

01 Oct. 93

To: K.W. Soucy  
From: R.A. Jackson *RWJ*

PROGRESS REPORTDetachable magazine box

\* The Phase I T&P rifles (reference report of 9/1/93) were built and tested with the following difficulties identified:

- a) Cartridges jumped out of the magazine during cycling of the bolt causing inability to feed properly.  
--> THIS IS BEING CORRECTED BY A REDESIGN OF THE MAGNUM MAGAZINE BOX. Twenty each of three types of slightly modified magazine boxes have been ordered from our vendor. After testing these, the best will be selected and specified as our new design. Trial and pilot quantities of this new box will then be ordered with the magnum T&P scheduled in November 1993.
- b) About 30% of the test rifles failed our normal Gallery testing because of "bolt over-ride". This means that the bolt passed over the next round in the magazine without feeding it up and into the chamber. Of those 70% that passed our normal in-process testing, all performed well in subsequent Phase I T&P testing in the Test Lab.  
--> THIS CONDITION IS BEING CORRECTED THROUGH CHANGES TO OUR STOCK INLETING AND TRIGGER GUARD PROCESSING.
- c) Black color was found to wear off the bottom of the magazine latches during normal cycling. This has been corrected through authorization of the Product Team allowing all silver colored latches. This not only looks fine but saves us \$0.30 - \$0.60 per rifle depending on the process required to make them a lasting black.
- d) Over-spray of black powder coat was found on the upper lip of the magazine box bottom. This is being corrected by additional masking of this surface during p-coat.
- e) Trigger guards protruded above the stock surface at the front nose by about 0.060". This is being corrected by changing the molding die. For the first ~ 4500 parts, we will mill the correct fit and configuration so that tooling change will not hold up production of product.

\* Phase 2 T&P rifles will be built during the first week of Oct.