

**REMINGTON ARMS COMPANY, INC.**  
**Product Team Meeting Minutes**

**August 24th, 2004 8:00 am EST**

**Future Meetings**

September 15<sup>th</sup> - Ilion  
November 17<sup>th</sup> - Ilion  
December 15<sup>th</sup> - Elizabethtown

**Future Important Dates**

October 14<sup>th</sup>-16<sup>th</sup>                      Writers Seminar-Orangeburg, SC  
November 6<sup>th</sup>-8<sup>th</sup>                      Sales Meeting-Greensboro, NC

**Business Review**

Jay Bunting to provide overview of current business environment

**ILION BASED SHOTGUN PRODUCTS**

**New Shotgun Product**

**Model 332-Skinner, *Orf***

OBJECTIVE: Establish a legitimate presence in the O/U market

Production Status:

- Guns per day
- Shooting Open-Update
  - Top Lever Template
  - Grinding Lugs
  - Communicating with Arms Service-Any New Repairs?

Template gauge in place to adjust top lever

No new issues since last meeting.

Grinding lugs does not seem to address shoot open issue

Orders on the books covered. Will build some inventory at 10 per day; close to 400 each at year end. 2005 daily rate currently would mean 6-7 guns per day. If cut back, getting back to 10 guns per day could take 6-7 months.

**Action: Check Williams sell through. (Fink/McCanna)**

Look at improving efficiencies and cost.

Planning requested assistance relating to schedules through out 2005.

Options for line extensions: Camo, Extra Wood, B-Grade, Cased

**M332 Sporting DL-*D.Diaz***

- Current Status
  - 3200 style barrel hanger-Designed barrel hanger set, .040" convergance. Plans to braze 3-5 barrel sets week of 7.21. Barrels will be crowned but not tubed and shot for POI.
  - Side Panels-Update
    - 5 prototype barrels with .040" versus .120" convergance built. Will ship to R. Murphy week of 8.23. Not overbored or choked, will shoot for POI/POA. Need to go to a light contour barrel, 28" 30" 32" 34" barrels, tapered rib, stepped rib, straight comb.
    - DAT complete first week of December. T&P-barrels should not be an issue. Biggest issue is raised side panels.

**Action: Make sure all future drawings/communications are funneled through Orf. (Diaz/Murphy)**

**Action: Decision point on side panels versus flat panel by next PTM. Checkering patterns are also an option. (Fink)**

#### **M1100 Sporting DL-B. Orf**

- Current Status-Make 1100 bbl with 105 ID and choke tubes, .735" with lengthened forcing cones. Goal is to have 10 barrels by September 1<sup>st</sup>. Boyds should make adjustable comb stock

Target sights

Glass beaded/shot blasted receiver

**ACTION:** Jeweling bolt-need to investigate bolt cosmetics. Fluting was proposed as an option. B. Orf to look into what is feasible.

Investigating ways to improve surface finish: action bars, slide, action tube, receiver with nickel Teflon finish. Polish hammer, locking block, action spring tube follower, link and hammer plunger with coating. Will have shooting prototypes by the end of September.

**Action:** Fink contact Kolar to have 5 adjustable comb stocks made from 1100

#### **Sporting.**

Will shot blast receiver and then polish.

Bolt-have not come up with option for jewelling or fluting. Body cote may be an option for the bolt.

Assuming cosmetics finalized by mid September, production could start end of first quarter.

#### **2005 Spring Shotguns-Skinner, Mroz, Orf**

- Current Status  
2005-06 SP-10 Mossy Oak Obsession October production-400 by year end  
2005-07 11-87 SM NWTF-Royalties 1500 by year end  
Call Tom Nagle regarding returns on 1187 SM.  
2005-08 870 SM Thumbhole 850 by year end, 50 by the end of September  
2005-09 870 Exp Jr. NWTF-Royalties 750 by year end  
925 Team NWTF guns in October  
Medallion Adhesive-Update- **ACTION:** S. Perniciaro to investigate adhesive

#### **1187 Sportsman Synthetic Line**

Update \$37K in stranded parts, \$11K in recoil pads that can be used elsewhere.

**ACTION:** Skinner-12 gauge production schedule- 12 gauges are structured with schedules starting in October for 12/26/28 and 12/21 FR CL.

**ACTION:** B. Orf - 20 gauge fore end. 9 weeks & \$15K to modify 1100 20 gauge tool.

#### **Ilion Quality – Shotguns**

##### **Shotgun POI-Perniciaro, Orf**

OBJECTIVE: Conformance to SAAMI spec

**ACTION:** Ilion Engineering to provide status of this project. Priority of shotguns in which to incorporate these changes first:

1. All 1100 Target, 1100 Classic Field and Synthetic
2. 11-87 Premier and SP/SPS
3. 870 Wingmaster and SPS
4. 870 Express
5. SP-10

Jack Kast has picked up. Trying smaller bead to evaluate POI. Lab time is being consumed for MCS at this point of time. Late July early August at this point for an answer. **By next PTM we should have results.**

- **Choke Tube Constriction/Patterning Concerns**

ACTION: B Orf to update drawings. Need to add some sort of ID mark on choke tubes. Tim Butler has some questions concerning transmitted spec versus current drawings. Fink to work with Butler.

- **Shotgun Bore Diameter-0.727" +/- .002"**- Current LE Process? Catalog guns? All barrels being forged to .718 and finished to .727", no longer issue. ACTION: Replace any barrels coming into Arms Service with a new barrel with the correct bore diameter.
- **1187 extractor is being used in 1100 Target guns. This means old 1100 barrels will not fit new 1100's.**  
ACTION: Perniciaro to investigate when change took place, report at next meeting, and provide plan to revert to an 1100 extractor.

