

M/600 FIRE CONTROL

In January 1975 R&D was advised of a problem existing with the M/600 Fire Control. Initial investigation of the fire control and components showed several out of tolerance conditions existing. The parts found to be out of tolerance are:

SEAR SAFETY CAM - Safety cam surface.

.5347 / .539 dim. and connector contact area

.341 / .346 dim. over max.

TRIGGER - Pivot hole in trigger

.991 / .975 dim. was found to be out of position over max.

TRIGGER CONNECTOR - This part was found to have a blow in the long leg of the part.

TRIGGER HOUSING - The following holes were found out of position -

Safety Pivot hole .649 / .651 & 1.306 / 1.307

Safety Detent Holes

Trigger Pivot holes .839 / .841 & 1.239 / 1.241

Holes were out of position also had variations from side to side.

Correction of these tolerance conditions was easily accomplished, as two of the four parts are made here.

SEAR SAFETY CAM - Is manufactured by Hi-Dense. It was found that by exercising more care in pressing and sintering this part could be made to model drawing tolerance.

TRIGGER - Also made by Hi-Dense with final machining by Rem. This part was brought back into tolerance by minor alteration of fixturing and reconstruction of the operator.

TRIGGER CONNECTOR - Manufactured outside - this part was brought back into tolerance by having the vendor make alteration on die.

PLAINTIFF'S  
EXHIBIT

3096

AL 0023528

10f3

A

TRIGGER HOUSING -- This part was found to have the most out of tolerance conditions.

This part can be controlled but it is necessary for both Rem. and vendor to screen and check all parts. Doing this increases piece price. Parts are also checked at Sub-Assembly to insure proper sear connector separation with safe in "ON SAFE" position.

Reason for change to M/700 Style Fire Control Housing.

Hardened low wear housing

More Positive safety

Eliminate trigger housing rejects at safety clearance inspection.

Common Housing -- (M/600, M/700, M/40X)

PARTS CHANGED OR REDESIGNED

Housing -- Altered to fit M/600 and M/700 receivers.

Safety Lever and Sear Safety Cam -- Altered to provide a longer duration of safety and more lift -- sear and connector separation.

Future plans for this Fire Control, the XP-100 Fire Control and the M/700 Fire Control are:

Continue to upgrade and improve them, include a unload on safe feature, a three position safe or both. This will probably be dictated by Marketing.

FEMartin:bd

4/5/77

AL 0023529

CALIBER	BEAD			REAR SIGHT SET	RAMP		
	25751 LOW	25750 MED.	14659 HIGH		28512 LOW	28511 MED.	28510 HIGH
.17 REM		x		4th Index Mark from rear			x
.222		x		"			x
.22-250		x		"			x
.25-06		x		"			x
.6mm		x		"			x
.243		x		"			x
.270		x		"			x
.30-06		x		"			x
.308		x		"			x
.7mm			x	"			x
.264			x	"			x
.300			x	"			x
.8mm			x	"			x
.375	x	Alt.		Middle 5th space		x	
.458	x	Alt.		"		x	

A

FEM:bd  
2-4-77

AL 0023530

3 of 3