

RD-49-B

## REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE



XC: C. B. Workman  
J. W. Bower  
J. S. Martin  
J. R. Snedeker

"CONFINE YOUR LETTER TO ONE SUBJECT ONLY" \_\_\_\_\_

Ilion, New York  
February 20, 1981

TO: G. D. CAMPBELL  
FROM: T. L. CAPELETTI *TC*  
SUBJECT: REPORT TO FEBRUARY OPERATIONS COMMITTEE MEETING

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LIMITED DISTRIBUTION

My reports to the February 11, 1981 Operations Committee Meeting may be summarized as follows:

● Models 7400, 7600, Four and Six

Phase 1 (Data Gathering) of the M/7400/7600 Task Force program is essentially complete and Phase 2 (Data Analysis) is in progress. Objective of the second phase is to develop useful diagnostic tools (eg. computer programs and wall charts) to aid in analysis and correction of recurring process upsets. For example, review of gallery rejects by malfunction type is complete and a computer program is being written to provide weekly update charts on status of malfunctions by gun caliber. In addition, parts for the 100 piece correlation study are 95% complete and nearing final assembly. Results of that study will provide information on the synergistic effect of tolerance stack up on malfunction rates.

A follow up Research Warehouse Quality Audit is in progress to compare performance of M/7400's to M/742's as supplied to the customer. Five guns each of M/7400, M/4, M/742 ADL and M/742 BDL have been obtained from the warehouse. Preliminary results of the visual audit indicate that the M/7400/4's are superior to the M/742 ADL/BDL's, respectively. Component

REPORT TO FEBRUARY OPERATIONS COMMITTEE MEETING

page 2  
2-20-81

- - - - -

measurements also indicate that the new models compare favorably with the previous line. Live fire field testing will be completed by the end of February.

● Model 700 Fire Control Improvements

An alternative design, featuring a blocked trigger and sear, has been completed for the M/700 fire control. The design has the added advantage of making it very difficult to adjust the system to provide a "hair" trigger. When adjusted to the extreme light trigger pull setting, the safety binds and is difficult to move from "safe on" to "fire" position. Five prototypes of the new design are in test. The 100 round functional test portion has been completed and results indicate no major problems with the design. Dry cycle endurance tests are scheduled for the end of February. Drawings have been provided to Production for cost estimating.

TLC:ws  
Firearms Research Division

XSG/XPG Shotguns

Two (2) more square wire action springs are in test. One (1) at 3,750 and the second at 6,573 so far closing velocities have been satisfactory. The sliding locking system has had past failures in gun no. X0018. It is being continued and now has 6,573 rounds of 2-3/4 " magnums. A redesign of this system is in progress.

Design work on the XPG for the feed systems has been started.

Four (4) new XSG prototypes are scheduled for mid-March assembly.

M/700 Bolt Lock and Fire Control

Five (5) prototype bolt locks and fire controls are in test. Testing is 40% complete with minor problem areas (bolt latch not relatching).

A re-evaluation cost of the bolt hand and plunger is being made.

M/788 Safety

To date, all model drawings, final and blank, have been transmitted to the Plant. Currently production has ordered a sample of 2,000 springs and plungers to evaluate the design with altered safety levers.

M/7400 - 7600 Centerfire Rifles

One of the identifiable problems with the 7400/7600 has been in the final heading area. The new heading machine is now running and the results look encouraging. The critical gage dimensions that are required for better dimensional control are now known and have turned over to Tool Design for design completion of new gaging fixtures. Other gage processes and

dimensions are also under scrutiny and will be analyzed for their cause/  
effect.

Model Four Limited Edition

Research is working with Process on best way to attach and finish  
rosewood tip to fore-end. Samples of rosewood have been received from  
vendor. Samples seem to be free from cracks and color is better than  
expected. Sample fore-ends w/rosewood tips will be made and tested.  
All drawings are now complete and with parts list can be transmitted.

J.S. Martin:ws  
2-20-81

DON'T SAY IT — WRITE IT

To J.S. Martin  
From S. Fawell:

Date 1-22-80

788 Monthly Report.

Samples of the new safety design have been ordered and process will run a 2000 unit sample in order to verify the design. Drawings have been prepared and will be transmitted to Production.

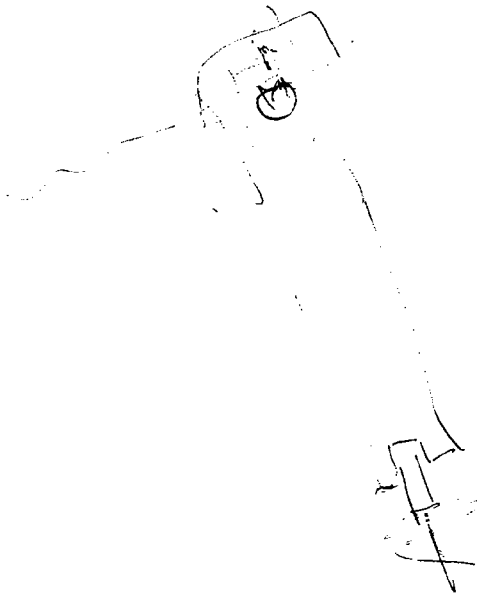
SAFETY IS A WISE INVESTMENT

Model 700 Bolt Lock and Fire Control

Testing of the new design bolt locks and fire controls is to begin the week of 19 January 1981.

Five models have been prepared and are in the test lab.

A final version of a simplified bolt lock is being fabricated and will be ready by 30 Jan 81.



COM 5

A.I. m/7400 June -

- march - 788 sal janella -

- [7400 a.i. repr. June.. - ?

[700 saf. Ball lock (April)

[5500 - may.

-1-1-1-1-

gas system - develop - Aug <sup>April</sup> ~~may~~ ?

Kevin Calkin - June. -

[X85 - July. 1, ?  
Ed Yetter -  
find out - when he can be moved.

tech presentation - 3<sup>rd</sup>

[Yetter - Computer model. - schedule  
Janella 750.

find out when he is ready to move -

→ Kevin Calkin - X85 - (feed system)

Adams Hagel - find out when

he will be ready

Fred Martin - May fine contact.

756. Meeting - 10:00 =

1-19-81

A.I. reports - Seminar - rough draft. Complete -  
A.I. " 7400 - started.

Unit reviews -

Presentations =

None Friday. Fri. 23<sup>rd</sup>

Adam Hugick. ?

→ <sup>788</sup> Safety - Sal Janella - Check -

→ Ed Yetter - Computer modeling - Check -

→ Kevin Calkin 552 - Long Rifles -

→ Fred Martin - 700 - Bolt Rock -

(A.I.) 788 Safety "march" Sal - Note =

Fred Martin + Bolt Rock = 700 safety - April -

Jack Kasey. A.I. - 5500 =

Calvin N. Gas System - = A.I. April -

Kevin Martin. 7400 A.I. Feb -

Ed Yetter Presentations = [1 march] April week of 20<sup>th</sup>



*am*

Need a formal letter to L. Ferreria  
To obtain our tooling for M-5500  
stock. we would like to have the dies  
for new initiated military work.

*Jack*

## DON'T SAY IT—WRITE IT

TO Clark WorkmanDATE August 25, 1980FROM Jim Martin

I have four (4) and possibly five (5) individuals at this time  
I feel could be capable of putting on a technical presentation.

1. Dave Findlay                      Subject would be the XSG and XPG designs  
                                         Dave could also do one on Spring Design
2. John Palmer                      Subject could be the seismic gun
3. Randy Murphy                    Could do a section of the XSG-XPG design
4. Ed Yetter, Jr.                    Subject could be a section of the seismic  
                                         gun such as the electric I/O, etc.

