700-24 292178 Lafety Detent Spring

PROCESS RECORD DATA BASE/ENGIN	0.0	OCESS CHANGE NO.	292178
CHANGE NOTICE A	· -	ENG. CHANGE NO.	
TO BE RETURNED	D BY	INITIATED DATE	
ROUTE TO	NAME	APPROVAL	DATE
	<i>I</i>	011	
PE&C SUPERVISOR	Cla Jackson	Kulach	9-25-91
PRODUCTION SUP'R			
PROD. FOREMAN			
	,		
ACCOUNTING *			-
PLANNING	· .		
PURCHASING	· · · · · · · · · · · · · · · · · · ·	·	
PART NUMBER	368	ECR NO.	• • •
DCR(IF ANY) DESCRIPTION OF CH		SI REDUCTION/INC	CREASE
Red m-24	<u> </u>	1	'ou-
			
			·
			•
	LASSIFICATION OF C	HANGE	
EFFECTIVITY DATE .) PHASE OUT () R	EGULAR
			· · · · · · · · · · · · · · · · · · ·

RD-6491-1

PROCESS RECUID-INSPECTION

GAUGES				IITS
TYPE	NUMBER	USE		MIN.
Visual		Inspect for defects		
Plug Gage	B-80002-V	Check hole dia.	.128	.126
Width Gage	A-50125	Check inside ears	.310	.300
Comp.Fixture		Check Contour		<u> </u>
Comp.Screen	B-700A-CL-7	Use with above	 	
Mics.	Std.	Check thickness	.021	.019
Mics.	Std.	Check height of dimple	.020	.010
				ļ ———
	·		 	
			 	

Final Appearance: Parts to be clean, free of rust, oiled with light rust-proofing oil (SAE #20 or equivalent)

<u>Packaging</u>: The gross weight of any container must not exceed 100 lbs.

Acceptance Testing: Inspection will be based on statistical sampling according to Mil Std. 105D

	<u> </u>	A.Q.L. 2.	5
MATERIAL: ATSI C-1095			
HEAT TREATMENT AT: Vendor			
COMPONENT CONDITION: FINISHED:	Х	SEMI-FI	N.
MODEL NO. 700, M/24			
PART NO. 15368			
PART NAME Safety Detent Spring			
	1	OF	1
·			
	HEAT TREATMENT AT: Vendor COMPONENT CONDITION: FINISHED: MODEL NO. 700, M/24 PART NO. 15368 BLANK DRAWING NO. B-15368 PART NAME Safety Detent Spring	HEAT TREATMENT AT: Vendor COMPONENT CONDITION: FINISHED: X MODEL NO. 700, M/24 PART NO. 15368 BLANK DRAWING NO. B-15368 PART NAME Safety Detent Spring	MATERIAL: AISI C-1095 HEAT TREATMENT AT: Vendor COMPONENT CONDITION: FINISHED: X SEMI-FI MODEL NO. 700, M/24 PART NO. 15368 BLANK DRAWING NO. B-15368 PART NAME Safety Detent Spring

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

Process Header

PURCHASED PARTS INSPECTION

Material : AISI C-1095

Heat Treatment At : Vendor

Component Condition : Finished X Semi-Fin

Model : 700 700 LH 7 Lwt 24

Part Number : 15368 Blank Drawing Number: B-15368

Part Name : Safety Detent Spring

Department 9291 A. Q. L.

: 28-Aug-1961 Origination Date

Effective Date 27-Sep-1991-08:00:00

: Parts to be clean, free of rust, oiled with light rust-proofing oil (SAE #20 or equivalent). Final Appearance

The gross weight of any container must not exceed Packaging

50 pounds.

Acceptance Testing: Inspection will be based on statistical sampling

according to the Sampling Tables of Mil Std 105D for M/24 and according to Mil Std 105D Modified for all other models. Shipments will be accepted if the quality on each of the gages is sufficient to keep within the Average Outgoing Quality Limit listed.

Process Revision Reasons

Date:	Reason For Revision:	Eng Log #:
#06 Mar 1001#Potypod old	namer process last tog 205503	######################################
%00-war-1331 % werAbed old	paper process last Log 285593	2PM 731337
24-Sep-1991 Added M-24	o process	LBF 292178

Process Approval List

Approved By	y: E	Badge #:	Date:	Designation:
#Jacksora				

Document Number: 15368

Rev:

VAXcamps V2.1 Hardcopy Utility

Page: 1

OF

Process Tools

Type	Number	Use	Max	Min
		*******This Process has ********* (2) Part #'s 15368 92546 and also (2) Drawing #'s B-15368 B-92546***		
Visual		Inspect for defects		
Plug Gage	B-80002-V	Check hole dia.	.128	35 535
Width Gage	A-50125	Check inside ears	.310	.300
Comp. Fixture		Check contour		
Comp. Screen	D-700-CL-7	Use with comp. fixture		
Mics.	std.	Check thickness	.021	.019
88	Std.	Check height of (2) dimples	.020	.010

Document Number: 15368

Rev:

VAXcamps V2.1 Hardcopy Utility

Page: 2

f

Process Header

PURCHASED PARTS INSPECTION

Material : AISI C-1095

Heat Treatment At : Vendor

Component Condition : Finished X Semi-Fin

Model : 700 700 LH 7 Lwt 24

Part Number : 15368
Blank Drawing Number: B-15368

Part Name : Safety Detent Spring

Department : 9291

A. Q. L. : 3

Origination Date : 28-Aug-1961

Effective Date : 27-Sep-1991-08:00:00

Final Appearance : Parts to be clean, free of rust, oiled with light

rust-proofing oil (SAE #20 or equivalent).

Packaging : The gross weight of any container must not exceed

50 pounds.

Acceptance Testing: Inspection will be based on statistical sampling

according to the Sampling Tables of Mil Std 105D for M/24 and according to Mil Std 105D Modified for all other models. Shipments will be accepted if the quality on each of the gages is sufficient to keep within the Average Outgoing Quality Limit listed.

Process Revision Reasons

Date:	Reason For Revision:	Eng Log #:
206 War 1001 Park and 113		arr-201222
06-Mar-1991 Retyped old paper	r process last Log 285593	19 FM 7 3 T 3 3 7
24-Sep-1991 Added M-24 to pro	ocess	LBF 292178

Process Approval List

Approved	Badge	#:	Date:	Designation:
Jacksora				
Odcksola				

Document Number: 15368 Rev:

VAXcamps V2.1 Hardcopy Utility Page: 1 OF 2

Process Tools

Type	Number	Use	Max	Min
		*******This Process has ********** (2) Part #'s 15368 92546 and also (2) Drawing #'s B-15368 B-92546***		
Visual		Inspect for defects	2000000	
Plug Gage	B-80002-V	Check hole dia.	.128	.126
width Gage	A-50125	Check inside ears	.310	.300
Comp. Fixture		Check contour		
Comp. Screen	D-700-CL-7	Use with comp. fixture		
Mics.	std.	Check thickness	.021	.019
Mics.	Std.	Check height of (2) dimples	.020	.010

Document Number: 15368

Rev:

VAXcamps V2.1 Hardcopy Utility Page: 2 OF

PROCESS RECUID-INSPECTION

GAU	GES			IITS
TYPE	NUMBER	USE	MAX.	MIN.
Visual		Inspect for defects		
Plug Gage	B-80002-V	Check hole dia.	.128	.126
Width Gage	A-50125	Check inside ears	.310	.300
Comp.Fixture		Check Contour		
Comp.Screen	B-700A-CL-7	Use with above	 	
Mics.	Std.	Check thickness	.021	.019
Mics.	Std.	Check height of dimple	.020	.010
				
				
		e clean, free of rust, oiled with light rust-proofing oil	L	<u> </u>

Final Appearance: Parts to be clean, free of rust, oiled with light rust-proofing oil (SAE #20 or equivalent)

<u>Packaging</u>: The gross weight of any container must not exceed 100 lbs.

Acceptance Testing: Inspection will be based on statistical sampling according to Mil Std. 105D

			A.Q.L. 2.	5
MATERIAL: ATSI C-1095				
HEAT TREATMENT AT: Vendor				
COMPONENT CONDITION:	FINISHED:	Х	SEMI-FI	N.
MODEL NO. 700, M/24				
PART NO. 15368				
BLANK DRAWING NO. B-15368				
PART NAME Safety Detent Spring				
	PAGE	11	OF	1
	HEAT TREATMENT AT: Vendor COMPONENT CONDITION: MODEL NO. 700, M/24 PART NO. 15368 BLANK DRAWING NO. B-15368	HEAT TREATMENT AT: Vendor COMPONENT CONDITION: FINISHED: MODEL NO. 700, M/24 PART NO. 15368 BLANK DRAWING NO. B-15368 PART NAME Safety Detent Spring	MATERIAL: ATSI C-1095 HEAT TREATMENT AT: Vendor COMPONENT CONDITION: FINISHED: X MODEL NO. 700, M/24 PART NO. 15368 BLANK DRAWING NO. B-15368 PART NAME Safety Detent Spring	HEAT TREATMENT AT: Vendor COMPONENT CONDITION: FINISHED: X SEMI-FI MODEL NO. 700, M/24 PART NO. 15368 BLANK DRAWING NO. B-15368 PART NAME Safety Detent Spring

AD-6491-1

Fining Pai Blank

PROCESS RECORD DATA BASE/ENGIN	PR	OCESS CHANGE NO	292106
CHANGE NOTICE A	UTHORIZATION	ENG. CHANGE NO	i
TO BE RETURNE	D BY	INITIATED DATE	7-30-91
ROUTE TO	NAME	APPROVAL	DATE
	·	011	
PE&C SUPERVISOR	R. A. JACKSON	KNlachen	8-3-9
PRODUCTION SUP'R			
PROD. FOREMAN			
	Shirley Willoughby		
ACCOUNTING	·		
PLANNING			
PURCHASING			
		. 51	W1976-91
	IN BLANK REQU		
			••••
	CO ANGE AND REASON De angle, Use surface "A		Dim:
#28806 use surface "(C" for stop. Use sur c a	ce "C" for stop and	adjust com-
parator table to suit	. Add steps 1 & 7, mea	surement description	s
			<u>,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,</u>
			····
	CLASSIFICATION OF CI	HANGE	
	() PHASE OUT () R	EGULAR
DATA COORDINATOR		DATE	

TITLE: Firing Pin Blank

Process Header

PURCHASED PARTS INSPECTION

Material : C-1035 or 1036

Heat Treatment At : Remington

Component Condition: Finished Semi-Fin X

Model : 700 40XCF Part Number : 28805 Blank Drawing Number: C-28805

Part Name : Firing Pin Blank

Department : 9291 A. Q. L. : 3 %

Origination Date : 22-Aug-1963

Effective Date : 15-Jul-1991-08:00:00

Final Appearance : Parts to be clean, free of rust, oiled with light

rust-proofing oil (SAE #20 or equivalent).

Packaging : The gross weight of any container must not exceed

50 pounds.

Acceptance Testing: Inspection will be based on statistical sampling

according to the Sampling Tables of Mil Std 105D for M/24 and according to Mil Std 105D Modified for all other models. Shipments will be accepted if the quality on each of the gages is sufficient to keep within the Average Outgoing Quality Limit listed.

Process History

Status	Date/Time	Status	Set	Responsible	User
Submitted	15-JUL-1991	12:49:28	S.83 Shirley	Willoughby	
Comment:	******				
Fully Approved	37-JUL-1991	09:35:36	6.50 R.A.Jack	son	
Comment:	*****1.7 **** 1.0.0.1****	00 - 26 - 11	1 F XXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXX		
Normal Release	17-JUL-1991	09:30:11	.15	son	
Comment:					

Process Revision Reasons

Date:	Reason For Revision:	Eng Log #:
28-Jun-1991 Retyped ol	d paper process last Log 279534	%SLW 291919

Process Approval List

Approved By:	Badge #:	Date:	Designation:
-			
R.A.Jackson	+ 00000	17-JUL-1991	Technical Supervisor
			-

Document Number: 28805 Rev:

VAXcamps V2.1 Hardcopy Utility Page: 1 OF 2

Process General Notes

Notes:

Process Tools

Type	Number	Use	Max	Min
Visual Comp. Screen	721-CL-114	Check for excessive burrs, cracks, mars. Length 28805 -28806- Profile of point to shoulder-Blank Dim.	5.614 4.764 1.330	4.758
Comp. Fixture	c-50440	1. To check: 1.330-1.324; 1.015- 1.005; .125120 dims.; 3 deg. angle, .215200R, & .055045. **Y-Use surface "A" for stop. Use -750 Spacer. 2. To check .255245 dim. and .025020R. Remove Spacer to check this dimension only.		
	4) —	3. To check 5.614-5.608-part 28805 and 4.764-4.758 dimension-Part # 28806-use surface "C" for stop. 4. To check .065050 diam. & 31 deg. angle **Use surface "C" for stop and adjust comparator table to suit.		
Dial Mics. Adj. "Vee"Block Std. Fed. Dial Comp.	Std. B-54162	Diameter of shank Diameter of point Max. eccentricity of point and shank is .006 T.I.R. Max. eccentricity of .410/.405 dia. and shank. (.006 T.I.R.)	.2820 .076	.2805 .074

- Move table .750; shoulder in step #1 will line up on comparator screen so that we step #2 can be accomplished.
- 4) Set screen to dimension line 5.614-5.608 at rear end of part to check chamfer.

Document Number: 28805 Rev:

VAXcamps V2.1 Hardcopy Utility Page: 2 OF 2

M/700 Scope Mounting



RD-69 REV. 6-58

REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE



cc: House Force

10 01 1.5. MARTIN 1LION file

Bridgeport, Connecticut May 5, 1982

TO THE FIELD FORCE

MODEL 700 - CHANGE IN OPERATION

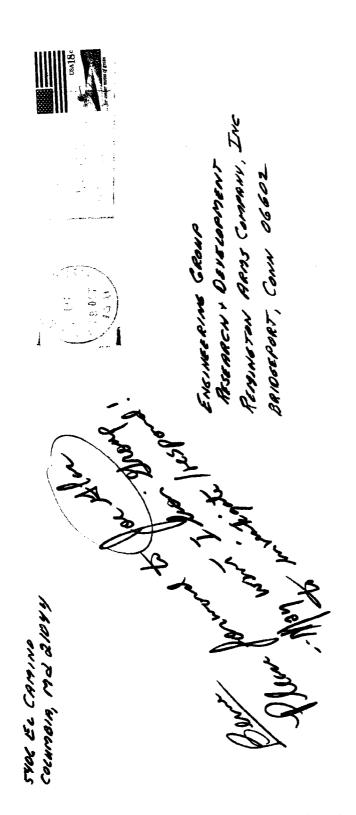
Market research, over the past several years, shows that customer interest in the bolt lock feature on the Model 700 rifle has declined. As a result, we have removed it.

