

TECHNICAL COMMITTEE MANUAL  
VOLUME VI - RIMFIRE RIFLE  
DROP TEST

I. REMINGTON CURRENT PRODUCT

- A. When the Technical Committee Manual, Volume VI.- Rimfire Rifle was circulated through Ilion Design and Production areas it was suggested that Volume VI could set the pattern for all long guns.
- B. If the drop test, impact test, and jar-off test were adopted, the following Remington product would be involved:
1. M/700 & XP-100 with exposed striker-firing pin heads would be in trouble if the impact test was adopted.
  2. Inertia fire pins will mark crushers when the firearm is subjected to muzzle drops as in drop test and jar-off test. This involves M/1100, M/870, M/11-48, M/742, and M/760.
  3. CBC exposed hammer model will become obsolete if the impact test is applied to long guns.

II. SAVAGE CURRENT PRODUCT

- A. If the drop test, impact test, and jar-off test were adopted the following Savage current product could be involved:
1. Savage exposed hammer guns would become obsolete if the impact test was applied to long guns.
  2. Available exploded firearms drawings of Savage product indicate several large-unbalanced trigger and/or sear assemblies which it is believed could place many Savage catalogue firearms in trouble when jar-off tested.

I-28-77  
AAHugick:T

*Remington Arms Company, Inc.*  
Ilion Research Division

Technical Committee Manual  
Volume VI - Rimfire Rifle  
Drop Test

III. ILION RESEARCH DROP TEST

- A. Ilion drop test and jar-off testing is conducted in a parallel pendulum - top, bottom, muzzle, butt and side.
- B. The drop test and jar-off test media used is a two inch thick hard maple plank secured to a concrete wall.

1-28-77  
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1976 REMINGTON CATALOG LISTING

<u>Model - Caliber - Action of Firearm</u>	<u>Drop Test</u>	<u>Jar-Off Test</u>	<u>Impact Test</u>
N-66 RF Autoloader	-	-	-
552 RF Autoloader	-	-	-
572 RF Slide	-	-	-
580 Series RF Bolt	-	-	-
40XR RF Bolt	-	-	-
700 CF Bolt	-	-	Trouble
742 CF Auto.	-	-	-
760 CF Slide	-	-	-
788 CF Bolt	-	-	-
XP-100 CF Bolt	-	-	Trouble
1100 SG Auto.	-	-	-
870 SG Slide	-	-	-
3200 SG Break Action	-	-	-
11-48 SG Auto. (Recoil)	-	-	-
CBC M122 RF Bolt	-	-	-
CBC M151 SG Break Action	-	-	Trouble

1-18-77  
AAHugick:T  
Ilion Research Division

1977 SAVAGE CATALOG LISTING

<u>Brand - Model - Caliber - Action of Firearm</u>	<u>Drop Test</u>	<u>Jar-Off Test</u>	<u>Impact Test</u>
Stevens 34 RF Bolt Action	-	Trouble	-
Stevens 89 RF Lever Action			Trouble
Stevens 73 RF Bolt Action			-
Stevens 72 RF Falling Block	-	-	Trouble
Sav/Anschutz 54 RF Bolt Action	-	Trouble	-
Sav/Anschutz 164 RF Bolt Action	-	Trouble	-
Sav/Anschutz 1418 RF Bolt Action			-
Savage 65M RF Bolt Action	-	Trouble	Trouble
Stevens 80 RF Autoloader			-
Savage 99C CF Lever Action	-	Trouble	-
Savage 110 CF Bolt Action	-	-	-
Anschutz 1432 CF Bolt Action			-
Savage 340 CF Bolt Action	-	-	-
Savage 170 CF Slide Action	-	-	-
Savage 2400 SG/CF Break Action			-
Savage 240 SG/CF Break Action			Trouble
Savage 242 SG Break Action			Trouble
Fox/Stevens BSE SG Break Action			-
Savage 333 SG Break Action	-	Trouble	-
Savage 30 SG Slide Action			-
Stevens 94 SG Break Action	Trouble	Trouble	Trouble

1-18-77

AAHugick:T

Ilion Research Division

BEAD					RAMP		
CALIBER	25751 LOW	25750 MED.	14659 HIGH	REAR SIGHT SET	28512 LOW	28511 MED.	28510 HIGH
.17 REM		x		4th Index Mark from rear			x
.222		x		"			x
.22-250		x		"			x
.25-06		x		"			x
.6mm		x		"			x
.243		x		"			x
.270		x		"			x
.30-06		x		"			x
.308		x		"			x
.7mm			x	"			x
.264			x	"			x
.300			x	"			x
.8mm			x	"			x
.375	x	Alt.		Middle 5th space		x	
.458	x	Alt.		"		x	
FEM:bd 2-4-77							

**PURCHASE  
ORDER NO.**

DATE ISSUED 2-25-77

PLACED ON J. G. Tilp Inc.