## Other presentations:

|             |                           |
|-------------|---------------------------|
| Fred Martin | Bolt action fire controls |
| Albert Eddy | 7400-7600 design          |
| Jack Kast   | Rimfire 5500 design       |
| Adam Hugick | Gas systems for firearms  |
| Tom Bauman  | XSG                       |

JSM:T



Pam L. Capelette  
to: Clark Workman:

10-6-80

Subject: Presentations (technical)

1. Dave Fridlay

Subject: M7400 magazine box designs  
Date: Dec. 1980

2. John Palmer:

Subject: Eismic Gun  
Date: Late Nov 1980

3. Adam Hugioka:

Subject: Coo system for Auto Gun designs  
Date: Dec. 1980

4. Jack Gast:

Subject: 5500 rim fire designs  
Date: Feb. 1981

5. Sal Tanelli & Fred Martin

Subject: Fire control design for bolt action  
rifles

Date: Jan. 1981

6. Ed Yetter Jr.

Subject: Spring Reorgs.

Date: Jan 1981

Recommendations for Legal Work:

Engineers: Jim Huttons. P.E.  
Bill Warrens

Technicians  
& Engineer

Jim Hennings  
Charles Sacket  
Jim Stekel  
Ed Sienkiewicz

RE D

Jim Warner

PROGRAM   REVIEWS   -   APRIL

|       |      |      |                 |
|-------|------|------|-----------------|
| WED.  | 4/1  | 9 AM | BOB SANZO       |
| FRI   | 4/3  | 9 AM | ✓ DAVE RINDLAY  |
| MON   | 4/6  | 9 AM | BOB BALASKA     |
| TUES  | 4/7  | 1 PM | ✓ ED YETTER JR. |
| MON   | 4/13 | 9 AM | BILL CERRY      |
| TUES  | 4/14 | 1 PM | ✓ FRED MARTIN   |
| THURS | 4/16 | 9 AM | KEN ROWLANDS    |
| MON   | 4/20 | 9 AM | ✓ SAL FANELLI   |
| TUES  | 4/21 | 1 PM | ED RANKINS      |
| MON   | 4/27 | 9 AM | ✓ JACK KAST     |

RJS  
3/30/81

## 7mm EXP — SBE PROBLEMS

STATIC PRESSURE @ FRONT - CENTER OF MAGAZINE FOLLOWER, PASSED GUNS -VS- SBE REJECTS

|                                                   | PASSED                      | SBE REJECTS                 |
|---------------------------------------------------|-----------------------------|-----------------------------|
| STATIC UPWARD PRESSURE<br>MEASURED IN OUNCES (OZ) | 19 OZ                       | 18 OZ                       |
|                                                   | 21                          | 20                          |
|                                                   | 20                          | 18                          |
|                                                   | 21                          | 20                          |
|                                                   | 21                          | 20                          |
|                                                   | 19                          | 21                          |
|                                                   | 21                          | 19                          |
|                                                   | 22                          | 20                          |
|                                                   | 21                          | 22                          |
|                                                   | 21                          | 21                          |
|                                                   | $\bar{X} = 20.6 \text{ OZ}$ | $\bar{X} = 19.9 \text{ OZ}$ |

MAGAZINE EXCHANGE TEST IN 4 RIFLES REJECTED BY Q.A. AS 50 DEMERIT GUNS FOR SBE

| SERIAL # | CONFIRM SBE? | WITH PH II | WITH 308 BOX<br>1 LONG FOLLOWER |
|----------|--------------|------------|---------------------------------|
| 9007     | CFM          | OR/SOR     | OK                              |
| 6051     | CFM          | OR/SOR     | OK                              |
| 4520     | CFM          | SBE        | OK                              |
| 5852     | CFM          | SBE/OR/SOR | SBE                             |

NOTE BOOK -

Pg 31

Pg 36

Pg 43

" 54

" 58

2-3-81

31

Continued  
12:30 - 2:00

work with Adam on his report for barrel strength m/1100 - 150. Adams will present this to the staff at 2:00 Thurs. - 2-5-81

2:30 - 3:30

took force meeting on 7600

review of interviews and 100 sample parts - next meeting on 2:30 have a compiled status of interviews.

3:30 - 4:30

worked on reports.



32

Wed. 2-4-81

temp. C

8:00

1. banded in model shop for new  
gas systems

Layout of new pistons Tom Bauman.

2. X0010 in test lab.

3. Hacking systems being worked on.  
in model.

→ Test lab -

Return: P.T. Curves - needed.

Dave: need High Speed.

m/1100

9:00. Limited Editions quality control.

Inspected (5) guns that were taken  
from the warehouse. I feel the guns  
selected were not indicative of what  
is in the warehouse - because that would  
not let us select at random.

10:00

Inspected till noon. Guns were good  
to excellent. There were no major  
mistakes made in any phase. people  
should be commended.

12:30

Discussions on X56 with Comi  
explained with him and how we were  
going to have guns built.

2:30 meeting on task force -  
interviews etc.

3:30

2-5-81

34

Thurs. Feb. 5, 81

temp - 5°

8:00 XSG Meeting

X0016 no shooting in TEST LAB.

X0018. new locking block, pit-, action  
bar.

work. - find out

Work on Gas system for new positions.  
Dac - in shop today. 10.9"Safety design in model shop today.  
Tom Powers - fire control -

9:00 Call from Bill Johnson on m/y

10:00 worked on report for XSG task force

10:30 Called Lou Jernan on m/y

12:30 Call from Bill Johnson.

on scope mounts on m/7400 - m/y.

2-5-87

35

Continued.

1:30 Had short meeting -

2:00 finished report on XSO

3:00 Discussion on m/y with Clark -  
Scheduling etc.

2-6 81

36

Fri: Feb 6, 81

temp + 8°

X56 meeting:

There will be a review with management  
at 1.00 in the conference room

X0016 working shooting  
X0018 " " "

1. Hatch returners problems. find a new way.
2. slide block on A<sup>2</sup> locking system.
3. barrel with new gas cylinder. for evaluation of stroke.
4. change in model shop for down bore surface holes.
5. feed system (Lock Fast.) review.
6. fire Control (low Power) in shop - safety. Tests (3 weeks).
7. Adam H. presentation Heat Treat. barrels
- 8.

9:00

Phone Call from Bill Johnson:

Discussions on m/t Limited Edition

3 way again with Purchasing. that  
have not informed Aumann of the  
Quantity - etc -

they did contact Aumann about  
schedule's and gave us a time of 5:00  
to get a sample.

1:00 XSC meeting with Tomi & Clark.

↓  
3:30. A status report was made -

each individual explained where they  
were.

Summary by Jim Martin -

3:30 - 4:30

Adam: review of Shot Show.

2-9-81

38

Simon: Feb. 9. 81

Temp 22°

8:00 XSG meeting:

review of the meeting

John Stoff meeting read.  
find out about actions 3-3-3-99:00 meeting with Ted & Sol on Bolt Action  
rifles. review of fire control.drugs have been turned over to process  
for. Eng. samples cost and they now  
need a assembly drug. Ted is working  
on this.10:00 report for operation Committee -  
XSG -12:30 Dave & L. discussed m/7400 mag.  
box design.2:30 Discussions with Pam about  
the design of the XSG. Clark is  
influencing the design again and  
trying to inject ideas from the past  
that never did work.3:00 XSG meeting with John, Knide  
Tami office -  
Candy Swartz  
Bruce Rann

2-10-81

39

Thurs Feb. 10, 81

temp 5°

8:00 XSG Meeting

X0018 Gun. Fire 500 rds. Pin broke  
added. Roll pin - check.X0018 Bolt velocities on new barrel  
longer. Gas ~~sq~~ cylinder -

Action bar. due on 16-17-

Sgt fore-end. being worked on. Scott  
Hanks - \$30, each two weeks.