Elimination of the bolt lock permits the bolt handle to be raised when the safety switch is either in the "S" or "F" position, simplifying loading and unloading. Appropriate changes in the instruction books have been made.

Since this change does not involve any product obsolescence, the order number will remain the same and there will be no formal trade announcement. Product will be shipped as available so orders should not specify guns with or without a bolt lock.

E. J. Conroy Director of Sales

EJC: fms



> CBNORMON on to?

Engineering Group - Research and Development Remington Arms Company, Inc. Bridgeport, Connecticut 06602 5406 El Camino REMINGION ARMS CO Columbia, Md 21044 RECEIVED 8 October 1981

OCT 1 4 1981

ILION RESEARCH DIVISION

Gentlemen:

HELP Q

Approximately two years ago, I traded into a Rem Model 700 BDL "Varmint Special" in Cal 223 Rem. Grudgingly, (since I am a confirmed Win Mod 70 and a Springfield Mod 03 affectiando) I now find that I prefer shooting the Mod 700 & That's the rub.

After working up some handloads based on 4895 IMR, (the) Rem 7 1/2 primer, and Nosler solid base 55gr bullets that grouped like"Wino's with a new bottle; I put a Redfield Palma rear and International front sights, on, with the intention of using the 700 as a practice weapon for polishing my metallic sights shooting for NRA National and International courses of fire.

Fortunately - or unfortunately - I find that not only can I get better scores with the 700; but, I can finish a days shooting much less tired and sore, (than if I use either my Win Mod 70 or my rebarreled Springfield 03).

Now, here's my problem.

As part of the course of fire in approximately 60% - 70% of our meets, a 'magazine change or reloading using stripper clips, is Mandated. Since this reloading occurs during timed events, the procedure must be done smoothly and quickly.

Unlike, my Win Mod 70, or my 03 Springfield, the Mod 700 does not have a machined 'clip' groove at the rear of the magazine well. There is a spacer - which I assumed was placed to position the shorter 223 cartridge forward in the receiver/magazine well; but there is nothing that will accept a stripper clip and invariably a magazine jam occurs if the stripper isplaced behind the floating 'guide' of the maga-

What I need, and what I am sure you'all have worked on at one time or another, (what with the 700 used as a sniper weapon in South-East Asia)..... is a proven method of rapidly reloading my 700. All things considered; I would prefer an insertable magazine but could reconcile my-self to machining a groove into a solid metal replacement for the spacer in the magazine well.

If you have some leftover magazines; or some thoughts on how I can get a good gunsmith to provide me with what I need, please let me know(to whom, and how much, so I can start sending checks).

Sorry to be a bother, but I figured if anyone would have the answers you would.

M-900 Sugar ? THE HOXE - CLIP SLOT Robert Solenberger

Capelette - Mark's

Now about some

feed back on this one
Slark.

Frodock ress inc.

714 State Street · Utica, N.Y. 13502 · Phone 735-9577

RD-69-8

REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE

Remington

PETERS

"CONFINE YOUR LETTER TO ONE SUBJECT ONLY"_____

xc: C. B. Workman
J. W. Brooks

J. S. Martin B. J. Sanita

Jile

March 9, 1981

TO:

T. L. Capeletti

FROM:

J. A. Stekl, F. E. Martin

SUBJECT:

Scope Mounting M/700

Recently we have encountered a fair number of complaints regarding scope mounting model 700 rifles.

The majority of the complaints received involve one-piece bridge type mounts and variable power scopes. In most of the instances, the scope does not have enough elevation adjustment to permit zero adjustment.

It is felt that this problem should be investigated from the following standpoints:

- 1. Proper receiver contour
- 2. Correct base-mount hole spacing
- 3. Proper base to receiver alignment
- 4. Proper fit between receiver and stock
 - a.) Possible action warpage on tightening guard screws
 - b.) Excessive amount of fore-end tip pressure
- 5. Correct sling-swivel stud usage per model

Any discrepancies found in any mounting systems, J.E. Redfield or Leupold, should be brought to the attention of the involved manufacturer.

TAS FEM:WS

Imper Side State Seft

PROCESS RECORD DATA BASE/ENGIN CHANGE NOTICE A	EERING PR UTHORIZATION	OCESS CHANGE NOS ENG. CHANGE NO. INITIATED DATE	
TO BE RETURNED	J B T		
ROUTE TO	NAME	APPROVAL	DATE
PE&C SUPERVISOR	C.a. Jackson	, Kalulan	8-5-91
PRODUCTION SUP'R			
PROD. FOREMAN			
	,		
ACCOUNTING. 1			-
PLANNING			
PURCHASING			
		52	2/8-1291
PART NAME Sugger PART NUMBER	ENG Sideflate Sylpe O	UESTED BY	
DCR(IF ANY) DESCRIPTION OF CH ald paper p	ANGE AND REASON _	STREDUCTION/ING Letyped for t Log 28 741	<i>~</i> ~~
		·	·
			
			•
	CLASSIFICATION OF C	HANGE	-
EFFECTIVITY DATE	() PHASE OUT () R	EGULAR
DATA COORDINATOR		DATE	

C) #491-1

PROCESS RECOM-INSPECTION

GAUGES		<u>.</u>		LIMITS	
TYPE	NUMBER	USE	MAX.	MIN.	
Visual		Free from burrs - noticeable defects			
Comp. Screen	D-700-CL-24				
Comp. Fixture	B-36301				
Plug Gage	Std.	Dia. of "A" hole - 3 places	,126	,125	
Plug Gage	Std.	Dia. of "B" hole - 4 places	.103	.101	
Plug Gage	B-80219-R	Dia. of "D" hole - 1 place	.1247	.1237	
Pinning Gage	C-36471	FOR VENDOR USE ONLY (1 GAGE)			
Mics.	Std.	Check material thickness	064	060	
SURFACE PLATE & SHIMS		Flatness	002		

Final Appearance: Parts to be clean, free of rust, oiled with light rust-proofing oil (SAE #20 or equivalent)

Packaging

: The gross weight of any container must not exceed 100 lbs.

Acceptance Testing: Inspection will be based on statistical sampling according to Dodge and Romig Sampling Tables of Bell Telephone Company. Shipments will be accepted if the quality on each of the gages is sufficient to keep within the "Average Outgoing Quality Limit" listed.

	A.Q.L. 5%
DATES AND REASONS FOR REVISIONS 5-1-70-New-AJU-268737	MATERIAL: C-1010 or C-1020
9/26/80 - Changed part number - was 30781 - CAK -	HEAT TREATMENT XX None
272.734	COMPONENT CONDITION: FINISHED: X SEMI-FIN.
2/17/81 - Changed part number back to 30781 - CAK	MODEL NO. 700 - 40XB - 600, SEVEN LWT
280217	PART NO. 30781
5/7/82 - Added SEVEN LWT - CAK - 28/464 - 10/21/82 - Added material thickness - CAK 28203	BLANK DRAWING NO. C-30781
_ 10/21/82 - Added material thickness - CAK 20203	PART NAME Trigger Side Plate (Left)
5/20/87-Added flatness within 002-IRF-287419	DEPT, NO. 92 PAGE 1 OF 1

RELINGTON ARMS CO., BIG., BICH, ILY.

TITLE: Trigger Side Plate (Left)

Process Header

PURCHASED PARTS INSPECTION

Material : C-1010 or C-1020

Heat Treatment At : None

Component Condition: Finished X Semi-Fin

Model

: 700 40XB 7LWT 600

Part Number : 30781 Blank Drawing Number: C-30781

Part Name : Trigger Side Plate (Left)

Department : 9291 A. Q. L. : 3 %

Origination Date : 01-May-1970

Effective Date : 06-Aug-1991-08:00:00

Final Appearance : Parts to be clean, free of rust, oiled with light

rust-proofing oil (SAE #20 or equivalent).

Packaging : The gross weight of any container must not exceed

50 pounds.

Acceptance Testing: Inspection will be based on statistical sampling

according to the Sampling Tables of Mil Std 105D for M/24 and according to Mil Std 105D Modified for all other models. Shipments will be accepted if the quality on each of the gages is sufficient to keep within the Average Outgoing Quality Limit listed.

Process Revision Reasons

Date:	Reason For Revision:	Eng Log #:
29-Jul-1991 Retyped ol	d paper process last Log 287419	291966

Process Approval List

Approved	dge #: Dat	
Jacksora		

Document Number: 30781

Rev:

VAXcamps V2.1 Hardcopy Utility

Page: 1

OF

TITLE: Trigger Side Plate (Left)

B-8/0219-R Dia. of "D" hole-1 place

Flatness

€C0-36471

Std.

Plug Gage

∰Mics.

Shims

Pinning Gage

Suface Plate &

Process Tools		n Con	To Part of the Control of the Contro			
Type	Number		Use		Max	Min
Visual	Ţ	Free from	burrs-noticea	ble defects		
Comp. Screen	D-700-CL-					
Comp. Fixture	B-36301					.125
Plug Gage	std.	Dia. of "A	A" hole-3 plac	ces	.126	.125
Plug Gage	std./	Dia. of "F	3" hole-4 plac	ces	.103	.101

FOR VENDOR USE ONLY (1 GAGE)

Check material thickness

Document Number: 30781 Rev:

VAXcamps V2.1 Hardcopy Utility Page: 2 OF 2

.1247 .1237

.060

.064

.002

P-14+01-1

PROCESS RECON-	- INSPECTION
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GAUGES		•		LIMITS	
TYPE	NUMBER	USE	MAX.	MIN.	
Visual		Free from burrs - noticeable defects			
Comp. Screen	D-700-CL-24				
Comp. Fixture	B-36301				
Plug Gage	Std.	Dia. of "A" hole - 3 places	,126	,125	
Plug Gage	Std.	Dia. of "B" hole - 4 places	.103	.101	
Plug Gage	B-80219-R	Dia. of "D" hole - 1 place	.1247	.1237	
Pinning Gage	C-36471	FOR VENDOR USE ONLY (1 GAGE)			
Mics.	Std.	Check material thickness	.064	.060	
SURFACE PLATE & SHIMS		Flatness	.002		

Final Appearance: Parts to be clean, free of rust, oiled with light rust-proofing oil (SAE #20 or equivalent)

Packaging : The gross weight of any container must not exceed 100 lbs.

Acceptance Testing: Inspection will be based on statistical sampling according to Dodge and Romig Sampling Tables of Bell Telephone Company. Shipments will be accepted if the quality on each of the gages is sufficient to keep within the "Average Outgoing Quality Limit" listed.

A.O.L.

50/

	1 3 %
DATES AND REASONS FOR REVISIONS 5-1-70-New-AJU-268737	MATERIAL: C-1010 or C-1020
9/26/80 - Changed part number - was 30781 - CAK -	HEAT TREATMENT XX None
372534	COMPONENT CONDITION: FINISHED: X SEMI-FIN.
2/17/81 - Changed part number back to 30781 - CAM	MODEL NO. 700 - 40XB - 600, SEVEN LWT
280217	PART NO. 30781
3802(7 5/7/82 - Added SEVEN LWT - CAK - 38/464 10/21/82 - Added material thickness - CAK 38303	BLANK DRAWING NO. C-30781
10/21/82 - Added material thickness - CAK 2603	PART NAME Trigger Side Plate (Left)
5/20/87-Added flatness within .002-LBF-287419	DEPT, NO. 92 PAGE 1 OF 1

REMINISTON ARMS CC., BIG., ILICH, H.Y.

moBDX 291985 Mussin Guard

ENG. CHANGE NO INITIATED DATE _ APPROVAL	
Rafach	DATE
Ra/achi-	8-5-91
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Ka/achin Stu	
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52	P-1\-91
Sw	P-1\-91
Sa	P-11-91
Sa	P-11-91
52	P-11-91
52	12-11-91
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Exped from the Long 3845-2	<u>~~</u>
	•
ANGE	-
PHASE OUT () RE	GULAR
	Letyped from 1845-2

.4.6491-1

PROCESS RECORD-INSPECTION

GAUGE	s		·		MITS
TYPE	NUMBER		USE	мах.	MIN.
Visual		Free from excessive	gates and flash and surface		
		imperfections.			
			O drip 1		
Mics.	Std.	Check width.	(•625 dim)	.630	.620
Plug Gage		Check slot.		420	476
, riug dage	Std.	Check SIOC.	$\frac{1}{4} \frac{1}{4} \frac{1}$	420	410
Comp. Fixture	B84517		7 9 11		
Comp. Screen	D700ADL-CL-6		top and side view (long action)		
<u>,</u>		·	top and side view (short action	·	100
Plug Ga.	Standard	Check width of Floo	r Plate Latch slot. (.190 dim)	195	.185
Plug Gage	Standard	Check Guard Screw h	oles.	255	.250
Calipers	Std.	Check width (outsid	e) magazine area, front 6975 di	m) .980	.970
	Std.	Check width (outside	e) magazine area, rear (1.080 di	m) 1.085	1.075
Final Appeara	nce: Parts to be (SAE #20 or	e clean, free of rust, c equivalent)	oiled with light rust-proofing oi	L	
Packaging		-	must not exceed 100 lbs.		
			tistical sampling according to Do	ige and Roi	nig
	Sampling	Tables of Bell Telepho	one Company. Shipments will be acc	epted if the	16
	quality of	on each of the gages is ality Limit" listed.	s sufficient to keep within the "A		
	FOING WILL	all by Bimio IIS bed;			L. 3%
ATES AND REASONS FO			MATERIAL: #218 Aluminum Die Ca	sting Alloy	
		- new form - Marley	HEAT TREATMENT AT: Remington		
9/26/80 - Chang and 2	ed part number	s - were 26375	COMPONENT CONDITION: FINISH MODEL NO. 700 BDL	ED: SI	MI-FIN. X
$\frac{1}{6}$ /11/84 - Revised	- TBM - 28444	5	PART NO. 34315, 34316		
5/29/84 - Revised - S			BLANK DRAWING NO. D-34315		
	——————————————————————————————————————			ank	
The state of the s					

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

TITLE: Trigger Guard Blank

Process Header

PURCHASED PARTS INSPECTION

: #218 Aluminum Die Casting Alloy Material Heat Treatment At : Remington Component Condition : Finished Semi-Fin X Model 700 BDL Part Number : 34315 Blank Drawing Number: D-34315 Part Name : Trigger Guard Blank : 9291 Department : 3 A. Q. L. Origination Date : 20-Jun-1961 : 06-Aug-1991-08:00:00 Effective Date Final Appearance : Parts to be clean, free of rust, oiled with light rust-proofing oil (SAE #20 or equivalent). The gross weight of any container must not exceed Packaging 50 pounds. Acceptance Testing: Inspection will be based on statistical sampling according to the Sampling Tables of Mil Std 105D for M/24 and according to Mil Std 105D Modified for all other models. Shipments will be accepted if the quality on each of the gages is sufficient to keep within the Average Outgoing Quality Limit listed.

