

**CONFIDENTIAL**

Remington Arms Company Inc.  
RESEARCH & DEVELOPMENT TECHNICAL CENTER  
315 WEST RING ROAD  
ELIZABETHTOWN, KY 42701

**TLW 1005**Method:

- Graduated headspace gauges will be used and the headspace measurements will be recorded to the nearest .001" increment as indicated by the gauge. The 12-gauge chamber for the Model 1100 CM will be found on drawing D-240355 and will be used for referenced chamber dimensions. (Note that: If graduated headspace gauges are not available then, as a minimum, use Min/Max headspace gauges to assure that the shotguns are at least within headspace specifications.)
- The headspace measurements will be recorded to the nearest .001" increment as indicated by the gauge.
- If the measurement is taken at the start of the test then headspace should be less than or equal to Min. + .007" (note that some of the M/1100 shotguns received from production were in excess of this specification and are noted on other documentation.)
- As the test progresses, headspace will be taken as designated by any specific test in the plan and in addition, at each scheduled "Safety Inspection" as well as at each "Clean & Inspect" activity scheduled by the test plan.
- The headspace readings for each firearm at each inspection will be recorded on the "Daily Test Data Sheet" to be kept with each firearm in the accompanying data packet.
- For any firearms where the headspace appears to be increasing at each inspection point the firearm will be withdrawn from test and examined for the probable cause.
- In no case will any shotgun in the test program be allowed to continue in the test if the headspace exceeds Min. + .013"

Data Required:

- Shotgun serial number
- Headspace measurements for each sample
- Testers' Names
- TLW Number

**TLW1005C -Proof Test:**

As a safety precaution the Proof Test procedure will be completed before test lab personnel can use the firearm for any additional firing tests.

All test sample firearms will be subjected to a standard 12-gauge Definitive Proof load shot in the blow-up room using lanyards. Because of the higher pressures involved in shooting proof cartridges, adequate precautions, both mechanical and procedural, must be taken to protect personnel performing the firearms proof testing. To this end, the firearm should be securely mounted, completely shielded from the operator and firing accomplished by a remote control method such as loading the chamber and firing by use of lanyards.

Any firearms components, such as bolts, bolt heads, receivers including chambers, etc. which were previously subjected to proof testing and, which subsequently, have any proof sensitive components changed, altered, or substituted, should be re-proofed.

Method:

- Record headspace before proof testing *per previous procedure "TLW1005B Measure Headspace."*
- Before proof testing the firearm should be inspected for:
  - Barrel Obstructions
  - Bore and chamber are free of grease or oil and other debris.
- After firing the proof round, the firearm will be carefully examined to determine if any damage to the product has occurred due to exposure to the proof pressure
- This inspection includes:
  - Visual inspection for damage.
  - Damaged receiver, locking block or bolt.
  - Bulged chamber or bore; split, cracked or otherwise damaged barrel, with special attention to the locking notch in the barrel extension.
  - Broken stock.
  - Any other part subjected to the proofing stress, which can be visually examined for damage.
  - Any "suspicious" areas should be submitted to magna-flux inspection before proceeding.
- The fired proof round should be examined to determine that no firearm fault has introduced round failure, such as:
  - Expanded case head.
  - Excessive roughness, rings, or bulging, which would affect extraction.

J.R. Snedeker

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Subject to Protective Order - Williams v. Remington

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