STREET NO. 80 Milltown Rd. CITY Union STATE N.J. 07083  
THIS BLOCK FOR PURCHASING DEPT. USE ONLY

**THIS BLOCK FOR PURCHASING DEPT. USE ONLY**

**NOTE TO WRITER**

**SPECIFICATIONS MUST BE CLEARLY STATED  
GIVING WHENEVER POSSIBLE CATALOGUE,  
MACHINE NUMBERS, ETC.**

Note: Assembly, final fitting and mold repair to be quoted on the inspection of mold at J.G. Tilp. at an extra charge.

PER YOUR QUOTATION OF Feb. 21, 1976 No. 27323

SHIP VIA Best Way

**F.O.B.**

ITEM NO.	CHARGE ACCOUNT	CODE	PLANT ORDER	WORK ORDER	TERMS
			2301	85234	DELIVER TO BLDG. NO. 76-2 NOTIFY MR. R.D. Polley & G. Schinoller ISSUED BY R.D. Polley APPROVED BY

PROPOSALM O L D S

Compression • Injection • Transfer

• LEADERS IN THE MOLD BUILDING FIELD SINCE 1916.

• 80 MILLTOWN ROAD, UNION, N. J. 07083

201 - 686-7307

Remington Arms Co., Inc.  
Ilion, N.Y. 13357

Attention of J. D. Rogers

Date February 21, 1977

Gentlemen: We propose to furnish the following, subject to the conditions on the reverse side hereof:

Reference: Your request for quotation #R-445  
Tilp Proposal #26570 dated 5/25/76Cost to Produce Core Inserts on M/788 Safety Button  
Dwg. #B-14247, Tilp #6982. To enable Remington to  
produce XP-100 Safety Button Dwg. #C-91495. Core  
inserts to be interchangeable.

\$1,100.00

Note: Assembly, final fitting and any mold repair  
to be quoted on the inspection of mold at  
J. G. Tilp at an extra charge.

We can make shipment.....3 to 4 weeks.....after receipt of your order.

Terms: Net .....1/3 down, 1/3 on 75% completion, 1/3 on approval.....

.....F.O.B. our plant, Union, N. J.

The conditions and statements on the reverse side of this sheet are to be considered as express covenants and undertakings included as of the essence of any contract accepted by us based upon your order submitted to us in pursuance of and in accordance with this proposal.

Please refer to and include the serial number of this proposal on your order.

J. G. TILP, INC.

By

Paul F. Surhoff

# PURCHASE REQUISITION

PURCHASE ORDER NO. I-3700

DATE ISSUED 2-25-77

PLACED ON J. G. TILP, INC.

STREET NO. 80 Milltown Rd. CITY Union STATE 07083

**THIS BLOCK FOR PURCHASING DEPT. USE ONLY**

### NOTE TO WRITER

SPECIFICATIONS MUST BE CLEARLY STATED  
GIVING WHENEVER POSSIBLE CATALOGUE,  
MACHINE NUMBERS, ETC.

[illegible]

PER YOUR QUOTATION OF

Feb. 21, 1976 No. 27323 - R-445

SHIP VIA

Best way 57 ~~January~~

F.O.B. *Union N.J.*

ITEM NO.	CHARGE ACCOUNT	CODE	PLANT ORDER	WORK ORDER	TERMS
			2301	85234	<p>N-30</p> <p>DELIVER TO BLDG. NO. 76-2</p> <p>NOTIFY MR. R. Polley &amp; G. Schineller</p> <p>ISSUED BY R. Polley</p> <p>APPROVED BY <i>[Signature]</i></p>



**FORM RD 15A**

## PURCHASE REQUISITION

**PURCHASE  
ORDER NO.**

I-3750

**DATE ISSUED**

PLACED ON J. G. TILP. DEC

STREET NO. 80 Milltown Rd.

