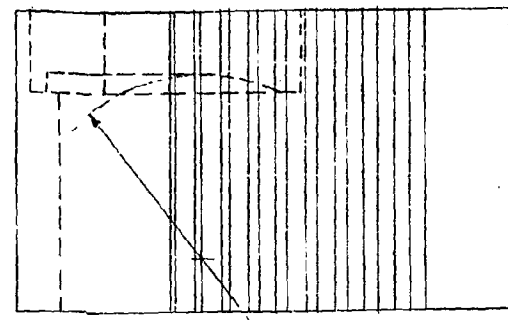


C-15453

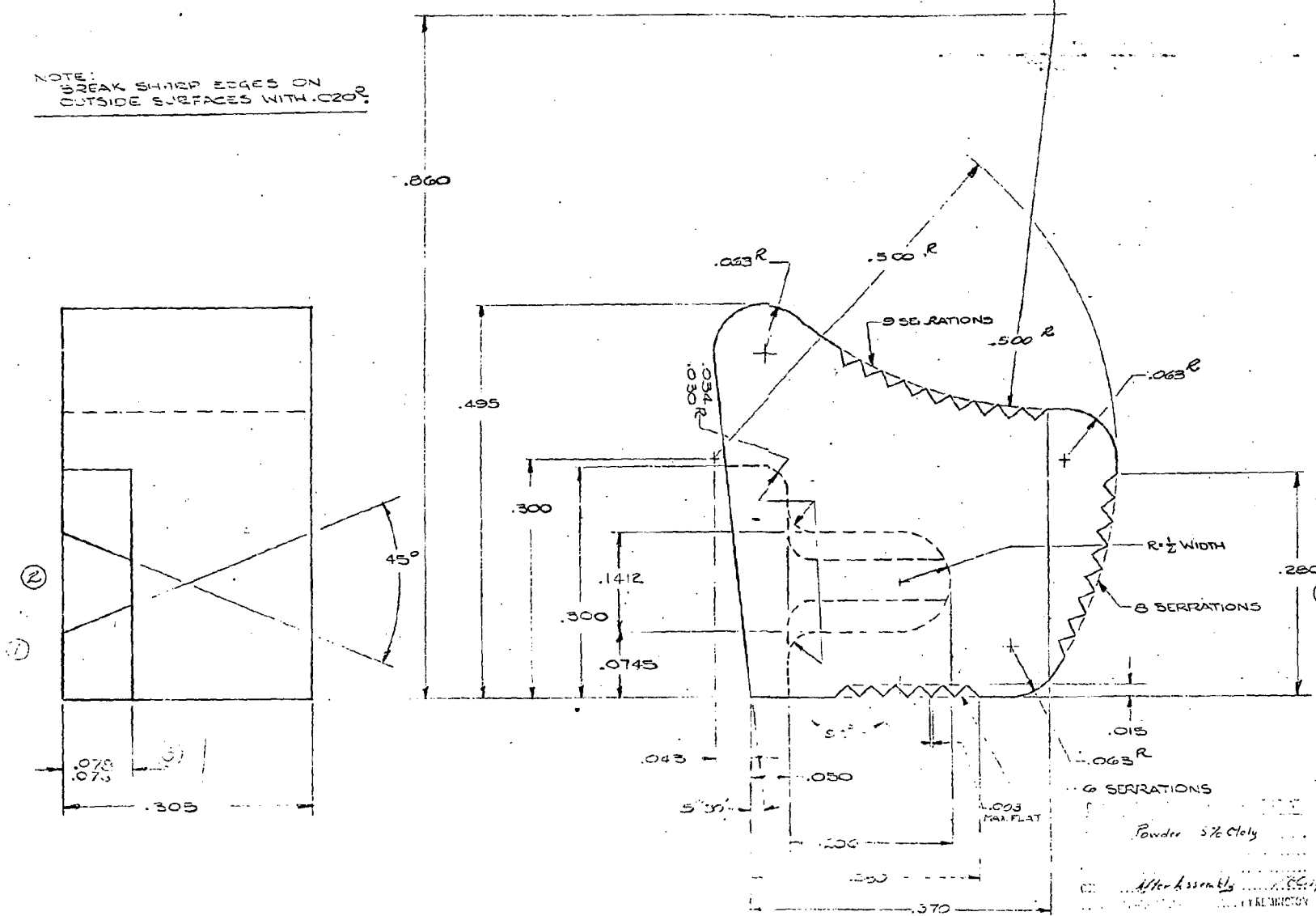
DO NOT SCALE THIS DRAWING. WORK TO FIGURES
UNLESS OTHERWISE NOTED. TOLERANCES
ON DECIMAL DIMENSIONS ARE $\pm .003$
ON FRACTIONAL DIMENSIONS $\pm .004$
ON ANGULAR DIMENSIONS $\pm .00430$
FINISHES ARE DESIGNATED BY ROST MEAN
SQUARE (R.M.S.) MICRO-INCH ROUGHNESS
VALUES AND ARE THE MAXIMUM ROUGH-
NESS ACCEPTABLE, UNLESS OTHERWISE
SPECIFIED. FINISH ROUGHNESS TO BE
V OR BETTER.

LET.	WAR	REFERENCE	BY	DATE
1	ADD USE 600	84244		
2	ADD USE 600	84244		
3	ADD USE 600	84244		
4	ADD USE 600	84244		
5	ADD USE 600	84244		
6	ADD USE 600	84244		
7	ADD NOTE			



3 R
16

NOTE:
BREAK SHARP EDGES ON
OUTSIDE SURFACES WITH .C20°



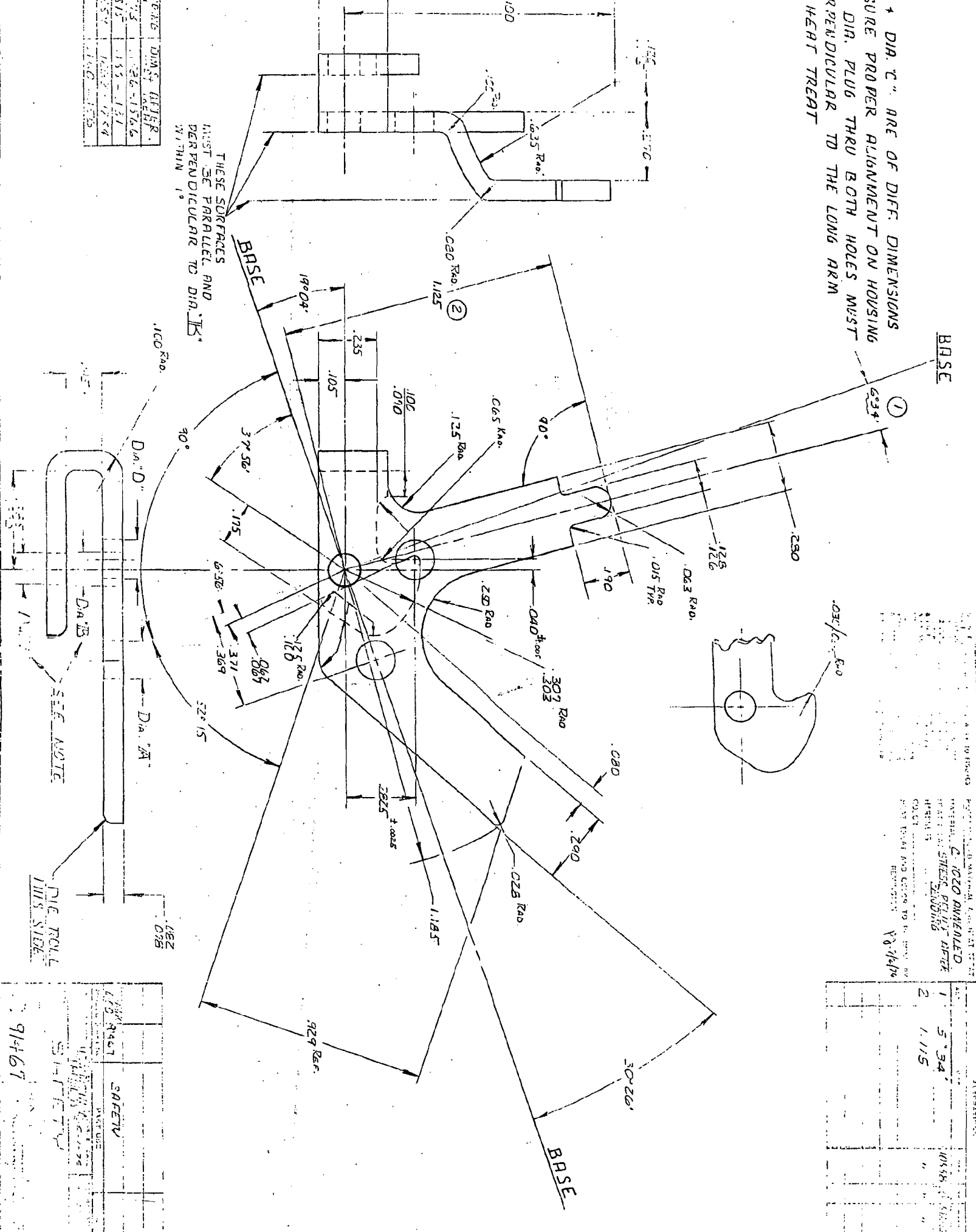
FOR PART SALES
ONLY

5	RESEARCH	SAFETY THUMBPIECE	1	
4	600	SAFETY THUMBPIECE	1	
3	600	SAFETY THUMBPIECE	1	
MODEL		PART USE	JUAN	SEE
DESIGN DATE	DRAWN BY DATE	CHECK BY DATE	APPR BY DATE	
TITLE: THUMBPIECE				
NUMBER	SCALE	RESEARCH & DEV. DEPT.		
C-15453	10X	REMINGTON ARMS CO. INC.		

