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Remington Arms Company Inc.  
RESEARCH & DEVELOPMENT TECHNICAL CENTER  
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ELIZABETHTOWN, KY 42701

**TLW 1005**

## M/1100 CM 12 Gauge Shotgun DESIGN ACCEPTANCE TEST PLAN - DAT #1

**Introduction:**

A test sample for the Design Acceptance Test (DAT) consisting of twenty (20) shotguns is scheduled for delivery in November 2002. An additional four (4) M/1100 standard shotguns will be made available to be used as control guns.

After completing basic measurements and inspections on the shotguns in the sample, a 200 round per gun jack-function test is planned for all test shotguns in the sample using a variety of ammunition to determine the probable malfunction rate and determine if the expenditure of additional ammunition for testing is justified. This test will be followed by a 100 round live fire test shot in the long range from the shoulder in a standing position using a variety of ammunition.

After completing the shoulder-fired function test, a random selection of 10 shotguns will be shot for Patterns using selected 12-gauge ammunition. The point of impact will be determined for the patterned shots. This will be followed by an extended function and endurance test on a selected number of test shotguns.

A selection of sample shotguns will also be tested under various environmental conditions.

Finally, a sample of shotguns will be tested under various conditions of intentional abuse.

**Initial Inspections, Measurements and Tests:****TLW1005A -Incoming Parts Inspection:**

Component parts for the Model 1100 CM will be measured for critical dimensions prior to assembly of the DAT sample shotguns. Records of the measurement results will be made available for inclusion in the DAT report. The parts used to fabricate the DAT sample shotguns must meet the model drawing for dimension and/or for specified characteristic or the drawings will be changed accordingly prior to transmittal to production. Design will provide a list of part drawings and associated dimensions/characteristics to be inspected.

**TLW1005B -Measure Headspace:**

All test sample shotguns will be measured for headspace before being tested in either the jack or shot from the shoulder. The barrel, bolt, and the receiver will be inspected for the presence of dirt or debris. Special attention will be paid to the chamber, bolt face, locking block & locking notch areas. Headspace measurements can be affected by the presence of dirt and debris. If dirt or debris is found, clean the shotgun before using the gauges.

Note that excessive headspace can result in blown case heads and/or split cases which can allow high pressure gases to escape in the chamber area potentially throwing debris in the shooters direction. Headspace that is below minimum specifications may result in the shotgun failing to lock-up. A firearm with the headspace out of specification can also result in other functional problems such as hard closing, misfires, poor extraction, etc. (See S.A.A.M.I. Technical Committee Manual Volume VIII, Shotgun, Sections 8-80.01-.02 Rev. 3/23/94.)

J.R. Smedeker

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