Process Revision Reasons

Date:	Reason For Revision:	Eng Log #:
30-Jul-1991 Retyped ol	d paper process last Log 284520	SLW 291985

Process Approval List

Approved	By:	Badge #:	Date:	Designation:
71				
#Jacksora				

Process General Notes

This process has two Pt.#'s they would not fit on Process Header section #34315 & 34316

Notes:

Document Number: 34315 Rev:

VAXcamps V2.1 Hardcopy Utility Page: 1 OF 2

TITLE: Trigger Guard Blank

Process Tools

Type	Number	. Use	/)	Max	Min
Visual		Free from excessive gates and fland and surface imperfections.	ash		
Mics.	std.	Check width (.625 d	im)	.630	.620
Plug Gage	std.	Check slot (.4 $\sqrt{5}$ d	im)	.420	.410
Comp. Screen	D-700ADL- CL-6	Check mean outline top and side view (long action)		0000000	
Comp. Fixture	B-84517	Check mean outline top and side view (short action)			
Plug Gage	Std.	Check width of Floor Plate Latch slot. (.190 dim)		.195	.185
Plug Gage	std.	Check Guard Screw holes		.255	.250
Calipers	std.	Check width (outside) magazine area, front (.975 dim)		.980	.970
		Check width (outside) magazine area, rear (1.080 dim)		1.085	1.075

Document Number: 34315

Rev:

VAXcamps V2.1 Hardcopy Utility Page: 2

OF

RD-4491-1

PROCESS RECORD-INSPECTION

GAUGE	s			ITS
TYPE	NUMBER	USE	MAX.	MIN.
Visual		Free from excessive gates and flash and surface		
		imperfections.		
		Oby VI		<u> </u>
Mics.	Std.	Check width. (.625 dim)	•630	.620
		le ob		
Plug Gage	Std.	Check slot. (.415 dim)	420_	410
		J 341 .		
Comp. Fixture	B8#517		<u> </u>	}
Comp. Screen	D700ADL-CL-6	Check mean outline top and side View (long action)		
		Check mean outline top and side view (short action)		
Plug Ga.	Standard	Check width of Floor Plate Latch slot. (.190 dim)	-195	.18
Plug Gage	Standard	Check Guard Screw holes.	. 255_	.25
Calipers	Std.	Check width (outside) magazine area, front (975 dim)	.980	.970
	Std.	Check width (outside) magazine area, rear (1.080 dim)	1.085	1.07
Final Appearan	Ce: Parts to be	e clean, free of rust, oiled with light rust-proofing oil equivalent)		
Packaging	: The gross	weight of any container must not exceed 100 lbs.		
Acceptance Tes	sting: Inspection Sampling quality	on will be based on statistical sampling according to Dodge Tables of Bell Telephone Company. Shipments will be accept on each of the gages is sufficient to keep within the "Averality Limit" listed.	ed if the	
DATES AND REASONS FOR	REVISIONS	MATERIAL: #218 Aluminum Die Casti		
8/29/63 - Retyped	from 6/20/61	- new form - Marley HEAT TREATMENT AT: Remington		
9/26/80 - Change	ed part number	S - WOYO 26375 COMPONENT CONDITION: FINISHED:	SEM	II-FIN. 🗶
9/26/80 - Change and 2	6376 - CAK	29234 MODEL NO. 700 BDL		
6/11/84 - Revised		5 PART NO. 34315, 34316		
6/29/84 - Revised - S	B - 284520	BLANK DRAWING NO. D-34315		
		PART NAME Trigger Guard Bland	ς	
		DEPT. NO. 92 60 PAGE		

700 192039 Safety Veter Ball

CHANGE NOTICE AUTHORIZATION ENG. CHANGE NO. TO BE RETURNED BY ROUTE TO NAME APPROVAL DATE PE&C SUPERVISOR PRODUCTION SUP'R PRODUCTION SUP'R PROD. FOREMAN ACCOUNTING PLANNING PURCHASING MODEL NO. PART NAME Setty Natural Requested by STA PART NUMBER BESCRIPTION OF CHANGE AND REASON CLASSIFICATION OF CHANGE EFFECTIVITY DATE CLASSIFICATION OF CHANGE EFFECTIVITY DATE () PHASE OUT () REGULAR	PROCESS RECORD AND DATA BASE/ENGINEERING PROCESS CHANGE NO.272039							
ROUTE TO NAME APPROVAL DATE PE&C SUPERVISOR PODE CONTROL SCHOOL	DATA BAGE, Extended							
PE&C SUPERVISOR PRODUCTION SUP'R PRODUCTION SUP'R PROD. FOREMAN ACCOUNTING PLANNING PURCHASING MODEL NO. PART NAME Softy Start Fact Requested by Start PART NUMBER DESCRIPTION OF CHANGE AND REASON CLASSIFICATION OF CHANGE EFFECTIVITY DATE () PHASE OUT () REGULAR	TO BE RETURNED BY INITIATED DATE							
PE&C SUPERVISOR PLANER SOLVER	ROUTE TO NAME APPROVAL DATE							
PRODUCTION SUP'R PROD. FOREMAN ACCOUNTING PLANNING PURCHASING MODEL NO. PART NAME Softwheth Gale REQUESTED BY STATE PART NUMBER DESCRIPTION OF CHANGE AND REASON Setting from ALI PARTO PROCESS SUPER SOLUTION/INCREASE DESCRIPTION OF CHANGE AND REASON Settings from ALI PARTO PROCESS SUPER SOLUTION SUPER SOLUTION SUPER SU								
PRODUCTION SUP'R PROD. FOREMAN ACCOUNTING PLANNING PURCHASING MODEL NO. PART NAME Softy Network Call REQUESTED BY STAD PART NUMBER DESCRIPTION OF CHANGE AND REASON Stapped from Classification Of Change CLASSIFICATION OF CHANGE EFFECTIVITY DATE () PHASE OUT () REGULAR	PE&C SUPERVISOR	CO Onckson	Robach	8-6-91				
ACCOUNTING PLANNING PURCHASING MODEL NO. To ENGINEER PART NAME Softy Natural Requested by STall PART NUMBER STALL REQUESTED BY STall PART NUMBER STALL COST REDUCTION/INCREASE DESCRIPTION OF CHANGE AND REASON States from PLANTING STALL CLASSIFICATION OF CHANGE EFFECTIVITY DATE () PHASE OUT () REGULAR	PRODUCTION SUP'R		\(\sqrt{\chi}\)					
PLANNING PURCHASING SLE 87291 MODEL NO. If or ENGINEER PART NAME Softy Natural Requested by SLU PART NUMBER 3222 ECR NO. DCR(IF ANY) COST REDUCTION/INCREASE DESCRIPTION OF CHANGE AND REASON Stayed from PLAPAGE Process Last Log 28/464 CLASSIFICATION OF CHANGE EFFECTIVITY DATE () PHASE OUT () REGULAR	PROD. FOREMAN							
PLANNING PURCHASING SLE 87291 MODEL NO. If or ENGINEER PART NAME Softy Natural Requested by SLU PART NUMBER 3222 ECR NO. DCR(IF ANY) COST REDUCTION/INCREASE DESCRIPTION OF CHANGE AND REASON Stayed from PLAPAGE Process Last Log 28/464 CLASSIFICATION OF CHANGE EFFECTIVITY DATE () PHASE OUT () REGULAR								
MODEL NO. The ENGINEER	ACCOUNTING V			-				
MODEL NO. If for ENGINEER	PLANNING	.*.						
MODEL NO. The softy Natural Sulphant Requested by Star Part Name Softy Natural Requested by Star Part Number 3322 ECR NO. DCR(IF ANY) COST REDUCTION/INCREASE DESCRIPTION OF CHANGE AND REASON Starped from Slapper process last Log 28/464 CLASSIFICATION OF CHANGE EFFECTIVITY DATE () PHASE OUT () REGULAR	PURCHASING	***						
PART NAME Softy Natural REQUESTED BY STAND PART NUMBER 33222 ECR NO. DCR(IF ANY) COST REDUCTION/INCREASE DESCRIPTION OF CHANGE AND REASON Stay Softy Alpaper process last Lag 28/464 CLASSIFICATION OF CHANGE EFFECTIVITY DATE () PHASE OUT () REGULAR			I S	Tel 8-12-91				
COST REDUCTION/INCREASE DESCRIPTION OF CHANGE AND REASON Letyped from Plant Log 28/46 4 CLASSIFICATION OF CHANGE EFFECTIVITY DATE() PHASE OUT () REGULAR	PART NAME Safety	Detent Bull REQU	JESTED BY	<i>ل</i> ح				
COST REDUCTION/INCREASE DESCRIPTION OF CHANGE AND REASON Letyped from Plant Log 28/46 4 CLASSIFICATION OF CHANGE EFFECTIVITY DATE() PHASE OUT () REGULAR	·			•- ••				
CLASSIFICATION OF CHANGE EFFECTIVITY DATE	DESCRIPTION OF CH	ANGE AND REASON	Cetyped for	om				
EFFECTIVITY DATE () PHASE OUT () REGULAR	Old Paper p	noves las	t dag 2814	64				
EFFECTIVITY DATE () PHASE OUT () REGULAR								
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EFFECTIVITY DATE () PHASE OUT () REGULAR								
EFFECTIVITY DATE () PHASE OUT () REGULAR		LASSIFICATION OF CH	IANGE					
				EGULAR				
			DATE					

PROCESS RECORD-INSPECTION

GAUGES				LIMITS		
TYPE	NUMBER		USE		MAX.	MIN.
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Visual		Finish		<u>-</u>		
Mi					17.64	
Mics.	Std.	Diameter		V	1564	1560
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Final Aunaan	ones Pente to b	alaan francis	alled with light much much		_	
rinal Appear	(SAE #20 o	r equivalent)	oiled with light rust-proc	oring off		
Packaging	: The gross	weight of any container	must not exceed 100 lbs.	1		
Acceptance I	esting: Inspect	on will be based on sta	tistical sampling accordi	ng to Dodge	and Romi	3
	Sampling	Tables of Bell Telepho	ne Company. Shipments will sufficient to keep within	l be accept	ed if the	
	quarity going Qu	ality Limit" listed.	sufficient to keep within	ter end i		
· · · · · · · · · · · · · · · · · · ·		279389	Description MC Ct 3		A.Q.L.,	7 %
ATES AND REASONS F			MATERIAL: Mfg. Std. HEAT TREATMENT AT:			
5/23/80 - Rety	rped from 27509 1 SEVEN LWT - C	6 - Updated - CAK-	COMPONENT CONDITION:	FINISHED:	y SEMI	-FIN.
3/1/8/ = Annec	I SEVEN IIVI - C	AL GOLDON	MODEL NO. 600, XP-100, 40	XB 700 CI		
			PART NO. 23222	111, 1111, -31	: V C-14	···
			BLANK DRAWING NO. B-23220			
			PART NAME Safety Deten	t Ball/Ope	ratingHand	le Detent
			DEPT. NO. 92	PAGE	$\mathcal{I}^{\mathcal{I}}$ of	7
						

TITLE: Safety Detent Ball/Oper.Hdl.Detent Ball

Process Header

PURCHASED PARTS INSPECTION

: Mfg. Std. Material Heat Treatment At Component Condition : Finished X Semi-Fin : XP100 600 40XB 700 7LWT Model Part Number : 23222 Blank Drawing Number: B-23220 Part Name : Safety Detent Ball/Oper.Hdl.Detent Ball Department : 9291 A. Q. L. : Origination Date : 23-Jun-1980 Effective Date : 06-Aug-1991-08:00:00 : Parts to be clean, free of rust, oiled with light rust-proofing oil (SAE #20 or equivalent). Final Appearance : The gross weight of any container must not exceed Packaging 50 pounds. Acceptance Testing: Inspection will be based on statistical sampling according to the Sampling Tables of Mil Std 105D for M/24 and according to Mil Std 105D Modified for all other models. Shipments will be accepted if the quality on each of the gages is sufficient to keep within the Average Outgoing Quality Limit listed.

Process Revision Reasons

Date:	Reason	For	Revision:	Eng Log #:
202-Aug-1991 Retyped old pape Retyped old pape ■	proces	ss la	st Log 28146	4

Process Approval List

Approved	Badge #:	Date:	Designation:	
Jacksora		*******		

Process General Notes

Notes:

**This process has two Pt. Names under same Pt.# included them in process header section

Document Number: 23222 Rev:

VAXcamps V2.1 Hardcopy Utility Page: 1 OF 2

TITLE: Safety Detent Ball/Oper.Hdl.Detent Ball

Process Tools

Ty	ype N	Number	Use	Max	Min
Wi gual			finish		
VISUAI		Check	11111511		
Mics.	Sto		ter	2.1564	.1560
XXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXX	************	*****			***************************************

Document Number: 23222

Rev:

VAXcamps V2.1 Hardcopy Utility Page: 2 OF

RD-6518 Rev 7/83

PROCESS RECORD AND DATA BASE/ENGINEERING CHANGE NOTICE AUTHORIZATION ENG. CHANGE NO INITIATED DATE			
TO BE RETURNED BY			
ROUTE TO	NAME	APPROVAL	DATE
PEAC SUPERVISOR	R a Orl		
PRODUCTION SUP'R	0 0		
PROD. FOREMAN			
ACCOUNTING .			-
PLANNING	: ·		·
PURCHASING		·	
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PART NAME 23222 ECR NOECR NO			
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DCR(IF ANY) COST REDUCTION/INCREASE DESCRIPTION OF CHANGE AND REASON			
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·			
			
CLASSIFICATION OF CHANGE			
EFFECTIVITY DATE .		PHASE OUT () RE	GULAR
DATA COORDINATOR		DATE	

AD-4491-1

PROCESS RECORD - INSPECTION

GAUGES				LIMITS	
TYPE	NUMBER	┥	USE	MAX.	MIN.
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Visual		Finish			
Mics.	Std.	Diameter		1564	156
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Final Appearanc	el Parts to 1 (SAE #20	pe clean, free of rust, or equivalent)	oiled with light rust-proofing oil		
<u>Packaging</u>	: The gross	weight of any container	must not exceed 200 lbs.		
Acceptance Test	ting: Inspect	ion will be based on sta	atistical sampling according to Dodge	and Romi	g
	Samplin	g Tables of Bell Telepho	one Company. Shipments will be accept	ed if the	_
	going O	on each of the gages is uality Limit" listed.	s sufficient to keep within the "Aver		
				A.Q.L.	7%
DATES AND REASONS FOR I	· - · ·	279389	MATERIAL: Mfg. Std.		
6/23/80 - Retyp	ed from 2750	096 - Updated - CAK -	HEAT TREATMENT AT:		
		280284	COMPONENT CONDITION: FINISHED:	X SEM	I-FIN.
			MODEL NO. 1100		
			PART NO. 23222		
			BLANK DRAWING NO. B-23220		
			PART NAME Op. Handle Detent Ball		
			DEPT. NO. 92 PAGE	l of	-

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

PROCESS RECORD-INSPECTION

GAUGES		1) law		LIMITS	
TYPE	NUMBER	1	USE	MAX.	MIN.	
						