* DIA. "C" ARE OF DIFF. DIMENSIONS
 TO ASSURE PROPER ALIGNMENT ON HOUSING
 DIA. PLUG THRU BOTH HOLES MUST
 BE PERPENDICULAR TO THE LONG ARM
 HEAT TREAT

ITEM	DIMS	DIFFER.
1	1.34	1.34
2	1.34	1.34
3	1.34	1.34
4	1.34	1.34
5	1.34	1.34
6	1.34	1.34
7	1.34	1.34
8	1.34	1.34
9	1.34	1.34
10	1.34	1.34

THESE SURFACES
 MUST BE PARALLEL AND
 PERPENDICULAR TO DIA. "C"
 WITHIN 1°



1000 UNANIMATED
 MATERIAL: C-1020 UNANIMATED
 HEAT TREAT: STRESS RELIEF AFTER
 BENDING
 COAT: OIL AND COAT TO THE MAX. NO.
 PART TOLERANCE AND COAT TO THE MAX. NO.
 REMARKS
 10/16/76

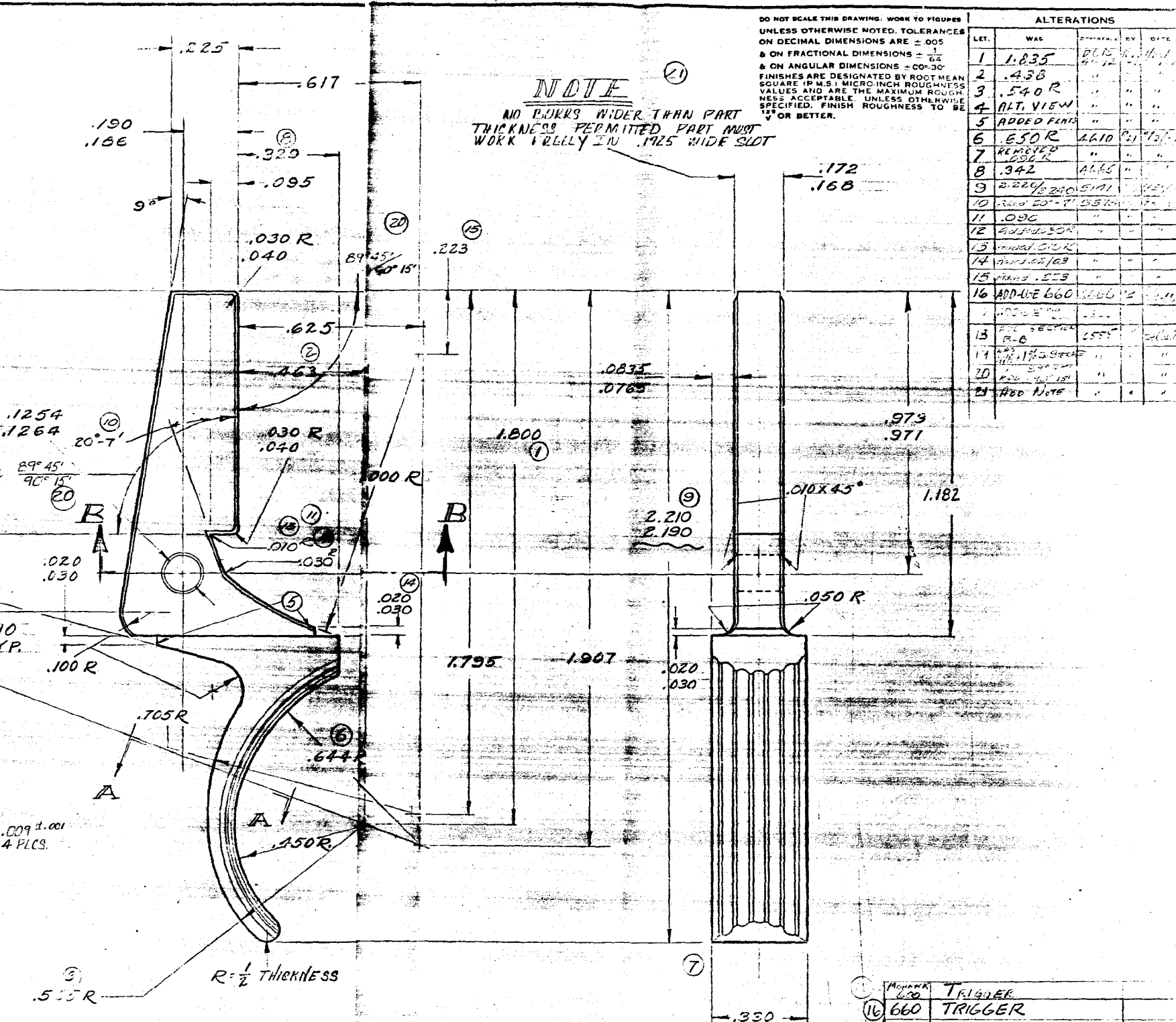
ITEM	DIMS	DIFFER.
1	5.34	105.58
2	1.115	"

ITEM	DIMS	DIFFER.
1	1.34	1.34
2	1.34	1.34
3	1.34	1.34
4	1.34	1.34
5	1.34	1.34
6	1.34	1.34
7	1.34	1.34
8	1.34	1.34
9	1.34	1.34
10	1.34	1.34

91467

SAFETY

P/N: 468		SAFETY ASSEMBLY	
MODEL	PART NO.	PART USE	
DATE BY DATE	ISSUED BY DATE	CHK. BY DATE	APP. BY DATE
15-JUNE-76	15-JUNE-76	15-JUNE-76	15-JUNE-76
ASSEMBLY			
SCALE	NO. OF SHEETS	REF. BY DATE	
41			
DEFINITION OF ARMS CO. INC.			



RECOMMENDED MATERIAL AND HEAT TREAT

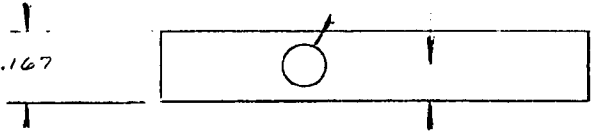
MODEL	660	TRIGGER
DES'D BY DATE	10/12/11	
DRAWN BY DATE	10/12/11	
CHECK BY DATE		
APPR BY DATE		
TITLE	TRIGGER	

DO NOT SCALE THIS DRAWING. WORK TO FIGURES
UNLESS OTHERWISE NOTED
TOLERANCES ON DECIMAL DIMENSIONS ARE
1 PLACE .01 — TOLERANCE ± .015
2 PLACE .01 — TOLERANCE ± .005
3 PLACE .001 — TOLERANCE ± .002
4 ON FRACTIONAL DIMENSIONS ± .001
5 ON ANGLE DIMENSIONS ± .01°
FIGURES NOTED IN PARENTS OF DIMENSIONS
VALUES AND ARE THE MAXIMUM PERMISSIBLE
ACCEPTABLE, UNLESS OTHERWISE SPECIFIED.
FINISH ROUGHNESS TO BE .125 OR BETTER

RECOMMENDED MATERIAL AND HEAT TREAT
MATERIAL C-1010
HEAT TREAT CYL. HARDENED & TEMPERED
HARDNESS T15 HRPD
COLOR
HEAT TREAT AND COLOR TO BE DONE BY
REVLINGTON P88 14-1-70

ALTERATIONS				
ALT	WAS	REF	BY	DATE
10	REV'D. & REDWN.	10-4-71		
11	ADDED NOTE & VIEW	10-4-71		

.100-.105 DIA.



