

700-24

292178

Safety District Spring

PROCESS RECORD AND  
DATA BASE/ENGINEERING  
CHANGE NOTICE AUTHORIZATION

PROCESS CHANGE NO. 292178

ENG. CHANGE NO. \_\_\_\_\_

TO BE RETURNED BY \_\_\_\_\_

INITIATED DATE \_\_\_\_\_

ROUTE TO	NAME	APPROVAL	DATE
PE&C SUPERVISOR	<i>R.L. Jackson</i>	<i>R. Jackson</i>	<i>9-25-91</i>
PRODUCTION SUP'R			
PROD. FOREMAN			
ACCOUNTING			
PLANNING			
PURCHASING			

MODEL NO. 700-24 ENGINEER \_\_\_\_\_  
 PART NAME Safety Interst Spig. REQUESTED BY SLW  
 PART NUMBER 15368 ECR NO. \_\_\_\_\_

DCR (IF ANY) \_\_\_\_\_ COST REDUCTION/INCREASE

DESCRIPTION OF CHANGE AND REASON

*Retyped from*  
*old paper process last Log 288052*  
*Add M-24*

## CLASSIFICATION OF CHANGE

EFFECTIVITY DATE \_\_\_\_\_ ( ) PHASE OUT ( ) REGULAR

DATA COORDINATOR \_\_\_\_\_

DATE \_\_\_\_\_

## PROCESS RECORD - INSPECTION

[illegible]

**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 Mil Std. 105D

**A.Q.L. 2.5**

<b>DATES AND REASONS FOR REVISIONS</b> 7/16/87-New-ELB-287552 4/6/88-Update-ELB-288052	<b>MATERIAL:</b> AISI C-1095 <b>HEAT TREATMENT AT:</b> Vendor <b>COMPONENT CONDITION:</b> FINISHED: X SEMI-FIN. <b>MODEL NO.</b> 700, M/24 <b>PART NO.</b> 15368 <b>BLANK DRAWING NO.</b> B-15368 <b>PART NAME</b> Safety Detent Spring <b>DEPT. NO.</b> 007556
	PAGE 1 OF 1

RD-6491-1

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

**CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER**

# KINZER V. REMINGTON

R2536017

**TITLE: Safety Detent Spring**

**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 #:
06-Mar-1991	Retyped old paper process last Log 285593	SLW 291332
24-Sep-1991	Added M-24 to process	LBF 292178

**Process Approval List**

Approved By:	Badge #:	Date:	Designation:
Jacksora			

Document Number: 15368

Rev:

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Page: 1 OF 2

**TITLE: Safety Detent Spring**

**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	.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:**

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**Page: 2**

**OF 2**

**TITLE: Safety Detent Spring**

**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 #:

06-Mar-1991 Retyped old paper process last Log 285593 SLW 291332

24-Sep-1991 Added M-24 to process LBF 292178

**Process Approval List**

Approved By: Badge #: Date: Designation:

Jacksora

Document Number: 15368

Rev:

VAXcamps V2.1 Hardcopy Utility

Page: 1

OF 2

**TITLE: Safety Detent Spring**

**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	.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**

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**OF 2**

**R2536022**

[illegible]

AD-6491-E

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



700-40XCF

292106

*Firing Pin Blank*

PROCESS RECORD AND DATA BASE/ENGINEERING CHANGE NOTICE AUTHORIZATION		PROCESS CHANGE NO. <u>292106</u> ENG. CHANGE NO. _____ INITIATED DATE <u>7-30-91</u>	
TO BE RETURNED BY _____			
ROUTE TO	NAME	APPROVAL	DATE
PE&C SUPERVISOR	R. A. JACKSON	<i>R. A. Jackson</i>	8-3-91
PRODUCTION SUP'R			
PROD. FOREMAN			
	Shirley Willoughby		
ACCOUNTING			
PLANNING			
PURCHASING			
			SW 976-91

MODEL NO. <u>700 40XCF</u>	ENGINEER <u><i>H. B. Fennell</i></u>
PART NAME <u>FIRING PIN BLANK</u>	REQUESTED BY <u>H. W. DUNCKEL</u>
PART NUMBER <u>28805</u>	ECR NO. _____

DCR(IF ANY) _____	COST REDUCTION/INCREASE
DESCRIPTION OF CHANGE AND REASON <u>Delete part # 28806 &amp; Dim:</u>	
<u>4.764-4.758, 3 degree angle, Use surface "A" for stop .Use .750 spacer,"</u>	
<u>#28806 use surface "C" for stop. Use surface "C" for stop and adjust com-</u>	
<u>parator table to suit. Add steps 1 &amp; 4, measurement descriptions.</u>	

CLASSIFICATION OF CHANGE	
EFFECTIVITY DATE _____	( ) PHASE OUT ( ) REGULAR
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 12:49:28.83		Shirley Willoughby
Comment:			
Fully Approved	17-JUL-1991 09:35:36.50		R.A.Jackson
Comment:			
Normal Release	17-JUL-1991 09:36:11.15		R.A.Jackson
Comment:			

**Process Revision Reasons**

Date:	Reason For Revision:	Eng Log #:
28-Jun-1991	Retyped old 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:

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TITLE: Firing Pin Blank

Process General Notes

Notes:

\*\*\*\*\*The Part #'s would not fit on Process Header Section\*\*\*\*\*  
 \*\*\*\*\*Part #'s 28805 28806\*\*\*\*\*

Process Tools

Type	Number	Use	Max	Min
Visual		Check for excessive burrs, cracks, mars.		
Comp. Screen	721-CL-114	Length 28805 <del>28806</del> Profile of point to shoulder-Blank Dim.	5.614 <del>4.764</del> 1.330	5.608 <del>4.758</del> 1.324
Comp. Fixture	C-50440	1. To check: 1.330-1.324; 1.015-1.005; .125-.120 dims.; <del>3 deg. angle, .215-.200R, &amp; .055-.045.</del> <del>Use surface "A" for stop. Use .750 Spacer.</del> 2. To check .255-.245 dim. and .025-.020R. Remove Spacer to check this dimension only. 3. To check 5.614-5.608-part 28805 and 4.764-4.758 dimension-Part # <del>28806 use surface "C" for stop.</del> 4. To check .065-.050 diam. & 31 deg. angle <del>Use surface "C" for stop and adjust comparator table to suit.</del>		
Dial Mics.	Std.	Diameter of shank Diameter of point	.2820 .076	.2805 .074
Adj. "Vee"Block Std. Fed. Dial Comp.	B-54162	Max. eccentricity of point and shank is .006 T.I.R. Max. eccentricity of .410/.405 dia. and shank. (.006 T.I.R.)		

1) Move table .750, <sup>in the "X" axis</sup> shoulder in step #1 will line up on comparator screen so that ~~xx~~ 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:

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OF 2

**Smead.**

**No. 2-152-5L**

HASTINGS, MN  
LOS ANGELES-CHICAGO-LOGAN, OH  
MCGREGOR, TX-LOCUST GROVE, GA  
U.S.A.

**REMINGTON ARMS COMPANY, INC.**

INTER-DEPARTMENTAL CORRESPONDENCE



cc: House Force

10 01  
J.S. MARTIN  
ILION

*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.

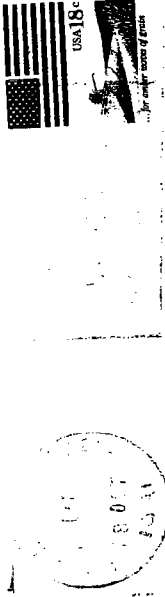
*E. J. Conroy*

E. J. Conroy  
Director of Sales

EJC:fms

5406 EL CAMINO  
COLUMBIA, MD 21044

*Don't forget to get help!  
to get help!  
to get help!  
to get help!  
to get help!*



ENGINEERING GROUP  
RESEARCH & DEVELOPMENT  
REMINGTON ARMS COMPANY, INC  
BRIDGEPORT, CONN 06602

→ CB Workman  
anything you can do?  
Engineering Group - Research  
and Development  
Remington Arms Company, Inc.  
Bridgeport, Connecticut 06602

5406 El Camino REMINGTON ARMS CO  
Columbia, Md 21044  
8 October 1981

RECEIVED  
OCT 14 1981

ILION RESEARCH DIVISION

Gentlemen:

HELP ?

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 is placed behind the floating 'guide' of the magazine.

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.

Sincerely yours,

*Robert Solenberger*  
Robert Solenberger

7M 40x2 - CLIP SLOT

M-700 Sniper ?



~~Capoletti~~ - ~~Jim Marti~~  
saw about some  
feed back on this one -  
Clark.

**B**rodock  
press inc.

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

## REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE



xc: C. B. Workman  
J. W. Brooks  
~~J. S. Martin~~  
~~D. J. Sanita~~

"CONFINE YOUR LETTER TO ONE SUBJECT ONLY" \_\_\_\_\_

*file*

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.

*JAS -m*  
JAS, FEM:ws

700

*Anger Side Plate 11*

291966

PROCESS RECORD AND  
DATA BASE/ENGINEERING  
CHANGE NOTICE AUTHORIZATION

PROCESS CHANGE NO. 291766

ENG. CHANGE NO. \_\_\_\_\_

TO BE RETURNED BY \_\_\_\_\_

INITIATED DATE \_\_\_\_\_

ROUTE TO	NAME	APPROVAL	DATE
PE&C SUPERVISOR	<i>R.L. Jackson</i>	<i>Rafael</i>	8-5-91
PRODUCTION SUP'R			
PROD. FOREMAN			
ACCOUNTING			
PLANNING			
PURCHASING			
			<i>32 8-12-91</i>

MODEL NO. 700

ENGINEER \_\_\_\_\_

PART NAME *Trigger Side Plate*REQUESTED BY *SLU*PART NUMBER 30781

ECR NO. \_\_\_\_\_

DCR (IF ANY) \_\_\_\_\_

COST REDUCTION/INCREASE

DESCRIPTION OF CHANGE AND REASON

*Retyped from old paper process last Log 287419*

## CLASSIFICATION OF CHANGE

EFFECTIVITY DATE \_\_\_\_\_

( ) PHASE OUT ( ) REGULAR

DATA COORDINATOR \_\_\_\_\_

DATE \_\_\_\_\_

# PROCESS RECORD - INSPECTION

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER  
KINZER V. REMINGTON

GAUGES		USE	LIMITS	
TYPE	NUMBER		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 Out-going Quality Limit" listed.