Visual		Finish				
Mics.	Std.	Diameter	2/0	.1564	156	
			lar a			
<u> </u>			0,57			
			- Contraction of the contraction		<u> </u>	
			98			
			CR O			
			·		ļ	
						
Final Appea	rance: Parts to b	e clean, free of rust, or equivalent)	oiled with light rust-proofing oil	•		
Packaging	: The gross	weight of any containe	r must not exceed 100 lbs.			
Acceptance	Testing: Inspect	on will be based on st	tatistical sampling according to Do none Company. Shipments will be acc	lge and Romi	g	
	quality	on each of the gages	is sufficient to keep within the "A	epted 11 the verage Ou t-		
	going Qu	ality Limit" listed.	· · · · · ·	A.Q.L,		
TES AND REASONS	FOR REVISIONS	279389	MATERIAL: Mfg. Std.			
6/23/80 - Ret	yped from 27509	6 - Updated - CAK-	HEAT TREATMENT AT:			
5/7/82 - Adde	ed SEVEN LWT - (AK - 28/464	COMPONENT CONDITION: FINISH		I-FIN.	
	····		MODEL NO. 600, XP-100, 40XB, 700,	SEVEN LWT		
		······································	PART NO. 23222 BLANK DRAWING NO. B-23220			
			PART NAME Safety Detent Ball			
			DEPT. NO. 92 PA	SE 1 OF	7	

lee Dr. 242043

PROCESS RECORD AND DATA BASE/ENGINEERING PROCESS CHANGE NO 292042						
CHANGE NOTICE AUTHORIZATION ENG. CHANGE NO						
TO BE RETURNED BY INITIATED DATE						
ROUTE TO	NAME	APPROVAL	DATE			
		2.1				
PE&C SUPERVISOR	C. O. Onckson	Kapeh-	8-6-91			
PRODUCTION SUP'R			2			
PROD. FOREMAN						
ACCOUNTING "			-			
PLANNING						
PURCHASING	** **					
PART NAME Sear	ENGI PEQU 24476	. مي م	み			
			•• ••.			
DCR(IF ANY)	CO	ST REDUCTION/IN	CREASE			
	ANGE AND REASON		- P 9			
or a puper p	roces las	0.09 20 00	() _ /			
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	LASSIFICATION OF CH	IANGE				
EFFECTIVITY DATE	(PHASE OUT () R	EGULAR			

PROCESS RECORD-INSPECTION

	GES			LIMITS	
TYPE	NUMBER	1·	USE	MAX.	MIN,
Visual		Free of Burrs, 01	0 x 45 Chamfer (one end)		<u> </u>
		Color Black	(one chay		
		l6-Finish			
Mics	St.d.	Diameter	(10)	.125	1248
			7		
Snap Ga.	В-80024-Т	Length .	W 10-	.720	.710
Scale or Calip	pers Std.	60 Inc. Angle		.060	.040
			V 9 "		1
			1),1		
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Final Aupeara	(SAE #20 o	r equivalent)	oiled with light rust-proofing oi	L	
			atistical sampling according to Do	dge and Romi	•
noce nothing 10	Sampling	Tables of Bell Telepho	one Company. Shipments will be accompany.	antad is the	. F.
		on each of the second		sprea II tile)
	quality	on each of the gages Ti	s sufficient to keep within the "A	verage Out-	ı ¯
	quality	ality Limit" listed.	s sufficient to keep within the "A	verage Out-)
ITES AND DEACONS FOL	quality going Qu	ality Limit" listed.	•	verage Out-)
LTES AND REASONS FOI	quality going Qu	ality Limit" listed. /88-Sep. Pt.#-ELB7	MATERIAL: AISI C-1095 or A50100	verage Out-)
LTES AND REASONS FOI	quality going Qu	88-Sep. Pt.#-ELB?	MATERIAL: AISI C-1095 OF A50100 HEAT TREATMENT AT: R 45 N 43-49	verage Out- A.q.L. or 52100	5%
ITES AND REASONS FOL	quality going Qu	88-Sep. Pt.#-ELB?	MATERIAL: AISI C-1095 OF A50100 HEAT TREATMENT AT: R 45 N 43-49 COMPONENT CONDITION: FINISH	verage Out- A.Q.L. or 52100)
ATES AND REASONS FOI	quality going Qu	88-Sep. Pt.#-ELB?	MATERIAL: AISI C-1095 or A50100 HEAT TREATMENT AT: R 45 N 43-49 COMPONENT CONDITION: FINISH MODEL NO. 700,40XB,40CF,7LWT,72	verage Out- A.Q.L. or 52100	5%
TES AND REASONS FO	quality going Qu	88-Sep. Pt.#-ELB?	MATERIAL: AISI C-1095 OF A50100 HEAT TREATMENT AT: R 45 N 43-49 COMPONENT CONDITION: FINISH MODEL NO. 700,40XB,40CF,7LWT,72: PART NO. 24476	verage Out- A.Q.L. or 52100	5%
ATES AND REASONS FO	quality going Qu	88-Sep. Pt.#-ELB?	MATERIAL: AISI C-1095 OF A50100 HEAT TREATMENT AT: R 45 N 43-49 COMPONENT CONDITION: FINISH MODEL NO. 700,40XB,40CF,7LWT,72: PART NO. 24476 BLANK DRAWING NO. C-24475	verage Out- A.Q.L. or 52100	5%
ATES AND REASONS FOI	quality going Qu	88-Sep. Pt.#-ELB?	MATERIAL: AISI C-1095 OF A50100 HEAT TREATMENT AT: R 45 N 43-49 COMPONENT CONDITION: FINISH MODEL NO. 700,40XB,40CF,7LWT,72: PART NO. 24476 BLANK DRAWING NO. C-24475 PART NAME Sear Pin	verage Out- A.Q.L. or 52100	5%

TITLE: Sear Pin

Process Header

PURCHASED PARTS INSPECTION

: AISI C-1095 or A50100 or 52100 Material Heat Treatment At : R45N 43-49 Component Condition : Finished X Semi-Fin : 700 40XB 40XCF 721 722 Model Part Number : 24476 Blank Drawing Number: C-24475 : Sear Pin Part Name : 9291 Department : 3 A. Q. L. Origination Date : 13-Oct-1988 Effective Date : 06-Aug-1991-08:00:00 : Parts to be clean, free of rust, oiled with light Final Appearance rust-proofing oil (SAE #20 or equivalent). : The gross weight of any container must not exceed Packaging 50 pounds. Acceptance Testing: Inspection will be based on statistical sampling according to the Sampling Tables of Mil Std 105D for M/24 and according to Mil Std 105D Modified for all other models. Shipments will be accepted if the quality on each of the gages is sufficient to keep within the Average Outgoing Quality Limit listed.

Process Revision Reasons

Date:	Reason For	Revision:	Eng Log #:
#02-Aug-1991 Retyped old paper	r process l	ast Log 288589	\$\$LW\$292042

Process Approval List

Approved	By:	Badge #:	Date:	Designation:
Jacksora				

Document Number: 24476 Rev:

VAXcamps V2.1 Hardcopy Utility Page: 1 OF 2

TITLE: Sear Pin

Process Tools

Type	Number	Use	Max	Min
%Visual		Free from burrs, .010 x 45 deg		
W 15ddi		chamfer (one end) Color Black		
		16-Finish		
Mics.	2826	Diameter	.125 .720 .060	.1248
Snap Gage	B-80012-T	Length	.720	.710
Scale or Calipers	Std.	60 deg. Inc. Angle (ength)	.060	.040

Document Number: 24476

Rev:

VAXcamps V2.1 Hardcopy Utility Page: 2 OF

2

PROCESS RECORD-INSPECTION

GAUGES				LIM	LIMITS	
TYPE	NUMBER	1	USE	MAX.	MIN.	
Visual		Free of Burrs, .010) x 45 Chamfer (one end)			
		Color Black	(01.6 (1.6)			
		16-Finish				
Mics	Std.	Diameter	100	.125	.1248	
			Λυ			
Snap Ga.	В-80024-Т	Length	W 12-	.720	.710	
Scale or Calipe	rs Std.	60°Inc. Angle	7 .	.060	.040	
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Final Aupearanc	es Parts to be (SAE #20 or	e clean, free of rust, r equivalent)	oiled with light rust-proofing oi	1		
Packaging	: The gross	weight of any container	must not exceed 100 lbs.			
Acceptance Test				dge and Romi	σ	
	Sampling	Tables of Bell Telepho	tistical sampling according to Do one Company. Shipments will be acc	epted if the	- 5	
	quality -	on each of the gages is	sufficient to keep within the "A	verage Out-		
	going Qu	ality Limit" listed.		A.Q.L.	5%	
ATES AND REASONS FOR I	REVISIONS 10/13/	/88-Sep. Pt.#-ELB/	MATERIAL: AISI C-1095 or A50100			
<u> </u>		288589	HEAT TREATMENT AT: R 45 N 43-49	01 32100		
			COMPONENT CONDITION: FINISH	IED: X SEM	II-FIN.	
			MODEL NO. 700,40XB,40CF,7LWT,72	765.	114,	
			PART NO. 24476	1,144		
<u> </u>			0.24475			
			BLANK DRAWING NO.			
			PART NAME Sear Pin DEPT. NO. 9291	7		
			DEPT. NO. $929\pm$ PA	ge los	7	
			55.11,1141			

Ingjul in John Blk. Pai

PROCESS RECORD DATA BASE/ENGIN	199	DCESS CHANGE NOS	292043			
CHANGE NOTICE AUTHORIZATION ENG. CHANGE NO						
TO BE RETURNED	BY	INITIATED DATE				
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PE&C SUPERVISOR PRODUCTION SUP'R	Il Galeson	Colam	8-651			
PROD. FOREMAN						
	,	,				
ACCOUNTING '	· · · · · · · · · · · · · · · · · · ·					
PLANNING		· · · · · · · · · · · · · · · · · · ·				
PURCHASING	, "					
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PART NUMBERERGINEERENGINEERERGINEERERGINEERERGINEERERGINEERERGINEERERGINEERERGINEERERGINEERERGINEERERGINEERERGINEERERGINEERERGINEER						
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DCR(IF ANY) COST REDUCTION/INCREASE DESCRIPTION OF CHANGE AND REASON Letyped from Old paper process last Log 288591						
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	()	PHASE OUT () R	EGULAR			
DATA COORDINATOR	Profiliple Segment freelighting speed, as a page or office, or a six or object on a supplement of the contract	7174				

PROCESS RECORD-INSPECTION

GAUGES					LIMITS	
TYPE	NUMBER	USE		MAX.	MIN.	
Visual		Free of Burrs .010 x 45°Chamfer	(Both ends)			
		Color-Black			l	
		16 Finish			ļ	
] 						
Mics	Std	Diameter	1/31	.125	.1248	
Grand G			- lay	.365	.355	
Snap Ga.	B-80024-U	Length		• 303	-333	
		1. 1. 1. 1. 1. 1. 1. 1. 1. 1. 1. 1. 1. 1	0.0			
		() X				
			· · · · · · · · · · · · · · · · · · ·		 	
						
						
						
			**	····		
/ 	•					
					ļ — — — — — — — — — — — — — — — — — — —	
<u>Packaging</u>	: The gross Testing: Inspecti Sampling quality	e clean, free of rust, oiled with light equivalent) veight of any container must not except will be based on statistical samp. Tables of Bell Telephone Company. Sign each of the gages is sufficient to ality Limit" listed.	eed 100 1bs. ling according to Dodge hipments will be accepte	ed if the age Out-		
				A.Q.L.	5 8	
DATES AND REASONS		■	I C-1095 or A50100 or	52100		
<u> 10/13/88-Seper</u>	ate Pt.#-ELB-289			v		
			COMPONENT CONDITION: FINISHED: X SEMI-FIN.			
	<u> </u>	MODEL NO. 700 PART NO. 244	XP100,541-S,7LWT,40XC	CF,721,7	22	
		BLANK DRAWING				
			igger Pin, Sear Blank	D		
		DEPT. NO. 9	291 PAGE			
		221,1,100	FAGE			
						

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

TITLE: Trigger Pin, Sear Blank Pin

Process Header

PURCHASED PARTS INSPECTION

Material : AISI C-1095 or A50100 or 52100 Heat Treatment At : R45N 43-49 Component Condition: Finished X Semi-Fin : 700 40XB 40XCF 721 722 XP100 541S Model Part Number : 24477 Blank Drawing Number: C-24475 Part Name : Trigger Pin, Sear Blank Pin Department : 9291 A. Q. L. : 3 Origination Date : 13-Oct-1988 Effective Date : 06-Aug-1991-08:00:00 Final Appearance : Parts to be clean, free of rust, oiled with light rust-proofing oil (SAE #20 or equivalent). The gross weight of any container must not exceed Packaging 50 pounds. Acceptance Testing: Inspection will be based on statistical sampling according to the Sampling Tables of Mil Std 105D for M/24 and according to Mil Std 105D Modified for all other models. Shipments will be accepted if the quality on each of the gages is sufficient to keep within the Average Outgoing Quality Limit listed.

Process Revision Reasons

Date:	Reason For Revision:	Eng Log #:
202-Aug-1991 Retyped	old paper process last Log 288591	SLW 292043

Process Approval List

*****	Approved	Badge #:	Date:	Designation:

‱Jack	sora	2 22222222		88

Document Number: 24477 Rev:

VAXcamps V2.1 Hardcopy Utility Page: 1 OF 2

TITLE: Trigger Pin, Sear Blank Pin

Process Tools

Type	Number	Use	Max	Min
Visual Mics. Snap Gage	Std. B-80012-U	Free from burrs, .010 x 45 deg chamfer (one end) Color Black 16-Finish Diameter Length	88	.1248 .355

Document Number: 24477

Rev:

VAXcamps V2.1 Hardcopy Utility Page: 2

PROCESS RECORD-INSPECTION

GAUGES		1	<u> </u>	LIM	ITS
TYPE	NUMBER	· .	USE	MAX.	MIN.
Visual		Free of Burrs .010	x 45°Chamfer (Both er	nds)	
		Color-Black			ļ
		l6 Finish			<u> </u>
					<u> </u>
Mics	Std	Diameter		.125	.124
			- Age		<u> </u>
Snap Ga.	B-80024-U	Length	ρ	3 .365	.355
			- wer -	<u> </u>	 _
•					<u> </u>
			0.8 9		
			() J.		<u> </u>
					<u> </u>
					<u> </u>
Final Aupean	rance: Parts to 1 (SAE #20	be clean, free of rust, or equivalent)	oiled with light rust-p	roofing oil	·
Packaging	: The gross	weight of any container	must not exceed 100 lb	g.	
Acceptance			atistical sampling accor		e
	Samplin	g Tables of Bell Telepho	one! Company. Shipments w	111 be accepted if the)
	quality	on each of the gages is uality Limit" listed.	sufficient to keep wit	hin the "Average Out-	
	going Q	uality Limit" listed.		A.Q.L.	5%
ES AND REASONS I	FOR REVISIONS		MATERIAL: AISI C-1095	or A50100 or 52100	
/13/88-Sepera	ate Pt #-ELB-28	8591	HEAT TREATMENT AT: R 45		
			COMPONENT CONDITION:	FINISHED: X SEM	II-FIN.
			MODEL NO. 700, XP100.54	1-S.7LWT.40XCF.721.7	122
			PART NO. 24477		
			BLANK DRAWING NOC-24475		
			PART NAME Trigger Pin		
			0007		
			DEPT. NO. 9291	PAGE 1 OI	7

Transfer Jering

TITLE: Trigger Spring

Process Header

PURCHASED PARTS INSPECTION

Material : Music Wire (Stress relieve) : None Heat Treatment At

Component Condition: Finished X Semi-Fin

Model : 700 40XB 7LWT 24

: 15400 Part Number Blank Drawing Number: A-15400

Part Name : Trigger Spring

Department : 9291 A. Q. L. : 3

: 15-Aug-1963 Origination Date

Effective Date : 27-Sep-1991-08:00:00

: Parts to be clean, free of rust, oiled with light Final Appearance

rust-proofing oil (SAE #20 or equivalent).

