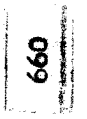
Model 660

BOORUM & PEASE "NOREAR" ®

SE "NOREAR" ®


660

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

BARBER - PRESALE R 0127140

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

REMINGTON STANDARDS - ARMS

MODEL 660		308 Win.	6MM Rem.	222 Rem.	35 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	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 (SAMMI)						
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.

BARBER - PRESALE R 0127140 R2528128

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

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.

RD 6496

BARBER - PRESALE R 0127141
BARBER - PRESALE R 0127141 R2528129

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

BARBER - PRESALE R 0127142

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

BARBER - PRESALE R 0127142
R2528130

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

MODEL 660		308 Win.	6MM Rem.	222 Rem.	35 Rem.	243 Win.		223 Rem. (Export Only)
MARKINGS	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)							
METAL FINISH	Black color, medium lustre on all exposed parts except as otherwise tabulated.							
PATENT NUMBERS	None.							

(1) Added. See SAFETY for reference.

BARBER - PRESALE R.0127144
BARBER - PRESALE R 0127144
R2528132

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON
BARBER - PRESALE R 0127145 R2528133

BARBER - PRESALE R 0127145

11-30-67
REVISED 10-10-69

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. 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 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.

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

MODEL 660	308 Win.	6MM Rem.	222 Rem.	~~35 Rem.~~	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)							
Rear (700 type)	Adjustment for windage and elevation.						
Eyepiece	"U" notch. White indicator						
Step	Graduated notches.						
Base	Attached to barrel with two(2)screws.						
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. Min. #13, 7-20-67.
(2) Added, See (1) above.
(3) Serial No. Sequence added. See Marking Dwg. C-14398.

RD-6489

BARBER - PRESALE R 0127146
R2528134
BARBER - PRESALE R 0127146

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

BARBER - PRESALE R 0127147

original 9-25-66
REVISED

REMINGTON STANDARDS - ARMS

SHEET 7

MODEL 660		308 Win.	6MM Rem.	222 Rem.	[illegible]	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.							

RD-6489

R2528135

OCT 3 [illegible]

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON
BARBER - PRESALE R 0127149 R2528137

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 - frarward 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: Obsolete Committee Minutes [illegible]

(1) Ref: See letter G.M. Calhoun to S.M. Alvis 3-18-66 [illegible]

RD-6480

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.		.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	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.

RD 6489

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON
BARBER - PRESALE R 0127150 - R2528138
BARBER - PRESALE R 0127150

Model 660 Mag.

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

BARBER - PRESALE R 0127152

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 - frarward 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 Sproting 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.

RD 6489

R2528140

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON
BARBER - PRESALE R 0127153
BARBER - PRESALE R 0127153
R2528141

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

REMINGTON STANDARDS - ARMS

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 (with strap & swivels)			6 3/4 lbs.		6 3/4 lbs.			
MAGAZINE	Fixed - Top Loading							
Capacity			3		3			
Follower	Bright Plate							

(1) Current (10) gun sampling.

RD-6469

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

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

REMINGTON STANDARDS - ARMS

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		
Other			
(1) Other	Mark "S" and "F" on receiver adjacent to respective SAFE and FIRE stop positions of safety.		
Bolt	(Prick-punch marks) 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.

BARBER - PRESALE R 01271-54
R2528142

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

BARBER - PRESALE R 0127155

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

REMINGTON STANDARDS - ARMS

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 5733.							
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.

RD-6469

BARBER - PRESALE R 0127155
R2528143

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

BARBER - PRESALE R 0127156

10-10-69
REVISED 11-30-67

REMINGTON STANDARDS - ARMS

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.

RD-6469

R2528144

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

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			
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.		

(1) "S" and "F" added. See Operations Comm. Min. #13, dated 7-20-67.

BARBER - PRESALE R 01271 R2528145

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

MODEL 660 MAGNUM		350 Rem, Mag.		6.5MM Rem. Mag.
STOCK	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.
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.			

BARBER - PRESALE R 0127158
R2528146

OCT 3 1966

Astle 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 brings 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 700.

You may want to get better legal language from Bob Sperling.

RECEIVED
SEP 12 1979
P.J. ROSENDAHL

EP

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. 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

Pete

MFB:sw

27 August 1979

Remington Arms Co Inc
Bridgeport
Connecticut 06602
U S A

RECEIVED
SEP 4 1979
INTERNATIONAL

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

Maurice F Bush
SPORTING GOODS DEPT

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

MFB:sw

27 August 1979

Mr D [illegible] Astle
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.

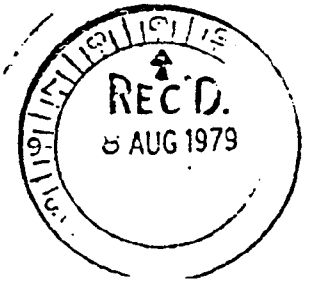
I would consider replacement of my present Model 660 faulty Rifle with a model 700 equivalent rifle to be a more appropriate arrangement.

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.

Ypurs faithfully

D W Astle



MFB: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.

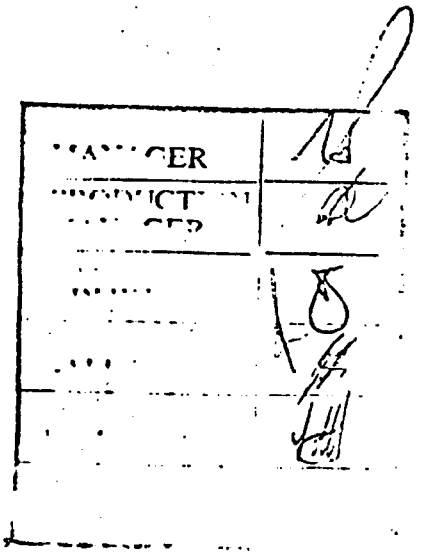
There are a relatively small number of rifles in New Zealand involved in the re-call and we have received no objections from the owners at having their firearms fitted, at no charge, with new trigger assemblies by a warranty Gunsmith.

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, CROTHER & CO LTD

M F Bush
SPORTING GOODS DEPT



CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS ENGINEERING ASSIGNMENTS

Job Description: M/660 Bolt Assemblies Char.- Safe binds in Bolt	Area Engineer: Burns
	Sheet No.: 1 / Job No.: 3917-B5
	Job Priority: D
	Job Code: 6
	Model: 660
	Part Name: Bolt
	Oper. No.: 5
	Dept. No.: 60
	Est. Comp. Mo/Yr:
	Est. Comp. Hours:
Assigned By:	Date: / Est. Savings:

Report Date	Elapsed Hrs.	Accomplishments
11/18/68	8	One hundred handles were processed milling stem to -.008 ± .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

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

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

M/640 - Stock

PROCESS ENGINEERING ASSIGNMENTS

Job Description: Char. - New Model Oper. - Compile Process	Area Engineer: Nielsen Sheet No.: 1 Job No.: 3199-71 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
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

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS ENGINEERING ASSIGNMENTS

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

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS ENGINEERING ASSIGNMENTS

Job Description:	Area Engineer: Clements
Oper. - Inlet Top of Stock	Sheet No.: 1 Job No.: 3696-C1
Char. - Set up to run on G-16 Inletter	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

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS ENGINEERING ASSIGNMENTS

Job Description:	Area Engineer: Nielsen
Oper. - Drill Grip Cap Screw Holes	Sheet No.: 1 Job No.: 3727-N1
Char. - Alter clamping to improve quality	Job Priority: A3
	Job Code: 1
	Model: 660
	Part Name: Stock
	Oper. No.: Drill Grip Cap Screw Holes
	Dept. No.: 71
	Est. Comp. Mo/Yr:
	Est. Comp. Hours:
Assigned By:	Date: Est. Savings:

Report Date	Elapsed Hrs.	Accomplishments
2/15/68		Request for clamp design change. Tooling being altered.
3/15/68		New clamp complete - appears O.K.
4/15/68		COMPLETE

RD - 6566 2/1/63

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS ENGINEERING ASSIGNMENTS

Job Description: Oper. - Drill Butt Plate and Front Locating Holes Char. - Change from hand oper. to Richardson G. I. Machine.	Area Engineer: Nielsen Sheet No.: 1 Job No.: 3728-M1 Job Priority: A3 Job Code: 1 Model: 660 Part Name: Stock - Laminated Oper. No.: Drill B/P Holes etc. Dept. No.: 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		COMPLETE

RD - 6566 2/1/63

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

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. 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.
2/19/68		Spacers to be used on calibers were necessary until higher sights are available. Close out. COMPLETE

RD - 6566 2/1/63

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS ENGINEERING ASSIGNMENTS

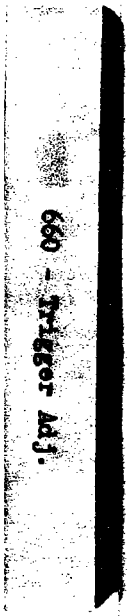
Job Description: M/660 Sight Line	Area Engineer:
	Sheet No.: 1 Job No.:
	Job Priority: 3
	Job Code: 6
	Model: 660
	Part Name: Final Assem.
	Oper. No.:
	Dept. No.: 61
	Est. Comp. Mo/Yr:
	Est. Comp. Hours:
Assigned By:	Date: 1/26/68
	Est. Savings:

Report Date	Elapsed Hrs.	Accomplishments
2/19/68		M/660 Sight Line at present is as follows;

Cal.	.030 Spacer	Sight
350	No	Low
6.5	Yes	Hi
222	No	Hi
243	No	Hi
6mm	Yes	Hi
308	No	Low

RD - 6566 2/1/63

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON


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	Trouble with Trigger holes not being in line in the Trigger housing punch to square the Housing. 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.
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

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

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	Trouble with Trigger holes not being in line in the Trigger housing punch to square the Housing. 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 nesessary "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.
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	6	
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	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).
6/20/68	5	
6/24/68	4	
7/8/68	3	Made a new set up with a 3 inch vise - had block made to try to straighten with heat. New parts from vendor.
7/9/68	2	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.
7/10/68	4	
7/15/68	1	Parts are not much better than the previous lot.

RD - 6566 2/1/63

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS ENGINEERING ASSIGNMENTS

Job Description: M/660 Trigger Adjustment	Area Engineer: Tibbitts
	Sheet No : 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: 3/13/68 / 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.

RD - 6566 2/1/63

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

M/660 - Quality

BARBER - PRESALE R 0127188

CC: W. A. Best, L. J. Boyle, E. R. Carr, L. Fox, G. E. Puckett, N. S. Thompso, W. J. Scott, S. F. Prosser, File

WAREHOUSE AUDIT REPORT
(QUALITY AUDIT RETEST)

DATE 3/[illegible]/69

MODEL 660 ITEM Front Trigger Adjusting Screw MK./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 3/20/69 PROD. PERIOD AUDITED 3/12/69 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			
TOTALS	500		50			

Quality Control Department
N. W. Menard, Supervisor

by C. C. Hritz Date 3/21/69

NWM/bd
12/8/67

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

BARBER - PRESALE R 0127188 R2528176

RD-6561

CC: W. A. Best, L. J. Boyle, R. J. Chesebrough, G. E. Fletcher, L. Fox, [redacted] E R CARR, N. W. Menard, G. E. Puckett, W. T. Scanlon, J. L. Smyder, N. S. Thompson, 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. & Ga. 308

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

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. Prosser 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		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. 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. Guns feed normally after outer rim of bolt is smoothed off.

RD - 6566 2/1/63

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

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

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

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 11/28 - 12/7/67

PRODUCTION ON HAND

PROD. DATE	QUAN. PROD.	QUAN. OBS. XMXMX MXMXM	12/7 FIRST WHSE. SAMP.	XXMXM XMXMX	12/14 SECOND WHSE. SAMP.	RESULTS OBSERVED
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	128	128	3		-	
	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

MWM/xx bd
6-25-[illegible]

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

BARBER - PRESALE R 0127192

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

PRODUCTION ON HAND

PROD. DATE	QUAN. PROD.	QUAN. OBS. XMXMX	WHSE. SAMP.	XMXMX	RESULTS OBSERVED
11/28	133	15	3		all samples O. K.
11/29	164	-	-		
11/30	190	1	1		
12/1	20	-	-		
12/4	50	-	-		
12/5	124	-	-		
12/6	20	20	3		
12/7	128	70	3		
	829	106	10		

ACTION TAKEN

QUALITY CONTROL DEPARTMENT
N. W. Menard, Supervisor

By W. T. Scanlon

NWM/xxbd
6-20-67

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

BARBER - PRESALE R 0127192

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 wasout 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

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

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

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS ENGINEERING ASSIGNMENTS

Job Description: M/660 Sight Line	Area Engineer: Tibbitts
	Sheer No.: 1 / Job No.: 3608-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: 1/26/68 / Est. Savings:

Report Date	Elapsed Hrs.	Accomplishments
2/19/68		M/660 Sight Line at present is as follows:
3/18/68		**Spacer has been discontinued in favor of new .460 Front Sight now in production.**
4/17/68		**All calibers within specs. with new sight.** **Close out.** COMPLETE

Cal.	.030 Spacer	Sight
350	No	Low
6.5	Yes	Hi
222	No	Hi
243	No	Hi
6mm	Yes	Hi
308	No	Low

RD - 6566 2/1/63

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

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. COMPLETE

RD - 6566 2/1/63

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS ENGINEERING ASSIGNMENTS

Job Description: 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. 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.
9/17/68		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

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS ENGINEERING ASSIGNMENTS

Job Description: M/660 Trigger Adjustment	Area Engineer: Tibbitts
	Sheet No. 2 of 2 | 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
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

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
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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 wasout 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. 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.

RD - 6566 2/1/63

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

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.**
9/17/68		**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.**

RD - 6566 2/1/63

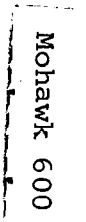
CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS ENGINEERING ASSIGNMENTS

Job Description: M/660 243 Cal. High Reject Rate Point of Impact	Area Engineer: Tibbitts
	Sheet No.: 1 Job No.: 3811-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		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.
7/17/68		Close out. COMPLETE

RD - 6566 2/1/63


Mohawk 600

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

BARBER - PRESALE R 0127204

ILION RESEARCH DIVISION JFF:bmg

REVISED 5-12-70 11-24-70

REMINGTON STANDARDS - ARMS

LIMITED DISTRIBUTION

MODEL MOHAWK 600		308 Win.	6MM Rem.	222 Rem.	243 Win.
ACCURACY					
Range	100 yards				
Point of Aim	6 o'clock on target				
Center of Impace	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.
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 Manufactures' Institue (SAAMI).				
ANNOUNCEMENT					
Jan 1971					
Warehouse Date					
DISCONTINUED					
* Magnum Calibers Deleted Per	F. E. Morgan. See Letter V. G. DeReus to A. D. Kerr 10-30-70				

RD-6128

BARBER - PRESALE R 0127204

LIMITED DISTRIBUTION

MODEL MOHAWK 600		308 Win.	6MM Rem.	222 Rem.	243 Win.
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)	18 1/2"				
Diameter (O.D.)	Mag num size.				
Bore (in.)		.300 min. .302 max.	.237 min. .238 max.	.219 min. .220 max.	.237 min. .238 max.
Groove (in.) (6)		.308 min. .310 max.	.243 min. .244 max.	.2240 min. .2250 max.	.243 min. .244 max.
Twist (R. H.) 1 Turn in		10 inches	9 1/8 inches	14 inches	9 1/8 inches
Markings	See MARKINGS – Barrel				
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 (last four (4) numbers) Use "shrouded" bolt plug.				
BOLT STOP	Located in left rear of "bolt track" in receiver. Use narrow tool to push down for release.				

RD-6489

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON
BARBER - PRESALE R 0127205
BARBER - PRESALE R 0127205
R2528193

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON
BARBER - PRESALE R 0127206
R2528194

ILION RESEARCH DIVISION JFF:bmg

REVISED 5-12-70 11-24-70

REMINGTON STANDARDS - ARMS

LIMITED DISTRIBUTION

BARBER - PRESALE R 0127206

MODEL MOHAWK 600		308 Win.	6MM Rem	222 Rem.	243 Win
BUTT PLATE		Black	Black	Black	Black
EJECTOR	Plunger type – spring loaded and pin assembled in bolt head.				
EXTRACTOR	Riveted to bolt.				
FIRING PIN	Spring retracted in bolt.				
Protrusion	.045 min. – .075 max.				
Indent	.018 min. – .026 max. (using copper crusher				
GUN – Length (Overall)	37 1/4" (Nominal)				
– Weight	6 1/2 lbs. (Nominal)				
MAGAZINE	Fixed – top loading				
Capacity		4	4	5	4
Follower	Bright plate.				
Spacer		No	No	Yes	No

RD-6489

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

LIMITED DISTRIBUTION

MODEL MOHAWK 600	308 Win.	6MM REm.	222 Rem.	243. Win.
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			

RD-6489

BARBER - PRESALE R 0127207
BARBER - PRESALE R 0127207
R2528195

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON
BARBER - PRESALE R 0127208
R2528196

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

BARBER - PRESALE R 0127208

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

MODEL MOHAWK 600	308 Win.	6MM Rem.	222 Rem.	243 Win.
SAFETY	2 – stop Position, forward and back–thumb operated. Serrated black surface.			
Location	Right rear of receiver.			
Fire Position	Forward stop. "F" Marking on receiver			
Safe Position	Rear stop. (Bolt handle locks down – action closed.) "S" marking on receiver.			
SERIAL NUMBER	(C-14398) First No. used 6200000 Last No. used 6899999.			
Location 1	See MARKING – Receiver.			
2	See MARKING – Bolt.			
SLING STRAP	As accessory at extra cost.			
Description:	7/8" QD type same as used on M/700. Leather material.			
SIGHTS	Metal material Black color			
Front (700 type)	Serrated ramp. Dove tail Brass bead. Attached to barrel with two (2) screws.			
(2) Rear (788 type) (1)	"U" notch. Eyepiece adjustable for windage and elevation. Base supported by rib (See RIB)			
	Attached to barrel with two (2) screws.			

(1) REF: Oper. Comm. min. No. 9, June, 1972. Releasing for production.
(2) Revised per design change 7-9-73.

RD-6489

BARBER - PRESALE R 0127209
BARBER - PRESALE R 0127209
R2528197

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

LIMITED DISTRIBUTION

MODEL MOHAWK 600		308 Win.	6MM Rem.	222 Rem.	243 Win.
STOCK	Comb cuts.	Formed grip.	Monte Carlo.	Angular forearm.	
Material		Walnut	Walnut	Walnut	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"				
Grip Cap	None				
Checker	D-15844 (Custom)				
~~Finish~~	~~Lacquer~~				
Bedding		Reg.	Reg.	Reg.	Reg.
TRIGGER	Metal material	Gold Color.			
Finger Surface	Serrated.				
Pull (lbs).	4 lbs. min. – 6 lbs. Max.				
Engagement	Sealed at factory.				
TRIGGER GUARD	Black "Zytel"				
Type	One piece mold.				

RD-6469

BARBER - PRESALE R 0127210
BARBER - PRESALE R 0127210 R2528198

BOORUM & PEAS

BOORUM & PEASE "NOTEAR" ®

600

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

MODEL 600		308 Win.	6MM Rem.	222 Rem.	~~XXXXXX~~	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 1/2"	2 1/2"	2 1/2"	XXXXX	2 1/2"		2 1/2"
	4 shots in:	3"			XX			
Ammunition		180 gr. PSP	100 gr. PSP	50 gr. SP	XXXXXXXX	100 gr. PSP		55 gr. SP
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.		1964		1964	1964	1965		
June			1964					1965
Warehouse Date								
DISCONTINUED								
Jan.					1967			
June								

BARBER - PRESALE R 0127212
R 528200

MODEL 600		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. 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.	.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 Turn in		10 inches	9 inches	14 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.							

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON
BARBER - PRESALE R 0127213 R2528201
BARBER - PRESALE R 0127213

MODEL 600		308 Win.	6MM Rem.	222 Rem.	XXXXXX	243 Win.		223 Rem. (Export only)
BUTT PLATE	Black plastic							
EJECTOR	Plunger type - spring loaded and pin assembled in bolt head.							
EXTRACTOR	Riveted to bolt.							
FIRING PIN	Spring retracted in bolt.							
Protrusion	.045 min. - .075 max.							
Indent	.018 min. - .026 max.		(using copper crusher)					
GUN - Length (Overall)	37 1/4" (Nominal)							
- Weight	5 1/2 lbs. (Nominal)							
MAGAZINE	Fixed - top loading							
Capacity		4	4	5	XX	4		5
Follower	Bright plate.							
Spacer		No	No	Yes	XXX	No		Yes

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON
BARBER - PRESALE R 012714
R528202
BARBER - PRESALE R 012714

BARBER - PRESALE R 0127215

MODEL 600

		308 Win.	6MM Rem.	222 Rem.	XXXXXXX	243 Win.		223 Rem. (Export only)
ARKINGS	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)							
ETAL FINISH	Black color, medium lustre on all exposed parts except as otherwise tabulated.							
ATENT NUMBERS	None							

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

BARBER - PRESALE R 0127215
R2528203

BARBER - PRESALE R 0127216

MODEL 600

		308 Win.	6MM Rem.	222 Rem.	XXXXXX	243 Win.		223 Rem. (Export only)
CKAGING	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. 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 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.							
OOF TEST (REP)	Fire one (1) standard proof cartridge in each gun. For location of marking (REP) see MARKINGS - Barrel.							
CEIVER	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.							

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON
BARBER - PRESALE R 0127216
R2528204

MODEL 600	308 Win.	6MM Rem.	222 Rem.	XXXXXX	243 Win.	223 Rem. (Export only)
SAFETY	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).					
SERIAL NUMBER	(Start 1000)					
Location (1)	See MARKING - Receiver.					
(2)	See MARKING - Bolt.					
SLING STRAP	As accessory at extra cost.					
Description:	7/8" QD type same as used on M/700. Leather material.					
SIGHTS	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.					
Eyepiece	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
KINZER V. REMINGTON
BARBER - PRESALE R 012721 R 528205
BARBER - PRESALE R 012721

BARBER - PRESALE R 0127218

MODEL 600

		308 Win.	6MM Rem.	222 Rem.	XXXXXX	243 Win.		223 Rem. (Export only)
TOCK	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.							

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

BARBER - PRESALE R 0127218
R2528206

g. 7-1-65
VISED 12-14-[illegible] 3-30-66

REMINGTON STANDARDS - ARMS

MODEL 600 MAGNUM			350 Rem. Mag.		6.5MM Rem. Mag.			
CCURACY								
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.			
CTION	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)							
NOUNCEMENT								
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.
[illegible] 12-14-65 (Verbal)

RECEIVED
MAR 31 1966
CURRENT PRODUCTS
Process Engineering

AL 0014337

MODEL 600 MAGNUM		350 Rem. Mag.	6.5MM Rem.Mag.
RREL	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	See 350 Mag.
Length (Nominal)		18 1/2"	See 350 Mag.
Diameter (O.D.)		Magnum	See 350 Mag.
Bore (in.)		.348 Min.	.256 Min.
		.354 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		
EL RIB	Black Delrin. Ventilated type attached to barrel studs with screws. Matted between sight positions.		
T (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.
Memo from W.E. Leek to R.P. Kelly dated 3-3-66 authorizing bedding specifications.
Division - Production & Research Division agreement of 3-7-66 per R.P. Kelly.

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON
BARBER - PRESALE R 0127221
BARBER - PRESALE R 0127221 R528209

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APR 4 1966

CURRENT PF
Proceeds E

AL 0014339

[illegible] STANDARDS - ARMS SHEET 3

MODEL 600 MAGNUM			350 [illegible]		6.5MM Rem.Mag.			
[illegible] STOP	Located in left rear of "bolt track" in receiver. Use narrow tool to push down for release.							
[illegible] PLATE	See RECOIL PAD							
[illegible]TOR	Plunger type. Spring loaded and pin assembled in bolt head.							
[illegible]	Riveted.							
[illegible] PIN [illegible]sion [illegible]	Spring retracted in bolt. .045" Min. - [illegible] .018" Min. - [illegible]							
[illegible] Length Weight	(Overall) [illegible]		[illegible]		[illegible]			
[illegible]INE [illegible]pacity	Fixed - [illegible]		[illegible]					
[illegible]	Bright plate.							

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)	
FINAL FINISH	Black color, medium lustre on all exposed parts except as otherwise tabulated.	
PAT NUMBERS	None	

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON
BARBER - PRESALE R 0127224 R2528212
BARBER - PRESALE R 0127224

[illegible] 7-[illegible]-65
[illegible]

REMINGTON STANDARDS - ARMS

SHEET 5

MODEL 600 MAGNUM	350 Rem. Mag.	6.5MM Rem. Mag.
[illegible]CKAGING	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.	
[illegible] Shipper	Sleeve of full carton of corrugated material.	
[illegible]	Green & White, Model, Serial No., Caliber, Packers code on label.	
[illegible]ings	Name, address of addressee, with copy of shipping ticket, return address.	
[illegible] Weight:	[illegible]	
[illegible] Gun	9 lbs.	
[illegible] Guns	1[illegible] lbs.	
[illegible] Guns	2[illegible] lbs.	
[illegible] Guns	[illegible] lbs.	
[illegible]port	Same as domestic except "[illegible]" or actual weight on label.	
[illegible] TEST (REP)	Fire one (1) standard proof cartridge in each gun. For location of marking (REP) see MARKING[illegible]	
[illegible] PAD (black with white spacer)	Yes	Yes
[illegible]	Cylindrical alloy steel, black color, medium lustre. Screw fitted to barrel and barrel bracket (solid frame).	
[illegible]ghting	Drilled and tapped (5 holes) for receiver sight and telescope mount. Fitted with receiver plug screws.	
Gas Escape	One (1) hole - right side.	
[illegible]	Standard	
[illegible]	See MARKINGS - Receiver.	

741-65

REMINGTON STANDARDS · ARMS

SHEET 6

MODEL 600 MAGNUM

350 Rem. Mag.

6.5MM Rem. Mag.

TY	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.				

MODEL 600
Design

Remington Rand
CATALOG NO. 5018 R • IF FASTENERS
TO BE INCLUDED PLEASE SPECIFY.
TEX FOLDER
MADE IN U.S.A.

(1) Mr. Walk
(2) Leek's file

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,

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

WEL:T

CC: F. E. Morgan

RD-69 REV. 6-58

REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE

Remington
DUPONT

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,

Jack

JVE:a

Thelma
Please file 600 - 6.5 Mag

6.5M loads
Test

W Dahl

Bullet Wt grs	Type	Powder Charge	Type (IN
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	Spire Soft Point	53.2	4350
160	Round Nose Soft Point	51.5	4350

OK

September 19, 1966

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

Design

Dear Friend:

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. 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 speciman 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 ijicated.

Thanking you in advance, I remain

very truly yours

Phil

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

cc: G. M. Calhoun
F. E. Morgan
V. G. DeRenz
W. E. Leek
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 RKW finish.

Barrel - Increase length to 20" and Magnum weight, without vent ribs. Use M/700 style front and rear sights.

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 Redfield. 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.

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

Form 1116

2627 Glendale 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 revision and changes that I would like to see in Remington rifles.

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

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

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

1 - 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 on cartridges such as 6 MM Rem. and .350 Mag you can't seat the longer, heavier bullets out farther enough to get full potential 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 having to seat the bullet so deep.

RECEIVED
MAY 31 1966
G. G. D. ROCKWELL

Form 1116

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 MM REM 6.5 REM MAG., should come with NO sights at all, just a long sleek barrell - NO removable front or rear sight. Not drilled & tapped for remove sights. No one buys a .22-250 and uses open sights or even removable sight.

700 - I feel that Remington really fills the bill with New 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 Weatherby Chambers for it - .257 Magnum.

742 - BDL models should be offered in each caliber that this model is offered, especially the 6 MM Remington.
also the BDL model should be offered in the Carbine Version.

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

742 - All calibers that the 22" rifle is chambered for should be offered on the 18½ barrel as well, both in the 742 and 760.

Form 1116

A- Model 600 Remington - Shorten fore-end of stock by about 2 inches because of the short 18½ barrell make the stock look too ~~short~~ long? for the barrel length

Do away with the Ventilated rib completely, as it serves no practical purpose, adds unnecessary expense. People think it looks like a toy on a Buck Roger Special, of the 18, I have sold, all have removed the rib.

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

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

As the same reciever and bolt are used for the XP-100 and 600, it would be nice to offer both model in the same caliber such as .221, 222, 222 Mag or .223 Rem. The serious Varmit hunter could 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 barrelled 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 Varmit 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 laminated wood in the laminated 600.

Form 1116

	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.	Wetherby 2½-10	Redfield
3 -	Remington	Model 722	.257 REM ROBERTS	LEUPOLD 3X9	RED FIELD
4 -	Remington	Model 742	.30-06 Springfield	LEUPOLD 3X	RED FIELD
5 -	Remington	Model 760	30-06 Springfield	Weaver K2½X	RED FIELD
6 -	Remington	Model 600	6 MM Remington	Weaver K-6	RED FIELD
7 -	Remington	Model 600	.350 Rem. Mag	Redfield 2X	RED FIELD
8 -	Remington	Model 600	6.5 Rem. Mag	Redfield 3X9	RED FIELD
9 -	Remington	Model XP 100	.221 Rem. Fireball	Leupold 2X	RED FIELD
10 -	Remington	Model 550-1	.22 Cal Rim Fire	Weaver KV	RED FIELD
11 -	Remington	Model 1100	12 gauge 28" Modified w/ Ventilated Rib		
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 M. Simmons
Hitchiti Gun Service

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 solicite Operations committee's approvals as soon as provided with confirmed economics.

SMA:c

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

June 10, 1966

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

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

SMAlvis

Dear Mr. Simmons:

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.

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.

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 not efficient 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 fine 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.

May 26, 1966

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

Gentlemen:

By Air Parcel Post we are sending you one Model 700 Rifle, caliber 308 with a special device permanently affixed to the muzzle that makes this rifle comply with the minimum 19½" 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 rifles' 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

Sincerely,

Julio B. Cadenas
Assistant Manager
Export Sales Division

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

cc: W.E. Leek

Ilion, New York
April 21, 1966

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

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 Nikko 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
M. E. Leek - Ilion
E. Sparre
W. D. Vuono

M/600 Design

Bridgeport, Connecticut
March 21, 1966

TO: H. J. WATKEMAN
ILION RESEARCH DIVISION

FROM: J. B. CADEMAS

Your photographs of the Model 600 incorporating the suggested muzzle brake to increase the barrel length to 19½" were submitted to our distributors in Japan, Nikko Industrial Co., Ltd. Nikko feels that this form of increasing our barrel length to 19½" 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/rk

G-88

DON'T SAY IT—WRITE IT

To W. E. LEEK

From W. L. DAHL

Date March 21, 1966

M/600 DLS

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

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

cc. Morgan

February 23, 1966

Mr. Thomas Ridlen
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

Thelma please send a copy to Sam & W DeReuse Done 12/9

RD-69-B

REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE

Remington DUPONT PETERS DUPONT

"CONFINE YOUR LETTER TO ONE SUBJECT ONLY"

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., 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 reworked 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 till management makes their decision.

H. J. WATERMAN

HJW:GMS

cc: S. Mathews
W. H. DuBois

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 representatives 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

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 C/Inc:
Ilion. N.Y.
U.S.A.

Wayne Seek
84.2

Burns Lake
B.C.
Canada:
Jan: 15-66

Sirs;-
I am old enough to know enough to mind my own damned bussiness. 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: an further handicap by not haveing a modern clip det mag: at least optinal. 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 Nuff to know whatinhell they do want But you fellows do, an sure a ~~sop~~ scope mounted on a sawed off barrel will shoot well but it sure won't do much to tame the horrible beller of the 308 win: case in any barrel less than 22" an even in

24" barrels the very nasty sharp snappy recoil of said otherwise excellent 308 Hull has resulted in not a few 308 cal. rifles sellen Second hand even here in BC where 30-06 an even heavier calibers are common on the Husqvarna on the A.V.A. action in their featherweights in 308 most often are acused 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 that despite Scopes & I used my first one in 1917, most game is shot off hand & a slightly muzzle heavy rifle usually handles better & even then one must use a conventional mag. The Hull could be large enough that clip det. Mags could be furnished optional.

Thos Rudkin.
Burns Lake. BC.
Canada.

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

BARBER - PRESALE R 0127257

File Copy

DON'T SAY IT—WRITE IT

TO J. B. CADENAS - Bridgeport

DATE Feb. 9, 1966

FROM H. J. WATERMAN - Ilion

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.

H. J. Waterman
Ilion Research Division

HJW:T
Encl.

TO BE SAFE; FIRST THINK YOU MIGHT NOT BE

BARBER - PRESALE R 0127257
R2528245

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

BARBER - PRESALE R 0127258

G88—Rem.

DON'T SAY IT—WRITE IT

52

TO Wayne Leek

DATE 2/4/66

FROM J. B. Cadenas

Julio Cadenas

Wayne
have you been able to do anything on the model 600 to increase the barrel length to 19½" i.e muzzle brake? Please advise as soon as possible.

Thanks
Julio

P.S. Opperation Bootleg

THE MORE CHANCES YOU TAKE, THE LESS CHANCE YOU HAVE

BARBER - PRESALE R 0127258
R2528246

Harold W
Look this must be one of your old buddies. Would you answer his question? [illegible]
JK 84-2

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

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 then the rest of the front sight sighting plain. Accuracy was improved remarkebly.

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

Harold's letter
JK.W

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.

W. E. Leek
Firearms Research & Design

WEL:T
Attach.

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

BARBER - PRESALE R 0127261

G-88

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

BARBER - PRESALE R 0127261

R2528249

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

BARBER - PRESALE R 0127262

G-88

DON'T SAY IT—WRITE IT

TO _____ DATE _____

FROM _____

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

TO BE SAFE; FIRST THINK YOU MIGHT NOT BE

BARBER - PRESALE R 0127262

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

BARBER - PRESALE R 0127263

G-88

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 1/2 YEARS PAST THE DWG. CHANGE AND THOUSANDS OF STOCKS. IF MAGAZINES EXSIST IN ANY FORM SAVE MODEL DRAWING THEY SHOULD BE SCRAPPED, OR ALTERED.

H J Waterman

TO BE SAFE; FIRST THINK YOU MIGHT NOT BE

BARBER - PRESALE R 0127263
R2528251

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.

Ilion, New York
October 18, 1965

H. J. HACKMAN

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Wayne E. Leek

W. E. Leek
Firearms Research & Design

WEL:T
Attach.

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 [illegible] 84-2

AUG 25, 1965

DEAR SIRS;

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 COMFORTABLE SIGHTING.

THE ONLY ALTERNATIVE WOULD BE TO MAKE UP A SIMILIAR SIGHT AS ON THE GUN ONLY WITH CLICKS STOPS FOR BOTH ELEVATION + WINDAGE

COULD YOU HELP ME?

THIS IDEA WOULD MAKE THE GUN MORE VERSATILE.

THANK YOU.

PAUL A. WALLIMANN
Box 65
GLENVILLE, 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~~
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

O. J. Carlson

R. L. Hall, Supervisor
Methods & Standards Section

Att.
RFKerr:sm

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

RECEIVED
JAN 25 1965
G. M. CALHOUN

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. Alvis
Ilion Research Division

SMA:T
Attach.

*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.

SMA:T

TO BE SAFE; FIRST THINK YOU MIGHT NOT BE

	Old (1/100)	New
	(15279)	(15647)
	[illegible]	[illegible]
Std. mtl.	20.300/c	19.300/c
Std. Lab.	1.606	3.605/c + Taper Mill [illegible]
		(add'l [illegible] Polish operation - Rent [illegible] process in [illegible])

No add'l. work on Bbl. Assy.
(No polish after Assembly in any)

Factory Cost Comparison

	Old	New
Std. Mtl.	$20.300/c	$19.300/c
Var. (140)	2.436 "	2.316 "
Std. Labor	1.606	3.605
Var. (380)	.562	1.262
Burden (260)	4.304	9.661
Sub Total	$29.208/c	$36.144/c
Plant O.H. (24.0)	7.010 "	8.675 "
Inv. Adj. (1.0)	.362	.448
Factory Cost	$36.580/c	$45.267/c
	.37 Ea	.45 Ea
Add'l. Cost		.08 Ea. ✓

Out of pocket (cost) $.04 each. ~~[illegible]~~

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.

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

BARBER - PRESALE R 0127273

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

	Current Line		Proposed
	Model 700 ADL	Model 600	Model 600 Magnum 6.5MM Caliber
Estimated Annual Volume	(500)	(500)	5000
Retail Selling Price	$129.95	$ 99.95	$144.95
Net Selling Price	$ 70.02	$ 53.87	$ 78.10
FULL COST DATA			
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%

BARBER - PRESALE R 0127273
R2528261

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

BARBER - PRESALE R 0127274

ESTIMATED [redacted] FACTORY COST AND OPERATIVE EARNINGS OF
PROPOSED MODEL 600, CALIBER 6.5MM REMINGTON - CASH BASIS

	Total Cash Reduction in Regular Rifles by Reduced Volume	Total Cash thru Addition of 6.5MM Caliber	Cash Results
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			$169,800
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

BARBER - PRESALE R 0127274

RD-49-B

REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE

Remington DU PONT PETERS DU PONT

February 12, 1965

"CONFINE YOUR LETTER TO ONE SUBJECT ONLY" M/600 Design

TO:
F.E. Morgan

SUGGESTION M.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.

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KINZER V. REMINGTON

Evaluation

Model 600 – Regular Calibers

1. Laminated Stock
   Regular Butt Plate (Not Ruger)
   Sling Swivels (3/8 Mag Type)

2. Plus Sling Strap (" ")

3. Without Sling Strap & Swivels.

G98—Rem

DON'T SAY IT—WRITE IT

cc J. Eliot

TO: F. E. MORGAN

FROM: J. V. ELIOT, JR.

DATE 1/17/65

We are watching the reaction to the laminated stock - if it is good and we feel that it can be sold in the regular line we will add it in 1966. Pete

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 abd 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

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

BARBER - PRESALE R 0127279

ESTIMATED FACTORY COST - MODEL 600 REGULAR CALIBERS
WITH STD MAG TYPE LAMINATE STOCK, SLING SWIVELS ETC

		M/600 .308 CAL.	ADD'L COST FOR LAMINATE STOCK - FLAT-SIDED PLATE	ADD'L COST FOR SLING SWIVELS (INSTALLED)	ADD'L COST FOR SLING STRAP
		$	$	$	$
STD. MATERIAL		7.03	1.10	1.41	.62
VARIANCE	13.0	.91	.15	.16	.09
STD LABOR		6.17	.91	.07	.01
VARIANCE	30.0	2.31	.35	.03	.01
BURDEN	210.0	12.78	2.48	.19	.03
SUB-TOTAL		29.20	5.08	1.66	.57
PLANT OVERHEAD	23.0	6.64	1.17	.38	.17
INVENTORY ADJ.	1.5	.41	.06	.02	.01
FACTORY COST		41.25	6.31	2.06	1.07
			$4759	$4965	$5067

FEB 4 1965

BARBER - PRESALE R 0127279 R2528267

SMAlvis:T 2-1-65

DRAFT

OPERATIONS COMMITTEE - February Meeting

Model 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

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

mount it caused these studs to fail 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.

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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. Alvis
Ilion Research Division

SMA:T
Attach.

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

Thelma
Please file M600
35014
Ue

Wayne

FIELD TEST
SUMMARY

REQUESTED BY
F. E. MORGAN

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. Beebe-R. A. Gravell
R. M. Malcom
Wayne Leak-Ilion

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.

Rex E. Dickey
Senior Research Engineer
Bridgeport Research Division

RED:MR

cc: R. B. Bowie
J. B. Cadenas-R. Perez
G. M. Calhoun
F. E. Morgan
H. J. Hackman-V.G. DeRoux
M. H. Walker
W. E. Lock-R. F. Kelly

M600 Design

Bridgeport, Connecticut
December 2, 1964

TO: S. M. ALVIS
Ilion, New York

FROM: WILLIAM D. VUONO

Dear Sam:

This will refer to your memo of November 30.

We consider your suggestion to send a sample bolt incorporating the shroud 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 shroud 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 Kelly 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, Edwin 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 shrouded bolt. Actually, we are only concerned in Export with the Model 600 with a shrouded bolt.

Regards.

WDV:jm
cc:

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. Hackman
V.G. DeReus
A.D. Kerr
F.T. Plunkett
Estimate File #2512

Ilion, New York
October 6, 1964

H. K. FAULKNER (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, Supervisor
Methods & Standards Section

RFKerr:sm

Provided advanced lot orders in minimum of 100 are placed

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

BARBER - PRESALE R 0127290

G-88

DON'T SAY IT—WRITE IT

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. In 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

BARBER - PRESALE R 0127290
R2528278

LIMITED DISTRIBUTION

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

DESIGN STATUS

MODEL 600 - 350 MAGNUM

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 lokt 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.

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

[illegible]son - H.J. Hackman

Ilion, N[illegible]
September [illegible]

F. E. MORGAN
Bridgeport

Design

MODEL 600 - BOLT PLUG

Foreign Sales needs to change the bolts in the Model [illegible] in order to meet the safety [illegible] requirements. Quite sometime [illegible] 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.

[illegible] about this today I suggested that [illegible] Sales initiate [illegible] 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

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

BARBER - PRESALE R 0127294

C-88

DON'T SAY IT—WRITE IT

To H. J. WATERMAN

Date Aug. 21, 1964

From W. E. LEEK

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

BARBER - PRESALE R 0127294
R2528282

cc: M.H. Walker
R.B. Hurley
L.J. Boyle
G.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
Firearms Design & Development
Ilion Research Division

HJW:WEL:T

RD-49-B

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

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. LEE.

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

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

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

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

WEL:T
Attach.

RD-61-8

REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE

Remington DUPONT PETERS DUPONT

"CONFINE YOUR LETTER TO ONE SUBJECT ONLY"

Ilion, New York

MEMORANDUM September 3, 1964

TO: W. E. LEEK

FROM: H. J. WATERMAN

M/600 STOCK INLETTING

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.

H J Waterman

HJW:T

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

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

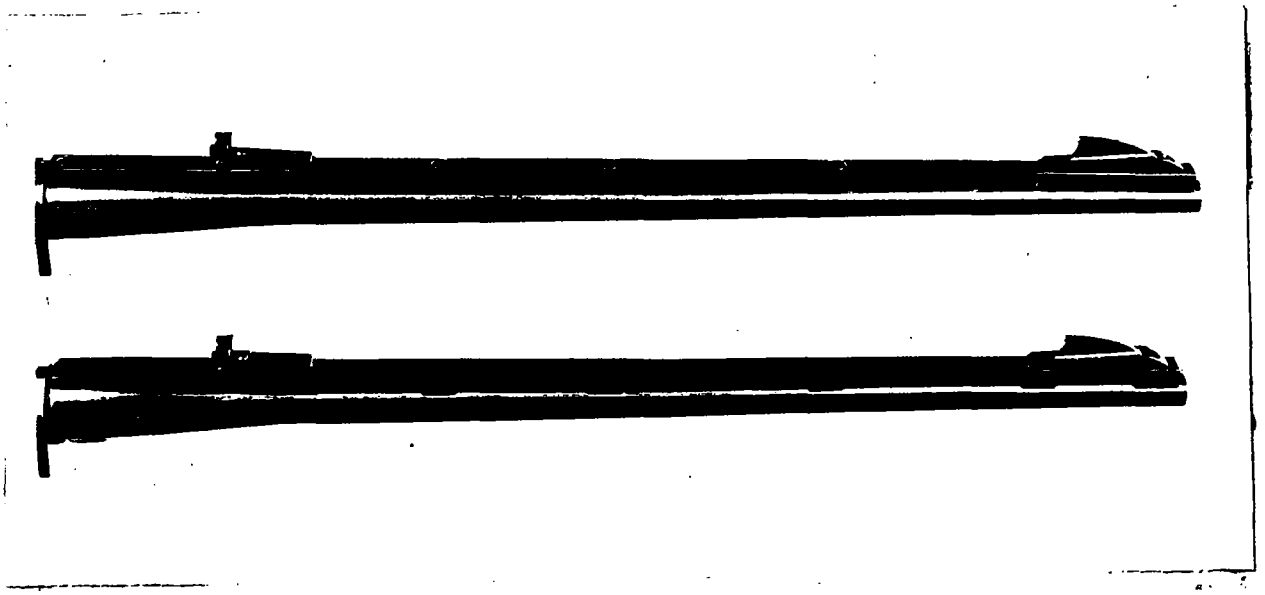


Figure 1: The Model 600 barrel rib at top has 4 attaching screws visible as compared with none in the modified barrel. The filler plugs that show in the prototype rib would not be required in a production model.

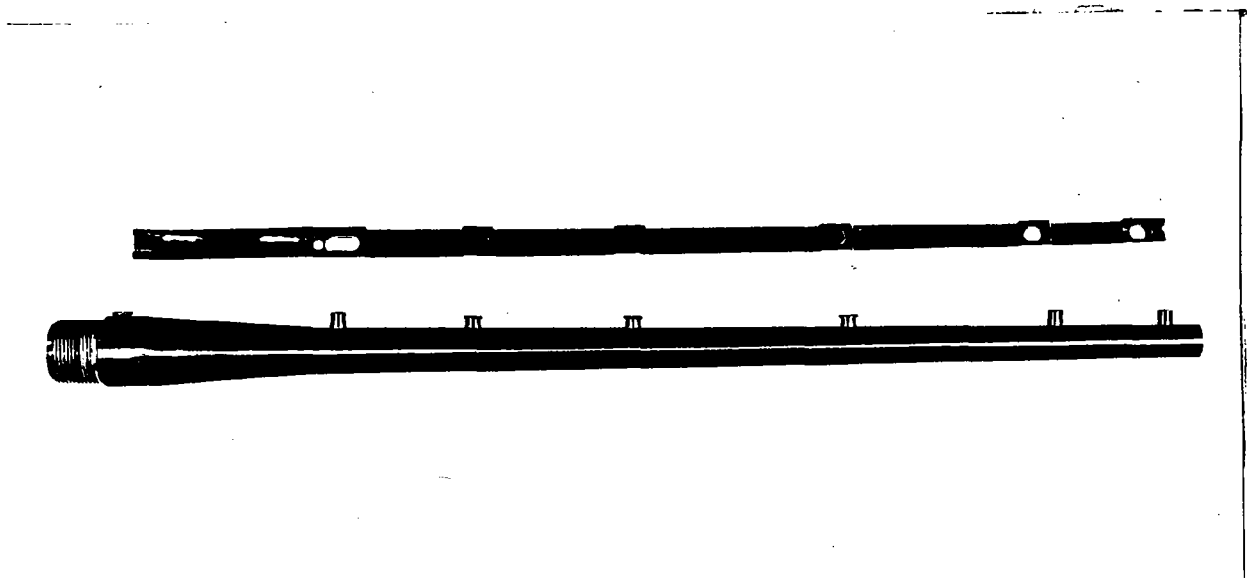


Figure 2: The countersink head screw at left enters a dovetail slot in the rib and the three headed bosses engage the T-slots when the rib slides in place from front to rear.

Jim
Pete + Sales
One of aware of this
I told them at the Sports
writers meeting me

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 di sadvantage 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

RD-69 REV. 6-58

REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE

Remington

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
Research Engineer

MWK:MR

(1)

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

Airmail Special

REMINGTON ARMS COMPANY, INC.

SPEEDMEMO

Date 12-7-63

Message To: Wayne Leek Subject various-

From: Tom Frye

Dear Wayne -

Rec'd air express tonight the 600. It will get to Les Bowman.

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 cases?

4- I know this 224 Weatherby will sell. Velocity and Belted case. Les feels the same.

5- What is your feeling on belted cases? even tho. It may not be needed.

ORIGINATOR—DO NOT WRITE BELOW THIS LINE

Reply To

From:

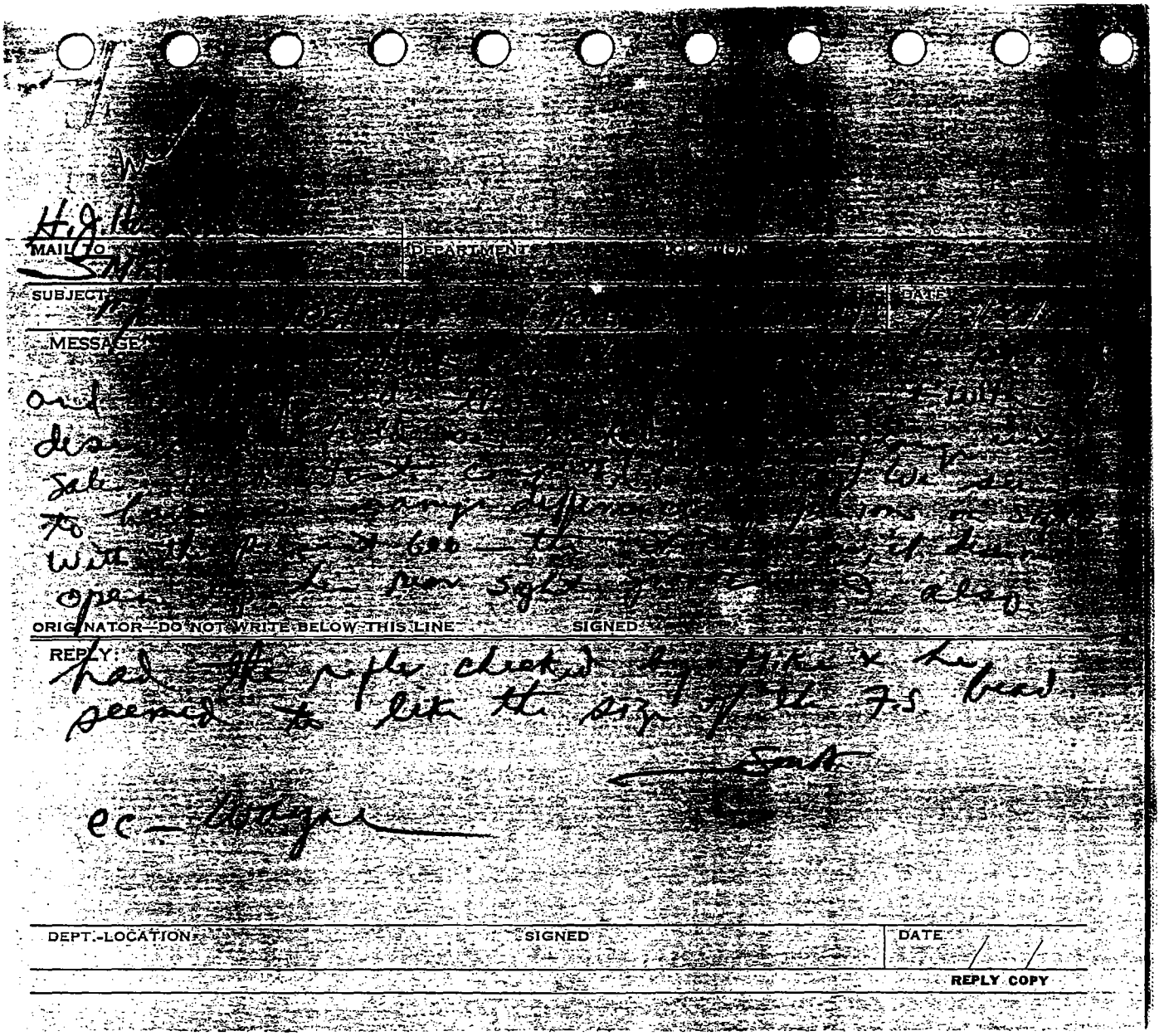
6. The 224 vel. 3900 f.s. - How about us making the 700 BDL in 24" Stainless Steel and priced retail 154.95 or such. Premium velocity - Premium Price. We will steal Weatherby's business. Not available in ADL.

7. Here are pics of 3 diff. deer. You may have a copy. M-600.

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.



MAIL TO: DEPARTMENT: LOCATION:

SUBJECT: DATE:

MESSAGE:

ORIGINATOR—DO NOT WRITE BELOW THIS LINE SIGNED:

REPLY:

DEPT.-LOCATION: SIGNED: DATE: / /

REPLY COPY

RD-49-B

REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE

Remington PETERS DUPONT

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
Firearms Design & Development

HJW:T

file

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.

Product	Bullet Weight (Gr.)	Corrected Velocity (ft/sec)	Energy	Ave. (Max.) Press. Spec. (lb/sq.in)
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

RD-49-B

REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE

Remington DUPONT PETERS DUPONT

cc: L. J. Boyle
V.G. DeReus
R.P. Kelly

"CONFINE YOUR LETTER TO ONE SUBJECT ONLY"

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.

