

NUMBER A-17023		REMINGTON ARMS CO. INC. RESEARCH & DEV. DEPT.	
SCALE		SUPERSEDES-REFERENCE	
TITLE SPRING, HELICAL COMP.			
DES. BY DATE REED	ORN. BY DATE 6-11-62	CHK. BY DATE	APP. BY DATE
FOR DETAILS, SEE PROCESS RECORD			
MODEL	PART USE	QUAN.	SEE
781	MAIN SPRING		W-17023M
785	MAIN SPRING		P.L. FOR CALIBERS
786	MAIN SPRING		P.L. FOR CALIBERS
788	MAIN SPRING		P.L. FOR CALIBERS

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
OR BETTER

RESISTANCE MATERIAL AND HEAT TREAT

**MUSIC WIRE
STRESS RELIEVE**

HEAT TREATING IN REMINGTON

THIS DRAWING OR INFORMATION IS
PROPRIETARY INFORMATION TO THE
REMINGTON ARMS COMPANY, INC.

INSPECTION

- To work freely in .420 dia. hole AT WORKING LGTH. (2.97)
- To work freely on .203 dia. pin AT WORKING LGTH.
- Load 24.4 to 26.0 lb. at 2.97 length (with set removed)
- Solid Height 2.26 max. 7. "Ind RIGHT H
- Free Length 5.80 min. 8. Remove set (No (except for inspection
- Ends SQUARED & GROUND
Approximate length limits to nearest 64th inch at constant load in lbs.
and nearest 1/4 oz. Load 25 lbs. 3/16 czs. at 2 5/16 to 3 1/16 in. length
OUTSIDE DIAMETER FREE LENGTH = .405 MAX.

MANUFACTURE

- Wire dia. .055
- Free Length 5.94 WITH SET REMOVED
- Outside dia. .405 MAX.
- Coils 37 Active 39 Total

DESIGN DATA

- Rate 8.61 lb./in.
- Spring Index 6.3
- Solid Stress 104,000 lb/sq.in.
- Torsional Mod. $G = 11.5 \times 10^6$ lb/sq.in.
- Solid Load 32.2 lb.
- Concentric Corr 1.00 DIRECT SHEAR

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.

13	REDRAWN	4793	6-11-62
ALT.	WAS	REFERENCE	BY DATE
ALTERATIONS			

WPA-3 REV. 1

A-17023