

BARBER - PRESALE R 0127889

REMINGTON ARMS COMPANY, INC. Firearms Research Division May 15, 1981

TO: C. B. WORKMAN

FROM: J. W. BROOKS

SUBJECT: BOLT ACTION CARBINE

This report covers work done on this project from August 1977 to May 1981.

JWB:T Attach. AI-81-9

BOLT ACTION CARBINE

August 1977 to May 1981

Project No. <u>C 1850</u>

Data in Report:

- 1. Pictures and information on 1977 models for Marketing
- 2. Pictures and information on 1978 models for Focus Panel
- 3. Focus Panel Report 1979
- 4. Pictures and information on 1980 models for Marketing
- 5. Field test reports of 1980 models
- 6. Picture of redefined model 1981

No previous reports have been written on this project.

This report prepared by:

John W. Brooks and Douglas E. Bullis Firearms Research Division May 1981

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CONTENTS

Heading

Introduction	1
Objectives	2
Summary & Conclusions	3
Patent Situation	4
Future Program	5
Acknowledgements	6
*Experimental Details	7
*Appendix	

*Omitted in abridged version.

INTRODUCTION

The goal of the Bolt Action Carbine project is to improve Remington's marketing position and increase sales by restyling the Mohawk 600 Rifle. This rifle has not had a change in the styling of the stock since it was originally introduced as the Model 600 in 1964. The barreled action had minor changes in 1968. The rifle is well liked as a brush gun because of its handling ability, short overall length, accuracy, and selection of calibers. It will be introduced to compete against carbine length rifles presently in the field.

OBJECTIVE

The work to be accomplished consists of redesigning the stock and barreled action for improved function, aesthetics, and weight reduction.

The work has covered three phases to date, and is presently in the fourth phase.

- o Models for Marketing evaluation completed in 1978.
- o Models for evaluation by a Marketing panel completed in 1979.
- o Models for field testing completed in 1980.
- o Redesigned models for field testing to be completed in 1981.

The first phase consisted of building models with all the features suggested by Marketing, the field force, and Research. These models were shown to Marketing to evaluate and decide what features should be included in the group of rifles to be shown to a Marketing Focus Panel.

The second phase consisted of building rifles with the features requested by Marketing for the Focus Panel exposure. Panels were held and results were tabulated and evaluated.

The third phase consisted of building models to test in-house and in the field. These models had the features requested by Marketing after their evaluation of the Focus Panel report.

The fourth phase consists of building models to test in-house and in the field. These models will have the added features that were requested after evaluation of the first field test. With satisfactory completion of this phase the model will be presented to the Operations Committee for addition to the Remington Centerfire Bolt Action line.

SUMMARY AND CONCLUSIONS

The project has been completed thru the third phase, which included field testing of the Bolt Action Carbine.

The reports were enthusiastic and complimentary. However, a large percentage of the reports indicated the rifle was too heavy.

In the fourth phase requirements were redefined which resulted in a smaller stock and smaller diameter barrel, reducing the overall weight by approximately one pound. Barreled actions with the smaller diameter barrel and the largest caliber to be introduced have been satisfactorily tested for strength. The rifles must still be tested for accuracy and the stock must be tested for strength.

PATENT SITUATION

The Patent Division has not discovered any unexpired competitively-owned patents that are relevant to the design being considered in this project. Initial investigation of a preliminary design of a new floor plate latching system suggests that patent protection may be obtainable for this design.

FUTURE PROGRAM

Completion of the Fourth Phase

Barreled actions of the latest design have been built in five of the proposed calibers. Five stocks of the latest design are being built and will be ready by the end of May. Accuracy and function testing of the rifles will be completed in 1981. Pending satisfactory completion of these tests, the Bolt Action Carbine is scheduled to be presented to the Operations Committee in June for approval to add this model to the Remington Centerfire Rifle line.

Twenty barreled actions of 7mm-08 Rem. caliber are being assembled for a new field test. They will be completed in May. Stocks have been ordered and will be completed in July. Rifles will be assembled and ready for a Marketing field test by September, 1981.

ACKNOWLEDGEMENTS

John Linde Design

Leon Johnson Stock models

(Retired)

Kurt Blumer Stock models and floor plate

(Resigned) design and models

Fred Martin Design

Douglas_Bullis Design

Adam Hugick Measurements & Test

James Hennings Measurements & Test

Richard Nightingale Measurements & Test

Christopher Miller Measurements & Test

EXPERIMENTAL HISTORY

Phase I In 1977 Marketing and Research agreed on a plan to restyle the Mohawk 600 rifle (Exhibits 1,2 & 3). Research began by building several models with various shaped stock stylings and barreled actions, with various additions and deletions, retaining the basic Mohawk 600 receiver and barrel. These models are shown in Exhibits 4 thru 8, with a list of changes that are different from the basic Mohawk 600 model. A meeting was held with Marketing and the above exhibit models were discussed to decide what features were to be shown to a focus panel. (Exhibit 9)

Phase II Six rifles were made up with the features discussed. (Exhibits 10 thru 15). These rifles were delivered to Marketing for use in the Focus Panel held January 1979. The group sessions were set up in three different marketing areas (Exhibit 16). A discussion guide and questionnaire (Exhibits 17 - 18) were used to obtain answers to the probability of acceptance of this Bolt Action Carbine concept. A final report (Exhibit 19) was written evaluating the concept. It stated that it is a "distinctive and promising new product prospect".

Phase III A subsequent meeting was held with Marketing to discuss the report. A decision was made on the design requirements of a final model using the panel report recommendations. (Exhibit 20)

Research proceeded to make final models for approval by Marketing. In order to add a hinged floor plate assembly the receiver had to be made a half inch longer and the rear receiver mounting hole moved back. The longer receiver can be made using existing Mohawk 600 tools and fixtures.

Two sample rifles were made using birch and walnut wood. (Exhibits 21 - 22). Marketing accepted the samples.

A meeting was then held with Process Engineering so they could discuss the new features of this model and changes could be made if possible to simplify processing and manufacture.

(Exhibit 23). At the same time models were started for accuracy, function, and field testing. Five hand made stocks were to be used for in-plant testing. The stocks were proofed four times each with each succeeding caliber. The stocks stood up well. The accuracy from the bench was well within the present plant specifications for these calibers in this and other centerfire rifles. (Exhibit 24)

Twenty stocks were ordered from Fajan from our handmade pattern, to be used for field testing. They were finished and fitted to actions by Remington personnel. The field test actions were all made up in 7mm-08. They were ready for field test in June 1980, and were sent to people designated by Marketing.

(Exhibits 25 - 26)

Costs were requested from Industrial Engineering.

Several updates were completed to cover possible changes in stock wood and finish and checkering. (Exhibits 27 thru 30) A separate cost was also requested for a proposed bolt lock mechanism. This mechanism has now been dropped from the latest model. (Exhibit 31)

A letter was received from the Patent Department (Exhibit 32) covering work to date on the new stamped floor plate design.

The field test models were returned to Ilion starting the first week of July. Marketing field test reports (Exhibit 33) indicated the rifle was too heavy and the stock was too fat. They requested that Research look at ways to reduce the overall weight by at least 3/4 of a pound. Research responded with several suggestions to meet this new criteria. (Exhibits 34 - 35) Subsequent testing indicated the required weight could be obtained by reducing the barrel diameter (Exhibit 36) and using walnut for the stock.

Phase IV New barreled actions were made with the smaller diameter barrels. A thinner stock was made up and a model was shown to Marketing. (Exhibit 37) They approved of the barreled action but requested further work be done on the stock. (Exhibits 38 - 39)

A sample was made with the grip and fore end slimmed down as requested by Marketing. Samples with a Schnabel fore end were also made to show them. (Exhibits 40, 41, 42)

The sample with the Schnabel fore end was accepted by Marketing. (Exhibit 40)

Five hand made samples are being built for accuracy and function testing of the 308, 7mm-08, 6mm, 243 and 222 calibers, and twenty stocks are being made by Fajan from a handmade pattern for field testing.

The test schedule becomes extremely important at this point because of the lighter barrel and stock. The first concern is what effect the heaviest caliber will have on the strength of the lighter stock. The second concern is what effect the smaller diameter barrel will have on accuracy and overall rifle function. These questions will be answered in June 1981.

APPENDIX

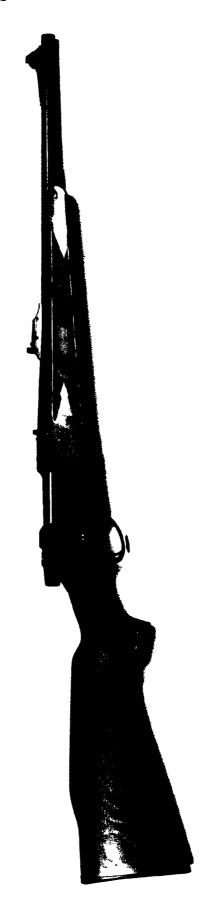


EXHIBIT NO. 1

MOHAWK 600 Production
Model

Serial No. A6390910

EXHIBIT 2

MODEL 600 CARBINE

Aug. 29, 1977

All models will have:

Barrel Length 16½ or 18"

Metal trigger guard

M700 barrel bracket

Standard short action cartridges

All have sling studs

Small sights

New tang design

Satin finish

Least expensive

- 1. Birch stock
 Black butt plate
 No checkering
 Straight pull stock
 - Plastic trigger guard
- 3. Birch stock
 Pistol grip no cap
 Black butt plate
 No checkering

- 4. Birch stock Pistol grip Recoil pad - 700 Classic No checkering
- 5. Same as above with 870 l" pad
- 6. Walnut stock with pistol grip Cut checkered 700 Classic recoil pad Sling, swivels and stud New bolt handle design

Typed 5-26-81 T

EXHIBIT 3

Xc: C. B. Workman

RD-49-6

REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE





"CONFINE YOUR LETTER TO ONE SUBJECT ONLY"____

Ilion, New York September 12, 1977

To:

W. J. Weeks - Bridgeport

J. H. Chambers -

H. D. Albaugh -

From:

J. P. Linde

Subject:

Research Inputs for the Model 600 Carbine Focus Panels

The consumer reactions to the following rifle characteristics would aid us in developing the M/600 Carbine. If you could combine these items into the upcoming focus panels, it would be appreciated.

- 1. Stock Styling General Type of Carbine Stock desired:
 - A. Straight pull Stock vs pistol grip Stock
 - B. Mannlicher Carbine Stock vs Classic Stock
 - C. Pistol grip thickness, grip shape, grip cap or no grip cap preference
 - D. Length of trigger pull
 - E. Preference of Stock fore-end shape
 - F. Preference of various styles of Recoil Pads and/or Butt Plates
 - G. Stock color light vs dark
 - H. Stock finish satin vs high gloss
 - I. Type of Wood vs sales price Walnut vs stained Birch
 - J. Cut Checkered more expensive rifle vs no checkering at less cost
- 2. Some idea of price versus anticipated product value of bolt action rifles compared to lever action rifles.
- 3. Would the customer plan on mounting a scope on the proposed carbine?

To:

W. J. Weeks

J. H. Chambers

Page 2

H. D. Albaugh

From:

J. P. Linde

Subject:

Research Inputs for the Model 600 Carbine Focus Panels

September 12, 1977

- 4. Iron Sight preference:
 - A. Buck Horn, such as lever action models
 - B. M/700 current sight, front and rear
 - C. Shortened M/700 sight and front sight ramp
 - D. Short fold-down sight such as Lyman blade sight
 - E. Receiver Sight
- 5. Barrel length preference 16, 18 or 20 inches.
- 6. Importance of modern cartridge selection bolt action vs lever action cartridges.

 308 Win., 6mm Rem. vs 30-30 Win. & 35 Rem.
- 7. Preferred Carbine Rifle weight comparison of selected models.
- 8. Preferred rifle length comparison of selected models.
- 9. Trigger Guard styling
- 10. Bolt Handle styling comparison of selected models.
- 11. Bolt Release with two position Safety general reaction to new design concept.
- 12. Would the customer like the sling included with the rifle?
- 13. Would the customer like the swivel study installed on the rifle at the factory? Would the customer find a swivel mounted on the barrel objectionable?
- 14. Type of Magazine Follower preferred cast, formed, machined.
- 15. Importance of metal finish and type preferred bright high luster vs dull satin finish.

J. P. Linde, Manager Manual Firearms Design Ilion Research Division

JPL/nl

EXHIBIT NO. 4 GUN SERIAL NUMBER A6550076

STOCK

WALNUT WOOD
VINYL FINISH
MODEL 700 CLASSIC RECOIL PAD
CLASSIC STYLING
INLET FOR TRIGGER GUARD
FRONT AND REAR SWIVEL STUDS

BARRELED ACTION

18% INCH BARREL LENGTH

Model 700 ADL short barreled action Model 700 trigger housing assembly Model 700 BDL front sight hood Model 700 BDL floor plate assembly

E . 4



EXHIBIT NO. 5 GUN SERIAL NUMBER A6786854

STOCK

BIRCH AND MAPLE LAMINATED WOOD GLOSS FINISH - RKW
CUT CHECKERING
CARBINE TYPE STRAIGHT GRIP
MODEL 870 RECOIL PAD
INLET FOR TRIGGER GUARD
REAR SWIVEL STUD

BARRELED ACTION

16½ INCH BARREL LENGTH
MODEL 700 BARREL BRACKET
NEW FRONT SIGHT BASE
FRONT SIGHT BY MARBLE
REAR SIGHT BY WILLIAMS
UNCLE MIKE'S FRONT SWIVEL RING
GOLD PLATED TRIGGER



EXHIBIT NO. 6 GUN SERIAL NUMBER 6841170

STOCK

BIRCH WOOD
GLOSS FINISH - RKW
CHEEKPIECE
CUT CHECKERING
CARBINE STYLE STRAIGHT GRIP
MODEL 700 BUTT PLATE
INLET FOR TRIGGER GUARD
FRONT AND REAR SWIVEL STUDS

BARRELED ACTION

18 INCH BARREL LENGTH
MODEL 700 ADL SHORT BARRELED ACTION
MODEL 700 TRIGGER HOUSING ASSEMBLY
MODEL 700 FLOOR PLATE ASSEMBLY
NEW FRONT SIGHT BASE
NEW FRONT SIGHT WITH WHITE PLASTIC BEAD
REAR SIGHT BY WILLIAMS



EXHIBIT NO. 7 GUN SERIAL NUMBER 6787144

STOCK

BIRCH WOOD
VINYL FINISH
CARBINE STYLE STRAIGHT GRIP
INLET FOR TRIGGER GUARD

BARRELED ACTION

16½ INCH BARREL LENGTH
MODEL 700 BARREL BRACKET
NEW FRONT SIGHT BASE
MODEL 700 FRONT SIGHT
REAR SIGHT BY WILLIAMS
GOLD PLATED TRIGGER



EXHIBIT NO. 8 GUN SERIAL NUMBER 6787241

STOCK

BIRCH WOOD

VINYL FINISH
CUT CHECKERING

MODEL 700 CLASSIC BUTT PAD
SCHNABEL DESIGN FORE END
INLET FOR TRIGGER GUARD
REAR SWIVEL STUD

BARRELED ACTION

16½ INCH BARREL LENGTH
MODEL 700 BARREL BRACKET
ALUMINUM TRIGGER GUARD - INVESTMENT CAST
NEW FRONT SIGHT BASE
MODEL 700 FRONT SIGHT
REAR SIGHT ASSEMBLY BY WILLIAMS
GOLD PLATED TRIGGER



RO-69 REV. 5-58

EXHIBIT 9

REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE

Remington,

CC: J. E. Preiser
C. B. Workman
W. J. Weeks
W. H. Forson, Jr.
J. H. Chambers

August 31, 1978

TO: J. W. BROOKS

FROM: H. D. ALBAUGH

BOLT ACTION CARBINE RIFLE

This is to confirm our meeting last week at which we reviewed various characteristics of the above gun. Each was placed into one of three categories as follows:

- We decided at meeting
- We will decide later
- Will submit to consumer panel

We Decided

- Pistol grip stock
- Open sights on barrel not "clean"
- Hooded front sight
- Aluminum trigger guard and floorplate
- Exterior bolt release
- Conventional rather than laminated

We Will Decide Later

- Butt plate or pad
- Grip contour
- Type of rear sight (ramp, folding leaf)
- Size of safety lever
- Type of action Model 600 or Model 700
- Barrel bracket contour
- Type of receiver tang Model 600 or Model 700
- Magazine style fixed or hinged floor plate

Submit to Panel

- Sling strap and swivels (barrel band or fore-end fit)
- Grip; plain or with cap
- Fore-end contour; regular or schnabel

Submit to Panel (cont.)

- Checkering what is it worth?
- Spacers with or without
- Wood color and/or gloss level
- Type of wood perceived value of walnut versus other species
- Color preference of front bead
- Safety
 - Importance of locking bolt handle when on safe a)
 - b) If locked handle is selected, which type of safety is preferred
 - Current
 - Three position safety; release at rear position
 - Release on bolt shroud
 - Location
- Caliber preference which are favorites, desired, etc.
- Bolt handle contour and styling
- Bolt body jewelled, polished, or bluedTrigger bow styling
- Barrel length

By copy of this letter, I am also advising Bud Weeks and Jim Chambers of our meeting and ask them to begin planning consumer tests.

E X H I B I T N O. 13 GUN SERIAL NUMBER A6495821

STOCK

BIRCH WOOD
VINYL FINISH
MODEL 870 RECOIL PAD
CLASSIC STYLING
INLET FOR TRIGGER GUARD
FRONT AND REAR SWIVEL STUDS

BARRELED ACTION

18 INCH BARREL LENGTH
MODEL 700 BARREL BRACKET
ROUNDED RECEIVER TANG SIMILAR TO MODEL 700
FORWARD SWEPT BOLT HANDLE WITH .625 BALL
MODEL 700 TYPE BOLT RELEASE
NEW BOLT LOCK DESIGN ON BOLT PLUG
ALUMINUM TRIGGER GUARD - INVESTMENT CAST
NEW FRONT SIGHT BASE
MODEL 700 BDL FRONT SIGHT HOOD
NEW TWO PIECE REAR SIGHT



EXHIBIT NO. 12 GUN SERIAL NUMBER A6495819

STOCK

BIRCH WOOD
VINYL FINISH
MODEL 700 CLASSIC BUTT PAD
INLET FOR TRIGGER GUARD
CUT CHECKERING
CLASSIC STYLING
FRONT AND REAR SWIVEL STUDS

BARRELED ACTION

18 INCH BARREL LENGTH

MODEL 700 BARREL BRACKET

ROUNDED RECEIVER TANG SIMILAR TO MODEL 700

FLAT SPOON HANDLE TYPE BOLT HANDLE

MODEL 700 TYPE BOLT RELEASE

ALUMINUM TRIGGER GUARD - INVESTMENT CAST

NEW FRONT SIGHT BASE

MODEL 700 BDL FRONT SIGHT HOOD

REAR FOLD DOWN SIGHT BY MARBLE



EXHIBIT NO. 11 GUN SERIAL NUMBER A6495820

STOCK

BIRCH WOOD
VINYL FINISH
SCHNABEL DESIGN FORE END
INLET FOR TRIGGER GUARD
REAR SWIVEL STUD

BARRELED ACTION

18 INCH BARREL LENGTH

MODEL 700 BARREL BRACKET

ROUNDED RECEIVER TANG SIMILAR TO MODEL 700

FORWARD SWEPT BOLT HANDLE WITH .795 BALL

MODEL 700 TYPE SAFETY BUTTON

NEW BOLT UNLOCK BUTTON NEXT TO SAFETY

MODEL 700 TYPE BOLT RELEASE

ALUMINUM TRIGGER GUARD - INVESTMENT CAST

NEW FRONT SIGHT BASE

MODEL 700 FRONT SIGHT

MODEL 700 BDL FRONT SIGHT HOOD

UNCLE MIKE'S FRONT SWIVEL STUD CLAMP

NEW REAR ADJUSTABLE SIGHT



EXHIBIT NO. 10 GUN SERIAL NUMBER A6495823

STOCK

BIRCH WOOD
VINYL FINISH
CUT CHECKERING
MODEL 700 CLASSIC BUTT PAD
SCHNABEL DESIGN FOR FORE END
INLET FOR TRIGGER GUARD
REAR SWIVEL STUD

BARRELED ACTION

18 INCH BARREL LENGTH
MODEL 700 BARREL BRACKET
ROUNDED RECEIVER TANG SIMILAR TO MODEL 700
FORWARD SWEPT BOLT HANDLE WITH .725 BALL
MODEL 700 TYPE SAFETY BUTTON
MODEL 700 TYPE BOLT RELEASE
ALUMINUM TRIGGER GUARD - INVESTMENT CAST
NEW FRONT SIGHT BASE
MODEL 700 FRONT SIGHT
MODEL 700 BDL FRONT SIGHT HOOD
UNCLE MIKE'S FRONT SWIVEL STUD CLAMP
BARREL MACHINED FOR REAR DOVETAIL SIGHT



EXHIBIT NO. 14 GUN SERIAL NUMBER A6273737

STOCK

Walnut wood Vinyl finish Model 700 Classic Butt PAD Classic styling Inlet for trigger guard

BARRELED ACTION

18½ INCH BARREL LENGTH
MODEL 700 BOLT HANDLE
MODEL 700 COMPLETE TRIGGER HOUSING ASSEMBLY
NEW ALUMINUM TRIGGER GUARD
NEW FRONT SIGHT BASE
MODEL 700 FRONT SIGHT
MODEL 700 BDL FRONT SIGHT HOOD
MODEL 600 REAR SIGHT BASE (STEEL)
OLD MODEL 600 BOLT PLUG

1



EXHIBIT NO. 15 Gun Serial Number A6273739

STOCK

BIRCH WOOD
GLOSS FINISH - RKW
MODEL 700 MAGNUM RECOIL PAD
CLASSIC STYLING
INLET FOR TRIGGER GUARD
FRONT AND REAR SWIVEL STUDS

BARRELED ACTION

18½ INCH BARREL LENGTH
MODEL 700 SAFETY BUTTON
ALUMINUM TRIGGER GUARD - INVESTMENT CAST
MODEL 700 FRONT SIGHT BASE
MODEL 700 FRONT SIGHT
MODEL 700 BDL FRONT SIGHT HOOD
MODEL 700 REAR SIGHT ASSEMBLY





John Brooks

EXHIBIT 16

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「Maries Constitution and the Constitution of the Constitution of

tion Carbine Style Rifle Research

Schodule of Group Sessions

Tornes, - January 30 - 6:00 P.M. and 6:30 P.M. (Lover action usure).

Boly and lever action users

Quality Controlled Services 7007 Sulf Freeway, Sulfe 212 Houston, Texas 77087

(Mr. Adotation horganon 713-641-3321)

గ్రామంలో Hadressay - January 31 - 8:00 P.M. (Levan sulion eyers)

> Marketing Information Service 9 Comparate Square Allenia, GA - 50729

(Bill williers 404-325-5221)

The taken - February 1 - 5:00 P.M. and P:00 P.M. (Love: action users)

D trait Porketing Sections Southfield Bd. Southfield, Whitiger (4807)

(*) 1 (*) (*) is mets = 313-562-7390)

EXHIBIT 17

NEW BOLT ACTION CARBINE STYLE CENTER FIRE RIFLE RESEARCH

Group Discussion Guide

Section 1 - General Positioning of Carbines

What we are going to be talking about today is <u>center fire rifles</u>; and we will be focusing most of the discussion on the lever action and bolt action types....

- First of all, let me ask each of you what kind of center fire gun do you mainly use and why? (WARM-UP)
- 2. What types do you use for different types of game?
- 3. How do the different type of actions (lever vs. bolt) affect your hunting attitudes and practices -- for example, in terms of type of game, range, accuracy, other considerations?
- 4. How do the different sizes and weights of a gun affect your hunting habits in terms of type of game, range, accuracy, other considerations?
- 5. Any relationship between type of action and size/weight of gun? Implications of this in terms of type of game, range, accuracy, other considerations? Ammunition?
- (IF, AND ONLY IF, "CARBINE" IS MENTIONED) 6. What <u>is</u> a carbine? What makes a carbine rifle a carbine?
 - How does a carbine compare to a regular rifle in terms of:
 - ...range
 - ...accuracy
 - ...ammunition
 - ...comfort
 - ...convenience
 - ...durability
 - ...overall

- Who are the main users of carbine style rifles?
- What types situations are they for?
- What advantages are there to using a carbine style rifle?
- What disadvantages are there to using one?
- What differences do you find as a result of the shorter barrel length? (PROBE FOR COMPARISONS BETWEEN A "CHOPPED OFF" BARREL AS OPPOSED TO ONE THAT IS PROPORTIONED OR SCALED DOWN TO SIZE.)

Section 2 - Concept Reactions

(PASS OUT CONCEPT STATEMENT AND READ IT ALOUD WHILE RESPONDENTS FOLLOW ALONG. GIVE THEM AS MUCH TIME AS THEY NEED TO "ABSORB" THE IDEA, AND LET THEM KEEP THE SHEETS TO REFER TO DURING THE FOLLOWING DISCUSSION.)

- Well, what are your first thoughts about the information on this sheet? (SPONTANEOUS AT FIRST; THEN PROBE) What else? Tell me more. Anything else?
- 2. How well does what is on the sheet fit in with your own attitudes and thoughts about guns? With your hunting habits?
- What do you especially like about what's said...or find of special interest? Explain.
- 4. What do you dislike or doubt about what's said? Or disagree with? Explain.
- 5. For what situations and purposes would a product like this be used? What makes you say that?
- 6. a. Who do you think would be most likely to use such a product? What type of hunters?
 - b. Does this describe you?
- 7. What would you expect a gun like the one described on the sheet to cost? How did you arrive at that price?
 - Would you be interested in buying it at that price?

(PASS OUT QUESTIONNAIRE BOCKLETS AND ASK RESPONDENTS TO FILL IN THE INFORMATION REQUESTED ABOVE THE BROKEN LINE, AND THEN TO RATE THEIR OVERALL REACTION TO THE CONCEPT ON THE SCALE BELOW THE BROKEN LINE.... ASK THEM NOT TO TURN THE PAGE.)

Section 3 - Detailed Model Reactions

(HAVE THE RESPONDENTS COMPARE THE MODELS ON EACH OF THE FOLLOWING ASPECTS AND DISCUSS THEIR COMPARISONS. REMIND THEM TO REFER TO THE MODEL LETTERS AND NUMBERS THROUGHOUT.... PROBE FOR INCREMENTAL PRICE EXPECTATIONS WHERE APPROPRIATE.)

- (SLING STRAP AND SWIVELS) Which do you prefer, the barrel bands or studs? How important are either or both of these to you? What are they worth? (COMPARE MODELS V, R AND Q)
- (GRIP) Which of the different type grips do you prefer and why? (V IS THE MOST SWEPT BACK OF ALL)... Do you prefer the plain or with the grip cap? (W70 GRIP CAP)
- 3. (FORE-END CONTOUR) Do you prefer the regular fore-end contour or the schnable? (Q AND S HAS SCHNABEL). Are there any advantages or disadvantages to the schnabel? Any limitations? (POINT OUT THAT SCHNABEL NECESSARILY IMPLIES BARREL BAND --(cf. #1, ABOVE.)
- 4. (BUTT PAD) There are several types of butt pads the standard plastic plate (S), the recoil pad (M) and the rubber butt pad (R). Which do you prefer and why? Do you consider any one or two of the three types to be preferable? (PROBE FOR REASONS LOOKS, FUNCTION, PRICE)
- (CHECKERING) How important is checkering to you? How much is pressed or cut checkering worth to you? (USE MODELS T AND Q FOR CUT CHECKERING AND THE 700 FOR PRESSED CHECKERING)
- 6. (WOOD COLOR) Which wood <u>color</u> do you prefer? (MODELS S AND V ARE WALNUT; Q, T, M, AND R ARE BIRCH)
 - How much is the specific type of wood worth to you? (PROBE FOR INCREMENTAL VALUE OF WALNUT VERSUS OTHER TYPES)
- 7. Which <u>finish or gloss</u> level do you prefer? How important is this to you? (HIGH GLOSS IS MODEL R -- ALL THE REST ARE SATIN FINISH (VINYL))
- 8. (FRONT BEAD) Do you have any color preference for the front bead? (LOCATED IN THE FRONT SIGHT; ALL THE MODELS ARE GOLD)

- 9. (BOLT HANDLE CONTOUR AND STYLING) Which type of bolt handle contour do you prefer -- both functionally and for looks or "fee!"? Why? (MODELS M, Q, R, S ARE DOG LEGGED, MODELS T AND V STRAIGHT)
- 10. (BOLT BODY) Do you prefer a blued or non-blued bolt body? Why? How important is it to you? What is it worth to you to have it or not have it?)
 - (JEWELING) What is a jeweled body worth to you? Do you prefer one?
- Ii. a. (SAFETY) Overal!, what are your feelings about safety with respect to center fire rifles? What are the main concerns here? What are the trade-offs between safety and operating convenience?

Now, regarding particular aspects of safety design....

- b. How important is it to you to be able to lock the bolt handle when the safety is on? Why?
- c. What are your opinions of, and preferences among, these different types of safetys...

- MODEL 70: three-position; bolt can be opened in middle position

- MODEL R: three-position; bolt can be opened in <u>rear</u> position

- MODELS M/S: three-position (in effect); press button to release bolt in safety lock position; release in on bolt shroud or on side near safety

(BE ALERT FOR PERCEPTIONS OF GOOD/BAD "FEEL" OF COMFORT/DISCOMFORT AS THE RESPONDENTS HANDLE THE MODELS AND WORK THE ACTION AND SAFETYS. ALSO, ARE THERE LEARNING PROBLEMS, NUISANCE, FRUSTRATION, ETC. WITH WORKING THESE SAFETYS.)

- d. How important, really, is it to have the bolt locked down when the safety is on? Why?
- e. Which of the various safety <u>locations</u> do you prefer -- tang, cross-bolt, standard Remington location (700, 788) or Winchester 70 location?

- f. Do you find you have any trouble with your hand rotating while operating the safety (possible accidental firing)?
- 12. (AMMUNITION/CALIBER)

(IF NOT FULLY COVERED IN EARLY PART OF DISCUSSION....)

- a. Bolt action guns (as opposed to lever action) will accept newer, high velocity calibers. Does this affect your reactions to this new gun concept and these models?
- b. What calibers should this gun accommodate? Why?
- 13. (ACCURACY/SCOPE) Do you think that these shorter bolt action rifles are any less accurate than regular-length models?

(IF SO) b. Do you think a scope would offset the difference? (IN FACT, IT WOULD)

Now, let's turn to the Questionnaire Booklets.

GRG #108

CONCEPT STATEMENT

As you know, for many years hunters have had a choice among several different types of operating actions where rifles are concerned — two of the most popular being lever action and bolt action. However, there are few, if any, guns on the market that can offer a combination of the advantages of both these types of guns — that is, a smaller, lighter weight gun that offers the better performance characteristics of a bolt action gun.

Now, a leading gun manufacturer has developed a new concept in the center fire rifle category — a bolt action gun scaled down to a smaller size, but one that can still accommodate the newer, high velocity cartridges. This new gun offers the "knockabout" convenience and portability that comes with smaller size and lighter weight — qualities that have long been available in lever action — but it offers them in a bolt action gun.

You get the "best of both worlds" in this new, high quality center fire rifle — the convenience of smaller size and lighter weight (not just a "sawed-off" barrel, but carefully designed and proportioned overall), plus the opportunity to use the newer, high velocity cartridges as well as the other performance advantages of bolt action.

EXHIBIT 18

GRG #108

QUESTIONNAIRE BOOKLET

Group Number
Location
Date

Concept Reaction

Which of the ratings below most closely describes your overall reaction to the new product idea described on the sheet?

- () Like it a lot
- () Like it somewhat
- () Indifferent
- () Dislike it somewhat
- () Dislike it a lot

(DO NOT TURN PAGE)

2. Why do you say that?

QUESTIONNAIRE BOOKLET

- A. I. Now that you've seen it -- and regardless or your preferences for the different feature variations we've discussed -- what do you think of the general idea of this new smaller size, lighter weight bolt action rifle? (PLEASE CHECK ONE:)

 () Like it a lot

 () Like it somewhat

 () Indifferent

 () Dislike it somewhat

 () Dislike it a lot
- Now, for each specific feature listed below, please place the appropriate model letter (Q, S, T, M, R, or V) in the proper column, according to which model you like best with respect to that feature; second best; and <u>least</u>.

	8es†	Second Best	Leas†
 Sling strap and swivel mounts (barrel band/studs) 			_
2. Grip design			
3. Fore-end contour design			
4. Butt pad			
5. Checkering (T and O only)			
6. Wood color			
7. Wood gloss level			
8. Boit handle contour and styling			
9. Safety - which type			
10. Safety - which <u>location</u>			
II. Overall - which gun do you prefer			

(DO NOT TURN PAGE)

c.	Next, please indicate your preferences on each of the items below:	2-
	1. () prefer grip cap	
	() Prefer no grip cap	
	J. P. Cop	
	2. () Prefer checkering	
	() Prefer no checkering	
	3. () Prefer regular fore-end contour	
	() Prefer schnabel fore-end contour	
	4. () Prefer blued boit body	
	() Prefer non-blued bolt body	
	5. () Prefer jeweled boit body	
	() Prefer non-jeweled boit body	
	Control of the state of the sta	
D.	For	
٥.	For comparison purposes in answering this next question, you might want to know that the suggested retail (list) prices of three of the currently marketed guns you've seen are as follows:	
	marketed guns you've seen are as follows:	
	- Remington Model 788 - about \$175.00	
	- Remington Model 700 ADL - about \$245.00	
	- Winchester Model 94 - about \$140.00	
•		
1.	. Now, taking into account the way you have "designed" this gun by your choices in the B and C question series you've just completed, write in here what you would expect the suggested retail (list) price of that gun to be.	
	\$	
2		
2.	Sriefly explain your answer.	
3.	Now, please indicate below how interested you would be in buying that gun if that were the suggested retail (list) price.	
	() Definitely would buy	
	() Probably would buy	
	() Might or might not buy	
	() Probably would not buy	
	() Definitely would not buy	
4.	Briefly explain your answer.	
	•	
	(GO ON TO NEXT PAGE)	

(GO ON TO NEXT PAGE)

 Please write in next to the type(s) of hunting you have done in the past year about how often you have done it, and the make and model/action of the gun mainly used.

Activity	Frequency	Make and Model/Action
Water fowl (i.a., ducks/geese)		·
Dove		
Small game (i.e., pheasant/rabbit/ quail/grouse/squirrel)		
Big game (i.e., deer)		
Target shooting (i.e., trap/skeet/ hand or portable trap)		
Target shooting - rifle		
Other: (specify)		

_	_						
8.	Overall.	how	MARY	guns	do	VOU	own?

Thanks very much for your cooperation.

EXHIBIT 19

the Gediman Research Group, Inc.

26 Sixth Street Stamford, Connecticut 06905 203-348-0009

MARKET EVALUATION, POSITIONING,
AND FEATURIZATION

OF A

NEW BOLT ACTION CARBINE STYLE
CENTER FIRE RIFLE

RECEIVED

MAR 2 7 1979

ILION RESEARCH DIVISION

For: Remington Arms Company, Inc.
March, 1979

TABLE OF CONTENTS

MANAGEM	ENT	SUM	MAR:	Ý.	•	•	•	•	•	•	•	•	•	•	٠		•
INTRODU	CTIC	n.	•	•	•		•	•		•	•		•	•	•	•	•
GENERAL	ATT	ITU	DES	Αì	ΝD	PI	RA	CT	IC	ES	٠	•	•		•	•	
CONCEPT	REA	CTI	ons				•	•		•	•	•	•		•	•	1
PROTOTYI	PE R	ŒAC	TION	18			•	•	•	•	•	•	•		•	•	1
APPENDI	Υ.																

MANAGEMENT SUMMARY

This section summarizes the key results of the consumer research on Remington Arms' proposed new bolt action carbine style center fire rifle....

The findings quite clearly indicate that the new idea is a distinctive and promising new product prospect, with good appeal to center fire rifle users across the board and especially strong appeal to the bolt action segment. The following two tables show the level of consumer interest, first at the concept and then at the product stage.

Concept Reaction*	Total Sample
	. (50)
Like it a lot	30 % 80 % 50
Like it somewhat	50
Indifferent	20
Dislike it somewhat	, -
Dislike it a lot	•

^{*}The concept statement shown to respondents is reprinted on Page 14.

Product Reaction*	Total Sample
	(50)
Like it a lot	42% 54 } 96%
Like it somewhat	54
Indifferent	•
Dislike it somewhat	4
Dislike it a lot	•

*All prototypes, collectively.

Price expectations for the new gun are at about the \$180 level (median). Purchase interest (definitely or probably would buy) approaches two-thirds of the sample. Both anticipated price and definite purchase interest are stronger among the bolt action segment.

If the new entry can be kept at or near the anticipated price of \$180 -- or in any event, under \$200 -- there wouldn't appear to be too much risk of cannibalizing the comparatively higher quality, higher priced Model 700. Rather it is the Model 788 that might present consumers with a closer choice. But the research results strongly suggest that, on balance, whatever sales might come at the expense of the 788, these would be more than offset by "additional gun" purchases (i.e., as a "walking gun," a "starter" gun for a child, a gun for a woman, etc.) versus "instead of" type purchases...as well as by an appreciable amount of entirely new business coming from the lever action segment.

It is our opinion, based on this research, that the new product need not, and probably should not, be presented specifically as a "carbine," because of the connotations of that among hunters: While it is true a carbine is perceived as being a smaller and lighter weight rifle, it is also thought of as having shorter range capabilities and less accuracy. We feel this gun should be presented as being "the best of both worlds" -- that is, a smaller, lighter weight gun (as in many lever action offerings) that offers the better performance characteristics of a bolt action gun, (via higher velocity cartridges).

What the new offering should be called is properly a matter for advertising and other creative development. However, in keeping with the general idea of communicating "the best of both worlds," one possible direction (given here for illustrative purposes only) might be, say, "bolt action brush gun."

Because of the mixed reactions greeting various different combinations of functional and aesthetic features of the prototypes, we feel that a "composite" gun, combining different features of several of the guns, would be best.

This composite gun would have a rounded fore-end contour design similar to Model V, rather than a schnabel fore-end, and would accommodate studs, for which there is an over-whelming preference (vs. barrel bands). It would have the grip design of Model T; and because of an only slight consumer preference for a grip cap, probably should be offered without

-4-

that feature (and thus without whatever price increment the grip cap would entail).

The recoil pad of Model M is favored, and could be adopted with reasonable confidence, though Models V, S, and R would likely also be acceptable.

Checkering is overwhelmingly preferred, with some slight favor for Model Q which has the checkering all around the fore-end. It appears that checkering (unlike such features as grip cap, bolt jeweling, or front bead color) is important enough to consumers to support a price increment. Pressed checkering is preferable to no checkering, but would not support as high a price increment as cut checkering.

Walnut is the preferred wood with Model V being the highly favored color and (non-)gloss level. A straight, not dog-legged, bolt handle contour with a knurled knob (Model V) is significantly more popular, as is a non-blued, jeweled bolt body.

After much discussion, the safety type of Model S (2-position safety with a separate push button bolt release mechanism), located on the side, seems to win on the basis that it has the advantages of all or any of the other safety types, without the disadvantages.

#

INTRODUCTION

This research was undertaken to provide an initial (qualitative) assessment of the market appeal for a new bolt action carbine style center fire rifle, as well as guidelines for its optimal positioning; that is, its "reason for being," in relation to consumers' hunting lifestyles and gun orientations, on the one hand, and to pertinent existing products, on the other.

The positioning issue both affects and is itself affected by the aesthetic and functional featurization elements that have been variously incorporated into six prototypes. And it is a major objective of this research to address and interrelate both sides of the "equation" -- that is:

- evaluate the market appeal and establish the best possible positioning for the new gun;
- determine what combination of test features best supports and reinforces that optimal positioning.

Research Method

The findings and interpretations in this report are derived from five consumer group discussions, in the course of which participants discussed the new gun idea from many different perspectives. Discussion within the groups first explored participants' general orientations to hunting, and in particular with lever and bolt action center fire rifles. Respondents were then presented with, and discussed, the new gun concept. Subsequent discussion focused in on the six prototypes, with their different combinations of functional and aesthetic elements, in order to assess consumers' perceived benefits, specific likes, dislikes, and expectations regarding use, users, price, and purchase intent. Following discussion and "hands on" examination of the prototypes (and four as-marketed guns included for purposes of comparison -- Remington Models 700 and 788, and Winchester Models 94 and 70), respondents rated and ranked the test designs on all key issues according to their preferences.

Sample and Fieldwork

The total sample consisted of 50 participants in five groups, and was about equally divided between men whose center fire rifle hunting is only or mainly with bolt action (48%) versus only or mainly with lever action (52%),* and collectively representing a wide range of socio-economic characteristics.

The sample representation for the three cities in the study is:

^{*}Two "pure" groups of lever action users, and three mixed groups were conducted.

-7-

- 24 consumers in two groups in Houston, Texas
- 11 consumers in one group in Atlanta, Georgia
- 15 consumers in two groups in Detroit, Michigan

* * *

The usual cautions for small-scale, group session research should be noted here, especially when comparing sub-segments. In this connection, note also that, both here and in the tabulations, raw numbers have been converted to percentages and rating scores only for purposes of analytic and editorial convenience; that is, in order to indicate more easily the direction, not the projectability, of the results. Nevertheless, as it turns out in this case, the results on most issues are fairly clear-cut.

* * *

A more detailed demographic breakdown of the sample, as well as all the statistical tabular data drawn from respondents' ratings of the test models, will be found in the Appendix section of this report.

GENERAL ATTITUDES AND PRACTICES

Beyond the few who have built-in, unchangeable, perceived preferences for one type gun or the other, respondents in all three regions, regardless of being bolt action or lever action users, are pretty much in agreement as far as their general attitudes and orientations to lever and bolt action center fire rifles are concerned.

Lever action center fire rifles are perceived by consumers to be lighter weight, therefore easier to handle, with greater portability and maneuverability:

"I have a Winchester 94 (lever) and it is lighter than my Murray Hill bolt action by at least 2 lbs. I find it easier to handle and use."
"In briars I'd use a lever for

portability."

They are considered walking and stalking guns, best suited for brush hunting and woods because they won't get tangled in the brush as easily. In addition, they are seen as having shorter range capabilities, the result of operating under lower pressure, producing a slower bullet; and as having less latitude for cartridge capacities:

"The biggest advantages of a lever are its lightness and maneuverability and it won't get tangled in the brush and briars."

The majority of the respondents feel that they can operate a lever action rifle faster, thereby being able to get the second shot off faster:

"I prefer a lever because it fires quicker and holds the aim better."

"I use a lever because it fires more rapidly without losing its target."

"A bolt action takes more time to get the second shot off."

"Bolts are notoriously slow."

There is a definite John Wayne/"Rifleman" type mystique about a lever action rifle which many attribute its popularity to:

"When you were a kid you'd always see John Wayne using a lever action rifle."

"Cowboy movies when you were young definitely stick with you."

Consumers find bolt action center fire rifles to be more accurate and to have longer range capabilities, due to the higher-velocity, higher energy cartridges they can handle, the greater range and accuracy of its cartridges. Because it is a heavier and more cumbersome gun than the lever action, it is predominantly considered best suited for wide, open country and greater (shooting, not walking) distances in contrast to the brush:

"I enjoyed my 30-30 lever action rifle but the range capacities made me change."

"You'll never find a really high caliber like a 7mm or a 388 Winchester in a lever action gun - only a bolt."

"If they could make a lever action as accurate as a bolt it would sell."

"Bolt action is stronger, more rigid because the breech and barrel is manufactured in one piece."

In a minority of the cases, opinion differs, usually on specific issues concerning one type action as compared to the other, most likely based on a respondent's particular built-in bias in favor of the type he uses. The following quotes illustrate some of these:

"My 243 lever will shoot just as far and just as accurate as a bolt."

"My lever is accurate. Accuracy really depends on who's operating it - whether it be a lever or bolt."

"I think a lever is just as reliable as a bolt and more so than an automatic."

"I don't think a bolt can shoot longer ranges with better accuracy."

"With a given caliber and barrel length, the range of a bolt and lever would be the same."

Respondents also mention that their gun choice sometimes depends on a particular personal preference which may be based on a physical impairment such as sight...

> "I'm blind on the right side and to me a bolt is very clumsy on the left side a lever is better for me."

...or a special concern such as safety and misfiring...

"I have a Savage 99 I bought in 1950-51 and I've shot 5 boxes of shells a year and it's never misfired. You can't do better than that."

...or a particular feel or style of hunting...

"I shoot a lever action for a totally different reason. I like the hammer and I can tell right away it is off. It's a personal preference with me."

"A model 88 has a 2½ inch spread which takes the gun off the game every time you crank it whereas a good hunter who shoots with a bolt won't take it off the game."

"A lever action lends itself to hunting on a horse whereas with a bolt it's harder to do."

"It depends which type you are more familiar with."

"To me its all subjective personal preference. I just
like using a bolt action better."

. Carbine/"Carbine-ness"

The term carbine is found to denote principally one idea shortness in barrel length. Carbines are generally, but not always, thought of as being about 2 inches shorter than a regulation sized rifle, thereby making them lighter in weight. The consensus of opinion perceives carbines as mainly or strictly lever action rifles and, with their shortness of length, contributing to the lever action's advantages of lightweight, portable, and easier to handle and maneuver, making it an excellent gun for brush and woods hunting. However, as with most lever action rifles, it also has the disadvantages of shorter range capabilities and less accuracy. A majority of the sample feel that even more range and accuracy are sacrificed when compared to a regular lever action because of these lost 2 inches. Range expectations of a carbine produce a mixed reaction from 50 yards to over 100 yards. The following summarize the general attitudes toward carbines:

"Carbines are easier to use in brush, which is a very real issue here (Atlanta)."

"It's a great walking gun especially through briar brush."

"A carbine is a short gun designed to be carried on horseback."

"A carbine is a great short barrel brush gun. It won't get tangled as easily." "The shorter barrel length affects its range and accuracy. A carbine is accurate up to a certain range."

"Accuracy is a function of range."

"Because of its shorter barrel length there is a loss of velocity because it's not holding in pressure. This lower velocity means less range and less accuracy."

Several men mention that, because of its smaller size and lightweight, a carbine makes a perfect "starter" gun for their sons and/or wife:

"I have 3 sons and I have to buy each of their first shotgun and rifle. I bought all carbines to start with. Psychologically it is easier for them."

"I bought my wife a carbine because it is lighter and easier for her to handle."

CONCEPT REACTIONS

The following concept was presented to the sample:

As you know, for many years hunters have had a choice among several different types of operating actions where rifles are concerned -- two of the most popular being lever action and bolt action. However, there are few, if any, guns on the market that can offer a combination of the advantages of both these types of guns -- that is, a smaller, lighter weight gun that offers the better performance characteristics of a bolt action gun.

Now, a leading gun manufacturer has developed a new concept in the center fire rifle category -- a bolt action gun scaled down to a smaller size, but one that can still accommodate the newer, high velocity cartridges. This new gun offers the "knockabout" convenience and portability that comes with smaller size and lighter weight -- qualities that have long been available in lever action -- but it offers them in a bolt action gun.

You get the "best of both worlds" in this new, high quality center fire rifle -- the convenience of smaller size and lighter weight (not just a "sawed-off" barrel, but carefully designed and proportioned overall), plus the opportunity to use the newer, high velocity cartridges as well as the other performance advantages of bolt action.

Initial reactions to the concept, prior to seeing any prototypes, are very favorable: 80% of the sample state they like it a lot or somewhat -- based directly on the intended conceptual merits of bolt action performance in a smaller, lighter gun. The degree and quality of concept acceptance seems to be somewhat higher in Detroit and Atlanta, and among bolt action users. The remaining 20% of the sample are indifferent to the concept as opposed to overtly negative.

Respondents readily accept the idea because this new product offers them "the best of both worlds." The majority of men (including lever action users) would like a light weight gun but do not want to sacrifice the range and accuracy of a bolt. This finally offers them an alternative:

"I'd like to see this - lightweight and a bolt with high velocity. I don't care how light a gun is, it gets heavy carrying it all day."

"I love the idea. You never know in the beginning of the day what you'll need by the end. A lever is a disadvantage in this aspect."

"If my accuracy wouldn't decrease with the light weight it would be great. I only switched due to the range before."

"If you are in the market for a more maneuverable gun, this is it."

"Weight really matters to me."

7

"This gun would be ideal for the brush here in Michigan."

"To me a bolt action is safer than a lever for my son. This would be perfect."

Only a few respondents in the sample make a contrast between this new gun concept and Remington's previous Model 600, which they speak favorably of:

"This is a remarketing of a Remington 600. I've shot one and I'd like to have one."

"This is similar to the Remington 600 which was great. I'm looking for something like that."

"There's one on the market already - a Remington 600. Well actually it's discontinued now. It was recalled because of an accident with a 15 year old boy who violated nine basic gun handling rules."

Another advantage that hunters perceive in this gun is its ability to accommodate a scope, which a Model 94 cannot do without a side mount. This seems to be a very important issue with a good percentage of the sample:

"In this area (Atlanta) you need a scope to see through the brush and thicket, trying to get a piece of the deer. This is a definite advantage of this new gun."

"Just about anyone going in the woods today will use a scope."

"When you get old enough where you can't see the front sight or the range you are shooting, you will learn to love a scope. It becomes a necessity."

The small percentage who do not accept the concept initially raise doubts about the ability to make such a gun that would have the advantages of both lever and bolt action. Several men seem worried or doubt the ability of a shorter barrel length to be able to handle high velocity cartridges efficiently and accurately:

"How can you get as high a velocity out of a shorter barrel as with a long barrel?"

"I don't believe a high velocity will come out of this gun and be accurate."

"High velocity cartridges depend on barrel length for efficiency."

Other negative reactions are a result of strong personal preferences - either for a particular type gun that they use and don't want to change or for a particular type of hunting:

"I'm sold on my lever. I'm not a very good hunter but my gun has killed anything (deer) it has hit. I'd never change to a bolt."

"I don't like too lightweight a gun. I like something there to swing."

"Not for me. I'm strictly a long bolt action user and I hunt accordingly. I'm used to the inconvenience of weight."

"Good idea for someone who hunts long ranges. Not me - I hunt under 50 yards." Some men seem concerned about the added recoil and muzzle blast:

"I think with lighter guns you feel the recoil more. I prefer heavier guns."

"You wouldn't be able to hear for 3 days."

"I don't like the muzzle blast of short barrel guns."

When respondents are asked which type action users would find this gun more appealing, about two-thirds of the sample agree that bolt action users would. The remainder either feel it would be more appealing to lever action users or to both equally.

In the discussions, price expectations vary, ranging from a low of \$160 to a high of \$300. This concept is perceived to be more expensive in Detroit, falling in the \$200 - \$225 range, whereas Atlanta and Houston are somewhat lower, around \$185.

PROTOTYPE REACTIONS

Respondents' first exposure to the six prototypes produces a mixture of spontaneous reactions. Three of the five groups find the models shorter than they expected. A large percentage recognize them right away to be Remington because of the bolt design and the checkering on two of the models. Many find them to be pretty much what they had expected. Others are surprised about the small stock and feel it would be more advantageous for smaller people (small men, women, children), while many state it would be perfect for themselves. Several respondents consider it not in line with the quality of the Remington 700, but rather closer to that of a lever or a lever carbine.

Yet, with all those initial pros and cons, consumers' rated reactions to the product -- that is, to the six prototypes collectively, before discussion of particular feature differences -- is even more favorable than at the concept level. Acceptance, in fact, is virtually unanimous with 96% liking it a lot or somewhat, and with top box approval ("like it a lot") appreciably higher now than at the concept level for the total sample, and nearly double for bolt action users (up from 33% to 63%).

Group discussions then centered on the six prototypes, with their different combinations of functional and aesthetic elements. Statistics for these issues -- compiled on the basis of respondents' ratings and rankings at the end of the group session -- can be found in the Appendix.

Studs Versus Barrel Bands and Fore-end Contour Design

These two issues are interrelated because of the fact that
a schnabel design, due to its shape, can only accept barrel
bands versus a regular fore-end contour design which can
accommodate studs. This fact clearly affects the preference
of the fore-end design. More than half of the sample in
discussion find the schnabel design (Models Q and S) appealing both aesthetically and functionally. However, because
of the overwhelming strong preference for studs (Models T
and R) versus barrel bands (Models Q and S) and hunters'
refusal to give up studs for the schnabel, they change their
preference to the regular fore-end contour design (72%) with
studs:

"I'm a little man and I have little hands. I like the feel of the schnabel but I sure wouldn't want barrel bands."

"If I couldn't have studs, I'd rather not have anything."

Model V fares extremely well, and because there is little or no difference in contour between T and V, we have to assume that the people who favor V don't want barrel bands or studs.

Grip Design and Grip Cap

There is a clear preference for Model T grip design. The most extreme swept back design (Model V) does almost as well on "best" and "second best" mentions; however, a high "liked least" score nets it out as a not very close second. Many respondents perceive Model V as being harder to grip:

"Model V is more swept back and this makes it harder to squeeze with the open handed method of shooting."

"V is too short for my big hands, especially for gripping and carrying."

There is a marginal preference overall for a grip cap (60% vs. 40%). Atlanta has a strong preference for it (91%) whereas Detroit prefers no grip cap (80%). Most respondents feel this feature is strictly aesthetic, with no real bearing on performance:

"I like a grip cap - it adds a touch of class."

"It's nice but not really worth paying for."

"I don't really like it. It's not important to me. It has no bearing on the gun or its performance."

Butt Pad

The recoil pad of Model M scores best, but with considerable bi-polarity (quite a few "liked least," mainly in Atlanta, but more "liked best," mainly in Houston):

"I like a recoil pad - you get more cushion and less recoil, kick."

"I like a recoil pad. I don't take fast shots at running deer."

"I wouldn't want a recoil pad or rubber pad it if would catch on my jacket."

The rubber butt pad on Model R, fairly popular in Houston, and the classic pad of Model V are tied for second, with the standard plastic plate of S, most popular in Atlanta, not far behind.

Checkering

Checkering is overwhelmingly preferred (84%) over no checkering. Not only do respondents consider it aesthetically more pleasing but they also consider it functionally more accommodating: it allows a better grip with no sticking, especially in wet weather:

"With checkering I can move my hand without sticking it gives a better grip."

"Checkering is good in wet or hot weather - you can get a better grip. It looks nicer too."

"I've never seen a high quality center fire rifle without checkering."

Although cut checkering (or "hand checkering," as some consumers call it) is preferred over pressed checkering, most would rather have the latter than no checkering at all:

"Pressed checkering doesn't have as sharp edges as cut, but it's better than nothing."

The majority of respondents acknowledge that they are willing to pay extra for checkering, with responses falling between the \$15.00 - \$20.00 range, or 10% of the price of the gun. They do feel, however, that machine or pressed checkering should be cheaper than cut checkering.

Of the two prototypes with checkering, Models T and Q, there is a preference, though not an overwhelming one, for Model Q -- the one whose checkering runs underneath the fore-end:

"This is the first one I've seen with checkering all the way around - I like it."

Wood Color

Model V, which is walnut, is clearly the conclusive favorite.

The majority of the sample perceive walnut as the only good wood for a gun, especially any high quality gun:

"If it's not black walnut, to a real enthusiast, it's a low quality gun."

Others feel it's not so much the goodness of walnut but the badness of birch (Models Q, T, M and R). However, the tone and "flavor" of some of the responses on this issue suggest that consumers would pay less attention to it in the "real world."

. Wood Gloss

Model V, again, is overwhelmingly preferred, perhaps due in part to a "spillover" effect of its admired color. However, there is a strong case among consumers to support the preference for a non-gloss finish, as the following verbatims illustrate:

"A polyurethane finish gets scratched in the brush and it always needs to be polished."

"A high gloss looks nice but it's just not practical. It scratches too easily."

"A high gloss finish is made for target shooting. Nongloss is made for hunting."

The one high gloss model in the test (R) is widely liked, especially in Houston and among lever action users, but just as widely disliked, specifically in Atlanta and among bolt action users. There are few in the middle.

Front Bead

This issue does not seem to be too important to the respondends; many are indifferent to the question of color preference for the bead. However, there are a few isolated verbatims showing some minority preference for a gold or brass bead and some for a ball instead of a bead:

"I like a gold or brass bead that can be shined up. It's easier to clean and see."

"My preference is for a ball versus a bead. To me its easier to see." "Most people with a bolt action gun put a scope on it anyway, so it really doesn't matter."

Bolt Handle Contour and Styling

Model V, which is straight, not dog-legged, with a knurled knob is the clear favorite among all areas and both lever and bolt action users. Respondents prefer the large, completely rounded, knurled ball because of its feel:

"I like V. It is swept back just a little bit and it has a nice big round knob on it and it is also checkered - which gives you a little bit of a grip."

Model T, which is straight like V but has a flat bolt handle is highly disliked across the board:

"Terrible - you can't get a hold of it."

Bolt Body Blueing

This feature is almost unanimously rejected (96%), for the reason that it will not last:

"It doesn't matter. It won't stay blue."

"I prefer a polished bolt body because the blueing will rub off."

Bolt Body Jeweling

Jeweling is preferred by a three to one margin, but probably would not support much of a price increment, if any. Cost reactions are mixed, with some men stating it should be standard on the gun, but a few others perhaps willing to

pay between \$5.00 and \$10.00 for it:

"If it's a good manufacturer it should be standard with the gun."

"I think it looks nice but wouldn't pay more than \$10.00 for it. \$5.00 is more reasonable."

"I prefer jeweling but I wouldn't pay extra for it."

Type of Safety

The 2-position safety with a separate bolt release mechanism is clearly approved (in the S version, though, not the M). In effect, it offers the advantages of any or all of the others, without the disadvantages:

"I don't like the 3-position safety -- there's more to go wrong."

"I prefer a separate release on the other side of the bolt away from the safety location. This would never foul up."

"I like the bolt release completely separate from the safety -- less complications."

Between these two 2-position safetys with separate bolt release mechanisms, Model S with the button type bolt release is preferred much more strongly than M. The "rocking lever" treatment of M is actually the least preferred safety (of any and all types) in the entire test:

"It's a brush catcher. and it takes (too) little pressure to release it."

Between the two types of conventional 2-position safetys, opinion is divided, with just a slight edge for the type in which the bolt is locked down on safe. Each type has its supporters, though.

Model V (bolt locked down on safe):

"I have three teenage boys and i don't want them to have any choices."

Model Q (bolt can be opened on safe):

"I don't think most people find it that important for the bolt to lock down -- as long as the safety is still on and it won't fire. That's the main thing. With Q you are able to load and unload with the safety on."

In addition to the personal safety aspects of the above viewpoints, there is some preference for the lock-down treatment
on grounds that it prevents accidental snagging and lifting
of the bolt on a twig, unbeknownst to the hunter, thus
possibly resulting in a missed opportunity.

There is some favor, as well, for the 3-position safety, but others feel it is too complicated -- just another thing to go wrong:

"I don't like the 3-position safety. There's more to go wrong. The simpler the better."

After a demonstration, however, several decided they like it:

"Maybe with a 3-position safety there is less of a possibility that the gun would go off when loading it." "When I'm hunting with lots of people getting in and out of a car, I don't want it to go off. The 3-position safety would avoid this."

However, with all the different choices, there is a clear consumer preference in this research for a safety that has a separate bolt release mechanism that lets you "have it your way," whatever that way may be.

Location of Safety

The shroud location, as on the Winchester Model 70 fares poorly. The side locations on the test products are much preferred, especially Model V. A few respondents mention preference for the Remington Model 700 location.

Overall Preference

Respondents clearly prefer Model V by far when asked about overall preference; and this is supported by their strong preferences for Model V's fore-end contour design, bolt handle contour and styling, wood color, wood gloss, and location of safety. However, not too much importance should be attached to this particular finding, since the more detailed results on features, as discussed herein, suggest that some sort of "composite" model is called for, drawn from favored aspects of the various prototypes.

Calibers

There is a wide range of opinion on what calibers respondents feel would be most appropriate for this new gun. About 50% of the sample feel either a .243 or .308 caliber is best suitable, while almost a quarter of the sample agree that a 30-30, 6mm or a 270 would be best.

Price Expectations

Anticipated prices* for the versions of the gun that respondents themselves have "designed," via their reactions and preferences regarding the various features at test, range from a low of \$125 to a high of \$265. There are two modal levels -- one at \$175 and another, smaller one at \$200. The median expectation is about \$180, with bolt action users a bit higher than lever action users, and the Detroit area higher than the other areas.

Purchase Intent

Overall, about two-thirds of the total sample express positive purchase intention ("definitely" or "probably" would buy) at their anticipated prices, with little difference (except in the top box) between those with higher versus lower anticipated prices. Overall, the "probablys" outnumber the "definitelys" by about two to one; but there is considerably more top box interest among bolt action users. Purchase intent is

^{*}Respondents were instructed to answer in terms of "suggested retail (list) price"; and, for purposes of comparison, were given the suggested retail (list) prices of the Remington Model 788 (\$175), Model 700 ADL (\$245) and Winchester Model 94 (\$140).

also higher in Atlanta (91%) and lowest in Houston (46%).

There is no total outright rejection ("definitely" would not buy) and moderate rejection ("probably" would not buy) is rare; most of the rest of the sample is in the "might or might not" category.

APPENDIX

Table 1

Demographics of Sample

Area	Total Sample (50)	Houston (24)	Atlanta (11)	Detroit (15)	Lever Action (25)	Bolt Action (24)
Houston Atlanta Detroit	483 22 30	100%	- \$ 100 -	-% - 100	58 % 27 60	423 73 40
Action						
Lever Eolt	52 % 48	58 1 42	27 % 73	60% 40	100\$	-\$ 100
Guns Owned	(49)	(23)	(11)	(15)	(25)	(24)
One Two Three Four Five Six Seven More than seven	18\$ 2 12 6 4 6 4	13% 4 13 9 4 4 13 40	-\$ -9 -9 - -82	40% 13 7 	243 4 16 4 8 4 8 32	13% 8 8 - 8 -
Marital Status	(50)	(24)	(11)	(15)	(26)	(24)
Single Married	12 % 82	8 \$ 8 8	9 % 91	20% 67	19 % 73	4 % 9 2
Divorced/separa- ted/widowed	6	4	•	13	8	4
Age of Respondent	(47)	(24)	(10)	(13)	(25)	(22)
Under 30 31 - 40 41 - 50 Over 50	30% 33 19 18	25% 41 21 13	40% 20 10 30	31 % 31 23 15	32 % 32 20 16	27% 37 18 18

(Cont'd.)

Table 1

Demograhics of Sample (Cont'd.)

Education	Total Sample (50)	Houston (24)	Atlanta (11)	Detroit (15)	Lever Action (26)	Bolt Action (24)
High school or less Some college	14 % 40	8 % 38	18\$ 55	20\$ 33	12% 46	17 % 33
College graduate or more	38	50	•	47	38	37
Technical/ trade school	8	4	27	-	4	13
Occupation	(50)	(24)	(11)	(15)	(26)	(24)
Professional/ managerial Sales/clerical Skilled worker Unskilled worker Retired/student	46% 10 32 4 8	55 [†] 4 29 8 4	36% 9 36 - 19	40% 20 33 7	23% 15 42 8 12	71 \$ 4 21 4
Income	(50)	(24)	(11)	(15)	(26)	(24)
Under \$15,000 \$15,000 - \$19,999 \$20,000 - \$24,999 \$25,000 - \$29,999 Over \$30,000	14% 12 14 18 42	16% 13 8 21 42	94 18 9 27 37	13% 7 27 7 46	16% 15 19 19 31	13% 8 8 17 54
Family Members Who Hunt or Shoot	*(50)	(24)	(11)	(15)	(26)	(24)
Wife Son(s) Daughter(s) Brother(s) Father None	14% 30 6 10 8 48	17% 33 4 · 13 8 46	18% 36 18 9 9	7% 20 - 7 7 67	15% .38 .4 19 15 35	13 [‡] 21 8 - 63

^{*}Multiple response

Table 2
Concept Acceptance

	Total Sample (50)	Houston (24)	Atlanta (11)	Detroit (15)	Lever Action (25)	Bolt Action (24)
Like it a lot	30\$) {80\$	25 %	27¶ 91\$	40 %) 87%	279	339
Like it somewhat	50	46 5' 13	64 5	47	46 5	54
Indifferent	20	29	9	13	27	13
Dislike it some- what	•	-	-	-	-	•
Dislike it a lot	•	-	•	•	-	-

Table 3
Model Acceptance

	Total Sample (50)	Houston (24)	Atlanta	Detroit	Action (26)	Action (24)
Like it a lot	42\$) (96\$	38%)	45%) {100%	479	2 7 2 3	633)
Like it somewhat	S4 }90 €	54 }925	55 \$ 100 \$	100% 53	73	33
Indifferent	-	-	-	-	-	-
Dislike it some- what	4	8	-	-	4	4
Dislike it a lot	-	-	-	-	-	- •

Table 4 Specific Model Reactions*

	Total Sample (50)	Houston (24)	Atlanta (11)	Detroit (15)	Lever Action (26)	Bolt Action (24)
Lightweight with bolt action/best of both worlds	44%	38\$	45%	53%	31%	583
Smaller in size/ shorter (posi- tive)	26	25	27	27	23	29
Easy to handle/ to carry/to use/ faster/better handling and maneuverability	16	13	9	27	15	17
Offers high calibers in a carbine style gun	12	8	9	20	8	17
Good for brush country/small gun	12	21	9	-	15	3
Good for women/ children/small people	12	2.5	-	<u>-</u>	12	13
Nice appearance/ design/eye appeal	L 10	4	18	13	12	8
New/different	8	8	18	-	12	4
Compact/all around rifle	i 6	4	9	7	4	8
A good marketable product	4	-	9	7	4	4
Kicking/recoil power stronger	4	8	-	-	8	-
Looks too short/ too small	4	8	-	-	-	8
Other**	12	25	18	7	12	13
No reason/answer	6	-	18	7	-	•

^{*}Multiple response

**Other includes: feels comfortable/good safety features/action seems
simple and easy/good compromise buy/full accuracy for distance hunters/ likes all Remington guns,

Table 5
Appropriate Calibers for Model

Calibers	Total Sample (50)	Houston (24)	Atlanta (11)	Detroit (15)	Lever Action (26)	Bolt Action (24)
.243	56%	71%	64%	278	46%	67\$
.308	46	42	73	33	42	50
30-30	24	25	18	27	31	17
6 mm	24	21	55	7	15	33
. 270	22	25	27	13	23	21
30-06	20	8	45	20	27	13
22-250	10	13	9	7	8	13
30 cal.	8	4	9	13	4	13
.222	6	8	-	7	4	8
7 mm	4	8	-	•	4	4
35	4	-	9	7	8	-
.306	4	-	•	13	4	4
.300	4	-	•	13	8	-
Other*	20	25	9	20	19	21

*Other includes: 22 Hornet/.223/250/.22 mag/.375 Win./.25/.223 to .30/Rem 700/44 mag/350 mag

Table 6

Overall Preference = Net Scores*

Model	Total Sample (50)	Houston (24)	Atlanta (11)	Detroit (15)	Lever Action (25)	Bolt Action (24)
V	57	22	15	20	,29	28
Q	7	7	-	-	-	7
S	4	6	3	- 5	Z	2
R	2	-4	-	6	2	-
М	-1	4	-2	-3	-2	1
T	-12	-8	-3	-1	-3	-9
			•		1.	

^{*}On this and on the next nine tables, net scores are derived from assigning two points for each "best" response; one point for each "second best" response and deducting two points for each "least" response.

Table 7

Fore-End Contour Design = Net Scores

Model	Total Sample (50)	Houston (24)	Atlanta (11)	Detroit (15)	Lever Action (26)	Bolt Action (24)
v	37	. 5	17	15	16	21
T	32	9	9	14	14	18
R	9	4	3	2	5	4
М .	4	2	1	1	4	•
Q	•	12	- 9	-3	5	- 5
S	-29	- 5	-12	-12	-12	-17

Table 8

Sling Straps and Swivel Mounts
(Studs/Barrel Bands) = Net Scores

Model_	Total Sample (50)	Houston (24)	Atlanta (11)	Detroit (15)	Lever Action (25)	Bolt Action (24)
R	45	2\$	8	12	25	20
T	44	16	12	22	22	23
M	4 ,	8	3	-7	-3	7
V	3	-4	2	5	2	1
s	-22	-4	-8	-10	-11	-11
-Q	-22	-9	-6	-7	-9	-13

Table 9

Bolt Handle - Contour and Styling = Net Scores

Model	Total Sample (50)	Houston (24)	Atlanta (11)	Detroit (15)	Lever Action (25)	Bolt Action (24)
A	71	32	22	17	33	38
Q	20	11	1	8	12	8
s	16	5	2	9	1	6
R	-	-1	· ` -1	2		3
М	- 2	-2	-	-	-	-4
T	-52	-20	-12	-20	-27	-25

Table 10

Grip Design = Net Scores

Model	Total Sample (50)	Houston (24)	Atlanta (11)	Detroit (15)	Lever Action (26)	Bolt Action (24)
T	30	13	12	5	13	17
Λ	12	10	3	-1	12	-
Q	8	2	6	-	-2	10
S	、3	3	-6	6	4	1
М	3	1	1	1	5	-2
R	1	-3	-1	5	1	-
		1			i	

Table 11

Butt Pad = Net Scores

Model	Total Sample (50)	Houston (24)	Atlanta (II)	Detroit (13)	Lever Action (26)	Bolt Action (24)
М	18	31	-14	1	16	2
Λ	13	-4	8	9	10	3
S	10	-22	20	12	-	10
R	9	21	-4	-8	5	4
T	4	4	2	- 2	-1	5
Q	-1	-5	-	4	-4	3

Table 12
Wood Color = Net Scores

Model	Total Sample (50)	Houston (24)	Atlanta (11)	Detroit (15)	Lever Action (26)	Bolt Action (2+)
V	47	20	8	19	31	16
s	6	5	6	- 5	-1	7
R	5	7	-4	2	-1	6
T	3	-4	2	5	-2	5
М	•	-	-	-	4	-4
Q	-9	-5	-	-4	-4	- S

Table 13
Wood Gloss Level = Net Scores

Model_	Total Sample (50)	Houston (24)	Atlanta (II)	Detroit (15)	Lever Action (25)	Bolt Action (24)
v	36	7	13	16	20	16
S	14	5	7	2	5	9
М	3	5	2	-4	2	1
R	3	18	-16	1	10	-7
T	2	-6	3	5	-4	6
Q	-6	-5	1	-2	-5	-1

Table 14

Type of Safety = Net Scores

Model	Total Sample (50)	Houston (24)	Atlanta (11)	Detroit (15)	Lever Action (26)	Bolt Action (24)	
S	33	14	15	4	16	17	
V	17	9	2	6	5	12	
Q	11	1	-	10	-	11	
R	6	12	- 5	-1	6	-	
Winchester	r 70 6	-	6	-	1	5	
T	-1	1	•	-2	. 4	- 5	
М	-17	-12	-4	-1	-3	-14	

Table 15

Location of Safety = Net Scores

Mode1	Total Sample (50)	Houston (24)	Atlanta (11)	Detroit (15)	Lever Action (26)	Bolt Action (24)
V	34	16	7	11	14	20
R	15	10	1	4	1	14
S	10	10	8	-8	3	7
Q	16	9	-2	9	11	5
М	-7	-5	•	-4	1	-8
Τ	-2	- 5	-	3	2	-4
Winchester 7	0 -7	-10	2	1	-6	-1

Table 16
Checkering*

Model	Total Sample (50)	Houston (24)	Atlanta (11)	Detroit (15)	Lever Action (26)	Bolt Action (24)
Q	56%	58%	73%	40%	62\$	50%
T	42	38	27	60	38	46
No choice	2	4	•	-	-	4

^{*}In the case of this characteristic, only two models had a checkering feature, therefore, the net scores were not meaningful. Percentages in this table refer to the number of people who felt that model was the better of the two.

Table 17
Feature Preferences

	Total Sample (50)	Houston (24)	Atlanta (11)	Detroit (15)	Lever Action (26)	Bolt Action (24)
Prefer grip cap	58%	67%	91%	20%	58\$	58\$
Prefer no grip cap No answer	4 0 2	33	9	80	38 4	42
Prefer checker- ing Prefer no	84 %	87%	100%	673	85%	83\$
checkering	16	13	-	33	15	17
Prefer regular fore-end contour Prefer schnabel	72%	58 %	100%	73%	62%	83%
fore-end contour	28	42	-	27	38	17
Prefer blued bolt body Prefer non-blued	4 \$	4 %	- \$	7%	4 %	4 \$
bolt body	96	96	100	93	96	96
Prefer jeweled bolt body Prefer non- jeweled bolt	76%	75%	100%	60\$	73%	79\$
pody	24	25	-	40	2.7	21

Table 18
Price Expectations

	Total Sample (50)	Houston (24)	Atlanta (11)	Detroit (15)	Lever Action (26)	Bolt Action (24)
Median	\$180.00	\$175.00	\$180.00	\$200.00	\$180.00	\$187.50
Mode	\$175.00	\$175.00	\$175.00	\$200.00	\$175.00	\$175.00
Range	\$125.00 to \$265.00	\$125.00 to \$245.50	\$160.00 to \$265.00	\$140.00 to \$250.00	\$125.00 to \$245.00	\$150.00 to \$265.00

Table 19
Purchase Intent

	Total Sample (50)	Houston (24)	Atlanta (11)	Detroit (15)	Action (26)	Bolt Action (24)
Definitely would buy	20%)	21%)	27%)	13%)	123	29\$
Probably would buy	44 }64%	25 }46	\$ \}919 64 \}	60	50 }6	29% 2% 37 66%
Might or might not buy	22	33	-	20	26	17
Probably would not buy	14	21	9	7	14	17
Definitely would not buy	-	-	•	-	-	•

Table 20

Purchase Intent at Different Price Expectation Levels

BARBER - PRESALE R 0127994

	Total Sample (50)			Lever Action (26)			Bolt Action (24)		
	\$175 and Under (22)	\$180 to \$200 (19)	Over \$200 (9)		\$180 to \$200 (10)	Over \$200 (3)	\$175 and <u>Under</u> (9)	\$180 to \$200 (9)	0ver \$200 (6)
Definitely would buy									
Probably would buy	40	37	67	57 1 81 541	50	67	33 78 8	23	67
Might or might not buy	23	21	22	31	30	-	11	11	33
Probably would not buy	14	16	11	15	-	33	11	33	-
Definitely would not buy	-	-	-	-	- .	-	-	-	-

RD-49-8

REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE

Xc: C.3. Workman W.Forson



PETERS

"CONFINE YOUR LETTER TO ONE SUBJECT ONLY"____

Ilion, New York

May 8,

1979

TO:

PAUL HOLMBERG - Bridgeport

FROM:

J. W. BROOKS

ion L

BOLT ACTION CARBINE

The following list contains the items discussed during our meeting last Thursday:

Stock

- Rounded tip like V
- 2. Grip like T or M
- 3. Butt plate like S
- 4. Birch wood
- 5. Pressed checkering like pattern on T
- 6. Color like M
- 7. RK-W gloss finish
- 8. Top profile like R not V

Other Items

- 9. Stamped hinged floor plate
- 10. M/700 front & rear sights (no hood). Check old M '700 sights.
- 11. Bolt handle M/700 on V
- 12. Bolt body bright
- 13. Barrel bracket like M or T
- 14. Swivel studs on stock
- 15. Metal finish like on present model
- 16. Stamped steel follower M/600
- 17. Calibers 222, 6mm, 243, 308, 7mm-08
- 18. Model 700 Fire Control without bolt lock
- 19. Boit Lock separate from fire control to be added

depending on Development Schedule

We are in the process of having a stock made for this model with the proposed shape. We will use the Model 700 Trigger Assembly and Bolt Handle on the short Carbine receiver. By using this Trigger Assembly we must move the receiver forward to get the preferred grip shape. As we mentioned at the time, this will leave an extra amount of open inletting behind the receiver. This may be improved by reshaping the receiver and blending of the stock at this point. We will contact you when we have a stock finished.

If you have any questions concerning the above list, please contact us.

TW 3:T Thion Research Division

EXHIBIT NO. 21 GUN SERIAL NUMBER A6890062

STOCK

BIRCH WOOD
VINYL FINISH
CUT CHECKERING
CLASSIC STYLING
INLET FOR TRIGGER GUARD
FRONT AND REAR SWIVEL STUDS

BARRELED ACTION

18½ INCH BARREL LENGTH

Model 700 Barrel Bracket

Rounded Receiver Tang Similar to Model 700

Model 700 Bolt Handle

Model 700 Trigger Housing Assembly

Model 700 Type Bolt Release

Model 700 Type Safety Assembly

New Bolt Lock on Bolt Plug

New Stamped Floor Plate Assembly

Model 700 Front Sight Base

Model 700 BDL Front Sight Hood

Model 700 Rear Sight Assembly



EXHIBIT NO 22 GUN SERIAL NUMBER 6226223

STOCK

BIRCH WOOD
GLOSSY FINISH - MODEL 3
CUT CHECKERING
CLASSIC STYLING
INLET FOR TRIGGER GUARD

BARRELED ACTION

18½ INCH BARREL LENGTH
MODEL 700 BARREL BRACKET
ROUNDED RECEIVER TANG SIMILAR TO MODEL 700
MODEL 700 BOLT HANDLE
MODEL 700 TRIGGER HOUSING ASSEMBLY
MODEL 700 TYPE BOLT RELEASE
MODEL 700 TYPE SAFETY ASSEMBLY
NEW STAMPED FLOOR PLATE ASSEMBLY
MODEL 700 BDL FRONT SIGHT AND BASE
MODEL 700 BDL FRONT SIGHT HOOD
MODEL 700 REAR SIGHT ASSEMBLY



EXHIPIT 23

RD-49-8

REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE





Xc: C.B. Workman

"CONFINE YOUR LETTER TO ONE SUBJECT ONLY"_____

MEMORANDUM OF MEETING

NEW BOLT ACTION RIFLE

November 15, 1979

PRESENT:

L. G. Wilke

D. E. Bullis

L. B. Bosquet

I.W. Brooks

D.D. Parker

P.G. Johnson

K. F. Blumer

This meeting was held so Process Engineering could look at the first proposed model and suggest problem areas of manufacture that should be reviewed before final prototype models are made.

- 1. The checkering pattern is large and close to top of stock and bottom of grip. It may go over radius of grip and fore end too far for custom checkering.
- 2. The top edge of stock along barrel and receiver should be approx. .050 min. width to meet present manufacturing processes.
- 3. Define tang area with more detail to establish safety button clearance with stock, safety arm clearance to prevent breakthru during sanding, and possible machining operation to help improve blend sanding of tang area.
- 4. It would be nice to have rear grip end radius as close as possible to radius on bottom of stock at rear of grip for machining purposes.
- 5. Can bolt handle cut be described so that it can be put on at inletter rather than with Z-arm router.
- 6. Inletting of floor plate should have as many common radii as possible and as large as possible.
- 7. Screw holes in butt end of stock should be same as in M600 to use same fixtures if possible.
- Pitch should be same as M600 to use same fixtures if possible.

TWB:T

Ilion Research Division

RD-49-8

REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE





"CONFINE YOUR LETTER TO ONE SUBJECT ONLY"_____

Ilion, New York May 12, 1980

EXHIBIT 25

TO:

W. H. FORSON

FROM:

J. W. BROOKS

SUBJECT:

BOLT ACTION CARBINE IN 7mm-08 CALIBER - FIELD TEST

Per our telephone conversation last week, these models are still on schedule for field testing by June 1. We will need authorization for where and to whom these rifles should be sent. We can use an altered Model 700 shipping carton for shipping.

We will not be providing ammunition with the rifles.

We will notify you when the rifles are ready to ship.

If you have further questions, please let us hear from you. In the meantime we will keep you informed of our progress.

JWB:T

Firearms Research Division

FXHIBIT 26

193 EVERASE BOLT ACTION CARBINE TEST GUNS	513 113	20, 20 BUFF	BOLT	ACTION	CAPBINE	7ES1	GUNS	
---	------------	-------------	------	--------	---------	------	------	--

		444 = = =				
	SERIAL	CALIBER	STOCK	WEIGHT	RETURNED	WEIGHT
	NUMBER	<u> </u>	FINISH			F BUTT PLATE
J. G. WILLIAMS	86226240	7MM-08	RK	7420	3-12-81	
- G. M. E. M.		11111				
J. E. PREISER	B 622 6246	4	RK	74/50	3-12-51	
E. J. CONROY	86226248	4.	RK	7412	8-27-80	70 40
						1: 1:
. C. CALLAHAN	86226251	,,	RX	フザ	7-12-80	2" 32
R.J. REINECK	86226252		RE	64134	8-27-80	110/512
P. H. HOLMBERG	BGZ:262:57	1.	RK	1502.	3-12-81	
P.J. BERGERE	36226259	4.0	24	6 13ª.	7-10-80	2000
1						
D. GODFREY	56226273		RK	C# 14= 1-	7-25-80	2 2 1/4
1.3. COCKMAN	8622GZ75		RK	74	8-5-80	2 39
T. W. RAWSOU	8 62262/8		WINTE	7#20	B-27-80	2 4
W.H. FORSON JR.	8 6226232		VINYC	6 = 150	B-27-FD	2 4 14
N.L. OLDRIDGE	3622623L	1 1.1	VINYE	フガ za.	3-12-51	
K. N. WAITE	56226270		WAYE	60142	7-11-80	2"/1
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EXHIBIT 27

xc: R.L. Hall
H.K. Boyle
J.P. Linda
C.B. Workman
J.W. Brooks
L.B. Bosquet

Est. File #4152

May 27, 1980

G.D. Campbell

Bolt Action Carbine Rifles

Estimated 1980 factory cost for the walnut stocked version of the Bolt Action Carbine rifle has been developed. The processing of this stock parallels that of the Model 700 Classic. Specifications will include machine cut checkering and M/III finish with no grip cap or fore-end tip.

Illustrated on the first attached sheet is the 1980 full book factory costs of both the birch and walnut versions of the Bolt Action Carbine rifle. For comparison, the cost of an M/700 ADL and Mohawk 600 are also presented.

The second attachment compares the cost differences between the component assemblies of the aforementioned guns on an incremental cost basis. The incremental analysis will provide Research and Process Engineering a more definitive structural review of the proposed products.

Please see the attachments.

J.C. Hutton, Superintendent Industrial Engineering Section

By: S.M. Morris

SMM/kc Attach. (2)

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BARBER - PRESALE R 0128006

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EXHIBIT 28

xc: R.L. Hall
H.K. Boyle
J.P. Linde
C.B. Workman
J.W. Brooks
L.B. Bosquet

Est. File #4152

June 3, 1980

G.D. Campbell

Bolt Action Carbine Rifles

Following our submission of the 1980 factory costs for the (2) versions of the Bolt Action Carbine Rifle, a request for suggested 1980 retail prices was forwarded. Accompanying this request was a Marketing directive to establish the retail prices using the current 1980 M/700 ADL and BDL factory margins. Respectively, these margins would be aligned to the birch and walnut versions of the B.A.C.

Please see the attached subdivision #3.

J.C. Hutton, Superintendent Industrial Engineering Section

1. C. Huitin

By: S.M. Morris

SMM/kc Attached

, BARBER - PRESALE R 0128008 BOLT ACTION CARRINE - ESTABLISH & 1980 SUGGESTED HETAIL PRICE BY MAINTAINING MICO ADL INVIOO BOL QUANTITY 13571.95 1980 SUGGESTED RETAIL PRICE 157.84 1189162 131 83 1221.85 142 05 PRETAX EARNINGS 24/24 29 69 26.01 32.78 1/ OF NET SELLING 17.3% 16.5 % 17.3 1/2

EXHIBIT 29

xc: R.L. Hall
H.K. Boyle
J.P. Linde
C.B. Workman
J.W. Brooks
L.B. Bosquet

Est. File #4152

June 16, 1980

G.D. Campbell

Bolt Action Carbine

A hi-spot cost analysis of a Bolt Action Carbine rifle with a birch stock and N/C cut checkering has been made. The processing of this stock was reviewed with Larry Wilke, and at that time it was decided to use M/III finish. The resulting 1980 factory cost for this version of gun would be \$112.51. Please see the attached comparison.

JC. Hutton, Superintendent Industrial Engineering Section

By: 3.M. Morris

SM/kc Attached

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EXHIBIT 30

xc: R.L. Hall
H.K. Boyle
J.P. Linde
C.B. Workman
J.W. Brooks
L.B. Bosquet

Est. #4152

July 9, 1980

G.D. Campbell

Bolt Action Carbine

The high spot cost analysis of the proposed Bolt Action Carbine rifle has been revised to include the following changes:

- *Substitute the M/600 Magazine Follower for the M/700 Magazine Follower (32.54 cost reduction).
- *Substitute the M/700 Package for the M/600 Package (\$.29 cost reduction).
- *Re-estimate the Walnut and Birch Stock with N/C cut checkering per processes supplied by PE&C (\$1.25 cost reduction for Walnut Stock; \$.62 cost increase for Birch Stock with N/C checkering).

Unit costs for the three options being considered are shown in the attached table. All costs are expressed in 1980 full book dollars. The proposed Bolt Latch mechanism is not included in these costs.

J.C. Hutton, Superintendent Industrial Engineering Section

By: T.R. Andrews

TRA/kc Attached

BARBER - PRESALE R 0128012 ARBINE

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EXHIBIT 31

xc: R.L. Hall
H.K. Boyle
J.P. Linde
C.B. Workman
J.W. Brooks
L.B. Bosquet
R.S. Swartz

Est. #4152

July 16, 1980

G.D. Campbell

Bolt Action Carbine - Bolt Lock Mechanism

An evaluation of the proposed bolt lock mechanism for the Bolt Action Carbine indicates it will result in \$3.99 in additional cost on a 1980 full book basis. The additional costs are summarized by component in the attached table.

£C. Hutton, Superintendent Industrial Engineering Section

By: T.R. Andrews

TRA/kc Attached

BARBER - PRESALE R 0128015

RD-49 REV. 4-58

REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE



CC: C. B. WORKMAN (No Attach.)
J. S. MARTIN " "

J. W. BROOKS
D. E. BULLIS

EXHIBIT 32

· .

BRIDGEPORT, CONN.

MAY 14, 1980

KURT BLUMER

SUBJECT: FLOOR PLATE LATCH FOR BOLT ACTION CARBINE WITH STAMPED TRIGGER GUARD

I have made a patent search on the latch shown in Drawings C-91840, '841, '843, '850; B-91845, '848; and an unnumbered assembly drawing you signed on April 1. Nothing has been found that could raise any risk of patent infringement if Remington adopts this design.

There are any number of patents showing examples of magazine or floor plate latches of the type having a pivot pin mounted in the receiver, in the magazine, or in the trigger guard. None of these is any more similar to your design than the Model 700 floor plate latch you showed me. As one example generally illustrating the type of designs shown in prior patents, I am enclosing a copy of Patent 667,856 - Wagner.

On the basis of this search, it appears to me that we may be able to secure some patent protection on the new latch, and I will undertake to prepare an application.

W. L. Ericson
WILLIAM L. ERICSON
SENIOR PATENT COUNSEL

WLE/dt Attach.

D-240

RD-48 REV. 4-16

EXPLIFIT 33

REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE

Remington.

cc: J. E. Preiser
P. H. Holmberg
W. J. Weeks

W. J. Weeks

Bridgeport, CT October 14, 1980

TO:

W. H. FORSON

FROM:

J. H. CHAMBERS

SUBJECT:

BOLT ACTION CARBINE FIELD TEST

During the middle of June, field tests of a prototype bolt action carbine were held by Regional Managers and select A. O. Building personnel. All the test guns were chambered for the 7mm-08 caliber.

The testers were also sent a questionnaire which they were asked to fill out after they had a chance to fire the test gun.

While there were varied comments about the test gun, consensus centered around the following issues:

- The gun tested was "too heavy" for a carbine should be in the 6-1/2 lb. area.
- Stock was too "fat" not trim enough for saddle/scabbard gun.
- Barrel diameter should be reduced to improve aesthetics and reduce weight.
- Price should be at least \$20 below M/700ADL ideally equally between M/788 and M/700ADL.

Other comments mentioned frequently were:

- Bolt handle should be "turned in" more necessary for saddle gun.
- A walnut stock would be a big plus.
- This gun would fill void left by M/600.
- The floor plate is somewhat cheap looking resembles M/541.

Should you wish to read through the 15 completed questionnaires, just let me know.

JHC: hm 3

7mm-08 Cal. Serial # 86226255

1.	What do you like about the new bolt action rifle?
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4.	In terms of overall quality, how does this new gun compare to other center fire rifles in Remington's line?
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	Hort such a Conse CHONOLON MORERANCE
5.	Given a \$210 suggested retail price for the M/788, a \$298 price for the M/700 ADL and a \$358 price for the M/700 BDL, where do you think the new gun would fit in our line from a price standpoint?
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•	Continued

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PAGE 2

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6.	Do you feel the gun's design is unique?
	Yes — Answer Q7
	No Skip to Q8
7.	What do you think is unique about the gun you tested?
8.	The gun you tested has an 184" barrel. Would you prefer some other barrel length?
	Yes
	No ZZ - Skip to Q10
9.	What barrel length would you prefer?
	Write barrel length here:
10a.	We are considering a number of stock finishes and whether to cut or press checker the gun. If the new rifle were cut checkered would you prefer a glossy or satin finish?
	Glossy (for - Dead France France)
	Satin Decry Softwork To Tele
10b.	If the gun were press checkered, would you prefer a glossy or satin finish?
	Glossy 💢
,	Satin

....Continued

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Design Nor Ton Powerto
.243, 6mm, .308 and 7mm-08 at a retail price \$20 below M/700 ADL, what impact would it have on other Remington fire rifles?
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M/700 ADL, what impact would it have on other Remington fire rifles? State of the State of the Property State Change of the State Change of the State Change of the Chang

7mm-08 Cal. Serial #B6226259

1.	What do you like about the new bolt action rifle?
	I like the concept of a high quality bolt action carbine.
	Plus-factors of my sample include cut checkering, correct
	barrel length and high gloss finish.

2. What do you dislike about this new gun?

> If our objective is to provide consumers with a lightweight carbine, I would recommend additional investigation to reduce weight by approx. 1 lb. This sample weighs slightly over 7 lbs. and feels no lighter than an average M/700. Other negative factors as follows (see other side #2.).

- ∙3. How would you improve the consumer acceptance of this bolt action rifle?
 - Reduce weight and bulk.

Improve stock material, finish and design.

- Provide aluminum cast trigger guard and mag. cover to enhance quality, reduce weight.
- Include a hard rubber rifle pad replacing current butt plate. Reduce barrel diameter and weight.

(Continued on other side, #3.)

In terms of overall quality, how does this new gun compare 4. to other center fire rifles in Remington's line?

> An upgraded version of our M/788; at best, equal in perceived value to the M/700 ADL. (Not near M/700 BDL standards.)

5. Given a \$210 suggested retail price for the M/788, a \$298 price for the M/700 ADL and a \$358 price for the M/700 BDL, where do you think the new gun would fit in our line from a price standpoint?

> In its current form, I would not price any higher than the M/700 ADL. I visualize the end product to be a miniature M/700 BDL priced at approximately \$325.

> >Continued

	•
•	Do you feel the gun's design is unique?
	Yes Answer Q7
	No ZZ - Skip to Q8
	What do you think is unique about the gun you tested?
	The gun you tested has an 184" barrel. Would you prefer some other barrel length?
	Yes — - Answer Q9
	No XX - Skip to Q10
	What barrel length would you prefer?
	Write barrel length here:
	We are considering a number of stock finishes and whether to cut or press checker the gun. If the new rifle were cut checkered would you prefer a glossy or satin finish?
	Glossy A My personal preference is satin, but I
	would recommend glossy finish in both instances for maximum consumer acceptance
	If the gun were press checkered, would you prefer a glossy or satin finish?
	Glossy 🖾
	Satin
	Continued
	a a a a LONT I NUPCI

PAGE 3

			<u> </u>	
How do you feel about	the new floo	r-plate:	?	
Floor plate operation	is excellen	t; other	commen	its in
			 	
	· · · · · · · · · · · · · · · · · · ·	······································		
How would you rate the characteristics and fe	gun you tes	ted on	the fol:	lowing
		Very		
	Excellent	Good	Good	Fair
Contour of stock				<u></u>
Weight				
Recoil				•
Ease of Operation		/		
Overall Quality				
Color of Stock				
Metal Finish			1	
Design of			/	
Checkering Pattern		ill appe	al?	
Checkering Pattern To whom do you think	this rilfe wi			

....Continued

	should we advertise the rifle you tested?
A c	empact and easy to handle bolt action rifle with
exc	llent accuracy periormance.
_	
1.7 % -	- dans the count Barobins man to come
MUS	does the word "carbine" mean to you?
Му	eaction to "carbine" is a compact, lightweight
and	quick pointing rifle.
.24 M/7	ming the new gun was introduced in 1980 in .222, . 3, 6mm, .308 and 7mm-08 at a retail price \$20 below 30 ADL, what impact would it have on other Remingto 4 rifles?
.24 M/7 fir	8, 6mm, .308 and 7mm-08 at a retail price \$20 below 00 ADL, what impact would it have on other Remingto e rifles?
.24 M/7 fir Sin	3, 6mm, .308 and 7mm-08 at a retail price \$20 below 00 ADL, what impact would it have on other Remingto rifles? The this rifle does not appear capable of generating the stantial new interest which might provide an extending the stantial new interest which might provide an extending the stantial new interest which might provide an extending the stantial new interest which might provide an extending the stantial new interest which might provide an extending the stantial new interest which might provide an extending the stantial new interest which might provide an extending the stantial new interest which might provide an extending the stantial new interest which might provide an extending the stantial new interest which might provide an extending the stantial new interest which might be stantial new interest which might be stantially the stantial new interest which we will never a stantial new interest which we will never a stantial new interest which we will never a stantial new interest which we will never a stantial new interest which we wi
.24 M/7 fir Sin Sub	8, 6mm, .308 and 7mm-08 at a retail price \$20 below 10 ADL, what impact would it have on other Remingto e rifles? Le-this rifle does not appear capable of generating stantial new interest which might provide an extention of market. I feel that most sales would be at
.24 M/7 fir Sin Sub	3, 6mm, .308 and 7mm-08 at a retail price \$20 below 00 ADL, what impact would it have on other Remingto rifles? The this rifle does not appear capable of generating the stantial new interest which might provide an extending the stantial new interest which might provide an extending the stantial new interest which might provide an extending the stantial new interest which might provide an extending the stantial new interest which might provide an extending the stantial new interest which might provide an extending the stantial new interest which might provide an extending the stantial new interest which might provide an extending the stantial new interest which might provide an extending the stantial new interest which might provide an extending the stantial new interest which might be stantial new interest which might be stantially the stantial new interest which we will never a stantial new interest which we will never a stantial new interest which we will never a stantial new interest which we will never a stantial new interest which we wi
.24 M/7 fir Sin Sub	8, 6mm, .308 and 7mm-08 at a retail price \$20 below 10 ADL, what impact would it have on other Remingto e rifles? Le-this rifle does not appear capable of generating stantial new interest which might provide an extention of market. I feel that most sales would be at
.24 M/7 fir Sin sub "ca exp	8, 6mm, .308 and 7mm-08 at a retail price \$20 below 10 ADL, what impact would it have on other Remingto e rifles? 10 rifles? 10 rifle does not appear capable of generating stantial new interest which might provide an extension market, I feel that most sales would be at ease of our present M/88 and M/700 ADL offerings. 11 rifle does not appear capable of generating stantial new interest which might provide an extension market, I feel that most sales would be at ease of our present M/88 and M/700 ADL offerings.
.24 M/7 fir Sin Sub "ca exp	3, 6mm, .308 and 7mm-08 at a retail price \$20 below to ADL, what impact would it have on other Remingto rifles? Le-this rifle does not appear capable of generating stantial new interest which might provide an extension market, I feel that most sales would be at ease of our present M/88 and M/700 ADL offerings. GE TESTED ON: URNED TO JOHN BROOKS, ILION: 7/3/80
.24 M/7 fir Sin Sub "ca exp	8, 6mm, .308 and 7mm-08 at a retail price \$20 below 10 ADL, what impact would it have on other Remingto e rifles? 10 rifles? 10 rifle does not appear capable of generating stantial new interest which might provide an extension market, I feel that most sales would be at ease of our present M/88 and M/700 ADL offerings. 11 rifle does not appear capable of generating stantial new interest which might provide an extension market, I feel that most sales would be at ease of our present M/88 and M/700 ADL offerings.

7mm-08 Cal. Serial #86226220

ı.	What do you like about the new bolt action rifle?
	Stock dinusins + fit - Accuracy - General
	appearance as a carbine. Magrileus is good , don
•	the the resemblance of a 700 Jr.
2.	What do you dislike about this new gun?
	Dull finish detraits from The gun porticularly with
	The brech. It adult from is doctred a much darker store should be used
Kicks II	Kehell but Trealize the snot a bouch will . Floor plate release is
Too large	How would you improve the consumer acceptance of this bolt
3.	/How would you improve the consumer acceptance of this bolt action rifle?
	The wood finish and smooth up satisfy and betterns &
	in the stock also see = objections
M ca.	ell consider 2 grades - 13 inch other walnut with proce differential 3 = 3
Pickap	owners may be more interested in a cheaper tool with biret.
4.	In terms of overall quality, how does this new gun compare to other center fire rifles in Remington's line?
	As noted - a short 700 700 Jr.
	Bruch more closured Losigo Thank Das.
5.	Given a \$210 suggested retail price for the M/788, a \$298 price for the M/700 ADL and a \$358 price for the M/700 BDL, where do you think the new gun would fit in our line from a price standpoint?
	250 Birch 280 walnut - It has some features the Adl
	does not have (May reclease) yet I don't believe we should
	compete with 700 price wice
	Continued

•		
Do you fee	1 the gun	's design is unique?
•	Yes	△ - Answer Q7
	No	
What do yo	u think i	s unique about the gun you tested?
Its resu	Hace to	700 which shield how custome appeal
The gun yo		has an 184* barrel. Would you prefer ength?
_	Yes	☐ - Answer Q9
a cer becastrin What barre Wri	No The The	187 - Skip to Q10 Not, five eveta off requests for return offee 600 in the south so was obsoleted would you prefer? The wight is a problem of the length here: I halance faccuracy is
Wri We are con to cut or	No The Same De l'al length de barrel desidering press che	All - Skip to Q10 Not , f we eve to off requests far return of the 600 in the south so was a holeted would you prefer? The weight is a problem of length here: I weight is a problem of stock finishes and whether ecker the gun. If the new rifle were you prefer a glossy or satin finish?
We are conto cut or	No The Same I length ite barrel isidering press che red would Glossy	AT - Skip to Q10 Not , f we eve to off requests far return offee 600 in the south so was absolved would you prefer? The weight is a problem of the length here: I weight is a problem of stock finishes and whether ecker the gun. If the new rifle were you prefer a glossy or satin finish?
We are conto cut or	No The Same I length ite barrel asidering press che red would	AT - Skip to Q10 Not, five evets off requests far return of the LCD in the south so was absoluted would you prefer? The wight is a problem would you prefer? I length here: I wast gate a lighter barrel balance of accuracy is a number of stock finishes and whether ecker the gun. If the new rifle were you prefer a glossy or satin finish?
We are conto cut or cut checke	No line. The same to length ite barrel sidering press che red would Glossy Satin	A - Skip to Q10 Not , f we eve to off requests far return of the LCD in the south so was absoluted would you prefer? The weight is a jordlene would you prefer a flower to a number of stock finishes and whether ecker the gun. If the new rifle were you prefer a glossy or satin finish? Unless a darker stain can be used a cutchankering durkent and fusiones?
Write are conto out or cut checke	No line. The same of length ite barrel sidering press che red would Glossy Satin were presinish?	AT - Skip to Q10 Not, fine each offerences of the course o

....Continued

PAGE 2

BOLT ACTION RIFLE QUESTIONNAIRE

PAGE 3

How do you feel about		_		L	
- great idea b	ut reduce		<u>f. refe</u>	es to	prive
		·			-
How would you rate th	e gun you tes	ted on	the fol:	lowing	
characteristics and f	eatures?				
- مندار	Excellent	Very Good	Good	Fair	Poor
Contour of stock					
Weight	sec 11				
Recoil					۲
Ease of Operation	<u>X</u>				
Overall Quality		<u>x</u> -	- 12		
Color of Stock	**************************************				X
Metal Finish			<u> </u>		
Design of Checkering Pattern			×		

.....Continued

BOLT ACTION RIFLE QUESTIONNAIRE

PAGE 4

What do	es the word "carbin	e" mean to you?		
******	A light weight eas	y to covery	But speaking rist	اد
-243, 6	g the new gun was i mm, .308 and 7mm-08 DL, what impact wou fles?	at a retail pr	ice \$20 below the	2
The 75	ruill de slauly	and it will a	Hect Ton ADL C	les
Hacky	4 it well outthe Rug	e. 72 popularita		
ctge	I we wented to with light recoil	_		16-1 11 es
2/2 6	maidared	7 A ()		

7mm-08 Cal. Serial # 66326232

a) Although the floorplace release is earce to use, it is burnersony when removered the stock. (i) Con't other both with safety "ON." + (1's NISEN, C) Finish makes the suffer approve "Chap." ow would you improve the consumer acceptance of this bolt ction rifle? (a) but a force present checkering pattern on it, securion to 7400. (i) Turn the burner bother some weeks (highter (it) (c) Use KK-U a structured water. Checker the bottom of text in terms of overall quality, how does this new gun compare to other center fire rifles in Remington's line? For above the 784 first cally lifty line them the 760 "Marsore," More grain water filled in (97 Here).	if it littlersome when renorms the stack. (1) Cont other both with safety "CN." + it's Noisey. (2) Finish makes the lift copyrum "Chiap." ow would you improve the consumer acceptance of this bolt ction rifle? (2) Pot a forcing pressed checkering pattern on it. similar to 7400. (1) Turn the burre down some some makes (highter lit) (C) Use KK-W a truncam water. Checker the bottom of text in terms of overall quality, how does this new gun compare of other center fire rifles in Remington's line? For others the 784 fact sallfilly him. There the 784 fact sallfilly him.	If the Ministersony when removing the Stock. In Court other both with safety "ON." + Us Notsey, C) Firstsh inches the Met's applican "Chappe" ow would you improve the consumer acceptance of this bolt ction rifle? That a forcise pressed checkering pattern on it, similar to 7400. (b) Turn the burrel bours some muse (hightn UY) (c) Use KK-U a three some make (hightn UY) (c) Use KK-U a three of overall quality, how does this new gun compare of other center fire rifles in Remington's line? For others the 784 fruit altifully him them the 700 Massic," Mora grain wat
(a) Count often both with safety "ON." + it's Notsey. (C) Finish inches the refer copywhen "Cheap." ow would you improve the consumer acceptance of this bolt ction rifle? (C) Put a forecase pressed checkering pattern on it, securion to 7400. (b) Turn the burred board some sugges (highty (it) (c) Use KK-U a threaten wathout. Whether the bottom of tere in a terms of overall quality, how does this new gun compare to other center fire rifles in Remington's line? For others the 784 four the little line. There was 100 Marson. Uters of the form of the fo	Depty ofen both with safety "ON." + It's Notsey, and Finish makes the reflection "Creap." On would you improve the consumer acceptance of this bolt ation rifle? That a forecise present checkering pattern on it, securion to 7400. (1) Turn the burrents form some makes (highter lity) (c) Use KK-W a structure water. Whether the bottom of term on terms of overall quality, how does this new gun compare of other center fire rifles in Remington's line? For others the 784 but allowers line?	C) First makes the 12th sakety "ON." + Us Notsey. C) First makes the 12th approximation "Chap." On would you improve the consumer acceptance of this bolt ation rifle? That a forecise present analysis the bursel for a forecise present (hightra (14) (c) Use KK-U a structure work (hightra (14) (c) Use KK-U a structure work to be the bottom of fore-in a terms of overall quality, how does this new gun compare to other center fire rifles in Remington's line? For above the 784 And Additional and the theory of the things of the the things of the
ow would you improve the consumer acceptance of this bolt ction rifle? That a forecise present checkering pattern on it, securion to 7400. (b) Turn the bursel boursel form some nume (highter (it) (c) Use KK-U a transcan water. Checker the bottom of term-in n terms of overall quality, how does this new gun compare to other center fire rifles in Remington's line? For whose the 788 fruit Alfallify him them the 700 Marson. Most Alfallify him.	ow would you improve the consumer acceptance of this bolt ction rifle? That a forecise present checkering pattern on it, securion to 7400. (b) Turn the burse lower some name (hightness (c) Use L'K-W of therease wellower. Whether the bottom of term of term of terms of overall quality, how does this new gun compare o other center fire rifles in Remington's line? For above the 784 but the lotter than the theory of the things t	would you improve the consumer acceptance of this bolt ction rifle? That a forcine present checkering pattern on it, similar to 7400. (b) Turn the bursel lower some muse (highter (it) (c) the LK-lV a terms of overall quality, how does this new gun compare of other center fire rifles in Remington's line? For others the 784 that callette him. Them the 700 Massic, Mora grain not
ow would you improve the consumer acceptance of this bolt ction rifle? That a forecise present checkering pattern on it, securion to 7400. (b) Turn the bursel boursel form some nume (highter (it) (c) Use KK-U a transcan water. Checker the bottom of term-in n terms of overall quality, how does this new gun compare to other center fire rifles in Remington's line? For whose the 788 fruit Alfallify him them the 700 Marson. Most Alfallify him.	ow would you improve the consumer acceptance of this bolt ction rifle? That a forecise present checkering pattern on it, securion to 7400. (b) Turn the burse lower some name (hightness (c) Use L'K-W of therease wellower. Whether the bottom of term of term of terms of overall quality, how does this new gun compare o other center fire rifles in Remington's line? For above the 784 but the lotter than the theory of the things t	would you improve the consumer acceptance of this bolt ction rifle? That a forcine present checkering pattern on it, similar to 7400. (b) Turn the bursel lower some muse (highter (it) (c) the LK-lV a terms of overall quality, how does this new gun compare of other center fire rifles in Remington's line? For others the 784 that callette him. Them the 700 Massic, Mora grain not
In it, similar to 7400. (b) Turn the burrel boursel boursel from some numer (highter lit) (c) Use KK-W a structure water. Where the bottom of text-in in terms of overall quality, how does this new gun compare to other center fire rifles in Remington's line? For above the 78% but callfully him them the 700 "Phassic," Word grain Not	then the 700 Plansic, " West 924 Med 1000 Med 10	then the 700 "Marsic," West grain Not
In it, similar to 7400. (b) Turn the burrel boursel boursel from some numer (highter lit) (c) Use KK-W a structure water. Where the bottom of text-in in terms of overall quality, how does this new gun compare to other center fire rifles in Remington's line? For above the 78% but callfully him them the 700 "Phassic," Word grain Not	then the 700 Plansic, " West 924 Med 1000 Med 10	then the 700 "Marsic," West grain Not
then the 700 "Marsic." When your Not	How the 700 Plansic, " West 92411 Not	there some negles (highter lit) (c) like KK-W a structure water the bottom of text in terms of overall quality, how does this new gun compare to other center fire rifles in Remington's line? For whose the 784 but callfully him them the 700 "Thurste," What given not
them the 700 "Placesic," Werd 924 NOT	terms of overall quality, how does this new gun compare of other center fire rifles in Remington's line? For others the 785 but called the line then the 700 "Marsic," Mora gain 1907	terms of overall quality, how does this new gun compare of other center fire rifles in Remington's line? For others the 785 that called the line them the 700 "Massic," there gives not
For obore the 785 but collecting him them the 700 "Placesic." Word gran NOT	them the 700 "Placesic." When given wer	o other center fire rifles in Remington's line? For other the 784 but calletty him them the 700 "Phassic," Word grain NOT
\ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \	,	· · · · · · · · · · · · · · · · · · ·
\ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \	,	· · · · · · · · · · · · · · · · · · ·
\ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \	,	· · · · · · · · · · · · · · · · · · ·
	filled us (OTHERY).	
iven a \$210 suggested retail price for the M/788, a \$298 price for the M/700 ADL and a \$358 price for the M/700 BDL,		
	iven a \$210 suggested retail price for the M/788, a \$298	

PAGE 2

1416 1110

6.	Do you feel the gun's design is unique?
	Yes 🗷 - Answer Q7
	No
7.	What do you think is unique about the gun you tested?
	(a) Salsty's Mose, to but (b) Continued excetion &
	(1) Kingeli Flourlate reliance (d) Front stock sine
	in concealed (1e) (these-stocked carlons
8.	The gun you tested has an 184" barrel. Would you prefer some other barrel length?
	Yes 🔀 - Answer Q9
	No Skip to Q10
9.	What barrel length would you prefer?
	Write barrel length here: 20" and would st
	y

10a. We are considering a number of stock finishes and whether to cut or press checker the gun. If the new rifle were cut checkered would you prefer a glossy or satin finish?

Glossy 🗷

Satin ___

10b. If the gun were press checkered, would you prefer a glossy or satin finish?

Glossy

B Buchwice

Satin 27

....Continued

	11.	How do you feel about the gun's weight?
		It's a little france to come but this
		weight helps in balding, vointability and
		recoil comfort.
	12.	How do you feel about the new floor-plate?
		I blu Ringed floor plates, but a flish-
		Fitting Clip may raine would be letter
		for this cartino!
	13.	How would you rate the gun you tested on the following characteristics and features?
		Very
		Excellent Good Good Fair Poor
		Contour of stock
	9	Weight
م مرازین م	المراز المشارعة عن المراز	Recoil Standing Buch
مستقمه دست مرفع		Ease of Operation
		Overall Quality
		Color of Stock
		Metal Finish
		Design of
		Checkering Pattern
	14.	To whom do you think this rilfe will appeal?
		Mountain hunters, Deep words Kunters,
		Yeaths.
		·
		Cartinus

Mationaula	· Attende	. it would	d be bet
the 7.85	ace 700:	in precise	quality
well pocit	ion feel a	unianie 700	Ü ,
, , , , , , , , , , , , , , , , , , , 	U	<i>1</i> [
	word "carbine"	-	_
Short li	inel, short	- come cul	1 Langth
forst - 15	and lines,		
	new gun was into 08 and 7mm-08 at		
M/700 ADL, wh fire rifles?	at impact would	it have on o	other Remingt
	idung caliber	c , t , ~	uld Jaka
	*	/	0
Sales and	in the training the state of th	محت النابان	
Sales aus	in tolon ADL	. <u> </u>	encircus (
Sales aus	soles. 10	e'd yet	son of
Sales aus	Scies. 12 -business	ed yet	som of
Sales aus Julius Philus 77	-busines	eid yet.	Som of
July Plus 77	sules. It	eid yet.	Som of
July Plus 77	-busines	eid yet.	Som of
Soles aus Justus" Fuger 77 Respondent	s Name: (S.)	A. Cinima	Som of
Soles aus Lu "Plus" Fuger 77 Respondent	s Name: (S.)	A. Cinima	Som of
Soles aus In Plus" Augen 77 Respondent	-busines	A. Cinima	Som of

BARBER -	PRESALE R 0128033
	PRESALE R. 0128033 TRATICE PRECLUDED BY ABILITY TO SHOOT RIPLE IN THIS TIME PLANE. REACTIONS ONLY BOLT ACTION RIFLE QUESTIONNAIRE
	O-JULY BOLT ACTION RIFLE QUESTIONNAIRE
	7mm-08 Cal. Serial \$ 3622618
	•.
1.	What do you like about the new bolt action rifle?
	THE CONCEPT - CARBINE - SHERT FAST
	HANDLING COLT ACTION RIFLE
2.	What do you dislike about this new gun?
	THE EXECUTION - THE RIFLE IS TOO HEAVY
	AND CLUBBY LOOKING - DO NOT LIKE SHEET
	METAL TRIGGER GUARD FLORPLATE - BOL TOO HEAVY
3.	How would you improve the consumer acceptance of this bolt action rifle?
	SUM DUWN BHI, BETTER SIGHTS, WHENUT STOCK,
	SLIM DIND STOCK PROFILE, DIFFERENT BOLT HANDLE.
	770 BOL FOER PLATE HISSBLY
	
4.	In terms of overall quality, how does this new gun compare to other center fire rifles in Remington's line?
	CLOSER TO 788 TITHEN 700. QUALITY OF
	EXECUTION IS SIMILAR. QUALITY OF DESILN
	IS A BIT IN LAMBO . NOT CLEHR WHETHER SUPPOSED
	TO BE CHETT M785 REPLACEMENT OR WHAT?
5.	Given a \$210 suggested retail price for the M/788, a \$298 price for the M/700 ADL and a \$358 price for the M/700 BDL, where do you think the new gun would fit in our line from a price standpoint?
	MAYBE \$250. SOMEWHERE BETWEEN 788
	+700, v7+DL,

.....Continued

BOLT	ACTION	RIFLE	CUESTIONNAIRE

					•			
6.	Do	Aon	feel	the	gun's	design	is	unique?

Yes 🖊 - Answer Q

No Skip to Q8

7-	What do	λοπ	think	is	unique	about	the	gun	you	tested?
----	---------	-----	-------	----	--------	-------	-----	-----	-----	---------

8. The gun you tested has an 184" barrel. Would you prefer some other barrel length?

9. What barrel length would you prefer?

Write barrel length here: 20" IF COULD KEEP WT SI

(AFTEK REDICTION PER OFF

10a. We are considering a number of stock finishes and whether to cut or press checker the gun. If the new rifle were cut checkered would you prefer a glossy or satin finish?

Glossy ID BELIEVE CUSTOMED WOULD PREFER SATIN,

10b. If the gun were press checkered, would you prefer a glossy or satin finish?

Glossy De WOULDNT WINT MESS CHECKERING

....Continued

.

BOLT ACTION RIFLE QUESTIONNAIRE

PAGE 3

How do you feel about	the new floo	r-olate?	?		
CHEMP LO				ندر	
WRONG PLAC					- ,
FINGEL AGA	_			•	188 -
SHOOTING				,	-
How would you rate th characteristics and f	e gun you tes eatures?	sted on t	the foli	lowing	
	Excellent	Very Good	Good	Fair	Poc
 Contour of stock				X	
Weight				•	\Rightarrow
Recoil NH					
Ease of Operation			<u> </u>		
Overall Quality				<u> </u>	
Color of Stock				<u> </u>	
Metal Finish			\overline{X}		
Design of Checkering Pattern			<u> </u>		
To whom do you think	this rilfe w	ill appe	al?		
M788 BUYEX.				<i>15</i>	<i>_</i>

.....Continued

How should we advertise the rifle you tested?
SHORT, LIGHT FAST HATUDUNG, HANDY.
COMPLEMENT TO FULL SIZE WHO DUN BIX
GRUE RIPLE. GOOD FOR WOUNTAIN AND
THOS COUNTRY HUNTING.
What does the word "carbine" mean to you?
A SHORT, LIGHT SLEWDER AND ETFICIENT
RIFLE OF HIGH QUALITY. A MORE
PERTUBLE VERSION OF MY MULIN BIS
GAME RIFLE
Assuming the new gun was introduced in 1980 in .222, .22-250, .243, 6mm, .308 and 7mm-08 at a retail price \$20 below the M/700 ADL, what impact would it have on other Remington center fire rifles?
DO NOT SEE VERY MUCH PLUS BUSINESS
IN CURLENT FORM FEAR WOULD MOSTLY
TAKE FROM 288 +700 ADL SALES. IF GUN
WITH SULL ALL THE PROTECT TO
TOO BUL WOULD PRIX OF MORE PLUS BUSINESS FROM INCOMISENT OWNERS OF THAT MODEL
FROM INCOMISENT OWNERS OF TITHE MODEL
Respondent's Name: Town Robusow
LOOKING FOR A "CARBNE"

7mm-08 Cal. Serial #<u>B(2)</u>6253

_1.	What do you like about the new bolt action rifle?
	Overall length is good: trigger and extin
	appar and feel a trong and well male.
	Cut cherkering is definite plus.
· 🗸 2 -	What do you dislike about this new gun?
	Stock dimensions and profile are
	shortand stocky - too" FAT" for carbine
	Rosal Ale zun
13.	How would you improve the consumer acceptance of this bolt action rifle?
	Modely stock fooks int like 788 with
	checkering. It to be pold in selected coliber
	as carbine the stock needs to be trimmed down.
	Horn plate in plus, but my for three who don't went to carry ex tra chys
4.	In terms of overall quality, how does this new gun compare '
	to other center fire rifles in Remington's line?
	terrel with an when appears be very close
	to M/700-if not actually the same the wood is which y
	not valuat so woodquality is not a consideration (Pachaps
	then cut heckering not necessary) On bolance comparison is foroutile
√ 5.	Given a \$210 suggested retail price for the M/788, a \$298 price for the M/700 ADL and a \$358 price for the M/700 BDL,
	where do you think the new gun would fit in our line from a
	price standpoint?
	Genera this spread, this new your would not
	fit Needs to be at a new 788.
	•

....Continued

•	:
6.	Do you feel the gun's design is unique?
•	Yes
	No 💋 - Skip to Q8
7.	What do you think is unique about the gun you tested?
8.	The gun you tested has an 181 barrel. Would you prefer some other barrel length?
	Yes
	No 🔀 - Skip to Q10
9.	What barrel length would you prefer?
	Write barrel length here:
10a.	We are considering a number of stock finishes and whether to cut or press checker the gun. If the new rifle were cut checkered would you prefer a glossy or satin finish?
	Glossy
	Satin 😂
105.	If the gun were press checkered, would you prefer a gloss or satin finish?
	Glossy 🗁

....Continued

Satin

V11.	How do you feel about	the gun's we	ight?			• •	
12.	- 1 00 0:1	to of flow from the the	extra porti	this of	niera 5. Ols 100 mg	uning of	- te
,	characteristics and fe	atures?	Very		-		
		Excellent	Good	Good	Fair	Poor	
	Contour of stock					<u>X</u>	
	Weight						
	Recoil						
	Ease of Operation		X				
	Overall Quality			X			
	Color of Stock			X			
	Metal Finish		X				
-	Omeign of Checkering Pattern			X			
114.	To whom do you think t	his rilfe wi	.11 appe	al?			
	Bulget conscion	2: Mass N	wheet	new	lel co	asumi.	
	What he "Romington	" brand to	Asles). al:	ب مه م	the gruy wh	۵
	wants a "mest" ger	n - Here.	able a	Dace	unte,	Enthu	
	all the fields of a 7	100 hype 12	whow.	$-$, $>$ 2	in qui Continú	4 Diles to	
	put a lot of lead in his can looke and neclarical probles	a Centinal a	mign	y abo	El pos	eldi i	,

How should we advertise the rifle you tested?
Containly by treet and to the attention
of the cost consciens. Remington quelity at old
Let the man merchant sell this.
What does the word "carbine" mean to you?
5.4
Alot lightweight, rapid-firing salle sun.
Auchl be able to compatably fit in scabbard.
<u> </u>
Assuming the new gun was introduced in 1980 in .222, .22-250,
.243, 6mm, .308 and 7mm-08 at a retail price \$20 below the M/700 ADL, what impact would it have on other Remington center
fire rifles?
Out bruke I don't know I think that orice is too
high It would take away no 200 ADL brainer palips
Than ald to 788 type business.
$\ell \supset \mathcal{D}$
Respondent's Name: 12 10 10 10 10 10 10 10 10 10 10 10 10 10

7mm-08 Cal. Serial # B6226275

Compac	o you like about the new bolt action rifle?
What d	o you dislike about this new gun?
Does r	not have a walnut stock.
	•
	ould you improve the consumer acceptance of this rifle?
Walnut	stock - recoil pad.
In ter	ms of overall quality, how does this new gun on conter fire rifles in Remington's line?
Carbin	ne version of Model 700 with birch stock.
	·
.	
price where	a \$210 suggested retail price for the M/788, a for the M/700 ADL and a \$358 price for the M/7 do you think the new gun would fit in our line standpoint?
Below	700 ADI.

BOLT	ACTION	DIETE	CUESTIONN	TOP
DOTI.	ACTION	RIFLE	CUESTIONN	LLL

6.	Do you feel the gun's design is unique?
	Yes XX - Answer Q7
	No
7.	What do you think is unique about the gun you tested?
	Typical carbine - Ideal pick-up truck rifle.
8.	The gun you tested has an 181 barrel. Would you prefer some other barrel length?
	Yes — Answer Q9
	No Skip to Q10
9.	What barrel length would you prefer?
	Write barrel length here:
10a.	We are considering a number of stock finishes and whether to cut or press checker the gun. If the new rifle were cut checkered would you prefer a glossy or satin finish?
	Glossy 🔀
	Satin
106.	If the gun were press checkered, would you prefer a glossy or satin finish?
	Glossy Z
	Satin

.....Continued

How do you feel about	the new floo	r-plate	?	
Excellent feature.				
		**		
How would you rate the characteristics and f	e gun you tes eatures?	ted on	the fol:	lowing
	Excellent	Very Good	Good	<u>Fair</u>
Contour of stock	X			
Weight	x			
m		<u> </u>		
Recoil				
Ease of Operation	X			
		x		
Ease of Operation		x		
Ease of Operation Overall Quality				
Ease of Operation Overall Quality Color of Stock		<u>x</u>		
Ease of Operation Overall Quality Color of Stock Metal Finish Design of	<u>X</u>	<u>x</u> <u>x</u>		

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER KINZER V. REMINGTON

....Continued

					
What d	oes the wor	rd "carbi	ne" mean	to you?	
Short	barrel.				
		·			
					
.243, M/700	6mm, .308	and $7mm-0$	8 at a re	tail pric	in .222, e \$20 below er Remingto
Will	hurt Model	788 sale	es		
					



7mm-08 Cal. Serial #<u>R 10</u>26-273

What do you like about the new	bolt action rifle?
The Ret should!	ulin auce In I Li
itaBearne itis A MA	Chuse- Sheel Wer A
herlyth- Functions of Fo	
	//
What do you dislike about this	
Bolt Should be De-	signism to the place l'une
Scar ud to have	and Auly thing - Not 1
Strak L. Hl. K. 1kg	4 Som Bereit
	,
How would you improve the consaction rifle?	sumer acceptance of this bol
Tapped the STORIE IT	CRL- ESPORALL IN TEN
Paper The Stock M	htie Sprille Caliber
Walsel Stoke	
In terms of overall quality, h	now does this new oun compar
to other center fire rifles in	Remington's line?
The with quely is	ciclity dintelle
Starra (
Given a \$210 suggested retail	
price for the M/700 ADL and a where do you think the new gur	
price standpoint?	1/1/
Literal har	DR. Art - Willithey ling
Ket med have	<u> </u>
•	•
	Continue

BOLT.	ACTION	RIFIE	OUESTIONNAIR:	F
	V-7701		へんこう エエ へいれいせてい	-

6.	Do you feel the gun	's design is unique?
	Yes	— Answer Q7
	No	Skip to Q8
7.		s unique about the gun you tested?
	Andle I tole	That this is withing on the
	,	
3.	The gun you tested some other barrel 1	has an 184" barrel. Would you prefer ength?
	Yes	— Answer Q9
	No	Skip to Q10
9.	What barrel length	would you prefer?
	Write barrel	length here:
10a.	to cut or press che	a number of stock finishes and whether ecker the gun. If the new rifle were you prefer a glossy or satin finish?
	Glossy	
	Satin	
10b.	If the gun were proor satin finish?	ess checkered, would you prefer a gloss
	Glossy	
	Satin	
	٠	Continued

ţ

BOLT ACTION RIFLE QUESTIONNAIRE

	t the new floo	or-plate?	•		
Thike it -	- Exst was	to us	LAD.	plus	<u>-</u>
Atestua A Os	chine does	cot	Unx	cella !	Ale
					-
How would you rate t	the gun you te	sted on t	he fol	lowing	
characteristics and				•	
	Excellent	Very Good	Good	Fair	Poc
Contour of stock		EVEOR		14120	
Weight			X		
Recoil			<u> Y</u>		
Ease of Operation	***************************************	X			
Overall Quality					
Color of Stock			<u>\</u>		
	<u> </u>				
Metal Finish		<			
Metal Finish Design of Checkering Pattern					
Design of	this rilfe w				

....Continued

What does the word "c	carbine* mean to you?	الکر-
P. Alexot. Top G	in youth + (a head)	Pen
.243, 6mm, .308 and 7 M/700 ADL, what impac	was introduced in 1980 in .2: nm-08 at a retail price \$20 ket would it have on other Remark	elow tington
It walk he	J. K. 188- 4 H.	7001
·	[[]	
	1// /////	

LAW J.H.C

BOLT ACTION RIFLE QUESTIONNAIRE

7mm-08 Cal. Serial # B6226249

What do you dislike about this new gun? The finish is too light. The muzzle blast in the 7 is extremely strong. The safety is too small. The rifle is too heavy for a carbine. How would you improve the consumer acceptance of the action rifle? I would darken the finish, make the safety larger 1 one on the Model 788 and remove the sights. In terms of overall quality, how does this new gun to other center fire rifles in Remington's line? I do not think the cosmetic appearance of this rifle compare with the Model 700 and the Model 788. I wo much prefer the Model 788 for the additional money Given a \$210 suggested retail price for the M/788, price for the M/700 ADL and a \$358 price for the M/788, price for the M/700 ADL and a \$358 price for the M/788, price standpoint? \$224.95		
The finish is too light. The muzzle blast in the 7 is extremely strong. The safety is too small. The rifle is too heavy for a carbine. How would you improve the consumer acceptance of the action rifle? I would darken the finish, make the safety larger 1 one on the Model 788 and remove the sights. In terms of overall quality, how does this new gun to other center fire rifles in Remington's line? I do not think the cosmetic appearance of this rifle compare with the Model 700 and the Model 788. I wo much prefer the Model 788 for the additional money Given a \$210 suggested retail price for the M/788, price for the M/700 ADL and a \$358 price for the M/788, price for the M/700 ADL and a \$358 price for the M/788, price standpoint?	What	do you dislike about this new gun?
is extremely strong. The safety is too small. The rifle is too heavy for a carbine. How would you improve the consumer acceptance of thi action rifle? I would darken the finish, make the safety larger 1 one on the Model 783 and remove the sights. In terms of overall quality, how does this new gun to other center fire rifles in Remington's line? I do not think the cosmetic appearance of this riff compare with the Model 700 and the Model 788. I wo much prefer the Model 788 for the additional money Given a \$210 suggested retail price for the M/788, price for the M/700 ADL and a \$358 price for the M/788, price for the M/700 ADL and a \$358 price for the M/788 price standpoint?		-
How would you improve the consumer acceptance of this action rifle? I would darken the finish, make the safety larger 1 one on the Model 783 and remove the sights. In terms of overall quality, how does this new gun to other center fire rifles in Remington's line? I do not think the cosmetic appearance of this riff compare with the Model 700 and the Model 788. I wo much prefer the Model 788 for the additional money Given a \$210 suggested retail price for the M/788, price for the M/700 ADL and a \$358 price for the M/788 where do you think the new gun would fit in our line price standpoint?		
I would darken the finish, make the safety larger 1 one on the Model 788 and remove the sights. In terms of overall quality, how does this new gun to other center fire rifles in Remington's line? I do not think the cosmetic appearance of this riff compare with the Model 700 and the Model 788. I wo much prefer the Model 788 for the additional money Given a \$210 suggested retail price for the M/788, price for the M/700 ADL and a \$358 price for the M/788 where do you think the new gun would fit in our line price standpoint?	The r	ifle is too heavy for a carbine.
one on the Model 788 and remove the sights. In terms of overall quality, how does this new gun of to other center fire rifles in Remington's line? I do not think the cosmetic appearance of this riff compare with the Model 700 and the Model 788. I wo much prefer the Model 788 for the additional money Given a \$210 suggested retail price for the M/788, price for the M/700 ADL and a \$358 price for the M/7 where do you think the new gun would fit in our line price standpoint?	actio	on rifle?
In terms of overall quality, how does this new gun of to other center fire rifles in Remington's line? I do not think the cosmetic appearance of this riff compare with the Model 700 and the Model 788. I wo much prefer the Model 788 for the additional money Given a \$210 suggested retail price for the M/788, price for the M/700 ADL and a \$358 price for the M/7 where do you think the new gun would fit in our line price standpoint?	I wou	ald darken the finish, make the safety larger li
I do not think the cosmetic appearance of this riff compare with the Model 700 and the Model 788. I wo much prefer the Model 788 for the additional money Given a \$210 suggested retail price for the M/788, price for the M/700 ADL and a \$358 price for the M/7 where do you think the new gun would fit in our line price standpoint?	one o	on the Model 788 and remove the sights.
much prefer the Model 788 for the additional money Given a \$210 suggested retail price for the M/788, price for the M/700 ADL and a \$358 price for the M/ where do you think the new gun would fit in our line price standpoint?	I do	ther center fire rifles in Remington's line? not think the cosmetic appearance of this rifle
Given a \$210 suggested retail price for the M/788, price for the M/700 ADL and a \$358 price for the M/where do you think the new gun would fit in our line price standpoint?		
price for the M/700 ADL and a \$358 price for the M/7 where do you think the new gun would fit in our line price standpoint?	- Indeli	preser the moder , or for the durational model.
\$274.95		a S210 suggested retail price for the M/788. a
	price where	for the M/700 ADL and a \$358 price for the M/7 do you think the new gun would fit in our line

BOLT ACTION RIFLE QUESTIONNAIRE

6.	Do you feel the gun's design is unique?
0.	
	Yes
	No
7.	What do you think is unique about the gun you tested?
8.	The gun you tested has an 184" barrel. Would you prefer some other barrel length?
	Yes — Answer. Q9
	No Ø - Skip to Q10
9.	What barrel length would you prefer?
	Write bafrel length here:
10a.	We are considering a number of stock finishes and whether to cut or press checker the gun. If the new rifle were cut checkered would you prefer a glossy or satin finish?
	Glossy ZZ
	Satin
105.	If the gun were press checkered, would you prefer a gloss or satin finish?
	Glossy 🗷
	Satin
	Continued

PAGE 3

11.	How do you feel about the gun's weight?				
	It is too heavy for a short barrel rifle. My sample				
	weighed approximately 84 lbs., which is too heavy a gun				
	of this design.				

- 12. How do you feel about the new floor-plate?

 The new floor plate is good. It could be of thicker material.

 I think that we could use the same type of floor plate we are using in our Model 700s.
- 13. How would you rate the gun you tested on the following characteristics and features?

	Excellent	Very Good	Good	<u>Fair</u>	Poor
Contour of stock					
Weight					X
Recoil					*
Ease of Operation	-		1		
Overall Quality	·		X		
Color of Stock					X
Metal Finish			X		
Design of Checkering Pattern	-		x		

I feel that this rifle would appeal to the beginner hunter or shooter. I do not believe a real avid rifleman would be in the market for this gun. He would go with the Model 700.

.....Continued

BOLT ACTION RIFLE QUESTIONNAIRE

	in the	4-H and	Future	Farmer	magazir	nes. I	wou
to the	beginni	ng shoo	ter and	hunter			
What d	oes the	word "c	arbine"	mean to	you?		
I fee	that a	carbine	is a f	ast swi	nging,li	ight we	ight
short	barrel n	tifle, c	ne that	can be	carried	i for a	gre
lengti	of time	throug	h the b	rush.	'		
.243, M/700	ng the n 6mm, .30 ADL, wha ifles?	8 and 7	mm-08 a	t a reta	il pric	e \$20 t	elow
fire :				•			

W. L. Flenn

Respondent's Name:

BOLT ACTION RIFLE QUESTIONNAIRE

7mm-08 Cal. Serial #<u>B622</u>6270

	do you dislike about this new gun?
Stock	finish, type of wood, sparse checkering on for
trigg	er guard and floor plate.
	ould you improve the consumer acceptance of this n rifle?
Valnu-	trstock, improved fore-end checkering as class
BDL,	700 BDL trigger guard.
In te	rms of overall quality, how does this new gun coher center fire rifles in Remington's line?
to ot	her center fire rifles in Remington's line?
only	her center fire rifles in Remington's line?
only	slightly above 788; not up to 700 standards.
only	her center fire rifles in Remington's line? slightly above 788; not up to 700 standards.
Only a "78 Given price where	her center fire rifles in Remington's line? slightly above 788; not up to 700 standards.

BOLT ACTION RIFLE QUESTIONNAIRE

6.	Do you feel the gun's design is unique?
٥.	
	Yes — Answer Q7
	No Z7 - Skip to Q8
7.	What do you think is unique about the gun you tested?
8.	The gun you tested has an 185 barrel. Would you prefer some other barrel length?
	Yes — Answer Q9
	No Skip to Q10
9.	What barrel length would you prefer?
	Write barrel length here:
10a.	We are considering a number of stock finishes and whether to cut or press checker the gun. If the new rifle were cut checkered would you prefer a glossy or satin finish?
	Glossy 🗷
	Satin
106.	If the gun were press checkered, would you prefer a glossy or satin finish?
	Glossy 🗷
	Satin
	Conhinue

11.	How do you feel abou	it the gun's we	ight?		
	Test rifle weighed	61bs. on UPS	scale. 78	8 (overal	1 2"
	longer stock) weigh	hed 61 lbs. W	eight okay	r - helps	<u>han</u> dle
	recoil.	· · · · · · · · · · · · · · · · · · ·			
12.	How do you feel abou	it the new floo	r-plate?		
	A strong dislike for	or mesthetics.	"Tinny loc	ok" as wit	:h 541 -
	complaints would be	e heard in thi	s area. S	Suggest a	700 BDL
	type trigger quard	- floor plate	*		
13.	How would you rate to characteristics and		ted on the	≅ followin	g
		Excellent	Very Good	Good Fai	r Poor
	Contour of stock	-		х	
	Weight			<u>x</u> _	
	Recoil		x		
	Ease of Operation	-		<u> </u>	*
	Overall Quality	- Charleston - Cha	<i>.</i>	<u>x</u>	
	Color of Stock	*			<u> x</u>
	Metal Finish	-	<u> </u>		
	Design of Checkering Pattern			<u>x</u>	
* Bolt st safety 14.	cicky, major difficult too loud for hunting To whom do you think	ies with ease rifle. this rilfe wi	of operat	ion of sat	fety and
	Very narrow group	as tested. No	economy,	no luxury	. Only
	slightly better th	an 788 and not	to 700 s	tandards.	
	41 <u></u>				

....Continued

	ength of action, ability to scope, quick and easy
<u>har</u>	dling and a "purist's carbine".
What	does the word "carbine" mean to you?
Sho	ort, brush-type rifle. Light and quick handling.
	
