MODEL 725

Specifications

cc: J.D. Mitchell
F.E. Morgan
G.M. Calhoun
P.H. Burdett
D.E. Miller
V.G. DeReus } In
H.J. Hackman } Turn

Ilion, New York
February 5, 1957

W. H. FOSTER, JR.
BRIDGEPORT

Supplementing our letter of January 29, 1957, you have called our attention to specifications as submitted to J.D. Mitchell by Dan Carroll in letter dated September 20, 1956. This contemplates the building of match rifles in four different calibers --- 30-06, 300 Magnum, 308 Win. and 222 Rem.. It also contemplates major changes being made to the receiver, fire control and magazine group in order to increase the magazine capacity, and also relocate the trigger, etc..

This involves a considerable amount of work; however, could of course be accomplished if considered justified, and will probably necessitate outside assistance both in model making and development. Without resorting to a detail estimate it would be expected that to build one each of the four different calibers to these proposed specifications would cost approximately $10,000 utilizing "gunsmithing" methods. To provide design and drawings for purpose of reproducing future models would involve an estimated additional $5,000.

S. M. Alvis, Manager
Ilion Research Division

SMA:T

DON'T SAY IT—WRITE IT

TO Sam Collins.

DATE 2/4/57

FROM Dan Carroll.

Here is an extra copy of the Sept 20, 1956 letter containing specifications for several versions of the C.F Match Rifle.

Many of these specs are common to the 725 or vice versa

"BE YOUR BROTHER'S KEEPER, STOP ACCIDENTS"

select a barrel length for the 30-06 rifle to bring it within this weight limit. In the interest of tooling the barrel, diameters could be kept constant. This would also help in front sight selection to keep down to a single type.

Stock: A modification of the Model 40X stock would be necessary to deepen the magazine for a clip of five 30-06 cartridges. The 40X stock as is would be ideal for the 300 Mag. - 308 Win. - 222 Rem. unless we include the 308 Win. in the Match Rifle category. There is only a remote possibility that the 308 Win. may be included in future National Matches, as the present rule states the "30-06 without modifications," and the High Power Rules Committee is not at present disposed to change that rule and Russ Warye, of the N.R.A. and a member of that committee, told me he would continue to oppose a rule change to permit the 308 to be used, and that it had been proposed several times.

Trigger Group: If we deepen the stock for a five cartridge magazine, then we must also lengthen the trigger housing and trigger to bring it to the correct depth in the trigger guard. The housing has to be lengthened so that the bolt release will be flush with the trigger plate. The finger piece of the trigger should be 5/16" further forward than its present location, as most shooters' fingers penetrate through the guard to a greater depth than needed. This would improve trigger control and apparent pull variations such as we have heard of on the Model 40X.

C O P Y

cc: Dewey Godfrey
Gail Evans
F. E. Morgan
S. M. Alvis
A. A. Riehl

Bridgeport, Conn.
September 20, 1956

TO: J. D. MITCHELL

FROM: DAN CARROLL

SUBJECT: CENTER FIRE MATCH RIFLE
RAPID FIRE - LONG RANGE - BENCH REST - VARMINT

The following specifications are for rifles in the above category. What may be insufficient volume in one type would be augmented by the addition of rifles from the other groups. The term "Match Rifle" is descriptive of the 30-06 N.R.A. 10-1/2 lb. "Match Rifle" and in this text will be used for that purpose only.

Caliber: 30-06 - 300 Mag. - 308 Win. - 222 Rem.

Barrel: .90" muzzle, 1.250" breech, 24" - 26" - 28" - 30" long. As there is a weight limitation of 10-1/2 lbs. with sights, swivels and butt plate, it may be necessary to select a barrel length for the 30-06 rifle to bring it within this weight limit. In the interest of tooling the barrel, diameters could be kept constant. This would also help in front sight selection to keep down to a single type.

Stock: A modification of the Model 40X stock would be necessary to deepen the magazine for a clip of five 30-06 cartridges. The 40X stock as is would be ideal for the 300 Mag. - 308 Win. - 222 Rem. unless we include the 308 Win. in the Match Rifle category. There is only a remote possibility that the 308 Win. may be included in future National Matches, as the present rule states the "30-06 without modifications," and the High Power Rules Committee is not at present disposed to change that rule and Russ Warye, of the N.R.A. and a member of that committee, told me he would continue to oppose a rule change to permit the 308 to be used, and that it had been proposed several times.

Trigger Group: If we deepen the stock for a five cartridge magazine, then we must also lengthen the trigger housing and trigger to bring it to the correct depth in the trigger guard. The housing has to be lengthened so that the bolt release will be flush with the trigger plate. The finger piece of the trigger should be 5/16" further forward than its present location, as most shooters' fingers penetrate through the guard to a greater depth than needed. This would improve trigger control and apparent pull variations such as we have heard of on the Model 40X.

J. D. Mitchell September 20, 1956

Trigger Guard: Whether or not we should have a removable floor plate on the Match Rifle is a moot point. But if we do, then it should be of the Mauser pattern button release. The Model 70 has a reputation for springing open from recoil during rapid fire. A removable floor plate could also be fitted to our ADL-BDL grade rifles as a sales feature. Aluminum could be used for the guard assembly. All this for the purpose of preventing having to skimp on barrel weight and length, as that is the best place to distribute the weight and reduce recoil, maintain center of impact, rapid heating of barrel.

Receiver Group: Cut clip slots. These may be best if cut off center to the right for best clip loading. See some Mauser rifles. The Model 70 is not ideal in this respect. The bolt handle may need to be lengthened for better leverage in rapid fire and to enable a better wrap around of the fingers. Bolt knob should be drilled to remove weight. Also, bolt handle may be better if repositioned to reduce notching of stock (hence weakening at a vital point.) This could be emphasized as an engineering and sales feature.

For the long range 30-06 and 300 H&H, the 308 Win. and 222 Rem. we should definitely make the receiver without a magazine cut-out. Reasons being for stiffness of assembly and ability of rifle to maintain constant center of impact from the first shot to the last when shot free floating as is the present custom or with the use of the bedding screws in operation.

At Camp Perry I heard that the recoil lug of the Model 721 would rotate after some use and that it would bend from recoil of the 300 Mag. This I can hardly believe, as the recoil lug bears on the wood of the stock and it does not seem possible that steel of this thickness could bend without destroying the stock.

The Model 70 bolt stop is a weak point of that design and is similar to our 721. Will our 721 bolt stop batter and break down from the violence of forceful bolt operation during rapid fire? The metal is thinner in our design than the Model 70. Plenty of field testing should bring out any weakness of this part, either in design or material.

The safety lock could be omitted on the long range, bench rest and 40X rifle. The stock would benefit by less wood removal.

Rear scope block screw hole spacing should be standard and not as we have done on the Model 40X. The 40X should be changed to agree with standard spacing. This can only be done on single shot type actions as the clip slot cut-out will not permit the longer spacing.

J. D. Mitchell September 20, 1956

Sights: Front - Redfield International Military or International Small Bore as second choice. Both sights are lightweight alloy and attach to scope type bases screwed to barrel and are interchangeable.

Rear - Redfield International or second choice Olympic. Both of these sights are heavy and may require some lightening cuts to remove weight. All this to keep the overall weight down to the required 10-1/2 lbs. with sights and without sling.

While on the subject of sights, it is known that the Lyman Company is designing "Match Rifle" sights.

As a final word, these rifles must be the very best that can be made, as they will be used by some very articulate cranks who can make this venture an excellent one for us or slow it down to a walk. The September 1956 issue of "Precision Shooting," Page 5, bottom of center column, gives our 721-722 actions and trigger excellent praise and we should captialize on the bench rest shooters' endorsement of our rifle.

Dan Carroll
Shooting Promotion Section

DC/1

C O P Y

cc: Dewey Godfrey
Gail Evans
F. E. Morgan
S. M. Alvis
A. A. Riehl

Bridgeport, Conn.
September 20, 1956

TO: J. D. MITCHELL

FROM: DAN CARROLL

SUBJECT: SPECIFICATIONS FOR CENTER FIRE "N.R.A. MATCH RIFLE"

"N.R.A. Match Rifle" Weight - mandatory 10-1/2 lbs., caliber 30-06 with swivels, sights, but without sling or scope blocks.

Barrel - 24" or 26" long, .900" muzzle, 1.250" breech. The 1.250" section should be about 1-1/4" long before starting to taper toward the muzzle. Caliber 30-06.

Chambering- Should be as close as permissible, as near bench rest practice as we can get them, particularly in the long range, bench rest and varmint rifles.

Action - Bolt handle may need lengthening and repositioning to a high location on the bolt body. Bolt knob drilled to remove weight, if needed. Perhaps some sweep back may be good. If bolt handle is relocated, then telescope sight tube interference should be kept in mind. Clip slots cut for rapid fire clip loading, and if needed to improve ease of loading, they should be located slightly to the right of center, like some Mauser rifles.

Stock - Modification of Model 40X. Change to consist of deepening stock to provide for a 5-shot magazine. Field tests are a must to decide if stock lines (drop, pitch, comb height) are satisfactory, but for first trial the Model 40X stock should be tried as is. "Group tightener" should be fitted.

Magazine Box - Lengthened for 5-shot capacity.

Trigger Group - The trigger housing and trigger will have to be lengthened if the stock is deepened. The trigger face should be 5/16" forward. Removable floor plate should be provided for unloading without working cartridge through action. This is a must, because if the command to unload is given for some safety hazard on the range, then the rifle must be cleared safely.

J. D. Mitchell September 20, 1956

Guard Lengthened to fit deeper stock.
Screws -

Sights - Front: Redfield International Military. This is a light-weight alloy material.

Rear: Redfield International. (Lyman is designing a new "Match Rifle" sight.

Scope blocks should be fitted unless we are pressed to meet the weight limitation.

Dan Carroll
Shooting Promotion Section

DC/1

C O P Y

cc: Dewey Godfrey
Gail Ivans
F. E. Morgan
S. M. Alvis
A. A. Riehl

Bridgeport, Conn.
September 20, 1956

TO: J. D. MITCHELL

FROM: DAN CARROLL

SUBJECT: SPECIFICATIONS FOR LONG RANGE - BENCH REST - VARMINT RIFLE

Barrel - 28" or 30" long. .90" muzzle, 1.250" breech. No weight limitation in this category.

Caliber - 222 Rem. - 30-06 - 300 Mag.

Chambering- Must be as close to bench rest standards as is possible in a rifle that should chamber commercial ammunition.

Action - Solid, without a cut-out for a magazine. No rifle in the above category has any need for a magazine. The action and stock assembly will benefit by increased stiffness and the rifle will group better and hold its zero. (Very important for long range matches where no sighting shots are allowed.)

The rear receiver bridge shall be left full width like the Model 40X and the scope block screw holes should be of standard spacing. This should be corrected on our Model 40X to permit interchange of scope blocks.

Stock - Could use Model 40X stock as is or the "Match Rifle" stock with "group tightener."

Trigger Group - The Model 40X trigger and trigger housing could be used as is in the Model 40X stock. The trigger face should be hung 5/16" forward of the present type.

Sights - Front: Redfield International Military or Olympic Alloy or steel models.

Rear: Redfield International or Olympic. Scope blocks should be fitted.

Dan Carroll
Shooting Promotion Section

DC/1

cc: G.M. Calhoun
J.D. Mitchell
W.H. Foster, Jr.
F.E. Morgan
D.E. Miller
H.J. Hackman - V.G.DeReus
J.W. Miller
~~W.E. Leek~~ - File

Ilion, New York
January 30, 1957

DAN CARROLL
BRIDGEPORT

MODEL 725 DESIGN

In reviewing status of this job am reminded that the limiting factor as to length of time required to have this model available after approval of final design is the development of tooling for those component parts to be made from powder metals. Some of these may require as much as 9 months before we might anticipate having a quantity of parts available.

Among those for which design is presently held up and incorporating the recent changes for which you arranged, are the Safety Thumb Piece and the Magazine Release Button.

Would therefore suggest that everything possible be done to get this information, including the model which you have, back to the designers so that they in turn can furnish adequate drawings for the tool designers to proceed with their work.

SMA:T

S. M. Alvis, Manager
Ilion Research Division

cc: H.A.Brown
F.E.Morgan
W.H.Foster
H.J.Hackman
F.H.Burdett
S.M.Alvis
A.A.Riehl

Bridgeport, Connecticut
January 9, 1957

TO: DAN CARROLL

FROM: J. D. MITCHELL

SUBJECT: PROPOSED MODEL 725 RIFLE

Confirming action of the Operations Committee, Firearms, on January 8, you are instructed to go to Ilion to coordinate and cooperate with the Design Group on the preparation of a Model 725 exhibit in calibers 30/06 and 308 that will incorporate correction of the points listed below.

1. Trigger Bow still too small.
2. "A" grade wood.
3. Checkering pattern to be established.
4. Fore-end tip too thin vertically, make like Model 70.
5. Safety thumb-piece loose, must be more positive.
6. Floor plate release too hard to open.
7. Aluminum floor plate instead of steel.
8. Fit grip cap.
9. Closer grip to prevent fingers from touching cheek.
10. Closer comb point to prevent thumb from bumping nose.
11. Top of left panel of stock to be lowered to allow fitting of Lyman and Redfield sights without notching stock.

After completion of these changes, the two exhibits are to be returned for viewing by Bridgeport Sales Department.

JDM/mvj

Bridgeport, Connecticut
September 18, 1956

TO: GAIL EVANS

FROM: J. D. MITCHELL

SUBJECT: SPECIFICATIONS - PROPOSED MODEL 725
BOLT ACTION CENTER FIRE RIFLE

The following quotation is taken from Special Staff Meeting Minutes, September 7, 1956:

"The proposed new Model 725 center fire bolt action rifle, designed to meet competition, was shown for approval. After considerable discussion of its features and characteristics, the Sales Department was requested to consider the features and saleability of the design promptly and report its recommendation as to specifications as soon as possible. N. F. Larsen was asked to prepare the cost and earnings estimate on the model presented based upon sale of 15,000 a year at a retail price of $129.95 each, including the price and volume required to obtain satisfactory operative earnings and return on investment."

Sales Department recommendations for Model 725 specifications are as follows:

ACTION

Bolt action same as Model 721 except new positive type thumb safety with S & F marked on rear of receiver for safe and fire positions. No loose wobble or excessive play in either position, easy open steel magazine floor plate, and "swept back" bolt handle. Bolt body bright. Protruding rear end of bolt black. Sand blasted and "matt" receiver.

September 18, 1956

CALIBERS	721-22	725	
300 H & H		1050	
30-06 Springfield	5500	3950	
280 Remington			
270 Winchester	2900	2050	
308 Winchester	2000	850	4500
257 Roberts	1800	1800	2850
244 Remington	2500	1850	7100
222 Remington	5800	3950	4350
	20 000	15000	7250

BARRELS

22" length for 30-06, 280 Remington, 270 Winchester, 308 Winchester, 257 Roberts

~~26"~~ length for 222 Remington, 244 Remington and 300 H & H

STOCK

1/4" longer than sample submitted from trigger to butt plate, with Monte Carlo, comb cuts, hand checkering or semi-machine checkering comparable to Model 70, sling swivels and scroll decorated grip cap. Butt plate to be approximately 1/16" thicker than sample, inlet at heel with overall quality similar to Model 70. Alter fore-end length and fore-end taper to be similar to Model 70. Overall stock length approximately same as Model 70 with Model 721 receiver. B grade wood.

SIGHTS

Front sight same as sample submitted with ramp and flat gold bead, plus hood similar to Model 70.

Rear sight. Marble or Lyman adjustable folding leaf rear sight on Remington aperture sight line base. Receiver to be drilled and tapped same as Model 721 for telescope and receiver sights.

WEIGHT

Approximately 7 pounds.

OTHER SPECIFICATIONS

Accuracy, packing, proof testing, wood and metal finishes to follow current Model 721 except as noted.

JDM/bmh

Thelma
Please file WL
Wayne

cc: N.F. Larsen
H.A. Brown
J.B. Maupin
J.D Mitchell
E.B. Wallin

Ilion, New York
September 14, 1955

G. M. CALHOUN

PROPOSED SPECIFICATIONS FOR MODEL 725

Attached hereto is a copy of proposed specifications for a new model high power bolt action rifle. The Sales Department has requested that this model be designated as Model 725 and be offered in seven calibers, which means all calibers presently supplied in the M/721-722 with exception of 300 Savage. Sales has also proposed that the same model designation be used for all calibers although approximately half would involve the M/721 style of long receiver, with remainder being M/722 style short receiver.

I have prepared these specifications on basis of notes from our discussion with J.D. Mitchell and W.H. Foster on Wednesday, September 7. At the Operations Committee Meeting on the following day this item was incorporated into the proposed Arms Development Schedule on basis of being "Under Investigation" and also contemplating a proposed retail selling price of approximately $120.00, and with a tentative forecast of from 7,000 to 10,000 "additional" rifles. The Models 721 and 722 would be retained in the line except that the AC and BDL Grades would be dropped.

It was decided that as a first step, sufficient information be furnished to N.F. Larsen for purpose of making an evaluation of the indicated economics. In this connection, I have found from a review of our files that essentially all of these items have been considered before although in different combinations. Therefore, it was possible to "extract" practically all of the details for an estimate summary for use in an economic evaluation.

Also attached hereto is a copy of the estimated cost for tooling as well as indicated unit factory cost which would be over and above the present factory cost for the M/721. It will be noted by Mr. Larsen that only in several cases was it possible for us to indicate the "additional capital" required; therefore, he may have to develop this information for us, and perhaps E.B. Wallin can help.

This estimate indicates an estimated total cost for tooling in amount of $136,290, of which approximately 10% would be charged to operations. The additional estimated total factory cost would amount to $5.82 per gun. In addition to the total indicated

tooling cost above, it is estimated that approximately $25,000 will be required for development in the categories of design, product engineering, pilot operations, production aids, etc., as shown in the detail. No attempt has been made to estimate additional working capital involved since this obviously would be affected by the forecasted schedule. However, believe that data available from the economic evaluation estimate for M/721 improvements dated December 22, 1953 might well be used as basis for a determination. I have reviewed this briefly with Messrs. J.B. Maupin and E.B. Wallin and it was agreed in order to proceed with distribution of these specifications along with our own estimate. This will then be reviewed by Messrs. Larsen, and Wallin, who perhaps by telephone can clear up any questions.

It also should be pointed out that the tooling estimate and product cost is based on the development of a machine for checkering which would involve approximately $100,000 on basis of an evaluation submitted to W.L. Clay by J.B. Maupin dated November 4 and November 11, 1953. If it were decided to consider on basis of hand checkering, the estimated appropriation might be reduced accordingly. However, the factory cost would have to be increased by approximately $5.00 greater than for machine checkering.

It should also be noted that the estimate has been based on the purchase of a Marble folding leaf rear sight instead of designing and tooling up for another. Should the latter course be followed it would then be necessary to increase the appropriation and investment, and there would probably be a reduction in additional unit factory cost of approximately $2.00.

We suggest that Mr. Larsen proceed to make an evaluation on basis of this estimate and if the results appear favorable then further work might be done on which to base a check estimate. There is some doubt in our minds that the proposed improvement in the form of a new model will gain the additional volume which is indicated. Undoubtedly, it would do so for at least the first year. However, at the same time, it will probably gain as much additional volume as would for the introduction of some other new bolt action high power rifle. In other words, with the present competition of more popular autoloading and slide action rifles today, it is doubtful that we could ever justify complete new development of another high power center fire bolt action rifle unless supported by some entirely new and novel designs and processes, either having significant effect on cost or design features. This may therefore be a rather economic

way to obtain a new model. We would also question the wisdom of coming out with so many different calibers before it has been possible to determine the acceptance. By restricting the first year to only one or two of the most popular calibers it would be possible to avoid the large additional working capital together with increased inventory of finished guns.

S. M. Alvis, Manager
Ilion Research Division

SMA:T

PROPOSED SPECIFICATIONS
FOR
MODEL 725 - NEW HIGH POWER BOLT ACTION RIFLE

9-8-55

Calibers: 30-06; 300 Mag., 270; 222 Remington; 308 Winchester; 244 Remington; 257 Roberts.

Action: A modification of the present M/721 as relates to stock, accessories, barrel and finish. The shorter receiver would be used for Cal. 308, 244, 257 and 222 without change to model designation, i.e. all to be called "Model 725".

Barrel:

Length: 22" for Cal. 30-06, 270, 308 and 257.
24" for Cal. 300 Mag., 244 and 222.

Barrel Lug Under Rear Sight: Not required, Subject to design considerations.

Finish: Same as M/721.

Receiver: Same as for M/721-722 except Matte Finish, Similar to Winchester M/70.

Sights:

Front Ramp style with "hood"
Consider use of special plastic bead or blade as feature.
Provision for windage adjustment desirable but not mandatory if covered with rear sight.
(Design Consideration: Problem of sight line to accommodate both high comb and regular stock.)

Rear New Design - Consider use of present M/740-760, modified to eliminate objectionable semi-buckhorn notch.
Alternate: To reduce costs of tooling consider Marble "Folding Leaf" as a purchase part.
Design Problem: Providing two different heights for high and low comb stocks.

Stock: New - Using same general grip dimensions, length, etc. which has been well accepted for the M/721. If necessary, revise length of the fore end for the shorter barrels. Also inletting for any change in barrel profile.

New Feature: Provide Monte Carlo style similar to the M/70 for the high comb and consider feasibility of milling of the "Monte Carlo" for the "low comb - regular" stocks.

Stock: Continued	Finish: - New - penetrating oil finish - scuff resistant. Checkering: - Checker grip and fore-end. Sling Swivels: - Same style as presently furnished for M/721 - BDL Grade. Butt Plate: - New - if required to accommodate proposed Monte Carlo stock - otherwise use present.
Trigger Guard:	New - More rugged appearance and with detachable floor plate.
Bolt Handle:	Modify present M/721 design to provide "swept back" appearance, as per earlier samples. Finish: - Black - as on M/40-X.
Bolt Plug & Cocking Indicator:	Use black finish as on M/40-X.
Weight:	Desire a reduction to approx. 6¼ to 6½ lbs.
Production Volume:	7,000 to 10,000/yr.
Retail Selling Price:	$120.00 (Approx.)

SMA:T
9-23-55

RIFLES Model 725 Bolt Action

MODEL 725 CENTER FIRE RIFLE

Introduced 1958

Discontinued 1962

Summary of Calibers and Barrel Lengths

Calibers	Barrel Length
30–06	22"
280 Rem.	22"
270 Win.	22"
244 Rem.	22"
222 Rem.	24"
243 Win.	22"
375 Win. Mag.	26"
458 Mag.	26"

Year	Production	Cu. Production	Serial No. end of year
1958	6367	6367	706,367
1959	4019	10386	710,400
1960	3311	13697	713,800
1961	2781	16478	716,550
1962	151	16629	716,700

			1955	1956	1957	1958	1959	1960	1961	1962
725	30/06	ADL			6	3776	1653	1098	1080	44
	280	ADL				1261	786	451	248	38
	270	ADL				1326	540	537	397	18
	244	ADL					436	178	226	
	222	ADL				2	602	416	435	23
	243	ADL						628	350	20
	375	MAG							23	5
	458	MAG							21	3
		D & F Grades				2	2	3	1	
		Total 725			6	6367	4019	3311	2781	151

SMAlvis:B
February 20, 1973

• M/725 in 244 Cal. have 1-12 twist up to serial number 713000 block
• after 713000 block (may 1960) the twist was changed to 1-10

To:
Dick Dietz – This is Company proprietary info.

Total gun quantities:

M/720 - - - 2,427
M/721 - - - - 270,989
M/722 - - - - 150,936
~~M/725~~ - - - - 16,629
M/600 - - - - 94,028
M/660 - - - - 50,536

Serial number blocks:

M/720 - - - - 40,000 to 42,427
M/721 } together at 1,100 to 423,014
M/722 }
M/725 - - - - 700,000 to 716,700
M/600 - - - 1,000 to 131,552 from 1963
M/660 to 1968. During November 1968 the number system was changed and started with the M/660 block at 6,200,000. The M/660 and M/600 were numbered in this same block, up to 6,222,957.

L. Goodstal 9/15/82

SHIPMENT RECORDS

Models			
37	721	722	725
605	-	-	-
758	39948	23541	-
829	40664	20479	-
648	35811	18614	-
242	7778	6241	-
45	8716	13502	-
1842	10438	10522	-
1339	7783	6242	6
5145	4568	5231	6367
2502	5656	4485	4019
3948	5303	4566	3311
	5939	3733	2781
17,903	520	595	151
-	173,124	117,751	16,635
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MODEL - 725 Rifle

YEAR OF MANUFACTURE - M/725 - BY SERIAL

INTRODUCED JAN. 1958 STARTING WITH SERIAL #700,000

Discontinued 1962

MODEL 725 CENTER FIRE RIFLE

INTRODUCED 1958
DISCONTINUED 1962

SUMMARY OF CALIBERS AND BARREL LENGTHS

CALIBERS	BARREL LENGTH
30-06	22"
280 REM.	22"
270 WIN.	22"
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	1955	1956	1957	1958	1959	1960	1961	1962
30-06 ADL			6	3776	1653	1098	1080	44
280 ADL				1261	786	451	248	38
270 ADL				1326	540	537	397	18
244 ADL					436	178	226	
222 ADL				2	602	416	435	23
243 ADL						628	350	20
"KODIAK") 375 MAG.							23	5
SPECIAL) 458 MAG.							21	3
D & F GRADES				2	2	3	1	
TOTAL			6	6367	4019	3311	2781	151

NOTES:

244 CALIBER - HAD 1-12 TWIST UP TO SERIAL NO. 713000 BLOCK.

AFTER 713000 BLOCK (MAY 1960) - TWIST WAS CHANGED TO 1-10.

MODEL 725 CENTER FIRE RIFLE

Introduced 1958

Discontinued 1962

Summary of Calibers and Barrel Lengths

Caliber	Barrel Length
30-06	22"
280 Rem.	22"
270 Win.	22"
244 Rem.	22"
222 Rem.	24"
243 Win.	22"
375 Win. Mag.	26"
458 Mag.	26"

SMAlvis:T
July 1970

MISCELLANEOUS RIFLE INFORMATION

MODEL 725

YEAR OF MANUFACTURE - M/725 - BY SERIAL

INTRODUCED JAN. 1958 STARTING WITH SERIAL #700,000.

REFINISHING PRICE

MODEL	STOCK	REC. BBL. & GD.	BOLT HANDLE	COMPLETE ARM
725	$13.50	7.50	1.00	8.50

.30-06 CAL. - JANUARY '58
.270 CAL. - MARCH '58
.280 CAL. - MAY '58
.222 CAL.)
.244 CAL.) - MARCH '59
.243 CAL. - 1-60
.375 W. MAG.
.458 W. MAG.

NOTES:

1958-1962 - APPROXIMATELY 16,000 WERE MADE

Remington

REMINGTON ARMS COMPANY, INC.

PETERS

MANUFACTURERS OF
SPORTING FIREARMS, AMMUNITION
TRAPS TARGETS
POWER TOOLS

ARMS AND CARTRIDGE POWERED TOOLS
ILION, N. Y.
AMMUNITION, BRIDGEPORT, CONN
POWER TOOLS PARK FOREST, ILL

BRIDGEPORT 2, CONNECTICUT

PETERS CARTRIDGE DIVISION
BRIDGEPORT, CONN
TRAPS AND TARGETS, FINDLAY, OHIO
CABLE—HARTLEY BRIDGEPORT
—ALL CODES—

January 5, 1959

Announcing...

THE REMINGTON MODEL 725
DELUXE BOLT ACTION CENTER FIRE RIFLE
IN 222 REMINGTON AND 244 REMINGTON CALIBERS

TO OUR WHOLESALERS

Gentlemen:

Just a year ago, Remington announced the Model 725 bolt action rifle - a deluxe rifle with custom features that has gained a distinguished reputation in just one year.

The Model 725 has been received so well that two new calibers are being made available - calibers that will help build your sales.

The 222 Remington and 244 Remington calibers have gained great confidence from shooters - team them with the Model 725 and you have a sure-fire combination.

Sales Features:

1. Versatility - large and small game alike can be hunted with the Model 725.

2. Ruggedness - the 725 has already proved its strength; use this feature to point out the world's strongest bolt action.

3. All purpose Monte Carlo stock - especially designed for instant use with either open or telescopic sights.

4. Sight mountings - drilled and tapped for five possible type mounts.

And all the rest of the custom features that go to make up the finest bolt action rifle available today.

January 5, 1959

PRICES AND TERMS

	Net to Wholesaler Less Tax	Net to Wholesaler Tax Included	Dealer	Retail
Model 725ADL "Deluxe" Grade	$75.23	$83.51	$101.20	$134.95

The net price is shown both with and without the U. S. Excise Tax of 11%. Dealer and retail prices include this tax. The terms and conditions outlined in our letter of January 5, 1959 will apply. The above dealer and retail prices have been established as minimum Fair Trade prices in all states having Fair Trade laws in effect.

DELIVERY

Model 725 - 222 Remington - January, 1959
Model 725 - 244 Remington - April, 1959

ADVERTISING MATERIAL

Electrotypes of the Model 725 will be furnished in sizes 2-5/8", 3-1/4", 4", and 6" upon request. Advertising material is prepared for your benefit and is furnished without charge.

Your efforts in the past twelve months have made the Model 725 a popular gun with shooters. Continued effort on your part will make the Model 725 in 222 Remington and 244 Remington calibers just as sought after - more sales mean more profits.

Sincerely,

Gail Evans

Director of Sales

Gail Evans:lk

Remington

REMINGTON ARMS COMPANY, INC.

Peters

MANUFACTURERS OF
SPORTING FIREARMS, AMMUNITION
TRAPS TARGETS
INDUSTRIAL TOOLS

ARMS AND INDUSTRIAL TOOL WORKS
ILION, N Y
AMMUNITION WORKS, BRIDGEPORT, CONN
CABLE—HARTLEY, BRIDGEPORT—ALL CODES

BRIDGEPORT 2, CONN.

PETERS CARTRIDGE DIVISION
BRIDGEPORT, CONN
TRAP AND TARGET WORKS
FINDLAY, OHIO

JANUARY 3, 1958

ANNOUNCING

THE NEW REMINGTON

MODEL 725

DELUXE BOLT ACTION CENTER FIRE RIFLE

TO OUR WHOLESALERS

Gentlemen:

The all new Remington Model 725 is a truly distinguished addition to the very fine Remington line of sporting firearms. Loaded with custom features, the Model 725 will meet the demands of the most exacting sportsmen. One look will tell you that here is a rifle with tremendous built-in sales appeal.

STRIKING NEW SALES FEATURES

1. NEW ALL PURPOSE MONTE CARLO STOCK ESPECIALLY DESIGNED FOR INSTANT USE WITH EITHER OPEN OR TELESCOPIC SIGHTS.

2. HINGED FLOOR PLATE WITH FAST, POSITIVE RELEASE LOCATED INSIDE THE TRIGGER GUARD.

3. NEWLY DESIGNED REAR SIGHT EASILY ADJUSTABLE FOR BOTH WINDAGE AND ELEVATION.

4. HOODED RAMP FRONT SIGHT....HOOD EASILY REMOVABLE.

5. OVERSIZED, SILENT THUMB SAFETY WITH THREE POSITIVE POSITIONS.

6. BEAUTIFULLY FINISHED AMERICAN WALNUT STOCK WITH PISTOL GRIP AND FOREARM FINELY CHECKERED.

7. DRILLED AND TAPPED FOR FIVE POSSIBLE SIGHT MOUNTINGS.

PRICES AND TERMS

	Net to Wholesaler	Dealer	Retail
Model 725ADL "Deluxe" Grade	$ 79.18	$101.20	$ 134.95
Model 725D "Peerless" Grade	398.35	466.75	565.75
Model 725F "Premier" Grade	734.31	860.35	1,012.20

The U. S. Excise Tax of 11% should be added to the net price. Dealer and retail prices include this tax. The terms and conditions outlined in our letter of December 27, 1956 will apply. The above dealer and retail prices have been established as minimum Fair Trade prices in all states having Fair Trade laws in effect.

ADVERTISING MATERIAL

Your regular supply of catalog pages, one copy of which is attached, will be forwarded to you shortly.

Electrotypes of this new rifle will be furnished in sizes 2-5/8", 3-1/4", 4", and 6" promptly upon request. These will be sent without charge.

DELIVERY AND ALLOTMENT

Deliveries will begin as follows:

30/06 Springfield Caliber----------January 1958
280 Remington Caliber----------March 1958
270 Win. Caliber----------May 1958

To assure every wholesaler of his proportionate share, distribution will be on an allocation basis. Your allotment for the entire year of 1958 is attached. Shipments against allocation will be on a fair and equitable basis, and every effort will be made to complete these deliveries not later than October 31, 1958. Please forward your order at once covering your allocation.

Thank you for your past efforts which have made Remington the world's leading sporting firearms manufacturer. Your enthusiastic cooperation will keep us continually on the march.

Sincerely yours,

REMINGTON ARMS COMPANY, INC.

Gail Evans

Director of Sales

Gail Evans:vv
Attachment

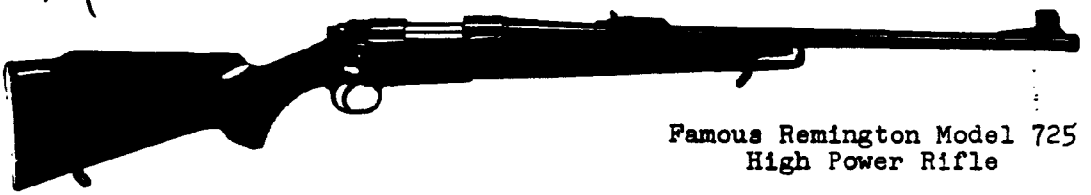
DU PONT

Wholesale Salesmen's

May 12, 1959 Volume 5, Number 5

File 7/725 Ads

BIG DEMAND SPURS INTRODUCTION OF BEAUTIFULLY CRAFTED RIFLE IN VARMINT, MEDIUM GAME CALIBERS



Famous Remington Model 725
High Power Rifle

NOW CHAMBERED FOR

222 Remington

244 Remington

(Model 725 also available in 280 Rem., 270 Win., 30-06)

With varmint shooting now a major sport, and still growing, you and your dealers have an even greater opportunity for sales. The avid varmint hunter is no longer satisfied with "just any" rifle or cartridge. He is extremely selective in choosing a rifle-and-cartridge combination that will back up his shooting ability - usually at long range.

Both the 222 Remington and 244 Remington* cartridges were specially designed for varmint hunters - and the sales success of these cartridges is evidence of their popularity. Add this popularity to the handsomely designed and field-proven Remington Model 725 and you have all the "makings" for plus business.

The Model 725 in 222 Remington caliber is now available; the rifle in 244 Remington caliber will be available for shipment this month. Dealer price is $101.20; retail price, $134.95.

Publicity and advertisements, in magazines with special appeal to varmint hunters, will pre-sell the many advantages of the Model 725 in these two new calibers...another reason for asking dealers for orders now in preparation for the big varmint season just ahead.

* * * * *

*The 244 Remington cartridge is also excellent for hunting medium game, such as antelope.

REMINGTON ARMS COMPANY, INC.
PUBLIC RELATIONS DIVISION
BRIDGEPORT, CONNECTICUT

725 calibers

FOR RELEASE UPON RECEIPT

NEW CALIBERS ANNOUNCED FOR
REMINGTON 721, 722 and 725 CENTER FIRE RIFLES

Remington Arms Company, Inc., Bridgeport, Conn., has announced new caliber additions for three bolt action center fire rifles. The Model 721 is now available in the popular 280 Remington caliber and the Models 722 and 725ADL are offered in 243 Win. caliber. The 280 Remington has been praised by shooters and gun experts alike as one of the best all around cartridges for North American big game. Addition of the 243 Win. completes a full range of hunting calibers.

Remington's Model 721 rifle, which is also available in 30-06, 270 Win. and 300 H & H magnum calibers, has been acclaimed as the strongest bolt action rifle ever built. Features of the 280 Remington Model 721 version include a 22" round tapered barrel; carefully bored and rifled for extreme accuracy; American walnut sporting stock; polished bolt and action; magazine holds four cartridges which, with one in the chamber, gives five shot capacity; gold bead front sight on matted ramp; step adjustable sporting rear sight with windage adjustment screw; receiver drilled and tapped for telescope mounts. Stock dimensions are: pull 13½", drop at comb 1-3/4", drop at heel 2-1/8". Weight is about 7 pounds and overall length is 42½". Retail price for the Model 721A 280 Remington is $98.25.

2¼

- MORE -

The Model 722A is the same as the Model 721A except that it has a shorter action and is chambered for 222 Remington, 222 Remington magnum, 244 Remington, 308 Win. cartridges, as well as the new 243 Win. Weight of the gun is about 7 pounds. Retail price of the 243 Win. is $98.25.

The Model 725ADL, which is offered in 222 Remington, 244 Remington, 243 Win., 280 Remington, 270 Win. and 30-06 calibers, is a bolt action model that is built with the finest custom features. Made with the new Remington all-purpose sight line which permits instant use of either open or telescopic sights, it has fine checkering and a handsome American walnut stock and a hinged floor plate. Other specifications include a 22" round, tapered barrel, carefully rifled for extreme accuracy; crisp match type trigger with new wide finger piece -- no backlash; polished bolt; magazine holds four shots, which, with one in the chamber, gives five shot capacity; gold bead hooded ramp front sight; rear sight adjustable for windage and elevation; receiver and barrel drilled and tapped for scope mounts (barrel tapped under rear sights). Stock dimensions are: drop at comb 1-3/4", drop at heel 2-1/8", length of pull 13½". Weight is 7 pounds and the overall length is 42½". Retail price for the Model 725ADL in all above calibers is $134.95.

-30-

January
1 9 6 0

COMPONENT PARTS REMINGTON

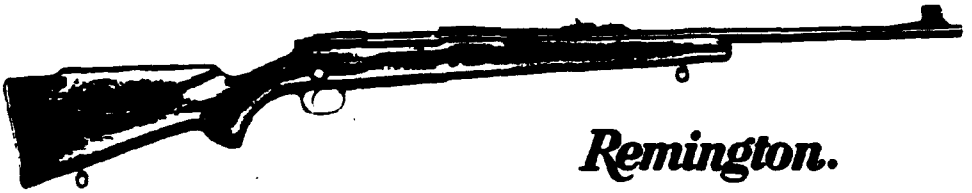
MODEL REPEATING RIFLE
725 BOLT ACTION-HIGH POWER

WHEN ORDERING PARTS-MODEL NO.PART NO.AND PART NAME MUST BE GIVEN

PART NO.	NAME OF PART
16415	BOLT LOCK-RESTRICTED--------
17012	BOLT PLUG----------
17013	BOLT STOP-RESTRICTED--------
16417	BOLT STOP PIN- " ----------
17044	BOLT STOP PIN SNAP WASH----- RESTRICTED----------
17038	BOLT STOP RELEASE-RESTRICTED
17014	BOLT STOP SPRING- "---------
25410	BUTT PLATE SCREW----------
17017	EJECTOR----------
17676	EJECTOR PIN----------
17019	EJECTOR SPRING----------
22020	FIRING PIN----------
22021	FIRING PIN,244,222 REM,243 WIN----------
22040	FIRING PIN ASSEMBLY---------
22043	FIR PIN ASSEM,244-222 REM., 243 WIN.----------
17022	FIRING PIN CROSS PIN--------
23321	FIR PIN HEAD-RESTRICTED-----
16105	FLOOR PLATE LATCH----------
16451	FLOOR PLATE LATCH PIN-------
16452	FLOOR PLATE LATCH SPRING----
16453	FLOOR PLATE PIVOT PIN-------
22035	FRONT GUARD SCREW----------
22037	FRONT GUARD SCREW, 244-222 REM, 243 WIN.----------
16770	FRONT SIGHT BLADE----------
18771	GRIP CAP----------
25385	GRIP CAP SCREW----------
16429	HOUSING-RESTRICTED----------
16430	MAGAZINE----------
16715	MAGAZINE, 244 REM.,243 WIN--
16716	MAGAZINE 222 REM.----------
17024	MAGAZINE FOLLOWER----------
17056	MAGAZINE FOLLOWER, 244 REM. 243 WIN.----------
17975	MAGAZINE FOLLOWER, 222 REM.-
17028	MAGAZINE SPRING----------
17891	MAGAZINE SPRING,244 REM,243 WIN.----------
16826	MAGAZINE SPACER, 222 REM----
17029	MAIN SPRING----------
17058	MAIN SPRING, 244-222 REM., 243 WIN.----------
20430	QUICK DETACHABLE SWIVEL,FRT OR REAR----------
26355	REAR GUARD SCREW----------
32524	REAR SIGHT ASSEMBLY---------
28200	REAR SIGHT ASSEM, COMPLETE--
16454	REAR SIGHT BASE----------
16023	REAR SIGHT BASE SCREW-------
16456	REAR SIGHT SCREW----------
28096	REAR SIGHT STEP(SELECTED SIZES-
16968	REAR SIGHT WASHER(ALL CALIBERS)
17034	RECEIVER PLUG SCREW----------
16413	SAFETY - RESTRICTED----------
23222	SAFETY DETENT BALL-RESTRICTED--
16421	SAFETY DETENT SPRING "---------
24545	SAFETY LOCK THUMBPIECE ASSEM RESTRICTED----------
17043	SAFETY PIVOT PIN-RESTRICTED-----
17044	SAFETY SNAP WASHER-RESTRICTED--
24590	SEAR & SAFETY CAM ASSEM-RESTRICTED
24476	SEAR PIN-RESTRICTED----------
17047	SEAR SPRING-RESTRICTED---------
18186	STOCK REINFORCING SCREW--------
16970	STOCK REINFORCING SCREW DOWEL--
20890	STOCK SWIVEL FRONT ASSEM-------
20895	STOCK SWIVEL REAR ASSEMBLY-----
17571	STOCK SWIVEL PIN, FRONT OR REAR
17049	TRIGGER ADJUSTING SCREW-RESTRICTED
24575	TRIGGER ASSEMBLY-RESTRICTED----
19461	TRIGGER CONNECTOR-RESTRICTED---
26371	TRIGGER GUARD ASSEMBLY---------
26370	TRIGGER GUARD ASSEMBLY,244-222 REM.,243 WIN.----------
24477	TRIGGER PIN-RESTRICTED---------
17978	TRIGGER SPRING-RESTRICTED------
17053	TRIGGER STOP SCREW-RESTRICTED--

DELIVERIES ARE F.O.B. ILION, NY 13350

PARTS AND PRICES SUBJECT TO CHANGE WITHOUT NOTICE



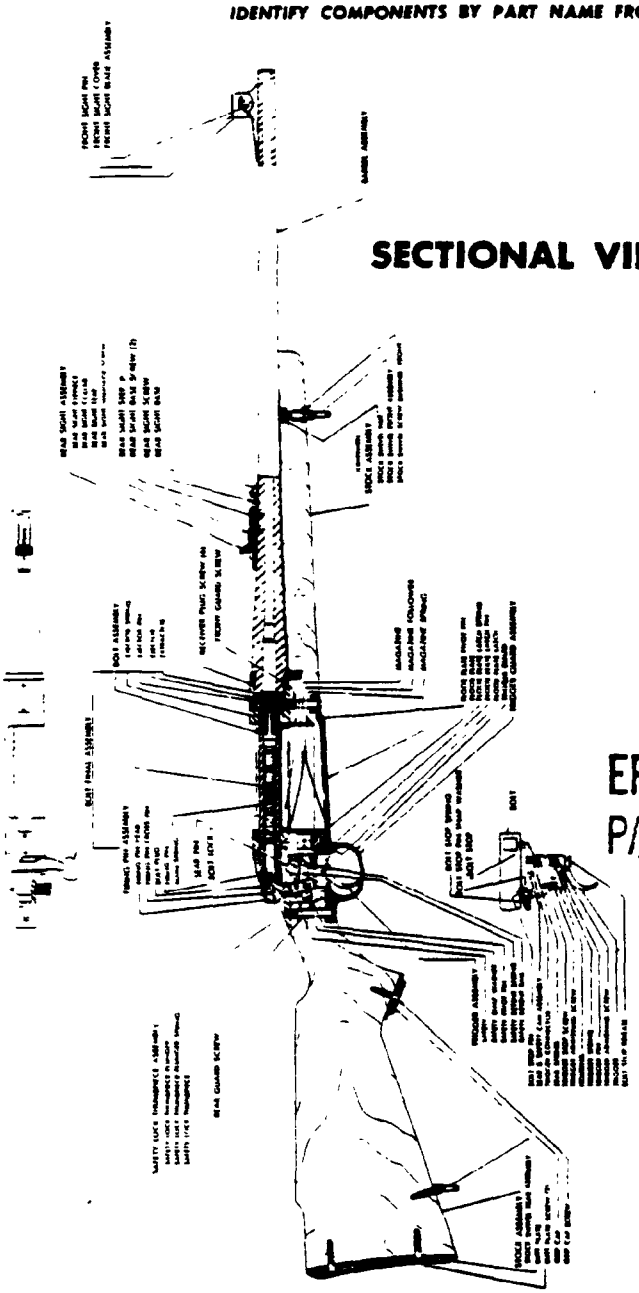
Remington.

MODEL 725 Repeating Rifle

BOLT ACTION — HIGH POWER

(DISCONTINUED)

IDENTIFY COMPONENTS BY PART NAME FROM SECTIONAL VIEW



SECTIONAL VIEW

CENTER FIRE CALIBERS

30-06
270 Win.
280 Rem.
222 Rem.
244 Rem.

ADL "DELUXE" GRADE

Send all guns for factory service and inquiries on service and parts to
REMINGTON ARMS COMPANY, INC.
Arms Service Division
Ilion, New York 13357

All other inquiries are to be addressed to
REMINGTON ARMS COMPANY, INC.
Bridgeport, Connecticut

EFFECTIVE JANUARY 1, 1978
PART PRICES INCREASED 15%

REPLACEMENT PARTS

When ordering parts, specify model, caliber, part name and number, and serial number of gun.

NOTE: The sale of barrel assemblies (includes receiver), and bolt assemblies is restricted. When these parts are needed for replacement, selective assembly is required to assure proper operation. All other parts will be shipped as ordered but, since they are made to close dimensions, the particular part may require slight adjustment or fitting to assure proper functioning of the arm.

THREE POSITION SAFETY LOCK

Safe "S"

(Fig. 1)

Cock rifle then rotate safety lock thumbpiece fully rearward to "S" mark on receiver. Bolt is *locked closed* in this position and bolt handle cannot be raised.

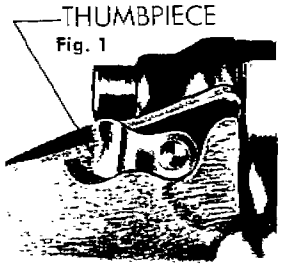


Fig. 1

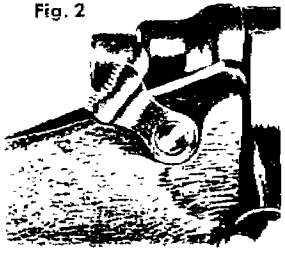
Unlock Position

(Fig. 2)

Rotate the safety lock thumbpiece to UNLOCK position between "S" and "F" (no mark). Bolt handle can then be raised and the bolt unlocked.

NOTE: Rifle *cannot be fired* when safety thumbpiece is set for unlock position.

Fig. 2



Fire "F"

(Fig. 3)

Rotate the safety lock thumbpiece fully forward to "F" mark on receiver.

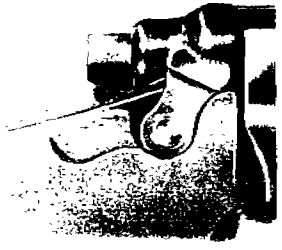


Fig. 3

SIGHT ADJUSTMENTS

OPEN SIGHTS

The sights on the Remington 725 are targeted at 100 yards and carefully adjusted at the factory.

For *Windage Adjustment* the rear sight eyepiece may be moved to the left by turning the windage screw clockwise. By turning the windage screw counter clockwise the rear sight eyepiece may be moved to the right.

NOTE: The windage screw is located beneath the eyepiece.

For *elevation* or *range* adjustment the rear sight may be raised or lowered by adjusting the notched sight step beneath the rear sight eyepiece.

TELESCOPE or RECEIVER SIGHTS

The all-purpose stock on the Remington 725 is adapted for use with telescope or receiver sights as well as gun factory sights. The location and design of the rear sight holes are standard for most target telescope mounts. If rear sight is removed for receiver sighting clearance, the rear sight barrel screw holes may be filled with the receiver plug screws.

Shoot REMINGTON or PETERS Ammunition for best results

The Remington 725 is chambered in the 30-06 Springfield caliber to deliver quality performance and maximum power for your shooting pleasure.

A full choice of bullet weights and styles is available. Choose the cartridge best suited to your particular hunting needs.

RD5359

Remington

DU PONT

Remington 725

DELUXE

Bolt Action • High Power

REPEATING RIFLE

DU PONT

Instruction Folder

REMINGTON ARMS COMPANY, INC.
ILION, NEW YORK, U. S. A.

HOW to LOAD your REMINGTON 725

IMPORTANT: Before firing, always check barrel and remove any obstruction, grease or heavy oil from bore and cartridge chamber.

SINGLE LOAD

Rotate safety lock thumbpiece to UNLOCK position between "S" mark and "F" mark on receiver. Raise bolt handle and pull bolt assembly backward to bolt stop. Place cartridge on magazine follower, then push bolt forward to load cartridge into barrel (see Fig. 4). Turn bolt downward, to lock cartridge in barrel and cock rifle. Rotate safety lock thumbpiece to SAFE "S" mark, or if desired to fire rifle, rotate thumbpiece to FIRE "F" mark.

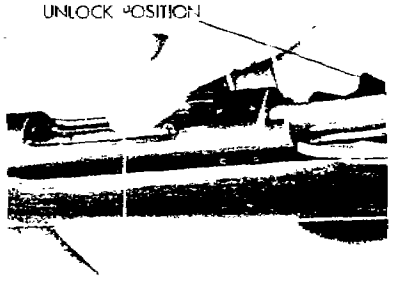


Fig. 4

MAGAZINE LOAD

Open Bolt—Load cartridges into top of magazine in conventional manner, if desired.

Closed Bolt — Rotate safety lock thumbpiece fully rearward to SAFE "S" mark on receiver. Turn rifle bottom upwards, and rotate floor plate latch forward. Lift unlatched floor plate and swing attached magazine follower and spring from magazine. Load cartridges into magazine opening (see Fig. 5). Close and latch floor plate against the staggered box column of loaded cartridges. NOTE: The first cartridge must be loaded to the right side of the open magazine.

Capacity — Load four (4) cartridges into magazine.

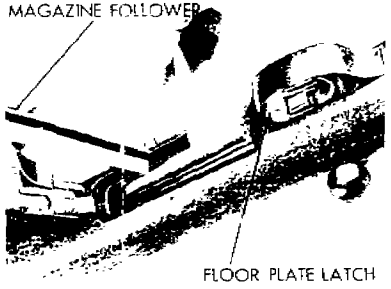


Fig. 5

UNLOAD MAGAZINE

With closed bolt:

Rotate safety lock thumbpiece fully rearward to SAFE "S" mark (bolt lock).

Turn rifle bottom upwards and unlatch floor plate from trigger guard.

Raise floor plate and remove live cartridges from magazine (see Fig. 6).

Close and latch floor plate.

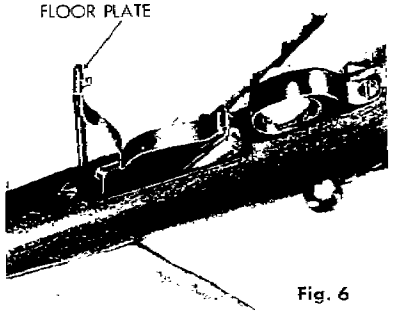


Fig. 6

UNLOAD BARREL

Rotate safety lock thumbpiece to UNLOCK position between "S" and "F" mark on receiver.

Raise bolt handle and pull bolt to rear slowly.

Lift live cartridge carefully from face of bolt as bullet end of cartridge clears the ejection port of receiver (see Fig. 7).

PRECAUTION: Make certain magazine is empty before closing bolt assembly. *If live cartridge remains in magazine,* return bolt forward to slide and raise cartridge free of magazine. Then pull bolt rearward again and carefully remove live cartridge from rifle.

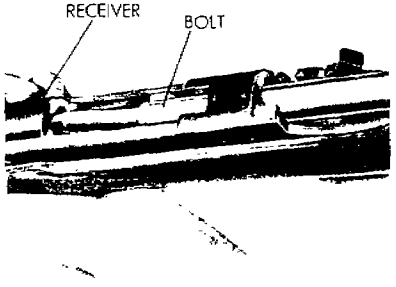
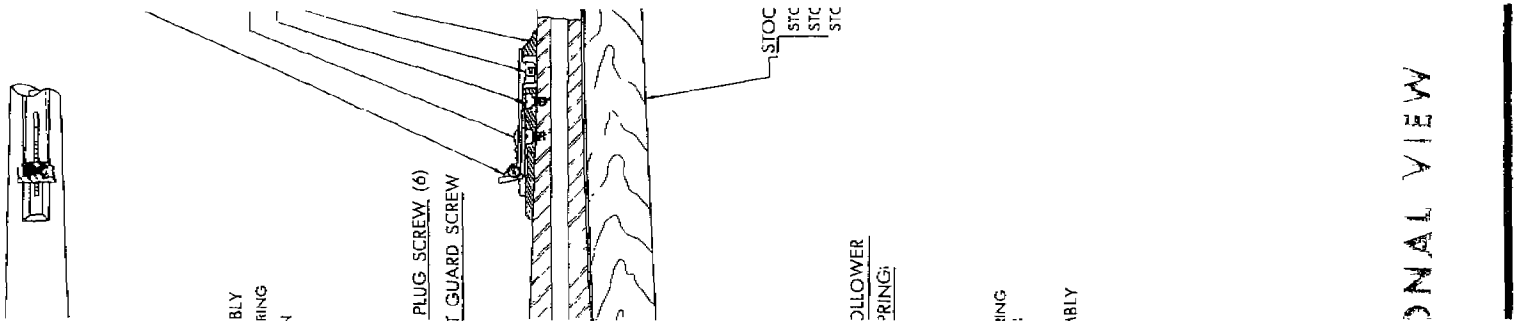


Fig. 7



CARE OF RIFLE

To keep the barrel bore in perfect condition, it is recommended that Remington Ammunition with KLEANBORE Priming, or Peters Ammunition with RUSTLESS Priming be used exclusively. These cartridges cannot cause rust or corrosion and cleaning is unnecessary other than passing an oiled patch through the bore to protect it against extreme moisture, or when the gun is laid away for some time. Also give the outside of your gun some attention after it has been handled. Wipe the gun with an oily cloth, since fingers leave invisible "prints" of moisture that may cause rust on metal unless removed. Should it be necessary to clean the action, it is recommended that the disassembly be made as instructed below. Wash with a petroleum solvent such as varnolene or kerosene, drain, and lubricate lightly. In freezing weather, oil should be removed and fine, dry graphite used as a lubricant.

To remove BOLT:

Rotate safety lock thumbpiece to UNLOCK position. Raise bolt handle and pull bolt rearward to bolt stop. Press upwards on bolt stop release (see Fig. 8) and pull bolt from receiver.

NOTE: It is not necessary to operate bolt lock release when replacing bolt.

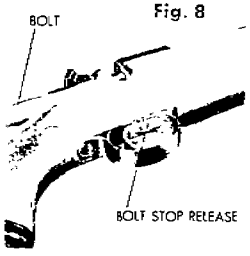


Fig. 8

To remove FIRING PIN ASSEMBLY:

Remove bolt from rifle. Pull firing pin head rearward until coin or similar tool can be inserted between it and bolt plug (see Fig. 9). Unscrew bolt plug to remove assembly from bolt.

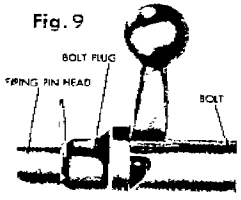


Fig. 9

To remove STOCK:

Unscrew both guard screws and remove. Lift trigger guard assembly from rifle (see Fig. 10).

NOTE: Magazine follower, and magazine spring will also be removed from rifle when trigger guard is lifted free.

Lift stock from rifle. Separate magazine from stock.

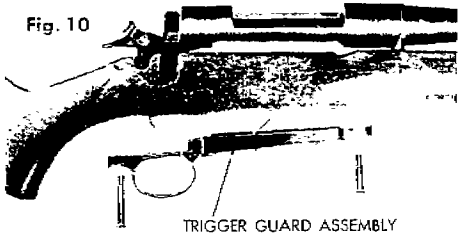


Fig. 10

NOTE: Before replacing stock, reassemble magazine first to receiver. Secondly, reassemble trigger guard assembly (with assembled magazine follower and spring) to stock. Then reassemble stock and trigger guard over assembled magazine and to receiver. Hold in position and replace trigger guard screws.

To adjust TRIGGER:

Remove trigger guard and stock. Cock bolt in receiver.

IMPORTANT: No adjustment or removal of the rear trigger adjusting screw is recommended unless replacement is necessary. The rear trigger adjusting screw is set at the factory to engage the trigger and provide the correct amount of supporting trigger connector surface beneath the sear (see Fig. 11).

Pull of Trigger:

Is adjusted to the desired weight by turning the front trigger adjusting screw clockwise for a heavier weight adjustment and counter clockwise for a lighter weight adjustment.

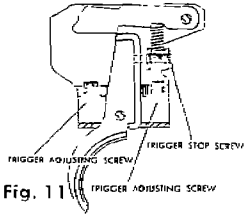
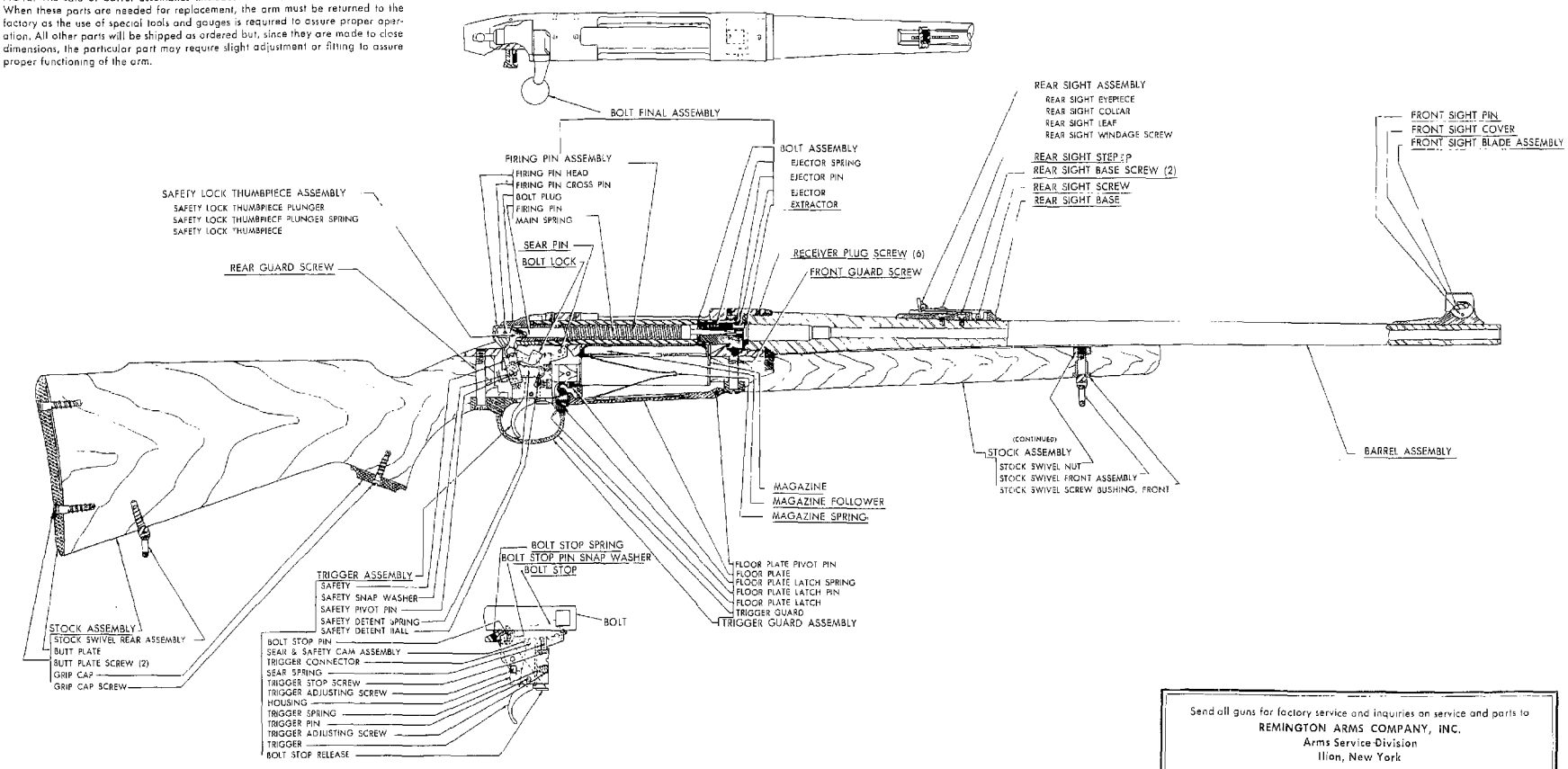


Fig. 11

Travel of Trigger:

May be reduced by turning the trigger stop screw clockwise until the firing pin will not fall when the trigger is pulled. Then while keeping pressure on the trigger, back off the trigger stop screw, counter clockwise, until the firing pin falls. This method of adjustment will allow the least amount of trigger overtravel.

REPLACEMENT PARTS: Prices for parts will be furnished upon application. When ordering parts specify model, caliber, part name and serial number of gun. NOTE: The sale of barrel assemblies (includes receiver) and bolts is restricted. When these parts are needed for replacement, the arm must be returned to the factory as the use of special tools and gauges is required to assure proper operation. All other parts will be shipped as ordered but, since they are made to close dimensions, the particular part may require slight adjustment or fitting to assure proper functioning of the arm.



Send all guns for factory service and inquiries on service and parts to
REMINGTON ARMS COMPANY, INC.
Arms Service Division
Ilion, New York

All other inquiries are to be addressed to
REMINGTON ARMS COMPANY, INC.
Bridgeport 2, Connecticut

distinguished, all-new...

BOLT ACTION RIFLE

REMINGTON

le luxe model

725

30-06 — January '58 delivery
30 Rem. — March '58 delivery
270 Win. — May '58 delivery

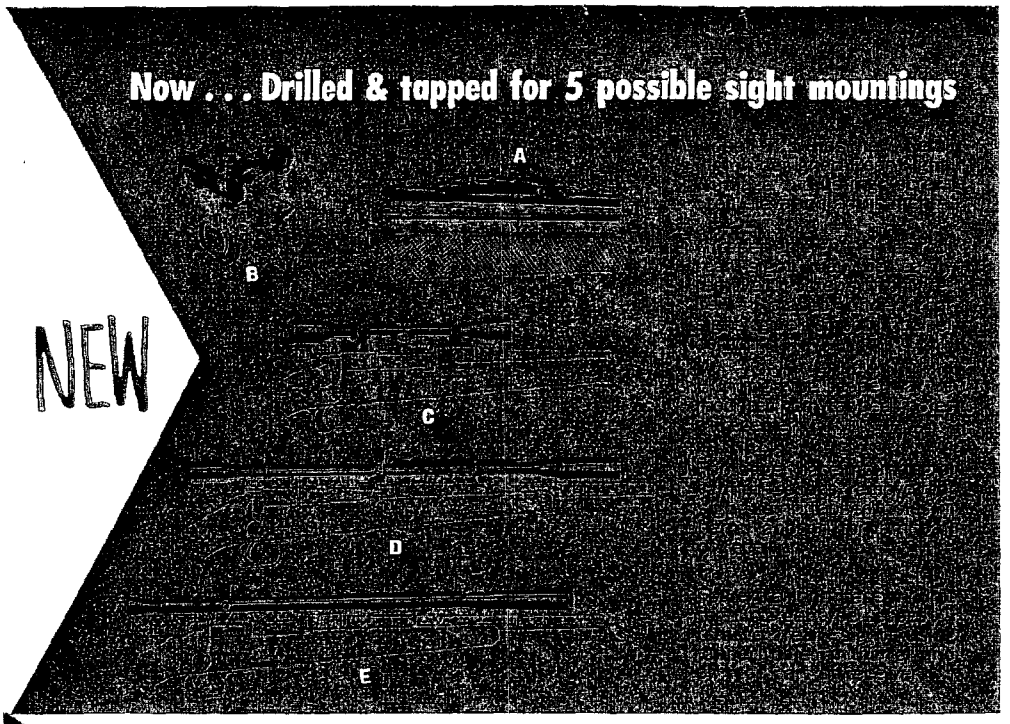
CUSTOM FEATURES

- ●
- ●
- ●
- ●
- ●

Remington

DU PONT
REG U S PAT OFF

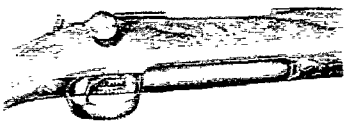
$134.95*



NEW

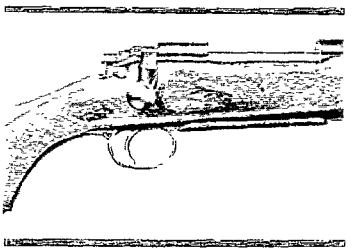
NEW

LOADING OR UNLOADING
Hinged floor plate makes job of loading, or unloading a lot easier. Just push the release button to remove cartridges from magazine. No working of bolt. If a low mounted scope interferes, load magazine from the bottom in seconds!



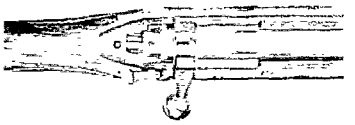
NEW

LARGE THUMB SAFETY
Placed on the right rear of the receiver, the big safety is right where shooters want it. Fast, positive, quiet . . . it also has a neutral (middle) position which allows the bolt to be drawn back, keeping the rifle on "Safe" at same time. Long travel distance of safety allows shooter to see at a glance whether safety is on or off.



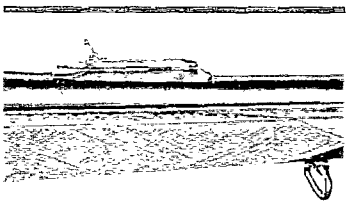
NEW

MATTED RECEIVER
Finish of receiver is matted for better visibility. Note clearly marked F and S for "Fire" and "Safe".



NEW

Windage Adjustable Open Rear Sight
New Remington designed open rear sight has windage adjustment screw on right side of sight leaf. Merely turn screw right or left when sighting in. To remove rear sight, if receiver or scope sights are desired, take out screw on right side of sight base. This allows sight leaf to be removed. Two hold down screws will be found on top of base. Remove these and barrel is ready for scope block mounting. If receiver sight is installed, take out filler screws on left side of receiver, and use to fill in barrel under rear open sight.



NEW

WITH OR WITHOUT
Easily removable hood on ramp front sight gives shooter instant choice. With hood in place, gold bead is exactly centered and flat faced for a more perfect sight picture every time!

What The New All Purpose Stock Does For The Shooter!

Revolutionary new **all purpose stock** means no more worry about interchanging between open and telescopic sights. No matter which is used, the eye is always in perfect sighting line. The pistol grip has been shaped to reduce the reach from hand to trigger . . . assuring more uniform squeezing of trigger. Straighter stock lines combined with slight forward slope of comb means less recoil.

SPECIFICATIONS
Remington Model 725ADL

Caliber
30-06, 280 Remington, 270 Win.

Action
Bolt. Bright finished body . . . handle blued. Same strong bolt design as famous Remington M/721-722. Receiver matte finished.

Magazine
Fixed box with hinged floor plate. Floor plate release inside trigger guard. 4 shot capacity plus one in chamber. Wide corrugated match-type trigger.