Priority set.

1. Four model guns -
2. Feed systems
3. Gas Systems -

If any major break thru come with  
gas system. it would. have a #1 priority10:00 meeting with Clark on operations  
Committee



2-11-81

40

Wed. Feb 11, 81

Temp + 30

Operations Committee meeting -

Ave down to Bridgeport 8:00 -  
meeting at 10:001230 - XOC Planning Committee  
meeting -Lauri presented status report on design.  
Committee in my opinion was  
satisfied with design plans and  
where we are now.3:00 meeting over with and the  
Company plane was grounded because  
of weather - rain wind etc -

Stayed over - note -

Chas. Feb 12, 81

temp - 5°

7:30 Left Bridgeport and flew back to Illinois  
on Company plane.

11:00 back to work. brought up two guns -  
One Competitors Trap Gun Club.  
One m/742. Poston Velasco.

12:30 -

work with Dave on magazine lock design

223

3:30 Safety meeting with Group.

Subject Hotel fires and how to handle

2-13-81

42

Thu Feb 13.

temp -9°

800-1200

Work on new initiative ideas -  
Knives -

Group includes Jim Martin Chairman  
Tom Plunkett Sec -  
Bernard Hagen  
Frank Hart.  
Tom Bauman Legal.  
Doug Butler

1230 .XSG meeting

set up review for Joe Glas.

2:00 reviewed project with Joe Glas.

covered all parts of the much  
guns and also the contingency designed.

3:30 - 4:30

discussions with Clark &amp; Lami

2-16-81  
43

Mon. Feb-16, temp +25  
8:00 meeting - XSC -  
X0016 - no report. Tom Bannan out -  
Adam reviewed gas system and barrel  
strengths.

X0018.

9:00 - worked on development schedule.  
in preparation for 1:00 meeting; set  
up by Clark.

1:00 meeting on development schedule.

worked on schedules, etc. (Don't look good.)

Clark asked for a review of what we  
expect to be in the early guns.

meeting over with 3:30.

2-17-81

44

Tues Feb. 17, 81

temp 38°

8:00

meeting on XSG - XPG.

How X0016 =

X0018 - 3000 rds.

What will the baby guns have in them

1. XSG - Basic what we have now
2. XPG - Basic.

10:00 meeting in Conference room.

"Blue Sky"

12:00 -

12:30 - 3:00 -

reviewed Tracking System on 7400 -  
with Jack East and Al Eddy.

3:00 Left for Kingstons N.Y.

Z-18-  
45

Wed. Feb-18, 81

temp 45°

Spent the day in Kingston N.Y.  
meeting with Marketing on Blue Sky  
Ideas.

Received the 56 items we had.  
Marketing had a number of new  
ideas pertaining to guns -

2-19-81

46'

Thurs Feb. 19. 81

temp 38°

8:00 X86 meeting

X0016

X0018.

9:00 Claypool's designs 223 - col.  
aut. rifle.

11:00 Bolt Actions Designs

12:30 Claypool.

1:00 Bolt Actions Designs - Programs  
see notes in book.

3:00 Claypool. Design review.

2-20-81

2-20

47

Fri Feb 20, 81

Temp 51°

8:00 XSG meeting

X 0016 25, 022

Spring #5 3750- 14.05 13.4

Break Bolt. 20.

Locking B. 12, 595

X 0018 30, 185

Spring #9 6573 14.22 11.8.

2  $\frac{7}{8}$  magnus -

Locking System

1. Break Bolt. 5640 - Broken.
2. Actions Br. - 3700 -
3. Locking Block. crack.
4. Slide block. crack.



2-23

48

Mon Feb 23 81

temp 40°

800 XSG meeting

1. new design on A-3 looking block and slide block

10:30 meeting in Clarks office -

Development Schedule.

XSG/XPG

1:30 - meeting in Clarks office

Development Schedule

2-24

2-24

49

Plus Feb 24-81

8:00 XSG/XPG meeting -

find out how fast we can have XPG drawings  
ready for fabrications

Designs ready to release XPG -

8:45. m/7400 meeting.

2. 308 Guns delivered in my office by  
Bob Jay Zui (20)

These two guns have the following problems.

1. Bad Chambers.
2. Rifle die wrong.
3. Feeds from fore-end in the gun system.
- 4.

The remainder of the day was spent on

m/7400 - 7600 magazine box-evaluation

2-25

50.

Wed. Feb. 25

temp 30°

8:00 XSG/XPG meeting -

review of parts to be sent to be made  
XPG - parts -

Discussions on hooking systems

Review of Feed Systems.

9:00 - 1200

worked on reports for Product Reliability  
Colburn & Remington.

12:30 - 2:00

worked and got report for Clark.  
and Product Reliability Case.

2-74

5

thurs Feb 26

temp 31°

8:00 XSG/XPG meeting.

X0016: 500 rds.  $2\frac{3}{4}$  mag. added.total rds. 25,502 4,250 on Actions  
Spring.9:00 meeting on 7400 - 300 cl.  
Done  
Rock  
Al.

problems with functions.

10:30 Found Daniels in production with  
the primary extractors cut with  
lumps        causing fail to lock  
up on 270 - 7800's  
Showered to Clark - ans. - "what  
the hell got to do with it." - tried to  
explain (got nowhere). ? Parts  
are bad.

11:00

2-27-81

52

Fri 2-27-81

temp 25°

XSG/XPG meeting

X0016 no shooting - gun in lab -

XSG-/XPG. Port list. Complete less  
XPG - latch - etc.

12. Slide blocks returned to W.EDM.

model Guns.

Parts needed:

no.

9:00 Hot Sheet meeting  
Norm. Capoletta (Chairman).

12:30 new initial session -

discussion on knives and break up  
about 3:00 -

3-2-81

3-2-81

53

Mon 3-2-81

temp 28°

X56/XPG meeting

8:00. X0016 - shooting?

feed System - prototype works.  
Parts to be made.

9:00 meeting on XPG.

Parts for the model Shop.

Tom Barnard  
Jack Beauchard.  
Jim Martin  
Bob Savage10:00 meeting with Marketing on Bull  
Action Rifle.

11:30. Lunch - with marketing

1:30 meeting continued until 3:30.

3-381

54

Thurs 3-3-81

temp 18°

XSC/XPC meeting.

8:00 Evaluations of High Standard Auto -  
Bolt velocities look good.

Tom Powers - is setting up a XSC barrel.

Adam barrel, shot no results yet.

9:00-12:00

Time management. Seminar

1:00-4:00. -

3-4-81

3-Y  
55

Wed. 3-4-81

temp 18°

XSG/XPG meeting.

8:00 X0016 26,422 spring H<sup>05</sup> 5150Hooking Block 14,000 rd. -  $2\frac{3}{4}$  mag.

Bruc Salt. 21,794.

Feed Systems Tom Powers -  
Extract shell from Magazine.Adam Cgs Systems hole plugged.  
working on -

9:00 - 12:00

Time Management Seminar.

1:00 - 4:00

good. Course.



3-5-81

56

Chris 3-5-81

temp 21°

8:00 XSG/XPG meeting -

X0016 - staged  
spring #5 5170 - Total 26442Locking Block - 14,015 - 2  $\frac{3}{4}$  mag 2Breech Bolt - 21,814 - 2  $\frac{3}{4}$  mag 2Gas System - Cylinder - being run  
for new gas

Parts for 4 model gun -

Rec. week of 9th

all other parts will be ready

9:00 - 12:00

Worked on 700 guns - Phase 5 vs  
machine-link guns.

3-6-

57

Fri 3-6-8

Temp 20°

8:00 XSB/XPE meeting

X0016 stopped shooting

reviewed schedule.