Packaging : The gross weight of any container must not exceed

50 pounds.

Acceptance Testing: Inspection will be based on statistical sampling

according to the Sampling Tables of Mil Std 105D for M/24 and according to Mil Std 105D Modified for all other models. Shipments will be accepted if the quality on each of the gages is sufficient to keep within the Average Outgoing Quality Limit listed.

Process Revision Reasons

Date:	Reason For Revision:	Eng Log #:
		##************************************
%0/-mar-1991 Retyped old	paper process last Log 281464	25 LW 22 J 3 3 3 3 3 3 3 3 3 3 3 3 3 3 3 3 3
24-Sep-1991 Added M-24 t	o process	LBF 292179

Process Approval List

Approved By	: Badge	#:	Date:	Designation:
*Jacksora				

Document Number: 15400

Rev:

VAXcamps V2.1 Hardcopy Utility Page: 1

OF

2

TITLE: Trigger Spring

Process Tools

Type Number	Use	Max	Min
Visual	 Do not set for inspection Use suitable equipment Check to inspection and manufacturing data on model dwg. A. Check ends-open ends ground End coil outside diameter not to exceed O.D. of spring Check wind-L.H. 		
Comp. & Std. "V" Block	Check 90 deg. angle of ground ends		

Document Number: 15400

Rev:

VAXcamps V2.1 Hardcopy Utility Page: 2 OF

PROCESS RECORD - INSPECTION

GAUGE S			LIMITS	
TYPE	NUMBER	USE	MAX.	MIN.
		1. Do not set for inspection		
		2. Use suitabel equipment		
		3. Check to inspection and manufacturing data on		
		model drawing		
		a. Check ends-open ends ground		<u> </u>
		b. End coil outside diameter not to exceed O.D. of spring		
	<u> </u>	c. Check wind - L.H.	, 	
		C. CLECK WIND D.II.		
Comparator & stand	dard "Vee" block	- Check 90° angle of ground ends		
	_			<u> </u>
				ļ
	_	- (VIII)	\	
				<u> </u>
				
				
				
	 			
Final Annearan	oas Parte to he	clean free of must oiled with light must proofing oil	L	
Tinal Appearan	(SAE #20 of	clean, free of rust, oiled with light rust-proofing oil equivalent)		
Packaging		weight of any container must not exceed 100 lbs.		
	_	on will be based on statistical sampling according to Mil. S	td. 105 D	
100000000000000000000000000000000000000	-			
i	•			
			A.Q.L.	
DATES AND REASONS FOR	REVISIONS 7/21/	87-New-ELB-287552 MATERIAL: Misic Wire (Stress relieve)		
		HEAT TREATMENT AT: None		
		COMPONENT CONDITION: FINISHED:	X SEM	I-FIN. 5%
		MODEL NO. 700, M/24	·	
	· · · · · · · · · · · · · · · · · · ·	PART NO. 15400		
	······································	BLANK DRAWING NO. A-15400	~ ~~~	
_ 		PART NAME Trigger Spring	1	 -
		DEPT. NO. 007556 PAGE	OF	, 1
RD-6491-1		REMINGTON ARMS CO., INC., ILION, N.Y.		

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- RD-6518 Rev 7/83

PROCESS RECORD AND DATA BASE/ENGINEERING CHANGE NOTICE AUTHORIZATION ENG. CHANGE NO				
TO BE RETURNED) BY	INITIATED DATE		
ROUTE TO	NAME	APPROVAL	DATE	
· ·	1		-	
PE&C SUPERVISOR	Pa On Jeson			
PRODUCTION SUP'R				
PROD. FOREMAN				
	·			
ACCOUNTING			-	
PLANNING	•.			
PURCHASING				
PART NAME Firm	17022 ENGI	JESTED BY	<u> </u>	
DCR(IF ANY) COST REDUCTION/INCREASE DESCRIPTION OF CHANGE AND REASON Letyped from				
old paper &	roces las	1 Log 28455	2	
and m-2	4	<u> </u>		
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			•	
	LASSIFICATION OF C	HANGE		
EFFECTIVITY DATE () PHASE OUT () REGULAR				
DATA CODEDINATO				

PROCESS RECORD-INSPECTION

GAUGES				ITS
TYPE	NUMBER	USE		MIN.
			.440	124
Adj. Snap Gage	B-80024-W	Length overall	.440	.434
Dial Mics.	Spec.	Diameter	.0937	.0935
		Visual 015 x 45° chamfer both ends 16 finish		
		by 1	L	
		181		
		Pot 27 176		
		1		
				ļ
				
Final Appears	ance: Parts to b	e clean, free of rust, oiled with light rust-proofing oil		

(SAE #20 or equivalent)

Packaging : The gross weight of any container must not exceed 100 lbs.

Acceptance Testing: Inspection will be based on statistical sampling according to Mil.Std. 105D

			A	.Q.L. 4.	, 0
DATES AND REASONS FOR REVISIONS 7/14/87-New-FLB-287552	MATERIAL: Mfg. Std.				
	HEAT TREATMENT AT: Vendor				
	COMPONENT CONDITION:	FINISHED:	X	SEMI-FIN	
	MODEL NO. 700. M/24				
	PART NO. 17022				
	BLANK DRAWING NO. B-17022				
	PART NAME Firing Pin Cross	Pin			
	DEPT. NO. 007556	PAGE	1	OF	1
		· · · · · · · · · · · · · · · · · · ·			

RD-4491-1

less spring

PROCESS RECORD DATA BASE/ENGINE CHANGE NOTICE AU TO BE RETURNED	EERING JTHORIZATION	ENG. CHANGE NO.		
TO BE RETURNED	DI			
ROUTE TO	NAME	APPROVAL	DATE	
	.!'			
PE&C SUPERVISOR	I.a. On Jeson	La Jachan	9-27-91	
PRODUCTION SUP'R				
PROD. FOREMAN				
	,			
ACCOUNTING			-	
PLANNING				
PURCHASING	****	·		
MODEL NO. 700 PART NAME Sear PART NUMBER		UESTED BYECR NO	•••••	
DCR(IF ANY) COST REDUCTION/INCREASE DESCRIPTION OF CHANGE AND REASON Letyped from ald paper process last Lag 2 \$7552 add m-24				
			•	
C	LASSIFICATION OF C	HANGE		
EFFECTIVITY DATE _) PHASE OUT () R	EGULAR	
DATA COORDINATION		7 7 7 7		

RD-6491-1

PROCESS RECORD - INSPECTION

GAUGES		{ · · · · · · · · · · · · · · · · · · ·		LIM	its
TYPE	NUMBER	1	USE	MAX.	MIN.
				ļ	ļ
		1. Use suitable equipm	ent	 	
		7. Check to inspection	n and manufacturing data	ļ	
			i did indidiction and and	 	
		on model drawing.		 	
		3. Use ring B-68582-K	to check sten #1 on		
 		model drawing.	to check step 12 on		
		model diaming.	The state of the s	 	
		1	· · · · · ·	 	
			- Water		
			(Put 27		
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			297		
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				 	<u> </u>
]				Ĺ	L
Final Abpearance:	Parts to b (SAE #20 c	e clean, free of rust, or equivalent)	oiled with light rust-proofing oil		
<u>Packaging</u> :	The gross	weight of any container	must not exceed 100 1bs.		
Acceptance Testing	g: Inspecti	ion will be based on sta	itistical sampling according to $^{ m Mil}\cdot$	3td. 105 D	
İ	-				
l			· · · · · · · · · · · · · · · · · · ·	·····	
		·	·	A.Q.L,	2.5
DATES AND REASONS FOR REVI	SIONS 7/16/	87-New-287552	MATERIAL: Music Wire		
			HEAT TREATMENT AT: None	X QFM	
			COMPONENT CONDITION: FINISHED:	A SEM	I-FIN.
			MODEL NO. 700, M/24 PART NO. 17047		
			BLANK DRAWING NO. A-17047		
			PART NAME Sear Spring		
			DEPT. NO. 007556 PAGE	1 OF	. 1
		·			

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

TITLE: Sear Spring

Process Header

PURCHASED PARTS INSPECTION

Material : Music Wire

Heat Treatment At : None

Component Condition : Finished X Semi-Fin

Model : 600 700 40XB 7LWT SP10 Mag. 24

Part Number : 17047
Blank Drawing Number: A-17047
Part Name : Sear Spring
Department : 9291

A. Q. L. : 3

Origination Date : 28-Mar-1963

Effective Date : 27-Sep-1991-08:00:00

Final Appearance : Parts to be clean, free of rust, oiled with light

rust-proofing oil (SAE #20 or equivalent).

Packaging : The gross weight of any container must not exceed

50 pounds.

Acceptance Testing: Inspection will be based on statistical sampling

according to the Sampling Tables of Mil Std 105D for M/24 and according to Mil Std 105D Modified for all other models. Shipments will be accepted if the quality on each of the gages is sufficient to keep within the Average Outgoing Quality Limit listed.

Process Revision Reasons

Date:	Reason For Revision:	Eng Log #:
214-Jun-1991 Retyped	old paper process last Log 288483	SLW 291823
25-Sep-1991 Added M-2	24 to process	ELBF292187

Process Approval List

Approved By:	Badge #:	Date:	Designation:
<pre>#Jacksora</pre>			***************************************

Document Number: 17047

Rev:

VAXcamps V2.1 Hardcopy Utility

Page: 1

OF

2

TITLE: Sear Spring

Process Tools

Туре	Number	Use	Max	Min
Visual Ring Gage	B-51000-L	Free of defects Inspection 1. Work freely in hole 2. Work freely on pin	.151 	
Elasticometer	Inv#28459	Procedure for removing set; Compress to solid and hold for 24 hrs. or bump set 25 times 3. Load 6.0 to 6.8 lbs. at .330 (L1) (With set) Load to (L2) (Removed)		
Calipers	std.	4. Solid height 5. Free length 6. Ends-Squared & Ground 7. Wind: Right Hand 8. Remove Set; DO NOT REMOVE SET NoTE: EXCEPT FOR INSPECTION	.303	.460

Document Number: 17047 Rev:

VAXcamps V2.1 Hardcopy Utility Page: 2 OF 2

100

PROCESS RECORD-INSPECTION

GAUGES					LIMITS	
TYPE	NUMBER	USE		MAX.	MIN.	
		1. Use suitable equipm	nent			
				I	L	
	<u> </u>	l	n and manufacturing data		<u> </u>	
		on model drawing.		ļ		
				 	<u> </u>	
		3. Use ring B-68582-K	to check step #1 on		<u> </u>	
		model drawing.	- Hay		ļ	
	ļ		al ~ (l	ļ	
	 		1000	}		
	<u> </u>		7.08	 	ļ	
	 		(1.4) 18 1	 	 	
	 		2921	<u> </u>		
			4			
	 					
	·					
Final Appearan	ce: Parts to be (SAE #20 or	e clean, free of rust, requivalent)	oiled with light rust-proofing oil			
<u>Packaging</u>	: The gross	weight of any container	must not exceed 100 lbs.			
Acceptance Tes			atistical sampling according to Mil.	Std. 105 D		
	-	••				
	•		·-			
	 	· · · · · · · · · · · · · · · · · · ·		A.Q.L.	2.5	
DATES AND REASONS FOR	REVISIONS 7/16/8	37-New-287552	MATERIAL: Music Wire			
			HEAT TREATMENT AT: None			
	····		COMPONENT CONDITION: FINISHED:	A SEM	I-FIN,	
			MODEL NO. 700, M/24 PART NO. 17047			
			BLANK DRAWING NO. A-17047			
			PART NAME Sear Spring			
			DEPT. NO. 007556 PAGE	1 OF	, 1	
			PAGE	<u> </u>		
	-					

xc:

W.H. Coleman, II/File K.W. Soucy

K.W. Soucy H.C. Munson L.B. Bosquet F.E. Martin

<u>File</u>

RESEARCH TEST AND MEASUREMENT REPORT

REPORT# 902271 W.O.# 481152 NOVEMBER 5, 1990

MODEL 700 7x64 CALIBER DESIGN ACCEPTANCE

ABSTRACT:

Research and Development finds the Design Acceptance Evaluation of the Model 700 rifle in 7x64 caliber to be acceptable. The evaluation consisted of Accuracy, Field Function and High Pressure Strength.

Prepared by: D.R. Thomas
Date Prepared: November 5, 1990

proofread and cleared by:

F.E. Martin Designer

J.R. SNEDEKER Staff Engineer

W.H. COLEMAN, II New Products Research Lab Director Jud E. Wartin 29 Nov'90

TO: J.R. Snedeker FROM: D.R. Thomas

INTRODUCTION:

In August of 1990 a request to conduct a Design Acceptance Evaluation of the Model 700 Rifle in 7x64 caliber was received by the Test Lab. The evaluation used six rifles and consisted of Accuracy, Field Function and High Pressure Strength.

SCOPE OF THE TEST:

To determine if the 7×64 caliber sample would meet the Remington Specifications for accuracy, field function and strength.

TEST RESULTS: ACCURACY:

The average group size was 1.79 inches well within the 3.2 inch specification.

FIELD FUNCTION:

Six rifles were each field tested with 100 rounds of Norma 150 gn. ammunition. There were no malfunctions in the 600 rounds fired.

STRENGTH:

One rifle with a plugged bore was subjected to a high pressure round. The resulting damage was typical of all Model 700 rifles subjected to this test.

REPORT TEXT: GENERAL:

and an experience of the second

The following six rifles were used for the Design Acceptance Evaluation:

C6563003 C6562997 C6563032 C6562914 C6563108 C6562918

ACCURACY:

All six rifles were used in the accuracy test.