Stock
American Walnut . . . forearm and pistol grip finely checkered. **All purpose stock** with Monte Carlo comb for use with open or telescopic sights. Black grip cap and black checkered butt plate.

Safety
Thumb operated lever . . . 3 position control. Receiver marked F and S for "Fire" and "Safe". Middle position for opening bolt with trigger on safe.

Barrel
22-inch round tapered.

Sights
Flat face gold bead front sight with hood. Step adjustable rear sight with windage adjustment screw.

Weight	Length
7 lbs.	42½ inches overall.

Also available in D "Peerless" and F "Premier" grades.

Remington

DU PONT

Remington Arms Company, Inc.
Bridgeport 2, Connecticut

Form No. 57-218R Printed in U.S.A.

Remington.

REMINGTON ARMS COMPANY, INC.

SPORTING ARMS-AMMUNITION-TARGETS-TRAPS

ILION, NEW YORK 13357

TELEPHONE (315) 894-9961

August 6, 1985

Mr. Kenneth Bolin
Box 116
Mt. Vernon, TX 75457

Dear Mr. Bolin:

Your Remington Model 725 rifle, bearing serial number 711408 was manufactured ~~during 1960~~. They have a 1-12 twist up to May of 1960 and a 1-10 twist from May, 1960 to the end - 1962.

We recommend not to shoot the Model 1882 shotgun. Many of these have Damascus or de-carbonized steel barrels.

Sincerely,

L.K. Goodstal, Museum Curator
Remington Company Historian

LKG:sr

RECEIVED
JUL 12 1985
CONSUMER SERVICE

July 3, 1985

Gentlemen:

Please furnish me with the following information. I have a Rem. Model 725 Rifle in .244 Rem caliber serial no. is 711408. Does this rifle have a 1-10 or 1-12 inch twist barrel? What was year of manufacture? This info will be much appreciated

Respectfully,

Kenneth Bolin
Box 116
Mt. Vernon, Tex
75457

P.S. Also need info on a Model 1882 12 ga. Rem. Shotgun serial no. 219720. Year of manufacture? Are barrels steel as it appears?

Thanks again

May 20, 1974

M-725

Mr. Elbert E. Averill
1402 S. Boulder Ave.
Tulsa, Oklahoma 74119

Dear Mr. Averill:

Our records reveal that a Remington Model 725 Rifle bearing serial number 704754 was manufactured during 1958.

The attachments show features of this model and prices as advertised back in 1958-59.

You may be correct in believing that the Model 725 was one of the better Remington high power rifles, back then. Notice that it was priced higher than the Models 721 and 722.

Very truly yours,

L. K. Goodstal
Curator - Remington Museum

LKG:T
Attach.

Remington

REMINGTON ARMS COMPANY, INC.

Peters

SPORTING FIREARMS
TRAPS
POWDER METAL PARTS
ILION, NEW YORK
AMMUNITION, BRIDGEPORT, CONNECTICUT
LONOKE, ARKANSAS

MANUFACTURERS OF
SPORTING FIREARMS, AMMUNITION
TRAPS TARGETS

ILION, NEW YORK 13357

PETERS CARTRIDGE DIVISION
BRIDGEPORT, CONNECTICUT
TARGETS, ADA, OKLAHOMA
ATHENS, GEORGIA
FINDLAY, OHIO
CABLE—HARTLEY, BRIDGEPORT

May 15, 1974

Mr. Elbert E. Averill
1402 S. Boulder Ave.
Tulsa, Oklahoma 74119

Dear Mr. Averill:

The Remington Model 725 was introduced in 1958 and discontinued in 1962.

We are not able to establish the exact year your specific rifle was manufactured without knowing its serial number.

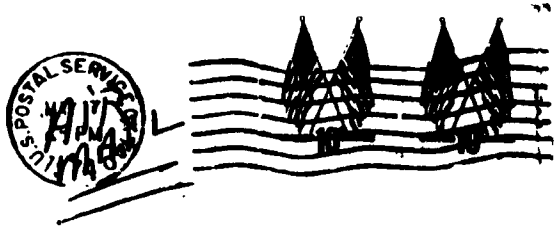
Very truly yours,

L. K. Goodstal

L. K. Goodstal
Curator - Remington Museum

LKG:T

E.E. Averill
1402 S. Boulder Ave.
Tulsa, Oklahoma 74119



Remington Arms Company, Inc.
Box 179
Ilion, New York 13357

Attention:
Mr. L.K. Goodstal
Curator-Remington Museum

May 15, 1974

Mr. Elbert E. Averill
1402 S. Boulder Ave.
Tulsa, Oklahoma 74119

Dear Mr. Averill:

The Remington Model 725 was introduced in 1958 and discontinued in 1962.

We are not able to establish the exact year your specific rifle was manufactured without knowing its serial number.

Very truly yours,

L. K. Goodstal
Curator - Remington Museum

LKG:T

To: Larry 4-11-74

From: [illegible]

Be nice to this guy
the may give you a
discount.

Can you give Mr.
Averill some info
on his M/725?

Thanks
Carl

The Fitzgerald
FUNERAL SERVICE
BOULDER AT FOURTEENTH, TULSA, OKLAHOMA 74119

April 8, 1974

RECEIVED
APR 11 1974
CONSUMER SERVICE

Mr. C. Beck
Remington Arms Co.
939 Barnum Ave.
Bridgeport, Conn. 06602

Dear Mr. Beck,

I just received your new 1974 catalog, and I thank you very much. Would you please be so kind to send me some information on the Remington Model 725 (30-06 caliber) I just recently purchased one, and would like to know the manufacture dates and when it was discontunied.

Thank you for your attention to this.

Sincerely,

Elbert E. Averill
1402 S. Boulder Ave.
Tulsa, Oklahoma 74119

Thelma:

Over

John Shonkwiler D. A. Zahn Arnold Moore Mrs. Margaret Fitzgerald

Remington
The Model 725 was introduced in 1958 and discontinued in 1962.

We are not able to establish the exact year your specific rifle was manufactured without knowing its serial number.

M/725 - Accuracy

M/725-30-06 Elevation check

G.M. 6/19/58

Gun no	7.5	Step	point of impact	
3910	high	8	1 low	.093
4938	"	8	6½ low	.118
4623	"	8	2 low	.098
4610	"	8	2 low	.098
4616	"	8	1 low	.093
4880	"	8	1 low	.093
4572	"	8	1 high	.085
4821	"	8	9 low	.134
4858	"	8	0	.089
4663	"	7	2 low	.071
4658	"	8	1 low	.093
4867	"	8	4 low	.107
4958	"	8	6 low	.116
4618	"	8	1 low	.093
4949	"	8	8 low	.125
4010	"	8	2 high	.080
4904	"	8	5 low	.111
4612	"	7	1 high	.058
4557	"	8	0	.089
4828	"	8	8 low	.125

$\frac{1974}{20} = .099$

M/725-30-06 Elevation check
New master gun

6/13/58

Gun No	75	step	point of impact	
5607	High	8	2" high	.080 ✓
5610	"	7	0	.062 ✓
5395	"	7	0	.062 ✓
4697	"	8	3" high	.076 ✓
4976	"	7	0	.062 ✓
4691	"	8	0	.089 ✓
4637	"	8	0	.089 ✓
5346	"	8	0	.089 ✓
4978	"	5	1 high	.015 ✓
5346	"	8	0	.089 ✓
5308	"	7	1 high	.058 ✓
4619	"	8	0	.089 ✓
4885	"	8	2 high	.080 ✓
5487	"	7	0	.062 ✓
5326	"	8	2 low	.098 ✓
4730	"	7	0	.062 ✓
5113	"	8	2 high	.080 ✓
5330	"	7	2 high	.053 ✓
5001	"	8	0	.089 ✓
4065	"	8	1 high	.085 ✓
5283	"	7	0	.062 ✓
5840	"	8	0	.089 ✓
5744	"	8	0	.089 ✓

$\frac{1709}{23} = .073$

M/725

DATE	1/28	1/29	2/5	2/6	2/10	2/11	2/11	2/12	2/12	2/13	2/17	2/17	2/18	2/18	2/19	2/20	2/24	2/25	2/25	2/27	2/27	3/3	3/4	3/5	3/6	3/6	3/10	3/12	3/13	3/17	3/17	3/18	3/19	3/20	3/20	3/24
											601/657 = 91%																									
																																			786/860 = 91%	
CALIBER	—	—	—	270	30-06	30-06	270	270	30-06	30-06	30-06	270	30-06	270	30-06	30/06	30-06	30-06	270	30-06	270	30-06	30-06	30-06	270	30-06	30-06	30-06	30-06	270	30-06	30-06	30-06	30-06	280	30-06
TARGET	116	28	71	54	78	45	65	67	40	93	70	14	42	19	29	29	52	54	23	75	24	124	76	107	17	49	58	114	109	12	79	24	35	93	17	108
PASSED	92	19	30	49	60	35	58	56	27	86	64	10	37	17	28	20	43	40	17	47	18	54	21	47	13	28	30	56	51	10	40	17	8	38	15	49
REJECTED	24	9	41	5	18	10	7	11	13	7	6	4	5	2	1	9	9	14	6	28	6	70	55	60	4	21	28	58	58	2	39	7	27	55	2	59
RIGHT	16		3		1		1	2																												
LEFT		4				7	3	5	13	1	4		3	2	1	8		9	5	17	4	52	48	53	4	21	18	55	50	1	30	6	27	53	2	57
HIGH	6	4	7	4	7	1		4		2	1					1					2	1														
LOW											1						6	2	1	7		11	11	9		1	5	6	7		5			5		5
F.S. DEFECTIVE																														1						
BENT																																				
MISSING		1			1																						1					1				
LOOSE			31		7							4	1														4									
OTHER																																				
R.S. BROKEN						1							1							2																
TIPPED							3			3							2	1		1		1									2					
MISSING																						1									2			1		
NO TENSION	2			1	2					1								2				2					1				1					
OUT OF LINE																																				
UNSTAKED						1																														
OTHER																	1											1								
BASE LOOSE																				1																
MISC																													1							

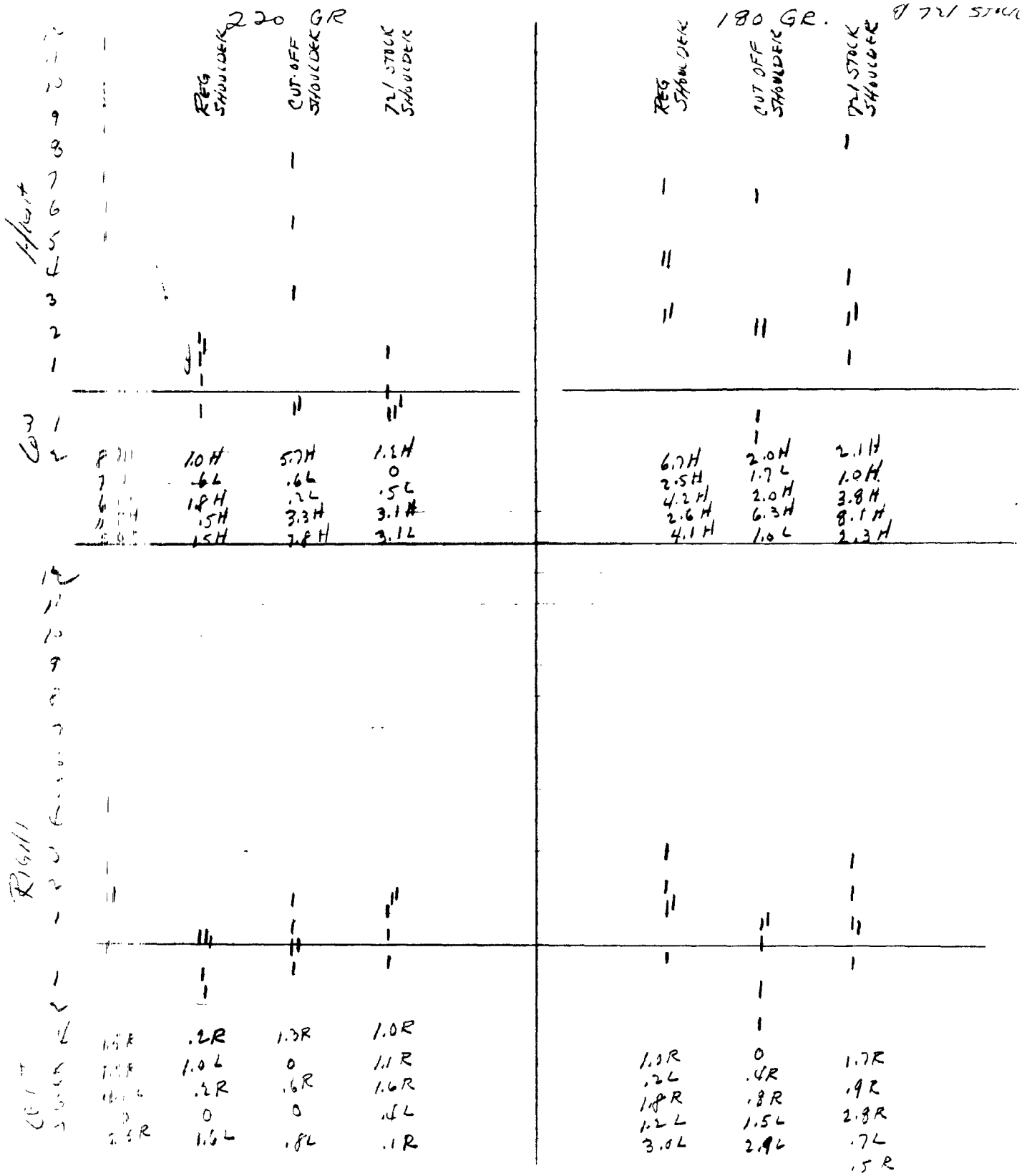
DATE	2/25	2/27	2/27	3/3	3/4	3/5	3/6	3/6	3/10	3/12	3/13	3/17	3/17	3/18	3/19	3/20	3/20	3/24
									1979/1066 = 90%									
												1174/1461 = 80.3%						
																		1332/1742 = 76.5%
CALIBER	270	30-06	270	30-06	30-06	30-06	270	30-06	30-06	30-06	30-06	270	30-06	30-06	30-06	30-06	280	30-06
TARGET	23	75	24	124	76	107	17	49	58	114	109	12	79	24	35	93	17	108
PASSED	17	47	18	54	21	47	13	28	30	56	51	10	40	17	8	38	15	49
REJECTED	6	28	6	70	55	60	4	21	28	58	58	2	39	7	27	55	2	59
RIGHT																		
LEFT	5	17	4	52	48	53	4	21	18	55	50	1	30	6	27	53	2	57
HIGH			2	1														
LOW	1	7		11	11	9		1	5	6	7		5			5		5
F.S. DEFECTIVE												1						
BENT																		
MISSING									1					1				
LOOSE									4									
OTHER																		
R.S. BROKEN		2																
TIPPED		1		1									2					
MISSING				1									2			1		
NO TENSION				2					1				1					
OUT OF LINE																		
UNSTAKED																		
OTHER										1								
BASE LOOSE		1																
MISC											1							

BY ..... DATE ..... SUBJECT .....
CHKD. BY ..... DATE ..... SHEET NO. ..... OF .....
JOB NO. .....

725 LEFT SHOOTERS

ZEROED IN FROM SHOULDER, THEN RESHOT FROM DEVICE

CUT OFF 721 & 721 STOCK



JRN ACCURACY DEVICE

	LEFT	BEAD OFF EYEPIECE	9" ANGULARITY
700116	6"	L.004	R.015
701150	8" .2R	R.001	R.024
700210	10" .2R	R.028	R.045
700237	5"	L.026	R.060
700414	6"	R.032	R.024
700452	5" 0	L.009	R.022
700530	17"	R.012	L.001
700602	9" 1.6L	R.011	R.036
700625	5"	L.023	R.032
700887	8" 1.0L	R.013	R.013

M/700 Accuracy Comparison

		700210			700887			701150			700452			700602		
		EL	WIND	GR	EL	WIND	GR	EL	WIND	GR	EL	WIND	GR	EL	WIND	GR
220	Shldr.	1.5H	0	2.2	.5L	0	1.9	1.0H	0	2.4	0	0	2.8	1.6H	1.5L	3.
	REG.	.5H	.5R	1.8	.8L	2.1	2.1	2.5H	.5R	1.5	1.0H	0	2.5	1.5H	1.8L	2.
	STOCK	1.0H	.2R	2.0"	.6L	1.0L	2.0"	1.8H	.2R	1.9	.5H	0	2.6	1.5H	1.6L	3
180	Shldr.	6.5H	1.5R	3.0	2.0H	1.0L	3.5	3.5H	1.3R	2.4	2.9H	.7L	3.3	3.8H	2.1L	2
	REG	7.0H	.5R	2.9	3.0H	.5R	2.5	5.0H	2.4R	1.9	2.4H	1.8L	2.9	4.4H	3.9L	3
	STOCK	6.7H	1.0R	2.9"	2.5H	.2L	3.0"	4.2H	1.8R	2.1"	2.6H	1.2L	3.1"	4.1H	3.0L	2
		5.9H	[illegible]		3.1H	.8R		2.4H	1.6R		2.1H	1.2L		2.6H	1.4L	
220	Accur.	8.0H	1.0R		6.0H	0		5.0H	5.0R		12.0H	4.0L		5.0H	2.0R	
	REG	9.5H	2.0R		8.0H	3.0R		7.0H	4.0R		11.0H	4.0R		6.0H	3.0R	
	STOCK	8.7H	1.5R		7.0H	1.5R		6.0H	4.5R		11.5H	0		5.0H	2.5R	
		7.1H	1.3R		7.6H	2.5R		7.2H	7.3R		11.0H	–		3.5H	7.1R	
220	Shldr	6.1H	1.5R	2.1	1.5L	.6L	2.8	.5L	0	3.5	2.6H	.5L	3.0	7.6H	.8L	2
	CUT OFF	5.3H	1.2R	3.9	.3H	.6R	1.6	0	1.3R	4.2	4.0H	.5R	3.3	8.0H	.8L	
	STOCK	5.7H	1.3R	3.0	.6L	0	2.2	.2L	.6R	3.8	3.3H	0	3.1	7.8H	.8L	
		7.7H	1.1R		–	1.0R		2.0L	.4R		2.8H	–		6.3H	.8R	
180	Shldr	2.0H	0	1.7	1.8L	.5R	1.9	2.0H	1.0R	1.3	5.3H	1.5L	4.0	1.5L	2.8L	
	CUT OFF	2.1H	0	3.4	1.6L	.3R	1.6	2.1H	.7R	2.7	7.4H	1.5L	3.4	.5L	3.1L	
	STOCK	2.0H	0	2.5	1.7L	.4R	1.7	2.0H	.8R	2.0	6.3H	1.5L	3.7	1.0L	2.9L	
		1.0H	.2L		1.1L	1.4R		.2H	.6R		3.8H	1.5L		2.5L	.3L	
220	Shldr	1.3H	.6R	1.8	0	.7R	2.2	1.0L	1.3R	2.9	3.1H	.6L	3.1	3.6L	.2R	1
	721	1.1H	1.4R	1.8	0	1.5R	3.7	0	1.9R	2.3	3.1H	.3L	3.8	2.7L	0	6
	STOCK	1.2H	1.0R	1.8	0	1.1R	2.9	.5L	1.6R	2.6	3.1H	.4L	3.4	3.1L	.1R	8
		.2H	.8R		.6H	2.1R		2.3L	1.4R		2.6H	.4L		4.6L	.7R	
180	Shldr	2.0H	1.5R	2.9	.3H	.4R	1.8	3.2H	3.0R	1.0	8.5H	.8L	3.1	1.9H	0	1
	721	2.2H	1.9R	2.2	1.7H	1.4R	2.4	4.6H	2.6R	2.5	7.8H	.6L	1.9	2.8H	1.0R	
	STOCK	2.1H	1.7R	2.5"	1.0H	.9R	2.1"	3.8H	2.8R	1.7"	8.1H	.7L	2.5"	2.3H	.5R	
		1.1H	[illegible]		1.6H	1.9R		2.0H	2.6R		7.4H	.7L		.5H	[illegible]	

Gun No	Front	Rear	Point impact	DIFF
700116	-.0035	+.001	6" left	L [illegible]
700530	+.0025	+.0045	17" left	L [illegible]
700625	+.0025	-.009	5" left	R [illegible]
700452	-.010	-.005	5" left	[illegible]
700602	+.0105	+.004	9" left	R 0
700414	-.0015	-.011	6" left	R 0
700237	-.004	-.010	5" left	R.0
700210	+.002	-.006	10" left	R.0
700887	+.001	-.0005	8" left	R.0
701150	+.003 -.004	-.0085	8" left	R.0

℄ 2.949

Gun No	Base R	Base F	Left Eyepiece	Right Blade		
700414	3.140	3.127	2.887 L.025	3.004 R.002		
700530	3.142	3.124	2.913 [illegible]	3.009 R.013	.01	
700625	3.144	3.129	2.949 R.031	3.010 R.014	.0	
701150	3.136	3.121	✓ 2.904 L.007	2.989 L.007	.0	
700887	3.152	3.128	✓ 2.906 L.006	3.003 R.001	.0	
700116	3.156	3.127	2.927 R.015	3.007 R.011	.0	
700210	3.148	3.132	✓ 2.902 L.010	3.014 R.018	.0	
700452	3.141	3.125	✓ 2.921 R.009	2.996 0	.0	
700602	3.159	3.138	✓ 2.935 R.023	3.028 R.032		
700237	3.150	3.128	2.953 R.041	3.011 R.015	.0	

2.949
.200
3.149

2.949
.176
3.125

2.949
1/2 dt .037
2.912

2.949
1/2 bad .047
2.990

700414 −.009
530 −.007
625 −.005
150 −.013
887 +.003
116 +.007
210 +.021
452 −.008
602 +.010
237 +.001

+.002
−.001
+.004
−.004
+.003

MINUS - .002 OUT

Lens #	T.I.R.	L.O.R.R.	AMOUNT
700237	.115	R.035	
700812	.040	R.018	
700602	.097	R.010	
700452	.040	L.005	
700625	.085	.000	
700530	.035	R.017	
700414	.060	.000	
701150	.032	R.005	
700887	.130	L.030	
700116	.152	L.075	
700210	.056	R.004	

700414

checking Bbl
run out with O.D. Rec from chuck.
in M.R.

	No.	Top	Right	Bottom		Left	Tot.
5	700237	+.010	+.0055	+.060	R.060	+.065	.073
8	700887	+.053	+.033	+.016	R.013	+.040	.038
6	700116	+.022	+.028	+.053	R.015	+.043	.035
17	700530	+.036	+.036	+.034	L.001	+.035	.003
6	700414	+.024	+.024	+.056	R.004	+.048	.035
5	700625	+.038	+.020	+.038	R.030	+.052	.030
9	700602	+.025	+.020	+.053	R.030	+.056	.045
8	701150	+.042	+.025	+.030	R.001	+.049	.027
10	700210	+.029	+.014	+.044	R.045	+.059	.045
5	700452	+.022	+.026	+.055	R.002	+.048	.038

Hurley checks on outer gauge in 46-1

Relation breech ring with stud
1 1/8" from reciver

1/31 58

Gun no.	Right	Left
700530	3.439	3.396
700414	3.444	3.390
700602	3.409	3.426
700887	3.432	3.394
700210	3.420	3.412
700452	3.435	3.392
701150	3.424	3.412
700625	3.416	3.414
700237	3.451	3.382
700116	3.460	3.370

℄ – 3.270 of [illegible]

M/725-30-06 Comparison test 2/3/58

Clean, sight as tested in accuracy house.

M/725 Stock new sight	point of impact	Machine
700116 RS. Broken	0 - 0	6" left
700237	2" Rt. 2" low	5" left
700414	13" left 4" high	6" left
700530	24" left	17" left
700625	0 - 2" low	5" left
M/725 Stock - cut off.		
700116	2" HIGH	
700237	2" high 1" right	
700414	13" left	
700530	24" left	
700625	2" low	
M/721 Stock		
700116	3" Rt. 3" high	
700237	0 - 0	
700414	13" left	
700530	30" left 1"	
700625	2 high	

700116 sight Broken

Comparison test - M/725/30-06

M/725 Stock	Step	Point of impact	Page	Turns	square
700210	6	1" HIGH			
700602	6	0-0			
700452	6	1" HIGH 1" RT			
701150	5	0-0			
700887		2" HIGH			

M/725 Stock - cut off.

700210	3½ RT.
700602	4" HIGH
700452	2" HIGH
701150	0-0
700887	1" HIGH

M/721 Stock

700210	4" HIGH	3½ RT
700602	7" HIGH	2½ RT
700452	1" HIGH	1½ LEFT
701150	1" HIGH	4" RT.
700887	8" HIGH	2" RT.

M/725-30-06 Elevation check 6/18/58

Gun No	75.	step	point of impact	
5049	High	7	0	.062
3913	"	7	0	.062
4797	"	7	1 high	.058
4313	"	6	1 low	.044
4648	"	8	2 low	.098
5050	"	8	0	.089
5075	"	8	1 low	.093
5089	"	8	0	.089
5041	"	8	0	.089
5107	"	7	0	.062
5112	"	7	1 high	.058
5100	"	7	2 low	.071
5116	"	8	0	.089
5090	"	7	0	.062
5122	"	8	0	.089
4584	"	7	0	.062
5091	"	7	1 low	.066
5073	"	7	0	.062
4992	"	6	0	.040

$\frac{1345}{19} = 71$

Pellet - 725 - 22 cal cyl 2nd 9-4-58 Exam

Gun No	Hi	low	left	right	Group size	
step	(R stepped?)					Shoulder drop
5945 1	0	0		1.5	2.9	1.8
2	0	0		1.5	1.8	1.8
9 step						
5912 1	0	0	0	0	2.3	
(master gun) 2	1"			1"	3.3	↓
5934 1	0	0	0	0	1.6	1.7
6 step 2	1"			1.5	1.7	1.6
5893 1		1"	0	0	2.1	↓ .6
7 step 2	0	0	0	0	2.4	.8
5920 1		1"		1"	2.1	↓ 1.5
7 step 2		.5	0	0	2.8	1.3
5926 1		1"	1"		2.3	↓ 1.4
6 step 2		0	1.5		2.5	1.3
5887 1	0	0	0	0	2.1	
7 step 2	0	0	0	0	1.8	
5905 1	0	0	1"		1.9	
6 step 2		1"	2"		2.1	
5904 1		1"	0	0	.9	1.6
7 step 2		1"	0	0	1.7	1.7
						1.7
5957 1					ave 2.13	ave 1.45
2						

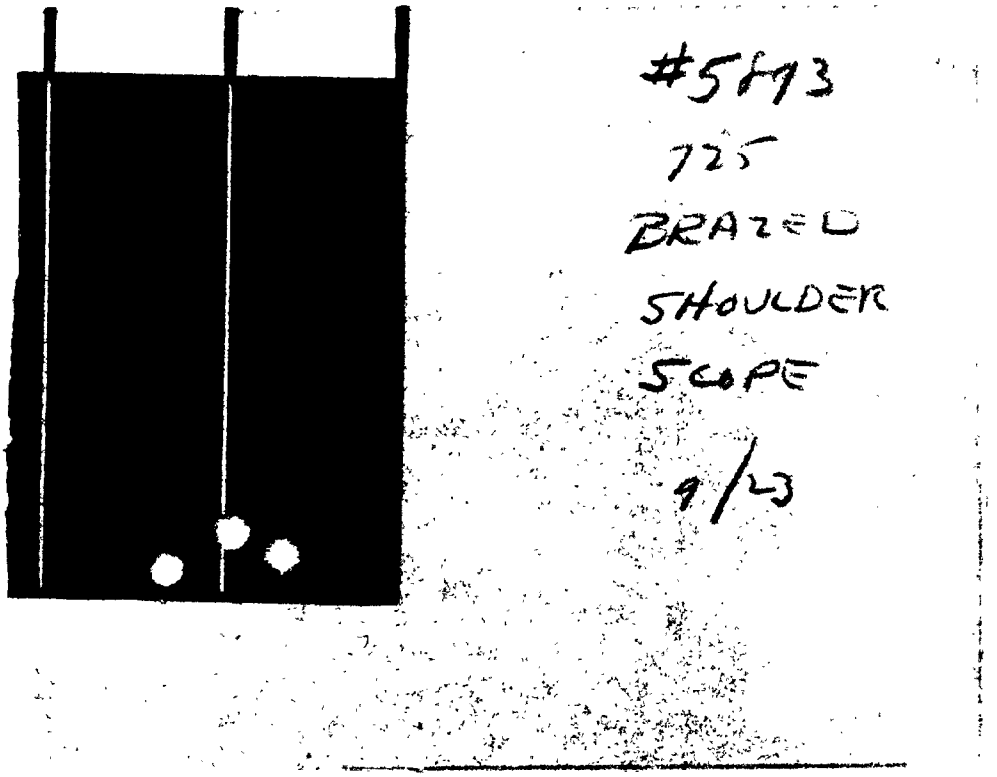
Fill Order

#5893

725 BRAZED

9/23

SHOULDER SCOPE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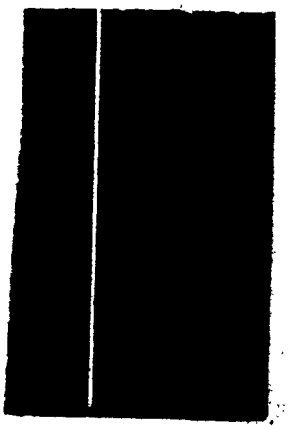
725
BRAZED
SHOULDER
SCOPE
9/23



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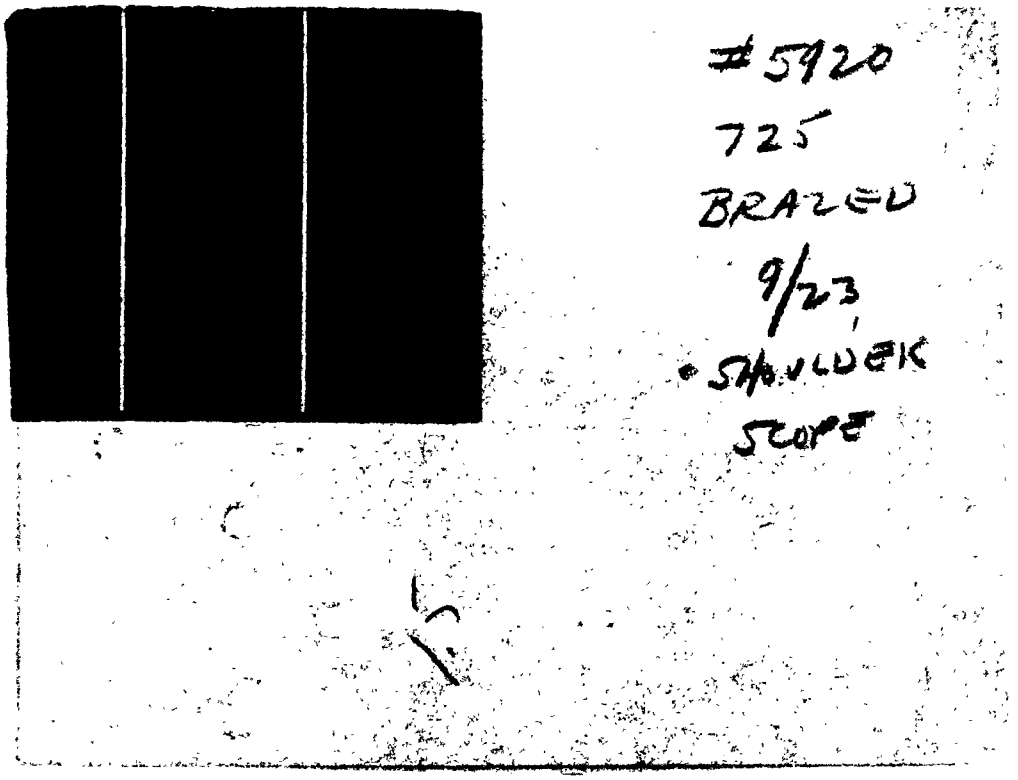
BRAZED
9/23
SHOULDER
SCOPE

M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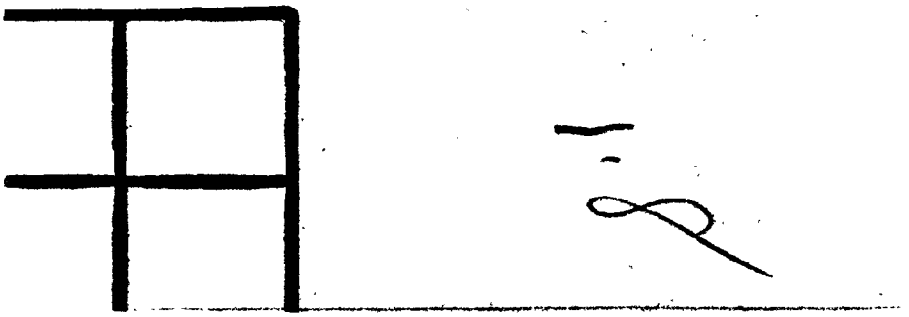
725
BRAZED
9/23
SHAVLOEK
SCOPE

5945
725
BRAZED
9/23
SHOULDER
SLOPE

Marksman



[redacted]

[illegible]

125 BRAZED

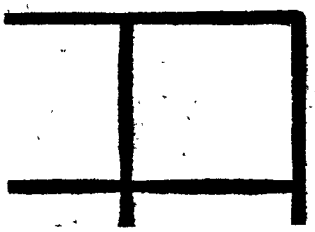
1/23 SHOULDER SCOPE

Marksman

#793V 725 BRAZED

1/23 SHAVDEK SCOPE

Markemen

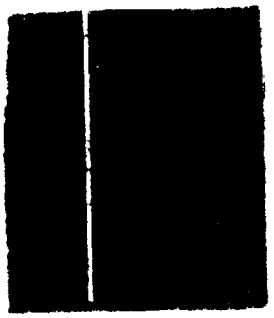


#593✓ 725 BRAZED
9/23 SHOULDER SCOPE

Marksman

#5151 /25 BRAZED
9/23 SHOULDER SCOPE

Marksman



#5957 725 BRAZED
9/23 SHOULDER
SCOPE

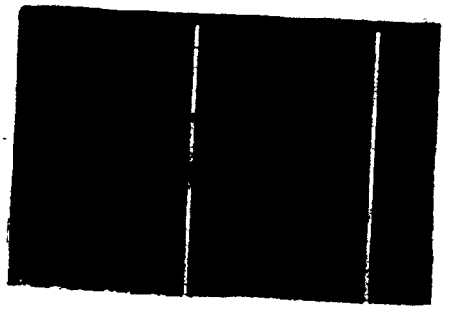
5151 725 BRAZED

9/23 SHOULDER SCOPE

Marksman

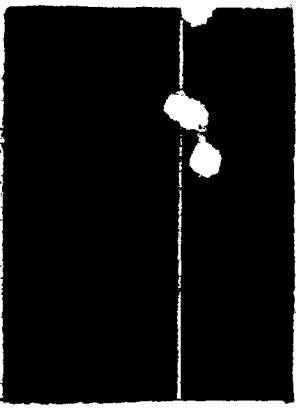
5426 725 BEAZED
1/23 SHOULDER SCOPE

1, 3



1 of

#5926 725
BRAZED
9/23
SHOULDER SCOPE



125. Elevation.

M/725-30-06 Point of impact - machine 2/27/58

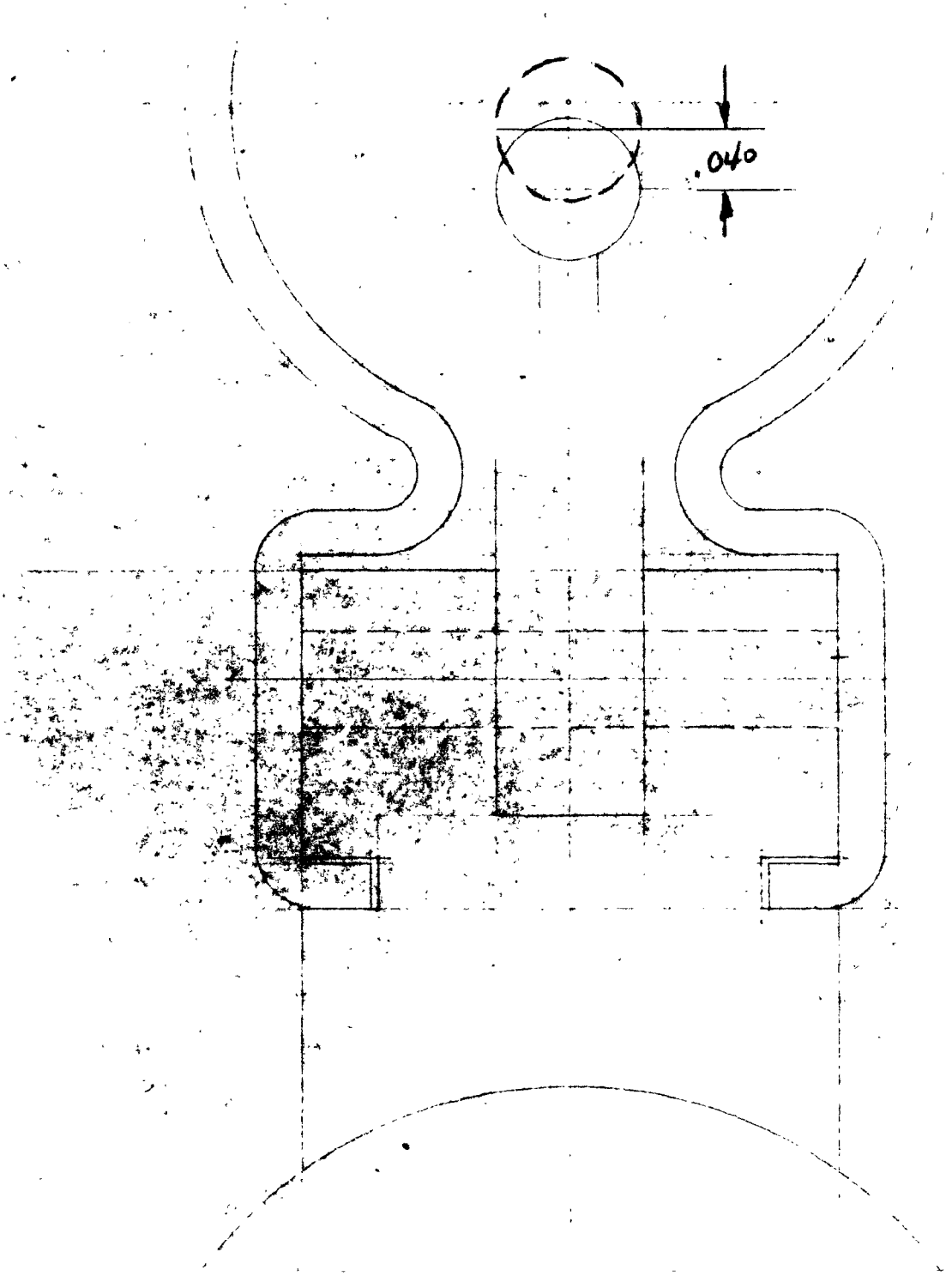
Rear sight eye pc high

Gun No.	Blade	Point of impact		step	turns left	R.S. eye pc sight range
702352	HI	5" low	✓	8.111	1¼	Right
702238	HI	4" low	✓	8.107	—	center
702325	HI	7" low 2" left	✓*	8.130 out of gage	¼	Right
702276	HI	8" left	✓	8.089	1½	Right
702107	HI	1 low 10 left	✓	8.093	1¾	Right
702091	HI	1 low 1 left		7.066	1½	Right
702229	HI	1 low 2 left		7.066	1¾	Right
700071	low	0-0		5.059	—	center
702322	HI	2 hi 1 left		7.051	1½	Right
701572	HI	2 left		7.062	1½	Right
702218	HI	1 hi 1 left		8.085	1¾	Right
701524	HI	0-0		6.040	1½	Right
702219	HI	1 low 2 left		7.066	1	Right
702290	HI	0-0		7.062	1¾	Right
701408	HI	1 left		7.062	1¾	Right
702094	HI	2 low 1 left		7.071	1½	Right
701708	HI	0-0		7.062	1½	Right
701847	HI	1 low 3 left		8.093	1½	Right
701463	HI	2" Rt		8.089	—	center
702122	HI	1 hi		7.058	1¼	Right
701586	HI	2 left		8.089	—	center
701636	HI	1 low		8.093	1½	Right
701816	HI	2 hi 1 left		8.080	1½	Right
701617	HI	0-0		7.062	—	center
702120	HI	1" hi		8.085	1½	Right
702015	HI	5" low	*	8.111	—	center
702090	HI	8 left		8.089 out of gage	½	Right

M/725-30-06 Point of impact - machine 3/3/5[redacted]
K 5 eye ke high

Gun No	Blade	Point of impact	step	inches left	5	pa
700966	hi	2 left 1 low	6 .044	2		
702395	hi	2 left 1 low	7 .066	1 1/4		
702059	hi	2 left 1 low	6 .044	1 1/2		
702019	hi	2 left	6 .04[illegible]	1 1/2		
702135	hi	3 left	7 .06[illegible]	1 3/4		
701897	hi	2 left	8 .094 gage	3/4		
702018	hi	2 left 1 low	8 .093	—		
702331	hi	2 left	8 .084	1/2		
702164	hi	2 low	6 .04[illegible]	1 1/2		
702009	hi	1 left 1 hi	8 .08[illegible]	1 3/4		
702385	hi	2 right	7 .06[illegible]	1 1/2		
700953	hi	2 hi	8 .080	1 1/2		
701410	hi	2 low	8 .09[illegible]	1		
701526	hi	1 hi	7 .05[illegible]	2		
701419	hi	2 low 1 left	8 .098	1		
701954	hi	2 left 1 low	8 .093 gage	1		
701603	hi	2 left	7 .06[illegible]	1 1/2		
702350	hi low RS	12 low *	8 .137	1/2		
702181	hi	7 low 2 left *	8 .120	1 3/4		
701990	hi	8 left	8 .09[illegible] gage	0		
702466	hi	6 left	7 .06[illegible]	2 1/4		
702386	hi	5 low 1 left *	8 .111	1 1/4		
702392	hi	6 left 2 low	6 .04[illegible] gage	1		

X-078


.040

1/13/58

M/725 - 30-06

SHOULDER SHOT

M/725 Shoulder - L Cart 11/13/58-
30-06 Cal.

H-HIGH
L-LOW-MILLED DEEP

GUN NO	STEP	POINT OF IMPACT	R.S. LEAF	TO GAGE	TURN LEFT
700764	5	.010 / HIGH	L	YES	2
700523	5	.014	0-0	L	"	1 1/4
700783	6	[illegible]	0-0	L	"	2 1/4
700793	5	.014	0-0	L	"	3
700495	7	.053	1" HIGH	L	"	1
700426	6	.061	0-0	H	"	1
700095	5	.041	1" LOW	H	"	2 1/2
700126	7	.053	1" HIGH	L	"	2
700491	6	.035	0-0	L	"	2

[illegible]

.036

9/13 · 58

M/725 — 270 CAL

MACHINE & SHOULDER SHOT

M/7-5-270 CAL Machine target 11/9/58

H - HIGH
L - MILLED DEEP

Gun no	step	Point of Impact	Rib leaf
700841	6	035	0-0	L
700354	4	035	0-0	H
700837	3	[illegible]	8" HIGH	H
700275	5	014	0-0	L
700279	5	045	0-0	H
701222	5	014	0 0	L
701102	3	-.008	8" HIGH	H
701101	3	.028	0-0	H
701109	3	.019	2" HIGH	H
700408	FRONT SIGHT RAMP OFF CENTER			
700243	5	018	0-0	H
701108	3	.028	0-0	H
701001 *	7	.057	0-0	L
701041	7	.057	0-0	L
700579	4	.038	0-0	H
701038	3	019	2"-RI-1" LEFT	H
701032	4	.029	2" HIGH	H
701007	6	035	0-0	L

* 111/1

.021

M/725 - 270 Cal - Shoulder - L Evans 1/3/58

NO	STEP	POINT OF IMPACT (mach chan in inches)			H-HIGH L-LOW - MILLED DEEP R S LEAF	TO GAGE	TURNS LEFT
00109	3	+7"	0-0	.025	H	YES	1 3/4
00101	5	-4½"	0-0	.18	H	"	3
00102	3	+3"	5 HIGH	[illegible]	H	NO	3/4
00222	6	-4½"	0-0	[illegible]	L	YES	2
00279	5	OK	0-0	.048	H	YES	2
00275	6	-4½"	0-0	.061	H	YES	1 3/4
00839	3	+8"	0-0	.028	H	YES	2
00354	5	-7¼"	0-0	[illegible]	H	YES	1 1/2
00841	7	-4½"	0-0	.057	L	YES	3

367/1 .341

These were target guns from the machine 1/9/58.

1-7-58

M/ 725 - 30/06

SHOULDER SHOT

.725 SHOULDER FIRING
COMMON SIGHTLINE 30-06 H - HIGH
L - LOW

GUN NO	STEP	POINT OF IMPACT	SIDE PULL
700067	8	1" HIGH 1" LEFT	L
700257	6 .051	0-0	L
700447	7 .051	8" LEFT	L
700068	6 .051	0-0	H
700069	7 .051	0-0	L
700191	6 .051	1" HIGH	L
700092	6 .065	1" HIGH	H
700088	7 .057	0-0	L
700103	6 .063	2" HIGH	H
700145	7 .051	0-0	L
700051	7 .050	1½" HIGH	L
700260	7 .053	1" HIGH	L
700062	7 .086	1½ HIGH	H
700204	6 .035	0-0	H

792/14 .057

ALL REAR SIGHTS OK ON WINDAGE GAGE

1/7/58

12/17/57

M/725 - 30-06

Machine Shot

225 Kwikum 30-06 12/17/57

			with .040 higher F.S.
4H	.038	4	7
7L	.057	6	7
7L	.057	6	7
5H	.048 ✓		7
5H	.048 ✓	5	7
7L	.057	6	7
6H	.069 ✓	6	8
5H	.048 ✓	5	7
6L	.035 ✓	4	6
5H	.048 ✓	5	7
7L	.057	6	7
7L	.057	6	7
7L	.057	.056	7
6L	.035 ✓	4	6
7L	.057	6	7

	Low Eyepiece	High Eyepiece (+.034)
8	.084	.118
7	.057	.091
6	.035	.069
5	.014	.048
~~4~~	4	.038
~~3~~	3	.028

12/2/57

M/725 - 30-06

Shoulder Shot - Polley - Evans - Simmons

M/725 by Polley (Adjusted 2 Hi 2 Lo) Over 2 Groups

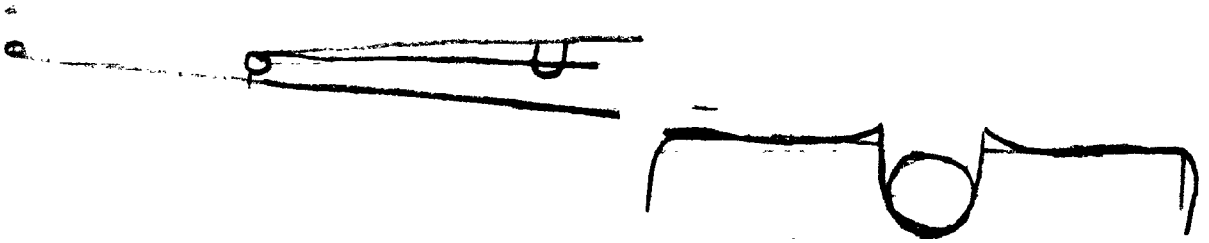
							#6 = 0			
0044	3/4 Hi	2 1/2 R	.040	8	0	9 1/2 Lo	+ .042	.000	−	.042
0012	1/4 Hi	1 1/4 R	.056	7	2 1/2 L	5 1/4 Lo	023	.011		.012
0035	1 Hi	3/4 L	.055	7	3 1/2 L	4 1/2 Lo	020	.015		.005
0005	1 1/4 Hi	3 R (adj)	.057	7	3 1/2 L	4 1/4 Lo	019	.015		.004
0010	1 Lo	3 3/4 R	.031	7	1 H	6 1/4 Lo	027	+ .004	−	.031
0004	1 1/2 Hi	1 L	.050	7	0	4 Lo	018	.000		.018
0009	2 1/2 Lo	3 1/2 R	.046	6	4 L	2 1/2 Lo	.011	< .004		.007
0014	1/4 Hi	2 1/4 R	.056	7	3 1/2 L	5 1/4 Lo	023	.015		.008
0046	1 1/4 Lo	2 1/4 R	.089	8	2 1/2 L	11 1/2 Lo	051	.011	−	.040
0011	1 Hi	2 R	.053	7	0	4 1/2 Lo	020	.000	−	.020
0038	1 Hi	1 R (adj)	.053	7	1 L	4 1/2 Lo	020	.004		.016
0037	1/2 Hi	1 1/2 R	.055	7	4 1/2 L	5 Lo	022	.020		.002
0048	1/2 Lo	4 R	.086	8	4 1/2 L	10 3/4 Lo	047	.020	−	.027
0024	2 Lo	1 1/2 R	.066	7	3 1/2 L	7 1/2 Lo	033	.015		.018
0050	3 Lo	4 R	.097	8	8 1/4 L	13 3/4 Lo	058	< .036	−	.022
0006	2 1/2 Lo	3 R	.068	7	1 L	8 Lo	035	.004	−	.031
0027	?	?	—	7	4 1/2 H			+ .020		
042	1 Lo	1/2 L	—	?	2 H	?		+ .009		

~~1/64 = .014~~
~~16 = .035~~
~~.064~~

.021

303/16
.019

#6 − .035 with high R.S appears.



Mod 725 Beshot of Polley by Evans

700012		2" - Hi		0	.045	7 step		3½
27		1" - low		0	.020	5 step		4½
24		1" - Hi		5 left	.060	7 step		3½
35		1" Hi		1 left	.060	7 "		3½
50	1 Hi	2" Hi	1L	0	.070	8 "		8¼
09		1" low		0	.040	6 "		1
42		2" Hi		0	.025	6 "		2 ✓
14		1" Hi		0	.050	7 "		3½
11	1 low	0"	1L	1 left	.035	6 "		0
10		1" Hi		0	.030	6 "		1
46		2" Hi		0	.045	7 "		2½
38		1" low		0	.040	6 "		1
44	0	0"	1R	1 Right	.035	6 "		0
06	1 low	1" low	0	0	.040	6 "		1
05		1" Hi		0	.050	7 "		3½
04	0	0	1L	0	.035	6 "		0
37		0		0	.055	7 "		3½
48	0	0	0	0	.055	7 "		3½

$\frac{770}{18}$ .043

½ Hi

target 725- Simmons

#700048 = 1" HI. — [redacted]" RIGHT	7	0	.055	
037 = [redacted]" HI. — 1" "	7	1H	.050	
004 - 0 — 0	6	1L	.040	
005 - 4 HI. — 2 "	7	3H	.040	
008 - [redacted] — 2 "	6	1L	.040	
044 - 1 HI. — 2 "	6	0	.035	
038 - 0 — 0	6	1L	.040	
046 - [redacted]" " — 0	7	1H	.050	
012 - 4" " — 0	7	3H	.040	
024 - 0 — 5 LEFT	7	1L	.050	
035 - 3" " — 3 "	7	2H	.045	
050 - 2½" 0	8	2H	.070	✓
009 - 0 — 0	6	1L	.040	
042 - 3" " — 0	6	2H	.075	
014 - 4" — 2 RIGHT	7	3H	.040	
011 - 1 LOW. 0	6	2L	.045	
027 - 0 — 0	5	1L	.020	✓
010 - 2 HI. 0	6	1H	.030	

$\frac{155}{14} = .04$

12½"

11"H

11"J

mod Restroot on M/725 Evans 12/1/57

044 —	0	1" R	4 step
040 4 —	0	1" left	6 "
048 —	0	0	7 step
006 —	1 low	0	6 "
011 —	1 low	1 left	6 step
050 —	1 Hi	1 left	8 step

Gun Number		Muzzle Pull		Stocks open at
700010	— 030	9	lbs	left side
" 11	— 035	40	lbs + still tight	left side
14	— 050	11	"	Both sides
42	— 025	13	"	" "
09	— 040	26	"	left side
50	— 070	9	"	left side
35	— 050	30	"	Both sides
24	— 050	24	"	" "
27	— 020	20	"	Right side
12	— 045	15	"	left side
9	— 040	12	"	Both sides
38	— 040	6	"	left side
44	— 035	40	" still tight	Both sides
06	— 040	25	"	left side
05	— 050	40	" still tight	left side
04	— 035	40	" " "	left side
37	— 055	40	" " "	left side
48	— 055	6	"	ok

M/725 - 30 - 06 corrected muzzle angularity 3/31/58
machine target - Repairs 4 M

Gun No	F.S	step	point impact	Turns left	Eye piece right or left
701979	high	7 .062	0 - 0	central	
700391	"	7 .062	0 - 1 left	"	
702153	"	7 .066	1 high - 1 left	2 1/2	left
702083	"	7 .062	0 - 1 left	2	right
702519	"	7 .062	0 - 0	2	left
702052	"	7 .071	2 high - 0	central	
702121	"	7 .071	2 high - 0	2 1/2	right
702419	"	7 .071	2 high - 0	central	
702434	"	7 .062	0 - 0	1 3/4	right
702284	"	7 .062	0 - 0	2	"
700694	"	8 .098	2 high - 5 left	2	" out
702401	"	7 .066	1 high - 3 left	2	"
701839	"	8 .085	1 low - 1 left	3	left
701020	"	7 .058	1 low - 0	central	
701839	"	8 .085	1 low - 1 left	"	
701020	"	7 .058	1 low - 0	"	
702171	"	7 .066	1 high - 1 left	"	
700895	"	7 .062	0 - 1 left	2	right
701214	low	7 .062	0 - 1 left	1 1/2	left
700065	"	7 .062	0 - 0	~~central~~ 1 1/4	left
700101	"	7 .058	1 high - 0	central	
700061	"	6 .048	0 - 0	1 1/4	right

144 - .068
.2

M/725 - 280 Cal
Machine target

3/28/58 G.M.

Shell No	75	Step	Point impact	Turns left	Eye piece right or left
702708	High	8 .089	0 - 1 left	2 1/4	right
702727	"	7 .053	2 high - 1 right	2	left
702739	"	6 .036	1 high - 0	2	right
702814	"	8 .107	4 low - 0	2 1/4	left
702757	"	5 .019	0 - 0	2	"
702718	"	7 .062	0 - 0	1 1/2	right
702722	"	5 .019	0 - 0	central	
702699	"	7 .062	0 - 1 left	"	
702866	"	7 .053	2 high - 0	2 1/4	left
702872	"	5 .019	0 - 3 left	1 3/4	right
702888	"	8 .080	2 high - 0	1 3/4	left
702778	"	6 .040	0 - 0	1 1/2	right
702690	"	6 .044	1 low - 0	central	
702916	"	5 .019	—	"	
702632	"	7 .053	2 high - 0	"	
702879	"	7 .066	1 low - 0	"	
702901	"	7 .062	0 - 1 left	"	
702653	"	8 .089	0 - 1 left	2	right
702726	"	7 .066	1 high - 0	central	
702808	"	7 .062	2 low - 0	"	
702730	"	7 .066	1 low 1 left	"	
702796	"	7 .066	1 low 1 right	"	
702760	"	7 .066	1 low - 0	2 1/2	left
702871	"	7 .062	0 - 2 left	1 1/4	right
702782	"	5 .019	0 - 0	2	"
702641	"	5 .023	1 low - 1 left	2	"
702638	"	6 .040	0 - 1 left	2 1/2	left
702634	"	7 .062	0 - 1 right	central	
702650	"	7 .062	0 - 0	"	
702876	"	5 .019	0 - 0	"	

[illegible] 225 - 280 Machine [illegible] 3/28/58

Gun #	[illegible]	Step	Point impact	turns left	eye pc right or left
702624	HIGH	7.066	1 low - 0	1 3/4	right
702795	"	7.053	2 high - 0	1 3/4	"
702671	" ×	6.040	0 - 1 left	2	"
702655	"	7.058	1 high - 0	2	"
702550	"	3.001	0 - 0	Central	
702691	" ×	7.066	1 low - 0	"	
702675	" ×	6.040	0 - 0	2	right
702720	" ×	8.080	2 high - 1 left	2	left
*702640	"	6.036	1 high - 0	1	right
702779	"	6.044	1 low 1 right	2 1/2	left
702668 ×	"	5.014	0 - 0	1 1/2	right
702823	"	7.062	0 - 0	Central	
702822	"	6.036	1 hi - 0	"	
702717	"	6.040	0 - 0	"	
702817	"	6.036	1 hi - 1 left	2	right
702795	"	6.044	1 low - 0	2 1/4	left
702867	"	8.084	0 - 0	central	
702660	"	6.040	0 - 1 left	"	
702677	"	7.058	1 high - 0	2	right

$\frac{906}{19} = 48$

$\frac{2491}{49} = 51$

M[illegible] - 30-06 Cal

6/17/58
4 m.

Elevation check

Gun [illegible]	F.S.	STEP	POINT IMPACT	
705[illegible]	HIGH	7	1" low	.066
704[illegible]	"	7	2" high	.053
70493[illegible]	"	7	1" low	.066
70512[illegible]	"	8	0	.089
70390	"	8	4" low	.107
70510[illegible]	"	7	1" high	.058
704[illegible]	"	7	2" low	.071
705[illegible]	"	7	1" "	.066
703[illegible]	"	7	2" high	.053
705[illegible]	"	5	1" high	.015
704[illegible]	"	6	1" "	.036
704[illegible]	"	8	1" "	.085
704[illegible]	"	8	2" low	.098
704[illegible]	"	8	2" low	.098
705[illegible]	"	7	1" low	.066
705[illegible]	"	7	0	.062
705[illegible]	"	5	1" high	.015
705[illegible]	"	8	0	.089
704[illegible]	"	8	5" low	.111
705[illegible]	"	7	2" low	.071

$\frac{1375}{20} = .069$

M/725 - 30-06 CHECKED FOR ANGULARITY AT MUZZLE 3/29/5[redacted]

MACHINE TARGET

700950 [illegible] FROM SHOULDER NO CHANGE - L EVANS

	F.S	STEP	POINT IMPACT	TURNS LEFT	EYE PC LEFT [illegible] RT
700945	H1	7	3 hi 1 left	2 1/4	Right
700980	H1	8	0 - 10 left	1 1/4	Right
STRAIGHTEN FRONT SIGHT NEW REAR SIGHT			4 1/2 left (to limit on gage)		
700888	H1	7	0 - 6 left	2 1/4	Right
702267	H1	7	0 - 1 left	2	Right
700981	H1	5	1 hi - 6 left	1 3/4	Right

	Base alignment	Shot	T.I.R.	2 1/2" plug Angularity Muzzle	Direction
700980	left +.007 rear	4 1/2 left	.009	low	Left
F.S. BLADE -.004 LT					
700888	" +.018 Rear	6 left	.006	low	Slightly left
.001 RT					
700981	" +.007 rear	6 left	.0045	low	Slightly left
F. [illegible] .012 RT					

/715 STRAIGHTENED AT MUZZLE
30-06 Machine (Polley)

Angularity at muzzle corrected to "0" to .003 [illegible]
3/20/58 - by CH Moore [illegible]

Gun No		STEP	POINT IMPACT	TURNS	EYE PC RIGHT	EYE PC LEFT
702038	LOW	8	2 HI 6 LEFT	2½	-	
702050	HIGH	7	1 LOW 6 LEFT	2	-	
702156	"	6	2 LOW 5 LEFT	3	-	
702109	"	5	1 LOW 5 LEFT	1¾	-	
702387	"	6	0-0	1¾	-	
702436	"	7	0 0	1¼	-	
701482	"	7	0-0	2	-	
701905	"	7	1 LOW 1 LEFT	2	-	

1st

.25-
30-06

angularity at muzzle
corrected to 0 to .003 Rt.
by C. Morse

3/20/58

702038 - 1 left - 0

701482 - 1 low - 0

701905 - 0 - 0

702387 - 0 - 0

Shoulder L Evans
front sight squared

702156 - 0 - 0

2nd

702109 - 0 - 0

702050 - 1 left 1 high

702436 - 0 - 0

Re target - machine - L Evans

Gun No	F.S.	Step	Point impact	turns left	Eye Piece	Gage adjustment left	
702038	low	6	6 left	2 1/2	Right	.012	X
701482	high	7	0-0	2	"	.005	✓
701905	"	7	0-0	1 3/4	"	out of gage .005 B.I.	✓
702387	"	6	2 left	2 1/4	"	.000	✓
702156	"	6	2 hi 1 left	3	"	.010	✓
702109	"	6	2 hi	2	"	.005	✓
702050	"	7	5 hi 2 left	2 1/2	"	.018	✓
702436	"	7	2 hi 2 left	1 1/4	"	.004	✓

3rd

725 accuracy

REMINGTON ARMS COMPANY INC.

ENGINEERING DEPARTMENT DU PONT COMPUTATION SHEET

M/725-30-06 BBLS RE-STRAIGHTENED

COMPUTER G.M. DATE 3/13 58

Gun No	Point of impact 1st test	Point of impact after re-straighten
506	6 left	OK
129	6 "	OK
798	5 "	OK
871	6 "	OK
715	6 "	OK
548	6 "	5 left
974	8 "	OK
428	6 "	6 left
570	8 "	6 left
932	8 " 8 low	18 low
286	8 "	8 left
090	8 "	5 "
544	8 "	5 "
812	6 "	6 "
438	8 "	OK

8 rejects — out of 15 — 53%

3 — 33%

rejects from

Good accuracy

3/3/58
G.M.

Gun No 702015

Point of impact - Mch - 5 low
shoulder - L Evans 6 low

angularity at muzzle .012
direction - low

Gun No - 702521 Bbl furnished by E. Stuart
Point of impact - ? left 3 ft - L Evans

angularity at muzzle - .046
direction - left.

M/725 · 30-06 - Repairs corrected for angularity at muzzle

[illegible]	[illegible]	Step	Point impact	Time left	Eye Pc	left on page
702087	High	7 [illegible]	1 hi - 0	2	Right	.005
702543	"	6 [illegible]	[illegible] ✓	[illegible]	"	.000
702503	"	8 [illegible]	[illegible]	2½	Central	
702502	"	7 [illegible]	0 - 3 left	3	"	
702048	"	7 [illegible]	0 - 3 left	3	Right	.008
702528	"	7 [illegible]	1 hi - 0	2¾	"	.015
701907	"	7 [illegible]	1 hi - 0	2¼	"	.000
702453	"	7 [illegible]	2 hi - 2 left	2	"	.000
702442	"	7 [illegible]	0 - 0	1¾	"	.003
702384	"	6 [illegible]	2 low - 0	2	"	.000
702378	"	6 [illegible]	1 low - 0	3	"	.010
702155	"	6 [illegible]	0 - 1 left	2	"	.000
700424	"	7 [illegible]	2 low - 0	1¾	"	.000
702620	low	7 [illegible]	1 hi - 3 left	1¾	"	.005
702256	high	7 [illegible]	0 - 0	1	"	.000
702144	"	8 [illegible]	1 hi - 0	1¼	"	.005
701776	"	7 [illegible]	0 - 0	1¼	left	.000
700235	"	7 [illegible]	0 - 0	2¼	right	.010
702101	"	7 [illegible]	0 - 5 left ✓	1½	"	.000
702408	"	6 [illegible]	1 low - 0	1	"	.000

[illegible] .065

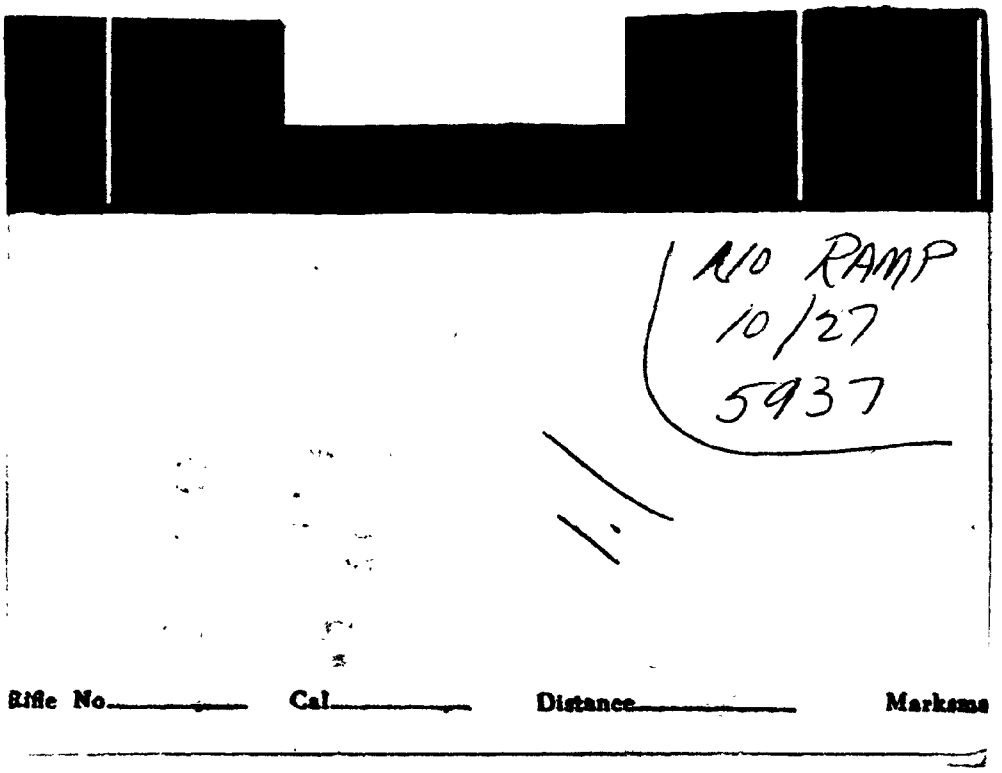
5/24/58

[illegible]

3/27

725 - 222 grouping bright barrels w/o FS ramps

5937	.9	1.1
5954	1.3	1.7
5896	1.2	1.7
5916	1.4	1.3
5927	1.3	1.5
5925	1.4	1.2
5826	1.0	1.7
5891	.8	1.1
200		1.3


A/O RAMP
10/27
5937
Rifle No.
Cal.
Distance
Markema

No RAMP
10/27
5937

9

Cal. Distance Marksman

NO RAMP
10/27

5891

NO RAMP 10/27

5891

1.1

NO RAMP
10/27
5954

13

NO RAMP
10/27
5954

NO RAMP 10/27
5896

N

NO RAMP 10/27
5f96

NO RAMP 10/27
5916

No RAMP 10/27
5916

NO RAMP 10/27
5927

13

Marksman

NO RAMP 10/27
5927

arksman

NO RAMP 10/27

5925

NO RAMP

10/27

5925

12

NO RAMP

10/27

5826

NO RAMP 10/27

5 of 26

11/8/58

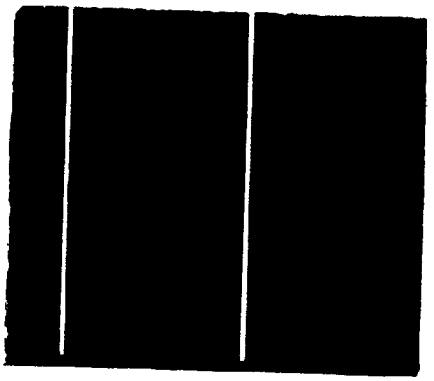
725 - 222 grouping bright barrels with hooded F.S Ramps

5937				
5954	1.1	.6		
5896	1.5	1.2		
5916	1.5	1.5		
5927	.9	1.5		
5925	1.1	1.5		
5826	1.4	1.4		
5891	1.1	1.8	2.3 (6 shots)	1.7

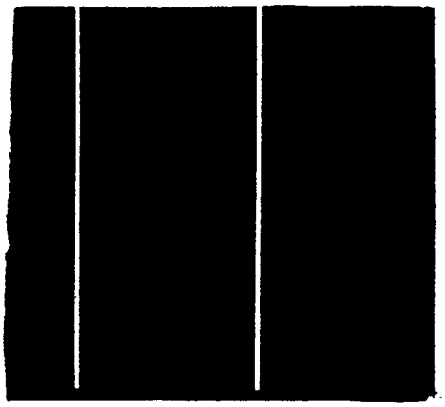
16 ⟌ 22

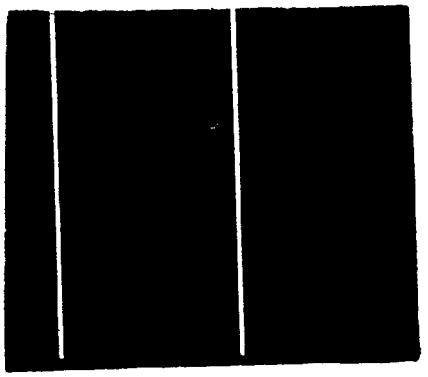
1.4

	145	
7620	.8 1.5	
[illegible]	.8 [illegible]	1.17
[illegible]	1.05 1.1	1.05
[illegible]	.7 [illegible]	.70
14135	.5 1.2	.85
	Cwt.	1.005

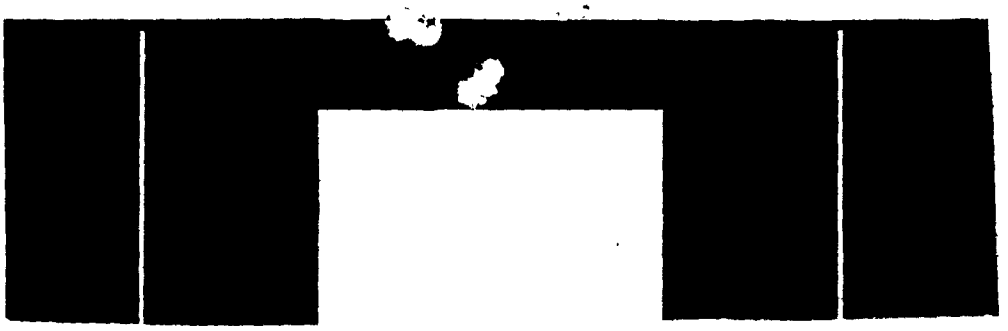


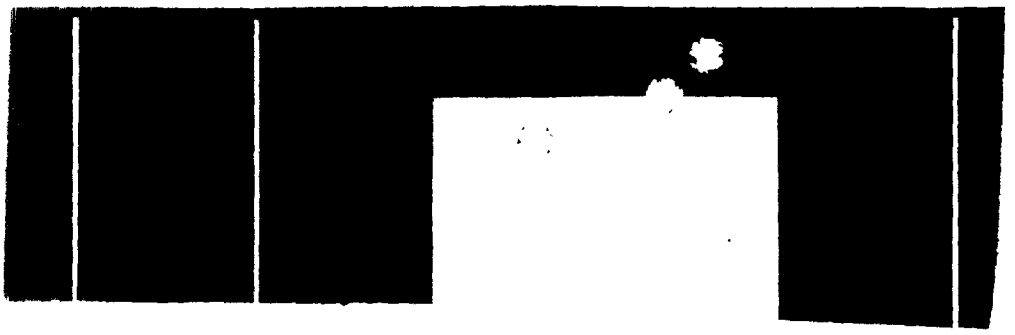
134.

