

33

UPDATES: 10/15/2004

Discussed Jan 14, 2023 call with Larry
Blackheart. Part find right. We will have
to buy more and from Black and Larry
will use needed parts.

BUY TUBER X P-100'S - CAL- 221 FIREBALL
RACON # 5470

PICKED UP 3 XP 190's STOCKS 11-1 277 BR
FROM BRIDG SERVICE

3 - M/870-12 GA 3" MAG. - 18" F.C. BARREL - 3 TOTAL
FRONT SIGHT BAR PUT ON - 173 HIGH. -

W. J. 23

Whole wt. WORK REQUEST. GIVED TO
EVAL RICHIE. EST. CORR. 2/11/83. IN TEST
LAB. 1-255-53

WE WILL USE ALL
PARTS OF THESE CANS
EXCEPT STOCK AND
BARRELS

NY 100

DATE
1983

TO: [REDACTED]

FBI NEW YORK

FROM: [REDACTED]

SUBJECT: [REDACTED]

RE: [REDACTED]

ATTENTION: [REDACTED]

REFERENCE: [REDACTED]

ENCLOSURE: [REDACTED]

DISTRIBUTION: [REDACTED]

ADMINISTRATIVE: [REDACTED]

TELETYPE: [REDACTED]

TELEPHONE: [REDACTED]

MAIL ROOM: [REDACTED]

CLERK: [REDACTED]

RECEIVED: [REDACTED]

FILED: [REDACTED]

INDEXED: [REDACTED]

SEARCHED: [REDACTED]

SERIALIZED: [REDACTED]

FILED: [REDACTED]

DATE: 1/23/83

LETTER NO. 1001

MODEL 3 SP-6 - 100 CAL./GA. .221 WERE CHECKED 8-0330-00-T

SERIAL NOS. 7-7571912 SER. "FIREARMS" 10470

7-7572257

7-7572553

REMARKS

1/25/83

100. METAL

1. ~~TURNED UP 1000 223 CALIBER RIFLE BARREL~~
~~OUTLINE 223 251253 251253 251253~~
Accuracy Rem. and other stuff for
accuracy. For not some 20 range. I found
600 ft possible. (no more recorded muzzle - cleaned)
6000 ft 1.182
(502 ft) 2 = 1.95 This 600 ft not shoot
2 = 1.95 3 = 1.24 consistent 6000 groups. More
6.21 Ave. than three groups were
2/11/83 (To C. W. K. M. D. H. 2/11/83)
cut 2 251253 Gun # R 2512535
Group #1 = 1.96
2 = 2.25 3 = 2.16
3 = 2.26 4 = 2.46
2.80 Ave 2.02 Ave

Rem. Rem. Thank Luck
55 OR (PLNR)
TOSOR

(223)
Cute 221 Fireball and
one of the above stuff
221 251253 given to Rem.
to show Texas. Cleaned
and waxed well.

Accuracy Spec's
XP-100
221 FIREBALL
(5 SHOTS IN 3" INSIDE
TO INSIDE)
2 MM B.R.
(5 SHOTS IN 3" INSIDE
TO INSIDE)
No SPEC'S FOR
223 IN THE XP100
2/11/83
TJR

Wickes, Fred (Cousin)

2- info. on B. Smith's work on 11/11/12

Accurately to date. This was a group

1- 1.70

2- 2.52 11/10/12 REM. 11/10/12 P.S.P.

3- 1.92 11/10/12 REM. 11/10/12 P.S.P.

2.06 AUG.

NOTE: THE FIELD TESTED MEET WEEK

4.6. 11/10/12 TOTAL 11/10/12 P.S.P.

11/10/12, 11/10/12, 11/10/12, 11/10/12
at same and out

3- 11/10/12 11/10/12 11/10/12 11/10/12 11/10/12 11/10/12 11/10/12 11/10/12 11/10/12 11/10/12

FOR REVIEW AND A DECISION ON WHAT TO DO. STAY WITH

PURPOSE. THERE IS NO IN PLACE. 11/10/12 11/10/12 11/10/12 11/10/12 11/10/12 11/10/12 11/10/12 11/10/12 11/10/12 11/10/12

IS NEEDED IF WE GO TO STAY. (FOR J. HILL)

4- 11/10/12 11/10/12 11/10/12 11/10/12 11/10/12 11/10/12 11/10/12 11/10/12 11/10/12 11/10/12

