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

TLW 1012Method:

- Graduated headspace gauges will be used and the headspace measurements will be recorded to the nearest .001" increment as indicated by the gauge. The .22 LR chamber for the model 504 will be found on drawing E-300849 and will be used for the referenced chamber dimensions. (Note that: If graduated headspace gauges are not available then, as a minimum, use Min/Max headspace gauges to assure that the rifles are at least within headspace specifications.)
- 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 or equal to Min. + .005" (i.e. less than or equal to Rimfire headspace gauge labeled 0.048")
- As the test progresses, headspace will be taken as designated by any specific test in the plan and in addition, at each scheduled "Safety Inspection" as well as at each "Clean & Inspect" activity scheduled by the test plan.
- The headspace readings for each firearm at each inspection 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- For any firearms where the headspace appears to be increasing at each inspection point the firearm will be withdrawn from test and examined for the probable cause.
- In no case will any rifle in the test program be allowed to continue in the test if the headspace exceeds Min. + .008" (i.e. greater than Rimfire headspace gauge 0.051".)

Data Required:

- Rifle serial number
- Headspace measurements for each sample
- Testers' Names
- TLW Number

TLW1012C -Proof Test:

Normally, Rimfire rifles are not subjected to a proof test procedure at the completion of production. However, note that for all newly designed Rimfire Rifles the Proof Test procedure will be completed before the firearm can be used for any additional firing tests by test lab personnel as a safety precaution.

All test sample firearms will be subjected to a standard .22 LR. Definitive Proof load shot in the blow-up room using a lanyard.

For fully assembled firearms, one definitive proof cartridge should be fired in each firearm. Definitive proof ammunition is to be used in accordance with the "Handling of Ammunition" procedure defined in the SAAMI Technical Committee Manual, Volume III, Section II, Page 2410 as follows:

- "Cartridges to be tested should be placed in a vertical position with primer end down in a recessed holding block."
- ".... a cartridge should be lifted vertically from the block. It should be rotated slowly, end over end, in a vertical plane through 360° pausing momentarily when the powder is at the bullet end and again when the powder is at the primer end."
- "The cartridge is then rotated slowly, a minimum amount to enter chamber, keeping primer end in lowest possible position until inserted gently and carefully into the chamber."
- "The cartridge should be seated in the chamber as far as practicable with the fingers. The bolt or breech mechanism should be closed gently in order not to disturb the position of the powder in the cartridge case. The object of this method of handling cartridges is to position the propellant powder at the primer end of the cartridge case by permitting it to fall gently against the primer and while rotating the case."

J.R. Smedeker

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Subject to Protective Order - Williams v. Remington