

Section E

History of "Trigger Adjustments"

Customer's
Inquiries

Beagle's Sporting Goods
133 S. Richard Street
Bedford, Pa.

January 27, 1958

Dear Mr. Beagle:

Your M/40X Trigger is being shipped by Parcel Post first class today. It is a new Trigger which has been readjusted. It is adjusted with its slide engagement as will hold the rifle in a cocked position. For this reason it will be necessary to prevent accumulations of dirt or gummed oil from collecting in the mechanism. I have found that Hoppe's No. 9 is a useful solvent in removing these accumulations. If properly cared for the setting should last for a long time.

You will soon find that slave pins are used in the assembly. This is done to ease the assembly to the receiver. The slave pins are driven out by the regular pins during the assembly operation.

Let me know how you make out with this one!

Sincerely,

M. H. Walker, Supervisor
Design Section
Ball Research Division

MHW:NL

TOM ADDISON'S GUN SHOP

SPORTING FIREARMS SALES AND SERVICE

Phone: 847-4566

KISSIMMEE, FLORIDA

Sept 13, 1969

*Copy for
Got
Buck
Pencil
G.L.S.T.*

Mr. M.H. Walker, Research Division
Remington Arms Company, Inc.
Ilion, N.Y.

Dear Mr. Walker:

Will you please give me a couple of minutes of your
time ?.

We have to SET almost every TRIGGER on the Model 700
and 660 that goes through our service dept. These Triggers come from the
Factory - Running from something like three - lbs. to near EIGHT LBS.

Surely - Remington - Expects - These - Triggers to be Adjusted to something
Like 4-lbs. (Good hunting average.) Trouble is - here of late - models - some
- Shut up at the Assembly - Line is STAKING PART - THE SCREWS - Then the SLOT-
SIMPLY BREAKS OUT and you have a 8-LB TRIGGER or DO NOTHING ABOUT IT.
Most of them are simply - DOPED to hold them from tuning - which is very good
but - staking them is quite - off base ?.

I have one here before me - Staked on both sides - Freezing the screw - where-
by - We had to borrow a trigger off another rifle - in order to complete the
Scoped - Model 700 - 7-MM Mag. which is going to Wyoming on a hunting trip-
THIS HUNTER WOULD BE TERIBLY HANDICAPPED WITH A 7-POUND PULL ON HIS TRIGGER-
We Re Bed and tune these rifles to group in ONE MINUTE OF ANGLE - BUT A SEVEN-
POUND TRIGGER - would ruin all our effort.

What shall we DO ?. Shall we be forced to carry a couple of TRIGGER UNITS -
Ready to replace these STAKED ONES ?.

Other-wise We have to DRILL OUT THE SCREW and Replace it - which is an HOURS -
WORK. and in RUSH TIMES THIS IS QUITE BORESOME!

This morning I have a Gun with No Trigger Unit- Simply because - Some one -
Goofed! - - Surely One of the Epoxy - Products will hold These Screw- Heads -
No STAKING IS NECESSARY - Without you set every Trigger at 4-LBS. Even then-
They often Loose half this Pull the First Year they are used - So They would h
To Be RE-SET.

Mr. Walker - Whats the Answer ? - In selling - we tell the customer - the tri
is adjustable and Crisp ! - Then We can't Produce! - Without All this Unnecess
Work: - Allen Head SCREWS - Are The Answer - But Can you Afford to make them
Perhaps you can answer this perplexing headache.

Most Cordially,

Tom Addison

WE ARE DEDICATED TO YOUR HUNTING AND SHOOTING PROBLEMS

REM 0095861

LUN 0027196



REMINGTON ARMS COMPANY, INC.



MANUFACTURERS OF
SPORTING FIREARMS, AMMUNITION
TRAPS TARGETS
POWER TOOLS

SPORTING FIREARMS
POWDER METAL PARTS
ILION, N. Y.
AMMUNITION, BRIDGEPORT, CONN
POWER TOOLS, PARK FOREST, ILL.