A.Q.L. 5%

DATES AND REASONS FOR REVISIONS 5-1-70-New-AJU-268737

9/26/80 - Changed part number - was 30781 - CAK - 277534

2/17/81 - Changed part number back to 30781 - CAK - 280217

5/7/82 - Added SEVEN LWT - CAK - 281464

10/21/82 - Added material thickness - CAK - 282003

5/20/87-Added flatness within .002-LRF-287419

MATERIAL: C-1010 or C-1020

HEAT TREATMENT AK None

COMPONENT CONDITION: FINISHED: X SEMI-FIN.

MODEL NO. 700 - 40XB - 600, SEVEN LWT

PART NO. 30781

BLANK DRAWING NO. C-30781

PART NAME Trigger Side Plate (Left)

DEPT. NO. 92 PAGE 1 OF 1

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

R2536035

**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 old paper process last Log 287419	SLW 291966

**Process Approval List**

Approved By:	Badge #:	Date:	Designation:
Jacksora			

Document Number: 30781

Rev:

VAXcamps V2.1 Hardcopy Utility

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**TITLE: Trigger Side Plate (Left)**

**Process Tools**

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	C636471	FOR VENDOR USE ONLY (1 GAGE)		
Mics.	Std.	Check material thickness	.064	.060
Surface Plate & Shims		Flatness	.002	

**Document Number: 30781**

**Rev:**

**VAXcamps V2.1 Hardcopy Utility**

**Page: 2**

**OF 2**

# PROCESS RECORD - INSPECTION

GAUGES		USE	LIMITS	
TYPE	NUMBER		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 Out-going Quality Limit" listed.

A.Q.L. 5%

**DATES AND REASONS FOR REVISIONS** 5-1-70-New-AJU-268737

9/26/80 - Changed part number - was 30781 - CAK - 277534

2/17/81 - Changed part number back to 30781 - CAK - 280217

5/7/82 - Added SEVEN LWT - CAK - 281464

10/21/82 - Added material thickness - CAK - 282003

5/20/87-Added flatness within .002-LBE-287419

**MATERIAL:** C-1010 or C-1020

**HEAT TREATMENT** ~~XX~~ None

**COMPONENT CONDITION:** FINISHED: ☒ SEMI-FIN.

**MODEL NO.** 700 - 40XB - 600, SEVEN LWT

**PART NO.** 30781

**BLANK DRAWING NO.** C-30781

**PART NAME** Trigger Side Plate (Left)

**DEPT. NO.** 92 **PAGE** 1 **OF** 1

REV 0491-1

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

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER

KINZER V. REMINGTON

R2536038



700802

291985

*Progrin Howard*

PROCESS RECORD AND  
DATA BASE/ENGINEERING  
CHANGE NOTICE AUTHORIZATION

PROCESS CHANGE NO. 291985

ENG. CHANGE NO. \_\_\_\_\_

TO BE RETURNED BY \_\_\_\_\_

INITIATED DATE \_\_\_\_\_

ROUTE TO	NAME	APPROVAL	DATE
PE&C SUPERVISOR	<i>R.L. Jackson</i>	<i>R. Jackson</i>	<i>8-5-91</i>
PRODUCTION SUP'R			
PROD. FOREMAN			
ACCOUNTING			
PLANNING			
PURCHASING			
			<i>SLW 8-12-91</i>

MODEL NO. 760 BDK ENGINEER \_\_\_\_\_  
 PART NAME Magne Guard Blk REQUESTED BY SLW  
 PART NUMBER 34315-16 ECR NO. \_\_\_\_\_

DCR(IF ANY) \_\_\_\_\_ COST REDUCTION/INCREASE

DESCRIPTION OF CHANGE AND REASON Retyped from  
old paper process last Log 3845-20

## CLASSIFICATION OF CHANGE

EFFECTIVITY DATE \_\_\_\_\_ ( ) PHASE OUT ( ) REGULAR

DATA COORDINATOR \_\_\_\_\_

## PROCESS RECORD - INSPECTION

GAUGES		USE	LIMITS	
TYPE	NUMBER		MAX.	MIN.
Visual		Free from excessive gates and flash and surface imperfections.		
Mics.	Std.	Check width. (.625 dim)	.630	.620
Plug Gage	Std.	Check slot. (.415 dim)	.420	.410
Comp. Fixture	B84517			
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	.185
Plug Gage	Standard	Check Guard Screw holes.	.255	.250
Calipers	Std.	Check width (outside) magazine area, front (.975 dim)	.980	.970
	Std.	Check width (outside) magazine area, rear (1.080 dim)	1.085	1.075

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 Out-going Quality Limit" listed.

A.Q.L. 3%

## DATES AND REASONS FOR REVISIONS

8/29/63 - Retyped from 6/20/61 - new form - Marley

9/26/80 - Changed part numbers - were 26375  
and 26376 - CAK - 284445

6/11/84 - Revised - JBM - 284445

6/29/84 - Revised - SB - 284520

MATERIAL: #218 Aluminum Die Casting Alloy

HEAT TREATMENT AT: Remington

COMPONENT CONDITION:

FINISHED:

SEMI-FIN. X

MODEL NO. 700 BDL

PART NO. 34315, 34316

BLANK DRAWING NO. D-34315

PART NAME Trigger Guard

Blank

DEPT. NO. 92 60

PAGE 1 OF 1

**TITLE: Trigger Guard Blank**

**Process Header**

**PURCHASED PARTS INSPECTION**

Material : #218 Aluminum Die Casting Alloy  
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  
Department : 9291  
A. Q. L. : 3 %  
Origination Date : 20-Jun-1961  
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 #:

30-Jul-1991 Retyped old paper process last Log 284520 SLW 291985

**Process Approval List**

Approved By: Badge #: Date: Designation:

Jacksora

**Process General Notes**

**Notes:**

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

Document Number: 34315

Rev:

VAXcamps V2.1 Hardcopy Utility

Page: 1 OF 2

**TITLE: Trigger Guard Blank**

**Process Tools**

*Corrected*

Type	Number	Use	Max	Min
Visual		Free from excessive gates and flash and surface imperfections.		
Mics.	Std.	Check width (.625 dim)	.630	.620
Plug Gage	Std.	Check slot (.415 dim)	.420	.410
Comp. Screen	D-700ADL-CL-6	Check mean outline top and side view (long action)		
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 2**

## PROCESS RECORD - INSPECTION

GAUGES		USE	LIMITS	
TYPE	NUMBER		MAX.	MIN.
Visual		Free from excessive gates and flash and surface imperfections.		
Mics.	Std.	Check width. (.625 dim)	.630	.620
Plug Gage	Std.	Check slot. (.415 dim)	.420	.410
Comp. Fixture	B84517			
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	.185
Plug Gage	Standard	Check Guard Screw holes.	.255	.250
Calipers	Std.	Check width (outside) magazine area, front (.975 dim)	.980	.970
	Std.	Check width (outside) magazine area, rear (1.080 dim)	1.085	1.075

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 Out-going Quality Limit" listed.

A.Q.L. 3%

## DATES AND REASONS FOR REVISIONS

8/29/63 - Retyped from 6/20/61 - new form - Marley  
 9/26/80 - Changed part numbers - were 26375  
 and 26376 - CAX - 279534  
 6/11/84 - Revised - JBM - 284445  
 6/29/84 - Revised - SB - 284526

MATERIAL: #218 Aluminum Die Casting Alloy

HEAT TREATMENT AT: Remington

COMPONENT CONDITION: FINISHED: SEMI-FIN. X

MODEL NO. 700 BDL

PART NO. 34315, 34316

BLANK DRAWING NO. D-34315

PART NAME Trigger Guard

DEPT. NO. 92 60

Blank

PAGE 1 OF 1

700

442039

*Deputy District Clerk*

PROCESS RECORD AND  
DATA BASE/ENGINEERING  
CHANGE NOTICE AUTHORIZATION

PROCESS CHANGE NO. 292039

ENG. CHANGE NO. \_\_\_\_\_

TO BE RETURNED BY \_\_\_\_\_

INITIATED DATE \_\_\_\_\_

ROUTE TO	NAME	APPROVAL	DATE
PE&C SUPERVISOR	<i>R. L. Jackson</i>	<i>Rafach</i>	8-6-91
PRODUCTION SUP'R			
PROD. FOREMAN			
ACCOUNTING			
PLANNING			
PURCHASING			
			<i>Steel 8-12-91</i>

MODEL NO. XP 100 ENGINEER \_\_\_\_\_  
 PART NAME Safety Detent Ball REQUESTED BY SLC  
 PART NUMBER 33222 ECR NO. \_\_\_\_\_

DCR (IF ANY) \_\_\_\_\_ COST REDUCTION/INCREASE

DESCRIPTION OF CHANGE AND REASON

*Retyped from  
old paper process last Log 281464*

## CLASSIFICATION OF CHANGE

EFFECTIVITY DATE \_\_\_\_\_ ( ) PHASE OUT ( ) REGULAR

DATA COORDINATOR \_\_\_\_\_ DATE \_\_\_\_\_



## PROCESS RECORD - INSPECTION

[illegible]

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 Out-going Quality Limit" listed.