THEORETICAL
SHARP CORNER

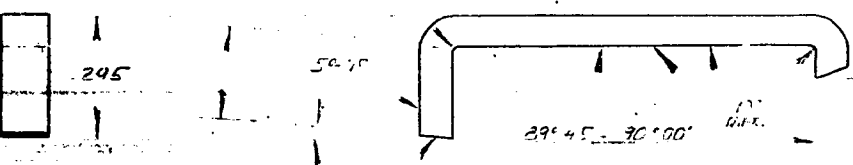
CE
CE1

.220 AT 6° TO THE
THEORETICAL SHARP
CORNER
AFTER HEAT TREAT

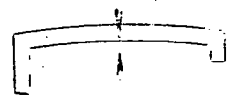
.155
.149

.0765
.0740

0.15



.015 MAX
PLACES



NOTE: THE
HOLE IS TO BE
DRILLED TO THE
FULL DEPTH

16

.076
.074 GRIND AFTER HEAT TREAT TO DIMENSION SHOWN

GROUND END MUST BE SQUARE
WITH LEG WITHIN ± .1

7

NOTE

1. CHECK DIMENSIONS AND TOLERANCES
BEFORE BEGINNING WORK
WITH LOTS OF DIMENSIONS
SURFACES AT 90 DEGREES
TO EACH OTHER
ON LOTS OF DIMENSIONS

7

2. INSIDE SURFACES MUST BE GRINDED
AND POLISHED
3. PART MUST BE TESTED TO SPEC

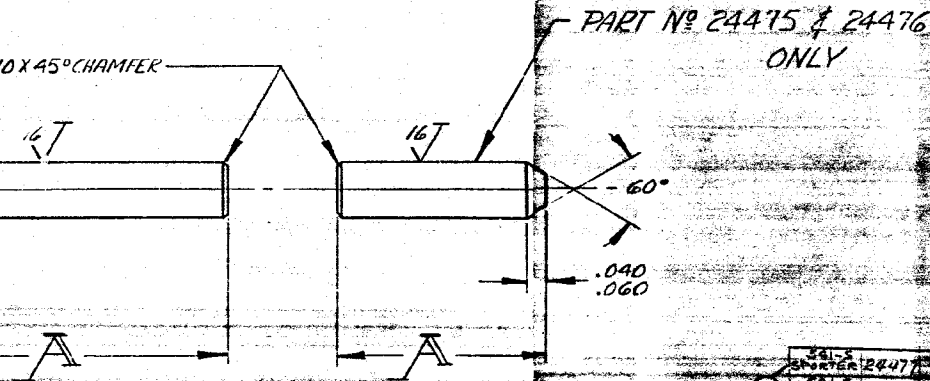
RECOMMENDED MATERIALS AND HEAT TREAT

MATERIAL AISI 61095 OR A50100
 HEAT TREAT HARDEN
 FINISHES R45N 43/49
 COLOR NITRE BLACK
 HEAT TREAT AND COLOR TO BE DONE BY REF.

DO NOT SCALE THIS DRAWING: WORK TO FIGURES
 UNLESS OTHERWISE NOTED, TOLERANCES
 ON DECIMAL DIMENSIONS ARE $\pm .005$
 & ON FRACTIONAL DIMENSIONS $\pm .004$
 & ON ANGULAR DIMENSIONS $\pm .004$
 FINISHES ARE DESIGNATED BY ROOT MEAN
 SQUARE (R.M.S.) MICRO-INCH ROUGHNESS
 VALUES AND ARE THE MAXIMUM ROUGH-
 NESS ACCEPTABLE, UNLESS OTHERWISE
 SPECIFIED. FINISH ROUGHNESS TO BE
 125 OR BETTER.

ALTERATIONS

LET.	WAS	REFERENCE	BY	DATE
59	REDEAWN	6015	DD	10/1/77
60	ADD USE 660	6059	72	1/1/78
61	ADD	6075	72	1/1/78
62	5807C	6075	72	1/1/78
63	ADD USE 660	6089	72	1/1/78
64	ADD USE	6075	72	1/1/78
65	ADD USE	6075	72	1/1/78
66	ADD USE	6075	72	1/1/78
67	ADD USE 580 SERIES 718 SERIES	10352	72	1/1/78



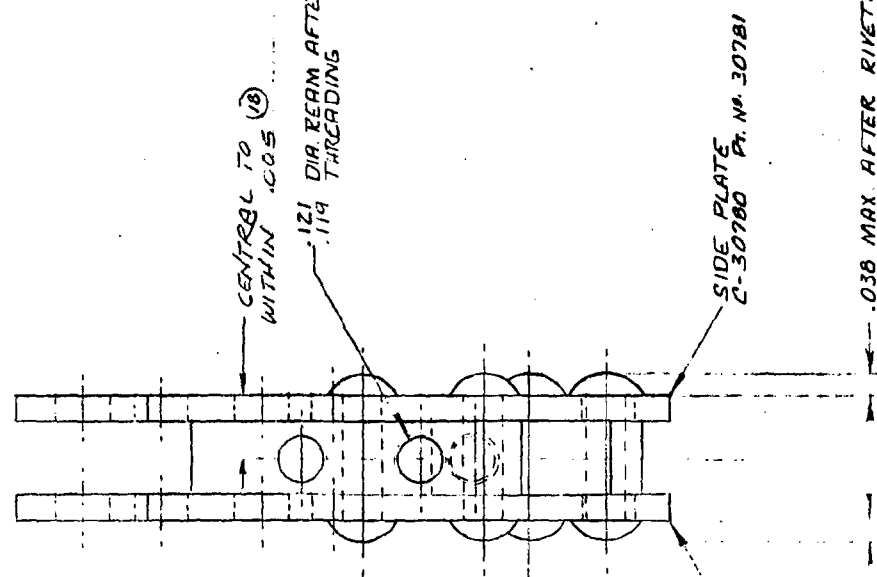
A	PART NUMBER
.365	24475
.715	24476
.360	24477
1.000	24478
.985	24479
.555	24479
.540	24480
.625	24480
.240	24481
1.250	24482
.500	24483
.295	24484

24475	24475	TRIGGER SPRING	1	P.L.
24476	24476	SEAR PIN	1	P.L.
24477	24477	TRIGGER PIN	1	P.L.
24478	24478	TRIGGER PIN	1	P.L.
24479	24479	SEAR PIN	2	P.L.
24480	24480	BOLT STOP PIN	1	P.L.
24481	24481	TRIGGER SPRING	1	P.L.
24482	24482	TRIGGER PIN	1	P.L.
24483	24483	SEAR PIN	1	P.L.
24484	24484	TRIGGER PIN	1	P.L.
24485	24485	SEAR PIN	2	P.L.
24486	24486	BOLT STOP PIN	1	P.L.
24487	24487	BOLT STOP PIN	1	P.L.
24488	24488	DISCONNECT PIVOT PIN	2	P.L.
24489	24489	TRIGGER PIN 202	1	D27565
24490	24490	SEAR LEVER PIN 202	1	D27565
24491	24491	TRIGGER PIN	1	P.L.
24492	24492	BOLT STOP PIN	1	P.L.
24493	24493	SEAR PIN	1	P.L.
24494	24494	TRIGGER PIN	1	P.L.
24495	24495	SEAR PIN	1	P.L.
24496	24496	BOLT STOP PIN	1	P.L.
24497	24497	EJECTOR PIN	1	P.L.
24498	24498	TRIGGER PIN	1	P.L.
24499	24499	BOLT STOP PIN	1	P.L.
24500	24500	SEAR PIN	1	P.L.
24501	24501	TRIGGER PIN	1	P.L.
24502	24502	EJECTOR PIN	1	P.L.
24503	24503	TRIGGER PIN	2	P.L.
24504	24504	TRIGGER PIN	1	P.L.
24505	24505	SEAR PIN	1	P.L.
24506	24506	TRIGGER PIN	1	P.L.
24507	24507	SEAR PIN	1	P.L.
24508	24508	TRIGGER PIN	1	P.L.
24509	24509	SEAR PIN	1	P.L.
24510	24510	TRIGGER PIN	1	P.L.
24511	24511	SEAR PIN	1	P.L.
24512	24512	TRIGGER PIN	1	P.L.
24513	24513	SEAR PIN	1	P.L.
24514	24514	TRIGGER PIN	1	P.L.
24515	24515	SEAR PIN	1	P.L.
24516	24516	TRIGGER PIN	1	P.L.
24517	24517	SEAR PIN	1	P.L.
24518	24518	TRIGGER PIN	1	P.L.
24519	24519	SEAR PIN	1	P.L.
24520	24520	TRIGGER PIN	1	P.L.
24521	24521	SEAR PIN	1	P.L.
24522	24522	TRIGGER PIN	1	P.L.
24523	24523	SEAR PIN	1	P.L.
24524	24524	TRIGGER PIN	1	P.L.
24525	24525	SEAR PIN	1	P.L.
24526	24526	TRIGGER PIN	1	P.L.
24527	24527	SEAR PIN	1	P.L.
24528	24528	TRIGGER PIN	1	P.L.
24529	24529	SEAR PIN	1	P.L.
24530	24530	TRIGGER PIN	1	P.L.
24531	24531	SEAR PIN	1	P.L.
24532	24532	TRIGGER PIN	1	P.L.
24533	24533	SEAR PIN	1	P.L.
24534	24534	TRIGGER PIN	1	P.L.
24535	24535	SEAR PIN	1	P.L.
24536	24536	TRIGGER PIN	1	P.L.
24537	24537	SEAR PIN	1	P.L.
24538	24538	TRIGGER PIN	1	P.L.
24539	24539	SEAR PIN	1	P.L.
24540	24540	TRIGGER PIN	1	P.L.
24541	24541	SEAR PIN	1	P.L.
24542	24542	TRIGGER PIN	1	P.L.
24543	24543	SEAR PIN	1	P.L.
24544	24544	TRIGGER PIN	1	P.L.
24545	24545	SEAR PIN	1	P.L.
24546	24546	TRIGGER PIN	1	P.L.
24547	24547	SEAR PIN	1	P.L.
24548	24548	TRIGGER PIN	1	P.L.
24549	24549	SEAR PIN	1	P.L.
24550	24550	TRIGGER PIN	1	P.L.
24551	24551	SEAR PIN	1	P.L.
24552	24552	TRIGGER PIN	1	P.L.
24553	24553	SEAR PIN	1	P.L.
24554	24554	TRIGGER PIN	1	P.L.
24555	24555	SEAR PIN	1	P.L.
24556	24556	TRIGGER PIN	1	P.L.
24557	24557	SEAR PIN	1	P.L.
24558	24558	TRIGGER PIN	1	P.L.
24559	24559	SEAR PIN	1	P.L.
24560	24560	TRIGGER PIN	1	P.L.
24561	24561	SEAR PIN	1	P.L.
24562	24562	TRIGGER PIN	1	P.L.
24563	24563	SEAR PIN	1	P.L.
24564	24564	TRIGGER PIN	1	P.L.
24565	24565	SEAR PIN	1	P.L.
24566	24566	TRIGGER PIN	1	P.L.
24567	24567	SEAR PIN	1	P.L.
24568	24568	TRIGGER PIN	1	P.L.
24569	24569	SEAR PIN	1	P.L.
24570	24570	TRIGGER PIN	1	P.L.
24571	24571	SEAR PIN	1	P.L.
24572	24572	TRIGGER PIN	1	P.L.
24573	24573	SEAR PIN	1	P.L.
24574	24574	TRIGGER PIN	1	P.L.
24575	24575	SEAR PIN	1	P.L.
24576	24576	TRIGGER PIN	1	P.L.
24577	24577	SEAR PIN	1	P.L.
24578	24578	TRIGGER PIN	1	P.L.
24579	24579	SEAR PIN	1	P.L.
24580	24580	TRIGGER PIN	1	P.L.
24581	24581	SEAR PIN	1	P.L.
24582	24582	TRIGGER PIN	1	P.L.
24583	24583	SEAR PIN	1	P.L.
24584	24584	TRIGGER PIN	1	P.L.
24585	24585	SEAR PIN	1	P.L.
24586	24586	TRIGGER PIN	1	P.L.
24587	24587	SEAR PIN	1	P.L.
24588	24588	TRIGGER PIN	1	P.L.
24589	24589	SEAR PIN	1	P.L.
24590	24590	TRIGGER PIN	1	P.L.
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24592	24592	TRIGGER PIN	1	P.L.
24593	24593	SEAR PIN	1	P.L.
24594	24594	TRIGGER PIN	1	P.L.
24595	24595	SEAR PIN	1	P.L.
24596	24596	TRIGGER PIN	1	P.L.
24597	24597	SEAR PIN	1	P.L.
24598	24598	TRIGGER PIN	1	P.L.
24599	24599	SEAR PIN	1	P.L.
24600	24600	TRIGGER PIN	1	P.L.