Norma 7X64, 150gn. Soft Point No. 17013, lot# 02723 was used for accuracy testing.

A Lyman "All American" 20% scope was used.

Accuracy results per individual rifle are located in the appendix of this report.

FIELD FUNCTION:

All six rifles were used in the Field Function Test.

The rifles were fired 100 rounds each in the Field Function Test conducted at the Ilion Fish and Game Club.

Norma 7X64, 150 gn. Soft Point No. 17013, lot# 02723 was the only ammunition available for field testing.

STRENGTH:

Rifle C6562918 was used for the high pressure strength test. The high pressure load consisted of 50gns. of 4227 powder and a 175 gn. bullet.

TEST PROCEDURE:

ACCURACY:

Three, five shot groups were shot with each of the six rifles. The accuracy was shot by J.E. Selan in the Research and Development 100 yard range located in building 52-1A.

Norma 150 gn. soft point ammunition code 17013 lot# 02723 was used for the accuracy testing.

Standard long action Leupold bases and rings were used in conjunction with a 20% All-American Lyman scope.

The targets were analyzed for group size using the HP 9000 computer and digitizing tablet.

FIELD FUNCTION:

The rifles were subjected to the loading and firing of 100 rounds of Norma 150 gn. soft point ammunition in a field function test conducted at the Ilion Fish and Game Club.

A round robin method of shooting, alternating shooters every ten rounds, was used throughout the field function testing.

The guns were allowed to air cool every 20 rounds.

STRENGTH:

Four bullets were lodged in the bore of rifle # C6562918.

A high pressure round was developed using the reloading and P&V facilities.

The high pressure round was fired in the "Iron Lung" in the measurement lab.

Estimated pressure for the destructive load fired in an unobstructed Barrel is 130,000 psi. Pressure generated in the plugged bore is much higher.

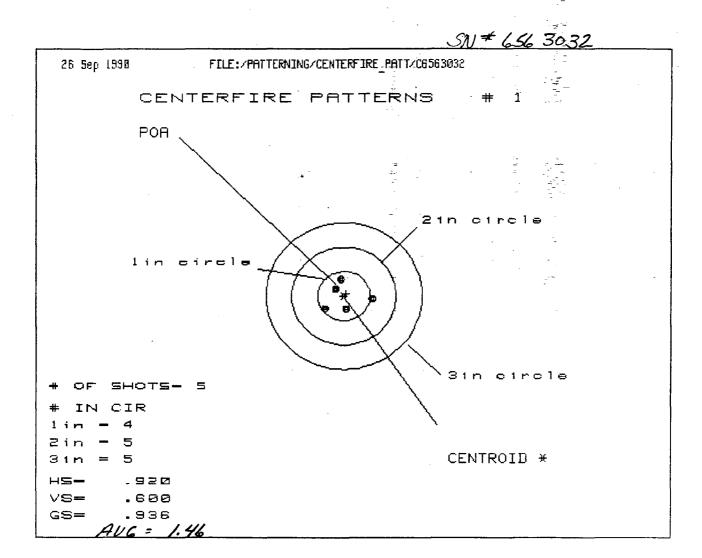
APPENDIX

100 YARD ACCURACY RESULTS

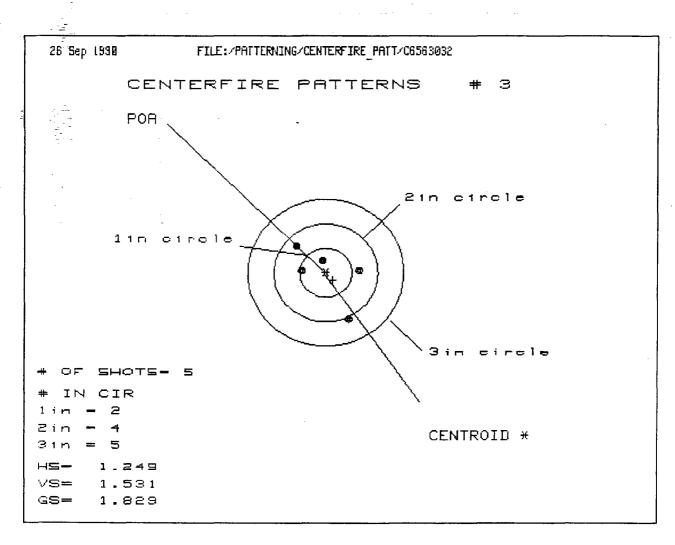
SERIAL NUMBER	GROUP 1 (in.)	GROUP 2 (in.)	GROUP 3 (in.)	AVERAGE (in.)
C6563032	0.94	1.83	1.61	1.46
C6562918	1.87	1.90	1.98	1.92
C6563108	2.26	2.19	1.85	2.10
C6563003	1.51	2.68	1.60	1.93
C6562914	2.11	1.80	1.33	1.75
C6562997	2.03	1.27	1.41	1.57

RESEARCH TEST & MEASUREMENT LAB WORK REQUEST

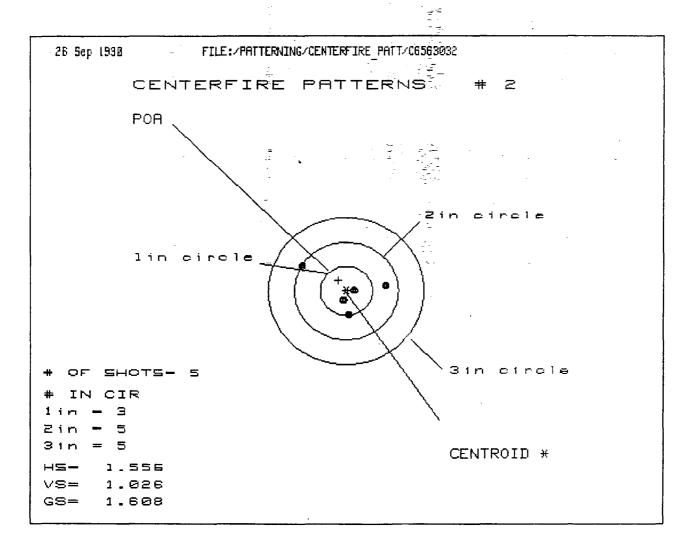
AREA OF TESTING					
Developmental	Sefety Releted	Litigation			
N Design Acceptance	Competitive Evalu	vetion Werehouse Audit			
Pre-Pilot	New Design	Cost Reduction			
Pliot	Design Change	Stake			
Production Acceptance	Plant Assistance	X Other New CALIBER			
FIREARM STAT'S.	REPORT REQ'D.				
MODEL: M 200	CORMAI	DATE REQUESTED: 8-15-90			
CAL or GAGE: 7x 64	FORMAL	DATE NEEDED BY: #8 4P			
BARREL TYPE: CWT	TEST RESULTS	REQUESTED BY: F. MARTIN			
PROOFED: YESNOX	ONLY X	WORK ORDER NO: 118 - 48 1155			
	TEST TYPE				
Strength Test Ammunitie	on Test Dry Cycle T	est Photo/Video			
Function Test Environme	intal Test Measuremen	Other			
Accuracy Test Customer (Compleint Endurance 1	Tett			
EXPLAIN IN DETAIL THE REASON FOR T	HISTEST: 6 Guns	Supplies For			
Field Function 3x5 Per Gu	100 40	Requestor			
FIELD FUNCTION	AND 100 gp	, The will a			
3x5 Per Gu	n				
• .					
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GUNS REQUIRED:					
NOTE: NO fireerms or perts will be tested in	•	DATE COMPLETED:			
eccompanied by a Work Request, and	1	TEST COMPLETED BY:			
the Labs by the designer or engineer.		REPORT DATE:			
to be filled out in detail. No Exception	no. Salar de la companya del companya del companya de la companya				



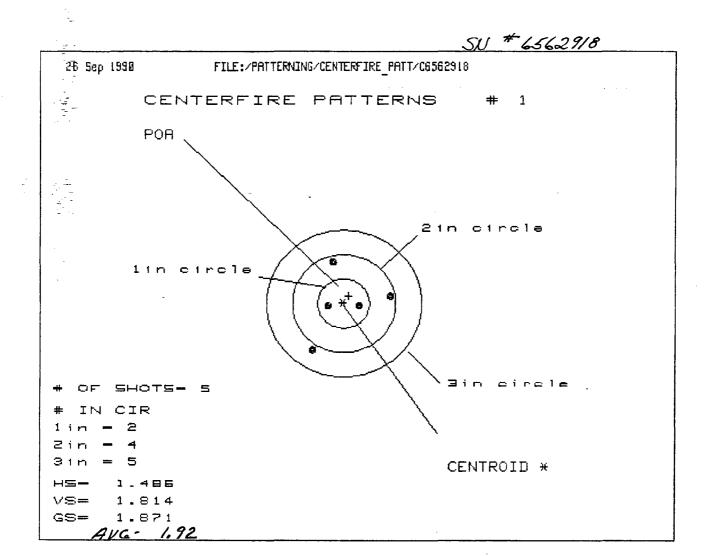
PATTERN #	:	1			
SHOTS (BEST OF)	:	5	4	3 m· 700 ·	7 X64
MAXIMUM X	:	.536	.128 ·	.045 Ammo:	. NORMA
MINIMUM X	:	384	250	068 /56 GR.	
MAXIMUM Y	:	.376	.366	.291 INDEX	174 13
MINIMUM Y	:	224	234	309 Zor -	02723
CENTROID X	:	~.037	171	088 SCOPE	LYMAN
CENTROID Y	:	047	037	.038	
POR TO CENTROID in	. :	.060	.175	.095 ALL AR	MERICAN · 20 · X
MIN RADIUS	:	.157	.093	.070 LEUPOLD	BASE & RINGS
MEAN RADIUS	:	.347	.269	.225 RANGE-	100 YDS.
MAX RADIUS	:	.538	.381	.312	, 55 , 55 ,
HORIZONTAL SPREAD	:	.920	.378	.113 REST.	SAND BAG.
VERTICAL SPREAD	:	.600	.600	.600	
EXTREME SPREAD	:	.936	.690	.600	
NUMBER IN ONE IN	ICH CIRCLI	E =	4		
NUMBER IN TWO IN	CH CIRCL	E ≂	5		
NUMBER IN THREE IN	CH CIRCL	E =	5		



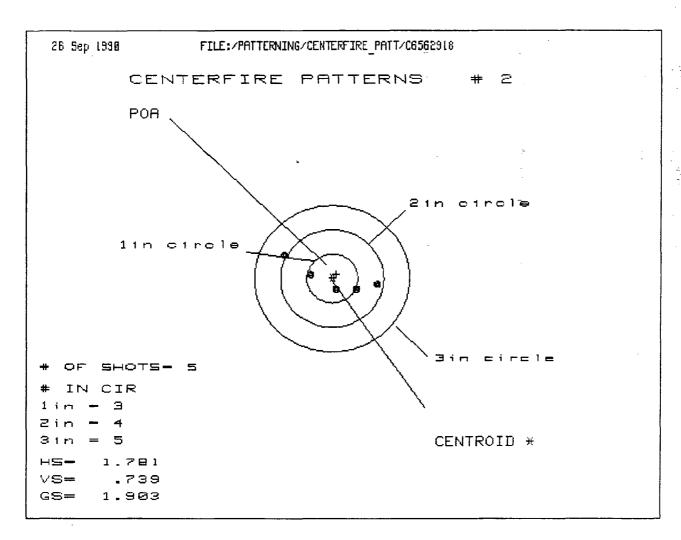
PHTTERN #	: (3		
SHOTS (BEST OF)	:	5	4	3
MAXIMUM X	:	.656	.758	.594
MINIMUM X	:	593	491	476
MAXIMUM Y	:	.544	.297	.139
MINIMUM Y	:	987	176	077
CENTROID X	:	136	237	074
CENTROID Y	:	.148	.395	.296
POR TO CENTROID in	. :	.201	.461	.305
MIN RADIUS	:	. 292	.061	.182
MEAN RADIUS	:	.650	.441	.420
MAX RADIUS	:	1.068	.778	.599
HORIZONTAL SPREAD	:	1.249	1.249	1.070
VERTICAL SPREAD	:	1.531	.473	.216
EXTREME SPREAD	:	1.829	1.336	1.070
NUMBER IN ONE IN	CH CIRCLE	=	2	
NUMBER IN TWO IN	OH CIRCLE	=	4	
NUMBER IN THREE IN	CH CIRCLE	=	5	



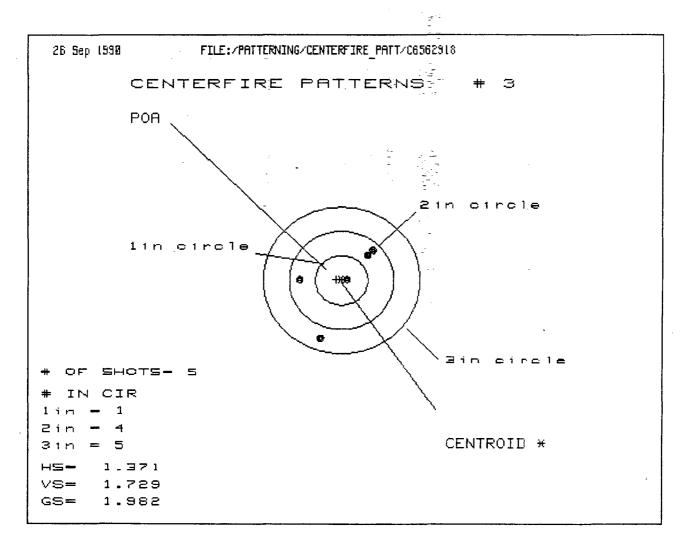
PATTERN #	:	2		
SHOTS (BEST OF)	:	5	4	3
MAXIMUM X	:	.739	.535	.074
MINIMUM X	:	817	233	055
MAXIMUM Y	:	.545	.277	.220
MINIMUM Y	:	481	344	252
CENTROID X	:	.151	.355	. 177
CENTROID Y	:	215	352	444
POA TO CENTROID in	. :	.263	.500	.478
MIN RADIUS	:	.101	.165	.063
MEAN RADIUS	:	.503	.351	.183
MAX RADIUS	:	.982	.602	.253
HORIZONTAL SPREAD	:	1.556	.768	.129
VERTICAL SPREAD	:	1.026	.621	.472
EXTREME SPREAD	:	1.608	.961	.481
NUMBER IN ONE INC	CH CIRCLE	=	3	
NUMBER IN TWO IN	CH CIRCLE	=	5	
NUMBER IN THREE IN	CH CIRCLE	=	5	