**A.Q.L.** 7%

### DATES AND REASONS FOR REVISIONS

6/23/80 - Retyped from 275096 - Updated - CAK -  
5/7/82 - Added SEVEN LWT - CAK - 281464

**MATERIAL:** Mfg. Std.

HEAT TREATMENT AT: - - -

COMPONENT CONDITION: FINISHED: ☒ SEMI-FIN. ☐

**MODEL NO.** 600, XP-100, 40XB, 700, SEVEN LWT

**PART NO. 23222**

**BLANK DRAWING NO. B-23220**

<b>PART NAME</b>	Safety Detent Ball / Operating Handle Detent Ball
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DEPT. NO. 92 PAGE 1 OF 1

**CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER**

R2536047

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

**Process Header**

**PURCHASED PARTS INSPECTION**

Material : Mfg. Std.  
Heat Treatment At : ---  
Component Condition : Finished X Semi-Fin  
Model : XP100 600 40XB 700 7LWT  
Part Number : 23222  
Blank Drawing Number: B-23220  
Part Name : Safety Detent Ball/Oper.Hdl.Detent Ball  
Department : 9291  
A. Q. L. : 3 %  
Origination Date : 23-Jun-1980  
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 #:

02-Aug-1991 Retyped old paper process last Log 281464 SLW 292039

**Process Approval List**

Approved By: 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**

Type	Number	Use	Max	Min
Visual		Check finish		
Mics.	Std.	Diameter	.1564	.1560

**Document Number: 23222**

**Rev:**

**VAXcamps V2.1 Hardcopy Utility**

**Page: 2**

**OF 2**

REF 292039

RD-6518 Rev 7/83

PROCESS RECORD AND DATA BASE/ENGINEERING CHANGE NOTICE AUTHORIZATION		PROCESS CHANGE NO. <u>292040</u>	
TO BE RETURNED BY _____		ENG. CHANGE NO. _____	
		INITIATED DATE _____	
ROUTE TO	NAME	APPROVAL	DATE
PE&C SUPERVISOR	<i>R J Orf</i>		
PRODUCTION SUP'R			
PROD. FOREMAN			
ACCOUNTING			
PLANNING			
PURCHASING			

MODEL NO. <u>1100</u>	ENGINEER _____
PART NAME <u><del>23222</del> <i>OP. Handle</i></u>	REQUESTED BY <u><i>S L W</i></u>
PART NUMBER <u>23222</u>	ECR NO. _____

DCR (IF ANY) _____	COST REDUCTION/INCREASE _____
DESCRIPTION OF CHANGE AND REASON <u><i>Retyped old paper</i></u>	
<u><i>process last Log 380284</i></u>	

CLASSIFICATION OF CHANGE	
EFFECTIVITY DATE _____	( ) PHASE OUT ( ) REGULAR
DATA COORDINATOR _____	DATE _____

## PROCESS RECORD - INSPECTION

[illegible]

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 200 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. 7%**

### DATES AND REASONS FOR REVISIONS

6/23/80 - Retyped from 275096 - Updated - CAK -

**MATERIAL:** Mfg. Std.

HEAT TREATMENT AT: - - -

**COMPONENT CONDITION:**                      **FINISHED:** ☒      **SEMI-FIN.** ☐

**MODEL NO.** 1100

**PART NO. 23222**

**BLANK DRAWING NO. B-23220**

**PART NAME** Op. Handle Detent Ball

DEPT. NO. 92 PAGE 1 OF 1

**CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER**

R2536051

## PROCESS RECORD - INSPECTION

**CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER**

[illegible]

RD-0491-1

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

R2536052

700

242042

Dear Sir

PROCESS RECORD AND  
DATA BASE/ENGINEERING  
CHANGE NOTICE AUTHORIZATION

PROCESS CHANGE NO. 292042

ENG. CHANGE NO. \_\_\_\_\_

TO BE RETURNED BY \_\_\_\_\_

INITIATED DATE \_\_\_\_\_

ROUTE TO	NAME	APPROVAL	DATE
PE&C SUPERVISOR	<i>R.L. Jackson</i>	<i>Raph</i>	8-6-91
PRODUCTION SUP'R			
PROD. FOREMAN			
ACCOUNTING			
PLANNING			
PURCHASING			

MODEL NO. 700

ENGINEER \_\_\_\_\_

PART NAME Sear PinREQUESTED BY SLWPART NUMBER 24476

ECR NO. \_\_\_\_\_

DCR(IF ANY) \_\_\_\_\_

COST REDUCTION/INCREASE

DESCRIPTION OF CHANGE AND REASON

*Retyped from  
old paper process last Log 288589*

## CLASSIFICATION OF CHANGE

EFFECTIVITY DATE \_\_\_\_\_

( ) PHASE OUT ( ) REGULAR

DATA COORDINATOR \_\_\_\_\_

DATE \_\_\_\_\_



**CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER  
KINZER V. REMINGTON**

29<sup>th</sup> Aug 2042

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.

PAGE 1 OF 1

R2536055

TITLE: Sear 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  
Model : 700 40XB 40XCF 721 722  
Part Number : 24476  
Blank Drawing Number: C-24475  
Part Name : Sear 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).

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 #:

02-Aug-1991 Retyped old paper process last Log 288589 SLW 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 chamfer (one end) Color Black 16-Finish		
Mics.	Std.	Diameter	.125	.1248
Snap Gage	B-8001 <sup>24</sup> 2-T	Length	.720	.710
Scale or Calipers	Std.	60 deg. Inc. Angle (length)	.060	.040

**Document Number: 24476**

**Rev:**

**VAXcamps V2.1 Hardcopy Utility**

**Page: 2**

**OF 2**

## PROCESS RECORD-INSPECTION

## GAUGES

**TYPE**

**NUMBER**

**USE**

## LIMITS

**MAX.**

MIN.

## Visual

Free of Burrs, .010 x 45° Chamfer (one end)  
Color Black  
16-Finish  
Diameter

MicsStd.

Diameter

.125

1248

Snap Ga.

B-80024-T

Length

.720

.710

Scale or Calipers	Std.
1	1
2	2
3	3
4	4
5	5
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99	99
100	100

Std.

60° Inc. Angle

.060

.040

**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** 10/13/88-Sep. Pt.#-ELB7  
288589

**MATERIAL:** AISI C-1095 or A50100 or 52100

HEAT TREATMENT AT: R 45 N 43-49

COMPONENT CONDITION: FINISHED: ☒ SEMI-FIN. ☐

**MODEL NO.** 700, 40XB, 40CF, 7LWT, 721, 722

PART NO. 24476

BLANK DRAWING NO. C-24475

**PART NAME** Sear Pin

DEPT. NO. 9291

PAGE 1 OF 1

RD-4471-1

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

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER  
ISSUED BY DENVER DISTRICT COURT

R2536058

100 att. 292043  
Dagge Rind/Don Blt. Pi

PROCESS RECORD AND  
DATA BASE/ENGINEERING  
CHANGE NOTICE AUTHORIZATION

PROCESS CHANGE NO. 292043

ENG. CHANGE NO. \_\_\_\_\_

TO BE RETURNED BY \_\_\_\_\_

INITIATED DATE \_\_\_\_\_

ROUTE TO	NAME	APPROVAL	DATE
PE&C SUPERVISOR	<i>W. L. Jackson</i>	<i>Rajah</i>	8-6-91
PRODUCTION SUP'R			
PROD. FOREMAN			
ACCOUNTING			
PLANNING			
PURCHASING			

MODEL NO. 700 ENGINEER \_\_\_\_\_  
 PART NAME Drugg Pin / Seal Bl. Pin REQUESTED BY SLZ  
 PART NUMBER 24477 ECR NO. \_\_\_\_\_

DCR (IF ANY) \_\_\_\_\_ COST REDUCTION/INCREASE

DESCRIPTION OF CHANGE AND REASON

*Retyped from  
old paper process last Log 288591*

## CLASSIFICATION OF CHANGE

EFFECTIVITY DATE \_\_\_\_\_ ( ) PHASE OUT ( ) REGULAR

DATA COORDINATOR \_\_\_\_\_

DATE \_\_\_\_\_

**CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER  
KINZER V. REMINGTON**

RD-6421-1

R2536061

**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  
Model : 700 40XB 40XCF 721 722 XP100 541S  
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).

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 #:

02-Aug-1991 Retyped old paper process last Log 288591 SLW 292043

**Process Approval List**

Approved By: Badge #: Date: Designation:

Jacksora

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		Free from burrs, .010 x 45 deg chamfer (one end) Color Black 16-Finish		
Mics.	Std.	Diameter	.125	.1248
Snap Gage	B-800 <sup>24</sup> <del>12</del> -U	Length	.365	.355

**Document Number: 24477**

**Rev:**

**VAXcamps V2.1 Hardcopy Utility**

**Page: 2**

**OF 2**

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

RD-0421-1

R2536064

700-24

Theresa Perry

292179

**TITLE: Trigger Spring**

**Process Header**

**PURCHASED PARTS INSPECTION**

Material : Music Wire (Stress relieve)  
Heat Treatment At : None  
Component Condition : Finished X Semi-Fin  
Model : 700 40XB 7LWT 24  
Part Number : 15400  
Blank Drawing Number: A-15400  
Part Name : Trigger Spring  
Department : 9291  
A. Q. L. : 3 %  
Origination Date : 15-Aug-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 #:

07-Mar-1991 Retyped old paper process last Log 281464 SLW 291339

24-Sep-1991 Added M-24 to 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		1. Do not set for inspection 2. Use suitable equipment 3. Check to inspection and manufacturing data on model dwg.  A. Check ends-open ends ground B. End coil outside diameter not to exceed O.D. of spring C. 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 2**

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

AD-6491-1

700-24 292184  
Firing Pen Cross Pen

PROCESS RECORD AND DATA BASE/ENGINEERING CHANGE NOTICE AUTHORIZATION		PROCESS CHANGE NO. <u>292184</u>	
TO BE RETURNED BY _____		ENG. CHANGE NO. _____	
INITIATED DATE _____			
ROUTE TO	NAME	APPROVAL	DATE
PE&C SUPERVISOR	<i>R.L. Jackson</i>		
PRODUCTION SUP'R			
PROD. FOREMAN			
ACCOUNTING			
PLANNING			
PURCHASING			

MODEL NO. <u>700-24</u>	ENGINEER _____
PART NAME <u>Firing Pin Cross Pin</u>	REQUESTED BY <u>SLW</u>
PART NUMBER <u>17022</u>	ECR NO. _____

DCR (IF ANY) _____	COST REDUCTION/INCREASE _____
DESCRIPTION OF CHANGE AND REASON <u>Retyped from</u>	
<u>old paper process last Log 284552</u>	
<u>add m-24</u>	

CLASSIFICATION OF CHANGE	
EFFECTIVITY DATE _____	( ) PHASE OUT ( ) REGULAR
DATA COORDINATOR _____	





701-24

292157

Dear Spring

PROCESS RECORD AND  
DATA BASE/ENGINEERING  
CHANGE NOTICE AUTHORIZATION

PROCESS CHANGE NO. 292187

ENG. CHANGE NO. \_\_\_\_\_

TO BE RETURNED BY \_\_\_\_\_

INITIATED DATE \_\_\_\_\_

ROUTE TO	NAME	APPROVAL	DATE
PE&C SUPERVISOR	<i>R.L. Jackson</i>	<i>R. Jackson</i>	<i>9-27-91</i>
PRODUCTION SUP'R			
PROD. FOREMAN			
ACCOUNTING			
PLANNING			
PURCHASING			

