NUMBER A-15411

**REMINGTON ARMS CO. INC.**
RESEARCH & DEV. DEPT

SCALE | SUPERSEDES PREFERENCE

TITLE SPRING

DES. BY DATE | DRN. BY DATE HL 12/6/61 | CHK BY DATE | APP BY DATE

FOR DETAILS SEE PROCESS RECORD

| MODEL | PART USE | QUAN. | SEE |
|---|---|---|---|
| 600 | MAIN SPRING | 1 | |
| 600 | MAIN SPRING | 1 | |
| 660 | MAINSPRING | | |
| 600 | MAIN SPRING | 1 | |
| 7LWT | " | " | |

DO NOT SCALE THIS DRAWING WORK TO FIGURES
UNLESS OTHERWISE NOTED, TOLERANCES
ON DECIMAL DIMENSIONS ARE ±.005
& ON FRACTIONAL DIMENSIONS ± 1/64
& ON ANGULAR DIMENSIONS ±00°-30'
FINISHES ARE DESIGNATED BY ROOT MEAN SQUARE (R.M.S.) MICRO-INCH ROUGHNESS VALUES AND ARE THE MAXIMUM ROUGHNESS ACCEPTABLE. UNLESS OTHERWISE SPECIFIED, FINISH ROUGHNESS TO BE 125 OR BETTER.

Music Wire
Stress Relieve

12/19/61

THIS DRAWING OR INFORMATION IS PROPRIETARY INFORMATION TO THE REMINGTON ARMS COMPANY, INC.

INSPECTION
1. To work freely in .420 dia. hole AT Working Length .605
2. To work freely on .263 dia. pin
3. Load 27.2 to 30.0 lb. at .605 length (with set removed)
4. Solid Height .443 max. 7. Wind RIGHT H
5. Free Length 3.63 min. 8. Remove set (Yes) (No (except for inspection
6. Ends SQUARE & GRIND
* Approximate length limits to nearest 64th inch at constant load in lbs. and nearest 1/4 oz. Load 28 lbs. 10 ozs. at 2 2 to 2 2 in. length

MANUFACTURE
9. Wire dia. .055 11. Free Length 3.85 WITH SET SQUARED
10. Outside dia. .405 12. Coils 24 Active 20 Total

DESIGN DATA
13. Rate 2.7 lb./in. 16. Spring Index 6.4
14. Solid Stress 75,000 lb./sq.in. 17. Torsional Mod. G= 11.5×10⁶ lb./sq.in.
15. Solid Load 30.7 lb. 18. Concentric Corr. .085

This Spring must meet the requirements in the "Inspection" section. Fi[illegible] given in the "Manufacture" section indicat[illegible] the gu[illegible]ed Spring, but th[illegible] Manufacturer may deviate fr[illegible] s[illegible] at his own discretion. Values in [illegible] "Design Data" section are [illegible] in the "Manufacture" section.

| ALT. | WAS | REFERENCE | BY | DATE |
|---|---|---|---|---|
| 4 | ADD USE 7LWT | 11667 | CB | 5/2/62 |
| 3 | ADD MOHAWK USE 600 | 8442 | RCE | 9-10-62 |
| 2 | ADD USE 660 | 4259 | GP | 12/5/62 |
| 1 | [illegible] | 9509 | [illegible] | 2-7-63 |

ALTERATIONS

TFA-3 REV 1

R2522550

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON