

SE "NOIEAR" ®

BOORUM & PEASE "NOIEAR" ®

Model 660



660



Original 9-25-66  
REVISED 3-13-69

REMINGTON STANDARDS - ARMS

PAGE 1

MODEL 660	308 Win.	6MM Rem.	222 Rem.	5.56 Rem.	243 Win.	223 Rem. (Export Only)
ACCURACY						
Range	100 yards					
Point of Aim	6 o'clock on target.					
Center of Impact	Not more than 2 inches below or 4 inches above or 3 inches either side of point of aim.					
Group Size (E.S.)	5 shots in:	3.8"	2.7"	2.7"	2.7"	2.7"
(1) (Center to Center)	4 shots in:	3.3"				
Ammunition	180 gr. PSP	100 gr. PSP	50 gr. SP		100 gr. PSP	55 gr. SP
ACTION	<p>Bolt action, hand operated. Removable bolt. Solid frame with takedown stock. Bolt cocks as handle is raised. Rifle cocks as bolt handle is lowered to lock action closed. Extracts and ejects as bolt is "opened". Direct action trigger. 2 stop safety - Forward to FIRE position - rearward to ON SAFE stop position.</p> <p>Action must feed, fire, extract and eject (include extraction and ejection without firing) satisfactorily with all varieties of ammunition listed as standard (for tabulated calibers) in Technical Committee Manual of the Sporting Arms and Ammunition Manufacturers' Institute (SAMMI)</p>					
ANNOUNCEMENT						
Jan. 1968						
Ref.: Operation Committee Minute #17 - 1966.						
(1) Ref: See letter G.M. Calhoun to S.M. Alvis	3-18-66. E.S. revised by W.E. Leek to comply with C to C requirement.					

11-0-000



11-30-67  
REVISED 10-10-69

REMINGTON STANDARDS - ARMS

SHEET 2 of 7

223 Rem.  
(Export Only)

MODEL 660	308 Win.	6mm Rem.	222 Rem.	243 Win.	223 Rem. (Export Only)
BARREL	Round tapered to breech and crowned at muzzle. Black color, medium lustre. Remington specification alloy steel.				
Bedding	No requirement.				
Barrel Bracket	Elevated type.				
Length (Nominal)	20"				
Diameter (O.D.)	Magnum size				
Bore (in.)	.300 min.	.237 min.	.219 min.	.237 min.	.219 min.
	.302 max.	.238 max.	.220 max.	.238 max.	.220 max.
Groove (in.) (6)	.308 min.	.243 min.	.2240 min.	.243 min.	.224 min.
	.310 max.	.244 max.	.2250 max.	.244 max.	.225 max.
Twist (R.H.)		(1)		(1)	
1 Turn in: (Mean)	10 inches	9-1/8 inches	14 inches	9-1/8 inches	12 inches
Markings	See MARKINGS - Barrel				
BARREL RIB	None				
BOLT (final assembly)	Includes Bolt Assembly, Firing Pin Assembly				
Bolt Lugs	Black color				
Bolt Body	Bright Steel				
Bolt Plug	Black color, shroud or hooded type				
Bolt Handle	Black color, Forward "S" shape with oval "half ball". Serrated on bottom of half ball.				
Firing Pin Head	Black color				
(2) Markings	Serial number on bottom of bolt. See MARKINGS - Bolt. Last four (4) numbers only.				
BOLT STOP	Located in left rear of "bolt track" in receiver. Use narrow tool to push down for release.				
(1) See Model Drawing.					
(2) See Model Drawing.					



SHEET 3

MODEL	660	308 Win.	6MM Rem.	222 Rem.	XXXXXX	243 Win.	223 Rem. (Export Only)
ATT PLATE	Black plastic						
ATT PLATE SPACER	White plastic						
JECTOR	Plunger type - spring loaded and pin assembled in bolt head.						
TRACTOR	Riveted to bolt.						
RING PIN	Spring retracted in bolt.						
Protrusion	.045 min. - .075 max.						
Indent	.018 min. - .026 max. - (using copper crusher)						
- Length (Overall)	38 3/4" (Nominal)						
- Weight	6 1/2 lbs. (Approx.)						
GAZINE	Fixed - top loading						
Capacity	4	4	5	XXXX	4	5	
Follower	Bright plate. No	No	No	Yes	XXXXX	No	Yes
Spacer	No	No	Yes	XXXXX	No	Yes	
CAP	M/1100 style - Black plastic. Diamond inlay - White plastic.						
CAP SPACER	White plastic						
						</	



EX-113 1968



Original 9-25-66  
REVISED 11-30-67

REMINGTON STANDARDS - ARMS

SHEET 4

MODEL 660	308 Win.	6MM Rem.	222 Rem.	<del>25 Rem.</del>	243 Win.	223 Rem. (Export Only)
<b>MARKINGS</b>	All marking visible unless specified otherwise.					
Barrel	Dwg. B-14398					
Assembly	Left rear					
Remington Name	Left side					
Remington Address	Left side					
Caliber	Left rear					
Code (Mfg. Date)	Left rear					
Patent Numbers	Below Remington name (If any)					
Proof (REP)	Right rear					
Test	Right rear					
Other:						
Magnaflux	Right rear (to rear of (REP) marking.					
Receiver	Dwg. B-14398					
Grade	None					
Remington Script	Left center					
Model Number	Below script (Rem.)					
Serial Number	Left front					
(1) Other:	Mark "S" and "F" on receiver adjacent to respective SAFE and FIRE stop positions of safety.					
Bolt	(Prick-punch mark) Ref: Current practice.					
Magnaflux	Right lug (center)					
Bolt Head Braze	Left lug (center)					
Bolt Handle Braze	Rear handle (center)					
Proof	Bottom handle (center)					
<b>METAL FINISH</b>	Black color, medium lustre on all exposed parts except as otherwise tabulated.					
<b>PATENT NUMBERS</b>	None.					
(1) Added. See SAFETY for reference.						



11-30-67  
REVISED 10-10-69

REMINGTON STANDARDS - ARMS

SHEET 5 of 7

223 Rem.  
(Export Only)

MODEL	660	308 Win.	6mm Rem.	222 Rem.	243 Win.	223 Rem. (Export Only)
PACKAGING	(3)	Full length.	Exposed metal parts coated with rust preventive.		Bolt packaged separately in carton.	
Literature		Instruction Folder - Parts List RD-5733				
Single Shipper		Single piece corrugated sheet, integral folds for rifle support. black artwork (Deer and Bear). Lid taped to close.			Marbleized color with brown and	
Multiple Shipper		Sleeve or full carton of corrugated material.				
Label		Green and white, model, serial number, caliber, packers code on label.				
Markings		Name and address of addressee, with copy of shipping ticket, return address.				
(2) (1) Shipping Weight						
1 Gun		8 lbs.				
2 Guns		16 lbs.				
3 Guns		23 lbs.				
5 Guns		38 lbs.				
Export		Same as domestic except: Legal or actual weight on label.				
PROOF TEST (REP)		Fire one (1) standard proof cartridge in each gun. For location of marking (REP) see MARKINGS - Barrel.				
RECEIVER		Cylindrical alloy steel, black color, medium lustre. Screw fitted to barrel and barrel bracket (solid frame).				
Sighting		Drilled and tapped (5 holes) for receiver sight and telescope mount. Fitted with receiver plug screws.				
Gas Escape		One (1) hole - right side.				
Length		Standard				
Markings		See MARKINGS - Receiver				
(1) Weights added per W. W. Fenton (Warehouse) 11-28-67						
(2) Weights corrected per Warehouse (W. W. Fenton)						
(3) Bolt indicated as packaged separately. Current practice.						



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REVISED 11-30-67

REMINGTON STANDARDS - ARMS

SHEET 6 of 7

MODEL	660	308 Win.	6MM Rem.	222 Rem.	<del>357&amp;XX</del>	243 Win.	223 Rem. (Export Only)
SAFETY	2-stop position, forward and back-thumb operated. Serrated black surface.						
Location	Right rear of receiver.						
(1) Fire Position	Forward stop. "F" Marking on receiver.						
(2) Safe Position	Rear stop (Bolt handle locks down - action closed). "S" Marking on receiver.						
Note: For Export	Markings, see MARKINGS - Receiver.						
SERIAL NUMBER (3)	First No. 6,200,000 - Last No. 6,899,999 to be used.						
Location (1)	See MARKING - Receiver						
(2)	See MARKING - Bolt						
SLING STRAP	As accessory at extra cost.						
Description	7/8" Q.D. type same as used on M/700. Leather material.						
SIGHTS	Metal material. Black color.						
Front (700 type)	Adjustment for windage and elevation. "U" notch. White indicator Graduated notches. Attached to barrel with two (2) screws.						
Rear (700 type)							
Eyepiece							
Step							
Base							
Front (700 type)	Dovetail fit for windage adjustment.						
Base	Serrated ramp. Attached to barrel by two (2) screws.						
Sight	Brass bead (flat).						
(1) Added. See Operations Comm. Mem. #13, 7-20-67.							
(2) Added. See (1) above.							
(3) Serial No. Sequence added. See Marking Dwg. C-14398.							



REMINGTON STANDARDS - ARMS

SHEET 7

MODEL	660	308 Win.	6MM Rem.	222 Rem.	<del>XXXX</del>	243 Win.	223 Rem. (Export Only)
STOCK	Comb cuts.	Formed grip.	Monte Carlo	Angular forearm.	Black	fore-end tip.	Tip Spacer (white).
Material	American Walnut						
Drop at Comb	1 7/8"						
Drop at Heel	2"						
Drop at Monte Carlo	1 5/8"						
Pitch	1 5/8"						
Length of Grip	3 1/2"						
Length of Pull	14 1/8"						
Length of Stock	31 1/4"						
Tang Support	None						
Grip Cap	Plastic						
Grip Cap Spacer	Plastic						
Grip Cap Inlay	Plastic						
Checker	D-15844 (Custom)						
Finish	RK-W						
Bedding	Regular						
TRIGGER	Metal material, Black color.						
Finger Surface	Serrated.						
Pull (lbs.)	4 lbs. min. - 6 lbs. max.						
Engagement	Sealed at factory.						
TRIGGER GUARD	Black "Zytel".						
Type	One piece mold.						

**CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER**

R2528135



OCT 3 1996



Original 9-25-66  
REVISED 3-13-69

REMINGTON STANDARDS - ARMS

SHEET 1

MODEL 660 MAGNUM		350 Rem. Mag.	6.5MM Rem. Mag.
ACCURACY			
Range	100 yds.		
Point of Aim	6 o'clock on target		
Center of Impact	Not more than 2 inches below or 4 inches above or 3 inches either side of point of aim.		
(1) Group Size (E.S.)	Center to Center	5 shots - 3.8"	5 shots - 3.7"
Ammunition		200 gr. PSP	120 gr.
ACTION		Bolt action, hand operated. Removable bolt. Solid frame with takedown stock. Bolt cocks as handle is raised. Rifle cocks as bolt handle is lowered to lock action closed. Extracts and ejects as bolt is "opened". Direct action trigger. 2 stop safety - Forward to FIRE position - forward to ON SAFE stop position.	
		Action must feed, fire, extract and eject (include extraction and ejection without firing) satisfactorily with all varieties of ammunition listed as standard (for tabulated calibers) in Technical Committee Manual of the Sporting Arms and Ammunition Manufacturers' Institute (SAAMI).	
ANNOUNCEMENT			
Jan. 1968			
Ref: Operation Committee Administrative - 1200			
(1) Ref: See letter G.M. Calhoun to S.M. Alvis 3-18-66 E.S. revised to comply with SAAMI			



Original 9-25-66  
REVISED 10-10-69

REMINGTON STANDARDS - ARMS

SHEET 2 of 7

MODEL 660 MAGNUM	350 Rem. Mag.	6.5MM Rem. Mag.
BARREL	Round, tapered to breech and crowned at muzzle. Black color, medium lustre. Remington specification alloy steel.	
Bedding	No Requirement	
Barrel Bracket	Elevated	See 350 Mag.
Length (Nominal)	20"	See 350 Mag.
Diameter (O.D.)	Magnum	See 350 Mag.
Bore (in.)	.349 Min. .351 Max.	.256 Min. .257 Max.
Groove (in.) (6)	.357 Min. .359 Max.	.264 Min. .265 Max.
Twist (R.H.) 1 turn in	16" (Nominal)	9" (Nominal)
Markings	See MARKINGS - Barrel	
BARREL RIB	None	
BOLT (Final Assembly)	Includes Bolt Assembly, Firing Pin Assembly.	
Bolt Lug	Black color.	
Bolt Body	Bright steel.	
Bolt Plug	Black color. Shroud or hooded design.	
Bolt Handle	Black color. Forward "S" shape with oval "half ball".	Serrated on bottom of half ball.
Firing Pin Head	Black color.	
Markings (1)	Serial Number on bottom of bolt. See MARKINGS - Bolt.	Last four (4) numbers only.
(1) Last four (4) numbers only. See model drawing.		



Model 660 Mag.



Original 9-25-66  
REVISED 3-13-69

REMINGTON STANDARDS - ARMS

SHEET 1

REVISED 3-13-69		350 Rem. Mag.		6.5MM Rem. Mag.			
MODEL 660 MAGNUM							
ACCURACY							
Range		100 yds.					
Point of Aim		6 o'clock on target					
Center of Impact		Not more than 2 inches below or 4 inches above or 3 inches either side of point of aim.					
(1)	Group Size (E.S.)	Center to Center		5 shots - 3.8"		5 shots - 3.7"	
Ammunition		200 gr. PSP		120 gr.			
ACTION		Bolt action, hand operated. Removable bolt. Solid frame with takedown stock. Bolt cocks as handle is raised. Rifle cocks as bolt handle is lowered to lock action closed. Extracts and ejects as bolt is "opened". Direct action trigger. 2 stop safety - Forward to FIRE position - forward to ON SAFE stop position.					
		Action must feed, fire, extract and eject (include extraction and ejection without firing) satisfactorily with all varieties of ammunition listed as standard (for tabulated calibers) in Technical Committee Manual of the Sporting Arms and Ammunition Manufacturers' Institute (SAAMI).					
ANNOUNCEMENT							
Jan. 1968							
Ref.: Operation Committee Minute #17 - 1966.							
(1) Ref: See letter G.M. Calhoun to S.M. Alvis 3-18-66 E.S. revised to comply (W.E. Leek) with C to C requirement.							



Original 9-25-66  
REVISED 10-10-69

REMINGTON STANDARDS - ARMS

SHEET 3 of 7

MODEL 660 MAGNUM	350 Rem. Mag.	6.5MM Rem. Mag.
BOLT STOP	Located in left rear of "bolt track" in receiver. Use narrow tool to push down for release.	
BUTT PLATE	See RECOIL PAD	
EJECTOR	Plunger type. Spring loaded and pin assembled in bolt head.	
EXTRACTOR	Riveted.	
FIRING PIN	Spring retracted in bolt.	
Protrusion	.045" Min. - .075" Max.	
Indent	.018" Min. - .026" Max. (using copper crusher).	
GUN - Length	(Overall)	38 3/4" (Nominal)
(1) - Weight		6 3/4 lbs.
(with strap & swivels)		6 3/4 lbs.
MAGAZINE	Fixed - Top Loading	
Capacity		3
Follower	Bright Plate	
(1) Current (10) gun sampling.		



Original 9-25-66  
 Revised 11-30-67

REMINGTON STANDARDS - ARMS

SHEET 4

MODEL 660 MAGNUM

350 Rem.  
 Mag.

6.5MM  
 Rem. Mag.

MARKINGS

Barrel	Dwg. No. B-14398. Same for all calibers.
Assembly	Left rear
Rem. Name	Left side
Rem. Address	Left side
Caliber	Left rear
Code (Mfg. Date)	Left rear
Patent Numbers	Below Remington name (if any).
Proof (REP)	Right rear
Test	Right rear
Other	
Magnaflux	Right rear (to rear of (REP) marking).

Receiver	Dwg. No. B-14398
Grade	None
Rem. Script	Left center
Model No.	Below script (Rem.)
Serial No.	Left front

(1) Other: Mark "S" and "F" on receiver adjacent to respective SAFE and FIRE stop positions of safety.

Bolt	(Pricke-punch mark) Ref.: Current practice for all calibers.
Magnaflux	Right lug (center)
Bolt Head Braze	Left lug (center)
Bolt Handle Braze	Rear handle (Center)
Proof	Bottom handle (center)

METAL FINISH Black color, medium lustre on all exposed parts except as otherwise tabulated.

PATENT NUMBERS None.

(1) Added. See SAFETY for reference.



Original 9-25-66  
REVISED 10-10-69

REMINGTON STANDARDS - ARMS

SHEET 5 of 7

MODEL 660 MAGNUM		350 Rem. Mag.	6.5MM Rem. Mag.
PACKAGING (1)	Full length. Exposed metal parts coated with rust preventive. Bolt packaged separately in carton.		
Accessories	Sling strap and fittings packed separately in carton.		
Literature	Instruction Folder - Parts List, RD 573 <sup>3</sup>		
Single Shipper	Single piece corrugated sheet, integral folds for rifle support. Marbleized color with brown and black artwork (Deer and Bear). Lid taped to close.		
Multiple Shipper	Sleeve or full carton of corrugated material.		
Label	Green & white, model, serial no., caliber, packers code on label.		
Markings	Name, address of addressee, with copy of shipping ticket, return address.		
Shipping Weight			
1 Gun	9 lbs.		
2 Guns	18 lbs.		
3 Guns	26 lbs.		
5 Guns	43 lbs.		
Export	Same as domestic except "legal" or actual weight on label.		
PROOF TEST (REP)	Fire one (1) standard proof cartridge in each gun. For location of marking (REP) see MARKING - Barrel.		
RECOIL PAD (Black with white spacer)	Yes	Yes	
RECEIVER	Cylindrical alloy steel, black color, medium lustre. Screw fitted to barrel and barrel bracket (solid frame).		
Sighting	Drilled and tapped (5 holes) for receiver sight and telescope mount. Fitted with receiver plug screws.		
Gas Escape	One (1) hole - right side.		
Length	Standard		
Markings	See MARKINGS - Receiver.		
(1) Bolt packaged separately. Current practice.			



10-10-69  
REVISED 11-30-67

REMINGTON STANDARDS - ARMS

SHEET 6 of 7

MODEL 660 MAGNUM	350 Rem. Mag.	6.5MM Rem. Mag.
SAFETY	2-stop position, forward and back thumb operated.	Corrugated black surface.
Location	Right rear of receiver.	
(1) Fire Position	Forward stop. "F" Marking on receiver.	
(1) Safe Position	Rear stop (bolt handle locks down - action closed). "S" Marking on receiver.	
SERIAL NUMBER (3)	First No. 6,200,000 - Last No. 6,899,999 to be used.	
Location (1)	See MARKING - Receiver	
(2)	See MARKING - Bolt	
SLING STRAP & SWIVELS, Q.D.	Yes	Yes
Description	7/8" Q.D. type, same as used on M/700	Leather material.
SIGHTS	Metal material. Black color.	
Front (700 type)	Dovetail fit for windage adjustment.	
Base	Serrated ramp. Attached to barrel by two (2) screws.	
Sight	Brass bead (flat).	
Rear (700 type)	Adjustment for windage and elevation.	
Eyepiece	"U" notch. White indicator.	
Step	Graduated notches.	
Base	Attached to barrel with two (2) screws.	
(2)(1) "S" and "F" added.	See Operations Comm. Min. #13, dated 7-20-67.	
(3) No. sequence added.	See Marking Dwg. C-14398.	



Original 9-25-66  
REVISED 11-30-67

REMINGTON STANDARDS - ARMS

SHEET 6

MODEL 660 MAGNUM		350 Rem. Mag.	6.5MM Rem. Mag.
<b>SAFETY</b>	2-stop position, forward and back thumb operated.	Corrugated black surface.	
Location	Right rear of receiver.		
(1) Fire Position	Forward stop. "F" Marking on receiver.		
(1) Safe Position	Rear stop (bolt handle locks down - action closed). "S" Marking on receiver.		
<b>SERIAL NUMBER</b>			
Location (1)	See MARKING - Receiver		
(2)	See MARKING - Bolt		
<b>SLING STRAP &amp; SWIVELS, Q.D.</b>		Yes	Yes
Description	7/8" Q.D. type, same as used on M/700	Leather material.	
<b>SIGHTS</b>			
Front (700 type)	Metal material Black color.		
Base	Dovetail fit for windage adjustment.		
Sight	Serrated ramp. Attached to barrel by two (2) screws.		
	Brass head (flat).		
Rear (700 type)	Adjustment for windage and elevation.		
Eyespiece	"U" notch. White indicator.		
Stop	Graduated notches.		
Base	Attached to barrel with two (2) screws.		
(1) "S" and "F" added. See Operations Comm. Min. #13, dated 7-20-67.			



Original 9-25-66  
REVISED

REMINGTON STANDARDS - ARMS

SHEET 7

MODEL 660 MAGNUM	350 Rem. Mag.	6.5MM Rem. Mag.
<b>STOCK</b>	Comb cuts. Formed grip. Monte Carlo. Angular forearm. Black tip.	
Material	Walnut and Beech - laminated. Drilled for swivels.	
Drop at Comb	1 7/8"	See 350 Mag.
Drop at Heel	2"	See 350 Mag.
Drop at Monte Carlo	1 5/8"	See 350 Mag.
Pitch	1 5/8"	See 350 Mag.
Length of Grip	3 1/2"	See 350 Mag.
Length of Pull	14 + 1/8"	See 350 Mag.
Length of Stock	31 1/4"	See 350 Mag.
Tang Support (Delrin)	In stock	See 350 Mag.
Grip Cap (M/1100 type)	Black plastic.	
Grip Cap Spacer	White plastic	
Grip Cap Inlay	White plastic	
Checker	D-15844 (Custom)	
Finish	RK-W	See 350 Mag.
Bedding	Custom	See 350 Mag.
<b>TRIGGER</b>	Metal material. BRASS COIL.	
Finger Surface	SCREWED.	
Pull (lbs.)	4 lbs. min. - 6 lbs. max.	
Engagement	Sealed at factory.	
<b>TRIGGER GUARD</b>	Black "Zytel"	
Type	One piece mold.	



OCT 3 1966



Asile Question. M/660

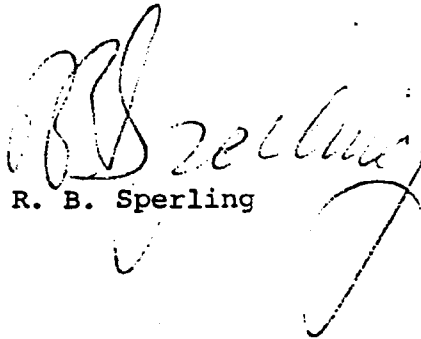


Recall 600

**DON'T SAY IT—WRITE IT**

To P. J. ROSENDAHL Location \_\_\_\_\_  
From R. B. SPERLING Location \_\_\_\_\_ Phone No. \_\_\_\_\_  
Subject D. W. ASTLE - NEW ZEALAND Date 9/17/79

Attached is a proposed reply to Mr. Astle.

  
R. B. Sperling

RBS:hss  
Attachment

cc: E. G. Larson

RD 779

STOP, LOOK, AND LIVE

*File*



D R A F T

Mr. D. W. Astle  
12 Tahu Cresent  
GLENFIELD

Dear Mr. Astle:

Your letter to Neill, Cropper & Co. Ltd. dated August 17, 1979, has been forwarded to our attention.

The installation of a new trigger assembly that has been modified to correct the potential problem described in our recall notice, will fully restore your Model 660 to Remington's current operating standards. Remington stands solidly behind all of its firearms with respect to their operation, but we cannot reasonably be expected to guarantee their value on the second-hand market at any particular point in time. Consequently, with our program of no-charge alteration of the Model 660, which completely restores the operational integrity of the rifle, we believe that Remington has completely fulfilled its obligations to its customers.

Very truly yours,

RBS:hss  
9-17-79



TO R B. Sperling 9/11/79  
FROM P. J. ROSENDAHL

Any suggestions on how we  
should reply to this correspondence  
from New Zealand?

Thanks.

PR

RECEIVED

SEP 14 1979

R. B. SPERLING



**DON'T SAY IT-WRITE IT**

To Pete Location \_\_\_\_\_  
From Earl Location \_\_\_\_\_ Phone No. \_\_\_\_\_  
Subject \_\_\_\_\_ Date \_\_\_\_\_

The installation of the new trigger bumps  
the gun up to current standards and that is all  
we are required to do.

If he so desires he can sell the repaired gun  
& purchase a new one.

You may want to get better legal language from  
Bst speaking.

RECEIVED

SEP 12 1979

P.J. ROSENDAHL

EF

RD 779

STOP, LOOK, AND LIVE



TO E Larson 9/10/79

FROM P. J. ROSENDAHL

Would you please review this  
correspondence & let me have  
your comments on how to reply.

Thanks  
P. J. Rosendahl



# Neill, Cropper & Co. Ltd.

CABLES & TELEGRAMS  
"CROPS" AUCKLAND.  
ALL STANDARD CODES  
TELEX N.Z.2521

CROPPER - NRM BUILDING,  
ANZAC AVENUE, AUCKLAND, 1, NEW ZEALAND  
TELEPHONE 31-049, P.O. BOX 9, AUCKLAND, NEW ZEALAND.

AUCKLAND  
WELLINGTON  
CHRISTCHURCH  
DUNEDIN  
SYDNEY

*file*  
MFB:sw

27 August 1979

Remington Arms Co Inc  
Bridgeport  
Connecticut 06602  
U S A

Attention: Mr P Valesco

Dear Pastor

## Rifle - Recall

Please find enclosed copies from a Mr Astle regarding his Model 660. As you will see he is very persistent and because of his attitude we felt that we should bring the matter to your attention before he wrote to you direct.

Whilst we feel that his comments and suggestions are not valid and do not warrant any action other than having the trigger assembly replaced, it would be appreciated if you would advise us of your decision in respect of this case.

To date we have located nine fire-arms which are subject to re-call and we should be able to give you a final figure next month.

We will advise you once the number has been established so that you can make arrangements to forward the parts required to modify the fire-arms.

We look forward to your reply on the matter of Mr Astle's rifle.

Kind regards

*M. F. Bush*  
Maurice F Bush  
SPORTING GOODS DEPT

RECEIVED  
SEP 4 1979  
INTERNATIONAL



# Neill, Cropper & Co. Ltd.

CABLES & TELEGRAMS  
"CROPS" AUCKLAND.  
ALL STANDARD CODES  
TELEX N.Z.2521

CROPPER - NRM BUILDING,  
ANZAC AVENUE, AUCKLAND, 1, NEW ZEALAND  
TELEPHONE 31-049. P.O. BOX 9, AUCKLAND, NEW ZEALAND.

AUCKLAND  
WELLINGTON  
CHRISTCHURCH  
DUNEDIN  
SYDNEY

HFB:sw

27 August 1979

Mr D M Kastle  
12 Tahu Crescent  
GLENFIELD

C O P Y

Dear Sir

We are in receipt of your letter of August 17 regarding your Model 660 and will pass on your request to Remington.

We will advise you of their reply and their decision as soon as we hear from them.

Yours faithfully  
NEILL, CROPPER & CO LTD

M F Bush  
SPORTING GOODS DEPT



GLENFIELD  
AUCKLAND 10

17 August 1979

20 AUG 1979

A

Mr M F Bush  
Neil Cropper & Co. Limited  
PO Box 9  
AUCKLAND

Dear Sir

Further to our correspondence in regard to the recall of my Remington rifle for the installation of a new trigger assembly, you wished me to elaborate on my objections to this proposal.

Firstly the Remington 660 rifle is now regarded as a "Maverick" weapon by two leading sports stores in Auckland. I approached two stores with the proposition of trading my weapon (after your repair work) on another weapon. They were reluctant to accept my weapon on the grounds of the publicity it had recently received.

I can no longer use the rifle with confidence. Thus it is useless to me. I can not dispose of the rifle without a considerable financial loss to myself.

Also, the Remington guarantees would not be fully applicable after the weapon had been altered; other than in the Remington factory.

The fact that there are only a few Remington 660s in New Zealand should not have any bearing on my proposal.

I would appreciate your presenting my personal request to Remington in regard to an exchange rifle with me meeting fair depreciation costs.

I look forward to your reply on this matter.

Yours faithfully

  
D W Astle



12 Tahu Crescent  
Glenfield  
AUCKLAND 10

Mr M F Bush  
Neil, Cropper & Co Limited  
PO Box 8847  
Symonds Street  
AUCKLAND

Dear Sir

RECALL OF REMINGTON MODEL 660 RIFLES

I am the owner of a Remington Model 660 Rifle; and upon reading the statement in the July issue of the N.Z. Outdoor Magazine I wish to enquire what avenues are open to me to have the fault rectified.

I am reluctant to accept the installation of an alternative trigger assembly. The reasons being obvious to weapon manufacturers, distributors and owner-users.


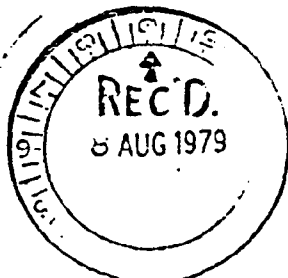
I would consider replacement of my present Model 660 faulty Rifle with a model 700 equivalent rifle to be a more appropriate arrangement.

I would expect to pay an agreeable sum to counter depreciation of my present weapon.

If you are unable to assist me further in negotiating a suitable arrangement could you please refer me to the person responsible for such matters at the principle office in the United States.

Yours faithfully

  
D W Astle





MFBS:sw

8 August 1979

Mr D W Astle  
12 Tahu Crescent  
Glenfield

Dear Sir

We are in receipt of your letter regarding the Remington rifle re-call and noted with interest your comments.

The procedure we are following is that laid down by Remington and therefore we are unable to accept your proposal of supplying you with a Model 700.

You mention that you are reluctant to accept the installation of a new trigger assembly for obvious reasons, however we, and our Gunsmith, are not aware of these.

There are a relatively small number of rifles in New Zealand involved in the re-call and we have received no objections from the owners at having their firearms fitted, at no charge, with new trigger assemblies by a warranty Gunsmith.

Should you be more specific in your objections to this procedure, we will be happy to take the matter up with Remington.

We look forward to your reply on this matter.

Yours faithfully  
NEILL, CROFTON & CO LTD

M F Bush  
SPORTING GOODS DEPT

MANAGER	18
PRODUCTION	18
SALES	18
...	18
...	18
...	18



M/660 - Bolt



PROCESS ENGINEERING ASSIGNMENTS			
<b>Job Description:</b>  <b>M/660 Bolt Assemblies</b>  <b>Char.- Safe binds in Bolt</b>		<b>Area Engineer:</b> Burns	
		<b>Sheet No.:</b> 1 <b>Job No.:</b> 3917-B5	
		<b>Job Priority:</b> D	
		<b>Job Code:</b> 6	
		<b>Model:</b> 660	
		<b>Part Name:</b> Bolt	
		<b>Oper. No.:</b> 5	
		<b>Dept. No.:</b> 60	
		<b>Est. Comp. Mo/Yr:</b>	
		<b>Est. Comp. Hours:</b>	
<b>Assigned By:</b>		<b>Date:</b>	<b>Est. Savings:</b>
<b>Report Date</b>	<b>Elapsed Hrs.</b>	<b>Accomplishments</b>	
11/18/68	8	One hundred handles were processed milling stem to $-.008 \pm .0025$ on Base Gage D-35108. Of the 100 Bolts, thirty had safe bind. Since M/Dwg. calls for a radius on handle, a TDR was issued to design cutter to mill radius. This would permit the Bolt to rotate approx. .015 in Receiver and should eliminate the Safe binding.	

RD - 6566 2/1/63



# LIMITED DISTRIBUTION

REMINGTON ARMS COMPANY, INC.  
Ilion, New York

Nov. 18, 1969

CC: F. E. Morgan - Bdpt.  
S. M. Alvis  
L. J. Boyle  
E. R. Carr  
L. Fox  
R. P. Kelly  
A. D. Kerr  
R. A. Williamson

F. G. CARLSON


## MOHAWK 660 BOLT ACTION CENTER FIRE RIFLE

Marketing is considering offering the Model 660 Center Fire Rifle as a Mohawk brand for 1971. The specifications would be the same as the Model 660 except -

1. The Stock would be the Model 600 which is without the Fore End Tip, Grip Cap and Spacer, and Butt Plate Spacer.
2. The Barrel would be the magnum Barrel same as the Model 660 except 18½" length and roll marked "Mohawk".
3. Barrel and Receiver would be Almco deburred and polish finish.
4. The Trigger is to be gold plated (Mohawk brand designation).
5. Receiver marking Mohawk.

R & D has been requested to determine if the 6.5mm and 350 Rem. magnum calibers require the laminated Stock. The magnum caliber rifles would require a Recoil Pad and the Sling and Swivels specified for the Model 788.

As soon as estimates are available from P E & C, Methods & Standards should develop a factory cost. Marketing will then determine selling prices.

  
V. G. DeReus, Secretary  
Operations Committee

VGD:I



W/640 - Book



*17 June*

PROCESS ENGINEERING ASSIGNMENTS

Job Description:  Char. - New Model  Oper. - Compile Process	Area Engineer: <b>Nielsen</b> Sheet No.: <b>1</b> Job No.: <b>3199-17</b> Job Priority: <b>A-3</b> Job Code: <b>1</b> Model: <b>660</b> Part Name: <b>Stock</b> Oper. No.: Dept. No.: <b>71</b> Est. Comp. Mo/Yr: Est. Comp. Hours:
--	--

Assigned By:	Date:	Est. Savings:
--------------	-------	---------------

Report Date	Elapsed Hrs.	Accomplishments
9/15/66		Process to be compiled and request tooling.
10/15/66		M/dwg. being altered (method of fastening tip).
11/15/66		Tool design 75% complete.
12/15/66		Tool design complete. Tooling being made.
1/15/67		Tooling approximately 50% complete.
2/15/67		Tooling approximately 75% complete.
3/15/67		Tooling approx. 90% complete. Trial lot to be first part of April.
4/15/67		Trial lot being run.
5/15/67		Production ready for sand oper.
6/15/67		M/Dwg. Barrel dia. change. Tool Design changes requested.
7/15/67		New Barrel former being made. - -
9/15/67		Present Mag. Barrel to be run until new shape barrel is available.
10/15/67		Investigating misalignment of Barrel and Receiver inletting.
12/15/67		Front of Receiver inletting not concentric.
2/15/68	8	Stocks being run on Richardson G-16 Inletter. Receiver inletting O.K.

RD - 6566 2/1/63



## PROCESS ENGINEERING ASSIGNMENTS

*It Hues*

Job Description:  Oper. - Inlet top of Stock  Char. - Set-up on Richardson G-16 Inletter		Area Engineer: Nielsen	
		Sheet No.: 1	Job No.: 3689-N1
		Job Priority: A-3	
		Job Code: 1	
		Model: 660	
		Part Name: Stock	
		Oper. No.:	
		Dept. No.: 71	
		Est. Comp. Mo/Yr:	
		Est. Comp. Hours:	
Assigned By:		Date:	Est. Savings:
Report Date	Elapsed Hrs.	Accomplishments	
1/15/68		Tooling received from Richardson. To be set up week of 1/21/68.	
2/15/68		First production run completed.	

RD - 6566 2/1/63



## PROCESS ENGINEERING ASSIGNMENTS

Job Description: Oper. - Inlet Top of Stock Char. - Set up to run on G-16 Inletter		Area Engineer: Clements	
		Sheet No.: 1	Job No.: 3696-C1
		Job Priority: A-3	
		Job Code: 1	
		Model: 660	
		Part Name: Stock	
		Oper. No.:	
		Dept. No.: 71	
		Est. Comp. Mo/Yr:	
		Est. Comp. Hours:	
Assigned By:		Date:	Est. Savings:
Report Date	Elapsed Hrs.	Accomplishments	
1/17/68		Corrected Process Records. Established cutter presets. Started set up of new tooling.	
2/18/68		Tooling tried out and Production run. Some minor alterations are required. TDR's to be issued for M/600 Barrel Groove, so that all old M/600 inletting equipment may be obsoleted.	
3/18/68		Alterations to butt locators to be completed.	
4/18/68		No change.	
5/17/68		Alterations to butt locators have been completed. Cams and tooling for small Barrel groove is on order.	
6/18/68		No change.	
7/17/68		No change.	
9/18/68		Tooling for small Barrel Groove to be completed this month.	
10/23/68		Tooling received and ready for try-out.	
11/18/68		No change.	

RD - 6566 2/1/63



PROCESS ENGINEERING ASSIGNMENTS			
<b>Job Description:</b>  <b>Oper. - Drill Grip Cap Screw Holes</b>  <b>Char. - Alter clamping to improve quality</b>		<b>Area Engineer:</b> Nielsen	
		<b>Sheet No.:</b> 1 <b>Job No.:</b> 3724-N1	
		<b>Job Priority:</b> A3	
		<b>Job Code:</b> 1	
		<b>Model:</b> 660	
		<b>Part Name:</b> Stock	
		<b>Oper. No.:</b> Drill Grip Cap Screw Holes	
		<b>Dept. No.:</b> 71	
		<b>Est. Comp. Mo/Yr:</b>	
<b>Assigned By:</b>		<b>Date:</b>	<b>Est. Savings:</b>
<b>Report Date</b>	<b>Elapsed Hrs.</b>	<b>Accomplishments</b>	
2/15/68		Request for clamp design change. Tooling being altered.	
3/15/68		New clamp complete - appears O.K.	
4/15/68		<u>COMPLETE</u>	

RD - 6566 2/1/63



PROCESS ENGINEERING ASSIGNMENTS		
<b>Job Description:</b>  <b>Oper. - Drill Butt Plate and Front Locating Holes</b>  <b>Char. - Change from hand oper. to Richardson G. I. Machine.</b>		Area Engineer: Nielser.
		Sheet No.: 1      Job No.: 3728-X1
		Job Priority: A3
		Job Code: 1
		Model: 660
		Part Name: Stock - Laminated
		Oper. No.: Drill B/P
		Dept. No.: Holes etc. 71
		Est. Comp. Mo/Yr:
		Est. Comp. Hours:
Assigned By:		Date:
Est. Savings:		
Report Date	Elapsed Hrs.	Accomplishments
2/15/68		Approx. 24 Stocks run through new process. Trial run to be made in March.
3/15/68		No change.
4/15/68		<u>COMPLETE</u>

RD - 6566 2/1/63



n/eds - negre line



*St. Hill*

PROCESS ENGINEERING ASSIGNMENTS

Job Description:  M/660  Sight Line  6mm 243 Cal.		Area Engineer: Tibbitts			
		Sheet No.: 1	Job No.: 3685-T2		
		Job Priority: D			
		Job Code: 6			
		Model: 660			
		Part Name: Final Assem.			
		Oper. No.:			
		Dept. No.: 61			
		Est. Comp. Mo/Yr:			
		Est. Comp. Hours:			
Assigned By:		Date:		Est. Savings:	
Report Date	Elapsed Hrs.	Accomplishments			
1/15/68		M/660 - 6mm & 243 Cal. guns shoot 10" to 14" high with highest front sight and lowest rear sight combination.			
2/19/68		<p>Upon investigation it was found that with .030 additional height on front sight largest percentage of guns hit point of aim. It was decided to provide .030 nylon spacers to raise front sight ramp.</p> <p>Spacers to be used on calibers were necessary until higher sights are available.</p> <p>Close out.</p> <p><u>COMPLETE</u></p>			

RD - 6566 2/1/63



PROCESS ENGINEERING ASSIGNMENTS

Job Description:  M/660 Sight Line		Area Engineer: <span style="float: right;">T. H. Hines</span>																						
		Sheet No.: 1	Job No.: 0128-72																					
		Job Priority: 2																						
		Job Code: 6																						
		Model: 600																						
		Part Name: Final Assem.																						
		Oper. No.:																						
		Dept. No.: 61																						
		Est. Comp. Mo/Yr:																						
		Est. Comp. Hours:																						
Assigned By:		Date: 1/26/68	Est. Savings:																					
Report Date	Elapsed Hrs.	Accomplishments																						
2/19/68		M/660 Sight Line at present is as follows;  <table border="0"> <tr> <td><u>Cal.</u></td> <td><u>.030 Spacer</u></td> <td><u>Sight</u></td> </tr> <tr> <td>350</td> <td>No</td> <td>Low</td> </tr> <tr> <td>6.5</td> <td>Yes</td> <td>Hi</td> </tr> <tr> <td>222</td> <td>No</td> <td>Hi</td> </tr> <tr> <td>243</td> <td>No</td> <td>Hi</td> </tr> <tr> <td>6mm</td> <td>Yes</td> <td>Hi</td> </tr> <tr> <td>308</td> <td>No</td> <td>Low</td> </tr> </table>		<u>Cal.</u>	<u>.030 Spacer</u>	<u>Sight</u>	350	No	Low	6.5	Yes	Hi	222	No	Hi	243	No	Hi	6mm	Yes	Hi	308	No	Low
<u>Cal.</u>	<u>.030 Spacer</u>	<u>Sight</u>																						
350	No	Low																						
6.5	Yes	Hi																						
222	No	Hi																						
243	No	Hi																						
6mm	Yes	Hi																						
308	No	Low																						

RD - 6566 2/1/63



660 - Trigger Adj.



PROCESS ENGINEERING ASSIGNMENTS		
Job Description:		Area Engineer: Webb
		Sheet No.: 1      Job No.: 3804-W2
		Job Priority: D
		Job Code: 6
		Model: 660
		Part Name:
		Oper. No.:
		Dept. No.:
		Est. Comp. Mo/Yr:
		Est. Comp. Hours:
Assigned By:		Date:
Est. Savings:		
Report Date	Elapsed Hrs.	Accomplishments
5/20/68	3	<p>Trouble with Trigger holes not being in line in the Trigger housing punch to square the Housing.</p> <p>Also some of the trouble is burrs from the thread and also some of the Triggers have small holes and some of the hole is not straight. Punch was O.K. before heat treat but now is too small. Tried using it by grinding angle on the bottom. Also grinding the end so we didn't hit in the bottom, none seemed to work - a new punch will have to be made. Before we did we ground the present punch so it would adjust the top of the part. Worked very well and have processed several hundred parts this way. They have been colored, we now have between 250 and 300 parts that we adjusted before any holes were reamed or tapped, to see if this is an easier way. Parts are completed. Tried Triggers in several parts. Some assemblies needed a slight adjustment. Made a new punch - added necessary "S" operations to process to repair approx. 13,000 parts. Operations not being used. Don't seem to get a good enough percent of good parts. Cancelled "S" operations and added an operation to assemble the Trigger to the housing and adjust the top rear holes and make sure the Trigger is free. Moved some Extractor rivet holes in the Bolt.</p>
5/31/68	4	
5/23/68	5	
5/24/68	7	
5/27/68	2	
5/28/68	8	
5/29/68	2	
5/31/68	2	
6/3/68	4	
6/4/68	2	
6/5/68	4	
6/6/68	3	
6/7/68	5	
6/11/68	8	
6/12/68	2	
6/13/68	5	

RD - 6566 2/1/63



PROCESS ENGINEERING ASSIGNMENTS		
Job Description:		Area Engineer: Webb
		Sheet No.: 1      Job No.: 3804-W2
		Job Priority: D
		Job Code: 6
		Model: 660
		Part Name:
		Oper. No.:
		Dept. No.:
		Est. Comp. Mo/Yr:
		Est. Comp. Hours:
Assigned By:		Date:
Est. Savings:		
Report Date	Elapsed Hrs.	Accomplishments
5/20/68	3	<p>Trouble with Trigger holes not being in line in the Trigger housing punch to square the Housing.</p> <p>Also some of the trouble is burrs from the thread and also some of the Triggers have small holes and some of the hole is not straight. Punch was O.K. before heat treat but now is too small. Tried using it by grinding angle on the bottom. Also grinding the end so we didn't hit in the bottom, none seemed to work - a new punch will have to be made. Before we did we ground the present punch so it would adjust the top of the part. Worked very well and have processed several hundred parts this way. They have been colored, we now have between 250 and 300 parts that we adjusted before any holes were reamed or tapped, to see if this is an easier way. Parts are completed.</p> <p>Tried Triggers in several parts. Some assemblies needed a slight adjustment. Made a new punch - added necessary "S" operations to process to repair approx. 13,000 parts. Operations not being used. Don't seem to get a good enough percent of good parts. Cancelled "S" operations and added an operation to assemble the Trigger to the housing and adjust the top rear holes and make sure the Trigger is free. Moved some Extractor rivet holes in the Bolt.</p> <p>Vendor to try to adjust some before reaming - latest word is that he will not be able to do any for some time - per J. Marley (6/19/68).</p> <p>Made a new set up with a 3 inch vise - had block made to try to straighten with heat. New parts from vendor. Parts that he was supposed to correct; had new parts checked in Tool Room and it showed that the holes are still out of line. Ran ten parts but it verified the Tool Room check.</p> <p>Parts are not much better than the previous lot.</p>
5/31/68	4	
5/23/68	5	
5/24/68	7	
5/27/68	2	
5/28/68	8	
5/29/68	2	
5/31/68	2	
6/3/68	4	
6/4/68	2	
6/5/68	4	
6/6/68	3	
6/7/68	5	
6/11/68	8	
6/12/68	2	
6/13/68	5	
6/19/68	4	
6/20/68	5	
6/24/68	4	
7/8/68	3	
7/9/68	2	
7/10/68	4	
7/15/68	1	

RD - 6566 2/1/63



118 Hine

PROCESS ENGINEERING ASSIGNMENTS		
<b>Job Description:</b>  M/660  Trigger Adjustment		<b>Area Engineer:</b> Tibbitts <b>Sheer No :</b> 1 <b>Job No.:</b> 3774-T2 <b>Job Priority:</b> 0 <b>Job Code:</b> 17 <b>Model:</b> 660 <b>Part Name:</b> Final Assem. <b>Oper. No.:</b> <b>Dept. No.:</b> 61 <b>Est. Comp. Mo/Yr:</b> <b>Est. Comp. Hours:</b>
<b>Assigned By:</b>		<b>Date:</b> 3/13/68
<b>Est. Savings:</b>		
Report Date	Elapsed Hrs.	Accomplishments
4/17/68		100 guns were assembled with weight screws and springs provided by R. Kelly, to determine if there would be any improvement in Trigger pull or Follow Down problem. All guns passed test with no rejects for Follow Down. Extended tests for jar off and trigger adjustment were also taken on 20 guns.

RD - 6566 2/1/63



H/660 - quality



CC: W. A. Best N. S. Thompson  
 L. J. Boyle W. J. Scott  
E. R. Carr C. P. Prosser  
 L. Fox  
 G. E. Puckett File

**WAREHOUSE AUDIT REPORT  
 (QUALITY AUDIT RETEST)**

DATE 3/15/69

MODEL 560 ITEM Front Trigger Adjusting Screw ~~XXX~~/CAL. ALL

REASON FOR RETEST (Defect Description) Follows Down

(No Trigger Adjusting Screw Spring tension on Trigger; Poor staking)

DATE OBSERVED IN AUDIT 3/20/69 DATE OF WHSE. AUDIT 2/20/69 PROD. PERIOD 3/12/69  
 AUDITED to 3/20 INC.

PROD. DATE	QUAN. PROD.	QUAN. OBSERVED IN WHSE.	QUAN. SAMPLE	O. K.	DEF.	REMARKS
3/12/69	98		9			1 - Stock split
3/13	108		6			1 - Stock split; poor stake 1
3/14	88		16			poor stake 2
3/17	116		13			poor stake 1
3/19	70		2			
3/20	20		4			
<b>TOTALS</b>	500		50			

Quality Control Department  
 N. W. Menard, Supervisor

by C. C. Untz Date 3/31/69

NWM/bd  
 12/8/67



RD-6561

CC: W. A. Best N. W. Menard  
L. J. Boyle G. E. Puckett  
R. J. Chesebrough W. T. Scanlon  
G. E. Fletcher J. L. Snyder  
L. Fox N. S. Thompson  
~~W. A. Best~~  
**ERCAF**  
J. A. Henry

Process Engineer's Report on QUALITY AUDIT  
MAJOR DEFECTS or WAREHOUSE AUDIT DEFECTS

Quality Audit Major Defect \_\_\_\_\_

Warehouse Audit Major Defect \_\_\_\_\_

Warehouse Audit Number \_\_\_\_\_

Model 660 Gun Number \_\_\_\_\_ Cal. & Gr. 308

Date of Audit 2-7-69 Auditor's Name URTZ

Type & Frequency  
of Malfunction FOLLOWS DOWN AFTER FIRST ROUND.

Cause of Malfunction CONNECTOR BINDING ON TRIGGER.

Results of Retest after Corrective Action \_\_\_\_\_

Action Taken to Correct Current Production DISCUSSED WITH ASSEMBLY  
FOREMAN. HE HAS INSTRUCTED SUB ASSEMBLERS TO  
CHECK FOR CONNECTOR BINDING ON TRIGGER.

Action Taken to Correct Future Production \_\_\_\_\_

Comments \_\_\_\_\_

Engineer's Name C. Prover 2/10/69



PROCESS ENGINEERING ASSIGNMENTS		
Job Description:  Bolt Over-rides Last Shell in Mag.  6.5mm 350 Rem.		Area Engineer: Tibbitts
		Sheet No.: 1      Job No.: 3704-T2
		Job Priority: D
		Job Code: 6
		Model: 660
		Part Name: Final Assem.
		Oper. No.:
		Dept. No.: 61
		Est. Comp. Mo/Yr:
		Est. Comp. Hours:
Assigned By:		Date: 2/16/68
Est. Savings:		
Report Date	Elapsed Hrs.	Accomplishments
2/19/68		<p>Upon investigation of Bolt Over-ride, last Shell out of Mag., it was found that Bolts in rejected guns have a slight protrusion in outer rim.</p> <p>This apparently caused by machine when extractor is riveted. Due to the thinner wall on Magnum Bolts the pressure of the riveting swells the shroud occasionally.</p> <p>Guns feed normally after outer rim of bolt is smoothed off.</p>

RD - 6566 2/1/63



Revised and reissued 12/14/67  
after additional audit.

CC: L. Fox  
R. P. Hurley  
N. S. Thompson  
W. A. Best

L. J. Boyle  
G. E. Puckett  
W. J. Scott  
M. J. Tibbitts  
File

WAREHOUSE AUDIT REPORT  
(QUALITY ADULT RETEST)

DATE 12/7/67

MODEL 660 GAUGE OR CAL. 308

REASON FOR RETEST One of two samples stems feed ramp. One of two ramp  
cuts missing.

RETEST DATE <u>12/7/67</u>		SAMPLE SIZE <u>10</u>		PRODUCTION DURING PERIOD <u>11/28 - 12/7/67</u>	
QUAN. 12/7		12/14		PRODUCTION ON HAND	
OBS. FIRST		SECOND			
PROD. QUAN. <u>XXXX</u>	WHSE. <u>XXXX</u>	PROD. QUAN. <u>XXXX</u>	WHSE. <u>XXXX</u>		
DATE	PROD. <u>XXXX</u>	SAMP. <u>XXXX</u>	SAMP. <u>XXXX</u>	<u>RESULTS OBSERVED</u>	
11/28	133	133	3	-	all samples O. K.
11/29	164	164	-	-	
11/30	190	190	1	-	
12/1	20	20	-	2	
12/4	50	50	-	2	
12/5	124	124	-	6	
12/6	20	20	3	-	
12/7	<u>128</u>	<u>128</u>	<u>3</u>	<u>=</u>	
	829	829	10	10*	

ACTION TAKEN

\*REMARKS: Second sample also audited for checked stock. All items  
were satisfactory.

QUALITY CONTROL DEPARTMENT  
N. W. Menard, Supervisor

By W. T. Scanlon

NAI/xx bd  
6-25-17



CC: L. Fox  
R. B. Hurley  
N. S. Thompson  
W. A. Best

L. J. Boyle  
G. E. Puckett  
W. J. Scott  
M. J. Tibbitts  
File

WAREHOUSE AUDIT REPORT  
(QUALITY ADUIT RETEST)

DATE 12-7-67

MODEL 660 GAUGE OR CAL. 308

REASON FOR RETEST One of two samples stems feed ramp. One of two ramp  
cuts missing.

RETEST DATE 12-7-67 SAMPLE SIZE 10 PRODUCTION DURING PERIOD 829

QUAN.

PRODUCTION ON HAND

OBS.  
PROD. QUAN. XXXXX WHSE. XXXXX  
DATE PROD. XXXXX SAMP. XXXXX

RESULTS OBSERVED

11/28	133	15	3
11/29	164	-	-
11/30	190	1	1
12/1	20	-	-
12/4	50	-	-
12/5	124	-	-
12/6	20	20	3
12/7	<u>128</u>	<u>70</u>	<u>3</u>
	829	106	10

all samples O. K.

ACTION TAKEN

QUALITY CONTROL DEPARTMENT  
N. W. Menard, Supervisor

By W. T. Scanlon

NEM/xxbd  
6-20-67



660 - Final Answer.



## PROCESS ENGINEERING ASSIGNMENTS

Job Description:  Bolt Opens - Safe on		Area Engineer: Tibbitts	
		Sheet No.: 1	Job No.: 3807-T2
		Job Priority: D	
		Job Code: 6	
		Model: 660 - 700	
		Part Name: Final Assem.	
		Oper. No.:	
		Dept. No.: 61	
		Est. Comp. Mo/Yr:	
Est. Comp. Hours:			
Assigned By:		Date:	Est. Savings:
Report Date	Elapsed Hrs.	Accomplishments	
6/17/68		Upon investigation of Bolt Handle lifts with Safe it was found that safety clearance cut was out of position radially up to .025. With this condition it is not possible for safe arm to move to its proper position to lock Bolt Handle down. This condition was found to exist on about 90% of M/660 Bolts at Assembly and 25% of M/700. To repair Bolts it was found necessary to file Bolt handles to obtain required clearance for safe arm. L. Chizzonite notified.	
7/17/68		Contacted J. Burns.  Machine studies have been taken and at present time operation is uncontrollable. New "V" Blocks on order.	
9/17/68		Contacted J. Burns. Operation still not controllable. Cocking notch fixture to be sent to Tool Room to be checked.	
10/17/68		Fixture and gages have been checked and were found to be O.K. Investigating possibility of faulty location of part when loading machine. Assemblers still have problem with Bolt Handle lifts with Safe in "on" position.	
11/18/68		A special lot of M/660 Bolt Handles have been processed which would allow Bolt to revolve radially .008 more than regular run of Bolts. With these handles it was thought that there would be .008 additional clearance for safe arm between Receiver and safety clearance cut in Bolt.	
11/13/68		All 100 Bolts with special handles were assembled to guns. From the 100 guns assembled it was necessary to file 32 handles in order to move safe to "on" position. Another lot of Bolts is to be processed which will be milled with special cutter. With these handles it should provide an additional .007 for a total of .015, more clear. between Bolt & Receiver.	

RD - 6566 2/1/63



PROCESS ENGINEERING ASSIGNMENTS		
Job Description:  M/660  Investigate Quality Audit Reject Trigger Pull varies		Area Engineer: Tibbitts
		Sheet No.: 1      Job No.: 3808-T2
		Job Priority: D
		Job Code: 6
		Model: 660
		Part Name: Final Assem.
		Oper. No.:
		Dept. No.: 61
		Est. Comp. Mo/Yr:
		Est. Comp. Hours:
Assigned By:		Date:
Est. Savings:		
Report Date	Elapsed Hrs.	Accomplishments
6/17/68		Upon investigation of Trigger pull varies, several factors were found to be present: 1. Trigger retaining pin hole oversize. 2. Housing retaining pin holes oversize. 3. Housings not filed to sample causing bind on Trigger. 4. Burrs on Trigger at retaining pin hole. 5. Trigger pin holes and housing retaining pin holes out of alignment causing Trigger to bind on side of housing and also hit Trigger Guard.  All housings were screened for oversize holes. All acceptable housings were returned to Dept. 75 to be filed to sample. Triggers were also returned to Dept. 75 for removal of burrs.  A. Webb was contacted and process has been written for straightening housings which are now in plant.  J. Marley contacted and informed vendor as to holes out of alignment on parts as received.
7/17/68		No change.

RD - 6566 2/1/63



PROCESS ENGINEERING ASSIGNMENTS																							
Job Description:  M/660 Sight Line		Area Engineer: Tibbitts																					
		Sheet No.: 1      Job No.: 3128-T2																					
		Job Priority: 0																					
		Job Code: 6																					
		Model: 660																					
		Part Name: Final Assem.																					
		Oper. No.:																					
		Depr. No.: 61																					
		Est. Comp. Mo/Yr:																					
		Est. Comp. Hours:																					
Assigned By:		Date: 1/26/68																					
Est. Savings:		9																					
Report Date	Elapsed Hrs.	Accomplishments																					
2/19/68		<p>M/660 Sight Line at present is as follows;</p> <table border="1"> <thead> <tr> <th>Cal.</th> <th>.030 Spacer</th> <th>Sight</th> </tr> </thead> <tbody> <tr> <td>350</td> <td>No</td> <td>Low</td> </tr> <tr> <td>6.5</td> <td>Yes</td> <td>Hi</td> </tr> <tr> <td>222</td> <td>No</td> <td>Hi</td> </tr> <tr> <td>243</td> <td>No</td> <td>Hi</td> </tr> <tr> <td>6mm</td> <td>Yes</td> <td>Hi</td> </tr> <tr> <td>308</td> <td>No</td> <td>Low</td> </tr> </tbody> </table>	Cal.	.030 Spacer	Sight	350	No	Low	6.5	Yes	Hi	222	No	Hi	243	No	Hi	6mm	Yes	Hi	308	No	Low
Cal.	.030 Spacer	Sight																					
350	No	Low																					
6.5	Yes	Hi																					
222	No	Hi																					
243	No	Hi																					
6mm	Yes	Hi																					
308	No	Low																					
3/18/68		<p>Spacer has been discontinued in favor of new .460 Front Sight now in production.</p>																					
4/17/68		<p>All calibers within specs. with new sight.</p> <p>Close out.</p> <p><u>COMPLETE</u></p>																					

RD - 6566 2/1/63



## PROCESS ENGINEERING ASSIGNMENTS

Job Description:  M/660  .243, 6mm, Sight Line		Area Engineer: Tiboitts	
		Sheet No.: 1	Job No.: 3740-T2
		Job Priority: A-3	
		Job Code: 1	
		Model: 660	
		Part Name: Final Assem.	
		Oper. No.:	
		Dept. No.: 61	
		Est. Comp. Mo/Yr:	
		Est. Comp. Hours:	
Assigned By:		Date:	Est. Savings:
Report Date	Elapsed Hrs.	Accomplishments	
3/18/68		Ten guns were assembled with new Front Sights with overall height of .460.  Guns were shot from shoulder by L. Evans and were satisfactory on point of aim. Assemblers were notified to discontinue use of .030 spacer.	
4/17/68		.243 - 6mm Calibers O.K. on point of aim. Close out.  <u>COMPLETE</u>	

RD - 6566 2/1/63



# PROCESS ENGINEERING ASSIGNMENTS

<b>Job Description:</b>  M/660  Trigger Adjustment		Area Engineer: Tibbitts	
		Sheet No.: 1 of 2 1	Job No.: 3774-T2
		Job Priority: D	
		Job Code: 17	
		Model: 660	
		Part Name: Final Assem.	
		Oper. No.:	
		Dept. No.: 61	
		Est. Comp. Mo/Yr:	
		Est. Comp. Hours:	
Assigned By:		Date: 3/18/68	Est. Savings:
Report Date	Elapsed Hrs.	Accomplishments	
4/17/68		100 guns were assembled with weight screws and springs provided by R. Kelly, to determine if there would be any improvement in Trigger pull or Follow Down problem. All guns passed test with no rejects for Follow Down. Extended tests for jar off and trigger adjustment were also taken on 20 guns.	
5/15/68		Model drawing has been changed to incorporate new springs and screws.	
6/17/68		Assemblers still having difficulty getting correct Trigger pull. This due primarily to misalignment of holes in Trigger housing. Holes in Triggers are also out of alignment. Triggers are now being screened with approx. 2/3 not meeting alignment gage. Operation has been set up at assembly for straightening and retapping housings.	
7/17/68		Operations have been set up at Final Assembly to adjust Trigger Housing so that Trigger will be more square in Receiver and also will not bind in Housing causing heavy pull. It was found necessary to retap Trigger Stop screw to misalignment of hole. Vendor has been contacted as to misalignment of holes in housing when received.	
9/17/68		It was also noted that in most guns where Trigger was hitting Trigger Guard, the hole in Trigger was also not square causing additional aggravation of the problem. F. Barry notified and all Triggers were screened. Fixture was also sent to Tool Room for repair.	
		On a recent check of Triggers, holes still did not meet alignment gage. A new shipment of housings have been received and processed. Trigger Pin Hole and housing have	

RD - 6566 2/1/63



# PROCESS ENGINEERING ASSIGNMENTS

<b>Job Description:</b>  <b>M/660</b> <b>Trigger Adjustment</b>		<b>Area Engineer:</b> Tibbitts	
		Sheet No. 2 of 2	Job No.: 3774-T2
		<b>Job Priority:</b> D	
		<b>Job Code:</b> 17	
		<b>Model:</b> 660	
		<b>Part Name:</b> Final Assem.	
		<b>Oper. No.:</b>	
		<b>Dept. No.:</b> 61	
		<b>Est. Comp. Mo/Yr:</b>	
		<b>Est. Comp. Hours:</b>	
<b>Assigned By:</b>		<b>Date:</b> 3-18-68	<b>Est. Savings:</b>
<b>Report Date</b>	<b>Elapsed Hrs.</b>	<b>Accomplishments</b>	
9/17/68		Been received and processed. Trigger Pin Hole and Housing retaining pin holes are still not square with housing. B. Bosquet was notified and agreed straightening operation would be necessary at present.	

RD - 6566 2/1/63



PROCESS ENGINEERING ASSIGNMENTS		
Job Description:  Bolt Opens - Safe on		Area Engineer: Tibbitts
		Sheet No.: 1   Job No.: 3807-T2
		Job Priority: D
		Job Code: 6
		Model: 660 - 700
		Part Name: Final Assen.
		Oper. No.:
		Dept. No.: 61
		Est. Comp. Mo/Yr:
		Est. Comp. Hours:
Assigned By:		Date:
Est. Savings:		
Report Date	Elapsed Hrs.	Accomplishments
6/17/68		Upon investigation of Bolt Handle lifts with Safe it was found that safety clearance cut was out of position radially up to .025. With this condition it is not possible for safe arm to move to its proper position to lock Bolt Handle down. This condition was found to exist on about 90% of M/660 Bolts at Assembly and 25% of M/700. To repair Bolts it was found necessary to file Bolt handles to obtain required clearance for safe arm. L. Chiszonite notified.
7/17/68		Contacted J. Barnes.  Machine studies have been taken and at present time operation is uncontrollable. New "V" Blocks on order.
9/17/68		Contacted J. Barnes. Operation still not controllable. Cocking notch fixture to be sent to Tool Room to be checked.

RD - 6566 2/1/63



# PROCESS ENGINEERING ASSIGNMENTS

<b>Job Description:</b>  <b>M/660</b>  <b>Investigate Quality Audit Reject</b> <b>Trigger Pull varies</b>		<b>Area Engineer:</b> Tibbitts	
		<b>Sheet No.:</b> 1	<b>Job No.:</b> 3808-T2
		<b>Job Priority:</b> D	
		<b>Job Code:</b> 6	
		<b>Model:</b> 660	
		<b>Part Name:</b> Final Assem.	
		<b>Oper. No.:</b>	
		<b>Dept. No.:</b> 61	
		<b>Est. Comp. Mo/Yr:</b>	
		<b>Est. Comp. Hours:</b>	
<b>Assigned By:</b>		<b>Date:</b>	<b>Est. Savings:</b>
<b>Report Date</b>	<b>Elapsed Hrs.</b>	<b>Accomplishments</b>	
6/17/68		<p>Upon investigation of Trigger pull varies, several factors were found to be present:</p> <ol style="list-style-type: none"> <li>1. Trigger retaining pin hole oversize.</li> <li>2. Housing retaining pin holes oversize.</li> <li>3. Housings not filed to sample causing bind on Trigger.</li> <li>4. Burrs on Trigger at retaining pin hole.</li> <li>5. Trigger pin holes and housing retaining pin holes out of alignment causing Trigger to bind on side of housing and also hit Trigger Guard.</li> </ol> <p>All housings were screened for oversize holes. All acceptable housings were returned to Dept. 75 to be filed to sample. Triggers were also returned to Dept. 75 for removal of burrs.</p> <p>A. Webb was contacted and process has been written for straightening housings which are now in plant.</p> <p>J. Marley contacted and informed vendor as to holes out of alignment on parts as received.</p> <p>No change.</p>	
7/17/68			
9/17/68		<p>New lot of housings have been received, which were supposed to have improvements incorporated by vendor. A trial lot of 100 housings were processed and assembled. There was no improvement over regular current production. Trigger Pin hole and housing retaining pin holes still not square with housing.</p>	

RD - 6566 2/1/63



PROCESS ENGINEERING ASSIGNMENTS			
<b>Job Description:</b>  M/660 243 Cal. High Reject Rate  Point of Impact		<b>Area Engineer:</b> Tibbitts	
		<b>Sheet No.:</b> 1 <b>Job No.:</b> 3811-T2	
		<b>Job Priority:</b> D	
		<b>Job Code:</b> 6	
		<b>Model:</b> 660	
		<b>Part Name:</b> Final Assem.	
		<b>Oper. No.:</b>	
		<b>Dept. No.:</b> 61	
		<b>Est. Comp. Mo/Yr:</b>	
		<b>Est. Comp. Hours:</b>	
<b>Assigned By:</b>		<b>Date:</b>	<b>Est. Savings:</b>
<b>Report Date</b>	<b>Elapsed Hrs.</b>	<b>Accomplishments</b>	
6/17/68		Seventeen target rejects were stripped and angularity straightened as near as possible to "0".  On retest sixteen were within specs. One gun shot 7" high with No. 3 step.  Report to N. Thompson, H. Payne. Close out.  <u>COMPLETE</u>	
7/17/68			

RD - 6566 2/1/63



Mohawk 600



REVISED 5-12-70 11-24-70

## REMINGTON STANDARDS - ARMS

SHEET 1 of 7

MODEL	MOHAWK	308 Win.	6MM Rem.	222 Rem.	243 Win.
	600				
<b>ACCURACY</b>					
Range	100 yards				
Point of Aim	6 o'clock on target				
Center of Impact	Not more than 2 inches below or 4 inches above or 3 inches either side of point of aim.				
Group Size (E. S.)	5 shots in:	3.8	2.7	2.7	2.7
Ammunition		180 gr. PSP.	100 gr. PSP	50 gr. PSP	100 gr. PSP.
<b>ACTION</b>					
Bolt action, hand operated. Removable bolt. Solid frame with takedown stock. Bolt cocks as handle is raised. Rifle cocks as bolt handle is lowered to lock action closed. Extracts and ejects as bolt is "opened". Direct action trigger. 2 stop safety - Forward to FIRE position - rearward to ON SAFE stop position.					
Action must feed, fire, extract and eject (include extraction and ejection without firing) satisfactorily with all varieties of ammunition listed as standard (for tabulated calibers) in Technical Committee Manual of the Sporting Arms and Ammunition Manufacturers' Institute (SAAMI).					
<b>ANNOUNCEMENT</b>					
Jan 1971					
Warehouse Date					
<b>DISCONTINUED</b>					
* Magnum Calibers Deleted Per F. E. Morgan. See Letter V. G. DeReus to A. D. Kerr 10-30-70					



Remington specification







ILION RESEARCH DIVISION JFF:bmg  
REMINGTON STANDARDS - ARMS

REVISED 5-12-70 11-24-70

SHEET 4 of 7

MOHAWK		308 Win.	6MM RE.m.	222 Rem.	243. Win.			
MODEL	600							
MARKINGS	All marking visible unless specified otherwise.							
Barrel	Dwg. C- 90382							
Assembly	Left rear							
Caliber	Left rear							
Code (Mfg. Date)	Left rear							
Patent Numbers	Below Remington name (if any)							
Proof (REP)	Right rear							
Test	Right rear							
Other:								
Magnaflux	Right rear (to rear of (REP) marking).							
Receiver	Dwg. C- 90382							
Grade	None							
Model	Left center							
Serial Number	Left front							
Safety Marks	Marks "S" and "F" on receiver adjacent to respective SAFE and FIRE stop positions on safety.							
Bolt								
Magnaflux	Right lug (center)							
Bolt head braze	Left lug (center)							
Bolt handle braze	Rear handle (center)							
Proof	Bottom handle (center) Prick Punch.							
Serial No.	Bottom - last - four (4) numbers only							
METAL FINISH	Black color, medium lustre on all exposed parts except as otherwise tabulated.							
PATENT NUMBERS	NONE							

LIMITED DISTRIBUTION



ILION RESEARCH DIVISION JFF:bmj  
REMINGTON STANDARDS - ARMS

REVISED 7 - 23 - 73 11-24-70

SHEET 5 of 7

MODEL	MOHAWK 600	308 Win.	6MM Rem.	222 Rem.	243 Win.			
PACKAGING	Full length.	Exposed metal	parts coated with rust preventive.	Bolt packaged out of rifle.				
Accessories								
Literature	Instruction Folder - RD							
Single Shipper	Single piece corrugated sheet; Added fillers for rifle support. Marbleized color with red and black artwork. Lid taped to close.							
Multiple Shipper	Sleeve or full carton of corrugated material.							
Label	Model, serial number, caliber, packers code on label.							
Markings	Name and address of addressee, with copy of shipping ticket, return address.							
Shipping Weight								
1 Gun	8 lbs.							
2 Guns	18 lbs.							
3 Guns	26 lbs.							
5 Guns	43 lbs.							
Export	Same as domestic except: Legal or actual weight on label.							
PROOF TEST (REP)	Fire one (1) standard proof cartridge in each gun. For location of marking (REP) see MARKINGS - Barrel. For bolt proof - see Markins - Bolt.							
RECEIVER	Cylindrical alloy steel, black color, medium lustre. Screw fitted to barrel and barrel bracket (solid frame.)							
Sighting	Drilled and tapped (5 holes) for receiver sight and telescope mount. Fitted with receiver plug screws.							
Gas Escape	One (1) hole - right side.							
Length	Standard							
Markings	See MARKINGS - Receiver.							
(1) RIB (and Spacer)	Supports rear sight. Striated on top surface. Attached to barrel with two (2) rear sight screws. Material Nylon (Rib) Metal (Spacer) Color - Black							
(1) Added : Ref. Design change 7-9-73.								

RD-6489

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER  
KINZER V. REMINGTON

R2528196



ILION RESEARCH DIVISION JFF:bmg  
REMINGTON STANDARDS - ARMS

REVISED 4-13-73 7-23-73

SHEET 6 of 7

[illegible]

RD-6489

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER

R2528197







BOORUM & PEASE "NGIEAR" ®

BOORUM & PEAS

600



7-1-65

**REMINGTON STANDARDS - ARMS**

SHEET 1

[illegible]

**CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER**

R2528200



223 Rem.  
(Export only)

<b>BARREL</b>	Round tapered to breech and crowned at muzzle. Black color, medium lustre. Remington specification alloy steel. Steel barrel studs (6) for rib and sight attachment.					
Bedding	No requirement.					
Barrel Bracket	Elevated type.					
Length (Nominal)	18 1/2"					
Diameter (O.D.)	Regular size.					
Bore (in.)		.300 min. .302 max.	.237 min. .238 max.	.219 min. .220 max.	.237 min. .238 max.	.219 min. .220 max.
Groove (in.) (6)		.308 min. .310 max.	.243 min. .244 max.	.2240 min. .2250 max.	.243 min. .244 max.	.224 min. .225 max.
Twist (R.H.) 1 Turn in		10 inches	9 inches	14 inches	9 inches	12 inches
Markings	See MARKINGS - Barrel					
<b>BARREL RIB</b>	Black Delrin. Ventilated type attached to barrel studs with screws. Matted between sight positions.					
<b>BOLT (Final Assembly)</b>	Includes Bolt Assembly, Firing Pin Assembly.					
Bolt Body	Bright steel					
Bolt Plug	Black color.					
Bolt Handle	Bright steel color. Forward "S" shape with oval "half ball". Serrated on bottom of half ball.					
Firing Pin Head	Black color.					
Markings	Serial number on bottom of bolt. See MARKINGS - Bolt.					
Export	Use "shrouded" bolt plug - special design.					
<b>BOLT STOP</b>	Located in left rear of "bolt track" in receiver. Use narrow tool to push down for release.					

R2528201



7-1-65

REMINGTON STANDARDS - ARMS

3

MODEL 600

308 Win.

6MM Rem.

222 Rem.

XXXXXXXXXX

243 Win.

223 Rem.  
(Export only)

[illegible]

**CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER**

R2528202



SED 8-26-66

3-22-67

REMINGTON STANDARDS - ARMS

SHEET 4

MODEL	600	308 Win.	6MM Rem.	222 Rem.	<del>XXXXXX</del>	243 Win.	223 Rem. (Export only)
MARKINGS	All marking visible unless specified otherwise.						
Barrel	Dwg. B-15729						
Assembly	Left rear						
Remington Name	Left side						
Rem. Address	Left side						
Caliber	Left rear						
Code (Mfg. Date)	Left rear						
Patent Numbers	Below Remington name (if any)						
Proof (REP)	Right rear						
Test	Right rear						
Other:							
Magnaflux	Right rear (to rear of (REP) marking).						
Receiver	Dwg. B-15482)						
Grade	None						
Remington Script	Left center						
Model Number	Below script (Rem.)						
Serial Number	Left front						
Export:	To Australia: Mark "S" and "F" on receiver adjacent to respective SAFE and FIRE stop positions of safety.						
Bolt	(Prick-punch mark) Ref. Current practice.						
Magnaflux	Right lug (center)						
Bolt head braze	Left lug (center)						
Bolt handle braze	Rear handle (center)						
Proof	Bottom handle (center)						
METAL FINISH	Black color, medium lustre on all exposed parts except as otherwise tabulated.						
PATENT NUMBERS	None						



MODEL	600	308 Win.	6MM Rem.	222 Rem.	<del>XXXXXX</del>	243 Win.	223 Rem. (Export only)
PACKAGING	Full length.	Exposed metal parts coated with rust preventive.				Bolt in rifle.	
Accessories	Rear sight wrench supplied.						
Literature	Instruction Folder - Parts List RD 5473						
Single Shipper	Single piece corrugated sheet, integral folds for rifle support. black artwork (Deer and Bear). Lid taped to close.					Marbled color with brown and	
Multiple Shipper	Sleeve or full carton of corrugated material.						
Label	Green and white, model, serial number, caliber, packers code on label.						
Markings	Name and address of addressee, with copy of shipping ticket, return address.						
Shipping Weight							
1 Gun	8 lbs.						
2 Guns	16 lbs.						
3 Guns	23 lbs.						
5 Guns	38 lbs.						
Export	Same as domestic except: Legal or actual weight on label.						
PROOF TEST (REP)	Fire one (1) standard proof cartridge in each gun.					For location of marking (REP) see MARKINGS - Bar	
RECEIVER	Cylindrical alloy steel, black color, medium lustre. Screw fitted to barrel and barrel bracket (solid frame).						
Sighting	Drilled and tapped (5 holes) for receiver sight and telescope mount. Fitted with receiver plug screw						
Gas Escape	One (1) hole - right side.						
Length	Standard						
Markings	See MARKINGS - Receiver.						



MODEL	600	308 Win.	6MM Rem.	222 Rem.	<del>XXXXXX</del>	243 Win.	223 Rem. (Export only)
<b>SAFETY</b>		2-stop position, forward and back-thumb operated.					
Location		Right rear of receiver.					
Fire Position		Forward stop.					
Safe Position		Rear stop. (Bolt handle locks down - action closed).					
<b>SERIAL NUMBER</b>		(Start 1000 )					
Location (1)		See MARKING - Receiver.					
(2)		See MARKING - Bolt.					
<b>SLING STRAP</b>		As accessory at extra cost.					
Description:		7/8" QD type same as used on M/700. Leather material.					
<b>SIGHTS</b>		Metal material. Black color.					
Front		Fixed (no adjustment). Blade shaped ramp. Brass bead. Attached on rib to barrel studs with two (2) screws.					
Rear		Sliding adjustment for windage and elevation.					
Eye piece		Allen-head screw for elevation adjustment. "U" notch.					
Leaf		Allen-head screw for windage adjustment. Scaled markings.					
Base		Attached to barrel with two (2) screws.					
Wrench		Allen-head type. Supplied with each gun.					

**CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER**

R2528205



MODEL 600

308 Win. 6MM Rem. 222 Rem. ~~XXXXXX~~

243 Win.

223 Rem.  
(Export only)

[illegible]



g. 7-1-65

ISED 12-14-65

3-30-66

REMINGTON STANDARDS - ARMS

9011 1

MODEL 600 MAGNUM

350 Rem.  
Mag.

6.5MM  
Rem. Mag.

ACCURACY

Range

100 yds.

Point of Aim

6 o'clock on target

Center of Impact

Not more than 2 inches below or 4 inches above or 3 inches either side of point of aim.

Group Size (E.S.)

5 shots-3 1/2"

\*\*5 shots-3 1/2" \*\*\*

Ammunition

200 gr. PSP

\*\*\*\*120 gr.

ACTION

Bolt action, hand operated. Removable bolt. Solid frame with takedown stock. Bolt cocks as handle is raised. Rifle cocks as bolt handle is lowered to lock action closed. Extracts and ejects as bolt is "opened". Direct action trigger. 2 stop safety - Forward to FIRE position - rearward to ON SAFE stop position.

Action must feed, fire, extract and eject (include extraction and ejection without firing) satisfactorily with all varieties of ammunition listed as standard (for tabulated calibers) in Technical Committee Manual of the Sporting Arms and Ammunition Manufacturers' Institute (SAAMI)

ANNOUNCEMENT

Jan.

1965

1966 \*

June

Added per Operations Committee Min. #6 1966 dated 3-9-66

Ref.: Per Operations Committee Min. #6 1966 dated 3-9-66 (was 2 1/2").

Genl. Mgt. approved release to Production of 6.5MM Rem. Mag. June 8, 1965.

12-14-65 (Verbal)



RECEIVED  
JUN 31 1966  
CURRENT PRODUCTS  
Purdue Engineering

AL 0014337



REMINGTON STANDARDS - ARMS

SHEET 2

MODEL 600 MAGNUM

350 Rem.  
Mag.

6.5MM  
Rem.Mag.

BARREL	Round, tapered to breech and crowned at muzzle. specification alloy steel.	Steel barrel studs (6) for rib and sight attachment.	Black color, medium lustre. Remington
Bedding	No Requirement.		
Barrel Bracket		Elevated	See 350 Mag.
Length (Nominal)		18 1/2"	See 350 Mag.
Diameter (O.D.)		Magnum	See 350 Mag.
Bore (in.)		.357 Min.	.256 Min.
		.359 Max.	.257 Max.
Groove (in.) (6)		.357 Min.	.264 Min.
		.359 Max.	.265 Max.
Twist (R.H.) 1 turn in		16" (Nominal)	9" (Nominal)
Markings	See MARKINGS - Barrel		
BARREL RIB	Black Delrin. Ventilated type attached to barrel studs with screws. Matted between sight positions.		
BOLT (Final Assembly)	includes Bolt Assembly, Firing Pin Assembly.		
Bolt Body	Bright steel		
Bolt Plug	Black color		
Bolt Handle	Bright steel color. Forward "S" shape with oval "half ball".		Serrated on bottom of half ball.
Firing Pin Head	Black color		
Markings	Serial Number on bottom of bolt. See MARKINGS - Bolt.		
Export	Use "Shrouded" bolt plug - special design.		
Per W.E. Leek.			
Note: Approved from W.E. Leek, R.P. Kelly dated 3-3-66 authorizing bedding specifications.			
Division - Production & Research Division agreement of 3-7-66 per R.P. Kelly.			



PROJECT VINE  
APR 4 1966  
CURRENT P  
Pascals 2

AL 0014339



ARMS

600 MAGNUM		150	6.5MM	Rem. Mag.
7.00P	Located in left rear of "bolt neck" in receiver.			Use narrow tool to push down for release.
REAR	See RECOIL PAD			
PLUNGER	Plunger type. Saddle is bolt and is assembled in bolt head.			
PLUNGER	Riveted			
PLUNGER	Spring loaded in front of bolt head.			
PLUNGER	.045" diam. .018" thick			
PLUNGER	(Overhead)			
PLUNGER	Fixed - 500			
PLUNGER	Bright steel			



# REMINGTON STANDARDS - ARMS

SHEET 4

MODEL 600 MAGNUM

350 Rem.  
Mag.

6.5MM  
Rem. Mag.

## MARKINGS:

Barrel Dwg. No. B-15729. Same for all calibers.

Assembly Left rear

Rem. Name Left side

Rem. Address Left side

Caliber Left rear

Code (Mfg. Date) Left rear

Patent Numbers Below Remington name (if any)

Proof (REP) Right rear

Test Right rear

Other

Magnaflux Right rear (to rear of (REP) marking).

Receiver Dwg. No. B-15482

Grade None

Rem. Script Left center

Model No. Below script (Rem.)

Serial No. Left front

Other

Export to Australia: Mark "S" and "F" on receiver adjacent to respective Safe and Fire stop positions of safety.

Bolt (Prick-punch Mark) Ref: Current Practice for all calibers.

Magnaflux Right lug (center)

Bolt Head Braze Left lug (center)

Bolt Handle Braze Rear handle (center)

Proof Bottom handle (center)

PAINT FINISH Black color, medium lustre on all exposed parts except as otherwise tabulated.

PATENT NUMBERS None



7-1-65  
REV

REMINGTON STANDARDS - ARMS

SHEET 5

MODEL 600 MAGNUM

350 Rem.  
Mag.

6.5MM  
Rem. Mag.

PACKAGING	Full length.	Exposed metal parts coated with rust preventive.	Bolt in Rifle.	
Accessories	Rear sight wrench supplied. Sling strap and fittings packed separately in carton.			
Literature	Instruction Folder - Parts List, RD 5653			
Single Shipper	Single piece corrugated sheet, integral folds for rifle support. Marbleized color with brown and black artwork (Deer and Bear). Lid taped to close.			
Double Shipper	Sleeve of full carton of corrugated material.			
Color	Green & White. Model, Part No., Call No. Printed on each label.			
Addresses	Name, address of addressee. Also name of shipping agent. Return address.			
Shipping Weight:				
1 Gun	8 lbs.			
2 Guns	16 lbs.			
3 Guns	24 lbs.			
4 Guns	32 lbs.			
Support	Same as domestic except "Net" or actual weight on label.			
Cartridge (REP)	Five one (1) standard steel cartridge in each gun. For location of marking (REP) see MARKING.			
Color Pkg	Yes			
Spacers (white spacer)	Yes			
Material	Cylindrical alloy steel, black color, medium lustre. Screw fitted to barrel and barrel bracket (solid frame).			
Drilling	Drilled and tapped (5 holes) for receiver sight and telescope mount. Fitted with receiver plug screws.			
One (2) Hole - right side				
Standard				
See MARKING - Receiver				



**NEMINGTON STANDARDS - ARMS**

SHEET 6

MODEL 600 MAGNUM

350 Rem.  
Mag.

6.5MM  
Rem. Mag.

**R2528214**



MODEL 600  
Design

*Remington-Union*  
CATALOG NO. 5018 R • IF FASTENERS  
TO BE INCLUDED PLEASE SPECIFY.  
FOLD-EX FOLDER  
MADE IN U.S.A.



① ~~Mr. Fenstermaker~~  
② Leek's file

③

April 3, 1968

Mr. William C. Fenstermaker  
R.F.D. No. 1 (Mickleys)  
Allentown, Pa. 18102

Design

Dear Mr. Fenstermaker:

This is in answer to your inquiry concerning the Model 600 - 6.5 Rem. Mag. and what to do about lengthening the overall receiver to accommodate the longer loaded round.

This gun was designed to accommodate shorter cartridges, but to obtain more power they were enlarged into the magnum size. This gave us the carbine effect we were after. Naturally, space limitations prevents the magnum case from accommodating the longer load you are desiring.

Your suggestion of cutting out the barrel is not advisable. First of all you have to cut the lower section of the receiver and ramp to allow the longer load to move upwardly out of the magazine into the chamber. In doing so you would severely cut away a portion of the material supporting the lower locking lug of the bolt. I am not saying that these loads would cause any danger, but we do not advise anyone to upset the fine balance of strength in our guns.

If you are bound and determined to have a gun that accommodates the longer cartridge case you should acquire a Model 700 action which will have this feature. However, the total overall length of the gun with the same length barrel would be increased.

I hope this answers your question satisfactorily, and am most appreciative of your interest in our products.

Very truly yours,

WEL

W. E. Leek,  
Manager - Firearms Research & Design  
Ilion Research Division

WEL:T



CC: F. E. Morgan



RD-59 REV. 6-58

**REMINGTON ARMS COMPANY, INC.**

INTER-DEPARTMENTAL CORRESPONDENCE



Milwaukee, Wis.  
Aug. 8, 1967

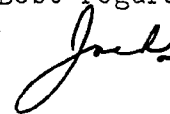
TO: WAYNE LEEK   
FROM: J. V. ELIOT, JR. 

Dear Wayne:

Thank you very much for your letter of July 31 with regard to the bolt design for the Model 660. Based on my letter to Pete Morgan, no doubt you may feel that I am hyper-critical regarding this new rifle and, frankly, such may be the case. Summing up all of the features, however, I will admit that it is indeed a very nice bolt action rifle, and should sell quite well. I would sum up my impression with one comment, and that is that I would have liked to have seen it look a bit more different than our other rifles in the line. I think this would have helped the sale, as I am sure many people buy new models only because of a new look.

You can rest assured that I am very glad that I did not try firing any of the modifications which were shown in the sporting magazines with the swept back bolt handle. I am sure that my knuckles would have been barked, too.

Best regards,



JVE:a



Thelma  
press file  
600 - 6.5  
mag

6.5 M looks

U. Dahl

1958

Bullet	Wt grs	Type	Powder Charge	Type (IR)
77		Spitzer Soft Point	55.5	4320
100		Spitzer Hollow Point	50.5	4320
100		Spitzer Hollow Point	58.5	4350
120		Spitzer Soft Point	47.1	4320
120		Spitzer Soft Point	55.0	4350
140		Spine Soft Point	53.2	4350
160		Round Nose Soft Point	51.5	4350



*File*  
*Confidential*  
*OK*

September 19, 1966

Mr. P. G. Garby  
5637 James Avenue South  
Minneapolis, Minnesota 55419

Dear Friend:

*DESIR*

It has been along time since hearing from you, and hope that this letter finds you in the best of health and enjoying your hunting sport out in the good old Middle West.

With reference to your bedding problems on the Model 600, I would suggest that the best areas would be the front section of the chamber rearwardly and to encompass the recoil lug and the front breech ring of the receiver. I think these items would support a better accuracy job if they were bedded in this manner. We have utilized the epoxy bedding method in the 350 and 6.5 as you know. We certainly stabilized the barrel bracket. You'll have to get down into some pretty fine shooting, however, to pick up the difference, but I suspect that by this time you should be very proficient in that business. If I recall, it wasn't long ago that you were the working man, and now are enjoying your much deserved retirement.

Glad to hear from you again and hope you find good success in the bedding procedures.

Best regards,

*W*  
W. E. Leek,  
Manager - Firearms Research & Design  
Ilion Research Division

WEL:T



Minneapolis, Minnesota  
26 Aug 66

Remington Arms Company, Inc.,  
Ilion, New York

Attn: Mr. Leek

Dear Wayne:

How was the vacation? I trust that on your return that you found the three months work awaiting you. That is what usually happened to me when I was a wage slave.

References:

- a). My ltr of 17 Aug 66 regarding the correct method of bedding the M-600, cal .308 and
- b). Your Mr. Finnegan's prompt reply of 25 Aug

Judging fm ref. b), above, the barrel should b free-floating but, getting down to the fine nit-picking details, from wat station on the barrel? Usually with the M-700, 721 and 722 series, I bedded the cylindrical portion of the barrel in the epoxy.

#1 Question: Shud the cylindrical portion of the the barrel of the M-600, cal .308, be bedded in the epoxy?

Ref. b), above, stated that the "M/600 Magnum is bedded in epoxy at the barrel bracket only". -this particular specimen of the M-600 has from 35 to 40 mils clearance along the sides of the receiver back along the cylindrical part, which is good for collecting pine needles and other debris in the woods. With the 700, 721 and 722, I bedded the entire receiver, less magazine box, in the epoxy with about 25 mils clearance in the front and the sides of the barrel bracket.

#2 Question: How much of the receiver should b bedded in the epoxy?

Knowing how much that I dont know, and how much I know that isnt' so, I prefer to ask questions ~~from~~ of competent engineers and get ificated.

Thanking you in advance, I remain

very truly yours



P. G. Carney  
5637 James Avenue South  
Minneapolis, Minnesota  
55419



cc: G. M. Calhoun  
F. E. Morgan  
V. G. DeRosa  
W. E. Lock  
M. H. Walker  
R. P. Kelly - file

Ilion, New York  
August 5, 1966

TO: R. A. WILLIAMSON

FROM: S. M. ALVIS

THE PROPOSED IMPROVEMENTS - MODEL 600

F. E. Morgan advises Marketing, approval to proceed on two new rifles for introduction in 1967. Earlier this year, he indicated that some changes would be needed in this model to sustain the desired volume. A number of different samples were prepared and we understand that selections have been made with the request that we move up on the work and schedule for introduction in January 1967. The economics are as per the Methods and Standards estimate No. 2587 of July 29th. The specification changes will be essentially the same for the Model 600 regular and for the Magnum. We understand that it is tentatively planned to designate new models numbers, either Model 666 or 606-. Present models are likely to be phased out next year as dictated by market acceptance.

A plant project is needed and suggests we will have to provide design drawings, parts lists, staff changes, etc., which will require diverting design personnel if given priority. This could be started as soon as directed and some drawings completed in about two weeks. Operations Committee action is also needed and suggest that the Secretary prepare data for submission to the individual Committee members, since awaiting the next scheduled meeting would delay the job.

The scope of work for both the regular and Magnum grades are:

- Stock - Re-design, with fore end tip and spacer; M/1100 style grip cap and spacer; butt plate spacer; and inlet for the Magnum weight barrel with R&W finish.
- Barrel - Increase length to 20" and Magnum weight, without vent ribs. Use M/700 style front and rear sights.



June 10, 1966

I note you have quite a combination of scopes and mounts. I don't know all the fellows involved in the manufacture of these scopes, but Ed Hilliard is a friend and old Army buddy of mine, who is associated with Radfield. My home is in Wyoming and I personally take many of our new models out in that area to test them each summer. We not only shoot at targets and game, but also with my three boys manage to pack these items on our back up into the high mountain ranges, and have found several on which we recommended changes as far as carrying ease is concerned.

About two years ago I tested the 6.5 and 350 with Les Bowman in Cody, Wyoming. Both guns performed superbly and the 350 has had time to add to its credit all of the major game in this country including Kodiaks, grizzlies, moose and buffalo, as well as mountain lion and Polar bear. The 7mm has performed good on big game worldwide, is excellent for long range shots at antelope, sheep and elk.

The Model 1100 is really making a name for itself. I don't think there is any doubt it is the finest autoloading shotgun ever made. The XP-100 holds records for accuracy in pistol shooting, Les Bowman having a 5-shot group at 100 yds. of .430". One other sports writer has a similar group at .460". Out on the West Coast in the Seattle area after the rifle type bench matches are over out comes the XP-100 for a bench rest match. One writer, Ken Judge Glanzer, seems to be promoting this work. As you probably know the XP-100 made the cover on 5 sporting magazines following its announcement. Naturally we don't expect large volume sales from this item since its usefulness is limited, but we do think it has made its impression on the shooting world as it influences the thinking of gun designers and military people as well.

One demonstration we enjoyed at Aberdeen a couple years ago with the XP-100 was to outshoot all the rifles on hand at 1/4 miles at bobbing targets, making 5 hits at 5 targets with 5 shots at this distance. We also demonstrated 5 hits from 5 shots offhand at 5 man size targets at 100 yards. This was unheard of in pistol shooting previous to this demonstration.

You can be justly proud of your collection and I can assure you that we are not resting on our laurels even though we are first in the gun business. More and more effort is required to remain in that position, and I am sure things to come you will be proud to add to your already growing list of fine Remington sporting guns.



Mr. Robert M. Simmons

-5-

June 10, 1966

I appreciate your letter and suggestions, and your letter is being routed to the gun designers in our group as well as our leading salesmen, and am sure it will be read with interest. It wouldn't be surprising if some of your suggestions might influence some of our existing models as well as those planned for the future.

Best regards and thanks again for writing,



W. E. Leek,  
Manager - Firearms Research & Design  
Ilion Research Division

WEL:T



2627 Alandale Drive

Macon, Georgia

May 24, 1966

Dear Mr. Rockwell,

I enjoyed talking with you today and I really appreciate your time and interest. I had been wanting to talk with some-one from Remington for a long time.

Time prevented me from really going into detail on the phone so I have taken the liberty of writing you and expressing some of my ideas and opinions of some of the revenues and changes that I would like to see in Remington rifles.

If you are not interested, I would appreciate your passing this letter along to someone who may be.

Again I would like to thank you for efforts to get our 6.5MM shipped.

Below and following are some of the suggestions that I would like to see Remington use in the future.

I - Make all 700 actions the same length, not have a short action and a long action as they have for years. My reasoning for this suggestion is that in cartridges such as 6MM Rem. and .350 mag

NP | you can't seat the longer, heavier bullets out far enough to get full penetration from the cartridge using the short action, where as if the long action was used, you could use every bullet weight and length and be able to get more powder in the shell, by not trying to seat the bullet so deep.

RECEIVED

MAY 31 1966

G. G. D. ROCKWELL



700 - A lot of people that I have talked feel that both the .350 Rem. Mag. and the New 6.5 Rem mag should be offered in the 700 (long action) series so that you would have at least 22" barrel or 24" barrel and with the long action you could use the longer - heavier bullets and seat them further out.

700 - In calibers that are designed specifically for scopes such as .222, 222 Mag, 223, 22-250, 243, 6.44 REM 6.5 REM Mag, should come with NO sights at all, just a long sleek barrel - NO removable front or rear sight. Not drilled & tapped for receiver sights. No one buys a 22-250 and uses open sights or even receiver sight.

700 - I feel that Remington really falls the bill with their calibers in the 700 series from 222 to .458 except for .25 caliber. This used to be a popular caliber and now no one except Witherby chambers for it - .257 Magnum.

742 - BDL Smokes should be offered in each caliber that this model is offered, especially the 6.44 Remington. Also the BDL smoke should be offered in the Carbine Version.

742 - The BDL Smokes of 742-760 should have been used as the "Sentinel" model, not just the standard model.

742 - All calibers that the 32" rifle is chambered for should be offered in the 18 $\frac{1}{2}$ " barrel as well, both in the 742 and 760.



A- Model 600 Remington - Shorten fore-end of stock by about 2 inches because of the short 18 $\frac{1}{2}$  borell make the stock look too short long? for the borell length.

~~Do away with the ventilated ribs completely, as it serves no practical purpose, adds unnecessary expense. People think it looks like a toy or a Buck Roger Special, but the 18, L have sold, all have removed the ribs.~~

With money saved by leaving off the ribs, use it for putting on a pistol grip cap.

Also would like to see a powder anodized aluminum floor plate and trigger guard instead of the nylon one.

On the same receiver and bolt are used for the XP-100 and 600, it would be nice to offer both models in the same caliber such as .221, 222, 222 M19 or .223 Rem. The serious Varmint hunter would take along his XP-100 and 600 and use the same ammo. It would be a good selling point.

B - XP-100 - Before it dies a natural death after a short life, I feel that if it were chambered for other cartridges such as .222 Rem, .222 Rem Mag and .223 Rem. or borell to .22-250 - .243 - 6MM or .257 as well as the current .221 sales would pick up and it would turn out to be popular. Single shot, long range Varmint pistol - properly scoped.

C. I feel that if the .350 and 6.5 Remington Magnum were offered in a standard version with regular one-color walnut and in a deluxe version with the laminated Birch & Walnut they would prove to be more popular. Some people just don't care for the gray light color of the birch wood in the laminated 6.5.



	MAKE	MODEL	CALIBER	SCOPE	MOUNT
1-	Remington	Model 700 BDL	7 MM. REM MAG.	Weaver V-9 (3-9)	Redfield
2-	Remington	Model 700 ADL	.22-250 REM.	Wetherly 2 1/2-10	Redfield
3-	Remington	Model 722	.257 REM ROBERTS	Leupold 3X9	Redfield
4-	Remington	Model 742	.30-06 Springfield	Leupold 3X	Redfield
5-	Remington	Model 760	.30-06 Springfield	Weaver K 2 1/2 X	Redfield
6-	Remington	Model 600	6 MM Remington	Weaver K-6	Redfield
7-	Remington	Model 600	.350 Rem. mag	Redfield 2X	Redfield
8-	Remington	Model 600	6.5 Rem. mag	Redfield 3X9	Redfield
9-	Remington	Model XP 100	.221 Rem. Fireball	Leupold 2X	Redfield
10-	Remington	Model 550-1	.22 Cal Rain Fire	Weaver KV	Redfield
11-	Remington	Model 1100	12 gauge 28" modified w/ventilated Red		
12-	Remington	Model 870	12 gauge 30" full	Plain barrel	
13-	Remington	Model 10	12 gauge 26" imp cyl	plain barrel	
14-	Remington	Falling block	.22 Cal single shot rifle		

Above is a list of Remington rifles, shotguns and pistol that I have (after I get my 6.5 MM). These fire arms are my personal guns that I take a lot of pride in showing and owning.

If I were able to, I would own one of every Remington Rifle, shotgun and pistol in ever caliber, gauge and grade.

99% of every gun I sell is a Remington. All eight of the fellows in our deer camp use Remington rifles. almost all of the rifles I trade or work on are Remingtons.

You can see that we are mighty sold on Remington.

Our saying is "Remington Makes the Best,  
Winchester makes the rest"

Respectfully yours,

Robert W. Simmons  
Hatchery Area Service



**THE PROPOSED IMPROVEMENTS - MODEL 600**

**Page 2  
August 5, 1966**

**Bolt - Use black handle and export style bolt plug.**

**Unless advised to the contrary, we will proceed with the design work, anticipating that the plant will provide for tooling and engineering.**

**Also, that Marketing will solicit Operations committee's approvals as soon as provided with confirmed economics.**

**BMA:c**



cc: R.P. Kelly  
\* F.E. Morgan - J.D. Mitchell } In  
\* R. L. Andrews } Turn

*mf600*  
*Desin*  
June 10, 1966

Mr. Robert M. Simmons  
HITCHITI GUN SERVICE  
2627 Alandale Drive  
Macon, Georgia 31200

Dear Mr. Simmons:

*② d11*  
\*The length of Wayne Leek's  
dissertation prompted thought  
we might as well "share the  
wealth".

SMALvis

I have your fine letter with suggestions concerning our Remington guns and will do my best to comment on them.

On the Model 700 action lengths, our intent was to keep the actions in 2 different lengths so that those who wanted the smaller calibers would not have to carry larger, more cumbersome guns, and those who desired longer length loadings and heavier calibers could select the larger models. We have enjoyed tremendous acceptance of this model and back in the Model 721 era by furnishing features which do not exist on competitive guns, one of which was the 2 length system.

The Model 600 Carbine was introduced as an item which would fill the requirements of those individuals who do not like to carry long barreled cumbersome bolt action rifles, but are more inclined to carry such items as Winchester Model 94. But a good portion of these individuals were also interested in something as potent as a 270 or 30-06. This was accomplished by providing a short barrel, short action, but extremely strong bolt action rifle with ballistics of the longer cartridges such as the '06 and 270 which could be obtained in a shorter but larger capacity case. Our intent was not to interfere with sale of the Model 700 by introducing the Model 600, but to fill the gap as previously stated, for those individuals who are not interested in the larger gun. Therefore, for the present at any rate, it is our policy to keep the new short cartridges such as the 350 and 6.5 in the carbine category and leave the longer cartridges in the longer action Model 700.

As far as sights are concerned, there is problem in providing rifles without sights except in the custom category. It is our experience that a standard model of any type must be usable when taken from the gun rack of any of the gun shops in the country; and therefore it is mandatory that they contain sights. I agree that seldom does anyone buy a 22/250 and use it with open sights. But in our business, with exception of the custom guns, it is about the same thing as providing a Ford truck without wheels.



June 10, 1966

We investigated a series of calibers during development of the 350 and 6.5, and of course it was natural that the 25 caliber should be considered, which it was. For some unfortunate reason the 257, which was an excellent little cartridge, has died a natural death in the country and has taken with it the stigma of the 25. There are so many calibers available at the present time that it appears to me there is very little room left for anything really new in standard combinations. I am referring specifically to changes in loads as well as bullet shapes, etc..

As far as Centennial models in the M/742 and others, this was a Management decision. Design for extremely short barreled rifles has varied over the years, and only on occasion do we get requirements in the autoloaders and pumps for barrels shorter than 22". The M/600 seems to have been satisfactory in the short action bolt action series.

Pertaining to the length of fore end on the M/600, we had about 6 or 8 different lengths on our prototype models and it was conclusion of the Design Group that this particular one selected made the best impression for eye appeal and handling. There have been some suggestions that the fore end be made longer. In other words, similar to a Mannlicher type. Yours is the first suggestion I have received on making it shorter. There is considerable amount of difficulty in changing lengths of fore ends in the factory. Therefore, it is mandatory the one selected be completely right as possible. For example, when the fore end is changed in length, the tapers on all 3 sides and the top would also have to be changed, along with formers and tooling for manufacturing purposes. Then, too, an approximate \$25,000 change would be necessary in the dies for making the checkering pattern. Naturally changes of this nature can be accomplished with less difficulty in a gun shop where mostly handwork is involved. But in mass production, limitations would prevent alterations of this nature.

We have had comments pro and con concerning rib on the Model 600, to extent that those who like it think it a great new innovation in gun development and sighting for rifles; while others take the rifle to a gunsmith at their expense to have the item removed. But a rib on a rifle is like a lot of things for which Remington should be given credit in trying something new. After all, ribs have been acceptable on revolvers, pistols and shotguns ---- why not rifles? And I think, to be honest, the silhouette provided by this combination gives a more pleasing appearance with the rib than without it. It takes the curse off the high sights. However, these are all matters of opinion, and I guess this is what makes the world go round.



June 10, 1966

I don't believe a cast aluminum anodized floor plate and trigger guard would add anything to the Model 600 except perhaps a few ounces of weight. To my knowledge we have had no difficulties with this item. It retains the black appearance permanently, is very rugged, light weight, and performs its job satisfactorily.

Your suggestion for a companion combination of caliber between the XP-100 and M/600 I think is an excellent one. We have made up a M/600 in .221 Caliber that performs very well, but is inefficient as the 222 or 223 because the 221 was designed to be efficient ballistically in a short barrel. By the same token the 222 family of cartridges was designed to be efficient ballistically in a long barrel, and there are not efficient in a short barrel. And when fired in an XP-100, velocity is low and blast to the shooter's ears is damaging. The first XP-100 made experimentally was chambered for the 222 and although accurate was not acceptable because of the two previously mentioned factors. There have been several who have made the mistake of purchasing an XP-100 and having it rechambered for a 222. We have considered other calibers for the XP-100 and have experimented with a few, one of which was a 6mm on a 222 case. This combination was very accurate but the muzzle blast was objectionable, range was excellent, and recoil not too severe. Other calibers such as you mentioned (22/250, 223, 257) we would consider not only dangerous as far as muzzle blast and broken ear drums are concerned, but in some instances recoil might be too severe for proper safety of handling such a gun and cartridge combination.

Going back to the Models 600 and 600 Magnum, our objective was to keep the Magnum and its laminated stock in one category and the one piece walnut stock in smaller calibers in standard version. All kinds of combinations could be supplied, of course. For example, we experimented with a laminated walnut stock which contained the superior qualities of warp-free conditions such as the one we now manufacture, but the laminations were not obvious enough, we thought, to suggest to the customer that he was getting more for his money; therefore, it was abandoned. We have tried several other combinations of woods, but it is difficult to find one that can be laminated properly to give enough definition of color changes so that the customer recognizes it as a laminated stock.

I got a chuckle from your comment about "Remington makes the best - Winchester makes the rest", and was astounded to see the list of rifles and shotguns of Remington manufacture that you own. You must be very proud of this collection.



*H. Watson*  
*Wayne*  
May 26, 1966  
*info*  
*DSS*

Nikko Industrial Co., Ltd.  
Chiyoda Bldg. No. 2, Kyobashi  
2-Chome, Chuoh-ku  
Tokyo, JAPAN

Gentlemen:

By Air Parcel Post we are sending you one Model 300 Rifle, caliber 308 with a special device permanently affixed to the muzzle that makes this rifle comply with the minimum 19<sup>th</sup> requirements of the Japanese law for center fire rifles.

Please examine this rifle and give us an estimate of your requirements as soon as possible, along with your initial order.

I am sure this rifle's specifications comply with your request to W. D. Vuono on his recent trip to Japan.

Your earliest comments would be greatly appreciated.

If I can be of any further service, please advise. With kindest regards, I remain

*Wayne*  
Sincerely,

*Julio B. Cadenas*  
Julio B. Cadenas  
Assistant Manager  
Export Sales Division

JBC:bh

cc: William D. Vuono  
~~Sam Alvis~~ - Ilion  
Wayne Leek - Ilion

*Shipped*  
*Julio*



cc: W.E. Leek

Ilion, New York  
April 21, 1966

TO: J.B. CADENAS  
Bridgeport  
FROM: H.J. WATERMAN *HJW*

I am sorry for the delay in answering your memo of March 21 regarding the possibility of getting a Model 600 with "Muzzle Brake - Barrel Extension" permanently affixed for export to the Nikke Industrial Co. as a sample.

As was stated previously, the extension in the picture was a prototype only and was affixed with a set screw. This method, of course, is unacceptable from a strength standpoint and it does not meet the "permanently affixed" standard. The picture submitted was solely meant for some acceptance or rejection of the idea aesthetically and was not meant to indicate a finish design.

I am attempting to affix the extension mechanically rather than by heat to avoid warpage, recoloring, high tooling cost, accuracy difficulties and a possible standing inventory.

The first attachment method was not successful on either the 350 Rem. Mag. caliber or .308 Win. caliber test rifles. A second method of attachment is being assembled on the 350 Rem. Mag. and will be test fired when ready. It is felt the attachment must be able to withstand the firing stresses of 3,000 rounds. Whether this will be tested on a live ammunition basis or dry cycle has yet to be determined.



I am enclosing a copy of a letter sent to the Process Control Section on March 31, 1966, the subject of which is cost estimate. The annual volumes and caliber types are solely working figures and may or may not be close to the actual figures.

Assuming the future design testing appears promising I will need clarification from you as to which type and caliber Model 600 to make up for submitting to our distributors in Japan.

HJW:gjp  
Encl.



cc: G. M. Calhoun  
W. E. Leek - Ilion  
E. Sparre  
W. D. Vuono

*m/600  
Design*

Bridgeport, Connecticut  
March 21, 1966

TO: H. J. WATERMAN  
ILION RESEARCH DIVISION

FROM: J. E. CADENAS

Your photographs of the Model 600 incorporating the suggested muzzle brake to increase the barrel length to 19 $\frac{1}{2}$ " were submitted to our distributors in Japan, Nikko Industrial Co., Ltd. Nikko feels that this type of increasing our barrel length to 19 $\frac{1}{2}$ " is acceptable, provided that the muzzle brake is permanently affixed to the barrel.

Would it be possible to get a Model 600 prepared in this way with the muzzle brake permanently affixed to the barrel in order to send it to Nikko Industrial Co. as a sample?

We would appreciate hearing from you at your earliest convenience on this.

JBC/rh



## DON'T SAY IT—WRITE IT

*File*  
To W. E. LEEK  
FROM W. L. DAHL

DATE March 21, 1966*M/600  
Des*

Reference your memo 24 Feb. 1966 regarding separate box magazine for M/600 Carbine.

The M/600 receiver can be adapted to take a detachable box for only the shortest of contemporary cartridges. For example, there is space available for fitting a Cal. 223 Armalite magazine into the M/600 but a Cal. 308 M14 Rifle box could be installed only through extensive modification of the receiver and trigger assembly. The M14 box could probably be fitted to the short M/700 receiver.

In concept I believe that separate box magazines and fixed box magazines could be used interchangeably with a standard receiver. The receiver rails that control the feeding shell in our current firearms would necessarily be cut away to take the separate box magazine with its integral feed lips. A fixed box magazine for the same receiver could have feed lips formed on it to perform the same function while installed permanently in the rifle stock. Feed lips on the magazine box might in principle be less desirable than feed rails in the receiver; but if separate boxes are workable, as indeed we know they are, this is substantive proof that feed lips on a fixed magazine box are workable.

WLD:T

THERE IS A SAFE WAY; DO IT THAT WAY



February 23, 1966

Mr. Thomas Riddle  
Burns Lake, B.C.  
Canada

Dear Sir:

I have been out of town for the past few weeks and haven't had the opportunity till now of reading your interesting letter and giving you my answer as I see it.


A review of a cross section of this country was made as to requirements for bolt action rifles and it was found that there was only one area lacking and that was a short barreled carbine which would be potentially powerful enough to down the largest game on the North American continent. There were racks full of 22", 24" and 26" barrel bolt action rifles of every caliber from a 22 center fire to 458's. It was then it was decided by our Company to fill the gap for the individual who deplores the long barrel, long action, and wants a light weight and short, handy carbine for his occasional hunt into the wild terrain. From this investigation the Model 600 was born, the outgrowth being enlarged into the 350 Magnum and now the 6.5 Magnum which provides a heavier barrel than the original Model 600, but of the same carbine length.