MODEL NO. 700-24 ENGINEER \_\_\_\_\_  
 PART NAME Seal Spring REQUESTED BY SLW  
 PART NUMBER 17047 ECR NO. \_\_\_\_\_

DCR (IF ANY) \_\_\_\_\_ COST REDUCTION/INCREASE

DESCRIPTION OF CHANGE AND REASON

*Retyped from  
old paper process last Log 287552  
Add m-24*

## CLASSIFICATION OF CHANGE

EFFECTIVITY DATE \_\_\_\_\_ ( ) PHASE OUT ( ) REGULAR

DATA COORDINATOR \_\_\_\_\_

## PROCESS RECORD – INSPECTION

[illegible]

RD-6491-1

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

**CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER**

**R2536074**

**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 #:

14-Jun-1991 Retyped old paper process last Log 288483 SLW 291823

25-Sep-1991 Added M-24 to process LBF 292187

**Process Approval List**

Approved By: Badge #: Date: Designation:

Jacksora

Document Number: 17047

Rev:

VAXcamps V2.1 Hardcopy Utility

Page: 1 OF 2

**TITLE: Sear Spring**

**Process Tools**

Type	Number	Use	Max	Min
Visual		Free of defects		
Ring Gage	B-51000-L	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  <del>8. Remove Set;</del> DO NOT REMOVE SET NOTE:           EXCEPT FOR INSPECTION	.303 -----	----- .460

Document Number: 17047

Rev:

VAXcamps V2.1 Hardcopy Utility

Page: 2

OF 2

# KINZER V. REMINGTON

## PROCESS RECORD - INSPECTION

[illegible]

RD-441-1

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

**R2536077**

902271

7x64 D.A.  
Model 700



xc: W.H. Coleman, II/File  
K.W. Soucy  
H.C. Munson  
L.B. Bosquet  
F.E. Martin  
File

RESEARCH TEST AND MEASUREMENT REPORT

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

MODEL 700 7x64 CALIBER DESIGN ACCEPTANCE

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

Fred E. Martin 29 Nov '90

J.R. Snedeker 29 Nov '90

W.H. Coleman II 11/29/90

MODEL 700 7x64 CALIBER DESIGN ACCEPTANCE

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 7x64 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.

## MODEL 700 7x64 CALIBER DESIGN ACCEPTANCE

**REPORT TEXT:****GENERAL:**

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" 20X 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.

## MODEL 700 7x64 CALIBER DESIGN ACCEPTANCE

**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 20X 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.

## MODEL 700 7x64 CALIBER DESIGN ACCEPTANCE

## APPENDIX

## 100 YARD ACCURACY RESULTS

<u>SERIAL NUMBER</u>	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

overall average = 1.79

Report No. 902271

RESEARCH TEST & MEASUREMENT LAB WORK REQUEST

<p>___ Developmental</p> <p><u>X</u> Design Acceptance</p> <p>___ Pre-Pilot</p> <p>___ Pilot</p> <p>___ Production Acceptance</p>	<p align="center"><u>AREA OF TESTING</u></p> <table> <tr> <td>___ Safety Related</td> <td>___ Litigation</td> </tr> <tr> <td>___ Competitive Evaluation</td> <td>___ Warehouse Audit</td> </tr> <tr> <td>___ New Design</td> <td>___ Cost Reduction</td> </tr> <tr> <td><u>X</u> Design Change</td> <td>Stake _____</td> </tr> <tr> <td>___ Plant Assistance</td> <td><u>X</u> Other <u>New CALIBER</u></td> </tr> </table>		___ Safety Related	___ Litigation	___ Competitive Evaluation	___ Warehouse Audit	___ New Design	___ Cost Reduction	<u>X</u> Design Change	Stake _____	___ Plant Assistance	<u>X</u> Other <u>New CALIBER</u>
___ Safety Related	___ Litigation											
___ Competitive Evaluation	___ Warehouse Audit											
___ New Design	___ Cost Reduction											
<u>X</u> Design Change	Stake _____											
___ Plant Assistance	<u>X</u> Other <u>New CALIBER</u>											
<p align="center"><u>FIREARM STAT'S</u></p> <p>MODEL: <u>M 700</u></p> <p>CAL or GAGE: <u>7x64</u></p> <p>BARREL TYPE: <u>CWT</u></p> <p>PROOFED: YES <u>1</u> NO <u>X</u></p>	<p align="center"><u>REPORT REQ'D.</u></p> <p>FORMAL _____</p> <p>TEST RESULTS ONLY <u>X</u></p>	<p>DATE REQUESTED: <u>8-15-90</u></p> <p>DATE NEEDED BY: <u>ASAP</u></p> <p>REQUESTED BY: <u>F. MARTIN</u></p> <p>WORK ORDER NO: <u>1118-481152</u></p>										

<p align="center"><u>TEST TYPE</u></p>			
<p>___ Strength Test</p> <p><u>X</u> Function Test</p> <p><u>X</u> Accuracy Test</p>	<p>___ Ammunition Test</p> <p>___ Environmental Test</p> <p>___ Customer Complaint</p>	<p>___ Dry Cycle Test</p> <p>___ Measurements</p> <p>___ Endurance Test</p>	<p>___ Photo/Video</p> <p>___ Other _____</p>

EXPLAIN IN DETAIL THE REASON FOR THIS TEST: 6 Guns Supplied For Field Function And 100yp. Accuracy 3x5 Per Gun

GUNS REQUIRED:

NOTE: NO firearms or parts will be tested in the Labs unless they are accompanied by a Work Request, and both are delivered to the Labs by the designer or engineer. All Work Requests are to be filled out in detail. No Exceptions.

DATE COMPLETED: \_\_\_\_\_

TEST COMPLETED BY: \_\_\_\_\_

REPORT DATE: \_\_\_\_\_

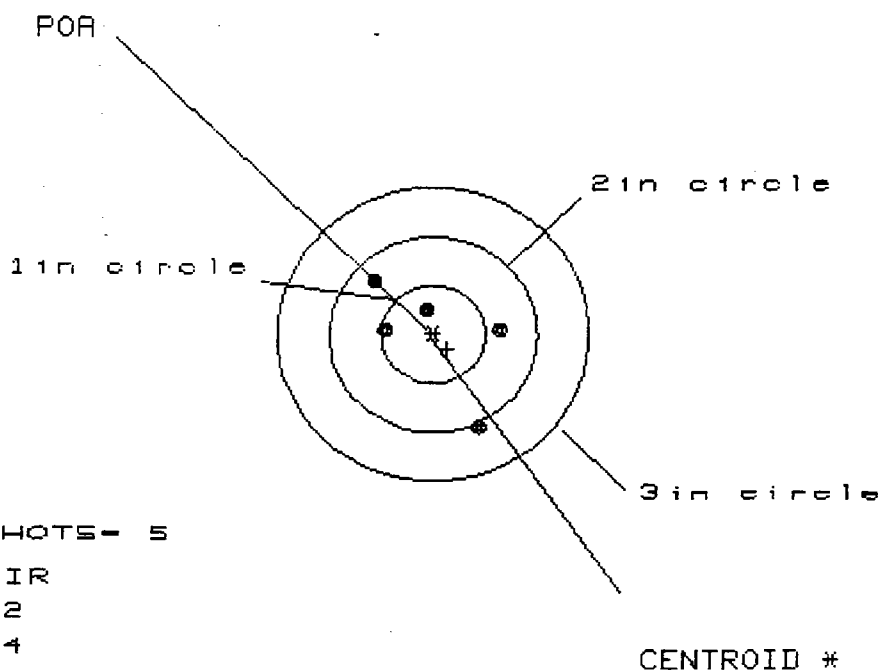




26 Sep 1998

FILE:/PATTERNING/CENTERFIRE\_PATT/C6563032

# CENTERFIRE PATTERNS # 3



# OF SHOTS- 5

# IN CIR

1in = 2

2in = 4

3in = 5

HS= 1.249

VS= 1.531

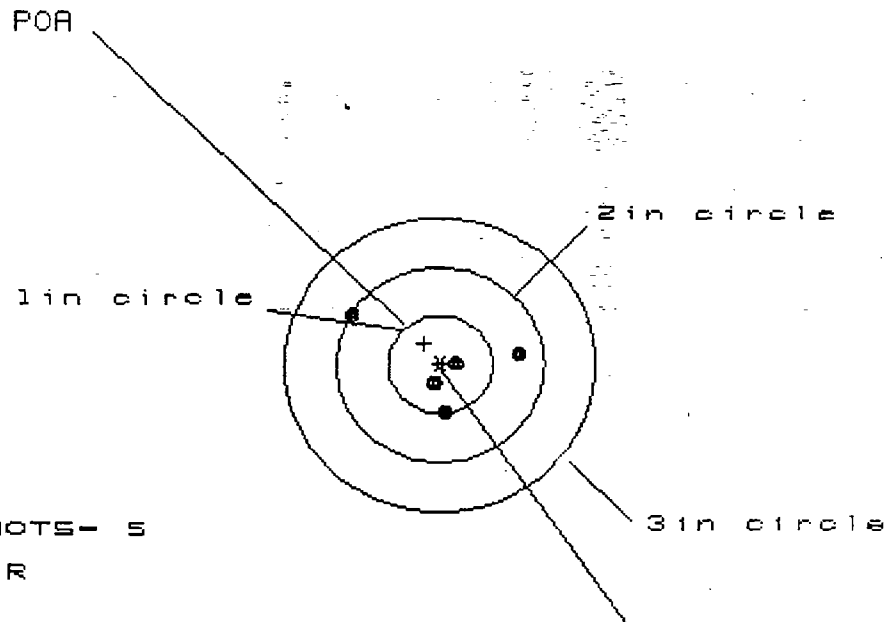
GS= 1.829

PATTERN #	:	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
POA 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 INCH CIRCLE =			2	
NUMBER IN TWO INCH CIRCLE =			4	
NUMBER IN THREE INCH CIRCLE =			5	

