

Sent: Thursday, September 11, 2003 2:16 PM
To: Golemboski, Matt R.; Keeney, Mike; Thwatt, Ed T.
Cc: Diaz, Danny; Recsor, Phillip K.; Snedeker, Jim
Subject: 710 Magnum Update
Importance: High

Matt,

Thought I'd update everyone at the same time as to 710 Magnum DAT status. To refresh everyone's memory we were not able to test the "B-Series" guns, extruded receiver, due to dimensional issues with the magazine opening in the receiver. These guns were returned to Mayfield. The "A-Series" guns, standard 710 design, have been in DAT for some time. To date the following has been completed on this 15 gun sample.

- 1 Preliminary measurements
- 2 HS/Proof/HS
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- 5 Initial Shoulder function
- 6 Accuracy
- 7 500 rd. Endurance
- 8 1,000 rd. Endurance
- 9 Cold Test
- 10 Hot Test - will be done today, 9/11
- 11 Thermal Cycle - in process

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- 2 Scopes have moved during the Scope Endurance Test and significant POI variations have occurred. 5 guns have been tested to date. This is a result of scope rings loosening from live firing. A more robust scope retention system is needed on the Magnum.
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Subject to Protective Order - Williams v. Remington

ETE00001118

CONFIDENTIAL

Scott Franz
Manager of Research and Technology
Remington Arms Company, Inc.
Research & Development Technology Center
Telephone: (270) 769-7607 - (0) for Operator
FAX: (270) 737-9576

MY E-MAIL HAS CHANGED to
scott.franz@remington.com

Subject to Protective Order - Williams v. Remington

ETE00001119

Scott Franz

From: Franz, Scott
Sent: 09/15/2003 08:25:39 AM
To: Golemboski, Matt R.
CC:
BCC:
Subject: RE: 710 Magnum Update

Matt,

How about Tuesday morning at 10:00 am EST? If this is OK I'll put out an email to all.

> -----Original Message-----

> From: Golemboski, Matt R.
> Sent: Thursday, September 11, 2003 5:22 PM
> To: Franz, Scott
> Subject: RE: 710 Magnum Update

> Pick a time Monday afternoon.

> Matt

> -----Original Message-----

> From: Franz, Scott
> Sent: Thursday, September 11, 2003 4:19 PM
> To: Golemboski, Matt R.
> Subject: RE: 710 Magnum Update
> Importance: High

> No can do. I'm gone tomorrow. Any day next week is fine.

> -----Original Message-----

> From: Golemboski, Matt R.
> Sent: Thursday, September 11, 2003 5:09 PM
> To: Franz, Scott; Keeney, Mike; Thweatt, Ed T.
> Cc: Diaz, Danny; Reesor, Phillip K.; Snedeker, Jim
> Subject: RE: 710 Magnum Update

> Lets have a conf call on Friday 9/12/03 at 10:00 cst to discuss the issues and path forward for the T&P guns.

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> Sent: Thursday, September 11, 2003 2:16 PM
> To: Golemboski, Matt R.; Keeney, Mike; Thweatt, Ed T.
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> Importance: High

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ETE00001120

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> Scott Franz
 > Manager of Research and Technology
 > Remington Arms Company, Inc.
 > Research & Development Technology Center
 > Telephone: (270) 769-7607 - (0) for Operator
 > FAX: (270) 737-9576

>

> MY E-MAIL HAS CHANGED to
 > scott.frenz@remington.com

Subject to Protective Order - Williams v. Remington

ETE00001121

Scott Franz

From: Norton, Vince
Sent: 09/16/2003 03:54:09 PM
To: Thweatt, Ed T.; Golemboski, Matt R.; Thompson, Jeff
CC: Diaz, Danny; Franz, Scott; Reesor, Phillip K.; Stone, Jeff
BCC:
Subject: PRE-T&P FIRE CONTROL SETTINGS

The following table is a comparison of the engagement and trigger pull as measured by Mayfield and as measured by E-town.

It appears that we have very good correlation for engagement between E-town and Mayfield. The most we differed from each other is 0.0013". The average difference is +/- .0008". If T&P guns are set in Mayfield around the center of the specification, 0.024" to 0.027" we should have fairly good success measuring T&P guns in E-town within specification.

For trigger pull there appears to be really no correlation between E-town and Mayfield. We had as much as a pound of difference between the two sites. I have no explanation at this time for the differences. If we varied in one direction or the other I would speculate that the difference is in the fixturing and position of the force gage on the trigger box. We may want to take our trigger pull fixture to Mayfield and do a side by side comparison to see what kind of differences we see. If we can spare the fixture for a while I recommend that we do that sometime before we start T&P.

