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

710 TRAIL & PILOT SERIES- B
11/15/00

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 MAGNAFLUX STAMP	HEADSPACE, REM. SPEC GAUGES	TRIGGER PULL WITH SPRING SCALE TLW0300J LBS.				FIRING PIN INDENT WITH COPPER CRUSHERS TLW0300H				SEAR TO TRIGGER ENGAGEMENT TLW0300I out of stock @ 20X				SEAR LIFT TLW0300I out of stock @ 20X				
		TLW0300E,F	TLW0300E,F	TLW0300G	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	0.0268	0.0268	0.0274	0.0122	0.0139	0.0133	0.0131	
B-2	71001184	Y	Y	MIN.+.002	5.25	5.5	5	5.25	0.018	0.017	0.016	0.0177	0.0277	0.0278	0.0268	0.0274	0.0127	0.0132	0.0131	0.0130	
B-3	71001244	Y	Y	MIN.+.002	4.25	4.75	4.25	4.42	0.017	0.016	0.018	0.0170	0.0262	0.0291	0.0278	0.0282	0.015	0.0145	0.0147	0.0147	
B-4	71001288	Y	Y	MIN.+.001	6	4.5	4.25	4.58	0.016	0.016	0.018	0.0173	0.032	0.0311	0.0307	0.0313	0.0151	0.0173	0.0167	0.0164	NOTE- MAR ON RECEIVER OUT OF BOX
B-5	71001421	Y	Y	MIN.+.001	4.25	4	4	4.08	0.018	0.018	0.017	0.0177	0.0268	0.027	0.0245	0.0268	0.0134	0.0123	0.0113	0.0123	NOTE- MISSING REAR TAKE DOWN SCREW OUT OF BOX, NOTHING IN BOX
B-6	71001462	Y	Y	MIN.+.001	4.75	4.25	4.25	4.42	0.016	0.016	0.017	0.0163	0.0262	0.0261	0.0255	0.0261	0.012	0.0124	0.0121	0.0122	
B-7	71001504	Y	Y	MIN.+.001	5.5	5.25	5	5.25	0.017	0.016	0.016	0.0163	0.0234	0.0239	0.0254	0.0296	0.0154	0.0139	0.0139	0.0143	
B-8	71001511	Y	Y	OUT OF TEST. TRIGGER LOCATED TO THE RIGHT OF CENTER IN TRIGGER GUARD, GUN HELD FOR MAGNETIC EVALUATION.																	
B-9	71001524	Y	Y	MIN.+.001	5.5	5.25	5.25	5.33	0.017	0.018	0.017	0.0173	0.0265	0.0287	0.0261	0.0271	0.0136	0.0132	0.0145	0.0138	
B-10	71001529	Y	Y	MIN.+.001	5.5	5.25	5.25	5.33	0.017	0.016	0.017	0.0173	0.0257	0.0255	0.0302	0.0271	0.0123	0.0141	0.0141	0.0135	
B-11	71001534	Y	Y	MIN.+.002	4.5	5	4.5	4.67	0.017	0.017	0.017	0.0170	0.0311	0.0297	0.0306	0.0305	0.0141	0.0137	0.0131	0.0136	
B-12	71001535	Y	Y	MIN.+.001	5.5	5	4.75	5.08	0.018	0.018	0.018	0.0183	0.0272	0.0283	0.0299	0.0285	0.0144	0.0137	0.013	0.0137	
B-13	71001539	Y	Y	MIN.+.001	5.5	5	5	5.17	0.017	0.016	0.017	0.0177	0.0291	0.0295	0.0299	0.0295	0.0152	0.0143	0.0146	0.0147	
B-14	71001559	Y	Y	MIN.+.002	5	5	5	5.00	0.019	0.019	0.02	0.0193	0.0314	0.0308	0.0316	0.0312	0.013	0.0123	0.0149	0.0135	