26 Sep 1998

FILE:/PATTERNING/CENTERFIRE PATT/C6563032

# CENTERFIRE PATTERNS # 2



# OF SHOTS- 5

# IN CIR

1in = 3

2in = 5

3in = 5

HS= 1.556

VS= 1.026

GS= 1.608

CENTROID \*

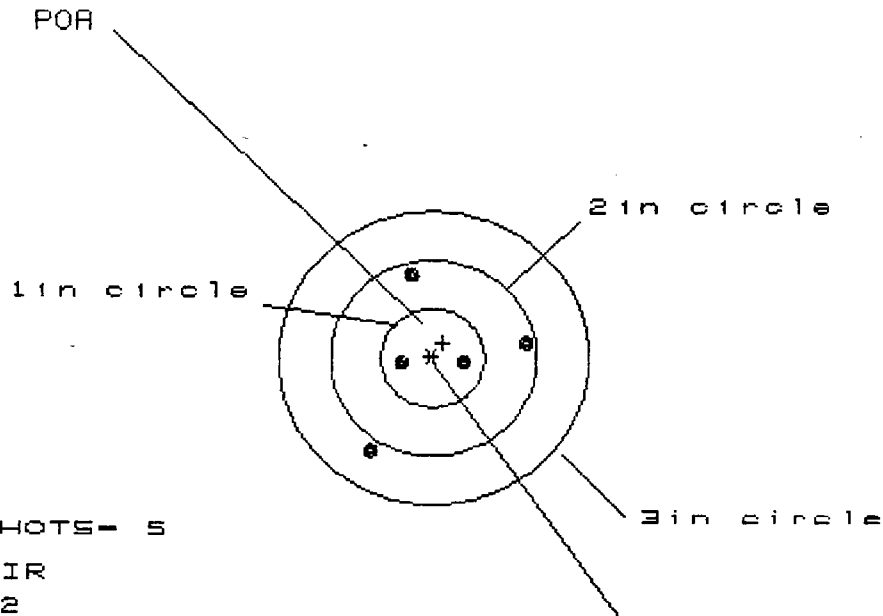
PATTERN #	:	2		
SHOTS (BEST OF)	:	5	4	3
MAXIMUM X	:	.739	.535	.074
MINIMUM X	:	-.817	-.233	-.055
MAXIMUM Y	:	.545	.277	.220
MINIMUM Y	:	-.481	-.344	-.252
CENTROID X	:	.151	.355	.177
CENTROID Y	:	-.215	-.352	-.444
POA TO CENTROID in.	:	.263	.500	.478
MIN RADIUS	:	.101	.165	.063
MEAN RADIUS	:	.503	.351	.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 INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		5	

SU #6562918

26 Sep 1990

FILE:/PATTERNING/CENTERFIRE\_PATT/C6562918

# CENTERFIRE PATTERNS # 1



# OF SHOTS- 5  
# IN CIR  
1in = 2  
2in = 4  
3in = 5  
HS= 1.486  
VS= 1.814  
GS= 1.871

AVG- 1.92

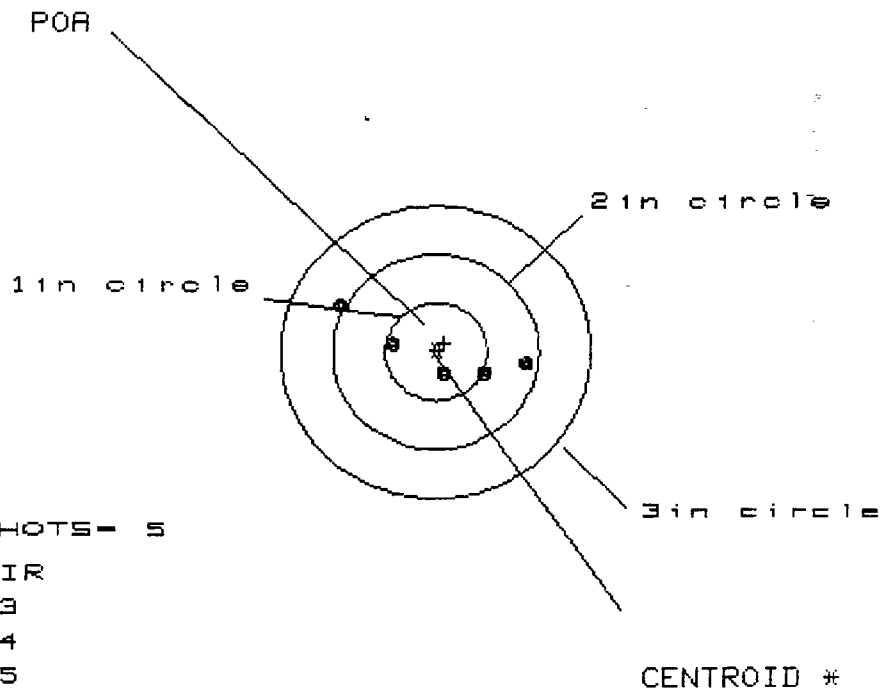
PATTERN #	1	2	3	4	5
SHOTS (BEST OF)	5	4	3		
MAXIMUM X	.866	.711	.605		
MINIMUM X	-.620	-.492	-.598		
MAXIMUM Y	.877	.643	.128		
MINIMUM Y	-.937	-.318	-.104		
CENTROID X	-.098	.057	.163		
CENTROID Y	-.155	.079	-.135		
POA TO CENTROID in.	.183	.098	.212		
MIN RADIUS	.267	.333	.104		
MEAN RADIUS	.700	.578	.440		
MAX RADIUS	1.123	.717	.618		
HORIZONTAL SPREAD	1.486	1.203	1.203		
VERTICAL SPREAD	1.814	.961	.232		
EXTREME SPREAD	1.871	1.260	1.213		
NUMBER IN ONE INCH CIRCLE	= 2				
NUMBER IN TWO INCH CIRCLE	= 4				
NUMBER IN THREE INCH CIRCLE	= 5				

M-700 7X64  
AMMO: NORMA  
150 GR. SP. SPIRE PT.  
INDEX 17013  
LOT - 02723  
SCOPE: LYMAN  
ALL AMERICAN - 20X  
LEUPOLD BASE & RINGS  
RANGE - 100 YDS.  
REST: SAND BAG.

26 Sep 1998

FILE:/PATTERNING/CENTERFIRE\_PATT/C6562918

# CENTERFIRE PATTERNS # 2



# OF SHOTS- 5

# IN CIR

1in = 3

2in = 4

3in = 5

HS= 1.781

VS= .739

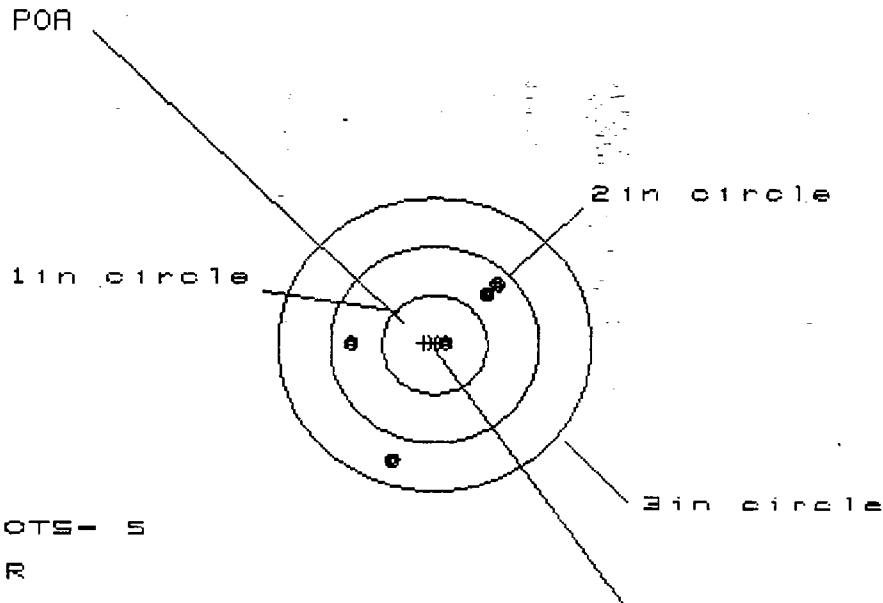
GS= 1.903

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 INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		5	

26 Sep 1998

FILE:/PATTERNING/CENTERFIRE\_PATT/C6562918

# CENTERFIRE PATTERNS # 3



# OF SHOTS- 5

# IN CIR

1in = 1

2in = 4

3in = 5

HS= 1.371

VS= 1.729

GS= 1.982

CENTROID #

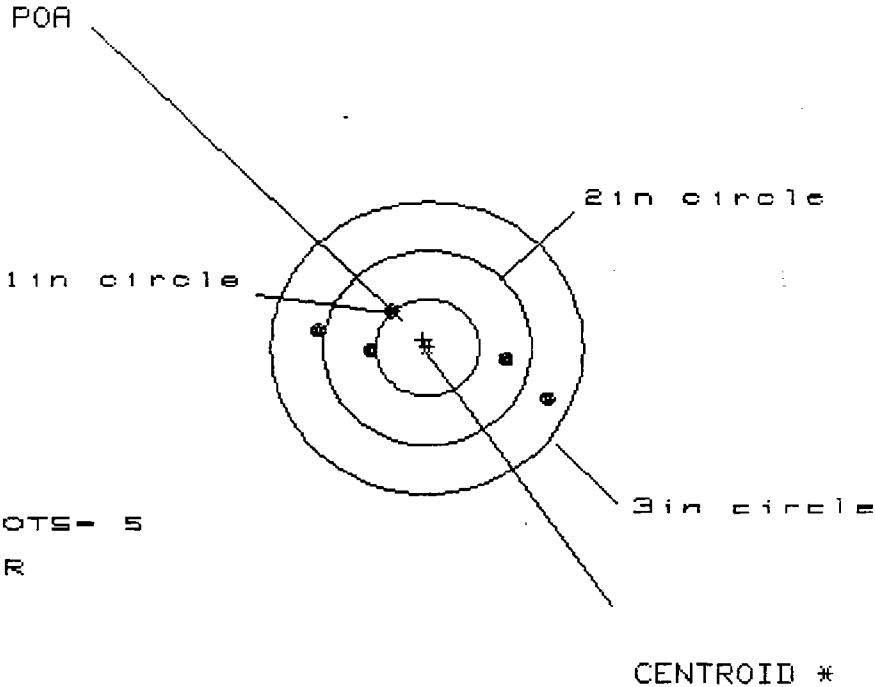
PATTERN #	3	4	3
SHOTS (BEST OF)	5	4	3
MAXIMUM X	.605	.514	.547
MINIMUM X	-.766	-.857	-.686
MAXIMUM Y	.594	.310	.369
MINIMUM Y	-1.135	-.295	-.192
CENTROID X	-.101	.192	.021
CENTROID Y	-.018	.266	.163
POA TO CENTROID in.	.103	.328	.164
MIN RADIUS	.059	.297	.237
MEAN RADIUS	.717	.565	.535
MAX RADIUS	1.192	.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		