40XCF	24477	TRIGGER PIN	1	22765
40XCF	24476	SEAR PIN	1	22765
40XCF	24475	BOLT STOP PIN	1	22765
412-A	24480	EJECTOR PIN	1	P.L.
412-A	24482	TRIGGER PIN	1	P.L.
413	24480	EJECTOR PIN	1	P.L.
F.R.	24481	TRIGGER PIN	1	SCD-266
F.R.	24481	SET LEVER PIN	1	SCD-266
F.R.	24481	SEAR PIN	1	SCD-266
F.R.	24481	HAMMER SP. PIN	1	SCD-266
F.R.	24481	HAMMER PIN	1	SCD-266
725	24477	TRIGGER PIN	1	P.L.
725	24476	SEAR PIN	1	P.L.
412	24480	EJECTOR PIN	1	P.L.
412	24482	TRIGGER PIN	1	P.L.
NYLON 66	24477	DISCONNECT PIVOT PIN	2	P.L.
411-B	24480	EJECTOR PIN	1	P.L.
455	24478	TRIGGER PIN	2	P.L.
40X	24477	TRIGGER PIN	1	22765
40X	24476	SEAR PIN	1	22765
40X	24475	BOLT STOP PIN	1	22765
450	24479	TRIGGER STOP PIN	1	P.L.
450	24478	TRIGGER PIN	1	P.L.
411-C	24480	EJECTOR PIN	1	P.L.
722	24477	TRIGGER PIN	1	222010
721	24477	TRIGGER PIN	1	222010
722	24476	SEAR PIN	1	222010
721	24476	SEAR PIN	1	222010
722	24475	BOLT STOP PIN	1	222010
721	24475	BOLT STOP PIN	1	222010
MODEL	PART NO	PART USE	QUAN	SEE
DES'D BY DATE	DRAWN BY DATE	CHECK BY DATE	APPR BY DATE	
DD 04766	DD 04766	DD 04766	DD 04766	
TITLE	121-A			

MATERIAL	ALC.	WAS	REMARKS
HEAT TREAT	17		REC. & REDWN. 1019
HARDNESS			
COLOR	18		USED CRIPPLE TO RETURN .005 10133
HEAT TREAT AND COLOR TO BE DONE BY REMINGTON PG. 7/2/76			

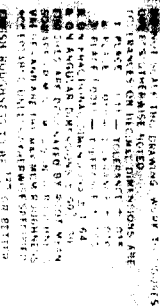
175



SIDE PLATE
C-30780 PT.NE 30780

049 RIVET HD HT.

[illegible]



DATE	NAME	REMARKS	INITIALS
10	P. H. FREDMAN	1005	W. E. L.

[illegible]

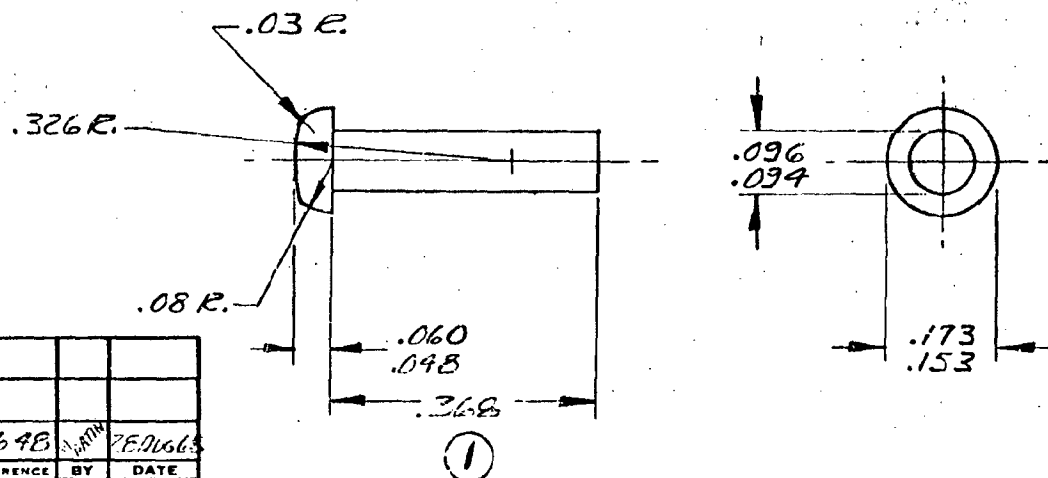
NUMBER <i>A-14632</i>		REMINGTON ARMS CO. INC. RESEARCH & DEV. DEPT.	
SCALE <i>2 X</i>	SUPERSEDES REFERENCE <i>200 7107</i>		
TITLE <i>RIVET</i>			
DES. BY DATE <i>DDK: MGL</i>	DRN. BY DATE <i>DDK: MGL</i>	CHK. BY DATE <i>DDK: MGL</i>	APP. BY DATE <i>DDK: MGL</i>
FOR DETAILS. SEE PROCESS RECORD			
MODEL	PART USE	QUAN.	SEE
<i>40XB</i>	<i>TRIGGER HOUSING RIVET</i>	<i>4</i>	<i>C20785</i>
<i>40XCF</i>	"	"	<i>C20785</i>
<i>700ADL</i>	"	"	<i>C21655</i>
<i>710BDL</i>	"	"	<i>C21655</i>
<i>710VAR</i>	"	"	<i>C21655</i>

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

RECOMMENDED MATERIAL AND HEAT TREAT	
MATERIAL	<i>STEEL</i>
HEAT TREAT	
HARDNESS	
COLOR	
HEAT TREAT AND COLOR TO BE DONE BY REMINGTON	
APPR. BY DATE	