.243 M/70	ming the new gun was introduced in 1980 in .222, . 8, 6mm, .308 and $7mm-08$ at a retail price \$20 below 00 ADL, what impact would it have on other Remington rifles?
	ome reduction of 700 ADL sales.

Respondent's Name: Name: 1. 1. Wash &

7mm-08 Cal. Serial # <u>B6226</u>248

	do you like about the new bolt action rifle?
GOO	d looking, quality qun, strong action.
Liv	es up to "Remington Quality"
What o	do you dislike about this new gun?
Rea	r sightdifficult to move. Ejection
was	not smoothshell remained in bolt head 1/2
How we	ould you improve the consumer acceptance of the n rifle?
Tuc	k bolt in more and thin down stock and
rem	nove floor plate
To tak	rms of overall quality, how does this new gun
to ot	her center fire rifles in Remington's line?
	It compares very well
price where	a \$210 suggested retail price for the M/788, for the M/700 ADL and a \$358 price for the M/do you think the new gun would fit in our linestandpoint?
	If possible, gun should be \$20 to \$30 less

BOLT ACTION RIFLE QUESTIONNAIRE

6.	Do you feel the gun's design is unique?
	Yes Answer Q7
	No ZZ - Skip to Q8
7.	What do you think is unique about the gun you tested?
•	
8.	The gun you tested has an 184" barrel. Would you prefer some other barrel length?
	Yes
	No ZZ - Skip to Q10
9.	What barrel length would you prefer?
	Write barrel length here:
10a.	We are considering a number of stock finishes and whether to cut or press checker the gun. If the new rifle were cut checkered would you prefer a glossy or satin finish?
	Glossy 🔀
	Satin
10b.	If the gun were press checkered, would you prefer a glossy or satin finish?
	Glossy 💯
	Satin
	•
	Continued

BOLT ACTION RIFLE QUESTIONNAIRE

		-9 - k - 6	_	
How do you feel abou Should not have		_		
SHOULD HOU HAVE	4 ITOOL Place	011 & 00		
		,		
				
How would you rate t characteristics and		ted on (the fol:	lowing
		Very		
	Excellent	Good	Good	Fair
Contour of stock		·	<u> </u>	
Weight			<u>x</u>	
Recoil			<u> </u>	·
Ease of Operation				
Overall Quality		<u> </u>		
Color of Stock				<u> x</u>
Metal Finish	X			
Design of Checkering Pattern		<u>x</u>		
To whom do you think	this rilfe wi	.11 appe	al?	
			ck up t	

_	Quality, strength, low cost, accuracythese
_	should be included in advertising
	nat does the word "carbine" mean to you?
	Carbine means a short light-weight gun.
M	ssuming the new gun was introduced in 1980 in .222, .2 243, 6mm, .308 and 7mm-08 at a retail price \$20 below /700 ADL, what impact would it have on other Remington ire rifles?
_	This model, with prices indicated above, would take
_	sales from our 700 ADL
_	

7mm-08 Cal. Serial #____

What d	o you dislike about this new gun?
	- Jod disting about mits new year.
	
How wo action	uld you improve the consumer acceptance of thi rifle?
	Juper Liction
	Improve Suction
In ter	ms of overall quality, how does this new gun car center fire rifles in Remington's line?
	
	
Given	a \$210 suggested retail price for the M/788, a
brice	for the M/700 ADL and a \$358 price for the M/7 do you think the new gun would fit in our line

PAGE 2

	•
6.	Do you feel the gun's design is unique?
	Yes Answer Q7
	No Z - Skip to Q8
7.	What do you think is unique about the gun you tested?
8.	The gun you tested has an 18½" barrel. Would you prefer some other barrel length?
	Yes — Answer Q9 No — Skip to Q10
9.	What barrel length would you prefer?
	Write barrel length here:
.0a.	We are considering a number of stock finishes and whether to cut or press checker the gun. If the new rifle were cut checkered would you prefer a glossy or satin finish?
	Glossy 🗹
	Satin
LOb.	If the gun were press checkered, would you prefer a gloss or satin finish?
	Glossy S
	Satin

....Continued

WOM GO AOU TEST SPORE	the gun's we			
How do you feel about	the new floo	r-plate?	?	
	OK	,		
characteristics and f	Excellent	Very Good	Good	Fair
Contour of stock	<u> </u>	2000	<u>3000</u>	
		-		
Weight				/
Weight Recoil				<u>~</u>
_				<u>/</u>
Recoil				<u> </u>
Recoil Ease of Operation				<u>\(\) \(\)</u>
Recoil Ease of Operation Overall Quality				<u>/</u>
Recoil Ease of Operation Overall Quality Color of Stock				\(\frac{1}{2} \)
Recoil Ease of Operation Overall Quality Color of Stock Metal Finish Design of	this rilfe wi	——————————————————————————————————————		<u> </u>

.....Continued

ACTION RIFLE QUESTIONNAIRE	PAGE 4
How should we advertise the rifle	e you tested?
What does the word "carbine" mean	n to you?
Saddle gus	1/
Assuming the new gun was introduction. 243, 6mm, .308 and 7mm-08 at a M/700 ADL, what impact would it fire rifles?	retail price \$20 below th
(\mathcal{M})	

7mm-08 Cal. Serial #B6226236

	1 1 2 2 2 2 2 2 2 3 2 4 4 4 7 4 4 4 4 4 4 4 4 4 4 4 4 4 4 4
	action appears to be a good solid "M/700 type". It
is a	quality piece and will convey value to the potentia
cust	omer.
What	do you dislike about this new gun?
The	stained Birch stock is completely not acceptable.
This	is compounded by the cut checkering on the Birchwo
The	stock dimensions and design are not consistent with
inte	ended purpose, nor for the bolt handle. Both need r the attached memo.
BOW W	yould you improve the consumer acceptance of this bol
	the memo attached.
366	the memo accached.
In te	erms of overall quality, how does this new gun compar wher center fire rifles in Remington's line?
to of	wer senter rich ciries in Kemination's line?
	general'- very well.
	general'- very well.
In (general'- very well.
In o	general'- very well. a \$210 suggested retail price for the M/788, a \$298 a for the M/700 ADL and a \$358 price for the M/700 BD
In of	general - very well. a \$210 suggested retail price for the M/788, a \$298 a for the M/700 ADL and a \$358 price for the M/700 BD
Giver price where	general'- very well. n a \$210 suggested retail price for the M/788, a \$298 e for the M/700 ADL and a \$358 price for the M/700 BD e do you think the new gun would fit in our line from e standpoint?
Giver price where price	general - very well. a \$210 suggested retail price for the M/788, a \$298 a for the M/700 ADL and a \$358 price for the M/700 BD a do you think the new gun would fit in our line from

BOLT ACTION RIFLE QUESTIONNAIRE

6.	Do you feel the gun's design is unique?
	Yes — Answer Q7
	No ZZ - Skip to Q8
7.	What do you think is unique about the gun you tested?
8.	The gun you tested has an 184" barrel. Would you prefer some other barrel length?
	Yes Answer Q9
	No ZZ - Skip to Q10 See the attached memo.
9.	What barrel length would you prefer? Same as #8 above.
	Write barrel length here:
10a.	We are considering a number of stock finishes and whether to cut or press checker the gun. If the new rifle were cut checkered would you prefer a glossy or satin finish?
	Glossy 😾
	Satin
106.	If the gun were press checkered, would you prefer a glossy or satin finish?
	Glossy 🔀
	Satin

....Continued

How do you feel about the new floor-plate? Unnecessary and inappropriate on a carbine. How would you rate the gun you tested on the fol characteristics and features? Very Good Good Contour of stock Weight Recoil Ease of Operation Overall Quality	essary and inappropriate on a carbine. Ild you rate the gun you tested on the following teristics and features? Very Excellent Good Good Fair
Contour of stock Weight Recoil Ease of Operation	eristics and features? Very Excellent Good Good Fai
Contour of stock Weight Recoil Ease of Operation	eristics and features? Very Excellent Good Good Fai
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Weight Recoil Lase of Operation	· · of stock
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Ease of Operation	<u> </u>
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	Quality X
Color of Stock	of Stock
Metal Finish	
Design of Checkering Pattern	
Metal Finish Design of	

....Continued

PAGE 4

BOLT ACTION RIFLE QUESTIONNAIRE

With cost stressing va	alue, quality and position
specifically toward the	e potential carbine user.
What does the word "car	thine" mean to you?
Short, light, flat and	d suitable for use with a sadd
scabbard.	
	s introduced in 1980 in .222,
.243, 6mm, .308 and 7mm	-08 at a retail price \$20 below
.243, 6mm, .308 and 7mm M/700 ADL, what impact fire rifles?	n-08 at a retail price \$20 below would it have on other Remingto
.243, 6mm, .308 and 7mm M/700 ADL, what impact fire rifles? In a good market suc	as introduced in 1980 in .222, 1-08 at a retail price \$20 below would it have on other Remington the an introduction should not have all effect on the sales of other
.243, 6mm, .308 and 7mm M/700 ADL, what impact fire rifles? In a good market suc	n-08 at a retail price \$20 below would it have on other Remington han introduction should not have all effect on the sales of other
.243, 6mm, .308 and 7mm M/700 ADL, what impact fire rifles? In a good market suc significant detriment	n-08 at a retail price \$20 below would it have on other Remington han introduction should not have all effect on the sales of other
.243, 6mm, .308 and 7mm M/700 ADL, what impact fire rifles? In a good market suc significant detriment	n-08 at a retail price \$20 below would it have on other Remington han introduction should not have all effect on the sales of other

7mm-08 Cal. Serial # <u>B6226251</u>

1.	What do you like about the new bolt action rifle?
	Gun looks like a quality our. Very handy
	to carry Represents in excellent 2 elice (dysonding
	on price in summary & like the sun, Like
į.	RKW Style finish at checkering
2.	What do you dislike about this new gun?
	Recail was very high-sun bent to die.
•	Trigger pull was too still signt (iten)
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á	were difficult to adjust and had to be adjusted to extreme left loor plate release was too being, might be released when greene
3.	How would you improve the consumer acceptance of this bolt
	action rifle?
	Onprive sights inquive trager pull
	·
4.	In terms of overall quality, how does this new gun compare to other center fire rifles in Remington's line?
_ 1	Very clon if not superior to ADL Checking is big plus
Cut	Cheikens is bug plus
	, , ,
-	Given a COIO avenue had websil maior for the MMCO door
5.	Given a \$210 suggested retail price for the M/788, a \$298 price for the M/700 ADL and a \$358 price for the M/700 BDL,
	where do you think the new gun would fit in our line from a price standpoint?
	\$275-300
	Continued

Do you feel the gun's design is unique?
Yes — Answer Q7
No
What do you think is unique about the gun you tested? Oun has 700 quality in but return courling
· .
The gun you tested has an 18½" barrel. Would you prefer some other barrel length?
Yes — Answer Q9
Yes — Answer Q9 No — Skip to Q10
What barrel length would you prefer?
Write barrel length here:
We are considering a number of stock finishes and whether to cut or press checker the gun. If the new rifle were cut checkered would you prefer a glossy or satin finish?
Glossy 📐
Satin
If the gun were press checkered, would you prefer a glossy or satin finish?
Glossy
Satin
•
Continued

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PAGE 4

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Recomment raniments as souther aswell. I believe to import will be minimal

.243, 6mm, .308 and 7mm-08 at a retail price \$20 below the M/700 ADL, what impact would it have on other Remington center

Respondent's Name: OC Collabora

7mm-08 Cal. Serial # 86226 225

	o you dislike about this new gun?
	e autin des lance
	uld you improve the consumer acceptance of trifle?
(the	ling walnut took, cotin his
Ston	ling walnut stock, with his
	ms of overall quality, how does this new gur er center fire rifles in Remington's line?
1/.0	u twosfle

....Continued

PAGE 2

6.	Do you feel the gun's design is unique?
	Yes — Answer Q7
	No 🗷 - Skip to Q8
7.	What do you think is unique about the gum you tested?
8.	The gun you tested has an 184" barrel. Would you prefer some other barrel length?
	Yes — Answer Q9
	No 🗵 - Skip to Q10
9.	What barrel length would you prefer?
	Write barrel length here:
10a.	We are considering a number of stock finishes and whether to cut or press checker the gun. If the new rifle were cut checkered would you prefer a glossy or satin finish?
	Glossy 🔼
	Satin 💆
106.	If the gun were press checkered, would you prefer a gloss or satin finish?
	Glossy 🔼
	Satin 🗵

.....Continued

1-1 1		r-plate?		
Lile it!				
How would you rate the characteristics and		ted on	the foli	lowing
	Excellent	Very Good	Good	Fair
Contour of stock		X		
Weight	-	-		\angle
Recoil				
Ease of Operation		X		
Overall Quality		X		
Color of Stock		*******	Y	
Metal Finish			X	
Design of Checkering Pattern		X		

....Continued

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.243, 6mm,	e new gun was .308 and 7mm-0 what impact wo	8 at a retail	price \$20 bel	Low
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EYHIBIT 34

REMINGTON ARMS COMPANY, INC.

INTER-OFFARTMENTAL CORRESPONDENCE

Remington.

RD-49-4

PETERS

Xc: C.B. Workhand P.H. Holmberg ごく 3 -

D.E. Bullis

"CONFINE YOUR LETTER TO ONE SUBJECT ONLY"_

Ilion, New York October 28, 1980

TO:

W. H. FORSON

FROM:

J. W. BROOKS 4 7.1e

BOLT ACTION CARBINE

We have gone over the field test results you sent to us last week and from further discussion with you and Faul on the subject we are proceeding with a new rifle design with the following changes:

- 1. New lighter barrel that will be approx. 12 oz. lighter than on field test models.
- Thinner and shorter walnut stock that will be approx. an ounce lighter than present walnut sample.
- Increase release latch spring force and/or reduce length of latch.

The weight of the finished rifle in 7mm-08 caliber will be approximately 6% pounds. All other features will remain as indicated on our letter of May 8, 1979, or as on the field test models. The weight of the rifle will change approximately 2.5 oz. from 308 to 222 caliber.

We have checked other items that could help reduce the overall weight. We will not proceed with any of these items unless you are interested.

- 1. New design floor plate assembly using aluminum, similar to M700 BDL type. Save approximately .84 oz.
- Receiver remove material from ejection port. Save approx. .3 oz.
- 3. Model 788 rear sight in place of Model 700 rear sight, Save approx. .38 oz.
- 4. New design forged bolt handle similar to Model 600. Save approx. .48 oz.

If you have any further thoughts or information, please call.

JWB:T

Firearms Research Division

EXHIBIT 35

20-49-E

REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE

Xc: C.B. Workman

P.H. Holmberg

D.E. Bullis

Remington.

PETERS

"CONFINE YOUR LETTER TO ONE SUBJECT ONLY"_

Ilion, New York November 3, 1980

Tile

TO:

W. H. FORSON

FROM:

J. W. BROOKS

SUBJECT:

BOLT ACTION CARBINE REQUIREMENTS

As a followup to my letter of October 28th, on the above subject, we are proceeding with the attached list of requirements for the bolt action carbine.

If you have any additions or changes, we would appreciate information from you as soon as possible.

JWB:T Attach.

Firearms Research Division

10-30-80 J.W.Brooks:T

BOLT ACTION CARBINE Model Requirements

- 1. Stock Walnut wood average weight decrease of walnut over birch approx. 3½ oz. Making stock shorter and thinner than present field test sample will decrease weight approx. I oz. RK-W glossy finish and pressed checkering using pattern on field test models. M600 butt plate.
- 2. Barrel Proposed .100 smaller OD than present M700. Approx. 12 oz. decrease over field test models, pending satisfactory performance.
- 3. Receiver Like M600 but with longer tang like present field test models.
- 4. Model 600 bolt assembly with a Model 700 bolt handle. Bolt body altered to work with bolt lock.
- New bolt plug with new bolt lock.
- 6. Model 700 barrel bracket.
- 7. Model 700 trigger assembly with new bolt stop release and reshaped M700 safety arm.
- 8. Model 600 bolt stop.
- 9. Model 700 BDL magazine.
- 10. Model 600 Follower and spring.
- 11. New trigger guard and floor plate assembly as used on field test rifles. Release latch will be made shorter and/or release latch spring stronger.

Bolt Action Carbine - Model Requirements 10-30-80

- 12. New rear trigger guard screw.

 Model 700 BDL front guard screw.
- 13. Model 700 rear sight base and sight. (New or alter to fit new barrel contour.)
- 14. Model 700 front sight base and sight. (New or alter to fit new barrel contour.)
- 15. Sling swivel studs.

JWB:T

EXHIBIT 36

REMINGTON ARMS COMPANY, INC. Fireards Research Division

January 5, 1981

Xc: J.W.Brooks
D.E.Bullis

= 132

TO:

J. R. SNEDEKER

FROM:

C. J. MILLER - R. E. NIGHTINGALE

SUBJECT:

MODEL 700 CARBINE

Work Order:

C 1856

30,06 :2.

INTRODUCTION

Four Model 700s with undersized and shortened barrels were supplied to the Measurements Lab for strength evaluation.

SYNOPSIS

The two Model 700s tested passed our most severe strength tests.

PROCEDURE

The two Model 700s with barrels undersized on the outside diameter by .120" and shortened by 4 inches were chosen for testing. The .100" O.D. undersized barrels were not tested.

The first rifle (\$B6261719) had a strain gage applied to the barrel for pressure measurements. Five proof rounds were fired and the barrel's O.D. was measured at one inch intervals starting at the muzzle. Then a super proof load (52.4 gr. of IMR 4198 and a 220 gr. bullet) was fired.

The second 700 Carbine (#86261940) was proof tested. Then four 220 grain bullets were forced into the barrel and a super proof load was fired.

RESULTS

There was no measurable or visual damage to either barrel. The stocks were broken due to gases escaping through or by the bolt.

The peak pressures measured by strain gage technique on B6261719 with super proof was 192,000 PSI-Strain.

The peak pressure on rifle #B6261940 with super proof and 4 bullets estimated (from other 700 testing) to be 400,000 PSI-Strain.

CJM:REN:T Research Measurements Lab

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8"	.568	1.568	1.563	.558	568	568	:568
91//	.598	577	. 578	5981	2798	598	598
10"	.625	626	. 6 25	625	625	.626	1625
// "	.655	1855	.455	1655	655	1551	.655
12"	685	1.685	1685	.689	585	325	.685
13."	.718	1.7/8	718	7/8	17/3	-777	77/2
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BARBER - PRESALE R 0128083

CHAMBER STRAIN TO P.S.I.

IODEL: 700 Corbins	SERIAL No.: <u>8625/940</u>
CALIBER: 30-06	DATE: 12-11-80
GAUGE: =4-04-125BT	
DISTANCE FROM BOLT FACE:	
INSIDE DIA: . 34/	
OUTSIDE DIA : 1.029	\
PRESSURE = Strain x $\left(\frac{E}{2} \times \left(\frac{Ro^2}{Ri^2} - 1\right)\right)$ = Strain	x (121.58) PSI/Winlin)
DEFERENCE AMMO.	

	Uin / in	P.S.I.
Ren 180,1		52,000
Saami WOX14		60,000
Saam VEW14		50,000
Proof4		38,000
5		
Avg.	,	

Super proof + 4x200gr Gillets

Estimated 400,000 PSI- STRAIN

BARBER - PRESALE R 0128084

CHAMBER STRAIN TO P.S.I.

MODEL: 700 Carbina	SERIAL No.: 35251719
CALIBER: 30-06	DATE: 12-11-80
GAUGE: <u>= 4-06-125-B7</u>	
DISTANCE FROM BOLT FACE: 2.3"	
INSIDE DIA: .34/	
OUTSIDE DIA : 1.030	•
PRESSURE = Strain x $\left(\frac{E}{x}\left(\frac{Ro^2}{a^2}-1\right)\right)$ = Strain	x (121.85) PSI/Vinha

•			
		Uin / in	P.S.I.
Proof	1		84,700
Proof	2		84,700
Proof	3		83,400
Proof	4		89,100

Super Proof
524gr IMA4198-2294 Lild
50,000 PSI-Strain Div
2 MSec Div.

5

Avg.

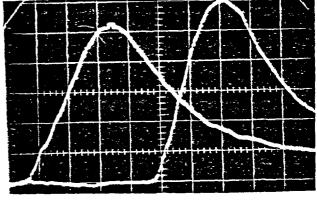
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Model 700 Carbine Chamber Pressure PSI-STRAIN 12-31-80 B526/940

Aan 180g-

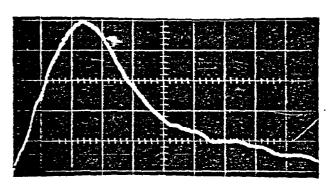
Saani 180g-10,000 PSI-STANI/Dis.



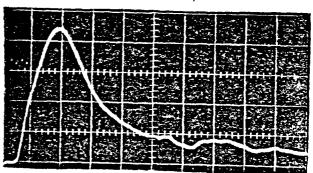
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Soami 180z-10,000 PSI-BTRAIN/AS

Rem Proof 20,000 PSI-STAAN DIN



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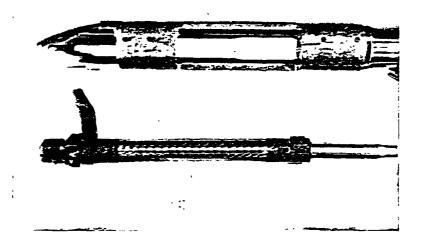


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Model 700 Carbine

B6261719

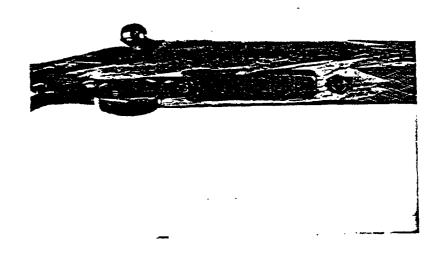
Super Proof

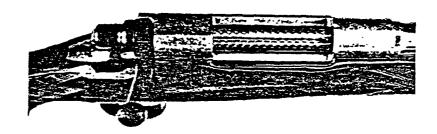


Model 700 Carbine

B6251970

Super Proof + 4x222 pr Ballats





BARBERN PRESALE R.0128088 NY, INC. Ilion Research Division

SUMMARY OF INTENTIONAL GUN ABUSE TEST

	34	
·	DATA	BY RENTICOM
		Data 12-11-80
<u>FIREARM</u> :	Make PENINGTON PARTINE	Model 700
J.	Grade Gauge 34/06	Serial Number 26261940
•	Origin Exp	
	Test Number Assigned C/856 Comments Juan Prof.) E Voca	: ./20.)
	· · · · · · · · · · · · · · · · · · ·	
HISTORY:	Condition NEW	
	Previous Rounds Fired 1 Fr. To. 2 - 1	PROST
	Headspace at Test Min - 004	
•	Test Date 12-11.36	
ABUSIVE	Powder Type	
LCAD USED:	Powder Weight 53,441.	
,	Case Make and Type Temmerau	PZHEL
	Total Bullet Weight 1100 \$1.	
•	Total Shot Weight	
,	Estimated Pressure	
•		•
ADDITIONAL COMMENTS:		
		

BARBER - PRESALE R 0128089
REMINGTON ARMS COMPANY, INC. Ilion Research Division

SUMMARY OF INTENTIONAL GUN ABUSE TEST

•	DATA By Co N
·	Date 1211-90
eretet.	Make Ram. Carone 18" BRL Model 200
<u>FIREARM</u> :	
-	Grade Gauge <u>30/06</u> Serial Number <u>86.261719</u>
•	Origin_E-KP.
	Test Number Assigned C/256
	Comments
FISTORY:	Condition <u>NEW</u>
	Previous Rounds Fired 2 FACTORY _ 5 PROOF
	Headspace at Test www. toaz
	Test Date
ABUSIVE	Powder Type 4198
LOAD USED:	Powder Weight
,	Case Make and Type REMINSTON PRINTED
•	Total Bullet Weight 220 27.
•	Total Shot Weight
	Estimated Pressure 200,000 . Via STZain 799 E
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ADDITIONAL	
	FOTION FROZEN. PIPE WRENCH HAMEZ
	REQUIRED TO OPEN. BOT HEAD DANAGED
	NO MAJOR DAMAGE TO GUN
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RD-40 REV. 4-58

REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE

Remington.

EXHIBIT 38

cc: J. P. Glas

J. E. Preiser

= 73

P. H. Holmberg

J. P. Linde

G. D. Campbell

Bridgeport, Connecticut March 11, 1981

TO:

J. W. BROOKS

FROM:

W. H. FORSON, JR.

SUBJECT:

BOLT ACTION CARBINE - REVISED MODEL REQUIREMENTS

We reviewed a prototype bolt action carbine last week. Please make the following revisions to finalize the design requirements.

- Walnut stock to be slimmed down in grip and fore-end areas.
- Grip cap installed Model 870 TC or similar.
- · Classic type rifle butt pad.

WHF: daf

EXHIBIT 39

EV3?

REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE

Xc: C.B. Workman P.H. Holmberg

D.E. Bullis

Remington

R 0-44-4

PETERS

"CONFINE YOUR LETTER TO ONE SUBJECT ONLY"_

Ilion, New York March 23, 1981

TO:

W. H. FORSON

FROM:

J. W. BROOKS

SUBJECT:

BOLT ACTION CARBINE MODEL REQUIREMENTS

Per your letter of March II we have changed the model requirements for the Bolt Action Carbine as follows:

Stock

- 1. Walnut wood
- 2. RK-W glossy finish
- 3. M700 Classic butt pad
- 4. Swivel studs
- 5. Grip cap (similar to Model 870 TC)
- 6. Cut checkering
- 7. Shape of butt stock similar to sample reviewed in March. Grip similar to Model 7 sample. Fore End similar to schnabel but with tip rounded off.

Barreled Action

- 1. Barrel contour similar to M700 but approx. .100" smaller.
- 2. M700 rear sight assembly.
- M700 front sight base with bottom radius to fit smaller barrel.
- 4. M700 front sight
- 5. M700 barrel bracket
- 6. M600 receiver with longer tang
- M600 bolt stop with M700 type release
- 8. M700 trigger assembly with 2 position safety

BARBER - PRESALE R 0128094

To:

W.H.Forson

From:

J.W.Brooks

Subject: Bolt Action Carbine Model Requirements

3-23-81

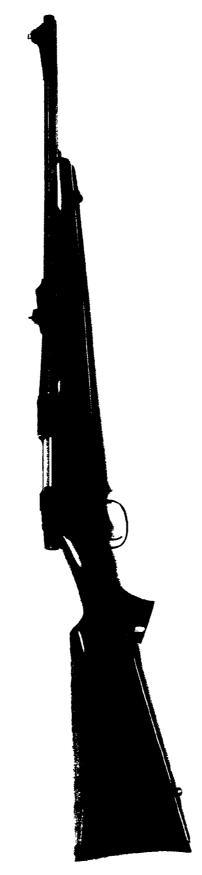
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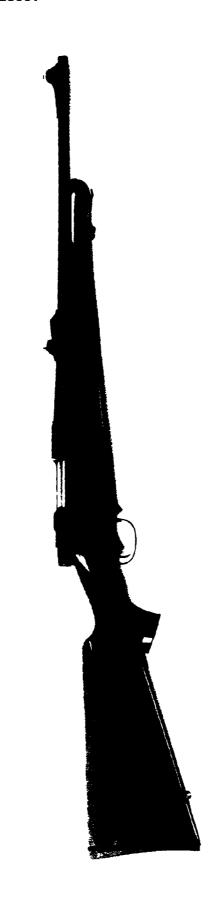
- M600 bolt assembly with M700 bolt handle and altered for a bolt lock
- 10. New bolt plug
- ll. New bolt lock
- 12. M700 BDL short action magazine
- 13. New stainless steel follower and spring
- 14. New stamped trigger guard and floor plate assembly. Short release latch for front release.
- 15. New trigger guard screw
- 16. M700 BDL front guard screw

JWB:T Firearms Research Division



4





MOODERS S

FILES

xc: H.K. Boyle

H.C. Munson C.B. Workman

C.B. Workman

T.L. Capeletti

W.K. Bryant

L.B. Bosquet R.W. Farrington, Jr.

J.H. Sweeney E.A. Burdick

Est. #4152

December 7, 1981

G.D. Campbell

Bolt Action Carbine

Estimated economic results have been developed for the proposed Bolt Action Carbine in both the first (1983) and third (1985) years of operation. These results are based on prices and volumes supplied by Marketing, and the "Present Operation" for each year was taken from the appropriate Accounting forecast.

Estimated first year results show net earnings of \$410M and a 7.0% net return on investment (full allocation basis) based on a Bolt Action Carbine volume of 28,500 units. First year incremental results are \$1,270 net earnings and a 23.9% net return on investment.

Estimated third year full allocation results based on a volume of 34,700 units are \$740M net earnings and a 10.5% net return on investment. Third year incremental results are \$1,770M net earnings and a 27.0% net return on investment.

J.C. Hutton, Superintendent Industrial Engineering Section

TRAndrews/kc Attached

Bolt Action Carbine Estimated Earnings and Net Return on Investment (Quantities and Dollars in Thousands)

TRA ISI

		FIRST Y	EAR OF OP	ERATION	(1983)
			RESULTS FROM		
		PRESENT	FILL	INCREMENTAL	OPERATION AFTER THIS
		OPERATION	ALLOCATION	BASIS	PROJECT
					:
CEVERAL	, DATA				·
Sales					•
Shotg		342			342
	ire Rifles	137		-	137
	r Fire Rifles	393	<u>38</u>	28	320
311377	Total	. 771	28	28	7 99
SALES		\$ 168,440	\$6.730	\$6,730	\$ 175,17
Less:	Mill Cost	\$ 123,020	\$ 5,270	\$ 3,880	\$ 128,29
	Finished Product Distribut	cion.			•
	Expense	3,200	130	80_	3,3
	Selling & Administrative Expense	14,070	540	310	14,61
	Total Cost	\$ 140,290	\$ 5,940	\$4,270	\$146,23
NET EAR	EARNINGS NINGS	# 28,150 # 14,500	\$ 790	\$ 1,270	\$ 28,9°
INVESIM		s	\$ 570	\$ 570	the end
Projec	t Expenditures		\$ 570	2 2 10	<u> \$ </u>
in On	ng Facilities used directly erations	<u>65,650</u>	-		65, 65
Alloca	ted General Facilities	2,530	100	30	2,63
Workin	g Capital	779,200	5,200	4,720	134,40
Tota	1	\$ 197,380	\$ 5,870	\$ 5,320	\$ 203,25
NET RET	URN ON INVESTMENT	7.3%	7.07。	23.9%	7.3°
SUPPLEM	ENTAL CALCULATIONS				
	rnings after amortizing (overs) operations charges	ver 	\$ 400	\$1,260	
	capital required including ions charges - net		\$6,010	# 5,470	
	on total capital required				

BOLT ACTION CARBINE Estimated Earnings and Net Return on Investment (Quantities and Dollars in Thousands)

18Ch/21

		RESULTS FROM		
	PRESENT OPERATION	FULL ALLOCATION	INCREMENTAL BASIS	OPERATION AFTER THIS PROJECT
GENERAL DATA			}	
Sales			1	
Spotguns	398		<u> </u>	398
Rim Fire Rifles	143		-'	143
Center Fire Rifles	367	3.5	35	402
Some Total	908	35	35	943
SALES	\$ 226,990	\$ 9,320	\$9,320	\$236.31
Less: Mill Cost	\$ 167,050	\$ 6940	\$ 5,340	\$ 173.99
Finished Product Distribu	4.310	180	110	4,49
Selling & Administrative Expense	18,910	סרף	440	19,68
Total Cost	\$ 190,270	\$ 7,890	\$ 5,590	\$198.16
PRETAX EARNINGS	\$ 36,720	\$ 1,430		\$ 38,15
NET EARNINGS	\$ 18,910	\$ 740	\$ 1,770	\$ 19,65
INESTMENT				
Project Emenditures	55. – .	\$ 570	\$ 570	\$ 570
Existing Facilities used directly in Operations	67,720	<u> </u>	-	67,720
Allocated General Facilities	3.410	140	50	3.550
Working Capital	754,230	6.370	5,930	160,600
Total 4	\$ 225,360	\$ 7,080	\$ G,550	\$ 232,440
NET RETURN ON INVESTMENT	8.42	10.57	21.07	8.5
SUPPLEMENTAL CALCULATIONS	•			
Net earnings after amortizing (or 183 years) operations charges	ver	\$ 730	\$ 1,760	<u> </u>
Total capital required including operations charges - net		\$ 7,220	\$ 6,700	

Bolt Action Carbine Estimated Earnings and Net Return on Investment (Dollars in Thousands)

		- 7 -4	·	· · · · · · · · · · · · · · · · · · ·	
		- hinst	Year of Ope		983)
					OPERATION
		PRESENT OPERATION	FULL ALLOCATION	INCREMENTAL BASIS	AFTER THIS PROJECT
GENERAL DA	<u>ata</u>				:
Sales					
Shotgun	s	341,500	_	•	341,500
	Rifles	137 050			137,050
	Fire Rifles	293/160	2 8,500	28,500	320.660
2004 Euri	derrois Total	770710	28,500	29,500	799,210
SALES	,	\$ 168,442	\$ 6,676	\$ 6,676	\$ 175,118
Less: Mi	ill Cost	\$ \23.023	\$ 5.412	\$ 3,988	* 128,435
F	inished Product Distribu	7, 200	127		3,327
	xpense alling & Administrative			80	
	peose	14.067	534	304	14,601
To	otal Cost	\$ 140,290	\$ 6,013	"4.372	\$ 146,363
PRETAX EAR		\$ 28,152	\$ 603	#2,304	<u>\$ 28,755</u>
VET EADNIN	arec	\$ 14499	` \$ 317		
NET EARNIN	<u> </u>	\$ 14,498	\$ 317	£1,193	
		# 14,498	\$ 317		
	Expenditures	\$ - '	\$ 317	\$1,193	
INVESTMENT Project I	Expenditures Facilities used directly	\$ - ·		\$1,193	\$ 14,815 \$ 570
INVESTMENT Project In Existing in Opera	Expenditures Facilities used directly	\$		\$1,193	\$ 14,815
INVESIMENT Project In Existing in Opens Allocated	Expenditures Facilities used directly actions L General Facilities	\$ - ·	\$ 570	\$1,193	\$ 14,815 \$ 570 65,648
INVESIMENT Project In Existing in Opera	Expenditures Facilities used directly actions L General Facilities	\$	\$ 570 -	\$1,193	\$ 14,815 \$ 570 65,648
Project Ficisting in Opens Allocate Working (Expenditures Facilities used directly actions L General Facilities	\$	\$ 570 100 5,227	\$1,193 \$ 570 33 4,738	\$ 14,815 \$ 570 65,648
Project Fristing in Opens Allocates Working (Expenditures Facilities used directly actions I General Facilities Capital	\$ - 65,648 - 2,527 - 729,190 # 197,365	\$ 510 100 5,227 \$ 5,897	\$1,193 \$ 570 \$ 33 \$1,738 \$5,341	\$ 14,815 \$ 570 65,648
Project Existing in Open Allocate Working (Total	Expenditures Facilities used directly actions I General Facilities Capital	\$ - 65,648 - 2,527 - 729,190 # 197,365	\$ 510 100 5,227 \$ 5,897	\$1,193 \$ 570 \$ 33 \$1,738 \$5,341	\$ 14,815 \$ 570 65,648
Project in Existing in Opera Allocate Working (Total NET RETURN NET RETURN Net earns	Expenditures Facilities used directly stions I General Facilities Lapital V ON INVESTMENT	\$	\$ 510 100 5,227 \$ 5,897	\$1,193 \$ 570 \$ 33 \$1,738 \$5,341	\$ 14,815 \$ 570 65,648
Project I Bristing in Open Allocates Working (Total NET RETURN Net earni 14 years) Total car	Expenditures Facilities used directly actions I General Facilities Capital V ON INVESTMENT TAL CALCULATIONS ings after amortizing (or	\$	\$ 510 100 5,227 \$ 5,897 5.4%	\$1,193 \$ 570 \$ 1,738 \$ 5,341 \$ 22.37	\$ 14,815 \$ 570 65,648

Bolt Action Carbine Estimated Earnings and Net Return on Investment . (Dollars in Thousands)

	Third '	Year of Ope	eration (10	905)
		RESULTS FROM	THIS PROJECT	OPERATION
	PRESENT	FILL	INCREMENTAL	AFTER THIS
	OPERATION	ALLOCATION	BASIS	PROJECT
	0.1101	A		1100201
GENERAL DATA				•
Sales				•
Shotzuns	397,500	_	-	397,500
Rim Fire Rifles	143450		-	143,450
Center Fire Rifles	367655	34.700	34,700	402 355
Shortyun Barrels Total	<u> </u>	34,700	34,700	943,305
SALES	\$ 226,994	\$ 9,070	\$ 9,070	\$ 236,054
	\$ 167,051	\$ 7,091	\$ 5,515	\$ 174.142
Less: <u>Mill Cost</u> Finished Product Distrib	ntion 12 (6.1.05)	1,091	- 9,519	4 1 1 4 1 4 2
Expense	4.313	172	109	4,485
Selling & Administrative Expense	18,901	737	408	\9,638
Total Cost	\$ 190,265	\$ 8,000	\$ 6,032	\$ 198,269
NET EARNINGS	\$ 18,910	\$ 1,070	3_038 # \571	# 37,78
INVESTMENT_				<i>i</i> -
Project Expenditures	<u> </u>	<u>\$ 570</u>	\$ 510	\$ 570
Existing Facilities used direct in Operations	67,723			67,723
Allocated General Facilities	3, 405	136	45	3,541
Working Capital	154,228	6,293	<u> 5.867</u>	160.521
Total	\$225,356	\$ 6,999	\$ 6,482	\$ 232,355
NET RETURN ON INVESTMENT	8.4%	8.0%	24.2%	-
SUPPLEMENTAL CALCULATIONS	•			
SUPPLEMENTAL CALCULATIONS			٠ د	
Net earnings after amortizing (over .	\$ 544	\$1,557	
Net earnings after amortizing (\$ 544	\$ 6,659	

FILET

xc: H.K. Boyle
H.C. Munson
C.B. Workman
T.L. Capeletti
W.K. Bryant
J.P. Linde
L.B. Bosquet

R.W. Farrington, Jr.

Est. #4152 (Revised)

February 9, 1982

G.D. Campbell

Bolt Action Carbine

The estimated economic results for the proposed Bolt Action Carbine have been updated based on revised data issued by P.E.&C. The changes reflected in this update include:

- 'Metal finishes equal to the M/700.
- A revised stock machining process utilizing the Richardson RTR NC-Router.
- Revised discount factors and third year pricing.
- *Including the cost effect of the rivetless extractor in the third year.
- ·Revised project expenditures.

The net effect of these changes is to increase the estimated unit cost by \$4.64 in the first year and \$3.17 in the third year. This results in reduced margins and net returns on investment in all positions.

The revised economic results are summarized as follows:

	First Ye	ear (1983)	Third Ye	ear (1985)
	Full Book	Incremental	Full Book	Incremental
% Pretax Margin Net Earnings Net ROI	9.0% \$ 317 5.4%	 \$1,193 22.3%	11.8% \$ 557 8.0%	 \$1,571 24.2%

J.C. Hutton, Superintendent Industrial Engineering Section

TRAndrews/kc Attached

BOLT ACTION CARBINE ESTIMATE UNIT PRICES, COSTS, AND PRE-TAX EARNINGS

	First Year Of Operation (1983)	THIRD YEAR OF OPERATION (1985)
QUANTITY	28,500	34,700
RETAIL SELLING PRICE	\$ 440.00	\$ 491.00
NET SELLING PRICE	\$ 234.23	\$ 261.38
LESS: TOTAL COST	\$ 213.08	\$ 230.55
PRE-TAX EARNINGS	\$ 21.15	\$ 30.83
% OF NET SELLING PRICE	9.0%	11.8%

GDC:JS 2/10/82

BARBER - PRESALE R 0128108

REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE





Xc:

Xc: C. B. Workman

J. W. Brooks

F. E. Martin

"CONFINE YOUR LETTER TO ONE SUBJECT ONLY"___

March 2, 1982

TO:

T. L. Capeletti

FROM:

I. S. Martin

SUBJECT:

Bolt Action Carbine

The New Product Design Group was asked to help develop the aluminum cast floor plate/trigger guard. A meeting was held with John Brooks, Fred Martin, and myself on February 25, 1982.

A complete review of the work that Bill Simpson had started was covered. Fred Martin will start the design on February 26, 1982. He has estimated it will take three weeks to layout and detail. After this is complete, it will take four weeks to make a prototype. If the first one is successful, four more would be made and a test program would be set up. It is estimated to take four weeks to build the four prototypes and two weeks to test.

This job will set back the work on the New Bolt Action Rifle (M/7) by six weeks. It will also lay a heavy burden on the Model Shop and Test Lab. It is felt that this job should have been done two years ago and it will not meet the schedule for the 1983 announcement of the Bolt Action Carbine now anyway.

Summary

Schedule Should Look Like This

February 26 - Start

March 22 - Complete layout/design details

April 19 - Complete first prototype

May 24 - Complete four prototypes

June 14 - Complete test and transmit

Bolt Action Carbine

- 2 -

3-2-82

Schedule Will Be Like This

February 26 - Start

March 22 - Complete design

April 19 - Complete prototype (redesign)

May 10 - Complete redesign

July 19 - Complete second prototype

July 19 - Get Marketing approval

July 26 - Complete four prototypes

August 9 - Complete test (problem come up)

September 6 - Complete redesign

October 4 - Complete third prototype

November 1 - Complete four prototypes

November 15 - Complete test and transmit

It is felt by Management that this design could be needed to reduce cost. However, we can not meet the schedule (1983 announcement) date with this design.

It is also felt it will delay the work we are doing on Bolt Action Rifles that is now needed to increase our share in the market place.

ISM:ws

. RD-69 REV. 6-38

BER-PRESALE R 0128110

Fragelette

J Brooks

INTER-DEPARTMENTAL CORRESPONDENCE

Clark

Clark

March 4, 1982

C. A. Riley C. B. Workman

OUTSIDE SUGGESTION FROM G. H. LEE FOR MODIFIED MODEL 660 CARBINE

Attached is material we received from a Garry H. Lee describing his suggestion for the reintroduction of a modified Model 660 Carbine. I note that we plan to introduce our new bolt action carbine towards the end of this year.

Please let me have your comments regarding Mr. Lee's suggestion so that I can respond.

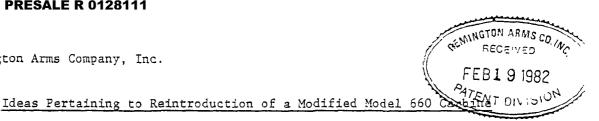
BE/vh attch. 44.00-L

> REMINGTON ARMS CO. RECEIVED

> > MAR 8 - 1982

FIREARMS RESEARCH DIVISION

fancy until it was out of production.



Recent magazine articles have renewed my interest in your Model 600/660 carbine. In the March 1981 issue of the American Rifleman, pg. 42, John E. Maxson told how he made his ideal lightweight rifle by modifying a Model 600 carbine. Jim Carmichel, in the April 1981 issue of Outdoor Life, pg. 88, praised the Model 660 he had used on an elk hunt. It is unfortunately

true, to paraphrase Mr. Carmichel, that the gun did not catch the sportsman's

- The December 1974 issue of Guns & Ammo, pg. 36, carried an interesting article by John F. Rea on the Model 660. After shooting two of these carbines extensively for several years, he said it was undoubtedly the best carbine ever offered to the hunter. It is impossible to know what caused the demise of the firearm. Some have suggested it failed because it was competing with the Model 700. This sounds unlikely because of your introduction of the Model 788 rifle, and now you are marketing the Model 788 as a semi-carbine, as well as a rifle, without hurting your Model 700 sales. The two best possibilities for the failure of the Model 660 are the choice of cartridges for which it was chambered and the use of plastic in its fabrication.
 - Rifles are made with falling block, lever, pump, autoloading and bolt actions. They are chambered for the many different rounds from the .222 Rem. to the .458 Win. Although the bolt action is the most popular, the favorite singular rifle-cartridge combination is the Winchester/Marlin lever action chambered for the .30-30 Win. Levers chambered for other cartridges have only limited appeal. Undoubtedly the late John Wayne contributed much to the nostalgia of the .30-30, but the continuing acceptance of the rifle is because hunters realize the cartridge is adequate for their needs and the rifle is easy to

handle and pleasant to shoot. A bolt action carbine with similar performance and characteristics would gain the acceptance and popularity that the .30-30 Winchester has. The ideal choice for such a gun is the Model 660 chambered for the .30 Rem.



There will be those who will want the carbine chambered for some cartridge other than the .30 Rem. It is well known that a 5½ to 6 lb. carbine with a 20-inch barrel has greater recoil and muzzle blast than a 7½ to 8 lb. rifle with a 22 to 24-inch barrel has when chambered for the same cartridge. The avid shooter is impervious to heavy recoil, but the average hunter is not an avid shooter. Although it is true recoil is not noticed during the excitement of the hunt, the anticipated recoil is considered in the gun shop when a rifle is being selected and is felt on the range when the rifle is being fired and zeroed in. This carbine is not designed for the Elmer Keiths, the Col. Askinses or the Jim Carmichels. It is designed for the John Does and the Joe Doakses who comprise the larger segment of the market. Col. Townsend Whelen believed the average shooter could tolerate approximately 15 ft.lbs. of recoil. This tolerance, along with muzzle blast, must be kept in mind when selecting alternate cartridges for the carbine.

For those hunters who will want a cartridge that has a flatter trajectory than the .30 Rem. has, I suggest developing a new one based on the .30 Rem. case. It will utilize the same bolt face and thus absorb some of the tooling costs. The .243 Win. and 6 mm Rem. cartridges are loaded with lightweight bullets for high velocity. They produce mild recoil, approximately 13 ft.lbs., but have small expansion ratios which cause some muzzle blast. Although these cartridges are acceptable, they are not ideal for a carbine. An ideal cartridg can be made by necking the .30 Rem. case to .257 caliber and moving the shoulder forward approximately .145 inch. The case may have to be strengthened to withstand chamber pressures of 50,000 to 53,000 c.u.p. By retaining the

outside dimensions of the case while increasing the thickness of the walls, the capacity would be reduced by no more than one grain of water. With a 100-grain bullet seated to a depth of .270 inch, the cartridge will have sufficient powder capacity to propel the bullet at a velocity of approximately 2800 fps. This is between the velocities developed by the nearly obsolete .250 Sav. and .257 Roberts and well below that generated by the .25-06 Rem. Just as the .222 Rem., .222 Rem. Mag. and .223 Rem. complement rather than compete with the .22-250 Rem. and nearly obsolete .220 Swift, this cartridge would appeal to those who are not interested in the .25-06 Rem.

- It goes without saying that developing and introducing a new cartridge is not without risk. Therefore, it is necessary to consider all possible applications for which the cartridge/case may be used. Here, the axiom, "Need is the mother of invention", comes into play. A .224 caliber cartridge based on this case would perform approximately the same as the popular .22-250 Rem. A .243 caliber cartridge would have somewhat less velocity than the .243 Win. and 6 mm Rem. For these reasons, plus the fact this is a light hunting carbine rather than a heavy varmint rifle, these cartridges may be disregarded. A .264 caliber cartridge would be nearly the same as a .257 caliber. It is true the larger caliber of two bullets of the same weight will have a greater muzzle velocity, everything else being equal, but it also has a smaller ballistic coefficient and therefore loses the velocity advantage on the way to the game at ranges of 200 yards or so. The 6.5 mm suffers from a bad reputation, although undeserved, and should be avoided.
- A .257 caliber cartridge is the only practical one that can be developed from the .30 Rem. case for use in a hunting rifle. However, there is a conspicuous gap between cartridges based on the .308 Win. and those based on the .222 Rem. used in benchrest rifles and silhouette/hunting pistols. Cartridges for these

Page 4

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Remington Arms Company, Inc.

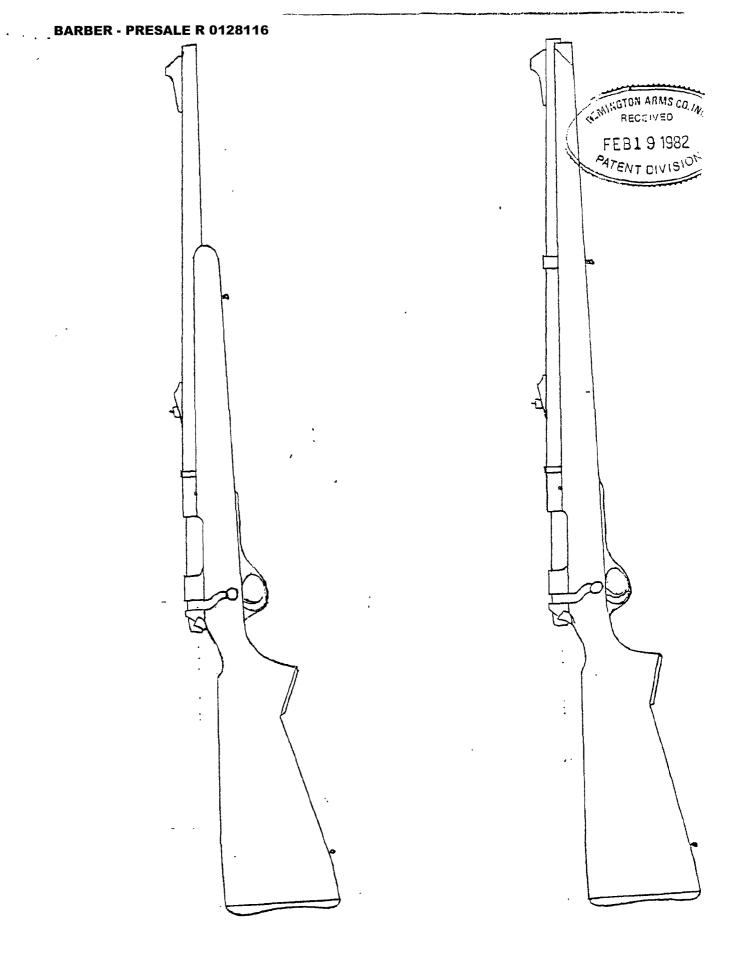
firearms based on the new brass would fill that gap and prove to be quite successful, particularly in the 6 mm and 7 mm calibers. The lack of an adequate supply of this brass to date has precluded wildcat development of such cartridges. If Remington Arms were to develop these cartridges in addition to the .257 caliber rifle cartridge, the rewards for the efforts invested would be greatly increased.

- The .223 Rem. and possibly 6 x 47 mm are two additional cartridges well suited for this carbine. They are good varmint cartridges at the shorter ranges and when properly handloaded are excellent for turkey hunting.
- For those who wish a more powerful weapon, the obvious choice of cartridges is limited to the .308 Win. and .358 Win. The .308 Win. is a well known and respected cartridge. Nothing derogatory can be said for its selection, and there is no need to repeat its fine qualities. The .358 Win. is a different matter. Since its introduction in 1955, it has never become popular. The reason for this, and this applies to the .350 Rem. Mag. also, is that hunters prefer bullets of .30 caliber or less for deer size game. A .35 caliber bullet appeals only to a relatively few hunters of the larger elk and moose. The .358 Win. is less powerful than the .350 Rem. Mag, but it kills just as effectively and recoils considerably less. Therefore, the .358 Win. will be accepted by those who would prefer the .350 Rem. Mag. and will be preferred by those who would not accept the .350 Rem. Mag.
- As to the carbine itself, it will, naturally, use the Model 660 action. It should be a quality piece so as to complement your Model 700 rather than compete with the Model 788. It should be offered with two styles of stock, a full Mannlicher and a conventional short stock. The stock should be as

straight as possible with minimum drop at the heel. The comb should be high and wide with a very slight forward slope. A builtin cheekpiece also may be considered. The butt plate area should be ample with 5½" x 1½" minimum dimensions. The length of pull should be 13½". The grip should be full or nearly full pistol, especially for the heavier cartridges. The forestock should be of sufficient size, not less than 1½" width, to provide a firm grip. The cross sectional dimensions in the receiver area can be scaled to the appropriate cartridge head diameter of .422" and .473" to achieve the desired slimness and weight. The 20-inch barrel should have a blade front sight similar to the Model 788. I prefer an aperature receiver sight but realize an open rear sight is quicker and more familiar to most hunters.

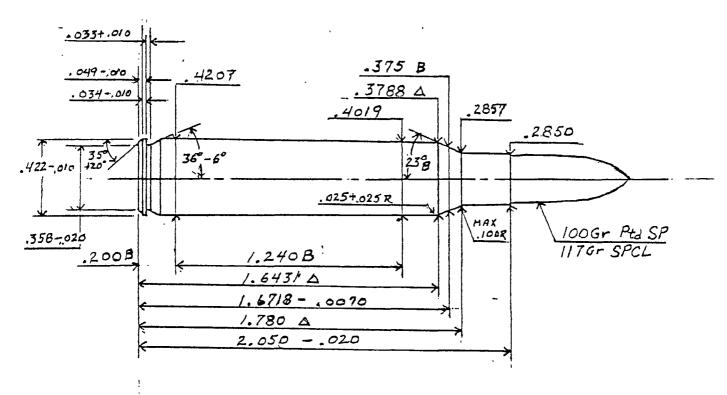
- Remington is continually involved in research and development. Your introduction of the .25-06, 8 mm Mag., 7 mm Express, 7 mm-08 and 7 mm BR cartridges are fine examples of your endeavors. You have redesigned your autoloading and pump rifles to improve already excellent products. There is a need for a small, light sporting rifle. Your comments on the resale value of the Model 600, as told by the editors of Outdoor Life, July 1981, pg. 8, indicates the current interest shown in the weapon. A Model 660, modified along the lines suggested will satisfy the need for a bolt action carbine that is easy to handle and pleasant to shoot, and chambered with an adequate cartridge. It will be welcomed by sportsmen and will enjoy a lasting popularity in the years to come.
- respectfully hope you find this idea compatible with Remington's policy to provide products that satisfy the needs of the shooting community.

Sarry Holee
Garry H. Lee





.250 REM.



RD-69-B

REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE





"CONFINE YOUR LETTER TO ONE SUBJECT ONLY"_

XC:

F.M. Ames
J.F. Bates
J.J. Bechard
J.W. Bower
H.K. Boyle
J.W. Brooks
T.L. Capeletti
G.E. Fletcher
J.P. Linde
J.S. Martin

C.E. Ritchie

Ilion, New York May 27, 1982

C.B. Workman

LIMITED DISTRIBUTION

MODEL SEVEN PRODUCTION TOOLING

To alleviate an approximate 1600 man hours of tool room backlog work, caused by the 5/4 work plan, the Research Model Shop is providing assistance on a first priority basis.

Six jobs, estimated at 700 man hours of work, have been released to the shop. To meet the scheduled completion dates, six (6) model makers have been assigned to these jobs. This will result in approximately 120 man days delay of Research prototype work. Presently this will affect the XSG program.

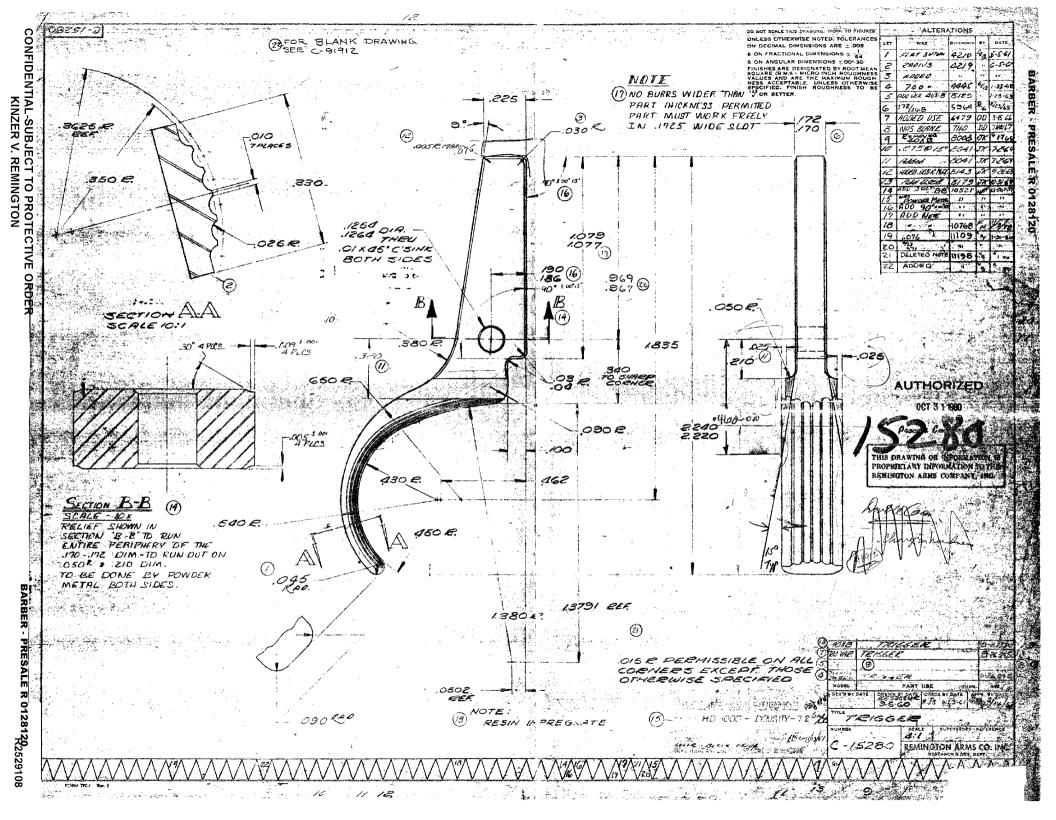
The remaining model makers (6) will continue on priority model work, namely the Model Seven and 700 ADL Restyle. No delay is anticipated in completion of the six (6) XSG prototype models scheduled for July, 1982.

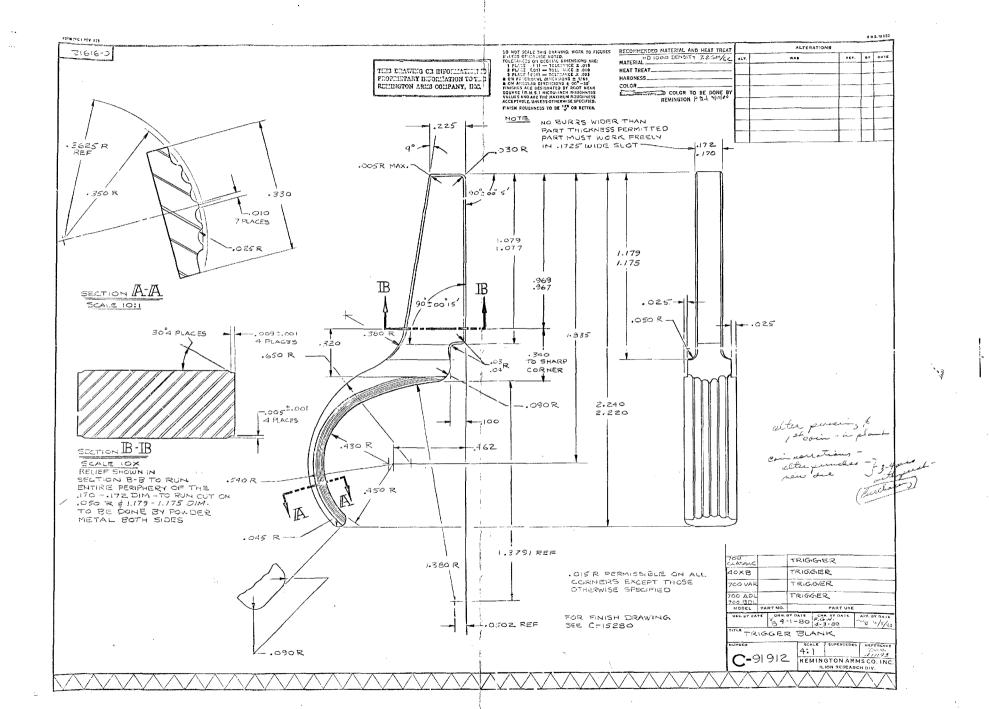
R.L. Sassone, Supervisor

Project Control & Administrative Services

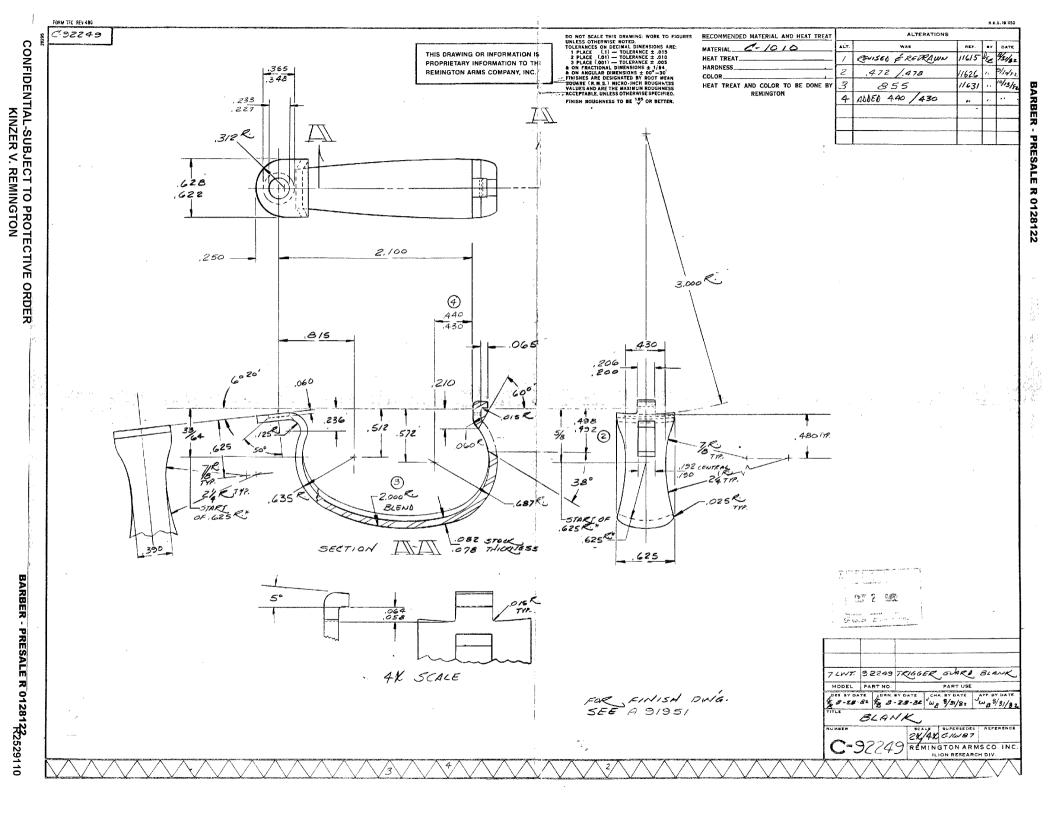
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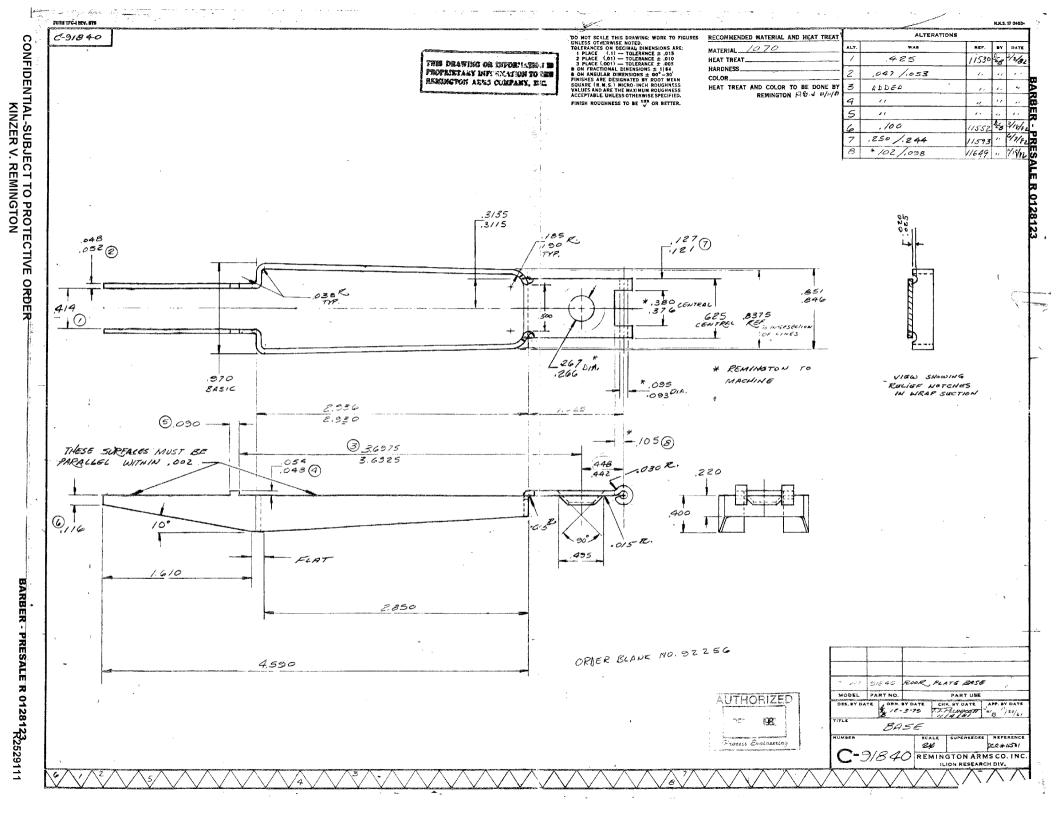
GS-11050 Rev. 8/78	TOTAL RETENTION: MAKE LIES OF	PROJECT FILE	RECORDS CATEGORY OR TITLE:	RECORDS CONTROL SCHEDULE		10Dat Casas Son
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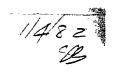




BARBER - PRESALE R 0128121







Model Seren Lately

Elanks produced	12/30/82	1/4/83	1/5/83	1/6/83	1/7/83	1/10/83
Remington Former	432	76	0	0	39	
Former	0	47	30	30	30	
Total to date	432	555	585	615	69	
Powowe Murre						
Parts in prices						
Strakke mill	87	0	0	0	30	
Will Slat	0	0	0	0	٥	
, Wrill holes	0	0	47	0	0	
Burnish	0	0	0	0	39	-
Color	0	76	0	0	0	
Co for to any of	(7	07	- 7/-	77	7 *	

Parts to assembly		•		77	
Total to date	345	432	507	584	614

XC: P. Linee J. D. Hill J. Bennett

Got Enedakee

1-6-83

Publica: Excessive opening between Flow Plate Cover Assembly and Stak at Final Accountly.

Sach grownd: There was no specification for acceptable gap included in the gum speces. During The the question came up at Final Augustion and the decision was made to use the My 700 spece.

of .030. This percel to be insufficient and was increased to .035. The My 700 is not gaged for this spece, and when the My some production gums come them, they were not gaged either.

On 1/5/53 an arbitrary spece of .025 was decided on. Jums were brought to Sund Jusp. from the Warehouse and were gaged (with a feeler gage) to the .025 dimension. Forty-one (41) only of one hundred sipty-one (16) passed.

Bugian: Home a study were on the components which have an effect on this condition. The study should fellie a group of parts from the blank then the processing steps to Line becausely. The components involved are:

· Flace Black Base Blank

C-92256

· Flore Plate Some

C-91840

· Flor Plate Comer Blank

C-92255

· Floor Plate Coner

C-91841

· Flow Plate Pad Blank

C-92449

Prints of each model dearing are attacked.

Included in the prints are the Floor Plate base

Quantly and the Floor Plate Comer Quantly. There
prints are included for information purposes, as
the study will include the beging operations on
both accemblies.

Thank you, Bead Saguet

REQUEST FOR MEASUREMENT ASSISTANCE REQUEST !

				ليار)	PRODU		<u>5</u>	ENG,		_	LATE 1/6/8	33		TLU	٦.	-	PART CES			ATE CO	υF	e	
39		11834	(10,20	3		OPERATION AND			REAM NO EN		م ۸	BORR						ΒΕ-Τ. <u>8</u> 57	 5		BLEG.
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一	-	nGCE!		T	_	MODEL	Κέ		NOOE1			HOCEL		<u> -</u>	HOUST.		· ·	MCCEL	-		POCEL.		i	H0051
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	1		+	+	+						46		<u> </u> ·	-		-	る	44	\vdash	9,	4,11-		<u>-</u> 	1
1	+	:073	丰	-	1	16,056		31	· ·	H			-	61	···_	-	75 77		<u> </u>			<u> </u>	<u> </u> 	
2	T	,054	4	$\overline{}$	ī	HL .057		32			47	·	<u> </u>	W						3	<u> </u>	 	<u> </u>	
3	+	049	<u> </u>	118	7	HL.057	_	33	-	·	48	· · · · · · · · · · · · · · · · · · ·	L	63		_	78		<u> </u>	73		1.	<u> </u>	
1	1	,०५४	1			HR.OSK	-	34			49		<u> </u>	64			79	·		94		<u> </u>	_	
5		,057	2	2	1	H1 .053		35			50	<u>.</u>		65			80			3				
6		.051		2	1/	4R 1059		36	•		51			66			81			%				
7	1.	060	- i-	2	d,	HL:057		37	71.		52			67	,•		32			97	, .		ŀ	
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9	F	.053	1	- 1	1	HL .056		39			54			69			84			3		Ī		
K	1	,060	1		7	46.054		40		,	55	· ·.		70			35			18	···		<u> </u>	
111	ī		- 1	1	- 1			¥1			56			71		_	36	····-			 -			•
$\overline{}$	T	1057	\neg		7	FR055	_	42			57	· · · · · · · · · · · · · · · · · · ·					37		<u> </u>	<u> </u>	 .	<u> </u> 	<u> </u>	
12	T	.054	\neg			HR .056		1	•		_			72	-	_	_		-		 , , , , , , , , , , , , , , , , , ,	<u> </u> 	 	
13	.1	.05	1			HL ,054		43			58		<u> </u>	73			38		<u> </u>	1				
15	Т	,053			Т	5TR. 1057		H			59			74			37				•			
1		054		3	1/	HL .058		45			60			75			%				•			
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REQUEST FOR MEASUREMENT ASSISTANCE REQUEST 4

REQUEST	ED BY	E	, Row	٠.	T.	ENG			DATE	3	3	MODEL 7 Lu	 او	_	PART DES			ON LATE (<u></u>	ځا د	e P
PART NO		<u> </u>	CPER.	700	<u>, (3</u>	CPERATIO	N O	ESC	1/6/CRIPTION REAM	ſ	۱	2 00						CEPT.	7.5	_	BLOG.
WORK RE		1	110,20	, .	<u>ن</u>		برر	•	VE LAN			SUPP									
	٠٠٠ مر د	5	Holiz			. :			-												
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			·	٠	.:		• • •	•	•						,	•.			-		
MERSURE	78 D		· R							-	DAT	E	10	2		-	SAN	PLE SIZE			
REHARKS			BAR							<u>_</u>		1/19				لـــ		30			
		الار	KRS -	<u> </u>	<u>ب</u>	HOLE	<u>></u>	ंड	Som URED	2	<u></u>	IMEN	<u> </u>	<u>-</u>	WALL INS	ΕĹ	<u>) </u>				
DESC.	OF CHE	RRC	TERISTIC		ō		_		TERISTIC	· 					TERISTIC		Q	ESC. OF	CHAR	ACT	ERISTIC
بند	= (0	94	0												•			•			•
4	00	005	F 16. 1			•															
RANG	n2= .0	93	- ,095				-											1			
no	CEL	T	HODEL		_	MODEL		_	HOCEL		<u> </u>	HODEL	\neg	_	NODEL			HOGEL.			1300n
1:109	3 D.A.		omg.gin.	i		ONG-CIN-			CHG-CIN-			ong.cih.			OMG.OIM.			OHG-DIN-			NG.CIN.
	SDA.		.QIII-	Z		gin.	X		BIH-	X	e	gin-	۶		ain-	X	=	CIH-	×		arn-
6	15		1094			·				·				1						+	
09			.095					·		·									Ħ	1	
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	594		, 094																		
	594		.094															_			
MATE	TOWN X	Cati	ES OUT OF	Ťn	-	OHC S	_			_	_							•			

REQUEST FOR MEASUREMENT ASSISTANCE REDUEST !

REQUESTED BY NEW PRODUCTS PART NO. DPER.	2 م	÷(P	ATE 1/6/3	3	MODEL		FLOOP	PLA	TON	EK	,	
PART NO. CPER. 91841 10,20,3	, v	OPERATIO	N CE	SCR	IPTION		<u></u>				BEPT.			BLOG.
		. 7	_	<u>.</u>										
C 14	<u>د</u> را	K 3.85	-	Ð,	M.			,						
		, ·,·,-							-					•
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HERSURED BY G. BAR.	1 6	5				DR	1/18/	33	•	SR	HPLE SIZE			
REMARKS.							· ···············		-					
		ME	EA	SL	IRED		IMEN	SI	ONS					
DESC- OF CHARACTERISTIC	1	iesc. of (HAR	RCTE	ZIZZIE.		CESC. OF C	HARR	CTERISTIC		GESC. OF	CHRI	RAC.	ERISTIC -
u= 3.8447														
J= .00176														
. RANGE = 3.840 - 3.84	7		•											
HOGEL HOGEL GMG-GIR. GMG-GIR.		HODEL -	\neg		MODEL G.CIR.		MODEL CMG.GIH.	1.	MODEL CHG.DIM.	1.	MOGEL GMG-GIN.			MODEL DIG.OIM.
3.850	ŀ		-											, •
e ath. X e ath.	*	CIN-	*	*	oin-		CIM-	X	ain-	g	ain-	×	•	GIM-
3.847				·	-									
-3845 81846	ŀ													
3.846. 3.84Z	1	-	-											-
3.844 3.845	ŀ						-							
3,843 3.847					<u> </u>									
3.841 3.845														
3842 3845	1	36			• • •	L		ŀ	-	ŀ			.	
3.840 3.847	$oldsymbol{\perp}$			ŀ	· .									
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3.846 3.845					·	_								
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3846 3.846						1_								
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3.845 3.845										1				1
3 .646 3.844														

REQUEST FOR MEASUREMENT ASSISTANCE REDUEST !

NEW PRODUCTS ENG.	WEER - 1/- 6/	183 7 LW	PART CESCA!	PATE ASSY	· .
PART NO. CPER 30	RATION GESCRIPTION BRAZE			8579	BLCC.
HORN REQUESTED SEE IF CON	ER IS BEING B	FATT AT ROL	∆7 €		
		en i i bri	720		
	·		-		
			<u>.</u>		
MESSURED ST (- BARNES		DATE 1/25/	83	SAMPLE SIZE	
REHARKS. Belly in C	un AFTER	BRAZELA	NOTHER BY	ZUN CROSS	Menero
AND ONES MARKED THE HINGE DESC.	MERSURED	DIMENS			
DESC. OF CHARACTERISTIC DESC.	of Characteristic	CESC OF CHR	RRCTER ISTIC	CESC OF CHAF	RCTERISTIC -
	GIN- CHG-GIN-	CMG-CIH-	740-317-	rocel Chg-3in-	model CHG-Jim-
	<u> </u>				· ·
	m- e din-	e cin-	e am-	- mid 3	* GIN-
11.012 16.008 31 31	46			9,1	-
2 000 17 1009 32		62	· · · · · · · · · · · · · · · · · · ·	3	
[3] ,009 - 118 ,00x 33	<u> </u>	63		3	
4 .002 .010 hay 19 ,006 34	49	64		94	
5 .00 20 .004 135	50	65		% %	
6 .005 21 .010 36	51				
7 007 20 003 70 457	52		82 13	9 ₇	
8 .006 23 .007 36	53 .			/x	
9 .01 24 .001 39	54			12	
10 010 25 005 40	551		P31 B6		
11 009 26 .004 "3"HI 12 .002 "# 27 .003 TRAS 47 42	56 57	1 1	β7		
12 / / / / / / / / / / / / / / / / / / /	59		88		ţ
H ,007 m2 27	59		B7	_	
15,006 30.005 45	KO	14 11	%		
NOTE: Y INDICATES OUT OF TO ERROCE		1/~1		L	•

REQUEST FOR MEASUREMENT ASSISTANCE REQUEST !

REQUESTED BY	W PRODUCT	s ÉNG.	1/6/83	プレルト	PART SESER!	PTION GER GUAPO	PLATE
PART NO.	CPER.	う ENG.	ESCRIPTION			GEPT.	BLEG.
HUNK RECUESTED				0 0 - 00			
	CHECK F	FOR STRAI	ght yess	BEFOREBR	CAZE		
		<u>.</u>	•	•	•		
	•	•	• •		•		
			• •	DOTE	· · · · · · · · · · · · · · · · · · ·	SAMPLE SIZE	·
MERSURED BY	BARNE	٠		1/24/83		30	
REHARKS. AL	L ARE	BENT	29 in 0	a direct	in I in am	tlan	
				DIMENS			
DESC. OF CHAP	RECTERISTIC	CESC. OF CHA	RACTERISTIC	histergen	##CTER 1371C	CESE - OF CHRI	ARCTERISTIC -
		X = 1015	59	X = .017	5	þ	
7	The state of the s	J = .01	114	G= .007	6		
Incoming Stemp	_		(
HQCEL_	MOCEL	MOSEL	MCCEL	HOOSEL	MOCEL	POCET_	HOCEL
ONG-JUI-	CMS-CIM-	ONG-CIN-	CMG-CLM-	OMG.CIM.	CHO-CIN-	CHG-3IM-	OMG-SIM-
e am. x	e ath. *	e om- ×	e cin- X	e cin. ×	s ain. X	e cin- X	e gin-
1.030 +		31	46	61	76	9,	
	17 1008 -	32	47	62	 	3	
	18 010 -		48	63		P ₃	·
F. 1	19 ,015 -	34	49	64	1.0.1	94	
	20,010 -	35	50	65		8	
	21 .016 -	36	51	66	81	8	
7 035 -	20 .017 -	37	52	67	82	97	
8.022 -	23 .612 -	36	53	68		98	
91.028 -	H.015 -	39	54 -	69	84	8	
101.012 -	- 210. 25	40	53	70	B5	12	
11.012 -	26 .013 -	41	56	7,1	B6		
12 .015 -	27 .020 -	42	57	72	87		
13 .010 -	28.018 -	V3	58	73	88		
14.030 -	A .020 -	14	59	74	37		
	30 .022 -	45	60	75	%		_
NOTE: Y INC.	ates out of it	L CRINCE					

REQUEST FOR MEASUREMENT ASSISTANCE REQUEST! -

Œ	WESTER BY	٠	PRODUCT	· .	Film	_	DATE /	')っ	HOUEL	774		PART DESC	RIP	PLAT:	PAC	_	
R		<u> </u>	PRODUCT		DESTRICT	CES	CRIPTION					<u> </u>	211	GE-1.	75		BLOG.
ū	PIRY O	3	1 0, 20,5	<u>, </u>			<u> </u>	<u>. +-</u>	REAM O		œ.						<u>!</u>
	. c	RI	entatio	,	OF HIM	ب دیم ه	= 70 h	- ال	OR TLA	7 E	12 F	42← ⊃ t	اں دا	LOER			
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•	RSURED BY .			7				· `	ATE				. 82	MPLE SIZI			
	HERKS.	G	BAR	آنہ	وج			\bot	1//3	18	3			3			
-		~ (حن	HOLE ATA	سدا													
					ME	AS	URED		·								
	DESC- OF CH	ARAC	TERISTIC	(DESC. OF C	IRRRI	TERISTIC		CESC. OF					GESC. OF	CHAR	AC.	reristii -
		=	<u>~</u>]				_		4:0	°Z	. 1						
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		Lo	LATE CHECK		Loc	471											
	HOCEL	Τ	MODEL		HOGEL.		HOGEL	+	HOSEL			HODEL	+	HOGEL			MOCEL
	OMG-GIU-		ING.CIT.		ONG-DIN- :	-	CHG-CIN-		ONG-QIN	•		mo.cin.		CHG-CIN.			nio-duc
•	ain.		.ain. X	5	otn-	× F	gin.	X	e gin-	ř		ain-	×	QIN-	X	•	ain.
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REQUEST FOR MEASUREMENT ASSISTANCE REQUEST ! -

RE	CUESTED	ay NEu) PODUCTS	s F	Nanet	[C 10	اداد	DATE	./8	 33	7Lu	ر	PART DE				3as	E
	4RT NG.		10.2	ان عن	CPERATE	en c	ESCR	ription T + R	EAG	\sim	HOLI	<u> </u>			1	BPT. BS		BLOG.
140	IRK REQUE	STED	LEARA										السدر ر	7س.				
		(LLEARA		. :	-					•							
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75	ERSURED 3	7 (-	s. BARN	JE <						JAT!	1/13/9	3.3			RNP	LE SIZE		
RE	EHARKS.		GE HOLE			·····	T.,	ok A								· · · · · · · · · · · · · · · · · · ·		
			7,520	<u> </u>							MEN		INS					····
	DESC. OF	CHAR	RCTERISTIC		CESC. OF	CHAR	ACT	ERISTIC		Qi	ESC OF	CHARA	TERISTIC		Œ	SC. OF	CHAR	ACTERISTIC -
				}														
		x:	097		•													•
		T:	.0026			-												
	HOGEL OMG-DIN		HOUEL	1	HODEL DNG-DIM			HOCEL NG.OIM.			MODEL		MODEL DNO.DIM.	1		MOGEL MG.JIH.		LEDDN -KID-DKD
	.\oS DIG-DIH-						. •	-		·			B-2001/10	.	. •			
	r din.	X	e .ain.	X.	gin-	×	•	oin.	×	•	gin.	×	ain.	×	8	ain-	*	e Cin-
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REQUEST FOR MEASUREMENT ASSISTANCE REQUEST .

RECUESTED BY	Romet	S ENG.	DATE 1/6/33	MODEL	PART DESCRI	PLATE BA	s C
PART NO.	CPER.	OPERATION CE	SCRIPTION C	۸ ۸		8575	BLOG.
		W OF THE			RALLEL SUC		
·							
MERSURED 87	BARNE	<u> </u>		1/13/8	3	SAMPLE SIZE	
	,	MEA	SURED I	DIMENS	IONS		
CESC- OF CHARACT	ERISTIC	DESC. OF CHAR		GESC - OF CHA		DESC. OF CHAR	RACTERISTIC
T = 1° 1° 1° 1° 1° 1° 1° 1° 1° 1° 1° 1° 1°	iquel	HOOSEL TO	NODEL :	MODEL	MODEL	roce:	ngost.
	04G-01H-	CHG-CIN-	CHG.CIM.	ONG-SIM-	CHG-CIT-	CHG-CIN-	CHO.DIN.
e air. X	.atm. X	s cin- X	e cin- x	e gin- X	e cin- X	e din- X	• GIN-
1.05	- 1°						
-1°151	1.151						
0'50'	10,6'						
1°15′	1.0			-			
1812	1.30						
0"-3	1° 15'						
1.0	10731						
10,01	0°40'	·					
10=1	100						
114	1° 10'						
115	nº 50'						•
10,00	1°25						
10151	125					_	
120	10 45'					_	
NOTE: X INDICATE	1° 40 /	ERRINCE				r	

REQUEST FOR MEASUREMENT ASSISTANCE REQUEST

REQUESTED BY	C	ENG, DPERATION OF	DATE	HOUEL	PART DESCRIE	TION	
PRI NO.	TROPUCTS	ENG, DESTRICTION OF	1/6/8 3 SCRIPTION	> 17LWT	1-Look	PLATE BALE	BLOG.
1,0,-		30 M.L.	SLOT of	PCAM		5575	
ICRK REQUESTED		OF COUNT			•		
	CRALL SIZE				•		
				•			
			••.				
					• •		· · · · · · · · · · · · · · · · · · ·
TERSURED BY	& BARN	© 5	. [IATE 1/13/2	33	angle size	
EHRRKS.			************				
		MEG	SURED	TIMENS	TONS		
GESC - GF CHA	RACTERISTIC	DESC. OF CHARF		DESC. OF CHA		DESC. OF CHAR	ACTERISTIC
							-
₹ = .50	96	←×→	1				
T=.00][
	506512	-			1		
HOGEL	HODEL	HODEL	HOGEL	HODEL	NODEL	HOBEL	HOCEL
DNG-3th-	SMG-GIH-	ONG-CIN-	CMG-SIX.	ONG-CIM-	. CHO-DIH-	. DIG-DIM-	CMG.CIT.
,495		<u> </u>					
r cin. X	e .ain. X	e din- X	e cin. X	e ain- ×	s Cin. X	e cin- X	. atn-
.510	515						٠
1.510	1.510		· .				
512	510				·	ŀ	
,510	.508			-			
,61p	50B						
.508	.510	1. 1.					-
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,506	1.510						
.510	1,506		-				
.512	.510						
508	.508						
516	,510						
. 510	.540						i
,512	.512						
.510	,510						
	CATES OUT OF F	DI FRENCE	<u> </u>		<u> </u>	1	

REQUEST FOR MEASUREMENT ASSISTANCE REQUEST ! -

RETUESTES SY NEW PRODU	CATE THE TWO THE THE THE THE THE THE THE THE THE THE	MODEL PART DESCR	IPTION PLATE BASE
PART NO. CPER. 92256 PURCHASE BY	מדבתה מבשבת ודוומא		GEPT. BLIG.
HORK RESUESTED			
G OF HING	HE TO PLATE -		
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REQUEST FOR MEASUREMENT ASSISTANCE REQUEST !

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REQUEST FOR MEASUREMENT ASSISTANCE REQUEST .

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Samphe

PURCHASED PART INSIECT

Part No. 92155	Lot iv.			
Drawing No.	Snawniel 30			
Part Name 7 LWT Floor Plate Cover Bla				
P. O. Number	Sample Size $1st35$ /2nd			
Vendor	AQL			
Date Received	Material			
Inspector & Date /- 1/-83	For LabDate			
Accept Lot Reject Lot	Accept Mtl. Reject Mtl.			
Special Notes:				

GAGE NO.	DIM.		TOL.	UNDERMIN	N-OVERMAX	REMARKS
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	640 - 630	30	1			* 4
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Samphe

PURCHASED PART INSPECIFIE.

Part No. 92256	_ Lot Ma	
Drawing No		30
Part Name 7 LWT FLOOR Phote Base		
P. O. Number	_ Sample Size	lst_ <i>30</i> _/2nd
Vendor	AQL	
Date Received	Material	
Inspector Cw Date /-//-83	For Lab	Date
Accept Lot Reject Lot	Accept Mtl	Reject Mtl

GAGE NO.	DIM.	# IN		UNDE	RMIN	F TOL.	REMARKS
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J. P. LINDE

XC: S. D. Bennett

Z. J. Kowaslki

J. B. Mroz

J. R. Snedeker R. L. Snedeker

File

REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE

Remington. **OUPOND**

DETERS

"CONFINE YOUR LETTER TO ONE SUBJECT ONLY"___

Bred Bosquet, February 2, 1983

will you the this in with the alter program

TO: L. B. BOSQUET on the m/7 flow plate?

Tond

FROM: G. E. BARNES

MODEL SEVEN LWT FLOOR PLATE ASSEMBLY

PROBLEM:

Final Inspection Rejects - excessive space

between Floor Plate Cover and Stock

METHOD:

Sample pieces (30) of floor plate base blank, floor plate cover and floor plate pad taken from Purchase Parts and measured for the following dimensions:

- A.) Floor plate base blank
 - 1.) All dimension checks for incoming purchase parts.
 - 2.) Dim..448-.442 before operations.
 - 90° c'sink 3.)
 - Centerline hinge hole to flat of 4.) hinge before mill, ream and deburr.
 - 5.) Width of c'sink (.495)
 - 6.) Orientation of hinge to base.
 - 7.) Dimension .448-.442 after operations.
 - 8.) Centerline hinge hole to flat of hinge after mill, ream and deburr.

TO: L. B. BOSQUET

FROM: G. E. BARNES

MODEL SEVEN LWT FLOOR PLATE ASSEMBLY

METHOD:

contd.

- B.) Floor plate cover
 - 1.) All dimension checks for incoming purchase parts
 - 2.) Dimension 3.850
 - 3.) Dimension .055
 - 4.) Contour before opeations
 - 5.) Contour after operations
 - 6.) Diameter of reamed hole (.093-.095)
- C.) Floor plate pad
 - 1.) 90° c'sink
 - 2.) Depth of c'sink (.107-.093)
 - 3.) Diameter of hole (.300)

OBSERVATIONS:

- A.) Floor Plate Base
 - *l.) Hinge hole undersize
 - * Take down hole undersize and eggshape
 - * Width of hinge oversize
 - * All parts out of parallelism from flat of base to hinge.
 - 2.) Dimension .448-.442 parts in tolerance (Note: holes are eggshaped)
 - 3.) All parts at 90° c'sink
 - 4.) Centerline hinge hole to flat ranges from .004-.005 before process.

- 2 -

TO: L. B. BOSQUET

FROM: G. E. BARNES

MODEL SEVEN LWT FLOOR PLATE ASSEMBLY

-3-

OBSERVATIONS:

- A.) Floor Plate Base contd.
 - *5.) C'sink oversize all 30 parts.
 - 6.) Hinge not parallel to base
 - *7.) Dimension .448-.442 not in tolerance after mill, ream, deburr.
 - 8.) Centerline of hinge hole to flat ranges from -.003 to .003 after mill, ream and deburr. (Note: ranges before and after may vary due to hinge hole being at taper.)

B.) Floor Plate Cover

- 1.) Found all 30 parts acceptable
- *2.) Dimension .3850 found parts at low limit or below
 - Dimension .055 found most parts in tolerance.
- *4.) Contour on comparator showed both ends to be .010 high.
- *5.) Contour after braze showed two variations to a lesser amount with several parts having hinge bent.
- 6.) .093-.095 hole found to be to model drawing.

C.) Floor Plate Pad

1.) Made 5 castings - found all to be 90°, but not at 4° angle and no .010 step at neck.

TO: L. B. BOSQUET

FROM: G. E. BARNES

MODEL SEVEN LWT FLOOR PLATE ASSEMBLY

OBSERVATIONS: C.) Floor Plate Pad - contd.

2.) Depth of c'sink in tolerance

Checked pad with the altered c'sink and found to be .114 deep.

- 4 -.

 $\frac{\text{NOTE}:}{\text{to .181}}$ Thickness varies from .171 to .181 with a .002 to .004 taper which could cause some plates to be higher than others.

*3.) Diameter hole .280-.281 with large burn at bottom.

* Denotes parts vary from model drawing.

NOTE: Full report upon request.

GEB/bdm

XC: G.E. BARNES - L. B. BOSQUET

TO: L.B. Bosquet FROM: G.E. BARNES Feb. 271983

R.L. SNEDEKER J.R. SNEDEKER S.D. BENNETT Z.J. KOWALSKI J. B. MROZ

MODEL SEVEN LUT FLOOR PLATE ASSEMBLY

PROBLEM: FINAL INSPECTION REJECTS - EXCESSIVE SPACE BETWEEN FLOOR PLATE COURS AND STOCK

- METHOD & SAMPLE PIECES (30) OF FLOOR PLATE BASE BLANK,

 FLOOR PLATE COUER, AND FLOOR PLATE PAD TAKEN

 FROM PURCHASE PARTS AND MEASURED FOR THE

 FOLLOWING DIMENSIONS
 - A) FLOOR PLATE BASE BLANK
 - 1) ALL DIM. CHECKS FOR INCOMING PURCHASE FARTS
 - 2) Dim. 448 ,442 BEFORE OPERATIONS
 - 3) 90° C'SINK
 - 4) CEMERLINE HINGE HOLE TO FLAT OF HINGE BEFORE
 MILL, ROAM, AND DEBURR
 - 5) WIGHT OF C'SINK (.495)
 - 6) ORIENTATION OF HINGE TO BASE
 - 7) D.m. 448- 442 AFTER OPERATIONS
 - 8) CENTER LINE HINGE HOLE TO FLAT OF HINGE AFTER MILL, REAM, AND DEBURR
 - B) FLOOR PLATE COVER

1) ALL DIM. CHECKS. FOR INCOMING PURCHASE PARTS

- 2) Dm. 3.850
- 3) Dm .055

- 4) CONTOUR BEFORE OPERATIONS
- 5) CONTOUR AFTER OPERATIONS
- () D.A. OF REAMED HOLE (.093-0095)
- C) FLOOR PLATE PAD
 - 1) 90°C'S.NK
 - 2) DEPTH OF C'SINK (107-1043)
 - 3) D.A. OF HOLE (.300)

OBSERVATIONS: A) FLOOR PLATE BASE

- * 1) HINGE HOLE UNDERSIZE
- TAKE DOWN HOLE UNDERSIZE AND ECGSHAPE
- WIDTH OF HINGE OVERSIZE
- * ALL PARTS OUT OF PARALLELISM FROM FLAT OF BASE TO HINGE
 - 2) DIM. 448-442 PARTS INTOLERANCE (NOTE: HOLES ARE EGGSHARE
 - 3) ALL PARTS AT 90°C'S, NK
 - 4) CEPTER LINE HINGE HOLE TO FLAT RANGES FROM. OUY -> T.OOS BEFORE PROCESS
- * 5) C'SINK OVERSIZE ALL 30 PARTS
- () HIUGE NOT PARALLEL TO BASE

 * 7) D.M. 448-142 NOT IN TOLERANCE AFTER MILL, REAM, DEBURY
 - 8) CENTERLINE OF HINGE HOLE TO FLAT RANGES FROM : 003 TO .003 AFTER MILL, REAM, AND DEBURR (NOTE: RANGES BEFORE ANDAFTER MAY VARY DUE TO HINGE HOLE BEING AT TAPER)
- B) FLOOR PLATE COVER

 - 1) FOUR ALL 30 PARTS ACCEPTABLE

 * 2) Din. 3,850 FOUND PARTS AT LOWLINIT OR BELOW
 - 3) D.m. 055 FOUND MOST, PARTS IN TOLERANCE

- * 4) CONTOUR ON COMPARATOR SHOWED BOTH ENDS TO BE.010
 High
- * 5) CONTOUR AFTER BRAZE SHOWED TWO VURIATIONS TO A
 LESSER AMOUNT WITH SEVERAL PARTS HAVING HINGE BENT

 () .093-.095 HOLE FOUND TO BE TO MODEL DRAWING
- C) FLOOR PLATE PAD
 - 1) MADE 5 CASTINGS FOUND ALL TOBE 90° BUT NOT AT 4° ANGLE AND NO .010 STEP AT NECK
 - 2) DEPTHOF C'SINK INTOLERANCE
 CHECKED PAD WITH THE ALTERED C'SINK AND FOUND
 TOBE IN DEEP

NOTE: THICKNESS VARIES FROM: 171 TO. 181 WITH A . DOZ TOO

. DOY TAPER WHICH COULD CAUSE SOME PLATES TO

. BE HIGHER THAN OTHERS

* 3) DIA. HOLE .ZBO-.ZBI WITH LARGE BURR AT BOTTOM

* DENOTES PARTS VARY FROM MODEL DRAWING

NOTE: FULL REPORT UPON REQUEST



2 FEB.83 G.E. BARNES

RECOMMENDATIONS TO ALTER FIXTURES

PORT	FIXTURE OR GAGE NUMBER	OBSERVATION	RECOMMENDATIONS
FLOOR PLATE COVER	D-46056	THE SPRING WHICH HOLDS	COAT SPRING WITH
•		PART ON THE FIXTURE 15	PLASTISOL OR DEVEN
		SCRATCHING THE PARTS	
FLOOR PLATECOVER	E-46058	INDICATOR ARM PART OF	LONGER INDICATOR
		GAGE AND ARE UNABLE	TIP REQUEED OR
		TO GAGE FULL CUT ON	ALTER HOLDING
		Himme	FIXTURE
FLOOR PLATE COUSE	E-46060	TAKE DOWN HOLE HAS PROPER	NEED BUSHING TO
		Positioning BUT THE REAMER	GUIDE ROAMER
		FOLLOWS THE ORIGINAL HOLE	TO CONTROL PROPER
		WHICH IS AT TAPER	Positioning
CLOOR PLATE BASE	E-45641	HINGE LOCATED IN Q'V" ON THE	GRIND RELIEF IN
	E-45640	FIXTURE & GAGE. THE HINGE	BOTH THE GALE &
		HAS RAISED & DEFORMED METAL	FIXTURE
		AND IS CAUSING A DEFLECTION	
FLOORPLANE BASE	E-45644	ALSO LOCATES INA "V" AND	Needs Relief Ground
		PART HAS BURRS + Deformed	IN THE"V"
		Metal	
		THE FIXTURE Need'S ALSO.	Needs a Guine
		ALLOWS THE REAMER	BUSHING TO HELP LOCATE
		TO FOLLOW THE ALREADY	HOLE PROPERLY
		FORMED HOLE	

NO. 14	DATE				
то:	B. Bos	quet			
FROM: J. P. LIN	IDE	<i>/</i>			
SUBJECT: 27	7/7 Fr	igger &	suard-	Floor-	blate
DESCRIPTION:	leave a	nganige	a m	esting -	with
B+D, Qua	lity, c	miner	g and	Produ	tion
on the m	7/7 ZW	Trigge		1-7 lone	flate
dut the	/ /	for e	ach co	1)	and
proposed	soluli	on Cif	they exic	<i>*)</i> .	
					· · · · · · · · · · · · · · · · · · ·
COMPLETE ACTION:	ASAP	DATE	2 - 2 ?- 83DISC	RETION	
AUTHORITY:		act on own.	REPORT AT R	EVIEW.	-
		ACT, BUT ADVI	SE. REPORT A	T REVIEW.	
-		ADVISE BEFOR	E TAKING ACTIO	ON.	
PROBLEM ANALYSIS S	HEET REQUIRED):		YES	···········
REPORT: VERBAL	N	OTE	LETTER	REPOR	RT
STATUS REPORT REQU	JIRED: YES_	-			,
ORIGIN OF REQUEST:	BBIDGEBOB	T MANAGEMEN	T HC	1/HKB	
ORIGIN OF REGUEST:	JPL V	OTHER DEF		17 NKB	
_		- JOINER DEF	13.		
COMPLETION DATE: 2	-/28/83				
STATUS REPORT DUE:				,	

m 6 5 55

• Sem a controlled text for I shift - Sereen or straighter enough Trigger June Plates (\$250) for one shift of operation

Deprindity N.P. Comes Justity Cont.

flatures spec on Jung ger fraud Plate affect of power resistions to Joes. In there a relationship to specific times of the day in terms of poor legs?

Jud Cont,

orecome difficulty of loading and fluting puts by investigating prosible design changes to provide a mechanical means of accently prior to hage

Rosearch

Floor Plate Cover Queenly - Buyings.

• Continue work on redesing of industrian anil

- Suretigeting more support for FP Cover in broging

fixture will be delayed until cail design in

· finalized.

Polling Komelski

- A. C. report on braging operation was received. It is felt that the warpage experienced is not existing.

MODEL KEY

DUC - D.U. COMM

DUS - D.U. SPECIAL

BAC - BOLT ACTION CARBINE

4LE - MODEL FOUR LIMITED EDITION

		_TRIAL & P:	ILOT START KEY EV	'ENTS	•	
	_	1	PROCESS RECORD	TRIAL & PILOT	COMPONENT	T & P
ENGINEER	MOD	COMPONENT	ISSUED	NOTIFICATION	WITHDRAWAL	START
Bottini	DUC	Barrel & Barrel Ass'y	ISSCHED	ISSUED		2/15
Kowalski	DUC	Rec. & Rec. Ass'y	ISSUED	ISSUED	I SSUAD	2/15
Bottini	4LE	Receiver				2/19
Poore	DUC	Fore-end	ISSUED	ISSUED		2/22
Poore	DUC	Stock Ass'y	ISSUED	ISSUED	1	2/22
Kowalski	DUS	Rec & Rec Ass'y	ر دیان در در	1554470		2/22
Bottini	DUS	Barrel & Barrel Ass'y	1.45460	15501577		2/22
Bottini	4LE	Receiver Ass'y	1880 600	ISSUED		3/5
Orf	BAC	Stock				3/12
Bennett	DUC	Trigger Plate Ass'y	155000	1550100		3/15
Orf	4LE	Stock (Aluminum master)	1			3/19
Poore	4LE	Stock	ונשטאני	ISSUED		3/19
Bennett	Dus	Trigger Plate Ass'y	1550 an	ISSUED		3/22
Kowalski	4LE	Upset & Drilled Bbl Blank				3/26
Kowalski	DUC	Final Assembly	ILSUED	, SSUED		4/1
Poore	4LE	Fore-end	1 SSUUD	158000		4/2
Kowalski	4LE	GFM Barrel Blank				4/2
Kowalski	4LE	Rear Sight Base	153UED			4/2
Kowalski	DUS	Final Assembly	ISSUETO	ISSUGD		4/5
Polley	4LE	Fore-end Tip Spacer				4/9
Bennett	4LE	Magazine	155060	13841600		4/9
KOW BLSKI	445	BARRIEL - FINAL SUR ASSENBLY	ISSUED			1"
KOWALSKI	DUS	STACK- LUCKINER ASSEMBLY	ISSUED	133060		3-15
KAWALSKI	DUC	STOCK. RUCKINGR ASSUMBLY	155000	15501570		1 -34 - 7 4

PRESALE R 0128152

MODEL KEY

DUC - D.U. COMM
DUS - D.U. SPECIAL
BAC - BOLT ACTION CARBINE
4LE - MODEL FOUR LIMITED EDITION

ENGINEER	MOD	COMPONENT	PROCESS RECORD ISSUED	TRIAL & PILOT NOTIFICATION	COMPONENT WITHDRAWAL	T & P START
Bennett	4LE	Operating Handle	፣ ՏՏປພ	155000		4/9
Kowalski	4LE	-Barrel				4/9
Kowalski	4LE	Front Sight Ramp	1534 40			4/16
Poore	4LE	Fore-end (Profiled)	155000			4/23
Poore	4LE	Stock (Profiled)	155080			4/23
Kowalski	4LE	Barrel Assembly	1.SS.CILID			4/23
Bennett	4LE	Fore-end Cap	1334160	ISSUED		4/30
Bennett	4LE	Trigger Plate	153067	135000		4/30
Poore	4LE	Fore-end Ass'y	15SUap			5/7
Kowalski	4LE	Rear Sight Assembly	155000			5/7
Bennett	4LE	Magazine Assembly	1530GD	ISSUMD		5/14
Poore	4LE	Stock Assembly	1350150			5/14
Bennett	4LE	Fore-end Screw	1530ED	ISSULTE	ĺ	5/21
Bennett	4LE	Trigger Plate Assembly	1550630	ISSUED		5/21
Rowalski	4LE BAC	Barrel Assembly Comp.	ISSUED	153060		5/21
Kowalski	BAC	Receiver BLANK	1350 CD	1830 WD	150UD-150	6/11
Ciecko	BAC	Barrel Blank				6/18
Kowalski	4 <u>LE</u>	Stock - Receiver Ass'y	153000			7/2
Bennett	BAC	Floor Plate Cover			1	7/9
Bennett	BAC	Mag. Spring Retainer				7/9
Kowalski	4LE	Final Assembly	/33000			7/16
KAW ALSKI	444	BARREL FINAL ASSETTELY	155000			

MODEL KEY

MODEL KEY						BA
DUC - D.U.	COMM					BARBER
DUS - D.U. BAC - BOLT						, 13
		R LIMITED EDITION				2
i di		MDTSI C D			•	PRESA
			ILOT START KEY EV PROCESS RECORD	TRIAL & PILOT	COMPONENT	T&PM
ENGINEER	MOD	COMPONENT	ISSUED	NOTIFICATION	WITHDRAWAL	START 7
Bennett	BAC	Floor Plate Base				7/16 28 7/23 5
Kowalski ·	BAC	Floor Plate Cover Ass'y	155047			7/23 5
Bottini	BAC	Bolt Body Assembly				8/13
Bennett	BAC	Trigger Guard Plate	1354160			8/13
Kowalski -	BAC	Floor Plate Base Ass'y	155460			8/20
Bennett	BAC	Bolt Handle				9/3
Bottini	BAC	Bolt Plug	:			9/3
Polley	BAC	Floor Plate Pad				9/3
Bottini	BAC	Barrel & Barrel Ass'y				9/10
Kowalski ·	BAC	Front Sight Ramp	ISSULED			9/10
Bennett	BAC	Safety Assembly	\			9/10
Bennett	BAC	Safety				9/10
Bennett	BAC	Safety Button				9/10
Bottini	BAC	Bolt Assembly	·			9/17
Bennett	BAC	Front Sight Ramp Screw				9/17
Korba	BAC	Bolt Stop Release	155JED			9/24
Bennett	BAC	Floor Plate Latch				9/24
Korba	BAC	Rear Guard Screw				10/1
Korba	BAC	Trigger Assembly				10/1
Korba	BAC	Trigger Guard				10/1
Kowalski ·	BAC	Final Assembly				10/29
KowaLSKI	שמ	ROCUIVOR				
	TEADE	STOOK RUC. ASSUMBLY FINAL ASSOMBLY			1	1

got copy of report from zinger



Floor Plate Bace

Stank - review and list all problems to be resolved.

with randor

· Will all for hinge - no problem

· Juging for mill and rean opens adequate

Floor Plate Ban Orsig.

· Brazing operation - apperx. 20 % scraps

-XTDR issued to release park after brage.

- Leizer June Plate not flat as received from newlor

- Poor and microsistent brage

- Check material become recurring part come Then to get builtle.

- Euned areas on lego - flex heing removed before heat is applied?

- Joseo broze unit -

power serger? control available power-?monitor?

* preaceable Bace Queenly prior to brage

ere we cheeking flatuers om Leigger Juand Blate?

Floor Plate Coner - hucoming good - check one fightere.

Markining -

- 3.850 deurs. running endersige

- maring at milling operation - TORin to reache

- coloring - mare - new rack designed to growing separation

Brazing operation - P 5% scrap - warpage & .010 as recid & at brage (maybe from hot spots)

- investigate better support

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER KINZER V. REMINGTON

BARBER - PRESALE R 0128155 R2529143 - clack rand timble specition - if not accomplishing

anything - source - (sheep edges cut into word)

- Row Polley - working on new coil dowing - lesp from vocco?

- 100 To will we get such of trouble o

- sout energy for an 8 for sum (250)

(descently
o in proper deburing - series and correct

filing o

o binding at heinge area

- · Meeting: 2/16/83 at 2:30 Pose C.R.

 List all pertinent problems (don't try to recolve them

 at this time) publish ---- effect ----
- · Keniew list if necessary, establish a ranking from most senere to miner. have typed - send to all - regresh input (if any) from location.
- · Establish a solution and time/dollar extimate for secolaring each groblem if a solution exist.
- · Schedule a follow-up meeting and review proposals with everyone.
- · lesse letter and pohedule to John Linde by 2-28

BARBER - PRESALE R 0128158

Brad Borquet, when is the report with the tanks, completion dates, and regionable

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER KINZER V. REMINGTON

Roark) TURN

xc: [J. P. Linde S. D. Bennett J. B. Mroz R. D. Polley

February 16, 1983

A meeting was held this date to discuss problems involving the Model Seven Floor Plate Base Assembly - Floor Plate Cover Assembly and their related components. Present were:

L. B. Bosquet

J. W. Brooks

D. E. Bullis

G. E. Barnes

P. C. Earl) IN

The purpose of the meeting was to generate as complete a list as possible of problems being encountered with these components. This initial meeting concentrated mainly on the components as they are received from the vendors and are processed through to final assembly. Noted were:

- Floor Plate Base Blank
 See attached Quality Control report.
- Floor Plate Base Machining Operations

 Mill slot in hinge production has no problems with this operation. Fixturing and gaging appears to be adequate.
 - Ream Front Take Down Screw Hole and Hinge Pin Hole.

 Fixturing and gaging appears to be adequate. Quality Control study indicates that all hinge pin holes are angled relative to the rest of the part.
- Parts are not flat as received from the vendor. Model drawing calls for parts to be flat within .010. Purchase Parts Inspection procedure to be reviewed and vendor will be contacted.
- Floor Plate Base Assembly Brazing Operation

 The brazing of this assembly is yielding approx. 25-30% scrap.
 - assembled FPBA difficult to remove from fixture after braze. A TDR has been issued (ZK-199) to provide a means of removing assembly without damage.

- poor and/or inconsistent braze
 flatness and/or straightness of parts could be
 a contributor.
 power supplied to TOCCO unit appears to vary during
 the shift.
- difficult to flux and load parts and position brazing preform.
- As received from the vendor, the blank is dimensionally good. The only problem appears to be that the ends are approximately .010 higher than the center. One Purchase Inspection gage appears to mar the surface.
- Floor Plate Cover Machining Operations

 3.850 +005 dims is running slightly undersize. It
 was found that a clamp at the milling operation was
 marring the surface. This will be taken care of by
 changing the clamp surface from steel to nylon.
- Floor Plate Cover Assembly Brazing Operation

 This brazing operation runs better than the Floor

 Plate Base Assembly. It produces approximately 5% scrap.

The main problem noted at this operation is a slight warpage in two areas. This may be the result of hot spots developed in the heating cycle. Work is in progress on the redesign of the induction coil.

A TDR will be issued to revise the fixture to provide additional support for the part during braze. This work will have to be coordinated with any change to the coil.

A question was raised concerning the efficiency of the sand tumble in removing sharp edges which cut into the Stock finish. It was also pointed out that some deformation of the Magazine Spring Retainer may be caused by this operation. An operation will be added to check for warpage 100% until coil and fixture design is finalized.

Final Assembly Problems

The main problem mentioned was the binding of the hinge. It is felt that this is caused by improper deburring of the mill cuts. This operation will be reviewed by the engineer and the filers will be reinstructed.

Another cause for binding is covered on the attached study done by Quality Control. The hinge as formed by the vendors runs at an angle. This condition will be corrected.

Steps have been taken to eliminate poor coloring on the Cover and Base Assemblies. New racks have been designed - one in use for Floor Plate Cover (approx. 120/rack), one for Floor Plate Base due by 2/18.

Functional Problems

The single most critical functional problem is the unlatching of the Floor Plate Cover when the gun is fired. This problem is being actively worked on by another group, but if any solutions come out of this committee, they will be implemented. Bending of Floor Plate Covers - thicker material samples are being machined and will be tested to see if any improvement is noted. Thicker Trigger Guard Plates are available and a request has been issued to obtain thicker Floor Plate Base Blanks from the vendor.

LBB:hf Attach.

BARBER - PRESALE R 0128162

Brad Bosquet,

I would like each item broken

February 23, 1983

into taske as you have then with

into taske as you have then with

J. P. LINDE

J. P. LINDE

RE: MODEL SEVEN FLOOR PLATE BASE, ETC. - PRODUCTION PROBLEMS

Attached is a list of items requiring follow up which came out of the meeting held 2/16. Responsibilies have been assigned for each item.

L. B. Bosquet

LBB:hf Attach.

FLOOR PLATE BASE BLANK

2. <u>Duc</u>

- Review Purchase Inspection procedure. Is it adequate based on experience gained to date?

Bennett Quality

 Send marked print to vendor indicating the results of Quality Control's study.
 Work up a program to resolve problem areas.

Bennett Purchasing

- Marked prints have been sent to vendor requesting samples from thicker material (.062).

Bennett Purchasing

FLOOR PLATE BASE (MACHINING OPERATIONS)

- Review the .100 ± .005 slot in the hinge. Engineering layouts indicate a potential bind condition at assembly. Engineering recommends that this dimension be changed to .115 + .005.

Research Bennett

- Review reaming operation to verify that part is located correctly.

Bennett

- Review filing operation - is it adequate? Is it being done correctly?

Bennett

TRIGGER GUARD PLATE

 Quality Control study shows these parts are bent as much as .035. The model drawing calls for parts to be flat w/in .010. Review gaging of incoming parts.

Bennett

 Samples of Trigger Guard Plates have been received made from .062 material. They were assembled and turned over to Research for testing 2/22.

Kowalski Research

FLOOR PLATE BASE ASSEMBLY

- Brazing operation

Bent Trigger Guard Plates may be a contributor to the brazing problems. Run a controlled study for one (1) shift using screened or straightened Trigger Guard Plates (approx. 250). Monitor the output to determine effect of flatness on yield. This study should also indicate whether or not there is a relationship between poor braze and specific times during the shift.

Kowalski
Polley
Production
Quality Control

FLOOR PLATE BASE ASSEMBLY - Contd.

3.

TDR (ZK-199) has been issued to make removal of assemblies from the brazing fixture easier.

Kowalski Tool Design

- TDR's (ZK-197 and 198) have been issued to alter the drill jig and pinning gage for positioning and sizing the rear take-down screw hole.

Kowalski Tool Design

• FLOOR PLATE COVER BLANK

- review gaging of hinge pin hole as formed by vendor. We should check to be sure this is 90° to long axis of part and parallel to the flat portion of the tab.

Bennett

• FLOOR PLATE COVER - PROCESSING

 review reaming operation (Production has no problems with this operation) to verify that drill jig is orienting part correctly.

Bennett

- sharp edges at Latch end of part are cutting into the finish on the Stock. Run a sample of parts through sand tumble prior to brazing operation.

Bennett Production Research

- review deburring operation - is it adequate? Is it being done properly?

Bennett

 obtain quotation and lead times to go to thicker material (.062 or possibly .078). Bennett Purchasing

FLOOR PLATE COVER ASSEMBLY - BRAZING

 continue work already in progress to redesign induction coil for better heat. Redesign of brazing fixture to add additional support (if possible) will be investigated when coil design is finalized.

Polley Kowalski

- Thicker Floor Plate Covers (.062 material) have been processed and are ready for braze. They will be turned over to Research for testing by 2/28.

Production Kowalski Research

LBB:hf

- ALTERING THE COINING PUNCH WHICH CREATES THE SERRATIONS ON THE FINGERPIECE AND,
- A NEW COINING DIE FOR SERRATING THE FINGERPIECE.

 THE BEST ESTIMATE FOR A NEW DIE AND ALTERED

 PUNCH IS 3-4 WEEKS.

L.B.Broquet 3/14/83

DIE & STAMPING COMPANY

DIV. OF UNITED SCREW AND BOLT CORP.

Engineering Tools Dies Stumpings Sub = Assemblies Bus Supplies

> 4650 TIEDEMAN ROAD CLEVELAND, OHIO 44144

216 671-8000

February 28, 1983

Remington Arms Company, Inc. Ilion, New York 13357

Attention: D. D. Ricci

Reference: #92256 Floor Plate Base

Dear Dwayne:

In reply to your letter of February 14, 1983, we find the following and make suggestions as noted below:

- The .251/.258 diameter hole should be changed to .248/.256 as this diameter is line contact only and will always be egg shaped. It would be better on the low side to always assure ream stock.
- The .080/.090 diameter hole should be changed to .078/.088 as this diameter will change with stock thickness variations.
- 3. The .442/.448 dimension should be eliminated as H & P manufactures to the 1.025 dimension.
- 4. The .620/.630 dimension over the hinge pin should be changed to .633/.645. H & P noted their quotation stated Remington to machine. This width over the roll will change with stock thickness variations.

February 28, 1983 Remington Arms Co., Inc. Page 2

- 5. The parallelism of the hinge platform to the legs are 90° ± 30°. H & P checks as 90° + 38°. We believe there should be common methods of checking. Material thickness and chemistry will affect the squareness. Would suggest a sizing operation if this condition gets out of control.
- 6. The .215/.225 dimension H & P checks as .218/.221. We believe there should be common methods of checking.

We have checking fixtures on hand that need considerable rework to make them usable.

Yours sincerely,

Frank Amorose

rn

QUOTATION





216-671-8000

DIE & STAMPING COMPANY

DIV. OF UNITED SCREW AND BOLT CORP.

Engineering · Development · Tools · Dies · Stampings Sub-Assemblies . Bus Supplies 4650 Tiedeman Road • Cleveland, Ohio 44144

March 4, 1983 Date

Terms 1% 10 days—30 days NET F.O.B. Our Plant-Cleveland, Ohio

Attn: D. D. Ricci

Ilion, N. Y. 13357

Remington Arms Co., Inc.

Gentlemen:

To

Quantity	Description	Price
	Part Number 91840 Base 92256 Blank	
	Temporary tools and engineering to drop bottom of hinged platform in line with top of legs radius to be approx035 rad. Twelve (12) piece sample.	
	Total:	\$1400.00
-	Total: Total:	

The above Quotation is subject to acceptance within 30 days from date hereof; thereafter, prices are subject to change without notice, according to fluctuation of market prices of material, over which we have no control. We are not responsible for delays in deliveries due to strikes and conditions beyond our control.

Very truly yours,

H & P DIE & STAMPING CO.

Ву	 		
- /	 	 	_

8000 pcs owed Remin to 3000 pcs owed Remin to corrected .495 shalance will be to corrected dim

on nesh order - ofter above uder is complete?

"Hoo" will cover alt to germoneak tolg - put front

pad in position and add relief notches - maintain

.015 radius (may require, 020 - 025 deep on notch.)

MARKED PRINTS TO REFLECT AFFECT OF ADD'L MAT'L THICKNESS WHERE APPLICABLE (MAINTAIN INSIDE DIMS PER J. BROOKS)

2 PRINTS TO DIRICCI, I TO J. BROOKS, 1-LBB

3-10-83

CHANGE . 414 DIM ON MARKED PRINT TO TAKE ADD'L
MAT'L. THICKNESS TO INSIDE PER J. BULLIS - CHANGED
TO ,394

CONTACTED PURCH & HEP - WILL REQUIRE ADD'L MONEY
AS QUOTE WAS BASED ON USING PORTIONS OF EXISTING
TOOLING WHERE POSSIBLE. THIS CHANGE REQUIRES
HOLDING INSIDE DIM FOR MAG. OPENING BUT CLOSING
IT IN UNDER THE TRIGGER GUARD PLATE.

Hip-THIS WILL AFFECT A SERIES OF FORM FOOLS-COST ADD'L.

AND DELAY SAMPLES

KOMINGTON - STAY WITH . 414 FOR SAMPLES - CHANGE IF . 062

BARBER - PRESALE R 0128170

MATGRIAL WILL BE MADE PERHANGUT

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER KINZER V. REMINGTON

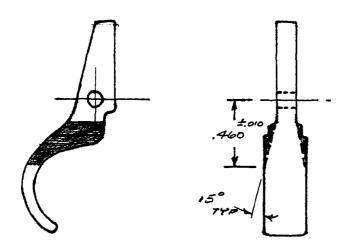
J.P. LINDE

Ra: MODEL SEVEN LIGHTWISIGHT TRIGGER.

PROBLEM: POTENTIAL FOR BINDING ON SIDE OF TRIGGER GUARD PLATE.

GOLUTION:

· IMMODIATE - PROVIDE ADDITIONAL CLEARANCE ON BOTH SIDES OF TRIGGER (15280) BY SETTING UP A MILLING OPERATION. CURRENT PRODUCTS IS WORKING ON A FIXTURE AND OUTTER TO ACCOMPLISH THIS.



- *LONG-RANGE SOLUTION IS TO CHANGE THE P/M BLANK (91912)
 THIS REQUIRES:
 - ALTERING UPPER & LOWER PRESSING PUNCHES. ALTERATION
 CAN BE DONE ON PLANT.
 - ALTERING UPPER & LOWER COINING PUNCHES. ALTERATION
 CAN BE DONE ON PLANT

3-16-83

Model Senen LWT Filose Plate Base Blank

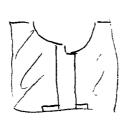
450

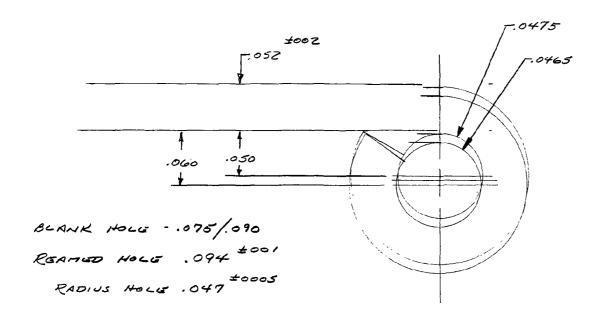
3½-4½ who from order point (1062 matil)

O.T. has been authorized - will letter del. by PIwh

Joahead given H & P 3-9 somples sure wh of 3/28 or 4/4

Randy & for Kick, Jerry. Jac Regal April 23





MAX MAT'L. .054 MIN MAT'L .050 CAN BG .014 MAX.

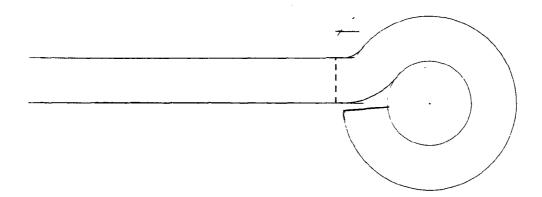
MAX TO & HOLE .060 MIN TO & MOLE .050 STEP AT TOP

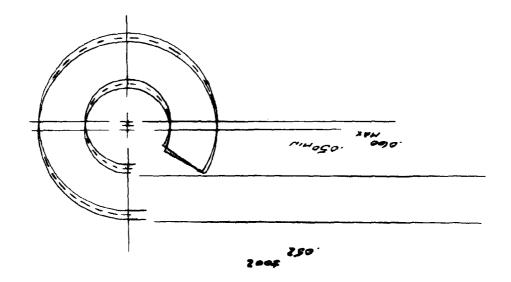
.114 .100

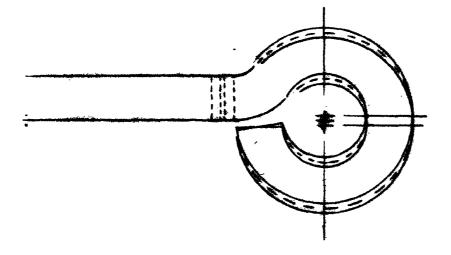
THIS COULD ALSO CAUSE:

- · HOLE TO BE REAMED AT AN ANGLE RETATIVE TO OUTSIDE
- . THIN WALL CONDITION
- · BINDING AT ASSEMBLY
- * VERIFY .055 ±005 POSITION OF HINGE HOLE IN BLANK AND
 REMOVE DRILL BUSHING AND ALLOW REAMER TO FLOAT
- * CHECK DRILL VIG TO BE SURE PART IS LOCATED WITH HINGE HOLE

 VERTICAL IN BOTH DIRECTIONS







88

DON'T SAY IT-WRITE IT

rom L.B. Bosquer

25: HODEL SEVEN LOST - REVISED TRIGGER

COSTS AND LEAD TIMES TO REVISE PIM FOOLING TO PROPOSED TRIGGER DESIGN.

PRESSING TOOLS ! NO CHANGE TO DIE

ALTER UPPER GLOWER PUNCHUS IN 2-3 DAYS

House

! NO CHANGE TO DIE

ALTER UPPER & LOWER PUNCHES IN 2-3 DAYS

HOUSE

COINING TOOLS... FINGURPHICE SURRATIONS

: NEW DIE

ALTER UPPER PUNCH

4 WEEKS

(ALLOW P INSER TO CHANGE)

DRAWINGS AND SHIP TOOLING)

1 work -

YOTAL COST ESTIMATED AT \$5000 LEAD TIME AT SWEEKS "YOUR SAFETY ATTENTION MEANS ACCIDENT PREVENTION"

Ilion Resea	rch D	IVIS	ion				RD - 65	14		
								ļ		}
DATE			MC	DEL SEVEN LIGHTWEIGHT						
6-15-83				LT ACTION CENTERFIRE RIFLE	1					
3-14-83	ŀ	ı	BC	LT ACTION CENTERFIRE RIPLE	ŀ					
		┢═			308 W	n. 6mm	243	7mm-08	222	.223
SHEET	1		Ooti	ted line ($$) indicates same part number	Win.	Rem.	Win.		Rem.	Rem.
O,	3				VY 111.	Kem.	VV Ц1.		Kem.	
₽₩G	_			O for this is a section						
NO		L,		- PARFNAME		l				
					<u> </u>		PART N			
R-21460	BAR	R		ASSEMBLY COMPLETE	21460	21461		21463		
D-34990	B	П		Assembly		34991		34993		34995
D32725		В	TTE	l (Blank 92252)		32726	32727	32728	32729	32730
B-15279		Ва	IT	l Bracket (Blank A-15128)	15279					
D-91876				iver (Blank B-31485- 31487)	91876					
C-91877		R	eC#	iver (Blank B-31485)					91877	
			7							
C-91882		L	Ш	(Bb) & Rec. Marking)						
D-34970	B	-	A	sembly	34970				34971 28737	
D-28735		Bo	dt	Body Assembly	28735	<u> </u>			<u> </u>	
C-15407			В	olt Body	15407	1				
C-28500				(Body Blank	28502					
A-18493			В	olt Body Brazing Slug	18493					
D-28665		<u> </u>	В	olt Head (Blank C-32820)	28665				28667	
A-18758			В	olt Pin	18758					
B-17011			E	ector Washer	17011					
R-92229		В	1,	Handle (Blank D-92227)	92229					
C-20185				ing Shim	20186					
A.17017	1 1			(Blank A-13974)	17017					
A 17676	1 1-	•		Pin (Blank A-91802)	17676					
A 17010				Spring	17019					
C-91816	LF	kı	ac	or (Blank A-90523)	91816					
C-91906				tor (Blank A-90522)					91906	<u> </u>
C-15373				Sight (Blank C-90393)	15373					T
C-15719	Ŭ.	مان	dr.	Sight (Alternate)(Blank C-90425)	15719					
B-92081		to	at	Sight Ramp (Blank B-92080)	92081	<u> </u>				
B-92084		i to	at	Sight Ramp Screw (2) (Blank 92247)	92084				<u> </u>	<u> </u>
B-28505	<u> I</u>	<u>Vea</u>	<u> S</u>	ight Base Screw (2) (Blank B-90347)						
B-32520	$\downarrow \downarrow \downarrow$	غطة	ĿS	aht Assembly	32524	l				
C-32510	$\bot \bot$	1	ea	Sight Aperture (Blank C-32535)						
C-91595	$\bot \bot$	1	≹ ea	Sight Base (Blank C-32530)	91595	<u> </u>				
C-90905	$\bot \bot$	Ц	de a	- Sight Slide (Blank C-90925)	90905		J		<u> </u>	
B-90906	44	,	1	ation Screw (Blank B-91910)	90906					
B-90904	44		1	dage Screw (Blank B-91911)	90904					
A-28600	FIR			IN ASSEMBLY	2860					
A.92288	44	вЫ	4 P	lug (Blank C-15674)	92288	3				T <u></u> -
B-15410		Elr	ومان	Pin (Blank B-16509)	15410)				
B-17022				Pin Cross Pin	17022	2				
C-23320	44	Εlι	ing	Pin Head (Blank B-27975)	2332					
A-1541	44	Цα	ih_	Spring	1541	1]	
	++	4	+							
	++	4	+	<u> </u>				I		
L		1		<u> </u>				_1		

	irch	Di	visi	on		 .		RD - 65	14	·	
DATE 4-29-82 6-15-83					DEL SEVEN LIGHTWEIGHT LT ACTION CENTER FIRE	308	6mm	243	7mm-08	222	223
SHEET OF	2		D	ot	. red line ($$) indicates same part number.		Rem.	Win.		Rem.	Rem.
DWG. NO.					PART NUMBER						
	П		T	Т				PARTN	UMBERS		
C-15412	Bd	lt.	Sik	ы	(Blank 92253)	15412					
C-24475	Bd	lt	Sik	я	Pin	24484					
A-15413						15413					
					rd Screw (Blank C-28810)	22037					
		7	1								
C-16715	М	023	zik	م	(Blank C.91934)	16715					
B-16716	М	ıqa	zi	e	(Blank C-17971)					16716	
					Follower (Blank C-92454)	92455					
					Follower (Blank C-92507)					92508	F
					Spacer (Blank B-91936)					15286	
					Spring (Blank 13713)	15699					
C-91905						100/				91905	
					d Screw (Blank 92248)	91881					
D-31001	1	-	7	4	d Screw (Blank 92246)	71001		===	 		[
B-17034	R	CE	ive	-	lug Screw (3) (Blank B-91913)	17034					
C-24475	Se	ar	Pi		(2)	24476		===		===	<u></u>
	<u> </u>	_	4	_				ļ	ļ		<u> </u>
					SSEMBLY WALNUT	100010			<u> </u>		
D-91544					Pad						<u> </u>
C-25410					Pad Screw (2) (Blank C-91916)	25410		_ = = =			
B-15651		R	ir	fo	cing Screw	15651					<u> </u>
E-91950		St	od	c d	Checkering Pattern D-91977)	91950			<u> </u>		<u></u>
A-15358		Sv	riy	el	Screw (2)	15358					
D-91780		G				91780					
C-91779					p Insert	91779					T
A-25380	T				p Screws(2) (Blank A-91914)	25380		<u> </u>			
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٠ ٦	Ilion Resea	rch D	ivisio	n			RD - 65	14		1
	DATE									
			MODEL SEVEN LIGHTWEIGHT							
	12-6-82		BC	LT ACTION CENTER FIRE RIFLE	}					
L	6-15-83			21 ACTION CENTER 1 III 2 III 2	1			, ,		
	SHEET OF	3 3	Do	tted line () indicates same part number.	.308 Win	6mm Rem.	.243 Win.	7mm-08	.222 Rem.	223 Rem.
	DWG. NO.			PART NAME						
						· 	PART N	JMBERS		
	D-92458	TRI	GGE	R ASSEMBLY	92458					
	C-91828			top Release (Blank 92251)	91828					
	B-91853			Assembly	91853					
	C-91851		Saf		91851					
[C-91852			ety Button	91852					
[B-23220			Detent Ball	23222					
	A-15368	S	afety	Detent Spring	15368					
ſ	B-17043	S	afety	Pivot Pin (Blank B-91918)	17043					
Ī	A-17044			Snap Washer	17044	<u> </u>				
	C-15666			afety Cam (Blank C-91919)	15666					
ſ	A-17047			pring	17047					
	C-15280	r	rigge	r (Blank C-91912)	15280					
	B-17053	T	rigge	r Screw Front (Blank B-91920)	17053					
Ī	C-19461	I	rigge	r Connector (Blank C-91921 - C-91937)	19461					
[B-91128	T	rigge	r Engagement Screw (Blank B-91922)	91128	===				
Ī	C-26655	1	rigge	r Housing Assembly	26655	===				
	A-14632			gger Housing Rivet (4)	14632					
Ī	B-14630		Tri	gger Housing Spacer (Blk B-91923)	14630					
Ī	B-14631	П	Tri	gger Housing Spacer, Rear (Blank B-91924	14631					
ļ	C-30780			gger Side Plate, Right(BlankC-32785)	30780					
Ī	C-30780		Tri	gger Side Plate, Left	30781					
	C-24475	1	rigge	r Pin	2447				_ = -	1
	Д-15400	1	Irigg	er Spring	15400)				
Ì	A-15481	11	Irigg	er Stop Screw (Blank A-91926)	15481					
Ì										
	C-91850	FIG	ar Pi	te Base Assembly	91850) <u> </u>				
Ì	C-91840			Plate Base (Blank 92256)	91840)				
- 1	A-92576			Plate Base Brazing Preform	92576	Ţ———				
1	B-91845			er Guard Plate	91848	-;				
,				ate Cover Assembly:	91842	,				
lst	C-91841			Plate Cover (Blank 92255)	9184					
2nd	A-92577			Plate Cover Brazing Shim	92577					
Ì	C-91846			zine Spring Retainer	91846				!	
		 			Z4V 13			T	T	1
	B-92581	Flo	or P	ate Latch & Spring Assembly	92581	1				
1	C-91843			Plate Latch (Blank C-92254)	91843					
	B-91848			Plate Latch Spring (Blank C-92250)	91848					
	A-90380			Plate Latch Spring Pin	90380					
				ate Pad (Blank C-92449)	92450		 			
				ate Pivot Pin	1645			1		
	A-91951	76	daer	Guard (Blank C-92249)	9195					
		† "["	77	()	1 /1/5		† = = = =	1	1	
		11	++		1		1	†		
1					<u> </u>			→		

From: LB Borguet

Re: Proposed change to thicker material on the Model Seven Llose Plate Base, etc.

· Sample components made from thicker material have been ordered and well be used for resification testing. Status:

Trigger June

Vendor wiel ship 250 per 4-1

Flow Plate Bace Blank

Vendor will ship 250 per 4-1

Tugger June Plate

Sample parts are on the plant

Flow Plate Comer Blank

Sample parts are on the plant

Felore Plate Latch Spring

Vendor will ship by 3-30

· In anticipation of acceptable texting of the above pumples, each render has been asked:

- are the temporary tools capable of producing 7000 part?

- what is the estimated lead time to prome 7000 parts?

- what is the externated time involved to change rendon tooling back to the present design?

- if there are open order for the present park, what is the lead time to produce them? - is the thicker material available? If not, what is the estimated lead time to processe it?