As far as accuracy is concerned, there is no question about it the short barrel is every bit as accurate if not more so than the long barreled rifle. The only loss is in velocity.

High sales volume and a continuing increase in demand for this model, plus a couple of competitive items on the market which are copying the idea but not fulfilling the specifications, are indicative of consumer acceptance.

I trust this information will enlighten you as to why we developed the Model 600 and why it has a barrel length under 22". Thank you again for your fine letter and your comments concerning Remington products.

Very truly yours,

  
W. E. Leek,  
Manager Firearms Research  
and Design  
Ilion Research Division

WEL:T



*please Sam & N DeRuse Same 7/9*  
ND-498  
**REMINGTON ARMS COMPANY, INC.**

INTER-DEPARTMENTAL CORRESPONDENCE

*Send a copy*  
**Remington**  
**DUPONT**

**PETERS**  
**DUPONT**

"CONFINE YOUR LETTER TO ONE SUBJECT ONLY" \_\_\_\_\_

December 9, 1965.

TO: *W. E. LEEK* *m*

FROM: H. J. WATERMAN

SUBJECT: M-600 CARTRIDGE FEEDING

Investigation of the M-600 (Magnum Cal.) feeding malfunction of the last round out of the magazine being "hard under rail" has indicated two methods of correction.

The first method is to change the release point cut in the rails (.015-.018 opening from .540 width), moving the cut starting point .370 rearward and terminating this cut .270 further forward. This runs this cut out as close to the forward wall of the magazine cut as a .250 dia. cutter will allow.

The 30° bevel cut on the bottom of the rails is continued forward to the front wall of the magazine cut. The cuts of this method have been made on a .350 Rem Mag and 6.5 Rem Mag. and the two rifles tested successfully with a minimal number of rounds.

A number of dummy rounds of other M-600 calibers (.308 Win., .243 Win., .35 Rem., 6mm Rem) were put through the magazines successfully. This was not a conclusive test and only indicates the rail change could be standardized. Further testing would be necessary.

The second method would be a change in the follower. It seems a decrease of approximately .050 on the high side of the follower allows the cartridge (Magnum) to be cammed from under the rails sooner and without binding.

This change can be either by raising the low side .050 or of course lowering the left side by the same amount. When the low side is raised, which can possibly be accomplished by reworking the blank before heat treat, or by having a new follower manufactured, the magazine box capacity is reduced by the depth of the pad increase. This capacity is critical now, several changes having been made to reach the present dimension.



M-600 CARTRIDGE FEEDING - Continued

December 9, 1965.

Lowering the high side of the follower would call for a new follower. There does not appear to be a way that blanks could be re-worked in a secondary operation successfully.

The second method in which the follower was changed does not call for a change in the rail cuts. The altered Receivers were functioned successfully with the altered follower but the double change is not necessary.

There was no attempt to function standard rifles in other than magnum calibers with the altered followers. There have been no feeding problems reported in other calibers.

The problem appears readily solvable with either method. The economics are not dealt with herein but appear to perhaps be the key to the solution of the problem.

No changes will be instituted on the M-600 model drawings or on the M-600 6.5mm Rem Mag rifles for field representatives until management makes their decision.

  
H. J. WATERMAN

HJW:GMS



cc: S. Matthews  
W. H. De Rosa

December 9, 1965.

TO: W. E. LEEK  
FROM: H. J. WATERMAN

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No changes will be instituted on the M-600 model drawings or on the M-600 6.5mm Rem Mag rifles for field representation until management makes their decision.

H. J. WATERMAN

HJW:GMS



*File Copy*

November 5, 1965

Mr. Henry L. Cosselman  
105 West Street  
Gloversville, New York

*Design*

Dear Mr. Cosselman:

Thank you for your letter of October 23, 1965 regarding the Remington Model 600, and particularly the Front Sight.

Design experience and testing, extensive field testing, and years of total hunting experience by our Design Section helped us to make our decision on the size of the Front Sight Bead.

One of our main concerns along with safety, quality and accuracy is field handling. We feel the large bead gives a much faster sight picture in the varying light conditions of field and brush shooting.

For sighting the rifle in, may we suggest you use a 6 o'clock hold on the 6 inch bullseye with the top of the bead. Keep the bullet point of impact several inches low. This should sight the rifle in so your field shooting sight picture will be point of aim when covered by the bead.

Thank you for your interest in Remington products. If we may be of further assistance, please contact us immediately.

Sincerely,

Harold J. Waterman  
Firearms Design And Development

HJW:GMS  
Encl.



Remington Arms Co.  
Elton, N.Y.  
U.S.A.

Wagner seeks  
84.2

Burns Lake  
B.C.  
Canada:  
Jan. 15-46

Sirs;  
I am old enough to know enough  
to mind my own damned business.  
But when I see what could so easily be  
a perfect Bushmans Rifle like your  
little 600 ruined by putting a barrel  
under 22" on a 308 cal. on further handling  
by not having a modern clip &  
det mag. at least optional. I could  
spend a week just a cussin. Sure  
I know most young men who make  
up the larger part of your potential  
customers don't have experience enough  
to know what in hell they do want  
But you fellows do, on sure a ~~scope~~  
scope mounted on a saved off barrel  
will shoot well but it sure won't  
do much to tame the horrible bells  
of the 308 win. case in any barrels  
than 22" on men in



24" barrels the a. nasty sharp <sup>snapping</sup> recoil of said otherwise excellent <sup>308</sup> hull has resulted in not a few <sup>308</sup> cal. rifles sellen second hand even here in BC where 30-06 an even heavier <sup>caliber</sup> are common on the Husquarna on the H.V.A. action in their featherweight in 308 most often are accused of having a much worse kick than a 30-06 an most of them don't stay long in the original purchaser's hands, yet this is a good Rifle & Case. I have over 50 years hunting experience 44 in BC I guided for years & I know the despite scopes & I used my first one in 1917, most game is shot off hand & a slightly muggle heavy rifle usually handles better off hand then one must use a conventional mag. The well could be large <sup>mag</sup> that clip det. Mags could be furnished optional.

Thos Riller  
Burns Lake, BC.  
Canada.



**DON'T SAY IT—WRITE IT**

*File Copy*

*File*  
TO I. B. CADENAS - Bridgeport

DATE Feb. 9, 1966

FROM H. J. WATERMAN - Ilion

*HJW*  
Julio:

Wayne has asked me to handle the M/600 - 19 1/2" barrel length proposal.

Enclosed are two pictures of barrel lengthening "muzzle brakes" which were placed on a prototype M/600. These were simply slipped on and attached with set screw. We are studying permanent attachment methods and also hope to have some preliminary cost figures soon.

HJW:T  
Encl.

H. J. Waterman  
Ilion Research Division

TO BE SAFE, FIRST THINK YOU MIGHT NOT BE



GSS-Rem.

**DON'T SAY IT—WRITE IT**

52

TO WAYNE LEEK

*Cadman*

FROM J. B. Cadman

DATE

2/4/66

*Julio Cadman*

*Wayne*

*have you been able to do anything on the  
model 600 to increase the barrel length  
to 19 1/2" i.e. muzzle brake? Please advise  
as soon as possible.*

*Thanks,  
Julio*

*P.S. Oppenheimer Booting*

THE MORE CHANCES YOU TAKE, THE LESS CHANCE YOU HAVE



*Handwritten:* This must be one of  
your old buddies. Would you  
answer his question? *JK*  
*89-2*

105 West Street  
Gloversville, N.Y.  
October 23, 1965

*Handwritten:* Remington  
Should be letter  
OK in

Remington Arms Company  
Ilion, New York

Gentlemen:

I have just purchased one of your new  
Remington Carbines Model 600.

It is a very good carbine with one  
exception: The Front Sight.

When aimed at a 6 inch bullseye at a  
hundred yards it completely blocks out the 6 inch  
bull and most of the 12 inch by 12 inch target.

I corrected this by filing down the  
brass or copper bead so that it is no bigger than  
the rest of the front sight sighting plain.

Accuracy was improved remarkably.

I would like your opinion as to why the  
copper or brass bead was not made smaller as the  
accuracy is improved with the small bead.

Very truly yours,

Henry L. Cosselman



H. J. HACKMAN

Ilion, New York  
October 18, 1965

*DE*  
**M/600 STOCK - MAGAZINE SUPPORT CUT**

I was surprised to learn the other day that we have as yet not removed this cut in the M/600 stock. The design change to incorporate the elimination was initiated in June 1964, well over a year ago.

There were several reasons for doing this. One was to nullify breakages of the stock due to tightening of the front guard screw, and another mainly for purposes of retaining a good bedding system up front.

Both of these problems were of such a nature that I had one of my designers working on the item full time until we had obtained necessary information to produce the desired results. It appears that I failed to convey the story properly to your department and the necessity and seriousness that might be caused due to the lack of support, and therefore am willing to shoulder the blame. However, I encourage you to initiate the change as soon as possible.

Attached is a report by Harold Waterman indicating the background on this problem which may aid you in your investigation.

WEL:T  
Attach.

*Wayne E. Leek*  
W. E. Leek  
Firearms Research & Design



**DON'T SAY IT—WRITE IT**

TO W. E. LEEK

DATE 10-4-65

FROM H. J. WATERMAN

SUBJECT: M600 STOCK - MAGAZINE SUPPORT CUT  
ORIGINALLY THE M600 MAGAZINE BOX HAD A  
MAGAZINE SUPPORT SPOT WELDED ON THE FRONT.  
A SCREW WAS PLACED THROUGH THE SUPPORT  
AND INTO THE RECEIVER. THIS SUPPORT CALLED  
FOR AN INLETTING CUT IN THE STOCK. THIS  
CUT WAS PLACED IN UNDER THE FORWARD  
RING OF THE RECEIVER.

THE SUPPORT WAS NOT NEEDED AND  
WAS ELIMINATED, THEREFORE THE SCREW WAS  
ELIMINATED. THIS ALSO MEANS TWO ASSEMBLY  
COSTS WERE ELIMINATED.  
THE INLETTING CUT IN THE STOCK WAS

TO BE SAFE, FIRST THINK YOU MIGHT NOT BE



DON'T SAY IT—WRITE IT

To \_\_\_\_\_ DATE \_\_\_\_\_

FROM \_\_\_\_\_

ELIMINATED. THE COST OF THE COT WAS  
ELIMINATED AND MORE IMPORTANT THE  
WEAKENING OF THE STOCK CAUSED BY THE  
CUT.

THIS CHANGE ON THE STOCK DRAWING  
WAS MADE ON JUNE 18, 1964. THE  
STOCKS, WITH THE EXCEPTION OF THE M600  
.350 MAGNUM, STILL HAVE THIS CUT.

WHETHER THIS WAS CHANGED ONCE AND  
CHANGED BACK IS NOT CERTAIN.

THERE HAS BEEN INQUIRY SEVERAL  
TIMES ONCE THE EXPLANATION WAS THAT  
THERE WAS AN ABUNDANCE OF MAGNUMS  
TO BE SAFE; FIRST THINK YOU MIGHT NOT BE



DON'T SAY IT—WRITE IT

To \_\_\_\_\_ DATE \_\_\_\_\_

FROM \_\_\_\_\_

OF A PARTICULAR CALIBER MADE UP  
AND THAT THE STOCKS WOULD BE RUN UNTIL  
THAT LOT OF MAGAZINES WAS EXHAUSTED.  
THIS EXPLANATION WAS SHORTLY AFTER THE  
CHANGE AND AT THE TIME SEEMED  
FEASIBLE.

WE ARE NOW  $1\frac{1}{2}$  YEARS PAST THE DWG.  
CHANGE AND THOUSANDS OF STOCKS. IF  
MAGAZINES EXIST IN ANY FORM JAKE MODEL  
DRAWING THEY SHOULD BE SCRAPPED, OR  
ALTERED.

TO BE SAFE, FIRST THINK YOU MIGHT NOT BE





Ilion, New York  
October 18, 1965

H. J. HACKMAN

M/600 STOCK - MAGAZINE SUPPORT CUT

I was surprised to learn the other day that we have as yet not removed this cut in the M/600 stock. The design change to incorporate the elimination was initiated in June 1964, well over a year ago.

There were several reasons for doing this. One was to nullify breakages of the stock due to tightening of the front guard screw, and another mainly for purposes of retaining a good bedding system up front.

Both of these problems were of such a nature that I had one of my designers working on the item full time until we had obtained necessary information to produce the desired results. It appears that I failed to convey the story properly to your department and the necessity and seriousness that might be caused due to the lack of support, and therefore am willing to shoulder the blame. However, I encourage you to initiate the change as soon as possible.

Attached is a report by Harold Waterman indicating the background on this problem which may aid you in your investigation.

WEL:T  
Attach.

  
W. E. Leek  
Firearms Research & Design



Ilion, New York  
October 18, 1965

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WEL:T  
Attach.

  
W. E. Leek  
Firearms Research & Design



September 1, 1965

Mr. Paul A. Wallimann  
Box 65  
Glenville, Connecticut

Dear Mr. Wallimann:

We have received your inquiry pertaining to our Model 600 rear sight adjustability.

The approach used in the design of this sight was on the premise that an individual would set the sights for a specified yardage, then would not attempt to adjust for individual shots at various ranges, or to calculate windage.

Over the years we have found that the majority of shooters have great difficulty in judging distance and wind velocity. Therefore, with the sights set for a predetermined range, the shooter will aim high or low, according to conditions; as well as allow for windage as may vary from left to right, whichever is feasible.

Hope the above will clarify your question concerning the click type of sight for elevation and windage.

Very truly yours,

  
R. P. Kelly  
Ilion Research Division

RPK:T



Sam Allen  
84-2

AUG 25, 1965

DEAR SRS;

I HAVE A PROBLEM: I HAVE JUST BOUGHT  
THE REMINGTON 350 MAG MODEL 600.

AS YOU KNOW THE REAR SIGHT HAS NO  
CLICK STOPS. YOU LOOSEN THE SCREW AND THE  
SIGHT SLIDES UP OR DOWN. THERE IS NO ACCURACY IN  
ADJUSTING THIS TYPE OF SIGHT.

ELMER KEITH RECOMMENDS A WILLIAMS FOOL  
PROOF RECEIVER SIGHT. BUT THAT WOULD MAKE  
THE SIGHT TOO HIGH, BECAUSE THE FRONT SIGHT  
IS ON A VENTED RIB. THE REAR SIGHT ON THE  
RECEIVER WOULD COME UP TOO HIGH FOR COMFORT-  
ABLE SIGHTING.

THE ONLY ALTERNATIVE WOULD BE TO MAKE  
UP A SIMILAR SIGHT AS ON THE GUN ONLY WITH  
CLICK STOPS FOR BOTH ELEVATION & WINDAGE

COULD YOU HELP ME?

THIS IDEA WOULD MAKE THE GUN MORE  
VERSATILE.

THANK YOU.

PAUL A. WALLIMANN

Box 65

GLENNVILLE, CONN.

P.S. I DON'T WANT A SCOPE ON  
THIS GUN.



cc: H.K. Faulkner  
R.A. Williamson  
~~S.M. Alvis~~ In  
~~W.E. Leek~~ turn *W*  
H.J. Hackman) In  
V.G. DeReus ) turn  
A.J. Seckner ) In  
D.E. Geiss ) turn  
Estimate File #2599

Ilion, New York  
May 28, 1965

E. B. WALLIN

ADDITION OF CALIBER 6.5MM REMINGTON  
TO THE MODEL 600 MAGNUM RIFLE

Attached are the summaries of full unit cost and total cash data being sent to general management for new product approval.

Factory costs for the proposed 6.5MM are based on the same features as the current 350 Remington Magnum

R. A. Williamson  
Works Manager

*R. L. Hall*

R. L. Hall, Supervisor  
Methods & Standards Section

Att.  
RFKerr:sm



RECEIVED

JAN 25 1965

G. M. CALHOUN

cc: G. M. Calhoun  
R. A. Williamson  
H. J. Hackman ) In Turn  
V. G. De Reus )  
R.P. Kelly - W.E. Leek - File

Ilion, New York  
January 21, 1965

F. E. MORGAN  
Bridgeport

MODEL 600 - BARREL BRACKET

Wayne has just showed us a 308 Caliber rifle which had been purchased by Leupold & Stevens for testing of one of their new scope mounts which is designed for attaching forward on the barrel. Not having any projection on the barrel bracket, it had sheared off the studs under the ventilated rib.

Wayne tells me that there was a similar incident reported by Redfield and that as soon as these folks release more of these forward mounting scopes we can expect considerably more of this difficulty. If this occurs it is very likely that the rifles will be returned here for repairs.

This situation is prevented in the 350 Caliber by the elevated barrel bracket. As noted in Minute No. 13 - 1964 of the Operations Committee, this raised barrel bracket was planned to be made available for the regular M/600 as well as the 350. There was later information showing an increase in cost for the raised barrel bracket, and since at that time there were no forward mounting scopes on the market I recommended to the Plant that action on changing design for the regular M/600 be deferred until after the first of the year. In the meantime there was some criticism of this type of bracket when data drawings were released for the 350 Magnum Caliber in this model.

There may be some possible way of avoiding increased cost for barrel bracket such as reconsidering Hi-Dense powder metallurgy; however, in view of latest development, am recommending to the Plant they proceed on completing the contemplated changes to meet Wayne's design, which was transmitted many months ago.

As this goes into effect we can expect the Plant to report a cost increase. However, Design is going to take position that the cost increase would not be valid unless it considers the savings for reducing the number of complaints sent in for repairs if the new bracket is not used.

SMA:T  
Attach.

S. M. Alvis  
Ilion Research Division

\*Unless advised to the contrary, assume you and Dr. Calhoun are in agreement on going ahead.



G-88

**DON'T SAY IT—WRITE IT**

COPY

cc: V. G. DeReus

TO W. E. LEEK

DATE Oct. 7, 1964

FROM S. M. ALVIS

Information from the Plant indicates that the cost of the new bracket will be greater than the old style. Believe that you had intended to make this a common part for both the standard grade as well as for the 350 Magnum caliber. Because of the unfavorable cost situation in attempting to meet project objectives with the standard rifle I have asked to hold up on applying this part "across the board" until you had a chance to recheck the implications.

com

SMA:T

TO BE SAFE, FIRST THINK YOU MIGHT NOT BE



Old  
(13210)  
Cred 15.46

New  
(15647)  
Cred 15.46

Std. Mat. 70.300/c

19.300/c

Std. Lab. 1.606

3.605/c

+ Taped  
+ Taped 3.00

(and 1.00 per  
unit - 1.00  
per unit in case)

The add'l. amount on (Std. Mat.)  
(The price after assembly in case)

Factory Cost Comparison

	<u>Old</u>	<u>New</u>
Std. Mat.	70.300/c	19.300/c
Var. (140)	7.436 "	7.316 "
Std. Lab.	1.606	3.605
Var. (350)	.567	1.767
Rounded (260)	4.304	9.661
Sub Total	79.408/c	36.144/c
Plant O.N. (240)	7.010 "	8.675 "
Ind. Adv. (100)	.367	.448
Factory Cost	36.580/c	45.467/c
	.37 Cn	.45 Cn
add'l. Cost		.08 Cn. ✓

Out of profit (cost) .04 and Off



CENTER FIRE RIFLES AND PISTOLS - contd.

Caliber 350 Remington Magnum - contd.

Sales suggested a tag be attached to the rifles advising the customer regarding the scope mounting. R & D would normally plan on covering in the instruction folders.

A model gun with the raised Barrel Bracket was shown to the committee. Because the raised section is approximately the same height as the rib, the appearance was considered satisfactory.

Sales requires five (5) model guns to field test ammunition and rifles in October. R & D will assemble the guns with scopes for delivery to Sales by October 1.

Committee Action

The committee approved the design change to the Barrel Bracket and suggested the use of an information tag advising the customer of the proper scope mounting.

RIM FIRE RIFLES

NYLON 76 LEVER ACTION RIM FIRE RIFLES

Sales has disposed of the warehouse quantities of Nylon 76 Lever Action Rim Fire rifles and stated that additional guns can be sold.

The Ilion Plant has reviewed the status of major components. The quantity of parts to be held for Arms Service sale and gun repair has been rechecked. Planning reaffirms that fourteen hundred (1400) additional guns, assuming normal scrap, can be produced to the warehouse.



ESTIMATED UNIT FACTORY COST AND OPERATIVE EARNINGS OF  
PROPOSED MODEL 600, CALIBER 6.5MM REMINGTON

	<u>Current Line</u>		<u>Proposed</u>
	<u>Model 700 ADL</u>	<u>Model 600</u>	<u>Model 600 Magnum 6.5MM Caliber</u>
Estimated Annual Volume	( 500)	(500)	5000
Retail Selling Price	\$129.95	\$ 99.95	\$144.95
Net Selling Price	\$ 70.02	\$ 53.87	\$ 78.10
<u>FULL COST DATA</u>			
Unit Factory Cost	\$ 44.20	\$ 38.87	\$ 51.04
Unit Selling, Administrative and Research Cost	\$ 9.80	\$ 7.54	\$ 10.93
Unit Cost of Goods	\$ 54.00	\$ 46.41	\$ 61.97
Unit Operative Earnings	\$ 16.02	\$ 7.46	\$ 16.13
% of Net Selling	22.9%	13.8%	20.7%



ESTIMATED ~~UNIT~~ FACTORY COST AND OPERATIVE EARNINGS OF  
PROPOSED MODEL 600, CALIBER 6.5MM REMINGTON - CASH BASIS

	<u>Total Cash Reduction in Regular Rifles by Reduced Volume</u>	<u>Total Cash thru Addition of 6.5MM Caliber</u>	<u>Cash Results</u>
Volume	(1000)	5000	4000
Net Sales	(\$61,940)	\$390,500	\$328,560
Factory Cost	(\$31,470)	\$195,050	\$163,580
Total Cost (includes Selling, Administrative & R & D)	(\$31,470)	\$195,050	\$163,580
Operative Earnings	(\$30,470)	\$195,450	\$164,980
Net Earnings	(\$14,770)	\$ 94,720	\$ 79,950
Investment			
Permanent Investment			0
Working Capital			<u>\$169,800</u>
Total Investment			\$169,800
Return on Investment			
Return on Capital			47.1%
Return on Total Costs (including Development and Operative Charges)			44.3%

Plant and R & D Expenditures .. \$10,500



## REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE

*Remington*  
DU PONT*PETERS*  
DU PONT

February 12, 1965

"CONFINE YOUR LETTER TO ONE SUBJECT ONLY"

TO:  
F.E. Morgan

SUGGESTION N.D. BERKELEY, MODEL 600 DE LUXE

The attached chart indicating estimated factory costs of the Model 600 compared with various additions including the laminated stock such as used in the .350 will probably be adequate to give you a guide as to the possibilities of such a combination. These were worked up by John Roberts who obtained his information from Vic DeReus and methods of standards. I feel that the estimates are quite firm. If there is anything further that I can get for you, as your interest changes in this combination, please advise.

W.E. Leek



CENTER FIRE RIFLES AND PISTOLS

MODEL 600

Costs

Production reviewed the second quarter costs shown on Table 2. These indicate that the cost for the year to date is \$ .07 over the first year project goal. The May and June figures were under the first year project goal.

Caliber 350 Remington Magnum

Production reported that the laminated walnut and beech Stock blanks have been ordered. Delivery is promised the middle of September. Tooling procurement schedule should permit the startup of pilot operations the latter part of September. The plant schedule is to produce guns to the warehouse in November.

In testing model guns, difficulty was experienced in shooting with scopes. While some difficulty has been reported with scope attachment to 308 caliber, the problem has been increased with the higher power of the 350 Remington Magnum. It was necessary to revise the design so that the scope mount could be against a raised section of the Barrel Bracket. The Barrel Bracket will be a new part and will be used for all Model 600 guns as soon as available. It was felt this will be an added sales feature.

R & D related that the change to the Barrel Bracket is the only part of the gun that would be revised. The balance of the change will have to be made by scope and scope mount manufacturers. Each vendor's scope or mount problems will have to be covered on an individual basis by R & D in order that the scope mount be supported by the bracket. Slippage of the telescope (within the mount), spacing of scope mount holes and difficulty with internal adjustments can be explained to the vendors.



Model 600 - Regular Caliber

1. Laminated Stock  
Regular Butt Plate (Not Rugged)  
Sling Swivels (350 mag type)
2. Plus Sling Strap ( " " )
3. without Sling Strap & Swivels.



G-8-Rec

San Antonio

Vic. Del Rio

TO: F. E. ORGAN

FROM: ELLIOT, JR.

**DON'T SAY IT—WRITE IT**

DATE 1/17/65  
VED  
JAN 1 1965  
OFF

Dear Pete:

A suggestion, why not consider making the M/600 in a deLuxe model using the laminated stock, sling swivels, etc. in our regular calibers? I believe that we could sell an increased quantity of the M/600 by doing this—perhaps 10 to 25% more rifles yielding an increased dollar volume. Whether the profit would increase, I don't know, as I do not have the costs.

It would be my thought that we could retail this deluxe M/600 for perhaps \$5.00 less than the 350 magnum as the barrels would be standard and the recoil shoulder would not be needed yet we could use the same stock with regular inletting tools.

Regards,

*Jack*

cc: M. D. Berkeley

SAFETY IS A RESPONSIBILITY — ACCEPT IT



Page 10 of 10  
 10/20/2010

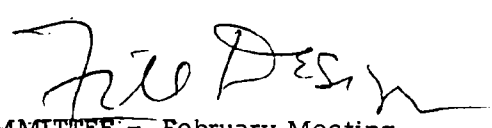
ESTIMATED FACTORY COST - MODEL 622 REGULAR CARTRIDGES  
WITH 30 MAG TYPE LAMINATE STOCK, SLUG SWIVELS ETC

	M/600 30S CAL.	ADOL COST PER LAMINATE STOCK FLY-CID B.M.A.T.	ADOL COST FOR SLUG SWIVEL	ADOL COST FOR SLUG SWIVEL
STD MATERIAL	\$ 7.03	\$ 1.19	\$ 1.71	\$ 68
VARIANCE	13.0	15	16	04
STD LABOR	6.17	91	07	01
VARIANCE	7.24	35	03	01
BURDEN	14.78	7.48	19	03
SUB-TOTAL	\$ 33.13	\$ 5.08	\$ 1.66	\$ 57
PLANT OVERHEAD	7.64	1.17	.38	17
INVENTORY ADJ.	41	04	04	01
FACTORY COST	\$ 41.75	\$ 6.31	\$ 7.06	\$ 1.04
		\$ 4729	\$ 4965	\$ 5067

FEB 4 1965



DRAFT

  
OPERATIONS COMMITTEE - February MeetingModel 600 - Barrel Bracket

At the July 1964 meeting of the Operations Committee, Wayne Leek presented a model of the M/600 Magnum Carbine with a new designed barrel bracket which projected above the receiver and sighting rib. The main purpose was to provide an abutment for positive support of the long eye relief type of telescope mounts expected to be offered to the trade. This would be an improvement and was incorporated into the design of the regular grade M/600 rifles as a common part with the 350 Caliber Magnum Carbine rifles.

The Committee approved the proposal as presented. When the design was later processed, the Plant concluded that the new bracket would impose an increase in cost and at a time when effort was being made to reduce cost of this regular grade rifle to bring it into line with the project figures. In view of these considerations the R&D Manager suggested that the Plant proceed with the procurement of the new brackets in sufficient quantity to meet the more severe requirements of the Caliber 350 Magnum (which sold at a premium price), and that changeover to the regular grade Model 600's might be deferred while efforts made to reduce cost of the new bracket.

Recently a telescope and mount manufacturer (Leupold & Stevens) returned a Model 600 in Caliber 308 which they had purchased for testing with their new long eye relief type of telescope mount. Their new mount was attached to the ventilated rib studs on the barrel. Without the new style of barrel bracket to support their



mount it caused these studs to fail <sup>in</sup> and shear. W.E. Leek has now urged that there be no further delay in adding the new brackets to the regular M/600 production in order to reduce possible incidence of this problem with scope mounts expected to appear on the market. The Design Group also feels that while Remington might not be directly responsible or obligated to accommodate the scope mount problems, it can very well affect the sale of the Model 600 rifles.

R&D has therefore requested that Production expedite the changeover and report on the indicated production cost.

SMA:T  
2-1-65



cc: G.M. Calhoun  
R. A. Williamson  
H. J. Hackman ) In Turn  
V. G. De Reus )  
R.P. Kelly - W. E. Leek - File ✓

Ilion, New York  
January 21, 1965

F. E. MORGAN  
Bridgeport

MODEL 600 - BARREL BRACKET

Wayne has just showed us a 308 Caliber rifle which had been purchased by Leupold & Stevens for testing of one of their new scope mounts which is designed for attaching forward on the barrel. Not having any projection on the barrel bracket, it had sheared off the studs under the ventilated rib.

Wayne tells me that there was a similar incident reported by Redfield and that as soon as these folks release more of these forward mounting scopes we can expect considerably more of this difficulty. If this occurs it is very likely that the rifles will be returned here for repairs.

This situation is prevented in the 350 Caliber by the elevated barrel bracket. As noted in Minute No. 13 - 1964 of the Operations Committee, this raised barrel bracket was planned to be made available for the regular M/600 as well as the 350. There was later information showing an increase in cost for the raised barrel bracket, and since at that time there were no forward mounting scopes on the market I recommended to the Plant that action on changing design for the regular M/600 be deferred until after the first of the year. In the meantime there was some criticism of this type of bracket when data drawings were released for the 350 Magnum Caliber in this model.

There may be some possible way of avoiding increased cost for barrel bracket such as reconsidering Hi-Dense powder metallurgy; however, in view of latest development, am recommending to the Plant they proceed on completing the contemplated changes to meet Wayne's design, which was transmitted many months ago.

As this goes into effect we can expect the Plant to report a cost increase. However, Design is going to take position that the cost increase would not be valid unless it considers the savings for reducing the number of complaints sent in for repairs if the new bracket is not used.

  
S. M. Akvis  
Ilion Research Division

SMA:T  
Attach.

\*Unless advised to the contrary, assume you and Dr. Calhoun are in agreement on going ahead.



Thelma  
Pless file M600  
35014  
u



WAYNE

FIELD TEST  
SUMMARY

REQUESTED BY  
F. E. MORGAN

John



REMINGTON ARMS COMPANY, INC.  
Ilion Research Division  
January 12, 1965

## FIELD TEST SUMMARY

### MODEL 600 MAGNUM CARBINE Caliber 350 Rem. Mag.

For field test purposes, a Model 600 Magnum Carbine was mailed to each of five Remington Regional Managers. A cover letter by R&D Ilion, dated October 1964, requested complete and confidential evaluation of each carbine.

All five carbines were telescope mounted (# 294 Redfield) and each shipment included 120 rounds of ammunition -- 60 rounds of 200 grain and 60 rounds of 250 grain weight.

Reports were received during the months of November and December from each of 5 regional offices; i.e.,

1. Berkeley, California	D.L. Braun/L.G. Dick
2. Cleveland, Ohio	C.W. Roney/
3. St. Louis, Missouri	M.D. Berkeley/G.T. Porter
4. Dallas, Texas	E.B. Spencer/Dewey Godfrey, Jr.
5. Memphis, Tennessee	J.C. Ridley/G.W. Martin

These reports have been reviewed and summarized in categories below:

**APPEARANCE** - was considered attractive, excellent, or well designed in three (3) of the five (5) reports. No objectionable comments were noted in the remaining two (2) reports. One report mentions "impression of custom made rifle"; another "unique - will add materially to consumer acceptance".

**CARRYING, HOLDING, POINTING, etc.** - generally rated as excellent in two (2) reports. Nothing of a negative nature appeared in other reports. This bears out R&D early prediction in this respect. "Well designed" was listed in the final analysis of one report.

**ACCURACY** - was generally rated as outstanding in all reports. Bench rest group of 1 1/2 inches and "very fine" ten shot groups at 100 yds. was noted in two (2) reports. Excellent 3-shot groups were noted in a third (3) report.

Offhand accuracy at 50 yards was quoted as "surprising" and very acceptable in one report.

A point of impact variation from 4 to 7 inches was noted when using the 250 grain ammunition in two (2) reports.



LONG EYE RELIEF SCOPE - was listed as excellent in two (2) of five (5) reports. No criticism in a third report, a "growing desirability" in another. A fifth report was not particularly clear as to adaptability of telescope mounting.

RECOIL - was considered as heavy to severe in all five reports. Most reports listed this as expected and not particularly abusive. "No discomfort" was the phrase used in one report. Muzzle-jump during bench shooting was noted. Recoil during offhand shooting was considered generally as not objectionable. Double recoil pad was suggested in one report.

MUZZLE BLAST - this appears to receive the strongest criticism. Two test results reported pain or "ringing in ear" sensations. Two reports made no mention of blast. A fifth termed it terrific for bystander but not objectionable to shooter.

FUNCTION - this includes all phases of operation and was considered as excellent in one report, smooth and positive in another. No objection was noted during firing, trigger pull, extraction, or ejection. Two reports mentioned difficulties in feeding from magazine and one on bolt closing or chambering the cartridge. Feeding from a full magazine or last cartridge from magazine was noted in these two reports. An unstable magazine follower was noted in this last malfunction.

A blunting of cartridge nose (P.S.P.) in magazine was found quite objectionable in one report and not so in another.

An audible safety snap was termed as "unwanted" in one report.

ACCEPTANCE - generally noted as good. Reports listed such phrases as:

- "Enjoy good sales ... if price is right."
- "Big seller in some sections of country."
- "Should be accepted by hunters who want an extra light weight MAGNUM".
- "Another winner in the making."

JFF:T  
(for F.E. Morgan)



cc: G. M. Calhoun  
D. S. Foster-R. A. Gravel  
R. M. Malcom  
Wayne Leek-Illian

Bridgeport, Connecticut  
December 9, 1964

W. L. PENN

350 REMINGTON MAGNUM

Salesmen test firing the 350 Remington Magnum in the 600 Rifle have reported feeding difficulty. The edge of the shell mouth picks up on the leading edge of the chamber as the shell is fed into the chamber.

I have not seen shells that caused this trouble but the sales personnel that have experienced this believe it is due to a light crimp on the shell mouth.

During the next loading of 350 Remington Magnum ammunition, care should be taken to assure a good mouth crimp. If this is done and the problem still exists, a look into the chamber design will be in order.

*RED*  
Rex E. Dickey  
Senior Research Engineer  
Bridgeport Research Division

RED:JR



cc: R. B. Davis  
J. B. Calhoun-R. Perea  
G. M. Calhoun  
F. E. Mangan  
E. J. Buchanan-V.C. DeLeon  
M. E. Walker  
✓ W. E. Lock-R. B. Hall ②

*M600  
Design*

Bridgeport, Connecticut  
December 2, 1964

TO: S. M. ALVES  
Ilion, New York

FROM: WILLIAM B. VUONO

Dear Sam:

This will refer to your memo of November 30.

We consider your suggestion to send a sample bolt incorporating the thread an excellent one. This, incidentally, ties in with our Australian distributor's request for a sample Model 600 which would be modified to incorporate the bolt thread and, in addition, indicate the 'fire' and 'safe' position markings which are required by the Australian authorities. This latter has been the subject of previous correspondence and will be at an additional charge. This subject is treated in R. L. Hall's memo of October 6, 1964. (See copy attached.)

Accordingly, in your absence, I spoke to Bob Hall to arrange for R & D to supply a Model 600 which would be modified as indicated above. I subsequently placed an export order for the account of our distributor, Main Wood Pty. Ltd., to be shipped by air parcel post, with the notation on the facing sheet that R & D would make up this gun.

We will advise you as soon as we receive word from our distributor if the Model 600 so modified will meet the Australian regulations.

In passing, I note that your memo of November 30 speaks also of the Model 700 with the threaded bolt. Actually, we are only concerned in Export with the Model 600 with a threaded bolt.

Regards.

*WV/jjs  
cc'd*



RECEIVED

OCT 7 1964

P. H. BURDETT

RECEIVED

OCT 7 1964

VICE PRESIDENT AND  
DIRECTOR OF PRODUCTION

cc: R.A. Williamson  
S.M. Alvis  
W.E. Leek  
H.J. Huckman  
V.G. DeReus  
A.D. Kerr  
F.T. Plunkett  
Estimate File #2512

Ilicon, New York  
October 6, 1964

H. K. PAULNIER (2)  
ATTENTION: C. L. JONES

MODELS 700 AND 600 SAFETY MARKINGS FOR EXPORT

Estimates indicate an additional factory cost of ninety cents (\$.90) per gun for the proposed safety position markings.

Receiver tangs under the safety will be engraved as follows:

1. A letter "S" in the rear position indicating "Safety On".
2. A letter "F" in the front position indicating "Ready to Fire".

Estimated costs are based on these assumptions:

1. Custom Repair will unpack warehouse guns.
2. Custom Repair will engrave and paint markings.
3. Custom Repair will repack and label for warehouse.

R. A. Williamson  
Works Manager

*R. L. Hall*  
R. L. Hall, Supervisor  
Methods & Standards Section

RFKerr:sm

*Provided addressed  
orders in memo  
of 100 are placed*



G-88

*W* DON'T SAY IT—WRITE IT *Devin*

TO G. M. CALHOUN

DATE Sept. 25, 1964

FROM S. M. ALVIS

We should tell you that the Delrin rib on the M/600 barrel may cause trouble from overheating in rapid fire. When change was made from nylon it was known that the melting point was about 100° lower. *Q* actual testing ~~When~~ firing 20-30 rounds rapid fire, temperatures go up to a little under 300° and causes melting at the bases. Firing beyond this point with higher temperatures is rather "disastrous".

Wayne is having more complete test and evaluation in the event we have to change material again.

SMA:T

TO BE SAFE, FIRST THINK YOU MIGHT NOT BE



# LIMITED DISTRIBUTION

REMINGTON ARMS COMPANY, INC.  
Illon Research Division  
October 7, 1964

## DESIGN STATUS

MODEL 600 - 350 MAGNUM

① The accuracy testing of this model was to have been conducted during the vacation period in August but due to some difficulties encountered with the bolt mechanism this test was not initiated until approximately six weeks later. Unfortunately several difficulties were encountered affecting the accuracy of the 350 Mag. - M/600 combination. The first difficulty encountered was that of the 200 grain soft point core lukt ammunition which was loaded too low in velocity and pressure, with resulting poor accuracy and extreme drift and drop in point of impact between 100 and 200 yards. This has been since corrected to higher pressures which are not above normal, with associated increase in velocity, resulting in a more reasonable accuracy and less point of impact shift between 100 and 200 yards.

As the testing progressed it was noted that due to the heavy recoil encountered in the 350 and the extreme amount of heat generated by such a cartridge, something was affecting the accuracy of the barrel during continued group shooting. Also it was noted that the action itself was shifting in the stock. This had not been previously encountered by other calibers and it was believed that excessive recoil was uncovering some inherent bedding problem in the M/600. A testing program was initiated to determine the cause of the problem, and the results show that the nylon rib on the barrel must be absolutely free and floating on the studs so that its rigidity would not interfere with the functional vibrations of the barrel during its changes due to heating and cooling.

It was also noted that an increase in barrel weight was needed to eliminate excessive vibrations encountered in the 250 grain bullet which caused a shift of point of impact of about 12 inches between the two bullet weights at 100 yards.

It was also noted that the violence created by the heavy recoil of this caliber was placing undue stress on the receiver tang which in turn was compressing the wood in the stock and eventually changing the point of impact of the barrel-receiver combination. The insertion of a reinforced nylon plug in that area eliminated this problem.

As testing progressed it was noted that the action always rotated to the left, this being due to the counter-moment incurred by the twist of the rifling and a poor bedding support. This counter-moment has been nullified to the point where it is non-effective by bedding the barrel bracket with an epoxy type material.



10-7-64

Some feeding difficulties have been encountered with the large round nose bullets in the 200-250 grain bullet and several magazine designs have been tested with some degree of success. These are rather minor difficulties, and it is believed that to eliminate the problem entirely more guns will be needed to complete this type of testing. It may be that the final design adjustment to the magazines cannot take place until after a production run of several hundred guns is made so that a complete test will reveal the inherent problem.

With the additional weight of the heavier barrel which was mentioned previously there will be a reduction in the weight that is located in the forepart of the stock, with a possible chance of complete elimination of this part. This can be determined as soon as the experimental barrel is made, weighed and balanced into the stock.

Completion of these items with the exception of the final changes in the magazine may be made sometime next week, and in the meantime drawings will be furnished the Process Engineering Department for their evaluation and introduction into the Plant,

W.E. Leek:T



*Tracy*  
F. B. MORGAN  
Bridgeport

*H. J. Stockman*  
Ilion, New York  
September 2, 1964

*Design*  
**MODEL 600 - BOLT PLUG**

Foreign Sales needs to change the bolts in the Model 600 in order to meet the safety requirements. I have prepared a sample of what might be done in the way of extending the bolt plug in order to act as a shroud for the firing pin head. I don't think anything else was done with it, and if to be done it would be applicable to all M/600's.

The change to the unit cost would be negligible; however, would expect a one time tooling change cost to be involved. It could be used as an added sales feature.

On September 2, 1964, I presented this to the Foreign Sales Committee for follow-up through Operations Committee. Sample rifle is here at Ilion and I will ask the Plant to give us an estimate of cost for making the change.

S. M. Alvis  
Ilion Research Division

SMA:T



G-28

## DON'T SAY IT—WRITE IT

To H. J. WATERMAN

DATE Aug. 21, 1964

FROM W. E. LEEK *WEL*

### MODEL 600 - 22-250 Caliber

After further discussion with V.G. DeReus, who called F.E. Morgan concerning this caliber and gun in which it was to be used, it appears that the 22-250 may not be introduced into the M/600 this year. The present thinking of the Sales Department is that they want to put this out as a prestige item. If it is introduced in the M/600 in the ADL version it would have to sell for \$135, which is a very close figure to the BDL M/700 at \$139.95.

So I believe that although we must continue to provide what little information is necessary and perhaps continue to do some testing in this M/600 with the new caliber, the final decision will be made that it will not be introduced in the M/600 this year.

WEL:T

TO BE SAFE, FIRST THINK YOU MIGHT NOT BE



cc: M.H. Walker  
R.B. Hurley  
L.J. Boyle

*R.P. Kelly*

Ilion, New York  
August 19, 1964

TO: V. G. DE REUS

FROM: W. E. LEEK

GAS RELIEF HOLE - M/600 BOLT HEAD

As a result of tests conducted by the R&D Test Section (C.B. Workman, report dated 8-12-64) the gas relief hole will be removed from all M/600 and XP-100 bolt heads.

Final Drawing: Transmittal will be delayed until completion of further

~~M/700 tests; however, removal of this operation in~~

M/600 and XP-100 bolt heads should be effected as

soon as feasible to production operations.

*W. E. Leek*  
W. E. Leek  
Firearms Design & Development  
Ilion Research Division

HJW:WEL:T



## REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE

*Remington*  
DUPONT*PETERS*  
DUPONT

"CONFINE YOUR LETTER TO ONE SUBJECT ONLY" \_\_\_\_\_

8/19/64

W. E. Leek

## GAS RELIEF HOLE/M600 BOLT HEAD

As a result of tests conducted by the R & D Test Section (C. E. Workman, Report Dated 8-12-64) the gas relief hole will be removed from all M600 bolt heads.

Final drawing: Transmittal will be delayed until completion of further M700 tests, however removal of this operation in M600 bolt heads should be effected as soon as is feasible to production operations.

Harold Waterman

HW:bs



*ngdr* *rbh* *efb* *ngdr* ?  
GAS RELIEF HOLE / M600 BOLT HEAD

AS A RESULT OF TESTS CONDUCTED  
BY THE R & D TEST SECTION (C.B.  
WORKMAN, REPORT DATED 8-12-64)

THE GAS RELIEF HOLE WILL BE REMOVED  
FROM ALL M600 BOLT HEADS.

FINAL DRAWING: TRANSMITTAL WILL  
BE DELAYED UNTIL COMPLETION OF  
FURTHER M700 TESTS, HOWEVER  
REMOVAL OF THIS OPERATION IN M600  
BOLT HEADS SHOULD BE EFFECTED AS  
SOON AS IS FEASIBLE TO PRODUCTION  
OPERATIONS

W.E. LECK.



February 19, 1964

In either of the foregoing assemblies, the rearward cantilever extension of the scope tube would not exceed the length that is often seen extending forward of conventional bridge type mounts. It would certainly be less than that observed with some side mounts. The arrangement might even facilitate loading, since only the scope tube itself would project over the loading port.

The second stud would also allow the rear open sight to be more securely attached at the factory. We claim that the nylon rib floats on the barrel, thus the rear of the open sight must also float in the present assembly. The extent of such movement may be negligible in practice but it is subject to criticism in principle.

We have ordered one of the new Redfield, long eye relief, scopes that are being produced for M/94 Winchester rifles. Redfield offers a mount for this scope to fit M/600 rifles. One assumes, from the sales brochures, that this assembly mounts only on the receiver ring. If this is the case, and if the mounting screws hold under recoil which past experience leads one to doubt, this might be a satisfactory combination for the M/600. It is believed, however, that dependence on one manufacturer's product for attainment of proper eye relief constitutes an undesirable limitation.

It is believed that by exercise of the technique discussed herein we can provide more latitude in scope mounting than is available with any competitive rifle, and that the added sales appeal will more than compensate for the inconvenience of making a change in production.

WLDahl:T



cc: W.E. Leek  
R.A. Williamson - H.J. Hackman

Ilion, New York  
September 22, 1964

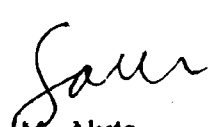
F. E. MORGAN  
Bridgeport

**MODEL 600 - BOLT PLUG**

Foreign Sales needs to change the bolts in the Model 600 in order to meet the safety inspection requirements. Quite sometime ago Wayne Leek prepared a sample of what might be done in the way of extending the bolt plug in order to act as a shroud for the firing pin head. I don't think anything else was done with it, and if to be done it would be applicable to all M/600's.

The change to the unit cost would be negligible; however, would expect a one time tooling change cost to be involved. It could be used as an added sales feature.

When asked again about this today I suggested that Foreign Sales initiate for follow-up through Operations Committee. Sample rifle is here at Ilion and I will ask the Plant to give us an estimate of cost for making the change.

  
S. M. Alvis  
Ilion Research Division

SMA:T



cc: S. M. ~~Alvis~~ ✓  
H. J. Waterman

Ilion, New York  
September 4, 1964

H. J. HACKMAN

I have been having considerable accuracy difficulties caused by improper inletting of the stock in the M/600, and have asked Harold Waterman to discuss this problem with your personnel to determine what efforts are being made as to correction.

After looking over a considerable number of M/600's since they have been in production last year I don't believe I have ever seen one where the fore end wasn't touching the left side of the barrel and was advised at that time that correction would be made.

Now that we are involved in a laminated stock and a more expensive gun it would seem past due time to make this correction and effort should be made to accomplish this before manufacturing the new stocks.

Attached is a report from Harold to me regarding the above.

  
W. E. Leek  
Firearms Design & Development  
Ilion Research Division

WEL:T  
Attach.



cc: S. M. Alvis  
H. J. Waterman

Ilion, New York  
September 4, 1964


H. J. HACKMAN

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Attached is a report from Harold to me regarding the above.

  
W. E. Leek  
Firearms Design & Development  
Ilion Research Division

WEL:T  
Attach.



## REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE



"CONFINE YOUR LETTER TO ONE SUBJECT ONLY" \_\_\_\_\_

## MEMORANDUM

Ilion, New York  
September 3, 1964TO: W. E. LEEK  
FROM: H. J. WATERMAN

## M/600 STOCK INLETING

According to a study made by Quality Audit on 5-5-64 a number of receiver and barrel seat cuts in the inletting of the M/600 have been classed as uncontrollable.

Observation of assembled rifles shows that a predominance of the barrel assemblies do not lay central in the receiver-barrel groove seat.

At the present time Bill Fagerstrom of E.S.D. is modifying the present manual mechanical clamping system on the inletting machines to a pneumatic mechanical system. This modification is being thought of only as a cost reduction item. It should give a more uniform method of clamping, and therefore perhaps better quality. However, this modification is not geared to finding a way to clamp the stock blank more rigidly or with more pressure points in the critical areas.

It would seem a joint effort by E.S.D. and Process Engineering at this time, to work out a more uniform clamping system and at the same time a more rigid system, would perhaps save duplication of effort in the future. With the walnut stock this is a bad situation, and with the laminated stock a bad situation will become critical.

HJW:T



W. E. Teek

-2-

October 23, 1963

In the matter of cost one supposes that the substitution of one piece headed bosses for the attaching screws numbers 3, 4 and 5 would work an economy that should offset the added cost of the past molding operation that might be used to cut the T-slots in the rib. In any case this modification proposed is offered for discussion with the appropriate operating officials and disposition as you see fit.

W. L. Dahl  
Firearms Design & Development

WLD:T



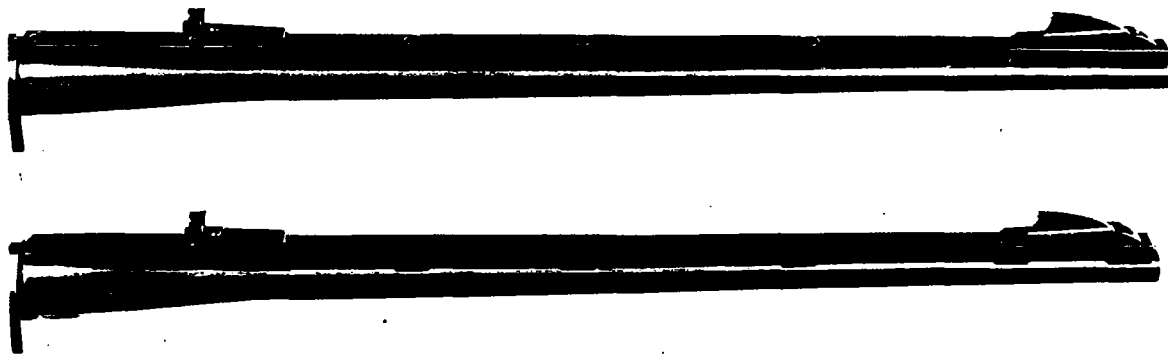


Figure 1: The Model 600 barrel rib at top has 4 attaching screws visible as compared with none in the modified barrel. The filler plugs that show in the prototype rib would not be required in a production model.



Figure 2: The countersink head screw at left enters a dovetail slot in the rib and the three headed bosses engage the T-slots when the rib slides in place from front to rear.



*Jim  
Peters & Sales  
Duroy aware of this  
I told them at the Sports  
writers meeting in*

cc: G.M. Calhoun  
H. J. Hackman

Ilion, New York  
December 5, 1963

F. E. MORGAN  
Bridgeport

*Design*  
MODEL 600 TRIGGER GUARD

Several field test reports commented about the finish of the trigger guard as being too "shiny" and tended to look "cheap". This is an item that I had "picked on" long ago, but failed to follow up to have it corrected.

Wayne Leek has requested the Plant to use a matte finish which will approximately match that of the molded rib. This should be going into effect immediately, and I have asked H.J. Hackman not to wait for any action of Operations Committee or Sales since the need is so obvious. Right at the moment this is being done as a supplementary operation; however, at a later date perhaps can be taken care of by a treatment to the finish of the mold.

Per telephone conversation it is agreed that we should add this same treatment to the field representatives' samples before they are shipped, even though may delay at least 4 or 5 days.

S. M. Alvis  
Ilion Research Division

SMA:T



cc: D.S. Foote  
E.A. Rickey  
S.M. Alvis  
F.E. Morgan

Ilion, New York  
December 3, 1963

MARTIN W. KORDAS  
Bridgeport

Thank you for your recent letter concerning the testing of the new Model 600 Rifle in the 308 Caliber. You are quite right that the action in the Model 600 is the XP-100 receiver with the exception of the bottom cuts which involve magazine and its feeding.

On occasion there is some interest in developing a bull pup type rifle. This has been discussed with sports writers, commercial gun designers, and also the military. There are very few people interested in the bull pup version for two reasons. From a point of safety, it is undesirable for the shooter to place his cheek near the chamber section of a gun. There are two or three things which can occur in this area. A plugged barrel will allow a barrel to split, no matter how strong the barrel may be, and regardless of the strength of the action. Also, if a cartridge case fails, even in the shrouded head bolt design of this model, a certain amount of gas leakage and the resulting particles of brass will fly out of the receiver and around the bolt. This would put the shooter's head and face and eyes in jeopardy. It is more desirable to have the shooter's head in a rearward position from the receiver as oftentimes an accident as explained above could be averted in that the gas escapes in an outward direction, and at least the shooter's head and associated parts of that portion of the body would be spared.

I have made an inquiry on several occasions with sports writers and others and there appears to be no market for the bull pup idea. One other disadvantage of this type of design is the awkward position in which the operation of the bolt must take place.

Thank you for your interest. If we see anything in the future that indicates possibility of a requirement for a bull pup version in this model, we will certainly make up one.

*Wayne E. Leek*  
W. E. Leek  
Manager - Firearms Design & Development  
Ilion Research Division

WEL:T



## REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE



cc: D. S. Foote  
E. A. Rickey  
S. M. Alvis  
F. E. Morgan

Bridgeport, Connecticut  
November 20, 1963

*W. E. LEEK*

REMINGTON MODEL 600 RIFLE

At the request of F. E. Morgan, Rex Dickey and I test fired the new 308 caliber Model 600 rifle. We were both impressed by its compactness and 100-yard accuracy. It was noted that the barreled action is essentially that of the XP-100 pistol, and it was mentioned that the rifle would also be made for cartridges in the varmint classification.

Some consider the XP-100 as being a "bull pup" pistol. Has Remington considered a "bull pup" version of the Model 600 for the varmint cartridges? My experience with "bull pup" varminters has left a desirable impression, but to my knowledge there are none commercially made today.

*Martin W. Kordas*  
Martin W. Kordas  
Research Engineer

MWK:MR



M/600  
Design

Ilion, New York  
December 16, 1963

T. R. FRYE  
Billings, Montana

Dear Tom:

Thanks for your SpeedMemo concerning the Model 600 and the fine pictures showing you with the mule deer that were killed with this new model. And now to answer some of your questions.

I'll have a M/600 experimentally made up for the 223 for you to test sometime in the first quarter. Right now we are being pressured to get out the M/600 and the M/1100 in the 20 and 16 Gauges, and haven't had the time to experiment further, but will keep you advised. When we send this experimental gun I will also furnish sufficient ammunition and fired cases for it for your handling.

I agree with you that the belted case is an excellent feature and I fear that you are correct in stating that the 224 Weatherby will sell. Perhaps we can put this cartridge or one similar to it in the M/600. Would you please advise me as to its total length.

As pertaining to the 224 in the M/700 BDL with stainless steel barrel, I would suggest that you contact the right people in Bridgeport and recommend this combination to them, as this is where it should originate.

I haven't seen the M/600 that you are returning containing accuracy problems, but will get at it as soon as it is available. The one furnished you was test fired by two or three individuals here and seemed to be fairly accurate. The groups I saw were round and in the neighborhood 1 3/4" to 2" at 100 yds. I feel that the difficulty you obtained in the M/600 you had was not inherent in this model and must have something to do with the interior of the barrel, but will advise you as to my findings.

Best wishes to you and your wife for a very Merry Christmas and Happy New Year.

W. E. Leek,  
Manager - Firearms Design & Development  
Ilion Research Division

WEL:T



*Airtel Special*

REMINGTON ARMS COMPANY, INC.

**SPEED MAIL**Date 12-7-63

Message To:

Wayne Seek

Subject:

various-

From:

Don FreyDear Wayne:

- Rec'd air express tonight the 600. It will get to the Browman.
- 1- How soon on the 223?
  - 2- Can you send one to use on varmints for a report to you.
  - 3- Also can you send a dozen fired ones?
  - 4- I know this 224 Weatherby will sell. Velocity and Belted case. It's feels the same.
  - 5- What is your feeling on belted case? Even tho it may not be needed.

ORIGINATOR—DO NOT WRITE BELOW THIS LINE

12/10/63

FROM:

6. The 224 vel. 3900 f.s. - How about we making the 700 BDL in 24" stainless steel and priced retail 154.95 or such. Premium velocity - Premium Price. We will steal Weatherby's business. Not available in A.D.L.

7. Here are pics of 3 diff. deer. You may have a copy. m-1600.

Would like to hear from you. Thanks  
you

ORIGINATOR OF MESSAGE: 1. Write message legibly in space provided. 2. Detach and keep yellow copy for your file or follow-up. 3. Send white original and pink copy with carbon between—do not separate.

RECEIVER OF MESSAGE: 1. Write reply legibly in space provided. 2. Detach pink copy for your file. 3. Send your reply to Originator.



H. J. H.

MAIL TO

DEPARTMENT

LOCATION

SUBJECT

DATE

MESSAGE

and  
dis  
Salem  
to have  
with  
open  
more soft  
also

ORIGINATOR - DO NOT WRITE BELOW THIS LINE

SIGNED

REPLY

had the rifle checked by Mike & he  
seemed to like the size of the 7.5 head

ec - [signature]

DEPT.-LOCATION

SIGNED

DATE

REPLY COPY



RD-44-B

REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE

Remington  
OUTPOST

PETERS  
ALPHA

cc: S. M. Alvis  
H. J. Hackman  
W. A. Best

CONFINE YOUR LETTER TO ONE SUBJECT ONLY"

Ilion, New York  
July 8, 1963

W. E. LEEK

FRONT SIGHT BEAD

An outdoor test was held July 3rd, 1963 to determine a possible difference in the sighting qualities of the two proposed Model 600 front sight beads. The diameters of the beads measured .075 and .095.

Shooting was done from a bench rest at a range of 100 yards. A standard open rear sight was used. Ammunition used was Cal. 308 - 180 gr. P.S.P. Remington factory loads.

Three shooters each fired three shot groups with each diameter sight bead. The three groups averaged as follows:

Fine Bead (.075 dia.)	2.96 inches
Coarse Bead (.095 dia.)	2.93 inches

Next the shooters were asked to determine, from personal observation, the qualities of the different diameter beads in a "snap" shooting situation. Two stated the .095 dia. bead showed better light gathering qualities, while the third could detect no distinct difference.

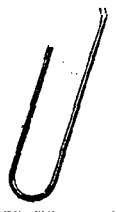
H. J. Waterman

H. J. Waterman  
Firearms Design & Development

HJW:T



File  
MLO



Dr. Smith

350 Remington Short Magnum

7/11/63

Loads have been established for the 350 Remington Short Magnum cartridge in the Model 600 rifle. Accuracy samples are being loaded for firing tests.

To aid in the evaluation of the new cartridge, a comparison has been made of the 350 Remington Short Magnum with the 7 mm Remington Magnum and the 30/06 Springfield.

<u>Product</u>	<u>Bullet Weight (Gr.)</u>	<u>Corrected Velocity (ft/sec)</u>	<u>Energy</u>	<u>Ave. (Max.) Press. Spec. (lb/sq.in)</u>
350 Rem. Short Mag.	150	3315	3610	54,000
	200	2900	3730	54,000
	250	2555	3570	54,000
7 mm Rem.	150	3260	3540	52,000
	175	3070	3660	52,000
30/06 Springfield	150	2970	2930	50,000
	220	2410	2830	50,000

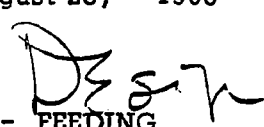


## REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE

*Remington*  
REMINGTON*PETERS*  
PETERScc: L. J. Boyle  
V.G. DeReus  
R.P. Kelly

"CONFINE YOUR LETTER TO ONE SUBJECT ONLY"

Ilion, New York  
August 23, 1963W. E. LEEK   
MODEL 600 - 222 - FEEDING

The investigation of feeding of the Model 600, chambered for 222 Rem. cartridge, has revealed the following information. Test results indicate feeding should be satisfactory if the following measures are taken.

The loading ramp cuts must be milled out with proper surface finish maintained. Grinding of these cuts is not adequate.

The follower spring shape must be maintained. Reworked springs are adequate; however, not the most desirable.

The .020<sup>R</sup> on the underside of the rails must be maintained. Failure to maintain this radius results in a condition which greatly increases the chances of stemming at "3 and 9 o'clock" on the chamber mouth.

Model drawing dimensions must be maintained in each of the above cases.

H. J. Waterman  
Firearms Design & Development

HJW:T



XC-13 - C.F. BOLT ACTION LIGHT WEIGHT RIFLE

4-26-61

1. Calibers to be investigated      222 Reg.  
   222 Mag.  
   30-30  
   44 Mag.  
   308  
   35
2. Receiver 3/4" shorter than M/722
3. Barrel 18½" overall
4. Nylon stock

R.P. Kelly  
~~W.E. Leek~~ *W*  
R.L. St. John  
J.A. Roberts



## DON'T SAY IT—WRITE IT

To D. S. MOOTE - BridgeportDATE March 8, 1962FROM S. M. ALVIS - Ilion

XC-13

MODEL 600 - LIGHT WEIGHT BOLT ACTION CARBINE RIFLE

The above is a new designation the Sales Department has requested be used for this rifle which was formerly called XC-13. The present approved development project is on basis of Calibers 308, 222 Rem. and 30-30. However, the designers have anticipated the need and desire for considering future possibilities of short magnum cartridges in this rifle.

G.M. Calhoun suggested that we first review the idea and characteristics with Gail Evans in order that Sales visualize how it might be best marketed or fitted into the line, and then be able to supply the needed forecast to support any such developments. This has been done and there seems to be a definite interest, but with desire it not be considered to be included with the first production of the above model. But if proven feasible may be developed as a potential item along with further improvements to the rifle that have been envisioned.

There is a Caliber 35 short magnum and perhaps another model 7mm short magnum proposed for this rifle, and our ideas including technical data are being discussed today with Messrs. Toulson and Dickey. They will probably take back some of the information and materials with them. This should give you folks sufficient time to review before we have our first R&D staff visitation as proposed in another letter today.

S. M. Alvis  
Ilion Research Division

SMA:T

cc: G.M. Calhoun  
R.E. Evans  
W.H. Walker - W.E. Look  
File

THERE IS A SAFE WAY; DO IT THAT WAY



MODEL 600  
Costs & Estimates

*Remington-Union*  
CATALOG NO. 5018 R • IF FASTENERS  
ARE TO BE INCLUDED PLEASE SPECIFY.  
**REMINGTON-TEX FOLDER**  
MADE IN U.S.A.



cc: R.A. Williamson  
~~S.M. Alvis~~ In  
W.E. Leek ) turn  
L. Fox ) In  
V.G. DeRous ) turn  
D.E. Geiss  
Estimate File #2587

Ilion, New York  
September 2, 1966

J. A. ROBERTS

REVISED ECONOMICS FOR INTRODUCTION OF MODEL 660  
(UPGRADED VERSION OF THE MODEL 600 RIFLE)

The economics have been revised to include the magnum grade of the above guns. The volumes have been split as follows between the regular and the magnum guns:

	<u>Present M/600 Rifle</u> <u>Anticipated 1967 Forecast</u>	<u>Proposed M/660 Rifle</u> <u>Anticipated 1967 Forecast</u>
Regular	9,600	16,000
Magnum	2,400	4,000
Total	12,000	20,000

The return on investment has been revised as indicated below:

	<u>Estimate dated 8-19-66</u> <u>(w/o Magnum)</u>	<u>Revised Estimate 9-2-66</u> <u>( with Magnum)</u>
Position A & B	48.3 %	47.9 %
Position C	39.2 %	39.0 %

*F. G. Carlson*  
F. G. Carlson, Supervisor  
Methods & Standards Section

att.  
FGC:sm



# ESTIMATED FACTORY COSTS AND ECONOMICS FOR UPGRADED MODEL 600 CENTER FIRE CARBINE

(308 6MM Y43 YYY 35 CALIBERS)

MAGNUMS NOT INCLUDED IN COSTS BELOW

MENT

	BEFORE - CURRENT DESIGN				AFTER - UPGRADED VERSION				TOTAL CASH	CASH RESULT	TOTAL CASH RESULT
	PRESENT 308 CAL	MAGNUM 308 CAL	PRESENT 308 CAL	TOTAL CASH	UPGRADED 308 CAL	MAGNUM 308 CAL	UPGRADED 308 CAL	TOTAL CASH			
VOLUME - MAGNUM (NOT INCLUDED)				(2,400)				(4,000)			1,600
- REGULAR				9,600				16,000			6,400
RETAIL PRICE	99.96	144.95			119.95	144.95					
NET SELLING	53.87	78.10	53.87	517,100	64.63	80.82	64.63	1,039,100	22,300	517,000	25,900
STD MATERIAL	8.05	11.90	8.05	27,300	8.59	12.43	8.59	137,400	22,200	60,100	81,200
VARIANCE	40	60	40	3,200	43	62	43	6,200	2,500	3,100	4,200
STD LABOR	5.99	7.17	5.99	57,500	7.00	7.49	7.00	112,000	22,000	54,500	67,300
VARIANCE	350	1.80	2.15	17,300	7.10	2.25	7.10	33,600	2,000	16,300	20,100
BURDEN	13.48	11.69	9.76	93,200	15.75	12.71	11.41	182,600	22,500	89,200	109,700
ADDL DEPRECIATION											
SUB-TOTAL	19.74	23.51	16.00	249,000	33.87	35.16	19.69	475,100	40,600	225,500	285,700
PLANT OVERHEAD	6.69	8.10	7.08	7,500	7.67	10.00	8.11	14,600	3,900	7,100	8,800
FRANCHISE TAX		1.73	1.07	10,300		1.72	1.35	21,500	7,100	11,200	14,100
INVENTORY ADD	36	36	18	2,700	41	37	37	5,100	1,500	2,400	3,000
FACTORY COST	36.77	36.53	28.13	272,100	41.90	33.92	32.77	516,300	53,100	246,200	311,600
SELLING AND ADMIN.	5.39				6.46						
RESEARCH	7.15				7.59						
TOTAL COST	49.31	36.53	28.13	220,100	50.95	33.92	32.77	516,300	153,100	246,200	311,600
OPER. EARNINGS	9.56			247,000	13.68			517,800	170,200	270,800	341,300
% OF NET SELLING	17.7%				11.1%						
LESS: 6% AND 4% 1/2				127,300				266,900	87,700	158,600	175,900
NET EARNINGS				119,700				250,900	82,500	131,200	165,400
INVESTMENT				UPGRADING FEATURES							
CONSTRUCTION				1. DELETE BARREL RIM AND STUD							
WORKING CAPITAL				2. Y.Y. MAGNUM TYPE BARREL							
TOTAL				3. M100 TYPE FLARE AND FUSE SIGNS							
RETURN ON INVESTMENT				4. ADD M100 TYPE BARREL AND STUD							
POSITION A AND H				5. ADD FUSE END TIE AND STUD							
POSITION C AND D (1.5%)				6. ADD BUTT PLATE SPACER							
MENT AND OPER. CHG.				7. REPAIRS TO EXPORTS							
				8. RAW FINISH							
								WORKING CAPITAL - RESULT			
								RAW MATERIAL 314 X 85,400			
								WORK IN PROCESS 136 X 31,100			
								FINISHED GOODS 167 X 31,100			
								CASH RECEIVABLE 100 X 25,300			
								CASH 148 X (31,100 - 3,000)			
								339,700			
								418,100			
								345,400			
								478,200			
								423,600			
								REVISED P. K. L. F.			
								8.17.66			
								REVISED 9-24-66			



**DON'T SAY IT—WRITE IT**

cc: V. E. Leek  
C. W. Stephan

TO L. L. DAHL

DATE Nov. 7, 1966

FROM R. L. SASSONE

**M/600 MANNLICHER**

Attached are sheets showing R&D estimates of standard labor and material.

The estimates are based on the proposed M/660, with export firing pin assembly and M/700 Mannlicher.

Estimates are as follows:

Sta. Labor	\$7.33
Sta. Material	9.74

RLS:T

TO BE SAFE; FIRST THINK YOU MIGHT NOT BE



R&D ESTIMATES  
600 MANNLICHER

R. J. SASSONE 11-4 '66

BASE GUN - M. 600 308 CAL

STD LAB. 5.99  
STD MAT. 8.05

PROPOSED MANNLICHER

STD LAB. 7.33  
STD MAT. 9.74

DIFFERENCE OF

LAB. 1.44 ✓  
MAT. 1.69 ✓

CHANGES ARE AS FOLLOWS:

STOCK & STOCK ASSEMBLY  
FIRING PIN ASSEMBLY (EXPORT)  
FRONT & REAR SIGHT 100  
FRONT & REAR SWIVELS  
BARREL

ESTIMATES ARE BASED ON 660 & ESTIMATE  
700 MANNLICHER STOCK.



PARTS LIST		MODEL 600 MANNLICHER				DATE	
		Bolt Action - Center Fire Carbine				11-4-66	
		R.D. ESTIMATES - R.L. SASSORLE				11-5-66	
Dotted line (-----) indicates same part number.						Sheet 1 of 3 sheets	
DWG. NO.	NAME	308 Win.	6MM Rem.	243 Win.	222 Rem.	STD LAB/C	STD MAT/C
D-29860	BARREL ASSEMBLY	29860	29863	29865	29861	172.28	156.61
D-29850	Barrel (Marking B-15729)	29850	29853	29855	29851		77.24
B-15647	Barrel Bracket (Blank B-15646)	15647	-----	-----	-----	4.50	19.30
B-29885	Receiver (Marking B-14398)	29885	-----	-----	29886	104.14	60.07
B-29890	BOLT FINAL ASSEMBLY	29890	-----	-----	29891		
B-29870	BOLT ASSEMBLY	29870	-----	-----	29871	16.01	
D-26710	BOLT BODY ASSEMBLY	26710	-----	-----	-----		
D-26780	BOLT BODY ASSEMBLY	-----	-----	-----	26780	(33.5)	(41.88)
C-15407	Bolt Body (Blank C-28505)	15407	-----	-----	-----		
A-18493	Bolt Body Brazing Slug	18493	-----	-----	-----		
C-15479	Bolt Head	15479	-----	-----	-----		
C-15851	Bolt Head	-----	-----	-----	15851		
A-18758	Bolt Pin	18758	-----	-----	-----		
B-17011	Ejector Washer	17011	-----	-----	-----		
D-15408	Bolt Handle	15408	-----	-----	-----	7.15	49.95
C-20185	Brazing Shim	20186	-----	-----	-----		.62
A-17017	Ejector	17017	-----	-----	-----		
A-15852	Ejector	-----	-----	-----	15852	.05	6.26
A-17676	Ejector Pin	17676	-----	-----	-----	.01	.30
A-17019	Ejector Spring	17019	-----	-----	-----		1.39
B-16254	Extractor	16254	-----	-----	-----		
C-15850	Extractor	-----	-----	-----	15850	.03	29.50
C-27340	Extractor Rivet	27340	-----	-----	27342		2.39
A-28600	FIRING PIN ASSEMBLY - EXPORT	28600	-----	-----	-----	(19.90)	(116.38)
C-15676	Bolt Plug (Blank C-15674)	15676	-----	-----	-----		
B-15410	Firing Pin	15410	-----	-----	-----		
B-17022	Firing Pin Cross Pin	17022	-----	-----	-----		
B-15673	Firing Pin Head (Blank B-27975)	15673	-----	-----	-----		
A-15411	Main Spring	15411	-----	-----	-----		
C-15412	Bolt Stop	15412	-----	-----	-----	.17	4.30
C-24475	Bolt Stop Pin	24484	-----	-----	-----		.22
A-15413	Bolt Stop Spring	15413	-----	-----	-----		1.20
A-15653	Front Guard Screw	15653	-----	-----	-----	.08	1.81
C-15373	Front Sight (Alternate C-15719)	15373	-----	-----	-----	3.90	.27
B-28510	Front Sight Ramp (Blank B-16724)	28510	-----	-----	-----	5.50	2.55
B-28505	Front Sight Ramp Screw (2)	28505	-----	-----	-----	.01	.62
C-15433	Magazine	15433	-----	-----	-----		
C-15842	Magazine	-----	-----	-----	15842	.03	12.90
C-17056	Magazine Follower	17056	-----	-----	-----		
C-16793	Magazine Follower	-----	-----	-----	16793	.65	7.19
Prepared By		Approved By					



Sheet 2  
of 3 sheets

**CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER**  
**KINZER V. REMINGTON**







## DON'T SAY IT—WRITE IT

To G. M. CALHOUNDATE June 25, 1965FROM S. M. ALVIS*m/600 Project*

This morning we got word from Vic De Reus as to his money situation for tools & development being way out of line. This was indicated to a degree by Wayne Leek in the May meeting of Operations Committee. The main trouble appears to be the trigger guard and trigger (as now designed) and which has been improved over original. Also there are areas of capacity that may need additional machines.

Wayne has a new high spot estimate sheet with him and am going to ask he get in touch with you after he gets back from Sikorsky. Roy decided best he not say anything to Ken about this yet, especially until we get a little better idea of what we should and can do. For example, am afraid to "stop work" because of the schedule situation ---- at same time am somewhat concerned on continuing work in the light of latest estimate.

SMA:T

TO BE SAFE; FIRST THINK YOU MIGHT NOT BE



G-M

**DON'T SAY IT—WRITE IT**

OC: ~~S.M. Alvis~~ In  
→ ~~W.E. Look~~ turn  
~~R.L. Hall~~  
DATE 5/26/65

TO V. G. DeREUS

FROM J. A. ROBERTS *J. A. Roberts*

**MODEL 600 CENTER FIRE RIFLE - CALIBER 6.5MM**

Research has expended to date \$3300 to develop the above caliber and with anticipated further expenditures the total is expected to be as follows:

Instruction folders, parts lists, etc.	
Design follow up and accuracy test	\$ 700
Research expenditures to date	<u>3,300</u>
Total anticipated expenditures	\$4,000

JAR:B

TO BE SAFE, FIRST THINK YOU MIGHT NOT BE



*[Handwritten signatures]*

cc: R.A. Williamson  
~~S.M. Alts~~  
H.J. Hackman) In  
V.G. DeReus ) turn  
M.H. Walker  
R.P. Kelly  
R.B. Hurley  
R.A. Morris  
Estimate File #2575

March 29, 1965

P. B. CROOP

*Costs*  
REPLACE FORMED MODEL 600 & 700 MAGAZINE FOLLOWERS  
WITH POWDER METAL PARTS

The attached cost sheet indicates that a cost increase of about \$3,000 would result if a powder metal process were adopted for the manufacture of the above Magazine Followers. This is based on having the R&D Powder Metal Division supply powder metal blanks to the plant for finishing.

In addition to the resultant increased cost of these components, it also would be necessary to spend approximately \$7,500 for powder metal tooling and trial runs.

On an average, the present formed Magazine Followers cost about \$7.61/C, whereas the powder metal Followers would average about \$11.51/C.

R. L. Hall, Supervisor  
Methods & Standards Section

*[Signature]*

F. G. Carlson

Att.  
FGC:sm



RD 6565

ESTIMATED SAVINGS & RETURN ON INVESTMENTREPLACE FORMED M/600 & 700 MAGAZINE FOLLOWERS  
WITH POWDER METAL PARTS1965 Year of OperationPRESENT  
PURCHASED  
STAMPINGPROPOSED  
POWDER  
METAL PROCESSQuantity Forecast67535OPERATING COSTS

	PRESENT	PROPOSED
Purchased parts	\$ 5,140	\$ 7,775
Raw material		
Direct Labor	345	425
LABOR VIK.	65	80
Industrial Relations @ 36%	165	205
Supplies		
Tool Replacement		
Cutter Grind	325	520
Tool Maintenance		
Maintenance		
Electricity		
Equipment Depreciation @		

Franchise Tax @ 4 1/2%

\$ 6,095 \$ 7,065SAVINGS IN OPERATING COST

COST INCREASE (\$2,980)

Less: All other expense:

All Other 6.9%; Federal Tax 4.3%

NET SAVINGSINVESTMENT

Project expenditures	\$
Manufacturing and working facilities	\$
Net Change in working capital	

Total capital required for this project

\$

RETURN ON INVESTMENT - THIS PROJECT

RED LOST IN COSTS - \$2,980  
\*\*\*\*\*  
POWDER METAL TOOLING - \$5,200

Return on total capital required including  
research and development and other  
operation charges

Return on total additional investment after  
completion of this project

(Subdivision 5)

1500000  
3-21-65



cc: D.E. Miller (2)  
H.J. Hackman  
S.M. - 4144  
A.J. Seckner ) In  
J.J. Phillips) turn  
Estimate File #2243

January 4, 1962

L. D. COX

**MODEL XP-100 AND MODEL 600  
REVISED ESTIMATED FACTORY COSTS AND ECONOMICS TO  
INCLUDE PROPOSED 30-30 AND 222 CALIBERS FOR MODEL 600 RIFLE**

Attached is a sheet showing a current appraisal of costs and economics for the two (2) subject guns. These figures, indicating the effect of the Model 600, 30-30 and 222 calibers, were developed in the following manner:

1. Costs for XP-100 and M/600 - .308 Cal. based on original design and Process estimates as presented in Project ADXP-700-2, Part III, dated January 23, 1962.
2. Model 600, 30-08 Caliber costs used for 222 Caliber.
3. New estimated costs for M/600, 30-30 Caliber based on indefinite design and hi-spot verbal processing.
4. Burden and overhead rates based on latest 1965 plant volumes as forecast for Model 1100 project - Part III.
5. Revised Project Expenditures as issued by R&D on October 10, 1962.
6. Same Selling Prices as used in Project.
7. Gun quantities as confirmed in letter, L.D. Cox to F.E. Morgan, dated October 15, 1962.

We would emphasize the point that these costs do not reflect any changes that may have occurred in design, manufacturing, or packing, since the original Project estimates. The cost of the Pistol Case was not included in the Project and is not included in this estimate. Revised costs incorporating all known changes are being prepared but were not complete for this presentation.

R. L. Hall, Supervisor  
Methods & Standards Section

By: R. F. Kerr

Att.  
RFKerr:sm



R2528317

<u>ESTIMATED FACTORY COSTS AND ECONOMICS FOR PROPOSED</u>						
<u>M/XP-100 PISTOL AND M1600 RIFLE - REVISED TO INCLUDE 30-30</u>						
<u>AND .22Y RIFLE CALS. - BASED ON M1100 PROJECT (PART III REV.) BURDEN AND G.H. RA</u>						
		<u>XP-100</u>	<u>MODEL 600</u>			<u>TOTAL</u>
			<u>308</u>	<u>.22Y</u>	<u>30-30</u>	
VOLUME		3,000	5,000	4,000	6,000	18,000
RETAIL PRICE		\$ 75.00	\$ 85.00	\$ 85.00	\$ 85.00	1,500,000
NET SELLING		40.37	45.74	45.74	45.74	807,110
STD. MAT'L		5.55	7.86	7.86	8.54	138,630
VAR.	15	.08	.17	.17	.13	2,100
VENDOR TOOL	1.9	.06	.08	.08	.09	1,440
STD. LABOR		4.71	5.08	5.08	5.43	97,430
VAR.	40.0	1.86	7.03	7.03	7.17	36,870
WAGE ADJ.						
DIRECT EXPENSE	116.0	5.18	5.84	5.84	6.74	105,540
IND. RELATIONS	35.0	7.30	7.49	7.49	7.66	45,770
GAS-POWER	6.6	.31	.34	.34	.36	6,150
DEPRECIATION	22.1	1.09	1.17	1.17	1.25	21,300
SPACE	7.5	.35	.38	.38	.41	6,930
DIRECT SUPERV.	14.4	.68	.73	.73	.78	13,290
ENGINEERING	8.8	.41	.45	.45	.48	8,160
WARRENTY REPAIRS		.60	.75	.75	.81	13,410
OTHER DIRECT	2.0	.09	.10	.10	.11	2,830
MFG. OVERHEAD	33.9	1.60	1.77	1.77	1.84	31,370
WAREHOUSE	8.6	.41	.44	.44	.47	8,010
SUB-TOTAL		75.78	79.58	79.58	81.77	537,680
PLANT OVERHEAD	24.0	6.07	7.10	7.10	7.67	127,830
FRANCHISE TAX						
INVENTORY ADJ.	.5	.16	.18	.18	.20	3,300
FACTORY COST		31.51	36.86	36.86	39.59	663,810
SELLING AND ADMIN	9.5	3.84	4.35	4.35	4.35	76,770
RESEARCH	3.0	1.21	1.37	1.37	1.37	24,180
TOTAL COST		36.56	42.58	42.58	45.31	764,760
OPER. EARNINGS		3.81	3.16	3.16	4.3	47,450
% OF NET SELL.		9.4%	6.9%	6.9%	9.9%	5.9%
LESS: 6% + 5Y%						
NET EARNINGS						
PROTECT INV'TMENT						
WORKING CAPITAL						
TOTAL CAPITAL AND INV'TMENT						
RETURN ON INVESTMENT (POS. A-F)						
" " (POS. C*)						

(659,680 + 553,500 = \$1,213,180)

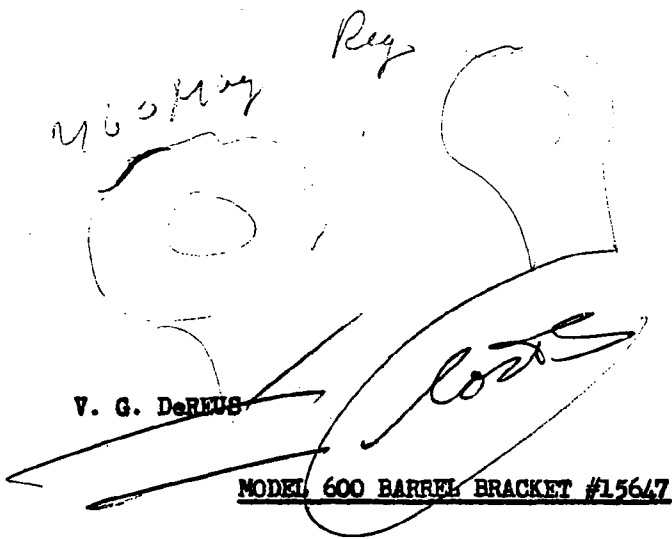


R. KERR - ILION  
1-4-63

1900 REF - REFERRED TO INSURANCE DIV  
- BASED ON M/1100 PROJECT (PART III REV.) BURDEN AND O.H. RATES FOR 1965

XP-100	MODEL 600			TOTAL	CASH RESULT	WORKING CAPITAL	%
	308	YY	30-30				
3,000	5,000	4,000	6,000	15,000	15,000		
75.00	85.00	85.00	85.00	1,500,000			
10.37	45.74	45.74	45.74	807,710	807,710		
5.55	7.86	7.86	8.54	138,630	138,630		
08	17	13	13	7,100	7,100		
06	08	08	09	1,440	1,440		
47.71	5.08	5.08	5.43	97,430	97,430		
1.86	7.03	7.03	7.17	36,870	36,870		
5.18	5.84	5.84	6.44	105,540	105,540		
7.30	7.49	7.49	7.66	45,770	45,770		
31	34	34	36	6,150	6,150		
1.09	1.17	1.17	1.26	21,300	21,300		
35	38	38	41	4,930	4,930		
48	73	73	78	13,290	13,290		
41	45	45	48	8,160	8,160		
60	75	75	81	13,417	13,417		
09	10	10	11	1,830	1,830		
1.60	1.74	1.74	1.84	3,430	3,430		
41	44	44	47	8,010	8,010		
5.28	29.58	29.58	31.77	437,680	437,680		
5.07	7.10	7.10	7.62	17,180	17,180		
16	18	18	20	3,300	3,300		
51	36.86	36.86	39.59	663,810	663,810		
84	4.35	4.35	4.35	76,770	76,770		
71	1.37	1.37	1.37	7,415	7,415		
56	47.58	47.58	48.31	764,760	764,760		
81	3.16	3.16	43.91	47,450	47,450		
9.4%	6.9%	6.9%	9.4%	53,710	53,710		
				174,490	174,490		
				144,640	144,640		
				183,700	183,700		
				476,160	476,160		
				659,860	659,860		
				716,710	716,710		





CC: cc: R.A. Williamson  
C.B. Putney  
S.M. Alvis  
H.J. Hackman  
L.J. Boyle  
Estimate File #2431

October 16, 1964

As requested, a cost comparison has been completed for the add-use of the above part on all Model 600 Rifles versus the use of the present M/700 type of Bracket currently being used.

Although the new Bracket costs less than the old design to buy, the added polishing required more than off-sets this differential. As a result, the out-of-pocket cost to produce this M/600 Bracket is 2.6¢ higher than the M/700 Bracket, equivalent to approximately 5¢ on a full book basis.

Material	\$ 20.30/C	\$ 19.10/C
Std. Labor	1.61	3.42
Other Costs	<u>2.51</u>	<u>4.50</u>
Total Out-of-Pocket Cost	\$ 24.42/C	\$ 27.02/C
Burden	<u>8.36</u>	<u>10.60</u>
Total Factory Cost	\$ 32.78/C	\$ 37.62/C

R. L. Hall, Supervisor  
Methods & Standards Section

*F. G. Carlson*  
F. G. Carlson

FGCarlson:sm



September 29, 1964

V. G. DeREUS

*Cost*  
MODEL 600 BOLT PLUG  
PROPOSED SHROUD TYPE DESIGN

Attached is a sheet showing estimated additional factory costs for this proposed change in design.

R. L. Hall, Supervisor  
Methods & Standards Section

*R. F. Kerr*  
R. F. Kerr

Att.  
RFX:sm

cc: R. A. Williamson  
S.M. Alvis *D*  
W.E. Leek  
Estimate File #2503



M6 aw

Estimated Costs to Increase Receiver Length  
or Add Receiver Support to M/600.

R.L. Hall  
V. J. Rous

Costs / c.  
Add. Rec'r Support      Increase  
   Length of Rec's

Materials.  
Fiberglass (.60" @ 2.67/lb) \*      1.78.  
Steel      1.99.

Standard Labor.      .77  
" Var.      .21  
Total Labor      .98

Ind Rel @ 33      .32

Direct Expenses.      .23.

Estimated out of pocket cost.      3.31      1.99  
" " " " /gun      .033-      .040  
" savings /gun           .013

\* This is price for small quantity. - should be less if bought in larger quantities.

C.W.W.  
10/30/63



cc: D.E. Miller  
L.D. Cox  
S.M. Alvis  
M.H. Walker  
H.J. Hackman) In  
V.G. DeReus ) turn  
A.D. Kerr  
Estimate File #2243

March 27, 1962

*R* *File* *Costs*  
**COST COMPARISON - PROPOSED M/600 (XC-13) STOCK-  
VARIOUS FORE END TIPS versus NO FORE END TIP**  
Reference: Letter R. L. Hall to W. E. Leek dated 3-13-62

In our previous letter regarding the subject material, estimated costs were shown for a stock with and without fore end tip and spacer, similar to that adapted for our M/700 barrel. Since receipt of this information, you have requested stock costs with tips fabricated from raw and scrap nylon.

In response to your request, additional estimates have been prepared and for your information, these and those outlined in our letter dated March 13th, are listed below.

	<u>Regular 500 Series Blank &amp; M/700 BDL Type Fore End Tip</u>	<u>Regular 500 Blank &amp; Remington Molded Raw Nylon Fore End Tip</u>	<u>Regular 500 Blank &amp; Remington Molded Scrap Nylon Fore End Tip</u>	<u>2 3/4" Longer Blank and No Fore End Tip</u>
Standard Material	\$ 1.68	\$ 1.31	\$ 1.30	\$ 1.50
Standard Labor	.88	.88	.88	.83
Total Factory Cost (Full Book)	6.80	6.36	6.35	6.31
Tool Charges	\$ 4,000	\$10,000	\$10,000	--

All of the above costs for stocks with tip include a fore end tip spacer.

Regarding your inquiry concerning the butt plate for the gun in question, we wish to advise that hi-spot estimates indicate a reduction of approximately \$.04 each in standard material if scrap nylon is used.

275  
R. L. Hall, Supervisor  
Methods & Standards Section

*R. F. Kerr*  
R. F. Kerr

RFKerr:sm



cc: D.E. Miller  
S.M. Alvis  
H.J. Hackman) In  
V.G. DeRous ) turn  
A.D. Kerr  
Estimate File #2243

Ilion, New York  
March 13, 1962

W. E. LEEK

**COST COMPARISON - PROPOSED MODEL XC-13 STOCK  
WITH AND WITHOUT FORE END TIP AND SPACER**

At your request, estimated Factory Costs have been developed for producing the above mentioned Stock with and without a Fore End tip and spacer.

Estimated costs for the Stock with a Fore End tip are based on procuring a tip comparable in cost to that being purchased for the Model 700 BDL. Costs for the Stock without a Fore End tip are based on quotes recently confirmed by our wood supplier for a blank 2 3/4" longer than our regular 500 Series blank.

Estimated costs as indicated on the attached sheet are as follows:

	<u>Stock with F.E. Tip and Spacer</u>	<u>Stock without F.E. Tip and Spacer</u>
Standard Material	\$ 1.68 Each	\$ 1.50 Each
Standard Labor	.88 "	.83 "
Total Factory (Full Book)	6.89 "	6.31 "
Tool Charges (Plant and Vendor)	\$ 4,000	-

Tool charges for plant operations are based on project estimates prepared by Process Engineering. Charges paid for the Model 700 BDL Fore End tip mold were used as a guide in developing vendor tooling estimates.

R. L. Hall, Supervisor  
Methods & Standards Section

R. F. Kerr

Att.  
RFKerr:sm

Stock - 1.30  
Tip - .83  
" " " " - .83  
Best Price - 1.30



COST COMPARISON - PROPOSED MODEL 86-13 STOCK  
WITH AND WITHOUT FORE-END TIP AND SPACER

				EST. COST PER 100	
				WITH F.E. TIP	WITHOUT F.E. TIP
MATERIAL - STD.				168.114	150.000
- VAR	(3 3/4%)			5.048	4.500
TOTAL MAT'L				173.157	154.500
LABOR - STD.				87.561	82.694
- VAR				34.143	32.251
TOTAL LABOR				121.704	114.945
DIRECT EXPENSE (ACT.)				118.892	105.848
IND. RELATIONS	(35%)			47.596	40.231
ALLOC. BURDEN				45.703	43.166
DIRECT CHARGES	(33.3 1/2% STD. LABOR)			79.158	72.537
MFG. OVERHEAD	(31 1/4% STD. LABOR)			77.317	75.801
SUB-TOTAL				558.579	512.078
PLANT OVERHEAD	(22 1/2%)			173.438	113.158
INVENTORY ADJ.	(1.0%)			6.820	6.252
TOTAL FACTORY COST PER 100				688.784	631.438
" " " " EA.				6.89	6.31
TOOL CHARGES					
PLANT OPERATIONS				2600	—
VENDOR (MOLOS)				1400	—

R. KERR 3/14/64



cc: D.E. Miller  
L.D. Cox  
~~S.M. Atiles~~  
~~M.H. Walker~~  
H.J. Hackman) In  
V.G. DeReus ) turn  
A.D. Kerr  
Estimate File #2243

March 27, 1962

W. E. LEEK

**COST COMPARISON - PROPOSED M/600 (XC-13) STOCK-  
VARIOUS FORE END TIPS versus NO FORE END TIP**  
Reference: Letter RLHall to WELook dated 3-13-62

In our previous letter regarding the subject material, estimated costs were shown for a stock with and without fore end tip and spacer, similar to that adapted for our M/700 barrel. Since receipt of this information, you have requested stock costs with tips fabricated from raw and scrap nylon.

In response to your request, additional estimates have been prepared and for your information, these and those outlined in our letter dated March 13th, are listed below.

	Regular 500 Series Blank & M/700 BDL Type Fore End Tip	Regular 500 Blank & Remington Molded Raw Nylon Fore End Tip	Regular 500 Blank & Remington Molded Scrap Nylon Fore End Tip	2 3/4" Longer Blank and No Fore End Tip
Standard Material	\$ 1.68	\$ 1.31	\$ 1.30	\$ 1.50
Standard Labor	.88	.88	.88	.83
Total Factory Cost (Full Book)	6.80	6.36	6.35	6.31
Tool Charges	\$ 4,000	\$10,000	\$10,000	--

All of the above costs for stocks with tip include a fore end tip spacer.

Regarding your inquiry concerning the butt plate for the gun in question, we wish to advise that hi-spot estimates indicate a reduction of approximately \$.04 each in standard material if scrap nylon is used.

R. L. Hall, Supervisor  
Methods & Standards Section

*R. F. Kerr*  
R. F. Kerr

RFKerr:sm



cc: D.E. Miller  
S.M. Alvis  
H.J. Hackman ) In  
V.G. DeReus ) turn  
A.D. Kerr  
Estimate File #2243

Ilion, New York  
March 13, 1962

W. E. LEEK

COST COMPARISON - PROPOSED MODEL XC-13 STOCK  
WITH AND WITHOUT FORE END TIP AND SPACER

At your request, estimated Factory Costs have been developed for producing the above mentioned Stock with and without a Fore End tip and spacer.

Estimated costs for the Stock with a Fore End tip are based on procuring a tip comparable in cost to that being purchased for the Model 700 BDL. Costs for the Stock without a Fore End tip are based on quotes recently confirmed by our wood supplier for a blank 2 3/4" longer than our regular 500 Series blank.

Estimated costs as indicated on the attached sheet are as follows:

	<u>Stock with F.E.</u> <u>Tip and Spacer</u>	<u>Stock without F.E.</u> <u>Tip and Spacer</u>
Standard Material	\$ 1.68 Each	\$ 1.50 Each
Standard Labor	.88 "	.83 "
Total Factory (Full Book)	6.89 "	6.31 "
Tool Charges (Plant and Vendor)	\$ 4,000	-

Tool charges for plant operations are based on project estimates prepared by Process Engineering. Charges paid for the Model 700 BDL Fore End tip mold were used as a guide in developing vendor tooling estimates.

R. L. Hall, Supervisor  
Methods & Standards Section

R. F. Kerr

Att.  
RFKerr:sm



COST COMPARISON - PROPOSED MODEL XC-13 STOCK  
WITH AND WITHOUT FORE-END TIP AND SPACER

				EST. COST PER 100	
				WITH F.E. TIP	WITHOUT F.E. TIP
MATERIAL - STD				168.114	150.000
- VAR (3 1/2%)				5.043	4.500
TOTAL MAT'L				173.157	154.500
LABOR - STD				87.561	87.694
- VAR				34.143	37.251
TOTAL LABOR				121.704	124.945
DIRECT EXPENSE (ACT.)				118.897	105.848
IND. RELATIONS (35%)				47.596	40.731
ALLOC. BURDEN				45.703	43.166
DIRECT CHARGES (33.3 1/2% STD LABOR)				79.158	77.537
MFG. OVERHEAD (31.4% STD LABOR)				77.319	75.801
SUB-TOTAL				558.579	517.078
PLANT OVERHEAD (7.11%)				173.436	113.158
INVENTORY ADJ. (1.0%)				6.870	6.757
TOTAL FACTORY COST PER 100				688.784	631.438
" " " " EA.				6.89	6.31
TOOL CHARGES					
PLANT OPERATIONS				2600	
VENDOR (MOLOS)				1400	

R-KERR 3/14/67



ESTIMATED ADDITIONAL FACTORY COST FOR PROPOSED SHROUD DESIGN- MODEL 600 BOLT PLUG #15409

		EST. ADD'L COST/100		
STD. MATERIAL		.35		
VARIANCE	7.0	.03		
STD. LABOR		1.65		
VARIANCE		.19		
DIRECT EXPENSE		.58		
IND. RELATIONS	93.0	.61		
ALLOC. BURDEN		.67		
MFG. OVERHEAD	40.0	.66		
SUB-TOTAL		4.74		
PLANT OVERHEAD	74.0	1.14		
INVENTORY ADJ.	1.0	.06		
FACTORY COST		5.94		
EST. ADD'L. FACTORY COST PER GUN			.06	
"	"	"	"	"
YEAR - '44 FORECAST				1450
ENGINEERING AND TOOLING			4400	

R. KERR



cc: R.A. Williamson  
C.B. Putney  
S.M. Alvis  
H.J. Hackman  
L.J. Boyle  
J. Marley  
Estimate File #2431

February 1, 1965

*cost*  
V. G. DeREUS

MODEL 600 BARREL BRACKET #15647

A revised cost comparison of the above Barrel Bracket and the regular M/700 Bracket has been completed as requested.

The full factory cost of the M/600 and M/700 Barrel Brackets is \$.45 and \$.37, respectively. The current M/600 Bracket with the required additional polishing around the periphery costs approximately \$.08 more than the standard M/700 Bracket.

A proposal is being considered of having the vendor perform a shave operation, and hopefully thus being able to eliminate the extra polishing now required on the M/600 Barrel Bracket. If this were 100% successful, the cost would be reduced to approximately \$.01 more than the present M/700 Barrel Bracket.

However, if the cost of the vendor tooling, about \$2,300, were to be amortized over the next five years, an additional \$.02 would be added to the cost of the component. This would make the proposed M/600 Bracket cost about \$.03 more than the present M/700 Bracket.

R. L. Hall, Supervisor  
Methods & Standards Section

*F. G. Carlson*  
F. G. Carlson

FGC:sm



P. E. & C. ESTIMATE

TO: H. J. Hackman

ESTIMATED BY: W. J. Kelly

S. M. Alvis R. L. Hall  
W. J. Kelly R. P. Kelly

MODEL 600 PROJECT NO. \_\_\_\_\_ DATE 9/25/64

PROJECT TITLE Estimate to change Bolt Plug to provide  
A shroud over the REAR of the Firing Pin Assembly  
For comparison with present part cost

	HOURS	RATE	TOTAL
PROCESS ENGINEERING & TRIAL RUN			—
TOOL DESIGN FIXTURES - GAGES			250
TOOLING FIXTURES - GAGES			1100
TOOL DESIGN — PERISHABLE TOOLS			
TOOL DESIGN REVISIONS			120
PERISHABLE TOOLING			480
TOOL REVISIONS			
TOOL REVISIONS - PERISHABLE			
TESTING			
ADMINISTRATION			
VENDOR TOOLING COSTS (DIES ETC.)			50
VENDOR TOOLING NOT REMINGTON PROPERTY			
SUB TOTAL			2000
CONTINGENCIES			200
			2200

COMMENTS \_\_\_\_\_



PROJ. OR STUDY NO.

WORKS

COMPUTER

DATE 9-23-64



PRESENT VENDOR'S P/P 130.44/M

EST. VENDOR'S P/P (REBUILT) 133.94/M

EST. VENDOR'S TOOL COST \$50.00

INCREASE IN VENDOR'S P/P 3.50/M

PURCHASE INSPECT

COMP. SCREEN

OP# 15. MILL FIRING PIN HEAD SLOT  
FLATS ON BOTTOM & SAFETY  
CLEARANCE.

FIXTURE (ALTER) D-54573

POSITION GA. (ALTER) C-51002

OP# 20 FINISH BORE FIRING PIN  
HEAD CLEAR.

DRILL JIG (NEW)



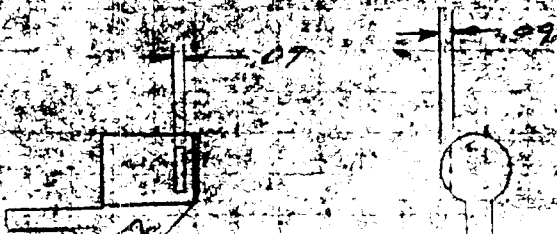
WELDING SHOP - MILLING PIN HEAD

FOR DESIGNER'S USE (SEE PL. 10)

COMPUTED BY

DATE 9-28-64

ALTERNATION NO. 10 FILING PIN HEAD



DES. HRS. 10 PL. 10

OP 12 - MILL Slot FOR COCKING  
SPACER

(HAND MILL)

FIXTURE	15	75
TEMPLATE (POSITION)	9	15
PLUS G.A. (DEPTH)	3	10



ENGINEERING



COMBINATION SHEET

SHEET NO. 1

TITLE *REMINGTON FIRING PIN ASSEMBLY*

DESIGN *DESIGN CHANGE (Bolt Plug)*

COMPUTER *FTN*

DATE *9-23-64*

DES. NO.

*OPP. A. REMINGTON FIRING PIN, MAIN  
BOLT PLUG AND FIRING  
PIN HEAD, RETHREAD BOLT  
PIN*

*FIXTURE (ALTER) D-50026*

*5*

*201*



TO: H. J. Hickman

B.L.O. ESTIMATE

ESTIMATED BY: R. Kelly  
R. S. Hurley  
R. C. Kemp - V. G. J. RensMODEL 600

PROJECT NO. \_\_\_\_\_

DATE 4/13/64PROJECT TITLE Estimate to use model 700 type front and rear sight  
on model 600 R216 in place of present rib and sight

	HOURS	RATE	TOTAL
PROCESS ENGINEERING & TRIAL RUN			—
TOOL DESIGN FIXTURES - GAGES			2300
TOOLING FIXTURES - GAGES			3700
TOOL DESIGN — PERISHABLE TOOLS			—
TOOL DESIGN REVISIONS			250
PERISHABLE TOOLING			3500
TOOL REVISIONS			350
TOOL REVISIONS - PERISHABLE			350
TESTING			—
ADMINISTRATION			—
VENDOR TOOLING COSTS (DIES ETC.)			—
VENDOR TOOLING NOT REMINGTON PROPERTY			—
SUB TOTAL			10450
CONTINGENCIES			1050
			11500

COMMENTS Part of the cost could be reduced if the model 600  
parts were incorporated in the initial design of the screw  
on front sight change now being made for the models 700-74  
and 760



## P. E. &amp; C. ESTIMATE

R. L. Hall

DELEK

TO: H. J. Hackman

ESTIMATED BY:

P. B. Hurley

- M. J. Kelly

MODEL

600-Exp

PROJECT NO.

DATE

10/25/63

PROJECT TITLE

Estimate to increase length of tang on m/600

Receiver to eliminate extra operation on stock and

nylon Receiver Support

	HOURS	RATE	TOTAL
		PER HOUR	RECEIVER
PROCESS ENGINEERING & TRIAL RUN			—
TOOL DESIGN FIXTURES - GAGES	10	200	150
TOOLING FIXTURES - GAGES	35	1000	700
TOOL DESIGN — PERISHABLE TOOLS	7	—	50
TOOL DESIGN REVISIONS	28	50	200
PERISHABLE TOOLING	33	—	350
TOOL REVISIONS	120	100	850
TOOL REVISIONS - PERISHABLE		—	0
TESTING		—	—
ADMINISTRATION		—	—
VENDOR TOOLING COSTS (DIES ETC.)		—	—
VENDOR TOOLING NOT REMINGTON PROPERTY		—	—
SUB TOTAL		1350	2300
CONTINGENCIES		0	0
		1350	2300

COMMENTS



MODEL 600  
Advertising

SMA



cc: G.M. Calhoun  
R. P. Kelly - File

Ilion, New York  
August 28, 1967

S. R. HUTCHINSON  
Bridgeport

**MODELS 660, 742 & 760 ADVERTISING**

It is good that you sent this up for review since there were several items which did not look right to me so I had Bob Kelly check them out. Bob has been following these models closely and for the most part he handled all 660 job himself.

Among items that should be further cleared at Bridgeport is your proposed use of the term "liquid hone" which apparently has some previous copyright reference. The equipment being used by Ilion on the improvement finishes program is manufactured by the Almco Company under trade name of "Vibrasheen". Of course, there had to be further process development to suit peculiarities and shapes of parts being finished, etc., which was handled by Ilion Plant and Product Engineering group.

On the Model 660 bolt with the "forward S", suggest that you might consider making a "plus" out of this since was done for specific purpose of avoiding bruising of your knuckles.

Since there is an inherent difference in the strength of the action of M/742 & 760 as compared to our bolt action guns, I would question using term "bank vault"; however, Bob tells me this has already been done.

Another one for the M/660, recall Wayne Leek having questioned the increased length of the barrel as interfering with use of this carbine for a saddle scabbard. Am told that this has been checked at Bridgeport and "no problem".

SMA:T

G. M. Alvis  
Ilion Research Division



REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE



Bridgeport, Connecticut  
August 23, 1967

TO: S. M. ALVIS - ILION  
FROM: S. R. HUTCHINSON

Although the attached copy which will be used for literature in the Models 660, 742 and 760 has been routed and approved here at Bridgeport, I'd feel a little better if you would give it the once over.

Thanks and best regards.



S. R. Hutchinson - Manager  
Advertising - Firearms

SRH:pmg  
Attach.



## DON'T SAY IT—WRITE IT

To \_\_\_\_\_

DATE \_\_\_\_\_

FROM \_\_\_\_\_

Re - telephone (Hutchinson) - 8/25/67

M/660, 842+160 - "liquid line" - term derived by advertising,  
discussed possible patent infringement, related  
present Alenco term (VIBRASHEEN)® - he will  
follow up with legal dept.

Follow-up call by Nick Storer (Legal) - discussed, then L. Fox & R. Can.

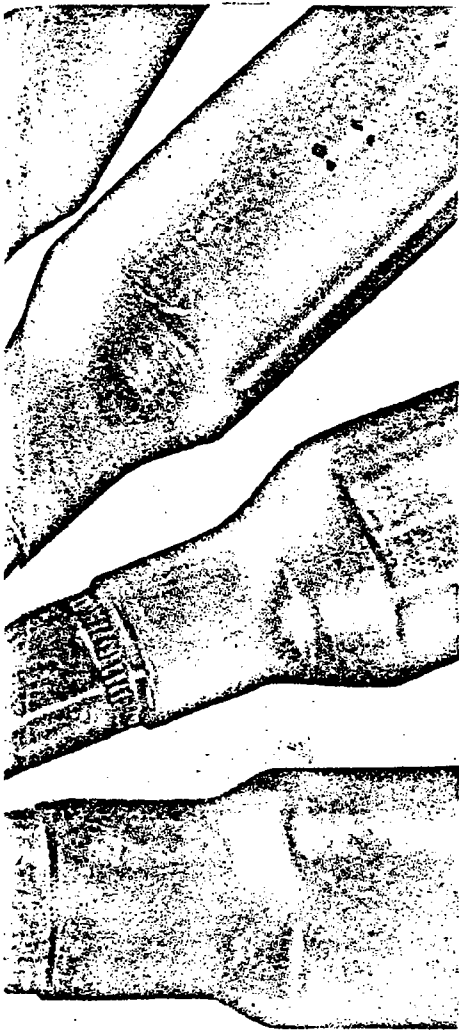
M/660 - Bolt handle - discussed plus feature of "in-  
langed up finger" with forward sweep.

M/42-761 - Bolt locking - "Vault vault" - claims have used before

TO BE SAFE, FIRST THINK YOU MIGHT NOT BE



*m/600 Adv*



**M**INE!" COMES a high, thin shout from the far west. Another faint cry drifts in from somewhere out east, then "No, dammit, I invented it!" sounds somewhere to the north. Then, privately, and with absolutely no intention of ever claiming any credit, but just to let you know what really happened, several other nameless associates advise you that, after all, they really did it first, but wouldn't consider it at all in good taste to publicly tell the truth after those other fellows claimed the credit.

And so it goes, the race amongst gun-writing hacks to claim credit for "inventing" the new 6.5mm Remington Magnum cartridge — say, you all wouldn't be interested in hearing who really thought of it first, would you . . . ?

When Remington introduced its short, new .350 Magnum, (about two years ago, as you read this) it was only natural that everyone jump feet first into a wildcatting program. Yours truly was no exception. I'll wager at least a forage wagon-load of actions and barrels have been consumed across the country in the process.

Except for the fun had by everyone in the process, it was really wasted effort, for it had all been done before.

Wayne Leek advised me many moons ago that Remington's versatile design

staff had made up and tested dozens of wildcats on the new case, long before ever announcing the .350 Magnum. In fact, the 6.5mm version had been selected as the most likely prospect for factory production before anyone outside the staff had ever seen even the .350.

The new 6.5mm Magnum from Bridgeport is a most interesting little cartridge. It utilizes the reliable old Holland and Holland belted case shortened to just a hair over two inches, with a very short neck, steep shoulder, and minimum body taper. Like most other lately-introduced calibers, the case is already so chubby that it is virtually impossible to "improve" it significantly in the usual wildcatter's fashion. The case weighs 223 grains, and holds 64 grains of water with the factory 120-grain bullet seated to standard depth. To base of neck, it holds 65.7 grains of water. Filled to the base of the neck with DuPont 4350 powder that has been well settled, it holds 60 grains.

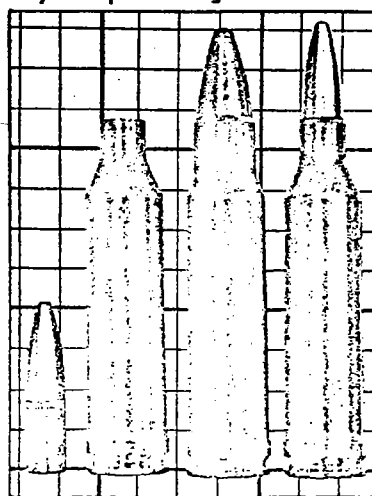
This brings up a characteristic that most gun buffs will consider undesirable — that bullets must be seated so deep as to intrude into the powder space, a situation brought about by the length limitations of the short M-600 Magnum action for which this cartridge was designed, and the short case neck. Because of this, the heavier the bullet with which one loads the cartridge, the less powder space is available. The same characteristic is found in many of the newer cartridges such as the .350 Remington Magnum, the .300 Winchester Magnum and .284 Winchester. Graybeards like myself who learned handloading when there was room enough in both case and rifle to seat all bullets to the base of the neck find this sort of arrangement hard to accept, and we still don't really like it. Seems like it is here to stay though, however, a few of us simply have our guns for these short cartridges built on standard length actions and go our merry way seating bullets the way we learned and like best.