ILION, NEW YORK 13357

PETERS CARTRIDGE DIVISION
BRIDGEPORT, CONN
TRAPS AND TARGETS, FINDLAY, OHIO
CABLE-HARTLEY, BRIDGEPORT
—ALL CODES—

September 17, 1969

Rec: S.M. Alvis

L. Fox
L. J. Boyle
G. S. Parkett
W. J. Scott

Tom Addison's Gun Shop
Kissimmee, Florida

Dear Tom:

The staking of trigger adjusting screws is something which has been added without the sanction of our designers. We have recently been running into trouble ourselves.

I will make every effort to get triggers adjusted properly and eliminate the staking.

Your letter will help!

Sincerely,

M. H. Walker, Manager
Custom Firearms Development
Ilion Research Division

MHW:ml

REM 0055860

LUN 0027195

cc: M.H. Walker

W.E. Leek - R. P. Kelly - File

Ilion, New York
February 22, 1972

L. FOX

MODEL 700 FIRE CONTROL - Trigger Adjusting Screw

In working with your people regarding the interopatory incidental to claim of personal injury by Thomas J. Brown, a suggestion has been made by M.H. Walker. We were examining several different fire controls including one from assembly and believe that the method of sealing can be improved. The present coating that is used over the head of the adjusting screw is relatively easy to remove or loosen. Walker thinks we could go a step further and use the red Loc-tite material, which will more permanently do the job.

As far as I can see there would be no changes necessary to the gun standards, but perhaps you may need to change the material specification if there is one in your process records.

S. M. Alvis, Manager
Ilion Research Division

SMA:T

REM 0095859

LUN 0027194

To R. P. KELLY

DATE February 21, 1973

FROM S. M. ALVIS

MODEL 700 - INSTRUCTION FOLDER

M.H. Walker has requested change to the folder to indicate "No Trigger Adjustments Are Recommended".

This is in accordance with his consultation with F.E. Morgan. It is understood that the need arises as result of significant increase in customer complaints of problem growing out of attempts to adjust trigger by shooters. The designers believe this condition arises as result of differences in parts as compared to earlier production, with the sear being a contributor.

M.H. Walker advises that F.E. Morgan desires to see proof copy of the folder change before printing, and advice as to inventory in terms of usage requirements and inventory cost in order to determine whether this should be made without obsolescence.


SMA:T

cc: M.H. Walker
F. E. Morgan



DON'T SAY IT—WRITE IT

TO S. M. ALVIS

DATE February 21, 1973

FROM F. G. HART

SUBJECT MODEL 700 GUN OWNER'S GUIDES

M. H. Walker has suggested that present copy instructing adjustment of trigger be substituted with following:

"TRIGGER (Fig.4) — No adjustment of trigger by the owner is recommended. Trigger pull has been factory adjusted. Should any adjustment be necessary return rifle to factory or see a Remington approved gunsmith."

The question arises as to whether the illustration (Fig. 4) should also be deleted.

As of this date, there are 6,725 copies in stores, representing approx. \$2,000. Reorder date is next month.

F. G. Hart

F.G.Hart:B

Ilion Research Division

CC: R. P. Kelly

M. H. Walker

F. E. Morgan — Bdpt.

PLAINTIFF'S
EXHIBIT

3075

TO BE SAFE: FIRST THINK YOU MIGHT NOT BE

AL 0022828

1 of 1

cc: E. J. Giner
E. S. Cipcer
E. G. Larson

Bridgeport, Connecticut
February 22, 1973

TO: S. M. ALVIS
FROM: F. E. MORGAN
SUBJECT: BOUSTEAD WOOD PTY. LTD.
THEIR LETTER OF 2/9/73

A prompt reply to the attached letter from the subject concern should be made by someone from Ilion via the International Department..

The Model 700 instruction folder on page 2 and captioned in bold print TO ADJUST TRIGGER -- tells the shooter in detail how to make some very technical adjustments to his Model 700 trigger. In fact, the copy actually invites him to make these changes.