· Long range program based on permane	ul ship	el	
to thicker material.	mat'l		accum
- Trigger June	time	time	secure lead time
produce To see on temp. tools		4 wh	4 who
consect taling back to pres, design		2	6.
connect to bearies mut'l permanently		5	//
samples		/	12
graduction		4	16
· · · · · · · · · · · · · · · · · · ·			
- Flore Plate Bose Blank			
produce 7m per on temp. tools		4	4
convert toling back to present des.		,	5
* processe thicker material	11 who		
um open production order (present des)		4	9
change tooling permanently		4	13
samples		1	14
predection		4	18
- Leizzer Jused Plate			
no tooling changes regulard			
produce 7 m pieces		\mathscr{A}	
material -	2 who		

NOTE: .080 MAT'L IS C-1010 NOT 1070
VENDOR WON'T QUOTE 1070 MAT'L, IN .080

* render produces pretetype part on temporary hench type hand operations and can produce 7re pieca. This way at approx. . 17 lack in 2 who. The other way to go is with permanent treling - 6 who and a piece price of approx. . 06 each and a tooling charge of about \$2400

045

Lugger flate sampler efrom Square were 1010 matil

metil. - lead

7000 pièces using 1010 - .080 ±003 mat'il 2 who existing tools 2 who

won't quate 1090

Floor Plate Cover

material - P / week

attentemptores won't produce 700 part

alter permanent tools & samples

2 wh

after permanent tools-back to.050

2 wh

matil ducets with temp set-up P.17 each

2 weeks

permanent tools 2400 p.06 en alter & comple

6 weeks

1 week

Review w/ Berearch? ? Remon: in some cares touling is being Mymb? S changed prior to exceptance - if not accepted could put production ochedule in japandy.

BARBER - PRESALE R 0128186 d - bending fixture - T.R. - Wate @ Butt frestor for RTR- inlet Be. & Barrel Joone. Justation for F.P. 73.73. plowexpedite by anthony : engineers, tim deed? saw matil - remem Peuch - contact mendons advance release recensory. IT LEAD TIMES -ALTER PERMANENT TOOLING 9Kg weeks (.062) Sample approval - to good. 3-4 who. send sample of T.G. Plate - for try out of Tigger Just. permanent tooling - approximately the pane because tooling for 788 has to remain

= Took plus peries 3/25/83 reason linder - mostly to left side Inspected Courses 1. Receive sext in stock unever, usually 2. Rear T/D hole run-out Conective action G-16 beller 1. Indexing pins realized to usure station to - station controlling 2. Fixtures realizant to insure fixture - to-fixture inletting and turning center controlly Thouseon fushing and rode repaired on stations 5, 9 \$11 One quide pen lousing repaired I wo other judged O.K. Of grown / tol layout empleted Process layerts revised for bbl growe. Base gage dugs revised. alterations to be made before next run Rear T/D Role to be moved to , 250 01 Receiver sent to be widered to 1.390 (1.360 receiver) with ,030 flat on bottom to insure receiver will not " cont". (me 1.360 DIA cutter)

10. New It morshell ordered 11. magazine cut slepth to be pulled up The.

RTR

- 1. Clearered outs added to bottom
- however to but locator) print to

 brieval 3 print 3 to gave being reviewed (3/25)

 when with gage to confirm the -up with H/D

 the up if here dimension which were transmitted

 foreg in a 2/28/83.

MISC

- 1. Production (John Miller, Out 72) has been importing and repairing all stocks before soul and checking against on action.
 - 2.) amponing operation (and gage) set up to redict to .250 dea. all . in-process stocks in Pent 72.
 - 3. 15 of 16 stocks from preliminary 6-16 set-up slowed NO TRIGGER MOVEMENT when assembled by Eventt Danies

ALTERNATE INLETTING

On 3/25/63 EL MORRIS VA. issued a capacity study (attacked) which shows that the ATR would be oundered 103% in many by adding top inletting and transferring the external cuts to the Heim.

freder that only 49% then 1963 it a cost of 455,000 (rough ext.) to provide tooling.

Mourice Monteau has outlined and N/C program and designed a full locator for the RTR se requested by J. P. LINDE, designed Built locator completepued decision on which may to go.

1. Make tried run of 11/7 stocks on

6-16 often mechine has feen repaired

and slighed, and the force game

has been altered. If the parts

are satisfactions continue to use

the G-16, facked up by

and the grapmane.

2. If parts are not established to be the God's and course is detirment to be the God's a. Repair moshing out try organ b. Proceed with RTR intetting program for short-term inprovement and order trolling for REML.

1. PARTS FROM G-16 - 4/1/83

2. RTR LOCATOR, PRGRAM, CUTTERS ONE MONTH

3. REAL TUBLING

DESIGN ONE MONTH

BID ONE MUNING
BUILD FOUR MONTH

STAL SIX MONTHS

R.W. Fornigton
S.M. Mornis

3-25-83

L.G. Wilke,

Per your request capacities have been re-evaluated on the proposal to relocate operation GO (Top Inlet), presently performed on the G-16 for the M/71tw, to the REML, Richardson RTR Router, and the Heian CNC Machining Center.

	Daily	Schedur	(including 159	16 Scop)
Model	April	May	3rd Quarter	16 Scop) 4th Quarter
7 Ltw	173	196	255	288
700	426	443	. 460	483
788	115	92	61	58

	Machin	e Hours	Colo Burden	ina	1
Machine	April	may	3rd Quarter	4th Quarter	Mocels Run
REML-Current	7.1 (31%)	7.4 (33%)	7.7 (34%)	8.1 (36%)	m/700
- Proposed	9.2 (40%)	9.7 (42%)	10.5 (46%)	11.1 (49%)	M/700, M/7L+W
RTR - Current	16.7 (73%)	18.6 (82%)	23.6 (10.4%)	26.3 (115%)	M/7Ltw-external cuts, M/2200, Target Stoc.
Proposed	22.1 (97%)	24.7 (108%)	31.6 (139%)	35.3 (155%)	M/THU-Top Inlet, M/200, Torget Stock
			·	1	
Heion - Anticipated				20.0 (82%)	M/100, 74w, 788, 580,541
Proposed				24.8 (109%)	M/700, 76tw, 76tw-Inlet, 788,580,541

Assuming M/7Ltw external cuts relocated to Heian

On a capacity basis the REML would be the best condidate for succeeding the G-16 for top inletting of the M/7Ltw.

E.L. Morris Jr.

3-25-83

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Heion - Anticipated				20.0 (88%)	! : M/100, 74w,788, 580,541
Proposed				24.8 (109%)	.M/700, 76t.w, 76tw-Inlet, 788,580,54,

Assuming M/7Ltw external cuts relocated to Heian

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E.L. Morris Jr.

- Described 2 308 Cal with:

- Described 2 308 Cal with:

- Fiture avail to diel of the form of the first of the first of the form of the first of t

testing 3-7

of 28 gums testado I F.P. opened
checking Latch Spains
no splik Stock

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MODEL SEVEN LIGHTWEIGHT

PROBLEM:

- · STOCK SPLITTING
- · FLOOR PLATES COVER OPENS

RUSPONSIBILITY COMPLETION

PROGRAM TO RESOLVE:

· IMMEDIATE

- Froux SPLITTING

MODIFIED M/600 DRILLING FIXTURE

ORE

COMPLETE

DESIGN AND BUILD TEMPORARY DRILLING

DESIGN

N.P. PROCESS

GOMPLETE

BUILD

Tool Room

- FLOOR PLATE COVER OPENS

MODEL SEVEN LIGHTWEIGHT FLOOR FLATE COVER OPENS

RESPONSIBILITY COMPLET

· IMMEDIATE

- A QUANTITY OF RIFLES IN . 308 CALIBER WILL BE
-ASSEMBLEDWITH THE FOLLOWING MODIFICATIONS:

ALTERED AND HEAT TREATED TRIGGER PROCESSENG.

GUARDS CHEM \$ MET

-28 GUNS

RD-69-8

REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE

Remington.

PETERS

Xc: L. B. Bosquet

D. D. Ricci

J. D. Rogers

C. B. Workman

41.00

"CONFINE YOUR LETTER TO ONE SUBJECT ONLY"__

April 8, 1983

TO:

J. P. LINDE

FROM:

G. D. CAMPBELL

MODEL SEVEN LWT LARGE CALIBER PRODUCTION

Objective

Implement the design revisions which Research proposes for the Model Seven LWT Trigger Guard and Floor Plate components, without altering or disrupting the current production schedule.

Status Summary

Research has proposed the redesign of all Trigger Guard and Floor Plate components to prevent potential failures for "Floor Plate Opens" in .308 and 7MM-08 calibers. They are currently producing 250 sample guns for test, and plan to transmit the new design about May 1.

Five purchased components are involved in the design change (Trigger Guard, Trigger Guard Plate, Floor Plate Base, Floor Plate Cover, and Floor Plate Spring). All require tooling changes, some of which will take eight to nine weeks, including sample approval. Another five weeks will be required to obtain production components. Assuming no action until Research transmits the design, redesigned components would be available for assembly beginning about July 21. However, the current production schedule calls for large caliber production from June 13 to August 24.

Week with

MODEL SEVEN LWT LARGE CALIBER PRODUCTION PAGE 2 April 8, 1983

Temporary vendor tooling was purchased by Research in March, and was used to produce 250 sample parts for design verification testing. Purchasing has contacted the vendors to determine:

1) whether that tooling can be used to produce 10,000 parts for production; 2) lead times to produce the 10,000 parts; and

3) lead time to convert permanent tools and begin supplying parts. Using this information, a Critical Path Network was developed which maintains the integrity of the current production schedule, subject to the following conditions:

- Temporary tooling cannot be used to produce Floor Plate Cover. The vendor will be released by mid-April to alter permanent tools and produce parts.
- 2. The vendor cannot guarantee 10,000 Floor Plate Bases off temporary tools. P. E. & C. should work with Research and Purchasing to loosen non-critical tolerances to maximize production off temporary tools.
- 3. Purchasing will release the Floor Plate Base vendor to purchase thicker material prior to design transmittal. Material delivery is expected to take about 11 weeks.
- 4. Planning will reschedule 2,000 Model Seven's in .243 caliber ahead of the first .308 run. These .243's were originally scheduled for assembly in late August.

GDC:hv

4-12-83

C. B. WORKMAN

SUMMARY

THE COSTS INVOLVED IN CHANGING FROM THE PRESENT DESIGN

AND FOR MATERIAL THICKNESS ON THE MODEL SEVEN LEST

FLOOR PLATE BASE AND RELATED COMPENSIONS HAS BEEN

ESTIMATED AS FOLLOWS.

VENDORS- TEMPORARY TOOLING	10,950.00
VENDORS - PURMANUNT TOOLING	36,975.00
PURCH. INSP. GAGING	9,065.00
PRODUCTION GAGING & FIXTURING	2736.00
TOTAL	\$ 59,726,00

BREAKDOWN BY COMPONENT IS ATTACHED

Shboquet

BRIENKDOWN OF COSTS BY COMPONIENT &

· FLOOR PLATE BASE	
VENDOR - TUMPORARY TOOLING	* 5800.00
VENDOR - PERMANENT TOOLING	11820.00
PURCH. INSP. GAGING	1540.00
PRODUCTION GAGING & FIX FURES	
Toma	\$ 21096.00
· TRIGGER GUARD PLATE	
VENDOR - TEMPORARY TOOLING	0.00
VENDOR - REVISE TO NEW DESIGN	1250.00
PURCH. INSP. GAGING	550.00
PRODUCTION GAGING & FIXTURING	0.00
TOTAL	\$ 1800.00
: FLOOR PLATE BASE ASSEMISLY	_
PRODUCTION FIXTURING	600.00
TOTAL	* 600.0 0
· FLOOR PLATE COVER	
VENDOR - TEMPORARY TOOLING	0.00
VENDOR - PURMANUNT TOOLING	≈800. 00
PURCH. INSIP. GAGING	200.00
PRODUCTION GAGING & FIXTURING	200.00
TOTAL	# 3200,00
· TRIEGER GUARD	
VENDOR - TEMPORARY TOOLING	5150.00
VENDOR- PERMANENT TOOLING	18730.00
PURCH. INSP. GAGING	6325,00
PRODUCTION GAGING & FIXTURING	0.00
TOTAL	30205.00

* FLOOR PLATE LATEN SPRING

VENDOR - TEMPORARY TOOLING

O.00

VENDOR - PERMANENT TOOLING

PURCH. INSP. GAGING

450.00

PRODUCTION GAGING & FIXTURING 0.00

TOTAL \$2825.00

ABBrazuet 4/12/83

C.B. WORKMAN

MODEL SEVEN LWT FLOOR PLATE BASIS ISTE. PROPOSED DESIGN CHANGE TO HEAVIER MATERIAL

· VENDOR TOOLING

FLOOR PLATE BASE BEANK

TEMPORARY TOOLING CHANGES TO PRODUCE

7000 - 10000 PARTS - PAID RESIDENCE

PERMANENT FOOLING

411820.00

TRIGGER GUARD PLATE

NO CHANGE RED'D TO PRODUCE 10,000

THICKER PARTS TO CURRENT

DUSIGN

TOOLING CHARGES TO GO TO PROPOSED

WIDER DESIGN

4/250,00

TRIGGER GUARD

TEMPORARY TOOLING CHANGES TO PRODUCE

10,000 PARTS (BY RESERREN

\$ 5150.00

PERMANENT TOOLING \$18730.00

FLOOR PLATE COVER BLANK

PERMANUNT TOOLING WAS ALTERED

TO PRODUCES 10,000 PARTS

ADDITIONAL REVISIONS TO PERMANENT

TOOLING

FLOOR PLATE LATER SPRING

TEMPORARY TOOLING TO PRODUCE

10,000 PARTS

PERMANENT TOOLING

2375,00

· PRODUCTION TOOLING

GAGES AND FIXTURES WILL HAVE TO BE

REVISED OR BUILT NEW TO

ACCOMMODATE HEAVIER MAT'L.

COST IS ESTIMATED AT

\$ 11250.00

· SUMMARY

TEMPORARY TOOLING

PERMANUT TOOLING

PRODUCTION GAGING & FIXTURING

\$11250.00

TOPAL



Remington Arms Co., Inc. Ilion, N.Y. 13357 To

Attn: D. D. Ricci



Engineering · Development · Tools · Dies · Stampings

Sub-Assemblies . Bus Supplies

4650 Tiedeman Road • Cleveland, Ohio 44144

Date April 5, 1983

Terms 1% 10 days-30 days NET F.O.B. Our Plant-Cleveland, Ohio

Gentlemen:

Replying to your inquiry of......we take pleasure in quoting as follows:

Quantity	Description	Price
669.00/M	Part Number 92249 Guard Permanent .036 increase front end 4°-30' Angle reverse tab back end Total: \$785.00 per M in 1000 piece lot Total: 738.00 per M in 2500 piece lot Total: 717.00 per M in 5000 piece lot Total: 709.00 per M in 10 M piece lot 1. lst Form Die	\$ 4300.00 470.00 450.00 490.00 5250.00 470.00 445.00 495.00 1520.00
	10. Alter Slot Die	620.00 470.00 3750.00
	Samples: 7/8 weeks	\$18730.00
	Production start 4 weeks after approval.	

The above Quotation is subject to acceptance within 30 days from date hereof; thereafter, prices are subject to change without notice, according to fluctuation of market prices of material, over which we have no control. We are not responsible for delays in deliveries due to strikes and conditions beyond our control.

Very truly yours,

H & P DIE & STAMPING CO.





Remington Arms Co., Inc. Ilion, N.Y. 13357 To

Attn: D. D. Ricci



Engineering • Development • Tools • Dies • Stampings Sub-Assemblies . Bus Supplies 4650 Tiedeman Road • Cleveland, Ohio 44144

Date April 5, 1983

Terms 1% 10 days-30 days NET F.O.B. Our Plant-Cleveland, Ohio

Gentlemen:

Quantity	Description	Price
	Part Number 91840 Base Permanent .060/.064 stock	
	Total: \$708.00 per M in 1000 piece lot	
	Total: 683.00 per M in 2500 piece lot	
20.50/re	Total: 677.00 per M in 5000 piece lot	
20.50/1	>Total: 668.00 per M in 10 M piece lot	
	1. Alter Blank & Pierce Die	\$ 2280.00
	2. Rework Coin Relief Notch Die	465.00
	3. Rework 1st Form & Start Curl Die	1670.00
	4. Rework U Form Die	1490.00
	5. Rework Cam Trim Die Tabs	735.00
	6. Rework 2 Stations Curl Die	2240.00
	7. Develop & Engineering	2940.00
	TOTAL	\$11820.00
	Samples: 6/7 weeks	
	Production start 3 weeks after approval.	
•		
		1

The above Quotation is subject to acceptance within 30 days from date hereof; thereafter, prices are subject to change without notice, according to fluctuation of market prices of material, over which we have no control. We are not responsible for delays in deliveries due to strikes and conditions beyond our control.

Very truly yours,

H & P DIE & STAMPING CO.

April 18, 1983

Remington Arms
Bridgeport, Connecticut 06602

Attn: Robert R. March Purchasing Agent

Re: Former, Dwg. #E-45992, P.O. # I-82376

Dear Bob:

In reference to your memo of 4/12/83, we have calculated cancellation charges for the subject former, which has been on hold since April 1982. The charges are as follows:

Stock Charge	\$ 350.00
Roughing Charges	935.00
*Fixturing & Set-up	825.00
Carrying Charge	290.00
Total	\$2400.00

*The total fixturing charges were quoted to be distributed equally to this former and the one we completed per your P.O. #I-82374 (completed 10/21/82).

Thank you for the opportunity to resolve this situation. Should you have any questions, please don't hesitate to contact Tim King or myself.

Best Regards,

Doug Price Vice President - Sales

DP/bf

₹D-69-8

REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE

Remington.



xc: C.B. Workman
L.B. Bosquet
D.E. Bullis
S.R. Franz

E. Yetter, Jr.

"CONFINE YOUR LETTER TO ONE SUBJECT ONLY"_

Ilion, New York April 19, 1983

TO:

J.W. BROOKS

FROM:

C.E. RITCHIE

SUBJECT:

MODEL SEVEN THICK FLOORPLATE ASSEMBLIES

A mismatch exists between the Model Seven floorplate base and the magazine box. This mismatch can cause difficulty in loading a fourth round in the magazine. Testing to date indicates the thicker base assemblies greatly aggravate this condition.

Eighty Six (86) guns were built by Production for Research with the thinner assemblies and no magazine loading problems were found. Recently, Research built eight (8) guns with the thicker assemblies and three (3) guns would take only three rounds in the magazine and one other had occasional loading problems. It is, therefore, the Test Lab's recommendation to stop the order for the thick floor plate bases until this condition can be rectified.

CER: js

	•	
OPERATI	ION LOG-	M/7 FLOOR PLATE ASS'Y
	•	OPER \$30 19/APRIL/83
NOTE:	9LL OPER	ATION CYCLES ARE CONSIDERED
		PRODUCED ADEQUATELY TORACED
		ES EXCEPT AS NOTED
CYCLE	TIME	- OBSERVATION
		CYCLE 22 MIN
	START 7:20	WATER PRESSURE ~ 50#
		7. PATED VOLTS - 88
		7. RATED AMPS - 66
		20 RATES KW - 54
		TO ROTTO KUAR - 20 LEAD
3	7:24	FAILURE-LEFT SIDE
		PLATE BOW UPWARD
		BRAZE FLOW DOWNWARD
13	7:47	SAME AS : CYCLE #3
14	7:50	FAILURE LEFT SIDE
•		PLATE BOW TIPWARD
		BRAZE FLOW UPWARD
/8	8:00	FAILURE LEFT SIDE
••		PLATE BOW DOWNWARD
		BRAZE FLOW DOWNWARD
25	STOP 8:21	NO CHANGE AT ZS CYCLES

6466E	TIME	OBSERVATION
26	START 8:41	NO CHANGE
27	8:45	FAILURE RIGHT SIDE
		PLATE BOW DOWNWARD
		BRAZE FLOW DOWNWARD .
30	8:53	FLOOR PLATE BASE SPRUNG;
		BRAZE OK
35	9:04	FLOOR PLATE BASE SPRUNG;
		Braze ok
_3>	9:09	FLOOR PLATE BASE SPRUNG;
		BRAZE OK
4>	9:30	FRILLIRE LEFT SIDE
		PLATE BOW DOWNWARD
		BRAZE FLOW DOWNWARD
50	9:36	NO CHANGE AT SO CYCLES
68	10:25	FAILURE CEST SIDE
		PLATE BOW DOWNWARD
		BRAZE FLOW LIDWARD
75	10:43	NO CHANGE
79	//: 34	FAILURE LEFT SIDE
		PLATE BOW UPWARD
	-	BRAZE FLOW DOWNWARD
	12:00	WATER PRESSURE 75#
_97	12:17	FLOOR PLATE BASE SPRUNG,
<u> </u>		BRAZE OK
100	12:24	NO CHANGE AT 100 CYCLE
	12:30	WATER PRESSURE 50

CYCLE	TIME	OBSER VATION
106	1:00	FAILURE LEFT SIDE
		PLATE BOW LIPWARD
		BERZE FLOW DOWNWARD
125	1:50	FRILURE LEFT SIDE
	·	PLATE BOW DOUNWARD
<u>,,, ,, ,, ,, ,, ,, ,, ,, ,, ,, ,, ,, ,,</u>		BRAZE FLOW CIPWARD
		NO CHANGE AT 125 CYCLES
134	2:14	FAILURE RIGHT SIDE
		PLATE BOW DOWNERD
/		BRAZE FLOW DOWNWARD
/35	Z:/7	FAILURE RIGHT SIDE
		PLATE BOW WALL
		BRAZE FLOW DOWNWARD
145	STOP 2:37	
		P DELLER
		ac :
		19APRIL 83

		·- <u>·</u>
		N-
	1 /	

FLATMESS	TALLY	TOTAL
0	//	2 4
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.003	/	1 100
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. 008	मार भार ।।	12
.009	1111	4
.010	41 HT 11	12
.011	+11T	5
.012	un 1	. 6
-013	1111	4
-014	111	3
.015		1
	X FER PARTS IN TOL ONLY =	PARTS IN TOL =
	.00603	ノフノ
	6 FOR PART IN TOL ONLY =	
	.001811	
		10.5
	X FOR ALL PARTS = . 00667	ALL PARTS = 190
	6 FOR ALL PARTS = .002604	
		R. Decer
		Q.C. Mar. &

		I	1
EATNESS	TALLY	Total	
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.005	80 Pcs		100-
.006	1	1	
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	477447417 -411 11	27	
.009	HIT-ITT HIT HIT HIT	25	
-010	HITHE LIST IIII	19	Y
.01/	HHT 111	8	
-012	///	3	
-013	<i> </i>	3	
.014	1/1	3	
.015	1//	3	
:			
;	ALL PARTS	·	
	X = .00943		
	6 = .00190		
	100 Pcs		
!	700 7 63		
	,		R. Dougz
			0.0
			MAR. 83

TO BE DONE BY REM.

ALTERATIONS TOR THICKER FL. PLATE BASES

FLOOR PLATE BASE

- · MILL, 030 OFF TRIG. GUARD PLATE SURFACE.
 THRU , 635 WIDTH.
- · MILL , OID OFF EACH SIDE OF TAB.
- MILL , 120 FIGURE AT HINGE.

FLOOR PLATE PAD

- . USE SAMPLES . OID THINNER
- · MILL CUT FOR HINGED AREA
- · C'SINK SCREW HEAD AREA

FLOOR PLATE COVER

· COIN OR MILL , 052 DIMENSION AT

STOCK

- . , OID OVERALL MAG. INLET
- · TRIG. GUARD PLATE INCET . 030 DEEPER

XC: \ L. B. Bosquet

J. R. Snedeker R. L. Snedeker

2D-69-8

REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE





"CONFINE YOUR LETTER TO ONE SUBJECT ONLY"_

April 21, 1983

TO:

J. В. MROZ 4.8.М.

FROM: R. C. DELLER

PROBLEM:

Poor yield at operation #30, M/7LWT Floor Plate Base Assembly (Braze) C-91850

PROCEDURE:

- 1. Obtain a sufficient quantity of M/7 trigger guard plates (B-91845).
- Measure and sort the trigger guard plates to M/D flatness tolerance. Enough "Good" plates for an eight (8) hour production shift will be required.
- 3. Using the sorted plates, monitor the braze operation (#30) for a full workshift. Use floor plate bases (C-91840) supplied by the production department.
- 4. Prepare a log of all observations.
- 5. Save all poor braze assemblies for examination by Process Engineering and Trial and Pilot Engineer.

OBSERVATIONS:

- 1. Trigger guard plates generally bow in the same direction. (Concave toward the shiny side)
- Based on two separately sampled lots, flatness of the trigger guard plate to the M/D varies considerably.
- This study had to be delayed while Gage D-46123 was corrected to M/D and P/R tolerances. This generated the need for a new machine capability study to reflect the above changes.

Poor yield at operation #30, M/7 LWT Floor Plate Base Assembly (Braze) C-91850

OBSERVATIONS: Contd.

- 4. Other than an increase in water pressure from 50 to 75, PSI from 1200 to 1230 hrs. all other operating parameters remained constant.
- 5. Failure observations at braze:
 - a. 2/3 failures were left side.1/3 failures were right side.
 - b. Total failures = 12 (8.275%) (Total Pcs. = 145)
 - c. There were equal freq. of failure with plates bowed up and down.
 - d. Braze material flowed downward on 75% of the failures.
 - e. Braze material flowed upward on 25% of the failures.
- 6. Floor plate bases which were sprung out of shape, did not cause any braze failures during the test. (145 cycles with four (4) sprung bases observed)
- 7. Time of day did not appear to affect braze failure.

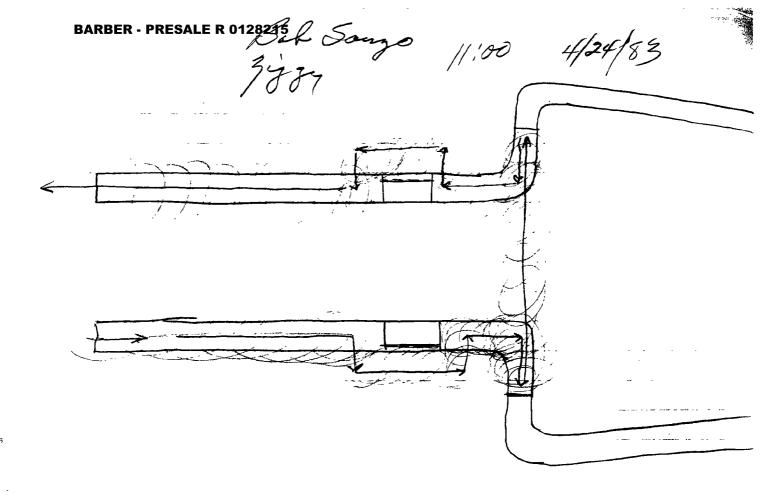
CONCLUSION:

- 1. Braze failure is unpredictable.
- Braze failure appears to happen when braze shim deflects away from the influence of flux and junction of parts being brazed due to the sudden heating.

ATTACHMENTS:

- Measurement tallies trigger guard plate for two lots of plates.
- Operation log M/7 LWT floor plate ass'y, operation #30.

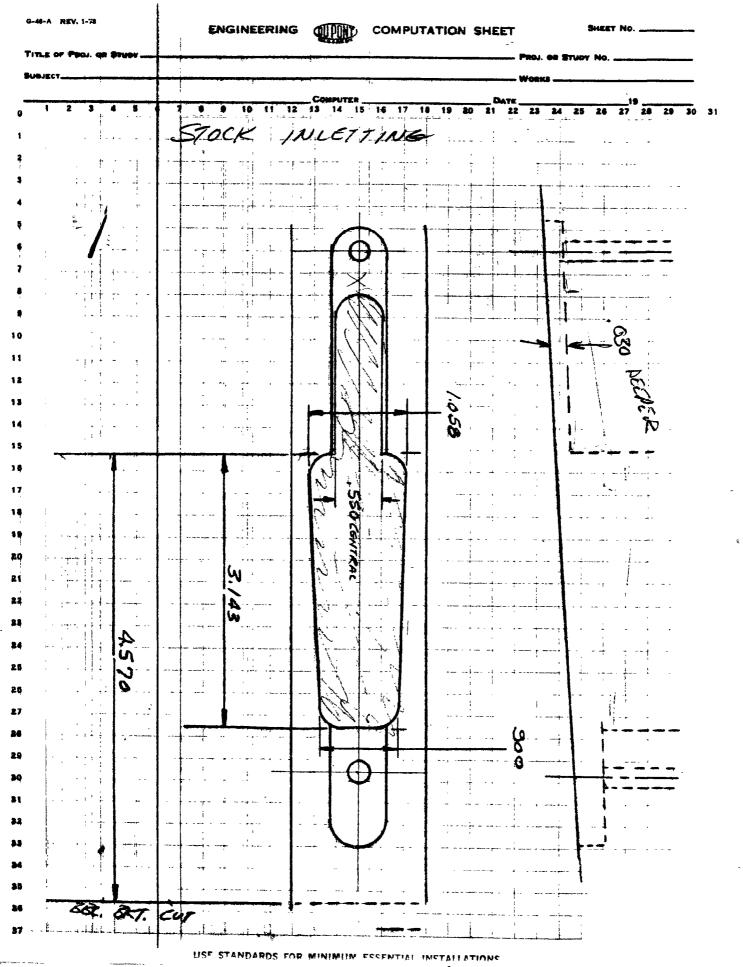
RCD/cac



Publem 1011 prèces made on temperary tooling will require
some modification by Cennington.

But fall the N/C group can do the required modification to the F.P. Bare - will have answer by 4/29 - willprobably use Mataura willrequire: · some sock of fixture

BARBER - PRESALE R 0128216



xc: G. D. Campbell

D. J. Anderson

RD-49-B

REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE



DETERS

"CONFINE YOUR LETTER TO ONE SUBJECT ONLY"_____

April 26, 1983

J. P. LINDE

MODIFICATIONS REQUIRED TO MODEL SEVEN LIGHTWEIGHT COMPONENTS

BEING PRODUCED ON TEMPORARY VENDOR TOOLING.

FLOOR PLATE BASE

The Research N/C group has been contacted to use the Matsura to remove additional material from this compo- N P Process nent to allow use of a thicker Trigger Guard Plate. A Research N/C fixture, program, and operator will be required. Ball

Production

Hinge clearance cut must be milled deeper to permit N P Process proper functioning of the thicker Floor Plate Cover. Production

It may be necessary to deepen the countersink to provide proper seating of the Take Down Screw.

Research N P Process Production

FLOOR PLATE COVER

A slight mill cut must be added to ensure proper N P Process functioning of the Floor Plate Latch.

Production

FLOOR PLATE PAD

This part must be thinner and the hinge clearance larger to accomodate the thicker Floor Plate Base. Powder Metal to be contacted to press 10M pieces to the thinner platform dimension. A milling operation will be set up to enlarge the hinge clearance. Research has a form cutter. A set of vise jaws will be designed and built.

N P Process Powder Metal Production

STOCK INLETTING

A revised tape has been prepared and approximately 200 Stocks have been run with revised inletting.

N P Process Chem. & Met. Production

L. B. Bosquet

xc: G. D. Campbell

D. J. Anderson

RD-49-8

REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE

Remineton OF THE PARTY OF TH

"CONFINE YOUR LETTER TO ONE SUBJECT ONLY"_____

April 26, 1983

J. P. LINDE

SUBJECT:

MODIFICATIONS REQUIRED TO MODEL SEVEN LIGHTWEIGHT COMPONENTS BEING PRODUCED ON TEMPORARY VENDOR TOOLING.

FLOOR PLATE BASE - need intermediate dung à number

The Research N/C group has been contacted to use the Matsura to remove additional material from this compo- N P Process nent to allow use of a thicker Trigger Guard Plate. A Research N/C fixture, program, and operator will be required.

Hinge clearance cut must be milled deeper to permit N P Process proper functioning of the thicker Floor Plate Cover. Production

It may be necessary to deepen the countersink to provide proper seating of the Take Down Screw.

Research N P Process Production

FLOOR PLATE COVER - transmit find design

A slight mill cut must be added to ensure proper functioning of the Floor Plate Latch.

Production

Production

PLATE PAD

Production

Production

Tolking - results in part on the plank in planty of time

N P Process

FLOOR PLATE PAD

This part must be thinner and the hinge clearance larger to accomodate the thicker Floor Plate Base. Powder Metal to be contacted to press 10M pieces to the thinner platform dimension. A milling operation will be set up to enlarge the hinge clearance. Research has a form cutter. A set of vise jaws will Powder Metal

N P Process

be designed and built.

Plar con lane set (after 2 new 1) ready in

STOCK INLETTING

The confidence of the formula of the transmitted of the transmitted of the formula of 200 Stocks have been run with revised inletting.

Chem. & Met. Production

L. B. Bosquet

ff. LBB: hf Vrijger Juan Plate

Februar Plate Part

Com't increase bringe clearance without:

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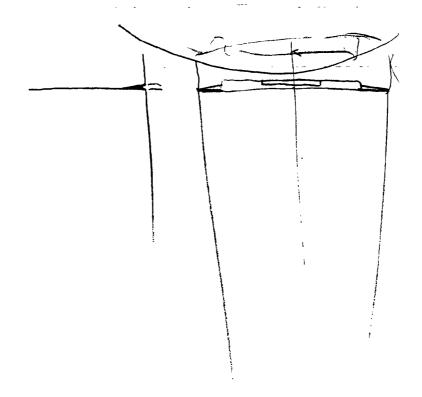
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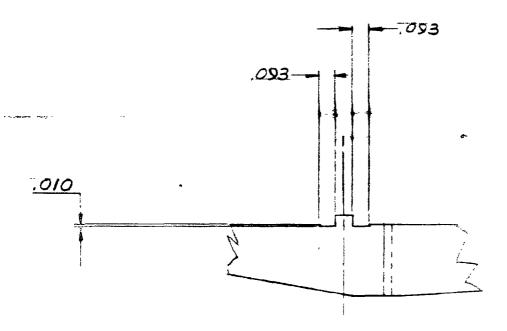
Can't increase bringe clearance wi

propried

30 PM







BARBER - PRESALE R 0128222 4/26/23 U judet Even nut - Redesign SB. Status L.E. Bosouet, J.W. Rpooles * Transmit ASAP _ D.D. Ricei , C.D. Eswitt * Cores C 92721 (heed blank #) allied can up-date tooling for 1300. - 2 weeks. Brad to verify to Dwayne that Extra time is ok; heed recusition Latch Spring B92722 due in 2 week = (5/9) 250 prototypes on order as ded . so E din . 100 dia the same Final design pending test. (for permanent tools) reld recuisition * Trigger quard Plate B92718 Source to produce 10,000 pcs on permanent tools need repuisition Trigger Juard Blank C92719

024/.033 din from base line to tab replaces .034-032? All other dimensions the same as marked grunt for

10,000 temporary justo (XC 92249)

need recuisition

(2) Model Seren LWT-Redesign

Floor Plate Base C92720 Weed blank #

Need intermediate humber for 10,000 pcs

on temporary tools (parts are received already

as # 92256)

Boxes must be remarked to new #.

heed requisition.

How flate Rad Blank C92449 (marked print)

P/M needs 5 weeks ARO to change radius from

.110 to .120.

Interins parts might heed to bane .120 R milled

Brad to check schedule for heed.

(P/M needs & 6 weeks to design & hild I new set of I have purely to growind parts to latest design die would have to be sent int for fitting of punch set. 5/2/83

Model Seven Lat.

- · dip at rear of bottom inletting whech w/ Dane & Ball
- · hend or put detent in detch converge area of Film Blete lover ______
- · coin or champer edge of Lugger June Plate
- · Latch can reach point where it comed more any further freward.
- · Katch Spring: what is rendon holding on spread or mydning?

BARBER - PRESALE R 0128225

POWDER METAL

		 .,,
_	- -	 F (0 (0)

PURCHASE REQUISITION

PURCHASE		
ORDER NO		

DATE ISSUED	5/2/83					
		THIS BLOCK FOR PURCHASING DE	PT USE ONLY		•	~
,	POWDER METAL PROD		,			
STREET NO		CITY	STATE	Z	IP CODE	
CONTACT PERS	60N		TELEPH	HONE NO		
QUOTATION RE	FERENCE: <u>Verbal</u> (F	R.F.Decker)			CRITI	
SHIP VIA	F.O.B.		TERMS		EXEN	ABLE [
SPECIF	ICATIONS MUST BE CLEARLY	NOTICE TO WRIT STATED GIVING WHENEVER		LOGUE MACHIN	E NUMBERS, E	ETC.
QUANTITY		DESCRIPTION		PRICE	DISCOUNT %	DELIVERY WANTED
1	Complete set of	lower punches to	fit exist	ng		
_ .	die for Model S	EVEN LWT Floor Pla	te Pad Bl	ank		
	C-92449 (to ads	wance print provide	d al			ļ
	C 92728 ALT	-#7)	-	\$1000.00		6/6/8
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	Service					
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ITEM NO.	CHARGE ACCOUNT	WORK ORDER	DE	LIVER TO BLDG.	NO.	
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	1 C	90290		JED BY Sper PROVED BY	cer Renn	ett 🍇
SON THE STATE OF T						

QUOTATION

ALLIED TOOL & DIE, INC.

16146 PURITAS AVE. -:- CLEVELAND, OHIO 44135
Phone: 941-6196

TO:

REMINGTON ARMS CO. ILION, N.Y. 13357 ATTN: MR. DWAINE RICCI Date MAY 4,1983

Gentlemen:

As per your request, we hereby quote you as follows.

Dwg./Part #	Description		Price (Pb
92255 Son't saap -	FLOOR PLATE COVER BLANKS: TO CHANGE PROGRESSIVE DIE TO .062 MATER SCRAP OUT 1185 LBS. OF .062 MATERIAL LESS SCRAP ALLOWANCE (\$50.40 LONG TON) COST TO REVERT PROGRESSIVE DIE BACK TO .052 MATERIAL	IAL SUB-TOTAL SUB-TOTAL TOTAL COST	\$ 2,800.00 per 1.52 \$ 511.52 \$ - 26.66 \$ 3,284.86 \$ 580.00 \$ 3,864.86
	NEWPIECE PRICE FOR 10 M PCS. PER 1 M PC / week for to reme of 1-2 weeks	s. outo sourced 5/11	\$ 8 9.50

Terms: Net 10 days.

This quotation is subject to terms and conditions printed on the reverse side of this sheet and becomes part of your order unless otherwise noted.

Yours truly,

ALLIED TOOL & DIE, INC.

PRICE SUBJECT TO CHANGE DUE TO POSSIBLE MATERIAL AND SERVICE PRICE INCREASES.

TERMS AND CONDITIONS OF SALE FOR SPECIAL TOOLING.

This quotation is subject to acceptance within thirty (30) days.

Deliveries are determined from the date of receipt of written purchase order or receipt of material if you are to furnish, whichever is the later. Every effort will be made to deliver as promised. No responsibility is assumed for any delays.

It is understood that there are no conditions or agreements outside of this written proposal; and that all prior conversations, agreements, or representations with reference to its subject matter are hereby superseded. Clerical errors are subject to correction.

Any tax imposed by any present or future law on the sale of the articles covered hereby shall be added to the amount to be paid.

Our terms are net 10 days, f.o.b. our Plant. All sizable and/or long delivery orders are subject to monthly invoicing as the work progresses.

ALL ORDERS ARE ACCEPTED WITH THE FOLLOWING CONDITIONS:

- a. All orders are not subject to cancellation nor deferment of shipment when ready unless we are indemnified against loss resulting therefrom, and further, the Allied Tool & Die Company shall not be responsible for delays or nonperformance caused by strikes, fires, or other causes beyond our control.
- b. The Customer shall defend, at his own expense, any suit which shall be brought against us by reason of the manufacture or sale of special parts made to the Customer's specifications.
- c. The Allied Tool & Die Company shall have the right to stop work at any time and withhold deliveries of any or all of the goods ordered and property relating to said work, if any payment herein stipulated is not made promptly as agreed or upon proof of Customer's inability to pay as agreed and thereupon the selling price of hours and material in process at such date shall be due and payable.
- d. The Customer will allow extra charges for authorized changes.
- e. The Customer will have a responsible member of his company approve all designs made by us. We will correct any errors in our designs mutually agreed upon, but we will assume no liability for corrections to the designed product.
- f. The Allied Tool & Die Company will not be responsible for product performance where the product is manufactured to the Customer's own design, prints, or specifications.
- g. The Allied Tool & Die Company's liability for defective work or material shall be confined solely to replacement or repair of defective goods.
- h. The Allied Tool & Die Company reserves the right to correct errors in our products. No charges for repair will be accepted without our written authorization.
- i. The Allied Tool & Die Company shall have the right to scrap without liability prints submitted for quotation, patterns, special tools, and designs used in the manufacture of material herein quoted unless notice is given to ship these items with the completed product or within 30 days of completion of the order.

f156 5-9-83

MODEL SUNGE LIGHTWEIGHT ELIMINATION OF FPO FOR 305 AND THIT-08

OBJECTIVE:

IMPLEMENT PROPOSED DESIGN REVISIONS (WHEN AVAILABLE)
TO THE TRIGGER GUARD AND FLOOR PLATE COMPONENTS
WITHOUT DISRUPTING PRODUCTION SCHEDULE.

STATUS:

THE REVISED PRODUCTION SCHEDULE CALLS FOR PRODUCING
THIS YEAR'S FORECAST FOR GMM, 243, AND 222 WITHOUT
INTERRUPTION. THIS STRATEGY ESTABLISHES A NEW TARGET
DATE OF 9/1 FOR RESUMING FINAL ASSEMBLY OF 308 AND
7MM-08.

A PROPOSED DESIGN CHANGE MUST BE AVAILABLE BY 6/13
IN ORDER TO HAVE OUR VENDORS SUPPLY PARTS FROM
TEMPORARY TOOLING TO MEET THE 9/1 DATE.

ATTACHED IS THE PROPOSED SCHEDULE FOR GACH COMPONENT

MODEL SEVEN LIGHTWEIGHT - REVISED SCHEDULE THICKER MATURIAL-FLOOR PLATE BASE, ETC.

· ASSUMPTIONS:

- A CHANGE WILL BE MADE TO USE THICKER MATERIAL.
- THE 1982 FORECAST FOR . 243, 6 MM, AND 222 WILL BE
- START UP OF FINAL ASSUMBLY FOR 308 \$ 7 MM-08 WILL

 BE THE FIRST OF CEPTEMBER
- FINALIZED DESIGN WILL BE SIMILAR TO THAT

 PROPOSED IN APRIL
- FINALIZED DESIGN WILL ALLOW VENDORS TO USE

 MOST OF THEIR PERMANENT TOOLING WITH SOME

 TEMPORARY TOOLING NECUSARY

- Two week SHUTDOWN NOT CONSIDERED	COMPLETION		
	GOAL	LATE	
· VERIFY REVISED DESIGN AND TRANSMIT	7-11	8-17	
FLOOR PLATE LATEN SPRING			
- PLACE ORDER FOR 10M PARTS	6-13	7-28	
ON TOMPORARY TOOLS			
- VENDOR SHIP ION PARTS	7-11	8-31	
- RELEASE VENDOR TO REVISE	7-11	8-17	
PERMANENT FOOLING			
- VENDOR MODIEY FOOLING AND	8-24	10-24	
SUBMIT SAMPLES			
- INSPECT SAMPLES AND RELEASE	8-31	10-31	
VENDOR			
- VENDOR SHIP FIRST PRODUCTION	9-15	11-14	
/.a			

	-GOAL	LATE
· FLOOR PLATES COVER		
- OLDER 10M PIECES - REQUIRES	6-13	6-29
ALTERATION TO PERHANGINT TOOLS		
- VENDOR HAS 1185 /bs OF. OGZ MAT'L. ON HAND	6-27	7-13
- VENDOR ALTER PERMANENT TOOLS	7-11	7-27
AND SUPPLY SAMPLES		
- Inspect samples and Release	7-18	8-3
VGNPOR		
- VENDOR SHIP FIRST PRODUCTION	8-1	8-18
Ler		
- COMPLETE SECONDARY OFERATIONS	8-15	8-31
· FLOOR PLATE BASE		
- PLACE DADER FOR IOM BLANKS	6-13	7-21
ON TOTAPORARY TOOLS - VENTOR HAS GGGGGGG MAT'L ON ORDER-DUE & 6-6		·
- VIENDOR SHIP IO M BLANKS	7-11	8-19
- COMPLETE SECONDARY OPERATIONS	7-21	8-31
- VENDOR ALTER PERMANENT TOOLING	8-17	9-28
AND SUPPLY SAMPLES		
- INSPECT SAMPLES AND RELUASE	8.24	10-5
VENDOR		
- VENDER SHIP FIRST PRODUCTION	9-14	11-2
LOT OF BLANKS		
- COMPLETE SECONDARY OPERATIONS	9-26	11-14

	GOAL	LATE
· TRIGGER GUARD		
- ORDER 10H PARTS ON TEMPORARY	6-13	6-27
TOOLS		
- VGNDOR SHIP IOM PARTS	7-18	8-1
- COMPLUTE SECONDARY OPERATIONS	8-1	8-31
- VENDOR ALTER PERMANENT TOOLS	9-14	9-28
AND SUPPLY BAMPLES	•	
- INSPECT SAMPLES AND RELEASE	9-21	10-5
VENDOR		
- VENDOR SHIP FIRST PRODUCTION	10-5	11-2
Lor		
- COMPLETE SECONDARY OPERATIONS	10-31	11-14
* TRIGGER GUARD PLATE		
- PLACE ORDER FOR IOM PARTS ON	6-13	7-21
TOMPORARY TOOLS		
- VENDOR PURCHASE THICKUR MATERIAL	6-27	8-4
- VENDOR SHIP 10 M PARTS	7-11	8-19
- COMPLETE SECONDARY OPERATIONS	7-21	8-31
- RELEASE VENDOR TO ALTER	7-12	8.30
PURMANUNT FOOLING		
- VENDOR ALTER PERMANENT TOOLS	8-10	9-28
AND SUPPLY SAMPLES		
- INSPECT SAMPLES AND RELEASE	8-17	10-5
VENDOR		
- VENDOR SHIP FIRST PRODUCTION	9-15	11-2
10 F		
- COMPLETE SECONDARY OFERATIONS	9-27	11-14

GOAL LATE

· FLOOR PLATE PAD

- RELEASE PIM TO DESIGN AND

BUILD NEW LOWER PUNCH SET

OR

RELEASE P/M TO DESIGN AND BUILD

NEW TOOLS COMPLETE

- P/M RUN 10 M PARTS ON REVISED

TOOLING,

25

PIM RUN IOM PARTS ON NUTE TOOLS

- INSPECT AND RULUASU P/M
- COMPLETE SECONDARY OPERATIONS

. HBB 5-9-8**3**

MODER SUVER LIGHTWEIGHT TRIGGER GUARD - FLOOR PLANS ASSIV.

· DIE CAST PROPOSAL	
- QUOTED IN BIE ALLOY	•
- TIME LING FROM FIRM DESIGN :	
- VENDOR QUOTE FIRMED UP TO ** ** ** ** ** ** ** ** ** ** ** ** **	
FINAL DUSIGN SPART WHILE QUOTE BEING FIRMED	2 WEEKS*
- VGHDOR BUILD TOOLING AND	
SUBMIT SAMPLES	16 WEEKS
- INSPECT SAMPLES	/ Wask
- REVISE. TOOLING & SUISHIT	
SAMPLES 4 WOUNTS	,
- INSPECT SAMPLES AND RULLINSS	
VENDOR	I WOUN
- FIRST PRODUCTION SHIPMENT	
(I WEEK TRANSIT TIME INCLUDED)	5 WEEKS
	23-29 WKS
	\$33,000
- PRODUCTION TOOLING	
DUSIGN & 1300 HRS (ASSUME 4 DUSIGNERS)	A 8 wards
BUILD ~ 30 27 HRS	12-14 WEEKS
- PROCESSING (IM-PLANT)	1-2 works

- TOTAL ESTIMATED LEAD TIME FROM FIRM

DESIGN TO PRODUCTION PARTS AT FINALASSIMALY

6-7 MONTHS

- INVESTMENT BAST PROPOSAL

- QUETED 1040 STEEL, ANNEALED &

CARBON RUSTORUD

- ESTIMATED TIME LINE FROM FIRM DESIGN:

- VENDOR QUOTE FIRMED UP TO FINAL TO DUSIGN (COULD GIVE APPROVAL TO START

WHILE QUOTE BUING FIRMED UP)

- VENDOR BUILD TOOLING AND SUBHIT

SAMPLES.

8-10 weeks

2000000

- INSPECT SAMPLES

ا سه محيير

- IF NECESSARY - REVISE FOOLING AND

SUBMIT NEW SAMPLES

- INSPECT SAMPLES AND RELEASE VENDOR

1 665

- FIRST PRODUCTION SHIPHENT

16 00 00015

26-34 WEEKS \$ 18,000

- PRODUCTION TOOLING

ASSUME ABOUT THE SAME AS THE

DIG CASTING

20-24 williams

- PROCESSING (IN-PLANT)

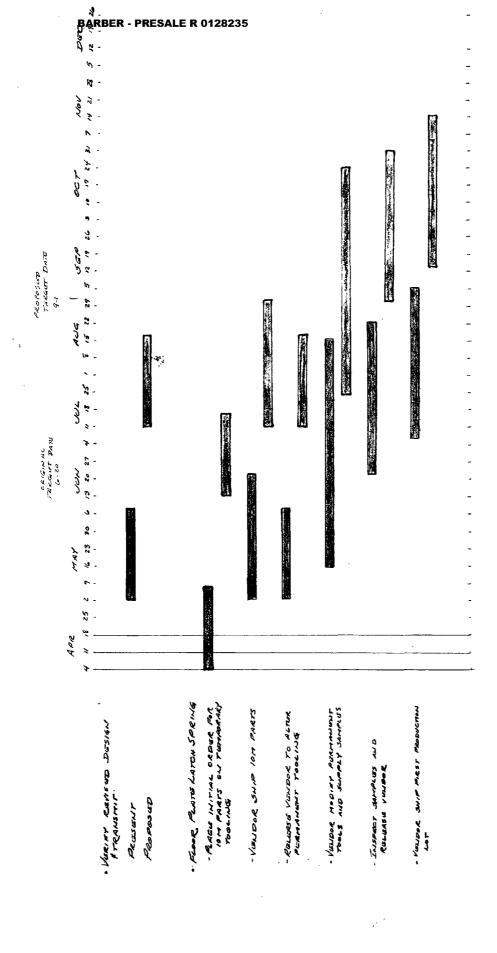
1-2 words

- TOTAL ESTIMATED LUAD TIME FROM FIRM

DISSIGN TO PRODUCTION PARTS AT

FINAL ASSEMBLY

7-9 MONTHS



BARBEI FORM RD 15A REV 1,	_ \	236 PURCHASE REQUIS		DISTORE	HASE R NO.	
DATE ISSUED _5	/11/83					, (F
		THIS BLOCK FOR PURCHASING DEPT. L				
PLACED ONA	LLIED TOOL & DIE	<u> </u>				
STREET NO		CITY	STATE	Z	IP CODE	
CONTACT PERS	ON		TELEPHO	NE NO		
QUOTATION RE	FERENCE:	·			ORDE	R STATUS
SHIP VIA	F.O.B	TERI	MS		TAXA	BLE □
SPECIFI		NOTICE TO WRITER Y STATED GIVING WHENEVER POS	SIBLE CATAL	OGUE MACHIN	IE NUMBERS, E	TC.
QUANTITY		DESCRIPTION		PRICE	DISCOUNT %	DELIVERY WANTED
	Cost to revert	permanent tooling fo	r Floor	\$580.00		
	Plate Blank #9	2255 back to handle .	052 mat	1		
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		REASON: LOWEST PRICE - OT	HER 🗆			
ITEM NO.	CHARGE ACCOUNT	WORK ORDER	DELI	VER TO BLDG.	NO.	
			[FY MR.	Bennett	
			1	D BY	Bosquet A	136
			APPF	ROVED BY	-	

BARBER - PRESALE R 0128237 FORM RD 15A REV 1, 12-81 PURCHASE REQUISITION ORDER NO. DATE ISSUED __ 5/11/83 THIS BLOCK FOR PURCHASING DEPT. USE ONLY PLACED ON ALLIED TOOL & DIE ______ CITY ______ STATE _____ ZIP CODE _ CONTACT PERSON ___ _____ TELEPHONE NO. ____ ORDER STATUS CRITICAL | TAXABLE [SHIP VIA __ F.O.B. ___ _____TERMS _ EXEMPT NOTICE TO WRITER SPECIFICATIONS MUST BE CLEARLY STATED GIVING WHENEVER POSSIBLE CATALOGUE MACHINE NUMBERS, ETC. **DELIVERY** QUANTITY PRICE DISCOUNT % DESCRIPTION WANTED Cost to alter permanent tooling to make Floor Plate Cover Blank #92255 out of .062 thick material \$2800.00 REASON: LOWEST PRICE - OTHER -ITEM NO. CHARGE ACCOUNT WORK ORDER DELIVER TO BLDG. NO. NOTIFY MR. S.D.Bennett ISSUED BY L.B.Bosquet

APPROVED BY

BARBER - PRESALE R 0128238 **PURCHASE** PURCHASE REQUISITION ORDER NO. DATE ISSUED _5/11/83 THIS BLOCK FOR PURCHASING DEPT USE ONLY PLACED ON H & P DIE & STAMPING _____ CITY _____ STATE ____ ZIP CODE_ STREET NO. _ CONTACT PERSON ___ _____ TELEPHONE NO. _____ ORDER STATUS QUOTATION REFERENCE: ___ CRITICAL [] TAXABLE SHIP VIA __ ____ F.O.B. ____ _____TERMS ___ EXEMPT NOTICE TO WRITER SPECIFICATIONS MUST BE CLEARLY STATED GIVING WHENEVER POSSIBLE CATALOGUE MACHINE NUMBERS, ETC. CELIVERY QUANTITY DESCRIPTION PRICE DISCOUNT % WANTED To cover cost of temporary tooling to increase locking tab dim. by .036 and to reverse the angle at the rear take down screw hole on \$1175.00 Trigger Guard Blank #92249 (marked print) To cover the cost of 10M Trigger Guard Blanks to be produced on above temporary tooling \$9750.00 at \$975 00/M per marked print REASON: LOWEST PRICE . OTHER .

ISSUED BY L. B. B.	. Bennett	NOTIFY MR. S. D.		
	. Bosquet #35	ISSUED BY L. B.		
APPROVED BY		APPROVED BY		

RD-49-5

REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE

Xc: L. B. Bosquet R. C. Bottini

File: Proposal 1011

Remington.

PETERS

"CONFINE YOUR LETTER TO ONE SUBJECT ONLY"_____

May 10, 1983

TO:

R. J. LONG

FROM:

D. J. ANDERSON

RE:

MODEL SEVEN LWT - .223 CALIBER

The above project has been accepted by the Operations Committee and a trial and pilot lot of 100 pieces is required for August assembly.

Please make whatever arrangements necessary. Barrel blanks have been completed through the GFM today.

DJA:hv

BARBER - PRESALE R 0128240

REHINGTON ARMS COMPANY, INC.

Distribution: C. B. Workman

J. P. Linde

J. Brooks C. E. Ritchie

"CONFINE YOUR LETTER TO ONE SUBJECT ONLY"_

RESEARCH TEST and MEASUREMENT REPORT - Raport No. 831361

MODEL SEVEN - .222 CALIBER TRIAL & PILOT EVALUATION

1. 0. J. Handenson Q 5/20 2. L. B. Besquer \$36 3/27

3. P. C. JOHNSON

4. J. Links

Prepared by:

C. E. Ritchie

Propinsad and Casted By:

Signature

Lare

C.E. Ritchie,

Sr. Supervisor - Testing,

Meas. & Mech. Analysis Lab

REPORT NUMBER: 831361

TEST & MEASUREMENT LAB REPORT

REPORT TITLE:	Model Seven — .222 Caliber Trial & Pilot Evaluation	
MCDEL(S):	Seven	
gauge or caliber:	.222	
DATE:	5-16-83	
WORK ORDER NO.:	81343-904	
PART NAME:		
DESIGNER/ENGINEER:	G. Hill/J. W. Brooks	
TEST TYPE:		
1.	PHOTO LAB	
2.	STRENGTH TEST - NO. OF GUNS TESTED	
3.	FUNCTION TEST - NO. OF GUNS TESTED	
4.	ACCURACY TEST - NO. OF GUNS TESTED	
5.	MEASUREMENTS - TYPE:	
6.	ENVIRONMENTAL TEST	
7.	AMMUNITION TESTING & EVALUATION - TYPE:	
8.	VISUAL EVALUATION - 8 OUT OF 40 GUN SAMPLE	
9.	ENDURANCE - NO. OF GUNS TESTED:	
	NO. CF ROUNDS PER GUN:	
	TOTAL ROUNDS FIRED IN TEST:	
	AMMO TYPE: MAGS TARGET:	
	RIM FIRECENTER FIRE	

BARBER - PRESALE R 0128242

REMINGTON ARMS CO., INC. Firearms Research Division

Report No. 831361 Page 1

May 18, 1983

TO:

C. B. WORKMAN

FROM:

C. E. RITCHIE

REPORT TITLE:

MODEL SEVEN - .222 CALIBER TRIAL & PILOT EVALUATION

ABSTRACT

A request was received from G. Hill, Supervisor, Process Engineering, to perform a Trial & Pilot evaluation of the Model Seven .222 Caliber production firearm.

SCOPE OF WORK

Perform a Trial & Pilot evaluation on an 8 gun sample from a 40 gun production run.

TEST RESULTS

Only a Visual Inspection was performed. The sample lot was rejected due to the following:

- 1.) 3 of the 8 guns had been assembled using old style unheat treated trigger guards with the tab bent in the old position (upwards).
- 2.) 1 stock was cracked.

M/Seven - .222 Caliber Trial & Pilot Evaluation

Report No. 831361 Page 2

REPORT TEXT

Of the 8 firearms inspected, the following major objections were pointed out:

- 1.) 3 of the 8 guns had been assembled using old style unheat treated trigger guards with tabs bent in the old position (upwards).
- 2.) I stock was cracked (beginning at the floor plate tab and running about 34" towards the muzzle of the gun).

These objections were the basis for rejection of this sample lot. No other physical testing was performed on the sample.

TEST PROCEDURE

An eight gun sample was selected by Charles Stephens, Research Test Lab, from a 40 gun production run.

A visual inspection was conducted in the Test Lab on 5-17-83 at 1:00 p.m. by Z. Kowalski, Process Engineering, D. Bullis, Current Firearms Design, R. Nightingale and E. Ritchie, Test Lab. Guns were wiped down with a clean cloth and inspected by each member of the committee and comments were recorded. Comments on individual guns can be found in the Appendix.

BARBER - PRESALE R 0128244

M/Seven - .222 Caliber Trial & Pilot Evaluation

Report No. 831361

APPENDIX

Visual Inspection — T & P Evaluation M/Seven .222 Cal.

7602556

- rear swivel screw hole not properly aligned.
- floor plate cover exceeds .026" gap .
- grip cap over polished to mis-shape the cap.

7602642

- front swivel screw bright mark on dome and hole not properly-aligned.
- dent in top of stock

7602629

- 2 pin holes and 1 dent in stock.
- light checkering on pistol grip both sides.
- trigger guard used has tab bent in the old directior (appears not to be heat-treated).

7602508

- excess space between floor plate pad and inlet cut in stock.

7602651

- comb cut (left side) is mis-shaped.
- wood inlet rear of trigger guard impression of trigger guard in wood screw hole probably mis-aligned.
- 2 pin holes in the bottom of the fore-end area.
- light checkering pistol grip area both sides.

7602631

- 2 dents in pistol grip.
- dent on left top rail of stock.
- bottom of comb is mis-shaped 3 flats.
- trigger guard used has tab bent in the old direction (appears not to be heat-treated).

7602637

- cracked stock - starts at floor plate pad.

Report No. 831361 Page 4

M/Seven - .222 Caliber Trial & Pilot Evaluation

7602605

- sight screw hole marred on rear sight.
- rear trigger guard screw marred.
- dent in floor plate pad.
- scratch on the floor plate cover.
- dent in top of the stock.
- trigger guard used has tab bent in the old direction (appears not to be heat-treated.)

- General Note 1.) Barrel bracket on all guns were duil finished.
 - 2.) Ejection port radius on the stock are all 3/16" radius drawing calls for 3/8" radius.

BARBER -	PRESALE	R 0128247

RD-6738 Rev. 380

DCR

Sheet ___/_ of __/

DESIGN CHANGE REQUEST (DCR) OR

TRANSMITTAL OF DRAWINGS / PARTS LIST

Requested By	Ch	Changed By Date		
Research	P. Nasupany		7/5/33	
Originating Date		Transmittal Date		
7/5/83		7-12-	· 83	

Model		Part Name / List	Drawing No.	Part No.
LWT	Barrel Assembly Complete		B-21460	21465
1 11	Barrel Assembly		D-3499	
ti (/	Barrel		D-3272	
, , ,		T Sheets I Tary 3		
Dwg. No.	Rev. No.	Design (Change	· · · · · · · · · · · · · · · · · · ·
21460	1 A	dded 223 Rem. calibe	¬.	
-34990	3	11 \11 11		
-3+745	5	11 10 10 U		
11	6 Ad	ded Part No. 32730 &	LA 507.	
ARTS LIS	T A	Ided 123 Rem cal. 7	To Parts 1/st	CheeTs 1-24
() Appears NOTE: A Co th	ny or all of the all ommittee and app e above changes	pove changes to current models requi proval of DCR by Div. Manager. On require approval of Div. Manager ON	Designer Signa	Ture / Land
Reason for	Change: A	1d 223 Rem. cal	ber per oper	ration
Commi	Hee min	uter of may 2	5 19'83 mei	ting
Disposition () Scrap	of Parts on Hand () Alter	i:(check below) () Use Inventory () RD 6589 Attached	
APPROVED	0.1			t is either scrapped or a

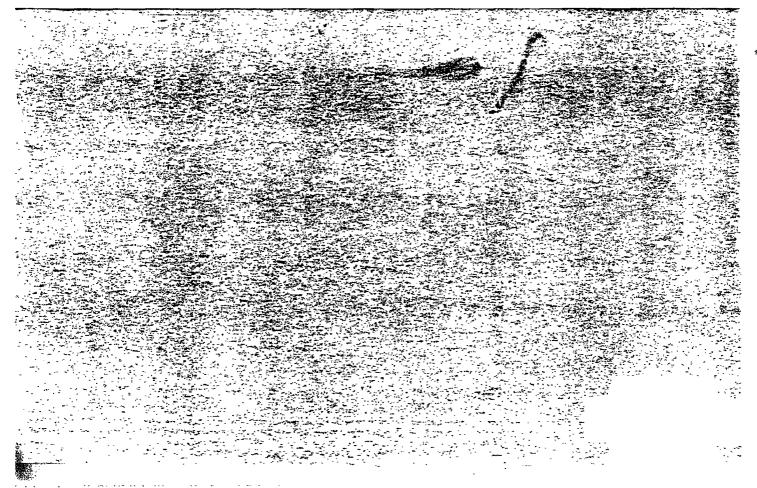
G-88

DON'T SAY IT-WRITE IT

Date 10/18/83 TO FRANK WRISLEY PLEASE RELEASE THE OPTI-SAND FORMER FOR BUILD.

COMMENT: PRODUCTION

"YOUR SAFETY ATTENTION MEANS ACCIDENT PREVENTION



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

TE 10-	21-83 COMPO	10-21-83 COMPUTER R.J. OEF			83 COMPUTER K.J. OFF SHEET / OF /			
IR).	OPERATION NAM		MACHINE	DEPT. NO.		HOUR!		
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SPOR	ETSMAN 12		OPTI-SAND	04	270	1400 #4600		
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6568	1-18-63	TOTAL			715	3 <u>870</u>		

PROCESS ENGINEERING ESTIMATE - TRIAL AND PILOT SHEET • COMPUTATION •

PERATION COTIC SAND MECHANE SEND COMPLETE OPER NO. LOW ACHINE RUCKER MAN OFFICEND DEPT NO. LOW OPERATOR DEPT N	IODEL PI 12 COMPONENT S	TO CK		_PART NO.	
SMEET JORE DATE 10-21-63 TOOLING DRAWING REMARKS HOURS HOURS FORLOWS FASSIGNTIONS FORLOWS FASSIGNTIONS FOLLOWS WHEEL (RICHARDS ON TO LUCKERMAN) FULLOW REMARKS FOLLOW RECKERMAN) FULLOW RECKERMAN	PERATION (DDTI- SAND) MACHIN	E SAND COMPL	STE	OPEF	R. NO
TOOLING DRAWING REMARKS DESIGN HOURS FORDER FARRICATION: FOLDOWER WHEEL (RICHARDSONTE ZUCKERMAN) FULLER BODY (RICHARDSON TO JUNE BODY (RICHARDSON	ACHINE QUEKERMAN OPT	FSAND		DEP	Г. NO. <u>–24</u> –
TOOLING NUMBER NEMARKS DESIGN BUILD FORMER FARRICATIONS FOLLOWER WAREL (RICHARDSON'TE ZUCKERMAN) FULLER DODY (RICHARDSON'TE ZUCKERMAN	COMPUTER X.J. ORF	DATE <u>/0 - 21 - 83</u>		SHEET	<u> </u>
FOLLOWER WHEEL (RICHARDS ON TO ZUCKERMAN) WEN 15 45 WILLIAR DADY (RICHARDS ON TO ZUCKERMAN) WEN 20 55 DUCKERMAN WEN 20 55 DUCKERMAN PREP & FARRICATION PREP & FARRICATION PREP & FARRICATION O STEEL BLANK THIS & FARRICATION PREP & FARRICATION WEN TORKER FOR CARVE TREP & FARRICATION MATSRATIONS SUB-TOTAL 115 420 SKETCH SKETCH	TOOLING		REMARKS	HOURS DESIGN	
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PROCESS ENGINEERING ESTIMATE - TRIAL AND PILOT SHEET • COMPUTATION •

PERATION (OPTI-SAND) MACHINE SAND	COMPLIETE		_PART NO. OPER	. NO. 100
ODEL SPT 12 COMPONENT STOCK PERATION (OPTI-SAND) MACHINE SAND ACHINE SAND			DEPT	NO09
COMPUTER R. J. ORF DATE	10-21-83		SHEET _3	OF _Z
TOOLING	DRAWING NUMBER	REMARKS	HOURS DESIGN	HOURS BUILD
SUB TOTAL			115	420 40
PART FABRICATION!				
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BUTT LOCATORS & CENTERS	0	8 Rea	15	270 TO
FORMER DRIVER	0	Rea	15	45
FORMER CENTER	0	Pess	15	45
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BASE GAGE (POCITION OF GRIP)	T _E F	1 REXU	40	140
SPEED PREED CAME	76	I ÇA.	5	20
MACHINE LAYOUT	F-TS-7039	0	25	
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				4.45
TOTAL			270	1400
SKETCH				44600

PROCESS ENGINEERING ESTIMATE - TRIAL AND PILOT SHEET • COMPUTATION •

MODEL SPT-74874 COMPONENT STOCK	<u> </u>		PART NO.	10.2
OPERATION (OPTI-SAND) MACHINE SAND	COM PLIETE		OPEI	R. NO. 100
MACHINE ZUCKERMAN (OPTI-SANDER) COMPUTER R.J. ORF DATE	10-21-83		DEP' DEP'	T. NO. <u>04</u> / OF <u>2</u>
TOOLING	DRAWING NUMBER	REMARKS	HOURS DESIGN	HOURS BUILD
FORMER FABRICATION:				
FOLLOWER WHERE (RICHARDSON to				
ZUCKREMIAN)		A/U		
COTTER BODY (RICHARDSON +0				
ZUCKERNIAN)	 	A/u		
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PREP É FABRICATION			20	20
ALUMINUM FLANK				800
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PROCESS ENGINEERING ESTIMATE - TRIAL AND PILOT SHEET • COMPUTATION •

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SPEED E FRED CHMS		· IRA	5	20
MACHINE LAYOUT			20	
TOTAL			1 Cm	1060
			180	
KETCH				44600

D.6567 LIQ.63

PROCESS ENGINEERING ESTIMATE - TRIAL AND PILOT SHEET

MODEL 870 SPECIAL COMPONENT STOCK OPERATION (OPTI - SAND) MACHINE SAND MACHINE SAND	PUTATION	•		
MODEL 870 SPECIAL COMPONENT STOCK			PART NO.	4 7 4
OPERATION (OPTI - SAND) MACHINE SE	AND COMPL	LATE	OPER	2. NO. <u>100</u>
MACHINE ZUCKERMAN OPTI- SAND	//1 - T / On		DEPT	. NO
COMPUTER R.J. ORF DATE	70 27:03	-	SHEET _/	
TOOLING	DRAWING NUMBER	REMARKS	HOURS DESIGN	HOURS BUILD
FORMER FABRICATION:				
ALUMINUM BLANK				800.
PREP & FABRICATION BLIERATIONS	ļ	·	20	.80 (C
PLTERATIONS				40
STEEL BLANK				<u> </u>
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PROCESS ENGINEERING ESTIMATE - TRIAL AND PILOT SHEET 12 64 • COMPUTATION •

ODEL 376 SATURE COMPONENT STOCK PERATION OPTI-SAND MACHINE SAN ACHINE ZUCKERMAN OPTI-SAN	P		UED.	R. NO. 100
OMPUTER RIJ. DEF DATE	10-21-83	-	SHEET _	T. NO. <u>04</u> Z OF <u>Z</u>
TOOLING	DRAWING NUMBER	REMARKS	HOURS DESIGN	HOURS BUILD
SUB-TOTAL			40	120
				#4300
PRT FABRICATION :				
TENON DRIVERS (SAME AS SPI-12)		A/L		
BUTT LO CATORS (1100)	0	BRED	15	270 7
BUTT LOCATORS (870)	0	8808	15	270 70
FORMER DRIVER		AIU		
FORMER CENTER		Alu		
CRADLES	0	16 Reg	20	100 70
BASE GAGE (Position of GRIP)		,		+
(PATER SPT-12)	0		20	60
SPEED & FRED CAMS	PTO	1EA	5	20
,				
PLACHINE LAYOUT	0		25	
· TOTAL			140	840
KETCH				34300·

PROCESS ENGINEERING ESTIMATE - TRIAL AND PILOT SHEET

20 GA: • CO	MPUTATION	•) (1 E. E. 1
MODEL ATO SPECIAL COMPONENT STOC OPERATION OPTI- SAND (MACHINE	SAND COMPL	EFE	_PART NO.	100
MACHINE ZUCKER MAN OPTI- SA	SAND CONTE	E / E	DER	R. NO. <u>100</u> T. NO. <u>04</u>
COMPUTER R. J. ORF DA	TF 10-21-83		SHEET	OF _2
TOOLING	DRAWING NUMBER	REMARKS	HOURS DESIGN	HOURS BUILD
FORMER FABRICATION:				
ALUMINUM BLANK				800
PREP & FABRICATION			20	80
ALTERATIONS				40
STEEL BLANK				
PREP & FABRICATION			20	"3500 - B
				J
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			· · · · · · · · · · · · · · · · · · ·	
			· · · · · · · · · · · · · · · · · · ·	
			-	
				
				
				
				+
TOTAL	-		40	120
SKETCH				⁹ 4300

MODEL SPECIAL COMPONENT STOCK PART NO.

OPERATION (OPTI-SAND) MACHINE SAND COMPLETE OPER NO. 100

MACHINE ZUCKER MAN OPTI-SANDER DEPT. NO. 24

COMPUTER R. J. OEF DATE	10-21-83	• <u> </u>	SHEET _	OF <u></u>
TOOLING	DRAWING NUMBER	REMARKS	HOURS DESIGN	HOURS
SUB-TOTAL			40	120
				"4300,
Deat Eaglianian	_			
PART FABRICATION: TENON DRIVERS (SAME AS SPI-74)		AIL		
BUT LOCATORS	0	2 Rea	15	270 TOTA
		Alu		
FORMER DRIVER FRANKE CANTER		A/U		
CRADUES	0	168129	20	100 7072
BASE GAGE (POSITION OF GRIP) (PLIER SPT 74-74)	0		20	60
(71/2/2 SF) /7-/G)		•		- 30
Speed & Feed Chins	PTO	IEA.	5	20
MACHINE LAYOUT			2 <i>5</i>	
			,	
				·
TOTAL			125	570
SKETCH	<u> </u>		<u> </u>	34300-



428 CHESTNUT STREET . PHOENIX, N. Y. 13135 . TEL. (315) 695-2026

October 25, 1983

Remington Arms
Ilion, New York 13357

Attn: Ed Murray

Re: Remington P.O. #I-82376 dated 4/29/82

Dear Ed:

Per my conversation with yourself and Bob March concerning the subject purchase order, we are requesting an amended order to change the price from \$3900.00 to \$5300.00 due to the real hours established on several former projects since this order was placed in early 1982. Also enclosed you will find a copy of my letter to Bob March in February 1983, in which we had requested an initial change in price to \$4290.00. The \$5300.00 price is based on a full length former we completed for Remington earlier this year at that price.

The delivery for Former #E-45992 will be January 15, 1984. Our normal delivery for a former is in the five to six week range; however, we have a commitment to deliver D-44423 (your P.O. C-11196) on November 28, 1983 and can not start E-45992 until it is complete.

Also, as we discussed, Arrowhead billed you for a cancellation charge of \$2400.00 relative to the subject purchase order. Please find a copy of my letter dated April 18, 1983 attached describing the reasons for those charges. Our accounting department will clear the purchase order by issuing a credit for that amount.

Should you have any questions, please don't hesitate to give me a call. Thank you for your assistance.

Best Regards

Doug Price Sales Manager

DP/bf

cc: Bob March

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

	•	e of operations •		_	
MOD	EL 7 LWT COMPONENT Stock	k Profiled	_ PA	RT NO. 2	72466
DATE	10/31/83 COMPUTER 72.	Workey		SHEET	1 of _/
OPER		 	DEPT.		HOURS
NO.	OPERATION NAME	MACHINE	NO.	HOURS DESIGN	BUILD
	USE PART # 91950				
	TO MAKE				<u> </u>
	STOCK PROFILED # 92466				ļ
\vdash					
60	Coat but with RKW &	BENCH	171		-
1	assemble Recoil Pad.				
757	Give top of Ped to Stock.		71		
821	9/06 766 8- /48 75 314CE;		-		
70	Sand Outside Contour	ZUCKERMANN OPTISAND	71	yohr.	120hr. \$5300
				97 W.*	
81	N/C Rout Stock exterior	HEIAN	72		
90	Drill holes for Grip Cap 2	REMINGTON SPECIAL	71		
<u> </u>	Roor Sling Swivel				
	,				
100	Assemble Guip Cap	BENCH	71		
	52/ 61 / 4	D			
785	Dill Stock & assemble	DRILL PRESS	7/		
-	Reinforcing Screw				
107	Sort for major repair		71		
			1	·	
115	Machine & hand sand complete.		71		_
	Visual Stock & repair Minor				
	wood fults.				
/25	Inspect for proper sanding		8055		
-	shape, and repairs 100%		 		
1200	P . 5/ 6- // /		1		
7302	Repair Stacks that have pin knots & bird pecks		7/		
	PIA MOTS & DIFA PEEKS				
1400	Repair Stocks that have		7/		
	chips, cracks, broken or		 		
	loose pads etc.				
	TO MRP Coib #24			_	
				- -	
*	Actual hours already completed.			r.	
			ļ——ļ	•	
			 	,	
		1	 		
			+	40 hr.	120 hr.\$5300
	TOTAL		 	97 hr. *	
RD-65				1 / 707. 天	フルハンボ

PROCESS ENGINEERING ESTIMATE - TRIAL AND PILOT SHEET

ODEL 7 LWT COMPONENT Stac. PERATION _Sand Outside Contour			OPER	NO 70
CHINE ZUCKERMANN OPTISAND			DEPT	'. NO. <u> </u>
OMPUTER 7.R. Whiley DATE	10/31/83	_	SHEET	<u>/</u> OF <u>2</u>
TOOLING	DRAWING NUMBER	REMARKS	HOURS DESIGN	HOURS BUILD
UCKERMANN OPTISAND		Add Use		
lachine Layout -TDR#81-Completed	F-45995	New	60 *	365 ⊀
ester Stock	E-45974	Add Use		
TORE87, 88,92,134,135,	E-45993	New	2/ ⊀	/38*
former - Cast Iron - TOR #83	E-4599 2	New	12 *	# 5300
ormer Diver - Det. 9/2	F-45995	(in Layout)		
ormer Conta		· Add Use		
tock Driver - Det. 2,5,6	E-44928	Add Use		
Hock Center - Det 3/2	F-45995	(in Laport)		
vadle Plate - Front - Det. 6/3	F-45995	(in Layout)		
redle Plate - fear - Dot. 5/3	F-4599 5	(in Layout)		
filower Roll (2)	C-43072	Add Use		
entact Roll (16)	C-43125	Add Use		
		-		\$5300
TOTAL			93 *	503*
* Actual hours on work alre	ady comple	eted.		

PROCESS ENGINEERING ESTIMATE - TRIAL AND PILOT SHEET

ODEL 7 LOT COMPERATION Sand OUT	BONENT Stock	0 (./-	<i>n</i>		
PERATION Sod OUT ACHINE BURERMA	POMEM - STORY	Frotiles	V	PART NO.	92466
ACHINE BULLERMA	tside contaur			OPER.	NO
	NN OPTISAND			DEPT. SHEET _2	NO. 7/
COMPUTER - 3.R. Was	DATE .	10/31/83		SHEET	
TOOLI	NG	DRAWING NUMBER	REMARKS	HOURS DESIGN	HOURS BUILD
selt quide (8)		C-45473	Add Use		
sugh Sanding Belts	- (8)		Add Use		
5"x 59" -80 6.	+	-			
inish sanding Betts 5×59" -PIZO G.	- (a)	_	Add Use		
			41.		
Dial Base Gage Goip Centrality		G-42541	Alter	40	/20
Position of Sign					
feed Template -TO	R#146	E-45915	· Alter	2*	4 *
speed Template -TD	124147	E-45480	Alter	2 *	4 *
<u> </u>		 			
		-			
				<i>"</i>	/3=
	TOTAL			40 4*	/20 8*
sketch K Actual hours o	n work already	y complete	ed.		

xc: D.J. Anderson

P.G. Johnson

L.B. Bosquet

W.S. Johnson

H.K. Boyle

C.H. Kohn

MODEL SEVEN LWT OPTISAND FORMER

J.P. Linde

11-2-83

W.K. Bryant R.W. Farrington

R.J. Long . J.W. Smith

stimated by F. Wrisley

G.E. Fletcher

G.J. Hill

F	ROPUSED START- MODEL SE		20.	30. 40.	19_84_
	CAP. \$	OP. \$		•	
NEIRLNG/DEVELOPMENT Investigation Design Hodels for Evaluation Design Testing					
an schunes soling	2100	1700			
AND PRECURE action Fabrication action Shipping action Installation action Alignations					
enting Alteration onl Alterations onishable Tooling endor Tooling coduction Aids	9500 3600	11200			
OPERATIONS actions Reschangement ilst Lot Manufacturing ilst Lot Testing		400].
ENGENICIES		400			1
nflation planned Tool Revisions planned Machine Revisions	800	600			1
utal L investment	16000	16000			

OPTI-SAND STOCK MACHINE

11-14-83

scimated by R. Orf

ENGINEERING ESTIMATE

xc: D.J. Anderson

P.G. Johnson

L.B. Bosquet

W.S. Johnson

H.K. Boyle

C.H. Kohn

W.K. Bryant R.W. Farrington J.P. Linde

G.E. Fletcher

R.J. Long .
J.W. Smith

G.J. Hill

PAGE 2 OF 3

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its

	POSED START-UR SPORTSMAN		20. 30. 40. SPORTSMAN 74-	
	CAP. \$	OP. \$	CAP. \$	OP. \$
INE-RING/DEVELOPMENT				
Investigation				
Design				
Models for Evaluation				
Design Testing				
TEN				
Machines			2200	1 0700
T eeling	3300	4200	2200	2700
LD AND PROCURE				
Macrine Facrication				
Machine Shipping			<u> </u>	
Machine Installation Machine Alterations	·	<u> </u>		
Tool Fabrication	17500	27200	13000	22800
Tool Alterations	1/300	2/200	13000	1 22800
Perishable Tooling		2000		700
Vendor Tooling				
Production Aids				
OT OPERATIONS				
Machine Rescrangement Pilot Lot Manufacturing		900		900
Filst Lot Testing		900		1 900
Component Obsilescence		600		600
INGENETES				
Inflation	2200	3100	1800	2700
Urplanned Tool Revisions		4000		3600
Unplanned Machine Revisions				
TCTAL	23000	42000	17000	34000
AL INVESTMENT	650			1000

ENGINEERING ESTIMATE

xc: D.J. Anderson

P.G. Johnson

L.B. Bosquet

W.S. Johnson

H.K. Boyle W.K. Bryant C.H. Kohn J.P. Linde

OPTI-SAND STOCK MACHINE W.

R.W. Farrington G.E. Fletcher

R.J. Long .
J.W. Smith

late 11-14-83

G.J. Hill

PAGE 3 OF 3

itle

	PROPOSED START-4 M/870-1100	JP <u>10.</u> 12 & 20 Ga.	20-	30. 40. SPORTSMAI	
	CAP. \$	OP. \$		CAP. \$	OP. \$
GINEERING/DEVELOPMENT Investigation					
Design Models for Evaluation			┥┢	·	
Design Testing			+ -		
SIGN Machines			+ -		
Tooling	2200	5000		2700	2400
ILD AND PROCURE			<u> </u>		
Machine Fabrication Machine Shipping			┥╞		
Machine Installation] [
Machine Alterations Tool Fabrication	15800	33900		20800	21900
Tool Alterations Perishable Tooling		1300	+		700
Vendor Tooling					
Production Aids			╅┢		
LOT OPERATIONS			#		
Machine Restrangement Pilot Lot Manufacturing		1400	+		900
Filot Lot Testing Component Obsclascence		1000	+		600
NTINGENCIES			<u> </u>		
Inflation Unplanned Tool Revisions	2000	3400 5000	┥┡	1500	2500 4000
Unplanned Machine Revisions		,	‡		1 4000
BTOTAL	20000	51000	+ +	25000	33000
ITAL INVESTMENT		.000	7 7		3000

STOPE:

Attached are five estimates which cover costs for formers and part fabrication required to sand the entire Sportsman line, the Model Seven LWT and the M/870-1100 12 & 20 Ga. Stocks on the Opti-Sand Machine.

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	Stock										'	İ													
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1	Tool Revision	#	11		200		11		500				100		11		1000				300			T	Ŧ
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G-38

DON'T SAY IT-WRITE IT

- F. R. Wrisley

Date Nov. 4, 1983

From E.L. Morris, Jr

re: Opti-sand M/7 Ltw Long Stocks

Per your request a high-spot evaluation has been performed on the proposal to Opti-Sand M/7 Ltw long stocks and perform a reduced Machine and Hand Sand rs. the current Machine and Hand Sand Operation. This high-spot indicates a potential \$30,000 annual (1964) labor savings based on the reduction in labor required at operation 110 Machine and Hand Sand Complete.

"DON'T TAKE A CHANCE, THINK SAFETY IN ADVANCE"

Proposal No. #1081

Xc:

P E & C EVALUATION REQUEST

MODEL:				Revised [
TITLE:	te Saul Meline	Former		
DEVELOPMENT S	CHEDULE ITEM?	PRODUCT	ACCEPT. DA	TE
SUBMITTED BY	7. Whilen + R. O.l	DATE //	14/83	ı.
		Year	Volume	Price
FOR NEW/REVISED MODELS	First Year			
ONLY	Third Year			
	SOURCE:			
DRAWINGS ATTA	CHED:			
PARTS LIST DA	TED:			
ENGINEERING C	OST ESTIMATE: DATE R	EQUIRED	1-21-83	
LEAD EST	IMATOR F. Wrisley & R	Of DAT	E COMPLETE	11/29/83
	ATE REQUIRED /2-2-			
OPERATIO.	NS COMMITTEE REVIEW			
PROJECT	DRAFT COMPLETED			
COMMENTS:				



216 671-8000

DIE & STAMPING COMPANY

DIV. OF UNITED SCREW AND BOLT CORP.

Engineering Tools Dies Stampings

Sub=Assemblies Bus Supplies

4650 TIEDEMAN ROAD CLEVELAND, OHIO 44144

November 14, 1983

Remington Arms Co., Inc. Ilion, N.Y. 13357

Attention: Messrs. Ferreira and Bosquet

Gentlemen:

FIRST OF ALL I HAVE

NOTHING TO DO WITH

NOTHING TO DO WITH

CURRENT PURCH. PARTS - Q.C.

CURRENT PURCH. PARTS - Q.C.

SECOND - WHY DID HE

SECOND - WHY DID HE

HAVE BOTH

HAVE BOTH

On June 17, 1983, we returned Remington's gage for all operating handles for correction and H & P's gage for updating. We are now manufacturing operating handles and the gage has not been returned.

On July 12, 1983, and previously, we called Remington's attention to the 92256 base gage and the trigger guard gage we have on hand that are not usable, please advise when exchange can be made.

Yours sincerely,

trank Comhor

Frank Ambrose

rn

M/7LWT STEEL PARTS

WE HAVE NO INTENTION OF

MAKING ANY CHANGES TO

THESE GAGES

Bolf action Carlina 1983 Introduction 11-3-81 JB/3

Tool Design

There are approximately 6000 hours of toolderign involved in this model. In order to meet the proposed Trial and Relat schedule I will be necessary to contract with outside design houses for al least 50% of the design. Design to be accomplished in 12 weeks (3 mouths) 6000 : 40 = 150 man weeks

assume that fine (5) Remeinston designers are assigned to this project

5 × 40 × 10 = 2 400 hours can be completed

6000 - 2400 = 3600 Kours to be "farmed and"

3600 +12 +40 = 7.5 n 8 metaide designer.

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER KINZER V. REMINGTON

G-88

DON'T SAY IT-WRITE IT

то 39	Date
To_3cg From_Beace	
Please check the M, (308 Cal) left once from	17 LWT assembled action
please the for	u the first go mend.
(308 Cal) left.	
If they look rusty (e	specially the tores thank
If they look rusty (e someone oil Them.	The state of the s
a. + at 1.1. actions	cirb 29 -
Spot chicked actions	
QK no mot=	11-10-83

"SAFETY RULES ARE PERFECT TOOLS"

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

DELS re //-	SFT. 78 COMPONENT STOCK 23-83 COMPUTER R.J.O		PA	RT NO SHEET	
R	OPERATION NAME	MACHINE	DEPT.	 	HOURS
BAS	is:				
O Vo	L. 18.000 /ME.				
(3) US	L. 18,000 / MR. E ZUCKERMAN PARVER FOR	mBR.	-	· · · · · · · · · · · · · · · · · · ·	
1				•	
2 (012)	I-SAND YMACHINE SAND COMPLE	7/3	72	188	1405
					B1100.
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	TOTAL				

PROCESS ENGINEERING ESTIMATE - TRIAL AND PILOT SHEET • COMPUTATION •

ERATION (OPTI-SAME CHINE ZUCKERMA) IMPUTER RIJ. ORF TOOLING PREP PLUMINUM (OPY 1:1 FROM (OPY	N OPTI-SAND DATE NG DN: BLANK (PRESENT)	//-23-83 DRAWING NUMBER		DEP	R. NO. 100 T. NO. 100
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1-18-63

PROCESS ENGINEERING ESTIMATE - TRIAL AND PILOT SHEET • COMPUTATION •

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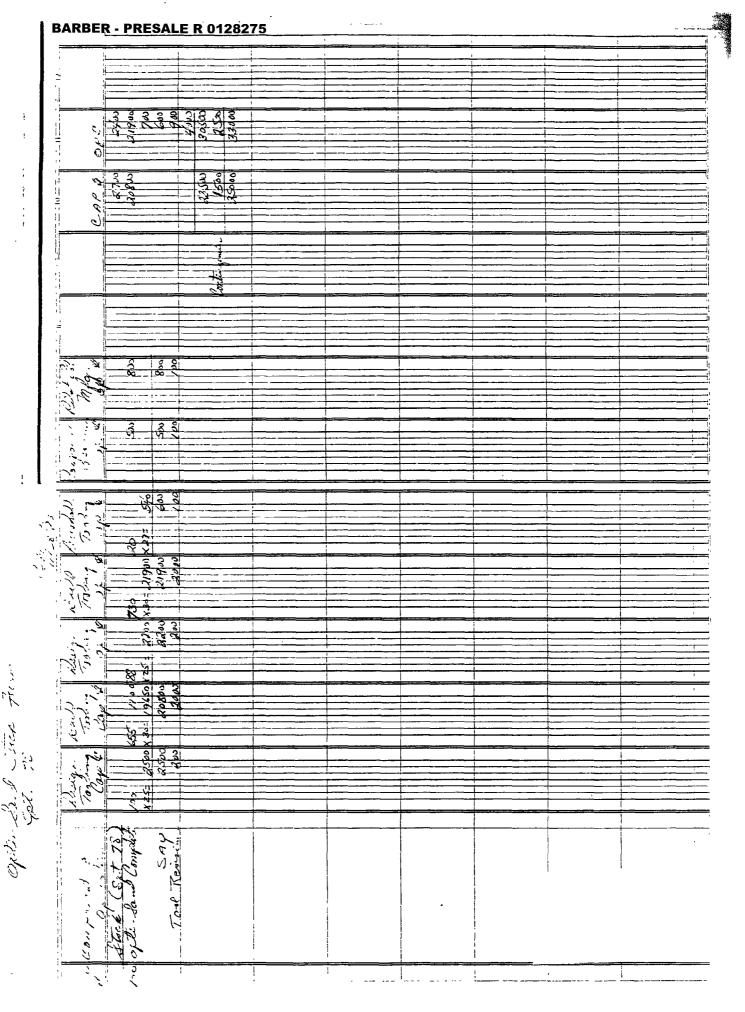
Sportsman 78 on opti-sander.

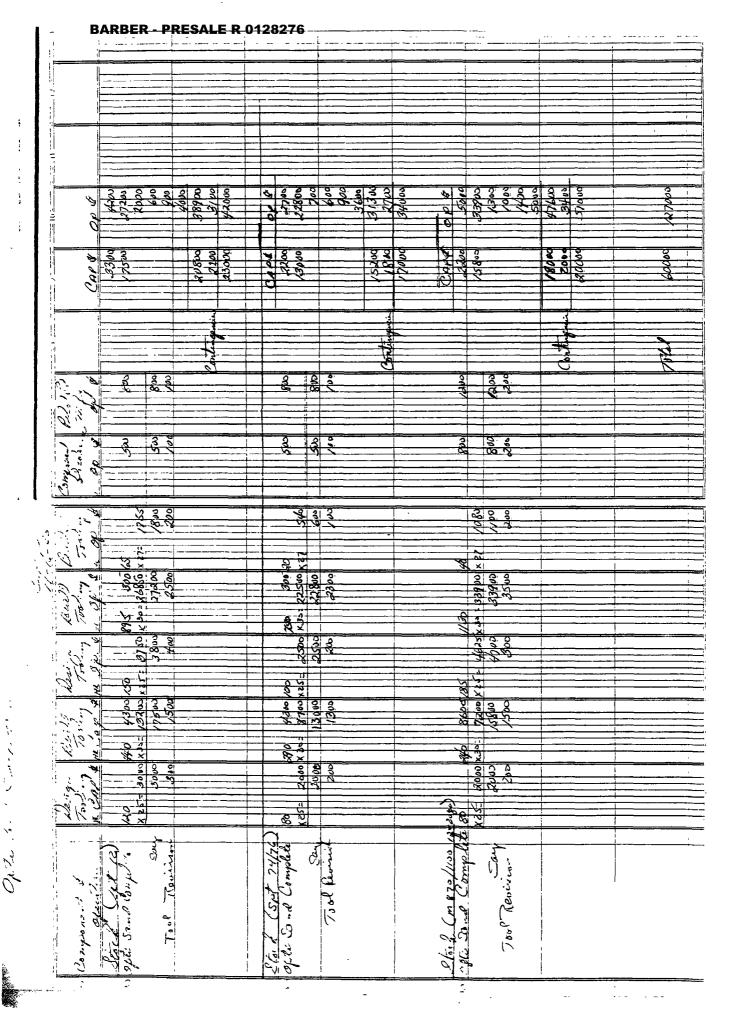
11-23-83 R.f.O.

Procedure for producing former for opti-sand.

Olse the Zuckerman carrer former for the ceasing and run stocks on the Richardson carrer.

- @ Copy the former 1:1 into aluminum for the opti-sander.
- Ilse the aluminum former on the opti-sander and the sand the stocks from the Richardson carrer.
- O Altu aluminum former as mulled and try again
- 3 Copy aluminum former into steel.



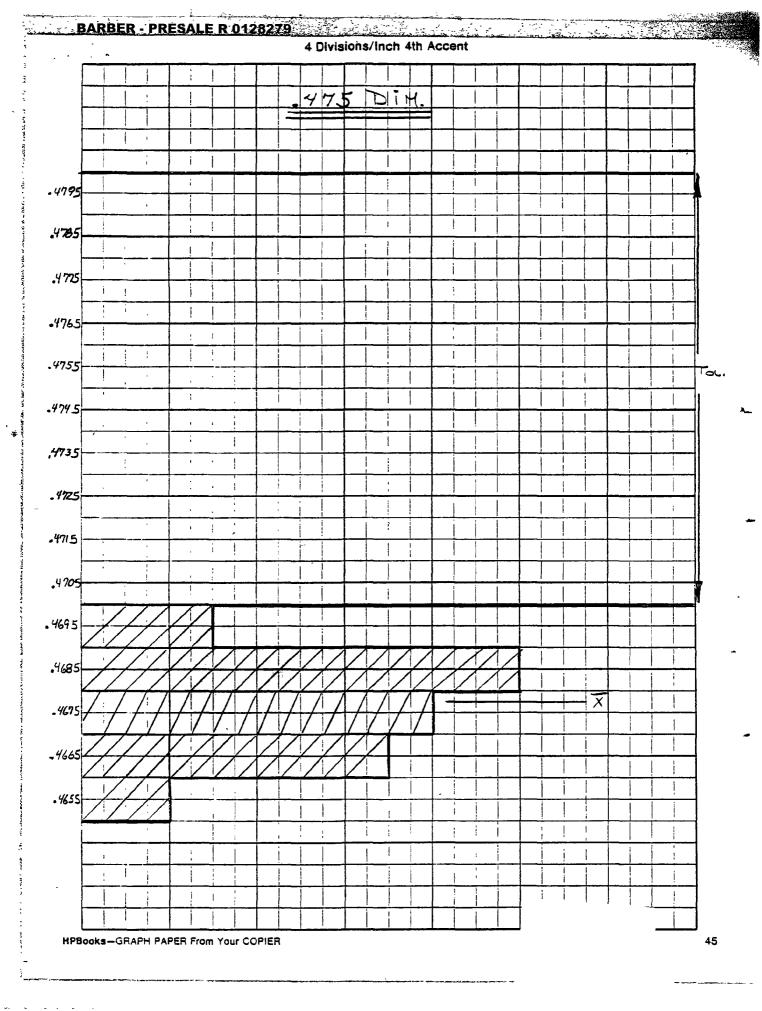


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RD-49-8

OR 000581

REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE

Remington. OF THE PROPERTY OF THE PROPERT

XC: L. B. Bosquet J. J. Burns R. L. Snedeker

K. W. Soucy

"CONFINE YOUR LETTER TO ONE SUBJECT ONLY"_

October 4, 1984

TO:

S. D. BENNETT

FROM: J. B. MROZ $\mathcal{I} \mathcal{B} \mathcal{M}$

M/7 LWT. TRIGGER GUARD BLANK D-92836

REQUEST:

Find the range of variation on the .475" + .005" (see

attached letter and model drawing).

METHOD:

Measure 30 trigger guards for $.475" \pm .005"$ dimension on

the 30" comparator in Q.C. lab.

RESULTS:

Range - .470" - .4657 = .0043" Mean - .4678"

Std. Dev. - .00107" 6 Std. Dev. - .0064"

(See attached data sheets and graph)

CONCLUSION: Vendor is not within control on this dimension.

JBM/cac Attach.

BARBER - PRESALE R 0128281 - ----

M/700 CLASSIC & MODEL SEVEN LWT RECOIL PAD

Xc: D.J. Anderson

G.J. Hill

L.B. Bosquet H.K. Boyle

P.G. Johnson J.C. Woudenberg

W.K. Bryant K.W. Soucy R.W. Farrington R.J. Long G.E. Fletcher

C.H. Kohn A.D. Johnson

ENGINEERING ESTIMATE

	PROPOSAL	#1125		
	PROPOSED START-	UP 1Q 20	30 40	. 19_85
	CAP. \$	OP. \$	CAP. \$	GP.\$
ENGINEERING DEVELOPMENT Investigation Design Models for Evaluation Design Testing				
DESIGN Machines Tooling	500			
BUILD AND PROCURE Machine Fabrication Machine Shipping Machine Installation				
Machine Alterations Tool Fabrication Tool Alterations Perishable Tooling	1100			
Vendor Tooling Production Aids	3500			
PILOT OPERATIONS Machine Rearrangement Trial & Pilot Operations R & D Design Confirmation Machine Runoff Trial and Pilot Scrap Comp. Obsolescence(Inv. Scra	p)	400		
CONTINGENCIES Plant Overhead Charges 4.4% Inflation	250 510	40		
Unplanned Tool Revisions Unplanned Machine Revisions				
SUB-TOTAL TOTAL INVESTMENT	5860	440 300		

SCOPE:

TITLE DATE

12-7-84 ESTIMATED BY Spencer Bennett

Purchase Recoil Pad and stamping dies to produce larger steel reinforcement.

PROCESS ENGINEERING ESTIMATE - TRIAL AND PILOT SHEET

MODEL 7 LWT COMPONENT RECOIL PAD PART NO. 91544

PER	12/7/84 COMPUTER Spende	· · · · · · · · · · · · · · · · · · ·		HOURS	HOURS
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	RUBBER COMPANY.		-		
	PURCHASE NEW STAMPING	PIES 70 PRODUCE			
	LARGER STEEL REINFORCEM	ENT.			
				·	
	TOOL CHARGE: 3500. (ST	AMPING DIE ONLY)			
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	PIECE PRICE: 2,20 EACH	· · · ·	-		
	(PAD WITH STEEL REINFORCEMENT	<u> </u>	-	· · · · · · · · · · · · · · · · · · ·	
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	PURCHASED PARTS INSPECTION	· · · · · · · · · · · · · · · · · · ·	9260		
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	TOTAL			20	35

G-88

DON'T SAY IT-WRITE IT

TO L.B. BOSQUET	Date
From Spencer Bennett	
	J D91544
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"YOUR SAFETY ATTENTION MEANS ACCIDENT PREVENTION"

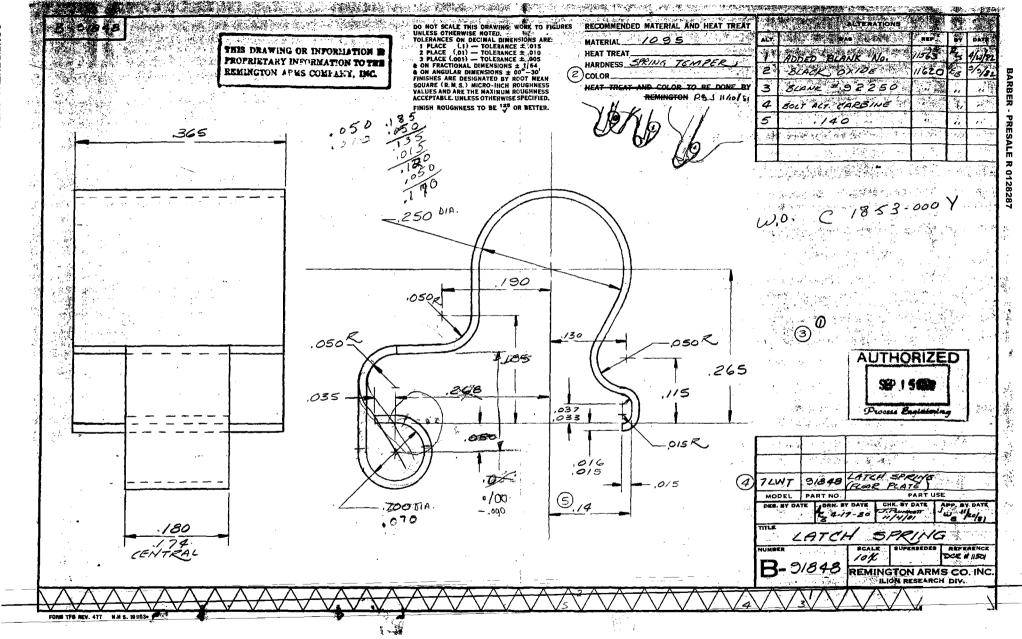
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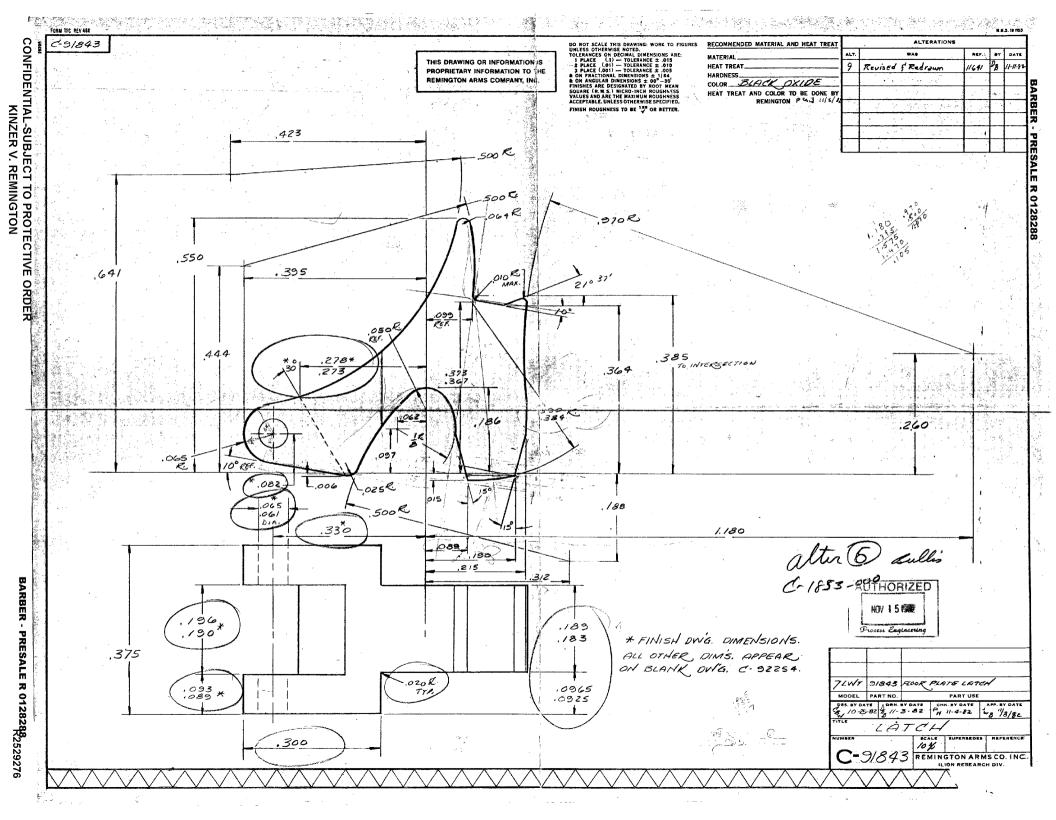


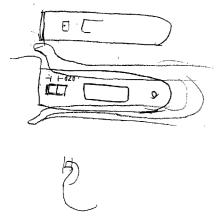
TO: J.W. BROOKS

(Received by C.B. Workman - 8/23/83)

Dog.







December 17, 1982

F. M. AMES L. W. BAUM L. B. BOSQUET J. W. BROOKS

W. W. COOK L. B. FERREIRA G. E. FLETCHER G. J. HILL

P. G. JOHNSON W. S. JOHNSON M. J. KANTOR C. E. RITCHIE

FROM: G. D. CAMPBELL / D. J. ANDERSON

MODEL SEVEN PRODUCTION STARTUP

A summary of the active programs to resolve startup difficulties with the Model Seven LWT is attached. Program status and anticipated completion dates are as of December 17, 1982. Progress will be monitored and status updated as required.

GDC/DJA:hv Attachment

MODEL SEVEN PRODUCTION STARTUP

PROGRAM STATUS

PRO	GRA	M/KEY EVENT	RESPONSIBILITY	COMPLETION			
I.		iminate/Minimize ESCR Rejects 243 Cal.)					
	0	File chamfer on rail to repair finished guns and Barrel assemblies (.243 only)	PRODUCTION	COMPLETE			
	0	File chamfer on rail of all new .243 Receivers prior to assembly to Barrels (Dept. 58)	PRODUCTION	IN PROGRESS			
	0	Revise Receiver design (add angle to rail) and process for all calibers-M/Seven only					
		- Provide samples for test	PE&C/PRODUCTION	1/14/83			
		- Function test	RESEARCH	TBD			
		- Transmit design change	RESEARCH	TBD			
		- Revise process	PE&C/PRODUCTION	TBD			
iı.	E 1	iminate Floor Plate Latch Failure Continue M/Seven assembly with available Latches - hold for Latch replacement	PRODUCTION	IN PROGRESS			
	0	Provide correct Latches using EDM process in quantities sufficient to support pro-duction					
		 Start producing 60/day with Research EDM (3 shifts) 	RESEARCH	COMPLETE			
		 Order additional from Fermer Tool & Die (rate TBD) 	PE&C/PURCHASING	12/17/82			
		- Complete straddle mill fixture	TOOL ROOM	12/20/82			
		 Start mill, drill, deburr, and heat treat operation 	PRODUCTION/PE&C	12/20/82			
		- First parts to Final Assembly	PRODUCTION/PE&C	12/21/82			

MODEL SEVEN PRODUCTION STARTUP PROGRAM STATUS

-2-

12/17/82

PRO	GRAI	M/KEY EVENT	RESPONSIBILITY	COMPLETION
II.		iminate Floor Plate Latch Failure ontinued)		
	0	Provide correct Powder Metal Latches		
		- Revise tooling	POWDER METAL	1/3/83
		- Production parts	POWDER METAL	1/5/83
III.		tablish Floor Plate to Stock earance specification		
	0	Continue M/Seven assembly holding maximum clearance at 0.035 inch (nominally same as M/700)	PRODUCTION	IN PROGRESS
	0	Determine clearance specification required	RESEARCH	TBD Dowy
	0	Revise design and/or process so that specification can be met	RESEARCH/PE&C	TBD

GDC:hv

RO-SBARBER - PRESALE R 0128294 REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE





"CONFINE YOUR LETTER TO ONE SUBJECT ONLY"______ December 30, 1982

J. P. LINDE

SUBJECT: MODEL SEVEN LIGHTWEIGHT FLOOR PLATE LATCH - MATERIAL

SUBSTITUTION FOR FIRST PRODUCTION GUNS

In August of this year approximately 1000 pieces of the original design part were received from Powder Metal. These blanks were made of HD 1000 powder metal pressed and coined to a density of 7.2. This lot of parts was accepted and was used in the Trial and Pilot of this model. The balance was to be used in the initial production run.

During the Trial and Pilot testing a functional problem was noted the Floor Plate Cover opened during shooting. Research analysis of the problem resulted in a redesigned Latch. Samples were made from C-1018 wrought steel, tested (in the plant and in the field), and were found acceptable in overcoming the problem.

The revised design was transmitted on November 11 and new Powder Metal tooling was ordered. Blanks were received December 3. Initial testing indicated that they functioned properly. However, as the first production guns were being tested it was noted that the problem was still present.

A meeting was held December 9 with representatives from New Product Process Engineering, Powder Metal, and Research in attendance. It was decided to tighten the dimensions locating the latching surface radius. The powder metal tooling vendor was contacted and instructed to build a new set of pressing and coining tools. Revised model drawings were transmitted December 13 on DCR 11658. The new pressing tools will be shipped to Remington (by air freight) on January 7, 1983 and the coining tools the following week.

Research N/C group was contacted and began producing Latch blanks on their wire EDM equipment. Two additional machining operations were set up and the first Latches processed through to Final Assembly on December 21. Research was originally requested to provide 500 blanks by January 1, 1983. In light of the powder metal tooling delivery this quantity was increased to a total of approximately 1400 blanks by January 21.

J. P. LINDE

LBB:hf

-2-

December 30, 1982

In order to provide an adequate supply of parts, Fermer Tool and Die was contracted to provide 250 blanks by January 1. This quantity was increased on 12/22 to a total of 1000 pieces by January 21, 1983.

It is anticipated that the new powder metal tooling will provide parts beginning about January 19, 1983. In summary: the original Latch design was a contributor to the "Floor Plate Cover Opens" malfunction; the redesigned Latch has eliminated the problem; new powder metal tooling will be available in mid January; to provide Latches for assembly until then, a total of approximately 2400 pieces is being produced from C-1018 wrought steel.

L. B. Bosquet, Supervisor N. P. Process Engineering

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER KINZER V. REMINGTON

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> John Brooks
J.P. Linge
C.B. Workman

Clark

(Toolene Cost?)

January 19, 1983

H.K. Boyle

High Spot Cost Comparison M/7 Floor Plate Assembly vs. M/700 Trigger Guard

Estimated cost for the Model Seven Floor Plate Assembly has been determined in respect to the M/700 Trigger Guard Assembly. More specifically, economics reveal a M/7 cost of \$940.998/C versus a M/700 cost of \$756.646/C.

Costs include standard labor, direct expense, and material costs. Variance and industrial relations have been applied to the appropriate accounts.

Cost differential for the two designs disclose a \$184.342/C increase for the M/7 Floor Plate Assembly.

Industrial Engineering Section R.W. Farrington, Jr., Supervisor
RW famington po
D. M. Scram

DGS/kc

REMINOTON ARMS CO. RECTUMD

JAM 2 6 1983

FERTARIAS RESEARCH DIVISION

xc: H.C. Munson

J.P. Linde C.B. Workman

Est. #4457

January 19, 1983

H.K. Boyle

High Spot Cost Comparison M/7 Floor Plate Assembly vs. M/700 Trigger Guard

Estimated cost for the Model Seven Floor Plate Assembly has been determined in respect to the M/700 Trigger Guard Assembly. More specifically, economics reveal a M/7 cost of \$940.998/C versus a M/700 cost of \$756.646/C.

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Industrial Engineering Section
R.W. Farrington, Jr., Supervisor
RW favoration for
D. S. Scram

By: \ D.G. Scram

DGS/kc

RD-69-B

REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE

Remington.

PETERS

"CONFINE YOUR LETTER TO ONE SUBJECT ONLY"....

xc: L. B. Ferreira

J. W. Brooks
L. B. Bosquet
R. C. Bottini

R_{il}J. Long

January 20, 1983

TO:

S. D. Bennett

FROM:

D. D. Ricci

REFERENCE:

#92227 Bolt Handle

Per conversations with Vestshell since my 12-27-82 letter, the following revised approach will be taken:

- Additional orders have been issued for the square neck, round ball handles to insure continuity.
- Rather than physically alter any of the new cavities at this time (to reduce the excess costs for prototype work and rebuild once a decision is made), Vestshell will exhaust all possibilities of design improvement to eliminate the 'hot tears'. Waxes will be hand scrapped using parts produced from the old die square neck, round ball design.

All options will be produced to metal and forwarded to Remington for review. Estimated time is three (3) weeks.

Vestshell has explored an option to metal form changing the acute angle from 1/16 radius to 3/32" radius. 'Hot tears' were diminished but not eliminated.

Example of option consideration;

- 1. 1/16 acute angle to 1/8 radius
- 2. 1/16 acute angle to 3/32 radius with sections A-A, B-B, C-C .100 radius change to
 - a. .070
 - b. .080
 - etc.

We hope this meets with your approval, as Vestshell is proceeding most expeditiously to eliminate this condition as well as provide our Production requirements.

DDR/y

more 650 proty of followers Flo 8 vendor complete parts Fel 10 Puts arrive Ilian Feb 11 Hat test of joits. Fb 14 to kichel flate. Feb 15 Ports to test leb for Teling F 10 - 9 Francist Junts to Person

RD-69-B

Remington.

REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE

PETERS

"CONFINE YOUR LETTER TO ONE SUBJECT ONLY"___

XC: S. D. Bennett
Z. J. Kowaslki
J. B. Mroz
J. R. Snedeker
R. L. Snedeker

File

February 2, 1983

TO: L. B. BOSQUET

FROM: G. E. BARNES

MODEL SEVEN LWT FLOOR PLATE ASSEMBLY

PROBLEM:

Final Inspection Rejects - excessive space between Floor Plate Cover and Stock

METHOD:

Sample pieces (30) of floor plate base blank, floor plate cover and floor plate pad taken from Purchase Parts and measured for the following dimensions:

- A.) Floor plate base blank
 - All dimension checks for incoming purchase parts.
 - 2.) Dim..448-.442 before operations.
 - 3.) 90° c'sink
 - Centerline hinge hole to flat of hinge before mill, ream and deburr.
 - 5.) Width of c'sink (.495)
 - 6.) Orientation of hinge to base.
 - 7.) Dimension .448-.442 after operations.
 - Centerline hinge hole to flat of hinge after mill, ream and deburr.

TO: L. B. BOSQUET - 2 -

FROM: G. E. BARNES

MODEL SEVEN LWT FLOOR PLATE ASSEMBLY

METHOD: contd.

- B.) Floor plate cover
 - All dimension checks for incoming purchase parts
 - 2.) Dimension 3.850
 - 3.) Dimension .055
 - 4.) Contour before opeations
 - 5.) Contour after operations
 - 6.) Diameter of reamed hole (.093-.095)
- C.) Floor plate pad
 - 1.) 90° c'sink
 - 2.) Depth of c'sink (.107-.093)
 - 3.) Diameter of hole (.300)

OBSERVATIONS: A.) Floor Plate Base

- *1.) Hinge hole undersize
- * Take down hole undersize and eggshape
- * Width of hinge oversize
- All parts out of parallelism from flat of base to hinge.
- 3.) All parts at 90° c'sink
- 4.) Centerline hinge hole to flat ranges from .004-.005 before process.

TO: L. B. BOSQUET

FROM: G. E. BARNES

MODEL SEVEN LWT FLOOR PLATE ASSEMBLY

OBSERVATIONS: A.) Floor Plate Base - contd.

- *5.) C'sink oversize all 30 parts.
 - 6.) Hinge not parallel to base
- *7.) Dimension .448-.442 not in tolerance after mill, ream, deburr.

- 3 **-**

8.) Centerline of hinge hole to flat ranges from -.003 to .003 after mill, ream and deburr. (Note: ranges before and after may vary due to hinge hole being at taper.)

B.) Floor Plate Cover

- 1.) Found all 30 parts acceptable
- *2.) Dimension <3850 found parts at low limit or below
- 3.) Dimension .055 found most parts in tolerance.
- *4.) Contour on comparator showed both ends to be .010 high.
- *5.) Contour after braze showed two variations to a lesser amount with several parts having hinge bent.
- 6.) .093-.095 hole found to be to model drawing.

C.) Floor Plate Pad

1.) Made 5 castings - found all to be 90°, but not at 4° angle and no .010 step at neck.

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER KINZER V. REMINGTON

BARBER - PRESALE R 0128303 R2529291

TO: L. B. BOSQUET

FROM: G. E. BARNES

MODEL SEVEN LWT FLOOR PLATE ASSEMBLY

OBSERVATIONS: C.) Floor Plate Pad - contd.

2.) Depth of c'sink in tolerance

Checked pad with the altered c'sink and found to be .114 deep.

- 4 -

NOTE: Thickness varies from .171 to .181 with a .002 to .004 taper which could cause some plates to be higher than others.

- *3.) Diameter hole .280-.281 with large burn at bottom.
- * Denotes parts vary from model drawing.

NOTE: Full report upon request.

GEB/bdm

BARBER - PRESALE R 0128305

MODEL SEVEN LIGHTWEIGHT

CALIBERS: 222 Rem., 6mm Rem., .243 Win., 7mm-08 Rem., .308 Win.

BOLT BODY: Damascene Finish

BOLT HANDLE: Smooth Knob

EXTRACTOR: Rivetless

SAFETY: Positive thumb type - 2 position - no bolt lock

EJECTOR: Spring loaded in bolt face

STOCK: Schnabel fore-end

Grip-cap - with insert (can be replaced with pewter

Sid Bell design like Model Four)

Recoil Pad

Cut Checkering - 18 lines per inch

Sling Swivel Studs

Walnut Wood

Medium Gloss Finish

Length of Pull - 13 1/2 inches

Drop at comb 19/32 Drop at heel 29/32

FLOOR PLATE: Steel-hinged

TRIGGER GUARD: Steel

RECEIVER: Round

Scope Mounting holes - 2 on front ring and 1 on rear ring

BARREL: Length 18½ inches - 6 grooves

Pressure Pad at front of Stock

SIGHTS: Front sight on base

Rear sight adjustable for windage and evaluation

BARBER - PRESALE R 0128306

MODEL SEVEN LIGHTWEIGHT - Contd.

GENERAL

WEIGHT: 64 pounds

LENGTH

OVERALL: 37½ inches

PITCH: 1 13/32 inches (To bbl. center line)

AMMUNITION

CAPACITY: 222 - 5 in Magazine & 1 in chamber

6mm - 4 in Magazine & 1 in chamber 243 - 4 in Magazine & 1 in chamber 7mm-08 - 4 in Magazine & 1 in chamber 308 - 4 in Magazine & 1 in chamber

METAL FINISH: Highly polished and buffed

STRENGTH: Three rings of steel around cartridge head

(Bolt, Barrel and Receiver) same as M/700

2/2/83 JWB:js





REMINGTON ARMS COMPANY, INC.

SPORTING ARMS-AMMUNITION-TARGETS-TRAPS

ILION, NEW YORK 13357

TELEPHONE (315) 894-9961

February 2, 1983

Mr. Nick Harvey Technical Editor Sporting Shooter Magazine Hills End via Mudgee North South Wales, Australia 2850

Dear Mr. Harvey:

Clark requested that we send you the enclosed information on the Model Seven Lightweight.

We also have a Model 700 barreled action in .257 Roberts Caliber for you.

The Model Seven Lightweight with a bolt lock will be sent to you this month along with the Model 700 barreled action.

Sincerely yours,

John W. Brooks, Supervisor Current Firearms Design

JWB:js Enc.

2-7-83

Recommendation to correct tolerand for tight flow Plats.

Bought show the will cover all condition.

File cover to fit latche

. alter Trigger Hand pivot senfore (at asserby)

xc: H.K. Boyle

H.C. Munson

J.P. Linde

C.B. Workman

L.B. Bosquet S.D. Bennett

D.G. Scram

Est. #4457

February 8, 1983

G.D. Campbell

Model Seven Lwt. Trigger Guard Assembly

The attached evaluation shows the estimated economic impact of the proposed cast aluminum trigger guard assembly for Model Seven Lwt. rifles. This aluminum trigger guard assembly would replace the current Model Seven stamped steel/brazed trigger guard assembly.

This proposal will result in an estimated \$62M net saving in operating cost and 44% net return on investment in the third year of operation (1986). Estimated first year results are a \$56M net savings and a 38% net return on investment.

The major improvement contributing to this estimated savings is elimination of the brazing operations required with the current stamped steel design. The proposed aluminum trigger guard assembly will also result in reduced polishing costs as it utilizes an Almco finishing process compared to manual polishing and buffing of the present trigger guard assembly.

This proposal would require capital investment of \$167M and \$42M in project operation charges.

Industrial Engineering Section R.W. Farrington, Jr., Supervisor

Ru farmingten for.

TRAndrews/kc
Attached

Program for Testing different length 1. Set up consition for · Max stock dyeth · max inliting · Max Dig Guard cut for Later · Shortest radius on Later 7.6 25 · Max come thickness 2. Set up condition for · Min Stock depth . Min Jug Guard cut for Latet · Min comer thickness Feb. 25 · Longest radius on Latch (.387) 3. Set up Mean and litons for Mean Slock lighth inletting · rean core theknes · Man rod. on Later (.377) 7el. 25 7et 28 · assemble each condition march 2. Test fire all conditions from fack & shoulder. **BARBER - PRESALE R 0128311**

. cover (File) . Tugger Huard 1

Leslie "Les" Bowman P.O. Box 88 Ocate, New Mexico 87734

505 666-2444

John W.brooks Current Rirearms Supervisor. Remington

Dear John:

Thanks for the letter re the barrel. Will look for it. I would like to ask you a question if you do not mind. When Mike Walker and Wayne leek were there I wrote to either for all info that I needed and knew which one would have the answer I required. But since they left I do not know the divisions of dapartments and who is head of them well enough to address any one but Clark. Will you bring me up to daye on that. Also I use to get back there fair often and stay with Mike or Wayne and get thru the factory. I sure do miss that.

I did get the new Model 7 that was sent me but we have had the damndest run of weather you ever saw here That has kept me from doing any shooting to amount to much. IN fact for four days we had to walk the 5/8th mile to the gate to our place here on the hardtop to get the mail from the box or to catch a ride to Larnie's (my daughter) store thats down the road 3 miles. Even UES did not deliver out this way. Our trouble was not caused by the depth of the snow but by the drifts. I had no chains for the tractor either and it just would not move on that icy hard snow. Thats what you get some times by living in the country. Then too the chores pile up and take so muck of ones time in such weather.

I just recieved one of Bill Rugers latest .357 Maximum Black-hawks with its $10\frac{1}{2}$ "barrel for test and evaluation.Also Dick had sent me 300 rounds of ammo for it and I have some more fimmo coming from Federal for it. I also have one of the new Mequan rests coming to try it out on.

But just as ssoon as things clear up I want to get at that Model 7 first to findout how well it can shoot. First thing was I could not get enough adjustment on the 1½ x 5 Leupole scope to clear it up for my right eye /SO changed to to a 12X Leupold and that one just would not shoot for me . Might have been in the mount but I di d not try to run the trouble down but installed a new Weaver T 10. And since then I have no time to do any thing about shooting it. (Oh yes, Weaver & sending me a mount for the Blackhawk handgun and also a 4 X extended eye relief scope) I just am not a rabid handgun man. Have several and use some for special purposes but just do not care greatly for handgun shooting.)

I am also NCT a short rifle barrel fan.I just cannot see building a good rifle and adopting a good cartridge and then sawing to barrel off to 18 inches and slowing the thing down so much. A close friend gunsmoith just made me up a Custom RugerNO 1 in 7MM Exxpress caliber with a 27" BR quality Shilen barrel .First loads tried give inch groups at just 3,000 FPS using 150 gr Noslers. I wanted a ruger with 28" barrel to match my Colt Sharps.270 that does so well. I get 3275 FPS from 130 gr Win.Silver tip 130 gr factory oads in that sharps.And I get just at 3500 FPS with max loads and

FIREARMS EDITOR - - - OUTDOORS WRITER

no undue pressure signs. However I use the gun on my Yukon and such hunts several times for single head of game such as sheep or goat. For those trips I load my own using 130 gr Nosler bullets to 3360 FPS as I want that shilen BR quality parrel to last me my lifetime. But I had never owned a rugerNo 1 tho I had shot many. None too accurate. I mean really accurate. SO I got this one to try.

I suggested to Dick Dietz after the seminar that made Rem.should chamber a few of the model 7s to the .350 Rem.Mag for those who like a light gun for safety in Dangerous game country such as Alaska's brown and grizzly areas. People that work there, not so muc h hunters. That is the only small cartridge that has sufficient energy and bullet weight (250 gr) for such. I know as I kiled the first one of the Browns with the first out 350 Rem.Mag 600. I chose to shoot t what I had figured was that cartridges max limit to do a presentable job on Brown bear. I had set that at 150 yards max. And my kill measured 146 yards. Bullet hit dead on the shoulder point, broke boths shoulders. The bear fell for ward, grabbed amouthful of driftwood and was dead. A caliber such as the .358 Win. just will not get the job done as well.

BUT one thing I would want in such a chambering is a barrel at least 22" long. That would add gust a wee bit more FPE.

Anyway , that's heaps for your letter and the inflormation.

Best regards

Les Bowman

P.S. The barrel length on the .350 chambering would also cut down on muzzle blast .



Joba Brooks -- Current design Super.

1 jon

Remington Arms CO

Leslie "Les" Bowman
P.O. Box 88
Ocate, New Mexico 87734

BARBER - PRESALE R 0128315

xc: J. P. Linde
S. D. Bennett
J. B. Mroz
R. D. Polley

February 16, 1983

A meeting was held this date to discuss problems involving the Model Seven Floor Plate Base Assembly - Floor Plate Cover Assembly and their related components. Present were:

L. B. Bosquet

W. L. Ganey

J. W. Brooks

D. E. Bullis

G. E. Barnes

P. C. Earl) IN

W. Roark) TURN

The purpose of the meeting was to generate as complete a list as possible of problems being encountered with these components. This initial meeting concentrated mainly on the components as they are received from the vendors and are processed through to final assembly. Noted were:

- Floor Plate Base Blank

 See attached Quality Control report.
- Floor Plate Base Machining Operations

 Mill slot in hinge production has no problems with this operation. Fixturing and gaging appears to be adequate.
 - Ream Front Take Down Screw Hole and Hinge Pin Hole

 Fixturing and gaging appears to be adequate. Quality
 Control study indicates that all hinge pin holes are
 angled relative to the rest of the part.
- Trigger Guard Plate

 Parts are not flat as received from the vendor. Model drawing calls for parts to be flat within .010. Purchase Parts Inspection procedure to be reviewed and vendor will be contacted.
- Floor Plate Base Assembly Brazing Operation

 The brazing of this assembly is yielding approx. 25-30% scrap.
 - assembled FPBA difficult to remove from fixture after braze. A TDR has been issued (ZK-199) to provide a means of removing assembly without damage.

- poor and/or inconsistent braze flatness and/or straightness of parts could be a contributor. power supplied to TOCCO unit appears to vary during the shift.
- difficult to flux and load parts and position brazing preform.

• Floor Plate Cover Blank

As received from the vendor, the blank is dimensionally good. The only problem appears to be that the ends are approximately .010 higher than the center. One Purchase Inspection gage appears to mar the surface.

- Floor Plate Cover Machining Operations

 3.850 ±005 dims is running slightly undersize. It
 was found that a clamp at the milling operation was
 marring the surface. This will be taken care of by
 changing the clamp surface from steel to nylon.
- Floor Plate Cover Assembly Brazing Operation

 This brazing operation runs better than the Floor
 Plate Base Assembly. It produces approximately 5% scrap.

The main problem noted at this operation is a slight warpage in two areas. This may be the result of hot spots developed in the heating cycle. Work is in progress on the redesign of the induction coil.

A TDR will be issued to revise the fixture to provide additional support for the part during braze. This work will have to be coordinated with any change to the coil.

A question was raised concerning the efficiency of the sand tumble in removing sharp edges which cut into the Stock finish. It was also pointed out that some deformation of the Magazine Spring Retainer may be caused by this operation. An operation will be added to check for warpage 100% until coil and fixture design is finalized.

Final Assembly Problems

The main problem mentioned was the binding of the hinge. It is felt that this is caused by improper deburring of the mill cuts. This operation will be reviewed by the engineer and the filers will be reinstructed.

Another cause for binding is covered on the attached study done by Quality Control. The hinge as formed by the vendors runs at an angle. This condition will be corrected.

Steps have been taken to eliminate poor coloring on the Cover and Base Assemblies. New racks have been designed - one in use for Floor Plate Cover (approx. 120/rack), one for Floor Plate Base due by 2/18.

Functional Problems

The single most critical functional problem is the unlatching of the Floor Plate Cover when the gun is fired. This problem is being actively worked on by another group, but if any solutions come out of this committee, they will be implemented. Bending of Floor Plate Covers - thicker material samples are being machined and will be tested to see if any improvement is noted. Thicker Trigger Guard Plates are available and a request has been issued to obtain thicker Floor Plate Base Blanks from the vendor.

LBB:hf Attach.

BARBER - PRESALE R 0128318

Production Liters (siteria where inter)

2-17-33

3365

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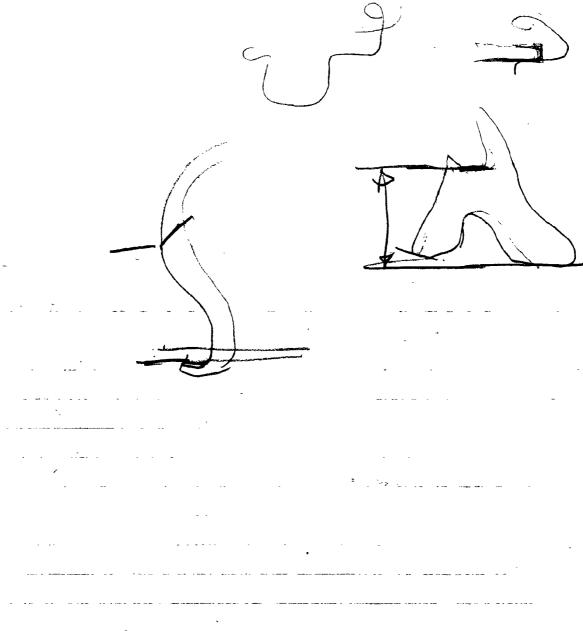
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2 -17-83

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CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER KINZER V. REMINGTON

REMINGTON ARMS COMPANY, INC. Remington CONFINE YOUR LETTER TO ONE SUBJECT ON	LY''	Distribution: C. B. Workman J. W. Brooks C. E. Ritchie T. J. Plunkett
RESEARCH TEST and MEASUREMENT REPO M/SEVEN LWT308 CALIBER — NEW MACH EVALUATION (SPRING LOA	INED 6061 ALU	MINUM FLOOR PLATE DESIGN
-	Prepared by: Date Prepared:	J. Baggetta 2-1-83
Proofisad and Cleared By: J.H. Hennings , R.E. Nightingale, Foreman-Test Lab Foreman-Measurement Lab	Signature	1 Date 1 2 - 21-5"3
C.E. Ritchie, Sr. Supervisor - Testing, Meas. & Mech. Analysis Lab	Signature	. Date

TEST & MEASUREMENT LAB REPORT

REPORT NUMBER:	830241
REPORT TITLE:	M/Seven LWT308 Caliber - New Machined 6061 Aluminum Floor Plate Design Evaluation (Spring Loaded Ball Type Latch Design)
MODEL(S):	M/Seven LW:T.
GAUGE OR CALIBER:	.308
DATE:	1-24-83
WORK ORDER NO.:	C-1856-000
PART NAME:	Latoh
DESIGNER/ENGINEER:	T. J. Plunkett
TEST TYPE:	
1.	PHOTO LAB
2.	STRENGTH TEST - NO. OF GUNS TESTED
3.	Function test · no. of guns tested3
4.	ACCURACY TEST · NO. OF GUNS TESTED
5.	MEASUREMENTS - TYPE: Headspace
6.	ENVIRONMENTAL TEST
7.	AMMUNITION TESTING & EVALUATION - TYPE:
8.	VISUAL EVALUATIONOUT OFGUN SAMPLE
9.	ENDURANCE - NO. OF GUNS TESTED:3
	NO. OF ROUNDS PER GUN: 30
	TOTAL ROUNDS FIRED IN TEST: 90
	AMMO TYPE: MAGS; TARGET:

RIM FIRE____

BARBER - PRESALE R 0128326

REMINGTON ARMS CO., INC: Firearms Research Division

Report No. 830241

February 1, 1983

TO:

R. NIGHTINGALE

FROM:

J. BAGGETTA

REPORT TITLE:

M/SEVEN LWT. .308 CALIBER - NEW MACHINED 6061 ALUMINUM FLOOR PLATE

EVALUATION (SPRING LOADED BALL TYPE LATCH DESIGN)

ABSTRACT

A request was received from T. Plunkett, Current Firearms Design, to evaluate the M/Seven LWT., redesigned Floor Plate Latching System. (Spring Loaded Ball Type Design.)

SCOPE OF TEST

To evaluate the performance of the redesigned M/Seven LWT. - .308 Caliber Floor Plate Latching System checking the floor plate latch opening on recoil.

TEST RESULTS

A. Jack Live Round Fire Function Test

o Three M/Seven LWT. .308 caliber rifles were fired a total of 45 rounds (15 rounds each) experiencing no malfunctions.

B. Field Function Test

o Three M/Seven LWT. .308 caliber rifles were fired a total of 90 rounds (30 rounds each) experiencing no malfunctions.

M/Seven LWT. .308 Caliber — New Machined 6061 Aluminum Floor Plate Design Evaluation (Spring Loaded Ball Type Latch Design)

Report No. 830241 Page 2

REPORT TEXT

Three (3) M/Seven LWT. .308 caliber rifles with the redesign latch (spring loaded ball-type design) were fired a total of 90 rounds (30 rounds each) experiencing no malfunctions.

TEST PROCEDURE

A. Measurements

o Headspace - (Refer to Appendix "A" Data Sheet No. 1.

B. Test Conditions

Condition No. 1 - Indoor Jack Shooting

- o The test was run using the Test Lab shooting room jacks.
- O The rifles were loaded with 4 rounds in the magazine and one in the chamber.
- o Various speed feeds were used such as: Slow, Medium and Fast.

Condition No. 2 - Ilion Fish & Game Club Outdoor Range

- o The test was run using the Ilion Fish & Game Club Rifle Range.
- o The weather was overcast, 320 and windy.
- o The rifles were loaded with 4 rounds in the magazine and 1 in the chamber.
- Various speed feeds were used such as: Slow, Medium and Fast.
- o Four shooters were used incorporating the round robin system.