*RIVET: AMERICAN STANDARD SMALL SOLID
TYPE: PAN HEAD*

NOTE: ALL RADII ARE APPROXIMATE



1	400 5.015	7648	7691665	
ALT.	WAS	REFERENCE	BY	DATE
ALTERATIONS				

TFA-3 REV. 1

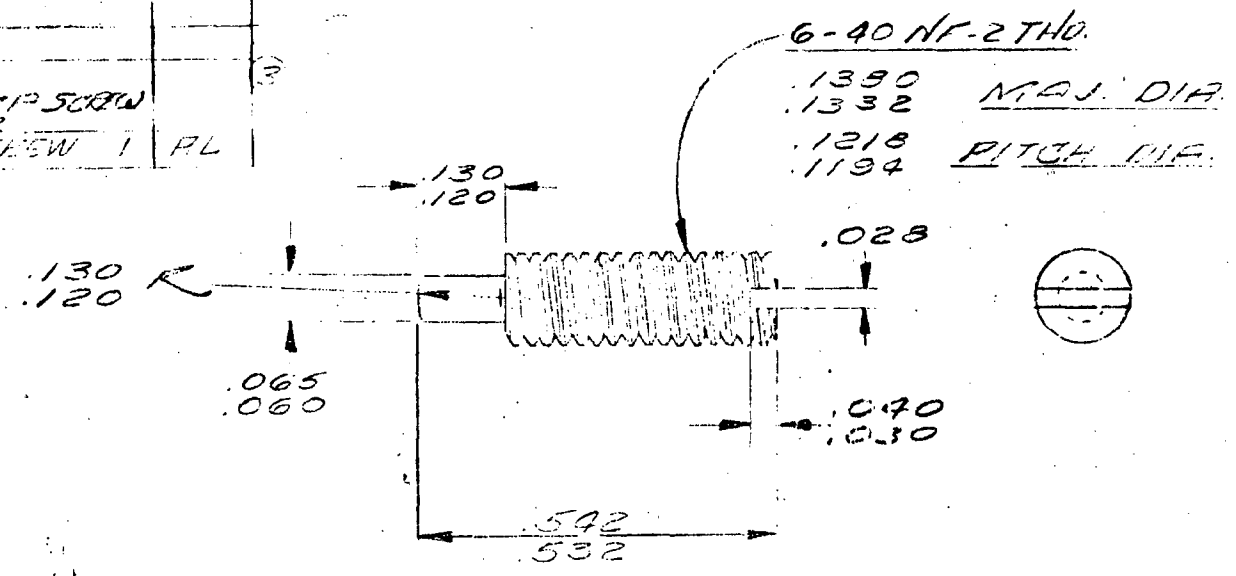
A-14632

NUMBER <i>1-12</i>		REMINGTON ARMS CO. INC. RESEARCH & DEV. DEPT.	
SCALE <i>9X</i>	SUPERSEDES REF. <i>6-11-53</i>		
TITLE <i>SCREW</i>			
DES. BY DATE	DRN. BY DATE	CHK. BY DATE	APP. BY DATE
FOR DETAILS, SEE PROCESS RECORD			

MODEL	PART USE	QUAN.	SEE
<i>7110L</i>	<i>TRIGGER STOP SCREW</i>	<i>1</i>	<i>D20345</i>
<i>7120L</i>	<i>"</i>	<i>"</i>	<i>"</i>
<i>40XB</i>	<i>TRIGGER STOP SCREW</i>	<i>1</i>	<i>PL</i>
<i>1FR</i>	<i>202 TRIGGER</i>	<i>"</i>	<i>"</i>
<i>710 JAR</i>	<i>TRIG STOP SCREW</i>	<i>1</i>	<i>PL</i>

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

RECOMMENDED MATERIAL AND HEAT TREAT
MATERIAL *08-12-1000*
HEAT TREAT *003-006 CASE*
HARDNESS
COLOR *NITRE PLATE*
HEAT TREAT AND COLOR TO BE DONE BY REMINGTON



<i>6</i>	<i>40XB</i>	<i>8178</i>	<i>JA</i>	<i>10-31-59</i>
<i>7</i>	<i>ADDED 115F</i>	<i>6400</i>	<i>IL</i>	<i>1-1-59</i>
<i>8</i>	<i>ADD 115F</i>	<i>211</i>	<i>"</i>	<i>"</i>
<i>9</i>	<i>"</i>	<i>640</i>	<i>"</i>	<i>"</i>
<i>10</i>	<i>"</i>	<i>115F</i>	<i>"</i>	<i>"</i>
ALT.	WAS	REFERENCE	BY	DATE

TFA-3 REV. 1 ALTERATIONS

A 15421

NUMBER A-17047		REMINGTON ARMS CO. INC. RESEARCH & DEV. DEPT.	
SCALE 72		SUPERSEDES REFERENCE 51-A-1950	
TITLE SPRING, HELICAL COMP			
DES. BY DATE	DRN. BY DATE JW B 6/19/69	CHK. BY DATE	APP. BY DATE
FOR DETAILS, SEE PROCESS RECORD			
MODEL	PART USE	QUAN.	SEE
700	SEAR SPRING		
40XB	SEAR SPRING		
40XCF	SEAR SPRING		
660	SEAR SPRING		
40XB-1FR	SEAR SPRING 208 TRIGGER		
22 MOHAWK 600	SEAR SPRING		

RECOMMENDED MATL. & HEAT TREAT
 Material
 Heat Treat
 Approval (By Date)

INSPECTION

1. To work freely in .151 dia. hole
2. To work freely on — dia. pin
3. Load 6.0 to 6.8 at .330 length (with set removed)
4. Solid Height .303 max. 7. Wind R H
5. Free Length .460 min. 8. Remove set ~~Yes~~
6. Ends SG + GR (No [except for inspection])

MANUFACTURE

9. Wire dia. .026
10. Outside dia. .146
11. Free Length .485 (with set removed)
12. Coils 9.6 Active 11.6 Total

DESIGN DATA

13. Rate 41.14 lb./in.
14. Solid Stress 74,684 lb./sq. in.
15. Solid Load 7.48 lb.
16. Spring Index 4.62
17. Torsional Mod. $G = 11.5 \times 10^6$ lb./sq. in.
18. Concentric Corr. 1.341

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

22	ADD MOHAWK USE 600	8445	RCE	9-11-70
21	.153		JK	1/8/70
20	REVISED REDRAWN	8179	JK	10/31/69
ALT.	WAS	REFERENCE	BY	DATE
TFA-3 REV. 2 ALTERATIONS				

A17047

NUMBER A-15400		REMINGTON ARMS CO. INC. RESEARCH & DEV. DEPT.	
TITLE SPRING		SCALE —	SUPERSEDES REFERENCE A-17578
DES. BY DATE 10-11-61	DRN. BY DATE 10-11-61	CHK. BY DATE 10-11-61	APP. BY DATE 10-11-61
FOR DETAILS, SEE PROCESS RECORD			
MODEL	PART USE	QUAN.	SEE
700-00	TRIGGER SPRING	1	D-26395
700BOL	TRIGGER ADJUSTING SPRING	1	D-27565
40XB IFA	2 OE TRIGGER	1	P.L.
700VAR	TRIGGER SPRING	1	P.L.

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

RECOMMENDED MATERIALS
MUSIC WIRE
STRESS RELIEVE
HARDNESS.....
COLOR.....
HEAT TREAT AND COLOR TO BE DONE BY REMINGTON

INSPECTION

- To work freely in .117 dia. hole
 - To work freely on .060 dia. pin
 - *Load 5.0 to 6.7 lb. at .177 length (with set removed)
 - Solid Height .150 max. 7. Wind 4 H
 - Free Length .200 min. 8. Remove set (Yes/No) (except for inspection)
 - Ends GROUND
- * Approximate length limits to nearest 64th inch at constant load in lbs.
and nearest 1/4 oz. Load lbs. ozs. at to in. length

MANUFACTURE

- Wire dia. .027
- Free Length .203
- Outside dia. .114
- Coils 5 Active 5 1/2 Total

DESIGN DATA

- Rate 225 lb./in.
- Spring Index 3.2
- Solid Stress 202,000 lb/sq.in.
- Torsional Mod. $G = 11.5 \times 10^6$ lb/sq.in.
- Solid Load 11.9 lb.
- Wahl Factor 1.53
- Concentric Corr. 1.53