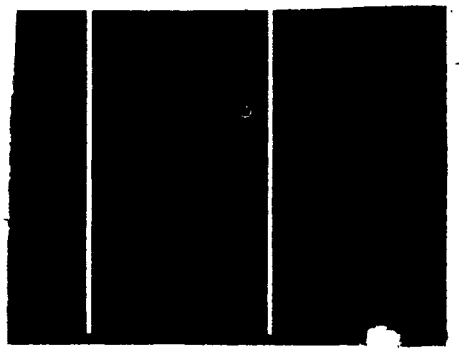


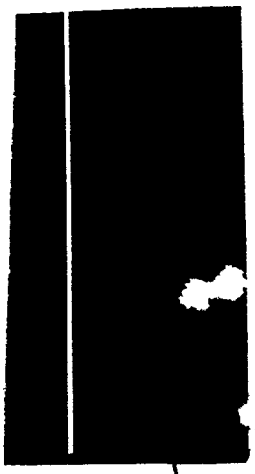


722
PLANT RAMP
10/28





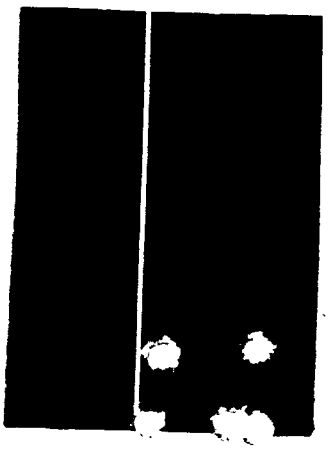




[illegible]

[illegible] RAN[illegible]

10/2[illegible]

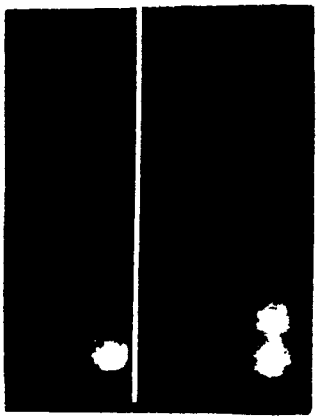


#5.11

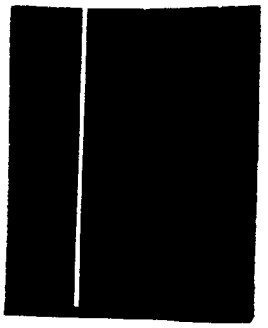
7E

10/20

sh



Marksman



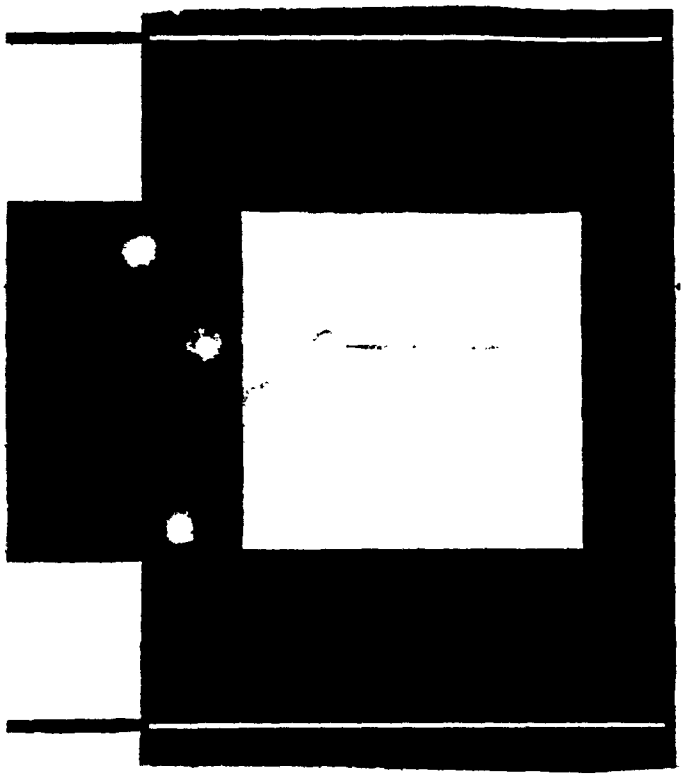
#1 [illegible]

PLANT RAMP
11/23

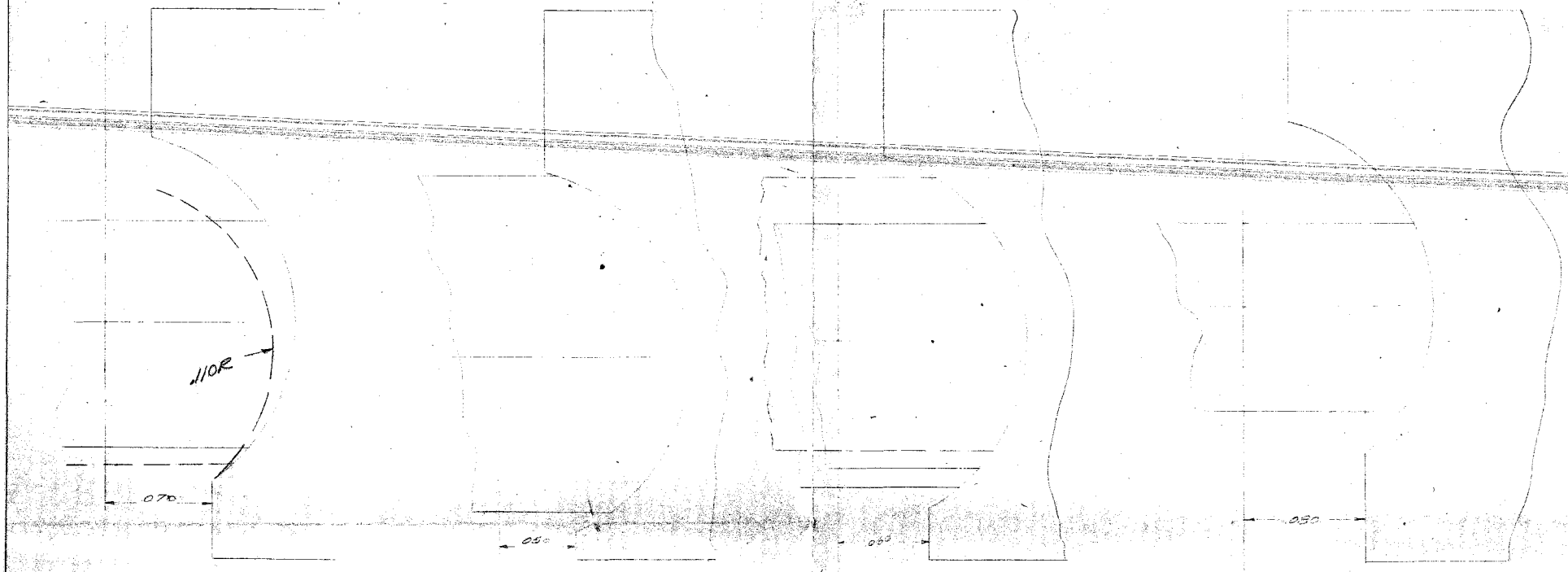
1/2

5731
BRAZED
RAMP
11/21

5937
BRAZED
RAMP
11/21



5981
BRAZED
RAMP
11/21



.300 BORE .598 O.D. B-74983-W TOOL .232 ℄ OF RAD	.213 BORE .658 O.D. B-74983-V TOOL .210 ℄ OF RAD.	DASH LINE .300 BORE .658 O.D. B-74983-T TOOL .222 ℄ OF RAD	SOLID LINES .252 & .273 BORE .598 O.D. B-74983-T TOOL .222 ℄ OF RAD	.351 BORE .598 O.D. B-74983-S TOOL .244 ℄ OF RAD.
30-06 300 SAV 308 WIN	.222 .244	300 MAG	.257 .270 .280	.35 REM

SCALE - 20 TO 1

NEED FOR ABOVE PLUS .270 .280

DETAIL NO.	MATERIAL SPEC.	STOCK SIZE	AMOUNT REQ.

TOLERANCES NOT OTHERWISE GIVEN
1 PLACE (.1) – TOLERANCE ± .05
2 PLACE (.01) – TOLERANCE ± .015
3 PLACE (.001) – TOLERANCE ± .0005

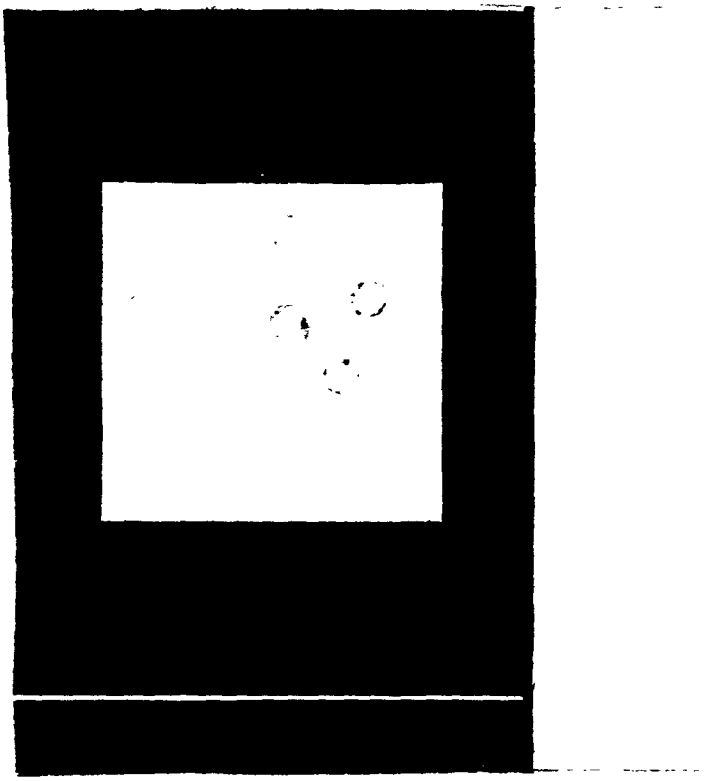
DO NOT SCALE DRAWING

RECORD OF ALTERATIONS	ADDITIONAL USES	CONST'N DWG.
		DETAILS

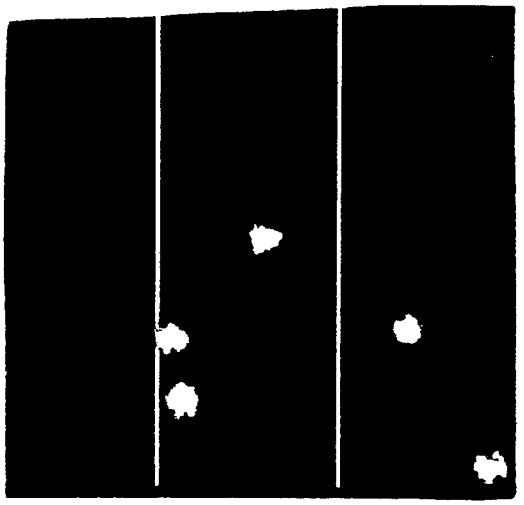
REMINGTON ARMS COMPANY, INC., ILION, N. Y.

SCALE	MODEL	PART DWG. No.			
PART					
TOOL					
OPERATION					
DESIGNED	BY	DATE	APPROVED	BY	DATE
DRAWN			SUPD'S DWG. No.		
CHECKED			DRAWING No.		

Form R. D. 5202-Rev. 4

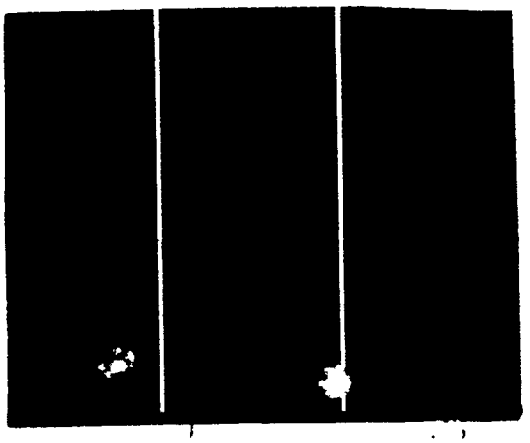


5981
BRAZED
RAMP
11/21



5F91
BRAZED
RAMP
11/18

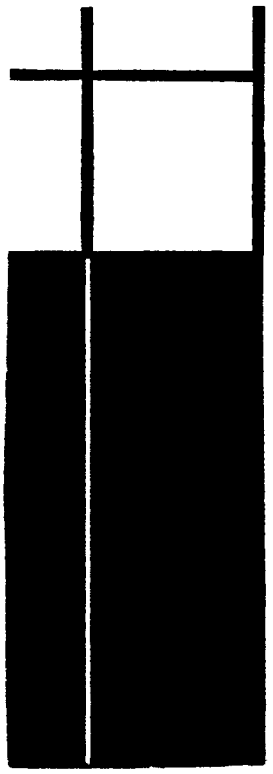
1.7



5891
BRAZED
RAMP
11/18

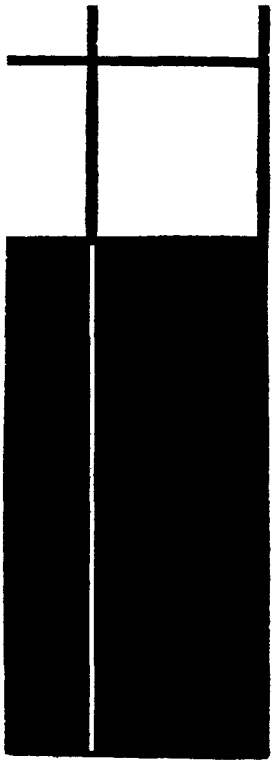
6 shots?

2.3



5891
BRAZED
RAMP
11/18

1.1



5891
BRAZED
RAMP
11/18

1.8

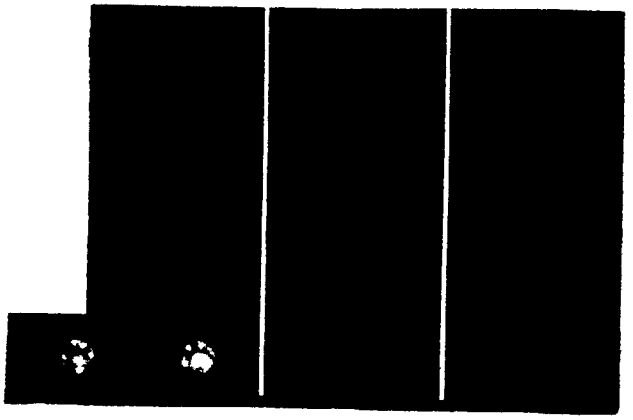
5826

BRAZED RAMP

11/18

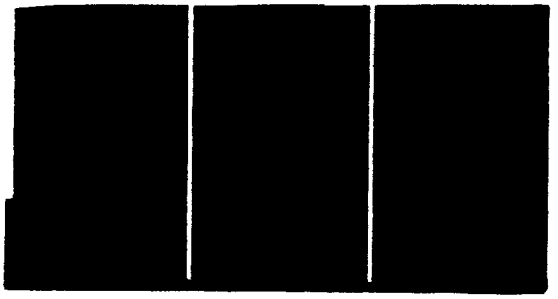
Distance _____ Marksman _____

1.4



5876
BRAZED RAMP
11/18

1.4

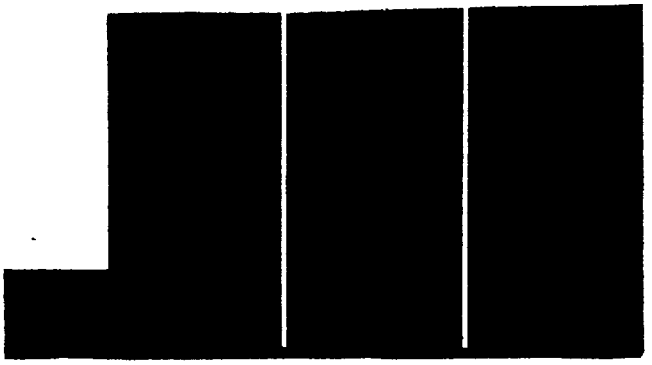


5925

BRAZED RAMP

11/18

1.1



5925
BRAZED
RAMP
11/18

1.5

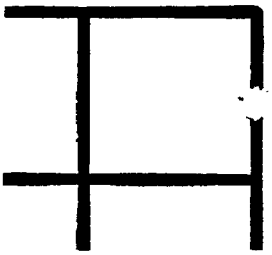
5927
BRAZED RAMP
11/18

ksman

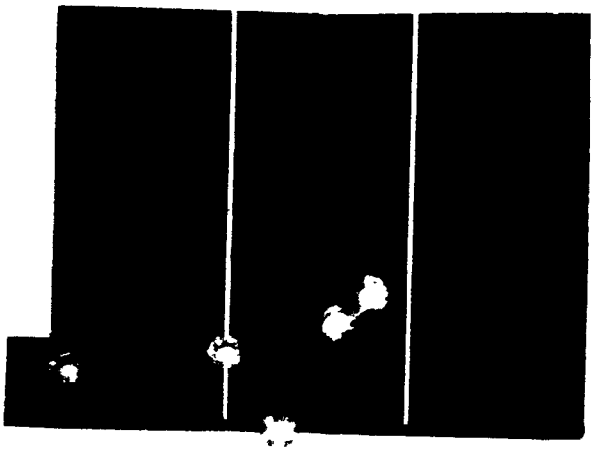
.9

5927
BRAZED
RAMP
11/18

arksman

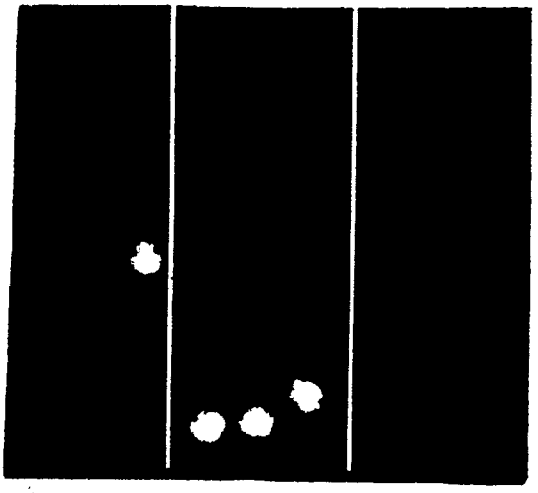


1.5



5916
BRAZED
RAMP
11/16

1.5



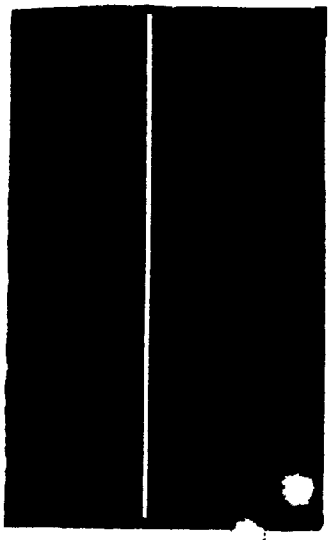
5916
BRAZED
RAMP
11/18

1.5

5896

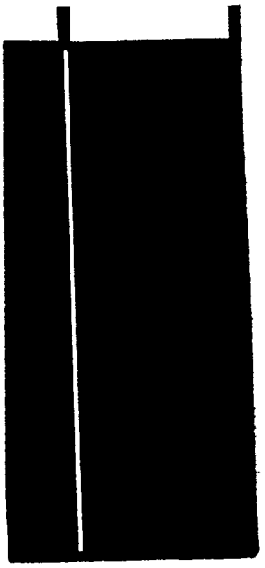
BRAZED
RAMP
11/18

1.5



5896
BRAZED
RAMP
11/18

1.2



5954

BRAZED RAMP

11/18

1.1

5954
BRAZED RAMP
11/18

.6

CC: R. A. Williamson
H. J. Hackman
R. B. Hurley
R. E. Wright
J. Henry
Area Auditor
File

Ilion, New York
June 16, 1959

D. GARLOCK

MACHINE STUDY
WHITNEY H/M #3109
M/725 TRIGGER GUARD #24196
OPER. 12 - MILL FLOOR PLATE CLEARANCE

Purpose: To measure machine capability and classify.

Observation: Operation appears to be controllable.

Note:

1. Distribution pattern (depth of cut) is towards the max. side of the tolerance. It is suggested that the job be set closer to the mean of the tolerance.

2. The parts reflected in this study were run Friday, 6/12, in the afternoon. It was reported by the auditor that an audit made Monday A.M., 6/15, showed that the measurement pattern had drifted beyond the max. limit with all pieces out of gage. It is further suggested that the frequency for checking this characteristic be reviewed.

Method: Thirty (30) parts were taken in sequence from the machine and checked with gages specified for the job.

QUALITY CONTROL DEPARTMENT
A. D. Gordon, Supervisor

by F. Macrina
F. Macrina

FM:I

QUALITY CONTROL DEPT
6-12-59
F. M.

R D-6360A

PRODUCT CONTROL CHART

OPER. NAME MILL FLOOR PLATE CLEARANCE

MOD NO 725 PART NAME TRIG GUARD PART NO 24196 MACH. NO 3109 OPER. NO 12

GAGE NO D-2-390 DIMEN .468-.475 CHARACTER DEPTH OF CUT

PLUS DIAL ADJUSTER

M/D DIMENSIONS

DIAL READINGS

PLUS + 3½ 3 2½ 2 1½ 1 ½ 0 ½ 1 1½ 2 2½ 3 3½ MINUS −

.475

468

SPREAD

AVERAGE

$\bar{X}$

CLER.

N = 30
$\bar{X}$ = .4744
σ = .0005

COMMENTS

GAGE NO D-2-321 DIMEN 2.490-2.520 CHARACTER POSITION OF CUT FROM HOLES

M/D DIMENSIONS

DIAL READINGS

PLUS + OK 0 MINUS −

SPREAD

AVERAGE

(1) [illegible] 6/26
(2) [illegible]
(3) Hurley

CC: R. A. Williamson
H. J. Hackman
~~R. B. Hurley~~
~~E. B. Croop~~ 6/26
R. L. Wright
Auditor
File

Ilion, New York
June 25, 1958

R. G. FERRIS

M/725 TRIGGER GUARD (LONG) #24196

Purpose: To check the relative positions of the hinge pin hole, latch pin hole and depth of latch slot after alteration to drill jig. Parts now locate on screw holes and latch slot instead of screw holes and top of guard.

Observation: The new method of location has resulted in a marked improvement on the characteristics measured.

A. Pos. hinge pin hole as measured from rear guard screw hole is well within model drawing tolerance.

B. The variation in the position of the latch pin hole from the hinge pin hole has been reduced from .012" to .003" but is still not within model drawing limits of ± .001". It appears that a tolerance of ± .0025" is needed for control.

C. Depth of latch slot is well within the model drawing limits of ± .005".

QUALITY CONTROL DEPARTMENT
A. D. Gordon, Supervisor

by A. B. Paulsen
A. B. Paulsen

ABP:I

K - 6260A

PRODUCT CONTROL CHART

6/23/58
#13

OPER NAME

MOD No 725 PART NAME Trig Guard PART No 24126 MACH No OPER No 8

GAGE No. DIMEN CHARACTER

M/D DIMENSIONS — PLUS + / DIAL READINGS / MINUS −

"A"	"B"	"C"
6.858	4.611	.2835
6.859	4.611	.2835
6.860	4.612	.2835
6.859	4.609	.2825
6.858	4.610	.2845
6.857	4.610	.2825
6.858	4.611	.2835
6.858	4.611	.2835
6.858	4.611	.2835
6.859	4.611	.2835

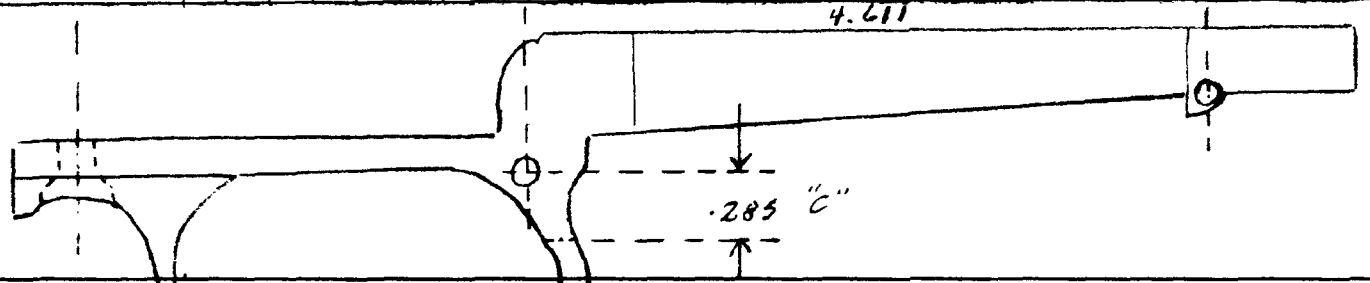
SPREAD

AVERAGE

"A" 4.860±5

"B" 4.609 4.611

COMMENTS



GAGE No. DIMEN 6.860±5 CHARACTER Pos. Hinge Pin Hole From Rear Guard Screw Hole "A" of Sketch

M/D DIMENSIONS — PLUS + / DIAL READINGS / MINUS −

HT. Gage

6.865 — 5

4 3 2 1

6.860 — 0

1 2 3 4

6.855 — 5

TOL

$\bar{X}$

N=10

$\bar{X}$=.6584

SPREAD

AVERAGE

R 2 6360A

PRODUCT CONTROL CHART

4/23/58
GJB

OPER NAME

MOD No 725 PART NAME Trig. S[illegible] PART No [illegible] MACH No OPER No

GAGE No. HT Gage DIMEN 4.609-4.611 CHARACTER Pos Latch Pin Hole from Hinge Pin Hole

"B" of Sketch

M/D DIMENSIONS — PLUS — DIAL READINGS — MINUS

4.611
4.610
4.609

2 1 1 1 1 1 1 1 1 1 1 2

$\bar{X}$

Tol.

N = 10
$\bar{X}$ = 4.6107
σ = .0007

SPREAD

AVERAGE

COMMENTS

GAGE No. HT Gage DIMEN .285 ± 5 CHARACTER Depth of Floor Plate Latch Slot from Hinge Pin Hole

M/D DIMENSIONS — PLUS — DIAL READINGS — MINUS

.290
.285
.280

5 4 3 2 1 0 1 1 1 1 2 2 3 3 4 5

$\bar{X}$

Tol.

N = 10
$\bar{X}$ = .2833

SPREAD

AVERAGE

S.M. Alois
H. L. Hamister
E. Sapp

P. E. & C. ESTIMATE

TO: H. J. Hackman

ESTIMATED BY: R. R. Hurley - V. G. Ge Berg

MODEL 721-722 PROJECT NO. DATE 6/26/58

PROJECT TITLE Estimate to provide hunte carlo stock with check piece for model 721-722 gun using "TC" Grip Cap and screw with model 725 Aluminum Butt Plate

	HOURS	RATE	TOTAL
PROCESS ENGINEERING & TRIAL RUN			700
TOOL DESIGN FIXTURES - GAGES 88			400
TOOLING FIXTURES - GAGES 445			2200
TOOL DESIGN — PERISHABLE TOOLS			20
TOOL DESIGN REVISIONS 75 + 10%			400
PERISHABLE TOOLING			100
TOOL REVISIONS 375 + 10%			2[illegible]
TOOL REVISIONS - PERISHABLE			20
TESTING			0
ADMINISTRATION			60
~~VENDOR TOOLING COSTS (DIES ETC.)~~ Machinery			4000
VENDOR TOOLING NOT REMINGTON PROPERTY			0
SUB TOTAL			10000
CONTINGENCIES			1000
			11000

COMMENTS 10 hrs to check machine capacity of 2" arm Router
If change on profile to servo mechanism is not made tooling would be increased $2000 for a steel master and former and sanding costs would be increased

CC: H. J. Hackman
R. A. Williamson
R. B. Hurley
P. B. Croop
W. A. Best
A. D. Gordon
R. G. Ferris
R. E. Wright
Auditor
File

Ilion, New York
April 21, 1958

D. GARLOCK

M/725 TRIGGER GUARD (LONG) #24196

Purpose: To check the relative positions of the hinge pin hole, latch pin hole and depth of latch slot relative to the problem "latch rotates too far forward at the top when the Floor Plate is in the open position".

Conclusions: The above problem occurs when the distance from the latch pin hole to the bottom of the latch slot is too great. This condition will not permit the latch to stop on the bottom of the slot as intended. Capital letters below refer to charted data attached.

A. The hinge pin hole (front) as measured from the Rear Guard Screw hole is well in tolerance per model drawing.

B. The distance from the hinge pin hole rearward horizontally to the latch pin hole varies from -.005" to +.007" versus a model drawing specification of ±.001". This could be a contributing factor in the problem as stated by changing the relationship of the hole to the bottom of the slot at the rear.

C. At the same time, the vertical position of the latch pin hole is toward the top of the Guard and averages on the extreme max. limit with some parts significantly beyond specification. This also is a factor.

D. The depth of the latch slot is well in model drawing tolerance but tends to be on the deep side.

Conclusions: (Cont'd)

E. The distance from the latch pin hole to the bottom of the slot is indicated as .275" to .295" per model drawing. In the ten parts measured, two Guards measured .013" and .018" beyond the max. depth.

Recommendations:

The problem appears to be essentially related to the position of the latch pin hole. It is recommended:

1. That the drill jig bushings be checked for size.

2. That a better technique for removing the casting flash from the top of the Guard to prepare the surface for more consistent location be considered.

3. In lieu of Item 2, that a change in the drill jig locator be considered. It is suggested that the ledge in the top inside of the Guard might be used. This would require a new locating block in the drill jig. There are no position gages requiring alterations.

Quality Control Dept.
A. D. Gordon, Supv.

by N. W. Menard

NWM:I

QUALITY CONTROL DEPT
4-14-58
F.J.H.

1—

PRODUCT CONTROL CHART

OPER NAME _____

MOD No 725 PART NAME TR. GUARD PART No 24196 MACH. No _____ OPER. No _____

GAGE No. _____ DIMEN _____ CHARACTER _____

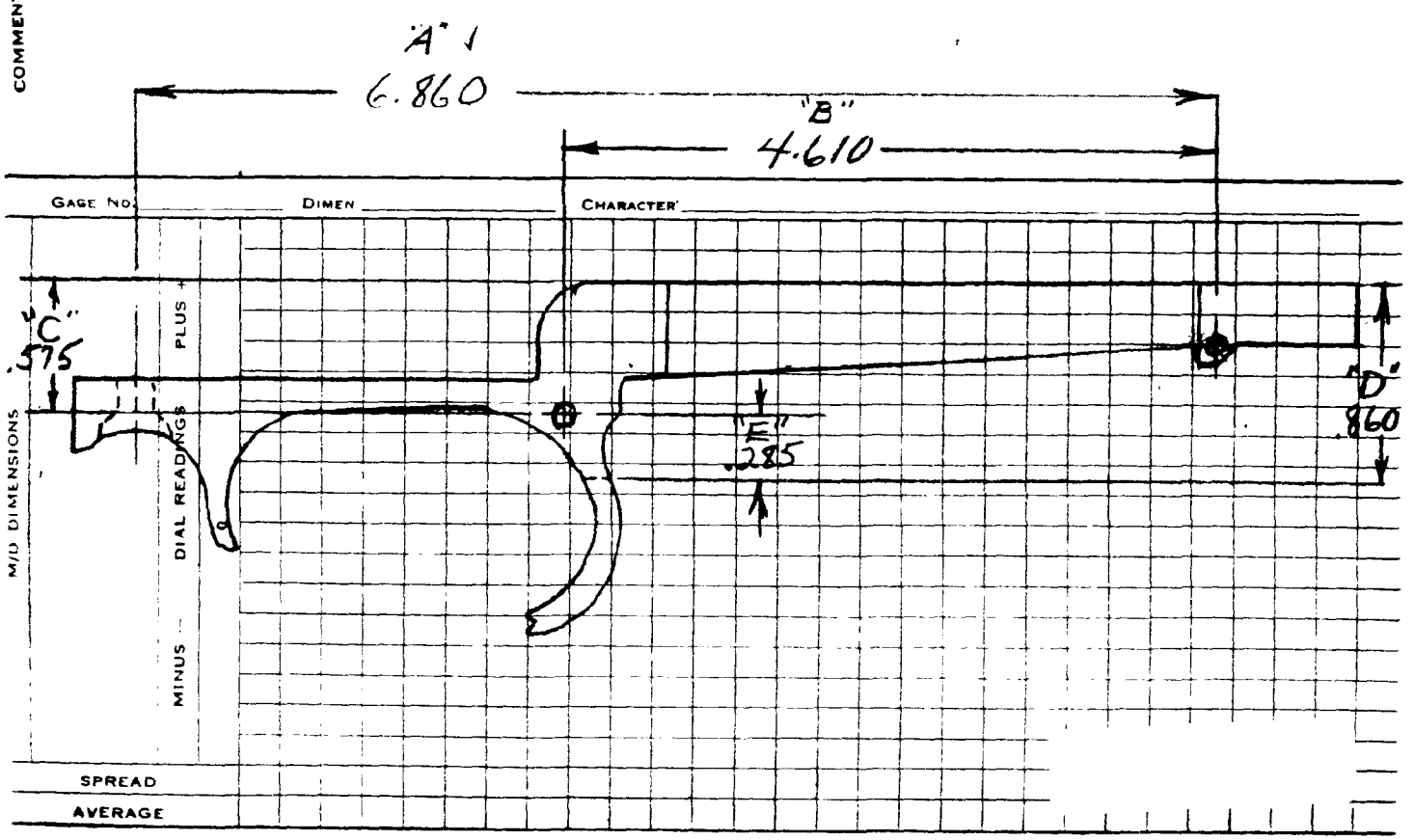
M/D DIMENSIONS — PLUS + / DIAL READINGS 0 / MINUS −

"A"	"B"	"C"	"D"	"E" DIFF. C & D
6.864	4.607	.558	.865	.308
6.861	4.608	.570	.863	.293
6.864	4.617	.550	.863	.313
6.862	4.605	.570	.862	.292
6.860	4.611	.569	.861	.292
6.860	4.607	.570	.863	.293
6.864	4.612	.571	.862	.291
6.861	4.609	.571	.863	.292
6.862	4.611	.568	.861	.293
6.863	4.609	.570	.860	.290

SPREAD

AVERAGE

COMMENTS



QUALITY CONTROL DEPT
4-17-58
F.J.M

2-

R D E 360A

PRODUCT CONTROL CHART

OPER. NAME _____

MOD No 725 PART NAME TR. GUARD PART No 24196 MACH No _____ OPER No _____

GAGE No. HEIGHT GAGE DIMEN 6.860 ± .005 CHARACTER POS. HINGE PIN HOLE FROM REAR GUARD

AND .093 PLUG

SCREW HOLE "A" OF SKETCH

M/D DIMENSIONS

6.865	PLUS +	5	
		4	IIII
		3	I
		2	II
		1	II
6.860	DIAL READINGS	0	II
		1	
		2	
		3	
		4	
6.855	MINUS -	5	

"TOLER."

SPREAD

AVERAGE

COMMENTS

GAGE No SAME DIMEN 4.610 ± .001 CHARACTER POS. LATCH PIN HOLE FROM FRONT

HINGE PIN HOLE "B" OF SKETCH

M/D DIMENSIONS

4.617	PLUS +	7	I
		6	
		5	
		4	
		3	
		2	I
4.611	DIAL READINGS	1	II
		0	
4.609		1	II
		2	I
		3	II
		4	
4.605	MINUS -	5	I

"TOLER"

SPREAD

AVERAGE

3A —

PRODUCT CONTROL CHART

OPER NAME _____

MOD No 725 PART NAME TR. GUARD PART No 24196 MACH No _____ OPER. No _____

GAGE No. HEIGHT GAGE DIMEN. .575 ± .005 CHARACTER VERTICAL POS. LATCH PIN HOLE

"C" OF SKETCH

M/D DIMENSIONS: .580 (AND PLUG), .575, .570, .558

DIAL READINGS: PLUS + 5, 4, 3, 2, 1, 0, 1, 2, 3, 4, 5, 6, 7 … MINUS − 17, 25

TOWARDS BTM. ↑ / TOP ↓

"TOLER."

SPREAD ~~.050~~

AVERAGE

COMMENTS

"E"

GAGE No. HEIGHT GAGE DIMEN. .860 ± .005 CHARACTER DEPTH OF LATCH SLOT

"D" OF SKETCH

M/D DIMENSIONS: .865, .860, .855

DIAL READINGS: PLUS + 5, 4, 3, 2, 1, 0, 1, 2, 3, 4, 5 … MINUS −

TOWARDS BTM. ↑ / TOP ↓

"TOLER."

DIFF. C&D: 313, 301, 295, 293, 291, 289, 287, 285, 283, 281, 279, 277, 275

TOLER.

DEEP ↑ / SHALLOW ↓

SPREAD

AVERAGE

CC: A. A. Williamson
H. J. Hackman
R. B. Hurley
G. Choules
V. Clark
Area Auditor
File

Ilion, New York
November 3, 1959

A. J. WEBB

MACHINE STUDY - DRILL PRESS #4512
MODEL 725 TRIGGER
OPER. 28 - DRILL & REAM TRIGGER PIN HOLE

Purpose: Classification.

Observation: The operation is controllable.

Method: Thirty (30) pieces were taken in sequence from operation and characteristics measured as shown on attached sheet.

QUALITY CONTROL DEPARTMENT
A. D. Gordon, Supervisor

by A. B. Paulsen
A. B. Paulsen

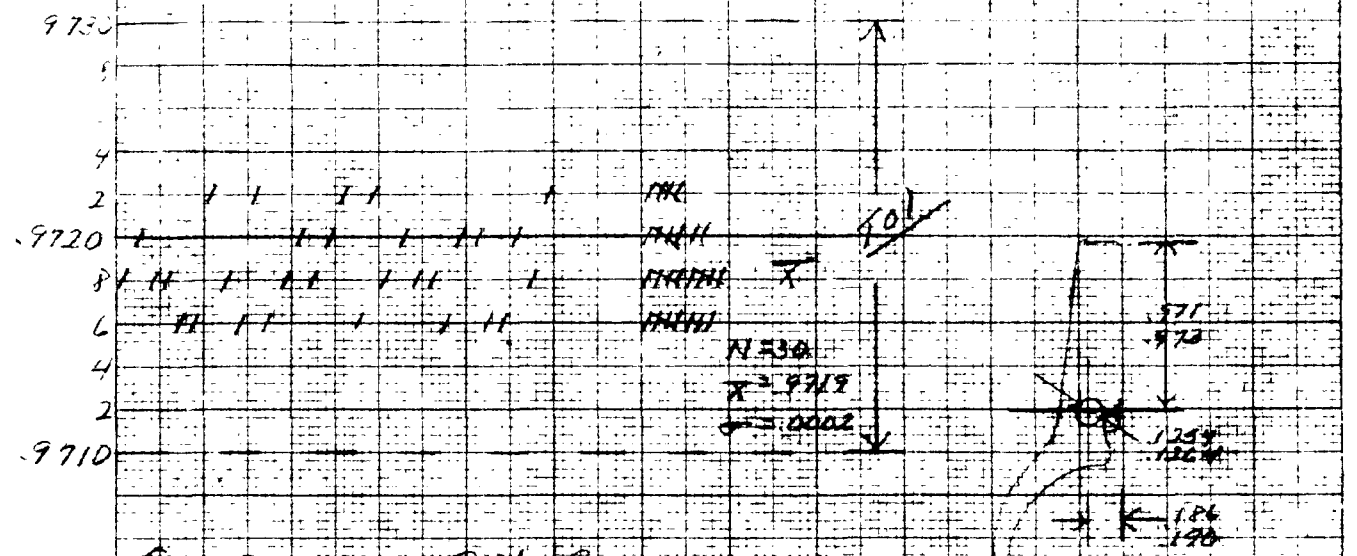
ABP:I

1/12/59

M-225 Trigger # 16718 Drill Press #4512

Oper. 28 Drill & Ream Trigger Pin Hole

Ga. B-50317 Pos from End .971 - .973



Ga. B-50317 Side Pos. .184 - .190

Under
O.K.
Over

Ga. B-80154-D Hole Dia. .1259 - .1264

Go Not Go
Go Goes
No Go Goes

M/725 - Test Performance

S. M. ALVIS
D. COCK
H. J. HACKMAN
W. E. LEEK
J. W. MILLER
G. E. RICE
E. SAPP
R. E. WRIGHT
R. A. WILLIAMSON

August 19, 1955

M/722 EXTENSIVE TESTING - 4/1/55 to 7/31/55

Date	Gun No.	Gage	No. Rounds	Function Test	Take Down & Finish Test
4/29	4460	308	500	D.E. 2 times % of Malf. 4	Stock marred. Trigger Adjusting Screws not sealed.
4/29	0960	308	500	O. K.	Stock marred.
5/19	1673	444	500	Heavy Bolt lift-10 Closes hard 1 O. R. 1 Total Malf. 12 % of Malf. 2.4	Trigger Adjusting Screws not sealed.
5/19	1375	444	500	Heavy Bolt lift- 14 Closes hard 2 Total Malf. 16 % of Malf. 3.2	Magnaflux stamp missing on Bolt Lug.

QUALITY CONTROL DEPARTMENT
A. D. Gordon, Supv.

by W. T. Scanlon
W. T. Scanlon

TESTING DEPARTMENT
W. A. Best, Supv.

by S. W. Fisher
S. W. Fisher

ADG/WTS/WAB/SWF/I

MAG. SPRING REVERSED

S P E C I L T E S T RD-6491

Model 725 Jack No. 1 Shooter Spann Date 6-30-60

Gun No.	Cal. Ga.	Rds.	Ammunition Code H.J.	Rds.	Ammunition Code L.J.
713759	100gr.	4	OK	4	OK
	80gr.	4	OK	4	OK
713720	100gr.	4	OK	4	OK
	80gr.	4	OK	4	OK
713681	100gr.	4	OK	4	OK
	80gr.	4	OK	4	OK
713465	100gr.	4	OK	4	OK
	80gr.	4	OK	4	OK
713372	100gr.	4	OK	4	OK
	80gr.	4	OK	4	OK
713766	100gr.	4	OK	4	OK
	80gr.	4	OK	4	OK
713326	100gr.	4	OK	4	OK
	80gr.	4	OK	4	OK
713649	100gr.	4	T.W.W	4	
	80gr.	4		4	

MAG. SPRING REVERSED

SPECIAL TEST RD-6491

Model 125 Jack No. 1 Shooter [illegible] Date 6-30-60

Gun No.	Cal. Gr.	Rds.	Ammunition Code H.J.	Rds.	Ammunition Code L.J.
713677	100gr.	4	OK	4	OK
	80gr.	4	OK	4	OK
713400	100gr.	4	OK	4	OK
	80gr.	4	OK	4	OK
713795	100gr.	4	OK	4	OK
	80gr.	4	OK	4	OK
713658	100gr.	4	OK	4	OK
	80gr.	4	OK	4	OK
713313	100gr.	4	OK	4	OK
	80gr.	4	OK	4	OK
713808	100gr.	4	BOLT CATCHES ON EXTRACTION	4	BOLT CATCHES ON EXTRACTION
	80gr.	4	"	4	"
713749	100gr.	4	OK	4	OK
	80gr.	4	OK	4	OK
713295	100gr.	4	OK	4	OK
	80gr.	4	OK	4	OK

MAG. SPRING REVERSED

S P E C I L T E S T RD-6491

Model 725 Jack No. 1 Shooter Sparrin Date 6-30-60

Gun No.	Cal. Ga.	Rds.	Ammunition Code H. J.	Rds.	Ammunition Code L. J.
713382	100 gr.	4	OK	4	OK
	80 gr.	4	OK	4	OK
713716	100 gr.	4	OK	4	OK
	80 gr.	4	OK	4	OK
713752	100 gr.	4	OK	4	OK
	80 gr.	4	OK	4	OK

M/725-222 Pilot lot. 1/7/59

710277 - Cross bolt - step in locking cam cuts of receiver (compressed)

710599 - Bolt stem follower - left ear of follower missing

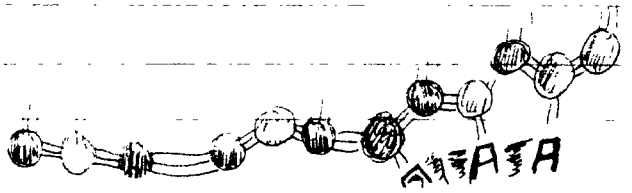
710555 - STC 1 Retest 50 rds OK

710466 - STC 2 - Retest 50 rds 1 mal straightened right side of mag. - 50 rds OK

710583 - STC 1

710242 - R&D group - 2.28 group size ous after tightening Rx screws 1.38

705947 - D.E. extractor binds? 50 rds. OK



710466

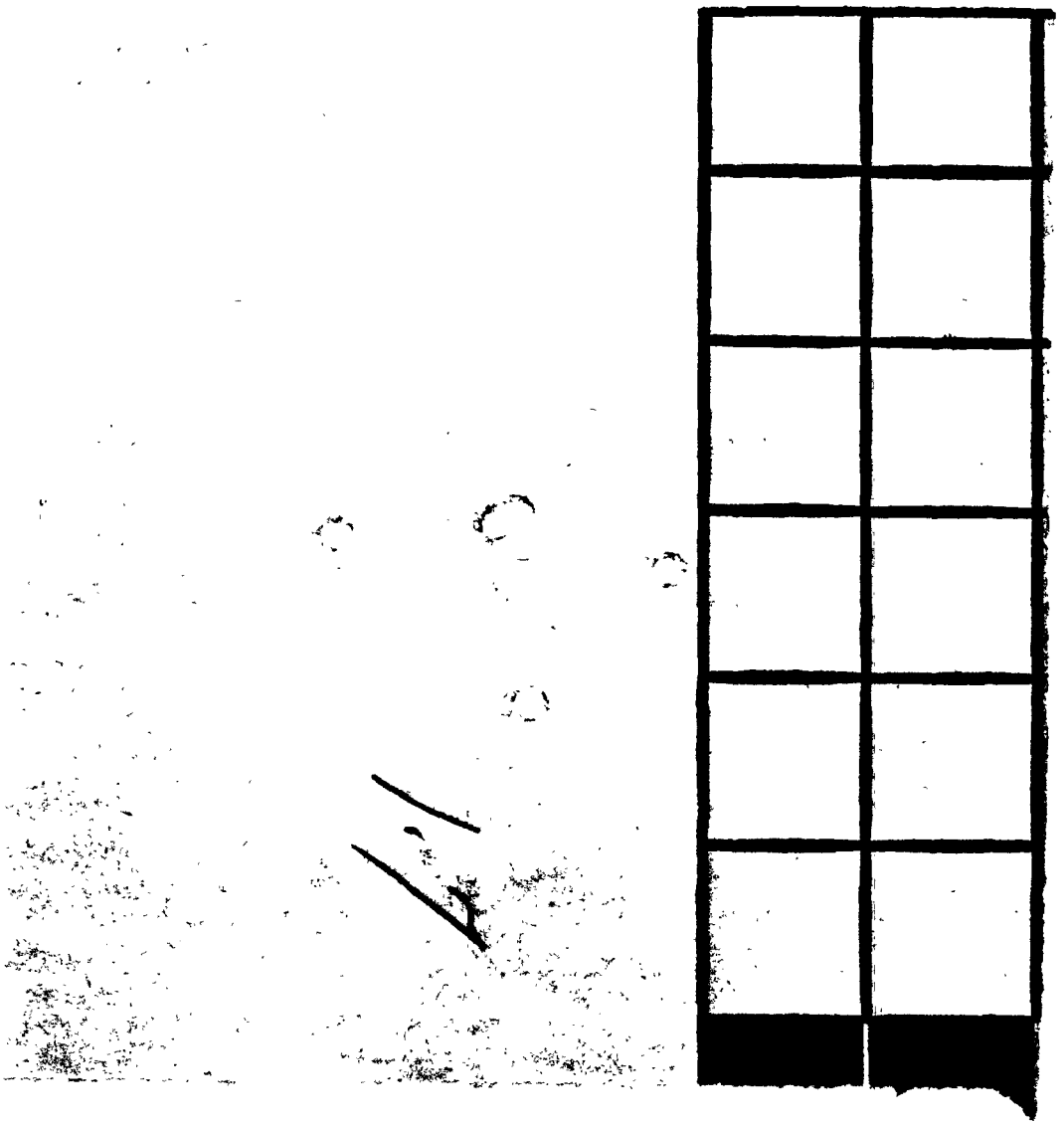
L. Evans 1.55

Date 1/7/59 Rifle No.

Form 868

155

M/725-222 REM



710466

REMINGTON ARMS COMPANY, INC.
Ilion Research Division

cc: S. M. Alvis
D. E. Miller
R. A. Williamson
H. J. Hackman
V. G. DeReus
R. B. Hurley
W. E. Leek

Ilion, New York
January 5, 1959

W. A. BEST

MODEL 725 - 222 CALIBER - PILOT LINE TEST

At your request ten of these rifles were withdrawn and subjected to test on 12/29/58.

Each gun was tested for unloading live ammunition and then fired 40 rounds in the field. Four shooters were used, with Rem. 50 gr. ammunition. All ten rifles were fired three 5-shot groups for accuracy, using a lot of ammunition that standardized at .7" for four 5-shot groups.

Conclusions

1. The escutcheon for the top swivel is too deep, showing unfinished wood.

2. The trigger assemblies are not adjusted, particularly the trigger stop screws.

3. The lip on the magazine follower on gun #710559 has been broken off, which in turn blocks the bolt from closing.

4. The overall malfunction rate is 1.75%, which seems rather high for a manual operated rifle.

5. Rifle #710242 averaged 2.28" in the accuracy test, which is over plant specifications. Reshot by Evans after tightening screws 1.35"

Results

Functional Test

Gun No.	No. Malf.	Rate		Type
710242	1	2.5%	1	Stem chamber.
705947	2	5.0%	2	Failures to eject.

Gun No.	No. Malf.	Rate	Type
710277	None	-	This rifle closes hard.
710252	None		
705898	None		
710559	None		
710555	1	2.5%	1 Stem chamber.
710466	2	5.0%	2 Stem chamber.
710583	1	2.5%	1 Stem chamber.
710521	None		

Rechut ok

Accuracy Test

3 - 5-Shot groups - 20X Scope - Bbl. & Rec. mounted
Bench Rest
Range - 100 yds.
Ammo. - Rem. 50 Gr. SP

Gun No.		Group	Gun No.		Group
710242	1)	2.5	705947	1)	1.7
	2)	2.7		2)	2.05
	3)	1.65		3)	1.05
		6.85			4.80
	Avg.)	2.28		Avg.)	1.6
710227	1)	1.4	710252	1)	1.4
	2)	1.6		2)	1.65
	3)	.8		3)	1.4
		3.8			4.45
	Avg.)	1.26		Avg.)	1.48
705898	1)	2.45	710559	1)	1.3
	2)	.95		2)	1.1
	3)	1.35		3)	1.6
		4.75			4.0
	Avg.)	1.7		Avg.)	1.3
710555	1)	1.12	710466	1)	1.65
	2)	.75		2)	1.5
	3)	.95		3)	1.05
		2.82			4.20
	Avg.)	.94		Avg.)	1.37

Gun No.		Group
710583	1)	1.25
	2)	1.25
	3)	1.3
		3.80
	Avg.)	1.27

Gun No.		Group
710521	1)	1.
	2)	1.3
	3)	.95
		3.25
	Avg.)	1.08

C. J. Theriault

C. J. Theriault
Supervisor - Testing Unit

CJT:T

SPECIAL TEST New firing plate - new spring RD-6491

INSTRUCTIONS: 100 rds

Model 725 Jack No. 1 Shooter Freeman Date 12-11/58

Gun No	Cal. Ga.	Rounds	Ammunition Code	Rounds	Ammunition Code
705936	222	50	SLC 10	50	OK
705102	222	50	OK	50	SLC 50
705915	222	50	SRC 29	50	OK
705941	222	50	Mag. ~~[illegible]~~ latch doesn't hold out	50	
705903	222	50	OK	50	SRC 23
705945	222	50	OK	50	OK
705957	222	50	SLC 12-24	50	SRC 5-35 SLC-36
705920	222	50	SLC 10-30-42 SRC-35	50	SLC 18-30 SRC 23
705926	222	50	OK	50	OK
705993	222	50	OK	50	SLC 99
705941	222	50	OK	50	OK

BY MARKLEY DATE 12-5-58 SUBJECT M/725-222 CAL SHEET NO. ... OF ...
CHKD. BY ... DATE ... MAGAZINE SPRING JOB NO ...

SAMPLE FURNISHED BY VENDOR - (24 HOUR SET)

108 RDS EACH RIFLE JACK #10

RIFLE NO		
705887	SLC-48TH RD	LAST SHELL OUT OF MAG.
705904	SLC-90TH RD	
705905	NO MAL	

MALFUNCTION RATE .6%

Fr. 721/725-222 Cal New floor plate
Reg 222 ~~Mag~~ Spring

SPECIAL TEST

INSTRUCTIONS:

Model Jack No. Shooter Date 11/5/58

Gun No.	Cal. Ga.	Rounds	Ammunition Code	Rounds	Ammunition Code
Marlin 705867	222	54	STC 48TH	X	
Evans		54	OK		
Marlin 705904		54	OK		
Evans		54	STC-L-4TH - 32 ~~TH~~ 54 ~~TH~~		
Marlin 705905		54	OK		
Evans		54	STC-36 ~~TH~~	X	

725 Test Pad

SPECIAL TEST

RD-6491

INSTRUCTIONS: 100 rds each per Marking

Model 725 Jack No. I Shooter Klimaitis Date 9-23-55

Gun No	Cal. Ga.	Rounds	Ammunition Code	Rounds	Ammunition Code	
No(3) 705905	222	25	ok	25	ok	100 rds
		25	ok	25	ok	
No(2) 705904	222	25	ok	25	Overtravel - 19- stem left chamber - 10-15	100 rds
		25	ok	25	ok	
No(1) 705887	222	25	ok	25	ok	100 rds
		25	ok	25	ok	

SPECIAL TEST 1/25-222 Pilot Test RD-6491

INSTRUCTIONS: [illegible] spring formed to give more support
+ [illegible] to front of [illegible]

Model Jack No. Shooter Evans Date 9-1-[illegible]

Gun No	Cal. Ga.	Rounds	Ammunition Code	Rounds	Ammunition Code
5945	22 2	54	SLC 48th		
5893	2 2 2	54	SRC 17		
5934		54	SLC 48th		
5926		54	SRC-5th 49th 53rd		
			SLC 6th 10-36		
5920		54	SRC 11-53		
5904		54	SLC 3rd-3th		
5957		54	SLC 42		
5905		54	ok		

A. 18893

SPECIAL TEST FD-6491

INSTRUCTIONS:

Model 725 Jack No. Shooter EVANS Date 9/17/58

Gun No	Cal. Ga.	Rounds	Ammunition Code	Rounds	Ammunition Code
5887	222	100	SRC-35-97		FLOOR PLATE AND SPRING #1
"	"	100	SRC-17-28-53-71 77 SLC 6 Th 48 Th		FLOOR PLATE AND SPRING #2
"	"	100	SLC 30-42-48-54-60-63 66-72-90-100 SRC 65-71-83		FLOOR PLATE AND SPRING #3
"	"	100	OK		RE FORMED SPRING #3 TO GIVE MORE LIFT TO FRONT END.
5887	222	100	OK		
5958	244	50	OK		
"	244	50	OK		

M/dwg floor plate (orig) spring cut off and reformed to give more lift at front end.

M/dwg floor plate and spring cut off

2nd Floor Plate

LUGS MOVED AHEAD .225 SPRING AROUND LUGS

SPECIAL TEST 725-222 mag PD-6491

INSTRUCTIONS:

Model Jack No. Shooter Cuen Date 9-11

Gun No	Cal. Ga.	Rounds	Ammunition Code	Rounds	Ammunition Code
5887	22	100 rds	SLC - 30 - 22 - 96 SRC - 65 gr		

4%

LUGS MOVED AHEAD .100 SPRING AROUND LUGS

SPECIAL TEST 725-222 RD.-6491

INSTRUCTIONS: 100 rd Test

Model Jack No. Shooter Date 9-11

Gun No	Cal. Ga.	Rounds	Amminition Code	Rounds	Ammunition Code
		100	SLC 6-36-42-60-78-90 99		
	222	rds	SRC 29-35-53-89-95-97-100		
5587					
			Stem char		
			14 times out of 100		

14

150 OFF LOWER SPG. LEAF. — SPG. SETTING JUST AHEAD OF LUGS.

SPECIAL TEST 22 - 22 pilot RD-6491

INSTRUCTIONS: Bruzel Fodut camp.

Model Jack No. Shooter Date 9-3-38

Gun No	Cal. Ga.	Rounds	Ammunition Code	Rounds	Ammunition Code
5945	22	54	ok		
5912		54	SLC 6th 12th 54th L L L		6 12 18 24 30 36 42 48 54
5934		54	ok		
5893		54	ok		
5920		54	STC 12th L		
5926		54	SLC 24th L SRC 36th NL		
5887		54	SRC 5th NL 36th NL SLC 10th 18th 24th 30th 46th 48th 54th		17%
5905		54	SLC 6th 12th 24th 36th 48th		
5904		54	SLC 30th 36th 48th		
5937		54	ok		
			540 rds 23 stem chamber		
			4.3%		

CC: D. E. Miller
R. A. Williamson
H. J. Hackman
E. Sapp
R. B. Hurley

A. D. Gordon
S. W. Fisher
C. O. Pardee
C. D. Hunt -Bdpt.

Ilion, New York
March 24, 1958

R. E. WRIGHT

M/725 PLANT TESTING AND TARGETING

Effective Monday, March 24, separate gallery testing on all current calibers (30-06, 270, 280) will be discontinued. Functional testing will be combined and done with the targeting operation in accordance with our present M/721-722 "Target-Test" procedure.

Approximately two thousand (2000) guns have been given a separate gallery test. Results have been quite comparable with those obtained with the Model 721-722 prior to adopting the "Target-Test" method. There is every indication that functional specifications can be controlled with the combined operation.

Hi-spot estimates show a cost reduction of twenty six dollars per hundred ($26.00/100).

Changes are being made to our M/721-722 "Target-Test" procedure to incorporate the M/725 in the above mentioned calibers and new sheets will be issued for plant use shortly. In the future, test results will be recorded on M/721-722 Target-Test Report Form #85-3.

W. A. Best, Supervisor
Product Testing Specs.

by R. F. Kerr

RFK : I

Pilot lot
feed ramp polished new guns

SPECIAL TEST RD-6491

INSTRUCTIONS: 100 Rds

Model 725 Jack No. 1 Shooter Pedersen Date 12-16

Gun No	Cal. Ga.	Rounds	Ammunition Code Heavy	Rounds	Ammunition Code Light
705917	222	50	OK	50	OK
705913	"	50	OK	50	OK
705898	"	50	OK	50	OK
705899	"	50	DE 13	50	OK
705963	"	50	OK	50	OK
705938	"	50	OK	50	OK
705923	"	50	FD (Cont. Fire) out Trig head on trig guard.	50	
705918	"	50	OK	50	OK
705878	"	50	Blows primer out	50	
705888	"	50	OK	50	SLC 2
705902	"	50	OK	50	OK
705914	"	50	DE 13 SLC 42	50	OK

P. E. & C. ESTIMATE

S. H. Hoe R. S. Hunting
D. H. Warnick L. Sapp

TO: H. J. Lackmann

ESTIMATED BY: R. Nelson - [illegible]

MODEL 725 PROJECT NO. DATE 9/22/54

PROJECT TITLE Monte Carlo with check piece Stock - ASSUMES model 721 - 722 in effect - Process on basis of hand checking

	HOURS	RATE	TOTAL
PROCESS ENGINEERING & TRIAL RUN			200
TOOL DESIGN FIXTURES - GAGES			600
TOOLING FIXTURES - GAGES			2600
TOOL DESIGN — PERISHABLE TOOLS			10
TOOL DESIGN REVISIONS			60
PERISHABLE TOOLING			20
TOOL REVISIONS			260
TOOL REVISIONS - PERISHABLE			10
TESTING			0
ADMINISTRATION			0
VENDOR TOOLING COSTS (DIES ETC.)			0
VENDOR TOOLING NOT REMINGTON PROPERTY			0
SUB TOTAL			3750
CONTINGENCIES			350
			4100

COMMENTS

I

Hand Jackson 9/4/59

MODEL NO 725 MODEL NAME MONTE-CARLO WITH CHEEK PIECE EST NO

PART NO PART NAME STOCK REQ ADD USE

MAT SPC SIZE WT PER 100 COST @ / LB

OPER NO	OPERATION DESCRIPTION	DEPT NO	SEX	STD HRS	COST	QUAN	EQUIPMENT DESCRIPTION	COST
							DES BLD	
	NOTE: OPERATIONS 5-20-30-35 & 45 SAME AS M/721-722 STOCK.							
55	INLET TOP						FIXTURE A.U FORMER - FIRE CONT. 10 NOTE:- ALL OTHER TOOLING IS SAME AS M/721-722	
86	PROFILE OUTSIDE CONTOUR							
160	INLET BOTTOM						FIXTURE A.U. FORMER 20	
	H/M SAFETY CLEAR.						FIXTURE 40 CUTTER 2 TEMP. ga. 6	
210	SHAPE FRONT TOP & BOTTOM							
220	SHAPE AROUND MAG. OPENING.							
260	DRILL SCREWED PIN HOLE & ASSEM. PIN.							
	ROUGH SHAPE OUTLINE FOR CHEEK PIECE							
	NOTE: USE SAME TOOLING AS USED FOR M/721-722							

FORM R D 5144

II

Paul Gillam 9/4/59

MODEL NO 725 MODEL NAME MONTE-CARLO WITH CHEEK PIECE EST. NO.

PART NO PART NAME STOCK REQ. ADD. USE

MAT. SPC. SIZE WT. PER 100 COST @ / LB.

OPER NO	OPERATION DESCRIPTION	DEPT NO	SEX	STD HRS.	COST	QUAN	EQUIPMENT DESCRIPTION	COST
							DES. BLD	
	DRILL GRIP CAP SCR. HOLE			FIXTURE			30	
				TEMP.			4	
	ROUT COMB CUT			FIXTURE			A.U	
	NOTE:- USE ~~SAME TOOLING~~			CUTTER			A.U	
	AS USED FOR M/721-722			TEMP.			A.U	
335	ASSEM. BUTT PLATE							
350	INSPECT							
377	ROUGH & FINISH MECH. SAND							
390	INSPECT, WOOD & WAX PATCH REPLACE BROKEN BUTT PLATES, ETC.							
405	SPOT STAIN, FILL & REMOVE EXCESS FILLER							
410	HAND SAND FILLER							
445	MACHINE SPRAY LACQUER & DRY.							
463	INSPECT & SCUFF.							
480	LAYOUT FOR CHECKER							
485	CHEKER & BORDER							
505	OIL CHECKERING							
510	INSPECT, WOOD OR WAX PATCH AS NECESSARY							

FORM R D 5144

CC: W. A. Best
~~R. B. Hurley~~
A. D. Gordon

Ilion, New York
June 30, 1959

W. B. PARSONS

MODEL 725 STOCK ASSEMBLY D-24565, PART #24566 - 222 Cal.

There are 1031 Stocks .222 Caliber in Receiving Stores. These Stocks were received beginning 5/12/59 to 6/18/59. Purchase Inspection discovered the Barrel and Receiver action did not fit properly. A thorough inspection of sample Stocks was made in Tool Inspection section with the assistance of the writer. Two major discrepancies of the Stocks are:

1. The width of Barrel inlet cut as shown by the following dimensions is too wide.

"E"	- 1.2445	- 1.2345	sample	measured	1.260"
"D"	- 1.0745	- 1.0675	"	"	1.080"
"C"	- .8257	- .8187	"	"	.839"
"B"	- .7585	- .7515	"	"	.772"

2. The relationship of the centerline between the Receiver section and Barrel inlet cut was measured and the following dimensions indicated the Barrel inlet cut is to the right of centerline. When the Receiver section was centered, the Barrel inlet cut at Section "D" was .005" to right of centerline; at Section "C", it was .013" to right; at section "B" it was .020" to the right.

Four (4) Stocks with the aforementioned discrepancies were assembled and targeted by testing section. The targeting results met Remington's specifications. Supervisors of Product Test Section and Current Arms Section reviewed the results and it was agreed that Stocks were acceptable. However, the vendor should undertake corrective steps to eliminate future repetition of wide and off-center Barrel inlet cut.

It is the writer's personal observation that recent shipments of Stocks have not met the high quality level which we expect and have received from Bishop in the past. Some of the more prevalent sub-standard items are:

1 - Non uniformity of wood margin left around Receiver "tang" section. Some Stocks would have a high wood margin on one side and a steel margin on the other side. Still others would have a .070" wood margin on both sides, and some had a steel margin. Remington's standard requires a wood margin at Receiver "tang" of .020" max. and a .005" max. steel margin.