C. Ammunition

Indoor Jack Shooting

o Winchester - 200 gr. Silver Tip

Field Function Test

- o Remington 180 gr. Soft Point
- o Winchester 200 gr. Silver Tip

D. Rifles Used In Test

M/Seven LWT. .308 Caliber

7600139 B6226256

7600050

BARBER - PRESALE R 0128328

M/Seven LWT. .308 Caliber - New Machined 6061 Aluminum Floor Plate Design Evaluation (Spring Loaded Ball Type Latch Design)

Report No. 830241 Page 3

REPORT TEXT - cont'd.

E. Hi-Speed Movies

- o Hi-Speed movies were previously taken of this design showing latch motion by Test Lab personnel in the Photo Lab Room.
- o Hi-Speed movies can be reviewed in the Photo Lab Room.

F. Photos

- o Pictures were taken of the redesigned M/Seven LWT. .308 caliber rifle. (Refer to Appendix "A" Data Sheet No. 2.)
- o Pictures were taken of the old style latch M/Seven LWT. .222 caliber rifle. (Refer to Appendix "A" Data Sheet No. 2.)

Report No. 830241

APPENDIX "A"

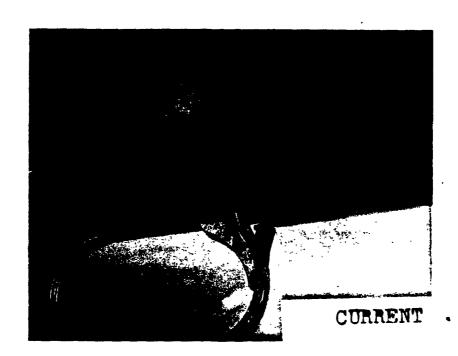
DATA SHEETS

M-7 Lut 308 Caliber Redesign Latch

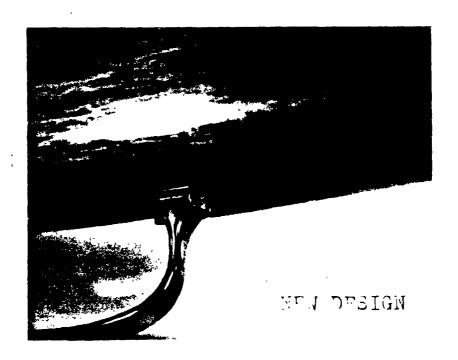
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DATA Sheet # 2

M-7 Lut . 222 caliber



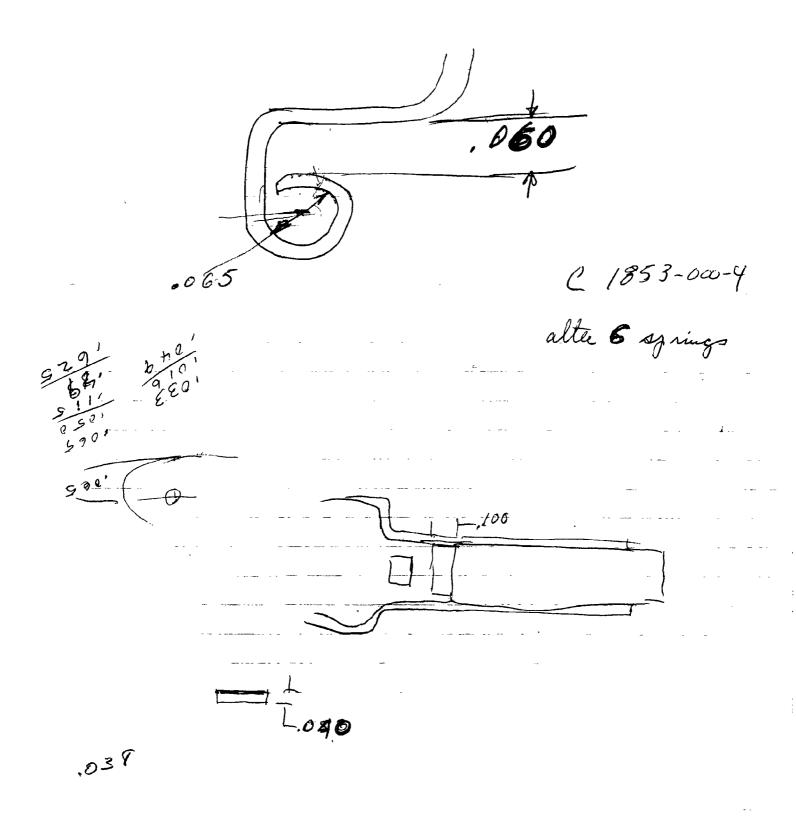
M-7 Lut 308 chliber



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FROM: T.J. PROUBERT

2/32/83

MISS FLOOR TURTE LATER STRINGS. MERS.

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REPORTS: report no. 823191

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1-76.75: 1-76.15-16-83 15 TO 20W 76.15-16-84/85 15 MARENHAL 2-18-48/52 15 THE TERINGE STRINGS

SHOULD BE IS.

#### **BARBER - PRESALE R 0128335**

Writers seminar gama

7600/25- 8-9 #5

116 9/2 #5

051 9/2 #5

124 9/2 #5

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140 8/2-9 #5



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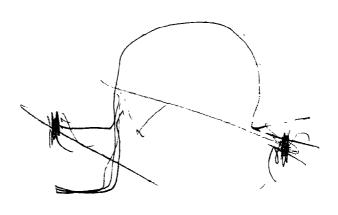
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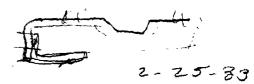
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#### **BARBER - PRESALE R 0128339**

Xc: S. D. Bennett P. C. Earl Z. J. Kowalski
 \( \frac{J}{J} \) W. Brooks W. L. Ganey J. B. Mroz
 D. E. Bullis J. A. Harter R. D. Polley
 G. E. Barnes J. W. Kelly

February 23, 1983

J. P. LINDE

RE: MODEL SEVEN FLOOR PLATE BASE, ETC. - PRODUCTION PROBLEMS

Attached is a list of items requiring follow up which came out of the meeting held 2/16. Responsibilies have been assigned for each item.

L. B. Bosquet

LBB:hf Attach.

#### FLOOR PLATE BASE BLANK

- Review Purchase Inspection procedure. Is it adequate based on experience gained to date?

Bennett Quality 2.

- Send marked print to vendor indicating the results of Quality Control's study. Work up a program to resolve problem areas.

Bennett Purchasing

- Marked prints have been sent to vendor requesting samples from thicker material (.062).1 644

Bennett Purchasing

### FLOOR PLATE BASE (MACHINING OPERATIONS)

- Review the .100 + .005 slot in the hinge. Engineering layouts indicate a potential bind condition at assembly. Engineering recommends that this dimension be changed to  $.115 \pm .005$ .

Research Bennett

Bennett

- Review reaming operation to verify that part is located correctly.

Bennett

- Review filing operation - is it adequate? Is it being done correctly?

Bennett

#### TRIGGER GUARD PLATE

- Quality Control study shows these parts are bent as much as .035. The model drawing calls for parts to be flat w/in .010. Review gaging of incoming parts.

Bennett

- Samples of Trigger Guard Plates have been received made from .062 material. They were assembled and turned over to Research for testing 2/22. Testing complete

Kowalski Research ____

#### FLOOR PLATE BASE ASSEMBLY

Brazing operation

Bent Trigger Guard Plates may be a contributor to the brazing problems. Run a controlled study for one (1) shift using screened or straightened Trigger Guard Plates (approx. 250). Monitor the output to determine effect of flatness on yield. This study should also indicate whether or not there is a relationship between poor braze and specific times during the shift.

Kowalski Polley Production Quality Control

#### FLOOR PLATE BASE ASSEMBLY - Contd.

TDR (ZK-199) has been issued to make removal of assemblies from the brazing fixture easier.

Kowalski Tool Design

3.

- TDR's (ZK-197 and 198) have been issued to alter the drill jig and pinning gage for positioning and sizing the rear take-down screw hole.

Kowalski Tool Design

#### FLOOR PLATE COVER BLANK

review gaging of hinge pin hole as formed by vendor. We should check to be sure this is 90° to long axis of part and parallel to the flat portion of the tab.

Bennett

#### FLOOR PLATE COVER - PROCESSING

- review reaming operation (Production has no problems with this operation) to verify that drill jig is orienting part correctly.

Bennett

- sharp edges at Latch end of part are cutting into the finish on the Stock. Run a sample of parts through sand tumble prior to brazing operation.

Bennett Production Research

- review deburring operation - is it adequate? Is it being done properly?

Bennett

obtain quotation and lead times to go to thicker material (.062 or possibly .078).

Bennett Purchasing

#### FLOOR PLATE COVER ASSEMBLY - BRAZING

- continue work already in progress to redesign induction coil for better heat. Redesign of brazing fixture to add additional support (if possible) will be investigated when coil design is finalized.

Polley Kowalski

- Thicker Floor Plate Covers (.062 material) have been processed and are ready for braze. They will be turned over to Research for testing by 2/28.

Production Kowalski

Research - Doug

LBB:hf

RD_6565 Rev. SMI: 3-26-79

## ESTIMATE # 4457

#### ESTIMATED SAVINGS & RETURN ON INVESTMENT

<del></del>				
ENGINEER: T.R Andrews				
DATE: February 4, 1983	1 ST YEAR OF	OPERATION	3 " YEAR OF	OPERATION
<u></u>	Present	Proposed		
	Stamped Steel	Cast Alumnium.		
	Trigger 64 Assy.		Present	Proposed
·		111111111111111111111111111111111111111		F-808 5EC
Forecast Year	1984	1	1986	
Quantity Forecast (Model Seven Lut)	31600	İ	39,755	
OPERATING COSTS				
WE WALLED COME		1		
Purchased Farts	\$ 92,900	\$ 99,000	\$128.200	\$ 136.600
New Material		-	_	
	01 500	1151.00		65.500
Standard Labor	81.500	47.600	112,500	65,700
Labor Variance 3	57.100	28,500	78,700	39.300
Industrial Relations @ 47.67.	66.000	36.200	91.000	50,000
Supplies				
Tool Replacement /				
Cutter Grind	18.900	14.400	26.500	30,200
Tool Maintenance	10.790		43.300	~0.400
		<u>-</u>		·····
Maintenance				
<u> </u>	14.700	5,900	21,900	3,900
Ecuipment Depreciation 3 7.57, 1		12,500	-	12.500
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Sub Totals	\$331 100	4 \$ 244,100	\$ 456,800	4 \$ 333,100
Gross Savings Before Admin. Exp.	<u> </u>		<u> </u>	
Gross Savines Selora Almin. Exp.		\$ 87.000	,	\$ 125,700
Admin. Exp. 84.3% Gross Savines		3 3 700	4	3 <u>\$ 5,40c</u>
Sub Totals	\$ 221 100 5	HB \$ 247.800	\$ 458.800 4+	3 \$ 230 sac
200 100213	. <u># 331,190</u> A	n = 11.200	<u> </u>	3 338 300
SAVINGS IN OPERATING COST		\$ 93 300		\$ 120,300
Less: Income Tax \$48.5 \$		( <u>\$ 40,400</u> )		( <u>\$ 58,300</u>
Flus: Amortization of Investment Tax Co	redit	\$ 13,400		<b>3</b> -
14 year 8 %; 3 year 0				
NET SAVINGS		\$ 56.300		\$ 62,000
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THY POSTALINT		1		
Project Expenditures		\$ 167,000		\$167.000
Manufacturing & Working Facilities		\$ -		\$ -
Net Change in Working Capital		(\$ 17.700)		\$ 25.800
Total Capital Required for this Proje		\$ 149,300		\$ 141,200
TOTAL CADITAL HEAGET SET TOT MITS 11016		<del>3 (77,300</del>	•	<u>5171,200</u>
RETURN ON INVESTMENT - THIS PROJECT		37.7 \$		43.97
Net Savings - After Amortization of Open	ration Charges	\$ 54.700		\$ 60,400
Project Operation Charges		\$ 43,000		\$ 42,000
Less: Administration Expense 94.3 %	&			
Income Taxes @48.5 % (Factor		(\$ 21,300)		18 -1 -00
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Total Capital Required Including Rese	earch &	1		
Development & Other Charges		\$ 170,000		\$ 161,900
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RETURN ON TOTAL CAPITAL REQUIRED		32.2 \$		37.37
Equipment to be Released				
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Increased Space Requirements (Decrease)	·	<u></u>		
Production Capacity				
Forecast Burdening		\$		
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MODEL SEVEN LWT.

MEETING OF 2-28-83

#### PRESENT:

C.B. WORKMAN E.W. YETTER, JR.
T.G. BAUMAN S.R. FRANZ
A.A. HUGICK D.E. BULLIS
C.E. RITCHIE J.W. BROOKS

The following items are scheduled to be done and followed by people designated:

#### o Bob Orf, Doug Bullis

200 Stocks ready for sand are to be drilled and a reinforcing screw added in the Model Shop 3-1. Production will furnish the Stocks 3-2 and 3-3.

## o Tom Bauman, Adam Hugick

Pick up 250 Model Seven Trigger Guards and have Model Shop alter rear tab to positive  $4^{\circ}$  -  $5^{\circ}$  downward bend. (Opposite present bend) Mark parts, measure parts, carburize and heat treat parts. Remeasure parts. Complete by 3-3.

## o Evan Ritchie, Ed Yetter, Scott Franz, Doug Bullis

Production assemble pinned Stocks to 180 actions in 308 Caliber with help of R&D. Use special heat treated Trigger Guards. Send thru Gallery 3-3 and 3-4. R&D will select 10 guns to field test and at least three for endurance to 3000 rounds. 3-5 and 3-7. Inspect parts.

#### o Doug Bullis

Have 25 latches heat treated. Use in above rifles. Use in two (2) endurance rifles if field tests are satisfactory.

MODEL SEVEN LWT - Contd.

#### o Doug Bullis

Floor Plate base machined to take .080 Trigger Guard Plate. Ready from Model Shop 3-1.

## o Doug Bullis

Trigger Guard Plate .080 material in inspection. Ready for half to be carburized 3-1.

## o Doug Bullis and Ziggy Kowalski

Braze Floor Plate base to Trigger Guard. Plate 3-2 or 3-3.

#### o Doug Bullis

Inlet 10 Stocks .030 deeper to be used with floor plate bases assembly with .080 Trigger Guard plates.

## o Doug Bullis

Mark latch spring print for vendor. Spring to fit .080 Trigger Guard Plate and 1/16 pin in latch. Order samples 3-2.

#### o Doug Bullis

Mark prints of Trigger Guard 3-1 for Brad Bosquet to give to F. Ambrose 3-2 when he visits him.

### o Doug Bullis

Check fit of .060 floor plate cover on present floor plate base assembly. Check strength of .060 cover.

Model ? Up dato on meeting of 2.28-33 200 stocks completed in Model slop I returned & production. 250 Trym Hund hove been head the near tab altered to 4 30! They have all been heathered. The last 150 are being meaned, The first 100 we being used to assable. 308 cal rifly with puned alabothet one commy there the live. Put John is clarity a comple of the first 20, the second 1004 The last 150, The are as follows; We will andune test somple

· Floor Pith Quards howe been mochined to take the the, so trype I word date.

+ samples that how boken carbunged are with ziggy Knowskie I have brozed to Floor plate bosso.

e Broging of above soits will be done this was.

we done this corels.

for up reply, Purchaming or fracia to

ship Fri F remberal mabe a doyan Tugjer march 11th. Is used with longer hools to fit , 080 meti. .

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from the 100 let & The 150 let, Phil believes The 150 lot sie closer to spring lemper & well not bereat of adjutte. If They are salisfactory at endurance terling cos can go with the brever a bleis morning svin Detakis, Ed getter & Dong Bellis are with the excelled during assubly of approx 30 rifles. The test late will use some of there for field & reducent tothey. - Heat trested lately are being juties

sever refles. 2 of those will be used in the endurance testing in the Two Lifeent heat theretel Trigger Grando

5 pine + or D. wagne (Hour marile 15.) . Thick where of 222 cal followers required in may. M.7 + 750 · I present prototype is satisfactory in texts how many more would be reguned for production, . Can vendor make the required amount on 1 who temporary tooling. If not how many comes 5000 he make on present temporary tooling, · when is latest date he has to start to low be went to sets for may lamble, for their toligher.

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J. M. Brooks

RD-49-8

REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE

Remington QU POND

DETERS

"CONFINE YOUR LETTER TO ONE SUBJECT ONLY"___

XC: S. Franz

R. L. Snedeker E. W. Yetter, Jr.

March 4, 1983

TO: J. R. SNEDEKER

FROM: E. L. BARNES

PROBLEM: M/7 LWT Latch Spring

30 - guns from different assemblers. METHOD:

> Latch spring disassembled and measured for .4705/.5075 dimension. (Could not get same

size sample from each assembler.)

OBSERVATIONS: Assembler 83 sample of 17 - 5 out of tol. = 29%

Assembler 93 sample of 6 - 2 out of tol. = 33% Assembler 91 sample of 3 - 1 out of tol. = 33% Assembler 30 sample of 3 - 0.K. Assembler 22 sample of 1 - 0.K.

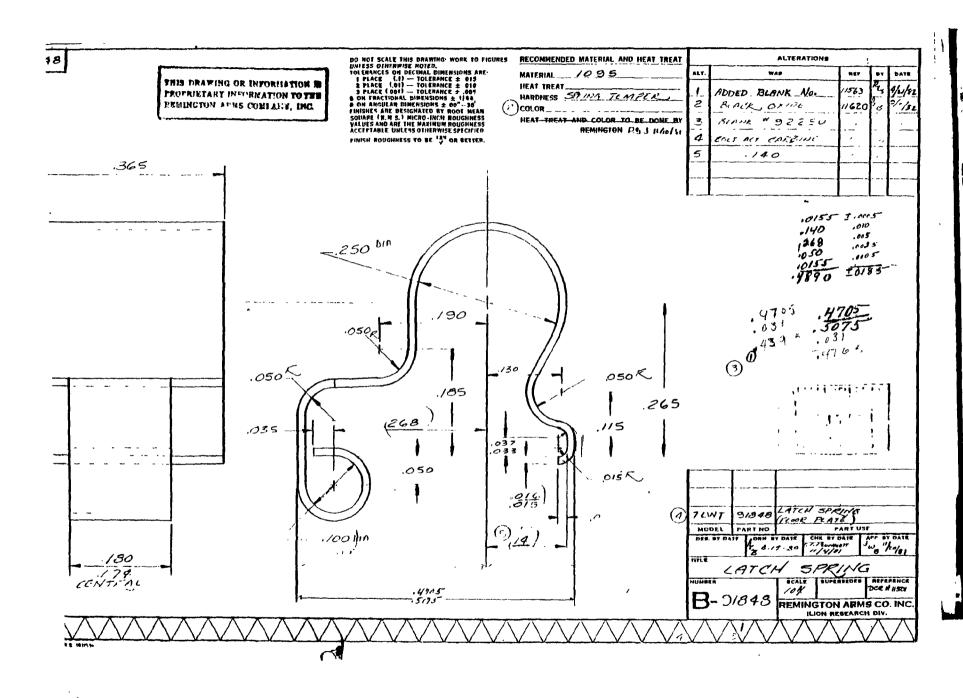
ELB/bdm Attachs.

REGI	JEST FOR MEAS	UREMENT ASSIS	TANCE RESULEST & -
PERT NO. SPER.	Scott Frank 1 3-1-9 CFERRION GESCRIPTION	HECEL PORT DESCR	Latch Spring CEPT SLOQ.
Meaus u Differen	re .4705/,5075 T Assembler's	Dim. After Ass.	embly. From
REMARKS	1. Barnes	DATE 3-2-83	SAMPLE SIZE
	. MEASURED	DIMENSIONS	
CESC. OF CHARACTERISTIC	Assem. 93	Assem 91	Assem. 30 Assem. 22
N= 17 Z= .5053 X= .0072	N= 6 V : .5052 X = .0065	N= 3 F= ,499 L= .0084	N= 3 x = .4947 L = .0066
7005L 7005L 740.01H. CMG.01H.	700EL 700EL 240-0111- 346-0111. 4705 75075	HODEL HODEL CHO.JIH. CHO.JIH. . 4703 -	-0021 -0021 
s dim. As dim.	s din- × s din- ×	x Gin. x gin. x	z din. A z din. X
1.5017 - 16,5126 X		1.4965	1,4963 1,503
3 .4945	3.5725 X	2   .5093   X	3,5062
4 .5/5	4.4998	1	
5 5014	5 .5024		
6,4958	6.5144 X		
7 .5014			
8 .5086 X			
9 .5/57 X			

10 .5033

,5017

NOTE: X INGICATES OUT OF TOLERANCE



1. .

BARBER - PRESALE R 0128352

SN 3676 Boquith slot Jatela with more relief.

RD-49-B

# REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE

Remington.

PETERS

xc: C.E. Ritchie
D.D. Ricci
D.E. Bullis
P. Nasypany
S.D. Bennett

"CONFINE YOUR LETTER TO ONE SUBJECT ONLY"_

Ilion, New York March 7, 1983

TO:

C.B. WORKMAN

FROM:

J.W. BROOKS

SUBJECT:

MODEL SEVEN AND 700 222 CALIBER

NO-BIND FOLLOWERS

The Model 700 and Seven rifles in 222 Caliber are scheduled by Production for assembly the last week of April and May. Volumes are 1700 for the Model 700 and 4,000 for the Model Seven.

We have 650 prototype stamped no-bind 222 Caliber Followers on hand. They were reformed by the vendor from Model 600 stamped Followers. They are to be used for two purposes.

- o Check to see that the no-bind Follower performs as well as the standard stamped Follower.
- o Investigate new magazine springs to improve feeding over present production spring.

Testing has been delayed because the Followers had to be recorded as the first sample was under size. The testing was to be completed by March 15 which is the latest date Production can order parts to be delivered in time for May I assembly. The date has been confirmed with the Follower vendor as he needs to make new dies. The spring vendor has not been contacted as yet to see if his date can be changed. The Test Lab cannot finish the first phase of their spring testing for two weeks. The second phase will be completed when more production rifles are available in May.

To: C.B. Workman

-2-3-7-83

Testing of the no-bind Followers will begin this week with current production springs vs. standard Followers and production spring.

If testing is satisfactory and a decision can be made to release the Follower drawings to Production by March 15, this will be done.

If this is not possible and more time is needed and the prototype Followers look promising the vendor stated that he can furnish us approximately 5,000 prototype Followers a week. He can alter all we have on hand if we wish to go this way before going to permanent tooling.

If we decide to notify the vendor by March 15 to commence the permanent tooling, he stated that in approximately two weeks he would have approximately a \$1500 tooling charge toward the final charge in case we need to stop the tooling for another design. The final tooling charge total will be under \$4,000 for complete new tooling.

If Phase One does not give enough of a confidence level to order new springs we will use current production springs until testing is completed. Feeding should be no different than present.

JWB: js

BARBER - PRESALE R 0128356	3-7-83
fot Par Phil Trigger New Treat 20 RC 47 15 Al 91	Trends at 5 date
20 RC 47 15A 91	= 26 B
100 RC 48 15N 91	= Rc69
150 RC 40 15N 85	= 2247-48
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BARBER - PRES						
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#### **BARBER - PRESALE R 0128358**

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DON'T SAY IT - WRITE IT

From John WB 10060 5 ulgest; M722 Parts 6 16, 793 + 617056

Plan do not sing thise outs at this aims. Please re instante with us in a mouther or so.

5 Touged followers

## DON'T SAY IT-WRITE IT CC : J.W. 5 ROOKS

TO JIM SNEDEKER	Location	
From D. BULLIS	Location	Phone No
Subject M/7 LW7 STOCKS	(POINTS TO CHECK)	Date <u>3 - 9 - 8 3</u>

- RECEIVER HOLE SPACING IN STOCK.
- . FRONT TAKE DOWN SCREW HOLE TO BBL. BRACKET SURFACE.
- · POSITION OF HOLES IN RELATION TO INLETTING (SIDE TO SIDE).
- POSITION OF RECEIVER & MAGAZINE INLETTING IN RELATION TO
  FLOOR PLATE BASE INLETTING.
- POSITION OF TRIGGER HOUSING OPENING IN RELATION TO TRIGGER GUARD PLATE INLETTING.
- · AMOUNT OF FILL OR CHIPS COVERED WITH FINISH IN INLETTING.

G-88 REV. 10-62

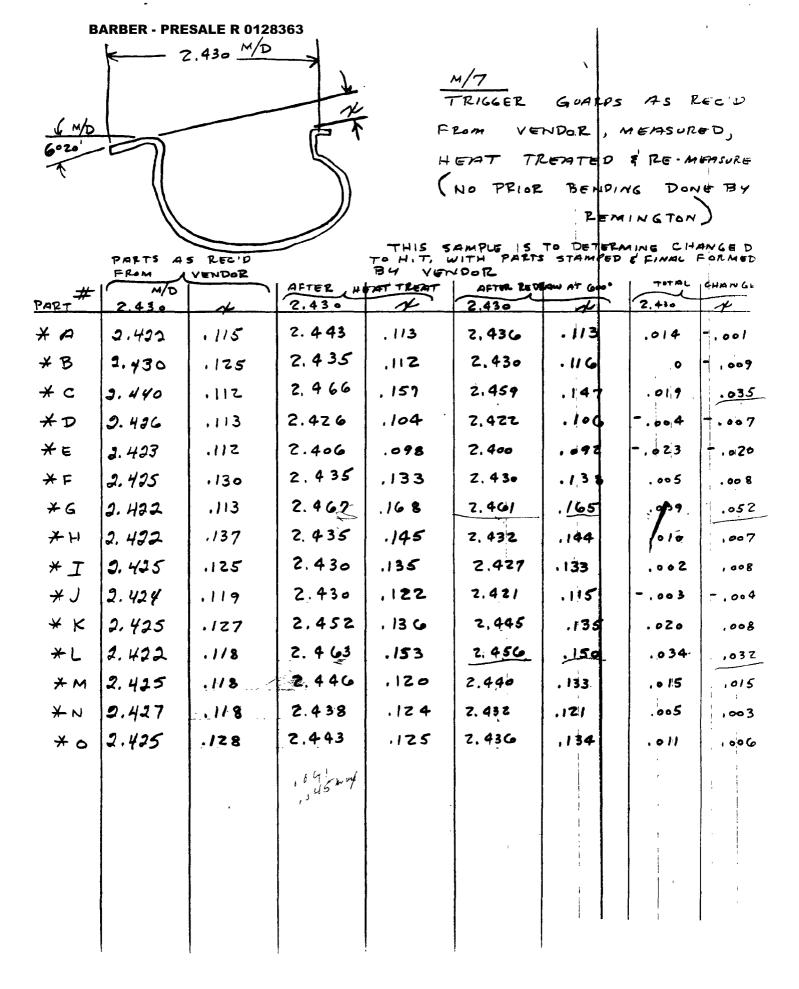
SECURITY IS EVERYONE'S RESPONSIBILITY

BARBER - PRESALE R 0128361
Per Duayn : 3-9-83
· Trujor Hand Peats 250 2 deg (. 080)
'o Flor PB, 3-4 26h 3875 250 pc.
¿ Trype Quand \$2300 250 pt.  Just had, milrest week  1200
. Spring , 300 pe \$465 zwbs.
o comers 11,75 250 po one week

GUN # 37 05 AT 3165 RDS GUARD # D3

TART {2.479 LENGTH 2.486 } 3165 RDS

.230 OFFSET .232 } 3165 RDS GUN# 3765 AT 3/65 RDS GUARD# JO \$2.460 LENGTH 2.474 \ 3/65 RDS START \ .230 OFFSET .224 \ 3/65 RDS SECURITY IS EVERYONE'S RESPONSIBILITY



2.430

SH.# |

* H.T. THEN POLISH & COLOR"

,				**		<b>A V V V V</b>		
M/7	TRIGGE	R GUA	ARD (1	AFTER TRAFFER	EATED)	•	HED & COLURG	b
PART#	2.430 Before Bend	.295	2.430 AFTER BEND	.295	2.430	. 295	2.430	
AO	2.430		2.414			.251	2,448	
AI	2,423		2410			. 247	2.446	
A 2	2,427		2.462	! * *		.315	2.383	
A3 ¥	2.435		2.412	1295	2.426	.285	2.420	<b></b>
A4 *	2,424		2416	.253	2,438	.256	2.443	
A5 *	2,439		2.4/2	.231	₹2.466	.220	2.4.75	
AG	2,435		2.413			. 305	2.401	
A7 *	2.439		2.468	.245	2,434	.244	2,440	
AB	2,440		2.417			.253	2.43/	
<u>A9</u>	2,433		2.413			.230	2.451	
B0 *	2.439		2.420	.263	2.446	.256	2,441	
<u>B1</u>	2.435		2.400			. 280	2.399	
B2 +	7.425		2.390	.256	2.414	.254	2.4.17	0
<u>B3</u>	Z. 435		2.412			.282	2.405	
B4	2.435		2.404			.289	2.400	
B5	2.435		2.418			. 257	2.440	
B6 *	2.431		2.419	.271	2,446	.273	2.447	•
<u>B7</u>	2.428		2.411			.275	2.421	
Вв	2.440		2.400			, 225	2.458	
<u>B9 *</u>	2,425		2.416	. 280	2.441	.272	2.454	
<u></u>	2.440		2.412		~	.260	2.438	
101 ×	2.423		2.403	BROKEN	2.461			l. 
<u>c s</u>	2.427		2.417		<u> </u>	.260	2.425	
<u>c3</u>	2.432		2.400			.270	2.412	
C4 ×	2.432		2.415	, 230	2.465	.23/	2.465	
<u>c5</u>	2,427		2.416			. 2/2	2.457	l
<u> </u>	2.437		2.416			.264	2.425	<del>-</del> -
	· <del></del>							

<u> </u>	430	
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(/	4030	1295
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M/7 TEIGGER GUARD (HEAT TREATED)  START BEND 4°36'  2.430  BEFOLG BEND 4°36'  C.7 x 2.427  C.8 z.42z  C.9 z.435  DO z.426  DI z.435  2.436  2.430  2.430  2.430  2.430  2.430  2.430  2.430  2.430  2.430  2.430  2.430  2.430  2.430  2.430  2.430  2.430  2.430  2.430  2.430  2.430  2.430  2.430  2.430  2.430  2.430  2.430  2.430  2.430  2.430  2.430  2.430  2.430  2.430  2.430  2.430  2.430  2.430  2.430  2.430  2.430  2.430  2.430  2.430  2.430  2.430  2.430  2.430  2.430  2.430  2.430  2.430  2.444
PART# 2.430 .295 2.430
C8       Z.422       Z.420       . 233       2.452         C9       Z.435       Z.409       . 265       2.444         D0       Z.426       Z.407       . 279       2.402         D1       Z.435       Z.400       . 240       2.431         D2       Z.436       Z.415       . 257       Z.435       . 261       Z.444
C 9       2.435       3.469       .265       3.444         D 0       2.426       3.467       .279       3.402         D 1       2.435       2.400       .240       3.431         D 2       2.436       3.415       .257       2.435       .261       2.444
Do       2.426       2.407       .279       2.402         D1       2.435       2.400       .240       2.431         D2       2.436       2.415       .257       2.435       .261       2.444
D1 Z. 435 2.400 .240 2.431 D2 x 2.436 2.415 .257 Z. 435 .261 2.444
D2 + 2.436 2.415 .257 2.435 .261 2.444
D3 + 2.437 2.427 .255 2.474 .230 2.479
D4 * 2.435 2.420 .245 2.459 .245 2.462
D5 2.437 2.406 .265 2.427
D6 * 2.429 2.406 .277 2.416 .275 2.419 0
D7 x 2.430 2.419 .244 \\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\
D8 + 2.435 2.420 .247 2.450 .237 2.458
D9 x 2.438 2.414 .287 2.436 .281 2.430
EO * 2.434 2.420 .213 \$2.475 .214 2.481 8
E 1 2.435 2.404 . 240 2.448
E2 x 2,437 2,416 .283 2.425 .286 2.428 -
E3 2.435 2.404 .263 2.431
- E4 * 2,435 2.426 .220 2,488 .225 2.491 6
E5 x 2.439 2.408 .267 2.453 .265 2.452
FG + 2.435 2.413 .210 2.480 .202 2.486
V E 7 + 2.427 2.409 .232 2,460 .226 2.464
E8 * 7.421 2.40 .245 2.458 .240 2.457
E9 * 2.438 2.418 .220 12.475 .217 2.475
Fo 2.4/2 .288 2,4/8
FI 2.401 .285 2.400
F2 2417 .258 2.422
F3 2.410 .235 2.441

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/ 1	TRIGGE	R GUA	ARD (I	HEAT TR	EATED)	FINISH	SO I COLORS	0
PART#	2.430 Before Bend	.295	2.430 AFTER Bend	.295	2.430	,295	2.430)	
F4	·	-	2.402			.275	9.422	
F5			2.408			.27/	9.423	
F6	<del></del>		2.401			. 282	2,433	
F 7	·		2.402			,260	2.431	
Fg	·		2.407	·		.275	2.4//	
F 9			2.400			, 268	2.420	
GOX			2.403	, Z 7 5	2.420	,270	2,428	
GI *			2.403	.242	2,411	.265	2.420	
G2			2.405			. 270	2.422	
<u>63</u>			2.413	<del></del>		. Zo5	2.456	
<u>G4</u>			2.407			,276	2.403	
<u>G5</u>			2.408			, 268	2.430	
G6 *			2.405	.258	2.425	.255	2.415	<u> </u>
<u>67</u>			2.402			.255	2.441	<del></del>
<u> 68</u>			2.410			.287	2,423	
<u>G9</u>			2.418			.290	2.425	
110			2.404			. 270	2.411	
141			2.411			.260	2 440	
H2			2.410			.247	2.436	
<u> H3 ×</u>			2.392	.249	2.422	.246	2.434	
<u> H4</u>			2.424			. 225	2,438	····
<u> </u>			2.412			, 273	2,415	
H6 *			2.392	.249	2.444	.240	2. 4 43	
H 7			2.406			.287	2,408	
148*			2.404	.268	2.444	.279	2.445	
H 9			2.406			.293	2.403	<del></del>
<u>'Io*</u>			2401	.270	2.432	.263	2.434	-

BARBER - PRESALE R 6428367

		1/		7 7		742 <b>T</b> S	COMPLETELY	
M/7 PART#	TRIGGE	BEND 4º70'	42D (1	AFTER	EATED)	FIN' SHE	D & COURED	<b>!</b>
PART#	START 2.430 Before Bend	.295	2.430 AFTER BEND	(.295	2.430	1295	2,430	
II			2.404			, 3a <b>5</b>	2,394	
I2			2.405			,262	2.428	
_I3 *			2.402	. 280	2,419	. 276	2,418	0
<u> I4 *</u>			2.404	.257	2.430	.264	2.427	
I5			2.405			.265	2.407	
I6			2.406			.270	2.422	
<u> 17 *</u>			2.401	, Z 3 17	2.453	,230	2.460	
IS			2411	· · · · · · · · · · · · · · · · · · ·		.240	2.442	
I9			2413			.295	2.460	
J0 *			2.40	.227	×2.464	.230	2460	
<u> </u>			2.425			.257	2,444	
J2			2.401			.280	2.40/	
J3			2.417			.245	2.463	
J4			2.407			.267	2.431	
J5 *			2.404	. 275	2.426	.270	2.428	
16			2.405			.3/0	2.402	
J7			2.407			,217	2,406	
_J8 *			2.417	,283	2.472	.282	2.424	
J9			2.401			. 295	2.402	
<u> Ko *</u>			2.401	,249	2.446	.240	2.456	
KI *			2.406	.279	2.428	, 283	2.4 22	-
KS			2.409			,253	2.439	
<u>K3</u>			2410			. 250	2,423	
<u> K4</u>			2.411			.257	2.427	
° K5 *			2.400	,243	2,447	.245	2.448	
K 6 *			2.405	.243	2.454	. 239	2.460	
<u> K7</u>			2.405			.289	2.455	
·								→ · ·

BARBER - PRESAL	ETR 0728368
	295
	4030

M/7 T21GGET GUMED (HEAT TREATED) STATET BAD 4150 12.430  2.430	,			_// .	A S		708TS 6	COMPLETELY	
PART 2.430 .235 ASTER SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH SEARCH S	/ !	TRIGGE	BEND 4º70'	ARD (	TEAT TR	EATED)	FINISHE	ا و دهده و و	
K.9       2,403       .264       2,435       .256       2,431         LI       2,408       .264       2,435       .256       2,431         LI       2,408       .269       .245       2,442         L2 +       2,449       .250       2,439       .251       2,439         L3 +       2,400       .239       2,468       .227       2,466         L4       2,404       .239       2,468       .227       2,466         L4       2,404       .233       2,451       .224       2,431         L5       2,402       .233       2,451       .224       2,455         L7       2,402       .250       2,453       .245       2,460         L7       2,402       .250       2,423       .245       2,460         L8       2,402       .250       2,423       .245       2,430         L8       2,402       .250       2,424       .243       2,430         M0 #       2,402       .250       2,442       .243       2,430         M1       2,403       .260       2,416       .277       2,430         M2       2,403       .260       2,427	PART#			2.430 AFTER	.295	2.430	.295	2.430	
Lo # 2,468 , 264	Kg			24/3			. 278	2.415	
Lo # 2408 .264 2.435 .256 2.431  LI	K-9			2.403			.287	2.404	
LI	Lo *			2.468	.264	2, 435	. 256	2,431	<u></u>
L3 *       2.400       .239       ₹.468       .227       ₹.466         L4       ₹.404       .273       ₹.431         L5       ₹.402       .286       ₹.431         .26 *       ₹.402       .286       ₹.451       .224       ₹.456         L7 *       ₹.402       .250       ₹.453       .245       ₹.460         L8 **       ₹.402       .250       ₹.424       ₹.430       ₹.430         L9 *       ₹.402       .250       ₹.424       ₹.430       ₹.430         M0 *       ₹.401       .243       ₹.430       ₹.430         M0 *       ₹.401       .243       ₹.450       ₹.450         M1       ₹.401       .243       ₹.430       ₹.430         M2       ₹.403       ₹.404       .2430       ₹.430         M4       ₹.403       ₹.403       ₹.200       ₹.430         M6 *       ₹.403       ₹.200       ₹.404       ₹.215       ₹.405       Ø         M8       ₹.403       ₹.404       ₹.215       ₹.405       Ø         M9 *       ₹.403       ₹.404       ₹.235       ₹.405       Ø         M9 *       ₹.404       ₹.235	L			2.408			. 245	2,442	
L3 *       2.400       .239       ₹.468       .227       ₹.466         L4       ₹.404       .273       ₹.431         L5       ₹.402       .286       ₹.431         .26 *       ₹.402       .286       ₹.451       .224       ₹.456         L7 *       ₹.402       .250       ₹.453       .245       ₹.460         L8 **       ₹.402       .250       ₹.424       ₹.430       ₹.430         L9 *       ₹.402       .250       ₹.424       ₹.430       ₹.430         M0 *       ₹.401       .243       ₹.430       ₹.430         M0 *       ₹.401       .243       ₹.450       ₹.450         M1       ₹.401       .243       ₹.430       ₹.430         M2       ₹.403       ₹.404       .2430       ₹.430         M4       ₹.403       ₹.403       ₹.200       ₹.430         M6 *       ₹.403       ₹.200       ₹.404       ₹.215       ₹.405       Ø         M8       ₹.403       ₹.404       ₹.215       ₹.405       Ø         M9 *       ₹.403       ₹.404       ₹.235       ₹.405       Ø         M9 *       ₹.404       ₹.235	L2 *			2.419	. 750	2.439	.251	2.439	
L4  L5  2.404  2.402  2.286  2.41/1  2.406  2.408  2.33  2.45/  2.224  2.456  2.460  L8 **  2.402  2.453  2.45  2.460  L8 **  2.402  2.250  2.453  2.45  2.460  L9 *  2.402  2.250  2.424  2.43  2.430  M0 *  2.403  2.401  2.401  2.401  2.401  2.405  2.405  2.400  2.405  2.400  2.400  2.400  2.400  2.400  2.400  2.400  2.400  2.400  2.400  2.400  2.400  2.400  2.400  2.400  2.400  2.400  2.400  2.400  2.400  2.400  2.400  2.400  2.400  2.400  2.400  2.400  2.400  2.400  2.400  2.400  2.400  2.400  2.400  2.400  2.400  2.400  2.400  2.400  2.400  2.400  2.400  2.400  2.400  2.400  2.400  2.400  2.400  2.400  2.400  2.400  2.400  2.400  2.400  2.400  2.400  2.400  2.400  2.400  2.400  2.400  2.400  2.400  2.400  2.400  2.400  2.400  2.400  2.400  2.400  2.400  2.400  2.400  2.400  2.400  2.400  2.400  2.400  2.400  2.400  2.400  2.400  2.400  2.400  2.400  2.400  2.400  2.400  2.400  2.400  2.400  2.400  2.400  2.400  2.400  2.400  2.400  2.400  2.400  2.400  2.400  2.400  2.400  2.400  2.400  2.400  2.400  2.400  2.400  2.400  2.400  2.400  2.400  2.400  2.400  2.400  2.400  2.400  2.400  2.400  2.400  2.400  2.400  2.400  2.400  2.400	<u>L3</u> *			2.410	.239	2.468	.227	2.466	
2.46				2.404			. 273	2.43/	<del></del>
$\begin{array}{c ccccccccccccccccccccccccccccccccccc$	L5			2.402			. 286	9.411	
L8 ★ 2.462	* LG *			2.408	.233	2.451	.224	2.456	
$\begin{array}{c ccccccccccccccccccccccccccccccccccc$	L7 *	***************************************		2.405	. 250	7,453	. 245	2.460	
$\begin{array}{c ccccccccccccccccccccccccccccccccccc$	L8 *	•		2.402			,275	2,417	<del> </del>
M1 2.401 .225 2.450  M2 2.405 .280 2.414  M3 * 2.407 .280 2.416 .277 2.430  M4 2.408 .260 2.429  M5 2.403 .257 2.431  M6 * 2.403 .297 2.465 ⊗  M7 2.403 .297 2.410  M8 2.403 .297 2.410  M8 2.403 .297 2.410  M8 2.403 .297 2.410  M8 2.403 .240 2.469 .235 2.473  N0 * 2.404 .277 2.423 .266 2.430  N1 2.404 .277 2.423 .266 2.430  N1 2.404 .277 2.423 .266 2.430  N1 2.404 .277 2.423 .268 2.425  N3 2.403 .267 2.418 .268 2.425  N3 2.403 .267 2.418 .268 2.425  N3 2.403 .267 2.418 .268 2.425	1			2.402	.250	2,424	.243	2.430	
M2 $2.405$ .280 $2.414$ M3 * $2.407$ .280 $2.416$ .277 $2.430$ M4 $2.408$ .260 $2.429$ M5 $2.403$ .257 $2.431$ M6 * $2.407$ .221 $2.461$ .215 $2.465$ $\infty$ M7 $2.403$ .297 $2.405$ $\infty$ M8 $2.403$ .240 $2.469$ .235 $2.412$ M9 * $2.407$ .240 $2.469$ .235 $2.473$ N0 * $2.407$ $2.423$ .266 $2.430$ N1 $2.407$ $2.423$ .266 $2.430$ N2 * $2.404$ .283 $2.473$ N2 * $2.404$ .263 $2.425$ N3 $2.403$ .267 $2.418$ .268 $2.425$ N3 $2.403$ .300 $2.393$ .300 $2.393$ N4 $2.413$ .282 $2.407$	Mo *	······································		2.413	.270	2.443	. 265	2.450	
$\begin{array}{c ccccccccccccccccccccccccccccccccccc$	MI			2.401	,		. 225	2.450	
M4 $2.408$ $.260$ $2.439$ M5 $2.403$ $.257$ $2.431$ M6 * $2.407$ $.221$ $2.461$ $.215$ $2.465$ $8$ M7 $2.403$ $.297$ $2.465$ $8$ M8 $2.403$ $.265$ $2.410$ M9 * $2.409$ $.240$ $2.469$ $.235$ $2.473$ N0 * $2.404$ $.277$ $2.423$ $.266$ $2.430$ N1 $2.404$ $2.404$ $2.283$ $2.413$ N2 * $2.403$ $2.67$ $2.418$ $2.68$ $2.425$ N3 $2.403$ $2.403$ $3.00$ $2.393$ N4 $2.413$ $2.82$ $2.407$	M2			2.405			. 780	2.414	
M5 $2403$ .257 $9.431$ M6 * $2.407$ .221 $2.461$ .215 $2.465$ $8$ M7 $2.403$ .297 $2.410$ M8 $2.413$ .265 $2.412$ M9 * $2.409$ .240       .235 $2.473$ N0 * $2.404$ .277 $2.423$ .266 $2.430$ N1 $2.404$ .283 $2.4/3$ N2 * $2.403$ .267 $2.418$ .268 $2.425$ N3 $2.403$ .300 $2.393$ N4 $2.4/3$ .282 $2.407$	M3 *	: 		2.407	,280	2,416	.277	2.430	
MG $*$ 2.407     .221     2.461     .215     2.465     8       M7     2.403     .297     2.410       M8     2.43     .265     2.412       M9 $*$ 2.409     .240     .235     2.473       N0 $*$ 2.404     .277     2.423     .266     2.430       N1     2.404     .283     2.4/3       N2 $*$ 2.403     .267     2.418     .268     2.425       N3     2.403     .300     2.393       N4     2.4/3     .282     2.407	м4			2.408			,260	2.429	
M7       2.403       .297       0.410         M8       2.413       .265       2.412         M9 *       2.409       .240       2.469       .235       2.473         N0 *       2.404       .277       2.423       .266       2.430         N1       2.404       .283       2.4/3         N2 *       2.403       .267       2.418       .268       2.425         N3       2.403       .300       2.393         N4       2.4/3       .282       2.4/07	M5			2.403	<u> </u>		.257	2.431	
M7       2.403       .297       0.410         M8       2.413       .265       2.412         M9 *       2.409       .240       2.469       .235       2.473         N0 *       2.404       .277       2.423       .266       2.430         N1       2.404       .283       2.4/3         N2 *       2.403       .267       2.418       .268       2.425         N3       2.403       .300       2.393         N4       2.4/3       .282       2.4/07	_ MG *			2.407	.221	2.461	.215	2.465	⊗
M9 *     2409     .240     2.469     .235     2.473       N0 *     2404     .277     2.423     .266     2.430       N1     2.404     .283     2.413       N2 *     2.403     .269     2.418     .268     2.425       N3     2403     .300     2.393       N4     2.413     .282     2.407	M 7			2.403			.297	2.410	
NO *     2.404     .277     2.423     .266     2.430       NI     2.404     .283     2.4/3       N2 *     2.63     .267     2.418     .268     2.425       N3     2.403     .300     2.393       N4     2.4/3     .282     2.407	MB			2.413			,205	2.412	
N1 2.404 .283 2.4/3  N2 * 2.603 .267 2.418 .268 2.425  N3 2.403 .300 2.393  N4 2.413 .282 2.407	M9 *			2.409	.240	2.469	.235	2.473	
N2 * 2.63 .267 2.418 .268 2.425  N3 2 403 .300 2.393  N4 2.413 .282 2.407	No *			2.404	.277	2.423	.266	2.430	
N3 2403 .300 2.393 N4 2.413 .282 2.407				2.404			.283	2.4/3	
N4 2.413 .282 2.407	NS *			2.163	.267	2,418	.268	2,425	
حديده والمرابخ والمرابخ والمستوان والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمرابخ والمر	. N3			2403			, 300	2.393	
	N4			2.413			.282	2.407	

	•	=	<del>♣</del> -	<u></u>				SH#6
		(( 4	• 3.0	1295				
M/7	TRIGGE	R GUA	42D (1	HEAT TR	(GETAB.	PARTS	COMPLETELY D \$ COURED	
PART#	START	34ND 4°76'	2.430	, 295	H.T.		2,430	
EWE!	2.430 Bend Bend	.2.3	AFTER Bend	1,273	2.430	,295	: 2, <del>7</del> )	
N 5			2.409			, 275	2.421	
N 6			2,410			.245	2.436	
N7 *			2.412	.778	2.416	.268	2.422	
N8 *			2.41	. 235	2, 463	.228	2, 468	
N9 *			2.403	.240	2:456	.233	z.471	
00			2 408			, 230	2,443	
101 +			2.410	.215	2.484	.205	2.485	8
02			2.421			.257	2.403	
03_*			2402	. 260	2.426	.242	2,439	
04 *			2.415	. 275	2.422	,270	2,431	
05 *			2.409	. 242	2,455	,242	2.466	
06 *	1		2400	. 2 4 2	2.428	.255	2.442	
_ 01 *			2.400	.217	2.457	.217	2.456	
08 *			2.463	. 247	2,431	.244	2, 434	
_ 09 *			2.400	. 225	2.476	.227	2482	
_Po			2.403			.250	2. 4.38	
P1 *			2401	.261	2,430	.260	2.437	
P2 *			2394	.220	2.465	.217	2.480	
P3			2.405			.264	2.407	•
P4			2.402			.251	2.421	
P5			2.404			.262	2.437	
P6			2.419			,268	2.435	
P7			2410			.276	2.417	
P8 ×			2.410	, Z33	2.466	.233	2.478	
P9 *			2.408	.269	2,418	.268	2,425	
Q0 *			2.391	, 250	2.434	.245	2.440	

2.422

2.409

.270

.269

2.426

M/7 TZIGGEZ GUAZD (HEAT TEATED) PART PART SAMPLATE CAPE COMPLETELY PRET SAMPLATE CAPE CAPE CAPE 2.430				<del>_</del>	1_				SH.# 7
PART COMPLET CONTROL (HEAT TREATED) PART   2.430   2.430   2.430   2.430   2.430   2.430   2.430   2.430   2.430   2.430   2.430   2.430   2.430   2.430   2.430   2.430   2.430   2.430   2.430   2.430   2.430   2.430   2.430   2.430   2.430   2.430   2.430   2.430   2.430   2.430   2.430   2.430   2.430   2.430   2.430   2.430   2.430   2.430   2.430   2.430   2.430   2.430   2.430   2.430   2.430   2.430   2.430   2.430   2.430   2.430   2.430   2.430   2.430   2.430   2.430   2.430   2.430   2.430   2.451   2.430   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.451   2.4			· // 4	10 30 · W	.295				
PART   25 mart   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 may   24 m				٠ (ا	*		PARTS	COMPLETELY	,
PART# 2.430	M/7	TRIGGE	R GU	42D (1	HEAT TR	(Garas	FINISH	eo f colors	
381-02       381-02       381-02       381-02       381-02       393       3943       393       3943       3943       39453       39453       39453       39453       39453       39453       39453       39453       39453       39453       39453       39453       39453       39453       39453       39453       39453       39453       39453       39453       39453       39453       39453       39453       39453       39453       39453       39453       39453       39453       39453       39453       39453       39453       39453       39453       39453       39453       39453       39453       39453       39453       39453       39453       39453       39453       39453       39453       39453       39453       39453       39453       39453       39453       39453       39453       39453       39453       39453       39453       39453       39453       39453       39453       39453       39453       39453       39453       39453       39453       39453       39453       39453       39453       39453       39453       39453       39453       39453       39453       39453       39453       39453       39453       39453       39453       3		START	BEND 4"70"	1	AFTER	H.T.		13	-
Q 2       2.465       .293       2,425         Q 3       2.463       .237       2,453         (Q 4 x)       2.412       .279       2.457       .277       2.437         Q 5 x       2.433       .232       2.452       .234       2.451         Q 6 x       2.413       .252       2.460       .252       2.460         Q 7 x       2.334       .275       2.452       .266       2.423         Q 8       2.411       .233       2.474       .234       2.470         Q 8       2.411       .233       2.474       .234       2.470         Q 9 x       1.411       .233       2.474       .234       2.470         Q 9 x       1.411       .233       2.474       .234       2.470         Q 9 x       1.411       .233       2.474       .234       2.470         Q 9 x       1.411       .233       2.474       .234       2.470         Q 1 x       2.411       .263       2.421       .245       2.437         Q 1 x       2.412       .245       2.447       .2402       2.447         Q 2 x       2.412       .243       .259       2.431 <td>PART</td> <td>2.430</td> <td>.295</td> <td>2.430</td> <td>(.295</td> <td>2.430</td> <td>1.295</td> <td>2,430</td> <td></td>	PART	2.430	.295	2.430	(.295	2.430	1.295	2,430	
Q3       2,443       .237       2,453         Q4 x       2,412       .279       2,457       .277       2,437         Q5 x       2,433       .232       2,452       .234       2,451         Q6 x       2,413       .258       2,458       .252       2,460         Q7 x       2,334       .275       2,458       .252       2,460         Q8       2,411       .233       2,474       .234       2,470         R0 x       2,465       .253       2,456       .251       2,455         R1 x       2,433       .263       2,456       .251       2,455         R1 x       2,433       .263       2,428       .265       2,431         R2 x       2,433       .250       2,467       .240       2,467         R3 x       2,466       .233       2,467       .240       2,467         R3 x       2,468       .295       2,427       .289       2,437         R4 x       2,462       .245       2,427       .289       2,431         R5 x       2,403       .259       2,435       2,478         R8 x       2,462       .241       .243       .255		BEND						{	
Q3       2,443       .237       2,453         Q4 x       2,412       .279       2,457       .277       2,437         Q5 x       2,433       .232       2,452       .234       2,451         Q6 x       2,413       .258       2,458       .252       2,460         Q7 x       2,334       .275       2,458       .252       2,460         Q8       2,411       .233       2,474       .234       2,470         R0 x       2,465       .253       2,456       .251       2,455         R1 x       2,433       .263       2,456       .251       2,455         R1 x       2,433       .263       2,428       .265       2,431         R2 x       2,433       .250       2,467       .240       2,467         R3 x       2,466       .233       2,467       .240       2,467         R3 x       2,468       .295       2,427       .289       2,437         R4 x       2,462       .245       2,427       .289       2,431         R5 x       2,403       .259       2,435       2,478         R8 x       2,462       .241       .243       .255		·		0.0					
Q 4 *       2.412       .279       2.457       .277       2.437         Q 5 *       2.433       .232       2.452       .234       2.451         Q 6 *       2.42       .258       2.458       .252       2.460         Q 7 *       2.334       .275       2.458       .252       2.460         Q 8       2.411       .233       2.474       .234       2.470         Q 9 *       2.411       .233       2.474       .234       2.470         R 0 *       2.405       .253       2.456       .251       2.455         R 1 *       2.405       .253       2.456       .251       2.455         R 1 *       2.403       .263       7.428       .265       2.437         R 2 *       2.433       .250       2.407       .240       2.407         R 2 *       2.405       .233       2.490       .221       2.482         R 4       2.408       .295       2.427       .289       2.431         R 2 *       2.408       .245       2.423       .250       2.431         R 3 *       2.408       .245       2.423       .255       2.431         R 4 *       <	92			2.405			. 7 93	2.425	
Q 4 *       2.412       .279       2.457       .277       2.437         Q 5 *       2.433       .232       2.452       .234       2.451         Q 6 *       2.42       .258       2.458       .252       2.460         Q 7 *       2.334       .275       2.458       .252       2.460         Q 8       2.411       .233       2.474       .234       2.470         Q 9 *       2.411       .233       2.474       .234       2.470         R 0 *       2.405       .253       2.456       .251       2.455         R 1 *       2.405       .253       2.456       .251       2.455         R 1 *       2.403       .263       7.428       .265       2.437         R 2 *       2.433       .250       2.407       .240       2.407         R 2 *       2.405       .233       2.490       .221       2.482         R 4       2.408       .295       2.427       .289       2.431         R 2 *       2.408       .245       2.423       .250       2.431         R 3 *       2.408       .245       2.423       .255       2.431         R 4 *       <	n: 2			2.443			237	9 453	
Q5 **       2.413       .232       2.452       .234       2.451         Q6 **       2.42       .258       .252       2.460         Q7 **       2.334       .2458       .252       2.460         Q8       2.411       .233       2.474       .234       2.470         Q9 **       2.414       .233       2.474       .234       2.470         R0 **       2.465       .253       2.456       .251       2.455         R1 **       2.433       .263       2.428       .265       2.439         R2 **       2.433       .250       2.467       .240       2.467         R2 **       2.462       .253       2.467       .240       2.467         R2 **       2.468       .295       2.427       .281       2.431         R4       2.468       .295       2.427       .281       2.431         R5 **       2.408       .295       2.427       .281       2.431         R6 **       2.411       .230       2.477       .225       2.478         R8 **       2.462       .243       .257       2.435         R9 **       2.465       .237       2.431 <td< td=""><td></td><td></td><td></td><td></td><td></td><td></td><td></td><td></td><td></td></td<>									
Q6 *       2.4%       2.4%       2.258       2.458       .252       2.460         Q7 *       2.37       .275       2.422       .266       2.423         Q8       2.4/1       .233       2.474       .234       2.470         Q9 *       2.4/1       .233       2.474       .234       2.470         R0 *       2.465       .253       2.456       .251       2.455         P1 *       2.403       .263       2.428       .265       2.439         R2 *       2.403       .250       2.467       .240       2.407         P3 *       2.466       .233       2.490       .221       2.482         R4       2.462       .2433       .250       2.431         P5 *       2.408       .295       2.427       .289       2.431         P6 *       2.408       .245       2.423       .250       2.431         P6 *       2.408       .245       2.477       .225       2.478         P8 *       2.402       .261       2.436       .259       2.435         P6 *       2.405       .233       2.446       .221       2.490         P8 *       2.405	Q4 ×			2.412	.279	2.457	.277	2.437	<u> </u>
Q6 *       2.4%       2.4%       2.258       2.458       .252       2.460         Q7 *       2.37       .275       2.422       .266       2.423         Q8       2.4/1       .233       2.474       .234       2.470         Q9 *       2.4/1       .233       2.474       .234       2.470         R0 *       2.465       .253       2.456       .251       2.455         P1 *       2.403       .263       2.428       .265       2.439         R2 *       2.403       .250       2.467       .240       2.407         P3 *       2.466       .233       2.490       .221       2.482         R4       2.462       .2433       .250       2.431         P5 *       2.408       .295       2.427       .289       2.431         P6 *       2.408       .245       2.423       .250       2.431         P6 *       2.408       .245       2.477       .225       2.478         P8 *       2.402       .261       2.436       .259       2.435         P6 *       2.405       .233       2.446       .221       2.490         P8 *       2.405				24/2	222	21.53	214	2 151	}
Q7 *       2.394       .275       2.422       .266       2.423         Q8       2.411       .233       2.474       .234       2.470         P0 *       2.465       .253       2.456       .251       2.455         P1 *       2.433       .263       2.456       .251       2.455         P1 *       2.433       .263       2.456       .251       2.455         P2 *       2.433       .250       2.467       .240       2.467         P2 *       2.466       .233       2.490       .221       2.482         P3 *       2.468       .233       2.490       .221       2.482         P4 *       2.468       .295       2.427       .289       2.431         P5 *       2.408       .295       2.427       .289       2.431         P6 *       2.417       .230       2.477       .225       2.478         P8 *       2.402       .261       2.436       .259       2.435         P8 *       2.405       .233       2.448       .221       2.490         P8 *       2.405       .237       2.433       .253       2.474         P8 *       2.405 <td><u> </u></td> <td></td> <td><u> </u></td> <td>2.713</td> <td>. 636</td> <td>2,432</td> <td>.234</td> <td>2.431</td> <td></td>	<u> </u>		<u> </u>	2.713	. 636	2,432	.234	2.431	
Q7 **       2.39       .275       2.422       .266       2.423         Q8       2.411       .285       3.464       .234       2.470         C9 **       1.414       .233       2.474       .234       2.470         R0 **       2.465       .251       2.455       2.455         R1 **       2.403       .263       2.428       .205       2.437         R2 **       2.433       .250       2.467       .240       2.467         R3 **       2.468       .233       2.490       .221       2.482         R4       2.488       .233       2.490       .221       2.482         R4       2.488       .245       2.427       .289       2.431         R5 **       2.408       .295       2.427       .289       2.431         R6 **       2.410       .245       2.423       .250       2.431         R7 **       2.411       .230       2.477       .225       2.478         R8 **       2.462       .261       2.436       .221       2.490         S0 **       2.465       .237       2.433       .253       2.474         S2 **       2.415       .	_ 06 *			2.42	. 258	2.456	, z <i>s</i> z	2.460	<u> </u>
$\begin{array}{cccccccccccccccccccccccccccccccccccc$	į				275	7 422	244	2 422	
\( \text{Q} ? \times \)       \( \frac{1}{2} \)       \( \frac{2}{3} \)       \( \frac{2}{3} \)       \( \frac{2}{3} \)       \( \frac{2}{3} \)       \( \frac{2}{3} \)       \( \frac{2}{3} \)       \( \frac{2}{3} \)       \( \frac{2}{3} \)       \( \frac{2}{3} \)       \( \frac{2}{3} \)       \( \frac{2}{3} \)       \( \frac{2}{3} \)       \( \frac{2}{3} \)       \( \frac{2}{3} \)       \( \frac{2}{3} \)       \( \frac{2}{3} \)       \( \frac{2}{3} \)       \( \frac{2}{3} \)       \( \frac{2}{3} \)       \( \frac{2}{3} \)       \( \frac{2}{3} \)       \( \frac{2}{3} \)       \( \frac{2}{3} \)       \( \frac{2}{3} \)       \( \frac{2}{3} \)       \( \frac{2}{3} \)       \( \frac{2}{3} \)       \( \frac{2}{3} \)       \( \frac{2}{3} \)       \( \frac{2}{3} \)       \( \frac{2}{3} \)       \( \frac{2}{3} \)       \( \frac{2}{3} \)       \( \frac{2}{3} \)       \( \frac{2}{3} \)       \( \frac{2}{3} \)       \( \frac{2}{3} \)       \( \frac{2}{3} \)       \( \frac{2}{3} \)       \( \frac{2}{3} \)       \( \frac{2}{3} \)       \( \frac{2}{3} \)       \( \frac{2}{3} \)       \( \frac{2}{3} \)       \( \frac{2}{3} \)       \( \frac{2} \)       \( \frac{2}{3} \)       \( \frac{2}{3} \)       \( \frac{2}{3} \)       \( \frac{2}{3} \)       \( \frac{2}{3} \)       \( \frac{2}{3} \)       \( \frac{2}{3} \)       \( \frac{2}{3} \)       \( \frac{2}{3} \)       \( \frac{2}{3} \)       \( \frac{2}{3} \)       \( \frac{2}{3} \)       \( \frac{2} \)       \(	<u>Q7</u> *			2.57	16/3	6,766	. 266	2.423	<u> </u>
\( \text{Q} ? \times \)       \( \frac{1}{2} \)       \( \frac{2}{3} \)       \( \frac{2}{3} \)       \( \frac{2}{3} \)       \( \frac{2}{3} \)       \( \frac{2}{3} \)       \( \frac{2}{3} \)       \( \frac{2}{3} \)       \( \frac{2}{3} \)       \( \frac{2}{3} \)       \( \frac{2}{3} \)       \( \frac{2}{3} \)       \( \frac{2}{3} \)       \( \frac{2}{3} \)       \( \frac{2}{3} \)       \( \frac{2}{3} \)       \( \frac{2}{3} \)       \( \frac{2}{3} \)       \( \frac{2}{3} \)       \( \frac{2}{3} \)       \( \frac{2}{3} \)       \( \frac{2}{3} \)       \( \frac{2}{3} \)       \( \frac{2}{3} \)       \( \frac{2}{3} \)       \( \frac{2}{3} \)       \( \frac{2}{3} \)       \( \frac{2}{3} \)       \( \frac{2}{3} \)       \( \frac{2}{3} \)       \( \frac{2}{3} \)       \( \frac{2}{3} \)       \( \frac{2}{3} \)       \( \frac{2}{3} \)       \( \frac{2}{3} \)       \( \frac{2}{3} \)       \( \frac{2}{3} \)       \( \frac{2}{3} \)       \( \frac{2}{3} \)       \( \frac{2}{3} \)       \( \frac{2}{3} \)       \( \frac{2}{3} \)       \( \frac{2}{3} \)       \( \frac{2}{3} \)       \( \frac{2}{3} \)       \( \frac{2}{3} \)       \( \frac{2} \)       \( \frac{2}{3} \)       \( \frac{2}{3} \)       \( \frac{2}{3} \)       \( \frac{2}{3} \)       \( \frac{2}{3} \)       \( \frac{2}{3} \)       \( \frac{2}{3} \)       \( \frac{2}{3} \)       \( \frac{2}{3} \)       \( \frac{2}{3} \)       \( \frac{2}{3} \)       \( \frac{2}{3} \)       \( \frac{2} \)       \(	QS			2.411		ļ	.285	9.404	
Ro *       2.465       .253       2.456       .251       2.455         R1 *       2.433       .263       7.428       .265       2.439         R2 *       2.43       .250       7.407       .240       2.467         R3 *       2.466       .233       7.407       .240       2.467         R4       2.468       .295       7.427       .289       2.431         R5 *       2.416       .245       7.423       .250       2.431         R6 *       2.417       .225       7.478         R8 *       2.462       .261       7.436       .259       7.435         R8 *       2.462       .261       7.436       .259       7.435         R8 *       2.462       .233       7.481       .221       7.490         50 *       2.465       .237       7.465       .235       7.446         51 *       2.465       .237       7.2465       .235       7.474         52 *       7.476       .232       7.474       .226       7.474         54 *       7.468       .210       7.248       7.260       7.474         55 *       7.468       7.277       7.428 </td <td></td> <td></td> <td></td> <td></td> <td></td> <td>X</td> <td></td> <td></td> <td></td>						X			
P1 *       2.43       .263       2.428       .265       2.439         R2 *       2.43       .250       2.467       .240       2.467         R3 *       2.466       .233       2.490       .221       2.482         R4       2.468       .295       2.427       .289       2.43/         R5 *       2.408       .295       2.427       .289       2.43/         R6 *       2.416       .245       2.423       .250       2.431         R7 *       2.417       .230       2.477       .225       2.478         R8 *       2.402       .261       2.436       .259       2.435         R8 *       2.402       .261       2.436       .259       2.435         R8 *       2.402       .233       2.481       .221       2.490         S0 *       2.405       .237       2.465       .235       2.474         S1 *       2.415       .237       2.465       .235       2.474         S2 *       2.400       .255       2.482       .233       2.475         S3 *       2.400       .232       2.474       .226       2.474         S5 *       2.408	09 *			2.414	. 233	7.474	.234	2,470	<u> </u>
P1 *       2.43       .263       2.428       .265       2.439         R2 *       2.43       .250       2.467       .240       2.467         R3 *       2.466       .233       2.490       .221       2.482         R4       2.468       .295       2.427       .289       2.43/         R5 *       2.408       .295       2.427       .289       2.43/         R6 *       2.416       .245       2.423       .250       2.431         R7 *       2.417       .230       2.477       .225       2.478         R8 *       2.402       .261       2.436       .259       2.435         R8 *       2.402       .261       2.436       .259       2.435         R8 *       2.402       .233       2.481       .221       2.490         S0 *       2.405       .237       2.465       .235       2.474         S1 *       2.415       .237       2.465       .235       2.474         S2 *       2.400       .255       2.482       .233       2.475         S3 *       2.400       .232       2.474       .226       2.474         S5 *       2.408	R0 *		1	2.405	.253	2.456	.251	2.455	1
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$\begin{array}{c ccccccccccccccccccccccccccccccccccc$	<u>PI *</u>			2.413	.263		.265	2.439	
$\begin{array}{c ccccccccccccccccccccccccccccccccccc$	12 3 ×	•		2.413	.250	2.467	240	2 467	·
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$\begin{array}{c ccccccccccccccccccccccccccccccccccc$	R3 *			2.406	.233	°2.490-	.221	2.482	
$\begin{array}{c ccccccccccccccccccccccccccccccccccc$	D A			2.49			73.	3 1/2-	
$\begin{array}{c ccccccccccccccccccccccccccccccccccc$				4.70		<del> </del>	, 2 3 8	2.900	
$\begin{array}{c ccccccccccccccccccccccccccccccccccc$	P5 *			2.408	. 295	2.427	. 289	2.43/	
$\begin{array}{c ccccccccccccccccccccccccccccccccccc$					245	7 423	3.50	2 431	
$\begin{array}{c ccccccccccccccccccccccccccccccccccc$	_ KG *		1	2.416	.243	<del></del>	. 230	2.43/	
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55 *     2.408     .210     2.485     .703     2.493     Φ ∞       56     2.405     .255     2.438       57 *     2.415     .277     2.428     .274     2.432	<u> 54 *</u>			2.414	.232	2,474	. 226	2.474	
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58 * 2.40 .247 2.453 .245 2.456	<u>57 *</u>			<del></del>	.277	2,428	, 274	1	
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201

PARTS COMPLETELY (HEAT TRIGGER TREATED) GUARD FINISHED & COLORED Bend 4"30" H.T. START 2.430 Be Fore 2.430 (.295 .295 2.430 2,430 ,295 Bend 2.401 .280 59 2.401 . 260 2.439 To * 2.403 258 2,435 2.474 . 247 . 254 2.474 2.40 .261 2.428 2.390 2.423 . 263 TZ * .277 2.406 T 3 2.401 T 4 × 2,424 . 262 2.427 2.403 . 263 2.408 . 224 2,468 T 5 * , 228 2.456 7.428 . 289 .285 -2.405 2.438 . 272 2.417 .262 2.408 2.434 ₹.4<u>64</u> .249 .247 2.420 7.465 . 250 .245 2.421 2.403 2.427 2.403 ,272 7,423 025 2.425 .245 2.431 UI 102 2.402 . 288 2.400 UZ 2.415 . 272 2,422 U3 . 277 2.404 U4 3.407 05 2.400 .255 2,432 2.40 . 250 2.446 06 2.408 .260 U1 2.419 2.405 UB 2,416 2.411 U 9 . 230 2.451 2.404 2.443 . 246 VO 2.407 2.416 VI 289 2.400 V 2 259 2432 2409 2.425 V 3 . 262 V4 2.406 2,442 .245 2.403 V5 .275 2.405

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V7	····		2.410			, 283	2.411	
V8			2.404			. 236	2.442	
V9			2.408			. 305	2,489	
wo	- <del></del>		2.404			. 235	2,400	<u> </u>
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_W3			2.404			.268	2.418	<u> </u>
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SH.#10

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·		1		1295		PARTS	COMPLETELY
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							_

# ROUTE:

B. F. Bullis
B. J. Hagen
T. Hagen

BARBER - PRESALE R 0128375

# REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE

Remington **OTPOND** 

"CONFINE YOUR LETTER TO ONE SUBJECT ONLY"_

Ilion, New York March 8, 1983

TO:

C.B. WORKMAN

FROM:

J.W. BROOKS

SUBJECT: MODEL SEVEN 308 CALIBER STOCK CRACKING

AND FLOOR PLATE INVESTIGATION

#### Stock

Testing of ten (10) Stocks, with reinforcing screws have been completed. Drawings have been transmitted and the plant is producing Stocks with reinforcing screws.

#### Trigger Guard

- 0 250 Trigger Guards with rear tab altered and heat treat have been given to Production to put on 308 Caliber rifles with pinned Stocks. We will field test sixteen (16) of these rifles and endurance test four (4).
- 250 Trigger Guards are on order from the vendor with an altered front hook. They will be shipped to us by March 16. They will be ready for testing by approximately March 23. They will be used to test rifles with thicker Trigger Guard Plates and Floor Plate bases.

To: C.B. Workman

-2-3-9-83

### Trigger Guard Plate

- o We have eighteen (18) parts made from .080 material. They will be brazed to current floor plate bases and tested. They will be ready for testing March 11.
- o 250 parts from .080 material will be available by March 11. These parts will be used with the thicker floor plate base samples.

#### Floor Plate Base

o 250 parts from .062 material will be available in three to four and a half weeks or by April 8. They will have to be Model Shop machined and brazed by Production. They will be available approximately April 22 for testing.

### Floor Plate Cover

o 250 parts from .062 material will be available by March
15. They will be available for testing approximately March
25.

#### Latch Spring

300 new latch springs will be available by March 23.

The above five items will be used together to test the Model Seven in 308 caliber for floor plate opening conditions. When these parts are ready for testing we will have results from present endurance testing so that we will know if a heat treated latch is required. If it is required, we will use them when testing these five items.

JWB: js

G-88

## DON'T SAY IT-WRITE IT

То	y. Nitoro
From	D. Kein

OBI

Date_____3-9_____

#9225\$ Hon Plate Bose

I checked my files and a transmitted wood could to make a black dwg C-92256. Therefore make necessary changes to that dwg per Hill letter.

Question: Shouldn't C-91840 say for black see C-92256 not see # 92256.

Taken cone of yesterling

"DON'T TAKE A CHANCE, THINK SAFETY IN ADVANCE"

G-88	DON'T SAY	IT- <i>WRITE IT</i>		
То			Date	
From				_
Frem	la Ambrose	216	671	8000

"DON'T TAKE A CHANCE, THINK SAFETY IN ADVANCE"

		CC	: C.C. queene
G-88	DON'T SAY IT	-WRITE IT	S. D Bennett
To J. Brooks		D.	3/10
To J. Brooks	<del></del>		
Repuncing your			
Checked MRP in	unitary on por	t # 16793 7	n/600 Follower
1010 pes. in -	enventry		·
Further investige	tim by & g	ocken red	realed an
enor - only	368 pc. in	inventory	

"DON'T TAKE A CHANCE, THINK SAFETY IN ADVANCE"

Mceeting of 3-10-83

Johnson Frag Dams Jochson Louds Rouds muram Saney Bullis Johnsha

. 5 Pring return banking in front,

- Trigge side clearing. marksjint for J. Ticke.

· Puned stocks for all salilers

· Production to use 2000 finished stacked

for 222

. Heat treated tryge Grand for all models.

3-15-23

· Floor Plate Cose

. Thises must, conton - mocaulou various thisknesses what would be delay? -

Present Time is 3-42 week

. What is best two withing 24 lingting?

, what is cost? ... 2?

Frank will call backs tomorrow

3-11 Dwayne said frut will shoot for 3-31 for jutt to us, the will going info on what is regal for thether math, REMINGTON ARMS COMPANY Model Seven Rifle ads

March 11, 1983

THAT'S 1004 REMINGTON,
BUT 20% LESS SIZE AND WEIGHT.

A COMPRED to the response Brokel Buyer twenty of MOREL 7005,

FEEL THE DIFFERENCE.

(LOGO) MODEL SEVEN LIGHTWEIGHT

The new Model Seven is the lightest, fastest, most compact Remington bolt action rifle ever. And, like every firearm we've made in American since 1816, it has quality written all over it.

Once you see and shoulder the Model Seven, you'll know it's tailored for day-long duty in the toughest terrain, from steep hills to knee-deep bogs.

Every Model Seven is only 15" longer than a yardstick. And, weighing an honest 4 oz. above the magic 6 lbs., it's one of the lightest big game bolt actions you can buy. At any price.

And check these hard-hitting calibers, ideally suited to the Seven's compact dimensions: 308, 6mm Rem., 7mm-08 Rem., 243, and 222 Rem.

Sure, there are other so-called "lightweight" rifles out there. But most got that way by turning down their barrels, lopping off an inch here and there, or by using lightweight materials. Not so with Remington, we designed a completely new rifle.

Long man-hours in research and on the range helped us develop a lightweight rifle that's all new — from the ground up. Yet its action and specially tapered barrel are built to be as strong and dependable as those Remington barreled actions that have been preferred by target champions and custom gunmakers for decades.

The Model Seven's American walnut stock is cut checkered, satinfinished, and sports a distinctive Schnabel fore-end. Every part of this rifle, right down to its crisp trigger and steel/ways. floor plate is made here in America. To the quality and accuracy standards shooters expect — and get — from Remington. The result is a high value lightweight rifle that's not 1" longer, 1 oz. heavier, or \$1 more expensive than it should be.

Try the Seven for size at your nearby Remington or read more about it in our free catalog. The Model Seven Lightweight, just one more way we're doing our best to keep you "First in the Field."

(Remington logo, Du Pont oval)

(small type at bottom of ad):

Remington is a trademark registered in the U.S. Patent & Trademark. Office by Remington Arms Company, Inc., Bridgeport, CT 06601.

PD-59-H

# REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE

Remington. **QUPOND** 

DETERS

"CONFINE YOUR LETTER TO ONE SUBJECT ONLY"_

J.P. Linde S.W. Johnson

J.J. Burns

W.W. Cook H.C. Munson

D.E. Bullis

C.E. Ritchie

E.W. Yetter

S.R. Franz

D. Jackson

H. Roark W.L. Ganey

J.R. Snedeker

Ilion, New York March 14, 1983

TO:

C.B. WORKMAN

FROM:

J. W. BROOKS

SUBJECT: MODEL SEVEN LIGHTWEIGHT

The following items were discussed and agreed upon for future production rifles in .222, 6 mm, and .243 Caliber.

- o Pinned Stocks (reinforcing screw) for all . future Stocks.
- o Production would use approximately 2,000 finished Stocks without reinforcing screws for .222 rifles.
- o Research will transmit trigger guard drawing with rear tab bent in opposite direction than it is now and also add heat treat specifications.
- o Research will furnish marked drawing of Model Seven trigger with extra relief cut on each side.

JWB∶js

RD-49-8

REMINGTON	ARMS	COMPANY,	INC.
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INTER-DEPARTMENTAL CORRESPONDENCE

Remington 

xc: J.P. Linde S.W. Johnson J.J. Burns W.W. Cook H.C. Munson D.E. Bullis

____C.E. Ritchie

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JWB:js

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER KINZER V. REMINGTON

RIFLE - SN	Report Dated 3-15-8Z		Report No. 82-0491	Report No. 82331
	Acc. 7-7-81	7-15-81	150-200 <b>p.</b> 12 Types Ammo. 3-12-82	200 Gr. 12-17-82
В 6226264	15 rds.	500 rds. 7 F.P.O.	180 rds.	20 rds.
256	15 rds. 15 rds.	500 rds. 7 F.P.O.	180 rds.	20 rds.
265	15 rds.	500 rds.	200 200	20 -0
237	15 rds.	500 rds.	180 rds.	20 rds.
276	15 rds.	500 rds.	180 rds.	
	Report #	Report #	Report #	Report #
	822811	822811	822811	828331
	10-18-82	10-28-82	10-29-82	200 Gr.
			No. 5 Design	
	10-25-82	50 rds. 200 Gr.	50 rds. 200 gr.	12-14-82
7600003	165 rds. 79 F.P.O.	No. 5 design ok		
08	165 rds. 59 F.P.O.		_	
13		(?) ok	ok	
16		(?) ok	ok	
22	165 rds. 22 F.P.O.	No. 5 design ok	_	
28		ok	ok	
34		ok	ok	
36	165 rds. ok	(?) ok	ok	
40	165 rds. 76 F.P.O.	5 F.P.O.	ok	
43	165 rds. ok	No. 5 design ok	_	
50		11 F.P.O.	ok	20 rds.
52		(?) ok	ok	
58	165 rds. ok	(?) ok	ok	
62		(?) ok	ok	
63		(?) ok	ok	
65		1 F.P.O.	0 K	
67				20 rds.
79				20 rds.
88			_	20 rds.
9 <b>6</b>		6 F.P.O.	ok	

, !

101	165 rds. 12 F.P.O	. No. 5 design ok		20 rds.
102				zord
103	165 <b>rds. ok</b>	(?) ok	ok	₽ rds.
107				20 rds.
120	_	6 F.P.O.	ok	· A
139	165 rds. 52 F.P.O	. No. 5 design ok		Zorda
Report No. 820491				
.243 CALIBER	11-15-82	7-15-81		
В 6226266	75 rds.	160 rds.		
225	75 rds.	160 rds.		
234	75 rds.	160 rds.		
262	75 rds.	160 rds.		
272	75 rds.			•
271		160 rds.		
6мм	•	•		
В 6226233	75 rds.	140 rds.		
263	75 rds.	140 rds.		
255	75 rds.	140 rds.		
230	75 rds.	140 rds.		
258	75 rds.	140 rds.		
7mm-08 CALIBER				ı
В 6226249		140 rds.		
232		140 rds.		
252		140 rds.		
220		140 rds.		
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JWB:js 2-23-83 **BARBER - PRESALE R 0128387** 

30 BARBER -	RESALE R 0128388			
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BARBER	- PRESAL	.E R 0128389

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REMINGTON ARMS CO. INC SILION RESEARCH DIV.

DEC # 1/501

REMINGTON ARMS CO. INC

TO: J.W. BROOKS

FROM: D.E. BULLIS

SUBJ:

M/TLWT FLOOR PLATE UNLATCHING.

TEN SCRAP STOCKS WEBE INLETTED . 030 SEEPER IN THETRIGGER GUARD PLATE AREA TO ALCEPT A GUARD THAT IS, 030 THICKER. 5 WERE PUT UP WITH . OBO THICK JUBO. PLATES WHICH WERE CARBURIZED & S WERE PUT UP USING REGULAR (UN-HEAT TREATED) PLATES! ALL RIFLES HAD . 1.050 THICK FLOOR PLATE COVERS. STANDARD LATCH & SPRING. · HEAT TREATED, MENERSEE SEEN THE GB WAT IN A -. 830 LOTTH CUT INTO NOTEH FOR DED THICKER GUARD PLATE. ALL WERE FIRED FROM HEAVY JACK WITH 308 CAL. - 180 P.S.P. FARTY ROUNDS WERE FIRED THRU EACH RIFE WITH NO OPENINGS. TEN STANDARD TRICECK GUARDS HAD , 030 CUT ENTO NOTCH TO FIT PLATESIE RE-SHOT ABOVE TEST. TWO GUARAS FAILED. (LATCH OPENED) HEAT TREATED BENT GUARDS WERE PUT BACK ON THESE TWO BUNS & RE-SHOT WITH NO COVER OPENINGS.

-6738 Rev.		·		- ·	DCR _		1694
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RD 6589

## DESIGN CHANGE REQUEST and TRANSMITTAL OF DRAWINGS

MICRO
DCR # 11694
Sheet Z of 2

Dwg. No.	Rev. No.	Recommended Design Change - Reason - Disposition of Parts
9/9/2	/	REMOVE .025 AS SHOWN
	2	" .320 " "
	3	RE DIMENSION 1.179/1.175 TO 1.129/1.125 AS SHOW
	4	ADD USE 7CWT
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D-6738 Rev.	380					DCR			116	597
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D-6738 Rev. 3	380		J. 1	, -		DCR	-	1699
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RD 6739

PARTC	TICT	CHANCE	MOTICE	(PLCN)

DCR #	11691				
Sheet	2	of	2		

TRANSMITTAL OF DRAWINGS / PARTS LIST

Requested By	Ch	anged By	Date	
Originating D	ate	Transmitt	al Date	

(PLCN) Use form	below if part num	ber is changed /	add - used, or superseded.	
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APPROVED:				

SALES

DEPARTMENT

# Remington Remington ROMOGIAM

Quick Facts About
REMINGTON
PRODUCTS

10 01 1.W. BROOKS 1LIOH

cc: House Force

Bridgeport, Connecticut March 24, 1983

#### TO THE FIELD FORCE:

You have already received a request to contact your jobber customers, instructing them to hold further delivery of any Model Seven rifles on hand and to supply you with a list of dealers who have received delivery of Model Seven rifles.

Our ultimate intention is to update all Model Seven rifles shipped to date by means of a return to the nearest Remington warranty gunsmith service location or to Arms Service in Ilion.

We have discovered that if a Model Seven rifle is disassembled after it leaves the factory, it is possible for the rifle to be reassembled incorrectly, producing off-center trigger alignment that might cause subsequent malfunction of the trigger and accidental firing of the rifle. The updating service on the rifle will eliminate the possibility of such incorrect reassembly.

To accomplish this, you are requested to obtain:

- 1. A list of all Model Seven rifles and matching serial numbers still in an individual jobber's inventory.
- 2. A list from the jobber of the names and addresses of dealers to whom Model Seven rifles have been shipped, including serial numbers.

Both jobbers and dealers will then be contacted by Product Service with instructions on how to have the rifles updated. Consumer purchasers of Model Seven rifles will also be contacted by Product Service with a request and instructions to have the rifles updated.

## REMINGTON ARMS COMPANY, INC., BRIDGEPORT 2, CONN.

Form No. RD 451

Printed in U.S.A.

Field Force Page 2 March 24, 1983

In all contact with jobbers, dealers, and retail customers on this subject, it is important to emphasize that the potential malfunction is remote, can occur only on a Model Seven rifle that has been disassembled and subsequently reassembled outside the factory, and that the update applies only to Model Seven rifles and not to any other Remington models.

This update is being incorporated into all Model Seven rifles to be shipped in the future.

Sincerely,

E. J. Conroy Director of Sales

EJC/dr

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B6226241

7600142

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B6226249

7 MM-08 rifler
To But Juy

G-88

## DON'T SAY IT-WRITE IT

То	c.	В.	WORKMAN	J. Brooks
From	J.	Р.	LINDE	411

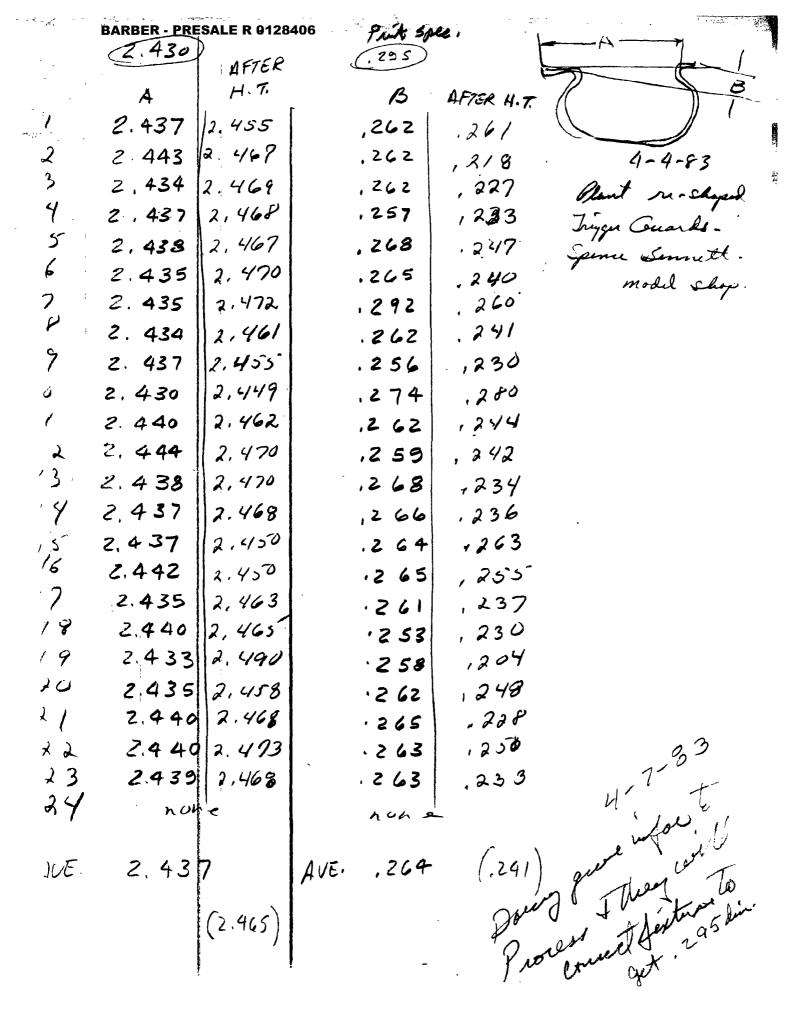
Date _____April 4, 1983

This is a file copy of deviations we made on the Model Seven LWT. The letter was written to describe the changes and the reasons for the changes at the time.

This is a copy for your files.

JPL:hv

"YOUR SAFETY ATTENTION MEANS ACCIDENT PREVENTION"



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## REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE

Remington.



xc: R.E. Fielitz

H.K. Boyle

H.C. Munson J.P. Linde

J.W. Brooks

"CONFINE YOUR LETTER TO ONE SUBJECT ONLY"_

Ilion, New York April 7, 1983

TO:

C.B. WORKMAN

FROM:

C.E. RITCHIE

SUBJECT:

MODEL SEVEN NEW STYLE TRIGGER EVALUATION

The purpose of the evaluation was to analyze the effect of removing material from both sides of the trigger to allow additional trigger clearance. Three analyses were performed as follows:

- John Brooks, Supervisor Current Firearms Design evaluated the effects of stack-up of dimensional tolerances;
- 2. Scott Franz and Ed Yetter, Jr. Basic Systems Research Group evaluated the theoretical aspects of the new trigger compared to old style trigger during a drop jar-off test and
- 3. The Research Test Lab performed a physical drop/jar-off test on both the old and new style triggers.

Results of these analyses are as follows:

1. With the new style trigger cuts an additional .0135" per side is achieved.

To: C.B. Workman

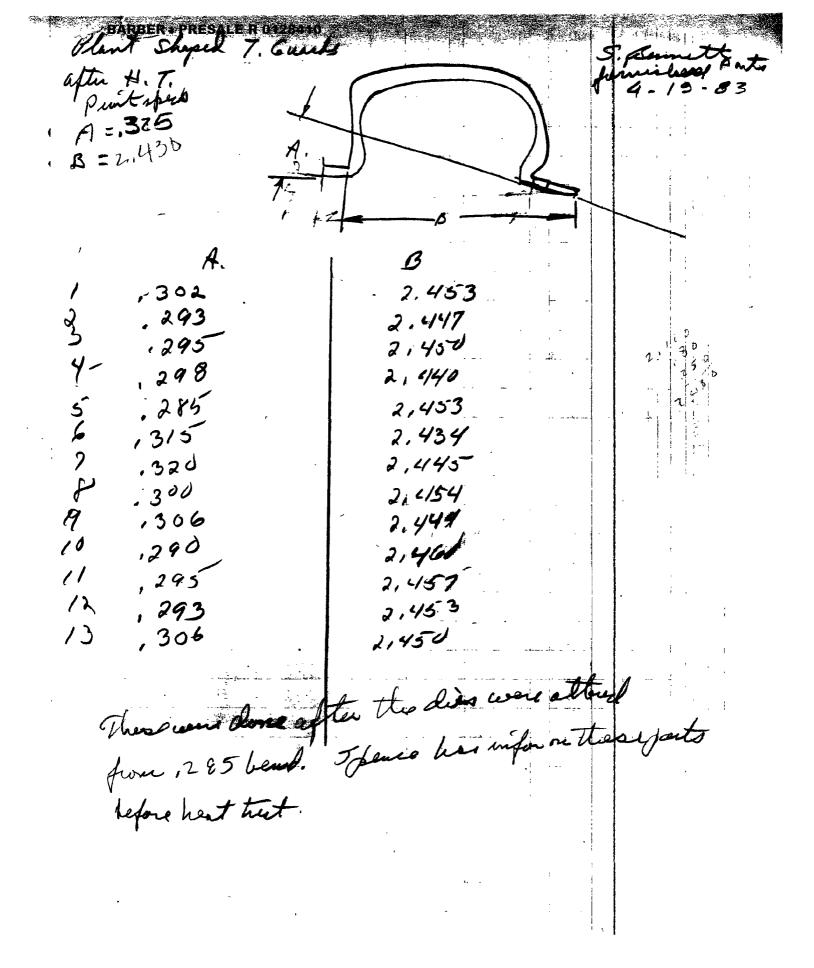
-2-4-8-83

- 2. The theoretical calculations indicated there is a 10% greater moment of inertia with the new style trigger over the old style trigger.
- 3. Drop and jar-off tests indicate the new style trigger to be as good "as the old style". The new style trigger also meets or surpasses SAAMI jar-off test requirements.

Overall results indicate the new style trigger should be a satisfactory replacement for the old style trigger.

If additional information is needed of test or evaluation reports, please contact me.

CER: js



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Summary of Testing 4/15/83 Model Sev-N Heavy material Floor Plate assemblies. Assemble: Rear hole drilled out on all guns

- 12 /2 1-1 -1.

Riled magazine box hole in stock on 2 guns All guns weeded latch coverage adjustment adjustment was difficult due to thick material majazine box bends whin adjustment is made. Bguns woeded mag, box repairafter letch coverage adjustment.

hab Shooting: 9 gone shot: 10 ands with old grands 10 rads with new guards

110

5 guns F.P.O. with old guards I gun F.P.O: with new goord Zguns took zonds in Bix.

Field Shooting: Field Function Test 135 ruds total assorted ammo types.

> 8 gove, to FP.O. 3 guns took only 3 rad, in mag. 2 guns had I stem high each I gun had I bolt override Replaced Trigger quard to Vendor port on 4 guns hats way through test -No problems.

GUN#

3489 - Assembly: rear stock hole drilled out

Hagazine box hole in stock filed

4th round into magazine loads hord.

hab shooting: No floor plate openings in 10 ruds with old Trigger Guard No floor plate openings in 10 ruds with New Trigger avord

Field Shooting 135 rnds. No mal sunctions

3136 Assembly: rear stock hole drilled out.

hab shooting: 5 F.P.O. in 10 ruds with old Trigger Guard.

No F. P.O. in 10 mads with New trigger guard. - magazina took only 3 mads

Field Shooting: Only 3 rads fit in mag during entire test. I stem high

3748 Assembly: rear stock tole drilled out

4th round in magazine loads hard

hab shooting: No F.P.O. in 10 ruds with old

trigger guards. NO F.P.O. in 10

rnds with New Trigger guard.

Field shooting: 135 mods - No. malfunctions

3429 Assembly: Rear hole in stock drilled out

Magazine box hole isistock filed

4th round in magazine loads hand.

hab Shooting: 2 F.P.O. in 10 rnds with old Trigger Good
100 F.P.O. in 10 rnds with New Trigger Guar

Field Shooting: 3 rnds only in magazine entire test

GUNTE Assembly: Drilled rear hole in stock 2905 hab shooting: NO F.P.O. 10 mods old Trigger guard. No F. P.O. 10 rnds New Trigger goard. With rad. in magatine loads hard. Drilled out rear hole in stock Ass-mbly: シィクク hab shooting: No F.P.O. 10 ruds old Trigger goord. No F.P.O. 10 ands New Trigger grand. Only took 3 ruds in magazine Sield Shooting: No malfunctions Assembly: Drilled rear hole in stock 3319 Lab shooting: 7 F.P.O. in 10 ruds old Trigger Good NO F.P.O. in 10-NUS New Trager Guard Field Shooting! No malfunctions 2962 Assembly: Drilled rear hole in stock tatch opening too hard - opening spring Bolt hundle would not close - in to farence with stock - filed stock Lab Shopting: 4 F.P.O. of 10 rads old Trigger Good 4 F.P.O. of 10 rnds New trigger Good, Field Shooting: Did not include in field test. for ther work will be done with this gun. Problem lies with bad Trigger guard causing poor latch coverage.

Model 7 - Magazine Capacity Investigation

Test Description: Magazins springs were altered as listed below to determine if these charges would eliminate. the follower catching on the magazine bod floorplate base edge caused by misalignment of the assembly. 1. Shortened .100" - follower side 11 " - floorplate side 3. Shortened .100" ON both sides

cut .100

2.0 cut .100" +1 +

(5N,7603/36)

4 rifle from the field test on 4-15-83 was used for the test sing this rifle would only take 3 rds in the magazine. All 3 spring configurations were assembled in this rifle and dumny role were loaded to determine the magazine capacity.

results: None of the three spring configurations above improved the loading of the magazine. In some instances four new could be loaded with some difficulty with three springs, but this was also the case with the unaltered spring.

5RF 4-18-83

≂ D-69-8

REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE

Remington.

PETERS

xc:

C.B. Workman L.B. Bosquet

Sproch

D.E. Bullis S.R. Franz E. Yetter, Jr.

"CONFINE YOUR LETTER TO ONE SUBJECT ONLY"_

Ilion, New York April 19, 1983

TO:

J.W. BROOKS

FROM:

C.E. RITCHIE

SUBJECT:

MODEL SEVEN THICK FLOORPLATE ASSEMBLIES

A mismatch exists between the Model Seven floorplate base and the magazine box. This mismatch can cause difficulty in loading a fourth round in the magazine. Testing to date indicates the thicker base assemblies greatly aggravate this condition.

Eighty Six (86) guns were built by Production for Research with the thinner assemblies and no magazine loading problems were found. Recently, Research built eight (8) guns with the thicker assemblies and three (3) guns would take only three rounds in the magazine and one other had occasional loading problems. It is, therefore, the Test Lab's recommendation to stop the order for the thick floor plate bases until this condition can be rectified.

CER: js

(2) Action on Existing assemble.

Schedule for completion

3D-69-B

## REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE

Remington IPM



xc: C.B. Workman L.B. Bosquet D.E. Bullis

S.R. Franz E. Yetter, Jr.

"CONFINE YOUR LETTER TO ONE SUBJECT ONLY"_

Ilion, New York April 19, 1983

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CER: js

John

4-20-83

Special 71/7 Stockes

are at white wood sand.

Should be nearly complete

mid to Sate next week. We'll

propobly have to "feed" them to

you, Like 30-50 per day.

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BARBER - PRESALE R 0128421
Model Seven
TO: J.W. Brooks Notes and recommendations
FROM: EW Yother S.R. Franz

- · If the following are encountered, replace the Trigger Guard:
  - 1. latch pushing through trigger guard 2. in adequate coverage (150%)
- Do Not adjust coverage by prying between box and Floorplate base.

  Use this adjustment for Cover to stock clearance Only

Caution: It is easy to distort the magazine box when mating this adjustment with the thick Floor Plate assemblies. It is possible to dimple the box (at the very least). This dimple can cause magazine loading problems.

- The Old style latch springs are recommended.

  New springs make latches more difficult to

  work (aug. Force 8.2165). Old springs work

  much better (aug. Force 5.0165). No floor plate

  openings were found during fining with the old

  springs:
- hatch coverage and therefore possibility of floor plate openings are very sensitive to the shape of the trigger guard. This shape cannot be governmented due to heat treatment. This senset with can be greatly reduced by a clearance cut in the back of the floor plate latch. It is recommended that dies be educated to accommodate this out.

Floor Plate base to Magazine box mismatch left to right must be corrected to reduce loading problems. This can be done by filing the magazine box hole in the stock.

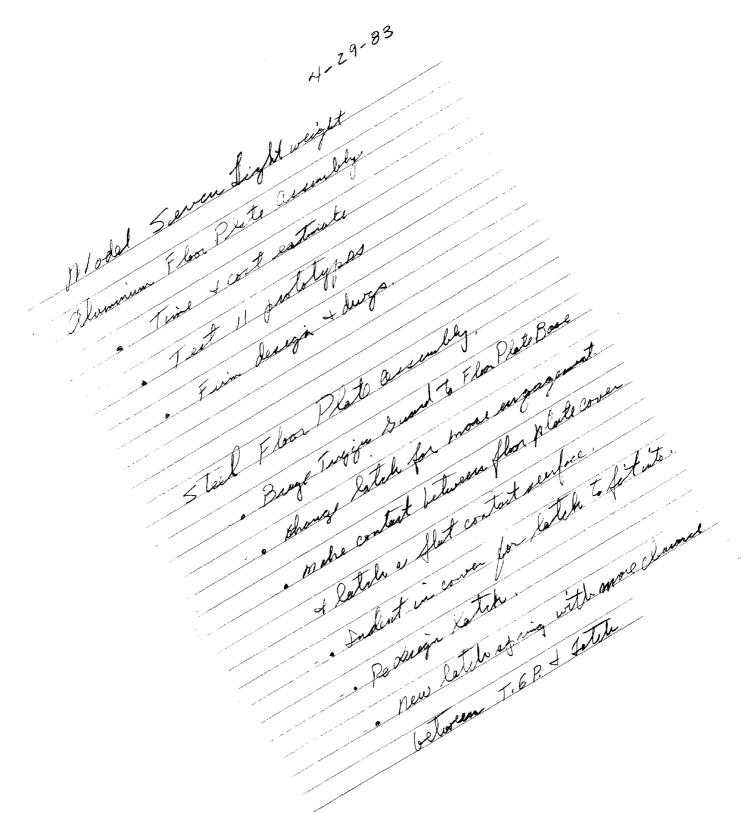
- Floor Plate base to Magazine box mismatch front to rear will cause loading problems.

Redesigning the floor plate base to eliminate the mismatch is the only good solution to this.

4-27-83

Floor Plate Base (250) , 250 Deanied 3-31-83 . to Production for machining , 50 to model slep 4-6 · 200 to model they 4-7, Finished 4-13 . 10 to Brogs 4-11-use current fixture. . 10 to Textlale for weathly to rifle 4-13 1 Test 4-15 · Production Brazing Sisturered 4-20 . HIII o special part needed at Begge. . 200 From Prote books started 4. 22-423 . 200. to slaw + said turble 4-25 , Polish + color 4-25-4-27

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#### **BARBER - PRESALE R 0128429**

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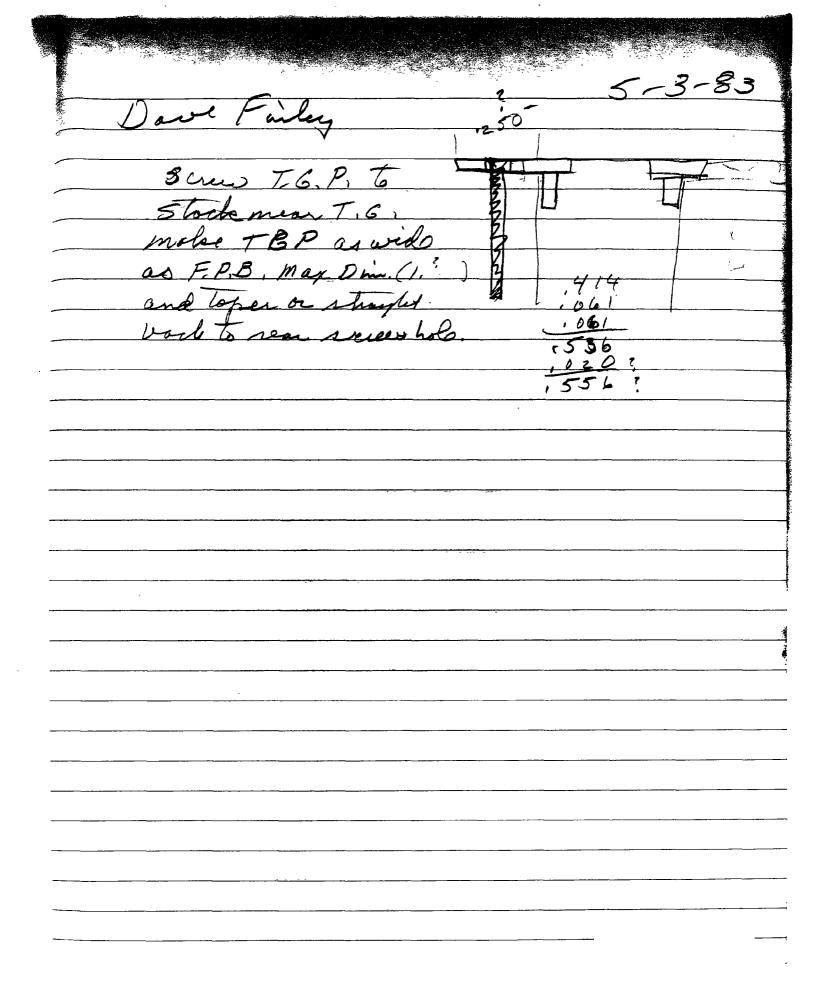
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-4	. 247	237	.092	.093	.097	.106
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	5/2/62	_
M/7 - Floor Plate Base brazed to T. G. Tab.	4-30	2-83
Tab Bigsed to Rear + Brazed	â.	
3775 / / RS. #FPO Coverage 12 / 3775 // // / / / / / / / / / / / / / / /	Opening 4.XT	Force
3481 20 0 10173 Y 3728 20 0 10359"Y	5.7. 4.0	Ħ
3475 20 1 .0257 Y 3689 20 0 .0249 Y 2814 20 0 0218 Y	5.5	
2814 20 0 .03/8" Y 3457 20 0 H.0361" Y 3611 20 1 0204 Y	4.5 4.2 3.8	
3377 5 2 .0305 n y . 3668 20 0 .0311 Y	2.2 5.0	<u>.</u> — ,
3405 20 0 .0221 Y 3433 10 2 .0301 Y	4.5	
3366 20 0 .0280 Y 3493: 20 0 .0256" Y 3676 20 0	5.2 3.\$	
3676 20 0 .030/ Y 15 GUNS W/FND - 5	4,6	
Total Shot - 15 Reject Rate 33%	•	9.5 \$4.5
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Tab Bia 34N # # 2979 20 3767 20 3417 20 3828 20 3680 20 3478 20 3333 20	00000	Coverage ( ) 329 M N Y .0329 M N Y .0355 Y .0355 N N .0381 Y .0381	Freduration From Forces (1/5) Francis From 1/200 (200 6.2 H 0/200 7/157 5.8 0/200 5.0 6/200 6/200
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OR - 000059

RD-69-B

#### REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE





Doug XC: \

XC: J. W. Brooks
R. A. Jackson
J. B. Mroz
R. L. Snedeker
C. B. Workman

"CONFINE YOUR LETTER TO ONE SUBJECT ONLY"____

May 6, 1983

TO: J. R. SNEDEKER

FROM: G. E. BARNES Day Som 3

#### - M/7 LATCH SPRING MEASUREMENTS

DIMENSIONS MEASURED:

.100 Diameter

.250 Diameter

.015 - .016 Mat'l. Thickness

.393 - .423 Dimension (See attached marked print)

PROCEDURE:

- 1. Take 30 pieces randomly from a lot size of 8,700, the only lot of M/7 latch springs on the plant. (Marked with Pen, 1-30)
- Fit ".250" diameter with pin (Snug fit to check actual dia.)
- Fit ".100" diameter with pin (Snug fit to check actual dia.) (This fit is dia. "A")
- Square the spring to optical comparator (20X) and measure distance from inside of .100 dia. to inside of hook (See marked drawing dimension "B")
- 5. Add ½ diameter "A" to dimension "B" to obtain dimension "C" which is the distance from the center of the ".100 dia.", as the hinge pin sees it, to the inner hook surface.
- 6. Measure material thickness (20X Optical Comparator).

#### M/7 LATCH SPRING MEASUREMENTS - Cont.

QR - 000059

RESULTS: All dimensions checked were within model drawing specifications on all thirty pieces.

> Model Drawing =  $.408 \pm .015$ DIMENSION "C": Mean = .4095Sample Std. Deviation= .0074

Range = .393 - .422

DIAMETER "A": Model Drawing = .095 - .105

Mean = .1003

Sample Std. Veviation = .0007

Range = .099 - .102

".250" DIAMETER: Model Drawing = .245 - .255

Mean = .2495

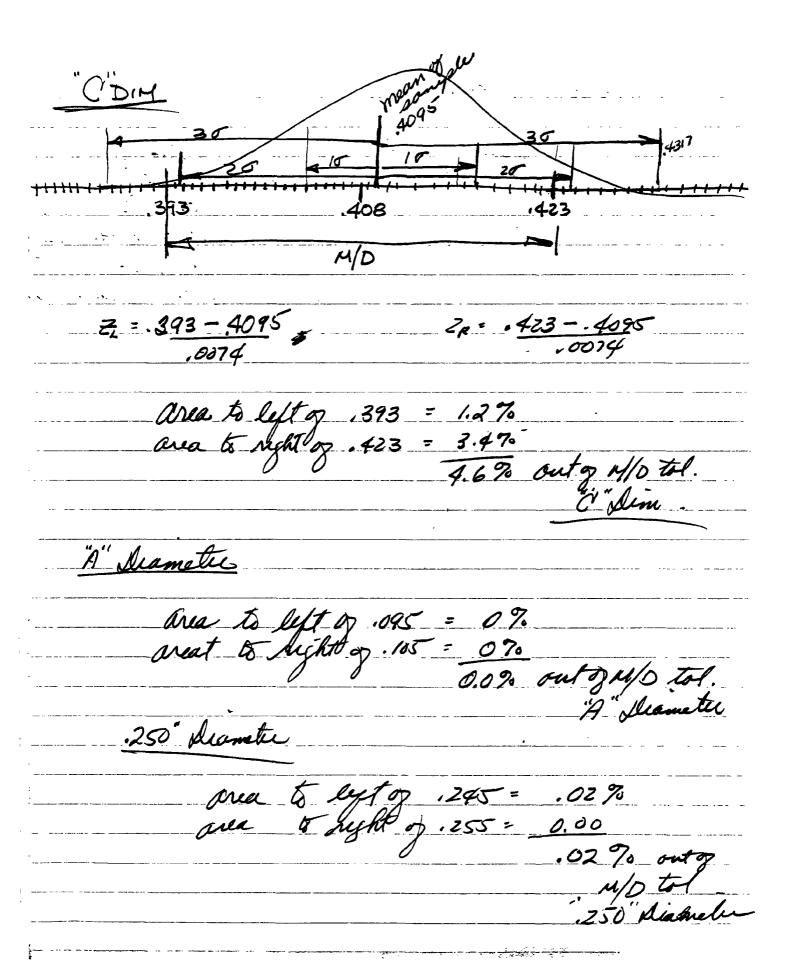
Sample Std. Deviation = .0013 = .247 - .252 Range

MATERIAL THICKNESS: Model Drawing = .015 - .016

Mean = .0152

Sample Std. Deviation = .0004Range = .015 - .016

GEB/cac JRS JA Attach.



### (SEE MARKED ATTACHED DRAWING)

05 May 83

BARBER - PRESALE R-0128439

ECE MBER	. 250 DIA.	.100 DIA "A" (.001 INCH)	.393423 DIMENSION "C" (.001 INCH)	,016016 MATERIAL THICKNESS (HONI 1004)		
	252	100.5	422	16		1
2	248	99.5	405	16		2
3	251	99.5	415	15		3
4	<u>25</u> 0	100.5	413	16		4
5	<u>25</u> 0	100.0	410	15		5
6	251	101.0	416	15		6
7	247	99.5	397	15		7
В	249	99.0	414	15		8
9	248	101-0	404	15		9
10	250	102-0	415	15		10
11	249	101-0	412	16		11
12	250	99.5	405	15		12
13	250	100-0	404	15		13
14	251	100.0	413	15		14
15	250	100.0	399	15		15
16	250	101.0	393	16		18
17	249	101.0	410	15		17
18	248	100-0	414	15		18
19	248	101.0	408	15		19
20	248	106.0	394	15		20
21	250	(01.0	416	16		21
22	250	99.5	412	15		22
23	252	100.5	422	15		23
24	248	101.0	414	15	<u>.</u>	24
25	248	100.0	410	15		25
26	247	100-0	402	5		20
27	250	100.5	4/2	15		27
28	250	101-0	409	15		28
29	250	101.0	413	15		29
30	250	99.5	409	15		30
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# 1.5c in 200 Investory 308 cal.

V= 4,23

Meser against in ac	
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3495	4168
3739	4252
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	419:4
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3429	40.93
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1285	<b>39</b> 58
1272	3770
£22	7068
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4019		3453	¥
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M/7-308 23. .760 3765 3791 3664 No pin, cracked
pinned, bad chamber
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Martinery Korn Hair Ports ケモカのたとドドチのはこれのこ 6 351-6 7603734 20MOJED 00, - - - + 3296 322 3625 NO Stort NO F. P.OSSIM NO MOS GOX 3531 6 MM ? T.W.B. Area, Nostact F. Doscon my is 6364418 6226270 7~1-08 622662 673 000 3746 eased F. P. assembly 3412 3453 27/ 17 T.G. 3750 ga row faire ist producest 3639 2962 NO STOCT GOT F. P. 250 7 3748 Field test, 18t prod. test 3/36 33/9 3617 Ling Niched New story 3352 3468 3690 3365 Corred Gonaidan 3337 X-pin ocrew Att. wetdram 3721 3461

or ot. G. , no stock 7603508 orion No y-pin No -Tri- grand crocked NO STOCK NO F. A. assem. 3714 , ~0 ~ 72. COX 3293 Orig T.G, NO Y-PIN 3603 SHITE TIS, X-PIN old T.G., NOX-pin. wacker 3502 Stroin gage, obl, rear ocres, F.A. assembly 3448 old T.G., NOX-PIN, cracked stock 2987 3627 15+ 15+ 4+ Tot TG. 3787 ob T.S. No X-yin cracked 3370 3770 3464 2 stocks in/offed for that assem.

# 50. No. 7601290 1293 1286 1300 1297 1301 1296 1287

1288 endarance 2010

553

В	ARBER - PRESAL	E R 0128447	Model Seven 308
. ***	DATA LISTI ON DATA SE FT GUNS		Fredd Test 5/6/83
`~****	Pacons Cons Cons	OFB OFA	All with modified hateless for increased coverage
<i>,,</i> ,	.0696 .0690	6.5000 6.5000	All gons-coverage adjusted by removing wood from
	.0633 .0640 .0633	4.5000 4.5000 4.7500	stocks not by bonding F.D. assembly.
`	.0556 .0 <b>≸</b> 91	4.7500 5.2500	F.V. assemby.
	.0677 .0678 .0478	5.0000 5.5000 5.2500	
	.0649 .0600	5.7500 4.7500	· • • • •
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	.0558 .0547 .0643	5.5000 4.5000 6.2500	
ð.	.0543 .0605	6.0000 4.7500	
	.0587	4.7500	·
. <del>4"</del>	DCO♥	DOF	NEAUS TON Reduction
	0006	0.0000	MEMUCHIN
	.0007	0.0000	Rea
	0077 0014	0.0000 2500	bessible
	0200	2500	more coverage 1
	0049	-1.0000	more coverage possible with adjustment
	0016	.7500	
	~.0011	-1.0000	
	•	. 2500	10 -,0018 0,000

#### **BARBER - PRESALE R 0128448**

-.0100

-.2500

-.0018

0.0000

	5-26	-83
M7 Hervin math	cera 10	25 parts
1. Ogening lace 7 th mi.		
2, 50% latch coverage min		
3. Bedding position of T. G. seconday in	tools (washing	(nopolan)
3. Bedding position of T. G. seconday in . 4. Tugger general tight to T. G. P.	-	, v
5, ingle set men 52 100 6, Comme between floor Plate + store 7, Heat Treated T. C.		
6, Came between floor Plate + store	b. (?)	
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	<i>)</i>	
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#### QUOTATION

No. 11165 PLEASE SHOW THIS NUMBER ON YOUR ORDER



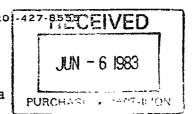
 $ext{NYLOK}_{\odot}$  self-locking threaded fasteners 11 THOMAS ROAD

HAWTHORNE, NEW JERSEY 07507

THE HEW JERSET U/50/

TO Remington Arms Co Inc Ilion NY 13357

ATTN: Louis B Ferreira



TWX: (710) 988-4140

DATE 6-3-83

YOUR REFERENCE Request

Thank you for your inquiry dated 6-2-83

We are pleased to quote you the following prices:

QUANTITY	DESCRIPTION	PRICE	DELIVERY
10000	P/N 92248 8-36 x 31/32 Stl Slot Oval Hd Pellet	77.50/M	1-2 Wks to Dri 2-3 Wks Insert the Pell
25000	11 11 11 11 11 11 11 11 11	74.20/M	11 11 11 11 11
50000		69.55/M	31 H H H
	NOTE - For pellet processing the parts would us in a soft condition for drilling parts to Remington Arms for heat tree re-ship to us for insertion of pelle	, we would re eat then you	turn drilled
10000	P/N 92248 8-36 x 31/32 Stl Slot Oval Hd Patch	9.10 <b>/</b> M	1-2 Wks ARM
25000	11 H H H H H H H H	8.15/M	1-2 Wks ARM
50000	паннавая	7.05/M	1-2 Wks ARM

#### THE ABOVE PRICES WERE QUOTED FOR PROCESSING ONLY!

We appreciate this opportunity to quote you and look forward to receiving your order for our prompt attention.

Both prices and delivery dates quoted above are subject to confirmation and are not binding on the Seller until confirmed by written acceptance of Buyer's order. The Buyer in placing any order on this quotation shall be understood as accepting the conditions of the Seller's standard terms of sale printed on reverse side hereof.

Prices quoted are based on bulk packaged shipments, and are firm for 90 days, unless otherwise noted.

No product shall be returned without prior written approval

TERMS Net 30 days;

F.O.B. POINT: HAWTHORNE, N. J. WJL/pn

AEROSPACE NYLOK CORPORATION

WILLIAM I TAN

ORIGINAL

THE ULTIMATE IN FASTENER RELIABILITY

700BDLR A 26355 1.54 A 91988

M ADGR A 152871480 A 91803

Front C 22035 C 23810

ADG F C 22035 C 29816

R 817580 1.555

7 2 8 9180 Line 92248

F 22035, 120 C 28810

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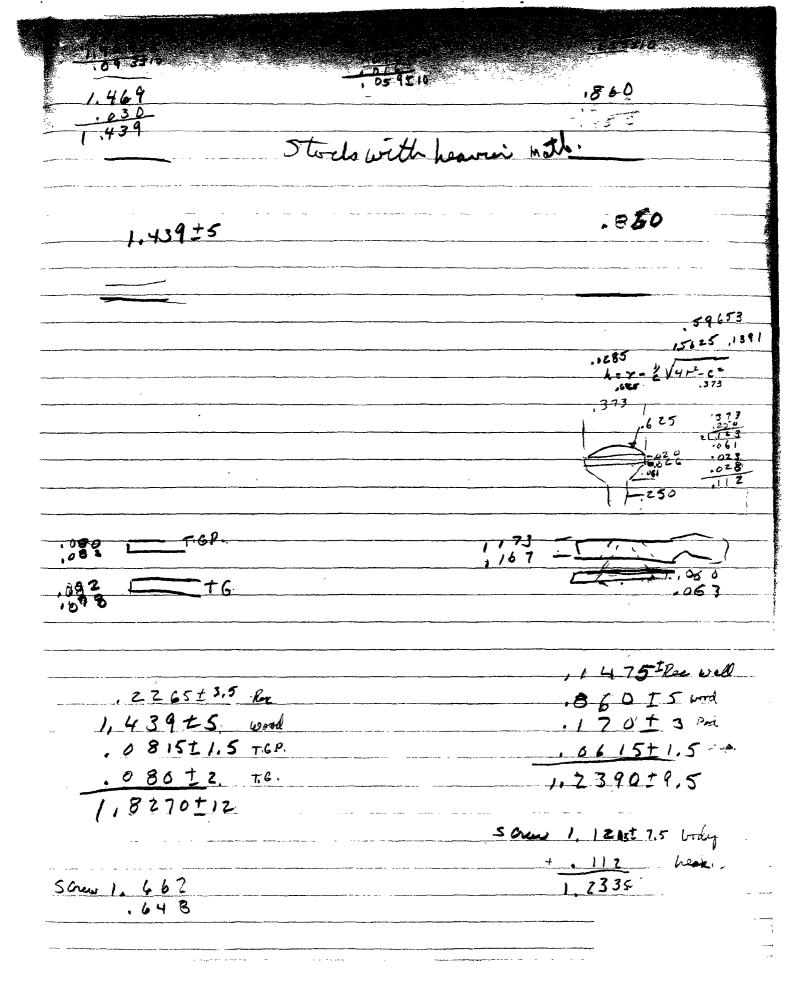
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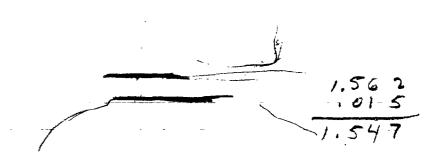
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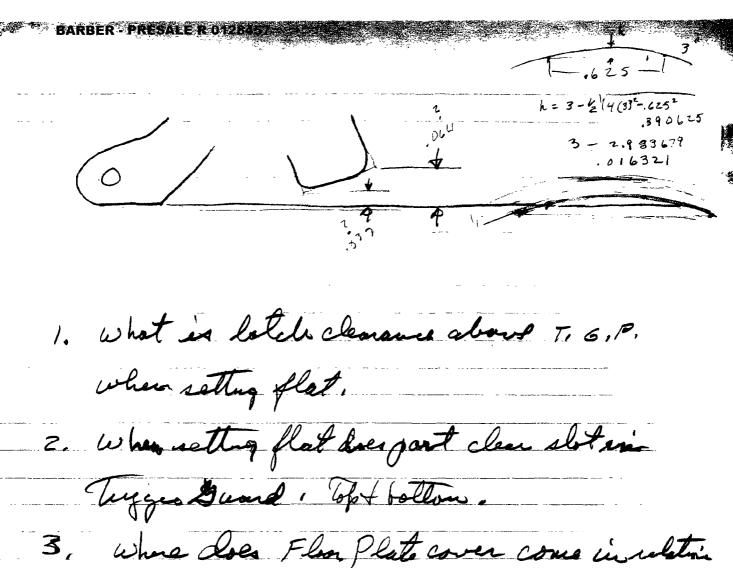
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## Remington Rem-O-Gram

Quick Facts About REMINGTON PRODUCTS

1C DI 1.W. BROOKS 1L10H

cc: House Force

June 22, 1983

TO THE FIELD FORCE

REVISED AVAILABILITY - MODEL SEVEN & MODEL 1100 SPECIAL FIELD

#### MODEL SEVEN 7mm-08 AND 308

We have been unable to meet our previous committment to have all Model Seven rifles in production early in 1983. Demand for our bolt action center fire rifles has been much stronger than expected resulting in heavy back orders on key calibers. Our efforts to clear up Model 700 back orders have delayed work on production of the Model Seven 7mm-08 and 308 calibers. At this point, it appears that product will be available in the first quarter 1984.

In consideration of this delay, we will alter our Early Order-Early Ship Program to enable distributors to replace their 7mm-08 and 308 orders. Distributors may place a single order prior to September 1 for immediate delivery for any specification in the Model 700 or 222, 243, and 6mm calibers in the Model Seven. The total number of rifles ordered may not exceed their total order for Model Seven 7mm-08 and 308. This additional order will qualify for the 4% Early Order-Early Ship discount and current anticipation terms.

#### MODEL 1100 SPECIAL FIELD 12 GAUGE

Endurance testing of the Model 1100 Special Field 12 Gauge has revealed a tendancy for fore-ends to crack after extensive shooting. We are not satisfied with this condition and have re-designed the fore-end retention system. Tooling required for the improved design will delay production until early 1984.

Twenty gauge guns are not affected and will be delivered on schedule. As with the Model Seven, we will extend the Early Order-Early Ship Program so that distributors may replace their Model 1100 Special Field 12 gauge guns with any other Model 1100 specification including the 20 gauge Special Field. They may

REMINGTON ARMS COMPANY, INC., BRIDGEPORT 2, CONN.

Ferm No. RD 451

Printed In U.S.A.

TO THE FIELD FORCE

June 22, 1983

#### MODEL 1100 SPECIAL FIELD 12 GAUGE (Cont'd.)

order up to the total quantity of 12 gauge Special Field shotguns previously ordered. This single order will qualify for the 4% discount and current anticipation terms if received by September 1 for immediate delivery.

Please review Model Seven and Model 1100 Special Field 12 gauge order positions with your distributors. Make certain they understand the one-time option available to them to replace the delayed product at Early Order-Early Ship Program prices.

Every effort is being made to expedite delivery of these products. We will keep you posted of further developments.

E. J. Conroy

Director of Sales

EJC:WHF:daf

RD-69-E

#### REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE

Remington **QUPOND** 



"CONFINE YOUR LETTER TO ONE SUBJECT ONLY"___

July 29, 1983

TO:

J. Linde

FROM: D. Riccinf

REFERENCE: M/7 Steel Purchase Parts Components for Fire Control Area

The Steering minutes and other verbal communications say that all involved vendors should have been notified of the steel design obsolescence and that Purchasing should refrain from ordering additional parts.

It is my understanding that the die cast design will be released for build approximately 9-1-83, with first samples due in December '83. Upon approval, trial & pilot and production build leadtimes, the earliest phase-in would be late first quarter or early 2nd quarter 1984.

Therefore, in absence of any further communication, Purchasing will continue to order the steel components per the MRP schedule, but minimum quantities to facilitate the transition next year. We'll begin advising our vendor of the possibility of a new design (since it is not a proven one) in order to keep them from running any shelf stock or ordering excess raw materials.

Also, previous orders had been issued for certain thicker design components, but were placed on hold. Again, if not advised otherwise, all outstanding orders for tools, components or raw materials will be cancelled and invoiced according to all work performed prior to the hold notification.

Based on current inventories, it appears that additional orders will have to be placed toward the end of August for MRP requirements in December '83. We will proceed with the program outlined unless otherwise advised.

DDR/sjk

XC: L. Ferreira S. Johnson

R. Long

File

J. Brooks

#### ROUTE:

J. W. Brooks
D. F. Bullis
P. M. J. Hagen
T. J. Hagen
T. J. Plunkett

-	LISTENING To american consumers in history!
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	M. V. Jones
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	P.S. I'm a salesman, and would happily take-lo responsibility for waring 10K as so These myself.
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"DON'T TAKE A CHANCE, THINK SAFETY IN ADVANCE"



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and in design tid divide Helial	-GUNS RECUIRED:  3 - 7617 GUNS  3 - REG PINNES SPRING & CATCH  3 - MACK SPRING.  NOTE: NO firearms or parts will be tested in the Labs unless they are accompanied by a Work Raquest, and both are delivered to	

20-46-B

# REMINGTON ARMS COMPANY, INC.

NTER-CEPARTMENTAL CORRESPONDENCE

Distribution: J. W. Brooks

C. E. Ritchie D. E. Bullis

Remineton

PETERS

"CONFINE YOUR LETTER TO ONE SUBJECT ONLY"_____

"TEST RESULTS ONLY"

RESEARCH TEST and MEASUREMENT REPORT - Report No. 823191

M/SEVEN LWT. WIDE LATCH SPRING VS. NARROW LATCH SPRING POUND FORCE TO OPEN FLOOR PLATE COMPARISON

Prepared by: R. Howe

Date Prepared: 11-15-82

Proofread and Cleared By:

J.H. Hennings , | R.E. Nightingale,

C.E. Ritchie,

Sr. Supervisor - Testing, Meas. & Mech. Analysis Lab Signature

____

# TEST & MEASUREMENT LAB REPORT

REPORT NUMBER:	8231	91
REPORT TITLE:		VEN LWT WIDE LATCH SPRING VS. NARROW LATCH NG POUND FORCE TO OPEN FLOOR PLATE COMPARISON
MODEL(S):	M/SE	VEN LWT.
GAUGE OR CALIBE	R:	
DATE:	11-15	5-82
WORK ORDER NO.:	C-18	56-000
PART NAME:	Latch	n Spring
DESIGNER/ENGINE	ER:	
TEST TYPE:		
1		PHOTO LAB
2	•	STRENGTH TEST - NO. OF GUNS TESTED
3		FUNCTION TEST - NO. OF GUNS TESTED
4		ACCURACY TEST - NO. OF GUNS TESTED
5		MEASUREMENTS - TYPE: Pound Force To Open Floor Plate
6	•	ENVIRONMENTAL TEST
7		AMMUNITION TESTING & EVALUATION - TYPE:
8		VISUAL EVALUATIONOUT OFGUN SAMPLE
9		ENDURANCE - NO. OF GUNS TESTED:3
		NO. OF ROUNDS PER GUN:
		TOTAL ROUNDS FIRED IN TEST:
		AMMO TYPE: MAGS; TARGET:
		RIM FIRECENTER FIRE

REMINGTON ARMS CO. INC. Firearms Research Division

Report No. 823191

November 16, 1982

'RESULTS ONLY"

TO:

J. H. Hennings

FROM:

R. Howe

REPORT TITLE:

M/SEVEN LWT. WIDE LATCH SPRING VS. NARROW LATCH SPRING

POUND FORCE TO OPEN FLOOR PLATE COMPARISON

#### REASON FOR TEST

To measure pound force difference required to open floor using "Regular" wide pinned latch spring vs. narrow "Half Wide" pinned latch spring.

#### TEST PROCEDURE

Three (3) M/Seven LWT. from R. & D. Gun Room were set up with C. B. Workman's New Design No. 5 Latch and "Regular" pinned wide latch spring. Then pound forces were checked with Chatillon Spring Scale (three readings for each). The three wide springs were then replaced with narrow "Half Wide" springs and Lb. force to open, taken again (3 each) for comparison.

#### TEST RESULTS

		No. 1 Lb. Reading	No. 2 Lb. <u>Reading</u>	No. 3 <u>Lb. Reading</u>	Average Of 3 Lb. Readings
"Regular"	No. 1	7.25	7.75	7.50	7.50
Wide Spring	No. 2	8.75	9.00	8.00	8.58
	No. 3	11.50	11.50	12.00	11.66
"Half Wide"	No. 1	4.50	4.75	4.75	4.66
Narrow Spring	No. 2	4.00	4.25	4.00	4.08
	No. 3	4.25	4.50	4.25	4.33

Supplement Comparison Test On M/700 on the following page.

November 16, 1982

#### REPORT TITLE

Supplement: M/700 Trial & Pilot Classic 300 H & H Mag. Pound Force To Open Floor Plate For

Comparison To M/Seven LWT. Using Wide and Narrow Latch Springs.

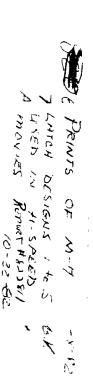
#### TEST PROCEDURE

Eight (8) M/700 Trial & Pilot "Classic" 300 H & H Mag. from Engineering were checked for pound forces to open Floor Plate (average of three readings each) with Chatillon Spring scale (0 to 10 lbs.) for a comparison with M/Seven LWT. w/"Regular" and "Half Wide" Springs on previous page.

#### TEST RESULTS

	Lb. Reading No. 1	Lb. Reading No. 2	Lb. Reading No. 3	Average of 3
Gun No. 1	6.50	7.00	6.25	6.58
2	7.00	7.50	7.75	7.41
3	8.50	9.00	9.25	8.91
4	8.25	8.75	8.50	8.50
5	5.75	6.25	6.00	6.00
6	6.75	7.00	6.75	6.83
7	7.50	7.75	7.50	7.58
8	6.00	6.25	6.00	6.08

Remort # 8228//



# REMINGTON ARMS COMPANY, INC.

Remington

Distribution: C. B. Workman

J. W. Brooks

C. E. Ritchie

D. E. Bullis

"CONFINE YOUR LETTER TO ONE SUBJECT ONLY"_

RESEARCH TEST and MEASUREMENT REPORT - Report No. 822811

M/SEVEN "TRIAL & PILOT" FUNCTION TEST FOR FLOOR PLATE COMING OPEN ON FIRING - 308 CAL. & 7MM-08 CAL.

Prepared by: R. Howe

Date Prepared: 10-25-82

Proofread and Cleared By:

R.E. Nightingale,

C.E. Ritchie.

Sr. Supervisor - Testing,

Meas. & Mech. Analysis Lab

# TEST & MEASUREMENT LAB REPORT

REPORT NUMBER:	822811
	M/SEVEN LWT. "TRIAL & PILOT" FUNCTION TEST FOR FLOOR PLATE COMING OPEN ON FIRING.
MODEL(S):	M/SEVEN LWT.
GAUGE OR CALIBER:	.308 & 7MM-08
DATE:	10-25-82
WORK ORDER NO.:	C-1856-000
PART NAME:	Floor Plate
DESIGNER/ENGINEER:	D. Bullis
TEST TYPE:	
1.	PHOTO LAB
2.	STRENGTH TEST - NO. OF GUNS TESTED
3.	FUNCTION TEST - NO. OF GUNS TESTED
4.	ACCURACY TEST - NO. OF GUNS TESTED
5.	MEASUREMENTS - TYPE: Lbs. Pressure to Open Floor Plate
6.	ENVIRONMENTAL TEST
7.	AMMUNITION TESTING & EVALUATION - TYPE:
8.	VISUAL EVALUATION - OUT OF GUN SAMPLE
9.	ENDURANCE - NO. OF GUNS TESTED:
	NO. OF ROUNDS PER GUN: 165/20 Guns
	TOTAL ROUNDS FIRED IN TEST: 3,300
	AMMO TYPE: MAGS; TARGET:
	RIM FIRE CENTER FIRE X

REMINGTON ARMS INC., INC. Firearms Research Division

Report No. 822811

October 25, 1982

TO:

J. H. Hennings

FROM:

R. Howe

REPORT TITLE:

M/SEVEN LWT. "TRIAL & PILOT" FUNCTION TEST FOR FLOOR PLATE

COMING OPEN ON FIRING

#### **ABSTRACT**

Ten M/Seven LWT. .308 cal. and Ten M/Seven LWT. 7MM-08 "Trial & Pilot" line guns were received from D. Bullis for evaluation. All twenty were "Live Fire" field function tested by R. & D. Test Lab.

#### SCOPE OF TEST

To check for Floor Plate coming open on firing of live rounds.

#### TEST RESULTS:

Of the twenty guns tested 50% showed low to high frequency of the Floor Plate openings when fired with 140 gr. and larger bullet weights.

#### REPORT TEXT

Of the twenty guns tested, six of the ten .308 cal. and four of the ten 7MM-08 cal. (or 50%) had from one to very high occurrence of the Floor Plate falling open when fired (off the shoulder) using 140 gr. and larger bullets.

All occurrences are broken down as to gun number, shooter and bullet weight in Appendix "A". All other data and measurements in Appendix "B".

NOTE: High speed films of "Floor Plate Opening When Fired" are available in the R. & D. Photo Lab Library.

#### TEST PROCEDURE

#### A. Measurements

The following measurements were taken on all twenty guns tested:

Headspace "After Proof" -.000 inch.

Floor Plate Latch Release Force - .lbs.

#### B. Test Conditions

All twenty guns were checked in the Test Lab for Headspace after proof and Floor Plate Latch release forces (in pounds) were taken for each gun as follows:

Three readings each with 0 - 1 - 2 - 3 & 4 "Dummy" rounds in the magazine. Results in Appendix "B".

They were then taken to the Rifle Range at the Ilion Fish and Game Club to be live fired (from the shoulder) to a total of 165 rds each. (For a test total of 3,300 rds. for twenty guns.)

