

Trip Report  
M/710 Manufacturing/Assembly Review  
Mayfield Facility  
August 12, 1999

Following the July 20 design review, the Mayfield facility received multiple samples of M/710 receiver insert assembly components. Throughout the past month, the assemblers have been working with the components to generate an understanding of the functional aspects as well as assembly times for estimating purposes. All other departments have been developing proposed processes and estimates. This review was scheduled to discuss recent concerns and suggestions for design/cost improvements. The following is a list of the issues discussed during the review.

- Trigger Adjustment** -- Several assemblies were noted as difficult to adjust.
- Side Plate Retention** -- Adjustment screws force the side plate to tilt away from the receiver insert. A third rivet may be required to properly retain the side plate.
- Stock Design** -- Mayfield requested a barrel contact pad at fore end of stock. Based on issues with M/597 barrel free floating, a contact pad will ensure proper barrel/stock margins.
- Ejection Port Margins** -- Allowable margin between steel receiver and synthetic receiver insert needs to be specified.
- Front Sight** -- Mayfield suggested using the one piece M/597 sight versus the proposed two piece M/700 front sight. M/597 sight is .100" shorter than M/700, not able to add use.
- Barrel Length** -- Mayfield would like 22" long action/24" magnum barrel lengths if Marketing must have a 24" magnum barrel. Otherwise make all barrels common length either 20" or 22" based on Marketing direction. They do not want to make 20" long action/22" magnum combination.
- Final Inspection** -- Minimum inspections required to include trig pull, safety function, sear lift, head space, and firing pin lock.
- Receiver Concentricity** -- Mayfield requested concentricity specification for receiver, .010 concentricity to be added to drawing.
- Bolt Head** -- Alter C datum lug specification due to ejector retaining pin hole location.

Other topics discussed during review:

Mayfield will investigate a common carton for the M/710 and M/597.

The DAT rifles will be assembled in Mayfield.

Design change of the Receiver Insert to cover the gap between the safety arm/rec. insert/stock, also include "F" and "S" designations molded into rec. insert.

Discussed/reviewed the M/700 firing pin lock design and incorporating into M/710.