SN. #6563108

26 Sep 1998

FILE:/PATTERNING/CENTERFIRE\_PATT/C6563108

# CENTERFIRE PATTERNS # 1



# OF SHOTS- 5  
# IN CIR  
1in = 0  
2in = 3  
3in = 5  
HS- 2.165  
VS- .903  
GS- 2.260

AUG - 2.34

PATTERN #	:	1		
SHOTS (BEST OF)	:	5	4	3
MAXIMUM X	:	1.158	1.085	.845
MINIMUM X	:	-1.007	-.718	-.513
MAXIMUM Y	:	.414	.292	.305
MINIMUM Y	:	-.489	-.196	-.183
CENTROID X	:	-.045	-.244	-.005
CENTROID Y	:	-.082	.040	.027
POA TO CENTROID in.	:	.094	.248	.028
MIN RADIUS	:	.563	.305	.451
MEAN RADIUS	:	.840	.608	.614
MAX RADIUS	:	1.257	1.102	.865
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	

m 700 - 7X64.

Ammo: NORMA

156 GR. SP. SPIRE PT.

INDEX: 17613

LOT: 02723

SCOPE: LYMAN

ALL AMERICAN - 20X

LEUPOLD BASE & RINGS.

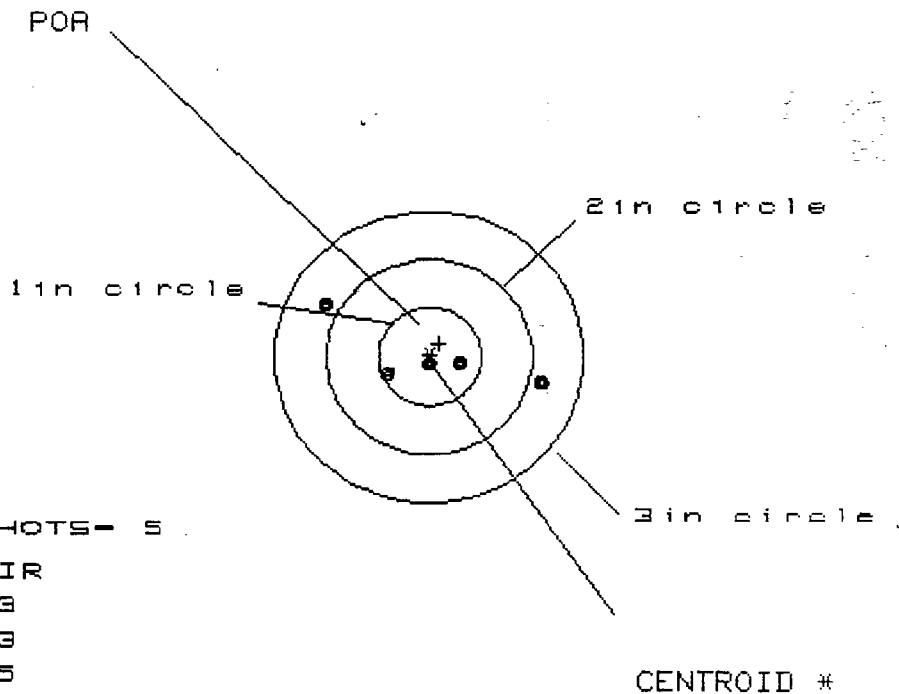
RANGE: 100 YDS

REST: SAND BAG

26 Sep 1988

FILE:/PATTERNING/CENTERFIRE\_PATT/C6563108

# CENTERFIRE PATTERNS # 2



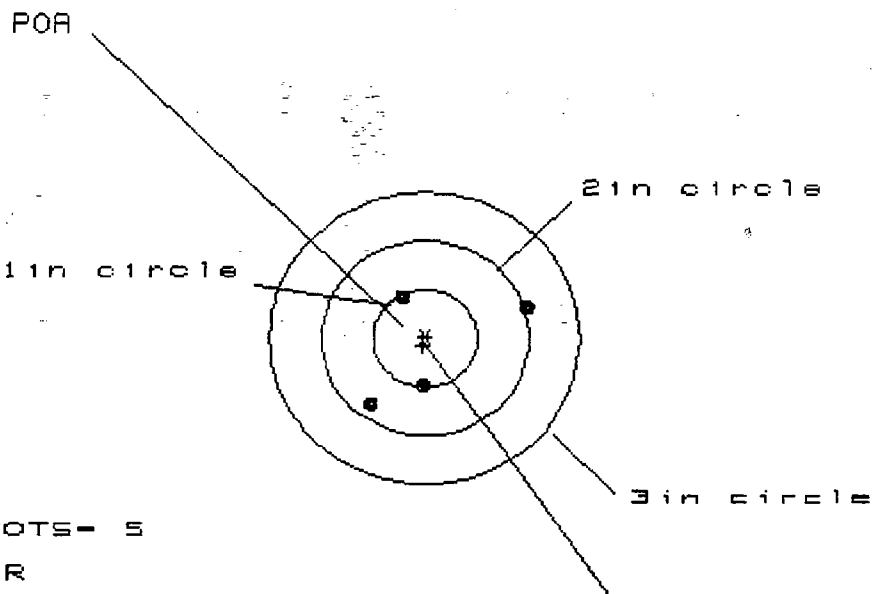
# OF SHOTS- 5  
 # IN CIR  
 1in = 3  
 2in = 3  
 3in = 5  
 HS= 2.019  
 VS= .853  
 GS= 2.192

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	:	.853	.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	

26 Sep 1998

FILE:/PATTERNING/CENTERFIRE\_PATT/C6563108

# CENTERFIRE PATTERNS # 3



# OF SHOTS- 5

# IN CIR

1in = 3

2in = 4

3in = 5

HS= 1.567

VS= 1.080

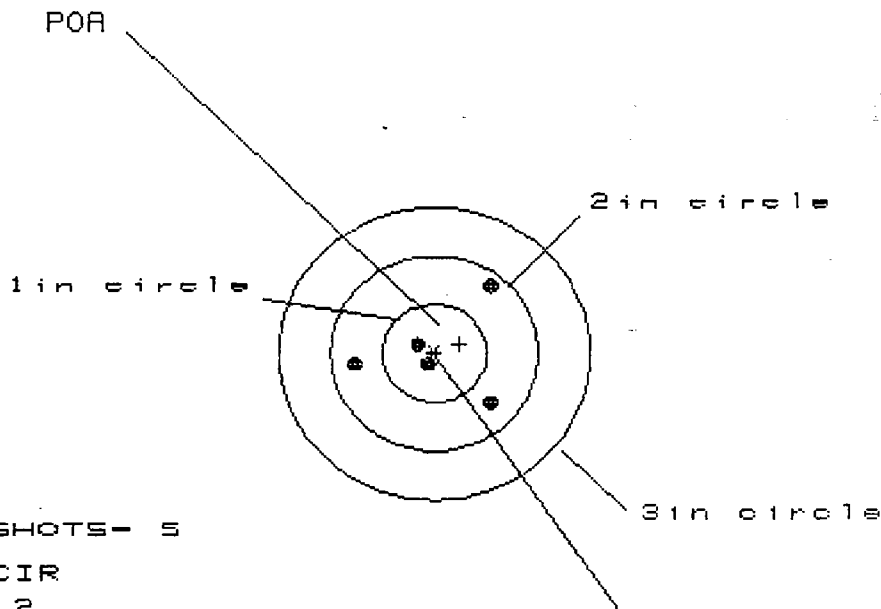
GS= 1.853

PATTERN #	:	3		
SHOTS (BEST OF)	:	5	4	3
MAXIMUM X	:	1.021	.201	.104
MINIMUM X	:	-.546	-.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	:	.655	.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	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		5	



SN. # C 6563003

# CENTERFIRE PATTERNS # 1



# OF SHOTS - 5  
# IN CIR  
1 in - 2  
2 in - 3  
3 in - 5  
HS - 1.315  
VS - 1.150  
GS - 1.514

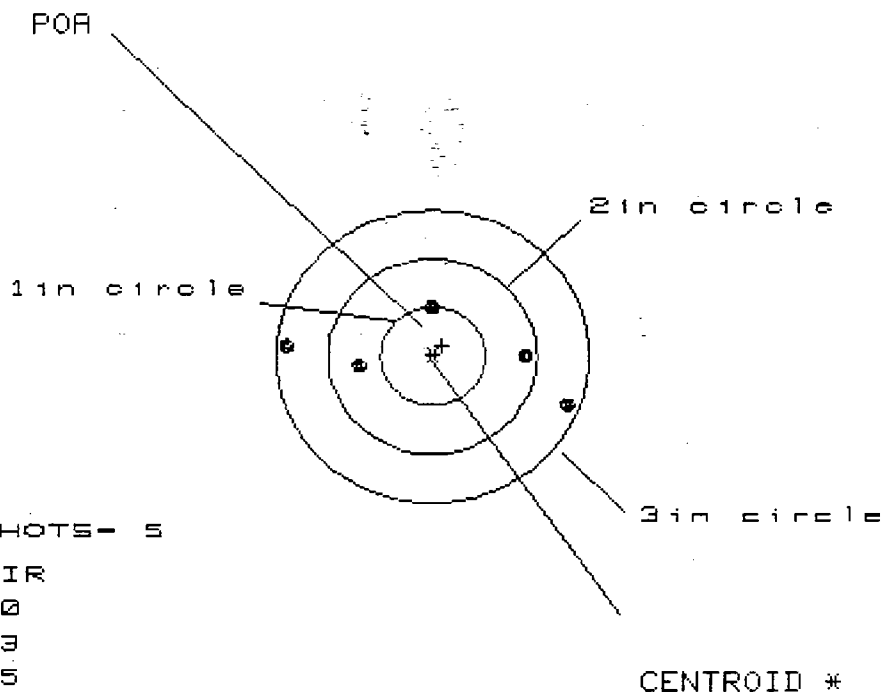
CENTROID #

AVG - 1.93

PATTERN #	:	1	4	3
SHOTS (BEST OF)	:	5	4	3
MAXIMUM X	:	.546	.658	.447
MINIMUM X	:	-.769	-.633	-.286
MAXIMUM Y	:	.662	.227	.253
MINIMUM Y	:	-.488	-.323	-.297
CENTROID X	:	-.235	-.371	-.160
CENTROID Y	:	-.094	-.259	-.285
POA TO CENTROID in.	:	.253	.453	.327
MIN RADIUS	:	.171	.053	.168
MEAN RADIUS	:	.548	.416	.362
MAX RADIUS	:	.858	.733	.537
HORIZONTAL SPREAD	:	1.315	1.291	.733
VERTICAL SPREAD	:	1.150	.550	.550
EXTREME SPREAD	:	1.514	1.352	.916
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		5	