9:00

↓

worked on assembly and with 20 new  
guns. for belt velocity functions.

4:30

Proved out that the functions (DBB)  
go with the actions box assemblyWe are now working with change on  
drive area. actions box sleeve.

3-9-81

58

Mon: 9-81

temp 30°

8:00 XSG/XPG - meeting

— (rec-) in the model shops this week -  
one receiver is to be ready - 13<sup>th</sup>

Call HGP on carrier - find out -

Board for Gas Systems bleed off. front  
(N. Standard) in shop should be ready  
to try.

review of Battle (Adams)

9:30 - 12:00

Stop II programs

interview/participants etc -

~~1:00~~

1:30

Balt Action R. files

meeting with Tammi - Clark -

John Brooks. get schedules - ready  
and set up meeting -

3-10-81.

3-10-81

59.

Tues 3-10-81

temp 30°

8:00 XSG/XPG - meeting -

bring up live ammo - R&amp;D test lab - policy,

1 Call H&amp;P on Carrier and feed latch

2(2) Receiver in model shop.

3. Detail drawings of new feed systems have been released to shop.

4. Gas System (front bleed off.) ready. should shoot to-day

5. Trigger Plate. parts - being completed.

6. Dry cycle machine for gun cycle run completions.

7.

8:30 Bolt Action Rifles -

- 1 788 redesign Safety Sol -
- 2 Scope mount - Fred -
- 3 M/7 - Fred.

9:00 Presentations:

Scott Strong on - Dry eye machine  
 Jeff Lawrence on - Pattern testing  
 Dave Hindley on Magazine box - 7800 -

60

thus continued.

12:30 meeting on m/d- 7400 project.

2:00 Staff Meeting -

1. Management Dinner 3-19-81
2. operations Committee 3-19-81' airport in - afternoon
3. Meeting on 3-16-81 Purchasing - Research.
4. Pre Op at 8:00
5. Pre Op at 3:00
6. Stop II at 9:30
7. March 16, Bolt Action Strategies
- 8. March 12, Development Schedule - 1:00

3:00 meeting on 7400 Productions Problems -

.308. DEB = 20.1 %

SOR = 15.1 overall monthly Ave.

PIR = 22.5

MFOP = 8.7.

next week .020 Spring will be in.  
Call for Smelter.

3-11-81

311

61

Wed. 3-11-81

temp 25°

8:00. pre-op.

Review of Status reports -

1. m/7400
2. m/4 Limited Edition
3. m/700 safety lever.
4. m/700 Bolt lock. → now off.

9:00 - telephone call. Bill Johnson.  
discussed m/4 - carbine - etc.

10:15 - Stop II program -

~~with~~ work as an observer with A.A. Hugio  
to 56-1 George Kennedy - reviewed -  
operator - etc.

12:30 - test lab for 7600 - worker evaluations.

2:00 review status for operations Committee  
meeting with Lami.

3:00

3-12-81

62

Churo 3-12-81

temp 20°

8:00 XSG/XPG - meeting -

- 1 Gas Systems in test - (H1 Standard T)
- 2 Parts for four model guns - 23rd
- 3 Carrier Call H&P many wall.
- ✓ fuel system parts in model shop -  
(v) action bar. Hong headster.

10:00 meeting with Production on  
the m/7408 - 270 cal - problems -  
also .308 -

Review given by Jim Smedley  
on the Quality Audits and for both  
270 and 30-06 -

Set up a meeting for. Tues. 3:00  
Smedley's office

1:00 meeting with Production on  
Development schedule -

3:30 - meeting on 270 audit results -  
m/7400 - project.

Fri 3-13-81

temp 34°

8:00 XSG/XPG - meeting -

1. Gas Systems on Hold -
2. Barrels in shop - 3" being completed
3. Currier fr. Heavy. wall.
4. Estimate time fr. XPG Parts -
5. Check about 3" - 5 shot - with marketing.
7. feed. - catches in r/p - tube being finished Action. var.
8. Asked for 10-12 m/1100 barrel assemblies be altered to our new gas system (re standard type)

9:00 Bolt Action Rifles -  
meeting on Bolt Tech.

Present:  
Carmi Capelletto  
Clark Workman.  
Jim Murt  
Fred Martin.

review of 7 different systems that have been made over the last 2 yrs.

In the discussion Clark made mention that Earl Larson did not like the shape of the new one as well as the old bolt plug - design.



3-13-81

64

## Bolt Lock Continuum

10:00 AM - We were asked to investigate a new design on the Plug.

1. to see if we can design like the old style and make out of investment casting.

2. investigate possibility of adding bolt lock in a boss type arrangement etc.,

10:30 Meeting on Purchasing policy

12:30 1. review of Carrier release latch (how it was handled)

Tomie made some good suggestions for future work with these animals

2. Curran Etching is a good example of how they operated.

3. Big Problem with H&P Die Stamping (I don't understand)

1230 new initiatives

Knives.

I was asked to Chairmen a group interested in making Remington Knives. We have now looked at and gathered info and have found out.

3-13-81

3-13-81

2m.

65

Continued

that the marketing personal. are working on the same project.

The group has voted to stop working on knives and has elected to work on wood splitters. the afternoon was spent on ideas and gathering info to start.

3:30. Bill Jenson called and I reported that the eight boxes made for Tracy are OK. we will send back to Amir Simmons the ones he wants.

3-16-81

66.

Mon March 16, 81

temp 28°

XSG/XPG Shotgun designs

800 meeting:

X0016 with new Gas System has been shot for bolt velocities. the results so far look good. additional bleed off holes are being opened up

Four Model guns -

2 receivers are complete from model. they need the top radius / maturing etc.

Gas system with air fire moved near completion. DF.

Trigger Guard - new safety locations trigger safety etc - looks good. Tom P

Dry cycle machine for bolt velocities - near completion - T. Power -

make sure the group knows about presentations - 3-20mi around the first of April.

9:00 Bolt Action Rifles.

review with personal to set up development time on M/700 A01-B01 etc.

Scope mounts - etc - needed one times -

3-16-81

3-16-81

67

Continued Mon.

10:00 meeting on XSC evaluations for processing -  
 Jim Bauer review listing on components.

11:00 - Tom Bauman fixed gas for the Glass  
 11:20 - Action leads - removed material  
 inside floor and straighten Action bars and  
 stow hammer where Action bar pick up  
 is

12:30.

meeting on Development Schedule.

The following personnel was present -

Research - J. C.B.W., J.B. J.M. T.C., J.G.

Marketing - 3 - J.P. B.F. P.H.

Plant - H.B. G.C. J.L.

The meeting went to 1:44 at which time  
 we had covered to items 8.

It is the ~~opinions~~ opinions of the writer  
 that no one knows what they want or  
 has any conception of time or how to get  
 a job done.

2:00 until 4:30

worked on mail box which we have  
 created a paper empire and it takes  
 a hr. out of each day to shuffle through.  
 I must be getting old or something.

3-17-81

68

Thurs 3-17-81

temp 17°

XSG/XPG.

5:00 meeting:

(2) receivers complete from Model Shop - / top rockets will be started thus

Cans will be assembled. week of the 23<sup>rd</sup>

2 Barrels with gas cylinder moved down here are ~~now~~ complete and will be shot 3-17-81 rifles at .062 (2)

3. Barrel with front bleed off system will be shot 3-17-81 for both velocities

9:00 review of Doves gas systems

10:00 Tom Bauman with Dick Nightingale setting up long (2") gas system (PROOF Barrel) etc.

11:00 Meeting with Adam.

2:00 Meeting Plant People. on m/7400  
308 nozzle change. AAH USM DF R&D  
Bob Day - Jerry Hill -  
Process.