At this point the 6.5mm maggie is offered only with a 120 grain bullet at 3030 fps (measured in a 20" barrel). Seems likely, though, that Remington will eventually supply it with other bul-

(Turn Page)

Shown flanking the earlier .350 maggie, the 6.5mm Magnum is only a logical development of that cartridge.

By Maj. George C. Nonte



DECEMBER, 1960



# Who's On First?

(Continued from Page 47)

let weights. A nicely pointed 100-grain projectile would churn up about 34-3500 fps with about 55 grains of IMR 4350 powder, and would be pure poison on varmints and light-to-medium game. Crowding a heavier bullet, say 140 grains, into that short, stubby case would cut down on powder capacity, but it should be possible to give it 2900-3000 fps at reasonable pressures. We'll just have to wait and see what the boys at Ilion can come up with in the way of other bullets, while we use the existing 120-grain load.

Our test lot of 6.5mm Remington Magnum cartridges was loaded with 54.2 grains of a perforated tubular grain powder. Charge weights ran quite uniform, with an average deviation of .3 grain. The charge does not fill the case completely, coming to a point about even with the base of the shoulder. The 120-grain bullet measures 1.055" in length and its base lies even with the base of the shoulder when seated to standard overall cartridge length of 2.79-2.80 inches.

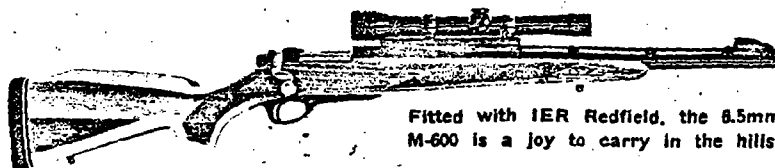
Powder capacity of the 6.5mm may be compared with that of the .270 and .284 Winchester, which hold approximately the same amount.

The 6.5mm's performance is within a whisker (on the low side) of each of those calibers, as is shown in the accompanying box. This makes it clear, that from purely a performance standpoint, there is no valid reason whatever for this new 6.5mm number.

It seems to me that the 6.5mm Magnum's real (and only) reason for existence is to provide a "distinctively Remington" cartridge that will fit the ultra-short M-600 action and be competitive performance-wise with the .270 and .284 Winchester. Actually, the latter caliber will fit very nicely in the M-600 action, but, "really, old boy, that just isn't done."

But, all wool-gathering aside, let's take a look at what our sample gun did on the range. The M-600 Magnum rifle with its laminated stock was described in detail in May, 65 SHOOTING TIMES. The 6.5mm 600 is identical to those already circulating in .350 caliber.

Functioning was flawless throughout the firing of a couple hundred rounds. Trigger pull was clean and crisp (as we've learned to expect on Remington's current production center fire rifles), and the bolt flipped through its cycle effortlessly. Fired cases extracted eas-



Fitted with IER Redfield, the 6.5mm M-600 is a joy to carry in the hills.

ily and indicated a smoothly-cut chamber.

Since the 600 is a short, light carbine, it didn't seem quite kosher to saddle it with a high-power scope, so initially the fine Redfield IER 2X was installed forward on the barrel in mounts by the same firm. This combination, by the way, is the best I've found for fast shots on moving game.

After setting the scope up with a Sweany Site-A-Line, the first bullet struck within 2" of point of aim at 100 yards. After a few rounds to settle the gun in the stock, it was cradled carefully on sandbags and five-shot groups began in earnest. The first three groups went into 1 1/4", 2 1/8" and 1 3/8" respectively. Thinking it ought to do better than that, the barrel was cooled, then shooting continued with careful spacing of shots and the ultimate in attention to detail. Slightly smaller groups resulted, but none quite made the magical one-inch we normally hope for. Switching to a receiver-mounted 6X scope with fine crosshair reticle helped a little bit, and groups settled down at about 1 1/8". This is excellent accuracy of a degree unheard-of in off-the-shelf combinations only a few years ago. In spite of this, I had hoped that the one-inch barrier might be broken. Three other 600's I've used would shoot under an inch when everything was right. One .308 600 in my rack has produced groups as small as 1/2 inch, certainly giving the lie to those who claim a light rifle won't shoot.

The RCBS tools in my self-propelled

loading shop were called into play and a number of handloads brewed up on the range. Several loads utilizing 100-grain Hornady bullets showed considerable promise, but there is much development work to be done on them yet. Ken Waters is hard at work on a comprehensive reloading report on the 6.5mm Magnum, so you'll soon be able to read all about his tests in that area. My own opinion is that with flat-shooting 100-grain loads this would be just about the finest all-round cartridge-gun combination a fellow could have for saddle or pickup truck in the far reaches of the plains states.

After considering all the angles, it appears that Remington has another winning combination that will make a bundle of money for the DuPonts—in spite of the fact that the cartridge itself won't do a thing several older ones can't do better. It's the combination that counts.

Caliber	Bullet Weight	Velocity	Energy	300 yd. MRT
6.5mm				
Mag.	120	3030	2450	5.7"
.270				
Win.	130	3140	2850	5.3"
.280				
Rem.	125	3190	2820	5.3"
.284				
Win.	125	3200	2840	5.3"

As indicated above, the 6.5mm Magnum actually falls below the .270, .280 and .284 in velocity, energy and flatness of trajectory.



## Stone Blinds

(Continued from Page 19)

lake. They changed course several times and then headed for the stone blinds. Bob practically crawled into the rocks as they appeared to head straight for him. The birds were getting close now. The largest was in the lead, and I thought to myself that Bob probably had his eye on that bird with the idea of getting his fifty cent piece back from me. Tension mounted with the low, guttural "Honk" of the birds talking to each other. These were large Honkers and they didn't keep up the constant

raucous cackling of the smaller species of Canada Geese.

They were nearly over Bob's blind now, and a puff of feathers flew from the lead goose, followed immediately by the roar of Bob's shotgun. The bird faltered and then caught himself and continued the steady rhythmic beat of his powerful wings. Then the huge bird's head snapped back and started to fall with the certainty that every hunter recognizes. The blast of Bob's gun was quickly followed by another shot, and the second bird of the flock slanted toward the ground with a frantic thrashing of wings.

(Continued on Page 54)

SHOOTING TIMES



G-26

DON'T SAY IT—WRITE IT

*File*

F. E. MORGAN  
To E. S. McCAWLEY  
FROM W. E. LEEK *WEL*

*CD 10/30* DATE Oct. 28, 1965

Attached is copy of a letter from Pete Brown to R.J. Stevens, who is associated with Leupold & Stevens Instruments. The article refers to the use of Leupold scopes on a Remington Model 600. I thought you would find the information very interesting.

*File*  
*info 600*  
*adv*

WEL:T  
Attach.



COPY

L & S I  
SEP 21 1965

# Sports Afield

959 EIGHTH AVENUE • NEW YORK, NEW YORK • 10019

PETE BROWN  
ARMS EDITOR  
2433 NORTH 47 WAY  
PHOENIX, ARIZONA 85018

September 17, 1964

Mr. R. J. Stevens  
Mr. Jack Slack  
LEUPOLD & STEVENS INSTRUMENTS INC.  
4445 N. E. Glisan St.  
Portland 13, Oregon

Dear Bob and Jack:

I'm back from Alaska and had a fine hunt. The part on the Yukon River didn't pan out too well, but we got sheep and caribou.

The Rem. 600 with the V8-2X and new mount worked to perfection. You'd be surprised at how impressed everyone was with this combination. I left it in Alaska with Don DeHart so his daughter Maude Ann can use it on a grizzly and moose. Don wrote that he had taken her out to check the sight setting after the combination had been banged around in a saddle scabbard, bumped in the rocks, and rained on for three weeks. Don said that she fired three shots at 250 yards and they were in better than 2 inches spread. I'm going to give Maude Ann one of these combinations because she was really crazy about it. She has done quite a lot of hunting so she isn't just taken with the elaborate stock.

I'm happy to report that the scope and mount are ideal for this rifle. I am very much in favor of its light weight. I can't believe these heavy steel bases are at all necessary.

Thanks again to you both for making my visit to Portland a most pleasant one. I also want to thank you for making it possible for me to try the new mount in Alaska.

Sincerely,



Pete Brown

PE:CPB



## REMINGTON'S NEWEST IS

### A POWERFUL PACKAGE FOR BIG GAME

By R. A. STEINDLER

*in/boos ad*

**I**F YOU HAVE been bemoaning the passing of an era—that is the era of the souped-up .35 caliber cartridge and rifle—you can stop crying! And if you have never heard of those .35's, there is a treat in store for you. Remington has a brand-new gun and a brand-new .35 caliber cartridge—the .350 Remington Magnum!

Just a little over a year ago Remington popped the Model 600 on the public. Gun writers, guides, and shooters immediately took sides, and opinions about the gun were about evenly divided. Let's recap the gun: It has an 18½ inch barrel, a dog-leg bolt that comes from the XP-100 which probably derived from the old Model 30 bolt handle, a plastic rib. The price tag was just under 100 bucks, weight of the gun was announced as 5½ lbs. This led some wag to state that the Model 600 cost slightly over \$18 per pound of gun. In some areas acceptance of the new and startling-looking gun was immediate, in other areas, where fast handling and weight were not major considerations, sales were slow. Construction of the Model 600 was such that anything more potent than the .35 Remington or the



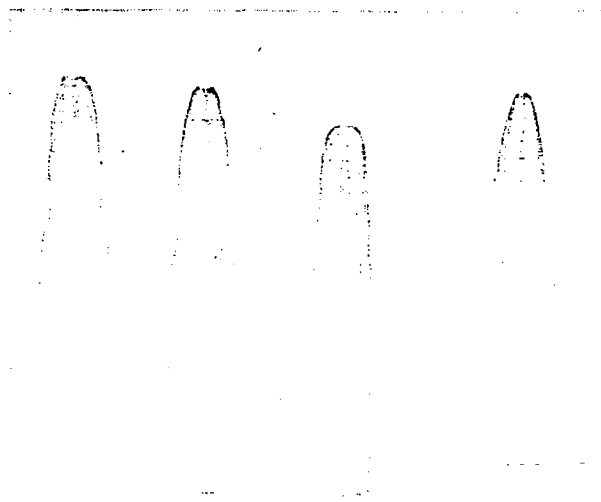
Potent punch of .350 Remington Magnum cartridge was demonstrated by shooting into plastic bottles.

## REMINGTON'S .350 MAGNUM!

.308 Winchester would be impossible. Mike Walker, one of the guiding lights of Remington's R&D staff and Charles Morse, another top-flight Remington designer, had been toying with the idea of a hot .35 caliber cartridge for a number of years. This dream cartridge would be ballistically in the league of the .35 Newton, the .35 Whelen, and cartridges of similar ilk. With the exception of a few .35 Newton rifles, guns for these wildcat cartridges had to be custom built. Mike, in the early 1950's, submitted a hot .35 cartridge and gun to Remington's management, but there were other things in the works and the project was shelved for the time being.

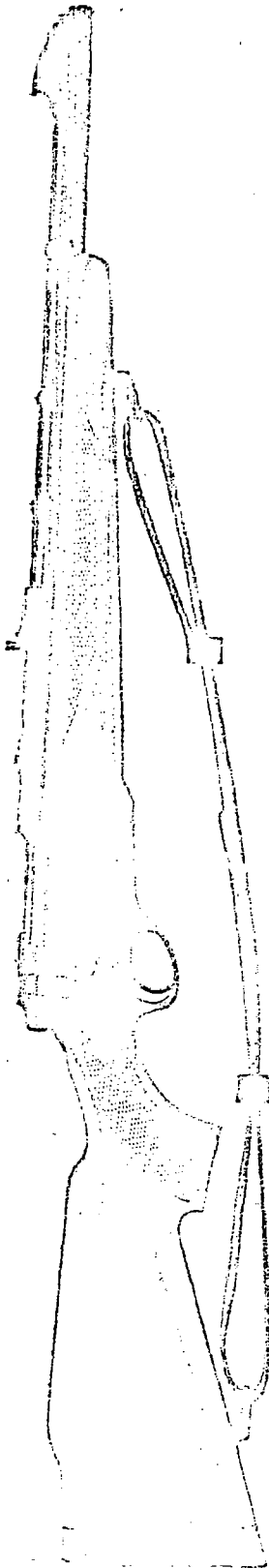
With the introduction of the Model 600, the Remington R&D boys had a light weight gun that would be suitable for a heavier caliber brush gun. They beefed it up here and there, and presto, they had had the rifle for the hot .35 caliber cartridge. Thus was born the .350 Remington Magnum—a real power package.

The new Model 600 Magnum, so far chambered only for the .350 Magnum, weighs 6.2 lbs., has a beefed up and free-floating barrel. The ventilated plastic rib has been strengthened somewhat and is a smidgeon wider than that of the standard model. The big change is in the wood! The

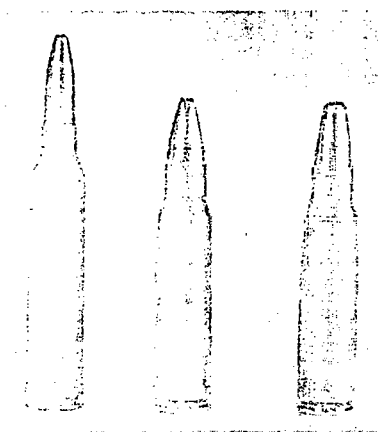


Left to right: The .348 and .358 Winchester; the .35 Remington; and the new .350 Remington Magnum.

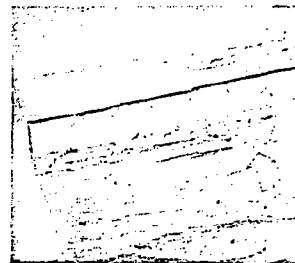




Above: Ice-filled plastic bottle shatters as it is hit by the 200 grain Core-Lokt Remington bullet.



Left: On the left is the 7 mm Remington. In the center is a factory loaded .350. Right is the .350 loaded with a 250 grain Speer bullet. Below. Penetration of the 200 grain factory bullet in the end grain of oak log.

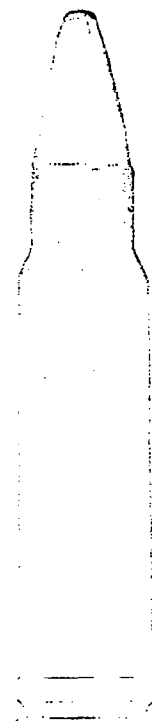


stock of the Model 600 Magnum is laminated beech and walnut, and this, to the best of my knowledge, is the first time in U.S. firearms history that an over-the-counter rifle is marketed with such a stock.

Extensive use of laminated stocks has been traced to WWII Germany. It was found that laminating military stocks would give not only a stronger product—that is a laminated gun stock was more resistant to moisture, oil, and general abuse—but stock manufacture was easier since less care in selecting the blanks was needed. Moreover, laminating conserves hard-to-get walnut which, though not really scarce, does, if finely figured, command a higher price than the grade of wood usually put on a standard grade gun.

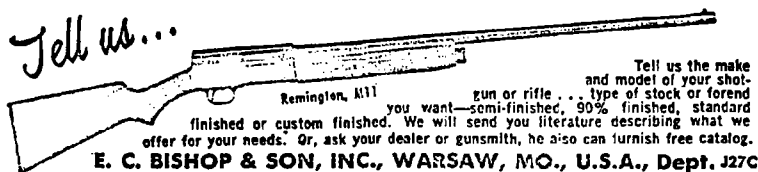
The beech and walnut lamination of the Model 600 Magnum stock is done in two directions to give the stock not only greater strength, but also prevent warpage. The checkering, still of the impressed kind, is somewhat improved, and the new DuPont RKW finish—a strict trade secret—has proved itself to be rugged and even more durable than last year's much touted Remington finish. A black rubber recoil pad is standard, as are the QD swivels and a leather carrying strap.

Several of the demonstration guns I saw (Continued on page 46)





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**P. O. DRAWER 1712 BROWNSVILLE 10, TEXAS**

## REMINGTON .350 MAGNUM

(Continued from page 35)

were topped by either Redfield or Leupold pistol scopes. These were mounted well forward for the long eye relief, and both companies will have mounts on the market by the time you read this article. In order to give a firm base for scope mounting in this forward position, Remington raised the barrel bracket that is located between action and barrel. This gives the scope considerable support and helps to keep the scope zeroed. If you don't care for the forward mounted scope, you can have your scope mounted in the standard fashion. This would have the advantage that you maintain the integrity of the open rear sight which must be removed if the scope is mounted forward. In forward mounting, the holes that hold the rear sight are used for the scope mount, thus depriving the shooter of the emergency use of the factory sights. This leaves scope mounting up to the individual buyer, and I consider this as advantage.

Aside from the laminated stock, there is one other major change in the Magnum version—the barrel has been made heavier for the .350 and twist is 1 in 16 inches.

### THE .35's

Caliber	Bullet Wt.	Powder	MV (fps)	Twist	Source
.358	200 gr.		2530	1-12	Factory
.35 Whelen	200 gr.	57 gr. 3031	2820	1-16	
	250 gr.	54 gr. 3031	2506		Speer
.35 Newton	200 gr.	68 gr. 3031	2625	1-14	P. O. Ackley
	250 gr.	66 gr. 3031	2665		Speer
.35 Ackley Magnum	200 gr.	60 gr. 3031	2824	1-14	P. O. Ackley
	250 gr.	65 gr. 4350	2850		P. O. Ackley
.35 Belted Newton	250 gr.	69 gr. 4320	2960	1-14	P. O. Ackley
.350 Rem. Magnum	200 gr.		2725*	1-16	Remington
	250 gr.		2410*		

\*Although it may appear that the new .350 Remington Magnum does not compare favorably with other .35's, it must be kept in mind that these ballistics for the new Remington cartridge are based on the 18½ inch barrel, while most of the factory ballistics for the above cartridges were taken in 24 and, in some cases in 26 inch barrels.

The Magnum model holds three cartridges in the magazine and one in the chamber.

The .350 Remington Magnum ammo is loaded with either the 200 gr. or the 250 gr. pointed Core-Lokt bullet. The case is a somewhat shortened 7 mm Remington Magnum case, and this case, in turn, had its origin with the .300 H&H case. Shoulder is 28°, and Wayne Leek of Remington reports that water capacity of the case is 65 grains. I checked capacity of a fired and neck-sized case. Filling it to the shoulder, I managed to get 67.1 gr. of Ball C. Lot #2 into the case. Case length is 2.161 inches, and loaded with the 200 gr. bullet, the cartridge measures 2.741 inches. At press time, no 250 gr. rounds were available, and I received only 20 rounds of the 200 gr. ammo. Originally, the gun was shipped to me so that Jim Thomas of WGN-TV and I could make a movie for his outdoor show and for Remington, but a severe snow storm forced a postponement of these plans.



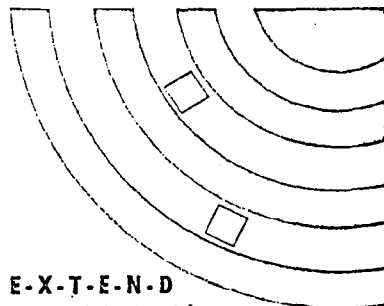
The 200 gr. rounds are loaded with 53.7 gr. of a non-cannister powder. RCBS air-mailed me a set of loading dies, thus enabling me to reassemble the rounds and also start some handloading before the gun had to be returned to Remington.

All testing was done with open factory sights, and penetration tests with Remington ammo and with handloads were nothing short of spectacular. Here are the factory ballistics. It should be noted that these data were compiled with a Remington 600 Magnum gun and a 18½ inch barrel. The data due to be published later were determined with a 20 inch test barrel, and they will therefore differ somewhat.

The ballistics and the inherent accuracy of the gun and the ammunition qualify this Remington creation as an out-and-out big game rifle. Wayne Leek and Les Bowman, big game guide and ballistics experimenter,

but also considerable destruction. One bottle containing frozen water shattered so completely that parts of the bottle were never recovered. Although this is by no means a scientific test, it does indicate that heavy bone, when hit with the 200 gr. bullet from the .350 Magnum, will be damaged considerably and there should be little doubt that the .350 will anchor big and dangerous game. Several experienced Kodiak bear guides, who also saw and fired the gun, consider the .350 Remington Magnum as the ideal big bear rifle in the thick alder country they hunt.

Accuracy tests were hampered by lack of enough factory ammo. All firing was done at 50 yards and range temperature was a chilly 7° with a 15 mph wind. Several three shot groups from the bench averaged 2 inches center to center, but I am confident that the gun is capable of better accuracy. The rela-



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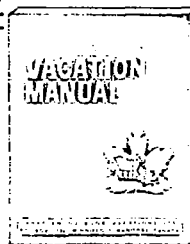
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CANADIAN OUTDOOR VACATIONS  
P.O. Box 1166 "K," WINNIPEG, CANADA.

Name .....  
Address .....  
City ..... State .....

#### 200 gr. Pointed Soft Point Core-Lokt

Range (Yds.)	Velocity (fps)	Energy (ft./lbs.)	Drop (Inches)	MRT (Inches)	Trajectory (Inches) sighted in at 200 yards
0	2725	3290	—	—	—
100	2355	2465	2.6	0.7	+ 2.7
200	2025	1820	11.5	3.2	0
300	1730	1325	28.9	8.3	-11.2
400	1470	960	58.1	17.6	-34.2
500	1260	705	103.3	32.7	-73.2

#### 250 gr. Pointed Soft Point Core-Lokt

Range (Yds.)	Velocity (fps)	Energy (ft./lbs.)	Drop (Inches)	MRT (Inches)	Trajectory (Inches) sighted in at 200 yards
0	2410	3220	—	—	—
100	2135	2535	3.2	0.8	+ 3.4
200	1885	1975	14.1	3.8	0
300	1660	1530	34.8	9.8	-13.2
400	1460	1185	68.2	19.9	-39.0
500	1285	920	118.0	35.9	-81.3

put the .350 through its paces last hunting season. All of the kills were one shot ones, and ranges varied from 75 yards right out to 250 yards. Mule deer and antelope dropped in their tracks, and one large moose moved a few yards before succumbing to the effect of the bullet. Both men were trophy hunting, thus were not overly concerned with meat damage, but they agreed that damage with the .350 was not any greater than that caused by any of the .30 caliber magnums.

Firing from 25 yards at a five inch thick seasoned oak log, the 200 gr. Remington bullet tore clear through the log, leaving an exit hole of about .50 caliber. Shooting into the end grain of the same log from the same distance, bullet penetration was six inches. Plastic bleach bottles filled with water, when hit from varying distances, showed not only excellent bullet performance

tively poor showing was due to the use of the iron sights and the wind made shooting a chore rather than a pleasure. Handloads with the 200 gr. Norma bullet averaged 1.75 inches, and the 250 gr. Speer bullet groups averaged 2.15 inches. On the Remington range at Ilion, New York, scoped rifles produced several excellent groups at 100 yards. Wayne Leek told me of a number of five shot, 100 yard targets where groups measured 0.75" from center to center.

The .350 Remington Magnum cartridge and the Model 600 Magnum carbine chambered for this potent cartridge, offer the big game hunter a powerful, if not the most powerful, bolt-action carbine on the market today. I hope to have a chance to try the new Remington combination on big game shortly and will also report on further ballistics tests as soon as ammo becomes more plentiful and weather conditions permit.

#### COLT .45's

We have 12 only of these Colt Army autos. Conditions range from NRA good to NRA excellent. Prices from \$40 to \$55. Send stamp for complete list and details of sale.

DISTRICT MERCHANTS CO.

1000 14th St. Alexandria, Virginia

#### IMPROVE YOUR SHOOTING with Franzi's GRIPS

FRANZI'S GRIPS, made by Sports, Inc., are hand-made, comfortable, long-lasting, and come in 7 colors. New color: dark red. For almost any gun make—Colt, Smith & Wesson, Iver, Remington, Savage, S&W, etc. Every barrel, wood, steel, alloy, etc. grips, slings, holsters, gun bags, etc. Write for FREE catalog. SPORTS, INC., 1000 14th St., Alexandria, Va. 22304



c.c. S.M. Alvis ✓  
E.S. McCawley

February 16, 1965

Ludwig E. Olson  
Associate Technical Editor  
THE AMERICAN RIFLEMAN  
1600 Rhode Island Avenue, N.W.  
Washington, D.C. 20036

Dear Mr. Olson:

In regard to your letter of February 10th, requesting differences between the Remington Model 600 Magnum Carbine and the Remington Model 600 standard carbine - see advertising material enclosed. This material includes also an instruction folder for each type of carbine. The differences are quite well itemized for each one in this material.

However, to briefly sum up the basic differences they are as follows:

- Barrel - magnum weighted, that is, larger in O.D. Raised barrel bracket has been introduced on this model as a telescope back up support in the forward position.
- Action - same as standard model except custom bedded in stock.
- Stock - laminated of two different woods, walnut and beech for greater strength, stability, etc.
- Finish - the over-all protective finish to the laminated stock is the DuPont RK-W type. This finish is similar to the type now in standard use for the 700, 1100 etc. The standard Model 600 has the traditional lacquer type finish.
- Weight - approximately 1 lb. greater than the standard model and that is 5 1/2 lbs. versus 6 1/2 lbs.
- Recoil Pad and Sling Strap - standard items furnished on the Magnum Model and included in the retail price. That is, items are extra cost accessories for the standard 600 Model. The list price of the Magnum Model - \$119.95. The retail list price for the regular model is \$99.95.

The Magnum Model, of course, is introduced in only one caliber - .350 Remington Magnum - and two different bullet weights, the 200 and the 250 grain.

If any other additional information is needed please advise.

Sincerely yours,

JFF:ie  
Enc. 4

J.F. Finnegan  
Ilion Research Division



**PETERS**  
DU PONT



## PETERS CARTRIDGE DIVISION

REMINGTON ARMS COMPANY, INC.

*Manufacturers of Sporting Ammunition*

BRIDGEPORT 2, CONN.

CABLE - PETERIDGE, BRIDGEPORT

July 21, 1955

*File 70/721-72-Advertising*  
TO REMINGTON FIREARMS AND PETERS AMMUNITION WHOLESALERS

### ANNOUNCING A REMARKABLE

EXTRA LONG RANGE VARMIN'T AND GAME SHOOTING TEAM

NEW REMINGTON MODEL 722 BOLT ACTION CENTER FIRE RIFLE

AND

NEW PETERS "HIGH VELOCITY" 244 REM. CAL. CARTRIDGE

Gentlemen:

Shooters have asked for a new cartridge and rifle combination which would give them the same speed, accuracy and flat trajectory as the fast selling Peters 222 Remington medium range cartridge but in a larger, double-duty caliber ... for extra long range varmint and bigger game shooting.

Remington-Peters research has answered this demand with the Remington Model 722 rifle chambered and designed for the Peters 244 Remington caliber extra long range center fire cartridge.

The new cartridge is available in two top performance bullet weights - 75 grain and 90 grain Pointed Soft Point. Ballistic figures prove that the 75 grain varmint weight Pointed Soft Point bullet really begins to show off at those "way out" ranges. At 500 yards it delivers 55% more bullet energy than the 220 Swift, and with phenomenal accuracy!

For larger game, such as deer and antelope, the 90 grain Pointed Soft Point bullet is remarkably effective for open long range shooting. Its tremendous speed and flat trajectory give the hunter a big advantage when squeezing off shots that have to cover long distances and still deliver knockdown wallop. The ballistic figures to prove it are attached.



July 21, 1955

The new rifle that will give this new cartridge the send-off it deserves is the Remington Model 722 in Peters 244 Remington caliber, of course! From its crisp match trigger to its precision-bored special weight 26" barrel, the Remington bolt action, high power Model 722 meets all requirements for an accurate long range varmint and game combination.

PRICES, SPECIFICATIONS AND TERMS

MODEL 722 RIFLE - 244 REMINGTON CALIBER

The Model 722 rifle in Peters 244 Remington caliber has the same specifications as the Model 722 in 222 Remington caliber now shown in our price list effective February 1, 1955, except for the magazine capacity of 4 and precision-rifled, special weight 26" barrel, chambered and designed for the new caliber. Retail price \$89.95. Complete price sheet is attached.

PETERS "HIGH VELOCITY"

244 REMINGTON CENTER FIRE CARTRIDGE

<u>Index</u>	<u>Weight</u>	<u>List</u>	<u>Wholesale Prices Per Thousand</u>					<u>Retail</u>	
	<u>Bullet</u>	<u>Case*</u>	<u>per</u>						<u>Box of</u>
<u>No.</u>	<u>Grs.</u>	<u>Lbs.</u>	<u>1000</u>	<u>Zone 1</u>	<u>Zone 2</u>	<u>Zone 3</u>	<u>Zone 4</u>	<u>Zone 5</u>	<u>20</u>
2441	75	51)							
		)	\$182.50	137.23	137.58	137.93	138.28	138.63	3.65
2442	90	53)							

The terms and conditions outlined in our letter of December 17, 1954 will apply. The above wholesale and retail prices are Fair Trade prices in those states having Fair Trade Laws.

ADVERTISING MATERIAL

An attractive catalog page featuring this new combination will be available shortly. It will be sent to you in quantities which you have previously specified for pages of this type. If you need additional copies we will be glad to send them to you.

Electrotypes of this new cartridge in actual size, plus electrotypes of the rifle in sizes 2-5/8, 3-1/4, 4 and 6 inches will be furnished promptly upon request without charge.



July 21, 1955

DELIVERIES

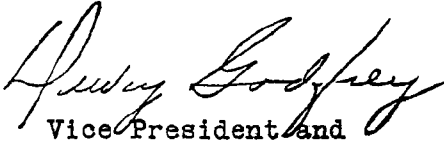
Delivery of both cartridges and the Model 722 rifle in this caliber will begin immediately upon receipt of your order.

We know that this excellent dual-purpose caliber will add to the enjoyment of shooters everywhere. But, what's more, it will increase your sales - just as many other Remington-Peters "firsts" in firearms and ammunition have done in the past.

Place your orders now because now is the time to cash in on another fast-selling Remington rifle and Peters cartridge combination.

Sincerely yours,

PETERS CARTRIDGE DIVISION  
Remington Arms Company, Inc.

  
Vice President and  
Director of Sales

Dewey Godfrey:M/bmh  
Attach.

\*Quantity - 1,000 per case.



MODEL 722 - 244 REMINGTON CALIBER

PRICES

	<u>Net to Jobbers</u>	<u>Wholesale</u>	<u>Retail</u>
No. 722A "Standard" Grade	\$52.77	\$67.45	\$89.95
No. 722ADL "DeLuxe" Grade with hand checkered stock and sling swivels	\$70.22	\$85.80	\$108.40
No. 722BDL "DeLuxe Special" Grade with hand checkered stock of selected wood and sling swivels	\$73.48	\$90.65	\$120.95
No. 722D "Peerless" Grade	\$347.25	\$407.25	\$494.45
No. 722F "Premier" Grade	\$657.26	\$770.50	\$907.45

The U. S. Excise Tax of 11% should be added to the net price, but this is included in the wholesale and retail prices.

The terms and conditions outlined in our letter of January 21, 1955 will apply. The above wholesale and retail prices are Fair Trade prices in those states having Fair Trade Laws.



BALLISTICS

PETERS "HIGH VELOCITY"

244 REMINGTON

<u>Index</u> <u>No.</u>	<u>Bullet</u> <u>Wgt.</u>	<u>Style</u>	<u>Muzzle</u>	<u>100 yd</u>	<u>200 yd</u>	<u>300 yd</u>	<u>400 yd</u>	<u>500 yd</u>
<u>VELOCITY - Feet per Second</u>								
2441	75	Pointed Soft Point	3500	3070	2660	2290	1960	1670
2442	90	Pointed Soft Point	3200	2850	2530	2230	1960	1710
<u>ENERGY - Foot Pounds</u>								
2441	75	Pointed Soft Point	2040	1570	1180	875	640	465
2442	90	Pointed Soft Point	2050	1630	1280	995	765	584
<u>MID-RANGE TRAJECTORY - Inches</u>								
2441	75	Pointed Soft Point		0.4	1.9	4.9	10.0	18.5
2442	90	Pointed Soft Point		0.5	2.1	5.5	11.0	20.0



## DON'T SAY IT—WRITE IT

To E. J. GarrityDATE 11-19-52FROM S. N. Alvis

John Finnegan just called attention to the fact that the new Steeger's catalog (1953) page 82 has an error with reference to the barrel specifications for the 28-Ga. Model 11-'48. John says this is listed as a 28" Vent. Rib, whereas all barrels for this gauge are manufactured to the 25" length.

Am not sure that you are the one that we should take this up with; if not, would appreciate your passing on for proper handling, especially since this may be an error carried over from some of our own literature.

SMA:LF

*Jan*  
S. N. Alvis

Arms Research &amp; Development Division

CC: J. F. Finnegan-File

NO ONE WAS EVER INJURED OBEYING SAFETY RULES



G-88-REM

DON'T SAY IT—WRITE IT

TO SMA.

DATE 11-17/52

FROM J. Finnegan

Stoeger Catalog  
Page 82

error - m/11-48 28ga has a 25" barrel  
Vent Rib. instead of 28" as listed

ARE YOU DOING YOUR SHARE IN SAFETY?

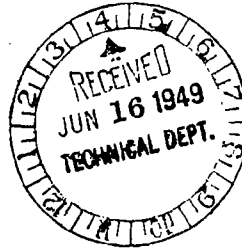


**REMINGTON ARMS COMPANY, INC.**

INTER-DEPARTMENTAL CORRESPONDENCE

**Remington**  
SUPER**PETERS**  
SUPER

PUBLIC RELATIONS DIVISION

Bridgeport, Conn.  
June 15, 1949

TO: S. M. ALVIS  
FROM: H. P. DAVIS

Enclosed are three copies of the brochure  
"What the Experts Say About the New Remington Models  
721 & 722." A similar booklet is being prepared on  
the Sportsman 48 and the Model 11-48. When these are  
ready for distribution, we will send you a supply.

HPD:JV  
Enc.





# REMINGTON ARMS COMPANY, INC.

MANUFACTURERS OF  
SPORTING FIREARMS, AMMUNITION  
TRAPS TARGETS

ARMS WORKS, ILION, N. Y.  
AMMUNITION WORKS, BRIDGEPORT, CONN.  
CABLE—HARTLEY, BRIDGEPORT—ALL CODES

BRIDGEPORT 2, CONN.

PETERS CARTRIDGE DIVISION  
BRIDGEPORT, CONN.  
TRAP AND TARGET WORKS  
FINDLAY, OHIO



January 10, 1950

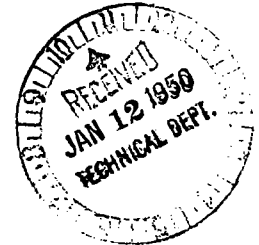
## ANNOUNCING

THE NEW REMINGTON MODEL 722 BOLT ACTION REPEATING RIFLE

CHAMBERED FOR

THE NEW 222 REMINGTON CARTRIDGE

*James  
Kinzer*



2 - Mr. S. M. Alvis,  
Remington Arms Co., Inc.,  
Ilion,  
New York

COPY OF LETTER SENT TO  
ALL FIREARMS JOBBERS

Gentlemen:

Remington marches on and to meet the demands of a great many discriminating sportsmen, has developed an entirely new long range varmint cartridge for use in the famous Remington Model 722 rifle.

The ballistics of this amazing new cartridge, supplied with 50 grain soft point bullet, are convincing evidence of its superior performance.

<u>Range in Yds.</u>	<u>Velocity Ft. Sec.</u>	<u>Energy Ft. Lbs.</u>	<u>Mid-Range Trajectory Inches</u>
Muzzle	3200	1135	--
100	2660	785	0.5
200	2170	520	2.5
300	1750	340	7.0

THE BULLET OF THIS NEW CARTRIDGE MUSHROOMS PERFECTLY. UPON IMPACT WITH THE GROUND OR OTHER OBSTACLE THE BULLET DISINTEGRATES, THUS PREVENTING DANGEROUS RICOCHETS. THE ACCURACY OF THIS CARTRIDGE WILL MEET THE REQUIREMENTS OF THE MOST FASTIDIOUS VARMINT SHOOTER.



JANUARY 10, 1950

The Remington Model 722 rifle, chambered for the new 222 Remington cartridge, will be regularly supplied with:

\*26" ROUND, TAPERED BARREL, CAREFULLY BORED AND RIFLED FOR EXTREME ACCURACY.

\*HIGH COMB STOCK, ESPECIALLY DESIGNED FOR USE WITH TELESCOPE OR RECEIVER SIGHT.

\*6-SHOT CAPACITY - FIVE IN THE MAGAZINE AND ONE IN THE CHAMBER.

\*WEIGHT - ABOUT 7-1/2 POUNDS.

\*LENGTH OVER-ALL - 45-1/4".

\*ALL OTHER SPECIFICATIONS ARE THE SAME AS THE MODEL 722 IN OTHER CALIBERS.

#### PRICES

The price of the Model 722 rifle, chambered for the 222 Remington cartridge, is the same as that of other calibers in this model, as shown in our price list, effective January 4, 1950.

The 222 Remington cartridge will list at \$99.50 per thousand and will be included in our new ammunition price list to be issued shortly.

#### ADVERTISING MATERIAL

An attractive catalog page and descriptive folder featuring the new rifle and cartridge will be available in a short time. If you will let us know on the enclosed order blank how many you will require, they will be sent to you promptly.

Electrotypes in sizes 2-5/8, 3-1/4, 4 and 6 inches will be furnished promptly upon request without charge.

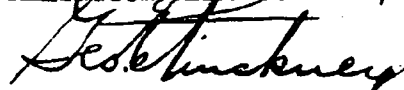
#### DELIVERIES

Deliveries of the rifles will begin by the end of this month and will continue throughout the year. These rifles are included in your allotment of Model 722 for 1950 and we suggest that you specify some of them on your order covering the allotment.

The cartridges are now available and can be shipped promptly upon receipt of your order.

We feel confident that the new combination will be hailed by varmint hunters everywhere and will meet their most exacting requirements.

Yours very truly,  
REMINGTON ARMS COMPANY, INC.



Manager, Products Sales Division

GEP:RHL



Remington Arms Company, Inc.  
Bridgeport, Conn.

Gentlemen:

Please send us, without charge, the following  
literature featuring the new Remington Model 722 Bolt Action  
Repeating Rifle and Cartridge in 222 Remington caliber:

Catalog Pages \_\_\_\_\_

Descriptive Folders \_\_\_\_\_

These should be marked for the attention of

---

Yours very truly,

Mr. S. M. Alvis,  
Remington Arms Co., Inc.,  
Ilion,  
New York



CC: E. J. Connelley  
D. S. Thayer  
H. A. Brown-File

Eliza, New York, October 8, 1948

TO: G. O. Clifford

FROM: S. M. Alvis

SUBJECT: ADVERTISING

For your information, we note that the November Issue of THE magazine includes an article by Lucian Gray on "Choosing Your Big Game Rifle". It is more or less dominated by discussions on the Model 721 all of which appears to be favorable. However, we did note one error in that he leaves the impression that the 300 Wagon Caliber may not be available, whereas all of our advertising matter has in the past included this caliber.

This brings to mind a point which was recently made by Warren Page, of FINCH & STERN, when he stated that they receive very little information from Remington in connection with full details on Arms development, whereas Winchester keeps them well supplied with "propaganda".

S. M. Alvis  
Arms Technical Division

SM:LI



## DON'T SAY IT—WRITE IT

TO J. D. MitchellDATE 6-13-49FROM S. M. Alvis

When Colonel A. L. Keyes, of the West Point Museum, called at the Plant On Friday, the writer presented him with our copy of the brochure entitled "What the Experts Say about the New Remington Models 721 and 722 Big Game Rifles". We would therefore appreciate your sending us possibly two or three additional copies for future similar occasions.

S. M. Alvis  
Arms Technical Division

SMA:LJ



CC: G.O.Clifford  
H.E.Faulkner  
H.J.Hackman  
D.S.Foots

Ilion, New York, February 3, 1949

TO: G. E. Pinckney

FROM: S. M. Alvis

SUBJECT: MODEL 721 - ADVERTISING

We note three items of special interest to the Model 721 as printed in the February issue of "The American Rifleman".

The first is in an article "Wanted: A Sniping Rifle", by Lt. Col. E. C. Hicker, in which he makes a reference to the full supported bolt head of the M/721, in fact, on the bottom of Page 26 he even suggests that Ordnance "adopt the 721 action from Remington".

On Page 41 there is an article entitled "Remodeling the Remington 721" and we were somewhat amused and knew that you would be interested in the statement in the second paragraph, Page 41, which reads "First, cut away the rear sight lug which the manufacturers neglected to take off when they made the gun".

Finally, there are three paragraphs on Model 721 Accuracy on Page 54 as a part of General Hatcher's "Dope Bag".

S. M. Alvis  
Arms Technical Division

SMA:LJ



Ilion, New York, December 22, 1948

TO: J. D. Mitchell

FROM: S. M. Alvis

SUBJECT: ADVERTISING BROCHURE

Will you please procure and mail to us an additional copy of the brochure entitled "What the Experts Say about the New Remington Models 721 & 722 Big Game Rifles".

S. M. Alvis  
Arms Technical Division

SMA:LJ



Remington

# ARMS and AMMO MAN



TOM FRYE

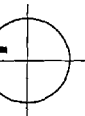
If there ever was a "Shooters Hall of Fame" chances are thousands of hunters, target shooters, dealers and wholesalers would want to see Tom Frye, the "Remington Man" from Billings, Montana, at the top of the list. In shooting circles, almost everyone knows Tom, and those that don't, have probably heard of him. Knowing all about guns, ammunition and shooting is his job... he's an expert. Remington has many men throughout the country who also are authorities on the shooting sports, but we'll tell you about them later. In this issue we want to give you some interesting facts on Tom's background. For example:

He has hunted everywhere from Canada to Mexico to Hawaii; high in the Rocky Mountains for bighorn sheep and elk in Wyoming and Montana for deer and antelope... in the pin oak flats of Arkansas for mallards, taken Canada Honkers at Mattamuskeet, Chinks in South Dakota, and on and on. He is probably the finest marksman in the country on moving targets. Tom has busted 1134 skeet targets in unregistered competition without a miss; and in 1963 he took Trappshooting World Series; The North American Professional Clay Target Championship. And another unique record: Tom shot over 100,000 2 1/2" hand-thrown wood blocks with a Remington Nylon 66 22 caliber rim fire automatic rifle with only 6 misses. He shattered the old record of 72,500 with 9 misses.

A shooting expert? That's for sure. This is the type of men Remington has in the field—many of them. And as a Remington Field Representative, Tom has his finger on the shooting pulse of his territory and gives freely of his shooting talents. He talks to shooters, dealers and wholesalers and helps them in every way he can; teaches new shooters, helps a gun club getting started, cooperates with conservation agencies. Actually he's a link (and a strong one) between the factory and the consumer... and the trade in between. Frequently his reports contain comments like, "Customers want a different type of sight on Model 600!" Or, "Dealers can use more catalogs and counter display material." And about a certain wholesaler: "Economic condition good; just moved into a larger warehouse and plans on increasing order by additional car of ammo." A good job—important communications from you—to us? You bet... and we listen.

Although Tom Frye works for Remington, he probably works harder for you... the shooter, the dealer, the wholesaler. We hope you'll think of him as *Your Man* in Montana and parts of Wyoming and Idaho. And take our word for it, you've got a good man.

## ON TARGET



### 'OLD RELIABLE'

Next time you're selling a man a Model 870 pump shotgun you might tell him about the letter Remington received from shooter Everett Terry. After firing almost a quarter of a million shells in his 870, Terry sent it back to Remington's Iliou, New York factory for an overhaul... after 15 years of use. The letter said: "An occasional cleaning and oiling was the extent of the gun's upkeep. No malfunctions have occurred due to mechanical failure." Sounds unbelievable doesn't it... but it's true.

### WORLD'S FAIR SIDE EXCURSION?

Speaking of Iliou, New York: if you or your customers are ever in the vicinity of Remington's firearms factory, which is located here, please drop in and visit the famous Remington Gun Museum. Open 24 hours a day—7 days a week—no admission charge—and it's a gun lover's heaven with a priceless collection of all the famous Remington's made in the last 149 years.

... and that reminds us: Next year, Remington will have been making sporting firearms for a century and a half. Interesting note: More advancements in guns and ammo have been made in the last 25 years than in all the other 125 years.

### NEW SPORTS MOVIE

Holding a "Hunters' Nite" or similar gathering with a sports audience? There's a great new 15 minute, 16 mm sound and color Remington movie free for a 2-day booking: "PLASTIC SHELLS" is the title and it's an inside story of how Remington developed, tested and produced these now-famous extra-performance shells. To obtain a print for your showing, write:

Modern Talking Picture Service, Inc.  
3 East 54th Street  
New York 22, New York

Allow six weeks for scheduling... it's a mighty popular film.

### "TOUGHY"

You'll be interested in this: We say the Nylon 66 automatic 22 rifle is tough—and Alaskan fishermen think so, too, as they use it on their fishing boats to keep sea lions out of their nets. Salt spray, foul weather, fish slime and mud knock out other 22's. But not the Nylon 66. This is why these fishermen look on the Remington Nylon 66 as almost a "tool-of-the-trade." Still further proof. Trappers in the humid bayous along the Gulf States swear by the "gun with the nylon stock." Why? Same reasons; it's tough, it works under all conditions. It stands up... and it's exceptionally accurate. It's the one gun you sell that's so good it's guaranteed: "WE GUARANTEE that this stock will not warp, crack, chip, fade or peel for the life of the rifle—or we will replace it free. Only Remington can make such a guarantee because only Remington makes precision-built stocks of tough, structural DuPont "ZYTEL" nylon.

Remington

Peters

ARMS

DEALER

VOLUME 1 NUMBER 1

FEBRUARY 1965

## Response to Dealers' Suggestions shown in New-For-1965 Products from Remington

New models and calibers, finer finishes, improved performance and added 'visible value' for shooters all give dealers a '65 Remington line packed with extra sales appeal

## HERE'S THE NEW MODEL 600 MAGNUM CARBINE

in new 350 Remington Magnum caliber



Most powerful... most accurate... most rugged big game carbine made!

This great new gun was, in a sense, 'dealer designed'—developed by Remington in response to dealers' requests. They said the regular Model 600 sold so well... why not make it in a magnum? So we did.

The Model 600 Magnum slams a 200 grain bullet out the muzzle at 2725 feet per second; it moves a 250 grain bullet at 2410 f.p.s. at the muzzle. And to handle all the power of these new 350 Remington Magnum loads, there's a magnum barrel, a tremendously strong and rigid stock made of laminated beechwood and walnut, and a recoil pad... and of course, the world's strongest bolt with cartridge head enclosed by 3 rings of steel.

Other extra-value features dealers said shooters would appreciate: Extra wide trigger—rotating thumb safety—forward "S" bolt handle—custom checkering—Monte Carlo stock—anti-vibration back up bracket for scope mount—free floating barrel for maximum accuracy—barrel bracket bedded in a special epoxy and exclusive DuPont developed RK-W 'bowling pin' wood finish. It has phenomenal accuracy, with 1 1/4" groups being reported by several men who have fired this new carbine. And here are two big exclusive selling points to tell customers: First; it's the only carbine made in a high power belted

magnum caliber. Second; it's the only production model hunting rifle made with a laminated stock. If you haven't seen this new rifle, you'll want to ask your wholesaler to show you one.

### SPECIFICATIONS • REMINGTON MODEL 600 MAGNUM

CALIBER	350 Remington Magnum
ACTION	Bolt, Repeating
CAPACITY	4 shot
MAGNUM BARREL	Tapered, Remington proof steel 18 1/2" with ventilated rib matted between sights.
LENGTH	37 3/4" over all, includes recoil pad.
STOCK	Laminated American walnut and beech. Custom checkering on fore-end and pistol grip. Monte Carlo stock with fluted comb. Sling strap and quick release swivels. 14" length of pull. 2" drop at heel, 1 7/8" drop at comb. Recoil pad with black & white spacers.
RECEIVER	Drilled and tapped for receiver and scope mounts. Scope shoulder for scope back up. Fixed magazine.
SIGHTS	Blade ramp front sight with brass bead. "U" notch rear sight adjustable for elevation and windage with adjustment screws.
SAFETY	Positive rotary thumb type with corrugated non-slip surface.
WEIGHT	6 1/2 lbs.
ORDER NO.	5724

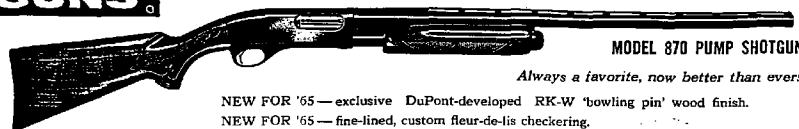
Remington, Peters

REMINGTON ARMS COMPANY, INC., BRIDGEPORT, CONNECTICUT 06602

PRINTED IN U.S.A.



# GUNS



MODEL 870 PUMP SHOTGUN

*Always a favorite, now better than ever!*

NEW FOR '65 — exclusive DuPont-developed RK-W 'bowling pin' wood finish.  
NEW FOR '65 — fine-lined, custom fleur-de-lis checkering.

"How would you like the Model 870 changed in 1965? we asked dealers.

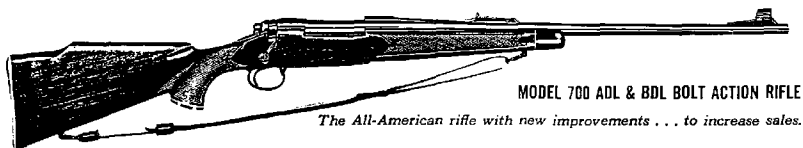
"Don't change a thing!" was the universal response. And no wonder: 'Old Reliable' 870 has been pleasing customers ever since its introduction. And so we left the working parts alone. The double action bars and the ball-bearing smoothness, the shell-shocking speed are all still there. So is the positive cross-bolt safety, the hardened barrel extension and the solid steel receiver.

But dealers — and shooters — will notice a new luxury look in the 1965 "Wingmaster." There's a new scratch-and-mar resistant RK-W 'bowling pin' wood finish — exclusive with Remington. And the checkering is now fine-lined fleur-de-lis pattern. So a great gun gets even better. There's new 'visible value' for you to sell and shooters to appreciate...

in one of the most popular shotguns ever manufactured in the history of shooting. 'Old Reliable' 870... now it looks like a million — and more than a million of 'em have been bought by satisfied shooters!

## MODEL 1100 TB AND MODEL 870 TB & TC TRAP GUNS NOW AVAILABLE WITH OPTIONAL MONTE CARLO STOCKS

Dealers who number trap shooters among their customers suggested we make our trap guns with an optional Monte Carlo stock, as customers wanted them and would be willing to pay a modest increase for this "extra." The important thing — it would increase sales. So — here they are, and we think you and trapshooters will agree — we've held to a pretty fair definition of that word "modest..." Ten bucks. Another new for '65 feature to help you sell.



MODEL 700 ADL & BDL BOLT ACTION RIFLE

*The All-American rifle with new improvements... to increase sales.*

NEW FOR '65 — longer (22") barrels in six standard calibers —  
NEW FOR '65 — exclusive Remington RK-W 'bowling pin' wood finish —  
NEW FOR '65 — new detachable sights and filler screws —  
NEW FOR '65 — hot new varmint caliber: 22-250 Remington with 3760 f.p.s. muzzle velocity.

What does a gunmaker do to improve a bolt-action rifle that is already best? And why do it if the gun is already rated tops by dealers and hunters? Well, no drastic changes were ever required since the Remington Model 700 was introduced, but some shooters and dealers suggested certain ways in which this model could be made even more popular — more saleable than it already is. One, they said a super-fast varmint caliber would find a ready market among the flat-shooting, long range fans. Two, maybe the beauty of the wood could be permanentized. Three, how about a slightly longer barrel in the popular standard calibers? And four, couldn't the sights be made readily detachable for the convenience of shooters who use scopes?

Well taken points, thought Remington gun designers. And so for 1965, the famous Model 700 ADL and BDL will be better than ever... with scratch-and-mar resistant 'bowling pin' wood finish through the exclusive Remington RK-W process, longer 22" barrels in 6m/m Remington, 243 Win., 270 Win., 280 Remington, 30-06 and 308 Win. calibers, and sights removable with just a screwdriver (filler screws are already in tapped scope holes in the receiver — use them to plug the sight fastening holes).

And, for the booming varmint market, both ADL and BDL models are available in the hot new 22-250 Remington

ton caliber (travels at a sizzling 3760 feet per second at the muzzle). Bullet in the new cartridge is a 55 grain Pointed Soft Point. The 22-250 has a long history as an excellent varmint — has won many bench rest matches — and nearly duplicates the velocity of the 220 Swift... but without the noise. And it's a hand loader's delight. The bolt-action buyer expects accuracy and in a Remington 700 he gets it. In any caliber, in any model, the Remington 700 has a well-deserved reputation for supreme accuracy among men who know guns. Dealers — here's a fact that's being proved every day. In the Model 700, the customer has been getting more gun for his money than anything else in its class. Now — with these features — he's getting even more!

## MODEL 600 BOLT ACTION RIFLE Additional caliber choice for a popular, fast-selling model

NEW FOR '65 — Now available in 243 Win. Caliber.

Model 600 has attracted plenty of shooter interest ever since it went on the market... and in the brush-busting 35 Remington, big game 308, flat shooting 222 Remington and 6 mm Remington it offered shooters a big choice of loads for many types of game. Now, for the shooters who swear by the 243 Win., this fast-handling, easily packable lightweight carbine is ready for their type of shooting. Weight is still just 5½ lbs., overall length is 37¼ inches... which specifications make it one of the best-handling carbines a shooter ever packed.

NEW IN 4 RARE WHITE CALIBERS — Plus the 350 Remington Magnum in the Model 600 Magnum Carbine.

# AMMO

## PLASTIC SHELL NEWS: LONG RANGE FIELD LOADS NOW WITH "POWER PISTON" THAT HIT LIKE MAGNUMS

NEW FOR '65 — Remington "Express" and Peters "High Velocity" shells with "Power Piston" in 12, 16, 20 and 28 gauge... and 12 gauge magnums.



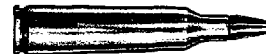
Here's the news dealers and hunters have been waiting for: High base plastic shells now have the "Power Piston" which is actually a combination wad column and shot container. Proved in 2 years of record-shattering performance in the toughest trap and skeet competition, "Power Piston" now gives field shooters more effective patterns at all ranges plus reduced recoil effect... to make hunting more enjoyable than ever. "Power Piston" protects and cushions the shot; there's no deformation — shot travels straight and true because it is perfectly round. They'll bag birds they might have otherwise missed... and make cleaner, surer kills with less cripples. In the history of shotgun field shooting,

there have been only a few major developments dealers could easily sell as a big shooter benefit: Smokeless powder — "Kleanbore" priming — plastic bodies — and now, in 1965, "Power Piston." This is the year you can offer your customers all those four major improvements... in the greatest game shell they've ever shot.

## NEW 20 AND 28 GAUGE PLASTIC SKEET LOADS WITH "POWER PISTON"

Last year the "Power Piston" was made in 12 gauge plastic skeet loads. Now it's available in 20 and 28 gauge, too. The performance-proved features that mean target-busting hits at all stations are: Plastic bodies — "Power Piston" combination wad column and shot container. In Remington and in Peters brands.

## 22-250 REMINGTON CENTER FIRE CARTRIDGE



NEW FOR '65 — and faster than any cartridge introduced since the 220 Swift!

This is the new hot one for varmint shooters; — it's chambered in Remington Model 700 rifle. It fires a 55 grain Pointed Soft Point bullet at 3760 feet per second muzzle velocity. It travels flat and fast... and is a big favorite with handloaders.

And here's the rest of the high speed story your customers will want to hear:

At 100 yards:	3230 f.p.s. velocity
200 yards:	2745 f.p.s. velocity
300 yards:	2305 f.p.s. velocity

In both Remington and Peters brands.

## 350 REMINGTON MAGNUM CENTER FIRE CARTRIDGE



NEW FOR '65 — first belted magnum cartridge designed for a big game carbine!

Your customer who buys the new Remington Model 600 Magnum carbine will be shooting one of the most powerful cartridges ever developed for a gun of its type. It's offered in two bullet weights, a 200 grain and a 250 grain, both Pointed Soft Point "Core-Lokt." This gun and cartridge combination will stop and drop any big game from Alaska to Mexico. Here are the convincing ballistics your customers will want to know about:

## REMINGTON & PETERS BALLISTICS (in an 18½" barrel)

Range (Yds.)	Velocity (f.p.s.)	Energy (ft. lbs.)	Trajectory (inches) sighted in at 200 yds.
<b>350 REMINGTON MAGNUM 250 Gr., P.S.P. "Core-Lokt" Bullet</b>			
0	2725	3290	—
100	2355	2465	+ 2.7
200	2025	1820	0
300	1730	1325	- 11.2
<b>350 REMINGTON MAGNUM 200 Gr., P.S.P. "Core-Lokt" Bullet</b>			
0	2410	3220	—
100	2135	2535	+ 3.4
200	1885	1975	0
300	1660	1530	- 13.2

This is unmatched performance in a short-action cartridge (and equaled or exceeded by only a few long-action loads). Alert dealers who note a high degree of "cartridge sease" in a customer will use the load to sell the gun. He can enjoy the one if he has the other. In both Remington and Peters brands.





# REMINGTON ARMS COMPANY, INC.



MANUFACTURERS OF  
SPORTING FIREARMS, AMMUNITION

TRAPS

TARGETS

POWER TOOLS

SPORTING FIREARMS  
ILION, N. Y.  
AMMUNITION, BRIDGEPORT, CONN.  
POWER TOOLS, PARK FOREST, ILL.

BRIDGEPORT, CONNECTICUT 06602

PETERS CARTRIDGE DIVISION  
BRIDGEPORT, CONN.  
TRAPS AND TARGETS, FINDLAY, OHIO  
CABLE - HARTLEY, BRIDGEPORT

*John F. Alvis*  
January 11, 1965

S. M. ALVIS

R & D ILION

TO OUR FIREARMS WHOLESALERS

Gentlemen:

Here's the NEW ONE ... the HOT ONE from Remington ...

MODEL 600 MAGNUM CARBINE  
in NEW 350 REMINGTON MAGNUM CALIBER

It's an exciting carbine - powerful, good looking,  
accurate - loaded with sales appeal and exclusive  
features such as:

- \* It's the only carbine made in a high power belted magnum caliber. It will roll over moose, bear, elk, deer ... in fact any big game in North America.
- \* And notice that laminated stock! It's the first production model hunting rifle ever made with a laminated stock (rich walnut and beech).
- \* For more features - and the list is a long one - please check the attached catalog page. And for additional copies, just fill in and return the attached order form. These pages were designed to help you and your dealers. Make 'em work for you.

Very truly yours,

*S. R. Hutchinson*

SRHutchinson/ecc  
Attch.

Manager  
Advertising - Firearms



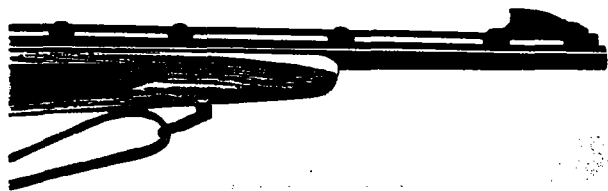
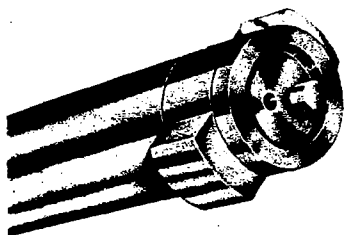
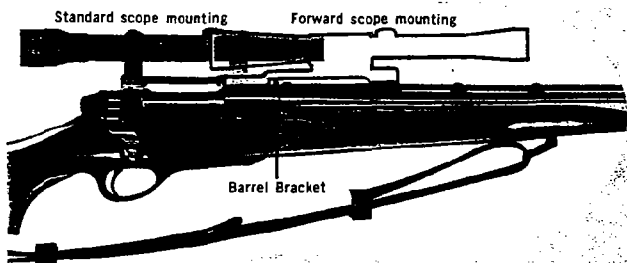
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*Most powerful...most accurate...*  
*most rugged* **BIG GAME**  
**CARBINE MADE!**



Range (Yds.)	Velocity (f.p.s.)	Energy (ft. lbs.)	Trajectory (inches) sighted in at 200 yds.	
0	2725	3290	—	350 REMINGTON MAGNUM 200 Gr., P.S.P.®Core-Lokt®Bullet
100	2355	2465	+ 2.7	
200	2025	1820	0	
300	1730	1325	— 11.2	
0	2410	3220	—	350 REMINGTON MAGNUM 250 Gr., P.S.P.®Core-Lokt®Bullet
100	2135	2535	+ 3.4	
200	1885	1975	0	
300	1660	1530	— 13.2	





- CUSTOM CHECKERING** on fore-end and grip is fine-lined, uniform, good looking. We suggest you do as other smart gun buyers do, **COMPARE** this checkering with that found on other makes of guns. Then judge for yourself.

**MONTE CARLO STOCK** with fluted comb means a better cheek-to-stock fit for quicker, surer sight alignment. Rich laminated walnut and beech stock has all-purpose dimensions which give perfect alignment with either a scope or open sights. Functional shape of fore-end provides a good reliable, non-slip grip for steady holding. Throw this rifle to your shoulder. See if you don't agree.

**RECOIL PAD** cushions the recoil of the game-getting 350 Remington Mag. caliber. Black and white spacers add to the Model 600 Mag's. good looks.

**ROTATING THUMB SAFETY** is conveniently located at the rear of the receiver where you can get at it in a hurry. Rearward for "Safe." Forward for "Fire."

**TRIGGER** is extra wide and corrugated; finger fits securely. Trigger pull is crisp and clean — no creep, no spongy action.

**FORWARD "S" BOLT HANDLE** hugs the stock — doesn't stick out — slips in and out of scabbard with ease. Half knob is serrated on the bottom so you get a good secure grip.

**SCOPE BACK-UP**—Strong bracket of steel forms scope mount back up. Scope mount rests snugly against bracket which takes vibration and recoil so that screws in mount are not jarred loose. Scope can also be mounted in forward position (with bracket as back stop) which gives long eye relief. This new trend in long eye relief scope mounting means shooter can get on target faster . . . instant sighting. See illustration at left.

**WORLD'S STRONGEST BOLT** — Cartridge head is completely encased by a ring of solid steel. When the bolt is closed, three rings of steel support the cartridge head. Strong? . . . there's none stronger.

**VENTILATED RIB** gives the Model 600 Mag. a new and rugged look. It's the first time a domestic, commercially produced sporting rifle has ever been designed with a ventilated rib. (Another first for Remington). It helps you aim, gives a definite sight-line so you can get on running game faster.

**BLADE RAMP FRONT SIGHT** with brass bead; and sturdy "U" notch rear sight is adjustable for elevation and windage. Receiver drilled and tapped for scope and receiver sights.

**MAGNUM BARREL** is designed to handle the powerful, hot 350 Remington Magnum caliber. It's free floating—extremely accurate—and punches out close groups consistently. Because of magnum barrel and excellent balance, recoil is not excessive.

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Remington. DU PONT

**REMINGTON ARMS COMPANY, INC., BRIDGEPORT, CONNECTICUT 06602**  
**IN CANADA: Remington Arms of Canada Limited,**  
**36 Queen Elizabeth Blvd., Toronto 18, Ontario** Printed in U.S.A.  
 Form No. AA-31





# REMINGTON ARMS COMPANY, INC.



MANUFACTURERS OF  
SPORTING FIREARMS. AMMUNITION

TRAPS

TARGETS

POWER TOOLS

SPORTING FIREARMS  
ILLION, N. Y.  
AMMUNITION, BRIDGEPORT, CONN.  
POWER TOOLS, PARK FOREST, ILL.

BRIDGEPORT, CONNECTICUT 06602

PETERS CARTRIDGE DIVISION  
BRIDGEPORT, CONN.  
TRAPS AND TARGETS, FINDLAY, OHIO  
CABLE - HARTLEY, BRIDGEPORT

REMINGTON OFFERS FOR '65...

December 30, 1964

A NEW MODEL 600 BOLT ACTION MAGNUM CARBINE

CENTER FIRE RIFLE

IN A "HOT" NEW BIG GAME CALIBER -

350 REMINGTON MAGNUM

## To Our Wholesalers

Gentlemen:

The most powerful...most accurate...most rugged big game  
CARBINE available is the new Remington Model 600 - chambered  
for the 'hot' new 350 Remington Magnum caliber.

Designed and precision engineered - for use on the largest  
North American game - the Model 600 Magnum Carbine is loaded with  
shooter appeal...guarantees more sales...more profits to you and  
your dealers.

- . New handsome laminated stock of select walnut and beech wood provides tremendous strength and rigidity, improves accuracy, and presents an attractive 2-color effect.
- . New Monte Carlo stock is "custom checkered" and protected with Remington's exclusive RK-W wood finish.
- . Overall 37-1/4" length and 6-1/2 lb. weight make the Model 600 Magnum Carbine just the right gun for hunting in any country.
- . World's strongest bolt - found only in Remington guns...wide serrated trigger with crisp, clean pull.



- . Newly designed barrel bracket provides positive support for scope bases...for either conventional mounting or forward mounting for long eye relief.
- . Magnum weighted barrel designed to handle the powerful 350 Remington Magnum cartridge.
- . Monte Carlo stock fitted with recoil pad and quick release swivels and sling strap.

#### AVAILABILITY

The new Model 600 - 350 Remington Magnum will be available in limited quantities for salesmen's sampling in January, 1965, and for stock shortly thereafter.

#### PRICES AND TERMS

	<u>Net to Wholesalers</u>		<u>Dealer</u>	<u>Retail</u>
	<u>Less Tax</u>	<u>Tax Included</u>		
Model 600 - 350 Remington Magnum	\$80.83	\$89.72	\$108.75	\$144.95
Ordering Number 5724				

The net prices are shown both with and without the U.S. Excise Tax of 11%. Dealer and retail prices include this tax. Terms and conditions as stated in our Firearms Wholesaler Appointment Letter with Prices and Terms of December 30, 1964, will apply. The above dealer and retail prices, effective January 4, 1965, will be established as minimum Fair Trade prices in all states having Fair Trade laws in effect.

#### ADVERTISING MATERIAL

Catalog pages and/or electrotypes in sizes 2-5/8" and 3-1/4" are available on request.



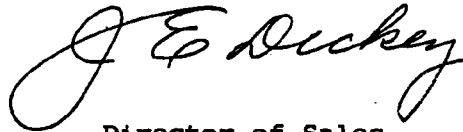
Model 600 Magnum Carbine

-3-

December 30, 1964

Increase your sales...and your profits...by sending us your orders promptly for this new MODEL 600 - 350 REMINGTON MAGNUM CARBINE.

Sincerely,

A handwritten signature in cursive script, appearing to read "J E Dickey".

Director of Sales  
Arms, Ammunition, Traps & Targets

JEDickey/mgm





# REMINGTON ARMS COMPANY, INC.



MANUFACTURERS OF  
SPORTING FIREARMS, AMMUNITION

TRAPS TARGETS

POWER TOOLS

SPORTING FIREARMS  
ILION, N. Y.  
AMMUNITION, BRIDGEPORT, CONN.  
POWER TOOLS, PARK FOREST, ILL.

BRIDGEPORT, CONNECTICUT 06602

PETERS CARTRIDGE DIVISION  
BRIDGEPORT, CONN.  
TRAPS AND TARGETS, FINDLAY, OHIO  
CABLE - HARTLEY, BRIDGEPORT

December 30, 1964

THE SENSATIONAL REMINGTON MODEL 600 BOLT ACTION CARBINE

CENTER FIRE RIFLE

NOW AVAILABLE IN THE POPULAR

243 WIN. CALIBER

To Our Wholesalers

Gentlemen:

Combining sales excitement and proven sales acceptance...  
the Model 600 Carbine, bolt action, center fire rifle, designed  
and engineered to give sportsmen everywhere that 'hard to beat'  
combination is now available in the 243 Win. caliber.

Really built to take the toughest punishment...the Model 600  
provides a new concept in carbines...fast pointing...versatile...  
easy to carry...easy to pack. Weighs only 5-1/2 lbs. with an over-  
all length of 37-1/4". The regular Model 600 Carbine, bolt action  
center fire rifle is now available in five favorite calibers...  
the powerful brush-busting 35 Remington...the 'big game' 308...  
the high velocity, flat trajectory 222 Remington...the long range  
6MM Remington...the popular 243 Win.

The Model 600 Carbine is loaded with sales appeal...unique  
in design... 'customized' checkering on American walnut stock -  
with the world's strongest bolt action, found only in Remington  
guns. Popularly priced...the Model 600 is the ideal gun for all-  
around shooting.



Model 600 Carbine  
243 Win. Caliber

-2-

December 30, 1964

AVAILABILITY

The new Model 600 - 243 Win. caliber, bolt action carbine, center fire rifle will be available for salesmen's sampling in early January, 1965, and for shipment of stock orders shortly thereafter.

PRICES AND TERMS

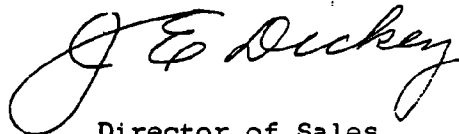
	<u>Net to Wholesalers</u>		<u>Dealer</u>	<u>Retail</u>
	<u>Less Tax</u>	<u>Tax Included</u>		
Model 600 - 243 Win.	\$55.75	\$61.88	\$75.00	\$99.95

The net prices are shown both with and without the U.S. Excise Tax of 11%. Dealer and retail prices include this tax. Terms and conditions as stated in our Firearms Wholesaler Appointment Letter with Prices and Terms of December 30, 1964, will apply. The above dealer and retail prices, effective January 4, 1965, will be established as minimum Fair Trade prices in all states having Fair Trade laws in effect.

-----

Increase your sales...and your profits...by sending us your orders promptly for this new caliber addition.

Sincerely,



Director of Sales  
Arms, Ammunition, Traps & Targets

JEDickey/mgm



cc: E.S. McCawley

June 9, 1964

Mr. Ken Warner  
Rt. 1 - Box 96  
Sarasota, Florida

Dear Mr. Warner:

I am in receipt of a letter you had written to Ted McCawley and also your note concerning some information required for an article involving the Remington Model 600 Rifle. I believe I have accumulated all the necessary information for you and will start by answering your questions as they occur in your letter.

By this time you have probably received the stock, which I hope meets with your approval. On our scales it weighs one pound eleven ounces. I chose that weight stock because it represents an average of ten which we had weighed originally, ranging in weights from one pound five ounces to one pound fifteen ounces. This stock coupled with a 308 Caliber M/600 should weigh at 5 lbs. 8 oz., the advertised specification. As you probably realize, we are making this rifle in four calibers, the 308 Win., 222 Rem., 35 Rem. and 6MM. They all vary in weights because of the bore size of the barrel, the 35 Rem. being the lightest, averaging around 5 lbs. 6 oz., and the 222 being the heaviest, averaging around 5 lbs. 12 oz.. That is, when we are comparing the average weight of 1 lb. 11 oz. of the stock with the actions. The actions only weigh 3 lbs. 13 oz. for the 308, 4 lbs. 1 oz. for the 222, and 3 lbs. 11 oz. for the 35 Rem. At the present time I haven't been able to get enough 6MMs all in one group to weigh them and determine their actual average. But I suspect this will suffice for your purposes.

As to the elements affecting weight reduction, the action itself was the greatest contributor because the barrel was reduced in length to approximately 18 1/2" and the receiver was reduced 3/4" under the shortest of our higher powered actions, in the Model 700. If you recall, the original Model 721 had two receiver sizes. We called it the M/721 and M/722, and they were approximately 3/4" different in length. This particular action is another 3/4" shorter than the M/722. At the same time when reducing the receiver the associated parts such as the bolt could be reduced in length, and therefore some weight saving was obtained in that part, along with the firing pin, firing pin retractor spring. A couple of modernistic cuts were placed upon the rear section of the receiver and the bolt plug, but the weight reduction accumulated in these areas was very small indeed, and the intent was not in the direction of weight reduction but more for a styling effect.



June 9, 1964

The barrel itself is rather husky in nature, especially in the breech section as you will note, and this was necessary for heavier caliber designs such as those involving the 35's.

One would expect the nylon trigger guard to contribute to weight reduction, and it does --- nylon weighing approximately one third that of aluminum, and aluminum roughly one third that of steel. This particular shape and design of the trigger guard, which is I believe original and a Remington style, has been found to be very rugged structurally and the nylon was most adaptable of all types of materials for this part. The nylon rib, we felt, added some aesthetic appeal to the rifle and made it more distinctive, setting it aside from others. It is floating on studs which are welded to the top of the barrel, the welding being at such a rapid rate that it does not effect the internal dimensions of the bore. The rib itself contains elongated slots which allow the rib to float, as I said previously, on the studs, and has no effect on the accuracy of the barrel, and will withstand high temperatures from rapid shooting generated into the barrel.

The rear sight and the front sight are mounted directly to the studs; therefore giving the utmost in accuracy by that direct mounting. This particular assembly is not unlike the XP-100 Pistol which was introduced ahead of the Model 600, and very intensive accuracy tests were conducted in both the rifle and the pistol to determine the effects of the rib on the barrel, and there were none whatever. As far as the ballistics are concerned, most ammunition charts list velocities and energies that have been obtained in 24" barrels. The particular pamphlet put out by Remington with their average ballistics in the 308 Caliber has been accomplished by using a 24" barrel. So I will list for you the results we obtained in actual measurement 3 feet from the muzzle using 180 grain bullets in 308 Caliber, in the Model 600, with an 18 1/2" barrel. The velocity was 2465 fps. In the Model 700, the same caliber, 20" barrel - velocity was 2525 fps. And in a pressure gun, the same caliber, 24" barrel - velocity was 2567 fps. So you can see the drop in velocity is rather insignificant when it comes to the compromise situation that a hunter or shooter must consider when weight or barrel length is involved. And the effect on game, for example, between the results on the Model 600 and the pressure gun, involving only 100 fps drop, would probably be immeasurable.

We determine the effect on shoulders by what we call shoulder force measurements, and have made two measurements for you, one on the Model 600 and the Model 700, weighing 5 1/2 lbs. and 5 1/4 lbs. respectively. We found that the shoulder force on the M/600 was 585 lbs., and on the M/700 was 415 lbs. I don't know whether this information pertaining to shoulder force is adequate for your needs, but if you need anything further in computations or measurements, please advise. This also applies to other information you might need pertaining to the gun.

With regard to your questions concerning the shorter barrel, of course we must stay within the limits of the Federal laws, which I believe is around 18", and we have



June 9, 1964

intended to make our barrels just slightly longer than the minimum legal limits so there will be no question about barrel lengths. The only really short barrel we ever made on these rifles was to compare 221 velocity versus the 222 by cutting off the barrels an inch at a time. And we did have one M/600 made up with a Mannlicher type stock which I think had a very pleasing appearance indeed. However, this requires longer stock blanks and very close manufacturing control for bedding, and other factors are involved along with the problem of unfortunately low sales appeal for Mannlicher stocks. I would not be surprised, however, to see some of the stock companies place Mannlicher stock blanks on the market for the Model 600.

I expect there have been several comments across the country about the timing of the Model 600 versus the XP-100 as to which model was created first, was introduced first, etc.. I can assure you that this was considered and that Remington kept within the limits of the law. The truth of the matter is that the XP-100 was conceived first, and all of the drawings and the models were made up and designated as pistols, and the items used in the receiver section were not originally involved with any rifle actions. As you probably know, the receiver section of the gun is the legal portion which is the gun, and the other parts are the accessories and appurtenances necessary to make it function. That is one of the reasons why the serial numbers are always placed on the receiver sections, since that is the basic gun. The original XP-100 design was made available to the Treasury Department for their ruling and approval before this item was placed upon the market, and the Model 600 was introduced one year later. The law states that it is illegal to convert rifles and shotguns into pistols, but it is not illegal to reverse this procedure, and therefore we have met the legal requirements by conceiving, designing and introducing this particular combination in the pistol first, prior to the introduction of the Model 600.

I trust this information will be adequate for your needs in your forthcoming article in POPULAR SCIENCE, and if there is anything further I can do to aid you in supplying information for your articles or for your general information please do not hesitate to write again. It has been nice corresponding with you, Ken, and I'm looking forward to further correspondence in the future.

Respectfully,



W. E. Leek  
Firearms Design & Development  
Ilion Research Division

WEL:T



## SPEED MESSAGE®

TO Mr. Wayne Leek  
Research and Development  
Remington Arms Co., Inc.  
Ilion, New York

FROM \_\_\_\_\_

**Ken Warner****Rt. 1 Box 96****Sarasota, Fla.**SUBJECT McCawley Letter of May 27

— Dear Mr. Leek:

DATE May 30, 1964 19\_\_\_\_

Ted in this letter said he was asking you to send me a stock and an action for a Model 600. On further reflection, I have decided I don't need the action, but that I would like to have the stock, preferably a lighter weight than the stock I have. That I am shooting has one of those wandering forearms that happens sometimes.

If you could weigh the 600 action for me, that would be fine. I'd also appreciate your comments on the relative importance of the various weight-cutting devices you used. It seems to me the barrel and the trigger guard are the principal savings, plus some few ounces eliminated by making the 600 such a compact action and an accompanying gain in each of the parts, like bolt and follower and so on.

On the ballistic side, I'd like to hear what your chronograph says about the difference between the #600 and the ammunition charts. Inevitably, the readers of POPULAR SCIENCE are going to be more burdened with the long barrels is best philosophy than the readers of more sophisticated magazines in the gun field. (Privately, I've wondered if you all had considered an even shorter barrel and a Mannlicher-type stock to the muzzle. I know I've considered it ever since I received this piece.) So I'd like a hard cold fact to use. Has anyone calculated the recoil in .308 with 180 gr. bullet with one of the standard formulae so a comparison can be made — to the GI Springfield or M-1 perhaps?

Outside of the POP SCI article, I am working over the pistols-from-rifles or rifles-from-pistols idea and would like to know if the XP-100 hit the market first because of the Treasury rulings or if that's just somebody else's idea.

Thanks for your help.

SIGNED

*Ken Warner*

GrayLine

"SNAP-A-WAY" FORM 44-900 2-PARTS

WILSON JONES COMPANY © 1961 PRINTED IN U.S.A.



Wayne:

Here are the figures you ask for.

Muzzle Velocity: 180 gr bullet @ 3 ft from muzzle  
(ave of 5)  
M 600 Cal. 308 18½ in Barrel 2465 FPS  
M 700 Cal. 308 20 in Barrel 2525 FPS  
Pressure Gun " " 24 in Barrel 2567 FPS

Shoulder Force (ave of 2)  
M 600; 5½ lb gun 585 lb  
M 700; 6¼ lb gun 415 lb



GUN WEIGHTS - MODEL 600

10/4/63

	<u>308 Win.</u>	<u>222 Rem.</u>	<u>35 Rem.</u>
Action only	3 lbs. 13 oz.	4 lbs. 1 oz.	3 lbs. 11 oz.
Wood only (Avg.)	+ 1 " 11 "	+ 1 " 11 "	+ 1 " 11 "
Total Avg.Wt.	5 lb. 8 oz.	5 lb. 12 oz.	5 lb. 6 oz.

Wood only (10)

1 lb. 5 oz.  
 1 9  
 1 9  
 1 8  
 1 13  
 1 13  
 1 10  
 1 15  
 1 15  
 1 10

Avg. 1 lb. 11 oz.

Comp. Gun ~~(10)~~ (308 Win)

6 lb. 0 oz.  
 5 8  
 5 6  
 5 12  
 5 10  
 5 8  
 5 12  
 5 12  
 5 8  
 6 0

Avg. 5 lb. 8 2/3 oz.

ATTESTED by

H.E.W.

J.F.F.

10/4/63

JFF:T



is having. Can you help him?

ESMCC

May 27, 1964

Mr. Ken Warner  
Rt. 1, Box 96  
Sarasota, Florida

Dear Ken:

Thanks very much for your letter of May 19. I am forwarding a copy of this to Wayne Leek in our Research and Development Department at our firearms plant in Ilion, New York. Wayne designed the gun and he may be able to give you some help with some of your questions.

I am also asking him, by copy of this letter, if he can send you another stock and also an action only for photographing. Since we do not sell actions only, this would obviously have to be returned after the pictures are taken.

You should be hearing from Wayne in the near future.

Kindest regards,



E. S. McCawley, Jr.  
Manager, Public Relations

ESM:JV

cc: Mr. W. Leek ✓



TO: Mr. E. S. McCauley  
Remington Arms  
Bridgeport 2, Conn.

FROM

RECEIVED

MAR 21

E. S. McCAULEY, II

SUBJECT Remington 600

Dear Ted:

DATE

March 9, 1964

Surprise and all that. POPULAR SCIENCE wants me to do a general engineering type story on your light weight.

What is an action? Well, it's how y'know, it's a pound or so and still has an accurate cylinder.

I plan to design a new action, nylon trigger trigger designed for light weight and barrel length and taper. But I have a few problems.

1. The stock on the 600 .308 I have is a warper. It came warped against the barrel, and it continued to warp after being relieved.

2. The stock is also a pretty dense sample and weighs about a quarter pound more than I figure the action should be.

So could I have another stock, please? A light and straight one?

3. I'd like to photograph the action only, perhaps in comparison with a more normal (that is, more usual) size like an M98 Mauser. And I'd like to see what the action looks like in the camera from the front without that barrel cluttering up the view.

So could I borrow an action without a barrel in it?

4. I'd like the Remington statement on effect of barrel length, etc.

SIGNED

*E. S. McCauley, II*

Can do? Soon? Regards...

WILSON JONES COMPANY

WILSON JONES COMPANY • C 100 • PRINTED IN U.S.A.



*1-john F. Pass on to Bpt. Adv.*  
*OK.*

cc: E.S. McCawley

June 9, 1964

Mr. Ken Warner  
Rt. 1 - Box 96  
Sarasota, Florida

Dear Mr. Warner:

I am in receipt of a letter you had written to Ted McCawley and also your note concerning some information required for an article involving the Remington Model 600 Rifle. I believe I have accumulated all the necessary information for you and will start by answering your questions as they occur in your letter.

By this time you have probably received the stock, which I hope meets with your approval. On our scales it weighs one pound eleven ounces. I chose that weight stock because it represents an average of ten which we had weighed originally, ranging in weights from one pound five ounces to one pound fifteen ounces. This stock coupled with a 308 Caliber M/600 should weigh at 5 lbs. 8 oz., the advertised specification. As you probably realize, we are making this rifle in four calibers, the 308 Win., 222 Rem., 35 Rem. and 6MM. They all vary in weights because of the bore size of the barrel, the 35 Rem. being the lightest, averaging around 5 lbs. 6 oz., and the 222 being the heaviest, averaging around 5 lbs. 12 oz.. That is, when we are comparing the average weight of 1 lb. 11 oz. of the stock with the actions. The actions only weigh 3 lbs. 13 oz. for the 308, 4 lbs. 1 oz. for the 222, and 3 lbs. 11 oz. for the 35 Rem. At the present time I haven't been able to get enough 6MMs all in one group to weigh them and determine their actual average. But I suspect this will suffice for your purposes.

As to the elements affecting weight reduction, the action itself was the greatest contributor because the barrel was reduced in length to approximately 16 1/2" and the receiver was reduced 3/4" under the shortest of our higher powered actions, in the Model 700. If you recall, the original Model 721 had two receiver sizes. We called it the M/721 and M/722, and they were approximately 3/4" different in length. This particular action is another 3/4" shorter than the M/722. At the same time when reducing the receiver the associated parts such as the bolt could be reduced in length, and therefore some weight saving was obtained in that part, along with the firing pin, firing pin retractor spring. A couple of modernistic cuts were placed upon the rear section of the receiver and the bolt plug, but the weight reduction accumulated in these areas was very small indeed, and the intent was not in the direction of weight reduction but more for a styling effect.



June 9, 1964

The barrel itself is rather husky in nature, especially in the breech section as you will note, and this was necessary for heavier caliber designs such as those involving the 35's.

One would expect the nylon trigger guard to contribute to weight reduction, and it does --- nylon weighing approximately one third that of aluminum, and aluminum roughly one third that of steel. This particular shape and design of the trigger guard, which is I believe original and a Remington style, has been found to be very rugged structurally and the nylon was most adaptable of all types of materials for this part. The nylon rib, we felt, added some aesthetic appeal to the rifle and made it more distinctive, setting it aside from others. It is floating on studs which are welded to the top of the barrel, the welding being at such a rapid rate that it does not effect the internal dimensions of the bore. The rib itself contains elongated slots which allow the rib to float, as I said previously, on the studs, and has no effect on the accuracy of the barrel, and will withstand high temperatures from rapid shooting generated into the barrel.

The rear sight and the front sight are mounted directly to the studs; therefore giving the utmost in accuracy by that direct mounting. This particular assembly is not unlike the XP-100 Pistol which was introduced ahead of the Model 600, and very intensive accuracy tests were conducted in both the rifle and the pistol to determine the effects of the rib on the barrel, and there were none whatever. As far as the ballistics are concerned, most ammunition charts list velocities and energies that have been obtained in 24" barrels. The particular pamphlet put out by Remington with their average ballistics in the 308 Caliber has been accomplished by using a 24" barrel. So I will list for you the results we obtained in actual measurement 3 feet from the muzzle using 180 grain bullets in 308 Caliber, in the Model 600, with an 18 1/2" barrel. The velocity was 2465 fps. In the Model 700, the same caliber, 20" barrel - velocity was 2525 fps. And in a pressure gun, the same caliber, 24" barrel - velocity was 2567 fps. So you can see the drop in velocity is rather insignificant when it comes to the compromise situation that a hunter or shooter must consider when weight or barrel length is involved. And the effect on game, for example, between the results on the Model 600 and the pressure gun, involving only 100 fps drop, would probably be immeasurable.

We determine the effect on shoulders by what we call shoulder force measurements, and have made two measurements for you, one on the Model 600 and the Model 700, weighing 5 1/2 lbs. and 5 1/4 lbs. respectively. We found that the shoulder force on the M/600 was 585 lbs., and on the M/700 was 415 lbs. I don't know whether this information pertaining to shoulder force is adequate for your needs, but if you need anything further in computations or measurements, please advise. This also applies to other information you might need pertaining to the gun.

With regard to your questions concerning the shorter barrel, of course we must stay within the limits of the Federal laws, which I believe is around 18", and we have



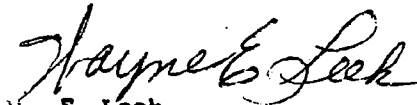
June 9, 1964

intended to make our barrels just slightly longer than the minimum legal limits so there will be no question about barrel lengths. The only really short barrel we ever made on these rifles was to compare 221 velocity versus the 222 by cutting off the barrels an inch at a time. And we did have one M/600 made up with a Mannlicher type stock which I think had a very pleasing appearance indeed. However, this requires longer stock blanks and very close manufacturing control for bedding, and other factors are involved along with the problem of unfortunately low sales appeal for Mannlicher stocks. I would not be surprised, however, to see some of the stock companies place Mannlicher stock blanks on the market for the Model 600.

I expect there have been several comments across the country about the timing of the Model 600 versus the XP-100 as to which model was created first, was introduced first, etc.. I can assure you that this was considered and that Remington kept within the limits of the law. The truth of the matter is that the XP-100 was conceived first, and all of the drawings and the models were made up and designated as pistols, and the items used in the receiver section were not originally involved with any rifle actions. As you probably know, the receiver section of the gun is the legal portion which is the gun, and the other parts are the accessories and appurtenances necessary to make it function. That is one of the reasons why the serial numbers are always placed on the receiver sections, since that is the basic gun. The original XP-100 design was made available to the Treasury Department for their ruling and approval before this item was placed upon the market, and the Model 600 was introduced one year later. The law states that it is illegal to convert rifles and shotguns into pistols, but it is not illegal to reverse this procedure, and therefore we have met the legal requirements by conceiving, designing and introducing this particular combination in the pistol first, prior to the introduction of the Model 600.

I trust this information will be adequate for your needs in your forthcoming article in POPULAR SCIENCE, and if there is anything further I can do to aid you in supplying information for your articles or for your general information please do not hesitate to write again. It has been nice corresponding with you, Ken, and I'm looking forward to further correspondence in the future.

Respectfully,



W. E. Leek

Firearms Design & Development  
Ilion Research Division

WEL:T



cc: E.S. McCawley

*File*  
F. E. MORGAN  
Bridgeport

*Adm*  
Ilion, New York  
April 6, 1964

We have been contacted by some of the sports writers, namely Warren Page and Les Bowman, and I believe others, who are extremely interested in introducing the 6mm into the Model 600 carbine rifle. I believe it was through the efforts of some of these individuals that encouraged us to proceed with this new caliber. And they have been advised that we would provide them information concerning this caliber as early as possible.

I think it would be opportune to provide at least some of them with a sample for write-ups in their individual sporting magazines, and would like permission to make special selections for these people, to make sure that we provide them with the most accurate of our 6mm samples. If you agree, please advise me as soon as possible so that I can take action in making the proper selections.

*WEL*  
W. E. Leek  
Firearms Design Section  
Ilion Research Division

WEL:T



ROUTE:

~~D. E. Sullis~~

~~W. L. Dahl~~ *WLD*

~~G. I. Ellis~~ *E*

~~J. F. Finnegan~~ *F*

~~E. G. Hart~~

~~R. P. Kelly~~ *R*

~~P. Nasypeny~~ *PN*

~~C. H. Morse~~

~~J. S. Martin~~

~~N. M. Reed~~ *NMR*

~~H. J. Waterman~~ *HJW*

~~G. B. Workman~~ *G*

~~R. Nightingale~~

~~A. Hugick~~ *AH*

~~W. R. Geogin~~ *W*

~~G. H. Zoller~~ *G*

~~J. J. Bechard~~ *J*

~~D. J. Urtz~~ *D*

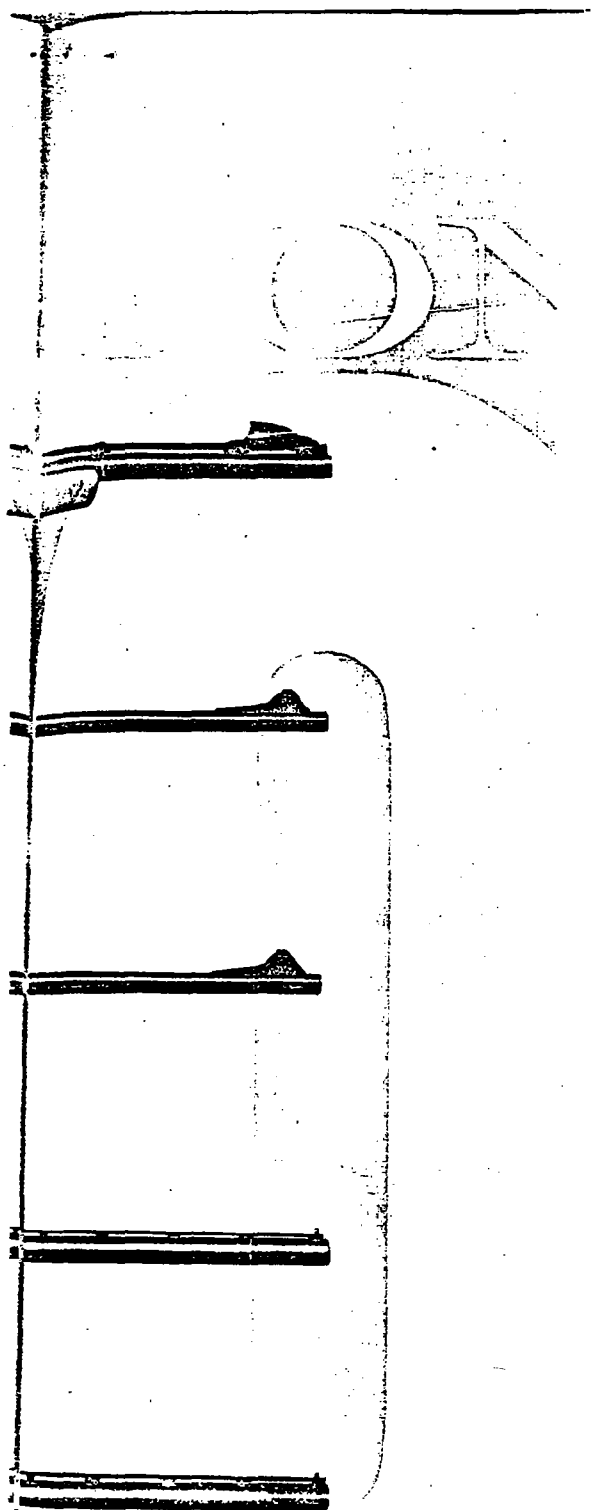
~~P. H. Eccleston~~

~~A. J. Long~~ *AJL*

~~R. Sassone~~ *R*

Return to W. E. Leek





**Light, easy to handle and moderately priced, this new bolt-action carbine is just what the big-game hunter ordered ■**

If you intend to do some hunting this coming fall, either upland or big-game, right now is the time to begin planning a program for sharpening your shooting technique—especially if you are a beginner. Perhaps you want to sport a new gun on the intended outings. If so, you have a wealth of sporting firearms by High Standard, Marlin, Remington, Ruger, Savage, Weatherby, Winchester and others, with plenty of brand-new models to examine. I'm sure you will find both rifles and shotguns that exactly will fulfill your needs. The point is, it is of utmost importance, before venturing afield, to become so thoroughly familiar with the gun that handling and shooting is almost instinctive. Let's look at a sorrowful "for instance."

Last year, during the hunting season, I watched a fellow fire two shots at a standing, perfectly silhouetted whitetail buck at a distance of about 125 yards and never touch a hair. Then he missed again when the magnificent animal took off in high gear. That particular deer had a rack that looked like a Christmas tree. It would have made a really great trophy—not to mention the tasty meat that never got to the table.

You probably are thinking that the hunter is a lousy shot. There is no question about it, at that moment, he was doing some mighty poor shooting. Ordinarily, this chap is an excellent, cool and calculating marksman, actually one of the best field shots I know, and he has plenty of world-wide hunting experience chalked up in his rather full record book.

Why did he miss the first two standing shots, one over and the other under the animal, and fail to connect with the third?

Afterwards, we discussed the matter. In utter disgust, my friend said that he aimed at the whole animal instead of doing a pinpoint job—the rifle was scope-equipped—hurried his shots, and as a result, did a complete Maggie's drawers. I think he was overwhelmed by the large rack atop the deer's head and had a mild case of buck fever which momentarily nullified his years of training as a rifleman. Thus, he merely shot at the whole animal, probably yanking (instead of squeezing) the trigger.

Regardless of how experienced a hunter may be, he still can benefit by some simple practice.

I'm just full of sad tales today. On one

**BY PETE KUHLOFF**

ARGO -

59



## THE REMINGTON 600/CONTINUED

occasion, during the wildfowl season last year, I was having trouble with geese. There were plenty of targets. They were flying high, but not out of range. A couple of times, I merely shot at geese, not at an individual bird. After settling down and beginning to point out individual targets, I now and then could hear shot rattle on wings, but no honkers plummeted earthward.

Finally, with the help of an observing friend, I realized that I was overleading—putting the shot away out in front of the mile-a-minute flyers. Misses on these birds almost always mean that the hunter is shooting behind them. Actually, there is nothing much more frustrating than to shoot and miss, and have no idea what you are doing wrong. I have seen this state of affairs bring strong men to tears.

To recapitulate, it took thirteen shells that day to bring down my limit of two Canada geese.

What can be done by the sportsman, during the non-hunting season, to improve his chances of successful shooting when the chips are down? As every experienced hunter knows, the important thing is to get enough practice shooting so that he can place his shots with at least a fair degree of accuracy. Next, in big-game hunting, it is most important to know where to place the shots on the game. This is something that is often neglected. A good knowledge of comparative anatomy certainly is a great help for the hunter in correct aiming. But even with a casual knowledge of the position of the vital organs and the general scheme of the skeleton, it is possible to determine where a meat-in-the-bug shot should be placed.

I'm not going to become mired down in a discussion of anatomy. However, one point should be borne in mind: Do not consider the heart as the ultimate part to be hit. Most animals aimed on are moving away from the hunter. So it is a good idea to try for the forward shoulder farthest away from the shooter. With such an angling shot, vital organs will be hit, and there will be a breakdown in locomotion. An old deer-stalking maxim is a good one to follow: On a broadside shot, sight on the foreleg and raise the point of aim up not quite halfway on the animal. That shot will be successful in almost all cases.

How about practice? Usually it is difficult for the city-dwelling sportsman to locate and shoot on a running-deer target, or other kind of moving target, with the rifle. But a lot of practical practice can be had in bedroom or den. Obtain some pictures, taken from various angles, of the animals to be hunted. Remember, the first shot usually presented is standing broadside or quartering, where careful aim will do a quick job. So be sure to have some pictures of the animal in these positions. Pin them up at a convenient height and do some dry-firing regularly. Be sure the gun is not loaded, line up the sights at the point on the pictured animal where you wish to make the hit and squeeze off the trigger. Fifteen or twenty squeeze-off snaps per session and done regularly, will bring great improvement. Be sure to retain a mental picture of exactly how the sights are lined up with each snap, so you can "call" your shots. With practice, you will be able to say exactly where the bullet would have landed had you been using live ammo. After engaging in such dry-firing practice

over a period of time, the rifle should be taken to a shooting range and sighted in from a rest position, and some actual shooting should be done on a life-size target at various expected ranges. This sort of program will definitely pay off in the field!

In shooting the shotgun, it is important that the comb of the stock is correctly cheeked each time the gun is mounted. This is particularly significant where very quick shots may be necessary on fast-moving targets that almost instantly can move out of sight. As with the rifle, good practice in mounting the gun can be had at home. Pin up pictures of the kind of birds you intend to hunt and practice shouldering the shotgun and pointing it at the individual target.

If you are a beginner shotgun shooter, try this routine: With the gun held ready for mounting, look at the target, close your eyes and mount the gun as though to shoot. Now open your eyes. The chances are that the gun will not be pointed exactly at the target. You may be pointing to one side or the other, perhaps looking well under the sighting plane and at the breech; or you may be seeing too much barrel. Thoughtful practice in shouldering and cheeking the gun will eventually result in perfect pointing.

When you can do a near-perfect job of pointing, it is time to begin practice on moving targets. The hand trap and a supply of clay targets is just about the best equipment at this point because it is possible to throw comparatively easy-to-hit, straightaway birds. When you can regularly powder the slow straightaways, try blasting some speedy ones thrown both low and high. Next, move away from the target thrower, maybe fifteen feet to one side or the other, and groove in on the angling clays. When you are proficient at powdering targets from the hand trap, it is time to locate a skeet layout and work at that game. All this is a lot of fun—and you will become a good wing shot.

### New From Remington

Right now, there are quite a number of new guns and other equipment being introduced for 1964. For big-game hunting, especially deer, Remington is producing a new, moderately priced, lightweight, bolt-action carbine, known as the Model 600 (\$99.95). Initially, this exciting and different-looking little number will be available in chamberings for two big-game calibers, .308 Winchester and .35 Remington. For the varmint hunter who likes fast-handling carbines, it will be chambered in .222 Remington caliber.

Over-all length of the Model 600 is only 1¼ inches over a yard and the little rifle weighs approximately 5½ pounds. The tapered 18½-inch barrel has a matted, ventilated rib (see photograph on page 58) that forms a straight-line sighting plane to help the shooter aim quickly. The front sight is blade-ramp type with brass bead that aligns perfectly with the U notch of the open rear sight, which is screw adjustable for both windage and elevation. The receiver is drilled and tapped for installation of scope or receiver sight.

The receiver of the Model 600 is similar to that of Remington's sensational XP-100 handgun which was introduced last year. The bolt-handle zigzags forward to eliminate chance of the bolt knob whacking the trigger-



## THE REMINGTON 600/CONTINUED

finger knuckle with recoil and is shaped so that it hugs the stock, doesn't stick out, for compactness in a saddle scabbard and no hang-up in field use. Yet the bolt half-knob is easy to grasp for fast operation and is serrated on the under side for positive, no-slip gripping. This is a fast-action carbine. Bolt throw is approximately 3/4 inches and works as smooth as silk. The bolt has the customary Remington recess at its face to encase the cartridge head completely in a ring of steel. The trigger is extra-wide and grooved for positive control. The pull is crisp and clean with no creep. Thumb safety is conveniently located at the rear of the receiver.

The magazine of this new, fast-shooting, slick-handling carbine is of fixed-box type, holds four cartridges in .308 and .35 calibers, five in .222. And an additional round may be loaded in the chamber.

The stock of the 600 is made of selected American walnut. Its Monte Carlo, fluted comb is dimensioned for fast line-up with either open sights or scope. Checkering at the pistol grip and forearm is custom—similar in character to that already made famous on the Remington Model 700 rifle, the Model 1100 automatic shotgun and the Model 870 pump-action shotgun.

For tops in accuracy and to eliminate any possibility of change of sighting zero, the barrel of the new carbine is free-floating in the barrel channel of the stock. This means that the wood of the stock does not touch the barrel at any point in its length. We all know that wood of almost any kind sometimes has a tendency to warp slightly. If the wood at the barrel channel makes contact with the barrel at all points and the wood should warp, it would exert uneven pressure, possibly to push or spring the barrel out of line so that the arm would not shoot to the point of aim. This would necessitate re-sighting-in, with the point of bullet impact being at the whim of weather or atmospheric conditions.

The new Remington Model 600 carbine should prove popular in hunting areas where a lightweight, easy-to-carry, easy-to-handle rifle, built to take punishment without sacrifice to vital accuracy, is needed to drop a buck in heavy brush.

The new 600 also will be handy for the rancher and others who hunt in open country since it slips into a saddle scabbard easily, fits snugly in a car rack or in the cab of a pick-up truck.

New looks have been given to three time-tried models in Remington's line of rifles and shotguns—the Model 712 "Woodsmaster" automatic big-game rifle, the Model 760 "Gamemaster" pump-action big-game rifle (as well as carbine versions of these models), and the Model 1113 automatic shotgun.

No internal changes in the mechanisms of these guns have been made, they're still the same trouble-free, reliable performers they always have been. However, Remington's exclusive custom fine-line checkering is now being used on the stocks and forearms of these models. The old standard A and ADL grades of the models 712 and 760 are gone, and all rifles of these two models, as well as the 1113 shotgun, will have the new fine-line checkering.

In case you have forgotten, the Model 712 automatic

(\$149.95) is available in four calibers—6-mm and .280 Remington, .30-06, and .308 Winchester, with the carbine version in .30-06 and .308 calibers.

The Model 760 (\$129.95), America's only pump-action, big-game rifle, is lightweight and fast-handling and has won fame in international running deer matches. It is offered in six calibers—the new .223 Remington, .280 Remington, .270 Winchester, .30-06, .35 Remington and .308 Winchester, with the carbine version made in the three latter calibers.

Both the 760 and the 742 have the well-known and very strong Remington rotary multiple-breech bolt.

The Remington 11-48 shotgun (starts at \$134.95) is the only automatic on the market which is made in all five gauges—12, 16, 20, 28 and .410. The 11-48, introduced in 1949, is a light, streamlined, modern version of the Model 11, Remington's first automatic and the first production-line autoloading shotgun made in the United States, dating back to 1905. Really time-tried, and long known to have a dependable and trouble-free type of action, this is truly one of the world's most popular shotguns.

In January of last year, Remington introduced the Model 1100, an all new gas-operated automatic shotgun in 12-gauge. An outstanding feature of this new gun is a facet of its design that results in up to around forty per cent less recoil effect or apparent recoil. Dig out your March, 1963, ARGOSY for a complete report on this 12-gauge gun. You'll find all of the details on page 66 of that issue.

Since that time, Remington has come up with some new developments for this shotgun and now the Model 1100 also is available in 16- and 20-gauges. And apparent recoil reduction in these gauges is comparable to the 12-gauge, making them exceptionally pleasant to shoot.

All Model 1100 guns have Remington's new RKW wood finish which was developed by Du Pont. This is a tough finish; in fact, it is as tough as the finish used on bowling pins. It is scratch-resistant, color-fast, weather-proof and oilproof. The full pistol grip and the forearm have a fleur-de-lis pattern with reverse checkering accomplished by Remington's exclusive new process. The custom-styled grip cap, inlaid with white diamond, and the butt plate have white spacers. The receiver and chrome-plated bolt are inscribed with decorative scrolls. And a new high-gloss, rust-resistant finish is used on metal parts.

Magazine capacity of the Model 1100 is four shells. With one in the chamber, total capacity is five shots. A three-shot plug is furnished for use when hunting migratory waterfowl. Takedown of the gun is easy. The barrel can be removed with the action either opened or closed, and the forearm can be removed separately if desired. Barrels of different lengths and chokes can be interchanged within gauges without special fitting.

The Model 1100 in all three gauges is available in various chambered for 2 3/4-inch shells in a full variety of barrel lengths and chokes with plain or ventilated rib barrels. In 12- and 20-gauges, it is also offered in models chambered to handle three-inch magnum shells. • • •

ARGOSY



*Fili* *X*

## CYCLE OF OPERATION

### REMINGTON MODEL 600 - BOLT ACTION CARBINE

Model 600 is a light weight, high power, bolt action, fixed magazine repeater chambered to four (4) popular cartridges -- .222 Rem., .35 Rem., .308 Win. and famous new 6 mm Rem. The vent rib barrel makes it a natural sighter, plus receiver being drilled and tapped ready to accept most popular makes of scopes and mounts. Basic operation of bolt is similar to most rifles of this type. Movement of bolt handle upward and fully back opens, forward and down closes and locks bolt.

#### FIRING

Firing cycle is basically release of a spring-loaded firing pin for purpose of striking primer of cartridge and igniting same. More specifically, pulling or squeezing of trigger moves connector forward leaving sear unsupported against "cocked" firing pin head. With no support, sear is cammed down by spring-loaded firing pin and main spring drives firing pin forward to strike and ignite primer.

#### UNLOCKING

Raising bolt handle unseats locking lugs on bolt head from recoil shoulders in receiver.

#### COCKING

Cocking takes place simultaneously with aforementioned cycle. A cam at rear of rotating bolt forces firing pin assembly rearward and holds it in position, in a notch at rear of bolt, until it is later freed in locking cycle.

#### EXTRACTION

This phase of operation cycle is essentially one of two parts referred to as (1) primary extraction and (2) secondary extraction. Primary extraction occurs simultaneously with unlocking. The rim of case, being completely encased by bolt head, is gripped by a circular recessed claw-type extractor. During final upward throw of bolt handle, a primary extraction cam retracts bolt approximately 1/8" with a mechanical advantage of about 8 to 1, completing primary portion of this phase. Bolt lugs are now free of locking shoulders in receiver and bolt may now be moved to rear completing second phase of extraction.



## CYCLE OF OPERATION

### REMINGTON MODEL 600 - BOLT ACTION CARBINE

#### EJECTION

Within the bolt face, maintaining constant pressure on head of cartridge, is a spring-loaded ejector. As bolt is retracted and front edge of cartridge reaches ejection port, pressure, along with opposing grip of extractor, ejects cartridge from port. Rearward motion of bolt is halted by bolt stop.

#### FEEDING

With bolt in this configuration, topmost cartridge in magazine is allowed to move upward against feeding lips on bottom edge of receiver, allowing itself to be moved ahead as bolt is advanced with a forward motion of bolt handle. Bullet guides cartridge into chamber via a feeding ramp on lower side of receiver.

#### LOADING

Loading cycle consists briefly of moving cartridge into chamber once it is free of feeding lips in receiver.

#### LOCKING

Locking cycle is accomplished by rotating bolt with a downward motion of bolt handle, locking cartridge in chamber. Four engagements are made by this cycle: (1) Locking lugs on bolt head are engaged with recoil shoulders in receiver. (2) Head of cartridge is seated into bolt head depressing ejector and extractor claw is snapped over rim of cartridge. (3) Sear engages and locks firing pin head in a cocked position by action of (4) Sear being supported from beneath by connector. Action is now ready to be fired, by release of trigger.

#### SAFETY

The safety button, located on right rear of receiver, is operated by a push and pull action of thumb. This two-position safety has two intentional functions. When safety button is pulled rearward by a slight down pressure of thumb, a cam is brought into position under safety cam, that locks cam against firing pin head preventing firing. Second function of safety in this SAFE position brings an arm into slot in bolt preventing bolt being opened. Pushing safety button forward to FIRE position nullifies above conditions and will allow rifle to be fired.

Instructions for loading, unloading, assembly, disassembly and care of rifle are contained in instruction folder (RD 5473) supplied with each rifle.

DEB:B  
364

- 2 -



1 - ~~Handwritten~~ Info  
2 - Thelma - File - M/Kov  
adv

@

January 20,

1964

Capt. George C. Nonte  
1403 Arkansas  
Killeen, Texas

Dear Captain Nonte:

I am in receipt of your letter to E. S. McCawley together with his request to advise you concerning the design of the mounting supports for the nylon rib on the Model 600 Rifle. This information also applies to the Model XP-100 Pistol.

The development of the nylon rib for both of these models was our most difficult design job. Actually, we were trying to obtain a new and pleasing appearance on a rifle or pistol, light in weight and a height device that would eliminate the unsightly high rear and front sights that are found on other rifles and pistols. Several things had to be taken into consideration, however, in the design of this rib. First of all, it must not effect accuracy in any manner, and this involved several difficult and basic design problems. It is well known among gun designers that the most accurate combination of sighting is to mount the sights directly and firmly upon rigid supports on the barrel itself. Secondly, any of the appurtenances to the gun must not be mounted or connected to the barrel in such a way that it would affect the normal and consistent vibrational performance during the flight of the bullet down the barrel.

