

Snedeker, Jim

From: Franz, Scott
Sent: Thursday, November 16, 2000 9:25 AM
To: Golemboski, Matt R.
Cc: Danner, Dale; Diaz, Danny; Keeney, Mike; Snedeker, Jim
Subject: TLR0300E,F,G,H,J,I.xls



Matt,

The attached spreadsheet contains early T & P measurement data. We need some help in understanding why our engagement numbers are so high. I know your fixture biases the insert up to simulate being mounted in the stock and we measure this in an unsupported state. Do you have any correlation data between your method and ours? We would like to run a test. Could you take one gun, set the fire control as per your process and record trigger pull and engagement as measured on your fixture. Then recheck engagement and trigger pull out of the stock without biasing the insert up, like we do (record these numbers). Assemble in a stock and recheck trigger pull and engagement, again recording this. You'll need to cut a hole in the stock to check this. Then send the gun to us. We'll measure here as well. Only a sample size of one but it may help us better understand. If you have any comments or suggestions give me a call.

Scott

CONFIDENTIAL

ET34330

710 TRAIL & PILOT SERIES-B
11/1500

PRELIMINARY MEASUREMENTS & CHECKS

BLUE INDICATES BELOW SPEC
RED INDICATES ABOVE SPEC

TEST LAB TRACKING NUMBER: TLW0300

PROOF TEST & MAGNAFLUX COMPLETED AT MAYFIELD

GUN ID #		SERIAL NUMBER	INSPECT FOR PROOF STAMP	INSPECT FOR HEADSPACE MAGNAFLUX STAMP	REM. SPEC GAUGES	TRIGGER PULL WITH SPRING SCALE			FIRING PIN INDENT WITH COPPER CRUSHERS			SLAM TO TRIGGER ENGAGEMENT			BEAR UFT		
						TLW3000.F	TLW3000.F	TLW3000	TLW3000	LBS.	TLW3000H	TLW3000 out of stock @ 20X	TLW3000 out of stock @ 20X	TLW3000 out of stock @ 20X	TLW3000 out of stock @ 20X	3 AVERAGE	
						1	2	3 AVERAGE	1	2	3 AVERAGE	1	2	3 AVERAGE	1	2	3 AVERAGE
B-1	71001124		YES	YES	MIN+.002	5	5	5.5 5.17	0.017	0.017	0.018 0.0173	0.0287	0.0288	0.0286 0.0274	0.0122	0.0139	0.0133 0.0131
B-2	71001184	Y	Y	Y	MIN+.002	5.25	5.5	5 5.25	0.018	0.017	0.018 0.0177	0.0277	0.0278	0.0279 0.0274	0.0127	0.0132	0.0131 0.0130
B-3	71001244	Y	Y	Y	MIN+.002	4.25	4.75	4.25 4.43	0.017	0.016	0.018 0.0169	0.0263	0.0261	0.0272 0.0262	0.015	0.0145	0.0147 0.0140
B-4	71001288	Y	Y	Y	MIN+.001	6	4.5	4.25 4.69	0.018	0.016	0.018 0.0173	0.032	0.0311	0.0307 0.0313	0.0151	0.0173	0.0167 0.0164
B-5	71001421	Y	Y	Y	MIN+.001	4.25	4	3.25 3.23	0.016	0.015	0.017 0.0163	0.0258	0.027	0.0265 0.0268	0.0123	0.0123	0.0113 0.0123
B-6	71001462	Y	Y	Y	MIN+.001	4.75	4.25	4.25 4.42	0.016	0.016	0.017 0.0163	0.0224	0.0261	0.0259 0.0261	0.0152	0.0124	0.0121 0.0122
B-7	71001504	Y	Y	Y	MIN+.001	5.5	5.25	5 5.25	0.017	0.016	0.016 0.0163	0.0234	0.0259	0.0254 0.0268	0.0154	0.0139	0.0138 0.0143
B-8	71001511	Y	Y	Y	OUT OF TEST. TRIGGER LOCATED TO THE RIGHT OF CENTER IN TRIGGER GUARD. GUN HELD FOR MANUFACTURER'S EVALUATION.												
B-9	71001524	Y	Y	Y	MIN+.001	5.5	5.25	5.25 5.33	0.017	0.018	0.017 0.0173	0.0265	0.0267	0.0261 0.0271	0.0138	0.0132	0.0145 0.0136
B-10	71001529	Y	Y	Y	MIN+.001	5.5	5.25	5.25 5.33	0.017	0.018	0.017 0.0173	0.0267	0.0263	0.0262 0.0269	0.0129	0.0141	0.0141 0.0138