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^{R} 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~~
R.L. St.John
J.A. Roberts

G-86

DON'T SAY IT—WRITE IT

TO D. S. FOOTE - Bridgeport DATE March 8, 1962

FROM 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
M.H. Walker - W.E. Leek
File

THERE IS A SAFE WAY; DO IT THAT WAY

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

MODEL 600
Costs & Estimates

Remington Rand
CATALOG NO. 5018 R • IF FASTENERS
ARE TO BE INCLUDED PLEASE SPECIFY.
REMTEX FOLDER
MADE IN U.S.A.

cc: R.A. Williamson
~~S.M. Alvis~~) In
W.E. Leek) turn
L. Fox) In
V.G. DeReus) 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:

	Present M/600 Rifle Anticipated 1967 Forecast	Proposed M/660 Rifle Anticipated 1967 Forecast
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:

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

F. G. Carlson, Supervisor
Methods & Standards Section

att.
FGC:sm

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

BARBER - PRESALE R 0127318

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

(308 6MM Y43 YYY 35 CALIBERS)

MAGNUMS NOT INCLUDED IN COSTS BELOW -

		BEFORE - CURRENT DESIGN				AFTER - UPGRADED VERSION							
		PRESENT 308 CAL	MAGNUM	PRESENT 308 CAL	TOTAL CASH	TOTAL CASH	UPGRADED 308 CAL	MAGNUM	UPGRADED 308 CAL	TOTAL CASH	TOTAL CASH	CASH RESULT	TOTAL CASH RESULT
		UNIT FULL BOOK	(UNIT CASH)	(UNIT CASH)	REGULAR	MAGNUM	UNIT FULL BOOK	(UNIT CASH)	(UNIT CASH)	(REGULAR)	(MAGNUM)	(REGULAR)	
VOLUME - MAGNUM (NOT INCLUDED)					(2,400)	2,400				(4,000)	4,000		1,600 Mag.
- REGULAR		#			9,600		#			16,000		6,400	6,400 Reg.
RETAIL PRICE		99.96	$144.95				119.95	$149.95					
NET SELLING		53.87	78.10	$53.87	517,100	$187,400	64.63	88.82	64.63	1,034,100	23,300	$517,000	$652,900
STD. MATERIAL		8.05	11.90	8.05	77,300	28,600	8.69	12.43	8.69	139,400	4,700	60,100	81,200
VARIANCE	.40	.40	.60	.40	3,800	1,400	.43	.62	.43	6,900	200	3,100	4,200
STD. LABOR		5.99	7.17	5.99	57,500	17,200	7.00	7.49	7.00	112,000	2,000	54,500	67,300
VARIANCE	300	1.80	2.15	1.80	17,300	5,200	1.10	2.25	1.10	33,600	1,000	16,300	20,100
BURDEN	225.0	13.48	11.69 163.9	9.76	93,700	28,000	15.75	12.21 163.9	11.41	182,600	4,800	88,900	109,700
								31,000 x 100 = 189,000					
ADD'L DEPRECIATION		—	—	—	—	—	—	—	.76	2,600	200	2,600	3,200
SUB-TOTAL		# 29.77	$33.51 100%	$26.00	249,600	$90,400	$33.87	$35.16 100%	# 29.69	$475,700	40,600	$228,500	285,700
PLANT OVERHEAD	75%	6.69	8 TEAM .78	.78	7,500	2,200	7.64	37 TEAM .91	.91	14,600	3,900	7,100	8,800
FRANCHISE TAX	40	—	1.73	1.07	10,300	4,200	—	1.77	1.35	21,500	7,100	11,200	14,100
INVENTORY ADJ.	1.0	.36	.36	.08	2,700	900	.41	.37	.32	5,100	1,500	2,400	3,000
FACTORY COST		$ 36.77	$36.53	# 28.13	270,100	$ 97,200	# 41.90	$38.27	32.77	516,300	53,100	$246,200	311,600
SELLING AND ADMIN.	10.0	5.39	—	—	—		6.46	—	—	—	—	—	
RESEARCH	4.0	1.16	—	—	—		1.59	—	—	—	—	—	
TOTAL COST		# 44.31	$36.53	# 28.13	270,100	$ 97,200	$ 60.95	$38.27	# 32.77	$516,300	53,100	$246,200	$311,600
OPER. EARNINGS		9.56			$247,000	$ 29,700	13.68			$517,800	17,200	$270,800	341,300
% OF NET SELLING		17.7%					17.1%						
LESS: 68% AND 48%					127,300	51,400				266,900	87,700	132,600	175,900
NET EARNINGS					113,700	48,300				250,900	82,500	131,230	165,400
INVESTMENT													
CONSTRUCTION												31,000	31,000
WORKING CAPITAL												308,900	314,400
TOTAL												339,900	345,400
RETURN ON INVESTMENT													47.9%
POSITION A AND B - 78,900													
POSITION C (DISCLOSE LOSS - MENT AND OPER. CHG.)													32.0%

* UPGRADING FEATURES

1- DELETE BARREL RIB AND STUD
2- 20" MAGNUM TYPE BARREL
3 M/700 TYPE FRONT AND REAR SIGHTS
4 ADD M/1100 TYPE 308 CAL AND UP
5- ADD FORE END TIP AND
6 ADD BUTT PLATE SPACER
7 REAL EDITAS EXPORT
8- RE-W FINISH

WORKING CAPITAL - RESULT			
RAW MATERIAL	31.4% x 339,900		31,900
WORK IN PROCESS	13.6% x 311,000		42,400
FINISHED GOODS	16.1% x 311,000		50,500
A/C'S. RECEIVABLE	70 DAYS x 750,300		150,100
CASH 1Y.8% x (31,100 - 3,100)			3,900
		#	314,400

339,900
- 75,000
= 418,100

345,400
778,200
923,600

REVISED 8-19-66 P. KLEE

REVISION #2 9-24-66 F. [illegible]

BARBER - PRESALE R 0127318
R2528306

DON'T SAY IT—WRITE IT

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

TO W. L. LAHL

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:

Std. Labor	$7.33
Std. Material	9.74

RLS:T

TO BE SAFE; FIRST THINK YOU MIGHT NOT BE

R'D ESTIMATES
600 MANNLICHER
R.L. SISSONE 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 700
FRONT & REAR SWIVELS
BARREL

ESTIMATES ARE BASED ON 660 & ESTIMATE
700 MANNLICHER STOCK.

RD-6514 Rev. 1

PARTS LIST

MODEL 600 MANNLICHER

Bolt Action - Center Fire Carbine

R&D ESTIMATES - R.L. SASSONE

DATE 11-4-66

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	(72.28)	(56.61)
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	104.12	60.07
B-29890	BOLT FINAL ASSEMBLY	29890	-----	-----	29891		
B-29870	BOLT ASSEMBLY	29870	-----	-----	29871	16.06	
D-26710	BOLT BODY ASSEMBLY	26710	-----	-----			
D-26780	BOLT BODY ASSEMBLY				26780	(38.5)	(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	-----	-----	-----	7.83	43.95
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)	(16.28)
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	Mainspring	15411	-----	-----	-----		
C-15412	Bolt Stop	15412	-----	-----	-----	.17	4.30
C-24475	Bolt Stop Pin	24484	-----	-----	-----		.92
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	.82
B-28510	Front Sight Ramp (Blank B-16724)	28510	-----	-----	-----	5.50	2.55
B-28505	Front Sight Ramp Screw (2)	28505	-----	-----	-----	.01	.42
C-15433	Magazine	15433	-----	-----			
C-15842	Magazine				15842	.03	14.90
C-17056	Magazine Follower	17056	-----	-----			
C-16793	Magazine Follower				16793	.60	7.57

Prepared By

Approved By

RD-6514 Rev. 1

PARTS LIST	MODEL 660 Bolt Action - Center Fire Carbine	DATE 10-25-66

Dotted line (-----) indicates same part number. Sheet 2 of 3 sheets

DWG. NO.	NAME	308 Win.	6MM Rem.	243 Win.	222 Rem.	STD LAB.	STD MAT.
B-15742	Magazine Spacer				15742	.04	3.60
C-17891	Magazine Spring	17891	-----	-----			
C-17983	Magazine Spring				17983		9.10
B-17580	Rear Guard Screw	17580	-----	-----	-----	.06	.67
C-24525	REAR SIGHT ASSEMBLY	24525	-----	-----	-----	1.81	12.57
A-16459	Rear Sight Collar	16459	-----	-----	-----		
D-16373	Rear Sight Eyepiece	16373	-----	-----	-----		
C-16374	Rear Sight Leaf	16374	-----	-----	-----		
A-16458	Rear Sight Windage Screw	16458	-----	-----	-----		
B-25310	Rear Sight Base	25313	-----	-----	-----	2.54	1.47
A-16023	Rear Sight Base Screw (2)	16023	-----	-----	-----	.03	1.12
A-16456	Rear Sight Screw	16456	-----	-----	-----	.01	.96
C-28095	Rear Sight Step (No. 5 Basic)	28095	-----	-----	-----	.04	.55
C-28095	No. 3 - 28093, No. 4 - 28094, No. 6 - 28096						
A-16968	Rear Sight Washer (2)	16968	-----	-----	-----		.14
B-17034	Receiver Plug Screw (5)	17034	-----	-----	-----		
						.05	2.49
C-26795	SAFETY ASSEMBLY	26795	-----	-----	-----	5.30	12.40
C-15430	Safety	15430	-----	-----	-----		
C-15453	Safety Thumbpiece	15453	-----	-----	-----		
A-26850	Safety Detent Ball	26850	-----	-----	-----		1.40
B-15432	Safety Detent Spring	15432	-----	-----	-----		2.69
B-17043	Safety Pivot Pin	17043	-----	-----	-----	.101	1.98
A-17044	Safety Snap Washer	17044	-----	-----	-----		.77
C-24475	Sear Pin (2)	24476	-----	-----	-----		1.40
	(Checkering D-15844)						
E-29835	STOCK ASSEMBLY (INCLUDES STOCK)	29835	-----	-----	-----	22.00	325.00
D-15741	Butt Plate	15741	-----	-----	-----	.81	3.85
C-25410	Butt Plate Screw (2)	25410	-----	-----	-----	.09	1.190
B-14390	Butt Plate Spacer	14390	-----	-----	-----	.72	.92
B-14393	Fore-End Tip	14393	-----	-----	-----	5.00	13.00
C-14391	Grip Cap	14391	-----	-----	-----	.50	.35
~~C-15899~~	~~Grip Cap Inlay~~	~~15899~~					
~~A-15757~~	~~Grip Cap Screw~~	~~15757~~					
B-14392	Grip Cap Spacer	14392	-----	-----	-----	.92	.32
B-15651	Reinforcing Screw (2)	15651	-----	-----	-----		4.99
~~A-14399~~	~~Fore-End Tip Plug (2)~~ SCREW	~~14399~~	-----	-----	-----	.08	.38
B-14394	~~Fore-End Tip Spacer~~ NUT	~~14394~~	-----	-----	-----		.30
	FRONT SWIVEL						8.50
	REAR SWIVEL						8.50

Prepared By NMR | Approved By WEL

RD-6514 Rev. I

PARTS LIST	MODEL 660 Bolt Action - Center Fire Carbine	DATE 10-25-66

Dotted line (-----) indicates same part number. Sheet 3 of 3 sheets

DWG. NO.	NAME	308 Win.	6MM Rem.	243 Win.	222 Rem.	STD. LAB.	STD MAT.
D-26730	TRIGGER ASSEMBLY	26730	-----	-----	-----		
C-15429	Housing (Blank C-15745)	15429	-----	-----	-----	12.78	14.90
C-15666	Sear Safety Cam	15666	-----	-----	-----	1.42	2.50
A-17047	Sear Spring	17047	-----	-----	-----		.77
C-15435	Trigger	15435	-----	-----	-----	5.20	.93
A-17049	Trigger Adjusting Screw (2)	17049	-----	-----	-----	.04	2.13
A-15436	Trigger Connector	15436	-----	-----	-----	.24	5.10
C-24475	Trigger Pin	24477	-----	-----	-----		.53
A-17978	Trigger Spring	17978	-----	-----	-----		1.62
B-17053	Trigger Stop Screw	17053	-----	-----	-----	.02	1.03
D-15437	Trigger Guard	15437	-----	-----	-----	6.40	2.65
	FINAL ASSEMBLY LAB.					110.00	
	PACKING MAT.						35.95
	TEST & TARGET					10.65	
	SUB TOTAL					666.32	927.78
	CONT. 5% MAT					66.66	46.39
	10% LAB.						
	GRAND TOTAL					733.22	974.17
						(735)	(974)
						36.	
						5.61	
						51.76	
						7.60	.74
						4.59	.57

Prepared By NMR | Approved By WEL

G-58

DON'T SAY IT—WRITE IT

To G. M. CALHOUN

Date June 25, 1965

From 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

cc: ~~S.M. Alvis~~ ~~W.E. Leek~~ ~~R.L. Hall~~ In turn

To V. G. DeREUS

Date 5/26/65

From 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	3,300
Total anticipated expenditures	$4,000

JAR:B

TO BE SAFE; FIRST THINK YOU MIGHT NOT BE

cc: R.A. Williamson
S.M. Alexander
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

F. G. Carlson

Att.
FGC:sm

RD 6565

ESTIMATED SAVINGS & RETURN ON INVESTMENT

REPLACE FORMED M/600 & 700 MAGAZINE FOLLOWERS WITH POWDER METAL PARTS

1965 Year of Operation

	Present Purchased Stampings	Proposed Powder Metal Process		
Quantity Forecast	67535			
OPERATING COSTS				
Purchased parts	$ 5,140	$ 7,775	$	$
Raw material				
Direct Labor	390	435		
Labor Var.	65	80		
Industrial Relations @ 36%	165	205		
Supplies				
Tool Replacement				
Cutter Grind EXPENSE	325	520		
Tool Maintenance				
Maintenance				
Electricity	—	—		
Equipment Depreciation @	—	—		
Franchise Tax @ 4%	—	—		
	$ 6,085	$ 9,065	$	$

SAVINGS IN OPERATING COST — COST INCREASE ($2,980)

Less: All other expense:
All Other 6.9%; Federal Tax 4.8%

NET SAVINGS $ $

INVESTMENT

Project expenditures	$	$
Manufacturing and working facilities		
Net Change in working capital		
Total capital required for this project	$	$

RETURN ON INVESTMENT - THIS PROJECT

R&D [illegible] & Trial Run - $2,3[illegible]

* * * * * * * * * * * * * *

Powder Metal Tooling - $5,2[illegible]

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)

[illegible]
3-2[illegible]

cc: D.E. Miller (2)
H.J. Hackman
S.M. [illegible]
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

ESTIMATED FACTORY COSTS AND ECONOMICS FOR PROPOSED
M/XP-100 PISTOL AND M/600 RIFLE - REVISED TO INCLUDE 30-30
AND 222 RIFLE CALS. - BASED ON M/1100 PROJECT (PART III REV.) BURDEN AND O.H. RA

		XP-100	MODEL 600 308	MODEL 600 222	MODEL 600 30-30	TOTAL
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	807,210
STD. MAT'L		5.55	7.86	7.86	8.54	138,630
VAR	1.5	.08	.12	.12	.13	2,100
VENDOR TOOL	1.0	.06	.08	.08	.09	1,440
STD. LABOR		4.71	5.08	5.08	5.43	92,430
VAR	40.0	1.86	2.03	2.03	2.17	36,870
WAGE ADJ.						
DIRECT EXPENSE	115.0	5.18	5.84	5.84	6.24	105,540
IND. RELATIONS	35.0	2.30	2.49	2.49	2.66	45,270
GAS-POWER	6.6	.31	.34	.34	.36	6,150
DEPRECIATION	23.1	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	100 → .81	13,410
OTHER DIRECT	2.0	.09	.10	.10	.11	1,830
MFG. OVERHEAD	33.9	1.60	1.72	1.72	1.84	31,320
WAREHOUSE	8.6	.41	.44	.44	.47	8,010
SUB-TOTAL		$25.28	$29.58	$29.58	$31.77	$532,680
PLANT OVERHEAD	24.0	6.07	7.10	7.10	7.62	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	.43	42,450
% OF NET SELL.		9.4%	6.9%	6.9%	.9%	5.3%
LESS: 6% + 52%						
NET EARNINGS						
PROJECT INVESTMENT						
WORKING CAPITAL						
TOTAL CAPITAL AND INVESTMENT						
RETURN ON INVESTMENT (POS. A + B)						(659,860 + 553,500 = 1,213
" " (POS. C)						

AND ECONOMICS FOR PROPOSED
1600 RIFLE - REVISED TO INCLUDE 30-30
- BASED ON M/1100 PROJECT (PART III REV.) BURDEN AND O.H RATES FOR 1965

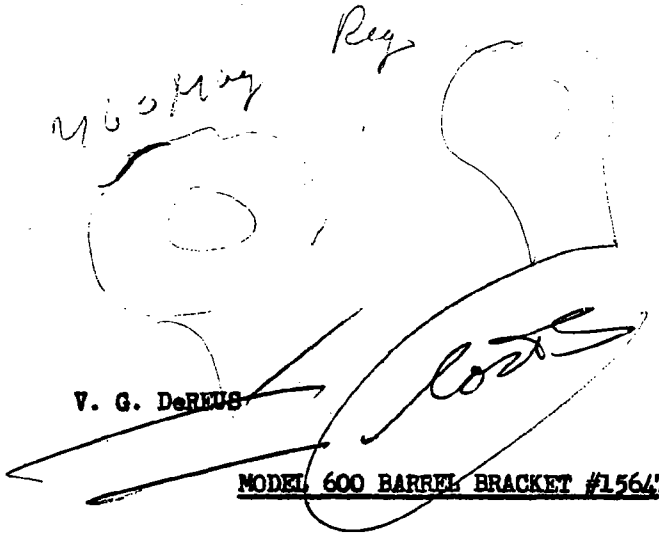
R. KERR - ILION
1-4-63

XP-100	MODEL 600 308	MODEL 600 222	MODEL 600 30-30	TOTAL	CASH RESULT
3,000	5,000	4,000	6,000	18,000	18,000
75.00	$85.00	$85.00	$85.00	$1,500,000	$
10.37	45.74	45.74	45.74	807,210	807,210
5.55	7.86	7.86	8.54	138,630	138,630
.08	.12	.12	.13	2,100	2,100
.06	.08	.08	.09	1,440	1,440
4.71	5.08	5.08	5.43	92,430	92,430
1.86	2.03	2.03	2.17	36,870	36,870
5.18	5.84	5.84	6.24	105,540	105,540
2.30	2.49	2.49	2.66	45,270	45,270
.31	.34	.34	.36	6,150	6,150
1.09	1.17	1.17	1.25	21,300	11,940
.35	.38	.38	.41	6,930	—
.68	.73	.73	.78	13,290	—
.41	.45	.45	.48	8,160	* 4,130
.60	.75	.75	107 .81	13,410	13,410
.09	.10	.10	.11	1,830	1,830
1.60	1.72	1.72	1.84	31,320	5,170
.41	.44	.44	.47	8,010	990
5.28	$29.58	$29.58	$31.77	$532,680	$465,900
5.07	7.10	7.10	7.62	127,830	9,570
					13,170
.16	.18	.18	.20	3,300	2,440
.51	$36.86	$36.86	$39.59	$663,810	491,080
.84	4.35	4.35	4.35	76,770	—
.21	1.37	1.37	1.37	24,180	—
.56	$42.58	$42.58	$45.31	$764,760	491,080
.81	3.16	3.16	.43	42,450	316,130
9.4%	6.9%	6.9%	.9%	5.3%	
					173,490
					142,640
					183,700
					476,160
					659,860
					21.6%
				(659,860 + 553,500 = 1,213,360)	11.8%

WORKING CAPITAL

MATERIAL	$142,170	X 37.4%	=	$53,170
WK. IN PROCESS	488,640	X 20.9%	=	102,130
FINISHED GOODS	491,080	X 24.3%	=	119,330
A/C'S RECEIVABLE	928,290	X 15.0%	=	139,240
CASH	479,140	X 13.0%	=	62,290
				476,160

* 1,000 ADDED TO PROTECT ENG. (3130) FOR 30-30 CAL.



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

October 16, 1964

V. G. DeREUS

MODEL 600 BARREL BRACKET #15647

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	2.51	4.50
Total Out-of-Pocket Cost	$ 24.42/C	$ 27.02/C
Burden	8.36	10.60
Total Factory Cost	$ 32.78/C	$ 37.62/C

R. L. Hall, Supervisor
Methods & Standards Section

F. G. Carlson

FGCarlson:sm

September 29, 1964

Cost

V. G. DeREUS

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

Att.
RFK:mm

cc: R. A. Williamson
S.M. Alvis
W.E. Leek
Estimate File #2508

M600 / M

R.L. Hall
V. DeReus

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

	Costs /c. Add. Rec'r Support	Increase Lg'th of Rec's
Material.		
Fiberfill (.68 @ $2.67/lb)*	1.78	
Steel		1.99
Standard Labor	.77	
" Var.	.21	
Total Labor	.98	
Ind Bel @ 33	.32	
Direct Expense	.23	
Estimated out of pocket cost	$3.31	1.99
" " " " /gun	$.033	$.020
" savings /gun		$.013

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

CWW.
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

W. E. Leek

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

RFKerr:sm

John Roberts
File
Please see me on this
M

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 M

M/600

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:

	Stock with F.E. Tip and Spacer	Stock without F.E. Tip and Spacer
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

15

1.30
Scrap RAW

Stock - [illegible]
Fore end tip - [illegible]
" " " Spacer - RAW.
Butt Plate - [illegible]

8½ x 11 — 6 columns
With description column

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

		EST. COST PER 100 WITH F.E. TIP	EST. COST PER 100 WITHOUT F.E. TIP
MATERIAL - STD		168.114	150.000
- VAR	(3%)	5.043	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%)	42.596	40.231
ALLOC BURDEN		45.703	43.166
DIRECT CHARGES	(33.3% STD LABOR)	29.158	27.537
MFG. OVERHEAD	(31.2% STD LABOR)	27.319	25.801
SUB-TOTAL		558.529	512.028
PLANT OVERHEAD	(22.1%)	123.435	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 (MOLDS)		1400	—

R.KERR 3/14/62

cc: D.E. Miller
L.D. Cox
~~S.M. Hyde~~
~~W.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 WELeek dated 3-13-62

Wayne looks like the cheapest way

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

RFKerr:sm

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

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:

	Stock with F.E. Tip and Spacer	Stock without F.E. Tip and Spacer
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

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KINZER V. REMINGTON

8½ x 11 — 6 columns
With description column

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%)	5.043	4.500
TOTAL MAT'L		$ 173.157	$ 154.500
LABOR - STD.		87.561	81.694
- VAR		34.143	33.251
TOTAL LABOR		$ 121.704	$ 114.945
DIRECT EXPENSE	(ACT.)	118.894	105.848
IND. RELATIONS	(35%)	42.596	40.231
ALLOC. BURDEN		45.703	43.166
DIRECT CHARGES	(33.3% STD. LABOR)	29.158	27.537
MFG. OVERHEAD	(31.2% STD. LABOR)	27.319	25.801
SUB-TOTAL		$ 558.529	$ 512.028
PLANT OVERHEAD	(22.1%)	123.436	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		$ 600	—
VENDOR (MOLDS)		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		$ .36
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	24.0	1.14
INVENTORY ADJ	1.0	.06
FACTORY COST		$ 5.94

EST. ADD'L. FACTORY COST PER GUN ..... $ .06

" " " " YEAR - #4 FORECAST ..... $ 1450

ENGINEERING AND TOOLING ..... $ 7700

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

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

FGC:sm

S. M. Alvis R.L. Hall
WE Leek RP Kelly

P. E. & C. ESTIMATE

TO: H. J. Hackman

ESTIMATED BY: P.E. Crook - [illegible]

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

ENGINEERING DUPONT COMPUTATION SHEET

SHEET NO.

TITLE OF PROJ. OR STUDY [illegible] PROJ. OR STUDY NO.

SUBJECT [illegible] CHANGE (BOLT PLUG) WORKS

COMPUTER [illegible] DATE 9-23-64 19

PRESENT VENDOR'S PC/PR $130.44/M

EST. VENDOR'S PC/PR (PROPOSED) 133.94/M

EST. VENDOR'S TOOL COST $50.00

INCREASE IN VENDOR'S PC/PR $3.50/M

	DES. HR	BLD. HR
PURCHASE INSPECT		
COMP. SCREEN	6	
OP# 15 - MILL FIRING PIN HEAD SLOT FLATS ON BOTTOM & SAFETY CLEARANCE.		
FIXTURE (ALTER) D-54573	4	10
POSITION GA. (ALTER) C-51002	[illegible]	20
OP# 20 FINISH C BORE FIRING PIN HEAD CLEAR.		
DRILL JIG (NEW)	[illegible]	50

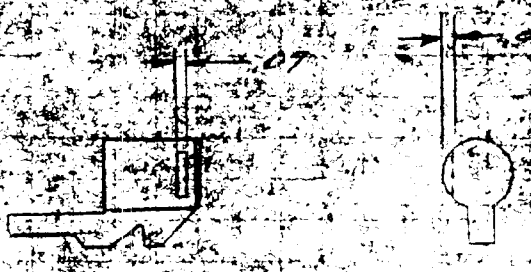
ENGINEERING COMPUTATION SHEET

[illegible] FIRING PIN HEAD

[illegible] (BOLT PLUG)

COMPUTER [illegible] DATE [illegible]

ALTERATION TO FIRING PIN HEAD

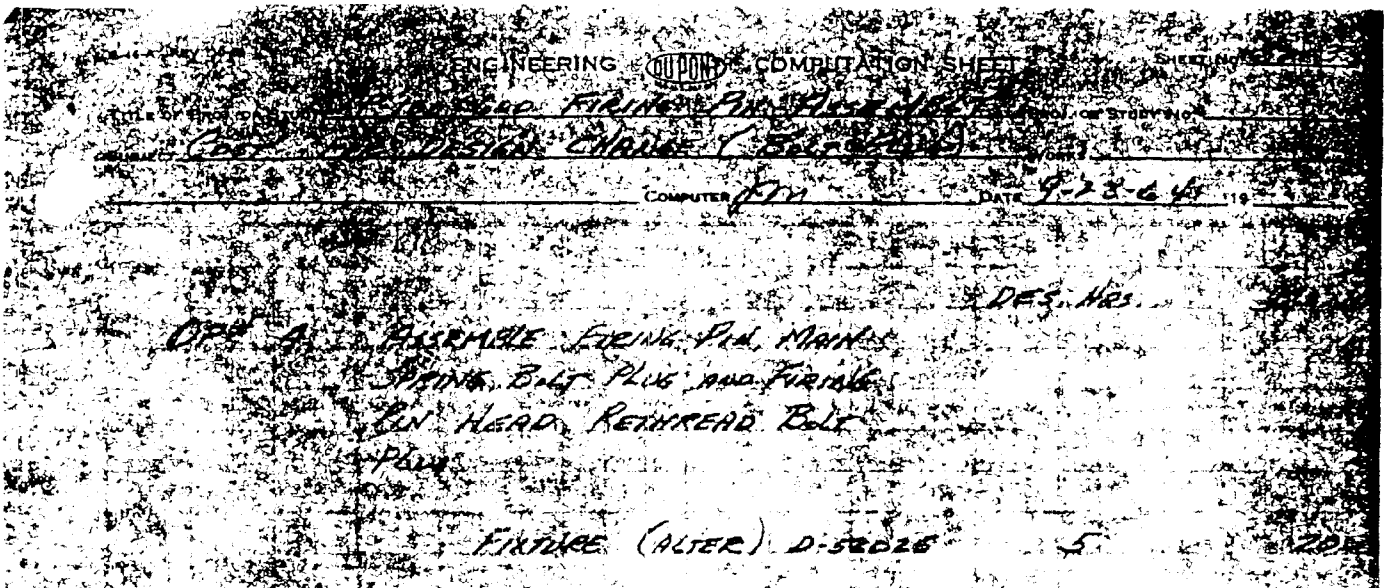


DES. HRS. BLD. H

OP 12 - MILL SLOT FOR COCKING SPACER

(HAND MILL)

FIXTURE	.5	.75
TEMPLATE (POSITION)	9	15
PLUG GA. (DEPTH)	3	10



ENGINEERING DUPONT COMPUTATION SHEET

TITLE OF PROJ. OR STUDY: [illegible] FIRING PIN ASSEMBLY

PROJ. OR STUDY NO.

SUBJECT: COST FOR DESIGN CHANGE (BOLT PLUG)

WORK

COMPUTER JM DATE 9-23-64 19

DES. HRS.

OP# A. ASSEMBLE FIRING PIN, MAIN SPRING, BOLT PLUG AND FIRING PIN HEAD, RETHREAD BOLT PLUG

FIXTURE (ALTER) D-52026 5 20

W. E. Leek
R P Kelly
R. B Hurley
SMALL
RL Hall

B.C. ESTIMATE

TO: H. J. Hackman

ESTIMATED BY: P.O. Croop - V.G. Ile Reng

MODEL 600 PROJECT NO. DATE 4/13/64

PROJECT TITLE Estimate to use model 700 type Front and Rear Sight on model 600 Rfle in place of present Rib and sights

	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. & C. ESTIMATE

R L Hall
R B Kelly
DE Leek

TO: H. J. Hackman

ESTIMATED BY: RB Hurley - [illegible]

MODEL 600 - Cost Est

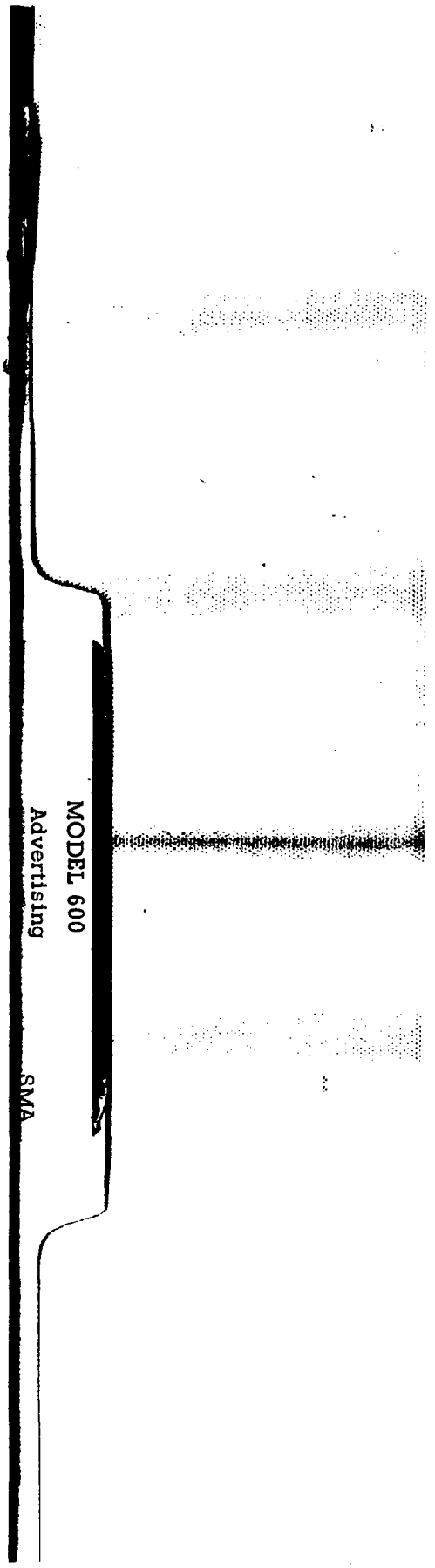
PROJECT NO.

DATE 10/25/63

PROJECT TITLE Estimate to increase lenght of tang on M/600 Receiver to eliminate extra operation on stock and nylon Receiver Support

	HOURS	RATE Stock	TOTAL Receiver
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


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".

S. M. Alvis
Ilion Research Division

SMA:T

RD-69 REV. 6-58

REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE

Remington DUPONT

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.

G-38

DON'T SAY IT—WRITE IT

TO _____ DATE _____

FROM _____

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

M/660, 742+760 - "liquid bone" - term devised by advertising, discussed possible patent infringement, related present Almco term (VIBRASHEEN) (R) - he will follow up with legal dept.

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

M/660 - Bolt handle - discussed plus feature of "no banged up fingers" with forward sweep.

M/742-760 - Bolt locking - "bank vault" - claims have used before

TO BE SAFE; FIRST THINK YOU MIGHT NOT BE

m/600 adv

MINE!" 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.

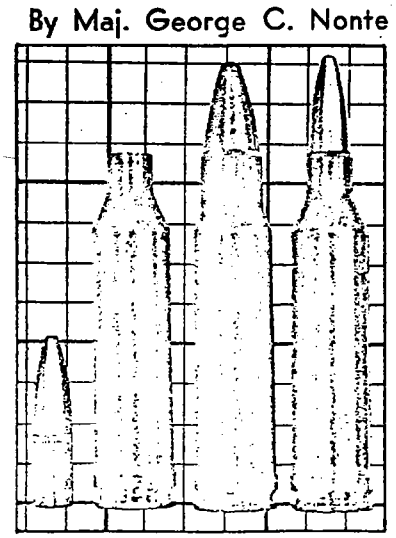
The new 6.5mm Magnum from Bridgeport is a most interesting little cartridge. It utilizes the reliable old Holland and Holland belted case shortened to just a hair over two inches, with a very short neck, steep shoulder, and minimum body taper. Like most other lately-introduced calibers, the case is already 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)

By Maj. George C. Nonte



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

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

BARBER - PRESALE R 0127353

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 easily and indicated a smoothly-cut chamber.

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

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 1¾", 2⅛" and 1⅜" 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 1⅛". 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 ½ 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)

Dec 66

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON
BARBER - PRESALE R 0127353
R2528341

G-88

File

DON'T SAY IT—WRITE IT

F. E. MORGAN

TO E. S. McCAWLEY

FROM W. E. LEEK WEL

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

sm/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
3433 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 M8-2X 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 rockes, and rained on for three weeks. Don said that she fired three shots at 150 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 don'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

PB:CPB

BARBER - PRESALE R 0127356

REMINGTON'S NEWEST IS A POWERFUL PACKAGE FOR BIG GAME

By R. A. STEINDLER

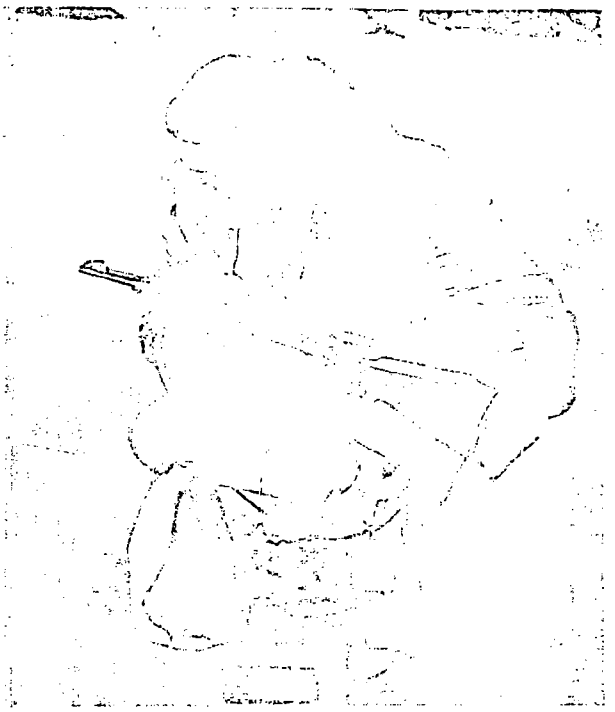
REMINGTON'S .350 MAGNUM!

IF 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!

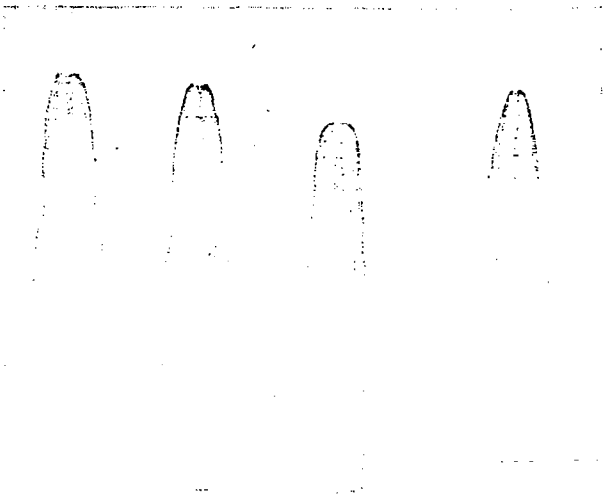
Just a little over a year ago Remington popped the Model 600 on the public. Gun writers, guides, and shooters immediately took sides, and opinions about the gun were about evenly divided. Let's recap the gun: It has an 18½ inch barrel, a dog-leg bolt that comes from the XP-100 which probably derived 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 .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



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



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

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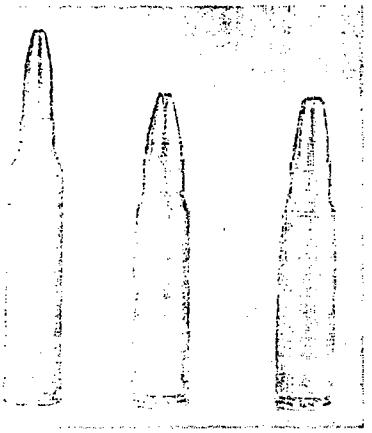
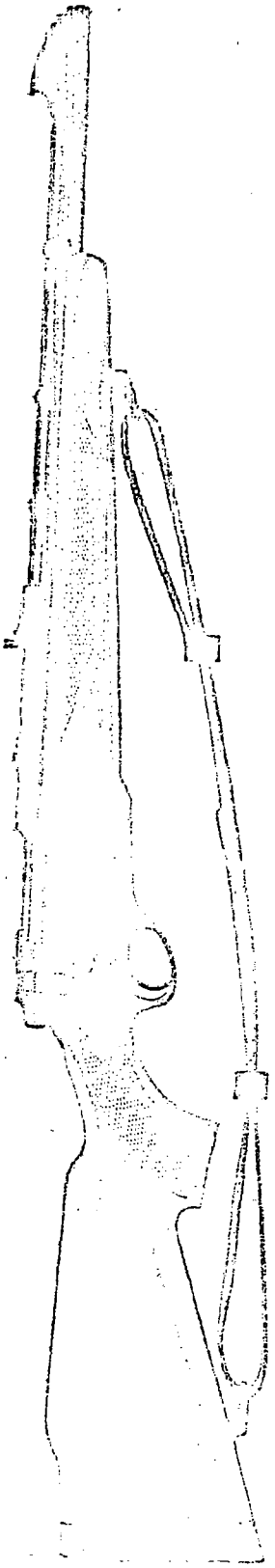
Above: Ice-filled plastic bottle shatters as it is hit by the 200 grain Core-Lokt Remington bullet.



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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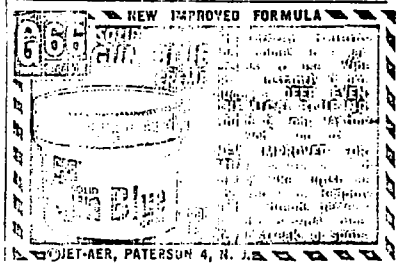

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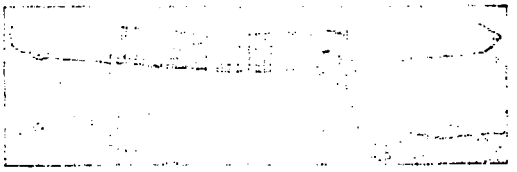

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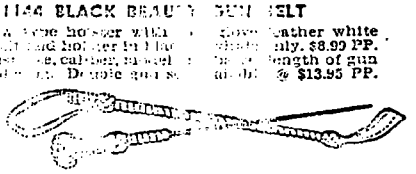

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P. O. DRAWER 1712

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. 250 gr.		2725* 2410*	1-16	Remington

*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 2.164 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.

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R2528346

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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, 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 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 relatively 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.

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

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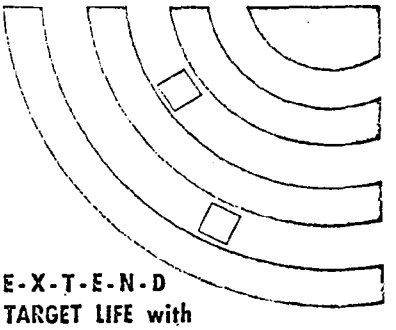

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c.c. S.M. Alvis
E.S. MCCawley

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 - $[illegible].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:e
Enc. 4

J.F. Finnegan
Ilion Research Division

PETERS CARTRIDGE DIVISION

REMINGTON ARMS COMPANY, INC.

Manufacturers of Sporting Ammunition

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July 21, 1955

7-21-55 Advertising

TO REMINGTON FIREARMS AND PETERS AMMUNITION WHOLESALERS

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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 varminter 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

Index No.	Weight Bullet Grs.	Weight Case* Lbs.	List per 1000	Wholesale Prices Per Thousand Zone 1	Zone 2	Zone 3	Zone 4	Zone 5	Retail Box of 20
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.

Dewey Godfrey

Vice President and
Director of Sales

Dewey Godfrey:M/bmh
Attach.

*Quantity - 1,000 per case.

MODEL 722 - 244 REMINGTON CALIBER

PRICES

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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

Index No.	Bullet Wgt.	Style	Muzzle	100 yd	200 yd	300 yd	400 yd	500 yd
			VELOCITY - Feet per Second					
2441	75	Pointed Soft Point	3500	3070	2660	2290	1960	1670
2442	90	Pointed Soft Point	3200	2850	2530	2230	1960	1710
			ENERGY - Foot Pounds					
2441	75	Pointed Soft Point	2040	1570	1180	875	640	465
2442	90	Pointed Soft Point	2050	1630	1280	995	765	584
			MID-RANGE TRAJECTORY - Inches					
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

G-86-REM

DON'T SAY IT—WRITE IT

TO R. J. Garrity DATE 11-19-52

FROM S. N. Alvis

John Finnegan just called attention to the fact that the new Stoeger'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.

SNA:LJ

S. N. Alvis
Arms Research & Development Division

CC: J. F. Finnegan-File

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G-58-REM

DON'T SAY IT—WRITE IT

TO S.M.A. DATE 11-17-52

FROM J. Finnegan

Stoeger Catalog

Page 82

error - w/11-48 28ga has a .25" barrel

Vent Rib. - instead of 28" as listed

ARE YOU DOING YOUR SHARE IN SAFETY?

RD-69-E

REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE

Remington UMC PETERS UMC

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 DUPONT

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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

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.

Range in Yds.	Velocity Ft. Sec.	Energy Ft. Lbs.	Mid-Range Trajectory Inches
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.

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 MAGAZNE 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.

G. E. Hinckley

GEP:RHL

Manager, Products Sales Division

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

[redacted]
R.A.Brown-File

Ilion, 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 [redacted] magazine includes an article by Lucian Cary 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 Magnum 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 FIELD & STREAM, 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

SMA:LJ

G-66

DON'T SAY IT—WRITE IT

TO J. D. Mitchell DATE 6-13-49

FROM 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.Foote

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

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

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 Trapshooting World Series; The North American Professional Clay Target Championship. And another unique record: Tom shot over 100,000 2½" 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 000" 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 Ilion, 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 Ilion, 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 Du Pont "ZYTEL"® nylon.

Remington Peters
REMINGTON ARMS COMPANY, INC., BRIDGEPORT, CONNECTICUT 06602
Printed in U.S.A.

Remington ARMS DEALER
Peters AMMO
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 1¼" 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.

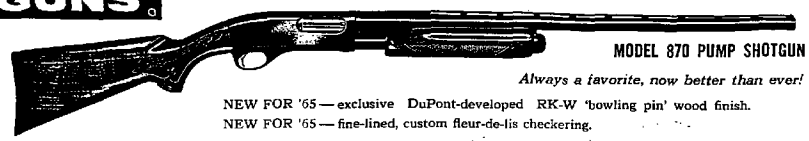
SPECIFICATIONS • REMINGTON MODEL 600 MAGNUM

CALIBER	350 Remington Magnum
ACTION	Bolt, Repeating
CAPACITY	4 shot
MAGNUM BARREL	Tapered, Remington proof steel 18½" with ventilated rib matted between sights.
LENGTH	37¾" 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, 1⅞" 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	6½ lbs.
ORDER NO.	5724

BARBER - PRESALE R 0127376
BARBER - PRESALE R 0127376
R2528364

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

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-shucking 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 varminter market, both ADL and BDL models are available in the hot new 22-250 Remington 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 varminter — 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.

NOW IN 5 FAVORITE 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.

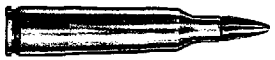
Here's the news dealers and hunters have been waiting for: High base plastic shells now have the "Power Piston" which is actually a combination wad column and shot container. Proved in 2 years of record-shattering performance in the toughest trap and skeet competition, "Power Piston" now gives field 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!

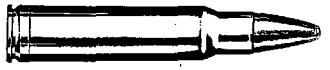
This is the new hot one for varmint shooters; — it's chambered in Remington Model 700 rifle. It fires a 55 grain Pointed Soft Point bullet at 3760 feet per second muzzle velocity. It travels flat and fast . . . and is a big favorite with handloaders.

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.
350 REMINGTON MAGNUM 200 Gr., P.S.P. Core-Lokt Bullet			
0	2725	3290	—
100	2355	2465	+ 2.7
200	2025	1820	0
300	1730	1325	— 11.2
350 REMINGTON MAGNUM 250 Gr., P.S.P. Core-Lokt Bullet			
0	2410	3220	—
100	2135	2535	+ 3.4
200	1885	1975	0
300	1660	1530	— 13.2

This is unmatchable 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 sense" 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.

BARBER - PRESALE R 012737
R2528365

Remington DUPONT

REMINGTON ARMS COMPANY, INC.

PETERS DUPONT

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

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,

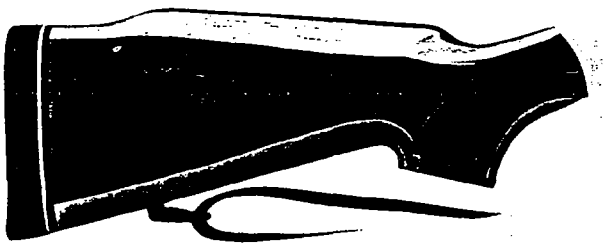
S. R. Hutchinson

SRHutchinson/ecc
Attch.

Manager
Advertising - Firearms

REMINGTON & PETERS BALLISTICS (in an 18½" barrel)

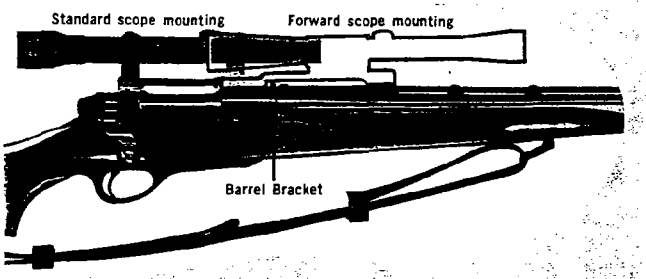
Range (Yds.)	Velocity (f.p.s.)	Energy (ft. lbs.)	Trajectory (inches) sighted in at 200 yds.	
0	2725	3290	—	350 REMINGTON MAGNUM 200 Gr., P.S.P.™ Core-Lokt™ Bullet
100	2355	2465	+ 2.7	
200	2025	1820	0	
300	1730	1325	— 11.2	
0	2410	3220	—	350 REMINGTON MAGNUM 250 Gr., P.S.P.™ Core-Lokt™ Bullet
100	2135	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.

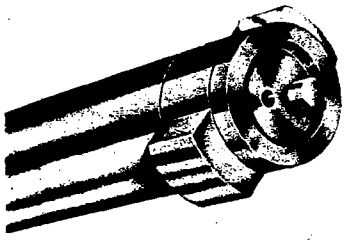


ROTATING THUMB SAFETY is conveniently located at the rear of the receiver where you can get at it in a hurry. Rearward for "Safe." Forward for "Fire."

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.

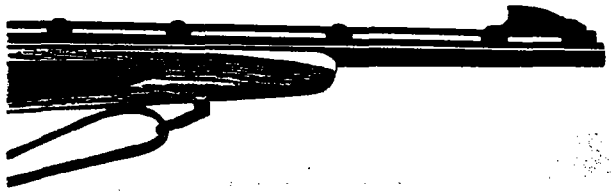


WORLD'S STRONGEST BOLT — Cartridge head is completely encased by a ring of solid steel. When the bolt is closed, three rings of steel support the cartridge head. Strong? . . . there's none stronger.

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.



- **FAST-HANDLING MODEL** — Short over-all length (37¼") makes Model 600 Mag. just right for hunting in heavy brush country because you can handle it faster, easier . . . get on that bouncing buck and drop him. It's a great saddle gun, too — fits a scabbard neatly or tucks in the rack of a pick-up truck.
- **PERFECT BALANCE AND WEIGHT** — Just 6½ well-balanced pounds but packs plenty of power. In the new 350 Rem. Mag. caliber, it will knock down and out any North American big game.
- **FINEST ACCURACY** — Here's where Model 600 Mag. really shines. Free floating barrel of Remington proof steel is precision rifled to exact standards, by Remington's special methods. Trigger pull is short, crisp and clean. We field tested it extensively under various conditions and on different types of game. At the factory and in the field we shot close groups — and so will you. It was designed to shoot this way.
- STRAP AND QUICK-RELEASE SLING SWIVELS are standard equipment on the Model 600 Magnum.

[illegible]	[illegible]
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Remington, DUPONT

REMINGTON ARMS COMPANY, INC., BRIDGEPORT, CONNECTICUT 06602

IN CANADA: Remington Arms of Canada Limited,
36 Queen Elizabeth Blvd., Toronto 18, Ontario

Form No. AA-31 Printed in U.S.A.

Remington DUPONT

REMINGTON ARMS COMPANY, INC.

PETERS DUPONT

MANUFACTURERS OF
SPORTING FIREARMS. AMMUNITION
TRAPS TARGETS
POWER TOOLS

BRIDGEPORT, CONNECTICUT 06602

SPORTING FIREARMS
ILION, N. Y.
AMMUNITION, BRIDGEPORT, CONN.
POWER TOOLS, PARK FOREST, ILL.

PETERS CARTRIDGE DIVISION
BRIDGEPORT, CONN.
TRAPS AND TARGETS, FINDLAY, OHIO
CABLE – HARTLEY, BRIDGEPORT

December 30, 1964

REMINGTON OFFERS FOR '65...

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

	Net to Wholesalers Less Tax	Net to Wholesalers Tax Included	Dealer	Retail
Model 600 - 350 Remington Magnum Ordering Number 5724	$80.83	$89.72	$108.75	$144.95

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.

ADVERTISING MATERIAL

Catalog pages and/or electrotypes in sizes 2-5/8" and 3-1/4" are available on request.

Increase your sales...and your profits...by sending us your orders promptly for this new MODEL 600 - 350 REMINGTON MAGNUM CARBINE.

Sincerely,

J E Dickey

Director of Sales
Arms, Ammunition, Traps & Targets

JEDickey/mgm

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

Remington DUPONT

REMINGTON ARMS COMPANY, INC.

PETERS DUPONT

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.

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

	Net to Wholesalers			
	Less Tax	Tax Included	Dealer	Retail
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,

J E Dickey

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.

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 6 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

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

DATE May 30, 1964 19

Dear Mr. Leek:

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, preferrably 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 ammmunition 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 @ 3ft 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

			(ave of 2)
Shoulder Force	M600;	5½ lb gun	585 lb
	M700;	6¼ lb gun	415 lb

GUN WEIGHTS - MODEL 600 10/4/63

	308 Win.	222 Rem.	35 Rem.
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. McCawley
Remington Arms
Bridgeport 2, Conn.

FROM

RECEIVED
MAY 2
E. S. McCAWLEY, Jr.

SUBJECT: Remington 600

Dear Ted:

DATE: May 19

Surprise and all that. POPULAR SCIENCE wants me to do a [illegible] engineering type story on your lightweight.

What is an [illegible] type story? Well, it's how y'[illegible] a pound or so and still [illegible] accurate firearm.

I plan to [illegible] design, nylon [illegible] trigger [illegible] designed for light weight and barrel length and taper. But I have [illegible]

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 [illegible] a quater-pound more than I figure [illegible] 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 [signature]

Can do? Soon? Regards...

WILSON JONES COMPANY © 1961 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.

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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.

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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,

Wayne E. Leek

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

WEL:T

cc: E.S. McCawley

Ilion, New York
April 6, 1964

F. E. MORGAN
Bridgeport

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.

W. E. Leek
Firearms Design Section
Ilion Research Division

WEL:T

ROUTE:

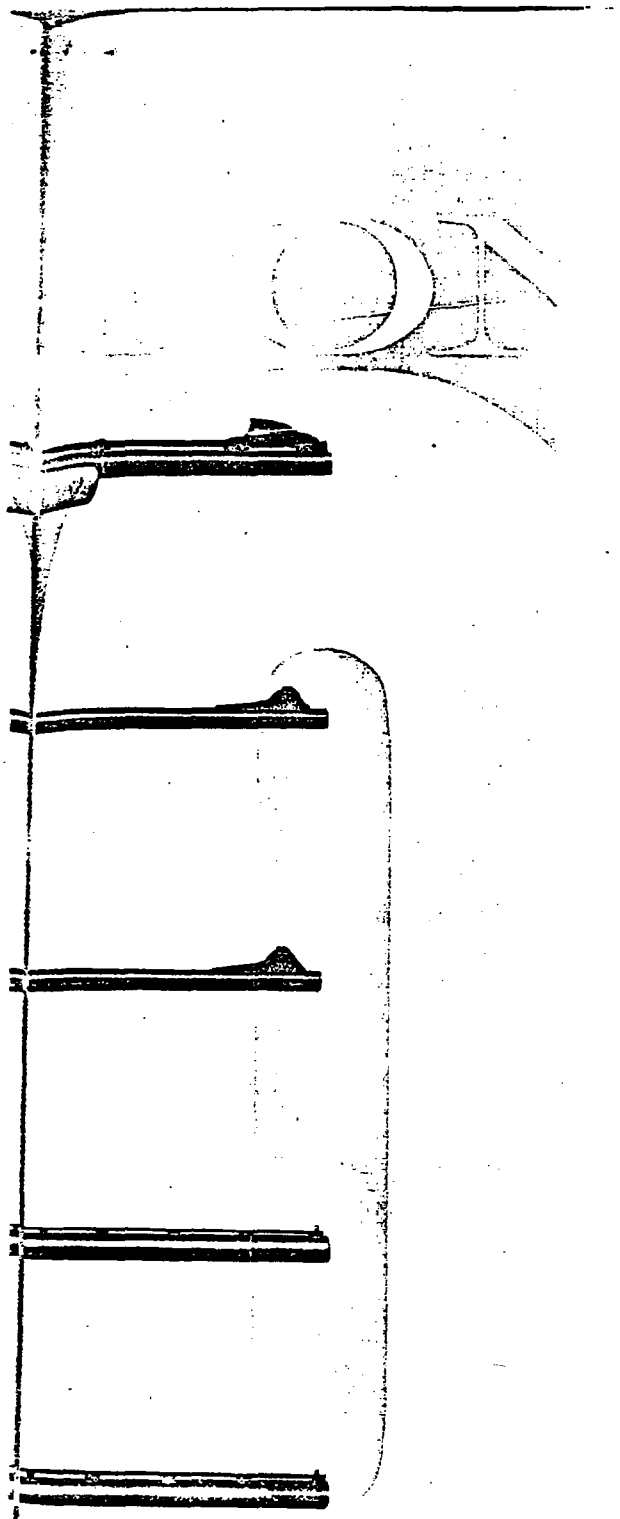
~~D. L. Sullis~~
~~W. L. Dahl~~
~~G. J. Ennis~~
~~J. F. Finnegan~~
~~E. Gessart~~
~~R. P. Kelly~~
~~P. Nasypany~~
~~C. H. Masso~~
~~J. S. Martin~~
~~N. M. Reed~~
~~H. J. Waterman~~

~~G. B. Workman~~
~~R. Nightingale~~
~~A. Hugick~~

~~W. R. Goegin~~
~~C. H. Zoller~~
~~J. J. Bechard~~
~~D. J. Urtz~~

~~P. H. Eccleston~~
~~A. J. Long~~
~~R. Sassone~~

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 pin-point 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 KUHLHOFF

ARGOSY -

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

BARBER - PRESALE R 0127400

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-bag 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-

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BARBER - PRESALE R 0127401

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 3¼ 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.