Rigidly mounted ribs on a rifle and pistol barrel have a tendency to affect the accuracy during the heating period of the barrel during shooting because of an imbalance of metal surrounding the bore itself. Also, any permanent attachments to the barrel must be of such a nature that the internal dimensions of the bore must not be affected. With these basic design items in mind, we finally concluded that the adequate design would be to weld studs upon the top of the barrel in perfect alignment to support the sights and the rib. The studs are welded in such a manner with such rapidity and high frequency that no deformation or change of dimensions to the internal surfaces of the bore can be found.

The nylon rib was designed in such a manner with elongated holes that during expansion and contraction of the barrel while shooting and undergoing the



January 20, 1964

heating process the rib actually floats on the studs and does not effect the vibration or any of the whipping characteristics that normally take place during the process of internal combustion.

It is a well known fact that all plastic materials "creep" under load, and will continue to creep until the load becomes zero. Sometimes this factor is an undesirable one. In this particular case it was an asset to us, for we designed the thickness of the rib approximately .005 greater than the height of the studs. It takes approximately two weeks after assembly for the nylon rib to reach thickness-wise the height of the stud. In other words, the nylon will creep .005 to the top of the stud. The load then becomes zero, but the rib remains tight without any continual or further tightening of the screws. In this manner the sights, therefore, rest directly on the top of the studs, and the perfect sighting combination is obtained.

We have had in our testing rifles and pistols that fired ~~standard~~ 5-shot groups at 100 yds. We have tested these continuously with and without the rib mountings and can determine no significant difference in the test results, proving that the rib does not effect the accuracy of these models.

I think the design characteristics that are involved with this mounting system are unique and very desirable, and appreciate the opportunity to reveal to you how they were accomplished, for I think this is an interesting story of design problems and the thinking behind these problems. And I believe important enough to be told to the shooting public. It is a pleasure to have the opportunity to write to you, and I will be most happy to correspond with you on any future questions or problems involved with Remington sporting arms.

Sincerely yours,



W. E. Leek,  
Manager - Firearms Design  
Ilion Research Division

WEL:T



January 14, 1964

**Sgt. George C. Monte**  
1403 Arkansas  
Killeen, Texas

Dear George:

Thanks very much for your letter of December 30. I am glad to hear that you have been getting such good results with the Model 600.

I am sending a copy of your letter to Wayne Leek at our firearms plant in Ilion. Wayne was the designer of this gun and he should be able to answer your question relative to the method by which the rib-supporting studs are attached to the barrel.

We have already entered an order for a Model 600 in 222 Remington caliber for you and it should be along in due course.

We appreciate the copy of your story on the 600 which looks like a good job.

Under separate cover, we are sending you a supply of the 223 commercial cartridges. As far as the 6 MM Remington International cases are concerned, we have not made any commercial production of these as yet.

Kindest regards,



**E. S. McCawley, Jr.**  
Manager, Public Relations

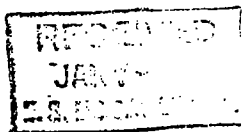
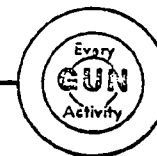
ESM:JV  
cc: Mr. W. Leek ✓



# SHOOTING TIMES

MAGAZINE

BOX 1500 • WAR MEMORIAL DR. • PEORIA, ILL. • PHONE 688-2411



1403 Arkansas  
Killeen, Texas  
December 30, 1963

Mr. E.S. McCawley Jr.  
Manager, Public Relations  
Remington Arms Company, Inc.  
Bridgeport 2, Conn.

Dear Ted;

Received the M-600 sample gun on 26 Dec. and spent the 27th shooting it. Frankly, at first I was disgusted as it scattered shots all over the paper. After it settled into the stock, things changed. It developed amazing accuracy for so light a piece.

Fitted with a Weaver K-3 (Post & crosshair) in modified weaver mounts (M-722 cut down), factory loads print in 1 1/4" (100 yards) for the first three or four rounds from a cold fouled barrel. Subsequent rounds open the group up to 2 1/2" to 4", but its that first three that count to the hunter. One of my favorite semi-handloads, WCC 58 M-59 7.62mm Ball having bullets repalaced with Gardiner 120 gr. open points, produced 3 shot cold barrel groups as small as one-half inch. Ridiculous, but true, even though powder combustion is incomplete in that short barrel as evidenced by brilliant muzzle flash and powder flecks on velocity screens. Generally, this load will put the first three into one inch, but I have one group before me as I write that measures right at One-half. That particular one was shot under conditions of no wind, 70°f, slightly overcast sky and a better shot than I pulled the trigger.

I'm enclosing a copy of my story on the gun for your information.

I'd like to know how the rib-supporting studs are attached to the M-600 barrel. I'm assuming they are brazed, but can't really tell by visual inspection. I'm sure I'll be asked about this and want to be able to give the correct answer.

Please go ahead and ship my M-600 in .222 Remington calibre. I'll settle for that for the time being, though I suspect you'll have some demand for it in .222 Mag. and .223 before long. This should make a really fine car gun for back ranch road fox and jack rabbit hunting as practiced in this area. Of course, shooting from a vehicle is technically prohibited in this state, but most conservat-

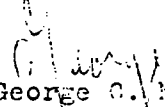


ion department people permit it so long as predators are the target.

Incidentally, have you yet manufactured any 6mm Rem. International cases either correctly headstamped, or without any headstamp at all? I'd like to have a sample for my reference collection if possible.

I'd also like to obtain a small supply of the sporting .223 cartridge as soon as available. I have a bolt gun in this calibre ready for stocking and would like to try commercial loads in it when finished.

Sincerely Yours

  
George C. Monte Jr.  
Capt. Ord. C  
Technical Editor

GCN:bp



W. E. LEEK

Telephone: 10-31 1:30 PM

From: George Rockwell

Model 600 is advertised as 5 1/2 lbs. (308 Cal.)

Our gun at Bridgeport weighs 5 lbs. 15 oz.

What is average accurate weight, please?

Ruger advertises carbine as 5 lbs. 12 oz.

Do you have Ruger's you could weigh, to get an average?

What we are trying to find out is --- Is the M/600 the lightest rifle in its class?

Advertising material ready for release, but held pending our statement of its being lightest rifle in its class.

600 WTS. PHONED TO GEO ON 11-1



GUN WEIGHTS - MODEL 600

10/4/63

	<u>308 Win.</u>	<u>222 Rem.</u>	<u>35 Rem.</u>
Action only	3 lbs. 13 oz.	4 lbs. 1 oz.	3 lbs. 11 oz.
Wood only (Avg.)	+ 1 " 11 "	+ 1 " 11 "	+ 1 " 11 "
Total Avg.Wt.	5 lb. 8 oz.	5 lb. 12 oz.	5 lb. 6 oz.

Wood only (10)

1 lb. 5 oz.  
 1 9  
 1 9  
 1 8  
 1 13  
 1 13  
 1 10  
 1 15  
 1 15  
 1 10

Avg. 1 lb. 11 oz.

Comp. Gun ~~410~~ (308 Win)

6 lb. 0 oz.  
 5 8  
 5 6  
 5 12  
 5 10  
 5 8  
 5 12  
 5 12  
 5 8  
 6 0

Avg. 5 lb. 8 2/3 oz.

ATTESTED by

H. J. W.

J. F. F.

10/4/63

JFF:T



*m/600*  
*adv*  
cc: R.A. Williamson  
W.C. Schrader  
W.E. Leek - File ✓

Ilion, New York  
December 12, 1963

A. J. BECKNER

The Design Group desires to make one of the early XP-100 test pistols available for a "No Return" loan to one of our principal suppliers (H & P Die & Stamping Company). This would be for promotional reasons, with the idea that it will probably be displayed at the vendor's plant. We have no objections and this particular inactivated pistol is not needed for further reference here.

If you will advise as to proper handling we will turn the pistol over to  
W.C. Schrader.

S. M. Alvis, Manager  
Ilion Research Division

SMA:T

Serial Number: 1170



*File*

*m/600 Adv*

Ilion, New York  
September 27, 1963

S. R. HUTCHINSON  
Bridgeport

**NEW REMINGTON MODEL 600**

We have reviewed your advertising copy of the new model and must say that you have done an excellent job in covering all of its features. The only comment that we can make is that you probably would wish to change the word "Rifle" at the top of the page to "Carbine".

From our recent shooting tests out west with Elmer Keith indications are that this Model 600 is really going to take its place as a famous sporting rifle. Oddly enough, there seems to be room for this size rifle in the bolt action field and I think will give a lot of competition to the Winchester 94.

Thanks again for your good advertising work, and let's sell a lot of 600's.

W. E. Leek  
Firearms Design & Development  
Ilion Research Division

WEL:T



Harold W W  
~~John F F~~  
Please review  
comment & ref. to  
me. W



Memo from the desk of STAN HUTCHINSON

Wayne Leek 9/23/63

Here's copy  
we're thinking  
of using for  
\$11/600. Any  
corrections or  
additions please  
let us know



NEW REMINGTON

MODEL 600

7  
AK-47 - See  
page 2

Pound for pound this sleek, new, lightweight rifle packs more power, punch and accuracy than any other rifle ever made.

**GOOD LOOKS** Model 600 has a new, rugged compact look - every inch a rifle built to take it. It looks different and it is ... in many ways. Notice the ventilated rib on the barrel. But there's more to it than looks. The rib, with its matted top surface, forms a "quick sight-line" that your eye just naturally follows - helps you get on a running target faster.

**LIGHTWEIGHT** There's none lighter - just 5-1/2 well-balanced pounds which means you can carry it all day and still finish fresh. This rifle is a carbine, it's short; you can handle it faster in heavy brush. Model 600 packs well, too; slips in a saddle scabbard, fits snugly in a car rack or in the cab of a pick up truck.

**POWER** Model 600 is available in three popular calibers - the powerful brush-busting 35 Remington and 308 Win. for big game and the 222 Remington ... a high velocity, flat trajectory varmint cartridge. To get the most from this cartridge, a rifle must be extremely accurate. Model 600 is!

Other features like custom checkering and the world's strongest bolt action (same as on Remington Model 700) make it a gun you can't forget (and wouldn't want to). For more details - see inside; and to prove them -- take it outside ... and shoot it.



## MODEL 600 - FEATURES

CUSTOM CHECKERING on fore-end and grip is fine-lined, uniform, good-looking. This checkering compresses the wood, actually makes it stronger. We suggest you do as smart gun buyers do ... COMPARE ... this checkering with that found on other makes. Then judge for yourself.

MONTE CARLO STOCK with fluted comb means a better cheek-to-stock fit for quicker, surer sight alignment.

RICH AMERICAN WALNUT STOCK has all-purpose dimensions which give perfect alignment with either a scope or open sights. Functional shape of fore-end provides a hand-filling, non-slip grip for steady holding. Throw this rifle to your shoulder. See if you don't agree.

WORLD'S STRONGEST BOLT - same as on Remington Model 700. Cartridge head is completely encased by a ring of solid steel. When bolt is closed, three rings of steel support the cartridge head. Strong? ... there's none stronger.

A LIGHTWEIGHT POWERHOUSE - Only 5-1/2 pounds but packs more power per pound than other guns, from the 35 Remington and 308 Win. calibers with power to smash through the heaviest brush, to the high velocity, flat trajectory 222 Remington varmint-walloping caliber. Carry it all day and at day's end you'll still be hunting - not just moving your feet.



VENTILATED RIB gives the Model 600 a new and rugged look. It's the first time a rifle has ever been designed with a ventilated rib. (Another first for Remington). It helps you aim, gives a definite sight-line so you get on running game faster.

FAST-HANDLING CARBINE MODEL - Short over-all length (37-1/4") makes Model 600 just right for hunting in heavy brush country because you can handle it faster, easier ... get on that bouncing deer and drop him. It's a great saddle gun, too - fits a scabbard neatly or tucks in the rack of a pick-up truck. You'll go for a Model 600 ... it's a great gun.

FINEST ACCURACY. Here's where Model 600 really shines. Free floating barrel of Remington proof steel is precision rifled by Remington's special methods to exacting standards. Trigger pull is short, crisp and clean. At the factory we shot close groups - and so will you. It was designed to shoot this way.

FORWARD S <sup>Bolt</sup> ~~BOLD~~ HANDLE hugs the stock - doesn't stick out - slips in and out of scabbard with ease. Half knob is serrated on the bottom so you get a good secure grip. It's the same bolt handle as on the sensational Remington XP-100 pistol.



ROTATING THUMB SAFETY is conveniently located at the rear of the receiver where you can get at it in a hurry, like the safety on the famous Remington Model 700. Rearward for "safe." Forward for "fire."

BLADE RAMP FRONT SIGHT with brass <sup>face</sup> "head" and sturdy U notch rear sight is adjustable for elevation and windage. Receiver drilled and tapped for scope and receiver sights. ~~SIGHT WRENCH~~ <sup>use quath marks</sup> SUPPLIED,

TRIGGER is extra wide and corrugated; finger fits secreuely. <sup>spelling</sup> Trigger pull is crisp and clean - no creep, no spongy action.



## SPECIFICATIONS

CALIBERS	35 REM., 308 WIN., 222 REM.
CAPACITY	5 SHOT 35 REM. 5 SHOT 308 WIN. 6 SHOT 222 REM.
BARREL	Tapered, Remington Proof Steel 18-1/2" With Ventilated Rib Matted between Sights.
OVER-ALL LENGTH	37-1/4"
STOCK	Selected American Walnut, custom <del>y</del> checkering on fore-end and pistol grip. Monte Carlo Stock with Fluted Bmr. <i>comb</i> 14" Length of pull 2" Drop at heel 1-5/8" Drop at comb
RECEIVER	Drilled and Tapped for Scope Mounts Fixed Magazine Box
SIGHTS	Blade Ram Front Sight with Brass Bead. "U" Notch Rear Sight Adjustable for elevation and windage with adjustable screws.
SAFETY	Positive Rotary Thumb Type with Corrugated Non-Slip Surface.
WEIGHT	5-1/2 LBS.

REMINGTON ARMS COMPANY, INC., BRIDGEPORT, CONNECTICUT 06602

In Canada: Remington Arms of Canada Limited, 36 Queen

Elizabeth Blvd., Toronto 18, Ontario.

Form No. AA-38

Printed in U.S.A



REMINGTON ANNOUNCES  
NEW MODEL 600 BOLT ACTION  
CARBINE CENTER FIRE RIFLE

*adv*

The nation's white-tailed deer population is at an alltime high and is growing every year. Because deer need browse for food, the heaviest concentrations of these popular game animals are found in areas where second or third growth woodlands have resulted in heavy underbrush and thick cover. Hunting in this type of country has created an increasing demand for lightweight, easy-to-carry, easy-to-handle rifles with the accuracy and power to buck through heavy brush.

In response to this demand, Remington Arms Company, Inc., has announced a new, moderately priced, bolt action carbine which, pound for pound, packs more power, punch and accuracy than any other rifle in its class.

Known as the Model 600, the new carbine weighs only 5½ pounds yet it has a rugged look, its every inch a rifle and built to take the toughest punishment. At the same time it has styling and eye appeal which would make any hunter proud to own it.

This compact power package should also be popular with ranchers and others who hunt in open country. The Model 600 slips into a saddle scabbard easily, fits snugly in a car rack, or in the cab of a pick up truck.



Initially, the new rifle will be chambered in two popular big game calibers, 308 Win. and 35 Remington. For the varmint hunter who likes fast handling carbines, it will also be chambered in 222 Remington.

The Model 600 looks different from most rifles and it is, in many ways. The barrel is fitted with a ventilated rib to form a quick sighting line that help shooters to get on targets faster. The front sight is of the blade ramp type with a brass head. The sturdy U notch rear sight is adjustable for windage and elevation and the receiver is drilled and tapped for telescopic sights. *and 6.5 mm / Sights*

Remington's handsome new custom checkering, already made famous on the Model 700 rifle, the Model 1100 shotgun and the Model 870 shotgun, is used on the new rifle.

The American walnut Monte Carlo stock, with a fluted comb, is designed for better cheek-to-stock fit for quicker, surer sight alignment. The all purpose stock dimensions also make it possible to line up either scope or open sights perfectly.

The fore-end is functionally shaped to provide a good reliable, nonslip grip for steady holding. The rifle goes up to your shoulder so naturally, it feels like it's part of you.

The Model 600 features Remington's exclusive bolt design. The cartridge head is completely encased by a ring of



solid steel making it the strongest bolt in the world.

In terms of accuracy the Model 600 really shines. Because bolt action rifles will generally shoot tighter groups than other types, the new rifle starts out with an advantage. However, the free floating barrel, made of Remington proof steel, precision rifled to exacting standards, results in outstanding performance. Extensively field tested on ranges and on different types of game, its accuracy rivals far more expensive and heavier models.

The bolt handle is specially shaped so that it hugs the stock and doesn't stick out. The half knob is serrated on the bottom for good secure gripping. It's the same bolt handle that is used on Remington's sensational XP-100 handgun, introduced last year.

A rotating thumb safety is conveniently located at the rear of the receiver. The trigger is extra wide and corrugated so that it fits the finger securely. The pull is crisp and clean with no creep or spongy action.

Available on January 2, 1964, this fast shooting, sweet handling <sup>carbine</sup> will set standards for accuracy, power and performance unequalled by any other rifles in its class. It will be priced at only \$\_\_\_\_\_ retail.



SPECIFICATIONS

CALIBERS	35 Rem., 308 Win., 222 Rem.
CAPACITY	5 Shot 35 Rem. 5 Shot 308 Win. 6 Shot 222 Rem.
BARREL	Tapered, Remington Proof Steel 18-1/2" With Ventilated Rib, Matted between Sights
OVER-ALL LENGTH	37-1/4"
STOCK	Selected American Walnut, custom checkering on fore-end and pistol grip. Monte Carlo stock with fluted comb
	<i>14"</i> Length of pull 2" Drop at heel 1-5/8" Drop at comb
RECEIVER	Drilled and tapped for scope mounts Fixed magazine
SIGHTS	Blade ramp front sight with brass bead "U" notch rear sight adjustable for elevation and windage with adjustable screws
SAFETY	Positive rotary thumb type with corrugated nonslip surface
WEIGHT	5-1/2 lbs.





# REMINGTON ARMS COMPANY, INC.



MANUFACTURERS OF  
SPORTING FIREARMS, AMMUNITION

TRAPS TARGETS

POWER TOOLS

SPORTING FIREARMS  
ILLION, N. Y.  
AMMUNITION, BRIDGEPORT, CONN.  
POWER TOOLS, PARK FOREST, ILL.

BRIDGEPORT, CONNECTICUT 06602

PETERS CARTRIDGE DIVISION  
BRIDGEPORT, CONN.  
TRAPS AND TARGETS, FINDLAY, OHIO  
CABLE - HARTLEY, BRIDGEPORT

*m/600 - adv*

December 6, 1963

NEW FOR '64...

A NEW CONCEPT IN CARBINES

THE FABULOUS LIGHTWEIGHT REMINGTON MODEL 600

BOLT ACTION CARBINE, CENTER FIRE RIFLE

To Our Wholesalers

Gentlemen:

Here is the new Model 600 - the new lightweight Remington bolt action carbine, center fire rifle...a new concept in carbines - that pound for pound...packs more power, more punch, and more accuracy than any rifle in its class.

Unique in design, built to take the toughest punishment... the Model 600 is precision rifled for exacting accuracy standards ...Monte Carlo stock...ventilated rib on barrel forms quick sight line to get on target faster...non-slip grip for steady holding ...'customized' checkering on rich American walnut...with the world's strongest bolt action, found only in Remington guns.

Versatile - easy-to-carry, easy-to-handle, the fast-pointing Model 600 weighs only 5-1/2 lbs. Overall length of 37-1/4" makes it ideal in the heavy brush country...the right gun for the saddle ...the right gun anywhere.

Popularly priced...choice of three favorite calibers...the powerful brush-busting 35 Remington...the 'big game' 308...the high velocity, flat trajectory Remington 222 varmint cartridge - the Model 600 is loaded with sales appeal - for shooters everywhere.



December 6, 1963

AVAILABILITY

The new Model 600 bolt action carbine, center fire rifle will be available on January 2, 1964, for salesmen sampling, and for stock shortly thereafter.

PRICES AND TERMS

	<u>Net to Wholesaler</u>		<u>Dealer</u>	<u>Retail</u>
	<u>Less Tax</u>	<u>Tax Included</u>		
MODEL 600 - 222 Remington )				
308 Win. )	\$55.75	\$61.88	\$75.00	\$99.95
35 Remington )				

The net prices are shown both with and without the U.S. Excise Tax of 11%. Dealer and retail prices include this tax. Terms and conditions as stated in our Firearms Wholesaler Appointment Letter with Prices and Terms of December 6, 1963, will apply. The above dealer and retail prices, effective January 2, 1964, will be established as minimum Fair Trade prices in all states having Fair Trade laws in effect.

ADVERTISING MATERIAL

A quantity of catalog pages is being sent to you under separate cover. Additional pages and/or electrotypes in sizes 2-5/8", 3-1/4", 4" and 6" are available on request.

-----

The new Model 600 bolt action carbine, center fire rifle will heighten the enjoyment of shooters and hunters the world over - but what's more it will increase your sales - and your profits. Please send us your orders.

Sincerely,



Vice President and  
Director of Sales

Gail Evans/mgm



NEW MODEL 600 CARBINE

WHOLESALE STOCK ORDER FORM

Date \_\_\_\_\_

TO: ORDER DEPARTMENT  
REMINGTON ARMS COMPANY, INC.  
BRIDGEPORT, CONNECTICUT #06602

PLEASE SHIP AND BILL AT REGULAR PRICE WITH SPRING DATING TERMS, TO

ORDER  
NUMBER

\_\_\_\_\_  
(Wholesaler's Name)

\_\_\_\_\_  
(Street Address)

\_\_\_\_\_  
(City)

\_\_\_\_\_  
(State)

Attention of \_\_\_\_\_  
(Name of Firearms Buyer)

\*\*\*\*\*

NEW MODEL 600 CARBINE

<u>QUANTITY</u>	<u>NUMBER</u>	<u>CALIBER</u>
_____	5728	35 Remington
_____	5722	308 Win.
_____	5726	222 Remington

\*\*\*\*\*

SPECIAL INSTRUCTIONS, IF ANY \_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_

\_\_\_\_\_  
(Buyer's signature)



TO: ORDER DEPARTMENT  
REMINGTON ARMS COMPANY, INC.  
BRIDGEPORT, CONNECTICUT #06602

Order Number

PLEASE SHIP PREPAID ONE EACH OF THE NEW REMINGTON SAMPLE GUNS CHECKED BELOW. BILL AT REGULAR PRICE WITH SPRING DATING TERMS; NO DROP SHIPMENT CHARGE. INCLUDE WITH THE NEW GUN (WHEN CHECKED) A NEW \$11.00 PROTECTIVE GUN CASE AT A NET COST OF \$4.13 EACH.

## SALESMAN'S NAME AND HOME ADDRESS

[illegible]

\*If you prefer specifications other than the ones suggested, please insert gun index number in space provided for your check-mark under "Gun."

(Buyer's Signature)

**CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER**

R2528415



## DON'T SAY IT—WRITE IT

cc: F.E. Morgan

TO E. S. Mc CAWLEY - BridgeportDATE Oct. 15, 1963FROM W. E. LEEK - Ilion

## TECHNICAL INFORMATION - MODEL 600 RIFLE

I am assuming that you have available general specifications for this model so will ignore commenting on that particular area and concentrate mainly upon the background and the reasons for development of the new rifle.

As far as we know there is no really light, high powered rifle regardless of the type of action on the market today. It is indeed getting very difficult to penetrate the bolt action market with anything new in this line. We did succeed in the Model 700 by introducing new calibers and new styling. However, the Model 700 as far as general shape, length, overall calibers and weight is concerned is quite similar to others in existence. There appeared to be one niche left in the general overall bolt action market and that was one which might be filled by a very light carbine type rifle in calibers up to and including 35 short magnum calibers.

We are planning to introduce the M/600 the first of 1964 in three calibers; the 222 Remington, 35 Remington and the 308. Of these three, the 308 will probably be the most popular as it presents a very potent cartridge in such a light rifle. Generally speaking, you will find this caliber in rifles weighing 6 1/2 lbs. upward and ones that have a length of 43 to 45 inches; whereas the M/600 will weigh 5 1/2 lbs. and the length will be approximately 37 inches.

There was also a need for a rifle that would adequately fit a horse scabbard with no protrusions of the bolt handle in the scabbard. This was neatly accomplished by pulling the bolt handle inwardly toward the stock, cutting the curved shape of the knob in half so that protrusions of the knob against the scabbard would not take place. Another neat feature is the forward crooked leg of the bolt handle. This allows the handle to be far forward of the trigger finger, preventing impact of the bolt handle against the finger during heavy impact from the recoil of large calibers. This has been demonstrated recently by the test firing of this model with the new short 35 Magnum which produces tremendous energy and with a fairly heavy recoil. Nothing was felt between the bolt handle and the trigger finger, as is usually felt by other bolt action rifles of even lighter recoil.

In addition to this exclusive feature, a rib was added to the barrel giving it a finer, higher class appearance with better sighting availability. This principle has long been used in fine shotguns and also target revolvers and pistols, and is believed to enhance the appearance of the rifle in addition to providing quicker sighting arrangements.

The M/94 Winchester has of course given all other guns a great deal of competition since its original impact on the market years ago. We believe that this rifle has

THERE IS A SAFE WAY; DO IT THAT WAY



Oct. 15, 1963

been popular because of its light weight, slenderness and short length, in addition to its larger magazine capacity. It has been popularized of course by good advertising and TV shows, and has been a hand-me-down from father to son for several generations. It is our belief that the rifle popularized the caliber, the reverse not being true. Although the 30-30 Caliber is one of the best sellers it is certainly one of the least potent of deer killing calibers and has wounded and maimed a considerable number of deer during its history. It is our hope that the Model 600 will go into direct competition with the M/94, comparing favorably in price, length, weight and of course providing it with a more potent caliber, the 308, than the 30-30 in the M/94.

The quick handling of a short barrel carbine is encouraging and the long distance shooting in the 308 Calibers tested in Idaho and Wyoming this summer produced some very astonishing results. Good hits at objects the size of an ordinary deer could be made at 800 yds., quite comparable to the M/700 in the 7mm cartridge. However, beyond 800 yds. the 7mm was most desirable.

As far as quick shooting was concerned the M/600 made very good account of itself on running jackrabbits up to 100 yds. Elmer Keith, who joined me in shooting this rifle, claims it will be an excellent rifle in the north woods, and especially in Alaska for fishermen and trappers who do not care to carry a heavy rifle around during their fishing and trapping seasons, but want something that is potent enough to stop a bear. He is, of course, very anxious to see it come out in the larger calibers, and is most anxious to hear of our results when we produce the 35 short magnum.

This leads us into a new area of calibers which are very potent and will popularize this model. We plan to produce the 35 short magnum and the 7mm short magnum for this model in the following year 1965. Testing of the 35 short magnum is already in progress and results are phenomenal, as Bridgeport people advised us of extreme accuracies of each group at 100 yds. with more potential energy and velocity out of an 18" barrel with this caliber than the 30-06 will produce in a 24" barrel.

Shoulder firing to date in the 35 short magnum indicates that the recoil when shooting 150 and 200 grain in 35's is relatively light in comparison to what was expected. However, in this model with the heavier calibers a rubber recoil pad will be necessary.

The 35 Remington has been quite popular in the eastern areas and it has been a good deer stopper at short ranges. Its trajectory is quite undesirable at long ranges, however. Its brush bucking capabilities are quite superior to the smaller calibers but it will be far overshadowed when the magnum makes its debut one year later. It is my belief that the 35 Remington will <sup>not</sup> be very popular in the western areas, but the impact of the 35 short magnum in the western states in the M/600 will get tremendous acceptance.



Oct. 15, 1963

Ballistics data are not available for the 7mm short magnum at this time but it is believed that results will also be astonishing. We may find that other calibers in the short magnum case such as the 6mm and the 257 might become quite popular. These will have to be investigated at a later date.

We are also experimenting with a laminated stock of three to five plys which could be introduced into this model with the magnums, as a plus feature. Of course these items will require a higher selling price.

There is seldom that there is a requirement in the gun line for a new model, and especially in this bolt action line, and I feel that we are fulfilling a need and a requirement ahead of our competitors. This has been demonstrated in the past by the introduction of the 222, 44 Mag., 7mm Mag., the Nylon line, the XP-100 Pistol. There was a need and a requirement for these items and proof was recorded by our high sales volume. Let's hope that this trend continues with the introduction of the new Model 600.



W. E. Leek

Firearms Design & Development  
Ilion Research Division

WEL:T



M/600 - Barrel



REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE



CC: H. K. Boyle  
R. L. Hall  
G. J. Hill  
R. D. Stowell

"CONFINE YOUR LETTER TO ONE SUBJECT ONLY"

Ilion, New York  
December 10, 1970

*N/600 Barrel.*

E. R. CARR

PRODUCT DEFICIENCY REPORT - MODEL 600 NFT BARREL BLANK

The product was reviewed by the writer at 8:00 A.M. on the same date as the Audit (12-9-70) and the following conditions were present:

1. All gage points except the one  $18\frac{1}{2}$ " from the breech were well within gage. The one at the muzzle was reading oversize due to excessive Stock at the Turn Operation to gain blank length. This point is at the end of the Barrel and beyond the Stock and was considered acceptable as long as all other conditions were to gage.
2. Air gage spindles indicated a groove diameter of .0000 to +.0001 at the muzzle with approximately .0002 taper and a bore diameter of +.0003 to +.0004 at the muzzle and about .0002 taper.
3. The Drop Plug for the lower half tolerance bore was "going".
4. The blank from the Upset Operation was "scant stock" on the big taper and a large number of forged blanks were bent and would not accept the Drop Plug and the air gage spindles would either hang or drag.

Upon being told of the Deficiency Report, the writer reviewed the product again and found all the conditions listed to be true. Investigation showed the cause of the air gage spindles not going into the bore was a "bugged" mandrel that the operator (a fairly new employee) could not identify and the "scant stock" blanks that were bent but not rejected by the operator. The undersize diameter on the master gage was the result of a temporary shim added to the Turn template in order to gain material, had slipped. The change had not been noted by the operator.



December 10, 1970

The visual condition on the Breech is a combination of machine "dwell" and machine "factor" to the form template as run on this machine (#4 GFM) as compared to the initial trial on #2 GFM. Nothing could be done to alter this condition.

Upon resetting the lathe and "debugging" the mandrel, the blank was back to the initial set-up condition - if the turned blank cleaned up, the forged blank was in gage throughout. If the blank had scant stock, the Drop Plug would not pass through indicating a bent Barrel.

This information was passed on to the supervisor and day shift foreman with the instructions that all the blanks run would have to be screened to pick out the "bugged" rifling and bent blanks passed by the inexperienced operator. The diameter deficiency is acceptable by deviation on this lot and new tooling must be designed to prevent recurrence.

  
\_\_\_\_\_  
J. W. Blair II  
Process Engineer

JWB:eb



**DON'T SAY IT—WRITE IT**TO F. E. MORGAN - BRIDGEPORTDATE Nov. 29, 1963FROM V. G. DUBOIS - ILIONCC: S. M. Alvis  
H. J. Mackman  
R. B. Hurley**MODEL 600 - EXPORT FOR JAPAN - 19 1/2" BARREL**  
**(Reference Nov. 12, 1963 letter)**

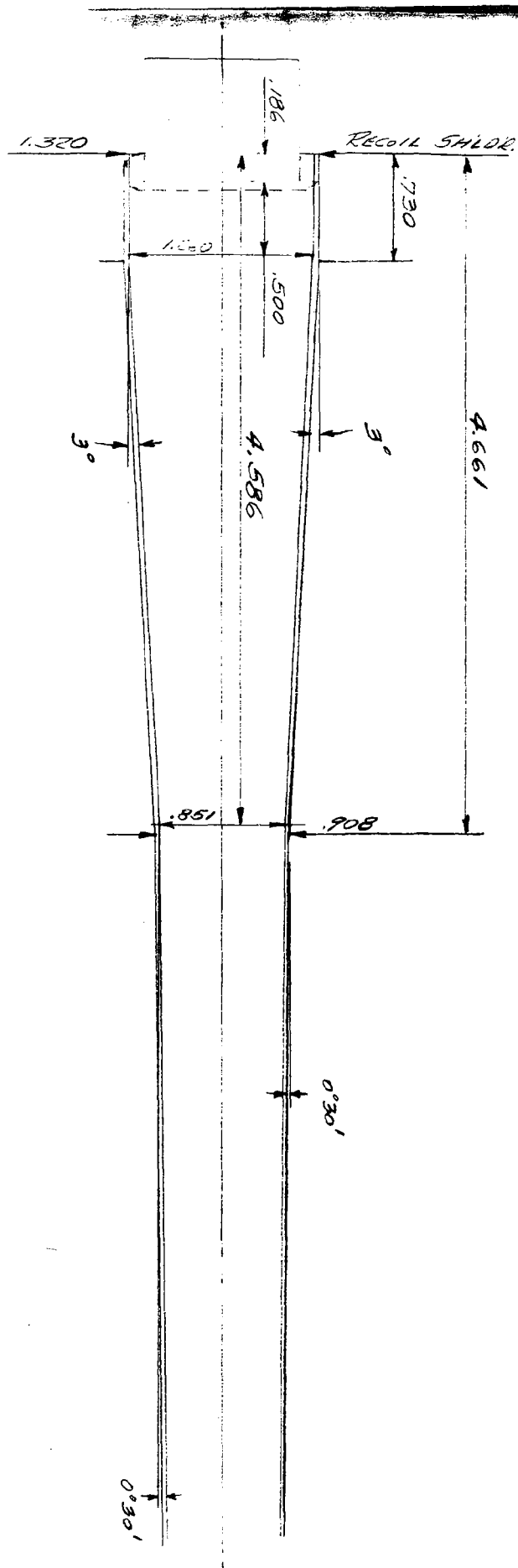
A high-spot check indicates that Barrel tooling from the starting operation and continuing throughout this process would be required to produce a 19 1/2" Barrel. The present Model 600 Barrel has a nominal length of 18 1/2".

Since there would be a considerable tooling cost, it is questionable if the added sales would justify. If a detailed estimate is desired, the economics can be developed. Ilion would need annual volumes and selling price as a basis for any estimate.

VED:I

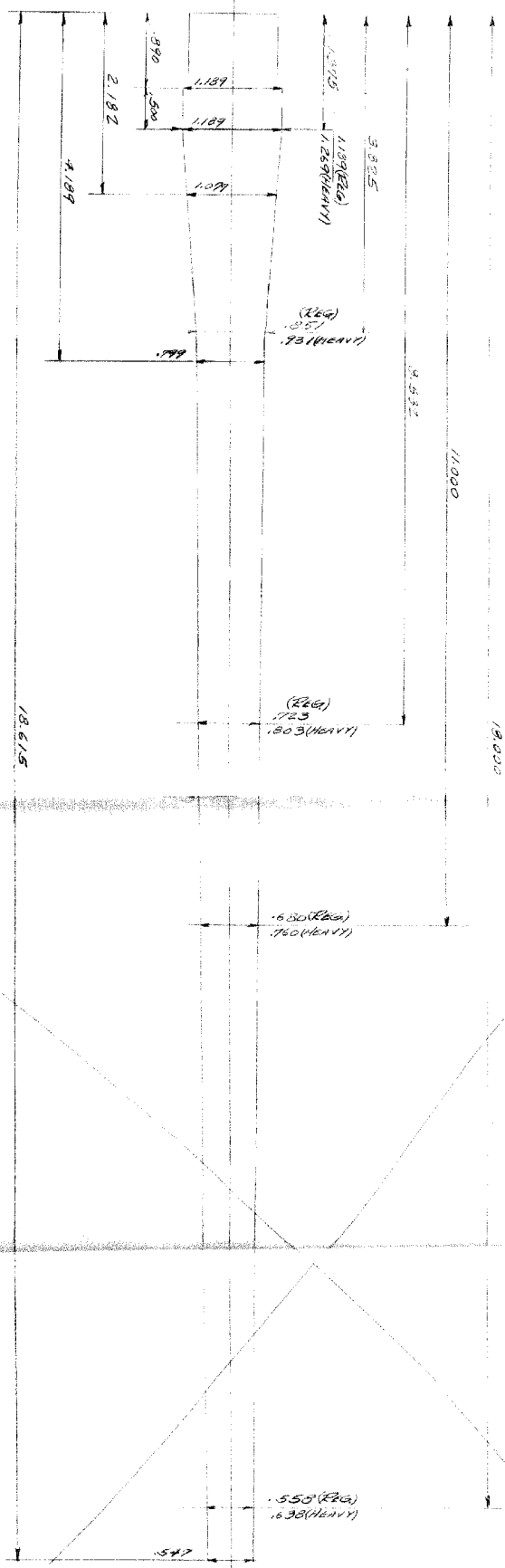
TO BE SAFE; FIRST THINK YOU MIGHT NOT BE





M/660 BBL. + STOCK PLAY VIEW AT ASSEM.  
SCALE: F. 5. - 25X - 6/1/87





NOTE: USE WITH C-75-4739  
M600 REG + HEAVY 1/4" S.  
C5K-8/23/68







P.B.H.  
CC: Lloyd Fox  
G. J. Hill  
July 18, 1966

R. P. KELLY

REPORT ON M/600 BARREL ASSEMBLIES

Requested:

- (1) Two .308 Caliber assemblies with a Magnum form and a standard length.
- (2) Two 6.5 Caliber assemblies with a Magnum form and a 20" length.

Results:

- (1) Five Barrels of each caliber were requested from Production to provide a buffer for scrap. Two .308's more than the five requested were received because of a machine set-up.
- (2) Turning and threading of the Breech was done in the Model Shop.
- (3) Five .308's were scrapped, three at Finish Turn and two at Turn and Thread Breech. Three 6.5's were scrapped, two at Finish Turn and one at Turn and Thread Breech.

Operations Charged to this Order:

<u>Oper. No.</u>	<u>Operation</u>	<u>Dept.</u>
45	Form Turn	48
50	G.F.M. Form and Finish Bore	48
61	Cut-off Muzzle end and Deburr	48
73	Finish Turn	58
106	Centerless Polish Full Length	58
120	Cut-off And Crown to Length	58
5	Assemble	58
15	Roll Mark	58



R. P. KELLY

-2-

July 18, 1966

Operations Charged to this Order: Cont'd.

<u>Oper. No.</u>	<u>Operation</u>	<u>Dept.</u>
5A	Cut to Length	73
10	Heat Upset and Trim	73
30	Machine Straighten	66
35	Drill Bore	66
44A	Ream Bore	66
73	Finish Turn	58
106	Centerless Polish Full Length	58
120	Cut-off and Crown to Length	58
5	Assemble	58
15	Roll Mark	58

The Barrels have been delivered as requested. They have no Sight Holes, no Vent Rib Studs, and no Chamber; they are colored.

Process Eng. - Current Products  
R. B. Hurley, Supervisor

By A. J. Schmidt  
A. J. Schmidt  
Process Engineer

AJS/ew



~~1000~~ 600 - 6 mm Barrel Blank length

700 — went from .770  $\pm .100$  cutoff length

to 2.570  $\pm .100$

plus elim cuprodoni / min groove diam.

& better ammo.

600 — have. ~~.345~~ <sup>.345</sup>  $\pm .100$

should go to ~~2.155~~ <sup>2.155</sup>  $\pm .100$  by going to 20" blank.

need new turning jammers



## REMINGTON ARMS COMPANY, INC.

ENGINEERING DEPARTMENT  COMPUTATION SHEETJ. H. MOCH  
E. BURGER  
SHEET NO. \_\_\_\_\_

TITLE OF PROJ. FINISH COMPARISON ON PROJ. NO. \_\_\_\_\_  
 SUBJECT CENTER FIRE BB's. WORKS \_\_\_\_\_  
PRESENT COST COMPUTER SA DATE 5-8 1963.

MODEL <u>XP 100</u> PT. No <u>26760</u>			
QTY.	DESCRIPTION	LABOR	EXPENSE
95	G/L GRIND BREECH	* 3.102	* 1.692
100	" " MUZZLE	3.434	1.120
105	SPIN Polish	2.800	2.426
		* 9.336/100	* 5.238/100
MODEL <u>600</u> PT. No <u>26690</u>			
61	HAND SPIN Polish Ro. No Finish	* 9.080/100	* 7.030/100
MODEL <u>700</u> PT. No <u>26291</u>			
70	CENTERLESS Polish ROUGH	2.986	1.865
72	CENTERLESS " " FINISH	3.220	1.699
		* 6.206/100	* 3.564
M/600 Bbl. TRIAL <sup>NO</sup> PILOT PROCESS FINISH WAS SAME AS M/700. HOWEVER TAPER PREVENTS CENTERLESS Polish			



MODEL 600



## REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE

Remington



JUL 26 1983

June 28, 1983

TO: D. J. Sanita  
 FROM: K. N. Waite, Jr.  
 SUBJECT: MODEL 600 TRIGGER ASSEMBLIES

Dennis:

Dick St. John has advised me that of late he has encountered several warranty gunsmiths authorized to do the Model 600 trigger replacements that claim we are not providing triggers and as a result, guns remain unrepaired.

Can you give me any details referencing present and/or future availability of Model 600 trigger assemblies?

Thanks for your help.

KNW/lc

Ken,  
 We are currently holding 24 orders for a total of  
 127 trigger assem. Oldest order is dated March 15, 1983.  
 MRP group on 6/21/83 advised that it will be available  
 longer. Production needs gun & safety cam assem's.

*Dennis 7/5/83*



# REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE

*Remington*



*Copy to Dennis Smith*  
*4-22-82*

cc: C. A. Riley  
H. K. Boyle  
~~J. H. Carter~~  
P. H. Holmberg  
W. H. Forson  
K. D. Green  
J. A. Stekl  
R. B. Sperling

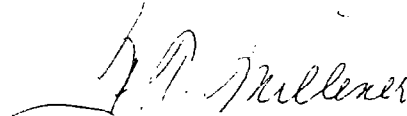
Bridgeport, Connecticut  
April 19, 1982

C. B. WORKMAN

## INSTRUCTION FOLDERS FOR MODEL 600 RIFLES

In conjunction with the process change to remove the bolt lock from the Model 700, the Model 600 will lose its bolt lock also. After the current supply of Model 600 bolts and/or safeties is used up, we will start using the new parts.

Arms Service will need Model 600 instruction folders appropriate to include with guns returned after being repaired. Please revise the current manual (Attached) to reflect removal of the bolt lock.



F. T. Millener

FTM: fms  
att.



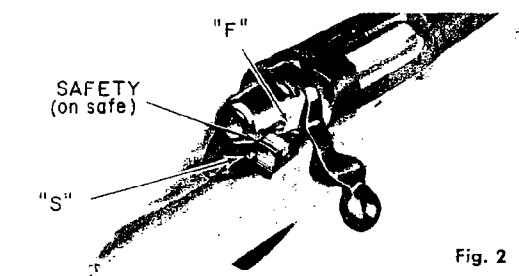
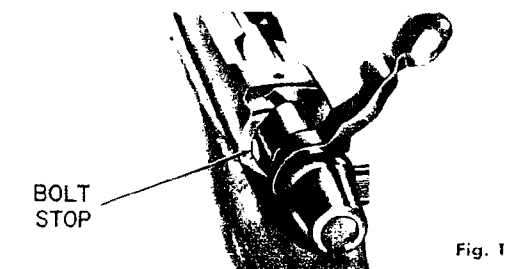
# HIGH POWER CARBINE

MOHAWK  
600

## FIXED BOX MAGAZINE

## BOLT ACTION REPEATER

# INSTRUCTION FOLDER and PARTS LIST



The Mohawk 600 is a light-weight, compact length carbine. In the 308 Win., 6mm Rem. and 243 Win. calibers, capacity of five (5) cartridges is possible — four (4) in the fixed magazine and one in the barrel chamber. In the 222 Rem. caliber, magazine capacity is five (5) cartridges.

**ACTION** — The Mohawk 600 includes a strong, steel shrouded bolt face and a jacket type bolt plug. A solid piece bolt with close fitting handle can be easily removed for takedown purposes. The receiver is fitted with removable plug screws for receiver sights or telescope mounts.

**STOCK** — The full length Monte Carlo stock features a form fitting pistol grip and custom checkering. A sling strap, complete with mountings, is available as an accessory at extra cost.

**CAUTION** — While handling, carrying, loading or unloading rifle, make sure that muzzle is pointed in a safe direction.

**TO PUT BOLT IN RIFLE** — Align bolt lugs to receiver, rotate safety forward and slide cocked bolt into rifle.

**TO REMOVE BOLT** — ~~Push safety forward to unlock bolt and raise bolt handle. Pull bolt rearward. Press down on front of bolt stop (located in left rear of bolt channel of receiver) with small, flat key or screw driver (Fig. 1). Allow bolt to slide back and disassemble as bolt stop is passed.~~

**SAFETY (Fig. 2)** — Side lever type safety is located at right rear of receiver. Close bolt and rotate safety to rear stop position marked fire rifle and bolt handle cannot be raised to unlock and open action.

"S" on receiver. In this position, trigger cannot be pulled to fire rifle. Trigger can be pulled to fire rifle and bolt handle can be raised to open action. **CAUTION:** Before loading make sure barrel bore is clear — free of heavy oil, grease, or any obstruction.

**TO SINGLE LOAD** — Raise bolt handle and pull bolt rearward to open action. With muzzle pointed in **SAFE** direction, load cartridge into breech. Close bolt to chamber cartridge and lower bolt handle to lock action. Rotate safety to rear **ON SAFE** position.

**TO UNLOAD BARREL CHAMBER** — Point muzzle in **SAFE** direction. ~~Rotate safety to forward FIRE position and raise bolt handle to unlock action.~~ Pull bolt rearward until tip of bullet clears receiver. Lift cartridge from rifle.

**TO LOAD MAGAZINE** — Open bolt. Point muzzle in **SAFE** direction. Load cartridges directly into magazine in conventional manner.

**TO UNLOAD MAGAZINE** — **Caution:** Make certain barrel chamber is empty when unloading magazine. Pull bolt rearward and then push forward until cartridge is released from magazine. Lift cartridge from rifle. Repeat until magazine is empty.

**SIGHTS** — The Mohawk 600 is factory equipped with open sights (Fig. 3). Windage or elevation adjustment may be made with rear sight. The front sight is "fixed" type, not adjustable for windage or elevation.

**ELEVATION OR RANGE** — If shots are too high, loosen elevation screw and lower rear sight eyepiece. If shots are too low, rear sight eyepiece should be raised.

**WINDAGE** — The rear sight eyepiece may be moved left or right by loosening the windage screw. If rifle shoots to left, the rear sight eyepiece should be moved to right. Should rifle shoot to right, move rear sight eyepiece to left.

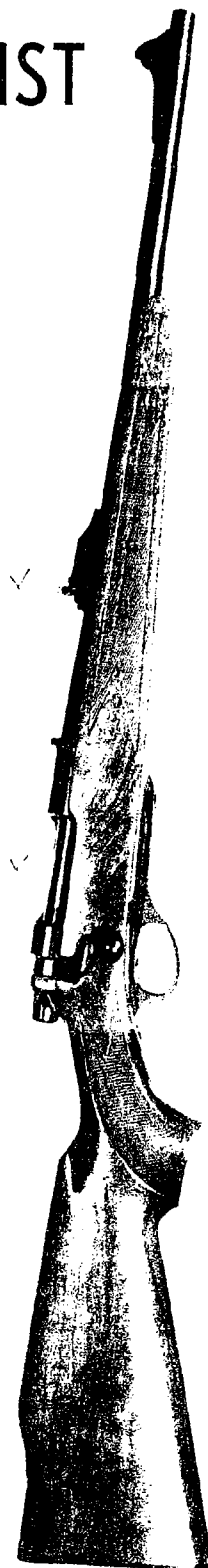
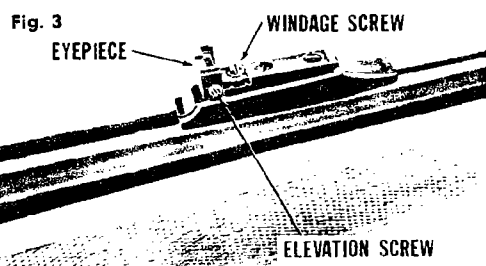
**NOTE:** Windage screw is located in front of the rear sight eyepiece.

**CLEANING AND CARE** — **Caution:** Make sure rifle is empty of live ammunition before cleaning. To make cleaning of barrel or bolt easier remove bolt from rifle. (See Fig. 1). Use a good petroleum solvent for cleaning of parts.

**CLEANING OF BARREL** — Use lightly oiled, soft cloth and clean from breech to muzzle. Scrub barrel bore and cartridge chamber in barrel with a good bore solvent, if necessary. Wipe dry and re-oil bore and chamber very lightly.

**CLEANING OF BOLT** — Brush face of bolt to remove shooting residue. Wipe dry and re-oil very lightly. To prevent undue wear, lubricate cam surfaces at rear of bolt — top and bottom. Additional care and cleaning of bolt parts can be done, if necessary.

**TO DISASSEMBLE BOLT PARTS** — Remove bolt. Pull firing pin head back until coin or similar piece can be inserted in slot near back edge of firing pin head (Fig. 4). Then hold bolt handle and turn bolt plug at rear until entire firing pin assembly can be unscrewed and removed from bolt assembly. Reassemble in reverse order.



REMINGTON ARMS COMPANY, INC. • Ilion, New York, U.S.A.



xc: P.H. Holmberg - Bpt.  
W.K. Bryant  
C.B. Workman

**REMINGTON ARMS COMPANY, INC.**

INTER-DEPARTMENTAL CORRESPONDENCE



"CONFINE YOUR LETTER TO ONE SUBJECT ONLY" \_\_\_\_\_

July 1, 1980

TO: J. H. CARTER  
FROM: J. W. BROOKS *JWB*  
SUBJECT: BOLT ACTION RIFLES FOR FIELD TEST

-----

We have furnished seventeen (17) bolt action rifles in 7mm-08 caliber for field testing. Bridgeport could not furnish the Ilion plant with a shipping number because this rifle does not have a RAMAC number. We therefore sent the rifles out on M-Orders (copies attached).

We sent the rifles to the people designated by Marketing using copies of Product Consignment Transaction Notice furnished to us by Paul Holmberg.

JWB:sse  
Attach.



-43864 sse 6/24/80

MAKE ALL REMITTANCES TO BRIDGEPORT, CONN.

**REMINGTON ARMS COMPANY, INC.**

Remington.

FIREARMS. AMMUNITION. TARGETS. TRAPS. AND POWDER METAL PARTS  
BRIDGEPORT, CONN.

Remington.



INVOICE NO.

INVOICE DATE

ORDER NO. M-43864

SHIPPED FROM ILION, NEW YORK

VIA P.H. Holmberg

CASES

WEIGHT

10

QUANTITY	SUGGESTED RETAIL	UNIT PRICE	TOTAL
10	7mm-08 Cal. Bolt Action Carbine	MEMO	
CONSIGNED TO THE FOLLOWING:			
1 -	P.H. Holmberg	Serial No. B6226257	
1 -	J.G. Williams	" " B6226240	
1 -	J.E. Preiser	" " B6226246	
1 -	E.J. Conroy	" " B6226248	
1 -	E.G. Larson	" " B6226220	
1 -	J.C. Callahan	" " B6226251	
1 -	R.J. Reineck	" " B6226252	
1 -	T.W. Rawson	" " B6226213	
1 -	R.F. Dietz	" " B6226241	
1 -	W.H. Forson	" " B6226232	
FOR: FIELD TEST			
TO BE RETURNED			
Requested by: J.W. Brooks			
Approved by: <i>[Signature]</i>			
W.O. G-0305			

"THE SELLER WARRANTS THAT, IN THE PRODUCTION OF THE ARTICLES COVERED BY THIS INVOICE, IT HAS COMPLIED WITH ALL THE APPLICABLE PROVISIONS OF THE FAIR LABOR STANDARDS ACT OF 1938 AS AMENDED."

ORIGINAL INVOICE

W.O. G-0305



720 RDS.

## PRODUCT CONSIGNMENT TRANSACTION NOTICE

DATE 6/6/80 REQUESTED BY: W. H. Forson, Jr.

TRANSACTION NEW CONSIGNMENT (XX)  
(CHECK TYPE) RETURN GOODS ( )  
TRANSFER OR EXCHANGE ( )\*  
SALE ( )\*\*  
WRITE-OFF ( )

cc: J. W. Brooks✓  
P. H. Holmberg

## APPROVALS:

REGIONAL MANAGER \_\_\_\_\_

AREA MANAGER \_\_\_\_\_

PRODUCT MANAGER \_\_\_\_\_

DIR. OF SALES W.H. Forson J. Rein

## ACCOUNT TO BE CHARGED:

NAME P. H. Holmberg/Rem. ArmsSTREET 939 Barnum Ave.CITY Bpt., STATE CT 06602

## ACCOUNT TO BE CREDITED:

NAME \_\_\_\_\_

STREET \_\_\_\_\_

CITY \_\_\_\_\_ STATE \_\_\_\_\_

SOLD TO CONSUMER ☐SOLD TO DEALER ☐SALES TAX APPLICABLE ☐SALES TAX NOT APPLICABLE ☐

## FIREARMS PRODUCT IDENTIFICATION

QUAN.	ORDER NO.	MODEL	GRADE	GA OR CAL	BBL LGTH	CHOKE	TYPE	SERIAL NO.
1		BAC		7mm-08			RK	B6226257

## OTHER PRODUCT IDENTIFICATION

QUAN.	ORDER AND/OR PART NO.	DESCRIPTION

## BILLING INSTRUCTIONS FOR CONSIGNMENT SALES

PRODUCT VALUE	U.S. EXCISE TAX	CITY SALES TAX	STATE SALES TAX	TOTAL BILLING

## REMARKS

REFER ORDER TO JOHN BROOKS

NOMINAL VALUE WRITE DOWN APPROVALS

ACCOUNT TO BE CHARGED FOR WRITE DOWN AMOUNTS:

\*Requires signatures of parties involved.

\*\*Must be in accordance with Gun Control Act of 1968.



REV. 4

PRODUCT CONSIGNMENT TRANSACTION NOTICE

DATE 6/6/80 REQUESTED BY: W. H. Forson, Jr.

TRANSACTION NEW CONSIGNMENT (XX)  
(CHECK TYPE) RETURN GOODS ( )  
TRANSFER OR EXCHANGE ( )\*  
SALE ( )\*\*  
WRITE-OFF ( )

cc: J. W. Brooks ✓  
J. G. Williams

APPROVALS:

REGIONAL MANAGER \_\_\_\_\_

AREA MANAGER \_\_\_\_\_

PRODUCT MANAGER Paul G. Kelly 6/13

DIR. OF SALES \_\_\_\_\_

ACCOUNT TO BE CHARGED:

NAME J. G. Williams/Rem. Arms

STREET 939 Barnum Ave.

CITY Bpt., STATE CT 06602

ACCOUNT TO BE CREDITED:

NAME \_\_\_\_\_

STREET \_\_\_\_\_

CITY \_\_\_\_\_ STATE \_\_\_\_\_

SOLD TO CONSUMER ☐

SOLD TO DEALER ☐

SALES TAX APPLICABLE ☐

SALES TAX NOT APPLICABLE ☐

FIREARMS PRODUCT IDENTIFICATION

BILLING INSTRUCTIONS FOR CONSIGNMENT SALES

QUAN.	ORDER NO.	MODEL	GRADE	GA OR CAL	BBL LGTH	CHOKE	TYPE	SERIAL NO.	PRODUCT VALUE	U.S. EXCISE TAX	CITY SALES TAX	STATE SALES TAX	TOTAL BILLING
1		BAC		7mm-	08		RK	B6226240					
OTHER PRODUCT IDENTIFICATION													
QUAN.	ORDER AND/OR PART NO.				DESCRIPTION								
1	B6226240												

REMARKS

REFER ORDER TO JOHN BROOKS.

NOMINAL VALUE WRITE DOWN APPROVALS

ACCOUNT TO BE CHARGED FOR WRITE DOWN AMOUNTS:

\*Requires signatures of parties involved.

\*\*Must be in accordance with Gun Control Act of 1968.



PRODUCT CONSIGNMENT TRANSACTION NOTICE

DATE 6/6/80 REQUESTED BY: W. H. Forson, Jr.

TRANSACTION NEW CONSIGNMENT (XX)  
(CHECK TYPE) RETURN GOODS ( )  
TRANSFER OR EXCHANGE ( )\*  
SALE ( )\*\*  
WRITE-OFF ( )

cc: J. W. Brooks ✓  
J. E. Preiser

APPROVALS:

REGIONAL MANAGER \_\_\_\_\_

AREA MANAGER \_\_\_\_\_

PRODUCT MANAGER Paul H. H. 6/13

DIR. OF SALES \_\_\_\_\_

ACCOUNT TO BE CHARGED:

NAME J. E. Preiser/Rem. Arms

STREET 939 Barnum Ave.

CITY Bpt., STATE CT 06602

ACCOUNT TO BE CREDITED:

NAME \_\_\_\_\_

STREET \_\_\_\_\_

CITY \_\_\_\_\_ STATE \_\_\_\_\_

SOLD TO CONSUMER ☐

SOLD TO DEALER ☐

SALES TAX APPLICABLE ☐

SALES TAX NOT APPLICABLE ☐

FIREARMS PRODUCT IDENTIFICATION

BILLING INSTRUCTIONS FOR CONSIGNMENT SALES

QUAN.	ORDER NO.	MODEL	GRADE	GA OR CAL	BBL LGTH	CHOKE	TYPE	SERIAL NO.	PRODUCT VALUE	U.S. EXCISE TAX	CITY SALES TAX	STATE SALES TAX	TOTAL BILLING
1		BAC		7mm-08			RK	B6226246					
OTHER PRODUCT IDENTIFICATION													
QUAN.	ORDER AND/OR PART NO.				DESCRIPTION								
	B 6226246												

REMARKS REFER ORDER TO JOHN BROOKS

NOMINAL VALUE WRITE DOWN APPROVALS

ACCOUNT TO BE CHARGED FOR WRITE DOWN AMOUNTS:

\*Requires signatures of parties involved.

\*\*Must be in accordance with Gun Control Act of 1968.



PRODUCT CONSIGNMENT TRANSACTION NOTICE

DATE 6/6/80 REQUESTED BY: W. H. Forson, Jr.

TRANSACTION NEW CONSIGNMENT (XX)  
(CHECK TYPE) RETURN GOODS ( )  
TRANSFER OR EXCHANGE ( )\*  
SALE ( )\*\*  
WRITE-OFF ( )

cc: J. W. Brooks ✓  
E. J. Conroy

APPROVALS:

REGIONAL MANAGER \_\_\_\_\_

AREA MANAGER \_\_\_\_\_

PRODUCT MANAGER Paul H. Harty 6/13

DIR. OF SALES \_\_\_\_\_

ACCOUNT TO BE CHARGED:

NAME E. J. Conroy/Rem. Arms

STREET 939 Barnum Ave.

CITY Bpt., STATE CT 06602

ACCOUNT TO BE CREDITED:

NAME \_\_\_\_\_

STREET \_\_\_\_\_

CITY \_\_\_\_\_ STATE \_\_\_\_\_

SOLD TO CONSUMER ☐

SOLD TO DEALER ☐

SALES TAX APPLICABLE ☐

SALES TAX NOT APPLICABLE ☐

FIREARMS PRODUCT IDENTIFICATION

BILLING INSTRUCTIONS FOR CONSIGNMENT SALES

QUAN.	ORDER NO.	MODEL	GRADE	GA OR CAL	BBL LGTH	CHOKE	TYPE	SERIAL NO.	PRODUCT VALUE	U.S. EXCISE TAX	CITY SALES TAX	STATE SALES TAX	TOTAL BILLING
1		BAC		7mm-08			RK	86226298					
OTHER PRODUCT IDENTIFICATION													
QUAN.	ORDER AND/OR PART NO.				DESCRIPTION								

REMARKS

REFER ORDER TO JOHN BROOKS

NOMINAL VALUE WRITE DOWN APPROVALS

ACCOUNT TO BE CHARGED FOR WRITE DOWN AMOUNTS:

\*Requires signatures of parties involved.

\*\*Must be in accordance with Gun Control Act of 1968.



PRODUCT CONSIGNMENT TRANSACTION NOTICE

DATE 6/6/80 REQUESTED BY: W. H. Forson, Jr.

TRANSACTION NEW CONSIGNMENT (XX)  
(CHECK TYPE) RETURN GOODS ( )  
TRANSFER OR EXCHANGE ( )\*  
SALE ( )\*\*  
WRITE-OFF ( )

cc: J. W. Brooks ✓  
E. G. Larson

APPROVALS:

REGIONAL MANAGER \_\_\_\_\_

AREA MANAGER \_\_\_\_\_

PRODUCT MANAGER Paul H. Hickey 6/13

DIR. OF SALES \_\_\_\_\_

ACCOUNT TO BE CHARGED:

NAME E. G. Larson/Rem. Arms

STREET 939 Barnum Ave.

CITY Bpt., STATE CT 06602

ACCOUNT TO BE CREDITED:

NAME \_\_\_\_\_

STREET \_\_\_\_\_

CITY \_\_\_\_\_ STATE \_\_\_\_\_

SOLD TO CONSUMER ☐

SOLD TO DEALER ☐

SALES TAX APPLICABLE ☐

SALES TAX NOT APPLICABLE ☐

FIREARMS PRODUCT IDENTIFICATION

BILLING INSTRUCTIONS FOR CONSIGNMENT SALES

QUAN.	ORDER NO.	MODEL	GRADE	GA OR CAL	BBL LGTH	CHOKE	TYPE	SERIAL NO.	PRODUCT VALUE	U.S. EXCISE TAX	CITY SALES TAX	STATE SALES TAX	TOTAL BILLING
1		BAC		7mm	08		SL	36226220					
OTHER PRODUCT IDENTIFICATION													
QUAN.	ORDER AND/OR PART NO.				DESCRIPTION								

REMARKS REFER ORDER TO JOHN BROOKS

NOMINAL VALUE WRITE DOWN APPROVALS

ACCOUNT TO BE CHARGED FOR WRITE DOWN AMOUNTS:

\*Requires signatures of parties involved.

\*\*Must be in accordance with Gun Control Act of 1968.



PRODUCT CONSIGNMENT TRANSACTION NOTICE

DATE 6/6/80 REQUESTED BY: W. H. Forson, Jr.

TRANSACTION NEW CONSIGNMENT (XX)  
(CHECK TYPE) RETURN GOODS ( )  
TRANSFER OR EXCHANGE ( )\*  
SALE ( )\*\*  
WRITE-OFF ( )

cc: J. W. Brooks ✓  
J. C. Callahan

APPROVALS:

REGIONAL MANAGER \_\_\_\_\_

AREA MANAGER \_\_\_\_\_

PRODUCT MANAGER Paul Hahley 6/13

DIR. OF SALES \_\_\_\_\_

ACCOUNT TO BE CHARGED:

NAME J. C. Callahan/Rem. Arms

STREET 939 Barnum Ave.

CITY Bpt., STATE CT 06602

ACCOUNT TO BE CREDITED:

NAME \_\_\_\_\_

STREET \_\_\_\_\_

CITY \_\_\_\_\_ STATE \_\_\_\_\_

SOLD TO CONSUMER ☐ SOLD TO DEALER ☐ SALES TAX APPLICABLE ☐ SALES TAX NOT APPLICABLE ☐

FIREARMS PRODUCT IDENTIFICATION

BILLING INSTRUCTIONS FOR CONSIGNMENT SALES

QUAN.	ORDER NO.	MODEL	GRADE	GA OR CAL	BBL LGTH	CHOKE	TYPE	SERIAL NO.	PRODUCT VALUE	U.S. EXCISE TAX	CITY SALES TAX	STATE SALES TAX	TOTAL BILLING
1		BAC		7mm-08			RK	86224251					
OTHER PRODUCT IDENTIFICATION													
QUAN.	ORDER AND/OR PART NO.				DESCRIPTION								

REMARKS REFER ORDER TO JOHN BROOKS

NOMINAL VALUE WRITE DOWN APPROVALS

ACCOUNT TO BE CHARGED FOR WRITE DOWN AMOUNTS:

\*Requires signatures of parties involved. \*\*Must be in accordance with Gun Control Act of 1968.



PRODUCT CONSIGNMENT TRANSACTION NOTICE

DATE 6/6/80 REQUESTED BY: W. H. Forson, Jr.

TRANSACTION NEW CONSIGNMENT (XX)  
(CHECK TYPE) RETURN GOODS ( )  
TRANSFER OR EXCHANGE ( )\*  
SALE ( )\*\*  
WRITE-OFF ( )

cc: J. W. Brooks ✓  
R. J. Reineck

APPROVALS:

REGIONAL MANAGER \_\_\_\_\_

AREA MANAGER \_\_\_\_\_

PRODUCT MANAGER Paul Volabey 6/13

DIR. OF SALES \_\_\_\_\_

ACCOUNT TO BE CHARGED:

NAME R. J. Reineck/Rem. Arms

STREET 939 Barnum Ave.

CITY Bpt., STATE CT 06602

ACCOUNT TO BE CREDITED:

NAME \_\_\_\_\_

STREET \_\_\_\_\_

CITY \_\_\_\_\_ STATE \_\_\_\_\_

SOLD TO CONSUMER ☐

SOLD TO DEALER ☐

SALES TAX APPLICABLE ☐

SALES TAX NOT APPLICABLE ☐

FIREARMS PRODUCT IDENTIFICATION

BILLING INSTRUCTIONS FOR CONSIGNMENT SALES

QUAN.	ORDER NO.	MODEL	GRADE	GA OR CAL	BBL LGTH	CHOKE	TYPE	SERIAL NO.	PRODUCT VALUE	U.S. EXCISE TAX	CITY SALES TAX	STATE SALES TAX	TOTAL BILLING
1		BAC		7mm-08			RK	86226252					
OTHER PRODUCT IDENTIFICATION													
QUAN.	ORDER AND/OR PART NO.				DESCRIPTION								

REMARKS REFER ORDER TO JOHN BROOKS

NOMINAL VALUE WRITE DOWN APPROVALS

ACCOUNT TO BE CHARGED FOR WRITE DOWN AMOUNTS:

\*Requires signatures of parties involved.

\*\*Must be in accordance with Gun Control Act of 1968.



PRODUCT CONSIGNMENT TRANSACTION NOTICE

DATE 6/6/80 REQUESTED BY: W. H. Forson, Jr.

TRANSACTION NEW CONSIGNMENT (xx)  
 (CHECK TYPE) RETURN GOODS ( )  
 TRANSFER OR EXCHANGE ( )\*  
 SALE ( )\*\*  
 WRITE-OFF ( )

cc: J. W. Brooks ✓  
 T. W. Rawson

APPROVALS:

REGIONAL MANAGER \_\_\_\_\_

AREA MANAGER \_\_\_\_\_

PRODUCT MANAGER Paul Holaday 6/13

DIR. OF SALES \_\_\_\_\_

ACCOUNT TO BE CHARGED:

NAME T. W. Rawson/Rem. Arms

STREET 939 Barnum Avenue

CITY Bpt., STATE CT 06602

ACCOUNT TO BE CREDITED:

NAME \_\_\_\_\_

STREET \_\_\_\_\_

CITY \_\_\_\_\_ STATE \_\_\_\_\_

SOLD TO CONSUMER ☐

SOLD TO DEALER ☐

SALES TAX APPLICABLE ☐

SALES TAX NOT APPLICABLE ☐

FIREARMS PRODUCT IDENTIFICATION

BILLING INSTRUCTIONS FOR CONSIGNMENT SALES

QUAN.	ORDER NO.	MODEL	GRADE	GA OR CAL	BBL LGTH	CHOKE	TYPE	SERIAL NO.	PRODUCT VALUE	U.S. EXCISE TAX	CITY SALES TAX	STATE SALES TAX	TOTAL BILLING
1		BAC		7mm-08			SV	86226218					
OTHER PRODUCT IDENTIFICATION													
QUAN.	ORDER AND/OR PART NO.				DESCRIPTION								

REMARKS

REFER ORDER TO JOHN BROOKS

NOMINAL VALUE WRITE DOWN APPROVALS

ACCOUNT TO BE CHARGED FOR WRITE DOWN AMOUNTS:

\*Requires signatures of parties involved.

\*\*Must be in accordance with Gun Control Act of 1968.



PRODUCT CONSIGNMENT TRANSACTION NOTICE

APPROVALS:

REGIONAL MANAGER \_\_\_\_\_

AREA MANAGER \_\_\_\_\_

PRODUCT MANAGER *[Signature]* 6/13

DIR. OF SALES \_\_\_\_\_

DATE 6/6/80 REQUESTED BY: W. H. Forson, Jr.

TRANSACTION NEW CONSIGNMENT (XX)  
(CHECK TYPE) RETURN GOODS ( )  
TRANSFER OR EXCHANGE ( )\*  
SALE ( )\*\*  
WRITE-OFF ( )

cc: J. W. Brooks ✓  
R. F. Dietz

ACCOUNT TO BE CHARGED:

NAME R. F. Dietz/Rem. Arms

STREET 939 Barnum Ave.

CITY Bpt., STATE CT 06602

ACCOUNT TO BE CREDITED:

NAME \_\_\_\_\_

STREET \_\_\_\_\_

CITY \_\_\_\_\_ STATE \_\_\_\_\_

SOLD TO CONSUMER ☐

SOLD TO DEALER ☐

SALES TAX APPLICABLE ☐

SALES TAX NOT APPLICABLE ☐

FIREARMS PRODUCT IDENTIFICATION

BILLING INSTRUCTIONS FOR CONSIGNMENT SALES

QUAN.	ORDER NO.	MODEL	GRADE	GA OR CAL	BBL LGTH	CHOKE	TYPE	SERIAL NO.	PRODUCT VALUE	U.S. EXCISE TAX	CITY SALES TAX	STATE SALES TAX	TOTAL BILLING
1		BAC		7mm-08			SL	56226241					
OTHER PRODUCT IDENTIFICATION													
QUAN.	ORDER AND/OR PART NO.				DESCRIPTION								

REMARKS REFER ORDER TO JOHN BROOKS

NOMINAL VALUE WRITE DOWN APPROVALS

ACCOUNT TO BE CHARGED FOR WRITE DOWN AMOUNTS:

\*Requires signatures of parties involved. \*\*Must be in accordance with Gun Control Act of 1968.



PRODUCT CONSIGNMENT TRANSACTION NOTICE

DATE 6/6/80 REQUESTED BY: P. H. Holmberg

TRANSACTION NEW CONSIGNMENT (XX)  
 (CHECK TYPE) RETURN GOODS ( )  
 TRANSFER OR EXCHANGE ( )\*  
 SALE ( )\*\*  
 WRITE-OFF ( )

cc: J. W. Brooks ✓  
 W. H. Forson

APPROVALS:

REGIONAL MANAGER \_\_\_\_\_

AREA MANAGER \_\_\_\_\_

PRODUCT MANAGER Paul Haly 6/13

DIR. OF SALES \_\_\_\_\_

ACCOUNT TO BE CHARGED:

NAME W. H. Forson/Rem. Arms

STREET 939 Barnum Ave.,

CITY Bpt., STATE CT 06602

ACCOUNT TO BE CREDITED:

NAME \_\_\_\_\_

STREET \_\_\_\_\_

CITY \_\_\_\_\_ STATE \_\_\_\_\_

SOLD TO CONSUMER ☐

SOLD TO DEALER ☐

SALES TAX APPLICABLE ☐

SALES TAX NOT APPLICABLE ☐

FIREARMS PRODUCT IDENTIFICATION

BILLING INSTRUCTIONS FOR CONSIGNMENT SALES

QUAN.	ORDER NO.	MODEL	GRADE	GA OR CAL	BBL LGTH	CHOKE	TYPE	SERIAL NO.	PRODUCT VALUE	U.S. EXCISE TAX	CITY SALES TAX	STATE SALES TAX	TOTAL BILLING
1		BAC		7mm-08			SV	86226232					
OTHER PRODUCT IDENTIFICATION													
QUAN.	ORDER AND/OR PART NO.				DESCRIPTION								

REMARKS REFER ORDER TO JOHN BROOKS

NOMINAL VALUE WRITE DOWN APPROVALS

ACCOUNT TO BE CHARGED FOR WRITE DOWN AMOUNTS:

\*Requires signatures of parties involved.

\*\*Must be in accordance with Gun Control Act of 1968.



M-43865 sse 6/24/80

MAKE ALL REMITTANCES TO BRIDGEPORT, CONN.

# REMINGTON ARMS COMPANY, INC.

Remington.

FIREARMS, AMMUNITION, TARGETS, TRAPS, AND POWDER METAL PARTS  
BRIDGEPORT, CONN.

Remington.



INVOICE NO.

INVOICE DATE 6/27/80

ORDER NO. M-43865

SHIPPED FROM ILION, NEW YORK

VIA Best Way UPS INS 6/26/8  
Value: \$500.

CASES


1

WEIGHT

9

SOLD TO

P.J. BERGERE  
REMINGTON ARMS COMPANY, INC.  
2975 W. MARKET ST.  
AKRON, OH 44313

QUANTITY	SUGGESTED RETAIL	UNIT PRICE	TOTAL
1	7mm-08 Cal. Bolt Action Carbine - Serial No. B6226259	MEMO	
	FOR: FIELD TEST TO BE RETURNED		
	Requested by: J.W. Brooks		
	Approved by 		
	W.O. G-0305		

se

"THE SELLER WARRANTS THAT, IN THE PRODUCTION OF THE ARTICLES COVERED BY THIS INVOICE, IT HAS COMPLIED WITH ALL THE APPLICABLE PROVISIONS OF THE FAIR LABOR STANDARDS ACT OF 1938 AS AMENDED."

ORIGINAL INVOICE

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER  
KINZER V. REMINGTON

R2528446



PRODUCT CONSIGNMENT TRANSACTION NOTICE

APPROVALS:

REGIONAL MANAGER \_\_\_\_\_

AREA MANAGER \_\_\_\_\_

PRODUCT MANAGER *P. J. Bergere 6/13*

DIR. OF SALES \_\_\_\_\_

DATE 6/6/80 REQUESTED BY: W. H. Forson, Jr.

TRANSACTION NEW CONSIGNMENT (xx)  
(CHECK TYPE) RETURN GOODS ( )  
TRANSFER OR EXCHANGE ( )\*  
SALE ( )\*\*  
WRITE-OFF ( )

cc: J. W. Brooks ✓  
P. J. Bergere

ACCOUNT TO BE CHARGED:

ACCOUNT TO BE CREDITED:

NAME P. J. Bergere/Rem. Arms

NAME \_\_\_\_\_

STREET 2975 W. Market St.

STREET \_\_\_\_\_

CITY Akron, STATE OH 44313

CITY \_\_\_\_\_ STATE \_\_\_\_\_

SOLD TO CONSUMER ☐

SOLD TO DEALER ☐

SALES TAX APPLICABLE ☐

SALES TAX NOT APPLICABLE ☐

FIREARMS PRODUCT IDENTIFICATION

BILLING INSTRUCTIONS FOR CONSIGNMENT SALES

QUAN.	ORDER NO.	MODEL	GRADE	GA OR CAL	BBL LGTH	CHOKE	TYPE	SERIAL NO.	PRODUCT VALUE	U.S. EXCISE TAX	CITY SALES TAX	STATE SALES TAX	TOTAL BILLING
1		BAC		7mm-08			RK	86226259					
OTHER PRODUCT IDENTIFICATION													
QUAN.	ORDER AND/OR PART NO.				DESCRIPTION								

REMARKS

REFER ORDER TO JOHN BROOKS

NOMINAL VALUE WRITE DOWN APPROVALS

ACCOUNT TO BE CHARGED FOR WRITE DOWN AMOUNTS:

\*Requires signatures of parties involved.

\*\*Must be in accordance with Gun Control Act of 1968.



M-43866 sse 6/24/80

MAKE ALL REMITTANCES TO BRIDGEPORT, CONN.

# REMINGTON ARMS COMPANY, INC.

Remington. FIREARMS, AMMUNITION, TARGETS, TRAPS, AND POWDER METAL PARTS Remington.  
BRIDGEPORT, CONN.



INVOICE NO.

INVOICE DATE 6/27/80

ORDER NO. M-43866


SHIPPED FROM ILION, NEW YORK

VIA L Best Way UPS INS  
Value: \$500. 6/26/80

CASES WEIGHT  
1 9

SOLD TO

N. L. OLDRIDGE  
REMINGTON ARMS COMPANY, INC.  
8080 WARD PKY. - SUITE #250  
KANSAS CITY, MO 64114

QUANTITY	SUGGESTED RETAIL	UNIT PRICE	TOTAL
1	7mm-08 Cal. Bolt Action Carbine - Serial No. B6226236	MEMO	
	FOR: FIELD TEST		
	TO BE RETURNED		
	Requested by: J.W. Brooks		
	Approved by 		
	W.O. G-0305		

3SE

"THE SELLER WARRANTS THAT, IN THE PRODUCTION OF THE ARTICLES COVERED BY THIS INVOICE, IT HAS COMPLIED WITH ALL THE APPLICABLE PROVISIONS OF THE FAIR LABOR STANDARDS ACT OF 1938 AS AMENDED."

ORIGINAL INVOICE

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER  
KINZER V. REMINGTON

R2528448



PRODUCT CONSIGNMENT TRANSACTION NOTICE

DATE 6/6/80 REQUESTED BY: W. H. Forson, Jr.

TRANSACTION NEW CONSIGNMENT (XX)  
 (CHECK TYPE) RETURN GOODS ( )  
 TRANSFER OR EXCHANGE ( )\*  
 SALE ( )\*\*  
 WRITE-OFF ( )

cc: J. W. Brooks ✓  
 N. L. Oldridge

APPROVALS:

REGIONAL MANAGER \_\_\_\_\_

AREA MANAGER \_\_\_\_\_

PRODUCT MANAGER \_\_\_\_\_

DIR. OF SALES \_\_\_\_\_

*Paul Holabz 6/13*

ACCOUNT TO BE CHARGED:

NAME N. L. Oldridge/Rem. Arms

STREET 8080 Ward Pkwy.-Suite #250

CITY Kansas City, STATE MO 64114

ACCOUNT TO BE CREDITED:

NAME \_\_\_\_\_

STREET \_\_\_\_\_

CITY \_\_\_\_\_ STATE \_\_\_\_\_

SOLD TO CONSUMER ☐

SOLD TO DEALER ☐

SALES TAX APPLICABLE ☐

SALES TAX NOT APPLICABLE ☐

FIREARMS PRODUCT IDENTIFICATION

BILLING INSTRUCTIONS FOR CONSIGNMENT SALES

QUAN.	ORDER NO.	MODEL	GRADE	GA OR CAL	BBL LGTH	CHOKE	TYPE	SERIAL NO.	PRODUCT VALUE	U.S. EXCISE TAX	CITY SALES TAX	STATE SALES TAX	TOTAL BILLING
1		BAC		7mm-	08		SV	26226236					
OTHER PRODUCT IDENTIFICATION													
QUAN.	ORDER AND/OR PART NO.				DESCRIPTION								

REMARKS REFER ORDER TO JOHN BROOKS

NOMINAL VALUE WRITE DOWN APPROVALS

ACCOUNT TO BE CHARGED FOR WRITE DOWN AMOUNTS:

\*Requires signatures of parties involved.

\*\*Must be in accordance with Gun Control Act of 1968.



M-43867 sse 6/24/80

MAKE ALL REMITTANCES TO BRIDGEPORT, CONN.

# REMINGTON ARMS COMPANY, INC.

Remington. FIREARMS, AMMUNITION, TARGETS, TRAPS, AND POWDER METAL PARTS  
BRIDGEPORT, CONN.

Remington.



INVOICE NO.

INVOICE DATE 6/27/80

ORDER NO. M-43867

SHIPPED FROM ILION, NEW YORK

VIA Best Way UPS INS

Value: \$500. 6/26/80

CASES

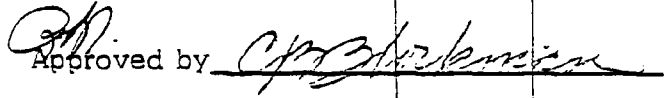
WEIGHT

1

9

SOLD TO

K. N. WAITE  
REMINGTON ARMS COMPANY, INC.  
20 TOWER LA. - AVON PARK SOUTH  
AVON, CT 06001

QUANTITY	SUGGESTED RETAIL	UNIT PRICE	TOTAL
1	7mm-08 Cal. Bolt Action Carbine - Serial No. B6226270	MEMO	
	FOR: FIELD TEST		
	TO BE RETURNED		
	Requested by: J. W. Brooks		
	Approved by 		
	W.O. G-0305		

"THE SELLER WARRANTS THAT, IN THE PRODUCTION OF THE ARTICLES COVERED BY THIS INVOICE, IT HAS COMPLIED WITH ALL THE APPLICABLE PROVISIONS OF THE FAIR LABOR STANDARDS ACT OF 1938 AS AMENDED."

ORIGINAL INVOICE

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER  
KINZER V. REMINGTON

R2528450



PRODUCT CONSIGNMENT TRANSACTION NOTICE

DATE 6/6/80 REQUESTED BY: W. H. Forson, Jr.

TRANSACTION NEW CONSIGNMENT (XX)  
(CHECK TYPE) RETURN GOODS ( )  
TRANSFER OR EXCHANGE ( )\*  
SALE ( )\*\*  
WRITE-OFF ( )

cc: J. W. Brooks ✓  
K. N. Waite

APPROVALS:

REGIONAL MANAGER \_\_\_\_\_

AREA MANAGER \_\_\_\_\_

PRODUCT MANAGER *Paul H. Hickey 6/13*

DIR. OF SALES \_\_\_\_\_

ACCOUNT TO BE CHARGED:

NAME K. N. Waite/Rem. Arms

STREET 20 Tower La. - Avon Park South

CITY Avon, STATE CT 06001

ACCOUNT TO BE CREDITED:

NAME \_\_\_\_\_

STREET \_\_\_\_\_

CITY \_\_\_\_\_ STATE \_\_\_\_\_

SOLD TO CONSUMER ☐

SOLD TO DEALER ☐

SALES TAX APPLICABLE ☐

SALES TAX NOT APPLICABLE ☐

FIREARMS PRODUCT IDENTIFICATION

BILLING INSTRUCTIONS FOR CONSIGNMENT SALES

QUAN.	ORDER NO.	MODEL	GRADE	GA OR CAL	BBL LGTH	CHOKE	TYPE	SERIAL NO.	PRODUCT VALUE	U.S. EXCISE TAX	CITY SALES TAX	STATE SALES TAX	TOTAL BILLING
1		BAC		7mm-08			SV	862262 70					
OTHER PRODUCT IDENTIFICATION													
QUAN.	ORDER AND/OR PART NO.				DESCRIPTION								

REMARKS REFER ORDER TO JOHN BROOKS

NOMINAL VALUE WRITE DOWN APPROVALS

ACCOUNT TO BE CHARGED FOR WRITE DOWN AMOUNTS:

\*Requires signatures of parties involved. \*\*Must be in accordance with Gun Control Act of 1968.



sse 6/24/80

M-43868

MAKE ALL REMITTANCES TO BRIDGEPORT, CONN.

# REMINGTON ARMS COMPANY, INC.

Remington.

FIREARMS, AMMUNITION, TARGETS, TRAPS, AND POWDER METAL PARTS  
BRIDGEPORT, CONN.

Remington.



INVOICE NO.

INVOICE DATE 6/27/80

ORDER NO.

M-43868

SHIPPED FROM ILION, NEW YORK

VIA Best Way UPS INS

Value: \$500. 6/26/80

CASES

WEIGHT

1

9

SOLD TO

W. L. FLINN  
REMINGTON ARMS COMPANY, INC.  
303 FRIENDLY CTR. OFC. BLDG.  
600 GREEN VALLEY RD.  
GREENSBORO, NC 27408

QUANTITY	SUGGESTED RETAIL	UNIT PRICE	TOTAL
1	7mm-08 Cal. Bolt Action Carbine- Serial No. B6226249	MEMO	
	FOR: FIELD TEST		
	TO BE RETURNED		
	Requested by: J.W. Brooks		
	Approved by <u>C. P. [Signature]</u>		
	W.O. G-0305		

se

"THE SELLER WARRANTS THAT, IN THE PRODUCTION OF THE ARTICLES COVERED BY THIS INVOICE, IT HAS COMPLIED WITH ALL THE APPLICABLE PROVISIONS OF THE FAIR LABOR STANDARDS ACT OF 1938 AS AMENDED."

ORIGINAL INVOICE



PRODUCT CONSIGNMENT TRANSACTION NOTICE

DATE 6/6/80 REQUESTED BY: W. H. Forson, Jr.

TRANSACTION NEW CONSIGNMENT (XX)  
(CHECK TYPE) RETURN GOODS ( )  
TRANSFER OR EXCHANGE ( )\*  
SALE ( )\*\*  
WRITE-OFF ( )

cc: J. W. Brooks ✓  
W. L. Flinn

APPROVALS:

REGIONAL MANAGER \_\_\_\_\_

AREA MANAGER \_\_\_\_\_

PRODUCT MANAGER \_\_\_\_\_

DIR. OF SALES \_\_\_\_\_

*Paul H. Haly 6/12*

ACCOUNT TO BE CHARGED:

NAME W. L. Flinn/Rem. Arms  
STREET 303 Friendly Ctr. Ofc. Bldg.  
600 Green Valley Rd.  
CITY Greensboro, STATE NC 27408

ACCOUNT TO BE CREDITED:

NAME \_\_\_\_\_  
STREET \_\_\_\_\_  
CITY \_\_\_\_\_ STATE \_\_\_\_\_

SOLD TO CONSUMER ☐

SOLD TO DEALER ☐

SALES TAX APPLICABLE ☐

SALES TAX NOT APPLICABLE ☐

FIREARMS PRODUCT IDENTIFICATION

BILLING INSTRUCTIONS FOR CONSIGNMENT SALES

QUAN.	ORDER NO.	MODEL	GRADE	GA OR CAL	BBL LGTH	CHOKE	TYPE	SERIAL NO.	PRODUCT VALUE	U.S. EXCISE TAX	CITY SALES TAX	STATE SALES TAX	TOTAL BILLING
1		BAC		7mm-08			SL	86226249					
OTHER PRODUCT IDENTIFICATION													
QUAN.	ORDER AND/OR PART NO.				DESCRIPTION								

REMARKS REFER ORDER TO JOHN BROOKS

NOMINAL VALUE WRITE DOWN APPROVALS

ACCOUNT TO BE CHARGED FOR WRITE DOWN AMOUNTS:

\*Requires signatures of parties involved.

\*\*Must be in accordance with Gun Control Act of 1968.



M-43869 sse 6/24/80

MAKE ALL REMITTANCES TO BRIDGEPORT, CONN.

# REMINGTON ARMS COMPANY, INC.

Remington. FIREARMS, AMMUNITION, TARGETS, TRAPS, AND POWDER METAL PARTS  
BRIDGEPORT, CONN.

Remington.



INVOICE NO.

INVOICE DATE

ORDER NO. M-43869

SHIPPED FROM ILION, NEW YORK

VIA Best Way UPS INS 6/26/80  
Value: \$500.

CASES

WEIGHT

1

9

SOLD TO

A. W. WHEATON  
REMINGTON ARMS COMPANY, INC.  
4510 W. 77th ST., - SUITE 227  
EDINA, MINN. 55435

QUANTITY	SUGGESTED RETAIL	UNIT PRICE	TOTAL
1	7mm-08 Cal. Bolt Action Carbine - Serial No. B6226253	MEMO	
	FOR: FIELD TEST		
	TO BE RETURNED		
	Requested by: J.W. Brooks		
	Approved by <i>[Signature]</i>		
	W.O. G-0305		

"THE SELLER WARRANTS THAT, IN THE PRODUCTION OF THE ARTICLES COVERED BY THIS INVOICE, IT HAS COMPLIED WITH ALL THE APPLICABLE PROVISIONS OF THE FAIR LABOR STANDARDS ACT OF 1938 AS AMENDED."

ORIGINAL INVOICE

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER  
KINZER V. REMINGTON

R2528454



PRODUCT CONSIGNMENT TRANSACTION NOTICE

DATE 6/6/80 REQUESTED BY: W. H. Forson, Jr.

TRANSACTION NEW CONSIGNMENT (XX)  
(CHECK TYPE) RETURN GOODS ( )  
TRANSFER OR EXCHANGE ( )\*  
SALE ( )\*\*  
WRITE-OFF ( )

cc: J. W. Brooks✓  
A. W. Wheaton

APPROVALS:

REGIONAL MANAGER \_\_\_\_\_

AREA MANAGER \_\_\_\_\_

PRODUCT MANAGER Paul H. Hickey 6/13

DIR. OF SALES \_\_\_\_\_

ACCOUNT TO BE CHARGED:

NAME A. W. Wheaton/Rem. Arms

STREET 4510 W. 77th St., - Suite 227

CITY Edina, STATE Minn. 55435

ACCOUNT TO BE CREDITED:

NAME \_\_\_\_\_

STREET \_\_\_\_\_

CITY \_\_\_\_\_ STATE \_\_\_\_\_

SOLD TO CONSUMER ☐

SOLD TO DEALER ☐

SALES TAX APPLICABLE ☐

SALES TAX NOT APPLICABLE ☐

FIREARMS PRODUCT IDENTIFICATION

BILLING INSTRUCTIONS FOR CONSIGNMENT SALES

QUAN.	ORDER NO.	MODEL	GRADE	GA OR CAL	BBL LGTH	CHOKE	TYPE	SERIAL NO.	PRODUCT VALUE	U.S. EXCISE TAX	CITY SALES TAX	STATE SALES TAX	TOTAL BILLING
1		BAC		7mm-08			SL	86226253					
OTHER PRODUCT IDENTIFICATION													
QUAN.	ORDER AND/OR PART NO.				DESCRIPTION								

REMARKS REFER ORDER TO JOHN BROOKS

NOMINAL VALUE WRITE DOWN APPROVALS

ACCOUNT TO BE CHARGED FOR WRITE DOWN AMOUNTS:

\*Requires signatures of parties involved.

\*\*Must be in accordance with Gun Control Act of 1968.



M-43870 sse 6/24/80

MAKE ALL REMITTANCES TO BRIDGEPORT, CONN.

# REMINGTON ARMS COMPANY, INC.

Remington.

FIREARMS, AMMUNITION, TARGETS, TRAPS, AND POWDER METAL PARTS  
BRIDGEPORT, CONN.

Remington.



INVOICE NO.

INVOICE DATE 6/27/80

ORDER NO. M-43870

SHIPPED FROM: ILION, NEW YORK

VIA Best Way UPS INS  
Value: \$500. 6/26/80

CASES

WEIGHT

1

9

QUANTITY

SUGGESTED RETAIL

UNIT PRICE

TOTAL

1

7mm-08 Cal. Bolt Action Carbine - Serial No. B6226273

MEMO

FOR: FIELD TEST

TO BE RETURNED

Requested by: J.W. Brooks

Approved by

W.O. G-0305

sse

"THE SELLER WARRANTS THAT, IN THE PRODUCTION OF THE ARTICLES COVERED BY THIS INVOICE, IT HAS COMPLIED WITH  
ALL THE APPLICABLE PROVISIONS OF THE FAIR LABOR STANDARDS ACT OF 1938 AS AMENDED."

ORIGINAL INVOICE

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER  
KINZER V. REMINGTON

R2528456



PRODUCT CONSIGNMENT TRANSACTION NOTICE

APPROVALS:

REGIONAL MANAGER \_\_\_\_\_

AREA MANAGER \_\_\_\_\_

PRODUCT MANAGER *W. H. Forson 6/13*

DIR. OF SALES \_\_\_\_\_

DATE 6/6/80 REQUESTED BY: W. H. Forson, Jr.

TRANSACTION NEW CONSIGNMENT (XX)  
(CHECK TYPE) RETURN GOODS ( )  
TRANSFER OR EXCHANGE ( )\*  
SALE ( )\*\*  
WRITE-OFF ( )

cc: J. W. Brooks ✓  
D. Godfrey

ACCOUNT TO BE CHARGED:

NAME D. Godfrey/Rem. Arms

STREET 313 Meadows Bldg.

CITY Dallas, STATE TX 75206

ACCOUNT TO BE CREDITED:

NAME \_\_\_\_\_

STREET \_\_\_\_\_

CITY \_\_\_\_\_ STATE \_\_\_\_\_

SOLD TO CONSUMER ☐

SOLD TO DEALER ☐

SALES TAX APPLICABLE ☐

SALES TAX NOT APPLICABLE ☐

FIREARMS PRODUCT IDENTIFICATION

BILLING INSTRUCTIONS FOR CONSIGNMENT SALES

QUAN.	ORDER NO.	MODEL	GRADE	GA OR CAL	BBL LGTH	CHOKE	TYPE	SERIAL NO.	PRODUCT VALUE	U.S. EXCISE TAX	CITY SALES TAX	STATE SALES TAX	TOTAL BILLING
1		BAC		7mm-08			RK	86226273					
OTHER PRODUCT IDENTIFICATION													
QUAN.	ORDER AND/OR PART NO.				DESCRIPTION								

REMARKS REFER ORDER TO JOHN BROOKS

NOMINAL VALUE WRITE DOWN APPROVALS

ACCOUNT TO BE CHARGED FOR WRITE DOWN AMOUNTS:

\*Requires signatures of parties involved.

\*\*Must be in accordance with Gun Control Act of 1968.



M-43871 sse 6/24/80

MAKE ALL REMITTANCES TO BRIDGEPORT, CONN.

# REMINGTON ARMS COMPANY, INC.

Remington. FIREARMS, AMMUNITION, TARGETS, TRAPS, AND POWDER METAL PARTS  
BRIDGEPORT, CONN.

Remington.



INVOICE NO.

INVOICE DATE 6/27/80

ORDER NO. M-43871

SOLD TO

W.B. COCKMAN  
REMINGTON ARMS COMPANY, INC.  
1410 WALKER BANK BLDG.  
SALT LAKE CITY, UTAH 84111

SHIPPED FROM: ILION, NEW YORK

VIA Best Way UPS INS  
Value: \$500. 6/26/80

CASES WEIGHT

1

QUANTITY	SUGGESTED RETAIL	UNIT PRICE	TOTAL
← 1	7mm-08 Cal. Bolt Action Cartine - Serial No. B6226275	MEMO	←
	FOR: FIELD TEST		
	TO BE RETURNED		
	Requested by: J.W. Brooks		
	Approved by: <u>W.B. Cockman</u>		
←	W.O. G-0305		

3se

"THE SELLER WARRANTS THAT, IN THE PRODUCTION OF THE ARTICLES COVERED BY THIS INVOICE, IT HAS COMPLIED WITH ALL THE APPLICABLE PROVISIONS OF THE FAIR LABOR STANDARDS ACT OF 1938 AS AMENDED."

ORIGINAL INVOICE



PRODUCT CONSIGNMENT TRANSACTION NOTICE

DATE 6/6/80 REQUESTED BY: W. H. Forson, Jr.

TRANSACTION NEW CONSIGNMENT (XX)  
 (CHECK TYPE) RETURN GOODS ( )  
 TRANSFER OR EXCHANGE ( )\*  
 SALE ( )\*\*  
 WRITE-OFF ( )

cc: J. W. Brooks✓  
 W. B. Cockman

APPROVALS:

REGIONAL MANAGER \_\_\_\_\_

AREA MANAGER \_\_\_\_\_

PRODUCT MANAGER W. B. Cockman 6/13

DIR. OF SALES \_\_\_\_\_

ACCOUNT TO BE CHARGED:

NAME W. B. Cockman/Rem. Arms

STREET 1410 Walker Bank Bldg.

CITY Salt Lake City STATE Utah 84111

ACCOUNT TO BE CREDITED:

NAME \_\_\_\_\_

STREET \_\_\_\_\_

CITY \_\_\_\_\_ STATE \_\_\_\_\_

SOLD TO CONSUMER ☐ SOLD TO DEALER ☐ SALES TAX APPLICABLE ☐ SALES TAX NOT APPLICABLE ☐

FIREARMS PRODUCT IDENTIFICATION

BILLING INSTRUCTIONS FOR CONSIGNMENT SALES

QUAN.	ORDER NO.	MODEL	GRADE	GA OR CAL	BBL LGTH	CHOKE	TYPE	SERIAL NO.	PRODUCT VALUE	U.S. EXCISE TAX	CITY SALES TAX	STATE SALES TAX	TOTAL BILLING
1		BAC		7mm-08			RK	86226275					
OTHER PRODUCT IDENTIFICATION													
QUAN.	ORDER AND/OR PART NO.				DESCRIPTION								

REMARKS REFER ORDER TO JOHN BROOKS

NOMINAL VALUE WRITE DOWN APPROVALS

ACCOUNT TO BE CHARGED FOR WRITE DOWN AMOUNTS:

\*Requires signatures of parties involved. \*\*Must be in accordance with Gun Control Act of 1968.



**REMINGTON ARMS COMPANY, INC.**

INTER-DEPARTMENTAL CORRESPONDENCE

*Remington*

cc: J. Carter ✓  
W. H. Forson  
J. E. Preiser  
W. J. Thresher, Sr.  
File

*Copies to Mike, Bennet, Bob Smith, Fred Hall, Dennis Smith,  
Eddie Fletcher, R L Hall*

*10-16-79*

October 12, 1979

TO: D. C. BROOKS  
FROM: D. E. MC WHIRT *DEM*  
SUBJECT: BARRELED ACTIONS

This is to reverse my letter of October 9th on this subject.

We will not establish or process through the Finished Goods Warehouse Ledger barreled actions. Sales of barreled actions will continue to be handled as a part sale.

Sales Accounting Section

DEM/cm



## REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE



cc: J. Carter ✓  
 W. H. Forsom  
 J. E. Preiser  
 W. J. Thresher, Sr.  
 File

*Copies Mike, Bernie, Bob Smith, Frank Hart, Dennis Smith  
 Eula Fletcher, R.L. Hall  
 10-12-79*

October 9, 1979

TO: D. C. BROOKS  
 FROM: D. E. MC WHIRT *[Signature]*  
 SUBJECT: BARRELED ACTIONS

In response to your question on the above, it has been reviewed and decided to establish Ramac numbers for these items.

Previous handling had been through part sales, but because of Federal firearms serial number records, we have decided these items should be handled in the same manner as complete guns.

The Ramac numbers assigned for the three specifications presently on order by GmbH are:

600	243	#26155
600	308	#26157
600	222	#26151

Sales Accounting Section

DEM/cm



DON'T SAY IT — WRITE IT

cc: J. H. Carter D. T. Brien  
B. H. GilbertTo D. J. Anderson  
From M. J. KentesDate 11/15/78

Re: M/600 Stock Blank # 2070

Based on our current inventory, all future orders for the above stock blank should be cancelled, due to the possibility of this model being discontinued.

Inventory 11/10/78	Expected deliveries for
Blanks 1850	which we are committed
In process 7687	5300 Blanks,
<u>9537</u>	

SAFETY IS A WISE INVESTMENT



**REMINGTON ARMS COMPANY, INC.**

INTER-DEPARTMENTAL CORRESPONDENCE

cc: W. H. Forson, Jr.



*Copies to Mike H. Barnil*

*8-15-78*

August 1, 1978

TO: J. H. CARTER

FROM: H. D. ALBAUGH

MOHAWK 600 FACT TAGS

A recent customer complaint has brought to my attention the fact that we are continuing to use a fact tag for the above gun in which we state the stock is of American walnut. As you recall, today's Mohawk 600 stock is produced of other than walnut wood. Certainly we will take steps to correct the fact tags, however, we should discontinue the use of the present tags at once. I am not sure about the guns in the warehouse, but I will talk to you about them on your return.

HDA/ap

A handwritten signature in dark ink, appearing to read "H. D. Albough", written over the typed name.



## REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE

*Remington*

OUTPRINT

cc: T. Rawson  
D. Ryan  
P. Rosendahl  
H. Albaugh  
R. Van Duzer  
B. Smith

cc: Harvey Boyle  
Homer Hardin  
Bob Smith

11-15-77

Bridgeport, Connecticut  
November 14, 1977

TO : JACK CARTER  
FROM : PASTOR VELASCO  
SUBJECT: M/600's RETURNED FROM AUSTRALIA FOR MODIFICATION

I refer to the 850 rifles, model 600, returned by BOUSTED PTY., LTD. in Australia to go through the modification of the trigger mechanism as they were rejected by the Commonwealth.

As you recall, we sent them samples of each caliber, which were inspected and passed the required tests. Therefore, we have been instructed by BOUSTEAD PTY., LTD. to have the balance of 847 rifles modified and returned as soon as possible.

Your cooperation will be very much appreciated.

PV/ca  
Encl.

*PV*  
PASTOR

*Forwarded guns to Bridgeport on Rem truck 1-13-78*



.....

1936 EST+

REMARKS STRD

BOUWOOD AA22657

VELASCO/LEVINSOHN

MOHAWK 600 SAMPLES HAVE PASSED COMMONWEALTH TESTING REQUIREMENTS  
AND GUNS MAY BE RETURNED AT YOUR EARLIEST CONVENIENCE. REGARDS.

\*

REMARKS STRD

RECEIVED

NOV 11 1977

PASTOR VELASCO



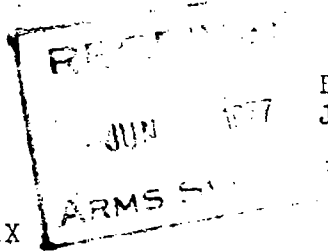
## REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE



cc: A. Farrington  
J. Fenton  
R. Moore  
P. Rosendahl  
R. Ryan  
D. Sawyer  
R. Van Duzer

Ship by 12-16-77



Bridgeport, Connecticut  
June 7, 1977

TO : HORACE HENDRIX

FROM : PASTOR VELASCO

SUBJECT: RETURN OF 350 GUNS FROM AUSTRALIA

To Ship

As you are aware, and upon management's approval, Australia has been given authorization to return the following items:-

199	200	200 Index	6156,	model	600,	caliber	.308
499	500	"	6150,	"	600,	caliber	.222
145	146	"	6154,	"	600,	caliber	.243

These items were shipped back to the United States on the vessel "AUSTRAL ENDURANCE" with an estimated time of arrival in New York of June 25th.

In order to avoid any confusion, or mishandling of this return, we will repair these guns as soon as possible and upon completion of all the 850 guns, they will be returned back to Australia. Most important, and this is mandatory, no change of serial numbers, or caliber will be accepted as these guns are already registered in Australia and they will not accept any deviation from the original information.

Your cooperation is requested inasmuch as we don't want to face the same mess that we had with the 3200 return of last year. If you have any question in this matter I ask that you refer it to my personal attention and once again, no credit is to be issued to Boustead Pty. Ltd.'s account and no return goods is to be sent for processing through the stock and order.

Thank you for your cooperation.

PV/ca

4 (6154) MISSING 6367325  
6363781  
6363676  
6340352



*copies Ken. M. H. Barnes*

*11-17-79*

XC: H. K. Boyle  
J. H. Carter  
P. G. Johnson  
J. P. Linde

11/15/77

RE: M/600 FIRE CONTROL

A meeting was held on Tuesday, 11/15/77, to review the new M/600 Fire Control. The following were in attendance.

E. Barnes  
S. Bennett  
J. Bower  
G. Hill

J. Hutton  
C. Prosser  
J. Snedeker  
J. Willoughby

60 of the new fire controls have been assembled and gallery tested. No gallery rejects were attributed to the new Fire Control. However, several observations were made during the assembly of the Fire Control:

1. Safety binds on Housing - This is caused by a worn vendors N. P. Process punch that forms the U-shaped section of the Safety arm. The vendor will correct. Temporarily, the Housing will be chamfered to provide clearance.
2. Safety binds on Stock -
  - a) Sidewise - caused by the Safety arm being fabricated N. P. Process at the wrong angle. The vendor has corrected.
  - b) Rearward - There appears to be an insufficient amount R & D of clearance rearward. R & D is reviewing the model drawings.
3. Housing interferes with Reinforcing Screw in Stock - The Chem & Met position of the Reinforcing Screw hole in the Stock is about .075 too far rearward. In order to assemble Housings, the Reinforcing Screw had to be bent.
4. Both ground and unground Sears were used for this test with no discernible difference in Trigger pull. It is therefore recommended that Sears not be ground.
5. A correction is required at the comparator for properly Process Eng. setting Trigger pull weight.

It was the consensus of the committee that the change to this Fire Control should not be implemented until the above deficiencies have been corrected.

*J. W. Bower*  
J. W. Bower  
For the Committee

JWB/hf



**DON'T SAY IT—WRITE IT**

cc: H. Hendrix  
8-15-77

To J. CARTER Location ILION  
From P. J. ROSENDAHL Location \_\_\_\_\_ Phone No. 357  
Subject M/600 RETURN AUSTRALIA Date 7/28/77

Attached are copies of the correspondence related to the return of the M/600 from Australia. Anything you can do to expedite the modification and return to Australia would be appreciated. When the guns are ready, please contact P. Velasco to obtain shipping instructions.

 P.J.R:rr  
Att.

cc: T. W. Rawson  
H. D. Albaugh  
P. Velasco  
E. S. Cipcer

RD 778

**STOP, LOOK, AND LIVE**



cc: H. W. Milliman

R. G. Ryan

## REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE

Remington



June 21, 1977

TO: P. VELASCO  
FROM: P. J. ROSENDAHL  
SUBJECT: MOHAWK 600 RIFLE RETURN - AUSTRALIA

In reference to your letter dated June 7th with instructions on handling of the return, I'm attaching a copy of David Tietjen's letter dated June 9, 1977 whereby they agree to handle the return of the guns in accordance with our proposal dated May 27th.

Would you please note that we must ship back samples of each caliber by air freight as soon as possible so that we can insure that it will pass the customs inspection. This is before we ship back the ocean freight shipment to them.

If there are any difficulties on this, please let me know.

*P.J. Rosen Dahl*  
P.J.R. as  
Attach.



## REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE



cc: A. Farrington  
J. Fenton  
R. Moore  
P. Rosendahl  
R. Ryan  
D. Sawyer  
R. Van Duzer

JUN 8 1977  
P.J. ROSENDAHL

Bridgeport, Connecticut  
June 7, 1977

TO : HORACE HENDRIX  
FROM : PASTOR VELASCO  
SUBJECT: RETURN OF 850 GUNS FROM AUSTRALIA

As you are aware, and upon management's approval, Australia has been given authorization to return the following items:-

- 200 Index 6156, model 600, caliber .308  
- 500 " 6150, " 600, caliber .222  
- 150 " 6154, " 600, caliber .243

These items were shipped back to the United States on the vessel "AUSTRAL ENDURANCE" with an estimated time of arrival in New York of June 25th.

In order to avoid any confusion, or mishandling of this return, we will repair these guns as soon as possible and upon completion of all the 850 guns, they will be returned back to Australia. Most important, and this is mandatory, no change of serial numbers, or caliber will be accepted as these guns are already registered in Australia and they will not accept any deviation from the original information.

Your cooperation is requested inasmuch as we don't want to face the same mess that we had with the 3200 return of last year. If you have any question in this matter I ask that you refer it to my personal attention and once again, no credit is to be issued to Boustead Pty. Ltd.'s account and no return goods is to be sent for processing through the stock and order.

Thank you for your cooperation.

PV/ca



## REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE

Remington

RECEIVED

cc: A. Farrington  
J. Fenton  
R. Moore  
P. Rosendahl  
R. Ryan  
D. Sawyer  
R. Van Duzer

6/16/77

Called Pastor - He will hold a meeting  
Monday 6-20-77 and resolve whether  
the same guns are to be returned to Australia  
Will be returned some guns  
ship late Oct

RECEIVED

JUN 8 1977

ARMS SECTION

Bridgeport, Connecticut  
June 7, 1977

cc: J. Ayers 6-14-77

TO : HORACE HENDRIX  
FROM : PASTOR VELASCO  
SUBJECT: RETURN OF 850 GUNS FROM AUSTRALIA

As you are aware, and upon management's approval, Australia has been given authorization to return the following items:-

200	Index	6156,	model	600,	caliber	.308
500	"	6150,	"	600,	caliber	.222
150	"	6154,	"	600,	caliber	.243

These items were shipped back to the United States on the vessel "AUSTRAL ENDURANCE" with an estimated time of arrival in New York of June 25th.

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Thank you for your cooperation.

PV/ca



## REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE

Remington

CLEAR

cc:

R. A. Van Duzer  
H. W. Milliman  
P. A. Davis  
File  
BOB SMITH

RETURN GOODS REQ. NO. 228 REQ. NO. DATE 3/31/77

TO: H. Hendrix - Ilion  
~~XXXXXXXXXXXXXXX~~

FROM: PASTOR VELASCO - International Sales

SUBJECT: Returned Goods

Our Order No. AX-43060  
AX-43070  
X-1049, 1157, 1196,  
Invoice No. 1226, 1281, 1282

Invoice Date \_\_\_\_\_

Customer Boustead Pty. Ltd.

Address P.O. Box 148

Ermington 2115, Sydney, AUSTRALIA

The following goods will be/have been returned to Bridgeport:

<u>200</u>	<u>M/600 Caliber 308</u>
<u>500</u>	<u>M/600 Caliber 222</u>
<u>300</u>	<u>M/600 Caliber 243</u>

Please return the product to warehouse stock. Charge the freight expenses to 6251-096.

Reason for return:

☐ Goods arrived damaged at destination.

☐ Wrong merchandise shipped.

☐ Other \_\_\_\_\_

Disposition: Return to stock and credit customer's account

Bill:

Please write our  
Req. No. on your  
Receiving Report.



cc: R. Moore  
P. Davis  
P. Velasco

**REMINGTON ARMS COMPANY, INC.**

INTER-DEPARTMENTAL CORRESPONDENCE



June 3, 1977

TO: R. FARRINGTON  
FROM: D. SAWYER  
SUBJECT: MODEL 600 RETURNED FROM AUSTRALIA

Ron, per our conversation, I am attaching a list of serial numbers of the guns that are being returned from Boustead Pty. for modification which should arrive this month.