CITY Union

STATE 03082

THIS BLOCK FOR PURCHASING DEPT. USE ONLY

### NOTE TO WRITER

**SPECIFICATIONS MUST BE CLEARLY STATED  
GIVING WHENEVER POSSIBLE CATALOGUE,  
MACHINE NUMBERS, ETC.**

[illegible]

PER YOUR QUOTATION OF

FEB. 27, 1976

No. 27323

- K-445

SHIP VIA

St. John's

F.O.B. *London N.Y.*

ITEM NO.	CHARGE ACCOUNT	CODE	PLANT ORDER	WORK ORDER	TERMS
			2301	85234	N-30 DELIVER TO BLDG. NO. NOTIFY MR. T. DALLAN ISSUED BY APPROVED BY

BARBER - PRESALE R 0106391  
**Remington.**



REMINGTON ARMS COMPANY, INC.

PURCHASE ORDER  
NO. **1-3700**

**J.G. TILP COMPANY, INC.**  
**80 MILLTOWN RD.**  
**UNION, N.J. 07083**

ORDER DATE

**3-4-77**

ORDER NUMBER MUST BE PLAINLY  
SHOWN ON EACH ITEM, PACKAGE, COR-  
RESPONDENCE, AND INVOICE.

COMPLETE PACKING LIST MUST AC-  
COMPANY EACH SHIPMENT.

SHIP TO AND INVOICE\* TO, USING BUYER'S FORM, LOCATION CHECKED BELOW:

☐ BRIDGEPORT, CONN. 06602  
TEL: 203-333-1112

☐ OTHER: \* (INVOICE TO BRIDGEPORT)

☐ LONOKE, ARK. 72086  
TEL: 501-676-3161

☒ ILION, N.Y. 13357  
TEL: 315-894-9961

DATE REQUIRED IN OUR PLANT

**4-6-77**

F.O.B.

**P.S.**

SHIP VIA

**ST. JOHNSBURY**

SELLERS QUOTE NO. OR DATE

**2-21-77 #27323 R-445**

REMINGTON CODE	LINE NO.	PRICE BASIS	QUANTITY	UNIT MEAS.	DESCRIPTION	PRICE
					<b>CORE INSERTS TO PRODUCE XP-100 SAFETY BUTTON PER DWG. C-91495. CORE INSERTS TO BE INTERCHANGEABLE WITH M/788 SAFETY BUTTON CORE INSERTS. PER DWG. B-14247 TILP #6982</b>	<b>\$1100.00 LOT</b>
					<b>NOTE - ASSEMBLY, FINAL FITTING AND MOLD REPAIR IF NECESSARY, QUOTED ON THE INSPECTION OF MOLD AT J.G. TILP AT AN EXTRA CHARGE</b>	
					<b>M/788 SAFETY BUTTON MOLD SHIPPED ON OUR SHIPPING MEMO M-29656</b>	

STATE SALES  
TAX APPLIES

☐ YES  
☒ NO

TERMS

**NET-30**

VENDOR CODE

BUYER

**JTR/1**

REMINGTON ARMS COMPANY, INC.  
R. BECKERDITE, MANAGER PURCHASING DIVISION

ENTER OUR ORDER AS ABOVE SUBJECT TO  
CONDITIONS ON THE REVERSE SIDE

DIRECT ALL  
INQUIRIES TO  
BUYER

BY

**J.D. ROGERS, PROCUREMENT MGR.**

ACCOUNT CHARGED	LINE	TAX	SNPG.	CASH	DELIVER TO
<b>2301 85234</b>					<b>R. POLLEY &amp; G. SCHNILLER 76-1</b>
					VALUE OF ORDER

FORM NO. RD 14 REV. 3/76

ORIGINATOR

BARBER - PRESALE R 0106391

R2507379

## PROCESS ENGINEERING ESTIMATE - TRIAL AND PILOT SHEET

## • SEQUENCE OF OPERATIONS •

MODEL XP-100 COMPONENT SAFETY BUTTONPART NO. C.DATE 5-14-76 COMPUTER WABSHEET 1 OF 1

OPER NO.	OPERATION NAME	MACHINE	DEPT. NO.	HOURS DESIGN	HOURS BUILD
5	BLEND NYLON POWDER	A.O. 788 SAFETY BUTTON PROCESS - P.N. 14247			
10	DRY NYLON POWDER	" "			
15	INJECTION MOLD	MINIJECTOR MOLDING PRESS 4 CAVITY MOLD NEW INSERTS			975
- TO DISPATCH AREA -					
TOTAL					

RD-6568

1-18-63

**PROPOSAL**C - K. Cuf  
Nº 26570**MOLDS**

Compression • Injection • Transfer

• LEADERS IN THE MOLD BUILDING FIELD SINCE 1916.