870 ?

New looks" have been given to three time-tried models in Remington's line of rifles and shotguns—the Model 742 "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 11-48 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 742 and 760 are gone, and all rifles of these two models, as well as the 11-48 shotgun, will have the new fine-line checkering.

In case you have forgotten, the Model 742 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, weatherproof 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 versions chambered for 2¾-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. • • •

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BARBER - PRESALE R 0127401
R2528389

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.

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KINZER V. REMINGTON

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

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

1 - ~~MHW~~ - Info
2 - Thelma - File - M/600
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

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 1/2" 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

Capt. 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

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RECEIVED
JAN
E.S. REMINGTON

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 brazzed, 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 damand 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. Nonte Jr.
Capt. Ord. C
Technical Editor

GCN:bp

W. E. LEEK / M/600 Telephone: 10-31 1:30 PM

From: George Rockwell

Model 600 is advertised as 5 1/2 lbs. (308 Cal.) get info.
Our gun at Bridgeport weighs 5 lbs. 15 oz.
What is average accurate weight, please? weigh 1 myself

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

	308 Win.	222 Rem.	35 Rem.
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 ~~1101~~ (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

cc: R.A. Williamson
W.C. Schrader
W.E. Leek - File

Ilion, New York
December 12, 1963

A. J. ZECKNER

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 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 TW
~~John F~~ F
Please review
+ comment + ret. to
me. W

Memo from the desk of STAN HUTCHINSON

Wayne Leek 9/23/63

Here's copy we're thinking of using for 3M/600. Any corrections or additions please let us know

NEW REMINGTON

MODEL 600

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 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. 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 "bead" and sturdy U notch rear sight is adjustable for elevation and windage. Receiver drilled and tapped for scope and receiver sights.

TRIGGER is extra wide and corrugated; finger fits securely. 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 checkering on fore-end and pistol grip. Monte Carlo Stock with Fluted ~~Bomb~~ Comb. 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 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 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

Draft - 11/5/63

adv

REMINGTON ANNOUNCES

NEW MODEL 600 BOLT ACTION

CARBINE CENTER FIRE RIFLE

The nation's white-tailed deer population is at an allttime 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.

(Rifle)

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 bead. The sturdy U notch rear sight is adjustable for windage and elevation and the receiver is drilled and tapped for telescopic sights and [illegible] 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 carbine will set standards for accuracy, power and performance unequalled by any other rifles in its class. It will be priced at only $_____ retail.

-30-

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 14" 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 DUPONT

REMINGTON ARMS COMPANY, INC.

PETERS DUPONT

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

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.

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

	Net to Wholesaler Less Tax	Net to Wholesaler Tax Included	Dealer	Retail
MODEL 600 - 222 Remington) 308 Win.) 35 Remington)	$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 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,

Gail Evans

Vice President and
Director of Sales

Gail Evans/mgm

NEW MODEL 600 CARBINE

WHOLESALER 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

QUANTITY	NUMBER	CALIBER
_____	5728	35 Remington
_____	5722	308 Win.
_____	5726	222 Remington

****

SPECIAL INSTRUCTIONS, IF ANY_____

_____

_____

_____

_____

_____ (Buyer's signature)

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON
BARBER - PRESALE R 0127427 R2528415

BARBER - PRESALE R 0127427

DISTRIBUTOR SALESMEN'S SAMPLE ORDER FORM

TO: ORDER DEPARTMENT
REMINGTON ARMS COMPANY, INC.
BRIDGEPORT, CONNECTICUT #06602

Date_____

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.

MODELS

11-48* 12/28 Mod Vent		1100* 20/28 Mod Vent		600 308 Caliber		760 30/06 Caliber		742 30/06 Caliber		510-X Bolt S. S.		511-X Bolt Clip		512-X Bolt Tube		SALESMAN'S NAME AND HOME ADDRESS
Gun	Case	Gun	Case	Gun	Case	Gun	Case	Gun	Case	Gun	Case	Gun	Case	Gun	Case	

*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)

G-88

DON'T SAY IT—WRITE IT

File

cc: F.E. Morgan

To E. S. Mc CAWLEY - Bridgeport

Date Oct. 15, 1963

From 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

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KINZER V. REMINGTON

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 not 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.

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.

Wayne E Leek

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

WEL:T

M/600 - Barrel

REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE

Remington DUPONT PETERS DUPONT

"CONFINE YOUR LETTER TO ONE SUBJECT ONLY"

CC: H. K. Boyle
R. L. Hall
G. J. Hill
R. D. Stowell

Ilion, New York
December 10, 1970

M/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 18½" 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.

BARBER - PRESALE R 0127433

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

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KINZER V. REMINGTON

BARBER - PRESALE R 0127433

G-88

DON'T SAY IT—WRITE IT

TO F. E. MORGAN - BRIDGEPORT

DATE Nov. 29, 1965

FROM V. G. [illegible] - ILION

CC: S. M. Alvis
M. J. Machman
R. B. Hurley

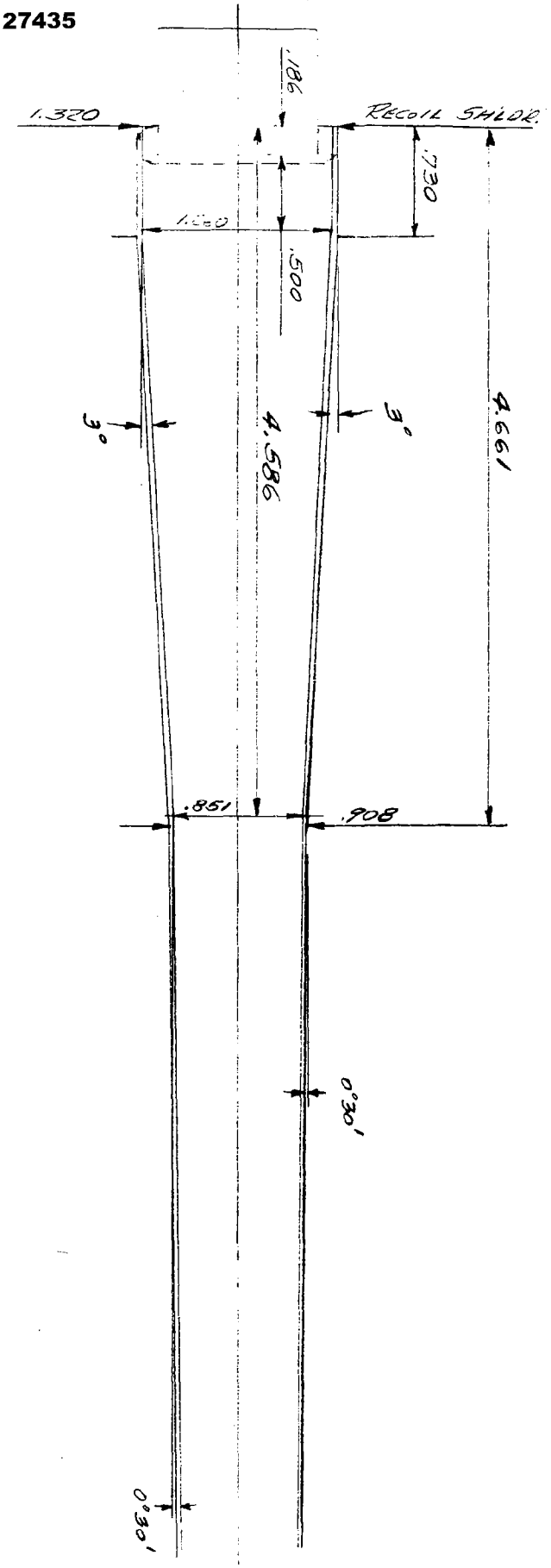
MODEL 600 - EXPORT FOR JAPAN - 19¼" BARREL
(Reference Nov. 19, 1965 letter)

A high-spot check indicates that Barrel tooling from the starting operation and continuing throughout this process would be required to produce a 19¼" Barrel. The present Model 600 Barrel has a nominal length of 18½".

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.

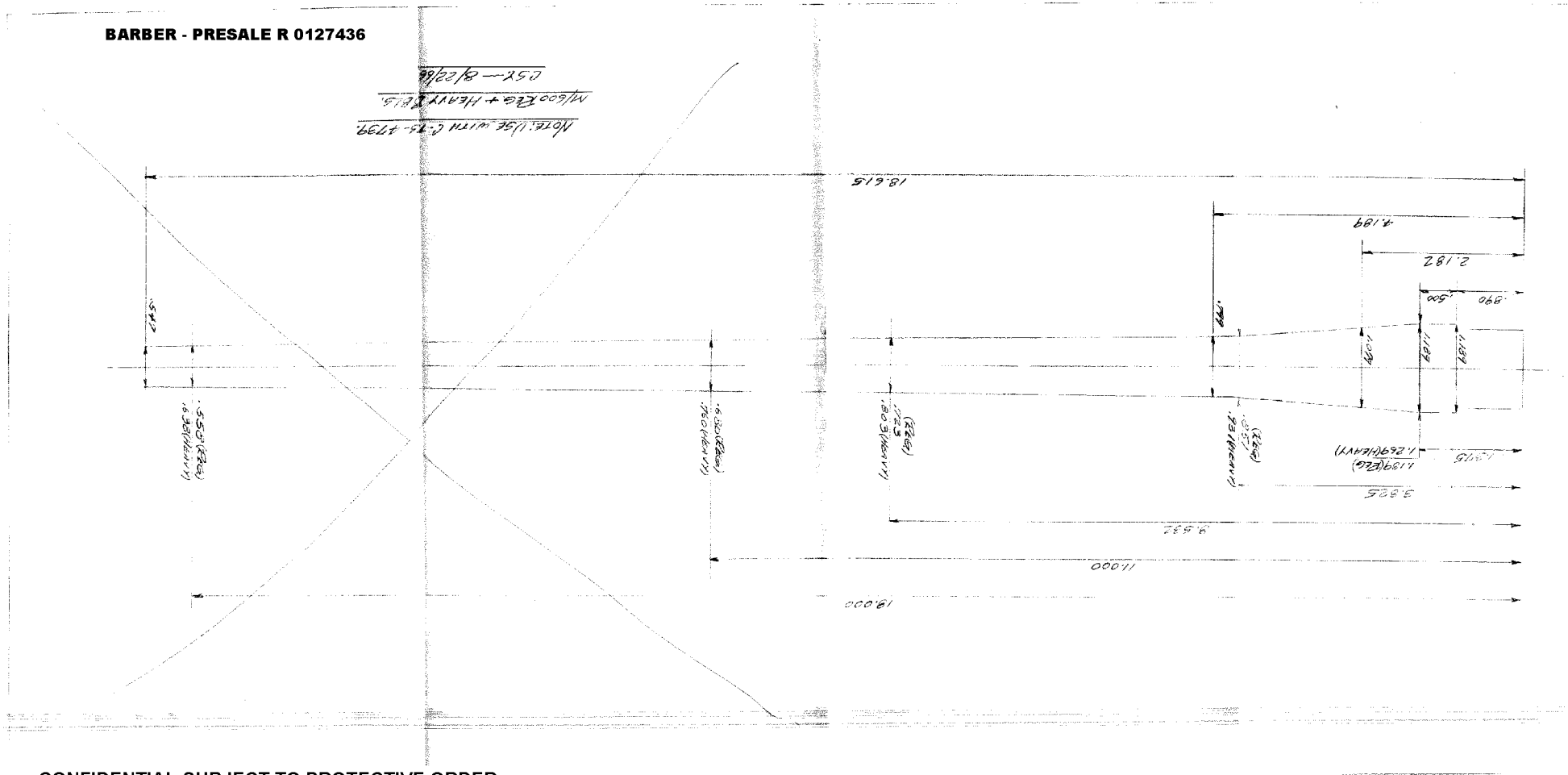
VGD:I

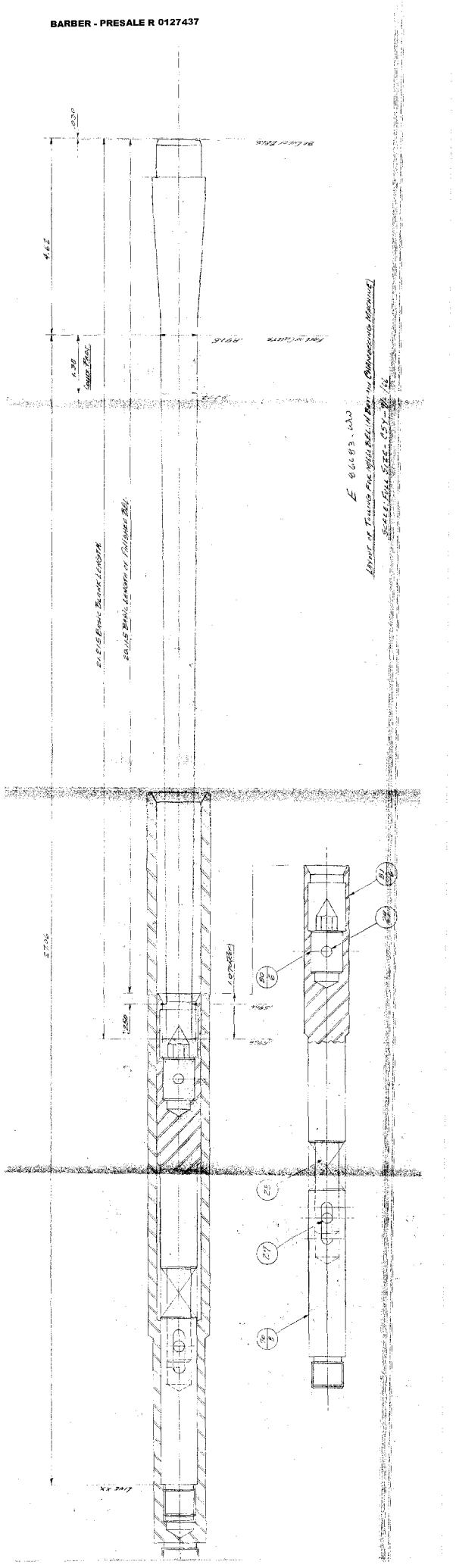
TO BE SAFE; FIRST THINK YOU MIGHT NOT BE



M/60 BBL. + STOCK PLAN VIEW ASSEM.

SCALE: F.S. - CSX - 6/1/67





P.B.K.

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:

.308's

Oper. No.	Operation	Dept.
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

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KINZER V. REMINGTON

Operations Charged to this Order: Cont'd.

6.5's

Oper. No.	Operation	Dept.
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/eb

600 — 6 mm Barrel Blank length

700 — went from .770 ±.100 cutoff length

to 2.570 ±.100

plus elim expenders / min groove dim.

& better ammo.

600 — have. .395 ±.100

should go to 2.155 ±.100 by going to 20" blank.

need new turning fixture

Form RD5845

REMINGTON ARMS COMPANY, INC.

ENGINEERING DEPARTMENT DUPONT COMPUTATION SHEET

J. Mock
E. Mock
B. Burger

SHEET NO.

TITLE OF PROJ. Finish Comparson on

PROJ. NO.

SUBJECT Center Fire Bbls.

WORKS

Present Cost COMPUTER SA DATE 5-8 1963-

Model XP 100 Pt. No 26760

OPR.	DESCRIPTION	LABOR	EXPENSE
95	Cyl. 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 600 Pt. No 26690

61	Hand Spin Polish Ro. & Finish	9.080/100	7.030/100

Model 700 Pt No 26291

70	Centerless Polish Rough	2.986	1.865
72	Centerless " Finish	3.220	1.699
		*6.206/100	*3.564

M/600 Bbl. Trial & Pilot Process Finish was same as M/700. However Taper prevents Senterless Polish

MODEL 600

cc: R. L. St. John

RD-69 REV. 6-58

REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE

Remington DUPONT

file m/600

JUL 26 1983

CC ~~J. P. Linde~~ ~~J. R. Snedeker~~ R. J. Long

700 back order

100 [illegible]

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.

Ken

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 awhile longer. Production needs sear & safety cam assem's.

Dennis 7/5/83

RD-69 REV. 6-58

REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE

Remington
DUPONT

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

Copy to Dennis Smith
4-22-82

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

F. T. Millener

FTM: fms
att.

HIGH POWER CARBINE

FIXED BOX MAGAZINE

BOLT ACTION REPEATER

MOHAWK 600

INSTRUCTION FOLDER and PARTS LIST

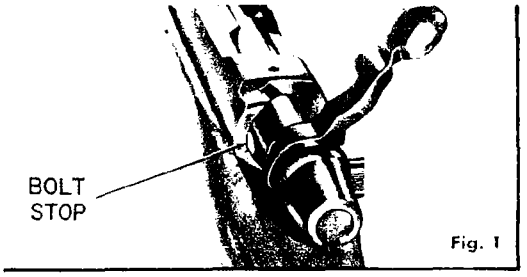


Fig. 1

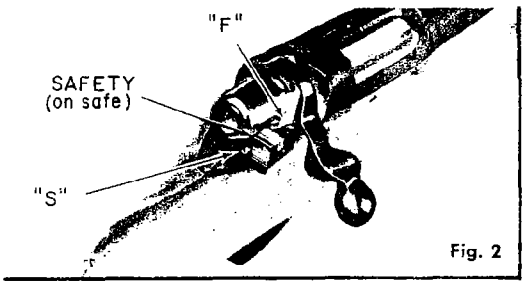
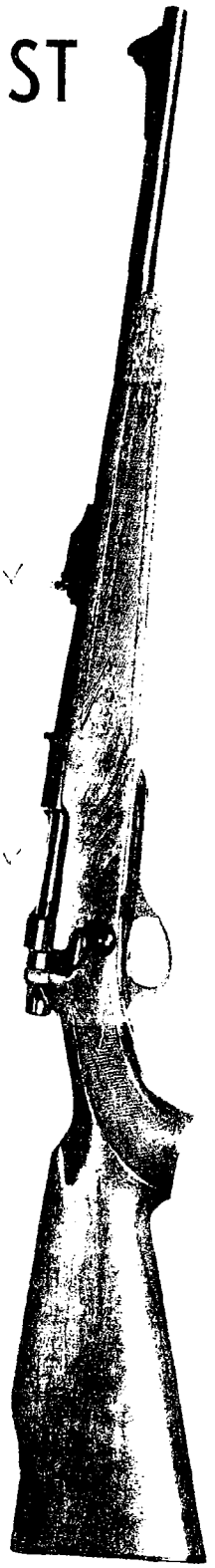


Fig. 2



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 "S" on receiver. In this position, trigger cannot be pulled to fire rifle and bolt handle cannot be raised to unlock and open action.

FIRE — Rotate safety to forward stop position marked "F" on receiver. 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.

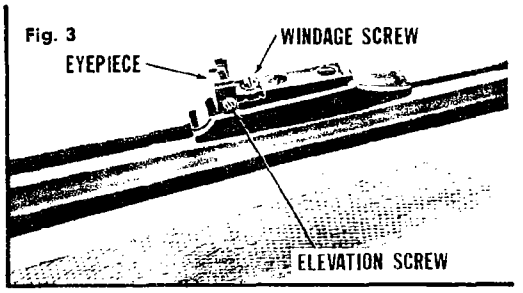


Fig. 3

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.

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

xc: P.H. Holmberg - Bpt.
W.K. Bryant
C.B. Workman

RD-69-B

REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE

Remington (DUPONT) PETERS (DUPONT)

"CONFINE YOUR LETTER TO ONE SUBJECT ONLY"

July 1, 1980

TO: J.H. CARTER

FROM: J.W. BROOKS

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.

RECT SHIPMENT BARBER - PRESALE R 0127447 SPEEDISET® MOORE BUSINESS FORMS, INC.
NOT TO BE INVOICED

-43864 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.

DU PONT DU PONT

INVOICE NO.

INVOICE DATE

ORDER NO. M-43864

SOLD TO
P.H. HOLMBERG
REMINGTON ARMS COMPANY, INC.
939 BARNUM AVE.
BRIDGEPORT, CT 06602

SHIPPED FROM ILION, NEW YORK
VIA P.H. Holmberg

CASES 10 WEIGHT

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	" " B6226218		
	1 - R.F. Dietz	" " B6226241		
	1 - W.H. Forson	" " B6226232		
	FOR: FIELD TEST			
	TO BE RETURNED			
		Requested by: J.W. Brooks		
		Approved by: [signature]		
	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

[illegible] 6/25/80

720 RDS.

PRODUCT CONSIGNMENT TRANSACTION NOTICE

APPROVALS:

REGIONAL MANAGER _____

AREA MANAGER _____

PRODUCT MANAGER _____

DIR. OF ~~SALES~~ MKTG/P.L. Plan _____

DATE 6/6/80 REQUESTED BY: W. H. Forson, Jr.

TRANSACTION (CHECK TYPE)
- NEW CONSIGNMENT (XX)
- RETURN GOODS ( )
- TRANSFER OR EXCHANGE ( )*
- SALE ( )**
- WRITE-OFF ( )

cc: J. W. Brooks ✓
P. H. Holmberg

ACCOUNT TO BE CHARGED:

NAME P. H. Holmberg/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

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.

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON
BARBER - PRESALE R 0127448
R2528436
BARBER - PRESALE R 0127448

[illegible] Rev. 4 [illegible] ARMS COMPANY, INC.

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 (CHECK TYPE)
- NEW CONSIGNMENT (XX)
- RETURN GOODS ( )
- TRANSFER OR EXCHANGE ( )*
- SALE ( )**
- WRITE-OFF ( )

cc: J. W. Brooks ✓
J. G. Williams

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

QUAN.	ORDER NO.	MODEL	GRADE	GA OR CAL	BBL LGTH	CHOKE	TYPE	SERIAL NO.
1		BAC		7mm-08			RK	B6226240

OTHER PRODUCT IDENTIFICATION

QUAN.	ORDER AND/OR PART NO.	DESCRIPTION
1	B6226240	

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.

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

BARBER - PRESALE R 0127450

PRODUCT CONSIGNMENT TRANSACTION NOTICE

APPROVALS:

REGIONAL MANAGER _____

AREA MANAGER _____

PRODUCT MANAGER 6/13

DIR. OF SALES _____

DATE 6/6/80 REQUESTED BY: W. H. Forson, Jr.

TRANSACTION (CHECK TYPE)
- NEW CONSIGNMENT (XX)
- RETURN GOODS ( )
- TRANSFER OR EXCHANGE ( )*
- SALE ( )**
- WRITE-OFF ( )

cc: J. W. Brooks ✓
J. E. Preiser

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

QUAN.	ORDER NO.	MODEL	GRADE	GA OR CAL	BBL LGTH	CHOKE	TYPE	SERIAL NO.
1		BAC		7mm-08			RK	B622646

OTHER PRODUCT IDENTIFICATION

QUAN.	ORDER AND/OR PART NO.	DESCRIPTION
	B622646	

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.

BARBER - PRESALE R 0127450
R2528438

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

[illegible] ARMS COMPANY, INC.

PRODUCT CONSIGNMENT TRANSACTION NOTICE

APPROVALS:

REGIONAL MANAGER _____

AREA MANAGER _____

PRODUCT MANAGER 6/13

DIR. OF SALES _____

DATE 6/6/80 REQUESTED BY: W. H. Forson, Jr.

TRANSACTION (CHECK TYPE)
- NEW CONSIGNMENT (XX)
- RETURN GOODS ( )
- TRANSFER OR EXCHANGE ( )*
- SALE ( )**
- WRITE-OFF ( )

cc: J. W. Brooks ✓
E. J. Conroy

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

QUAN.	ORDER NO.	MODEL	GRADE	GA OR CAL	BBL LGTH	CHOKE	TYPE	SERIAL NO.
1		BAC		7mm-08			RK	B622628

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.

BARBER - PRESALE R 0127451
BARBER - PRESALE R 0127451
R2528439

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

BARBER - PRESALE R 0127452

PRODUCT CONSIGNMENT TRANSACTION NOTICE

APPROVALS:

REGIONAL MANAGER _____

AREA MANAGER _____

PRODUCT MANAGER Paul Hobaby 6/13

DIR. OF SALES _____

DATE 6/6/80 REQUESTED BY: W. H. Forson, Jr.

cc: J. W. Brooks ✓
E. G. Larson

TRANSACTION (CHECK TYPE)
- NEW CONSIGNMENT (XX)
- RETURN GOODS ( )
- TRANSFER OR EXCHANGE ( )*
- SALE ( )**
- WRITE-OFF ( )

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

QUAN.	ORDER NO.	MODEL	GRADE	GA OR CAL	BBL LGTH	CHOKE	TYPE	SERIAL NO.
1		BAC		7mm-08			SL	B6226220

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.

R2528440

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

BARBER - PRESALE R 0127453

BARBER - PRESALE R 0127453

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 (CHECK TYPE)
- NEW CONSIGNMENT (XX)
- RETURN GOODS ( )
- TRANSFER OR EXCHANGE ( )*
- SALE ( )**
- WRITE-OFF ( )

cc: J. W. Brooks ✓
J. C. Callahan

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

QUAN.	ORDER NO.	MODEL	GRADE	GA OR CAL	BBL LGTH	CHOKE	TYPE	SERIAL NO.
1		BAC		7mm-08			RK	B622625I

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.

R2528441

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

BARBER - PRESALE R 0127454

PRODUCT CONSIGNMENT TRANSACTION NOTICE

APPROVALS:

REGIONAL MANAGER _____

AREA MANAGER _____

PRODUCT MANAGER Paul Holaby 6/13

DIR. OF SALES _____

DATE 6/6/80 REQUESTED BY: W. H. Forson, Jr.

cc: J. W. Brooks ✓
R. J. Reineck

TRANSACTION (CHECK TYPE)

NEW CONSIGNMENT	(XX)
RETURN GOODS	( )
TRANSFER OR EXCHANGE	( )*
SALE	( )**
WRITE-OFF	( )

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

QUAN.	ORDER NO.	MODEL	GRADE	GA OR CAL	BBL LGTH	CHOKE	TYPE	SERIAL NO.
1		BAC		7mm-08			RK	86226252

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.

R528442

BARBER - PRESALE R 0127454

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 (CHECK TYPE)
- NEW CONSIGNMENT (XX)
- RETURN GOODS ( )
- TRANSFER OR EXCHANGE ( )*
- SALE ( )**
- WRITE-OFF ( )

cc: J. W. Brooks ✓
T. W. Rawson

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

QUAN.	ORDER NO.	MODEL	GRADE	GA OR CAL	BBL LGTH	CHOKE	TYPE	SERIAL NO.
1		BAC		7mm-08			SV	B6226218

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.

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PRODUCT CONSIGNMENT TRANSACTION NOTICE

APPROVALS:

REGIONAL MANAGER _____

AREA MANAGER _____

PRODUCT MANAGER Paul Holaday 6/13

DIR. OF SALES _____

DATE 6/6/80 REQUESTED BY: W. H. Forson, Jr.

TRANSACTION (CHECK TYPE)
- NEW CONSIGNMENT (XX)
- 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

QUAN.	ORDER NO.	MODEL	GRADE	GA OR CAL	BBL LGTH	CHOKE	TYPE	SERIAL NO.
1		BAC		7mm-08			SL	B6226241

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.

BARBER - PRESALE R 0127456
BARBER - PRESALE R 0127456 R2528444

PRODUCT CONSIGNMENT TRANSACTION NOTICE

APPROVALS:

REGIONAL MANAGER _____

AREA MANAGER _____

PRODUCT MANAGER [signature] 6/13

DIR. OF SALES _____

DATE 6/6/80 REQUESTED BY: P. H. Holmberg

TRANSACTION (CHECK TYPE)
- NEW CONSIGNMENT (XX)
- RETURN GOODS ( )
- TRANSFER OR EXCHANGE ( )*
- SALE ( )**
- WRITE-OFF ( )

cc: J. W. Brooks ✓
W. H. Forson

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

QUAN.	ORDER NO.	MODEL	GRADE	GA OR CAL	BBL LGTH	CHOKE	TYPE	SERIAL NO.
1		BAC		7mm-08			SV	86226232

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.

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 Remington.
BRIDGEPORT, CONN.

DU PONT DU PONT

INVOICE NO.

INVOICE DATE 6/27/80

ORDER NO. M-43865

SOLD TO
P.J. BERGERE
REMINGTON ARMS COMPANY, INC.
2975 W. MARKET ST.
AKRON, OH 44313

SHIPPED FROM ILION, NEW YORK
VIA Best Way UPS INS 6/26/8
Value: $500.

CASES 1 WEIGHT 9

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

BARBER - PRESALE R 0127459

PRODUCT CONSIGNMENT TRANSACTION NOTICE

APPROVALS:

REGIONAL MANAGER _____

AREA MANAGER _____

PRODUCT MANAGER Paul Holaday 6/13

DIR. OF SALES _____

DATE 6/6/80 REQUESTED BY: W. H. Forson, Jr.

TRANSACTION (CHECK TYPE)
- NEW CONSIGNMENT (XX)
- RETURN GOODS ( )
- TRANSFER OR EXCHANGE ( )*
- SALE ( )**
- WRITE-OFF ( )

cc: J. W. Brooks ✓
P. J. Bergere

ACCOUNT TO BE CHARGED:

NAME P. J. Bergere/Rem. Arms

STREET 2975 W. Market St.

CITY Akron, STATE OH 44313

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	B6226259

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.

BARBER - PRESALE R 0127459
R2528447

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.

DU PONT DU PONT

INVOICE NO.

INVOICE DATE 6/27/80

ORDER NO. M-43866

SOLD TO
N.L. OLDRIDGE
REMINGTON ARMS COMPANY, INC.
8080 WARD PKY. - SUITE #250
KANSAS CITY, MO 64114

SHIPPED FROM ILION, NEW YORK
VIA L Best Way UPS INS
Value: $500. 6/26/80

CASES 1 WEIGHT 9

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

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

BARBER - PRESALE R 0127461

PRODUCT CONSIGNMENT TRANSACTION NOTICE

APPROVALS:

REGIONAL MANAGER _____

AREA MANAGER _____

PRODUCT MANAGER Paul Holaday 6/13

DIR. OF SALES _____

DATE 6/6/80 REQUESTED BY: W. H. Forson, Jr.

cc: J. W. Brooks ✓
N. L. Oldridge

TRANSACTION (CHECK TYPE)

NEW CONSIGNMENT	(XX)
RETURN GOODS	( )
TRANSFER OR EXCHANGE	( )*
SALE	( )**
WRITE-OFF	( )

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

QUAN.	ORDER NO.	MODEL	GRADE	GA OR CAL	BBL LGTH	CHOKE	TYPE	SERIAL NO.
1		BAC		7mm-0	8		SV	8622623C

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.

R2528449

BARBER - PRESALE R 0127461

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 Remington.
BRIDGEPORT, CONN.

DU PONT DU PONT

INVOICE NO.

INVOICE DATE 6/27/80

ORDER NO. M-43867

SOLD TO
K. N. WAITE
REMINGTON ARMS COMPANY, INC.
20 TOWER LA. - AVON PARK SOUTH
AVON, CT 06001

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. B6226270		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

BARBER - PRESALE R 0127463

BARBER - PRESALE R 0127463
R2528451

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 (CHECK TYPE)
- NEW CONSIGNMENT (XX)
- RETURN GOODS ( )
- TRANSFER OR EXCHANGE ( )*
- SALE ( )**
- WRITE-OFF ( )

cc: J. W. Brooks ✓
K. N. Waite

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

QUAN.	ORDER NO.	MODEL	GRADE	GA OR CAL	BBL LGTH	CHOKE	TYPE	SERIAL NO.
1		BAC		7mm-08			SV	B622627o

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.

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 Remington.

BRIDGEPORT, CONN.

DU PONT DU PONT

INVOICE NO.

INVOICE DATE 6/27/80

ORDER NO. M-43868

SOLD TO
W.L. FLINN
REMINGTON ARMS COMPANY, INC.
303 FRIENDLY CTR. OFC. BLDG.
600 GREEN VALLEY RD.
GREENSBORO, NC 27408

SHIPPED FROM ILION, NEW YORK

VIA Best Way UPS INS

Value: $500. 6/26/80

CASES 1 WEIGHT 9

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 [signature]

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

BARBER - PRESALE R 0127465

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 (CHECK TYPE)
- NEW CONSIGNMENT (XX)
- RETURN GOODS ( )
- TRANSFER OR EXCHANGE ( )*
- SALE ( )**
- WRITE-OFF ( )

cc: J. W. Brooks ✓
W. L. Flinn

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

QUAN.	ORDER NO.	MODEL	GRADE	GA OR CAL	BBL LGTH	CHOKE	TYPE	SERIAL NO.
1		BAC		7mm-08			SL	6622649

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.

BARBER - PRESALE R 0127465
R2528453

M-43869 sse 6/24/80

MAKE ALL REMITTANCES TO BRIDGEPORT, CONN.

REMINGTON ARMS COMPANY, INC.

Remington. DU PONT

FIREARMS, AMMUNITION, TARGETS, TRAPS, AND POWDER METAL PARTS
BRIDGEPORT, CONN.

Remington. DU PONT

INVOICE NO.

INVOICE DATE

ORDER NO. M-43869

SOLD TO
A. W. WHEATON
REMINGTON ARMS COMPANY, INC.
4510 W. 77th ST., - SUITE 227
EDINA, MINN. 55435

SHIPPED FROM ILION, NEW YORK

VIA Best Way UPS INS 6/26/80
Value: $500.

CASES	WEIGHT
1	9

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 [signature]

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

APPROVALS:

REGIONAL MANAGER _____

AREA MANAGER _____

PRODUCT MANAGER [signature] 6/13

DIR. OF SALES _____

DATE 6/6/80 REQUESTED BY: W. H. Forson, Jr.

TRANSACTION (CHECK TYPE)
- NEW CONSIGNMENT (XX)
- RETURN GOODS ( )
- TRANSFER OR EXCHANGE ( )*
- SALE ( )**
- WRITE-OFF ( )

cc: J. W. Brooks ✓
A. W. Wheaton

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

QUAN.	ORDER NO.	MODEL	GRADE	GA OR CAL	BBL LGTH	CHOKE	TYPE	SERIAL NO.
1		BAC		7mm-08			SL	86226253

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.

M-43870 sse 6/24/80

MAKE ALL REMITTANCES TO BRIDGEPORT, CONN.

REMINGTON ARMS COMPANY, INC.

Remington. DU PONT

FIREARMS, AMMUNITION, TARGETS, TRAPS, AND POWDER METAL PARTS
BRIDGEPORT, CONN.

Remington. DU PONT

INVOICE NO.

INVOICE DATE 6/27/80

ORDER NO. M-43870

SOLD TO
D. GODFREY
REMINGTON ARMS COMPANY, INC.
313 MEADOWS BLDG.
DALLAS, TX 75206

SHIPPED FROM ILION, NEW YORK

VIA Best Way UPS INS
Value: $500. 6/26/80

CASES 1 WEIGHT 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 C.B. Hickman		
	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

BARBER - PRESALE R 0127469

PRODUCT CONSIGNMENT TRANSACTION NOTICE

APPROVALS:

REGIONAL MANAGER _____

AREA MANAGER _____

PRODUCT MANAGER Richard Godfrey 6/13

DIR. OF SALES _____

DATE 6/6/80 REQUESTED BY: W. H. Forson, Jr.

TRANSACTION (CHECK TYPE)
- NEW CONSIGNMENT (XX)
- 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

QUAN.	ORDER NO.	MODEL	GRADE	GA OR CAL	BBL LGTH	CHOKE	TYPE	SERIAL NO.
1		BAC		7mm-08			RK	B6226273

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.

BARBER - PRESALE R 0127469
R2528457

M-43871 sse 6/24/80

MAKE ALL REMITTANCES TO BRIDGEPORT, CONN.

REMINGTON ARMS COMPANY, INC.

Remington. DU PONT

FIREARMS, AMMUNITION, TARGETS, TRAPS, AND POWDER METAL PARTS
BRIDGEPORT, CONN.

Remington. DU PONT

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. Brocks

Approved by C. B. Wiseman

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

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 (CHECK TYPE)
- NEW CONSIGNMENT (XX)
- RETURN GOODS ( )
- TRANSFER OR EXCHANGE ( )*
- SALE ( )**
- WRITE-OFF ( )

cc: J. W. Brooks ✓
W. B. Cockman

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

QUAN.	ORDER NO.	MODEL	GRADE	GA OR CAL	BBL LGTH	CHOKE	TYPE	SERIAL NO.
1		BAC		7mm-08			RK	B6226275

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.

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 Bennett, Bob Smith, Fred Hart, Dennis Smith, Earle Fletcher, R L Hall

10-16-79

October 12, 1979

TO: D. C. BROOKS

FROM: D. E. MC WHIRT

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

RD-49 REV. 6-58

REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE

Remington
DUPONT

cc: J. Carter
W. H. Forsom
J. E. Preiser
W. J. Thresher, Sr.
File

Copies Mike, Bernie, Bob Smith, Frank Hart, Dennis Lonito
Earle Fletcher, R. L. Hall
10-12-79

October 9, 1979

TO: D. C. BROOKS

FROM: D. E. MC WHIRT

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

G-68

cc: J.H. Cartes, D.T. Brien
B.H. Gilbert

DON'T SAY IT — WRITE IT

To D.J. Anderson

Date 11/15/78

From M.J. Kantos

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
Blanks 1850
In Process 7687
9537

Expected deliveries for which we are committed 5300 Blanks.

SAFETY IS A WISE INVESTMENT

RD-69 REV. 6-58

REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE

Remington

cc: W. H. Forson, Jr.

Copies to Mickey Barnes

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.

H. D. Albaugh

HDA/ap

RD-69 REV. 6-58

REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE

Remington

cc: T. Rawson
D. Ryan
P. Rosendahl
H. Albaugh
R. Van Duzer
B. Smith

cc: Harvey Boyle
Howard Hendrix
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.

PASTOR

Forwarded guns to Bridgeport on Pan truck 1-13-78

.....;

1936 EST+

REMARMS STRD

BOOWOOD AA22657

VELASCO/LEVINSOHN

MOHAWK 600 SAMPLES HAVE PASSED COMMONWEALTH TESTING REQUIREMENTS AND GUNS MAY BE RETURNED AT YOUR EARLIEST CONVENIENCE. REGARDS.

+

REMARMS STRD

RECEIVED
NOV 11 1977
PASTOR VELASCO

RD-89 REV. 6-58

REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE

Remington DUPONT

cc: A. Farrington
J. Fenton
R. Moore
P. Rosendahl
R. Ryan
D. Sawyer
R. Van Duzer

ship by 12-16-77

RECEIVED JUN 1977 ARMS SALES

Bridgeport, Connecticut
June 7, 1977

TO : HORACE HENDRIX

FROM : PASTOR VELASCO

SUBJECT: RETURN OF 850 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
499 500 500 " 6150, " 600, caliber .222
-4 145 146 150 " 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

4 (6152) MISSING 6367325
6363781
6363676
6340352

XC: H. K. Boyle
J. H. Carter
P. G. Johnson
J. P. Linde

11/15/77

copies to Mr. Barnes
11-17-77

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	J. Hutton
S. Bennett	C. Prosser
J. Bower	J. Snedeker
G. Hill	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 punch that forms the U-shaped section of the Safety arm. The vendor will correct. Temporarily, the Housing will be chamfered to provide clearance. — N. P. Process

2. Safety binds on Stock -
   a) Sidewise - caused by the Safety arm being fabricated at the wrong angle. The vendor has corrected. — N. P. Process
   b) Rearward - There appears to be an insufficient amount of clearance rearward. R & D is reviewing the model drawings. — R & D

3. Housing interferes with Reinforcing Screw in Stock - The 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. — Chem & Met

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 setting Trigger pull weight. — Process Eng.

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
For the Committee

JWB/hf

cc: H. Hendrix 8-15-77

DON'T SAY IT—*WRITE IT*

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.

PJR:rr
Att.

cc: T. W. Rawson
H. D. Albaugh
P. Velasco
E. S. Cipcer

RD 778 STOP, LOOK, AND LIVE

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

RD-63 REV. 6-58

REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE

Remington
DUPONT

cc: H. W. Milliman
R. G. Ryan

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.R.ds
Attach.

RD-69 REV. 6-58

REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE

Remington
DUPONT

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

RD-49 REV. 6-56

REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE

Remington DUPONT

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 same guns ship back to us

cc: J. Ayers 6-14-77

RECEIVED JUN 8 1977 ARMS SALES

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

RD-49 Rev. 6-58

REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE

Remington

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

FROM: PASTOR VELASCO - International Sales

SUBJECT: Returned Goods

Our Order No. AX-43060 AX-43070

Invoice No. X-1049, 1157, 1196, 1226, 1231, 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:

200		M/600 Caliber 308
500		M/600 Caliber 222
300		M/600 Caliber 243

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.

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

cc: R. Moore
P. Davis
P. Velasco

RD-69 REV. 6-58

REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE

Remington
DUPONT

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

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

LM:RP

1396

2nd May, 1977.

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.

Per _____

2/5/77
DATE

SIGNATURE

CNR DAY & EGERTON STS
SILVERWATER. N.S.W.
ADDRESS

OFFICE SUPERVISOR.
CAPACITY

RECEIVED
MAY 10 1977
PASTOR VELASCO

M/600

"Malmros Monsoon" C/S 4312/S 20.1.1977

AX-43070-01

20 - 6156 150 - 6154

Case 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	

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

AX-43070-01

Case No. 11	5-6154
6367325	
6363781	
6363676	
6340352	
6367530	

Case No. 12	5-6154
6354004	
6354041	
6353962	
6354930	
6354793	

Case No. 13	5-6154
6367140	
6367544	
6367576	
6367346	
6367145	

Case No. 14	5-6154
6363741	
6363628	
6354559	
6354622	
6353897	

Case No. 15	5-6154
6354539	
6354837	
6355013	
6354701	
6354603	

Case No. 16	5-6154
6363828	
6363819	
6367488	
6363788	
6363577	

Case No. 17	5-6154
6354743	
6383816	
6355011	
6363790	
6354987	

Case No. 18	5-6154
6363830	
6367074	
6363719	
6363829	
6367498	

Case No. 19	5-6154
6367364	
6367078	
6367231	
0367517	
6367447	

Case No. 20	5-6154
6363728	
6367137	
6367266	
6367322	
6339874	

Case No. 21 5-6154

6340027
6363636
6348782
6353966
6354995

Case No. 22 5-6154

6354886
6354610
6355009
6354694
6354512

Case No. 23 5-6154

6363708
6363554
6363837
6363779
6363683

Case No. 24 5-6154

6363808
6367345
6367492
6367213
6354422

Case No. 25 5-6154

6367459
6367148
6367532
6367445
6354978

Case No. 26 5-6154

6339937
6354754
6354777
6354778
6354821

Case No. 27 5-6154

6367126
6367127
6367553
6367108
6367438

Case No. 28 5-6154

6363648
6363699
6363646
6363647
6363557

Case No. 29 5-6154

6354969
6354964
6354547
6354589
6367572

Case No. 30 5-6154

6348606
6345943
6345904
6354521
6354975

...4/.

AX-43070-01

Case No. 31	5-6154
6354734	
6354829	
6354580	
6355002	
6340072	

Case No. 32	5-6154
6354549	
6354450	
6354820	
6354683	
6354523	

Case No. 33	5-6154
6367085	
6367470	
6354492	
6367462	
6363612	

Case No. 34	5-6154
6354618	
6363661	
6367303	
6354953	
6367437	

M/600

AX-43060-03 20-6156 130-6150

Case 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-43060-03

Case No. 7	5-6150
6371258	
6371245	
6371367	
6375819	
6375703	

Case No. 8	5-6150
6375740	
6375729	
6375712	
6375707	
6375809	

Case No. 9	5-6150
6371157	
6371453	
6371404	
6371260	
6371333	

Case No. 10	5-6150
6375833	
6375834	
6371181	
6375838	
6371382	

Case No. 11	5-6150
6371343	
6371435	
6371286	
6371427	
6371497	

Case No. 12	5-6150
6375799	
6375673	
6375705	
6375817	
6371595	

Case No. 13	5-6150
6375749	
6310314	
6375828	
6375785	
6375756	

Case No. 14	5-6150
6375801	
6371418	
6371199	
6371546	
6371275	

Case No. 15	5-6150
6371182	
6375676	
6371468	
6371565	
6371495	

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. 18	5-6150
6375340	
6371456	
6371232	
6371217	
6371512	

Case No. 19	5-6150
6371454	
6371579	
6371574	
6371485	
1371508	

Case No. 20	5-6150
6371179	
6371225	
6371514	
6371314	
6371417	

Case No. 21	5-6150
6371169	
6375708	
6375762	
6371573	
6375727	

Case No. 22	5-6150
6371200	
6371215	
6371177	
6371373	
6371201	

Case No. 23	5-6150
6375795	
6371463	
6371597	
6375737	
6371473	

Case No. 24	5-6150
6375717	
6371175	
6371327	
6371293	
6317076	

Case No. 25	5-6150
6371569	
6371467	
6375773	
6371602	
6371389	

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. 28	5-6150
6371505	
6375745	
6371477	
6371502	
6371581	

Case No. 29	5-6150
6371598	
6371515	
6375738	
6371577	
6371556	

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	Case No. 2 5-6156
6371614	6367329
6371652	6354816
6367299	6367164
6371675	6367167
6371662	6367538
Case No. 3 5-6156	**Case No. 4 5-6156**
6367369	6339898
6367316	6340459
6371977	6339839
6367414	6340010
6361612	6339665
Case No. 5 5-6156	**Case No. 6 5-6156**
6340182	6371838
6339909	6371670
6339891	6371647
6339853	6371678
6340524	6371632
Case No. 7 5-6156	**Case No. 8 5-6156**
6367211	6367368
6367332	6367482
6371627	6367377
6371657	6367262
6371720	6354037
Case No. 9 5-6156	**Case No. 10 5-6156**
6367358	6340522
6367403	6339849
6371644	6339948
6371625	6340482
6371695	6340195

AX-43060-02

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	

Columbus Victoria C/S 4319/S

AX-43060-04

100 - 6150

Case No. 1 5-6150	Case No. 2 5-6150
6371481	6371222
6371267	6375678
6371586	6375803
6371540	6310166
6317018	6371325
Case No. 3 5-6150	**Case No. 4 5-6150**
6371307	6371472
6371165	6371486
6375766	6371296
6371372	6375796
6371545	6371518
Case No. 5 5-6150	**Case No. 6 5-6150**
6371185	6375681
6371306	6375732
6371282	6375790
6371445	6375811
6371398	6375818
Case No. 7 5-6150	**Case No. 8 5-6150**
6371310	6371178
6375725	6375711
6371357	6375700
6375826	6371507
6371279	6375798
Case No. 9 5-6150	**Case No. 10 5-6150**
6371229	6371277
6375786	6371204
6375757	6371226
6375690	6375688
3675832	6371194

BARBER - PRESALE R 0127497

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/.

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

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. 12	5-6150
6375742	
6371244	
6371195	
6371176	
6371498	

Case No. 13	5-6150
6371550	
6371591	
6371193	
6371263	
6371391	

Case No. 14	5-6150
6371198	
6371300	
6371360	
6371304	
6371348	

Case No. 15	5-6150
6371525	
6371352	
6371478	
6371548	
6371460	

Case No. 16	5-6150
6371211	
6371355	
6371363	
6371261	
6371426	

Case No. 17	5-6150
6371347	
6371208	
6371416	
6371203	
6371297	

Case No. 18	5-6150
6371397	
6371250	
6371183	
6371206	
6371274	

Case No. 19	5-6150
6371452	
6371375	
6371167	
6371420	
6371186	

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. 32	5-6150
6371547	
6371166	
6371510	
6371537	
6371424	

Case No. 33	5-6150
6371441	
6371522	
6371213	
6371419	
6371493	

Case No. 34	5-6150
6371221	
6371386	
6371582	
6371423	
6371359	

Case No. 35	5-6150
6371370	
6371446	
6371570	
6371559	
6371262	

Case No. 36	5-6150
6371324	
6371432	
6371552	
6371524	
6371434	

Case No. 37	5-6150
6317029	
6315313	
6315701	
6311421	
6312208	

Case No. 38	5-6150
6315634	
6315666	
6310257	
6310306	
6315289	

Case No. 39	5-6150
6371326	
6371576	
6371599	
6371171	
6371443	

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. 42	5-6150
6371334	
6371411	
6371387	
6371358	
6300713	

Case No. 43	5-6150
6371284	
6371390	
6315928	
6371328	
6371428	

Case No. 44	5-6150
6371442	
6371584	
6371394	
6371256	
6371429	

Case No. 45	5-6150
6371526	
6371345	
6371529	
6371513	
6371356	

Case No. 46	5-6150
6371533	
6371592	
6371228	
6371564	
6371509	

Case No. 47	5-6150
6312212	
6314681	
6290487	
6315322	
6311416	

Case No. 48	5-6150
6371187	
6317039	
6371379	
6375793	
6375787	

Case No. 49	5-6150
6375723	
6375713	
6371489	
6375810	
6371484	

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. 52 5-6156

6375545
6384465
6372141
6371946
6372123

Case No. 53 5-6150

6371918
6367341
6363827
6371936
6384474

Case No. 54 5-6156

6372005
6371292
6372054
6374825
6354448

Case No. 55 5-6156

6354483
6371680
6371829
6372150
6371618

Case No. 56 5-6156

6372086
6371807
6384481
6371976
6375577

Case No. 57 5-6156

6371928
6354392
6371821
6372040
6371986

Case No. 58 5-6156

6371857
6372009
6372152
6372118
6371907

Case No. 59 5-6156

6371870
6371858
6371989
6371903
6371650

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:

	M/581 Single Shot Conversion Kit
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, Superintendent
INDUSTRIAL ENGINEERING SECTION

by: RWFarringtonJr

RWFjr/mc

Copies for Ken Mike 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

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

M/600 FIRE CONTROL - contd. -2-

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 Assembly by 12/27. — Production

J. W. Bower
For the Committee

JWB/hf

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BARBER - PRESALE R 0127508

DATES AND RE ONS 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

Form R. D. 6466

BARBER - PRESALE R 0127508
R2528496

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KINZER V. REMINGTON

BARBER - PRESALE R 0127509

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 - NWM/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 (.) - 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.

(PERFORM CHECK THREE TIMES)

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.

BARBER - PRESALE R 0127509
R528497

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BARBER - PRESALE R 0127510

DATES AND R ONS 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 TIME MODEL No. Moh. 600 OPER. No. 310
TYPE MACH. HRS. DEPT. No. 55 PAGE 4 OF 4
MACHINE

Form R.D. 6466

BARBER - PRESALE R 0127510 R 0128498

BARBER - PRESALE R 0127510

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON
BARBER - PRESALE R 0127511-R2528499

BARBER - PRESALE R 0127511

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
8-26-66 - Revised to include M/600 JAH/cm
1-25-67 - Item 20-b-1 was ¼ to 6 lbs. - NWM/cm
1/15/68 - Item 20b.-1 was 3½ 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
3/4/70 - Item 20-B-2 - Change Trig. Pull Specs. - M/700 from 6½ to 5½ 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

DESCRIPTIVE INFORMATION

(PERFORM CHECK THREE TIMES)

19. Safe - Function - 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. Trigger Pull - All Models

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 3½ to 6½ pounds pressure two (2) times out of three (3) - (M/600)
2. Gun must fire with 3 to 6½ pounds pressure two (2) time out of three (3) - (M/700)

PART NAME I. Inspection before COOLANT SET UP TIME MODEL No. 700 - 600 OPER. No.
TYPE Quality Audit Gallery Test. MACH. HRS. DEPT. No. PAGE 12 OF 15
MACHINE

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON
BARBER - PRESALE R 0127512 R2528500

DATES AND REASONS FOR REVISIONS 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
4/6/71 - Revised to change 18-a from 3/8" to 1/16"-RBL/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

1. 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

Form R. D. 6466

BARBER - PRESALE R 0127512

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS ASSEMBLY SHEETS

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

~~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 vial sliver 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. Add Additional Screws (Two) and Thumb Screw~~

20. Pick correct Magazine Box, inspect for color, no rust.

21. Assemble Magazine Box to Action.

EQUIPMENT—TOOLS & 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

N. D. 6461

BARBER - PRESALE R 0127513
BARBER - PRESALE R 0127513
R2528501

REASONS FOR REVISIONS 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.

(PERFORM THREE TIMES)

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.

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BARBER - PRESALE R 0127514 R2528502
BARBER - PRESALE R 0127514

DATES AND REASONS FOR REVISIONS 4/1/68 - Retyped from 3/18/68 - 266083 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.

Try Three Times:
- Clean sharp single detent.
- "On" back, can't fire with heavy Trigger pressure.
- Trigger must retract. Push Safety halway 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 Safety.
- 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)

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

Form R. D. 6466

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON
BARBER - PRESALE R 0127515
R2528503
BARBER - PRESALE R 0127515

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON
BARBER - PRESALE R 0127516
R2528504

BARBER - PRESALE R 0127516

5

DATES AND REASONS FOR REVISIONS 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

4/6/71 - Revised to change 18-a from 3/8" to 1/16"-RBL/bd

DESCRIPTIVE INFORMATION

17. Bolt Assembly - Finish & Fit (con't.)

M/700 - 600 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) timesforcibly
   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

1. 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

Form R. D. 6466

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON
BARBER - PRESALE R 0127517-R2528505

BARBER - PRESALE R 0127517

5/10/77-Add note;perform ck. 3 times #19-JCH/bdm-27594.

