

Revised 10/20/47

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Model 513-S

RD-61-6

NEW METHOD

Job Method: Study No. 227-1

Part Name Rifle, Bolt Action, Box Mag. Part No. Sporter

Date 10/20/47

Insp. Oper. no. First No. of Inspectors 1

Gauge No.	Gauge Type	% of Insp.	Dimension Inspected	Key Points	Safety & Details
	Safety		Chamber, Magazine & Receiver	No ammunition Rifle empty	Follower visible
			All dummy cartridges used in inspection	Must conform to description	In current safety bulletin
	Stamps		Assembly		
	Specifications		Sporter Grade		Barrel top center ahead of front
				"Matchmaster Model 513S"	Barrel top center back of front
				"Remington"	Barrel top left
				"22 Long Rifle"	Barrel top left, front of receiver
				Bolt Handle	Large & grooved
				Serial Number	Bottom of barrel
				For export rifles & other grades	See supplemental detail
Remove	Mag. & Stock		Release magazine lock	With gun pointed down 45°	Magazine must fall out
		%	Loosen take down scr.	Remove stock	No bind
	Finish & Fit		Metal Parts	Color uniform	No red or gray browning
				No seams	Mars or scratches slight

NOTE: All items listed to be 100% inspected except where marked "%" in which case one gun from each side of each truck to be inspected.

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Model 513-B

RD-6L6

NEW METHOD

Job Methods Study No. 227-1

Part Name Rifle, Bolt Action, Box Mag. Part No. Sporter

Date 10/20/47

Insp. Oper. No. First No. of Inspectors 1

Gauge No.	Gauge Type	% of Insp.	Dimension Inspected	Key Points	Safety & Details
	Finish & Fit (Cont)		Muzzle crown	Flat, no jams	At edge of bore
				Double countersink	Outside chamfered
				Colored	Accept 1/16" light ring around bore
			Barrel	Tight in receiver	Twist to test
				Rifling present	
			Barrel & Receiver	Shoulder joint opening	Max .005 HOGG at top right on 45°
		%	Barrel Pins	Tight, no heavy burrs	Hand punch test
			Red safe points (2)	Under Safe & on indicator	At rear of bolt sleeve with gun cocked
	Sights		Front Sight	Ramp screws tight	Wear slight
			Rear Sight	Screws tight	Tension on bottom notch of stop
	Screws	%	Safety Screw	Tight	Screwdriver test
		%	Ejector Screw	"	" "
		%	Sear Screw (rear)	Receiver staked into screw slot	By assembler
		%	Magazine lock screws	Tight	Screwdriver test
		%	Trigger cushion spring screw (center)	"	" "
		%	Magazine adjusting screw (each end)	Visual Only	Not Stripped

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Gauge No.	Gauge Type	% of Insp.	Dimension Inspected	Key points	Safety & Details
	Stock		Visual	No bad checks or mutilations	Minor repairs at final inspection
					Checkered
		%	Inside finish	Colored	Not rough
			Trigger guard	Tight	If loose, test for stripped screws
		%	Escutcheon	Tight	Pull on take down screw to test
	Fit	%	Reassemble stock	No bind	On action
			Fit along barrel & receiver	uniform	Bolt handle clears recess
		%	Turn take down screw	Lead in easily	With receiver against recoil shoulder
		%		Tighten with special screwdriver	Screw marks slight
			Hold at fore-arm & receiver rear	Compress alternately at ends	No rock
			Trigger	Not hang outside	of guard bow
			Pull trigger	Remove bolt	Must clear stock
	Bolt			Marks or burrs	Slight
			Bolt sleeve	Not cracked	At pin holes
			Bolt sleeve pin	Not project either end	Not short
				Tight	Hand punch test

Cam pin

Not project either side

Good bearing both sides

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Gauge No.	Gauge Type (cont)	% of Insp.	Dimension Inspected	Key Points	Safety & Details
			Bolt handle	Tight in cocking cam	
			Extractor pins	Not project, top or bottom	Tight, hand punch test
			Extractors Right	Square under claw	Bottom of claw rounded
			Left	Bevel under claw	" " " "
			Both chamfered	Lead angles top & bottom	For barrel slots
			Operate	Free, tension	No bind or grate
			Release firing pin	Pretrusion	Flush or below bolt face
			Bolt lug (bottom front)	Rounded	Front end .06 radius
			Start bolt in receiver	Cock cam	Rear end .03 radius
					Pull trigger to insert
Heading & chamber					
AL-591	Plug	100	Head Space MIN	Insert in chamber	Clearance match extractors
				Bolt should close	Accept if slightly snug
AL-592	Plug	100	Head Space MAX	Insert in chamber	Clearance match extractors
				Bolt should NOT close	Accept if very snug
510-509	Plug	100	Diameter of Chamber	MIN GO to notch on gage	To detect burrs at mouth of chamber
	Magazine		Follower free	Depress full stroke & release slowly	Retracts

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RD-6146

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Gauge No.	Gauge Type	# of Insp.	Dimension Inspected	Key points	Safety & Details
	<u>Magazine (cont.)</u>		<u>Load 2 Long Rifle dummy cartridges</u>	<u>Into magazine</u>	<u>Magazine assemble easily</u>
			<u>Magazine locks into position</u>	<u>Push down to test</u>	<u>Vertical play slight</u>
	<u>Function</u>		<u>Operate action</u>	<u>Normally</u>	<u>Eject properly</u> <u>No missed feeds</u>
				<u>Lead not shaved</u>	<u>From bullets</u>
	<u>Action</u>		<u>Bolt operates free</u>	<u>Cocks easily</u>	<u>No bind or drag</u>
				<u>Extractors enter barrel slots</u>	<u>No bind</u>
				<u>Rear face of barrel</u>	<u>No firing pin marks</u>
			<u>Bolt handle not catch</u>	<u>At front of handle slot</u>	<u>When opening bolt</u>
<u>Close Bolt</u>			<u>Safe Manual type</u>	<u>Safe not move</u>	<u>When bolt opens</u>
			<u>ON(to rear)</u>	<u>Covers red spot</u>	<u>Pull trigger, Must NOT fire</u>
			<u>Operate</u>	<u>Free, tension</u>	<u>Leave ON</u>
				<u>Accept with no trigger play</u>	<u>If safe goes ON with no bind</u>
			<u>OFF(forward)</u>	<u>Pull trigger, must fire</u>	<u>Safe not go ON (test with one finger)</u>

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