

**Ilion firearms Quality Meeting  
Summary**

*August 11, 2004  
11:00 am - Noon*

**Attendees:** John Loschin, Ken Nickerson, Danny Evans, Chris Shoemaker (conf), Bob Longo (conf), Jerry Allen (conf), Fred Surpy (conf), Jeff McGlory (conf), Joe Pugliese (conf), Bob Orf (conf), Steve Perniciaro (conf), John Shannon (conf)  
**Absent:** Greg Foster, Paul Cahan, John Trull, John Fink, Ed Shoppman, Tom Nagle

**Agenda:**

- Review Accuracy of Model 700 rifles
- Model 7400 fore-end testing
- Model 870 chamber issues
- Model 700 fluted firing pins
- Model 332 bluing salt concerns

**Discussion:**

- John Loschin recapped the meeting notes from July.
- Chris advised the group that they tested 9 Model 700's for accuracy.

**Problem Reported:**

- 3 accuracy problems
- 4 poor group sizes
- 1 accuracy and tooling marks in the bore
- 1 firers after 2<sup>nd</sup> round shot

**Problem Found:**

- 1 no problem found
- 2 marred rifling
- 1 bore heat checked
- 2 would not group no problem detected
- 2 action loose
- 1 burr at the muzzle

**Solution:**

- 2 replaced assembly
- 1 gun replaced
- 1 returned as received
- 2 tightened action
- 1 reamed muzzle
- 2 lapped bore

Confidential

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**Accuracy Received:**

- 1 - 1" - 1 ½"
- 1 - over 2"

**Accuracy Returned:**

- 3 - 1" - 1 ½"
- 4 - 1.5" - 2"

- Steve P. talked about the testing they are doing on what Remington ammo shoots best with each model we produce.
- John L. and Danny E. asked about adding to the repair system the accuracy and the type of ammo used for testing for the CSR's to view. Also, adding this information to the repair document that is returned to the consumer.
- Bob Longo advised the team that Arm Service tested their guns off the shoulder and included targets.
- The ammo used in the gallery is standard Remington ammo and if the gun does not meet specifications on 3 shot group, a 4 shot group will be done and if that does not meet specification a 5 shot group will be done.
- Danny requested that a new gallery ammo specification sheet be provided, including the type of ammo used and the desired acceptable groupings.
- Danny E asked when the *Model 7400* testing would be completed.
- Steve P advised the team that the fore-ends should be available by mid to late September. Also, the testing has been fine the change in glue, liner and cut have shown favorable results.
- John L. talked about the *Model 870* tight chambers.
- Bob Orf advised the team that they use a max feed shell to check all the dimensions of the chamber on the Model 870. Danny E asked if we had these "plug" to send or sell to our Premier RARC's in 12 and 20 gauge. These "plug" are made of hardened material. Ken to look into these further for Premier RARC use.
- Jerry A asked why is the consumer bringing back these Model 870's. He advised the team that the chambers are visual inspected at final inspect for roughness. At this time the gallery does not have a code for rough chamber just fails to extract.
- Steve P advised that we had similar problem with auto loaders.

- The team would like to review a new report of the code M129 (fails to extract), by date produced (2003 – ytd) and Date repaired. John L to produce reports before next meeting
- Danny E talked about the new model *700 fluted trigger pins*. The question was raised about using these pins with and without the ISS system. Should we have any concerns? Ken N -Drop test issues? At this time the ISS firing pin assembly is restricted.
- Bob Orf and Steve P advised the team that there is no reason to restrict the new fluted firing pin assembly for parts sales. The new firing pin meets all specifications for standard and ISS assemblies and is interchangeable.
- Steve added that we should send a trigger lock when converting from the ISS to the new fluted assemblies.
- *Model 332* was discussed briefly. The bluing salt problem was discussed, Jerry A advised that the new bleed line was in place and that as of this month August, we all guns with be going through it.

**Notes:**

- **Next meeting will be on September 8<sup>th</sup>, 11:00 am – noon. If you cannot attend our meeting, please let me know as far in advance as possible.**
- **We will follow-up next meeting on 700 accuracy concerns, Model 870 fails to extract, Model 7400 fore-end testing and Model 332 concerns.**