m. 700 · 7X64  
AMMO: NORMA  
 156 GR. S.P. SPIRE PT.  
INDEX - 17013  
LOT - 02723  
SCOPE - LYMAN  
 ALL AMERICAN - 20X  
 LEUPOLD RINGS & BASES  
RANGE - 100 YDS  
REST - SAND BAG

# CENTERFIRE PATTERNS # 2



# OF SHOTS- 5

# IN CIR

1in = 0

2in = 3

3in = 5

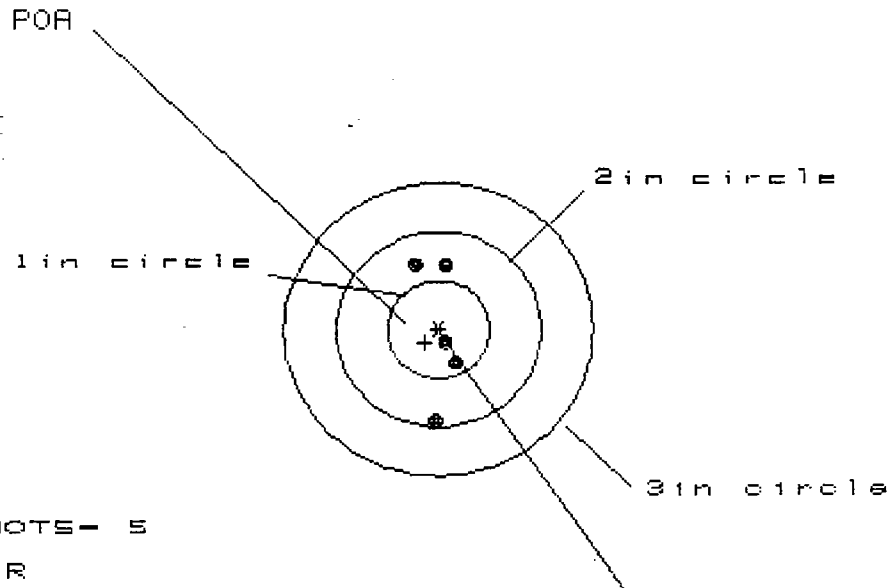
HS= 2.624

VS= .991

GS= 2.679

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	:	-.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	

# CENTERFIRE PATTERNS # 3



# OF SHOTS- 5  
 # IN CIR  
 1in = 2  
 2in = 5  
 3in = 5  
 HS= .414  
 VS= 1.589  
 GS= 1.601

CENTROID \*

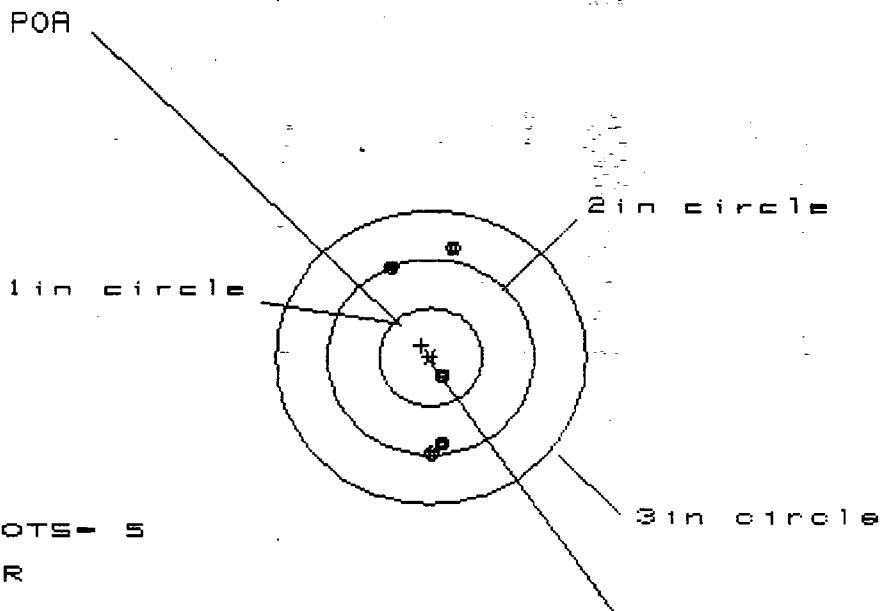
PATTERN #	:	3		
SHOTS (BEST OF)	:	5	4	3
MAXIMUM X	:	.176	.171	.090
MINIMUM X	:	-.238	-.243	-.063
MAXIMUM Y	:	.699	.474	.627
MINIMUM Y	:	-.900	-.595	-.442
CENTROID X	:	.135	.140	.221
CENTROID Y	:	.132	.357	.204
POA TO CENTROID in.	:	.189	.384	.301
MIN RADIUS	:	.129	.344	.188
MEAN RADIUS	:	.573	.489	.423
MAX RADIUS	:	.900	.619	.631
HORIZONTAL SPREAD	:	.414	.414	.153
VERTICAL SPREAD	:	1.599	1.069	1.069
EXTREME SPREAD	:	1.601	1.134	1.088
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		5	

SN # C6562914

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# CENTERFIRE PATTERNS # 1



# OF SHOTS- 5

# IN CIR

1 in - 1

2 in - 3

3 in - 5

HS- .587

VS= 2.098

GS= 2.108

AVG- 1.74

PATTERN # : 1

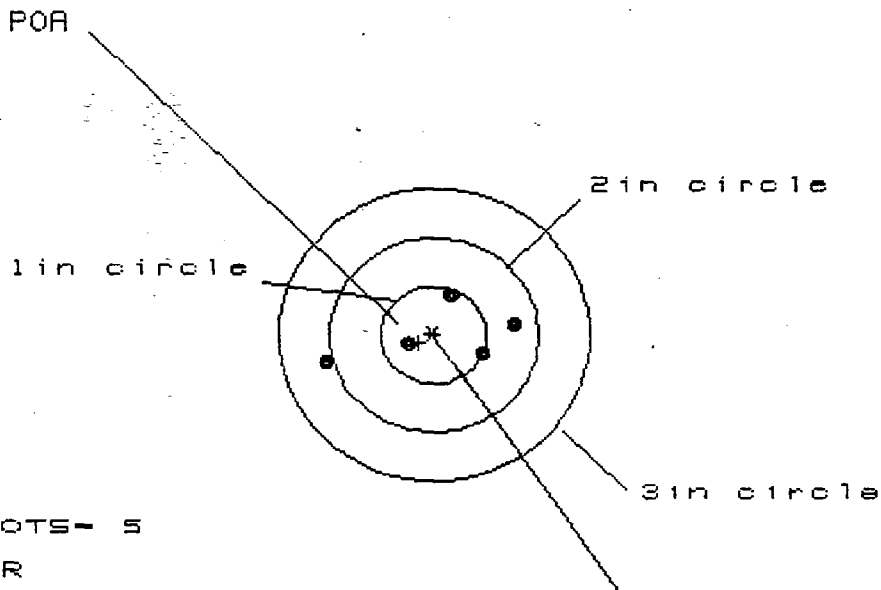
SHOTS (BEST OF)	5	4	3
MAXIMUM X	.185	.168	.050
MINIMUM X	-.402	-.356	-.091
MAXIMUM Y	1.104	1.244	.493
MINIMUM Y	-.994	-.718	-.304
CENTROID X	.090	.044	.162
CENTROID Y	-.119	-.395	-.809
POA TO CENTROID in.	.149	.397	.825
MIN RADIUS	.232	.186	.194
MEAN RADIUS	.856	.706	.336
MAX RADIUS	1.119	1.294	.496
HORIZONTAL SPREAD	.587	.524	.141
VERTICAL SPREAD	2.098	1.962	.797
EXTREME SPREAD	2.108	1.999	.809
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	3		
NUMBER IN THREE INCH CIRCLE =	5		

M-700. 7X64  
AMMO- NORMA.  
 150GR. SP SPIRE PT.  
 INDEX- 17013  
 LOT - 02723  
SCOPE- LYMAN  
 ALL AMERICAN. 20X  
 LEUPOLD RINGS & BASES  
RANGE- 100 YDS  
REST- SAND BAG