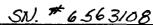
PATTERN #	:	1		
				m. 760. 7X64
SHOTS (BEST OF)	:	5	4	3
MAXIMUM X	:	.866	.711	·605 AMMO: NORMA
MINIMUM X	:	620	492	598 /50 CR. SP. SPIRE PT.
MAXIMUM Y	:	.877	.643	.128 -NOEX /70/3
MINIMUM Y	:	937	318	104 LOT - 02723
CENTROID X	:	098	.057	.163 SCOPE: LYMAN
CENTROID Y	:	155	.079	135 ALL AMERICAN - 20X
POA TO CENTROID i	n.:	.183	.098	.212 LEUPOLD BASE & RINGS
MIN RADIUS		.267	.333	104
MEAN RADIUS		.700	.578	184 RANGE - 100 YDS.
MAX RADIUS	•	1.123	.717	646
HORIZONTAL SPREAD	:	1.486	1.203	.618 <u>REST</u> : . SAND BAG.
VERTICAL SPREAD	_	1.814	.961	.232
EXTREME SPREAD	-			
		1.871	1.260	1.213
NUMBER IN ONE I	NOH CIRC	LE =	2	
NUMBER IN TWO I	NCH CIRC	LE =	4	
NUMBER IN THREE I	NCH CIRC	LE =	5	

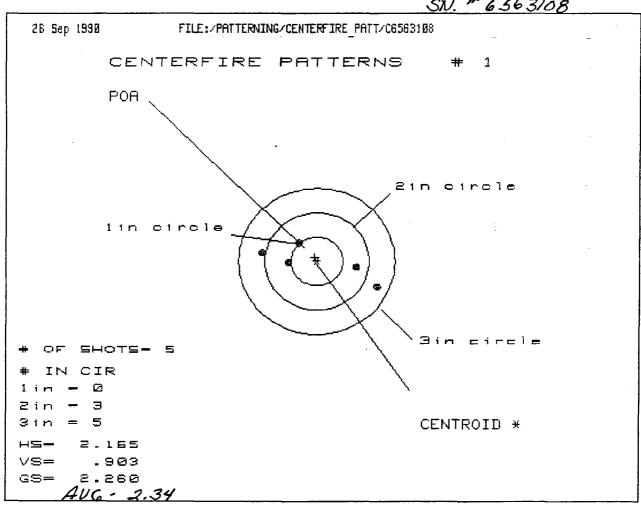


PATTERN #	: [2		
SHOTS (BEST OF)	:	5	4	3
MAXIMUM X	:	.879	.654	.440
MINIMUM X	:	902	685	467
MAXIMUM Y	:	.509	.220	.209
MINIMUM Y	: .	230	103	114
CENTROID X	:	072	.153	065
CENTROID Y	:	084	211	200
POA TO CENTROID in.	:	.111	.261	.210
MIN RADIUS	:	.233	.217	.117
MEAN RADIUS	:	.625	.457	.360
MAX RADIUS	:	1.035	.720	.511
HORIZONTAL SPREAD	:	1.781	1.339	.907
VERTICAL SPREAD	:	.739	.323	.323
EXTREME SPREAD	:	1.903	1.363	.956
NUMBER IN ONE INC	H CIRCLE	=	3	
NUMBER IN TWO INC	H CIRCLE	=	4	
NUMBER IN THREE INC	H CIRCLE	=	5	· ·

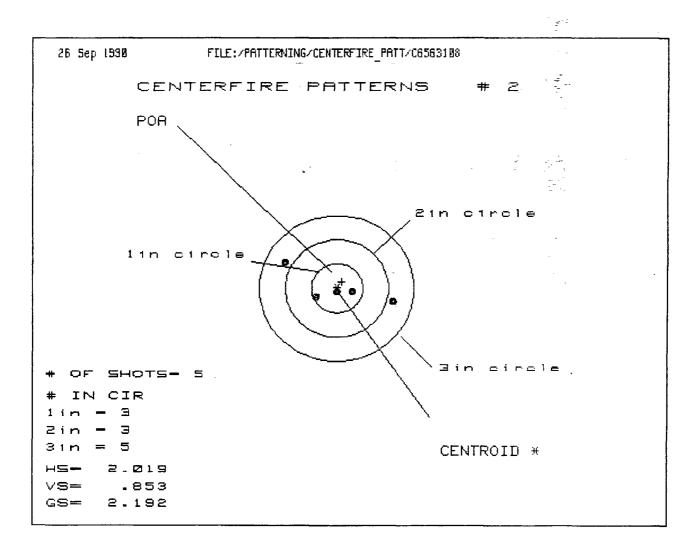


PATTERN # :	3		
SHOTS (BEST OF) :	5	4	3
MAXIMUM X :	.605	.514	.547
MINIMUM X :	766	857	686
MAXIMUM Y :	.594	.310	.369
MINIMUM Y :	-1.135	295	192
CENTROID X :		.192	.021
CENTROID Y :	018	.266	.163
POA TO CENTROID in.:	.103	.328	.164
MIN RADIUS :	.059	.297	.237
MEAN RADIUS :	.717	.565	.535
MAX RADIUS :	1.192	.902	.708
HORIZONTAL SPREAD :	1.371	1.371	1.233
VERTICAL SPREAD :	1.729	.605	.561
EXTREME SPREAD :	1.982	1.493	1.348
NUMBER IN ONE INCH	CIRCLE =	1	
NUMBER IN TWO INCH	CIRCLE =	4	
NUMBER IN THREE INCH	CIRCLE =	5	

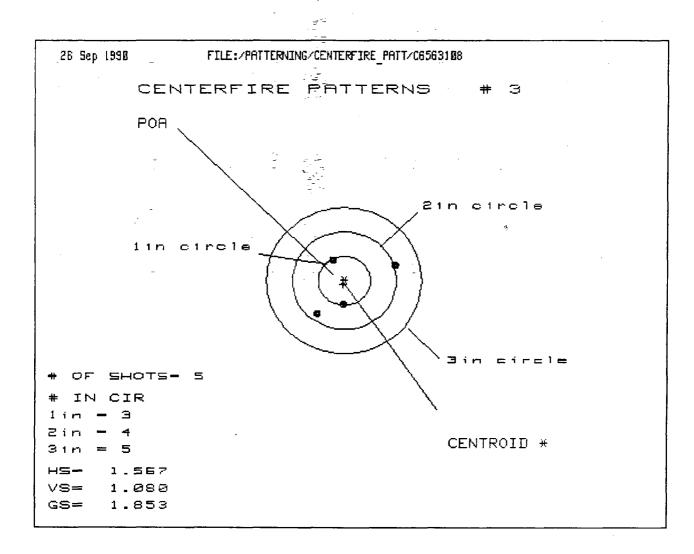




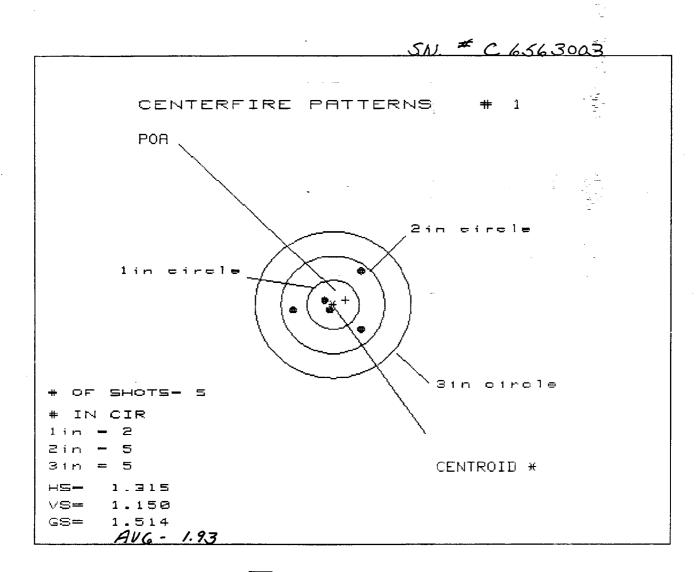
PATTERN # :	1			
SHOTS (BEST OF) :	5	4	• • • •	100 - 7 X 6 4.
MAXIMUM X :	1.158	1.085	.845 <i>A</i>	MMO: NORMA
MINIMUM X :	-1.007	718	~ 512	SOGR. SP. SPIRE PT.
MAXIMUM Y :	.414	.292	205	DEX - 176/3
MINIMUM Y :	489	196	183 Z	
CENTROID X :	~ .045	244	005 cca	
CENTROID Y :	082	.040	0.27 	PE - LYMAN II AMERICAN : 20X
POA TO CENTROID in.:	.094	.248	666	UPOLD BASE & RINGS.
MIN RADIUS :	.563	.305	A E 1	NEE- 100 YDS
MEAN RADIUS :	.840	.608	.614	<u>VEE - 100 9D3</u>
MAX RADIUS :	1.257	1.102	.865 <i>RES</i>	T. SAND BAG
HORIZONTAL SPREAD :	2.165	1.802	1.358	-
VERTICAL SPREAD :	.903	.488	.488	
EXTREME SPREAD :	2.260	1.817	1.359	
NUMBER IN ONE INCH	CIRCLE =	0		
NUMBER IN TWO INCH	CIRCLE =	3		
NUMBER IN THREE INCH	CIRCLE =	5		



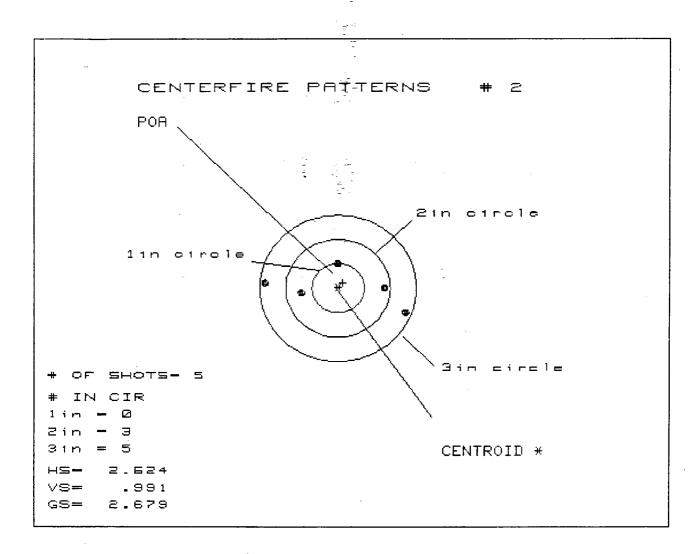
PATTERN # :	2		
SHOTS (BEST OF) :	5	4	3
MAXIMUM X :	1.046	.802	.353
MINIMUM X :	- . 973	643	375
MAXIMUM Y :	.568	.101	.054
MINIMUM Y :	285	143	058
CENTROID X :	091	.153	115
CENTROID Y :	133	275	228
POA TO CENTROID in.:	.161	.315	.255
MIN RADIUS :	.090	.132	.023
MEAN RADIUS :	.612	.460	.253
MAX RADIUS :	1.127	.815	.380
HORIZONTAL SPREAD :	2.019	1.445	.728
VERTICAL SPREAD :	. 85 3	.244	.112
EXTREME SPREAD :	2.192	1.451	.737
NUMBER IN ONE INCH	CIRCLE =	3	
NUMBER IN TWO INCH	CIRCLE =	3	
NUMBER IN THREE INCH	CIRCLE =	5	



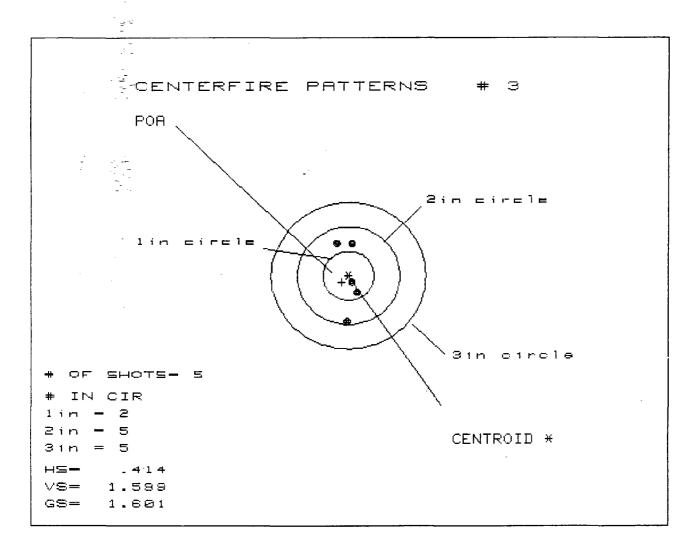
PATTERN #	3		
SHOTS (BEST OF)	5	4	3
MAXIMUM X	1.021	.201	.104
MINIMUM X	5 46	290	058
MAXIMUM Y :	.410	.489	.293
MINIMUM Y :	670	591	556
CENTROID X :	~.023	233	136
CENTROID Y :	.076	003	.193
POA TO CENTROID in.:	.079	.233	.236
MIN RADIUS :	.432	.412	.268
MEAN RADIUS :	.65 5	.506	.377
MAX RADIUS :	1.070	.658	.566
HORIZONTAL SPREAD :	1.567	.491	.162
VERTICAL SPREAD :	1.080	1.080	.849
EXTREME SPREAD :	1.853	1.129	.864
NUMBER IN ONE INCH	CIRCLE =	3	
HUMBER IN TWO INCH	CIRCLE =	4	
NUMBER IN THREE INCH	CIRCLE =	5	



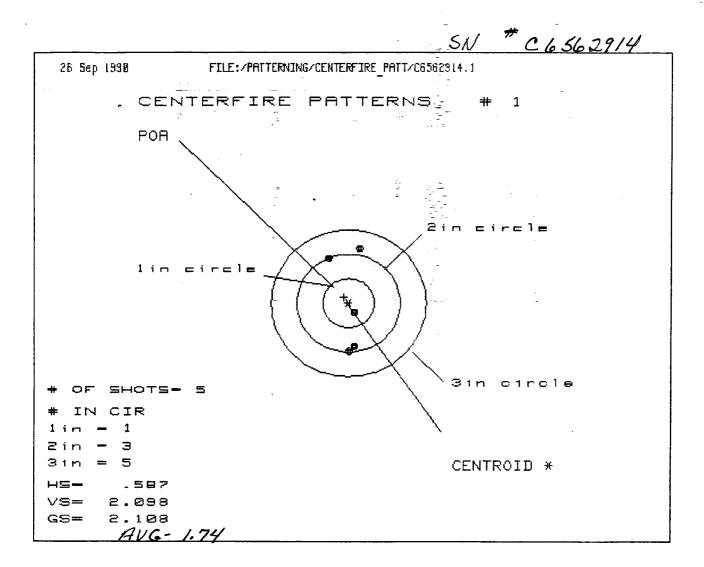
PATTERN #	:	1			
SHOTS (BEST OF)	:	5	4	3	m.700. 7464
MAXIMUM X	:	.546	.658	.447	AMMS: NORMA
MINIMUM X	:	769	633	286	Market 100 Com
MAXIMUM Y	:	.662	.227	.253	156 GR. S.P. SPIRE PT.
MINIMUM Y	:	488	323	297	INDEX - 17013
CENTROID X	:	<i>-</i> .235	371	160	LDT - 02723
CENTROID Y	:	094	259	285	SCOPE - LYMAN
POA TO CENTROID i	n.:	.253	.453	.327	ALL AMERICAN - 20 X
MIN RADIUS	:	.171	.053	.168	LEUPOLD RINGS & BASES
MEAN RADIUS	:	.548	.416	.362	
MAX RADIUS	:	.858	.733	.537	RANGE - 100 YDS
HORIZONTAL SPREAD	:	1.315	1.291	.733	REST. SAND BAG
VERTICAL SPREAD	:	1.150	.550	.550	
EXTREME SPREAD	:	1.514	1.352	.916	
NUMBER IN ONE I	NCH CIRCLE	=	2		
NUMBER IN TWO I	NCH CIRCLE	=	5		
NUMBER IN THREE I	NCH CIRCLE	=	5		



