

CONFIDENTIAL

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

TLW 1005

- Beginning separation or material stretching in front of the case head indicating excessive headspace or excessive pressure as stated above.
- Any cartridge case failure indicating a firearm fault.
- In addition, the spent proof round should be examined for the presence of unusual deformation, split case or split head, and for any evidence of a pierced primer. Any of these conditions may be indicative that high-pressure gases may have vented into the action where other damage to components may have occurred.
- Take note of any indication of significant gas leakage. If present, it may indicate that the firearm was not subjected to full proof pressures and the proof test would then be invalid and would require re-proofing.
- A firearm is only properly proofed when the cartridge has been fired without evidence of significant gas leakage.
- Save the spent proof case in a Zip-Lock plastic bag and label and place in the data packet for possible future reference. If any parts were broken or otherwise damaged, place these parts in the same bag as the proof case and label. Place a warning label on the firearm and withdraw the firearm from the test.
- Each sample firearms' headspace (see following procedure "TLW1005D -Re-Measure Headspace after Proof") must remain in range from min. to min. + .0009" (this is to allow for normal growth due to wear before reaching extreme Max.) after proofing, with no individual firearm's headspace to grow more than .002" after firing one proof round.
- After successful proofing without observable damage and the headspace is within allowed specifications, stamp the barrel with an authorized Proof stamp. Locate the proof mark on the right rear of the barrel in the specified location for the Remington proof stamp. **DO NOT STAMP** if the headspace exceeds Min + .013". If this is a barrel that has previously been proofed and already has a Remington proof mark, do not re-stamp.

Data Required:

- Shotgun serial number
- Record and note any headspace growth and the corresponding round level.
- Record significant gas leakage and/or firearm damage
- Record any case damage or other ammunition related malfunctions.
- Record any damage to the firearm resulting from the proof test. Document with photographs if necessary.
- TLW Number
- Testers' Names

TLW1005D -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 and 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:

- Graduated headspace gauges (if available) will be used and the headspace measurements will be recorded to the nearest .001" increment as indicated by the gauge. The 12-gauge chamber drawing D-240355 will be used for referenced chamber dimensions.
- The headspace measurement taken prior to the proof test should be less than or equal to Min. + .007". (See previous note under Measure Headspace.) 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 + 0.009" for a new firearm.
- If at any time during the test program the headspace exceeds an extreme maximum of Min. + .013" do not continue to fire the shotgun, 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 proper disposition.

Data Required:

J.R. Snedeker

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Subject to Protective Order - Williams v. Remington

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