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

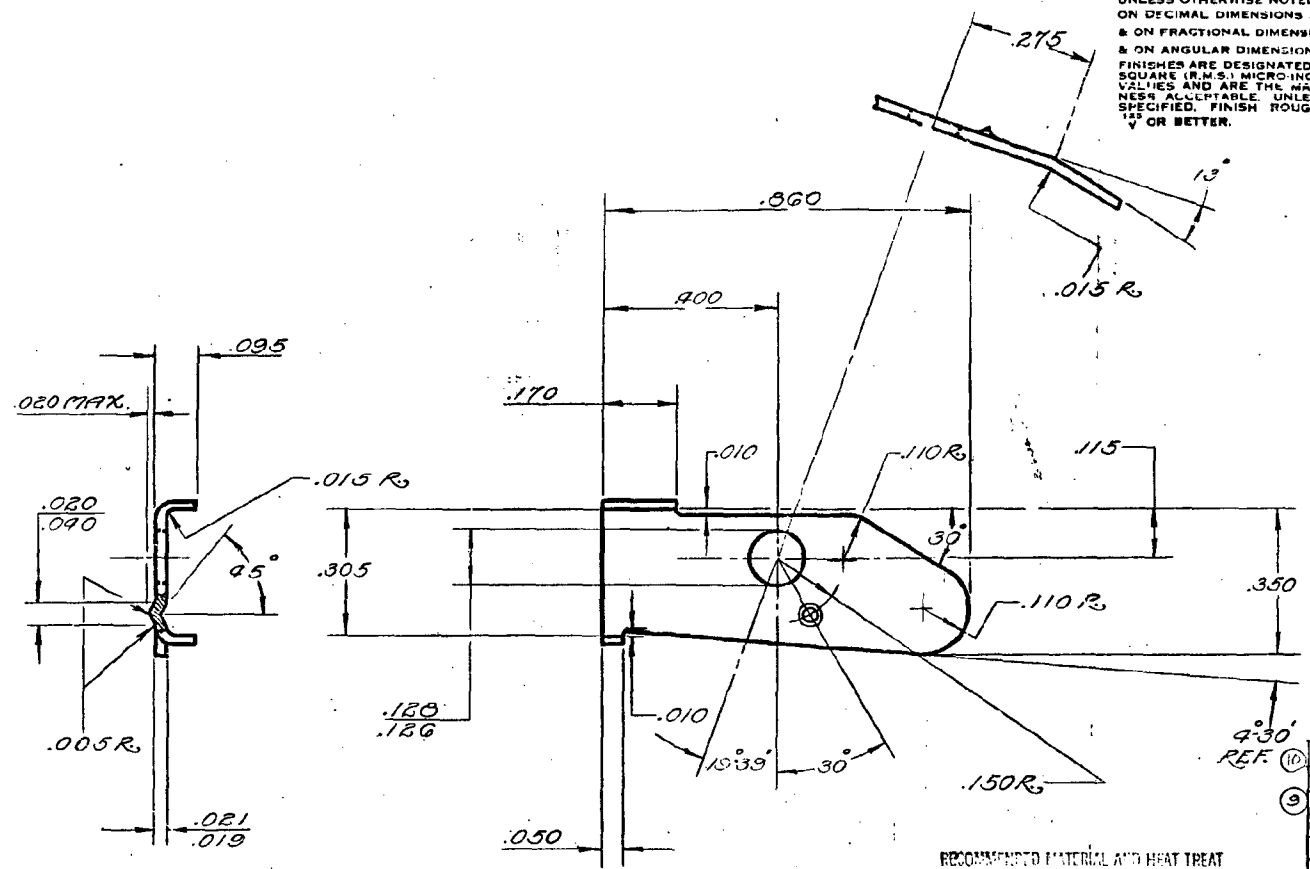
7	40XB & 40XF	8179	JK	10-31-64
6	Added	8005	JK	6-17-69
5	40XB & 40XF	7110	DD	7-11-67
4	ADDED USE	6479	DD	3-15-66
3	ADD USE 40X-B	5129	OE	1-25-65
2	700	4445	OE	11-24-62
1	WITH SET REMOVED	4382	RJS	11-13-61
ALT.	WAS	REFERENCE	BY	DATE
TFA 3 REV. 1 ALTERATIONS				

A-15400

6-10360

DO NOT SCALE THIS DRAWING. WORK TO FIGURES
UNLESS OTHERWISE NOTED. TOLERANCES
ON DECIMAL DIMENSIONS ARE $\pm .003$
& ON FRACTIONAL DIMENSIONS $\pm \frac{1}{64}$
& ON ANGULAR DIMENSIONS $\pm .003^\circ$
FINISHES ARE DESIGNATED BY ROOT MEAN
SQUARE (R.M.S.) MICRO-INCH ROUGHNESS
VALUES AND ARE THE MAXIMUM ROUGH-
NESS ACCEPTABLE, UNLESS OTHERWISE
SPECIFIED. FINISH ROUGHNESS TO BE
125 OR BETTER.

ALTERATIONS				
LET.	WAS	REFERENCE	BY	DATE
7	REDRAWN	2658	AK	3-29-61
8	5-15360	"	LA	"
9	ADD USE 5120	"	"	"
10	ADDED USE 6473	"	"	"
11	76-75 RA	"	"	"



RECOMMENDED MATERIAL AND HEAT TREAT

MATERIAL C-1095
HEAT TREAT RACN 66-69
COLOR TEMPER COLOR
HEAT TREAT AND COLOR CODE BY REMINGTON

6-15360

7.10 VAR	SAFETY DETENT SPRING	D-2634
100B1A	SAFETY DETENT SPRING	D-2756
100B2A	SAFETY DETENT SPRING	D-2756
100B3A	SAFETY DETENT SPRING	D-2756
100B4A	SAFETY DETENT SPRING	D-2756

MODEL	PART USE	QUAN.	SEE
DES'D BY DATE	DRAWN BY DATE	CHECK BY DATE	APPR. BY DATE
AK	AK	AK	AK

TITLE SPRING

NUMBER 7 SCALE 1:1 SUPERSEDES-REFERENCE 7-15360

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

TP&A REV. 2

B 23220

DO NOT SCALE THIS DRAWING. COPY TO FIGURES
UNLESS OTHERWISE NOTED. TOLERANCES
ON DECIMAL DIMENSIONS ARE .005
ON FRACTIONAL DIMENSIONS .001
ON ANGULAR DIMENSIONS .001
FINISHES ARE DESIGNATED BY FIRST MEAN
SQUARE (R.M.S.) MICROINCH ROUGHNESS
VALUES AND ARE THE MAXIMUM ALLOWABLE
ACCEPTABLE. UNLESS OTHERWISE
SPECIFIED, FINISH ROUGHNESS TO BE .125
OR BETTER.

RECOMMENDED MATERIAL AND HEAT TREAT

MATERIAL *MILK'S STEEL*

HEAT TREAT

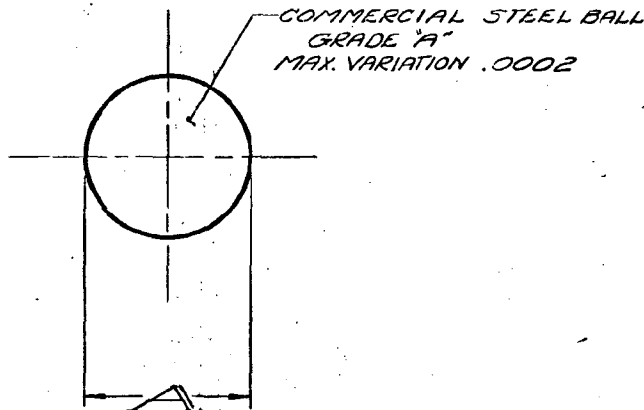
HARDNESS

COLOR

HEAT TREAT AND COLOR TO BE DONE BY
REMINGTON*12/1/15*

ALTERATIONS

ALT.	DATE	BY	DATE
33	REVISED & EXDRAWN	11/79	10/31/83
34	ADD USE	8470	10-270
35	ADD USE	8499	11/1/10
36	ADD USE - MILKAWK-48	8684	1/1/73
37	ADDED USE	9956	1/1/15
38	ADDED USE - MILKAWK-48	4967	1/1/15



DIMENSION 'A'	PART NO.
3/16	23225
3/32	23220
1/8	23221
5/32	23222
9/64 (.1406)	23223
1/4	23224

34	870LW MAG.	23223	SAFETY DETENT BALL	
	870LW	23223	SAFETY DETENT BALL	
	77	23224	SAFETY DETENT BALL	
	66	23224	SAFETY DETENT BALL	
	742	23223	ORIFICE BALL	
	742	23223	SAFETY DETENT BALL	
	552	23223	SAFETY DETENT BALL	
	572	23223	SAFETY DETENT BALL	
	760	23223	SAFETY DETENT BALL	
	1100	23223	SAFETY DETENT BALL	
	870	23223	SAFETY DETENT BALL	
	40XB	23222	SAFETY DETENT BALL	
	40XB	23223	TRIGGER ADJ. BALL	
	40XB	23222	SAFETY DETENT BALL	
	40XCF	23222	SAFETY DETENT BALL	
	40XCF	23223	TRIGGER ADJ. BALL	
37	1100	23222	OPERATING HANDLE BALL DETENT 12-16-20	12120LH
	700	23222	SAFETY DETENT BALL	
	MODEL	PART NO.	PART USE	SEE
	USED BY DATE	CHK BY DATE	CHK BY DATE	CHK BY DATE
		11/1/15	12/3/15	12/1/15
	TITLE			
			BALL	
	NUMBER			
			B 23220	
			REMINGTON ARMS CO. INC.	
			RESEARCH & DEV. DEPT.	