Program -

nozzle change does not seem to change both velocities - Asked Production to make DCR Request for change

Continued 7:00 meeting -

Process is removing teflon coat on the  
head -. 270 -. 308

Process will run a sample lot of teflon  
bolts. if proven successful R&D will  
change.

Bruck Bolts with step drill in ejector  
hole to ~~remove~~ relieve gnd. in hole.

7mm Express Rem coming up -  
280 ammo a problem.

3:30

1 mail time -

4:30

→ 70

Wed 3-18-81

temp 10°

8:00 XSG/XPG meeting -

Stock Bobb. Joe Glass.

1 H Guns - scheduled. week - 23<sup>rd</sup>

new feed systems - May - ?

2 Gas Systems - Tom Powers - (bleed off -)  
Bolt Velocity -3 fire Control - champs made for Shooting  
test. drop test etc.4 Gas System - Dove Dindley - (moved down  
row -)  
Shot for Bolt Velocity.

9:00. Safety meeting with Group -

10:00 Review 7400 design performance  
with Clark, Jim Smalaker -

11:00 - meeting on Bolt Action Guns -

3-18-

3-18

71

Continued 3-18-81

1:00 meeting with Tom & Jim Bowers -

review work needed for XSG meeting -

set up model requirements etc -

3:00. Coffee break.



3-19-81

72

thurs 3-19-81

temp 28

8:00 - went to airport for XSB meeting -

showed the XSB objectives to Marketing.  
and explained the status of the the designs etc.  
Letter is to be sent to marketing for their  
approval.

12:00 Lunch -

1:30 Operators Committee Meeting:

Explained 788 safety design  
need two to three samples for  
marketing, review etc.

Explained m/7600 fore-end washer  
design - on order. should make sure  
we follow up on this design.

Chairman. was upset about functional  
performance on the m/7400 (Gallery)

If not straighten out recommend we  
shut down.

3-20-81

3-20-81

Thu. 3-20-81

Temp 17°

800 XSG meeting -

Explained to group about the XSG meeting  
at Airport Inn

items for discussion:

Barrel - new gas systems

4 model guns parts - ready for the week  
of 23<sup>rd</sup>.

9:00 staff meeting - fix the 7400 Amens -

11:00 - meeting with Lami -  
review what we are doing to  
fix the 7400's

12:30 same meeting -

2:00 -

2:00 review presentations

4:30 -

74

Mon: 3-23-81

temp 20°

8:00

Recurier. (6)

Top Radius - in N/C shop - today -  
Rec. should be completed by - this week

1. Seals for XSC - sent -
2. Pistol seat. torsion - heat shield -  
fired out -
3. Four for arms - to Arm Service - for -  
checking -
4. Gas System - Dove - bolt relocation -
5. Gas System - Tom - new barrel -  
work continued - bled off looks good  
so far -
6. Lock - Action bars in model shop  
new feed system -
7. XSC parts have been started in shop

9:30 - meeting 7:00 -  
done - for -

magazine boxes sent down to model  
shop for lip change - die to be  
made.

3-23  
81  
75

10:00 review mail -

note: minute #3 page-5- Feb 15, 1981

Paragraph: 3 Hunted Election  
model (4)

11:30 meeting on 7400 review of -

100 ad. / 100 gun test by Jim Snedeker  
feeding from the right side a major  
problem -

12:30 - 4:00 -

Shot gun at my house for free recoil  
m/58 vs. Calburn vs. Remingtons - C

4:00 meeting took place - m/7400 -

introductions Jim Maltz

Jim Snedeker - took place -

showed. Check -

3-23-81

76

② Stem Barrel - 3 and 5 rd. -  
alter 45° Chamber to Extensions

heavy Ammo - 50 lb. 3 and 5 rd.  
DLG - more on fire rd. always 2 or 3 rd.

1. Things to do - and who is responsible -

Jim Suckler - review gallery testing -

- 430 -

280 -

Copy of report - (10)

2. 7mm Tamaraut in plant -

Stems Barrel Gln.

magazine box positions.

meeting ended at 5:00.

3-24-81

77

Thurs 3-24-81

Temp 28°

8:00 XSC/XPC meeting.

1. Rec. cut top radius sample cut.  
To-day for model gun.
2. Colors pistols tooling, 3875.
- 3.

9:00 meeting 7400 -

ad Eddy. Dave Durdley, Lami Capelitto  
Adam August.

10:00. Plant investigations on Actions Co  
Assembly. Model drug figure and  
milling operations. Also found referring  
of magazine box lips. Both know what  
effect this might have.

12:30.

↓ worked on 7400 box problems and  
actions box evaluations.

4:00.

meeting in my office on 7400 with  
plant personal.

Rt D explained what their objectives  
were.

78

Wed. 3-25-8.

800 XSG - | XPG - meeting -

1. Rec. top radius 2 scarp rec. were cut - good one to-day..
2. Talons seal. - m/1100 - 14,000 - 1700 3" mag - heat factor
3. Drawing - complete for talons seal.
4. Gun Modeling show - charts - graph etc.
5. Fire Control Hovers Calkins - part - in shop airt outside vendor - - check purchasing -
6. Gas system, bolt velocity, still be evaluated Gons Power - -
7. Gas System - II barrels returned for. Parts -
8. update. Actions box to - see if - we can add slingshot to carrier dog notch - mark Cate -

9:00 meeting Tami office on 7400 production Areas -

11:52 - worked on. Court case -

4:00 meeting 7400 with Process Eng.

79

thurs. 3-26-81

temp 28°

Spent all day with attorneys  
on Colburn vs Remington <sup>Co</sup> Gun Crossman  
and Gerald Coley.

Also reviewed magazine for designs  
with H & P Die Stamping.



3-27-81

80

Fri 3-27-81

temp 31

8:00 XSG/XPG-

meeting -

Recurer - Shown. 6 complete.  
 April 3 - Radius complete - mill  
 and matt needed -

Slide block - Actions bar attachment.

Sliding Pin -

Buck Bolt.

Hacking Block -

week of 6<sup>th</sup> - for testing -

new fire Control - tons in test Lab -

new Carrier lock to be completed -  
 April 6<sup>th</sup> - maybe -

9:00 - meeting 7:00 - Done at self

Discussed change in dimensions of  
 recurer. Had marked up print etc.

11:00 hot sheet meeting.

81

1230-

made production tour to try and find out gages, fixtures etc.

also talked to assemblers about parts, gun assembly etc. there are still problem with parts.

4:00 m/7:00 meeting to solve problems

1. Rec. dimensions
2. magazine box -
3. measurement.
4. Assembly - ?
- 5.

Process - to remove undercut in barrel Extension feed on thrust.

Discuss feed cut in barrel Extension - back fast.

Check. proof rds. pressure 270 find out - 300. hold. 1200.

7mm - find out.

Three fire for to production 2 boxes -

82

Mon 3-30-81

temp 61°

8:00 836 Meeting:

Receiver - Complete by Fri.

1 Assembly week. of 6<sup>th</sup>

2 Barrel. Complete.

3. Stainless mag tube being made.

4 Aluminum. Rec. Blanks - will  
ream

5. Gas System Adam ? dirt - and etc.

6.

9:00 review of 7400 problem areas.

10:00 reviewed Gauge - tool rooms, Joe Bates  
(John Humphrey)

1:00 meeting with Tomi on 7400  
Don't understand any more.

3:00 heard that Ronald Reagan was  
shot - and these other people.  
and this explains what the  
conspiracy is all about -

3-30-11

83

4:00 7400 meeting -  
Present.

Questions - tool room gauge - well - with here.