The guns are to be repaired or modified and the same guns are to be returned to Boustead; handled as customer property.

Pastor Velasco has notified H. Hendricks and Bob Smith of the coming event.

I thought it best to get you involved to keep an eye on the operation to avoid any complications.

*Some guns will not be returned to Australia.  
These 850 guns will be returned to warehouse for domestic sales.*

Thanks,

  
Dave

DCS/is  
Attach.





## Boustead Pty. Limited

LM:RP

1396

2nd May, 1977.

Cnr. Day & Egerton Streets,  
Silverwater, N.S.W.  
Address all mail to:  
P.O. Box 148,  
Ermington 2115  
Cables "Boustead" Sydney  
Telex 22657  
Telephone 648 3922

Remington Arms Co. Inc.,  
939 Barnum Avenue,  
BRIDGEPORT, CONNECTICUT,  
U.S.A.

I, Lyn Mathison, declare that the articles herein specified are, to the best of my knowledge and belief, the growth, produce or manufacture of the United States; that they were exported from the United States, from the port of New York on or about November and December 1976; that they are returned without having been advanced in value or improved in condition by any process of manufacture or other means.

(See details attached). 850 M/600 Rifles @ U.S. \$77.33 each.  
Total Value U.S. \$65,730.50.

Boustead Pty. Ltd.

DATE

SIGNATURE

ADDRESS

CAPACITY

RECEIVED

MAY 10 1977

PASTOR VELASCO



"Malmros Monsoon"C/S 4312/S20.1.1977AX-43070-0120 - 6156150 - 6154Case No. 1      5-6156

6340461

6339827

6339643

6339915

6315476

Case No. 2      5-6156

6339892

6339666

6339628

6339626

6339900

Case No. 3      5-6156

6340489

6339974

6339897

6294986

6340220

Case No. 4      5-6156

6340511

6233793

6339999

6340500

6340197

Case No. 5      5-6154

6367543

6367323

6367163

6315682

6363734

Case No. 6      5-6154

6354858

6354795

6363653

6354434

6363815

Case No. 7      5-6154

6363778

6367363

6367172

6367464

6367446

Case No. 8      5-6154

6367087

6367181

6367309

6354624

6367183

Case No. 9      5-6154

6367098

6367508

6363585

6367114

Case No. 10      5-6154

6363775

6363772

6367230

6367286



AX-43070-01

Case No. 11      5-6154

6367325  
6363781  
6363676  
6340352  
6367530

Case No. 13      5-6154

6367140  
6367544  
6367576  
6367346  
6367145

Case No. 15      5-6154

6354539  
6354837  
6355013  
6354701  
6354603

Case No. 17      5-6154

6354743  
6383816  
6355011  
6363790  
6354987

Case No. 19      5-6154

6367364  
6367078  
6367231  
0367517  
6367447

Case No. 12      5-6154

6354004  
6354041  
6353962  
6354930  
6354793

Case No. 14      5-6154

6363741  
6363628  
6354559  
6354622  
6353897

Case No. 16      5-6154

6363828  
6363819  
6367488  
6363788  
6363577

Case No. 18      5-6154

6363830  
6367074  
6363719  
6363829  
6367498

Case No. 20      5-6154

6363728  
6367137  
6367266  
6367322  
6339874



Case No. 21      5-6154

6340027  
6363636  
6348782  
6353966  
6354995

Case No. 23      5-6154

6363708  
6363554  
6363837  
6363779  
6363683

Case No. 25      5-6154

6367459  
6367148  
6367532  
6367445  
6354978

Case No. 27      5-6154

6367126  
6367127  
6367553  
6367108  
6367438

Case No. 29      5-6154

6354969  
6354964  
6354547  
6354589  
6367572

Case No. 22      5-6154

6354886  
6354610  
6355009  
6354694  
6354512

Case No. 24      5-6154

6363808  
6367345  
6367492  
6367213  
6354422

Case No. 26      5-6154

6339937  
6354754  
6354777  
6354778  
6354821

Case No. 28      5-6154

6363648  
6363699  
6363646  
6363647  
6363557

Case No. 30      5-6154

6348606  
6345943  
6345904  
6354521  
6354975

...4/.



AX-43070-01Case No. 31      5-6154

6354734

6354829

6354580

6355002

6340072

Case No. 33      5-6154

6367085

6367470

6354492

6367462

6363612

Case No. 32      5-6154

6354549

6354450

6354820

6354683

6354523

Case No. 34      5-6154

6354618

6363661

6367303

6354953

6367437

M/600AX-43060-0320-6156130-6150Case No. 1      5-6156

6340477

6339963

6339946

6340501

6339914

Case No. 2      5-6156

6340188

6340507

6339968

6340211

6329755

Case No. 3      5-6156

6340219

6339607

6339912

6340193

6339883

Case No. 4      5-6156

6339876

6339906

6339829

6315836

6339610

Case No. 5      5-6150

6371476

6371553

6372604

6371455

6375710

Case No. 6      5-6150

6375760

6375761

6375837

6375776

6371457



AX-43060-03Case No. 7            5-6150

6371258  
6371245  
6371367  
6375819  
6375703

Case No. 9            5-6150

6371157  
6371453  
6371404  
6371260  
6371333

Case No. 11          5-6150

6371343  
6371435  
6371286  
6371427  
6371497

Case No. 13          5-6150

6375749  
6310314  
6375828  
6375785  
6375756

Case No. 15          5-6150

6371182  
6375676  
6371468  
6371565  
6371495

Case No. 8            5-6150

6375740  
6375729  
6375712  
6375707  
6375809

Case No. 10          5-6150

6375833  
6375834  
6371181  
6375838  
6371382

Case No. 12          5-6150

6375799  
6375673  
6375705  
6375817  
6371595

Case No. 14          5-6150

6375801  
6371418  
6371199  
6371546  
6371275

Case No. 16          5-6150

6375836  
6375822  
6371506  
6371158  
6371580



AX-43060-03

Case No. 17      5-6150

6371383  
6371494  
6371555  
6371531  
6371246

Case No. 19      5-6150

6371454  
6371579  
6371574  
6371485  
1371508

Case No. 21      5-6150

6371169  
6375708  
6375762  
6371573  
6375727

Case No. 23      5-6150

6375795  
6371463  
6371597  
6375737  
6371473

Case No. 25      5-6150

6371569  
6371467  
6375773  
6371602  
6371389

Case No. 18      5-6150

6375340  
6371456  
6371232  
6371217  
6371512

Case No. 20      5-6150

6371179  
6371225  
6371514  
6371314  
6371417

Case No. 22      5-6150

6371200  
6371215  
6371177  
6371373  
6371201

Case No. 24      5-6150

6375717  
6371175  
6371327  
6371293  
6317076

Case No. 26      5-6150

6371588  
6371381  
6371316  
6371561  
6371410

...7/.



AX-43060-03

Case No. 27      5-6150

6371414

6371479

6371587

6371578

6375788

Case No. 29      5-6150

6371598

6371515

6375738

6371577

6371556

Case No. 28      5-6150

6371505

6375745

6371477

6371502

6371581

Case No. 30      5-6150

6371590

6371490

6311407

6371288

6371241



"Colombus Australia"

C/S 4262/S

AX-43060-02

80-6156

20-6150

Case No. 1      5-6156

6371614  
6371652  
6367299  
6371675  
6371662

Case No. 2      5-6156

6367329  
6354816  
6367164  
6367167  
6367538

Case No. 3      5-6156

6367369  
6367316  
6371977  
6367414  
6361612

Case No. 4      5-6156

6339898  
6340459  
6339839  
6340010  
6339665

Case No. 5      5-6156

6340182  
6339909  
6339891  
6339853  
6340524

Case No. 6      5-6156

6371838  
6371670  
6371647  
6371678  
6371632

Case No. 7      5-6156

6367211  
6367332  
6371627  
6371657  
6371720

Case No. 8      5-6156

6367368  
6367482  
6367377  
6367262  
6354037

Case No. 9      5-6156

6367358  
6367403  
6371644  
6371625  
6371695

Case No. 10      5-6156

6340522  
6339849  
6339948  
6340482  
6340195



Case No. 11            5-6156

6340480  
6340465  
6339977  
6316073  
6292191

Case No. 12            5-6156

6339965  
6340473  
6339862  
6339964  
6339866

Case No. 13            5-6156

6329725  
6339929  
6339913  
6332892  
6315763

Case No. 14            5-6156

6340485  
6340218  
6339941  
6340225  
6339978

Case No. 15            5-6156

6340504  
6339917  
6339640  
6333111  
6339833

Case No. 16            5-6156

6333011  
6339870  
6339693  
6339908  
6315498

Case No. 17            5-6150

6361438  
6371511  
6371309  
6371535  
6371191

Case No. 18            5-6150

6371338  
6371160  
6371543  
6371276  
6371219

Case No. 19            5-6150

6371216  
6372197  
6371560  
6371571  
6371500

Case No. 20            5-6150

6375697  
6375835  
6371192  
6371519  
6371600



AX-43060-04100 - 6150Case No. 1      5-6150

6371481

6371267

6371586

6371540

6317018

Case No. 2      5-6150

6371222

6375678

6375803

6310166

6371325

Case No. 3      5-6150

6371307

6371165

6375766

6371372

6371545

Case No. 4      5-6150

6371472

6371486

6371296

6375796

6371518

Case No. 5      5-6150

6371185

6371306

6371282

6371445

6371398

Case No. 6      5-6150

6375681

6375732

6375790

6375811

6375818

Case No. 7      5-6150

6371310

6375725

6371357

6375826

6371279

Case No. 8      5-6150

6371178

6375711

6375700

6371507

6375798

Case No. 9      5-6150

6371229

6375786

6375757

6375690

3675832

Case No. 10      5-6150

6371277

6371204

6371226

6375688

6371194



AX-430 0-0

Case No. 11      5-6150

6375728  
6375734  
6371184  
6375782  
6371403

Case No. 12      5-6150

6371172  
6371504  
6371596  
6371462  
6371365

Case No. 13      5-6150

6371312  
6375683  
6375812  
6371392  
6310164

Case No. 14      5-6150

6371487  
6375829  
6375783  
6375815  
6371170

Case No. 15      5-6150

6371164  
6371461  
6371538  
6371544  
6371188

Case No. 16      5-6150

6375722  
6375743  
6375670  
6371405  
6375672

Case No. 17      5-6150

6371291  
6371202  
6371408  
6371767  
6371554

Case No. 18      5-6150

6371224  
6371496  
6371530  
6375779  
6375765

Case No. 19      5-6150

6375808  
6375781  
6375759  
6375716  
6375763

Case No. 20      5-6150

6375797  
6375696  
6375777  
6375752  
6375719

...3/.



AX-43070-02

250-6150

80-6156

Case No. 1      5-6150

6375827  
6371318  
6371470  
6376789  
6371340

Case No. 2      5-6150

6371212  
6371271  
6371480  
6371551  
6375739

Case No. 3      5-6150

6371384  
6375775  
6375687  
6371399  
6371298

Case No. 4      5-6150

6371488  
6371541  
6371447  
6375824  
6375709

Case No. 5      5-6150

6371332  
6371344  
6371469  
6371503  
6317072

Case No. 6      5-6150

6375823  
6375814  
6375747  
6375769  
6375792

Case No. 7      5-6150

6371159  
6371337  
6371415  
6371240  
6371406

Case No. 8      5-6150

6371567  
6371364  
6371350  
6371227  
6310243

Case No. 9      5-6150

6371330  
6371528  
6371336  
6371190  
6375770

Case No. 10      5-6150

6371421  
6371234  
6371451  
6371440  
6371444



AX-43070-02

Case No. 11      5-6150

6371377  
6371539  
6371483  
6371466  
6371563

Case No. 13      5-6150

6371550  
6371591  
6371193  
6371263  
6371391

Case No. 15      5-6150

6371525  
6371352  
6371478  
6371548  
6371460

Case No. 17      5-6150

6371347  
6371208  
6371416  
6371203  
6371297

Case No. 19      5-6150

6371452  
6371375  
6371167  
6371420  
6371186

Case No. 12      5-6150

6375742  
6371244  
6371195  
6371176  
6371498

Case No. 14      5-6150

6371198  
6371300  
6371360  
6371304  
6371348

Case No. 16      5-6150

6371211  
6371355  
6371363  
6371261  
6371426

Case No. 18      5-6150

6371397  
6371250  
6371183  
6371206  
6371274

Case No. 20      5-6150

6371388  
6371393  
6371339  
6371594  
6371197



AX-43070-02

Case No. 21      5-6150

6371335  
6371605  
6371163  
6371235  
6371305

Case No. 22      5-6150

6371156  
6371492  
6371583  
6371351  
6371532

Case No. 23      5-6150

6371295  
6371294  
6371536  
6371449  
6371575

Case No. 24      5-6150

6371459  
6371322  
6371341  
6371189  
6371174

Case No. 25      5-6150

6371368  
6371207  
6371601  
6371464  
6371433

Case No. 26      5-6150

6371220  
6371180  
6371534  
6371369  
6371425

Case No. 27      5-6150

6306984  
6371589  
6371450  
6371523  
6371437

Case No. 28      5-6150

6371311  
6371568  
6371491  
6371323  
6371520

Case No. 29      5-6150

6371549  
6367353  
6371665  
6371676  
6371672

Case No. 30      5-6150

6371558  
6371603  
6371557  
6371329  
6371173



AX-43070-02

Case No. 31      5-6150

6371361  
6371308  
6371431  
6371315  
6371385

Case No. 33      5-6150

6371441  
6371522  
6371213  
6371419  
6371493

Case No. 35      5-6150

6371370  
6371446  
6371570  
6371559  
6371262

Case No. 37      5-6150

6317029  
6315313  
6315701  
6311421  
6312208

Case No. 39      5-6150

6371326  
6371576  
6371599  
6371171  
6371443

Case No. 32      5-6150

6371547  
6371166  
6371510  
6371537  
6371424

Case No. 34      5-6150

6371221  
6371386  
6371582  
6371423  
6371359

Case No. 36      5-6150

6371324  
6371432  
6371552  
6371524  
6371434

Case No. 38      5-6150

6315634  
6315666  
6310257  
6310306  
6315289

Case No. 40      5-6150

6371474  
6371319  
6371542  
6371566  
6371585



AX-43070-02

Case No. 41      5-6150

6371264  
6371321  
6371527  
6371354  
6371376

Case No. 43      5-6150

6371284  
6371390  
6315928  
6371328  
6371428

Case No. 45      5-6150

6371526  
6371345  
6371529  
6371513  
6371356

Case No. 47      5-6150

6312212  
6314681  
6290487  
6315322  
6311416

Case No. 49      5-6150

6375723  
6375713  
6371489  
6375810  
6371484

Case No. 42      5-6150

6371334  
6371411  
6371387  
6371358  
6300713

Case No. 44      5-6150

6371442  
6371584  
6371394  
6371256  
6371429

Case No. 46      5-6150

6371533  
6371592  
6371228  
6371564  
6371509

Case No. 48      5-6150

6371187  
6317039  
6371379  
6375793  
6375787

Case No. 50      5-6150

6371439  
6375821  
6375677  
6371209  
6375767



AX-43070-02

Case No. 51      5-6150

6371889  
6371891  
6372016  
6372146  
6372161

Case No. 53      5-6150

6371918  
6367341  
6363827  
6371936  
6384474

Case No. 55      5-6156

6354483  
6371680  
6371829  
6372150  
6371618

Case No. 57      5-6156

6371928  
6354392  
6371821  
6372040  
6371986

Case No. 59      5-6156

6371870  
6371858  
6371989  
6371903  
6371650

Case No. 52      5-6156

6375545  
6384465  
6372141  
6371946  
6372123

Case No. 54      5-6156

6372005  
6371292  
6372054  
6374825  
6354448

Case No. 56      5-6156

6372086  
6371807  
6384481  
6371976  
6375577

Case No. 58      5-6156

6371857  
6372009  
6372152  
6372118  
6371907

Case No. 60      5-6156

6371634  
6371913  
6371796  
6371784  
6372140



AX-43070-02

Case No. 61      5-6156

6372000  
6372038  
6372019  
6372089  
6371876

Case No. 62      5-6156

6371878  
6370993  
6371237  
6371107  
6371038

Case No. 63      5-6156

6371727  
6371233  
6371616  
6372112  
6354669

Case No. 64      5-6156

6363586  
6367310  
6367410  
6339532  
6340184

Case No. 65      5-6156

6372156  
6371743  
6371781  
6371751  
6354597

Case No. 66      5-6156

6371851  
6371840  
6372064  
6371969  
6372105



Copies to: H. D. Albaugh - Bridgeport  
R. L. Hall  
J. R. Ayers  
J. H. Carter  
R. W. Farrington, Sr.  
H. K. Boyle  
E. M. Douglass Est. File #3701

## LIMITED DISTRIBUTION

October 27, 1977

E. HOOTON, JR.

M/581 Single Shot Conversion Kit Sold As An Accessory

Reference: Telephone Conversation from H. D. Albaugh  
to E. M. Douglass 10/25/77

For the 1978 Product Line, it is proposed to replace the M/580 Single Shot Rifle, with the M/581 Clip Repeater, utilizing a single shot conversion kit.

H. D. Albaugh has provided a retail price of \$4.00 and has requested 1978 estimated factory costs for the conversion kit as a Part Sales accessory for existing M/581 rifles.

Costs and earnings are as follows:

	<u>M/581 Single Shot Conversion Kit</u>
Retail Price	\$ 4.00
Net Price	2.80
Estimated Factory Cost (including insurance, shipping and handling)	1.05
Factory Margin	\$ 1.75
% of Net Selling	62.5%

*G. E. Fletcher*  
G. E. Fletcher, Superintendent  
INDUSTRIAL ENGINEERING SECTION

by: RWFarringtonJr

RWFjr/mc



*Copies for Ken M/600 - Horace*

*12/19/77*

XC: H. K. Boyle  
J. H. Carter  
J. C. Hutton  
P. G. Johnson  
J. P. Linde  
C. O. Pardee

12/15/77

RE: M/600 FIRE CONTROL

A meeting was held on Wednesday, 12/14/77, to review the progress on the new M/600 Fire Control. The following were in attendance:

S. D. Bennett  
J. W. Bower  
L. B. Ferriera  
B. H. Gilbert

G. J. Hill  
F. E. Martin  
C. F. Prosser  
L. G. Wilke

With reference to the 11/15 meeting, the following progress has been made:

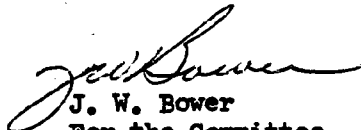
1. Safety binds on Housing - The vendor has repaired his tooling to correct this. In the meantime, an "S" operation has been added to chamfer the Housing. N. P. Process
2. Safety binds on Stock -
  - a. Sidewise - The stamping vendor has corrected his tooling, and good parts are available. N. P. Process
  - b. Rearward - A model drawing transmittal has been made showing changes to both the Stock and Safety. The radius change on the Stock will be implemented with the next production run. The Safety change requires the vendor to change his tooling. In the meantime, a repair operation will be instituted in the wood shop to provide sufficient clearance. Chem & Met  
N. P. Process
3. Housing interferes with Reinforcing Screw in Stock. The Reinforcing Screw hole has been moved forward. Chem & Met
4. The decision has been made to grind Sears, and a model drawing revision is required for Powder Metal to leave a grinding allowance. R & D
5. It is felt that grinding the Sears will correct the heavy Trigger pull. If not, a different comparator setting will be used. Proc. Eng.

The following new items were discussed:

1. Design verification testing should be complete by 12/16. R & D



2. Spare parts requests for Fire Controls, or Fire Control components (except Safeties) will be filled with the new design. Arms Serv.
3. The question of supplying Safeties alone is to be resolved. R & D
4. All future orders for vendor parts will be for new style Housing components. No old style parts will be inputted, unless required by Arms Service. Planning
5. It is expected that new style Housings will be available in Production Assembly by 12/27.

  
J. W. Bower  
For the Committee

JWB/hf



DATES AND REVISIONS FOR REVISIONS 3/26/75 - Retyped from 3/26/7. Added 16a. - Prosser - 273889  
5/9/77 - Add info to element 15 - Joy - 275936

DESCRIPTIVE INFORMATION

15. (cont.) a. Push Safety "ON" back, can't fire with heavy Trigger pressure. Trigger must retract. Push Safety half way off, pull Trigger, must not fire. Push Safety to "OFF" position, Firing Pin must not follow down, Safety must return to off position under tension. (PERFORM CHECK THREE TIMES)
17. Adjust Trigger pull (4 to 6 lbs.) and stake Trigger Adjusting Screws. Trigger Pull Scales - B-70697.
18. Seal all Adjusting Screws with DuPont Cement.
19. Pick correct Magazine Assembly - Inspect for color, no rust.
20. Assemble Magazine Assembly to Receiver with Screw.
21. Assemble Magazine Spring to Magazine Follower and position in Magazine Assembly/

Trigger Pull Scales - B-70697

PART NAME Final Assembly COOLANT SET UP TIME MODEL No. Moh. 600 OPER. No. 175  
TYPE MACH. HRS. DEPT. No. 41 PAGE 3 OF 4  
MACHINE



DATES AND REASONS FOR REVISIONS 3/24/75 - Added Safety check; Items VI-3 thru VI-7, for clarification. Also changed model number to agree with current listing - NWN/GRB - 273871  
9/10/77-Add note to #3 & #7-JCH/bdm-275943

DESCRIPTIVE INFORMATION

VI

Description of Test.

A. Test - (cont'd)

2. Pick up gun and visually inspect for:
  - a. Safety - Inspect chamber and Magazine - both must be empty-
  - b. Caliber - To verify for shooters personal safety in selecting ammunition for test.
  - c. Proof mark on Barrel (REP) - Must be present; right rear side, ahead of magnaflux stamp.
  - d. Proof Mark on Bolt (P) - Prick punch mark must be present at bottom of Bolt Handle.
  - e. Visual Defects - If not within visual Specifications for items a-d, reject gun at this point.
3. With Safe in "OFF" position - close Bolt crisply on empty chamber.
  - a. Firing Pin must not follow down as Bolt cams shut.
  - b. Must not fire on closing.
4. Move safet to "ON" position - Try to raise Bolt.
  - a. Must not raise or open.
5. With Safet still "ON" - pull Trigger firmly.
  - a. Gun must not fire.
6. With finger off Trigger - move safet to "OFF" position.
  - a. Gun must not fire as safe is moved to "OFF" position.
7. With safe in "OFF" position - raise bolt slowly and open to rearward position.
  - a. Gun must not fire as Bolt is raised.
8. With Action open, position gun in device and clamp.
9. Lower line-o-sighter and adjust device to point gun on target paper if necessary.
10. Remove line-o-sighter.
11. Load Magazine to capacity - see table, Item IV-A, for capacity by caliber.
12. Hold cartridges down in Magazine, start Bolt over Cartridge column and close Bolt on empty chamber.

(PERFORM CHECK THREE TIMES)

PART NAME Gallery Test - Target COOLANT SET UP TIME MODEL No. 600 OPER. No. 300  
TYPE Procedure and Specifications MACH. HRS. DEPT. No. 85 PAGE 8 OF 11  
MACHINE



DATES AND REASONS FOR REVISIONS 3/26/75 - Retyped from 7/26 - Added reading - Prosser - 273889  
5/9/77 - Add note to element 9 - Joy - 275936

DESCRIPTIVE INFORMATION

9. Safe, Gun cocked. (PERFORM CHECK THREE TIMES)

Clean sharp single detent.

"On" back, can't fire with heavy Trigger pressure.

Trigger must retract.

Push Safety halfway off, pull Trigger, must not fire. Push Safety to off position, Firing Pin must not follow down, Safety must return to off position under tension.

Bolt Handle must not unlock on safe.

Safety should snap in Detent in both "On" and "Off" position.

Check Trigger Pull - No creep (4 to 6 lbs. on Moh. 600)

10. With Safety "ON" push upward on bottom of Trigger Connector while pulling back on Trigger and releasing. Trigger must retract without catching. Push Safety "OFF". Firing Pin must NOT follow down.

11. Stamp Final Inspection and Code Marks on Left Side of Barrel, Rear sign gun tag.

TO WAREHOUSE

PART NAME Final Assembly COOLANT                      SET UP                      MODEL No. Moh. 600 OPER. No. 310  
TYPE                      MACH. HRS.                      DEPT. No. 55 PAGE 4 OF 4  
MACHINE



5/10/77-add note; perform ok. 3 times #19-JCH/bdm-27591

DATES AND REASONS FOR REVISIONS	
6/1/62 - New Model - NWM/eb	2/9/68 - Item 20b-1- Change Trigger Pull Spec. for M/660 add Item 20b-2 for M/700 SPC/bd
8-26-66 - Revised to include M/600 JAH/cm	2/29/68 - Change Model No. 600 to 660; Revised to include M/660; Retyped; SPC/bd
1-25-67 - Item 20-b-1 was 4 to 6 lbs. - NWM/cm	3/4/70 - Item 20-B-2 - Change Trig. Pull Specs. - M/700 from 6 1/2 to 5 1/2 lbs. - SPC/bd
1/15/68 - Item 20b.-1 was 3 1/2 to 6 lbs. - WAB/NWM/bd	4/5/71 - Item 19-a-1; Change Firing Pin Head protrusion rearward of Bolt Plug. Change Model No. 660 to 600. HKB/bd

DESCRIPTIVE INFORMATION	
19. <u>Safe - Function</u> - Cont'd.	
a. Cont'd.	
1. Firing Pin head must move rearward and protrude approximately 1/16" beyond rear of Bolt Plug.	
b. Move Safe rearward full stroke to "on" position.	
1. Must operate with tension - no excessive bind - must clear stock in all positions.	
2. Must operate with normal finger pressure,	
- with Safe in "on" position.	
c. Pull Trigger with firm pressure.	
1. Gun must not fire with Safe "on".	
2. Trigger movement is acceptable but Trigger must retract.	
d. Test raising Bolt Handle for cooking.	
1. Bolt must be locked in closed position with Safe "on".	
e. Move Safe to forward to "off" position.	
1. Gun must not fire as Safe is moved to "off" position.	
f. Pull Trigger - with Safe "off".	
1. Gun must fire.	
20. <u>Trigger Pull</u> - All Models	
a. Open and close Bolt for cooking.	
- pull Trigger.	
1. Pull must be short and crisp.	
2. Trigger must retract.	
b. With gun cooked.	
- weigh pull three (3) times with spring scale B-70697.	
1. Gun must fire with 3 1/2 to 6 pounds pressure two (2) times out of three (3) - (M/600)	
2. Gun must fire with 3 to 5 1/2 pounds pressure two (2) time out of three (3) - (M/700)	

PART NAME	1. Inspection before	COOLANT	SET UP	MODEL No.	700 - 180X	OPER. No.
TYPE	Quality Audit Gallery Test.		MACH. HRS	DEPT. No.	PAGE	12 of 15
MACHINE						

(PERFORM CHECK THREE TIMES)



<b>DATES AND REASONS FOR REVISIONS</b> 5/10/77-Add note to #19-JCH/bdm-275943			
2/29/68 - Change Model No. 600 to 660 Revised to include M/660; Retyped: SPC/bd		4/5/71 - Change Model No. 660 to 600 - HKB/bd	
4/6/71 - Revised to change 18-a from 3/8" to 1/16"-FBL/bd			
<b>DESCRIPTIVE INFORMATION</b>			
17. <u>Bolt Assembly - Finish &amp; Fit (con't.)</u> M/700 - 660 ADL & BDL			
i. Depress Ejector with hand punch 1. Must depress and retract freely - no bind - with spring tension 2. Must be retained by Ejector Pin			
j. Try Ejector Pin from both sides with 5# pressure - Tester #510-695 1. Must be tight - not shift			
k. Assemble Bolt to gun			
18. <u>Firing Pin - Follow Down - All Models</u>			
a. With safe in "off" position and Firing Pin in fired position - raise Bolt Handle full stroke for cocking 1. Firing Pin Head must move rearward and protrude approximately 1/16" beyond rear of Bolt Plug			
b. Lower Bolt Handle to close 1. Firing Pin Head must not move forward into Bolt Plug			
c. Repeat items a & b three (3) times forcibly 1. Firing Pin Head must not move forward into Bolt Plug			
19. <u>Safe - Function - All Models</u> (PERFORM CHECK THREE TIMES) - with Safe in forward "off" position			
a. Open and close Bolt for cocking - Handle down			
I. <u>Inspection before Quality</u>			
PART NAME <u>Audit Gallery Test</u>	COOLANT _____	SET UP TIME _____	MODEL No. <u>700 = 600</u>
TYPE _____	MACH. HRS. _____	DEPT. No. _____	OPER. No. _____
		MACHINE _____	PAGE <u>11</u> OF <u>16</u>



## PROCESS RECORDS ASSEMBLY SHEETS

9

DATES AND REASONS FOR REVISIONS 3/27/75 - Retyped from 12/26/74 - Prosser - 273888 - Revised  
8/12/75 - Removed 17a chg word. of 19 chg. adjust to weight & removed 20, renumber 21 & 22 - CP - 274202  
10/8/76 - Added info to 18a - Joy - 275300

## DESCRIPTIVE INFORMATION

~~17. Adjust Trigger Stop Screw to reduce overdraw  
Turn Stop Screw in until Action will not fire with Safety  
off. Hold Trigger back and Turn Stop Screw out until Action  
fires. Then slightly more than 1/8 and less than 1/4 Turn more. N  
No detectable rearward Trigger play in excess of a wink after firing.~~

17a. Check notch escape by holding Trigger while closing Bolt slowly. Firing Pin must follow down.

18. Try Safety and Bolt Action. Adjust if necessary.

- a. Push Safety "ON" back, can't fire with heavy Trigger pressure. Trigger must retract. Push Safety halfway off, pull Trigger, must not fire. Push Safety to OFF position, Firing must not follow down, Safety must return to OFF position under tension. Use downward pressure on Safety. Perform check three times.

19. Weight Trigger Pull (3 to 5 lbs.)

- a. Must be short & crisp, no creep or overdraw. Try 3 times.

~~20. Set adjusting screws (1/4) Turn "Down" down.////////~~

20. Pick correct Magazine Box, inspect for color, no rust.

21. Assemble Magazine Box to Action.

## EQUIPMENT - TOOLS &amp; GAGES

NOTE: - Cock Rifle - Hold down hard on Bolt Handle - Must fire when Trigger is pulled.

Trigger Pull scales B-70697

## OPERATION DESCRIPTION

Assemble Action

(700 ADL)

OCC. No.

STD. HRS/C

STD. No.

EFF. DATE

PART No.

GA.

PART NAME Final Assembly

COOLANT

SET UP  
TIME

MODEL No.

700 ADL

OPER. No.

175

TYPE

MACH. HRS.

DEPT. No.

61

PAGE 3

OF 4

MACHINE



10/8/75 - Took out M/700 reference notes and added to item V notes. Retyped from 10/16/67-  
5/10/77-Add note to #3 - #9-JCH/bdm-275943

DESCRIPTIVE INFORMATION

VII. Description of Test.

A. Test.

-Each gun as received, Bolt in open position.

1. The first rifle after test is to be left off truck so that there will be one space between tested guns. and untested guns. Place first gun back on truck after truck load is completed.
2. Pick up gun from truck and inspect for:
  - a. Safety - Inspect chamber and Magazine - both must be empty.
  - b. Caliber - To verify for shooters personal safety in selecting ammunition for test.
  - c. Proof Mark on Barrel (REP) must be present, right rear side of Barrel, ahead of Magnaflux stamp.
  - d. Proof mark on Bolt - (.) Prick punch mark must be present at bottom of Bolt Handle.
  - e. Visual Defects - If not within specifications for items a-d, reject gun at this point.
  - f. Normal Sight alignment - as described in VI-C.
3. With safe in "OFF" position - close Bolt crisply on empty chamber.
  - a. Firing pin must not follow down as Bolt cams shut.
  - b. Must not fire on closing.
4. Move safe to "ON" position and try to raise Bolt
  - a. Must not raise or open - must be locked closed by safety
5. With safe still "ON" - pull Trigger firmly.
  - a. Gun must not fire.
6. With finger off Trigger - move safe to "OFF" position.
7. Open and close Bolt full stroke to cock firing pin
8. Move safe to full rear "ON" position and then move to half way "OFF" position with thumb only, if possible
9. If safety stops at half-way position - pull Trigger.
  - a. Gun must not fire.
  - b. Safety must not move to full "OFF" position.
10. With Action open, position gun in device and clamp.
11. Lower line-o-sights and adjust device to point gun on target paper if necessary.
12. Remove line-o-sighter.
13. Load Magazine to capacity - see table #1 and #2, item IV - for Magazine capacity by caliber.
14. Hold cartridges down in Magazine, start Bolt over Cartridge column and close Bolt on empty chamber.
15. Open Bolt full stroke to rear position.
16. Assemble Firing Pin Trip Pin in device.
17. Close guard.
18. Close Bolt to feed shell into chamber and lock - to start test.
19. Fire gun by pushing (2) two buttons on device simultaneously.

(PERFORM THREE TIMES)

ART NAME Gallery Test - Target COOLANT                      SET UP                      MODEL No. 700 OPER. No. 300  
 TIME                      MACH. HRS.                      DEPT. No. 85 PAGE 91 OF 11  
 TITLE Procedure and Specification



DATES AND REASONS FOR REVISIONS		4/1/68 - Retyped from 3/18/68 - 266283	10/8/76 - Add info to 9 - Joy - 275299
12/23/70 - Added Mohawk 600 - CP - 269276			
3/13/73 - Added element 10, renumbered 11-CP - 271645			
7/26/74 - Remove 660 - CP - 273270			
3/27/75 - Added to #9 - CP - 273888			

DESCRIPTIVE INFORMATION

8. Action:

1. Operate Bolt 3 times and fire, no bind, Bolt Handle raises and lowers easily.
2. Open and close Bolt forcibly 3 times. Trigger must not follow down.
3. Check for jar off by steady pressure on end of Firing Pin head, when rifle is cocked, with Safety in off position (Use end of Hammer Handle)

9. Safe, Gun cocked.

Clean sharp single detent.  
 Try "On" back, can't fire with heavy Trigger pressure.  
 Three Times { Trigger must retract. Push Safety halfway off, pull Trigger, Must not fire. Push Safety to OFF position, Firing Pin must not follow down, Safety must return to OFF position under tension. Use downward pressure on Bolt Handle must not unlock on safe. Safety should snap in Detent in both "On" and "Off" position. Check Trigger Pull - No creep { 4 to 6 lbs. on M/660 } Mohawk 600) { 3 to 5 lbs. on M/700 }  
 Safety.

10. With Safety "ON" push upward on bottom of Trigger Connector while pulling back on Trigger and releasing. Trigger must retract without catching. Push Safety "OFF". Firing Pin must NOT follow down.

11. Stamp Final Inspection and Code Marks on Left Side of Barrel, Rear sign gun tag.

To Warehouse

PART NAME	Final Assembly	COOLANT	SET UP TIME	MODEL NO.	700ADL-700 BDL	OPER. No.	310
TYPE		MACH. HRS	DEPT. No.	55	PAGE	4	OF 4
MACHINE							

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 KINZER V. REMINGTON



5/10/77-Add note to #19-JCH/bdm-275943

2/29/68 - Change Model No. 600 to 660

4/5/71 - Change Model No. 660 to 600 - HKB/bd

Revised to include M/660;

Retyped: SPC/bd

1/6/71 - Revised to change 18-a from 3/8" to 1/16"-FBL/bd

DESCRIPTIVE INFORMATION

17. Bolt Assembly - Finish & Fit (con't.)

M/700 - 660 ADL & BDL

i. Depress Ejector with hand punch

1. Must depress and retract freely - no bind - with spring tension
2. Must be retained by Ejector Pin

j. Try Ejector Pin from both sides with 5# pressure - Tester #510-695

1. Must be tight - not shift

k. Assemble Bolt to gun

18. Firing Pin - Follow Down - All Models

a. With safe in "off" position and Firing Pin in fired position - raise Bolt Handle full stroke for cocking

1. Firing Pin Head must move rearward and protrude approximately 1/16" beyond rear of Bolt Plug

b. Lower Bolt Handle to close

1. Firing Pin Head must not move forward into Bolt Plug

c. Repeat items a & b three (3) times forcibly

1. Firing Pin Head must not move forward into Bolt Plug

19. Safe - Function - All Models (PERFORM CHECK THREE TIMES)

- with Safe in forward "off" position

a. Open and close Bolt for cocking - Handle down

I. Inspection before Quality

PART NAME Audit Gallery Test COOLANT \_\_\_\_\_ SET UP TIME \_\_\_\_\_ MODEL No. 700 - 600 OPER. No. \_\_\_\_\_  
TYPE \_\_\_\_\_ MACH. HRS. \_\_\_\_\_ DEPT. No. \_\_\_\_\_ PAGE 11 OF 16  
MACHINE \_\_\_\_\_



5/10/77 add note; perform ck. 3 times #19-JCH/bdm-27594

6

<b>DATES AND REASONS FOR REVISIONS</b> 6/1/62 - New Model - NWM/eb 8-26-66 - Revised to include M/600 JAH/cm 1-25-67 - Item 20-b-1 was 4 to 6 lbs. - MWN/cm 1/15/68 - Item 20b.-1 was 3 1/2 to 6 lbs. - WAB/NWM/bd		2/9/68 - Item 20b-1- Change Trigger Pull Spec. for M/660 add Item 20b-2 for M/700 SPC/bd 2/29/68 - Change Model No. 600 to 660; Revised to include M/660; Retyped; SPC/bd 3/1/70 - Item 20-B-2 - Change Trig. Pull Specs. - M/700 from 6 1/2 to 5 1/2 lbs. - SPC/bd 4/5/71 - Item 19-a-1; Change Firing Pin Head protrusion rearward of Bolt Plug. Change Model No. 660 to 600. HKB/bd	
<b>DESCRIPTIVE INFORMATION</b>			
19. <u>Safe - Function</u> - Cont'd.			
a. Cont'd. 1. Firing Pin head must move rearward and protrude approximately 1/16" beyond rear of Bolt Plug.			
b. Move Safe rearward full stroke to "on" position. 1. Must operate with tension - no excessive bind - must clear stock in all positions. 2. Must operate with normal finger pressure,			
- with Safe in "on" position.			
c. Pull Trigger with firm pressure. 1. Gun must not fire with Safe "on". 2. Trigger movement is acceptable but Trigger must retract.			
d. Test raising Bolt Handle for cocking. 1. Bolt must be locked in closed position with Safe "on".			
e. Move Safe to forward to "off" position. 1. Gun must not fire as Safe is moved to "off" position.			
f. Pull Trigger - with Safe "off". 1. Gun must fire.			
20. <u>Trigger Pull - All Models</u>			
a. Open and close Bolt for cocking, - pull Trigger. 1. Pull must be short and crisp. 2. Trigger must retract,			
b. With gun cocked, - weigh pull three (3) times with spring scale B-70697. 1. Gun must fire with 3 1/2 to 6 pounds pressure two (2) times out of three (3) - (M/600) 2. Gun must fire with 3 to 5 1/2 pounds pressure two (2) time out of three (3) - (M/700)			
PART NAME <u>1. Inspection before</u> COOLANT <u>SET UP</u>		MODEL No. <u>700 - 1800</u> OPER. No. <u>600</u>	
TYPE <u>Quality Audit Gallery Test.</u>		MACH. HRS. <u>        </u> DEPT. No. <u>        </u> PAGE <u>12</u> OF <u>15</u>	
MACHINE <u>        </u>			

(PERFORM CHECK THREE TIMES)



3.

1/19/68 - Retyped from 1/19/68 - 265799

2/21/68 - Add descriptive information - MT - 265932

3/5/75 - Chg. reading on 2A and 3A - CP - 273834

6/28/68 - Added item 7-1 - Tibbitts - 266479

4/15/75 - Added 9-6 & 7 - Prosser - 273940

3/2/71 - Chg. sheet no. - CP - 269506

6/25/75 - Added 8 & 9 - Burns - 274067

7/19/74 - Chg. dept. # - Prosser - 273250

5/9/77 - Add note to element 9 - CP - 275937

## EQUIPMENT-TOOLS & GAGES

- 7 - Assemble Firing Pin Final Assembly to Bolt Assembly and remove Slave Pin.
- 7-1 - Apply Molykote and oil mixture to Bolt Plug threads & Cocking Cam.
- 7A - Air clean Bolt and rear of Receiver.
8. - Insert Bolt Assembly into Action and Lock down.
9. - Check function of Safety.
- 9a - Check Trigger pull. (4 to 6 lbs.)
- 10 - Assemble Magazine Guide Bar to Receiver with Magazine Guide Bar Screw. & Washer.
- 11.- Pick correct Magazine Assembly - Inspect for color. No rust.
- 12.- Assemble Magazine Assembly to Action and try for freeness.
- 14 - Assemble Rib Spacer Rib and Rear Sight Assembly to Barrel with 2 Rear Sight Screws.

9. Check function of Safety (PERFORM CHECK THREE TIMES)

1. Cock Rifle
2. Move Safe to "ON" position.
  - A. No "catch" or Good Detent Lock.
3. Pull Trigger
  - A. No "click" or "catch" in pull possible.
  - B. Trigger must retract when released
4. Move Safe to "OFF" position.
  - A. Action must not fire
5. Pull Trigger.
  - Action must fire.
6. Cock Rifle
7. Move safe to "ON" position, Push forward toward "OFF" position. MUST RETURN to OFF position under tension.
8. Push Safety to ON position.
9. Close Bolt with firm pressure
  - A.) Safety must remain in ON position.

OPERATION DESCRIPTION		OCC. No.					
	STD. HRS/C						
	STD. No.						
	EFF. DATE						
PART No.							
GA.							

Final Assembly

PART NAME

Center Fire

TYPE

COOLANT

SET UP TIME

788

MODEL No.

175

OPER. No.

MACH. HRS

41

DEPT. No.

2

PAGE

2

OF

MACHINE

Bench

**CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER**

R2528506



DATES AND REASONS FOR REVISIONS 11/3/75 - Separated Test and Target operations, removed obsolete calibers (30-30, 44 Rem) and added a new caliber (.223) - Also added item for proper operation of the safety. Also made provision to extract and eject last live round instead of having it fired. NWM/GRB - 274448  
5/10/77-Add note to #3A-JCII/bdm-275943

DESCRIPTIVE INFORMATION

3. Before placing gun into device for test, check for proper operation of the safety.
- a. With safe in "OFF" position - close Bolt crisply on empty chamber.
    - 1. Firing Pin must not follow down as Bolt Cams shut.
    - 2. Must not fire on closing.
  - b. Move safe to "ON" position - pull Trigger firmly.
    - 1. Gun must not fire.
  - c. With finger OFF Trigger, move safe to "OFF" position.
    - 1. Must not fire as safe is moved to "OFF" position.
  - d. Open and close Bolt full stroke to cock Firing Pin.
  - e. Move safe to full rear "ON" position and then move to halfway "OFF" position with thumb only, if possible.
    - 1. Accept if safety moves to "ON" or "OFF" position without hesitation at halfway position.
  - f. If safety stops at half-way position - pull Trigger.
    - 1. Gun must not fire.
    - 2. Safety must not move to full "OFF" position.
    - 3. With Action open - position gun in device and clamp.
    - 4. Close action on empty chamber and move safe to "ON" position.
    - 5. Remove Magazine Box.
    - 6. Load Magazine Box to capacity - See table VII-A.
    - 7. Reassemble Magazine Box into gun - must lock into place with Bolt closed.
    - 8. Protective Guard must be in down position as each round is fired.
    - 9. After Guard has been pulled down into position - Safe "ON" - pull Trigger - Must not fire.
    - 10. Move Safe to "OFF" position.
    - 11. Operate action full cycle to feed live rounds from Magazine into chamber, and to extract and eject fired cases.
    - 12. Extract and Eject last live round and retrieve.
      - a. Must extract and eject live round.
    - 13. Pick up gun from jack saddle - muzzle still in port.
    - 14. Check chamber and Magazine for live ammunition.
      - a. Chamber and Magazine must be empty.
    - 15. Remove gun fully from test jack - stamp acceptable product - place white tag on reject gun. NOTE: Fill out Gallery Report forms with proper information.
    - 16. Return gun to truck.

(PERFORM THREE TIMES)

PART NAME Gallery Test COOLANT SET UP TIME MODEL No. 788 OPER. No. 295  
TYPE Procedure and Specifications MACH. HRS. DEPT. No. 85 PAGE 5 OF 6



Form R. D. 6466



DATES AND REASONS FOR REVISIONS

1-30-67 - New Model - HKB/gm  
5/11/77-Add note-perform ck. 3 times-#19-JCH/bdm-275943

DESCRIPTIVE INFORMATION

19. Safe - Function

- with Safe in forward "off" position.

a. Open and close Bolt for cocking - Handle down.

b. Move Safe rearward full stroke to "on" position.

1. Must operate with tension - no excessive bind - must clear stock in all positions.

2. Must operate with normal finger pressure.

- with Safe in "on" position.

c. Pull Trigger with firm pressure.

1. Gun must not fire with Safe "on".

2. Trigger movement is acceptable but trigger must retract.

d. Test raising Bolt Handle for cocking.

1. Bolt must be locked in closed position with Safe "on".

e. Move Safe to forward to "off" position.

1. Gun must not fire as Safe is moved to "off" position.

f. Pull Trigger - with Safe "off".

g. Push Safety Button forward from "off" position and remove Bolt from rifle.

1. Bolt must remove freely without bind.

- Insert Bolt into rifle

2. Must assemble freely without bind.

20. Trigger Pull

a. Open and close Bolt for cocking.

- pull Trigger.

1. Pull must be short and crisp.

2. Trigger must retract.

PART NAME I. Inspection Before COOLANT SET UP MODEL No. 788 OPER. No.             
TYPE Quality Audit Gallery Test. MACH. HRS.            DEPT. No.            PAGE 2 OF 11  
MACHINE





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KINZER V. REMINGTON

R2528510

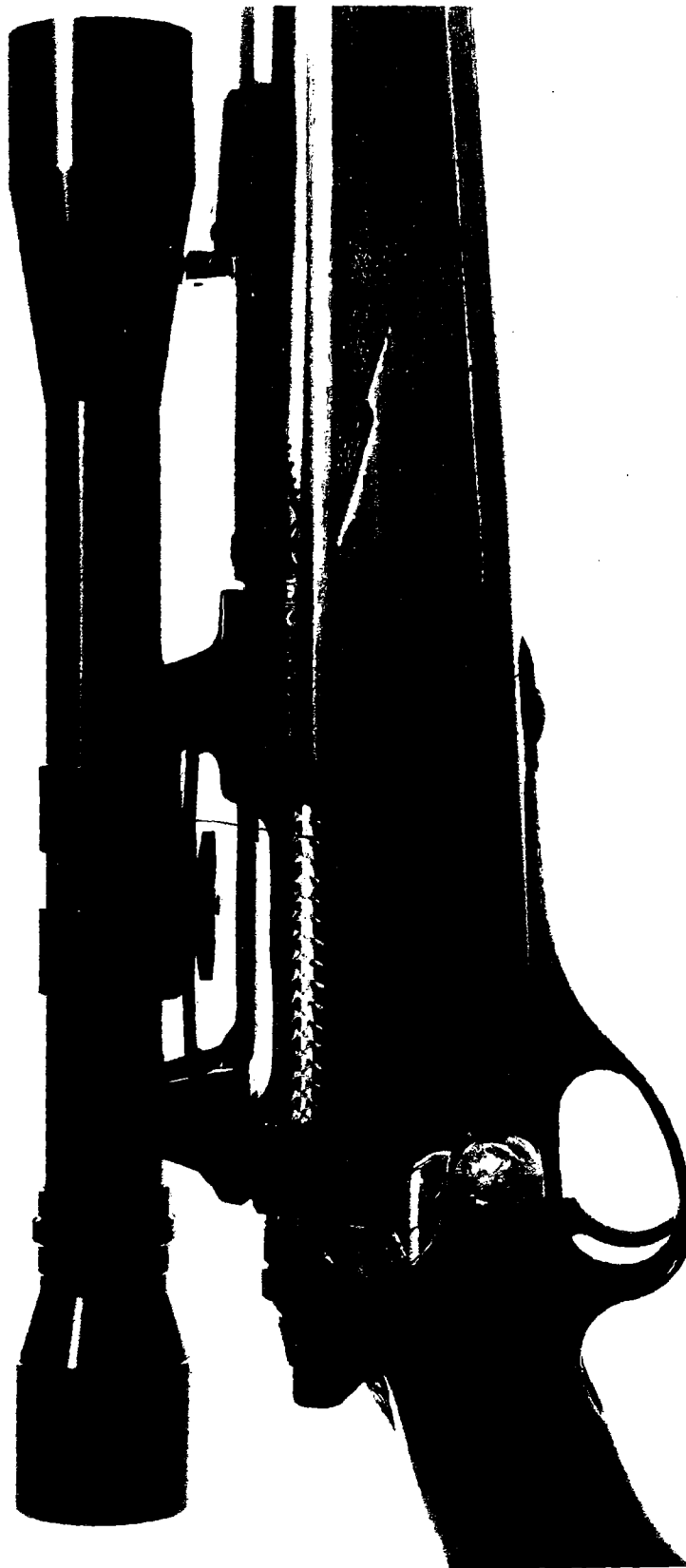


REMINGTON-UMC CO., Inc.  
LION RESEARCH DIVISION



NOTED 11/15/73  
FBI - NEW YORK





CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER  
KINZER V. REMINGTON

R2528513



REMINGTON-UMC, INC.  
HIGH RESEARCH DIVISION

Adolfo Lopez Mateos





CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER  
KINZER V. REMINGTON

R2528515



# REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE



cc: Norman Wilson, Bridgeport  
E. R. Carr  
L. Fox  
F. Plunkett

"CONFINE YOUR LETTER TO ONE SUBJECT ONLY"

Ilion, New York  
June 30, 1972

*copy for* L. J. Boyle  
E. G. Larson  
F. E. Morgan

✓ A. D. KERR

## TRIP TO N.Y.C. POLICE ACADEMY

Arrived at Police Academy at 8:00 A.M. Tuesday, June 27, 1972. Discussed problem with Lt. Francis Magee.

Examined approximately 300 fired cases finding no Remington cases with pierced primers which we consider the underlying cause of the breaking of Connectors and Sear. In the sample, however was found a quantity of "Norma" ammunition which almost 100% showed primer piercing. We then examined the rifles which had malfunctioned and found evidence of primer piercing in each of these. The writer explained the function of the Connector, why it should not be soldered to the Trigger and how piercing the primer causes breaking. We then repaired the rifles to instruct the Police Gunsmith in all phases of correction, from replacing Connectors and Sear, to complete Trigger Assembly replacement including adjusting, staking and sealing. As time permitted, the most used group of rifles was checked over replacing the old style Connector which is more easily broken due to the reduction in wall thickness around the Stop Screw hole.

It was agreed that the Police Gunsmith would replace Connectors in all rifles as the trucks containing them came in for regular check up. Remington will furnish the necessary components. Also the Bolts in all 223 rifles will be altered to minimize primer piercing by swaging a radius (used for 17 Cal.) around the Firing Pin hole. The tool for this was left with the Gunsmith by the writer.

*C. F. Prosser*

C. F. Prosser  
Process Engineer

CFP:jc



*8- m/600*

John Jay

40 600 Carbine - Cal. 223 Rem.

Price \$55.75 each.

Factory Order No. A 11154 ( Purchase order not assigned.

Invoice and ship to

New York City Police Range- New York City Police Academy  
Rodmans Neck  
Pelham Bay Park  
Bronx, New York

Attention Lt. Frank McGee.

Standard swivels only (not the quick detachable type)      no sling strap

ship swivels loose.

Show federal excise tax ~~separate~~

Transportation prepaid - no charge

*Ship Monday sure*

*Art  
Shipped 7/31/67*

*Called Rdy 8:45 AM 7/31  
D. McArthur*



DATE OF ORDER

Q 106

TERMS: **NET** **2/0 REMITTANCE**

SHIPPING ORDER

GOVERNMENT SALES DIVISION  
REMINGTON ARMS COMPANY, INC.  
BRIDGEPORT, CONNECTICUT 06602

REMINGTON ORDER NO. <b>A-22294</b>	
CUSTOMER ORDER NO.	
ORDER DATE <b>7/10/67</b>	DATE TO PLANT <b>7/28</b>
DATE RCVD. <b>7/28/67</b>	DATE ASSIGNED
MUST BE SHIPPED ON OR BEFORE <b>28 JUL 67</b>	

DISTRIB. BY GOVT. SALES	DISTRIB. BY BPT. PLANNING
MASTER GOVT. SALES FILE 4 CARB. SET <b>C. AMMUNITION 93-2</b> <del>1 WHITE U.S. INSPECTOR</del> <del>WHITE BPT. PLANNING</del> <b>R.A. WILLIAMS</b> <b>WASO WENTON-ELLEN</b> SOLD TO <b>MR POLICE RANGER</b> <b>REDAKED NAME</b> <b>REDAKED NAME (GAIL ON INT)</b> <b>REDAKED NAME</b> <b>ATTN MR FRANK RANGER</b>	WHITE PLNG. SPVSR. WHITE TRAF. SPVSR. WHITE WHSE. SPVSR. (2) WHITE INSP. SPVSR.

SHIP TO **SAME**

SPECIFICATIONS, SCHEDULE & OTHER INSTRUCTIONS  
**\*TO Number will be forwarded when received.**  
**Receipts Certificates will be issued**

*8 - 14/600*

GVT. INSP. AT PLANT	FED. EXCISE TAX	SHIP PREPAID	SHIP COLLECT
GVT. INSP. AT DEST.	INCLUDED	<input checked="" type="checkbox"/> NO CHARGE	GOVT. B/L
CERT. OF COMPL.	<del>REDAKED</del>	CHG. ACTUAL	COML. B/L
GVT. LOT NOS. RQD.	NOT APPLICABLE	CHG. EQUALIZED	MARK TO CONVERT
REM. LOT NOS. RQD.	<input checked="" type="checkbox"/> <del>REDAKED</del>	CHG. \$	TO GB/L AT DEST.

ITEM NO.	DESCRIPTION	INDEX	ORDER QUANTITY	UNIT PRICE	\$ AMOUNT	QUANTITY SHIPPED	NO. OF CASES
1.	<b>REM. 600 CALIBER 283</b> <b>REM. 600 CALIBER 283</b> <b>REDAKED (not quite correct)</b> <b>not used by...</b>		<b>40</b>	<b>52.75</b>			

*Shipped 7/31*

LOT NOS., CODES, ETC. **154-75**  
**C.I. P.I.R.**

DATE SHIPPED
NO. OF CASES
SHIPPING WEIGHT <span style="float:right">LBS.</span>
CARRIER



## REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE

*Remington*  
DUPONT*PETERS*  
DUPONT

"CONFINE YOUR LETTER TO ONE SUBJECT ONLY" \_\_\_\_\_

CC: F. E. Morgan - Bdpt.  
L. J. Boyle  
S. M. Alvis  
L. Fox  
W. C. Schrader  
R. L. Hall

Ilion, New York  
October 30, 1970

A. D. KERR

MOHAWK 600

Confirming a telephone conversation with F. E. Morgan, October 30, 1970, the magnum calibers will be deleted for the Mohawk 600 for 1971.

*V. G. DeReus*  
V. G. DeReus  
Senior Engineer - Staff

VGD:I



## REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE

*Remington*  
DUPONT*PETERS*  
DUPONT

CC: F. E. Morgan - Bdpt.  
L. J. Boyle  
S. M. Alvis  
L. Fox  
W. C. Schrader  
R. L. Hall

"CONFINE YOUR LETTER TO ONE SUBJECT ONLY" \_\_\_\_\_



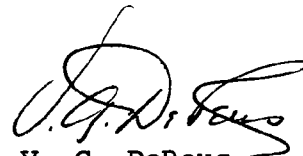
Ilion, New York  
October 14, 1970

A. D. KERR

MOHAWK 600

Confirming a conversation with F. E. Morgan, it is possible that in 1971 the magnum calibers will be deleted for the Mohawk 600.

On this basis, any ordering of parts and birch blanks for the Stock should be held. Marketing will advise Ilion by November 1, 1970 regarding the magnum calibers.



V. G. DeReus  
Senior Engineer - Staff

VGD:I



Bal. To Revenue 7/31	Revenue	Bal. To Revenue IN SEPT.	IN Process						
308	37	38	258	0	1200	AT	OUT	OK	
35	—	58	230	380					
60111	526	582	308	521	← Revenue - (many of these are assigned to other keys)				
243	396	403	662	300/200					
6.5	—	248	248	400					
223		70		24.5					



R2528522







6/3/67

[illegible]



12/10/20

	1916	2460	3800	5560	1120
1950	660	2144	1746	1857	581
1949	<del>1154</del>	<del>206</del>	<del>2054</del>	<del>3703</del>	<del>539</del>
1948					



<del>1.24</del>	<del>9/18</del>	<del>14600</del>	<del>Amount</del>
	8/16-1		

1961-1961



735  
14/10300  
98  
50  
42/80



REMINGTON ARMS COMPANY, INC.  
Ilion Research Division  
April 4, 1966

J.D. Mitchell  
F.E. Morgan  
S.R. Hutchinson  
T.F. Lynch  
E.G. Larson

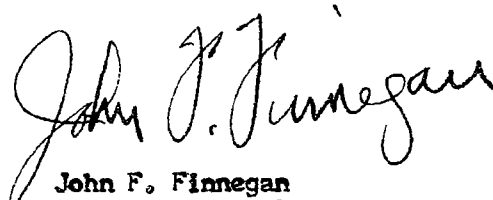
R.A. Williamson  
V.G. De Reus  
~~L.J. Davis~~  
A.D. Kerr } In Turn  
H.J. Hackman (3)  
F.T. Plunkett } In Turn  
R. Greenlee }  
W.W. Fenton  
F. Carlson  
R.W. Farrington  
R.E. Wright  
W.A. Best

REMINGTON STANDARDS - ARMS  
Model 600 - Standard - Revision  
Model 600 - Magnum - Revision

Attached are two sheets (one for each model) revised as follows:

Sheet 2 - BARREL: Bedding specification indicated as  
"No Requirement".

Reference: W.E. Leek.

  
John F. Finnegan  
Ilion Research Division

JFF:gjp  
Attach.



REVISED 3-9-66

REMINGTON STANDARDS - ARMS

SHEET 2

MODEL 600	308 Win.	6MM Rem.	222 Rem.	35 Rem.	243 Win.	223 Rem. (Export only)
<b>BARREL</b>	Round tapered to breech and crowned at muzzle. Black color, medium lustre. Remington specification alloy steel. Steel barrel studs (6) for rib and sight attachment.					
<b>Bedding</b>	No Requirement.					
<b>Barrel Bracket</b>	Elevated type.					
<b>Length (Nominal)</b>	18 1/2"					
<b>Diameter (O.D.)</b>	1.315 inches					
<b>Bore (in.)</b>	.300 min. .302 max.	.237 min. .238 max.	.219 min. .220 max.	.349 min. .351 max.	.237 min. .238 max.	.219" min. .220" max.
<b>Groove (in.) (6)</b>	.308 min. .310 max.	.243 min. .244 max.	.2240 min. .2250 max.	.357 min. .359 max.	.243 min. .244 max.	.224" min. .225" max.
<b>Twist (R.H.)</b>	1 Turn in:					
	10 inches	9 inches	14 inches	16 inches	9 inches	12 inches
<b>Markings</b>	See MARKINGS - Barrel					
<b>BARREL RIB</b>	Black Delrin. Ventilated type attached to barrel studs with screws. Matted between sight positions.					
<b>BOLT (Final Assembly)</b>	includes Bolt Assembly, Firing Pin Assembly.					
<b>Bolt Body</b>	Bright steel.					
<b>Bolt Plug</b>	Black color.					
<b>Bolt Handle</b>	Bright steel color. Forward "S" shape with oval "half ball". Serrated on bottom of half ball.					
<b>Firing Pin Head</b>	Black color.					
<b>Markings</b>	Serial number on bottom of bolt. See MARKINGS - Bolt.					
<b>Export</b>	Use "shrouded" bolt plug - special design.					
<b>BOLT STOP</b>	Located in left rear of "bolt track" in receiver. Use narrow tool to push down for release.					
<b>Per W.E. Lett.</b>						
<b>Other</b>	Other than bedding specifications.					
<b>Revision</b>	Production & Research Division agreement of 3-7-66 per R.P. Kelly.					

RD-6489



Fig. 7-66  
REVISED 3-3-66

REMINGTON STANDARDS - ARMS

SHEET 2

MODEL 600 MAGNUM	350 Rem. Mag.	6.5MM Rem.Mag.
<b>BARREL</b>	Round, tapered to breech and crowned at muzzle. specification alloy steel. Steel barrel studs (6)	Black color, medium lustre. Remington for rib and sight attachment.
<b>** Bedding</b>	No Requirement.	
Barrel Bracket	Elevated	See 350 Mag.
Length (Nominal)	18 1/2"	See 350 Mag.
Diameter (O.D.)	Magnum	See 350 Mag.
Bore (in.)	.349 Min.	.256 Min.
	.351 Max.	.257 Max.
Groove (in.) (6)	.357 Min.	.264 Min.
	.359 Max.	.265 Max.
Twist (R.H.) 1 turn in	16" (Nominal)	9" (Nominal)
Markings	See MARKINGS - Barrel	
<b>BARREL RIB</b>	Black Delrin. Ventilated type attached to barrel studs with screws. Matted between sight positions.	
<b>BOLT (Final Assembly)</b>	includes Bolt Assembly, Firing Pin Assembly.	
Bolt Body	Bright steel	
Bolt Plug	Black color	
Bolt Handle	Bright steel color. Forward "S" shape with oval "half ball".	Serrated on bottom of half ball.
Firing Pin Head	Black color	
Markings	Serial Number on bottom of bolt. See MARKINGS - Bolt.	
Export	Use "Shrouded" bolt plug - special design.	
<b>** Per W.E. Leek.</b>		
Ref. Memo from W.E. Leek & R.P. Kelly dated 3-3-66 authorizing bedding specifications.		
Revision - Production & Research Division agreement of 3-7-66 per R.P. Kelly.		

NO-6489



REMINGTON ARMS COMPANY, INC.  
Ilion Research Division  
March 31, 1966

J.D. Mitchell  
F.E. Morgan  
S.R. Hutchinson  
T.F. Lynch  
E.G. Larson

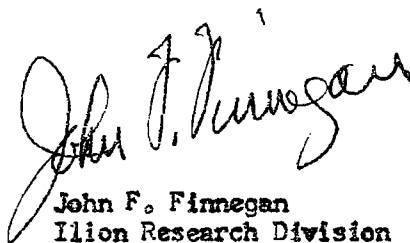
R.A. Williamson  
V.G. De Reus  
~~L.J. Boyle~~  
~~A.D. Kerr~~ ) In Turn  
H.J. Hackman (3)  
F.T. Plunkett ) In Turn  
K. Greenlee )  
W.W. Fenton  
F. Carlson  
R.W. Farrington  
R.E. Wright  
W.A. Best

REMINGTON STANDARDS - ARMS  
Model 600 Magnum

Attached is Sheet #1 revised for 6.5MM Rem. caliber.

ACCURACY - Group Size (E.S.) - Now indicated as 5 shots-3 1/2"  
(was 2 1/2").  
- Ammunition - 120 gr. bullet weight added.

Reference: Operations Committee Min. #6-1966, dated 3-9-66.

  
John F. Finnegan  
Ilion Research Division

JFF:rgjp  
Attach.



Orig. 7-1-65

REVISED 12-14-65

3-30-66

REMINGTON STANDARDS - ARMS

SHEET 1

MODEL	600 MAGNUM	350 Rem. Mag.	6.5MM Rem. Mag.
ACCURACY			
Range	100 yds.		
Point of Aim	6 o'clock on target		
Center of Impact	Not more than 2 inches	below or 4 inches above or	3 inches either side of point of aim.
Group Size (E.S.)		5 shots - 3 1/2"	*** 5 shots - 3 1/2" ***
Ammunition		200 gr. PSP	*** 120 gr.
ACTION	<p>Bolt action, hand operated. Removable bolt. Solid frame with takedown stock. Bolt cocks as handle is raised. Rifle cocks as bolt handle is lowered to lock action closed. Extracts and ejects as bolt is "opened". Direct action trigger. 2 stop safety - Forward to FIRE position - rearward to ON SAFE stop position.</p> <p>Action must feed, fire, extract and eject (include extraction and ejection without firing) satisfactorily with all varieties of ammunition listed as standard (for tabulated calibers) in Technical Committee Manual of the Sporting Arms and Ammunition Manufacturers' Institute (SAAMI)</p>		
ANNOUNCEMENT			
Jan.		1965	1966 *
June			
<p>**** Added per Operations Committee Min. #6 1966 dated 3-9-66</p> <p>*** Ref.: Per Operations Committee Min. #6 1966 dated 3-9-66 (was 2 1/2").</p> <p>*Ref: Genl. Mgt. approved release to Production of 6.5MM Rem. Mag. June 8, 1965.</p> <p>** Per W. E. Leek 12-14-65 (Verbal)</p>			



CC: A. D. Kerr  
W. A. Best  
T. H. Pratt (2)  
V. G. DeReus  
F. H. Byrnes

Ilion, New York  
February 25, 1966

L. J. BOYLE

MODEL 600, 6.5mm REMINGTON MAGNUM BARRELS  
SCANT MATERIAL - TAPER SECTION - BREACH END

Several representative Barrels from a lot of approximately 1600 have been reviewed by the Plant Committee.

The scant material at the breech end, resulting in poor fit in Stock and a noticeable gap between Rib and Barrel, is considered to be excessive.

It is suggested that this lot of Barrels be set aside and placed in the Salvage Area for possible disposition at a later date.

RAW. Thompson Chairman

H. H. Hackman

HJH:I



*R. A. Williamson*  
cc. J. E. Dickey *Oz Boyle*  
H. J. Mackman  
S. E. Alvis  
E. J. Conroy  
Neil Oldridge

Berkeley, California  
January 12, 1966

TO: F. E. MORGAN  
FROM: D. LEE BRAUN  
SUBJECT: MODEL 600 - 6.5 MM REMINGTON MAGNUM TEST - SERIAL 56408

On January 11, 1966, the above model subject gun was shot and tested and we give you the following critique.

Loading and unloading was satisfactory in every respect. However, some of the cases are scratched and in two instances the noses of the cartridge was blunted to one side. This was caused by the tip of the bullet contacting the loading ramp before entering the barrel.

The accuracy of this particular rifle with scope and rest was an inch and some few shots a little outside of an inch group, but this could be caused by reason of shooting shotguns more often than shooting a rifle. This accuracy test was at a 100 yards.

The handling is very satisfactory. Both extractions and ejection were smooth and positive.

With ear plugs and cotton, the muzzle blast was not at all uncomfortable. The recoil is negligible.

Shooting offhand at 100 yards, we were able to keep the hits within the black, which is exceptional, not doing more rifle shooting than the writer and Neil Oldridge participate in.

We will re-iterate, this cartridge should be made to perform BETTER than the 270, so as to give us something to sell over and above. We have not heard or found expression on this gun in the same interest as the 350 magnum and it will have to be given a lot of push and promotion and advertising, if we do not make a better performing cartridge than the one we have just shot, which is only comparable to a 270.

This test was performed by Neil Oldridge and the writer.

I again request that Neil Oldridge be put on our list of representatives for testing purposes, as he is a hunter and has the experience of actuality, other than just theory, - which so many of our representatives lack.

Very truly yours,

*D L B*  
D. Lee Braun  
Manager - Western Region

DLB:ms

P.S. The 2½ Leupold scope is, we feel, not the proper scope. It should have a little more powerful scope for bench rest testing.

D.L.B.



cc: ~~Harvey Mackinnon~~

RD-60-F

REMINGTON ARMS COMPANY, INC.  
INTER-DEPARTMENTAL CORRESPONDENCE



St. Louis, Missouri  
January 13, 1966

TO: F. E. MORGAN  
FROM: G. T. PORTER  
SUBJECT: TEST RESULTS GP MODER 600 YARD REMINGTON MAGNUM  
SERIAL #57416

Half of this test was made under very adverse weather conditions. This rifle was tested in rain with wind approximately 7 miles per hour and a heavy overcast. The accuracy at 50 and 100 yards off hand I considered very acceptable. I hand fed single shots during the accuracy test and noticed that the camming of the bolt was difficult on some cartridges and the extraction was also somewhat difficult on some of the cases, however, I attribute this to the resizing of the .350 case. I had no problems with feeding or ejection while extraction was difficult at times. Recoil, I consider well within the acceptable range while the muzzle blast appeared to be above the normal and unpleasant. This resulted in a ringing in my ears after which ear plugs were used.

Carrying qualities were considered excellent.

Enclosed are some of the test targets used that were shot offhand at 50 yards and bench rest at 100 yards.

GTP/sk



TO: A. D. KERR

cc: J. McIntyre  
File

RESEARCH AND DEVELOPMENT

FIREARMS ~~WITHDRAWN~~ RETURN

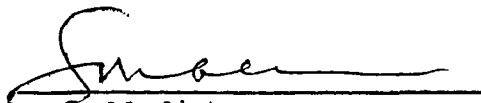
DATE	Dec. 17, 1965		
QUANTITY	13		
LETTER NO.	993		
MODEL	600	CAL. <del>3A</del>	6.5MM
WORK ORDER	73813		
SERIAL NOS.	56329	56116	56809
	56154	57416	56115
	56067	56405	57636
	57385	56039	56060
	56408		

REMARKS:

These were withdrawn on Letter No. 990.  
Each of the above rifles are being shipped to the Remington field representatives on R&D M-orders in accordance with distribution listed in F.E. Morgan's letter dated ~~Dec 1~~ 1, 1965 to your attention.

Above Research work order should be credited.

JAR:SMA:T

  
S. M. Alvis



cc: H. J. Hackman  
S. M. Alvis

# REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE

Remington



Bridgeport, Connecticut  
December 1, 1965

TO: A. D. KERR - ILION

R. A. Williamson (1)  
Copies: W. W. Fenton (2)  
12/2/65

FROM: F. E. MORGAN

*12/2/65*

It is my understanding that the field test Model 600 - 6.5MM Remington Magnum rifles will be ready in a couple of days.

Will you therefore, please arrange to ship a gun and 80 rounds of ammunition to each of the following -

D. Lee Braun\*  
T. R. Frye\*  
M. S. Crabtree  
G. W. Martin\*  
R. G. Sherman\*  
E. B. Spencer\*  
R. J. Dickey

J. V. Eliot  
G. T. Porter  
T. C. Williams\*  
C. H. Reinhard  
T. F. Parker  
F. E. Morgan\*

\*These guns are to be equipped with rifle scopes.

FEM/mgm

*F. E. Morgan*

P.S. Incidentally Art, these guns will be returned to Ilion after the field tests have been conducted. If you have any questions concerning this, please contact Harvey Hackman.

FEM

*Expect to ship wk. 7/2/13*



REMINGTON ARMS COMPANY, INC.  
Ilion Research Division  
July 7, 1965

*Good*  
J. D. Mitchell  
E. E. Morgan  
S. R. Hutchinson  
T. F. Lynch  
E. G. Larson

*Ken.*  
*How about labels & folders*  
*Labels & folders*  
*Ken*  
R. A. Williamson  
~~E. J. Boyle~~ ) In Turn ✓  
A. D. Kerr )  
H. J. Hackman (3)  
T. F. Plunkett ) In Turn  
K. Greenlee )  
V. G. DeReus  
W. W. Fenton  
Methods & Stds.  
R. W. Farrington  
R. E. Wright  
W. A. Best

REMINGTON STANDARDS - ARMS  
Model 600 MAGNUM Calibers

Attached is a complete MAGNUM supplement of seven (7) sheets. This new transmittal includes specifications for 350 Rem. Mag. and 6.5MM Rem. Mag. Calibers.

The 350 Rem. Mag. caliber has been separated from the regular Model 600 Caliber Remington Standards. See revised transmittal for M/600 (Regular) dated 7-1-65.

Reference for addition of 6.5MM Rem. Mag. is per Genl. Mgt. approval for release to Production June 8, 1965.

JFF:T  
Attach.

*called J. Kane 7/13/65*  
*J. P. Finnegan*  
J. P. Finnegan  
Ilion Research Division



SHEET 1

MODEL 600 MAGNUM		350 Rem. Mag.	6.5MM Rem. Mag.
<b>ACCURACY</b>			
Range	100 yds.		
Point of Aim	6 o'clock on target		
Center of Impact	Not more than 2 inches	below or 4 inches above or	3 inches either side of point of aim.
Group Size (E.S.)		5 shots-3 1/2"	5 shots-3 1/2"
Ammunition		200 gr. PSP	?
<b>ACTION</b>			
Bolt action, hand operated. Removable bolt. Solid frame with takedown stock. Bolt cocks as handle is raised. Rifle cocks as bolt handle is lowered to lock action closed. Extracts and ejects as bolt is "opened". Direct action trigger. 2 stop safety - Forward to FIRE position - rearward to ON SAFE stop position.			
Action must feed, fire, extract and eject (include extraction and ejection without firing) satisfactorily with all varieties of ammunition listed as standard (for tabulated calibers) in Technical Committee Manual of the Sporting Arms and Ammunition Manufacturers' Institute (SAAMI)			
<b>ANNOUNCEMENT</b>			
Jan.	1965	1966 *	
June	--	--	
*Ref: Genl. Mgt. approved release to Production of 6.5MM Rem. Mag. June 8, 1965.			

**CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER**

R2528539



Orig. 7-1-65  
REVISED

REMINGTON STANDARDS - ARMS

SHEET 2

MODEL 600 MAGNUM	350 Rem. Mag.	6.5MM Rem. Mag.
BARREL	Round, tapered to breech and crowned at muzzle. Black color, medium lustre. Remington specification alloy steel. Steel barrel studs (6) for rib and sight attachment.	
Barrel Bracket	Elevated	See 350 Mag.
Length (Nominal)	18 1/2"	See 350 Mag.
Diameter (O.D.)	Magnum	See 350 Mag.
Bore (in.)	.349 Min.	.256 Min.
	.351 Max.	.257 Max.
Groove (in.) (6)	.357 Min.	.264 Min.
	.359 Max.	.265 Max.
Twist (R.H.) 1 turn in	16" (Nominal)	9" (Nominal)
Markings	See MARKINGS - Barrel	
BARREL RIB	Black Delrin. Ventilated type attached to barrel studs with screws. Matted between sight positions.	
BOLT (Final Assembly)	includes Bolt Assembly, Firing Pin Assembly.	
Bolt Body	Bright steel	
Bolt Plug	Black color	
Bolt Handle	Bright steel color. Forward "S" shape with oval "half ball". Serrated on bottom of half ball.	
Firing Pin Head	Black color	
Markings	Serial Number on bottom of bolt. See MARKINGS - Bolt.	
Export	Use "Shrouded" bolt plug - special design.	



**CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER  
KINZER V. REMINGTON**

## KINZER V. REMINGTON

**R2528541**

RD-6489



Orig. 7-1-65

REVISED

## REMINGTON STANDARDS - ARMS

SHEET 4

MODEL 600 MAGNUM		350 Rem. Mag.	6.5MM Rem. Mag.					
MARKING S:								
Barrel	Dwg. No. B-15729. Same for all calibers.							
Assembly	Left rear							
Rem. Name	Left side							
Rem. Address	Left side							
Caliber	Left rear							
Code (Mfg. Date)	Left rear							
Patent Numbers	Below Remington name							
Proof (REP)	Right rear							
Test	Right rear							
Other								
Magnaflux	Right rear (to rear of (REP) marking).							
Receiver	Dwg. No. B-15482							
Grade	None							
Rem. Script	Left center							
Model No.	Below script (Rem.)							
Serial No.	Left front							
Other								
Export to Australia: Mark "S" and "F" on receiver adjacent to respective Safe and Fire stop positions of safety.								
Bolt (Prick-punch Mark)	Ref: Current Practice for all calibers.							
Magnaflux	Right lug (center)							
Bolt Head Braze	Left lug (center)							
Bolt Handle Braze	Rear handle (center)							
Proof	Bottom handle (center)							
METAL FINISH	Black color, medium lustre on all exposed parts except as otherwise tabulated.							
PATENT NUMBERS	Pat. Pending							



Orig: 7-1-65  
REVISED

REMINGTON STANDARDS - ARMS

SHEET 5

MODEL	600 MAGNUM	350 Rem. Mag.	6.5MM Rem. Mag.
PACKAGING	Full length.	Exposed metal parts coated with rust preventive.	Bolt in Rifle.
Accessories	Rear sight wrench supplied. Sling strap and fittings packed separately in carton.		
Literature	Instruction Folder - Parts List, RD 5653		
Single Shipper	Single piece corrugated sheet, integral folds for rifle support. Marbleized color with brown and black artwork (Deer and Bear). Lid taped to close.		
Multiple Shipper	Sleeve of full carton of corrugated material.		
Label	Green & White, Model, Serial No., Caliber, Packers code on label.		
Markings	Name, address of addressee, with copy of shipping ticket, return address.		
Shipping Weight:			
1 Gun	9 lbs.		
2 Guns	18 lbs.		
3 Guns	26 lbs.		
5 Guns	43 lbs.		
Export	Same as domestic except "legal" or actual weight on label.		
PROOF TEST (REP)	Fire one (1) standard proof cartridge in each gun. For location of marking (REP) see MARKING-Barrel		
RECOIL PAD (Black with white spacer)		Yes	Yes
RECEIVER	Cylindrical alloy steel, black color, medium lustre. Screw fitted to barrel and barrel bracket (solid frame).		
Sighting	Drilled and tapped (5 holes) for receiver sight and telescope mount. Fitted with receiver plug screws.		
Gas Escape	One (1) hole - right side.		
Length	Standard		
Markings	See MARKINGS - Receiver.		



Orig. 7-1-65  
REVISED

REMINGTON STANDARDS . ARMS

SHEET 6

MODEL 600 MAGNUM		350 Rem. Mag.	6.5MM Rem. Mag.
SAFETY	2-stop position, forward and back thumb operated.		Corrugated black surface.
Location	Right rear of receiver.		
Fire Position	Forward stop.		
Safe Position	Rear stop (bolt handle locks down - action closed).		
SERIAL NUMBER			
Location (1)	See MARKING - Receiver		
(2)	See MARKING - Bolt		
SLING STRAP & SWIVELS, Q.D.	Yes		Yes
Description	7/8" Q.D. type, same as used on M/700. Leather material.		
SIGHTS	Metal material. Black color.		
Front	Fixed (no adjustment). Blade shaped ramp. Brass head. Attached on rib to barrel studs with two (2) screws.		
Rear	Sliding adjustment for windage and elevation.		
Eye piece	Allen-head screw for elevation adjustment. "U" notch.		
Leaf	Allen-head screw for windage adjustment. Scaled markings.		
Base	Attached to barrel with two (2) screws.		
Wrench	Allen-head type. Supplied with each gun.		



Orig. 7-1-65  
REVISED

REMINGTON STANDARDS - ARMS

SHEET 7

MODEL 600 MAGNUM	350 Rem. Mag.	6.5MM Rem. Mag.
STOCK	Comb cuts. Formed grip. Monte Carlo. Angular forearm.	
Material	Walnut and Beech - laminated. Drilled for swivels.	
Drop at Comb	1 7/8"	See 350 Mag
Drop at Heel	2"	See 350 Mag
Drop at Monte Carlo	1 5/8"	See 350 Mag
Pitch	1 5/8"	See 350 Mag
Length of Grip	3 1/2"	See 350 Mag
Length of Pull	14 ± 1/8"	See 350 Mag
Length of Stock	31 1/4"	See 350 Mag
Tang Support (Delrin)	In stock	See 350 Mag
Grip Cap	None.	
Checker	D-15844 (Custom)	
Finish	RK-W	See 350 Mag
Bedding (Epoxy)	Custom	See 350 Mag
TRIGGER	Metal material. Black color.	
Finger Surface	Serrated.	
Pull (lbs.)	4 lbs. min. - 6 lbs. max.	
Engagement	Sealed at factory.	
TRIGGER GUARD	Black "Zytel".	
Type	One piece mld.	



REMINGTON ARMS COMPANY, INC.  
Ilion Research Division  
July 7, 1965

J. D. Mitchell  
F. E. Morgan  
S. R. Hutchinson  
T. F. Lynch  
E. G. Larson

R. A. Williamson

L. J. Boyle ) In Turn

A. D. Kerr )

H. J. Hackman (3)

T. F. Plunkett ) In Turn

K. Greenlee )

V. G. DeReus

W.W. Fenton

Methods & Stds.

R.W. Farrington

R. E. Wright

W.A. Best

REMINGTON STANDARDS - ARMS  
Model 600 - Revision

Attached is complete supplement of eight (8) sheets. Caliber 223 Rem. now is added and tabulated for Export Only. Caliber 350 Rem. Mag. has been deleted and transferred to a new supplement for the Magnum 600 Calibers. See transmittal of standards for 600 Magnum Calibers dated 7-1-65.

Other revised specifications include:

ACCURACY - Ammunition:  
(see latest Sales Catalog)

Bullet weight for 35 Rem. now  
specified as 290 gr. SP.

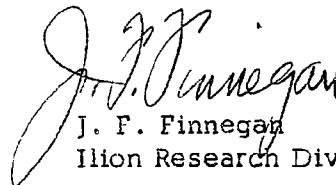
BARREL - Twist: (Nominal)  
Ref: See Chamber Drawings

9 inches now specified for 6MM Rem.  
9 inches now specified for 243 Win.

MARKING Prints

Receiver - B-15482  
Barrel - B-15729  
are also attached.

Note: For 223 Rem. Caliber addition see Oper. Comm. Minute #12 - 1965.

  
J. F. Finnegan  
Ilion Research Division

JFF:T  
Attach.



**R2528547**

RD-4480



REVISED 11-20-64 7-1-65

## REMINGTON STANDARDS - ARMS

SHEET 2

MODEL 600	308 Win.	6MM Rem.	222 Rem.	35 Rem.	243 Win.	223 Rem. (Export only)
BARREL	Round tapered to breech and crowned at muzzle. Black color, medium lustre. Remington specification alloy steel. Steel barrel studs (6) for rib and sight attachment.					
Barrel Bracket	Elevated type.					
Length (Nominal)	18 1/2"					
Diameter (O.D.)	Regular size.					
Bore (in.)	.300 min. .302 max.	.237 min. .238 max.	.219 min. .220 max.	.349 min. .351 max.	.237 min. .238 max.	.219" min. .220" max.
Groove (in.) (6)	.308 min. .310 max.	.243 min. .244 max.	.2240 min. .2250 max.	.357 min. .359 max.	.243 min. .244 max.	.224" min. .225" max.
Twist (R.H.) 1 Turn in:	10 inches	9 inches	14 inches	16 inches	9 inches	12 inches
Markings	See MARKINGS - Barrel					
BARREL RIB	Black Delrin. Ventilated type attached to barrel studs with screws. Matted between sight positions.					
BOLT (Final Assembly)	includes Bolt Assembly, Firing Pin Assembly.					
Bolt Body	Bright steel.					
Bolt Plug	Black color.					
Bolt Handle	Bright steel color. Forward "S" shape with oval "half ball". Serrated on bottom of half ball.					
Firing Pin Head	Black color.					
Markings	Serial number on bottom of bolt. See MARKINGS - Bolt.					
Export	Use "shrouded" bolt plug - special design.					
BOLT STOP	Located in left rear of "bolt track" in receiver. Use narrow tool to push down for release.					



RD-6489



REVISED 11-20-64

7-1-65

REMINGTON STANDARDS - ARMS

SHEET 4

MODEL	600	308 Win.	6MM Rem.	222 Rem.	35 Rem.	243 Win.	223 Rem. (Export only)
MARKINGS	All marking visible unless specified otherwise.						
Barrel	Dwg. B-15729						
Assembly	Left rear						
Remington Name	Left side						
Rem. Address	Left side						
Caliber	Left rear						
Code (Mfg. Date)	Left rear						
Patent Numbers	Below Remington name						
Proof (REP)	Right rear						
Test	Right rear						
Other:							
Magnaflux	Right rear (to rear of (REP) marking).						
Receiver	Dwg. B-15482)						
Grade	None						
Remington Script	Left center						
Model Number	Below script (Rem.)						
Serial Number	Left front						
Export:	To Australia: Mark "S" and "T" on receiver adjacent to respective SAFE and FIRE stop positions of safety.						
Bolt	(Prick-punch mark) Ref: Current practice.						
Magnaflux	Right lug (center)						
Bolt head braze	Left lug (center)						
Bolt handle braze	Rear handle (center)						
Proof	Bottom handle (center)						
METAL FINISH	Black color, medium lustre on all exposed parts except as otherwise tabulated.						
PATENT NUMBERS	Patent Pending.						



REVISED 11-20-64 7-1-65

## REMINGTON STANDARDS - ARMS

SHEET 5

MODEL 600	308 Win.	6MM Rem.	222 Rem.	35 Rem.	243 Win.	223 Rem. (Export only)
PACKAGING	Full length.	Exposed metal parts coated with rust preventive.			Bolt in rifle.	
Accessories	Rear sight wrench supplied.					
Literature	Instruction Folder - Parts List RD 5473					
Single Shipper	Single piece corrugated sheet, integral folds for rifle support. Marbled color with brown and black artwork (Deer and Bear). Lid taped to close.					
Multiple Shipper	Sleeve of full carton of corrugated material.					
Label	Green and white, model, serial number, caliber, packers code on label.					
Markings	Name and address of addressee, with copy of shipping ticket, return address.					
Shipping Weight						
1 Gun	8 lbs.					
2 Guns	16 lbs.					
3 Guns	23 lbs.					
5 Guns	38 lbs.					
Export	Same as domestic except: Legal or actual weight on label.					
PROOF TEST (REP)	Fire one (1) standard proof cartridge in each gun. For location of marking (REP) see MARKINGS - Barrel.					
RECEIVER	Cylindrical alloy steel, black color, medium lustre. Screw fitted to barrel and barrel bracket (solid frame).					
Sighting	Drilled and tapped (5 holes) for receiver sight and telescope mount. Fitted with receiver plug screw.					
Gas Escape	One (1) hole - right side.					
Length	Standard					
Markings	See MARKINGS - Receiver.					



REVISED 11-20-65

7-1-65

## REMINGTON STANDARDS - ARMS

SHEET 6

MODEL 600	308 Win.	6MM Rem.	222 Rem.	35 Rem.	243 Win.	223 Rem. (Export only)
<b>SAFETY</b>	2-stop position, forward and back-thumb operated. Serrated black surface.					
Location	Right rear of receiver.					
Fire Position	Forward stop.					
Safe Position	Rear stop. (Bolt handle locks down - action closed).					
<b>SERIAL NUMBER</b>	(Start 1000 )					
Location (1)	See MARKING - Receiver.					
(2)	See MARKING - Bolt.					
<b>SLING STRAP</b>	As necessary at extra cost.					
Description	7/8" OD type same as used on M/700. Leather material.					
<b>SIGHTS</b>	Metal material. Black color.					
Front	Fixed (no adjustment). Blade shaped ramp. Brass head. Attached on rib to barrel studs with two (2) screws.					
Rear	Sliding adjustment for windage and elevation.					
Eye piece	Allen-head screw for elevation adjustment. "U" notch.					
Leaf	Allen-head screw for windage adjustment. Scaled markings.					
Base	Attached to barrel with two (2) screws.					
Wrench	Allen-head type. Supplied with each gun.					



REVISED 11-20-65 7-1-65

REMINGTON STANDARDS - ARMS

SHEET 7

MODEL 600	308 Win.	6MM Rem.	222 Rem.	35 Rem.	243 Win.	223 Rem. (Export only)
STOCK	Comb cuts.	Formed grip.	Monte Carlo.	Angular forearm.		
Material	American Walnut					
Drop at Comb	1 7/8"					
Drop at Heel	2"					
Drop at Monte Carlo	1 5/8"					
Pitch	1 5/8"					
Length of Grip	3 1/2"					
Length of Pull	14 1/8"					
Length of Stock	31 1/4"					
Tang Support	None					
Grip Cap	None					
Checker	D-15844 (Custom)					
Finish	Lacquer					
Bedding	Regular					
TRIGGER	Metal material. Black color.					
Finger Surface	Serrated.					
Pull (lbs.)	4 lbs. min. - 6 lbs. max.					
Engagement	Sealed at factory.					
TRIGGER GUARD	Black "Zytel".					
Type	One piece mold.					



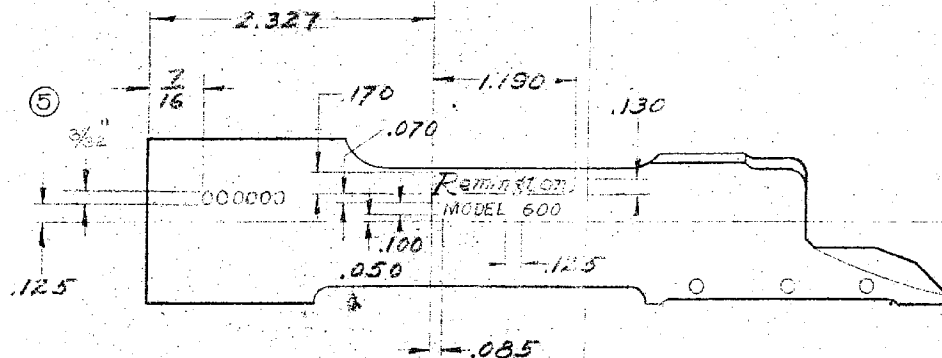
B-15482

MODEL	CALIBER	ASS'Y NO.	RECEIVER NO.
600	308 WIN	26680	15406
600	222 REM	26681	15787
600	35 REM	26682	15406
600	6MM REM	26683	15406
600	350 REM MAG	26684	15406
600	243 WIN	26685	15406
600	6.5MM REM MAG	26686	15406

DO NOT SCALE THIS DRAWING. WORK TO FIGURES.  
UNLESS OTHERWISE NOTED, TOLERANCES  
ON DECIMAL DIMENSIONS ARE  $\pm .005$   
& ON FRACTIONAL DIMENSIONS  $\pm \frac{1}{64}$   
& ON ANGULAR DIMENSIONS  $\pm 00^{\circ}30'$   
FINISHES ARE DESIGNATED BY ROOT MEAN  
SQUARE (R.M.S.) MICRO-INCH ROUGHNESS  
VALUES AND ARE THE MAXIMUM ROUGH-  
NESS ACCEPTABLE, UNLESS OTHERWISE  
SPECIFIED. FINISH ROUGHNESS TO BE  
125  
V OR BETTER.

# ALTERATIONS

LET.	WAS	REFERENCE	BY	DATE
1	Added	5019	JW	10-26-62
2	222 Rem	5213	JW	3/24/63
3	Added 35 Rem	5213	JW	3/24/63
4	Added 6mm Rem	5566	JW	2/24/64
5	.125	5661	JF	7/24/64
6	Added 243 WIN	6075	JF	5/17/65
7	Added 350 REM MAG	"	"	"
8	Added 6.5mm REM MAG	"	"	"



NOTE-

DIMENSIONS ARE TO OUTSIDE  
EDGE OF IMPRESSION

600 RECEIVER MARKING			
MODEL	PART USE	QUAN.	SEE
DES'D BY DATE	DRAWN BY DATE	CHECK BY DATE	APPR. BY DATE
	RJ 3/29/62		WL 4/15/62
TITLE RECEIVER MARKING			
NUMBER	SCALE	SUPERSEDES-REFERENCE	
B-15482	FULL	REMINGTON ARMS CO. INC.	
RESEARCH & DEV. DEPT.			

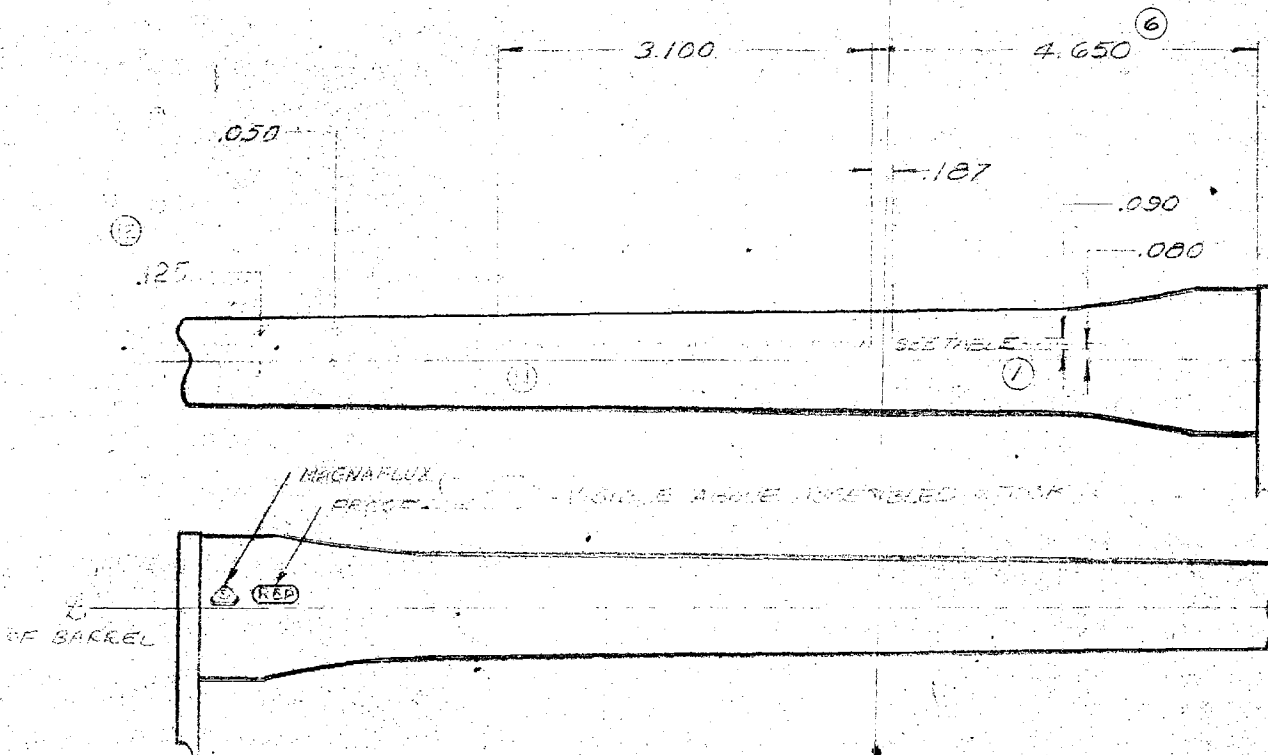


5-15729

NOTE:  
DIMENSIONS ARE TO  
OUTSIDE OF IMPRESSION

DO NOT SCALE THIS DRAWING. WORK TO FIGURES.  
UNLESS OTHERWISE NOTED, TOLERANCES  
ON DECIMAL DIMENSIONS ARE  $\pm .005$   
& ON FRACTIONAL DIMENSIONS  $\pm \frac{1}{64}$   
& ON ANGULAR DIMENSIONS  $\pm 00^{\circ}30'$   
FINISHES ARE DESIGNATED BY ROOT MEAN  
SQUARE (R.M.S.) MICRO-INCH ROUGHNESS  
VALUES AND ARE THE MAXIMUM ROUGH-  
NESS ACCEPTABLE, UNLESS OTHERWISE  
SPECIFIED. FINISH ROUGHNESS TO BE  
125  
V OR BETTER.

ALTERATIONS				
LET.	WAS	REFERENCE	BY	DATE
1	308 WIN.	5013	AL	10/24/62
2	Added	5013	AL	9/29/62
3	222 Rem.	5213	AL	9/24/63
4	35 REM.	5213	AL	9/24/63
5	222 Rem Mag	5242	AL	9-26-63
6	3.187	5862	AL	5-10-64
7	ADDED PROOF 3 MAGNAFLUX	5526	AL	4/15/64
8	Added 6MM	5566	AL	5-12-64
9	ADDED PROOF 35 REM MAG	5717	AL	6-28-64
10	35 REM MAG	5739	AL	7/2/64
11	PAT. PENDING	5764	AL	7/13/64
12	ESTABLISHED CENTER LINE	"	"	7/14/64
13	ADDED 243 WIN.	5842	"	10/28/64
14	ADDED 6.5MM REM MAG	6075	AL	5/17/65
15	ADDED 223 REM EXPORT	6129	"	5/29/65



600	"EXPORT"	223 REM.	26697	26687
600	6.5mm REM. MAG.	26696	26686	
600	243 WIN.	26695	26685	
600	350 REM. MAG.	26694	26684	
600	6MM REM.	26693	26683	
600	35 REM.	26692	26682	
600	222 REM.	26691	26681	
600	308	26690	26680	
TFB-1 REV. 2 MODEL		CALIBER	B&L NO.	ASSY NO.

600 BBL. MARKING			
MODEL	PART USE	QUAN.	SEE
DES'D BY DATE	DRAWN BY DATE	CHECK BY DATE	APPR. BY DATE
	AL 7/29/62		AL 4/15/62
TITLE BARREL MARKING			
NUMBER	SCALE	SUPERSEDES - REFERENCE	
B-15729	Full		
REMINGTON ARMS CO. INC. RESEARCH & DEV. DEPT.			



CC: S. M. Alvis N. W. Menard  
L. J. Boyle R. B. Hurley  
A. D. Kerr W. Scanlon

Illion, New York  
April 7, 1965

H. J. Hackman

Subject: M/600 & M/700 Finish Gun Weights - Warehouse Audit

As a result of comments by Rivolier Pere et Fils, Remington distributors in France that our M/700 270 Cal. was heavier than advertised although M/600 35 Cal. was acceptable, a 5 gun audit of every caliber by grade was made.

Attached is the summary of these results together with the weight as specified in the 1965 standard book and the 1965 gun catalogues. It will be noted that the catalogue list the same weight for ADL and BDL grades of the same caliber whereas specifications issued by R & D generally show BDL as heavier than ADL - a fact confirmed by the audit. Catalogue weights do not always agree with R & D specifications. Also they are the same as in 1964 catalogue although the barrel on the 6 calibers are now 22" vs. 20".

To Summarize:

M/700

1. Calibers with 24" barrels and short Receivers average about 7# 2-3 oz. in the ADL and 7# 6-8 oz. in BDL, some 6 to 12 oz. over specifications.
2. Calibers with 24" barrels and long Receivers average 7# 4-10 oz. in ADL and 7# 11 oz. in BDL. These are  $\pm$  4 oz. of specifications.
3. Calibers with 22" barrels in short Receivers are only 3-4 oz. in ADL over specs. but average 5-10 oz. over in the BDL grades.
4. Calibers with 22" barrel in long Receivers are only a couple of ounces over specs. in both grades. The catalogue however show 2 oz. lower on ADL and 6 oz. lower on BDL grade than specs.

M/600

1. The 3 small calibers average 9 oz. over spec. or 6# 1 oz.
2. 308 Cal. is 6 oz. over, 35 Cal. only 2 oz. over while the 350 Rem. Mag. is right on mean at 6# 8 oz.



W. A. Best, Supervisor  
Product Testing Specs.

WAB/cm  
attach.



## REMINGTON ARMS COMPANY, INC.

ENGINEERING DEPARTMENT

COMPUTATION SHEET

SHEET NO.

TITLE OF PROJ.

SUBJECT

PROJ NO

WORKS

DATE

M/700 & M/600 Finish Gun Weights  
ADL & BDL Grade by Calibers  
Warehouse Order by W. Scandon

4/5/65

Model		ADL	SPEC.S	BDL	SPEC.S
700		MAX MIN AVER CAT. STD.	MAX MIN AVER CAT. STD.		
22-250	24" Short Rec.	7-9 1/2 6-15 1/2 7-3.2	6-12	7-9 7-3 1/2 7-6.8	6-12
222 Rem.	24" "	7-4 1/2 7-2 7-2.8	6-12 6-12	7-10 1/2 7-4 7-8.5	6-12 7-0
222 Win.	24" "	7-3 1/2 7-0 7-2.0	6-12 6-12	7-9 1/2 7-4 7-6.0	6-12 7-0
Average	24" "	7-9 1/2 6-15 1/2 7-2.7		7-10 1/2 7-3 1/2 7-7.2	
6mm	22" Short Rec.	7-1 1/2 6-13 6-14.8	6-12	7-9 7-0 7-5.2	6-12
243	22" "	7-2 6-15 7-0.3	6-12	7-6 7-3 7-4.8	6-12
308	22" "	6-14 1/2 6-11 6-12.1	6-12	7-3 6-15 7-0.6	6-12
Average	22" "	7-2 6-11 6-14.4		7-9 6-15 7-3.5	
7mm	24" Long Rec.	7-5 7-3 1/2 7-4.0	7-12 7-8	7-12 7-9 1/2 7-11.1	7-12 7-12
264 Long	24" "	7-14 7-6 1/2 7-9.9	7-12 7-8	N.A. N.A. N.A.	7-12 7-12
300 Win.	24" "			N.A. N.A. N.A.	7-12 7-12
Average	24" "	7-14 7-3 1/2 7-7.0		7-12 7-9 1/2 7-11.1	
270	22" Long Rec.	7-1 1/2 6-11 6-15.3	6-12 6-14	N.A. N.A. N.A.	6-12 7-2
280	22" "	7-5 1/2 6-13 7-0.6	6-12 6-14	7-12 7-2 7-5.4	6-12 7-2
30-06	22" "	7-3 6-12 7-0.7	6-12 6-14	7-4 6-14 1/2 7-1.7	6-12 7-2
Average	22" "	7-5 1/2 6-11 6-15.2		7-12 6-14 1/2 7-3.6	
600					
222	18 1/2" Short Rec.	6-2 1/2 6-0 1/2 6-1.5	5-8 5-8		
6mm	18 1/2"	6-4 5-13 6-0.8	5-8 5-8		
243	18 1/2"	6-5 5-13 6-1.1	5-8 5-8		
308	18 1/2"	6-1 5-11 5-14.2	5-8 5-8		
35	18 1/2"	5-12 1/2 5-7 1/2 5-9.9	5-8 5-8		
Average	18 1/2" Cartridges	6-5 5-7 1/2 5-15.1			
350mag.	18 1/2" Hammered	6-10 6-7 1/2 6-8.6	6-8 6-8		

4/6/65







CC: H. J. Hackman  
V. G. DeReus  
A. D. Kerr  
W. N. Simmons

Ilion, New York  
March 22, 1965

F. Plunkett

Subject: M/600 Export Sales - Shrouded Bolt Plugs

Will you please set up your procedure when changing the F. P. Assembly to the shrouded type for Australia Export. The protusion should be checked on the new shrouded F. P. Assembly. The limits for this protusion are .045 -- .075.



W. A. Best, Supervisor  
Product Testing Specs.



CC: L. J. Boyle  
T. H. Pratt  
L. Fox  
R. E. Wright  
F. H. Byrnes

A. D. Kerr  
R. Greenlee  
B. Gilbert

n. J. Hackman  
V. G. DeReus  
R. B. Hurley

R. L. Hall

February 10, 1965

MODEL 600 BARREL BRACKET

In accordance with the Steering Committee authorization, the revised Model 600 Barrel Brackets are to be used on all M/600 Barrel and Receiver Assemblies, effective 2/10/65.

M/600 Barrel Brackets, with the clearance angles on the bottom, are to be used for M/600 Rifles 350 Caliber only.

FHB:mc



cc: Packing Committee:

W.A. Best  
W.W. Fenton  
W.T. Smith  
J.F. Finnegan  
L.W. Leonard  
R.E. Wright  
A.D. Kerr  
F.G. Carlson

January 25, 1965

C. W. WESCHROB

SAVINGS - REVISED CASE FOR SINGLE SHIPMENTS  
SHOTGUNS - MODELS 742 - 760 - 700

A suggestion to use taped tube for singles, (such as M/600), instead of a RSC or Sleeve O/Wrap, has resulted in an annual savings of \$1,450.

This revision was made after an analysis of labor and material costs indicated a potential savings in labor even if material costs did not change. However, material costs did change significantly (\$1,150).

Purchasing has been ordering new style overwrap since October, 1964, but due to an oversight, savings have not been claimed to date.



R. J. Long  
Methods & Standards Section

RJL:sm

*OK in effect.*



CC: S. M. Alvis  
A. D. Kerr

2813

Model 600, 350 Rem. Magnum

Production to Warehouse

December 1964

Based on the satisfactory plant pilot testing of 350 Rem. Magnum Rifles, R & D has agreed to continued assembly and warehousing.

Magazine Followers which were the control for continued rifle assembly were completed Dec. 21. The plant objective is to select and ship writer's and field representative rifles as soon as possible.

Model 600, Caliber 243

Production to Warehouse

January 1965

Initial rifle assembly started December 22.

Model 742-760 DeLuxe Grade

The prototype of the Model 760 Slide Action was approved. R & D will complete model drawings for release to the plant.

Work on the Stock tooling has been temporarily held to revisions. Design of the Model 742 Fore End tooling is continuing.

Orders were placed for the Fore End Tip and Spacer molding die. Delivery is expected by the end of February.

The process for the "hump" on the Receiver should be established by the end of December.

VGD:I  
12/22/64



## REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE

cc: P. H. Burdett  
R. B. Bowie  
J. B. Cadenas



Bridgeport, Connecticut  
November 13, 1964

TO: F. E. MORGAN  
FROM: W. D. VUONO  
SUBJECT: MODEL 600

The export forecast in the No. 2 forecast period for Model 600 with hooded bolt by calibers is as follows:

<u>Calibers</u>	<u>Units</u>
243	350
222	550
6mm	100
308	600
35 Rem	100
	1700

Copy for Ken Gruber (2)

W.D.



cc: P. H. Burdett  
R. B. Bowie  
J. B. Cadenas

## REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE

*Remington*

Bridgeport, Connecticut  
November 5, 1964

TO: F. E. MORGAN  
FROM: W. D. VUONO  
SUBJECT: MODEL 600

This will refer to our recent conversation in which I outlined the export need for a hooded bolt on the Model 600. The reason that a hooded bolt would be a desirable feature in export is to satisfy the so-called "safety requirements" described for firearms imports in some countries. For example, Australia, a major centerfire rifle market, has prohibited importation of the Model 600 because it has failed to pass the "safety test" prescribed for all imported firearms. This test consists of striking the back of the bolt with a mallet and should the firearm discharge it is considered unsafe. The purpose of the hooded bolt would be to prevent the possibility of accidental discharge by a blow of this type.

In my opinion, we could sell an additional 500 Model 600's, providing this Model was equipped with a hooded bolt. The Export No. 1 Forecast for the Model 600 is 1,200.

To cover additional factory cost that would be involved, we would propose to increase the price of the Model 600 in 1965.

It is my understanding that an Operations Committee Meeting is being scheduled for the near future and I hope that this item can be considered by the Committee members at this meeting.

Please advise me if you require any further information.

*W.D.V.*

*Warehouse - March 1965  
for cost by ad. required.*



REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE

*9/18*  
*9/15*  
*10/20*  
*OK MD*

Bridgeport, Connecticut  
 May 19, 1964

TO: C. L. JONES  
 FROM: WILLIAM D. VUONO  
 SUBJECT: MODEL 600

We feel .223 ammunition in combination with the Model 600 in .223 caliber might make it possible to develop a market in Greenland for .223 for use in commercial seal hunting. Our tentative plan is to commence demonstrations of .223 ammunition with two Models 600 in .223 caliber. If we are successful, we would attempt to sell the stock of obsolete .223 ammunition presently in the plant's inventory.

The purpose of this memo is to request the plant to make up for use in demonstrations two Models 600 in .223 caliber.

Please advise me of your decision.

*shipped to Germany  
 in air.*

*4/3 - H. Hackman checked  
 will follow*

*4/24 - W. A. Bush, checked*

*7/23 - No release yet.*

*9/1 - No release; Hackman will follow up with  
 Vuono (Export) re present status.*

*OK [Signature]*



# LIMITED DISTRIBUTION

## OPERATIONS COMMITTEE

### ILION DIVISION

f  
m/600

Ilion, New York  
November 19, 1964

CC: R. A. WILLIAMSON  
S. M. ALVIS  
A. D. KERR  
L. J. BOYLE  
V. G. DEREUS

TO: H. K. FAULKNER  
GAIL EVANS - P. H. BURDETT  
C. M. ALBRIGHT, JR.


G. M. CALHOUN  
H. M. STOESSEL

SUBJECT: APPROVAL FOR RELEASE TO PRODUCTION  
MODEL 600, CALIBER 243 WINCHESTER

November 17, 1964, General Management approved the addition of the caliber 243 Winchester to the Model 600 Center Fire Bolt Action Rifle. The accuracy specification is 2½".

Approval is subject to the Operations Committee conditions that work continue to effect improvements so that a 2" specification can be achieved.

Invoice shipment approval will be requested when a production sample is available.

  
V. G. DeReus, Secretary  
Operations Committee

VGd:I



RD-69-B

# REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE

*Remington*  
DUPONT

*PETERS*  
DUPONT

"CONFINE YOUR LETTER TO ONE SUBJECT ONLY" \_\_\_\_\_

Ilion, New York  
September 11, 1964

① R.C.M. copy as many as signed.

② A D KERR ✓  
46-1

*shipped  
Paw  
& W*

## Two (2) Model 600 6mm High Grade Guns for CDM

We have been requested to produce two (2) High Grade Model 600 6mm guns with RK-W finish on stock, scope attached and provide with leather carrying cases. The engraving on the guns should be the same as the one produced in June.

The stocks are to be fitted with name plates, the initials to be R.S.M. on one, and R.S.L. on the other. Detailed information on the name plates will be furnished later. Hold this operation until last.