## **ILION BASED GENERAL TOPICS**

### **ISS Conversion-S. Perniciaro**

- Current status of lock and implementation dates  
Scheduled to start phasing in October, 2004.  
Regal will work on 332 next.  
**Haskin handling shotgun timeline, Zito handling rifle.**  
Action: Haskin/Zito to e-mail timeline to Trull/Fink.

### **R3 Pad on Wood Stocks-B. Orf**

- Review status with team based on recent visit.
- 1<sup>st</sup> T&P on 700 magnum received 8.22. will submit CAR for white line spacer. Continuing to work on short stocks. Ed Owens is handling, will be at S&K at least one week per month.

### **Wood Stocks Dipped with Wood Pattern**

- Develop contacts to test market an 1187-Need to see some samples, may do a SHOT Show special.  
ACTION: B. Orf to get contact information from S. Perniciaro and have some stocks dipped for samples.

## **ILION BASED RIFLE PRODUCTS**

### **2005 Ilion New Rifle Programs**

#### **Model 700 Synthetic Stock Redesign Status-J. Mroz/Mead**

- Status Update on vendor progress
- Status update on production plans Balio

#### **SPS**

Stocks by October. Have equivalent wood stock guns scheduled to switch into SPS guns as soon as stock is delivered.

September 23<sup>rd</sup> delivery scheduled for LA magnum stocks. Would spend \$15K-\$20K for OT and reduce by one week. Mead to evaluate what can be done to expedite.

#### **Model 700 XCR-Coatings-G. Sietsema**

- Marketing has approved color on trigger guard and components
- Need an update on testing (salt fog, abrasion, endurance)
- Need an update on DAT/T&P to establish material flow process with vendor.
- Sietsema to present testing data and comparison to competitive offerings.

#### **Model 700 New Varmint Line – Mroz/Balio**

- Status Update on production
- HS given release to go ahead on July 28<sup>th</sup>. 1500 left hand were supposed to be delivered and built in August. Was to be at 100 stocks per day, delivering 10-15. moved August and September schedule.

**Action: Trull to draft letter to be approved by planning and put HS on notice.**

**Action: E'town to investigate new bedded stock design.**

- Trigger guards are structured incorrectly.

#### **Model XR-100-Mroz**

- Status Update on Gun – When are structures going to be complete?
- Status Update on Owners Manual – Has copy been sent to Dale Wills for review?
- Some changes have been made to owners manual. Has been sent out for revisions, **ACTION: Mroz to check and confirm. Will be costed and structured by week of 8.30.**
- Boyd's could be an issue on stock delivery. Order should be placed ASAP.

#### **Model 700 SPL Fire Control – Perniciaro/Diaz**

- Update on findings on the 7491 with bad extractor and inability to adjust current firecontrol below 5lbs consistently. - Perniciaro
- Update on testing/timing. – Perniciaro
- Update on surface finishes. – Perniciaro
- Discuss trigger pull spec for production – Trull/Perniciaro/Diaz
- CAR approved 8.24.

#### **Ilion Quality Issues – Rifles**

##### **Model 700/Seven Trigger Pull Weights-S. Perniciaro**

- Brief update on how new procedure is progressing in manufacturing.

##### **Model 7400 Cracked Fore Ends -S. Perniciaro**

- Perniciaro to advise on testing of new parts and what has changed in process to correct issues
- Trull and Perniciaro to visit Rivolier the week of August 30<sup>th</sup>. Need to know how many samples will be available.

## **R&D TOPICS**

### **E-Town Development Topics**

#### **Fluted Firing Pin - Diaz/Perniciaro**

- Status
- Production Ramp up – Ilion
- R&D complete, turned over to Ilion

#### **17 Hornady Mach 2 Project - Diaz**

- Status on 504
- Ammunition was to arrive by end of July. Diaz to confirm.
- New Eley ammunition. At SAAMI nominal dimensions. Some issues with magazine boxes, will evaluate with new magazine box design. Will test 597 with standard bolt. BV's at 400 in/sec.

**NCAR – (New Centerfire Autoloading Rifle) – Diaz**

- Diaz/Trull to brief team on concepts and competitive strategy.
- NPP to Jeff Stone to evaluate replacement for 7400. Will be building 1-2 prototype guns.

**7400 SGS-New gas system.**

**Mayfield Topics**

**Model 597 22LR New Mag Box – Diaz/Lance**

- Status/Roll in plan
- Available quantities for promotion?

**Model 710 Metal Receiver – Diaz/Lance**

- DAT Update
- Mayfield should be ramping up and switching in October to make 2005 catalog
- Confirm costing

**Model 504-T LS HB – Diaz/Lance**

- Confirm Stocks were received
- Confirm Testing schedule is on track
- Cost Estimate Needed
- Production plans

**Mayfield Production Plan for 2004 – Bunting/Lance/Trull**

- Need to discuss potential plans to ramp up M710's by 5k units by year end

**Model 504 Stock Improvements – Lance**

- ¼ Sawn lumber implementation
- Wrap around fore end checkering
- Supplier plans (Boyd's vs. S&K)

**Military/Law Enforcement**

- 870 MCS-Status Update
- Israeli 120 day order with 10" bbl and threaded muzzle break choke tube, would not work. Need direction from Schoppman and Foster.
- Airforce order pending for 1150 guns.
- 7615-Status Update  
Scheduled to have DAT testing done by September 3<sup>rd</sup>. Product will be a complicated build to produce.