Comments and suggestions are welcome.
Vince

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ETE00001122

Scott Franz

From: Golemboski, Matt R.
Sent: 09/11/2003 05:21:51 PM
To: Franz, Scott
CC:
BCC:
Subject: RE: 710 Magnum Update

Pick a time Monday afternoon.

Matt

-----Original Message-----

From: Franz, Scott
Sent: Thursday, September 11, 2003 4:10 PM
To: Golemboski, Matt R.
Subject: RE: 710 Magnum Update
Importance: High

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-----Original Message-----

From: Golemboski, Matt R.
Sent: Thursday, September 11, 2003 5:09 PM
To: Franz, Scott; Keeney, Mike; Thweatt, Ed T.
Cc: Diaz, Danny; Reesor, Phillip K.; Snedeker, Jim
Subject: RE: 710 Magnum Update

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Sent: Thursday, September 11, 2003 2:16 PM
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FAX: (270) 737-9578

MY E-MAIL HAS CHANGED to
scott.franz@remington.com

Subject to Protective Order - Williams v. Remington

ETE00001124

Scott Franz

From: Franz, Scott
Sent: 09/11/2003 05:19:04 PM
To: Golemboski, Matt R.
CC:
BCC:
Subject: RE: 710 Magnum Update

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> From: Golemboski, Matt R.

> Sent: Thursday, September 11, 2003 5:09 PM

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ETE00001125

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>
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Subject to Protective Order - Williams v. Remington

ETE00001126

Scott Franz

From: Golemboski, Matt R.
Sent: 09/11/2003 05:08:48 PM
To: Franz, Scott; Keeney, Mike; Thweatt, Ed T.
CC: Diaz, Danny; Reesor, Phillip K.; Snedeker, Jim
BCC:
Subject: RE: 710 Magnum Update

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Sent: Thursday, September 11, 2003 2:18 PM
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Cc: Diaz, Danny; Reesor, Phillip K.; Snedeker, Jim
Subject: 710 Magnum Update
Importance: High

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ETE00001127

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Subject to Protective Order - Williams v. Remington

ETE00001128

Phillip Reesor

From: Franz, Scott
Sent: 09/11/2003 03:16:27 PM
To: Golemboski, Matt R.; Keeney, Mike; Thweatt, Ed T.
CC: Diaz, Danny; Reesor, Phillip K.; Snedeker, Jim
BCC:
Subject: 710 Magnum Update

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ETE00001130

Scott Franz

From: Franz, Scott
Sent: 09/11/2003 03:14:12 PM
To: Golemboski, Matt R.; Keeney, Mike; Thweatt, Ed T.
CC: Diaz, Danny; Reesor, Phillip K.; Snedaker, Jim
BCC:
Subject: 710 Magnum Update

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To date the following issues have been found.

- * Small hair line cracks in stocks. These have been found in both corners just behind the recoil lug and just behind the front take down screw hole. No crack propagation or deformation of the stock has occurred since initial observance of the crack. We're going to go back and inspect .30-06 and .270 Win. DAT and T&P guns to see if cracks were also present in these guns.
- * Scopes have moved during the Scope Endurance Test and significant POI variations have occurred. 5 guns have been tested to date. This is a result of scope rings loosening from live firing. A more robust scope retention system is needed on the Magnum.
- * A full Magazine Box can bind the action if the rounds are loaded incorrectly. This is caused by an incorrect stagger in the box. This appears to be a loading/learning issue when loading the box. If the rounds are staggered correctly this does not happen. This was seen to some extent in .30-06/.270 testing.
- * Extractors are losing tension which results in extraction/ejection issues at the 1,000 rd. level. This occurred on both guns that were tested to these round levels.
- * Magazine box deformation at the top front and bottom front have occurred. This is from impacting of the rounds in the magazine during recoil. Deformation eventually results in magazine boxes that are difficult to insert or remove from the gun. This was seen during .30-06/.270 testing and is no worse than what was seen there.
- * Bolt Stop deformation has occurred to a point where consistent bolt stop performance has been effected on some guns. This again has been seen in previous 710 testing.

Let me make a few general comments. No issues have been seen with the heat treated barrels so this appears to be a viable solution. Overall function has also been very good until extractor set

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occurred. Accuracy also seemed to be more than acceptable. The issues noted above are not show stopper ones. Not that they shouldn't be addressed or improved on if possible. Most of the planned DAT activity should be complete by the end of next week except Extended Endurance. We were not able to test a full compliment of guns for this DAT since "B-Series" guns were not tested. Due to the reduced sample size, 15 versus the usual 30, we ought to discuss a path forward to resolve those issues noted. This may involve a second DAT. Another option could be to accept the risk and head directly to T&P.

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