Phone 1 Box - in so report - on:  
box does not look good. -

Called R&D and. will have boxes  
by - wed -

box bottoms galled - needed -

add 28° to sleeve DCR. complete -

filing in side looking tops of Barrel  
extensions - check sample - with products

Bruck Bolt - thru hole -

Too needed 7mm don't make them

Three changes in the work -

1. Bruck Bolt -
2. 28° 29°
3. Sleeve -

3-31-81

84

Plus 3-31-81

temp 60°

8:00 XSG/XPG meeting

One gun shown with partial Assembly  
 (6) guns now are ready for assembly.

serial XSG - 0021 - 0027

Cars Systems Bleed off ready (2) - to-day.

2:00 meeting with Process. SD Vermin? Com  
 308 - 5025 -  
 Bot Problems..

4:00 meeting on 7400.5

People: Chel. Dennis - 1 crack you and.

Cover -

magazine box - 7mm  
 use 308 - and it works in 7mm -

4-1-81

4-1-81  
86

Wed. 4-1-81

800 XSG/XPG meeting.

Fit model Guns -

Short meeting - -

8:45 - m/9400 testing on the hill.  
9:00 -

test will involve the 100 gun test -  
 5 guns that shot clean in the  
 locks and 5 guns with feeding malfunctions.  
 will be shot on the hill.

4-2-81

86

Thur. 4-2-81.

temp 41

8:00 X86-/XPG- meeting -

Guns - being completed -  
Assembly 4-6-81 -

feed System - magazine tube -

in. shop - Spring - 4 guns will  
be set up for this system.

Core system - ready to shoot.

9:00 m/7400 review -

Look at new gauge for magazine  
bot -

Inspected fire Controls -

1:30 Hot Sheet meeting

4-28

87

4.00 meeting -

new gauge report - Bob Joy -

two gauge now complete -

Bob has set up "O" reading gauges -

found 5 "O" pipes .

4 boxes 4 gms. - fired -  
with - "O" gauge. boxes - 1 reject.  
out of 120 ads. -  $\pm 1,001$

feed ram cut . .

H&P Boxes and. time 4-8-81.

Process and Resend. to go out  
and take gauge and. go over tooling

Check H&P. follow lip - hold - 012  
no.



83

Fri April 3, 81

Temp 65°

800 XSG-/XPG meeting.

Assembly 4-6<sup>th</sup> (6) Guns -

new barrel for Gas System. pressure vent -  
proof etc - to-day for testing -

Sheet p/rap barrels set up on (2) of the  
6 guns -

9:00 worked on 700 project.

Plant - assembly area. reviewed  
what the posts are etc.

1230 meeting with Clark on 4 guns  
test. 7 min - on the hill -

Guns were shot with standard  
magazine boxes and new boxes  
adjusted to the new gauge.

The guns went from 17% with old  
boxes to 2.9% with adjusted boxes.

Fri. 4-3-81

1.00 worked on Court Case

Colburn vs Remington -

test conducted was a S&W .58 in free  
recoil from a vertical position

It was conducted at Jim Martin's  
house - in back yard.

Vidco tape was set up and we  
had three takes.

The gun fired from about 6" off the  
ground, hung by a rope - the trigger  
was about 4" and the gun did not  
function.

In all the testing we have done with  
the (.58) in free recoil we have placed  
a dummy rd in the magazine to see if  
the gun would function - and feed the  
next rd. - this has not happened.

4-6-81

90.

Mon 4-6-81

temp 32°

8:00 XSG/XPG - meeting -

6 model Guns -

1. Guns are in color and will be out to-day -

2. Planned Assembly is for starting to-day and to-morrow -

3. Gas System - Tom Powers - will be shooting to-day

4. Fire Control test complete waiting report -

9:00 Had a meeting in test lab to review the video tapes for Calburn Case.

10:00 Went up on the hill to observe shooting 7400. Spectator test. did not see that much -

11:00 Discussions with Tami on work - have a meeting set up 9:30 4-7-81

2:00 Review 7400 feeding problems with Bill Johnson on Ph.

Called Doyle Long and discussed some problems he is having. m/c - 270 cal. and some 30-06. - Looks like he has some bad boxes.

46-81  
91

4:00 7:00 meeting - Design, Process & Plant.

Present: J. Hill A. Eddy D. Rinday  
B. Joy J. Lind? G. A. Hugick.

Review status - g - reform boxes.

7mm - 8 1/2 - Huston Box 3 systems

The present situations does not look that good. We are now looking at gun problems - more than the magazine box. However the magazine box remains the largest problem.

4-5-81

92

Tues 4-7-81

Temp 31°

XSG-XPG meeting.

800 1 Rec. fr. 6 guns. Color to-day -  
 Stocks wed, fore-end ready.

2 Gas System. 1 ton Power. Gas bleed off.  
 incinerator dia-forward. re stock to-day.

8.

900 7400 meeting alone & Albert. & Allen -  
 discuss magazine box. what to do -  
 the problem is getting bad

2000 Pre Op-

4:00 - 21/4 - meeting -

4-8-81

93

Wed. 4-8-81

temp 45°

XSG/XPB - meeting

8:00

Parts for 6 model guns-

1. Receivers - 4-8-81
2. Stocks - 20 by - 4-9-81
3. Fore-ends. Complete (4).

Set up slides for Planning meeting,  
April 27.

Also make sure we have <sup>2</sup> model  
guns in good working order. Steel & trap-  
by that time.

4-8-81

94

4:00. 7400 meeting -

H&P magazine boxes to gauge (model diag)  
will have. Bird & Dove mon - Tues -

20 boxes without any adjustment -

R&amp;D to field test 30-06 -

100 boxes and.

Pin Holes - were one we. ?

4-9-81

95

Thur 4-9-81

temp 61°

8:00 XSB-XXPG-meeting.

1. 2 model guns have been assembled.
2. 2 more will be assembled -- to-day.
3. First made of component part and  
nutruct spec.

Plans will record all revisions made to  
assemble model guns.

5.

9:00 meeting on 7:00 - R & D.  
at Jack. Dove - Adams.

11:00 meeting 7:00 - R & D.

Lock. Kost Plan McCormick to work on.  
Chamber - to correct.

1:00 - 3:00

Willie tope the Colburn vs Pen. Case.



96

4:00. m 74.0 meeting.

1. we are putting up 100 Cans -
2. new magazine boxes. (Special Select Lot)
3. boxes have been set to gauge
4. all boxes have good followers
5. Cans will have #2 latch
6. magazine springs have been selected.

There is a need for a screw in the magazine cap.

4-10-81

410-  
97

Fri 4-10-81

temp 30°

XSE - XPG - meeting

1. model shop priorities
2. Jane Gun's (complete) -

9:00 7:00 meeting -

worked with plant - on problem areas -  
barel Ext. chamfr. etc. / process

4-13-81

98

Mon April 13-81

XSG /XPG-

800 meeting.

Take Guns to model shop & guns  
head space cliff.

meeting short. because of 7400 testing.

9:00 testing on hill.  
7400's

3:30 m/7400 meeting -

Report - by Bob Day.

100 gun test - 37 of each STD & Special  
have been shot - new boxes.

30-06 box will be run only -

HP boxes will be in there.

win Pin Clearance cut in wood. Production  
will evaluate RPD to give them a drawing.

Epstein Pin hole - there - test for strength.

4-14-81  
99

Plus April 14, 81

XSO/XPS meeting

1. 4 model guns - being set up for test lab -  
Guns will be ready 4-20-81
2. Parts for (2) Guns - Buck Bolt check -
3. Slides for presentations -
4. Action Spring for 2" down bore - needed.
5. Spring for bleed off - down to purchasing -
6. Gas System. Ross Power. - new 8 hole bleed off -
7. magazine tube - for - new feed system - J. Kast.