B-11	71001534	Y	Y	Y	MIN+.002	4.5	5	4.5 4.67	0.017	0.017	0.017 0.0170	0.0311	0.0307	0.0306 0.0309	0.0141	0.0137	0.0131 0.0136
B-12	71001535	Y	Y	Y	MIN+.001	5.5	5	4.75 5.08	0.018	0.018	0.018 0.0183	0.0278	0.0283	0.0285 0.0291	0.0144	0.0137	0.0143 0.0137
B-13	71001539	Y	Y	Y	MIN+.001	5.5	5	5 5.17	0.017	0.019	0.017 0.0177	0.0291	0.0295	0.0295 0.0296	0.0152	0.0143	0.0146 0.0147
B-14	71001559	Y	Y	Y	MIN+.002	5	5	5 5.00	0.018	0.019	0.018 0.02	0.0313	0.0308	0.0316 0.0312	0.013	0.0128	0.0149 0.0128
B-15	71001576	Y	Y	Y	MIN.	4.5	4.75	4.5 4.88	0.017	0.017	0.017 0.0170	0.029	0.0278	0.0283 0.0287	0.0162	0.0163	0.0158 0.0161
B-16	71001580	Y	Y	Y	MIN+.001	5.75	5.5	6 5.78	0.017	0.018	0.018 0.0177	0.0307	0.0304	0.0313 0.0308	0.0158	0.0161	0.0158 0.0158
B-17	71001583	Y	Y	Y	MIN+.002	5	5	5.25 5.08	0.017	0.018	0.019 0.0180	0.029	0.0291	0.0298 0.0303	0.0155	0.0155	0.0157 0.0156
B-18	71001584	Y	Y	Y	MIN+.001	4.75	5	5.25 5.67	0.016	0.018	0.017 0.0179	0.0291	0.0272	0.0285 0.0290	0.0138	0.0138	0.0138 0.0139
B-19	71001595	Y	Y	Y	MIN+.001	5	5.5	5.25 5.25	0.019	0.019	0.019 0.0187	0.0295	0.0292	0.0295 0.0296	0.0119	0.0119	0.0111 0.0116
B-20	71001605	Y	Y	Y	MIN+.001	5	4.5	4.75 4.73	0.018	0.018	0.017 0.0183	0.0262	0.0271	0.0269 0.0264	0.0175	0.0153	0.0165 0.0167
B-21	71001613	Y	Y	Y	BELOW MIN.	5.75	5.75	5.25 5.58	0.017	0.017	0.018 0.0173	0.0256	0.0258	0.0251 0.0254	0.0154	0.0146	0.0145 0.0147
B-22	71001623	Y	Y	Y	MIN.	4.75	4.75	5.25 4.97	0.018	0.018	0.018 0.018	0.0271	0.0273	0.0282 0.0279	0.0134	0.0134	0.0144 0.0137
B-23	71001632	Y	Y	Y	MIN+.001	5	4.75	5.25 5.00	0.018	0.018	0.017 0.0170	0.0267	0.0271	0.0278 0.0273	0.015	0.0157	0.0157 0.0148
B-24	71001634	Y	Y	Y	MIN+.001	5.5	5.5	5.25 5.43	0.017	0.017	0.017 0.0177	0.0279	0.0278	0.0285 0.0283	0.0141	0.0149	0.0145 0.0145
B-25	71001643	Y	Y	Y	MIN+.001	4.25	4	4.25 4.33	0.016	0.017	0.018 0.0177	0.0301	0.0304	0.0312 0.0312	0.0159	0.015	0.0140 0.0145
B-26	71001647	Y	Y	Y	MIN+.001	5	5	5 5.00	0.017	0.017	0.017 0.0170	0.0269	0.0285	0.0292 0.0292	0.0129	0.0136	0.0136 0.0136
B-27	71001724	Y	Y	Y	MIN+.002	5.75	4.75	4.25 4.92	0.016	0.019	0.02 0.0183	0.0298	0.0304	0.0299 0.0300	0.0163	0.0175	0.0175 0.0170
B-28	71001760	Y	Y	Y	MIN+.002	5.25	4.75	4.5 4.83	0.016	0.017	0.016 0.0163	0.0344	0.036	0.0367 0.0357	0.0171	0.0154	0.0149 0.0149
B-29	71001762	Y	Y	Y	MIN+.002	4.25	4.75	5 4.87	0.019	0.019	0.018 0.0187	0.0264	0.0263	0.0303 0.0297	0.0152	0.0154	0.0157 0.0152
B-30	71001789	Y	Y	Y	MIN+.002	4.25	4.5	4.5 4.43	0.019	0.017	0.019 0.0183	0.0284	0.0285	0.0307 0.0294	0.0138	0.0138	0.0134 0.0132
TEST AVERAGE						4.96			TEST AVERAGE 0.01782			TEST AVERAGE 0.02808			TEST AVERAGE 0.0132		
SPEC: 4.0 TO 5.5 LBS.						SAAMI MIN = .017			SPEC = .029 TO .025			SPEC: .008 TO .018					

COMMENTS FROM TECHNICIANS:

STOCK TAKE DOWN SCREWS ARE NOT TIGHTENED TO TORQUE SPEC, SOME ARE BARELY TIGHTENED AT ALL
SCOPE RING TO MOUNT SCREWS ARE NOT TIGHT

NOTE: WAR ON RECEIVER OUT OF BOX

NOTE: MISSING BEAR TAKE DOWN SCREW OUT OF BOX, NOTHING IN BOX

NOTE: SAFETY IN FIRE POSITION OUT OF BOX

NOTE: WAR ON STOCK OUT OF BOX

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ET34331

Confidential - SHARPER-522P06r0007843e Order

Williams v. Remington