

W.

Subject: RE: Issues we have seen in the last 12 months with 700 Police rifles

Greg,

I discussed this with Jeff and I will respond to your list below.

Steve P.

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

From: Foster, Greg  
Sent: Wednesday, March 09, 2005 1:39 AM  
To: McGlory, Jeffrey  
Cc: Perniciaro, Stephen; Cahan, Paul L.; Bristol II, Ronald H.; Foster, Greg  
Subject: Issues we have seen in the last 12 months with 700 Police rifles

At our meeting two weeks ago, you ask me for problems that I have seen, my people have seen and our 700P warranty stations have seen with the 700 Police rifles.

This is a QUICK over the top summary of common problems we see.

Barrel lays left - for the most part - may be corrected  
Improper or no crown  
Crooked chamber  
Long freebore  
Improper headspace - should not be more than 1.633 on police rifles - (this was agreed upon by our quality group early last year and I am still looking for the confirmation email about it - will provide later on )

Bolts handles coming off  
Wrong bolt plug  
Wrong firing pin / spring  
ISS system used in Police rifles  
Heavy triggers  
Inconsistent trigger pull weights (vary from 4 - 7 1/2 lbs)  
Bent firecontrol pins due to softness (this has been a complaint of the US Secret Service for years and still is from our warranty stations)

Bad mag follower springs (assembled incorrectly and angled incorrectly)  
Inconsistent follow springs used  
Rust on follower springs  
Rust on bolt handles  
Parko in chambers  
Parko in barrels  
Rust pitting in chambers  
Rust pitting in barrels  
Scope mount holes not straight  
Poor finish / Parkerization  
Wrong bolt head used (should be the old style)  
Bolt heads not put on straight  
Scarring, gouging, from pull through reamer and rod, directly in front of chamber, very common in the last two years  
Stressed barrel steel directly in front of chamber, most likely from proof load, cracks or fractures the

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Problems being reported on guns sent in and returned without proper fix or no fix at all claiming the gun is in spec...- customer just sells the rifle and moves on to someone else.

What happens in all of these cases is the NEW gun has to be sent back for repair, killing all confidence in the rifle from the start and causing problems for the department because this rifle is needed for duty and there is no back up. I can personally tell you I sent 4 - 5 rifles out to departments last year to cover them while their NEW rifle was in for repair. This is not good

We have had Norm Chandler of Iron Brigade come in and provide consultation about or resolution for many of these problems yet we still see the problems continue.

It will be one of the main objectives of the 700 Police build area to NOT see any of these problems surface once it is up and running.

The 870 build area just suffered a set back with the results of the audit I conducted when I was in last. 5 guns out of 11 was unacceptable. The plan was supposed to be in place for the PARTS to all have been inspected and for the TRAVELER on each gun to insure the final product had been inspected. Obviously, this is not being adhered to. Paul is addressing this. But the same will be true of the 700 Police build area. Each part will be inspected before put in the crib and each gun will be inspected throughout and at the end of the assembly (Firearm attached TRAVELER)

Please let me know of any questions or concerns you have about the above.

I look forward to working with you on this project.

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