2 - Too much wood margin left at Front Stock Swivel Screw Bushing. The result of this condition is to score the Stock when assembling the Front Swivel.

3 - Poor application at "filler" operation.

4 - The Trigger Guard area not sanded uniformly. Some Stocks show too great a wood margin and Floor Plate cannot be latched properly. Also, one side shows too much Trigger Guard where opposite has a wood margin.

Purchase Inspection has rejected fifty-one (51) pieces .244 Cal., Part No. 24567. The Trigger Guard cut is not centered with front and rear Trigger Guard Screw holes. Please refer to my letter of January 15, 1959 addressed to you on this same subject.

Attached are drawings D-24565 and D-25155 with red pencil marks showing Stock dimensions and areas where corrective action is required.

P. B. Creep, Supervisor
Process Engineering Dept.
New Products & Tool Design

J. C. 6/30/59
Jack Carter
Process Engineer

JC/fe
Attach.

5 quotes

CC: R. A. Williamson
R. E. Wright
W. B. Parsons
W. C. Schrader
W. A. Best
K. R. Chadwick
P. B. Croop
R. B. Hurley
W. T. Scanlon
File

Ilion, New York
October 15, 1958

H. J. HACKMAN

FINISHED PRODUCT AUDIT
MODEL 725 - EXCESS STEEL MARGIN AT BUTT PLATES

At Finished Gun Audit - One (1) rifle was reported for the above defect (in excess of .020") on Tuesday, October 14. At the same time, it was noted that all the rifles in the sample that day showed some evidence of substantial steel margin in varying degree but within specifications.

At Assembly - A review of the Stock Assemblies indicates that nearly all current assemblies show some steel margin with approximately half beyond specification. It is anticipated that continued shrinkage may still occur in a portion of the balance. Assembly is sorting.

At Purchased Parts Inspection - The Stocks reviewed by the writer were reported as received since September 26. A substantial proportion of the Stock Assemblies were checked and showed some steel margin in the bulk of the sample but in a very minor degree. These probably are in the early stages of shrinkage, if any is to be expected.

Warehouse Audit - The warehouse has also been checked and suggests that the defect may be confined to those Stock Assemblies received during and since September. Results are as follows:

Quantity	Code	Sample	Results
150	Aug.	5	3-Butt Plate flush to Stock. 2-Show a whisker of steel margin.
150	Sept.	5	1-Over .020" steel margin. 4-Show a significant margin but less than .020". One (1) of these four (4) also shows a wood check over the top Butt Plate Screw.

QUALITY CONTROL DEPARTMENT
A. D. Gordon, Supervisor

by N. W. Menard
N. W. Menard
Quality Control Engineer

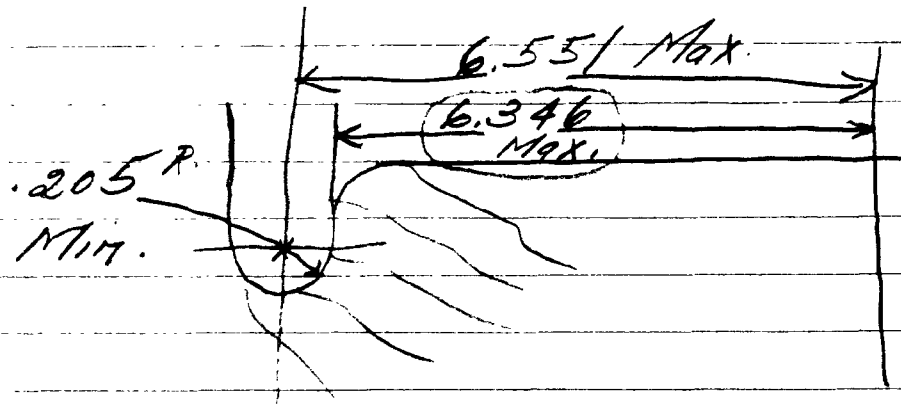
NWM

T25 -- Stock / Thumb Piece Clearance 2/12/58

Rec	7.345 ± .003	5.970 ± .002
	.905 ± .003	1.428 ± .001
	8.250 ± .006	7.398 ± .003
	7.398 ± .003	
	.852 ± .009	
Thumb Pc	.190 ± .005	
	1.042 ± .014	

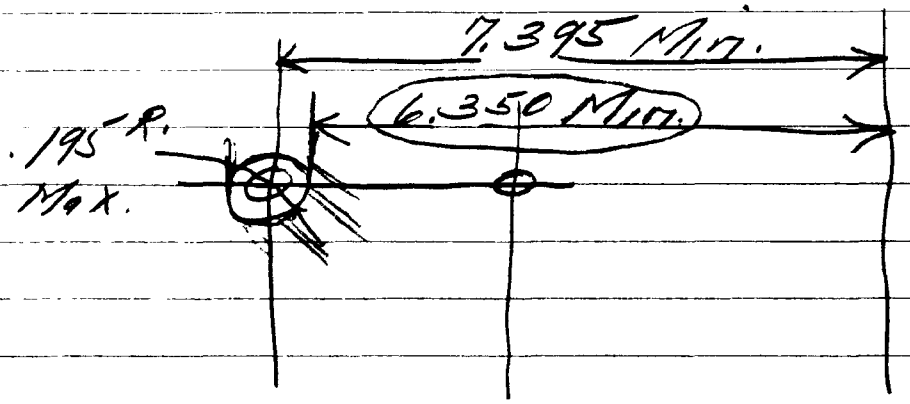
Stock	7.407 ± .005
	6.548 ± .003
	.859 ± .008
	.210 ± .005
	1.069 ± .013

	1.056	1.082
Clear.	1.056	1.028
	~~.004~~	.054



Stock

6.551
.205
6.346

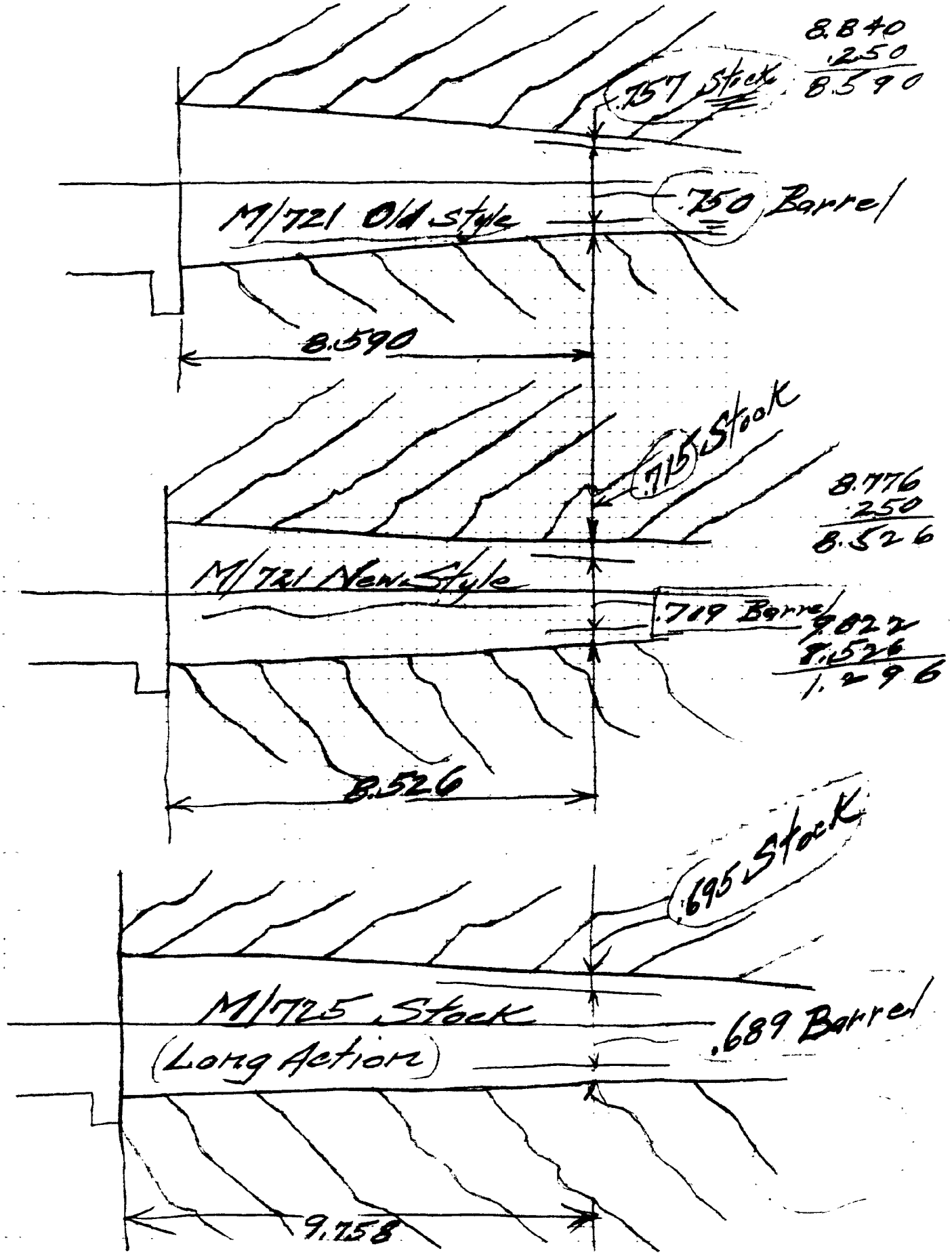


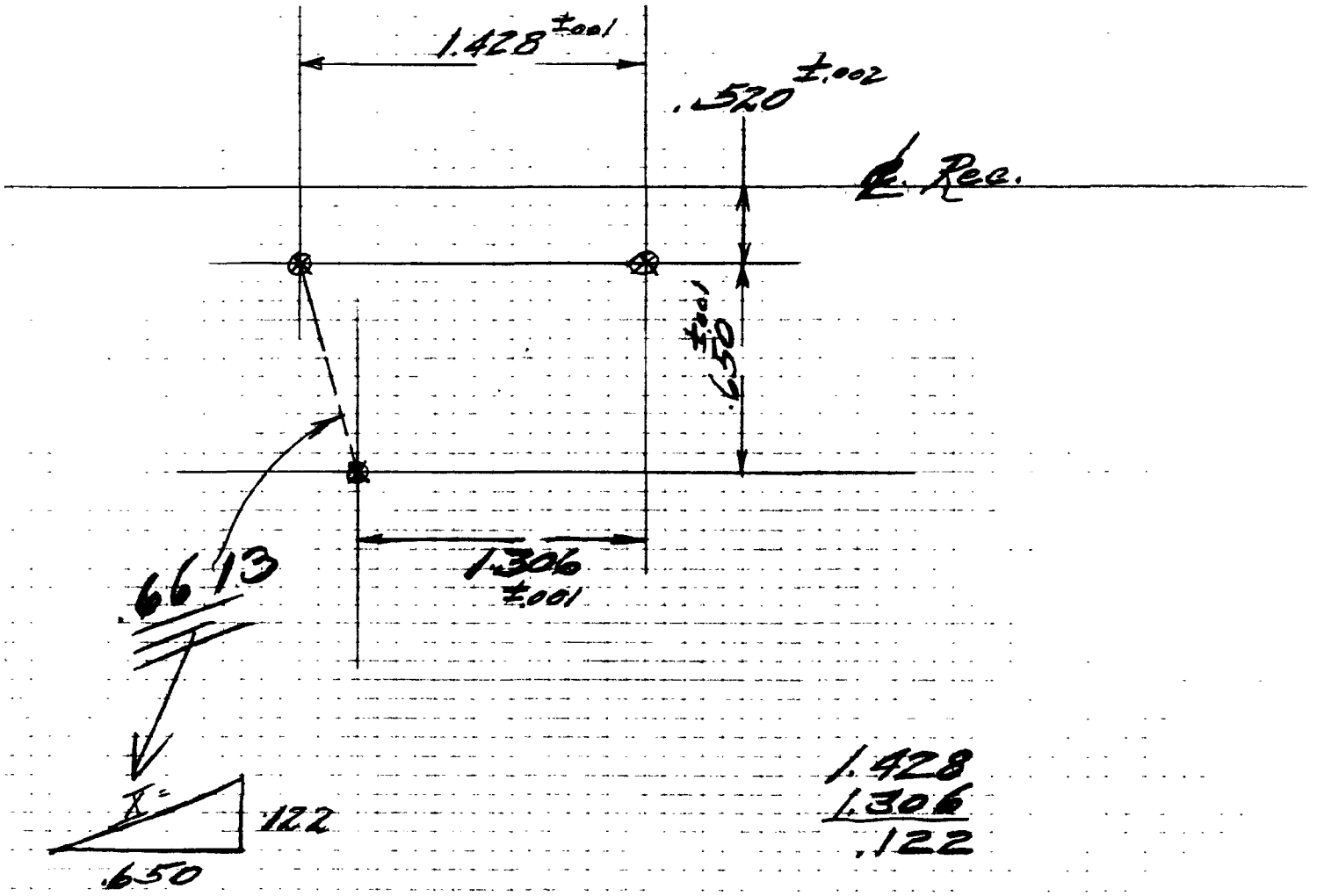
Rec.

~~5.968 Min.~~
~~1.427 Min.~~
~~7.395 Min.~~

6.350
6.346
.004 Clear.
Worst Cond.

5.118 Min.
1.427 Min.
6.545
.195 Max.
6.350


8.840
.250
8.590
.757 Stock
M/721 Old Style
.750 Barrel
8.590
.715 Stock
8.776
.250
8.526
M/721 New Style
.719 Barrel
9.022
8.526
1.296
8.526
.695 Stock
M/725 Stock
(Long Action)
.689 Barrel
9.758



1.428
1.306
.122

$.650^2 = .422500$
$.122^2 = .014884$
$\sqrt{.437384} = .6613$

2 | 1.048 ±.002 P.D.
.524 ±.001 Rad.

2 | .264 ±.002 P.D.
.132 ±.001 Rad.

.132 ±.001
.524 ±.001
.656 ±.002

725-Ch-7

Cc: R. A. Williamson
A. J. Brown) In
C. I. Mann)Turn
A. D. Kerr
R. C. Gilbert
E. B. Wallin
C. Putney
H. J. Hackman)In
W. G. De Reus)Turn
J. W. Miller
P. Nielsen

W. Leo (2)
W. A. Bo
A. D. Gordon) In
E. Sapp)Turn
M. Bennett
L. Pettingill
C. Prosser
R. Wright) In
G. Choules)Turn
Process Eng. Group Heads
Central File

COMPLETED 9/14/55

PRODUCT ENGINEERING & CONTROL
Remington Arms Company, Inc.
Ilion, New York

To: M. H. Walker
From: C. Prosser
Engineer
in Charge: P. Nielsen

Date: 8-25-55
Model No.: 721-722
Part Name: Stock
Part No.: All
Dwg. No.: D-20125
Exp. No.: 223422

REQUEST FOR CHANGE

Title: Stock Dimension.

Object: To eliminate interference of safety with stock.

Summary: The new lower finger piece safety now coming into general use on M/721-722 in many guns strikes the stock when "on".

Conclusion: Research and Development Department is requested to change dimension .4675"-.4525" on drawing D-20125 to .4855"-.4705" (dimension used on M/40-X).

Engineer 8-25-55

Supervisor - Proc. Engr.

R. & D.

Production

Methods and Standards

fe

M/725 - Bolt

CC: R. A. Williamson
W. A. Best
G. A. Choules
H. E. Wright
E. E. Folmsbee

November 5, 1958

H. E. HURLEY

M/721-722-725 BOLT HEADS

Per your request, the following is the result of 100% inspection of M/721, 722, 725 Bolt Heads rejected against worst acceptable sample for excessive turning rings on shroud.

156 - complete assemblies at Assembly)
35 - " " " Polish) Complete Assembly
255 - (257 Cal.) complete assemblies at Color.)
211 - Body and Head Assemblies - at Heat Treat
203 - Bolt Heads - at Heat Treat
183 - Bolt & Head Assemblies to Braze Handles at Braze
188 - Bolt&Head Assemblies at Turn

These are identified with "Red Tickets" and should be held for disposition.

500 - M/725 at Quackenbush will be sorted when returned.

L. J. Boyle, Supervisor
Production Section

LJB:mc

CC: R. A. Williamson
H. J. Hackman
R. E. Wright
P. K. Agrelius
E. R. Carr
R. B. Hurley
J. W. Miller
P. Eccleston
A. D. Gordon
Auditor
File

Ilion, New York
March 19, 1958

V. G. DEREUS

MODEL 725 - BOLT ASSEMBLY
YIELD AT COLORING OPERATION

A yield of approximately 60% is indicated from two (2) lots of work totaling two hundred and sixty (260) Bolts which were checked as indicated below. Samples of the rejects have been taken by E. R. Carr for review with the vendor today.

The total lot of two hundred and sixty (260) Bolt Assemblies were inspected 100% and sorted out by the area auditor with a yield of approximately 50%. About half of the defects were further reviewed with W. A. Best for verification and the final yield estimated on the basis of the results of this recheck. The defects were also reviewed with a representative of Process Research and Chem. & Met. Adjusted results were as follows.

Sample - 260 No. ok - 156 - 60% Defects - 104 - 40%

QUALITY CONTROL DEPARTMENT
A. D. Gordon, Supervisor

by N. W. Menard

NWM:I

M/725 - Bolt Stop Pin

RT-215

Date 9/26/58

TO: W. LEEK

FROM: A. WEBB

DESIGN CHANGE REQUEST

Gun Model 725

Part Name BOLT STOP PIN

Part Number 16417

See attached note

not approved

The followin.;change in design is recommended:

THAT THE DIA. OF THE HEAD BE CHANGED FROM .246-.250 TO .240-.245.

Reason for Design Change: THE HOLE IN THE SAFETY THUMB-PIECE IS .251-.255 & THE DIA. OF THE SAFETY GEAR THAT FITS IN THE HOLE IS .246-.250. WHEN THE PARTS ARE PROJECTION WELDED TO-GEATHER THEY SOMETIMES SHIFT SLIGHTLY & WHEN THE BOLT STOP PIN IS ASSEMBLED THE HEAD OF THE PIN WILL NOT GO OR IS TOO TIGHT TO ALLOW THE ASSEMBLY TO MOVE FREELY.

BEARING TO BE TAKEN ON BODY OF PIN IN SAFETY GEAR

Design Change Made By:

Date:

725 - Bolt Stop Pin

G-55

TO _____

DATE _____ TIME _____

WHILE YOU WERE OUT

M _____

OF _____

PHONE _____

TELEPHONED _____ ☐ PLEASE PHONE _____ ☐

CALLED TO SEE YOU _____ ☐ WILL CALL AGAIN _____ ☐

WANTS TO SEE YOU _____ ☐ RUSH _____ ☐

RETURNED YOUR CALL ☐

MESSAGE _____

_____

_____

_____

_____

Mr. Phillips

I don't think
advisable a
must provide
the head of
have the
[illegible] assembly.

[illegible]

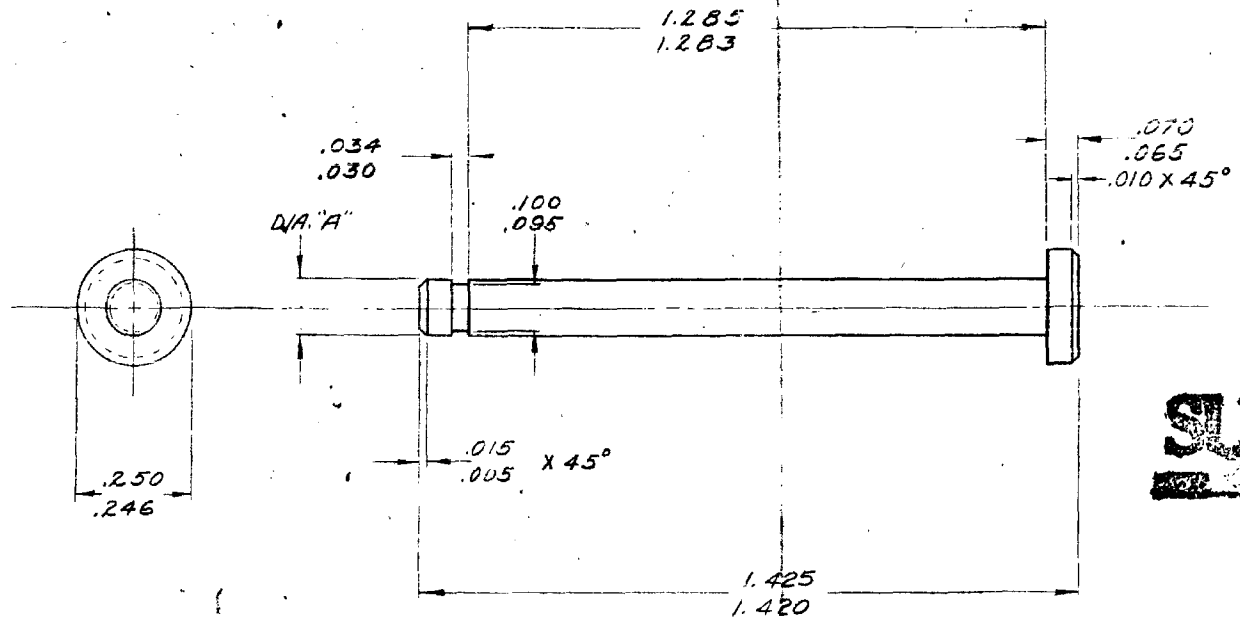
[redacted]

M/725 - Bolt Stop Spring

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

ALTERATIONS

LET	WAS	REFERENCE	BY	DATE
1	.1245/.1225	D.C.R. 2804	R.J.J.	8/14/57
2	.123/.125"	"	"	"



SUPERSEDED
DATED

DIA.	MANUFACTURING DIM.	DIM. AFTER HEAT TREAT.
"A"	.1245-.1215	.122-.125
	1	2

725	BOLT STOP PIN		
MODEL	PART USE	QUAN.	SEE
DES'D BY DATE	DRAWN BY DATE R.J.J. 5-8-56	CHECK BY DATE R.J.J. 4/24/57	APPR. BY DATE W.L. 6/28/57
TITLE	PIN		
NUMBER B-16417	SCALE 4:1	SUPERSEDES—REFERENCE	
	REMINGTON ARMS CO. INC. RESEARCH & DEV. DEPT.		

TF81 REV 2

MAR 17

CC: V. G. DeReus
~~Textile~~ Chem & Met.
File 4058

TO: P. B. Croop
R. B. Hurley

Date Dec. 1, 1960

SUBJECT: TRANSMITTAL OF DRAWINGS

MODEL 721, 722, 725, 40X, and Stunners

Enclosed herewith 4 copies of the following:

NAME		DWG. NO.
Receiver 721-722 - Rev. #92 thru 97	OK	D-20181
Receiver 725 - Rev. #33 thru 36	new batch 37-40	D-23755
Receiver 725 .222 - Rev. #1	DCR & dwg.	C-16849
Receiver 40X - Rev. #20 thru 25	OK	D-19767
Receiver 411, 412, 413 - Rev. #16 and 17	OK	D-18961
Bolt Stop Spring (new)	OK	A-15224
also new stock old spg for 725		A-17014

~~TRANSMITTAL OF PARTS LISTS~~

1/24/61

11,000 on hand

2/6

pm

REMARKS

Obsolete present Bolt Stop Spring (A-17014). Replace with new Spring (A-15224). Add counterbore to all receivers to accommodate new Bolt Stop Spring. Remove present Spring hole, all receivers. Revise receiver tangs to new thinner design. M/725 receiver tang profile remains as at present.
Use up parts on hand.

? What about stocks

M.H. Walker - Research Department
Design Section

Kamey getting new cutters & gages on tang
new jig & c'line for stop spring

M/725 - Floor Plate

CC: R. A. Williamson
H. J. Hackman
R. B. Hurley
R. E. Wright
C. Prosser
Auditor
File

Ilion, New York
April 21, 1960

J. HENRY

MACHINE STUDY - H/M #3109
M/725 FLOOR PLATE #19800
OPER. 4 - FORM MILL LATCH

Purpose: To evaluate machine capability of holding model drawing tolerances.

Observation: The operation is controllable for both characteristics measured.

Method: Thirty (30) pieces were taken in sequence from Operation 4 and characteristics measured as shown on attached sheet.

QUALITY CONTROL DEPARTMENT
A. D. Gordon, Supervisor

by A. B. Paulsen
A. B. Paulsen

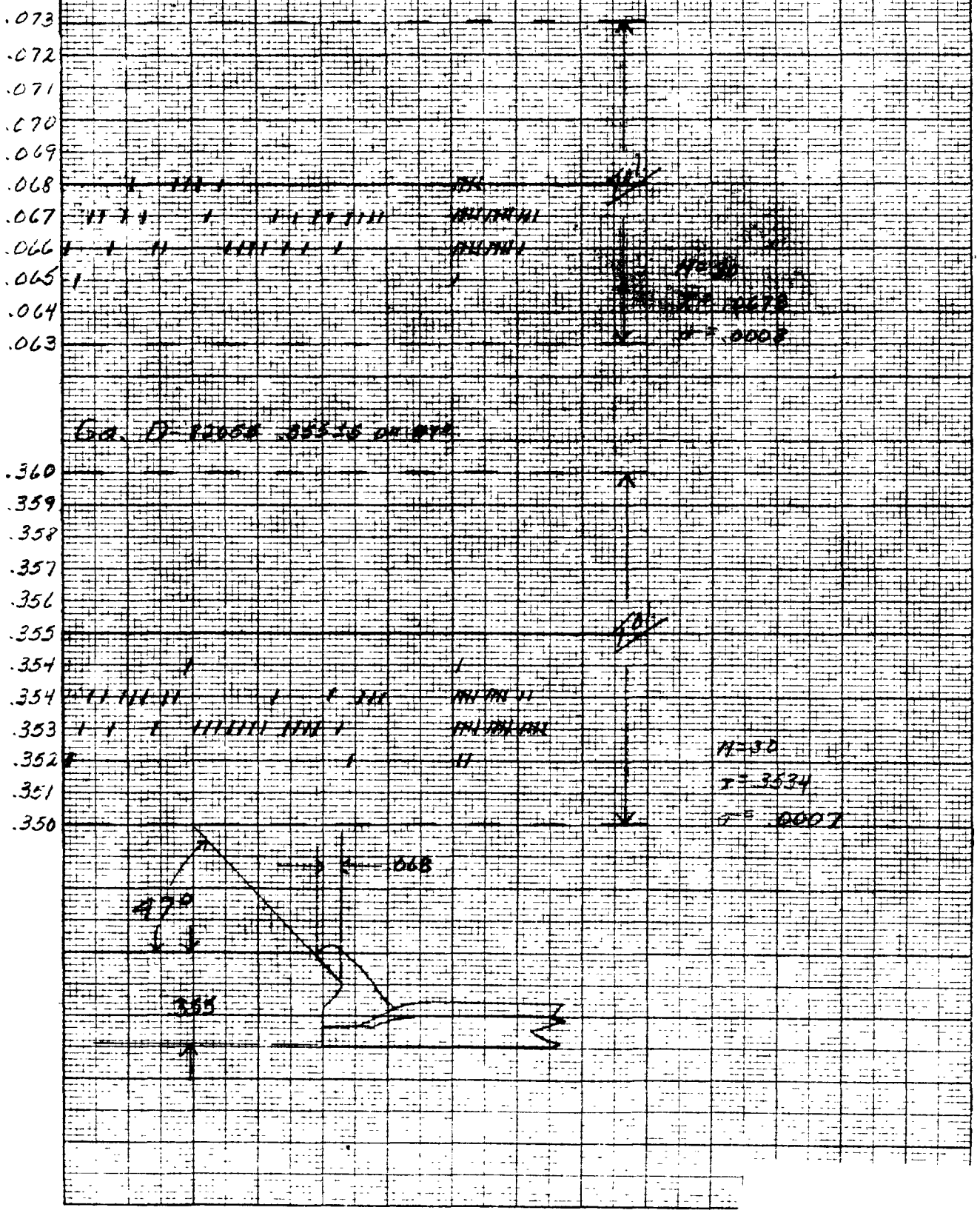
ABP:I

4/20/60

M-725 Floor Plate # 19800 HIM # 3109

Open 4 Form Mill Latch

Ga. D-82055 .063-.073 Dim. Depth



CC: R. A. Williamson
H. J. Hackman
R. B. Hurley
R. E. Wright

D. Garlock
Area Auditor

File

Ilion, New York
May 28, 1959

J. HENRY

MACHINE STUDY - MACHINE #3419
M/725 FLOOR PLATE #19800
OPER. 8 - PROFILE SPRING CLEARANCE SLOT

Purpose: Classification.

Observation: The operation is controllable.

Method: Thirty (30) pieces were taken in sequence from Oper. 8 and measured with gages as specified in the process record.

QUALITY CONTROL DEPARTMENT
A. D. Gordon, Supervisor

by A. B. Paulsen
A. B. Paulsen

ABP:I

5/26/59
HOL

M-725 Floor Plate # 19800 Mach # 3419

Open & Profile Spring Clearance Shot

Ga. G-82634 .020-.6 Dim Pos. from Gat Rom

Left Side Rear Right Side Front

.075
.074
.073
.072
.071
.070
.069
.068
.067
.066
.065

10d

M=30
X̄=.0087
σ=.001

M=30
X̄=.0077
σ=.0008

Ga. B-82022 .020-.5 Dim Spar

Not Go
Go Goes
Go Goes

Ga. A-82025 .020-.040

Not Go
Goes
Goes

.520 ±

.025

.024

CC: R. A. Williamson
H. J. Hackman
R. B. Hurley
R. E. Wright

D. Garlock
Area Auditor
File

Ilion, New York
May 28, 1959

J. HENRY

MACHINE STUDY - STRADDLE MILL #3219
M/725 FLOOR PLATE #19800
OPER. 12 - STRADDLE MILL HINGE

Purpose: Classification.

Observation: The operation is being run to deviation of 12/26/57 which changes the width of the hinge from .368" ± 5 to .378" ± 5 to accommodate the oversize opening in the Trigger Guard.

As run, the operation is controllable for the width of the hinge (.378" ± 5 dim.) and the length from the rear end of the plate to the angle surface at sides of the hinge (4.235" ± 5 M/Dwg. dim.). The .633" ± 5 dim. however, is not in control to the gage on the job since this characteristic increased in width the same as the hinge when a larger spacer block was used between the cutters.

Process Engineer has requested a design change for the width of the hinge from .368" ± 5 to .378" ± 5. It is also understood that the thickness of the cutters are to be reduced by .005" so that the .633" ± 5 dim. can be maintained.

Method: Thirty (30) Floor Plates were taken in sequence from Oper. 12 (Straddle mill hinge) and measured as shown on attached sheet.

QUALITY CONTROL DEPARTMENT
A. D. Gordon, Supervisor

by A. B. Paulsen

ABP:I

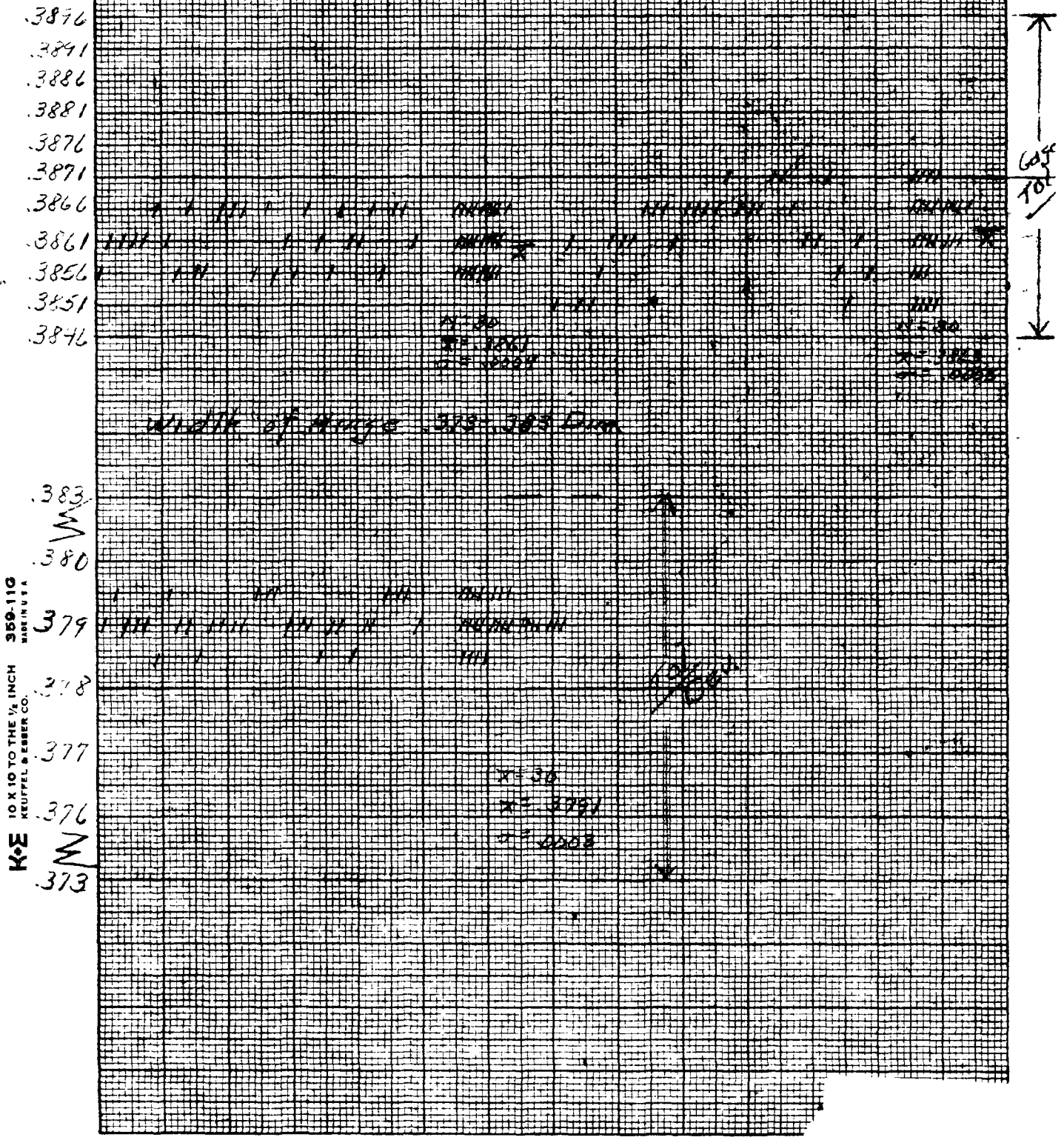
M-725 Floor Plate # 19800 Mach. # 3219

Open 1/2 Straddle Mill Hinge

Length From Rear End To Angle Surface of Sides of Hinge

Gap of Pads .3846-.3896 (Calculated) Milling Dim. # 2354

Left Side Right Side



725 Flor Plate

CC: R. A. Williamson
H. J. Hackman
R. B. Hurley
R. E. Wright
D. Garlock
Area Auditor
File

Ilion, New York
June 10, 1959

J. HENRY

MACHINE STUDY - DRILL PRESS #4511
M/725 FLOOR PLATE #19800
OPER. 16 - DRILL & REAM HINGE PIN HOLE

Purpose: Classification.

Observation: The operation is controllable.

Since there is no gage listed for checking the lengthwise position (4.335" ± 5 dim.) or the vertical position (.140" ± 5 dim.) of the pin hole, the ream side of the drill jig was used for these measurements after it had been checked satisfactorily by tool inspection.

The technique of using the drill and ream jig was used for checking the position of the hole since a slight warpage is present in the Floor Plates making accurate location difficult. The jig overcomes this warpage in clamping. It should be noted that the warpage is slight and probably would have a minimum effect on fit and appearance in the assembled gun.

Method: Thirty (30) pieces were taken in sequence from drill press #4511 and measured as shown on attached sheet.

QUALITY CONTROL DEPARTMENT
A. D. Gordon, Supervisor

by A. B. Paulsen
A. B. Paulsen

ABP:I

M-725 Floor Plate #19400 Oper. 12 Drill & Ream Hinge

Drill Press #4811 Pin Hole

Dia. of Pin Hole

.097

.096

.095

Position of Pin Hole from Rear End

Tol. Drill & Ream Jig #C

Short

O.K.

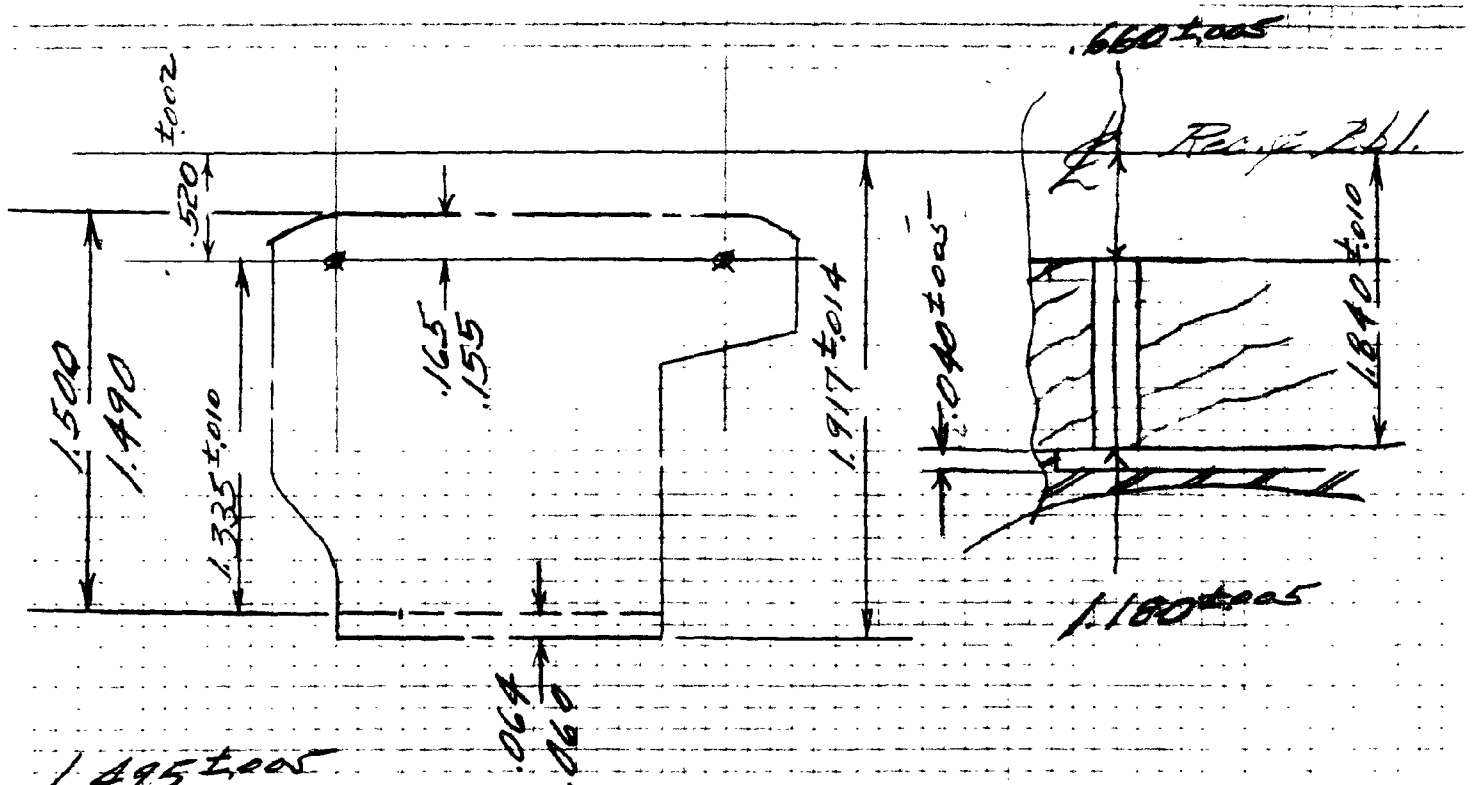
Long

Position of Pin Hole from Bottom

Low

O.K.

High



1.495 ±.005
.160 ±.005
1.335 ±.010
.062 ±.002
.520 ±.002
1.917 ±.014

1.100 ±.005
.040 ±.005
.660 ±.005
1.800 ±.015

1.100 ±.005
.660 ±.005
1.840 ±.010

1.917 ±.014
1.880 ±.015
.037 ±.029 Inter.

.005 to .066

M/725 - General

CC: R. A. Williamson
H. J. Hackman
E. B. Wallin
~~R. B. Hurley~~
A. D. Gordon
S. W. Fisher
C. O. Pardee

Ilion, New York
January 3, 1958

R. E. WRIGHT

M/725 PLANT TESTING & TARGETING

Temporarily all Model 725 30-06 caliber production will be submitted to separate functional and accuracy tests.

Gallery testing will be done in accordance with the procedure used on the M/721 30-06 caliber before adopting the combined "Target - Test". This procedure is as follows:

1. Put Safe in "on" position.
2. Position gun in jack (light shoulder setting).
3. Completely load magazine - 4 rounds. (Use following sequence)
   a. 3 light bullet type (150 gr. PMC)
   b. 1 heavy bullet type (220 gr. SPCL)
4. Try fifth round in magazine. Reject if able to close action over the fifth round.
5. Close action.
6. Move safe to "off" position.
7. Fire three (3) rounds (1 heavy, 2 light).
8. Feed last or fourth round from magazine into chamber but do not fire. Eject this unfired shell (light).
9. Move Safe to "on" position.
10. Remove gun from jack.

No retest is allowed and guns are to be rejected with one (1) or more malfunctions.

Accuracy testing or targeting will be done as per our current centerfire targeting procedure for 30-06 caliber using the 220 gr. bullet.

There will be no test procedure detail sheets issued covering this interim testing for it is hoped that the quality level of early production quantities will be such that we can shortly adopt the combined "Target - Test" method.

Test reject sheets to be made out and turned in to writer daily.

PRODUCT TESTING SPECS.
W. A. Best, Supervisor

By R. F. Kerr

RFK:I

CC: V. G. De Roos
A. D. Kerr
~~H. R. Burley~~
K. R. Chadrick
A. J. Castelle

Ilion, New York
July 5, 1957

W. R. PARSONS (2)

MODEL 725

This is the first authorized transmittal of model drawings for the Model 725. The components listed in this transmittal are never machine fabrication.

1. Bolt Stop Pin B-16417 - This part will be purchased complete ready for heat treat. The vendor is to fabricate diameter "A" to .1249"-.1255".

2. Bolt Handle C-16433 - This part is to be purchased as a blank. The vendor will form a .338"-.342" radius and Remington will machine to .342"-.350" radius. All tooling which the vendor has for fabrication H/721-722 Handle C-17222 can be utilized for Model 725 Bolt Handle C-16433. However, C-16433, Bolt Handle, an additional bend has been incorporated 2.425R which changes the length from the centerline of the .338"-.342"R to 2.470.

3. Floor Plate Latch Pin A-16463 - This is a standard type "C" Driv-Lok Pin and it will be purchased ready for heat treat.

4. Front Sight Pin A-16461 - This is a standard type "A" Driv-Lok Pin and it will be purchased ready for heat treat.

5. Floor Plate Pivot Pin A-16462 - This part will be purchased complete ready for assembly.

6. Trigger Plunger A-16711 - This part is to be purchased ready for heat treat.

The purchase inspection and material procurement records are attached. The vendor's tooling is to be charged to work order number 70519 per V. G. De Roos.

P. B. Croop, Supervisor
Process Engineering
New Products & Tool Design

J. Carter
Process Engineer

JC/fs
Attach.

725 general

MODEL 725 - "A" GRADE
(Standard Barrel)

"A" - Parts Altered from M/721-722 Design
"N" - New Part Added
"Om" - Omitted

	Drawing No.	Part Name	Modification
(A)	D-23755X	Receiver (Long & Short)	Eliminate counterbore and drill & tap for center guard screw; eliminate counterbore for drilling bolt stop pin. Change end mill cut for bolt lock to profile cut. Add straddle mill cut behind bolt handle cut.
(A)	D-18570X	Barrel (Standard)	New contour without hump, 22" long (comes out of M/740-760 barrel blank)
(A)	C-24200X (MM D-94 barrel drawing)	Barrel Assembly	Drill and tap for rear sight; pin for front sight.
(A)	B-16367X	Front Sight Ramp	New contour, and slightly higher
(A)	C-23805X	Front Sight	New contour (higher), and drill for bead
(A)	A-16433X	Front Sight Bead	Replaces soldered bead (stainless).
(N)	C-16366X	Rear Sight Base	Replaces Rear Sight dovetail of M/721-722
(Om)	A-18685 ✓	Open Sight Base (dovetail)	
(N)	A-16023X	Rear Sight Base attaching screws (2)	St'd. 6x48 Scope Block Screws
(A)	C-16368X	Rear Sight Leaf	Folded and drilled to allow attachment by screws
(N)	A-16369X	Rear Sight Adjusting Screw, Right	
(N)	A-16370X	Rear Sight Adjusting Screw, Left	
(A)	C-16433X	Bolt handle (stainless)	Swept back bolt handle

	Drawing No.	Part Name	Modification
(A)	D-16422X D-16423X	Stock (short action) " (long action)	Eliminates difference between high comb and low comb. Barrel, Safety, and guard inletting changed, plus outside contour. Note: [illegible] and mill spread of [illegible] be done after outside contour of [illegible] has been cut.
(A)	D-24195X	Trigger Guard (short and long)	7551 "forged" aluminum, electropolished. Replaces stamped steel - 721-722 Guard.
(Om)	B-17055	Trigger Guide Plate	
(Om)	A-17580	Center Guard Screw	
(A)	C-16430X	Magazine	Trim off bottom edge to horizontal
(A)	C-19450X	Trigger	New contour of finger piece
(A)	C-16429X	Trigger Housing	3 safety detent holes. Includes alteration of chamfer and location of the present two.
(N)	D-16411X	Safety Lock Thumbpiece	
(N)	B-16415X	Bolt Lock	
(A)	B-16413X	Safety	Eliminate thumbpiece, reverse cam, and provide two gear segments.
(A)	B-16419X	Safety Cam	Change contour.
(A)	B-16421X	Safety Detent Spring	Change contour.
(A)	B-16417X	[illegible]	Add head, and groove for retaining spring.
Add-Use	A-17044	[illegible] Snap Washer	Same as Safety Snap Washer

CSC:NL
6/5/56

M/25 - From [illegible] Dover

[illegible] Specialist ✓
Remington Mfgd. _____

Ref. - File Folder # [illegible]

SUMMARY

BEFORE AND AFTER HEAT TREAT STUDY

MODEL 725 COMPONENT NAME FRONT SIGHT COVER PART NO. 16355

#	CHARACTERISTICS CHECKED	Parts	Before H.T. In	Before H.T. Out	Effect thru H.T. Signif.	Effect thru H.T. Insignif.
	.410 ± .010" dim.					
	Front					
	Rear					
	Parallelism					
	CC: R. A. WILLIAMSON					
	R. B. HURLEY					
	~~W. A. BEST~~					
	K. R. CHADWICK					
	P. B. CROOP					
	~~J. CARTER~~					
	FILE					

STEEL SPECIFICATIONS: AI SI C1095

HEAT TREAT SPEC. - HARDEN _____ DRAW _____

HEAT TREAT RESULTS: IN ___ OUT ___ IN ___ OUT ___

PARTS PER LOAD - REG. _____ THIS TEST _____

RACK _____ BASKET _____ OTHER _____

DESCRIPTION: Neutral Salt Harden
Temp. 1525°-1550° F 10 Min. Oil Quench
Nitre Black
900° F 10 Min. Water Quench

REMARKS: Covers showed a significant change through heat treat both on the .410" ± .010" dim. and the parallelism of front and rear ends.

Date Started 3/3/58 By ABP

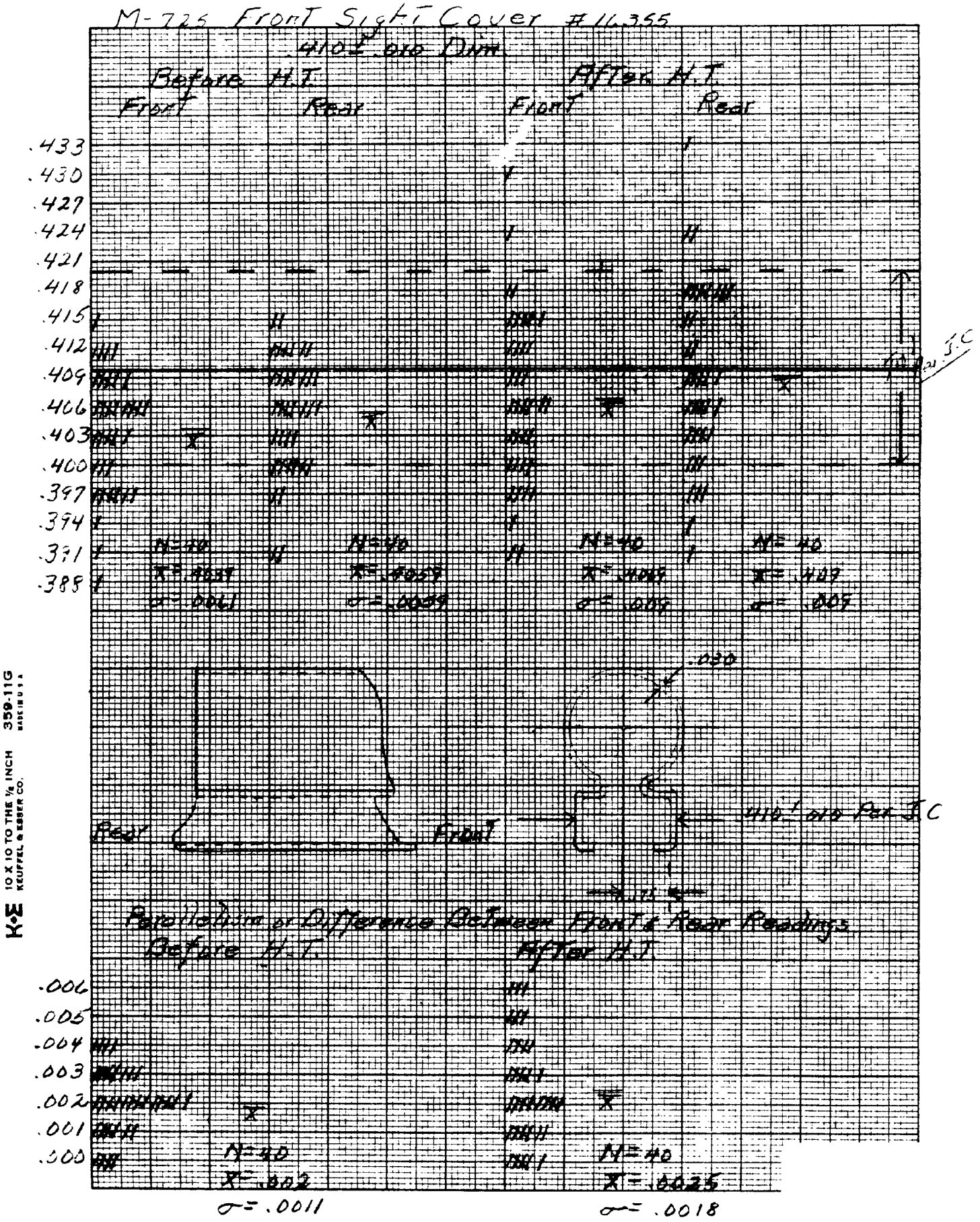
Date Completed 3/6/58 By ABP

Date Issued 3/6/58

QUALITY CONTROL DEPT.
A. D. Gordon, Supvr.

By [illegible] 3/6/58

ABP:I



M/725 - Safety

CC: R. A. Williamson
H. J. Hackman
R. B. Hurley
L. J. Boyle
J. W. Miller
K. R. Chadwick
J. Smyder
Area Auditor
File

Ilion, New York
January 29, 1958

K. C. O'CONNELL

SPECIAL AUDIT
M/725 SAFETY GEAR & M/725 SAFETY LOCK THUMB PIECE ASSEMBLY
DIAMETER OF HOLE IN SAFETY GEAR

Purpose: To determine the size of the hole in Safety Gear relative to the assembly problem of undersize holes in Safety Lock Thumb Piece Assembly.

Observation: The size of the hole in the Safety Gear before the braze operation is well within the model drawing limits of ± .0015".

The small hole condition referred to above appears to be due to a burr in the edge of the hole, noted in about 40% of the samples checked. The burr is consistently in the same approximate position and appears to be related to the technique of orienting the Safety Thumb Piece and Gear components in the welding fixture in relation to the welding contacts. This item has been discussed with Chem. & Met. who have contacted production personnel.

Method: Forty (40) Safety Gears were taken from sub-assembly and the size of the hole measured with expanding balls and mics. (Top of attached sheet).

Forty (40) Safety Lock Thumb Piece Assemblies were taken from assembly and the hole size of the gear measured with variable plugs. (Bottom of attached sheet).

QUALITY CONTROL DEPARTMENT
A. D. Gordon, Supervisor

by A. B. Paulsen
A B Paulsen

ABP:j

R D 6360A

PRODUCT CONTROL CHART

OPER NAME

MOD No 725 PART NAME Safety Gear PART No 16723 MACH. No OPER No

GAGE NO Exp Balls DIMEN .1255-.1285 CHARACTER Hole Dia.

M/D DIMENSIONS — DIAL READINGS — PLUS + / MINUS −

.1285	
.1280	II
.1275	~~IIIIIIIIIIIIIIII~~
.1270	~~IIII IIII~~ $\bar{X}$
.1265	II
.1260	
.1255	

40

N = 40
$\bar{X}$ = .1273
σ = .0003

SPREAD

AVERAGE

COMMENTS

Safety Lock Thumb Piece Assembly
Sample 40
19 - Take .127 Plug
5 - " .126 Plug
16 - " .126 " as far as burr on end of Gear.

GAGE No. DIMEN CHARACTER

M/D DIMENSIONS — DIAL READINGS — PLUS + / MINUS − — 0

SPREAD

AVERAGE

RD-5038

EQUIPMENT INSPECTION REPORT

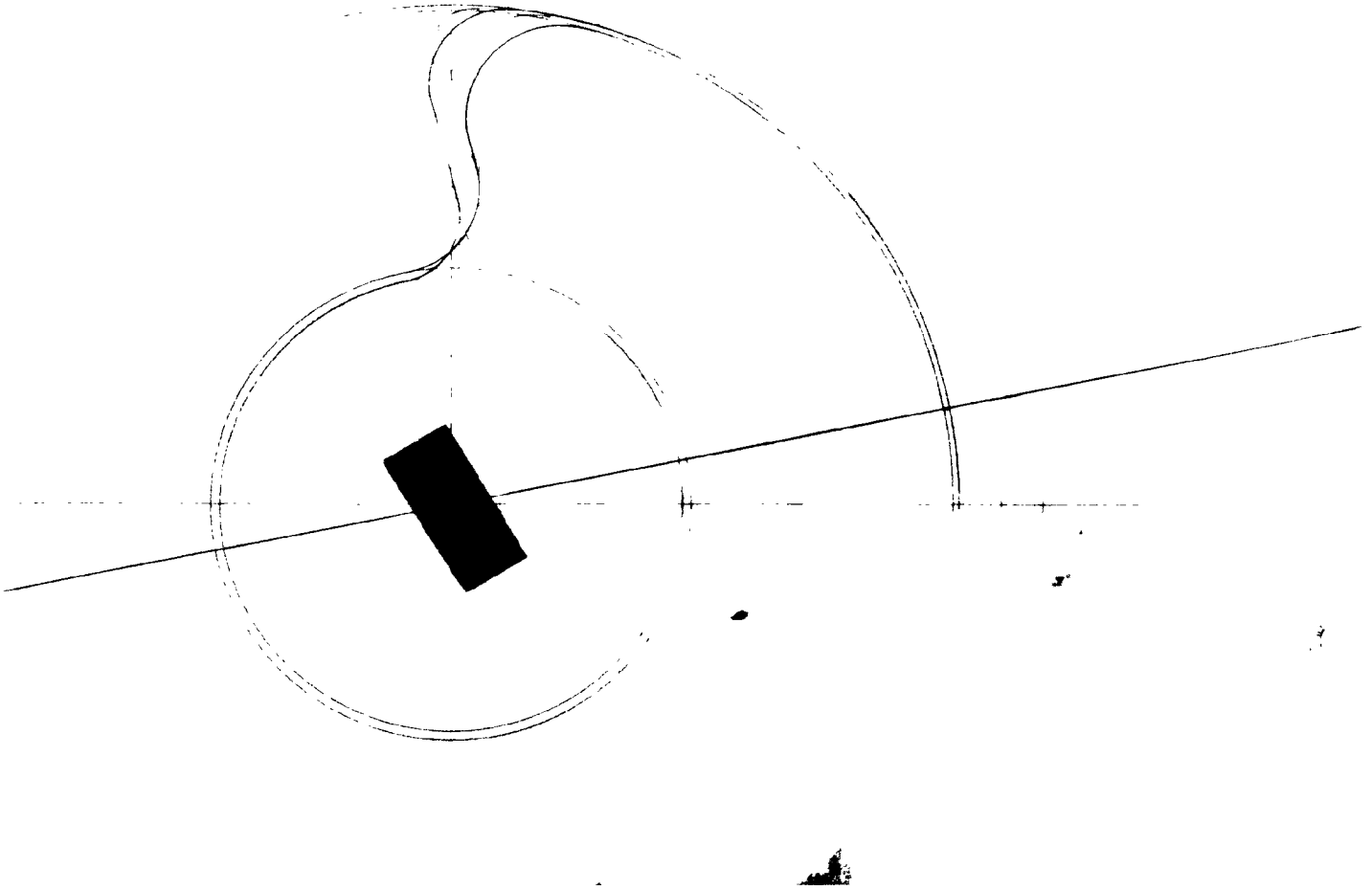
SUBJECT M/725 Housing TO DEPT. NO.

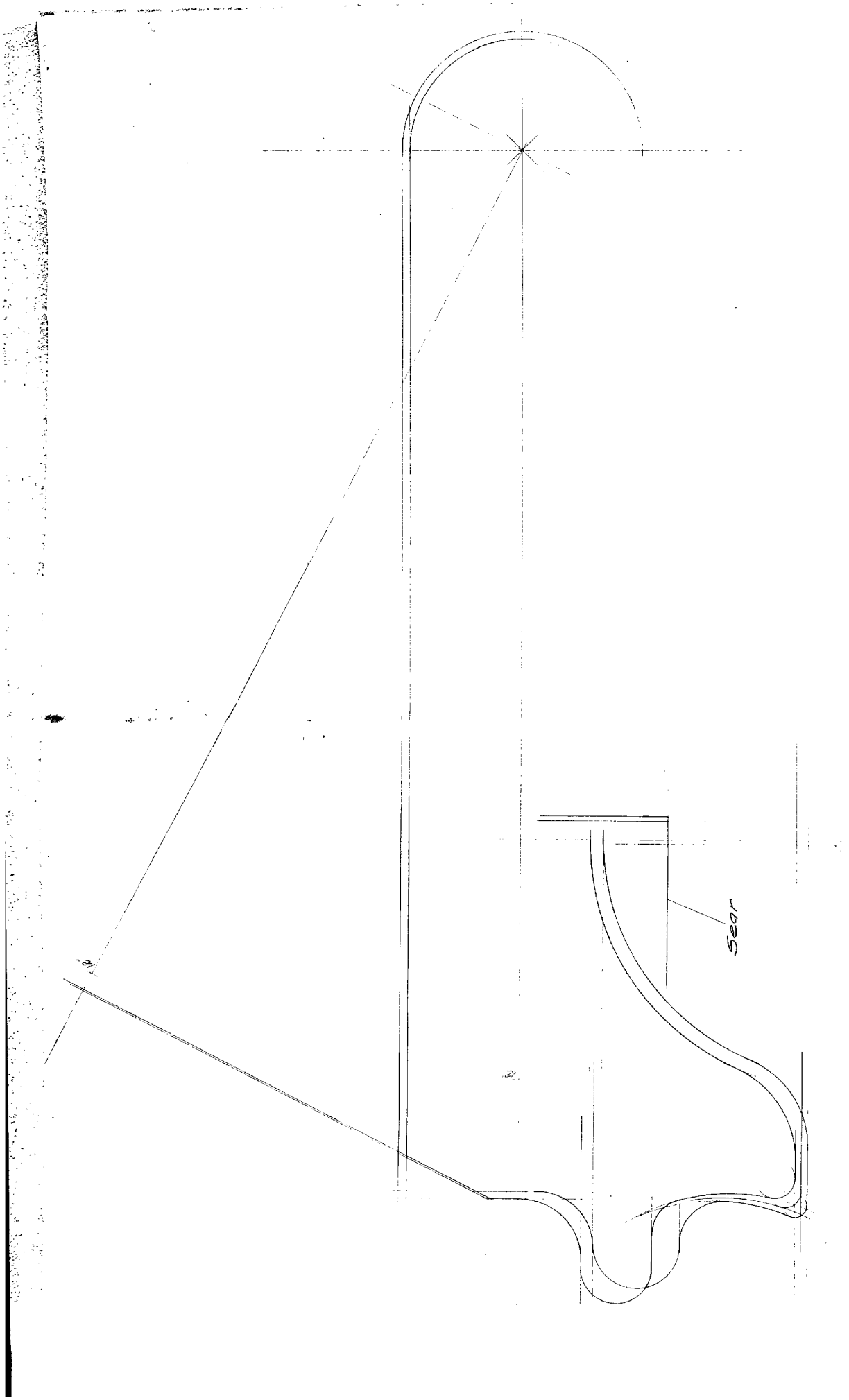
INV'TY NO. C-16429 ORDER NO. 29— DWG. NO C-16429 DATE 12-12-57

Chk 2 Housings

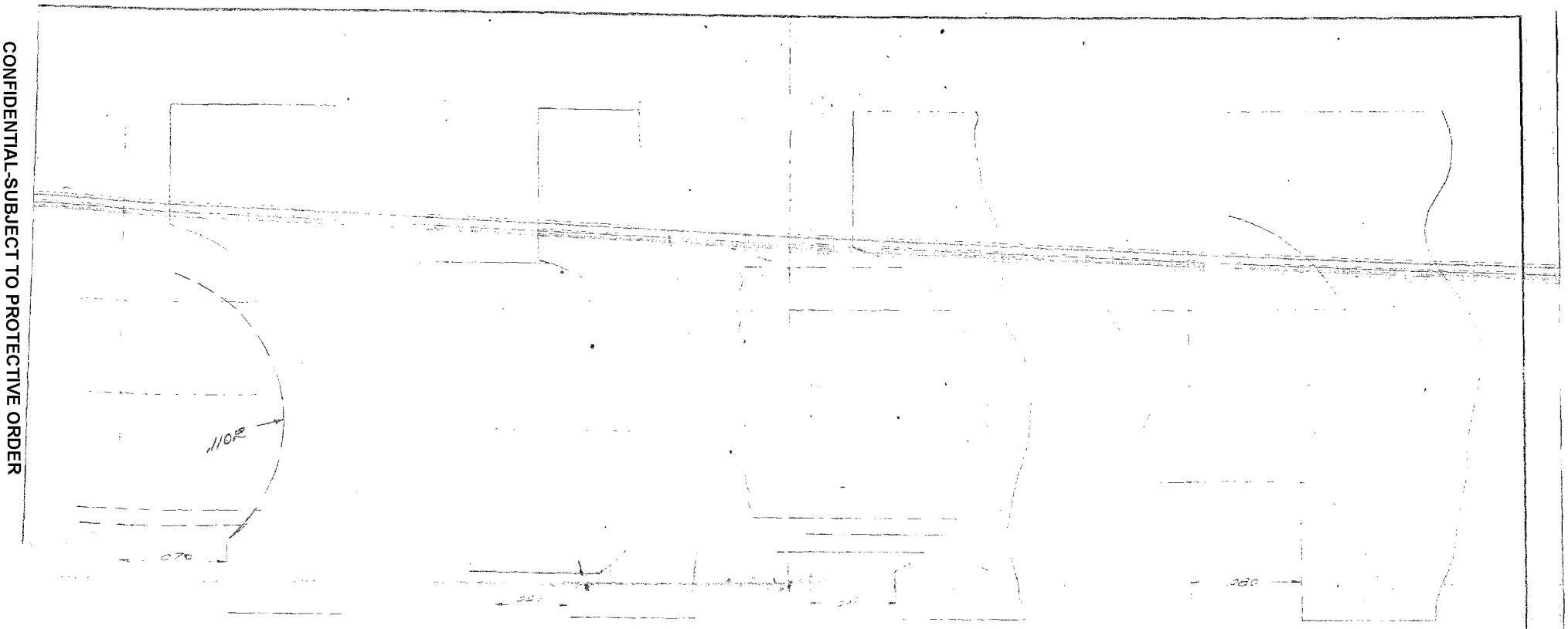
	# 1	#	
.6092 - .6052	.606	.604 ✓	-.001
.7812 - .7772 ✓	.781 ✓	.777	OK
.957 .953	.956	.9515 ✓	-.001
.624 .620	.614 ✓	.618 ✓	-.002
.637 .633 ✓	.623 ✓	.630 ✓	-.003
.694 .690	.684 ✓	.691	OK

INSPECTOR Comstock CORRECT PASSED BY DEL. TO




Sear

N/725 - Barrel



.300 Bore .508 O.L. B-74993-W Tool .232 ℄ of Rad	.219 Bore .458 O.D. B-74993-1 Tool .210 ℄ of Rad	Dash L.L. .300 Bore .458 O.D. B-74993-T Tool .222 ℄ of Rad	Sol. a Lines .253 & .273 Bore .598 O.D. B-74993-T Tool .222 ℄ of Rad	.351 Bore .598 O.D. B-74993-S Tool .244 ℄ of Rad.
30-06 300 SAV 308 Win	.222 .244	300 H&H	.257 .270 .280	.35 Rem

SCALE - 20 = 1

NEW
FOR ABOVE
PLUS
.270
.280

DO NOT SCALE DRAWING

RECORD OF ALTERATIONS	ADDITIONAL USES	CONT'N DWG.
		DETAILS

DETAIL NO.	MATERIAL SPEC.	STOCK SIZE	AMOUNT REQ.

TOLERANCES NOT OTHERWISE GIVEN
1 PLACE (.1) – TOLERANCE ±.05
2 PLACE (.01) – TOLERANCE ±.010
3 PLACE (.001) – TOLERANCE ±.005

REMINGTON ARMS COMPANY, INC., ILION, N. Y.

SCALE	MODEL	PART DWG. No.
PART		
TOOL		
OPERATION		

DESIGNED	BY	DATE	APPROVED	BY	DATE
DRAWN			SUPD'S DWG. No.		
CHECKED			DRAWING No.		

UNLESS OTHERWISE SPECIFIED REMOVE ALL BURRS AND SHARP CORNERS—.010 R

.640
.2375
.4025
.1625
.2475
.1875
.0625

.08703-.03668
.0564
.25748
.08703
.03668
.05643

M/721 BR ASSEM. 222-264
LOC. OF FRONT SIGHT RAMP PIN HOLE
SCALE 10:1

DETAIL NO.	MATERIAL SPEC.	STOCK SIZE	AMOUNT REQ.

TOLERANCES NOT OTHERWISE GIVEN
1 PLACE (.1) — TOLERANCE ± .03
2 PLACE (.01) — TOLERANCE ± .010
3 PLACE (.001) — TOLERANCE ± .0005

RECORD OF ALTERATIONS	ADDITIONAL USES	CONST'N DWG.
		DETAILS

REMINGTON ARMS COMPANY, INC., ILION, N. Y.

SCALE MODEL PART DWG. No.

PART
TOOL
OPERATION

DESIGNED	BY	DATE	APPROVED	BY	DATE
DRAWN			SUPD'S DWG. No.		
CHECKED			DRAWING No.		