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# CENTERFIRE PATTERNS # 2



# OF SHOTS- 5

# IN CIR

1in = 3

2in = 4

3in = 5

HS= 1.742

VS= .774

GS= 1.795

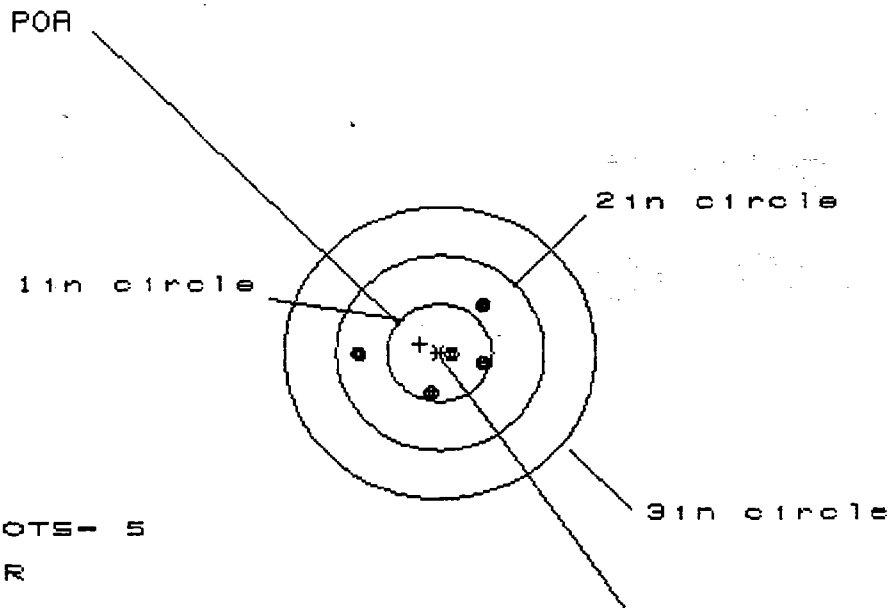
CENTROID #

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	

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# CENTERFIRE PATTERNS # 3



# OF SHOTS- 5

# IN CIR

1in = 3

2in = 5

3in = 5

HS= 1.253

VS= .859

GS= 1.334

CENTROID \*

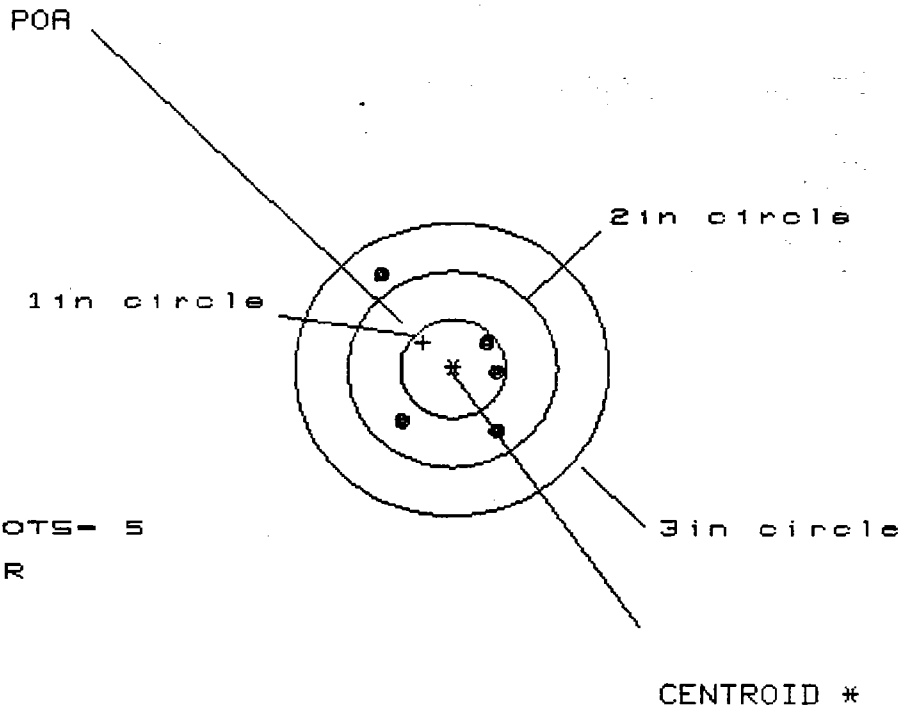
PATTERN #	3	4	3
SHOTS (BEST OF)	5	4	3
MAXIMUM X	.425	.218	.247
MINIMUM X	-.828	-.341	-.268
MAXIMUM Y	.488	.496	.145
MINIMUM Y	-.371	-.363	-.198
CENTROID X	-.186	.393	.320
CENTROID Y	-.090	-.098	-.263
POA TO CENTROID in.	.207	.405	.414
MIN RADIUS	.158	.056	.147
MEAN RADIUS	.485	.326	.244
MAX RADIUS	.828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

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# CENTERFIRE PATTERNS # 1



# OF SHOTS - 5  
 # IN CIR  
 1in = 2  
 2in = 4  
 3in = 5  
 HS = 1.156  
 VS = 1.667  
 GS = 2.029

AVG - 1.57

PATTERN # : 1

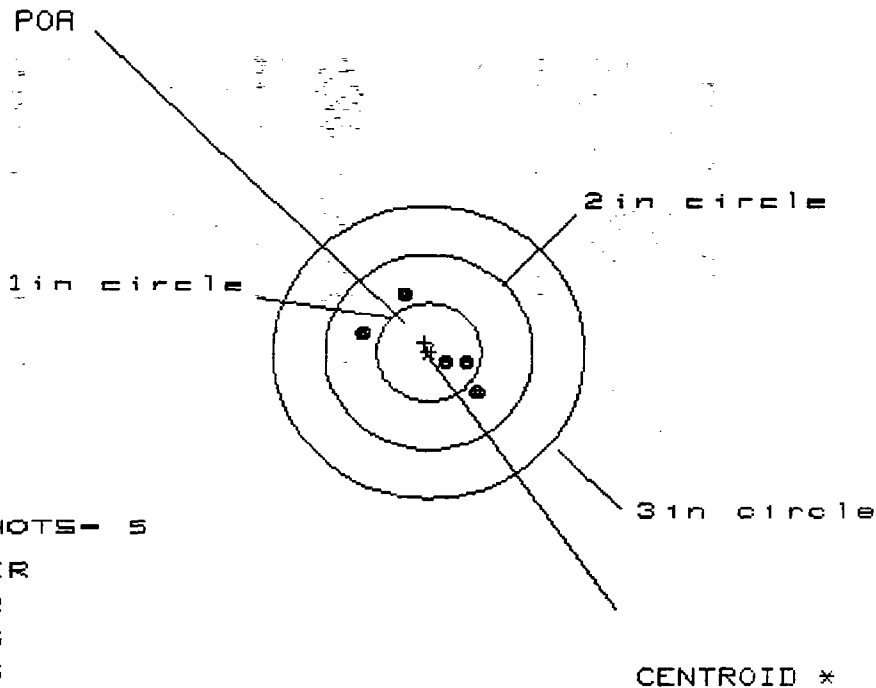
SHOTS (BEST OF)	5	4	3
MAXIMUM X	.466	.293	.320
MINIMUM X	-.690	-.616	-.518
MAXIMUM Y	1.014	.515	.382
MINIMUM Y	-.653	-.399	-.455
CENTROID X	.282	.455	.357
CENTROID Y	-.272	-.526	-.393
POA TO CENTROID in.	.392	.695	.531
MIN RADIUS	.378	.304	.328
MEAN RADIUS	.706	.505	.483
MAX RADIUS	1.227	.695	.690
HORIZONTAL SPREAD	1.156	.909	.838
VERTICAL SPREAD	1.667	.914	.837
EXTREME SPREAD	2.029	1.101	1.101
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		4	
NUMBER IN THREE INCH CIRCLE =		5	

m-700. 7X64  
 Ammo: NORMA  
 150 GR. SP. SPIRE PT.  
 INDEX 17013  
 LOT 02723  
 SCOPE: LYMAN  
 ALL AMERICAN - 20X  
 LEUPOLD RINGS & BASE  
 RANGE - 100 YDS.  
 REST - SAND BAG.

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# CENTERFIRE PATTERNS # 2



# OF SHOTS- 5

# IN CIR

1in - 2

2in - 5

3in - 5

HS- 1.118

VS- .997

GS- 1.268

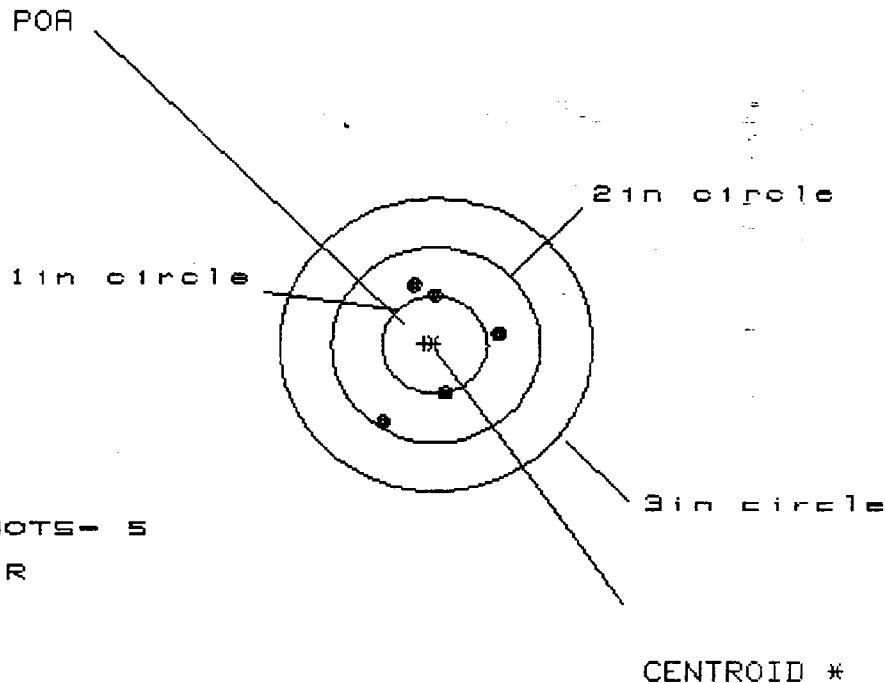
PATTERN #	2	4	3
SHOTS (BEST OF)	5	4	3
MAXIMUM X	.465	.301	.280
MINIMUM X	-.653	-.435	-.335
MAXIMUM Y	.556	.596	.462
MINIMUM Y	-.441	-.402	-.245
CENTROID X	.037	.201	.100
CENTROID Y	-.096	-.136	-.002
POA TO CENTROID in.	.103	.242	.100
MIN RADIUS	.170	.094	.223
MEAN RADIUS	.495	.386	.389
MAX RADIUS	.672	.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		



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# CENTERFIRE PATTERNS # 3



# OF SHOTS- 5

# IN CIR

1in = 1

2in = 5

3in = 5

HS= 1.117

VS= 1.376

GS= 1.412

PATTERN #	3	4	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	.097	.223	.327
CENTROID Y	-.014	.179	.041
POA TO CENTROID in.	.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 INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	5		