

Remington Arms Company, Inc.
January 26, 2001

CONFIDENTIAL

Research and Development Technology Center
Elizabethtown, Kentucky

- Another time consuming operation previously required was the application of Loctite to the top scope ring screws. The assemblers were applying a Loctite thread sealer to the four screws that clamp the top scope ring to the bottom ring. This procedure was eliminated in belief that the consumer will have to loosen the screws to adjust the scope position for their preferred eye relief anyway, thus breaking the Loctite bond.
- An inspection that was developed based on issues during Trial and Pilot testing required the assembler to ensure the sear was free to move prior to assembling the bolt into the firearm. As a review, we discussed the current assemblies and frequency of issues relative to friction against the sears. It has become apparent to the assemblers that the interference between the sear and receiver insert assembly was partially caused during the receiver insert assembly. They have corrected the issue with the receiver insert assembly procedure and subsequently have not had trouble with sear interference. Another contributing factor to sear interference was due to varying receiver insert support screw hole locations. Current receivers provide consistent receiver insert support screw hole locations, which have eliminated any biasing of the receiver insert assembly when assembled to the receiver. The inspection for free sear travel will continue, but wanted to note the lack of issue with this at the current time.
- A comment was made by the assemblers regarding the high consumption rate of dummy rounds. Discussing the subject of dummy rounds and their usage evolved into a question of purpose and requirement for cycling dummies through the action. The net shape manufacturing processes used for the magazine box assembly, stock and latching mechanism provide a consistent relationship of those components when assembled into a complete firearm. Due to the consistency of the components, if an issue arises with feeding performance it will be obvious and common across that specific lot of errant components. Therefore, since we have established an excellent feeding performance baseline to date, elimination of action cycling inspection at the assembly bench is acceptable. The action cycling performance will continue to be verified during proof and accuracy testing.

Gallery Testing

- During observation of the gallery testing a slight deformation of triggers was noted. Inspection of the test jack revealed that the cable used to actually pull the trigger was bound around the activation cylinder. This binding caused the tension in the cable to be too high, imparting a higher than required force to the trigger during firing. Correction of the cable routing and connection eliminated the binding. Subsequent firearms tested did not show signs of trigger deformation.

Michael D. Koehn
Staff Engineer

Page 2 of 3

20060120103804A00009941.doc

Subject to Protective Order - Williams v. Remington

BARBER - 5.30.060004406

ETE00002202