Form R. D. 526-Rev. 3

SEQUENCE OF OPERATIONS

OP. No	OPERATION	DEPT	OP. No.	OPERATION	DEPT
65.	Centerless grind, wipe, and mark for identification.	58			
70.	Face to length and crown	58			
75.	Centerless polish Barrel	57			
	READY FOR BARREL ASSEMBLY PROCESS	58			

DATES AND REASONS FOR REVISIONS 11/14/57 -New - RWS - 252613

DATES AND REASONS FOR REVISIONS

MODEL 721 - 722 - 725
Common Sight Line

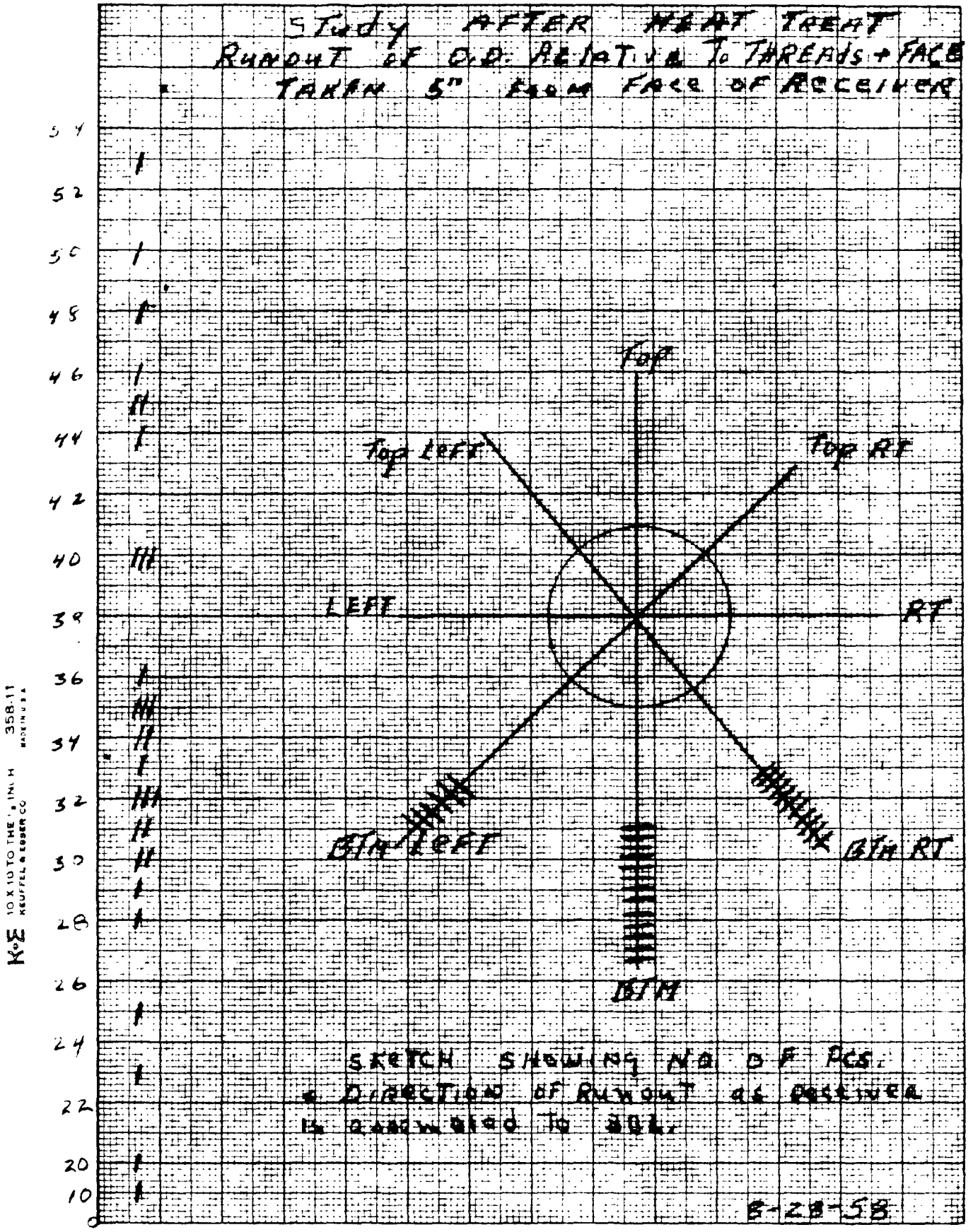
PART NAME Barrel

PAGE 2 OF 2

GA. OR CAL.	30-06	300 H&HMag.	308 Win.	280 Rem.	270 Win.	.257 Robt.
PART No.	24515	24562	24518	24519	24516	24517
	244 Rem.	222 Rem.				
	24560	24561				

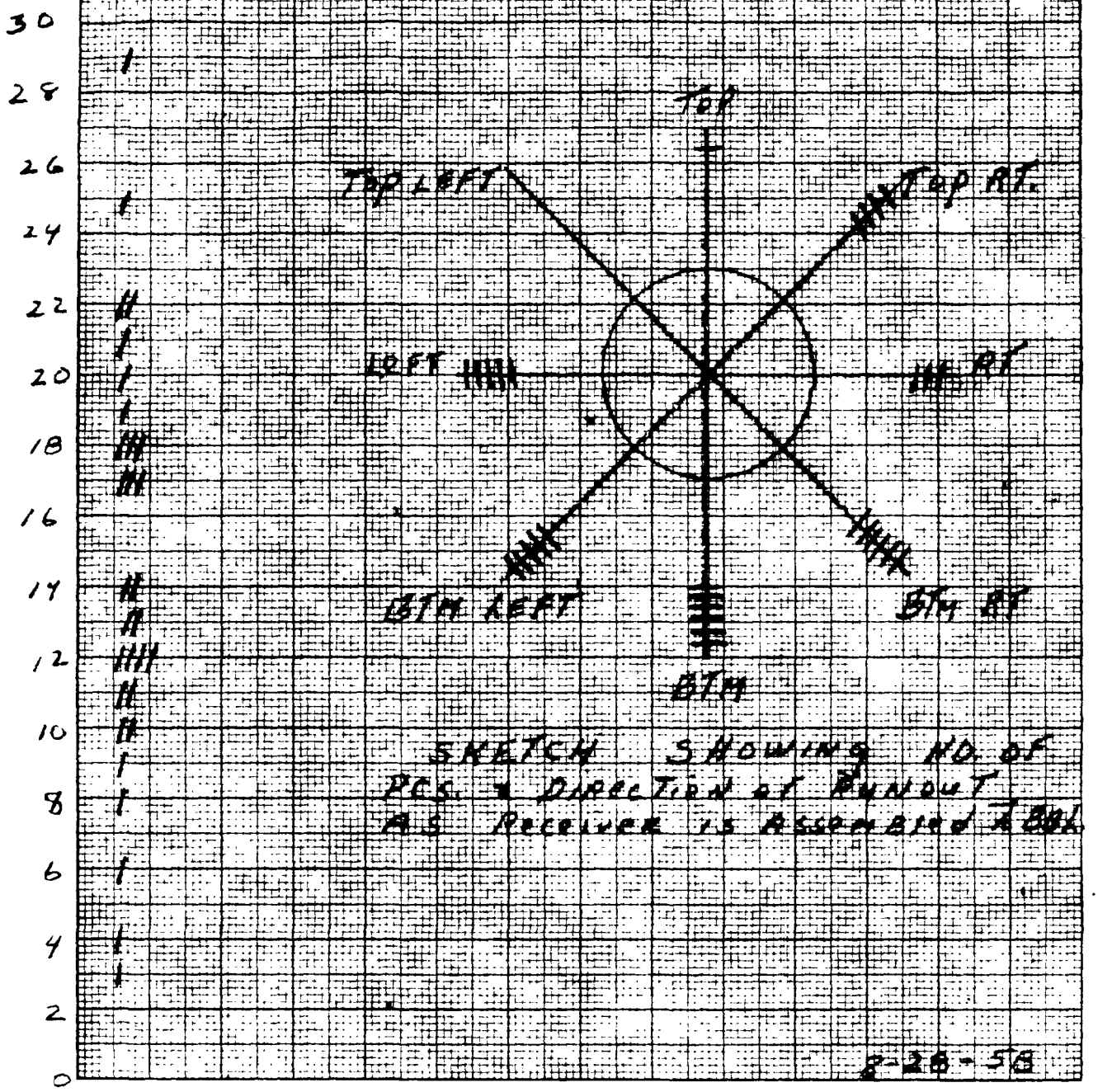
RD-6460


M/785 MODIFY BOLT HOLE



R Hurley

STUDY BEFORE HEAT TREAT
RUNOUT OF O.D. RELATIVE TO THREADS & FACE
TAKEN 5" FROM FACE OF RECEIVER



SKETCH SHOWING NO. OF PCS. & DIRECTION OF RUNOUT AS RECEIVER IS ASSEMBLED TO BOX

8-26-58

CC: W. A. Best
R. W. Selwood
A. D. Gordon
K. R. Chadwick
R. B. Hurley

Ilion, New York
August 27, 1958

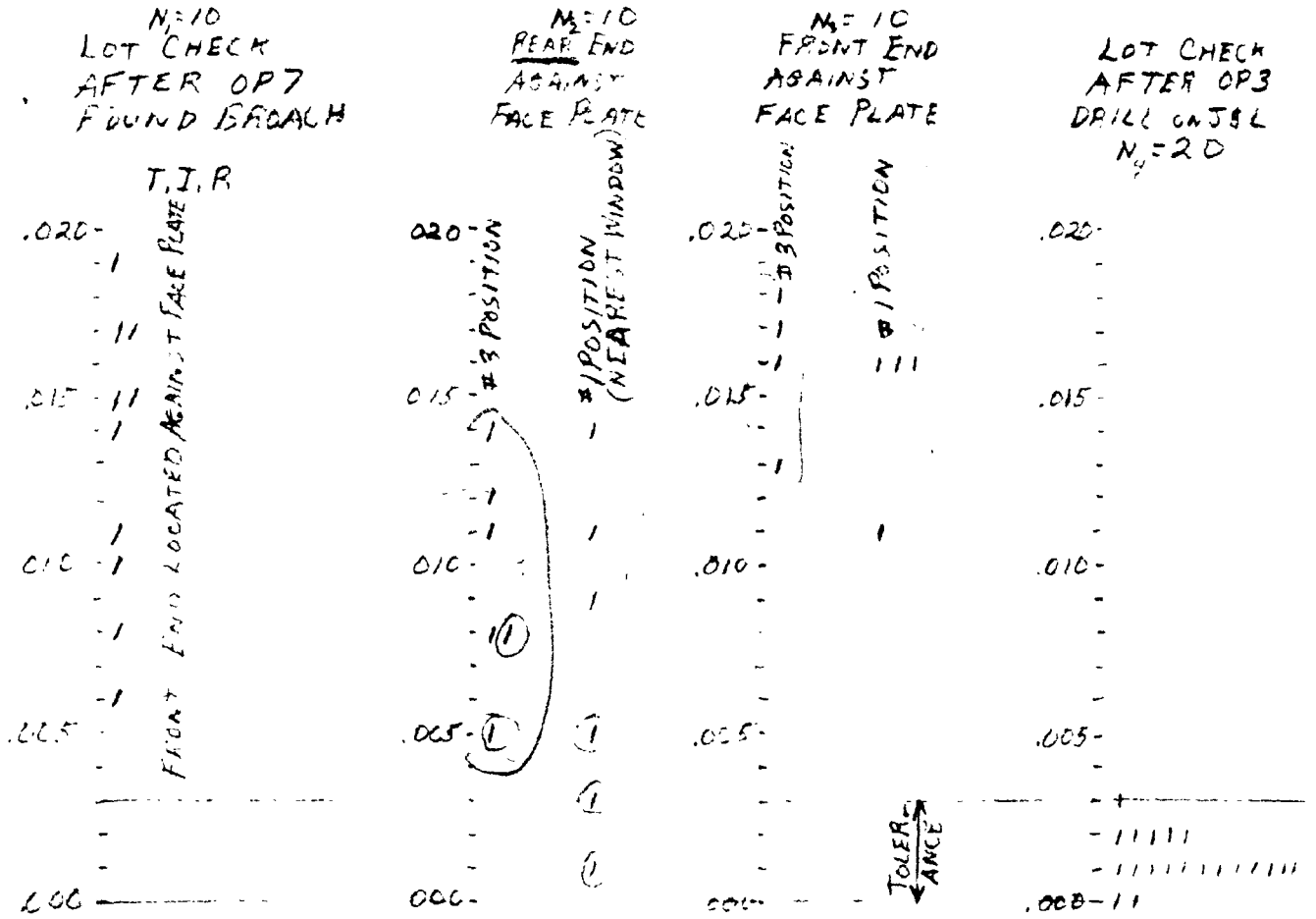
HEADING CHECK - 50 PROOF LOADS
M/725, 270 CAL. - WARPED RECEIVERS
CHECKED EVERY 10th ROUND

Gun Number	Original Reading	10th Round	20th Round	30th Round	40th Round	50th Round
706627	2.054"	2.0555"	2.054"	2.054"	2.0545"	2.0545"
	2.053"	2.055"	2.054"	2.055"	2.0545"	2.054"
	2.0535"	2.0555"	2.054"	2.0545"	2.055"	2.0545"
706621	2.0515"	2.0525"	2.055"	2.054"	2.0535"	2.0535"
	2.052"	2.053"	2.054"	2.0535"	2.054"	2.0535"
	2.052"	2.0525"	2.054"	2.0535"	2.054"	2.0535"

Min. 2.050"
Max. 2.055"

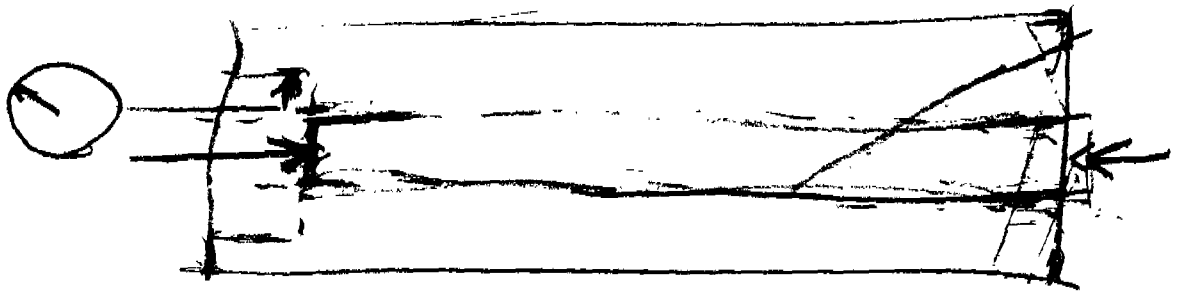
GMarkley:I

BY F. HUNT DATE 7-3-58 SUBJECT 721 RECEIVER SHEET NO. 1 OF 1
CHKD. BY DATE BBL HOLE & ECCENTRICITY JOB NO
COMPARE ECCENTRICITY GA. D-51341



N_2 AND N_3 CAME FROM N_4

THE 5 CIRCLED PARTS ARE THE ONLY ONES O.K. ON FUNCTIONAL GA. C-53609 AFTER SPLINE BROACH OP16



REMINGTON ARMS COMPANY INC

DEPARTMENT SUPERINTENDENT COMPUTATION SHEET

/

M/725 Receiver - Bolt hole finish & runout
Revisions to status since 12-2-57 F. Hunt DATE 1-23-58

1. Reaming is being done on the J & L by use of op 4

2. The process record is being revised to allow the reaming to be replaced by broaching. Op 4A & 4B will be allowed to be used with an inspection operation (op 6T). Runout must still be held to .010 max T.I.R. on parts for M/725

3. M & S (Bob Hall) is evaluating the proposal to:

Drill, rough bore & c'sink on the J & L.
Broach the bolt hole to finish size on op 4B
Face & c'bore with a piloted tool on a #3 Way Drill Press
Tap with a piloted tap on a lead screw tapper.

The reamer continues its bad performance on the J & L
we have experimented with reamer geometry as follows:
1. more lead angle
2. less primary land
3. more & less primary clearance

we have increased & decreased speed
we have increased & decreased feed
we have used floating holders
" " " rigid "
" " " sloppy "

a carbide expansion reamer B-TS-2501-1 is on Cy Douglas to be fitted to the combination facing & c'bore tool, in the O. 525 70

REMINGTON ARMS COMPANY INC

ENGINEERING DEPARTMENT DUPONT COMPUTATION SHEET SHEET 2

PROJ. NO.

SUBJECT WORKS

COMPUTER DATE 19

Brass reaming was tried on the flat bed reamer. Finish was acceptable but alignment is not improved over ~~the broach~~ what the broach will produce.

Very little trouble is encountered with torn finish, the typical waviness or chatter finish. The reamer often dulls in producing the first piece.

All I can do is to make a "TS" of .696 dia drill to replace the .683 drill. It is hoped that the .702 dia. reamer may be fed more rapidly than

Regular reamer speed is 178 rpm
" " feed is .011"/rev.

The newest possibility is that ~~the~~ alignment produced by the broach would be 100% satisfactory, if the spoke holes can be drilled after the barrel is assembled.

F. Hunt
12-2-57

(1)

To: R. B. Hurley
From: F. Hunt
Subject: M/725 Receiver - Bolt Hole Finish & Runout

It has been difficult to get a satisfactory smooth hole at all times. The problem existed on the 40-X, but the problem is greater now because of the ~~high~~ production schedule for the M/725. ~~which~~

Two methods are being used to produce Receivers.

1. The first (and preferred) method includes reaming per op 4 (on the J & L turret lathe).
2. The second method is being used to maintain production when reamer and material problems prevent method 1. Parts are drilled per op 4A (on the J & L). The c'bore & tap used have long pilots to fit the drilled hole. The hole is broached to size on op 4B.

Parts by both methods are being gaged 100% for runout. Some of the hole alignment is lost by broaching. A few (less than 5%) of the unreamed parts have excess runout (over .010"). None of the reamed parts exceed the allowable runout.

To date about 3000 Receivers have been produced for M/725.

F, Hunt
12-2-57
(2)

a trial lot of 1000 pounds of leaded steel was tried satisfactorily. The reamer was used on all of the parts run from the lot. The leaded steel made drilling and reaming easier, so 5000 pounds more has been ~~ordered and~~ received.

Last week a new shipment of reamers was received. One of these reamers has been put to use on the unleaded steels. It reamed smooth straight holes; but most of the holes were blue indicating high temperature.

The difference between a "good" reamer and a "bad" reamer (or between "good" steel and "bad" steel) is difficult to determine. They are "borderline" most of the time. If continued tests of leaded steel give improved machinability, then we should stay with leaded steel for this job.

Experiments were tried with other methods and tools.

1. a spade type center drill TS-3157-1 and single lip gun drill TS-3157 were tried. The hole produced was rough, apparently due to the chips not breaking up. If higher oil pressures were available, the chips might break up and finish might improve

(3) F. Hunt
12-2-57

2. A .668" crankshaft drill and .682" reamer were tried. Finish was o.k. when the reamer grind was altered. However the part still had to be broached on op. 4B. This method was dropped, because a drilled hole at .682" will give the same finish after broaching. When drilling to .682", it is necessary to use long pilots on the bore and tap to fit the drilled hole.

3. A spade type center drill and a matching spade type point on a crankshaft drill were tried. The hole was rough

More experiments are planned as follows:

1. C. Doyle will try various feeds and speeds on the gundrill TS-3157. The object to find a set of conditions that will allow us to drill without reaming. Hole finish and runout must be satisfactory.
2. Try a carbide expansion reamer. One is now on order per B-TS-2501-1-W. An attempt will be made to get better reamer life and perhaps higher feeds and speeds to reduce cycle time.
3. E. Stheed will try draw reaming in place of broach op 4B.

F. Hunt
12-2-57

(4)

Briefly, the runout problem has been solved by using either method 1 or 2. The finish problem has been handled the same way.

Finish is difficult to maintain. Two types of bad finish are most prevalent.

1. a torn finish seems to result when the material stocks up or is too ductile.
2. a spiral waviness has resulted sometimes. The hole has been undersize. This condition was corrected by face grinding the cutting edge to a keen edge. The finish improved but we got only 50 pieces per grind on unleaded steel.

Experience on the 40-X has been 100 to 400 pieces per grind.

F. Hunt
11-22-57

M/725 RECEIVER - BOLT HOLE FINISH & RUNOUT

There has been considerable difficulty in getting the reamer to produce a smooth hole. Consequently, two methods are being used to produce Receivers.

1. The first method, which is preferred, is reaming per Oper. 4. This has been working on most of the material available. The 45° lead on the front of the reamer was changed to 30° and the face of the flutes at the front were reground to insure a keen edge. Grind life is very poor (about 50 pieces per grind).

2. The second method is used when good reamers are not available. Parts are drilled per Oper. 4A. A piloted c'bore and a piloted tap is used. The hole is broached to size per Oper. 4B. Some of the hole alignment is lost by broaching.

Parts by both methods are being gaged 100% for runout. Very few (less than 5%) are over the .010" max. allowable T.I.R.

To date, about 2500 Receivers have been produced for M/725.

More experimental work is being attempted.

1. E. Streed will try draw reaming in place of broach Oper. 4B.

2. C. Deyle will try various feeds and speeds on the Barrel type drill TS-3157 and spade type drill in an attempt to drill without reaming. The present "Crankshaft" type drill produces holes with acceptable runout but the finish is not smooth enough.

3. A carbide expansion reamer, B-TS-2501-1-W, is on order to try to get better reamer life and perhaps higher feeds and speeds to reduce cycle time.

Some things which were tried on the J & L but were not successful so far are:

1. Spade type center drill TS-3157-1 with single lip barrel type drill TS-3157. Attempt was made to finish to size this way. The hole produced was rough, apparently due to the chips not breaking up. Perhaps with higher oil pressure, the chips would break and finish improve.

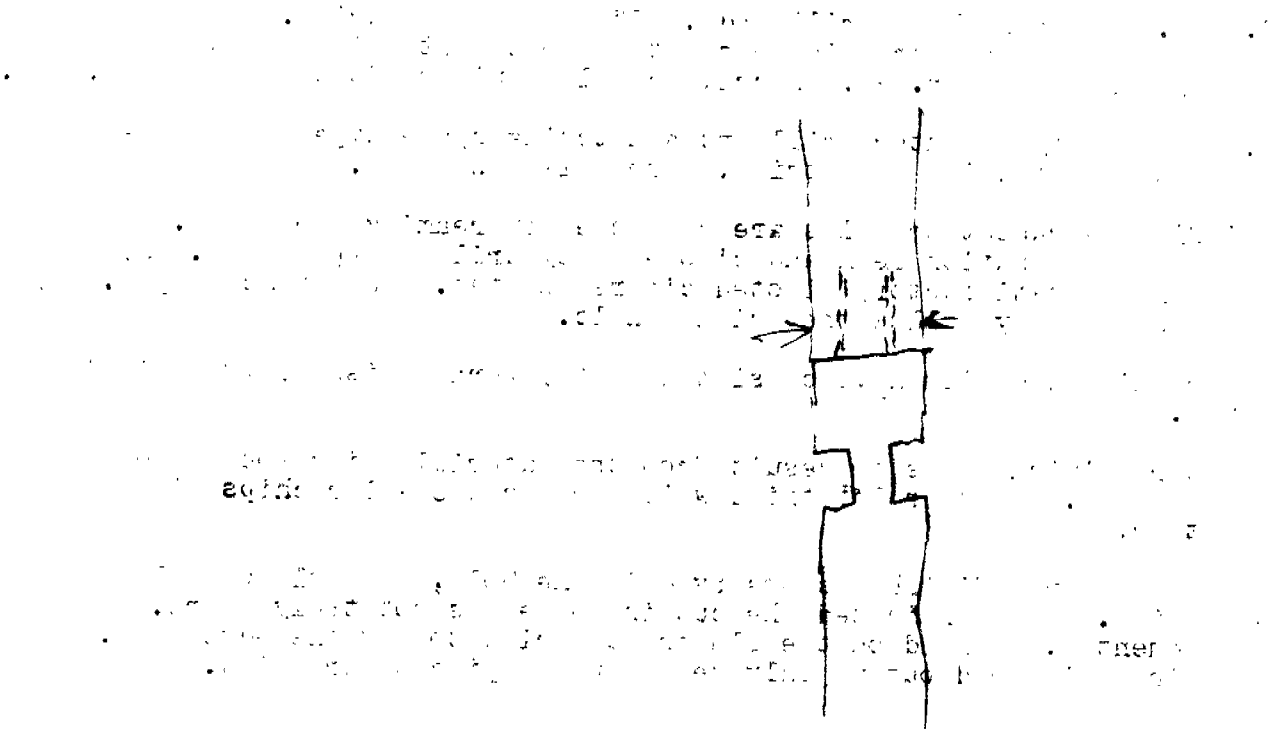
2. A .668" crankshaft drill and .682" reamer were tried. Finish was ok when reamer grind was altered but part still had to be broached on Oper. 4B. A drilled hole would be just as good at .682".
   WITH PILOTED C'BORE & TAP
3. A spade type center drill and a matching spade type point on a crankshaft drill were tried. The hole was rough.

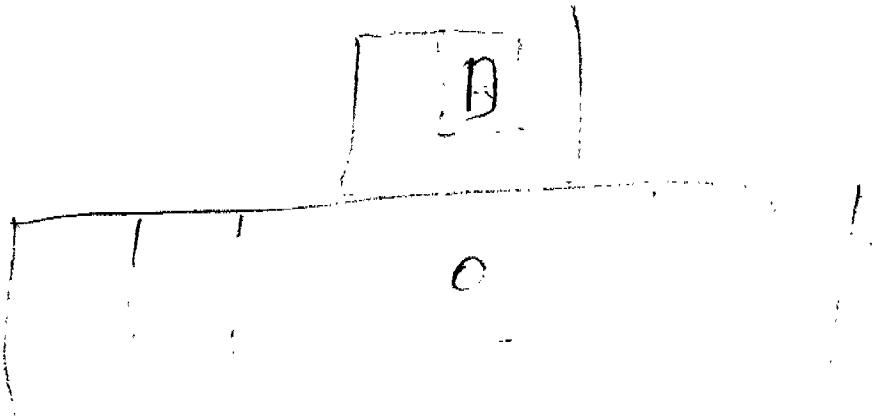
Briefly the runout troubles was corrected by reaming (Oper Oper. 4) with the combination ream and c'bore, or by drilling (Oper Oper. 4A) and using a satisfactory piloted c'bore and tap. The broach (Oper. 4B) will essentially follow the drilled hole,

The reaming troubles have consisted of (1) torn finish or (2) spiral waves.

The torn finish seems to result from the material being too tough and ductile. Another lot tried which produced smaller chips did not tear.

When the spiral finish was observed in the hole, the hole was also undersize. This indicated the cutting edge was not truly sharp. Consequently, a grind on the flutes was tried to get the edge keen. The finish is good but we only get about 50 pieces per grind.




D

(1 Roy Williamson
(2 Joe Boyle

CC: R. W. Selwood
F. Hunt
E. Folmsbee

For your info & action. Engineers working on this and agree conditions cannot be lived with.

January 9, 1958

L. J. BOYLE

M/725 RECEIVER

From the time we started the M/725 Receiver up to the present time, we have run 4600 Receivers. These were all run on Oper. #4- Line Ream Bolt Hole.

We started this operation in October and have used (8) combination reamers #74686V at a cost of $114.70 or $917.60 ~~per reamer.~~

This operation has not run satisfactorily. Reamer does not cut properly.

Reamers were marked to determine how many receivers we got per grind with the following results:-

Reamer	#1	0 Receivers	#2	1 Receiver	#3	50	Receivers
	"	30 "	"	4 Receivers	"	41	"
			"	1 Receiver			
	#4	50 "	#5	0 Receivers	#6	32	"
	#4	1 Receiver	#5	7 "	#6	0	"

Process Engineering have worked with us constantly but have not been able to determine what is wrong.

The Reamers we have on hand are nearly worn out and the prospects of getting other reamers is not good. As a result, this operation will have to be down.

EEF:mc

E. E. Folmsbee, Foreman
Dept. 73

16 Rec/Grind

13 Grinds

217

4600 | 9200 | ~~.10~~ .20
9200

CC: R. A. Williamson
H. J. Hackman
R. B. Hurley
L. J. Boyle
D. F. Cook
R. W. Selwood
E. E. Folmsbee
Area Auditor
File

Ilion, New York
January 3, 1958

F. HUNT

PROCESS STUDY - M/725 RECEIVER
J & L MACHINE - OPER. 4 & ALTERNATE OPERATIONS 4A & B

Purpose: To compare results obtained with current tooling for the concentricity (or runout) of the Bolt hole with the Barrel thread.

Observation: Concentricity - Bolt hole with Barrel thread.

Ga. D-71544 was used for this check. Results indicate the technique used for Oper. 4 (outlined on attached sheets) is significantly better than that used for alternate Operations 4A and 4B.

The significant difference between Operation 4 and the combined alternate Operations 4A and 4B is the finishing of the Bolt hole to size. Oper. 4 uses a single form tool for reaming the Bolt hole to size, finishing the c'bore and facing the front end to maintain the concentric relationship. Oper. 4A rough drills the Bolt hole which is broached to size on Oper. 4B. The c'bore for Barrel thread and face are finished by a single tool which is designed to maintain the relationship of these two characteristics only.

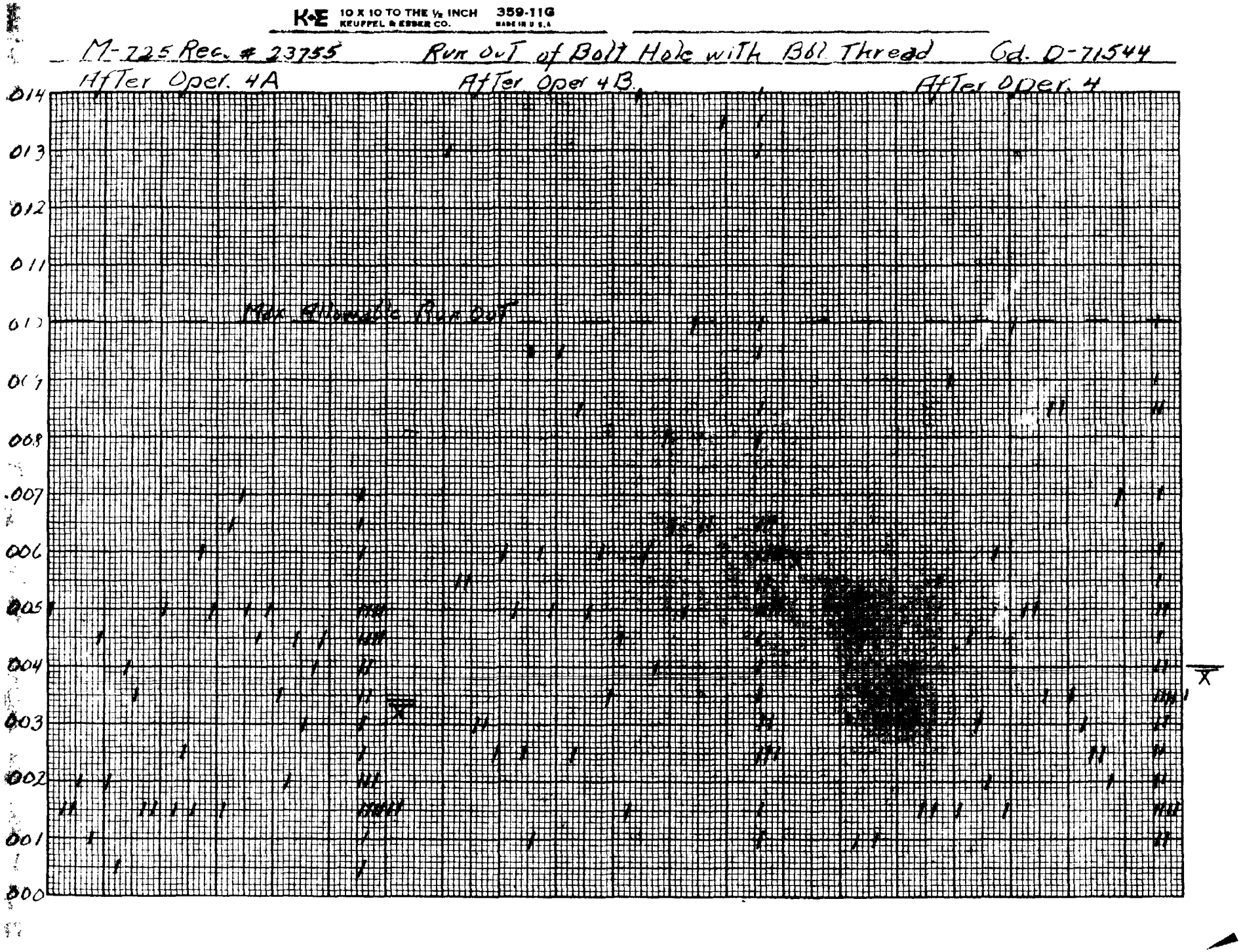
Method: Thirty (30) Receivers were taken in sequence from Oper. 4A and the runout of the Bolt hole with the Barrel thread measured with Ga. D-71544. Receivers were then run through Oper. 4B (Broach Bolt hole to size) and measurements repeated.

Thirty (30) Receivers were then taken after Oper. 4 and measurements taken as before.

QUALITY CONTROL DEPARTMENT
A. D. Gordon, Supervisor

R. B. Paulsen
R. B. Paulsen

Oper. 4A	Oper. 4B	Oper. 4
(Attach Oper's. To Oper. 4)		(Revolver Process)
Spot		Spot
Rough Bore		Rough Bore
Drill (Bolt Hole)		Drill (Bolt Hole)
Finish Bore	Bream (Bolt Hole & Stud)	Bream (Bolt Hole & Stud) Count Tool No. 74C4CU
Face (Front End)		Finish Bore
C'sink (Stud)		Face (Front End)
Tap (B-12UNS) Reduced Pilot		C'sink (Stud)
Cut off		Tap B-12UNS
		Cut off



CC: R. A. Williamson
H. J. Hackman
E. B. Wallin
L. J. Boyle
~~R. B. Hurley~~
R. W. Selwood
File

Ilion, New York
October 18, 1957

V. G. DE REUS

PROCESS STUDY - M/725 RECEIVER
J & L MACHINE & TURNING OPERATION

Purpose: To determine the ability of the proposed process to produce parts within model drawing specifications for the squareness of the front face and alignment of the Barrel thread with the O. D.

Observations: The proposed process is controllable as evidenced by the charts attached.

Remarks: A one piece form tool was used to square the front face, ream the c'bore for the Barrel thread and ream the Bolt hole to maintain alignment and squareness. Following the current M/721 process, the Bolt Lug slots were then broached in the Receivers followed by turning of the O. D. Receivers were located on a mandrel and expanding sleeve for turning.

Method: Thirty (30) Receivers were taken from the J & L machine after Oper. 4 and the squareness of the front face with the Barrel thread measured. Receivers were threaded on tap B-74685 and with the shank of the tap located in a "V" block, height gage readings were taken at four points as shown. Height gage was set on "0" at point 1 and deviation from this "0" at other three points recorded.

Same Receivers were then taken after Oper. 20, turn O. D., and the eccentricity between the thread and O. D. (rear end) measured by use of a gage D-71544.

QUALITY CONTROL DEPARTMENT
A. D. Gordon, Supervisor

by A. B. Paulsen
A. B. Paulsen

ABP:I

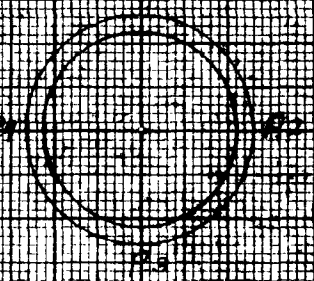
M-725 Receiver # 23755 Squareness of Front Face with B61 Thread Oper. 4

Part # 32304

Point 1 Point 2 Point 3

.001
½
.000
½
.001

$\bar{X}$ = .000 $\bar{X}$ = .000 $\bar{X}$ = .000 $\bar{X}$ = .000



Eccentricity between O.D. & B61 Thread T.I.R.
Gd. D-71344 Oper. 20 Part # 32304
Max T.I.R.

.010
.009
.008
.007
.006
.005
.004
.003
.002
.001
.000

$\bar{X}$

N=30
$\bar{X}$ = .0043
σ = .0023

721 Receiver

(1) Follow plus handle

There is no reamer for the long Receiver yet. The short reamer can be used for the short Receivers

(2) Hurley

An expansion reamer will be tried on 722's as soon as a plumbing job is fitted to the turret position.

(3) Hurley

is successful, a longer one will be tried on 721. If successful it will be adopted

Then of 4A & 4B could be eliminated

F.E. 8-26-57

CC: E. B. Wallin
R. A. Williamson
H. J. Hachmann
R. E. Kepler

Ilion, New York
August 16, 1957

S. M. Hyde

MODEL 721-722 RECEIVER
MODEL 725 RECEIVER
MODEL 40-X RECEIVER

At the present time, M/721-722 Receivers are produced on the JML Turret Lathe operation 4A and followed by a broaching operation to size the hole - operation 4B. With the introduction of the M/40-X Receiver, the importance of concentricity made it necessary to include as part of JML operation 4 a reaming which replaced the broaching used on the M/721-722 Receiver. With the introduction of the M/725 and the problems which will be involved in sighting, it was indicated that improved concentricity of the Barrel thread with the OD, squareness of the front face with the Barrel thread, and squareness of the face with the OD would be increasingly important.

It is planned to produce a common Receiver for the M/721-722 through the majority of the machining operations and provide a take over near the end of the operations to produce the M/725.

A study was, therefore, made by Quality Audit of the concentricity produced by operations 4A and 4B as compared with the single operation 4 which included line ream. This study which was completed July 17 indicates that improved concentricity is obtained through the use of operation 4. The addition of the line ream to the JML operation [illegible] quite, therefore, M. & S. was requested to study the JML burdening and to indicate the cost between the two processes. The review indicates that if the M/495 and M/496 parts now produced on the JML are transferred to a Burden & Oliver Machine that there will be sufficient time to produce on a three shift basis, M/721-722, M/725, and M/40-X. At present cost of the machine set up there would be an added cost of approximately $10 per hundred for the M/721-722 and M/725 Receivers. This is because of machine grouping. It is believed

Pass this on to the only Tool Room in Ilion that actually has the material here to make them from 4B

when the consolidation of the machining of the Industrial Tools is made with Dept. 74, that the J&L operation can be combined with a B&O operation which should reduce the operating cost to approximately the same as that now being realized by performing operations 4A and 4B.

It is recommended that Process Engineering immediately remove operations 4A and 4B from the process set up - M/T21-T22 and M/T23 to be produced on the J&L as operation 4 which will include the line ream.

V. V. [redacted]

VVD:EK

DRAWING NO	REMINGTON ARMS COMPANY, INC. ILION, N. Y.	ADDITIONAL USES	RECORD OF ALTERATIONS
A 60930			

MODEL [illegible] SCALE [illegible] ORDER NO.

PART [illegible] EXTENSION - 20GA

TOOL [illegible] DRILL - 2ND & 3RD POS.

OPERATION [illegible]

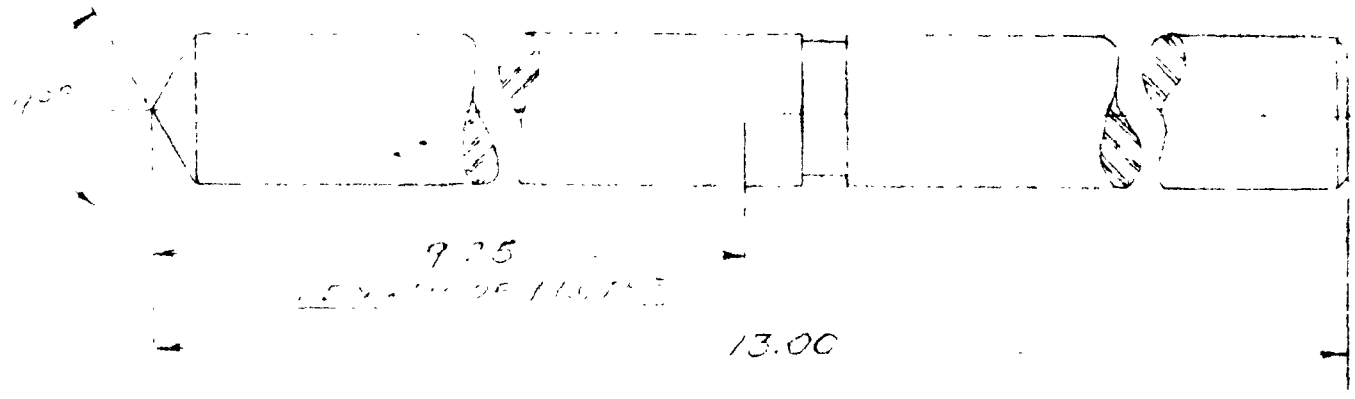
SUP'D'S. DWG. NO	B-58732 B 58734	CHECKED	BY ARL	DATE 2-22-49
DESIGNED	BY	DATE	TRACED	
DRAWN	HP	1-18-49	APPROVED	C.P.C 2/25/49

TOLERANCES NOT OTHERWISE GIVEN

1 PLACE (.1) - TOLERANCE ±	.05
2 PLACE (.01) - TOLERANCE ±	.005
3 PLACE (.001) - TOLERANCE ±	.0005

BLANKING
3 5 3
[illegible]

MATL - A-60930



[illegible] 47/64 [illegible] DRILL - [illegible] - [illegible]

JAN 13 1958

TC 3157-1

REMINGTON ARMS COMPANY, INC.
ILION, N. Y.

RECORD OF ALTERATIONS

Full Size — PART DWG. No. 17004-W3 — DETAILS

Receiver, #17004W

Step Drill.

Drill & Bore, Tap & Cut off.

DWG. No.			CHECKED	BY	DATE
	BY	DATE	TRACED		
			APPROVED		

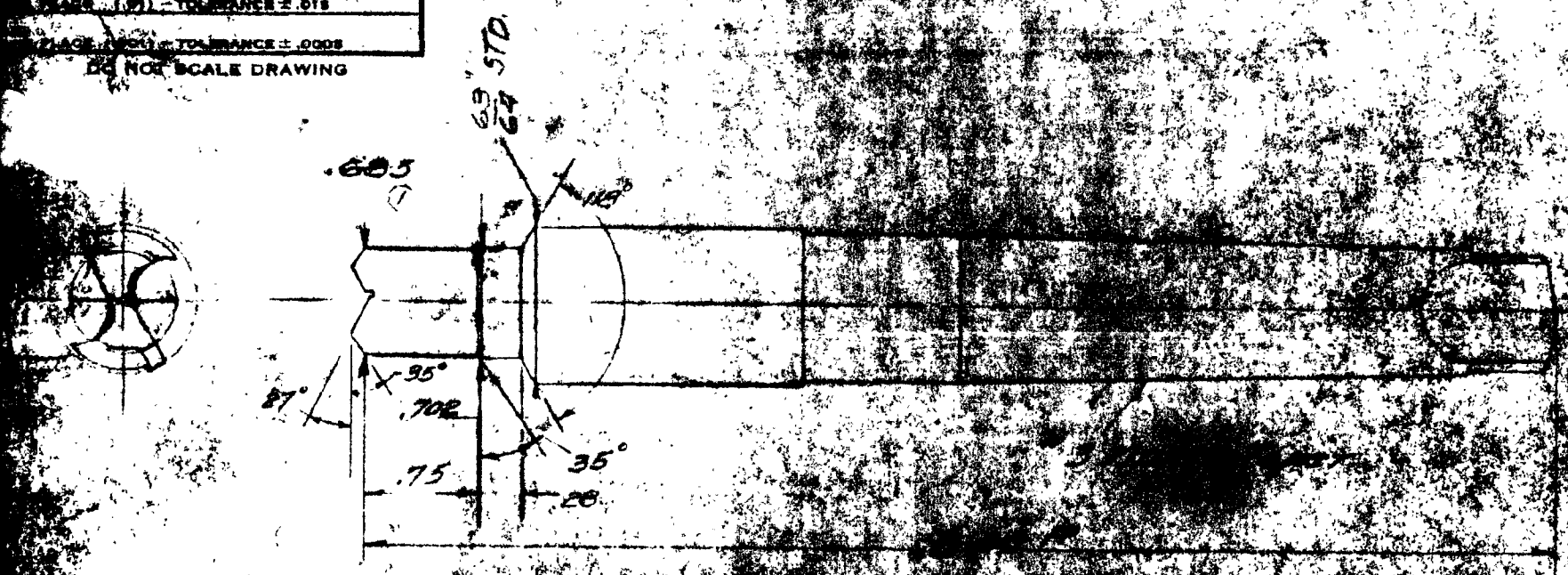
TOLERANCES NOT OTHERWISE GIVEN

PLACE (.1) — TOLERANCE ± .08

PLACE (.01) — TOLERANCE ± .015

PLACE (.001) — TOLERANCE ± .0005

DO NOT SCALE DRAWING

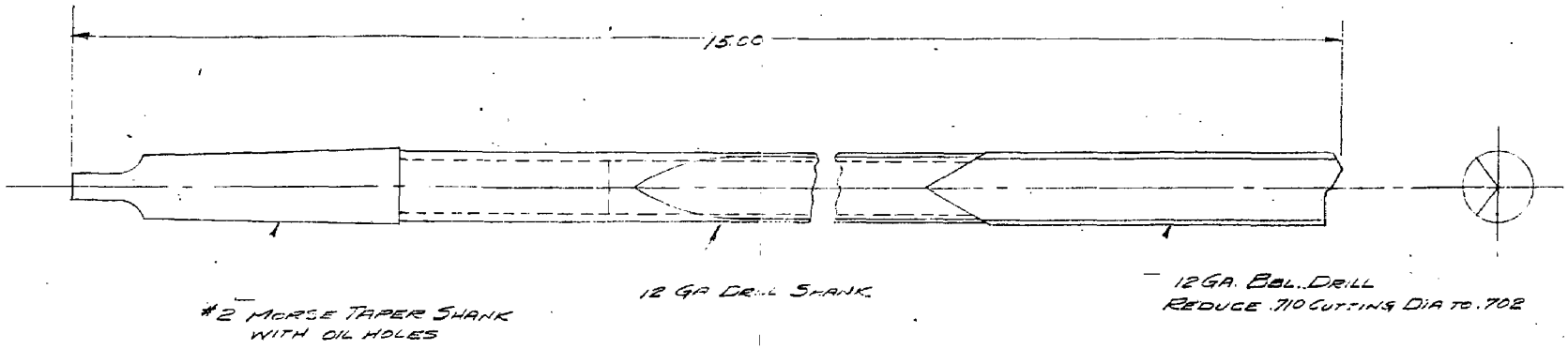


PURCHASE - DRILL CUT DOWN TO CUT

R. D. 520r

B-TS-3157

B-TS-3157



USE WITH SPOT DRILL A-TS-3157-1

DO NOT SCALE DRAWING

DETAIL NO.	MATERIAL SPEC.	STOCK SIZE	AMOUNT REQ.

TOLERANCES NOT OTHERWISE GIVEN
1 PLACE (.1) - TOLERANCE ± .05
2 PLACE (.01) - TOLERANCE ± .015
3 PLACE (.001) - TOLERANCE ± .0005

RECORD OF ALTERATIONS	ADDITIONAL USES	CONST'N DWG.
		DETAILS

REMINGTON ARMS COMPANY, INC., ILION, N. Y.

SCALE	MODEL 725 PART DWG. No.				
PART	RECEIVER				
TOOL	DRILL				
OPERATION	J & L. TURRET LATHE				
DESIGNED	BY	DATE	APPROVED	BY	DATE
DRAWN	ARL	10/2/57	SUPD'S DWG. No.		
CHECKED			DRAWING No. B-TS-3157		

Attn:

If we don't broach, will the hole be smooth enough? Edmsbe thinks not.
There should be no reamer rings if alignment is proper.

CC: H. J. Hackman (3)
R. B. Hurley
W. A. Best

Ilion, New York
July 17, 1957

V. G. DEREUS

M/40-X RECEIVER - OPER. 4 - SCREW MACHINE
M/721 RECEIVER - OPER. 4A & 4B - SCREW MACHINE

At your request, an audit of thirty (30) Receivers for each of the above models was taken as completed just prior to hardening and measured for comparison of the characteristics noted below. The characteristics are among those affecting the alignment of the Receiver and Barrel as assembled.

The Model 40-X process appears to be significantly better than for the M/721 Receiver. The data indicates a slight tendency for the Barrel to point downward at the muzzle in the M/40-X. The data for the M/721 suggests the same tendency approximately three times greater.

1. Alignment of Barrel Thread with the O.D.

   Both Receivers show some runout toward the rear of the Receiver. As viewed from the front of the Receiver, the Barrel hole in the M/40-X starts in slightly toward the top and left side and runs out further toward the top and right side. Variation is nominal. In the M/721, the hole starts in about the same point as in the M/40-X and runs upward at a comparatively greater angle. Variation is significantly greater at both the start in point and at the rear (see chart #1).

2. Squareness of Front Face with Barrel Thread

   M/40-X appears to be consistently square. The M/721 data shows an out-of-square condition averaging about .0009" at the bottom front face. (See chart #2, bottom of sheet).

3. Squareness of Front Face with O.D.

   M/40-X appears to be about 50% better than the M/721 for this characteristic. In both cases, the condition indicates a possible tendency for the Barrel to point slightly downward at the muzzle which might be reflected in assembling to the Stock. (See chart #2, top of sheet).

Oct 16th - [illegible] reamer E-74[illegible] [illegible]
Oct 15th - [illegible] 31 [illegible] [illegible]
Oct 15th - [illegible] [illegible] (using E 74[illegible]?).

Method: Thirty (30) Receivers each of the M/40-X and M/721 were taken just prior to heat treat and measured as follows.

1. Alignment of Barrel Thread with O.D.

   Receivers were threaded on tap B-74685 and with the shank of the tap located in a "V" block, height gage readings were taken at four points around the front end and around the O. D. at a point 5" out. Height gage was set at '0' at point 1 at the front end and readings taken at above points. Plotted figures on page 1 represent the deviation from the centerline of the thread.

2. Squareness of Front Face with Barrel Thread

   Receivers were again threaded on tap B-74685 and with the shank of the tap located in a "V" block, height gage readings were taken on the front face of the Receiver at four points as before. Height gage was again set at '0' at point 1 and deviation from this '0' recorded (page 2, bottom).

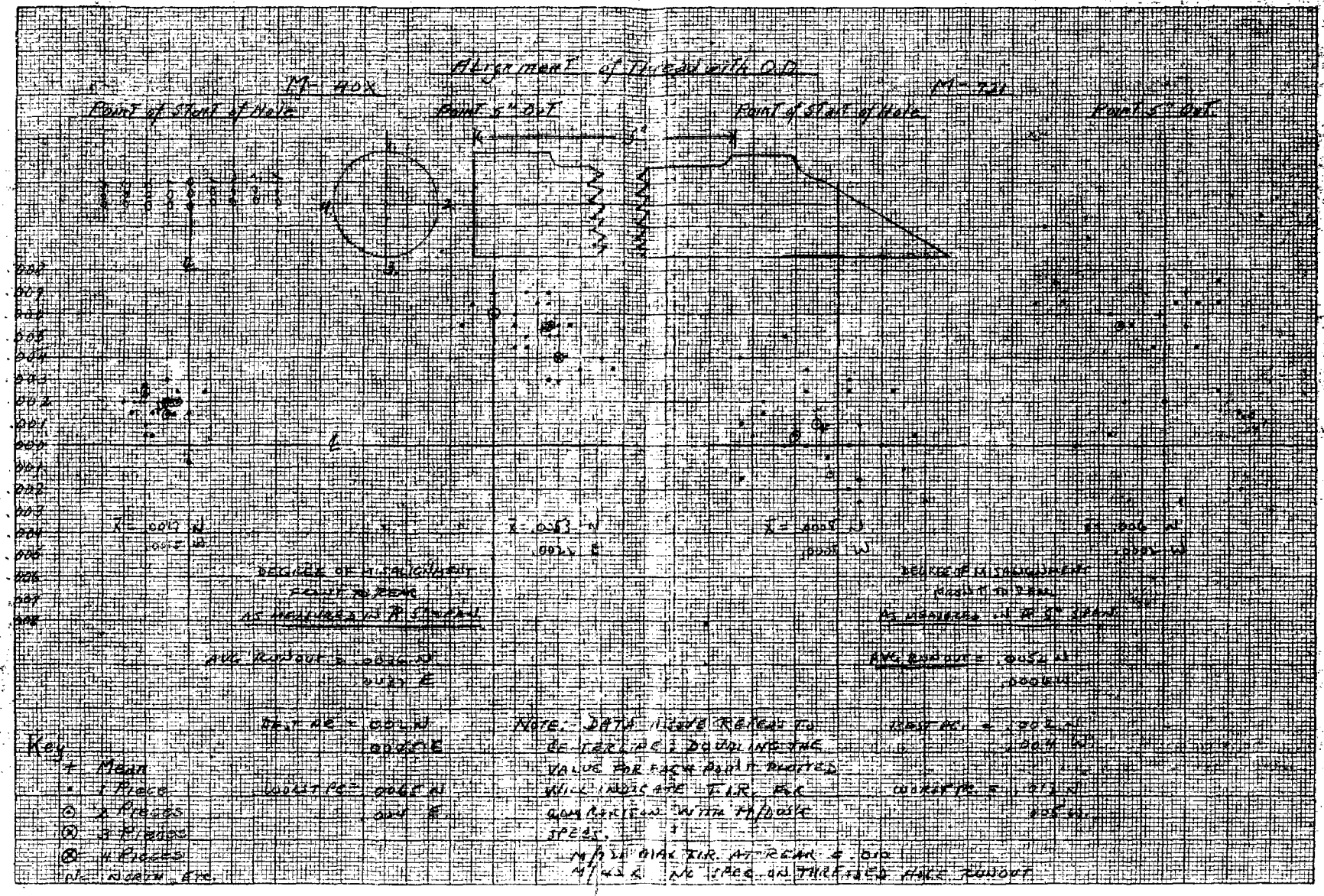
3. Squareness of Front Face with O.D.

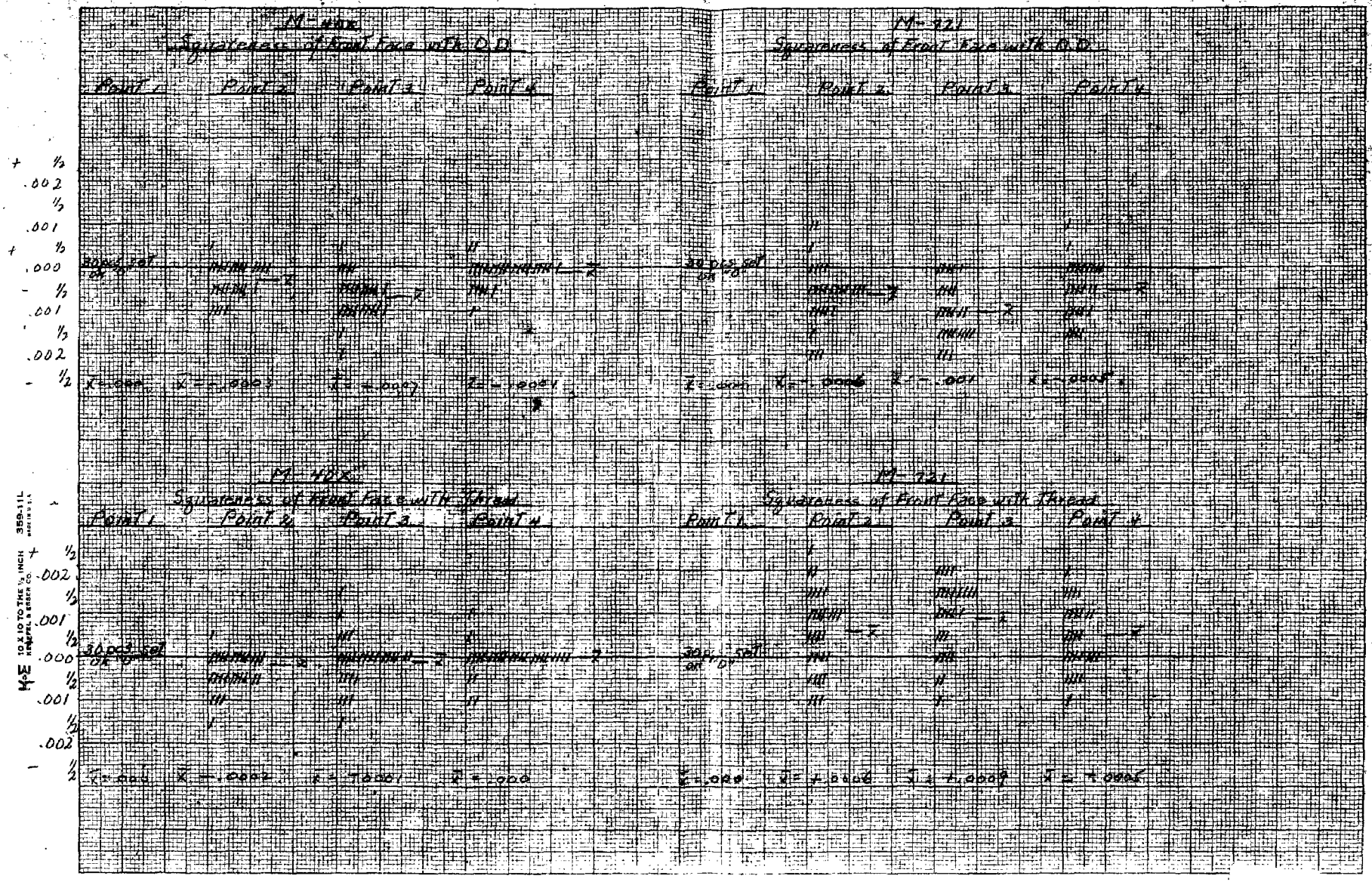
   Receivers were located in a "V" block and height gage readings taken at the same four points as above. Height gage was again set at 0 at point and the deviation from this '0' recorded (page 2, top).

QUALITY CONTROL DEPARTMENT
A. D. Gordon, Supervisor

by A. B. Paulsen /g
A. B. Paulsen

ABP/I





16 ga. .195 B-18782

12 ga. .155 B-18865

.010 chamb

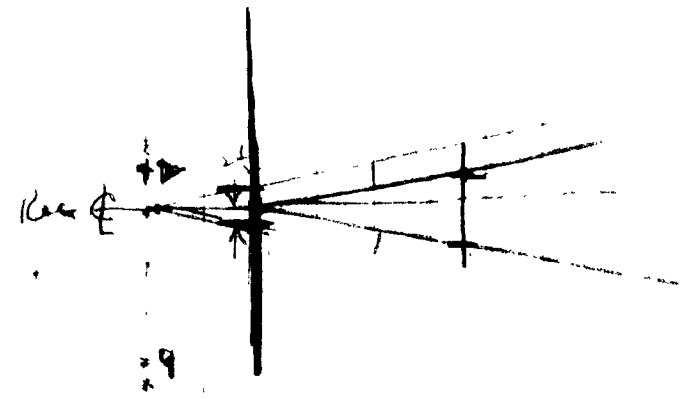
.010 spring

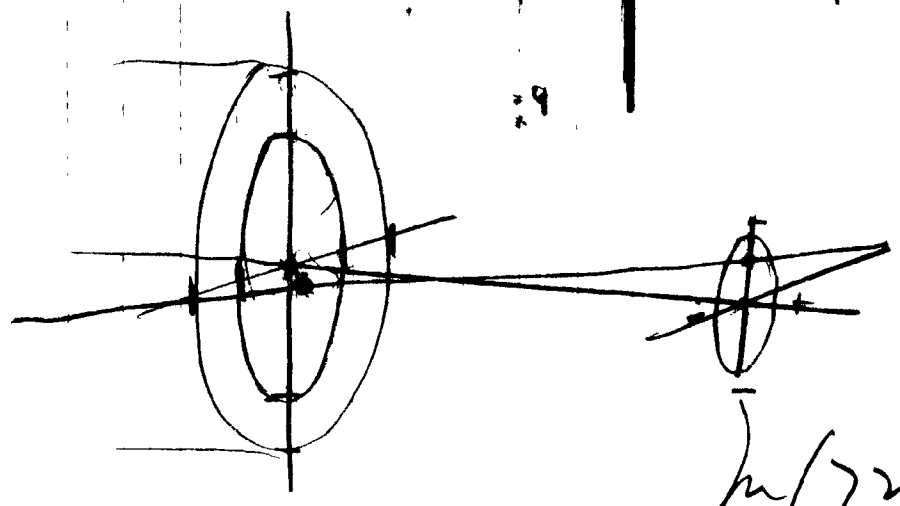
.050

.010
.010
.020
.040

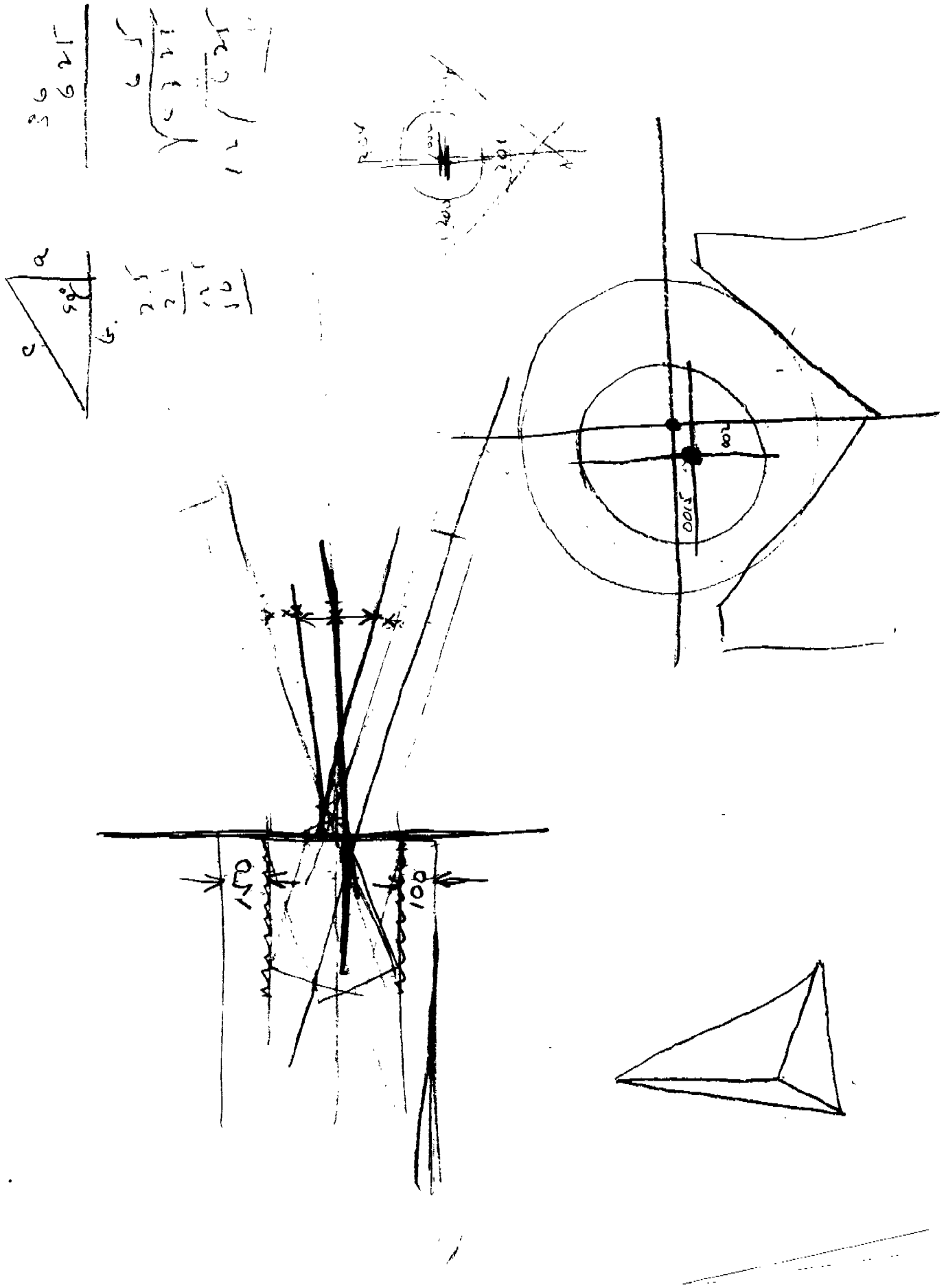
OD Top		OD W/S.	OD E/W.	Wall thickness. T	L	B	R	Reading on Top T	L	B	R	Squareness of [illegible] T	L	B	R
.8605	1	1.359	1.359	181	176½	176	179	−1½	+4	+9½	+5	0	2	−2	−3
	2	358	.3575	177	177	178½	179	−6	−10	−11	−4	0	+2½	+2	+1½
	3	359	.358	181	183½	176½	173½	0	−1	−6	−9	0	+2	+2	+1
	4	359	.3575	175½	180	181	175½	−7	−12½	+8	−3	0	0	0	−2½
	5	.358	.358	174	180½	182	174	0	−5½	−2	−7	0	+1	−1	−1

1	2½ Bot. 1½ Left
2	3/4 Top 1 Left
3	2¼ Bot. 5 right
4	2¼ Top 2¼ Left
5	4 Top 2¼ Left





M/722
2/15



CC: R. A. Williamson
H. J. Hackman
E. Sapp) In
R. Hurley) Turn
W. A. Best
E. Folmsbee
File

February 24, 1956

L. J. BOYLE

M/721-722 RECEIVER

Purpose: To show the angularity of face and threaded Barrel hole relative to problem of customer complaint "can't sight in properly" due to misalignment of Barrel and Receiver.

Observations: M/721 Receivers show considerable angularity of the Barrel hole with the face (chart #1) which is believed to be typical of current components ready for Assembly. The angularity is such as to indicate the possibility of additional customer complaints similar to the one referred to above.

M/722 Receivers also show some angularity of the Barrel hole with the face (chart #2). However, the degree is considerably less and appears to be relatively insignificant.

Reference to the Process Record shows that different processes are used in the manufacture of the two Receivers. In the M/721, the face, Ba rel thread c'bore and Bolt hole are generated separately while in the M/722, the face is squared and the c'bore for the thread and the Bolt hole are reamed with a single combination tool (B-74686) to assure better alignment. A similar experimental tool (A-TS-2348) is also listed for the M/721. However, it is understood that this latter tool was made and tested but that the problem was not followed to a conclusion due to changes in Engineering personnel. Therefore, M/721 Receivers are still manufactured by the original process.

The data suggests that if the same process used for the M/722 Receiver is adapted to the M/721, the problem of misalignment of Barrel and Receiver may be minimized.

Method: I. Squareness of Front Face

Receivers were placed vertically in a "V" Block and measurements taken with a height gage at the top, bottom, left and right side of the front face. The height gage was set to zero each time for the reading at the top.

Method: (Continued)

II. Angle of Tap in Receiver

Receivers were placed horizontally in a "V" Block and a tap screwed into the Barrel hole to approximately the same depth for each Receiver. Readings were taken 1-3/4" out on the stem of the tap at the top, bottom, left and right side. The height gage was again set to zero for the reading at the top.

Attached sheets show the squareness of the front face in relation to the O.D. of the Receiver and the angle which the tap enters in relation to the centerline of the Receiver.

Calculations for above are on file in the Quality Control Department.

