

REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE



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Ilion, New York
January 26, 1979

R. L. HALL

MODEL XP-100 SEQUENCE OF EVENTS

Model XP-100 sequence of events in modifying customer return guns and insuring integrity of production Trigger Assemblies is listed chronologically below:

<u>Date</u>	<u>Event</u>
10-24-78	Remington announced recall of M/600 and XP-100 pistol.
11-78	Engineering and Production effort concentrated on M/600. Gunsmith write-up - assemblies for gunsmith - establishing process for Trigger Assemblies to be shipped.
11-17-78	Present process reviewed - trick test for XP-100 reviewed with assemblers - shim test added (check for clearance between Sear and Sear Block with shim Stock, with Safety in null position).
12-1-78	Initial work on defining situation for customer repair XP-100's started - process reviewed, additions and clarifications were made.
12-15-78	Process developed for customer repair pistols; Engineers tried sample run. Customer repair gunsmith trained.
12-18-78	Initial lot of 25 customer guns modified to repair process. Lot rejected, two guns failed test. (1) shim test and (1) trick test.

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<u>Date</u>	<u>Event</u>
12-18-79 Contd.	The trick test was re-evaluated and it was found that the engineer and gunsmith were using different techniques - standardized test. The shim test was also re-evaluated for consistent and easier operation. It was also found that some customers had made alterations to the Sear Housing Assemblies and they had to be readjusted to standards.
12-28-78	A second lot of 25 was modified to revised process. A large percent of pistols would not pass shim test and the new gaging technique was questioned - parts measured.
1-4-79	Engineering analysis showed second lot of pistols was using a new shipment of Safety Assemblies which had .006" less lift on Sear. R & D altered drawing to increase lift - parts were ordered with higher lift. Shim test results were analyzed by using dial gage which fits into back of Receiver. Results were correlated.
1-10-79	New lot of 25 pistols started to process for modification - high lift Sear were used and pistols were audited - process verified.
1-12-79	Repair verified on customer pistols - pistols started being returned to customers. Production started using low lift Safety levers; reject rate increased dramatically \approx 50%.
1-19-79	New Safety levers delivered to Ilion - found to have too much Sear lift, .002" over max. model drawing.
1-22-79	New Safety levers in Assemblies - mechanism would lock up when put on Safe. Safety levers ground down to max. model drawing. Mechanism worked but rear of Sear interferes with Sear Housing Pin.
1-23-79	Safety levers ground to mean model drawing - still binding. Drawing change made to grind clearance on Sear - parts tried, mechanism worked.

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<u>Date</u>	<u>Event</u>
1-24-79	Parts modified, Assemblies put together. Safety worked hard. Lubrication technique developed - parts delivered to Final Assembly - pistols put up.
1-25-79	Pistols tested satisfactorily. More parts were modified. Pistols which had been rejected were refitted with new Sear and lever.
1-26-79	More parts being modified - permanent process for part modification being developed.
1-29-79	Parts delivered to Customer Repair - to continue modifying guns - 147 shipped to date.

J. P. Linde

J. P. Linde, Superintendent
P E & C Section

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