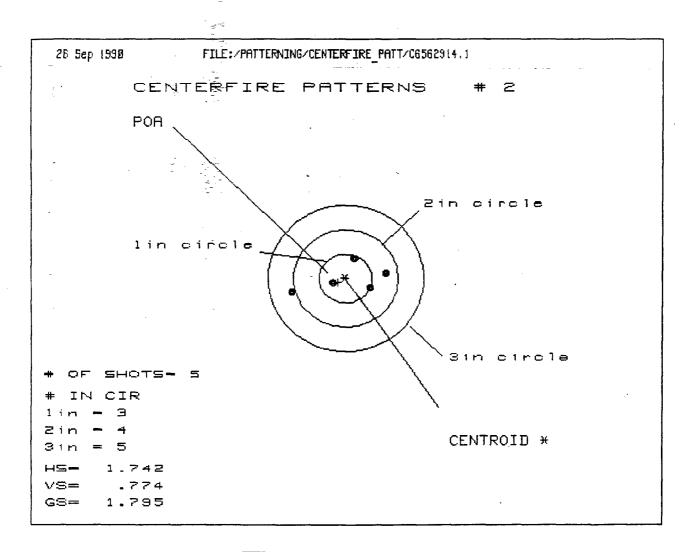
PATTERN # :	2		
SHOTS (BEST OF) :	5	4	3
MAXIMUM X :	1.253	.910	.837
MINIMUM X :	-1.371	-1.056	752
MAXIMUM Y :	.514	.529	.376
MINIMUM Y :	477	461	226
CENTROID X :	<i>.</i> −.093	.249	054
CENTROID Y :	106	121	.032
POA TO CENTROID in.:	.141	.278	.063
MIN RADIUS :	.516	.534	.385
MEAN RADIUS :	.965	.817	.674
MAX RADIUS :	1.372	1.058	.850
HORIZONTAL SPREAD :	2.624	1.966	1.589
VERTICAL SPREAD :	.991	.991	.602
EXTREME SPREAD :	2.679	2.004	1.591
NUMBER IN ONE INCH	CIRCLE =	0	
NUMBER IN TWO INCH	CIRCLE =	3	
NUMBER IN THREE INCH	CIRCLE =	5	



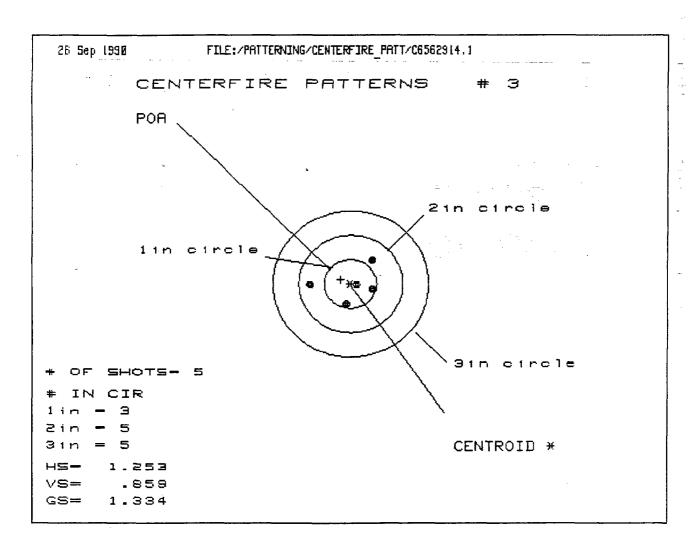
PATTERN #	:	3		
SHOTS (BEST OF)	:	5	4	3
MAXIMUM X	:	.176	.171	.090
MINIMUM X	:	238	243	063
MAXIMUM Y	:	.699	.474	.627
MINIMUM Y	:	900	595	442
CENTROID X	:	.135	.140	.221
CENTROID Y	:	.132	.357	.204
POA TO CENTROID in	n.:	.189	.384	.301
MIN RADIUS	:	.129	.344	.188
MEAN RADIUS	:	.573	.489	.423
MAX RADIUS	:	.900	.619	.631
HORIZONTAL SPREAD	:	.414	.414	.153
VERTICAL SPREAD	:	1.599	1.069	1.069
EXTREME SPREAD	:	1.601	1.134	1.080
NUMBER IN ONE II	NOH CIRCLE	=	2	
NUMBER IN TWO II	NCH CIRCLE	=	5	
NUMBER IN THREE IN	NCH SIRCLE	=	5	



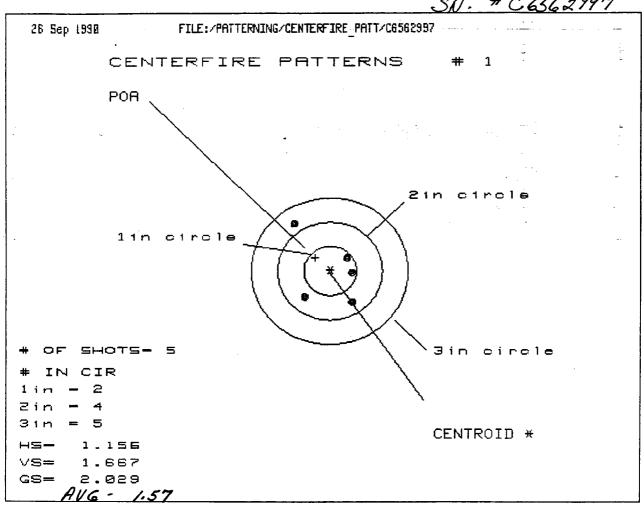
PATTERN #	:	1			
SHOTS (BEST OF)	:	5	4	3	m.700. 7x64
MAXIMUM X	:	.185	.168	.050	Ammo. NORMA.
MINIMUM X	:	402	356	091	THE TOURS TOURS
MAXIMUM Y	:	1.104	1.244	.493	156GR. SP. SPIRE PT.
MINIMUM Y	:	994	718	304	INDEX- 17013
CENTROID X	:	.090	.044	.162	107 - 02723
CENTROID Y	:	119	395	809	
POA TO CENTROID	in.:	.149	.397	.825	SCOPE. LYMAN
MIN RADIUS	:	.232	.186	.194	ALL AMERICAN. 20X
MEAN RADIUS	:	.856	.706	.336	LEUPOLD · RINGS & BASES
MAX RADIUS	:	1.119	1.294	.496	RANGE - 100 YOS
HORIZONTAL SPREA	D:	.5 87	.524	.141	KANGE - 100 103
VERTICAL SPREA	D:	2.098	1.962	.797	REST. SAND BAG
EXTREME SPREA	D:	2.108	1.999	.809	
NUMBER IN ONE	INCH CIR	:CLE =	1		
NUMBER IN TWO	INCH CIR	CLE =	3		
NUMBER IN THREE	INCH CIR	CLE =	5		



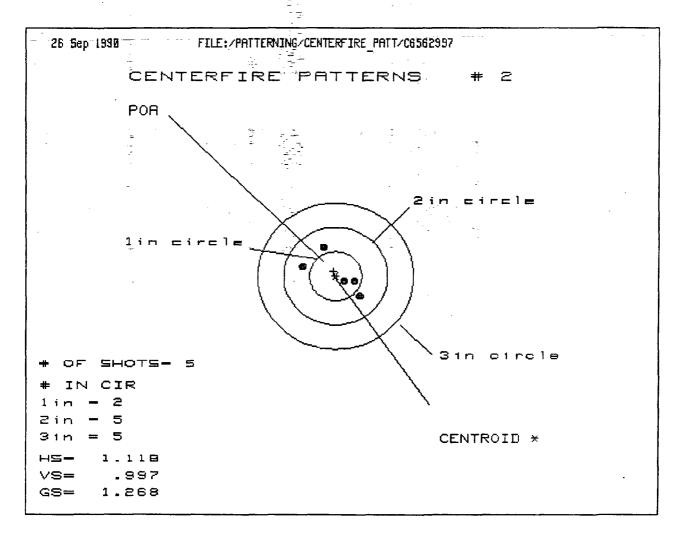
PATTERN # :	2		
SHOTS (BEST OF) :	5	4	3
MAXIMUM X :	.720	.465	.335
MINIMUM X :	-1.022	525	370
MAXIMUM Y :	.456	.376	.388
MINIMUM Y :	318	277	265
CENTROID X :	139	.394	.239
CENTROID Y :	.081	.161	.149
POA TO CENTROID in.:	.161	.426	.281
MIN RADIUS :	.275	.330	.390
MEAN RADIUS :	.606	.433	.402
MAX RADIUS :	1.070	.542	.427
HORIZONTAL SPREAD :	1.742	.990	.705
VERTICAL SPREAD :	.774	.653	.653
EXTREME SPREAD :	1.795	1.005	.719
NUMBER IN ONE INCH	CIRCLE =	3	
NUMBER IN TWO INCH	CIRCLE =	4	
NUMBER IN THREE INCH	CIRCLE =	5	



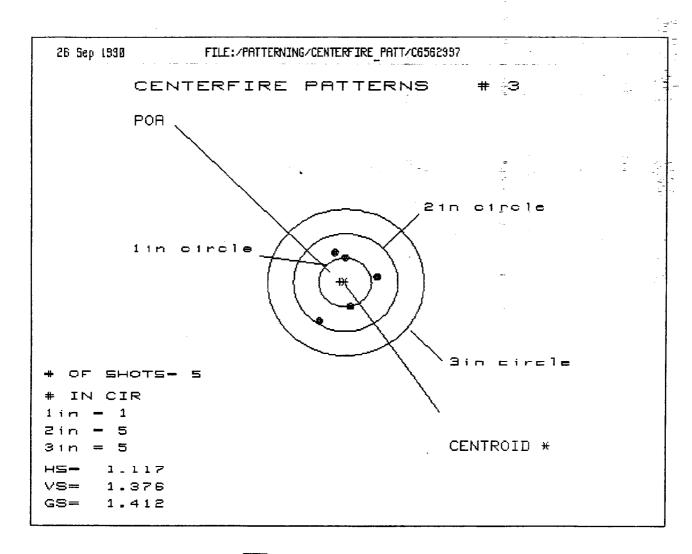
PATTERN #	:	3		
SHOTS (BEST OF)	:	5	4	3
MAXIMUM X	:	.425	.218	.247
MINIMUM X	:	828	341	268
MAXIMUM Y	:	.488	. 496	.145
MINIMUM Y	1 .	371	363	198
CENTROID X	:	~.186	.393	.320
CENTROID Y	:	090	098	263
POA TO CENTROID in.	:	.207	.405	.414
MIN RABIUS	:	.158	.056	.147
MEAN RADIUS	:	.485	.326	.244
MAX RADIUS	:	.828	.542	.333
HORIZONTAL SPREAD	:	1.253	.559	.515
VERTICAL SPREAD	:	.859	.859	.343
EXTREME SPREAD	:	1.334	1.025	.573
NUMBER IN ONE INC	H CIRCLE	=	3	
NUMBER IN TWO INC	H CIRCLE	=	5	
NUMBER IN THREE INC	H CIRCLE	=	5	



PATTERN #	:				
SHOTS (BEST OF)	:	5	4	3	m-700. 7x64
MAXIMUM X	:	.466	.293	.320	AMMO: NORMA
MINIMUM X	:	690	616	518	150 GR. SP. SPIRE PT.
MAXIMUM Y	:	1.014	.515	.382	INDEX 170/3
MINIMUM Y		- <u>.</u> 653	399	455	LOT - 02723
CENTROID X	•	.282	.455	.357	SCOPE. LYMAN
CENTROID Y	:	272	526	393	ALL AMERICAN - 20X
POA TO CENTROID i	n.:	.392	.695	.531	LEUPOLD RINGS & BASE
MIN RADIUS	:	.378	.304	.328	
MEAN RADIUS	:	.706	.505	.483	RANGE - 100 YOS.
MAX RADIUS	:	1.227	.695	.690	
HORIZONTAL SPREAD	:	1.156	.909	.838	REST · SAND BAG.
VERTICAL SPREAD	:	1.667	.914	.837	
EXTREME SPREAD	:	2.029	1.101	1.101	
NUMBER IN ONE I	NCH CIRCLE	=	2		
NUMBER IN TWO I	NCH CIRCLE	=	4		
NUMBER IN THREE I	NCH CIRCLE	=	5		



PATTERN # :	2		
SHOTS (BEST OF) :	5	4	3
MAXIMUM X :	.465	.301	.280
MINIMUM X :	653	435	335
MAXIMUM Y :	.556	.596	.462
MINIMUM Y :	441	402	245
CENTROID X :	.037	.201	.100
CENTROID Y :	096	136	002
POR TO CENTROID in.:	.103	.242	.100
MIN RADIUS :	.170	.094	.223
MEAN RADIUS :	.495	.386	.389
MAX RADIUS :	.672	.738	570
HORIZONTAL SPREAD :	1.118	.737	.615
VERTICAL SPREAD :	.997	.997	.707
EXTREME SPREAD :	1.268	1.240	.937
NUMBER IN ONE INCH	CIRCLE =	2	
NUMBER IN TWO INCH	CIRCLE =	5	
NUMBER IN THREE INCH	CIRCLE =	5 .	



PATTERN #	:	3		
SHOTS (BEST OF)	:	5	4	3
MAXIMUM X	:	.614	.488	.384
MINIMUM X	:	503	314	209
MAXIMUM Y	:	.607	.414	.474
MINIMUM Y	:	769	644	506
CENTROID X	:		.223	.327
CENTROID Y	:	014	.179	.041
POA TO CENTROID in	. 1	.098	.286	.330
MIN RADIUS	:	.455	.352	.385
MEAN RADIUS	:	.632	.505	.479
MAX RADIUS	:	.919	.648	.535
HORIZONTAL SPREAD	:	1.117	.802	.593
VERTICAL SPREAD	:	1.376	1.058	.980
EXTREME SPREAD	:	1.412	1.086	.981
NUMBER IN ONE IN	CH CIRCLE	=	1	
NUMBER IN TWO IN	CH CIRCLE	=	5	
NUMBER IN THREE IN	CH CIRCLE	=	5	