DATES AND REASONS FOR REVISIONS

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 ¼ to 6 lbs. - NWM/cm
1/15/68 - Item 20b.-1 was 3½ 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
3/4/70 - Item 20-B-2 - Change Trig. Pull Specs. - M/700 from 6½ to 5½ 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. HEB/bd

DESCRIPTIVE INFORMATION

(PERFORM CHECK THREE TIMES)

19. Safe - Function - 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. Trigger Pull - All Models

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 3½ to 6½ pounds pressure two (2) times out of three (3) - (M/600)
2. Gun must fire with 3 to 5½ pounds pressure two (2) time out of three (3) - (M/700)

PART NAME I. Inspection before COOLANT SET UP TIME MODEL No. 700 - 600 OPER. No.
TYPE Quality Audit Gallery Test. MACH. HRS. DEPT. No. PAGE 12 OF 15
MACHINE

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS RECORDS - ASSEMBLY SHEETS

3

DATES AND REASONS FOR REVISIONS

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

DESCRIPTIVE INFORMATION

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.

EQUIPMENT—TOOLS & GAGES

9. Check function of Safety (PERFORM CHECK THREE TIMES)
   1. Cock Rifle
   2. Move Safe to "ON" position.
      A. No catch. Good Detent.
   3. Pull Trigger
      A. No click or catch in pull.
      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.							

PART NAME Final Assembly COOLANT SET UP TIME 788 MODEL No. OPER. No. 175

TYPE Center Fire MACH. HRS. DEPT. No. 41 PAGE 2 OF 2

MACHINE Bench

BARBER - PRESALE R 0127518 R2528506
BARBER - PRESALE R 0127518

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

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-JCH/bdm-275943

DESCRIPTIVE INFORMATION

3. Before placing gun into device for test, check for proper operation of the safety.

(PERFORM THREE TIMES)

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 postion.
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.

BARBER - PRESALE R 0127519
BARBER - PRESALE R 0127519 R2528507

4

DATES AND REASONS FOR REVISIONS 2/13/67 - Retyped from 1/30/67 - 264391

10/24/67 - Chg. reading - NST - 265360 3/5/75 - Removed "Bolt Handle not unlock on safe" CP - 273834

2/21/68 - Add weight spec's - MT - 265 932 4/15/75 - Added to element #10 - Prosser - 273940

3/8/68 - Chg. dept. number - MT - 266011 6/25/75 - Added to element 10. - Burns - 274067

7/19/74 - Chg. dept. # - CP - 273250 5/9/77 - Add note to element 10 - CP - 275937

DESCRIPTIVE INFORMATION

9. 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.

10. Safe, gun cocked. (PERFORM CHECK THREE TIMES)

Clean sharp single detent
'On' back, cannot fire with heavy Trigger pressure.
Trigger must retract.
Release safe - Must not fire until Trigger is pulled
[redacted].
Safety should snap in Detent in both "on" and "Off" position.
Check Trigger pull - No creep($3\frac{1}{2}$ to $6\frac{1}{2}$)
Cock Rifle, move Safety to "ON" position, push forward halfway toward "OFF" position. MUST RETURN to "OFF" position under tension.

~~11. Stamp Final Inspect and Code marks on Left Side Barrel Rear~~

~~Sign gun tag~~ [redacted].

Push Safety to ON position, close Bolt with firm pressure. Safety must remain in ON position.

11. Stamp Final Inspect and code marks on left side Barrel rear . Sign Gun Tag.

To Warehouse

PART NAME Final Assembly COOLANT SET UP TIME MODEL No. 788 OPER. No. 310

TYPE MACH. HRS. DEPT. No. 55 PAGE 4 OF 4

MACHINE

Form R. D. 6466

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

BARBER - PRESALE R 0127521

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

(PERFORM CHECK THREE TIMES)

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".

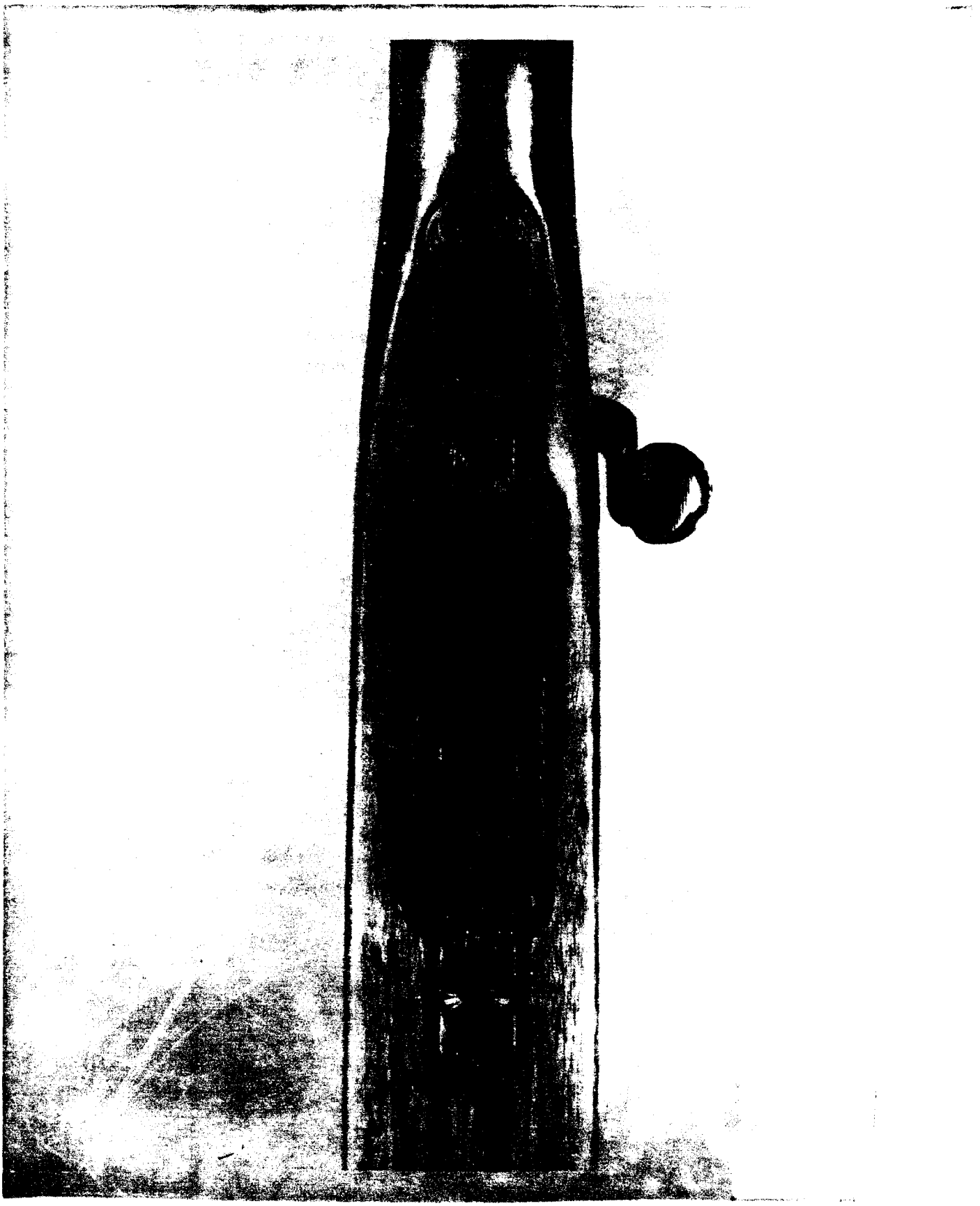
g. Push Safety Button forward from "off" position and remove Bolt from rifle.
1. Bolt must remove freely without bind.
- Insert Bolt into rifle
2. Must assemble freely without bind.

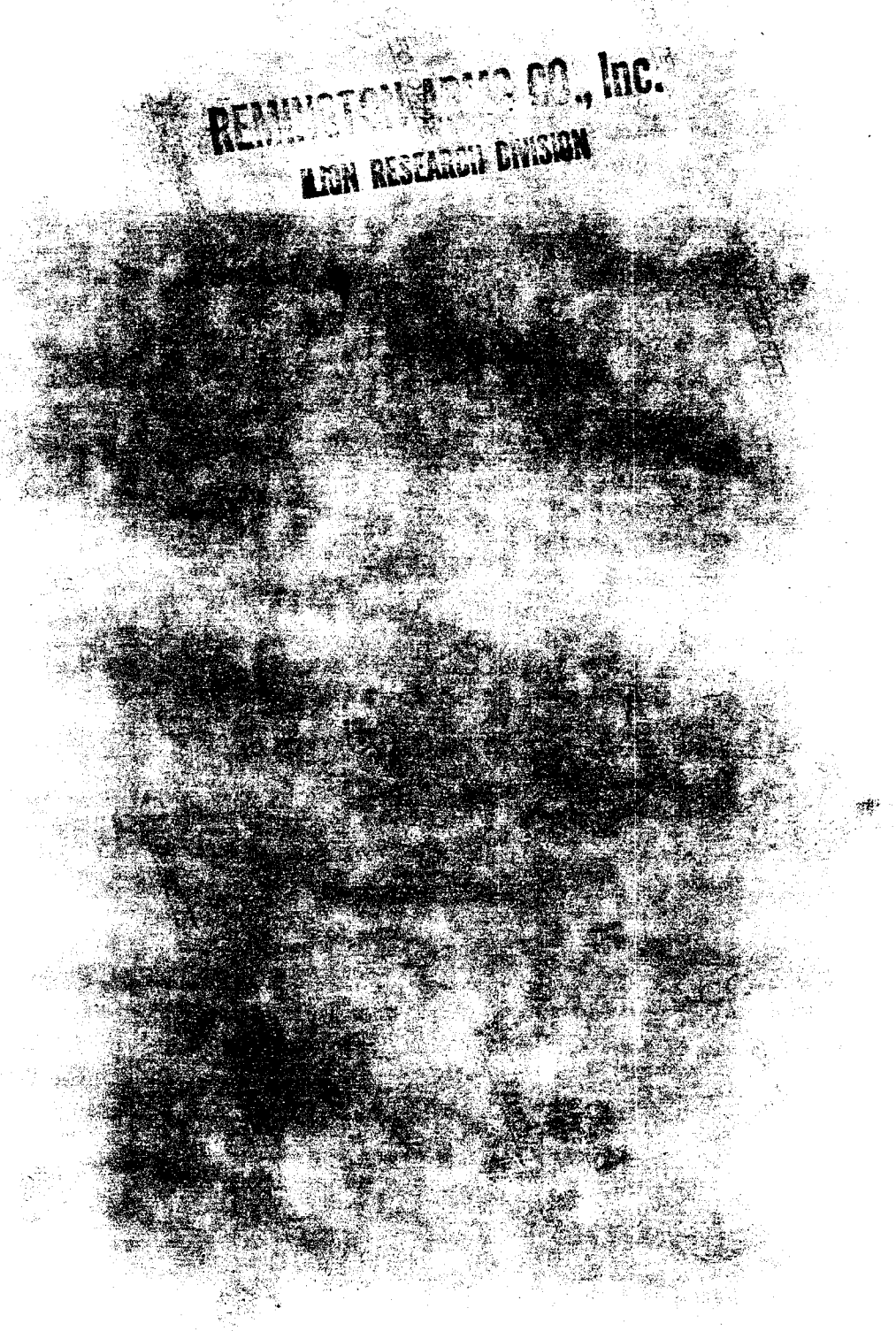
20. Trigger Pull
a. Open and close Bolt for cocking.
- pull Trigger.
1. Pull must be short and crisp.
2. Trigger must retract.

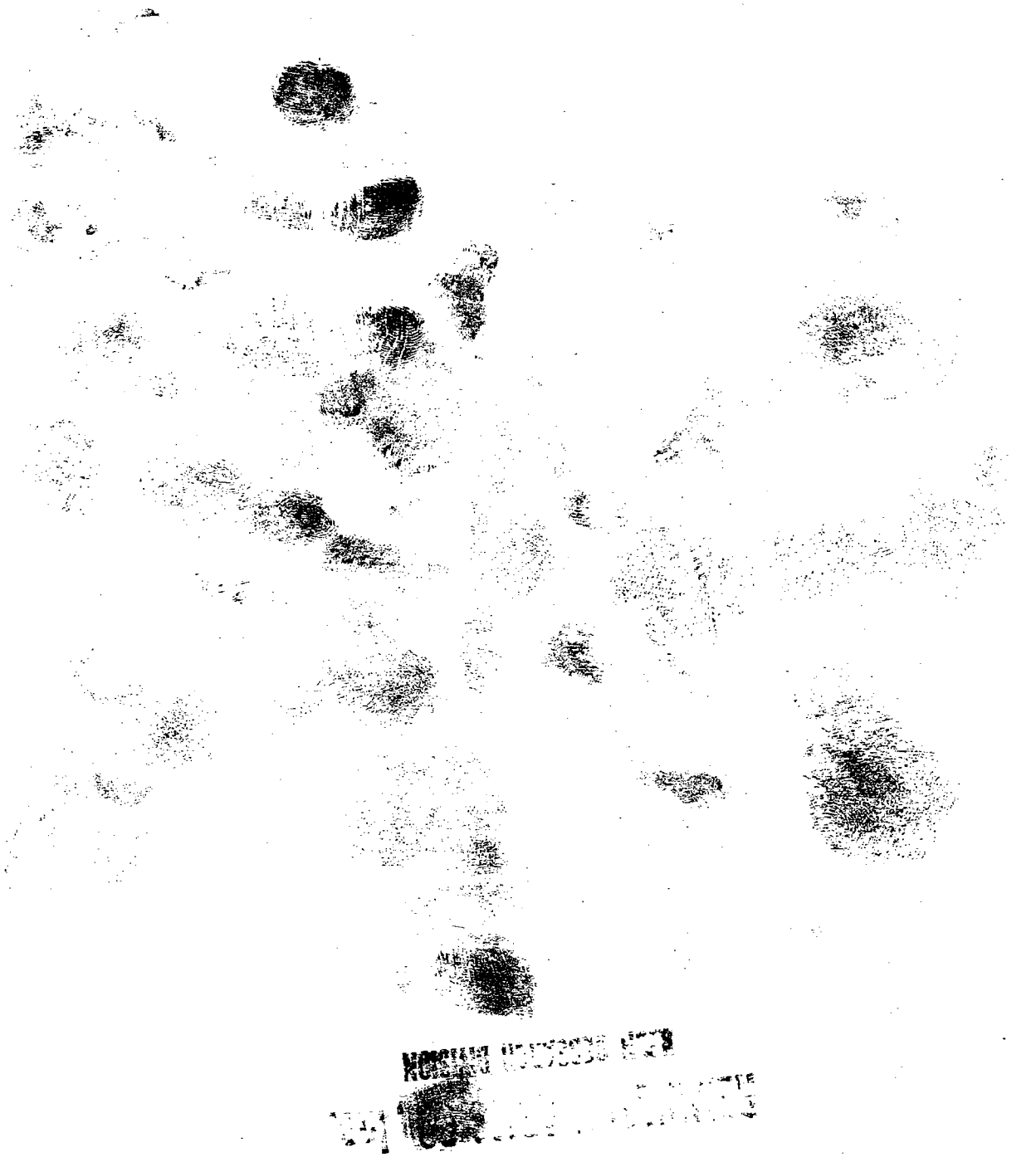
PART NAME I. Inspection Before COOLANT SET UP TIME MODEL No. 788 OPER. No.
TYPE Quality Audit Gallery Test. MACH. HRS. DEPT. No. PAGE 9 OF 11
MACHINE

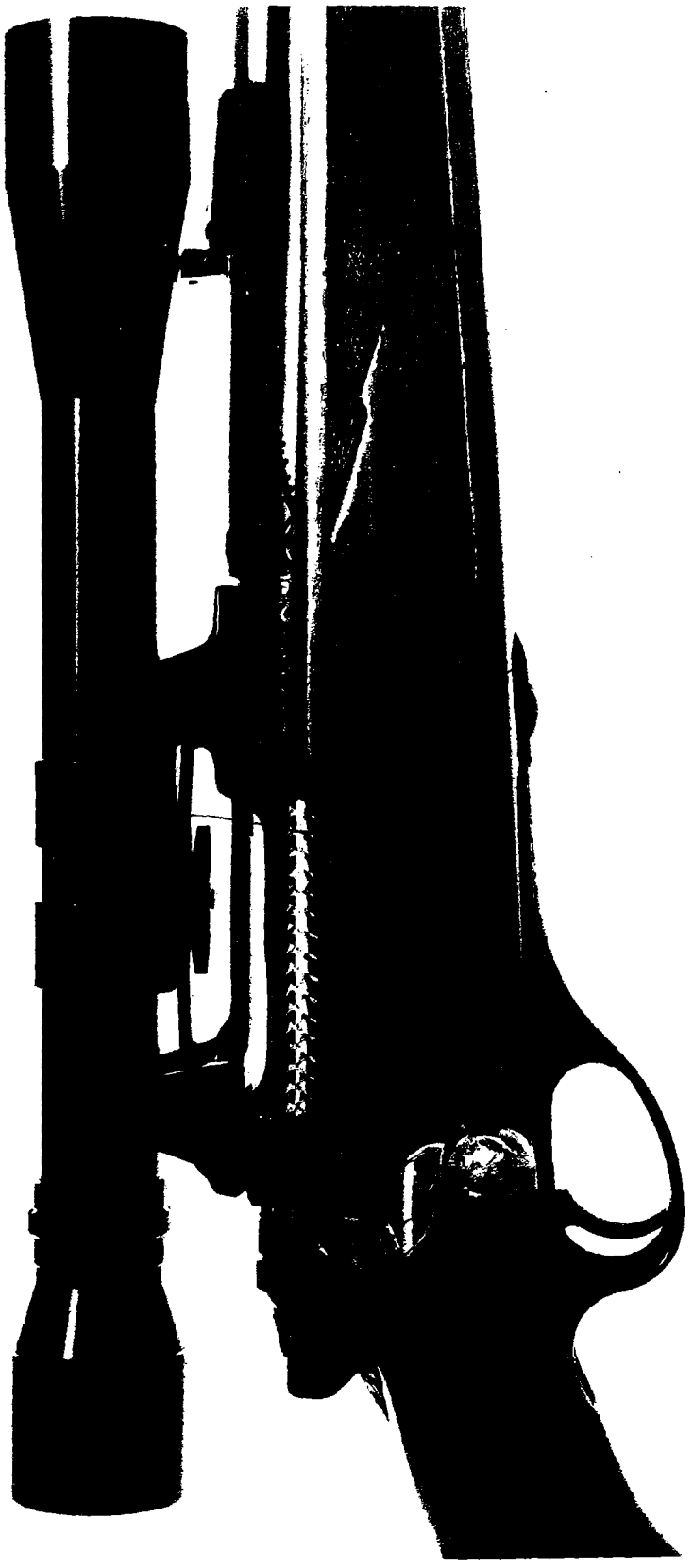
Form R. D. 6466

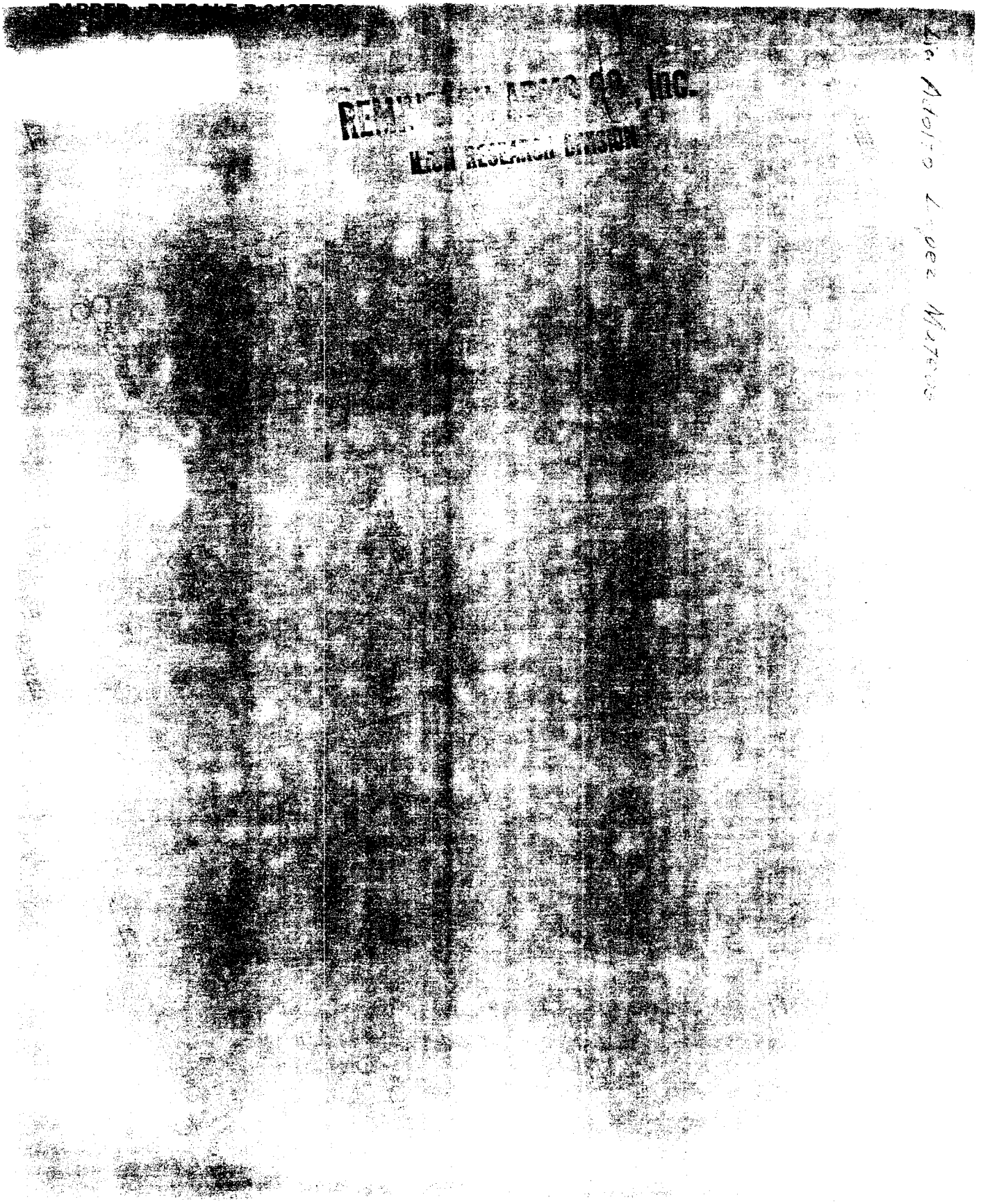
BARBER - PRESALE R 0127521-R528509

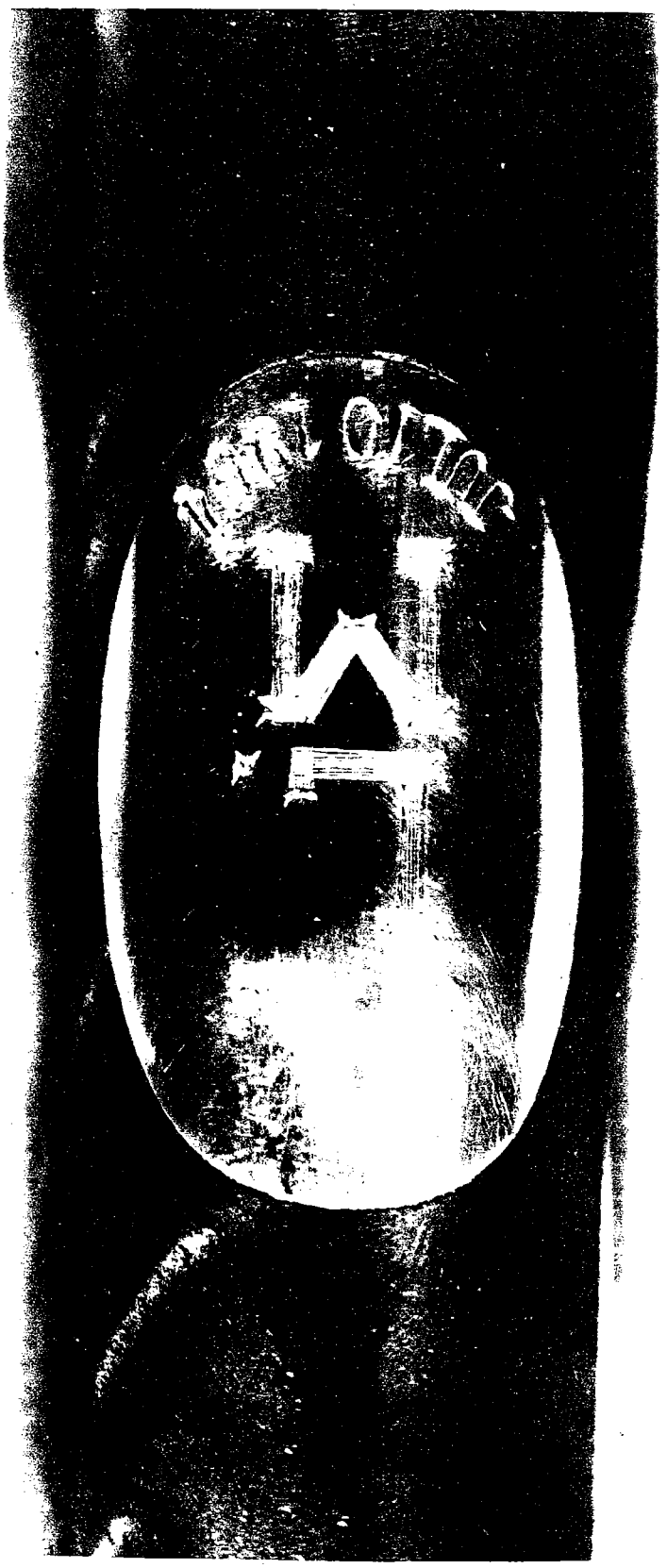



REMINGTON ARMS CO., Inc.
ARMS RESEARCH DIVISION









RD-69-B

REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE

Remington DUPONT PETERS DUPONT

"CONFINE YOUR LETTER TO ONE SUBJECT ONLY"

cc: Norman Wilson, Bridgeport
E. R. Carr
L. Fox
F. Plunkett

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 Sears. 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- w/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

Ark
Shipped 7/31/67

Called Ralph D McArthur
8:45 AM 7/3

BARBER - PRESALE R 0127530 [redacted] a 10K

TERMS: [redacted] [redacted]

SHIPPING ORDER

GOVERNMENT SALES DIVISION
REMINGTON ARMS COMPANY, INC.
BRIDGEPORT, CONNECTICUT 06602

REMINGTON ORDER NO. [redacted]

CUSTOMER ORDER NO. [redacted]

DISTRIB. BY GOVT. SALES	DISTRIB. BY BPT. PLANNING
MASTER GOVT. SALES FILE	WHITE PLNG. SPVSR.
4 CARB. SET [redacted]	WHITE TRAF. SPVSR.
1 WHITE U.S. INSPECTOR	WHITE WHSE. SPVSR. (2)
WHITE BPT. PLANNING	WHITE INSP. SPVSR.
[redacted]	

ORDER DATE [redacted] DATE TO PLANT [redacted]

DATE RCVD. [redacted] DATE ASSIGNED

MUST BE SHIPPED ON OR BEFORE [redacted]

SOLD TO [redacted]

SHIP TO [redacted]

SPECIFICATIONS, SCHEDULE & OTHER INSTRUCTIONS

"TO Number will be forwarded when received. Exemption Certificate will be issued"

$ - m/600

	GVT. INSP. AT PLANT	FED. EXCISE TAX		SHIP PREPAID		SHIP COLLECT	
	GVT. INSP. AT DEST.		INCLUDED	X	NO CHARGE		GOVT. B/L
	CERT. OF COMPL.	[redacted]			CHG. ACTUAL		COML. B/L
	GVT. LOT NOS. RQD.		NOT APPLICABLE		CHG. EQUALIZED		MARK TO CONVERT
	REM. LOT NOS. RQD.	X [redacted]		[redacted]	CHG. $		TO GB/L AT DEST.

ITEM NO.	DESCRIPTION	INDEX	ORDER QUANTITY	UNIT PRICE	$ AMOUNT	QUANTITY SHIPPED	NO. OF CASES
1.	[redacted]		[redacted]	[redacted]			
	[redacted]						
	[redacted]						
	[redacted]						

shipped 7/31

LOT NOS., CODES, ETC. [redacted]

DATE SHIPPED

NO. OF CASES

SHIPPING WEIGHT LBS.

CARRIER

RD-90 9/1/64

RD-69-8

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

5

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
Senior Engineer - Staff

VGD:I

RD-61-B

REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE

Remington DU PONT PETERS DU PONT

"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 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 PRODUCE 7/31	PRODUCED		BAL. TO PRODUCE IN SEPT.		IN PROCESS							
.308	292	~~37~~	38	256		0			1200 AT CUT-OFF				
.35	230	—	58	230		300							
6MM	834	526	552	308		521							
.243	1058	396	403	662		~~1900~~	← Bernie - Canary of these be changed to [illegible]? Key						
6.5	248	—		248		400							
223			70										
						2400							

7/31/67 Total Orders		Use for 67	Use #4 Fcst (1000) less than 3	A when stock 12/31	B Prod. Jan-July	Total avail. A+B	Bal. to produce 8/1	Use 19000 for cal yr.	A when stock 12/31	B Prod. Jan-July	Total Avail 7/31/67 A+B	Bal. to Produce
4860	33.2	35.0	7450	1659	4699	6358	1092	6650	1659	4699	6358	292
546	3.7	3.6	770	1816	160	1976	1206	690	1816	160	1976	1286
1779	12.1	12.0	2350	863	1403	2266	84	2090	863	1403	2266	176
272	1.8	2.0	420	150	—	150	270	380	150	—	150	230
2422	16.5	16.0	3480	540	1666	2206	1274	3040	540	1666	2206	834
4161	28.4	28.0	5950	861	3401	4262	1688	5320	861	3401	4262	1058
-				(17)	(59)	(76)			(17)	(59)	76	
634	4.3	4.4	940	579	3	582	358	830	579	3	582	248
14674			21300	6468	11332			19000	6468	11332		
			7450	2350	3420	5950	940	6650	1970	2266	3040	5320
			6358	2266	2206	4262	582	6358	690	2090	2206	4262
			1092	84	1214	1688	358	292	1286	176	834	1058
		1976							830			
		770		17800					582			
									548			

6/30/67 Total Orders		Use for '67		A White Stock 12/31	B Prod. Jan June	Total available A+B	Bal. to Produce					
4668	33.1	35.0	7800	1659	3862	5521	2279					
510	3.6	3.6	800	1616	160	1976	1176					
1705	12.0	11.0	2460	863	1402	2265	195					
241	1.7	2.8	440	150	—	150	290					
2379	16.8	16.0	3570	540	1658	2198	1372					
4062	28.8	28.0	6250	861	2777	3638	2612					
—				17	—	+7						
608	4.3	9.4	980	579	3	582	398					
14173			22300	6485	9962							

6/3/67

5/29/67 Total Orders		Use La 1967		A 12/31 whse Stock	B Prod. Jan-May	Total available A+B	Bal. to Produce						
4413	32.4	35.0	7800	1659	3520	5179	2621						
458	3.4	3.0	670	1816	159	1975	1305						
1628	11.9	11.0	2460	863	1398	2261	199						
239	1.8	2.0	440	150	—	150	290						✓
2323	17.1	17.0	3790	540	1214	1754	2037						
3957	29.0	28.0	6250	861	1729	2590	3660						
—				17	—	17	—						
596	4.4	4.0	890	579	2	581	309						✓
13614			22300	6485	8022	14507							
				7800	1975	2460	3790	6250					
				5179	670	2261	1754	2590					
				2621	1305	199	2036	3660					

5/4/67

Apr. 30 1967 Total orders		Max for 1967		A 12/31/66 White stock	B Prod. Jan-Apr.	A+B	Bal. to Prod.	½ Prod. sched				
3771	33.5	37.0	8250	1659	2678	4337	3913	4560				
354	3.2	3.0	660	1816	—	1816	1156	0				
1318	11.7	11.0	2460	863	1301	2164	296	0				
190	1.7	2.0	450	150	—	150	300	150				
1870	16.6	17.0	3800	540	1206	1746	2054	1200				
3721	28.7	25.0	5560	861	996	1857	3703	3150				
				17	—	17						
511	4.6	5.0	1120	579	2	581	539	300				
11235			22300	6485	6183	12668	10805					
				1816	2460	3800	5560	1120				
			660	660	2164	1746	1857	561				
			1156	1156	296	2254	3703	539				
			3913									

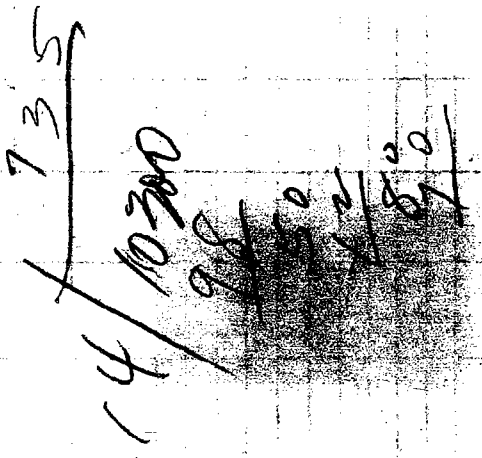
~~T-24~~ ~~8/24~~ T-9/18

M/600 Runout

4/11/67

~~T-4/29~~

1965	1966		Mar 31 1967		Use for 1967		A 12/31 whse	B Prod. Jan. Mar	A+B	Bal. to Prod.		#2 Prod. schedule			
308	[illegible]	[illegible]	3069	33.4	37.0	8250	1659	1874	3533	4717		5300			
350	[illegible]	[illegible]	270	2.9	3.0	660	1816	159	1975	1316					
222	[illegible]	[illegible]	1094	11.3	11.0	2460	863	570	1433	1027		760			
35	[illegible]	[illegible]	152	1.6	2.0	450	150		150	300		150			
614	[illegible]	[illegible]	1596	19.3	19.0	3800	540	1205	1745	2055		1200			
243	4442	19.8	2668	29.0	25.0	5560	861	941	1802	3758		3250			
223	12	.1	—				17		17	—					
6.5m	2938	13.1	410	4.5	5.0	1120	579	7	577	543		300			
Total	22380		9209			22300	6485								
							8250	2460	3800	5560	1120				
							3533	1433	1745	1802	577				
							4717	1027	2055	3758	543				



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. Boyle~~)
A.D. Kerr) In Turn
~~H.J. Hackman~~ (3)
F.T. Plunkett)
K. Greenlee) In Turn
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

John F. Finnegan
Ilion Research Division

JFF:gjp
Attach.

REVISED [illegible] 3-9-66 [illegible]

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.							
** Bedding	No Requirement.							
Barrel Bracket	Elevated type.							
Length (Nominal)	18-1/2"							
Diameter (O.D.)	[illegible]							
Bore (in.)		.300 min.	.237 min.	.219 min.	.349 min.	.237 min.		.219" min.
		.302 max.	.238 max.	.220 max.	.351 max.	.238 max.		.220" max.
Groove (in.) (6)		.308 min.	.243 min.	.2240 min.	.357 min.	.243 min.		.224" min.
		.310 max.	.244 max.	.2250 max.	.359 max.	.244 max.		.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.							

** Per W.E. Leek.

[illegible] authorizing bedding specifications.

Revision- Production & Research Division agreement of 3-7-66 per R.P. Kelly.

RO-6489

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON
BARBER - PRESALE R 0127542 R2528530

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.		
** 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.)		.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.		

** Per W.E. Leek.
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.

RD-6489

BARBER - PRESALE R 0127542

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.

References: Operations Committee Min. #6-1966, dated 3-9-66.

John F. Finnegan

John F. Finnegan
Ilion Research Division

JFF:gjp
Attach.

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON
BARBER - PRESALE R 0127544
R2528532

BARBER - PRESALE R 0127544

Orig. 7-1-65
REVISED 12-14-65 3-30-66

REMINGTON STANDARDS - ARMS

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").
*Ref: Genl.Mgt. approved release to Production of 6.5MM Rem.Mag. June 8, 1965.
** Per W. E. Leek 12-14-65 (Verbal)

RD-6489

CC: A. B. 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 - BREECH 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.

R. W. Williamson Chairman

H. J. Hackman

HJH:I

cc. J. E. Dickey
H. J. Blackman
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 extraction 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,

DLB

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 Hackman~~

RD-69-F

REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE

Remington DUPONT

~~L. J. Boyle~~
~~A. D. Kerr~~

St. Louis, Missouri
January 13, 1966

TO: F. E. MORGAN

FROM: G. T. PORTER

SUBJECT: TEST RESULTS OF MODEL 600 [illegible] 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 contribute 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 [redacted] RETURN

DATE Dec. 17, 1965

QUANTITY 13 LETTER NO. 993

MODEL 600 CAL./GA. 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 [redacted] 1, 1965 to your attention.

Above Research work order should be credited.

JAR:SMA:T

S. M. Alvis

RD-69 REV. 6-58

REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE

Remington DUPONT

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

Bridgeport, Connecticut
December 1, 1965

TO: A. D. KERR - ILION

Copies: R. A. Williamson (1)
W. W. Fenton (2)
12/2/65

FROM: F. E. MORGAN

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

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. of 12/13

REMINGTON ARMS COMPANY, INC.
Ilion Research Division
July 7, 1965

J. D. Mitchell
F. E. Morgan
E. 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 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.

J. F. Finnegan
Ilion Research Division

JFF:T
Attach.

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

BARBER - PRESALE R 0127551

BARBER - PRESALE R 0127551

Orig. 7-1-65
REVISED

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		?				
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			--		--				

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

RD-6489

R2528539

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

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.		

BARBER - PRESALE R 0127552
BARBER - PRESALE R 0127552
R2528540

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON
BARBER - PRESALE R 0127553 R252854

BARBER - PRESALE R 0127553

Orig. 7-1-65
REVISED

MODEL 600 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)	37 1/4" (Nominal)						
- Weight			6 1/2 lbs.		6 1/2 lbs.			
MAGAZINE	Fixed - Top Loading							
Capacity			3		3			
Follower	Bright plate.							

RD-6489

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON
BARBER - PRESALE R 0127554
R2528542

Orig. 7-1-65
REVISED

REMINGTON STANDARDS - ARMS

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.Data)	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	

RD-6489

BARBER - PRESALE R 0127554

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON
BARBER - PRESALE R 0127555 R2528543

BARBER - PRESALE R 0127555

Orig.: 7-1-65
REVISED

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 5663	
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 MARKINGS-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.	

RD-6489

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, O.D.	Yes	Yes
Description	7/8" O.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.	
Eyepiece	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
KINZER V. REMINGTON
BARBER - PRESALE R 012755
R2528544
BARBER - PRESALE R 012755

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

BARBER - PRESALE R 012755 7 R2528545

BARBER - PRESALE R-012755

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 mold.								

RD-6469

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 200 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.

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

BARBER - PRESALE R 0127559

BARBER - PRESALE R 0127559

REVISED 11-20-64 7-1-65 **REMINGTON STANDARDS - ARMS** SHEET 1

MODEL 600		308 Win.	6MM Rem.	222 Rem.	35 Rem.	243 Win.		223 Rem. (Export only)
ACCURACY								
Range	100 yards							
Point of Aim	6 o'clock on target.							
Center of Impact	Not more then 2 inches below or 4 inches above or 3 inches either side of point of aim.							
Group Size (E.S.)	5 shots in:	3 1/2"	2 1/2"	2 1/2"	3 1/2"	2 1/2"		2 1/2"
	4 shots in:	3"			3"			
Ammunition		180 gr. PSP	100 gr. PSP	50 gr. SP	200 gr. SP	100 gr. PSP		55 gr. SP
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.		1964		1964	1964	1965		
June			1964					1965
Warehouse Date								

RD-4489

R2528547

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

BARBER - PRESALE R 0127560

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

BARBER - PRESALE R 0127560 R2528548

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

BARBER - PRESALE R 0127561

REVISED 11-20-64 7-1-65

REMINGTON STANDARDS - ARMS

MODEL 600		308 Win.	6MM Rem.	222 Rem.	35 Rem.	243 Win.		223 Rem. (Export only)
BUTT PLATE	Black plastic							
EJECTOR	Plunger type - spring loaded and pin assembled in bolt head.							
EXTRACTOR	Riveted to bolt.							
FIRING PIN	Spring retracted in bolt.							
Protrusion	.045 min. - .075 max.							
Indent	.018 min. - .026 max.		(using copper crusher)					
GUN - Length (Overall)	37 1/4" (Nominal)							
- Weight	5 1/2 lbs. (Nominal)							
MAGAZINE	Fixed - top loading							
Capacity		4	4	5	4	4		5
Follower	Bright plate.							
Spacer		No	No	Yes	No	No		Yes

RD-6489

BARBER - PRESALE R 0127561
R2528549

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON
BARBER - PRESALE R 0127562
R2528550

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 "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	Patent Pending.					

RD-6469

BARBER - PRESALE R 0127562

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON
BARBER - PRESALE R 0127563
R2528551

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. 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 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.							

RD-6489

BARBER - PRESALE R 0127563

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON
BARBER - PRESALE R 012756 4
R2528552

MODEL 600	308 Win. 6MM Rem. 222 Rem. 35 Rem. 243 Win.	223 Rem. (Export only)
SAFETY	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).	
SERIAL NUMBER	(Start 1000)	
Location (1)	See MARKING - Receiver.	
(2)	See MARKING - Bolt.	
SLING STRAP	As accessory at extra cost.	
Description:	7/8" OD type same as used on M/700. Leather material.	
SIGHTS	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.	
Eyepiece	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.	

RD-6489

BARBER - PRESALE R 012756 4

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

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.							

RD-6489

BARBER - PRESALE R 0127565
R2528553

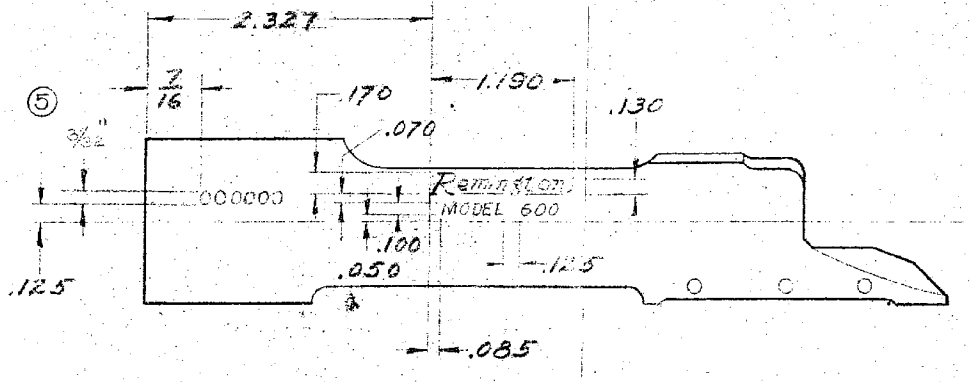
CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

B-15482

MODEL	CALIBER	ASS'Y NO.	RECEIVER NO.	
600	308 WIN	26680	15406	
600	222 REMINGTON	26681	15787	(2)
600	35 REM	26682	15406	(3)
600	6MM REM	26683	15406	
600	350 REM MAG	26684	15406	(7)
600	243 WIN	26685	15406	(6)
600	6.5MM REM. MAG	26686	15406	(8)

DO NOT SCALE THIS DRAWING. WORK TO FIGURES.
UNLESS OTHERWISE NOTED, TOLERANCES ON DECIMAL DIMENSIONS ARE ±.005
& ON FRACTIONAL DIMENSIONS ± 1/64
& ON ANGULAR DIMENSIONS ± 00°-30'
FINISHES ARE DESIGNATED BY ROOT MEAN SQUARE (R.M.S.) MICRO-INCH ROUGHNESS VALUES AND ARE THE MAXIMUM ROUGHNESS ACCEPTABLE. UNLESS OTHERWISE SPECIFIED, FINISH ROUGHNESS TO BE 125 V OR BETTER.

ALTERATIONS				
LET.	WAS	REFERENCE	BY	DATE
1	Added	5013	[illegible]	[illegible]
2	222 Rem	5213	[illegible]	3/16/62
3	Added 35 Rem	5213	[illegible]	3/16/62
4	Added 6MM Rem	5566	[illegible]	2/12/64
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 RJ 3/29/62	CHECK BY DATE	APPR. BY DATE WL 4/5/62
TITLE: RECEIVER MARKING			
NUMBER: B-15482	SCALE: FULL	SUPERSEDES—REFERENCE	
	REMINGTON ARMS CO. INC. RESEARCH & DEV. DEPT.		

FB-1 REV. 2

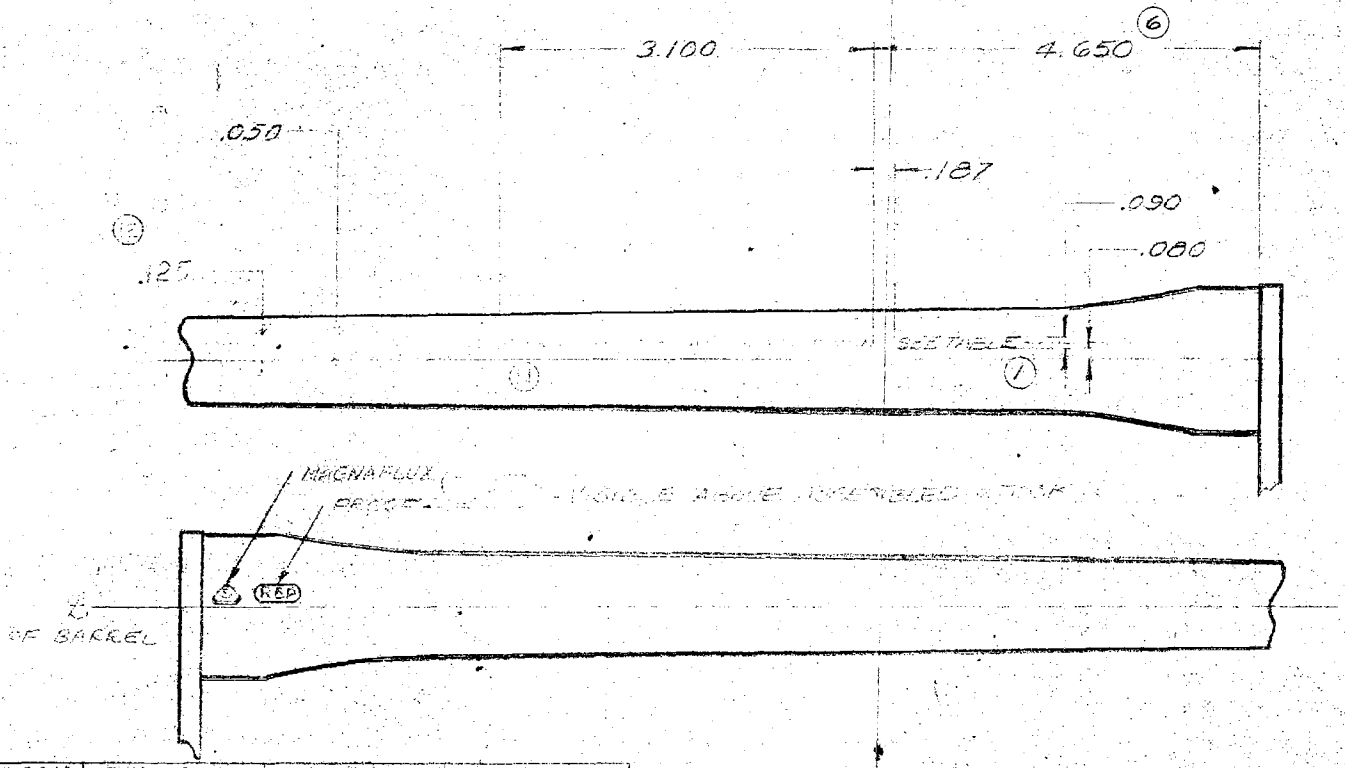
B-15482

BARBER - PRESALE R 01275662528554
BARBER - PRESALE R 01275662

B-15729

DO NOT SCALE THIS DRAWING. WORK TO FIGURES UNLESS OTHERWISE NOTED. TOLERANCES ON DECIMAL DIMENSIONS ARE ±.005 & ON FRACTIONAL DIMENSIONS ± 1/64 & ON ANGULAR DIMENSIONS ±00°-30'. FINISHES ARE DESIGNATED BY ROOT MEAN SQUARE (R.M.S.) MICRO-INCH ROUGHNESS VALUES AND ARE THE MAXIMUM ROUGHNESS ACCEPTABLE. UNLESS OTHERWISE SPECIFIED, FINISH ROUGHNESS TO BE 125 √ OR BETTER.

NOTE:
DIMENSIONS ARE TO OUTSIDE OF IMPRESSION



ALTERATIONS

LET.	WAS	REFERENCE	BY	DATE
1	.308 WIN	5013	HJW	10/29
2	Added	5013	HJW	10/29
3	222 Rem	5213	HJW	9/22/63
4	Add use 35 Rem	5213	HJW	3/22/63
5	222 Rem Mag	5292	HJW	9-26
6	3.187	5262	HJW	5-16
7	ADDED PROOF & MAGNAFLUX	5526	JF	1/15-64
8	Added 6mm	5566	HJW	3-12
9	ADDED M600 35 REM MAG	5717	HJW	6-24
10	.35 REM. MAG.	5739	V.F.	7/2/64
11	PAT. PENDING	5764	V.F.	7/13-64
12	ESTABLISHED CENTER LINE	"	"	7/14/64
13	ADDED 243 WIN.	5842	"	10/23-64
14	ADDED 6.5mm REM MAG	6075	JF	5/17/65
15	ADDED 223 REM "EXPORT"	6129	"	5/28/65

	MODEL	CALIBER	BBL. NO.	ASS'Y NO.
15	600 "EXPORT"	223 REM.	26697	26687
14	600	6.5mm REM. MAG.	26696	26686
10	600	243 WIN.	26695	26685
9	600	350 REM. MAG.	26694	26684
8	600	6MM REM	26693	26683
	600	35 REM	26692	26682
5	600	222 REM	26691	26681
	600	308	26690	26680

TFB-1 REV. 2

MODEL	PART USE	QUAN.	SEE
600	BBL. MARKING		

DEG'D BY DATE	DRAWN BY DATE	CHECK BY DATE	APPR. BY DATE
	HJ 3/29/62		WL 4/5/62

TITLE: BARREL MARKING

NUMBER: B-15729

SCALE: FULL

SUPERSEDES—REFERENCE

REMINGTON ARMS CO. INC.
RESEARCH & DEV. DEPT.

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON
BARBER - PRESALE R 0127567
R2528555

CC: S. M. Alvis N. W. Menard
L. J. Boyle R. B. Hurley
A. D. Kerr W. Scanlon

Ilion, 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 ± 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.

Form RD5845

REMINGTON ARMS COMPANY, INC.

ENGINEERING DEPARTMENT COMPUTATION SHEET SHEET NO

TITLE OF PROJ M/700 & M/600 Finish Gun Weights PROJ NO

SUBJECT ADL & BDL Grade of Calibers WORKS

Warehouse Audits by W. Scanlon DATE 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.	7-9½	6-15½	7-3.2	6-12		7-9	7-3½	7-6.8	6-12	
222 Rem.	24" "	7-4½	7-2	7-2.8	6-12	6-12	7-10½	7-4	7-8.5	6-12	7-0
222 Nikko	24" "	7-3½	7-0	7-2.0	6-12	6-12	7-9½	7-4	7-6.0	6-12	7-0
Average	24" "	7-9½	6-15½	7-2.7			7-10½	7-3½	7-7.2		
6mm	22" Short Rec.	7-1½	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" "	6-14½	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	7-3½	7-4.0	7-12	7-8	7-12	7-9½	7-11.1	7-12	7-12
264 Win	24" "	7-14	7-6½	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	7-3½	7-7.0			7-12	7-9½	7-11.1		
270	22" Long Rec.	7-1½	6-11	6-15.3	6-12	6-14	N.A	N.A	N.A	6-12	7-2
280	22" "	7-5½	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	6-14½	7-1.7	6-12	7-2
Average	22" "	7-5½	6-11	6-15.2			7-12	6-14½	7-3.6		
600											
222	18½" Short Rec.	6-2½	6-0½	6-1.5	5-8	5-8					
6mm	18½"	6-4	5-13	6-0.8	5-8	5-8					
243	18½"	6-5	5-13	6-1.1	5-8	5-8					
308	18½"	6-1	5-11	5-14.2	5-8	5-8					
35	18½"	5-12½	5-7½	5-9.9	5-8	5-8					
Average	18½" Carbines	6-5	5-7½	5-15.1							
350 Mag.	18½" Hammerless	6-10	6-7½	6-8.6	6-8	6-8					

4/6/65

Form RD5845

REMINGTON ARMS COMPANY, INC.

