

REMINGTON ARMS CO. INC.			
RESEARCH & DEV. DEPT.			
SCALE		SUPERSEDES REFERENCE	
TITLE SPRING			
DES. BY DATE	DRN. BY DATE	CHK. BY DATE	APP. BY DATE
	10/25/61		11/12/62
FOR DETAILS, SEE PROCESS RECORD			
MODEL	PART USE	QUAN.	SEE
	FOR BACK SPRING	1	
	FOR CURTAIN WEIGHT SPRING	1	

DO NOT SCALE THIS DRAWING: WORK TO FIGURES
UNLESS OTHERWISE NOTED. TOLERANCES
ON DECIMAL DIMENSIONS ARE $\pm .005$
ON FRACTIONAL DIMENSIONS $\pm \frac{1}{64}$
ON ANGULAR DIMENSIONS $\pm 00^{\circ}30'$
FINISHES ARE DESIGNATED BY ROOT MEAN
SQUARE (R.M.S.) MICRO-INCH ROUGHNESS
VALUES AND ARE THE MAXIMUM ROUGH-
NESS ACCEPTABLE. UNLESS OTHERWISE
SPECIFIED, FINISH ROUGHNESS TO BE
125 OR BETTER.

RECOMMENDED MATERIAL AND HEAT TREAT

MATERIAL M4.2. Wire
HEAT TREAT Stress Relieve
HARDNESS
COLOR

① ATTENT AND COLOR TO BE DONE BY REMINGTON

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

INSPECTION

- To work freely in dia. hole
 - To work freely on .104 dia. pin
 - *Load 1.82 to 2.31 lb. at .450 length (with set removed)
 - Solid Height .246 max. 7. Wind R H
 - Free Length .650 min. 8. Remove set No (except for inspection)
 - Ends SQUARE & GRIND BOTH ENDS
- * Approximate length limits to nearest 64th inch at constant load in lb.
and nearest 1/4 oz. Load 2 lbs. 1.6 oz. at 1/16 to 1/32 in. length

MANUFACTURE

- Wire dia. .020
- Free Length .650
- Outside dia. .150
- Coils 10 Active 12 Total

DESIGN DATA

- Rate 19.5 lb./in.
- Spring Index 6.5
- Solid Stress 123,400 lb/sq. in.
- Torsional Mod. G = 11,540,000 lb/sq. in.
- Solid Load 2.530 lb.
- Concentric Corr. 1.077

This Spring must meet the requirements in the "Inspection" section. Figures given in the "Manufacture" section indicate the preferred Spring, but the Manufacturer may deviate from these at his own discretion. Figures in the "Design Data" section are based on those in the "Manufacture" section.

3	ADD USE	11273	XP	11-6-80
2	XP-700	8563	E	12-29-70
1	REMOVED	DEB	2	2-9-62
ALT.	WAS	REFERENCE	BY	DATE

ALTERATIONS

A-15456