

Project Name: 504 Target (22LR & 17HMR)

Revised: 6/10/05

Project Number: 241426

R&D Engineer(s): Will B James, Vince Norton

Marketing Manager: John Trull

Plant Contact: Kevin Lance

Status:

- Completed shooting both 17HMR and 17M2 Universal receivers. 17HMR averaged 0.607" the 17M2 averaged 0.8" with Eley ammunition @ 100yds. The UR barrels are 1 in 9 twist rate. Free bore is less than 1/64".
- 504T HB 17HMR (DAT 3) Accuracy @ 100 yards, 10 gun average was 1.602". (597 17HMR T&P accuracy was 1.44" at 100 yards)
- 504T HB 17HMR (DAT 3) Accuracy @ 50 yards, 8 gun average was 0.728".
- Ordered green mountain 17HMR barrel blanks, 25" long and 1.062" in diameter.
- Mayfield will order tighter SAMMI 17HMR chamber reamers.
- Sent two (2) DAT 504 17HMR to custom shop for evaluation. The two (2) guns shot a 1.62" average at 100 yards. The two guns were lapped and glass bedded then re-shot for accuracy. At 100 yards the average with Remington ammunition was 1.18".
- Current software using actual velocities from production rifles indicates a slower twist maybe beneficial; 1 in 11 or 1 in 12 inches. Mayfield will order a rifling button with new twist rate and evaluate.
- Mayfield will complete Green Mountain Barrels and shipped to E-town by 6/10/05.
- Mayfield will provide E-town with 6 barrels with tighter chambers once they can work the job in their schedule.
- E-town received 10 magnum 504 pillar bedded stocks to complete T&P drop testing.

Issues:

- Differences between the UR and a standard 504T-HB-17HMR are (1) length + 4 inches, (2) barrel screw onto receiver, and (3) a fine internal finish. The 40x receiver was used for the UR barrel test.

Action Items:

Action Item	Status	Responsible	Date
1. Transmit Drawing package 504T-HB 22LR	Complete	R&D	4/15/05
2. Ordered Green Mountain barrel Blanks 17HMR	Complete	R&D	5/06/05
3. Finish-out Green Mountain Barrels & Evaluate		Mayfield	6/10/05
4. Custom Shop evaluation of 504 17HMR	In process	Ilion	5/17/05
5. Measure velocity & evaluate twist rate	Complete	R&D	4/28/05
6. Order SAMMI chamber reamer	Complete	Mayfield	5/9/05
7. Order 1 in 12 twist rifling button	In process	Mayfield	5/9/05
8. Mayfield will evaluate DAT guns from jack (4 guns)	In Process	Mayfield	5/13/05
9. T&P build for 504T 17HMR	After DAT	Mayfield	TBD

Schedule / Key Milestones:

Milestone	Current Date
EET	6/30/04
DAT 504LR	3/11/05
DAT 504 17HMR	3/25/05
T&P 504T 22LR	4/20/05
T&P 504T 17HMR	TBD
Warehouse Position 22LR	4/30/05