4.00. meeting -

new boxes in Perry Hills office -

Questions how to gauge and we do not expect boxes -

4-15-81

100

Wed. 4-15-81

temp -50.<sup>o</sup>  
To

thur. 4-16-81

both days spent on Colburn vs  
Remingtons

made trip to Maryland for  
depositions with L.S. Martin -  
Calley and Britnell there

4-20-81

4-2081

101

Mon 4-20-81

temp 33°

XSG meeting:

8:00 4 model Guns.

Schedule made up for July Guns -

Schedule also set up for 25 guns  
to be made in Sept. 81.

The 4 guns will be measured and tested.

9:00 m/7400 meeting.

3:30 m/7400 meeting.

20 Guns put up with new magazine  
boxes from H&P Inc. C. -The results looks about as good as the  
boxes adjusted to the gauge.100 more will be run through standard  
production guns and gallery test.

4-22-81

102

Tues April 21

temp 22°

XOB meeting -

4 new model guns are being prepared  
for the test lab -

Report on testing to be forwarded to  
Tome and Clark for review.

4-22-81

4-22-

103

Wed. April 22-81

Temp 20°

X86. meeting.

Slides for April 27 meeting - need  
to have them by Fri.



4-23.  
104

Thurs April 23

8:00 - no meeting -

Problem with Employee (Muel Porter)  
I had to take Muel to Marcy State  
and have him admitted. - this  
took most of the morning -

1:30 - worked on m/7400 project.

3:30. meeting with Process Eng. and

Research - reviewed magazine list  
from H.P. and also John Trickle  
had a number of items for review -  
See (Ref notes.)

4-24

105

Fri April 24.

Jim XSG-/XPG--

Worked on Slides and Presentations for  
Bridgeport.  
most of the day.

5:30. short meeting on Hoo.

4-27-81

106

Mon April 27-81

Temp 40°

meeting in Bridgeport on XSG- / XPC-  
planning -

Presentations on Designs in Bridgeport

I think it left a lot to be desired

3:30. M/7400 meeting - B.J. J.H. D.F. B.B.  
 A.H. J.S.G.  
 1. 270 Rept. needed - A. Eddy

4-28-81

4-28

107

Rus April 28-81

temp 45°

8:00 XSG/XP6 meeting

4 model Gans - for test lab -

review of presentations and reported to the group what went on in XSG planning meeting.

10:00 - Review presentations with Ed Potter -  
Computer modeling -

11:00 made a report out to Al Eddy.

4-29-81

108.

Wed April 29-81

temp 55°

8:30. XSG/XPG meeting

Meeting Held in Conference room.

Slides were shown to group with comments explained changes needed etc.

Review presentations

only slides needed -

Tom Bauman made list.

Jack Best will do the feed system slides.

10:00 write up on John Remington  
Lab Microphones

write up on work load -

2:30 Presentations to Staff -  
↓ Ed Yetter -

Don Prosser -

4:30. Sal Tanelli -

4-30

4.30

109.

Thurs. April 30

8:00. XSG/KPG meeting.

4 model Guns. where are we.  $2\frac{3}{4}$ " Change. 3"

(a) they are now in the test lab-

(b) Proof to day.

(c) spring change for 4 shells in.

9:30 Medical. Physical.

3:30 m/4400 meeting -

1. Rec. - J. Hill -

2. Trigger Clearance. - Jerry Hill at up meeting -

3. 308. open on fire. 125 maggel.

4. Debus board Extension -

5. Magazine -

6. test lab. on magazine box. clearance -

7. Brozini Problem -

8. 308 trail/hold -

9. follow-up change -

→ 10. magazine box Program needed - write up -

11. Bot - needed - that's - Owl -

12. -

5-1-81

110

May 1  
Fri April 30

temp 35°

XSB/XPG meeting -

1. 4 model Guns -

air pressure dia 055 (1)

ave. turn. 285 -

control sample.

2. review carrier latch Kevin Collins -

9:00 - model 7800 Blow up problems with  
new spec hose in Bolt Ejection hole -4  
3:30 - m/7800 project meeting -

Discussed Magazine box problems -

5-4-81

5-4-81

111

Snow May 4.

Temp 35°

8:00 L model guns will be shot up at the  
Fish & Game Club - to-day - ?

8:30. meeting on m/700 cost program - -

11:00 meeting on CCG status -

Ed. Yetter -

Hern Culkins -

12:30.



5-5-81

112

Tues May 5, 81

temp 45°

- 8:00 1 4 Gun on the hill today -  
2 Gas cylinder - model shop -  
3.

9:00 meeting Lami office -

10:00 meeting Conference Room  
7400 strength test -

1:30 meeting on Personal needs -  
budget, etc -

5-6-81

5-6-81

M3

temp 60"

wed.

8:00. X86/X86 meeting  
test results.

9:00 m/700 improvements

330 7400 meeting!

23.9. 30.06..

now. 11.6

114

Thru April 7, 81

Temp 32°

8:00 meeting - XSG - / XPG -

4 Guns. shot. results being tabulated

9:00 medical second part. Physical.

11:00 Presentation: XSG/XPG -

1:30 Hot Sheet:

3:30 meeting on 7400 - Process &amp; Research -

review gallery results. 30-06- 360 guns -  
tested 20 reject - 5. percent - good -

went over sheet prepared by Bob Joy -

Good meeting and the gallery results.

5-8-

115

Temp 28°

Fri May 8

XSC - meeting  
Review testing of model Guns -  
result - 8 of 10 .54 percent m/1100 -

malfunctions were -

1. Failed to connect
2. Failed to Feed.
3. Don't Blow Back.
4. Don't Eject.

Corrections

1. =

5-11-81

116

Mon May  
April 11,

Temp 60°

800 XGB/XPB meeting -

Four model guns.

Guns have been adjusted to the feed plugs  
and also found was a burr on the disconnect  
tail.The bolt relocators will be taken and it is  
planned to gun the original one drill size  
and rehook -

10:00 XGB - Schedule model shop work -

need. Schedule for 50 guns - 25 each  
see Report - Dated 5-11-8111:00 meeting in Clarke's office - CCB's assignments.  
Kevin Calkins - Test Lab - 6-1-81  
Ed Yetter dr. - Test Lab - 5-18-81

3:30 meeting - 7400

Barrel with large dia counter sink -  
found .693 max. over by .003Cone Saunders to check Helix action bolt.  
check cam cut in bolt - 3 machines -  
Extractors - what to do -

overall Gallery rate - 7.7.

100 rapid. 20 DX - 20 mag/box stamp.

Good rate -

5-11-81

717

Call Brad - to review extractor thickness  
.022 -.018 - three size -

25. Break Bolts - all to Bob Joy -  
1. Check Run on phase I guns -

270- Customer guns - returned OK -

Setup chart for customers

5-12

118

Tues May 12

temp 65°

3:00 XSB/XPB meeting -

Four model guns will be shot on  
the hill - full cycle page.

9:00 XSB - Presentation -

10:00 -

5-13

119

Wed. May 13 -

temp 50°

→ went to Bridgeport for XSB  
dry run etc. Planning, meeting -

XSB 3" may guns shot again -

Results - to morrow.



120

Thurs May. 14,

temp -

in Budget

KS6 Presentations to top management -  
review. Base Case -

Questions about timing - ?

Fri. May 15, 81

temp -

8:00. XSB meeting.

Review of testing XSB Shotguns.

Control Bows

5-18-81

122

Mon. May 18-81

temp 30°

XSG-XPG - meeting -

815

11.15 Left for Houston Texas court case -  
Calburn vs Rem -

Tues May 19-81 = Calburn vs Rem.

Wed. May 20 81. Left for Chicago  
Pindle vs. Rem.

