

CONFIDENTIAL

Remington Arms Company Inc.
RESEARCH & DEVELOPMENT TECHNICAL CENTER
315 WEST RING ROAD
ELIZABETHTOWN, KY 42701

TLW0010C – Re-Measure Headspace after Proof

All test samples will be re-measured for headspace after proof and before being tested in either the jack or shot from the shoulder. The chamber, bolt face & locking block/locking notch will be inspected for the presence of dirt or debris. If dirt or debris that could affect headspace measurement is present then these areas of the firearm will be thoroughly cleaned before using the gauges.

Method:

- The graduated headspace gauges based on Remington chamber dimensions (Ref.: Remington Gauge Drawing # 41560 ...A (min.), ...B (+.005), ...C (+.007) & ...D (+.009)) will again be used and the headspace measurements will be recorded to the nearest .001" increment as indicated by the gauge. The .30-06 Remington chamber drawing LB-153 will be used for chamber dimensions and LB-154 will be used for chamber drawings for the .270 caliber.
- The headspace measurement taken prior to the proof test should be less than min. + .005". If, after proof, the growth of the headspace is more than + .002" from the pre-proof condition, then stop and review the results with the test manager before continuing to the next phase of the test.
- In no case should the measurement for headspace after initial proof test be greater than min. +.007" for a new firearm.
- If at any time during the test program the headspace exceeds a maximum of Min. + .009" do not continue to fire the rifle, tag the gun with a label reading "Do Not Shoot This Firearm – Exceeds Maximum Allowable Headspace" and return the firearm to the Test Manager for disposition.

Data Required:

- Rifle serial number
- Record and note any headspace growth and round level.

J.R. Snedeker

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