ONE TO J. HILL. POOR GROUP. 11/10/12 11/10/12 11/10/12 11/10/12 11/10/12 11/10/12 11/10/12 11/10/12 11/10/12 11/10/12

TWO GIVE TO C. H. WORKMAN. 11/10/12 11/10/12 11/10/12 11/10/12 11/10/12 11/10/12 11/10/12 11/10/12 11/10/12 11/10/12

ONE GIVEN TO C. H. DID NOT HAVE TO BE A NEW

GROUP. INSTEAD. THIS TAKES TO THE NEXT

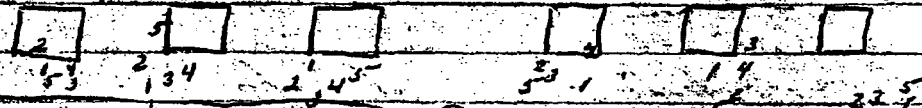
WEEK. ALSO HAVE OUT IN.

5- DRAWING CHANGE OF MAX. FOR 11/10/12 11/10/12 11/10/12 11/10/12 11/10/12 11/10/12 11/10/12 11/10/12 11/10/12 11/10/12

11/10/12, 11/10/12, 11/10/12, 11/10/12, 11/10/12, 11/10/12, 11/10/12, 11/10/12, 11/10/12, 11/10/12

11/10/12

11/10/12



11/10/12 11/10/12 11/10/12 11/10/12 11/10/12 11/10/12 11/10/12 11/10/12 11/10/12 11/10/12

2/2/52 - 2/15/52 - Wed - Thurs

1. Labour covering out before 19/52, XP 100 2 more
Rabbit Culture

2. We will make 100 each of the following
B- M/2 WT 250 SAUCE
D- XP 100 - 305 CAL

Rabbit will make the 100. Rabbit
Cauldron

The XP 100 305 will have to make
part of stock removed so Rabbit will
fit

Picked up all necessary parts so that
Custom Gun Shop each send 100 of each

- A- BARREL & BRACK
- B- Bolt
- C- RECEIVER
- D- XP 100 - STOCK (CR)

Receiver No's

XP 100	M/2 WT
B 75-13212	760 4575
B 75-13096	760 4516
B 75-10477	760 4504
B 75-14311	760 4703
B 75-13899	760 4709
B 75-13226	760 4507

All parts were bought on inventory

STILLER BOUNTY

RECEIVED PARTS FROM PROD.
GIVEN TO BACKPACKER BOUNTY
CHECKED IN CASES

PARTS BOUNTY M.R.P.

PARTS TO PICK UP 3/11/83

XP 100 RECS - 9 TOTAL (6 for 2mm OR,
and 3 for 223)
unit - 66 #15426

M/2 BARRELS - 6 TOTAL (2mm OR)
unit - 66 #32228

BARREL BRACKET - 6 (M/2)
unit - 66 #15425 - 3 (XP 100)

BOLT BODY ARM. 6 - (2mm OR) (for 2mm OR)
unit - #25253 3 - (221 RE.) (for 223)

STOCKS - XP 100 - 9 (2mm OR) (6 for 2mm OR)
unit - #91265 - (3 for 223)

3/11/93 - Monday

1- FAVORABLE WORKING CONDITIONS

LARRY BLACKHURST location CUSTOM GUN SHOP

from Tom PLUNKETT location RFD

Phone No. 256

Subject XP-100-222 CAUSER W/No. P-0230-000-Y Date 3/11/93

3 TOTAL

- 1- CUT OF BARREL TO CORRECT LENGTH. DWG. #C-344
- 2- CROWN
- 3- ASSEM. TO ACTION, CHAMBER & FINAL HEAD
- 4- POLISH & COLOR (PRODUCTION POLISH, NO HIGH GLOSS)
- 5- DRILL SIGHT HOLES- USE DIM'S FOR DEPTH AS DISCUSSED ON 3/11/93. *DO NOT USE DIM'S FOR DEPTH ON PRINT NO. C-345 AS THEY ARE TOO DEEP
- 6- HAND FIT BARRELED ACTION TO STOCKS. BARREL CHAM. WILL HAVE TO BE RE-WORKED FOR PROPER FIT.
- 7- ASSEM. REMAINING COMPONENTS
- 8- PROOF.

9- ACCURACY- 3 FIVE SHOT GROUPS PER COM. CHART BULLET IMPACT.

