

Remington.

300 WIN MAG BARRELS

DAT TEST

Gary Riley March 12, 2003

Project Summary

Thirty drilled barrels and thirty barrel blanks were sent to E-town on 1/16/03 for heat treat. Thirty barrel blanks were also sent to Ilion 2/28/03 for heat treat. The 60 barrels from the E-town supplier were received on 3/5/03. The testing began on the drilled blanks 3/6/03. Using existing tooling the barrels were reamed and rifled. The heat treated drilled blanks would not rifle to size using our existing tooling. The tooling that is needed to produce the heat treated barrels to print specification has been ordered.

Planned Activity

•DRILLED BARREL BLANK TEST

-Existing Tooling

•30 Drilled Barrels From E-town Heat Treater

- Drill, Ream, Rifle,

3/6/2003

-New Tooling

•30 Barrels Blanks From E-town Heat Treater

4/25/2003

- Drill, Ream, Rifle, Stress Relieve
- Turn, Chamber, Crown
- Heat Treat Hub End, Magnaflux

•BARREL BLANK TEST (solid heat treated stock)

-New Tooling

•30 Barrels From E-town Heat Treater

4/25/2003

- Drill, Ream, Rifle, Stress Relieve
- Turn, Chamber, Crown
- Heat Treat Hub End, Magnaflux

•30 Barrels Ilion

4/25/2003

- Drill, Ream, Rifle, Stress Relieve
- Turn, Chamber, Crown
- Heat Treat Hub End, Magnaflux

•Submit DAT Barrels to E-town

4/30/2003

Projected Outcome

The projected outcome of these test are to establish a process to produce M710 magnum barrels out of heat-treated blanks or heat-treated drilled blanks. If unable to produce a stable process from the heat-treated blanks, forged blanks will be tested from Ilion. Information as to what can be provided from Ilion is being collected in the coming weeks.

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