QUALITY CONTROL DEPARTMENT
A. D. Gordon, Supervisor

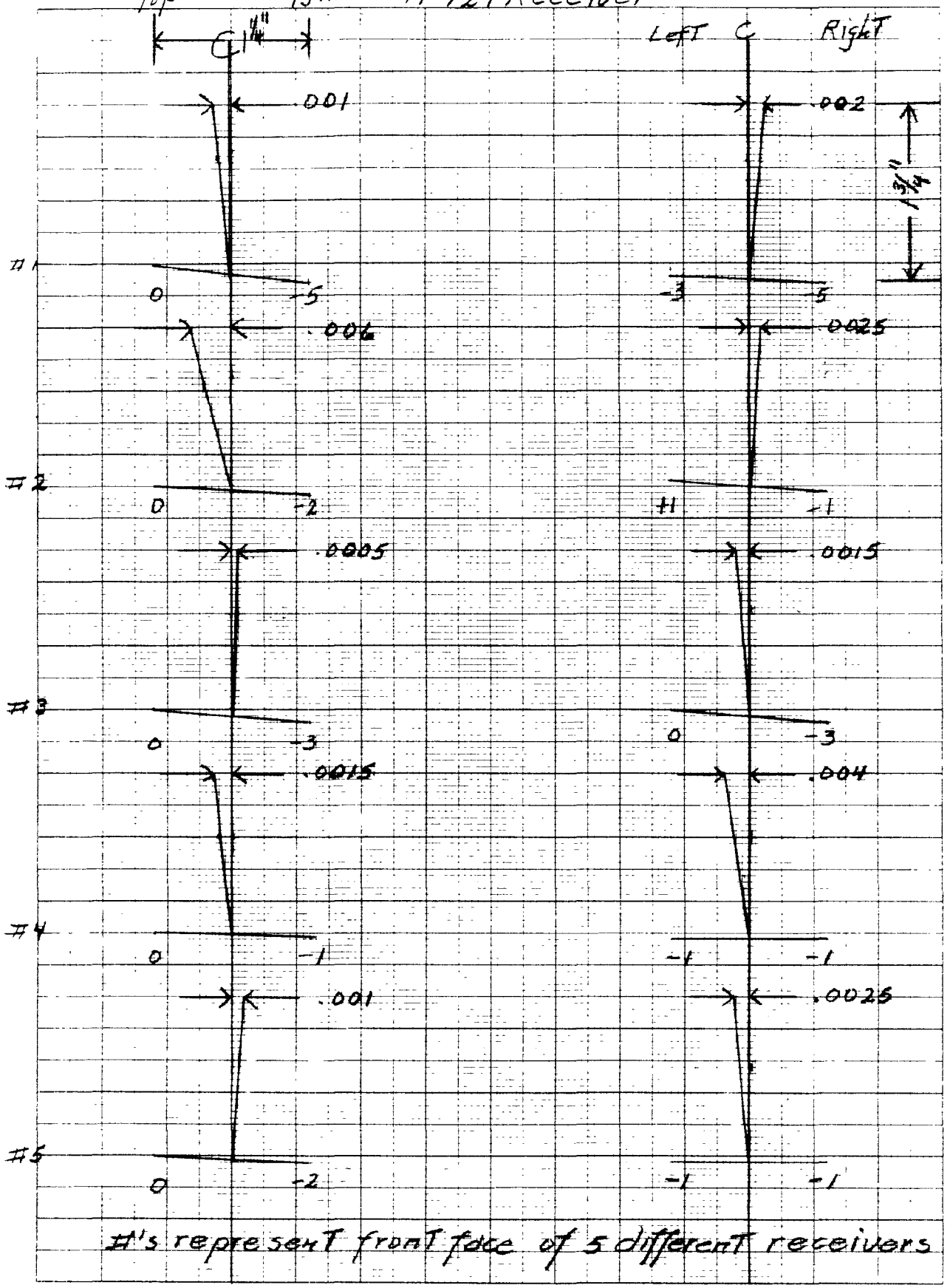
by A. B. Paulsen
A. B. Paulsen

ABP/I
Attach.

Squareness of Front Face & Angle of Tap

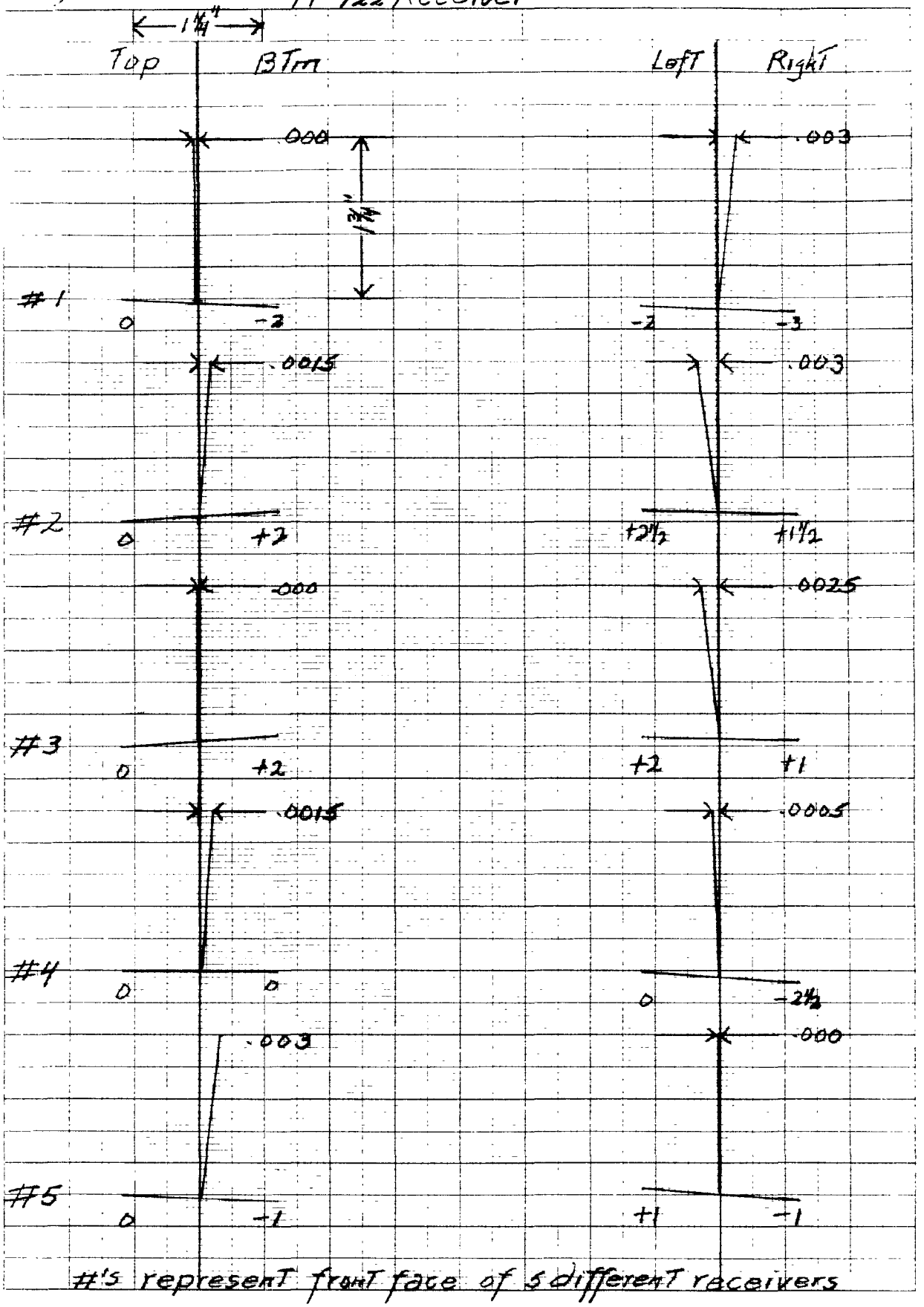
Top Bim M-721 Receiver

1

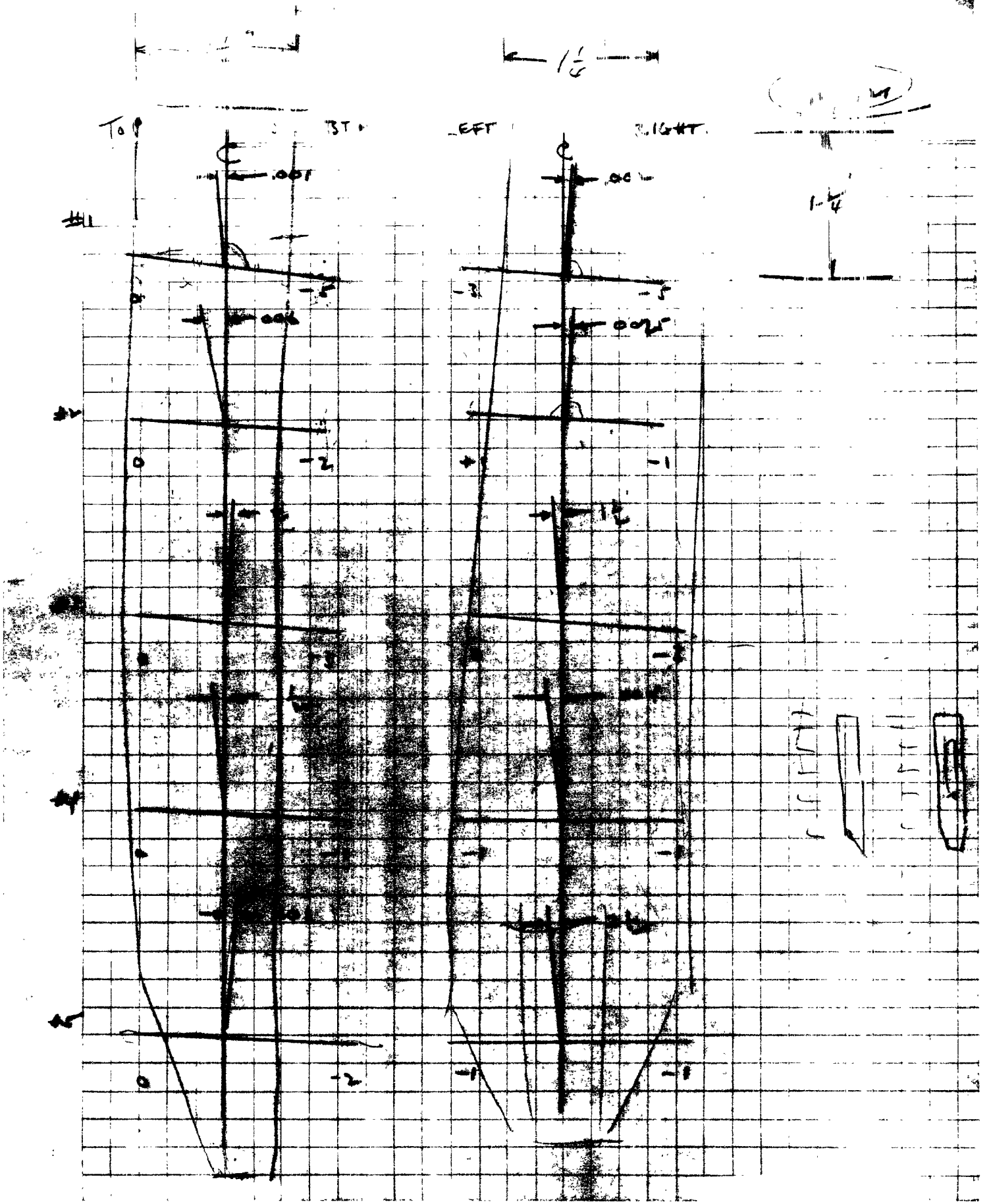


#'s represent front face of 5 different receivers

Squareness of Front Face & Angle of Tap
M-722 Receiver



#'s represent front face of 5 different receivers


TOP
BOTTOM
LEFT
RIGHT

194
174
136
504

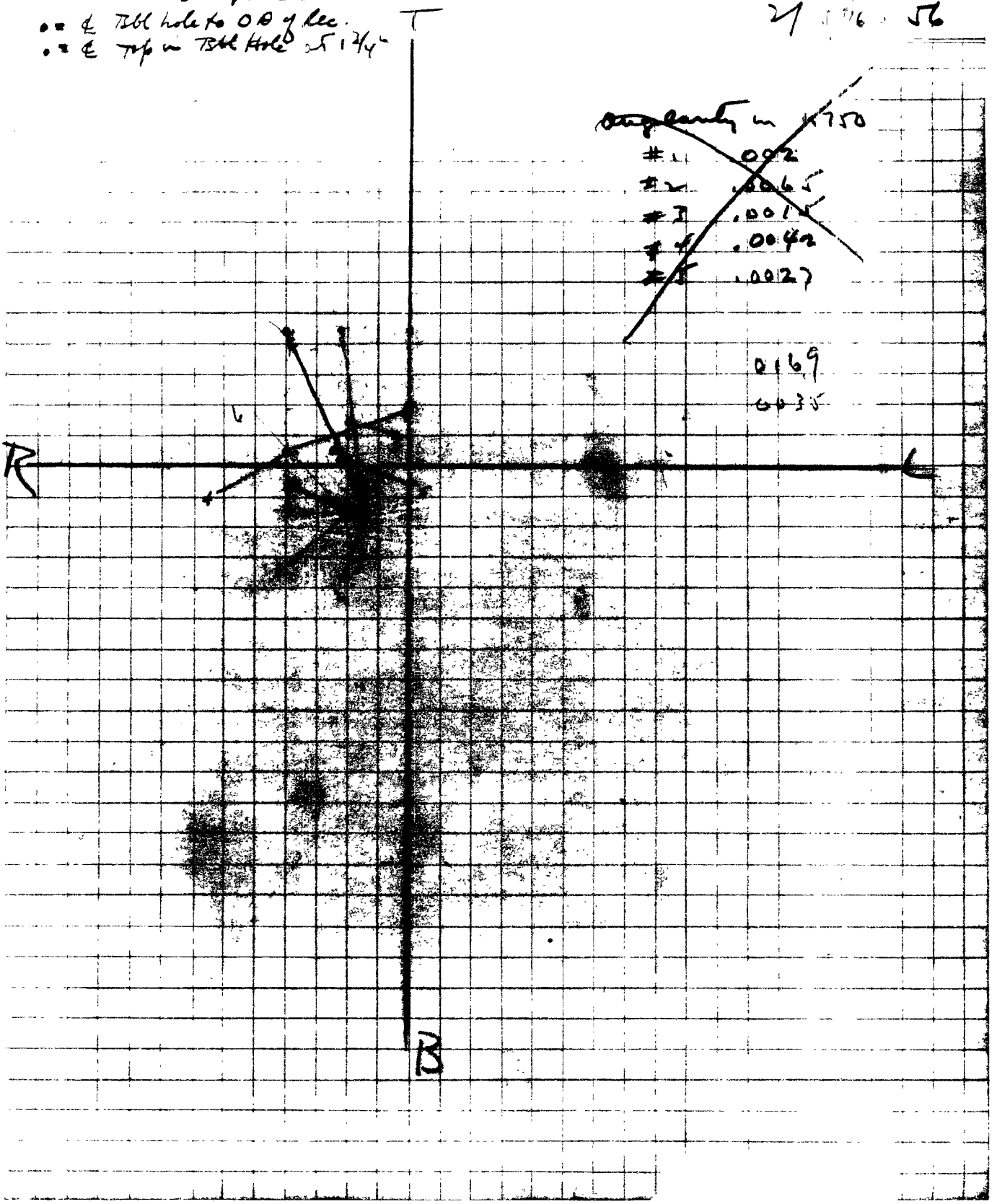
174
194
136

173
145
270

Angularity of Threaded Bbl hole in Rec.

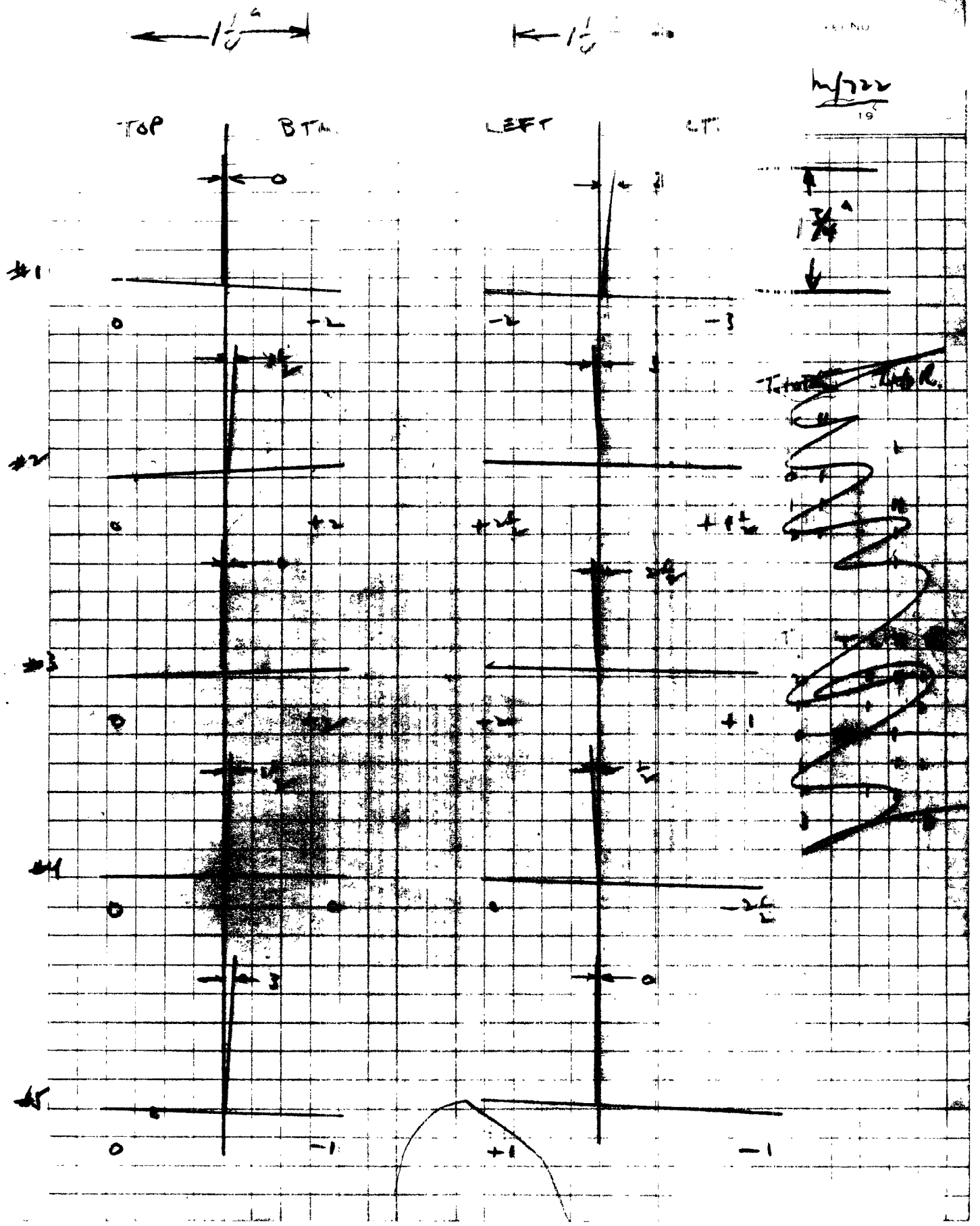
• = ℄ Bbl hole to OD of Rec.
• = ℄ Top in Bbl Hole of 1 3/4"

27 [illegible] 56

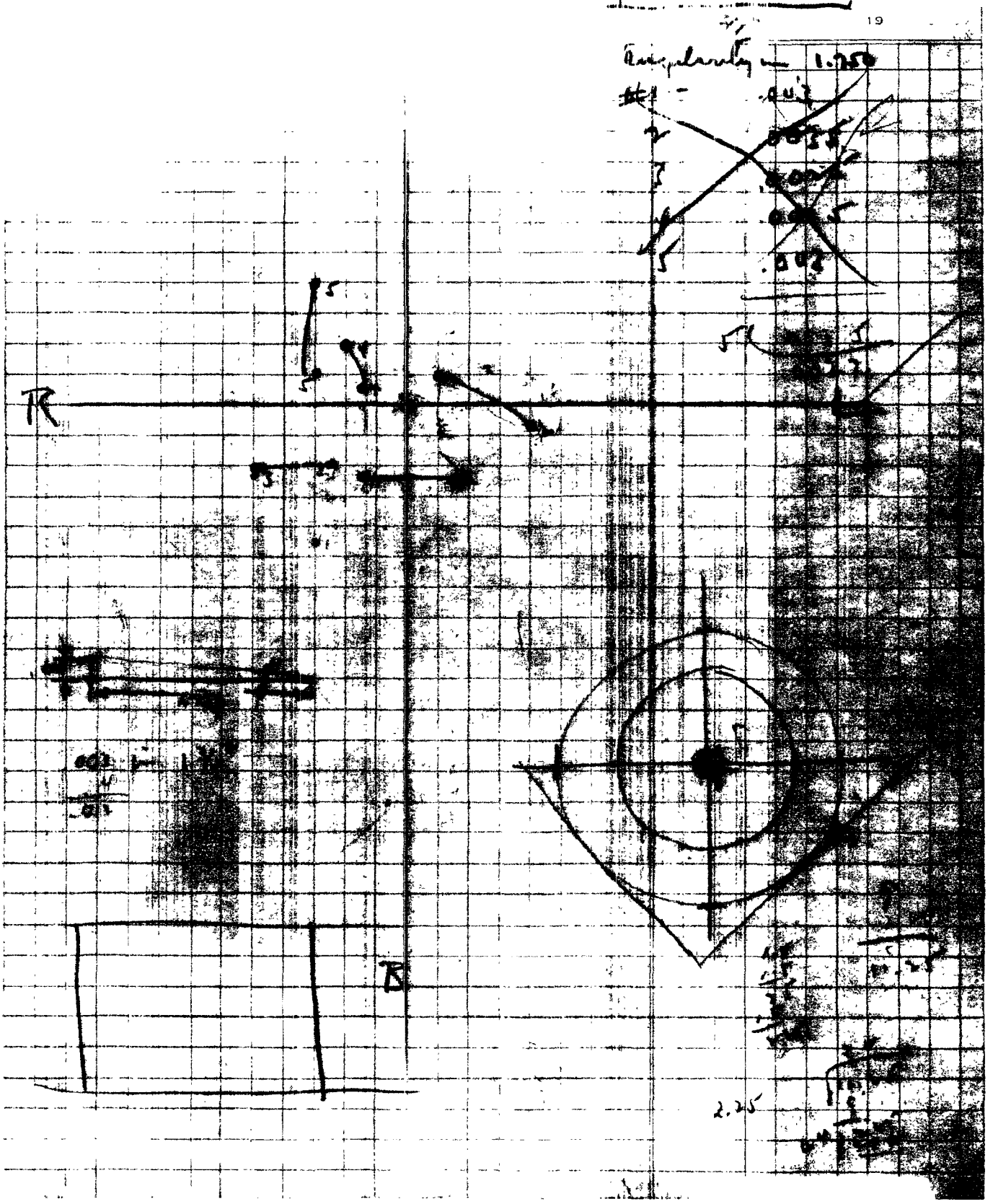


m/721 2/16

		#1	#2	#3	#4	#5
OD. – Top To Btm		1.3585	1.359	1.358	1.3585	1.3585
Side wise		1.358	1.3585	1.357	1.3565	1.3585
Wall thickness	Top	204	204	201	202	201
	Left	204	204	204	205	203
	Btm	201	201	204	203	202
	Rt.	200	201	200	197	198
Bending on top.	Top	0 +1½	0 +1½	0 -1½	0 -½	0 -½
	Left	-2 0	+5½ +7	-1 +1	-3½ +½	-7 -4½
	Btm	+2 +½	+12 +10½	+2 +3½	+4 +4½	-4 -3½
	Rt.	-6½ -8½	1 -2½	0 -2	+3 -1	-2 -0½
Play on top	Top	.016	.020	.020		
	Left	.021	.024	.023		
	Btm	.017	.024			
	Rt.	.023	.027			
Squareness of face.	T	0	0	0	0	0
	L	-3	+1	0	-1	-1
	B	-5	-2	-3	-1	-2
	R.	-5	-1	-3	-1	-1


TOP
BTM
LEFT
LT
#1
#2
#3
#4
#5

FRONT VIEW



J.C.

CC: R. A. Williamson
H. J. Hackman
E. B. Wallin
L. J. Boyle
R. B. Hurley
R. W. Selwood
File

Ilion, New York
October 18, 1957

V. G. DE REUS

PROCESS STUDY - M/725 RECEIVER
J & L MACHINE & TURNING OPERATION

Purpose: To determine the ability of the proposed process to produce parts within model drawing specifications for the squareness of the front face and alignment of the Barrel thread with the O. D.

Observations: The proposed process is controllable as evidenced by the charts attached.

Remarks: A one piece form tool was used to square the front face, ream the c'bore for the Barrel thread and ream the Bolt hole to maintain alignment and squareness. Following the current M/721 process, the Bolt Lug slots were then broached in the Receivers followed by turning of the O. D. Receivers were located on a mandrel and expanding sleeve for turning.

Method: Thirty (30) Receivers were taken from the J & L machine after Oper. 4 and the squareness of the front face with the Barrel thread measured. Receivers were threaded on tap B-74685 and with the shank of the tap located in a "V" block, height gage readings were taken at four points as shown. Height gage was set on "0" at point 1 and deviation from this "0" at other three points recorded.

Same Receivers were then taken after Oper. 20, turn O. D., and the eccentricity between the thread and O. D. (rear end) measured by use of a gage D-71544.

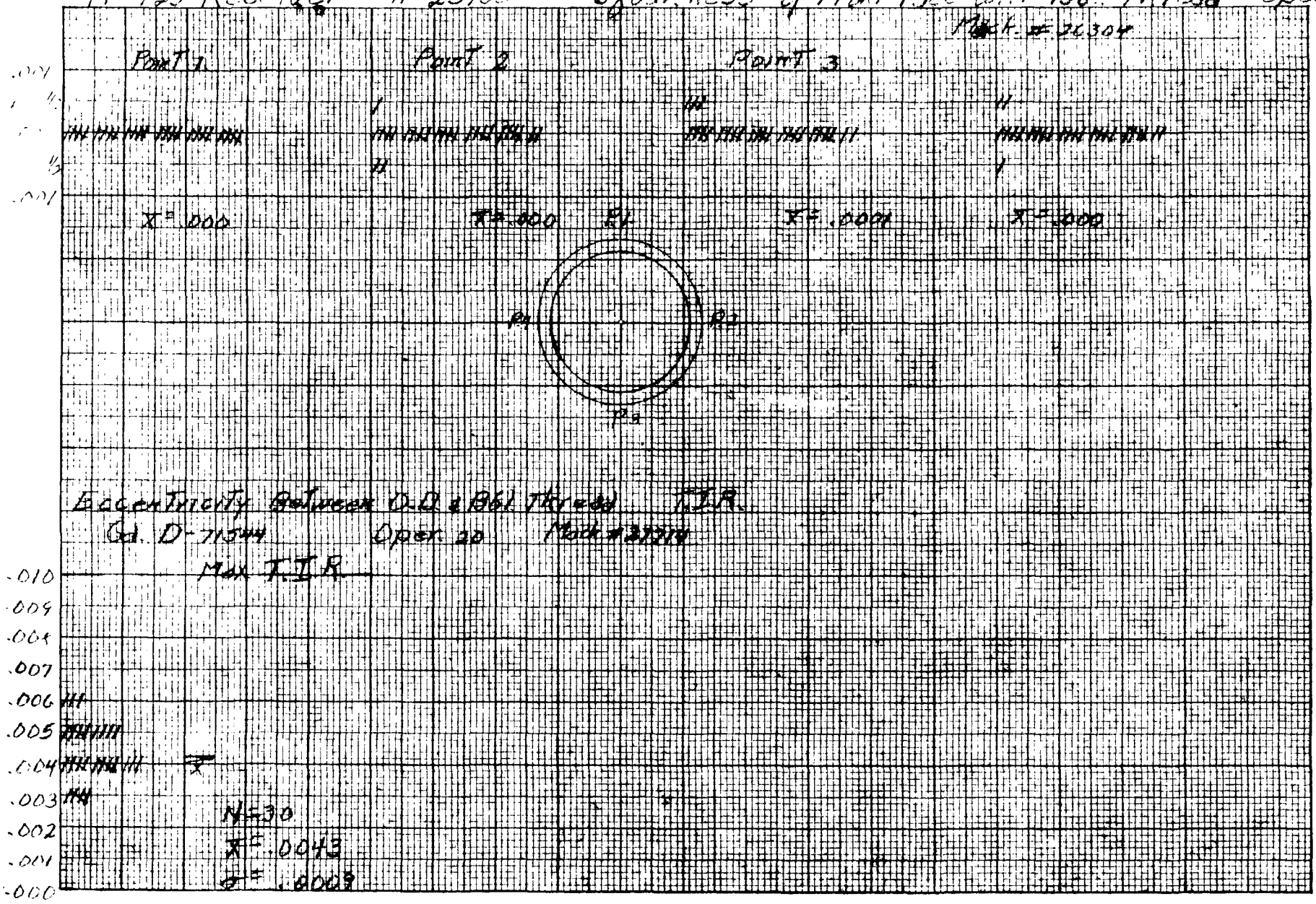
QUALITY CONTROL DEPARTMENT
A. D. Gordon, Supervisor

by A. B. Paulsen
A. B. Paulsen

ABP:I

M-725 Receiver # 23755 Squareness of Front Face with 1.36" Thread Oper. 4

Mach. # 20304



10/11/57

Vic.

Study relative to squareness of face of 1/2 Receiver & 1/2 x Receiver.

	Date of Study	Remarks.
1 –	2/24/56	Points to sighting components
2 –	6/10/52	Points to split stock.
3 –	6/5/52	Shows influence of out of square face on subsequent processing.
4 –	2/17/57	Shows current misalignment (This is study addressed to you)
5 –	6/2/55	Previous study using different technique which shows about same results.

CC: E. B. Wallin
R. A. Williamson
H. J. Hackman
R. B. Hurley

Ilion, New York
August 16, 1957

S. M. Alvis

MODEL 721-722 RECEIVER
MODEL 725 RECEIVER
MODEL 40-X RECEIVER

At the present time, M/721-722 Receivers are produced on the J&L Turret Lathe operation 4A and followed by a broaching operation to size the hole - operation 4B. With the introduction of the M/40-X Receiver, the importance of concentricity made it necessary to include as part of J&L operation 4 a reaming which replaced the broaching used on the M/721-722 Receiver. With the introduction of the M/725 and the problems which will be involved in sighting, it was indicated that improved concentricity of the Barrel thread with the OD, squareness of the front face with the Barrel thread, and squareness of the face with the OD would be increasingly important.

It is planned to produce a common Receiver for the M/721-722 through the majority of the machining operations and provide a take over near the end of the operations to produce the M/725.

A study was, therefore, made by Quality Audit of the concentricity produced by operations 4A and 4B as compared with the single operation 4 which included line ream. This study which was completed July 17 indicates that improved concentricity is obtained through the use of operation 4. The addition of the line ream to the J&L operation reduces the cycle, therefore, M. & S. was requested to study the J&L burdening and to indicate the cost between the two processes. The review indicates that if the M/455 and M/456 parts now produced on the J&L are transferred to a Bardon & Oliver Machine that there will be sufficient time to produce on a three shift basis, M/721-722, M/725, and M/40-X. At present cost of the machine set up there would be an added cost of approximately $10 per hundred for the M/721-722 and M/725 Receivers. This is because of machine grouping. It is believed

when the consolidation of the machining of the Industrial Tools is made with Dept. 74, that the J&L operation can be combined with a B&O operation which should reduce the operating cost to approximately the same as that now being realized by performing operations 4A and 4B.

It is recommended that Process Engineering immediately remove operations 4A and 4B from the process set up - M/721-722 and M/725 to be produced on the J&L as operation 4 which will include the line ream.

V. G. DENGUS

VGD:MK

A Work-A-Day Calendar

JAN	FEB	MAR	APR	MAY	JUNE
JULY	AUG	SEP	OCT	NOV	DEC

11.08
5.86

LAST MONTH

1957 June 1957						
S	M	T	W	T	F	S
						1
2	3	4	5	6	7	8
9	10	11	12	13	14	15
16	17	18	19	20	21	22
23 30	24	25	26	27	28	29

1957 JULY 1957						
S	M	T	W	T	F	S
	1	2	3	4	5	6
7	8	9	10	11	12	13
14	15	16	17	18	19	20
21	22	23	24	25	26	27
28	29	30	31			

NEXT MONTH

1957 August 1957						
S	M	T	W	T	F	S
				1	2	3
4	5	6	7	8	9	10
11	12	13	14	15	16	17
18	19	20	21	22	23	24
25	26	27	28	29	30	31

TUESDAY **16** JULY

16.88 10.500 + 3

721 Rec Jrl 16.39 + 3%
OL 1.55
Exp 10.56

Shell Chem

~~24~~ 8

New Jersey 4 ~~40~~ .x

722 24.70 15.69 17.40
1.52 1.67
10.58 10.87

10.00 per hundred
Lade

197 TUESDAY, JULY 16, 1957 168

	Volume	Bottles	Sizer	Cartons	Total
[illegible]	[illegible]				
[illegible]	[illegible]				
[illegible]	[illegible]				
[illegible]	[illegible]				
[illegible]	[illegible]				
	34,855	5110	110	990	6,35[illegible]
		5880			
[illegible]	Broadway Mass [illegible]				
[illegible]	[illegible]	[illegible]			
[illegible]	[illegible]	[illegible]	[illegible]		[illegible]
[illegible]	11,925	1150	30	90	1270
[illegible]	[illegible]	900	[illegible]	60	[illegible]
[illegible]	[illegible]	2070	[illegible]	200	[illegible]
[illegible]	[illegible]	452	[illegible]	[illegible]	[illegible]
[illegible]		4680			

SPEEDIMEMO

TO	DEPT -LOCATION
H. J. HACKMAN	
FROM	DEPT -LOCATION
S. M. ALVIS	
SUBJECT	DATE
MODEL 721-722 RECEIVER PROCESSING	8 / 2 / 57

MESSAGE:

On March 25 th of this year, I confirmed having discussed with you our desire to have a determination of what would be involved to improve the process and equipment necessary to conform with the revisions what had been made to the drawing to control alignment. We sent you a follow up note on April 12th. As far as I can determine, there is still no answer, and with the Model 725 "coming up", I am more concerned that we should do something on this without further delay.

ORIGINATOR DO NOT WRITE BELOW THIS LINE SIGNED SMA

REPLY:

CC: GM Calhoun
Wayne Leek - MH Walker

DEPT.-LOCATION	SIGNED	DATE
		/ /

SEND PARTS 1 AND 3 WITH CARBON INTACT - PART 3 WILL BE RETURNED WITH REPLY

Citation
85
1-6-53

limits on 1721-722
Receiver to C/O
remove or trim with
threads.
6/25
T 5/23 6/10 DHAW.

7.5. Ry 721
16468
new #?

23825 added to
870 Bble. guide
Ring

COVER ONE SUBJECT ONLY IN EACH LETTER

MS-616

SPEEDIMEMO

TO Harvey	DEPT.-LOCATION
FROM SMA	DEPT.-LOCATION
SUBJECT M/721-722 Receiver Processing	DATE 4/15/57

MESSAGE:

In going through my "Waiting" file note that on Friday March 19th, I left with you a note with drawing number, Revision # etc, & asked to be advised what would be involved to meet the requirements for the lead run-out. How soon do you think that you might have it?

SMA

ORIGINATOR - DO NOT WRITE BELOW THIS LINE SIGNED

REPLY:

DEPT.-LOCATION	SIGNED	DATE
		/ /

SEND PARTS 1 AND 3 WITH CARBON INTACT - PART 3 WILL BE RETURNED WITH REPLY

COVER ONE SUBJECT ONLY IN EACH LETTER

MS-618

SPEEDIMEMO

TO: Harvey

DEPT.-LOCATION:

FROM: SMA

DEPT.-LOCATION:

SUBJECT: M/721-722 Receiver Processing

DATE: 4 12 57

MESSAGE:

In going through my "Waiting" file note that on Friday March 19th, I left with you a note with drawing number, Revision #, etc, & asked to be advised what would be involved to meet the requirements for the road run-out. How soon do you think that you might have it?

SMA

ORIGINATOR - DO NOT WRITE BELOW THIS LINE

SIGNED: [illegible]

REPLY:

DEPT.-LOCATION

SIGNED

DATE / /

WRITER'S COPY

DETACH AND FILE FOR FOLLOW-UP

COVER ONE SUBJECT ONLY IN EACH LETTER

MOORE REDIFORM 518

SPEEDIMEMO

TO Harvey	DEPT.-LOCATION
FROM Sam	DEPT.-LOCATION
SUBJECT M/721-722 - Receiver Processing	DATE 3/1/ST

MESSAGE:

Friday, I left with you a small note with drawing number, Revision #, etc & you planned to ascertain what will be involved to tools & process to meet the drawing requirements for Thread Run-out

ORIGINATOR - DO NOT WRITE BELOW THIS LINE SIGNED SMA

REPLY:

DEPT.-LOCATION	SIGNED	DATE / /

SEND PARTS 1 AND 3 WITH CARBON INTACT - PART 3 WILL BE RETURNED WITH REPLY

SPEEDIMEMO

TO Harvey

DEPT.-LOCATION

FROM Sam

DEPT.-LOCATION

SUBJECT 721-722 - Receiver Processing

DATE 3/25

MESSAGE:

Friday, I left with you a small note with drawing number, Revision #, etc & you planned to ascertain what will be involved to tools & process to meet the drawing requirements for Thread Run-out.

ORIGINATOR - DO NOT WRITE BELOW THIS LINE SIGNED SMA

REPLY:

DEPT.-LOCATION SIGNED DATE / /

WRITER'S COPY

DETACH AND FILE FOR FOLLOW-UP

PROCESS RECORDS

DATES AND REASONS FOR REVISIONS 3/14/55 - Revised sheets - EJC - 249742 -
4/18/55 - Add 722-.222 - EJC - 249847

TOOLS, GAGES AND EQUIPMENT			GA. OR CAL.	APPROVAL AND DATES 721	722	40X	722-.222		
SPEED	FEED								
Step Drill Barrel and Bolt Hole:									
178	.011	Drill		A-69549	A-69549	A-69549	A-69549		
		1 7/16" spindle collet		B-90047W	B-90047W	B-90047W	B-90047W		
		1 7/16" spindle collet bushing		B-90048W	B-90048W	B-90048W	B-90048W		
		Flanged tool holder		B-90045V	B-90045V	B-90045V	B-90045V		
		Adaptor		B-90112N	B-90112N	B-90112N	B-90112N		
Drill Bolt Hole to full depth:									
123	.033	.683" oil hole drill		A-54222	A-54222	A-54222	A-54222		
		Collet		B-54363	B-54363	B-54363	B-54363		
		Plug Gage (.687"-.680")		B-80007V	B-80007V	B-80007V	B-80007V		
		NOTE: M/721 9" deep							
		M/722 8 1/8" deep							
		M/40X 8 1/8" deep							
		NOTE: Engage feed before drill enters small hole							

OPERATION DESCRIPTION		721	722	40X	722-.222		
	PART No.	20181	20182	19767			
Step drill; deep hole drill; ream, c'bore and face; tap; and cut off.							
	OCC. No.						
	STD. HRS/C						
	STD. No.						
	EFF. DATE						

PART NAME Receiver COOLANT A 9C SET UP TIME MODEL No. 721 - 722 -40X OPER. No. 4

TYPE 45" J&L Turret Lathe MACH. HRS. DEPT. No 73 PAGE 1 OF 3

RD-6461

PROCESS RECORD

DATES AND REASONS FOR REVISIONS 3/14/55 - Revised sheets - JC - 24,742 -
[illegible] - Add 722-.222 EJC - 249847

TOOLS GAGES AND EQUIPMENT	GA. OR CAL	721	722	40X	722-.222
SPEED FEED					
C'bor, c'sink, and face Bbl. hole; ream Bolt hole:					
.013 .011 Comb. c'bore facer & reamer		A-TS-2348	B-74686	B-74686	B-74686
Empire floating holder		Std.	Std.	Std.	Std.
Flanged tool holder		B-90045V	B-90045V	B-90045V	B-90045V
Depth gage (1.151-1.149)		B-50240	B-50240	B-50240	B-50240
Setting Gage		B-50295	B-50295	B-50295	B-50295
Fed. Dial (1.003-.998 dia.)		B-80057W	B-80057W	B-80057W	B-80057W
Setting Gage		B-80064W	B-80064W	B-80064W	B-80064W
C'sink Gage		B-74639	B-74639	B-74639	B-74639
Plug Gage (.703-.700 dia.)		B-80199V	B-80199V	B-80199V	B-80199V
NOTE: Hold reamer in dwell at end of cycle					
Tap Barrel hole:					
40 Hand					
Return: Tap (1 1/16" - NC-3)		B-74685	B-74685	B-74685	B-74685
90 Hand Flanged tool Holder		B-90045W	B-90045W	B-90045W	B-90045W
Releasing Tap Holder		B-90041V	B-90041V	B-90041V	B-90041V
Empire floating Holder		Std.	Std.	Std.	Std.
Th'd Gage (.003 T.I.R.)		B-80071U	B-80071U	B-80071U	B-80071U
Th'd Segments		B-80072W	B-80072W	B-80072W	B-80072W
Min. Setting Ring		B-80078W	B-80078W	B-80078W	B-80078W
Th'd depth Gage		A-52823	A-52823	A-52823	A-52823
Th'd Plug (Salvage Max.)		A-54568	A-54568	A-54568	A-54568

APPROVAL AND DATES

PART NAME Receiver COOLANT A9C SET UP TIME MODEL No 721,722,40X OPER. No 4
TYPE #5 J&L Turret Lathe MACH HRS. MACHINE DEPT No 73 PAGE 2 OF 3

RD 6463

PROCESS RECORD

DATES AND REASONS FOR REVISIONS 3/14/55 - Revised process - EJC - 249742 -
4/18/55 - Revised - Add 722-.222 EJC - 249847

SPEED	FEED	TOOLS GAGES AND EQUIPMENT	GA. OR CAL.	M/721	M/722	40X	722 - .222
		Feed to stop and cut off					
734	.005	Carbide cut-off Tool		B-50183	B-50183	B-50183	B-50183
		Stock Stop		B-90010V	B-90010V	B-90010V	A-90010V
		Snap Gage (Length)		B-80020W	B-80020P	B-80020P	B-80020P
		(M/721: 8.715"-8.695")					
		(M/40X& M/722: 7.865"-7.845")					
		Base Gage		D-51341	D-51341	D-51341	D-51341
		Base Gage		D-71554	D-71554	D-71554	D-71554
		NOTE: Deburr end of Bolt hole to gage only.					
		C'sink Bbl. hole (To be done after ream station until final design is reached on reamer A-TS-2348 & B-74686					
178	Hand	Severance c'sink (1¼ dia.)		Std.	Std.	Std.	Std.
		C'sink gage		B-74639	B-74639	B-74639	B-74639

APPROVAL AND DATES

PART NAME Receiver COOLANT A-9C SET UP TIME MODEL No 721-722-40X OPER. No 4
TYPE #5 J & L Turret Lathe MACH. HRS. DEPT. No 73 PAGE 3 OF 3
MACHINE

RD 6461

PROCESS RECORDS

DATES AND REASONS FOR REVISIONS 4/18/55 - Revised - EJC - 249847

TOOLS, GAGES AND EQUIPMENT			GA. OR CAL.	APPROVAL AND DATES 721	722	722 - .222
SPEED	FEED					
STEP	DRILL	BARREL & BOLT HOLE				
178	.011	Drill		A-69549	A-69549	A-69549
		1 7/16 spindle collet		B-90047W	B-90047W	B-90047W
		1 7/16 spindle collet bushing		B-90048W	B-90048W	B-90048W
		Flanged tool holder		B-90045V	B-90045V	B-90045V
		Adapter		B-90112N	B-90112N	B-90112N
DRILL	BOLT	HOLE TO FULL DEPTH				
123	.033	.683 oil hole drill		A-54222	A-54222	A-54222
		collet		B-54363	B-54363	B-54363
		Plug gage (.683-.680		B-80007V	B-80007V	B-80007V

NOTE: M/721 9" deep
M/722 - 8 1/8" deep

NOTE: Engage feed before drill enters small hole.

OPERATION DESCRIPTION				
	PART No.	20181	20182	10680
Step drill; deep hole drill; c'bore and face; tap; and cut off.				
	OCC. No.	39	39	39
	STD. HRS/C	10.225	9.791	9.791
(Combination of 4A and 4B are the alternate to 4)	STD. No.	E-66	E-67	E-67
	EFF. DATE	10/20/47	10/20/47	10/20/47

PART NAME Receiver COOLANT Macco SET UP TIME MODEL No 721-722 OPER. No 4A

TYPE J&L Turret MACH. HRS. DEPT. No 73 PAGE 1 OF 3

RD-8461

PROCESS RECORDS

DATES AND REASONS FOR REVISIONS 4/18/55 - Revised process - EJC - 249847

APPROVAL AND DATES

TOOLS, GAGES AND EQUIPMENT	GA. OR CAL.	721	722	722-.222
SPEED FEED				
C'BORE AND FACE BARREL HOLE				
1041 .007 Carbide c'bore		C-52104	C-52104	C-52104
Depth Ga. (1.151-1.149)		B-50240	B-50240	B-50240
Setting Gage		B-50295	B-50295	B-50295
Fed. Dial (1.003-.998 dia.)		B-80057W	B-80057W	B-80057W
Setting Gage		B-80064W	B-80064W	B-80064W
C'sink gage		B-74639	B-74639	B-74639
Flanged tool holder		B-90045V	B-90045V	B-90045V

NOTE: Maintain tension on star wheel and relieve c'bore as soon as feed stops.

OPERATION DESCRIPTION

PART No.

OCC. No.
STD. HRS/C
STD. No.
EFF. DATE

PART NAME Receiver COOLANT SET UP TIME MODEL No. 721-722 OPER. No. 4A

TYPE MACH. HRS. DEPT. No 73 PAGE 2 OF 3

RD-6461

PROCESS RECORD

DATES AND REASONS FOR REVISIONS 4/18/55 - Revised process - EJC - 249847

SPEED	FEED	TOOLS, GAGES AND EQUIPMENT	GA. OR CAL.	721	722	722-.222			
				APPROVAL AND DATES					
TAP BARREL HOLE									
40	Hand								
Return		Tap (1 1/16 NC-3)		B-52506	B-52506	B-52506			
90	Hand	Flanged tool holder		B-90045W	B-90045W	B-90045W			
		Releasing tap holder		B-90041V	B-90041V	B-90041V			
		Thread Gage		B-80071U	B-80071U	B-80071U			
		Thread segments		B-80072W	B-80072W	B-80072W			
		Min. Setting Ring (.003 T.I.R.)		B-80078W	B-80078W	B-80078W			
FEED TO STOP AND CUT OFF.									
734	.005	Carbide cut-off tool		B-50183	B-50183	B-50183			
		Stock Stop		B-90010V	B-90010V	B-90010V			
		Snap Gage (Lgth.) (M/721- 8.715-8.695) (M/722 - 7.865 - 7.845)		B-80020W	B-80020P	B-80020P			
		Base Gage		D-51341	D-51341	D-51341			
		NOTE: Deburr end of Bolt hole to gage only							
C'SINK BARREL HOLE (TO BE DONE AFTER DRILL STATION UNTIL DESIGN WORK IS COMPLETED ON C'BORE									
		Severence c'sink (1¼" dia.)		Std.	Std.	Std.			
		C;sink gage		B-74639	B-74639	B-74639			

PART NAME Receiver COOLANT Macco SET UP TIME MODEL No 721-722 OPER. No 4A
TYPE MACH. HRS. DEPT. No 73 PAGE 3 OF 3
MACHINE

RD-6463

PROCESS RECORDS

DATES AND REASONS FOR REVISIONS 4/18/55 - Revised process - EJC - 249847

SPEED	FEED	TOOLS, GAGES AND EQUIPMENT	GA. OR CAL.	721	722	722-.222			
				APPROVAL AND DATES					
#3 Cut		H.S.S. TWO STEP BROACH		D-53963	D-53963	D-53963			
#4 Return									
		Fixture		D-54493	D-54493	D-54493			
		Retriever		D-67025	D-67025	D-67025			
		Broach Holders		B-52322	B-52322	B-52322			
		Reducting Bushing		C-50196	C-50196	C-50196			
		Pull Pin		A-54548	A-54548	A-54548			
		Plug Gage (.703-.700)		B-80199V	B-80199V	B-80199V			
		Concentricity Gage (.003 ind. reading)		D-51341	D-51341	D-51341			
		NOTE: Permissable to accept at .7035 dia. when broaches are new.							

OPERATION DESCRIPTION	PART No.	20181	20182	18680
Broach bore to final I.D.				
NOTE: Combination of 4A & 4B are the alternates of 4)				
	OCC. No.	92	92	92
	STD. HRS/C	1.267	1.267	1.267
	STD. No.	E-97	E-97	E-97
	EFF. DATE	5/8/51	5/8/51	5/8/51

PART NAME Receiver COOLANT Sun. #623 SET UP TIME MODEL No. 721-722 OPER. No. 4B

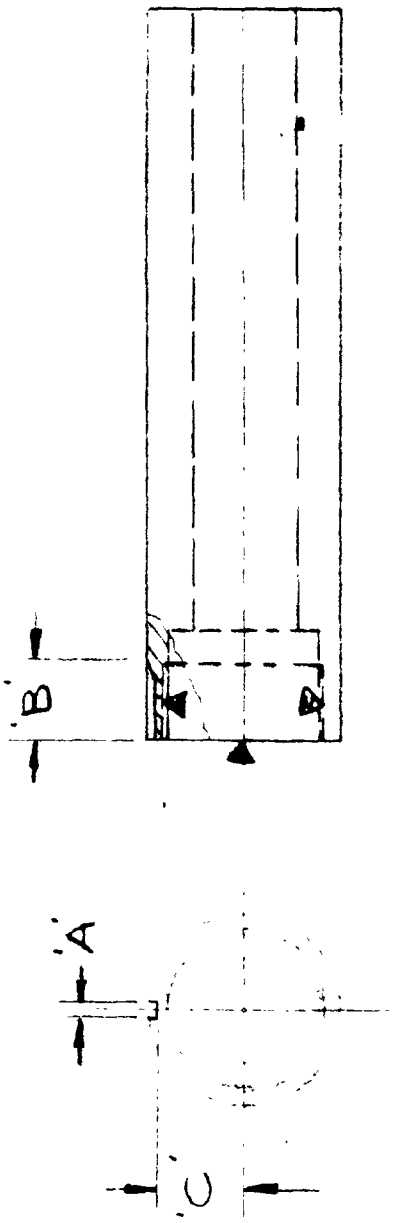
TYPE J&L Turret Lathe MACH. HRS. DEPT. No 58 PAGE 1 OF 1

RD-6461

TPR-7

PART: RECEIVER M,40 X	PART No. 19767
OPERATION: H/MILL LOCATING SLOT	OPER. No.: 8 DEPT. 73

PROCESS RECORD — ILLUSTRATION SKETCH



3/14/55 - Revised process - K - 249742

COMPILED BY: K-12 22 54	APPROVAL & DATE: K

REMINGTON ARMS COMPANY, INC., ILION, N. Y.

PROCESS RECORDS

DATES AND REASONS FOR REVISIONS 3/14/55 - Revised process - K - 249742 -
5/9/55 - Chg. "B" - "C" Dim. and dept. no. ZK - 249971

TOOLS, GAGES AND EQUIPMENT	GA. OR CAL.	M/40X	APPROVAL AND DATES				
SPEED / FEED							
Cutter - 3 x 1/8 x 1" hole		Std.					
Arbor 1" hole							
Fixture		D-73756					
Plug Gage "A" .127 - .124		B-80224P					
Template "B" .815 - .815		B-73758					
Spec. Snap Ga. "C" [illegible] - [illegible]		C-73925					
Plug Gage (Centrality)		B-74712					
Qualify Ga.		B-73728					
OPERATION DESCRIPTION	PART No.	19767					
Burr face and hand mill locating slot. (M/40X only)							
	OCC. No.						
(NOTE: M/40X becomes distinct at this point.)	STD. HRS/C						
	STD. No.						
	EFF. DATE						

PART NAME Receiver COOLANT SET UP TIME MODEL No. 40X OPER. No. 8
TYPE Whitney Hand Mill MACH. HRS. DEPT. No. 73 PAGE 1 OF 1

RD-6461

To: Vic
From: Bob "a"

Hrs - Hrs Required

All receivers Reamed in Dept 73

	Operation	Setup	Total
M/455-456	670	180	850
40-X	70	20	90
721-722 (20,000/yr)	2990	60	3050
725 (15,000/yr)	2240	30	2270

All receivers reamed in Dept 73 — 6260 hrs/yr
Less 455/456 − 850
5410
Hrs Available 3 shifts 5324
86

M/721-722 & 725 Receivers Broached

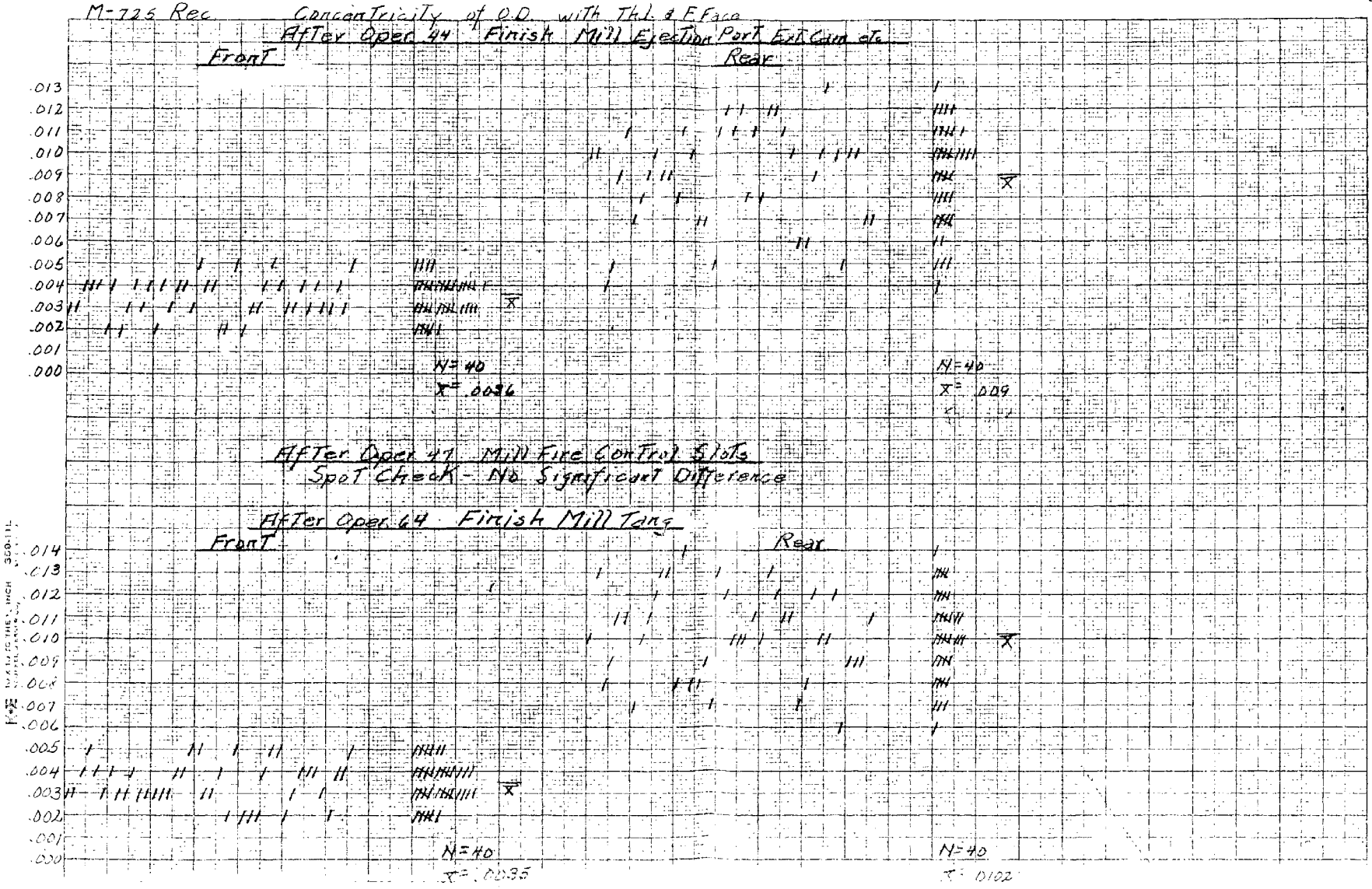
M/455-456	670	180	850
40-X	70	20	90
721-722	2050	60	2110
725	1530	30	1560

4610 Drilling
− 850
3760

721-722 No Ream
725 - Ream Dept 73 } 5320 min.

M-725 Rec. Concentricity of O.D. with Thd. & F Face

After Oper. 44 Finish Mill Ejection Port Ext. Cam etc.

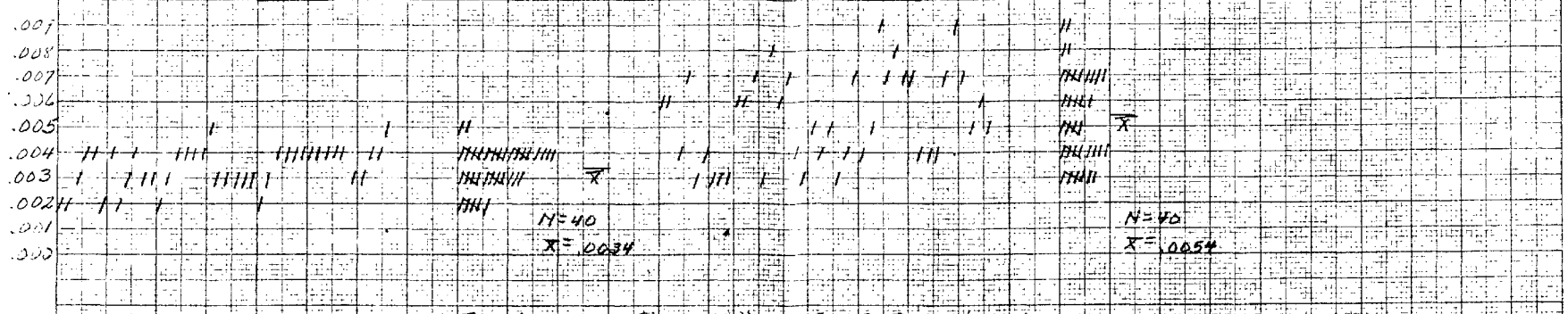


After Oper. 47 Mill Fire Control Slots
Spot Check - No Significant Difference

After Oper. 64 Finish Mill Tang

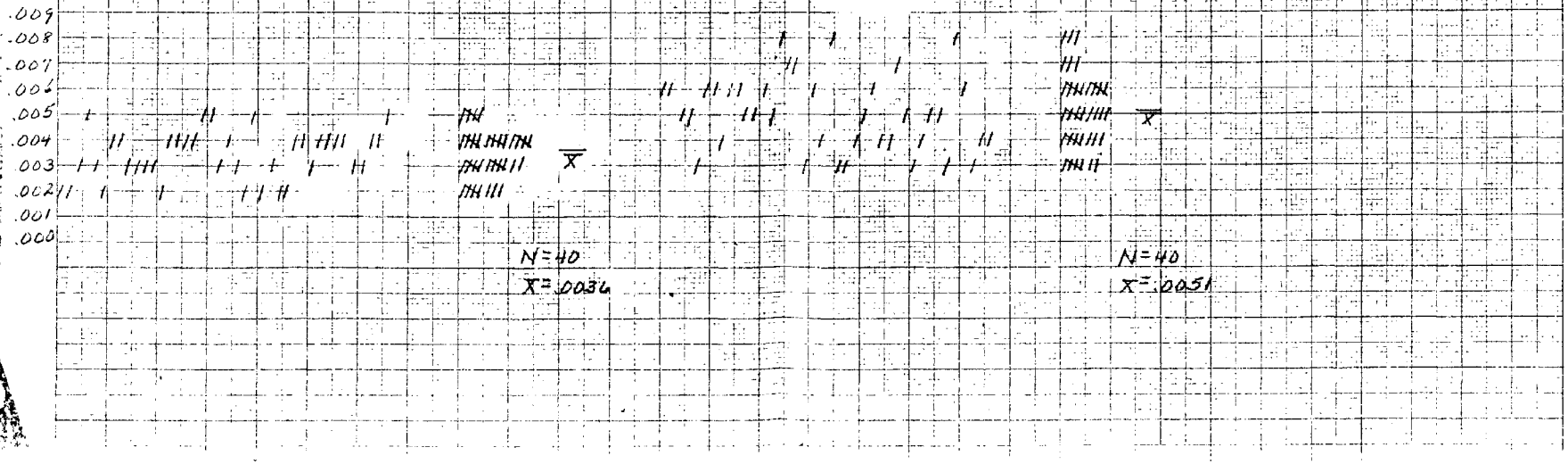
M-725 Receiver Concentricity of O.D with Thread & Front Face

After Oper. 20 Turn O.D

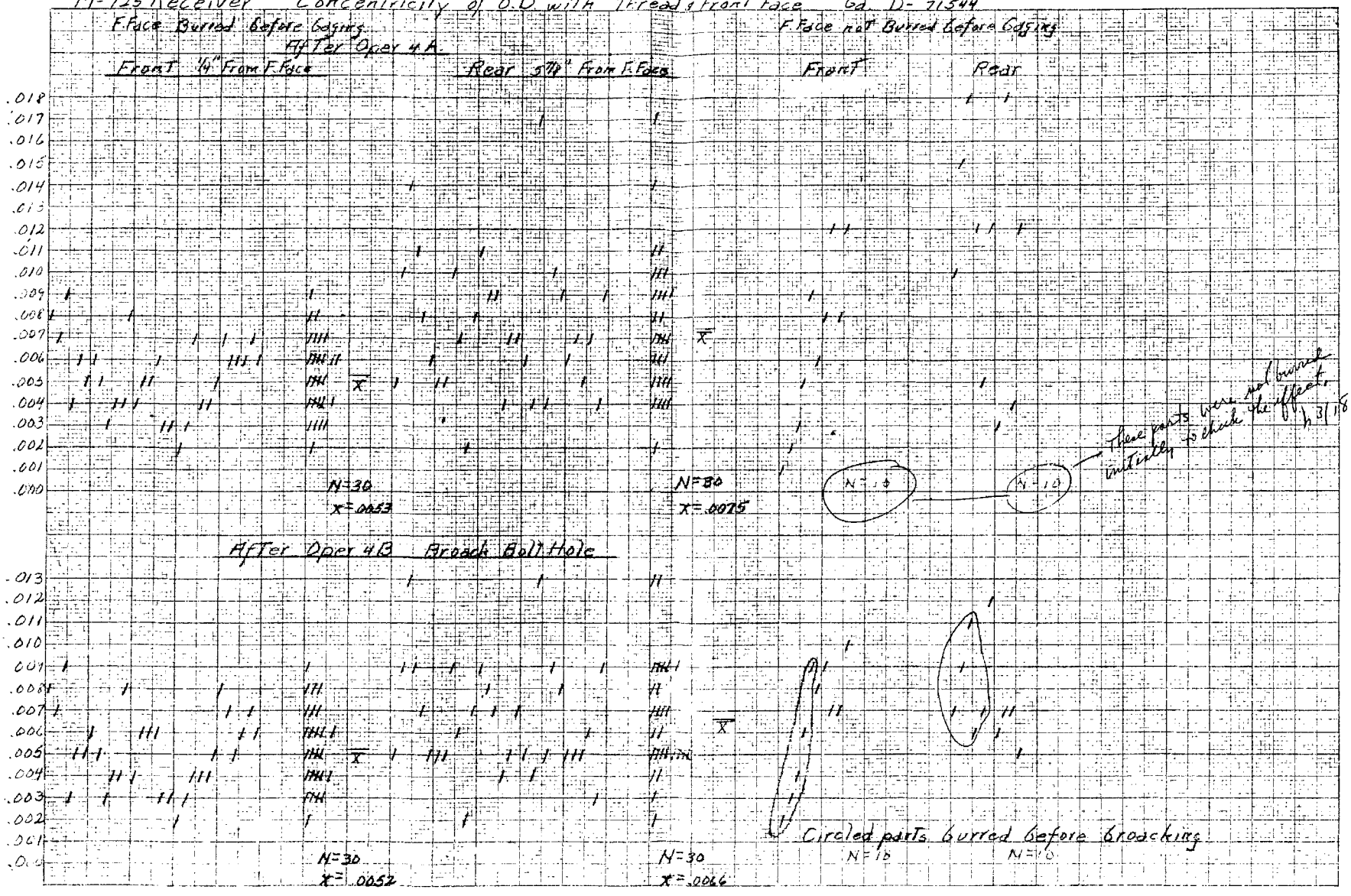


After Oper. 32 Plunge Mill Ejection Port & Mag. Slot
Spot Check - No Significant Difference

After Oper 40 Broach Ejection Port & Mag. Slot



M-725 Receiver Concentricity of O.D with Threads Front Face Gd. D-71544



M-725 Receiver Alignment of Bolt Hole with F. Face (as measured at rear of rec.)

After Oper 4A — Ga. D 11644 — After Oper 4B

Bored F. Face Before Gaging

After Oper 4A — After Oper 4B

21 1/2 - 1 Not Bored Before Gaging

18 1/3 1 1

Check at O.D. — Bolt Hole alignment pretty good by comparison

Note: Due to the fact that an adequate check of the Rec. Hole cannot be made after broaching the Rec. key slot, the O.D. was selected for consistency in comparing results. This one check was made for initial reference.