B-15	71001578	Y	Y	MIN.	4.5	4.75	4.5	4.58	0.017	0.017	0.017	0.0170	0.029	0.0276	0.0293	0.0287	0.0162	0.0163	0.0156	0.0161	
B-16	71001580	Y	Y	MIN.+.001	5.75	5.5	6	5.75	0.017	0.018	0.018	0.0177	0.0307	0.0294	0.0313	0.0308	0.0156	0.0161	0.0156	0.0158	
B-17	71001583	Y	Y	MIN.+.002	5	5	5.25	5.08	0.017	0.018	0.019	0.0180	0.036	0.0376	0.0366	0.0367	0.0137	0.0135	0.0137	0.0136	NOTE- SAFETY IN FIRE POSITION OUT OF BOX
B-18	71001584	Y	Y	MIN.+.001	4.75	6	5.25	5.67	0.016	0.018	0.017	0.0170	0.0291	0.0272	0.0286	0.0283	0.0114	0.0138	0.0138	0.0139	
B-19	71001595	Y	Y	MIN.+.001	5	5.5	5.25	5.25	0.019	0.016	0.019	0.0187	0.0296	0.0282	0.0286	0.0288	0.0116	0.0119	0.011	0.0118	
B-20	71001605	Y	Y	MIN.+.001	5	4.5	4.75	4.75	0.016	0.016	0.017	0.0163	0.0262	0.0271	0.026	0.0264	0.0175	0.0153	0.0165	0.0164	
B-21	71001613	Y	Y	BELOW MIN.	5.75	5.75	5.25	5.58	0.017	0.017	0.018	0.0173	0.0256	0.0256	0.0251	0.0254	0.0151	0.0148	0.0145	0.0147	
B-22	71001623	Y	Y	MIN.	4.75	4.75	5.25	4.92	0.016	0.018	0.018	0.0173	0.0271	0.0273	0.0262	0.0269	0.0134	0.0134	0.0144	0.0137	
B-23	71001632	Y	Y	MIN.+.001	5	4.75	5.25	5.00	0.018	0.016	0.017	0.0170	0.0267	0.0271	0.0278	0.0272	0.0126	0.015	0.0157	0.0144	
B-24	71001634	Y	Y	MIN.+.001	5.5	5.5	5.25	5.42	0.019	0.017	0.017	0.0177	0.0279	0.0278	0.0288	0.0282	0.0145	0.0141	0.0149	0.0145	
B-25	71001643	Y	Y	MIN.+.001	4.25	4	4.5	4.25	0.018	0.017	0.018	0.0177	0.0301	0.0304	0.0312	0.0306	0.0156	0.015	0.0149	0.0145	
B-26	71001647	Y	Y	MIN.+.001	5	5	5	5.00	0.017	0.017	0.017	0.0170	0.0269	0.0285	0.0292	0.0282	0.0126	0.0139	0.0135	0.0134	
B-27	71001724	Y	Y	MIN.+.002	5.75	4.75	4.25	4.92	0.019	0.018	0.02	0.0193	0.0296	0.0304	0.0299	0.0300	0.0163	0.0173	0.0175	0.0170	
B-28	71001760	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	0.0127	0.0149	0.0149	
B-29	71001782	Y	Y	MIN.+.002	4.25	4.75	5	4.67	0.018	0.018	0.018	0.0187	0.0294	0.0293	0.0303	0.0297	0.0162	0.0154	0.0157	0.0158	NOTE- MAR ON STOCK OUT OF BOX
B-30	71001789	Y	Y	MIN.+.002	4.25	4.5	4.5	4.42	0.019	0.017	0.019	0.0183	0.0284	0.0285	0.0307	0.0296	0.0126	0.0136	0.0131	0.0132	
							TEST AVERAGE	4.96			TEST AVERAGE	0.01732			TEST AVERAGE	0.02908			TEST AVERAGE	0.0132	
							SPEC.= 4.0 TO 5.5 LBS.				SAAMI MIN.= .017				SPEC.= .020 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