*Paw*  
R. A. WILLIAMSON  
WORKS MANAGER

RAW md

*check Trig. guard with Wagon*  
*OK*



CC: ~~S. M. Alvis~~  
~~A. D. Kerr~~

L. J. B

Model 600, 350 Rem. Mag.

Production to Warehouse

December 1964  
(Revised)

Model drawings of the design changes have been released to the plant October 16. Process Engineering is reviewing. Tool design and equipment alterations will be expedited.

Barrel blanks which had been held for pilot operations will not clean up at the revised turning dimension. A second pilot production will be required.

Model 742-760 Appearance Change

Purchase orders have been placed for the Richardson copy lathe, "Z" arm router and dual head Barker hand mill. Delivery is promised by February 1.

Design of the checkering machine for the Fore End is approximately 60% complete.

A project to authorize funds for the Model 742-760 should be released for signatures this week.

Plant work is limited until model drawings are released by R & D.

VGD:I  
10/20/64



## OPERATIONS CONSIDER

1 2 3 4 5 6 7 8 9 10 11 12 13 14 15 16 17 18 19 20 21 22 23 24 25 26 27 28 29 30 31 32 33 34 35 36 37 38 39 40 41 42 43 44 45 46 47 48 49 50 51 52 53 54 55 56 57 58 59 60 61 62 63 64 65 66 67 68 69 70 71 72 73 74 75 76 77 78 79 80 81 82 83 84 85 86 87 88 89 90 91 92 93 94 95 96 97 98 99 100 101 102 103 104 105 106 107 108 109 110 111 112 113 114 115 116 117 118 119 120 121 122 123 124 125 126 127 128 129 130 131 132 133 134 135 136 137 138 139 140 141 142 143 144 145 146 147 148 149 150 151 152 153 154 155 156 157 158 159 160 161 162 163 164 165 166 167 168 169 170 171 172 173 174 175 176 177 178 179 180 181 182 183 184 185 186 187 188 189 190 191 192 193 194 195 196 197 198 199 200 201 202 203 204 205 206 207 208 209 210 211 212 213 214 215 216 217 218 219 220 221 222 223 224 225 226 227 228 229 230 231 232 233 234 235 236 237 238 239 240 241 242 243 244 245 246 247 248 249 250 251 252 253 254 255 256 257 258 259 260 261 262 263 264 265 266 267 268 269 270 271 272 273 274 275 276 277 278 279 280 281 282 283 284 285 286 287 288 289 290 291 292 293 294 295 296 297 298 299 300 301 302 303 304 305 306 307 308 309 310 311 312 313 314 315 316 317 318 319 320 321 322 323 324 325 326 327 328 329 330 331 332 333 334 335 336 337 338 339 340 341 342 343 344 345 346 347 348 349 350 351 352 353 354 355 356 357 358 359 360 361 362 363 364 365 366 367 368 369 370 371 372 373 374 375 376 377 378 379 380 381 382 383 384 385 386 387 388 389 390 391 392 393 394 395 396 397 398 399 400 401 402 403 404 405 406 407 408 409 410 411 412 413 414 415 416 417 418 419 420 421 422 423 424 425 426 427 428 429 430 431 432 433 434 435 436 437 438 439 440 441 442 443 444 445 446 447 448 449 450 451 452 453 454 455 456 457 458 459 460 461 462 463 464 465 466 467 468 469 470 471 472 473 474 475 476 477 478 479 480 481 482 483 484 485 486 487 488 489 490 491 492 493 494 495 496 497 498 499 500 501 502 503 504 505 506 507 508 509 510 511 512 513 514 515 516 517 518 519 520 521 522 523 524 525 526 527 528 529 530 531 532 533 534 535 536 537 538 539 540 541 542 543 544 545 546 547 548 549 550 551 552 553 554 555 556 557 558 559 560 561 562 563 564 565 566 567 568 569 570 571 572 573 574 575 576 577 578 579 580 581 582 583 584 585 586 587 588 589 590 591 592 593 594 595 596 597 598 599 600 601 602 603 604 605 606 607 608 609 610 611 612 613 614 615 616 617 618 619 620 621 622 623 624 625 626 627 628 629 630 631 632 633 634 635 636 637 638 639 640 641 642 643 644 645 646 647 648 649 650 651 652 653 654 655 656 657 658 659 660 661 662 663 664 665 666 667 668 669 670 671 672 673 674 675 676 677 678 679 680 681 682 683 684 685 686 687 688 689 690 691 692 693 694 695 696 697 698 699 700 701 702 703 704 705 706 707 708 709 710 711 712 713 714 715 716 717 718 719 720 721 722 723 724 725 726 727 728 729 730 731 732 733 734 735 736 737 738 739 740 741 742 743 744 745 746 747 748 749 750 751 752 753 754 755 756 757 758 759 760 761 762 763 764 765 766 767 768 769 770 771 772 773 774 775 776 777 778 779 780 781 782 783 784 785 786 787 788 789 790 791 792 793 794 795 796 797 798 799 800 801 802 803 804 805 806 807 808 809 810 811 812 813 814 815 816 817 818 819 820 821 822 823 824 825 826 827 828 829 830 831 832 833 834 835 836 837 838 839 840 841 842 843 844 845 846 847 848 849 850 851 852 853 854 855 856 857 858 859 860 861 862 863 864 865 866 867 868 869 870 871 872 873 874 875 876 877 878 879 880 881 882 883 884 885 886 887 888 889 890 891 892 893 894 895 896 897 898 899 900 901 902 903 904 905 906 907 908 909 910 911 912 913 914 915 916 917 918 919 920 921 922 923 924 925 926 927 928 929 930 931 932 933 934 935 936 937 938 939 940 941 942 943 944 945 946 947 948 949 950 951 952 953 954 955 956 957 958 959 960 961 962 963 964 965 966 967 968 969 970 971 972 973 974 975 976 977 978 979 980 981 982 983 984 985 986 987 988 989 990 991 992 993 994 995 996 997 998 999 1000 1001 1002 1003 1004 1005 1006 1007 1008 1009 1010 1011 1012 1013 1014 1015 1016 1017 1018 1019 1020 1021 1022 1023 1024 1025 1026 1027 1028 1029 1030 1031 1032 1033 1034 1035 1036 1037 1038 1039 1040 1

**Bridgewater, Connecticut**  
**June 1, 1964**

2

1. NAME \_\_\_\_\_

**SECRET**

FROM: L. D. ONE *Lee*

[REDACTED]

ALL INFORMATION CONTAINED HEREIN IS UNCLASSIFIED  
DATE 08-01-2001 BY 60322 UCBAW

[illegible]

\_\_\_\_\_



CC: L. J. Boyle	<u>A. D. Kerr</u>	H. J. Hackman	R. Pugh
R. J. Chesebrough	R. Gilbert	V. G. DeReus	J. Smyder
E. J. Mock	K. Greenlee	R. B. Hurley	
T. H. Pratt	F. Plunkett	J. Hill	
F. H. Byrnes	A. Barnes	R. Burger	
		P. Nielsen	

March 16, 1964

MODEL 600 -6MM RIFLE

MONTANA STATE CENTENNIAL ORDER

1. Schedule
  - A. Quantity ordered - 1000 6MM Rifles
  - B. Assembly to start - 4/21/64
  - C. Order to be completed - 5/15/64

2. Specification requirements for M/600 - 6MM Rifles

A. M/600 Receiver

R. Pugh

1. Special Roll - due 4/3/64  
Roll - Montana Centennial 1864 - 1964  
75th Anniversary of Statehood
2. Serial number to start with 0001.  
Planning Section to schedule total number to be rolled.
3. After Serial Number - deliver Receivers to Custom Repairs Dept. to add Symbol MC along side of Serial Number. *Prefix*

R. Pugh  
F. Plunkett

B. M/600 Stock Assembly

M/600 Stocks before "fill & lacquer" are to be delivered to the Tool Room (Dept. 21) for inletting of Stock for the Centennial medallion.

R. Chesebrough  
E. Barnes  
P. Nielsen

C. M/600 Barrel Assembly 6MM

1. New M/600 Barrel Blanks - 2" longer required.
2. M/600 Barrels 6MM - to be processed same as the Model 700 Barrels 6MM.  
Process Records to be established.

J. Smyder

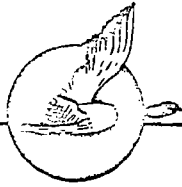
R. Burger

FHB:mc

*Can T.R. handle  
on 100+ day basis?*



# Remington



# Farms

*A.O. Kerr*

DR. J. P. LINDUSKA  
DIRECTOR OF WILDLIFE MANAGEMENT

CHESTERTOWN • MARYLAND 21620

3 Copy *Mullen*  
*Plumb*  
*Ren*

21 April 1964

*Remington*



*I haven't been able to get why I received this letter. I'll get it.*

Mr. Harvey Hackman  
Remington Arms Co., Inc.  
Ilion, New York

Dear Harvey:

The six presentation rifles (MC0001-MC0006) presented to notables at the Montana Centennial banquet on 17 April are being returned to you today by Railway Express. After substituting working bolts for the dummy bolts and performing any final adjustment and checking, these can be shipped as follows:

No. MC0006 to: The Honorable Tim Babcock  
Governor of Montana  
State Capitol Building  
Helena, Montana

(A case to accompany this gun in shipment is being sent to you by parcel post from Mr. Virgil Agostinelli in Washington, D.C.)

The five remaining rifles can all be shipped to Mr. Virgil Agostinelli (General Chairman of the Territorial Centennial dinner) at 113 Carroll Street, N.W., Washington 12, D.C. He is holding the remaining five cases and following receipt of the guns will deliver these and the cases to the offices of the Montana delegation, and will arrange through the offices of Mike Mansfield for President Johnson to receive his gun and case.

It may be helpful if shipping boxes show serial numbers and names so as to assure delivery of the correct rifles, as follows:

No. MC0001- President Johnson  
MC0002- Senator Mansfield  
MC0003- Senator Metcalf  
MC0004- Congressman Olson  
MC0005- Congressman Battin

*4/30 Ship*

*Harvey - I assume Ted McCarty expects Morgan mentioned before that the stock on one of these was broken before the banquet.*

JPL/jb

cc: Pete Morgan  
Virgil Agostinelli

Very truly yours,

J. P. Linduska  
Dir. of Public Relations  
and Wildlife Management



8  
m/600

CC: S. M. Alvis  
H. J. Hackman  
A. D. Kerr

Ilion, New York  
April 24, 1964

L. D. COX

MODEL 600, 6MM CALIBER

Sufficient commercial grade Model 600, 6mm caliber guns were assembled and tested by the plant to permit R & D to select ten (10) for confirmation testing. The results of the plant testing were considered satisfactory.

R & D completed function and accuracy testing of the ten (10) guns April 24. The function was satisfactory and the accuracy was within the 2 $\frac{1}{2}$ " specification.

Management approval to make warehouse shipments is requested.

*R. A. Williamson*  
R. A. WILLIAMSON  
WORKS MANAGER

VQDeReus:I



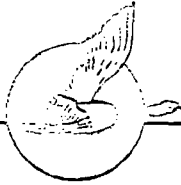
MODEL 600 CUSTOMER GUNS RETURNED  
BY COMPLAINT - MONTH RECEIVED AND YEARLY TOTAL

1964

	Jan.	Feb.	Mar.	Apr.	May	June	Jul.	Aug.	Sep.	Oct.	Nov.	Dec.	Total
Total Guns Returned:						14							
Total Complaints:													
Total Functional Complaints						4							
Ejection													
Firing													
Extraction													
Feeding													
Closing													
Bolt Binds						2							
Trigger Pull						2							
Safe													
Damaged or Blown Cases or Primers													
Ejector Binds or Stock in Bolt													
Jams, Repair, etc.													
Up to Standard (Functional)													
Total Intermediate Complaints						10							
Stock Broken, Cracked						9							
Stock Finish or Checkering													
Stock Cracked at Barrel Groove													
Accuracy (Point of Impact)													
Accuracy (Group Size)													
Bolt Handle Broken - Loose													
Sights Crooked - Tipped etc.													
Sights out of Line						1							
Scope Mounting Trouble													
Sights Broken													
Bolt Pulls Out													
Broken Steel Parts													
Trigger Guard Broken													
Up to Standard (Intermediate)													
Total Visual etc. - Complaints													
Misc. Visual Complaints													
Misc. Non-Functional													
Up to Standard (Non-Functional)													



# Remington



# Farms

*A.D. Keen*

DR. J. P. LINDUSKA  
DIRECTOR OF WILDLIFE MANAGEMENT

CHESTERTOWN • MARYLAND 21620

3 Copy *Miller*  
*Blum*  
*Ren*

21 April 1964

*Remington*

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JPL/jb

cc: Pete Morgan  
Virgil Agostinelli

Very truly yours,

*J. P. Linduska*  
J. P. Linduska  
Dir. of Public Relations  
and Wildlife Management



# A. C. ESTIMATE

ATTACHED  
K.L. Hall

TO: H.S. Hartman

ESTIMATED BY: V.G. DeRue

MODEL 600 - 6mm - Montana State Centennial PROJECT NO. \_\_\_\_\_ DATE 2/18/64

PROJECT TITLE Estimate to produce 1000 Model 600 6mm  
Caliber gung for Montana State Centennial - Receiver marking  
and coin set in stock - going to be furnished FREE

	HOURS	RATE	TOTAL
PROCESS ENGINEERING & TRIAL RUN			—
TOOL DESIGN FIXTURES - GAGES			—
TOOLING FIXTURES - GAGES			200
TOOL DESIGN — PERISHABLE TOOLS		—	—
TOOL DESIGN REVISIONS			—
PERISHABLE TOOLING			1300
TOOL REVISIONS			—
TOOL REVISIONS - PERISHABLE			—
TESTING			—
ADMINISTRATION			—
VENDOR TOOLING COSTS (DIES ETC.)			—
VENDOR TOOLING NOT REMINGTON PROPERTY			—
SUB TOTAL			1400
CONTINGENCIES			0
			1400

COMMENTS RECEIVER - Added roll marking - serial number start with  
10 0000 on other side marking roll and added machine set ups  
Stock process given to MVS by P. Hjelseth



CC: E. E. Folmsbee  
R. W. Pugh

R. Stafford

A. D. Kerr

J. Scanlon

S. M/600

February 12, 1964

MODEL 600 RECEIVER 222 CALIBER

C-1144 HIGH STRAIN TEMPERED STEEL

1. Meeting held 2/13/64 to establish the production controls required to process 7000 Model 600 Receivers (C-1144 high strain tempered steel).

2. The following were in attendance:

L. J. Boyle	H. J. Hackman	R. B. Hurley	B. Gilbert
E. J. Mock	V. G. DeReus	G. J. Hill	
F. H. Byrnes	E. R. Carr		

3. Production controls authorized

- A. Production Orders and Route Cards for the M/600 Receivers 222 Caliber (C-1144 material) are to be issued on the blue cards. B. Gilbert

1. Production departments will be responsible to maintain the Blue Route Cards with each lot of the M/600 Receivers 222 Caliber (C-1144 material). E. J. Mock

2. Planning Section to review scheduling of M/600 Receiver 222 Caliber (C-1144 material) so as to process between the M/700 Receiver runs. B. Gilbert

Proposed scheduling

- A. Process lot of 700 Receivers-Short or Long Action  
B. Process lot of M/600 Receiver 222 Cal. C-1144 material.  
C. Process lot of M/700 Receivers-Short or Long Action.

- B. Process Engineering to establish the following Cuprodine operations: E. Carr  
J. Hill

1. Oper. 4T - to follow J & L Turret Lathe operation  
2. " 22T - " " Turn & Tap Operation Group

- C. Process Engineering to establish permanent identification for the M/600 Receiver 222 Cal. (C-1144 material) J. Hill

1. Oper. 193-5T - Stamp  - Top of Tang.

- D. Production departments to correct all repair work on the M/600 Receivers 222 Cal. (C-1144 material) during the run of the Receivers. E. J. Mock



- E. M/600 Receivers 222 Cal. (C-1144 material) are not to be retained in fixtures for setup purposes.
- F. Process Engineering to order collets for the Cone Screw Machine for the processing of M/600 Receivers 222 Cal. (C-1144 material).

E.J.Mock

J.Hill

FHB:mc



## REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE

Remington



TO: HARRY HACKMAN  
FROM: GENE T. PORTER  
SUBJECT: MODEL 600 FIELD TEST

~~R. A. Williams~~  
~~C. B. Feltner~~  
~~A. D. Kutz~~  
Prairie Village, Kansas  
November 6, 1963  
R. A. Gellert

I test fired the 600 with 140 rounds of Peters and Winchester ammunition.. I was unable to test this rifle for accuracy; however, I did give it a normal function test.

This rifle functioned perfectly and to my surprise it did not have excessive muzzle blast. The recoil was not comfortable; however, normal. I was shooting at inanimate targets and recoil always appears greater to me when shooting at this type target..

I like the feel of this rifle and it "comes up good".. The top of the stock seemed sharp to me cheek; however, it did not mark my face.. The vent rib gives it a distinctive appearance and I like it; however, the rib seems flimsy and I question the accuracy of the sights when the rib gets good and hot.

A small black tip on the fore-end would make it a real stand out.

Would it be possible to dull the trigger guard? If it had a sand blasted appearance I feel it would be more acceptable to consumers.

In Southern Missouri and North Arkansas this rifle should be well accepted.. Price is, of course, very important..



**REMINGTON ARMS COMPANY, INC.**

INTER-DEPARTMENTAL CORRESPONDENCE

*Remington*  
REMINGTON*PETERS*  
PETERS

*A.D. Kern*  
cc: G.M. Calhoun  
R. A. Williamson  
W. E. Leek - File

**"CONFINE YOUR LETTER TO ONE SUBJECT ONLY"**

Ilion, New York  
October 29, 1963

**H. J. HACKMAN****MODEL 600 FIELD TEST RIFLES**

I have informed F.E. Morgan of results of our field test with selected shooters and rifles. Also, that we have recommended you proceed to plan on shipping these rifles without further changes to the stocks, on assumption that our test samples were representative.

On this basis we should forego any alterations pending results of the Sales field test as well as R&D pilot testing which is now in progress.

*SMA*  
S. M. Alvis  
Ilion Research Division

**SMA:T**



cc: R.A. Williamson  
H.J. Hackman) In  
V.G. DeReus ) turn  
A.D. Kerr - R.C. Gilbert  
A.J. Seckner ) In  
J.J. Phillips) turn  
Estimate File #2427

Ilion, New York  
February 19, 1964

H. K. FAULKNER  
ATTENTION: C. L. JONES (2)

ESTIMATED FACTORY COST - MODEL 600, 6MM CALIBER  
WITH STOCK MEDALLION FOR MONTANA STATE CENTENNIAL

In accordance with a recent request, estimated costs have been developed for the manufacture of 1,000 guns as described in the above subject.

Costs have been added to cover proper installation of the Centennial Medallion to be furnished by the State of Montana and changes in the Receiver markings.

The estimated full factory cost less tooling charges is \$42.00 per gun. Tooling charges, including new Receiver marking rolls, will total \$1,400. Amortizing these charges over the 1,000 guns will amount to \$1.40 per gun.

The total estimated cost with tooling is \$43.40. For comparison, current estimates for regular commercial grade 6 mm caliber indicate a cost of \$42.39 per gun.

R. A. Williamson  
Works Manager

*R. L. Hall*

R. L. Hall, Supervisor  
Methods & Standards Section

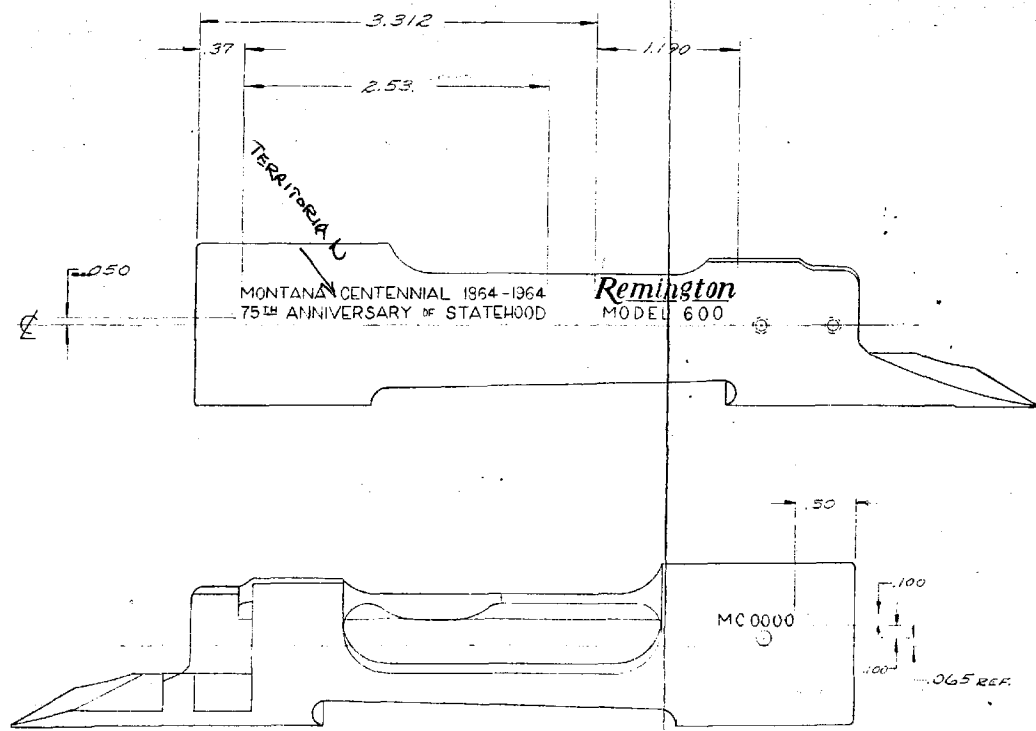
RFKerr:sm

NOTE TO C. L. JONES:

Two sample stocks are being held by R. C. Gilbert, Ilion, awaiting Bridgeport instructions for disposition.



UNLESS OTHERWISE SPECIFIED  
REMOVE ALL BURRS AND  
SHARP CORNERS .010R



DETAIL NO.	MATERIAL SPEC.	STOCK SIZE	AMOUNT REQ.
TOLERANCES NOT OTHERWISE GIVEN			
1 PLACE (.1) - TOLERANCE ± .08			
2 PLACE (.01) - TOLERANCE ± .015			
3 PLACE (.001) - TOLERANCE ± .0005			
RECORD OF ALTERATIONS			
ADDITIONAL USES			
CONST. N. DWG.			
DETAILS			
TOOL			
OPERATION			
DESIGNED	BY	DATE	APPROVED
DRAWN			SUPD'S DWG. NO.
CHECKED			DRAWING NO.

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER  
KINZER V. REMINGTON

R2528581



FEB 6 1964

FE

FEB 6 1964



for project economic

m/600

1st

2nd

7500

15000

308 7500

222

5000

4000

30.30

6000

5/1 whse.



## REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE

Gail Evans  
W. H. Foster  
F. E. MorganBridgeport, Conn.  
April 23, 1963Mary:  
Copies below, also RemingtonDEM  
SMA-WFL  
HJM-VCD  
AVB-SMAShip - Labels - 306  
222  
35 Rem  
Please note.  
A  
JEDTO: DEAN COX

FROM: J. E. DICKEY

SUBJECT: AMMUNITION CALIBERS FOR THE MODEL 600 RIFLE

This is to advise that the third caliber to be used in the new Model 600 rifle will be the Remington 222 cartridge and not the Remington 222 Magnum.

The 222 cartridge sells approximately 5-times the volume than the 222 Magnum and the 222 cartridge is approximately 10% less in cost.

It will be appreciated if you will advise the necessary people of this decision.

JED

JED:M



RD-6514

9:30 Friday

1/9/63

PARTS LIST		MODEL 600 Bolt Action - Center Fire Rifle		DATE 6-15-62	
*Parts Not Common To Any Other Model				Sheet 1 of 2 sheets	
D'W'G. NO.	PART NO.	NAME	No. Reqd.	IN Row	Row
D-26680*		BARREL ASSEMBLY	0	0	
D-26690*		Barrel (Marking B-15729)	0	0	
B-15279		Barrel Bracket	0	0	
B-15724		Barrel Stud	0	0	
D-15406*		Receiver (Marking B-15482)	0	0	
N-26700*		BOLT FINAL ASSEMBLY	0	0	
D-26705*		BOLT ASSEMBLY	0	0	
D-26710*		BOLT BODY ASSEMBLY	0	0	
C-15407		Bolt Body	0	0	
A-18493		Bolt Body Brazing Slug	0	0	
C-15479		Bolt Head	0	0	
A-18758		Bolt Pin	0	0	
B-17011		Ejector Washer	0	0	
D-15408		Bolt Handle	0	0	
A-20185	20186	Brazing Shim	0	0	
A-17017		Ejector	0	0	
A-17676		Ejector Pin	0	0	
A-17019		Ejector Spring	0	0	
B-16254		Extractor	0	0	
A-19629		Extractor Rivet	0	0	
N-26715		FIRING PIN ASSEMBLY	0	0	
C-15409		Bolt Plug	0	0	
B-15410		Firing Pin	0	0	
A-17022		Firing Pin Cross Pin	0	0	
B-23320	23321	Firing Pin Head	0	0	
A-15411		Main Spring	0	0	
C-15412*		Bolt Stop	525	0	complete
A-15413		Bolt Stop Spring	0	0	
B-24475	24477	Bolt Stop Pin	0	0	
B-15414*		Front Guard Screw	500	2200	complete
B-27365*		FRONT SIGHT ASSEMBLY	0	0	
B-15754*		Front Sight	5350	0	order 700 to complete
A-15755*		Front Sight Bead	0	5100	
B-27260*		MAGAZINE ASSEMBLY	0	0	
C-15433*		Magazine	0	0	
A-15743*		Magazine Support	540	0	completed
B-15416		Magazine Support Screw	0	0	
C-17056		Magazine Follower	0	0	
C-17891		Magazine Spring	0	0	
A-17580		Rear Guard Screw	0	0	
Prepared By		HLC	Approved By		WEL



RD-6514

1/9/63

PARTS LIST	MODEL 600		DATE		
	Bolt Action - Center Fire Rifle		6-15-62		
*Parts Not Common To Any Other Model			Sheet 2 of 2 sheets		
D'W'G. NO.	PART NO.	NAME	No. Reqd.	IN PROG.	RAW STOCKS
C-26840	26841	REAR SIGHT ASSEMBLY		—	—
A-15733		Elevation Screw		—	—
C-15727		Rear Sight Base		—	—
C-15726*		Rear Sight Eyepiece		500	0
C-15728		Rear Sight Leaf		—	—
B-15732		Windage Screw		—	—
A-15734		Windage Screw Lock Washer		—	—
A-15418		Rear Sight Nut		—	—
A-17034		Receiver Plug Screw	5	—	—
D-15488*		Rib		0	0
B-15417		Rib Screw	4	—	—
B-24475	24476	Sear Pin	2	—	—
B-15416		Sight Screw	4	—	—
E-15426*		Stock		0	0
D-15741*		Butt Plate		0	0
C-25410		Butt Plate Screw	2	—	—
C-26795		SAFETY ASSEMBLY		—	—
C-15430		Safety		—	—
C-15453		Safety Thumbpiece		—	—
A-26850		Safety Detent Ball		—	—
B-15432		Safety Detent Spring		—	—
A-17043		Safety Pivot Pin		—	—
A-17044		Safety Snap Washer		—	—
D-26730		TRIGGER ASSEMBLY		—	—
C-15429*		Housing (Blank C-15745)		500	0
N-26590		SEAR & SAFETY CAM ASSEMBLY		—	—
B-15369		Safety Cam (Blank 1B-17945)		—	—
2B-17946		Sear (Blank 1B-17945)		—	—
A-17047		Sear Spring		—	—
C-15435*		Trigger		500	0
A-17049		Trigger Adjusting Screw	2	—	—
A-15436*		Trigger Connector		500	0
B-24475	24477	Trigger Pin		—	—
A-17978		Trigger Spring		—	—
B-17053		Trigger Stop Screw		—	—
D-15437		Trigger Guard		—	—
Prepared By HLC			Approved By WEL		



cc: D.E. Miller  
S.M. Alvis  
H.J. Hackman) In  
V.G. DeReus ) turn  
A.D. Kerr  
Estimate File #2243

Ilion, New York  
March 13, 1962

W. E. LEEK

COST COMPARISON - PROPOSED MODEL XC-13 STOCK  
WITH AND WITHOUT FORE END TIP AND SPACER

At your request, estimated Factory Costs have been developed for producing the above mentioned Stock with and without a Fore End tip and spacer.

Estimated costs for the Stock with a Fore End tip are based on procuring a tip comparable in cost to that being purchased for the Model 700 BDL. Costs for the Stock without a Fore End tip are based on quotes recently confirmed by our wood supplier for a blank 2 3/4" longer than our regular 500 Series blank.

Estimated costs as indicated on the attached sheet are as follows:

	<u>Stock with F.E.</u> <u>Tip and Spacer</u>	<u>Stock without F.E.</u> <u>Tip and Spacer</u>
Standard Material	\$ 1.68 Each	\$ 1.50 Each
Standard Labor	.88 "	.83 "
Total Factory (Full Book)	6.89 "	6.31 "
Tool Charges (Plant and Vendor)	\$ 4,000	-

Tool charges for plant operations are based on project estimates prepared by Process Engineering. Charges paid for the Model 700 BDL Fore End tip mold were used as a guide in developing vendor tooling estimates.

R. L. Hall, Supervisor  
Methods & Standards Section

  
R. F. Kerr

Att.  
RFKerr:sm







cc: D.E. Miller  
L.D. Cox  
S.M. Alvis  
M.H. Walker  
H.J. Hackman) In  
V.G. DeReus ) turn  
A.D. Kerr  
Estimate File #2243

March 27, 1962

W. E. LEEK

**COST COMPARISON - PROPOSED M/600 (XC-13) STOCK-  
VARIOUS FORE END TIPS versus NO FORE END TIP**  
Reference: Letter RLHall to WELeak dated 3-13-62

In our previous letter regarding the subject material, estimated costs were shown for a stock with and without fore end tip and spacer, similar to that adapted for our M/700 barrel. Since receipt of this information, you have requested stock costs with tips fabricated from raw and scrap nylon.

In response to your request, additional estimates have been prepared and for your information, these and those outlined in our letter dated March 13th, are listed below.

	<u>Regular 500 Series Blank &amp; M/700 BDL Type Fore End Tip</u>	<u>Regular 500 Blank &amp; Remington Molded Raw Nylon Fore End Tip</u>	<u>Regular 500 Blank &amp; Remington Molded Scrap Nylon Fore End Tip</u>	<u>2 3/4" Longer Blank and No Fore End Tip</u>
Standard Material	\$ 1.68	\$ 1.31	\$ 1.30	\$ 1.50
Standard Labor	.88	.88	.88	.83
Total Factory Cost (Full Book)	6.80	6.36	6.35	6.31
Tool Charges	\$ 4,000	\$10,000	\$10,000	—

All of the above costs for stocks with tip include a fore end tip spacer.

Regarding your inquiry concerning the butt plate for the gun in question, we wish to advise that hi-spot estimates indicate a reduction of approximately \$.04 each in standard material if scrap nylon is used.

R. L. Hall, Supervisor  
Methods & Standards Section

*R. F. Kerr*  
R. F. Kerr

RFKerr:sm



M

M/600 - Barrel Bracket



Oct. 21, 1964

RESPONSIBILITYMODEL 600350 Remington Magnum

The chamber tooling was released for procurement July 8. The Federal master ring gages are now promised October 23.

Purchasing

In tryout of the turning operation, it was found that the Barrel blanks which had been held did not clean up. It will be necessary to start a new pilot quantity.

Planning

A new turning template for the Barrel blank has been designed and released to the toolroom.

Works Eng.

Process Engineering is to release TDR's for the balance of the Barrel changes. Also, Process Engineering is to investigate the conversion of a set of 410 gauge New Britain collet pads to handle the 350 Remington Magnum. If the alteration is not possible, it is indicated that it will take approximately six (6) weeks to purchase new pads.

Process Eng.

The alterations to the tool design for the Stock have been completed. Orders have been released to the toolroom.

Works Eng.

Planning is to request R & D to fabricate the nylon inserts required for the 350 caliber production.

Planning

A vise jaw and cutter to alter the Barrel Bracket for the 350 caliber should be completed next week.

Works Eng.

The use of the new Barrel Bracket for all Model 600 guns will increase the full book cost five cents per gun. Problems of finishing the Barrel Bracket were discussed. It is possible that equipment could be designed to reduce the finishing costs.

N. P. Process  
R & D



Nov. 5, 1964

RESPONSIBILITY350 Remington Magnum - contd.

Model 600 Barrel and Receiver Assemblies with the new bracket will be available for appearance review by the end of the week.

Note: Instructions were received from R & D for the present to limit the use of the new Barrel Bracket to the 350 Remington Magnum caliber.

The tooling to alter the Barrel Brackets for the 350 Remington Magnum caliber has been completed.

Production

Production

Trigger Guard Screws were received November 3.

N. P. Process

Production reported that Bolt Assembly operations are being performed as time is available.

Production

R & D will release the additional changes to the Magazine and Magazine Follower November 4.

R &amp; D

Dummy and proof ammunition has been received. 250 grain test ammunition has not been received.

Prod. Testing

Bolt - Receiver

A letter has been written to R & D advising that the elimination of the gas hole in the Bolt and Receiver requires Sales and Legal approval. It is indicated that the R & D tests show the gas escape holes in the Bolt and Receiver are not functional in case of blowup. Before removal, however, information is to be furnished and Sales and Legal approval obtained.

R &amp; D

243 Caliber

Twelve (12) model guns assembled by the plant are being tested for function and accuracy. Information should be available for review at the November 10 Operations Committee meeting. Sales is proposing the addition of this caliber to the line for 1965.

Process Eng.



Nov. 11, 1964

RESPONSIBILITY

MODEL 600

350 Remington Magnum

The chamber tooling was released for procurement July 8. The Federal master ring gages are now promised for shipment November 12 and 13.

Purchasing

Pilot Barrel production can start. The turning former has been completed. Barrel blanks can be processed to "chamber."

Production

The tooling to inlet the Stocks should be completed by the end of the week.

Production

R & D is revising the model drawings for the Delrin Receiver Insert to specify use for only the 350 Remington Magnum rifles.

R & D

Trigger Guards have been molded and a quantity set aside for pilot assembly.

Production

It is considered advisable to limit the use of the new Barrel Bracket to the 350 Remington Magnum caliber for the present. Planning should take steps to obtain sufficient quantities of the old style Barrel Bracket to maintain production through the first quarter of 1965 to allow time to determine field reaction.

Planning

The tooling to alter the Barrel Brackets for the 350 Remington Magnum caliber has been completed.

Production

Trigger Guard Screws are being inspected.

N. P. Process

Production reported that Bolt Assembly operations are being performed as time is available.

Production



# PROCESS ENGINEERING ASSIGNMENTS

Job Description:

M/600 - Bbl. Assy. - 350 Map.

Oper. 5 - Assemble, etc.

Follow through assembly operation.

Area Engineer:

Purger

Sheet No.: 1

Job No.: 2376-B3

Job Priority:

A-3

Job Code:

9

Model:

600

Part Name:

Bbl. Assy.

Oper. No.:

5

Dept. No.:

58

Est. Comp. Mo/Yr:

Est. Comp. Hours:

Assigned By:

Date:

Est. Savings:

Report Date

Elapsed Hrs.

Accomplishments

12-17-64

12

The barrel brackets on the 350 have to be carefully centered because of their form. The 2° draft angles had to be altered by hand and the bracket top had to be marked by hand and assembled by eye for centrality. Another method is being investigated.

1-18-65

6

NEW BATCH OF BRACKETS WERE MILLED MORE ACCURATELY. THE MODIFIED WRENCH WAS USED BUT IT HAD TOO MUCH GIVE IN IT. A SHIM WAS USED TO COMPENSATE FOR THE SPRINGINESS. ~~THE~~ THE WRENCH ~~MUST~~ MUST BE CHANGED TO REFLECT THIS.

RD - 6566 2/1/63



CC: L. J. Boyle  
T. H. Pratt  
L. Fox  
H. L. Wright  
F. H. Byrnes

A. D. Kerr  
A. Greenlee  
B. Gilbert

L. J. Mackman  
V. G. DeRous  
H. B. Hurley

A. L. Hall

February 10, 1965

MODEL 600 BARREL BRACKET

In accordance with the Steering Committee authorization, the revised Model 600 Barrel Brackets are to be used on all M/600 Barrel and Receiver Assemblies, effective 2/10/65.

M/600 Barrel Brackets, with the clearance angles on the bottom, are to be used for M/600 Rifles 350 Caliber only.

FHB:mc



M/600 - Receiver



## REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE

cc: J. E. Preiser  
C. B. Workman

Remington



Jill Under

May 11, 1978

TO: J. P. LINDE

FROM: H. D. ALBAUGH

MOHAWK 600 RECEIVER TANG

Confirming our conversation of yesterday on the above subject, Marketing has agreed to accept your proposal to change the current receiver tang to the Model 700 type. A sample of the new type was illustrated in a carbine sample now under evaluation here at Bridgeport. By copy of this letter, I am also advising C. B. Workman of this decision and ask that he make R & D's feelings known before the process is changed.

HDA/ag

5/21/78 - Larry Marketing Samples - copy of letter to Preiser



cc: R.L. Hall  
L. Fox  
F.H. Byrnes  
J.L. Snyder  
E.R. Carr  
Capacity File CS-62

April 30, 1971

L. J. BOYLE

MOHAWK 600 - 700 RECEIVER LINE

Elimination of the Mohawk 600 from the Receiver Line would result in a gross annual savings of \$7,600. (Based on #2-1971 Production Forecast)

Overtime premium	\$ 3,750
Shift Bonus	1,400
Change-over	2,450
	<hr/>
Total	\$ 7,600

F. G. Carlson, Superintendent  
Methods & Standards Section

*RJ Long*

By: R. J. Long, Group Leader

RJL:sm




CC: S. P. Cross  
L. Fox  
R. L. Hall

J. L. Smyder  
R. L. Stafford  
N. S. Thompson  
File

March 29, 1971

E. R. CARR

  
M/600, 308 Cal. - Receiver

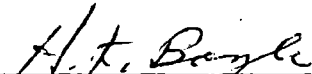
Operation 68 - Tri-ordinate # 1

Reference: 50 Demerit M/600, 222 Cal., Stems chamber,  
of 3/23/71.

Attached is a partial machine study on pertinent characteristics  
of the Magazine opening which are believed associated with the  
referenced 50 demerit item.

The measurements indicate that an uncontrollable condition  
currently exists.

by

  
H. K. Boyle, Supervisor  
Quality Control Department

HKB/bd  
Attachs.



[illegible]

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Year	1970	1971	1972	1973	1974	1975	1976	1977	1978	1979	1980	1981	1982	1983	1984	1985	1986	1987	1988	1989	1990	1991	1992	1993	1994	1995	1996	1997	1998	1999	2000	2001	2002	2003	2004	2005	2006	2007	2008	2009	2010	2011	2012	2013	2014	2015	2016	2017	2018	2019	2020	2021	2022	2023	2024	2025	2026	2027	2028	2029	2030	2031	2032	2033	2034	2035	2036	2037	2038	2039	2040	2041	2042	2043	2044	2045	2046	2047	2048	2049	2050	2051	2052	2053	2054	2055	2056	2057	2058	2059	2060	2061	2062	2063	2064	2065	2066	2067	2068	2069	2070	2071	2072	2073	2074	2075	2076	2077	2078	2079	2080	2081	2082	2083	2084	2085	2086	2087	2088	2089	2090	2091	2092	2093	2094	2095	2096	2097	2098	2099	2100
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Year	1950	1951	1952	1953	1954	1955	1956	1957	1958	1959	1960	1961	1962	1963	1964	1965	1966	1967	1968	1969	1970	1971	1972	1973	1974	1975	1976	1977	1978	1979	1980	1981	1982	1983	1984	1985	1986	1987	1988	1989	1990	1991	1992	1993	1994	1995	1996	1997	1998	1999	2000	2001	2002	2003	2004	2005	2006	2007	2008	2009	2010	2011	2012	2013	2014	2015	2016	2017	2018	2019	2020	2021	2022	2023	2024	2025	2026	2027	2028	2029	2030	2031	2032	2033	2034	2035	2036	2037	2038	2039	2040	2041	2042	2043	2044	2045	2046	2047	2048	2049	2050	2051	2052	2053	2054	2055	2056	2057	2058	2059	2060	2061	2062	2063	2064	2065	2066	2067	2068	2069	2070	2071	2072	2073	2074	2075	2076	2077	2078	2079	2080	2081	2082	2083	2084	2085	2086	2087	2088	2089	2090	2091	2092	2093	2094	2095	2096	2097	2098	2099	2100																			
Population	1,000,000	1,050,000	1,100,000	1,150,000	1,200,000	1,250,000	1,300,000	1,350,000	1,400,000	1,450,000	1,500,000	1,550,000	1,600,000	1,650,000	1,700,000	1,750,000	1,800,000	1,850,000	1,900,000	1,950,000	2,000,000	2,050,000	2,100,000	2,150,000	2,200,000	2,250,000	2,300,000	2,350,000	2,400,000	2,450,000	2,500,000	2,550,000	2,600,000	2,650,000	2,700,000	2,750,000	2,800,000	2,850,000	2,900,000	2,950,000	3,000,000	3,050,000	3,100,000	3,150,000	3,200,000	3,250,000	3,300,000	3,350,000	3,400,000	3,450,000	3,500,000	3,550,000	3,600,000	3,650,000	3,700,000	3,750,000	3,800,000	3,850,000	3,900,000	3,950,000	4,000,000	4,050,000	4,100,000	4,150,000	4,200,000	4,250,000	4,300,000	4,350,000	4,400,000	4,450,000	4,500,000	4,550,000	4,600,000	4,650,000	4,700,000	4,750,000	4,800,000	4,850,000	4,900,000	4,950,000	5,000,000	5,050,000	5,100,000	5,150,000	5,200,000	5,250,000	5,300,000	5,350,000	5,400,000	5,450,000	5,500,000	5,550,000	5,600,000	5,650,000	5,700,000	5,750,000	5,800,000	5,850,000	5,900,000	5,950,000	6,000,000	6,050,000	6,100,000	6,150,000	6,200,000	6,250,000	6,300,000	6,350,000	6,400,000	6,450,000	6,500,000	6,550,000	6,600,000	6,650,000	6,700,000	6,750,000	6,800,000	6,850,000	6,900,000	6,950,000	7,000,000	7,050,000	7,100,000	7,150,000	7,200,000	7,250,000	7,300,000	7,350,000	7,400,000	7,450,000	7,500,000	7,550,000	7,600,000	7,650,000	7,700,000	7,750,000	7,800,000	7,850,000	7,900,000	7,950,000	8,000,000	8,050,000	8,100,000	8,150,000	8,200,000	8,250,000	8,300,000	8,350,000	8,400,000	8,450,000	8,500,000	8,550,000	8,600,000	8,650,000	8,700,000	8,750,000	8,800,000	8,850,000	8,900,000	8,950,000	9,000,000	9,050,000	9,100,000	9,150,000	9,200,000	9,250,000	9,300,000	9,350,000	9,400,000	9,450,000

Year	1980	1981	1982	1983	1984	1985	1986	1987	1988	1989	1990	1991	1992	1993	1994	1995	1996	1997	1998	1999	2000	2001	2002	2003	2004	2005	2006	2007	2008	2009	2010	2011	2012	2013	2014	2015	2016	2017	2018	2019	2020	2021	2022	2023	2024	2025	2026	2027	2028	2029	2030	2031	2032	2033	2034	2035	2036	2037	2038	2039	2040	2041	2042	2043	2044	2045	2046	2047	2048	2049	2050	2051	2052	2053	2054	2055	2056	2057	2058	2059	2060	2061	2062	2063	2064	2065	2066	2067	2068	2069	2070	2071	2072	2073	2074	2075	2076	2077	2078	2079	2080	2081	2082	2083	2084	2085	2086	2087	2088	2089	2090	2091	2092	2093	2094	2095	2096	2097	2098	2099	2100
1980	1980	1981	1982	1983	1984	1985	1986	1987	1988	1989	1990	1991	1992	1993	1994	1995	1996	1997	1998	1999	2000	2001	2002	2003	2004	2005	2006	2007	2008	2009	2010	2011	2012	2013	2014	2015	2016	2017	2018	2019	2020	2021	2022	2023	2024	2025	2026	2027	2028	2029	2030	2031	2032	2033	2034	2035	2036	2037	2038	2039	2040	2041	2042	2043	2044	2045	2046	2047	2048	2049	2050	2051	2052	2053	2054	2055	2056	2057	2058	2059	2060	2061	2062	2063	2064	2065	2066	2067	2068	2069	2070	2071	2072	2073	2074	2075	2076	2077	2078	2079	2080	2081	2082	2083	2084	2085	2086	2087	2088	2089	2090	2091	2092	2093	2094	2095	2096	2097	2098	2099	2100

[illegible]

Year	1950	1951	1952	1953	1954	1955	1956	1957	1958	1959	1960	1961	1962	1963	1964	1965	1966	1967	1968	1969	1970	1971	1972	1973	1974	1975	1976	1977	1978	1979	1980	1981	1982	1983	1984	1985	1986	1987	1988	1989	1990	1991	1992	1993	1994	1995	1996	1997	1998	1999	2000	2001	2002	2003	2004	2005	2006	2007	2008	2009	2010	2011	2012	2013	2014	2015	2016	2017	2018	2019	2020	2021	2022	2023	2024	2025	2026	2027	2028	2029	2030	2031	2032	2033	2034	2035	2036	2037	2038	2039	2040	2041	2042	2043	2044	2045	2046	2047	2048	2049	2050	2051	2052	2053	2054	2055	2056	2057	2058	2059	2060	2061	2062	2063	2064	2065	2066	2067	2068	2069	2070	2071	2072	2073	2074	2075	2076	2077	2078	2079	2080	2081	2082	2083	2084	2085	2086	2087	2088	2089	2090	2091	2092	2093	2094	2095	2096	2097	2098	2099	2100
1950	1951	1952	1953	1954	1955	1956	1957	1958	1959	1960	1961	1962	1963	1964	1965	1966	1967	1968	1969	1970	1971	1972	1973	1974	1975	1976	1977	1978	1979	1980	1981	1982	1983	1984	1985	1986	1987	1988	1989	1990	1991	1992	1993	1994	1995	1996	1997	1998	1999	2000	2001	2002	2003	2004	2005	2006	2007	2008	2009	2010	2011	2012	2013	2014	2015	2016	2017	2018	2019	2020	2021	2022	2023	2024	2025	2026	2027	2028	2029	2030	2031	2032	2033	2034	2035	2036	2037	2038	2039	2040	2041	2042	2043	2044	2045	2046	2047	2048	2049	2050	2051	2052	2053	2054	2055	2056	2057	2058	2059	2060	2061	2062	2063	2064	2065	2066	2067	2068	2069	2070	2071	2072	2073	2074	2075	2076	2077	2078	2079	2080	2081	2082	2083	2084	2085	2086	2087	2088	2089	2090	2091	2092	2093	2094	2095	2096	2097	2098	2099	2100	

Year	1960	1961	1962	1963	1964	1965	1966	1967	1968	1969	1970	1971	1972	1973	1974	1975	1976	1977	1978	1979	1980	1981	1982	1983	1984	1985	1986	1987	1988	1989	1990	1991	1992	1993	1994	1995	1996	1997	1998	1999	2000	2001	2002	2003	2004	2005	2006	2007	2008	2009	2010	2011	2012	2013	2014	2015	2016	2017	2018	2019	2020	2021	2022	2023	2024	2025	2026	2027	2028	2029	2030	2031	2032	2033	2034	2035	2036	2037	2038	2039	2040	2041	2042	2043	2044	2045	2046	2047	2048	2049	2050	2051	2052	2053	2054	2055	2056	2057	2058	2059	2060	2061	2062	2063	2064	2065	2066	2067	2068	2069	2070	2071	2072	2073	2074	2075	2076	2077	2078	2079	2080	2081	2082	2083	2084	2085	2086	2087	2088	2089	2090	2091	2092	2093	2094	2095	2096	2097	2098	2099	2100
1960	1961	1962	1963	1964	1965	1966	1967	1968	1969	1970	1971	1972	1973	1974	1975	1976	1977	1978	1979	1980	1981	1982	1983	1984	1985	1986	1987	1988	1989	1990	1991	1992	1993	1994	1995	1996	1997	1998	1999	2000	2001	2002	2003	2004	2005	2006	2007	2008	2009	2010	2011	2012	2013	2014	2015	2016	2017	2018	2019	2020	2021	2022	2023	2024	2025	2026	2027	2028	2029	2030	2031	2032	2033	2034	2035	2036	2037	2038	2039	2040	2041	2042	2043	2044	2045	2046	2047	2048	2049	2050	2051	2052	2053	2054	2055	2056	2057	2058	2059	2060	2061	2062	2063	2064	2065	2066	2067	2068	2069	2070	2071	2072	2073	2074	2075	2076	2077	2078	2079	2080	2081	2082	2083	2084	2085	2086	2087	2088	2089	2090	2091	2092	2093	2094	2095	2096	2097	2098	2099	2100	

[illegible]

This image shows a vertical strip of a document page, likely a ledger or table. The page features a grid pattern with horizontal and vertical lines. There are handwritten entries in the cells, including numbers and text. A large, dark, irregular mark or smudge is visible in the center of the page, obscuring some of the grid and text. The overall appearance is that of a scanned document with some physical damage or artifacts.

[illegible]

日期	星期	天气	温度	风向	风速	湿度	气压	能见度	云量	降水	日照	蒸发	土壤湿度	土壤温度	植物生长	动物活动	其他
1950年	1月	1日	晴	北	2	65	1013	10	10	0	8	1.2	15	5	开始发芽	开始活动	
2日	晴	北	3	60	1012	10	10	0	8	0	10	1.5	10	继续发芽	继续活动		
3日	晴	北	4	55	1011	10	10	0	8	0	12	1.8	5	发芽增多	活动频繁		
4日	晴	北	5	50	1010	10	10	0	8	0	14	2.0	0	大部分发芽	活动正常		
5日	晴	北	6	45	1009	10	10	0	8	0	16	2.2	0	发芽完成	活动正常		
6日	晴	北	7	40	1008	10	10	0	8	0	18	2.4	0	发芽完成	活动正常		
7日	晴	北	8	35	1007	10	10	0	8	0	20	2.6	0	发芽完成	活动正常		
8日	晴	北	9	30	1006	10	10	0	8	0	22	2.8	0	发芽完成	活动正常		
9日	晴	北	10	25	1005	10	10	0	8	0	24	3.0	0	发芽完成	活动正常		
10日	晴	北	11	20	1004	10	10	0	8	0	26	3.2	0	发芽完成	活动正常		
11日	晴	北	12	15	1003	10	10	0	8	0	28	3.4	0	发芽完成	活动正常		
12日	晴	北	13	10	1002	10	10	0	8	0	30	3.6	0	发芽完成	活动正常		
13日	晴	北	14	5	1001	10	10	0	8	0	32	3.8	0	发芽完成	活动正常		
14日	晴	北	15	0	1000	10	10	0	8	0	34	4.0	0	发芽完成	活动正常		
15日	晴	北	16	0	999	10	10	0	8	0	36	4.2	0	发芽完成	活动正常		
16日	晴	北	17	0	998	10	10	0	8	0	38	4.4	0	发芽完成	活动正常		
17日	晴	北	18	0	997	10	10	0	8	0	40	4.6	0	发芽完成	活动正常		
18日	晴	北	19	0	996	10	10	0	8	0	42	4.8	0	发芽完成	活动正常		
19日	晴	北	20	0	995	10	10	0	8	0	44	5.0	0	发芽完成	活动正常		
20日	晴	北	21	0	994	10	10	0	8	0	46	5.2	0	发芽完成	活动正常		
21日	晴	北	22	0	993	10	10	0	8	0	48	5.4	0	发芽完成	活动正常		
22日	晴	北	23	0	992	10	10	0	8	0	50	5.6	0	发芽完成	活动正常		
23日	晴	北	24	0	991	10	10	0	8	0	52	5.8	0	发芽完成	活动正常		
24日	晴	北	25	0	990	10	10	0	8	0	54	6.0	0	发芽完成	活动正常		
25日	晴	北	26	0	989	10	10	0	8	0	56	6.2	0	发芽完成	活动正常		
26日	晴	北	27	0	988	10	10	0	8	0	58	6.4	0	发芽完成	活动正常		
27日	晴	北	28	0	987	10	10	0	8	0	60	6.6	0	发芽完成	活动正常		
28日	晴	北	29	0	986	10	10	0	8	0	62	6.8	0	发芽完成	活动正常		
29日	晴	北	30	0	985	10	10	0	8	0	64	7.0	0				


姓名	性别	年龄	籍贯	民族	文化程度	职业	婚姻	子女	健康状况	宗教信仰	政治面貌	特长	其他
王德胜	男	45	山东	汉族	高中	教师	已婚	2	良好	无	党员	书法	
李小红	女	38	河南	汉族	初中	工人	已婚	1	良好	无	群众	唱歌	
张建国	男	52	江苏	汉族	大学	医生	已婚	3	良好	无	党员	游泳	
刘小芳	女	41	四川	汉族	小学	农民	已婚	2	良好	无	群众	跳舞	
陈伟强	男	35	广东	汉族	高中	学生	未婚	0	良好	无	团员	篮球	
赵小梅	女	48	湖南	汉族	初中	工人	已婚	1	良好	无	群众	做饭	
孙志强	男	55	浙江	汉族	大学	教授	已婚	2	良好	无	党员	研究	
周小华	女	32	湖北	汉族	高中	教师	已婚	1	良好	无	党员	写作	
吴大伟	男	40	安徽	汉族	初中	工人	已婚	2	良好	无	群众	修理	
郑小丽	女	36	江西	汉族	小学	农民	已婚	1	良好	无	群众	种田	
冯国强	男	50	福建	汉族	大学	工程师	已婚	2	良好	无	党员	设计	
马小娟	女	43	广西	汉族	初中	工人	已婚	1	良好	无	群众	缝纫	
徐志强	男	39	山西	汉族	高中	学生	未婚	0	良好	无	团员	运动	
黄小芳	女	46	陕西	汉族	小学	农民	已婚	2	良好	无	群众	家务	
曹伟强	男	51	甘肃	汉族	大学	教授	已婚	1	良好	无	党员	研究	
周小梅	女	34	宁夏	汉族	初中	工人	已婚	1	良好	无	群众	做饭	
吴大伟	男	44	青海	汉族	高中	学生	未婚	0	良好	无	团员	运动	
郑小丽	女	42	四川	汉族	小学	农民	已婚	2	良好	无	群众	种田	
冯国强	男	49	湖南	汉族	大学	工程师	已婚	1	良好	无	党员	设计	
马小娟	女	37	湖北	汉族	初中	工人	已婚	1	良好	无	群众	缝纫	
徐志强	男	38	广东	汉族	高中	学生	未婚	0	良好	无	团员	运动	
黄小芳	女	47	广西	汉族	小学	农民	已婚	2	良好	无	群众	家务	
曹伟强	男	53	陕西	汉族	大学	教授	已婚	1	良好	无	党员	研究	
周小梅	女	33	甘肃	汉族	初中	工人	已婚	1	良好	无	群众	做饭	
吴大伟	男	43	宁夏	汉族	高中	学生	未婚	0	良好	无	团员	运动	
郑小丽	女	41	青海	汉族	小学	农民	已婚	2	良好	无	群众	种田	
冯国强	男	50	四川	汉族	大学	工程师	已婚	1	良好	无	党员	设计	
马小娟	女	36	湖南	汉族	初中	工人	已婚	1	良好	无	群众	缝纫	
徐志强	男	37	广东	汉族	高中	学生	未婚	0	良好	无	团员	运动	
黄小芳	女	46	广西	汉族	小学	农民	已婚	2	良好	无	群众	家务	
曹伟强	男	52	陕西	汉族	大学	教授	已婚	1	良好	无	党员	研究	
周小梅	女	32	甘肃	汉族	初中	工人	已婚	1	良好	无	群众	做饭	
吴大伟	男	42	宁夏	汉族	高中	学生	未婚	0	良好	无	团员	运动	
郑小丽	女	40	青海	汉族	小学	农民	已婚	2	良好	无	群众	种田	
冯国强	男	49	四川	汉族	大学	工程师	已婚	1	良好	无	党员	设计	
马小娟	女	35	湖南	汉族	初中	工人	已婚	1	良好	无	群众	缝纫	
徐志强	男	36	广东	汉族	高中	学生	未婚	0	良好	无	团员	运动	
黄小芳	女	45	广西	汉族	小学	农民	已婚						

Year	1990	1991	1992	1993	1994	1995	1996	1997	1998	1999	2000	2001	2002	2003	2004	2005	2006	2007	2008	2009	2010	2011	2012	2013	2014	2015	2016	2017	2018	2019	2020	2021	2022	2023	2024	2025	2026	2027	2028	2029	2030	2031	2032	2033	2034	2035	2036	2037	2038	2039	2040	2041	2042	2043	2044	2045	2046	2047	2048	2049	2050	2051	2052	2053	2054	2055	2056	2057	2058	2059	2060	2061	2062	2063	2064	2065	2066	2067	2068	2069	2070	2071	2072	2073	2074	2075	2076	2077	2078	2079	2080	2081	2082	2083	2084	2085	2086	2087	2088	2089	2090	2091	2092	2093	2094	2095	2096	2097	2098	2099	2100
1990	1991	1992	1993	1994	1995	1996	1997	1998	1999	2000	2001	2002	2003	2004	2005	2006	2007	2008	2009	2010	2011	2012	2013	2014	2015	2016	2017	2018	2019	2020	2021	2022	2023	2024	2025	2026	2027	2028	2029	2030	2031	2032	2033	2034	2035	2036	2037	2038	2039	2040	2041	2042	2043	2044	2045	2046	2047	2048	2049	2050	2051	2052	2053	2054	2055	2056	2057	2058	2059	2060	2061	2062	2063	2064	2065	2066	2067	2068	2069	2070	2071	2072	2073	2074	2075	2076	2077	2078	2079	2080	2081	2082	2083	2084	2085	2086	2087	2088	2089	2090	2091	2092	2093	2094	2095	2096	2097	2098	2099	2100	

	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41	42	43	44	45	46	47	48	49	50	51	52	53	54	55	56	57	58	59	60	61	62	63	64	65	66	67	68	69	70	71	72	73	74	75	76	77	78	79	80	81	82	83	84	85	86	87	88	89	90	91	92	93	94	95	96	97	98	99	100	101	102	103	104	105	106	107	108	109	110	111	112	113	114	115	116	117	118	119	120	121	122	123	124	125	126	127	128	129	130	131	132	133	134	135	136	137	138	139	140	141	142	143	144	145	146	147	148	149	150	151	152	153	154	155	156	157	158	159	160	161	162	163	164	165	166	167	168	169	170	171	172	173	174	175	176	177	178	179	180	181	182	183	184	185	186	187	188	189	190	191	192	193	194	195	196	197	198	199	200	201	202	203	204	205	206	207	208	209	210	211	212	213	214	215	216	217	218	219	220	221	222	223	224	225	226	227	228	229	230	231	232	233	234	235	236	237	238	239	240	241	242	243	244	245	246	247	248	249	250	251	252	253	254	255	256	257	258	259	260	261	262	263	264	265	266	267	268	269	270	271	272	273	274	275	276	277	278	279	280	281	282	283	284	285	286	287	288	289	290	291	292	293	294	295	296	297	298	299	300	301	302	303	304	305	306	307	308	309	310	311	312	313	314	315	316	317	318	319	320	321	322	323	324	325	326	327	328	329	330	331	332	333	334	335	336	337	338	339	340	341	342	343	344	345	346	347	348	349	350	351	352	353	354	355	356	357	358	359	360	361	362	363	364	365	366	367	368	369	370	371	372	373	374	375	376	377	378	379	380	381	382	383	384	385	386	387	388	389	390	391	392	393	394	395	396	397	398	399	400	401	402	403	404	405	406	407	408	409	410	411	412	413	414	415	416	417	418	419	420	421	422	423	424	425	426	427	428	429	430	431	432	433	434	435	436	437	438	439	440	441	442	443	444	445	446	447	448	449	450	451	452	453	454	455	456	457	458	459	460	461	462	463	464	465	466	467	468	469	470	471	472	473	474	475	476	477	478	479	480	481	482	483	484	485	486	487	488	489	490	491	492	493	494	495	496	497	498	499	500	501	502	503	504	505	506	507	508	509	510	511	512	513	514	515	516	517	518	519	520	521	522	523	52
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Year	1990	1991	1992	1993	1994	1995	1996	1997	1998	1999	2000	2001	2002	2003	2004	2005	2006	2007	2008	2009	2010	2011	2012	2013	2014	2015	2016	2017	2018	2019	2020	2021	2022	2023	2024	2025	2026	2027	2028	2029	2030	2031	2032	2033	2034	2035	2036	2037	2038	2039	2040	2041	2042	2043	2044	2045	2046	2047	2048	2049	2050	2051	2052	2053	2054	2055	2056	2057	2058	2059	2060	2061	2062	2063	2064	2065	2066	2067	2068	2069	2070	2071	2072	2073	2074	2075	2076	2077	2078	2079	2080	2081	2082	2083	2084	2085	2086	2087	2088	2089	2090	2091	2092	2093	2094	2095	2096	2097	2098	2099	2100
1990	1991	1992	1993	1994	1995	1996	1997	1998	1999	2000	2001	2002	2003	2004	2005	2006	2007	2008	2009	2010	2011	2012	2013	2014	2015	2016	2017	2018	2019	2020	2021	2022	2023	2024	2025	2026	2027	2028	2029	2030	2031	2032	2033	2034	2035	2036	2037	2038	2039	2040	2041	2042	2043	2044	2045	2046	2047	2048	2049	2050	2051	2052	2053	2054	2055	2056	2057	2058	2059	2060	2061	2062	2063	2064	2065	2066	2067	2068	2069	2070	2071	2072	2073	2074	2075	2076	2077	2078	2079	2080	2081	2082	2083	2084	2085	2086	2087	2088	2089	2090	2091	2092	2093	2094	2095	2096	2097	2098	2099	2100	

時間	場所	内容	備考
10:00	1000	1000	1000
10:05	1005	1005	1005
10:10	1010	1010	1010
10:15	1015	1015	1015
10:20	1020	1020	1020
10:25	1025	1025	1025
10:30	1030	1030	1030
10:35	1035	1035	1035
10:40	1040	1040	1040
10:45	1045	1045	1045
10:50	1050	1050	1050
10:55	1055	1055	1055
11:00	1100	1100	1100
11:05	1105	1105	1105
11:10	1110	1110	1110
11:15	1115	1115	1115
11:20	1120	1120	1120
11:25	1125	1125	1125
11:30	1130	1130	1130
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11:45	1145	1145	1145
11:50	1150	1150	1150
11:55	1155	1155	1155
12:00	1200	1200	1200
12:05	1205	1205	1205
12:10	1210	1210	1210
12:15	1215	1215	1215
12:20	1220	1220	1220
12:25	1225	1225	1225
12:30	1230	1230	1230
12:35	1235	1235	1235
12:40	1240	1240	1240
12:45	1245	1245	1245
12:50	1250	1250	1250
12:55	1255	1255	1255
13:00	1300	1300	1300
13:05	1305	1305	1305
13:10	1310	1310	1310
13:15	1315	1315	1315
13:20	1320	1320	1320
13:25	1325	1325	1325
13:30	1330	1330	1330
13:35	1335	1335	1335
13:40	1340	1340	1340
13:45	1345	1345	1345
13:50	1350	1350	1350
13:55	1355	1355	1355
14:00	1400	1400	1400
14:05	1405	1405	1405
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14:25	1425	1425	1425
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14:35	1435	1435	1435
14:40	1440	1440	1440
14:45	1445	1445	1445
14:50	1450	1450	1450
14:55	1455	1455	1455
15:00	1500	1500	1500
15:05	1505	1505	1505
15:10	1510	1510	1510
15:15	1515	1515	1515
15:20	1520	1520	1520
15:25	1525	1525	1525
15:30	1530	1530	1530
15:35	1535	1535	1535
15:40	1540	1540	1540
15:45	1545	1545	1545
15:50	1550	1550	1550
15:55	1555	1555	1555
16:00	1600	1600	1600
16:05	1605	1605	1605
16:10	1610	1610	1610
16:15	1615	1615	1615
16:20	1620	1620	1620
16:25	1625	1625	1625
16:30	1630	1630	1630
16:35	1635	1635	1635
16:40	1640	1640	1640
16:45	1645	1645	1645
16:50	1650	1650	1650
16:55	1655	1655	1655
17:00			

[illegible][illegible][illegible]

年次	1950	1951	1952	1953	1954	1955	1956	1957	1958	1959	1960	1961	1962	1963	1964	1965	1966	1967	1968	1969	1970	1971	1972	1973	1974	1975	1976	1977	1978	1979	1980	1981	1982	1983	1984	1985	1986	1987	1988	1989	1990	1991	1992	1993	1994	1995	1996	1997	1998	1999	2000	2001	2002	2003	2004	2005	2006	2007	2008	2009	2010	2011	2012	2013	2014	2015	2016	2017	2018	2019	2020	2021	2022	2023	2024	2025	2026	2027	2028	2029	2030	2031	2032	2033	2034	2035	2036	2037	2038	2039	2040	2041	2042	2043	2044	2045	2046	2047	2048	2049	2050	2051	2052	2053	2054	2055	2056	2057	2058	2059	2060	2061	2062	2063	2064	2065	2066	2067	2068	2069	2070	2071	2072	2073	2074	2075	2076	2077	2078	2079	2080	2081	2082	2083	2084	2085	2086	2087	2088	2089	2090	2091	2092	2093	2094	2095	2096	2097	2098	2099	2100																			
人口	1,000,000	1,050,000	1,100,000	1,150,000	1,200,000	1,250,000	1,300,000	1,350,000	1,400,000	1,450,000	1,500,000	1,550,000	1,600,000	1,650,000	1,700,000	1,750,000	1,800,000	1,850,000	1,900,000	1,950,000	2,000,000	2,050,000	2,100,000	2,150,000	2,200,000	2,250,000	2,300,000	2,350,000	2,400,000	2,450,000	2,500,000	2,550,000	2,600,000	2,650,000	2,700,000	2,750,000	2,800,000	2,850,000	2,900,000	2,950,000	3,000,000	3,050,000	3,100,000	3,150,000	3,200,000	3,250,000	3,300,000	3,350,000	3,400,000	3,450,000	3,500,000	3,550,000	3,600,000	3,650,000	3,700,000	3,750,000	3,800,000	3,850,000	3,900,000	3,950,000	4,000,000	4,050,000	4,100,000	4,150,000	4,200,000	4,250,000	4,300,000	4,350,000	4,400,000	4,450,000	4,500,000	4,550,000	4,600,000	4,650,000	4,700,000	4,750,000	4,800,000	4,850,000	4,900,000	4,950,000	5,000,000	5,050,000	5,100,000	5,150,000	5,200,000	5,250,000	5,300,000	5,350,000	5,400,000	5,450,000	5,500,000	5,550,000	5,600,000	5,650,000	5,700,000	5,750,000	5,800,000	5,850,000	5,900,000	5,950,000	6,000,000	6,050,000	6,100,000	6,150,000	6,200,000	6,250,000	6,300,000	6,350,000	6,400,000	6,450,000	6,500,000	6,550,000	6,600,000	6,650,000	6,700,000	6,750,000	6,800,000	6,850,000	6,900,000	6,950,000	7,000,000	7,050,000	7,100,000	7,150,000	7,200,000	7,250,000	7,300,000	7,350,000	7,400,000	7,450,000	7,500,000	7,550,000	7,600,000	7,650,000	7,700,000	7,750,000	7,800,000	7,850,000	7,900,000	7,950,000	8,000,000	8,050,000	8,100,000	8,150,000	8,200,000	8,250,000	8,300,000	8,350,000	8,400,000	8,450,000	8,500,000	8,550,000	8,600,000	8,650,000	8,700,000	8,750,000	8,800,000	8,850,000	8,900,000	8,950,000	9,000,000	9,050,000	9,100,000	9,150,000	9,200,000	9,250,000	9,300,000	9,350,000	9,400,000	9,450,00

Year	1950	1951	1952	1953	1954	1955	1956	1957	1958	1959	1960	1961	1962	1963	1964	1965	1966	1967	1968	1969	1970	1971	1972	1973	1974	1975	1976	1977	1978	1979	1980	1981	1982	1983	1984	1985	1986	1987	1988	1989	1990	1991	1992	1993	1994	1995	1996	1997	1998	1999	2000	2001	2002	2003	2004	2005	2006	2007	2008	2009	2010	2011	2012	2013	2014	2015	2016	2017	2018	2019	2020	2021	2022	2023	2024	2025	2026	2027	2028	2029	2030	2031	2032	2033	2034	2035	2036	2037	2038	2039	2040	2041	2042	2043	2044	2045	2046	2047	2048	2049	2050	2051	2052	2053	2054	2055	2056	2057	2058	2059	2060	2061	2062	2063	2064	2065	2066	2067	2068	2069	2070	2071	2072	2073	2074	2075	2076	2077	2078	2079	2080	2081	2082	2083	2084	2085	2086	2087	2088	2089	2090	2091	2092	2093	2094	2095	2096	2097	2098	2099	2100																			
Population	1,000,000	1,050,000	1,100,000	1,150,000	1,200,000	1,250,000	1,300,000	1,350,000	1,400,000	1,450,000	1,500,000	1,550,000	1,600,000	1,650,000	1,700,000	1,750,000	1,800,000	1,850,000	1,900,000	1,950,000	2,000,000	2,050,000	2,100,000	2,150,000	2,200,000	2,250,000	2,300,000	2,350,000	2,400,000	2,450,000	2,500,000	2,550,000	2,600,000	2,650,000	2,700,000	2,750,000	2,800,000	2,850,000	2,900,000	2,950,000	3,000,000	3,050,000	3,100,000	3,150,000	3,200,000	3,250,000	3,300,000	3,350,000	3,400,000	3,450,000	3,500,000	3,550,000	3,600,000	3,650,000	3,700,000	3,750,000	3,800,000	3,850,000	3,900,000	3,950,000	4,000,000	4,050,000	4,100,000	4,150,000	4,200,000	4,250,000	4,300,000	4,350,000	4,400,000	4,450,000	4,500,000	4,550,000	4,600,000	4,650,000	4,700,000	4,750,000	4,800,000	4,850,000	4,900,000	4,950,000	5,000,000	5,050,000	5,100,000	5,150,000	5,200,000	5,250,000	5,300,000	5,350,000	5,400,000	5,450,000	5,500,000	5,550,000	5,600,000	5,650,000	5,700,000	5,750,000	5,800,000	5,850,000	5,900,000	5,950,000	6,000,000	6,050,000	6,100,000	6,150,000	6,200,000	6,250,000	6,300,000	6,350,000	6,400,000	6,450,000	6,500,000	6,550,000	6,600,000	6,650,000	6,700,000	6,750,000	6,800,000	6,850,000	6,900,000	6,950,000	7,000,000	7,050,000	7,100,000	7,150,000	7,200,000	7,250,000	7,300,000	7,350,000	7,400,000	7,450,000	7,500,000	7,550,000	7,600,000	7,650,000	7,700,000	7,750,000	7,800,000	7,850,000	7,900,000	7,950,000	8,000,000	8,050,000	8,100,000	8,150,000	8,200,000	8,250,000	8,300,000	8,350,000	8,400,000	8,450,000	8,500,000	8,550,000	8,600,000	8,650,000	8,700,000	8,750,000	8,800,000	8,850,000	8,900,000	8,950,000	9,000,000	9,050,000	9,100,000	9,150,000	9,200,000	9,250,000	9,300,000	9,350,000	9,400,000	9,450,000

姓名	性别	年龄	民族	籍贯	职业	文化程度	政治面貌	宗教信仰	婚姻状况	健康状况	特长爱好	其他
王德胜	男	45	汉族	山东	教师	本科	党员	无	已婚	良好	书法	
李小红	女	32	汉族	河南	护士	大专	团员	无	已婚	良好	舞蹈	
张小明	男	28	汉族	江苏	程序员	本科	党员	无	未婚	良好	编程	
赵国强	男	55	汉族	四川	工程师	硕士	党员	无	已婚	良好	阅读	
陈丽娟	女	40	汉族	广东	会计	本科	党员	无	已婚	良好	烹饪	
刘伟强	男	38	汉族	浙江	医生	本科	党员	无	已婚	良好	运动	
孙小芳	女	25	汉族	湖北	文员	大专	团员	无	未婚	良好	唱歌	
周大伟	男	50	汉族	湖南	农民	小学	党员	无	已婚	一般	务农	
吴小华	女	35	汉族	安徽	教师	本科	党员	无	已婚	良好	阅读	
郑国强	男	42	汉族	江西	工人	高中	党员	无	已婚	良好	木工	
冯小娟	女	30	汉族	福建	护士	大专	团员	无	已婚	良好	舞蹈	
马大伟	男	48	汉族	广西	工程师	本科	党员	无	已婚	良好	阅读	
林小芳	女	28	汉族	云南	文员	大专	团员	无	未婚	良好	唱歌	
周国强	男	52	汉族	贵州	农民	小学	党员	无	已婚	一般	务农	
吴小华	女	35	汉族	四川	教师	本科	党员	无	已婚	良好	阅读	
郑国强	男	42	汉族	湖南	工人	高中	党员	无	已婚	良好	木工	
冯小娟	女	30	汉族	广东	护士	大专	团员	无	已婚	良好	舞蹈	
马大伟	男	48	汉族	浙江	工程师	本科	党员	无	已婚	良好	阅读	
林小芳	女	28	汉族	湖北	文员	大专	团员	无	未婚	良好	唱歌	
周国强	男	52	汉族	河南	农民	小学	党员	无	已婚	一般	务农	
吴小华	女	35	汉族	山东	教师	本科	党员	无	已婚	良好	阅读	
郑国强	男	42	汉族	江苏	工人	高中	党员	无	已婚	良好	木工	
冯小娟	女	30	汉族	安徽	护士	大专	团员	无	已婚	良好	舞蹈	
马大伟	男	48	汉族	江西	工程师	本科	党员	无	已婚	良好	阅读	
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周国强	男	52	汉族	广西	农民	小学	党员	无	已婚	一般	务农	
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冯小娟	女	30	汉族	四川	护士	大专	团员	无	已婚	良好	舞蹈	
马大伟	男	48	汉族	湖南	工程师	本科	党员	无	已婚	良好	阅读	
林小芳	女	28	汉族	广东	文员	大专	团员	无	未婚	良好	唱歌	
周国强	男	52	汉族	浙江	农民	小学	党员	无	已婚	一般	务农	
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冯小娟	女	30	汉族	山东	护士	大专	团员	无	已婚	良好	舞蹈	
马大伟	男	48	汉族	安徽	工程师	本科	党员	无	已婚	良好	阅读	
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马大伟	男	48	汉族	四川	工程师	本科	党员	无	已婚	良好	阅读	
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郑国强	男	42	汉族	湖北	工人	高中	党员	无	已婚	良好	木工	
冯小娟	女	30	汉族	河南	护士	大专	团员	无	已婚	良好	舞蹈	
马大伟	男	48	汉族	山东	工程师</							

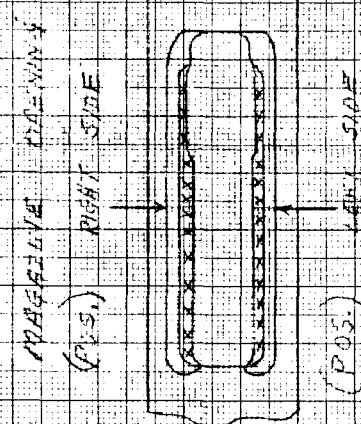
(P05) LAM SIDE

Year	1950	1951	1952	1953	1954	1955	1956	1957	1958	1959	1960	1961	1962	1963	1964	1965	1966	1967	1968	1969	1970	1971	1972	1973	1974	1975	1976	1977	1978	1979	1980	1981	1982	1983	1984	1985	1986	1987	1988	1989	1990	1991	1992	1993	1994	1995	1996	1997	1998	1999	2000	2001	2002	2003	2004	2005	2006	2007	2008	2009	2010	2011	2012	2013	2014	2015	2016	2017	2018	2019	2020	2021	2022	2023	2024	2025	2026	2027	2028	2029	2030	2031	2032	2033	2034	2035	2036	2037	2038	2039	2040	2041	2042	2043	2044	2045	2046	2047	2048	2049	2050	2051	2052	2053	2054	2055	2056	2057	2058	2059	2060	2061	2062	2063	2064	2065	2066	2067	2068	2069	2070	2071	2072	2073	2074	2075	2076	2077	2078	2079	2080	2081	2082	2083	2084	2085	2086	2087	2088	2089	2090	2091	2092	2093	2094	2095	2096	2097	2098	2099	2100
1950	1951	1952	1953	1954	1955	1956	1957	1958	1959	1960	1961	1962	1963	1964	1965	1966	1967	1968	1969	1970	1971	1972	1973	1974	1975	1976	1977	1978	1979	1980	1981	1982	1983	1984	1985	1986	1987	1988	1989	1990	1991	1992	1993	1994	1995	1996	1997	1998	1999	2000	2001	2002	2003	2004	2005	2006	2007	2008	2009	2010	2011	2012	2013	2014	2015	2016	2017	2018	2019	2020	2021	2022	2023	2024	2025	2026	2027	2028	2029	2030	2031	2032	2033	2034	2035	2036	2037	2038	2039	2040	2041	2042	2043	2044	2045	2046	2047	2048	2049	2050	2051	2052	2053	2054	2055	2056	2057	2058	2059	2060	2061	2062	2063	2064	2065	2066	2067	2068	2069	2070	2071	2072	2073	2074	2075	2076	2077	2078	2079	2080	2081	2082	2083	2084	2085	2086	2087	2088	2089	2090	2091	2092	2093	2094	2095	2096	2097	2098	2099	2100	

姓名	性别	年龄	籍贯	民族	文化程度	职业	工作单位	住址	电话	备注
王德胜	男	45	山东	汉族	高中	工人	山东钢铁厂	济南市	1234	
李秀英	女	38	河北	汉族	初中	教师	石家庄市	石家庄市	5678	
张国强	男	52	河南	汉族	大学	教授	郑州大学	郑州市	9012	
刘小红	女	28	广东	汉族	小学	售货员	广州百货	广州市	3456	
陈为民	男	60	浙江	汉族	小学	农民	杭州郊区	杭州市	7890	
赵子龙	男	35	四川	汉族	高中	干部	成都军区	成都市	2345	
孙文才	男	48	湖北	汉族	初中	工人	武汉钢铁	武汉市	6789	
周大伟	男	55	湖南	汉族	小学	农民	长沙郊区	长沙市	1011	
吴小芳	女	32	安徽	汉族	高中	教师	合肥市	合肥市	4567	
郑为民	男	40	江西	汉族	初中	工人	南昌钢铁	南昌市	8901	
冯国强	男	50	广西	汉族	小学	农民	南宁郊区	南宁市	2101	
马小红	女	25	福建	汉族	高中	售货员	福州百货	福州市	5432	
徐为民	男	58	山西	汉族	小学	工人	太原钢铁	太原市	9876	
黄子龙	男	30	陕西	汉族	初中	干部	西安军区	西安市	3210	
周大伟	男	42	甘肃	汉族	小学	农民	兰州郊区	兰州市	6543	
吴小芳	女	35	宁夏	汉族	高中	教师	银川市	银川市	1098	
郑为民	男	45	青海	汉族	初中	工人	西宁钢铁	西宁市	4321	
冯国强	男	55	新疆	汉族	小学	农民	乌鲁木齐	乌鲁木齐市	7654	
马小红	女	20	内蒙古	汉族	高中	售货员	呼和浩特	呼和浩特市	2109	
徐为民	男	60	辽宁	汉族	小学	工人	鞍山钢铁	鞍山市	5678	
黄子龙	男	35	吉林	汉族	初中	干部	长春军区	长春市	9012	
周大伟	男	48	黑龙江	汉族	小学	农民	哈尔滨	哈尔滨市	3456	
吴小芳	女	30	山东	汉族	高中	教师	济南市	济南市	7890	
郑为民	男	40	河南	汉族	初中	工人	郑州市	郑州市	1234	
冯国强	男	50	河北	汉族	小学	农民	石家庄市	石家庄市	5678	
马小红	女	25	广东	汉族	高中	售货员	广州市	广州市	9012	
徐为民	男	55	浙江	汉族	小学	工人	杭州市	杭州市	3456	
黄子龙	男	30	四川	汉族	初中	干部	成都市	成都市	7890	
周大伟	男	45	湖北	汉族	小学	农民	武汉市	武汉市	1234	
吴小芳	女	35	湖南	汉族	高中	教师	长沙市	长沙市	5678	
郑为民	男	45	安徽	汉族	初中	工人	合肥市	合肥市	9012	
冯国强	男	55	江西	汉族	小学	农民	南昌市	南昌市	3456	
马小红	女	20	广西	汉族	高中	售货员	南宁市	南宁市	7890	
徐为民	男	60	福建	汉族	小学	工人	福州市	福州市	1234	
黄子龙	男	35	山西	汉族	初中	干部	太原市	太原市	5678	
周大伟	男	48	陕西	汉族	小学	农民	西安市	西安市	9012	
吴小芳	女	30	甘肃	汉族	高中	教师	兰州市	兰州市	3456	
郑为民	男	40	宁夏	汉族	初中	工人	银川市	银川市	7890	
冯国强	男	50	青海	汉族	小学	农民	西宁市	西宁市	1234	
马小红	女	25	新疆	汉族	高中	售货员	乌鲁木齐市	乌鲁木齐市	5678	
徐为民	男	55	内蒙古	汉族	小学	工人	呼和浩特市	呼和浩特市	9012	
黄子龙	男	30	辽宁	汉族	初中	干部	鞍山市	鞍山市	3456	
周大伟	男	45	吉林	汉族	小学	农民	长春市	长春市	7890	
吴小芳	女	35	黑龙江	汉族	高中	教师	哈尔滨市	哈尔滨市	1234	
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周大伟	男	48	四川	汉族	小学	农民	成都市	成都市	5678	
吴小芳	女	30	湖北	汉族	高中	教师	武汉市	武汉市	9012	
郑为民	男	40	湖南	汉族	初中	工人	长沙市	长沙市	3456	
冯国强	男	50	安徽	汉族	小学	农民	合肥市			

[illegible]

10 X 10 TO 1 1/2 INCH 47 1323  
10 X 15 INCHES  
KEUFFEL & ESSER CO.  
MADE IN U.S.A.





m/600 RECEIVER # 15406

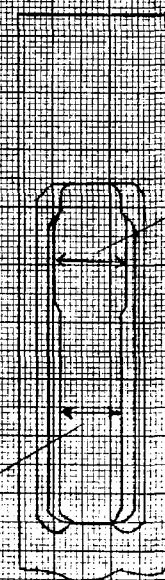
TRI-CORDINATE # 29600

SHEET 2 3-24-71 FC

OP. 83	TRI-CORDINATE	W	1	2	3	4	5	6	
GA. C-54702 V (PLUG)	DIM. 548-918								
FRONT	V	1	2	3	4	5	6		
UNDER	1								
OK	11111	11111	11111	11111	11111	11111	11111	11111	
OVER									
GA. C-54725 V (PLUG)	DIM. 29362/29440								
FRONT	V	1	2	3	4	5	6		
UNDER	1								
OK	11111	11111	11111	11111	11111	11111	11111	11111	
OVER									
GA. H-800076 (PLUG)	DIM. 561-561								
FRONT	V	1	2	3	4	5	6		
UNDER	1								
OK	11111	11111	11111	11111	11111	11111	11111	11111	
OVER									
GA. B-8012-20 (PLUG)	DIM. 555-551								
FRONT	V	1	2	3	4	5	6		
UNDER	1								
OK	11111	11111	11111	11111	11111	11111	11111	11111	
OVER									



REAR OPENING



10 X 10 TO 1 1/2 INCH 47 1323 KEUFFEL & ESSER CO.



PROCESS ENGINEERING ASSIGNMENTS		Burns
<b>Job Description:</b>  <b>Oper. - Tap Barrel Hole</b>  <b>Char. - Concentricity of Thread</b> <b>with O.D. (7/16/64)</b>		<b>Area Engineer:</b> Anderson Stedford
		<b>Sheet No.:</b> 1 <b>Job No.:</b> 7686-Sk A-B5
		<b>Job Priority:</b>
		<b>Job Code:</b> 3
		<b>Model:</b> 600
		<b>Part Name:</b> Receiver
		<b>Oper. No.:</b> 19
		<b>Dept. No.:</b> 54
		<b>Est. Comp. Mo/Yr:</b> 4/65
		<b>Est. Comp. Hours:</b> 35
<b>Assigned By:</b>		<b>Date:</b>
<b>Est. Savings:</b>		
<b>Report Date</b>	<b>Elapsed Hrs.</b>	<b>Accomplishments</b>
1/15/65		No change.
4/15/66		No change.
1/22/68		Job transferred to Burns.
6/17/68		See Job No. 8262-B5 - M/660 Receiver.
		<u>COMPLETE</u>

RD - 6566 2/1/68



8  
cc: L. J. Boyle  
T. H. Byrnes  
F. G. Carlson  
I. B. Croop  
V. G. Deheus

J. H. Carter  
H. J. Hackman  
C. I. Mann  
T. H. Pratt  
P. W. Fugh

W. C. Schrader  
R. L. Stafford  
R. A. Williamson

MEMORANDUM OF VISIT  
To  
TRI-ORDINATE CORPORATION  
Berkeley Heights, N.J.  
By  
G. J. Hill and S. I. Cross  
On  
June 29 - July 2, 1965

Purpose - Trial Run of M/600 Receivers on Tri-Ordinate Machine #2.

A trial run was made on Model 600 receivers to check cams for this model and to check corrections to head #3 "Mill Firing Pin Head Clearance".

Problems encountered were still in head #3. After investigation, the following items were corrected or are to be corrected:

1. Gibs were tightened up - replaced damaged roller retainer. Carbide cutter used gave a more satisfactory cut.
2. Angle on clamp was not satisfactory to direct clamping force through centerline of locator blocks. Verified by movement after clamping pressure applied.
3. No support under tang of receiver.
4. Locator tongue on gage and fixture have no allowance for eccentricity of receiver bolt hole to I.D. This makes loading of receiver on fixture and gage difficult.
5. Car changed so cutter did not pass through cut on return causing over-size slot.

Items 2 and 3 are to be corrected by Tri-Ordinate by July 12, when a retryout of Model 600 will be performed.

Item 4 will be completed week of July 12.



MEMORANDUM OF VISIT - TRI-ORDINATE COFF.  
Berkeley Heights, F. J. - June 29 - July 2, 1965

2.

A quantity of 150 Model 600 receivers will be needed the week of July 12 for this additional trial.

All cuts - heads #1, 4, and 5, cut against clamp. Measurements show no problem with reasonably sharp cutters.

Cutter life was observed as follows but this will be changed either way in a production run.

- |                                   |  |
|-----------------------------------|--|
| Head 1. Mill Safety Slot etc.     | - 80 - 100 pcs/grind max.                  |
| 2. Mill Shell Clearance           | - 80 pcs. run on study - cutter still O.K. |
| 3. Mill Firing Pin Head Clearance | - Trying new carbide cutter                |
| 4. Mill Scope Mount Radius        | - 150 pcs; still appears O.K.              |
| 5. Mill Ejection Port Outline     | - 80 - 100 pcs/grind                       |

Quality Control  
F. W. Menard, Supervisor

Process Eng. - Current Products  
R. E. Hurley, Supervisor

By S. F. Cross  
S. F. Cross  
Quality Auditor

By G. J. Gill  
G. J. Gill  
Process Engineer

SPC/GJH/eb  
7-7-65



RECEIVED  
JUN 24 1965

CC: H. J. Hackman L. Fox  
L. J. Boyle R. W. Keddell  
T. H. Pratt R. E. Wright  
R. W. Pugh E. R. Carr  
R. B. Burle R. L. Stafford  
N. S. Thompson file

CURRENT PRODUCTS  
*Process Engineering*

June 22, 1965

G. J. HILL

M/600 RECEIVER, SCOPE HOLE DIAMETER

**Purpose:** To study the effect of Heat Treat on diameter of the scope holes relative to problems of assembling sight screws in Final Assembly.

**Conclusion:** No significant change through hardening was observed.

The problem of assembling sight screws in the Receiver appears to be related to the use of a worn gage and undersize taps together with problems of upset threads after destoning following the Almco operation. It may be necessary to retap the screw holes prior to assembling.

**Observations:** 1. The initial check of the tapping operation revealed that the gage in use was considerably worn and the tap, while correct to the worn gage, was not up to specification size. The gage and taps were replaced to insure parts to specification for this study.

2. After replacement of the gage and taps, a spot check indicated satisfactory parts were being produced. Therefore, the parts were processed through the "Grind O.D." and "Rollwork" operations, completing the operations specified before hardening. The sample parts (30) were selected as ready for heat treatment. At this point in the process, it was noted that a slight metal burr was present either around the mouth of or inside the holes interfering with proper use of the gage. A tap, without a handle, was spun into the holes with finger pressure to remove the burr and to assure parts "to gage" before hardening.



Observations: 3. After hardening, the parts were "to gage" except that some salt residue was present in approximately twenty (20) of the thirty (30) parts. Six (6) of the twenty (20) parts were again cleaned by finger use of the hand tap to verify thread diameter size. The parts were then processed through filing, polish and the Almco and destoning operations.

4. After the Almco and destoning operations, it was noted that material was apparently rolled in around the circumference of some of the holes accompanied by extensive damage to the threads in a majority of the holes. The material displacement appears to be related to the form of the destoning tool while the thread damage seems to be caused by the forcing of the stone through the hole for removal. Parts could not be gaged due to the damaged threads.

QUALITY CONTROL DEPARTMENT  
N. W. Menard, Supervisor

by Donald Keddell  
D. M. Keddell

DMK/cm



RECEIVED  
JUL 23 1965

cc: R.A. Williamson  
L.J. Boyle  
H.J. Hackman  
P.B. Croop  
R.B. Hurley

F.H. Byrnes  
G.J. Hill  
R.W. Pugh  
Estimate File #2380

CURRENT PRODUCTS  
*Process Engineering*

July 23, 1965

T. H. PRATT

MODEL 600-700 RECEIVERS  
FIRST TRI-ORDINATE MACHINE

Quantity lot prices have been received on three cutters; i.e., A32 (now \$1.60), #83895 (\$70.36), and #87600W (\$2.67), and will change standard cost at inventory time on Tool Replacement, from \$11.849/100 to \$8.4555.

E. A. Karla  
Methods & Standards Section

*G. F. Frazier*  
G. F. Frazier

GFF:sm



RECEIVED  
JUL 21 1965

CURRENT PRODUCTS  
*Process E. Engineering*

cc: R.A. Williamson  
L.J. Boyle  
H.J. Hackman  
P.B. Croop  
~~R.D. Hurley~~ *[Signature]*  
G.J. Hill  
R.W. Pugh  
Estimate File #2380

July 20, 1965

T. H. PRATT

MODEL 600-700 RECEIVERS - FIRST TRI-ORDINATE MACHINE

The attached sheets indicate our present Tri-Ordinate Machine operating costs, labor and expense versus the former method.

It is intended to show where the high tool costs are by stations, and the elemental breakdown of labor.

E. A. Karle  
Methods & Standards Section

*G. F. Frazier*

G. F. Frazier

Att.  
GFF:sm



## REMINGTON ARMS COMPANY, INC.

ENGINEERING DEPARTMENT ~~Q1112ND~~ COMPUTATION SHEET

SHEET NO

TITLE OF PROJ. *M/600- 700 REC. OLD PROCESS*

PROJ NO

SUBJECT *VS TRI- ORD. LABOR- EXP. BASED.*

WORKS

ON # *3 FORECAST*


COMPUTER

DATE *7-20* 19*65*

	OLD PRO.	TRI- ORD.
<i>M/600- LABOR (32,470 REC.)</i>	<i>4950</i>	<i>2310</i>
<i>700 " (57,840 ")</i>	<i>7020</i>	<i>4120</i>
<i>600 Exp.</i>	<i>5300</i>	<i>6840</i>
<i>700 "</i>	<i>8760</i>	<i>12,350</i>
<i>RELATIONS</i>	<i>4310</i>	<i>2310</i>
<i>DEPRECIATION</i>		<i>4730</i>
<i>TOTAL DPR POST</i>	<i>\$ 30,340</i>	<i>\$ 32,660</i>
<i>GROSS LOSS</i>		<i>\$ 2,320</i>



REMINGTON ARMS COMPANY, INC.

ENGINEERING DEPARTMENT  COMPUTATION SHEET

SHEET NO 2

PROJECT NO. M/700 REC. Old PROCESS  
 SUBJECT COST vs PRESENT TRI-ORDINATE  
 MACH. COST. COMPUTER \$1. DATE 7. 19 1965.

PT No 26575-6

OLD PROCESS

OPR.	Labor	Supplies	GRIND	Tool REPR.	Tool MAINT	MACH. REPR.	OTHER REPR	TOTAL EXP.
47	2.657	.043	1.096	.613	.190	.171	.009	2.122
80	1.821	.048	1.434	2.244	.169	.106	.008	4.029
108	3.511	.240	3.964	.859	.167	.130	.007	5.367
121	1.751	.027	1.237	.132	.086	.086	.002	1.570
129	1.518	.033	1.146	.168	.148	.146	.008	1.649
130	.880	.008	.	.245	.148	.002	.001	.404
#	12.138	.399	8.097	4.261	.908	.641	.035	# 15.141

TRI-ORDINATE

			Scrap					
68	# 7.120	.772	.112	5.807	11.849	.428	2326	.024
								# 21.361



REMINGTON ARMS COMPANY, INC.

ENGINEERING DEPARTMENT  COMPUTATION SHEET

SHEET No 3

TITLE OF PROJ TRI-ORDINATE EXPENSE ACCT.

PROJ. NO.

SUBJECT

WORKS

COMPUTER

DATE 7-19-1965


OPR. DESCRIPTION	TOOL REPLACEMENT					GRIND COST	
	TOOL NO	TOOL COST	PCS. GR	GRINDS TOOL	COST 100	GRIND TIME	COST/100
BOIT STOP SLOT	53133W	38.00	150	25	.974	1.2 HRS	3.480
FIRE CONT	" V						
RO. MILL MAG. OPEN	A-32	<sup>1.60 hr</sup> 4.76	90	1	2.611	1	.354
MILL BOIT H. SLOT	83891	<sup>70.30</sup> 87.40	250	25	1.345	.45	.783
SHAVE BOIT	87602	18.50	500	10	.336	.30	.250
F.N. MAG. RECESS	<sup>31 MIN</sup> N-16	9.20	120	1	3.833	.25	.470
MILL BEVEL - FIRE		<sup>2.67</sup>					
CONT. SAFETY SLOT	87600W	5.50	100	1	2.750	.25	.570
					<u>\$11.849</u>		<u>\$5.807</u>

MACH. MAINT

\* 65,000 X 4% + 2 SHIFTS = .167 COST HR. = 2.326/hr  
28.8 PCS.



## REMINGTON ARMS COMPANY, INC.

ENGINEERING DEPARTMENT  COMPUTATION SHEET

SHEET NO 4

TITLE: TRI. ORDINATE Labor Post.

PROJ NO

SUBJECT

WORKS

COMPUTER

DATE

7-19-1965

ELEMENTS	TIME	HRS.	COST/100	
FLUSH FIX	.193	.322	.676	x
GET PT, LOAD, STAMP	.177	.203	.476	
WALK, UNLOAD	.110	.183	.384	
FILE	.470	7.00	1.470	x
RINSE PART	.070	.117	.246	
GAGE, ST. SHIRT	.070	.117	.247	
" DURING OPR.	.154	.257	.540	x
MISC. CLEAN UP.	.035	.058	.122	
STEAM UP 1 DAY	.062	.100	.210	
CUTTER CHGS.	.507	.845	1.795	x
CHANGE OVERS 7.00 HRS./5000 Pcs.	.147	.245	.684	
			\$ 6.780	
		NITE BONUS.	340	
			\$ 7.120	
x EXCESSIVE				



CC: L. J. Boyle  
F. H. Byrnes  
F. G. Carlson  
F. E. Croop  
V. C. DeRue

J. H. Carter  
H. J. Hackman  
C. I. Mann  
T. H. Pratt  
P. W. Pugh

W. C. Schrader  
R. L. Stafford  
R. A. Williamson

MEMORANDUM OF VISIT  
To  
TRI-ORDINATE CORPORATION  
Berkeley Heights, N. J.  
By  
G. J. Hill and S. P. Cross  
On  
July 13-16, 1965

---

Purpose: Trial run of M/600 Receivers on Tri-Ordinate Machine #2  
with corrections made as listed in prior reports.

A study of 60 receivers - 10 per fixture - was made and measured on all characteristics. All items were considered controllable with the following corrections:

1. A positive stop was added to Head #3 to obtain constant depth reading.
2. Offset Key to be made for Fixture #3 - all studies show this fixture out of alignment.
3. Sidewise position - offset key may bring this alignment in control - E. & D. is checking possibility of additional tolerance.

Due to difficulty of loading part on tongue locator a new movable type locator will be made.

To overcome cuts that cut against clamp (actually this clamp is a hydraulic cylinder with 1500# pressure with more rigidity than ordinary fixture back up block) a left hand spiral cutter will be tried for the scope mount radius. The other two cuts, the excess material M/600 and milling side of ejection port are removing smaller amounts of material and should cause no problems with this type clamp.

On Model 600 - Mill Fingernail Clearance a model drawing change for position of runout to front end should be made to increase cutter life. Present machining allows stops on machine to determine runout position, the Tri-Ordinate runout is determined by a cam and the runout would be determined by cutter life.



Memorandum of Visit - July 13-16, 1965  
Tri-Ordinate Corp., Berkeley Heights, N. J.

2.

Process Engineering will issue DCR's to cover this change which has already been reviewed with R. & D.

The parts used on this trial run had the extractor cam cuts already in - this cut threw a burr on the spline cut which made it impossible to load on locator until burr was filed. For regular production, this burr may have to be removed before this machine or the cam cuts put in after this machine. Upon visual inspection of parts in Production area on July 20, no visible burr was noticed - this burr could have been caused by dull cutter.

Machine was authorized for shipment to Ilion on July 19.

Electrical drawings are available for changing #1 Tri-Ordinate Machine so it cannot index to cut another part until completed part is removed. This feature on #2 Machine prevents any receivers from being cut for the second time. This will be necessary for one operator to run these two machines. This change should be made at Production's convenience.

Quality Control  
N. W. Menard, Supervisor

Process Eng. - Current Products  
R. B. Hurley, Supervisor

By S. P. Cross  
S. P. Cross  
Quality Auditor

By G. J. Hill  
G. J. Hill  
Process Engineer



RECEIVED  
MAY 4 1965

CURRENT PRODUCTS  
*Process Engineering*

cc: L.J. Boyle  
T.H. Pratt  
R.B. Hurley  
P.B. Croop  
G.J. Hill  
Estimate File #2317

May 4, 1965

F. H. BYRNES

PROPOSED SPECIAL DRILLING MACHINE -  
CENTER FIRE BOLT ACTION RECEIVERS

A high spot estimate shows that a gross labor savings of \$1,750 would be realized if a special drill machine was constructed to perform the following manual operations:

M/IP-100, 600 Receiver

Oper. #134 - Drill Gas Hole.

" #141 - Buttmill Bolt Release Spring Seat.

M/40X, 700 Receiver

Oper. #118 - Buttmill Bolt Stop Spring Recess.

" #132 - Drill Gas Escape & Center Guard Screw Holes.

The above savings would yield a 10% return on a capital investment of \$5,000.

The latest estimate available for constructing subject machine is \$10,000 capital and \$3,000 operations.

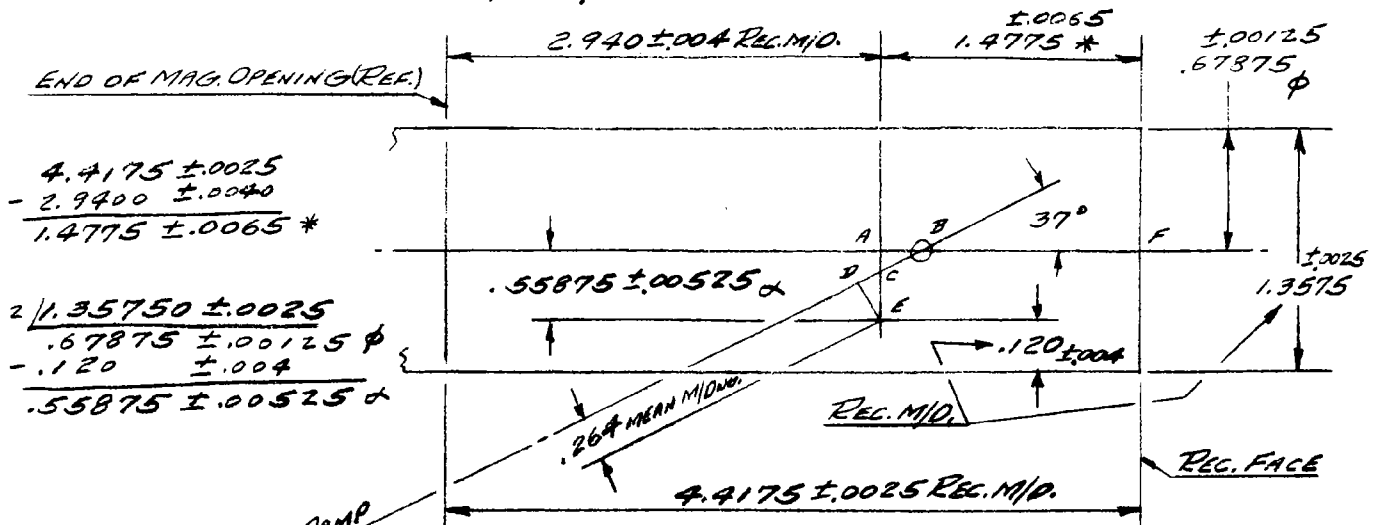
E. A. Karls  
Methods & Standards Section

G. F. Frazier

GFF:sm







FEED RAMP  
SEE A. 51665

$$\begin{aligned} AE &= .55875 \\ DE &= .264 \\ CE &= DE \cos 37^\circ = \frac{.264}{.79863} = .33057 \\ AC &= AE - CE = .55875 - .33057 = .22818 \\ AB &= AC \cot 37^\circ = (.22818)(1.327) = .30279 \\ AF &= 4.4175 \pm .0025 - 2.9400 \pm .004 = 1.4775 \pm .0065 \\ DF &= AF - AB = 1.4775 - .30279 = 1.17471 \text{ MEAN M/DWG.} \end{aligned}$$

$$\begin{aligned} 1.47100 - \text{MIN.} & \quad .680 - \text{MAX.} \\ -1.17471 - \text{MEAN} & \quad .116 - \text{MIN.} \\ UV &= .29629 - \text{MIN. (RV = .564 - MAX)} \\ UV &= .29629 (\text{MIN}) \\ RV &= .564 (\text{MAX}) \\ SV &= UV \tan 37^\circ = (.29629)(.75355) = .22327 \\ RS &= RV - SV = .564 - .22327 = .34073 \\ \text{MAX RT} &= RS \cos 37^\circ = (.34073)(.79863) = .27212 \end{aligned}$$

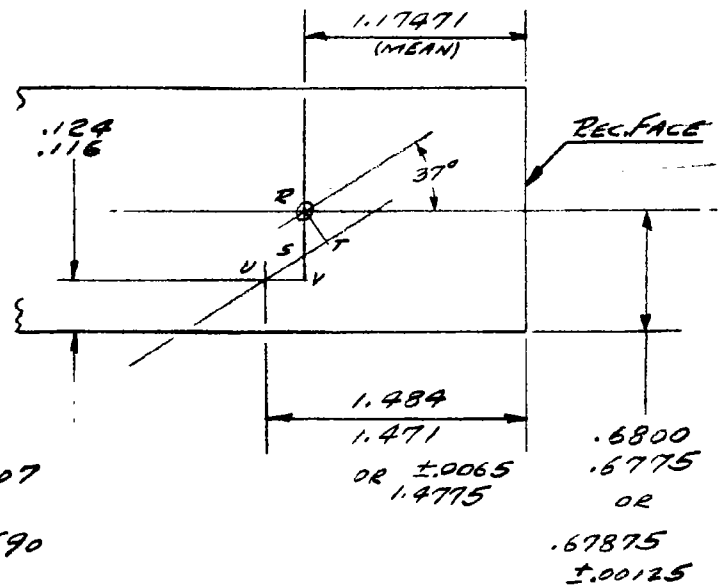
$$\begin{aligned} 1.48400 - \text{MAX.} & \quad .6775 - \text{MIN.} \\ -1.17471 - \text{MEAN} & \quad .1240 - \text{MAX.} \\ UV &= .30929 - \text{MAX. (RV = .5535 - MIN)} \end{aligned}$$

$$\begin{aligned} UV &= .30929 - \text{MAX.} \\ RV &= .5535 - \text{MIN.} \\ SV &= UV \tan 37^\circ = (.30929)(.75355) = .23307 \\ RS &= RV - SV = .5535 - .23307 = .32043 \\ \text{MIN RT} &= RS \cos 37^\circ = (.32043)(.79863) = .25590 \end{aligned}$$

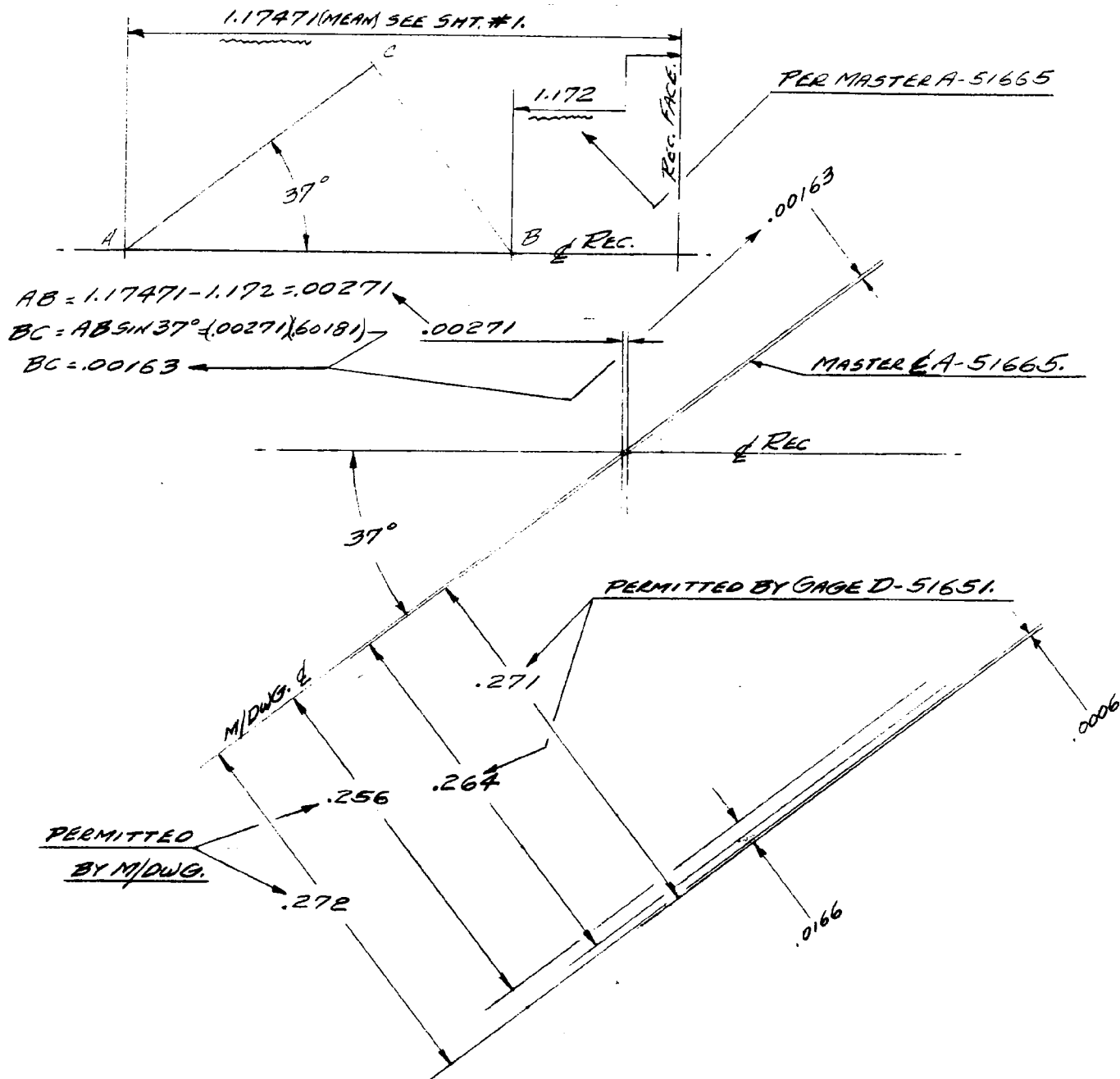
$$\begin{aligned} \text{MAX RT} &= .27212 \\ \text{MEAN RT} &= .264 \\ & \quad .00812 \end{aligned}$$

$$\begin{aligned} \text{MEAN RT} &= .26400 \\ \text{MIN RT} &= .25590 \\ & \quad .00810 \end{aligned}$$

TOL. ON RT =  $\pm .008$  PERMITTED BY M/DWG.







SHEET 2 OF 6.