To check for Floor Plate falling open on firing. Results in Appendix "A".

"TEST RESULTS"

"APPENDIX "A"

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- 18 - 8	?1		<del></del>	# TIMES	FLOOR	PLATE	FELL	OPEN	OHLY)			W	1.0. # C 185	
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% #%	OH ORIGINAL W.O.	TIMES FLOOR	~ <u>~</u>			1						PER	TEST	TOTALTA
اجد عو	CON BRIGHT STORY	PLATE OPENED									 	SHOOTER	1650 RDS.	4
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Ζ,	R. EASTWOOD	1-12-13	12			†'   † †								
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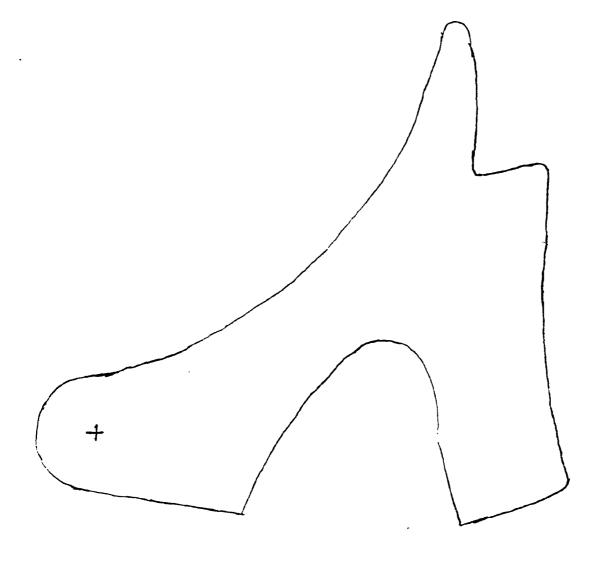
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OOTES	SERIAL NO.  GUN NO.  ANMO, R-140-PSP ALL	7600098/ <b>1</b>	7600010	7600094 3	7600133	7600137 5	7600081 6	7600080	7600148 8	7600130 9	7600144 10	TOTAL PER. SHOOTER	1650 RP	TOTAL TES
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<i>3</i> .	IT WEAVER					2	27					30		
<b>4.</b>	C DICKENSON					1	30					3.2		
5.	D. JENNINGS					<b>/</b>	25					26		
	TOTALPER GUN		0/1	0/<	ok	6	146		oK	0/5	oK.			
	TOTAL PER BULLET WT 154" ALL Ammo - R-140-PSP -													
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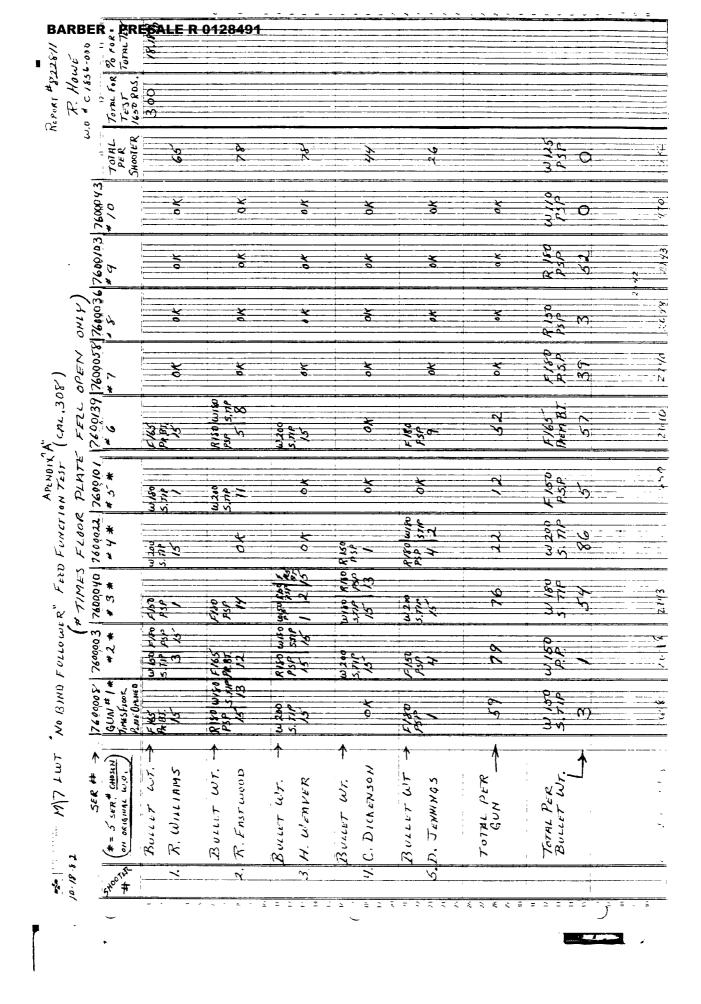
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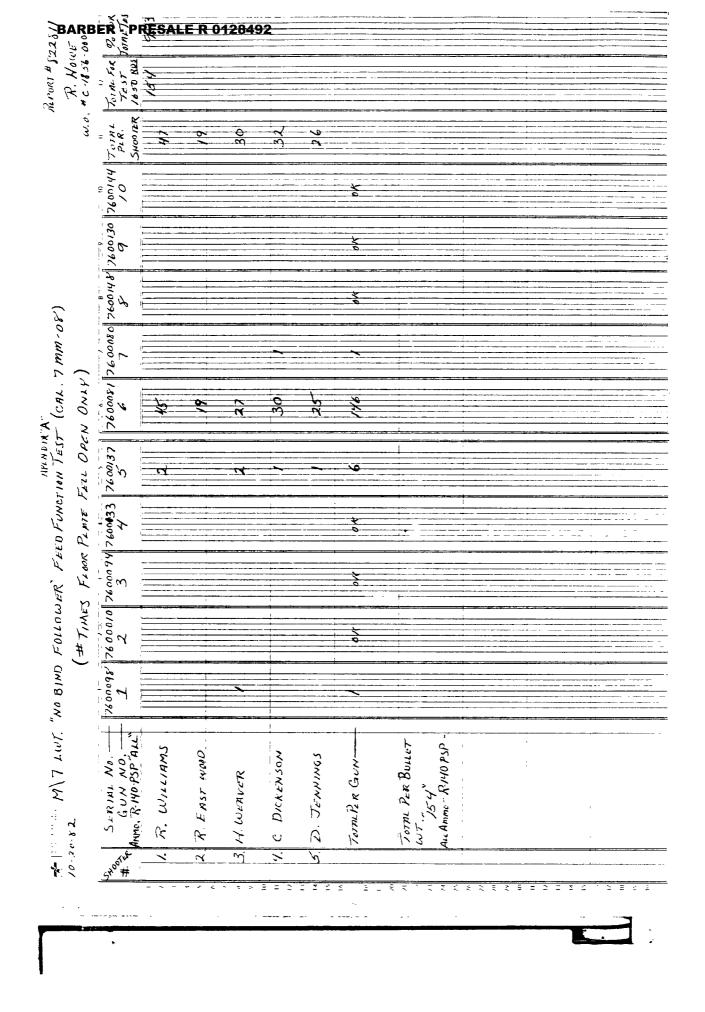
NOTE

ALTERATIONS SHOWN BY DOTTED LINES -----



		Report No. 522511
RESEARCH TES	T & MEASUREMENT LAB WORK F	REQUEST
Developmental Design Acceptance  Pre-Pilot Pilot Production Acceptance  FIREARM STAT'S MODEL: 7 427  CAL	Safety Related  Competitive Eva  New Design  Design Change  Plant Assistance  REPORT REQ'D.  FORMAL  TEST	REA OF TESTING Litigation  Warenouse Audit Cost Reduction Stake
PROOFED: YESNO	RESULTS CNLY	WORK ORDER NO: CIPIG
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NOTE: NO firearms or parts will be tested in accompanied by a Work Request, and the Labs by the designer or engineer, to be filled out in detail. No Exception	d both are delivered to All Work Requests are	DATE COMPLETED: 11-3-6つ/ TEST COMPLETED BY: 11・3・6つ/ REPORT DATE: 11・3・6つ/





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### "APPENDIX "B"

"CONTENTS"

All Data, Malfunctions and Measurements Not Contained
In Appendix "A"

FIELD CYCLE	TEST -	CENTERFIRE
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REPROT N	0.1	822	811
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PAGE NO.

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760002	2	1	165																	7		-				-	22	23	1
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REMINGTON ARMS COMPANY, INC.

Distribution: C. B. Workman J. W. Brooks

C. E. Ritchie D. E. Bullis

Remington 

"CONFINE YOUR LETTER TO ONE SUBJECT ONLY"_

"Supplement"

RESEARCH TEST and MEASUREMENT REPORT - Report No. 822811

M/7 LWT. "TRIAL & PILOT" FUNCTION TEST FOR FLOOR PLATE COMING OPEN ON FIRING. .308 CAL. AND 7MM-08 CAL.

Prepared by:

R. Howe

Date Prepared: 11-3-82

Proofread and Cleared By:

J.H. Hennings

R.E. Nightingale.

C.E. Ritchie.

Sr. Supervisor - Testing, Meas, & Mech. Analysis Lab

Foreman-Test La Foreman-Measurement Lab

## TEST & MEASUREMENT LAB REPORT

REPORT NUMBER:	822811 "Supplement"
REPORT TITLE:	M/7LWT. "Trial & Pilot" Function Test For Floor Plate Coming Open on Firing308 Cal. and 7MM-08 Cal.
MODEL(S):	M/7LWT.
GAUGE OR CALIBER:	.308 & 7MM-08 Cal.
DATE:	11-3-82
WORK ORDER NO.:	C-1856-000
PART NAME:	Floor Plate
DESIGNER/ENGINEER:	D. Bullis
TEST TYPE:	
1.	PHOTO LAB
2.	STRENGTH TEST - NO. OF GUNS TESTED
3.	FUNCTION TEST - NO. OF GUNS TESTED 20
4.	ACCURACY TEST - NO. OF GUNS TESTED
5.	MEASUREMENTS - TYPE: Lbs. Pressure to Open Floor Plate
6.	ENVIRONMENTAL TEST
7.	AMMUNITION TESTING & EVALUATION - TYPE:
8.	VISUAL EVALUATIONOUT OFGUN SAMPLE
9.	ENDURANCE - NO. OF GUNS TESTED:
	NO.,OF ROUNDS PER GUN:
	TOTAL ROUNDS FIRED IN TEST:
	AMMO TYPE: MAGS; TARGET: X
	RIM FIRECENTER FIRE

REMINGTON ARMS CO., INC. Firearms Research Division

Report No. 822811 Supplement

November 5, 1982

TO:

J. Hennings

FROM:

R. Howe

REPORT TITLE:

M/SEVEN LWT. TRIAL & PILOT FUNCTION TEST FOR FLOOR PLATE

COMING OPEN ON FIRING.

(SUPPLEMENT TO REPORT No. 822811 SHOT ON OCT. 12th & 19th, 1982)

#### REASON FOR SUPPLEMENT TEST:

After the Field Test of 10-12-82 and 10-19-82 that showed 50% malfunction rate it was decided to change the design of the Floor Plate Latch on the M/Seven LWT.

Changes were made as follows:

- Design No. 0. Standard Current Production Latch
  - 1. Standard Current Pinned
  - 2. Standard Current Pinned and Clipped
  - 3. Standard Current Pinned, Chambered and Clipped
  - 4. Pinned, Chambered, Clipped and Extended Square
  - 5. Pinned, Chambered, Clipped and Extended Angle
  - 6. "Standard" Design of Aluminum

NOTE: All above Designs were placed in guns and shot in Photo Lab with the following ammo types; Cal. -.308 - W-200 - Silver Tip, Cal. - 7MM-08 - R-140-PSP, High Speed Movies of the above latch designs showing their respective success or failure are available in the Photo Lab Library. See Appendix "A".

Drawings of above designs in Supplement Appendix "A".

After observing the above movies, it was decided to Field Test, "on 10-28-82" Design No. 5 using both a wide standard production latch spring and a narrow "altered" production latch spring. Five of each spring type for a total of ten guns, to be fired 50 rounds each. Guns were numbered 1 through 10.

It was also decided to use ten M/Seven LWTs from production with the "current" standard (Design No. 0.) production latch and spring as a control group for this test. These were numbered 11 through 20 and also fired 50 rounds each.

Guns 1 through 10 with new Design No. 5 latch were set up as follows:

Numbers 1 - 3 - 7 - 8 - 9 with narrow "Altered" Spring Numbers 2 - 4 - 5 - 6 - 10 with wide standard spring

Results (of test on 10-28-82)

50 rounds W-200-S. Tip. shot in each gun.

Guns No. 1 through 10 with New Design No. 5 latch showed little or no movement of latch and only gun No. 3. using "Altered" narrow spring had any problem with Floor Plate falling open, while guns No. 11 through 20 (Control Group) had considerable problems with Floor Plate falling open and latch movement.

All Floor Plate openings and Latch Movement listed in Supplement Appendix "B".

### **BARBER - PRESALE R 0128500**

M/Seven LWT. Trial & Pilot Function Test For Floor Plate Coming Open on Firing

Report No. 822811 Supplement

### Follow-up Test for Design No. 5

On 10-29-82, guns No. 1 - 3 - 7 - 8 - 9 and guns No. 11 through 20 were equipped with Latch Design No. 5 and "Standard" Wide Spring. Then taken back to the Ilion Fish and Game Rifle Range and shot 50 rounds each with W-200 S. Tip.

## Results (Of Field Test On 10-29-82)

All 15 of the above guns with New Design No. 5 Latch and Wide Spring had no occurance of latch moving or Floor Plate falling open shooting 50 rounds each of W-200 - S. Tip.

Results of above Test in Supplement Appendix "C".

NOTE: "Opinion": All Take Down "Floor Plate" screws on M/Seven LWT. should be tightened at least 30 inch pounds to prevent flexing of Floor Plate on recoil.

Report No. 822811 Page 1

M/Seven LWT. "Trial & Pilot" Function Test For Floor Plate Coming Open on Firing .308 Cal. and 7MM-08 Cal.

M/Seven LWT. Latch Evaluation High Speed Film List (Available in Photo Lab Library)

			nal Gun ''	_	Ourrent'' .058 .022 .040		ld L. atch	Stayed (	Closed	Film 3D-1
Design No.	O.									
1 Shot		7MN	<i>I</i> -08		.140 gr	Bullet	(	Opened		Film 3D-2
Design No.	<u>Q</u> .									
5 Shots	1.	Ser :	No.		.003		(	Opened		Film 3D-3
	2.	"	• •		.010			,,		
	J.		,,		.103			Stayed		
	4.	"	"		.139			Opened		
	5.	"	,,		.028		ç	Stayed		
Design No. J. W. Bro I Shot	oks				l Latch v	w/.020 S	Sprin	g.		Film 3D-4
Design No.	2	Old	Late	h Pini	red & C	ipped				
		7M1	30-IV	31	40 Gr.					Film 3D-5
5 Shots	ì.	Ser.	No.		.003		;	Stayed		
	2.	"	"		.101			"		
	3.	,,	,,		.043			"		
	4.	"	"		.139			"		
	5.	"	"		.103		1	Opened		
Design No.	3	Mod	dified	Pinn	ed Latel	1				
		Pin	ned &	Chai	nbered (	& Clippe				Film 3D-6
4 Shots	1.		No.		.101		1	Opened		
	2.	**	"		.139					
	3.	"	"		.103			_		
	4.	"	"		.003 W	I/Protot	yped	Guard S	Shot No. 4 Only	7
Design No.	_ :	Fred	Mart	in La	tch "W/	Ball End	**			Film 3D-7
1 Shot			. No.			20-82				

# **BARBER - PRESALE R 0128502**

M/Seven LWT. "Trial & Pilot" Function Test For Floor Plate Coming Open on Firing .308 Cal and 7MM-08 Cal.

Report No. 822811 Page 2

		low In Use'' (W/Wi			Film 3D-8
3 Shots 1.	Design No. 5	Reg. Wide Spring,	Ser. No040	Stayed	
2.	Design No. 0	Reg. Wide Spring,		Opened	
3.	Design No. 5	Narrow Spring	"".040	) Stayed	
	– Aluminum La '' Seven Films V	itch W/Prototype Guard			Film 3D-9

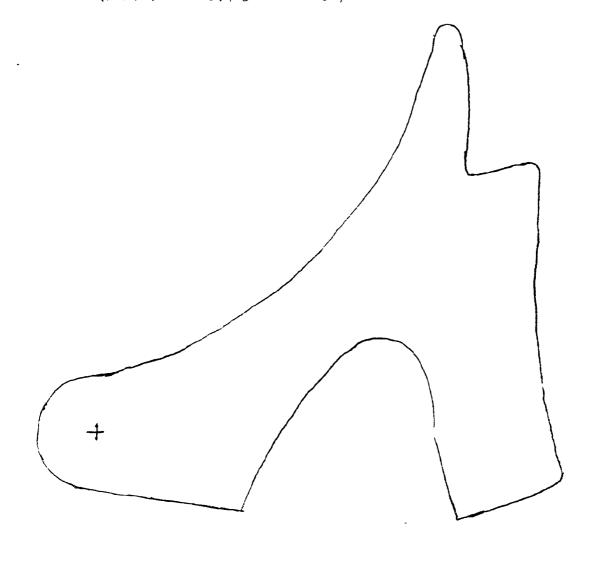
" 10 " 11 " 12 " 13 " 14 " 15 Supplement

"APPENDIX "A"

MY LW.T. LATCH DESIGN # O

CURRENT" STANDARD LATCH (FROM PRODUCTION)

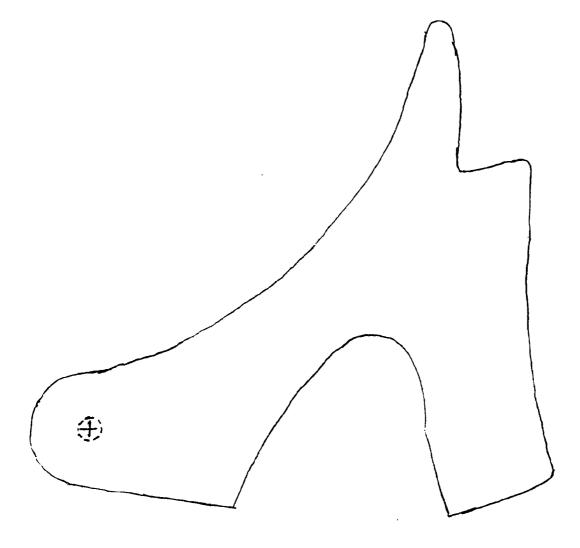
GLIERATIONS SHOWN BY DOTTED LINES -----



MY LW.T. LATCH DESIGN # 1

NOTE "CURRENT" PINNED

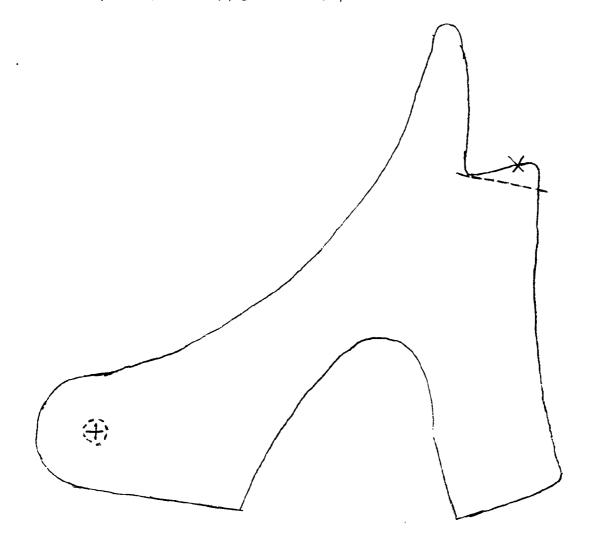
FALTERATIONS SHOWN BY DOTTED LINES -----

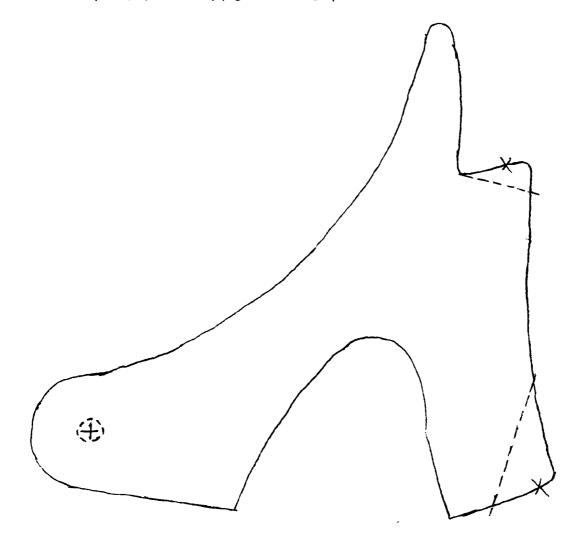


MY LWT. LATCH DESIGN#2

NOTE CURRENT PINNED + CLIPPED

ALTERATIONS SHOWN BY DOTTED LINES -----

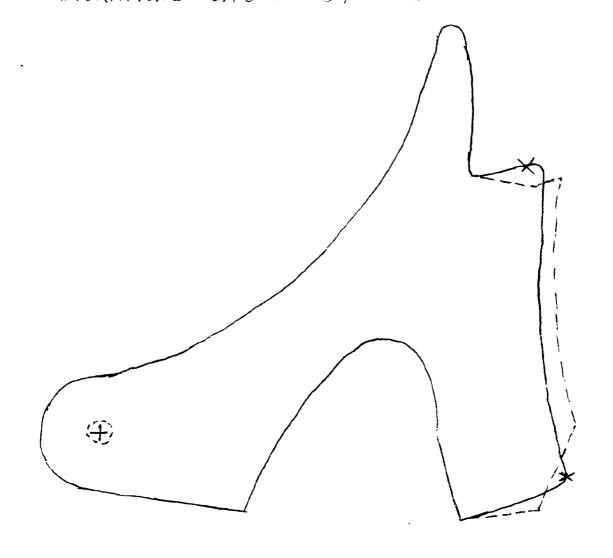




MY LW.T. LATCH DESIGN # 4

NOTE PINNED, CHAMFERED, CLIPPED + EXTENDED SQUARE

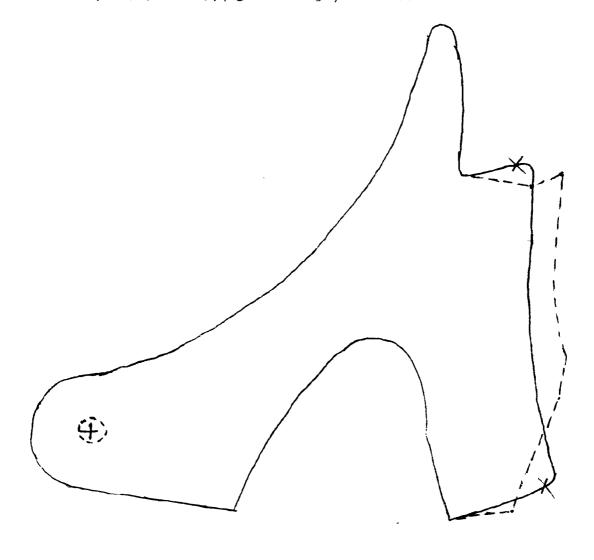
- GLIERATIONS SHOWN BY DOTTED LINES -----



MY LW.T. LATCH DESIGN #5

NOTE PINNED, CHAMFERED, CLIPPED + FXTENDED ANGLE

- GLIERATIONS SHOWN BY DOTTED LINES -----



Supplement

"APPENDIX "B"

Test of 10 - 28 - 82

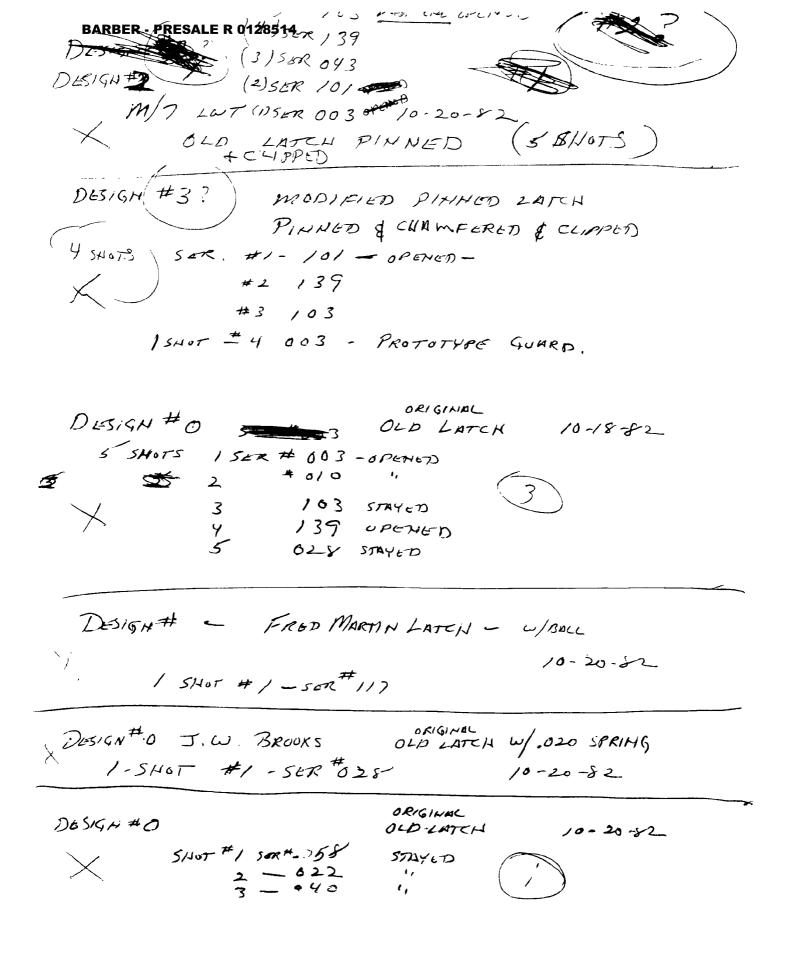
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1 JOE BAGGETTA	OK	OK	20	<del> </del>	ION	101	5 2-5	- [د	OA .			3-5	5	2.5	2.5	2-1	5	2-5	2:-5	\$				ШШ
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Supplement

APPENDIX "C"

Test of 10-29-82

SHOOTER  SHOOTER NAME  (5 RDS EACH GUN)  1 JOE BAGGETTA	# /	5ER,#		12===	
# SHOOTER NAME  (5 ROS EACH GUN)	1				11
(5 ROS EACH GUN)	1				11
	/		1		1
1 JOE BAGGETTA		7600028			# 111
Jo Shige/IA					
	3	7600040			
	7	7600058			
2 BOB HOWE					
	5	7600036			
1	7	7600103			
3 BOB BALASKA					
	1/	7600052			
B B	12	7600063			
4 BOB SMITH					11
11	13	7600120			
	14	76000/3			
5 ROH WILLIAMS					44
	15	7600065		11-1-1	4 1
	16	7600034		<del>                                     </del>	
6 RALPH EASTWOOD	<b></b> c				
	17	7600062			# +
	<del></del>				#
7 6. 7	18	7600050		<del>                                     </del>	
7 CAL DICKERSON	19	7/4/05/	<del>-                                     </del>	+++++	
	19	7600076		+++++	
	20	7600016	+++++	+   -	
8 DALE JEHNINGS	$ \stackrel{\sim}{=}$	10000	+++++	+++++	
DALE JEHNINGS	1-	╌┼┼┼┼╂╫┼┼	+++	+++++	
			++++		
		+			
9 CHARLIE STEPHENS	-  -				+
VINERALE SIEPNEMS	1				
				+++++	
				+++++	
O DON WILLIAMS				<del>                                     </del>	
					1 !



#### **BARBER - PRESALE R 0128515**

M-) LLUT LATEN EVAL

DESIGN-1 ALUM LATEN - 308 200 GR.

5 SHOTS - SET OPENED ONLE

SHOTS 1- STAYED SUR 081

DESIGN# 3 REG SFG

SHOT # 1 #5 SER # O'LD REG SPG 308-200 GR 10-25-52

#0 CURRENT - 050 GPENED

#5 040 - NAR, SPG,

SHOT# / - LATCH#5 - SER#O40 REG SPG STAYED 308-200GR
#2 - OLD LATCH#O SER OSO - " " OPENED
#3 - LATCH#5 SER#O40 NARROW SPG STAYED

DESIGNA- PINMED ALUM, LATEN

PROTOTUPE GUARD. (MOVED)

SER- M-7-003

(movers)

DESIGN #O OXIGIADE DMM-08

OCD LATELL 140GR.

1-SHOT OPENED #2

BARBER-PRESALE R 0128516

2.17) LEITH

2.11. Std Latch Pinned & Clipped

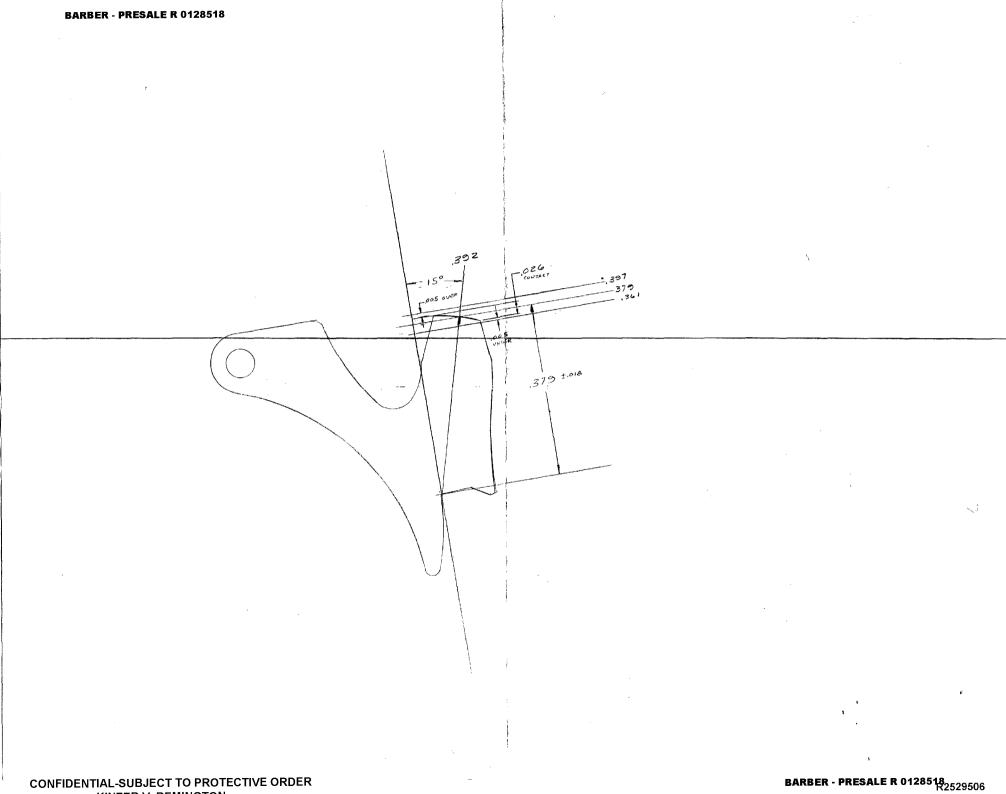
2.12. Pinned & CHAPATER & 22 Pinned & Clipped

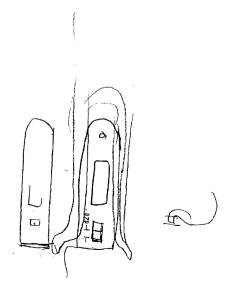
2.13. Pinned & CHAPATER & Clipped

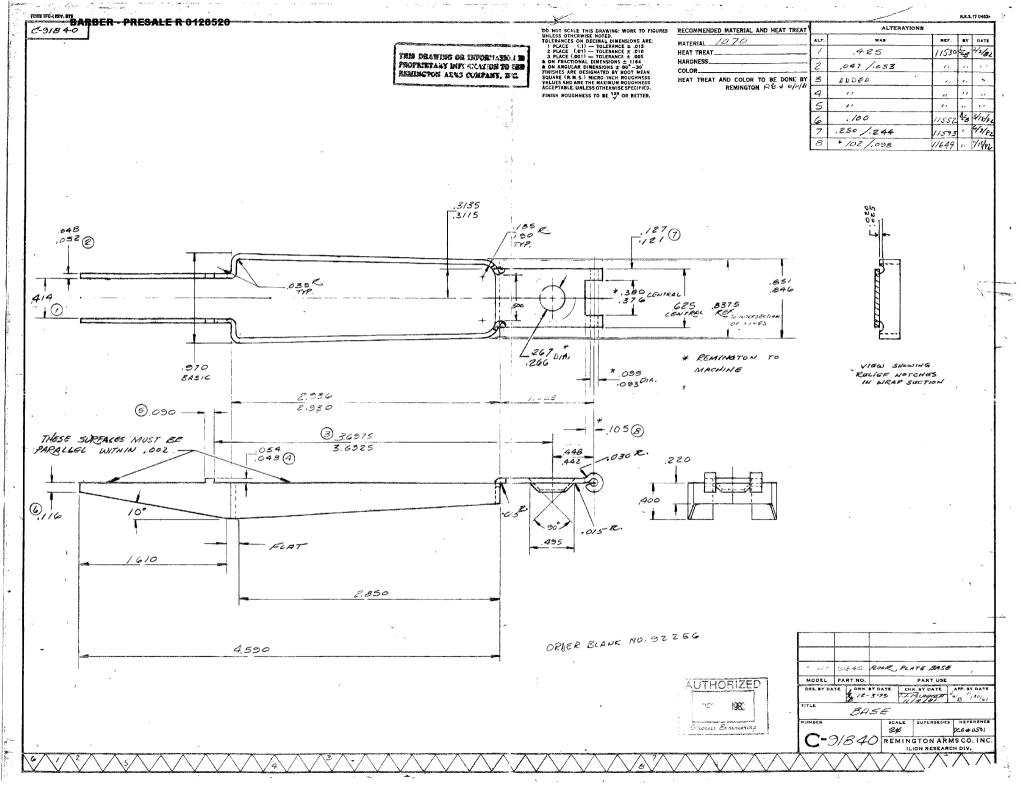
2.14. Pinned, CHAPATER & Clipped & extended square-M.

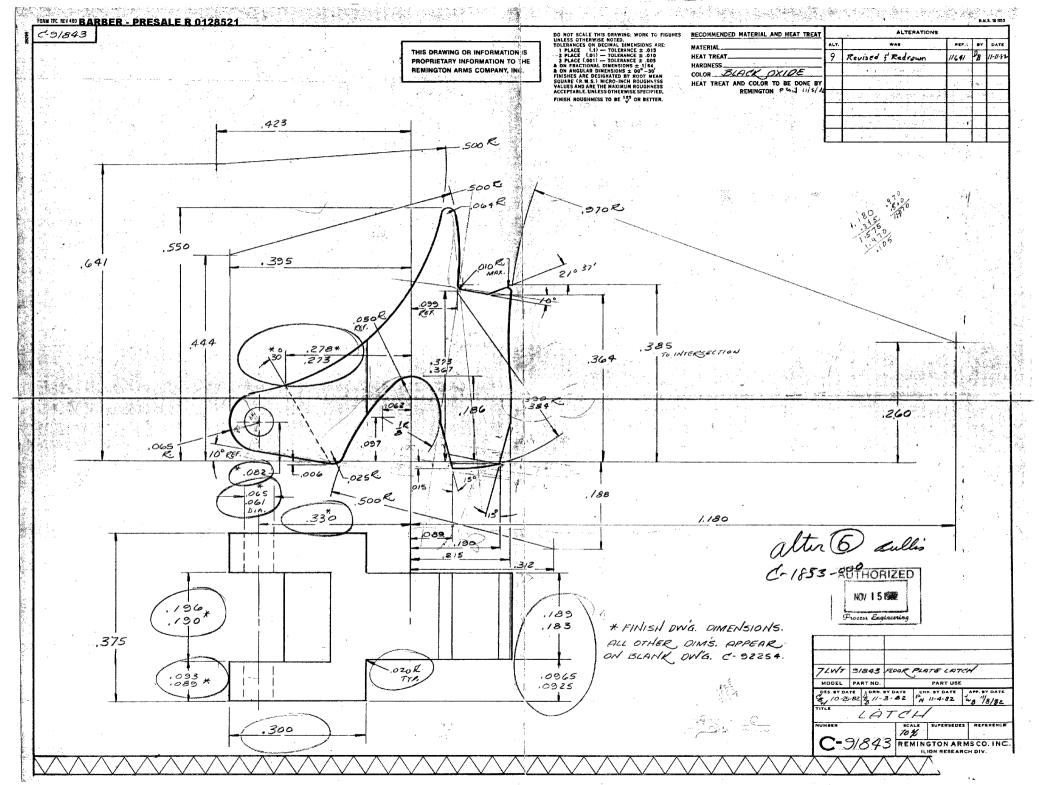
5. Pinned CHAPATER & Clipped & extended Rayle

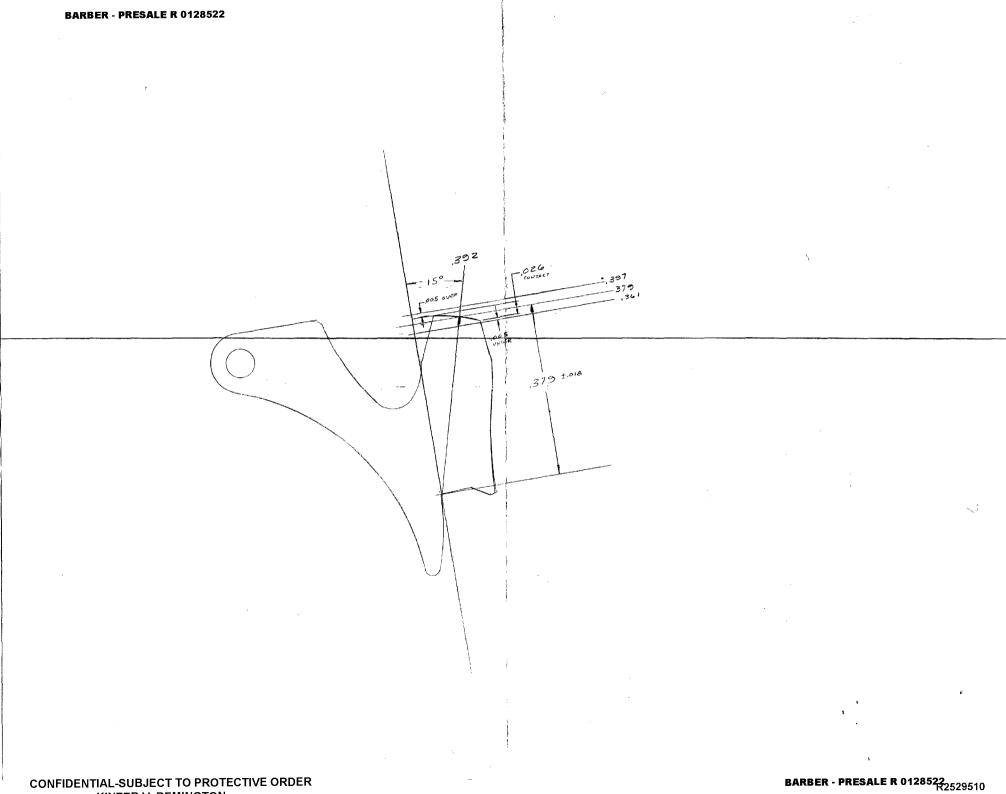
2.15. AL UMINUMA STD-PINNED.

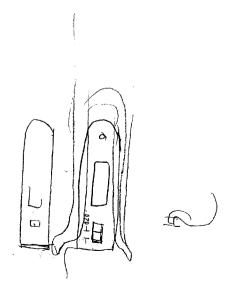


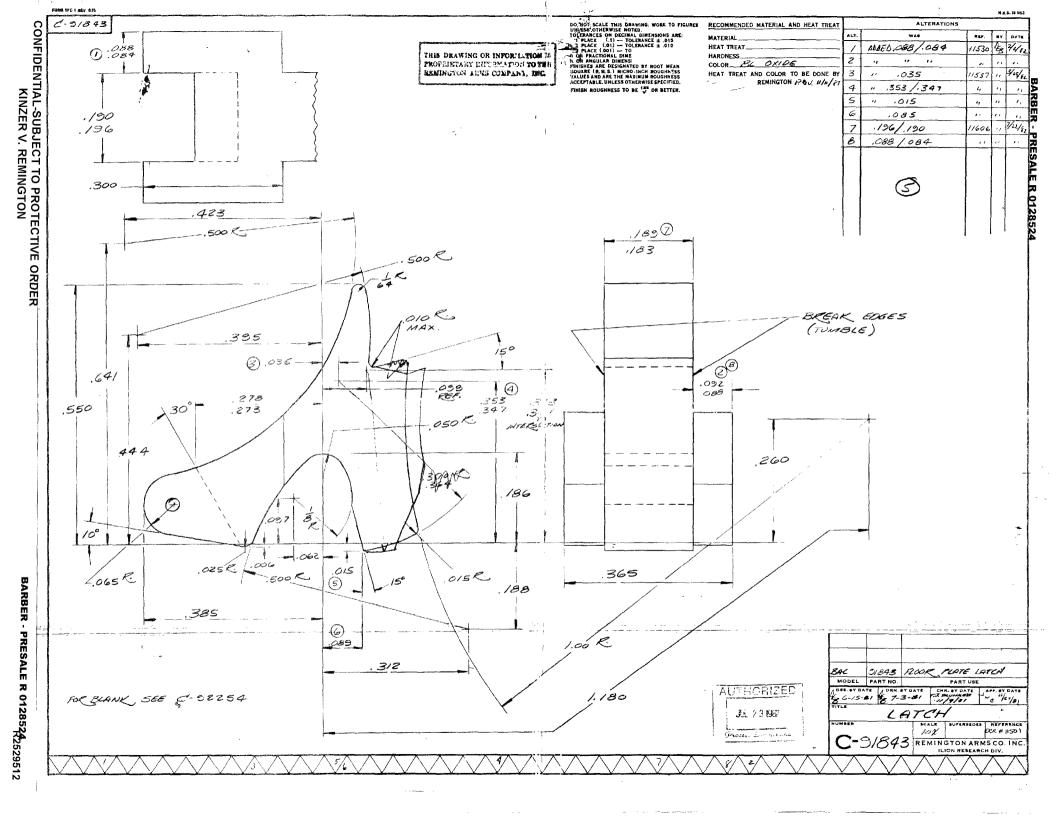


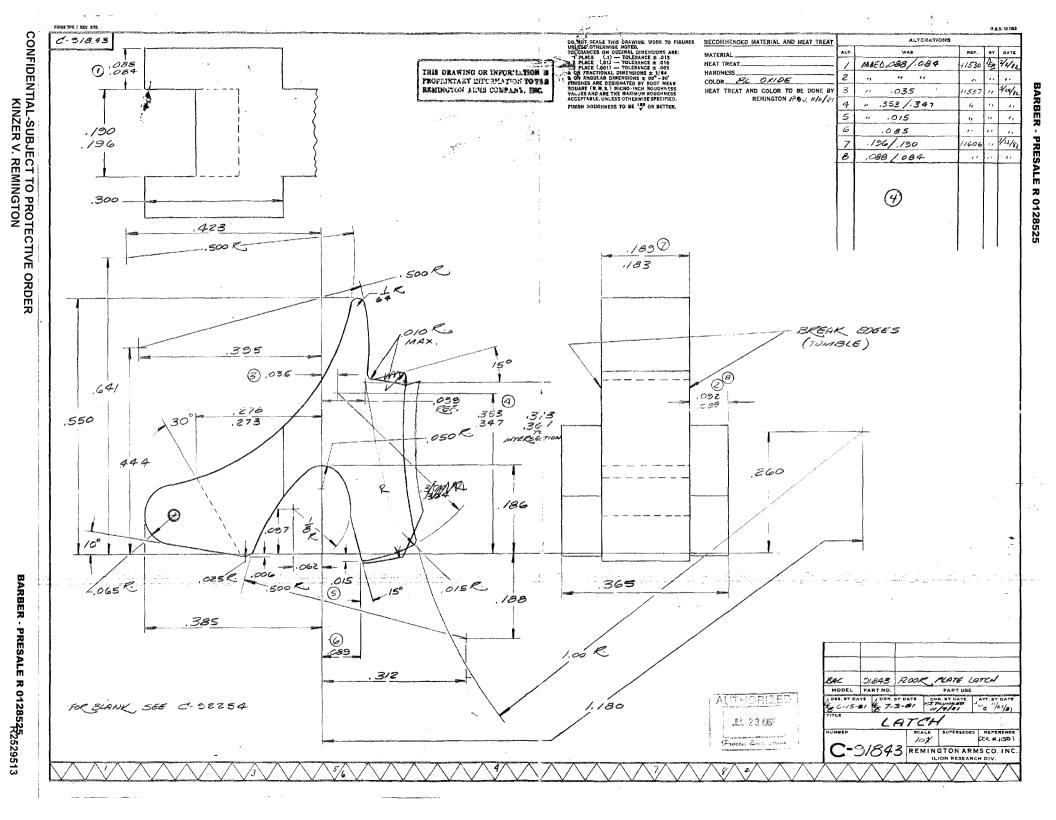


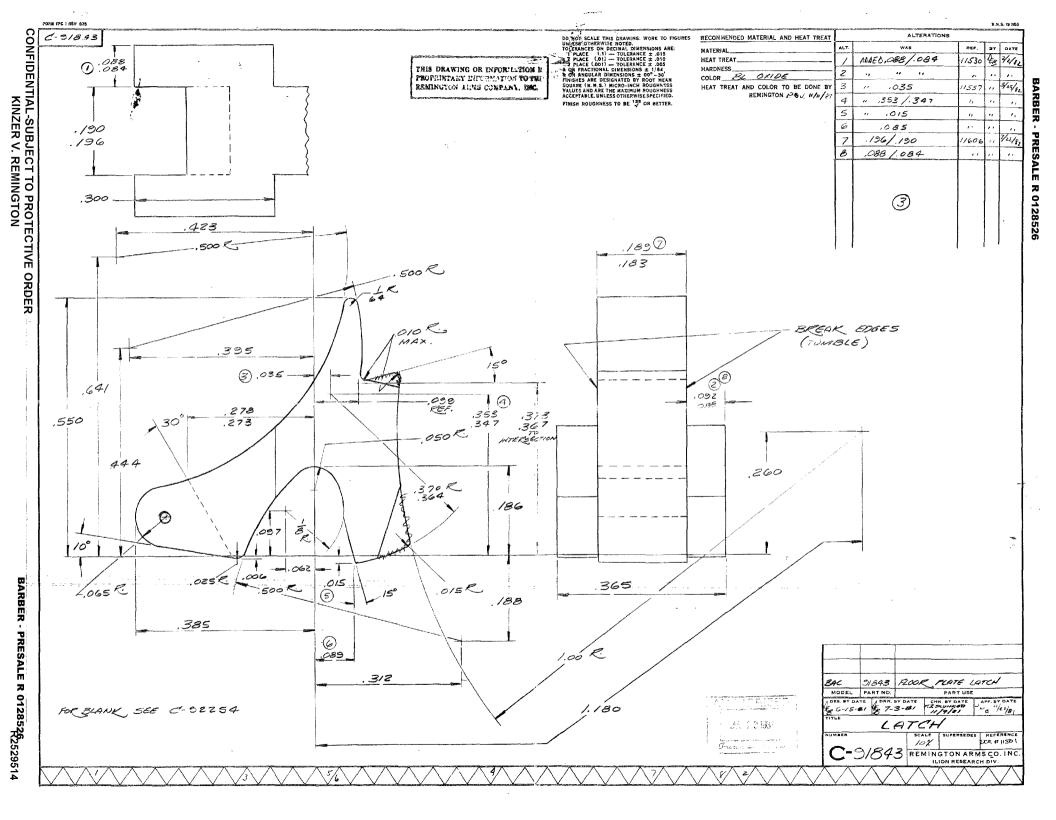


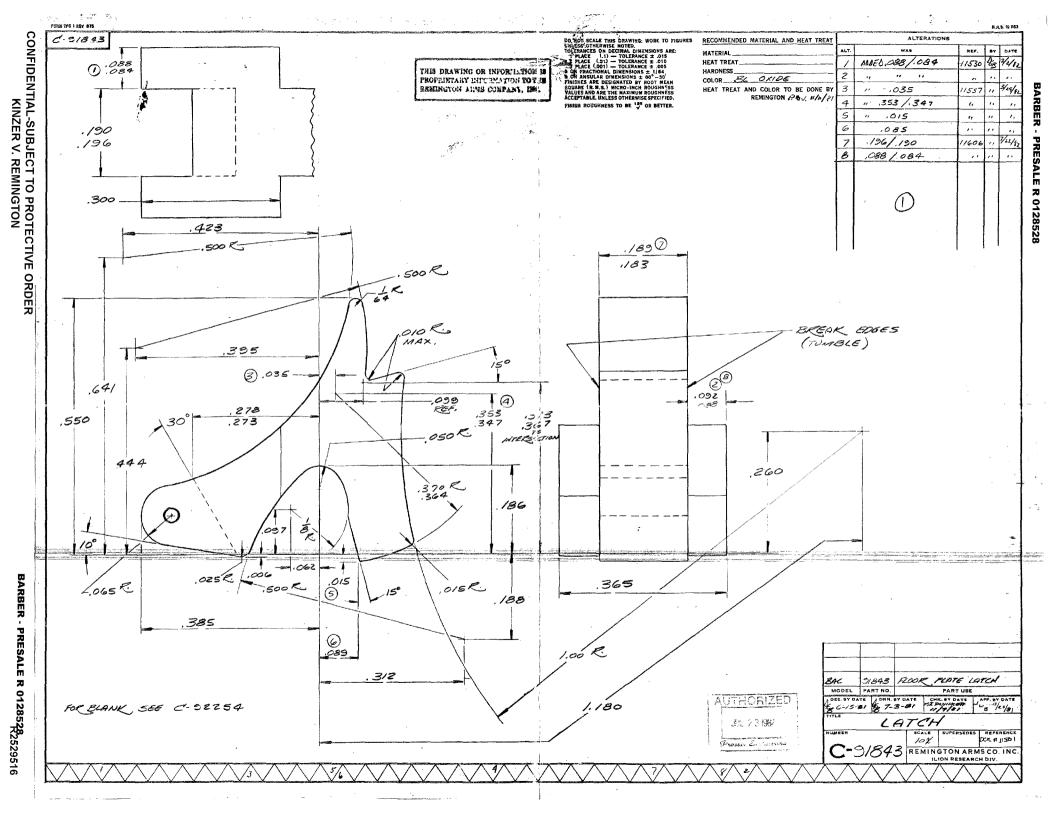












MTE:	10	-/2	-چ-	2_

MODEL: M/7 LTW GAUGE 1308 SERIAL NO. 7600008

TTL. RDS. FIRED:

**THEVIOUS** EXHIDOR

TEST TITLE: SUMMARY SHEETS PER - RIFLE - AMMO TYPE - SHOOTER

CLOUDY + COOL 54° m/7 CAL 308 FUNCTION TEST TTL. MALFUNCTIONS: "MLFUNCTIONS" MALFUNCTION DATE: BARBER - PRESATEN 0128529 HEAD SPACE MIHH,005 FLOOR PLATE ORNED FEED BTEM JUMPS MAG MALFUNCTIONS PER CIMABER DONY" BLOW BACK DON'T LOCK OFTH OVERRIDE FOLLOWER BINIDS FROM ACTION BRING UP TOA FUETO STEEL BOLE OVERRIDE LCADITION HARD STIEMS DON'T LOCK UP DON'T EXTENCE TOTAL STREET SUMMARY SHEET REPLACEMENTS ADJUSTMENTS Md. BY HEFA KAGES EG. G PIREIG SHELL Int and POWER SHELL R. HOWÉ RICER 田田田 INCH R 150 PSP RW SLOW MED. RW3 FAST OK R 180 PSP SLOW RE 5 MED RE FAST RE W 110 PSP SLOW WW 5 ok MUD 0/( MW FAST OX TOTAL (FER MAL.)



WOT 6-1856-001	~0~	0	U-1	85	6	-0	C	ζ
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# FIELD CYCLE TEST - CENTERFIRE

REPROT	NO.1	822	81	1

TAUE NO. 2

PREVIOUS	INTE: 10-12.82 MODEL: 11/7 LTW GALUE: 308	BERIAL NO. 7600008
DOUNDA	TEST TITLE: SUMMARY SHEETS PER - RIFLE - AMMO TYPE - SHOOTER	TTL. RIS. FIRED:
	m/7 CAC 308 FUNCTION TUST "MIFUNCTIONS"	TTL. MALFUNCTIONS: MALFUNCTION NATE:

SUMMRY SHEET BY		तत्त्वाड शास्त्रक		SEST.	TO ST	DON'T BLOW BACK	ock open	FR FR MA		STEMS MAG.	OVERRIDE	COCK UP	i	SI Cliv	em Mber		JUMPS MAG.	FOLLOWER BINIS	HARD 4 FILL	ERRIDE	ang up	TRACT	82	· STEE	2013	IONS PER	RATE PER ATERE
	SHOOTES	30 OE	) FIELDIG	Trais Cand Val	Den't Enser	1,500.	DOI'T LOCK		i.cii Suq		POWER (	1 T. MOC.	HIER	101	arcus.	1221	SHELL	FOLLOWE	CADING HARD	BOLT OVERRIDE	ACTION BANG UP	DOR"T EXTERACT	HEFA KAGES	ADJUSTMENTS	REPLACEMENTS	MALFUNCTIONS	MAIF. RATE
W-125 PSP																								-		 	
SLOW	CD	5																-	1			-				 	
MED	C D	5																	1			-				 	
	CD	5																	7			<u> </u>	<u> </u>	_		 	
W-150 S.TIP																						-	<b> </b>	-		 	
SLOW	03	3	04																				-	-		 	
MED	DT	5	OK																							 	
	<b>D</b> T	5	6/(																							 	
W.150 P.P.			-																							 	
	RW	5	6/(																			,					
MED	φw	5	615																			_				 	
FAST	RU	5	910																	,			_			 	
TOTAL (PER INL.)																		_				1	-	-		 	

<i>(</i> ).	10, C-783E			<u>F1</u>	ELD	CYC	CLE	TES	<u>T: -</u>	CEN	TER	FIR	<u>E</u>						R	EPRO	T NO	<u>8</u> ، .	22	28	//_	-		MUE	No	<u>3</u>
1	PREVIOUS	<b>I</b> M'	re:/	0./.	2 · s	2_			MO	Dei.:_	mt	7 27	7W	<u>,</u>		Œ	ے H <del>uci</del> e	AL !	30	8			81	er <b>i</b> a:	l no	2	60	000	18	
	nounus nu/7	TE:	3T T:	17LE 308	St	JMMA!	RY S	HEET	S PE	R - 1	RIFL	E -	AMM	o ty unct	PE -	SHO	OTE!	R		<del></del>			; !	ITL. ITL. MALF	rds Mal Unct	FUNC	red: Tion Pate	g :	NO 8	
	SUMMARY SII			ECTAINS FIRED				и	DON'T LOCK OPEN	FEE FRO MO	:D M	STEMS MAG.	POWER OVERRIDE			<b>81</b> 1			• •	R BINIS								FLOOR PARTY OPENED		
			SECOTES	10. OF	~~~	Conc Val.	ביביב בישכני	E T. MOC	יייייי ני	TV Ist	ond	냽	POWER (	יישיים ו	माद्य	TON	RICHE	इ.संट्रा	SHELL	FOLLOWE	LOADING	BOLT OV	ACTION HANG UP	CE T. MOG	BREA EAG	ADJUSTMENTS	REFLACTIVENTS	FLOOR	MALFUNCT	MALE. RATE PER
,	W-180 S SLO 14167 FAS	. T/F	RI	7	_	_	_	-						_						_			_	_	_	-		4		
	14167	2	RE D	<u>5.</u> フ			_		_				_	_		2-			·	_	_	_					_	4		
	W.200 5.			3						_				_		_			_			_					_	5		
	5604 MCD		μω μω	1			_		-					<u>.                                    </u>						 				-	-	-	-	5		
	FAST		μw	3										- ;														5		
	F150 F	J_	CB	1	ok	-		-	-						_		_						_		-					
	MED		CD CD	1	ok ok		-	-		-			-	-	-	-		-	_	-	-	-	-	-	-	-	-	-		_
	TOTAL (PER 1	nt.)																			1	1		1	7		1	1		

TOTAL (FER MAL.)

w	DT C7856 000		<u>F1</u>	ELD	CYC	CLE	TES	<u>r -</u>	CEN	'TER	FIR	E	-					R	EPRO	T NO	•1	82.	28	//	-		"Vae	NO. 4	/
1	4KEA 1003																	308	8			81	eriai	l no	<u>.                                    </u>	60	00	NO. 4	
•	nounds TE			-					Tes							OOTE	R					•	ITL. ITL. MLF	ML	FUNC	TION	31		
	SUMMARY SHEET BY		acting Freed		н				FE FR MA Int	2D		ធ			TU	em Mden		JUMPS MAG.	FOLLOWER BINDS	CADING HARD YOU	TERRIDE	erac up	TEACT	83	- Save	KENTE			F. RATE PER
		SHOOTES	6 8	FIRING	TOA PEED	DOM'T ELECT	E T. MOC	DOM'T L	10t	Sug Sug	SHELL	POWER	DON'T LOCK UP	HICH	TOS	RICHE		TIEES	FOLLOW	i reading	o ETOE	ACCION	DON'T EXTRACT	DES ESTE	ADJUSTMENTS	REFLACTMENTS	FLOOR PLATE	MALFUNCTIONS	MALE RATE PER
•	F 180 PSP SLOW	NT	_	ok		-	-	-	_			-		-	_	-	_	_	_	<u> </u>				_	_	_			
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	FAST	DJ	3			-	-	-				-	-		_		_		_	1		_	_		-	_	1		
,	F 165 PREMBT. SLOW	RW	5	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	<del> -</del>	_	-	_	-	-	-	5		
	· MED	RW	5									_							<u> </u>	1							5		
	FAST	RW	5	-	-	-	-	-	-	-		-	-	-	-	-				-		_	-	-	-	-	5		
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NOOMES I	rayr. T	LLLG	- N	UIWKL	mi n	)11 <u>66</u> 1	10 F	rin -	KIL	<u>//</u> LE -	? <u>/</u>	7 C	V YPE	<b>a</b> - sh	AUJE OOTE	R		30	8	• .		TIL.	RDG	. FI	IRED:	'	e no 20 3	BAKDE
m/7 e	AL	30	8	Fer	1677	04-	Tes	-ر ٬		•11	#IM!	UNUI	rions	, ii								ITL. MLF	MAI Unct	FUNC 'ION	TION PATE	9:		
HEAD SPACE MIN +.004  SUMMARY SHEET		يعكنا كليتمح		Sream	302	OW BACK	ट्रा व्यव्या		EED ROM	STEWS MAG.	OVERRIDE	品		ST. CIM	em Mber		JUMPS MAG.	BINDS		RRIDE	20 22	BACT		ž	1	we Opener	ONS PER	MALE, RATE PER
R. HOWE	SECOTOR	NO. OF 2	718176	TOA ZEETS	DOMLE ELECT	DON'T BLOW BACK	DON'T LOCK OPEN	181		TELL	POWER OF		TITES	ICM	RIGGE		अस्या उठ	FOLLOWER BINDS	LOADING	BOLT OVERRIDE	ACTOR BARG UP	DON'T STEERCE	BEEN KACES	ADJUSTMENTS	replacemen	FLOUR PLATE	MALFUNCTIC	MALF. RATE
R150 PSP	-																						===	=				-=
SLOW	RE	3		'										214														
	R-													Ŋ														
	PE-	5	010		_																							
R180 PSP																												
SLOW	HW	5		<b> </b> '																						5		
MED	μw	-					'											·								5		
FAST	Hω	5																								5		
W 110 PSF	1!											<u> </u>																
SLOW	CD	5	ox																			1						
MED	CD	3	015																	,								
FAST	CD	5	UK	<b>!</b> '																,								
TOTAL (PER MAL.)																	<b> </b>			-	<del> </del>	<del> </del>	<del> </del>	-		<del> </del>		<b> </b>

<i>56-0</i> 00	_				
_	FIELD	CACLE	TEST	_	CENTERFIRE

REPROT NO. 1 822811

PAUE NO. 2

INTE: 10-12.82

MODEL: M/7 LTW

108 BUNE -308

BERIAL NO. 7600003

PREVIOUS ROUNDS

TEST TITLE: SUMMARY SHEETS PER - RIFLE - AMMO TYPE - SHOOTER

TTL. RDS. FIRED:
TTL. MALFUNCTIONS:
MALFUNCTION RATE:

M/7 CAL 308 FUNCTION TUST "MITUNITIONS"

SUMMRY SHEET BY		ACUNDS PTREED			Seeming Control	and a	ILON BACK	Lock open	1	ed om G.	STEMS MAG.	OVERRIDE	LOCK UP		CIIV	em Mben	<b>!</b>	JUMPS MAG.	er binds		KRRIDE	क्रमंद पार	TEACT	ស្ន	. 223	SIME	LATE UPRAVED	IONS PER	TE PER	RESILE R DIVING
~ 4 4 6 6 6 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1	SECOTES	TO. OF	בובוצ	Clade Vol.	DCE TECH	NOTE T. SECS	DOIL I	•	i.Cii Suq		POWER	DOM'T L	HIER	LOW	अस्टब्स	1.02.1	SHELL	FOLLOWER	LOADING	BOLT OVERRIDE	ACCITON HANG UP	DOR'T EXTRACT	BREAKACES	ADJUSTMENTS	REPLACEMENTS	FLUOR PLATE	MALFUNCTIONS	MALF. RATE		
W-125 PSP																						===							1	
SLOW	DJ	5	015																										1	
MED	07	5	ok																					_				-	1	
	DJ	5	٥K																									<del> </del>	ľ	
W-150 S.TIP																	<u> </u>	-		-	<b> </b>	<b> </b>	-					<del>                                     </del>		
SLOW	RU	5																				_	<u> </u>	<del> </del>	-	<u> </u>			1	
MED	RV.	5															_	·				_	-			2			1	
FAST	ęν	5	OK								7													_					1	
W-150 P.P.										,												_	-					<u> </u>	l	
SLOW	RL	5												2/2						-		Ī ,	-						İ	
MED	Pt	5									<u> </u>			$\sqrt{3}$																
FAST	<b>?</b> Ŀ	б												11						7										
TOIML (FER IML.)																		-	-	-	-	<u> </u>	-		-					

<b>(</b> ~	10, 6,7836		<u>F.II</u>	ELD	CYC	CLE	TES	T' -	CEN	TER	FIR	E						R	EPRO	T NO	1.1.8	2	28	<u>//</u> _		-	ACE	NO	<u>3</u>
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]	NOUNDS TE	3 <b>T T</b> ]	TLE (	SU	IMMAI	RY S	HEET	S PE	er -	RIFI	<u>.e -</u>	АММ	YI O	PE -	SHO	OTE	R					7	ITL.	rio Mal	. FII	red: Fion	31	110	
•	no/7 cu	<u>ت</u> ک	308	<i></i>	-UM	1677	0/1	16	ふて	-, 	• • • • • • • • • • • • • • • • • • • •	WIF	UNCT	TONB,	···		1		<del></del> -		·	, 	MATER	UNCT	ION	INTE	·	<del></del>	
Summary Sheet			ECTAINS FIRED		Trees.	DOM'T ELECT	ICH BACK	DOR'T LOCK OPER	FE: FR: NA		STEMS MAG.	POWER OVERRIDE	व्या क		ST CIM	em Mber		JUMPS MAG.	FOLLOWER BINES	CADIDG	VERR TDE	HANG UP	TERACT	X	- STE	(ENTE	FLOURPHIE OPENED	IIONS PER	. RATE PER
	BY	SECOLES	NO. CF	FIRTRE	TEN PUED STEELE	E T. MOG	E TOTAL	DOM'T L	I _B (	rcli Sug		POWER (	DOM'T LOCK UP	HIGH	TCM.	RICER		TIZES	FOLLOW	LOADITE	DOIN O	יכבומו	T. NOOT	BREAKIC	ADJUSTMENTS	BEFLACTMENTS	FLOOR	MALFUNCTIONS	MALE RATE PER
	W-180 S.TIF	£																											
•	SLOW	3	5					_				_															5		
	MED	4	<u>3</u> .			_		_				_						<u></u>					_	_	_	_	3		
ì	FAST	μW	5				_	_	<u> </u>	_									_	<u>                                      </u>			_	_	_		5		
	W.200 5.71P					_	_	<u> </u>				_	_	_					_	_		_	_	_	_	_			
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	F 150 PSP SLOW		_		_	_	_				_	-	_	_		-			_	-	.		-	<u> </u>	-	-			_
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	FAST	DJ	15	OK	1_		_				_			_	_		<u> </u>		_		_		_	_			_		
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TOTAL (PER MAL.)

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		DA:	re: <u>/</u>	0-1	2-	S 2		•	MOI	der:	<u> </u>		7	<u>~</u>		<u> 11</u>	CAL	30	8			B	eria	l no	•	760	2 200	) 103	
1	PREVIOUS ROUNDS									R -												•	TTL.	RIS	. FI	RED:		<del></del>	
		m/7	CAC	30	18	Ti	IHC	7/0	. الم	143	<b>-</b>	**1	Mif	INCT	ions	ri										tions inte			
[		<del></del> _	— <u>ʻ</u> i				,. 				<u></u>						<del></del>						<u> </u>						i
	SUMMARY			तटाकाठ हरायका		Serve	TOE!	DON'T BLOW BACK	LCCX OPER	FEI FRO MAG	М	STEMS MAG.	OVERRIDE	TOCK UP		CIM	em Mder	JUMPS MAG.	FOLLOWER BINDS		ZRRIDE	अजद वह	TEACT	N	. S.T.S	ENTS	FLOURPLATE GRENED	MALFUNCTIONS PER	rate per
	B	Y	SHCOTER	TO OF	FIRING	THE SEELS	DOM " EJECT	E T. NOC	DOINT IA	Iot		SHELLS	POWER (		ETICES	LON	ancer	SHELL	FOLLOWE	LCADING	BOLT OVERRIDE	ACCION BANG UP	DOR'T EXTENCE	महास्त्रात	ADJUSTMENTS	BEPLACEMENTS	FromR	MALFUNCI	MALE BY
,	F 180	PSP																											
٠,	520	w	RW	5							-																5		
	ME		PW	,																							3		
	FA	57	RM																								5		
	F 165	PREMBT.																											
	320		RE	3										•													3		
	· ME	わ	RÉ	5															<u> </u>								4		
	FA	ST	RÉ	5																							5		
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FAST

TOTAL (PER MAL.)

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Enotabl	DAT	ee: _	10-,	12-	82	_		140	DEL:	m	//	2 _	T	. <i>J</i>	4	<del>MUN</del>	n_	د .	30	8		8	er <b>i</b>	IL NO	` }•`	<u>76</u>	5) 00	е но 040	) - }
ROUNDE	TE	T T	itle	si si	UMMA	RY S	HEET	rs Pi	ER -	RIF	LE -	ΛM	10 T	YPE	- SH	OOTE	R	******************************			•		TTL.	RDS	. FI	med:	'		Ū
m/		ac _	30	8	FUN	10771	0/+ -	TES	<b>-</b> -ر		11	<u>MIT</u>	UNCI	rions	Į'i							1	TTL. MLF	Mal Unct	Func Ion	Tion Pate	B1		
NEAD SPACE MINT, 004			Freeza				М	ta	FE	ed	MAG.	ы				rem Imber	·	MAG.		THRD.							OPENED	M	JACE 7
Summary Sil		pi	301115		D SERVE	S. S. S. S.	DON'T SECN SACT	CCCX OFFE	FRO		STEEMS M	OVERRIDE	LOCK GR		1	1	1	JUMPS N	FOLLOWER BINDS	COADING HARD YTH	BOLT OVERRIDE	ELECT UP	TEACT	M	5	Signal Signal	1 1		ATE PER
P. NOWE		SECCEES	MO. OF	FIRES	TOA POET	DOM'T	1.000	DON'T LOCK	1 1	icii Sug	SHELL	POWER	ы	HIGH	ICH ICH	Ricer	Term	SHELL	POLLOW	LOADING	BOLT OF	ACTION BRING UP	DON'T EXTERACT	BREAKAGES	ADJUSTMERTS	restacsments	FLOOR PLATE	MALFUNCTIONS	MALF. RATE
R 150 P	SP	*															-											-=	-==-
SLou		10		OK											_			-					_		-				
MED		HW	5															-									7		-
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## FIELD CYCLE TEST - CENTERFIRE

TIBBO CICHE IE	SI - CENTERFIRE	REPROT NO. :	18 NO. 2
IMTE: 10-12-82	MODEL: M/7 LTW	HALLIES 308	BERIAL NO. 2600040.

PREVIOUS
ROUNDS TEST TITLE: SUMMARY SHEETS PER - RIFLE - AMMO TYPE - SHOOTER

TEST TITLE: SUMMARY SHEETS PER - RIFLE - AMMO TYPE - SHOOTER

TIL. RDS. FIRED:

TIL. MALFUNCTIONS:

MALFUNCTIONS:

MALFUNCTION RATE:

SUMMARY SHEET BY	pt	RCUNDS FIRED		D SEETL	aract.	DON'T SCOW BACK	LOCK OPER	]	ed om g.	STEWS MAG.	OVERRIDE	LOCK UP	,	GIIV	em Mden		JUMPS MAG.	FOLLOWER BINES	contro Unro 4th RO	BOLT OVERRIDE	EAST; UP	CERACE	N	, STE	EWE	MIE-O PENED	IONS PER	RATE PER
	SECOLES	NO. OF	FIELD	Case You	DOTE TING	1,100	T. 1000	1	CII 5ng		POWER	DOM'T I	मात्रम	TON	अस्टिं	1.0221	SHELL	FOLLOW	LOADING	BOLT O	ACTION BANG UP	DON'T EXTENCT	BRES KACES	ADJUSTMENTS	REFFACEMENTS	FWOR PLATE.O	MALFUNCTIONS	MALF RATE
W-125 PSP																				===		===	-					====
	RW	5	ΟĶ															-				-	-	-				
MED	RW	5	ok																			-						
	RW	5	٥K																			<u> </u>		-				
W-150 S.TIP																						-	-	<del> </del>		-		
- SLOW	RE	5	015													****							_	-				
MED	RÉ	5											N	-				-					-					
FAST	re	5									<i>,</i>								T									
W.150 P.P.										,											_							
<u>560W</u>	μω	0/5																				1						
MED	μW									-										*						1		
FAST	HW	ok																		*						-4		
TOTAL (FER MIL.)																						<del> </del>	-	-				

W	0" C-1856-0	50	<u>F1</u>	ELD	CY	CLE	TES	T: -	CE	NTER	FIR	E	-	•				n	EPRO	yr no	٤.١	82	28	//			. 1	e no	3_
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WO#C-185	FIELD CYCLE TEST - CENTERFIRE	REPROT NO.1 \$228	11
PREVIOUS		GATGET 308 BERIAL	L NO. 7600/0/
ROUNDS	m/7 CAL 308 FUNCTION TOST "MILTURCTIONS"		RDS. FIRED: MALFUNCTIONS: MCTION RATE:

PREVIOUS	-			-	NDS TEST TITLE: SUMMARY SHEETS PER - RIFLE - AMMO TYPE - SHOOTER															•	8	erla	L NC	·	60	0/	0/	
	nds test title: summary sheets per - rifle - ammo type - shooter  m/7 cal 308 Function Test "malfunctions"																		TTL. TTL. MLF	ML	FUNC	TION	91					
SHOOTER  THEATH AND WILL STEAM MAG.  FOLLOWER BIXING  TOADING   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I'NG   I																RATE PER												
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ı	nounus — m/z c	TEST 1	TILE	I S	<b>MMN</b>	RY S	HEET	S PI	er -	RIF	LE -	AM	10 T	PE ·	- SH	OOTE	R					,	itl. Itl. Mlf	rds Mal Unct	. Fi Func Ion	red: Tion Rate	8:		
	SUMMARY SHEET BY R, Howe		SCHAIRS FTAEDS		D SEETLE	Z. Z. Z. Z. Z. Z. Z. Z. Z. Z. Z. Z. Z. Z	DON'T BLOW BACK	CCX OPER	PE PII NA	ED OM G. 2nd	STEMS MAG.	OVERRIDE	an xoo			em Mben		SHELL JUMPS MAG.	er benes	CADITIE HARD YTH	VERRIDE						FLO OR PLANT OPENETS		NEOME
	R, HOWE	SECOLE	30. G	PERMIT	TOA PROF	T. MOC.	14. MOC	DOM'T 1	Inf	rcii Suq	SHELL	POWER	I II. NOC	田田	E 23	THE	10021	SHELL	FOLLOW	LOADING	BOLT O	ACTION )	T.MOC	ज्ञास्त्र स्थाय	ADJUSTMENTS .	REPLACEMENTS	Troon	MALFUNCI	MALF. RATE PER
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SUMMARY SHEET BY	-	acums Freed		SPETT.	TECT	DOE"T BLOW BACK	DON'T LOCK OPEN	FE FR MA	OM	STEMS MAG.	POWER OVERRIDE	क्टा क		CIN	em Mden		JUMPS MAG.	FOLLOWER BINDS	MARD YES	ERRIDE	क्रमद पष्ट	TEACT	n	) SEE	STATES	FLUOR PLANTE CAUNION	MALFUNCTIONS PER	TE PER
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m/7	eac.	30	8	Fer	1077	OH -	TES			•	WIT	UNC	LONS	·i								TTL. Malf	MAI. Unci	Func Ion	TION RATE	B:		
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				FIELD	CYCLE	TEST	-	CENTERFIRE

REPROT NO.1 822811

7 No. 2

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MODEL: M/7 LTW

MUSE 308

BERIAL NO. 7600036

EUCLVING BUNDON

TEST TITLE: SUMMARY SHEETS PER - RIFLE - AMMO TYPE - SHOOTER

TTL. RIS. FIRED: TTL. MALFUNCTIONS: MALFUNCTION RATE:

M/7 CAL 308 FUNCTION TOST "MIFUNCTIONS"

SUMMARY SHEET BY	<b>tri</b>	actures present		TELES CHARTE	STECT	HOW BACK	LOCK OPEN		ed om	STEMS MAG.	OVERRIDE	LOCK UP	ł	cin el	em Mder		JUMPS MAG.	FOLLOWER BINIS	HARD 47.5	BOLT OVERRIDE	अपट क	TEACT	N	- SIE	STAIG	KIOR PLATE OPENED	TONS PER	RATE PER
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TOTAL (FER ML.)																												

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	mounts	TEST	7171 30	E:_S	UMM Fu	IRY S	7 <i>07</i> 7	rs pr	ER - ・ ・ ジブ	RIFI	E -	AMM MLE	o Ty unct	PE -	- SH(	OOTE	R					1	ITL. ITL. MALF	rds Mal Unct	. Fi Func Ion	red: Tion rate	8:	NO ) )36	
	summary shee by R. Nowé	T	RECEIPTS FIREDS		STEEL.	1355	DON'T BICH BACK	DEST TOOK OFTE	V41	om a.	STEMS MAG.	POWER OVERRIDE	an xoo		CIV	em Mber		JUMPS MAG.	FOLLOWER BINDS	COADIED HARD 4713	Verride	स्त्राट पर	ZTEACT	X	- Santa	VENITS.	LINTE OPENIED		F. RATE PER
	R. Howe	SHCOFF	<b>B</b>	FTATING	Trans Cand Vom	DON'T ZIECT	7000	1 T. 1202	Iv	i.Cli Suq	SHELL	POWER	DOM'T LOCK UP	EEEE	<b>1</b> 53	recue !		TIMES	FOLLOW	בינמאסים !	BOLT O	ACCION	DOM'T E	BEEARAG	ADJUSTMENTS	REPLACTIVEMENS	FLUCK PLATE	MALFUNC	MALF. RATE PER
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REPROT NO.: 82281/	REPROT	NO.1	822	811	/
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	m/7									-				TONS		<del> •</del>	<del></del>					•	TTL.	ML	Func:	TION	B :		
Ţ,	HEAD SPACE MINT, OOY		FIRED						FE	ED					BT	em Mber		AG.	Ø	W.W.							PENERS	YER	PRESALE
	SUMMARY SHEET BY		30.1313		THE PERD SERVE	Z.ECE	DON'T SICH SACK	EO X307	FR:	ecii	STEMS MAG.	OVERRIDE	1.00.3 (II)		<u> </u>			JUMPS MAG.	FOLLOWER BINDS	CADDE HARD L	VERRIDE	ACTION BANG UP	DOR'T EXTERACT	X.	AERTS .	STANGE	FLOUR PLATE OPENED	MALFUNCTIONS PER	MALE, RATE PER
	R. Howe		8 8	DE LE	TOO POOL	DOM'T ZIECT	1.500	T.MOG	I _B t	Sug	SHELL	POWER	DOM.T	HIER	101	अस्टास	1221	TIMES	FOLLOW	LOADIN	BOLT (	ACCTOR	TOTE .	PER EN	ADJUSTMENTS .	REPLACEMENTS	From	MALETUNG	MALE.
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REPROT NU.1 822811

PAIT NO. 2

INTE: 10-12.82

MODEL: M/7 LTW

CAL 308

BERIAL NO. 2600/03

PREVIOUS ROUNDS

TEST TITLE: SUMMARY SHEETS PER - RIFLE - AMMO TYPE - SHOOTER

TTL. RDS. FIRED: RESTRICTIONS: RESTRICTION RATE:

M/7 CAL 308 FUNCTION TUST "MITUNICTIONS"

SUMMARY SHEET BY	بتحج	व्ह बटाकाड रामध्य	316	गामना प्रमान क्ष	ರಿಯ್ ಪಾರದ	DON'T SLOW BACK	ಎಂಬ್ ಒಂಯ ರಾವಾ	FEI FRO MAC	MC	II STEMS MAG.	POWER OVERRIDE	T LOCK UP		ST Clia	MDER		LL JUMPS WAG.	FOLLOWER BINDS	THE MARD YELL	BOLT OVERRIDE	ACTION HANG UP	DON'T ETTRACT	Here there s	ADJUSTMENTS .	Rever A Compined	FLOOR PLATE UP ENERS	MALFUNCTIONS PER	PRESALE RO128562
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TOTAL (PER MAL.)

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MTE: 10-19-82	INTE:	10	-19	-82
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MODEL: 7 LWT. CAL: 7mm-08

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PREVIOUS ROUNDS

TOTAL (PER ML.)

TEST TITLE: SUMMARY SHEETS PER - RIFLE - AMMO TYPE - SHOOTER

TTL. RDS. FIRED: TIL. MALFUNCTIONS! MALFUNCTION NATE:

M/7 LWT 7MM-08 FUNCTION TEST "MITUNCTIONS" BARBER - PRESALER 0438 69 RET FEED STEME MAG. BTEM JUMPS MAG. EMPTY SHELL OTTEN DOR'T LOCK OFFER CHAMBER OVERRIDE BIMIS FROM BOLT OVERRIDE B TEA PERCO SEELL B DON'T EXTERACT MALFUNCTIONS DON'T EXECT 2001 ACTION BANG REFLACEMENTS SUMMARY SHEET ADJUSTMENTS Md. BREAKAGES POLLOWER BY NO. OF ZIETZ LOADERS SHELL POWER R. HOWE SHELL 18t 2nd 11.100 H IVICH R 140 PSP SLOW ok 5 MED OK FAST OK 540W RE ox 5 MED 5 Rť FAST RE 5 OK SLOW OK HM 5 MED 5 ok FAST μW OK



FIELD	CYCLE	TEST -	- CENTI	ERFIRE
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PAUE NO. 2

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MODEL 7 LWT.

CAL: 7mm-08

BERIAL NO. 76 00098

ROUNDS PREVIOUS

TEST TITLE: SUMMARY SHEETS PER - RIFLE - AMMO TYPE - SHOOTER

TTL. RDS. FIRRD:
TTL. MALFUNCTIONS:
MALFUNCTION RATE:

M/7 LWT 7mm-08	FUNCTION TEST	"MIFUNCTIONS"
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SUMMARY SHEET BY		Remark Freeza		SERTE	and Co.	EMPTY SHELL OTTHES RET		1	ed om	STEMS MAG.	OVERRIDE	इंटिस सु		cin	em Mden		JUNES MAG.	R BINDS		OVERRIDE	स्त्रह क	TEACT	ช	·	200	FLOOR PLATE OPENED	IONS PER	PRESALE B. 0128570 W
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REPRUT NO.1 8228//

PAGE NO. 3

MTE:	10	-19	-82
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MODEL 7 LWT.

CAL: 7mm-08

BERIAL NO. 7600098

PREVIOUS ROUNDS

TEST TITLE: SUMMARY SHEETS PER - RIFLE - AMMO TYPE - SHOOTER

TTL. RDS. FIRED: TTL. MALFUNCTIONS: MALFUNCTION NATE:

M/7 LWT. 7MM-08 FUNCTION TEST "MILTURETIONS"

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PAGE NO. 4/

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MODELL 7 LWT.

CAL: 7mm-08

BERIAL NO. 7600095

PREVIOUS

TEST TITLE: SUMMARY SHEETS PER - RIFLE - AMMO TYPE - SHOOTER

TTL. RDS. FIRED:

TTL. MALFUNCTION FATE:

m/7 1	WT. 71	mm-08	FUNC	TION TE	~ " <u>M</u> I	<b>FUNCT</b>	TONS 4
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SUMMARY SHEET BY		SCHOOL PIECES		Trans.		EMPTY SHELL OTTHES RED	OCX OPEN		ed om	STEMS MAG.	OVERRIDE	LOCK UP		CIN	em Moen	JUMPS MAG.	R BINDS		द्राहर ग्राज्य	and the	TEACT	Ø		21715	PLATE OPENED	IONS PER	PRESALE B 0128572 1154
R. Howe	SHOOKS	8 8	F	THE CHARTEN	DOM'T ZIZZ	EMPTY	מבידים ני		end evil					<b>801</b>	Name of	SHELL	FOLLOWER	LOADING	BOLT OVERRIDE	ACTION HANG	DOE'T STEER OF	HEEN TAKES	ADJUSTEMENTS	Signed Action	FLOOR P.	MALFUNCTIONS	\$573.TW
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INTR: 10-19-82

MODEL! 7 LWT.

CAL: 7mm-08

BERIAL NO. 76000/0

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TEST TITLE: SUMMARY SHEETS PER - RIFLE - AMMO TYPE - SHOOTER

TTL. RDS. FIRED:
TTL. MALFUNCTIONS:
MALFUNCTION RATE:

M/7 LWT. 7MM-08	FUNCTION TEST	"MLFUNCTIONS"
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CAL. 7mm-08 BERIAL

(2)
BERIAL NO. 7600010

**PREVIOUS** ROUNDS

TEST TITLE: SUMMARY SHEETS PER - RIFLE - AMMO TYPE - SHOOTER

TTL. RDG. FIRED: TTL. MALFUNCTIONS: MALFUNCTION RATE:

M/7 LWT. 7MM-08	FUNCTION TEST	"MLFUNCTIONS"
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MODEL! 7 LWT.

CAL: 7mm-08

BERIAL NO. 7600010

PUEATORS

TEST TITLE: SUMMARY SHEETS PER - RIFLE - AMMO TYPE - SHOOTER

TTL. RDS. FIRED:
TTL. MALFUNCTIONS;
MALFUNCTION NATE:

M/7 LWT. 7MM-08	FUNCTION TEST	"MALFUNCTIONS"
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	BY R. Howe	SECORES	8	FIELDIE	TO FEET PARTY	200	EMPTY	DON'T LOCK	1	t <b>Cii</b>		POWER (	Taring I	H	101		1	SHELL	FOLLOWER	COADURG	BOLK OV	ACCION B	DOR'T STUBACT	SECTOR SECTION	ADJUSTMENTS	REFEACTMENTS	FLOOR P.	MALFUNCTIONS	8575 ₂₁₈₀
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nounds	TEST TITLE: SUMMARY SHEETS	PER - RIFLE - AMMO TYPE	- SHOOTER	TTL, Ri

M/7 LWT. 7MM-08 FUNCTION TEST "MIFURCTIONS"

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TTL. MALFUNCTIONS:

MALFUNCTION NATE:

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SUMMARY SHEET		acums Fraen		SEEL	ETECT	HELL OTTHES RED	Fred	FE FR	140	STEMS MAG.	POWER OVERRIDE	an XX		chv	em Mden	1	JUMPS MAG.	POLICOVER BINDS		OVERRIDE	electric de	TEACT	8	2	2000	FLOOR PLATE OPENED	IONS PER	PRESALE R 0128576
BY R. Howe	ESTOCES	10. G	STATIST.	Canal Ven	2011 E	EMPTY SHELL	DON'T LOCK		end reli		POWER (	DON'T LOCK UP	開	103	RICER	1	SHELL J	POLLOWE	LOADING	BOLL OV	ACCULAGE B	DOR'T EXTRACT	BEEN CAGES	ADJUSTMENTS	Pres Actor Grans	FLOOR P	MALFUNCTIONS	9576 119
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SUMMARY SHEET BY	-1	ACTED NO.			T. C.	HELL (	Ä	MV		STEEDES	OVERR	25 EB			 JUMPS	B BIN		OVERRID	באבי ת	Take:	n	2	STATE	अगर (	IOMS	B.O 法
R. Howe	SHOOTES		STEELS.	TA ZEELD	Serie 2	EMPTYSHELL	T T. MOO	<b>!</b> '	ecii Suq		POWER O	א ביישכנ	103	RICER	SHELL J	FOLLOWER	LOADING	BOLL OV	ACTOR SANG U	DON'T EXTERACT	इस्टाइ इस्टास	ADJUSTMENTS	PROTACTIVERS	FLOOR PLATE	MALFUNCTIONS	Ba 128577 21 W
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MODEL: 7 LWT.

CAL: 7mm-08

BERIAL NO. 26 000 94

PREVIOUS

TEST TITLE: SUMMARY SHEETS PER - RIFLE - AMMO TYPE - SHOOTER

TTL. RDS. FIRED:

TTL. MALFUNCTIONS:

MALFUNCTION NATE:

M/7 LWT 7MM-08	FUNCTION TEST	"MLFUNCTIONS"
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SUMMARY SIEET BY		SCHOOL FLEED		Septe	ಪಾರ್ವ	HELL OTTHES RED	DON'T LOCK OPEN		ed om	STEMS MAG.	OVERRIDE	TOCK UP	BT Ci <b>i</b> n	em Mben	JUMPS MAG.	R BINIS		बरार नगड	<b>13G GP</b>	EACE	ta	A	S-LANG	PLATE OPENED	CONS PER	PRESALE R 0128578
R. Howe	ESTOCES	Б В	STEEL STEEL	Cane Vo	2 T. 1000	EMPTYS	T. SOC.		ccii Sug		1	DOM'TE LA		STEELS.	SHELL J	POLLOWER	LOADING	BOLL OVERRIDE	ACTOR BANG UP	DOR'T STUBACT	REPARTMEN	ADJUSTMENTS	Prese Actor (Branes	FLOOR P.	MALFUNCTIONS	78578 187
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MODELL 7 LWT.

CAL: 7mm-08

3 BERIAL NO. <u>7600094</u>

PUBVIOUS

TEST TITLE: SUMMARY SHEETS PER - RIFLE - AMMO TYPE - SHOOTER

TTL. RDS. FIRED:

TTL. MALFUNCTIONS:

MALFUNCTION NATE:

M/7 LWT. 7MM-08	FUNCTION TEST	"MLFUNCTIONS"
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	SUMMARY SHEET BY	2	उटाचाड शास्त्र		TIMES (	and it	SHELL OTHES RET		FR	SED IOM	STEMS MAG.	OVERRIDE	LOCK UP		CHA	em Moen	JUMPS MAG.	POLICONER BINDS		OVERRIDE	स्त्रस्ट एक	TRACT	พ	A	71	FLOOR PLATE OPENED	IONS PER	PRESALE B 0128579
	R. Howe	E-SIOCHS	8 8	NAME OF THE PERSON OF THE PERSON OF THE PERSON OF THE PERSON OF THE PERSON OF THE PERSON OF THE PERSON OF THE PERSON OF THE PERSON OF THE PERSON OF THE PERSON OF THE PERSON OF THE PERSON OF THE PERSON OF THE PERSON OF THE PERSON OF THE PERSON OF THE PERSON OF THE PERSON OF THE PERSON OF THE PERSON OF THE PERSON OF THE PERSON OF THE PERSON OF THE PERSON OF THE PERSON OF THE PERSON OF THE PERSON OF THE PERSON OF THE PERSON OF THE PERSON OF THE PERSON OF THE PERSON OF THE PERSON OF THE PERSON OF THE PERSON OF THE PERSON OF THE PERSON OF THE PERSON OF THE PERSON OF THE PERSON OF THE PERSON OF THE PERSON OF THE PERSON OF THE PERSON OF THE PERSON OF THE PERSON OF THE PERSON OF THE PERSON OF THE PERSON OF THE PERSON OF THE PERSON OF THE PERSON OF THE PERSON OF THE PERSON OF THE PERSON OF THE PERSON OF THE PERSON OF THE PERSON OF THE PERSON OF THE PERSON OF THE PERSON OF THE PERSON OF THE PERSON OF THE PERSON OF THE PERSON OF THE PERSON OF THE PERSON OF THE PERSON OF THE PERSON OF THE PERSON OF THE PERSON OF THE PERSON OF THE PERSON OF THE PERSON OF THE PERSON OF THE PERSON OF THE PERSON OF THE PERSON OF THE PERSON OF THE PERSON OF THE PERSON OF THE PERSON OF THE PERSON OF THE PERSON OF THE PERSON OF THE PERSON OF THE PERSON OF THE PERSON OF THE PERSON OF THE PERSON OF THE PERSON OF THE PERSON OF THE PERSON OF THE PERSON OF THE PERSON OF THE PERSON OF THE PERSON OF THE PERSON OF THE PERSON OF THE PERSON OF THE PERSON OF THE PERSON OF THE PERSON OF THE PERSON OF THE PERSON OF THE PERSON OF THE PERSON OF THE PERSON OF THE PERSON OF THE PERSON OF THE PERSON OF THE PERSON OF THE PERSON OF THE PERSON OF THE PERSON OF THE PERSON OF THE PERSON OF THE PERSON OF THE PERSON OF THE PERSON OF THE PERSON OF THE PERSON OF THE PERSON OF THE PERSON OF THE PERSON OF THE PERSON OF THE PERSON OF THE PERSON OF THE PERSON OF THE PERSON OF THE PERSON OF THE PERSON OF THE PERSON OF THE PERSON OF THE PERSON OF THE PERSON OF THE PERSON OF THE PERSON OF THE PERSON OF THE PERSON OF THE PERSON OF THE PERSON OF THE PERSON OF THE PERSON OF THE PERS	Canal Part	T. S. S. S. S. S. S. S. S. S. S. S. S. S.	EMPTY	1 111100	•	end End		POWER	in the state of	H	5	BEILE	 SHELL	POLLOWE	LOADENG	BOLL OF	ACTOR B	DOM'T STUTACT	इस्टाच्य इसस	ADJUSTMENTS	REPLACEMENTS	FLOOR P.	MALFUNCTIONS	8579 118
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MODEL 7 LWT.

CAL: 7mm-08

BERIAL NO. 7600094

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TEST TITLE: SUMMARY SHEETS PER - RIFLE - AMMO TYPE - SHOOTER

TTL. RDJ. FIRED:
TTL. MALFUNCTIONS:
MALFUNCTION RATE:

M/7 LWT. 7MM-08	FUNCTION TEST	"MALFUNCTIONS"
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	Summary Sheet By	24	acting Press		SERIE I	and a	SHELL OTHES RED		FR	om d.	STEENS MAG.	OVERRIDE	टिट्स प्रम		cin 81	en Mden	JUMPS MAG.	अज्ञाह		OVERRIDE	म्बाट वर	TO POLICE	SO .		E-107.5	FLOOR PLATE OPENED	IONS PER	PRESALE B.O 128580 TWO
	BY R. Howe	SECORES	30 - OE	200222	Cand Ve.	2000	EMPTY SHELL	Table 1		gnd wil	1	POWER	Darie D	H	E C	Recent	TIMES	FOLLOWER	CAMME	BOLT OV	ACTION BANG UP	DOR'T EXTERACT	SECT VICES	ADJUSTMENTS	REFLACTMENTS	FLOOR P	MALFUNCTIONS	MAIF 0858
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INTR: 10-19-82

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CAL: 7mm-08

BERIAL NO. 7600/33

ROUNDS PREVIOUS

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TEST TULE: SUMMARY SHEETS PER - RIFLE - AMMO TYPE - SHOOTER

TTL. RDJ. FIRED:

M/7 LWT 7MM-08	FUNCTION TEST	"MIFUNCTIONS"
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MTE: 10-19-82

Model 7 LWT.

CAL: 7mm-08

BERIAL NO. 7600133

PREVIOUS ROUNLES

TEST TITLE: SUMMARY SHEETS PER - RIFLE - AMMO TYPE - SHOOTER

TTL. RIG. FIRED:
TIL. MALPUNCTIONS:
MALPUNCTION NATE:

	M/7 LWT.	7mm-08	FUNCTION TEST	"MIFUNCTIONS"
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MODEL 7 LWT

CAL: 7mm-08

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PREVIOUS ROUNDA

TEST TITLE! SUMMARY SHEETS PER - RIFLE - AMMO TYPE - SHOOTER

TTL. RDS. FIRED:

TTL. MALFUNCTIONS:

MALFUNCTION RATE:

M/7 LWT. 7MM-08	FUNCTION TEST	"MLFUNCTIONS"
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INTE: 10-19-82

MODEL: 7 LWT.

CAL: 7mm-08

BERIAL NO. 7600137

PREVIOUS ROUNDS

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TEST TITLE: SUMMARY SHEETS PER - RIFLE - AMMO TYPE - SHOOTER

TTL. RIM. FINED: R
TTL. MALFUNCTIONS: R
MALFUNCTION RATE: R

M/7 LWT. 7mm-08	FUNCTION TEST	"Mifunctions"
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PREVIOUS RAIMUOR

TEST TITLE! SUMMARY SHEETS PER - RIFLE - AMMO TYPE - SHOOTER

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TTL. MALFUNCTIONS:
MALFUNCTION RATE:

M/7 LWT. 7MM-08	FUNCTION TEST	"MALFUNCTIONS"
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BERIAL NO. 76008/

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TEST TUTLE: SUMMARY SHEETS PER - RIFLE - AMMO TYPE - SHOOTER

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TTL. MALFUNCTIONS:
MALFUNCTION RATE:

	M/7 LWT.	7mm-08	FUNCTION TEST	"MALFUNCTIONS"
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FIELD CYCLE TEST - CENTERFIRE

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PREVIOUS PREVIOUS

TEST TUTLE! SUMMARY SHEETS PER - RIFLE - AMMO TYPE - SHOOTER

TTL. RIM. FIRED:
TTL. MALFURCTIONS:
MALFURCTION NATE:

M/7 LWT 7MM-08 FUNCTION TEST "MITURETIONS"

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MTE: 10-19-82

MODELY 7 LWT.

CAL: 7mm-08

BERIAL NO. 7600080

PREVIOUS ROUNDS

TEST TITLE! SUMMARY SHEETS PER - RIFLE - AMMO TYPE - SHOOTER

TTL. RDS. FIRED:
TTL. MALFUNCTIONS:
MALFUNCTION NATE:

M/7 LWT. 7MM-08	FUNCTION TEST	"Malfunctions"
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MODEL! 7 LWT.

CAL: 7mm-08

BERIAL NO. 7600080

PREVIOUS

TEST TUTLE: SUMMARY SHEETS PER - RIFLE - AMMO TYPE - SHOOTER

TTL. RDS. FIRED:

TTL. MALFUNCTIONS:

MALFUNCTION NATE:

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M/7 LWT. 7MM-08	FUNCTION TEST	"MIFUNCTIONS"
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PREVIOUS ROUNDS

TEST TITLE: SUMMARY SHEETS PER - RIFLE - AMMO TYPE - SHOOTER

TTL. RDS. FIRED:
TTL. MALFUNCTIONS:
MALFUNCTION NATE:

M/7 LWT. 7MM-08 FUNCTION TEST "MITURETIONS"

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CAL: 7mm-08

BERIAL NO. 760080

PREVIOUS ROUNDS

TEST TITLE: SUMMARY SHEETS PER - RIFLE - AMMO TYPE - SHOOTER

TTL. RIX. FIRED:
TTL. MALFUNCTIONS:
MALFUNCTION INTE:

•	M/7 LWT.	7mm-08	FUNCTION TEST	"MLFUNCTIONS"
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MTR: 10-19-82

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BERIAL NO. 7600148

PREVIOUS ROUNDS

TEST TITLE: SUMMARY SHEETS PER - RIFLE - AMMO TYPE - SHOOTER

TTL. RDS. FIRED:

TTL. MALFUNCTIONS:

MALFUNCTION RATE:

M/7 LWT 7mm-08	FUNCTION TEST	"MALFUNCTIONS"
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FIELD	CYCLE	TEST	_	CENTERFIRE
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TEST TITLE: SUMMARY SHEETS PER - RIFLE - AMMO TYPE - SHOOTER

TTL. RDG. FIRED:
TTL. MALFUNCTIONS:
MALFUNCTION DATE:

M/7 LWT. 7MM-08	FUNCTION TEST	"MIFUNCTIONS"
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MODEL! 7 LWT.

CAL: 7mm-08

BERIAL NO. 7600 148

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TEST TITLE: SUMMARY SHEETS PER - RIFLE - AMMO TYPE - SHOOTER

TTL. RDS. FIRED:
TTL. MALFUNCTIONS:
MALFUNCTION RATE:

M/7 LWT. 7MM-08	FUNCTION TEST	"MALFUNUTIONS"
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INTE: 10-19-82

Motesta 7 LWT.

CAL: 7mm-08

BERIAL NO. 7600/30

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TEST TUTLE: SUMMARY SHEETS PER - RIFLE - AMMO TYPE - SHOOTER

TTL. RDS. FIRED:
TTL. MALFUNCTIONS:
MALFUNCTION NATE:

M/7 LWT. 7MM-08 FUNCTION TEST "MITURETIONS"

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INTE: 10-19-82

Modela 7 LWT.

CAL: 7mm-08

BERIAL NO. 7600/30

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TEST TITLE: SUMMARY SHEETS PER - RIFLE - AMMO TYPE - SHOOTER

TTL. RIE. FIRED:

M/7 LWT. 7MM-	18 FUNCTION TES	"MIFUNCTIONS"
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BY R. Howe		B - B	SHORTE	TOPES CERET	DOM: SECON	EMPTYS	בי אסמי	18/			POWER O	DOE"T 120		103	Name of the last		SHELL JI	FOLLOWER	LOADING	BOLT OVERRIDE	ACTION 33	DOR'T STUTACE	HEET CACES	A DJUST CENTS	Tree Accelerate	FLOOR PL	MALFUNCTIONS	THE USE OF THE
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	MTR: 10-19-82	Model 7 LWT.	CAL 7mm-08 #10	NO. 2600/44
	TEST TITLE! SUMMARY SH	EETS PER - RIFLE - AMMO TYPE -	SHOOTER TTL. R	DJ. FIRED:

RBER TTL. MALFUNCTIONS M/7 LWT 7MM-08 FUNCTION TEST "MITURETIONS" MALFUNCTION NATE: PRESALE B. 0128605 TW FEED BTEM JUNES MAG. CIMMBER OVERRITE FOLIOWER BINDS FROM BOLT OVERRIDE B TOA POSTO STREET DOM'T STITEACT FLOOR PLATE MALFUNCTIONS PORT'S PIECE ACCOUNT BANG FEAT ACTORNIA SUMMARY SHEET ADJUSTMENTS MO. BEEN EAGES 10. CE TOADTHE SHEET SHELL POWER R. HOWE Ind Sug T. TELL HIER H 3 R140 PSP SLOW DJ MED FAST 61 W 540W MED FAST RU ٥K SLOW MED Řť FAST RE

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FIELD CYCLE TEST - CENTERFIRE

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inte: 10-19-82	MODEL 1 7 LWT.	CAL. 7mm-08	BERIAL NO.	) 7600144

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TEST TITLE: SUMMARY SHEETS PER - RIFLE - AMMO TYPE - SHOOTER

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R. Howe	BENOOES !	<b>6</b>	213116	Cand You	DOM: S.ECT	EMPTUS	ממניד ני	184	ecii Suq		POWER O		arrea .	LOS	RICHE	i	SHELL J	POLLOWER	LOADUMG	BOLT OVE	ACCITOR E	7. EDG	350 A CAS	ADJUSTMENTS	BERTACTABIANS	FLOOR PL	MALFUNCTIONS	MIE-20387
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BARBER - PRESALE R 0128610

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JACK ENDURANCE	CENTERFIRE
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JACK ENDURANCE	CENTERFIRE
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10-15-82

RIFE



BARBER - PRESALE R 0128616

10-18-82

M/7 CAL. 308 FLOOR PLATE LATCH EVAL.

SER# 7600008

RIFLE#1

FLOOR PLATE LATCH RELEASE FORCE LBS.

۲.	0	RDS	111	MAG.
	1	t i	••	• •
	2			4,
	3	(4		44
_	4	v	1,	n
•				

	2	3	TOTAL	AVG
2.75	2.50	2.25	7.50	2,50
2.50	2.25	2.00	6.75	2.75
2.50	2.50	2.25	7.25	2,42
2.25	2.75	225	7.25	2.42
2.50	2,25	2.50	7.25	2.42

AVG. 7.20 2.40

M/7 CAL 7MM-08 FLOOR PLATE LATCH EVAL.

SER# . 7600098

= RIFLE# 1

FLOOR PLATE LATCH RELEASE FORCE LBS.

7.	0	ROS.	111	MAG
	/	11	"	P
	2	•	"	••
	3	11	"	**
	4	4	u	μ

1	2	3	TOTAL	AVG.
1.75	5 200	2.00	5,75	1.92
1.75	175	1.75	5,25	1.75
2.00	1.75	1.75	5,50	1.83
1.75	1.50	1.75	5,00	1.67
1.75	1.75	1.50	5,00	1.67

AUG 5.30 1.76

M/7 CAL. 308 FLOOR PLATE LATCH EVAL.

SER# 7600003

RIFLE# 2

FLOOR PLATE LATCH RELEASE FORCE LBS.

۲.	0	KDS	IN	MAG.
	1		••	"
	2			č.
	3	G		41
	4	•	t,	11

	2	3	TOTAL	AVG
2.50	225	2.25	7.00	2,33
1.75	2.00	2.25	6,00	2.00
2.25	2.25	2.00	6,50	2110
2.25	2.50	2.25	7.00	2.33
2.50	2.50	2.50	7.50	2.50

AUG. 6.80 2.27

M/7 CAL 7MM-08 FLOOR PLATE LATCH EVAL.

SER# 7600010

= RIFLE# 2

FLOOR PLATE LATCH RELEASE FORCE LBS.

٨.	0	ROS.	111	MAG
	/	11	"	11
	2	•	41	.,
	3	•	"	
	4	<i>I</i> ,	4	μ

/	2	3	TOTAL	AVG.
3.00	3.25	3.50	9.75	3.25
2.25	2.50	2.75	7.50	2.50
2.50	2.75	2.75	8.00	2.67
2.50	2.75	2.50	7.75	2.58
2.25	2.25	2,50	7.00	2.33

Keturn latch by hand
ANG 8.00 2.6

M/7 CAL. 308 FLOOR PLATE LATCH EVAL.

SER# 7600040

RIFLE#3

FLOOR PLATE LATCH RELEASE FORCE LBS.

7.	0	RDS	111	MAG.
	1	4.		• •
	2	.,	1.	.,
	3	64		44
	4	e.	1,	n

	2	3	TOTAL	AVG
300	2.50	2.50	8.00	2.67
225	2.25	2.50	7.00	2,33
2.50	2.25	2.25	7.00	2.33
2.50	2.25	225	7.00	2.33
3.00	3.00	2.50	8.50	2.83

AUG. 7.50 2.50

M/7 CAL 7MM-08 FLOOR PLATE LATCH EVAL.

' SER# 7600094

= RIFLE# 3

FLOOR PLATE LATCH RELEASE FORCE LBS.

			!	
٨.	0	ROS.	111	MAG
	/	11	"	11
	2	•	4	• •
	3	,,	**	**
	4	4	h	μ

•						
		2	3	TOTAL.	AVG.	
	2.25	2,25	2.00	6.50	2.16	
	2.25	2,50	2.25	7.00	2.33	
	2,25	2,00	2,25	6.50	2.16	
	2.25	2.25	2.25	6.75	2,25	
	2.00	2.00	2.25	6.25	2.08	

AUG. 6.60 2.20

M/7 CAL. 308 FLOOR PLATE LATCH EVAL.

SER# 7600.022

RIFLE#4

FLOOR PLATE LATCH RELEASE FORCE LBS.

۲,	0	RDS	111	MAG.
	1		••	"
	2		,,	i.
	3	4		••
	4	•	1,	11

	2	3	TOTAL	AVG
2,25	2,25	2,25	6.75	2,25
2.50	2.50	2.25	7.25	2,42
250	2.25	2.25	7.00	2.33
2.75	250	2.25	7.50	2.50
2.50	2.50	2.25	7.25	2.42

AUG 7.15 2.38

M/7 CAL 7MM-08 FLOOR PLATE LATCH EVAL.

SER# 7600133

= RIFLE# 4

FLOOR PLATE LATCH RELEASE FORCE LBS.

٨.	0	RDS.	114	MAG
	/	#	v	11
	2	•	4	U
	3	"	**	"
	4	,,	h	"

/	2	3	TOTAL	AVG.
2.25	2.00	2.50	6.75	2,25
2.00	1.75	2.50	6.25	2.08
2.25	2 75	1.75	6.75	2.25
2.00	2.25	1.75	6.00	2.00
1.75	1.75	1.75	5.25	1.75

AUG. 6.20

207

M/7 CAL. 308 FLOOR PLATE LATCH EVAL.

SER# 7600101

RIFLE#5

FLOOR PLATE LATCH RELEASE FORCE LBS.

	1		
ζ.	O RDS	111	MAG.
	1		"
	2 "		· ·
	3 "	4+	41
	4 .	u	"

	2	3	TOTAL	AVG
2.75	275	2.75	8.25	2.75
2.75	2.50	2.75	8.00	2.66
2.50	2.50	2.50	7.50	2.50
2.75	2.50	2.50	7.75	2.58
2.25	3.25	2.75	8.25	2.75

AUG 7,95 2.65

M/7 CAL 7MM-08 FLOOR PLATE LATCH EVAL.

SER# 7600137

= RIFLE# 5

FLOOR PLATE LATCH RELEASE FORCE LBS.

1.				MAG
		7.		P
	2	"	4	u
	3	r :	"	11
	4	4	h	"

/	2	3	TOTAL	AVG.
2.25	2.50	3.00	7.75	2.58
2.50	2.25	2,00	6.75	2.25
2.50	2.25	2,50	7.25	2.42
2.25	2.75	2.50	7,50	2,50
2.50	2.75	2.75	6.00	2.67

AUG. 7.45 2.48

M/7 CAL. 308 FLOOR PLATE LATCH EVAL.

SER# 7600139

RIFLE#6

FLOOR PLATE LATCH RELEASE FORCE LBS.

۲,	0	RDS	IN	MAG.
	1		••	"
	2	4		.,
	3	4	4.	•1
	4	U	1.	n

	2	3	TOTAL	AVG
4.0	3.50	3.5	11.00	3.66
3.50	3,25	3,25	10.00	3,33
3.25	3,25	3,50	10.00	3.33
3.00	3.5	3,00	9.50	3.16
2.75	3.25	3,25	9.25	3.08

AUG 9.95 3.32

M/7 CAL 7MM-08 FLOOR PLATE LATCH EVAL.

SER# 7600081

= RIFLE# 6

FLOOR PLATE LATCH RELEASE FORCE LBS.

<i>j</i> .	0	RDS.	111	MAG
	1	70	**	11
	2	•	"	•
	3	•	e	1+
	4	lı .	11	μ

	2	3	TOTAL	AVG.
2.00	2.00	1.75	5,75	1.92
2.50	2.00	2.00	6.50	2.16
1.75	2.00	1.75	5.50	1.83
2.00	2.00	2.00	6,00	2.00
2.25	2.00	2.00	6.25	2.08

M/7 CAL. 308 FLOOR PLATE LATCH EVAL.

SER# 7600058

RIFLE#7

FLOOR PLATE LATCH RELEASE FORCE LBS.

1.	0	RDS	14	MAG.
	1	•	**	"
	2			ė,
	3	6	41	•1
	4	t.	1,	"
•				

1	2	3	TOTAL	AVG	
2.75	2.75	2.50	8.00	2.67	
2,50	2.75	3.00	8.25	2.75	
2.50	2.75	2.50	7.75	2,58	
2.25	2.50	2.50	7.25	2.42	
2.25	2.25	2.50	7.00	2.33	
Peturn latch by hand					
•		0.26	マフィグ	2.55	

M/7 CAL 7MM-08 FLOOR PLATE LATCH EVAL.

SER# . 7600080

= RIFLE# 7

FLOOR PLATE LATCH RELEASE FORCE LBS.

٨.	0	RDS.	111	MAG
	1	#	"	11
	2		4	•
	3	•	et.	.,
	4	<i>1</i> ₄	h	"

Ì	1	2	3	TOTAL	AVG.
	2.25	2.00	2,25	6.50	2.16
	1.75	1.75	2.00	5,50	1.83
	225	1.75	1.75	5.75	1.92
	2.00	2.25	1.75	6,00	2,00
	1.50	1.75	2.00	5,25	1.75

AUG 5,80 1.93

M/7 CAL. 308 FLOOR PLATE LATCH EVAL.

SER# 760.0036

RIFLE#8

FLOOR PLATE LATCH RELEASE FORCE LBS.

<i>Ι</i> .	0	RDS	111	MAG.
	1		**	"
	2			i,
	3	4	4.	и
	4	•	ŧ,	n

/	2	3	TOTAL	AVG	
4.00	3.75	3.50	11.25	3.75	
3.25	3.00	325	9,50	3.16	
3.50	3,25	3,25	10.00	3.33	
3.50	325	3.00	9.75	3.25	
2.50	2.75	3,50	8.75	2.92	
Return latch by hand					
·	3.28				

M/7 CAL 7MM-08 FLOOR PLATE LATCH EVAL.

SER# .7600148

= RIFLE# Y

FLOOR PLATE LATCH RELEASE FORCE LBS.

٨.	O	ROS.	111	MAG
	1	**	11	11
	2	•	"	•
	3	<i>r</i>	"	"
	4	<i>u</i>	u	μ

1	2	3	TOTAL	AVG.
2.00	2.50	2.50	7.00	2.53
2.25	2.25	2.00	6.50	2.16
1.75	2.00	1.75	5.50	1.83
2.00	2.25	2.25	650	2.16
2,25	3.00	2,25	7,50	2.50

AUG. 6.60 2.20

M/7 CAL. 308 FLOOR PLATE LATCH EVAL.

SER# 7600103

RIFLE#9

FLOOR PLATE LATCH RELEASE FORCE LBS.

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	2	3	TOTAL	AVG
4.25	4.25	4.00	12.50	4.16
3.50	3.75	4.00	11.25	3.75
4.75	4.25	3.50	1250	4.16
3.75	3.75	4.00	11.50	3.83
3,25	3.50	3.00	9.75	3.25
0+	1.4.1	1.	700	-

Return lateh by hand .

Aug. 11.50 3.83

M/7 CAL 7MM-08 FLOOR PLATE LATCH EVAL.

SER# 1600130

= RIFLE# 9

FLOOR PLATE LATCH RELEASE FORCE LBS.

٨.	0	ROS.	111	MAG
	/	11	"	ľ
	2	•	11	"
	3	"	"	60
	4	l.	h	μ

1	2	3	TOTAL	AVG.
2.50	2.50	2.25	7.25	2.41
1.75	2.25	2.25	6.25	2.08
1.75	1.75	1.75	5-25	1.75
2.25	2.50	2.25	7.00	2.33
1.50	2,25	1.75	5.5	1.83

Avg. 6.25 2.08

M/7 CAL. 308 FLOOR PLATE LATCH EVAL.

SER# 7600043

RIFLE#10

FLOOR PLATE LATCH RELEASE FORCE LBS.

<i>I</i> .	0	RDS	111	MAG
	1		**	"
	2	.,		
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	2	3	TOTAL	AVG
3.50	3.50	4.00	11,00	3,67
3.00	3.25	3,25	9,50	3.16
3,50	3.50	3,25	10.25	3.42
3,50	3.00	3.00	9.50	3.16
3.50	3.50	3.00	10.00	3.33

Peturn latch by hand Aug 10.05 3.35

M/7 CAL 7MM-08 FLOOR PLATE LATCH EVAL.

SER# 7600144

= RIFLE# 10

FLOOR PLATE LATCH RELEASE FORCE LBS.

٨.	0	ROS.	111	MAG
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	3	<i>!•</i>	e	11
	4	4	11	"

/	2	3	TOTAL	AVG.
3.50	3,25	350	10.0	3,33
3.00	3.00	3,50	9.5	3.16
3.00	3.00	3,00	9.0	3.00
2.75	3.25	3.75	9.75	3.25
2.75	2.50	325	8.5	2.83

Return latch by hand Ave. 9.35 3.11

MODEL SEVEN

finel- en gones

Reminetos

cc: C. A. Riley

R. J. Long

J. P. Linde G. D. Campbell

Bridgeport, Connecticut
January 13, 1983

TO:

P. J. MEYER

FROM:

W. H. FORSON, JR.

SUBJECT:

REVISION TO MODEL SEVEN FORECAST

Total Company orders for the Model Seven are approaching 5,000, which is sufficient to recognize trends that differ from the original forecast. Based on an analysis of orders to date, PRODUCTION please implement the following revised forecast.

Caliber	Demand Quantity	OR16. BEMOND	or 16 schid	Rev Edd 2
222 243 6mm 7mm-08 308	3,600 10,000 2,400 3,200 9,300	11 500 1800 4500 5400	5600 16,240 1800 5500 8500	
TOTAL	28,500	28,500	37,640	

John: fleare fell on revised schools for me.

I know were cut 1st Run of 7mm at to 2000 44.118

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1600

M/2 ORIG Doe Schelule Golday XIb days = 960

Month end was edged adding 2 dry to December (Shouldn't appeal on total pas prost for December)

For stat-up assurely Techeles Hon 11-19-82) we are lacking:

#15412 (adm) Bolt Stop (noed add H/T-wmm, matl) - will be ver by 11-29
92428(5) 7dmy May abllown (held at PP Insp) - ""

#17891 oday May Spg [also from vandon 11-17] ""

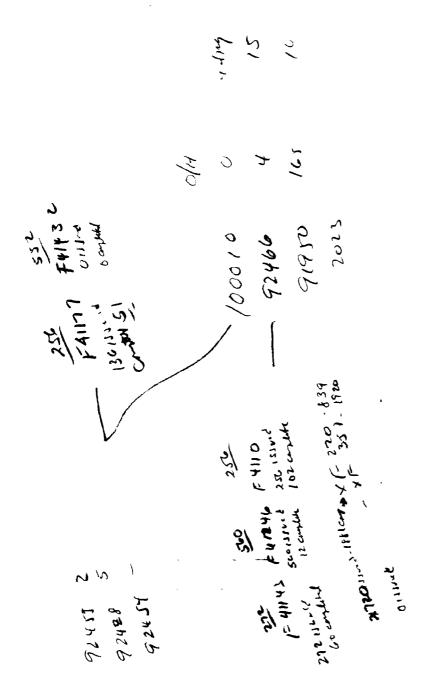
STK Assg (256 o'doe) - """

TR16 Assy (244 o'doe) - """

FP Latch (P/m-dus 12/10)

FP Pad (P/m-dvr 11-24)
Boetassy (678 in Prom?) - "

Fit Si, Kt Ramp (P/M - due 11-24)



Seavence			
M 7	243	2400	DEC - FEB
{ '	30B	1500	FEB-MAR
	222	2000	MAR OUT
•	7mm08	2000	MAR-APR
	6 MM REA	1000	APR
	243	3000	APR
	<i>3</i> 08	2000	MO4-
	222	3000	UUNC

The L.S.Starrett Company

BEARCAT TEETH

M/7 Mag. fallower received Punhased Inst

not get inspected.

Harris Com Harter (30)950 (ver) Back

BALDWIN-HALL COMPANY P.O. Box 4847 6552 Ridings Road Syracuse, N.Y. 13221 Phone (315) 463-9251

M/7 Balt Stops

F 52449 Hit

P.P. not yet issued.

M/7 How Plat Base

P.P. held for Material

(enters lot rejected

by PE+C)

2 D-69-8

REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE



DETERS **QUPUND**

"CONFINE YOUR LETTER TO ONE SUBJECT ONLY"

XC: J. P. Linde

File

R. J. Long

W. S. Johnson

January 26, 1983

TO:

D. D. RICCI

FROM:

M. S. HALL

SUBJECT: M/7 FLOOR PLATE BASE

Purchased Parts Inspect rejected 2 lots of parts totaling 9632 pieces. Parts have cracks and 6 characteristics out of specs.

Production needs parts.

In attendance at meeting 1/25/83:

D. J. Anderson J. B. Mroz S. D. Bennett D. D. Ricci L. B. Bosquet J. R. Snedeker M. S. Hall R. L. Snedeker

Z. J. Kowalski

CONCLUSIONS FROM MEETING:

In Plant Parts

Purchased Parts will screen parts and release to Production parts that don't have cracks.

Future Vendor Parts

- Vendor has changed grain flow of material to eliminate 1.) cracks.
- 2.) Vendor will be expected to meet following specs.:
 - a.) .080-.090 dia's. of hinge pin hole.
 - .495 ± .005 dim. of coined countersink. b.)

SUBJECT: M/7 FLOOR PLATE BASE

CONCLUSIONS FROM MEETING:

Future Vendor Parts (contd.)

- 3.) Inspection point will be clarified on .625 dim. on width of hinge pin section and .220 dim. (height of front end). Production will file .625 dim. over hinge section.
- 4.) B. Bosquet will get with vendor on .251-.258 dia. of take down screw hole to resolve this problem.
- 5.) B. Bosquet will get with Research on possible redimensioning of .442-.448 dim. (position of takde down hole from hinge pin hole).
- 6.) Gary Barnes will check parts to see if & of hinge pin hole is in line with bottom of plate.

MS Hall

MSH/bdm

- 2 -

SALES

DEPARTMENT

Remington Remington ROM-O-Gram

Quick Facts About REMINGTON PRODUCTS

1710H 677 FONG 10 05

cc: House Force

Bridgeport, Connecticut March 24, 1983

MAR 28 1983

TO THE FIELD FORCE:

You have already received a request to contact your jobber customers, instructing them to hold further delivery of any Model Seven rifles on hand and to supply you with a list of dealers who have received delivery of Model Seven rifles.

Our ultimate intention is to update all Model Seven rifles shipped to date by means of a return to the nearest Remington warranty gunsmith service location or to Arms Service in Ilion.

We have discovered that if a Model Seven rifle is disassembled after it leaves the factory, it is possible for the rifle to be reassembled incorrectly, producing off-center trigger alignment that might cause subsequent malfunction of the trigger and accidental firing of the rifle. The updating service on the rifle will eliminate the possibility of such incorrect reassembly.

To accomplish this, you are requested to obtain:

- 1. A list of all Model Seven rifles and matching serial numbers still in an individual jobber's inventory.
- 2. A list from the jobber of the names and addresses of dealers to whom Model Seven rifles have been shipped, including serial numbers.

Both jobbers and dealers will then be contacted by Product Service with instructions on how to have the rifles updated. Consumer purchasers of Model Seven rifles will also be contacted by Product Service with a request and instructions to have the rifles updated.

REMINGTON ARMS COMPANY, INC., BRIDGEPORT 2, CONN.

Form No. RD 451

Printed In U.S.A.

Field Force Page 2 March 24, 1983

In all contact with jobbers, dealers, and retail customers on this subject, it is important to emphasize that the potential malfunction is remote, can occur only on a Model Seven rifle that has been disassembled and subsequently reassembled outside the factory, and that the update applies only to Model Seven rifles and not to any other Remington models.

This update is being incorporated into all Model Seven rifles to be shipped in the future.

Sincerely,

E. J. Conroy Director of Sales

EJC/dr

Remington. 21

APR 6 1983

REMINGTON ARMS COMPANY. INC.

TELEX 964-20! STRATFORD CT 939 BARNUM AVENUE P.O. BOX 1939

TELEPHONE 203-333-1112

BRIDGEPORT, CONNECTICUT 06601

March 31, 1983

TO OUR DISTRIBUTORS:

Remington Arms Company has discovered a problem that may develop with the Model Seven rifle and is requesting you hold further delivery of the Model Seven that remain in your inventory until notified. This letter provides you with the necessary details regarding this request.

We have discovered that if a Model Seven rifle is disassembled after it leaves the factory, it is possible for the rifle to be reassembled incorrectly, producing off-center trigger alignment that might cause subsequent malfunction of the trigger and accidental firing of the rifle.

Since a rifle may be disassembled at any time in the future for one of several reasons, we wish to update all Model Seven rifles with a preventative modification that eliminates the possibility of such incorrect reassembly. As a result, if you have not already done so, we are requesting your assistance with the following actions:

- 1. Please hold any Model Seven rifles still in your inventory.
- 2. Please send to us (c/o Remington Arms Co., Inc., 939 Barnum Avenue, P. O. Box 1939, Bridgeport, CT 06601, Attention J. D. Glenn) or provide your Remington Field Representative with a list of the names and addresses of dealers to whom you have shipped Model Seven rifles with matching serial numbers for those rifles. We will then contact those dealers with instructions for the updating modification.

3. Please return any Model Seven rifles still in your possession to the Remington warranty gunsmith service location nearest you for the updating modification. A list of such locations is enclosed. If it is inconvenient or difficult for you to return Model Seven rifles to a warranty service location, you may also ship them to:

Remington Arms Co., Inc. Arms Service Division Ilion, NY 13357

To expedite, shipments should be made prepaid. Upon receipt of a copy of your freight bill, Remington will issue a check for same. Your receipt should also be referred to J. D. Glenn (c/o Remington Arms Co., Inc., 939 Barnum Avenue, P. O. Box 1939, Bridgeport, CT 06601) for handling.

In returning Model Seven rifles to either location, please include your company name and return mailing address inside each box. The updating of your rifles and return to you will be accomplished as quickly as possible. While the possibility of the described malfunction is remote and it can occur only if the rifles are disassembled after they leave the factory, we believe it is in the best interests of the eventual owner to have this preventative modification performed.

We apologize for whatever inconvenience this may cause you. This update applies only to Remington Model Seven rifles shipped prior to this date and not to any other Remington models. The corrective action will be incorporated into all Model Seven rifles to be shipped in the future.

If you have any further questions, or if any of your dealers have questions concerning this request, please feel free to call us on the following toll free number, 800-243-2953 (operational after April 8, 1983), between 8:00 a.m. and 4:30 p.m. Eastern Standard Time.

Sincerely

E. J. Compay

Director of Sales

EJC/dr Enc. RD-69-B

REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE

Xc: L. B. Bosquet R. C. Bottini

File: Proposal 1011

Remington.

PETERS

"CONFINE YOUR LETTER TO ONE SUBJECT ONLY"_____

May 10, 1983

TO:

R. J. LONG

FROM:

D. J. ANDERSON

RE:

MODEL SEVEN LWT - .223 CALIBER

The above project has been accepted by the Operations Committee and a trial and pilot lot of 100 pieces is required for August assembly.

Please make whatever arrangements necessary. Barrel blanks have been completed through the GFM today.

DJA:hv

REMINGTON ARMS COMPANY. INC

INTER-DEPARTMENTAL CORRESPONDENCE

xc: L.B. Ferreira L.B. Bosquet R.J. Long S.D. Bennett

Remington. **QUPOND**

DETERS **QUPOND**

"CONFINE YOUR LETTER TO ONE SUBJECT ONLY"_

—— May 26, 1983

TO:

1D-89-B

D.J. Anderson

FROM: D.D. Ricci

M/7 RE-DESIGN STATUS

PHASE I - Strengthen Design

1. Plate - change to .080 material

a. no changes transmitted

b. no orders issued

2. Spring - alter configuration

- a. order I-1648 issued to marked print for 10,000 parts on temporary tools
 - 1) order cancelled 5-9-83 no cancellation charges
- b. issued an additional production for 10,000 to alleviate vendor of material since not a standard thickness
- 3. Cover change to .062 material
 - a. order I-1667 issued for 10,000 parts from altered permanent tools. Requisition issued to cover \$2,800.00 tooling alteration only.
 - 1) order put on hold as there will be a consideration for the steel if scrapped. Steel will be inventoried and tooling segments shelved until June '83. Determination required at that time.
 - 2) no production parts produced.

PD-69-B ,

REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE

Remington.

PETERS

"CONFINE YOUR LETTER TO ONE SUBJECT ONLY"___

May 26,1983

M/7 RE-DESIGN STATUS

PHASE I - Page 2

- 4. Base change to .062 material
 - a. order I-1636 issued for 10,000 parts (#92724) requisition received
 - b. letter issued to vendor authorizing purchase of additional raw material, but hold until further decision in June '83. If not used then, a cancellation charge will be incurred.
 - c. parts have been received.
- 5. Guard temporary tool change to front & rear configurations
 - a. order I-1637 verbally issued. Requisition issued for \$1,175.00 tooling charge and 10,000 parts at \$975.00/M.
 - 1) order is on hold and vendor has incorporated enough changes that parts can not be used as #92249. Value of parts with 3 operations left to lengthen hook end is \$744.00/M

P.D-69-1.

REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE

Remington.
OUPOND

PETERS

"CONFINE YOUR LETTER TO ONE SUBJECT ONLY"_____

May 26, 1983

PHASE II - RETURN TO ORIGINAL DESIGN

- 1. Plate #91845
 - a. no changes required to tools
 - b. 9,000 parts in inventory next order required the end of July '83.
 - 1) I-1796 issued for 10,000 parts due 7-1-83.
- 2. Spring #91848
 - a. no changes required to tools
 - b. 7,000 parts in inventory. Original order for 10,000 never cancelled is due May '83.
 - c. due to cancellation of proposed design (non standard steel to consider) have issued an additional order for 10,000 #9.848 also due May '83. Therefore, enough parts until October '83.
- 3. Cover #92255
 - a. tooling change will be required to return to .050 material
 - 1) Requisition issued for \$580.00 Order I-3330
 - b. 11,000 parts in inventory
 - c. next order required August '83.
 - 1) I-3331 issued for 10,000 parts due 6/30.



ED-69-B

REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE



PETERS

"CONFINE YOUR LETTER TO ONE SUBJECT ONLY"______ May 26, 1983

PHASE II - RETURN TO ORIGINAL DESIGN - page 2

4. Base #92256

- a. tooling change will be required to return to .050 material
 - 1) Requisition issued
 - 2) Order I-1797 issued to complete change week of 5/23.
- b. next order required for June '83.
 - 1) I-1798 issued for 10,000 parts due 6-8-83.

5. Guard #92249

- a. tooling change will be required to return to original design C-92249 Alt # 7 rear tab 7 front hook unchanged.
- b. but R&D has issued a transmittal to change rear tab only C-92249 Alt #13
 - 1) I-3332 issued to alter tools \$10,880.00 11-13 weeks.
 - 2) Also additional charge of \$1175.00 for temporary tools required to get parts in July.
- c. Parts required in July
 - 1) I-3333 issued for 10,000 parts due 6-30-83.

PHASE III - RETURN TO PHASE I?

Meeting to be held 5/26 for discussion and earliest implementation based on production's current requirements and vendor's leadtime.

DDR/1

BARBER - PRESALE R 0128646

SALES

DEPARTMENT

Remington Remington Rem-O-Gram

Quick Facts About REMINGTON PRODUCTS

10 D2 R.J. LONG ILION Juli m/1

JUN 1 3 1983

June 6, 1983

TO THE FIELD FORCE:

The following information covers all Model 7 production since the recent update notice. You can identify these models by:

- (1) A dot on the left side of the trigger.
- (2) A circle P P on all master cartons (5 pack).
- (3) A circle P P on each individual gun box.

All firearms updated by either Arms Service or Remington Warranty Gunsmiths will have triggers marked as indicated above.

Sincerely,

E. J. Conroy

Director of Sales

EJC/dr

REMINGTON ARMS COMPANY, INC., BRIDGEPORT 2, CONN.

Ferm No. 8D 451

Printed in U.S.A.

RD-49-8

REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE

Remington.

PETER:

Jy Structure

AUG 1 5 1983

L. Ferreira
S. Johnson
R. Long
J. Brooks
File

film/7

XC:

"CONFINE YOUR LETTER TO ONE SUBJECT ONLY"_

July 29, 1983

TO:

J. Linde

FROM:

D. Ricciy

REFERENCE: M/7 Steel Purchase Parts Components for Fire Control Area

The Steering minutes and other verbal communications say that all involved vendors should have been notified of the steel design obsolescence and that Purchasing should refrain from ordering additional parts.

It is my understanding that the die cast design will be released for build approximately 9-1-83, with first samples due in December '83. Upon approval, trial & pilot and production build leadtimes, the earliest phase-in would be late first quarter or early 2nd quarter 1984.

Therefore, in absence of any further communication, Purchasing will continue to order the steel components per the MRP schedule, but minimum quantities to facilitate the transition next year. We'll begin advising our vendor of the possibility of a new design (since it is not a proven one) in order to keep them from running any shelf stock or ordering excess raw materials.

Also, previous orders had been issued for certain thicker design components, but were placed on hold. Again, if not advised otherwise, all outstanding orders for tools, components or raw materials will be cancelled and invoiced according to all work performed prior to the hold notification.

Based on current inventories, it appears that additional orders will have to be placed toward the end of August for MRP requirements in December '83. We will proceed with the program outlined unless otherwise advised.

DDR/sjk

1/7/2 200 FOR PLUTE PLANT CHANGE PIN, ANCH

		785	A OF TESTING	
Developmental				
Pre-Pilot		 -		
?ilot		Design Change	Stake	
Production Acceptance		Plant Assistance	Gther	
FIREARM STATS	SEPC	BT BEO'D		
	Competitive Evaluation Warenouse Audit Pre-Pilot New Design Cost Reduction Pilot Design Change Stake Production Acceptance Plant Assistance Other FIREARM STATS REPORT REQ'D. MODEL: TAWT CALL or GAGE: ZOP BARREL TYPE: TAPE RESULTS ONLY PROOFED: YES NO ONLY Strength Test Ammunition Test Dry Cycle Test Photo/Video			
——————————————————————————————————————	FORMAL		DATE NEEDED BY:	
	TEST			
		/		
		 -		
Function Test Accuracy Test EXPLAIN IN DETAIL THE RES There are the d	Environmental Test Customer Complaint SON FOR THIS TEST:	Measurement Endurance T	Other	

the Lacs by the designer or engineer. All Work Requests are

to be filled out in detail. No Exceptions.

REPORT DATE: _

D-ah-e		
REMINGTON ARMS COMPANY, INC.	Distribution:	
inter-departmental correspondence	D. Bu	4615
Remington PETERS		
	.ui	
"CONFINE YOUR LETTER TO ONE SUBJECT ONLY	f"	•
TEST RESULTS ON	LY	
RESEARCH TEST and MEASUREMENT REPOR	•	
MI/7 LWT , 308 CAL. FUN	10.7	
POWDER METAL LATER (1-10	COTON TEST OF LAS	7257
OPENING ON FIRING	83) FOR FLOOR PLAT	6
-		
	Prepared by: R. Howe	·
	Date Prepared: 1-18-83	3
	•	
Proofread and Cleared By:		
110011cas and Courts Sy.		•
J.H. Hennings , R.E. Nightingale.		
J.H. Hennings , R.E. Nightingale, Foreman-Test Lab Foreman-Measurement Lab	C:	
	Signature	Date
C.E. Ritchie, Sr. Supervisor - Testing,	Signature	Date
Meas. & Mech. Analysis Lab	•	

TEST & MEASUREMENT LAB REPORT

REPORT NUMBER: 83	
REPORT TITLE: M/72	WT. 308 CAL. FUNCTION TEST OF LATEST
MODEL(S): m/7 LW7	WT, 308 CAL. FUNCTION TEST OF LATEST METAL LATCH (1-10-83) FOR FLOOR PLATE OPENING. ON FIRING.
GAUGE OR CALIBER: .	
DATE: 1-18-83	
WORK ORDER NO.: C -	1856-000
PART NAME: FLOOR	PLATE LATCH
DESIGNER/ENGINEER:	D. BULLIS
TEST TYPE:	
1.	PHOTO LAB
2.	STRENGTH TEST - NO. OF GUNS TESTED
3.	FUNCTION TEST - NO. OF GUNS TESTED
4.	ACCURACY TEST - NO. OF GUNS TESTED
5.	MEASUREMENTS - TYPE:
6.	ENVIRONMENTAL TEST
7.	AMMUNITION TESTING & EVALUATION - TYPE:
8.	VISUAL EVALUATION - OUT OF GUN SAMPLE
9.	ENDURANCE - NO. OF GUNS TESTED:
	NO. OF ROUNDS PER GUN: 130
	TOTAL ROUNDS FIRED IN TEST: 650
	AMMO TYPE: MAGS:; TARGET:

RIM FIRE _____ CENTER FIRE X

FROM R. HOWE

TEST RESULTS ONLY"

TEST TITLE

M/7 LWT, 308 CAL. FUNCTION TEST OF LATEST POWDER METAL LATCH 1-10-83 FOR FLOOR PLATE OPENING ON FIRING.