38	870LW MAG.	SAFETY DETENT BALL	23222
36	870LW MAG.	SAFETY DETENT BALL	23223
35	870LW MAG.	SAFETY DETENT BALL 12120	23223
	870LW	" " " 12GA	23223

02981-5

RECOMMENDED MATERIAL AND HEAT TREAT

MATERIAL 1/4" 1018 Iron

HEAT TREAT

HARDNESS (1.1 MIN. DENSITY)

COLOR

HEAT TREAT AND COLOR TO BE DONE BY REMINGTON

APPR. BY DATE 10/1/67

DO NOT SCALE THIS DRAWING: WORK TO FIGURES

UNLESS OTHERWISE NOTED, TOLERANCES ON DECIMAL DIMENSIONS ARE $\pm .003$

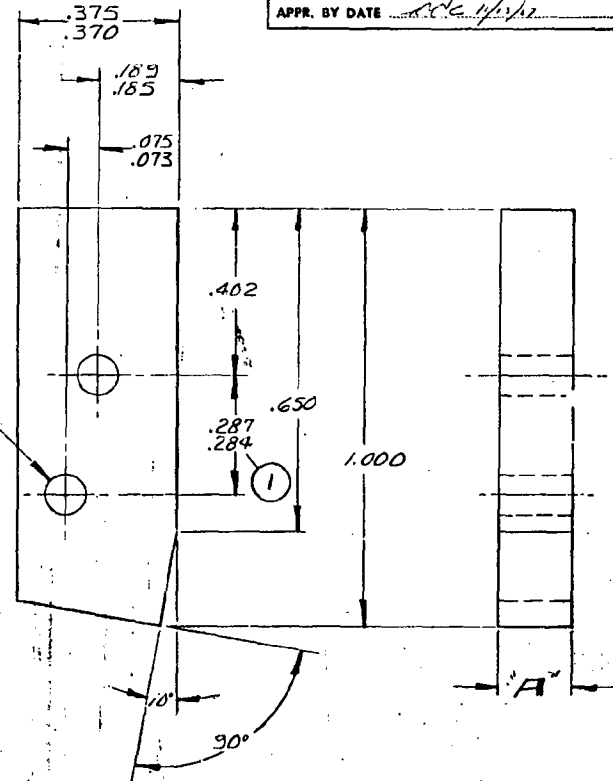
& ON FRACTIONAL DIMENSIONS $\pm .004$

& ON ANGULAR DIMENSIONS $\pm .00430^\circ$

FINISHES ARE DESIGNATED BY ROOT MEAN SQUARE (R.M.S. MICRO-INCH ROUGHNESS VALUES AND ARE THE MAXIMUM ROUGHNESS ACCEPTABLE, UNLESS OTHERWISE SPECIFIED. FINISH ROUGHNESS TO BE 125 OR BETTER.

ALTERATIONS				
LET.	WAS	REFERENCE	BY	DATE
1	266-285	2385	FM3-17-67	
2	SUPERSEDED	2385	FM3-17-67	
3	REINSTATED	2385	FM3-17-67	
4	WOLD TABLE	2385	FM3-17-67	
5	ADD USE	2385	FM3-17-67	
6	175-176	2385	FM3-17-67	
7	175-176	2385	FM3-17-67	

.0985 DIA. THRU
(2 HOLES)



DIM. A	
BLANK DIM.	180/176
FINISH DIM.	175/174

(5)	THROAT TOP	TRIG. HOUSING FRONT SPACER	C-2466	
	TOO WAR	TRIG. HOUSING FRONT SPACER	C-2466	
	TOO ADL		C-2466	
	THROAT		C-2466	
	ADJCF		C-2466	
	ADXB	TRIG. HOUSING FRONT SPACER	C-2466	
MODEL		PART USE	QUAN.	SEE
DES'D BY DATE		DRAWN BY DATE	CHECK BY DATE	APPR. BY DATE
		J.D. 30/1/67		11/1/67
TITLE				
SPACER, FRONT				
NUMBER		SCALE	SUPERSEDES-REFERENCE	
B-14630		4X	A-13923 7101	
REMINGTON ARMS CO. INC.				
RESEARCH & DEV. DEPT.				

TFB-1 REV. 2

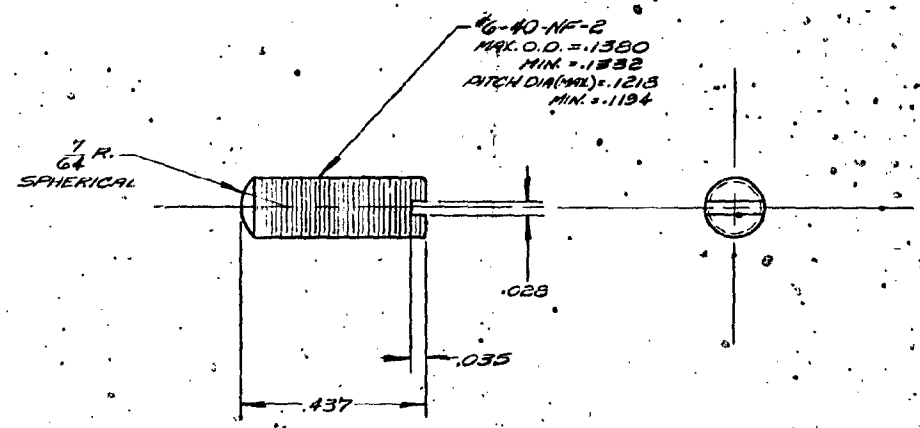
D-14630

B-91128

DO NOT SCALE THIS DRAWING. WORK TO FIGURES
UNLESS OTHERWISE NOTED.
TOLERANCES ON DECIMAL DIMENSIONS ARE:
1 PLACE (.1) — TOLERANCE ± .015
2 PLACE (.01) — TOLERANCE ± .010
3 PLACE (.001) — TOLERANCE ± .005
4 ON FRACTIONAL DIMENSIONS ± 1/64
5 ON ANGULAR DIMENSIONS ± 60'—10'
FINISHES ARE DESIGNATED BY ROOT MEAN
SQUARE (R.M.S.) MICRO-INCH ROUGHNESS
VALUES AND AT THE MAXIMUM ROUGHNESS
ACCEPTABLE, UNLESS OTHERWISE SPECIFIED.
FINISH ROUGHNESS TO BE 125 OR BETTER.

RECOMMENDED MATERIAL AND HEAT TREAT
MATERIAL: 08/20CRH5.5 STEEL
HEAT TREAT: QTN. HDN. 1250 1/2 HRS @ 1550
HARDNESS
COLOR: NITRE BLACK
HEAT TREAT AND COLOR TO BE DONE BY
REMINGTON 220 4/5/74

ALTERATIONS				
ALT.	WAS	REF.	BY	DATE



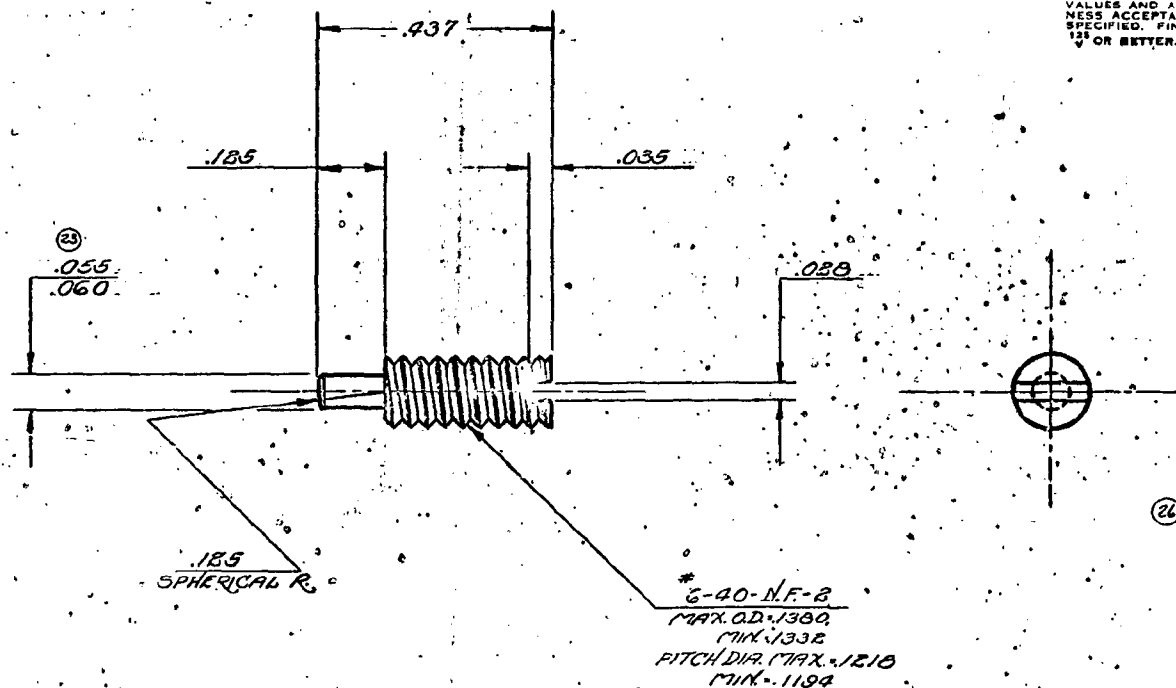
40XB 5R	TRIGGER ENGAGEMENT SCR.		
40XR			
40XC			
40XB			
700ALL	TRIGGER ENGAGEMENT SCR.		
MODEL	PART NO.	PART USE	SEE
DES. BY DATE	DRN. BY DATE	CHK. BY DATE	APP. BY DATE
	U. KEST	JW 6/11/74	JW 6/11/74
TITLE: <u>SCREW</u>			
NUMBER	SCALE	SUPERSSEDER	REFERENCE
B-91128	4:1		
REMINGTON ARMS CO. INC.			
ILION RESEARCH DIV.			