ENGINEERING DEPARTMENT COMPUTATION SHEET

SHEET NO. M/600

TITLE OF PROJ M/700-600 Wire Audit - Gun Weight

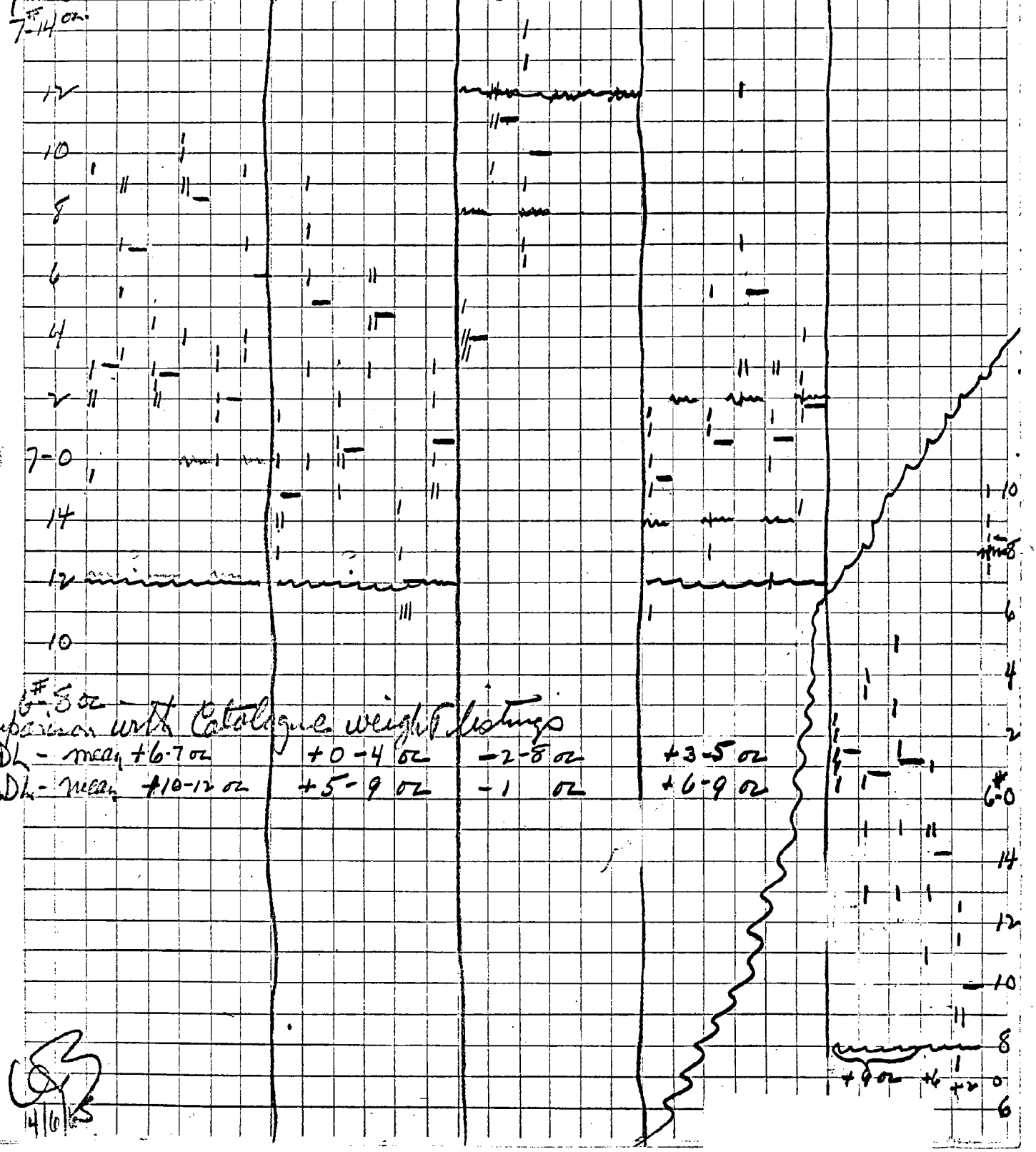
PROJ NO

SUBJECT M/700

WORKS

Cal. - 22-250 222 222M 6mm 243 308 COMPUTER 7mm 264 300W 270 DATE 280 300 6 222 6mm 243 308 35 350

Grade - A B A B A B A B A B A B A B A B A B A B A B A B A B



Comparison with Catalogue weight listings

ADL - mean	+6-7 oz	+0-4 oz	-2-8 oz	+3-5 oz
BDL - mean	+10-12 oz	+5-9 oz	-1 oz	+6-9 oz

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.

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

CC: L. J. Boyle
T. H. Pratt
L. Fox
R. L. Wright
F. H. Byrnes
A. B. Kerr
K. Greenlee
B. Gilbert
M. 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 /600

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

R. J. Long
Methods & Standards Section

RJL:sm

OK in effect.

CC: S. M. Alvis
~~A. D. Kerr~~
F&B

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

RD-69 REV. 6-58

REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE

Remington DUPONT

11/25/64

cc: P. H. Burdett
R. B. Bowie
J. B. Cadenas

RECEIVED
NOV 1 9 1964
OFFICE - F. E. MORGAN

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:

Calibers	Units
243	350
222	550
6mm	100
308	600
35 Rem	100
	1700

Copy for Ken Grunler (2)

cc: P. H. Burdett
R. B. Bowie
J. B. Cadenas

RD-69 REV. 6-58

REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE

Remington DUPONT

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.

WDV:Ja

Warehouse - March 1st
forecast by acct. required.

REMINGTON ARMS COMPANY, INC.
INTER-DEPARTMENTAL CORRESPONDENCE
Remington

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 1 to Germany in Oct.

WDV:ja

4/3 - H. Hackman checked - will follow

4/22 - W. A. Best, Chvld

7/23 - No release yet.

9/1 - No release; Hackman will follow-up with Vuono (Export) re present status

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

BARBER - PRESALE R 0127577 R2528565

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

cc - H J Hackman

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.G. copy as many as req'd. A

Shipped Prem & Nov

(2) A D KERR
46-1

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.

RAW

R. A. WILLIAMSON
WORKS MANAGER

RAW md

~~check Trig. guard with Wayne~~

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

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

LIMITED DISTRIBUTION

[redacted]

[redacted]

[redacted]

CC: L. J. Boyle, R. J. Chesebrough, E. J. Mock, T. H. Pratt, F. H. Byrnes, A. D. Kerr, R. Gilbert, K. Greenlee, F. Plunkett, A. Barnes, H. J. Hackman, V. G. DeReus, R. B. Hurley, J. Hill, R. Burger, P. Nielsen, R. Pugh, J. Smyder

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. — J. Smyder
     2. M/600 Barrels 6MM - to be processed same as the Model 700 Barrels 6MM. Process Records to be established. — 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

Remington DUPONT

3 Copy Gilbert Plunkett Kerr

21 April 1964

Haven't any idea as to why I received this letter = 4/24

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 McCauley or Pete Morgan mentioned to you that the stock on one of these was broken before the banquet.

Very truly yours,

J. P. Linduska
Dir. of Public Relations
and Wildlife Management

JPL/jb
cc: Pete Morgan
Virgil Agostinelli

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 2½" specification.

Management approval to make warehouse shipments is requested.

R. A. Williamson

R. A. WILLIAMSON
WORKS MANAGER

VQDeReus:I

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

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)													

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

Remington Farms

A. O. Kerr

DR. J. P. LINDUSKA
DIRECTOR OF WILDLIFE MANAGEMENT

CHESTERTOWN • MARYLAND 21620
Remington

3 Copy Gilbert Fleming Kerr

21 April 1964

Haven't any idea as to why I received this letter ≡ 4/24

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

Harvey - I assume Ted McCauley or Pete Morgan mentioned to you that the stock on one of these was broken before the banquet.

Very truly yours,

J. P. Linduska

J. P. Linduska
Dir. of Public Relations
and Wildlife Management

JPL/jb
cc: Pete Morgan
Virgil Agostinelli

P. & C. ESTIMATE

ADRERR
R.L. Hall

TO: H.J. Hackman

ESTIMATED BY: VG DeReus

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 - Coins 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			1200
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 1C 0000 on other side marking roll and added machine set ups
Stock process given to M & S by P Nielsen

CC: E. E. Folmsbee R. Stafford A. D. Kerr J. Scanlon
R. W. Pugh

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 [Iron Cross] - 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

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KINZER V. REMINGTON

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

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KINZER V. REMINGTON

~~R. A. Williams~~
~~C. B. Potsky~~
~~A. D. Kerr~~

RD-69 REV. 6-58

REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE

Remington DUPONT

Prairie Village, Kansas
November 6, 1963

R. A. Gilbert

TO: HARRY HACKMAN

FROM: GENE T. PORTER

SUBJECT: MODEL 600 FIELD TEST

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 muzzel 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..

Gene

A. D. Kerr

RD-61-B

REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE

Remington DUPONT PETERS DUPONT

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.

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 $40.39 per gun.

R. A. Williamson
Works Manager

R L Hall

R. L. Hall, Supervisor
Methods & Standards Section

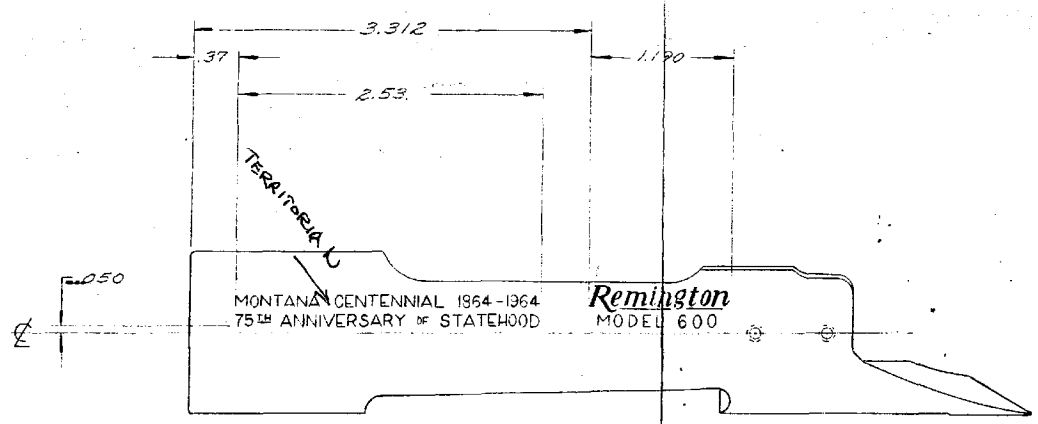
RFKerr:sm

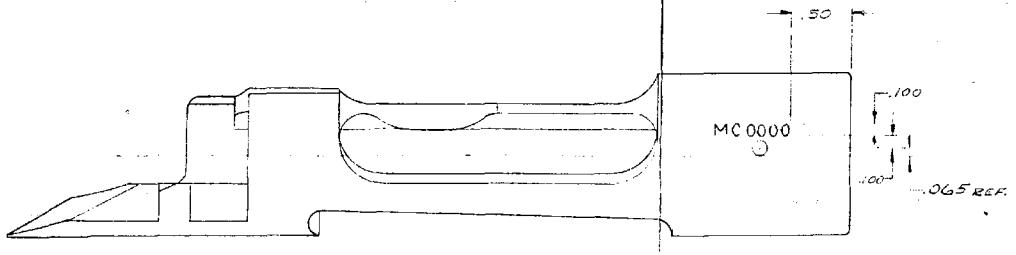
NOTE TO C. L. JONES:
Two sample stocks are being held by R. C. Gilbert, Ilion, awaiting Bridgeport instructions for disposition.

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

BARBER - PRESALE R 0127593

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 ± .05
2 PLACE	(.01) — TOLERANCE ± .015
3 PLACE	(.001) — TOLERANCE ± .0005

RECORD OF ALTERATIONS	ADDITIONAL USES	CONST'N. DWG.
		DETAILS

REMINGTON ARMS COMPANY, INC., ILION, N. Y.

SCALE	MODEL	PART DWG. NO.
PART		
TOOL		
OPERATION		

	BY	DATE		BY	DATE
DESIGNED			APPROVED		
DRAWN			SUPD'S DWG. NO.		
CHECKED			DRAWING NO. B-		

Form R. D. 5204-Rev.

BARBER - PRESALE R 0127593
R2528581

FEB 6 1964

FE

FEB 6 1964

for project economics

m/600	1st	2nd.
	7500	15000
30 8	7500	5000
22 2		4000
30.30		6000

5/1 whisc.

RD-68 REV. 6-63

REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE

Remington

Gail Evans
W. H. Foster
F. E. Morgan

Bridgeport, Conn.
April 23, 1963

Mary: Copies per below, pls
DEM
SMA - WEC
HVH - VGD
AVB - SMA
① Ship - Labels - 308 ~~222~~ 35 Rem
② Ken Please note.
A
Ok Trip
XEB

TO: 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

9:30 Friday

1/9/63

RD-6514

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 Prog.	Raw Stores	
D-26680*		BARREL ASSEMBLY		0	0	
D-26690*		Barrel (Marking B-15729)	1223 308	200 296	0	
B-15279		Barrel Bracket		—	—	
B-15724		Barrel Stud	6	—	—	
D-15406*		Receiver (Marking B-15482)	—	[illegible]	0	300 - VVV 300 - 308
N-26700*		BOLT FINAL ASSEMBLY 00 300 .308		[illegible]	[illegible]	
D-26705*		BOLT ASSEMBLY		0	0	
D-26710*		BOLT BODY ASSEMBLY		0	0	
C-15407		Bolt Body		—	—	
A-18493		Bolt Body Brazing Slug		—	—	
C-15479		Bolt Head		—	—	
A-18758		Bolt Pin		—	—	
B-17011		Ejector Washer		—	—	
D-15408		Bolt Handle		—	—	
A-20185	20186	Brazing Shim		—	—	
A-17017		Ejector		—	—	
A-17676		Ejector Pin		—	—	
A-17019		Ejector Spring		—	—	
B-16254		Extractor		—	—	
A-19629		Extractor Rivet		—	—	
N-26715		FIRING PIN ASSEMBLY		—	—	
C-15409		Bolt Plug		—	—	
B-15410		Firing Pin		—	—	
A-17022		Firing Pin Cross Pin		—	—	
B-23320	23321	Firing Pin Head		—	—	
A-15411		Main Spring		—	—	
C-15412*		Bolt Stop		525	0	complete
A-15413		Bolt Stop Spring		—	—	
B-24475	24477	Bolt Stop Pin		—	—	
B-15414*		Front Guard Screw	complete	500	2200	
B-27365*		FRONT SIGHT ASSEMBLY		0	0	order 700 to complete
B-15754*		Front Sight		5350	0	
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		—	—	
C-17056		Magazine Follower		—	—	
C-17891		Magazine Spring		—	—	
A-17580		Rear Guard Screw		—	—	

Prepared By HLC | Approved By WEL

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

1/9/63

RD-6514

PARTS LIST	MODEL 600 Bolt Action - Center Fire Rifle	DATE 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 PROC.	RAW STOCKS	
C-26840	26841	REAR SIGHT ASSEMBLY		—	—	
A-15733		Elevation Screw		—	—	
C-15727		Rear Sight Base		—	—	
C-15726*		Rear Sight Eyepiece		500	0	Limb 4 hrs
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	HHB
N-26590		SEAR & SAFETY CAM ASSEMBLY		—	—	
B-15369		Safety Cam (Blank 1B-17945)		—	—	
2B-17946		Sear (Blank 1B-17946)		—	—	
A-17047		Sear Spring		—	—	
C-15435*		Trigger		500	0	HHB
A-17049		Trigger Adjusting Screw	2	—	—	
A-15436*		Trigger Connector		500	0	Completed
B-24475	24477	Trigger Pin		—	—	
A-17978		Trigger Spring		—	—	
B-17053		Trigger Stop Screw		—	—	
D-15437		Trigger Guard		—	—	

Prepared By HLC | Approved By WEL

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

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:

	Stock with F.E. Tip and Spacer	Stock without F.E. Tip and Spacer
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 STEEL WITH AND WITHOUT FORE-END TIP AND SPACER

	EST. COST PER 100 WITH FE TIP	EST. COST PER 100 WITHOUT FE TIP
MATERIAL - STD	$ 168.114	$ 150.000
- VAR (3%)	5.043	4.500
TOTAL MAT'L.	$ 173.157	$ 154.500
LABOR - STD	87.561	81.694
- VAR	34.143	31.251
TOTAL LABOR	$ 121.704	$ 114.945
DIRECT EXPENSE (ACT)	118.897	105.848
IND RELATIONS (35%)	42.596	40.231
ALLOC BURDEN	45.703	43.166
DIRECT CHARGES (33.3% STD LABOR)	29.158	27.537
MFG OVERHEAD (31.9% STD LABOR)	27.319	25.801
SUB-TOTAL	$ 558.529	$ 512.028
PLANT OVERHEAD (22%)	123.436	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	$ 600	—
VENDOR (MOLDS)	1400	—

R. KERR 3/14/69

Follow up please for M/600

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 WELeek 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

RFKerr:sm

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

M/600 - Barrel Bracket

RESPONSIBILITY

MODEL 600

350 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

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

RESPONSIBILITY

350 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. — Production

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

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 & 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 & 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.

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:	Burger
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

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

CC: L. J. Boyle
T. H. Pratt
L. Fox
[illegible] Wright
F. H. Byrnes
[illegible] Kerr
[illegible] Greenlee
[illegible] Gilbert
[illegible] Hackman
V. G. DeReus
D. B. Hurley
[illegible] 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

RD-69 REV. 6-58

REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE

Remington

cc: J. E. Preiser
C. B. Workman

Jill Linde

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.

H. D. Albaugh

HDA/ap

5/22/78 - Larry making Samples - copy of letter to Brooks

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
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.

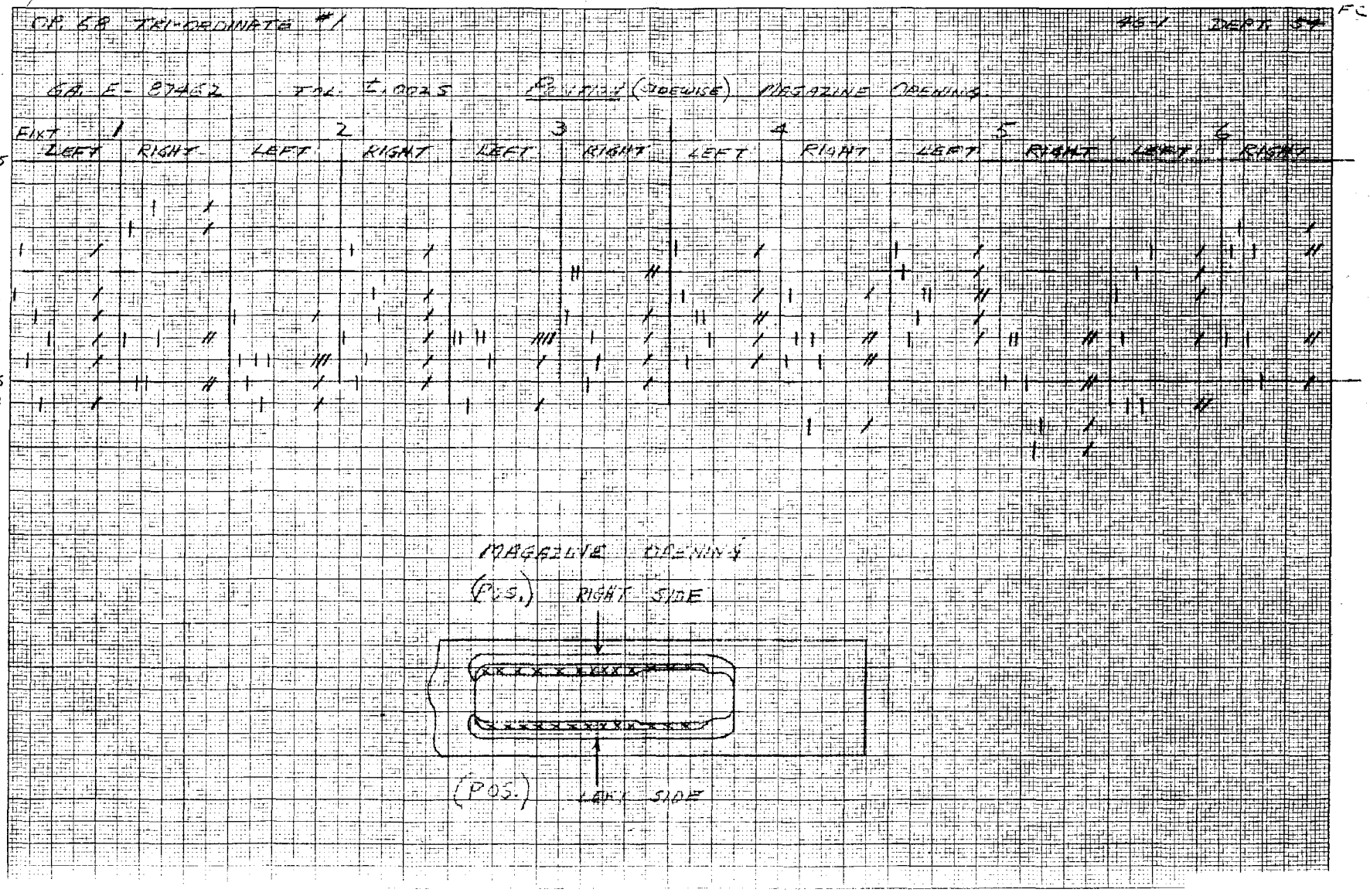
Attached is a partial machine study on pertinent characteristics of the Magazine opening which are believed associated with the referenced 50 demerit item.

The measurements indicate that an uncontrollable condition currently exists.

by H. K. Boyle
H. K. Boyle, Supervisor
Quality Control Department

HKB/bd
Attachs.

M/600 RECEIVER # 15405 TRI-ORDINATE # 27600 SHEET 1 3-24-71



K+E 10 X 10 TO ½ INCH 47 1323
10 X 15 INCHES MADE IN U.S.A.
KEUFFEL & ESSER CO.

M/600 RECEIVER # 15406 TRI-ORDINATE # 29600 SHEET 2 3-24-71

OP. 6B TRI-ORDINATE #1 464 DEPT. 54 FC

GA. C-50792 V (PLUG) DIM. .968-.978 WIDTH OF RECESS (Mag Box opening)

FIXT.	1	2	3	4	5	6
UNDER	I		I	I		
OK	I I III	III III	I I III	II III	III III	III III
OVER						

GA. C-54525 V (PLUG) DIM. 2.9362/2.9440 LENGTH OF RECESS (Mag Box opening)

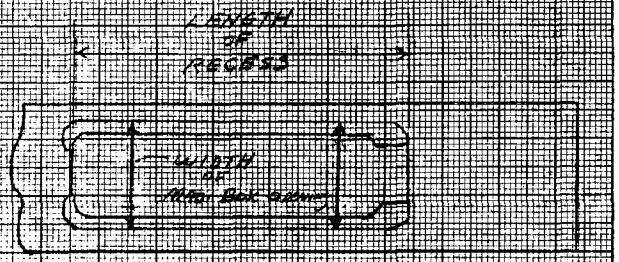
SHORT						
OK	III III	III III	III III	III III	III III	III III
LONG						

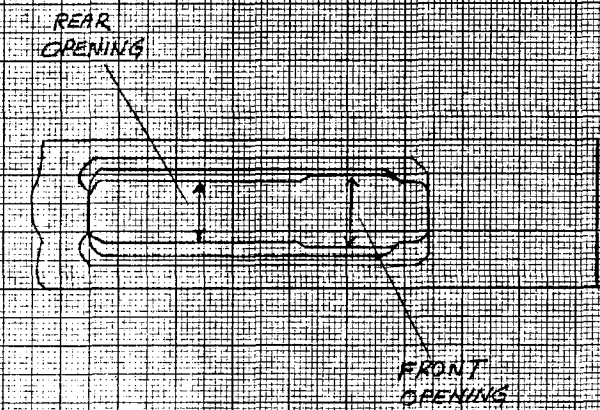
GA. B-80007-G (PLUG) DIM. .561-.581 WIDTH - FRONT OPENING (Shell opening)

NARROW						
OK	III III	III III	III III	III III	III III	III III
WIDE						

GA. B-80112-B (PLUG) DIM. .535-.541 WIDTH - REAR OPENING (Shell opening)

NARROW						
OK						
WIDE	III III	III III	III III	III III	III III	III III





K&E 10 X 10 TO ½ INCH 47 1323
10 X 15 INCHES MADE IN U.S.A.
KEUFFEL & ESSER CO.

PROCESS ENGINEERING ASSIGNMENTS

Job Description:	Area Engineer: Burns ~~Anderson~~ ~~Stafford~~
Oper. - Tap Barrel Hole	Sheet No.: 1 Job No.: 7686-~~S1~~ ~~A1~~B5
Char. - Concentricity of Thread with O.D. (7/16/64)	Job Priority:
	Job Code: 3
	Model: 600
	Part Name: Receiver
	Oper. No.: 19
	Dept. No.: 54
	Est. Comp. Mo/Yr: 4/65
	Est. Comp. Hours: 35
Assigned By: Date:	Est. Savings:

Report Date	Elapsed Hrs.	Accomplishments
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.
		COMPLETE

RD - 6566 2/1/63

cc: L. J. Boyle
T. H. Byrnes
F. G. Carlson
L. B. Croop
V. G. Debeus
J. H. Carter
H. J. Hackman
C. I. Mann
T. H. Pratt
F. W. Pugh
W. C. Schrader
R. L. Stafford
F. 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. Bar changed so cutter did not pass through cut on return causing over-size slot.

Items 3 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 CORP.
Berkeley Heights, N. 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

By S. P. Cross
S. P. Cross
Quality Auditor

Process Eng. - Current Products
R. B. Hurley, Supervisor

By G. J. Hill
G. J. Hill
Process Engineer

SPC/GJH/eb
7-7-65

CC: H. J. Hackman, L. J. Boyle, T. H. Pratt, R. W. Pugh, R. B. Hurley, N. S. Thompson, L. Fox, R. W. Keddell, R. E. Wright, E. R. Carr, R. L. Stafford, file

RECEIVED
JUN 24 1965

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 replacment 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

CURRENT PRODUCTS
Process Engineering

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

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

GFF:sm

RECEIVED
JUL 21 1965
CURRENT PRODUCTS
Process Engineering

cc: R.A. Williamson
L.J. Boyle
H.J. Hackman
P.B. Croop
~~R.B. Harley~~
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 COMPUTATION SHEET SHEET NO 1

TITLE OF PROB M/600-700 REC. 010 PROCESS PROJ NO

SUBJECT VS TRI-ORD. LABOR-EXP. BASED WORKS

ON # 3 FORECAST COMPUTER A. DATE 7-20 1965.

	010 PRO.	TRI-ORD.
M/600-LABOR (32,470 REC.)	4950	2310
700 " (57,840 ")	7020	4120
600 EXP.	5300	6840
700 "	8760	12,350
RELATIONS	4310	2310
DEPRECIATION		4730
TOTAL OPR COST	#30,340	#32,660
GROSS LOSS		#2,320

REMINGTON ARMS COMPANY, INC.

ENGINEERING DEPARTMENT DUPONT COMPUTATION SHEET SHEET NO 2

SUBJECT M/700 REC. OLD PROCESS PROJ NO

SUBJECT COST VS PRESENT TRI-ORDINATE

MACH. COST. COMPUTER AA. DATE 7-19 1965.

PT NO. 26575-6.

OLD PROCESS

OPR.	LABOR	SUPPLIES	GRIND	TOOL REPL.	TOOL MAINT	MACH. REPR.	OTHER REPR	TOTAL EXP.
47	2.657	.043	1.096	.613	.190	.171	.009	2.122
80	1.821	048	1.454	2.244	.169	.106	.008	4.029
108	3511	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	8.897	4.261	.908	.641	.035	# 15.141

TRI-ORDINATE

			Screw					
68	# 7.120	.772	112	5.807	11.849	.428	2.326	.024	# 21.361

REMINGTON ARMS COMPANY, INC.

ENGINEERING DEPARTMENT DUPONT COMPUTATION SHEET SHEET NO 3

TITLE OR PROJ TRI. ORDINATE EXPENSE ACCT. PROJ NO

SUBJECT WORKS

COMPUTER JJ DATE 7-19 1965.

		Tool Replacement				Grind Cost	
OPR. DESCRIPTION	Tool No	Tool Cost	Pcs. Gr.	Grinds Tool	Cost 100	Grind Time	Cost/100
Bolt Stop Slot	53133W	38.00	150	25	.974	1.2 Hrs.	3.480
Fire Cont. "	" V						
Ro. Mill Mag. Open	A-32	~~4.70~~ 1.60	90	1	2.611	.1 "	.254
Mill Bolt H. Slot	88895	~~87.40~~ 10.30	250	25	1.345	.45	.783
Shave Bolt "	87602	18.50	500	10	.336	.30	.250
Fin. Mag. Recess	Simonds N 16	9.20	120	1	3.833	.25	.470
Mill Bevel - Fire Cont. Safety Slot	87600W	~~5.50~~ 2.10	100	1	2.750	.25	.570
					# 11.849		# 5.807

MACH. MAINT

65,000 X 4% ÷ 2 Shifts = .67 Cost Hr. = 2.326/m

288 Pcs.

REMINGTON ARMS COMPANY, INC.

ENGINEERING DEPARTMENT — COMPUTATION SHEET — SHEET NO 4

TITLE Tri. Ordinate Labor Cost. PROJ NO

SUBJECT WORKS

COMPUTER A DATE 7-19 1965.

ELEMENTS	TIME	HRS.	COST/100.	
FLUSH FIX	.193	.322	.676	X
GET PT, LOAD, STAMP	.177	.203	.426	
WALK, UNLOAD	.110	.183	.384	
FILE	.420	.700	1.470	X
RINSE PART	.070	.117	.246	
GAGE, ST. SHAFT	070	.117	.247	
" DURING OPR.	.154	257	.540	X
MISC. CLEAN UP.	.035	.058	.122	
CLEAN UP 1 DAY	.062	.100	.210	
SUTTER CHGS.	.507	.845	1.775	X
STRANGE OVERS 2.00 HRS./5000 PTS.	.141	.241	.684	
			#6.780	
		WITE BONUS.	.340	
			#7.120	

X EXCESSIVE

CC: L. J. Boyle
F. H. Byrnes
F. G. Carlson
E. E. Croop
V. G. DeReus
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.

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

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

By S. P. Cross
S. P. Cross
Quality Auditor

Process Eng. - Current Products
R. B. Hurley, Supervisor

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/XP-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

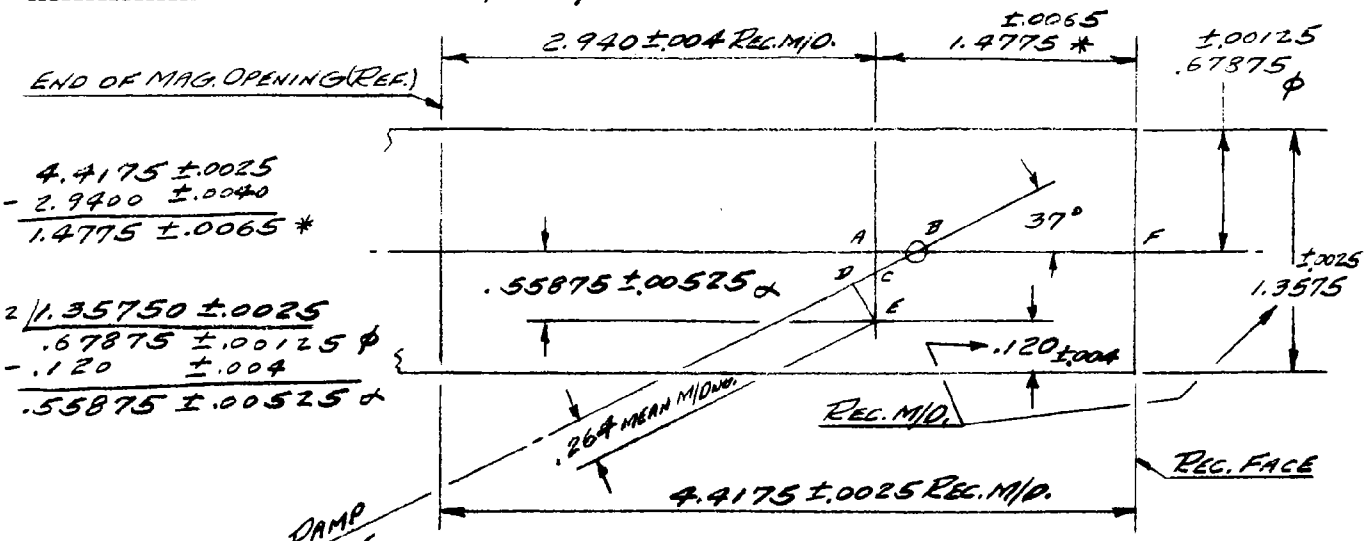
G. F. Frazier

GFF:sm

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

CSY 10/23/62 SUBJECT M/600 RECEIVER. SHEET NO. 1 OF 6

C. KD. BY _____ DATE _____ (OP.) MILL FEED RAMP (CURRENT PERMITTED BY M/DWG). JOB NO. _____



AE = .55875

DE = .264

$CE = \frac{DE}{\cos 37^\circ} = \frac{.264}{.79863} = .33057$

AC = AE - CE = .55875 - .33057 = .22818

AB = AC cot 37° = (.22818)(1.327) = .30279

AF = 4.4175 ±.0025 - 2.9400 ±.004 = 1.4775 ±.0065

DF = AF - AB = 1.4775 - .30279 = 1.17471 MEAN M/DWG.

1.47100-MIN. .680-MAX
- 1.17471-MEAN .116-MIN.
UV = .29629-MIN. RV = .564-MAX

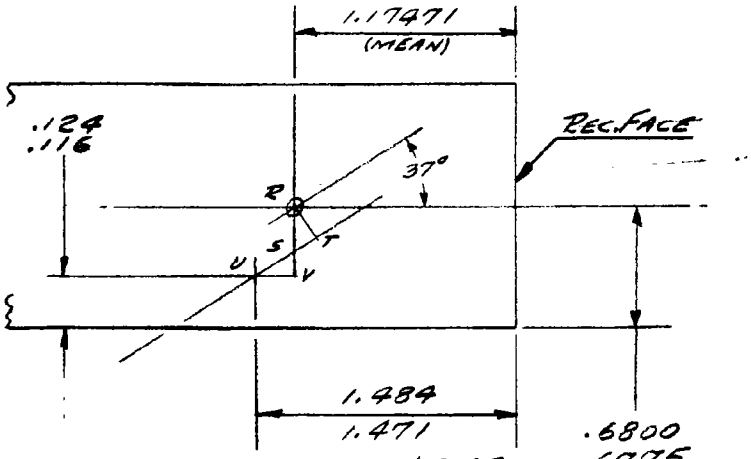
UV = .29629 (MIN)

RV = .564 (MAX)

SV = UV tan 37° = (.29629)(.75355) = .22327

RS = RV - SV = .564 - .22327 = .34073

MAX RT = RS cos 37° = (.34073)(.79863) = .27212



1.48400-MAX. .6775-MIN.
- 1.17471-MEAN. .1240-MAX.
UV = .30929-MAX. RV = .5535-MIN.

UV = .30929-MAX.

RV = .5535-MIN.

SV = UV tan 37° = (.30929)(.75355) = .23307

RS = RV - SV = .5535 - .23307 = .32043

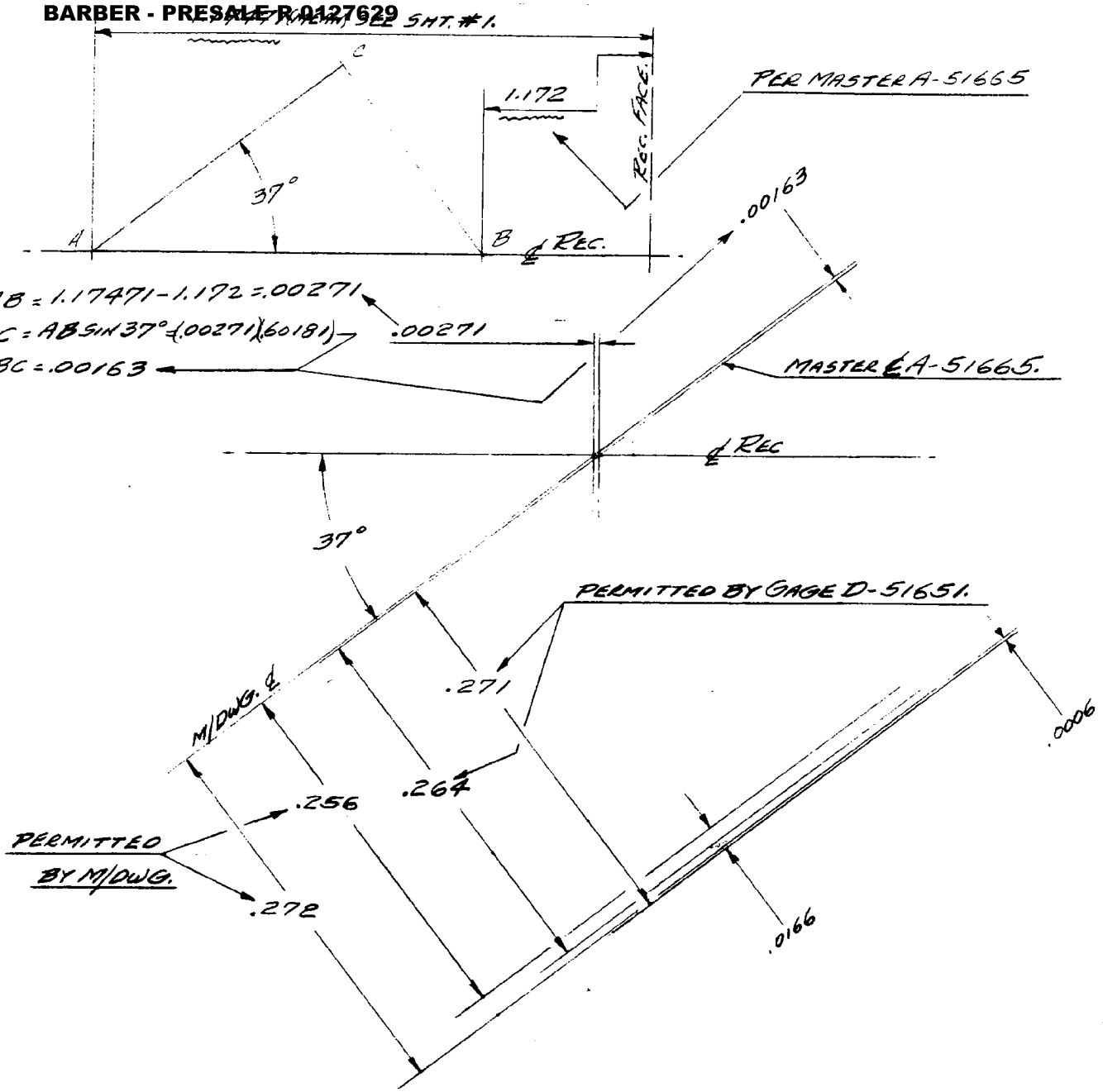
MIN RT = RS cos 37° = (.32043)(.79863) = .25590

MAX RT = .27212
MEAN RT = .264
.00812

MEAN RT = .26400
MIN RT = .25590
.00810

TOL. ON RT = ±.008 PERMITTED BY M/DWG.

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON



SHEET 2 OF 6.

M/600 REC. OR. MILL FEED RAMP 37° CUT

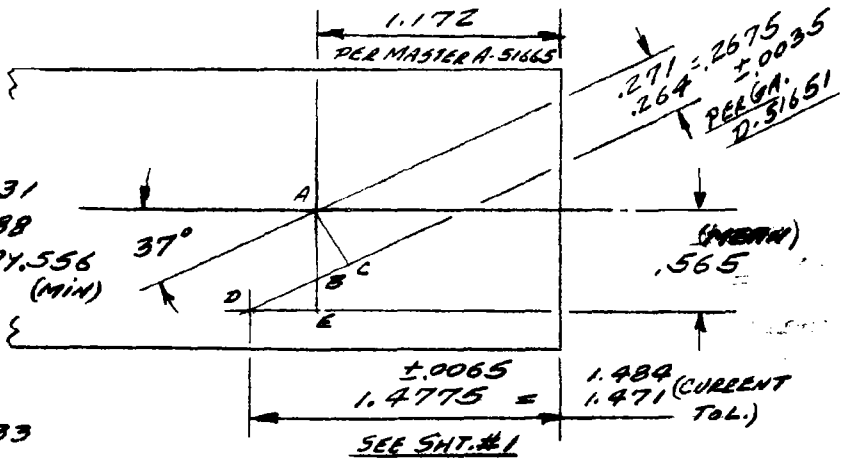
RELATION BETWEEN M/DWG DIMS + DIMS PERMITTED BY GAGES

SCALE 10 TO 1 CSY. 10/24/63

CST 10/23/63 SUBJECT M/600 RECEIVER SHEET NO. 3 OF 6

CHKD. BY _____ DATE _____ CHECK ON GA D-51651, MASTER A-51655B, JOB NO. _____

+GA D-86631 TO DETERMINE CURRENT PARTS.



AC(MIN.) = .264

DE(MIN.) = 1.471 - 1.172 = .299

AB = AC/cos 37° = .264/.79863 = .33057

BE = DE tan 37° = (.299)(.75355) = .22531

AE = AB + BE = .33057 + .22531 = .55588

OR SAY .556 (MIN)

AC(MAX) = .271

DE(MAX) = 1.484 - 1.172 = .312

AB = AC/cos 37° = .271/.79863 = .33933

BE = DE tan 37° = (.312)(.75355) = .23511

AE = AB + BE = .33933 + .23511 = .57444

OR SAY .574 (MAX)

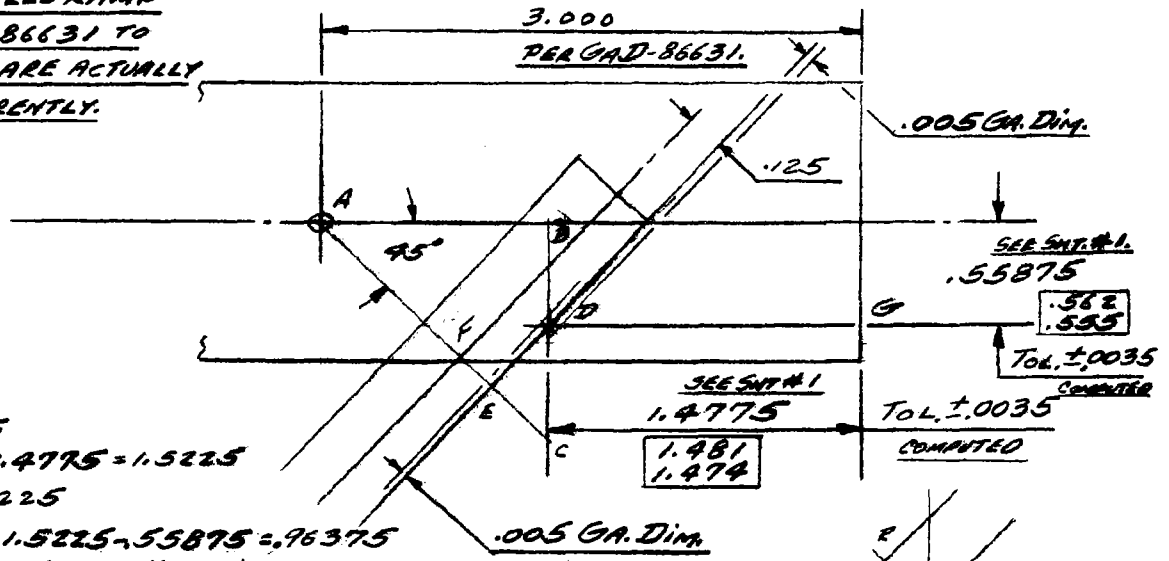
.574 − .556 = .018 ; .556 + .009 = .565 ±.009

TOL. PERMITTED BY ACCUMULATION

(OP. MILL FEED RAMP) (CURRENT)

OP. MILL 45° IN FEED RAMP

CHECK ON GA D-86631 TO FIND WHAT WE ARE ACTUALLY PRODUCING CURRENTLY.



BD = .55875

AB = 3.000 − 1.4775 = 1.5225

BC = AB = 1.5225

DC = BC − BD = 1.5225 − .55875 = .96375

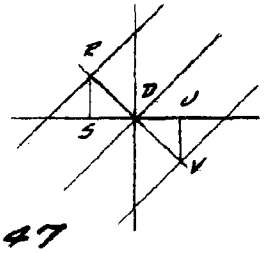
EC = DC sin 45° = (.96375)(.70711) = .68148

FE = .125

AC = AB/sin 45° = 1.5225/.70711 = 2.15313

FC = FE + EC = .125 + .68148 = .80648

AF = AC − FC = 2.15313 − .80648 = 1.34665 + GAGE DIM. = 1.347

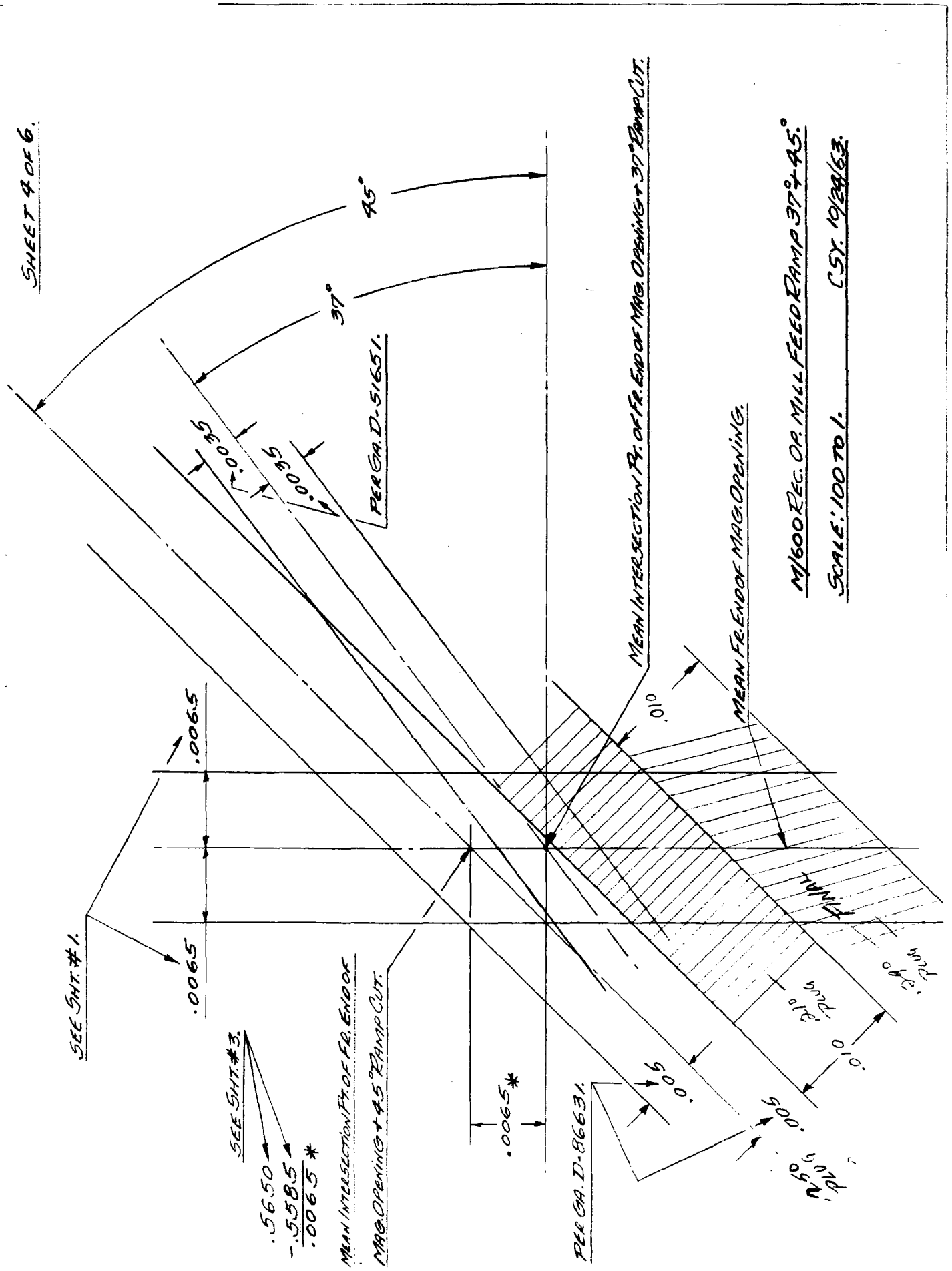


RD = DV = .005

RS = RD sin 45° = (.005)(.70711) = .00354 OR SAY .0035

DS = DU = UV = RS = .0035

TOL. ON BD + DG = ±.0035


SHEET 4 OF 6.
45°
37°
PER GA. D-51651.
.0035
.0035
MEAN INTERSECTION PT. OF FR. END OF MAG. OPENING + 37° RAMP CUT.
MEAN FR. END OF MAG. OPENING.
M/600 REC. OP. MILL FEED RAMP 37° + 45°.
SCALE: 100 TO 1.
CSY. 10/24/63.
.010
.0065
.0065
SEE SHT. #1.
SEE SHT. #3.
.5650
-.5585
.0065*
MEAN INTERSECTION PT. OF FR. END OF MAG. OPENING + 45° RAMP CUT.
.0065*
PER GA. D-86631.
.005
.005
.010
.010
FINAL

BY: [illegible] DATE: [illegible] SUBJECT: M/600 RECEIVER OP. MILL 45° IN FEED RAMP. PROPOSED M/DWG CHG TO CONFORM TO CURRENT PRACTICE. SHEET NO. 5 OF 6

CHKD. BY _____ DATE _____ JOB NO. _____

RS = .285 (MEAN M/DWG.)

SV = .270 = $\frac{.540 \text{ (MEAN M/DWG.)}}{2}$

ST = RS tan 20° = (.285)(.36397) = .10373

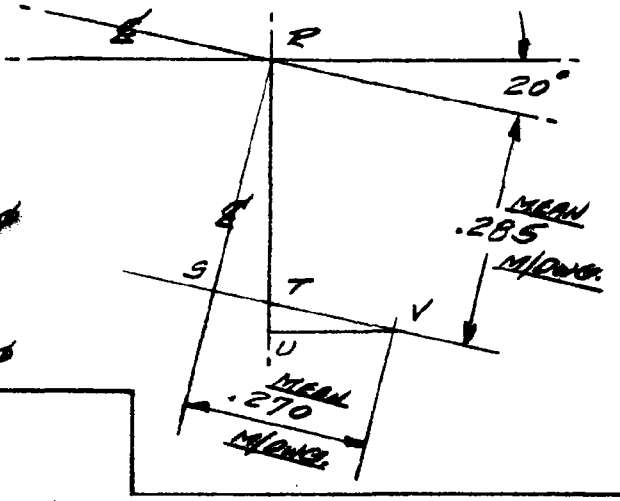
TV = SV − ST = .270 − 10373 = .16627

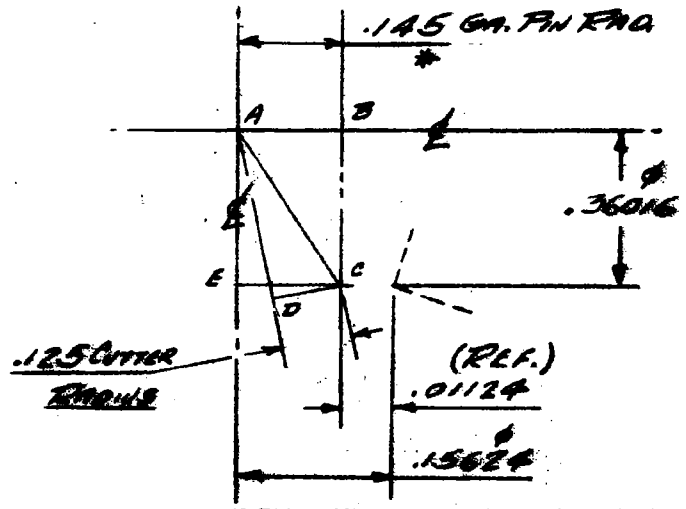
UV = TV cos 20° = (.16627)(.93969) = .15624 ϕ

RT = RS/cos 20° = .285/.93969 = .30329

TU = TV sin 20° = (.16627)(.34202) = .05687

RU = RT + TU = .30329 + .05687 = .36016 ϕ





AB = .145 *

BC = .36016 ϕ

AC = $\sqrt{.145^2 + .36016^2}$ = .38825

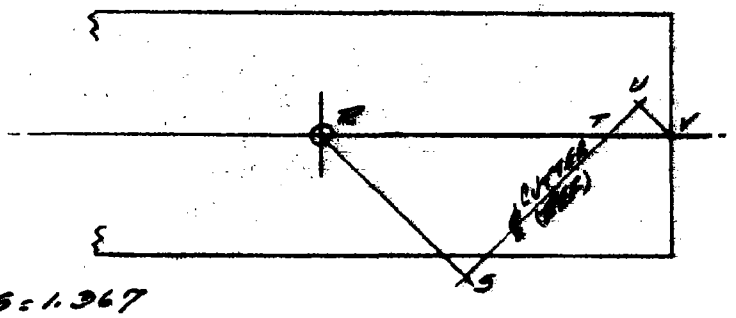
Tan ∠BAC = $\frac{BC}{AB} = \frac{.36016}{.145}$ = 2.48386 = 68°4'13"

Sin ∠DAC = $\frac{DC}{AC} = \frac{.125}{.38825}$ = .32196 = 18°46'54"

∠BAD = ∠BAC + ∠DAC = 86°51'7"

∠EAD = 90° − ∠BAD = 3°8'53"

ANGLE SOUGHT FOR M/DWG. = 40° + 2(3°8'53") = 46°17'46" OR SAY 46°18'



.145 GAGE PIN RAD.
− .125 CUTTER RAD.
.020 DIFFERENCE
+ 1.347 GAGE D-86631 DIM.
1.367 = RS.

RS = 1.367

RV = 3.000

RT = RS/sin 45° = 1.367/.70711 = 1.93322

TV = RV − RT = 3.000 − 1.93322 = 1.06678

UV = TV sin 45° = (1.06678)(.70711) = .75433

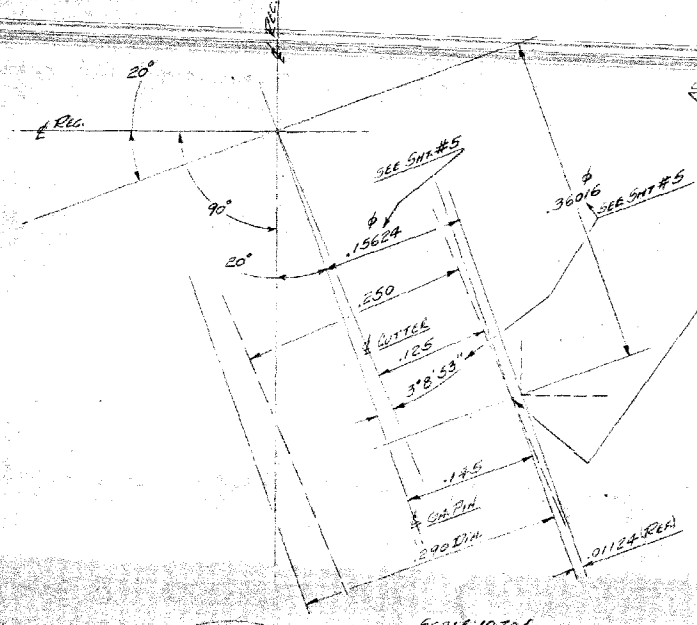
UV − .125 = .75433 − .125 = .62933 ans DIM. FOR M/DWG.

