - (cont.)

IV. <u>Demerit Value</u>	<u>Definition</u>	<u>Examples</u>	<u>Model</u>
1 - (cont.)		<u>E. Fore End Assembly - (cont.)</u>	
		Open grain on fore end.	M/1100, 11-48, 870, 742, 760, 552, 572
		Pin hole in fore end.	M/1100, 11-48, 870, 742, 760, 552, 572
		Poor finish on fore end.	M/1100, 11-48, 870, 742, 760, 552, 572
		Poor patch (color) on fore end.	M/1100, 11-48, 742, 760, 552, 870, 572
		Poor repair on fore end.	M/1100, 11-48, 870, 742, 760, 552, 572
		RW-W bubble on fore end.	M/1100, 11-48, 870, 742-BDL, 760 BDL, 552 BDL, 572 BDL
		Run out of finish on fore end.	M/1100, 11-48, 870, 742, 760, 552, 572.
		<u>F. Receiver Assembly</u>	
		Burr at ejection port.	M/1100, 11-48, 870, 742, 760, 552, 572, N66

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Finished Product Defect Index - Classification & Demerit Values - (cont.)

IV. Demerit Values	Definition	Examples	Model
1 - (cont.)		<u>F. Receiver Assembly - (cont.)</u>	
		Burr on Receiver.	All models
		Color off Rec. bottom.	M/1100, 11-48, 870, 742, 760, 552, 572
		Color worn off take down screw.	M/552, 572, 500 series
		Deflector marred.	M/552
		Ejection port sharp:	M/1100, 11-48, 870, 742, 760, 552, 572, N66, 10-C
		Front trigger plate pin loose.	M/1100, 11-48, 870, 742, 760, 552, 572
		Outer magazine tube bent at tension slot.	M/552, 572, 500 series
		Poor color on Rec. (minor).	All models
		Poor color on Rec. bottom.	All models
		Poor finish at rail.	M/600, 700, 500 series
		Poor finish on Rec.	All models

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Finished Product Defect Index - Classification & Demerit Values - (cont.)

IV. Demerit Value	Definition	Index	Model
1 - (cont.)		E. Receiver Assembly - (cont.)	
		Magazine plug pin loose.	M/552, 572, 500 series N66
		Rear trigger plate pin loose.	M/1100, 11-48, 870, 552, 572, 742, 760
		Receiver cover damaged.	M/NG6, 10-C
		Receiver cover screw broken.	M/NG6, 10-C
		Receiver marred.	All models
		Rec. plug screws mutilated.	M/600, 700, 742, 760
		Rec. rail rough.	M/700, 600, 500 series
		Rec. rough inside at bolt.	M/700, 600, 500 series
		Rec. shows stress at interceptor latch.	M/1100, 11-48, 870, 742, 760, 552, 572
		Scope cut on Rec. rough.	M/552, 572, 500 series
		Serial number light fill (gold)	All anniversary models

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Finished Product Defect Index - Classification & Demerit Values - (cont.)

IV. Demerit Value	Definition	Examples	Model
1 - (cont)		<u>F. Receiver Assembly</u> -(cont.)	
		Take down screws mutilated.	M/552, 572, 500 series
		Trigger plate pin short.	M/1100, 11-48, 870, 742, 760, 552, 572
		<u>G. Stock Assembly</u>	
		Acid spot at tip.	M/N66, 10-C
		Bad spot in stock.	All models
		Butt plate cracked. (minor)	All models except mag- nums
		Butt plate loose.	All models except magnums
		Butt plate screw loose.	Rimfire, centerfire
		Butt plate spacer loose.	M/1100, N66
		Check at checkering. (minor)	All models with check- ering
		Checkering border run out.	All models with checkering

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Finished Product Defect Index - Classification & Demerit Values - (cont.)