R 3/15/55

.016
.015
.014
.013
.012
.011
.010
.009
.008
.007
.006
.005
.004
.003
.002
.001
.000

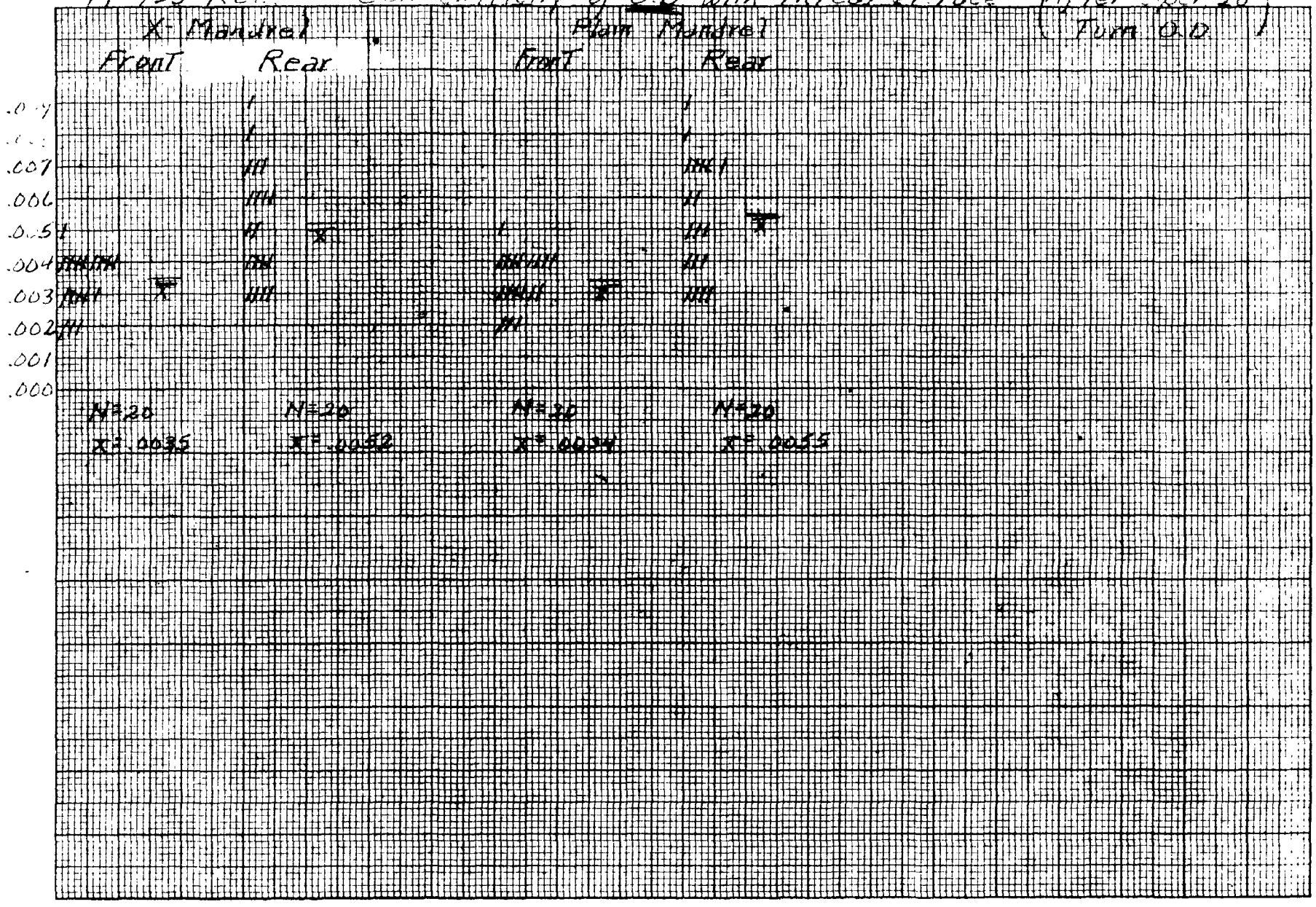
N=29
x̄ = .0035

N=30
x̄ = .0035

N=15

N=10

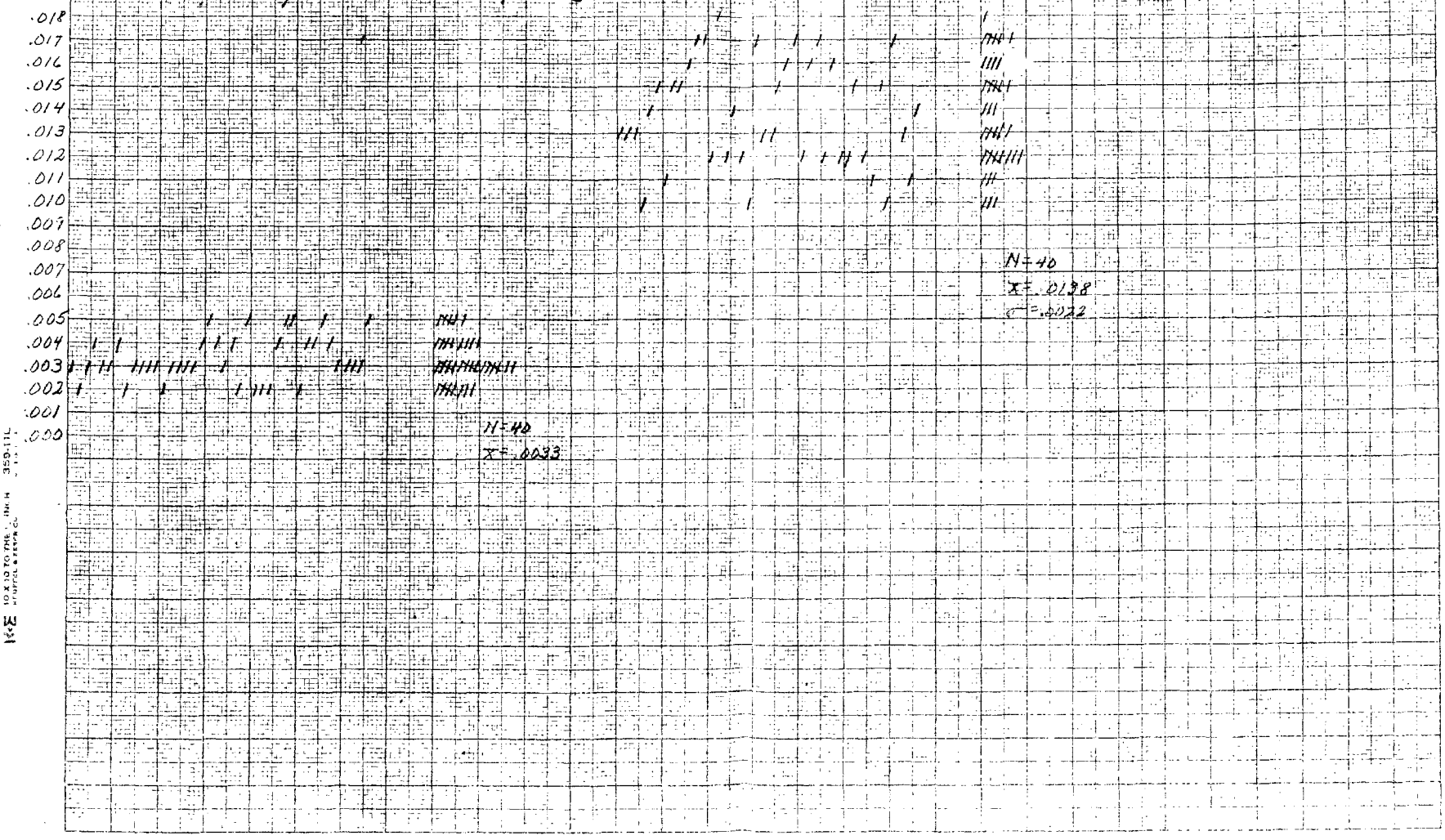
M-725 Rec. Concentricity of O.D. with Thread & Face (After Oper 20) (Turn O.D.)



M-725 Receiver Concentricity of O.D. with Thread & Front Face

After Oper 88 - Finish Mill Bolt Handle Slot
Spot Check - No Significant Difference

After Oper 110 - Profile Mg Recess & Burr



Ray Hurley

X
75 Per
Bolt Hole

This apparently points up the problem Best filed above on issues [illegible] personnel changes.
L. J. B. 2/27

CC: R. A. Williamson
H. J. Hackman
E. Sapp) In
R. Hurley) Turn
W. A. Best
E. Folmsbee
File

February 24, 1956

L. J. BOYLE

M/721-722 RECEIVER

Purpose: To show the angularity of face and threaded Barrel hole relative to problem of customer complaint "can't sight in properly" due to misalignment of Barrel and Receiver.

Observations: M/721 Receivers show considerable angularity of the Barrel hole with the face (chart #1) which is believed to be typical of current components ready for Assembly. The angularity is such as to indicate the possibility of additional customer complaints similar to the one referred to above.

M/722 Receivers also show some angularity of the Barrel hole with the face (chart #2). However, the degree is considerably less and appears to be relatively insignificant.

Reference to the Process Record shows that different processes are used in the manufacture of the two Receivers. In the M/721, the face, Barrel thread c'bore and Bolt hole are generated separately while in the M/722, the face is squared and the c'bore for the thread and the Bolt hole are reamed with a single combination tool (B-74686) to assure better alignment. A similar experimental tool (A-TS-2348) is also listed for the M/721. However, it is understood that this latter tool was made and tested but that the problem was not followed to a conclusion due to changes in Engineering personnel. Therefore, M/721 Receivers are still manufactured by the original process.

The data suggests that if the same process used for the M/722 Receiver is adapted to the M/721, the problem of misalignment of Barrel and Receiver may be minimized.

Method: I. Squareness of Front Face

Receivers were placed vertically in a "V" Block and measurements taken with a height gage at the top, bottom, left and right side of the front face. The height gage was set to zero each time for the reading at the top.

[redacted]

Method: (Continued)

II. Angle of Tap in Receiver

Receivers were placed horizontally in a "V" Block and a tap screwed into the Barrel hole to approximately the same depth for each Receiver. Readings were taken 1-3/4" out on the stem of the tap at the top, bottom, left and right side. The height gage was again set to zero for the reading at the top.

Attached sheets show the squareness of the front face in relation to the O.D. of the Receiver and the angle which the tap enters in relation to the centerline of the Receiver.

Calculations for above are on file in the Quality Control Department.

QUALITY CONTROL DEPARTMENT
A. D. Gordon, Supervisor

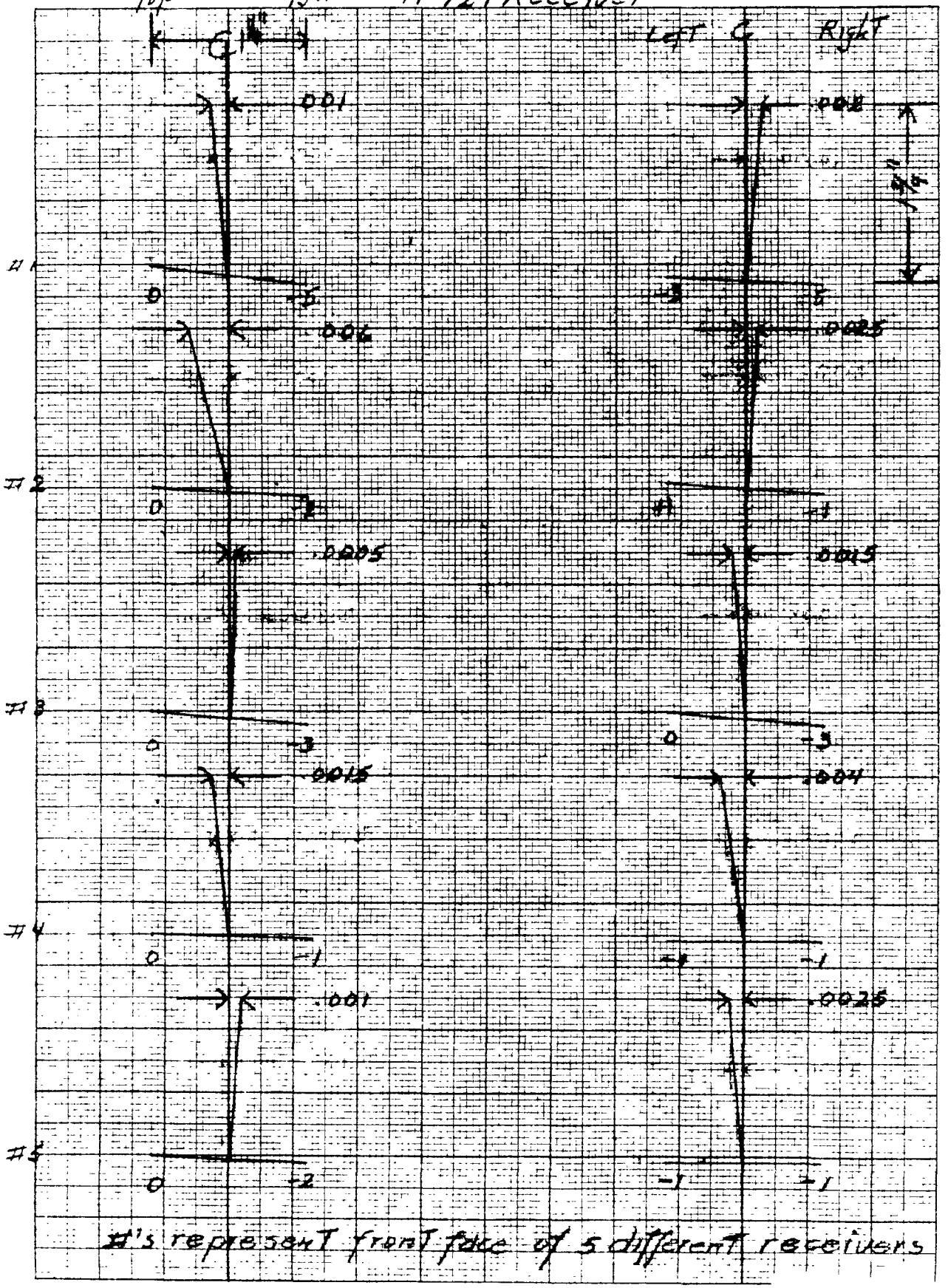
by A. B. Paulson
A. B. Paulson

ABP/I
Attach.

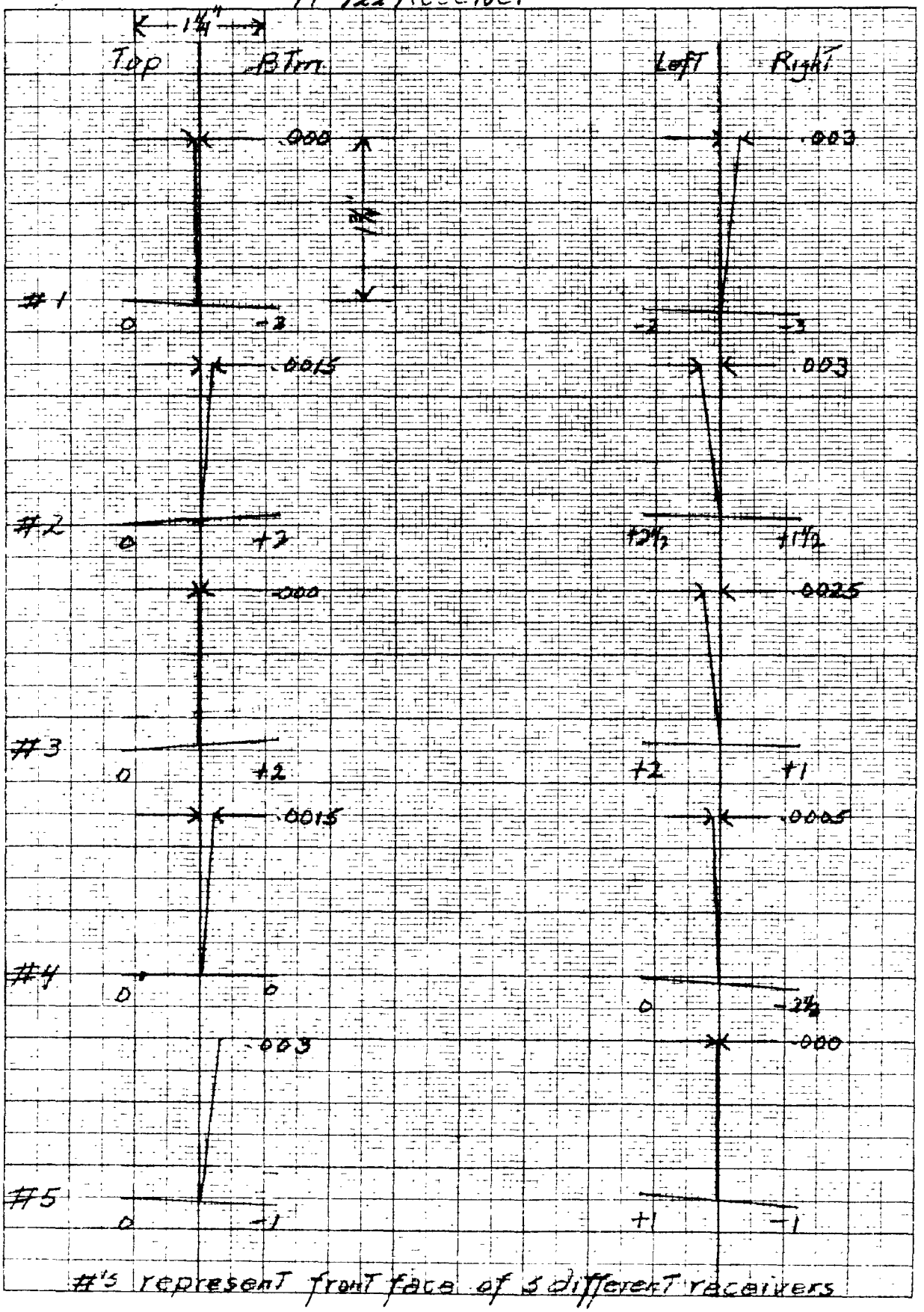
[redacted]

Squareness of Front Face & Angle of Top
Top Btm M-721 Receiver

1



Squareness of Front Face & Angle of Tap
M-722 Receiver



#'s represent front face of 5 different receivers

1 – The study was made in 1955 [illegible] Technique to be used [illegible] to the same [illegible] the charts taken 7/17/57 on the attached charts were taken from a study) made 6/2/55

"to measure the alignment of the receiver & barrel at the points affecting bedding in the stock for comparison of the results obtained by two (2) different processes of manufacture"

ie – 1/721 Receiver vs. 1/40 x receiver

the data suggests that the point of aim for:–

1– 1/721. is low & to the right with very appreciable scatter both horizontally & vertically.
a – Horizontal variation ranges from .030 rt to .010 left.
b – Vertical variation ranges from .005 above the horizontal centerline to .050 below.

2– 1/40 x. has a tendency to lay low & left but with significantly less scatter & better grouping closer to the horizontal & vertical centerline.

Note:– the attached data represents Barrel & Receiver assemblies checked at a point 10½" away from the front screw hole in the receiver.

L. Jeanard 10/11/57

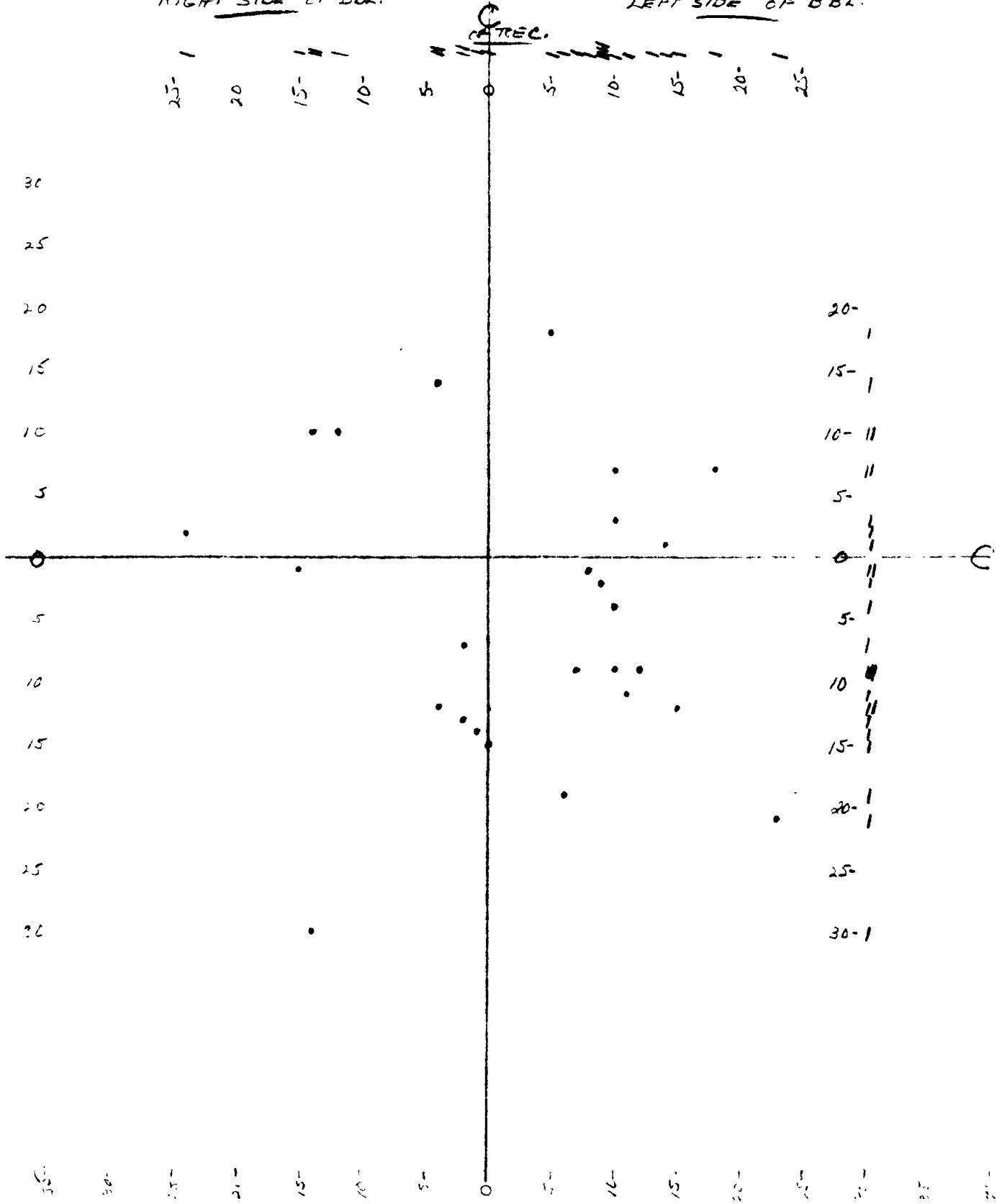
BY F. MACRINA DATE ..... SUBJECT M-40X RECEIVER-BARREL SHEET NO. 2 OF 2

CHKD. BY F.M. DATE 5-27-55 JOB NO. .....

PROCESS #2

VIEWED FROM MUZZLE

RIGHT SIDE OF BBL. LEFT SIDE OF BBL.



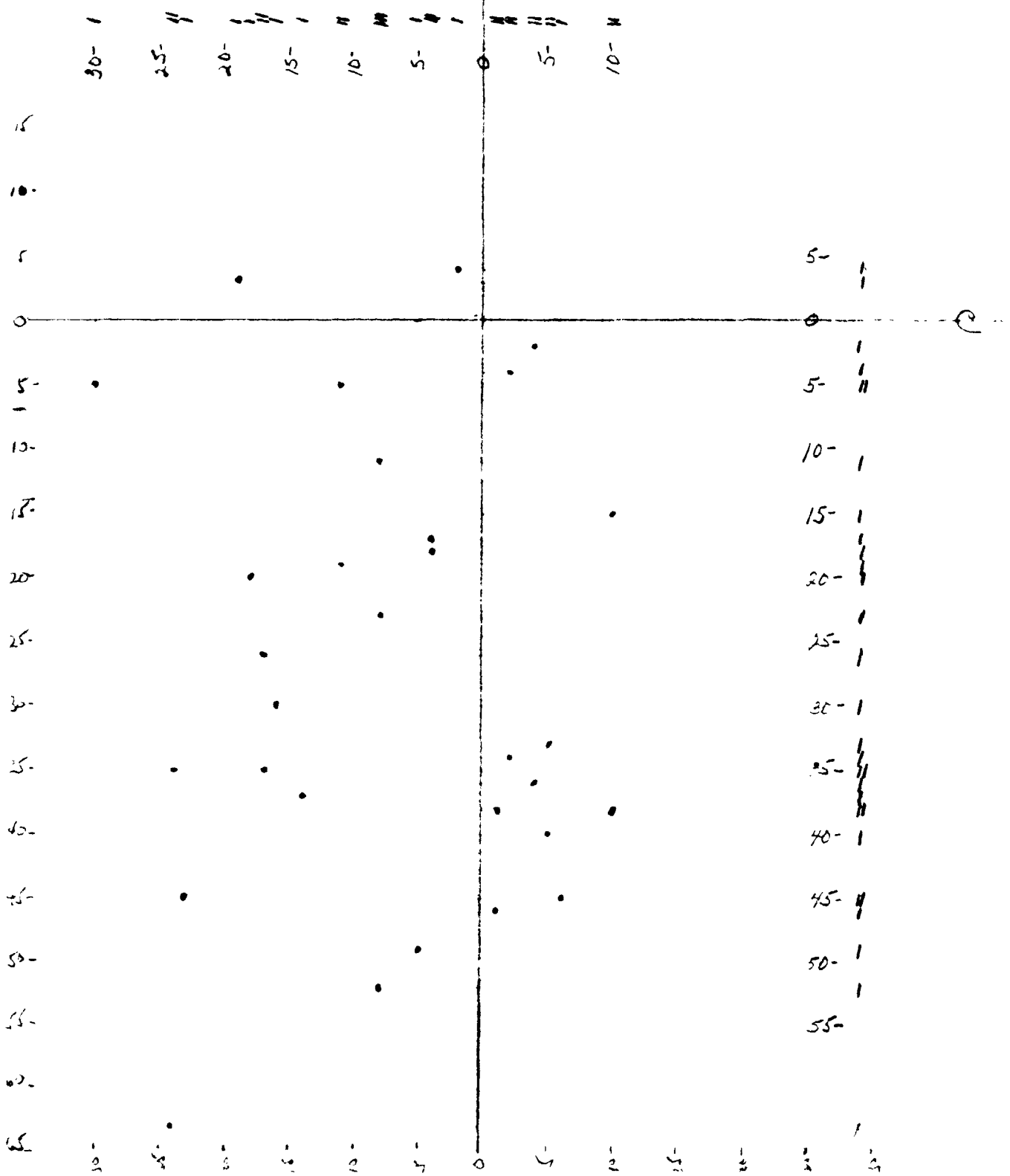
BY F. MARINA DATE ..... SUBJECT M/721 RECEIVER-BARREL SHEET NO. 1 OF 2
CHKD. BY F. M. DATE 5-25-55 .257 CAL. JOB NO. .....

PROCESS #1

VIEW FROM MUZZLE

RIGHT SIDE OF BOR C LEFT SIDE OF BOR

OF REC



DON'T SAY IT—WRITE IT

To 5/22/[illegible]

Date

From

721-722-[illegible] Reamer

Using present reamer set up, bolt hole align. is being held to [illegible] req'd. by M/D (Bore go. D-71554). (These [illegible] P/R). However, because of added cycle time (O.P. #4) being run in this manner — 721, 722 [illegible] set up as op 4A & 4B. Contour should be [illegible] improved & a c'sink added to rear of [illegible] cut-off bar.

USE YOUR BRAINS—A MACHINE HAS NONE

REQUEST FOR BRAND NEW EQUIPMENT	REQUEST FOR NEW EQUIPMENT TO SUPERSEDE OLD EQUIPMENT	~~REQUEST FOR ALTERATION~~	~~REVISION NOTIFICATION~~	~~INACTIVE OR OBSOLETE NOTIFICATION~~

CROSS OUT 4 OF THE ABOVE HEADINGS

MODEL: 121 COMPONENT: [illegible] PART NOS.:

OPER. NO.: OPERATION: FIRST MACHINING

NAME OF TOOL: [illegible] REAMER CORE & FACING TOOL

QUANTITY: INV. NO. & SUFFIXES:

DWG. NO.: C-TS-2501 LAST REVISION DATE:

SUPERSEDES OLD DWG. NO.: OLD INVENTORY NO.:

OLD DESIGN CAN CANNOT CAN WITH ALTERATION BE USED (CROSS OUT 2)

DESCRIPTION OF WORK: NEW

QUOTATION ONLY – WENOT – SONIS –

McCREERY TOOL CORP – WAUKESHA TOOL CO.

NOTIFICATION OR EXPERIMENT NO.: APPROVED: [signature] TOOL DESIGN DATE: 1-26-55

RD-5936 REV. 1 **ENGINEERING SECTION STANDARD EQUIPMENT FORM**

RD-69-B

REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE

Remington DU PONT PETERS DU PONT

"CONFINE YOUR LETTER TO ONE SUBJECT ONLY"

What does this mean

CC: H. J. Hackman
S. M. Alvis
In E. K. Wheat
Turn P. H. Eccleston

Please attach [illegible] Part 4-9

(1) Hurley
(2) Sapp

April 1, 1952

TO: E. Sapp

FROM: M. H. Walker

SUBJECT: MODEL 721 BARREL AND RECEIVER THREADS

As you know we have had considerable difficulty with the alignment of the Barrel and Receiver due to angularity of the threads on these two parts. This condition has existed since the announcement of the Model 721 and is one which has been discussed considerably.

I do not believe that anyone would question the fact that improvement of this condition would improve the bedding and consequently improve the accuracy. It could also conceivably help to alleviate in a small way the cracked stock condition in the action cuts.

Present intentions are to add an angularity tolerance to the Barrel and Receiver threads. This would consist of an indicator reading in the center of the Barrel as the Barrel was screwed into a fixed threaded ring. In practice the weight of the Barrel is enough to give proper reading on the indicator due to angularity of the threads with the center line of the bore. Temporarily, .040" total indicator reading max. is proposed for the Barrel.

The Receiver can be measured in the same manner by screwing it on a threaded plug with the dial indicator at the rear of the Receiver. This gaging would probably come after the centerless grinding operation on the Receiver. .010" total indicator reading max. is proposed for the Receiver.

Unless you find that these tolerances are either too small or too large within the next sixty days they will be added to the Barrel and Receiver drawings.

M. H. Walker
Research and Development Department

RECEIVED
1 1952

MHW:NL

[redacted]

G-88-REM

DON'T SAY IT—WRITE IT

TO E. Sopp

DATE 4-4-52

FROM R W Selwood

I agree with the merit in what mike is attempting to do. I do not agree with the way he is attempting to do it. Checking the panel and receiver will not insure the condition of panel and receiver alignment. The straightening operation in the panel assembly process will effect the alignment condition more than the limits which mike anticipates putting on the parts.

I will investigate the panel whover

NO ONE WAS EVER INJURED OBEYING SAFETY RULES

to see if at the new Bickford operation it will meet the .090 limit as specified in the attached letter.

A lot of 30 Receivers was measured after the first centerless grind operation for angularity of threads. In an attempt to duplicate the gaging set up as proposed by M. Walker, it was found that duplication of readings was quite difficult to obtain due primarily to the weight of the receiver ~~to~~ acting against the comparatively small bearing area in the threads.

By measuring the eccentricity of an extension on a threaded plug gage at two different points, approximately 1 1/8" apart, it was found that the thread was at an angle of $\bar{X}$ = .0015 within that length — with .0005 T.I.R.

In order to obtain a controllable operation if gaging 6" toward the rear of the receiver would require a tolerance of .045" —

Respectfully
E.
E. C.

$$V_T = \frac{2\pi r N}{12}$$

$$V_T = \frac{\pi D N}{12}$$

$$N = \frac{12 V_T}{\pi D} = \frac{4 V_T}{D}$$

SFPM	RPM
110	630/440
96	548/384
76	434/304
40	230/160
35	200/140

.0066 /REV.

Re-opened for J. T. Reames

BASE [illegible]

REAMER B-74686

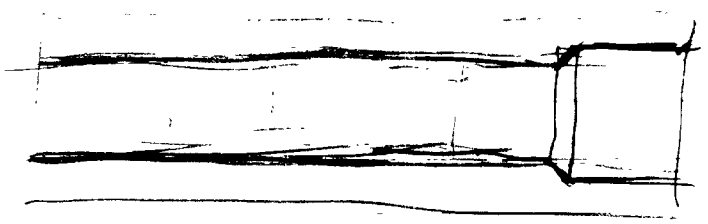
DEPTH B-50240

2-2-5 Rem

Estimated Direct Cost comparisons of Alternative Methods of Finishing Grade M1721-2 - 40X Receivers

Based on Cost per 100 pcs

	Previous Method		Present Method				Alternative Method	
	M1721	M1722-40X	M1721		M1722-40X		M1721	M1722-40X
			Fast Run	Slow Run	Fast Run	Slow Run		
Op 2	$15.68	$15.00	$19.60	$27.50	$18.40	$25.85	$14.70	$14.10
Op 6	1.95	1.95	—	—	—	—	1.95	1.95
Op 7	—	—	—	—	—	—	2.98	2.98
Op 8	—	—	—	—	—	—	2.62	2.62
Total Cost	$17.63	$16.95	$19.60	$27.50	$18.40	$25.85	$22.25	$21.65
Operations Eliminated								



OLD	PRESENT	ALTERNATE
2 J&L	2 J&L	2 J&L
~~BROACH BORE~~	STEP DRILL	STEP DRILL
STEP DRILL	DEEP HOLE DRILL	DEEP HOLE DRILL
DEEP HOLE DRILL	REAM, C'BORE & FACE	C'SINK FEED TO STOP
C'BORE & FACE	C'SINK	CUT OFF
C'SINK TAP	TAP (PILOTED)	M/721 M/722
FEED TO STOP	FEED TO STOP	9.600 9.200
CUT OFF	CUT OFF	
6 BROACH BORE (FINAL I.D.)		6. BROACH BORE 1.267
10 ~~BROACH SPLINES~~	10 ~~BROACH SPLINES~~	7. ~~C'BORE~~ C'BORE (DRILL JIG & PILOT) (SPEC DRILL PRESS) 2.00
14 ~~TURN O.D.~~	~~14 TURN O.D.~~	8. TAP (PILOTED WARNER & SWASEY) 1.250
M/721 M/722	M/721 M/722	
22 10.225 9.791 Dec 39 Optional	12800 12.000	10 ~~BROACH SPLINES~~
2pc. 1.267 1.267 Dec 92 Optional	18.000 16.900	
		14 ~~TURN O.D.~~

CC: R. A. Williamson
A. J. Brown
H. J. Hackman
E. B. Wallin
W. A. Best
A. D. Gordon
A. D. Kerr
C. Putney
E. E. Folmsbee
L. J. Boyle
L. Pettingill
N. S. Thompson
C. Mann
M. Bennett
J. W. Miller
R. Snell
V. G. De Reus
R. B. Hurley
W. Leek
Tool Design
L. Stickles
E. Corcoran
Central File

PRODUCT ENGINEERING & CONTROL
Remington Arms Company, Inc.
Ilion, New York

To: E. Sapp
From: E. Corcoran
Engineer
in Charge: R. B. Hurley

Date: 1-21-53
Model No.: 721-722
Part Name: Receiver
Part No.: 20180
20182
18680
Dwg. No.: D-20181
Exp. No.: 223158

REQUEST FOR CHANGE

Title: Request for additional tooling on Model 721-722 Receiver.

Object: To comply with model drawing revision #85.

Summary: Revision #85 added the following note: "Alignment of threads must be held so that an indicator reading at the rear end of the Receiver when threaded on a rotating plug of zero run-out is less than .010".

Since it is intended to provide control over alignment of the Barrel and Receiver, the gage should simulate assembly conditions by allowing the Receiver face to be seated tight against a shoulder on the threaded plug before rear end run-out is checked. Model drawing should be changed to indicate this.

An experimental counterbore and facing tool (B-TS-1897) is being made in Dept. 26 and should be ready by 1-21-53. This tool will be held in a floating holder and within the full length of the bolt hole before the reamer engages the work thereby controlling alignment. The tap will also be allowed to float

Estimated tooling costs will be as follows:

Design	48 hours
Build	100 hours
Purchase	$ 70.00

Conclusion:

1. Tool Design Section is requested to:

   1. Design and make a base gage with a rotating threaded and shouldered plug and two dial gages: one to pick up on rear end bolt hole I.D. at operation #2 and the second to pick up on O.D. after turning operation #14. (40 design and 80 build hours).

   2. Design and make piloted counterbore and facing tool (work already started - see B-IS-1897). (8 Design and 20 Build hours - record only).

   3. Purchase two (2) Ziegler floating holders (already on order). Purchase cost $35.00 each - record only).

   * Only one base required since operations 2 and 14 are performed next to each other.

Engineer

Production

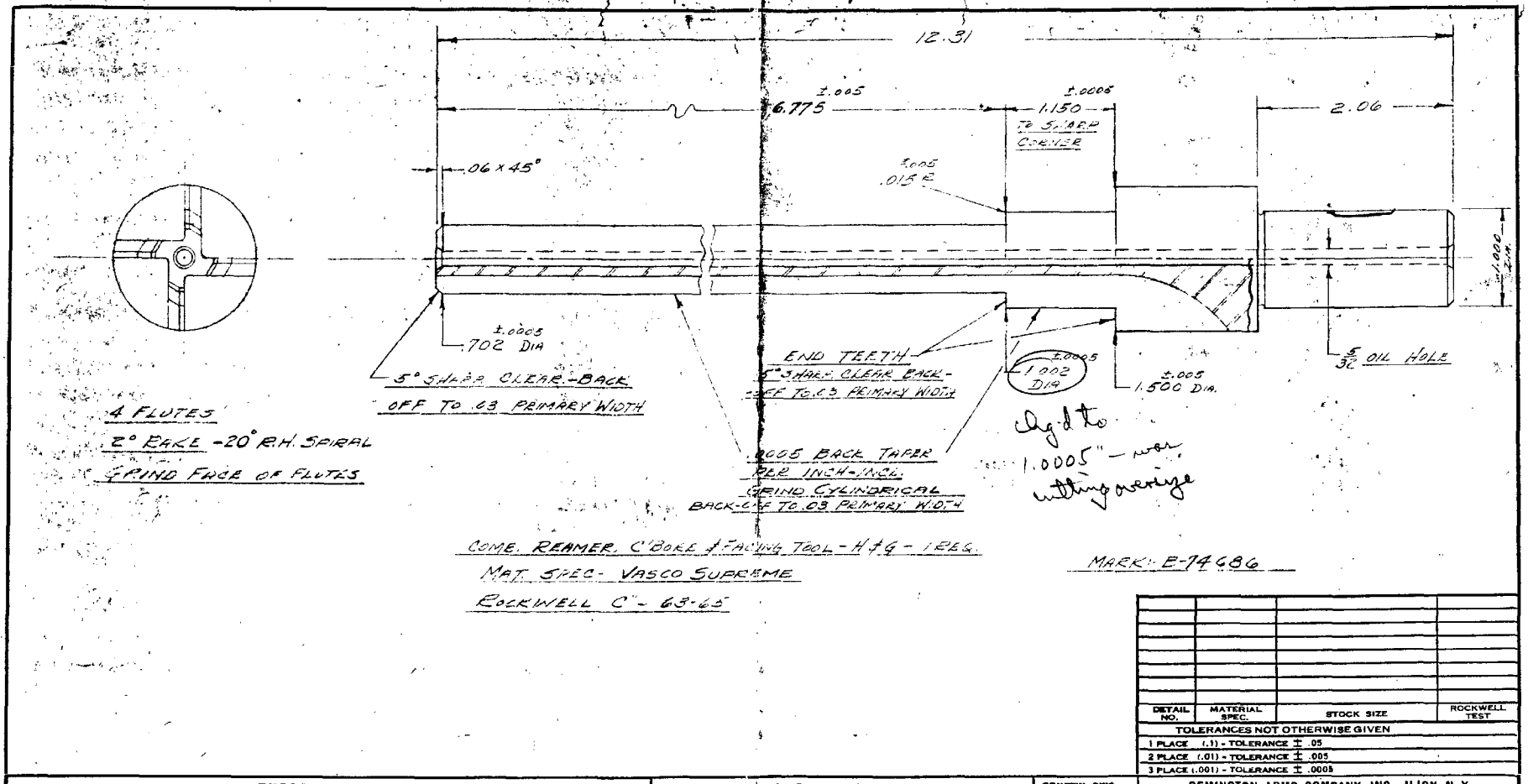
Chg. To Dept. 70

Chief Process Engineer

Methods and Standards

fc

E-74686



DETAIL NO.	MATERIAL SPEC.	STOCK SIZE	ROCKWELL TEST

TOLERANCES NOT OTHERWISE GIVEN
1 PLACE (.1) - TOLERANCE ± .05
2 PLACE (.01) - TOLERANCE ± .005
3 PLACE (.001) - TOLERANCE ± .0005

RECORD OF ALTERATIONS	ADDITIONAL USES	CONST'N. DWG.
	M/722 - RECEIVER	
		DETAILS

REMINGTON ARMS COMPANY, INC., ILION, N. Y.

MODEL 40X SCALE FULL ORDER No. 2018
PART RECEIVER
TOOL COMB. REAMER C'BORE & FACING TOOL
OPERATION FIRST MACHINING

	BY	DATE		BY	DATE
DESIGNED			APPROVED		
DRAWN	RWJ	6 1 54	SUPD'S DWG. No.	B-75-2349	
CHECKED			DRAWING No.	E-74686	
TRACED					

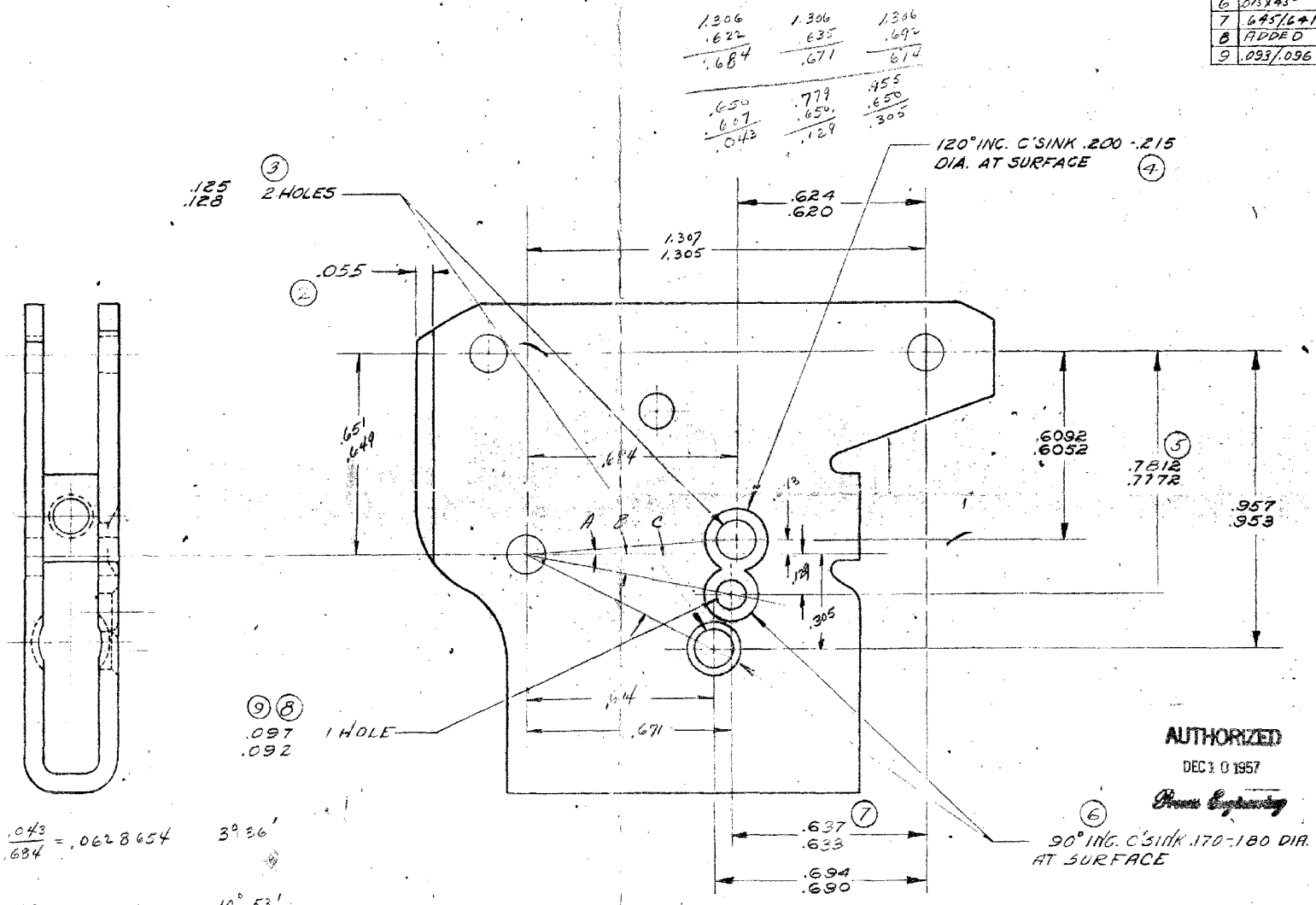
M/725 - Receiver

C-16429

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.

ALTERATIONS

LET	WAS	REFERENCE	BY	DATE
1	RE DIMENSION HOLE LOCATION	DCR 2777	[illegible]	7-25-57
2	REMOVED .038 X 45°	DCR 2633	[illegible]	9/5/57
3	3 HOLES	DCR 2920		11/21/57
4	.220-.235	"	"	"
5	.8212/.8172	"	"	"
6	.015 X 45°	"	"	"
7	.645/.641	"	"	"
8	ADDED	"	"	"
9	.093/.096	DCR 2042	[illegible]	1/4/62



AUTHORIZED
DEC 10 1957
Design Engineering

TAN ∠A = .043/.684 = .0628654 3° 36'

TAN ∠B = .129/.671 = .192250 10° 53'

TAN ∠C = .305/.614 = .496744 26° 25'

NOTE:
FOR DIMENSIONS NOT SHOWN SEE DWG. C-17039

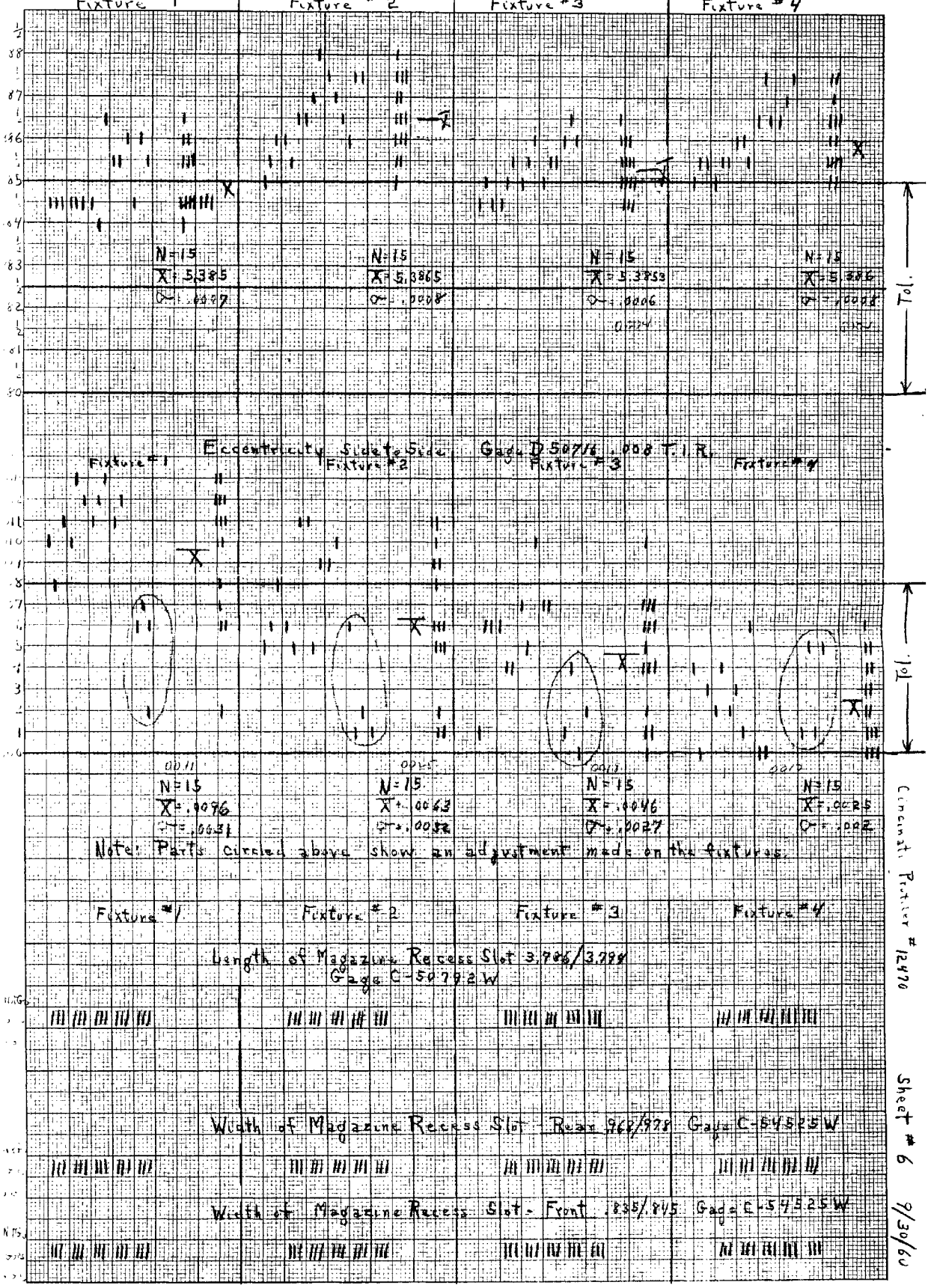
725	FIRE CONTROL HOUSING		
MODEL	PART USE	QUAN.	SEE
DES'D BY DATE	DRAWN BY DATE PS 6-20-57	CHECK BY DATE PS 6/21/57	APPR BY DATE W 6/28/57
TITLE HOUSING			
NUMBER C-16429	SCALE 4:1	SUPERSEDES—REFERENCE	
REMINGTON ARMS CO. INC. RESEARCH & DEV. DEPT.			

9 3 8 2 7 6 4 5

TFC-1 REV. 2

K+E 10 X 10 TO THE ½ INCH KEUFFEL & ESSER CO. 359-11L MADE IN U.S.A.

Model 725 Receiver (Long) Part # 23755 Position of Slot Lengthwise Gg-D 50221 - Tol 5.380/5.385



Cincinnati Fixture # 12470

Sheet # 6

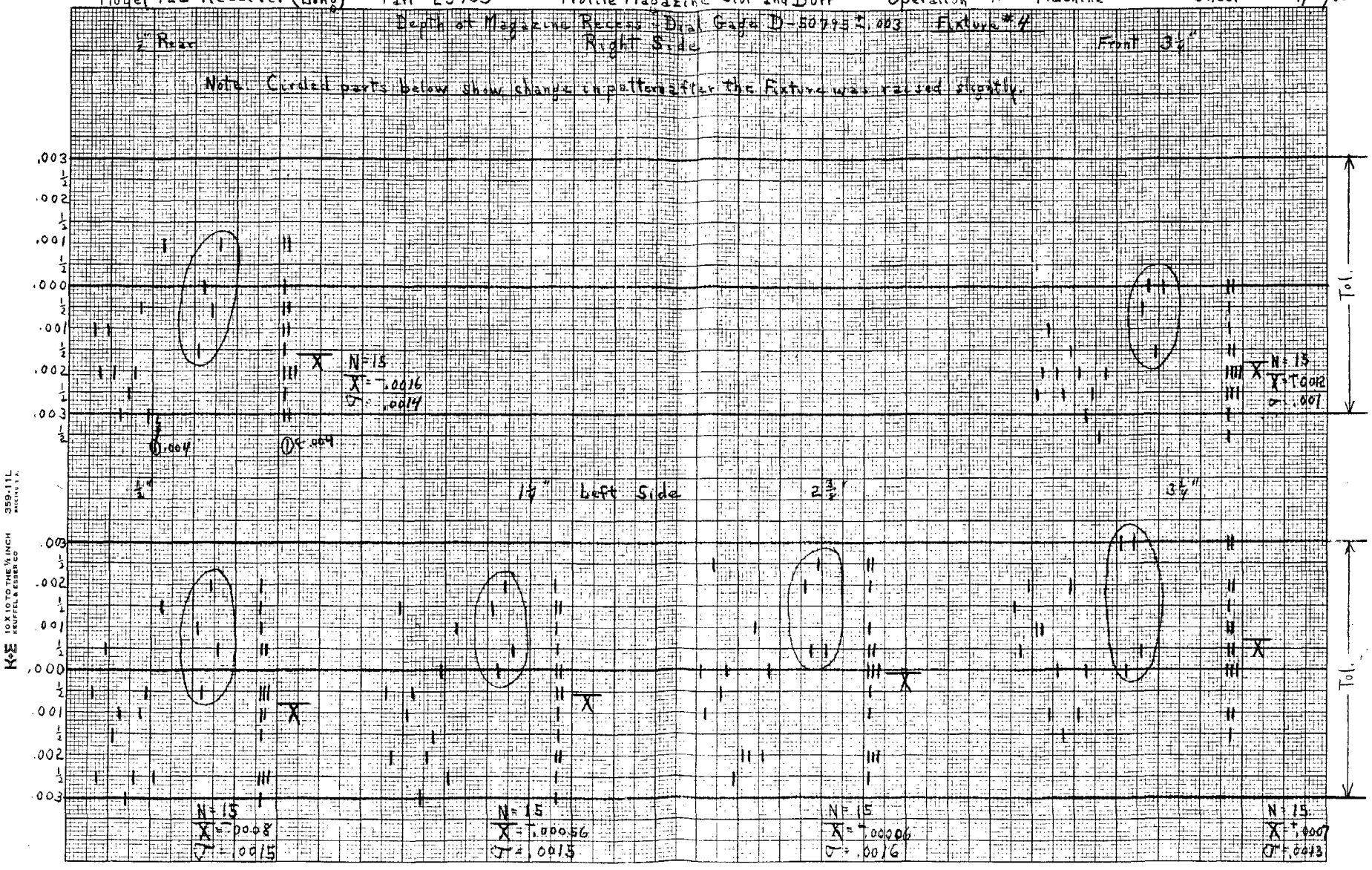
9/30/60

Model 722 Receiver (Long) Part# 23755 Profile Magazine Slot and Burr Cincinati Profiler Operation #110 Machine# Sheet #5 9/30/60

Depth of Magazine Recess - Dial Gage D-50795 ± .003 Fixture #4

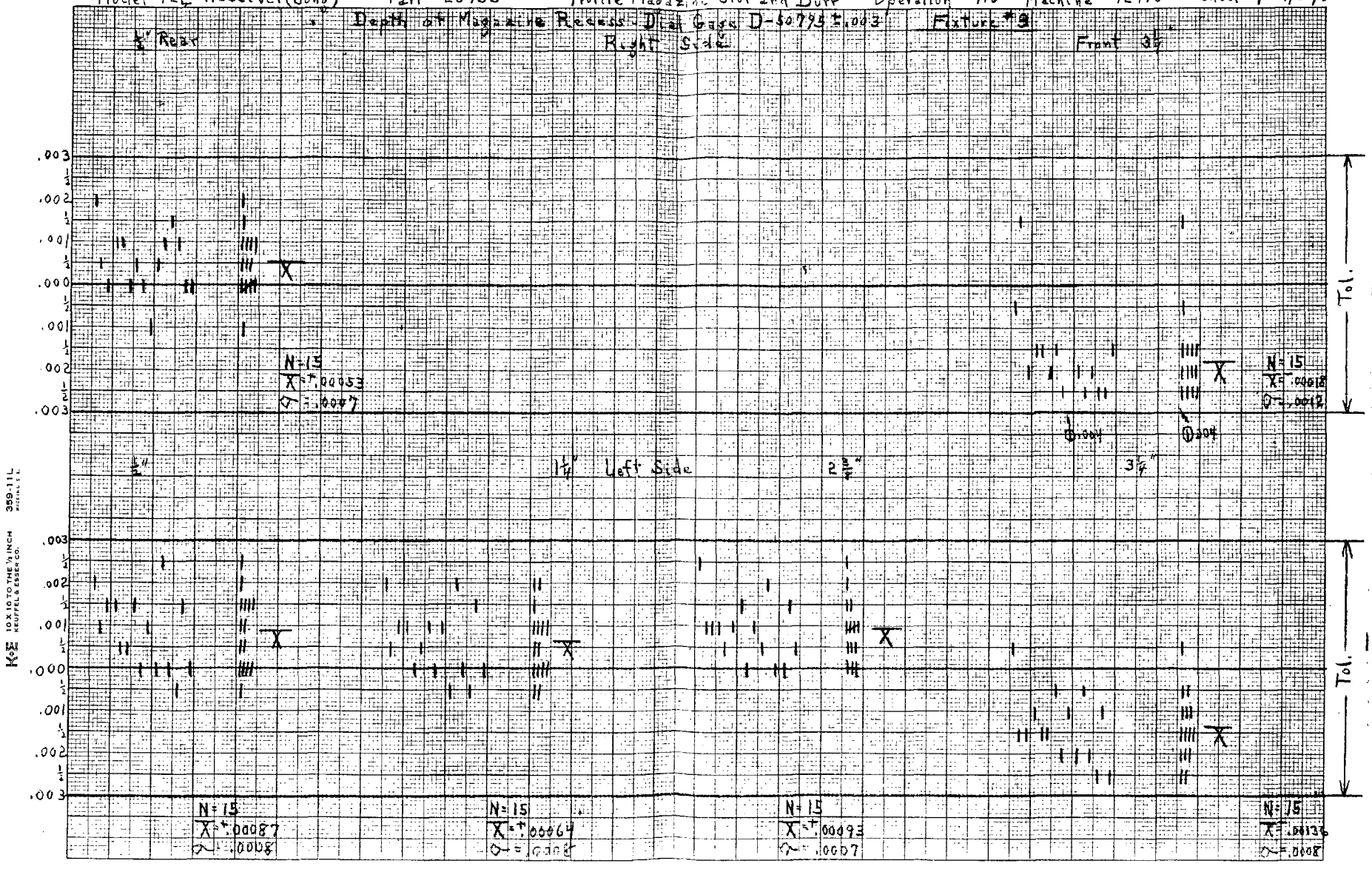
Right Side

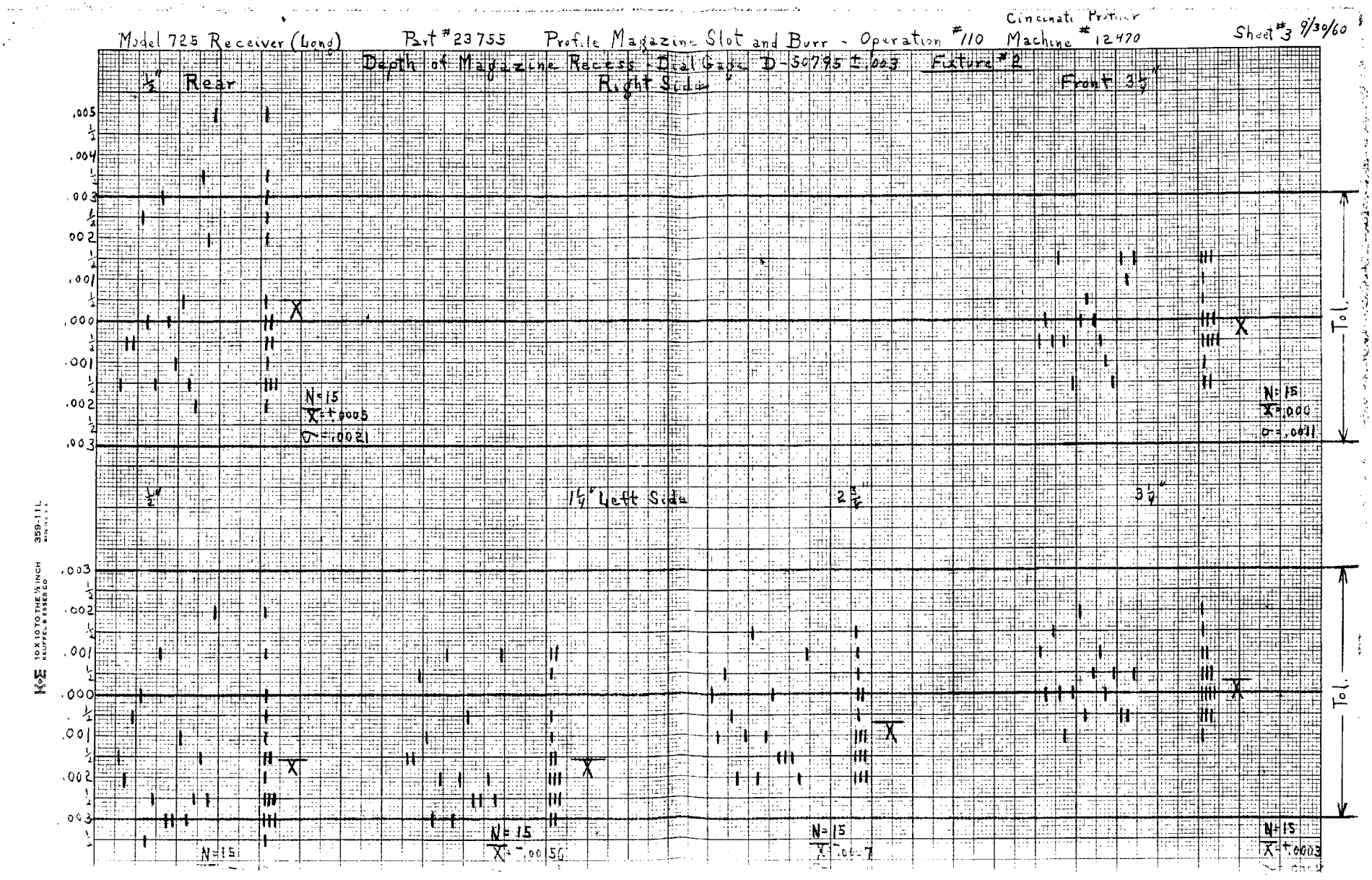
Note: Circled parts below show change in pattern after the Fixture was raised slightly.



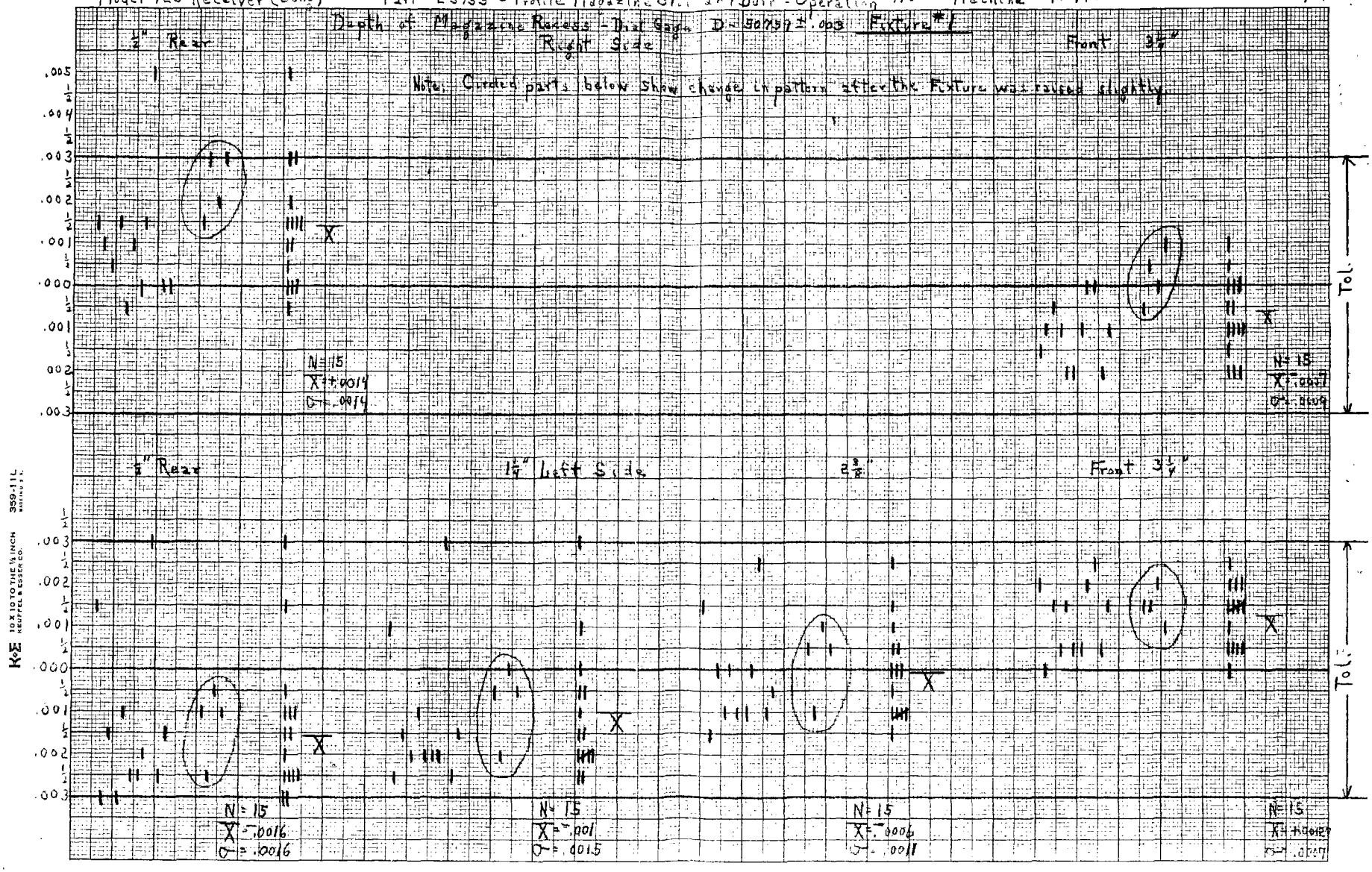
Model 722 Receiver (Long) Part # 23755 Profile Magazine Slot and Burr Operation #110 Cincinati Profiler Machine # 12470 Sheet #4 9/30/60

Depth of Magazine Recess - Dial Gage D-50795 ±.003 Fixture #9





Model 725 Receiver (Long) Part #23755 - Profile Magazine Slot and Burr - Operation #110 Cincinnati Profiler Machine # 12470 Sheet #2 9/30/60



CC: L. J. Boyle
H. J. Hackman
R. B. Hurley
E. C. Ranney
E. J. Mock
A. T. Francisco
Auditor
File

October 26, 1960

R. W. SELWOOD

MACHINE STUDY
MODEL 725, RECEIVER #23755 (LONG)
CINCINNATI, 360° PROFILER #12470
OPERATION 110 PROFILE MAGAZINE SLOT AND BURR

Purpose: This study was taken to evaluate controllability of the machine after extensive repairs were reported as completed.

CONCLUSIONS: The operation is uncontrollable.

Remarks: Overall length and width of the Magazine recess appears to be satisfactory. The data suggests, however, that further work to align the fixtures lengthwise and crosswise and also to level them in relation to the path of the cutter would be required.

The V-block locators in fixtures 1 and 2 are reported as cracked and probably should be replaced. The "tongue" locators for radial location were also reported as comparatively loose in the receivers when placed in the fixture as compared to a tight fit in the gages. These differences in the fixtures could be a factor contributing to excessive variation in the measurements noted on the gages and should be checked.

An additional study should be made when corrective action has been accomplished.

Method: Fifteen (15) parts were taken in sequence from each of the four (4) fixtures and measured with gages per Process Record.

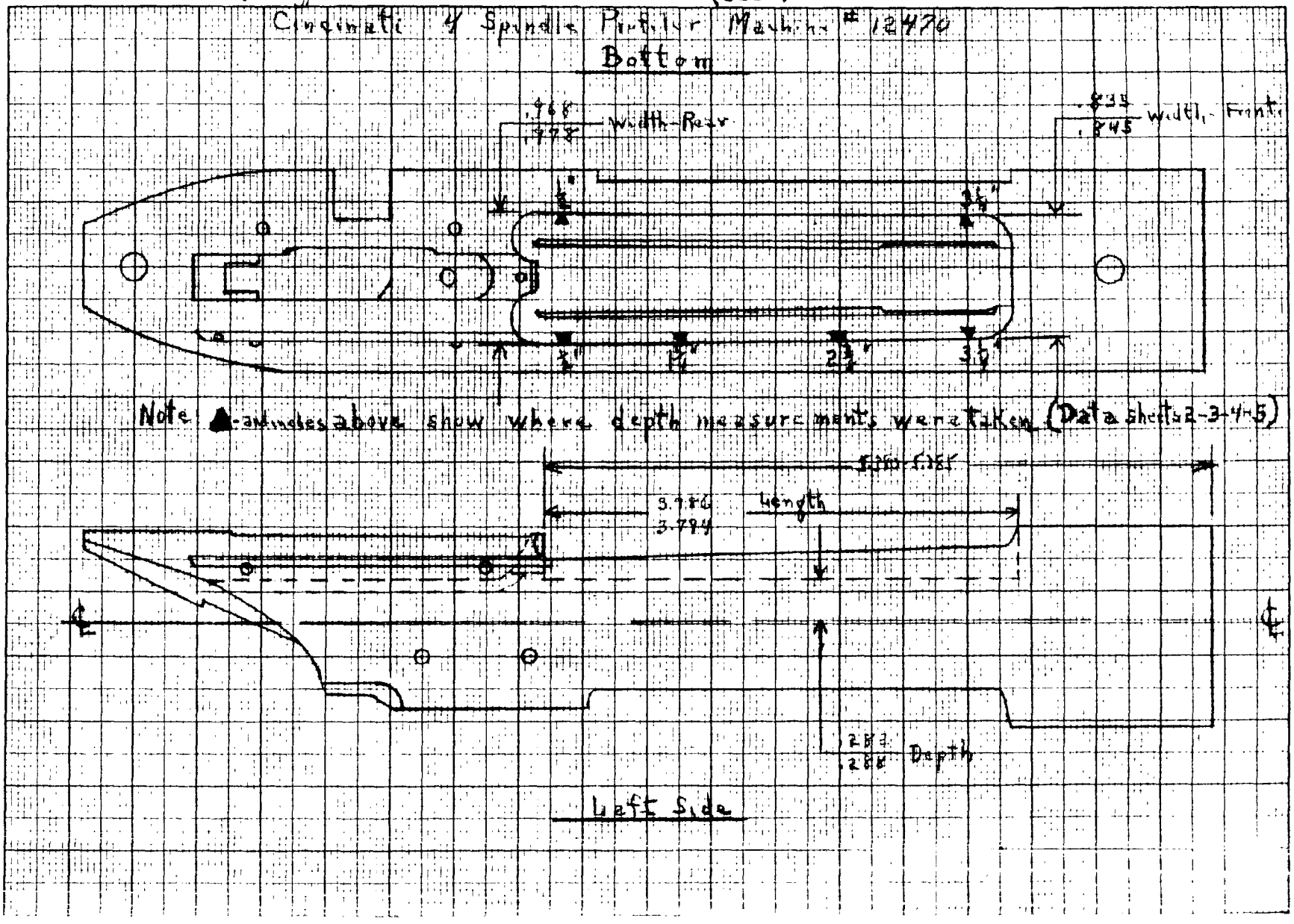
QUALITY CONTROL DEPARTMENT
A. D. Gordon, Supervisor

L. Leonard

Model 725 (Long) Part # 23755 Receiver Data Sheet #1

Cincinnati 4 Spindle Profiler Machine # 12470

Bottom



Sheet #1 1/3/1

RD-5038

EQUIPMENT INSPECTION REPORT

SUBJECT M/725 Barrel & Rec. Ass'y .244 TO DEPT. NO.