Earl Larson points out that we should be more cautious and perhaps rewrite this portion of the folder. I certainly concur and suggest that we also delete the figure 4 drawing.

FEM/bc
att.

P.S.

Since dictating this letter suggested copy changes have been received as the result of a telephone call to Mike Walker earlier this week. The composition in Frank Hart's letter of February 21 is satisfactory and should be incorporated in the next printing of the folder.

PLAINTIFF'S
EXHIBIT

3099

AL 0023545

1 of 1

DESIGN CHANGE REQUEST (DCR)

LEWY

DCR

10899

Sheet

1 of 4

~~TRANSMITTAL OF DRAWINGS / PARTS LIST~~

PARTS LIST CHANGE NOTICE

Requested By	Changed By	Date
MARKETING	RLS	6-7-79
Originating Date	Transmittal Date	
	6-13-79	

Model	Part Name / List	Drawing No.	Part No.
700 LH	TRIGGER ASSY LH	D-32895	32895
40XB	" "	D-27590	27590
541-S	SPRING	A-14501	14501
40XC	SPRING	A-14634	14634
XP-100	SCREW	A-15469	15469
40XC	SCREW	B-90568	90568

Dwg. No.	Rev. No.	Design Change
D-32895	1	CHANGE TRIG. ADJ. SCREW TO TRIG SCREW FROM
D-27590	5	" " " SPRING " " SPRING "
"	6	" " " BALL " " BALL "
"	7	" " " SCREW " " SCREW "
A-14501	4	" " " SPRING " " SPRING "
A-14634	3	" " " " " " " "

Classification of Change

- () Functional Change
 () Safety Mechanism Revision
 () Appearance

NOTE: Any or all of the above changes to current models require approval of Operations Committee and approval of DCR by Div. Manager. On models NOT IN PRODUCTION, the above changes require approval of Div. Manager ONLY.

(✓) Other



Designer Signature

Reason for Change: PART NAMES WERE CHANGED TO ELIMINATE

THE TERM ADJUSTMENT.

CHANGE ALLOWS OWNERS MANUALS TO BE CHANGED AND ELIMINATE
 THE POSSIBILITY OF GUN OWNER ATTEMPTING TO ADJUST
 TRIGGER PULL WHICH THE WORD ADJUSTMENT IMPLIES

Disposition of Parts on Hand: (check below)

- () Scrap () Alter () Use Inventory () RD 6589 Attached

 PLAINTIFF'S
 EXHIBIT
 7-bbb

A86-037017

"There have been 91 individual items identified in our research work pool. Obviously all cannot be covered in detail at this meeting. They will be grouped as appropriate under one of five main headings.

1. Necessity
2. New Product Development
3. Process Development
4. Other Work
5. Backlog

"Under the heading of Necessity we have one commitment, Bolt Action Fire Controls (Chart 32). Our objectives here are to enable the shooter to load and unload his gun with the safety switch in the 'ON' position and prevent him for 'adjusting' himself into trouble. This work has been pursued in two ways:

1. Make the present fire control more tamper proof.
2. Design a new fire control.

"Working with Production, the Legal Department and Du Pont consultants, a number of possible improvements to the present fire control have been identified (Chart 33).

- (1) A warning 'Do not adjust Trigger Assembly' will be stamped into the side plate of the fire control.
- (2) Special screw heads will be developed to further discourage adjustment by anyone other than the factory or an authorized gunsmith.
- (3) A new sealant will be investigated that will enable us to prove conclusively that the seal on the adjusting screws has been broken.
- (4) A \$5,000 work order was authorized in March of this year for the Du Pont Engineering Department to assist us in developing a cleaning and lubrication procedure for the Model 700 Fire Control that can be included in the rifles instruction book.

"The evaluation program will consist of a preliminary review of all potential cleaning and lubrication candidates within proposed guidelines and selected products will be screened for performance. It is the program aim, if possible, to specify products on a generic name basis.

"Results of this work are expected in September.

AD 0001923

AD 0000920



1 LUN 0002282 1