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

BARBER - PRESALE R 0127633

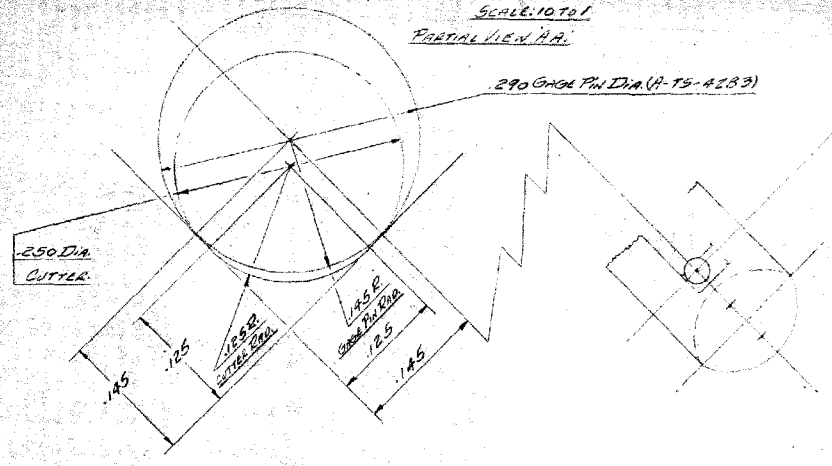
8644-SL-D

UNLESS OTHERWISE SPECIFIED REMOVE ALL BURRS AND SHARP CORNERS .010R.



SCALE: 10 TO 1

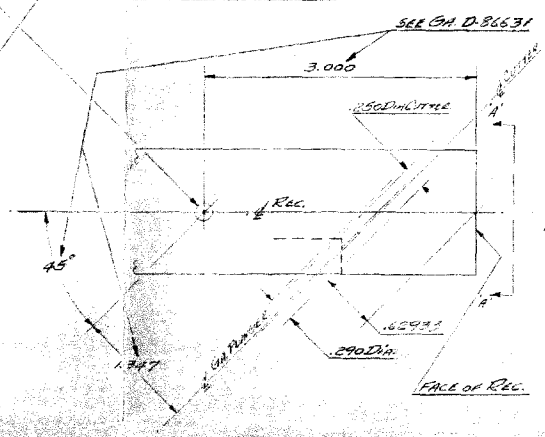
PARTIAL VIEW AA

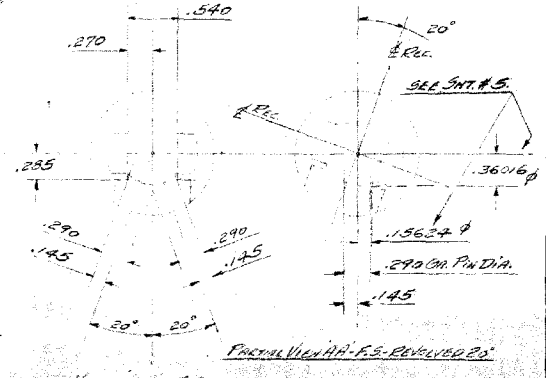


SCALE: 10 TO 1

CONST'N. HOLE IN BASE GAGE D-86631

INTERSECTION PT OF CUTTER + GA. PIN





PARTIAL VIEW AA-FS-REVOLVED 20°

SHEET #6 OF 6

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

REMINGTON ARMS COMPANY, INC., ILION, N. Y.

SCALE FS MODEL 600 PART DWG. NO.

PART RECEIVER.

TOOL PROPOSED MILLING CHANGE TO CONFORM TO CURRENT PRACTICE

OPERATION MILL 45° IN FEED RAMP

	BY	DATE		BY	DATE
DESIGNED			APPROVED		
DRAWN	C.S.K.	6/16/64	SUPD'S DWG NO.		
CHECKED			DRAWING NO.	C-TS-4438	

Form R. D. 5202-Rev. 4

BARBER - PRESALE R 0127633
R2528621

600 REC

REMINGTON ARMS COMPANY, INC.

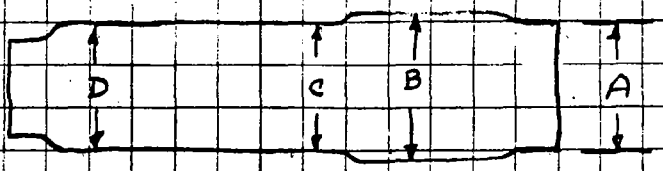
ENGINEERING DEPARTMENT DUPONT COMPUTATION SHEET

OP PROFILE MAG. SLOT OP. #36 MODEL 600

RECEIVER CAL 308 WIN

R. L. STAFFORD COMPUTED DATE 4-15- 1963

OPERATION CHECKED BEFORE & AFTER HEAT TREAT



DIM A

BEFORE

.545
4
3
2
1
.540
9
8 $\bar{X}$ .53642
7 σ .0014
6
.535

AFTER

insignif

$\bar{X}$ .53667
σ .0015

TOL .010

DIM B

BEFORE

.576
5
4
3
2
1
.5705
0
9 $\bar{X}$ .56908
8 σ .0027
7
6
.565

AFTER

$\bar{X}$ .57150
σ .0032

TOL .011

signif

DIM C

BEFORE

9
8
7
6
.545
4
3
2
1 $\bar{X}$
.540
9
8
7
6
.535

AFTER

$\bar{X}$

TOL .010

signif

$\bar{X}$ .54125
σ .0016

$\bar{X}$ .54492
σ .0026

DIM D

BEFORE

.545
4
3
2
1 $\bar{X}$
.540
9
8
7
6
.535

AFTER

$\bar{X}$

TOL .010

signif

$\bar{X}$ .54092
σ .0012

$\bar{X}$ .54258
σ .0024

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KINZER V. REMINGTON

M/600 RECEIVER-10 TO 1 LAYOUT

CHAMFER IN MAG. OPENING

CSY. 8-27-63.

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.

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

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

Mill Yoke The .020^{R} 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

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

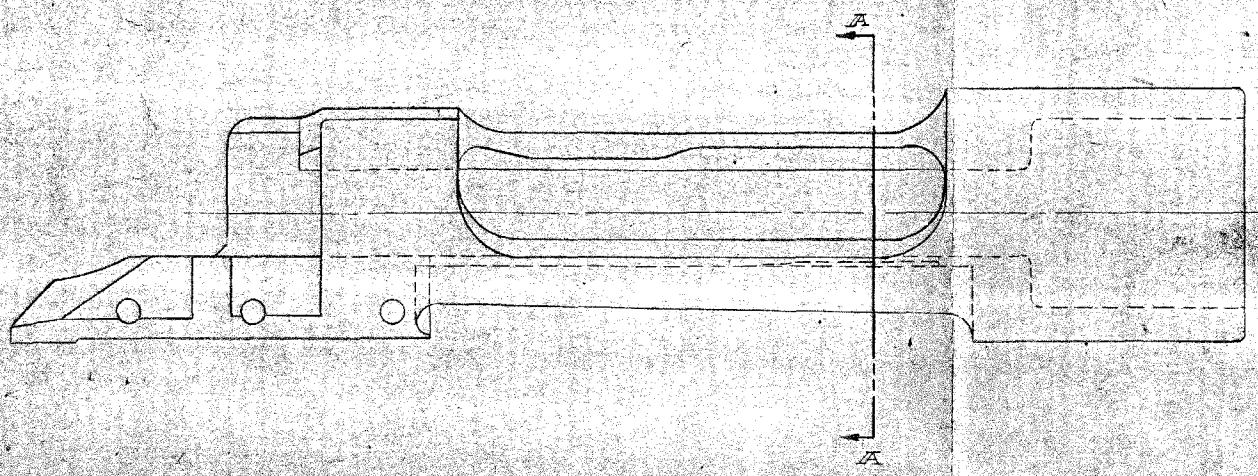
BARBER - PRESALE R 0127637

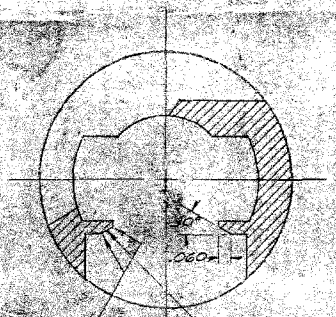
C-15787

DO NOT SCALE THIS DRAWING: WORK TO FIGURES
UNLESS OTHERWISE NOTED, TOLERANCES
ON DECIMAL DIMENSIONS ARE ±.005
& ON FRACTIONAL DIMENSIONS ± 1/64
& ON ANGULAR DIMENSIONS ±00°-30'
FINISHES ARE DESIGNATED BY ROOT MEAN SQUARE (R.M.S.) MICRO-INCH ROUGHNESS VALUES AND ARE THE MAXIMUM ROUGHNESS ACCEPTABLE, UNLESS OTHERWISE SPECIFIED. FINISH ROUGHNESS TO BE 125 √ OR BETTER.

ALTERATIONS

LET.	WAS	REFERENCE	BY	DATE
1	REDRAWN	5126	[illegible]	6-22-63
2	OBSOLETE	5126	[illegible]	7-20-63
3	222 REMMAG	5242	[illegible]	11-25-63

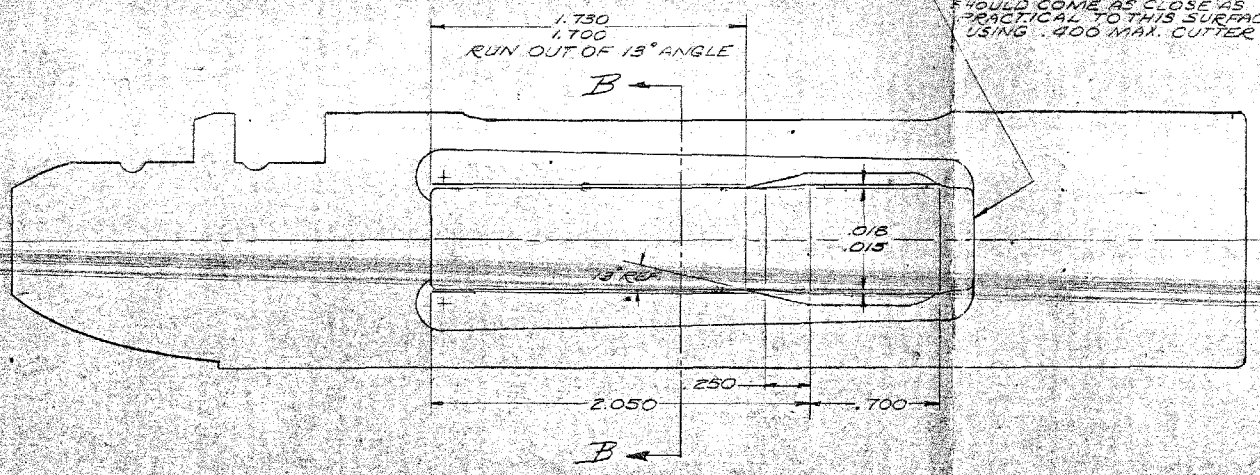


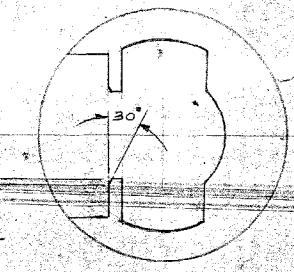


SECTION E-E

.240 U3 BOTTOM CORNERS
.020 - JUST BE
FOLLOWING JES

.IN OUT OF 30° BEVEL CUT
SHOULD COME AS CLOSE AS
PRACTICAL TO THIS SURFACE
USING .400 MAX. CUTTER DIA.





SECTION B-B

Thread 60° Pilot to half of full thickness of shoulder & Jump Cut

NOTE: FOR DIM NOT SHOWN SEE DWG. D-15406

R. L. STAFFORD
8-21-63

(3)	G00	RECEIVER, ASSEMBLY		
MODEL		PART USE	QUAN.	SEC
DES'D BY DATE	DRAWN BY DATE Hilda E. Hearn 1-22-63	CHECK BY DATE	APPR. BY DATE VLJ 1-29-63	

TITLE: RECEIVER

NUMBER: C-15787 | SCALE: 2-1 | SUPERSEDES C-15787 Sheet 1 of 2 Sheets

REMINGTON ARMS CO. INC.
RESEARCH & DEV. DEPT.

FORM TPC-1 Rev. 2

BARBER - PRESALE R 0127637 R2528625

600 Rec

9/5/63
9:30 A

600-222 Receivers.

Blasted + extra almco

R&D pres

2- Finished by R. Carr in Almco - Turned over to R Kelly - 1325 - 1327
18 held

to Marlen 9/5/63 4:00 pm

4. Machined in Tool Room ready for Barrel Assembly
Ser # 1406, 1409, 1410, 1415 - regular almco

2- Filed by filer ready for Barrel Assembly
Ser # 1318, 1326 - regular almco

not polished properly

All Assem. bright

1 - Waterman release pt back .030
+ extra Almco # 1323

1 - Waterman release pt back .060
+ extra almco # 1324

9/16/63

1,100 - 222 CAL. RECEIVERS

(ALL ASSEM. BRIGHT)

GUN NUMBER		TOTAL RDS	REMARK	SLS. CHAMB.	C.C. BOLT OVER SSH.	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	FR. GD. SCR. BINDS BOLT	96	" "	2	✓	✓		
1410		96	" "	11			1	
1415		96	" "	1				
1318		96	PROD. FILE REG. ALMCO					CLEAN
1326		96	" "	2				
1323		96	WATERMAN .030 EXT. ALMCO					1ST. SHELL OUT M.A.G. HARD UNDERRAIL
1324		96	WATERMAN .060 EXT. ALMCO					CLEAN

TOTAL MAL. 2/960 - 2.1%

CC: E. E. Folmsbee R. Stafford A. D. Kerr J. Scanlon
R. W. Pugh

600

February 12, 1964

RECEIVED
FEB 14 1964
CURRENT PRODUCTS
Process Engineering

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 Curodine 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 [Iron Cross] - 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

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KINZER V. REMINGTON

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

600

CC: P. B. Croup
E. J. Meek
R. W. Pugh

March 3, 1964

E. T. DWYER

M/600 RECEIVER - FIXTURES & [illegible]

The following is a list of fixtures and gages that have pin locators for the M/600 Receiver.

These pins should be removed as they are marking the face of the Receiver which leads to "bleeding" at color. The pins should be replaced with flat locators.

Oper. 36 - Profile Magazine Slot
(4) Fixtures E-51498 (same for Oper. 109 & 126).

Oper. 44 - Mill .312 - .305 Fire Control Slot
Fixture E-85153 Gage D-85061

Oper. 48 - Mill .097 - .092 Fire Control Slot
Fixture D-85154 Gage D-85063

Oper. 56 - Finish Mill Tang, Crosswise, Rear End
Fixture E-85064 Gage D-85065

Oper. 64 - Mill Extraction Cam in Bolt Handle Slot
Fixture E-85059

Oper. 72 - Mill Safety Notch and Burr Tang
Gage 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 - Hand 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

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

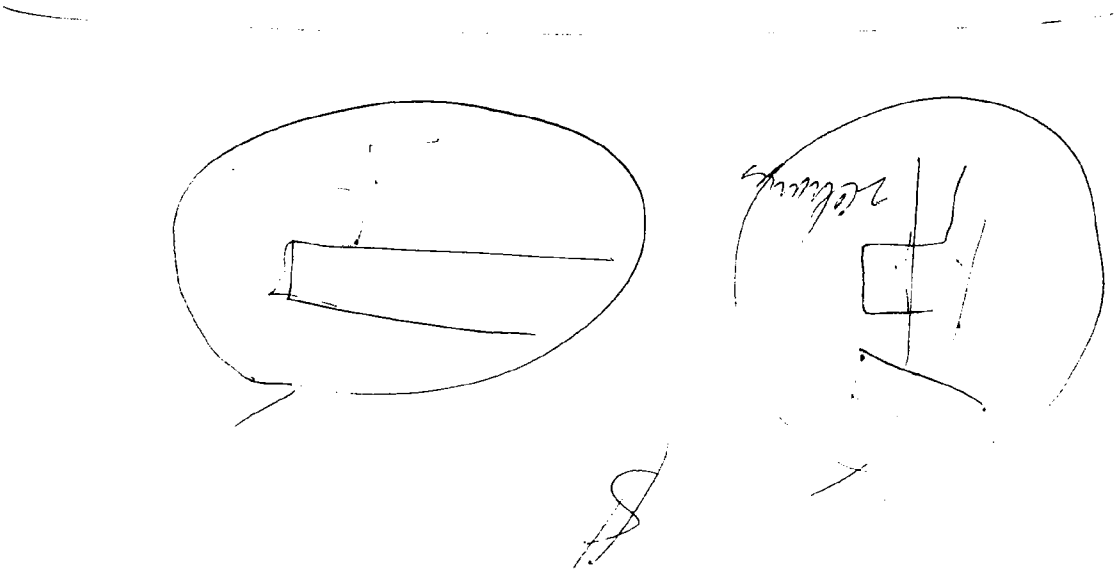
600
R B Harley
note & return
DL 11/7

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

RECEIVED
NOV 7 1963
CURRENT PRODUCTS
Process Engineering

	Costs/c. Add. Rec'r Support	Increase Lg'th of Rec'r
Material.		
Fiberfill (.68 @ 267/lb)*	1.78	
Steel		1.99
Standard Labor	.77	
" Var.	.21	
Total Labor	.98	
Ind Bel @ 33	.32	
Direct Expense	.23	
Estimated out of pocket cost	$3.31	1.99
" " " " /gun	$.033	$.020
" savings/gun		$.013

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



600

P. E. & C. ESTIMATE

R L Hall D E Leek
P P Kelly

TO: H J Hackman

ESTIMATED BY: RB Hurley - VG De Reus

MODEL 600 PROJECT NO. _____ DATE 10/25/63

PROJECT TITLE Estimate to increase lenght of tang on M/600 Receiver to eliminate extra operation on stock and nylon Receiver Support

	HOURS	RATE Stock	TOTAL Receiver
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	J&L			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 .312-.305 FIRE CONTROL SLOT			—	—
48	MILL .097-.092 FIRE CONTROL SLOT			—	—
52	SHAVE PRIMARY SEATING RAMP			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			—	—
106	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			—	—
154A	CYLINDRICAL GRIND			—	—
156	FINISH FILE			—	—
162	ROLL MARK			—	—
164	SERIAL NO.			—	—
168	AUSTEMPER			—	—
	SUB TOTAL			36	178

EDG568 1-18-63

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS ENGINEERING ESTIMATE-TRIAL AND PILOT SHEET
"SEQUENCE OF OPERATIONS"

MODEL 600 COMPONENT RECEIVER PART NO. 15406 15787

DATE 10/21/63 COMPUTER RLS & 9041 SHEET 2 OF 2

OPER NO.	OPERATION NAME	MACHINE	DEPT NO.	HOURS DESIGN	HOURS BUILD
172	LINDBERG DRAW			—	—
174	CYLINDRICAL GRIND			—	—
176	GRIND FRONT FACE			—	—
188R	DRAW FILE RAILS			—	—
192	HAND OIL POLISH			—	—
192-3	HAND OIL ABRASISH BELT POLISH			—	—
193	FILE RAIL & SHROUD			—	—
194	HAND TOP BARREL HOLE			—	—
196	ALMCO SPIN FINISH			—	—
200	REMOVE LODGED CHIPS			—	—
		SUB TOTAL		0	0
				36	178
		TOTAL		36	178
62	MILL TO LENGTH			9	35
	PROPOSED OPERATION TO ALLOW (UNIFORM LENGTH AT CUTOFF FOR BOTH 600 & XP100)				
	ADDED WEIGHT FOR ADDED 1/4" LENGTH - .113 #/RECEIVER				
	TOTAL			45	213

RD-6505 11-8-65

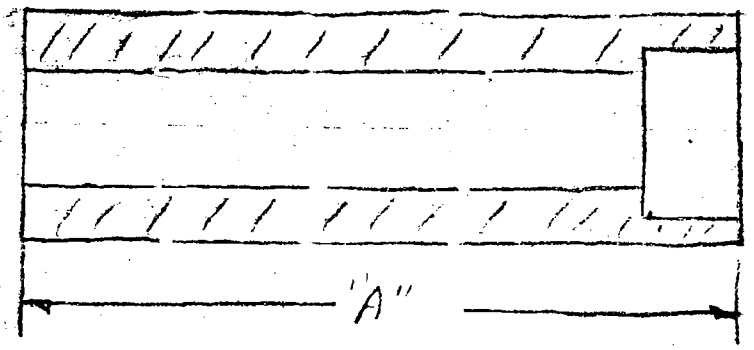
PROCESS ENGINEERING ESTIMATE-TRIAL AND PILOT SHEET

"COMPUTATION"

MODEL 600 COMPONENT RECEIVER PART NO. 15406 15787
OPERATION STEP DRILL & CUT OFF OPER. NO. 3E
MACHINE JET TURRET LATHE DEPT. NO. 23
COMPUTER RLS & ADM DATE 10/21/63 SHEET 1 OF 1

TOOLING	DRAWING NUMBER	REMARKS	HOURS DESIGN	HOURS BUILD
LENGTH GAGE		NEW	2	8
"A" 6.940				
ALL OTHER TOOLS		A.U.		
TOTAL			2	8

SKETCH



INCREASE WEIGHT PER PIECE = .113# ✓

RD-6567 1-18-63

PROCESS ENGINEERING ESTIMATE-TRIAL AND PILOT SHEET
•COMPUTATION•

MODEL 600 COMPONENT RECEIVER PART NO. 15406 15787
OPERATION TAP BARREL HOLE OPER. NO. 19
MACHINE BAKLWELL TAPPER DEPT. NO. 54
COMPUTER RLS E [illegible] DATE 10/21/63 SHEET 1 OF 1

TOOLING	DRAWING NUMBER	REMARKS	HOURS DESIGN	HOURS BUILD
FIXTURE	E-86173	ALTER	2	10
- CHANGE CLAMP LENGTH to 6.940 ft				
- NEW KEY SLOT				
ALL OTHER TOOLING		AU		
TOTAL			2	10

SKETCH

RD-6567 1-18-63

PROCESS ENGINEERING ESTIMATE-TRIAL AND PILOT SHEET.
◦COMPUTATION◦

MODEL 600 COMPONENT RECEIVER PART NO. 15406 15283
OPERATION DRILL SCOPE HOLES OPER. NO. 28
MACHINE DEPT. NO. 54
COMPUTER RLS & PJH DATE 10/21/63 SHEET 1 OF 1

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.

RD-6567 1-18-63

PROCESS ENGINEERING ESTIMATE-TRIAL AND PILOT SHEET

◦COMPUTATION◦

15206

MODEL 600 COMPONENT RECEIVER PART NO. 15787

OPERATION MILL EJECTION PORT OPER. NO. 40

MACHINE CINCINNATI 2/24 RISE & FALL MILLER DEPT. NO. 52

COMPUTER RLS & PGM DATE 10/21/63 SHEET 1 OF 1

TOOLING	DRAWING NUMBER	REMARKS	HOURS DESIGN	HOURS BUILD
DIAL BASE GAGE	D-85057	ALTER	3	15
MOVE LOCATING BLOCK 1/4" NEW HOLES IN BASE				
ALL OTHER TOOLING		A.U.		
TOTAL			3	15

SKETCH

RD-6567 1-18-63

PROCESS ENGINEERING ESTIMATE-TRIAL AND PILOT SHEET
°COMPUTATION°

MODEL 600 COMPONENT RECEIVER PART NO. 15206. 15787
OPERATION SHAVE PRIMARY SEATING CAMS OPER. NO. 52
MACHINE REMINGTON SPECIAL #29181 DEPT. NO. 52
COMPUTER RLS # 4041 DATE 10/21/63 SHEET 1 OF 1

TOOLING	DRAWING NUMBER	REMARKS	HOURS DESIGN	HOURS BUILD
FIXTURE	D-86815	ALTER	4	20
MOVE CLAMP FOR ADDED LENGTH - NEW HOLES IN BASE & NEW KEY WAY				
ALL OTHER TOOLING		A.U.		
TOTAL			4	20

SKETCH

RD-6567 1-18-63

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

PROCESS ENGINEERING ESTIMATE-TRIAL AND PILOT SHEET
°COMPUTATION°

MODEL 600 COMPONENT RECEIVER PART NO. 15406 15787
OPERATION MILL TANG CROSSWISE OPER. NO. 56
MACHINE LINN 2-24 RISE & FALL MILLER DEPT. NO. 54
COMPUTER RLS & QM DATE 10/21/63 SHEET 1 OF 1

TOOLING	DRAWING NUMBER	REMARKS	HOURS DESIGN	HOURS BUILD
FORM CUTTER		NEW	3	15
BASE GAGE	D-85275	ALTER	2	10
MOVE FRONT LOCATING BLOCK				
ALL OTHER TOOLING		A.N.		
TOTAL			5	25

SKETCH

RD-6567 1-18-63

PROCESS ENGINEERING ESTIMATE-TRIAL AND PILOT SHEET
"COMPUTATION"

MODEL 600 COMPONENT RECEIVER PART NO. 15406 15787
OPERATION MILL ANGLE ON TANG OPER. NO. 60
MACHINE #12-1B MILWAUKEE SIMPLEX DEPT. NO. 57
COMPUTER RLS & BMI DATE 10/21/63 SHEET 1 OF 1

TOOLING	DRAWING NUMBER	REMARKS	HOURS DESIGN	HOURS BUILD
FIXTURE	D-85062	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

RD-6567 1-8-63

PROCESS ENGINEERING ESTIMATE-TRIAL AND PILOT SHEET
◦COMPUTATION◦

MODEL 600 COMPONENT RECEIVER PART NO. 15406 15787
OPERATION FINISH MILL BOLT HANDLE SLOT OPER. NO. 81
MACHINE 50-8 CINCINNATI PLAIN MILLER DEPT. NO. 54
COMPUTER RLS & [illegible] DATE 10/21/63 SHEET 1 OF 1

TOOLING	DRAWING NUMBER	REMARKS	HOURS DESIGN	HOURS BUILD
BASE GAGE	D-50455	ALTER	2	10
(NEW INTERCHANGABLE				
REAR LOCATING PIN)				
ALL OTHER TOOLING		A.U.		
TOTAL			2	10

SKETCH

RD-6567 1-18-63

PROCESS ENGINEERING ESTIMATE-TRIAL AND PILOT SHEET
•COMPUTATION•

MODEL 600 COMPONENT RECEIVER PART NO. 15406 15787
OPERATION MILL FIRE CONTROL SAFETY SLOT OPER. NO. 110
MACHINE NICHOLS AUTO HAND MILL DEPT. NO. 54
COMPUTER RLS [illegible] DATE 12/21/63 SHEET 1 OF 1

TOOLING	DRAWING NUMBER	REMARKS	HOURS DESIGN	HOURS BUILD
FIXTURE	D-86305	ALTER	4	20
NEW REAR CLAMP				
ALL OTHER TOOLING		A.U.		
TOTAL			4	20

SKETCH

RD-6567 1-18-63

PROCESS ENGINEERING ESTIMATE-TRIAL AND PILOT SHEET
•COMPUTATION•

MODEL 690 COMPONENT RECEIVER PART NO. 15406 15789
OPERATION 8 MILL BOLT RELEASE SPRING SEAT OPER. NO. 141
MACHINE [illegible] DRILL PRESS DEPT. NO. [illegible]
COMPUTER [illegible] DATE 10/21/63 SHEET 1 OF 1

TOOLING	DRAWING NUMBER	REMARKS	HOURS DESIGN	HOURS BUILD
DRILL JIG	D-85084	ALTER	3	15
NEW INTERCHANGEABLE				
REAR CLAMP				
ALL OTHER TOOLING		A.D.		
TOTAL			3	15

SKETCH

[illegible] 1-18-63

PROCESS ENGINEERING ESTIMATE-TRIAL AND PILOT SHEET
◦COMPUTATION◦

MODEL XP-100 COMPONENT RECEIVER PART NO. 15406 15787
OPERATION MILL TO LENGTH OPER. NO. 62
MACHINE DEPT. NO. 54
COMPUTER RES [illegible] DATE 10/21/63 SHEET 1 OF 1

TOOLING	DRAWING NUMBER	REMARKS	HOURS DESIGN	HOURS BUILD
FIXTURE		NEW	8	32
CUTTER (STANDARD)		NEW	1	3
LENGTH GAGE	B-80178-3	A.U.		
TOTAL			9	35

SKETCH

PROPOSED OPERATION - OBJECT IS TO KEEP COMMON CUTOFF LENGTH FOR M/600 & M/XP-100 TO THIS OPERATION FROM J. & L. LATH.

RD-6567 - 8-63

M/600 - Accuracy

cc HJH, RBH, SMH, WLD, [illegible]
RB Hensley

M/600 6.5mm Accuracy
Accuracy Durie 100 yd by Palmer 11/8/65
2-5 Shot groups.

		E.S.	E.H.	E.V.	
* 56043		1.94	1.84	.75	Ring in chamber (Polished out)
		1.25	1.20	.80	
	Aver.	1.605	1.53	.775	
56405		2.28	1.63	2.15	Ring in cham. (Polished out)
		3.53	.95	3.50	
	Aver.	2.905	1.29	2.825	
55133		3.02	1.77	2.36	
		3.33	2.17	2.80	
	Aver.	3.175	1.97	2.58	
56067		1.87	1.87	1.85	Rough chamber (Polished out)
		3.65	2.52	2.74	
	Aver.	2.76	2.195	2.295	
Average		2.611	1.746	2.119	

Need Low F.S. - Low R.S. base set with .100 block.

* This gun delivered to Walt Dahl 11/9/65 for use by BPD in Ammun. testing.

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

BARBER - PRESALE R 0127661 R2528649

REMINGTON ARMS COMPANY, INC.

ENGINEERING DEPARTMENT COMPUTATION SHEET SHEET NO 1-1

PROJ NO

WORKS

M/600 - 6mm.
(FRONT SIGHT .050 HIGHER) 4.7m 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		.5	0	0	.130	.132
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 | .747

.124 ave.

TARGET BY L. EVANS.

.132

REMINGTON ARMS COMPANY, INC.

ENGINEERING DEPARTMENT COMPUTATION SHEET

TITLE OF PROJ.

SUBJECT M/600 6MM Accuracy
Ammo, Code A055 100 GR PSP 3/14/64

	L. EVANS (5X Scope)		R+R (20X Scope)	
5505	2.20 2.20	2.20	3.00	
5557	1.40 1.63	1.515	2.15	
5502	117 183	1.50	2.37	
5507	.90 3.35 (1.85)	2.125	2.00	flyer 1.80" away
5501	2.10 1.40	1.75	2.00	
5504	1.35 1.55	1.45	2.38	
6 Gun Avg.		1.757"	2.317"	

BARBER - PRESALE R 0127664

TO: (1) V. DEREUS

(2) E. DWYER

(3)

(4)

DATE: 6/16/64

TO DO	EST. HRS.	REQ'D.	WORK ORDER
DESIGN			
BUILD OR ALTER			

CHARGE — DEPT.:

MODEL: 600 PART NO.:

☐ New Tooling
☑ Replacement Tooling

COMPONENT: BARREL GA./CAL.:

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-87180 - DESIGN PER SHEET H ATTACHED

OBSOLETE VALUE $

REASON FOR CHANGE: TO BE COMPATIBLE WITH NEW ROUGH TEMPLATE

INITIATED: [signature] ESTIMATED: APPROVED:

RD-8241, REV. 1-53

REQUEST FOR TOOL DESIGN OR REVISION

BARBER - PRESALE R 0127665

TO: (1)	TO DO	EST. HRS.	REQ'D.	WORK ORDER
(2) E. DWYER	DESIGN			85880
(3)	BUILD OR ALTER			85880
(4)	CHARGE — DEPT.:			

DATE: 6/17/64

☐ New Tooling ☑ Replacement Tooling

MODEL: 600 PART NO.:

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 PER SHEET I ATTACHED

OBSOLETE VALUE $

REASON FOR CHANGE: TO BE COMPATIBLE WITH OTHER LONGER BR GAGING

INITIATED: ESTIMATED: APPROVED:

RD-6241 REV. 1-53

REQUEST FOR TOOL DESIGN OR REVISION

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

BARBER - PRESALE R 0127666

TO: (1) L. DE REUS

(2) E. DWYER

(3)

(4)

	TO DO	EST. HRS.	REQ'D.	WORK ORDER
	DESIGN			85880
	BUILD OR ALTER			85880

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: ROUGH TURN TEMPLATE

DESCRIPTION OF WORK & DISPOSITION OF TOOLING: DESIGN & MAKE TEMPLATE TO REPLACE D-87179 - DESIGN PER SHEET H ATTACHED

OBSOLETE VALUE $

REASON FOR CHANGE: TO ELIMINATE TOOL BREAKAGE

INITIATED: ESTIMATED: APPROVED:

RD-6241 REV. 1-53

REQUEST FOR TOOL DESIGN OR REVISION

6/18

TO: (1) V. DEREUS
(2) E. DWYER
(3)
(4)

DATE: 6/16/64

	TO DO	EST. HRS.	REQ'D.	WORK ORDER
	DESIGN			85880
	BUILD OR ALTER			85880

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: FINISH TURN TEMPLATE

DESCRIPTION OF WORK & DISPOSITION OF TOOLING: DESIGN & MAKE TEMPLATE TO REPLACE D-P7180 — DESIGN PER SHEET H ATTACHED

OBSOLETE VALUE $

REASON FOR CHANGE: TO BE COMPATIBLE WITH NEW ROUGH TEMPLATE

INITIATED: ESTIMATED: APPROVED:

RD-6241 REV. 1-53

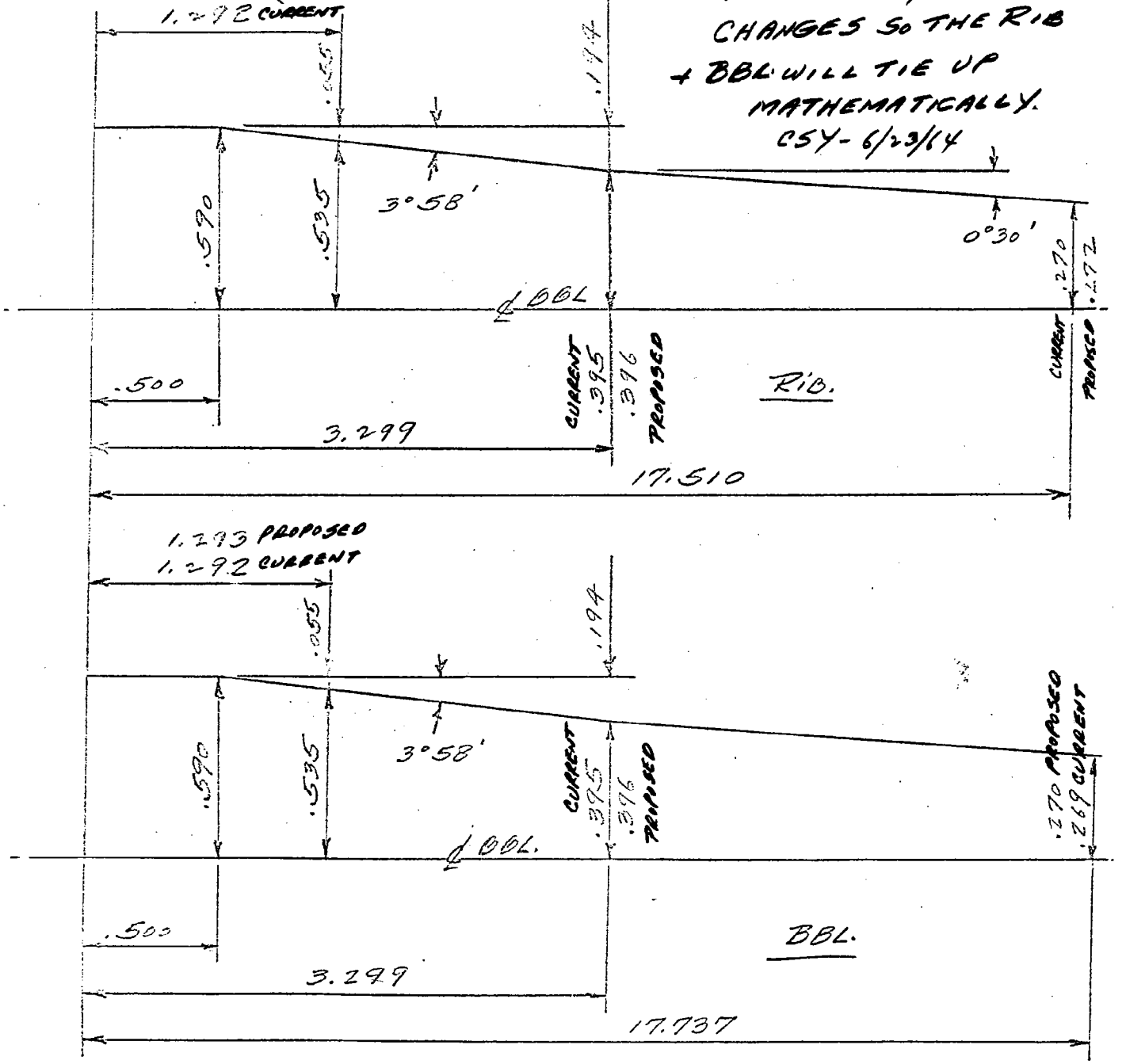
REQUEST FOR TOOL DESIGN OR REVISION

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

M/600
(D-15488) BARREL RIB
(D-26690) BARREL

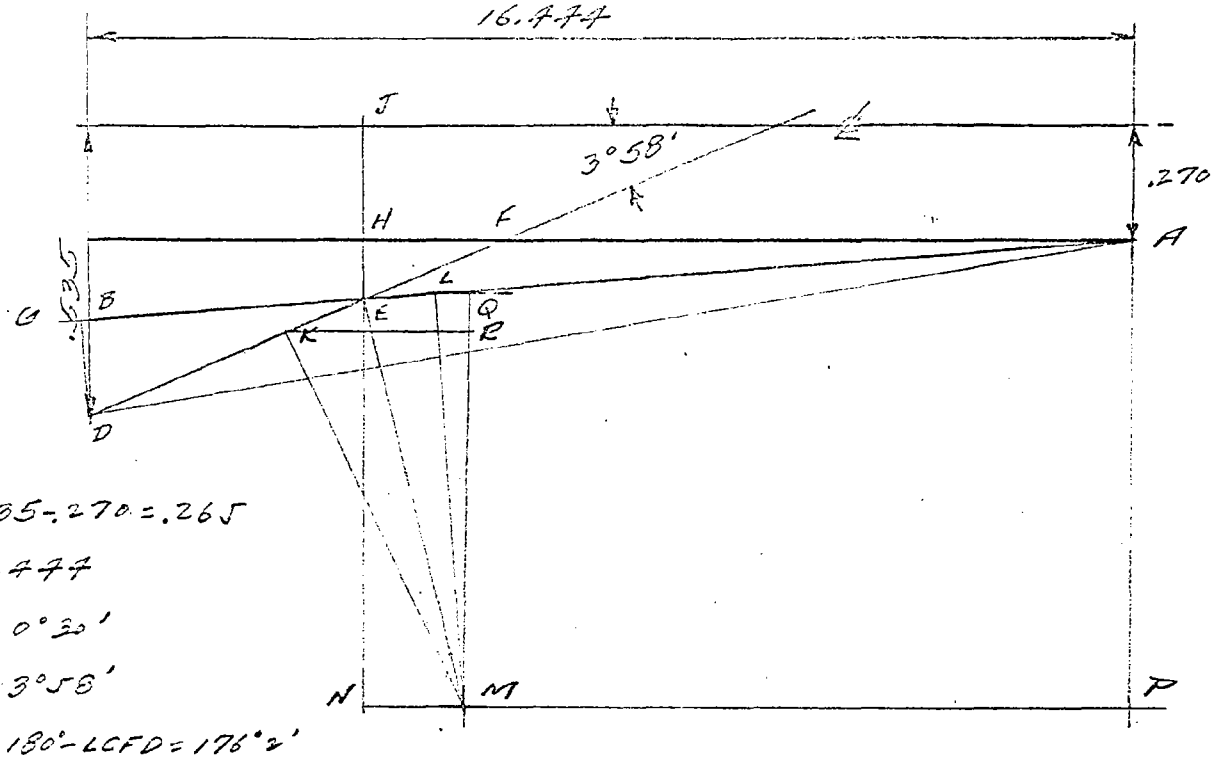
SHEET 1 OF 3

PROPOSED M/DWG CHANGES SO THE RIB + BBL WILL TIE UP MATHEMATICALLY.
CSY - 6/23/64



.396
.394

SHEET 2 OF 3



$DC = .535 - .270 = .265$

$AC = 16.444$

$\angle CAB = 0°30'$

$\angle CFD = 3°58'$

$\angle EFA = 180° - \angle CFD = 176°2'$

$\angle FEA = 180° - (\angle EFA + \angle CAB) = 3°28'$

$\angle DEA = 180° - \angle FEA = 176°32'$

$DA = \sqrt{AC^2 + DC^2} = \sqrt{16.444^2 + .265^2} = \sqrt{270.405136 + .070225} = 16.44614$

$\text{Tan}\angle CAD = \frac{DC}{AC} = \frac{.265}{16.444} = .01612 = 0°55'25''$

$\angle EAD = \angle CAD - \angle CAB = 0°55'25'' - 0°30' = 0°25'25''$

$\angle EDA = 180° - (\angle EAD + \angle DEA) = 3°2'35''$

$GD = AD \sin \angle EAD = (16.44614)(.00739) = .12154$

$AG = AD \cos \angle EAD = (16.44614)(.99997) = 16.44565$

$\angle GCD = \angle FEA = 3°28'$

$GE = GD \cot \angle GED = (.12154)(16.507) = 2.00626$

$AE = AG - GE = 16.44565 - 2.00626 = 14.43939$

$JH = .270$

$HE = AE \sin 0°20' = (14.43939)(.00375) = .12606$

$AH = AE \cos 0°20' = (14.43939)(.99999) = 14.43881$

$JE = JH + HE = .270 + .12606 = .39606$

$\angle KEL = \angle DEA = 176°32'$

$\angle ECH = \angle MEL = \frac{\angle CEL}{2} = 88°16'$

SHEET 3 OF 3

$\angle KME = \angle LME = 90° - \angle KEM = 1°44'$

$EM = MK/\sin \angle KEM = 4.00/.99954 = 4.00184$

$\angle HEA = 90° - 0°30' = 89°30'$

$\angle HEM = \angle HEA + \angle MEL = 177°45'$

$\angle NEM = 180° - \angle HEM = 2°14'$

$\angle EMN = 90° - \angle NEM = 87°46'$

$NE = EM \sin \angle EMN = (4.00184)(.99954) = 3.9985$

$MN = EM \sin \angle NEM = (4.00184)(.03897) = .15595$

$PN = AN = 14.93581$

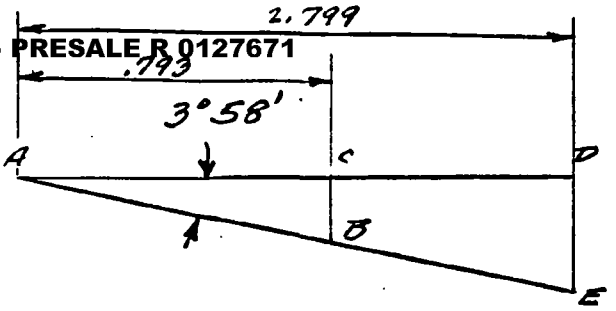
$PA = PN - MN = 14.43381 - .15595 = 14.28286$

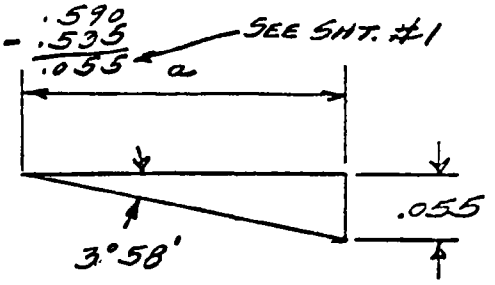
$JH = JH + HE + NE = 4.39486$ ans

$JE = JH + HE = .39606$ ans

17.737
− 14.283
3.454

BARBER - PRESALE R 0127671





$AC = .793$

$BC = AC \tan 3°58' = (.793)(.06934) = .05499$

$AD = 3.299 - .500 = 2.799$

$DE = AD \tan 3°58' = (2.799)(.06934) = .19408$ (PROPOSED)

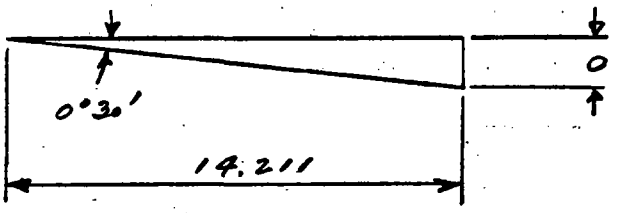
.590 M/DWG − .194 = .396 COMPARES WITH $\frac{.790}{2} = .395$

$a = (.055)(\cot 3°58')$

$a = (.055)(14.421) = .79316$

.500
+ .793
1.293 COMPARES WITH M/DWG. 1.292

17.510 LENGTH OF RIB
− 3.299 DISTANCE FROM END OF RIB TO INTERSECTION OF 3°58' + 0°30' ANGLES
14.211 LENGTH OF RIB WHERE 0°30' ANGLE

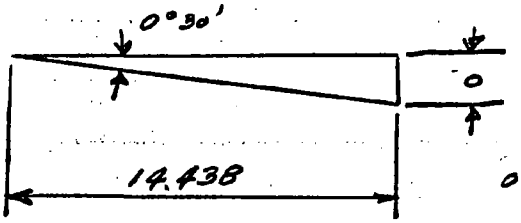


18.615 BBL. LENGTH
− .878 HUB LENGTH
17.737 FROM HUB TO MUZZLE
− 3.299
14.438 DISTANCE FROM MUZZLE TO INTERSECTION OF 3°58' + 0°30' ANGLES.

$0 = 14.211 \tan 0°30'$

$0 = (14.211)(.00873) = .12406$

.39600
− .12406
.27194 OR SAY, .272 (PROPOSED)



$0 = (14.438)(.00873) = .12604$

.396
− .126
.270 PROPOSED RADIUS AT MUZZLE

.540 PROPOSED DIA AT MUZZLE

FORM RD 6277 REV. 6/61

WORK ORDER

FROM DEPT. [redacted] 28 TO DEPT. [redacted] CRAFT

WORK ORDER NUMBER

DATE ISSUED 7-10-64 DATE REQ'D 8/17/64

ACCOUNT [redacted] 9923-01

MODEL 600 DIRECT INDIRECT

COMPONENT BARREL

OPERATION & NO. ROUGH & FINISH TURN

QUANTITY [illegible] NAME OF TOOL TAIL STOCK CENTER ASS'Y.

DWG. NO. B-86249 INV. NO. & SUFFIXES MARK

SUPERSEDED BY DWG. NO. SUPERSEDES OLD DWG. NO.