• 80 MILLTOWN ROAD, UNION, N. J. 07083  
201 - 686-7307Remington Arms  
Ilion, N.Y. 13357

Attention of J. D. Rogers

Date May 25, 1976

Gentlemen: We propose to furnish the following, subject to the conditions on the reverse side hereof:

Ref. your request for quotation # R-445

A. The cost to produce back inserts  
on M/788 safety button per DWG B-14247. Mold  
Tilp #6982 to enable Remington to Produce  
XP-100 safety button

\$975.

B. Assembly, final fitting & any mold  
repair to be quoted on inspection of mold**RECEIVED**

MAY 27 1976

PURCHASING DEPT.-ILION

3-4 weeks

We can make shipment..... after receipt of your order.

Terms: Net ..... 1/425 - 3 - com, 1/4 50% comp 1/4 del bal on approval.....

..... F.O.B. our plant, Union, N. J.

The conditions and statements on the reverse side of this sheet are to be considered as express covenants and undertakings included as of the essence of any contract accepted by us based upon your order submitted to us in pursuance of and in accordance with this proposal.

Please refer to and include the serial number of this proposal on your order.

J. G. TILP, INC.

By .....

Paul F. Surhoff

0-99

## DON'T SAY IT—WRITE IT

TO J.D. Rogers  
FROM R.D. PolleyDATE 2-16-77

I have been to see John about getting Quales for back inserts for the m/788 safety button to produce new m/x1-100 safety button with the ability to also make the m/788 safety button by ~~putting the old~~ making the back inserts interchangeable.



Remington Arms Company, Inc.  
Ilion Research Division

Telex to E. F. Barrett

Ilion, New York  
March 4, 1977

TO: W. E. LEEK  
FROM: J. P. LINDE  
SUBJECT: MOHAWK 600 RIFLES FOR EXPORT TO AUSTRALIA

I recommend that no alterations be made to the Mohawk 600 rifles being exported to Australia based on the following information.

The trigger adjustment mechanism on the Mohawk 600 has been investigated from a reliability standpoint. The basic question raised is will the rifle trigger mechanism stay in adjustment over an extended period of time. The answer to this question is yes based on the experience we have with the Mohawk 600 and Models 721 and 722. Both the Model 721 and 722 have the same type of fire control with a folded housing and staked adjustment screws. The Mohawk 600 has an added degree of security as the adjusting screws are also sealed with DuPont Duco cement. In conclusion, it has been our experience that these rifles will not change adjustment with continued usage.

The next question raised on the Mohawk 600: is it adjustable in the field by the customer? The answer is no. The Gun Owner's Instruction Folder supplied with each rifle states that the trigger assembly is factory sealed to the correct adjustment.

In the Field Service Manual supplied to gunsmiths we give clear concise details how to adjust the trigger assembly with proper instructions on resealing the screws.

In reviewing the Model 700 rifles being exported to Australia I have determined why their trigger assemblies are different from the assemblies sold in the United States.

The alteration was made to the trigger assemblies in Australia due to an accident involving a Model 700. The customer had improperly adjusted his fire control, applied no locking cement, and after some usage, the rifle discharged unexpectedly. At the time of this incident the Gun Owner's Manual described how to make the adjustment

To: W. E. Leek  
From: J. P. Linde  
Subject: Mohawk 600 Rifles for Export to Australia

Page 2

March 4, 1977

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to lighten the trigger pull. The Australian position was that, if it is adjustable, the adjusting screws should be able to be locked after adjustment. Our experience on the M/700 indicated that it would stay in adjustment without the jam screws, which we supplied, but the government prohibited the sale of these rifles until the alterations were completed. Since this time the gun owner's guide for all M/700s has been altered to read, "No adjustment of trigger by the owner is recommended. Trigger pull has been factory adjusted. Should any adjustment be necessary return rifle or see a Remington approved gunsmith".

The M/700 trigger assemblies are presently being sealed in place with DuPont Duco cement. The sear engagement screw, the most important, is also sealed with a Loctite type of adhesive. The Duco cement not only seals the screws but also indicates whether the screws have been tampered with.

So in conclusion the situation which existed in 1973 on the M/700 does not exist today. That is, we recommend that the customer does not make any alterations to his trigger assembly. We are also secure in the position that the screws will stay in position once adjusted.

J. P. Linde/nl  
Manual Firearms Design  
Ilion Research Division