

Trip Report – M/710 Barrel and Receiver Assembly in Ilion, NY 5/13/99
M/710 Receiver Insert Mold Runoff in Detroit, MI 5/14/99

Barrel/Receiver Assembly

The M/710 barrel to receiver attachment method utilizes an interference fit (press fit). The production fixture to support and align the barrel and receiver during the pressing operation was received on 5/13/99. EET barrels and receivers were previously delivered to Ilion. The fixture installation was completed by the Ilion machine shop. Ten EET barrel assemblies were completed using the fixture. No complications were encountered while pressing the receivers onto the barrels. There are minor improvements to be made to the fixture to enhance the barrel/fixture interaction, but the overall function of the fixture and component design proved to be acceptable.

Receiver Insert Mold Runoff

The Hanson Group had previously processed receiver inserts, dimensionally inspected and completed corrections to the tool. The objective of this mold runoff was to verify the tool corrections and to provide acceptable components for EET. It was agreed upon by Remington that the bolt guidance hole would remain tight for this runoff, due to extensive tool work required to correct. Corrections will be completed for the DAT component runoff, required by June 23, 1999. The tool was processed at M&C Tool, a contracted vendor of The Hanson Group. M&C Tool are responsible for the GCP process, which regulates internal cavity pressure during mold filling. All receiver inserts are to be processed utilizing the GCP process. Twenty-five receiver inserts were processed and hand carried to Elizabethtown for assembly into EET firearms. An additional twenty-five pieces were processed for dimensional inspection by The Hanson Group.

Note: EET firearm assembly incorporating the barrel assemblies and receiver inserts discussed above was completed on May 17, 1999. No major complications were encountered. Eight firearms were submitted to the test lab for EET.