M/600 REC. OP. MILL FEED RAMP 37° CUT

RELATION BETWEEN M/DWG DIMS +

DIMS PERMITTED BY GAGES

SCALE 10 TO 1 CSY. 10/24/63







[illegible]

CSX 10/24/63.

SCALE: 100 TO 1.

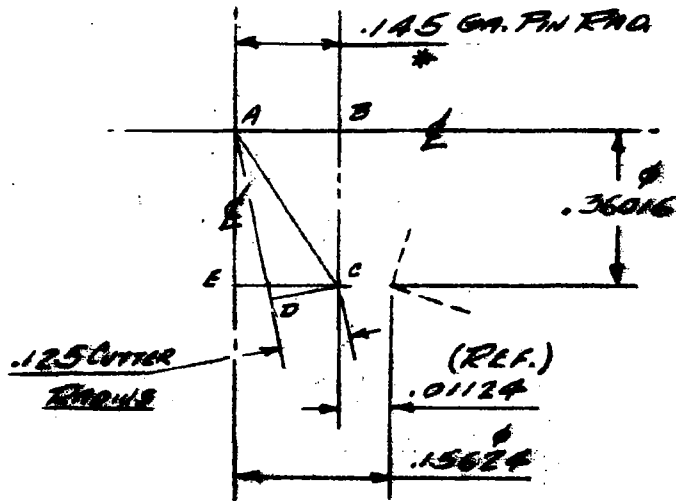
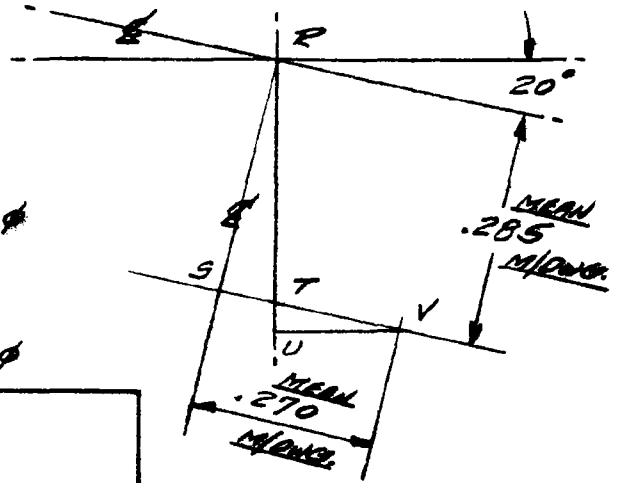


BY OSY DATE 4/15/64  
CHKD. BY \_\_\_\_\_ DATE \_\_\_\_\_

SUBJECT M/600 RECLAMER  
OP. MILL 45° IN FEED RAMP  
PROPOSED M/DWG. CHG. TO CONFORM TO CURRENT PRACTICE.

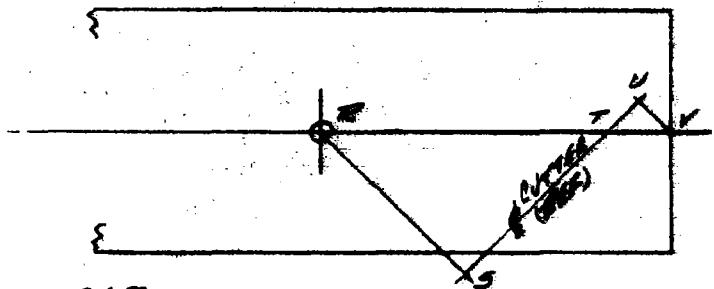
SHEET NO. 5 OF 6  
JOB NO. \_\_\_\_\_

$$\begin{aligned} RS &= .285 (\text{MEAN M/DWG.}) \\ SV &= .270 = .540 (\text{MEAN M/DWG.}) \\ ST &= RS \tan 20^\circ = (.285)(.36397) = .10373 \\ TV &= SV - ST = .270 - .10373 = .16627 \\ UV &= TV \cos 20^\circ = (.16627)(.93969) = .15624 \\ RT &= RS / \cos 20^\circ = .285 / .93969 = .30329 \\ TU &= TV \sin 20^\circ = (.16627)(.34202) = .05687 \\ RU &= RT + TU = .30329 + .05687 = .36016 \end{aligned}$$



$$\begin{aligned} AB &= .145 * \\ BC &= .36016 \\ AC &= \sqrt{.145^2 + .36016^2} = .38825 \\ \tan \angle BAC &= \frac{BC}{AB} = \frac{.36016}{.145} = 2.48386 = 68^\circ 4' 13'' \\ \sin \angle DAC &= \frac{BC}{AC} = \frac{.36016}{.38825} = .92796 = 68^\circ 46' 54'' \\ \angle BAD &= \angle BAC + \angle DAC = 86^\circ 51' 7'' \\ \angle EAD &= 90^\circ - \angle BAD = 3^\circ 8' 53'' \end{aligned}$$

$$\begin{aligned} \text{ANGLE SAUGHT FOR M/DWG.} &= 46^\circ + 2(3^\circ 8' 53'') = \\ &= 46^\circ 17' 46'' \end{aligned}$$

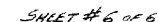


$$\begin{aligned} &.145 \text{ GA. PIN RING} \\ &-.125 \text{ CUTTER RING} \\ &=.020 \text{ DIFFERENCE} \\ &+ 1.347 \text{ GAGE D-86631 DIM.} \\ &1.367 = RS. \end{aligned}$$

$$\begin{aligned} RS &= 1.367 \\ RV &= 3.000 \\ RT &= RS / \sin 45^\circ = 1.367 / .70711 = 1.93322 \\ TV &= RV - RT = 3.000 - 1.93322 = 1.06678 \\ UV &= TV \sin 45^\circ = (1.06678)(.70711) = .75433 \\ UV - .125 &= .75433 - .125 = .62933 \text{ and DIM. FOR M/DWG.} \end{aligned}$$



R2528621

Form R, D. 9201-Rev. 4



600  
REC

345

REMINGTON ARMS COMPANY, INC.

KINZING DEPARTMENT  COMPUTATION SHEET

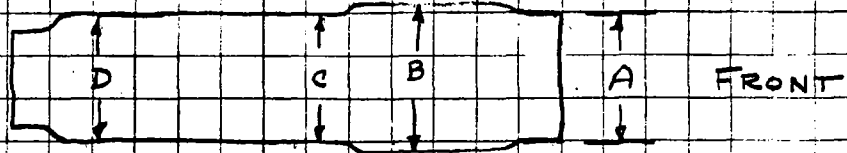
OP PROFILE MAG. SLOT OP. # 36  
RECEIVER  
R. L. STAFFORD

MODEL 600  
PAGE NO  
CAL 308 WIN  
WOMES

COMPUTER

DATE 4-15-1963

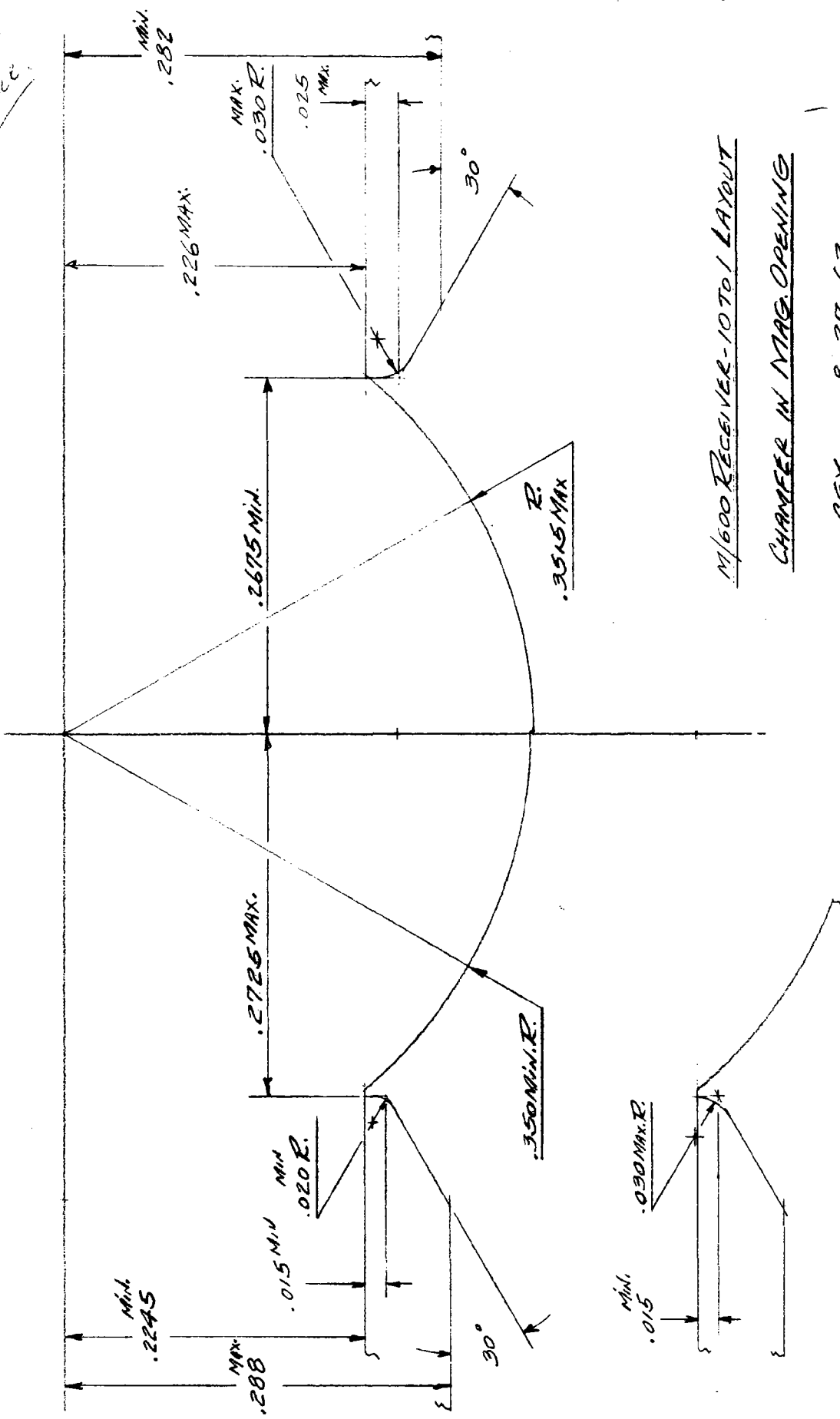
OPERATION CHECKED BEFORE & AFTER HEAT TREAT



DIM A				DIM B			
BEFORE		AFTER		BEFORE		AFTER	
.545				.576			
4				5			
3				4		III	
2	insignif	$\bar{x}.53667$		3 II		$\bar{x}.57150$	
1		$\sigma.0015$		2 I		$\sigma.0032$	
			Tol .010	1 II		$\bar{x}$	Tol .011
.540				.5705			
9 I		II		0		III	
8 II	$\bar{x}.53642$	II		9 I	$\bar{x}.56908$		
7 III	$\sigma.0014$	III		8 I	$\sigma.0027$	II	signif
6 I				7 II			
.535	II	III		6 III		I	
				.565			
DIM C				DIM D			
BEFORE		AFTER		BEFORE		AFTER	
9							
8							
7		III				II	
6							
.545		III	$\bar{x}$	.545			
4		I		4		II	
3 I				3		I	$\bar{x}$
2 II				2 III		II	
1 III	$\bar{x}$		Tol .010	1 III	$\bar{x}$	III	
.540		II		.540	III	I	
9 II				9		I	
8				8 I			
7	signif			7			
6				6			signif
.535				.535			
$\bar{x}.54125$		$\bar{x}.54492$		$\bar{x}.54092$		$\bar{x}.54258$	
$\sigma.0016$		$\sigma.0026$		$\sigma.0012$		$\sigma.0024$	



600  
REC.



M/600 RECEIVER-10 TO 1 LAYOUT

CHAMFER IN MAG. OPENING

C5Y. 8-27-63.

Remington



60° R

cc: L. J. Boyle  
V.G. DeReus  
R.P. Kelly

Ilion, New York  
August 23, 1963

W. E. LEEK

MODEL 600 - 222 - FEEDING

The investigation of feeding of the Model 600, chambered for 222 Rem. cartridge, has revealed the following information. Test results indicate feeding should be satisfactory if the following measures are taken.

*File* The loading ramp cuts must be milled out with proper surface finish maintained. Grinding of these cuts is not adequate.

*Garlock* The follower spring shape must be maintained. Reworked springs are adequate; however, not the most desirable.

*File* The .020<sup>R</sup> on the underside of the rails must be maintained. Failure to maintain this radius results in a condition which greatly increases the chances of stemming at "3 and 9 o'clock" on the chamber mouth.

Model drawing dimensions must be maintained in each of the above cases.

*H. J. Waterman*  
H. J. Waterman  
Firearms Design & Development

HJW:T



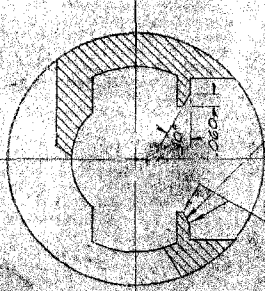
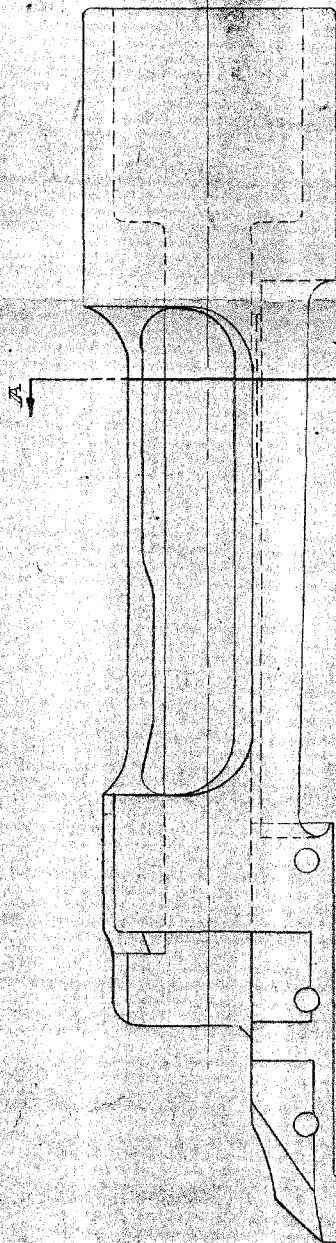
2-15787

**CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER**  
**KINZER V. REMINGTON**

**R2528625**

DO NOT SCALE THIS DRAWING. WORK TO FIGURES  
UNLESS OTHERWISE NOTED. TOLERANCES  
ON DECIMAL DIMENSIONS ARE  $\pm .005$   
& ON FRACTIONAL DIMENSIONS  $\pm \frac{.01}{16}$   
& ON ANGULAR DIMENSIONS  $-00^{\circ}30'$   
FINISHES ARE DESIGNATED BY ROOT MEAN  
SQUARE (RMS) SURFACE VALUES. THE  
VALUES ARE THE MAXIMUM PERMISSIBLE  
VALUES ACCEPTABLE. UNLESS OTHERWISE  
SPECIFIED, FINISH ROUGHNESS TO BE  
32, 63, OR BETTER.

ALTERATIONS				
L.T.	WAS	REFERENCE	BY	DATE
1	RECOMM	5126	W	1/5/2
2	CBSOLITA	5126	W	1/5/2
3	222 BEN NARE	5242	W	1/5/2



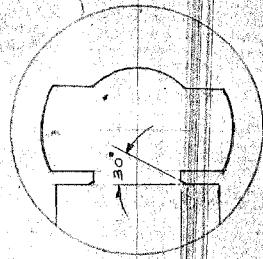
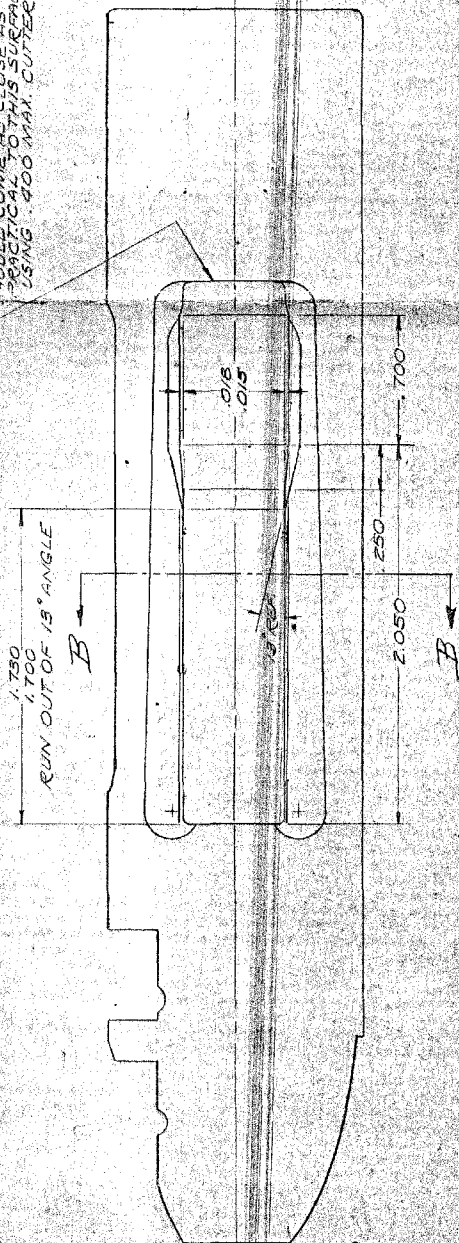
SECTION 4-16

32 BOTH SIDES

103 BOTTOM CORNERS

200 - MUST BE

IN OUT OF 90° BEVEL CUT.  
WOULD COME AS CLOSE AS  
PRACTICAL TO THIS SURFACE  
USING .400 MAX. CUTTER DIA.



SECTION B-B

R. L. STAFFORD

8-21-63

NOTE: FOR DIM NOT SHOWN SEE DWG. D-5406

600	RECEIVER	422,054		
MODEL	PART USE	CLASS	SEC	
DEPT/DAT	OWNED DATE	CHECK BY DATE	WIP-SP DATE	
	1-22-13		11/11/13	
TITLE RECEIVER				
NUMBER	SCALE	SUBSECTIONS IN NUMBER		
C-15787	3-1			
REMINGTON ARMS CO INC				
RESEARCH & DEV. DEPT.				

FORM ITC-1 (Rev. 2)



600 *per*

9/5/63

9:30 A

## 600-222 Receivers.

*Blasted + extra alms*

R4D  
HWS { 2- Finished by R. Cam in Almsco - Turned over to  
R Kelly - 1325 - 1327  
if add

to  
Mandley  
9/5/63  
4:00  
pm  
not polished  
properly { 4- Machined in Tool Room ready for Barrel Assembly  
ser # 1406, 1409, 1410, 1415 - regular alms  
2- Filed by files ready for Barrel Assembly  
ser # 1318, 1326 - regular alms

*all down bright*

1 - Waterman release pt back .030  
+ extra alms = 1323

1 - Waterman release pt back .060  
+ extra alms = 1324



1.00-222 CAL. RECEIVERS

9/16/63

(ALL ASSEM. BRIGHT)

GUN NUMBER		TOTAL RDS	REMARK	SLS. CHAMBS.	C.C. BOLT OVER SST.	C.H.	S.R.C.	
1325		96	EXTRA ALMCO	1				
1327		96	" "	2				
1406		NONE	T. R. MACH		OUT ?			
1406	RETEST	96	" REG ALMCO					CLEAN
1409	FRGD. SLR. BINDS BOLT	96	" "	2	✓	✓		
1410		96	" "	11			1	
1415		96	" "	1	release to easy ?			
1318		96	PROD. FILE REG. ALMCO					CLEAN
1326		96	" "	2				
1323		96	WATERMAN .030 EXT. ALMCO					1ST. SHELL OUT MAG. HARD UNDER RAIL
1324		96	WATERMAN .060 EXT. ALMCO					CLEAN
TOTAL MAL. 28/960 - 2.1%								




660  
CC: E. E. Folmsbee R. Stafford A. D. Kerr J. Scanlon  
R. W. Pugh

February 12, 1964

MODEL 600 RECEIVER 222 CALIBER  
C-1144 HIGH STRAIN TEMPERED STEEL

RECEIVED  
FEB 14 1964

CURRENT PRODUCTS  
*Process Engineering*

1. Meeting held 2/13/64 to establish the production controls required to process 7000 Model 600 Receivers (C-1144 high strain tempered steel).
2. The following were in attendance:  
L. J. Boyle      H. J. Hackman      R. B. Hurley      B. Gilbert  
E. J. Mock      V. G. DeReus      G. J. Hill  
F. H. Byrnes      E. R. Carr
3. Production controls authorized
  - A. Production Orders and Route Cards for the M/600 Receivers 222 Caliber (C-1144 material) are to be issued on the blue cards. B. Gilbert
    1. Production departments will be responsible to maintain the Blue Route Cards with each lot of the M/600 Receivers 222 Caliber (C-1144 material). E. J. Mock
    2. Planning Section to review scheduling of M/600 Receiver 222 Caliber (C-1144 material) so as to process between the M/700 Receiver runs. B. Gilbert
  - Proposed scheduling
    - A. Process lot of 700 Receivers-Short or Long Action
    - B. Process lot of M/600 Receiver 222 Cal. C-1144 material.
    - C. Process lot of M/700 Receivers-Short or Long Action.
  - B. Process Engineering to establish the following Currodine operations: E. Carr  
J. Hill
    1. Oper. 4T - to follow J & L Turret Lathe operation
    2. " 22T - " " Turn & Tap Operation Group
  - C. Process Engineering to establish permanent identification for the M/600 Receiver 222 Cal. (C-1144 material) J. Hill
    1. Oper. 193-5T - Stamp  - Top of Tang.
  - D. Production departments to correct all repair work on the M/600 Receivers 222 Cal. (C-1144 material) during the run of the Receivers. E. J. Mock



E. M/600 Receivers 222 Cal. (C-1144 material) are not to be retained in fixtures for setup purposes.

E.J.Mock

F. Process Engineering to order collets for the Cone Screw Machine for the processing of M/600 Receivers 222 Cal. (C-1144 material).

J.Hill

FHB:mc



650

CC: P. E. Group  
E. J. Hook  
R. H. Pugh

March 1, 1964

1. 1. 1. 1.

1/400 REPAIRS - FIXTURES

The following is a list of fixtures and pages that have pin locators for the 1/400 Receiver.

These pins should be removed as they are striking the face of the Receiver which leads to "bleeding" at solder. The pins should be replaced with flat locators.

Oper. 36 - Profile Magazine Slot  
(4) Fixtures E-51496 (same for Oper. 309 & 326).

Oper. 44 - Mill 312 - 205 Fire Control Slot  
Fixture E-55153 Page D-85061

Oper. 48 - Mill 097 - 092 Fire Control Slot  
Fixture D-85154 Page D-85063

Oper. 56 - Finish Mill Tang, Grooveless, Rear End  
Fixture E-85064 Page D-85065

Oper. 64 - Mill Extraction Cam Pin Bolt Handle Slot  
Fixture E-85079

Oper. 72 - Mill Safety Notch and Burr Tang  
Page D-85069

Oper. 81 - Finish Mill Bolt Handle Slot  
Fixture E-50525

Oper. 85 - Mill Bolt Handle Clearance Left Side and Burr  
Fixture E-50565

Oper. 88 - Head Mill Excess Material between Bolt Handle Slot and  
Extraction Cam Slot  
Fixture D-85072



E. T. DWYER

- 2 -

March 3, 1964

Oper. 92 - Mill Firing Pin Head Clearance  
Fixture E-50554 Gage D-65609

Oper. 106 - Hand Mill Finger Clearance  
Fixture D-85077 Gage D-85078

Oper. 135 - Mill Top Radius for Scope Mount  
Fixture E-50505

Oper. 141 - Buttmill Bolt Release Spring Seat  
Fixture D-85084 Gage D-85085

Process Eng. - Current Products  
R. B. Hurley, Supervisor

By R. L. Stafford  
R. L. Stafford  
Process Engineer

RLS/eb



60°  
R. B. Hunter  
note circled

Estimated Costs to Increase Receiver Length  
or Add Receiver Support to M/600.

11/7

RECEIVED  
NOV 7 1963

CURRENT PRODUCTS  
Process Engineering

Costs / c.  
Add. Rec'r Support      Increase  
   Lgth of Rec'r

Material.  
Tubing (1.5" @ 2.27 / ft) \*      1.78  
Steel      1.99.

Standard Labor      .77  
" Var.      .21  
Total Labor      .98

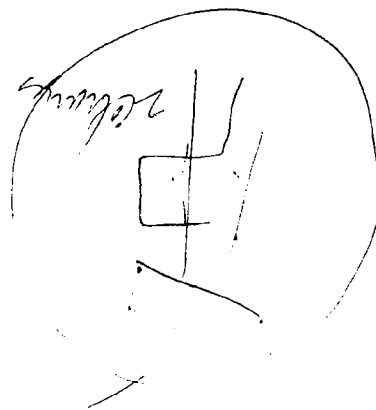
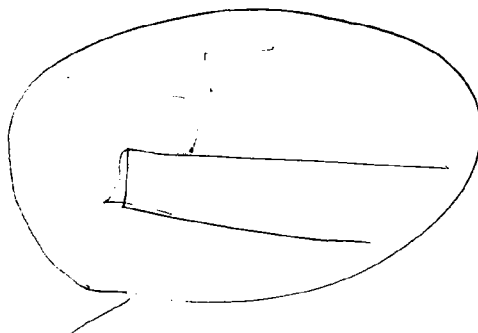
Ind Rel @ 23      .32

Direct Expenses      .23

Estimated out of pocket cost      3.31      1.99  
" " " " / gun      .033      .040  
" savings / gun           .013

\* This is price for small quantity - should be less if bought in larger quantities







# P. E. & C. ESTIMATE

TO: H. J. Hackman

ESTIMATED BY: R. P. Kelly - J. G. Reus

MODEL 600

PROJECT NO. \_\_\_\_\_

DATE 10/25/63

PROJECT TITLE Estimate to increase length of tang on m/600  
Receiver to eliminate extra operation on stock and  
nylon Receiver Support

	HOURS	RATE	TOTAL
PROCESS ENGINEERING & TRIAL RUN			—
TOOL DESIGN FIXTURES - GAGES	10	200	150
TOOLING FIXTURES - GAGES	55	1000	700
TOOL DESIGN — PERISHABLE TOOLS	7	—	50
TOOL DESIGN REVISIONS	28	50	200
PERISHABLE TOOLING	38	—	350
TOOL REVISIONS	120	100	850
TOOL REVISIONS - PERISHABLE		—	0
TESTING		—	—
ADMINISTRATION		—	—
VENDOR TOOLING COSTS (DIES ETC.)		—	—
VENDOR TOOLING NOT REMINGTON PROPERTY		—	—
SUB TOTAL		1350	2300
CONTINGENCIES		0	0
		1350	2300

COMMENTS

**RECEIVED**  
OCT 25 1963

CURRENT PRODUCTS  
Process Engineering



PROCESS ENGINEERING ESTIMATE-TRIAL AND PILOT SHEET.  
"SEQUENCE OF OPERATIONS"

MODEL 600 COMPONENT RECEIVER PART NO. 15406  
15787  
DATE 10/21/63 COMPUTER RLS #9411 SHEET 1 OF 2

OPER NO.	OPERATION NAME	MACHINE	DEPT NO.	HOURS DESIGN	HOURS BUILD
3	JAL			2	8
6	BROACH BORE TO FINAL I.D.			-	-
8	TURN O.D.			-	-
11	BURR			-	-
16	BROACH SLOTS			-	-
19	TAP BARREL HOLE			2	10
28	DRILL SCOPE HOLES			4	20
32	PLUNGE MILL MAG. SLOT			-	-
36	PROFILE MAG. SLOT			-	-
40	MILL EJECTION PORT			3	15
44	MILL .3125-.305 FIRE CONTROL SLOT			-	-
48	MILL .097-.092 FIRE CONTROL SLOT			-	-
52	SHAVE PRIMARY SEATING CAMS			4	20
56	MILL TANG CROSSWISE			5	25
60	MILL ANGLE ON TANG			7	35
64	MILL BOLT HANDLE SLOT			-	-
72	MILL SAFETY NOTCH			-	-
81	FIN. MILL BOLT HANDLE SLOT			2	10
85	MILL BOLT HANDLE CLEARANCE			-	-
88	HAND MILL EXCESS MATERIAL BETWEEN BOLT HANDLE SLOT & EXTRACTION CAM SLOT			-	-
92	MILL FIRING PIN HEAD CLEAR			-	-
96	HAND REAM			-	-
100	HAND MILL FINGER CLEAR.			-	-
108	METASILICATE WASH			-	-
110	MILL FIRE CONTROL SAFETY SLOT			4	20
112	PROFILE MAG. RECESS			-	-
114	DRILL FIRE CONTROL HOLES			-	-
125	BUTTMILL FEED RAMP			-	-
126	PROFILE 80° BEVEL .222 ONLY			-	-
127	MILL 30° BEVEL .308 & .35			-	-
131	SHAVE MAGAZINE SLOT			-	-
132	MILL 45° FEED RAMP			-	-
135	MILL SCOPE MOUNT RADIUS			-	-
139	TAP GUARD SCREW HOLES			-	-
141	B MILL BOLT RELEASE SPRING SEAT			3	15
143	TAP SCOPE HOLES			-	-
144	DEBURR SCOPE HOLES			-	-
145	DRILL & TAP MAGAZINE SUPPORT SCREW HOLE			-	-
150A	CYLINDRICAL GRIND			-	-
156	FINISH FILE			-	-
160	ROLL MARK			-	-
164	SERIAL NO.			-	-
168	AUSTEMPER			-	-
SUB TOTAL				36	178



### • SEQUENCE OF OPERATIONS •

DATE 10/21/63 COMPUTER RLS & GATH

SHEET 2 OF 2

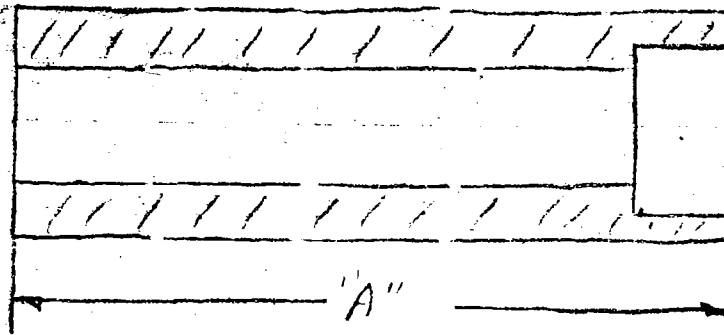
FD-350 1-15-55



• COMPUTATION •

TOOLING	DRAWING NUMBER	REMARKS	HOURS DESIGN	HOURS BUILD
LENGTH GAGE		New	2	8
"A" 6940 AP				
ALL OTHER TOOLS		A.U.		
TOTAL			2	8

SKETCH



INCREASE WEIGHT PER Piece = .113#



• COMPUTATION •

TOOLING	DRAWING NUMBER	REMARKS	HOURS DESIGN	HOURS BUILD
FIXTURE	E-86173	ALTER	2	10
- CHANGE CLAMP LENGTH to 6.940 P				
- NEW KEY SLOT				
ALL OTHER TOOLING		AU		
TOTAL			2	10

**SKETCH**



• COMPUTATION •

TOOLING	DRAWING NUMBER	REMARKS	HOURS DESIGN	HOURS BUILD
DRILL JIG	D-85052	ALTER	4	20
- INCREASE CLAMP LENGTH TO 6.940" - REQUIRING NEW BLOCKS FOR END OF FIXTURE				
ALL OTHER TOOLING		AV		
TOTAL			4	20

### SKETCH

NEW MACHINE WHEN IN USE WILL ELIMINATE THIS ALTERATION.



• COMPUTATION •

15206

(3)

25

**CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER**  
**KINZER V. REMINGTON**

R2528640



• COMPUTATION •

15206.

4 20

RD-6567 1-18-65



# PROCESS ENGINEERING ESTIMATE-TRIAL AND PILOT SHEET

## • COMPUTATION •

MODEL 600 COMPONENT RECEIVER PART NO. 15406  
 OPERATION MILL TANG CROSSWISE OPER. NO. 56  
 MACHINE CINN. 2-24 RISE & FALL MILLER DEPT. NO. 57  
 COMPUTER ALS 2490 DATE 10/21/63 SHEET 1 OF 1

TOOLING	DRAWING NUMBER	REMARKS	HOURS DESIGN	HOURS BUILD
FORM & CUTTER		NEW	3	11
BASE GAGE MOVE FRONT LOCATING BLOCK	D-85215	ALTER	2	10
ALL OTHER TOOLING		A.V.		
TOTAL			5	25

SKETCH

RD-6567 11-8-63



• COMPUTATION •

TOOLING	DRAWING NUMBER	REMARKS	HOURS DESIGN	HOURS BUILD
FIXTURE	D-85466	ALTER	4	20
MOVE REAR LOCATOR (IF ANGLE IS CHANGED THEN NEW FIXTURE)				
CUTTER		NEW	3	15
ALL OTHER TOOLING		A.W.		
TOTAL			.7	35

SKETCH

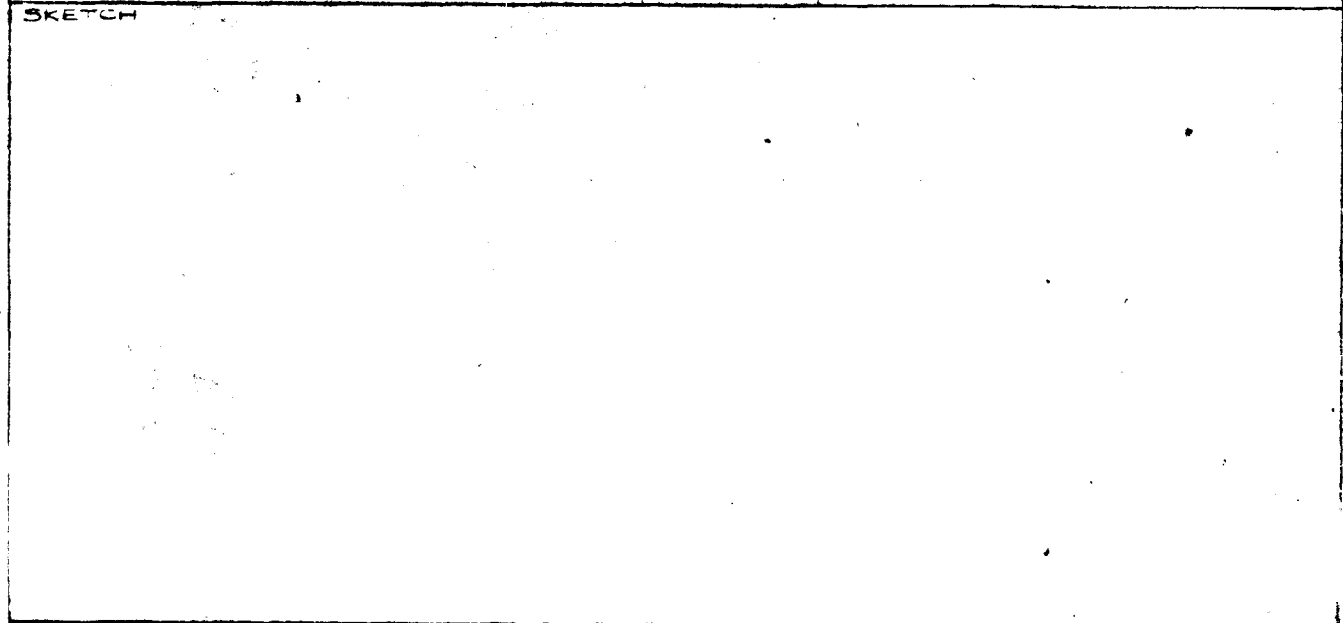


# PROCESS ENGINEERING ESTIMATE-TRIAL AND PILOT SHEET •COMPUTATION•

MODEL 600 COMPONENT RECEIVER PART NO. 15406  
 OPERATION FINISH MILL BOLT HANDLE SLOT OPER. NO. 81  
 MACHINE EO-8 CINCINNATI PLAIN MILLER DEPT. NO. 54  
 COMPUTER RLB DATE 10/2/11 SHEET 1 OF 1

TOOLING	DRAWING NUMBER	REMARKS	HOURS DESIGN	HOURS BUILD
BASE GAGE (NEW INTERCHANGEABLE REAR LOCATING PIN)	D-50453	ALTER	2	10
ALL OTHER TOOLING		A.U.		
TOTAL			2	10

SKETCH



RD-6567 1-12-58



• COMPUTATION •

TOOLING	DRAWING NUMBER	REMARKS	HOURS DESIGN	HOURS BUILD
FIXTURE	D-86505	ALTER	4	20
NEW REAR CLAMP				
ALL OTHER TOOLING		R.D.		
TOTAL			4	20

**SKETCH**



• COMPUTATION •

TOOLING	DRAWING NUMBER	REMARKS	HOURS DESIGN	HOURS BUILD
DRILL JIG NEW INTERCHANGEABLE READ CLAMP	D-85084	ALTER	3	✓
ALL OTHER TOOLING		A.D.		
TOTAL			3	✓

9月15日



## • COMPUTATION •

15402

PART NO. 15787

OPER. NO. 62

**✓ MACHINE**

DEPT. NO. 51

SHEET 1 OF 1

9

SKETCH

PROPOSED OPERATION - OBJECT IS TO KEEP  
COMMON <sup>CUTOFF</sup> LENGTH FOR M/600 & M/XP-100 TO  
THIS OPERATION FROM J. E. LATH.



M/600 - Accuracy



cc HAH, ASH, SMH, WLD, LPH  
R B Henley

m/600 6.5mm Accuracy.  
Accuracy Purip 100 yd by Palmer  
2-5 shot groups.

11/8/65

	E.S.	E.H.	E.H.	
* 56043	1.94	1.84	.75	Ring in Chamber (Polished out)
	<u>1.25</u>	<u>1.20</u>	<u>.80</u>	
Aver.	1.605	1.53	.775	
56405	2.25	1.63	2.15	Ring in Chamber (Polished out)
	<u>3.53</u>	<u>.95</u>	<u>3.50</u>	
Aver.	2.905	1.29	2.825	
55133	3.02	1.77	2.36	
	<u>3.33</u>	<u>2.17</u>	<u>2.80</u>	
Aver.	3.175	1.97	2.58	
56067	1.87	1.87	1.85	Ring in Chamber (Polished out)
	<u>3.65</u>	<u>2.52</u>	<u>2.74</u>	
Aver.	2.76	2.195	2.295	
Average	2.611	1.746	2.119	

Need low F.S. - low R.S. base set with 1 as block.

\* This gun delivered to Walt Stahl 11/9/65 for use by  
Rpt. in Comm. testing.

CR



M/600 - 6mm.  
(FRONT SIGHT .050 HIGHER.)

4.71)

PROJ NO

WORKS

DATE 4-16 19 64

HEIGHT OF REAR SIGHT EYE PIECE ABOVE RIB AFTER  
TARGET (TOP OF RIB TO BOTTOM OF EYE PIECE)

GUN NO	HI	LO	LEFT	RIGHT	HEIGHT FROM RIB TO BOTTOM OF EYE PIECE	
						CORRECTED
10172		15	0	0	.130	.130
10043	0	0		1.0"	.125	.125
10066	0	0"	1.0"		.120	.120
10109		1.0"	0	0	.120	.124
10069	1.0"		1.0"		.130	.126
10145	0		1.0"	0	.120	.120

6/ ~~.124~~  
747  
.123  
Q. 0.

TARGET BY L. EVANS.

132



TITLE OF PROJ.

SUBJECT

11/600 6 AMM Accuracy Ammun. Code R055 100 GR PSP 3/11/64 (67)			
	L. EVANS (5X Scope)		RTR (20X Scope)
5505	2.20 <u>2.20</u>	2.20	3.00
5557	1.40 <u>1.63</u>	1.515	2.15
5502	1.17 <u>1.83</u>	1.50	2.37
5507	90 <u>3.35</u> (1.55)	2.125	2.00
5581	2.10 <u>1.40</u>	1.75	2.00
5504	1.35 <u>1.55</u>	1.45	2.35
6 gr QWR.		1.757"	2.317"



TO: (1) <u>V. DEREW</u>	TO DO DESIGN BUILD OR ALTER	EST. HRS.	REQ'D.	WORK ORDER
(2) <u>E. DWYER</u>				
(3)				
(4)				

DATE: 6/16/64 CHARGE -- DEPT.: \_\_\_\_\_  
 MODEL: 600 PART NO.: \_\_\_\_\_ ☐ New Tooling  
 COMPONENT: BARREL GA./CAL.: \_\_\_\_\_ ☒ Replacement Tooling  
 OPERATION NO.: \_\_\_\_\_ NAME: R & F TURN FILL LENGTH  
 TOOL DWG. NO.: \_\_\_\_\_ NAME: FINISH TURN TEMPLATE  
 DESCRIPTION OF WORK & DISPOSITION OF TOOLING: DESIGN & MAKE TEMPLATE  
TO REPLACE D-P7180 - DESIGN PER SHEET H  
ATTACHED  
 REASON FOR CHANGE: TO BE COMPATIBLE WITH NEW ROUGH TEMPLATE  
 INITIATED: R. B. H. H. ESTIMATED: \_\_\_\_\_ APPROVED: \_\_\_\_\_  
 REQUEST FOR TOOL DESIGN OR REVISION



TO: (1) <u>V. DE PAUS</u>	<u>TO DO</u> <u>DESIGN</u> <u>BUILD OR ALTER</u>	<u>EST. HRS.</u>	<u>REQ'D.</u>	<u>WORK ORDER</u> <u>85880</u> <u>85880</u>
(2) <u>E. DWYER</u>				
(3)				
(4)				

DATE: 6/17/64 CHARGE — DEPT.: \_\_\_\_\_

MODEL: 600 PART NO.: \_\_\_\_\_ ☐ New Tooling  
☒ Replacement Tooling

COMPONENT: BARREL GA./CAL.: \_\_\_\_\_

OPERATION NO.: \_\_\_\_\_ NAME: R & F TURN FULL LENGTH

TOOL DWG. NO.: \_\_\_\_\_ NAME: SET MASTER

DESCRIPTION OF WORK & DISPOSITION OF TOOLING: DESIGN & MAKE NEW  
SET MASTER TO REPLACE D-86596  
DESIGN FOR SET I ATTACHED

REASON FOR CHANGE: TO BE COMPATIBLE WITH OTHER LONGER DR  
GAGING.

INITIATED: [Signature] ESTIMATED: \_\_\_\_\_ APPROVED: \_\_\_\_\_

RD-6241 REV. 1-53 REQUEST FOR TOOL DESIGN OR REVISION [Signature]



TO: (1) <u>V. DE REUS</u>	<u>TO DO</u> <u>DESIGN</u> <u>BUILD OR ALTER</u>	<u>EST. HRS.</u>	<u>REQ'D.</u>	<u>WORK ORDER</u> <u>85880</u> <u>85880</u>
(2) <u>E. DWYER</u>				
(3)				
(4)				
DATE: <u>6/17/64</u>	CHARGE - DEPT.: _____			
MODEL: <u>600</u>	PART NO.: _____	<input type="checkbox"/> New Tooling <input type="checkbox"/> Replacement Tooling		
COMPONENT: <u>BARREL</u>	GA./CAL.: _____			
OPERATION NO.: _____	NAME: <u>R &amp; F TURN FULL LENGTH</u>			
TOOL DWG. NO.: _____	NAME: <u>ROUGH TURN TEMPLATE</u>			
DESCRIPTION OF WORK & DISPOSITION OF TOOLING: <u>DESIGN &amp; MAKE TEMPLATE</u> <u>TO REPLACE D-87179 - DESIGN PER</u> <u>SHEET H ATTACHED</u>				
OBSOLETE VALUE \$ _____				
REASON FOR CHANGE: <u>TO ELIMINATE TOOL BREAKAGE</u>				
INITIATED: <u>[Signature]</u>	ESTIMATED: _____	APPROVED: _____		
RD-6241 REV. 1-53				
REQUEST FOR TOOL DESIGN OR REVISION				

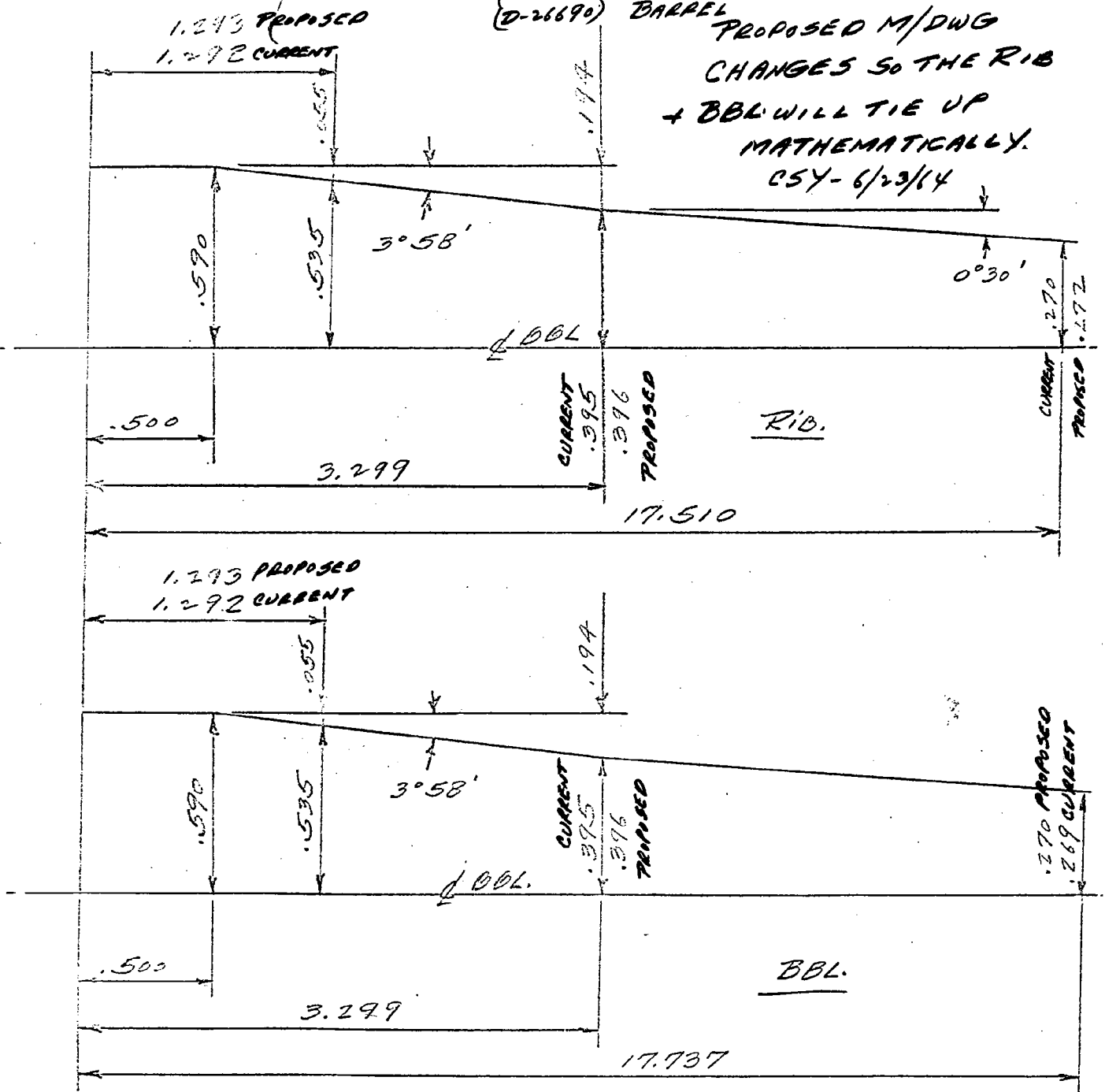
Dirk  
6/18



TO: (1) <u>V. DEREW</u> (2) <u>E. DWYER</u> (3) _____ (4) _____	TO DO DESIGN BUILD OR ALTER	EST. HRS. _____ _____	REQ'D. _____ _____	WORK ORDER <u>85880</u> <u>85880</u>
DATE: <u>6/16/64</u>		CHARGE — DEPT.: _____		
MODEL: <u>600</u> PART NO.: _____		<input type="checkbox"/> New Tooling <input checked="" type="checkbox"/> Replacement Tooling		
COMPONENT: <u>BARREL</u>		GA./CAL.: _____		
OPERATION NO.: _____		NAME: <u>R &amp; F TURN FILL LENGTH</u>		
TOOL DWG. NO.: _____		NAME: <u>FINISH TURN TEMPLATE</u>		
DESCRIPTION OF WORK & DISPOSITION OF TOOLING: <u>DESIGN &amp; MAKE TEMPLATE</u> <u>TO REPLACE D-P7180 - DESIGN PER SHEET H</u> <u>ATTACHED</u>				
OBSOLETE VALUE \$ _____				
REASON FOR CHANGE: <u>TO BE COMPATIBLE WITH NEW ROUGH TEMPLATE</u>				
INITIATED: <u>R. Blumley</u>		ESTIMATED: _____		APPROVED: _____
RD-6241 REV. 1-53		REQUEST FOR TOOL DESIGN OR REVISION		

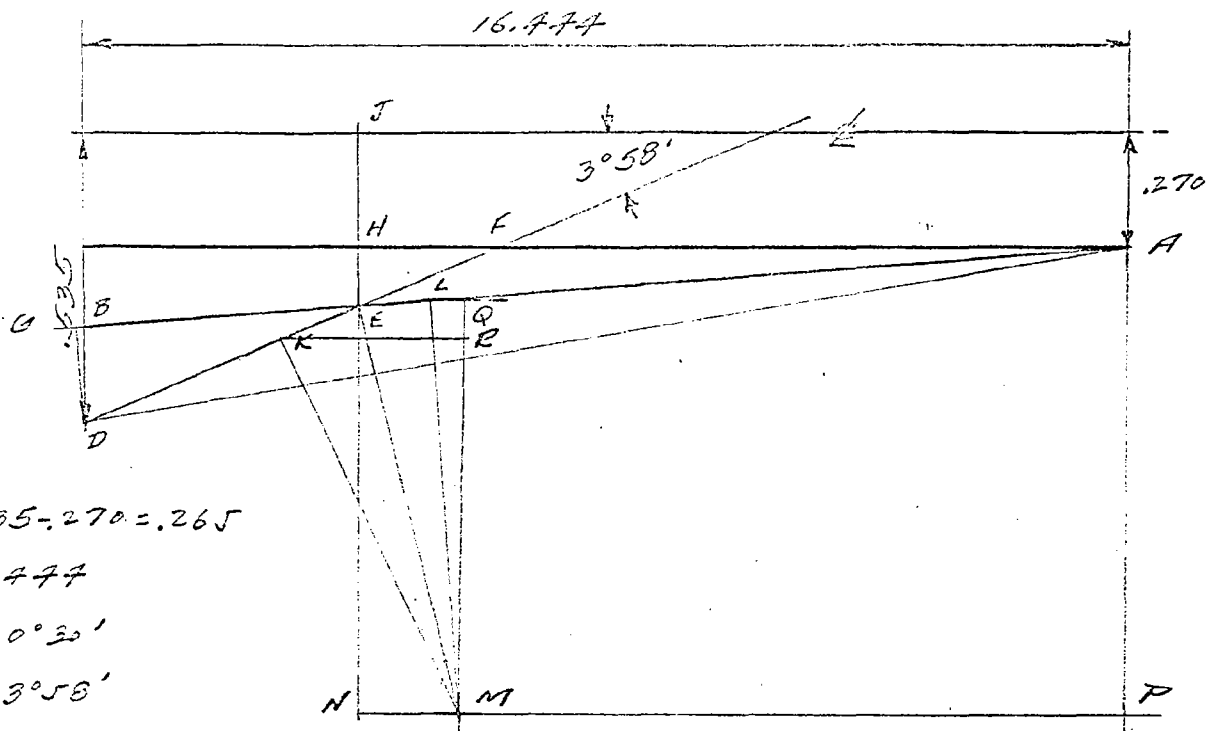


M/600  
 (D-15488) BARREL RIB SHEET 1 OF 3  
 (D-26690) BARREL  
 PROPOSED M/DWG  
 CHANGES SO THE RIB  
 + BBL WILL TIE UP  
 MATHEMATICALLY.  
 CSY-6/23/14



396  
 2  
 192





$$DC = .535 - .270 = .265$$

$$AC = 15.777$$

$$\angle CAB = 0^\circ 30'$$

$$\angle CFD = 3^{\circ} 58'$$

$$\angle EFA = 180^\circ - \angle CFD = 176^\circ 2'$$

$$\angle FEA = 180^\circ - (\angle EFA + \angle EAB) = 3^\circ 28'$$

$$\angle DEA = 180^\circ - \angle FEA = 176^\circ 32'$$

$$DA = \sqrt{AC^2 + DC^2} = \sqrt{16.449^2 + 2.65^2} = \sqrt{270.405136 + 0.70225} = 16.44614$$

$$\tan \angle CAD = \frac{DC}{AC} = \frac{.265}{16.444} = .01612 = 0^\circ 55' 25''$$

$$LEAD = \angle CAD - \angle CAB = 0^\circ 55' 25'' - 0^\circ 30' = 0^\circ 25' 25''$$

$$LEOA = 180^\circ - (LEAD + LDEA) = 3^\circ 2' 35''$$

$$GD = AD \sin LEAD = (16.44614)(.00739) = .12154$$

$$AE = ADC - LEAD = (6.49614)(.99997) = 6.44565$$

$$\angle GCO = \angle FEA = 3^\circ 48'$$

$$GE = GD \text{ cut } LGED = (112154)(16.507) = 2.00626$$

$$AE = AG - GE = 16.47565 - 2.00626 = 14.46939$$

$$JH = .270$$

$$HE = AE \sin 0^\circ 20' = (14.43739)(0.375) = .12606$$

$$AH = AE \cos \phi = (14.73739)(.99975) = 14.73881$$

$$JF = JH + HF = .270 + .12606 = .39606$$

$$105 - 104 = 1$$

$$\angle ECL = 206.1 = 176^{\circ} 35'$$

$$\angle ECH = \angle HCL = \frac{45^\circ}{2} = 22.5^\circ$$



$$LKME = L LME = 90^\circ - L KEM = 1^\circ 44'$$

$$EM = MK / \sin L KEM = 4.00 / .99954 = 4.00184$$

$$LHEA = 90^\circ - 0^\circ 50' = 89^\circ 20'$$

$$LHEM = LHEA + LME = 177^\circ 45'$$

$$LNEM = 180^\circ - LHEM = 2^\circ 14'$$

$$LEMN = 90^\circ - LNEM = 87^\circ 46'$$

$$NE = EM \sin LEMN = (4.00184)(.99724) = 3.9928$$

$$MN = EM \sin LNEM = (4.00184)(.3877) = .15595$$

$$PN = AH = 14.43381$$

$$PII = PN - MN = 14.43381 - .15595 = 14.28286$$

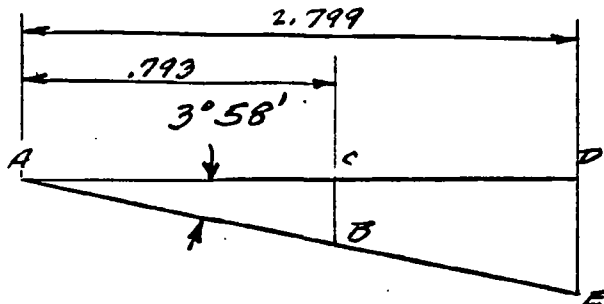
$$JH = JH + HE + NE = 4.39786 \text{ ans}$$

$$JE = JH + HE = .39606 \text{ ans}$$

$$\begin{array}{r} 17.737 \\ - 14.283 \\ \hline 3.454 \end{array}$$



SHEET  
1 A.



$$AC = .793$$

$$BC = AC \tan 3^{\circ}58' = (.793)(.6934) = .05499$$

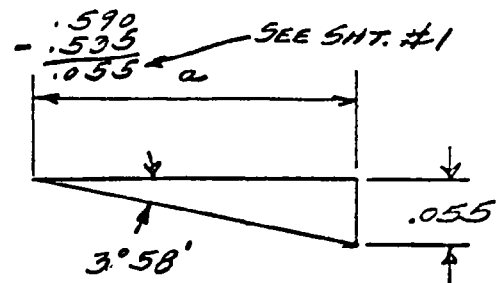
$$AD = 3.299 - .500 = 2.799$$

$$DE = AD \tan 3^{\circ}58' = (2.799)(.6934) = .19408$$

(PROPOSED)

$$.590 \text{ M/DWG} - .194 = .396 \text{ COMPARES}$$

$$\text{WITH } \frac{.790}{2} = .395$$



$$a = (.055)(\cot 3^{\circ}58')$$

$$a = (.055)(14.421) = .79316$$

$$\begin{array}{r} .500 \\ + .793 \\ \hline 1.293 \end{array} \text{ COMPARES WITH } \text{M/DWG } 1.292$$

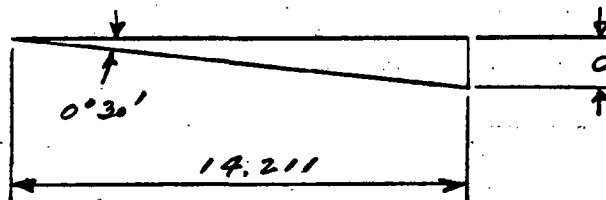
17.510 LENGTH OF RIO

- 3.299 DISTANCE FROM END OF RIO TO INTERSECTION OF  $3^{\circ}58'$  +  $0^{\circ}30'$  ANGLES

$$14.211$$

LENGTH OF RIO

WHERE  $0^{\circ}30'$  ANGLE



$$.39600$$

$$- .12406$$

$$.27194 \text{ OR SAY } .272$$

(PROPOSED)

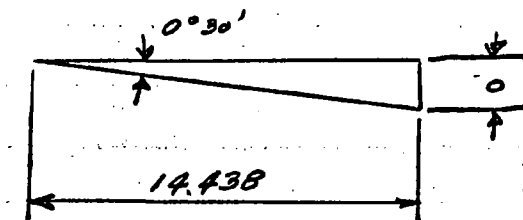
$$18.615 \text{ OBL. LENGTH}$$

$$- .878 \text{ HUB LENGTH}$$

$$17.737 \text{ FROM HUB TO MUZZLE}$$

$$- 3.299$$

14.438 DISTANCE FROM MUZZLE TO INTERSECTION OF  $3^{\circ}58'$  +  $0^{\circ}30'$  ANGLES.



$$0 = (14.438)(.00873) = .12604$$

$$\begin{array}{r} .396 \\ - .126 \\ \hline .270 \end{array}$$

PROPOSED RADIUS AT MUZZLE

.540 PROPOSED DIA AT MUZZLE



## WORK ORDER

FROM DEPT. <b>28</b>	TO DEPT. <b>28</b>	CRAFT	WORK ORDER NUMBER
DATE ISSUED <b>7-10-64</b>	DATE REQ'D <b>8/17/64</b>	ACCOUNT <b>9923-01</b>	
MODEL <b>600</b>	DIRECT	INDIRECT	
COMPONENT <b>BARREL</b>			
OPERATION & NO. <b>ROUGH &amp; FINISH TURN</b>			
QUANTITY <b>1 ea</b>	NAME OF TOOL <b>TAIL STOCK CENTER ASS'y.</b>		
DWG. NO. <b>B-86249</b>	INV. NO. & SUFFIXES	MARK	
SUPERSEDED BY DWG. NO.	SUPERSEDES OLD DWG. NO.		
DESCRIPTION OF WORK: <b><del>REWORK ONLY</del> alt 3</b>			BLDG.
<b>make new "B" "C" &amp; "D"</b>			
<b>* ADD TO PROCESS RECORDS</b>			
<b>(return to cutter shop)</b>			
DWG. APPROVED <b>[Signature]</b>			EST. COST
ISSUED BY <b>RS</b>	DATE APPROVED <b>7/13/64</b>	APPROVED	COMPLETED
<b>[Signature]</b>			ACT. COST
			COST
			CLOSED

M.D. - 115  
check - believe  
this is large  
& shipping equip

**[Signature]** 7/17/64







DRAWING No. <b>A-86249-3</b>		REMINGTON ARMS COMPANY, INC. ILION, N. Y.		CONST'N DWG. <b>B-86249</b>	ADDITIONAL USES	RECORD OF ALTERATIONS
SCALE <b>FULL</b> MODEL <b>XP-100</b> PART DWG. NO.				DETAILS		
PART <b>BARREL</b>						
TOOL <b>TAIL STOCK CENTER ASSY.</b>						
OPERATION <b>ROUGH &amp; FINISH TURN</b>						
SUP'D'S DWG. NO.		CHECKED	DATE			
DESIGNED	BY	DATE	TRACED			
DRAWN	<b>LIRTE</b>	<b>1/22/68</b>				
TOLERANCES NOT OTHERWISE SPECIFIED						
1 PLACE (.1) - TOLERANCE $\pm .01$						
2 PLACE (.01) - TOLERANCE $\pm .015$						
3 PLACE (.001) - TOLERANCE $\pm .005$						

**MARK  
B-86249-A**

**MUST BE  
CONCENTRIC  
WITH .219 DIA.**

**TOOL STEEL  
ROCK C-56-58**



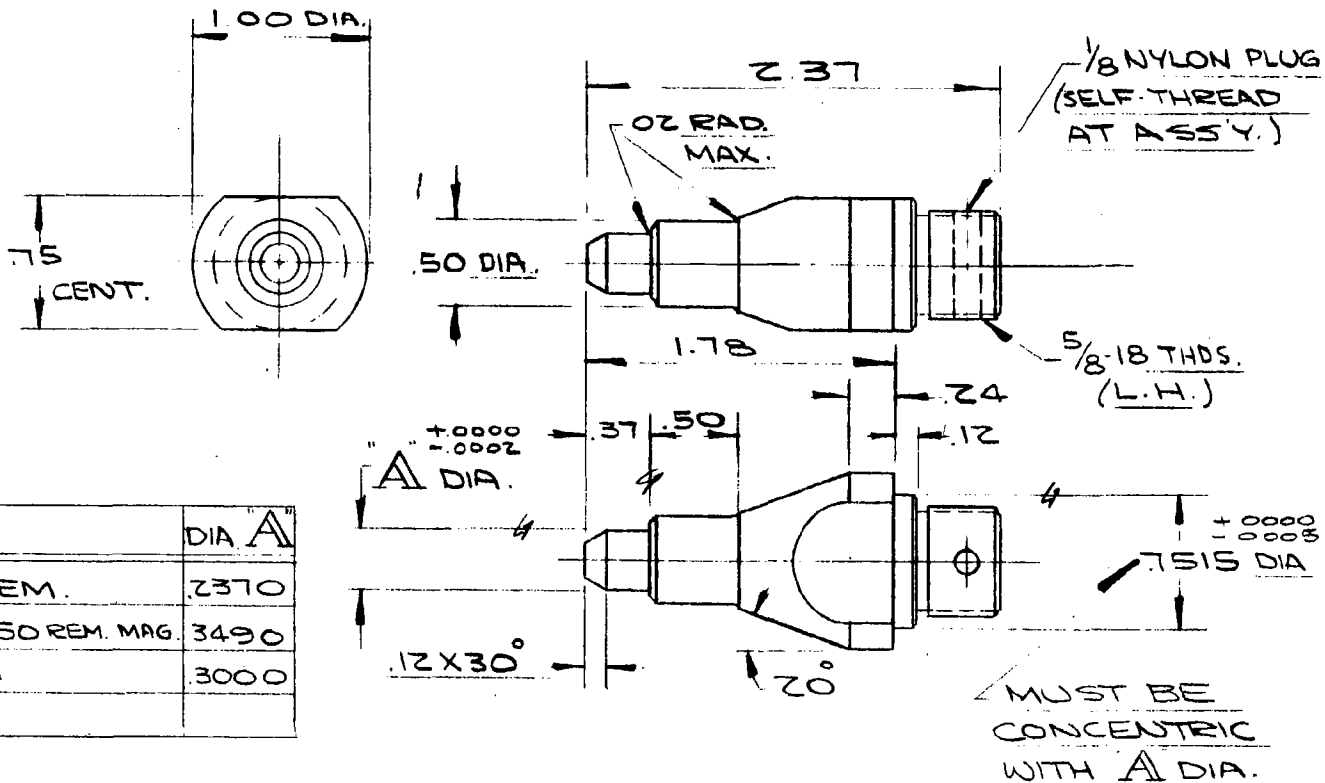
JUL 29 1964



DRAWING NO. <b>A-86249-4</b>		REMINGTON ARMS COMPANY, INC. ILION, N. Y.		CONST'N DWG.	ADDITIONAL USES	RECORD OF ALTERATIONS
SCALE <b>FULL</b> MODEL <b>600</b> PART DWG. NO.				DETAILS		
PART <b>BARREL</b>						
TOOL <b>TAIL STOCK CENTER ASSEMBLY</b>						
OPERATION <b>ROUGH &amp; FINISH TURN</b>						
SUP'D'S. DWG. NO.		CHECKED	BY	DATE		
DESIGNED	BY	DATE	TRACED			
DRAWN	<b>R SHITH</b>	<b>7-10-64</b>	APPROVED			

TOLERANCES NOT OTHERWISE GIVEN	
1 PLACE (.1) - TOLERANCE	±.08
2 PLACE (.01) - TOLERANCE	±.015
3 PLACE (.001) - TOLERANCE	±.0005

DETAIL NO	MARK	DIA "A"
4-4	B-86249-B~6MM. REM.	.2370
5-4	B-86249-C~35REM.~350 REM. MAG.	.3490
6-4	B-86249-D~308WIN.	.3000



MATL. SPEC TS  
ROCK. "C" 58-60

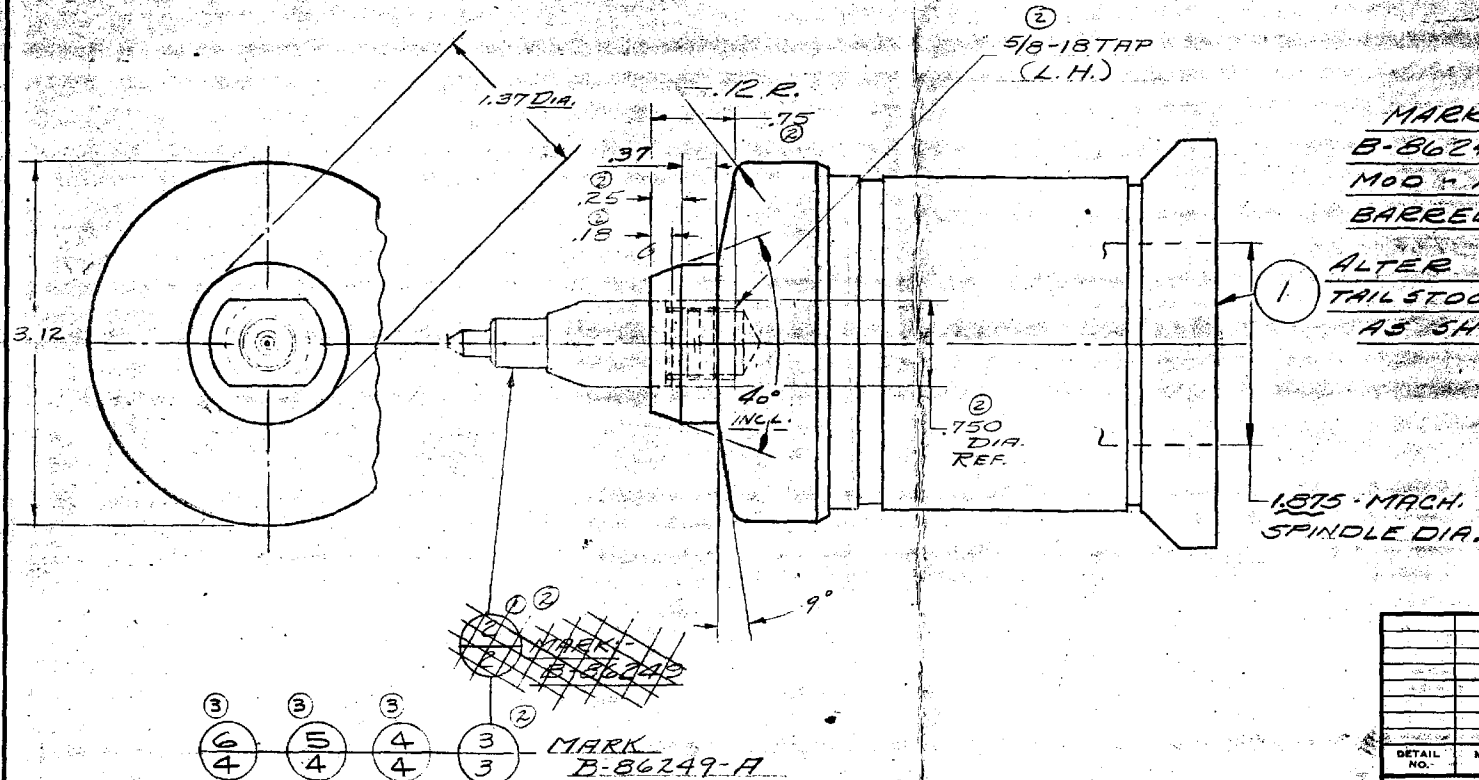


APR 23 2013



67390-2

UNLESS OTHERWISE SPECIFIED  
REMOVE ALL BURRS AND  
SHARP CORNERS — .010R



MARK:  
B-86249  
MOD - XP-100  
BARREL  
ALTER STD. READY TOOL CO.  
TAIL STOCK ASSEM. #050-4  
AS SHOWN

③ ③ ③ ③  
⑥ ⑤ ④ ③  
④ ④ ④ ③  
MARK  
B-86249-A

DIMS. NOT GIVEN TO BE SCALED

RECORD OF ALTERATIONS		ADDITIONAL USES	CONST'N. DWG.	DETAILS	OPERATION
① REDESIGNED END & ADDED DET. 2/2 & DET. 5/4 T.		③ M/600 BARREL - 6MM. REM, 35 REM.		① B-86249-2	TOOL TAIL STOCK CENT ASSEM.
A-86249-2 TDR 1/4/63 ② REDESIGNED FRONT END -		350 REM MAG & 308 WIN. CAL.		② A-86249-3	OPERATION ROUGH & FINISH TURN
REMOVED DET. 2/2 (OBSOLETE A-86249-2) - & ADDED DET.				③ A-86249-4	
3/2 (A-86249-3) TDR 4-24-63 ③ ADDED NEW MODEL & CAL. ADDED					
SHEET # A-86249-4 & DETS 4/4, 5/4 & 6/4 R. SMITH 7-10-64 TDR.					

DETAIL NO.	MATERIAL SPEC.	STOCK SIZE	AMOUNT REQ.
TOLERANCES NOT OTHERWISE GIVEN			
1 PLACE (.1) - TOLERANCE ± .05			
2 PLACE (.01) - TOLERANCE ± .015			
3 PLACE (.001) - TOLERANCE ± .0005			
REMINGTON ARMS COMPANY, INC., ILION, N. Y.			
SCALE FULL MODEL XP-100 PART DWG. NO. 26760			
PART BARREL			
DESIGNED BY DATE APPROVED BY DATE			
DRAWN HAZE 4-27-62 SUPD'S DWG. NO.			
CHECKED DRAWING NO. B-86249			







M/600 - Quality



DATE	10-20-66
SAMPLE	18
TOTAL DEMERITS	94
D. P. U.	5.2
D. P. U. MON. TO DATE	2.0

MODEL	S.S.	DEM.	MOTFL	S.S.	DEM.
11-48	2		N/10 & N/11		
870	3		N/12		
1100	3		510X & 511X		
600	2	51	512X		
700	2	1	514		
742	2		550-1		
760	2	20	552		
			572		
			N/66	2	22
			N/76		
Total	16	72	Total	2	22

M/600	308 CAL	D.E. AFTER 10 <sup>TH</sup> RD. (EJECTOR STUCK)	50
M/760C	35 "	NO PLAY AT TRIG. & BUSHING. ✓	10
"	"	" " " " " " " " ✓	10
N-66	1-	CTG. FEED GUIDE SPRING LOOSE	10
	2-	POOR PLATE ON BAL.	10



CC: L. Fox  
R. B. Hurley  
N. S. Thompson  
W. A. Best

L. J. Boyle  
G. E. Puckett  
W. J. Scott  
M. J. Tibbits  
File

WAREHOUSE AUDIT REPORT  
(QUALITY ADULT RETEST)

DATE 3-10-67

MODEL 600 ~~ENGINE~~ OR CAL. 350 R. M.

REASON FOR RETEST 1/2 samples 3-7-67 opens hard and last c'tg. stems  
incline

RETEST DATE 2-9-67 SAMPLE SIZE 4 PRODUCTION DURING PERIOD 8 (3-6-67)

PROD. WHSE. GA./  
DATE SAMP. CAL.

3-6-67 4 350 R. M.

RESULTS OBSERVED

#2104 - Bolt stems second c'tg.  
feeding first.  
#2208 - Last c'tg. feeds hand  
under rail.

ACTION TAKEN \_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_

QUALITY CONTROL DEPARTMENT  
N. W. Menard, Supervisor

By W. T. Scanlon  
c. m.

NHM/cm  
1-20-67



CC: H. J. Hackman  
R. B. Hurley  
W. A. Best  
L. J. Boyle  
R. E. Wright  
C. O. Pardee  
G. J. Markley

FINISHED GUN QUALITY AUDIT  
RETEST REPORT

DATE 11-18-65

MODEL 600 GAUGE-OR CAL. 350 R. M.

REASON FOR RETEST 2/2 samples 11/16/65 incorrect epoxy mixture.

RETEST DATE 11-18-65 SAMPLE SIZE 10 LOT SIZE 64

NUMBER DEFECTIVE GUNS FOUND IN RETEST 3

ACTION TAKEN Remaining 54 withdrawn from Warehouse and  
repaired if necessary.

COMMENTS:

QUALITY CONTROL DEPARTMENT  
N. W. Menard, Supervisor

By W. T. Scanlon  
W. T. Scanlon *et*

NWM/eb



CC: H. J. Hackman  
R. B. Hurley  
W. A. Best  
L. J. Boyle  
W. J. Scott  
C. O. Pardee  
R. E. Wright  
G. J. Markley

FINISHED GUN QUALITY AUDIT  
RETEST REPORT

DATE 6-15-65

MODEL 600 CAL. .243

REASON FOR RETEST 1 of 2 samples of 6/14/65 - "Jars off".

RETEST DATE 6/15 SAMPLE SIZE 30 LOT SIZE 297

NUMBER DEFECTIVE GUNS FOUND IN RETEST 1 (day firing)

ACTION TAKEN Cause: Scant Sear engagement. Repaired by  
Process Engineering. Assemblers restructured to adjust for  
more engagement. Process Engineering investigating chrome  
plating process.

COMMENTS:

Sample

June 9 - 10  
10 - 10  
11 - 10  
  
Tot. - 30

QUALITY CONTROL DEPARTMENT  
N. W. Menard, Supervisor

By W. T. Scanlon  
W. T. Scanlon *eb*

WBM/eb



CC: H. J. Hackman  
~~E. E. Hurlet~~ *2/16*  
W. A. Best  
L. J. Boyle  
R. E. Wright  
W. J. Scott  
G. J. Markley  
R. J. Chesebrough

FINISHED GUN QUALITY AUDIT  
RETEST REPORT

DATE 2-16-66

MODEL 600 ~~GAUGE~~ or CAL. 350 R.M.

REASON FOR RETEST Barrel beds on front swivel screw

RETEST DATE 2-16 SAMPLE SIZE 10 LOT SIZE from Final Insp.

NUMBER DEFECTIVE GUNS FOUND IN RETEST 5

ACTION TAKEN Swivel screws for this model will be shortened  
approx. 1" (4 threads)

COMMENTS:

QUALITY CONTROL DEPARTMENT  
N. W. Menard, Supervisor

By W. T. Scanlon  
W. T. Scanlon *W*

NWM/eb



CC: H. J. Hackman  
W. A. Best  
L. J. Boyle  
R. E. Wright  
W. J. Scott  
C. O. Pardee  
G. J. Markley

FINISHED GUN QUALITY AUDIT  
SPEC. RETEST REPORT

DATE 8-24-65

MODEL 600 GAUGE or CAL. 308

REASON FOR RETEST To verify corrective action taken at reaming  
operation to remove brazing material - Refer - Ejector binds back.

RETEST DATE 8/24/65 SAMPLE SIZE 5 \* LOT SIZE 30

NUMBER DEFECTIVE GUNS FOUND IN RETEST None

ACTION TAKEN \_\_\_\_\_

COMMENTS:

\* Test - 32 rds., each gun - after regular Gallery Test.

QUALITY CONTROL DEPARTMENT  
N. W. Menard, Supervisor

By W. T. Scanlon  
W. T. Scanlon

N. W. Menard



CC: H. J. Hackman  
R. B. Hurley  
W. A. Best  
L. J. Boyle  
R. E. Wright  
W. J. Scott  
M. E. Rogers  
C. O. Pardee  
C. J. Markley

FINISHED GUN QUALITY AUDIT  
RETEST REPORT

DATE 2-21-66

MODEL 600 GAUGE or CAL. 350 Win. Mag.

REASON FOR RETEST 2/2 Samples, proof stamps missing on  
barrel and bolt

RETEST DATE 2-21-66 SAMPLE SIZE 15 LOT SIZE 2/17 128  
2/18 27  
155

NUMBER DEFECTIVE GUNS FOUND IN RETEST 3

ACTION TAKEN \_\_\_\_\_

COMMENTS:

Warehouse and line screened.  
Warehouse 29 Proof stamps missing  
Line 7 Proof stamps missing  
Qual. Aud. 2  
123

QUALITY CONTROL DEPARTMENT  
N. W. Menard, Supervisor

By W. T. Scanlon  
W. T. Scanlon *W*

NWM/eb







M/600 - sights



P. E. & C. ESTIMATE

WE look SIMA 100  
 RP Kelly  
 4/13/64  
 ESTIMATED BY: J. D. Kemp - V. G. J. Remy

TO: H. J. Hickman

MODEL 600

PROJECT NO.

DATE 4/13/64

PROJECT TITLE Estimate to use model 700 type front and rear sight on model 600 rifle in place of present rib and sight

	HOURS	RATE	TOTAL
PROCESS ENGINEERING & TRIAL RUN			—
TOOL DESIGN FIXTURES - GAGES			2300
TOOLING FIXTURES - GAGES			3700
TOOL DESIGN — PERISHABLE TOOLS			—
TOOL DESIGN REVISIONS			2450
PERISHABLE TOOLING			3500
TOOL REVISIONS			3500
TOOL REVISIONS - PERISHABLE			3500
TESTING			—
ADMINISTRATION			—
VENDOR TOOLING COSTS (DIES ETC.)			—
VENDOR TOOLING NOT REMINGTON PROPERTY			—
SUB TOTAL			10450
CONTINGENCIES			1050
			11500

RECEIVED  
 APR 13 1964

CURRENT PRODUCTS  
 Process Engineering

COMMENTS Part of the cost could be reduced if the model 600 parts were incorporated in the initial design of this screw on front sight change now being made for the Model 700-742 and 760







PROCESS ENGINEERING ESTIMATE TRIAL AND PILOT SHEET. ①  
 • SEQUENCE OF OPERATIONS •

MODEL 600 COMPONENT FRONT-REAR SIGHTS PART NO. \_\_\_\_\_  
 DATE 4-9-64 COMPUTER AND ASSEMBLY SUMMARY SHEET 2 OF 2

OPER NO.	OPERATION NAME	MACHINE	DEPT NO.	HOURS DESIGN	HOURS BUILD
	BARREL ASSEMBLY (26680-81-82-83) OMIT FOLLOWING OPERATIONS.				
25	DRILL AND TAP REAR RIB SCREW HOLE.				
30	WELD RIB STUDS TO BARREL				
35	FACE RIB STUDS TO PROPER HEIGHT AND COUNTERSINK.				
	FINAL ASSEMBLY REMOVE THE FOLLOWING ELEMENTS.				
175	#28- ASSEMBLE RIB TO BARREL ASSEMBLY WITH RIB SCREWS AND REAR SIGHT NUT				
	#29- ASSEMBLE FRONT SIGHT ASSEMBLY TO RIB WITH FRONT SIGHT SCREWS AND NYLON WASHERS.				
	#30 ASSEMBLE REAR SIGHT ASSEMBLY TO RIB WITH REAR SIGHT SCREWS AND NYLON WASHERS.				
	THE FOLLOWING OPERATIONS ARE TO BE ADDED TO THE COST OF THE M/600.				
	BARREL ASSEMBLY (26680-81-82-83) DRILL AND TAP TWO PRESENTLY BEING REAR SIGHT SCREW HOLES. DESIGNED REM. 35 100 DRILL AND TAP TWO SPECIAL FRONT SIGHT SCREW HOLES. MACHINE.				
	FOLLOWING PARTS LIST IS FROM M/700. AND A.U.				
	FRONT SIGHT RAMP SCREW (2)	19025			
	FRONT SIGHT	15282			
	REAR SIGHT COLLAR	16459			
	" " EYEPiece	16373			
	" " LEAF	16374			
	TOTAL				

RD-2528 11-8-63











# PROCESS ENGINEERING ESTIMATE TRIAL AND PILOT SHEET

## SEQUENCE OF OPERATIONS

MODEL 600 COMPONENT FRONT SIGHT RANGE PART NO.             
 DATE 4-13-64 COMPUTER            SHEET 1 OF 1

OPER NO.	OPERATION NAME	MACHINE	EST. HOURS	DESIGN	BUILD
1					
2					
3					
4	COVER AND MOUNT PLATE				
5	DRILL AND REAM HOLE				
6	DRILL AND REAM HOLE				
7	DRILL AND REAM HOLE				
8	DRILL AND REAM HOLE				
9	DRILL AND REAM HOLE				
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96	DRILL AND REAM HOLE				
97	DRILL AND REAM HOLE				
98	DRILL AND REAM HOLE				
99	DRILL AND REAM HOLE				
100	DRILL AND REAM HOLE				
TOTAL					



⑥

SECRET

5000 3000

TOTAL



M/600 - Stock



PROCESS ENGINEERING ASSIGNMENTS			
<b>Job Description:</b> <b>Oper. - Inlet Stock, Top and Bottom</b> <b>Char. - Provide tooling for Barrel groove.</b> <b>(Required for parts sales.)</b>		<b>Area Engineer:</b> Clements	
		<b>Sheet No.:</b> 1 <b>Job No.:</b> 3769-C1	
		<b>Job Priority:</b> A-3	
		<b>Job Code:</b> 1	
		<b>Model:</b> 600	
		<b>Part Name:</b> Stock	
		<b>Oper. No.:</b> 110	
		<b>Dept. No.:</b> 71	
		<b>Est. Comp. Mo/Yr:</b>	
		<b>Est. Comp. Hours:</b>	
<b>Assigned By:</b>		<b>Date:</b>	<b>Est. Savings:</b>
<b>Report Date</b>	<b>Elapsed Hrs.</b>	<b>Accomplishments</b>	
4/18/68		Issued TDR's for template and cam design. Prepared process sheets for Barrel groove inletting.	
5/17/68		Tooling is on order.	
6/18/68		No change.	
7/17/68		No change.	
9/18/68		Tooling to be completed this month.	

RD - 6566 2/1/63



10/25/65

W/600 stock - magazine support cut -

cut was retained in stock until all magazines with supports had been used up or disposed of. Apparently magazines with supports have not been in assembly for 8-10 months. In checking receivers in assembly, all available had had the screw hole eliminated - Process Engineering to remove clear. operation in stock -

hst



10/2/65

R. B. Harlow

Why 3

Please handle 10/2/65



# REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE

*Remington*  


*PETERS*  


"CONFINE YOUR LETTER TO ONE SUBJECT ONLY"

Ilion, New York  
 October 18, 1965

H. J. HACKMAN

## M/600 STOCK - MAGAZINE SUPPORT CUT

I was surprised to learn the other day that we have as yet not removed this cut in the M/600 stock. The design change to incorporate the elimination was initiated in June 1964, well over a year ago.

There were several reasons for doing this. One was to nullify breakages of the stock due to tightening of the front guard screw, and another mainly for purposes of retaining a good bedding system up front.

Both of these problems were of such a nature that I had one of my designers working on the item full time until we had obtained necessary information to produce the desired results. It appears that I failed to convey the story properly to your department and the necessity and seriousness that might be caused due to the lack of support, and therefore am willing to shoulder the blame. However, I encourage you to initiate the change as soon as possible.

Attached is a report by Harold Waterman indicating the background on this problem which may aid you in your investigation.

*Wayne E. Leek*

W. E. Leek  
 Firearms Research & Design

WEL:T  
 Attach.



DON'T SAY IT—WRITE IT

To W.E. LEEK

DATE 10-4-65

FROM H. J. WATERMAN

SUBJECT: M600 STOCK - MAGAZINE SUPPORT CUT

ORIGINALLY THE M600 MAGAZINE BOX HAD A MAGAZINE SUPPORT SPOT WELDED ON THE FRONT. A SCREW WAS PLACED THROUGH THE SUPPORT AND INTO THE RECEIVER. THIS SUPPORT CALLED FOR AN INLETTING CUT IN THE STOCK. THIS CUT WAS PLACED IN UNDER THE FORWARD RING OF THE RECEIVER.

THE SUPPORT WAS NOT NEEDED AND WAS ELIMINATED, THEREFORE THE SCREW WAS ELIMINATED. THIS ALSO MEANS TWO ASSEMBLY COSTS WERE ELIMINATED.

THE INLETTING CUT IN THE STOCK WAS ELIMINATED. THE COST OF THE CUT WAS ELIMINATED AND MORE IMPORTANT THE WEAKENING OF THE STOCK CAUSED BY THE CUT.

THIS CHANGE ON THE STOCK DRAWING WAS MADE ON JUNE 18, 1964. THE STOCKS, WITH THE EXCEPTION OF THE M600 .350 MAGNUM, STILL HAVE THIS CUT.

WHETHER THIS WAS CHANGED ONCE AND CHANGED BACK IS NOT CERTAIN.

THERE HAS BEEN INQUIRY SEVERAL TIMES ONCE THE EXPLANATION WAS THAT ~~THERE~~ WAS AN ABUNDANCE OF MAGAZINES OF A PARTICULAR CALIBER MADE UP AND THAT THE STOCKS WOULD BE RUN UNTIL THAT LOT OF MAGAZINES WAS EXHAUSTED. THIS EXPLANATION WAS SHORTLY AFTER THE CHANGE AND AT THE TIME SEEMED FEASIBLE.

WE ARE NOW  $1\frac{1}{2}$  YEARS PAST THE DWG. CHANGE AND THOUSANDS OF STOCKS. IF MAGAZINES EXIST IN ANY FORM SAME MODEL DRAWING THEY SHOULD BE SCRAPPED, OR ALTERED.



TO BE SAFE, FIRST THINK YOU MIGHT NOT BE



600 Stock Blank

4/23/64 RSB

purchase

plane both sides

circular saw to face (square to sides)

- normally leave .020 to sand as top is not profiled
- normally face rather than joint because its faster & produces an acceptable surface (remove A)  $(\frac{1}{8} - \frac{1}{4})$
- do however joint as a repair if not enough material to circular saw

cut ends

band saw to template

20% scrap / w. Cook = 2000 / 10000

= per schedule A 2000 salvage blanks  
which had wrong shape



1000  
DON'T SAY IT—WRITE IT

To N. S. Thompson

DATE 12-11-63

FROM P. Nielsen

cc: L. J. Boyle  
R. J. Chesebrough  
R. B. Hurley

M/600 Stock - Oper. Rout Bolt Handle Clearance

Rubber tip added to De-Sta-Co Clamp. Parts checked for movement  
(clamping and cutting) with dial indicator. No movement  
encountered.

eb



2-10

*Handwritten signature*  
② *Handwritten signature*

DON'T SAY IT—WRITE IT

cc: L. J. BOYER  
L. J. BOYER  
VLR

TO PAUL WILSON

RECEIVED  
DEC 9 1963

DATE 12/2/63

FROM R. J. CHESBROUGH

SUBJECT: N/600 STOCKS

CURRENT PRODUCTS  
*Process Engineering*

In the past run of about 450 - N/600 Stocks, over 90 Stocks were scrapped for Stock broke at rear of Bolt Handle Cut in Gallery, besides many of them had to be Sanded to an Action for Clearance at Bolt Handle Slot.

In checking the Fixture - E-85611 - for routing this Cut we find that the Stock moves rearward as the clamp tightens, thus reducing Clearance at rear end of slot.

At present we are "trying" to use a Wooden Wedge to keep Stock in position, but this leaves something to be desired. Please take necessary action to correct.

*Handwritten signature*

R. J. CHESBROUGH  
Supervisor

THERE IS A SAFE WAY; DO IT THAT WAY



## REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE

*Remington*  
CORPENT*PETERS*  
CORPENTcc: F.E. Morgan  
G.M. Calhoun  
W.E. Leek - File*Jim Morgan*  
*W. Leek*

"CONFINE YOUR LETTER TO ONE SUBJECT ONLY" \_\_\_\_\_

Ilion, New York  
October 25, 1963

H. J. HACKMAN

MODEL 600 STOCK

As result of preliminary testing and examination of an advance sample, F.E. Morgan has asked that we either raise our sight line or take some wood off the top of the stock so that it will fit better for use with open sights. He feels definitely this should be done for the field test samples, else we may find reports so colored with criticism of sight line other features may be neglected.

I have had Harold Waterman remove approximately *.030* from this model stock. This is from the point of the comb and continues straight back rather than a runout. It seems to make a perceptive difference. We will therefore want to strip field test rifle stocks and give the same treatment.

I would like to hold up making any change to the drawing until we have more confirmation as to adequacy.

*S. M. Alvis*  
S. M. Alvis  
Ilion Research Division

SMA:T



MODEL 600 BARRELED ACTIONS



G-88

DON'T SAY IT — WRITE IT

To

*Jack Carter*

Date

*3/29/82*

From

*Bill Stone*

*m/600 FBI actions in stock.*

<i>6150</i>	<i>-</i>	<i>248</i>
<i>6152</i>	<i>-</i>	<i>31</i>
<i>6154</i>	<i>-</i>	<i>96</i>
<i>6156</i>	<i>-</i>	<i>14</i>

*TOTAL 389*

KEEP SAFETY IN MIND IN '79



**DON'T SAY IT—WRITE IT**

To Jack Carter  
From W. J. Smith

Date 3/11/82

110000 Barrel Actions Picked during Feb + Mar. 1982

308 cal - 16  
222 cal - 246  
243 cal - 96  
6mm - 31

total shipments to date: Started Mar 1979

308 cal - 1916  
222 cal - 1007  
243 cal - 756  
6mm - 39

**"SAFETY RULES ARE PERFECT TOOLS"**



DON'T SAY IT — WRITE IT

To J. H. CARTER  
From W. E. STEVENSDate 3/8/82

M/600 ACTIONS IN WAREHOUSE

(222)	6150	—	246
(6mm)	6152	—	31
(243)	6154	—	96
(308)	6156	—	16
			<u>389 TOTAL</u>

KEEP SAFETY IN MIND IN '79



Copy to Larry Blacklund  
3-1-82  
cc J. H. Carter  
1/4/82  
Barrel Actions Order

week	m/700	m/40XR	m/788	m/540x
1/10/82	17	23	2	0
1/24/82	8	2	0	0
1/31/82	7	1	0	1
2/7/82	22	0	0	2
2/26/82	8	2	1	2



G-88

**DON'T SAY IT—WRITE IT**

To \_\_\_\_\_

Date \_\_\_\_\_

From \_\_\_\_\_

*m/600 Inventory*

ARMS SERVICE	_____	164
READY for ARMS SERVICE	_____	125
ACTIONS	_____	10
GALLERY	_____	50
		<u>349</u>

50 BBLS DOWN  
IN 50-3 CRIB.

MAX BBLS.

NO MAX. BOLTS.

ONLY 70 BBLS LEFT.

**"SAFETY RULES ARE PERFECT TOOLS"**



G-88

**DON'T SAY IT—WRITE IT**

To

Jack Carter

Date

2/1/82

From

Bill Starnes

M/600 BA Actions MC in warehouse 2/1/82

6152 — bmm — 8 — 9

6150 — 222 — 95 — 30

6156 — 308 — 2 — 0

105 + 39 = 144  
TOTAL

**"SAFETY RULES ARE PERFECT TOOLS"**



**FAST-but-informal**

*Jack,*

*1/12/82*

*MoH 600 Barrel Action  
packed*

*308 cal - 65*

*Glenn*

**Remington®**

ARMS SERVICE DIVISION

Remington Arms Company, Inc., Ilion, New York 13357  
Tel. (315) 894-9961



# FAST-but-informal

1/5/81

Jack,

Barrel Action

Packed mch 600

.308 cal - 50

.222 cal - 15

.243 cal - 9

*Remington*

**Remington®**

ARMS SERVICE DIVISION

Remington Arms Company, Inc., Ilion, New York 13357  
Tel. (315) 894-9961



G-88

**DON'T SAY IT-WRITE IT**

To D. ROARK

7:00 A.M.

Date 1-13-82

From \_\_\_\_\_

M/600 INVENTORY

GALLERY — 40  
READY FOR PACK — 65  
READY FOR STOCKING — 25

FIRE CONTROLS TO ARM SERVICE — 50

NOTE: - ONLY 45 SLAVE STOCKS ON ASSEMBLY

**"SAFETY RULES ARE PERFECT TOOLS"**



DON'T SAY IT — WRITE IT

To: Jack Carter  
From: James Smith

Date: 9/18/80  
Updated 1/20/81

Subject: 110th 600 Barrel Action Shipments

March 1979 308 cal - 400  
222 cal - 100

Sept. 1979 243 cal - 399

Nov. 1979 308 cal - 333

Jan. 1980 308 cal - 395

Jan 1980 308 cal - 88  
222 cal - 60

July 1980 308 cal - 314  
222 cal - 24

July 1980 243 cal - 249  
308 cal - 116  
222 cal - 161

Sept 1980 308 cal - 324  
243 cal - 23  
222 cal - 3

Jan 1981 308 cal - 114  
222 cal - 68

Total Shipments by caliber  
as of 9/18/80 Jan 1981  
308 cal - 1669 1783  
243 cal - 651  
222 cal - 669 737

SAFETY IS A WISE INVESTMENT



M600 Bbl action Produced to Warehouse 12-12-80

110	# 6156	308 cal
65	# 6150	222 cal



DON'T SAY IT — WRITE IT

cc B. H. Gilbert

To

From

Date

To Jack Carter  
From Remington-Union9/18/80Subject 1100 600 Remington-Union ShipmentsMarch 1979 308 cal - 400  
222 cal - 100

Sept. 1979 243 cal - 399

Nov. 1979 308 cal - 333

Jan. 1980 308 cal - 395  
Jan 1980 308 cal - 88  
222 cal - 60July 1980 308 cal - 314  
222 cal - 24July 1980 243 cal - 249  
308 cal - 116  
222 cal - 161Sept 1980 222 cal - 324  
308 cal - 23  
243 cal - 3total Shipments by caliber  
as of 9/18/80308 cal. - 1669  
243 cal. - 651  
222 cal. - 669

SAFETY IS A WISE INVESTMENT



**DON'T SAY IT-WRITE IT**

To \_\_\_\_\_

Date

11/30/79

From \_\_\_\_\_

*Nov 600 Barrel Automatic Shipped to date**March 79 308 cal. - 400 ✓  
222 cal. - 100 ✓**Sept 79 243 cal. - 399 ✓**Nov 79 308 cal. - 333 ✓**Jan 80 308 cal. - 325 ✓  
308 cal. - 88 ✓  
222 cal. - 60 ✓**July 80 - 308 cal. - 314 ✓  
222 cal. - 24 ✓**July 80 243 cal. - 249 ✓  
308 cal. - 116 ✓  
222 cal. - 161 ✓*

<u>308</u>	<u>222</u>	<u>243</u>	
1646	345	648	2639

120

200

200

**"SAFETY RULES ARE PERFECT TOOLS"**

341



## DON'T SAY IT—WRITE IT

To \_\_\_\_\_

Date 11/30/79

From \_\_\_\_\_

*1100 600 Barrel Automatic Shipped to date**March 79 308 cal. - 400  
222 cal. - 100**Sept 79 243 cal - 399**Nov 79 308 cal - 333**Jan 80 308 cal - 395  
308 cal - 88  
222 cal - 60**July 80 - 308 cal - 314  
222 cal - 24**July 80 - 243 cal - 249  
308 cal - 116  
222 cal - 161*

"SAFETY RULES ARE PERFECT TOOLS"



*Packed on Production*  
BBL ACTIONS - M 600

12 31 - .222 + 128 = 159 7/18-80

116 - .308

304 - .243 + 9 = 313

---

451 TOTAL

---

*Mero & Sam*



## DON'T SAY IT—WRITE IT

To \_\_\_\_\_

Date \_\_\_\_\_

From \_\_\_\_\_

11/01/600 Bbl. autos packed

90 - 308 cal > 6/18/80  
25 - 222 cal

223 - 308 cal - 6/24/80  
338

"SAFETY RULES ARE PERFECT TOOLS"



Remington

# REMINGTON ARMS COMPANY, INC.

PETERS

SPORTING FIREARMS  
AMMUNITION  
TARGETS  
TRAPS

BRIDGEPORT, CONNECTICUT 06602  
U.S.A.

CABLE-HARTLEY, BRIDGEPORT  
TELEX: (964-286) & (964-201)

## INTERNATIONAL SALES ORDER FORM

REMINGTON ORDER NUMBER  
PX-4160

RED AREAS FOR REMINGTON USE ONLY		FOR TRAFFIC		CODE	DATE 6/17/80	REMINGTON ORDER NUMBER PX-4160	
				FOR ORDER AND BILLING			
S O L D T O	REMINGTON ARMS GMBH Winterhäuser Str. 85 8700 Würzburg 21			CUSTOMER ORDER NUMBER 800512	REP/DIST. ORDER NO.	DATE 23 May 80	
				TERMS		SHIPMENT ocean	
				DESTINATION West Germany		KLS.	INSURANCE x yes
				FOREIGN BANK			
MARK  dto.				IMPORT PERMIT			
CONSIGNMENT							
REMARKS: SPECIAL INSTRUCTIONS  For shipment soonest possible							

RECEIVED  
 JUN 18 1980  
 ARMS SERVICE

RAMAC NUMBER	QUANTITY	INDEX NUMBER	DESCRIPTION	UNIT PRICE	U.S. DOLLAR VALUE
			Mod 600 / Barreled Actions only		
	400		.243 Win		
	600		.308 Win		
			Barrelled actions must be		
			packed in a full stocked		
			carton.		

PRODUCTION

RD 1457 REV. 9/72

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER  
KINZER V. REMINGTON

R2528712



GmbH *Barclay's order outstanding*

*5/30/80*

*308 cal. - 84*  
*222 cal. - 490*  
*243 cal. - 151*

*55 - 308 cal in warehouse awaiting shipment*

*shipped 6/5/80 PX 3392.4*



## DON'T SAY IT-WRITE IT

To Jackie Bernie  
From Bernie Jack 4-18-80

Date 4/18/80

May I please have M/600 barreled  
action amounts reqd. for shipment.

.308 -	400
.222 -	850
.243 -	720
6MM -	100
	<hr/>
	2070

KEEP SAFETY IN MIND IN '79



4-18-80

# M600 Barrel Action

## Original breakdown

308	1200 qty
243	900 "
222	900 "

<u>308</u>
required 1200
shipped Nov 79 - 333
<u>for 81 - 483</u>
need 384

<u>243</u>
900
<u>shipped 79 - 399</u>
<u>501</u>
501

<u>222</u>
900
<u>shipped 80 - 60</u>
<u>Feb 80 - 23</u>
817



0-48  
DON'T SAY IT-WRITE IT

To \_\_\_\_\_

Date

11/30/79

From \_\_\_\_\_

1707 600 Canal Action Shovel to date

March 77 308 cal - 400

Jan 80 -

308 cal - 37  
230 cal - 60

April 79 243 cal - 379

Nov 79 308 cal - 350

Jan 80 308 cal - 350

KEEP SAFETY IN MIND IN 79



G-88

**DON'T SAY IT-WRITE IT**

cc M.J. Kantor  
Date 2/19/80

To

From

J. H. Carter  
M. J. Kantor

*MoH 600 panel actions packed for GMBH orders*

*308 cal - 122 + 56 = 178*

*222 cal - 23*

**KEEP SAFETY IN MIND IN '79**



**PETER**

**CABLE—HARTLEY, BRIDGEPORT**  
**TELEX: (964-286) & (964-201)**

REMINGTON ORDER NUMBER  
PX-3393

REMARKS: SPECIAL INSTRUCTIONS

FD-1457 REV. 6-27-64



**PETER**

**CABLE—HARTLEY, BRIDGEPORT**  
**TELEX: (964-286) & (964-201)**

REMINGTON ORDER NUMBER  
PX-3392

S O L D  T O	Remington Arms GmbH Winterhauser Str. 85 8700 Wurzburg-Heidingsfeld West Germany	CUSTOMER ORDER NUMBER		REP/DIST. ORDER NO.	DATE	
		90309			3/14/79	
		TERMS			SHIPMENT	
		DESTINATION			KLS. INSURANCE	
MARK		West Germany				
		FOREIGN BANK				
		IMPORT PERMIT				
CONSIGNMENT						
REMARKS: SPECIAL INSTRUCTIONS						

RAMAC NUMBER	QUANTITY	INDEX NUMBER	DESCRIPTION	UNIT PRICE	U.S. DOLLAR VALUE
			Barrelled Actions Model 600		
OK	400 -	<del>125</del>	Cal. 308 Win.	395 shipped 1/7/80, 5 shipped 2/19/80	
	200		Cal. 222 Rem.	60 Shipped 1/31/80, 23 shipped 2/19/80	
dew					

R2528719



Miko/Barnie

# M600 Barrel Actions for International + Arms Service

<u>Cal</u>	<u>Int'l Need</u>	<u>Arms Service</u>	<u>Total Required</u>	<u>Shipped</u> <u>1/14/80 to 1/22-2-19</u>
222	850	0	850	$52 + 10723 = 85$
243	900	215	1115	0
308	398	0	391	$809 + 29 + 178 = 1016$
6M	0	96	96	0
			2452	861 = 0 1160

Start warehousing for shipment Jan 28, 1980  
30 per day.



REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE

Remington  
ORD

*Copies to Mike & Bernie,*

*sub*  
*11-15-79*

cc: E. J. Giner  
M. F. deMayo  
W. D. Nickel  
P. H. Holmberg  
P. J. Rosendahl

Bridgeport, Connecticut  
November 13, 1979

*5-2 333 4-2 3-3*

J. H. CARTER

M600 BARRELED ACTIONS FOR GMBH

This is to confirm our conversation of 11/12/79. The 1,401 units on order under PX3392-3 are valid orders, and we prefer them shipped prior to year-end, but sales wise the product will be considered for use in 1980. Therefore, the aforementioned quantity is to be considered part of the 3,000 units forecasted for 1980. Forecasted sales for 1981 are 3,500 units.

We hope this clarifies the current confusion, and if you have any questions please give me a call.

*Bill Boettner*

W. J. BOETTNER

WJB/kam



**DON'T SAY IT-WRITE IT**

*C. L. HALL*

To W. D. NICKEL Location \_\_\_\_\_  
From W. J. BOETTNER Location \_\_\_\_\_ Phone No. \_\_\_\_\_  
Subject M600 BARRELED ACTION MIX FOR GMBH Date 10/19/79

Gunther Droge has suggested the following mix: 40% .308 caliber 1200  
30% .243 caliber 900  
30% .222 caliber 900

We would also like consideration of the 300 units of 6mm if the plants can handle without any major interference.

~~W. J. BOETTNER~~  
*@ JH Carter* *Bill*

WJB/kam

RD 779

**STOP, LOOK, AND LIVE**

**CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER  
KINZER V. REMINGTON**

R2528722



**DON'T SAY IT-WRITE IT**

*HKB*

To SEE BELOW Location \_\_\_\_\_  
From W. J. BOETTNER Location \_\_\_\_\_ Phone No. \_\_\_\_\_  
Subject MODEL 600 MANNLICHER STOCKED GUN Date 9/11/79

*Bob Hall*

C. F. WAGNER  
K. B. SPERLING  
✓ J. E. PREISER

E. J. GINER  
E. F. BARRETT  
J. P. McANDREWS

*for your info  
Walt Micky*

Attached for your information and files is a copy of the approved  
M600 Mannlicher stock proposal.

*CC: J. H. CARTER*

WJB/kam  
Att.

*Copy to Mike + Dennis  
9-18-79*

RD 770

**STOP, LOOK, AND LIVE**



cc: M. F. deMayo

TO: C. T. WAGNER *can* (IN TURN)  
R. B. SPERLING  
J. E. PREISER *TS*  
E. J. GINER *TS*  
E. HOOTON, JR. *Ed*  
E. F. BARRETT *TS*  
J. P. McANDREWS *TS*

REQUEST TO SELL MODEL 600 MANNLICHER STOCK GUN IN EUROPE

Attached for your review is Gunther Droge's request for GmbH to sell M600 barreled actions with a Mannlicher stock produced by Hofmann. The modified gun is currently sold in Germany by Hofmann and is pictured in the attached brochure. GmbH would like to sell these products initially in Scandinavia and expand the sales area in 1980 after reviewing our initial performance.

Consideration was given to having Remington produce the product, but the "high spot" economics prepared by Process Engineering eliminates this consideration for the present time. They estimate a \$138,000 investment for tooling plus additional labor costs would be required to produce the Mannlicher version compared to the current Remington designed product. The potential additional earnings from this project do not appear to justify the investment presently, based on the additional forecasted volume of 500 units. These added units may provide estimated, increased income of \$19,000 - \$20,000 less expenses based on a 22.7% markup. Margins can be adjusted once actual costs are determined. The Mannlicher stocked M600 provides Marketing with a tool to evaluate consumer acceptance of modified, specialized Remington products with little risk or exposure to the company.

Ilion is in the process of providing quality control production guidelines which will formally be transmitted to Hofmann in an attempt to keep our liability at a minimum.

The product we seek to sell would be represented as European modified M600's and assuming the sales and acceptance are as forecasted and product performance meets Remington's criteria, we would then consider supplying other market areas.



At this time, we seek approval to sell the modified gun in the Scandinavian market as soon as it is practical subject to receiving Ilion's input.

Please signify your approval by initialing next to your name.

WLB/LW  
Attach.  
5-1-79



# REMINGTON ARMS GMBH

INTER-DEPARTMENTAL CORRESPONDENCE

*Remington.*



TO: E.J. Giner

FM: G. Dröge

30th May 1979

RE: Remington Model 600 with Mannlicher stock

We have received a total of 500 barreled actions for model 600 at an input price of US \$ 79.44. Restocking is done by H. Hofmann with a Mannlicher stock, oil-finish, at a price of DM 175,50 (US \$ 92.36), which brings up a total ~~of~~ cost price of US \$ 171,80. The selling price based on this input price is US \$ 210.83, leaving a mark-up of 22.7 % for GmbH.

The restocking is done by H. Hofmann who is selling this gun with the Mannlicher stock in Germany. Hofmann's forecast reads 800 guns p.a. assorted in the calibers .243/.222, and .308.

We anticipate additional sales of 500 guns in the first year in Scandinavia and of 1,000 guns in the second year, if this gun can be offered by us with the Mannlicher stock. Your authorization is requested to offer and sell the model 600 with Mannlicher stock as a Remingtongun to Scandinavia, and at a later date Belgium and France.

G. Dröge

Incl.

approved by:

.....

E.J. Giner



# **FAST-but-informal**

We've replied to your letter by marginal notes  
on the letter itself. Saves your time, our time.

10/31/79

Mike,

Attached are orders  
covering the balance  
of Fort 44 requirements  
for Model 600 banded  
actions.

Joan Murphy

**Remington**

ORDER SERVICES

Remington Arms Company, Inc., Bridgeport, Conn. 06602

RD 1202



Remington.

**REMINGTON ARMS COMPANY, INC.**

PETERS



SPORTING FIREARMS  
AMMUNITION  
TARGETS  
TRAPS

BRIDGEPORT, CONNECTICUT 06602  
U.S.A.