REASON FOR TEST:

TO DETIRMINE IF FLOOR PLATE LATCH WILL RELEASE FLOOR PLATE WHEN RIFLE IS LIVE FIRED UNDER FIELD CONDITIONS.

TEST PROCEDURE:

THIS WAS A FIELD FUNCTION TEST ONLY AND WAS SHOT AT THE ILION FISH + GAME CLUB RIFLE RANGE AT 100 YDS., FOO RDS PER GUN, FIFTERN ROUNDS EACH OF R-150-PSP, R-180-PSP, W-150-PP, W-180-ST, W-200-ST, F-150 PSP, F-180-PSP AND F-165-PREM BT.

EACH AMMIO TYPE BEING SHOT 5 RDS SLOW, 5 MED, + 5 FAST FEED SPEEDS.

THE ROUND ROBIN SYSTEM WAS USED WITH EACH SHOOTER FIRING IS RDS. AT THE ABOUT THREE FEED SPEEDS AND THEN CHANGING GUNS UNTIL EACH GUN WAS FIRED A TOTAL OF ADROS.

TEST RESULTS:

OF THE FIVE RIFLES TESTED NONE HAD AN OCCURANCE OF FLOOR PLATE FALLING OPEN ON LIVE ROUND FIRING FOR ENTIRE TEST.

"COHT."

TEST RESULTS "CONT,

NO OTHER MALFUNCTIONS OCCURED WITH THE EXCEPTION OF THE FOLLOWING NOTE.

NOTE:

AFTER FIRST 150 ROS, OF TEST (30 RDS EACH GUN)

FOLLOWERS IN ALL FIVE TEST GUNS WERE ALTERED

BY BENDING LEGS IN SLIGHTLY BECAUSE FOLLOWER

WAS HAHGING UP ON STEEL STAMPING OF FLOOR

PLATE FRAME AND CUITING MAGAZINE CAPACITY FROM

4 ROUNDS TO 3. AFTER ALTERING FOLLOWERS ALL GUNS

TOOK 4 RDS IN MAGAZINE WITH NO FORTHER PROBLEMS.

Report No.	830101
LIAMON FIRM	

RESEARCH TEST & MEASUREMENT LAB WORK REQUEST

•	ARE	A OF TESTING
Developmental	Safety Related	Litigation
Design Acceptance	Competitive Evalu	
Pre-Pilot	New Design	Cost Reduction
Pilot	Design Change	Stake
Production Acceptance	Plant Assistance	Other
FIREARM STAT'S	REPORT REQ'D.	
MODEL: TLWT		DATE REQUESTED: 1-10-83
CAL or GAGE: 308	FORMAL	DATE NEEDED BY: A.S.A.P.
BARREL TYPE: CA PB	TEST RESULTS	REQUESTED BY: RULLIS
PROOFED: YESNO	ONLY	WORK ORDER NO:
	<u> </u>	C-1856000
	TEST TYPE	, ,
Strength Test Ammuni	tion Test Ory Cycle To	est Photo/Video
Function Test Environm	nental Test Messuremen	ts Other
Accuracy Test Custome	r Complaint Endurance T	'est
EXPLAIN IN DETAIL THE REASON FOR		
This are the latest	P.M. Retake to d	ate (1-10-83).
Function test 5 A	iflee to check for	floor plate opening.
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	•	
- GUNS REQUIRED:	60 102	
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67 76 49	00-01	
47		
NOTE: NO fireerms or perts will be tested	in the Labs unless they are	DATE COMPLETED:
accompanied by a Work Request.	·	TEST COMPLETED BY:
		REPORT DATE: 1-18-63
the Labs by the designer or engine		REPURTUATE:
to be filled out in detail. No Excep	ortions.	
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	TEST TITLE: NY LWT TEST LOR FLOOR YLATE COMING OPEN M/ 7 LWT .308 FUNCTION I LST "MILTURCTIONS" FEED STEM CHAMBER BUILD BUIL																	•		PAGI	8 NO	2_						
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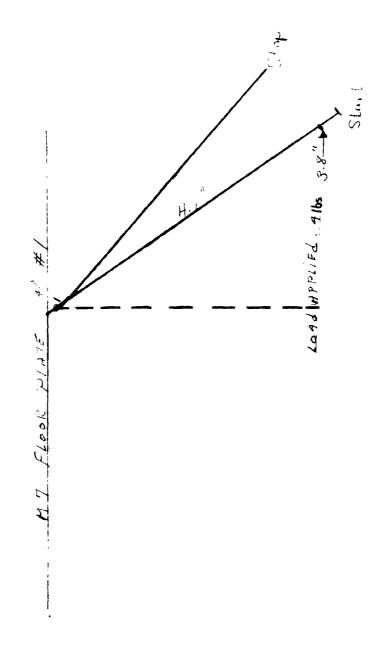
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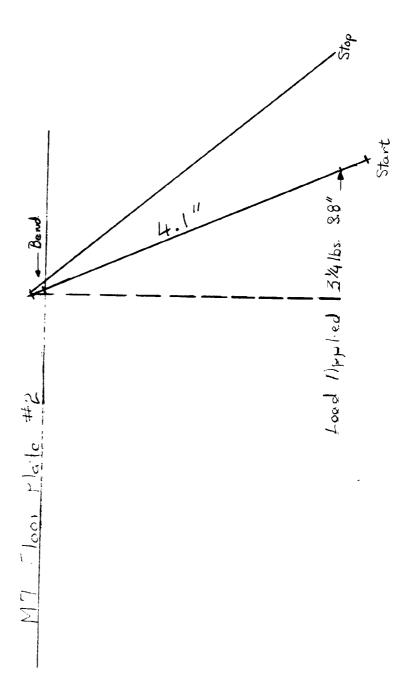
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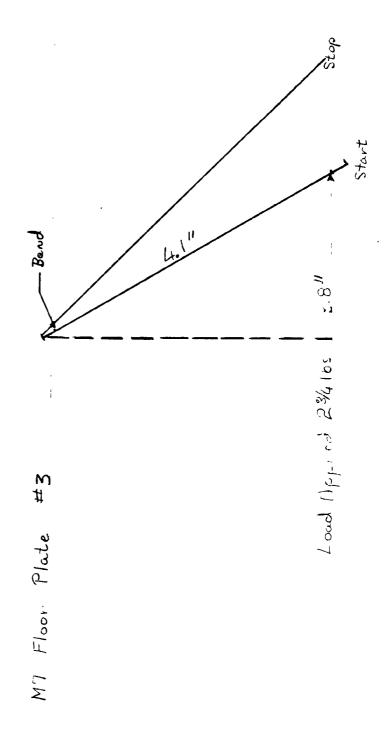
accompanied by a Work Request, and both are delivered to the Labs by the designer or engineer. All Work Requests are

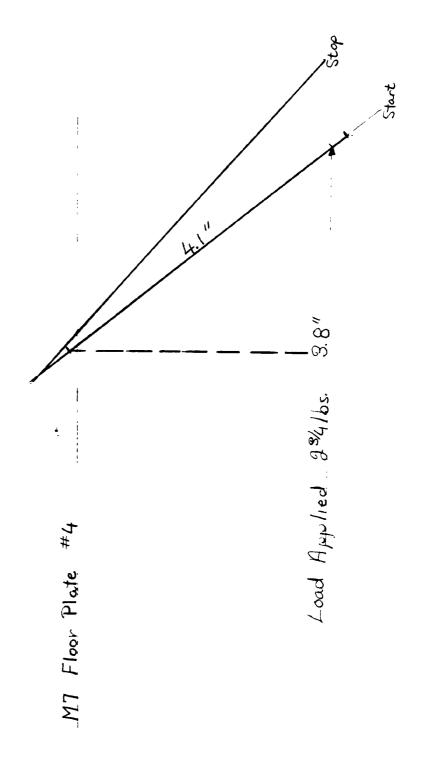
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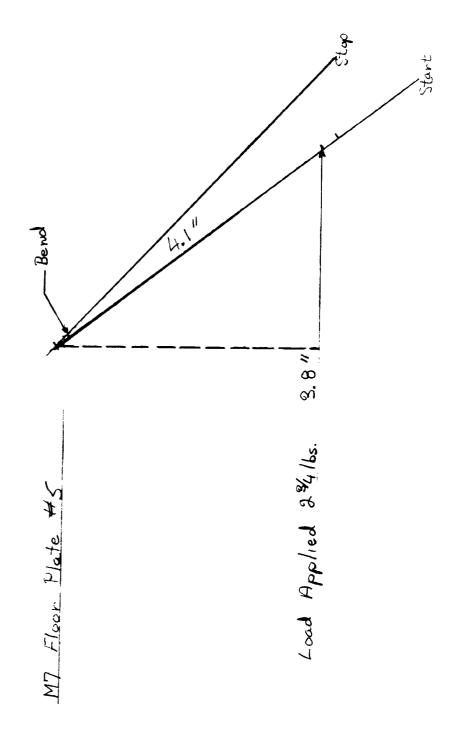
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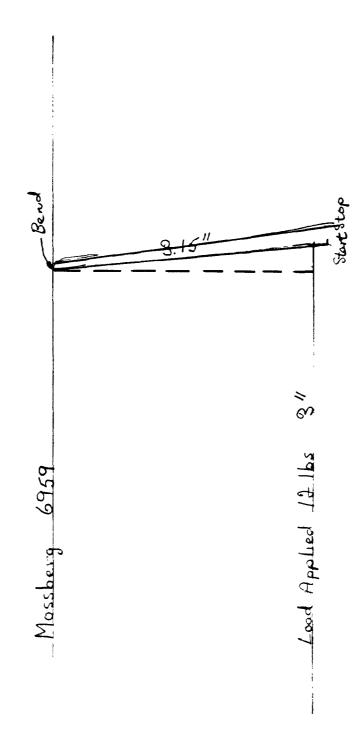


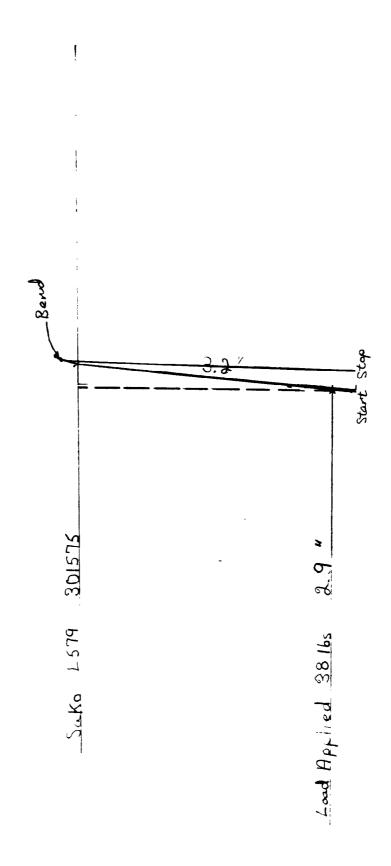


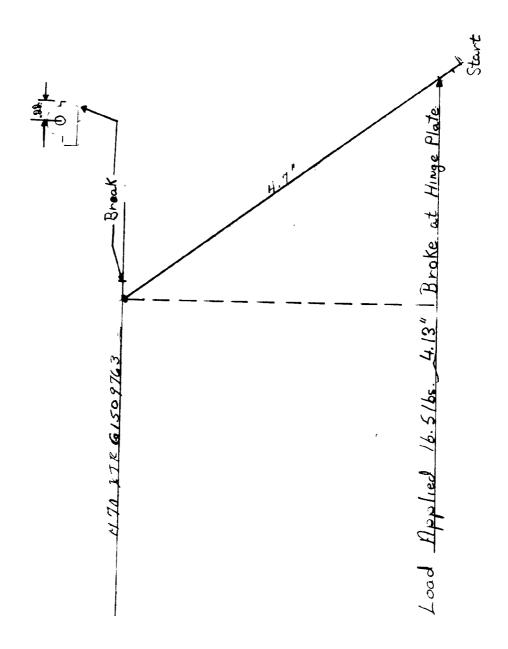






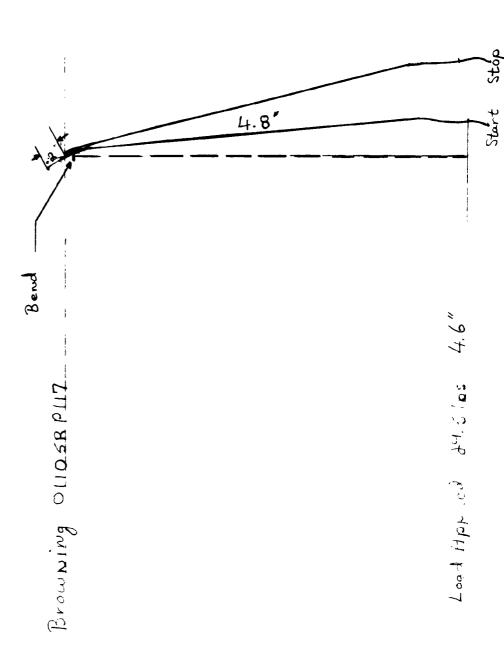


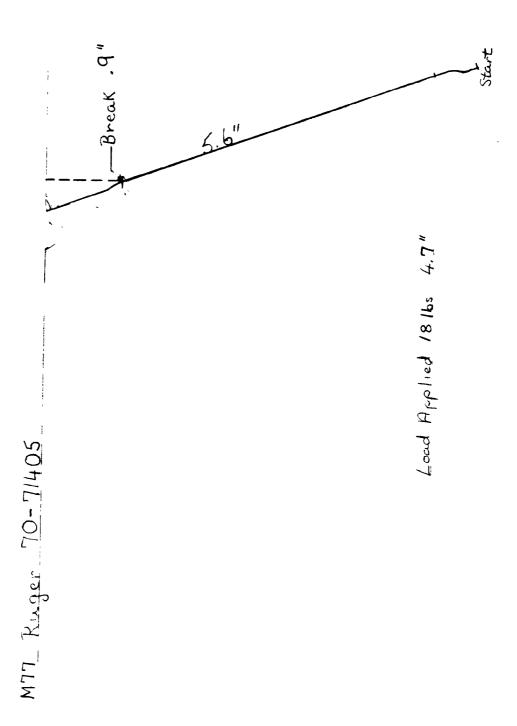


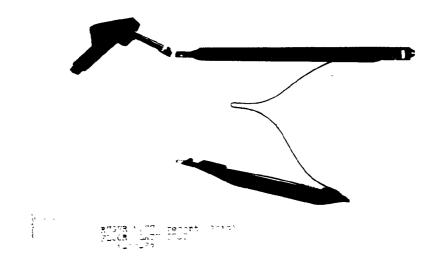


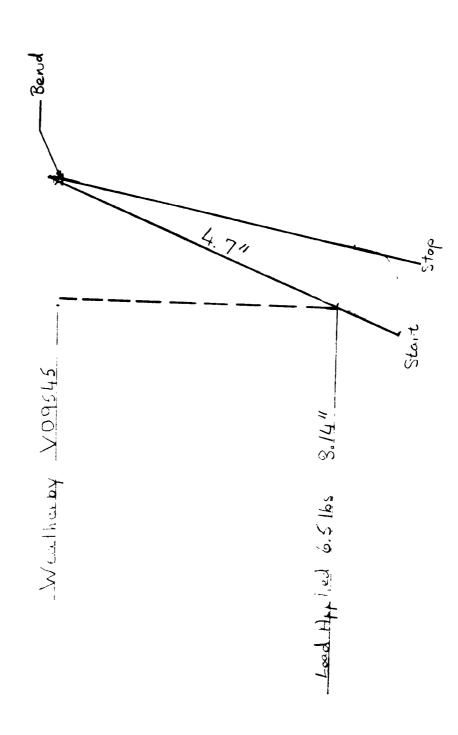


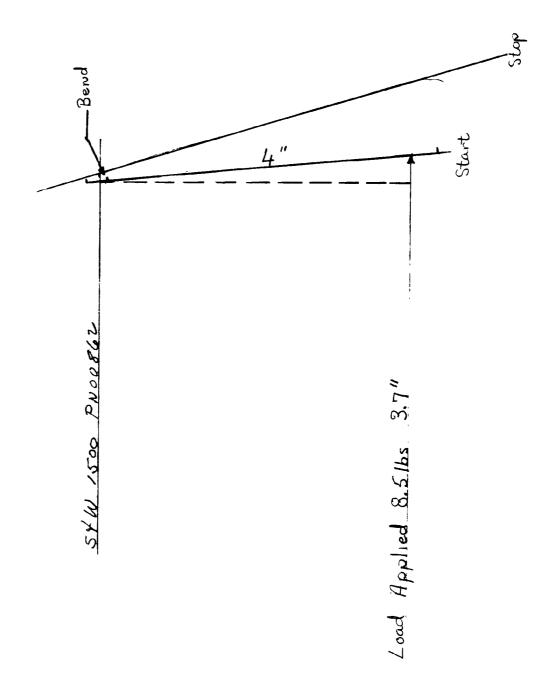
VIN. M/70 (report 830191) FLOOR PLATE TEST 1-20-83













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Report No.		1
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RESEARCH TEST & MEASUREMENT LAS WORK REQUEST

		A OF TESTING
	Safety Related	
Design Acceptance		Utigation ation Warenouse Audit
Pra-Pilot	New Design	Cost Reduction
Pilot	Design Change	Stake
Production Acceptance	Plant Assistance	Cther
FIREARM STAT'S	REPORT REQ'D.	
MODEL:	FORMAL	DATE REQUESTED: 8 -3 - 8 2
CAL = CACE 222	FORMAL	DATE NEEDED BY:
BARREL TYPS: CALE SINGE	TEST RESULTS	REQUESTED BY: عصير د شار د ما
PROOFED: YESNO	ONLY	WORK ORDER NO: 4-1356-000
		:
	TEST TYPE	
Strength Test Ammuniti		
Function Test Environme		
Accuracy Test Customer	Complaint Endurance 1	
EXPLAIN IN DETAIL THE REASON FOR T	HIS TEST:	
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/720 222 6	11 1 3 m.	
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-GUNS REQUIRED:	(403.00)	
-GUNS REQUIRED: 5 -M 7LWT WY-H	NEW, EOUD ST	en och for such
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NOTE: NO firearms or parts will be tested in	the Labs unless they are	DATE COMPLETED: 1/24 2-
accompanied by a Work Request, an	nd both are delivered to	TEST COMPLETED BY:
the Laps by the designer or engineer	. All Work Requests are	REPORT DATE: 1/20 227
to be filled out in detail. No Excepti	ons.	
		<i>,</i>

Distribution: C. B. Workman REMINGTON ARMS COMPANY, INC. J. W. Brooks INTER-OSPARTMENTAL CORRESPONDENCE C. E. Ritchie D. Bullis Remington "CONFINE YOUR LETTER TO ONE SUBJECT ONLY"_ RESEARCH TEST and MEASUREMENT REPORT - Report No. 822731 M/SEVEN LWT. .222 CALIBER STAMPED NO-BIND FOLLOWER vs. M/600 STAMPED FOLLOWER COMPARISON TEST J. Baggetta Prepared by: Date Prepared: 1.24-83 Proofread and Cleared By: ab/ Foreman-Messurement Lab

C.E. Ritchie.

Sr. Supervisor - Testing, Mess. & Mech. Analysis Lab

TEST & MEASUREMENT LAB REPORT

REPORT NUMBER:	822731
REPORT TITLE:	M/Seven LWT222 Caliber Stamped No-Bind Follower vs. M/600 Stamped Follower Comparison Test
MODEL(S):	M/Seven LWT.
GAUGE OR CALIBER:	.222
DATE:	9-30-82
WORK ORDER NO.:	C-1856-000
PART NAME:	
DESIGNER/ENGINEER	D. Bullis
TEST TYPE:	
1.	PHOTO LAB
2.	STRENGTH TEST - NO. OF GUNS TESTED
3.	FUNCTION TEST · NO. OF GUNS TESTED5
4.	ACCURACY TEST · NO. OF GUNS TESTED
5.	MEASUREMENTS - TYPE:
6.	ENVIRONMENTAL TEST
7.	AMMUNITION TESTING & EVALUATION - TYPE:
8.	VISUAL EVALUATIONOUT OFGUN SAMPLE
9.	ENDURANCE - NO. OF GUNS TESTED: 5
	NO. OF ROUNDS PER GUN: 75
	TOTAL ROUNDS FIRED IN TEST: 750
	AMMO TYPE: MAGS,; TARGET:
	RIM FIRE CENTER FIRE X

Two Followers Per Gun.

BARBER - PRESALE R 0128694

REMINGTON ARMS CO., INC. Firearms Research Division

Report No. 822731

January 24, 1983

TO:

R. E. NIGHTINGALE

FROM:

J. BAGGETTA

REPORT TITLE:

M/SEVEN LWT. .222 CALIBER STAMPED NO-BIND FOLLOWER vs.

M/600 STAMPED FOLLOWER COMPARISON TEST.

ABSTRACT

A request was received from D. Bullis, Current Firearms Design, to Field Function Test, 5 M/Seven LWT. .222 caliber with the Stamped No-Bind Follower vs. M/600 Stamped Follower.

SCOPE OF TEST

To evaluate the M/Seven LWT. .222 Caliber Stamped No-Bind Follower vs the M/600 Follower for feeding and ejection malfunctions.

TEST RESULTS

- 1.) Five (5) M/Seven LWT. .222 caliber were fired a total of 375 rounds (75 rounds each) experiencing a total of 45 malfunctions for an overall malfunction rate of 12.0%.
- 2.) Five (5) M/Seven LWT. .222 caliber with the M/600 Stamped Follower were fired a total of 375 rounds (75 rounds each) experiencing a total of 54 malfunctions for an overall malfunctions rate of 14.4%.

BARBER - PRESALE R 0128695

M/Seven LWT. .222 Caliber Stamped Nc and Follower vs. M/600 Stamped Follower Comparison Test

Report No. 822731

REPORT TEXT

- 1.) Five of the Stamped No-Bind Followers tested experienced a total of 45 malfunctions. For individual malfunction, see Appendix "A" Data Sheet No. 1.
- 2.) Four of the five M/600 Stamped Followers experienced 54 malfunctions. For individual malfunctions. See Appendix "A" Data Sheet No. 2.

TEST PROCEDURE

1.) Five (5) Stamped No-Bind Followers were assembled into the M/Seven LWT. .222 Caliber rifles, upon completion of this test, the 5 M/600 Stamped Followers were assembled into the M/Seven LWT. .222 caliber rifles.

2.) Field Function Test

• The Field Function Test was run at the Ilion Fish & Game Club Rifle Range. Five men were used to fire the rifles, incorporating the round robin system. Each man took 15 rounds of each ammotype and would fire 5 rounds each of Slow, Medium and Fast feed rate. The rifles were cooled every 15 rounds (able to hold barrel in hand). It was a one page Field Function Test.

3.) Ammunition

Ammunition used in the Field Function Test:

- Remington 50 gr. Pointed Soft Point
- Remington 50 gr. Hollow Point
- Remington 55 gr. Metal Case
- Federal 50 gr. Soft Point
- Winchester 50 gr. Pointed Soft Point

Test Rifles

Rifles used in the Field Function Test:

M/Seven LWT, .222 Caliber

- B6364423
- B6364417
- B6364418
- B6364428
- B6364421

"APPENDIX "A"

Data Sheets

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Report No. 822731	
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RESEARCH TEST & MEASUREMENT LAB WORK REQUEST

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	ARE	A OF TESTING
Developmental	Safety Related	Litigation
Design Acceptance	Competitive Evalua	ation Warehouse Audit
Pre-Pilot	New Design	Cost Reduction
Pilot	Design Change	Stake
Production Acceptance	Plant Assistance	Other
FIREARM STATS. MODEL: 7 LWT. CAL or GAGE: 222 BARREL TYPE: CARBINE	REPORT REQ'D. FORMAL TEST RESULTS	DATE REQUESTED: 9-30-82 DATE NEEDED BY: REQUESTED BY: 8UCLIS
PROOFED: YES VO	ONLY	WORK ORDER NO: 6-1856-000
	TECT 40/85	
_	TEST TYPE	
Strength Test Ammunition	_ 	
Function Test Environme		
Accuracy Test Customer	Complaint Endurance T	est
EXPLAIN IN DETAIL THE REASON FOR T	HIS TEST:	
WE WOULD LIKE AC	OMPARISON TEST	RUN ON THE
M/7 CWT. 222 C	#L18ER.	
•		FIREL ROUNLS
USING NEW, NO-	BIND FOLLOWERS.	
2. SAME TES,	7 USING OLD S	TAMPED FOLLOWER,
FAST, MEDIUM É		
-GUNS REQUIRED:	(40 B,ND)	
-GUNS REQUIRED: 5 -M 7LWT WITH	NEW, ÉOLD STA	IMPED FOLLOWERS
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NOTE: NO firearms or parts will be tested in	the Labe uples they are	DATE COMPLETED.
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REFROT NO.: 82273/ FAGE NO. 2

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REFROT NO.1 822731

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FIELD	CVCLE	TEST	 CENTERFIRE
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	SHOOTES		HO. GH	FIREME	TOTA TOWN STEELS.	DCM'T ELECT	E ALLEDO	I T'ROU	I ^B L	icii Sug	SHELL	POWER	oure o	बास	ICH ICH	साइस		TIMES	FOLLOW	LCADING	BOLZ O	ACCION BANG UP	DON'T EXTRACT	ज्ञास्त्र स्ट	ADJUSTMENTS	REPLACEMENTS		MALFUNCTIONS	Mr-8. R
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FIELD	CYCLE	TEST	_	CENTERFIRE

REPROT NO.1 82273/

PAUE NO. 2

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DI	SHCOTES	NO OF	FIELDIG	TOA POED SECTLE	Den't Erach	EOTE I. SIDC	ען דישוסנו	Int	icii Suq	S TIMES	POWER C	DON'T LOCK UP	मास्य	ICH	RICKE	1221	SHELL J	FOLLOWE	LOADING	BOLT OV	ACCION HANG UP	DOR'T EXTERCT	महास्य स्वतन्त्र	ADJUSTMENTS	REPLACEMENTS		MALFUNCTIONS	MF , RA1 21.28
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SUMMRY SHEET BY	1	SCHIME PERSON		SPERIL	13051	DON'T SECT SACK	DON'T LCCK OPEN	FR	ed om	STEIMS MAG.	VERRIDE	品品		et Civ	'em Mber	l	JUMPS MAG.	R BINIDS		दारस्रामा	याट ताह	TEACT	PO	E	MIN		ONS PER	. RATE PER
DI	SHOOTES	6 9	FIRES	Traes Coad Von	DON'T ELECT	H 1. 100	DON'T L	161	rcii Sug	SHELL S	POWER 0	DOM*** I.O.	FICH	CIM	RUSSE	1257	SHELL J	FOLLOWER	LCADING	BOLT OVERRIDE	ACTION B	DON'T EXTRACT	इस्ट्या स्वत्ह	ADJUSTMENTS	REPLACEMENTS		MALIFUNCTIONS PER	W-F. RATE
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FIELD	CYCLE	TEST	- CE	NTERFIRE

REFROT NO.1 822731

	MTE: regr	l'i'i'Le	: _ S	UMMA	RY 8	HEET	S PI	ER -	RIF	LE -	ΛM	10 T	YPE	- SH	OOTE	R				•	8	ERIA TTL.	L No	. E	763	64	42/	BARBE
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SUM:ARY SHEET BY		ROUNDS FTEE		PARTED SEELL		BACTS	DOR'T LOCK OPER	FE FR	om Ed	STEMS MAG.	呂			81	em Poen		SHELL JUMPS MAG.	R BINIS				uce					भ्रज्ञत	RATE PER 3128216 - BER
- 15 of 50 to 15 or 15 or 15 to 15 t	SECOLES	No. Oil	STEELS!	TON FOR	DOM'T ELECT	DON'T BLCS	ו בישכני		gnd		REMOR	an xoot Linco	HIER	TON	RICER	Teen	SHELL	FOLLOWE	LOADING	BOLT OVERRIDE	ACCION HANG UP	DORTE EXTERACT	BREAKAGES	ADJUSTMENTS	REPLACEMENTS		MALFUNCTIONS	M RA 61.2
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Model 7 LWT.

Col. 222

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MIN. T.OC.

B-6364417

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Report No.	<i>8</i> 2327	*

RESEARCH TEST & MEASUREMENT LAB WORK REQUEST

	<u>54</u>	EA OF TESTING
Developmental	Safety Related	Litication
Design Acceptance	Compatitive Eval	iuation Warenouse Audit
Pre-Pilot	New Design	Cost Reduction
Pilat	Design Change	Stake
Production Acceptance	Plant Assistance	Other
FIREARM STAT'S. MODEL: 7 400 CAL or GAGE: 2 2 2 BARREL TYPE: CA 2 3 PROOFED: YES	REPORT REQ'O. FORMAL TEST RESULTS ONLY	DATE REQUESTED:
	TEST TYPE	
Strength Test Ammunition	on Test Dry Cycle	Test Photo/Video
Function Test Environme	ntai Tast Measureme	nts Cther
Accuracy Test Customer	Complaint Endurance	Test
TV0. 1010 BCT 10 TUT 351501 TO0 T		
EXPLAIN IN DETAIL THE REASON FOR T	*	_
1. FEED É EVECT L	INE & PINESS X	POUNTS USING
· 100-3140 FOLLOWER	= m/600 mAG	, SP, 27115.
. 6:0		.,
•		
8 NO-BIND 11	É EXP. 2 2 6	TAD MAG. SP.
, 600 "		.,
-GUNS REQUIRED:		•
NOTT: NO See 111		0.55 20101 555 1 5 5 7
NOTE: NO firearms or parts will be tested in	·	TEST COMPLETED BY: Vidace
accompanied by a Work Request, an		
the Lass by the designer or engineer.	,	REPORT DATE:
to be filled out in datail. No Exception	ons.	

Test Results only

TO D Bullis

From J. Baggetta

Test THE

M 7 Lut 222 coliber evaluation of feeding and ejection of design mult stanged No. Bind Follower vs wisagam oud -M enizul - (Using M-600 magazine spring and experimental 2# Load magazine spring,

Test Results

The Following rifles had the experimental > 2# Load magazine spring assembled in them-

- · FOUR design No.1 stanged following No-Bind Following were fixed a total of 360 round (90 rounds epon) experiencing 48 malfunction for an overall malfunction rate of 13.3%.
- Four M-600 followers were fixed a total of 360 rounds (90 rounds each) experiencing 50 malfunctions for an overall malfunction rate of 13.9%.

The following ritles had the M-600 MASAZINE SGrinis
Assembled in them-

· Four design No. 1 Stpmped No-Bind follower were fired a total of 360 rounds (90 rounds

each) experiencing 66 mplfunctions for an overall malfunction rate of 18.3 %.

· Four M-600 followers were fired a total of 360 rounds (90 rounds each) experiencing 55 malfunctions for an overall malfunction rate of 15.3 %.

Rifles used In Field Function Test

M1-7Lwt 222 chiben

B 6364423.

B 6364418

B 6364422

B 6364421

JACK FUNCTION

REPROT NO. 1 82327/

PREVIOUS								MO										127	<u></u>			8	erla	L NO	۰				
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SUMMARY SHEE BY	T		ACCUMIS FIRED		SHELL	Erect	DON'T BLOW BACK	מאיי נסכג מפשם	FR	ED IOM	STEMS MAG.	OVERRIDE	B 1			'em Mden		JUMPS MAG.	a Binds		CRIDE	20 CE	TRACT	***	Ð	N. I.		CONS FEER RICHE DIL	
D1		SHOOTES	MO. CE	FIRENCE	CEST VOI	DOM'T E	H 11.500	עו די צוסט	18t	rcli Suq		POWER O	DON'T LOCK UP	HIGH	103	N TEST		SHELL J	FOLLOWER BINDS	LOADING	BOLT OVERRIDE	ACTION BANG UP	DOISTY EXTERNAL	BEEN TAGES	ADJUSTEMENTS	TEFFACEMENTS		MALETINCTIONS OVER-PIL	MALZ. SATE PER
B6364423			90	_	_	_			_					2.							2.0						-		24.4
B6364418			90											1	2				_		18	_		_			_	23,3	23.3
B 636442	_		90		-		-		-					2	2													5°.6	5.6
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Report No. 82327/

RESEARCH TEST & MEASUREMENT LAS WORK REQUEST

	<u>AF</u>	REA OF TESTING
Developmental	Safety Related	Litigation
Design Acceptance	Competitive Eva	luation Warehouse Audit
Pre-Pilot	New Design	Cost Reduction
Pilot	Design Change	Stake
Production Acceptance	Plant Assistance	Other
FIREARM STAT'S.	REPORT REQ'D.	
MODEL: 7/wr	FORMAL	DATE REQUESTED: 11-25-62
CAL or GAGE: 222		REQUESTED BY: 2 3 6 6 6 7 1
BARREL TYPE:CA PR	TEST RESULTS	
PROOFED: YESNO	ONLY	WORK ORDER NO: 1756-000
	TEST TYPE	
Strength Test Ammuniti		Test Photo/Video
Function Test Environme		· · · · · · · · · · · · · · · · · · ·
Accuracy Test Customer		
Accuracy rest Customer	Complaint Churanes	
EXPLAIN IN DETAIL THE REASON FOR T	HIS TEST:	
1. FEED & EVECT 6	,	
· 100-B1AD FORESON EX	= m/600 MAG	SPRING.
1.0	•	
- 0	→	* ;
6 NO-BIND 11	É EXP. 24 LO	110 MAG, SP.
, 600 11		er en en en en en en en en en en en en en
-GUNS REQUIRED:		
-GONS REQUIRED:		
·		
		,
NOTE: NO firearms or parts will be tested in	·	DATE COMPLETED:
accompanied by a Work Request, an	d both are delivered to	TEST COMPLETED BY:
the Labs by the designer or engineer.	. All Work Requests are	REPORT DATE:
to be filled out in detail. No Excepti	ons.	
	i	

FURD	er el	THOT	_	CENTERF IRE
TACK	ELLA	1 cdis	~ (

REPROT NO.1 82327/

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DESCRIPTIONS

"MILITIMETIONS" TTL. RIS. FIRED: 90
TTL. MALFUNCTIONS: 8
MALFUNCTION RATE: 8.9 % ROUNDS FEET SECTION FEED **STEM** SHELL JUMPS MAG. SHELL STEMS MAG. DON'T BLOW BACK CHAMBER DON'T LOCK OPEN POWER OVERRIDE FOLLOWER BINDS BOLT VELOCITIES BOLT OVERRIDE ACTION BANG UP DON'T EXTRACT FROM TRA PPED SHELL DOM'T LOCK UP REPLACEMENTS DOK'T EJECT ADJUSTEMENTS BREAKAGES MAG. **AMMUNITION** LOADING NO. GE PERMIT Ist 2nd Load Size RICER HIGH TEST S TVLCH YES R. 500, PSS <u>5</u> JB Slock oK JB Michiam 5 ٥K tacil R-306R HP 5 38 38 Slow OK 5 0 K Modium JB Enst Rossy Michal 2 Slow 53 TB 5 0 K Median te 1297 TOTAL (PER MAL.)

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CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER KINZER V. REMINGTON

BARBER - PRESALE R 0128762

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FIREARM STATS.	REPORT REQ'D.	!
MODEL: 74WT	. /	DATE REQUESTED: 1-21-83
CAL or GAGE: 222	FORMAL	DATE NEEDED BY: A CA.P.
BARREL TYPE:	TEST RESULTS	REQUESTED BY: 31665
PROCFED: YES VNO	ONLY	WORK ORDER NO: 2-1256-0
	TEST TYPE	
S		rde Test Photo/Video
Strength Test Ammunit		•
Accuracy Test Custome	r Complaint Endura	inca Test
EXPLAIN IN DETAIL THE REASON FOR	THIS TEST:	
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-GUNS REQUIRED:	: M7LWT MAG. S	(2 <u>60</u> (2 <u>60</u> <u>6</u> 6)
- GUNS REQUIRED:	M7LWT MAG. 5	PRING (LENCED)
	M7LWT MAG. 5	PRING (LENCED)
- GUNS REQUIRED:	M7LWT MAG. 5	PRING (LENCED)
-GUNS REQUIRED: FOUR TEST GUNS	2 6364423 8 6364422 8 6364421	PPING (LENCED)
- GUNS REQUIRED:	2 6364423 & 6364422 & 6364421 in the Labs unless they are	DATE COMPLETED: 1-31-73 TEST COMPLETED BY: Joe Canas

to be filled out in detail. No Exceptions.

## **BARBER - PRESALE R 0128764**

## REMINGTON ARMS COMPANY, INC.

Remington

Distribution: C. B. Workman

J. W. Brooks C. E. Ritchie

D. Bullis

"CONFINE YOUR LETTER TO ONE SUBJECT ONLY"_

RESEARCH TEST and MEASUREMENT REPORT - Report No. 830211 M/SEVEN LWT. .222 CALIBER STAMPED NO-BIND FOLLOWER DESIGN NO. 4. FUNCTION TEST.

Prepared by: J. Baggetta

Date Prepared: 1-31-83

Proofread and Cleared By:

C.E. Ritchie.

Sr. Supervisor - Testing,

Meas, & Mech. Analysis Lab

## TEST & MEASUREMENT LAB REPORT

REPORT NUMBER:	830211									
REPORT TITLE:	M/SEVEN LWT222 CALIBER STAMPED NO-BIND FOLLOWER DESIGN NO. 4,FUNCTION TEST.									
MODEL(S):	Seven LWT.									
GAUGE OR CALIBER:	.222									
DATE:	1-23-83									
WORK ORDER NO.:	C-1856-000									
PART NAME:	Follower									
DESIGNER/ENGINEER:	D. Bullis									
TEST TYPE:										
1.	PHOTO LAB									
2.	STRENGTH TEST - NO. OF GUNS TESTED									
3.	Function test - no. of guns tested4									
4.	ACCURACY TEST - NO. OF GUNS TESTED									
5.	MEASUREMENTS - TYPE:									
6.	ENVIRONMENTAL TEST									
7.	AMMUNITION TESTING & EVALUATION - TYPE:									
8.	VISUAL EVALUATION - OUT OF GUN SAMPLE									
9.	NO. OF GUNS TESTED: 4									
	NO. OF ROUNDS PER GUN: 126									
	TOTAL ROUNDS FIRED IN TEST: 504									
	AMMO TYPE: MAGS,; TARGET:_X									
	RIM FIRECENTER FIRE									

#### **BARBER - PRESALE R 0128766**

REMINGTON ARMS CO., INC.

Firearms Researcj Division

Report No. 830211

January 31, 1983

TO:

R. NIGHTINGALE

FROM:

J. BAGGETTA

REPORT TITLE:

M/SEVEN LWT. .222 CALIBER STAMPED NO-BIND FOLLOWER

**DESIGN NO. 4 FUNCTION TEST** 

### **ABSTRACT**

A work request was received from D. Bullis, Current Firearms Design, to evaluate the M/Seven LWT. .222 caliber Stamped No-Bind Follower Design No. 4.

## SCOPE OF TEST

To evaluate the feeding and ejection of the M/Seven LWT. .222 C.aliber Follower.

### TEST RESULTS

## A. Jack Live Round Unload Function Test

o Four M/Seven LWT. .222 caliber were live round unload tested a total of 504 rounds (126 rounds each) experiencing 14 malfunctions for an overall malfunction rate of 2.8%.

## B. Field Function Test

o Four (4) M/Seven LWT. .222 caliber were fired a total of 504 rounds (126 rounds each) experiencing 10 malfunctions for an overall malfunction rate of 2.0%.

M/Seven LWT. .222 Caliber Stamped No and Follower Design No. 4 Function Test.

## REPORT TEXT

- A. The following rifles experienced malfunctions during the Jack Live Round Unload Test in the R & D shooting room:
  - 1.) B6364423 Two stem chamber high
  - 2.) B6364421 Eight stem chamber left one stem chamber low.
  - 3.) B6364418 Two stem chamber right one stem chamber left
  - 4.) B6364422 One stem chamber right
- B. The following rifles experienced malfunctions during the Field Function Test at the Ilion Fish & Game Club rifle range:
  - 1.) B6364423 One stem chamber left one stem chamber right
  - 2.) B6364421 One stem chamber right one stem chamber left three stem chamber high
  - 3.) B6364418 One stem chamber right one stem chamber high
  - 4.) B6364422 One stem chamber left

#### TEST PROCEDURE

## A. Measurements

No measurements were taken.

#### B. Test Conditions

## Condition No. 1 - Indoor Jack Live Round Unload

- The test was run using the Test Lab Shooting Room Jacks.
- The rifles were loaded with 5 rounds in the magazine and one in the chamber.
- Various speed feeds were used such as: Slow, Medium and Fast.
- The rifles were live round unload tested only. No live firing was done in the jacks.

## Condition No. 2 - Ilion Fish & Game Club Outdoor Range

- The test was run using the Ilion Fish & Game Club rifle range.
- The rifles were loaded with 5 rounds in the magazine and 1 round in the chamber.
- Various speed feeds were used such as: Slow, Medium and Fast.
- Four shooters were used incorporating the round robin system.
- The weather was overcast, 320 and windy.

#### C. Ammunition

Ammunition used in Jack Live Round Unload and Field Function Test:

Remington 50 gr. Soft Point

Remington 50 gr. Hollow Point

Remington 55 gr. Metal Case

Federal 50 gr. Soft Point

Federal 55 gr. Metal Case Boat Tail

Winchester 50 gr. Soft Point

Winchester 55 gr. Metal Case

(Refer to Appendix "A" Data Sheet No. 1 for malfunction breakdown)

D. Rifles used in Field Function Test:

M/Seven LWT. .222 Caliber

B6364423

B6364421

B6364418

B6364422

Report No. 830211

"APPENDIX "A"

Data Sheets

# FIELD CYCLE TEST - CENTERFIRE

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Report No.	830211

## RESEARCH TEST & MEASUREMENT LAB WORK REQUEST

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Developmental	Safety Related	Litigation
Design Acceptance	Competitive Eva	uation Warehouse Audit
Pre-Pilot	New Design	Cost Reduction
Pilot	Design Change	Stake
Production Acceptance	Plant Assistance	Other
FIREARM STAT'S.  MODEL: 7 L W T  CAL or GAGE: 222  BARREL TYPE:  PROOFED: YES NO	FORMAL TEST RESULTS ONLY	DATE REQUESTED: 1-21-83  DATE NEEDED BY: A.S.A.P.  REQUESTED BY: BULUS  WORK ORDER NO: 6-1856-000
	TEST TYPE	
Strength Test Ammunition	on Test Dry Cycle	Test Photo/Video
Function Test Environme	ental Test Measureme	nts Other
Accuracy Test Customer	Complaint Endurance	Test
-	HIS TEST: & FIRED ROUNDS M7LWT MAG. SPRI	VSING TEST FOLLOWERS
-GUNS REQUIRED: FOUR TEST GUNS	B 6364423 B 6364422 B 6364421	
NOTE: NO firearms or parts will be tested in	the Labs unless they are	DATE COMPLETED:
accompanied by a Work Request, an	d both are delivered to	TEST COMPLETED BY:
the Labs by the designer or engineer.	All Work Requests are	REPORT DATE:
to be filled out in detail. No Exception	ons.	

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REPORT No. 53032 WO# 1856-000 D. BULLIS

Report No. 230322

RESEARCH TEST & MEASUREMENT LAB WORK REQUEST

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Pre-Pilot	New Design	Cost Reduction
?!lot	Design Change	Stake
Production Acceptance	Plant Assistance	Cther
FIREARM STATS.	REPORT REGIO.	
MODEL	FORMAL >	DATE REQUESTED:
CAL or GAGE: 223		DATE NEEDED BY:
BARREL TYPE: CARBINE	TEST RESULTS	REQUESTED BY: 1. 2012 415
PROOFED: YES V NO V	ONLY	WORK ORDER NO: /356-000
	TEST TYPE	
Strength Test Ammunition	on Test Dry Cycle 1	est Photo/Video
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EXPLAIN IN OSTAIL THE REASON FOR T	418 TEST: New Product	tecentance
THIS IS THE INTRODU	CTION OF A NEW	PEALIBER (223) TO THE
MITLUT LINE. WE	SHOULD TEST FO	R FUNCTION & ACCURACY.
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NOTE: NO firearms or parts will be tested in	the Labs unless they are	DATE COMPLETED: 2-11-33
accompanied by a Work Request, an	d both are delivered to	TEST COMPLETED BY: L. W. 11/and
the Labs by the designer or engineer.	All Work Requests are	REPORT DATE:
to be filled out in detail. No Exception	ens.	
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RESEARCH TEST and MEASUREMENT REPOR	
TEST RESULTS ONLY"	Prepared by: R. Williams Date Prepared: 2-11-83
Proofread and Cleared By:	
J.H. Hennings , R.E. Nightingale, Foreman-Test Lab Foreman-Measurement Lab	Signature Date
C.E. Ritchie, Sr. Supervisor - Testing, Mess. & Mess. Applymic Lab	Signature Date

TEST & MEASUREMENT LAB REPORT

REPORT NUMBER: 830322
REPORT TITLE: M 7LWT CAL 223 FUNCTION & ACCURACY EVALUATION
MODEL(S): SEVEN LWT
GAUGE OR CALIBER: 223
DATE: 2-11-83
WORK ORDER NO.: C-1856-1000
PART NAME:
DESIGNER/ENGINEER: D. BULLIS
TEST TYPE:
1. PHOTO LAB
2. STRENGTH TEST - NO. OF GUNS TESTED
3. FUNCTION TEST - NO. OF GUNS TESTED //
4. ACCURACY TEST - NO. OF GUNS TESTED
5. MEASUREMENTS - TYPE: STATIC
6. ENVIRONMENTAL TEST
7. AMMUNITION TESTING & EVALUATION - TYPE:
8. VISUAL EVALUATIONOUT OFGUN SAMPLE
9. ENDURANCE - NO. OF GUNS TESTED:
NO. OF ROUNDS PER GUN:
TOTAL ROUNDS FIRED IN TEST:
AMMO TYPE: MAGS; TARGET:
RIM FIRECENTER FIRE X

FEB. 11, 1983

REPORT No. 830322

"TEST RESULTS ONLY"

To: D. BULLIS

FROM: R. WILLIAMS

REPORT TITLE: M/7LWT CALLAS FUNCTION + ACCURACY EVALUATION

REASON FOR TEST

To evaluate the performance of the M/7 LWT introduced in the new CAL. 223.

TEST PROCEDURE

Load and Unload Cycle test was conducted in the Shooting Jacks in the Test Lab. Seven (7) types of ammo were used with Slow, Medium and Fast action cycle.

AMMUNITION REM. 55 Gr. P.S.P.
REM. 55 Gr. H.P.
REM. 55 Gr. M.Case

REM. 55 Gr. H.P. WIN. 55 Gr. S.P. WIN. 55 Gr. M. CASE
FEO. 55 Gr. S.P.

TEST RESULTS

Two (2) rifles had no maltunctions. The other eight (8) rifles had a maltunction rate of the following percent. 40%, 8.5%, 10.4%, 1.9%, 13.3%, 20%, 19% and 28.5% Due to the high maltunction Rate of Live Round Cycle Load & Unload Test, Further testing was stopped.

FED. 55 Br. M. CASE

Report No. 230522

RESEARCH TEST & MEASUREMENT LAB WORK REQUEST

	AR	ea of testing
Developmental	Safety Related	Litigation
Design Acceptance	Competitive Eval	uation Warehouse Audit
Pre-Pilot	New Design	Cost Reduction
Pilat	Design Change	Stake
Production Acceptance	Plant Assistance	Other
FIREARM STAT'S. MODEL: 7 LWT	REPORT REQ'D.	DATE REQUESTED: 2-1-83
MODEL:	FORMAL	DATE RECOESTED:
	TEST	REQUESTED BY: D. BULLIS
BARREL TYPE: CARBINE	RESULTS	WORK ORDER NO: C- 1856-000
PROOFED: YES V NO V		WORK ORDER NO: 2:7233000
	TEST TYPE	
Strength Test Ammunitie	on Test Dry Cycle '	Test Photo/Video
Function Test Environme	ental Test Measureme	nts Other
Accuracy Test Customer	Complaint Endurance	Test
EXPLAIN IN DETAIL THE REASON FOR T	HISTEST: New Product	Acceptance
THIS IS THE INTRODU	CTION OF A NEW	PEACIBER (223) TO THE
M/7 LWT LINE. WE	SHOULD TEST FO	R FUNCTION É ACCURACY.
. FEEDING E	UNCOADING LIVÉ	215.
erni E = 1 m 1 f	. UNCOADING LIVE ELECTION OF FI	eren RAS.
. JACK &	SHOULDER SHOT	T, NG
· ACCURA	C 7	
· ACTIONS CO	ONTAIN #4 M	4G FOLLOWER
-GUNS REQUIRED: -NEED PROOF	NA	All auns are
7600143 7600154	PRACEEN -	7600152 All guns are 7600155 7600158
7600150 7600156 7600151 7600157	, , , , , ,	7600155
74001 5 1 74001 57 74001 53		7800.230
NOTE: NO firearms or parts will be tested in	the Labs unless they are	DATE COMPLETED:
accompanied by a Work Request, an		TEST COMPLETED BY:
the Labs by the designer or engineer.	j	REPORT DATE:
to be filled out in detail. No Exception	,	

JACK	ENDURANCE	CENTERF IRE

REPROT NO.: 830322

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JACK	ENDURANCE	CENTERFIRE

REPROT NO.: 830344

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FIELD CYCLE TEST - CENTERFIRE

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BARBER - PRESALE R 0128804, 2529792

TAUE NO.__

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TOTAL (TER MAL.) [_

Report No. 830322

RESEARCH TEST & MEASUREMENT LAB WORK REQUEST

	<u>AF</u>	REA OF TESTING
Developmental	Safety Related	Litigation
Design Acceptance	Competitive Eva	luation Warehouse Audit
Pre-Pilot	V New Design	Cost Reduction
Pilot	Design Change	Stake
Production Acceptance	Plant Assistance	Other
FIREARM STAT'S.	REPORT REQ'D.	·
MODEL: 74WT		DATE REQUESTED: 2 - 1- 83
CAL or GAGE: 223	FORMAL	DATE NEEDED BY:
BARREL TYPE: CARBINE	TEST RESULTS	REQUESTED BY: D. BULLIS
PROOFED: YES V NO V	ONLY	WORK ORDER NO: <u>C- 1856-000</u>
	TEST TYPE	
Strength Test Ammunition	on Test Dry Cycle	Test Photo/Video
Function Test Environme	ntal Test Measurem	ents Other
Accuracy Test Customer	Complaint Endurance	Test
EXPLAIN IN DETAIL THE REASON FOR T	HISTEST: New Product	Accentusce
		U CACIBER (223) TO THE
M/7LWT LINE. WE	SHOULD TEST FO	OR FUNCTION & ACCURACY.
FEEDING E	UNCOADING LIVÉ	RUS.
FIRMS	ELECTION OF FI	4 7 7
· FEEDING, 1 &	EJECTION OF FI	RED RUS.
JACK É	SHOULDER SHOO	TING
· ACCURA	CY	
· ACTIONS CO	ONTAIN # 4 M	AG FOLLOWER
		·
-GUNS REQUIRED: -NEED PROOF	NA	7600152 All guns are with D. Bullis
7600143 7600154 7600150 7600156	PROOFED.	7600152 WITH D. Bullis 7600158
7600151 7600157		7600.158
76001 53		
NOTE: NO firearms or parts will be tested in	the Labs unless they are	DATE COMPLETED:
accompanied by a Work Request, an	d both are delivered to	TEST COMPLETED BY:
the Labs by the designer or engineer.	All Work Requests are	REPORT DATE:
to be filled out in detail. No Exception	ons.	-

BARBER - PRESALE R 0128806

	CHRONOLOGICAL REC	CORD OF TESTING	REPORT #830322
	MODEL & DESCRIPTION M-71WT	CAL. 223	
	CALIBER OR CAUGE FUNCTION +		
DATE		TES	
2-8-83			
	Test Lab by Scott Fran	_	
	taken by R. Williams on all		<i>'</i>
2-11-83	TEST was stopped	because of	high malfunction
	Pate of Live Round Load	d + Unload	Test Cycle
			/
_			
			
			

SHOTGUIS, JENER	RETERS, REFERENCE & AUTOLOADETS)
CAL, ASS	TEST PROCEDURE SHEET Model SEVEN Served No. 7600152
Headspace as Received:	Safe - "ON" - I "OFF" - I
Proof: YES Emadatace after Proof: Min. 7.002	2 2 3 3
Firing Pin Indent(in.) 021 2. 0225 3. 0215	Bolt Cten Force(lbs.) Cocked: I Dry Fired: I 2 2 3 3
Triager Pull(15s.) 5. 3.75 2. 3.75 3. 3.75	301t Release Force(lbs.) 2 3
Gun Length:	Primer Marking:
Gun Weight:	Safety Check:
Center of Gravity:	Firing Pin Protrusion:
Scre:Choke:	Pattern Test (Avg. of 5) Group Size: Horz.:
Bolt Closing Velocity:	Vert.:
Magazine Spring Force: Disconnector Check:	Accuracy (Avg. of 5) Group Size: Horz.:
	Vert.: P.O.I.:_
I-IZ-62	• Tester and Date: 1. Williams 2-8-83

SHOTOURS, CENTER THES, REFERENCE /FORE & AUTOLOADERS'

	Model SEVEN QUN Q
	Serval No. 7600/58
Headspace as Received:	Safe - "ON" - I
Proof: YES Headspace after Proof: Min. 7:004	2 2 3 3
Firing Pin Indent(in.) 1022 2022 3022	Bolt Cpen Force(lbs.) Cocked: I Dry Fired: I 2 2 3 3
Trisger Pull (lips.) I. 2.75 2.2.75 3.2.75	3
Gun Length:	Primer Marking:
Gun Weight:	Safety Check:
Center of Gravity:	Firing Pin Protrusion:
3cre:	
Choke:	Pattern Test (Avg. of 5)
Orifice Size:	Group Size:
Bolt Closing Velocity:	Horz.:
Magazine Spring Force:	Vert.:
Disconnector Check:	Accuracy (Avg. of 5)
	Group Size:
	-
cjs	• Tester and Date: Khilliams
I-I2-82	2-8-83

SECTIONS, CONTRACTOR, SECTIONS / FINES & AUTOLOGISMS

	Model SEVEN QUN S
	Serial No. 7600/55
Headstace as Received:	Safa - "ON" - I "ONE" - I
Proof: YES	2 2 3
Headspace after Proof: Min.t.001	
Firing Fin Indent(in.)	Bolt Cpen Force(lbs.)
=. <u>.0195</u>	Cocked: I. Dry Fired: I.
2. 0/95	2
3. 10205	3
Trigger Pull(lbs.)	Bolt Release Force(lbs.)
<u> </u>	
2.4.0	2
3. <u>375</u>	3
Jun Length:	Primer Marking:
Fun Weight:	Safety Check:
Center of Gravity:	Firing Pin Protrusion:
Bore:	Pattern Test (Avg. of 5)
Thoke:	Group Size:
rifice Size:	Hor2.:
Solt Closing Velocity:	Vert.:
Megazine Spring Force:	Accuracy (Avg. of 5)
risconnector Check:	Group Size:
	Rorz.:
	Vert.: 7.0.I.:
JS -12-82	• Tester and Date: KWilliams
-12-US	2-8-83

SHOTOURS, CENTERFIELS, REFERES (FIRES & AUTOLOADERS)

TIST PROCEDURE SHEET

	Model SEVEN GUN (4)
	Servai IIc. 7600150
Headapace as Received: Min. + 001	3a2a - "OX" - I "OXT" - I
Proof: Yes Headstace after Proof: Minton	2 2 3 3
Firing Pin Indent(in.) I022 2022 3022	Bolt Cpen Force(lbs.) Cocked: I Dry Fired: I 2 2 3 3
Triager Pull(liss.) 1. 3.0 2. 3.0 3. 3.0	3 3
Gun Length:	Primer Marking:
Gun Weight:	Safety Check:
Center of Gravity:	Firing Pin Protrusion:
3cre:	<u>Pattern Test</u> (Avg. of 5)
Choke:	Group Size:
Orifice Size:	Horz.:
Bolt Closing Velocity:	Vert.:
Magazine Spring Force:	Accuracy (Avg. of 5)
Disconnector Check:	Group Size:
	Horz.:
	Vert.: P.O.I.:_
CJS I-12-82	Tester and Date:

SHOUGUIS, CENTERFEES, REFERENCES / FIRES & AUTOLOADERS !

SEVEN GUIV 5
-21 To. 7600151
Safe - "ON" - I "ONE" - I
2
3
· · · · · · · · · · · · · · · · · · ·
Bolt Open Force(lbs.)
Cocked: I. Dry Fired: I.
2
3
Bolt Release Force(lbs.)
ž
2
3
Primer Warking:
Safety Check:
Firing Pin Protrusion:
Between Team (1 mm and 5)
Pattern Test (Avg. of 5)
Group Size:
Hor2.:
Vert.:
Accuracy (Avg. of 5)
Group Size:
Horz.:
Vert.:
• Tester and Date: KWilliams

2-8-83

SHOOGUIS, CONTERFERES, REFERES (FOVES & AUTOLOADERS)

	Hadel SEVEN GUN 6
	10del <u>SEVEN</u> GUN 6) Serval III. 7600157
M'a. + aa	
Headstace as Received: Min.t.00	-
Proof: Yes	
Headstace after Proof: Mint, 0	3· 3
	Bolt Open Force(lbs.)
Firing Pin Indent(in.)	Cocked: I. Dry Fired: I.
=. 1021	2
2. <u>1021</u>	3
3. 10215	
Trigger Pull(lbs.)	Bolt Release Force(lbs.)
<u> </u>	I
2. 4.25	2
3. <u>4. 0</u>	3
Gun Length:	Primer Marking:
Gun Weight:	Safety Check:
Center of Gravity:	Firing Pin Protrusion:
Bore:	Pattern Test (Avg. of 5)
Choke:	
Orifice Size:	Group Size:
Bolt Closing Velocity:	Rorz.:
Magazine Spring Force:	Vert.:
Disconnector Check:	Accuracy (Avg. of 5)
	Group Size:
	Herz.:
	Vert.: P.O.I.:
CJS I-I2-82	• Tester and Date: KN illiams
	2-8-93

SHOTOUTS, CENTERETES, REFERES (FORMS & AUTOLOADETS)

	SEVEN GUN (7)
Lebel: 2	SEVEN GUN
Se <u>rtal</u>	::o. 7600156
Headspace as Received: Min. +:001	Safe - "GF" - I "GFF" - I
Proof: Yes	2 2 3 3
Headspace after Proof: Min.t.002	
Firing Pin Indent(in.)	Bolt Coen Force(lbs.)
I022	Cocked: I Dry Fired: I
2 0 2 2	2
30215	3
Trigger Pull (Ds.)	Bolt Release Force(Ibs.)
=. 4.25	Ī.
2. <u>4.5</u>	2
3. <u>4.5</u>	3
Gun Length:	Primer Marking:
Gun Weight:	Safety Check:
Center of Gravity:	Firing Pin Protrusion:
3ore:	Pattern Test (Avg. of 5)
Choke:	Group Size:
Orifice Size:	
Bolt Closing Velocity:	Horz.:
Magazine Spring Force:	Vert.:
Disconnector Check:	Accuracy (Avg. of 5)
	Group Size:
	Horz.:
	Vert.: P.O.I.:
CJS I-12-82	• Tester and Date: <u>F.W. illiams</u> 2-8-83
	2-8-83

SHORDING, CONTROL TOTAL CONTROL & ACTOLOGICAL

	TEST FROCEDURE SHEET
	Madel SEVEN GUN 8
	Serial II. 7600149
Headstace as Received: Min. T. 00)	Safe - "ON" - I "OFF" - I
<u>y 25</u>	2
Headspace after Proof: Min. + 00)	3
Firing Pin Indent(in.)	Bolt Open Force(lbs.)
=.,022	Cocked: I Dry Fired: I
20215	2
	3
3. 1022	
<u>Trigger Pull</u> (lbs.)	Bolt Release Force(lbs.)
= 3.5	
2. <u>3</u> . 5	2
3.3.25	3•
Gun Length:	Primer Marking:
Gun Weight:	Safety Check:
Center of Gravity:	Firing Pin Protrusion:
3ore:	
Choke:	Pettern Test (Avg. of 5)
Orifice Size:	Group Size:
Bolt Closing Velocity:	Horz.:
Agazine Spring Force:	Vert.:
Disconnector Check:	Accuracy (Avg. of 5)
	Group Size:
	Horz.:
	Vert.: P.O.I.:_
:J5 :-I2-82	• Tester and Date: R. Williams
-16-06	2-8-183

SHOUGHE, CHIMINGTON, RIGHTS (FILES & AUTOLANTIS)

	Madel SEVEN (4)
	Serial No. 7600153
Headstace as Received: Min. t.001	Safe - "OH" - I "OFF" - I
Proof: Yes	2
Headspace after Proof: /Yin.t.00	3
Firing Pin Indent(in.) 10225 2022 3023	3 3 3
Trigger Pull (lbs.)	Bolt Release Force (lbs.)
<u> </u>	I.
2. <u>3 5</u>	2
3. <u>3. 75</u>	3
Gun Length:	Primer Marking:
Gun Weight:	Safety Check:
Center of Gravity:	Firing Pin Protrusion:
3ore:	Patraces Tare (Assert 12 T)
Choke:	Pattern Test (Avg. of 5)
Orifice Size:	Group Size:
Bolt Closing Velocity:	Horz.:
Magazine Spring Force:	Vert.:
Disconnector Check:	Accuracy (Avg. of 5)
	Group Size:
	Horz.:
	Vert.:
CJS I-12-82	• Tester and Date: RWilliams
a 200 - Via	2-8-43

	1331 19003003 37331
	Model SEVEN GUN (10)
	Serval III. 7600154
Headspace as Received: Min.t.a	01 Safe - "CN" - I "CEF" - I
7	2 2
Proof: YEJ Essassace siter Proof: Min. to	3
Headstace siter Frooi: //////	
Firing Fin Indent(in.)	<pre>3clt Cpen Force(lbs.) Cocked: I Dry Fired: I</pre>
=P215	
2.10215	2
3.1022	3
Trigger Pull(lbs.)	Bolt Release Force(lbs.)
I. 3.5	I.
2. 3 . 5	2
3. 3 . 75	3
Gun length:	Primer Marking:
Gun Weight:	Safety Check:
Center of Gravity:	Firing Pin Protrasion:
Bore:	Dattern Mast (Arm of 5)
Choke:	Pattern Test (Avg. of 5) Group Size:
Driftce Size:	Group Size:
Bolt Closing Velocity:	Vert.:
Magazine Spring Force:	
Disconnector Check:	Accuracy (Avg. of 5)
	Group Size:
	Horz.:
:.s	Vert.: P.O.I.:

2-8-83

BARBER - PRESALE R 0128818

REMINGTON ARMS COMPANY, INC. INTER-DEPARTMENTAL CORRESPONDENCE Remington PETERS "CONFINE YOUR LETTER TO ONE SUBJECT ON		Sis m buzon: -	C. B. Workman J. W. Brooks C. E. Ritchie T. J. Plunkett
RESEARCH TEST and MEASURE MENT REPO		970041 DUM EL COD BI	AME DEGICAL
M/SEVEN LWT308 CALIBER - NEW MACH EVALUATION (SPRING LOA			ATE DESIGN
_			
_	Prepared by:	J. Baggetta	
	Date Prepared:	2-1-83	
•			
Prociread and Cleared By:			
J.H. Henrings . R.E. Michringale.			<u> </u>
J.H. Hennings , R.E. Mightingale, Foreman-Test Lab Foreman-Measurement Lab	56	Mej hein	7/2. 2-21-53
	Signature		Pars
C.E. Ritchie.	•	-	-
Sr. Supervisor · Testing,	Signature		Date

Meas. & Mech. Analysis Lab

TEST & MEASUREMENT LAB REPORT

REPORT NUMBER:	830241
REPORT TITLE:	M/Seven LWT308 Caliber — New Machined 6061 Aluminum Floor Plate Des
MODEL(S):	Evaluation (Spring Loaded Ball Type Latch Design) M/Seven LWT.
GAUGE OR CALIBER:	.308
DATE:	1-24-83
WORK ORDER NO.:	C-1856-000
PART NAME:	Latch
DESIGNER/ENGINEER	: T. J. Plunkett
TEST TYPE:	
1.	PHOTO LAB
2.	STRENGTH TEST - NO. OF GUNS TESTED
3.	function test - no. of guns tested3
4.	ACCURACY TEST - NO. OF GUNS TESTED
5.	MEASUREMENTS - TYPE: Headspace
6.	ENVIRONMENTAL TEST
7.	Ammunition testing & evaluation - Type:
8.	VISUAL EVALUATION - OUT OF GUN SAMPLE
9.	ENDURANCE - NO. OF GUNS TESTED:3
	NO. OF ROUNDS FER GUN: 30
	total rounds fired in test: 90
-	AMMO TYPE: MAGS; TARGET:

RIM FIRE CENTER FIRE X

February 1, 1983

TO:

R. NIGHTINGALE

FROM:

J. BAGGETTA

REPORT TITLE:

M/SEVEN LWT. .308 CALIBER - NEW MACHINED 6061 ALUMINUM FLOOR PLATE

EVALUATION (SPRING LOADED BALL TYPE LATCH DESIGN)

ABSTRACT

A request was received from T. Plunkett, Current Firearms Design, to evaluate the M/Seven LWT., redesigned Floor Plate Latching System. (Spring Loaded Ball Type Design.)

SCOPE OF TEST

To evaluate the performance of the redesigned M/Seven LWT. - .308 Caliber Floor Plate Latching System checking the floor plate latch opening on recoil.

TEST RESULTS

A. Jack Live Round Fire Function Test

o Three M/Seven LWT. .308 caliber rifles were fired a total of 45 rounds (15 rounds each) experiencing no malfunctions.

B. Field Function Test

o Three M/Seven LWT. .308 caliber rifles were fired a total of 90 rounds (30 rounds each) experiencing no malfunctions.

BARBER - PRESALE R 0128821

M/Seven LWT. .308 Caliber — New Machined 6061 Aluminum Floor Plate Design Evaluation (Spring Loaded Ball Type Latch Design)

Report No. 830241 Page 2

REPORT TEXT

Three (3) M/Seven LWT. .308 caliber rifles with the redesign latch (spring loaded ball-type design) were fired a total of 90 rounds (30 rounds each) experiencing no malfunctions.

TEST PROCEDURE

A. Measurements

Headspace — (Refer to Appendix "A" Data Sheet No. 1.

B. Test Conditions

Condition No. 1 - Indoor Jack Shooting

- The test was run using the Test Lab shooting room jacks.
- The rifles were loaded with 4 rounds in the magazine and one in the chamber.
- Various speed feeds were used such as: Slow, Medium and Fast.

Condition No. 2 - Ilion Fish & Game Club Outdoor Range

- o The test was run using the Ilion Fish & Game Club Rifle Range.
- o The weather was overcast, 320 and windy.
- o The rifles were loaded with 4 rounds in the magazine and 1 in the chamber.
- o Various speed feeds were used such as: Slow, Medium and Fast.
- o Four shooters were used incorporating the round robin system.

C. Ammunition

Indoor Jack Shooting

o Winchester - 200 gr. Silver Tip

Field Function Test

- o Remington 180 gr. Soft Point
- o Winchester 200 gr. Silver Tip

D. Rifles Used In Test

M/Seven LWT. .308 Caliber

7600139

B6226256

7600050

BARBER - PRESALE R 0128822

M/Seven LWT. .308 Caliber - New Machined 6061 Aluminum Floor Plate Design Evaluation (Spring Loaded Ball Type Latch Design)

Report No. 830241 Page 3

REPORT TEXT - cont'd.

E. Hi-Speed Movies

- Hi-Speed movies were previously taken of this design showing latch motion by Test Lab personnel in the Photo Lab Room.
- o Hi-Speed movies can be reviewed in the Photo Lab Room.

F. Photos

- o Pictures were taken of the redesigned M/Seven LWT. .308 caliber rifle. (Refer to Appendix "A" Data Sheet No. 2.)
- o Pictures were taken of the old style latch M/Seven LWT. .222 caliber rifle. (Refer to Appendix "A" Data Sheet No. 2.)

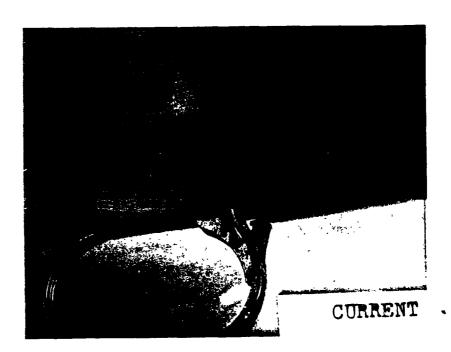
APPENDIX "A"

DATA SHEETS

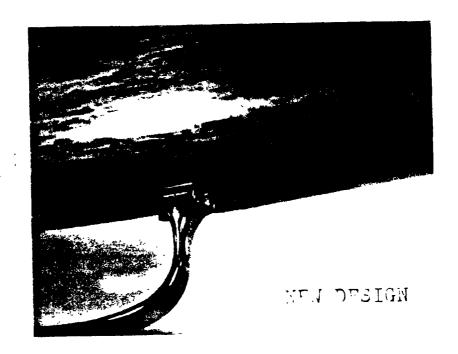
A A Martin Committee and the second committee	Keport	,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,
M-7 Lut 308 Caliber Rode	sien	LAtch
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=	Measurements	He ~ -1			2 ====		≅ 3 ====	1	= 4 ====	5 <u></u>	J.A.C
	1 ICH SUPERINT	Sence			 -					 	
	Gun#	Min +	•					-			-
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M-7 Lut .222 caliber



M.7 Lut 308 chliber



BARBER - PRESALE R 0128826

10-46-4 REMINISTON ARMS COMPANY, INC. Discribution: C. B. Workman J. W. Brooks INTER-DEPARTMENTAL CORRESPONCENCE C. E. Ritchie T. J. Plunkett Remineton "CONFINE YOUR LETTER TO ONE SUBJECT ONLY"_ RESEARCH TEST and MEASUREMENT REFORM - Report No. 970041 M/SEVEN LWT. .308 CALIBER - NEW MACHINED 6061 ALUMINUM FLOOR PLATE DESIGN EVALUATION (SPRING LOADED BALL TYPE LATCH DESIGN) Frenared by: J. Baggetta Data Prepared: 2-1-83 Precirate and Cared By: C.E. Ritchie.

Signature

Sr. Supervisor - Testing,

Meas. & Mech. Analysis Lab

Date

TEST & MEASUREMENT LAB REPORT

REPORT NUMBER:	830241
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PART NAME:	Latch
DESIGNER/ENGINEER	: T. J. Plunkett
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2.	STRENGTH TEST - NO. OF GUNS TESTED
3.	function test - no. of guns tested3
4.	ACCURACY TEST · NO. OF GUNS TESTED
5.	MEASUREMENTS - TYPE: Headspace
6.	ENVIRONMENTAL TEST
7.	Ammunition testing & Evaluation - Type:
8.	VISUAL EVALUATION - OUT OF GUN SAMPLE
9.	ENDURANCE - NO. OF GUNS TESTED: 3
	NO. OF ROUNDS PER GUN: 30
	TOTAL ROUNDS FIRED IN TEST: 90
	AMMO TYPE: MAGS; TARGET:

February 1, 1983

TO:

R. NIGHTINGALE

FROM:

J. BAGGETTA

REPORT TITLE:

M/SEVEN LWT. .308 CALIBER - NEW MACHINED 6061 ALUMINUM FLOOR PLATE

EVALUATION (SPRING LOADED BALL TYPE LATCH DESIGN)

ABSTRACT

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B. Field Function Test

Three M/Seven LWT. .308 caliber rifles were fired a total of 90 rounds (30 rounds each) experiencing no malfunctions.

BARBER - PRESALE R 0128829

M/Seven LWT. .308 Caliber — New Machined 6061 Aluminum Floor Plate Design Evaluation (Spring Loaded Ball Type Latch Design)

Report No. 830241

Page 2

REPORT TEXT

Three (3) M/Seven LWT. .308 caliber rifles with the redesign latch (spring loaded ball-type design) were fired a total of 90 rounds (30 rounds each) experiencing no malfunctions.

TEST PROCEDURE

A. Measurements

o Headspace - (Refer to Appendix "A" Data Sheet No. 1.

B. Test Conditions

Condition No. 1 - Indoor Jack Shooting

- o The test was run using the Test Lab shooting room jacks.
- o The rifles were loaded with 4 rounds in the magazine and one in the chamber.
- o Various speed feeds were used such as: Slow, Medium and Fast.

Condition No. 2 - Ilion Fish & Game Club Outdoor Range

- o The test was run using the Ilion Fish & Game Club Rifle Range.
- o The weather was overcast, 320 and windy.
- o The rifles were loaded with 4 rounds in the magazine and 1 in the chamber.
- o Various speed feeds were used such as: Slow, Medium and Fast.
- o Four shooters were used incorporating the round robin system.

C. Ammunition

Indoor Jack Shooting

o Winchester - 200 gr. Silver Tip

Field Function Test

- Remington 180 gr. Soft Point
- o Winchester 200 gr. Silver Tip

D. Rifles Used In Test

M/Seven LWT. .308 Caliber

7600139

B6226256

7600050

BARBER - PRESALE R 0128830

M/Seven LWT. .308 Caliber - New Machined 6061 Aluminum Floor Plate Design Evaluation (Spring Loaded Ball Type Latch Design)

Report No. 830241 Page 3

REPORT TEXT - cont'd.

E. Hi-Speed Movies

- Hi-Speed movies were previously taken of this design showing latch motion by Test Lab personnel in the Photo Lab Room.
- o Hi-Speed movies can be reviewed in the Photo Lab Room.

F. Photos

- Pictures were taken of the redesigned M/Seven LWT. .308 caliber rifle. (Refer to Appendix "A" Data Sheet No. 2.)
- o Pictures were taken of the old style latch M/Seven LWT. .222 caliber rifle. (Refer to Appendix "A" Data Sheet No. 2.)

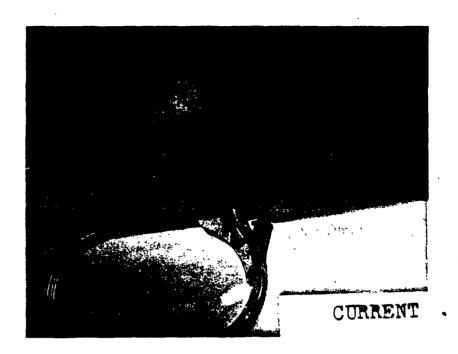
APPENDIX "A"

DATA SHEETS

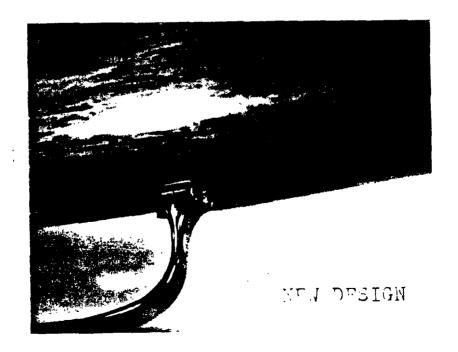
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M-7 Lut 308	Caliber	Redesign	LAtch

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M-7 Lut , 222 caliber



M.7 Lut 308 chliber



APPENDIX "A"

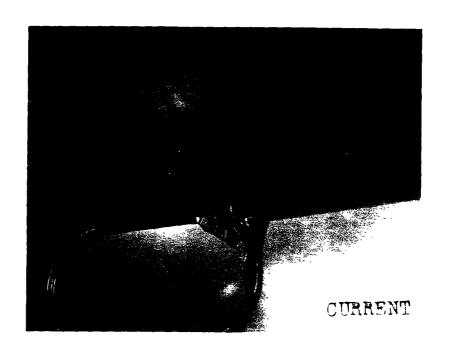
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	M-7 Lut	.308	Caliber	Redesign	LAtch
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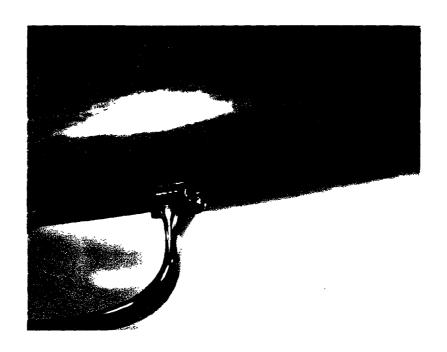
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Pata Sheet # 2

M-7 Lut ,222 caliber



M.7 Lut 308 chliber



SHOTGUIS, CENTERFIERS, RIGHTES (FUNES & AUTOLOADERS)

TEST PROGREUPE SHEET

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	Serial To.B 622 6256
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Proof:	3 3
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3. <u> </u>	
Trigger Pull(Ups.)	Bolt Release Forma(lbs.)
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2	2
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Gum Weight:	Safety Check:
Center of Gravity:	Firing Pin Protrusion:
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Choke:	Pattern Test (Avg. of 5)
Orifice Size:	Group Size:
Bolt Closing Velocity:	Horz.:
Magazine Spring Force:	Vert.:
Disconnector Check:	Accuracy (Avg. of 5)
	Group Size:
	Horz.:
	Vert.:
CJS I-IZ-82	Tester and Date:

SHOUGHIS, CENTERFIRES, RIGHTES (FUVES & AUTOLOADERS)

	1121 LEPOTOTT SETT	
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	Serial No. B 7600139	
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Gun Length:	Primer Marking:	
Gun Weight:	Safety Check:	
Center of Gravity:	Firing Pin Protrusion:	
Bore:	Takham Mash (Assa sa a)	
Choke:	Pattern Test (Avg. of 5)	
Orifice Size:	Group Size:	
Bolt Closing Velocity:	ior2.:	-
Magazine Spring Force:	Vert.:	•
Disconnector Check:	Accuracy (Avg. of 5)	
	Group Size:	
	Horz.:	
	Vert.:	P.O.I.:_
cjs I-I2-82	Tester and Date:	

SHOUGHTS, CHITTHERES, RESERVES (STREET, AUTOLUARIES)

TEST FROCEDURE SHEET

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Trigger Pull(Uss.)	Bolt Release Force(lbs.)	
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Gun Length:	Primer Marking:	_
Gun Weight:	Safety Check:	
Center of Gravity:	Firing Pin Protrusion:	
3ore:	Pattern Test (Avg. of 5)	
Choke:	Group Size:	
Orifice Size:	Horz.:	
Bolt Closing Velocity:		
Magazine Spring Force:	Vert.:	
Disconnector Check:	Accuracy (Avg. of 5) Group Size:	
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JACK ENDURANCE - SHOTGUNS	83		Trues Chicago	I.											
ENDO	2.8		BING	Į	OK	ok	OK		_						
CK	rie		CERTE SCHING FIRED	N	5	5	7								
5	mte: /-25- 83 test title: <u>(/ac</u>		HOOTESE	s	5	6	4								
	PREVIOUS DAT ROUNDS TES		amúnition Lord 81ze		308 WID. 5	ly								TOTAL (PER MAL.)	
معدرتات شاهده	PREVIOUR	/	Aladin	-	368 12		-			··				 TOTAL	

		*
<u> </u>		Report No. 830241
RESEARCH TES	T & MEASUREMENT LAB WORK RE	EQUEST
	4.05	14.05 TESTINO
Sandarana		EA OF TESTING
Developmental Design Acceptance	Safety Related	Litigation Marehouse Audit
Pre-Pilot	New Design	Cost Reduction
Pilot	Design Change	Stake
Production Acceptance	Plant Assistance	Other
FIREARM STAT'S.	REPORT REQ'D.	
MODEL: 2 LWT	FORMAL X	DATE REQUESTED: 1/24/03
CAL or GMSE:	TEST	DATE NEEDED BY: ASAR
BARREL TYPE:	RESULTS	REQUESTED BY: TT. PLUNKETT
CHECK HEADSTACK NO	ONLY	WORK ORDER NO:
	TEST TYPE	C-1856-000
Strength Test Ammuniti	on Test Dry Cycle T	est Yhoto/Video-H1-57662
Function Test Environme	ental Test Measuremen	Other
Accuracy Test Customer	Complaint Endurance ?	Test
FUNETIONS TESTINE, FLOOR PLATE IS S A- AMMO WHICH CA TO BE USED PL TEST INFORMATIO	THI SPEED MOUIES IF REDESIEN OF ATIS FRETORY, USED LATCHING US ANY OTHER WIS ON. ELT AND AFTER I TACK TO JUSTIF	IN PRIOR TESTIME FIRM WILL GIVE US IN' SPIERD MOUNES, ISINE I FURTHER TESTIME
MOTE: NO firearms or parts will be tested in accompanied by a Work Request, and the Labs by the designer or engineer to be filled out in detail. No Except	n the Labs unless they are and both are delivered to	DATE COMPLETED:TEST COMPLETED BY:REPORT DATE:
1	i	

M- Seven cut mamos 2-21-8

Function Test Floor Pikto

Regart No. 830521

REMINGTON ARMS COMPANY, INC. Distribution: T. Plunkett	•
Remington PETERS	
"CONFINE YOUR LETTER TO ONE SUBJECT ONLY" "Test Results only" RESEARCH TEST and MEASUREMENT REPORT - Report No. 830521 M- Seven Lut 7 MIMO8 Function Test-(Floor Plate)	
Prepared by: J. Bagetta Date Prepared: 2-22-83	
•	
Proofread and Cleared By:	
J.H. Hennings , R.E. Nightingale, Foreman-Test Lab Foreman-Measurement Lab Signature Date	
C.E. Ritchie, Se Supervisor - Testing Signature Date	

Meas. & Mech. Analysis Lab

TEST & MEASUREMENT LAB REPORT

REPORT NUMBER:	83027	1		
REPORT TITLE: "	1-2evcn	Lut 7MMOK	Function Test-	(12100 PIATC)

MODEL(S): Seven

GAUGE OR CALIBER: 7 MM O 8

DATE: 2-21-83

WORK ORDER NO.: C-1852-000

PARTNAME: Floop PIFTE

DESIGNER/ENGINEER: T. Plunkett

TEST TYPE:

1.	PHOTO LAB
2.	STRENGTH TEST - NO. OF GUNS TESTED
3.	FUNCTION TEST - NO. OF GUNS TESTED
4.	ACCURACY TEST - NO. OF GUNS TESTED
5.	MEASUREMENTS - TYPE:
6.	ENVIRONMENTAL TEST
7. ·	AMMUNITION TESTING & EVALUATION - TYPE:
8.	VISUAL EVALUATIONOUT OFGUN SAMPLE
9.	-ENDURANCE - NO. OF GUNS TESTED:
	NO. OF ROUNDS PER GUN:
	TOTAL ROUNDS FIRED IN TEST: 60
	TOTAL ROUNDS FIRED IN TEST:; TARGET:;

TO T. Plunkett

From J. Baggetta

Test Title

M- Seven Lut 7mm 08 Function Test- (Floor Plate)

Test Results

Field Function Test

- · Gun No. 7600118 Fixed 40 rounds at various speed rate (slow, medium, fast) experienced no malfunctions. Note-magazine would only take three rounds instead of four rounds.
- CUN No. 7600122-Fixed 20 rounds at uprious speed rate (810m, medium, fast) experienced 12 bolt override for and overall malfunction rate at 60.0%. Note magazine would only take three rounds instead at four rounds. Stopped test after 20 rounds due to excessive malfunctions.

eport No.	730521
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RESEARCH TEST & MEASUREMENT LAB WORK REQUEST

	ARE	A OF TESTING
Developmental	Safety Related	Litigation
Design Acceptance	 	ation Warehouse Audit
Pre-Pilot	New Design	Cast Reduction
Pilot	Design Change	Stake
Production Acceptance	Plant Assistance	★ Other
FIREARM STAT'S. MODEL: 2 LWT CAL. or GAGE: 2 MM OR	REPORT REQ'D. FORMAL TEST	DATE REQUESTED: 2/21/03 DATE NEEDED BY: Q. S. D. 72
PROOFED: YES X NO	RESULTS ONLY	WORK ORDER NO: C-1852-000-Y
11100120111203		Will official the Control of the Con
• .	TEST TYPE	5 1 A (1)
Strength Test Ammunitie		<u>, — — </u>
Function Test Environme Accuracy Test Customer		
Acturaty Test customer (Complaint Elidurance	
EXPLAIN IN DETAIL THE REASON FOR T	HIS TEST:	
DETERMINE IF	FLOOR TILITE W	UILL REMAINS
CLUSED WHEN SIXOOT	TING FIROND SHOW	14.D.E.R.
AMMO: 40 ROS	TOTAL.	
	OW FEED	
•	ED "	
•	GST 11	
76171612: 100)	YARDS (200 IF N	(ECESSIARY) F. C.C. CLUB
HOTE: WALTER	.	
IN FOR	OU YARDS ON 2/18	OF MARR. SIGNTED
	- 1111125 02 2//8	4/83
GUNS REQUIRED:		•
ONE EURNISHED = M/O CONSI	LWT. 7MMOB- &	# 9600118. GUNTU BE
NOTE: NO firearms or parts will be tested it	n the Labs unless they are	DATE COMPLETED:
accompanied by a Work Request, a	nd both are delivered to	TEST COMPLETED BY:
the Labs by the designer or engineer	r. All Work Requests are	REPORT DATE:
to be filled out in detail. No Except	ions.	

FIELD	CYCLE	TEST -	CENTERFIRE
	~ ~ ~ ~ ~ ~ ~		OTITIOTIC TICE

REPROT NO.: 830521

PAGE NO.

PREVIOUS ROUNDS	TE	ST T	2 - 2 ITLE CR:	:	<u>- u</u>	3 nct	10	MO	DEL:	<u>z</u> t : : t						AUGE	:_7	<u> </u>	, ό (<u> </u>	2	8	ERIA TTL.	L NO RDS MAL	·	RED:	S:_	20	BARBE
				·····		·		····			11	MALE	UNCI	'IONS	!"								MALF	UNCT	ION	RATE		0.0	<u>%</u>
AMMUNITION		INIS FIRED			SHELL	ECT	DON'T BLOW BACK	DON'T LOCK OPEN	FE: FR: MA:	OM	STEMS MAG.	POWER OVERRIDE	LOCK UP			em Mber		JUMPS MAG.	FOLLOWER BINDS		ERRIDE	ANG UP	TRACT	S ₂	ITIS	ENTS	OCITIES .	REMAI (ON I	RESALE R 012
Load Size		SHOOTER	NO. OF ROLLINDS	FIRING	TRAPPED SHELL	DON'T EJECT	DOM.T. E	DON'T L	Ist	2nd		POWER O	DOM'T IV	HIGH	103	RICE	LEFT	SHELL	FOLLOWE	LOADING	BOLT OVERRIDE	ACTION HANG UP	DON'T EXTRACT	BREAKAGES	ADJUSTMENTS	REPLACEMENTS	BOLT VELOCITIES	YES	3A(%) 58 NO
R-140PS8	S	2	5																		3 /								
	3		5																		3 1/2								
	F		2																		33								
R-140958	٤		5			<u> </u>															3 3								
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R-140 PSR	2		<u> </u>			<u> </u>		_						_					<u> </u>	_									
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TOTAL (PER M	L.)				<u></u>		<u> </u>	<u> </u>		<u> </u>	<u></u>	<u> </u>	<u> </u>				<u> </u>	<u> </u>	<u> </u>					<u> </u>	<u> </u>				

FIELD	CYCLE	TEST	 CENTERFIRE
1	~ ~ ~ ~ ~		 ODITION TITLE

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PAGE	NO.
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	DA'	MTE: 2-22-83 MODEL: Seven : CAUGE: 7MM OV												8	SERIAL NO. 7600117														
PREVIOUS ROUNDS			ITLE CR:			uct	"MIFUNCTIONS"												TTL. RDS. FIRED: 40 TTL. MALFUNCTIONS: 0 MALFUNCTION RATE: 0						BARBER-				
1. Joe 6- Kralpi			NDS FIRED		ELL	H	BACK	: OPEN	FE FR		STEMS MAG.	OVERRIDE	B			'EM MBER	l	PS MAG.	BINDS		RIDE	gg e	ACT		8	83	सम्बद्ध	REMAI	PRESALE R 0
AMMUNITION Load Size		SHOOTER	NO. OF ROINIS	FIRING	TRAPPED SHELL	DOM'T EJECT	DON'T BLOW BACK	DON'T LOCK OPEN	1	ECH Sug	als Tiens	POWER OVE	DON'T LOCK UP	HICH	LOW	RIGHT	LENT	SHELL JUMPS MAG.	FOLLOWER BINDS	LOADING	BOLT OVERRIDE	ACTION BANG UP	DON'T EXTRACT	BREAKAGES	ADJUSTMENTS	REFLACIEMENTS	BOLT VELOCITIES	REMAI (ON I	RKEC BACES)
R-140 PSR.	S	1	5	oK																									
	<u>M</u>			οK											_														
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R.140PSR	2	2	7	cΚ																									
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TOTAL (PER MA)	Ն.)																												

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REMINGTON ARMS COMPANY, INC. Distribution: C. B. Workman C. E. Ritchie J. W. Brooks Remineton D.E. Bullis "CONFINE YOUR LETTER TO ONE SUBJECT ONLY"_ RESEARCH TEST and MEASUREMENT REPORT - Report No. 830411 M/SEVEN LWT. - CAL. .243 - EVALUATION OF RECEIVERS MODIFIED WITH INTERNAL **BROACH CUTS** R. Williams Prepared by: 2-28-83 Date Prepared: _ Prociread and Cleared By: J.H. Hennings , R.E. Nightingale, Foreman-Test Lab/ Foreman-Measurement Lab C.E. Ritchie.

Sr. Supervisor - Testing, Meas. & Mech. Analysis Lab REPORT NUMBER: 830411

TEST & MEASUREMENT LAB REPORT

REPORT TITLE:	M/Seven LWT Cal243 - Evaluation of Receivers Modified With Internal Broach Cuts
MODEL(S):	M/Seven LWT.
gauge or caliber:	.243
DATE:	2/28/83
WORK ORDER NO.:	C-1856-000
PART NAME:	Receiver
DESIGNER/ENGINEER:	D. Bullis
TEST TYPE:	
1.	PHOTO LAB
2.	STRENGTH TEST - NO. OF GUNS TESTED
3.	FUNCTION TEST - NO. OF GUNS TESTED 16
4.	ACCURACY TEST - NO. OF GUNS TESTED
5.	MEASUREMENTS - TYPE: Static
6.	ENVIRONMENTAL TEST
7.	Ammunition testing & Evaluation - Type:
8.	VISUAL EVALUATION - OUT OF GUN SAMPLE
9.	ENDURANCE - NO. OF GUNS TESTED:
	NO. OF ROUNDS PER GUN: 135
	TOTAL ROUNDS FIRED IN TEST: 2,160
	AMMO TYPE: MAGS; TARGET:
	RIM FIRECENTER FIRE X

BARBER - PRESALE R 0128863

REMINGTON ARMS CO., INC. Firearms Research Division

Report No. 830411

February 28, 1983

TO:

R. E. NIGHTINGALE

FROM:

R. WILLIAMS

REPORT TITLE:

M/SEVEN LWT. - CAL. .243 - EVALUATION OF RECEIVERS MODIFIED WITH

INTERNAL BROACH CUTS

ABSTRACT

A total of sixteen (16) M/Seven LWT. Cal. .243 rifles with modified receivers which have a broach cut at the right lug area and Plant altered magazine boxes (right feed lip) were received in the Test Lab from D. G. Bullis, Current Firearms Design, for a Function Test.

SCOPE OF TEST

To determine if the New Design Change with the broach cut in the receiver will have any effect on extracted shell hanging up or being marked by receiver during ejecting cycle.

TEST RESULTS

There were no problems of shell casings being marked or hanging up during the ejection cycle.

There were other malfunctions during the test and they can be found in Report Text.

Two rifles left rings on fired brass, photos in Appendix "A".

REPORT TEXT

Load and Unload Cycle Test
 Cal. .243 Total Rounds Per Rifle – 135 Rds.

Rifle No. 7601300

Rifle No. 7601301

Rifle No. 7601296

Rifle No. 7601287

Rifle No. 7601288

No Malfunction

Rifle No. 7601291	- 24 Malfunctions for a 1	.7.7% rate	
1 Stem High	Rem. 80 Gr. P.S.P.	3rd out of mag.	Medium Cycle
1 Stern High	Rem. 80 Gr. P.S.P.	4th out of mag.	Fast Cycle
1 Stem Low	Ren, 80 Gr. P.S.P.	2nd out of mag.	Slow cycle
l Hard Under Rail	Rem. 80 Gr. P.S.P.	3rd out of mag.	Slow cycle
l Stem Left	Rem. 80 Gr. H. P.	2nd out of mag.	Slow cycle
1 Stem Left	Rem. 80 Gr. H.P.	2nd out of mag.	Medium cycle
1 Stem Low	Rem. 80 Gr. H. P.	2nd out of mag.	Fast cycle
l Hard Under Rail	Rem. 80 Gr. H.P.	3rd out of mag.	Medium cycle
1 Hard Under Rail	Rem. 100 Gr. P.S.P.	3rd out of mag.	Slow cycle
1 Stem High	Fed. 80 Gr. S.P.	4th out of mag.	Fast cycle
l Hard Under Rail	Fed. 80 Gr. S.P.	3rd out of mag.	Medium cycle
l Hard Under Rail	Fed. 100 Gr. S.P.	4th out of mag.	Slow cycle
1 Stem High	Fed. 85 Gr. B.T.H.P.	4th out of mag.	Fast cycle
1 Hard Under Rail	Fed. 85 Gr. B.T.H.P.	3rd out of mag.	Slow cycle
1 Hard Under Rail	Fed. 85 Gr. B.T.H.P.	4th out of mag.	Medium cycle
l Stem High	Fed. 100 Gr. B.T. S.P.	2nd out of mag.	Medium cycle
l Hard Under Rail	Fed. 100 B.T.S.P.	3rd out of mag.	Slow cycle
1 Stem High	Win. 80 Gr. P.S.P.	4th out of mag.	Slow Cycle
1 Stem High	Win. 80 Gr. P.S.P.	4th out of mag.	Medium cycle
1 Hard Under Rail	Win. 80 Gr. P.S.P.	3rd out of mag.	Slow cycle
1 Hard Under Rail	Win. 80 Gr. P.S.P.	4th out of mag.	Medium cycle
1 Bolt Stem Shell in M	Mag.Win. 100 Gr. S.P.	4th out of mag.	Fast cycle
1 Stem High	Win. 100 Gr. S.P.	3rd out of mag.	Slow cycle
1 Hard Under Rail	Win, 100 Gr. S.P.	4th out of mag.	Slow Cycle

REPORT TEXT - cont'd.

Load and Unload Cycle Test
 Cal. .243 Total Rounds Per Rifle – 135 Rds. - cont'd.

l Hard Under Rail	Rem. 80 Gr. P.S.P.	3rd out of mag.	Slow cycle
l Hard Under Rail	Rem. 80 Gr. P.S.P.	4th out of mag.	Slow cycle
l Hard Under Rail	Rem. 80 Gr.P.S.P.	4th out of mag.	Medium cycle
l Hard Under Rail	Rem. 80 Gr. H.P.	3rd out of mag.	Slow cycle
l Hard Under Rail	Rem. 80 Gr. H.P.	3rd out of mag.	Medium cycle
l Hard Under Rail	Rem. 100 Gr. P.S.P.	4th out of mag.	Slow cycle
l Hard Under Rail	Fed. 80 Gr. S.P.	3rd out of mag.	Slow cycle
l Hard Under Rail	Fed. 80 Gr. S.P.	2nd out of mag.	Medium cycle
1 Hard Under Rail	Fed. 80 Gr. S.P.	4th out of mag.	Medium cycle
l Hard Under Rail	Fed. 100 Gr. S.P.	2nd out of mag.	Slow cycle
l Hard U nder Rail	Fed. 100 Gr. S.P.	4th out of mag.	Medium cycle
l Hard Uner Rail	Fed. 85 Gr. B.T.H.P.	3rd out of mag.	Slow cycle
l Hard Under Rail	Fed. 85 Gr. B.T.H.P.	4th out of mag.	Medium cycle
l Hard Under Rail	Fed. 100 Gr. B.T.S.P.	3rd out of mag.	Slow cycle
l Hard Under Rail	Win. 80 Gr. P.S.P.	2nd out of mag.	Slow cycle
l Hard Under Rail	Win. 100 Gr. S.P.	3rd out of mag.	Slow cycle
l Hard Under Rail	Win. 100 Gr. S.P.	4th out of mag.	Medium cycle

M/Seven LWT. - Cal. .243 - Evaluation of Receivers Modified With Internal Broach Cuts

REPORT TEXT - cont'd.

Load and Unload Cycle Test
 Cal. .243 Total Rounds Per Rifle — 135 Rds. - cont'd.

Rifle No. 7601293	- 18 Malfunctions for a 13	.3% rate	
1 Stem High	Rem. 80 Gr. P.S.P.	4th out of mag.	Slow cycle
l Stem High	Rem. 80 Gr. P.S.P.	4th out of mag.	Medium cycle
1 Stem High	Rem. 80 Gr. P.S.P.	4th out of mag.	Fast cycle
l Hard Under Rail	Rem. 80 Gr. P.S.P.	4th out of mag.	Slow cycle
l Hard Under Rail	Rem. 80 Gr. P.S.P.	4th out of mag.	Medium cycle
l Hard Under Rail	Rem. 80 Gr. P.S.P.	4th out of mag.	Fast cycle
1 Stems Incline	Rem. 100 Gr. P.S.P.	4th out of mag.	Slow cycle
1 Stems Incline	Rem. 100 Gr. P.S.P.	4th out of mag.	Medium cycle
l Stems Incline	Rem. 100 Gr. P.S.P.	4th out of mag.	Fast cycle
l Stem High	Fed. 80 Gr. S.P.	4th out of mag.	Medium cycle
l Stem High	Fed. 100 Gr. S.P.	4th out of mag.	Medium cycle
l Stem High	Fed. 100 Gr. S.P.	4th out of mag.	Fast cycle
l Stem High	Fed. 100 Gr. B.T.S.P.	4th out of mag.	Slow cycle
l Stem High	Fed. 100 Gr. B.T.S.P.	4th out of mag.	Fast cycle
1 Stems Incline	Win. 80 Gr. P.S.P.	4th out of mag.	Slow cycle
1 Stem High	Win. 80 Gr. P.S.P.	4th out of mag.	Fast cycle
1 Stems Incline	Win. 100 Gr. S.P.	4th out of mag.	Slow cycle
l Stem High	Win. 100 Gr. S.P.	4th out of mag.	Medium cycle
-		•	
Rifle No. 7601286	- I Malfunction for a .7% ra	ate	
l Hard Under Rail	Rem. 80 Cr. P.S.P.	3rd out of mag.	Slow cycle
D:0 N 001004	1 N.C.16	A	
Rifle No. 7601294	 1 Malfunction for a .7% ra 	Te	
1 Stem Right	Rem. 100 Gr. P.S.P.	lst out of mag.	Slow cycle
Rifle No. 7601289	- 2 Malfunctions for a 1.4% ra	nte	
	 		-
1 Drops Shell	Rem. 80 Gr. P.S.P.	2nd out of mag.	Slow cycle
1 Drops Shell	Rem. 80 Gr. P.S.P.	3rd out of mag.	Slow cycle
Rifle No. 7601297	 13 Malfunctions for a 9.6 	% rate	
1 Mag Loads Hard	Rem. 80 Gr. P.S.P.	4th in the mag.	Slow Cycle
l Mag. Loads Hard	Rem. 80 Gr. P.S.P.	4th in the mag.	Medium cycle
l Mag. Loads Hard	Rem. 80 Gr. P.S.P.	4th in the mag.	Fast cycle
1 Mag. Loads Hard	Rem. 80 Gr. H.P.	4th in the mag.	Slow cycle
1 Mag Loads Hard	Rem. 80 Gr. H.P.	4th in the mag.	Medium cycle
1 Mag. Loads Hard	Rem. 100 Gr. P.S.P.	4th in the mag.	Medium cycle
l Mag. Loads Hard	Rem. 100 Gr. P.S.P.	4th in the mag.	Fast cycle
l Mag. Loads Hard	Fed. 80 Gr. S.P.	4th in the mag.	Slow cycle
1 Mag. Loads Hard	Fed. 80 Gr. S.P.	4th in the mag.	Medium cycle
l Mag. Loads Hard	Fed. 80Gr. S.P.	4th in the mag.	Fast cycle
l Mag. Loads Hard	Fed. 100 Gr. S.P.	4th in the mag.	Medium cycle
l Mag. Loads Hard	Win. 85Gr. P.S.P.	4th in the mag.	Fast cycle
1 Mag. Loads Hard	Win. 80 Gr. P.S.P.	4th in the mag.	Medium cycle
	• • • • • • • • • • • • • • • • • • • •	-	

M/Seven LWT. - Cal. - .243 - Evaluation of Receivers Modified With Internal Broach Cuts

REPORT TEXT - cont'd.

Load and Unload Cycle Test Cal. .243 Total Rounds Per Rifle - 135 Rds. - cont'd.

Rifle No. 7601285	- 3 Malfunctions for a 2.2% rate			
1 Bolt Override	Fed. 80 Gr. S.P.	lst out of the mag.	Medium cycle	
1 Bolt Override	Fed. 85 Gr. B.T.H.P.	lst out of the mag.	Fast cycle	
1 Bolt Override	Win. 100 Gr. S.P.	lst out of the mag.	Medium cycle	
Rifle No. 7601292	 7 Malfunctions for 	a 5.1% rate		
1 Shell Stems Mag.	Rem. 100 Gr. P.S.P.	4th out of mag.	Medium cycle	
1 Shell Stems Mag.	Rem. 100 Gr. P.S.P.	4th out of mag.	Fast cycle	
1 Stem Left	Fed. 100 Gr. S.P.	4th out of mag.	Slow cycle	
1 Stem Left	Fed. 100 Gr. S.P.	4th out of mag.	Medium cycle	
1 Stem Left	Fed. 100 Gr. S.P.	4th out of mag.	Fast cycle	
1 Stem Left	Fed. 85 Gr. B.T.H.P.	4th out of mag.	Medium cycle	
1 Stem Left	Fed. 85 Gr. B.T.H.P.	4th out of mag.	Fast cycle	
Rifle No. 7600921	 4 Malfunctions for 	a 2.9% rate		
				
1 Stem Low	Rem. 80 Gr. H.P.	4th out of mag.	Slow cycle	
1 Stem Low	Rem. 80 Gr. H.P.	4th out of mag.	Fast cycle	
1 Stem High	Fed. 100 Gr. S.P.	2nd out of mag.	Slow cycle	
1 Stem High	Win. 80 Gr. P.S.P.	3rd out of mag.	Medium cycle	
Rifle No. 7600614	 9 Malfunctions for 	a 6.6% rate		
l Stem Low	Rem. 100 Gr. P.S.P.	lst out of mag.	Medium cycle	
1 Stem Low	Rem. 100 Gr. P.S.P.	1st out of mag.	Fast cycle	
1 Stem Right	Fed. 100 Gr. S.P.	1st out of mag.	Slow cycle	
1 Stem Low	Fed. 85 Gr. B.T.S.P.	lst out of mag.	Slow cycle	
1 Stem Low	Win. 80 Gr. P.S.P.	1st out of mag.	Slow cycle	
1 Stem Low	Win. 80 Gr. P.S.P.	1st out of mag.	Medium cycle	
1 Bolt Override	Win. 80 Gr. P.S.P.	2nd out of mag.	Medium cycle	
1 Stem Low	Win. 100 Gr. S.P.	lst out of mag.	Slow cycle	
1 Stem Right	Win. 100 Gr. S.P.	3rd out of mag.	Slow cycle	

2. Live Load & Fire Cycle Test

Cal. .243 Total Rounds Per Rifle - 135 Rds.

Rifle No. 7601286 Rifle No. 7601300 Rifle No. 7601296 Rifle No. 7601287 Rifle No. 7601288 No Malfunction

Report No. 830411 Page 5

REPORT TEXT- cont'd.

2. Live Load & Fire Cycle Test - cont'd.

Cal. .243 Total Rounds Per Rifle — 135 Rds.

Rifle No. 7601291	 17 Malfunctions for 	a 12.5% rate	
l Stem High	Rem. 80 Gr. P.S.P.	4th out of mag.	Slow cycle
l Stem High	Rem. 80 Gr. P.S.P.	4th out of mag.	Medium cycle
l Stem High	Rem. 80 Gr. H.P.	4th out of mag.	Slow cycle
1 Stem High	Rem. 80 Gr. H.P.	4th out of mag.	Medium cycle
1 Stem High	Fed. 80 Gr. S.P.	4th out of mag.	Slow cycle
1 Stem High	Fed. 80 Gr. S.P.	4th out of mag.	Medium cycle
1 Stem High	Fed. 80 Gr. S.P.	4th out of mag.	Fast cycle
l Stem High	Fed. 100 Gr. S.P.	4th out of mag.	Slow cycle
l Stem High	Fed. 100 Gr. S.P.	4th out of mag.	Medium cycle
1 Stem/High	Fed. 100 Gr. S.P.	4th out of mag.	Fast cycle
1 Stem High	Fed. 85 Gr. B.T.H.P.	4th out of mag.	Slow cycle
1 Stem High	Fed. 85 Gr. B.T.H.P.	4th out of mag.	Medium cycle
1 Stem High	Fed. 100 Gr. B.T.S.P.	4th out of mag.	Slow cycle
1 Stem High	Win. 80 Gr. P.S.P.	4th out of mag.	Medium cycle
1 Stem High	Win. 100 Gr. S.P.	4th out of mag.	Slow cycle
1 Stem High	Win. 100 Gr. S.P.	4th out of mag.	Medium cycle
l Stem High	Win. 100 Gr. S.P.	4th out of mag.	Fast cycle
Rifle No. 7601290	 23 Malfunctions for 	a 17.% rate	
1 Stem High	Rem. 80 Gr. P.S.P.	3rd out of mag.	Fast cycle
l Hard Under Rail	Rem. 100 Gr. P.S.P.	1st out of mag.	Slow cycle
l Hard Under Rail	Rem. 100 Gr. P.S.P.	4th out of mag.	Slow cycle
l Hard Under Rail	Fed. 80 Gr. S.P.	1st out of mag.	Slow cycle
l Hard Under Rail	Fed. 80 Gr. S.P.	2nd out of mag.	Slow cycle
l Hard Under Rail	Fed. 80 Gr. S.P.	1st out of mag.	Medium cycle
l Hard Under Rail	Fed. 80 Gr. S.P.	2nd out of mag.	Medium cycle
l Hard Under Rail	Fed. 100 Gr. S.P.	1st out of mag.	Slow cycle
l Hard Under Rail	Fed. 85 Gr. B.T.H.P.	lst out of mag.	Slow cycle
l Hard Under Rail	Fed. 85 Gr. B.T.H.P.	1st out of mag.	Medium cycle
l Hard Under Rail	Fed. 85 Gr. B.T.H.P.	1st out of mag.	Fast cycle
l Hard Under Rail	Fed. 100 Gr. B.T.H.P.	1st out of mag.	Slow cycle
l Hard Under Rail	Fed. 100 Gr. B.T.H.P.	2nd out of mag.	Slow cycle
l Hard Under Rail	Fed. 100 Gr. B.T.H.P.	lst out of mag.	Medium cycle
1 Hard Under Rail	Fed. 100 Gr. B.T.H.P.	2nd out of mag.	Medium cycle
1 Hard Under Rail	Fed. 100 Gr. B.T.H.P.	1st out of mag.	Fast cycle
l Hard Under Rail	Win. 80 Gr. P.S.P.	1st out of mag.	Slow cycle
l Hard Under Rail	Win. 80 Gr. P.S.P.	lst out of mag.	Medium cycle
l Hard Under Rail	Win. 80 Gr. P.S.P.	lst out of mag.	Fast cycle
1 Hard Under Rail	Win. 100 Gr. S.P.	1st out of mag.	Slow cycle
1 Hard Under Rail	Win. 100 Gr. S.P.	lst out of mag.	Medium cycle
l Hard Under Rail	Win. 100 Gr. S.P.	2nd out of mag.	Medium cycle
l Hard Under Rail	Win. 100 Gr. S.P.	1st out of mag.	Fast cycle

Report No. 830411 Page 6

REPORT TEXT - cont'd.

Live Load & Fire Cycle Test - cont'd.
 Cal. .243 Total Rounds Per Rifle - 135 Rds.

Rifle No. 7601293	- 10 Malfunctions fo	or a 7.4% rate	
l Stem High	Rem. 80 Gr. P.S.P.	4th out of mag.	Medium Cycle
l Stem High	Rem. 80 Gr. P.S.P.	4th out of mag.	Fast Cycle
l Hard Under Rail	Rem. 80 Gr. P.S.P.	1st out of mag.	Slow cycle
l Hard Under Rail	Rem. 80 Gr. P.S.P.	4th out of mag.	Slow cycle
l Hard Under Rail	Rem. 80 Gr. P.S.P.	4th out of mag.	Medium cycle
l Hard Under Rail	Rem. 80 Gr. P.S.P.	4th out of mag.	Fast cycle
1 Stems Incline	Rem. 100 Gr. P.S.P.	4th out of mag.	Slow cycle
1 Stem High	Fed. 100 Gr. B.T.S.P.	4th out of mag.	Fast cycle
l Stem High	Win. 80 Gr. P.S.P.	4th out of mag.	Fast cycle
1 Stem High	Win. 100 Gr. S.P.	4th out of mag.	Slow cycle
Rifle No. 7601300	- 10 Malfunctions for	or a 7.4% rate	
1 Mag Loads Hard	Rem. 80 Gr. P.S.P.	4th in the mag.	Slow cycle
1 Mag Loads Hard	Rem. 80 Gr. P.S.P.	4th in the mag.	Medium cycle
l Mag Loads Hard	Rem. 80 Gr. H.P.	4th in the mag.	Medium cycle
l Mag Loads Hard	Rem. 80 Gr. H.P.	4th in the mag.	Fast cycle
1 Mag. Loads Hard	Rem. 100 Gr. P.S.P.	4th in the mag.	Slow cycle
l Mag Loads Hard	Rem. 100 Gr. P.S.P.	4th in the mag.	Medium cycle
l Mag. Loads Hard	Fed. 80 Gr. S.P.	4th in the mag.	Medium cycle
l Mag Loads Hard	Fed. 80 Gr. S.P.	4th in the mag.	Fast cycle
1 Mag Loads Hard	Fed. 100 Gr. S.P.	4th in the mag.	Fast cycle
l Mag Loads Hard	Win. 100 Gr. S.P.	4th in the mag.	Fast cycle
Rifle No. 7601301	 3 Malfunctions for 	r a 2.2% rate	
1 Bolt Stems Shell	Win. 80 Gr. P.S.P.	4th out of mag.	Slow cycle
1 Bolt Stems Shell	Win. 80 Gr. P.S.P.	4th out of mag.	Medium cycle
l Bolt Stems Shell	Win. 80 Gr. P.S.P.	4th out of mag.	Fast cycle
Rifle No. 7601294	 7 Malfunctions for 	a 5.1% rate	
1 Don't Extract	Rem. 100 Gr. P.S.P.	2nd out of mag.	Slow Cycle
1 Don't Extract	Rem. 100 Gr. P.S.P.	3rd out of mag.	Medium Cycle
l Don't Extract	Rem. 100 Gr. P.S.P.	4th out of mag.	Medium Cycle
1 Don't Extract	Rem. 100 Gr P.S.P.	1st out of mag.	Fast Cycle
1 Don't Extract	Rem. 100 Gr. P.S.P.	3rd out of mag.	Fast Cycle
l Don't Extract	Rem. 100 Gr. P.S.P.	5th out of mag.	Fast Cycle
	Replaced Extractor at 45	Rounds	
1 Stem High	Fed. 100 Gr. S.P.	1st out of mag.	Fast Cycle

M/Seven LWT. - Cal. - .243 Evaluation of Receivers Modified With Internal Broach Cuts

REPORT TEST - cont'd.

Live Load & Fire Cycle Test - cont'd.
 Cal. .243 Total Rounds Per Rifle - 135 Rds.

Rifle No. 7601289	 2 Malfunctions for a 	1.4% rate	
1 Drops Shell	Rem. 80 Gr. H.P.	3rd out of mag.	Medium cycle
1 Stem Left	Win. 80 Gr. P.S.P.	4th out of mag.	Medium cycle
Rifle No. 7601285	 2 Malfunctions for a 	1.4% rate	
1 Bolt Override	Fed. 85 Gr. B.T.H.P.	1st out of mag.	Slow cycle
l Bolt Override	Fed. 85 Gr. B.T.H.P.	lst out of mag.	Medium cycle
Rifle No. 7601292	 5 Malfunctions for a 	a 3.7% rate	
1 Shell Stems Mag.	Rem. 100 Gr. P.S.P.	4th out of mag.	Fast cycle
1 Stem Left	Rem. 100 Gr. P.S.P.	4th out of mag.	Slow cycle
l Stem Left	Fed. 100 Gr. S.P.	4th out of mag.	Slow cycle
1 Stem Left	Win. 80 Gr. P.S.P.	4th out of mag.	Slow cycle
l Stem Left	Win. 80 Gr. P.S.P.	4th out of mag.	Medium cycle
Rifle No. 7600921	- 1 Malfunction for a	.7% rate	
1 Stem Low	Rem. 80 Gr. H.P.	4th out of mag.	Fast cycle
Rifle No. 7600614	 2 Malfunctions for 1 	1.4% rate	
1 Stem Low	Rem. 100 Gr. P.S.P.	1st out of mag.	Slow cycle
1 Stem Low	Win. 100 Gr. S.P.	1st out of mag.	Slow cycle

^{3.} Two Rifles Serial No. 7601294 and Serial No. 7600614 left deep rings on the fired brass. Also the base of the case is deformed due to the chamber.

Photographs of the fired cases will be found in Appendix "A".

TEST PROCEDURE

A. Measurements

Measurements taken in the Test Lab are Headspace after Proof and can be found in Appendix "A".

B. Load and Unload Cycle Test and Live Load and Fire Cycle Test

Both tests were conducted in the Shooting Jacks in the Test Lab. Each rifle was cycled and fired a total of 135 rounds with nine (9) types of ammunition. Each rifle was fired 15 rds. with 5 rds. of Slow, Medium and Fast Cycle and rifle allowed to cool between each 15 rounds.

1. Ammunition Cal. .243

Rem. 80 Gr. Ptd. S.P.	Index	R243W1
Rem. 80 Gr. Power-Lokt H.P.	"	R243W2
Rem. 100 Gr. Core-Lokt Ptd. S.P.	"	R243W3
Fed. 80 Gr. S.P.	**	243A
Fed. 100 Gr. Hi-Shok S.P.	"	243B
Fed. 85 Gr. Boat-tail H.P.	77	P243D
Fed. 100 Gr. Boat-tail H.P.	"	P243C
Win. 80 Gr. P.S.P.	"	X2431
Win. 100 Gr. P.P.S.P.	"	X2432

M/Seven LWT. Cal. .243

Serial No.	Headspace After Proof
7601291	Min. + .003
7601290	Min. + .002
7601293	Min. + .003
7601286	Min. + .003
7601300	Min. + .002
7601297	Min. + .002
7601301	Min. + .003
7601296	Min. + .002
7601287	Min. + .003
7601294	Min. + .003
7601288	Min. + .004
7601289	Min. + .003
7601285	Min. + .003
7601292	Min. + .003
7600921	Min. + .003
7600614	Min. + .002

"APPENDIX "A"

FIELD	CYCLE	TEST	_	CENTERFIRE
		1101		CHMINITING

REPROT	NO.1	830	411
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PAGE	No	1
171.06	MU.	,

INTE: 2-28-83 MODEL: 7/WT ONUIR: 243 BERIAL NO. BARBER - PRESALE R 0128873 PREVIOUS TEST TITLE! SUMMARY SHEETS PER - RIFLE - AMMO TYPE - SHOOTER HOUNDS TTL. RDS. FIRED: "LOAD & UNLOAD CYCLE TEST" TTL. MALFUNCTIONS! "MALFUNCTIONS" MALFUNCTION RATE: FEED BTEM SHELL JUMPS MAG. CHAMBER FOLLOWER BINDS FROM BOLT OVERRIDE TISES Cland Vol. LOADING May. MALFUNCTIONS DOR'T BIBOT SUMMARY SHEET Wd. RATE १ वज्यव Int Sug Rifle RIEST 103 MALF Tykon 7601291 135 24 7601290 17 12.59 7601293 135 3 10 7601286 135 7601294 135 7601289 135 2 7601297 135 13 13 76.01285 135 3 3 7601292 5 135 7 7600921 135 2 7600614 135 2 TOTAL (PER MAL.)

FIELD	CYCLE	TEST	_	CENTERF IRE
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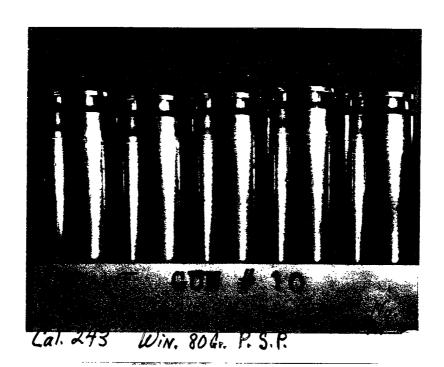
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PREVIOUS ROUNDS	TEST T	TTLE	<u>s</u>	UMMA	RY S	HEET	S PE	R -	RIF	LE -	AMM	YI O	PE -	- SHO	OTE	R					:	TTL.	RDS	. FI	RED:		,	BARBER-
- LIVE	: Lo	AD	4		E	Cyc	15	1E	sT	. 10	MIF	unct.	lons	H							j	MIF	Mal. Unct	runc Ion	tion rate	:		
SUMMARY SHEET		ACURDS FIRED				STEMS INCLINE		FE FR MA	ed om		PROP 500 SHELL	HARD UNDER RAIL		et Cim	em Mber		JUMES MAG.	FOLLOWER BINDS	COADING May, Loads	BOLT OVERRIDE	STEMS SHELL		K	orts .	STREET.	KS or BACK	CIONS PER	RESALE ROJZE
Rifle.	SHOOTER	80 90	FIRES	THE CHART	DOIL PLECT	STEMS	ו ביוצסם		rcH Sug	SHELL	PROP S	HARD	BECER	TON.	RICHE		SHELL	FOLLOW	LCADING	BOLT O	Bout	DON'T EXTRACT	HEEA KAGES	ADJUSTMENTS	REPLACEMENTS	REMARKS	MALFUNCTIONS	BH ZHW
7601291		135											17														17	12.59
7601290		135										22	1														23	17.%
7601293		135				1						4	5														10	7.4%
7601300		135																	10								10	7.4%
7601301		135	1_		_									<u> </u>			<u> </u>				3						3	2.2%
7601294	_	135	1					<u> </u>				<u> </u>	1					<u> </u>	_			6	<u> </u>		X	X	7	5.1%
7601289		135	1			_		_			1	<u> </u>		<u> </u>	 	1	_	Ŀ					<u> </u>	_			2	1.4%
7601285	·	135	1		_	<u> </u>		<u> </u>				<u> </u>								2							2	1.4%
7601292		133	1_		_	<u> </u>				1						4	_						_	_			5	3.7%
7600921		135	1_	<u> </u>				_			<u> </u>			1					_			<u> </u>					/	.7%
7600614		135	1_	1_					_	_		1_		2						_		<u> </u>					2	1.4%
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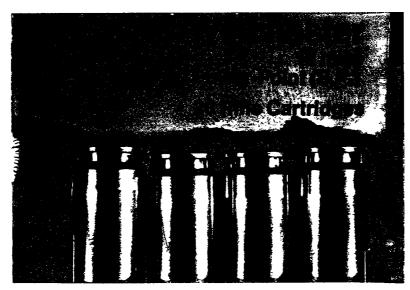
RESEARCH TEST & MEASUREMENT LAB WORK REQUEST

*		
* * *	ARE	A OF TESTING
Developmental	Safety Related	Litigation
Design Acceptance	Competitive Evalua	ation Werehouse Audit
Pre-Pilot	New Design	Cost Reduction
Pilot	Design Change	Stake
Production Acceptance	Plant Assistance	Other
FIREARM STAT'S.	REPORT REQ'D.	
MODEL: 72WT		DATE REQUESTED: 2 - 10 -83
CALARGAGE: 243	FORMAL	DATE NEEDED BY: ASAP
BARREL TYPE: CARB.	TEST RESULTS	REQUESTED BY:
PROOFED: YES VNO	ONLY	WORK ORDER NO:
	TEST TYPE	
Strength Test Ammuniti		Photo/Video
Function Test Environme	intal Test Measurement	Other
Accuracy Test Customer	Complaint Endurance T	· · · · · · · · · · · · · · · · · · ·
EXPLAIN IN DETAIL THE REASON FOR T		
M/7 LWT - 243 CAL.	BROACHED REC.	(RIGHT LUG AREA)
PLANT AL:	TERES MAGAZINE	E BOX (RIGHT FEED LIP)
PUN TEST TO INCLUBE	FEEDING, EXTRAC	ITING & ESECTION OF
LIVE & FIRED SHE	ces. (FAST, MED.	, scow)
· LOOK FOR EXERME	TED SHELL HANG	ING UP OR BEING
MARKED BY RECE	IVER DURING ES	ECTING CYCLE.
· BE ALERT TO FE	EDING PROBLEMS _	ESPECIALLY LAST ROUND
IN MAG.		
-GUNS REQUIRED: 7 60 \$2 9	7/4/200 2/	101287 7401285
7600921	1297	1294 7601285
-GUNS REQUIRED: 760 29 1 7600 92 1 1290 760 06 14 1293	1301	1288
1286	1296	1289.
NOTE: NO firearms or parts will be tested in	n the Labs unless they are	DATE COMPLETED:
accompanied by a Work Request, at		TEST COMPLETED BY:
the Labs by the designer or engineer		REPORT DATE:
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Feb. 1983

REPORT No. 830411 R. Williams





GUN # 16 MYTLWT Serial No. 7600614 REPORT No. 830411

TOTAL (PER MAL.)

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REMINGTON ARMS Remington  "CONFINE YOUR LE	COMPANY, INC.  COMPANY, INC.  PETERS  TIER TO ONE SUBJECT ONL	Y''	Distribution:	C. B. Workman C. E. Ritchie J. Brooks T. Plunkett
RESEARCH TEST MODEL SEVEN -	and MEASUREMENT REPORT		831311 ANCE	
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Prophead and Cea J.H. Hennings , Foreman-Test Lab	R.E. Nightingale, Foreman-Measurement Lab	Signature	2 a thyale	- 7-20-83
	C.E. Ritchie, Sr. Supervisor - Testing, Mess. & Mech. Analysis Lab	Signature	Otti.	7/20/73 Date

## TEST & MEASUREMENT LAB REPORT

REPORT NUMBER:	831311
REPORT TITLE:	Model Seven - Aluminum Floor Plate Design Acceptance .
MODEL(S):	Seven
gauge or caliber:	.308
DATE:	6-27-83
WORK ORDER NO.:	C-1856-000
PART NAME:	Aluminum Floor Plate Assembly
DESIGNER/ENGINEER:	Requested by T. J. Plunkett
TEST TYPE:	
1.	PHOTO LAB
2.	STRENGTH TEST · NO. OF GUNS TESTED
3.	FUNCTION TEST - NO. OF GUNS TESTED
4.	ACCURACY TEST - NO. OF GUNS TESTED
5.	MEASUREMENTS - TYPE: Headspace Latch Force
6.	ENVIRONMENTAL TEST
7.	AMMUNITION TESTING & EVALUATION - TYPE:
8.	VISUAL EVALUATION - OUT OF GUN SAMPLE
9.	ENDURANCE - NO. OF GUNS TESTED: 10
	NO. OF ROUNDS PER GUN: 2 to 5000
	TOTAL ROUNDS FIRED IN TEST: 26,000
	AMMO TYPE: MAGS; TARGET:
	RIM FIRE CENTER FIRE X

REMINGTON ARMS CO., INC. Firearms Research Division

Report No. 831311 Page 1

July 20, 1983

TO:

R. E. NIGHTINGALE

FROM:

F. L. SUPRY

REPORT TITLE:

MODEL SEVEN - ALUMINUM FLOOR PLATE DESIGN ACCEPTANCE

#### ABSTRACT

On May 11, 1983, a request was received from T. J. Plunkett to conduct a Design Acceptance Test on ten (10) Model Seven, .308 caliber rifles, assembled with a new design aluminum floor plate assembly.

### SCOPE OF WORK

To determine by Field Function Testing and Jack Endurance Testing if the button in front of the trigger guard will retain the floor plate cover in the closed position, while the rifle is being fired, and prevent the dumping of shells.

#### TEST RESULTS

No floor plate openings occurred during any portion of the testing conducted on these rifles.

NOTE: It was determined that some dimensional changes in the trigger guard bow would be necessary, due to an interference between the inside of the bow and the trigger.

Report No. 831311

Page 2

#### REPORT TEXT

After the assembly of these rifles, an interference between the bow of the trigger guard and the trigger was found. To eliminate the interference, material was ground from the end of the trigger.

The ten rifles were subjected to a Field Function Test, then enduranced to 2000 rounds in a Jack Function Test. Two of the ten rifles were selected and enduranced to 5000 rounds. No floor plate openings occurred during any portion of the testing conducted on these rifles.

A breakdown of the rifles by serial number and finished round level is located in the appendix.

#### TEST PROCEDURE

#### Assembly:

The assembly was made by T. J. Plunkett (Research - Current Products).

The triggers were ground by F. L. Supry, (Research - Test Lab).

#### Measurements:

Headspace measurements were made using graduated headspace gauges.

Latch force measurements were made using a ten pound chattlon push-pull gauge.

An individual measurement sheet is located in the appendix.

#### Field Function:

165 rounds of Remington and competitive ammunition were fired through each rifle, during a Field Function Test conducted at the Ilion Fish & Game Club.

Slow, medium and fast feed cycle speeds were used. The round robin system was used in this test.

Three feeding malfunctions occurred; resulting in a .2% overall malfunction rate.

Prior to the firing of each ammunition type, the magazine was manually unloaded by pushing the release button.

#### Jack Endurance:

8 rifles were enduranced to 2000 rounds.

2 rifles were enduranced to 5000 rounds.

#### Ammunition:

#### Field Test:

Remington - Remington - Winchester - Winchester - F ederal	R308 W1 R308 W2 X3081 X3087 P308C	Code Code Code Code	L22A W09F 14 12SH13 32A	D0364 D8217 PN 80 3118
Endurance:	R308W2	Code	W09F	D8217

#### Appendix Contents:

Serial Numbers of the rifles used and finished round level.

Headspace and Latch Measurement Sheet.

Field Function breakdown.

Report No. 831311

**APPENDIX** 

Report No. 831311 Data Sheet No. 1

Serial Numbers	Finished Round Level.		
7603983	2000		
7603866	5000		
7604206	2000		
7604123	2000		
7603941	2000		
7604158	2000		
7604243	2000		
7604175	2000		
7604114	2000		
7604185	5000		

Report No. 831311 Data Sheet No. 2

<u>Serial</u> No. 's	Head Space (In.)	Latch	Force (Lbs.)	Floor Plate
110. S	Start Finish	<u>Start</u>	Finish	<u>Openings</u>
7603983	.004 .004	2.25	2.25	0
7603866	.003 ,004	2.25	2.0	0
7604206	.000 .001	2.5	2.75	0
7604123	.003 .003	2.75	2.75	0
7603941	.004 .004	2.75	3,00	0
7604158	.004 .004	2.75	2.75	0
7604243	.003 .004	2.25	2.25	0
7604175	.004 .004	2.25	2.25	0
7604114	.004 .004	2.75	2.75	0
7604185	.004 .004	2.75	3.75	0

Report No. 831311

Data Sheet 3

## Field Function Breakdown

Serial No.	No. of Malfunctions	Malfunction Description	Malfunction Rate
7603983	0	_	0%
7603866	0	Fai to	0%
7604206	1	Extract	.6%
7604123	0	<del>-</del>	0%
7603941	0	_	0%
7604158	0		0%
7604243	0	_	0%
7604175	2	1 ST.R.*; 1 B.O.**	1.23%
7604114	0		0%
7604185	0	-	0%

*ST. R = Stem Right **B.O. = Bolt Override

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BARREL TYPE: _/	. 1	RESULTS	-	REQUEST	ED 8Y: 77.72	UNKETT
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X Function Test	Environme	ntai Test	Measuremen	nts	Other	
Accuracy Test	Customer (	Complaint	X Endurance	Test		
EXPLAIN IN DETAIL THE  PETERMINE  ACK ENDURAR  UIARD WILL RE  HILE RIFLE IS  TEST PROCEDUR  X PROOF IF NECE  LATEN SPRING  XLAREN SPRING  XLAREN SPRING  XLAREN SPRING  XLAREN SPRING  XLAREN SPRING  XLAREN SPRING  XLAREN SPRING  XLAREN SPRING  XLAREN SPRING  XLAREN SPRING  XLAREN SPRING  XTAKE LATCH OPENI  HI-SPEED MOUN  AN O RIPUS  GUNS REQUIRED:  1/ TOTAL-I-U	BY FIED NEE TEST BEING F. ESSARY-NO OPENING PENING TEST. PENING YE FORCE TYC FORCE	LD FUN TING IN GOR PUN GORDSPR FORCE, MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA MAGAZIA	TO SOLD TE	PARENT DUN RIFLE, COUSE N RESUME PAL GUN VI REAN FOR SISL. VI NOVE	TOF THE	TIGGETY TO SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS, THE SHELLS,
•	parts will be tested in		•		PLETED:	
	designer or engineer					
	in detail. No Excepti	·	rearing GIG	neroni ur	71 E	<del></del>
(O Od Imag Out )	- Jamin 140 EVESDE					

FD-49-4

# REMINGTON ARMS COMPANY, INC.

Distribution:

J. W. BROOKS

FILE

Reminston.

PETERS

"CONFINE YOUR LETTER TO ONE SUBJECT ONLY"_____

RESEARCH TEST and MEASUREMENT REPORT - Report No. 832691 REPEAT

TEST

M/7LW 3M AIOACRYLIE ADHESIVE

ENVIRONMENTAL TEST

Prepared by: R. WILLIAMS

Date Prepared: 3-16-84

Proofread and Cleared By:

R.E. Nightingale,
Foreman-Test Lab Foreman-Measurement Lab

C.E. Ritchie, Sr. Supervisor - Testing, Mess. & Mech. Analysis Lab Signature

Signature

Date

Date

## TEST & MEASUREMENT LAB REPORT

REPORT NUMBER: 832691 REPEAT TEST

REPORT TITLE: M/TLW 3M "ALOACRYLIE" ADHESIVE

ENVIRONMENTAL TEST

MODEL(S): 7LW

GAUGE OR CALIBER: ANY

DATE: 3-16-84

WORK ORDER NO.: C-1856-000

PART NAME: STOCK

DESIGNER/ENGINEER: J. W. BROOKS

## TEST TYPE:

	I.	PHOTO LAB
<del></del>	2.	STRENGTH TEST - NO. OF GUNS TESTED
	3.	Function test - no. of guns tested
	. 4.	ACCURACY TEST - NO. OF GUNS TESTED
•	5.	MEASUREMENTS - TYPE:
	6.	environmental test ×
-	7.	AMMUNITION TESTING & EVALUATION - TYPE:
	8.	VISUAL EVALUATION - OUT OF GUN SAMPLE
	9.	ENDURANCE - NO. OF GUNS TESTED:
		NO. OF ROUNDS FER GUN:
		TOTAL ROUNDS FIRED IN TEST:
		AMMO TYPE: MAGS: TARGET:
		DIM FIRE CENTED FIRE

MARCH 16, 1984

REPORT No. 832691 REPEAT TEST

To: J.W. BROOKS

FROM: R. WILLIAMS

TEST TITLE: MYTH 3M AIDACRYLIE" ADHESIVE ENVIRONMENTAL TEST

REASON FOR TEST

To evaluate what effect various solvents

have on a 3M Product "Aioacrylic" adhesive.

TEST PROCEDURE

The Test Lab received from J.W. Brooks
a flat Stack with M/7 Finish and with sample
spacers put an with various adhesive thicknesses.
Inhibisol was sprayed on the tack and
spacers and allowed to set for two days. Than
Hoppe's #9 Oil, Hoppe's #9 Solvent, CRC and Rem. Oil
were used and allowed to stay on the stock
two days each. The lubricants were liberally
applyed and the stock was cleaned with inhibitol
before applying each lubricant.

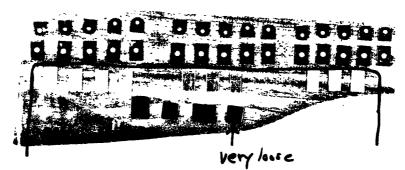
TEST RESULTS

Some spacers became losse after applying Hopp's #9 Salvent but did-not come off.

Photo on next page.

MARCH 16, 1984

REPEAT TEST



These spacers became loose None came off

ilesort.	٠٥.	

### RESEARCH TEST & MEASUREMENT LAB WORK RECUEST

	AREA OF TESTING							
Developmental	Safety Related	Litigation						
Design Acceptance	Competitive Eval	uation Warehouse Audit						
Pre-Pilot	New Design	Cost Reduction						
Pilot	Design Change	Stake-						
Production Acceptance:	Plant Assistance	Other						
FIREARN STATS  MODEL:	PORMAL TEST RESULTS ONLY  TEST TYPE  ION TOER ORY Cycle Test Measureme Complaint Endurance THIS TEST:  SEE WHAT EX  M PRODUCT AION PEAT TEST 8  Into Mac whent  Y. Check to see y  Aphibiant.	DATE REQUESTED: 2-17-84  DATE REQUESTED BY: 3-5-84  REQUESTED BY: 1 12 BRUKS  WORK ORDER NO: C1856-022/  Photo/Video  Other  Test  CRYLIC ADMESIVE  3 2691.  I blocally, a ince to  y parts are loose and						
Them we Hopei oil, Hopeis solvent, CRC+Rom oilcleaning interven with Inhibition.  UNSREQUIRED: FURMISHED  FLAT STOCK WITH M7 FINISH WITH SAMPLE  SPACERS AND VARIOUS ADMESIVE THICK, VIII.								
OTE: NO fireerms or perts will be tested accompanied by a Work Respect.	•	DATE COMPLETED:						
the Labs by the designer or engine		REPORT DATE:						
		nervni vale:						
to be filled out in detail. No Excep								

REMINGTON ARMS COMPANY, INC.