INV'TY NO. ORDER NO. 29— DWG. NO. D-20181 DATE 4-16-59

Chk

Bolt Lug Grooves Set Parallel

℄ .700 Dia. Bolt Hole Set Parallel

*711598 ℄ Bore @ Muzzle is .065 above ℄ Bolt

*711498 ℄ Bore @ Muzzle is .020 above ℄ Bolt

℄ Bolt to Top of Receiver Bridge - rear end
(2.025 R - 1.462, 1458 = .563 - .567)

*711598 is .557

*711498 is .561

INSPECTOR Comstock CORRECT PASSED BY DEL. TO

725 Rec

CC: E. B. Wallin
W. E. Leek
~~R. B. Hurley~~

Ilion, New York
July 20, 1956

RECEIVED
JUL 23 195
PROCESS ENGINEER

V. G. DeReus

The following is an estimate for proposed changes to equipment and sequence for manufacturing M/725 Receivers - short and long. Due to lack of surplus machines and adequate space in present machinery layout for additional machines, it will be necessary to concide purchasing of same type of machine for the new operations #53 or alternates #54 and #55. Due to the shortage of floor space, operation #53, using a new O-8 Cinn. R. & F. Machine with duplex head was considered for the regular operation. Alternate shown would use two new Nichols Hand Mills and would require more floor space.

Operation #4 through #48 - same as present M/721-722 sequence.

Operation #52 - Drill scope holes, guard screw and gas escape holes. (Note: Only two guard screw holes needed for new style Guard instead of three. Reduction in direct labor.)

Operation #53 - Mill Safety clearance, right and left sides (O-8 Cinn.)

Fixture	40	120
Cutters (2 req'd)	4	12
Snap Gage - Width	4	12
Gage - Depth & Pos. Right Side	60	180

Total design and build hours - 432.

Operation #54 (alternate) - Mill Safety clearance, right side (Nichols Hand Mill)

Fixture	40	120
Cutter	4	12
Wing Gage - Depth & Pos.	60	180

Operation #55 (alternate) - Mill Safety clearance, Left side (Nichols Hand Mill).

Fixture	40	120
Cutter (same as Op. #54)		
Gage Snap	4	12

Total design and build hours - 592.

Operation #60 - Butt mill, drill, and ream fire control holes. (Note: Due to previous new cut, it will not be necessary to butt mill only one hole. Reduction in direct labor and tool usage.)

Operation #64 through #104 - Same as present M/721-722 sequence.

Operation #107 - Profile fire control safety slot

Fixture - OK		
Former (alter)	40	120
Gage Pos. (alter)	1	3
Gage depth (alter)	25	75

Total design and build hours - 264.

Operation #108 through Operation #132 - same as present M/721-722 sequence.

Operation #136 - Tap two Guard screw holes. (Note: Elimination of one Guard screw hole would reduce direct labor and tool usage.)

Operation #140 through Operation #196 - Same as present M/721-722 sequence.

Total cost of regular sequence above:

Total cost of equipment	- 432 hrs. @ $5	- $ 2,160
O-8 Cinn. R. & F. Miller		10,000
	Total	$12,160
	10% Contingencies	1,216
Total cost using O-8 Miller		$13,376

Total cost of alternate operations:

Total cost of equipment - 592 hrs. @$5 -		$ 2,960
Two (2) Nichols Hand Mills @ $3,500		7,000
	Total	$ 9,960
	10% Contingencies	996
Total		$10,956

Machine estimates were supplied by Purchasing and are only tentative. They should be verified by firm quotes from vendors before final decision is made.

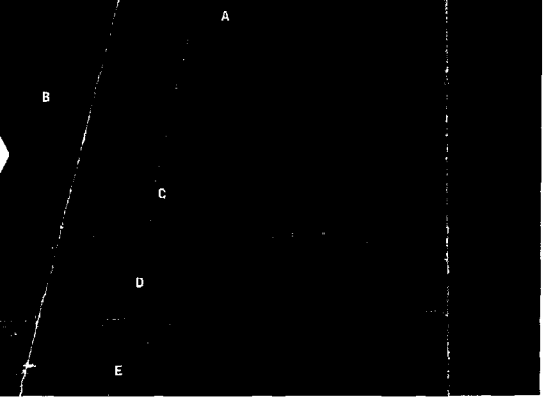
N. Thompson

N. S. Thompson

NST:EK

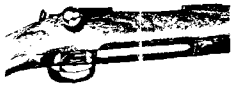
Now . . . Drilled & tapped for 5 possible sight mountings

NEW



NEW

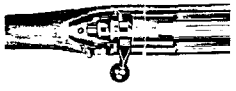
LOADING OR UNLOADING
Hinged floor plate makes job of loading, or unloading a lot easier. Just push the release button to remove cartridges from magazine. No working of bolt. If a low mounted scope interferes, load magazine from the bottom in seconds!



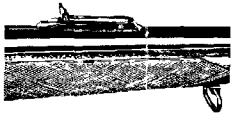
LARGE THUMB SAFETY
Placed on the right rear of the receiver, the big safety is right where shooters want it. Fast, positive, quiet . . . it also has a neutral (middle) position which allows the bolt to be drawn back, keeping the rifle on "Safe" at same time. Long travel distance of safety allows shooter to see at a glance whether safety is on or off.

NEW

MATTED RECEIVER
Finish of receiver is matted for better visibility. Note clearly marked F and S for "Fire" and "Safe".



Windage Adjustable Open Rear Sight
New Remington designed open rear sight has windage adjustment screw on right side of sight leaf. Merely turn screw right or left when sighting in. To remove rear sight, if receiver or scope sights are desired, take out screw on right side of sight base. This allows sight leaf to be removed. Two hold down screws will be found on top of base. Remove these and barrel is ready for scope block mounting. If receiver sight is installed, take out filler screws on left side of receiver, and use to fill in barrel under rear open sight.



NEW

WITH OR WITHOUT
Easily removable hood on ramp front sight gives shooter instant choice. With hood in place, gold bead is exactly centered and flat faced for a more perfect sight picture every time!

What The New All Purpose Stock Does For The Shooter!

Revolutionary new **all purpose stock** means no more worry about interchanging between open and telescopic sights. No matter which is used, the eye is always in perfect sighting line. The pistol grip has been shaped to reduce the reach from hand to trigger . . . . . assuring more uniform squeezing of trigger. Straighter stock lines combined with slight forward slope of comb means less recoil.

SPECIFICATIONS
Remington Model 725ADL

Caliber
30-06, 280 Remington, 270 Win.

Action
Bolt. Bright finished body . . . handle blued. Same strong bolt design as famous Remington M/721-722. Receiver matte finished.

Magazine
Fixed box with hinged floor plate. Floor plate release inside trigger guard. 4 shot capacity plus one in chamber. Wide corrugated match-type trigger.

Stock
American Walnut . . . forearm and pistol grip finely checkered. **All purpose stock** with Monte Carlo comb for use with open or telescopic sights. Black grip cap and black checkered butt plate.

Safety
Thumb operated lever . . . 3 position control. Receiver marked F and S for "Fire" and "Safe". Middle position for opening bolt with trigger on safe.

Barrel
22-inch round tapered.

Sights
Flat face gold bead front sight with hood. Step adjustable rear sight with windage adjustment screw.

Weight	Length
7 lbs.	42½ inches overall.

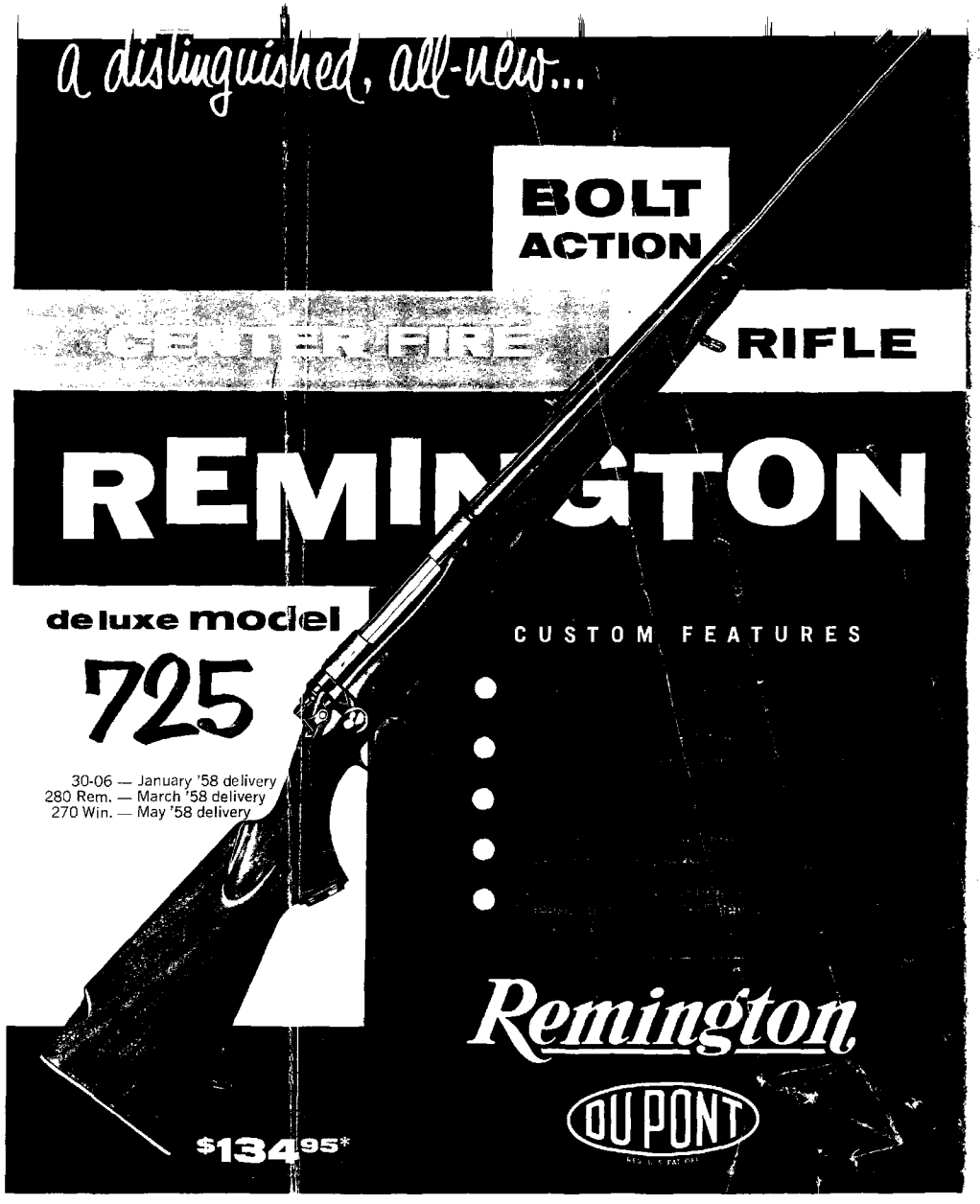
Also available in D "Peerless" and F "Premier" grades.

Remington

DU PONT

Remington Arms Company, Inc.
Bridgeport 2, Connecticut

Form No. 57-218R Printed in U.S.A.



G-88

DON'T SAY IT—WRITE IT

To K. Grunlee

From B. Gilbert

Date 2/15/55

1170

(M/725) 222 Stocks

Boxes labeled .222 should contain 819.

There are 2 piles of short stocks on the floor – 56 and 305 count, total 361. These may be .222 but are not so identified. I tried an action in some and they seemed ok to me.

TO BE SAFE; FIRST THINK YOU MIGHT NOT BE

5-38

DON'T SAY IT—WRITE IT

TO [illegible]

FROM B. Gilbert

DATE 3/22/62

11/25 Stock Inventory

	10 per Pt Lake		
#24565-30/06 — 318	200 -	~~H8~~	100
#24566 .222 - 1118	30	4	1100
#24567 .243 - 235	50		150

Wk 1400 to

[illegible] 3/22

1.43

@ $12.37 = $17.318

1.43

THERE IS A SAFE WAY; DO IT THAT WAY

G-88

DON'T SAY IT—WRITE IT

To [illegible]

From [illegible]

Date [illegible]

[illegible] of the [illegible] stock
To the [illegible] for the [illegible].

Delivery of first quantity, 100 [illegible] do, [illegible] 11/1/58

THERE IS A SAFE WAY; DO IT THAT WAY

G-88

DON'T SAY IT—WRITE IT

To A. Ziegler

From C. Gilbert

Date 10/2/61

M/725 Stock Ins.

	Assembly & Wood Det	Stores	Total	3 mo estimate	
Long 30/06. – 1270 280	62	530	592	280	300
.222 –	2	1288	1290	–	1300
.308 – 243	12	217	229	–	200
					1800

@ $12.37 = $22,266

THERE IS A SAFE WAY; DO IT THAT WAY

T25 CAL. DISTRIBUTION

	JAN	FEB	MAR	APR	MAY	JUNE	JULY	AUG	SEPT	OCT	NOV	DEC	
30/06	34	75	94	121	341	463	573	695	772	948	1055	1082	39.6
		41	19	27	220	122	110	122	77	176	107	27	
270	15	27	37	41	99	143	184	245	304	356	379	392	14.4
		12	10	4	56	44	41	61	59	52	23	13	
280	13	21	34	41	96	114	145	168	193	233	239	245	9.0
		8	13	7	55	18	31	23	25	40	6	6	
222	30	73	110	135	212	256	288	322	356	386	417	439	16.1
		43	37	25	77	44	32	34	34	30	31	22	
244	8	14	25	54	72	132	220	222	223	224	224	224	8.2
		6	11	29	18	60	88	2	1	1	0	0	
243	13	26	50	57	113	150	188	219	272	306	335	347	12.7
		13	24	7	56	37	38	31	53	34	29	12	
264													
Total	113	236	350	449	933	1258	1598	1871	2120	2453	2649	2729	
	113	123	114	99	484	325	340	273	249	333	196	80	
30/06	21	1	2	5	23	177	105	4	78	208	74	32	
270	44	22	70	60	1	17	1			(1)	19		
280	82	3	19	43	59	11	1						
222	61	15	21	35	4	51	31		1		10	15	
244				(1)				1					
243	2	9	18	58	83	24	27		43	[illegible]	39		
264													
Total	210	48	130	200	170	280	165	5	122	212	142	47	

725 cal. Distribution - 1960

	Jan	Feb	Mar	Apr	May	June	July	Aug	Sept	Oct	Nov	Dec
30/06	49	88	139	192	513	599	710	826	952	1044	1070	1098
		39	51	53	324	86	111	116	126	92	26	28
270	15	36	59	47	202	225	251	287	406	437	526	538
		21	23	8	135	23	26	36	119	31	89	12
280	40	54	85	116	203	249	291	345	397	424	446	450
		14	31	31	87	46	42	54	52	27	22	4
222	38	71	120	179	270	308	335	363	380	394	408	415
		33	49	59	91	38	27	28	17	14	14	7
244	15	37	57	68	107	120	128	148	163	172	174	178
		22	20	11	39	13	8	20	15	9	2	4
243	—	—	—	-	—	306	464	555	591	608	621	628
						306	158	91	36	17	13	7
Total	157	286	460	622	1295	1807	2179	2524	2889	3079	3245	3308
		129	174	162	673	512	372	345	365	190	166	59
						Production						
30/06	306	326	17	3	28	1	72	1	72	10	88	81
270		1	1	121	3	58	154	105	88		90	1
280	4	16	131	147	42	8	5	7	1	9		
222			12	7	224	20	16		34		35	7
244	2		10	39	15	59	45	56	18	2		
243						328	186	78	40	5	21	
Total	312	343	169	317	250	474	490	248	132	20	58	87

725 Calibre Distribution - 1959

	Jan	Feb	Mar	Apr	May	June	July	Aug	Sept	Oct	Nov	Dec	
30/06	83	51	89	91	355	159	200	245	181	139	66	30	
		134	223	314	669	828	1028	1273	1454	1593	1659	1689	41.1
270	32	15	34	33	74	109	68	65	61	40	10	12	
		47	81	114	188	297	365	430	491	531	541	553	13.5
280	38	27	43	27	152	67	64	126	136	62	36	16	
		65	108	145	297	364	428	554	690	752	788	804	19.5
222	113	71	56	42	109	33	52	40	39	25	22	14	
		184	240	282	391	424	476	516	555	580	602	616	15.0
244				27	171	95	64	30	34	10	6	10	
				27	198	293	357	387	421	431	437	447	10.9
Total	266	164	222	230	861	463	448	506	451	276	140	82	
Cum.		430	652	882	1743	2206	2654	3160	3611	3887	4027	4109	
					Distribution								
30/06	11	11	265	130	207	135	117	167	191	219	189	147	1789
270	4	57	41	2	68	124	150	1	5	12		14	478
280	1	352	38	154	10	26	4	2	119		2	3	711
222	507	74	94	104	8	123	128	2	7	1	2	17	1067
244				43	131	151	2	33	45	4	3	3	445
Total	523	494	438	463	424	559	401	205	367	236	196	184	
					2342	2901	3302	3507	3874	4110	4306	4490	4490

6/22/61

Parts to furnish for 725 -

30/06 - 398
270 - 15
280 - —
222 - 76
243 - 134
(?) 264 440

G-88

DON'T SAY IT—WRITE IT

To A. KERR

Date 6/20/61

From B GILBERT

M/725 STOCK INV. 6/20/61

30/06 – 788 } 415 required for guns
Remo

.244 – 351 } 154 for guns

.222 – 1609 – 76 required for guns

THERE IS A SAFE WAY; DO IT THAT WAY

4/25 Est for #3 #4 F'cast 1961

4/25/61

	Shipped 1960		Total orders 6/31		Est. for 1961	Shipped 6/31	when stock	Bal to Produce 6-1-12/31	Prod. in June	On order	Part 6
30/06	[illegible]		510		1000	341	72	587	115	94	398
270	[illegible]		162		400	99	268	33	176	2	15
280	[illegible]		116		250	96	161	—	7	4	—
XXX	[illegible]		226		400	212	112	76			76
244	[illegible]		79		160	72	151	—	—		—
243	[illegible]		140		350	113	89	148	7	7	134
264	[illegible]		—		480	—		440			440
Total	[illegible]		1253		3000	933	853	1284			

Production

	June	July	Aug	Sept	Oct.			Schedule	Actual	
30/06	250	100	139	154	480			587	286	301
270	16				15			31	18	13
280	5							5	12	—
XXX					76			76	82	—
244									1	—
243	5	~~[illegible]~~	50		57			148	51	97
264		~~[illegible]~~	~~160~~	~~[illegible]~~	~~[illegible]~~					
Total	276	247	189	260	~~760~~ 325			847		

make more?

Any Bbls.?

	Shipped 9/1-12/31/60	when 9/31	Bal.	
30/06	269	4	265	
270	251	140	111	140 psi.
280	105	106	—	
XXX	52	84	—	9/35 this is probably all we need
244	30	2		
243	73	38	35	
Total	780			

1994
1480
2694

3/9/61

725 Est. for #2 F'cast

	Nov	Apr	May	June	July	Aug	Sept	Oct	
30/06	5	70 403	242	69 714	50 737	52 789	98 857	52 909	Long action 829 + 250 = 1079
270	57 336	336	336	336	336	336	336	49	
280	35	30 175	175	2 199	43 250	40 260	42 305	47 349	
222	211	211	211	211	211	22 239	38 271	43 314	Short action - 417 -
243	7	130 158	158	21 179	43 222	40 264	42 304	48 352	
244	310	310	310	310	310	310	310	310	
264				150 200	100 300	50			
Total	714	320	242	~~214~~ 292	~~209~~ 309	~~154~~ 324	220	209	

G-88

DON'T SAY IT—WRITE IT

To A. Kizer

From R. Gilbert

Date 6/14/61

M/725 Trigger Guards on hand 6/14

	In Proc.	Raw stores	Total
M/725 Long, #24196 -	224	622	846

30/year part sales

	In Proc	Raw stores	Total
M/725 Short, #24195	545	1958	2503

12/year part sales

THERE IS A SAFE WAY; DO IT THAT WAY

G-88

DON'T SAY IT—WRITE IT

TO A. KERR

DATE 3/10/61

FROM B. GILBERT

ON HAND 3/10/61

	M/725	IN PROC.	RAW STORES	TOTAL	Est. Reqd
24196 24195 24195 24596	TRIG. GO, LONG –	2042	622 –	2664.	2300
	TRIG. GO, SHORT –	1572	1958 –	3530	840
19800	FLOOR PLATE, LONG –	1214	4482 –	5693	2250 · 3460
16434	FLOOR PLATE, SHORT –	239	1020 –	1259	500

THERE IS A SAFE WAY; DO IT THAT WAY

3-88

DON'T SAY IT—WRITE IT

TO _____ DATE _____

FROM _____

Bal.
725-3006-16
" 270-11

Cash
725-2463-11
" 2222-1
" 2811-12
" 3006-131

Chasem Acty
725-3006-140
" 2463-14
" 270-11
" 2801-12

Fuability Credit
725-3006-13
725-2463
Minnie Bill.-12

THERE IS A SAFE WAY; DO IT THAT WAY

6/15/61

w/425 Est. for #3 Feast 1961

	Total orders 5/31	Assign.	Stock	Future
30/06	510	387	31	128
		-41	+41	+41
		341	72	169
270	167	118	249	44
		-19	+19	+19
		99	268	63
280	116	103	154	13
		-7	+7	+7
		96	161	20
227	226	218	106	8
		-4	+6	+6
		214	112	14
244	79	75	148	0
		-3	+3	+3
		72	151	3
243	140	123	79	37
		+10	+10	+10
		113	89	47
264				

M 425.

On the basis of present plant production planning, which is in turn based on a plant est. of calendar year 2000 (2050), this model goes out of the line Dec 31st 1961 and is replaced by the M700 Ark. ~~The average estimated beyon~~.

The commitments beyond ~~to~~ the estimated requirements are:

	Finished guns -	104	244 caliber.
	Finished stocks -	1400	222 type (17000) 3 yrs. +
* 24604	Barrel assem.	200	222 —
— 24195	Trig. guard short	2700	- short action
— 19800	Floor plate, long	3400	- long action
— 16434	" " short	500	- short action

	Tax Value	Mat'l Value	Total Value
24604	428.57	336.33	764.90
24195	—	1259.82	1259.82
19800	—	673.20	673.20
16434	—	99.00	99.00

4/2/61

Est. average on 222 type stock - use 6/21/60 est and adjust.

Stock # ~~24566 - used for 222 only.~~

~~Est. Sales 1960 600~~

~~Est. Actual~~

~~Sales 1960 600 415~~

~~1475~~

Est. 222 sales for 1961 - 345
Stocks 12/22/60 1696
when stock 12/31/61 187

Est. req'd 345
when stock 187
Bal. at assem. 158

Stocks on hand 12/22/61 - 1696
Req'd 158
1538 Est. usage - 1400

1237
4
4948
1237
17318

~~Trigger guards - long action - Guns - 1079~~
~~Service~~

	Guns.	Service
Trigger guard long action # 24196	1100	20/yr. x 10 = 200
" " " " assem. 24595	—	100 x 10 = 1000
		1200
		1100
		1300
Trigger guard short action # 24195	420	12/yr. x 10 = 120
" " ass. 24596	—	30 x/yr x 10 300
		420
		420
		840
Floor plate, long 19800	1100	15/yr = 150
" " in guard assem.		100/yr = 1000
"		1150
		1100
		2250
Floorplate, short # 16434	420	2/yr. 50
in guard assem.		300
		350
		420
		770

725 - #1 F'cast

	Total orders 11/30	Total 12/01/59					#1 1st Qtr 1961	#2 1st Qtr 1961						
30/06	1097	1689		1300	345		790	995						
270	526	553		550	16		330	425						
280	446	804		500	145		290	325						
222	489	616		450	13		240	345						
244	194	447		150	45		90	120						
243	621	-		500	145		290	395						
Total	3248	4109		[illegible]	Fiscal		2060	2605						
	3400			3450										

Sales Requirement

		Dec	Jan	Feb	Mar	Apr	May	June	July	Aug	Sept	Oct	Nov	Dec
30/06		56	60 116	[illegible] 164	[illegible] 330	[illegible]	[illegible]	[illegible]	[illegible]	131 1049	[illegible] 1127	75 1257	[illegible] 1282	37 1319
270		24	26 50	21 71	[illegible] 100	[illegible] 126	[illegible] 546	[illegible] 556	[illegible]	[illegible] 445	61 506	32 538	32 570	16 586
280		22	23 45	19 64	[illegible] 87	[illegible] 110	[illegible] 417	[illegible] 349	55 349	[illegible] 398	58 456	29 485	[illegible] 511	15 526
222		19	21 40	17 57	[illegible] 80	[illegible] 101	[illegible] 197	[illegible] 327	57 314	[illegible] 368	56 424	26 450	11 461	13 474
244		7	7 14	6 20	[illegible] 28	7 35	[illegible] 68	[illegible] 90	[illegible] 102	[illegible] 138	12 150	9 159	6 165
243		22	23 45	19 64	[illegible] 90	[illegible] 153	[illegible] 290	[illegible] 343	58 361	45 406	[illegible] 451	[illegible] 480	[illegible] 514	15
Total		150	160	150	[illegible]	[illegible]	[illegible]	584	[illegible]	[illegible]	[illegible]	[illegible]	[illegible]	[illegible]
1960			157	129	179	146	[illegible]	512	[illegible]	[illegible]	365	[illegible]	166	
1959		7	266	164	222	[illegible]	[illegible]	[illegible]	[illegible]	504	[illegible]	276	140	[illegible]

	Wholesale Sales													
30/06	303	50 353	15 358	10 363	353	353	35 388	[illegible]	[illegible]	[illegible]	[illegible]			
270	181	181	171 352	60 412	412	412	412	[illegible]	[illegible]	[illegible]	[illegible]	59	59	59
280	60	4	65 125	15 140	35 477	477	477	[illegible]	[illegible]	[illegible]	[illegible] 477	[illegible] 527	527	527
222	184	5 189	189	160 379	379	379	379	100 479	[illegible]	[illegible]	[illegible]	479	479	479
244	124	1 129	129	129	129	129	129	[illegible]	[illegible]	[illegible]	129	129	129	129
243	36	6 42	100 142	142	142	380 462	70 532	532	[illegible]	[illegible]	[illegible]	432	432	432
Total	1082	67	996	320	365	320	365	382	[illegible]	[illegible]	[illegible]	[illegible]		

[illegible] Stock

Wh. Sales - 12/1/60 - 12/31/61	522
Whse Stock 11/30/60	36
Units on hand 12/1/60	139
[illegible] on Juicer, 244 cal.	71
" Order stocks	300

O.K. after discussion with Al.

4/3/61

725 Runout info.

	Net Prod.	Prod. in Mar.	Syr. of cream		Bal.									
30/06	601	2	6		593									
270	176	70	61		45		Long active stocks including 264 -							
280	229	19	93		117									
222	123	21	14		88								Rjd -	1005
243	331	18	37		276								Quad 3/31	1087
244	—	—			—									
264	250	—			250									

925 – Sales First Est 2650
Shipped Jan & Feb 236
Bal. to ship 2414
whse. stock 2/28 not including damages 955
1459
Guns assembled (Mar. prod.) 214
Bal. to produce 1245
~~Bal. to assemble 4-10/31-136 days - 9.25~~ use 9

Add 250 esh. for 264 -

1245
250
1495 = 11
136

Inv. 3/7/61

		3/7/61	Assem	Start
721-722	30/06	176	83	
	270	213	140	
	280	6	–	
	300 Mag	44	–	
	308	4	0	
	243	1	0	
	222	8	0	
	222 Mag		0	
Total				
				Brack.
725	30/06	23	0	2
	270	77	0	50
	280	7	0	18
	222	52	42	20
	243	12	0	17
	244		0	
	264		0	
Total				

70

3/6/61

725 - Est for #2 F'cast

Sale & F'cast.

	Jan	Feb	Mar	Apr	May	June	July	Aug	Sept	Oct	Nov	Dec		Total
30/06	34	41	52	49	202	454	18	104	[illegible]	57	50	17		0
270	15	17	22	21	86	65	48	44	48	24	20	8		
280	13	8	20	19	78	60	43	40	47	22	19	6		
222	30	43	18	17	70	53	39	36	38	20	17	6		
243	13	13	22	19	78	60	43	40	42	22	19	7		
244	8	6	6	5	24	18	13	12	13	7	6	2		
264														
Total	113	123	140	130	538	410	298	306	[illegible]	152	132	48		[illegible]
1960	157	129	174	162	673	512	392	345	[illegible]	190	166	59		3304

Sales & F'cast

	Mar	Apr	May	June	July	Aug	Sept	Oct	Nov	Dec
30/06	52	49 107	202 [illegible]	454 467	512 589	104 673	[illegible] 345	157 840	50 890	17 907
270	22	21 43	86 129	65 194	48 242	44 286	46 332	44 376	22 398	7 385
280	20	19 39	78 117	60 177	43 220	40 260	47 305	22 327	19 346	6 349
222	18	17	70 105	53 158	39 197	36 233	38 271	20 291	17 308	6 314
243	22	19 41	78 119	60 179	43 222	40 262	42 304	22 326	19 345	7 352
244	6	5 11	24 35	18 53	13 66	12 78	[illegible] 91	7 98	6 104	2 106
264					150	100				
Total	140	130	538	410	[illegible]	[illegible]	[illegible]	[illegible]	[illegible]	[illegible]

Production Pl[illegible]

	Mar Stock											
30/06	208	25 233	40 273	68 441	471	109 580	[illegible]	[illegible]	[illegible]	[illegible]	[illegible]	[illegible]
270	209	127 336	336	336	336	336	336	336	336	336	336	336
280	120	25 145	30 175	174 349	349	349	349	349	349	349	349	349
222	191	20 211	211	211	211	211	27 238	27 265	211	211	211	211
243	21	17 38	120 158	158	158	98 256	256	256	256	256	256	256
244	210 (100)	210										
264					150	150	50					
Total	958	214	2500	[illegible]	[illegible]	[illegible]	[illegible]	[illegible]	[illegible]			

Turn

4/3/61

M/725 - To be replaced by 700 ADL -

	Plant Est. Mf Sales
30/06	982
270	412
280	370
222	367
243	378
244	
264	250
	2450

Stock # 24515 - used for 30/06, 270, 308 (heavy action)

Est. Sales - 1960 - 3100

Shipped thru 5/31/60 - 918

INV. 12/22 — Total Stock 5/31/60 - 1598

RAW STOCK - 1440 — Bal. req'd to ship product - 891

Rej. - 25 — Stock on hand 5/31 - 1870

Discard - 25 — Excess stock - 979

1490

Stock # 24516 - used for .308 only (short action - heavy bbl.)

Est. Sales 1960 - 400

Shipped thru 5/31/60 - 270

INV. 12/22 — Total Stock 5/31/60 - 299

Raw Stock - 1676 — Bal. req'd to produce - 31

Discard - 20 — Stock on hand - 1569

1696 — Excess Stock - 1538

2500 Stocks @ 12.37 each = $30,925

G-88

DON'T SAY IT—WRITE IT

TO W.B. Burns

DATE 12/12/60

FROM GWK

M/725 stock #24567 (used for .243 & .244 cal.)
Please order 300 for use in April.

THERE IS A SAFE WAY; DO IT THAT WAY

3-88

DON'T SAY IT—WRITE IT

To _____ Date _____

From _____

Wood Job. 725 ADL 3066 - 36

Assembly 725 ADL 243 - 6

" " " " " 3066 - 14

" " " " " 244 - 1

Quality Audit..... 222 - 5

THERE IS A SAFE WAY; DO IT THAT WAY

13

Check 745 stock
for 444, 443

Disp Appr - 14
Stores 125
139 12/1

M/720 .243 STOCKS

2 ON ASSEM.
30 IN DISPATCH AREA
125 IN RAW STORES

B 10/17

B

Stop 725 when
black frames time
turn produces to when,

10/12
start up again.

725 - check distribution

	Shipped 1959	Orders 7/31/59	Est. for 1960	Orders 7/31/60		Shipped 9/31/60	7/31/60 Whse Stock	Bal. to Produce	
30/06	[redacted]	[redacted]	1200	784	33.7	710	691	201	
270	[redacted]	[redacted]	415	270	11.6	251	349	185	
280	[redacted]	[redacted]	550	306	13.1	291	197	62	7
222	[redacted]	[redacted]	505	340	14.6	335	270	105	
244	[redacted]	[redacted]	216	139	6.0	128	196	108	
243	[redacted]	[redacted]	725	489	21.0	464	50	206	79.22
Total	[redacted]	[redacted]	3650	2328		2179			
	[redacted]	[redacted]	3646						

10/15/60

9-5 #1 Flock 1960

					Nov	Dec	Jan	Feb	Mar	Apr	May	June	July	Aug	Sept
		30/06	[redacted]	[redacted] 100	40 140	38 178	36 374	46 430	70 490	70 560	244 806	96 902	144 1052	123 1176	141 1317
		270	[redacted]	[redacted] 30	24 54	10 64	24 148	19 167	30 197	30 227	105 332	45 377	60 437	52 489	60 549
		280	[redacted]	[redacted] 30	28 58	10 68	23 149	19 168	29 197	29 226	102 328	43 371	58 429	51 480	58 538
		222	[redacted]	[redacted] 20	15 40	15 40	22 137	18 155	28 183	28 211	97 308	42 350	55 405	48 453	55 508
		244													
		243	[redacted]	[redacted] 20	24 74	20 94	35 216	28 244	43 287	43 330	150 480	64 544	86 630	76 706	86 792
		Total	[redacted]	[redacted]	180	50	160	130	200	200	700	300	400	350	400
Blk. Hum			[redacted]												
			2812												
87	10	30/06	376	10 478		478	478		396 874	874	156 1030 874	256 1130	1280	1280	1280
224	90	270	211	90 301		301				1232	328	328	328	328	328
64		280	99	99		99	1	360 459	459	459	459	459	459		
401	40	222	189	48 239		239			1	1363	363	1462 512	511	511	511
		244	235	235											
82	43	243	42	43 85	85	85	374 443	443	443	443	240 703	703	703	703	703
		Total	1154	—	—	—	378	360	396	340	396	396	347	252	360

guns on ranch.

Note: for 243 production see stock or 243 in wheel.

	Shipped	Total		Shipped	Est.		Rec	
	9/30/60	Orders		1959	Total		40	
		950			1960		Ship	1960
30/06	952	944	352	1689	3	1130	178	
270	406	447	150	553		450	44	
280	397	397	145	544			48	
222	380	380	136	616			60	
244	163	104		447				
243	591	591	215				104	
Total	2889	2908		4109				
		2744						

1962 ?

cc: C. W. Roney
T. F. Parker
G. A. Schneider (Attch.)
R. Gilbert

May 25, 1960

Abercrombie & Fitch Company
Madison Avenue at 45th Street
New York 17, New York

Attn: Mr. Nichols

Gentlemen:

Thank you for your order of May 20 No. 35980. You have requested that we ship direct to your stock

1 only Remington Model 725F "Premier" Grade Bolt Action Repeating Rifle 243 Winchester Caliber 22" Barrel fitted with Lyman 16A Middle Sight with base like Mannlicher-Schoenauer Rifle with quick detachable swivels, No Sling Strap, Length of Stock including Pachmayr Recoil Pad 13-1/2". Select best piece of wood possible. Supply extra Pachmayr Recoil Pad, not attached but shipped.

Upon checking with our production people we have been advised that there will be a delay of approximately three months in the shipment of this order. Also note that this request will not be subject to cancellation and will be subject to any price change which might occur.

If these conditions do not meet with your acceptance and that of your customer please let us know at once.

Yours very truly,

Firearms Marketing

JHFenton/vv

RAY GILBERT:

Have assumed that the special middle sight and base can be supplied. If however, you find this is not correct please let me know. Thank you.

Jack Dunton

6/21/60

725 Sporter Stock

Stock # 24515 - used for 30/06, 270, 280 (long action)

Est. Sales - 1960 -	3100	
Shipped thru 5/31/60 -	918	
Whse. Stock 5/31/60 -	1291	
Bal. req'd to ~~stop~~ produce -		891
Stocks on hand 5/31		1870
Excess stocks		979

Stock # 24566 - used for .222 only (short action - heavy bbl.)

Est. Sales 1960 -	600	
Shipped thru 5/31/60	270	
Whse stock 5/31/60	299	
Bal. to produce	31	
Stocks on hand	1569	
Excess stocks	~~27~~	1538

2500 stocks @ 12.37 each = $30,925

725 sporter stock 4/19/60

Stock #24565 - used for 30/06, 270, 280 (long action)
3/31 1870

Est. Sales 4/1 - 12/31 -	2785
Inter. stock 3/31	1643
Bal. req'd	1142
Stocks on hand	2230
Excess -	1088 x

Last delivery July '59

Stock #24566 - used for .222 only (short action heavy bbl.)
1569

Est. Sales 4/1 - 12/31 -	557
Inter. stock 3/31	218
Bal. req'd	339
Stocks on hand	1839
Excess	1500 x

Last delivery June '59

6/15/60

725 - [illegible] Cabinet #3

	Schedule Mar. Apr. May	Actual	[illegible]	[illegible]	Totals 1959	Rec. for 1960	Shipped	Unsh. Stock 5/31	Bal. to Produce		Rec. to Ship		Bbls.	Total Orders 4/30/60	
30/06	50	8	58		689	1700	513	833	354		1187		—	784	
270	110	117	7		553	600	202	186	212		398		440	[illegible]	
280	185	320	138		504	800	203	274	325		597			[illegible]	
222	—	243	243		410	600	270	299	31		330		440	[illegible]	
244	240	64	176		447	400	107	83	210		[illegible]		189	1396	222
243	300	—	300		[illegible]	800	—	—	800		[illegible]		450	[illegible]	
Total					[illegible]	4900	[illegible]		1932					[illegible]	3708
	Month When	June	July	Aug	[illegible]	[illegible]	[illegible]	[illegible]	[illegible]	[illegible]	May	Apr.	May	June	
30/06	200	159	200	245	181	[illegible]	[illegible]	31	[illegible]	[illegible]	51	53	[illegible]	189	
270	50	109 159	65	[illegible]	[illegible]	[illegible]	16	12	15	[illegible]	22	[illegible]	136	109	
280	50	67	64 181	126	[illegible]	62	[illegible]	[illegible]	40	[illegible]	31	31	90	67	
222	50	33 83	52 135	40 175	39	[illegible]	[illegible]	[illegible]	[illegible]	[illegible]	49	60	91	83	
244	50	30 80	50 130	30 160	[illegible]	16	16	16	15	[illegible]	28	15	40	30	
243	100	300	100	100	[illegible]	100	50	50	[illegible]	30	50	[illegible]	[illegible]	[illegible]	
Total	500	698	534	606	[illegible]	376	180	[illegible]	[illegible]	180	224	227	769	498	
									39	180	204	204	104	184	
	When Ship														
30/06	833	833	833	833	130	500	[illegible]	[illegible]	[illegible]	[illegible]	[illegible]	[illegible]	[illegible]	[illegible]	
270	186	50 536	138	[illegible]	[illegible]	[illegible]	[illegible]	[illegible]	[illegible]	[illegible]	576	576	576	576	
280	272		60 337	337	[illegible]	337	337	337	[illegible]	[illegible]	[illegible]	337	337	337	
222	299	299	299	299	299	299	299	299	[illegible]	[illegible]	[illegible]	619	619	619	
244	89	50 133	100 233	233	[illegible]	233	233	[illegible]	[illegible]	[illegible]	[illegible]	233	233	140 233	
243	—	340	110 450	[illegible]	[illegible]	800	[illegible]	[illegible]	[illegible]	[illegible]	[illegible]	[illegible]	[illegible]	[illegible]	
Total	1673	440	4400	260	430	360	430	[illegible]	[illegible]	[illegible]	[illegible]	400	4430	4440	

F - 3/15/60

DON'T SAY IT—WRITE IT

To W.B. Parsons

Date 1/7/60

From AHL

Please order me more 725 switches —

I'm tickling this for 3/15/60

3/15 Bunie — what is our present position?

THERE IS A SAFE WAY; DO IT THAT WAY

T - 1/5/60

G-58

DON'T SAY IT—WRITE IT

To W.B. Parson

Date 12/21/59

From G.N.K.

Please order no M/725 stock until further notice. The question of check-price is still not clear.

I'm kicking this for Jan 15th

SK

THERE IS A SAFE WAY; DO IT THAT WAY

4/11/60

Bishop does not want to
run 350 only, needs 750
for a run
must know by Thursday
4/13
Parsons, Brown, Kerr - offer
Bishop premium price to run
small quantity.

T-

3.

725 stocks on hand

3/31

#24565	30/06	2230
#24566	.222	1839
#24567	.244	820
		64
		756 880 July

S-88

DON'T SAY IT—WRITE IT

To K. B. Parsons

Date 4/1/62

From Clark.

M/725 stock # 24567 (used for 243 & 244 dal.)

350 ~~[illegible]~~ th @ 100 / mk

starting July 15th

THERE IS A SAFE WAY: DO IT THAT WAY

3/28/60

725 Cal. Distribution - Feast #2

			Min other	Mar	Apr	May	June	July	Aug	Sept	Oct	Nov	Dec	Jan	Feb	Mar
								Sales								
35.2	30/06	1689	200	53 [illegible]	[illegible] 320	281 604	196 760	211 [illegible]	211 1263	211 1143	211 1234	105 1329	70 1799	88 1887	53 1941	70 2010
11.5	270	553	70	[illegible]	110	97 205	57 259	69 328	69 397	69 466	69 535	35 570	23 593	28 621	17 638	23 661
16.7	280	804	80	[illegible]	138	134 272	83 355	100 455	100 555	100 655	100 755	50 805	33 838	41 879	25 904	33 937
12.8	222	616	70	[illegible]	114	102 216	63 279	76 355	76 431	76 507	76 583	38 621	25 646	32 678	19 697	25 722
9.3	244	447	50	14 [illegible]	82	74 156	46 202	56 258	56 314	56 370	56 426	28 454	18 472	23 495	14 509	18 527
14.6	243	700	100	22 [illegible]	163	117 270	75 345	88 433	88 521	88 609	88 697	44 741	31 772	38 810	28 838	31 863
	Total	4609	560	[illegible]	[illegible]	800	500	600	600	600	600	300	200	250	150	200
								Production								
			other stock													
	30/06		1266	50 1316	1316	1316	1316	1316	1316	1316	40 1356	420 1776	336 2112	2112	2112	
680	270		235		110 345	345	345	345	345	345	150 495	x 495	495	200 695	695	
400	280		101	125 226	226	257 57	174 457	457	457	207 664	150 814	814	814	241		
770	222		255	254	255	255	200 455	455	455						420	
~~[illegible]~~	244		89	10 99	230 329	329	329	200 529	529	529	529	529	529	529	529	46 529
	243		—			200 200	240	140 440	221 661	150 811	811	811	811	811		
	Total			235	340	357	374	340	221	357	340	420	336	441	420	467

10/9/59

725 Gal. Distribution R4 Forecast 1959

						Sales Requirements										
		Jan inches	Oct	Nov	Dec	20 Jan	20 Feb	23 Mar	20 Apr	21 May	22 June	22 July	18 Aug	21 Sept		
1454 402	30/06	240	122 262	61 423	40 463	83 546	51 597	89 686	91 777	355 1132	159 1291	200 1480	245 1725	181 1917		
491 136	270	80	40 130	20 140	14 154	32 186	15 201	34 235	33 268	74 342	109 451	68 519	65 584	61 645		
690 191	280	115	57 172	28 200	19 219	38 257	27 284	43 327	37 364	152 516	67 583	64 647	126 773	136 909		
555 154	222	92	46 138	23 161	15 176	47 223	71 294	56 350	42 392	109 498	33 531	52 583	40 623	39 662		
421 117	244	70	35 105	18 123	12 135	47 182	71 253	56 309	42 351	100 451	38 481	64 545	30 575	34 609		
	243								300	200	200	200	100			
3611	Total	600	300	150	100	200	164	222	530	1000	660	650	600	500		
						Production Schedule										
		when stock														
	30/06	390	519 670 220	189 1010 400	1350 340	1350	1350	[illegible]	[illegible]	1350	1350	380	260	420		
	270	325	325	325	325	325	325	325	325	300 625	625	625	625	[illegible]		
	280	235	235	235	235	400 635	635	635	635	120 755	755	755	[illegible]	[illegible]		
	222	366	366	366	366	366	366	310 676	676	676	[illegible]	[illegible]	676	676		
	244	140	140	140	140	140	400 540	540	540	540	[illegible]	[illegible]				
	243							150	400		440	60				
	Total	1456	220	400	340	400	400	460	400	420	440	440	260	420		
						#1 Forecast 1960										
		when	Nov	Jan	Feb	Mar	Apr	May	June	July	Aug	Sept	Oct	Nov	Dec.	
1661 402	30/06	240	41 281	82 363	82 445	82 527	82 609	328 937	205 1142	246 1388	246 1634	246 1880	246 2126	123 2249	82 2331	
543 132	270	80	13 93	26 119	26 145	26 171	26 197	104 301	65 366	78 444	78 522	78 600	78 678	39 717	26 743	
790 192	280	115	20 135	40 175	40 215	40 255	40 295	160 455	100 555	120 675	120 795	120 915	120 1035	60 1095	40 1135	
402 150	222	92	15 107	30 137	30 167	30 197	30 227	120 347	75 422	90 512	90 602	90 692	90 782	45 827	30 857	
437 106	244	70	11 81	22 103	22 125	22 147	22 169	88 257	55 312	66 378	66 444	66 510	66 576	33 609	22 631	
	243															
4033	Total	600	100	200	200	200	200	800	500	600	600	600	600	300	200	
		when stock				Production										
	30/06	598	200	400 1198	1198	1198	1198	1198	110 1308	400 1708	260 1968	420 2388	400 2788	420		
680	270	266			266	266	532 596	150 746	746	746	746	746	746	746	746	
400	280	148			400 548	548	548	300 848	300 1148	1148	1148	1148	1148	1148	1148	
7.6	222	322			322	460 782	70 852	852	852	852	852	852	852	852	852	
83	244	131			131	?									320	
	243															
	Total	1465	200	400	400	460	400	420	440	400	260	120	400	420	320	

4/15

735 est. Distribution #3 Flat 1989

old Jan.-May	Total Orders 5/31	Future Mo.			Stk whse	June	July	Aug	Sept	Oct	Nov	Dec	Jan	Feb	Mar	Apr	May
									Sales.								
1083	42.5 42	414 22.4	55	30/06	330	332 567	365 947	336 274	330 607	275 682	137 2019	82 2101	109 2210	84 2294	105 2391	105 2504	468 6912
305	11.9 12	117 15.5	14	270	96	104 160	112 272	96 368	96 464	80 544	40 584	24 608	31 634	24 663	30 693	30 723	137 860
400	15.6 15	103 13.7	14	280	74	56 130	98 228	74 302	74 376	70 446	35 481	21 502	39 541	30 571	38 604	38 647	119 766
445	17.3 18	54 7.2	7	222	42	28 70	49 119	42 161	42 203	35 238	18 256	11 267	47 314	36 350	45 395	45 440	60 [illegible]
325	12.7 13	66 8.6	8	444	48	120 168	56 224	41 272	41 320	40 360	20 380	12 342	24 426	26 452	32 484	32 516	66 582
2558		754		Total	600	500	700	600	600	500	250	150	200	200	250	250	850
									Production								
					whse stock												
1875 610		27		30/06	567	100	50	275 992	525 1517	525 2042	400 2442	2442	2442		460	400	420
		800		270	493		100	593	593	593	593	593	593	400			
		450		280	331		200	531	531	531	531	531	400 931				
		950		222	396	120		516	516	516	516	516	516				
	31	450		444	6	200	200	406	406	406	41	340 746	746				
		~~[illegible]~~		Total	1792	400	550	275	525	526	400	340	400	400	460	400	420

Mar. 6

425 #2 Fiast 1959

Sales Requirement

Ilac				Stk where	Mar 21	Apr 22	May 20	June 22	July 22	Aug 21	Sept 17	Oct 25	Nov 20	Dec 17	Jan 20	Feb 20	Mar 23		
46.6	36.2	41	30/02	205	156 361	155 515	205 717	267 984	308 1292	226 1518	268 1786	164 1950	82 2032	62 2094	209 2303	82 2385	123 2504		
14.5	11.8	14	270	70	53 123	53 176	70 246	91 337	105 442	77 519	91 610	56 666	28 694	21 715	70 785	28 813	42 855		
14.5	11.8	14	280	70	53 123	53 176	70 246	92 337	105 442	77 519	91 610	56 666	28 694	21 715	70 785	28 813	42 855		
21.6	34.2	31	222	105	82 187	82 265	105 370	135 505	157 662	115 662	135 797	84 881	42 923	31 954	105 1059	42 1101	63 1164		
7.2	6.0	10	244	50	38 88	38 126	50 176	65 241	75 316	55 371	65 436	40 476	20 496	15 511	50 561	20 581	30 611		
Spiceodus Total 3/31/59				500	380	375	500	650	750	550	650	400	200	150	500	200	300	Total Dealer 4/24	
			2/28	Wher ehtk					Production										
46.4	37.6		30106	500		315 815	500 1315		1315	275 1590	425 2015	625 2640					275	819	40.3
13.0	10.5		270	523			523	200 723	723	723	723	723	500 1223	723		200	300	248	12.1
17.7	14.3		280	361	210 571		571	200 771	771	771	771	771	771	771	200	300		311	15.2
27.5	22.2		222	397	150 547		547		400 947	947	947	947	947	425 1372				386	18.8
19.0	15.4		244		165	135 300	300	150 450	150 600	600	600	600	600	600	300			279	13.6
123.6		Total		1781	525	550	500	550	550	275	425	625	500	425	500	500	575	2043	

1/9/54

Forecast #1 1959 - w/ 725

		Total Cutting 11/30/54													
	30/06	1775	19.2	19											
	270	1200	20.9	21											
	280	1259	19.9	20											
	Total	6364													

Sales Requirement

			Jan	Feb	Mar	Apr.	May	June	July	Aug	Sept	Oct	Nov	Dec.
	30/06	360	147 507	177 684	206 890	236 1126	295 1421	354 1775	560 2335	472 2807	560 3367	364 3731		
	270	120	57 177	63 235	74 309	84 393	105 498	126 624	200 824	168 992	200 1192	126 1318		
	280	120	50 170	60 230	70 300	80 380	100 480	120 600	190 790	160 950	190 1140	120 1260		
	222	350	251 501	300 801	350 1151	400 1551	500 2051							
	244	150						x 600 600	500 1100	200	300	200		
	Total	1000	500	600	700	800	1000	1200	1450	1000	1250	800	400	300

Jan + Feb Prod

Forecast	Actual																
			Wheel Stock	Wheel Stock													
	77	30/06	619	611	611	611	244 955	500 1455	1455	600 2055	130	715	605	750			
	68	270	493	510	510	510	510	510	500 1010	1010	1010	1010	500 1510	1510			
470	353	280	84	73	73	470 543	90 633	633	633	633	700 1333	1333	1333	1333			
730	581	222	—		630	100 730	234 964	600 1564	500 2064	2064	2064	2064	2064	2064			
*	0	244								500 500	600 1100	1100	1100	1100			
1200	1016	Total	1201		1130	570	630	1100	1000	1100	1430	715	1105	750	600	510	

Production Schedule

Add 200 222 from Dec.

9/18

'525 "4 4' east

	Take Order 9/13													
30/06	3318	59.0												
270	1213	21.6												
280	1085	19.4												
Total	5616													
	Mfg Wkal	Sept	Oct	Nov	Dec	Sales Requirements Jan	Feb	Mar	Apr	May	June	July	Aug	Sept
30/06	530	530 1060	412 1472	236 1708	231 1944	147 2121	116 2237	295 2531	295 2826	325 3151	383 3534			
270	194	194 388	151 539	86 625	86 711	65 776	43 819	108 927	108 1035	118 1153	140 1293			
280	176	176 352	136 488	78 566	78 644	58 702	39 741	97 838	97 935	107 1042	127 1169			
222						500	300 800	200 1000	200 1200	200 1400	100 1500	100 1600	100 1700	100 1800
244							300	200 500	100 600	50 650	50 700	200 900	100 1000	100 1100
Total	900	900	700	400	400	800	800	900	900	800	800	1100	1000	1100
	Mfgr Stock					Production Schedule								
30/06	534	510 1044	900 1944	1944	1944	748 2692	452 3144							
270	117	400	517	500	817		365 1182	135						
280	44	170	600 814		817									
222				355	645 1000									
244					345	155								
Total	695	1080	1500	855	990	903	817	903	946	645	946	946	473	

#3 F'cast · M/725

	Total Order 6/30		Future Order 6/30			Use							
30/06	~~[illegible]~~	615	598	594		61							
270	972	210	247	246		22							
280	813	175	162	160		17							
Total	4636		1007										
	Min when	July	Aug	Sept	Oct	Sales Fcst	Requirements left	Jan	Feb	Mar	Apr	May	June
30/06	366	305 941	305 926	367 1343	367 1710	244 1954	244 2198						
270	132	110 242	110 352	132 484	132 616	88 704	88 792						
280	102	85 187	85 272	102 374	102 476	68 544	68 612						
~~222~~													
244													
Total	600	~~[illegible]~~ 500	~~[illegible]~~ 500	601	601	400	400	830	1000	1000	1000	1000	950
6/30	Min Stock					Production Schedule							
30/06	479	700 1179	1179	185 1364	764 2128	2128	2128	355	665	486			
270	31	65	270	480 846	846	846	846			255			
280	360				136	496	130	380					
~~222~~						630	370						
244							500						
Total	870	765	270	585	900	630	990	735	665	735	770	555	770

700

x

40

12

812
162
[illegible]

5/6/58

7/25 Remington #3 F'cast.

	Total Order		Total F'cast	Unsigned	Bal to Ship	Wheat Stock	Bal to Prod.		5/29 Total		Future		Unc
30/06	2340	65.5	4900	1790	3120	6	3114		2659	63.[illegible]	691	62.8	63.
270	695	19.4	1450	434	1016	40	976		843	20.3	276	25.1	22.
280	546	15.2	1140	—	1140	265	875		665	16.	133	12.1	15.
Total	3581		7500	2224	5276	311	4965		4167		1100		

Not accumulated	Min. wheat		Sales		
		June	July	Aug	Sept
30/06	756	504	378 882	378 1260	346 1606
270	264	176	132 308	132 440	121 561
280	180	120	90 210	90 300	83 383
Total	1200	800	600	600	550

5/29	Wheat Stock		Production		
30/06	—	866	534 1400	134 1534	828 2362
270	104	100 204	478 682	272 954	9
280	357			100 457	
Total		966	1012	506	838

30/06 - 1400
270 - 650

3/7/58

M/725 ave. Distribution · F'cast #2

	Orders on hand		Total orders Rec'd 2/28/58		Low water	Mar	Apr.	May	June	July	Aug	Sept	Oct	Nov	Dec	Jan	Feb
									Sales Requirements.								
58	1055	30/06	1782	70		406	464 870	464 934	455 1389	490 2279	384 2663	490 3153	384 3537	384 3921	350 4271		
24	449	270	[illegible]	17.5	X	168	192 360	192 552	114 666	123 789	99 888	123 1009	97 1106	99 1203	87 1290		
18	328	280	[illegible]	12.5		126	144 270	144 414	81 495	87 582	69 651	87 738	69 807	69 876	63 939		
	1830	Total	2559		1040	700	800	800	650	700	550	700	550	550	500	800	800
					When Stock				Production Schedule								
		30/06			3	525 528	475 1414	1414	800 2214	880 3094	320 3414	340 3754	1000 4754	100 4854			
		270			172	75	135 372	460 832	40 872	872	1 992	580 1572	1572	1572	1572		
		280					600 600	500 1100	1100	1100	1100	1100	1100	1100	1100		
		222												440	240		
		244													640		
		Total			175	600	1200	960	840	880	440	720	1000	760	880	840	760

30/06 - 1200 (?) Repairs
270 · 240
280 - 1240
270 · 500
30/06 · 2000
270 - 700
30/06 - 1250
222 - 1000

12/2/57

(4(9) yy)

M/725 - #1 Forecast 1958

Open. Inventory commitment:

3406 Jan														
270 Feb														
280 May														
	Use		Jan	Feb	Mar	Apr	May	June	July	Aug	Sept	Oct	Nov	Dec
3406	340		600 +1140	1140 1300	300 2500		270	630	660	330				
270			600		600 1200						540			
280					360	480	360 1200					625		
244													475	
232														550
Total	340		1320	1140	1260	480	630	630	660	330	540	625	475	550
3406			900	720	680									
270			300	300										
280					400									
244														
232														
			1200	1020	1080									

VII/771 - Finished 1st Assemblies 11/2/19

30/66	600
270	690
2[illegible]	100
222	770
250	50

- 725 BM. 9/30

270, 700
244, 48
222, 750
280, 54

3/9/60

725-725 - Cartns. for 243 & 244

2/74	Sold in '59	to date 60	wholesale	Cart.	Total	Bal. 4/4
725-244	447	37	89	100	226	221
725- "	705	100	91	-	191	514

725 - 244 - 150
725 - 244 - 400 - 200

725 - 243 - 300
725 - 243 - 600 *
~~1500~~ 1450

1200

725 1000 *
1000 700 *

7-88

DON'T SAY IT—WRITE IT

TO Mr. Neilsen

FROM AMC

DATE 2/9/60

244 cal.

	Wheel stock	Bal.
722 -	11	—
725	89	10

THERE IS A SAFE WAY: DO IT THAT WAY

9/10/69 1x

12,00

425 - Sporter Stock

Total		Est Sales Rest of yr.	Assigned 8/31	Where Stock 8/31		Sal. to Produce		Excess Prime		Excess Stock		Vendors	Dept	1/7/70 Acc	check Acc	
1305 404	30/06	2020	1273	380		367			3764	3397			315	231	191	737
443 11.1	270	685	430	381				126								
575 11.1	280	890	554	252		184										
518 16.0	222	800	516	398				114	1749	1635			6	1	2	
391 12.1	244	605	387	129		89			250 716	877			45	4	2	
3232	Total	5000	3160	1540		640				5909	= 70,907					

Cash #1	10,000
2	10,000
3	10,000
4	6500

725 Comparison of Sales Fcast & actual

	Shipments				Production										
	Fcast	Actual	Diff		Fcast	Actual	Diff	2mo. actual	2mo Fcast	when Fcast Est	Stocks 1/30 Act.				
20/06	147	83				11+1	+11	12		464	540				
270	52	32				3+57	+3	60		458	487				
280	50	38				1+352	-1	353	470	13	36				
222	251	113			630	507+74	[illegible]	581	730	379	394				
344						0									
Total	500	266			630	522				1324	1452	+130			

OK

B. Any Problem? Would like report 200 / 300 tal.

PARK FOREST WORKS

January 9, 1958

cc: J. B. Maupin
D. E. Miller (Elion)
W. H. Parsons (Elion)
W. T. Smith (Elion)
W. H. Sanders
F. R. Kaifert

TO: F. R. CROOP
(Elion)

SUBJECT: M/725 Long Action Trigger Guard #24195

The subject casting die was removed from production due to difficulties encountered in casting the balance of the present open order.

1. The .592 maximum (per deviation notice) cannot be held consistently. The scrap rate is approximately 50% even with extreme care in blowing off flash from the parting line faces.

   a. To maintain the .592 maximum dimension, it is planned to recut the cavity halves (at a cost of approximately $350). It is not planned to recut the bow cavity since there is a possibility in working in the hardened die of developing an undercut which would only cause future problems. It is intended to maintain size where the piece fits the wood (in fact the die will be made to minimum), but the bow would be smaller, a minimum of .600, which it is felt would not affect visual appearance. Consequently, could the print be revised to show a note in Section AA indicating the acceptability of a .600 minimum?

   b. We have not as yet received a print changing the .627-.622 to give .010 total tolerance (similar to the other dimensions 1.030 and .975) as discussed with you. We are also at a loss, since reading the memo of December 18, 1958 sent with the deviation notice, to know what basic dimension is desired now that we must recut the die. Please advise.

2. When we change the die, we intend to correct the .190 dimension width of the fork slot. It is now running .195-.196 including draft. We will grind a little off the core in this case.

3. The .178-.174 dimension width of the slot in magazine opening is running .182 at highest point. We intend to correct this dimension.

We do not have any acceptable castings to send you at this time. Please let us have your comments on these changes; also, forward changed prints (Item 1 b) as soon as possible, so we can proceed on the die alteration. It is estimated that it will require six weeks to be able to get back into production with approved castings.

J. B. Maupin, Manager
Park Forest Works

E. W. Hedren, Superintendent
Product Engineering & Control

cc: Heinz

G-88

DON'T SAY IT—WRITE IT

To _____ Date _____

From _____

THERE IS A SAFE WAY; DO IT THAT WAY

Jones Trs. Rhein plan.

30/66	290	257
85	100	100
	99	
	110	
	88	
	99	
	99	
	95	
	97	
	96	
	87	
	99	
	1057	

(Tx?)

How many long action slide
actuator frame?

2467 stores
79 on assem.
80 dispatching
3 Wrod job
2529 TOTAL 8/22
473 Recd 8/22 – 9/12
3002 Total

E. C. BISHOP & SON, INC.

WARSAW, MISSOURI
BOX 141A R. R. #2
GUNSTOCKS

August 12, 1958

Remington Arms Company
Ilion
New York

1- Art Kerr - Is this O.K. - what about more long action version?

2- Attention: Mr. W. B. Parsons, Chief Buyer

Dear Mr. Parsons:

This is to advise that the last stock we are making to apply on your Order No. I-19954, for the long action version of the M/725 rifle, has been inletted and shaped in our finishing department and the completed order will be shipped sometime the middle of next week. From the figures that I have been given, it will be slightly in excess of 9,000 stocks that we have made on this order, with probably less than 100 in excess. If it is not agreeable to ship these excess stocks to you, please let us know. OK

We are now starting the short action version of the M/725 stock through the production line in the finishing department and the completed stocks will start moving to you sometime the middle of next week. It is our intention, if it is agreeable with you, to make about 40 of these short action version stocks a day, which would mean about 200 stocks shipped to you a week. This production schedule would let us complete the order of 2,000 sometime the first part of October. This schedule can be increased or decreased some 100 stocks a week should it be necessary.

Yours very truly
E. C. BISHOP & SON, INC.

John H. Pohl
JHP-ec

RECEIVED
AUG 14 1958
PURCHASING DEPT.

3/13/56

My 725 cal. distribution by months

Use current orders rather than assignment

1958

	Jan	Feb	Mar	Apr	May	June	July	Aug	Sept	Oct	Nov	Dec	Total
30/06	898	1436	1717										
270	118	238	354										
280	112	217	369										
Total	1128	1891	2440										
*1 F'cast	800	1500	2300	3000	3700	4300	4900	5400	6000	6500	7000	7500	
2			1363	2163	2963	3763	4313 287	4863 377	5563 681	6113 801	6663 400	7163 400	
3 Remand													
4													

To Art Kerr Shop Plant

From Jack Fenton

This is for
Mr. Warden
please select +
test
thanks
JF

1/21/58

Please enter -

Charged on Consignment and ship to
Dewey Godfrey
Gun Arms Co Inc
Byt. Conn

1- 725 "F" 280 Cal
fitted with Gold name Plate on
stock with initials "N.R.W"

Type on order - refer to Art Kerr
for selection + testing

per D Godfrey's instructions 1/20/58
J Genton

1/24/58 Advised Parsons re. stocks
1/28 - Stocks received to be in Gun work.
4/8 - Gun arrived - weight 6½ about 3 days.
4/11 - Art checked - everything was done

31/1/57

725 30/06 - 1200 (?)
270 - 200
760 - 1200

400 Demo.
500
300

463

720
730
31

463

MODEL 725

Problems of the adequacy of the Rear Sight Assembly and sight alignment have been the major factors in producing warehouse guns.

The Rear Sight Leaf has been improved by adding a web between the ears and strengthening fillets. In addition, current production has a reverse die break which has greatly reduced cracking at the ear bend junction. Replacing the bent up ears by a roll construction should if manufacturing requirements can be held, further strengthen the sight. Samples of the roll design are expected the middle of March.

Radial alignment of the Receiver scope holes, Rear Sight Base, and Front Sight Base which existed with the old sight set up but were not visually objectionable, now are with the new sight line with the Rear Sight Base and higher Front Sight Ramp. In order to produce warehouse guns, selected Barrel Assemblies are required. A major program is under way to produce assemblies that will meet specifications. Contributing component processes are being studied which includes the effect of angular displacement in the first inch of the muzzle. These are not new items but the solution is most important to the production of a quality product.

A new Bolt Stop Pin to reduce the side play and looseness of the Safety has been made effective. The action of the Safety has been measurably

improved since initial production. The action of the Safety is still the basic M/721-722 but the added lever and gear action has reduced the force to actuate the Safety. The first initial movement of Safety raises the Safety Cam and locks back the Firing Pin. The force required to provide the initial locking is to the uninitiated sufficient to move the Safe to the full on position. This is considered advisable. The operator then is able to return the Safe to the center position if desired.

As an added improvement, the closer tolerences for the Bolt Stop Pin provided a better fit of the Fire Control Housing in the Receiver with a resultant better Trigger pull. An interference between the Housing and the Trigger Guard has been corrected. This caused a binding of the Bolt Stop Pin and affected functioning. Further means of improving the Fire Control are being studied.

Difficulties of color, checkering, and dimensions of initial Stock production have been greatly improved in current production. The vendor is being promptly advised of any problems. Additional gages to enable the vendor to better control dimensions are being provided.

The crowning of the Barrel has been questioned. While this is the same as used on all center fire Barrels, it is believed that by changing the operation the feather edge can be eliminated.

A record is being kept of Sales and customer reaction to this new gun. Action is and will be taken on any condition which adversely affects the acceptance of this gun.

An initial quantity of 270 caliber guns has been assembled. Ten (10) guns have been selected by Research for pilot testing.

The warehouse schedule is revised as follows:

	January 7, 1958 Schedule			March 4, 1958 Schedule		
	30-06	270	280	30-06	270	280
December 1957	*6	0	0	*6	0	0
January 1958	900	300	0	*333	0	0
February 1958	720	300	0	*400	0	0
March 1958	680	0	400	500	400	200
April 1958				500	200	500

* Actual

VGD:EK

G-88

DON'T SAY IT—WRITE IT

To [illegible] Date [illegible]

From [illegible]

We are [illegible] 50 of our [illegible] Don't think
thanks is supposing so what they can the paint
to Bishop — Please have those [illegible]
with me finish.

(725)

THERE IS A SAFE WAY; DO IT THAT WAY