DESCRIPTION OF WORK: "[redacted]" alt 3 BLDG.

make new "B" - "C" & "D"

+ ADD TO PROCESS RECORDS

~~(Return to Cutter Stores)~~

M.D. - 145 check - believe this is Lodge & Shipley Equip

PM 7/17/64

EST. COST

COMPLETED

ACT. COST

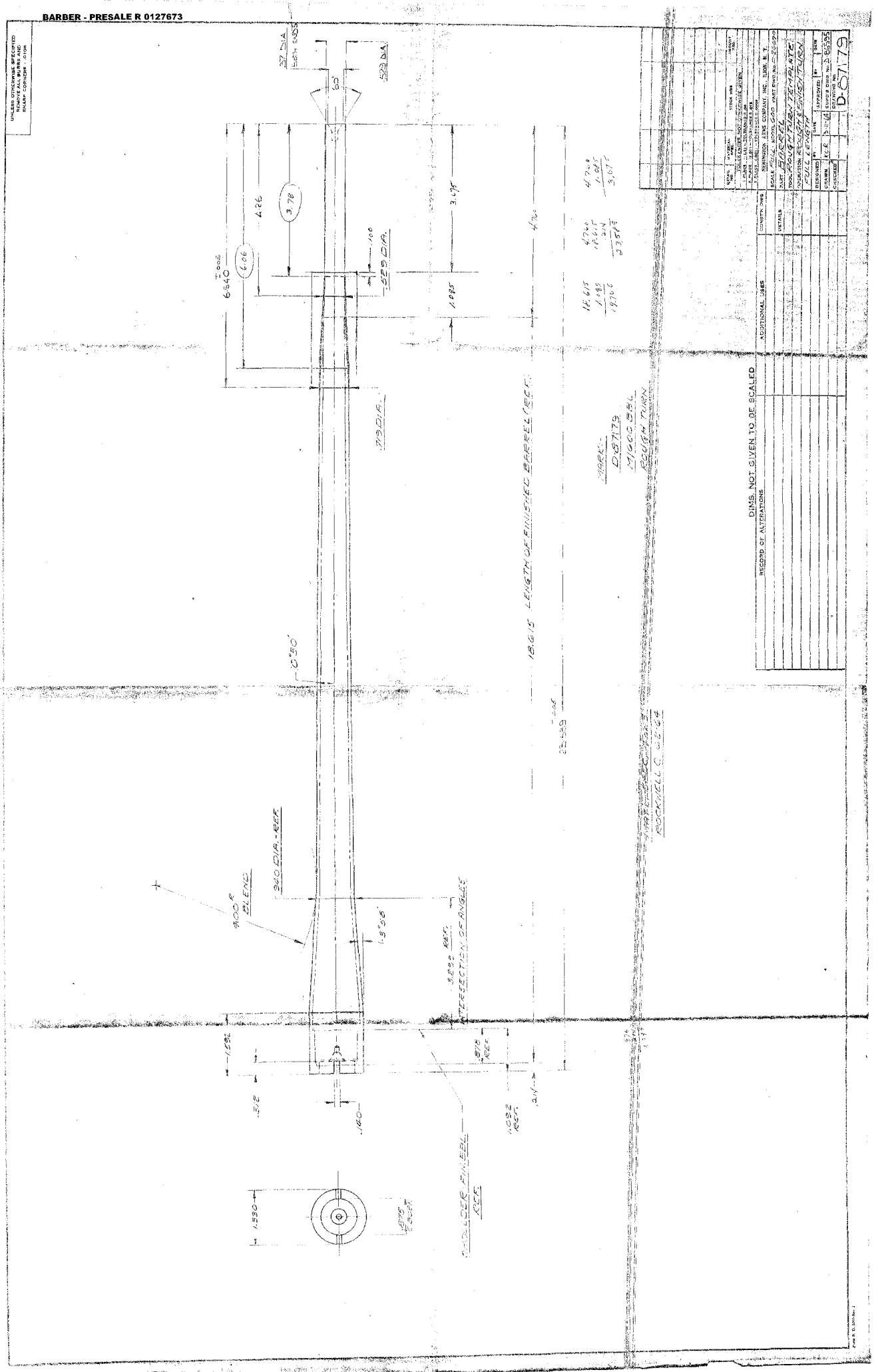
COST

CLOSED

DWG. APPROVED [signature] DATE 7/13/64

ISSUED BY RS APPROVED APPROVED

[signature]


DIMS. NOT GIVEN TO BE SCALED
DRAWING NUMBER D87179
ROUGH TURN
ROLLER FINGER
ROCK
.340 DIA. REF.
.400 R BLEND
.160
.312
1.530
1.592
.822 REF.
.878 REF.
.100 DIA.
.529 DIA.
.379 DIA.
.27 DIA
6.06
4.26
3.78
6.640
1.085
3.195
18.615 LENGTH OF FINISHED BARREL REF.
23.539
.030
.050
1.858
.100
.500
.750
.875
.938
1.000
1.125
1.250
1.375
1.500
1.625
1.750
1.875
2.000
2.125
2.250
2.375
2.500
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3.750
3.875
4.000
4.125
4.250
4.375
4.500
4.625
4.750
4.875
5.000
5.125
5.250
5.375
5.500
5.625
5.750
5.875

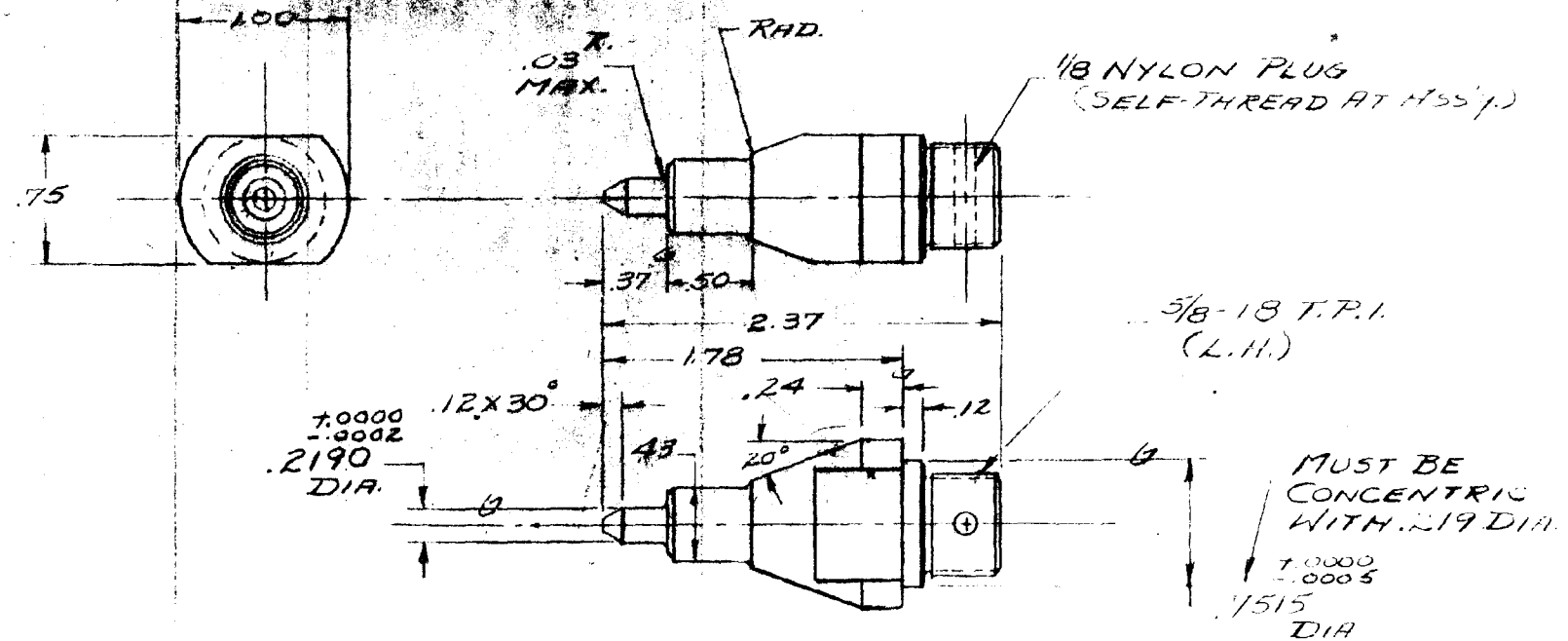
CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

DRAWING No.	REMINGTON ARMS COMPANY, INC. ILION, N. Y.	CONST'N DWG.	ADDITIONAL USES	RECORD OF ALTERATIONS
A-86249-3		B-86249		
SCALE FULL MODEL XP-100 PART DWG. NO.		DETAILS		
PART BARREL				
TOOL TAIL STOCK CENTER ASS'Y.				
OPERATION ROUGH & FINISH TURN				

SUP'D'S. DWG. NO.			CHECKED	BY	DATE
DESIGNED	BY	DATE	TRACED		
DRAWN	URTZ	4/24/63			

TOLERANCES NOT OTHERWISE SPECIFIED
1 PLACE (.1) – TOLERANCE ± .05
2 PLACE (.01) – TOLERANCE ± .010
3 PLACE (.001) – TOLERANCE ± .005

MARK
B-86249-A

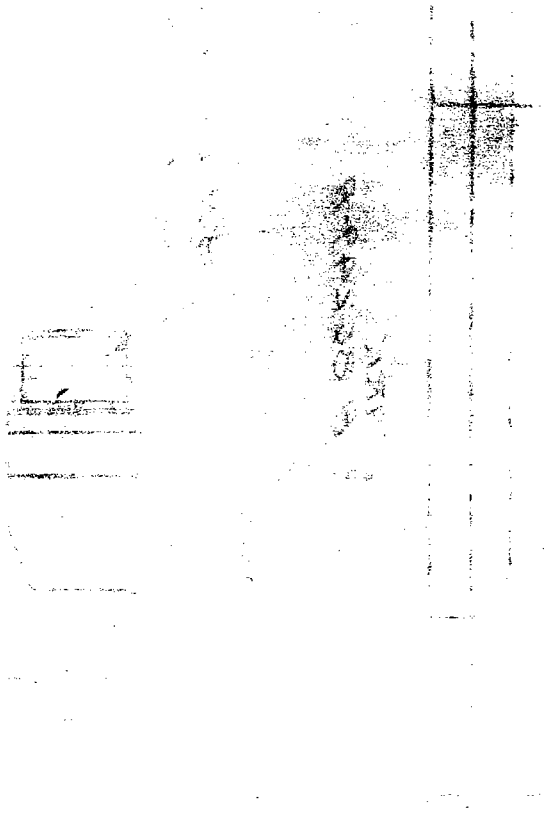


3/3 TOOL STEEL
ROCK C-56-58

FORM R. D. 5201-REV. 3

A-86249-3

BARBER - PRESALE R 0127674
BARBER - PRESALE R 0127674
R2528662

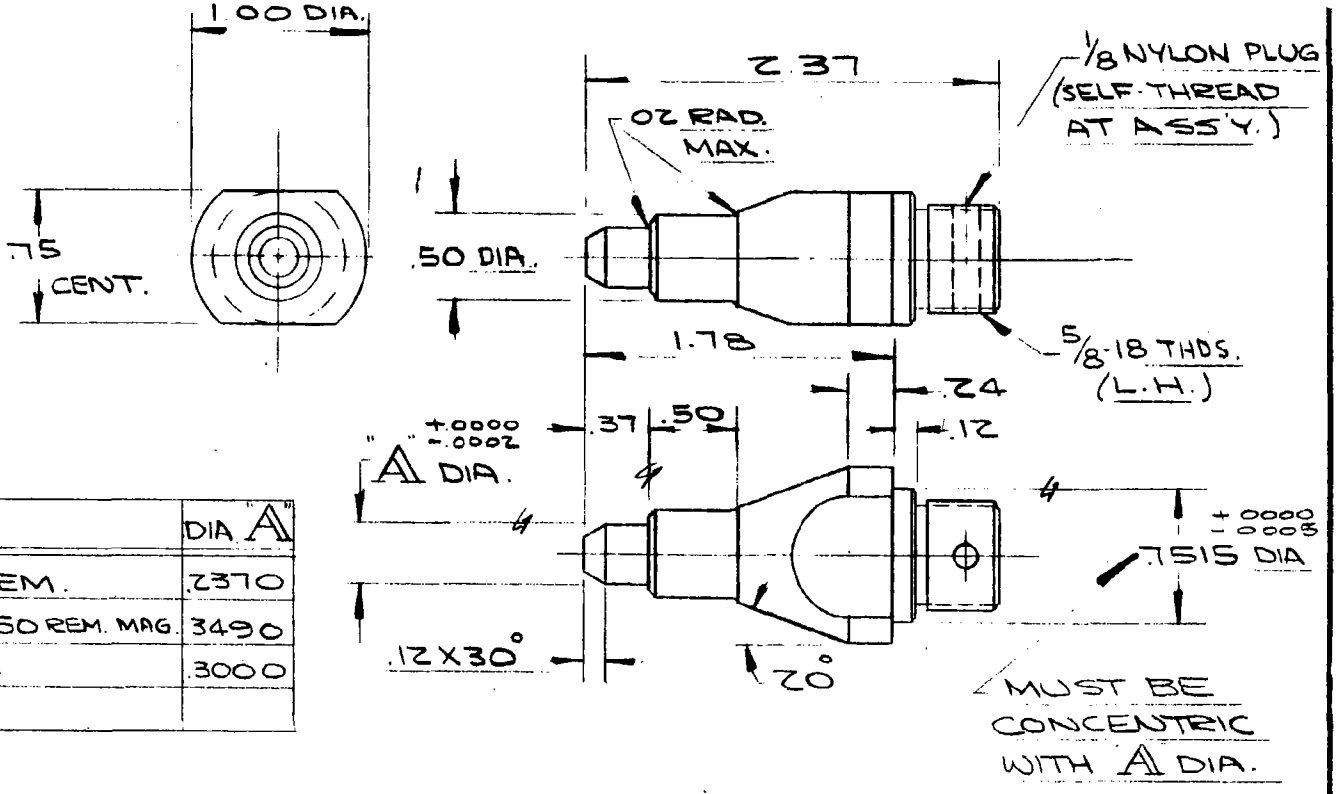


DRAWING No.	REMINGTON ARMS COMPANY, INC. ILION, N. Y.	CONST'N DWG.	ADDITIONAL USES	RECORD OF ALTERATIONS
A-86249-4				
SCALE FULL MODEL 600 PART DWG. NO.		DETAILS		
PART BARREL				
TOOL TAILSTOCK CENTER ASSEMBLY				
OPERATION ROUGH & FINISH TURN				

SUP'D'S. DWG. NO.			CHECKED	BY	DATE
DESIGNED	BY	DATE	TRACED		
DRAWN	R SMITH	7-10-64	APPROVED		

TOLERANCES NOT OTHERWISE GIVEN

1 PLACE (.1)	TOLERANCE ± .05
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 ~ 35 REM. ~ 350 REM. MAG.	.3490
6-4	B-86249-D ~ 308 WIN.	.3000

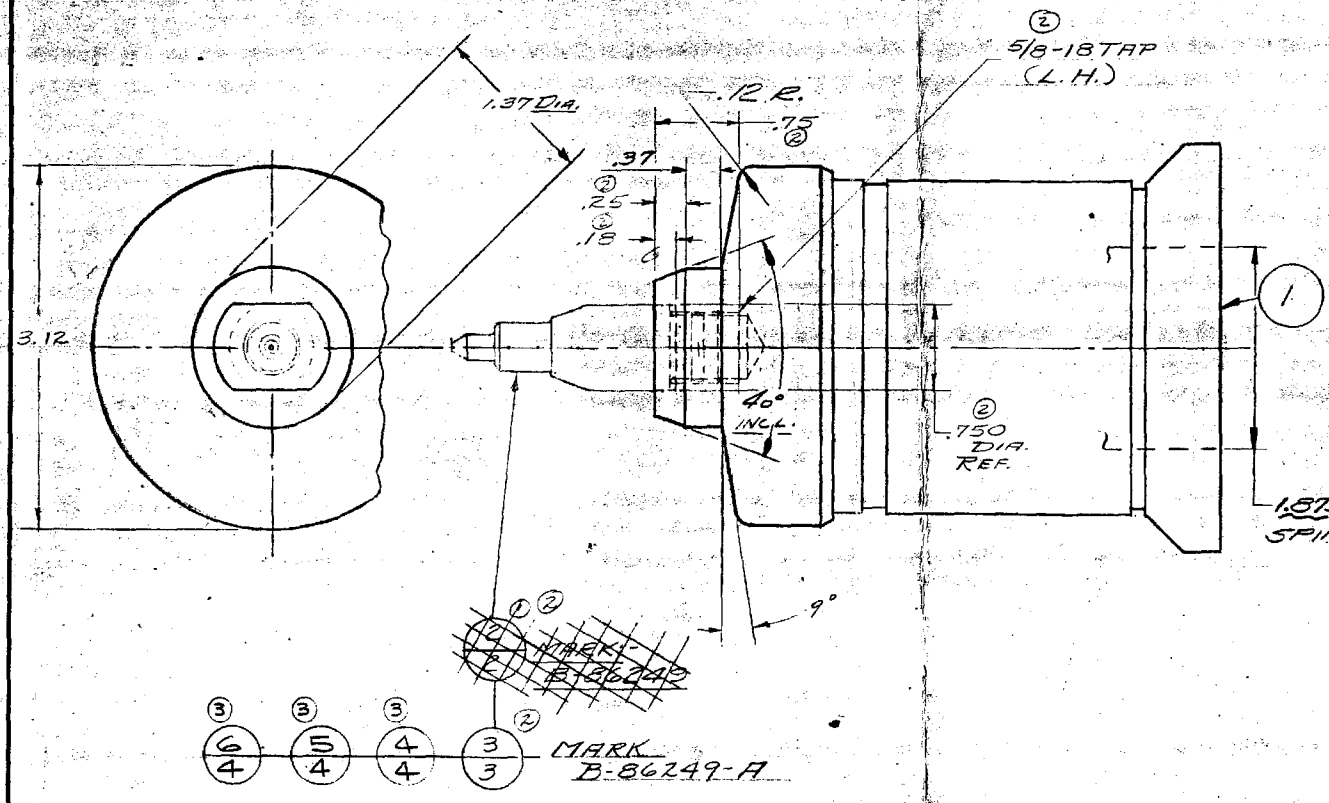
MATL. SPECTS
ROCK. "C" 58-60

FORM R. D. 5201 Rev. 3

A-86249-4

BARBER - PRESALE R 0127676
BARBER - PRESALE R 0127676 R2528664
CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

UNLESS OTHERWISE SPECIFIED REMOVE ALL BURRS AND SHARP CORNERS — .010R



MARK:
B-86249
MOD - XP-100
BARREL

① ALTER STD. READY TOOL CO. TAIL STOCK ASSEM. #050-4 AS SHOWN

1.875 - MACH. SPINDLE DIA.

DIMS. NOT GIVEN TO BE SCALED

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

RECORD OF ALTERATIONS	③ ADDITIONAL USES	CONST'N. DWG.
① REDESIGNED END & ADDED DET. 2/2 & DET. SH'T.	M/600 BARREL ~ 6MM REM, 35 REM.	
A-86249-2 TDR WHC 1/9/63 ② REDESIGNED FRONT END -	.350 REM. MAG & 308 WIN. CAL.	DETAILS
REMOVED DET. 2/2 (OBSOLETE A-86249-2) - & ADDED DET.		① ~~A-86249-2~~
3/3 (A-86249-3) (TDR) 4-24-63 AJH ③ ADDED NEW MODEL & CAL. ADDED		② A-86249-3
SHEET #A-86249-4 & DETS. 4/4, 5/4 & 6/4 R. SMITH 7-10-64 - TDR		③ A-86249-4

REMINGTON ARMS COMPANY, INC., ILION, N. Y.

SCALE FULL MODEL XP-100 PART DWG. NO. 26760

PART BARREL

TOOL TAIL STOCK CENT ASSEM.

OPERATION ROUGH & FINISH TURN

DESIGNED	BY	DATE	APPROVED	BY	DATE
DRAWN	KLAZE	10-27-62	SUPD'S DWG. NO.		
CHECKED			DRAWING NO. B-86249		

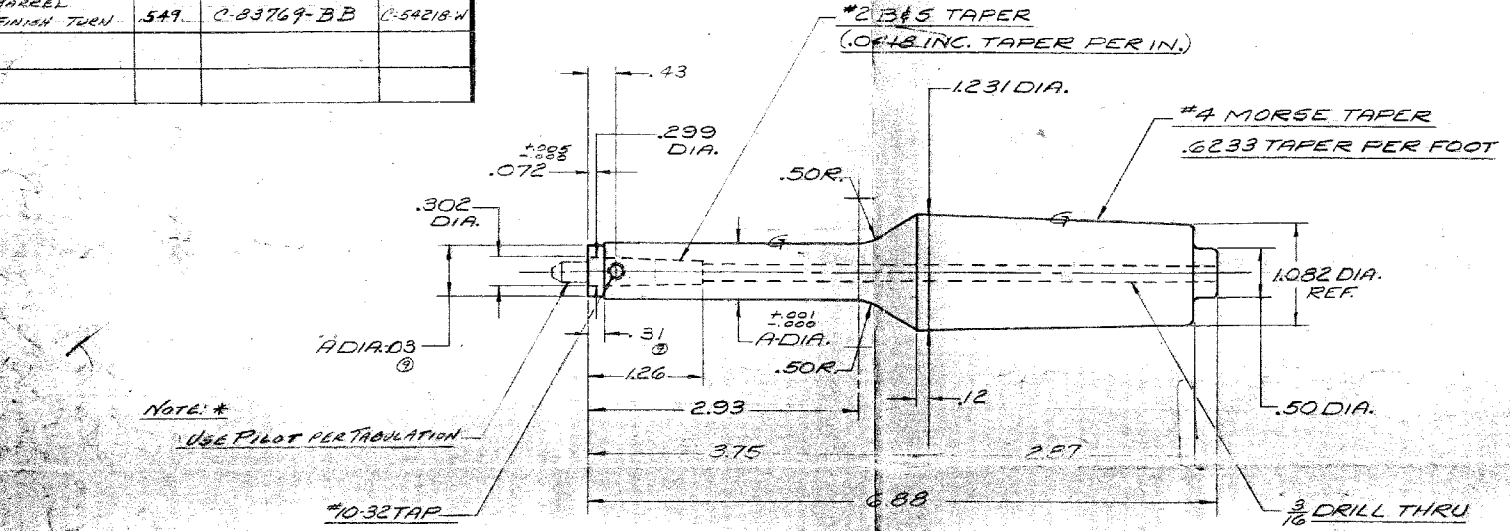
OGILVIE PRESS, INC., BROOKLYN 17, N. Y. STOCK NO. 624B FORM R.D. 5204-REV.

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON
BARBER - PRESALE R 0127679
BARBER - PRESALE R 0127679
R2528667

USES	A +.001 -.000	MARK	USE * PILOT
M/40-X BBL (LT. WT.) ROUGH + FINISH TURN	.757	C-83769-L M/40-X BBL (LT. WT.)	C-54218-H
M/700 BBLS. 222+ 300 H+H Cal. M/700 ROUGH & FINISH TURN	.660	C-83769-M Cal 222+ M/700 BBLS. 300 H+H	C-54218 W+T.
M/40-X BBL (HEAVY) FINISH TURN	.871	C-83769-N M/40-X (HEAVY)	C-54218-H
M/552-572 BBL. FIN. TURN FULL LENGTH	.625	C-83769-S M/552-572 BBL.	C-54218-Y
M/700 BBL FINISH TURN FOR GRIND PROCESS	.670	C-83769-A-A	C-54218-V.T.W. OR V.W.W
M/600 BARREL ROUGH & FINISH TURN	.549	C-83769-BB	C-54218-W

USES	A +.001 -.000	MARK	USE * PILOT
M/513-T BARREL FINISH TURN FULL LENGTH	.823	C-83769-P M/513-T BARREL	C-54218-Y (9)
M/40-X BBL (HEAVY) ROUGH TURN	.971	C-83769-Q M/40-X (HEAVY)	C-54218-H (10)
M/510-11-12-14 BBLS. FIN. TURN FULL LENGTH	.6165	C-83769-R M/510-11-12-14	C-54218-Y (12)
M/XC-13 BARREL ROUGH & FIN. TURN	.539	C-83769-T M/XC-13 BBL.	C-54218-W (13)

UNLESS OTHERWISE SPECIFIED REMOVE ALL BURRS AND SHARP CORNERS .010R



NOTE: * USE PILOT PER TABULATION

TAIL STOCK CENTER
MAT'L. SPEC. 40R3
ROCKWELL C-53-56

*NOTE: USE PILOT PER CORRES. CAL.

USES	A +.001 -.000	MARK	USE * PILOT
M/555 BARREL FINISH TURN FULL LENGTH FOR POLISH PROC.	.631	C-83769-F M/555	C-54218-Y
M/552-572 BBL. FINISH TURN FULL LENGTH FOR POLISH PROCESS	.623	C-83763-G M/552-572 BBLS.	C-54218-Y
M/700-722-725-700 HEAVY BARREL - FINISH TURN FOR GRIND PROCESS	.661	C-83769-H	C-54218-V.T.N. OR W.W.
M/510-511-512-514 BBLS. BARREL FINISH TURN FOR GRIND PROCESS M/700	.602	C-83769-J	C-54218-W.V.T.S.R. OR W.W.
M/510-511-512-514 BBLS. FINISH TURN FULL LENGTH FOR POLISH PROCESS.	.625	C-83769-K M/510-511-512-514 BBLS.	C-54218-Y

USES	A +.001 -.000	MARK	USE PILOT
M/550 BARREL OPER. FIN. TURN	.5995	C-83763-A M/550 BARREL	
M/552-572 BBL. OPER. FIN. TURN	.617	C-83769-B M/552-572 BBL.	
M/555 BARREL OPER. FIN. TURN	.624	C-83769-C M/555 BARREL	
M/510-11-12-14 BBL. OPER. FIN. TURN	.615	C-83769-D M/510-11-12-14 BBL.	
M/550 BARREL FINISH TURN FULL LENGTH FOR POLISH PROCESS	.6075	C-83769-E M/550 BARREL	C-54218-Y

NOTE-
TO BE USED ON
NEW MONARCH LATHE

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

RECORD OF ALTERATIONS

(1) OBSOLETED C-83769-A-B-C & D ADDED
C-83769-E-F-G (Cal.) (Tool) TOR RLS 9/19/41 (2) ADDED H" TO TAB
ADDED "USE PILOT" TO TAB. - ALL FOR CENTER FIRE BBLS TOR RLS 10/11/41
(3) ADDED C-83769-K TO TAB. (TOR) 9/19/41 (4) ADDED NO. OF CAL. TO TAB. FOR
M/510-511-512-514 BBLS. (TOR) 9/19/41 (5) ADDED TO TAB. C-83769-L (TOR) 9/19/41
(6) ADDED TO TAB. C-83769-M (TOR) 10/6/41 (7) ADDED "N" TOR RLS 1-17-42
(8) ADDED "P" TOR RLS 3-31-42 (9) DIM. .81 WAS .78 & A-DIA WAS .902 - ON
C-83769-H .661 WAS .692 TOR RLS 2-5-42 (10) ON C-83769-N .871 WAS .875 & ADDED C-83769-Q TO TAB. TOR RLS 3-2-42 (11) ON C-83769-Q
.767 WAS .769 TOR RLS 3-6-42

ADDITIONAL USES

M/550 BARREL
M/555 BARREL
M/510-511-512-514 BARREL
M/700-760 BBL.
M/721-722-725 BBL.
M/721-722-725 HEAVY BBL.
M/740-C-760-C BBL.
M-66G BBL ASSEMBLY
M-76 BBL ASSEMBLY
M-700 BBL ASSEMBLY

CONST'N. DWG.
DETAILS

REMINGTON ARMS COMPANY, INC., ILION, N. Y.
SCALE FULL MODEL 552-572 PART DWG. NO.
PART BARREL
TOOL TAILSTOCK CENTER
OPERATION FINISH TURN FULL LENGTH

DESIGNED	BY	DATE	APPROVED	BY	DATE
DRAWN		6-14-40	SUED'S DWG. NO.		
CHECKED			DRAWING NO. C-83769		

Form R. D. 5202-Rev. 4

M/600 - Quality

FINISHED GUN QUALITY
DAILY

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.	MODEL	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

MAJOR REJECTS & TEN DEMERIT ITEMS

M/600 308 CAL D.E. AFTER 10TH 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 BBL. 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 ADUIT RETEST)

DATE 3-10-67

MODEL 600 GRADE 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. DATE	WHSE. SAMP.	GA./ CAL.	RESULTS OBSERVED
3-6-67	4	350 R. M.	#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.

NWM/cm
1-20-67

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

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~~ 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

NWM/eb

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

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 reinstructed 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

WTS/eb

CC: W. J. Hackman
~~E. D. Hurlet~~
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

NWM/eb

CC: H. J. Hackman
~~B. B. Hurley~~ 8/24
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

[illegible]/st

CC: H. J. Hackman
R. B. Hurley
W. A. Best
L. J. Boyle
R. E. Wright
W. T. Scott
M. F. Rogers
C. O. Pardee
G. T. 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
38

QUALITY CONTROL DEPARTMENT
N. W. Menard, Supervisor

By W. T. Scanlon
W. T. Scanlon

NWM/eb

① Gordon should this report have been issued w/o comments

② Hurley

RECEIVED
APR 13 1964
CURRENT PRODUCTS
Process Engineering

cc: H. J. Hackman
~~L. E. Hurley~~ 4/13
W. A. Best
L. J. Boyle
W. J. Scott
C. O. Pardee
M. B. Rogers
R. E. Wright
G. J. Markley

FINISHED GUN QUALITY AUDIT
RETEST REPORT

Date 4-8-64

MODEL 600 CAL. .222

REASON FOR RETEST 1/2 C.A. S.T.L.C. 4/7/64

RETEST DATE 4/8/64 SAMPLE SIZE 10 LOT SIZE

NUMBER DEFECTIVE GUNS FOUND IN RETEST 2

ACTION TAKEN

COMMENTS:

QUALITY CONTROL DEPARTMENT
A. D. Gordon, Supervisor

By W. D. Gordon
eb

ADG/eb

M/600 - Sights

P. E. & C. ESTIMATE

WE Leek SM Alvin
RP Kelly RL Hall
[redacted] 4/13

TO: H. J. Hickman

ESTIMATED BY: [redacted] VG Ile Reng

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 sights

	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

RECEIVED
APR 13 1964
CURRENT PRODUCTS
Process Engineering

COMMENTS Part of the cost could be reduced if the model 600 party were incorporated in the initial design of the screw on Front Sight change now being made for the Fortely 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 SCHAFER SHEET 1 OF 1

OPER NO.	OPERATION NAME	MACHINE	DEPT NO.	HOURS DESIGN	HOURS BUILD
	THIS ESTIMATE COVERS THE REMOVAL OF THE M/600 BARREL RIB, FRONT AND REAR SIGHTS. THEY ARE REPLACED BY THE REGULAR M/700 TYPE SIGHTS ONLY.				
	FOLLOWING IS A LIST OF M/600 PARTS WHICH WOULD BE COMPLETELY ELIMINATED.				
	RIB			15489	
	RIB SCREWS (4)			15417	
	BARREL STUDS (6)			15724	
	FRONT SIGHT BASE			15754	
	FRONT SIGHT BEAD			15755	
	REAR SIGHT BASE.			15600	
	" " "			15727	
	" " LEAF			15728	
	" " EYEPIECE			15726	
	" " WINDAGE SCREW.			15732	
	" " " " LOCK WASHER			15734	
	" " ELEVATION SCREW			15733	
	" " NUT			15418	
	" " WRENCH			15778	
	SIGHT SCREWS (4)			15416	
	" " WASHERS (4)			16968	
	IN ADDITION THE FOLLOWING ASSEMBLIES ARE AFFECTED :-				
	FRONT SIGHT ASSEMBLY OMIT COMPLETE PROCESS.			27365	
	REAR SIGHT ASSEMBLY OMIT COMPLETE PROCESS.			26840	
	TOTAL				

RD-6568 1-18-65

(1)

PROCESS ENGINEERING ESTIMATE-TRIAL AND PILOT SHEET.
• SEQUENCE OF OPERATIONS •

MODEL 600 COMPONENT FRONT - REAR SIGHTS PART NO. _____
DATE 4-9-64 COMPUTER AND ASSEMBLY SUMMARY SHEET 2 OF _____

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 ETC. ARE TO BE ADDED TO THE COST OF THE M/600.				
	BARREL ASSEMBLY (26680-81-82-83)				
	DRILL AND TAP TWO REAR SIGHT SCREW HOLES. DRILL AND TAP TWO FRONT SIGHT SCREW HOLES.	PRESENTLY BEING DESIGNED REM. SPECIAL MACHINE.		35	100
	FOLLOWING PARTS LIST IS	FROM M/700. AND	A.U.		
	FRONT SIGHT RAMP SCREW	(2) 19025.		15	
	FRONT SIGHT	15292			
	REAR SIGHT COLLAR	16459			
	" " EYEPIECE	16373			
	" " LEAF	16374			
	TOTAL				

RD-6528 1-18-65

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

(3)

PROCESS ENGINEERING ESTIMATE-TRIAL AND PILOT SHEET.
• SEQUENCE OF OPERATIONS •

MODEL 600 COMPONENT FRONT - REAR SIGHTS PART NO. _____

DATE 4-10-64 COMPUTER AND ASSEMBLY SHEET 3 OF _____

OPER NO.	OPERATION NAME	MACHINE	DEPT NO.	HOURS DESIGN	HOURS BUILD
	REAR SIGHT WINDAGE SCREW.	16458			
	" " BASE SCREW. (2)	16023			
	" " SCREW	16456			
	" " STEP	28095			
	" " WASHER	16968			
	FINAL ASSEMBLY -				
	ASSEMBLE FRONT SIGHT.	SAME ELEMENT			
	ASSEMBLE REAR SIGHT	AS M/700.			
	BASE, REAR SIGHT				
	ASSEMBLY, REAR				
	SIGHT STEP.				
	REAR SIGHT ASSEMBLY				
	USE SAME INFORMATION AS M/741				
	PART NO. 24525.				
	TOTAL				

RD-6868 1-18-63

PROCESS ENGINEERING ESTIMATE-TRIAL AND PILOT SHEET.
• SEQUENCE OF OPERATIONS •

MODEL 1858 COMPONENT/KIT FRONT SIGHT RAMP PART NO. _____

DATE 4-13-64 COMPUTER SCHAFER SHEET 1 OF _____

OPER NO.	OPERATION NAME	MACHINE	DEPT NO.	HOURS DESIGN	HOURS BUILD
	FOLLOW SAME AS M/740 EXCEPT MATL				
	REQUIRES NEW BLANK				
4	WEIGH AND BLEND POWDERS, ALLOYS AND LUBRICANTS	ADD 1% GRAPHITE TO MIXTURE	53	—	—
8	PRESS		53	400	800
12	SINTER		53		
16	INSPECT		53		
20	PRE BEND		53		
24	COIN		53	400	1200
28	INSPECT		53		
	TOTAL			1400	2000

6

PROCESS ENGINEERING ESTIMATE-TRIAL AND PILOT SHEET
SEQUENCE OF OPERATIONS

MODEL 600 COMPONENT FRONT SIGHT RAMP PART NO.

DATE 4-13-64 COMPUTER [illegible] SHEET 1 OF

OPER NO.	OPERATION NAME	MACHINE	DEPT NO.	HOURS DESIGN	HOURS BUILD
4	CHEM. AND NET. INSPECT				
8	DRILL, C'BORE, MILL, DOVETAIL, ETC.	REMINGTON [illegible]		[illegible]	[illegible]
12	DEGREASE AND INSPECTION				
16	CHEM. AND NET. INSPECT				
20	SUBMERGE TOUCHUP				
	* SPECIAL MACHINE NOW IN PROCESS OF DESIGN AND BUILD.				
	TOTAL			[illegible]	

[illegible] 10-63

(6)

PROCESS ENGINEERING ESTIMATE-TRIAL AND PILOT SHEET
"SEQUENCE OF OPERATIONS"

MODEL 600 COMPONENT REAR SIGHT BASE PART NO. ____

DATE 4-13-64 COMPUTER SCHAFER SHEET ___ OF ___

OPER NO.	OPERATION NAME	MACHINE	DEPT NO.	HOURS DESIGN	HOURS BUILD
5	WEIGH AND BLEND, ETC.	SAME AS M/74V			
10	PRESS	" " "		$500.00	$1500.00
15	SINTER	" " "			
20	INSPECT AFTER SINTER	" " "			
25	STRAIGHTEN	" " "			
30	FILE SLOT TO WIDTH	" " "			
35	FORM MILL RADIUS, DRILL REAR SIGHT LEAF HOLES AND C'BORE SCREW HOLES	REMINGTON SPECIAL MACHINE		[illegible]	[illegible]
		GAGES AND TOOLING [illegible]			
40	REAM FRONT HOLE	SAME AS M/74V			
45	SUBMERGE TUMBLE	" " "			
50	BURN OFF IN NITRE - ETC.	" " "			
55	BLACK OXIDE	" " "			
	TOTAL			$1000.00	$3000.00

RD-6566 1-18-63

M/600 - Stock

PROCESS ENGINEERING ASSIGNMENTS

Job Description: Oper. - Inlet Stock, Top and Bottom Char. - Provide tooling for Barrel groove. (Required for parts sales.)	Area Engineer: Clements Sheet No.: 1 Job No.: 3769-C1 Job Priority: A-3 Job Code: 1 Model: 600 Part Name: Stock Oper. No.: 110 Dept. No.: 71 Est. Comp. Mo/Yr: Est. Comp. Hours:
Assigned By: Date:	Est. Savings:

Report Date	Elapsed Hrs.	Accomplishments
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

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

10/25/65

M/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. On checking receivers in assembly, all available had had the screw hole eliminated - Process Engineering to remove clear. Operation in Stock -

RST

10/20/65

R. B. Hurley

Why?

Please handle

[illegible] 10/20/65

69-B

REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE

Remington DUPONT PETERS DUPONT

"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.

BARBER - PRESALE R 0127702

To W.L.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 1½ YEARS PAST THE DWG. CHANGE AND THOUSANDS OF STOCKS. IF MAGAZINES EXIST IN ANY FORM SAVE MODEL DRAWING THEY SHOULD BE SCRAPPED, OR ALTERED.

H J Waterman

TO BE SAFE; FIRST THINK YOU MIGHT NOT BE

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

600 Stock Blank 4/23/64 RBG

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 AP 1/8 - 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 Schroder AP 2000 salvage blanks which had wrong shape

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.

SAFETY ALERT

eb

cc: L. J. [illegible]
L. C. [illegible]
FILE

DON'T SAY IT—WRITE IT

TO PAUL NEILSEN

DATE 12/2/63

FROM R. J. CHERRINGTON

RECEIVED
DEC 9 1963
CURRENT PRODUCTS
Process Engineering

SUBJECT: M/600 STOCKS

In the past run of about 450 - M/600 Stocks, over 50 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-69811 - 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.

mk

R. J. Cherrington
Supervisor

THERE IS A SAFE WAY; DO IT THAT WAY

600

RD-69-B

REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE

Remington DU PONT PETERS DU PONT

cc: F.E. Morgan
G.M.Calhoun
W.E. Leek - File

"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
Ilion Research Division

SMA:T

MODEL 600 BARRELED ACTIONS

G-88

DON'T SAY IT — WRITE IT

To Jack Carter

From Bill Stevens

Date 3/29/82

M/600 BDL actions in stock.

6150	-	248
6152	-	31
6154	-	96
6156	-	14
TOTAL		389

KEEP SAFETY IN MIND IN '79

G-88

DON'T SAY IT—*WRITE IT*

To Jack Carter

Date 3/11/82

From A. J. Santa

n/oh 600 Barrel Actions Packed during Feb + Mar. 1982

308 cal - 16
222 cal - 246
243 cal - 96
6mm - 31

total shipments to date: Started Nov 1979

308 cal - 1916
222 cal - 1007
243 cal - 756
6mm - 39

"SAFETY RULES ARE PERFECT TOOLS"

G-88

DON'T SAY IT — WRITE IT

To J. H. CARTER Date 3/8/82

From W. E. STEVENS

M/600 ACTIONS IN WAREHOUSE

(222)	6150	—	246
(6mm)	6152	—	31
(243)	6154	—	96
(308)	6156	—	16
			389 TOTAL

KEEP SAFETY IN MIND IN '79

Copy to Larry Blackhurst 3-1-82

cc J H Carter 1/4/82

Barrel Actions Orders

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
	349

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

From Bill Stevens

Date 2/1/82

M/600 BR Actions NC in warehouse 2/1/82

6152 — 6mm — 8 + 9
6150 — 222 — 95 + 30
6156 — 308 — 2 + 0

105 +39 = 144 ~~TOTAL~~

"SAFETY RULES ARE PERFECT TOOLS"

FAST-but-informal

1/12/82

Jack,

Mch 600 Barrel Actions

packed

308 cal — 65

Dennis

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 mod 600

.308 Cal - 50
.222 Cal - 15
.243 Cal - 9

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: Dennis Sanita

Date: 9/[illegible]

Updated 1/[illegible]

Subject Moh 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
[illegible] - 161

Sept 1980 [illegible] - 324
[illegible] cal - 23
243 cal - 3

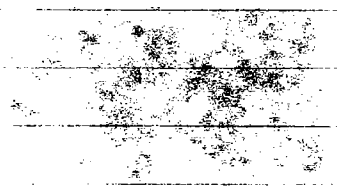
Jan 1981 308 cal - 114
222 cal - 68

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 & Warehoused 12-12-80

110	#6156	308 ml
65	#6150	222 ml



cc B. H. Gilbert

DON'T SAY IT — WRITE IT

To Jack Carter

From Dennis Sanita

Date 9/18/80

Subject Winch 600 Bank 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	222 Cal - 324 308 Cal - 23 243 Cal - 3

Total Shipments by caliber as of 9/18/80

308 Cal. - 1669
243 Cal. - 651
222 Cal. - 669

SAFETY IS A WISE INVESTMENT

G-88

DON'T SAY IT—*WRITE IT*

To _____ Date 11/30/79

From _____

Nov 600 Barrel actions 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 ✓

308	222	243	
1646	345	648	2639

"SAFETY RULES ARE PERFECT TOOLS"

G-88

DON'T SAY IT—*WRITE IT*

To _____ Date 11/30/79

From _____

Nov 600 Barrel Actions 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

Merv & Sam

G-88

DON'T SAY IT—*WRITE IT*

To _____ Date _____

From _____

Mon 600 Bbl actions packed

90 - 308 Cal
25 - 222 Cal } 6/18/80

223 - 308 Cal - 6/24/80
338

"SAFETY RULES ARE PERFECT TOOLS"

Remington

REMINGTON ARMS COMPANY, INC.

PETERS

BRIDGEPORT, CONNECTICUT 06602
U.S.A.

SPORTING FIREARMS
AMMUNITION
TARGETS
TRAPS

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

FOR ORDER AND BILLING

SOLD TO:
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.: x

INSURANCE: yes

MARK: dto.

FOREIGN BANK:

IMPORT PERMIT:

RECEIVED
JUN 18 1980
ARMS SERVICE

CONSIGNMENT:

REMARKS: SPECIAL INSTRUCTIONS

For shipment soonest possible

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

GmbH Barrel Actions orders 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

G-83

DON'T SAY IT—*WRITE IT*

To Jack/ Bernie Date 4/18/80

From ~~Bernie Jack~~ 4-18-80

May I please have M/600 barreled action amounts regd. for shipment.

.308 -	400
.222 -	850
.243 -	720
6MM -	100
	2070

KEEP SAFETY IN MIND IN '79

4-18-80

M600 Barrel Action

Original breakdown

308 1200 qty

243 900 "

222 900 "

308	243	222
required 1200	900	900
shipped Nov 79 -333	Sept 79 -399	Jan 80 -60
Jan 80 -483	501	Feb 80 -23
need 384	501	817

DON'T SAY IT—WRITE IT
To
From
Date
KEEP SAFETY IN MIND

G-88

DON'T SAY IT—*WRITE IT*

cc M.J. Kantor

To J.H. Carter

Date 2/19/80

From D.J. Santa

Mon 600 barrel actions packed for GMBH orders

308 cal - 122 + 56 = 178

222 cal - 23

KEEP SAFETY IN MIND IN '79

Remington.

REMINGTON ARMS COMPANY, INC.

PETERS

BRIDGEPORT, CONNECTICUT 06602
U.S.A.

SPORTING FIREARMS
AMMUNITION
TARGETS
TRAPS

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

SOLD TO:
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		
OR	500		Cal. 308 Win. 333 Shipped Nov 79		88 - 1/31/80 128 2-29-80
	350		Cal. 222 Rem.		
	151		Cal. 243 Win.		
dcw					

RD 1457 REV. 8/74 — PRODUCTION

Remington.

REMINGTON ARMS COMPANY, INC.

PETERS

BRIDGEPORT, CONNECTICUT 06602
U.S.A.

SPORTING FIREARMS
AMMUNITION
TARGETS
TRAPS

CABLE—HARTLEY, BRIDGEPORT
TELEX: (964-286) & (964-201)

INTERNATIONAL SALES ORDER FORM

REMINGTON ORDER NUMBER: PX-3392

RED AREAS FOR REMINGTON USE ONLY — FOR TRAFFIC

CODE

DATE: 10/31/79

FOR ORDER AND BILLING

SOLD TO:
Remington Arms GmbH
Winterhauser Str. 85
8700 Wurzburg-Heidingsfeld
West Germany

CUSTOMER ORDER NUMBER: 90309

REP/DIST. ORDER NO.

DATE: 3/14/79

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	400 — ~~125~~		Cal. 308 Win. 325 shipped 1/7/80, 5 shipped 2/19/80		
	209		Cal. 222 Rem. 60 Shipped 1/3/80, 23 shipped 2/19/80		
dcw					

RD 1457 REV. 9/72

Mike / Bernie

M600 Barrel Actions for International + Arms Service

Cal	Int'l Need	Arms Service	Total Required	Shipped as of 1-14-80 to 1/22 - 2-19
.222	850	0	850	52 + 10 + 2.3 = 85 (1-31, 2-19)
.243	900	215	1115	0
.308	391	0	391	809 + 88 + 178 = 1,075 (1-31-80, 2-19)
6M	0	96	96	0
			2452	861 = 1160

Start warehousing for shipment Jan 28, 1980
30 per day.

BARBER - PRESALE R 0127733

RD-69 REV. 6-68

REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE

Remington

Copies to Mike + Bernie,
Jack
11-15-79

cc: E. J. Giner
M. F. deMayo
W. D. Nickel
P. H. Holmberg
P. J. Rosendahl

Bridgeport, Connecticut
November 13, 1979

J. H. CARTER

M600 BARRELED ACTIONS FOR GMBH

This is to confirm our conversation of 11/12/79. The 1,601 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*

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	120
30%	.243 caliber	90
30%	.222 caliber	90

We would also like consideration of the 300 units of 6mm if the plants can handle without any major interference.

[redacted]
@JH Carter

Bill

WJB/kam

RD 779

STOP, LOOK, AND LIVE

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

DON'T SAY IT—WRITE IT

HKB

To SEE BELOW Location

From W. J. BOETTNER Location ~~Bob Hall~~ Phone No.

Subject MODEL 600 MANNLICHER STOCKED GUN Date 9/11/79

for your info
Walt Mickey

C. F. WAGNER
K. B. SPERLING
J. E. PREISER
E. J. GINER
E. F. BARRETT
J. P. McANDREWS

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 + Bernie
9-18-79

RP 7/78

STOP, LOOK, AND LIVE

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

cc: M. F. deMayo

TO: C. T. WAGNER (IN TURN)
R. B. SPERLING
J. E. PREISER
E. J. GINER
E. HOOTON, JR.
E. F. BARRETT
J. P. McANDREWS

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.

WJb/kw
Attach.
[illegible]

REMINGTON ARMS GMBH

INTER-DEPARTMENTAL CORRESPONDENCE

Remington.

DUPONT

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.

Günther Dröge

approved by:

incl.

.....
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 Smith requirements for Model 600 barrelled actions.

Janet Murphy

Remington
ORDER SERVICES
Remington Arms Company, Inc., Bridgeport, Conn. 06602

RD 1202

Remington.

REMINGTON ARMS COMPANY, INC.

PETERS

BRIDGEPORT, CONNECTICUT 06602
U.S.A.

SPORTING FIREARMS
AMMUNITION
TARGETS
TRAPS

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

SOLD TO:
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. 8/72

PRODUCTION

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-3392

RED AREAS FOR REMINGTON USE ONLY — FOR TRAFFIC

CODE

DATE: 10/31/79

FOR ORDER AND BILLING

SOLD TO:
Remington Arms GmbH
Winterhauser Str. 85
8700 Wurzburg-Heidingsfeld
West Germany

CUSTOMER ORDER NUMBER: 90309

REP/DIST. ORDER NO.

DATE: 3/14/79

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	400 –	125	Cal. 308 Win.		
	200		Cal. 222 Rem.		
	600				
dcw					

Copy

RD 1457 REV. 9/72

PRODUCTION

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

[illegible] SAY IT—WRITE IT

To _____ Date 11/30/79

From _____

Mot 600 [illegible] Actions 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 + 150

KEEP SAFETY IN MIND IN '79

Jan 25 308 cal 88
Jan 25 222 cal 62

OA Rev - 0

1-80 FCST PRODUCT -- M600 DATE ISSUED 10/25/79 PAGE
PEAK NOMINAL INVENTORY MONTH OF PEAK INVENTORY

	TOTAL DEMAND FORECAST	PRODUCTION						O	
		PLANT			PLANT				
		RATE M/DAY	DAYS	FCST. PROD.	RATE M/DAY	DAYS	FCST. PROD.	FCST. INV.	
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									

1-80 FCST PRODUCT — M600 PEAK NOMINAL INVENTORY

DATE ISSUED 10/25/79 MONTH OF PEAK INVENTORY

PAGE

	TOTAL DEMAND FORECAST	PRODUCTION PLANT RATE M/DAY	PLANT DAYS	PLANT FCST. PROD.	PLANT RATE M/DAY	PLANT DAYS	PLANT FCST. PROD.	FCST. INV.
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 + Rec Assm.	180
.308 cal	" " "	900

Requirements - Marketing

	FCST	SHIPPED	BALANCE	+ armorers	
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

Armorers Requirement

222 cal	100	complete in armorers 1/80
243 cal	216	
308 cal	240	complete " " " 1/80
6MM cal	96	
	652	

G-88

DON'T SAY IT — WRITE IT

To J. H. Carter

From D. J. Sanita

Date 11/12/79

all Mok 600 Barrel 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

	Avail. - Bbl. Assm Area.	Rqd.
.222 - 900	180	720
.243 - 900	—	900
6MM - 300	—	300
.308 - 1200	951	300
		2220

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
	2,872

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	(.2225)
		4,750	

M600

Per Bill Bottoms on 11/12/79. The 3000 feet for 1980 includes the balance of Px 3392 + 3393 and 300 Mannlicher stocks.

Copies to
~~Copies~~:
Mike / Bernie

Per Walt Nickel, International Sales wants M600 Barrel Actions only.

900	~~+000~~	222 cal
900	+000	243
1200	~~+000~~	308
	300	6MM.

They would like them early in 1980.
Please review and advise what the ramification would be on ~~the chart~~ other models.

Jack
10-18-79

Changed per W. Nickel on 10/22/79.
Want .222 cal first.

Jack
10-22-79

Plus Bbl. Actions

Cal	Actions Parts Sales	#1 FCST	Mann Act	Arms 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
308 cal	500		500	440
222 cal	860	690		
243		710	557	
6M			396	

Remington

REMINGTON ARMS COMPANY, INC.

BRIDGEPORT, CONNECTICUT 06602
U.S.A.

PETERS

SPORTING FIREARMS
AMMUNITION
TARGETS
TRAPS

CABLE—HARTLEY, BRIDGEPORT
TELEX: (964-286) & (964-201)

INTERNATIONAL SALES ORDER FORM

AX-11860

3-30- Called Ed Cupin & Herb Albany!
Per Herb A- do not fill order at this time.

3/29/79

B/O Special
Priority 90

SOLD TO
REMINGTON ARMS GMBH
Winterhäuser Str. 85
8700 Würzburg 21

CUSTOMER ORDER NUMBER: 90309
REP/DIST. ORDER NO.:
DATE: 14 Mar 79
TERMS:
SHIPMENT: ocean freight
DESTINATION: West Germany
KLS.: x
INSURANCE: yes

MARK
REMINGTON ARMS GMBH
Winterhäuser Str. 85
8700 Würzburg 21

FOREIGN BANK:

IMPORT PERMIT:

CONSIGNMENT:

RECEIVED
MAR 30 1979
ARMS SERVICE

REMARKS: SPECIAL INSTRUCTIONS

QUANTITY	INDEX NUMBER	DESCRIPTION	UNIT PRICE	U.S. DOLLAR VALUE
		BARRELLED ACTIONS MOD 600		
400		cal. 308 Win		
200		cal. 222 Rem		
~~200~~		cal. 243 Win		
~~500~~ 600				

Remington®

REMINGTON ARMS COMPANY, INC.

PETERS

BRIDGEPORT, CONNECTICUT 06602
U.S.A.

SPORTING FIREARMS
AMMUNITION
TARGETS
TRAPS

CABLE—HARTLEY, BRIDGEPO
TELEX: (964-286) & (964-201)

INTERNATIONAL SALES ORDER FORM

REMINGTON ORDER NUMBER: AX-21680

RED AREAS FOR REMINGTON USE ONLY — FOR TRAFFIC

CODE

DATE: 5/25/79

FOR ORDER AND BILLING

B/O Special
Priority 90

SOLD TO
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: Ocean Freig

DESTINATION: WEST GERMANY

KLS.: X

INSURANCE: Yes

MARK

FOREIGN BANK

IMPORT PERMIT

CONSIGNMENT

REMARKS: SPECIAL INSTRUCTIONS

RAMAC NUMBER	QUANTITY	INDEX NUMBER	DESCRIPTION	UNIT PRICE	U.S. DOLLAR VALUE
			BARRELLED ACTIONS MOD 600		
	500 ✓		Cal. 308 Win +400 = 900		
	350 ✓		Cal. 222 Rem' + 200 = 550		
	~~350~~ 151		Cal. 243 Win + 200 = 550		
	~~+200~~ 1051		2000		
dcw					

RD 1457 REV. 9/72

PRODUCTION

BARBER - PRESALE R 0127754

RD-69 REV. 6-58

11-3-78

REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE

Remington DUPONT

cc: E. J. Giner
H. D. Albaugh
H. K. Boyle

October 31, 1978

Copies to Mich & Barnes
11-2-78

J. H. Carter

TO: ~~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

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

BARBER - PRESALE R 0127754
R2528742

M600 Production Fcst

June	50/day	=	950	(less trigger assy)
July	43/day	=	945	(505 less trigger assy plus 405 WIP)
Aug	33/day	=	360	(all WIP)
Sept	48/day	=	1050	(all WIP)
Oct	48/day	=	1050	(all WIP)
	Total		4355	

6-7-99

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.- 155 ON ASSEM.
911 IN BOLT ASSEM. PROCESS

RECS. IN LINE - .308 OR .222 - 6,251

RD-69-B

REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE

Remington (DUPONT) PETERS (DUPONT)

cc: P.H. Holmberg
W.H. Forson, Jr.

"CONFINE YOUR LETTER TO ONE SUBJECT ONLY"

Copies to Mike + Bernie
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.
1,455	Total

WORK-IN-PROCESS PARTS TO BUILD RIFLE ASSEMBLIES

1,000	.222 Cal.
1,900	.308 Cal.
2,900	Total

WAREHOUSE INVENTORY - ASSEMBLED RIFLES

25	.222 Cal.
250	.243 Cal.
245	.308 Cal.
85	6MM
605	Total

TOTAL AVAILABLE

In Process	Whs. Inv.	Total	
1,125	25	1,150	.222 Cal.
865	250	1,115	.243 Cal.
2,365	245	2,610	.308 Cal.
--	85	85	6MM
4,355	605	4,960	

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

1455

June 950

July 505 + 440

Aug 360

Sept 1050

Oct 1050

4355

RD-80 REV. 6-66

REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE

Remington

cc: P. H. Holmberg

File

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 [1]	+	WORK IN PROCESS [2]	=	TOTAL M/600 AVAILABLE	-	DOMESTIC ORDERS [3]	-	TOTAL INTERNAT. REQUIREMENTS [4]	=	BALANCE NOT SOLD [5]
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.

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

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.

W. H. Foran, Jr.

WHF;bp

M600

	Available Less Trigger	W.I.P.	Whse Inv	Total	Intl Orders Action
.222	125	1000	25	1150	550
.243	865	—	250	1115	550
308	465	1900	245	2610	900
Total	1455	2900	520	4875	2000

RD-69-B

REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE

Remington (DU PONT) PETERS (DU PONT)

"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

125	.222 Cal.
865	.243 Cal.
465	.308 Cal.
1,455	Total

WORK-IN-PROCESS PARTS TO BUILD RIFLE ASSEMBLIES

1,000	.222 Cal.
1,900	.308 Cal.
2,900	Total

WAREHOUSE INVENTORY - ASSEMBLED RIFLES

25	.222 Cal.
250	.243 Cal.
245	.308 Cal.
85	6MM
605	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

BARBER - PRESALE R

REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE

cc: P. H. Holmberg

File

Bridgeport, Connecticut
May 23, 1979

TO: J. E. PREISER

FROM: W. H. FORSON JR.

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6150 222	288		1,250 1000		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 1900 2900 = 6548		3,544		475		1,100		1,969
TOTALS	3,648	+	3,380	=	7,028	-	3,751	-	2,500	=	2,777

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2) Count supplied by Jack Carter 5/21/79.
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4) Calendar year requirements including 100 222 and 400 308 already shipped to GMBH.
5) As of 5/21/79.

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

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Paul and I would like to discuss this matter with you at your earliest convenience.

W. H. Foran, Jr.

WHF;bp

G-88

DON'T SAY IT — WRITE IT

To Jack

From Dennis

Date 5/31/79

7 yr Usage Mdl 600 Barrel & Receiver Components for Arms Service

243 cal. - 75
6MM cal. - 50
222 cal - 50
308 cal. - 75

KEEP SAFETY IN MIND IN '79

SPORTING FIREARMS
AMMUNITION
TARGETS
TRAPS

BRIDGEPORT, CONNECTICUT 06602
U.S.A.

CABLE—HARTLEY, BRIDGEPORT
TELEX: (964-286) & (964-261)

INTERNATIONAL SALES ORDER FORM

REMINGTON ORDER NUMBER: PX-2714

CODE

DATE: 7/05/78

SOLD TO:
REMINGTON ARMS GMBH
WINTERHAUSER STR 85
8700 WURZBURG-HEIDINGSFELD
W. GERMANY

CUSTOMER ORDER NUMBER: SM: 06/156
REP/DIST. ORDER NO.
DATE: 6/29/78

TERMS
SHIPMENT

DESTINATION: W. GERMANY
KLS.
INSURANCE

MARK: ADDRESSED

FOREIGN BANK

IMPORT PERMIT

CONSIGNMENT

REMARKS: SPECIAL INSTRUCTIONS

RECEIVED
JUN -6 1978
ARMS SERVICE

QUANTITY	INDEX NUMBER	DESCRIPTION	UNIT PRICE	U.S. DOLLAR VALUE
400		M/600 CAL. 308 BARRELLED ACTIONS		
100		M/600 CAL. 222 BARRELLED ACTIONS		
		Okay to ship per Jack Brown + Hal Albaugh 1-5-79		
7/05/78 ca				

TRAFFIC

RD 1457 REV. 9/72

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

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:

Caliber	Quantity Requested	1980 Factory Cost M/600 Barreled Action
222	920	$ 75.03
243	717	$ 74.54
308	499	$ 74.15
6mm	96	$ 74.41

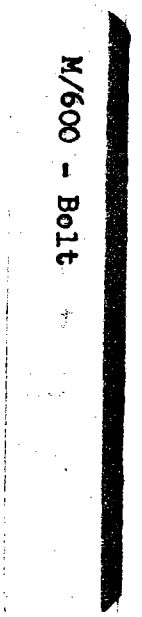
R. S. Swartz, Superintendent
INDUSTRIAL ENGINEERING SECTION

R. S. Swartz √ Ruff/c.

by S. M. Morris

SMM/mc

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON


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 ± .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.

N. S. Thompson
Sr. Process Engineer

NST/eb

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

RD-67-1

REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE

Remington (DUPONT) PETERS (DUPONT)

"CONFINE YOUR LETTER TO ONE SUBJECT ONLY"

Ilion, New York

MEMORANDUM December 15, 1965

TO: 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$^{R.}$ 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.

