

REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE

Remington  
SUPER

PETERS  
SUPER

cc: J. P. Linde  
Lab File

2-2

"CONFINE YOUR LETTER TO ONE SUBJECT ONLY"

Illion, New York  
May 15, 1975

TO: W. E. LEEK  
FROM: A. A. HUGICK  
DATE: May 13, 1975  
WORK ORDER: G 0457  
TEST PERIOD: April 16, 1975 thru May 13, 1975  
SUBJECT: M/600 SAFETY EVALUATION - REPORT #1

INTRODUCTION:

Design initiated a review of the bolt action rifle safety function. Three (3) M/600 test rifles were delivered to the Lab area for testing and evaluation. Test activity of these rifles was confined to wear function of the safety and fire control.

TEST OBJECTIVE:

Dry cycle test the sample M/600 rifle safety assemblies for endurance and function.

TEST RESULTS & OBSERVATIONS:

1. M/600 - 6854251 - Test Gun #1
  - Test Activity
    - 50,000 Cock and Dry fire cycles.
    - 50,000 Safe On - Safe Off cycles.
    - WD-40 lubrication.
  - Test Results
    - Sear lift showed no major trend.
    - Sear lift showed variation .0065 Max. - .0045 Min.
    - Safe On force variations ranged from 4.5 Max. to 2.5 Min.
    - Safe On force variations ranged from 15.0 Max. to 4.0 lbs. Min.

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER  
KINZER V. REMINGTON

R2506081

To: W. E. Leek  
From: A. A. Hugick  
M/600 Safety Evaluation - Report #1

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TEST RESULTS & OBSERVATIONS: (Con'td)

1. (Cont'd)
  - Safe function was normal.
  - Safe could be tricked as received.
  - Trigger pull remained fairly constant around 8.5 lbs.
  - Fire control part appearance was good.
2. M/600 - 6846506 - Test Gun #2
  - Test Activity
    - 50,000 Safe On - Safe Off cycles.
    - 50,000 Cock and Dry fire cycles.
    - WD-40 lubrication.
  - Test Results
    - Safe can be made to fire rifle when assembled in stock.
    - Sear lift showed variations from .0062 Max. to .0019 Min. inches.
    - Safe On force variations ranged from 4.0 lbs. Max. to 1.0 lbs. Min.
    - Trigger pull remained constant at ten lbs.
    - Safe could be tricked as received.
3. M/600 - 6854270 - Test Gun #22
  - Test Activity
    - 23,500 Safe On- Safe Off cycles.
    - "Very Slow" Safe On - Safe Off cycling 12/Min.
    - No lubrication.
  - Test Results
    - The trigger housing failed in bearing due to detent ball.
    - Failure of trigger housing produced conditions of safe binding and not being able to move to Safe Off position.
    - Sear lift increased from .006 as received to .0118 at 11,000 Safe On - Safe Off cycles.
    - Safe On force and Safe Off force showed major increases.
    - Safe function was normal.
    - Safe could be tricked as received.

AAH:bd  
Illion Research Division  
Attached

2 X M/600 RIFLES WITH SWADGED SAFETY CAMMING

- a. Trigger pull, Headspace, Safe On force, Safe off force, safety lift of Sear at Trigger, Trigger radius at Sear.
- B. Check function of safety - fire 10 Rds.
- C. Clean and lubricate (F.C. WD-40)
- D. 1,000 cock and dry fire dry cycles.  
1,000 Safe On / Safe Off dry cycles.
- E. Measure Safe On force, Safe Off force, Trigger pull, safe lift of Sear at Trigger.
- F. Check function of safe. - fire 10 Rd.
- G. Clean and lubricate.
- H. 1,000 cock and dry fire cycles.  
2,000 Safe On / Safe Off cycles.
- I. Measure Safe On force, Safe Off force, Trigger pull, safe lift of Sear at Trigger.
- J. Check function of safe - fire 10 Rds.
- K. Clean and lubricate.
- L. 2,000 cock and dry fire cycles.  
2,000 Safe On / Safe Off cycles.
- M. Repeat I.
- N. Repeat J.
- O. Repeat K.
- P. 5,000 cock and dry fire cycles.  
5,000 Safe On / Safe Off cycles.
- Q. Repeat I.
- R. Repeat J.
- S. Repeat K.
- T. Repeat P.
- U. Continue to a total of 50,000 / 50,000 cycles.

Bower  
-5/9/75-  
5-19-75

M/600 - SAFETY FUNCTION TEST - PRELIMINARY SUMMARY

Period - Start of Test <sup>5/16</sup> 4/14/75 to 5/9/75

Total guns received . . . . . <sup>359</sup> 344

Guns received with box marked OK (previously tested) . . . . . 88

Of 88 guns received with box marked OK - All guns passed both the worst test and trick test.

Of the remaining <sup>271</sup> 256 guns:

1 failed the worst test  
139 failed the trick test

Of the <sup>151</sup> 139 guns which failed the trick test:

<sup>145</sup> 133 repaired by installing swaged Safeties  
6 guns replaced by Custom Repair

Of the 1 gun which failed the worst test:

1 repaired by installing swaged Safety

CODE NO.CATEGORY & TYPEFIRING (100 to 199)

- 100 Fails to cock.
- 101 Fails to fire or misfires.
- 102 Firing Pin strikes light blow, poor point.
- 103 Firing Pin fell out.
- 104 Firing Pin or Spring binds, length incorrect, protrudes
- 105 Firing Pin strikes off center, marks shells.
- 106 Fails to connect.
- \* 107 Jags off or fires closing.
- \* 108 Fires on safe or safe doesn't hold.
- \* 109 Fires when safe is pushed off.
- \* 110 Follows down or Hammer falls.
- 111 Pieces or primer in action or Bolt.
- 112 Right Connector doesn't seat in sear notch.
- 113 Trigger binds.
- 114 Trigger pull heavy, light, creeps, long. Poor
- 115 Safe binds, loose, excessive play, double click.
- 116 Max. header.
- 117 Min. header.
- 118 Bolt catches on Receiver (M/721-722 only).
- 119 Fires automatic, doubles.
- 120 Improper Head Space
- 121 Safe goes on after firing.
- 122 Selector won't fire.
- 123 Selector works hard, binds.
- 124
- 125

\* These are the complaint code numbers and meanings  
used on the attached report.