CABLE—HARTLEY, BRIDGEPORT  
TELEX: (964-286) & (964-201)

**INTERNATIONAL SALES ORDER FORM**

REMINGTON ORDER NUMBER  
PX-3393

RED AREAS FOR REMINGTON USE ONLY		FOR TRAFFIC		CODE	DATE 10/31/79
				FOR ORDER AND BILLING	
S O L D T O	Remington Arms GMBH Winterhauser Str. 85 8700 Wurzburg-Heidingsfeld West Germany			CUSTOMER ORDER NUMBER EJG	REP/DIST. ORDER NO.
				DATE 5/25/79	
				TERMS	
				SHIPMENT	
			DESTINATION West Germany	KLS.	INSURANCE
MARK			FOREIGN BANK		
			IMPORT PERMIT		
CONSIGNMENT					
REMARKS: SPECIAL INSTRUCTIONS					

RAMAC NUMBER	QUANTITY	INDEX NUMBER	DESCRIPTION	UNIT PRICE	U.S. DOLLAR VALUE
			Barrelled Actions Model 600		
OK	500		Cal. 308 Win.		
	350		Cal. 222 Rem.		
	151		Cal. 243 Win.		
	1001				
dcw					

Copy

RD 1457 REV. 9/72

PRODUCTION

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER  
KINZER V. REMINGTON

R2528728





**CABLE—HARTLEY, BRIDGEPORT**  
**TELEX: (964-286) & (964-201)**

## REMINGTON ORDER NUMBER

PX-3392

RED AREAS FOR REMINGTON USE ONLY	FOR TRAFFIC	CODE	DATE
		10/31/79	
		FOR ORDER AND BILLING	

S O L D  T O	Remington Arms GmbH Winterhauser Str. 85 8700 Wurzburg-Heidingsfeld West Germany	CUSTOMER ORDER NUMBER		REP/DIST. ORDER NO.	DATE	
		90309			3/14/79	
		TERMS			SHIPMENT	
		DESTINATION			KLS.	INSURANCE
		West Germany				

MARK	FOREIGN BANK
	IMPORT PERMIT

CONSIGNMENT	

REMARKS: SPECIAL INSTRUCTIONS
-------------------------------

RAMAC NUMBER	QUANTITY	INDEX NUMBER	DESCRIPTION	UNIT PRICE	U.S. DOLLAR VALUE
			Barrelled Actions Model 600		
OK	400 - 125		Cal. 308 Win.		
	200		Cal. 222 Rem.		
	600				
dew					

RD 1457 REV. 9/72

# PRODUCTION

**CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER**  
**KINZER V. REMINGTON**

R2528729



To

Date

From

mot 600 *1 Action* shipped today

March 79 308 cal - 400  
222 cal - 100

Sept 79 243 cal - 399

Nov 79 308 cal - 333

Jan 80 308 cal - 375 + 150

KEEP SAFETY IN MIND IN '79

Jan 25 305 cal 88  
Jan 25 222 cal 62



1-80 FCST PRODUCT -- M600  
PEAK NOMINAL INVENTORY

DATE ISSUED 10/25/79  
MONTH OF PEAK INVENTORY

PAGE

02 Jan - 0

	TOTAL DEMAND FORECAST	P R O D U C T I O N							FCST. INV.
		P L A N T		FCST. PRGD.	P L A N T		FCST. PROD.		
		RATE M/DAY	DAYS		RATE M/DAY	DAYS			
JAN	300								
FEB	260								
MAR	190								
1ST QTR	750								
APR	400								
MAY	400								
JUN	200								
2ND QTR	1000								
JUL	160								
AUG	160								
SEP	330								
3RD QTR	650								
OCT	120								
NOV	180								
DEC	300								
4TH QTR	600								
YEAR 80	3000								
JAN									
FEB									
MAR									
1ST QTR									
APR									
MAY									
JUN									
2ND QTR									
JUL									
AUG									
SEP									
3RD QTR									
OCT									
NOV									
DEC									
4TH QTR									
YEAR 81									



	TOTAL DEMAND FORECAST	P R O D U C T I O N						
		P L A N T			P L A N T			F C S T . I N V .
		R A T E M / D A Y	D A Y S	F C S T . P R O D .	R A T E M / D A Y	D A Y S	F C S T . P R O D .	
JAN	300							
FEB	260							
MAR	190							
1ST QTR	750							
APR	400							
MAY	400							
JUN	200							
2ND QTR	1000							
JUL	160							
AUG	160							
SEP	330							
3RD QTR	650							
OCT	120							
NOV	180							
DEC	300							
4TH QTR	600							
YEAR 80	3000							
JAN								
FEB								
MAR								
1ST QTR								
APR								
MAY								
JUN								
2ND QTR								
JUL								
AUG								
SEP								
3RD QTR								
OCT								
NOV								
DEC								
4TH QTR								
YEAR 81								



## M600 Barrel Actions

### Work-In-Process

222 cal	Bbl + Recv Assem.	180
308 cal	" " "	900

### Requirements - Marketing

	<u>EST</u>	<u>SHIPPED</u>	<u>BALANCE</u>	<u>+ arm service</u>	
222 cal	900	—	900	100	1000
243 cal	900	399	501	216	717
308 cal	1200	281	919	240	1159
6MM cal	—	—	—	96	96
	3000	680	2320		2372

### Arm Service Requirements

222 cal	100	complete in arm ser. 1/80
243 cal	216	
308 cal	240	complete " " 1/80
6MM cal	96	
	652	



G-88

DON'T SAY IT — WRITE IT

To

From

*J. H. Carter*  
*A. J. Smith*

Date

*11/12/79*

*all Nov 600 Banet Actions shipped 1979 to date*

*March 400 - 308 cal.*  
*100 - 222 cal.*

*Sept 399 - 243 cal.*

*all*  
*GMBH*

*125 in Warehouse pending shipment + 156 at pack = 281*

KEEP SAFETY IN MIND IN '79



# I. Barrel Actions Requested

	<u>Grail. - Bbl. Accum Area.</u>	<u>Reqd.</u>
.222 - 900	180	720
.243 - 900	—	900
6MM - 300	—	300
.308 - 1200	900	300
		<u>2220</u>

## Part Sales 10 yrs

.222 - 100  
.243 - 216  
6MM - 96  
.308 - 240  
652

Will make one run  
of barrels as follows  
plus about 15% scrap  
factor. (3,300)

.222 - 820  
.243 - 1116  
6MM - 396  
.308 - 540  
2872



# M/600 RECEIVER INV.

11/7/79

OPER.

QUAN.

5	BROACH GROUP	1200
16	" "	2050
64	TRI-ORDINATE	800
85	FIRE CONTROL GRP	500
	AHO. HEAT TREAT	200 (.222s)
		<u>4750</u>



M600

Per Bill Bortner on 11/12/79. The 3000 feet for 1980  
includes the balance of Px 3392 + 3393 and 300 Mannliche stalks.



cond to  
Cofort:  
Mike/Bernie

Per Walt Nickel, International files wants  
M600 Barrel Actions only.

900 ~~1000~~ 222 cal

900 ~~1000~~ 243

1200 ~~1000~~ 308

300 6MM.

They would like them early in 1980.

Please review and advise what the ramifications  
would be on ~~the~~ ~~other~~ other models.

changed per W. Nickel on 10/22/79.  
Want .222 cal first.

Jack  
10-18-79

Jack  
10-22-79

Plus Bbl. Actions



Cal	Actions Participates	# IFCSY	Months act	Goals Served
① 308	775	1200		240
243	151	900		216
222	550	900		100
6MM			300	96
	1476	3000	300	652
				5428
				-775
				4653

775 make 1979

	Jan	Feb	Mar	Apr
308al	500		500	440
222al	860	690		
243		710	557	
6M			396	



**PETERS**

**SPORTING FIREARMS  
AMMUNITION  
TARGETS  
TRAPS**

BRIDGEPORT, CONNECTICUT 06602  
U.S.A.

**CABLE-HARTLEY, BRIDGEPORT**  
**TELEX: (964-286) & (964-201)**

# INTERNATIONAL SALES ORDER FORM

AX-11860

3-30 Called El Cuper + Herb Albany!  
Referred to - do not fill order at this time.

3/29/79

**B/O Special  
Priority 90**

S O L D  T O  M A R K	<b>REMINGTON ARMS GMBH</b> <b>Winterhäuser Str. 85</b> <b>8700 Würzburg 21</b>	CUSTOMER ORDER NUMBER	REP/DIST. ORDER NO.	DATE
		90309		14 Mar 79
		TERMS	SHIPMENT	
			ocean freight	
	<b>REMINGTON ARMS GMBH</b> <b>Winterhäuser Str. 85</b> <b>8700 Würzburg 21</b>	DESTINATION	KLS. INSURANCE	
		West Germany	x yes	
		FOREIGN BANK		
		IMPORT PERMIT		

RECEIVED

MAR 30 1979

**ARMS SERVICE**

[illegible]







## REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE

Remington

cc: E. J. Giner  
H. D. Albaugh  
H. K. Boyle

October 31, 1978

TO:

*J. H. Carter*  
J. R. AYERS

FROM:

J. E. PREISER

SUBJECT:

MOHAWK 600 BARRELED ACTIONS FOR  
INTERNATIONAL SALES

Confirming our conversation today, E. J. Giner agrees that these barreled actions may be moved back in priority to make more fire controls available for the recall program. I mentioned to Ed, based upon our present situation and the need for the fire controls, that the possibility is remote that these actions would be shipped this year.

If any further questions come up on this order, please refer them to me.



JEP/lcy



m 600 Production Fct

June	50/day =	950	(less trigger assay)
July	43/day =	945	(505 less trigger assay plus 405 WIP)
Aug	33/day =	360	(all WIP)
Sept	48/day =	1050	(all WIP)
Oct	48/day =	<u>1050</u>	(all WIP)
Total		4355	

6-7-79



M/600

5/24/79

.222

BBLs. - 1,127 Op. 50, ASSEMBLE RECS. TO BBLs

RECS. - 464 READY FOR BBL. ASSEM.  
423 Op. 25, 8-10 DAYS FROM  
BBL. ASSEM.

BOLTS. - 0

.308

BBLs. - 2,119 Op. 50 - AHEAD OF G.F.M.

RECS. - 1,964 READY FOR BBL. ASSEM.

BOLTS. - 135 ON ASSEM.  
911 IN BOLT ASSEM. PROCESS,

RECS. IN LINE - .308 OR .222 - 6,251



## REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE

Remington  
CUPONTPETERS  
CUPONTcc: P.H. Holmberg  
W.H. Forson, Jr.

"CONFINE YOUR LETTER TO ONE SUBJECT ONLY" \_\_\_\_\_

Copies to Mike + Benie  
6-6-79

June 6, 1979

TO: E. HOOTON, JR.

ATTENTION: W. NICKEL

MODEL 600

As of May 25, 1979 the following is an inventory of assembled rifles (less trigger assemblies) and work-in-process parts to build rifle assemblies.

MODEL 600 - LESS TRIGGER ASSEMBLIES

125	.222 Cal.
865	.243 Cal.
465	.308 Cal.
<u>1,455</u>	Total

WORK-IN-PROCESS PARTS TO BUILD RIFLE ASSEMBLIES

1,000	.222 Cal.
<u>1,900</u>	.308 Cal.
2,900	Total

WAREHOUSE INVENTORY - ASSEMBLED RIFLES

25	.222 Cal.
250	.243 Cal.
245	.308 Cal.
<u>85</u>	6MM
605	Total

TOTAL AVAILABLE

<u>In Process</u>	<u>Whs. Inv.</u>	<u>Total</u>	
1,125	25	1,150	.222 Cal.
865	250	1,115	.243 Cal.
2,365	245	2,610	.308 Cal.
--	85	85	6MM
<u>4,355</u>	<u>605</u>	<u>4,960</u>	



The #3-79 demand forecast from May through December is 5,759. The plant can produce to the warehouse by the end of October, 4,355 Model 600 from components available. Any additional production would sacrifice other center fire production, principally Model 700 and XP-100.

In addition, the #3-79 Forecast indicates a demand in 1980 of 2,600 rifles. Currently there are no plans for any Model 600 production beyond using the available components. In light of the aforementioned, it is recommended the Model 600 demand requirements be reviewed for 1979 and 1980.

R.L. HALL  
PLANT MANAGER

*J.H. Carter*  
J.H. Carter  
Superintendent-Planning

JHC: jr



June 950

July 505 + 440

- Aug 360

(52) Sept 1050

Oct 1050  
4355



## REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE

Remington  
6700

cc: P. H. Holmberg

Bridgeport, Connecticut  
May 23, 1979

TO: J. E. PREISER

FROM: W. H. FORSON JR.

SUBJECT: MOHAWK 600

Sufficient information is now available to review the Mohawk 600 requirements for Domestic and International. The following table illustrates our best estimates of the various factors.

ORDER #	BEGINNING INVENTORY	<sup>1)</sup> +	WORK IN PROCESS	<sup>2)</sup> =	TOTAL M/600 AVAILABLE	<sup>3)</sup> -	DOMESTIC ORDERS	<sup>4)</sup> -	TOTAL INTERNAT. REQUIREMENTS	<sup>5)</sup> =	BALANCE NOT SOLD
6150 222	288		1,250		1,538		188		738		612
6152 6mm	318		50		368		318		0		50
6154 243	1,398		180		1,578		770		662		146
6156 308	1,644		1,900		3,544		475		1,100		1,969
TOTALS	3,648	+	3,380	=	7,028	-	1,751	-	2,500	=	2,777

- 1) Original count of guns in warehouse without triggers.
- 2) Count supplied by Jack Carter 5/21/79.
- 3) Domestic order position as of 5/21/79.
- 4) Calendar year requirements including 100 222 and 400 308 already shipped to GMBH.
- 5) As of 5/21/79.

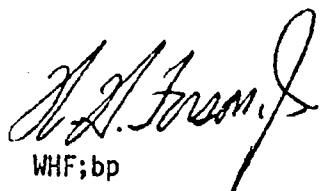


The figures indicate:

- Domestic orders to date are far short of total guns available. (Inventory count given to Domestic was 3,148 to reflect 500 barreled actions shipped to GMBH).
- Work in process will cover current Domestic and total International calendar year requirements.
- Approximately 2,800 M/600's are not committed as of 5/21/79.
- A shortage will exist in 243 relative to other calibers due to the low work in process (180).

Based on our analysis of inventory, work in process, and order positions, I recommend that Ilion resume production of the M/600 by finishing work in process. To compensate for the out-of-balance inventory, Domestic sales emphasis must decrease on 243 and increase on 222 and 308. In order to clear out all 222 and 308 caliber rifles, additional product might be offered to International.

Paul and I would like to discuss this matter with you at your earliest convenience.

  
WHF;bp



M600

	<u>Available</u> <u>Less Trigger</u>	<u>W. IP</u>	<u>Whole Tr</u>	<u>Total</u>	<u>Intl orders</u> <u>Action</u>
222	125	1000	25	1150	550
243	865	-	250	1115	550
308	<u>465</u>	<u>1900</u>	<u>295</u>	<u>2610</u>	<u>900</u>
Total	1455	2900	520	4875	2000



**REMINGTON ARMS COMPANY, INC.**

INTER-DEPARTMENTAL CORRESPONDENCE

**"CONFINE YOUR LETTER TO ONE SUBJECT ONLY"**

May 30, 1979

TO: E. HOOTON, JR.

**MODEL 600**

As of May 25, 1979 the following is an inventory of assembled rifles (less trigger assemblies) and work-in-process parts to build rifle assemblies.

**MODEL 600 - LESS TRIGGER ASSEMBLIES**

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**WAREHOUSE INVENTORY - ASSEMBLED RIFLES**

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250	.243 Cal.
245	.308 Cal.
85	6MM
<u>605</u>	Total

AL 0024917



The plant can produce to the warehouse by the end of October, 4,355 Model 600 within the constraints of plant capacity. The #3-79 demand forecast from May through December is 5,759. Additional production runs would be scheduled to meet demand forecast, however, this will effect other center fire production schedules principally Model 700 and XP-100. In addition, the #3-79 Forecast indicates a demand in 1980 of 2,600 rifles.

In light of the aforementioned, it is recommended the Model 600 demand requirements be reviewed for 1979 and 1980.

R.L. HALL  
PLANT MANAGER

J.H. Carter  
Superintendent-Planning

JHC: jr



# REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE

cc: P. H. Holmberg

Bridgeport, Connecticut  
May 23, 1979

TO: J. E. PREISER  
FROM: W. H. FORSON JR.  
SUBJECT: MOHAWK 600

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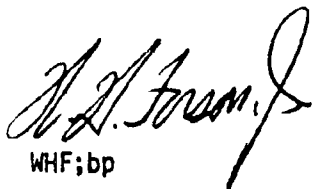


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WHF;bp



DON'T SAY IT — WRITE IT

To

*Jack*

Date

*5/31/79*

From

*afennis*

*7 yr lease Moh 600 Panel & Receiver components for  
Dms Service*

*243 cal. - 75*

*6mm cal. - 50*

*222 cal - 50*

*308 cal. - 75*

KEEP SAFETY IN MIND IN '79



**CABLE-HARTLEY, BRIDGES**  
**TELEX: (964-288) & (964-261)**

# INTERNATIONAL SALES ORDER FORM

REMINGTON ORDER NUMBER  
**PX-2714**

REMINGTON ARMS OMBH WINTERHAUSER STR 85 8700 WURZBURG-HEIDINGSFELD W. GERMANY		CUSTOMER ORDER NUMBER <b>SN: 06/156</b>	REP/DIST. ORDER NO.	DATE <b>7/05/78</b>
MARK  ADDRESSED		TERMS	SHIPMENT	
CONSIGNMENT		DESTINATION  <b>W. GERMANY</b>	KLS.	INSURANCE
REMARKS: SPECIAL INSTRUCTIONS		FOREIGN BANK		
		IMPORT PERMIT		

**RECEIVED**  
 JUL - 6 1978  
**ARMS SERVICE**

[illegible]

RD 1457 REV. 9/72

TRAFFIC



Copies to: R. L. Hall  
H. K. Boyle  
J. P. Linde  
J. H. Carter  
G. E. Fletcher  
Est. No. 4103

✓ Copies to Mike & Bernie

12-4-79

November 29, 1979

J. W. BOWER

M/600 Barreled Actions

Factory costs have been developed for the 222,243,308 and 6 mm caliber barreled actions requested by International Sales and Arms Service for future use. Based on the changeover necessary for the quantities requested, a penalty of 36¢ per action was developed and added to factory cost.

Further, no lost M/700 sales will result from consummating this order. However, overtime will be required within the M/600 Receiver ejection port group until RI-1270 equipment is available in March 1980. If production start-up on this order could be delayed until the second quarter, the RI-1270 equipment would be available and a 30¢ per unit labor variance penalty could be avoided.

The factory cost by caliber is as follows:

<u>Caliber</u>	<u>Quantity Requested</u>	<u>1980 Factory Cost M/600 Barreled Action</u>
222	920	\$ 75.03
243	717	\$ 74.54
308	499	\$ 74.15
6mm	96	\$ 74.41

R. S. Swartz, Superintendent  
INDUSTRIAL ENGINEERING SECTION

by S. M. Morris

SMM/mc

R.S. Swartz  
Ruffo.



M/600 - Bolt



January 11, 1966

R. B. HURLEY

MODEL 600 BOLTS

Re: Letter to W. E. Leek from H. J. Waterman 12/15/65

Due to the type of radius dimension on present model drawing form tool was made with a .010 radius or mean model drawing. This tool will never produce over a .010 radius.

Model drawing of magnum shroud is .699 - .697. In order to use the same form tool apparently the regular form tool has been used for all bolts, thus holding the shroud to .698 - .693 (regular model drawing), crush grind dimension at .698 - .695, it is possible to remove some of the .010 radius at this operation. At this time, all bolts are inspected and the radius is repaired by filing resulting in some unevenness and roughness, shown in Picture 1 and 2.

A more realistic approach to this condition would be to change model drawing to a .020  $\pm$  .005 radius which would not materially reduce wall thickness beyond other sections of shroud (see layout) and would insure sufficient radius remaining after succeeding operations. An experimental form tool with a .020 radius has been ordered for tryout.

Flushing of extractor rivet is necessary and results in some marring of bolt head as shown in all photos.

Chamfering of front and rear edges of lugs must be done to the very intersection of lug with O.D. and present samples indicate acceptance of file edge markings as in Photo #1 and 4. Gouges shown lengthwise in Photo #3 were obviously made while removing mismatch of crush grind and shroud O.D. This is not desirable.

W. S. Thompson  
Sr. Process Engineer

NST/eb



## REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE

*Remington*  
COPY*PETERS*  
COPY

"CONFINE YOUR LETTER TO ONE SUBJECT ONLY" \_\_\_\_\_

MEMORANDUM

Ilion, New York  
December 15, 1965TO: W. E. LEEK  
FROM: H. J. WATERMAN

## MODEL 600 BOLTS

In a report dated December 9, 1965-on M/600 cartridge feeding a proposal was forwarded regarding a change in the release point location on the M/600 rails. It was felt at this time that this change perhaps could include all cartridges with a head diameter of .472 (example: 308 Win.) as well as the belted magnums with a head diameter of .532.

P.E. & C. sent 12 M/600 rifles (3 each in Cal. 308 Win., 244 Rem., 243 Win., 35 Rem.) to Research for alteration to the proposed cut and return to them, for a design change test.

After these alterations the rifles were functioned with dummies in a preliminary test. There were no malfunctions of the actual feeding of the cartridges. However, there was considerable roughness in most cases experienced by working the bolt with cartridges in the magazine.

Examination of the bolts pointed out conditions which are in part exemplified by the attached photographs.

The model drawing (C-15479) of the bolt head calls for a .015<sup>R</sup> max. on the shroud. While this does indicate maximum and can be construed as dead sharp (as is very close to the case on several of the rifles) it is felt the intent of the drawing is clear and should be adhered to.

These serrated chamfers, uneven chamfers and radii, file gouges, grinder gouges, tool marks, and other discrepancies can and often do lead to feeding malfunctions, hard bolt lift, poor extraction and ejection.



W. E. Leek  
Model 600 Bolts

-2-

December 15, 1965

By far the worst problem here is the visual appearance and poor quality the customer and potential customer sees.

This same bolt head is used in both the M/600 and M/700 assemblies.

Attached are photographs of some of the bolt heads of the lot of 12 rifles. This may not be typical, or it may be, but in either case it is a definite possible problem both internally and externally.



H. J. Waterman  
Firearms Research & Design

HJW:T

cc



M/600 Bolt Body Assembly

9-10-64

RUN 2 PASSES ON CENTERLESS GRIND RLS  
TO BODY DIAMETER OF .6716

TOTAL INDICATOR READING

.012  
.011  
.010  
.009  
.008  
.007  
.006  
.005  
.004  
.003  
.002  
.001  
.000

CENTERLESS

CYLINDRICAL

POINT I

POINT II

POINT III

POINT IV

POINT V

358-11  
MADE IN U.S.A.

10 X 10 TO THE 1/2 INCH  
KEUFFEL & ESSER CO.



9/2/64

RB Hurley

M/700-600 - 420B Bolt Body  
Grind S.D.

The following are comparisons for the Cinn. Grinder:

- |  |               |   |
|--|---------------|---|
| ① Actual Schedule  | 580 Bolts/day |   |
| ② Production Schedule (includes br)                                    | 420 Bolts/day | ← |
| ③ Grind Time new method<br>(.7145 turn dia -<br>load-unload - address) | 2.1 Min       |   |
| ④ Capacity per hour  | 28.6 Bolts/hr |   |
| ⑤ Capacity 15hr @ 75% eff.   | 340 Bolts/day | ← |
| ⑥ Grind Time old method<br>(.7045 turn dia -<br>load-unload & address) | 1.4 Min       |   |
| ⑦ Capacity per hour  | 43 Bolts/hr   |   |
| ⑧ Capacity 15hr @ 75% eff.   | 515 Bolts/day | ← |

Bolts are warped from heat treat - new .025  
T.I.R. runout in center - this causes problems  
with grinding wheel hitting head on first pass.



600  
Bolt  
BY K. BURGER DATE 11-8-62

SUBJECT .30 - 30 BOLT

SHEET NO. 1 OF 1

CHKD. BY \_\_\_\_\_ DATE \_\_\_\_\_

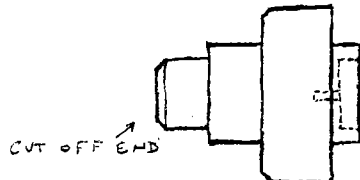
JOB NO. \_\_\_\_\_

BOLT HEAD

OP #5 DRILL, TURN, FORM, SHAVE AND CUT OFF.

SAME AS 700 BOLT HEAD - PT. NO. 15479, 15706

6 SPINDLE AUTOMATIC SCREW MACHINE.

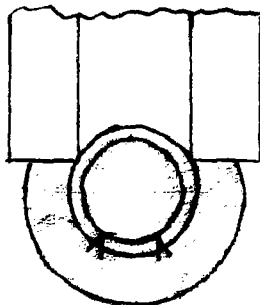


OP #10 BURR CUT OFF END. (BENCH GRINDER)

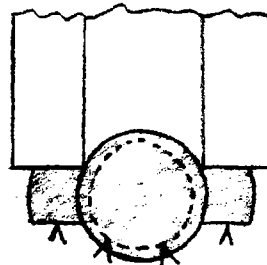
SAME AS OP. # 10 ON PT. NO. 15479, 15706

OP #15 CLIMB MILL BOLT LUGS

SAME AS OP. # 15 ON PT. NO. 15479, 15706



STEP 1



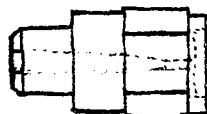
OP #17 STAMP "A" ON FRONT FACE OF LEFT LUG.

(RIGHT LUG TO BE REMOVED) MAX. HEADER

BOLT HEADS ONLY.

SAME AS OP # 17 ON REGULAR 700 PROCESS

OP #21 DRILL AND REAM FIRING PIN HOLE



FIRST PART OF OP # 20 PT. NO.  
NO EJECTOR HOLE, 15479  
GAS ESCAPE HOLE, 15706  
OR EJECTOR PIN HOLE



BY R. BURGER DATE 11-8-62 SUBJECT 30 - 30 BOLT SHEET NO. 1 OF 4  
CHKD. BY \_\_\_\_\_ DATE \_\_\_\_\_ JOB NO. \_\_\_\_\_

BOLT BODY ASSEMBLY

OP #5 ASSEMBLE WASHER AND BOLT HEAD TO BOLT BODY.

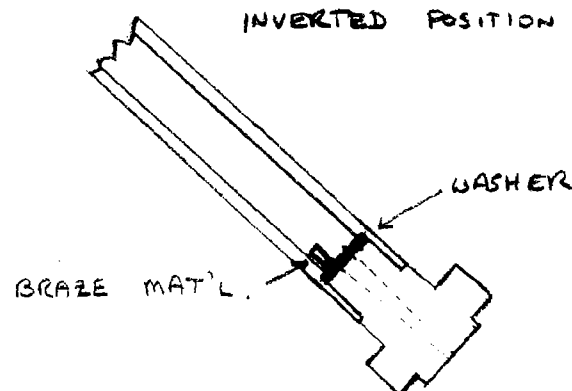
SAME AS FOR REGULAR 600 PROCESS.



OP #11 SPOT DRILL  $3/16$ " DEEP, STEP DRILL TO DEPTH AND DRIVE IN PIN #A-18758. REAM TO BUREAU FIRING PIN HOLE.

SIMILAR TO OP #10 ON REGULAR 600 PROCESS EXCEPT EJECTOR HOLE IS NOT REAMED.

OP #16 INSERT COPPER SLUG AND FURNACE BRAZE. THIS OPERATION CAN NOT BE DONE IN REGULAR MANNER, THAT IS DROPPING THE SLUG DOWN THE EJECTOR HOLE. THERE IS NO EJECTOR HOLE. THE BOLT WILL HAVE TO BE INVERTED AND THE BRAZE MATERIAL PLACED ON THE WASHER. (PER K. CHADWICK)



OP #20 INSPECT BRAZE

SAME AS FOR REGULAR 600 PROCESS



BY R. BURGER DATE 11-8-62 SUBJECT 30-30 BOLT SHEET NO. 2 OF 4  
CHKD. BY \_\_\_\_\_ DATE \_\_\_\_\_ JOB NO. \_\_\_\_\_  
\_\_\_\_\_

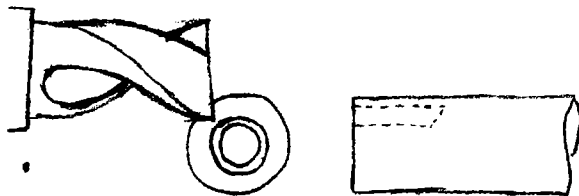
OP # 25 CYANIDE DEPLATE

SAME AS FOR REGULAR 600 PROCESS

OP # 30 TURN O.D. AND REMOVE RING LEFT BY BRAZE.

SAME AS REGULAR 600 PROCESS.

OP # 35 MILL SAFETY CUT



SAME AS REGULAR 600 PROCESS.

OP # 40 MILL COCKING NOTCH, RADIUS, AND BURR.

SAME AS REGULAR 600 PROCESS

OP # 45 RETAP BOLT PLUG HOLE

SAME AS REGULAR 600 PROCESS

OP # 50 WASH

SAME AS REGULAR 600 PROCESS

OP # 55 LINDBERG ANNEAL

SAME AS REGULAR 600 PROCESS

OP # 60 DEGREASE, MICRO HARDEN, QUENCH, AND DEGREASE

SAME AS REGULAR 600 PROCESS



BY R. Bunker DATE 11-8-62 SUBJECT 30-30 BOLT SHEET NO. 3 OF 4  
CHKD. BY \_\_\_\_\_ DATE \_\_\_\_\_ JOB NO. \_\_\_\_\_  
\_\_\_\_\_

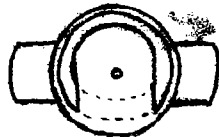
OP # 65 LINDBERG DRAW  
SAME AS REGULAR 600

OP # 70 INSPECT  
SAME AS REGULAR 600

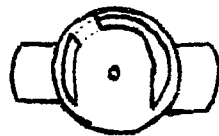
OP # 75A GRIND FINISH BODY DIAM. ON CENTERS  
SAME AS REGULAR 700 PROCESS  
ADD USE TO 600

OP # 80 GRIND LUGS TOP AND BOTTOM  
SAME AS REGULAR 600 PROCESS

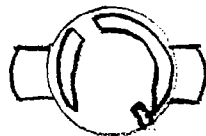
OP # 87 MILL SHROUD FOR EJECTOR SLOT



OP # 92 MILL SHROUD FOR EXTRACTOR CUT



OP # 97 MILL EJECTOR SLOT

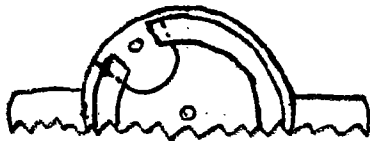




OP #100 DRILL AND REAM EXTRACTOR HOLE



OP #105 MILL EXTRACTOR ANGLE CUT



OP #110 BURR

THIS IS TO REMOVE ANY BURS FORMED  
IN OP # 87 - 105

OP #115 FILE CHAMFER ON CORNERS OF LUG AND  
BREAK SHARP CORNER ON BOTTOM FRONT EDGE  
OF BOLT HEAD

DIFFERENT FROM #85 ON REGULAR 600

OP #120 ALKALINE CLEAN ONLY

SAME AS OP #90 ON REGULAR 600

OP #125 MAGNAFLUX AND ETCH CODE SYMBOL AND DEMAGNETIZE

SAME AS OP #95 ON REGULAR 600

TO STORAGE AREA - DEPT 79 - BLDG. 82-1



BOLT ASSEMBLY

OP# 5 CLEAN BOLT BODY  
SAME AS REGULAR 600 PROCESS

OP# 10 CLEAN BOLT HANDLE  
SAME AS REGULAR 600 PROCESS

OP# 15 FLUX HANDLE & POSITION BRAZING SHIM ON  
HANDLE. FLUX BOLT & ASSEMBLE BOLT BODY  
ASSEMBLY & BOLT HANDLE IN FIXTURE &  
INDUCTION BRAZE,  
SAME AS REGULAR 600 PROCESS

OP# 20 CLEAN FLUX AFTER BRAZE  
SAME AS REGULAR 600 PROCESS

OP# 25 INSPECT 100%  
SAME AS REGULAR 600 PROCESS

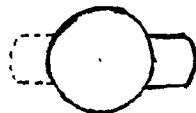
OP# 30 TEST BOLT HANDLE FOR BRAZE  
SAME AS REGULAR 600 PROCESS

OP# 35 TENSILE TEST BOLT HEAD FOR FUSING TO BOLT  
BODY AND MARK LUG WITH CENTER PUNCH TO  
DENOTE TEST HAS BEEN MADE,  
SAME AS REGULAR 600 PROCESS



OP# 36-1 MILL OFF RIGHT BOLT LUG

DIFFERENT FROM REGULAR



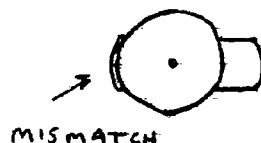
OP# 37-5      MAGNAFLUX      INSPECT      100%

SAME AS REGULAR 700 PROCESS  
ADD USE TO 600?

OP # 38-S BELT SAND BOLT HANDLE FLUSH WITH BOLT BODY  
AS REQUIRED.

SAME AS REGULAR 700 PROCESS  
ADD USE TO 600 ?

OP# 42 POLISH BLEND MISMATCH



OP # 47 REAM FIRING PIN HOLE TO REMOVE BRAZING MATERIAL,  
CLEAN EJECTOR SLOT TO REMOVE POLISHING COMPOUND.  
DIFFERENT FROM REGULAR



^ EJECTOR SLOT WILL PROBABLY HAVE  
TO BE SCRAPED.

OPT 70 ROTARY FINISH - SAME AS REGULAR 600 PROCESS

OP# 75 SPIN FINISH - SAME AS REGULAR 600 PROCESS



10/30/00 2:00 PM 10/30/00

5



1964 M/600 Cal. 222

Malfunction Rejects

	JAN	FEB	MAR	APR	MAY	JUNE	JULY	AUG	SEPT	OCT	NOV	DEC	
AB	.47		.31										
CH	1.59	17.72	2.28	1.41	1.56	.49	1.32	.52	.34	.60	.38	.40	
CLM	.47	.63	.11	.20		.07			1.37				
DE	.83		4.56	.60	.78								
DI	.12		.23			.14							
FF	.12		.23	.20	.16	.21	.31			.10			
JM	.47					.14	.08				.09	.20	
MCW	.18					.42	.31		1.72	.20	.85	.40	
OR	.30	.63	.57	.80	1.72	.14			3.78	.10			
SC	2.95	1.27	.68	1.61	1.41	6.81	4.35			8.40	2.46	.99	
DLU													
EDS						.07							
ESB	.06					.14				.10			
OH			.23	.20	.47	.77				.20	.85	.20	
XH			.11			.07	.16		.17	.40	.19		
BHR									<del>7.38</del>	.10			
	7.56	20.35	9.11	5.02	6.10	9.77	6.53		7.38	10.20	4.82	2.19	
MISC.	1.30	3.70	1.14	.40	.78	1.03	2.10	.52	.86	.80	.76	.60	
TOTAL %	8.86	20.05	10.25	5.42	6.88	10.80	8.63	1.04	8.24	11.00	5.58	2.79	
REJECTS	150	38	90	27	44	154	111	2	48	110	59	14	
TESTED	1694	158	877	497	640	1425	1285	191	582	999	1059	504	

File - M/600 Stalling Problems



**Journal of Democracy**



196 4 M/ 600 Cal. 6mm

Malfunction Rejects

	JAN	FEB	MAR	APR	MAY	JUNE	JULY	AUG	SEPT	OCT	NOV	DEC	
AB					.09					.40			
CH				2.11	2.58	.71	1.38		.31	2.79	5.63	1.94	
CLM									1.42				
DE				.12			.11						
DX									.74				
FP				.12	.45	.71	.85			.13			
JM									.25				
MCW													
OR					.98	.71				.13			
SC					.09		.11						
DLU													
EDS									.06				
ESB				.50	.18				.25	.13		.78	
OH				1.00		1.43	.64		.49	1.33	1.41		
XH					.09				.06				
BHR									.12				
				3.85	4.46	3.56	3.09		3.70	4.91	7.04	2.72	
MISC.				.87	.27		.21		.86	.40			
TOTAL %				4.72	4.73	3.56	3.30		4.56	5.31	7.04	2.72	
REJECTS				38	53	5	31		74	40	10	7	
TESTED				804	1122	140	941	0	1621	753	142	257	

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER

KINZER V. REMINGTON

R2528774







1964

W/600

Cal

300

Malfunction Rejects

	JAN	FEB	MAR	APR	MAY	JUNE	JULY	AUG	SEPT	OCT	NOV	DEC
AB		.08	.07		.30	.30			.16	.53	.20	.19
CH		1.04	2.21	2.96	1.57	3.24	1.52	1.02	.57	.61	1.12	.32
CLM		.48										
DE			2.80	2.04	.79	.38		.37		.70		
DI				.09			.09	.07		.09		
FF				.09		.08	.09	.07		.26		.13
JM												
MGV										.09		
OR		.08	.07	.19		.15		.29	.16			
SC		.08		.19	.39	.23						.06
DLJ		1.83		.19								
EDS		.36	.07	.09								.06
ESB		.48	.33	.27		.08	.09	1.02	.57	.53	1.32	
OH		1.33	1.43	1.02	1.14	2.56		.41	.41	1.66	.49	.46
XE		.08	.13	.26	1.97	.98	.19		.08		.10	
BER				.19								.06
		5.66	7.41	7.54	6.39	7.90	1.98	2.84	1.95	4.47	3.14	1.28
MISC.		.40	.22	.74	.00	1.53	.38	.51	.81	.79	2.24	.64
TOTAL		6.04	7.63	8.28	6.29	9.43	2.36	3.35	2.76	5.26	5.38	1.92
REJECTS	0	76	117	.89	16	125	25	46	34	60	53	30
TESTED	5	1256	1538	1074	254	1329	1051	1369	1230	1142	984	1572



## 4. Mission Statement



1964 W/600 Cal. 35 # Malfunction Rejects

	JAN	FEB	MAR	APR	MAY	JUNE	JULY	AUG	SEPT	OCT	NOV	DEC
AB											.50	
CH	19.51	13.94	5.55								1.51	
CLM												
DE												
DI												.84
FF											.17	
JM												
MCW												
GR											.50	
SC		.19									3.70	
DLU												
KDS												
ESB											.17	
OH												
XH												
BHR												
	19.51	14.13	5.55	.00	.00						6.55	
MISC.	1.71	2.76	5.55	.40							1.68	
TOTAL %	21.22	16.89	11.10	.40					0		8.23	.84
REJECTS	87	171	2	4					0		49	1
TESTED	410	1011	18	10	0	0	0	0	5	0	595	119







600

1-8-64

To R. Hurley  
From G. Markley

M/600 - 222 Rem - stem chamber and  
jump magazine

(19) guns rejected for stem chamber  
repaired by bending the rear tabs on  
the bottom of the magazine up to keep  
the magazine spring from moving too  
far to the rear of the magazine. By  
bending these tabs up pressure is kept  
on the feeding shell until it reaches the  
release point on the feed lips.

These guns tested 48 rds. each  
(17) passed with no malfunctions.

(2) gun rejected for shell on the right side  
of magazine jumping before the shell  
reached the release point.

one repaired by bending the magazine  
support to force the magazine to the  
right side of the magazine opening  
48 rds - no malfunctions.

Gun #3835 scrapped - The width of the  
opening across feed lips .007 over max  
M/DWG 540 I.005.



11/696 - Report



# P E. & C. ESTIMATE

SM. AIDIS  
WEEKER  
R.B. Nuxley  
A.G. CARLSON

TO: L. Fox

ESTIMATED BY: P.B. Group - Y. G. K. K.

MODEL 600 - For Export

PROJECT NO

DATE 9/7/66

PROJECT TITLE In order to comply with the BARREL LENGTH

REQUIRED to EXPORT to Japan. An extension to the BARREL is proposed

	HOURS	RATE	TOTAL
PROCESS ENGINEERING & TRIAL RUN			
TOOL DESIGN FIXTURES - GAGES	72		540
TOOLING FIXTURES - GAGES	375		3000
TOOL DESIGN - PERISHABLE TOOLS			
TOOL DESIGN REVISIONS			
PERISHABLE TOOLING			120
TOOL REVISIONS			1000
TOOL REVISIONS - PERISHABLE			
TESTING			
ADMINISTRATION			
VENDOR TOOLING COSTS (DIES ETC.)			
VENDOR TOOLING NOT REMINGTON PROPERTY			1800
SUB TOTAL			6460
CONTINGENCIES			640
			7100

RECEIVED  
SEP 7 1966

CURRENT PRODUCTS  
Process Engineering

COMMENTS



SEP 3 1966

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER  
KINZER V. REMINGTON

R2528783



## REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE

Remington  
DU PONTPETERS  
DU PONT

"CONFINE YOUR LETTER TO ONE SUBJECT ONLY"

Ilion, New York  
March 31, 1966

TO: V. G. DE REUS  
H. J. HACKMAN

FROM: H. J. WATERMAN

MODEL 600 BARREL EXTENSION

The Research Department requests that the P.E. & C. Control Section initiate a product high spot cost estimate on the proposed M/600 barrel extension and related parts.

Volumes to be considered are 1,000 and 5,000 annually.

Standard and Magnum barrel dimensions should be considered separately where applicable.

This M/600 barrel extension, or a similar type, has been requested by the Marketing Department to lengthen the M/600 barrel for possible export to Japan where minimum legal length of center fire barrels is 19 1/2".

Attached are drawings and marked prints. Please use for estimate only.

*H. J. Waterman*  
H. J. Waterman  
Ilion Research Division

W.E. Leek

HJW:T



HI-SPT ESTIMATE

PROCESS ENGINEERING ESTIMATE - TRIAL AND PILOT SHEET

• SEQUENCE OF OPERATIONS •

MODEL X-600 COMPONENT BARREL EXTENSION PART NO. \_\_\_\_\_  
 DATE 5-2-66 COMPUTER 277 SHEET 1 OF 1

OPER NO	OPERATION NAME	MACHINE	DEPT. NO.	HOURS DESIGN	HOURS BUILD
	PURCHASE FROM SREW MACH VENDOR				
	VENDOR'S PC/PR			1.00	EACH
	VENDOR'S TOOL COST			4990	PR
	(NOTE: PC PRICE SAME FOR STD & MRS)				
	PURCHASE INSPECT				
	MICS	STD			
	FED. RECESS GAGE	2 RECD			1300
	SPECIAL PLUG			6	60
	CALIPERS	STD			
	DEPTH PLUG			6	60
5	CARBONITRIDE HARDEN				
14	DRILL				
15	INSPECT FOR HARDNESS				
24	CENTERLESS GRIND				
25	FLASK OXIDE CLEAN				
	- TO BARREL ASSEM. -				
	TOTAL				

FD 250E 1-15-63



## PROCESS ENGINEERING ESTIMATE - TRIAL AND PILOT SHEET

MODEL X-600 COMPONENT Lock Ring PART NO. \_\_\_\_\_  
DATE 5-2-66 COMPUTER BD SHEET 2 OF 1


FD-3566 1-18-63



# PROCESS ENGINEERING ESTIMATE - TRIAL AND PILOT SHEET

\* SEQUENCE OF OPERATIONS \*

MODEL 600 EXPERT COMPONENT BARREL PART NO. 000010  
 DATE 8-30-66 COMPUTER KOWALSKI SHEET 1 OF 1

OPER. NO.	OPERATION NAME	MACHINE	DEPT. NO.	HOURS DESIGN	HOURS BUILD
	NOTE: SAME AS PRESENT M/600 BARREL. PILOT SHEET FOR THE FOLLOWING OPERATION.				
	15. PREP LOW END GROOVE. TURN				
					
	TURN BARREL	BU			
	TURN BARREL	BU		3	8
	TURN BARREL	BU		1	1
	TURN BARREL	BU			
	TURN BARREL	BU			
	TURN BARREL	BU		3	15
	TURN BARREL	BU		3	15
	TURN BARREL	BU		3	15
	TURN BARREL	BU		3	10
	TOTAL				

RD-656B

1-16-63



## • SEQUENCE OF OPERATIONS •

[illegible]



## • SEQUENCE OF OPERATIONS •

REF: D-29-75

OPER NO.	OPERATION NAME	MACHINE	DEPT. NO.	HOURS DESIGN	HOURS BUILD
	NOTE: SAME AS PRESENT M1600 FINAL ASSEMBLY EXCEPT FOR THE ADDITIONAL CHANGES AT OPERATION 175 "FINAL ASSEMBLY"				
15	Final Assembly				
27-1	Assemble Lower End, to Barrel				
27-2	Apply G.E. Lubricant Bore, Crane Head, to Barrel				
27-3	Assemble Lower End, to Barrel Extension to Barrel	Spec. Machine			
	TOTAL				

RD-6562

1-18-52



M/600 - Trigger Housing



XC: H. K. Boyle  
J. P. Linde  
C. O. Pardee

12/15/77

RE: M/XP-100 FIRE CONTROL


A meeting was held on Wednesday, 12/14/77, to review the progress on the new XP-100 Safety Assembly. This change has been in production for about a month with some repair work required in Assembly. The purpose of this meeting was to determine what could be done to eliminate the repair work. The following were in attendance:

S. D. Bennett  
J. W. Bower  
L. B. Ferriera  
B. H. Gilbert

G. J. Hill  
F. E. Martin  
C. F. Prosser  
L. G. Wilke

The following items were discussed:

1. Safety binds on Sear Block - A model drawing transmittal is complete to correct this, and the vendor has corrected his tooling. There are 5,000 Safeties on the plant which will be altered in Assembly. Production Proc. Eng.
2. Safety binds on Stock - Stocks are presently being cleared out in Assembly. An economic review will be made for altering the Stock mold. Chem & Met

  
J. W. Bower  
For the Committee

JWB/hf



XC: H. K. Boyle  
J. H. Carter  
P. G. Johnson  
J. P. Linde

11/15/77

RE: M/600 FIRE CONTROL

A meeting was held on Tuesday, 11/15/77, to review the new M/600 Fire Control. The following were in attendance.

E. Barnes  
S. Bennett  
J. Bower  
G. Hill

J. Hutton  
C. Prosser  
J. Snedeker  
J. Willoughby

60 of the new fire controls have been assembled and gallery tested. No gallery rejects were attributed to the new Fire Control. However, several observations were made during the assembly of the Fire Control:

1. Safety binds on Housing - This is caused by a worn vendors N. P. Process punch that forms the U-shaped section of the Safety arm. The vendor will correct. Temporarily, the Housing will be chamfered to provide clearance.
2. Safety binds on Stock -
  - a) Sidewise - caused by the Safety arm being fabricated N. P. Process at the wrong angle. The vendor has corrected.
  - b) Rearward - There appears to be an insufficient amount R & D of clearance rearward. R & D is reviewing the model drawings.
3. Housing interferes with Reinforcing Screw in Stock - The Chem & Met position of the Reinforcing Screw hole in the Stock is about .075 too far rearward. In order to assemble Housings, the Reinforcing Screw had to be bent.
4. Both ground and unground Sears were used for this test with no discernible difference in Trigger pull. It is therefore recommended that Sears not be ground.
5. A correction is required at the comparator for properly Process Eng. setting Trigger pull weight.

It was the consensus of the committee that the change to this Fire Control should not be implemented until the above deficiencies have been corrected.

11/17/77 - Part 40 - instruction for usage - c Please to follow  
J. W. Bower  
For the Committee

JWB/hf



XC: H. K. Boyle  
J. H. Carter  
J. C. Hutton  
P. G. Johnson  
J. P. Linde  
C. O. Pardee

12/15/77

RE: M/600 FIRE CONTROL

A meeting was held on Wednesday, 12/14/77, to review the progress on the new M/600 Fire Control. The following were in attendance:

S. D. Bennett  
J. W. Bower  
L. B. Ferriera  
B. H. Gilbert

G. J. Hill  
F. E. Martin  
C. F. Prosser  
L. G. Wilke

With reference to the 11/15 meeting, the following progress has been made:

1. Safety binds on Housing - The vendor has repaired his tooling to correct this. In the meantime, an "S" operation has been added to chamfer the Housing. N. P. Process
2. Safety binds on Stock -
  - a. Sidewise - The stamping vendor has corrected his tooling, and good parts are available. N. P. Process
  - b. Rearward - A model drawing transmittal has been made showing changes to both the Stock and Safety. The radius change on the Stock will be implemented with the next production run. The Safety change requires the vendor to change his tooling. In the meantime, a repair operation will be instituted in the wood shop to provide sufficient clearance. Chem & Met  
N. P. Process
3. Housing interferes with Reinforcing Screw in Stock. The Reinforcing Screw hole has been moved forward. Chem & Met
4. The decision has been made to grind Sears, and a model drawing revision is required for Powder Metal to leave a grinding allowance. R & D
5. It is felt that grinding the Sears will correct the heavy Trigger pull. If not, a different comparator setting will be used. Proc. Eng.  
a/c

The following new items were discussed:

1. Design verification testing should be complete by 12/16. R & D



2. Spare parts requests for Fire Controls, or Fire Control components (except Safeties) will be filled with the new design. Arms Serv.
3. The question of supplying Safeties alone is to be resolved. R & D
4. All future orders for vendor parts will be for new style Housing components. No old style parts will be inputted, unless required by Arms Service. Planning
5. It is expected that new style Housings will be available in Production Assembly by 12/27. Production

  
J. W. Bower  
For the Committee

JWB/hf



**REMINGTON ARMS COMPANY, INC.**

INTER-DEPARTMENTAL CORRESPONDENCE



xc: G. J. Hill  
J. W. Brooks  
F. E. Martin  
Lab file

"CONFINE YOUR LETTER TO ONE SUBJECT ONLY" \_\_\_\_\_

Ilion, New York  
February 10, 1978

TO: C. B. WORKMAN  
FROM: A. A. HUGICK *A. A. H.  
2-13-78*  
DATE: DECEMBER 20, 1977  
SUBJECT: PILOT - M/600 RIFLES ADUSING M/700 TRIGGER HOUSING  
WORK ORDER: 80-64

INTRODUCTION:

Twelve Mohawk M/600 rifles with M/700 trigger housings were delivered to the Measurement/Test Lab for pilot evaluation by production. Three rifles were Australian "Export" samples with jam screws at the trigger adjustment screws and nine were domestic samples with Duco cement sealant at the trigger adjustment screws.

TEST OBJECTIVE:

Review pilot sample M/600 rifles adusing M/700 trigger housing.

TEST RESULTS / OBSERVATIONS:

1. The rear stock reinforcement screw interferes with the forward portion of the trigger housing. One thousand rounds of shooting bent gun A6520153 stock reinforcement screw forward approximately .050<sup>+</sup> inch and damaged the trigger adjustment screw.
2. Gun A653136 sear lift measurement was below the design specifications. (Min. - .007 Max. - .018 inches)



To: C. B. Workman  
From: A. A. Hugick  
Pilot - M/600 Rifles Adusing M/700 Trigger Housing

February 10, 1978  
Page 2

TEST RESULTS / OBSERVATIONS:

3. Safe On & Off dry cycle testing indicated sear lift variations. This wide variation of lift appears to be the results of sear lift measuring technique via. reflected optical comparator.
4. Rifle A6520135 safety arm failed in safe On & Off dry cycle testing. Inspection of the fracture indicated a possible inclusion per 10x magnification.
5. Bright hand filed clearance for safety arm operation - assembly was noted on the rear of the right side of the trigger housing.
6. Rifle drop test results compare with earlier powder metal sear evaluation results.

TEST CONCLUSIONS:

The test results were reviewed with design and the recommendation made that the pilot test be accepted.

FUTURE WORK:

None planned at this time.

AAHUGICK:bd  
Measurement/Test Lab  
Ilion Research Division  
Attached



Seal Lift & Engagement were measured on the Optical Comparator

[illegible]

12-19-77 A.M.  
12-19-77 C.S.

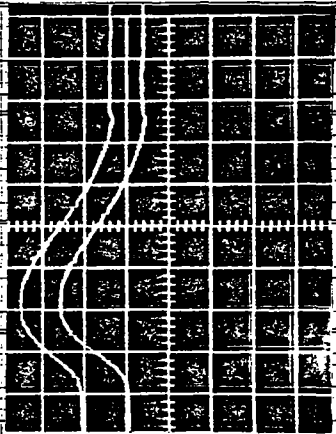
R2528797



Engagement & Lift were measured on the Optical Comparator by the use of the Reflection Unit.

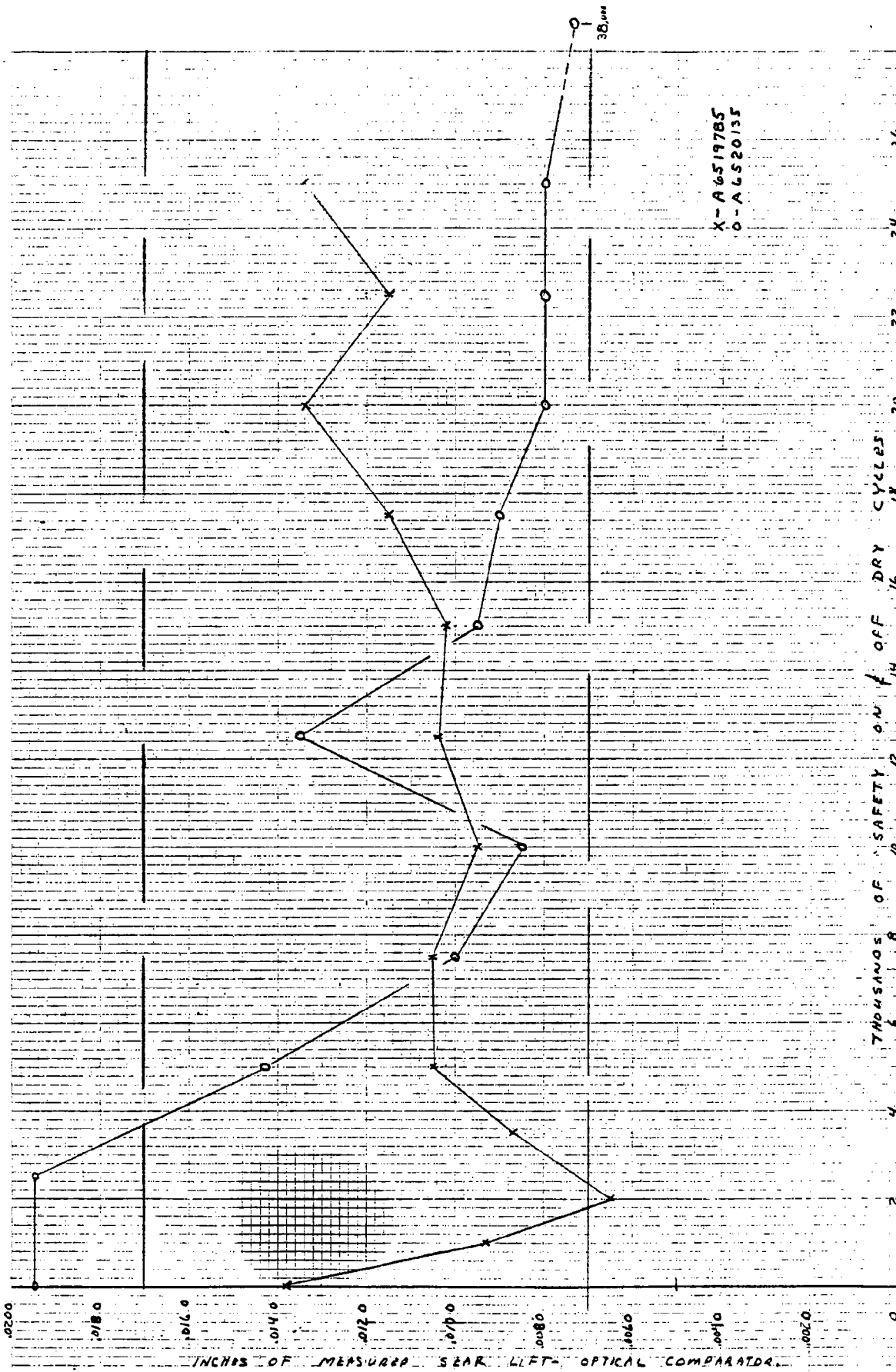
11-29-77 C.J. Sweet M1600 Australian Gun Evaluation

GUN	CALIBER	Firing Pin In Dent (in) (Avg. of 5)	Trigger Pull (lbs) (Avg. of 5)	Safe "On" (lbs) (Avg. of 5)	Safe "Off" (lbs)	Engagement* (Inches)	Lift* (Inches)
M1600 Serial No. A6315198	308	.023	6.9	3.33	2.66	.0192	.0135
M1600 Serial No. A6371413	308	.0237	4.75	5.33	4.16	.0205	.0135
M1600 Serial No. A632045	308	.0239	4.25	5.5	3.66	.0185	.0125
LOCK TIME M1600 Serial No. A6520135	33 AS&L 32 AS&L 32 AS&L 32 AS&L 32 AS&L 32 AS&L 32 AS&L 32 AS&L 32 AS&L 32 AS&L						
Original Safety Lever for Measurement							



M1600 Australian Gun Ser. No. A6520135  
Lock Time  
Emset/DW  
1.18 #2



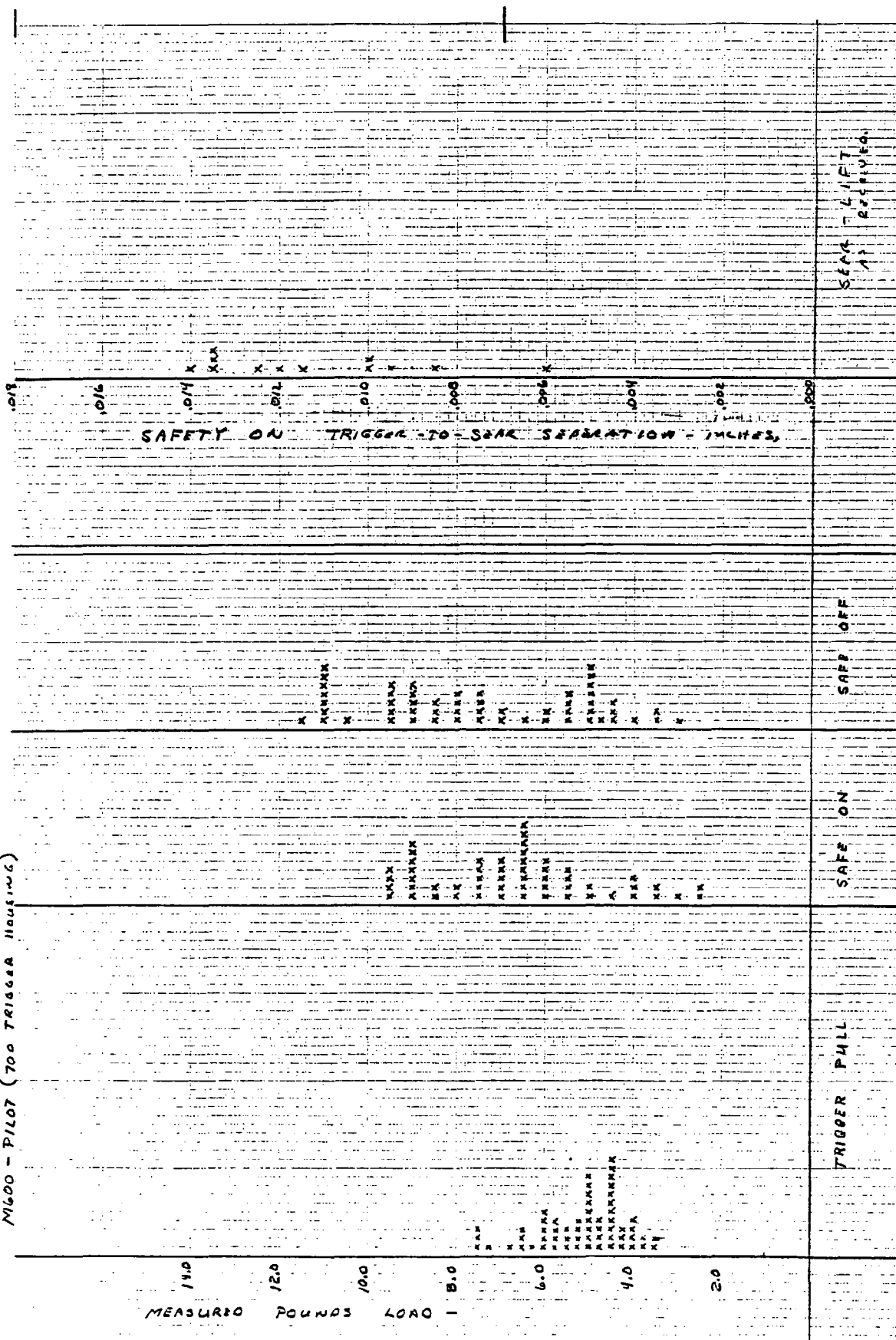


1/4" METRIC RULER CO. 1/4" INCHES  
 1" = 25.4 MM

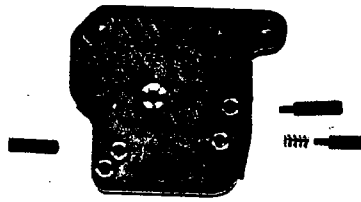
43 0203



M160 - PILOT (700 TRIGGER HOURS)







U.S.



AUSTRALIA

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## REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE

xc: G. J. Hill  
Lab File

"CONFINE YOUR LETTER TO ONE SUBJECT ONLY" \_\_\_\_\_

Ilion, New York  
January 12, 1976

TO: J. P. LINDE  
FROM: A. A. HUGICK  
DATE: JANUARY 12, 1976  
SUBJECT: M/600 RIFLES ADUSING M/700 TRIGGER HOUSING  
WORK ORDER: E 0262

INTRODUCTION:

Nineteen (19) M/600 - 308 Win. Caliber rifles with M/700 Trigger Housings were delivered from production to the Measurement Test Lab for evaluation. Note attached letter dated January 6, 1976 program item 1-A through 1-F for rifle assembly particulars.

TEST OBJECTIVE:

Review M/600 rifles adusing M/700 Trigger Housing assemblies for functional performance.

TEST RESULT/OBSERVATIONS:

1. Six (6) rifles indicate possible contact or interference of the stock reinforcement screw with Trigger Housing assembly.
2. Safety and fire control functions were measured and recorded, per attached.



To: J. P. Linde  
From: A. A. Hugick  
M/600 Rifle Adusing M/700 Trigger Housing

Jan. 12, 1976  
Page 2

TEST RESULT / OBSERVATIONS - Cont'd

M/600 - 308 WIN.

<u>Serial #</u>	<u>Safe On Force</u>	<u>Safe Off Force</u>	<u>Safety Function</u>
6251005	8#'s	7#'s	OK
0929	9#	12 1/2#	"
0970	8 1/2#	9#	"
1051	6#	3 1/2#	"
1002	6 3/4#	6 1/2#	"
1010	5 3/4#	5#	"
1026	6#	4 1/2#	"
0799	5 1/4#	4#	"
0785	7#	5#	"
4811	7 1/4#	7 1/2#	"
0989	7 3/4#	6 1/2#	"
1053	8 1/4#	10#	"
0992	8 1/4#	6#	"
1034	8 1/2#	9 1/2#	"
0984	6#	4#	"
0964	7#	6 1/2#	"
0926	7 1/4#	7 1/2#	"
0947	9#	10 1/4#	"
6251040	8#	10 1/4#	"

<u>Serial #</u>	<u>Safe on - Sear Lift</u>	<u>Stock Reinforcement Screw - - to - Fire Control Condition</u>
1005	.015" Go	Screw touches Fire Control
0929	.015" Go	Screw - OK
0970	.010 Go .015 No Go	Screw - OK
1051	.015 Go	Screw - OK
1002	.010 Go .015 No Go	Screw - OK
1010	.010 Go .015 No Go	Screw touches Fire Control
1026	.010 Go .015 No Go	Screw - OK
0799	.010 Go .015 No Go	Screw - OK
0811	.010 Go .015 No Go	Screw - OK
0989	.010 Go .015 No Go	Screw - OK
1053	.010 Go .015 No Go	Screw touches Fire Control
0992	.010 Go .015 No Go	Screw - OK
1034	.010 Go .015 No Go	Screw touches Fire Control
0984	.010 Go .015 No Go	Screw - OK



To: J. P. Linde  
From: A. A. Hugick  
M.600 Rifle Adusing M/700 Trigger Housing

Jan. 12, 1976  
Page 3

-----  
TEST RESULT / OBSERVATIONS - Cont'd

M/600 - 308 WIN.

<u>Serial #</u>	<u>Safe On - Sear Lift</u>	<u>Stock Reinforcement Screw - - to - Fire Control condition</u>
0964	.010 Go .015 No Go	Screw touches Fire Control
0926	.010 Go .015 No Go	Screw - OK
0947	.010 Go .015 No Go	Screw - OK
1040	.008 Go .010 No Go	Screw touches Fire Control

Safety detent positive on all guns.

TEST PROCEDURE:

Record gun serial number.  
Measure force to move safety to safe position.  
Measure force to move safety to fire position  
Check safety function in Safe position.  
Check safety function moving to fire position.  
Check safety detent function  
Check stock reinforcement screw-to-fire control clearance - to- interference  
Check sear lift by safety at trigger with following: For Go/No Go.  
    .015 music wire   )  
    .010 music wire   )  
    .008 music wire   )  
    .005 shim stock   )  
                                    Supplied A.

A A HUGICK

AAH:bd  
Meas/Test Lab  
Illion Research Division



CC: D. J. Anderson	C. A. Korba
L. B. Bosquet	J. P. Linde
J. W. Bower	R. J. Long
H. K. Boyle	F. E. Martin
J. J. Burns	N. W. Menard
R. J. Chesebrough	C. O. Pardee
W. W. Cook	C. F. Prosser
<u>A. A. Hugick</u>	File

January 6, 1976

A. D. KERR

C. B. WORKMAN

CENTER FIRE - FIRE CONTROL - SAFETY PROBLEMS

Center Fire - Design Process Problems

A program has been set up to review weekly with R & D and P E & C personnel, relating to Fire Control and Safety problems on M/700, 600, 788 and 580 Series.

Next meeting will be held in H. K. Boyle's office - Bldg. 52-4 on 1/13/76 at 8:15 A. M.

Program

1. Model 600 - 250 guns to be assembled with the following altered parts; this will allow M/700 trigger housings to be used in M/600.
 

A. Alter trigger housing side plates - 250 - ready 1/7/76. Ready for sub-assembly - 1/6/76.	D. Anderson
B. Alter sear-safety cam - 20 complete 1/6/76.	F. Martin
C. Alter M/700 safety levers. 20 complete - 1/6/76. 250 ready 1/7/76.	F. Martin
D. Transmit drawings for model drawing changes.	J. Linde
E. First 20 guns to be ready for test 1/6/76.	J. Bower C. Prosser



Program (cont.)

1. (cont.)

F. Guns to be regular gallery tested, then turned over to R & D for test.

A. Hugick

G. When change in safety occurs, what is status of XP100?

J. Linde

2. M/788 - Safety and related problems.

A. Fit of Receiver to Stock - drawings transmitted to tie up dimensions of Barrel bracket slot and front take down screw hole in Stock to front take down screw hole in Receiver. Complete 12/30/75.

J. Linde

1. Process Engineering to correct process to new drawings.

B. Bosquet  
J. Bower

B. Double click safe - present process.

1. Chamfer on safety to new sample - complete 12/18/75.

C. Prosser

2. Stone c'sink on safety detent hole on safety.

C. Prosser

3. Triggers being used - not ground.

J. Bower

4. H. T. study on safety warpage.

G. Hill

C. Double click safe - future process.

1. Housing - sample of 27 available to model drawing dimensions.  
- Mill thickness of safety .349-.346

G. Hill  
D. Anderson

2. New type safeties - available.

3. Triggers - H. T. Study to be completed by 1/5/76. From these results M/D dimension to be determined. Ready 1/13/76.

J. Linde  
J. Bower

4. Receivers with new safety clearance cut - available approximately 1/15/76.

W. Cook



Copies to: R. L. Hall  
C. B. Workman  
H. K. Boyle  
R. J. Chesebrough  
J. H. Sweeney  
Est. File #3569

5/11/76

*Martin to issue Model drawing to reflect change*

~~Under~~

*File - M/600 Trigger Housing*

May 5, 1976

L. B. BOSQUET

MOHAWK 600 - TRIGGER ASSEMBLY

An economic evaluation has been completed on the proposal to replace the present Mohawk 600 Trigger Assembly with a prototype of the Model 700.

Based on the 1977 Forecast, there will be a gross annual savings of \$7,910 and a 111% return on the total expenditure of \$12,800.

INDUSTRIAL ENGINEERING SECTION  
J. Polivka, Group Leader

*G. E. Saunders*

By: G. E. Saunders

GES/mc  
Att.



RD-6  
Rev. 10-67  
1-12-71

ESTIMATE # 3569  
ESTIMATED SAVINGS & RETURN ON INVESTMENT

NEW STYLE MODEL 600 TRIGGER ASSEMBLY

	PRESENT	PROPOSED		
Forecast Year	1977			
Quantity Forecast	14200			
<b>OPERATING COSTS</b>				
Purchased Parts	\$ 25390	\$ 22800	\$	\$
Raw Material				
Standard Labor	17060	15280		
Labor Variance @ 20% - 10%	3410	1530		
Industrial Relations @ 39%	7980	6560		
Supplies	230	240		
Tool Replacement	350	140		
Cutter Grind	160	90		
Tool Maintenance	60	70		
Maintenance	230	250		
Electricity	40	40		
Equipment Depreciation @				
<b>Franchise Tax @</b>				
	\$ 54910	\$ 47000	\$	\$
<b>SAVINGS IN OPERATING COST</b>				
Less: All other expense:		\$ 7910		\$
All Other 9.5%; Federal Tax 48%	.5294	\$ 5450		\$
<b>NET SAVINGS</b>		\$ 4190		\$
<b>INVESTMENT</b>				
Project expenditures		\$		\$
Manufacturing and working facilities				
Net change in working capital		\$ 3220		
Total capital required for this project		\$ (3220)		\$
<b>RETURN ON INVESTMENT - THIS PROJECT</b>				
NET SAVINGS - After Amortization of Operation Charges		\$ 3120		\$
Project Operation Charges		\$ 12800		\$
Loss: Federal Tax 50%		\$ 6780		\$
Total capital required including research and development and other charges		\$ 2800		\$
Return on total capital required		111%		%
Equipment to be released				
Increased space requirements (Decrease)				
Production capacity				
Forecast burdening			%	%

Engineer: G. Saunders  
Date: 5-5-76



## REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE



XC:

G. J. Hill ✓

Lab File

CABWICKMAN

HK Boyle

LT Bower

B Bosquet

"CONFINE YOUR LETTER TO ONE SUBJECT ONLY" \_\_\_\_\_

File - M/600 Trigger Housing

Ilion, New York

January 12, 1976

Please read and return

TO: J. P. LINDE

FROM: A. A. HUGICK

DATE: JANUARY 12, 1976

SUBJECT: M/600 RIFLES ADUSING M/700 TRIGGER HOUSING

WORK ORDER: E 0262

INTRODUCTION:

Nineteen (19) M/600 - 308 Win. Caliber rifles with M/700 Trigger Housings were delivered from production to the Measurement Test Lab for evaluation. Note attached letter dated January 6, 1976 program item 1-A through 1-F for rifle assembly particulars.

TEST OBJECTIVE:

Review M/600 rifles adusing M/700 Trigger Housing assemblies for functional performance.

TEST RESULT/OBSERVATIONS:

1. Six (6) rifles indicate possible contact or interference of the stock reinforcement screw with Trigger Housing assembly.
2. Safety and fire control functions were measured and recorded, per attached.



To: J. P. Linde  
 From: A. A. Hugick  
 M/600 Rifle Adusing M/700 Trigger Housing

Jan. 12, 1976  
 Page 2

TEST RESULT / OBSERVATIONS - Cont'd

M/600 - 308 WIN.

<u>Serial #</u>	<u>Safe On Force</u>	<u>Safe Off Force</u>	<u>Safety Function</u>
6251005	8#'s	7#'s	OK
0929	9#	12 1/2#	"
0970	8 1/2#	9#	"
1051	6#	3 1/2#	"
1002	6 3/4#	6 1/2#	"
1010	5 3/4#	5#	"
1026	6#	4 1/2#	"
0799	5 1/4#	4#	"
0785	7#	5#	"
4811	7 1/4#	7 1/2#	"
0989	7 3/4#	6 1/2#	"
1053	8 1/4#	10#	"
0992	8 1/4#	6#	"
1034	8 1/2#	9 1/2#	"
0984	6#	4#	"
0964	7#	6 1/2#	"
0926	7 1/4#	7 1/2#	"
0947	9#	10 1/4#	"
6251040	8#	10 1/4#	"

<u>Serial #</u>	<u>Safe on - Sear Lift</u>	<u>Stock Reinforcement Screw - - to - Fire Control Condition</u>
1005	.015" Go	Screw touches Fire Control
0929	.015" Go	Screw - OK
0970	.010 Go .015 No Go	Screw - OK
1051	.015 Go	Screw - OK
1002	.010 Go .015 No Go	Screw - OK
1010	.010 Go .015 No Go	Screw touches Fire Control
1026	.010 Go .015 No Go	Screw - OK
0799	.010 Go .015 No Go	Screw - OK
0811	.010 Go .015 No Go	Screw - OK
0989	.010 Go .015 No Go	Screw - OK
1053	.010 Go .015 No Go	Screw touches Fire Control
0992	.010 Go .015 No Go	Screw - OK
1034	.010 Go .015 No Go	Screw touches Fire Control
0984	.010 Go .015 No Go	Screw - OK



To: J. P. Linde  
From: A. A. Hugick  
M.600 Rifle Adusing M/700 Trigger Housing

Jan. 12, 1976  
Page 3

TEST RESULT / OBSERVATIONS - Cont'd

M/600 - 308 WIN.

<u>Serial #</u>	<u>Safe On - Sear Lift</u>	<u>Stock Reinforcement Screw - - to - Fire Control condition</u>
0964	.010 Go .015 No Go	Screw touches Fire Control
0926	.010 Go .015 No Go	Screw - OK
0947	.010 Go .015 No Go	Screw - OK
1040	.008 Go .010 No Go	Screw touches Fire Control

Safety detent positive on all guns.

TEST PROCEDURE:

Record gun serial number.  
Measure force to move safety to safe position.  
Measure force to move safety to fire position  
Check safety function in Safe position.  
Check safety function moving to fire position.  
Check safety detent function  
Check stock reinforcement screw-to-fire control clearance - to- interference  
Check sear lift by safety at trigger with following: For Go/No Go

.015 music wire	)	
.010 music wire	)	
.008 music wire	)	Supplied A.
.005 shim stock	)	

C.G. 74.  
AAH:bd  
Meas/Test Lab  
Ilion Research Division

A A HUGICK



939  
WORK REQUEST

DATE REQUESTED 1-9-76 WORK ORDER E0262

DESIGNER OR ENGINEER J. FLINDE

MODEL 600 CAL. OR GAUGE 308 BARREL TYPE —

TYPE OF TEST

NEW DESIGN — DESIGN CHANGE X

DRY CYCLE — ACCURACY — HAND LOADING — STRESS —

PRESSURE — MUZZLE VELOCITY — FUNCTION X PHOTOS —

EVALUATION X BOLT VELOCITIES — OTHER —

ESTIMATED COMPLETION DATE —

REPORT REQUIRED

FORMAL — INFORMAL X TEST RESULTS ONLY X

TEST OBJECTIVE

REVIEW THE 19 GUN ENGINEER SAMPLE  
RIFLES (M600 ADUING M700 TRIGGER PLATE  
HOUSING) PER ATTACHED SHEET.

GUNS REQUIRED

TEST COMPLETION DATE — SIGNED —

B 1270



M/600 - Trigger



## DON'T SAY IT—WRITE IT

To Lay  
FROM JimDATE 3/20/75Re. m/600 triggers

I spoke with Chuck Sampson today on dimensional problems with the 600 triggers. The .834/.837 Connector surface is running .002/.003 over max due to flashing on the bottom surface. Sampson said he will follow.

TO BE SAFE; FIRST THINK YOU MIGHT NOT BE



**REMINGTON ARMS COMPANY, INC.**

INTER-DEPARTMENTAL CORRESPONDENCE



"CONFINE YOUR LETTER TO ONE SUBJECT ONLY" \_\_\_\_\_

XC: W. E. Ackley  
 R. J. Chesebrough  
 J. G. Lampert  
 J. P. Linde  
 P. G. Johnson  
 J. J. Marley  
 C. O. Pardee  
 C. J. Sampson  
 W. A. Warren  
 File

*File under 600 Triggers*

November 21, 1978

M/600 TRIGGER

In fire controls, triggers have been breaking at trigger pin hole. This is occurring at assembly and in the field. A meeting was held with P. E. & C. and Powdered Metal to review:

1. As of 11/17, Production is magnafluxing all triggers being used on assembly. C. O. Pardee
2. P. E. & C. to process a lot of 100 thru operations of drilling trigger pin hole and c'sink pin hole. Triggers will be magnafluxed after operations to determine if and where cracking is occurring. Results to be reviewed by P. E. & C. and Powdered Metal. G. J. Hill
3. Powdered Metal is to analyze a sample of triggers before any operations performed by Plant. J. J. Marley  
 J. G. Lampert  
 C. J. Sampson

by

*G. J. Hill 11/21/78*  
 G. J. Hill, Supervisor  
 for the Committee

GJH/bdm



File under  
600 ~~700~~ Trigger

To R Bouch

9/7/78

15435 14 600 Trigger

Per instructions from Phil Johnson change  
the process as follows, G. Hill has  
evaluated samples of the new process  
and has approved them.

From: Press, Sinter, Coin, Barrel Finish

To: Press, Sinter, Coin, Anneal, Tochite Impregnate.

The Anneal will be in H-24 2050 hr  
with LC-24 and STW alternate furnaces.

Note to G Hill: please note the B.F. is being  
dropped, there was probably an error in the  
earlier process. The M700 (15280) and the  
XP100 (15457) are similar triggers and are not  
processed the with a B.F. Please make  
sure barrel finish is picked up in the  
plant processing.

Let me know if there are problems.

copy to Hill

Chamber

4/10/78 Process the same

600  
700

} More superheated operations  
in PIR



## DON'T SAY IT—WRITE IT

TO JERRY HILL

DATE 11.14.78

FROM BILL WARREN ~~WAW~~ *File*POWDER METAL PARTS - MOHAWK 600 TRIGGER ASSEMBLY

THE FOLLOWING PROBLEMS WITH POWDER METAL PARTS ARE ~~BEING NOTED~~ ON SUB-ASSEMBLY OCCURRING:

TRIGGER DRAWING C-15435

- PARTS ARE BREAKING THROUGH THE HOLE. ONE SUCH PART WAS BLACK COLORED @ THE BREAK. SAMPLES ENCLOSED.

- SERRATIONS DO NOT RUN FULL HEIGHT ON TRIGGER. COMPARE TO M200 TRIGGER.

- WHITE POWDER BLEEDOUT. WHEN CAN WE START PLASTIC IMPREGNATING THESE PARTS? M.D. COE REQ'D.

SEAR SAFETY CAM C-91470

- HOLE IS NOT COUNTERSUNK. BURR EXCEEDS ALLOWABLE M. DRAWING WIDTH. SEAR BINDS IN HOUSING. COMPARE TO M200 SEARS, WHICH ARE COUNTERSUNK AND WORK CORRECTLY. M.D. SPECIFIES COUNTERSINK.

LOT OF PARTS WAS RETURNED TO P.M. WEEK OF 11.6.78 FOR REWORK. THESE HAVE NOT BEEN RETURNED YET.

SAMPLES AND DRAWINGS INCLUDED.

*Triggers from warehouse - may be bad*

TO BE SAFE, FIRST THINK YOU MIGHT NOT BE



11/600 Trigger

UTICA PLATING COMPANY, INC.  
176 WHITESBORO STREET - YORKVILLE, NEW YORK 13495  
FIRST NATIONAL BANK BLDG. - UTICA, NEW YORK 13501  
Area Code 315 Phones: Plant 736-3079 - Office 732-2505

M E S S A G E

R E P L Y

TO Remington Arms Company, Inc.

Ilion, New York

Attn: Mr. L. E. Ferriera

DATE March 14, 1974

Re: Gold costs

Our actual metal costs on the triggers are running 33¢ and 20¢ for each piece, at \$180.00 per ounce for gold. Therefore, our costs to you would be 43¢ and 30¢ each.

However, we can retain the 16¢ price with a thinner gold.

Yours truly,

UTICA PLATING COMPANY, INC.

*[Signature]*  
Philip J. Jankiewicz  
Plant Manager

PJJ/jd

SIGNED

SIGNED

FORM AVAILABLE FROM GRAYARC CO., INC.  
882 THIRD AVE., B'KLYN 32, N. Y.

PERSON ADDRESSED RETURN THIS COPY TO SENDER

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER  
KINZER V. REMINGTON

R2528818



CC: J. W. Bower  
E. R. Carr  
K. R. Chadwick

S. P. Cross  
D. F. Kane  
J. J. Marley  
File

*DC 2 submitted*  
*7/19/73*  
          

May 30, 1973

C. F. PROSSER

M/600 Triggers #90377

Purpose:

To determine if connector clearance and diameter of trigger pin hole meet the model drawing specifications before Operation 46-47 Cyanide Harden and Draw; after Operation 46-47 Cyanide Harden and Draw; and after Gold Plating.

Observations:

1. Connector clearance does not meet model drawing dimensions prior to cyanide harden.
2. Significant change in connector clearance through cyanide harden and gold plate.
3. Significant change in trigger pin hole through gold plate only.

Method:

Thirty (30) triggers were taken at random from a single lot at heat treat and measured using 1 inch micrometer and gage plugs. Results are shown on attached charts.

Quality Control Department  
H. K. Boyle, Supervisor

by

*F. Cirillo*  
F. Cirillo

*G. A. Garlock*  
G. A. Garlock

FC/GAG/bdm  
Attachs.



M/600 - Trigger Guard







600  
RECEIVED  
DEC 9 1963

CURRENT PRODUCTS  
*Process Engineering*

~~①~~ *Handwritten signature*  
cc: G.M. Calhoun  
H. J. Hackman ✓

Ilion, New York  
December 5, 1963

F. E. MORGAN  
Bridgeport

MODEL 600 TRIGGER GUARD

Several field test reports commented about the finish of the trigger guard as being too "shiny" and tended to look "cheap". This is an item that I had "picked on" long ago, but failed to follow up to have it corrected.

Wayne Leek has requested the Plant to use a matte finish which will approximately match that of the molded rib. This should be going into effect immediately, and I have asked H.J. Hackman not to wait for any action of Operations Committee or Sales since the need is so obvious. Right at the moment this is being done as a supplementary operation; however, at a later date perhaps can be taken care of by a treatment to the finish of the mold.

Per telephone conversation it is agreed that we should add this same treatment to the field representatives' samples before they are shipped, even though may delay at least 4 or 5 days.

*Handwritten signature*  
S. M. Alvis  
Ilion Research Division

SMA:T



M/600 - Test Performance



~~Handwritten notes and signatures in the top left corner, including a circled '3' and a signature.~~

RECEIVED  
MAR 31 1967

CURRENT PRODUCTS  
Process Engineering

CC: W.E. Leek  
S.M. Alvis  
G.E. Puckett  
L. Fox  
V. DeReus  
W.A. Best  
R.B. Hurley  
C.H. Morse  
W.L. Dahl

TO: A. A. HUGICK  
FROM: W. R. GOOGIN *W.R.*  
SUBJECT: M/600 6.5mm mag. AUDIT TEST

March 20, 1967

Ten (10) M/600 6.5mm mag. bolt action rifles were withdrawn from the gallery for Research Audit Test.

TEST OBSERVATIONS

1. Two guns had firing pin indent below design specifications.  
2. Two guns had trigger pulls over design specifications.  
3. Three guns had substandard group sizes first test in the accuracy device.  
4. One bolt handle broke off when tested in the accuracy device.

DETAILED TEST RESULTS BELOW

- |   |   |
|---|---|
| 1. Headspace  | - All in Remington standards  |
| 2. Firing pin indent  | - Eight were in specification<br>Two were below minimum specification |
| 3. Trigger pull   | - Eight were in specification<br>Two were over maximum specifications |
| 4. Firing pin protrusion  | - All in Remington standards  |
| 5. Bolt lift  | - In specification  |
| 6. Group size<br>(Avg. of 3-5 shot groups<br>Shot in accuracy device<br>with Rem. 120 gr. psp cl)     | - Seven passed<br>Three rejected                                      |
| 7A Further accuracy<br>(the three reject guns and<br>the three best were reshot<br>from the shoulder) | - All six were in specifications                                      |
| 7B Two of the reject guns<br>were then reshot in the<br>accuracy device                               | - Both were in specifications<br>(results not recorded)               |



REMINGTON ARMS COMPANY, INC.

ENGINEERING DEPARTMENT COMPUTATION SHEET

Audit test

M600 MAG. G.S MM MAG. Accuracy, machine rest 100 yds  
Rem 120 gr. PSP C.L.

COMPUTER Ltj

DATE Feb 9

67

		GROUP SIZE	HORIZ. SPREAD	VERT. SPREAD
GUN #① 73969	1	4.65	4.3	2.05
	2	2.4	1.45	1.9
	3	2.8	2.75	.95
	AVG.	3.28	2.83	1.63

GUN #② 75134	1	3.1	2.35	2.05
	2	2.1	1.1	1.9
	3	1.35	1.25	.8
	AVG.	2.18	1.57	1.58

GUN #③ 73284	1	3.35	2.35	3.15	* Bolt handle broke off after second group
	2	2.95	.7	2.9	
	3	*	*	*	
	AVG.	3.15	1.53	3.03	

GUN #④ 75662	1			
	2	GUN WOULD NOT FIT PROPERLY IN MACHINE REST.		
	3			
	AVG.			

GUN #⑤ 73783	1	4.0	1.8	3.95
	2	2.3	1.45	1.85
	3	2.6	1.05	2.3
	AVG.	2.96	1.43	2.7



REMINGTON ARMS COMPANY, INC.  
ENGINEERING DEPARTMENT COMPUTATION SHEET

Audit test

M600 6.5MM MAG ACCURACY, MACHINE REST 100 YDS  
Prm 120 gr. PSP C.I.

PROJ NO

WORKS

DATE Feb 9

67

COMPUTER *WJ*

		GROUP SIZE	HORIZ. SPREAD	VERT. SPREAD
GUN #⑥ 74204	1	3.65	1.6	3.3
	2	4.7	2.9	4.45
	3	3.7	2.0	3.0
	AVG.	4.01	2.17	3.58

		GROUP SIZE	HORIZ. SPREAD	VERT. SPREAD
GUN #⑦ 74811	1	2.85	1.4	2.7
	2	3.85	2.1	3.4
	3	3.15	2.2	2.2
	AVG.	3.28	1.9	2.77

		GROUP SIZE	HORIZ. SPREAD	VERT. SPREAD
GUN #⑧ 70850	1	3.1	2.8	2.7
	2	3.5	3.45	2.1
	3	2.3	1.85	2.1
	AVG.	2.96	2.7	2.3

		GROUP SIZE	HORIZ. SPREAD	VERT. SPREAD
GUN #⑨ 73462	1	5.45	4.35	3.1
	2	2.3	.9	2.0
	3	2.9	1.55	2.65
	AVG.	3.55	2.27	2.58

		GROUP SIZE	HORIZ. SPREAD	VERT. SPREAD
GUN #⑩ 75078	1	6.6	1.9	6.3
	2	3.1	2.65	2.4
	3	3.5	2.05	3.35
	AVG.	4.4	2.2	4.01

Design Specs. 3.50 3" L OR R 2" low 4" high



ACCURACY  
m/600 - 6.5 mm MAG. AUDIT TEST  
T.F.P.

2/15 67

SUMMARY  
ACCURACY FROM SHOULDER

VS.

MACHINE

RANGE = NEW 100 Yd. - BENCH REST

SIGHTS = SCOPE - BALVAR & A - KUHARSKY - 1-PIECE MT.

MUNIC = REM-120 GR - PSPCL, FACTORY

INDEX # - 2065 CODE # - 6071.

GROUPS - 3-5 SHOT SPD. PER GUN

AIMING - CENTER TO CENTER

SHOOTERS - W.R. COGGIN & T.J. PLUNKETT

ALL FIGURES = AVE OF THREE SPD.

GUN #	FROM MACHINE			FROM SHOULDER		
	GR. SIZE	HR. SPD.	VER. SPD.	GR. SIZE	HR. SPD.	VER. SPD.
x (1) = 75154	2.18"	1.57"	1.58"	2.62"	2.13	1.92
x (2) = 73463	2.96"	1.43"	2.70"	2.40"	2.27	.88"
(3) = 74204	4.01"	2.17"	3.53"	3.00"	2.26"	2.45"
(4) = 70850	2.96"	2.70"	2.30"	3.40"	2.78"	2.56"
(5) = 73463	3.55"	2.27"	2.58"	1.65"	1.25"	1.55"
x (6) = 75078	4.40"	2.20	4.01	2.27"	1.87"	1.83"



# REMINGTON ARMS COMPANY, INC.

ENGINEERING DEPARTMENT QUALITY CONTROL COMPUTATION SHEET

## AUDIT TEST

M600 6.5MM. MAG.

PARAMETERS AS RECEIVED

DATE 4/5

3-14

67

TEST FUNCTION	GUN NO. 1	GUN NO. 2	GUN NO. 3	GUN NO. 4	GUN NO. 5	GUN NO. 6	GUN NO. 7	GUN NO. 8	GUN NO. 9	GUN NO. 10	DESIGN SPECS.
GUN SERIAL NUMBER	73969	75134	73284	75662	73783	74204	74811	70850	73462	75078	
HEADSPACE CHECK	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK	MIN. GO MAX. NO GO
FIRING PIN INDENT - IN.	.01925	.0208	.01915	.0185	.01775	.01945	.01705	.01925	.01935	.01925	.018 - .026
TRIGGER PULL LBS.	4.775	4.45	5.40	5.775	5.20	5.20	6.9	5.35	6.725	4.575	4 - 6
FIRING PIN PROTRUSION IN	.055	.060	.054	.056	.056		.058			.061	.045 - .075
COCKED BOLT LIFT. LBS.	5.0	4.8	4.5	4.8	4.1	4.0	5.0	5.1	5.0	5.0	N.A.
DRY FIRED BOLT LIFT LBS.	11.1	8.0	8.0	7.9	8.0	10.1	8.0	8.0	8.0	8.4	N.A.
GROUP SIZE MACHINE REST IN.	3.28	2.18	3.15		2.96	4.01	3.28	2.96	3.55	4.4	3.50
HORIZ. SPREAD MACHINE REST IN.	2.83	1.57	1.53		1.43	2.17	1.9	2.7	2.27	2.2	3" left or right
VERT. SPREAD MACHINE REST IN.	1.63	1.58	3.03		2.7	3.58	2.77	2.3	2.58	4.01	2" low 4" high
GROUP SIZE Shoulder shot. IN		2.62			2.40	3.00		3.40	1.65	2.27	3.50
HORIZ. SPREAD Shoulder shot IN.		2.13			2.27	2.26		2.78	1.25	1.87	3" left or right
VERT. SPREAD Shoulder shot IN.		1.92			.85	2.45		2.56	1.55	1.83	2" low 4" high
RE-TEST MACHINE REST GROUP SIZE, HORIZONTAL SPREAD						OK - WITHIN STDS.				OK - WITHIN STDS.	
GUN EXAMINER'S			BROKE BOLT HANDLE								



GOOD PEASE  
BOORUM & PEASE  
Remington

600 - 308 PILOT

M.C.W. - REAR LEGS ON FOLLOWERS  
INTERFERING WITH LANCING IN BOX

TRIGGER - BREAKING AT PIN HOLE

STOCKS - BREAKING FROM WOOD JOB

BOORUM & PEASE "NOISEAR" ®



600 - 308 CAL. PILOT - 9/10/63 *WBA*

DATE	GUN	CORRECT.	TOTAL RDS	% MALF.	ESB	DE	MCW	SLC	ABL	COMMENTS
9/10	1041		5		5					
	1087		15		5					
	1104		100		3					
	1165		100		2	9				
	1074		—					X		
	1143		—					X		
	1034		100						2	
	1326		96					2		
	1110		20	0						
	1136		20	0						
	1042		20	0						
	1135		20	0						
	1051		100	0						
	1095		100	0						
	1099		100	0						
	1155		100	0						
	1318		96	0						
	1036		100	0						
	1109		100	0						
	1083		80	0						
	1173		100	0						
	1071		100	0						



M/600 - Point of Impact



506

200 Gr. Bullet  
 .030 Shim Under Rear Sight  
 .030 Removed From Front Sight

12/9/63  
 M600 -35 Cal.

Gun #	Impact Pls	Rear Sight	Front Sight	Differential	Distance from Rib Top To Eyepiece	Distance from Top of Eyepiece To Base of Sight
1515	1" H 1" R	5.525	5.423	.102	.147	185
1470	1" L 0	5.525	5.414	.111	.136	175
1523	1" H 0	5.531	5.435	.096	.147	191
1565	1" H 0	5.551	5.431	.120	.166	211
1466	1" H 0	5.537	5.429	.109	.154	192
1443	1/2" H 0	5.508	5.416	.098	.130	172
1434	1/2" L 1" R	5.525	5.410	.115	.145	186
1473	1" H-0	5.304	5.195	.109	.160	227
1450	1" H 0 R	5.544	5.415	.129	.168	210
1576	0-1 R	5.525	5.425	-.100	.140	191



M/600 - Magnum



cc: H. J. Hackman ✓  
S. M. Alvis

REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE



RECEIVED

DEC 6 1965

Bridgeport, Connecticut  
December 1, 1965

TO:

CURRENT PRODUCTS  
*Process Engineering*

FROM: F. E. MORGAN

A Model 600 in the 6.5MM Remington Magnum caliber Carbine is being shipped to you for field test and evaluation. 80 rounds of ammunition in 120 grain will also be shipped with the gun.

These carbines are factory produced and tested, and are similar in every respect to the 350 Magnum carbine with exception of the caliber. The 6.5MM Magnum will provide long range shooting equipment for the enthusiast who is interested in that combination for big game; provides a high velocity, flat shooting, accurate carbine.

The 120 grain pointed corelokt bullet used in this combination has already been tested and found to be very effective on mule deer, antelope and elk, and of course, it is an excellent combination for long range shooting of smaller game such as coyotes, foxes, badgers, and on varmints such as crows, chucks, etc.

The ballistics of this combination have not been officially released, but they will be reviewed with you at our sales meetings. The ballistics of the 6.5 Mag. are comparable to that of a 270 Win. and although Remington is only furnishing this caliber with 120 grain bullet, the handloader will find an unusually good spread of bullet weights from the custom bullet shops.

You might ask why replace the 270 with a 6.5 Magnum. The 270 is a longer cartridge and requires a longer receiver, therefore resulting in a heavier, more cumbersome type of rifle. To keep our concept of magnum carbine in its own category it was necessary to develop this efficient, high velocity cartridge to fit the carbine itself.

The following is a review of the designer's specifications submitted to you last year on the 350 Magnum Carbine. All items listed apply to the new combination.



To:

December 1, 1965

1. The new barrel is MAGNUM weighted and extra heavy for rigidity, although still carrying the same general barrel contour as the standard 600 models. The barrel is free floating and equipped with standard factory open sights.
2. The MAGNUM stock is of walnut and beech wood, laminated for greater strength and waterproofed to prevent warpage. With custom checkering and the now famous DuPont RK-W finish applied, this gun gives a pleasing overall two-color effect.
3. The action is the same weight and general characteristics as the present standard 600 action. However, it is epoxy bedded into the stock for maximum accuracy. This insures return of the barrel to the same bedding position shot after shot.
4. The sight line carries the same general characteristics with the free floating Delrin ventilated rib. This DuPont material is impervious to weather, warping, etc.
5. Telescope Mounting - The M/600 MAGNUM model will introduce for the first time a raised barrel bracket. This elevated projection located between the joining point of the receiver and barrel serves as a recoil support for mounting of a telescope base. Or in other words, when shooting heavy caliber cartridges this new barrel bracket provides a 'back-up support' for the telescope. This will insure positive firm positioning of telescope when shooting.

Further mounting features include for the first time a forward mounting facility (removable rear sight) for telescope bases. With this forward mounting of telescope, offhand shooting is unobstructed from loading to ejection of cartridge. Long eye relief effect is thus obtained which gives much clearer picture in big game hunting, particularly if the game is in movement.

A standard short eye relief mounting may also be made if desired.

6. Recoil Pad - A black recoil pad with white spacer is fitted to the butt of the stock, which softens recoil for all types of shooting.



To:

December 1, 1965

7. All MAGNUM models will be fitted with a 7/8" quick detachable leather carrying strap as standard equipment.

----

Please test this new Model 600 Magnum Carbine for function, feeding, extration, ejection, trigger pull, etc., for accuracy at 100 yards both offhand and bench if possible, and evaluate carrying qualities.

If any malfunction occurs, please return related ammunition, either fired or unfired, to Harvey Hackman at Ilion.

Please complete the test at the very earliest date - return in 2 weeks' time if possible. Insure Carbine for \$500.00 upon return.

Your report should be directed to F. E. Morgan with copy to Harvey Hackman at Ilion. Additional distribution will be made to interested parties.

FEM/mgm

ALL TESTS AND REPORTS ARE

STRICTLY CONFIDENTIAL



③ V. G. De Reus

① G. Thompson  
② BB Blum

December 9, 1965.

TO: W. E. LEEK  
FROM: H. J. WATERMAN

SUBJECT: M-600 CARTRIDGE FEEDING

Investigation of the M-600 (Magnum Cal.) feeding malfunction of the last round out of the magazine being "hard under rail" has indicated two methods of correction.

The first method is to change the release point cut in the rails (.015-.018 opening from .540 width), moving the cut starting point .370 rearward and terminating this cut .270 further forward. This runs this cut out as close to the forward wall of the magazine cut as a .250 dia. cutter will allow.

The 30 bevel cut on the bottom of the rails is continued forward to the front wall of the magazine cut. The cuts of this method have been made on a .350 Rem Mag and 6.5 Rem Mag. and the two rifles tested successfully with a minimal number of rounds.

A number of dummy rounds of other M-600 calibers (.308 Win., .243 Win., .35 Rem., 6.5 Rem) were put through the magazines successfully. This was not a conclusive test and only indicates the rail change could be standardized. Further testing would be necessary.

The second method would be a change in the follower. It seems a decrease of approximately .050 on the high side of the follower allows the cartridge (Magnum) to be camed from under the rails sooner and without binding.

This change can be either by raising the low side .050 or of course lowering the left side by the same amount. When the low side is raised, which can possibly be accomplished by reworking the blank before heat treat, or by having a new follower manufactured, the magazine box capacity is reduced by the depth of the pad increase. This capacity is critical now, several changes having been made to reach the present dimension.



M-600 CARTRIDGE FEEDING - Continued

December 9, 1965.

Lowering the high side of the follower would call for a new follower. There does not appear to be a way that blanks could be re-worked in a secondary operation successfully.

The second method in which the follower was changed does not call for a change in the rail cuts. The altered Receivers were functioned successfully with the altered follower but the double change is not necessary.

There was no attempt to function standard rifles in other than magnum calibers with the altered followers. There have been no feeding problems reported in other calibers.

The problem appears readily solvable with either method. The economics are not dealt with herein but appear to perhaps be the key to the solution of the problem.

No changes will be instituted on the M-600 model drawings or on the M-600 6.5mm Rem Mag rifles for field representation until management makes their decision.

H. J. WATERMAN

HJW:GMS

50



## P. E. &amp; G. ESTIMATE

F. G. Carlson

TO: H. S. Nakman

ESTIMATED BY:

V. G. J. King

MODEL 600 Magnum

PROJECT NO:

DATE 5/27/65

PROJECT TITLE Estimate to Add 6.5 mm to the model 600  
Magnum Rifle

	HOURS	RATE	TOTAL
PROCESS ENGINEERING & TRIAL RUN			
TOOL DESIGN FIXTURES - GAGES			900
TOOLING FIXTURES - GAGES			4000
TOOL DESIGN - PERISHABLE TOOLS			100
TOOL DESIGN REVISIONS			100
PERISHABLE TOOLING			500
TOOL REVISIONS -			400
TOOL REVISIONS - PERISHABLE			
TESTING			600
ADMINISTRATION			3500
VENDOR TOOLING COSTS (DIES ETC.)			
VENDOR TOOLING NOT REMINGTON PROPERTY			
SUB TOTAL			10,100
CONTINGENCIES			400
			10,500

RECEIVED  
MAY 28 1965

CURRENT PRODUCTS  
Process Engineering

R & I Charges - not to be included in project

R & I Charges - not to be included in project -

COMMENTS



1417 97 1985



600 - Product Safety



*File -*  
*M/600 Product Safety*

CC: W. E. Ackley	A. D. Kerr
D. J. Anderson	N. W. Menard
<u>J. W. Bower</u>	C. F. Prosser
J. J. Burns	C. O. Pardee
R. J. Chesebrough	R. L. Stafford
W. W. Cook	C. B. Workman
A. Huffman	File
E. D. Johnson	

January 19, 1976

H. K. BOYLE

Report on Investigation and Follow-Up on  
M/600 - Follow Down - Gallery Rejects

On 1/15/76 - (5) M/600 Follow Down rejects were recorded by Gallery.  
Investigation revealed the following problems and action taken to correct:

Problem caused by sear bound in down position after trigger has been pulled.

1. Investigation revealed a burr at rear sear pin hole in trigger housing.  
Burr caused from pin holes in Receiver being out of gage on span of  
holes. M/D dimension 1.429-1.427 - actual measurements 1.418 on 3  
Receivers.
  - A. Receiver corrected by new bushings on special  
machine that drills holes. After correction  
dimension measured 1.429. E. Johnson  
A. Huffman
  - B. To insure proper dimensional check by operator,  
Gage B-52944 to be put in Receiver process J. Bower  
Operation #116 - Line Ream Fire Control Holes. R. Stafford
  - C. Dept. 54 - screened 610 Receivers in area -  
found 50 that would not meet span gage.
2. Guns checked at Assembly, 9 of 140 followed down after Gallery and  
Final Inspection.
  - A. Warehouse checked for January '76 and December  
'75 guns.
    - 1 of 30 - January '76 defective
    - 1 of 20 - December '75 defective
    - 5 of 60 - November '75 defective C. Pardee  
(see attached reports) W. Ackley




Report on Investigation and Follow-Up on  
M/600 - Follow Down - Gallery Rejects (cont.).

- 2 -

2. (cont.)

- B. Warehouse to be screened approximately 1800 guns.
- C. All guns assembled and packed after 1/16 - marked "F" on label.

by

  
G. J. Hill, Supervisor  
Quality Control Dept.

GJH/bdm  
Attachs.



CC: W. E. Ackley N. W. Menard R. E. Smith  
 J. W. Bower C. O. Pardee  
 R. J. Chesebrough T. H. Pratt  
 R. L. Hall G. E. Puckett  
 A. D. Kerr C. B. Workman File

WAREHOUSE AND PACKAGING AUDIT REPORT

DATE 1/19/76

MODEL 600 GA./CAL. 222 6MM  
243 308

SHIFT \_\_\_\_\_

GUN AUDIT ☒ DEFECT DESCRIPTION CHECK SEAR FOR BIND

PACKAGING AUDIT

GUN AUDIT SUMMARY

MODEL	PROD. DATE	S.S.	O.K.	DEF.	REMARKS
222	14BI	5	5		
6MM	13BI	5	5		
6MM	8BI	5	4	1	SEAR BINDS DOWN
243	14BI	5	5		
308	12BI	5	5		
308	12BI	5	5		
243	2XZ	5	5		
243	16XZ	5	5		
6MM	18XZ	5	4	1	SEAR BINDS DOWN
6MM	15XZ	5	5		
TOTALS		50	48	2	

PACKAGING AUDIT SUMMARY

MODEL	PROD. DATE	S.S.	O.K.	DEF.	PACK. NO.	REMARKS
TOTALS						

Quality Control Department  
 G. J. Hill, Supervisor

by R. H. Charles Date 1/19/76

HKP/bdm GJH/bdm Rev. 5/7/74  
 Rev. 5/1/73

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER  
 KINZER V. REMINGTON

R2528844



CC: W. E. Ackley N. W. Menard R. E. Smith  
 J. W. Bower C. O. Pardee  
 R. J. Chesebrough T. H. Pratt  
 R. L. Hall G. E. Puckett  
 A. D. Kerr C. B. Workman File

WAREHOUSE AND PACKAGING AUDIT REPORT

DATE 1/20/76

MODEL 600 GA./CAL. 243  
222

SHIFT \_\_\_\_\_

GUN AUDIT ☒ DEFECT DESCRIPTION CHECK SEAR FOR BIND

PACKAGING AUDIT \_\_\_\_\_

GUN AUDIT SUMMARY

MODEL	PROD. DATE	S.S.	O.K.	DEF.	REMARKS
600	22/RZ	5	5		
	12/RZ	5	5		
TOTALS		10	10		

PACKAGING AUDIT SUMMARY

MODEL	PROD. DATE	S.S.	O.K.	DEF.	PACK. NO.	REMARKS
TOTALS						

Quality Control Department  
 G. J. Hill, Supervisor

by R. H. Charles Date 1/20/76

HKB/bdm G.JH/bdm Rev. 5/7/74  
 Rev. 5/1/73

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER  
 KINZER V. REMINGTON

R2528845



CC: W. E. Ackley N. W. Menard R. E. Smith  
J. W. Bower C. O. Pardee  
 R. J. Chesebrough T. H. Pratt  
 R. L. Hall G. E. Puckett  
 A. D. Kerr C. B. Workman

*File - m/600  
 Product Safety*

File

WAREHOUSE AND PACKAGING AUDIT REPORT

DATE 1/19/76

MODEL 600 GA./CAL. 222 6MM  
243 308

SHIFT

GUN AUDIT ☒ DEFECT DESCRIPTION CHECK SEAR FOR BIND

PACKAGING AUDIT

GUN AUDIT SUMMARY

MODEL	PROD. DATE	S.S.	O.K.	DEF.	REMARKS
222	14BI	5	5		
6MM	13BI	5	5		
6MM	8BI	5	4	1	SEAR BINDS DOWN
243	14BI	5	5		
308	12BI	5	5		
308	12BI	5	5		
243	2XZ	5	5		
243	16XZ	5	5		
6MM	18XZ	5	4	1	SEAR BINDS DOWN
6MM	15XZ	5	5		
TOTALS		50	48	2	

PACKAGING AUDIT SUMMARY

MODEL	PROD. DATE	S.S.	O.K.	DEF.	PACK. NO.	REMARKS
TOTALS						

Quality Control Department  
 G. J. Hill, Supervisor

by R. H. Charles Date 1/19/76

HKB/bdm GJH/bdm Rev. 5/7/74  
 Rev. 5/1/73

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER  
 KINZER V. REMINGTON

R2528846



1  
 Please make copies incl  
 742, 600, & 700  
 GALLERY REJECTS - FOLLOW UP ACTION

CC - AKEER RCHESBEC  
 HBoyle C. Price  
 D LOUIS  
 WACKLEY  
 J Bowers  
 C PROSSER

DATE	MODEL	MAIFUNCTION	CAUSE	ACTION
14/15	788	FOS	SAFE BINDS ON STOCK	Review Assembly Foreman.
14/15	742 (2)	FD #82	Incorrect adjustment Disconnecter to Action Bar	Reviewed Assembly Foreman & Supervisor
7/7	600	Long Fire #85	Firing Pin binds on Burst Plug	1) Reviewed assembly Supervisor 2) Reviewed production Foreman Sept 75
1/8	600	FD (6)	Sear binds on Trigger Housing	1) Reviewed Foreman
1/9	742 (2)	FD #94	Incorrect adjustment Disconnecter to Action Bar	Reviewed assembly Foreman
1/9	700	FSR	Safe binds on Stock	Reviewed assembly Foreman.



J.M. EXC NEO Rev.  
 Make two additional copies and file under  
 M/600 - Product Safety  
 M/700  
 M/742

# LOG OF SAFETY PROBLEMS

W/F	DEFECT	CAUSE
11/21/76	600 FD	FOREIGN MATTER BINDING SEAR
	742 FD	F.P. BINDS, RET PIN CUT MIS CUT IN F.P.
	742 FD	DISC. LOOSE, DROPS OFF ACTION BAR
	700 FD	COCKING CAM A NOTCH OFF POS. IN BOLT
11/28/76	600 FD	SEAR BINDS, BURR IN REAR HOUSING PIN HOLE
	600 FSR	CONNECTOR BINDS, BURR @ HOLE
	600 FSR	CAN'T DUPLICATE - CHECKS OK
12/5/76	742 FD	PRIMER FRAGMENT CAUGHT IN F.P. HOLE
12/12/76	600 FSR	CONNECTOR BINDS ON CROOKED TRIG STOP SCREW
	600 FSR	CONNECTOR DOESN'T RETRACT - NO LUBE & MIS ADJUSTED
12/19/76	742 FSR CLOSING	F.P. BOUND FORWARD, RET. PIN CUT .015 SALLOW (.14)
	700 FSR	INSUFFICIENT SAFETY LIFT - .0015 (.005 MIN)
	700 FSR	SAFETY BINDS ON STOCK - HIGH AT R.S. OF TANG
1/2/77	742 FD	INSUFFICIENT TENSION ON DISCONNECTOR, DROPS OFF A. BAR
	700 FSR	TRIGGER STICKS BACK, BINDS IN GUARD - LEFT SIDE
1/16/77	742 FD	COULDN'T DUPLICATE, BUT FOUND PRIMER ANVIL IN ACTION
	700 FSR	SAFETY BUTTON BINDS ON STOCK - HIGH AT R.S. OF TANG.
	742 FD	DISCONNECTOR OVER TOP OF CONNECTOR
	700 FSR	INSUFFICIENT SAFETY LIFT - .0015 (.005 MIN.)



# GALLERY REJECTS - FOLLOW UP

File - M/600  
Product Safety

CC - Adken  
K Chesebrough  
Wockley  
R Joy  
J Bomer  
N Menard  
H Boyle  
C Walker  
C Kaba

DATE	MODEL	MAIFUNCTION	CAUSE	ACTION
1/23/76	700	FSR	SAFETY CROOKED checked to Process Engineering's gage	1) Reviewed Assembly Foreman. 2) Gage similar to one used by Process Engineers to be ordered by Production
1/23/76	700	FSR	SAFE HITS STOCK	Reviewed assembly Foreman
2/3/76	700 (2)	FSR/FD #29	Trigger guard deformed bending trigger.	Reviewed Production Foreman - He will review with operator.
2/6/76	600 (3)	FD	Sear Binds on Trigger Housing	Reviewed Assembly Foreman -  J.H.H. Quality Control