

**CONFIDENTIAL**

Remington Arms Company Inc.  
Research & Development Technical Center  
315 West Ring Road  
Elizabethtown, KY 42701

**HEADSPACE AND PROOF - TLW0300E THROUGH TLW0300G:**

**TLW0300E - Measure Headspace**

All test samples will be measured for headspace before being tested in either the jack or shot from the shoulder. The chamber, bolt face & locking lugs 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 cleaned before using the gauges.

**Method:**

The graduated headspace gauges based on Remington chamber dimensions (Ref.: Remington Gauge Drawing # 41560 ...A, ...B, ...C, & ...D) will 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.

The headspace measurements will be recorded to the nearest .001" increment as indicated by the gauge.

If the measurement is taken at the start of the test then headspace should be less than Min. + .005".

As the test progresses, headspace will be taken at each "Safety Inspection" scheduled in the plan and, in addition, at each "Clean & Inspect" activity scheduled by the plan.

The readings for each firearm will be recorded on the "Daily Test Data Sheet" to be kept with each firearm in the accompanying data packet.

For any firearms where the headspace is changing at each inspection point the firearm will be withdrawn from test and examined for the cause.

In no case will any firearm in the test program be allowed to continue test if the headspace exceeds Min. + .009".

**Data Required:**

Rifle serial number

Headspace measurements for each sample