Distribution:

J. W. BROOKS

FILE

Remington

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840594 RESEARCH TEST and MEASUREMENT REPORT - Report No. 832691 REPEAT

M/7LW 3M AIOACRYLIE" ADHESIVE ENVIRONMENTAL TEST

Prepared by: R. WILLIAMS

Date Prepared: 3-16-84

Proofread and Cleared By:

Foreman-Test Lab Foreman-Measurement Lab

Signature

C.E. Ritchie. Sr. Supervisor - Testing, Meas. & Mech. Analysis Lab

Signature

Date

## TEST & MEASUREMENT LAB REPORT

REPORT NUMBER: 832691 REPEAT TEST REPORT TITLE: M/7LW 3M HIGACRYLIE" ADHESIVE MODEL(S): 74w GAUGE OR CALIBER: ANY DATE: 3-16-84 WORK ORDER NO.: 2-1856-000 PART NAME: STOCK DESIGNER/ENGINEER: J.W. BROOKS TEST TYPE: PHOTO LAB STRENGTH TEST - NO. OF GUNS TESTED _____ 3. Function test - no. of guns tested ____ ACCURACY TEST - NO. OF GUNS TESTED 5. MEASUREMENTS - TYPE: ENVIRONMENTAL TEST X 7. AMMUNITION TESTING & EVALUATION - TYPE:___ VISUAL EVALUATION - ____OUT OF ____ GUN SAMPLE ENDURANCE - NO. OF GUNS TESTED: 9. NO. OF ROUNDS FER GUN: TOTAL ROUNDS FIRED IN TEST:_____

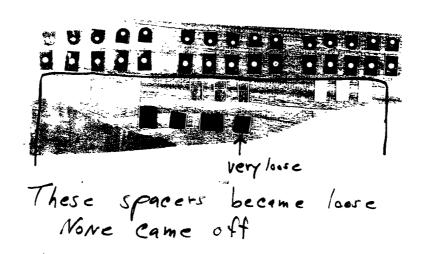
AMMO TYPE: MAGS: TARGET:

RIM FIRE CENTER FIRE

MARCH 16, 1984 KEPORT No. 8326	.91
REPE	
To: J. W. BROOKS	
FROM: P. WILLIAMS	
T - T - M/- 24 " 2	
TEST TITLE: MYTH 3M AIDACRYLIE" ADHE	SIVE
ENVIRONMENTAL TEST	
REASON FOR TEST	
To evaluate what effect various	s solvents
To evaluate what effect various have on a 3M Product "Aioacrylic" adhes	rive.
TEST PROCEDURE	
The Test Lab received from J.W.	
a flat Stock with M/7 Finish and with	sample
spacers put on with various adhesive the	cknesses.
Inhibisal was sprayed on the stock	K and
spacers and allowed to set for two days Hoppe's #9 Oil, Hoppe's #9 Solvent, CRC and	r, /han
Hoppe's "9 Oil, Hoppe's "9 Jolven!, CNC and	1em. Oil
were used and allowed to stay on the two days each. The lubricants were like applyed and the stock was cleaned will before applying each lubricant.	110C/C
and the stack has cleaned wi	the inhibital
Letere applying each lubricant.	<u> </u>
TEST RESULTS	
Some spacers became losse after a	eplying Happe's
Some spacers became losse after a #9 Salvent but did-not come off.	
Photo on next page.	

MARCH 16, 1984

REPEAT TEST



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Resort No.	
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## RESEARCH TEST & MEASUREMENT LAB WORK RECUEST

_	AREA OF TESTING					
Developmental	Safety Related	Litigation				
Design Acceptance	Competitive Evalua	ation Warehouse Audit				
Pre-Pilot	New Design	Cost Reduction				
Pilet	Design Change:	Stake-				
Production Acceptance:	Plant Assistance	Other				
FIREARM STAT'S	REPORT REQ'D.					
MODEL: 7		DATE REQUESTED: 2 -17-84  DATE NEEDED BY: 3 - 5-84				
CAL or GAGE:	FORMAL					
BARRELTYPE:	TEST /	REQUESTED BY: 1 10 BROOKS				
PROOFED: YESNO	ONLY	WORK ORDER NO: (1856-00)				
	TESTTYPE					
Strength Test Ammuni	tion Test Dry Cycle To	est ?hata/Videa				
Function Test Environm	nental TestMessuremen	Other				
Accuracy TestCustome	r Complaint Endurance T	'at				
XPLAIN IN DETAIL THE REASON FOR	THIS TEST: /					
<b>▼</b>	THIS TEST IS TO SEE WHAT EFFECT VARIOUS SOLVENTS					
HAVE ON & 3M PRODUCT AIDACRYLIE ADHESINE						
FAMILY RE	PEAT TEST 8:	3 2 6 9 / .				
		liberally. a love to				
		+ 0 1				
set for a de	set for a day. Check to see if parts are loose and					
motera	0 9					
+ H	D. 0 . 1	•				
. 5 tant with Inhibisiol.						
· There we Hope's oil, Hope's so vert, CRC+Pan vilcleaning						
Them we Hopeis oil, Hopeis so veit, CRC+Pam oil cleaning inbetween with Inhibit.  UNS REQUIRED: FURHISHED  FLAT STOCK WITH M7 FINISH WITH SAMPLE						
						SPACERS AND VARIOUS ADMESIVE THICKMENDES.
e	TO THE TOTAL PROPERTY.	JIVE IMICKIVATO.				
OTE: NO firearms or parts will be tested	in the Labs unless they are	DATE COMPLETED:				
accompanied by a Work Request,	and both are delivered to	TEST COMPLETED BY:				
the Labs by the designer or engine	er. All Work Requests are	REPORT DATE:				
to be filled out in detail. No Exce	ptions,					

10-40-6

# REMINGTON ARMS COMPANY, INC.

NTER-GEPARTMENTAL CORRESPONDENCE

Distribution: C. B. Workman

C. E. Ritchie J. W. Brooks

Remineton

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RESEARCH TEST and MEASUREMENT REPORT - Report No. 830941

M/SEVEN LWT. PENDULUM DROP TEST TO EVALUATE NEW TRIGGER DESIGN.

Prepared by: R. Howe

Date Prepared: 4-6-83

Propinsad and Cleared By:

J.H. Hennings , R.E. Nightingale,

Foreman-Measurement Lab

C.E. Ritzhie,

Mess. & Mech. Analysis Lab

Sr. Supervisor - Testing,

Signature

Data

## TEST & MEASUREMENT LAB REPORT

REPORT NUMBER:	830941					
REPORT TITLE:	M/Seven LWT. Pendulum Drop Test To Evaluate New Trigger Design					
MODEL(S):	M/Seven LWT.					
GAUGE OR CALIBER:	.243					
DATE:	4 - 6- 83					
WORK ORDER NO.:	C-1809-000					
PART NAME:	Trigger					
DESIGNER/ENGINEER	: D. Bullis					
TEST TYPE:						
1.	PHOTO LAB					
2.	STRENGTH TEST - NO. OF GUNS TESTED					
3.	Function test - no. of guns tested					
4.	ACCURACY TEST - NO. OF GUNS TESTED					
5.	MEASUREMENTS - TYPE:					
6.	ENVIRONMENTAL TEST					
7.	Ammunition testing & Evaluation - Type:					
8.	VISUAL EVALUATIONOUT OFGUN SAMPLE					
9.	ENDURANCE - NO. OF GUNS TESTED:4					
	NO. OF ROUNDS PER GUN:					
	TOTAL ROUNDS FIRED IN TEST:					
	AMMO TYPE: MAGS; TARGET:					

RIM FIRE CENTER FIRE

Report No. 830941 Page 1

April 6, 1983

TO:

C. E. RITCHIE

FROM:

R. W. HOWE

REPORT TITLE:

M/SEVEN LWT PENDULUM DROPTEST TO EVALUATE NEW DESIGN TRIGGER

## **ABSTRACT**

On April 4, 1983, a request was received to test three (3) M/Seven LWT. rifles. Two with New Style Trigger, one with the Old Style Trigger, and also one M/700 with old style trigger. D. Bullis, Current Firearms Design, requested the Test Lab to do a Pendulum DropTest on these four rifles. To evaluate the Jar-Off resistance of the Fire Control Assembly.

#### SCOPE OF TEST

To evaluate and compare the Jar Off resistance of the Fire Control Assembly at a 3' drop height against a hardwood back stop.

### TEST RESULTS

Some Jar -Offs did occur in the top and bottom side modes at various heights as described in Result Sheet Appendix "A".

#### **BARBER - PRESALE R 0128933**

M/Seven LWT. Pendulum Drop Test To Evaluate New Design Trigger

Report No. 830941 Page 2

### REPORT TEXT

1. Trigger Pull and Sear Engagement was preset at minimum present Remington Specs.

Present Remington Specs. are:

Trigger Pull Lbs.

3.0 to 5.0 lbs.

Trigger Sear Eng.

.015 to .020

2 The four rifles were drop tested at the 3' drop height against a hardwood backstop in the following modes:

Muzzle First W/Safe in "On" & "Off" positions

Butt First W/Safe in "On" & "Off" positions

Right Side W/Safe in "On" & "Off" positions

Left Side W/Safe in "On" & "Off" positions

Top Side W/Safe in "On" & "Off" positions

Bottom Side W/Safe in "On" & "Off" positions

Results in Appendix "A".

Note: During .drop test, some Jar-Off did occur in the top and bottom side modes so it was decided to drop these guns at various other levels to determine what height the Jar-Off would occur. Other drop levels and results are recorded in Appendix "A".

3. After the first drop test was completed, all four (4) rifles were set at the minimum (3.0lb.) trigger pull and redropped in all test modes.

Also, one M/700 rifle from Test Report No. 820391 was added to this test. This rifle contained a new design trigger spring and screw as per Drawing Nos.:

Trigger Spring Dwg. No. SK A-3687

Trigger Screw Dwg. No. SK B-3688

- Results in Appendix "A".

#### TEST PROCEDURE

#### A. Measurements

Trigger Pull was taken at the start of each test.

Sear Engagement was taken at the start of each test.

#### **Test Conditions**

- 1. Trigger pull forces were taken on all test guns using a Chatillon Model IN-10 Spring Pull Scale (See Appendix "A".)
- 2. Sear Engagement was set on productions Optical Comparator in M/700 final assembly area. (See Appendix "A".)
- 3. The Pendulum Drop Test was conducted on all test rifles at the 3' and the various other drop levels against a hardwood backstop from the muzzle, butt, both sides, top and bottom. (See Appendix "A".

# Rifles Used in Test

M/Seven - Serial No. 7601285, Serial No. 7601292, Serial No. 7601289

M/700 - Serial No. A6351001, Serial No. B6341922

APPENDIX "A"

#### M/7 NEW STYLE TRIGGER EVALUATION

4/5/83 #830941 BARBER - PRESALE R 0128936

			TEST #1	l			TEST #2	#830941	
DROP/JAR-OFF TEST ( HARDWOOD SURFACE FI 3' DROP EVALUATION		M/7 New Styl Trigger	M/7 e New Style Trigger	M/7 Old Style Trigger	M/700 Old Style Trigger	M/7	M/7	M/7	m/700
Serial	#	#7601285	<u>#7601292</u>	<u>#7601289</u>	#A6351001	<b>#7601285</b>	<b>#</b> 7601292	<b>#7601289</b>	#16351001
SAFE POSITION		On Off	On Off	On Off	On Off	On Off	On Off	On Off	On Off
TRIGGER PULL									
(Lbs.) Avg.		3.5 lb	s. 316.	4.751b.	5.75lb.	3.01ь.	3.01b.	3.01b.	3.01b.
SEAR ENGAGEMEN	1 <b>T</b>	.015"	.015"	.015"	.015"	.015"	.015"	.015"	.015"
MUZZLE FIRST		Ok Ok	Ok Ok	Ok Ok	Ok Ok	Ok Ok	Ok Ok	Ok Ok	Ok Ok
BUTT FIRST		Ok Ok	Ok Ok	Ok Ok	Ok Ok	Ok Ok	Ok Ok	Ok Ok	Ok Ok
RIGHT SIDE		Ok Ok	Ok Ok	Ok Ok	Ok Ok	Ok Ok	Ok Ok	Ok Ok	Ok Ok
LEFT SIDE		Ok Ok	Ok Ok	Ok Ok	Ok Ok	Ok Ok	Ok Ok	Ok Ok	Ok Ok
BOTTOM SIDE	12" 18"	- Ok - 3 J/O	- Ok 4 - 1 J/04	~ Ok - Ok	Ok Ok Ok Ok	Ok Ok Ok 1 J/04	Ok Ok Ok 3 J/04	Ok Ok Ok 2 J/04	Ok Ok Ok 4 J/04
	24"	- 4 J/04		- 1 J/04	Ok Ok	Ok 2 J/04	Ok 4 J/04	Ok 4 J/04	Ok 4 J/04
	36"	Ok 4 J/04		Ok 2 J/04	Ok Ok	Ok J/0	Ok J/0	Ok J/0	Ok J/0
TOP SIDE	12" 18" 24"								Ok Ok Ok Ok Ok Ok
	36"	Ok Ok	Ok Ok	Ok Ok	Ok Ok	Ok Ok	Ok Ok	Ok Ok	0k J/0

NOTE: J/O means - Jar-Off (i.e. 3 J/O 4 means 3 Jar-Offs out of 4 tries.)

CERitchie: js 4/10/83

,	RESEARCH TEST	「& MEASUREMENT LAB WORK	Report No. 830941 REQUEST
Developmental Design Acceptance Pre-Pilot Pilot Production Accepta	nce	Safety Related	Werehouse Audit  Cost Reduction  Stake
FIREARM STA MODEL:	243	FORMAL TEST RESULTS ONLY	DATE REQUESTED: 4-4-83  DATE NEEDED BY: A.S.A.P.  REQUESTED BY: Sullis  WORK ORDER NO: C-1809-000
Strength Test Function Test Accuracy Test	Ammunitio	ntal Test Measure	mentsOther_DROP.
. DROP 3	Z M/: FEET	HISTEST:  7 LWT 243 CA  215, BOTH SIG	•
NEW STY	E TRIGO	SER - REZIVED	BOTH SIDES.
-GUNS REQUIRED: ±1 760 1285 ±1 760 1292 _	sull 3	3# engagement	.015"
accompanied by the Labs by the	Work Request, an	the Labs unless they are delivered to All Work Requests are ons.	DATE COMPLETED: TEST COMPLETED BY: REPORT DATE:

M/700 (CONTROL GUN) TARRED OFF 4TIMES IN 4 DROPS AT 24" (BOTTOM DROP ONLY) 0" "4" "18"

MOTE: M/700 CONTROL ALSO DATED ON TOP AT 12'-18' + 24" LOVERS 4 TIMES AT EACH LEVEL RESULTS 24" OK ALL 4 TIMES 18" OK """ 12" OK """

4-5-83									
		OFF	70	γo	94	<i>&gt;&gt;</i> 0	JAKRED OFF	JARRED. OFF	Pack
CONTROL GUM	M/700 SR##4635 1001	WO	γ0	OX	οK	σK	2/0	وبر	318. TR18 Pull
MITLWITNEW STYLE IRIGGER- 3 UROP LEST (THRO WOOD STOP OHLY)  NEW STYLE TRIG. NEW STYLE TRIG. CONTROL	12 sx#7601289	OFF	7/0	26	OK	οK	OK	TARRED	¥
EST (TIME	12 SER	HO	<i>%</i> 0	NO	χg	σK	УO	0 K	FOUR GUMS HAVE BEEN SET ENGAGEMENT (SEAR)
TRIG.	14 SUR#7601292	OFF	01	*0	Χo	)/o	λo	TMRRED OFF	UHS HAV
NEW STYLE TRIG.	14 SER#	HO	οχ	40	Do	OF	OK	. 0K	, ALL FOUR GUMS F.
-NEW STYLE 1RK.	13 ser #7601285	OFF	OK	ak	70	λo	OK	JARRED	. Mer.
MEN STY	13 ser #7	N0	OK	OX	ΟK	OK	0%	οK	Non
M/71W	GUN+SER#	POSITION.	MUZZLE	BUTT	RIGHT SIDE	LEFT	70P 90E	BOTTOM SIDE	

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BARBER - PRESALE R 0128941
 M/7 LWT DROP TEST SAFE "OFF" ONLY. (HARD WOOD STOP)
          (FOUR DROPS AT EACH LEVEL)
M > LWT GUN # 13 - JARRED OFF 2 TIMES IN 4 DROPS AT 24"

(BOTTOM DROP ONLY)

O" "4" "12"
M/7 LWT GUN#14- JARRED OFF 4 TIMES IN 4 DROPS AT 24"
(BOTTOM DROP DHLY) 3" "4" "18"
    (COMTRIL GUN)
M/7 LUT GUN#12 JARRED OFF 4711965 IH 4 DROPS AT 24"
(BOTTOM DROP ONLY) 2 " " 4" " 18"

