

Remington Arms Company, Inc.  
January 26, 2001

**CONFIDENTIAL**

Research and Development Technology Center  
Elizabethown, Kentucky

Subject: M/710 Production Review -- Plant visit to review M/710 production.

In general, the product that was reviewed on Thursday was encouraging. It appears that the components and assembly procedures have stabilized, producing consistently functional and cosmetically uniform firearms. Although the primary intent of the visit was to review components for conformance to design intent, the primary result of the visit was procedural enhancements to improve product flow.

The review began with discussions with Joe and Matt regarding component issues that affect performance or assembly. Out of that discussion, the main issue noted from both performance and assembly aspects was the stock and bolt stop interaction. A significant number of stocks are scrapped due to insufficient bolt stop retention forces. The current procedure requires secondary manual "crimping" of the bolt stop ribs to produce the desired interference with the bolt stop. The manual crimping operation is operator sensitive and inconsistent. As an intermediate step the stock tool has been altered to eliminate the manual crimping, but due to assembly tolerances the change will not completely eliminate the potential for insufficient bolt stop retention forces. The proper correction will involve the implementation of the bolt stop spring. The bolt stop spring drawing has been forwarded to vendors for production quoting and startup. Implementation of the bolt stop spring will require core changes to the stock tool as well. Coordination of the stock changes and bolt stop spring production will be required.

The following are minor component or procedural issues discussed with their respective action noted.

Stock: (Other than bolt stop issue discussed above)

- Middle take down screw torque -- If torqued above 45 in-lbs, the screw head will burrow into the stock. The material thickness around the middle screw hole will be significantly increased to provide more support for the screw head. The tool change will occur coincident with the bolt stop spring core changes.
- Slight flash (excess material) is present in latch opening. Currently does not impede latch movement but if amount of flash increases, it will eventually affect latch movement. Mayfield to review with molder, tool corrections could be completed with bolt stop spring core changes.

Final Assembly Process: (Notes regarding component fits and assembly procedures)

- A request was made to eliminate the requirement for Sear Lift inspection. Due to the design and assembly procedures of the receiver insert assembly, the sear lift is a built-in feature not adjustable. The assemblers noted the consistency and indicated significant time is required to complete the inspection. It is my opinion that this operation can be eliminated, will request a further review with management.

Michael D. Koehn  
Staff Engineer

Page 1 of 3

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Subject to Protective Order - Williams v. Remington