2006 New Product
M332 Small Gauge

- Small frame 20 gauge
- Frame to accommodate 16 gauge barrels
- Stock dimensions-trimmed down version of 12 gauge
- 26" and 28" Barrels
- Steve Perniciaro and Dave Findlay have drawings
- Need to examine ways to build low volume items efficiently
- Investment cast-brings some new issues and solves others
- Have to improve cost, efficiency and quality
- OBJECTIVE: To announce 20 gauge M332 on 2006 Spring Gun Program
- Brad Howard presented current design at March 2004 PTM. Status and timelines to meet August 2005 announcement
- Parts out for prototyping. Ilion to assist with assembly. Guns assembled mid-May.

Ilion Quality – Shotguns

Shotgun POI

OBJECTIVE: Conformance to SAAMI spec

ACTION: Ilion to provide status of this project. Priority of shotguns in which to incorporate these changes first:

1. All 1100 Target, 1100 Classic Field and Synthetic
2. 11-87 Premier and SP/SPS
3. 870 Wingmaster and SPS
4. 870 Express
5. SP-10

Findlay presented prototype of proposed new rib design to bring our POI in line with SAAMI.

- Tooling & Gauging to be complete by June 2004
- T&P Scheduled September 2004 for 870/1187

Will run current barrels vent ribs with smaller front bead. Smaller front bead raised POI 6". This may resolve issue and would be more desirable than converting to a new rib taper.

11-87 Super Mag

OBJECTIVE: Determine necessary changes to make this product to the performance requirements as originally specified.

Action: Engineering to provide update on design recommendations and timeline for implementation. What testing needs to be done and when can we expect to make the transition in production?

Findlay presented new gas collar design to give a better seal.

- (10) 12 gauge barrels in test with new design
- Objective to reduce 3" & 3 ½" terminal velocities and improve function
- Testing to be completed by 2.15.04
- MIM , gas cylinder prototype-10 weeks and $15K
- 30 piece 12 gauge machined sample to transmit April 30, 2004

ACTION: **Report on test status**

- **Range of 350 Max and 150 Min. Still testing different gas cylinder designs.**
- **By 3.30.04 start MIM Gas Cylinder**

MIM Gas Cylinder made no statistical difference in terminal bolt velocities.
Surface finish on internal moving parts. Concern expressed that finish is not comparable to where finish was at 20 years ago.
Action bars, hammers, gas cylinders and check barrel alignment.