LARRY BLACKHURST location CUSTOM GUN SHOP

from Tom PLUNKETT location RFD

Phone No. 256

Subject XP-100-277308 W/No. P-1804-000-Y Date 3/11/93

6 TOTAL

- 1- CUT OF BARREL TO CORRECT LENGTH. DWG #C-349
- 2- CROWN
- 3- ASSEM. TO ACTIONS. - CHAMBER & FINAL HEAD.
- 4- DRILL FRONT SIGHT HOLES- USE DIM'S FOR DEPTH AS DISCUSSED ON 3/11/93. *DO NOT USE DIM'S ON PRINT C-349 AS THEY ARE TOO DEEP.
- 5- POLISH AND COLOR (PRODUCTION COLOR, NO HIGH GLOSS)
- 6- HAND FIT BARRELED ACTION TO STOCKS. BARREL CHAM. WILL HAVE TO BE CUT AWAY FOR PROPER FIT.
- 7- ASSEMBLE REMAINING COMPONENTS.

NOTE: DO NOT PROOF OR TEST FIRE.

3/22/81 - TUESDAY

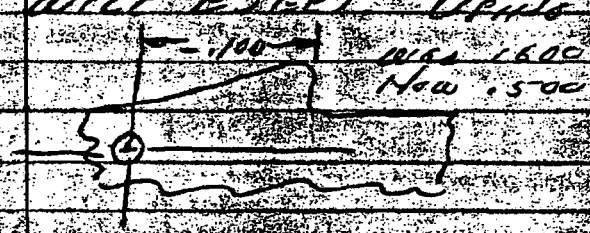
1. UNOILED HOT SHEET

XX 2. 14/27 100. ALL ROLL'S WITH 14/27 BARREL
XX 3. HOT SHEET MADE TO BE CUT ON END SO
THAT FRONT TAKE DOWN SCREW WILL
ENGAGE PROPERLY. HAVE TO ALIGN 14/27
BARREL



XP-100-300

3. Bolt Prop. is Part of M.S. Move Bolt
PROP. CUT BACK .100-50 THAT SHELL (LIVE RD.)
WILL EJECT. UPON XP OVERRR STEP.



4. HOUSEKEEPING INSPECTION - TEST LAB-52-1-A1.

5. XP 100-223, 2 M208, 300 - Man 1400RS REQUIRING
FOR INSPECTION, Testing & Transmittal (Cum-223, 2 M208)

2/20/52 Memorandum

1- SEE BELOW

WORK AND MAN HOUR REQUIRED FOR DESIGNING

BUILDING, TESTING & TRANSMITTING THE FOLLOWING PRODUCTS

Area & Work Description

CUSTOMER'S SHOP: BUILD REL.
 ACTUALLY REQUIRED
 (1 day) 40 hrs. (1 day) 40 hrs. (1 day) 40 hrs. (1 day) 40 hrs.
 \$125.00 \$125.00 \$125.00 \$125.00

PRODUCTION: BUILD REL.
 (1 day) 40 hrs. (1 day) 40 hrs. (1 day) 40 hrs. (1 day) 40 hrs.
 \$125.00 \$125.00 \$125.00 \$125.00

N/C: PERT CHARTS
 (1 day) 16 hrs. (1 day) 16 hrs. (1 day) 16 hrs. (1 day) 16 hrs.
 \$125.00 \$125.00 \$125.00 \$125.00

DESIGN: RE-DESIGN FROM, DMS,
 PARTS LIST, COST REQUEST, LAY-OUTS,
 BOM-UP CURRENTLY, 1715.
 (1 day) 40 hrs. (1 day) 40 hrs. (1 day) 40 hrs. (1 day) 40 hrs.
 \$125.00 \$125.00 \$125.00 \$125.00

MODEL SHOP: BUILD STOCK, PMS.
 (1 day) 120 hrs. (1 day) 120 hrs. (1 day) 120 hrs. (1 day) 120 hrs.
 \$225.00 \$225.00 \$225.00 \$225.00

TEST LAB: FIND MEASUREMENTS,
 ENDURANCE TEST, PRODUCT
 ACCEPTANCE.
 #1 40 hrs. (1 day) 40 hrs. (1 day) 40 hrs. (1 day) 40 hrs.
 #2 40 hrs. (1 day) 40 hrs. (1 day) 40 hrs. (1 day) 40 hrs.
 #3 40 hrs. (1 day) 40 hrs. (1 day) 40 hrs. (1 day) 40 hrs.
 \$125.00 \$125.00 \$125.00 \$125.00