<u>IV. Demerit Value</u>	<u>Definition.</u>	<u>Examples</u>	<u>Model</u>
1 - (cont.)		<u>G. Stock Assembly - (cont.)</u>	
		Dirty butt plate. (minor)	All models except magnum
		Epoxy filler piece margin.	M/600 (.35 Cal. & 6.5mm)
		Excess filler on stock.	All models
		Excess filler piece margin.	All models
		Excess lacquer on stock.	M/742, 760, 552, 572, 500 series
		Excess lacquer on butt plate.	M/742, 760, 552, 572, 500 series
		Excess RK-W on butt plate.	M/1100, 11-48, 870, 742-BDL, 760 BDL, 552 BDL, 572 BDL
		Excess RK-W on grip cap.	M/1100, 11-48, 870, 742 BDL, 760 BDL, 552 - BDL, 572 BDL
		Excess RK-W on stock.	M/1100, 11-48, 870, 742-BDL, 760 BDL, 552 BDL, 572 BDL
		Floor plate dirty.	M/700 BDL

PART NAME Finished Prod. Defect Index COOLANT _____ SET UP TIME _____ MODEL No. All Models OPER. No. _____
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DESCRIPTIVE INFORMATION

Finished Product Defect Index - Classification & Demerit Values - (cont.)

IV. <u>Demerit Value</u>	<u>Definition</u>	<u>Examples</u>	<u>Model</u>
1 - (cont.)		<u>G. Stock Assembly - (cont.)</u>	
		Floor plate binds.	M/700 BDL
		Grip cap spacer loose.	M/1100, 742 BDL, 760 BDL
		Incorrect epoxy mixture.	M/600 (.35 Cal. & 6.5 mm)
		Knot in stock.	M/600 (.35 Cal. & 6.5 mm)
		Lacquer bubble on stock.	M/742, 760, 552, 572, 500 series
		Lacquer chipped at floor plate.	M/742, 760, 552, 572, 500 series
		Lacquer chipped on stock.	M/742, 760, 552, 572, 500 series
		Lacquer run on stock.	M/742, 760, 552, 572, 500 series
		Over .012 filler piece.	All models
		Paper on butt plate.	All models
		Pencil mark on stock.	All models
		Pin hole in stock.	All models
		Poor color on stock.	All models

PART NAME Finished Prod. Defect Index COOLANT _____ SET UP _____ MODEL No. All Models OPER. No. _____
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DESCRIPTIVE INFORMATION

Finished Product Defect Index - Classification & Demerit Values - (cont.)

IV. Demerit Value	Definition	Examples	Model
1 - (cont.)		<u>G. Stock Assembly - (cont.)</u>	
		Poor finish on stock.	All models
		Poor finish at bolt clearance cut.	M/600, 700, 500 series
		Poor patch (color) on stock.	All models
		Poor repair on stock.	All models
		Poor sanding on stock.	All models
		Poor sanding at butt plate.	All models
		Porous recoil pad.	M/600, 700 mag., 1100, 11-48, 870
		Margin at grip cap. (minor)	All models
		RK-W bubble on stock.	M/1100, 11-48, 870, 742 BDL, 760 BDL, 552 - BDL, 572 BDL, 600, 700
		Rough trigger slot in stock.	M/700, 500 series
		Stock checkering crushed. (minor)	All models with checkering.
		Stock checkering marred. (minor)	All models with checkering

PART NAME Finished Prod. Defect Index COOLANT _____ SET UP TIME _____ MODEL No. All Models OPER. No. _____
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DESCRIPTIVE INFORMATION

Finished Product Defect Index - Classification & Demerit Values - (cont.)

IV. <u>Demerit Value</u>	<u>Definition</u>	<u>Examples</u>	<u>Model</u>
1- (cont)		<u>G. Stock Assembly - (cont.)</u>	
		Stock chipped. (minor)	All models
		Stock color light.	All models
		Stock marred.	All models
		Stock rough inside.	All models
		Swivel on stock (uncalled for)	All models
		Tip & spacer uneven.	M/700 BDL, N66, 10-C
		Trigger guard & plate screw marred.	M/600, 700, 500 series

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