FORM 100 REV. 116

B-17053

DO NOT SCALE THIS DRAWING: WORK TO FIGURES
UNLESS OTHERWISE NOTED. TOLERANCES
ON DECIMAL DIMENSIONS ARE $\pm .005$
& ON FRACTIONAL DIMENSIONS $\pm \frac{.04}{16}$
& ON ANGULAR DIMENSIONS $\pm 0^{\circ}.30'$
FINISHES ARE DESIGNATED BY ROOT MEAN
SQUARE (R.M.S.) MICRO-INCH ROUGHNESS
VALUES. THE HIGHER THE MICRO-INCH ROUGHNESS
SPECIFIED, FINISH ROUGHNESS TO BE
125
OR BETTER.

ALTERATIONS				
LET.	WAB	REFERENCE	BY	DATE
18	REDRAWN	9557	W	3-3-68
19	A-17053	"	W	"
20	90XCF 5100	4832	W	2-1-68
21	ADD USE 90X-8	5120	"	1/2/68
23	.06% .060	"	"	"
24	ADDED USE	6479	DD	3-16-68
25	ADD USE M-160	5666	W	1/1/68
26	40X-8 90XCF TEIG 3A SC600	7110	DD	7/11/67
27	ADD. HUGHAWK ISS 600	8045	W	9-1-70
28	REMOVED	9203	W	6-9-70



RECOMMENDED MATERIAL AND HEAT TREAT

MATERIAL .00/20 CRAB STEEL
HEAT TREAT CYN. HON. .002/002 CRAB
HARDNESS 20-22
COLOR NITRE BLACK
HEAT TREAT AND COLOR TO BE DONE BY LEXINGTON (13)

MODEL	PART USE		QUAN.	SEE
ORDER BY DATE	DRAWN BY DATE BREGED 2-1-68	CHECK BY DATE 2-1-68 3-7-68	APPR. BY DATE NL3/13/68	
TITLE SCREW				
NUMBER B-17053	SCALE 3:1	SUPERSEDES - FT. 17053 A-17053		
REMINGTON ARMS CO. INC. NEWINGTON AVE., DETT.				

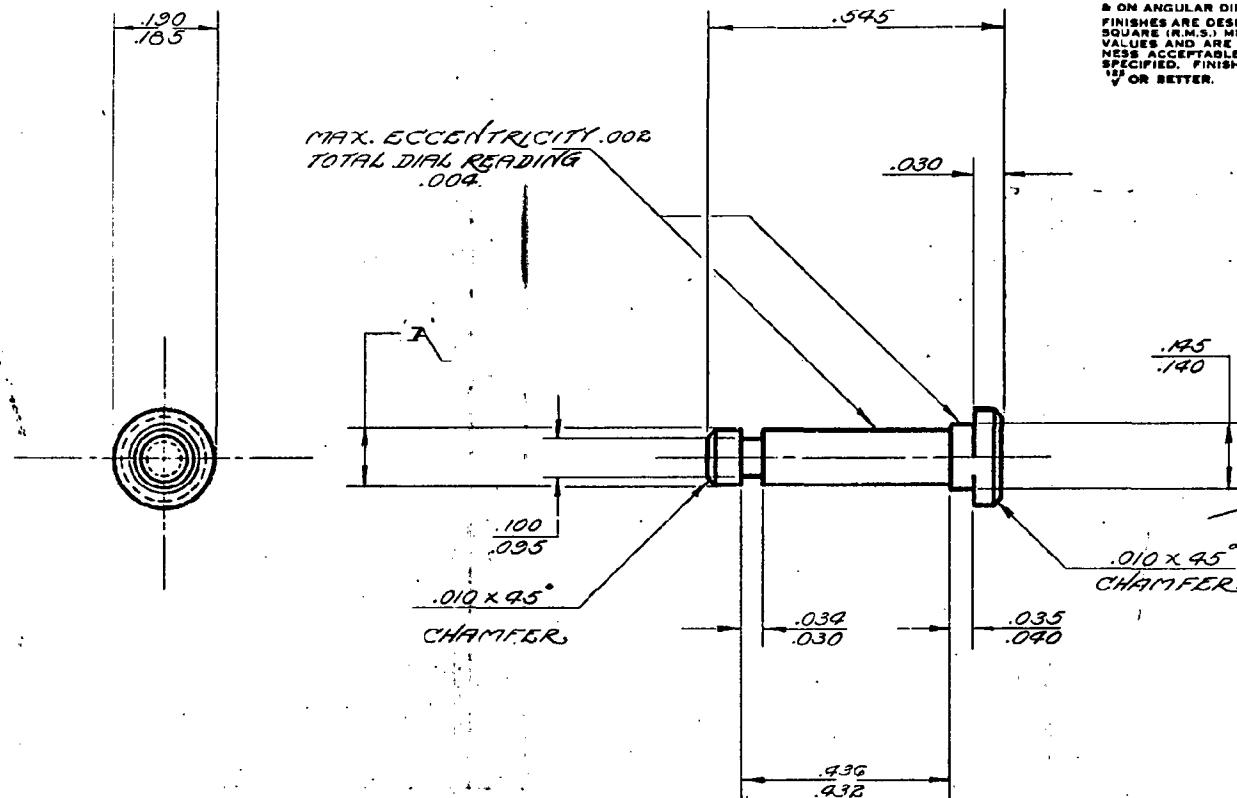
B-17053

B-17043

DO NOT SCALE THIS DRAWING: WORK TO FIGURES
UNLESS OTHERWISE NOTED. TOLERANCES
ON DECIMAL DIMENSIONS ARE $\pm .003$
& ON FRACTIONAL DIMENSIONS $\pm \frac{1}{64}$
& ON ANGULAR DIMENSIONS $\pm .001$ 30'
FINISHES ARE DESIGNATED BY ROOT MEAN
SQUARE (R.M.S.) MICRO-INCH ROUGHNESS
VALUES AND ARE THE MAXIMUM ROUGH-
NESS ACCEPTABLE, UNLESS OTHERWISE
SPECIFIED. FINISH ROUGHNESS TO BE
100 OR BETTER.

ALTERATIONS

LET.	WAR	REFERENCE	BY	DATE
23	REDDAWN	9671	DR	5-3-62
24	B-17043	"	DR	5-3-62
25	ADD USE 660	5129	DR	1/29/62
26	ADDED USE	6479	DR	3-14-66
27	ADD USE 660	6662	DR	1/11-66
28	ADD MOHAWK USE 600	8444	DR	7-11-70



DIM.	MANUFACTURING DIM.	DIM. AFTER HEAT TREAT
A	.1245 - .1225	.123 - .125*

*NOTE

THIS DIA. MUST PASS THRU
17.125 DIA. RING GAGE FREELY

RECOMMENDED MATERIAL AND HEAT TREAT

08/ 100 P.L. CARBON STEEL
003 - 006 CASE
NITRE BLACK
HEAT TREAT COLOR TO BE DONE BY RE...

B-17043

MOHAWK 600	SAFETY PIVOT PIN	1	C-26795
660	SAFETY PIVOT PIN	1	
700VME	SAFETY PIVOT PIN	1	D-26345
40X-8	SAFETY PIVOT PIN	1	D-27565
40X-8	SAFETY PIVOT PIN	1	D-27530
600	SAFETY PIVOT PIN	P.L.	
XP100	SAFETY PIVOT PIN	P.L.	
700BDL	SAFETY PIVOT PIN	D-26345	
700ADL	SAFETY PIVOT PIN	D-26345	
40XCF	SAFETY PIVOT PIN	P.L.	
Y25	SAFETY PIVOT PIN	D-24575	
40-X	SAFETY PIVOT PIN	P.L.	
T62	SAFETY PIVOT PIN	D-170364	
T61	SAFETY PIVOT PIN	D-170364	

MODEL	PART USE	QUAN.	SEE
DES'D BY DATE	DRAWN BY DATE	CHECK BY DATE	APPR. BY DATE
	2 REED	5-1-62	16 5/15/62

TITLE	NUMBER	SCALE	SUPERSEDES-REFERENCE
PIN	B-17043	5:1	--17043
REMINGTON ARMS CO. INC. RESEARCH & DEV. DEPT.			

23 24