TOTAL MAN HOURS
 #1 40 hrs. (1 day) 40 hrs. (1 day) 40 hrs. (1 day) 40 hrs.
 #2 40 hrs. (1 day) 40 hrs. (1 day) 40 hrs. (1 day) 40 hrs.
 #3 40 hrs. (1 day) 40 hrs. (1 day) 40 hrs. (1 day) 40 hrs.
 \$125.00 \$125.00 \$125.00 \$125.00

PER HOUR
 #1 40 hrs. (1 day) 40 hrs. (1 day) 40 hrs. (1 day) 40 hrs.
 #2 40 hrs. (1 day) 40 hrs. (1 day) 40 hrs. (1 day) 40 hrs.
 #3 40 hrs. (1 day) 40 hrs. (1 day) 40 hrs. (1 day) 40 hrs.
 \$125.00 \$125.00 \$125.00 \$125.00

DEC. WAGE RATES:
 WAGE ROLL — \$24.42
 MAN EMERG — \$24.42
 EXEMPT — \$36.15

3/15/52
 J.J. PLUNKER

2- 10/15/52 - TRIAL: PILOT - PICKED UP & SAMPLED
 FROM PRODUCTION PER J.W. BROOKS

3- RE-OLD ABOVE - CUS HOURS

1. General 2. Particular 3. Conclusion
 4. Summary 5. Remarks 6. Signature
 7. Date 8. Place 9. Time
 10. Witness 11. Witness 12. Witness
 13. Witness 14. Witness 15. Witness
 16. Witness 17. Witness 18. Witness
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 310. Witness 311. Witness 312. Witness
 313. Witness 314. Witness 315. Witness

5. X-100-121 CAC. Name of the person who was arrested
 at the time of the arrest. For 1994, the name
 of the person who was arrested is [redacted]

[illegible]

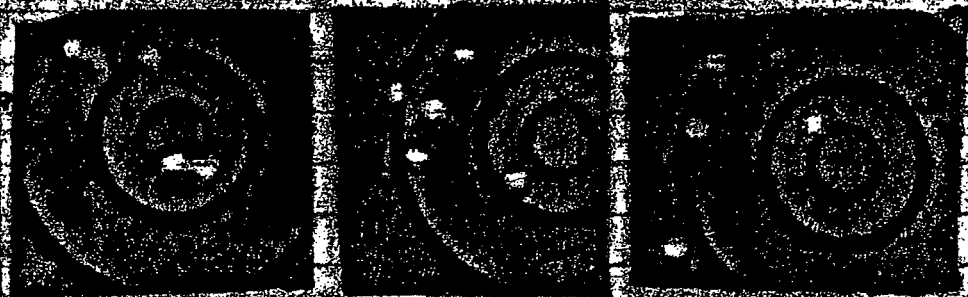
Along Amnong
FIRST TRAP NET

# <u>0554</u>	<u>0506</u>	# <u>4007</u>	<u>4009</u>	# <u>6013</u>	<u>6015</u>
1 - 1.26	1.40	1 - 2.40	2.40	1 - 2.72	2.14
2 - 1.20	2.44	2 - 2.40	2.40	2 - 1.45	1.75
3 - 2.00	1.91	3 - 2.55	2.55	3 - 2.00	2.04
<u>6.26</u>		<u>9.80</u>		<u>6.17</u>	
53 - 2.02 AUE	2.56	53 - 2.02 AUE	4.12	53 - 2.05 AUE	2.3

STATE OF ARIZONA, COUNTY OF PIMA, QUARTER DIRT

5. W/PROBABLE PERSONAL SCREENING. The
process will be a primary in most cases
when staff are not yet trained and to
check the screen sheet to determine
more thoroughly about
the person and not under control.

All data taken from
 Remington-Union Carbide
 Co. and all data taken from
 Remington-Union Carbide Co.



AVG.
 1.06



AVG.
 .73

Score for 1st Group



AVG-1.28

(Score for 1st Group)
 (Score for 2nd Group)

Notes

- 0- Rifle fired from gallery
- 0- Gun cleaned prior to testing
- 0- Cooled after each group
- 0- Not cleaned between ammo types
- 0- Ammo saved to be used in future accuracy

14-12-1961

5/16/93 - Chardway

Tommaso

12/7 2005

12. Increase = 15 mil each. Date 2:30

5/18/63 - M-L

2003: Was start work tomorrow. GETTING