

Remington Arms Technical Center

**Project Name:** 504 Target  
**Project Number:** 241426  
**R&D Engineer(s):** Will B James, Vince Norton

**Revised:** 3/11/05  
**Marketing Manager:** John Trull  
**Plant Contact:** Kevin Lance

**Status:**

- DAT 2 accuracy for 10, 504 T-22LR was 0.475" average at 50 yards.
- The 504-T 22LR was dropped (tested) with and without pillar stocks. Pillared stocks passed drop with current process trigger weight of 3 to 5lbs. Engagement was checked to make sure it was within the process specification of .022 to 0.29". The 504 -T22LR with non-pillar stocks failed the rotation test with trigger weight set at 3lbs. The 504T HB 22LR passed drop testing after lubricating the firecontrol and changing the trigger pull to 3.25Lbs. The 504T 17HMR will be drop on the March 14<sup>th</sup> with trigger pull set at 3.25lbs.
- New HB 17HMR barrels for DAT 2 were received on 2/11/05 from Mayfield. The accuracy for the test group was 3" average with new barrels. An evaluation was conducted and a number of tool marks found in bore. Free bore was measured at 0.5". Free bore specification is a little more than 1/8<sup>th</sup> of an inch. Mayfield will investigate process, etc.
- Completed shooting both 17HMR and 17M2 Universal receivers. Complete on 2/15/05. 17HMR averaged 0.607" the 17M2 averaged 0.8" with Eley ammunition.
- Mayfield to build T&P for 504T22LR HB's. Shipped to Etown on 3/30/05.
- Mayfield to supply R&D with new barrels for 17HMR HB's on 3/18/05.

**Issues:**

1. 600+ 504T 22LR stocks without pillars in Mayfield. 600+ 504T17HMR without pillars currently in Mayfield. Stocks cannot be modified to accept pillars because of narrow wood margin around the front takedown screw. Stock inletting was modified to accept pillar. Additional wood margin was added around the front takedown screw.

**Action Items:**

Action Item	Status	Responsible	Date
1. UR Test 17HMR & 17M2	Complete	R&D	2/16/05
2. Shoot 504T 17HMR accuracy DAT 2	Complete	R&D	3/1/05
3. Shoot 504T 22LR accuracy DAT 2	Complete	R&D	3/3/05
4. Drop test 504T 22LR With and with pillar bedding	Complete	R&D	3/11/05
5. Drop test 504T 22LR With and with pillar bedding	Complete	R&D	3/14/05
6. T&P build for 504T 22LR	In process	Mayfield	3/30/05
7. New barrels for 17HMR accuracy test (DAT 3)	In Process	Mayfield	3/18/05
7. T&P build for 504T 17HMR	After DAT	Mayfield	TBD

**Schedule / Key Milestones:**

Milestone	Current Date
EET	6/30/04
DAT 504LR	3/11/05
DAT 504 17HMR	3/25/05
T&P 504T 22LR	4/20/05
T&P 504T 17HMR	5/20/05
Warehouse Position	TBD

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Subject to Protective Order - Williams v. Remington

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