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.

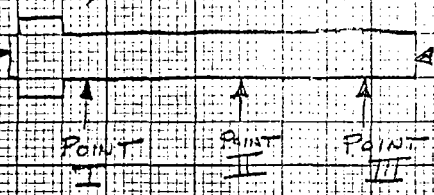
H. J. Waterman
Firearms Research & Design

HJW:T

cc

M/600 Bolt Body Assembly 9-10-64

RUN 2 PASSES ON CENTERLESS GRIND RLS
TO BODY DIAMETER OF .696



CENTERLESS

CYLINDERICAL

TOTAL INDICATOR READING

.012
.011
.010
.009
.008
.007
.006
.005
.004
.003
.002
.001
.000

POINT II
POINT III
POINT I
POINT II

10 X 10 TO THE ½ INCH
KEUFFEL & ESSER CO.
358-11
MADE IN U.S.A.

9/2/64

RB Hurley

M/700-600 - [illegible] Body
Grind [illegible]

The following are comparisons for the Cinn. Grinder:

(1)	Actual Schedule	[illegible] Bolts/day
(2)	Production Schedule (includes [illegible])	420 Bolts/day ←
(3)	Grind Time new [illegible]	
	(.7145 turn dia - [illegible]	
	load-unload - [illegible])	2.1 Min
(4)	Capacity per hour	28.6 Bolts/hr
(5)	Capacity 15hr @ [illegible] eff.	340 Bolts/day ←
(6)	Grind Time old [illegible]	
	(.7045 turn dia - [illegible]	
	load-unload & release)	1.4 Min
(7)	Capacity per hour	43 Bolts/hr
(8)	Capacity 15hr @ 75% eff	515 Bolts/day ←

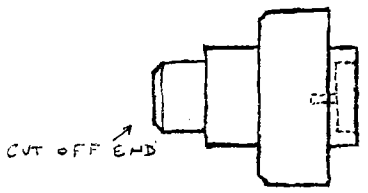
Bolts are warped from heat treat - new .025 T.I.R. runout in center - this causes problems with grinding wheel hitting head on first pass.

BY K. BURGER DATE 11-8-62 SUBJECT .30 - 30 BOLT SHEET NO. 1 OF 1
CHKD. BY _____ DATE _____ JOB NO. _____

600 Bolt

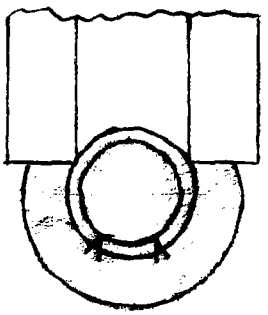
BOLT HEAD

OP # 5 DRILL, TURN, FORM, SHAVE AND CUT OFF.
SAME AS 700 BOLT HEAD - PT. NO. 15479, 15706
6 SPINDLE AUTOMATIC SCREW MACHINE.

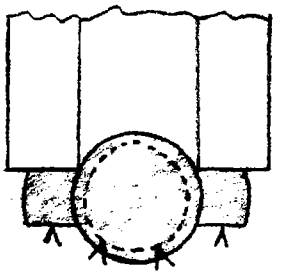


OP. # 10 BURR CUT OFF END. (BENCH GRINDER)
SAME AS OP. # 10 ON PT. NO. 15479, 15706

OP # 15 CLIMB MILL BOLT LUGS
SAME AS OP. # 15 ON PT. NO. 15479, 15706

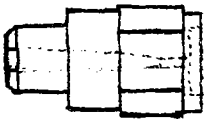


STEP 1



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. 15479, 15706
NO EJECTOR HOLE,
GAS ESCAPE HOLE,
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

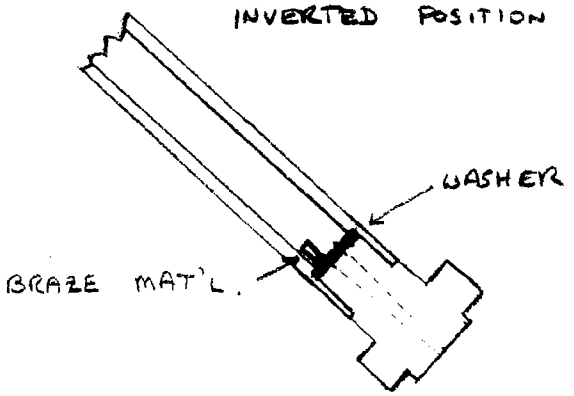
OP # 5 ASSEMBLE WASHER AND BOLT HEAD TO BOLT BODY.

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 BURR 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. ____

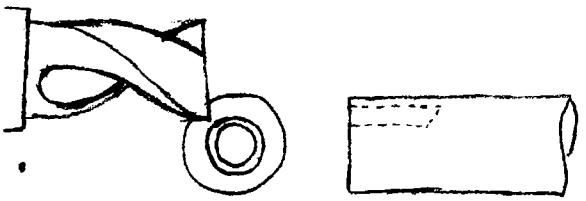
OP # 25 CYANIDE DEPLATE

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. Burger 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

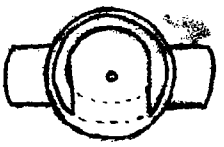
OP. # 75A GRIND FINISH BODY DIAM. ON CENTERS

SAME AS REGULAR 700 PROCESS
ADD USE TO 600

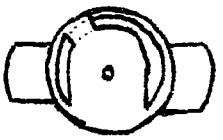
OP. # 80 GRIND LUGS TOP AND BOTTOM

SAME AS REGULAR 600 PROCESS

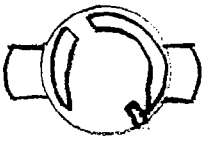
OP. # 87 MILL SHROUD FOR EJECTOR SLOT



OP # 92 MILL SHROUD FOR EXTRACTOR CUT

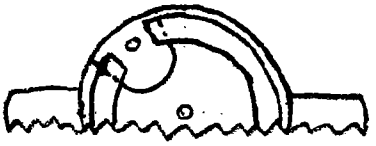


OP # 97 MILL EJECTOR SLOT



OP # 100 DRILL AND REAM EXTRACTOR HOLE

OP # 105 MILL EXTRACTOR ANGLE CUT



OP # 110 BURR

THIS IS TO REMOVE ANY BURRS 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

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

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

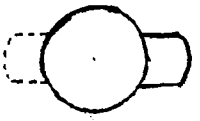
OP# 30 TEST BOLT HANDLE FOR BRAZE
SAME AS REGULAR 600 PROCESS

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

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

OP # 36-1 MILL OFF RIGHT BOLT LUG

DIFFERENT FROM REGULAR



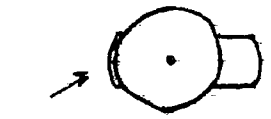
OP # 37-S MAGNAFLUX INSPECT 100 %

SAME AS REGULAR 700 PROCESS
ADD USE TO 600 ?

OP # 38-S BELT SAND BOLT HANDLE FLUSH WITH BOLT BODY AS REQUIRED.

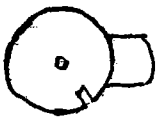
SAME AS REGULAR 700 PROCESS
ADD USE TO 600 ?

OP # 42 POLISH BLEND MISMATCH, [illegible]



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.

OP # 70 ROTARY FINISH - SAME AS REGULAR 600 PROCESS

OP # 75 SPIN FINISH - SAME AS REGULAR 600 PROCESS

File - M/600 Hallery Roddam

1964 M/600 Cal. 222 % Malfunction Rejects

	JAN	FEB	MAR	APR	MAY	JUNE	JULY	AUG	SEPT	OCT	NOV	DEC	
AB	.47		.11										
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								
DX	.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									[illegible]	.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	

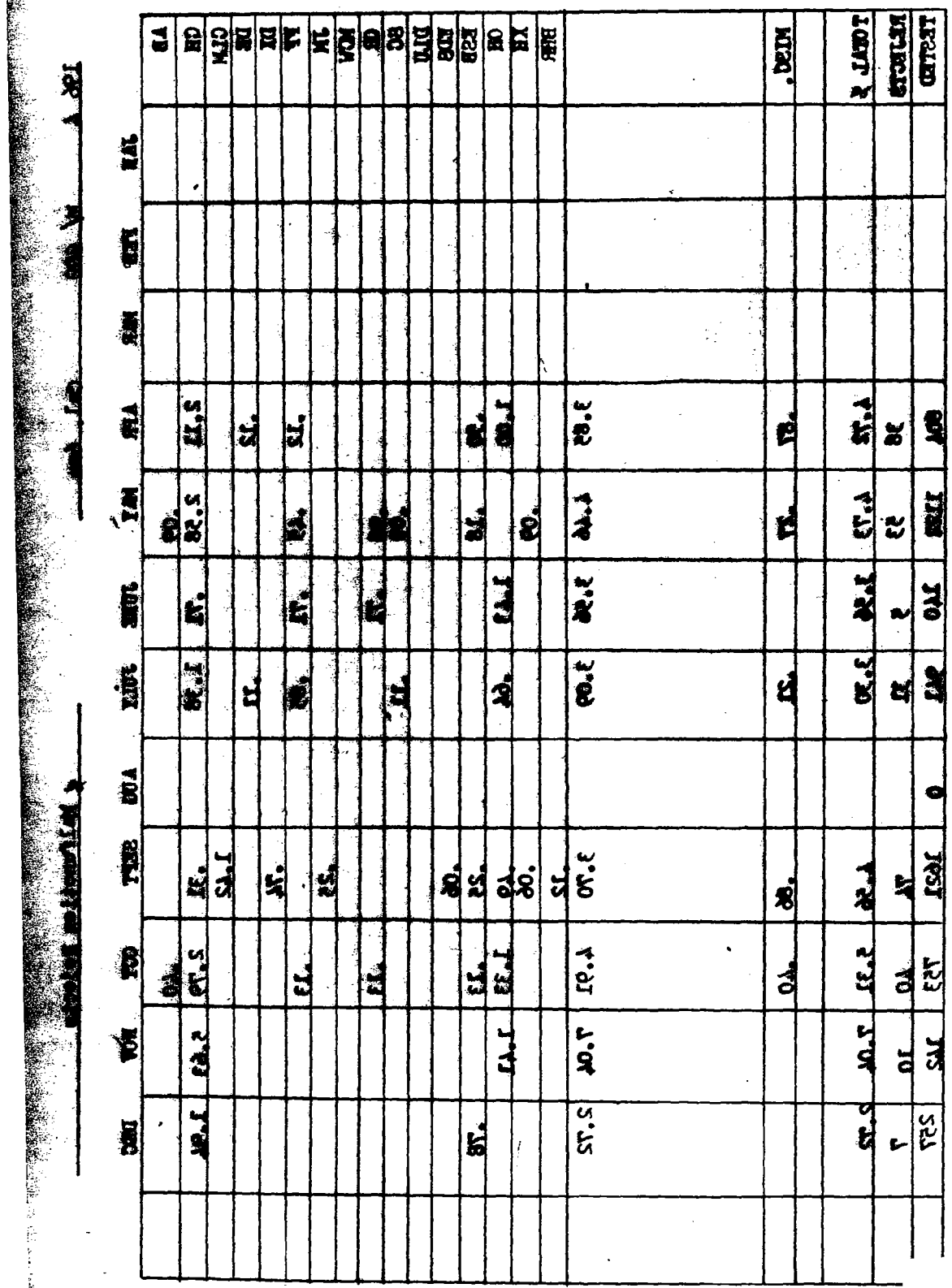
CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

BARBER - PRESALE R 0127786

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				
FF				.12	.45	.71	.85			.13			
JM									.25				
MCW													
GR					.28	.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	

BARBER - PRESALE R 0127786
R2528774



1964 M/600 Cal .308 % Malfunction Rejects

	JAN	FEB	MAR	APR	MAY	JUNE	JULY	AUG	SEPT	OCT	NOV	DEC	
AB		.08	.07		.39	.30			.16	.53	.20	.19	
CH		1.04	2.21	2.98	1.57	3.24	1.52	1.02	.57	.61	1.12	.32	
CLM		.48											
DE			2.89	2.05	.79	.38		.37		.70			
DK				.09			.09	.07		.09			
FF				.09		.08	.09	.07		.26		.13	
JM													
MCW										.09			
OR		.08	.07	.19		.15		.29	.16				
SC		.08			.39	.23						.06	
DLH		1.83		.19									
EDS		.16	.07	.09								.06	
ESB		.48	.33	.37		.08	.09	1.02	.57	.53	1.32		
OH		1.35	1.43	1.02	1.18	2.56			.41	1.66	.40	.46	
XH		.08	.13	.28	1.97	.98	.19		.08		.10		
BHR				.19								.06	
		5.66	7.41	7.54	6.29	7.90	1.98	2.84	1.95	4.47	3.14	1.28	
MISC.		.40	.22	.74	.80	1.53	.38	.51	.81	.79	2.24	.64	
TOTAL %		6.06	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	

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON
BARBER - PRESALE R 0127788 R2528776
BARBER - PRESALE R 0127788

	DEC	NOV	OCT	SEPT	AUG	JULY	JUNE	MAY	APR	MAR	FEB	JAN	
AB	.79	.20	.53	.74			.30	.39		.07	.08		
CH	.32	1.52	.49	.57	1.50	1.52	3.24	1.57	2.98	2.23	1.04		
CTM											.48		
DE			.70		.17		.86	.70	2.05	2.80			
MI			.09		.07	.09			.09				
PL	.13		.35		.07	.09	.08		.09				
TL													
MCM			.98										
QB				.74	.02		.12		.79	.07	.08		
SC	.08						.03	.02			.08		
TJD									.19		.13		
EGS	.06								.00	.07	.14		
BSB		.35	.53	.77	.08	.09	.04		.37	.33	.48		
OH	.46	.10	1.44	.43			2.54	1.18	1.05	1.43	1.32		
KH						.19	.08	1.27	.85	.13	.08		
BHH	.08	.10		.08					.19				
	.85	3.74	1.47	1.92	2.44	1.98	7.90	6.29	7.74	7.43	5.94		
MISC.													
	.94	4.54	.92	.18	.12	.24	1.53	.00	.74	.55	.07		
TOTAL $	1.98	5.38	5.26	2.76	3.32	2.36	9.43	6.29	8.28	7.69	6.06		
RECEIPTS	36	53	69	34	44	52	152	74	88	111	74	0	
CHARGES	2121	1944	2117	1530	1361	1201	1259	1254	1104	1258	1254	2	

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

1964 M/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													
DX												.84	
FF											.17		
JM													
MCW													
OR											.50		
SC		.19									3.70		
DLU													
EDS													
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	

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON
BARBER - PRESALE R 0127790
R2528778
BARBER - PRESALE R 0127790

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 # 1835 scrapped - The width of the opening across feed lips .007 over max
m/DWG .540 ± .005 -

Sm Alois RB Hurley
WE Leek F.G. Carlson

P. E. & C. ESTIMATE

TO: L. Fox

ESTIMATED BY P.B. Croop - V G Wekens

MODEL 600 - For Export PROJECT NO DATE 9/7/66

PROJECT TITLE In order to comply with the Barrel lenght 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

RD-49-B

REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE

Remington DUPONT PETERS DUPONT

"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
Ilion Research Division

W.E. Leek

HJW:T

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

HI-SPT ESTIMATE

PROCESS ENGINEERING ESTIMATE - TRIAL AND PILOT SHEET

• SEQUENCE OF OPERATIONS •

MODEL X-660 COMPONENT BARREL EXTENSION PART NO. _____

DATE 5-2-66 COMPUTER IBM SHEET 1 OF 1

OPER NO	OPERATION NAME	MACHINE	DEPT. NO.	HOURS DESIGN	HOURS BUILD
	PURCHASE FROM VENDOR	SCREW MACH			
	VENDOR'S PC/PR			$1.00	EACH
	VENDOR'S TOOL COST			$990.00	
	(NOTE: PC PRICE SAME FOR STD & MRB)				
	PURCHASE INSPECT				
	MICS	STD		—	—
	FED. RECESS GAGE	2 REQ'D			$300.00
	SPECIAL PLUG			6	60
	CALIPERS	STD			
	DEPTH PLUG			6	60
5	CARBONITRIDE HARDEN				
10	DEBUR				
15	INSPECT FOR HARDNESS				
20	CENTERLESS GRIND				
25	BLACK OXIDE CLEAN				
	- TO BOLT ASSEM. -				
	TOTAL				

PC FORM 118-63

HI-SPOT ESTIMATE

PROCESS ENGINEERING ESTIMATE - TRIAL AND PILOT SHEET

• SEQUENCE OF OPERATIONS •

MODEL X-600 COMPONENT LOCK RING PART NO. _____

DATE 5-2-66 COMPUTER [illegible] SHEET 1 OF 1

OPER. NO.	OPERATION NAME	MACHINE	DEPT. NO.	HOURS DESIGN	HOURS BUILD
	PURCHASE FROM STAMPING VENDOR				
	VENDOR'S PC/PR			[illegible]	
	VENDOR'S TOOL COST			[illegible]	
	PURCHASE INSPECT				
	[illegible] GAGES				
5	NEUTRAL SALT HDN				
10	BRAW				
15	INSPECT FOR HO'NESS				
	TO DISPATCH AREA				
	TOTAL				

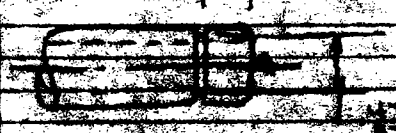
RD-8568 1-18-63

PROCESS ENGINEERING ESTIMATE - TRIAL AND PILOT SHEET

* SEQUENCE OF OPERATIONS *

MODEL 600 Export COMPONENT Barrel PART NO [illegible]

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 #26690 EXCEPT FOR THE FOLLOWING OPERATION				
75	TURN LOCK RING GROOVE	TURRET [illegible]			
		COLLET [illegible]	AU	-	-
		[illegible]	[illegible]	3	[illegible]
		[illegible]	"	1	1
		TOOL [illegible]	[illegible]	-	-
		[illegible]	[illegible]	-	-
		SPEC [illegible]	[illegible]	3	15
		" " [illegible]	"	3	15
		[illegible]	"	5	25
		FLAT RING GA. [illegible]	"	3	10
	TOTAL				

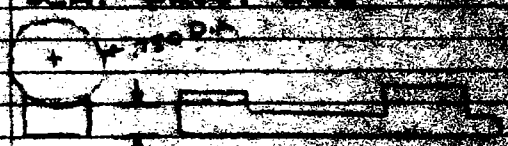
RD-6568 1-18-63

PROCESS ENGINEERING ESTIMATE - TRIAL AND PILOT SHEET

* SEQUENCE OF OPERATIONS *

MODEL 600 EXPORT COMPONENT BARREL RIB PART NO. [illegible]

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 [illegible] BARREL RIB [illegible] EXCEPT FOR THE FOLLOWING OPERATION				
20	MILL BARRE [illegible] SEAT FRONT END	[illegible]			
		[illegible]		25	60
		[illegible]	NEW	3	15
		[illegible]	STD	[illegible]	125
		[illegible]	NEW	5	20
		[illegible]	"	5	20
		[illegible]	"	5	20
	.150 - STD .140 MAG				
	TOTAL				

RD-6566 1-18-63

PROCESS ENGINEERING ESTIMATE - TRIAL AND PILOT SHEET

REF: D-29715

• SEQUENCE OF OPERATIONS •

MODEL 600 EXPORT COMPONENT FINAL ASSEMBLY PART NO. —

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 M1600 FINAL ASSEMBLY				
	EXCEPT FOR THE ADDITIONAL ELEMENTS				
	AT OPERATION 175 "FINAL ASSEMBLY"				
175	FINAL ASSEMBLY				
	27-1 - ASSEMBLE LOCK RING TO BARREL	[illegible]	[illegible]	[illegible]	
	27-2 - APPLY G.E. SILICONE RUBBER "CLEAR SEAL" TO BARREL				
	27-3 - [illegible] LOCK RING [illegible] EXTENSION TO BARREL	SPEC. [illegible]	NEW	3	5
	TOTAL				

RD-6568 1-18-63

M/600 - Trigger Housing

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

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	G. J. Hill
J. W. Bower	F. E. Martin
L. B. Ferriera	C. F. Prosser
B. H. Gilbert	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	J. Hutton
S. Bennett	C. Prosser
J. Bower	J. Snedeker
G. Hill	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 punch that forms the U-shaped section of the Safety arm. The vendor will correct. Temporarily, the Housing will be chamfered to provide clearance. — N. P. Process

2. Safety binds on Stock -
   a) Sidewise - caused by the Safety arm being fabricated at the wrong angle. The vendor has corrected. — N. P. Process
   b) Rearward - There appears to be an insufficient amount of clearance rearward. R & D is reviewing the model drawings. — R & D

3. Housing interferes with Reinforcing Screw in Stock - The 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. — Chem & Met

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 setting Trigger pull weight. — Process Eng.

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 - Put 40 - austration Jurisup - C Prosser 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	G. J. Hill
J. W. Bower	F. E. Martin
L. B. Ferriera	C. F. Prosser
B. H. Gilbert	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. / ajc

The following new items were discussed:

1. Design verification testing should be complete by 12/16. — R & D

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

M/600 FIRE CONTROL - contd. -2-

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

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

RD-69-B

REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE

Remington (DUPONT) PETERS (DUPONT)

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 interfers with the forward portion of the trigger housing. One thousand rounds of shooting bent gun A6520153 stock reinforcement screw forward approximately .050$^{+}_{-}$ inch and damaged the trigger adjustment screw.

2. Gun A653136 sear lift measurement was below the design specifications. (Min. - .007 Max. - .018 inches)

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

To: C. B. Workman
From: A. A. Hugick
Pilot - M/600 Rifles Adusing M/700 Trigger Housing

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

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

BARBER - PRESALE R 0127809

M600 Pilot Run - Production Run No. 1

9 Guns 12-6-77

Sear Lift & Engagement Were Measured on the Optical Comparator

		Test Preformed on the M1600 Rifles With the M700 Fire Control Housing.	Gun # 1 Ser. No. A6519901	Gun # 2 Ser. No. A6509265	Gun # 3 Ser. No. A6506712	Gun # 4 Ser. No. A6531366	Gun # 5 Ser. No. A6531113	Gun # 6 Ser. No. A6520147	Gun # 7 Ser. No. A6519785	Gun # 8 Ser. No. A6520153	Gun # 9 Ser. No. A6531367
1	1	Caliber of each gun	.6 MM	243	243	308	308	308	308	308	308
2	2	Firing Pin Indent - Measured in inches - Average of 5	.0243	.025	.0236	.0254	.0232	.024	.025	.0244	.0238
3	3	Trigger Pull - In lbs. - Average of 5	5.65	4.45	4.8	5.25	4.95	4.85	5.0	4.5	3.95
4	4	Safe "ON" - In lbs. - Average of 5	7.3	5.3	6.2	7.2	7.0	7.3	6.3	8.8	6.4
5	5	Safe "OFF" - In lbs. - Average of 5	8.2	4.45	6.9	9.3	11.1	7.5	5.4	10.5	9.0
6	6	Engagement - Measured in Inches	.0158	.0195	.0195	.0205	.0205	.0185	.022	.022	.023
7	7	Lift - Measured in Inches	.012	.0083	.0096	.006	.0098	.0115	.0138	.0133	.0110
8											
9	8	Lock Time - in Msec - Average of 10	3.1			3.1				3.0	
10	9	Accuracy - Average of 3 5 SHOT GROUPS at 100 yds.									
11		Accuracy Device was used — Horizontal	.43					.28			1.8
12		Vertical	.33					.29			1.2
13		Group (*)	.59					.34			2.1
14											
15	10	LIVE FIRE - SHOT FROM LIGHT JACK - ROUNDS		500						1000 *	500
16	11	ENGAGEMENT - AFTER 500 ROUNDS		.021							.0295
17		LIFT - AFTER 500 ROUNDS		.0079							.0085
18	12	ENGAGEMENT - AFTER 1000 ROUNDS								.026	
19		LIFT - AFTER 1000 ROUNDS								.0135	
20											
21	13	LOCK # DAY FIRE - 25000 CYC - MOLYKOTE LUBE - SEAR LIFT					.0097				
22		- ENGAGEMENT					.0221				
23		- TRIG. PULL					4.5				
24											
25	14	SAFE ON # OFF - 25000 CYC - TAI-FLON LUBE -									
26		SEAR LIFT							.0134		
27		ENGAGEMENT							.0195		
28		SAFE ON							4.25		
29		SAFE OFF							4.50		
30			10 IN - 4 FT			10 IN - 4 FT					
31	15	DROP TEST - SAFETY ON — TOP	1/3 - 0/3			0/3 - 0/3					
32		(STEEL & POLE / NO. DROPS) — BOTTOM	0/3 - 0/3			0/3 - 0/3					
33		MUZZLE	0/3 - 0/3			0/3 - 0/3					
34		BUTT	0/3 - 0/3			0/3 - 0/3					
35	16	DROP TEST - SAFETY OFF — TOP	3/3 - 3/3			0/3 - 0/3					
36		BOTTOM	0/3 - 0/3			3/3 - 3/3					
37		MUZZLE	0/3 - 0/3			0/3 - 0/3					
38		BUTT	0/3 - 1/3			2/3 - 2/3					
39											
40											

(*) Receiver With Known Muzzle Damage

+ Seeks Pawl Dog To Graduation

* Stock Chipped

12-19-77 A.W.
12-16-77 C.S.

BARBER - PRESALE R 0127809
R2528797

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

BARBER - PRESALE R 012781

m/600 Australian Gun Evaluation

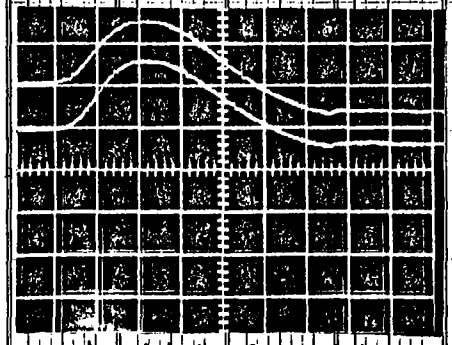
11-29-77 C.J. Sweet

Engagement & Lift were measured on the Optical Comparator by the use of the Reflection Unit.

GUN	CALIBER	Firing Pin Indent (mm) (Avg. of 5)	Trigger Pull (lbs) (Avg. of 5)	Safe "on" (lbs) Avg. of 3	Safe "off" (lbs)	Engagement* (Inches)	Lift* (Inches)
m/600 Serial No. A6315498	.308	.023	4.9	3.33	2.66	.0192	.0135
m/600 Serial No. A6371913	.308	.0237	4.75	5.33	4.16	.0205	.0135
m/600 Serial No. A6320045	.308	.0239	4.25	5.5	3.66	.0185	.0125

LOCK TIME
m/600
Serial No. A6520135

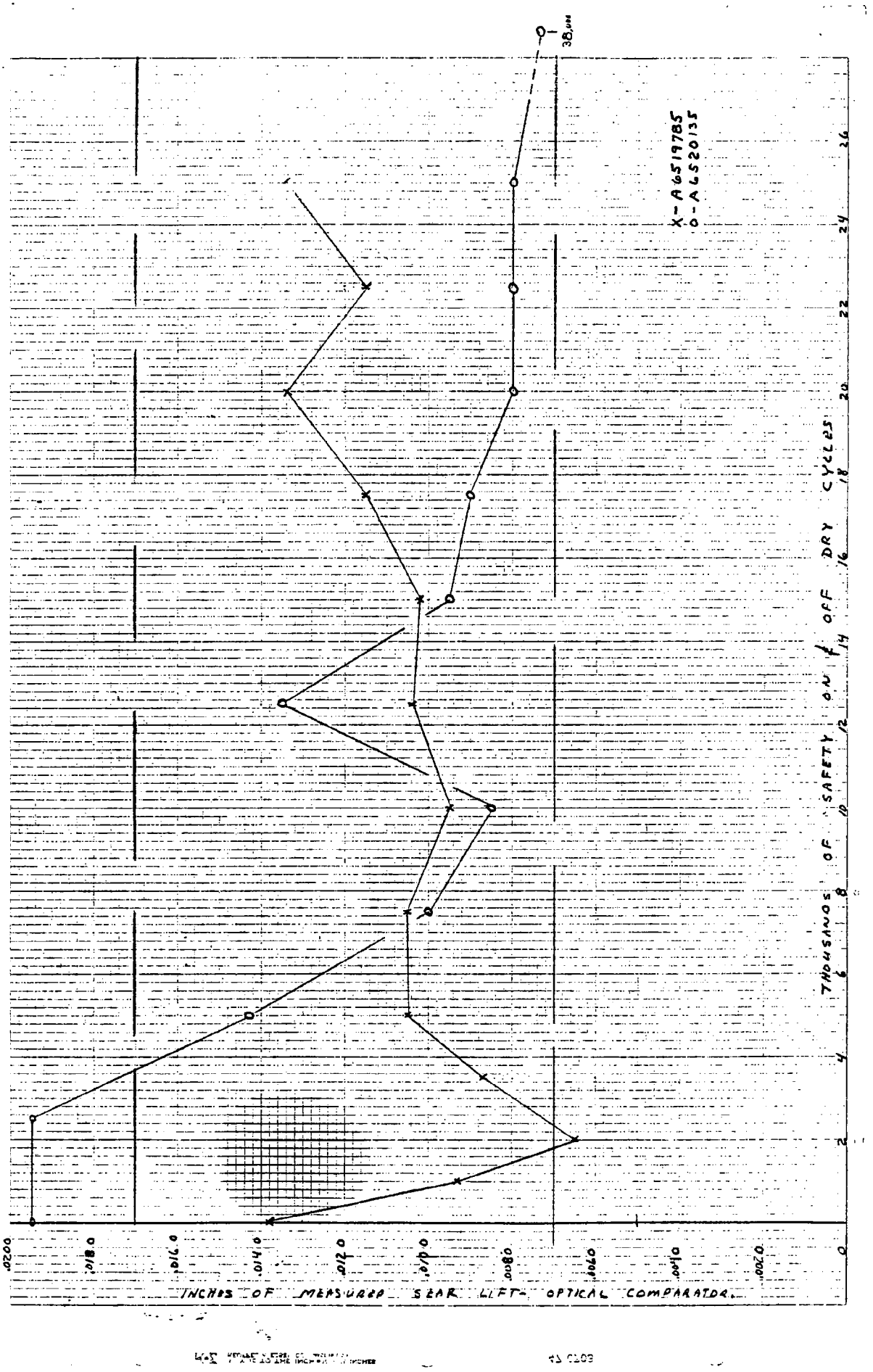
NO.	
1	33 MSec.
2	32 MSec.
3	32 MSec.
4	32 MSec.
5	33 MSec.
6	32 MSec.
7	32 MSec.
8	32 MSec.
9	32 MSec.
10	32 MSec.

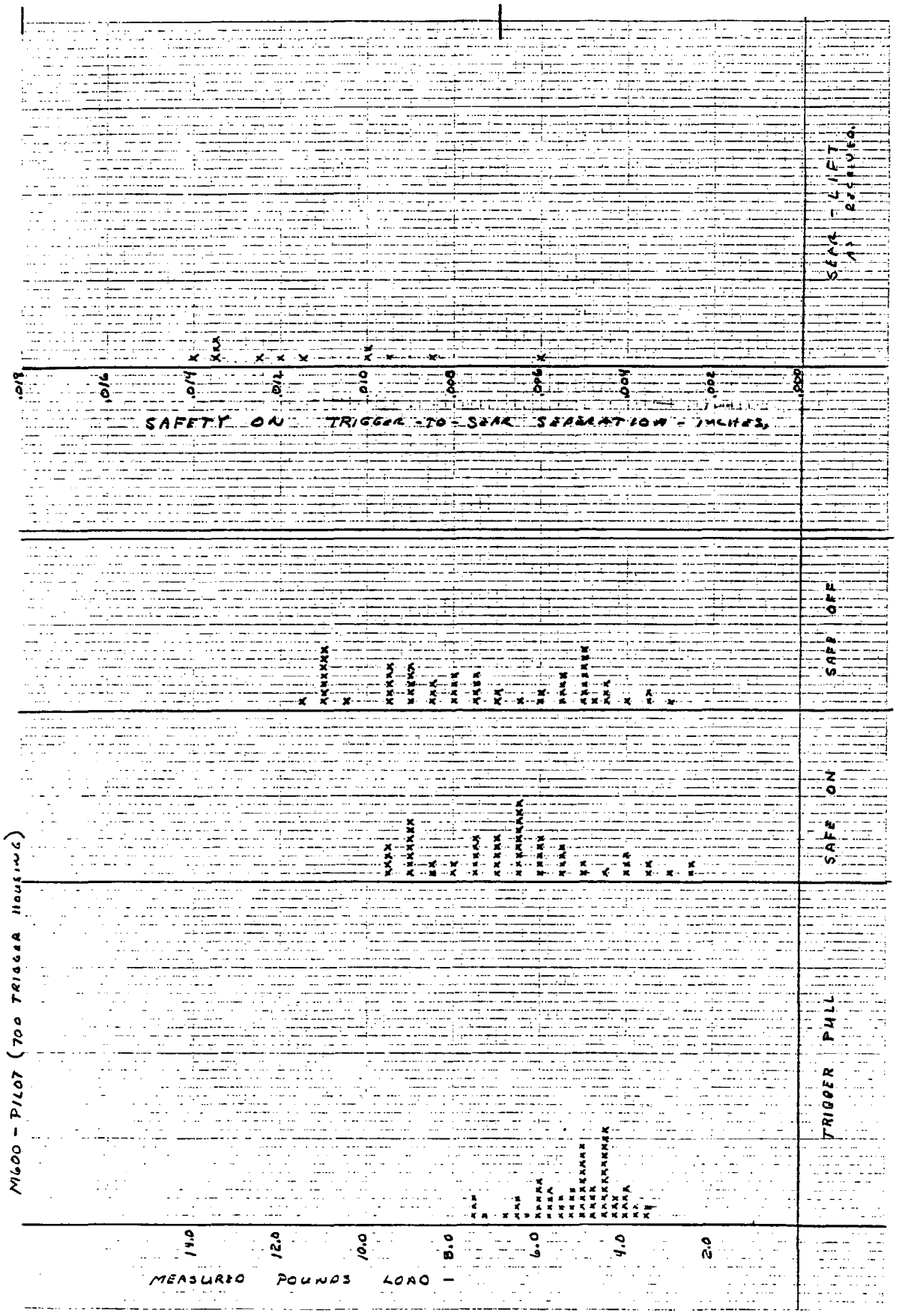


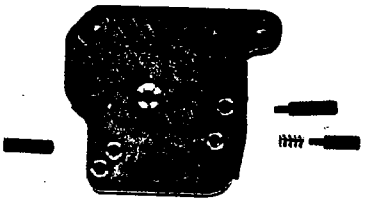
m/600 Australian Gun Ser. No. A6520135
Lock Time
.5 msec / Div
#1 & #2

*Original Safety Lever for Measurement

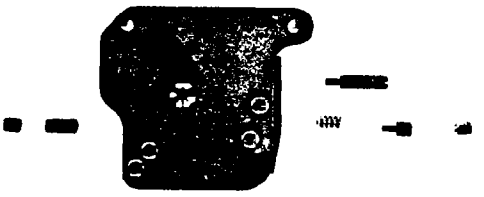
BARBER - PRESALE R 012781
R528798


X-A 6519785
O-A 6520135
THOUSANDS OF SAFETY ON OFF DRY CYCLES
INCHES OF MEASURED SEAR CLEFT- OPTICAL COMPARATOR.


SEAR - LIFT RELEASED
SAFETY ON TRIGGER-TO-SEAR SEPARATION - INCHES
.018
.016
.014
.012
.010
.008
.006
.004
.002
.000
SAFE OFF
SAFE ON
TRIGGER PULL
M600 - PILOT (700 TRIGGER HOUSING)
MEASURED POUNDS LOAD -
14.0
12.0
10.0
8.0
6.0
4.0
2.0



U. S.



AUSTRALIA

RD-48

REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE

Remington DUPONT PETERS DUPONT

"CONFINE YOUR LETTER TO ONE SUBJECT ONLY"

xc: G. J. Hill
Lab File

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.

Serial #	Safe On Force	Safe Off Force	Safety Function
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#	"

Serial #	Safe on - Sear Lift		Stock Reinforcement Screw - - to - Fire Control Condition
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

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

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.

Serial #	Safe On - Sear Lift		Stock Reinforcement Screw - - to - Fire Control condition
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) Supplied A.
.008 music wire)
.005 shim stock)

A A HUGICK

AAH:bd
Meas/Test Lab
Ilion Research Division

CC: D. J. Anderson, L. B. Bosquet, J. W. Bower, H. K. Boyle, J. J. Burns, R. J. Chesebrough, W. W. Cook, A. A. Hugick, C. A. Korba, J. P. Linde, R. J. Long, F. E. Martin, N. W. Menard, C. O. Pardee, C. F. Prosser, 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

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

CENTER FIRE - FIRE CONTROL - SAFETY PROBLEMS (cont.) - 2 -

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. — G. Hill
         - Mill thickness of safety .349-.346 — 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

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

Copies to: R. L. Hall
C. B. Workman
H. K. Boyle
R. J. Chesebrough
J. H. Sweeney
Est. File #3569

5/11/76
Matrix to issue Model drawings to reflect change

[redacted]
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.

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

RD-6
Rev. 6-10-67
1-12-71

ESTIMATE # 3569
ESTIMATED SAVINGS & RETURN ON INVESTMENT

NEW STYLE MODEL 600 TRIGGER ASSEMBLY

	PRESENT	PROPOSED		
Forecast Year	1977			
Quantity Forecast	14200			
OPERATING COSTS				
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 @				
Franchise Tax @				
	$ 54910	$ 47000	$	$
SAVINGS IN OPERATING COST		$ 7910		$
Less: All other expense:				
All Other 9.5 %; Federal Tax 48 %	.5294	$ 5450		$
NET SAVINGS		$ 4190		$
INVESTMENT				
Project expenditures		$ ——		$
Manufacturing and working facilities				
Net change in working capital		$ 3220		
Total capital required for this project		$ (3220)		$
RETURN ON INVESTMENT - THIS PROJECT		∞ %		%
NET SAVINGS - After Amortization of Operation Charges		$ 3120		$
Project Operation Charges		$ 12800		$
Less: Federal Tax ____ %		$ 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

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

RD-19-B

REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE

Remington DUPONT PETERS DUPONT

"CONFINE YOUR LETTER TO ONE SUBJECT ONLY"

xc: G. J. Hill ✓
Lab File
C B Workman
H K Boyle
J Bower
B Bosquet

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.

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

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.

Serial #	Safe On Force	Safe Off Force	Safety Function
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#	"

Serial #	Safe on - Sear Lift		Stock Reinforcement Screw - - to - Fire Control Condition
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

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

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.

Serial #	Safe On - Sear Lift		Stock Reinforcement Screw - - to - Fire Control condition
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)

A A HUGICK

AAH:bd
Meas/Test Lab
Ilion Research Division

939

WORK REQUEST

DATE REQUESTED 1-9-76 WORK ORDER E0262

DESIGNER OR ENGINEER J. P. LINDE

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 HOUSING M700 TRIGGER PLATE HOUSING) PER ATTACHED SHEETS.

GUNS REQUIRED

TEST COMPLETION DATE _____ SIGNED _____

B 1270

M/600 - Trigger

DON'T SAY IT—WRITE IT

To Kay

Date 3/20/75

From Jim

Re: M1600 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

RD-89-B

REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE

Remington (DUPONT) PETERS (DUPONT)

"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 Trigger

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 4/7/78

15435 M 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, Loctite Impregnate,

The Anneal will be in H-24 2050 1hr with LC-24 and SLW 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 shure barrel finish is picked up in the plant processing.

Let me know if there are problems.

copy G Hill Thanks
Ch

4/10/78 Process the same 600 700 } Have superstrain operations in PLR

DON'T SAY IT—WRITE IT

TO JERRY HILL DATE 11.14.78

FROM BILL WARREN ~~IAW~~ file

POWDER METAL PARTS - MOHAWK 600 TRIGGER ASSEMBLY

THE FOLLOWING PROBLEMS WITH POWDER METAL PARTS ARE ~~BEING NOTED~~ OCCURRING ON SUB-ASSEMBLY:

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 M700 TRIGGER.
- WHITE POWDER BLEEDOUT. WHEN CAN WE START PLASTIC IMPREGNATING THESE PARTS? M.D. COG. REQ'D.

SEAR SAFETY CAM C-9/470

- HOLE IS NOT COUNTERSUNK. BURR EXCEEDS ALLOWABLE M. DRAWING WIDTH. SEAR BINDS IN HOUSING. COMPARE TO M700 SEARS, WHICH ARE COUNTERSUNK AND WORK CORRECTLY. M.P. 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

Y

M/600

BARBER - PRESALE R 0127830

UTICA PLATING COMPANY, INC.
76 WHITESBORO STREET - YORKVILLE, NEW YORK 13495
FIRST NATIONAL BANK BLDG. - UTICA, NEW YORK 13501
Area Code 315 Phones: Plant 736-3079 - Office 732-2505

MESSAGE	REPLY
TO Remington Arms Company, Inc. Ilion, New York Attn: Mr. L. P. Ferriera	DATE
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.

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

CC: J. W. Bower
E. R. Carr
K. R. Chadwick
S. P. Cross
D. F. Kane
J. J. Marley
File

DC2 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

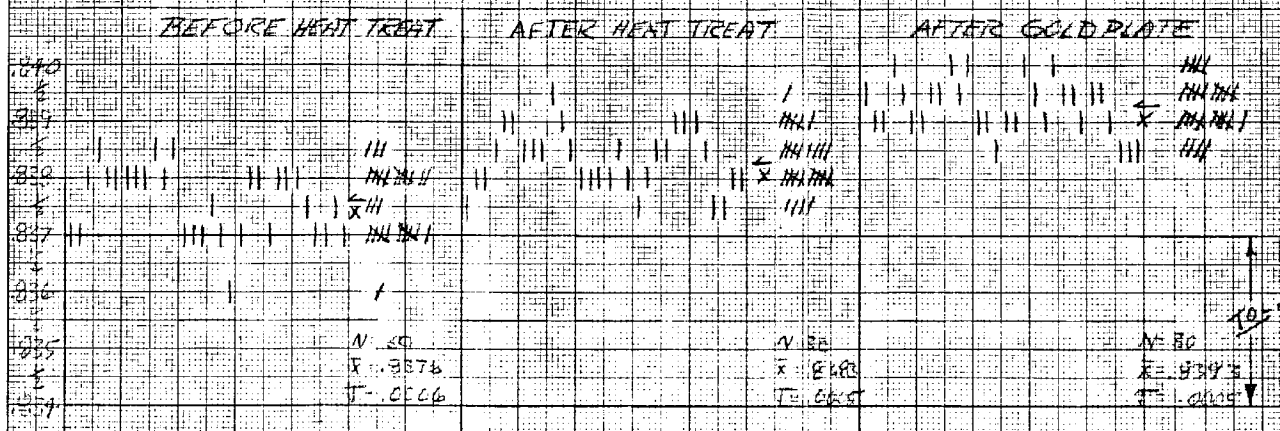
FC/GAG/bdm
Attachs.

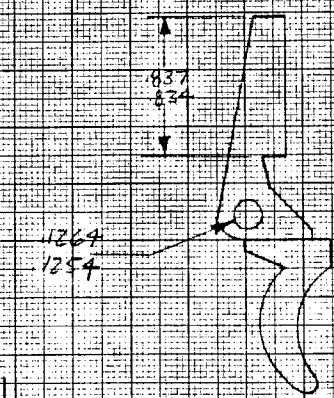
M/600 - Trigger Guard

M/600 TRIGGERS #90377 HEAT TREAT STUDY 5-29-73

OP 46 CYANIDE HARDEN, OP 47 DRAW, OP 48 SUPERSHEEN, AND VENDOR GOLDPLATE

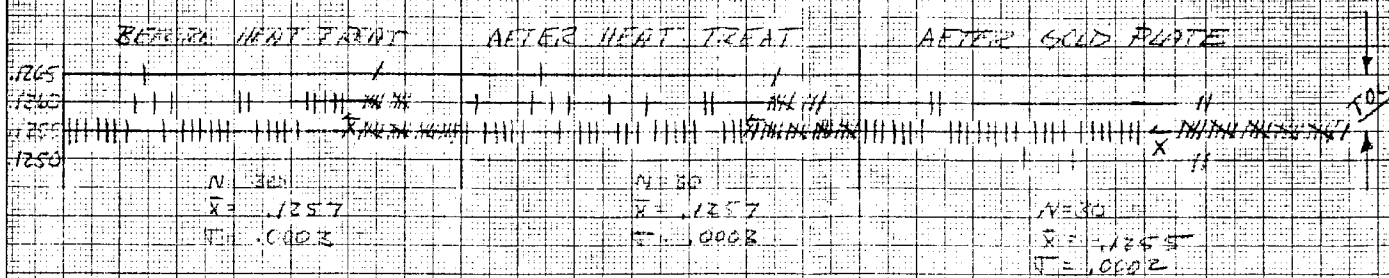
1" MICS DIM .837-.834 CONNECTOR CLEARANCE





GAGE PLUGS (.0005 INCREMENTS) DIM .1264-.1254

DIAMETER TRIGGER PIN HOLE



CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

600

RECEIVED
DEC 9 1963

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

CURRENT PRODUCTS
Process Engineering

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.

S. M. Alvis
Ilion Research Division

SMA:T

M/600 - Test Performance

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

March 20, 1967

FROM: W. R. GOOGIN

SUBJECT: M/600 6.5mm mag. AUDIT TEST

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 Two were below minimum specification
3.	Trigger pull	-	Eight were in specification Two were over maximum specifications
4.	Firing pin protrusion	-	All in Remington standards
5.	Bolt lift	-	In specification
6.	Group size (Avg. of 3-5 shot groups Shot in accuracy device with Rem. 120 gr. psp cl)	-	Seven passed Three rejected
7A	Further accuracy (the three reject guns and the three best were reshot from the shoulder)	-	All six were in specifications
7B	Two of the reject guns were then reshot in the accuracy device	-	Both were in specifications (results not recorded)

REMINGTON ARMS COMPANY, INC.

ENGINEERING DEPARTMENT COMPUTATION SHEET

Audit test

M600 MAG. 6.5 MM MAG. Accuracy, machine rest 100 yds

Rem 120 gr. PSP C.L. COMPUTER [illegible] 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
	2	2.95	.7	2.9	broke off after
	3	*	*	*	second group
	AVG.	3.15	1.53	3.03	
GUN #4 75662	1				
	2	GUN WOULD NOT FIT PROPERLY IN MACHINE REST.			
	AVG 3				
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

Rem 120gr. PSP C.L.

COMPUTED [illegible] DATE Feb 9 67

		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
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
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
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	0.58
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
.222/600 - 6.5 m/m MAG. AUDIT TEST
T.R. 2/15 67

SUMMARY
ACCURACY FROM SHOULDER
VS.
MACHINE

RANGE = NEW 100 Yd. - BENCH REST
SIGHTS = SCOPE - BALVAR 8A - KUHARSKY - 1-PIECE MT.
AMMO = REM - 120 GR - PSPCL, FACTORY
INDEX # - 2065 CODE # - 6071.
GROUP = 3-5 SHOT SPS. PER GUN
AIM = CENTER TO CENTER
SHOOTERS - W.R. GOGGIN & T.T. PUNNETT

ALL FIGURES ARE OF THREE SPS.

GUN #	FROM MACHINE			FROM SHOULDER		
	GR SIZE	HOR. SPD	VER. SPD	GR. SIZE.	HOR. SPD.	VER. SPD.
× ① = [illegible]	2.18"	1.57"	1.58"	2.62"	2.13	1.92
× ⑤ = 72763	2.96"	1.43"	2.70"	2.40"	2.27	.88"
⑥ = 74204	4.01"	2.17"	3.53"	3.00"	2.26"	2.45"
⑧ = 70650	2.96"	2.70"	2.30"	3.40"	2.78"	2.56"
⑨ = 73463	3.55"	2.27"	2.58	1.65"	1.25"	1.55"
× ⑩ 75078	4.40"	2.20	4.01	2.27"	1.87"	1.83"

REMINGTON ARMS COMPANY INC.

ENGINEERING DEPARTMENT COMPUTATION SHEET

AUDIT TEST

M600 6.5MM MAG.

PARAMETERS AS RECEIVED CLF 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	739_{69}	751_{34}	732_{84}	756_{62}	737_{83}	742_{04}	741_{81}	708_{50}	734_{62}	750_{78}	
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	.01985	.01985	.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	.056	.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	1.56	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, HORIZ VERT SPRD						OK - WITHIN STDS.				OK WITHIN STDS.	
GUN FEATURES			BROKE BOLT HANDLE								

600 - 30# 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 "NOREAR" ®

600 – 308 CAL. PILOT – 9/10/63 KFSD.

DATE	GUN	CORRECT.	TOTAL RDS	% MALF.	ESB	DE	MCW	SLC	HBL	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

12/9/63

M600 – 35 Cal.

200 Gr. Bullet
.030 Shim Under Rear Sight
.030 Removed From Front Sight

Gun #	Impact Pt.	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
1505	1"H 0	5.551	5.431	.120	.166	211
1466	1"H 0	5.537	5.429	.109	.154	192
1443	½"H 0	5.508	5.410	.098	.130	172
1434	½"L 1"R	5.525	5.410	.115	.145	186
1473	1"H-0	5.304	5.195	.109	.160	227
1450	1"H 0R	5.544	5.415	.129	.168	210
1576	0-1 R	5.525	5.425	.100	.140	191

BARBER - PRESALE R 0127844

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

BARBER - PRESALE R 0127844

R2528832

M/600 - Magnum

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

RD-69 REV. 6-58

REMINGTON ARMS COMPANY, INC.
INTER-DEPARTMENTAL CORRESPONDENCE

Remington

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) B.B. Hartley

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., [illegible] 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.

BARBER - PRESALE R 0127850

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 reworked 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

RJW:GMS

cc

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KINZER V. REMINGTON

BARBER - PRESALE R 0127850

R2528838

P. E. & C. ESTIMATE

F.G. Carlson

TO: H.S. Hackman

ESTIMATED BY: V.G. Jeremy

MODEL 600 Magnum PROJECT NO. DATE 5/27/65

PROJECT TITLE Estimate to add 6.5 mm to the model 600 Magnum R.H.E.

	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 R+D Changes - not to be included in project			600
ADMINISTRATION R+D Changes - not to be included in project			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

COMMENTS

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

BARBER - PRESALE R 0127854

File -
M/600 Product Safety

CC: W. E. Ackley, D. J. Anderson, J. W. Bower, J. J. Burns, R. J. Chesebrough, W. W. Cook, A. Huffman, E. D. Johnson, A. D. Kerr, N. W. Menard, C. F. Prosser, C. O. Pardee, R. L. Stafford, C. B. Workman, File

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 Operation #116 - Line Ream Fire Control Holes. — J. Bower, 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
      (see attached reports) — C. Pardee, W. Ackley

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KINZER V. REMINGTON

BARBER - PRESALE R 0127854
R2528842

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, J. W. Bower, R. J. Chesebrough, R. L. Hall, A. D. Kerr, N. W. Menard, C. O. Pardee, T. H. Pratt, G. E. Puckett, C. B. Workman, R. E. Smith, 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	2AI	5	5		
243	16AI	5	5		
6mm	18AI	5	4	1	SEAR BINDS DOWN
6mm	15AI	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

CC: W. E. Ackley, J. W. Bower, R. J. Chesebrough, R. L. Hall, A. D. Kerr, N. W. Menard, C. O. Pardee, T. H. Pratt, G. E. Puckett, C. B. Workman, R. E. Smith, 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 GJH/bdm Rev. 5/7/74
Rev. 5/1/73

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

CC: W. E. Ackley, J. W. Bower, R. J. Chesebrough, R. L. Hall, A. D. Kerr, N. W. Menard, C. O. Pardee, T. H. Pratt, G. E. Puckett, C. B. Workman, R. E. Smith, _____, _____, File

File - M/600 Product Safety

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	2XI	5	5		
243	16XI	5	5		
6mm	15XI	5	4	1	SEAR BINDS DOWN
6mm	15XI	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

Please make copies and file separately ... 788, 742, 600, & 700 ... Gallery Rejects - Follow up Action

CC - A Kerr, R Chesebro, H Boyle, C Prosser, D Lonis, W Ackley, J Bower, C Prosser

DATE	MODEL	MALFUNCTION	CAUSE	ACTION
12/15	788	FOS	SAFE BINDS ON STOCK	Review Assembly Foreman.
12/22	742 (2)	FD #82	Incorrect adjustment Disconnector to action Bar	Reviewed Assembly Foreman & Supervisor
1/7	600	Hong Fire #85	Firing Pin binds on Bolt Plug	1) Reviewed assembly Supervisor 2) Reviewed production Foreman Dept 75
1/8	600	FD (6)	Sear binds on Trigger Housing	1) Reviewed Foreman
1/9	742 (2)	FD #94	Incorrect adjustment Disconnector to action Bar	Reviewed assembly Foreman
1/9	700	FSR	Safe binds on Stock	Reviewed assembly Foreman.

J.M., Bev, Make two additional copies and file under
M/600 - Product Safety
M/700 " "
M/742 " "

LOG OF SAFETY PROBLEMS

W/E	DEFECT		CAUSE
11/21/76	600	FD	FOREIGN MATTER BINDING SEAR
	742	FD	F.P. BINDS, RET PIN CUT MISCUT IN F.P.
	742	FD	DISC. LOOSE, DROPS OFF ACTION BAR
	700	FD	COCKING CAM & 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	FIRES 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.)

CC - A Oken, R Chesebrough, Wockley, R Joy, J Bower, N Menard, H Boyle, C Workman, C A Korba

GALLERY REJECTS - FOLLOW UP ACTION

File - M/600
Product Safety

DATE	MODEL	MALFUNCTION	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 Engineer 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 binding trigger.	Reviewed Production Foreman - He will review with operator.
2/6/76	600 (3)	FD	Sear Binds on Trigger Housing	Reviewed Assembly Foreman -

J J Hill
Quality Control