O" " 4" " 12"
M/700 (CONTROL GUN) TARRED OFF 4 TIMES IN 4 DROPS AT 24"
(BOTTOM DROP ONLY) 0" "4" "12"
 NOTE:
    M/700 CONTROL ALSO DATED ON TOP AT
    12'-18" + 24" LEVERS 4 TIMES AT EACH LEVEL
```

18" OK " " "

12" OK "" "

RESULTS 24" OK ALL 4 TIMES

	NEW SI	YLE TRIGGE	R) FIRST TES	182	
M/7 LWT	3' DR	OP TEST	(HARD WOOD	o STOP OHLY	
GUN#	13 SERT ;	7601285 SAFE OFF	1	7601292 SAFE OFF	
MUZZLE FIRST	OK	OK	OK	OK	
BUT FIRST	OK	OK	OK	OK	
RIGHT SIDE	OK	OK	0 K	OK	
LEFT SIDE	OK	OK	OR	OK	
TOP	OK	OK	OK	OK	
BOTTOM	οK	*J.O.	OK	* J.O.	

J.O. = JARRED OFF (FIRING PIN FEZL)

3.25 3.55 3.50 AUG 3.52BS.

#13 TRIG PULL

3-3-3 AUG. 3LBS.

* CONTROL N " 450-475-500 AUG 4.75 LBS.

MYOU " " 550 600 575 AUG 5575 LBS.

4-4-83

HARD WOOD STOP N-SAKE OFF ONLY
M/7 LUT DROP TEST, B-BOTTOM ONLY
(4 DROPS AT FACH LEVER BELOW)

#14 TRIG PULL AUG OF THREE 3.5 LBS

M/7 LWT CONTROL GUN JARRED OFF 2 TAMES IN 4 AT 36"

1 " " " " " AT 24"

CONTROL TRIG PULL DUG OF THREE 4.75 LBS

REG M/700 DID NOT JAR OFF UNTIL 4 DROP.

M/700 TRIG PULL AUG OF THREE 5.75 LBS.

THE RESULTS BELONG W/5/83 JEST

(NEW CANTRIL GUNS)

WHY SAFE OFF 12" OK

2 MY 18"

Y IN Y 24" JARRED OFF

M/700 TOP + BOTTOM SAFE OFF 12" OK

(BUTTOM - U IN 4) 18" OK

(BOTTOM 4 IN 4) 24" OK

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	(NEW STYLE	TRIGGER	)		
MITLUT	3' DROP	TEST	(HARD WOOD	STOP	OHLY)

/19 / 2001	J DR		() TAKD 0000	
GUN#	ł	7601285 SAFE OFF	1	7601292 SAFE OFF
MUZZLE FIRST	OK	OK	ok	OK
BUT FIRST	OK	OK	OK	ox
RIGHT SIDE	OK	OK	OK	OK
LEFT SIDE	OK	OK	OK	OK
TOP	OK	OK	OK	OK
Boirom	OK	*T.O.	ÓK	* J.O.

J.O. = TAPRED CFF (FIRING PIN FELL)

# 13 TRIG PULL 2 3 3 5 255

# 111

#14 " " 3-3-3 AVS, 3CBS
* CONTROL " " 450-475-500 AVS 4.75 LBS

HARD WOOD STOP N-SAFE OFF ONLY
M/7 LIST DROP TEST, B-BOTTOM OHLY
(4 DROPS AT EACH LEVER BELOW)

M/7 LWT CONTROL GUN JARRED OFF 2 74MES IN 4 AT 36"

1 " " 4 AT 24"

1 OK — 4" " 4 AT 12"

CONTROL TRIG PULL DUG OF THREE 4.75 LBS

REG M/700 DID NOT JAR OFF CHTIL 4' DROP.

M/700 TRIG PULL AUG OF THREE 5.75 LBS.

M. 7-222 X3/361 Gualution

#### **BARBER - PRESALE R 0128948**

10-10-4

# REMINGTON ARMS COMPANY, INC.

NTER-GEPARTMENTAL CORRESPONDENCE

Remineto



Discribution: C. B. Workman

J. P. Linde G. Hill J. Brooks C. E. Ritchie

"CONFINE YOUR LETTER TO ONE SUBJECT ONLY"_____

RESEARCH TEST and MEASUREMENT REPORT - Report No. 831361

MODEL SEVEN - .222 CALIBER TRIAL & PILOT EVALUATION

Stepared by:

C. E. Ritchie

Date Prepared:

Prophead and Cleared By:

J.H. Hennings , | R.E. Nightingale,

Signature

C.E. Ritchis, Sr. Supervisor - Testing, Meas. & Mech. Analysis Lab

3---

# TEST & MEASUREMENT LAB REPORT

REPORT NUMBER:	831361				
REPORT TITLE:	Model Seven222 Caliber Trial & Pilot Evaluation				
MCDEL(S):	Seven				
GAUGE OR CALIBER:	.222				
DATE:	5-16-83				
WORK ORDER NO.:	81343-904				
PART NAME:					
DESIGNER/ENGINEER:	G. Hill/J. W. Brooks				
TEST TYPE:					
1.	PHOTO LAB				
2.	STRENGTH TEST - NO. OF GUNS TESTED				
3.	Function test - no. of guns tested				
4.	ACCURACY TEST - NO. OF GUNS TESTED				
5.	MEASUREMENTS - TYPE:				
6.	ENVIRONMENTAL TEST				
7.	Ammunition testing & Evaluation - Type:				
8.	VISUAL EVALUATION - 8 OUT OF 40 GUN SAMPLE				
9.	ENDURANCE - NO. OF GUNS TESTED:				
	NO. OF ROUNDS PER GUN:				
•	TOTAL ROUNDS FIRED IN TEST:				
	AMMO TYPE: MAGS; TARGET:				
	RIM FIRECENTER FIRE				

#### **BARBER - PRESALE R 0128950**

REMINGTON ARMS CO., INC. Firearms Research Division

Report No. 831361 Page 1

May 18, 1983

TO:

C. B. WORKMAN

FROM:

C. E. RITCHIE

REPORT TITLE:

MODEL SEVEN - .222 CALIBER TRIAL & PILOT EVALUATION

#### **ABSTRACT**

A request was received from G. Hill, Supervisor, Process Engineering, to perform a Trial & Pilot evaluation of the Model Seven .222 Caliber production firearm.

#### SCOPE OF WORK

Perform a Trial & Pilot evaluation on an 8 gun sample from a 40 gun production run.

### TEST RESULTS

Only a Visual Inspection was performed. The sample lot was rejected due to the following:

- 1.) 3 of the 8 guns had been assembled using old style unheat treated trigger guards with the tab bent in the old position (upwards).
- 2.) 1 stock was cracked.

Report No. 831361 Page 2

# REPORT TEXT

Of the 8 firearms inspected, the following major objections were pointed out:

- 1.) 3 of the 8 guns had been assembled using old style unheat treated trigger guards with tabs bent in the old position (upwards).
- 2.) I stock was cracked (beginning at the floor plate tab and running about 34" towards the muzzle of the gun).

These objections were the basis for rejection of this sample lot. No other physical testing was performed on the sample.

## TEST PROCEDURE

An eight gun sample was selected by Charles Stephens, Research Test Lab, from a 40 gun production run.

A visual inspection was conducted in the Test Lab on 5-17-83 at 1:00 p.m. by Z. Kowalski, Process Engineering, D. Bullis, Current Firearms Design, R. Nightingale and E. Ritchie, Test Lab. Guns were wiped down with a clean cloth and inspected by each member of the committee and comments were recorded. Comments on individual guns can be found in the Appendix.

APPENDIX

# <u>Visual Inspection - T & P Evaluation</u> <u>M/Seven .222 Cal.</u>

#### 7602556

- rear swivel screw hole not properly aligned.
- floor plate cover exceeds .026" gap .
- grip cap over polished to mis-shape the cap.

## <u>7602642</u>

- front swivel screw bright mark on dome and hole not properly aligned.
- dent in top of stock

#### 7602629

- 2 pin holes and 1 dent in stock.
- light checkering on pistol grip both sides.
- trigger guard used has tab bent in the old direction (appears not to be heat-treated).

#### 7602508

- excess space between floor plate pad and inlet cut in stock.

#### 7602651

- comb cut (left side) is mis-shaped.
- wood inlet rear of trigger guard impression of trigger guard in wood screw hole probably mis-aligned.
- 2 pin holes in the bottom of the fore-end area.
- light checkering pistol grip area both sides.

#### 7602631

- 2 dents in pistol grip.
- dent on left top rail of stock.
- bottom of comb is mis-shaped 3 flats.
- trigger guard used has tab bent in the old direction (appears not to be heat-treated).

#### 7602637

- cracked stock - starts at floor plate pad.

M/Seven - .222 Caliber Trial & Pilot Evaluation

## 7<u>602605</u>

- sight screw hole marred on rear sight.
- rear trigger guard screw marred.
- dent in floor plate pad.
- scratch on the floor plate cover.
- dent in top of the stock.
- trigger guard used has tab bent in the old direction (appears not to be heat-treated.)

# $\underline{\text{General Note}} - 1.) \quad \text{Barrel bracket on all guns were dull finished}.$

2.) Ejection port radius on the stock are all 3/16" radius drawing calls for 3/8" radius.

#### **BARBER - PRESALE R 0128955**

REMINGTON ARMS COMPANY, INC. Distribution: C. B. Workman C. E. Ritchie Į. **W**. Brooks Remington "CONFINE YOUR LETTER TO ONE SUBJECT ONLY". RESEARCH TEST and MEASUREMENT REPORT - Report No. 831361 Supplement M/SEVEN - .222 TRIAL & PILOT EVALUATION F. L. Supry Prepared by: 6-24-83 Date Prepared: Propired and Ceared By:

C.E. Ritchie.

Sr. Supervisor - Testing, Meas. & Mech. Analysis Lab

# TEST & MEASUREMENT LAB REPORT

REPORT NUMBER:		831361 Supplement				
REPORT TITLE:		Model Seven .222 Caliber Trial & Pilot Evaluation				
MODEL(S):		Seven				
GAUGE OR CALIBER:		.222 Caliber				
DATE:		6-24-83				
WORK ORDER NO.:		81343-904				
PARŢ NAME:		Rifle				
DESIGNER/ENGIN	NEER:	Requested by G. Hill				
TEST TYPE:						
	1.	PHOTO LAB				
	2.	STRENGTH TEST - NO. OF GUNS TESTED				
	3.	Function test - no. of guns tested				
	4.	ACCURACY TEST - NO. OF GUNS TESTED 8				
	5.	MEASUREMENTS - TYPE: 4				
6. 7.		ENVIRONMENTAL TEST				
		AMMUNITION TESTING & EVALUATION - TYPE:				
	8.	VISUAL EVALUATION - 8 OUT OF 40 GUN SAMPLE				
	9.	ENDURANCE - NO. OF GUNS TESTED:				
		NO. OF ROUNDS PER GUN:				
-		TOTAL ROUNDS FIRED IN TEST:				
		AMMO TYPE: MAGS; TARGET:				
		RIM FIRE CENTER FIRE 50 gr				

#### **BARBER - PRESALE R 0128957**

REMINGTON ARMS CO., INC. Firearms Research Division

Report No. 831361 Page 1

June 24, 1983

TO:

R. E. NIGHTINGALE

FROM:

F. L. SUPRY

REPORT TITLE:

MODEL SEVEN - .222 CALIBER TRIAL & PILOT EVALUATION

#### **ABSTRACT**

A request was received from G. Hill, Supervisor, Process Engineering, to perform a Trial & Pilot evaluation of the Model Seven .222 caliber production firearm.

The first Trial & Pilot sample of this firearm was rejected by a visual inspection committee on May 17, 1983. (Refer to Report No. 831361, dated 5-18-83.)

#### SCOPE OF WORK

Perform a Trial & Pilot evaluation consisting of Visual Inspection, Field Function, and Accuracy Testing on an eight gun sample from a forty gun production run.

#### TEST RESULTS

The eight gun sample was accepted in each phase of the Trial & Pilot evaluation. Individual results and comments on each phase of the evaluation are located in the Report Text section of this report.

#### REPORT TEXT

1. Visual — It was the consensus of the visual inspection committee that there were no major deterrents in the appearance of the (8) rifles inspected. However, the following observations were made on the rifles:

Serial No. 7613006 -Poor latch color

Barrel pad uneven from side to side

Over-runs on checkering.

Serial No. 7613454 - Poor latch color

Front of bolt handle marred Over-runs on checkering.

Serial No. 7613278 - Poor latch color.

Poor location of bolt marks on lugs Finish on recoil pad body.

Serial No. 7612795 -Poor latch color

Trigger guard marred left side.

Serial No. 7613306 - Poor latch color

Latch unhooked from trigger guard.

Serial No. 7612969 - Poor latch color

Butt pad dirty.
Pitt marks in finish.

Serial No. 7613510 - Poor latch color

Barrel inletting uneven

Rear trigger guard screw marred.

Serial No. 7613513 - Poor latch color

Dirt under finish - rear of trigger guard

Finish on left side appears to be two different colors.

 Field Function - 100 rounds were fired through each rifle in a field function test. The following results were obtained:

3 rifles had no malfunctions

l rifle had l malfunction

3 rifles had 2 malfunctions

1 rifle had 10 malfunctions

The rifle with 10 malfunctions (Gun No. 3, Serial No. 7613306) was examined by Process Engineers. It was determined that the magazine spring had been altered, resulting in a loose fit. A spring from another rifle was assembled into Gun No. 3 and the rifle functioned without any further malfunctions.

The overall malfunction rate, not including Gun No. 3, was 1%, which compared favorably to the Model 700 ADL Restyle .222 Caliber, accepted May 1983 and reported on in Report No. 831292.

Data sheets located in Appendix "A" contain individual results by rifle, shooter and ammo type.

#### REPORT TEXT - cont'd.

3. Accuracy - The Remington standard for .222 caliber is 2.2" center to center in a 5 shot group.

Three (3) five shot groups were fired with four of the Trial & Pilot rifles.

Each rifle was within Remington standards.

Data Sheets located in Appendix "B" contain the individual results.

## TEST PROCEDURE

## 1. Visual

- A.) The Visual Inspection Committee consisted of T. Plunkett, R. Murphy, R. Nightingale, F. Supry (Research); W. Warren (Quality Control), and Z. Kowalski (Engineering).
- B.) Each rifle was wiped down with a clean cloth and inspected by each member of the committee.
- C.) Rifles used for the visual inspection.:

Serial No. 7613513	7613454
7613006	7612795
7613306	7612969
7613278	7613510

#### 2. Field Function

Each rifle was subjected to a Field Function Test, conducted at the Ilion Fish & Game Club, consisting of 100 rounds of Remington and competitive ammunition cycling the action slow, medium and fast. The round robin system was used in this test. The weather was warm, sunny with temperatures around  $80^{\circ}$ F.

## 3, Accuracy

One-hundred yard accuracy was shot on four of the rifles by R. Williams and C. Stephens (Research Test Lab). Three, five shot groups were shot utilizing .222 Remington 50 gr. "Power Lokt" hollow point ammunition, Code No. S22 ND 4072.

Before shooting the rifles for accuracy, each bore was wire brushed with Hoppe's No. 9 Solvent and patched dry.

The rifles were cooled and cleaned between groups, and one "warmer" was fired prior to each group.

The following rifles were used for the 100 yard accuracy test: 7613454 7612795 7613510

#### 4. Ammunition

Function Test - Remi	ngton R.222R1	Code	Uloa	D0780
Remi	ngton R 222R3	Code	S22	ND4072
Remi	ngton R 222R4	Code	T15U	D2458
Feder	al 222A -	Code	3B	1268
Winch	nester X222R	Code	24SL21	24
Accuracy Test - Remi	ngton R 222R3	Code	S22	ND4072

APPENDIX "A"

TOTAL (FER INL.)

# FIELD CYCLE TEST - CENTERFIRE

Reprot	NU.1	831361
	-	SUPPLEMENT

PAGE	NO.	
~ == ~ ~	1144	

PREVIOUS
ROUNDS
TEST TITLE: SUMMARY SHEETS PER - RIFLE - AMMO TYPE - SHOOTER

TIL. RDS. FIRED:
TIL. MIJUNCTIONS:

"MAISTREET DATE: SUMMARY PROPERTY PROPERTY PATE: MIJUNCTION PATE: MIJUNCTION PATE: MIJUNCTION PATE: MIJUNCTION PATE: MIJUNCTION PATE: MIJUNCTION PATE: MIJUNCTION PATE: MIJUNCTION PATE: MIJUNCTION PATE: MIJUNCTION PATE: MIJUNCTION PATE: MIJUNCTION PATE: MIJUNCTION PATE: MIJUNCTION PATE: MIJUNCTION PATE: MIJUNCTION PATE: MIJUNCTION PATE: MIJUNCTION PATE: MIJUNCTION PATE: MIJUNCTION PATE: MIJUNCTION PATE: MIJUNCTION PATE: MIJUNCTION PATE: MIJUNCTION PATE: MIJUNCTION PATE: MIJUNCTION PATE: MIJUNCTION PATE: MIJUNCTION PATE: MIJUNCTION PATE: MIJUNCTION PATE: MIJUNCTION PATE: MIJUNCTION PATE: MIJUNCTION PATE: MIJUNCTION PATE: MIJUNCTION PATE: MIJUNCTION PATE: MIJUNCTION PATE: MIJUNCTION PATE: MIJUNCTION PATE: MIJUNCTION PATE: MIJUNCTION PATE: MIJUNCTION PATE: MIJUNCTION PATE: MIJUNCTION PATE: MIJUNCTION PATE: MIJUNCTION PATE: MIJUNCTION PATE: MIJUNCTION PATE: MIJUNCTION PATE: MIJUNCTION PATE: MIJUNCTION PATE: MIJUNCTION PATE: MIJUNCTION PATE: MIJUNCTION PATE: MIJUNCTION PATE: MIJUNCTION PATE: MIJUNCTION PATE: MIJUNCTION PATE: MIJUNCTION PATE: MIJUNCTION PATE: MIJUNCTION PATE: MIJUNCTION PATE: MIJUNCTION PATE: MIJUNCTION PATE: MIJUNCTION PATE: MIJUNCTION PATE: MIJUNCTION PATE: MIJUNCTION PATE: MIJUNCTION PATE: MIJUNCTION PATE: MIJUNCTION PATE: MIJUNCTION PATE: MIJUNCTION PATE: MIJUNCTION PATE: MIJUNCTION PATE: MIJUNCTION PATE: MIJUNCTION PATE: MIJUNCTION PATE: MIJUNCTION PATE: MIJUNCTION PATE: MIJUNCTION PATE: MIJUNCTION PATE: MIJUNCTION PATE: MIJUNCTION PATE: MIJUNCTION PATE: MIJUNCTION PATE: MIJUNCTION PATE: MIJUNCTION PATE: MIJUNCTION PATE: MIJUNCTION PATE: MIJUNCTION PATE: MIJUNCTION PATE: MIJUNCTION PATE: MIJUNCTION PATE: MIJUNCTION PATE: MIJUNCTION PATE: MIJUNCTION PATE: MIJUNCTION PATE: MIJUNCTION PATE: MIJUNCTION PATE: MIJUNCTION PATE: MIJUNCTION PATE: MIJUNCTION PATE: MIJUNCTION PATE: MIJUNCTION PATE: MIJUNCTION PATE: MIJUNCTION PATE: MIJUNCTION PATE: MIJUNCTION PATE: MIJUNCTION PATE: MIJUNCTION PA

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SUMMARY SHEET		acours Franco		SHELL	Erect	OW BACK	DON'T LOCK OPEN	FE FR MA	OM	Stems mag.	POWER OVERRIDE	<b>知</b>		CIIV	em Mber	l	JUMPS MAG.	R BINDS		OVERRIDE	THE CT.	TEACT	70	9	NT.S	IONS PER	RATE PER
RIFLE	ESJOHS	NO. OF	FIRING	TRA PUED	DOM'T E	DON'T BLOW	DON'T IL	ıst	2nd		POWER O	DON'T LOCK UP	ELIES .	TOW	RICHE	1477	L LIBER	FOLLOWER	LOADING	BOLT OW	ACCION BING UP	DON'TE EXTERACE	प्रकृति स्वतक्ष	ADJUSTMENTS	RESTACEMENTS	 MALFUNCTIONS	MALE BAT
1) 7613513													2				<b> </b>										
2) 7613006						<b> </b>	1										<u> </u>	<u> </u>			-	<u> </u>	<del> </del>	<del> </del>		 	
3) 7613306													5	,			3	<del> </del>			<del> </del>	-	_	<b> </b>		 	
4) 7613278															<b>ـــــ</b> ـــــــــــــــــــــــــــــــ		1	_			-	-				 	
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6)7612795				-			_					-	-				-				-	-		-		 	
7) 7612969												<u> </u>	<b> </b>			1	-					-		-		 	
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# FIELD CYCLE TEST - CENTERFIRE

REPROT NO.: 83/36/

PAGE NO.

PREVIOUS ROUNDS TEST TITLE: SUMMARY SHEETS PER - RIFLE - AMMO TYPE - SHOOTER

"MIFUNCTIONS"

TOURS TEST TITLE: SUMMARY SHEETS PER - RIFLE - AMMO TYPE - SHOOTER

"MIFUNCTIONS"

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SUMMARY SHEET		ACUMUS FIRED		STEETL	1501	BLOW BACK	lock open	1	ed om	STEWS MAG.	OVERRIDE	LOCK UP		B1 CIM	'EM MBEN	l	JUMPS MAG.	R BINDS		बराप्तामह	म्बर प्रक	TEACT	10	TIS .	STATES	CONS PER	RATE PER
Shooter	ESTOCKS	NO. OF	FIRING	TOA PUED SHELL	DOM: T. BIECE	DON'T B	DON'T IX	}	icii Suq	SHELLS	POWER O	OI I.ROG	ETTE	ros	RIGHT	Test	SHELL J	FOLLOWER	LCADING	BOLT OVERRIDE	ACTION BANG UP	DON'T EXTENCT	BEEN KAGES	ADJUSTMENTS	REPLACEMENTS	MALFUNCTIONS	MAIF. RATE
J. BAGGETTA													3				1										
R. HOWE													2														
C. STEPHENS					_								4	1			2										
R. WILLIAMS					_								1	_	1	2											
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TOTAL (FER MAL.)

# FIELD CYCLE TEST - CENTERFIRE

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	SUMMARY SHE BY	EET	g	ह उत्पक्तांड हमहा	t	ED SHELL	TORTE	DON'T BLOW BACK	DON'T LOCK OPEN	FE FR	om d.	STEMS MAG.	OVERRIDE	TOCK UP		et.	MBER		. JUMES MAG.	FOLLOWER BINDS	2	BOLT OVERRIDE	ACCITON BANG UP	DON'T EXTERACT	القتة	ADJUSTMENTS .	Reflacments		MALETUNCTIONS PER	BARBER-PRESALE R 0128963
	Ammo		SHOOTES	NO. OF	FIRING	TEA PERT	E. MOC	E. SEC	DOM: T		icii Sug	SHELL	POWER	DOM	FICE	103	TESTE !	1.021	TIMES	FOLIC	LOADING	BOLT	ACCETO	T. ECG ?	BREA KAGES	Stray	TELETA		MALEUN	3
`	R-60-PS	P					_	-						 	3				1				_							
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APPENDIX "B"

BAR	BER	- PRI	ESAI	LE R	012	8965

REPORT No. 831361

ACCURACY:

Minimum of 3 - 5-shot Groups

Gun # 5 SER. 7613454

Ammunition Used KFM. CAL. 222
50 G. POWER-LOKT H.P.
Provious Rounds INDEX R222R3
CODE S22 ND 4072.

	Group Size (in.)	Vertical Spread	Horizontal Spread
1	1.4	1.0	1.3
2	1.1	,3	1.0
3	1,3	.4	1.3
4			
5			

Avg. 1.26

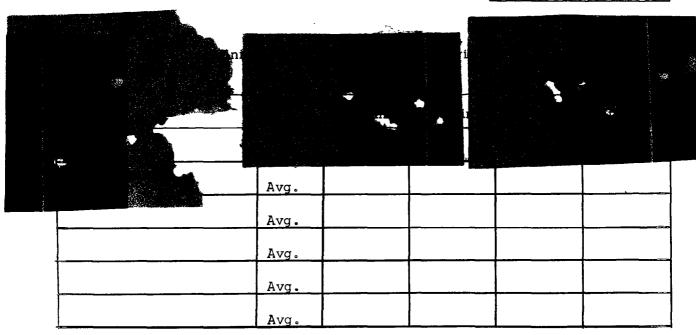
.56

REM. STOS. 2.2"-5 SHOT

Tester Date

R. WILLIAMS

6-16-83



Tester _	
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· Date

465

		REPORT No.	831361 Page
ACCI	JRACY: Minimum of	7 3 - 5-shot Groups	Gur # 6
	Ammunition Used REA	1. CAL. 222 Br POWER-LOKT H.P.	SER. 7612795
	President Rounds INC	S22 ND4072	<del></del>
	Group Size (in.)	Vertical Spread	Horizontal Spread
1	1.7	/.3	1.6
2	1.9	.9	1.7
3	2.1	1.7	2.0
4			
. 5			
A	vg	1.3	1.76
0	Ŷ	Tester	R. WILLIAMS
REM. I	STOS. 2.2"-5 SHOT		6-16-83
POINT	OF IMPACT: Minimum	f 2 10 - 11 - 12 1ps	
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	Avo	J.	
	Avo	J.	
	Avg	9.	
		Tester	
		Tester	

KEPORT No. 83136	/ Page	_
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ACCURACY:

Minimum of 3 - 5-shot Groups

Ammunition Used REM. CAL. 222

50 Gr. PowER-LoKT H.P. SER. 7612969

TNDEX R222R3

Code S22 ND4072

Gur#7

Group Size (in.) Vertical Spread Horizontal Spread 1.5 1.3 1.1 1 1.2 1.1 1.0 1.0 3 4 5

Avg. 1.3

1.2

1.0

REM. STOS. 2.2"-5 SHOT

Tester

Date

R. WILLIAMS 6-16-83

Avg. Avg. Avg. Avg

Tester	
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· Date

465

KEPORT No. 831361 Page_

ACCURACY:

M/7
Minimum of 3 - 5-shot Groups

Gun #8

Ammunition Used REM. CAL. 222 SER. 7613510

Provided Reunds INDEX R222 R3

CODE S22 ND 4072

	Group Size (in.)	Vertical Spread	Horizontal Spread
1	1.0	.8	, 9
2	2.0	1:1	1.7
3	1.3	1.3	.7
4			
5			

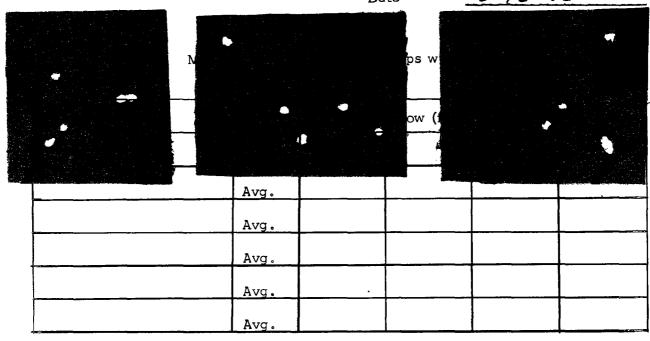
REM. STOS. 2.2"-5 SHOT

Tester

ter R. WILLIAMS

Date

6-16-83



Date

465

REPORT. No. 831361

M/7 CAL 222

AMMO REM. 222 50 GM POWER-LOKT HOLLOW PT.

IMDEX MAGNITS

LOE 322 ND4052

MOUNT - LEUPOLD RINGS - LEUPOLD Scope - LEUPOLD VARI-X-III 1.5 x 5

Qur#5 SER-7613454

JUN#6 SEC-7612795

Bur =7 3ER-76/2969 2nd Group Marc 2.00 11 300 mm

Jun #8 SEC-76/3510

The accuracy test was shot at the X.40. 100ya. rate
by RWilliams and C. Stephens

A total of three (3) five (5) shot groups were find with each of 4 nifles and the barrel cooled Let in ling.

Before shooting rifles for occuracy such bore was nire brusines with Hoppe's North Solvent and patched dry.

R-50-PSP

R-50-HP

F-50-SP

W-50-PSP

R-55-M. CASE

TOTAL (PER MAL.)

3. 0/c 5 0/c

> OK OK

5

<u>5</u>

2

3

4

PREVIOUS ROUNDS	DATE TEST		6-	15	- B			МО	Del:	7	ca.	<u>.</u>		i tona	<u>د ۲</u>	VIOLE	1_2	F 222CA				g	ERLA TTL.	L NO	. FI		3 5 81	5/3 //0 2	-
Jac Bob Chuck RON AMMINITION Load Bize	Ball Office		NO. OF ROUNDS FIRED	FRING	TINES CHELT	Don't Eject	HOH	DON'T LOCK OPEN	PR MM Ist		SHELL STEMS MAG.	POWER OVERRIDE	DON'T LOCK UP	HIGH	ST	MBER			FOLLOWER BIRINS	LOADING	BOLT OVERRIDE	ACTION BANG UP	DON'T EXTRACT	HREA TAGES	ADJUSTDRETES	REPLACEMENTS	BOLT VELOCITIES .	REMAI (ON 1	RKS BACK)
******		-										<del> </del>					<u> </u>	<del> </del>		<del> </del>		=	믇	-	┝╩╌				
R-50-PSP			15	OK		1	2 2	1 K		U	101	<u> </u>	0	07	80	2							<u>                                     </u>						
R-50-HP	M	2	15	æ_		11	12	e 3		2.	2 6	4	UD	4	77	, .				}			]						
R-55-M. CASE		0	15	OK	114	+	15	u	D	24	58							Ŀ											
F-50-SP	H	ő	15	OK		Ss	2 A		30	12	68																		
W-50-PSP			15			X 2	22	e	21	27.5	/ -	4_		25															
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TOTAL (PER MAL.)

INV TOUR	MTE:_ rest t					I	MO	P P			2	22 unct	<u>C</u>	<u>al</u>	·	 22C#	L.			,	TTL.	RDS	. FI	RED:	!	100	
MOLTINUMMA		ROUNDS FIRED		SHELL	Billion	DON'T BLOW BACK	DON'T LOCK OPEN	FEE FRO MAG	M	STEWS MAG.	OVERRIDE	LOCK UP		BT Clia	em Mber	JUMPS MAG.	FOLLOWER BINDS		ERRIDE	and up	TRACT	W	reres	SIMP	VELOCITIES .	REMAI	
Load Size	SHOOTER	IO. QF	FIRING	THATE CHECART	DOM'TE EL	DOM'T BE	DON'T LO	1 ^{9t}	Suq		POWER O	DOE'T LO	нти	LOW	RIGHT	SHELL J	FOLLOWE	LOADING	BOLT OVERRIDE	ACTION BANG UP	DON'T EXTRACT	BEEN THESE	ADJUSTMENTS	REPLACEMENTS	BOLT VEL	(ON 1	
R-50-PSP	2	15	ot																								
R-50-HP	3		ac																								
R-55-M. CASE	4	15	OK													Ŀ											
F-50-SP		15	ok																								
W-50-PSP	2	15			_		_				_		14	»1 ——		 				_				_			
R-50-PSP	2	5.	OF		-	-	╂	$\ \cdot\ $			-	<u> </u>			_	 	_	-			-	_	╂	_			-
R-50-HP	3	5	OK		1		1	$  \cdot  $								 <u> </u>				<b> </b>			<del>                                     </del>	-	<b> </b>		
R-55-M. CASE	4	5	OK		1			$  \cdot  $				<b> </b>	_														
F-50-SP	1	5	OK			Γ		$\prod$													,						
W-50-PSP	2	5	æ		T																<u> </u>						

FIELD CYCLE TEST - CENTERFIRE

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AMMUNITION		ROTHING FIRED		Sामकता.	IBCE	DON'T BLOW BACK	LOCK OPEN	FE FR MA	OM	STEMS MAG.	OVERRIDE	LOCK UP			em Mber		JUNES MAG.	R BINDS		ERRIDE	ang up	TRACT	SZ.	arrs	ENTS	OCITIES .	Ŗ <b>e</b> M <b>A</b> J	
Load Size	SHOOTER	NO. OF	FIRING	TISHS CHAZVEL	DOK'T BJECT	DOK.I D	מבייונים		2nd		POWER (	מבייבוסמ	EDIES.	109	RIGHE		SHELL	FOLLOWER	LOADING	BOLT OVERRIDE	ACTION HANG	DOR'T EXTRACT	BEEA KAGES	ADJUSTMERTS	REPLACEMENTS	BOLT VELOCITIES	(on 1	no No
R-50-PSP	3	B	1										3				1											
R-50-HP	4	15	_												12	15												
R-55-M. CASE	1	15											سرا				1											
F-50-SP	2	15	ok																									
W-50-PSP	3	15											13"	1			1											
														0			·											
R-50-PSP	3	2	~															·										
R-50-HP	4	5	~																									
R-55-M. CASE	$\prod$	5	ساء																									
F-50-SP	2	5	ok																			·						
W-50-PSP	3	3																										
TOTAL (PER MAL.)																												

FIELD	CYCLE	TEST	=	CENTERFIRE
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										•1	WIE	unci	'IONS	at .								ttl. Mlø	MAL UNCT	func Ion	TION RATE	8:	0	<del></del>
AMMUNITION		ROUNDS FIRED		SHELL	TSC-T	DON'T BLOW BACK	LOCK OPEN	•	eed Om	STEMS MAG.	OVERRIDE	LOCK UP		CHA	em Mber		JUNES MAG.	POLLOWER BINDS		ERRIDE	AUG UP	TRACT	82	KTS	STATES	CCTITES .	REMA	rks Back)
Load Size	SHOOTER	<b>6</b> 0	FIRING	TRAFFED SHELL	DON'T EJECT	E T. MOC	DON'T L	•	ich Sug		POWER (	DON'T IV	田田田	LON	RICHE		SHELL J	FOLLOWE	LOADING	BOLT OVERRIDE	ACCION BANG UP	DON'T EXTRACT	BREA RACES	ADJUSTMENTS	REPLACEMENTS	Bola Velocities	(ON 1	no Back)
R-50-PSP	4	15	OK																									****
R-50-HP		15	OK																									
R-55-M. CASE	2	15	OK		1.												·											
F-50-SP	3	15	ok																									
W-50-PSP	4	15	OK	_	_	_											-											
R-50-PSP	4	5	ok	-	-	-	-	-	-			-						_			-	_						
R-50-HP	1	5	OK					<del> </del>				<u> </u>						_			<u> </u>							
R-55-M. CASE	2	5	DIC																									
F-50-SP	3		0/2																			,						
W-50-PSP	4	S				_						_																
TOTAL (PER MAL.	,																											

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AMMUNITION		ROUMUS FIRED		SHELL	I GOT	DON'T BLOW BACK	LOCK OPEN	FE FR MA	ОМ	STEMS MAG.	OVERRIDE	LOCK UP		civ 81	em Mber		JUMPS MAG.	R BINDS		ERRIDE	ANC OF	TEACT	SJ SJ	5123	ENTS	VELOCITIES .	REMA	rke Back)
Load Size	SHOOTER	NO. OF	PERMIT	TRA PPED SHELL	Don't Ribor	E T. MOC	DOE'T L		icii Suq		1 .	7 1,100	HIGH	101	RUCKE		SHELL	POLLOWER	LOADING	BOLT OVERRIDE	ACTION BANG	DOR'T EXTENCT	BEFA TAGES	ADJUSTMERTS	REPLACEMENTS	BOLL VEL	(ON 1	
R-50-PSP	1	15	OŁ																									
R-50-HP	2	15	OF																									
R-55-M. CASE	3		OK		1												·											
F-50-SP	4	15	0K																									
W-50-PSP	1	15	ok				-		_	_					_													
R-50-P8P		5	OK		-		-		-			<u> </u>			_	-			-		-		_	-				
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R-55-M. CASE	3	5	DK																									
<b>F-</b> 50-SP	4	5	0K																									
W-50-PSP	1		OK			-	-							-				-										
TOTAL (PER MAL	.)																								_			

FIELD	CYCLE	TEST -	- CENTERFIRE

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AMMUNITION -		ROIMING FIRED		SHELL	EJECT	DON'T BLOW BACK	CK OPEN	FE FR	OM	STEMS MAG.	POWER OVERRIDE	ट्राट वर्ष		St CIIA	em Mber		Jumps Mag.	R BINDS		ERRIDE	ALTIC UP	TRACT	M	iers	ENTE	VELOCITIES .	REMA	
Load Size	SHOOTER	NO. OF	FIRING	TEA PURT	DOG***	E T. MOC	DON'T LOCK		2nd	1	POWER (	DON'T LOCK UP	HIER	LOW	RICHE	T-EFF	SHELL	FOLLOWER	LOADING	BOLE OVERRIDE	ACCION BANG	DON'T EXTRACT	BREAKAGES	ADJUSTMERTS	REPLACEMENTS	BOLT VE	YES	no
R-50-PSP	2	15	OK																									
R-50-HP	3		OK																									
R-55-M. CASE	4	15														,												
F-50-SP	1	15	ok																									
W-50-PSP	2	15	/										/															
																								<u> </u>				
R-50-PSP	2	5	OK															Ŀ										
R-50-HP	3	5	OK									L												<u> </u>				
R-55-M. CASE	4	5	OK																									
F-50-SP	1	5	ok																									
W-50-PSP	2	5																										
TOTAL (PER MAL.	)																											

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Trigger Pull(lbs.)	Bott Release Forme (Los.)
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··· –	2. <u>5.5</u>
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Gun Weight:	Safety Check:
Center of Gravity:	Fining Fin Protestics:
3070:	Fattern Test (Avg. of 5)
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Orifice Size:	Horz.:
Bolt Closing Velocity:	Vert.:
Magazine Syring Force:	Accuracy (Avg. of 5)
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	TIST PROTECTE SHEET
	Madai
•	Servai IIc. 764 35/3
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3	3. <u>9</u>
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Trisser Pull(lbs.)	Beir Release Force(lbs.)
= 4/2	<u>:. 5.5</u>
2. 4/2	2. <u>5.5</u>
3. 4h	3. <u>5.5</u>
Gun Length:	Primer Marking:
Gun Weight:	Safety Check:
Center of Gravity:	Firing Pin Provension:
30:4:	Sobraco Back (Associated
Choka:	Fattern Test (Avg. of 5)
Orifice Size:	Group Size:
Bolt Closing Velocity:	Tora.:
Magazine Spring Force:	Vert.:
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	Group Size:
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a=	Vers.: F.O.I.:_
CJS	Tester and Date:

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### SHOTOURS, PERCENTURE, REGERES (FINES & AUTOLOADERS)

	TEST FROGERINE SHEET
	12del 7
	Servai No. 7613306
Headatace as Received:	Sade - "ON" - 1. 10 "OFF" - 1.15
2	2. 10 2. 15
Front:  Headstroe after Front: 7.003	3. <u>10</u> 3. <u>15</u>
	Bolt Coen Force(Ubs.)
Firing Pin Indent(in.)	Cocked: I. 3. 5 Day Fired: I. 7.5
***	2. 3.5
2	3. 3.5 3. 7.5
3	
<u>Trisger Puli</u> (lbs.)	lath
E. 3.75	- <b>5</b>
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3. 3.7 <b>5</b>	<del></del>
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Jun Langth:	Primer Marking:
Gum Weight:	Safety Check:
Center of Gravity:	Firing Pin Protrusion:
Bore:	Fattern Test (Avg. of 5)
Choke:	Group Size:
Orifice Size:	Gorz.:
Bolt Closing Velocity:	
Magazine Spring Force:	7ert.:
Disconnector Check:	Accuracy (Avg. of 5)
	Group Size:
	dora.:
	Vert.: 7.0.I.:_
CJ3 T-T2-62	Tester and Date:

<u>Secretais, or</u>	DINGERS REFERS (FORS & AUTOLOADERS)
4	TEST FROMUNE SPEED  Middel
Eesdapace ta Receivad:	Sara - 'ON' - 1. 8.5 'OFF' - 1. 7.5 2. 8.5 2. 7.5
Proof:	3. <b>8.5</b> 3. 7.5
Firing Fin Indent(in.)  I  2	301t Cyen Force(lbs.)  Cocked: I. 7 Dry Fired: I. 9  2. 7  3. 7  3. 9
3	latch  Belease Force(lbs.)  I. <u>6.5</u>
2. <u>4.5</u> 3. <u>4.5</u>	2. <u>6.5</u> 3. <u>6.5</u>
Gum Langth:	Primer Yearing:
Gun Weight:	Safety Check:
Center of Gravity:	Firing Rin Decoration:
3ore:	<u>Pattern Test</u> (Avg. of 5)
Choke:	Group Size:
Orifice Size:	Eor2.:
Bolt Closing Velocity:	
Magazine Spring Force:	Accuracy (Avg. of 5)
Disconnector Check:	Group Size:
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	Vers.:
	7623.

CJ3 I-12-82 

## SHOUGHT, SEREETES, RESERVATORS & AUTOLOGISTS

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	Serrai IIo. 7613454
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	2. <u>8</u> 2. <u>8</u>
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Firing Fin Indens(in.)	Bolt Coen Force (10s.)
	Cocked: I. 5 Dry Fired: I. 9.5
	2. <u>5</u> 3. <u>5</u> 3. <u>9.5</u>
2	3. <u>5</u>
3	3
	lahh
Trigger Full(Dis.)	Beit Release Force(lbs.)
<u> </u>	<u>:. 5.5</u>
2. 4.25	2. 5.5
3. 4. 2.5	3. 5.5
J	
Sum langth:	Swiman Vaniering:
Gun Weight:	Safety Check:
Center of Gravity:	Timing Pin Protestin:
3ore:	Pattern Test (Avg. of 5)
Choice:	
Orifice Size:	Group Size:
Bolt Closing Velocity:	Horz.:
Magazine Spring Force:	Vert.:
Disconnector Check:	Accuracy (Avg. of 5)
	Group Size:
	Hors.:
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CJS I-12-82	Tester and Date:

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# SHOUGHS, CERLINGUES, REGUESS (FIRS & AUTOLOADES)

	TIST FROCTURE SHEET
	: todal
	Sernal No. <u>761279</u> 5
Eesdstage as Receivad:	Sade - "ON" - 1. 9 "ONE" - 1. 9
	2. <u>9</u> 2. <u>9</u>
?roof:	3. <u>9</u> 3. <u>9</u>
Readspace after Proof: + oul	· · · · · · · · · · · · · · · · · · ·
Firing Fin Indent(in.)	Bolt Cpen Force(lbs.)
	Cocked: I. 5.5 Dry Fired: I. 9.5
<u> </u>	2. <u>5.5</u>
2	3. <u>5.5</u> 3. <u>9.5</u>
3	
Trigger Pull(Ds.)	Bolt Release Force(lbs.)
<u> </u>	<u>=6</u>
2. 4	2. 6
3. 4	3. 6
<del></del>	
Jun Length:	Deiner Warring:
Gun Weight:	Safety Check:
Center of Gravity:	Firing Fin Protruction:
3029:	Fattern Test (Avg. of 5)
Choke:	
Orifice Size:	Group Size:
Bolt Closing Velocity:	iora.:
Magazine Spring Force:	Vert.:
Disconnector Check:	Accuracy (Avg. of 5)
	Group Size:
	iora.:
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CJS I-IZ-82	Tester and Date:

(1) <u>SHOTOURS, RESTE</u>	RUCES, RICUES (FORS & AUTOLOADES)
	TEST PROGRAMME SHEET
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	Servei 110.7612969
Essistace as Received:	3a2e - "ou" - 1.8.5
	2.8.5
Proof:	3. <b>8.5</b> 3. <b>8.5</b>
Resistance after Proof: 4,002	
Firing Fin Indent(in.)	Bolt Cten Force(lbs.)  Cocked: I. 4 Dry Fired: I. 7.5
I	2. 4 2. 7. 5
2	3. 4 3. 7.5
3	3·
Trigger Pull(Des.)	LATCH 300 Release Force(Ibs.)
=. 4.5	<u>=- 4.5                                   </u>
2. 4.5	2. <b>4.5</b>
3. <u>4. S</u>	3. <u>4.</u> S
Gun Length:	Prizer Maridag:
Gun Weight:	Safety Check:
Center of Gravity:	Firing Fin Provincion:
30:0:	Pattern Test (Avg. of 5)
Choka:	Group Size:
Oricice Size:	ëorz.:
Bolt Closing Velocity:	Vert.:
Magazine Spring Force:	Accuracy (Avg. of 5)
Disconnector Check:	Group Size:
	Hors.:
4 <del>-</del>	Vert.: P.O.I.;
ਹਿਤ I-I2-82	Tester and Date:

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# SHOTOUTS, JUNEAUTRES, RIFERS (FORS & AUTOLOADERS)

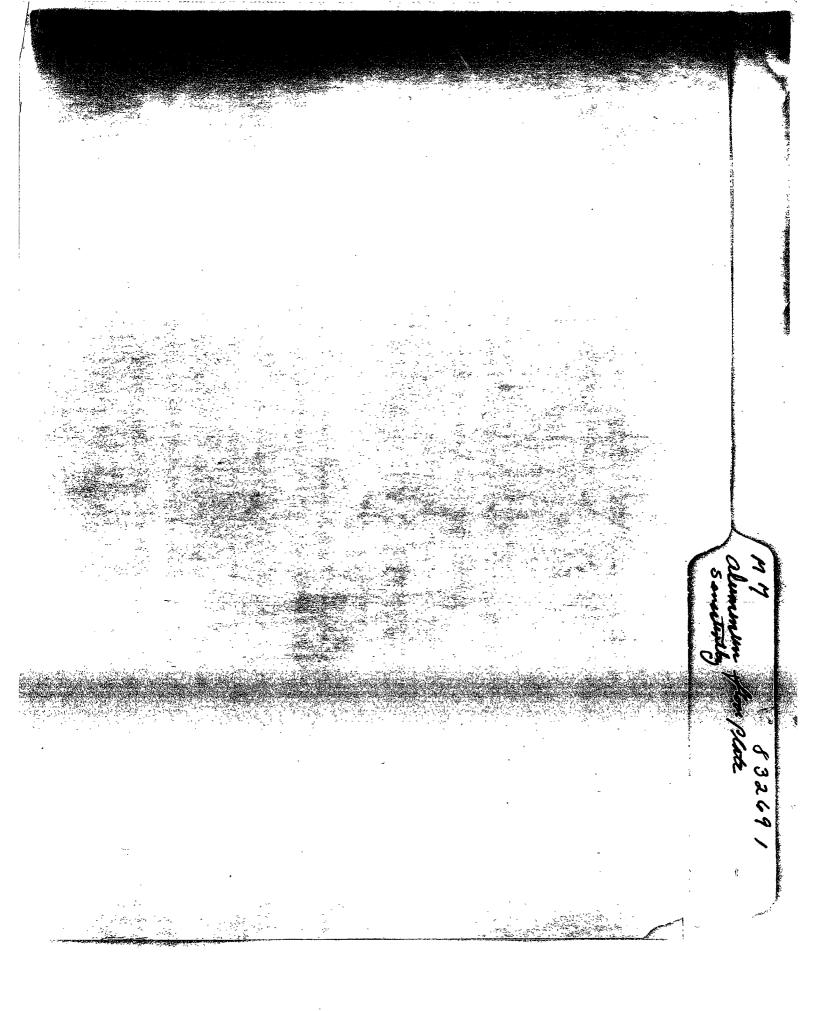
	TEST FROCEDURE SHEET
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? <u>~~~</u>	2. <u>8.5</u> 3. 8.5
Esedanace after Proof: 4.003	3. <u>0</u>
Firing Fin Indent(in.)	Bolt Crem Force(lbs.)  Cocked: I. 55 Dry Fired: I. 9
<u></u>	2. <u>5. 5</u>
3	3. <u>5.5</u>
*	
<u> </u>	<u> 3olt Release Force</u> (lbs.)
2. 4.25	2. <u>6</u>
3. 4.25	3. 6
Gun Langth:	Primer Mariting:
Gun Weight:	Safety Check:
Center of Gravity:	Firing Fin Provension:
3024:	Pattern Test (Avg. of 5)
Choke:	Group Size:
Orifice Size:	Eorz.:
Bolt Closing Velocity:	Veru.:
Magazine Spring Force:	Accuracy (Avg. of 5)
Disconnector Check:	
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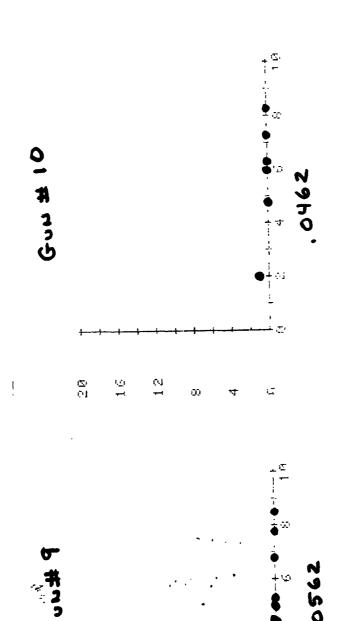
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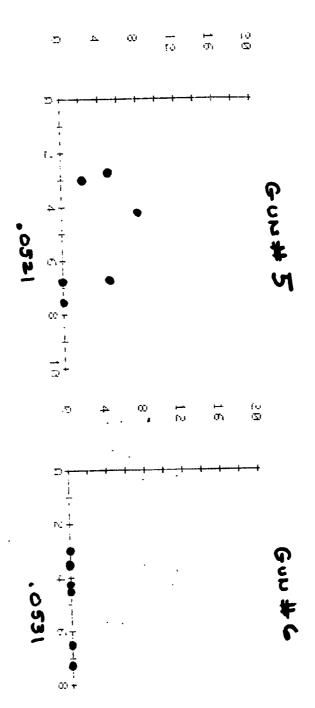


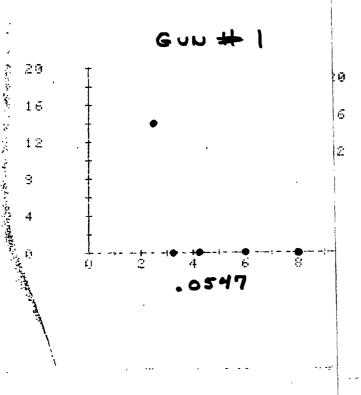
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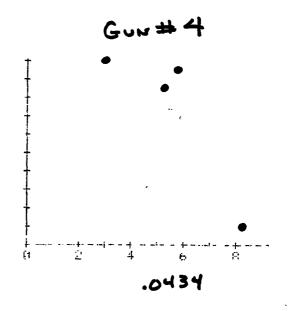
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`	surfaces cleaned out (scraped) to allow for good
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	filed as needed to allow for adequate latch
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# RESEARCH TEST & MEASUREMENT LAB WORK RECUEST

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OTE: NO firearms or parts will be tested	in the Labs unless they are	DATE COMPLETED:
accompanied by a Work Request, a	nd both are delivered to	TEST COMPLETED BY:
the Labs by the designer or enginee	r. All Work Requests are	REPORT DATE:
to be filled out in detail. No Excep	tions.	

NUMBER A-EXP 1169	REMINGTON ARMS OF RESEARCH & DEV. E	DEPT.	RECOMMENDED MATL. & HEAT TREAT  Material MUSIC. WIRE - PSTM. R.Z.Z.B.  Heat Treat. ST.R.E.S. R.E.L.E.W.E.
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_			INSPECTION  1. To work freely in .235 dia. hole  2. To work freely on dia. pin  3. Load 1.46 to 1.68 lb. at .300 length (with set removate)  4. Solid Height .258 max. 7. Winderwerth  5. Free Length .595 min. 8. Remove set ()  6. Ends SQUARED . Not GROUND (No [except for inspection])
			MANUFACTURE  9. Wire dia. 0/2 11. Free Length 625 (with set removed)  10. Outside dia. 082 12. Coils 20 Active /8 Total
			DESIGN DATA  13. Rate 4.83 lb./in.  14. Solid Stress 234,000 lb./sq. in.  15. Solid Load 1.80 lb.  16. Spring Index 5.83  17. Torsional Mod. G=11.5-x10  18. Concentric Corr. 1.26 (WMW)
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1. 28

ALTERATIONS

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C.E. Ritchie, Sr. Supervisor

Testing, Measurement & Mech. Analysis Lab

#### TEST & MEASUREMENT LAB REPORT

REPORT	NUMBER:	832691
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REPORT TITLE: PROTOTYPE ALUMINUM FLOOR PLATE SENSITIVITY ANALYSIS

MODEL(S): MODEL SEVEN LWT

GAUGE OR CALIBER: .308

DATE: 11/30/83

WORK ORDER NO.: C-1856-000

PART NAME: FLOOR PLATE ASSEMBLY

DESIGNER/ENGINEER: J.W. BROOKS/D.E. BULLIS

#### TEST TYPE:

⊥•	PHOTO LAB
2.	STRENGTH TEST-NO. OF GUNS TESTED
3.	FUNCTION TEST-NO. OF GUNS TESTED 10
4.	ACCURACY TEST-NO. OF GUNS TESTED Acceleration, Coverage, Opening
5.	MEASUREMENTS - TYPE Force, Screw Torque, Headspace
6.	ENVIRONMENTAL TEST COLD
7.	AMMUNITION TESTING & EVALUATION-TYPE
8.	VISUAL EVALUATION OUT OF GUN SAMPLE
9.	ENDURANCE-NO. OF GUNS TESTED: 2
	NO. OF ROUNDS PER GUN 2,000
	TOTAL ROUNDS FIRED IN TEST 4,000
	AMMO TYPE: MAGSTARGET:
	RIM FIRECENTERFIRE .308
	180 gr.

#### **BARBER - PRESALE R 0129007**

REMINGTON ARMS CO., INC. Firearms Research Division

Report No. 832691

Page 1

November 30, 1983

TO:

R. NIGHTINGALE

FROM:

S.R. FRANZ

REPORT TITLE:

MODEL SEVEN LWT PROTOTYPE ALUMINUM FLOOR PLATE SENSITIVITY ANALYSIS

#### ABSTRACT

A previous sensitivity analysis on the steel floor plate assembly showed that this design was sensitive to a number of variables and dimensions. In order to assure no floor plate openings with this design it would require 100% inspection of all floor plate assembly parts; a very costly and time consuming process. Because of this a new aluminum floor plate assembly was designed that would be cheaper to make and be less sensitive to manufacturing tolerances. (See Appendix for the Floor Plate Assembly Parts List) Prototypes were made and initial testing confirmed that the design was better from a functional standpoint. Production reviewed this design and recommended that some changes be made to allow for their manufacturing process. These design changes were made and 10 prototypes were built and assembled on .308 cal. actions. The Test and Measurement Lab received a work request from D.E. Bullis, Current Firearms Design, to run a sensitivity analysis on these prototype rifles.

#### SCOPE OF TEST

To determine the sensitivity of the new aluminum floor plate assembly to floor plate openings during live fire.

#### TEST RESULTS

Testing has proven that the new aluminum floor plate assembly is not as sensitive to floor plate openings as the steel assembly. The Report Text section contains a detailed explanation of the tests that were run as well as their results. Testing did show, however, that a condition exists that could adversely effect the functioning and appearance of the rifle. This condition is discussed below.

Report No. 832691 Page 2

TEST RESULTS - Contd.

Initial observations showed that the front trigger guard screw on all 10 rifles interfered with the floor plate when the floor plate was closed. This interference caused the floor plate to bow out. Not only does this detract from the appearance of the rifle but it also increases the load on the floor plate latch. This condition could also increase the sensitivity of the floor plate latch to floor plate openings because of this additional load. J.W. Brooks and D.E. Bullis were made aware of this condition so that corrective action could be taken. After this condition was found the front screw heads were filed down to eliminate this interference. The remainder of testing was completed with the filed down screw heads.

Although this testing has proven that the aluminum assembly is a good design we must remember that these were prototype parts machined in the Research N/C area and the Model Shop, not vendor parts handled by production. As soon as vendor parts are received another sensitivity analysis similar to this one will be run to increase our confidence level before production begins with this assembly.

Report No. 832691 Page 3

#### REPORT TEXT

A total of ten newly designed aluminum floor plate assemblies were tested for sensitivity to floor plate openings. Sensitivity to the following parameters were considered:

- Part Wear (endurance)
   Guard Screw Torque
   Fit to Stock (washers)
   Latch Coverage
   Opening Force

- 6. Lubrication7. Temperature (cold)

In addition, measurements, high speed movies and accelerometer measurements were taken to compare the aluminum to the steel assembly. An explanation of each test and the results follow.

Note: See last page in Appendix for prototype Floor Plate Assembly Parts List.

Report No. 832691 Page 4

#### TEST PROCEDURE

#### A. Measurements

Before any testing was done some preliminary measurements were taken on all the rifles. A listing of the measurements made and the range of values measured are listed below. (See Appendix for the complete data listing).

Opening Force: 2.25 --- 3.50 lbs.
Latch Coverage: 0.065 -- 0.085
Headspace; min + .004 -- min. +.005 in.
Screw Torque: pre-set at 25 lb-in
Stock to Floor Plate Cover Gap: 0.008--0.031 in.

#### B. Initial Shooting

After initial measurements all ten rifles had five rounds of Rem. 180 gr. .308 cal. ammo shot through them in the Test Lab jacks. No floor plate openings occurred.

#### C. Field Cycle Test

After the initial jack shooting all ten rifles were brought up to the Ilion Fish and Game Club for a full field function test. Each rifle was shot a total of 150 rds. of Rem. and Competitive ammo. All ten rifles shot malfunction free.

#### D. Measurements

The initial measurements were repeated after the Field Test to determine if any changes had occurred. A summary of the results are listed below. (See Appendix for complete data listing.)

Opening Force 2.25 -- 3.25 lbs.
Latch Coverage 0.064 -- 0.084
Headspace: min + .004 -- min. + .005 in.
Screw Torque: front 10 -- 25 lb. - in.
Rear 20 -- 25 lb - in.
Stock to Floor Plate Cover Gap 0.010 -- 0.031 in.

This data shows that the assembly screws did loosen slightly and that the front screw loosened more than the rear. This is explained under the Screw Torque Test.

Report No. 832691 Page 5

## TEST PROCEDURE - Contd.

E. Part Wear (endurance), High Speed Movies, Accelerometer Measurements

Two rifles were selected from the ten guns supplied for endurance testing. The rifles selected were:

Ser. No. 7603854 Ser. No. 7603221

Both of these rifles were shot 2000 rds. each using Rem. 180 gr. .308 cal. ammo. The floor plates on both rifles were opened and closed every 20 rounds throughout this test. Rifle No. 7603854 had high speed movies taken both before and after endurance. High speeds were taken to determine if the aluminum assembly moves during live firing and to determine if this movement increases as rounds are put on the rifle.

No rifle experienced floor plate openings during shooting. In addition, the high speed movies indicated that the assembly does move slightly downward (out of stock) but that it is considerably less that the steel assembly. There was also no noticeable increase in this movement in the second high speed taken after the 2000 rounds were fired. No floor plate latch movement was detected in either of the high speeds. This indicates that the slight movement of the floor plate housing is not enough to initiate latch movement during live firing. (These high speed movies are available for viewing in the Research Photo Lab.)

Accelerometer measurements were also made to confirm the movement of the floor plate assembly in the stock during live shooting. These measurements were taken with a PCB miniature accelerometer, Model No. 303A02, powered by a PCB power supply, Model No. 482A04. The accelerometer was mounted on the bottom of the floor plate housing to measure vertical acceleration. Similar measurements were also made on a rifle with a steel assembly for comparison. These measurements showed that the aluminum assembly had one-half of the downward acceleration of the steel assembly. This can be seen in the two graphs in the Appendix. These graphs show the Power Spectrum of the acceleration curves in the range of 0-2000 HZ taken with a WaveTek/Rockland Model 5830A Spectrum Analyzer. The graph for the steel assembly shows that the resonant frequency of the floor plate base is 335 HZ and the peak acceleration is 348 g's at this frequency. The second graph shows that the aluminum assembly resonates at approximately the same frequency but the acceleration is approximately half that of the steel assembly.

Report No. 832691 Page 6

TEST PROCEDURE - Contd.

#### F. Guard Screw Torque

The eight remaining rifles were used for this test. Screw Torque was set at seven different values and 20 rds. of Rem. 180 gr. ammo was fired per setting. After every 20 rds. screw torque was checked to determine if the screws had loosened up. The following torque settings were used: 1, 5, 10, 15, 20, 25 and 30 lb-in. No floor plate openings occurred at any of these values. Loosening of the assembly screws occurred at torques up to and including 15 lb.-in. No loosening occurred over the 15 lb-in level. This seems to contradict an earlier condition where the screws loosened after the field cycle test when they were pre-set at 25 lb-in. The difference between the two is that 150 rds. were fired on the field test and only 20 at the individual settings for this test. It should be stated here that the two endurance guns were fired 2000 rds. each without re-tightening the screws and no floor plate openings occurred. Although it seems that floor plate openings are not sensitive to screw torque, a torque of at least 30 lb-in is recommended.

#### G. Fit to Stock (Washers)

Production has stated that they cannot control the inletting depth for the floor plate assembly in the stock. This is true for all M/700 and Model Seven Lwt Calibers. To compensate for this lack of control they purposely inlet too deep and use spacers between the stock and the floor plate assembly to ensure a good looking fit to the stock. Using spacers in this way changes the interaction between the floor plate assembly and stock because support to the assembly is decreased. This test was designed to determine if this effects the performance of the floor plate assembly. Eight rifles were tested with no spacers and four spacers between the floor plate assembly and the stock. Each spacer was 0.015 in. thick. Twenty rds. of Rem. 180 gr. .308 cal. ammo was fired per condition and no floor plate openings occurred.

#### H. Latch Coverage

Initial measurements showed that latch coverage for this ten rifle sample was in a range of 0.065 to 0.085 in.

Latch coverage was decreased in four steps by filing away the floor plate edge on five rifles until each rifle had 0.005 in. coverage. At each increment 20 rds. of Rem. 180 gr. .308 Cal. ammo was fired. No floor plate openings occurred at any of the latch coverage increments. See data in Appendix.

Report No. 832691 Page 7

#### TEST PROCEDURE - Contd.

#### I. Opening Force

The same five rifles used for the latch coverage test were used here. Two conditions were tested. 20 rounds of Rem. 180 gr. .308 cal. ammo was shot with the floor plate latch springs at full length and then reshot with the springs cut to 3/4 length. The latch spring could not be cut any shorter than this and still exert a force on the floor plate latch. We considered that a 3/4 length spring would be the worst possible condition that could occur with this design and still allow proper functioning. Latch opening forces were measured for the full length and 3/4 length springs with the cover opened and closed for comparison. These numbers can be seen in the Appendix. No floor plate openings occurred on any of the five rifles with the full or 3/4 length spring. To go one step farther two of the five rifles had their latch springs completely removed and 20 rounds of ammo was shot through each. In this way the only force on the floor plate latch was the force due to the floor plate cover and friction. One rifle opened 1 out of 20 rds. and the other opened 2 out of 20 rds.

#### J. Lubrication

All firearms should be cleaned and oiled periodically to ensure proper functioning. However the frequency and extent of cleaning depends on the individual. This lubrication test was designed to test the extremes of lubrication on the rifle in the floor plate and latch area. The two conditions tested were with no lubrication at all on the assembly (dry) and with the assembly saturated with Du Pont Teflon wet lubrication. Two Model Seven's were selected for this testing. In addition three competitor's rifles were also tested for controls. These rifles were: Win. M/70 in. .30-06 cal. Browning BBR in .30-06 cal. S&W M/1500 in .30-06 cal.

20 rds. of Rem. 180 gr. .308 cal. ammo was fired per condition in the Model Seven's and Rem. 180 gr. 30-06 cal. ammo was fired in the competitor's rifles. None of the rifles, Model Seven's or competitor's, experienced any malfunctions during this test. Latch opening forces were measured with and without lubrication on all the rifles tested. These measurements show little if any difference in opening forces between the two conditions. This data can be found in the Appendix.

Report No. 832691 Page 8

TEST PROCEDURE - Contd.

#### K. Temperature (Cold)

Firearms are used in all types of climates and temperature extremes. They, therefore, have to operate properly in these conditions. The cold test determines if firearms will operate properly in extremely low temperatures. The same two Model Seven's used in the lubrication test along with the three competitors listed above were stored overnight in the lab's freezer at -30 Deg. F. The following day they were removed and floor plate latch opening forces were measured. Following these measurements 20 rounds of ammo was shot through each rifle. After shooting latch opening forces were measured again. No floor plate openings occurred on any of the rifles. See Appendix for opening force data.

# M/ 7 SENS. ANAL.

# TESTING SEQUENCE

- o MEASUREMENTS
- o FIELD TEST ALL 10
- o MEASUREMENTS
- o PICK TWO FOR ENDURANCE
- o H.S. ONE ENDUR. GUN
- o ENDUR. 2 TO 2000 RDS.
- o H.S. AFTER ENDURANCE
- o GUARD SCREW TORQUE TEST
- o FIT TO STOCK (WASHERS)
- o OPENING FORCE
- o LATCH COVERAGE
- o 2 GUNS FOR:

TEMPERATURE TEST LUBRICATION TEST

#### APPENDIX

- o Measurements
- o Field Cycle Sheets
  o Endurance Sheets
  o Acceleration Data

- o Screw Torque Data
- o Fit to Stock Data

- o Latch Coverage Data
  o Opening Force Data
  o Lubrication Data
  o Cold Test Data
  o Floor Plate Assembly Parts List

## BEFORE TEST-0 RDS

GUN NUMBER	OPENING FORCE (1b)	COVERAGE	WOOD/COVER GAP (in)	HEADSPACE MIN+	SCREW TORO. FRONT.REAR
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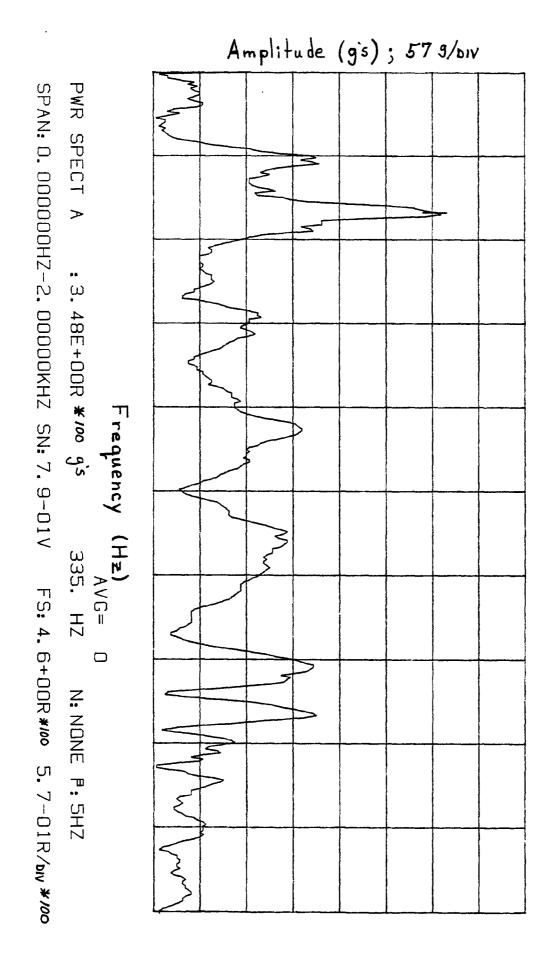
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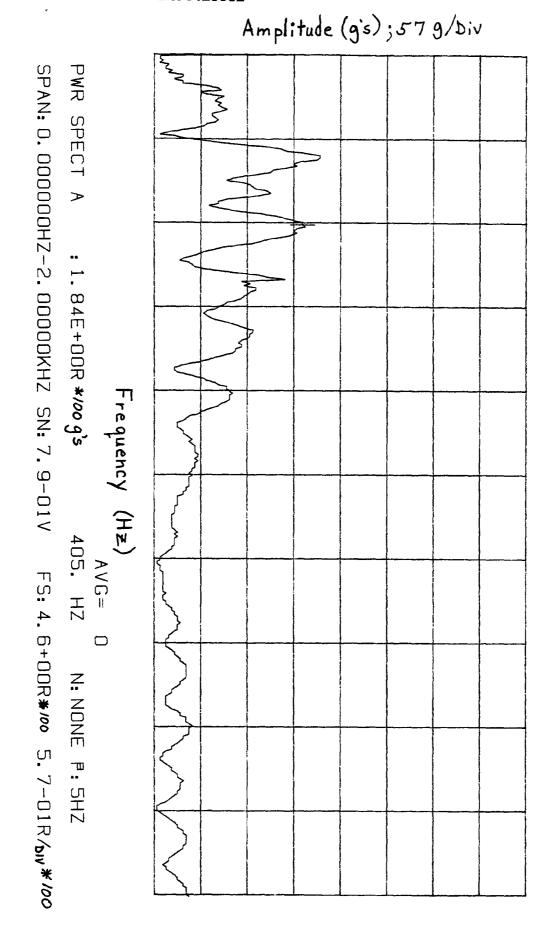
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AMMUNITION Load 81ze    DOD	"MLFUNC		308 BER PS High speed 1TT MA	RIAL NO. 760386 TL. RDS. FIRED: TL. MALFUNCTIONS: ALFUNCTION NATE:	54
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# STEEL ASSEMBLY





# SCREW TORQUE TEST

ERIAL NO	1 in-1b	5 in-lb	10 in-1b	15 in-1b	20 in-1b	25 in-1b	30 in-lb
4086	ок	OK	0K	OK	OK.	0K	OΚ
4091	ΟK	0K	OΚ	ÛK	OΚ	OK	θK
3907	OK	OK	0K	8K	ÐΚ	ok	Ok.
3187	οK	OΚ	OΚ	OΚ	ūΚ	OΚ	ΩK
4201	ΘK	OK	οк	ок	0K	ok	٥٢
4244	OK	ΩK	OΚ	ΩK	OK	ΩK	ΰK
3910	or:	OK	οκ	or.	0K	OΚ	OK
3821	OK	ΟK	OΚ	ОК	OK	ΟK	OK

20 rounds were fired per condition.

# FIT TO STOCK (WASHERS)

SERIAL NO 4086 4091 3907 3187 4201 4244 3910 3821	NO SPACERS (0.0")  OK  OK  OK  OK  OK  OK  OK  OK  OK  O	4 SPACERS (.060")
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20 rds fired per condition.

# LATCH COVERAGE TEST

SERIAL NO	4086	4091	3907	3187	4244
COVERAGE	.075-0K .065-0K .055-0K .045-0K .035-0K .025-0K .015-0K	.050-0K .030-0K .010-0K .005-0K	.050-0K .030-0K .010-0K .005-0K	.060-0K .040-0K .020-0K .010-0K .005-0K	.055-0K .035-0K .015-0K .005-0K

20 rounds fired per condition.

# OPENING FORCE TEST

SERIAL NO 4244 3187 3907 4091 4086	3/4 LENGTH OK OK OK OK OK	FULL LENGTH  OK  OK  OK  OK  OK  OK  OK  OK	nds fired condition
	OPENING FORCES		
SERIAL NŪ	3/4 LENGTH OPEN CLOSED	FULL LENGTH OPEN CLOSED	
4244 3187 3907 4091 4086	.75 1.25 .75 1.25 .75 1.75 .75 2.75 .75 1.75	1.25 2 1.25 1.75 1.5 2.25 1.5 3 1.25 3	

# LUBRICATION TEST

MODEL	SERIAL NO.	LUB FIRING	RICATION OPENING FORCE
REM M/7 REM M/7 WINCHESTER M/70 BROWNING BBR S&W 1500	7603910 7603821 G1486933A 01185RP117 PN00862	0K 0K 0K 0K 0K	2.25 2.50 6.00 4.00 5.25
		NO LU FIRING	JBRICATION OPENING FORCE
REM M/7 REM M/7 WINCHESTER M/70 BROWNING BBR S&W 1500	7603910 7603821 G1486933A 01185RP117 PN00862	0K 0K 0K 0K	2,25 3,50 6,75 4,00 5,25

20 rds fired per condition

# COLD TEST (-30 F)

MODEL  REM M/7 REM M/7 HINCHESTER M/70 BRCHNING BBR S&W 1500	SERIAL NO. 7603910 7603821 G1486933A 01185RP117 PN00862	FIRING OK OK OK OK OK	BEFORE FIRING OPENING FORCE 2.25 3.25 4.00 3.75 4.00
REM M/7 REM M/7 WINCHESTER M/70 BROWNING BBR S&W 1500	7603910 7603821 G1486933A 01185RP117 PN00862		AFTER FIRING OPENING FORCE 2.25 3.25 5.00 4.00 5.00

20 rds fired per condition

Prototype Aluminum
Floor Plate Assembly
Parts List

4-92909	TRIGHER Guard	92909	92909	
	ASSEMBLY	92822	92822	
B-92848	Floor Plate Latch	92848	92848	
	Floor Plate Latch Blank	92885	92885	
A-92847	Floor Plate Latch Spring	92847	92847	
A-92846	Floor Plate Latch Pin ,	92846	92846	
D-92889	Sub-Assembly	92889	92889	
A-16453	Floor Plate Pivot Pin	16453	16453	
D-92839	FloorPlate Cover	92839	92839	
D-92838	Floor Plate Cover Blank	92838	92838	
D-92837	Trigger Guard	92837	92837	
D-92836	Trigger Guard Blank	92836	92836	
B-92849	Front Guard Screw Spacer	92849	92849	
	Front Guard Screw Spacer Blank 929		92883	
B-92850	Rear Guard Screw Spacer	92850	92850	-
	Rear Guard Screw Spacer Blank	92884	92884	

Report No. 832691

### RESEARCH TEST & MEASUREMENT LAB WORK REQUEST

	AREA	OFTESTING
	Safety Related	Litigation
Design Acceptance	Competitive Evalua	tion Warenouse Audit
Pre-Pilot	New Design	Cost Reduction
?llot	Design Change	Stake
Production Acceptance	Plant Assistance	<u></u> Other
FIREARM STATS.  MODEL: 7 LINT  CAL or GAGE: 308  BARREL TYPE: CARBINE  PROOFED: YES V NO	REPORT REQ'D.  FORMAL  TEST  RESULTS  ONLY	DATE REQUESTED: 9/26/83  DATE NEEDED BY:  REQUESTED BY: D. BULLIS  WORK ORDER NO: C-1856-600
	TEST TYPE	_
Strength Test Ammuniti  Function Test Environme Accuracy Test Customer		Other SENSITIVITY TE
EXPLAIN IN DETAIL THE REASON FOR T	HIS TEST:	
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REMINGTON ARMS COMPANY, INC.  INTER-OFFICE COMPANY, INC.  Remington  "CONFINE YOUR LETTER TO ONE SUBJECT ONL	Y"	Distribution:	C. B. Workman J. W. Brooks C. E. Ritchie
RESEARCH TEST and MEASUREMENT REPORT MODEL SEVEN223 CALIBER - DESIGN A	RT - Raport No.	831291 830632 831791 LUATION	
- ·	Prepared by:	C. Stephens July 11, 1983	
Propiesed and Cleared By:  J.H. Hennings ,   R.E. Nightingsle, Foreman-Test Lab   Foreman-Measurement Lab	\200	Pay htmale	- 2-21-83
C.E. Ritchie, Sr. Supervisor - Testing, Mess. & Mech. Analysis Lab	Signature  Signature	O 0 Detrbué	7/21/83 Date

REPORT NUMBER: 831791

# TEST & MEASUREMENT LAB REPORT

REPORT TITLE:	Model Seven .223 Cal Design Acceptance Evaluation									
MODEL(S):	Model Seven									
GAUGE OR CALIBER:	.223									
DATE:	7-11-83									
WORK ORDER NO.:	C-1861-000									
PART NAME:										
DESIGNER/ENGINEER:	J. W. Brooks									
TEST TYPE:										
1.	PHOTO LAB									
2.	STRENGTH TEST - NO. OF GUNS TESTED									
3.	FUNCTION TEST - NO. OF GUNS TESTED 9									
4.	ACCURACY TEST · NO. OF GUNS TESTED 5									
5.	MEASUREMENTS - TYPE:									
6.	ENVIRONMENTAL TEST									
7.	AMMUNITION TESTING & EVALUATION - TYPE:									
8.	VISUAL EVALUATION - OUT OF GUN SAMPLE									
9.	ENDURANCE - NO. OF GUNS TESTED:									
	NO. OF ROUNDS PER GUN:									
	TOTAL ROUNDS FIRED IN TEST:									
	AMMO TYPE: MAGS; TARGET:									
	RIM FIRECENTER FIRE									

### **BARBER - PRESALE R 0129073**

REMINGTON ARMS CO., INC. Firearms Research Division

Report No. 831291

830632 831791

July 11, 1983

TO:

R. E. NIGHTINGALE

FROM:

C. STEPHENS

REPORT TITLE:

MODEL SEVEN .223 CAL. - DESIGN ACCEPTANCE EVALUATION

### ABSTRACT

On 6-28-83, a request was received from J. W. Brooks, Supervisor, Current Products Design, to function test nine rifles from the shoulder and test five for accuracy.

### SCOPE

To evaluate the acceptability of the Model Seven .223 caliber into the Model Seven rifle line.

### TEST RESULTS

The results show a malfunction rate of 1.8 with three malfunctions out of 162 rds. shot. The five rifles shot for accuracy were all within Remington Specs. which is 2.2 ins.

The nine rifles were previously used in two function tests and had feeding malfunctions (Report No.'s 831291 and 830632).

### REPORT TEXT

Nine Model Seven rifles used in a previous function test (Report No. 831291) were used in the test. Each rifle was shot a total of 18 rounds using slow, medium and fast rates of feed. The magazine box from Rifle No. 7600150 was used in all the rifles. Each magazine spring was checked to make sure it was forward in the follower and latch cover. A total of 162 rounds were shot with 3 malfunctions. Appendix "A" Data Sheets 1 - 10 contains the summary and individual information for each rifle.

After the function test, five rifles were tested for accuracy. Each rifle was shot for three five shot groups with each group and then one fouling shot fired after cooling. Each rifle bore was wire brushed with Hoppe's No. 9 solvent and patched dry. Each rifle was shot using a 10X Lyman Scope with a Tasco mount, Weaver Scope Rings and Remington 55 gr. pointed soft point ammunition.

The average group size was within Remington specifications for all five rifles. Data Sheets 11 - 15 contain the individual information for each rifle.

### TEST PROCEDURE

### A. Measurements

No measurements were taken.

### B. <u>Test Condition</u>

1. Same code of ammunition to be used.

### C. Test

The function test was conducted in the R & D 50 yd. range by C. Stephens and F. Supry. Eighteen rounds shot per gun using slow, medium and fast feeding. The same magazine box was used for all rifles and each magazine spring checked to make sure it was all the way forward in the follower and latch cover.

The accuracy test was shot in the R & D 100 yd. range by R. Williams and C. Stephens. Three five shot groups were fired per rifle.

# D. Ammunition

1. Remington 55 gr. Pointed Soft Point (Code D3633).

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REPROT NO.1 831//4			DILLAOI											
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FIELD	CYCLE	TEST	- CENTERFIRE

REPROT NO.1 83/171

	1MTE: 6-38-83 MODEL: 7 CAUGE: .333							BERIAL NO. 156																					
PREVIOUS 126	TEST TITLE. TUNICTIONS"								TTL. RDS. FIRED: 18 TTL. MALFUNCTIONS: 1 TIONS" MALFUNCTION RATE: 5.5																				
			ROMINS FIRED		SHELL	100	DON'T BLOW BACK	DON'T LOCK OPEN	FE FR MA	om d.	STEMS MAG.	POWER OVERRIDE	DCX EE		et CIV	em Mber	l .	JUMPS MAG.	FOLLOWER BINDS		BOLT OVERRIDE		TERACT.	ĸ	eners.	(Entra	ì		
		SHOOTER	NO. OF	FIRING	THA PPETD STREET	DON'T EIBCT	1.100	ביוצכב	lat LA	rcii Suq	SHELL	POWER	DON'T LOCK UP	HIGH	IOI	REELE	1	SHELL	FOLLOW	LOADING	BOLT O	ACTON BANG UP	DON'T EXTERACT	BEDA KAGES	ALJUSTMENTS	ecet A Cambinas			
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TOTAL (PER MA	L.)																												

REMARKS							<u>DIAGRAM</u> (IF NEEDED)
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FIELD	CYCLE	TEST	- CENTERFIRE	3

REPROT	NO.	231	791
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PREV LOUS	D A!	DATE: 5-98-83 MODEL: 7							daude: a973					BERIAL NO. 7600157															
LSP 199	TE	TEST TITLE. Function TTL. RDS. FIRED: 18 "MIFURCTIONS" "MIFURCTIONS" TTL. RDS. FIRED: 18 TTL. RDS. FIRED: 18 TTL. RDS. FIRED: 18 TTL. RDS. FIRED: 18 TTL. RDS. FIRED: 18 TTL. RDS. FIRED: 18 TTL. RDS. FIRED: 18 TTL. RDS. FIRED: 18 TTL. RDS. FIRED: 18 TTL. RDS. FIRED: 18 TTL. RDS. FIRED: 18 TTL. RDS. FIRED: 18 TTL. RDS. FIRED: 18 TTL. RDS. FIRED: 18 TTL. RDS. FIRED: 18 TTL. RDS. FIRED: 18 TTL. RDS. FIRED: 18 TTL. MALFUNCTIONS: 0 MALFUNCTION RATE: 0																											
			ACUNDS FIRED		SHELL		DON'T BLOW BACK	DON'T LOCK GREN	FE FR MA	OM	STEMS MAG.	POWER OVERRIDE	日数		chy al	em Mber		SHELL JUMPS MAG.	FOLLOWER BINDS		ERRIDE	ANG UP	TEACT	S 2		ENTS			
		SHOOLES	No. OF	PERTON	THE CHART	DOM'T RIBOT	H L. MOC	L T. NOT		rcii Suq		POWER (DOM'T LOCK UP	HIEE	103	<u>स्टा</u> स	I ESSI	SHELL	FOLLOW	LOADING	BOLT OVERRIDE	ACTION BANG UP	DON'T EXTERACT	BEELVELCES	ADJUSTIMENTS	REPLACEMENTS			
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TOTAL (PER P	WF.)																												

ARKS						IF NEEDED)
INTERNITION						BAVUDVIII

REPORT No. 831791 Page 13

ACCURACY: Minimum of 3 - 5-shot Groups

Gur # 4 7600150

Previous Rounds

Ammunition Used REM. CAL. 223

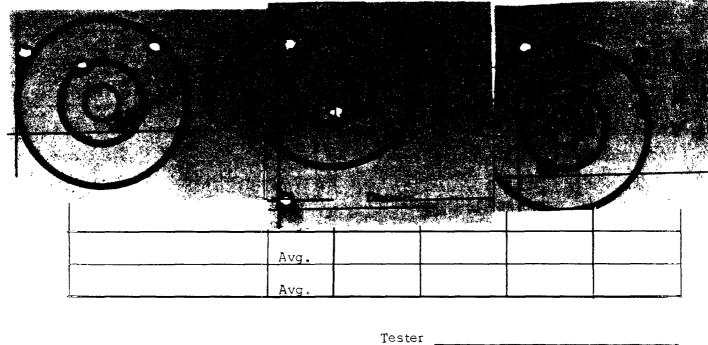
-	SOFT F 23 RI			
D363				

	Group Size (in.)	Vertical Spread	Horizontal Spread
1	1.5	. 9	1.5
2	1.8	1.8	1.2
3	1.7	1.5	1.3
4			
5			

1.4 1.3

Tester *R. Williams* Avg. 1.6

7-8-83 Date



Date

REPORT No. 83/79/

ACCURACY: Minimum of 3 - 5-shot Groups

GUN#6

Ammunition Used <u>REM. CAL.</u> 223 7600157 55 Gr. Ptd. SOFT PT.

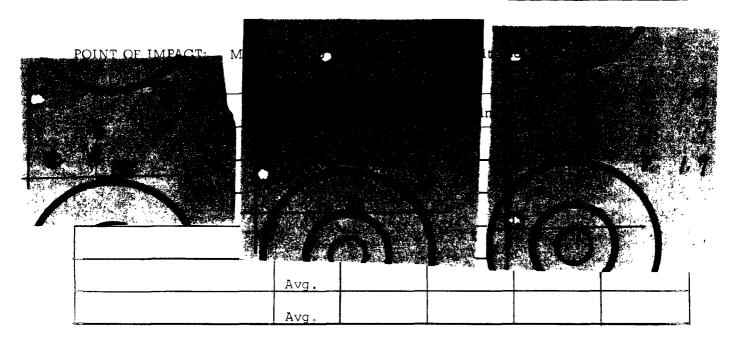
Previous Rounds INDEX R223R1
CODE D3633

	Group Size (in.)	Vertical Spread	Horizontal Spread
1	1, 3	.8	1.0
2	1.7	1.7	1.0
3	1.9	1.9	.7
4			
5			

ster R. Williams Avg. 1.6 1.4

Tester

Date



Tester _____

Date

REPORT No. 831791 Page 14

ACCURACY: Minimum of 3 - 5-shot Groups

Ammunition Used

REM. CAL. 223

55 År. Ptd. S.FT PT.

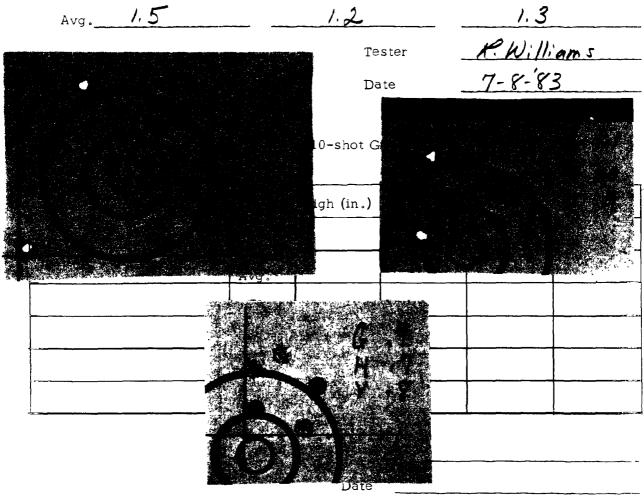
Previous Rounds

LNDER R223 R1

CODE D3633

Gur	#	7	
7	160	015	6

	Group Size (in.)	Vertical Spread	Horizontal Spread
l	2.5	1.9	2.2
2	1.1	, 9	1.0
3	, 9	.8	. 7
4			
5			



ACCURACY: Minimum of 3 - 5-shot Groups Gur # 8

Ammunition Used <u>PFM. CAL. 223</u> 7600149 55 Gr. Ptd. SoFT PT.

Previous Rounds INDEX RJ23 RI CODE D3633

	Group Size (in.)	Vertical Spread	Horizontal Spread
1	1.9	1.8	, 9
2	1.6	1.1	1,1
3	1.7	. 8	1.7
4			
5			

Avg. 1.7 1.2 R. Williams Tester 7-8-83 Date 3 - 10-sho High (in

Date

ACCURACY: Minimum of 3 - 5-shot Groups

ACY: Minimum of 3 - 5-shot Groups

Ammunition Used REM. CAL. 223

55 Gr. Ptd. Soft PT.

Previous Pounds

Previous Rounds INDEX R213 R1

Code D3633

	Group Size (in.)	Vertical Spread	Horizontal Spread
1	1.1	.9	, 9
2	1.2	.9	1.1
3	2.2	1.1	1.1
4			
5			

.96 Avg. 1.5

K. Williams Tester 7-8-83 Date - 10-shd High (in

Report No.	831791
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RESEARCH TEST & MEASUREMENT LAB WORK REQUEST

	ARI	EA OF TESTING
Developmental	Safety Related	Litigation
Design Acceptance		uationWarehouse Audit
Pre-Pilot	✓ New Design	Cost: Reduction
Plat	Design Change	Stake-
Production Acceptance:	Plant Assistance	Other
FIREARM STAT'S. MODEL:M	FORMAL TEST RESULTS	DATE REQUESTED: 6-28-83 DATE NEEDED BY: 6-36-83 REQUESTED BY: V. W. Brooks
PROOFED: YES VNO	ONLY	WORK ORDER NO: (1861-000)
	TEST TYPE	
Strength Test Ammuniti		Test Photo/Video
Function Test Sovironme	ental Test: Measuremen	Other
Accuracy Test Customer	Complaint Endurance	Test
Magazine spring UNS REQUIRED: 7600152 7600 158	9 rifle from the she Il jumps majayie 7600150 from gun 76001 rounds per gum.	oulder. Fast, midum 4 stews. Fast, midum 50 in all atherizans in flower + cover et assure.
OTE: NO firearms or parts will be tested	in the Labs unless they are	DATE COMPLETED:
accompanied by a Work Request, a	1	TEST COMPLETED BY:
the Labs by the designer or enginee		REPORT DATE:
to be filled out in detail. No Except	į	

REMINGTON ARMS COMPANY, INC.	I	Distribution: < Bworkman Turbrowky (Exatible
Reminston. PETERS		Clode
"CONFINE YOUR LETTER TO ONE SUBJECT ONL	Y"	
Test la	sults Only"	
RESEARCH TEST and MEASUREMENT REPOR	Lower (Current Va	modern Transfer of the
Model Seven = . 223 al - De	sign No.7 Maga	give Follower Exclustion
-	Prepared by:	itephens
	Date Prepared:	
,		
•		
Proofread and Cleared By:		
J.H. Hennings , R.E. Nightingale, Foreman-Test Lab Foreman-Measurement Lab		
•	Signature	Date
C.E. Ritchie,	9	•
Sr. Supervisor - Testing, Meas. & Mech. Analysis Lab	Signature	Date

TEST & MEASUREMENT LAB REPORT

•
REPORT NUMBER: 831291
REPORT TITLE: Some is and
MODEL(S): 7
GAUGE OR CALIBER: . 223 cal
DATE:
WORK ORDER NO.: C-1861-000
PARTNAME: Magazine Follower
DESIGNER/ENGINEER: D. Bullis
TEST TYPE:
1. PHOTO LAB
2. STRENGTH TEST - NO. OF GUNS TESTED
3. Function test - no. of guns tested O
4. ACCURACY TEST - NO. OF GUNS TESTED
5. MEASUREMENTS - TYPE:
6. ENVIRONMENTAL TEST
7. AMMUNITION TESTING & EVALUATION - TYPE:
8. VISUAL EVALUATIONOUT OFGUN SAMPLE
9. ENDURANCE - NO. OF GUNS TESTED:
NO. OF ROUNDS PER GUN: 126
total rounds fired in test: 1260
AMMO TYPE: MAGS. : TARGET:

RIM FIRE CENTER FIRE χ

Remington arms Co. Inc.	Report # 831291
army Research Devision	1
1 June 1983	
To: D. Bullis	
From: C Steplens	-
To: D. Bullis From: C. Steplens (Test Results Only)	
Text Title:	1910-1-1
1 9 1 : 0 75 1 : engagarate O 8 Crasse Consider	COEMOCO
Rear For First.	
To bunting test new m/7 moon	in bollower convertly
Reason Fortest: To function test new m/7 magas being vendor produced	
ð , , , , , , , , , , , , , , , , , , ,	
Test Procedure.	
The ten refles were live round feed	franction tested in
RYD laby in slow, mederum, and fort	-
available types of amminition.	
all ten rubles were also field brin	ction tested at the
Sleon Fish & Dame Club rising the	seven available types
of ommunition.	
Test Perults:	
The results from the live field and	
indicate that the molfunction rate is	· · · · · · · · · · · · · · · · · · ·
limits. Most malfunctions occured on	
of the magazine and was a stem or she	ll Jumps magazine.

	831291
Test Results: (Con't)	
The percentage on the live feed text of on the first round out of the magazine was for the field function text 55.2	molfunctions 77.5 and
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FIELD	CYCLE	TEST	 CENTERFIRE

REPROT NO.1 831291

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SUMMARY SHE			OF ACTIONS FIRED		SEET	ETECH	HIOW BACK	OCX OPER	FR	ed om	STEMS MAG.	OVERRIDE	tock up		CIN	em Mder	l	JUNES MAG.	POLLOWER BINDS		OVERRIDE	aue de	TEACT	2	ì	Since	ject	IONS PER	PRESALE R 012910555
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FIELD	CYCLE	TEST	- CENTERFIRE

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											11	WIT	unci	'IONE	j **								TTL. Malf	mal Unct	FUNC ION	tate Tate	H	67 3.3	- - -
Summary She	ET		acting rited		Seeder	RIBOR	OF BACK	THE OLD YOU	FE FN	OM	STEMS MAG.	VERRIDE	8		CIN	'EM Mbei	1	JUMPS MAG.	BINIDS		KRIDE		EACT		· A	N.T.S.	a ect	ONS PER	PRES/
ву Аммо Тур	ē.	SHOOLES	NO. OF 1	PIRING	TOTAL CENT NEW	DOM'T E	POTE T'NOT	DON'T LOCK OPEN	Ist	end End		POWER OVERRIDE	DON'T LOCK UP		TON	PIESE	1221	SHELL J	POLLOWER BINDS	LOADING	BOLT OVERRIDE	ACTION BANG UP	DOR'T STITEACT	BREA FACES	ADJUSTMENTS	replacement	Doewlt Egect	MALFUNCTIONS PER AMMO Type	A PARTY
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Ren 55 HI			/80											ľ	##			11					11					11	6.1
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WIN SS MC	· 		180													11/1-		HI										9	5
WIN 55 PS	ρ		180			_	_						<u>. </u>					些										11	6.1
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FIELD	CYCLE	TEST .	- CENTERFIRE
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REPROT	NO.	83	129	
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MODEL: 7 LWT	1 MA	DATE REQUESTED: 5-9-83
CAL or GAGE: 223	FORMAL	DATE NEEDED BY: ASATO
BARREL TYPE:	TEST RESULTS	REQUESTED BY: BULLIS
PROOFED: YES VNO	ONLY	WORK ORDER NO: (-1861-000
	TEST TYPE	
Strength Test Ammuniti		Test Photo/Video
Function Test Environme		
	Complaint Endurance	Test
EXPLAIN IN DETAIL THE REASON FOR T	HIS I EST:	
FUNCTION TEST NO	EW # 7 MAGAZIN	E FOLLOWER.
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CURRENT VENDOR F	PODUCES.) & LATE.	ST SPRING.
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- GUNS REQUIRED: 7600149	7600154	1
150	155 156	
/5/ /52	157	* * * * * * * * * * * * * * * * * * * *
153	158	
NOTE: NO firearms or parts will be tested in	n the Labs unless they are	DATÉ COMPLETED: 5-24-53
accompanied by a Work Request, a	•	TEST COMPLETED BY: O. Triple
the Labs by the designer or engineer		REPORT DATE: 6/1/22 The
to be filled out in detail. No Except	•	/
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DEPENDANTE	it & measurement lab work	Report No. 830632
RESEARCH	I & MEASUREMENT CAS WORK	neduesi
	<u> </u>	AREA OF TESTING
Developmental	Safety Related	Litigation
Design Acceptance	Competitive E	valuation Warehouse Audit
Pre-Pilot	New Design	Cost Reduction
Pilot	Design Change	Stake
Production Acceptance	Plant Assistant	ce Other
FIREARM STAT'S.	REPORT REQ'D.	
MODEL: 76W7		DATE REQUESTED: 3-4-83
CAL or GAGE: 223	FORMAL	DATE NEEDED BY: A.S. A. P. (3-14-13)
BARREL TYPE: Curb	TEST RESULTS 6	REQUESTED BY: D. BUCCES
PROOFED: YES VNO	ONLY	WORK ORDER NO: 1.1856-000
	TEST TYPE	
Strength Test Ammuniti	on Test Dry Cyc	de Test Photo/Video
Function Test Environme	ental Test Measure	ments Other
Accuracy Test Customer	Complaint Enduran	ce Test
EXPLAIN IN DETAIL THE REASON FOR T	HISTEST: NEW PRODUC	1 ACCEPTANCE
LEN CALIBER INTRODO	CTION TO M/TLW	T LING.
TEST FOR FUNCTION	É ACCURACY.	
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-GUNS REQUIRED: 7600 149	7600156	
150	157 154	
153	155	
154	158	
NOTE: NO firearms or parts will be tested	n the Labs unless they are	DATE COMPLETED:
accompanied by a Work Request, a	nd both are delivered to	TEST COMPLETED BY:
the Labs by the designer or engineer	r. All Work Requests are	REPORT DATE:
to be filled out in detail. No Except		
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FIELD CYCLE TEST - CENTERFIRE

REPROT NO.1_	810632
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**KINZER V. REMINGTON** 

PD-49-8

REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE

Remington.

PETERS

cc: W.H. Coleman, II

J.R. Snedeker

J.P. Linde

J.W. Bower

R.S. Murphy

D.J. Anderson

L.B. Bosquet Z.J. Kowalski

"CONFINE YOUR LETTER TO ONE SUBJECT ONLY"

REPORT# 841021 WORK ORDER# 81343-929

TO: R.E. NIGHTINGALE

FROM: F.L. SUPRY

TITLE: T

TRIAL AND PILOT EVALUATION; MODEL 7 LWT. 308 CALIBER

WITH ALUMINUM TRIGGER GUARD ASSEMBLY.

#### ABSTRACT:

On April 10, 1984 a request was received to conduct a Trial and Pilot Evaluation on the Model 7 Lwt. 308 caliber rifle, assembled with the new design aluminum trigger guard assembly. The Trial and Pilot Evaluation consists of Visual Inspection, Accuracy, Field Function, and Endurance. All 35 rifles, from a sample lot of 35 rifles, will be utilized within the spectrum of the evaluation.

## SCOPE OF TEST:

To determine if the production run samples meet the Remington Specifications set by the Research Design Section.

# TEST RESULTS:

The 35 rifle Trial and Pilot Evaluation was found to be unacceptable, due to the following:

- A. During the Preliminary Measurements, a burr was found on the tip of the firing pin on two of the rifles, serial# 7603193 and serial# 7604383.
- B. During the Field Function Test of the first ten rifles, one rifle, serial# 7603423 was leaving deep rings on the throat area of the fired brass.

### COMMENTS:

The rifle, serial# 7603423 was returned to P.E. & C. The two firing pins were replaced with firing pins from from two of the rifles used in the visual inspection.

To obtain a good data base on the aluminum trigger guard, the testing that was scheduled on the remaining rifles will continue. A formal report, will be issued at the completion of the testing.

# BARBER - PRESALE R 0129153

Report No. 841021

# RESEARCH TEST & MEASUREMENT LAB WORK REQUEST

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	<del></del>	A OF TESTING
Developmental	Safety Related	Litigation
Design Acceptance		ation Warehouse Audit
Pre-Pilot	New Design	Cost Reduction
Pilot	Design Change	Stake
Production Acceptance	Plant Assistance	Other
FIREARM STAT'S.	REPORT REQ'D.	
MODEL: 74WT.		DATE REQUESTED: 4-10-87
CAL or GAGE: 3 08	FORMAL	DATE NEEDED BY: 4-17-84
BARREL TYPE:	TEST RESULTS	REQUESTED BY: JWB POOKS
PROOFED: YES V NO	ONLY	WORK ORDER NO: 81343 - 926
	TEST TYPE	
Strength Test Ammuniti	on Test Dry Cycle T	est Photo/Video
Function Test Environme	ental Test Measuremen	ts Other
Accuracy Test Customer	·	
EXPLAIN IN DETAIL THE REASON FOR T	HIS TEST: /	t 308 calibis with as assembly.
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Trial + Mot	Woder 1 Jun	
(2)	· Trigorer quo	as assembly,
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-GUNS REQUIRED:		
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NOTE: NO firearms or parts will be tested in	n the Labs unless they are	DATE COMPLETED:
accompanied by a Work Request, an	nd both are delivered to	TEST COMPLETED BY:
the Labs by the designer or engineer	. All Work Requests are	REPORT DATE:
to be filled out in detail. No Except	ions.	

# **BARBER - PRESALE R 0129154**

8-08-CF

# REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE

Remington.

PETERS

"CONFINE YOUR LETTER TO ONE SUBJECT ONLY"_____

RESEARCH TEST AND MEASUREMENT REPORT REPORT# 841401

MODEL SEVEN LWT. .308 CALIBER TRIAL AND PILOT EVALUATION

-2-

## MODEL SEVEN LWT. .308 CALIBER TRIAL AND PILOT EVALUATION

#### ABSTRACT:

Research and Developement finds the Trial and Pilot Evaluation of the Model Seven Lwt. .308 caliber, assembled with the aluminum floor plate assembly, to be acceptable. However, eventhough there were no malfunctions related to the new design floor plate assembly, the following should be investigated:

- 1. During a Field Function Test on thirty (30) of the first Trial and Pilot rifles, ninety-nine (99) malfunctions occurred, for an overall malfunction rate of 2.4%. Seventy-two (72) malfunctions or 72.2% of the malfunctions, were "Don't Eject" malfunctions.
- 2. During a Field Function Test conducted on eight (8) of the second Trial and Pilot rifles, thirty-five (35) "Don't Eject" malfunctions occurred, for an overall malfunction rate of 3.2%. The "Don't Eject" malfunction accounted for 100% of the malfunctions occurring in the Field Test. Two (2) of the rifles, serial# 7603137 and serial# 7604294, had fifteen (15) and thirteen (13) malfunctions respectively. These two (2) rifles were turned over to PE & C. A note of explaination from PE & C is included in the appendix of this report.

Since the "Don't Eject" malfunction was so predominate during the evaluation, either greater care must be taken in production, to follow the established procedures or a change in the current procedures may be needed.

Dropored by FI SUDDV

Date Prepared:	
proofread and cleared by:	
R.E. NIGHTINGALE, Foreman Test, Measurement & Mech. Analysis Lab	
J.R. SNEDEKER, Research Supervisor	
Test, Measurement & Mech. Analysis Lab	
W.H. COLEMAN, II New Products Research Lab Director	

-3-

REP.#841401

W.O.#81343-926

MODEL SEVEN LWT 308 CALIBER TRIAL AND PILOT EVALUATION

TO: R.E. NIGHTINGALE FROM: F.L. SUPRY

## INTRODUCTION:

On May 16, 1984 a request to conduct a Trial and Pilot evaluation on the Model 7 Lwt. 308 caliber rifle, assembled with the new design aluminum trigger guard assembly, was recieved by the Research Test Lab. A forty (40) rifle, production run sample will be used.

Due to the favorable results of an extensive endurance, accuracy, preliminary measurements, and visual inspection completed on the last production run samples of the rifle this Trial and Pilot will be limited to Jack Function and Field Function.

The results of the testing done on Previous sample will be included in this report.

## SCOPE OF TEST:

To determine if the production run samples meet Remington Specifications set by the Research Design Section.

# TEST RESULTS: (Previous sample)

Thirty (30) rifles were subjected to a 135 round Field Function Test. Ninty-nine (99) malfunctions occurred, for an overall malfunction rate of 2.4%.

Fifteen (15) rifles were fired to 335 rounds, seven (7) rifles were fired to 1005 rounds, and three (3) rifles were fired to 2035 rounds. No breakages occurred. No floor plate openings occurred.

# TEST RESULTS: (New sample)

The forty (40) rifle sample was found to meet the Remington Specifications set by the Research Design Section.

All forty (40) rifles were subjected to twenty (20) rounds of Remington ammunition, in a Jack Function test. No malfunctions occurred.

Eight of the rifles were subjected to a 135 round Field Function test. Thirty-five (35) "don't eject malfunctions" occurred, for an overall malfunction rate of 3.2%.

-4-

## REPORT TEXT:

- 1. VISUAL INSPECTION: (5 rifles) (Previous sample)
  - A. The visual inspection committee found no major deterrent in the appearance of the rifles inspected.
  - B. The following general comments were made in overall reference to the rifles:
    - a. Several of the rifles had a dent on the top, rear of the stock, where the stock hit against the stop board of the gun truck.
    - b. The checkering over-runs were primarily located at the rear of the fore end pattern.
    - c. The rifles used in the visual inspection were as follows:

7603926 7603156 7603161 7603441 7603126

- d. Comments recorded for each individual rifle are located in the appendix of this report.
- 2. PRELIMINARY MEASUREMENTS: (30 rifles)(Previous sample)
  - A. During the Preliminary Measurements, a burr was found on the tip of the firing pin of two of the rifles. The firing pins were replaced with firing pins from two of the rifles used in the visual inspection.
  - B. The following averages were established for the 30 rifles:

a. Floor Plate opening force:
b. Trigger Pull:
c. Firing Pin Indent:
d. Headspace:
3.0 pounds
3.75 pounds
.024 inches
d. Headspace:
.003 inches

C. Preliminary Measurement results per individual rifle are located in the appendix of this report.

-5-

REPORT TEXT: (continued)

- 3. ACCURACY: (Previous sample)
  - A. Nineteen (19) rifles were tested for 100 yard accuracy and the following averages were established:

a. Group Size:
b. Horizontal Spread:
c. Vertical Spread:
1.69 inches

- B. Accuracy results per individual rifle are located in the appendix of this report.
- 4. FIELD FUNCTION: (Previous sample)
  - A. Thirty (30) rifles were subjected to a 135 round per rifle, Field Function Test and the following results were obtained:
    - a. Twenty (20) rifles experienced no malfunctions.
    - b. Ninety-nine malfunctions occurred, for an overall malfunction rate was 2.4%.
    - c. Seventy-two (72) of the malfunctions were "Don't Eject" malfunctions.
    - d. One rifle had a rough chamber. (Refer to report# 841021)
- 5. FIELD FUNCTION: (New sample)
  - A. All forty (40) rifles were subjected to the loading and firing of twenty (20) rounds of Remington, 180 grain soft point, ammunition, prior to the Field Function Test. There were no malfunctions on any of the rifles.
  - B. Eight of the 40 rifles were subjected to a 135 round per rifle, Field Function Test, and the following results were obtained:
    - a. Two (2) of the rifles had no malfunctions.
    - b. The overall malfunction rate was 3.2%.
    - c. The malfunctions were all "don't eject" malfunctions. At each occurance the plunger was found to be stuck down.
    - d. Two (2) rifles, serial# 7603137 and serial# 7604294, accounted for twenty-eight (28) of the malfunctions. These two (2) rifles were turned over to J.B. Willoughby for examination. A note of explaination is included in the appendix of this report.

-6-

REPORT TEXT: (continued)

- 6. ENDURANCE: (Previous sample)
  - A. Fifteen (15) rifles were subjected to an additional 200 round endurance test, and the following results were obtained:
    - a. There were no floor plate openings.
    - b. The overall malfunction rate for this portion of the endurance test was 0.76%.
    - c. Twelve (12) of the rifles experienced no malfunctions.
    - d. The three rifles that experienced malfunctions, experienced them as follows:
      - i. 7604807 5 stem low (2.5% malfunction rate)
      - ii. 7603207 12 don't eject (6.0% malfunction rate) At each occurence, the ejector was stuck down due to shaved brass.
      - iii. 7603389 2 stem high 4 follower tip down (3.0% malfunction rate)
  - B. Seven (7) of the fifteen (15) rifles were subjected to an additional 700 round endurance test, and the following results were obtained:
    - a. There were no floor plate openings.
    - b. The overall malfunction rate for this portion of the endurance test was 0.8%.
    - c. Five (5) of the rifles had no malfunctions.
    - d. The two (2) rifles that experienced the malfunctions, experienced them as follows:
      - i. 7604098 4 stem high
        2 stem right
        1 bolt override (1.0% malfunction rate)

-7-

# TEST RESULTS: (continued)

- C. Three (3) of the seven (7) rifles were subjected to an additional 1000 round endurance test, and the following results were obtained:
  - a. There were no floor plate openings.
  - b. The overall malfunction rate for this portion of the endurance test was 0.2%.
  - c. Two (2) of the rifles had no malfunctions.
  - d. The rifle that experienced the malfunctions, experieced them as follows:
    - i. 7603153 2 stem high
      2 stem right
      1 follower tip down
      1 bolt override (0.6% malfunction rate)

# 7. JACK FUNCTION: (New sample)

- A. Each of the forty rifles were subjected to twenty rounds of Remington ammunition, and no malfunctions occurred.
- B. There were no rough chambers in any of the sample rifles.

## TEST PROCEDURE:

- 1. VISUAL INSPECTION: (Previous sample)
  - A. The Visual Inspection Committee consisted of Z. Kowalski, B. Bosquet, (P.E. & C.); J. Snedeker, F. Supry, (Research); and J. Brooks, (consultant).
  - B. Five (5) rifles were selected for the visual inspection, using random number tables, from a sample lot of 35 rifles.
  - C. Each rifle was wiped down with a clean white Coyne towel, and examined by each member of the Visual Inspection Committee. All comments were recorded.
- 2. PRELIMINARY MEASUREMENTS: (Previous sample)
  - A. Each rifle was checked for magnaflux and proof stamps.
  - B. The headspace was checked on each rifle, using graduated headspace gauges.

-8-

TEST PROCEDURE: (continued)

# 2. PRELIMINARY MEASUREMENTS: (continued)

- C. The floor plate opening force was checked, using a ten (10) pound push pull gauge. Three readings were taken on each rifle and an average calculated.
- D. Trigger pull force measurements were taken, using a ten (10) pound spring scale. Three readings were taken on each rifle and an average calculated.
- E. Firing Pin Indent measurements were taken, using annealed copper crushers and a calibrated dial indicator. Three measurements were taken on each rifle and an average calculated.

# 3. ACCURACY: (Previous sample)

A. The following nineteen (19) rifles were used in the 100 yard accuracy test:

7602999	7603374	7603110	7604374	7604807
7603362	7603323	7603340	7603609	7603482
7603389	7603003	7603153	7604098	7603155
7603357	7603342	7603326	7603430	

- B. The accuracy was shot by R. Williams, Research Test Lab, at the R & D 100 yard range.
- C. Weaver mounts and rings were used in conjunction with a Lyman All American 20X 1/8 inch dot scope.
- D. Remington ammunition, index R308W2; code W09F D4501, 180 grain soft point, was used for the 100 yard accuracy test.
- E. Before shooting the 100 yard accuracy test, the bores on each rifle were brushed with Hoppe's No. 9 solvent and patched dry.
- F. A total of two (2), five (5) shot groups were shot with each rifle. The rifles were cooled between each group, and one (1) "warmer" shot was fired before the next group was shot.
- G. The patterns were analyzed for group size, horizontal spread, and vertical spread. The averages were calculated for each rifle.

-9-

# 4. FIELD FUNCTION: (Previous sample)

A. Thirty (30) of the rifles were subjected to the loading and firing of 135 rounds of Remington and competitive ammunition. The round robin method of firing the rifles was used. Fifteen (15) rounds were fired; five (5) at a slow feeding cycle speed, five (5) at a medium feeding cycle speed, and five (5) at a fast feeding cycle speed. The rifles were then cooled before the firing of the next ammunition type.

B. The following ammunition was used in the field test:

a. Remington: R308W1 150-psp code# S22K D7069 R308W3 180-psp code# W17F D7743

b. Winchester: X3081 110-psp code# 79SE12 5Q X3085 150-sp code# 24UE81

c. Federal: 308A 150-psp code# 5A 1245

308B 180-psp code# 5B 1104 P308C 165-bt code# 32A 3118

C. All malfunctions were recorded; per rifle, per ammunition type, per feeding cycle speed, and per shooter. Individual and overall malfunction rates were calculated.

# 5. FIELD FUNCTION: (New sample)

A. The same procedure, that was used on the Previous sample, was followed to conduct a field function test on eight (8) rifles from the New sample.

# 6. APPENDIX:

## A. Contents:

- a. Visual Inspection comments per individual rifle.
- b. Preliminary Measurement results per individual rifle.
- c. Accuracy results per individual rifle.
- d. A copy of the Lab Work Request.
- e. A copy of the note explaining the findings of the examination of the two rifles, serial# 7603137 and serial# 7604294.
- f. A copy of Report# 841021

-10-

APPENDIX
MODEL 7 LWT. 308 CALIBER WITH ALUMINUM TRIGGER GUARD ASSEMBLY

-11-

VISUAL INSPECTION:

## GENERAL:

- 1. A slight mar was noticed on the top rear of the stocks, on each of the rifles, from the rifles hitting on the stop board of the gun truck.
- 2. The checkering over runs were primarily located at the rear of the patterns.

# COMMENTS PER INDIVIDUAL RIFLE:

- 1. 7603926 Some checkering over runs on all four points, at the rear of the fore end pattern.
- 2. 7603441 Dent in the stock, about an inch in front of the rear swivel screw.

The checkering in the grip area has slight over and under runs.

Bright spot on the rear of the trigger guard, from the head of the screw hitting the trigger guard.

The repaired crown appears rough.

- 3. 7603156 Polish scratches on the floor plate cover.
- 4. 7603161 White marks on the inside of the floor plate, on the side of the trigger bow.

Two dents on the left side of the stock, below the rear sight.

The repaired crown appears rough.

5. 7603126 - Dust in the finish.

Dent in the right side of the floor plate.

-12-

PRELIMINARY MEASUREMENTS:

SERIAL#	HD SPACE (in)	FP INDENT (in)	TRIGGER PULL (1bs)	F PLATE OPENING (1bs)
7(021(0	000	000		0.00
7603160	.002	.023	4.00	3.00
7603374	.005	.0235	3.00	3.00
7603423	.005	.0235	3.50	3.00
7603323	.004	.0215	4.00	3.00
7603340	.001	.0235	4.00	3.00
7603207	.005	.024	3.25	3.25
7603110	.004	.024	3.50	3.00
7603616	.002	.0245	3.25	3.00
7603153	.001	.025	4.50	3.00
7603389	.004	.023	3.00	3.25
7604264	.006	.0225	3.25	2.75
7603882	.005	.021	3.75	3.00
7603326	.003	.0245	3.75	2.75
7603774	.003	.0225	3.25	2.75
7603342	.004	.024	4.00	3.00
7603003	.003	.023	3.25	3.00
7603357	.002	.025	3.50	3.00
7603155	.004	.023	3.75	3.25
7603453	.002	.023	3.75	3.25
7604374	.005	.024	4.25	3.00
7604098	.005	.0245	4.00	3.00
7604807	.001	.024	3.50	2.75
7603482	.004	.023	3.75	3.00
7603430	.005	.0255	4.25	3.00
7603609	.002	.024	4.50	3.00
7603362	.004	.025	4.75	2.75
7603262	.002	.023	3.00	3.00
7602999	.002	.0255	4.50	4.00
7604283	.005	.024	3.75	3.00
7603193	.002	.024	4.00	3.00
AVERAGE	= .003	.024	3.75	3.00

-13-

# ACCURACY PER INDIVIDUAL RIFLE:

SERIAL#		GROUP SIZE (in.)	HORIZONTAL	VERTICAL (in.)
7603155		1.2 1.5	1.1 1.2	0.5 1.3
average	=	1.35	1.15	0.9
7604098		1.3 2.5	1.0 1.9	1.0 2.4
average	=	1.9	1.45	1.7
7603357		1.9 2.5	1.7	0.8
average	=	2.2	2.4 2.05	1.6 1.2
7603326		2.1 3.1	1.0 2.8	1.9 2.1
average	=	2.6	1.9	2.0
7603430		2.8 2.3	1.9 2.0	2.0 2.3
average	=	2.55	1.95	2.25
7603342		2.6	2.1 1.6	1.9 2.2
average	=	2.6	1.85	2.05
7603482		2.3	1.8 3.1	1.7 1.5
average	=	2.8	2.45	1.6
7603482		1.7	1.4	1.1
average	=	1.85	1.4 1.4	1.9 1.5
7603389		2.0	1.1	1.7
average	=	3.2 2.6	3.2 2.15	2.3 2.0

-14-

ACCURACY PER INDIVIDUAL RIFLE: (continued)

SERIAL#		GROUP SIZE	HORIZONTAL	VERTICAL
7603003		2.1 3.2	2.0 3.1	1.2 1.5
average	=	2.65	2.55	1.35
7603153		2.3 3.0	2.1 3.0	1.1 1.3
average	=	2.65	2.55	1.2
7903323		2.2 2.0	1.9 1.1	1.9 1.9
average	=	2.1	2.0	1.9
7603362		2.9 2.5	2.8 1.8	1.4 1.9
average	-	2.7	2.3	1.65
7603340		2.8 2.2	2.6 1.0	1.1 2.0
average	=	2.5	1.8	1.55
7603110		2.3 2.9	2.3 1.4	1.1 2.6
average	=	2.6	1.85	1.85
7604374		1.6 2.7	1.4 0.6	1.3 2.6
average	=	2.15	1.0	1.95
7603374		2.3 2.3	1.6 2.3	2.1 1.3
average	=	2.3	1.95	1.7
7604807		1.9	1.7 2.5	1.0 1.8
average	=	2.4	2.1	1.4
7602999		2.8 2.3	1.9 0.9	2.4 2.3
average	=	2.55	1.4	2.35

G-88

# DON'T SAY IT-WRITE IT

TO L.B. BOSSIET

Date 5-3/-99

From J. B. MILLOUGHEY

RE: M/T E. S.B.

BOTH BOLTS HAVE A NOTICEABLE BURE AROUND THE EJECTRE
HOLE THAT SHAVES BEASS FROM THE SHELL HEAD & DEPOSITS IT
IN THE HOLE BINDING THE EJECTOR. ALSO SER. # 3137 HAS THE
WIDNE EJECTOR SPRING IN 17, MID CALLS FOR A MIN. PROELENGTH
OF 1.100 IN. THIS SPRING IS PD. 920. THE SPRING HAD BEEN CUT
OFF. I HAD IT BE ASSEMBLED WITH A FULL LANGEN SPRING & IT WHERE
FINE. TREHOLE FROM SER. # 3137 WAS NOT SCRIPPED AT THE
HEADING-YOR, # THE OTHER ONE WAS DONE IN PROPERCY. BOTH HOLE
DIAMETERS WERE O.K.

"DON'T TAKE A CHANCE, THINK SAFETY IN ADVANCE"

# **BARBER - PRESALE R 0129169**

Report No. 841401

# RESEARCH TEST & MEASUREMENT LAB WORK REQUEST

Developmental	AR Safety Related	EA OF TESTING Litigation
Design Acceptance	Competitive Eval	<del></del>
Pre-Pilot	New Design  Heaving Change	Cost Reduction Stake
Production Acceptance	Plant Assistance	Other
FIREARM STAT'S.  MODEL: SPLEARM  CAL or GAGE: 308  BARREL TYPE:	REPORT REQ'D.  FORMAL  TEST RESULTS ONLY	DATE REQUESTED: 5-16-84  DATE NEEDED BY: AS AP  REQUESTED BY: £ S. MURPHY  WORK ORDER NO: C-1856-00 :
	TEST TYPE	
Strength Test Ammuniti		
Function Test Environme     Accuracy Test Customer	<del></del>	
Please perform on the sample of		rail and Pilot lest
on the sample of	guns supplied h	y Production
-GUNS REQUIRED: Synlice	<u>.</u>	·
NOTE: NO firearms or parts will be tested in	the Labs unless they are	DATE COMPLETED: 5/25/84
accompanied by a Work Request, an		TEST COMPLETED BY: RW, FS
the Labs by the designer or engineer.  to be filled out in detail. No Excepti	•	REPORT DATE:
to be inted out in detail. 140 EXCEPT	OHa.	

-15-

REPORT# 841021 WORK ORDER# 81343-929

TO: R.E. NIGHTINGALE

FROM: F.L. SUPRY

TITLE: TRIAL AND PILOT EVALUATION; MODEL 7 LWT. 308 CALIBER WITH ALUMINUM TRIGGER GUARD ASSEMBLY.

#### ABSTRACT:

On April 10, 1984 a request was received to conduct a Trial and Pilot Evaluation on the Model 7 Lwt. 308 caliber rifle, assembled with the new design aluminum trigger guard assembly. The Trial and Pilot Evaluation consists of Visual Inspection, Accuracy, Field Function, and Endurance. All 35 rifles, from a sample lot of 35 rifles, will be utilized within the spectrum of the evaluation.

# SCOPE OF TEST:

To determine if the production run samples meet the Remington Specifications set by the Research Design Section.

# TEST RESULTS:

The 35 rifle Trial and Pilot Evaluation was found to be unacceptable, due to the following:

- A. During the Preliminary Measurements, a burr was found on the tip of the firing pin on two of the rifles, serial# 7603193 and serial# 7604383.
- B. During the Field Function Test of the first ten rifles, one rifle, serial# 7603423, was leaving deep rings on the throat area of the fired brass.

# COMMENTS:

The rifle, serial # 7603423, was returned to P.E. & C. The two firing pins were replaced with firing pins from two of the rifles used in the visual inspection.

To obtain a good data base on the aluminum trigger guard, the testing that was scheduled on the remaining rifles will continue. A formal report, will be issued at the completion of the testing.

# TEST & MEASUREMENT LAB REPORT

REPORT NUMBER: 841401 REPORT TITLE: MODEL SEVEN LWT. .308 CALIBER TRIAL & PILOT

MODEL(S): SEVEN LWT.

GAUGE OR CALIBER: .308

DATE: 5/30/84

WORK ORDER NO.: 81343-926

PART NAME: RIFLE

DESIGNER/ENGINEER: Requested by R.S. MURPHY

# TEST TYPE:

⊥.	PHOTO LAB				
2.	STRENGTH TEST-NO. OF GUNS TESTED				
3.	FUNCTION TEST-NO. OF GUNS TESTED 40				
4.	ACCURACY TEST-NO. OF GUNS TESTED 19				
5.	MEASUREMENTS - TYPE Preliminary				
6.	ENVIRONMENTAL TEST				
7.	AMMUNITION TESTING & EVALUATION-TYPE				
8.	VISUAL EVALUATION 5 OUT OF 40 GUN SAMPLE				
9.	ENDURANCE-NO. OF GUNS TESTED: 30,15,7,3				
NO. OF ROUNDS PER GUN 135,300,1000,2000					
TOTAL ROUNDS FIRED IN TEST 15,000					
	AMMO TYPE: MAGS. TARGET:				
	RIM FIRECENTERFIREX				

RD-69-B

# REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE

Remington QUPOND



cc: W.H. Coleman, II

K.W. Soucy D.J. Anderson

R.S. Murphy

J.W. Bower J.R. Snedeker

"CONFINE YOUR LETTER TO ONE SUBJECT ONLY"_

# RESEARCH TEST AND MEASUREMENT REPORT REPORT# 841401

MODEL SEVEN LWT. .308 CALIBER TRIAL AND PILOT EVALUATION

-2-

MODEL SEVEN LWT. .308 CALIBER TRIAL AND PILOT EVALUATION

## ABSTRACT:

Research and Developement finds the Trial and Pilot Evaluation of the Model Seven Lwt. .308 caliber, assembled with the aluminum floor plate assembly, to be acceptable. However, although there were no malfunctions related to the new design floor plate assembly, the following should be investigated, by production:

- 1. During a Field Function Test on thirty (30) of the first Trial and Pilot rifles, ninety-nine (99) malfunctions occurred, for an overall malfunction rate of 2.4%. Seventy-two (72) malfunctions or 72.2% of the malfunctions, were "Don't Eject" malfunctions.
- 2. During a Field Function Test conducted on eight (8) of the second Trial and Pilot rifles, thirty-five (35) "Don't Eject" malfunctions occurred, for an overall malfunction rate of 3.2%. The "Don't Eject" malfunction accounted for 100% of the malfunctions occurring in the Field Test. Two (2) of the rifles, serial# 7603137 and serial# 7604294, had fifteen (15) and thirteen (13) malfunctions respectively. These two (2) rifles were turned over to PE & C. A note of explaination from PE & C is included in the appendix of this report.

Since the "Don't Eject" malfunction was so predominate during the evaluation, either greater care must be taken in production, to follow the established procedures or a change in the current procedures may be needed.

Prepared by: F.L. SUPRY Date Prepared: 5/30/84

proofread and cleared by:

R.E. NIGHTINGALE, Foreman

Test, Measurement & Mech. Analysis Lab

J.R. SNEDEKER, Research Supervisor

Test, Measurement & Mech. Analysis Lat

W.H. COLEMAN, II

New Products Research Lab Director

-3-

REP.#841401

W.O.#81343-926

MODEL SEVEN LWT 308 CALIBER TRIAL AND PILOT EVALUATION

TO: R.E. NIGHTINGALE FROM: F.L. SUPRY

# INTRODUCTION:

On May 16, 1984 a request to conduct a Trial and Pilot evaluation on the Model 7 Lwt. 308 caliber rifle, assembled with the new design aluminum trigger guard assembly, was recieved by the Research Test Lab. A forty (40) rifle, production run sample was used.

Due to the favorable results of an extensive endurance, accuracy, preliminary measurements, and visual inspection completed on the last production run samples of the rifle this Trial and Pilot will be limited to Jack Function and Field Function.

The results of the testing done on Previous sample will be included in this report.

# SCOPE OF TEST:

To determine if the production run samples meet Remington Specfications set by the Research Design Section.

TEST RESULTS: (Previous sample)

Thirty (30) rifles were subjected to a 135 round Field Function Test. Ninty-nine (99) malfunctions occurred, for an overall malfunction rate of 2.4%.

Fifteen (15) rifles were fired to 335 rounds, seven (7) rifles were fired to 1005 rounds, and three (3) rifles were fired to 2035 rounds. No breakages occurred. No floor plate openings occurred.

TEST RESULTS: (New sample)

The forty (40) rifle sample was found to meet the Remington Specifications set by the Research Design Section.

All forty (40) rifles were subjected to twenty (20) rounds of Remington ammunition, in a Jack Function test. No malfunctions occurred.

Eight of the rifles were subjected to a 135 round Field Function test. Thirty-five (35) "don't eject" malfunctions occurred, for an overall malfunction rate of 3.2%.

-4-

#### REPORT TEXT:

- 1. VISUAL INSPECTION: (5 rifles) (Previous sample)
  - A. The visual inspection committee found no major items in the appearance of the rifles inspected.
  - B. The following general comments were made in overall reference to the rifles:
    - a. Several of the rifles had a dent on the top, rear of the stock, where the stock hit against the stop board of the gun truck.
    - b. The checkering over-runs were primarily located at the rear of the fore end pattern.
    - c. The rifles used in the visual inspection were:

7603926 7603156 7603161 7603441 7603126

- d. Comments recorded for each individual rifle are located in the appendix of this report.
- 2. PRELIMINARY MEASUREMENTS: (30 rifles)(Previous sample)
  - A. During the Preliminary Measurements, a burr was found on the tip of the firing pin of two of the rifles. The firing pins were replaced with firing pins from two of the rifles used in the visual inspection.
  - B. The following averages were established for the 30 rifles:

a. Floor Plate opening force:
b. Trigger Pull:
c. Firing Pin Indent:
d. Headspace:
3.0 pounds
3.75 pounds
.024 inches
d. Headspace:
.003 inches

C. Preliminary Measurement results per individual rifle are located in the appendix of this report.

-5-

REPORT TEXT: (continued)

- 3. ACCURACY: (Previous sample)
  - A. Nineteen (19) rifles were tested for 100 yard accuracy and the following averages were established:

a. Group Size:
b. Horizontal Spread:
c. Vertical Spread:
1.69 inches

- B. Accuracy results per individual rifle are located in the appendix of this report.
- 4. FIELD FUNCTION: (Previous sample)
  - A. Thirty (30) rifles were subjected to a 135 round per rifle, Field Function Test and the following results were obtained:
    - a. Twenty (20) rifles experienced no malfunctions.
    - b. Ninety-nine malfunctions occurred, for an overall malfunction rate of 2.4%.
    - c. Seventy-two (72) of the malfunctions were "Don't Eject" malfunctions.
    - d. One rifle had a rough chamber. (Refer to report# 841021)
- 5. FIELD FUNCTION: (New sample)
  - A. All forty (40) rifles were subjected to the loading and firing of twenty (20) rounds of Remington, 180 grain soft point, ammunition, prior to the Field Function Test. There were no malfunctions on any of the rifles.
  - B. Eight of the 40 rifles were subjected to a 135 round per rifle, Field Function Test, and the following results were obtained:
    - a. Two (2) of the rifles had no malfunctions.
    - b. The overall malfunction rate was 3.2%.
    - c. The malfunctions were all "don't eject" malfunctions. At each occurance the plunger was found to be stuck down.
    - d. Two (2) rifles, serial# 7603137 and serial# 7604294, accounted for twenty-eight (28) of the malfunctions. These two (2) rifles were turned over to J.B. Willoughby for examination. A note of explaination is included in the appendix of this report.

-6-

REPORT TEXT: (continued)

- 6. ENDURANCE: (Previous sample)
  - A. Fifteen (15) rifles were subjected to an additional 200 round endurance test, and the following results were obtained:
    - a. There were no floor plate openings.
    - b. The overall malfunction rate for this portion of the endurance test was 0.76%.
    - c. Twelve (12) of the rifles experienced no malfunctions.
    - d. The three rifles that experienced malfunctions, experienced them as follows:
      - i. 7604807 5 stem low (2.5% malfunction rate)
      - ii. 7603207 12 don't eject (6.0% malfunction rate) At each occurence, the ejector was stuck down due to shaved brass.
      - iii. 7603389 2 stem high - 4 follower tip down - (3.0% malfunction rate)
  - B. Seven (7) of the fifteen (15) rifles were subjected to an additional 700 round endurance test, and the following results were obtained:
    - a. There were no floor plate openings.
    - b. The overall malfunction rate for this portion of the endurance test was 0.8%.
    - c. Five (5) of the rifles had no malfunctions.
    - d. The two (2) rifles that experienced the malfunctions, experienced them as follows:
      - i. 7604098 4 stem high 2 stem right
        - 1 bolt override (1.0% malfunction rate)
      - ii. 7603389 8 don't eject 2 stem high 7 stem low

1 stem right

16 follower tip down - (4.8% malfunction rate)

-7-

# TEST RESULTS: (continued)

- C. Three (3) of the seven (7) rifles were subjected to an additional 1000 round endurance test, and the following results were obtained:
  - a. There were no floor plate openings.
  - b. The overall malfunction rate for this portion of the endurance test was 0.2%.
  - c. Two (2) of the rifles had no malfunctions.
  - d. The rifle that experienced the malfunctions, experieced them as follows:
    - i. 7603153 2 stem high
      2 stem right
      1 follower tip down
      1 bolt override (0.6% malfunction rate)
- 7. JACK FUNCTION: (New sample)
  - A. Each of the forty rifles were subjected to twenty rounds of Remington ammunition, and no malfunctions occurred.
  - B. There were no rough chambers in any of the sample rifles.

# TEST PROCEDURE:

- 1. VISUAL INSPECTION: (Previous sample)
  - A. The Visual Inspection Committee consisted of Z. Kowalski, B. Bosquet, (P.E. & C.); J. Snedeker, F. Supry, (Research); and J. Brooks, (consultant).
  - B. Five (5) rifles were selected for the visual inspection, using random number tables, from a sample lot of 35 rifles.
  - C. Each rifle was wiped down with a clean white Coyne towel, and examined by each member of the Visual Inspection Committee. All comments were recorded.
- 2. PRELIMINARY MEASUREMENTS: (Previous sample)
  - A. Each rifle was checked for magnaflux and proof stamps.
  - B. The headspace was checked on each rifle, using graduated headspace gauges.

-8-

TEST PROCEDURE: (continued)

# 2. PRELIMINARY MEASUREMENTS: (continued)

- C. The floor plate opening force was checked, using a ten (10) pound push pull gauge. Three readings were taken on each rifle and an average calculated.
- D. Trigger pull force measurements were taken, using a ten (10) pound spring scale. Three readings were taken on each rifle and an average calculated.
- E. Firing Pin Indent measurements were taken, using annealed copper crushers and a calibrated dial indicator. Three measurements were taken on each rifle and an average calculated.
- 3. ACCURACY: (Previous sample)
  - A. The following nineteen (19) rifles were used in the 100 yard accuracy test:

7602999	7603374	7603110	7604374	7604807
7603362	7603323	7603340	7603609	7603482
7603389	7603003	7603153	7604098	7603155
7603357	7603342	7603326	7603430	

- B. The accuracy was shot by R. Williams, Research Test Lab, at the R & D 100 yard range.
- C. Weaver mounts and rings were used in conjunction with a Lyman All American 20X 1/8 inch dot scope.
- D. Remington ammunition, index R308W2; code W09F D4501, 180 grain soft point, was used for the 100 yard accuracy test.
- E. Before shooting the 100 yard accuracy test, the bores on each rifle were brushed with Hoppe's No. 9 solvent and patched dry.
- F. A total of two (2), five (5) shot groups were shot with each rifle. The rifles were cooled between each group, and one (1) "warmer" shot was fired before the next group was shot.
- G. The patterns were analyzed for group size, horizontal spread, and vertical spread. The averages were calculated for each rifle.

-9-

# 4. FIELD FUNCTION: (Previous sample)

- A. Thirty (30) of the rifles were subjected to the loading and firing of 135 rounds of Remington and competitive ammunition. The round robin method of firing the rifles was used. Fifteen (15) rounds were fired; five (5) at a slow feeding cycle speed, five (5) at a medium feeding cycle speed, and five (5) at a fast feeding cycle speed. The rifles were then cooled before the firing of the next ammunition type.
- B. The following ammunition was used in the field test:

a. Remington: R308W1 150-psp code# S22K D7069 R308W3 180-psp code# W17F D7743

b. Winchester: X3081 110-psp code# 79SE12 5Q X3085 150-sp code# 24UE81 X3086 180-sp code# 68TC90 83 X3084 200-st code# 52TF80

c. Federal: 308A 150-psp code# 5A 1245 308B 180-psp code# 5B 1104 P308C 165-bt code# 32A 3118

- C. All malfunctions were recorded; per rifle, per ammunition type, per feeding cycle speed, and per shooter. Individual and overall malfunction rates were calculated.
- 5. FIELD FUNCTION: (New sample)
  - A. The same procedure, that was used on the Previous sample, was followed to conduct a field function test on eight (8) rifles from the New sample.

## 6. APPENDIX:

## A. Contents:

- a. Visual Inspection comments per individual rifle.
- b. Preliminary Measurement results per individual rifle.
- c. Accuracy results per individual rifle.
- d. A copy of the Lab Work Request.
- e. A copy of the note explaining the findings of the examination of the two rifles, serial# 7603137 and serial# 7604294.
- f. A copy of Report# 841021

-10-

APPENDIX
MODEL 7 LWT. 308 CALIBER WITH ALUMINUM TRIGGER GUARD ASSEMBLY

-11-

VISUAL INSPECTION:

## **GENERAL:**

- 1. A slight mar was noticed on the top rear of the stocks, on each of the rifles, from the rifles hitting on the stop board of the gun truck.
- 2. The checkering over runs were primarily located at the rear of the patterns.

## COMMENTS PER INDIVIDUAL RIFLE:

- 1. 7603926 Some checkering over runs on all four points, at the rear of the fore end pattern.
- 2. 7603441 Dent in the stock, about an inch in front of the rear swivel screw.

The checkering in the grip area has slight over and under runs.

Bright spot on the rear of the trigger guard, from the head of the screw hitting the trigger guard.

The repaired crown appears rough.

- 3. 7603156 Polish scratches on the floor plate cover.
- 4. 7603161 White marks on the inside of the floor plate, on the side of the trigger bow.

Two dents on the left side of the stock, below the rear sight.

The repaired crown appears rough.

5. 7603126 - Dust in the finish.

Dent in the right side of the floor plate.

TandP_841401

-12-

#### PRELIMINARY MEASUREMENTS:

SERIAL#	HD SPACE	FP INDENT	TRIGGER PULL	F PLATE OPENING (1bs)
	(111)	(111/	(IDS)	(IDS)
7603160	.002	.023	4.00	3.00
7603374	.005	.0235	3.00	3.00
7603423	.005	.0235	3.50	3.00
7603323	.004	.0215	4.00	3.00
7603340	.001	.0235	4.00	3.00
7603207	.005	.024	3.25	3.25
7603110	.004	.024	3.50	3.00
7603616	.002	.0245	3.25	3.00
7603153	.001	.025	4.50	3.00
7603389	.004	.023	3.00	3.25
7604264	.006	.0225	3.25	2.75
7603882	.005	.021	3.75	3.00
7603326	.003	.0245	3.75	2.75
7603774	.003	.0225	3.25	2.75
7603342	.004	.024	4.00	3.00
7603003	.003	.023	3.25	3.00
7603357	.002	.025	3.50	3.00
7603155	.004	.023	3.75	3.25
7603453	.002	.023	<b>3.7</b> 5	3.25
7604374	.005	.024	4.25	3.00
7604098	.005	.0245	4.00	3.00
7604807	.001	.024	3.50	2.75
7603482	. 004	.023	3.75	3.00
7603430	.005	.0255	4.25	3.00
7603609	.002	.024	4.50	3.00
7603362	.004	.025	4.75	2.75
7603262	.002	.023	3.00	3.00
7602999	.002	.0255	4.50	4.00
7604283	.005	.024	<b>3.7</b> 5	3.00
7603193	.002	.024	4.00	3.00
AVERAGE	<b>=</b> .003	.024	3.75	3.00

TandP_841401

-13-

#### ACCURACY PER INDIVIDUAL RIFLE:

SERIAL#	1	GROUP SIZE (in.)	HORIZONTAL (in.)	VERTICAL (in.)
7603155		1.2	1.1	0.5
		1.5	1.2	1.3
average	=	1.35	1.15	0.9
7604098		1.3	1.0	1.0
		2.5	1.9	2.4
average	=	1.9	1.45	1.7
7603357		1.9	1.7	0.8
		2.5	2.4	1.6
average	=	2.2	2.05	1.2
7603326		2.1	1.0	1.9
		3.1	2.8	2.1
average	=	2.6	1.9	2.0
7603430		2.8	1.9	2.0
		2.3	2.0	2.3
average	=	2.55	1.95	2.25
7603342		2.6	2.1	1.9
		2.6	1.6	2.2
average	=	2.6	1.85	2.05
7603482		2.3	1.8	1.7
		3.3	3.1	1.5
average	=	2.8	2.45	1.6
7603482		1.7	1.4	1.1
		2.0	1.4	1.9
average	=	1.85	1.4	1.5
7603389		2.0	1.1	1.7
-		3.2	3.2	2.3
average	=	2.6	2.15	2.0
•				

TandP_841401

-14-

ACCURACY	PER	INDIVIDUAL	RIFLE:	(continued)
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SERIAL#		GROUP SIZE	HORIZONTAL	VERTICAL
7603003		2.1	2.0	1.2
		3.2	3.1	1.5
average	=	2.65	2.55	1.35
7603153		2.3	2.1	1.1
		3.0	3.0	1.3
average	=	2.65	2.55	1.2
7903323		2.2	1.9	1.9
		2.0	1.1	1.9
average	=	2.1	2.0	1.9
7603362		2.9	2.8	1.4
		2.5	1.8	1.9
average	=	2.7	2.3	1.65
7603340		2.8	2.6	1.1
		2.2	1.0	2.0
average	**	2.5	1.8	1.55
-				
7603110		2.3	2.3	1.1
		2.9	1.4	2.6
average	=	2.6	1.85	1.85
7604374		1.6	1.4	1.3
		2.7	0.6	2.6
average	#	2.15	1.0	1.95
7603374		2.3	1.6	2.1
		2.3	2.3	1.3
average	=	2.3	1.95	1.7
7604807		1.9	1.7	1.0
		2.9	2.5	1.8
average	=	2.4	2.1	1.4
7602999		2.8	1.9	2.4
		2.3	0.9	2.3
average	E	2.55	1.4	2.35

TandP 841401

-15-

REPORT# 841021 WORK ORDER# 81343-929

TO: R.E. NIGHTINGALE

FROM: F.L. SUPRY

TITLE: TRIAL AND PILOT EVALUATION; MODEL 7 LWT. 308 CALIBER WITH ALUMINUM TRIGGER GUARD ASSEMBLY.

#### ABSTRACT:

On April 10, 1984 a request was received to conduct a Trial and Pilot Evaluation on the Model 7 Lwt. 308 caliber rifle, assembled with the new design aluminum trigger guard assembly. The Trial and Pilot Evaluation consists of Visual Inspection, Accuracy, Field Function, and Endurance. All 35 rifles, from a sample lot of 35 rifles, will be utilized within the spectrum of the evaluation.

#### SCOPE OF TEST:

To determine if the production run samples meet the Remington Specifications set by the Research Design Section.

#### TEST RESULTS:

The 35 rifle Trial and Pilot Evaluation was found to be unacceptable, due to the following:

- A. During the Preliminary Measurements, a burr was found on the tip of the firing pin on two of the rifles, serial# 7603193 and serial# 7604383.
- B. During the Field Function Test of the first ten rifles, one rifle, serial# 7603423, was leaving deep rings on the throat area of the fired brass.

#### COMMENTS:

The rifle, serial# 7603423, was returned to P.E. & C. The two firing pins were replaced with firing pins from two of the rifles used in the visual inspection.

To obtain a good data base on the aluminum trigger guard, the testing that was scheduled on the remaining rifles will continue. A formal report, will be issued at the completion of the testing.

G-88

#### DON'T SAY IT-WRITE IT

From L.B. BOSSIET

From L.B. MILLONGUSY

Date 5-3/-91

RE: M/7 E. S.B.

BOTH BOLTS HAVE A NOTICEABLE BURE AROUND THE EJECTOR HOLE THAT SHAVES BEASS FROM THE SHELL HEAD & DEPOSITS IT IN THE HOLE BINDING THE EJECTOR. ALSO SER. # 3137 HAS THE WADN'T EJECTOR SPRING IN 17, A/O CALLS FOR A MIN. FREE LEWERN OF 1, 100 IN. THIS SPRING IS AP. 920. THE SPRING HAD BEEN CUT IFF. I HAD IT BE ASSEMBLED WITH A FULL LEWERN SPRING # IT HOMBED FINE. THEHOLE FROM SEC. # 3137 WAS NOT SCAMED AT THE HEADING HOR, # THE OTHER ONE WAS DONE IN PROPERCY. BOTH HEED DIAMETERS WELL ON.

"DON'T TAKE A CHANCE, THINK SAFETY IN ADVANCE"

#### BARBER - PRESALE R 0129189

Report No. 37/72

#### RESEARCH TEST & MEASUREMENT LAB WORK REQUEST

	`		AREA	OF TESTING
	Developmental	Safety	Related	Litigation
	Design Acceptance	Compe	titive Evaluat	tion Warehouse Audit
F	<del>Pre-P</del> ilot	New De	sign	Cost Reduction
F	भावर	Design	Change-	Stake
<u>*</u>	Production Acceptance	Plant A	ssistance	Other
C	FIREARM STAT'S.  MODEL: Special Solution GAGE: 308  BARREL TYPE:	FORMAL TEST RESULTS	-	DATE REQUESTED: STATE AS A PORTION OF THE PROPERTY OF THE PROPERTY OF THE PROPERTY OF THE PROPERTY OF THE PROPERTY OF THE PROPERTY OF THE PROPERTY OF THE PROPERTY OF THE PROPERTY OF THE PROPERTY OF THE PROPERTY OF THE PROPERTY OF THE PROPERTY OF THE PROPERTY OF THE PROPERTY OF THE PROPERTY OF THE PROPERTY OF THE PROPERTY OF THE PROPERTY OF THE PROPERTY OF THE PROPERTY OF THE PROPERTY OF THE PROPERTY OF THE PROPERTY OF THE PROPERTY OF THE PROPERTY OF THE PROPERTY OF THE PROPERTY OF THE PROPERTY OF THE PROPERTY OF THE PROPERTY OF THE PROPERTY OF THE PROPERTY OF THE PROPERTY OF THE PROPERTY OF THE PROPERTY OF THE PROPERTY OF THE PROPERTY OF THE PROPERTY OF THE PROPERTY OF THE PROPERTY OF THE PROPERTY OF THE PROPERTY OF THE PROPERTY OF THE PROPERTY OF THE PROPERTY OF THE PROPERTY OF THE PROPERTY OF THE PROPERTY OF THE PROPERTY OF THE PROPERTY OF THE PROPERTY OF THE PROPERTY OF THE PROPERTY OF THE PROPERTY OF THE PROPERTY OF THE PROPERTY OF THE PROPERTY OF THE PROPERTY OF THE PROPERTY OF THE PROPERTY OF THE PROPERTY OF THE PROPERTY OF THE PROPERTY OF THE PROPERTY OF THE PROPERTY OF THE PROPERTY OF THE PROPERTY OF THE PROPERTY OF THE PROPERTY OF THE PROPERTY OF THE PROPERTY OF THE PROPERTY OF THE PROPERTY OF THE PROPERTY OF THE PROPERTY OF THE PROPERTY OF THE PROPERTY OF THE PROPERTY OF THE PROPERTY OF THE PROPERTY OF THE PROPERTY OF THE PROPERTY OF THE PROPERTY OF THE PROPERTY OF THE PROPERTY OF THE PROPERTY OF THE PROPERTY OF THE PROPERTY OF THE PROPERTY OF THE PROPERTY OF THE PROPERTY OF THE PROPERTY OF THE PROPERTY OF THE PROPERTY OF THE PROPERTY OF THE PROPERTY OF THE PROPERTY OF THE PROPERTY OF THE PROPERTY OF THE PROPERTY OF THE PROPERTY OF THE PROPERTY OF THE PROPERTY OF THE PROPERTY OF THE PROPERTY OF THE PROPERTY OF THE PROPERTY OF THE PROPERTY OF THE PROPERTY OF THE PROPERTY OF THE PROPERTY OF THE PROPERTY OF THE PROPERTY OF THE PROPERTY OF THE PROPERTY OF THE PROPERTY OF THE PROPERTY OF THE PROPERTY OF THE PROPERTY OF THE PROPERTY OF THE PROPERTY OF THE PROPERTY OF THE PROPERTY OF THE PROPERTY OF THE PROP
F	PROOFED: YESNO	ONLY	-	WORK ORDER NO: (-1856-00)
		TEST TYPE		
\$	Strength Test Ammuni	tion Test D	ry Cycle Tes	tPhoto/Video
<u> </u>	Tunction Test Environm	nentzi Test <u>*</u> M	easurements	Other
<del>*</del> *	Accuracy Test Custome	r Complaint E	ndurance Tea	π
XPLA	IN IN DETAIL THE REASON FOR	THIS TEST:		
00	Please perform The sample of	a full the	d To	met came titet de i
BUNS F	REQUIRED: Syphe	<u>.</u>		
OTE:	NO firearms or parts will be tested	in the Labs unless they are		DATE COMPLETED: 5/25/84
	accompanied by a Work Request, a	and both are delivered to		TEST COMPLETED BY: RW.FS
	the Labs by the designer or enginee	r. All Work Requests are		REPORT DATE:
	to be filled our in desail. No Evens	. •		

#### TEST & MEASUREMENT LAB REPORT

REPORT NUMBER: 841401	
REPORT TITLE: MODEL SE	VEN LWT308 CALIBER TRIAL & PILOT
MODEL(S): SEVEN LWT.	
GAUGE OR CALIBER:	.308
DATE: 5/30/84	
WORK ORDER NO.: 813	43-926
PART NAME: RIFLE	
DESIGNER/ENGINEER: Re	quested by R.S. MURPHY
meem myne.	
TEST TYPE:	
1.	PHOTO LAB
2.	STRENGTH TEST-NO. OF GUNS TESTED
3.	FUNCTION TEST-NO. OF GUNS TESTED 40
4.	ACCURACY TEST-NO. OF GUNS TESTED 19
5.	MEASUREMENTS - TYPE Preliminary
6.	ENVIRONMENTAL TEST
7.	AMMUNITION TESTING & EVALUATION-TYPE
8.	VISUAL EVALUATION 5 OUT OF 40 GUN SAMPLE
9.	ENDURANCE-NO. OF GUNS TESTED: 30,15,7,3
	NO. OF ROUNDS PER GUN 135,300,1000,2000
	TOTAL ROUNDS FIRED IN TEST 15,000
	AMMO TYPE: MAGSTARGET:

RIM FIRE ____ CENTERFIRE __X

#### **BARBER - PRESALE R 0129191**

## REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE

Remington **OPPORD** 

"CONFINE YOUR LETTER TO ONE SUBJECT ONLY"_

Distribution: W.H. Coleman, II

J.W. Bower J.R. Snedeker

R.S. Murphy

File

840971 RESEARCH TEST AND MEASUREMENT REPORT - Report No.

MODEL SEVEN .308 CALIBER PRE-PILOT EVALUATION

Prepared by: J. BAGGETTA

Date Prepared: 4/6/84

Proofread and Cleared by:

R.E. Nightingale, Foreman - Test, Measurement Lab

J.R. Snedeker, Research Supervisor Testing, Measurement & Mech. Analysis Lab

#### TEST & MEASUREMENT LAB REPORT

REPORT NUMBER: 840971	
REPORT TITLE: MODEL SE	EVEN .308 CALIBER PRE-PILOT EVALUATION
MODEL(S): SEVEN	
GAUGE OR CALIBER: .308	
DATE: 4/6/84	·
WORK ORDER NO.: C-1809	
PART NAME: MODEL SEVE	N .308 CALIBER PRE-PILOT
DESIGNER/ENGINEER: J.W	•
TEST TYPE:	
1.	PHOTO LAB
2.	STRENGTH TEST-NO. OF GUNS TESTED
3.	FUNCTION TEST-NO. OF GUNS TESTED 6
4.	ACCURACY TEST-NO. OF GUNS TESTED
5.	MEASUREMENTS - TYPE
6.	ENVIRONMENTAL TEST
7.	AMMUNITION TESTING & EVALUATION-TYPE
8.	VISUAL EVALUATIONOUT OFGUN SAMPLE
9.	ENDURANCE-NO. OF GUNS TESTED:
	NO. OF ROUNDS PER GUN 105
	TOTAL ROUNDS FIRED IN TEST 630
	AMMO TYPE: MAGSTARGET:

RIM FIRE ____CENTERFIRE X

#### **BARBER - PRESALE R 0129193**

REMINGTON ARMS CO., INC. Firearms Research Division Report No. 840971 Page 1

TO:

J.W. BOWER

FROM:

J.A. BAGGETTA

REPORT TITLE: MODEL SEVEN .308 CALIBER PRE-PILOT EVALUATION

#### ABSTRACT

On April 6, 1984 a request was received from J.W. Bower, R&D Firearms Research Manager to evaluate Model Seven .308 Caliber pre-pilot samples.

#### SCOPE OF TEST

To field function six (6) Model Seven .308 caliber rifles, checking for floor plate latch openings and other malfunctions.

#### TEST RESULTS

#### Field Function Α.

Six (6) Model Seven .308 Caliber rifles were fired a total of 630 rounds. No malfunctions or opening of the floor plate latch occurred while firing.

Model Seven .308 Caliber Pre-pilot Evaluation

Report No. 840971 Page 2

#### REPORT TEXT

Six (6) Model Seven .308 Caliber rifles were fired a total of 630 rounds (105) rounds each experiencing no malfunction or opening of the floor latch while firing.

#### TEST PROCEDURE

#### A. Test Conditions

- o The field test was conducted at the Ilion Fish & Game Club 100 yard rifle range.
- o Four men were used, incorporating the "round-robin" system.
- o The men would take fifteen rounds (15) to the line and load one in the chamber and four (4) in the magazine, firing slow, medium and fast.
- o Three (3) ammunition brands were used, Remington, Winchester and Federal. All ammunition was shot from the shoulder.

The rifles used in the Field Function Test were Model Seven, .308 Caliber. Serial Numbers are listed below:

7603349	7603287
7603818	7603386
7603104	7604048

#### B. Ammunition Types

Remington - 150 Grain Pointed Soft Point Remington - 180 Grain Pointed Soft Point

Winchester - 150 Grain Soft Point Winchester - 180 Grain Soft Point Winchester - 200 Grain Silver Tip

Federal - 150 Grain Pointed Soft Point Federal - 180 Grain Pointed Soft Point

#### RESEARCH TEST & MEASUREMENT LAB WORK REQUEST

	AREA OF TESTING					
Developmental	Safety Related	Litigation				
Design Acceptance	Competitive Evalu	ustion Warehouse Audit				
Pre-Pflot	New Design	Cost Reduction				
Pilot	Design Change	Stake				
Production Acceptance	Plant Assistance	Other				
FIREARM STAT'S.	REPORT REC'D.					
MODEL: SEVED	500444	DATE REQUESTED: 4/4/84				
CAL or GAGE: 308	FORMAL	DATE NEEDED BY: ASAP				
BARREL TYPE: ろか	TEST RESULTS	REQUESTED BY: Surbower				
PROOFED: YESNO	ONLY	WORK ORDER NO: C-1809				
•	TEST TYPE					
Strength Test ` Ammuniti	ion Test Dry Cycle 1	Test Photo/Video				
Function Test Environme	ental Test Measuremen	otts Other				
Accuracy Test Customer	Complaint Endurance	Test				
EXPLAIN IN DETAIL THE REASON FOR T	HIS TEST:					
7 . 00 0 +	<u> </u>	p. 0. 4 pa p00.				
<b>5</b> .	in text of pre-	recorrection,				
No munal		•				
cheek for any obvious functional problems, in						
particular, fl	cheek for any obvious functional problems, in particular, floor plate lateling.					
,						
-GUNS REQUIRED:						
	Some resources.					
•						
NOTE: NO fireerms or parts will be tested it	in the Labs unless they are	DATE COMPLETED:				
accompanied by a Work Request, a	nd both are delivered to	TEST COMPLETED BY:				
the Labs by the designer or engineer	r. All Work Requests are	REPORT DATE:				
to be filled out in detail. No Except	ions.					

G-88

#### DON'T SAY IT-WRITE IT

To Bill Coleman	Date 4/13/89
From Jim Some	
La: Trial + Pilat Qe	T + .
	•
Model Seven	308 Caliber

The trial and pailat acceptance of the M/Seven - 308 caliber has been rejected. One gun had a dejective chamber unbich coursed fire-forming of the chamber. No contridge separations occurred. In addition, two guns had poorly younted fining pains. Net wich Process Eng this morningthey will supply another sample. we will continue to test gum from the first sample

to at least newfy the floor yslato latel design.

"DON'T TAKE A CHANCE, THINK SAFETY IN ADVANCE"

# The Lightest Of T

Ranging from six to 7½ pounds in weight, these featherweight production hunting rifles carry more than a little weight with hunters due to qualities like speed of handling and excellent accuracy.

#### By Clair Rees

ONLY A FEW years ago, buying a production bolt-action hunting rifle weighing less than 7½ pounds was almost impossible. Most models nudged the eight-pound mark from one side or the other. To get a really lightweight deer or sheep rifle, you had to take a standard model to a custom gunsmith and let him whittle away to achieve the desired shape and weight.

I'm one shooter who's glad this is no longer the case. The concept of a lightweight, easy-carrying hunting rifle has become so popular that the major gun manufacturers are finally producing a fine selection of such firearms. Browning, Smith & Wesson, and Winchester offer lightweight bolt models ranging from just under to just over seven pounds, while Ruger and Remington have introduced a pair of new ultralight rifles in the six-pound range.

All these rifles represent a significant reduction in weight compared to what was available, they are available in a variety of chamberings suitable for deer-sized and larger game, and in spite of their weight, they are capable of excellent accuracy.

Ruger's new Model 77 Ultra Light is the lightest of the new breed. To get a lighter hunting rifle, you'd have to go the full custom route or at least add a fiberglass stock. The Ultra Light sells for \$455. This six-pound rifle is available in both short and long action lengths to chamber seven popular cartridges: .22-250, .243, .250-3000, .308, .257 Roberts, .270, and .30-06. Ruger's other lightweight offering is the Model 77 International, which is four ounces heavier than the Ultra Light and features a wood-to-muzzle stock. Other than the stock configuration, the rifles are identical.

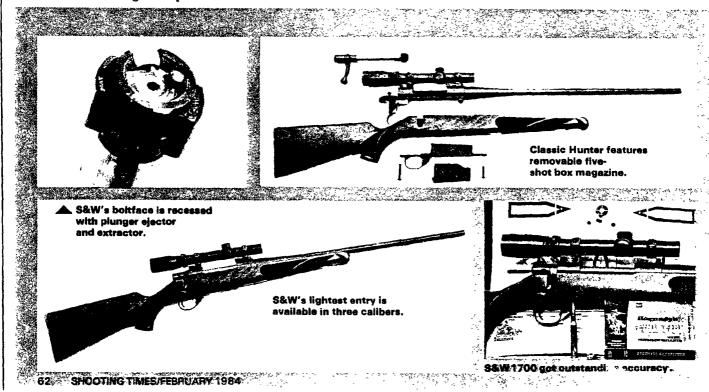
The test gun I had was chambered for the .243 Winchester round and tipped the scales exactly at the advertised six pounds. Overall length was 39% inches with the 20-inch barrel. In addition to shortening the Model 77 barrel a couple of inches, Ruger has drastically tapered it. The barrel of my test rifle measures barely a half-inch across at the muzzle.

The lighter and shorter Ultra Light also differs from other Model 77s by featuring a black forend tip. The butt-stock is of the classic design, with a straight comb dropping only ¼ inch along its length. The stock also sports a %-inch-thic rubber recoil pad.

The Model 77's Mauser-inspired bolt retains the large extractor claw with its external spring arm. This time-proven system provides excellent reliability and extracts even stubborn cases with authority. The ejector is a spring-powered plunger.

Another Model 77 feature shared by the new Ultra Light is the front mounting screw which angles forward. Tightening this screw pulls the barreled action back and down into the stock to provide positive bedding. I've found this system can be temperamental at times, but most Model 77s are capable of excellent accuracy when the tension is properly adjusted.

My .243 Winchester test rifle proved finicky, but it delivered minute-of-angle accuracy when fed the right loads. With factory loads, group size varied between 11/8 and more than two inches



# 11weig

SPECIFICATIONS
Smith & Wesson Model 1700LS Classic Hunter .270 Bolt-Action Rifle

Manufacturer Howa Machinery Co.	Safety
Japan	Sights
Modef 1700LS Classic Hunter	
Type Bolt-action repeater	Riffing
Operation Manual	Magaz
Caliber	Finish
Barrel length ,	Variati
Overall length	
Stock American walnut	Distrib
Orog at comb	
Drop at heel	
Length of pull	
Weight, empty	Price .
<del></del>	

Safety Rocking thumb safety	
Sights None provided; 1%-5X	
Burris mounted	
Riffing 4 graaves, 1:10 RH twist	
Magazine capacity	
Finish	
Variations Available in .30-06	
and .243 Win.	
Distributor Smith & Wesson	
2100 Roosevelt Ave.	
Springfield, MA	
01101	
Price	

across. Frontier's 100-grain loads gave the best results. Handloading shrank the groups to one inch at 100 yards.

The next lightest mass-produced rifle on the market is Remington's new Med el Seven. This short-action beauty in a fered in .222, .243, 7mm-08, 6mm Re ington, and .308 Winchester caliber

and is advertised as weighing 61/4 pounds. Individual rifles will vary in weight, primarily because of differences in wood density, and the test rifle I received tipped the scales at 61/2 pounds four ounces over the specified weight.

Several years ago, Remington offered another short-action carbine called the Model 600. When this rifle was discontinued, the action brought howls of protest from those sportsmen who appreciated its fine handling qualities. When Remington announced its intentions to introduce a new bolt-action carbine, some people were betting it would be a facelift of the old Model 600. But when the Model Seven was finally unveiled, shooters saw a brand-new rifle. The jeweled, highly polished bolt features twin front-locking lugs and a completely recessed face to enclose the cartridge case head. The extractor claw assembly is completely contained within the inside rim of the boltface. A plunger ejector is used.

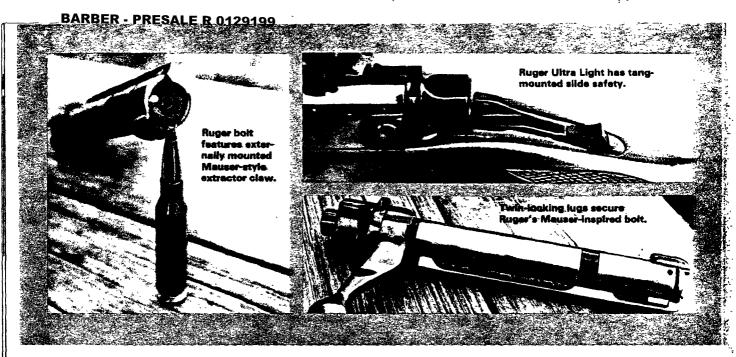
The bolt knob is smoothly elliptical, and the stubby length of the bolt provides a very short throw. The floorplate and trigger guard are blued steel not lightweight alloy. The release for the hinged floorplate is located in the forward part of the trigger guard and projects inside the guard to allow the catch

#### **SPECIFICATIONS**

Remington Model Seven 7mm-08 Bolt-Action Rifle

Manufacturer Remington Arms Co. Inc.
Bridgeport, ET 06601
Model Seven
Type Bolt action
Operation Manual
Caliber , 7mm-08 Remington
Barrel length 18½ inches
Overall length
Stock Checkered walnut
Drop at comb % inch (from center
. line of bore)
Brop at heel
Length of pull
Weight, empty 6½ pounds
Safety
Sights Rear sight adjustable for
windage and elevation; bead-
on-post ramp front sight;
11/2-41/4X Bushnell ScapeChief
VI mounted
Rifling 6 groaves, 1:9.25 RH twist
Magazine capacity 4
Finish Blued Variations Available in 222 Rem.,
. 243 Win., 6mm Rem., and .308 Win.
Distributor Remington Arms Co. Inc.
Price\$449.95





to be pushed fully into position for positive lockup. The front takedown screw is located under the hinged floorplate.

This rifle was designed from scratch for lightweight portability without sacrificing strength. The 18½-inch barrel is free floated except for a single pressure point near the forend tip. The entire rifle is just 37½ inches long, and it balances very well in the hands.

Like most new rifles, the Model Seven sports a straight, classic-style stock which drops ¾ inch from comb to heel. A rubber recoil pad is standard, as are quick-release sling swivel studs. The forend and pistol grip carry a generous amount of cut checkering, while the forend tip sports a schnabel profile.

The trigger was set for a five-pound release as it came from the box. It featured a crisp, single-stage letoff. The two-position rocking safety locks the trigger-but not the bolt-when engaged, allowing the chamber to be loaded without first placing the rifle in firing condition.

Chambered for the 7mm-08 Remington round, my test rifle proved to be a pleasure to fire, with recoil being no problem. Accuracy was very good with factory loads, with groups averaging

## SPECIFICATIONS Ruger Model 77 Ultra Light .243 Bolt Action Rifle

Manufacturer	Sturm, Ruger & Co. Inc.
	Southport, CT 06480
Model	
	Bolt-action repeater
	243 Winchester
Barrel length	20 inches
Drop at comb	% inch (from center
•	line of bore)
Brog at heef	
	6 pounds

1% inches across at 100 yards.

The rifle carries a recommended price of \$449.95.

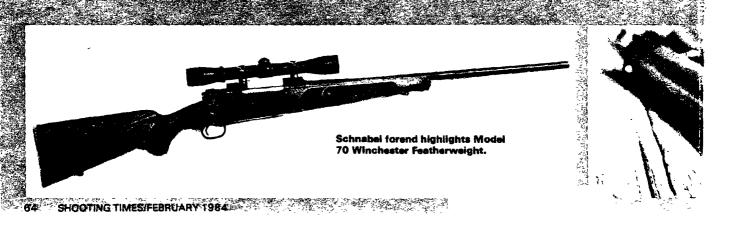
U.S. Repeating Arms' Winchester Model 70 XTR Featherweight is a modern revival of the long-discontinued Model 70 Featherweight first introduced in 1952. At 6¾ pounds, this rifle is a true lightweight in spite of its standard 21¾-inch barrel and relatively conventional design.

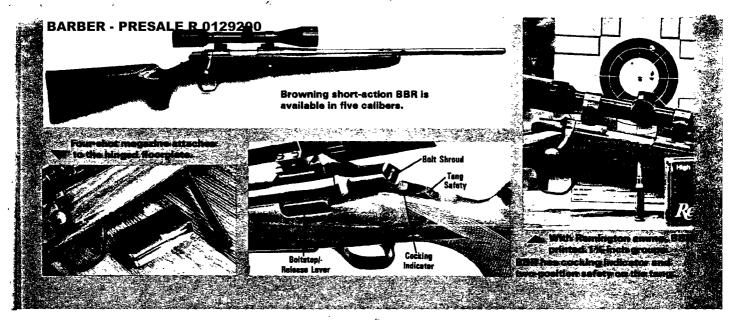
Retailing at a nickel under \$500 with iron sights or \$469.95 without, the Win-

Safety	Two-position tang
	None supplied; Leupold
•	16X scope mounted
Riffing	6 groeves,
	1:10 RH twist
Magazine capacit	y:
Finish	
Variations	Available in .257 Roberts,
	.270, .30-06, .22-250,
	.250-3000, .308 Win.;
	Mannlicher-styled Model
	77 RSI weighs 61/4 pounds
Distributor	Sturm, Ruger & Co. Inc.
	\$455

chester Featherweight is at the top of the Model 70 lineup. Appropriately enough, it sports a highly distinctive stock, complete with the schnabel forend. The checkering has the pattern of cut diamonds interrupted by a gracefully curving inset of smooth wood. A red rubber buttpad and quick-release sling swivels are standard equipment. Overall length is 42% inches.

The Featherweight is available in six excellent hunting calibers: .243 Winchester, .257 Roberts, .270 Winchester,





7x57mm Mauser, .308 Winchester, and .30-06 Springfield.

The Model 70 belt is jeweled and features a fully recessed face. The ejector is a spring-loaded plunger; the extractor claw is inset into the face of one of the twin locking lugs. The three position wing type safety leaves the driven locking but allows the bolt to be seemed in the intermediate position.

experienced riflement

While the Model 70's trigger guard is made of alloy, the hinged floorplate is blued steel. The action is bedded in a thermoplastic matter and the stock carries an attractive seatin finish.

I had the chance to put a 7x57mm Featherweight through its paces, and the rifle performed admirably. With Federal 140-grain factory loads, the streamlined Winchester delivered 1½-

inch groups at 100 yards. A Redfield 4X Tracker scope was mounted, and it made a fine match for the rifle.

Smith & Wesson's actor into the Bat veight rifle masks is the Classic Ruster, which is made in Japan to S&W specifications. While the Standard and Deluxe model S&W bolt rifles average between 7½ pounds and seven pounds, 10 ounces in weight, the Classic Hunter weighs seven pounds in .270 and .30-06 chamberings. The model chambered in .243 Winchester is listed in the specifications at six pounds, 15 ounces. My test rifle digested .270 Winchester loads and was right on the money at seven pounds. It was fitted with a 1¾-5X Burris; no factory sights are supplied.

The Classic Hunter sports a classic stock and has a schnabel forend. The cut checkering is also interrupted, giving the S&W stock an appearance very similar to the Model 70 Winchester Featherweight's. It has a red rubber buttpad. The stock is fitted with sling swivels from Michaels of Oregon, and these are flush mounted to avoid spoiling the smooth lines.

Unlike other S&W bolt rifles, the Classic Hunter has a removable five-(Continued on Page 95)

## SPECIFICATIONS U.S.R.A. Winchester Model 70 XTR Featherweight 7x57mm Bolt-Action Rifle

Manufacturer	. U.S. Repeating Arms Co.	Length of pull
*	275 Winchester Ave.	Weight, empty: 6% pounds:
	New Haven, CT 06511	Safety Three-position wing
Model:	Winchester 70°	Sights None supplied; Redfield
*	XTR Featherweight	4X Tracker mounted
Туре:	Bolt action	Riffling 4 grooves, 1:8.25 RH twist
		Magazine capacity
Caliber	7x57mm Mauser	Finish
Barrel length		Variations Available in .243 Win.,
		.257 Roberts, .270 Win., .30-06,
Stock	Checkered walnut:	and .308 Win.; iron sights
Brograt comb	%, inch (from center	available:
\$ 1 T - 2	line of borok	Distributor U.S. Repeating Arms Co.
		Price \$469.95









SHOOTING TIMES/FEBRUARY 1984

## The Lightest Of The Lightweights

(Continued from Page 65)

shot clip in place of the integral magazine with hinged floorplate. The magazine release lever is located in the trigger guard, just like the floorplate release found on the other models. The trigger guard is alloy, while the magazine is blued steel.

The bolt is jeweled and features a blued cocking piece shroud. The bolt-



Author found all the lightweight rifles pleasant to shoot.

face is recessed with a generously proportioned plunger ejector. The handle of the bolt is knurled and blued. The two-position rocking safety alongside the receiver leaves the bolt fully operable when engaged.

Like the Model 70 Featherweight, the

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S&W Classic Hunter is a full-sized rifle. Sporting a 22-inch barrel, it runs 42½ inches from muzzle to butt. At \$479.95, the Classic Hunter is the most expensive bolt rifle offered by S&W. I think it's also the most attractive.

Accuracy was exceptional, with Hornady-loaded 140-grain Frontier factory ammo yielding sub-minute-of-angle groups measuring ¾ inch across.

At 7¼ pounds, Browning's Japanesemade BBR bolt rifle is the heaviest of the new lightweight rifles evaluated. This is still a very light sporter by any standard, and when introduced in 1978, it ranked among the lightest production rifles then on the market.

The BBR I've been using is one of the short-action models chambering the 7mm-08 Remington cartridge. Other calibers offered include the .243 Winchester, .22-250 Remington, .257 Roberts, and .308 Winchester. The short-action BBR has a 22-inch barrel, two inches shorter than barrels on the longer Browning bolt rifles. The short BBR is also six ounces lighter and features a classic, straight-combed stock; the standard model has a Monte Carlo comb with a raised cheekpiece.

The BBR rifle is also known as the "Lightning Bolt," as the bolt handle travels through a short, 60-degree arc to lock or unlock the action. The Browning centerfire also features an antiwarp forend with an eight-inch-long section of ½-inch-thick aluminum channel ma-

terial inletted below the barrel channel. Its purpose is to stiffen the forend and prevent warpage.

Releasing the hinged floorplate lowers a detachable box magazine that clips to the swing-down floorplate. The magazine can be loaded in place or removed to make loading easier.

Nine forward locking lugs are arranged in triple rows for a very strong design. The boltface is deeply recessed. The magazine is cleverly designed to make sure each cartridge is properly seated all the way to the rear as the magazine is loaded. The same tapered feeding lip that nudges each round rearward during the loading process ensures positive feeding when it's time to chamber a round.

The bolt action is very smooth and slick, and very little effort is required to cycle the bolt. The trigger sported a clean, 3½-pound letoff, but it can be adjusted between three and six pounds.

The BBR Browning comes without sights. I mounted a new Bausch & Lomb 4X scope on mine. The rifle delivered 1½-inch, three-shot groups with Remington's 140-grain PSP factory loads. The short-action BBR lists at \$469.95.

I am very favorably impressed with the lineup of lightweight factory rifles being offered. I've toted my share of overweight firearms afield, and now that I'm older and wiser, I'm glad there are finally some slimmed-down production hunting rifles available across the counter.

These new rifles will be my first choice on future hunts. I'm betting a lot of other sportsmen will feel the same way.

110





SHOOTING TIMES/FEBRUARY 1984

RD-49-15

## REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE

Xc: C.B. Workman

T.L. Capeletti J.W. Brooks



PETERS

"CONFINE YOUR LETTER TO ONE SUBJECT ONLY"_

Ilion, New York March 10, 1981

TO:

J. S. MARTIN

F. E. MARTIN - S. A. FANELLI

SUBJECT: M-7 SCHEDULING

The program for M-7 Bolt Action Development, with the rifle as

shown with no or minor alterations, can be as follows:

6-81

Design Verification (Drawing Completion)

8-81

Hi-Spot Cost Review

1-82

Product Acceptance (Models for Acceptance)

1-82

Design Transmittal

Future dates dependent on Marketing decision.

FEM:SAF:T

Firearms Research Division

#### **BARBER - PRESALE R 0129203**

## REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE

Remington OUPOND.

"CONFINE YOUR LETTER TO ONE SUBJECT ONLY"_

September 2, 1981

To:

I. S. Martin

From: F. E. Martin

Subject: M/7 Design Specification

The M/7 proto-type was conceived with these specifications:

Octagonal Receiver

Light Weight Firing Pin (reduced lock-time)

Fully Enclosed Bolt Plug with Cocking Indicator — Enclosed Pick and Cocking Indicator — Enclosed Pick and Cocking Indicator — Enclosed Pick and Cocking Indicator — Enclosed Pick and Cocking Indicator — Enclosed Pick and Cocking Indicator — Enclosed Pick and Cocking Indicator — Enclosed Pick and Cocking Indicator — Enclosed Pick and Cocking Indicator — Enclosed Pick and Cocking Indicator — Enclosed Pick and Cocking Indicator — Enclosed Pick and Cocking Indicator — Enclosed Pick and Cocking Indicator — Enclosed Pick and Cocking Indicator — Enclosed Pick and Cocking Indicator — Enclosed Pick and Cocking Indicator — Enclosed Pick and Cocking Indicator — Enclosed Pick and Cocking Indicator — Enclosed Pick and Cocking Indicator — Enclosed Pick and Cocking Indicator — Enclosed Pick and Cocking Indicator — Enclosed Pick and Cocking Indicator — Enclosed Pick and Cocking Indicator — Enclosed Pick and Cocking Indicator — Enclosed Pick and Cocking Indicator — Enclosed Pick and Cocking Indicator — Enclosed Pick and Cocking Indicator — Enclosed Pick and Cocking Indicator — Enclosed Pick and Cocking Indicator — Enclosed Pick and Cocking Indicator — Enclosed Pick and Cocking Indicator — Enclosed Pick and Cocking Indicator — Enclosed Pick and Cocking Indicator — Enclosed Pick and Cocking Indicator — Enclosed Pick and Cocking Indicator — Enclosed Pick and Cocking Indicator — Enclosed Pick and Cocking Indicator — Enclosed Pick and Cocking Indicator — Enclosed Pick and Cocking Indicator — Enclosed Pick and Cocking Indicator — Enclosed Pick and Cocking Indicator — Enclosed Pick and Cocking Indicator — Enclosed Pick and Cocking Indicator — Enclosed Pick and Cocking Indicator — Enclosed Pick and Cocking Indicator — Enclosed Pick and Cocking Indicator — Enclosed Pick and Cocking Indicator — Enclosed Pick and Cocking Indicator — Enclosed Pick and Cocking Indicator — Enclosed Pick and Cocking Indicator — Enclosed Pick and Cocking Indicator — Enclosed Pick and Cocking Indicator — Enclosed Pick

Blocked Trigger and Sear - Neel "sats and " !!

New "No Drag" Follower (to enhance action smoothness) - //s- - fample Touris.

A Truly "Classic" Stock - No Montelan on Treckpier, make ( Israel &

A Functional Checkering Pattern

No Sights

Classic Calibers i.e., .257, 7 x 57, .35 Whelen, etc.

Limited Production of Calibers 3,000 - 4,000

+ Scope Mounts
+ Option of Floorplete on Letochobit Myrin Gin

+ Hew Extractor

Desciposant required

9/11/81 E

#### M/7 DESIGN SPECIFICATION

This is a composite listing of features provided on the M/7 proto-type and those desired by Research:

- Octagonal Receiver
  - Investigate the use of octagonal stock
  - Heavier barrel lug
- Walnut Stock
  - True Classic
  - No Monte Carlo
  - Cheekpiece
  - Cut functional checkering
  - Sling swivel studs
- Hammer Forged Barrel
  - No turn or polish
  - Program to determine possible benefits i.e., accuracy vs. finish
  - Lightweight slimmer contour
  - Clean no sights
- Fire Control
  - Blocked trigger and sear
  - Bolt lock
  - New safety configuration or location
  - With safe adjustments
- Improved (Reduced) Locktime
  - Lightweight firing pin
  - Investigate pierced primer gas flow around firing pin and head
- Additional Desired Features
  - Scope mounts
  - New bolt handle
  - Teweled
    - follower
    - bolt body
- New Extractor
- New Feeding System
  - To be smoother
  - To be functionally superior
  - To be detachable with integral magazine box

#### **BARBER - PRESALE R 0129205**

- Classic Calibers
- Limited Production 3,000 4,000 per year

F. E. Martin:ws September 11, 1981

T Capitette

file#53

February 25, 1982

Mr. Faul Holmberg
Marketing Mgr. Firearms
Remington Arms Co., Inc.
Bridgeport, Conn. 06602

Dear Paul:

For what its worth, I'd like to say that I was absolutely flabergasted and smitten with your Model 7. Its in very good taste aesthetically by a gun connoiseur's standards; deviating from what might be considered conventional, or normal, just enough to be highly interesting. Its approaching, if not indeed, trend setting and some comments I guess I made relative to Winchester and Ruger squirming weren't merely rhetoric but heartfelt and sincere.

I suppose I have to be a bit presumptious to say so but my advice would be to take the ball and run.

I enjoyed my stay and tour of the plant immensely. Very educational in so many ways. I was glad to see you and Tom again and will look forward to seeing you both at Fhiladelphia.

Best wishes.

Bob Emmons 238 Robson Road Grafton, Chio 44044

## REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE

Xc: <u>T. L. Capeletti</u>

Remington **OUPOND** 

"CONFINE YOUR LETTER TO ONE SUBJECT ONLY"_

February 23, 1983

TO:

J. S. MARTIN

FROM:

F. E. MARTIN

SUBJECT:

M/7 LWT TRIGGER GUARD ASSEMBLY

This item has been turned over to the Current Firearms Design Group for follow up and testing. Present status with this group is unknown. Advantages for implementation would be its:

- Lightweight
- Stronger Assembly
- Rust Resistance

#### Disadvantages:

- Not Steel
- Coloring Problem
- Cannot be Recolored Easily

711 FEM:ws SALES

CEPARTMENT

Remington Remington Remington

Quick Facts About REMINGTON PRODUCTS

cc: House Force

Bridgeport, Connecticut March 24, 1983

#### TO THE FIELD FORCE:

You have already received a request to contact your jobber customers, instructing them to hold further delivery of any Model Seven rifles on hand and to supply you with a list of dealers who have received delivery of Model Seven rifles.

Our ultimate intention is to update all Model Seven rifles shipped to date by means of a return to the nearest Remington warranty gunsmith service location or to Arms Service in Ilion.

We have discovered that if a Model Seven rifle is disassembled after it leaves the factory, it is possible for the rifle to be reassembled incorrectly, producing off-center trigger alignment that might cause subsequent malfunction of the trigger and accidental firing of the rifle. The updating service on the rifle will eliminate the possibility of such incorrect reassembly.

To accomplish this, you are requested to obtain:

- 1. A list of all Model Seven rifles and matching serial numbers still in an individual jobber's inventory.
- 2. A list from the jobber of the names and addresses of dealers to whom Model Seven rifles have been shipped, including serial numbers.

Both jobbers and dealers will then be contacted by Product Service with instructions on how to have the rifles updated. Consumer purchasers of Model Seven rifles will also be contacted by Product Service with a request and instructions to have the rifles updated.

### REMINGTON ARMS COMPANY, INC., BRIDGEPORT 2, CONN.

Form No. RD 451

Printed In U.S.A.

#### **BARBER - PRESALE R 0129209**

Field Force Page 2 March 24, 1983

In all contact with jobbers, dealers, and retail customers on this subject, it is important to emphasize that the potential malfunction is remote, can occur only on a Model Seven rifle that has been disassembled and subsequently reassembled outside the factory, and that the update applies only to Model Seven rifles and not to any other Remington models.

This update is being incorporated into all Model Seven rifles to be shipped in the future.

Sincerely,

E. J. Conroy Director of Sales

EJC/dr



F. 82.

### REMINGTON ARMS COMPANY, INC.

TELEX 964-201 STRATFORD CT SPORTING ARMS-AMMUNITION-TARGETS-TRAPS

939 BARNUM AVENUE P.O. BOX 1939 203-333-1112

**BRIDGEPORT, CONNECTICUT 06601** 

March 31, 1983

#### TO OUR DISTRIBUTORS:

Remington Arms Company has discovered a problem that may develop with the Model Seven rifle and is requesting you hold further delivery of the Model Seven that remain in your inventory until notified. This letter provides you with the necessary details regarding this request.

We have discovered that if a Model Seven rifle is disassembled after it leaves the factory, it is possible for the rifle to be reassembled incorrectly, producing off-center trigger alignment that might cause subsequent malfunction of the trigger and accidental firing of the rifle.

Since a rifle may be disassembled at any time in the future for one of several reasons, we wish to update all Model Seven rifles with a preventative modification that eliminates the possibility of such incorrect reassembly. As a result, if you have not already done so, we are requesting your assistance with the following actions:

- 1. Please hold any Model Seven rifles still in your inventory.
- 2. Please send to us (c/o Remington Arms Co., Inc., 939 Barnum Avenue, P. O. Box 1939, Bridgeport, CT 06601, Attention J. D. Glenn) or provide your Remington Field Representative with a list of the names and addresses of dealers to whom you have shipped Model Seven rifles with matching serial numbers for those rifles. We will then contact those dealers with instructions for the updating modification.

3. Please return any Model Seven rifles still in your possession to the Remington warranty gunsmith service location nearest you for the updating modification. A list of such locations is enclosed. If it is inconvenient or difficult for you to return Model Seven rifles to a warranty service location, you may also ship them to:

Remington Arms Co., Inc. Arms Service Division Ilion, NY 13357

To expedite, shipments should be made prepaid. Upon receipt of a copy of your freight bill, Remington will issue a check for same. Your receipt should also be referred to J. D. Glenn (c/o Remington Arms Co., Inc., 939 Barnum Avenue, P. O. Box 1939, Bridgeport, CT 06601) for handling.

In returning Model Seven rifles to either location, please include your company name and return mailing address inside each box. The updating of your rifles and return to you will be accomplished as quickly as possible. While the possibility of the described malfunction is remote and it can occur only if the rifles are disassembled after they leave the factory, we believe it is in the best interests of the eventual owner to have this preventative modification performed.

We apologize for whatever inconvenience this may cause you. This update applies only to Remington Model Seven rifles shipped prior to this date and not to any other Remington models. The corrective action will be incorporated into all Model Seven rifles to be shipped in the future.

If you have any further questions, or if any of your dealers have questions concerning this request, please feel free to call us on the following toll free number, 800-243-2953 (operational after April 8, 1983), between 8:00 a.m. and 4:30 p.m. Eastern Standard Time.

E. J. Controy

Director of Sales

EJC/dr Enc.

#### PRODUCTS SCHEDULED FOR 1984 INTRODUCTION

Cepeus mdg 6/17/83

July M/Seven

#### MODEL SEVEN . 223 REM. . /

#### Marketing Comments

The domestic market for rifles in .223 Rem. has increased as a result of the availability of low cost ammunition. Since the Model Seven was introduced, we have had numerous requests from distributors and dealers to add this caliber. We believe the addition of the .223 offers the potential for increased Model Seven sales and will help improve dealer relations. The short, light weight of the Model Seven is appropriate for the .223 Rem. caliber.

High spot economics will now be presented to the Committee (Exhibit 1).

#### Research Comments

Design test of no bind follower in progress. If satisfactory, transmit June 10.

#### Production Comments

Trial and pilot operations have commenced on the barrel. Assembled guns should be ready for Research acceptance testing in August. Production will start in September with guns going to the warehouse in November.

.∽RΔE	NEW PRODUCT DEVELOPMENT I	REQUEST DATE May 24, 1983
	CTION A	Dill 1107 24, 1703
Ĩ.	Description of New Product	
	Add the .223 caliber to the Model Seven	EXHIBIT 1
II.	How Fit Strategic Plan/Business Missio  o New caliber offering intended to take advar of 223 Rem. o Market share restoration.	<del></del>
111.	Economic Estimates (Outset) Price - \$449.95	YEARS
	A. Forecast Sales Volume (M Units)	2.5 3.0
	Total Incremental	
	B. Pretax Earnings (\$M)	
	Full Book Incremental	39.0 94.0 168.0 255.0
	C. Program Investment (\$M) (Incremental Costs to Implement)	
	Research Expense Production Expense Permanent Investment Increase in Working Capital	17.0 1.5 (Add-use of existing tooling) 280.0
	D. Net Return on Program Investment (Years 1 & 3 Only)	31% 35%
	E. Payback (# of Years) 3.5 Years	
	F. Manpower (Man Years of Effort) Mkt	g02 Prod10 Res392
	G. Probability of Success (Check One)	X HighMediumLow
ıv.	Development Responsibility (Check One)	X Research Production
ν.	Marketing Approval	
	Director Finance	
	Director Legal	
	Director Marketing	
	Director Production	
	Director R & D	

#### IMPROVEMENTS TO EXISTING PRODUCTS

#### MODEL SEVEN

#### Research Comments

The short-term modification of this design includes the items shown on Exhibit I.

The material thickness in the floor plate cover and the floor plate base has been increased from .050" to .062" to increase rigidity and facilitate production assembly operations. The material thickness of the trigger guard plate has been increased from .050" to .080" and the width has been increased from .625" to .750" for the same reason.

The latch spring may require modification to optimize latch opening force. This remains to be determined. The modifications should be limited to a material thickness change and/or a slight change in shape.

It has been demonstrated that brazing the trigger guard to the trigger guard plate plays a major role in preventing floor plate opening. This operation would be difficult to perform in production so an alternative method of maintaining a tight joint is being pursued. This involves an interference fit that can be easily monitored by the final assembler.

Finally, a sensitivity analysis is in process that addresses each of the factors that has at one time or other appeared to contribute to the problem. These factors are shown on Exhibit II.

- o Opening Force: The opening force required to disengage the latch should be in the neighborhood of 7 lb. minimum. This requires additional verification.
- o Latch Coverage: A minimum of 50% latch coverage on the floor plate cover must be maintained.
- o Bedding of Assembly to Stock: The amount of contact between the assembly and the stock has proven to be an insignificant factor. This fact may allow for a more positive method of maintaining latch coverage at final assembly with the use of spacers.
- o Tightness of Trigger Guard: Tests so far indicate that this may be one of the most important factors. The joint between the front of the trigger guard and the trigger guard plate must be tight.
- o Angle at the Rear of the Guard Bow: Variations in this angle within a wide tolerance band have proven to be insignificant.

Addendum A-1

- O Clearance Between Floor Plate and Stock: This is still in test.
- o Soft vs. Heat Treated Bow: The trigger guard must be heat treated to prevent the interference fit from becoming loose during customer use and to prevent distortion if the gun is dropped or bumped. Soft trigger guards are easily distorted with rough handling.
- o Floor Plate and Latch Design: It has also been demonstrated that bending the assembly to establish latch coverage at final assembly is an unsatisfactory procedure since the bent part does not maintain its shape or location.

At the conclusion of the sensitivity analysis, a sample of 25 guns will be assembled by Research and tested to verify the findings. Pending satisfactory results and no complications, our earliest transmittal date for the revised design is June 10.

#### Production Comments

Production is continuing on the Model Seven in the .222, .243, and 6mm calibers. At the current rate of production, 1983 demand requirements for these calibers will be completed by about September 1. Production for the remainder of the year will build 1984 inventory.

The best case situation to resolve the floor plate opening malfunction would be a design change allowing production to start assembly of the 7mm-08 and .308 by September 1. This would permit continuous production against 1983 requirements. To accomplish this, design release would be required no later than mid-June 1983.

The worst case would be a major design revision entailing the use of die cast or investment cast components. This would require six to nine months to complete after release of the design. The casting schedules are based on a best effort basis by the vendors.

Based on the latest information from Research, Production will follow these steps to institute the design changes to the Model Seven LWT rifle.

One hundred to two hundred rifles will be assembled utilizing trigger plate assemblies fabricated from heavier stock. These trial and pilot parts will be made on temporary vendor tooling. All of the critical dimensions and performance characteristics will be checked on vendor and production parts to verify vendor and process controllability.

The rifles will be assembled and the critical factors from Research's sensitivity analysis will be checked. The rifles

will be tested in the Gallery and turned over to Research for product verification testing.

With positive test results, the vendors will develop permanent tooling and start running production quantities of parts. Initial production of rifles would start in September.

#### Marketing Comments

When the Model Seven was announced, we provided estimated availability dates by caliber to the trade through the field force. The full line catalog also contained these dates to advise retail customers when the various calibers would be available. The .308 and 7mm-08 were originally scheduled for January and March respectively. With the production delay on these calibers, it will be necessary to notify our customers of the revised availability dates.

Should the delay be three months, the field and our distributors will be contacted and advised of the new delivery date. Under these conditions no significant increase in distributor orders for 7mm-08 and .308 can be expected prior to initial delivery. A forecast reduction will be necessary.

A comparison of orders and shipments indicates that 45% of total orders are 7mm-08 and .308. A three month delay would place initial shipments of these calibers in September. There would be approximately 30 days available to ship the 8,000-9,000 current orders prior to the start of fall hunting seasons. Production planning estimates this quantity represents in excess of two months' production. Beyond September, distributors will not take in sizeable firearms shipments and some cancellations are expected. We estimate lost sales at 5,000-6,000.

In the event of a delay in excess of three months, product would not be available to the trade in advance of the hunting season. In this case, 45% of the Model Seven forecast would be lost for 1983. We would make every effort to write additional business for the three calibers in production. If we were successful in selling 3,000-4,000 additional rifles, the reduction in forecast would be approximately 10,000 guns. If there is an extended delay, it will be necessary to advise the field force and our distributors. In addition, a public relations release would be required to update the status of the Model Seven. (See Chart III.)

#### EXHIBIT I

# MODEL SEVEN SHORT TERM MODIFICATION

- HEAVIER MATERIAL
- WIDER TRIGGER GUARD BASE
- MODIFIED LATCH SPRING
- INTERFERENCE FIT
- SENSITIVITY ANALYSIS

#### SCHEDULE

- DESIGN TESTING JUNE 8
- TRANSMIT DESIGN REVISION JUNE 10

#### EXHIBIT II

#### MODEL SEVEN

#### SENSITIVITY ANALYSIS

1)	OPENING FORCE	Min. 7 lb.
2)	LATCH COVERAGE	Min. 50%
3)	BEDDING - ASSY. TO STOCK	Insignificant
4)	TIGHTNESS OF TRIGGER GUARD	Must be tight
5)	ANGLE AT REAR OF GUARD BOW	Insignificant
6)	CLEARANCE BETWEEN FLOOR PLATE & STOCK	?
7)	SOFT vs. HEAT TREATED BOW	Heat Treated

Cannot bend to adjust for coverage

EXHIBIT III

## MODEL SEVEN ORDERS & SHIPMENTS (Total Company 5/9/83)

	Orders	% of Total	Shipments	% of Orders	Balance to be Shipped
;	0.012	11 2			2 212
222	2,213	11.3			2,213
243	6,529	33.2	3,069	47.0	3,460
6mm	2,048	10.4	1,257	61.4	791
7mm-08	2,875	14.6			2,875
308	5,973	30.4			5,973
		<del></del>			
TOTAL	19,638	100.0	4,326	22.0	15,312

- Total orders (19,597) are 68.5% of Forecast (28,605).
- 45% of orders are 7mm-08 and 308 (8,833).
- Total Forecast for 7mm-08 and 308 = 12,925
- Probable loss of 5,000-6,000.

همین Mdg ۱۵/27/83

#### MODEL 7 CAL. .308 AND 7MM-08

#### Production Comments

Designs have been transmitted and the casting supplier has started die fabrication.

Samples are expected the week of February 3 and Trial and Pilot machining operations will begin immediately upon receipt. Tool delivery will be a key factor in timely completion of the Trial and Pilot phase. Each tool will be individually prioritized by need date before submitting to Purchasing for handling.

If the design is confirmed by Research, production to the warehouse will commence in July, 1984.

Addendum L

#### Comments:

- Both designs are successful thus far and cost nearly the same.
- Production estimates trial and pilot for either design can be completed by January 1984.

<u>Action</u>: Committee requests the Model 1100 12 Gauge Special Field not appear in the 1984 firearms catalog.

Reference: Research and Production comments and exhibits in Addendum G.

#### Item: Model Seven Calibers .308 and 7mm-08

Problem: Premature opening of floor plate in heavy calibers.

Impact: Delay shipment of these products until second quarter, 1984.

Solution: Aluminum floor plate and trigger guard assembly.

#### Status:

- Sensitivity tests of new design commenced on caliber .308.
- First steps of design review started by Production.
- Casting dies and sample parts ordered for trial and pilot.
- Production to warehouse targeted for second quarter, 1984.

Action: Committee requests the Model Seven in caliber
.308 and 7mm-08 not appear in the 1984 catalog.

Reference: Research and Production comments in Addendum H.

#### GENERAL

#### Item: Cut Checker Capacity

Objective: Determine cut checkering capcity needs relative to the No. 1-1984 Sales Forecast and planned new product programs.

Status: Production is pursuing equipment manufacturers' quotes expected by 10/15/83.

#### KEY ISSUES

#### #2 - ACHIEVE 30% RETAIL MARKET SHARE

#### MODEL SEVEN CALIBERS .308 and 7mm-08

#### **Production Comments**

Advance prints of the new aluminum trigger guard components were received in early July. Proposed processing techniques were developed and reviewed with Research to refine both the design and the process. the casting supplier was also consulted to assure that the design was producible on a continuing basis, and that gauging characteristics and quality criteria were realistic. This is the first step of the design review to insure the parts will perform as intended. A purchase order has been placed for casting dies and sufficient sample parts to support trial and pilot operations.

Tooling lead times have extended since mid-summer, creating a tight schedule for second quarter warehouse date. Trial and pilot completion is contingent on timely tool deliveries and acceptable die castings on the first attempt by the vendor.

Production quantities to the warehouse could start approximately 8-10 weeks after completion of design confirmation testing by Research (Exhibit 1).

#### Research Comments

Ten prototype aluminum trigger guards and covers will be completed the week of September 19 for assembly. Complete .308 caliber rifles with the prototype trigger guard assemblies will be furnished to the test lab for sensitivity the following week.

Drawings of this trigger guard and cover were transmitted to the plant on September 1. The stock drawing and other component required for this change will be transmitted to the plant the last week of September.

**WAREHOUSE** 

## MODEL SEVEN LIGHTWEIGHT ALTERATIONS IMPLEMENTATION SCHEDULE

	AUG, SEP, OCT, NOV, DEC, JAN, FEB, MAR, APR, MAY, JUN,
TOOL DESIGN	
TOOL BUILD	
VENDOR SAMPLES	
TRIAL & PILOT	<del></del>
DESIGN VERIFICATION	· · · · · · · · · · · · · · · · · · ·
VENDOR PRODUCTION	
PLANT PRODUCTION	

Tile M/ Seven

> 8-19-83 J.W. BROOKS

#### MODEL SEVEN LIGHTWEIGHT

(Decision of Operations Committee to use Aluminum Trigger Guard - 6-83)

ITEM	S TO COMPLETE	COMPLETED BY
0	Casting Drawing Dimensioning decisions	8-25
0	Drawings completed and send to vendor	9-1
0	12 model prototypes complete -(trigger guards)	8-31
0	Stocks complete (M. Monteau for program - Parker for complete Stock)	
0	Trigger Guard screws (if needed)	
0	Sensitivity test (Use .308 Cal.) (10 Models) (Design verification)	
0	Design verification - 7mm-08 (5 models)	
0	Pre-transmittal Field review 5308 Cal. and 5 - 7mm-08 Cal.	
0	Transmittal drawings and parts list	
0	Post transmittal Field review	

(Same rifles used in pre-transmittal review)

#### MODEL 870 LOW COST

TEM	S TO COMPLETE	COMPLETED BY
0	Receive report on ejection testing of 2 3/4 shells from 3" chambers	8-24
0	Larger test sample on ejection testing of 2 3/4 shells from 3" chamber (Std. 2 3/4 control Extractor clearance	e) 9 <b>-</b> 15
0	Decision on ejection tests	9-22
	Rollmarking required on Receiver and Barrel. (Marketing)	8-25
0	Build 10 models	
0	Pre-transmittal field review	-
0	Transmittal of drawings and parts list	

#### MODEL 700 LOW COST

ITEM	TO COMPLETE	COMPLETED BY
0	Receive report on 10 gun function test	0.10
0	on .243 caliber Redesign and retest magazine, follower,	8-18
Ü	spring and spacer (or other options)	
0	Rollmarking of Barrel and Receiver (Marketing)	8-25
0	Complete drawings and parts list (preliminary drawings and parts list to Process)	9-2
0	Test rifles with M/788 Rem. sight and M/700 front sight (100 Gr. Bullets) P.O. I 243 ready for test 8-26 .	9-16
0	Build models	
	5-270 5-30-06	
0	Design verification (270, 30-06)	
0	Design verification (.243)	
0	Pre-transmittal Field Review	
0	Transmittal drawings and parts list	

#### MODEL 870/1100 WATERFOWL

ITEM	S TO COMPLETE	COMPLETE BY
MODE	L 870	
0	Model requirement agreement (Marketing)	8-15
٥	Design verification (5 Models)	
0	Build 10 models	
0	Pre-transmittal Field Review	
0	Transmittal of drawings and parts list	
MODE	L 1100	
0	Model requirement agreement (Marketing)	8-25
0	Test 5 models (does parkerize effect function)	
0	Build 25 models	
0	Design verification (25 models)	
0	Pre-transmittal (10 models) (Use 10 from above)	
0	Transmittal of drawings and parts list	

#### MODEL 700 CLASSIC .338 MAG.

#### ITEMS TO BE COMPLETED

COMPLETED BY

- o Build 5 models (Need new Mandrel and Chamber reamer)
- o Design verification
- o Transmit drawings and parts list

#### MODEL 870 COMPETITION TRAP SET

#### ITEMS TO COMPLETE

COMPLETED BY

- o New Stock
- o Field test of 16 yd. Barrels (Marketing)
- o Packaging
- o Transmittal of drawing and parts list

#### MODEL 1100 LOW COST

#### ITEMS TO COMPLETE

COMPLETED BY

- o Define model requirements
- o Build 5 models (each gauge)
- o Design verification (5 models)
- o Pre-transmittal Field Review (10 models any mix)
- o Transmit drawings and parts list
- O Post transmittal Field Review
  (10 models any mix)

BARBER - PRESALE R 0129231

REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE



DETERS

"CONFINE YOUR LETTER TO ONE SUBJECT ONLY"_

Ilion, New York December 8, 1983

Copy & Evan Ritchia - Rlean melide in a

future wourkours audit. File - MI-

xc: R.A. Murphy

TO:

J.W. BOWER

FROM:

J.A. LAWRENCE JL

SUBJECT:

MODEL SEVEN SAFETY BUTTON,

BOLT PLUG CONTACT

This morning Bill Warren informed me that the safety button is contacting the bolt plug on the Model Seven rifle in approximately 60% of the guns inspected in a Warehouse Audit, comprised of all of October production and all .223 cal. Model Sevens.

Testing in P E & C has indicated that this situation does not pose a problem with the proper operation of the safety. However, it does create unsightly lines on the bolt plug that are astatically unacceptable.

Bill feels the contact is a result of using the Model 700 projection welding fixture (used to weld the safety button to the safety leve/) instead of the Model Seven fixture. This cants the safety button allowing it to contact the bolt plug. Bill's opinion is, there is no reason to believe the correct fixture was ever used, indicating all Model Sevens may be affected by this contact.

Bill assured me that the correct fixture will be used for all Model Seven safeties manufactured in the future. All Model Sevens previously manufactured will be screened for contact before shipments are made, pending a decision on what to do with the contact situation on the existing rifles.

JAL: js

File M/Seveen

RD-49-8

### REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE

DETERS

Remington. **QUPOND** 

"CONFINE YOUR LETTER TO ONE SUBJECT ONLY"____

December 12, 1983

Xc: J. W. Bower
J. A. Lawrence

TO:

W. A. WARREN

FROM:

R. S. MURPHY 23M

SUBJECT:

MODEL SEVEN BOLT PLUG/SAFETY BUTTON CLEARANCE

Based on Fred Martin's layout of the Model Seven, the clearance between the bolt plug and the safety button can range from +.037" to -.008". This represents a .045" range with a mean figure of +.0145.

RSM:ws Ilion Research Division 

# Loading For Th

BY CLAY HARVEY

The current craze in rifles is the trend toward the lightweights. Clay Harvey secured a batch of them and worked up 41 handloads in five calibers in an effort to expose some of the more popular misconceptions.



## e Lightweights





(Turn Page For Story)

LIGHTWEIGHT hunting rifles are making a strong comeback. It's a good thing. Within given and easily established parameters, the lighter the hunting gun the better. The current crop of airweight rifles includes notables like the Remington Model Seven, the Winchester Model 70 Featherweight, the Ruger Model 77 International and Ultra Light, the Smith & Wesson Classic Hunter, and the new Browning BBR short action.

Actually, some of the rifles in this group are not as lacking in heft as you might think. The two Rugers and the Remington Model 7 are the only true lightweight models, although the others are lighter than the standard rifles offered by the same firms. In addition, the Winchester, Browning, and Smith & Wesson carry normal-length barrels of 22 inches, although barrel contours are slimmer than usual. The Ruger International and the Remington Seven both sport 18.5-inch barrels; the Ruger Ultra Light has a 20-inch tube.

Various misconceptions have slipped into the public's mind over the years, many of them concerning the handloading and accuracy aspects of light, short-barreled rifles. Here's a sampling: short-barreled rifles are less accurate than their standard-length counterparts; light, "whippy" barrels do not shoot well, regardless of length; will not shoot well; short-tubed rifles lose so much velocity that the resulting ballistics are inadequate for hunting: if you must use

a short-barreled rifle, you should burn a fast-burning rifle powder in an effort to salvage as much velocity as possible.

In order to demonstrate the fallacies of each of these "truisms," I secured a representative batch of test rifles from several manufacturers. All had trim, whippy barrels, and one was full-stocked. The guns and calibers were: Remington's Model Seven in 6mm Remington, Ruger's International in .250-3000, U.S.R.A.'s Winchester Model 70 Featherweight in 7x57 Mauser, Smith & Wesson's Classic Hunter in .243 Winchester, and Browning's BBR in 7mm-08.

Let's expose some myths . . . .

#### **Inaccurate Short Barrels**

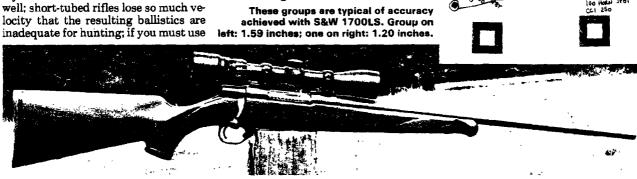
You can decide for yourself whether my short-barreled test rifles were inaccurate, but let me point out a few facts. Competitive benchrest shooters have proven short tubes are accurate—more accurate than longer, less-rigid barrels. Remington's 40X-BR bench rifles are sold with 20-inch barrels and used to win the NBRSA's Light Varmint classes regularly. (Remington also makes a 24-inch 40X-BR, but it is designed for the Heavy Varmint class and is no more accurate than the 20-incher.)

Remington's short-tubed Models 600 and 660 of nearly 20 years ago were noted for their accuracy, particularly in .222 Remington. That same firm mar-

kets a handgun (the XP-100) based on the identical action which has a 10.5inch barrel and will group five shots inside one inch with good loads and a practiced hand. That's better than 99 out of 100 sporter-weight rifles regardless of barrel length or configuration

My Remington Model Seven in 6mm was tested with five handloads and two factory loads. Of the seven loads, only three would not group under two inches for five-shot strings at 100 yards; those three averaged around 21/4 inches. The best load in my 6mm consisted of the Hornady 75-grain hollowpoint varmint bullet and 46.0 grains of Winchester W760 powder. The average for three five-shot groups was 1.55 inches. Next best was a mild load of 36.0 grains of IMR-3031 and the Speer 80-grain softpoint. Groups ran 1.70 inches, although the velocity was low. Bumping the charge level to 39.5 grains kicked the muzzle speed up to 3060 feet per second (fps), turning it into an acceptable load for varmints.

The overall average of all the loads tried, good as well as mediocre, was a tidy 1.95 inches. No groups were dis-



			:		odel 17 Winche					
Bullet	Punda O'mek	e (Grad)	Primer	Class	Muzzles Velocity (fps)	Mezzio Energy (ft./lbe.)	Extreme Spread	Standerd Deviation	Group Average!	
Hornady 75-gr. HP	MRP	50.2	81/2-120	Fed.	3290	1800	47	20	1.96	Fastest load tested
Hornady 75 gr. HP	H380	40.0	81/4-120	Fed.	2957	1455	94	44	1.92	Mild load
Speer 85-gr. SPBT	IMR-4350	45.0	CC1 250	Fed.	3110	1822	61	24	1.34	Most accurate load tested
Sierra 100-gr. SPBT	IMR-3031	35.5	CC1 200	Fed,	2779	1715	36	14	1.76	Consistent velocity
Siarra 100-gr. SPBT	IMR-4350	42.0	CCI 250	Fed.	2837	1787	97	38	1.62	
Hornady 100-gr. SPBT	MRP	46.0	81/4-120	Fed.	2935	1912	42	17	2.21	
Hornady 100-or, SPBT	MRP	47.5	CCI 250	Fed.	2960	1945	55	24	1.59	Fine deer load; accurate
Federal 80-gr. PSP		Factor	ry Load		3200	1815	67	27 .	1.42	Very accurate
Hornady 100-gr. SPBT		Factor	ry Load		2700	1619	25	10	1.74	Accurate and consistent

NOTES. Loads were chronographed with an Delike Model 33 Chronotach(Sryscreen system).

"This is the average for two or three five shall groups, benchrest, 100, yords.

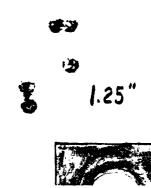
The rifle has a 22-inch barrel.

Overall average for all loads tested was 1.73 inches.

SHOOTING TIMES/FEBRUARY 1984

			المجرارة		Muzzie: Velocity	Muzzie: Energy:	Extreme	Standard	Group: Average*	
Bullet	[[yget]	(Grs.)	Primer	Ceses	(fps)	(ft./ibs.)	Spread	Deviation		Remarks
Hornady 75-gr. HP	W760	46.0	Rem. 91/2	Fed.	3200	1702	94	37	1.55	Most accurate load tested
Speer 80-gr. SP	IMR-3031	36.0	Fed. 210	Fed.	2880	1474	102	46	1.70	Second most accurate; mi
Spear 80-gr. SP	IMR-3031	39.5	CCI 200	Fed.	3060	1663	81	33	2.27	Do not increase
Sierra 85-gr. HPBT	H205	47.0	CCI 250	Rem.	. 3135	1851	62	23	2.24	Good velocity
Speer 85-gr. SP8T	IMR-4350	45.7	8%-120	Fed.	3125	1839	82	34	2.29	•
Federal 80-gr. SP		Factor	Loed		3213	1830	82	32	1.73	Most accurate factory loa
Remington 80-or. SP		Factor	Load		3320	1954	74	32	1.87	Fine varmint load; very fas





Model Seven 6mm produced this group. The load: 46.0 grains of W760, Hornady 75-grain HP, Rem. 9½ primer, Federal case.

counted due to flyers, conditions, or phase of the moon. The most accurate rifle tested had a longer barrel, but it averaged only a couple of tenths better than the Remington.

The short Model Seven will shoot.

## Inaccurate Mannlicher-Style Rifles

I saved my other shorty, the Ruger International, for this section. Certainly the stubby 18½-inch barrel didn't affect accuracy. The Ruger was as accurate as the Remington with its best load. More importantly, the wood-to-muzzle mode didn't appear to hurt it much

My first experience with a full-stocked rifle came in the mid-1970s, when I used a Harrington & Richardson Model 301 fabricated by H&R on a Sako action with a 20-inch Douglas barrel and put up in a Fajen Mannlicher stock. Chambered for the .308 Winchester, it would group five shots under 1½ inches all day with four different loads in three bullet weights from four manufacturers. Its worst performance was a 2.11-inch average with one factory load.

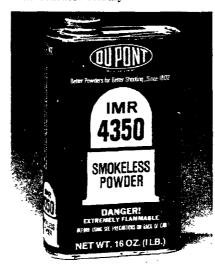
Not quite as accurate as the H&R, my test International in .250 Savage clustered three five-shot groups into 1.55 inches with the Remington 100-grain factory softpoint. Its pet handload, 40.0 grains of Hodgdon's H205 under the Speer 100-grain hollowpoint, would not group any better, but it was

155 fps faster. The runnerup handload was the same charge of H205 pushing the Nosler 100-grain solidbase (with groups running 1.75 inches).

A fine varmint load for the International was 41.5 grains of Winchester W760 and the Sierra 87-grain softpoint. Velocity was over 2900 fps, despite the abbreviated barrel, and accuracy was 1.87 inches. A real fine load.

The petite Ruger showed a 2.40-inch overall average for all loads tried (nearly 30 five-shot strings).

Inaccurate? Hardly.



IMR-4350 was the propellant author used most frequently in his testing.

#### Inaccuracy Of "Whippy" Barrels

All five test guns had thin, whippy barrels. Naturally, the longer the barrel, the more whip it has, given a basic tube profile. Following this logic, none of my long-barreled test guns should have grouped well or consistently. I miked the muzzle diameters of all five guns, and none exceeded .56 inch. If a barrel can be described as whippy, my rifles certainly met the criteria. Were they inaccurate? Not so you'd notice.

The Smith & Wesson Classic Hunter. designated the Model 1700LS, was the most accurate of the batch when best loads are considered, but only by a very small margin over the Model 70 Featherweight. The Smith favored the Speer 85-grain softpoint boattail pushed by 45.0 grains of DuPont IMR-4350 and sparked by a CCI 250 primer. Groups ran 1.34 inches, and the muzzle velocity exceeded 3100 fps. The next best handload was 47.5 grains of Norma MRP and the Hornady 100-grain softpoint boattail for a 1.59-inch average. The reliable Federal 80-grain softpoint factory load averaged 1.42 inches for three five-round strings.

The Classic Hunter's overall average from its lightweight, whippy, inaccurate barrel was only 1.73 inches. Best of the batch. I have fired a bunch of heavy, stiff, "accurate" barrels into averages much larger than this figure.

The Model 70 Featherweight was al-

SHOOTING TIMES/FEBRUARY 1984



These .25-caliber bullets were tested in Ruger M77 International.

Author uses lightweight CF rifles for varmint hunting.

This group is typical of accuracy Model 77 International is capable of producing.

Ruger Model 77 International .250-3000 Savage

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	Pione (Users)	ine (Great			Heats Vicini	Barrier Barrier Barrier		3-1-			
								A Company of the			4
Sierra 75.gr. HP	H380	40.3	Rem. 91/2Mi	Win.	3055	155 <del>5</del>	114	42	3.71	Fastest load tested	
Speer 87-gr. SP	IMR-3031	34.5	CC1 200	Win.	2812	1528	92	33	2.35		
Sierra 87-gr. SP	W760	41.5	Fed. 210	Win.	2902	1627	42	17	1.87	Very accurate and fast	
Sierra 90-gr. HPBT	IMR-4350	41.0	Fed. 210	Win.	2875	1652	44	17	2.55		
Sierra 90-gr. HPST	W760	41.4	Rem. 91/4M	Win.	2990	1787	63	23	3.29	Very high velocity	
Sierra 90-gr. HPBT	H205	42.0	CCI 200	Win.	2920	1704	19	7	2.02	Extremely consistent	
Speer 100-gr. SPBT	W760	40.0	Fed. 210	Win.	2875	1835	31	13	2.88	Very high muzzle energy	
Speer 100-gr. HP	W760	40.0	Rem. 91/2	Win.	2838	1786	29	10	3.81	Consistent velocity	
Speer 100-gr. SPBT	H205	40.0	Rem. 91/2	Rem:	2715	1639	91	38	1.96	Accurate	
Sierra 100-gr. SP	H205	40.0	Rem. 91/2	Rem.	2717	1640	70	26	1.90	Accurate:	
Space 100-gr: HP	H20 <del>5</del>	40.0	Rem. 91/2	Rem.	2745	1673	89	37	1.55	Most accurate handload	
Nosier 100-gr. S&	H205	40.0	Rem. 91/2	Rem	2733	1659	39	18	1.75	Very accurate	
Remington 100-gr. PSP		Fact	ory Load		2590	1489	65⊧	25	1.55	Extremely accurate	

most as good with its favored load, printing a tight 1.38-inch average when fed Hodgdon's H4831 in a 51.0-grain dose and plugged by the streamlined Sierra 160-grain softpoint boattail. Speeds ran 2608 fps on my Oehler Model 33 Chronotach. Bridesmaid was the same charge and powder pushing the Nosler 162-grain solidbase, with groups running 1.72 inches for the average.

Both the Remington and Federal 140grain factory loads grouped around 1% inches (five shots) which is very good. Muzzle speeds with the factory ammo were in the 2600 range. Overall average for the Featherweight was 2.21 inches.

The new BBR 7mm-08 dumped group

after group under two inches, its best going 1.63 for the average. The load: Speer 115-grain hollowpoint, 46.0 grains of IMR-4064, CCI 200, and a Remington case. (I've used the same load in my Model Seven 7mm-08, and it is also this gun's preferred load.) Muzzle speed is 3100 fps in the Browning, making it a crackerjack varmint load.

The second-place load in the BBR was 43.3 grains of Hodgdon H380 and the Nosler 140-grain Partition. It printed just under 134 inches. The overall average for the Browning was 2.33 inches.

These five rifles, waspish barrels and all, averaged 1% inches or less with their favorite loads. Two of the five

printed just over 11/2 inches, and two of them would go approximately 1% inches.

#### Short-Barrel Velocity Loss

Many sage and otherwise knowledgeable shooters think the velocity loss necessitated by abridging a rifle barrel renders the gun useless as a hunting tool. Let's examine this view and see if it will hold up.

My short-tubed Remington Model Seven clocked 3320 fps with the Remington 80-grain softpoint factory load. A Remington Model 700 Varmint Special I tested averaged 3346 fps from the 80-grain Power-Lokt. I realize this is a

## Winchester Model 70 Featherweight 7x57 Mauser

	Powde	278.275 278.275 278.275			Muzzier Velocity	Muzzie: Energy	Extreme	Standard	Group Average*	
A Printer Land	Typel	(Gra.)	Primer	Chang	(Det	(ft. Ma.		Deviation	(Inches)	Remarks:
Hornady 139-gr. SPBT	MR-4320	45.0	Rem. 9½	Rem.	2920	2631	39	15	2.29	Best deer/antelope load
Nasier 140-gr. SB	MR-4064	41.8	Rem. 91/2	Rem.	2705	2274	52	18	3.31	
Speer 145-gr. HPBT-M.	H414	48.4	CCI 200	Win.	2795	2515	27	11	2.86	Excellent velocity
Sierra 150-gr. HPBT-M	IMR-4350	46.0	Rem. 91/2	Rem.	2595	2243	61	23	2.10	
Nosler 150-gr. Partition	H4831	52.3	Rem. 91/2	Rem.	2677	2386	55	22	2.98	Good velocity
Sierra 160-gr. SPBT	H4831	51.0	CCI 200	Win.	2608	2416	65	24	1.38	Most accurate load tested
Nasier 162-gr. SB	H4831	51.0	CCI 200	Win.	2510	2266	61	21	1.72	Accurate
Remington 140-gr. PSP		Factory	Load		2595	2093	68	27	1.65	Very accurate
Federal 140-gr. PSP		Factor	Load		2613	2122	63	22	1.62	Most accurate factory load

NIO ESC County renew common graphies, write an Unitine Model, 32 Chromatach Sicyacrem system
"This is, the auguste for two, to four five shot groups, benchrost, 100 yards."

The rifle has a 22 inch barrel. Overall group average for all leads tested was 2.21 inches.

different load fired in a different gun, but consider this: my Model Seven is only 26 fps slower with a load comparable to one fired in a gun sporting a barrel 5½ inches longer!

In a Savage Model 111 .250-3000 with a 22-inch barrel, I clocked 40.0 grains of H205 under the Nosler 100-grain solidbase at 3010 fps. The same load (different lots of components, of course) chronographed 2733 fps in my Ruger International. This represents a loss of 79 fps per inch of barrel. Forty grains of Winchester W760 pushes the Speer 100-grain softpoint boattail to 2875 fps in the International. The same charge behind a Sierra 100-grain softpoint yields 3020 in a 22-inch Ruger Model 77. That figures the loss per inch

to 41 fps. An old batch of Winchester 87-grain softpoints reaches only 2830 fps in the 22-inch Ruger; the identical load (from the same box) clocks 2712 in the International for a 34 foot-per-second/per-inch deficit.

While these numbers aren't exactly insignificant, they certainly aren't alarming. In a rifle to be used primarily for whitetail or black bear hunting, walking after varmints, or scaling precipitous peaks in search of sheep or goats, I'll gladly trade 35 to 50 fps of velocity per inch of barrel for the added convenience (less weight).

And how much trajectory disadvantage will you be acquiring? Well, a Nosler 140-grain Partition starting at 2800 fps shows a 23.1-inch drop at 400 yards

from a 200-yard zero. The same bullet drops 27.3 inches when kicked off at 2600 fps. This is only 4.2 inches more drop at 400 yards! Disastrous? No way.

#### **Short Tubes And Fast Powders**

If you must have a short barrel, the savants say, handload it with a fast powder and retain as much of that elusive velocity as possible. Unfortunately, this advice is incorrect. Despite the fact you do realize a more serious velocity loss with a slow propellant than a faster one, the slow burner still provides higher muzzle speeds.

I eased up to maximum in my Model Seven 6mm, starting below and moving up slowly and cautiously with IMR-3031. My top load was 39.5 grains be-

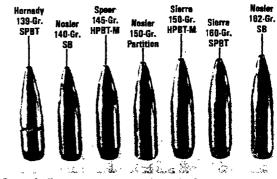
## Fastest load in 7x57 Featherweight utilized 45.0 grains of IMR-4320.

/60 SIERRA SPBT 51.0 /H 4831 CCI 200 WIN CASE

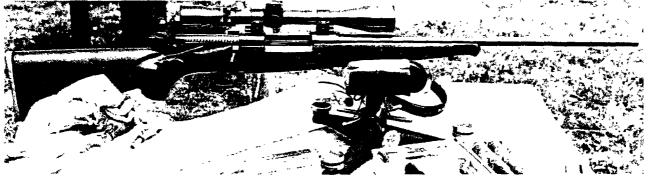


Featherweight turned in this group.





Seven bullets were employed in 7x57 Featherweight loads.



Chambered for the 7x57 Mauser, the Winchester Model 70 Featherweight averaged 1.38 inches with its best deer/antelope load.

SHOOTING TIMES/FEBRUARY 1984

			7	Brow 7mm-0	ning E 8 Remi					
	Penn			Name of the second	Muzzie Valacity	Muzzie Energy (ft./lbs.)	Extreme Seconds	Standard	Groups Accornage	
Speer 115-gr. HP	IMR-4064	46.0	CCI 200	Rem.	( <b>fps)</b> 3100	2448	34	15	1.63	Most accurate load; fast
Nosier 120-gr. SB Nosier 120-gr. SB	1 <b>MR</b> -4064 H380	44.0 46.2	CC1 200 Rem. 9½M	Rem. Rem.	2964 2820	2340 2119	45 43	18 18	1.91 1.89	Okay for varmints
Sierra 140-gr. SPBT	IMR-4064	42.0	CC1 200	Rem.	2739	2331	73	30	3.31	
Nosler 140-gr. Partition Nosler 140-gr. Partition	1MR-4064 H380	42.0 43.3	CCI 200 Rem. 9½M	Rem. Rem.	2735 2580	2325 2069	78 52	28 20	1.98 1.73	Second most accurate load
Nosier 140-gr. Partition Nosier 140-gr. Partition	W760 W760	47.0 47.0	Fed. 215 Fed. 215	Rem. Rem.	2783 2809	2408 2452	31 59	12 25	1.79 3.19	LOA 2.80; accurate LOA 2.75; note differences
Sierra 170-gr. RN	IMR-4350	42.0	CCI 200	Rem.	2335	2058	93	38	3.29	
Sierra 170-gr. RN Remington 140-gr. PSP	IMR-4831	45.6 Fact	CCI 200 ory Load	Rem.	2453 2807	2273 2449	35 62	13 24	2.03 2.8 <del>9</del>	Fine heavy-game load

NOTES: Loads were chimnographed with air Genker Model 33. Chronotech/Skyacraen systems. The rife hase 22 lasts barrel.

This is the average for two five-shot groups, benchrost, 180 years. Overall, group septage for all basis tested west 2.32 inches.



hind the Speer 80-grain softpoint. The velocity? A mediocre 3060 fps. The factory-loaded Remington 80-grainer, which uses a powder much slower than 3031, clocked 3320 fps, a full 260 fps more. Burning the slow Hodgdon H205 under the Sierra 85-grain hollowpoint boattail produced 3135 fps, 75 fps higher than the 3031 load and with a bullet five grains heavier.

In the limited-capacity .250-3000, where the quicker propellants look better due to the small case size, a top load of 3031 was 34.5 grains when coupled with the Sierra 87-grain softpoint. Velocity was 2812. Loading the same bul-

let over 41.5 grains of slow-burning Winchester W760 produced 2902 fps.

The moral of all these figures? If you want high muzzle speeds in cartridges of compatible capacity, use medium/slow to slow-burning powders. Save the quicker propellants for other purposes.

#### Advantage Of The Fast Burners

Quicker propellants like IMR-3031 and either DuPont or Hodgdon 4895 do have an advantage over the slower stuff for use in a lightweight: they kick less. There are two reasons. First, velocities are not up to those produced by the slower propellants with bullets of

the same weight loaded to top pressures; lower velocity yields lower recoil energy, all else being equal. Secondly, from a recoil standpoint, the less powder you use the better.

If you take a rifle and load it to a given velocity and pressure with a certain bullet using two powders of different burning rates, the faster propellant will always yield less felt recoil. When figuring the recoil energy of a load, part of the mathematical formula includes the "weight of ejecta." The "ejecta" includes everything coming out of the barrel, including the powder charge. The heavier the charge, the heavier the ejecta. In addition, the powder charge is multiplied by 1.75 to give it greater significance due to the phenomenon known as the "jet effect." This "jet effect" is what happens when the bullet, upon exiting the muzzle, is passed by the hot powder gases it had been preceding down the bore. The gases accelerate so violently the effect is exactly like that of a jet engine and causes the gun to come back into your shoulder with more authority.

So there is a viable use for the faster powders after all, particularly in a lightweight rifle, where recoil is more noticeable.



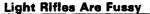
#### Reduced-Load Accuracy

One other "truism" I explored briefly during my firing tests was this old bromide: many propellants do not perform well at reduced levels, most specifically the ball types. I'm not speaking of loads reduced to the level of small-game application but loads about 10 percent below the maximum working level to make shooting easier on barrel steel and the shooter's shoulder.

The second most accurate load in the Model Seven 6mm utilized such a load

(36.0/IMR-3031 Speer 80-grain combination). The load was accurate, pleasant to shoot, and relatively quiet; I wouldn't hesitate to use it as a 200-yard chuck or crow load.

In the Smith & Wesson .243, I tried 40.0 grains of Hodgdon H380, which is a spherical propellant. Hodgdon's manual goes to 43.0 grains with this bullet; the Speer book goes to 44.0 grains with its bullet of the same weight. The Smith grouped it into 1.92 inches. A very pleasant and accurate load, this one would also make a nice 200-yard varmint load.



One overlooked facet of lightweight rifles is worthy of mention. They are fussy. They respond well to some loads and poorly to others. Only the Smith & Wesson was atypical, shooting nearly everything well. The Smith was not an especially light rifle as .243s go, however, so don't let it cloud your objectivity.

The Model Seven did not shoot drastically large groups, but it did display a distinct preference for certain recipes. Note the 2.29-inch average with the Speer 85-grain boattail, a bullet it didn't seem to like.

The Ruger .250-3000 was a classic case. With the load it favored least, this rifle averaged nearly four inches. Another group went 3.71. Its favored loads cut those group averages by more than

half! The Browning was another example. It shot into 1.63 inches with its choice load and 3.31 with its least suitable. Two other loads grouped well over three inches.

Even the Featherweight, which was the heaviest gun of the clutch (despite its extremely slender barrel contour), was fussy, stoutly refusing to shoot well with any handload using a bullet weighing less than 160 grains. I doubt whether its extremely fast twist of 1:8½ inches was the reason. It shot well with both of the 140-grain factory loads while refusing to group less than 2.06 inches with any of the three heavy-bullet factory loads tried.

In closing, let me separate the grain from the chaff. When loading for light rifles, choose a fairly fast powder only if you wish to reduce recoil or barrel wear. If you want optimum ballistics from your short tube, forget the fast burners and load the same slow propellants you would choose for a long-barreled rifle.

Don't worry about the accuracy of your short, light, whippy little rifle. If the bedding is okay, it will shoot just fine. You might have to work a tad harder at finding a pet handload, but that's part of the charm. It's worth not lugging a heavyweight around in the deer woods.

NOTE: All load data should be used with caution. Always start with reduced loads first and make sure they are safe in each of your guns before proceeding to the highest loads listed. Since Shooting Times has no control over your choice of components, guns, or actual loadings, neither Shooting Times nor the various firearms and components manufacturers assume any responsibility for the use of this data.



Lightweights are built for field work.

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			Dow	nrang	ge Ba	llistics	Of To	op Lo	ads					
								C 7.9 C 4	-	116		Bree	A Section	
Bolice (Californ		T.	20E		400.	Messie	100		300.			(inches)		Perpens
Hornady 75-gr. HP (.243)	3300	2960	2639	2342	2069	1814	1459	1160	914	713	+1.3	man constitute as a		Varmints
Speer 85-gr. SPBT (.243)	3100	2854	2622	2400	2190	1813	1537	1297	1087	905	+1.4	- 6.5	-19.0	Varmints, antelope
Sierra 85-gr. HPBT (.243)	3100	279 <del>5</del>	2475	2178	1901	1813	1474	1156	895	682	+1.5	- 7.2	-21.7	Varmints
Hornady 100-gr. SPBT (.243)	2950	2710	2480	2266	2064	1934	1631	1367	1141	947	+1.7	- 7.4	-21.7	Deer, antelope
Sierra 87-gr, SP (.257)	2900	2582	2277	1993	1727	1624	1288	1001	767	576	+1.9	- 8.6	-26.0	Varmints, antelope
Sierra 90-gr, HPBT (.257)	3000	2640	2286	1960	1638	1798	1393	1044	768	536	+1.8	- 8.5	-26.0	Varmints
Speer 100-gr. HP (.257)	2800	2438	2103	1797	1525	1741	1320	982	717	516	+2.2	-10.1	-31.1	Varmints .
Speer 115-gr. HP (.284)	3100	2727	2384	2066	1774	2453	1899	1451	1090	804	+1.6	- 7.8	-23.7	Varmints
Nosler 140 gr. Partition (.284)	2800	2586	2383	2192	2011	2438	2079	1766	1494	1258	+1.8	<b>→</b> 7.9	-23.1	Medium big game
Speer 145-gr. HPBT (.284)	2800	2615	2438	2267	2103	2524	2201	1914	1654	1424	+1.8	- 7.7	-22.1	Target, silhouette
Sierra 160-gr. SPBT (.284)	2600	2432	2271	2116	1987	2401	2102	1832	1590	1374	+2.2	- 8.9	-25.6	Big game
Sierra 170-gr. RN (.284)	2450	2173	1915	1691	NŁ	2267	1783	1385	1079	NL	+2.9	-12.5	NL	Big game in timber
NOTES Valuations were rounded to the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back of the back									NE.	Nor tiste			12.	

### **BARBER - PRESALE R 0129241**

REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE

Remington.

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stribution: C.B. Workman

C.E. Ritchie J.W. Brooks R.S. Murphy

File

"CONFINE YOUR LETTER TO ONE SUBJECT ONLY"

Prepared by: ____S.R. FRANZ

Date Prepared: 11/30/83

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Foreman - Test, Measurement Lab

Signature Mughlyals 12-283

C.E. Ritchie, Sr. Supervisor Testing, Measurement & Mech. Analysis Lab

Signature kitchia

Date

#### TEST & MEASUREMENT LAB REPORT

REPORT NUMBER: 832691

REPORT TITLE: PROTOTYPE ALUMINUM FLOOR PLATE SENSITIVITY ANALYSIS

MODEL(S): MODEL SEVEN LWT

GAUGE OR CALIBER: .308

DATE: 11/30/83

WORK ORDER NO.: C-1856-000

PART NAME: FLOOR PLATE ASSEMBLY

DESIGNER/ENGINEER: J.W. BROOKS/D.E. BULLIS

#### TEST TYPE:

⊥•	PHOTO LAB
2.	STRENGTH TEST-NO. OF GUNS TESTED
3.	FUNCTION TEST-NO. OF GUNS TESTED 10
4.	ACCURACY TEST-NO. OF GUNS TESTED Acceleration, Coverage, Opening
5.	MEASUREMENTS - TYPE Force, Screw Torque, Headspace
6.	ENVIRONMENTAL TEST COLD
7.	AMMUNITION TESTING & EVALUATION-TYPE
8.	VISUAL EVALUATIONOUT OFGUN SAMPLE
9.	ENDURANCE-NO. OF GUNS TESTED: 2
	NO. OF ROUNDS PER GUN 2,000
	TOTAL ROUNDS FIRED IN TEST 4,000
	AMMO TYPE: MAGSTARGET:
	RIM FIRECENTERFIRE .308
	180 gr.

#### **BARBER - PRESALE R 0129243**

REMINGTON ARMS CO., INC. Firearms Research Division

Report No. 832691 Page 1

November 30, 1983

TO:

R. NIGHTINGALE

FROM:

S.R. FRANZ

REPORT TITLE:

MODEL SEVEN LWT PROTOTYPE ALUMINUM FLOOR PLATE SENSITIVITY ANALYSIS

#### ABSTRACT

A previous sensitivity analysis on the steel floor plate assembly showed that this design was sensitive to a number of variables and dimensions. In order to assure no floor plate openings with this design it would require 100% inspection of all floor plate assembly parts; a very costly and time consuming process. Because of this a new aluminum floor plate assembly was designed that would be cheaper to make and be less sensitive to manufacturing tolerances. (See Appendix for the Floor Plate Assembly Parts List) Prototypes were made and initial testing confirmed that the design was better from a functional standpoint. Production reviewed this design and recommended that some changes be made to allow for their manufacturing process. These design changes were made and 10 prototypes were built and assembled on .308 cal. actions. The Test and Measurement Lab received a work request from D.E. Bullis, Current Firearms Design, to run a sensitivity analysis on these prototype rifles.

#### SCOPE OF TEST

To determine the sensitivity of the new aluminum floor plate assembly to floor plate openings during live fire.

#### TEST RESULTS

Testing has proven that the new aluminum floor plate assembly is not as sensitive to floor plate openings as the steel assembly. The Report Text section contains a detailed explanation of the tests that were run as well as their results. Testing did show, however, that a condition exists that could adversely effect the functioning and appearance of the rifle. This condition is discussed below.

Report No. 832691 Page 2

TEST RESULTS - Contd.

Initial observations showed that the front trigger guard screw on all 10 rifles interfered with the floor plate when the loor plate was closed. This interference caused the floor plate look out. Not only does this detract from the appearance out it also increases the load on the floor plate late could also increase the sensitivity of the floor plate openings because of this additional loss. J.W. Brooks and D.E. Bullis were made aware of this condition so that corrective action could be taken. After this condition was found were filed down to eliminate this interference.

Although this testing has proven that the aluminum assembly is a good design we must remember that these were prototype parts machined in the Research N/C area and the Model Shop, not vendor parts handled by production. As soon as vendor parts are received mother sensitivity analysis similar to this one will be run to increase our confidence level before production begins with this assembly.

Report No. 832691 Page 3

#### REPORT TEXT

A total of ten newly designed aluminum floor plate assemblies were tested for sensitivity to floor plate openings. Sensitivity to the following parameters were considered:

- Part Wear (endurance)
   Guard Screw Torque
   Fit to Stock (washers)
- 4. Latch Coverage
- 5. Opening Force
- 6. Lubrication
- 7. Temperature (cold)

In addition, measurements, high speed movies and accelerometer measurements were taken to compare the aluminum to the steel assembly. An explanation of each test and the results follow.

Note: See last page in Appendix for prototype Floor Plate Assembly Parts List.

Report No. 832691 Page 4

#### TEST PROCEDURE

#### A. Measurements

Before any testing was done some preliminary measurements were taken on all the rifles. A listing of the measurements made and the range of values measured are listed below. (See Appendix for the complete data listing).

Opening Force: 2.25 --- 3.50 lbs.
Latch Coverage: 0.065 -- 0.085
Headspace; min + .004 -- min. +.005 in.
Screw Torque: pre-set at 25 lb-in
Stock to Floor Plate Cover Gap: 0.008--0.031 in.

#### B. Initial Shooting

After initial measurements all ten rifles had five rounds of Rem. 180 gr. .308 cal. ammo shot through them in the Test Lab jacks.

#### C. Field Cycle Test

After the initial jack shooting all ten rifles were brought up to the Ilion Fish and Game Club for a full field function test. Each rifle was shot a total of 150 rds. of Rem. and Competitive ammo.

#### D. Measurements

The initial measurements were repeated after the Field Test to determine if any changes had occurred. A summary of the results are listed below. (See Appendix for complete data listing.)

Opening Force 2.25 -- 3.25 lbs.

Latch Coverage 0.064 -- 0.084

Headspace: min + .004 -- min. + .005 in.

Screw Torque: front 10 -- 25 lb. - in.

Rear 20 -- 25 lb - in.

Stock to Floor Plate Cover Gap 0.010 -- 0.031 in.

This data shows that the assembly screws did loosen slightly and that the front screw loosened more than the rear. This is explained under the Screw Torque Test.

Report No. 832691 Page 5

#### TEST PROCEDURE - Contd.

E. Part Wear (endurance), High Speed Movies, Accelerometer Measurements

Two rifles were selected from the ten guns supplied for endurance testing. The rifles selected were:

Ser. No. 7603854 Ser. No. 7603221

Both of these rifles were shot 2000 rds. each using Rem. 180 gr. .308 cal. ammo. The floor plates on both rifles were opened and closed every 20 rounds throughout this test. Rifle No. 7603854 had high speed movies taken both before and after endurance. High speeds were taken to determine if the aluminum assembly moves during live firing and to determine if this movement increases as rounds are put on the rifle.

No rifle experienced liker that the during shooting. In addition, the high speed movies indicated that the assembly does move slightly downward (out of stock) but that it is considerably less that the steel assembly. There was also no noticeable increase in this movement in the second high speed taken after the 2000 rounds were fired. No floor plate latch movement was detected in either of the high speeds. This indicates that the slight movement of the floor plate housing is not enough to initiate latch movement during live firing. (These high speed movies are available for viewing in the Research Photo Lab.)

Accelerometer measurements were also made to confirm the movement of the floor plate assembly in the stock during live shooting. These measurements were taken with a PCB miniature accelerometer, Model No. 303A02, powered by a PCB power supply, Model No. 482A04. The accelerometer was mounted on the bottom of the floor plate housing to measure vertical acceleration. Similar measurements were also made on a rifle with a steel assembly for comparison. These measurements showed that the aluminum assembly had one-half of the downward acceleration of the steel assembly. This can be seen in the two graphs in the Appendix. These graphs show the Power Spectrum of the acceleration curves in the range of 0-2000 HZ taken with a WaveTek/Rockland Model 5830A Spectrum Analyzer. The graph for the steel assembly shows that the resonant frequency of the floor plate base is 335 HZ and the peak acceleration is 348 g's at this frequency. The second graph shows that the aluminum assembly resonates at approximately the same frequency but the acceleration is approximately half that of the steel assembly.

Report No. 832691 Page 6

TEST PROCEDURE - Contd.

#### F. Guard Screw Torque

The eight remaining rifles were used for this test. Screw Torque was set at seven different values and 20 rds. of Rem. 180 gr. ammo was fired per setting. After every 20 rds. screw torque was checked to determine if the screws had loosened up.

mis seems to contradict an earlier condition where the screws loosened after the field cycle test when they were pre-set at 25 lb-in. The difference between the two is that 150 rds. were fired on the field test and only 20 at the individual settings for this test. It should be stated here that the two endurance guns were fired 2000 rds. each without re-tightening the screws and no floor plate openings occurred. Although it seems that floor plate openings are not sensitive to screw torque,

#### G. Fit to Stock (Washers)

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Production has stated that they cannot control the inletting depth for the floor plate assembly in the stock. This is true for all M/700 and Model Seven Lwt Calibers. To compensate for this lack of control they purposely inlet too deep and use spacers between the stock and the floor plate assembly to ensure a good looking fit to the stock. Using spacers in this way changes the interaction between the floor plate assembly and stock because support to the assembly is decreased. This test was designed to determine if this effects the performance of the floor plate assembly. Eight rifles were tested with no spacers and four spacers between the floor plate assembly and the stock. Each spacer was 0.015 in. thick. Twenty rds. of Rem. 180 gr. .308 cal. ammo was fired per condition and no floor plate openings occurred.

#### H. Latch Coverage

Initial measurements showed that latch coverage for this ten rifle sample was in a range of 0.065 to 0.085 in.

Latch coverage was decreased in four steps by filing away the floor plate edge on five rifles until each rifle had 0.005 in. coverage. At each increment 20 rds. of Rem. 180 gr. .308 Cal. ammo was fired. No floor plate openings occurred at any of the latch coverage increments. See data in Appendix.

Report No. 832691 Page 7

#### TEST PROCEDURE - Contd.

#### I. Opening Force

The same five rifles used for the latch coverage test were used here. Two conditions were tested. 20 rounds of Rem. 180 gr. .308 cal. ammo was shot with the floor plate latch springs at full length and then reshot with the springs cut to 3/4 length. The latch spring could not be cut any shorter than this and still exert a force on the floor plate latch. We considered that a 3/4 length spring would be the worst possible condition that could occur with this design and still allow proper functioning. Latch opening forces were measured for the full length and 3/4 length springs with the cover opened and closed for comparison. These numbers can be seen in the Appendix. No floor plate openings occurred on any of the five rifles with the full or 3/4 length spring. To go one step farther two of the five rifles had their latch springs completely removed and 20 rounds of ammo was shot through each. In this way the only force on the floor plate latch was the force due to the floor plate cover and friction. One rifle opened 1 out of 20 rds. and the other opened 2 out of 20 rds.

#### J. Lubrication

All firearms should be cleaned and oiled periodically to ensure proper functioning. However the frequency and extent of cleaning depends on the individual. This lubrication test was designed to test the extremes of lubrication on the rifle in the floor plate and latch area. The two conditions tested were with no lubrication at all on the assembly (dry) and with the assembly saturated with Du Pont Teflon wet lubrication. Two Model Seven's were selected for this testing. In addition three competitor's rifles were also tested for controls. These rifles were: Win. M/70 in. .30-06 cal. Browning BBR in .30-06 cal. S&W M/1500 in .30-06 cal.

20 rds. of Rem. 180 gr. .308 cal. ammo was fired per condition in the Model Seven's and Rem. 180 gr. 30-06 cal. ammo was fired in the competitor's rifles. None of the rifles, Model Seven's or competitor's, experienced any malfunctions during this test. Latch opening forces were measured with and without lubrication on all the rifles tested. These measurements show little if any difference in opening forces between the two conditions. This data can be found in the Appendix.

Report No. 832691 Page 8

TEST PROCEDURE - Contd.

#### K. <u>Temperature</u> (Cold)

Firearms are used in all types of climates and temperature extremes. They, therefore, have to operate properly in these conditions. The cold test determines if firearms will operate properly in extremely low temperatures. The same two Model Seven's used in the lubrication test along with the three competitors listed above were stored overnight in the lab's freezer at -30 Deg. F. The following day they were removed and floor plate latch opening forces were measured. Following these measurements 20 rounds of ammo was shot through each rifle. After shooting latch opening forces were measured again. No floor plate openings occurred on any of the rifles. See Appendix for opening force data.

## M/ 7 SENS. ANAL.

## TESTING SEQUENCE

- o MEASUREMENTS
- o FIELD TEST ALL 10
- o MEASUREMENTS
- o PICK TWO FOR ENDURANCE
- o H.S. ONE ENDUR. GUN
- o ENDUR. 2 TO 2000 RDS.
- o H.S. AFTER ENDURANCE
- o GUARD SCREW TORQUE TEST
- o FIT TO STOCK (WASHERS)
- o OPENING FORCE
- o LATCH COVERAGE
- o 2 GUNS FOR:

TEMPERATURE TEST LUBRICATION TEST

#### APPENDIX

- o Measurements
  o Field Cycle Sheets
  o Endurance Sheets
  o Acceleration Data
  o Screw Torque Data
  o Fit to Stock Data

- o Latch Coverage Data
  o Opening Force Data
  o Lubrication Data
  o Cold Test Data
  o Floor Plate Assembly Parts List

#### BEFORE TEST-0 RDS

GUN NUMBER	OPENING FORCE (16)	COVERAGE	WOOD/COVER GAP (in)	HEADSPACE MIN+	SCREW TORG. FRONT.REAR
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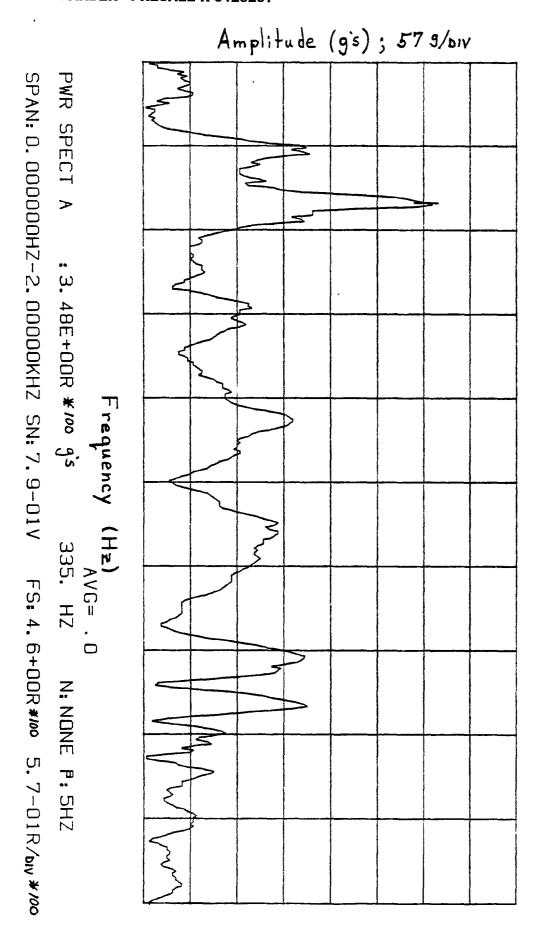
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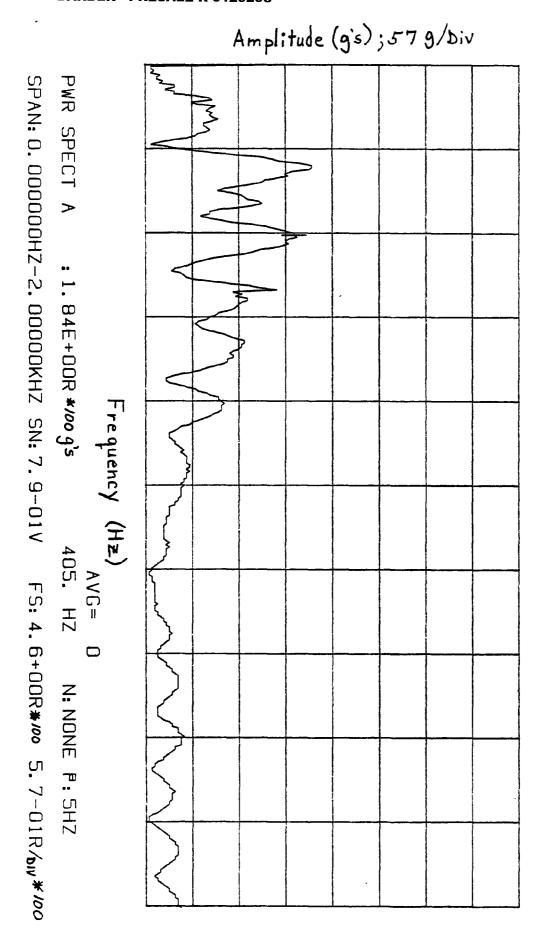
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# SCREW TORQUE TEST

erial NO	l in-1b	5 in-lb	10 in-1b	15 in-1b	20 in-lb	25 in-1b	30 in-1b
4086	0K	<b>o</b> K	OK	OK	۵K	OK	OK
4091	0K	OK	OK	ŪK	OK	OK	DK
3907	OK	OK	OK	OK	OK	OK	OK
3187	0K	OΚ	OK	OK	OΚ	OΚ	OK ·
4201	0K	OK	OK	0K	OK	٥K	OK
4244	OK	ūΚ	ΩK	ΰĸ	ΟK	ΩK	0K
3910	0K	OK	0K	OK	0K	OK	0K
3821	0K	OΚ	ΟK	OK	OK	OK	OK

20 rounds were fired per condition.

## FIT TO STOCK (WASHERS)

SERIAL NO 4086 4091 3907 3187 4201 4244	0K 0K 0K 0K 0K	4 SPACERS (.060")
3910	0K	OK
3821	0K	OK

20 rls fired per condition.

## LATCH COVERAGE TEST

SERIAL NO	4086	4091	3907	3187	4244
COVERAGE	.075-0K .065-0K .055-0K .045-0K .035-0K .025-0K .015-0K	.050-0K .030-0K .010-0K .005-0K	.050-DK .030-DK .010-DK .005-DK	.060-0K .040-0K .020-0K .010-0K .005-0K	.055-OK .035-OK .015-OK .005-OK

20 rounds fired per condition.

# OPENING FORCE TEST

SERIAL NO 4244 3187 3907 4091 4086	3/4 LENGTH OK OK OK OK OK	FULL LENGTH  OK OK OK OK OK OK OK	rds fired condition
	OPENING FORCES		
SERIAL NO	3/4 LENGTH OPEN CLOSED	FULL LENGTH OPEN CLOSED	
4244 3187 3907	.75 1.25 .75 1.25 .75 1.75	1.25 2 1.25 1.75 1.5 2.25	
4091 4086	.75 1.75 .75 2.75 .75 1.75	1.5 3 1.25 3	

### LUBRICATION TEST

MODEL	SERIAL NO.	LUE FIRING	RICATION OPENING FORCE
REM M/7 REM M/7 WINCHESTER M/70 BROWNING BBR S&W 1500	7603910 7603821 G1486933A 01185RP117 PN00862	0K 0K 0K 0K 0K	2.25 2.50 6.00 4.00 5.25
			JBRICATION
REM M/7	7603910	FIRING OK	OPENING FORCE 2.25
REM M/7	7603821 G1486933A	ÖK OK	3.50 6.75
WINCHESTER M/70 BROWNING BBR	01185RP117	ŌΚ	4.00
S&W 1500	PN00862	OK	5.25

20 rds fired per condition

### COLD TEST (-30 F)

MODEL	SERIAL NO.	FIRING	BEFORE FIRING OPENING FORCE
REM M/7 REM M/7 WINCHESTER M/70 BROWNING BBR S&W 1500	7603910 7603821 G1486933A 01185RP117 PN00862	OK OK OK OK	2.25 3.25 4.00 3.75 4.00
REM M/7 REM M/7 WINCHESTER M/70 BROWNING BBR S&W 1500	7603910 7603821 G1486933A 01185RP117 PN00862		AFTER FIRING OPENING FORCE 2.25 3.25 5.00 4.00 5.00

20 rds fired per condition

Prototype Aluminum
Floor Plate Assembly
Parts List

-92909 TRICK	ER Guard	92909	92909
	ASSEMBLY	92822	92822
B-92848   Floor	Plate Latch	92848	92848
- Floor	Plate Latch Blank	92885	92885
A-92B47 Floor	Plate Latch Spring	92847	92847
A-92846 Floor	Plate Latch Pin	92846	92846
D-92889	Sub-Assembly	92889	92889
A-16453 Flo	or Plate Pivot Pin	16453	16453
D-92839 Flo	r Plate Cover	92839	92839
D-92838 F	loorPlate Cover Blank	92838	92838
D-92837 Tri	ger Guard	92837	92837
D-92836 T	igger Guard Blank	92836	92836
B-92849 Front G	uard Screw Spacer	92849	92849
	Guard Screw Spacer Blank 929		92883
B-92850 Rear Gu	ard Screw Spacer	92850	92850
Rear	Guard Screw Spacer Blank	92884	92884

Report No. 832691

#### RESEARCH TEST & MEASUREMENT LAB WORK REQUEST

	- AREA OF TEETING	
Developmental	AREA OF TESTING	
· · · · · · · · · · · · · · · · · · ·	Safety Related	Litigation stion Werenouse Audit
Design Acceptance .	New Design	Cost Reduction
Pre-Pilot		
Prior	Design Change	Stake
Production Acceptance	Plant Assistance	Other
FIREARM STAT'S.	REPORT REQ'D.	,26,
MODEL: 7 LINT	FORMAL V	DATE REQUESTED: 9/26/83
CAL or GAGE: 308		DATE NEEDED BY:
BARREL TYPE: CARRINE	TEST RESULTS	REQUESTED BY: D. BULLIS
PROOFED: YESNO	ONLY	WORK ORDER NO: C-1856-600
TEST TYPE		
TEST TYPE  Strength Test Ammunition Test Dry Cycle Test Photo/Video		
Strength Test Ammuniti	•	
Function Test Environme		· · · · · · · · · · · · · · · · · · ·
Accuracy Test Customer Complaint Endurance Test		
EXPLAIN IN DETAIL THE REASON FOR THIS TEST:		
SENSITIVITY TEST: HERVY LOAD		
1. AMOUNT OF LATCH ENGAGEMENT 5 QUNS		
2-LETTE ZOLCASO POLICE		
3. TRIL GUARD ADJUSTED IN SEACEDS to CONTR LOCK NOT TOWN WOOD, Town miching		
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5. 16. MOULES OF MAX. RECOIL. HEROT LACK.		
2 Course Scot BUT per 1811.		
R. Environment Test: Coid & Hot		
2 9. Endurance life of parts & effect on operation		
to Enterest Assembly		
-GUNS REQUIRED:		
-11. Corrosion		
T=.5+ 1/6	,	•
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NOTE: NO firearms or parts will be tested in		DATE COMPLETED:
accompanied by a Work Request, ar	<b>!</b>	TEST COMPLETED BY:
the Labs by the designer or engineer. All Work Requests are		REPORT DATE:
to be filled out in detail. No Exceptions.		
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