

Ilion Firearm Quality Meeting Summary

November 10th, 2004

11:00 am - Noon

Attendees: John Loschin, Ken Nickerson, Danny Evans, Bob Longo (conf), Tom Nagle (conf), Fred Supry (conf), Bob Orf (conf), Steve Perniciaro (conf), Jeff McGlory (conf), Jerry Allen (conf), Chris Shoemaker (conf)

Absent: Paul Cahan, Joe Pugliese, John Trull, John Fink, Jack Shannon, Ed Schoppman, Greg Foster,

Agenda:

- Review Model 700 Accuracy
- Accurizing Process
- Review Model 332
- Repair/Refinish Process for 700 XCR and VSSFII
- LE: Steel vs. MIM ejectors

Model 700 Accuracy:

- Chris reviewed with the group the findings of 12 Model 700's.
- 2 ADL's, 3 BDL's, 1 PSS, Model 7, 1 VSF, 2 LV's, 1 673, 1 Mtn

Problem Reported:

- 4 Accuracy
- 1 Accuracy went group
- 1 will not zero at 100 yards
- 6 went group
- 1 accuracy stock miss cut

Problem Found:

- 12 no problem found
- 1 stock miss cut

Action Taken:

- 9 Nothing
- 1 (PSS) replaced BBL (goodwill)
- 1 adjust sight
- 1 lap bore
- 1 replace stock

Accuracy Received:

- 3 < 1"
- 9 1" – 1.5"
- 1 2" – 2.5"

Accuracy Returned:

- 3 < 1"
- 10 1" – 1.5"

- Chris is concerned that we are not seeing many guns come in for accuracy. The team discussed it and decided to discontinue reporting accuracy information. We will still make ourselves aware of concerns but need to concentrate our efforts on other issues.
- Ken advised that he is having two guns come in for accuracy evaluation.
- Bob L. requested we rerun our quality code report to determine what our number one concern is.
- Steve advised that they are still gathering accurizing information. They are currently gathering information on 14 varmint SKU's. He also advised that they are accurizing 100% of five SKU's.
- Chris advised that they are three shot groups.
- John L asked about the repair process on the new XCR finish. Steve advised that to refinish the firearm will be more difficult than a normal finish. They will be determining what process it will take to remove the old finish.
- Bob L asked about the refinish process for the VSSFII with the blued flutes. Steve advised that to refinish this model they would have to re-blue the entire gun then polish around the flutes.
- Danny requested an updated list of gallery ammo used for testing and targeting.
- **Steve asked Andy Longway to provide Danny with the gallery target and testing specs spreadsheet.**

Model 332:

- Bob O. advised that they he received four Model 332's back for evaluation.
 - 1 had a broken stock
 - 1 had a bulge on the barrel near the choke tube (concentricity).
 - 1 loose fore-end and second barrel would not fire
 - 1 not fitted correctly, space between frame.

Law Enforcement Barrels:

- Ken advised that the Royal Mounted Police had 59 barrels that had problems after firing five slugs. The RMP claimed that they would have to stop and clean the guns after five rounds (Model 870 smooth bore). The build up looked like rust.
- Chris advised that it maybe plastic build up. He would like to have the bbl's come in for evaluation. The question was raised as to if it was salt or rust they were seeing.
- Ken is going to continue to research. Getting barrels back to Canada is very difficult.
- Steve advised that after awhile the white salt would turn to red as the metal deteriorated.
- Greg Foster sent the team an email requesting we discuss steel ejectors.
- Bob O advised that with the mounted MCS, 3 out of 4 ejectors broke. He found some old steel ejectors and conducted the same test and received the same results, 3 out of 4 broke.
- They are testing in MIM, molded 4140 material. In the lab the break strength was higher but the shrink rate was also greater. This would require a new mold tool.
- Jack Kast is evaluating the new style and feels that is should be okay. He will be testing it in receivers and by the looks of the design should be stronger.
- Bob O. advised with try 4140 as is. If it does not breaks will get "coining" tool. If it does will need to make a new tool with the design.
- **Bob O to give update on drop test next meeting.**

Notes:

- **Next meeting will be held on December, 8th 2004, 11:00 am – Noon. If you cannot attend the meeting, please let me know as far in advance as possible.**
- **We will follow up next meeting with Bob O's drop test results, Gallery Target and testing specs, Model 332 concerns and the number one repair code issue for centerfire rifles.**