Thurs May 21.81 Pindel vs Rem.

5-22-81

Fri May 22, 81

temp 50°.

XSG-XP6 - meeting:

11:00 - 7400 meeting -

Extractor:

magnetic Gauge.

5-25 -

124

may 25 — may 29 - vacation  
 this Page - out -

mon:

tues: went to Texas on Calhoun vs Rem.,  
 Hutton & Capeletti -

wed: went to Chicago to be a  
 witness in the Pindell vs Rem.

thurs. in Chicago Pindell vs Rem

Fri returned to Ills -

Vacations -

6-1-81

126

Dane. 1 Mon.

attended Burger Writing Seminar



all day.

June 2 Tues  
attended writing Seminar

all day -

6-3-81

128

Wed June 3, 81

8:00 XSB-meeting :

Housekeeping,

Review of Project where we are etc.

Discussions on stock bldg. and  
operating bundle.

Management does not like the design  
the way it is.

9:00 m/t Limited Editors 7:00 etc.  
meeting.

Discussion on where we are.



6-5

129

in June 5-81

XSB - meeting -

Clean up - etc.

Tom Bauman gave a report on the  
testing and parts in the shop for July  
guns and 25 in sept.

n/7400 meeting.

**BARBER - PRESALE R 0137172**  
R2538160

6-8-81

\*

132

Mon. June 8, 81

temp 50°

8:00 XSG meeting:

12:30. Shooting on the hill - this morning -

Comparison test conducted between  
XSG - 12643" and m/1100 same -

3:30 m/7400 - m/4 - meeting -

discussion held on items to be worked  
on.

6-9-81

133

Thurs June 9-81

XOC meeting -

review testing results -

we need the changes.

- more magazine exposure
- fore-end closed is on top -
- lighter action spring (closing velocity)

330 Beg. wheels come around -

6-10-81

134

Wed. June 10

temp 60°

XSC meeting.

Discussions on Prototypes - dates etc.

Gun on schedule -

Sheet boards are being made.

6-11-81

135-

Chur. June 11-81

500 XSG meeting

100 7400 meeting strength testing

1. items -
- 2.

6-12-

134

Jm.

June 12, 81

ten 3 60°

XSG - meeting

revised testing  
 comparison test - M1100 - vs XSG -

100 tested 3" mag on hill -

XSG - M1100 -

there is a different feeling  
 between the XSG & M1100

new springs are going to be made.

6-15-

137

mon June 15, 81

temp 65°-

XSG meeting .

Review testing =

Review Cons in Process-



~~6-16~~ 6-16-81

138

Tues June. 16, 81

temp 74°

X56 - meeting -

Hookin, Blocks - Complete by 22<sup>nd</sup>

New feed Systems - Ready by -

July. 6<sup>th</sup>

7400 - Project -

release of M/6 - M/7600 - testing to be  
done by. Productions R&D will  
wait for results -

To Date no trial of Pilot test have been  
conducted on the Pump Cam.

12:30 writing Seminar.

3:00. Pick up Markle - Carter.

6 -

139.

Wed June.  
XSO - meeting.

1,456.00

1230 Burger. Course

- 288 -

140.

Cher June 18.

X86 - meeting

Set up shooting test.

Monday.

12.30 Burger Course  
↓

Thu June 19

XSO - meeting

1. Buck Bolts - Change XPb.
2. Gas System for 3" Guns. Zourek.
- 3.

6-22

142

Mon June 22-81

Temp 65°

8:00 XSG meeting

Review status and set up date  
for shooting on the hill.

9:00 - Made out monthly Report.

143

Thurs June 23-81

Temp 57

800. xsg/xpg- meeting-

866-1330

hooking Block. -

rfe. should be complete to day-

(dent treat.)

Spring - raise level. work.

900 m/700 meeting.

330. meeting with tami

6-24

144

Wed. June. 24.

Temp 46°

X86. meeting :

Call George Jackson - Tom Bauman

wrote. Clark letter on Personal. X86 - XPG - H.P.X.

1:00. Shot w/700 375 mag.

Thurs June 25

temp 62°

XSG meeting:

Two new Gun. assembled.

Locking blocks in model shop - -

Disconnection change - "hook interlock"

Carrier latch.

Action Boxes to heat treat JTCR.

9:00, Fire Control 7/00 -



146

June 26 Fri

XSG meeting -

2 new XSG are to be endurance  
tested

6-30 ©  
7-1 147

Mon June 29

Tues June 30

Wed July 1

Spent most of the time on AIT report-  
for the m/7400.

7-2-81

148

Charg July 2

temp 65°

no meeting on XSE!

endurance testing being completed  
to 2000 rds.

149

Fri July 3, 81

temp 68°

XOG- no meeting

2000 rdr endurance complete -

problems with

7-13

150.

Vacation July 6 - 10 - Temp 71

July 13, Mon.

8:00 XSG meeting

testing 4 guns (XSG) now at 2000 will  
return for testing to-day.

Problems - Areas:

1. one action bar. broke.
2. Carrier latch took bending  
one broke in adjustment.

9:30 model 7400 meeting.

270. Cal. new problem - proof ammo -  
high pressure - blow up - s in plant -  
perce primer. etc. -11:00 Scope mounts  
meeting - to

2:15 7400 meeting R&amp;D &amp; Process Eng.

Review items and 270 performance

151

151

Tues July 14, 81

temp 68

8:00 XSB meeting.

1. Endurance guns.  
1- no shooting-
2. Eight new Guns -  
start assembly - -
3. 25 new Guns. =  
some parts returned.
- 4 (2) Guns for Bridgeport. near completion -  
test Lab. Today - 7-14- - X0021 - 26

9:45 Completed telephone conversations  
with Bill Parsons 45 min.  
m/7400 - 25-06 - 7m-08 -  
do not want new caliber for next  
year - may want m/4 -

Amited Editor have sample ready by  
Sept. Operations Committee -

7-15  
152

Wed. July 15, 81

temp 60°

800 XSC meeting

2 Guns for Budgetary.

Set up as Sketch and Mag.

2. XSC - 2 n/1100 endurance test.

7-16

153

Thru July 16.

800 X56 munit (-

2 <sup>X56-</sup> Endurance gun at 3000  
2 m/1100 guns at 3000-



154

Thi July. 17. 81

186 - meeting

no activities on endurance guns.

155

(1) Mon July 20,

temp 65.  
rain -

8:00 X86 - meeting -

1. monthly staff notes -

2. 2 Guns for Bridgeport have been shot  
for Bolt Reloc. Tr - need further info -  
the bolt velocities are off -

154

Tues July 21.

800 X80 - meters -

Report by Tom Baumert.

Wed. July 22

8:00 XSG meeting  
no shooting -  
Bans are ready -  
17 cal. two top priority  
Govt understand -

158

Chap July 23

temp 70°

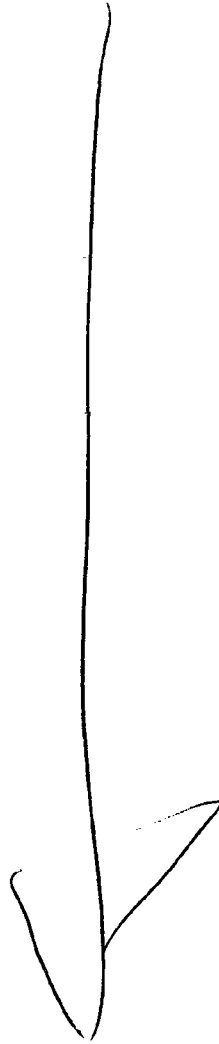
800 XSC motor -

Starting on the hill -

Two Street Cars  
two of the 4 cars -

Vactions -

July 28 — Aug. 17



New Book -