

DESCRIPTIVE INFORMATION

	<-----ALL MANUALLY OPERATED----->				<---ALL AUTOLOADERS--->			
	ALL BOLT ACTIONS		ALL PUMP ACTIONS		PARENT		SPTS.	
CENTERFIRE	PARENT	SPTS.	PARENT	SPTS.	PARENT	SPTS.	PARENT	SPTS.
RIFLE								
FIXED BOX MAGAZINE								
BLIND(NO FLOORPLATE)	700A	78	NONE	NONE	NONE	NONE	NONE	NONE
WITH FLOOR PLATE	700BDL	NONE	NONE	NONE	NONE	NONE	NONE	NONE
	700CL.	NONE	NONE	NONE	NONE	NONE	NONE	NONE
	7	NONE	NONE	NONE	NONE	NONE	NONE	NONE
REMOVABLE CLIP MAG	NONE	NONE	7600	76	7400	74		
SINGLE SHOT	NONE	NONE	6	NONE	4	NONE		
			NONE	NONE	NONE	NONE		
PISTOL (SINGLE SHOT)	XPI00	NONE	NO PUMP ACTION PISTOL		NO AUTOLOADING PISTOL			
SHOTGUN								
BUILT-IN TUBULAR MAG.	N		870	12P	1100	12A		
SINGLE SHOT	O	N	870 C.T.	NONE	NO SINGLE SHOT AUTO.			
		E						
RIMFIRE								
SINGLE SHOT	40XR	N	NO SINGLE SHOT PUMPS		NO SINGLE SHOT AUTO.			
REMOVABLE CLIP MAG.	541X	O	NONE	N	NONE	N		
				O		O		
REMOVABLE TUBULAR MAG	NONE	N	572A	N	552A	N		
			572BDL	E	552BDL	E		
		E			N/66			

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R2516702

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NOTES:

<u>Code No.</u>	<u>Abr.</u>	<u>Malfunction</u>	<u>Models Involved</u>	<u>Explanation</u>
1	AB	Action binds	All pumps and autos	Action has a definite catching in either opening or closing on more than one (1) test round.
199	BB	Bolt binds/catches	All bolt actions	Bolt has a definite catching or bind in either forward or rearward motions (anywhere except bolt stop: refer to #8).
2	ASFB	Action spring follower binds	1100 family	Follower binds in action tube preventing action spring from going forward to close action.
3	BHS	Bolt plug hits safety switch	All bolt actions	Bolt plug contacts safety switch thumb piece as bolt is operated toward forward or rearward positions.
4	BCOF	Bolt catches on follower	700 family, 7, 7600 family, 7400 family, 552, 572	During forward motion of the bolt, bolt head contacts and binds on rear end of magazine follower.

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5	BAC	Burr at chamber	All	Burr, nick or upset at mouth of chamber which interferes with feeding or extraction of live round or fired case.
7	BC	Blows cases	All	Shell bursts, splits or blows out at any part of brass portion.
8	BCOBS	Bolt catches on bolt stop	541X	When starting to move bolt to rear position, stop catches in bolt stop slot.
9	BCOE	Bolt catches on ejector	870 family, 1100 family, 870 C.T.	In normal operation, bolt catches on ejector due to lack of proper clearance.
12	BLOP	Bar lock or disconnecter out of position	All using common trigger plate	Disconnecter or action bar lock drops off action bar; this can cause #1 AB, #37 DFB, etc.
13	BPO	Bolt pulls out	All bolt actions	Bolt assembly fails to hold at rearmost stopping point and is pulled clear of rifle during normal opening of action.
14	BSSM	Bolt stems shell in magazine	All centerfire repeaters	While feeding cartridge toward chamber, cartridge wedges tightly while still fully engaged with and parallel to receiver rails or magazine lips. This stops bolt motion (This is not #108 OR or #132 SOR or #72 HUR)

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16	BHR	Bolt hits receiver	All center fire bolt actions	Front of bolt strikes ejection port or front receiver ring during forward motion.
17	BWCFM	Bolt won't close over full magazine	All center fire bolt actions	The correct number of cartridges in a fully loaded magazine cannot be pushed far enough downward to prevent the bolt from contacting a round as bolt is moved forward.
18	BSCO	Barrel support came out	870 family, 870 C.T. 1100 family	Barrel support has become separated from receiver assembly.
19	BLSO	Barrel lug shot off	7400 family	Barrel lug separates from barrel or becomes loose.
21	CBS-F	Shells catch on barrel support-feeding	870 family 1100 family	After feeding from magazine, front end of shell catches on barrel support preventing proper feed-up.
22	CBS-L	Shells catch on barrel support-loading	870 family 1100 family	When loading shells into the magazine, front end of shell catches on barrel support.

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23	CC	Carrier catches (on shells in magazine or latches or receiver)	870 family 1100 family 870 C.T.	During operation, carrier will catch at one of the points mentioned and prevent proper feed-up of shell.
24	CH	Closes hard	All	See #199 BB & #71 HUE. Should not be considered a malfunction on manually operated models unless more than normal closing speed is required on more than one shell.
25	CHAB	Carrier hits action bar	870 family 870 C.T. 1100 family	During operation, carrier catches on action bar and interferes with proper feed-up of shell on carrier.
26	CLM	Can't load magazine	All except single shots	In loading magazine, shells will not go in or will not go in properly.
27	CO	Cut-off	All	Shotguns: Paper/plastic of shell is cut off completely or partially at front of brass. Rifles: Brass case is completely severed around circumference of body.
28	CR	Cuts rim	All centerfires and shotguns	Rim of case completely cut through by extractor without causing #47 DX.

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29	CS	Cases swell	All	Case deforms or swells when fired; rear face of head becomes convex and/or body diameter increases.
30	CWSB	Cams wrong side of action bar	870 family 1100 family	Shell/feed latch cams behind action bar and jams action.
31	CTP	Creepy trigger pull	All	Movement is interrupted when trigger is pulled to rearward position.
32				
33	DXL	Doesn't extract live round	All	When action is opened, live round is not removed from chamber.
34	DBB	Doesn't blow back	All autoloaders	Action fails to open far enough after firing to eject empty case, cock hammer or feed next round (Bolt closes over fired case).
35	DE	Doesn't eject	All	The fired shell is extracted from chamber but fails to leave the ejection port although the action opens fully.

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<u>Code No.</u>	<u>Abr.</u>	<u>Malfunction</u>	<u>Models Involved</u>	<u>Explanation</u>
36	DEL	Doesn't eject live round	All	When the action is fully opened a live shell fails to leave the receiver ejection port.
37	DFB	Doesn't feed back	552, 572	Shells fail to feed back far enough to position properly on carrier.
38	DFU	Doesn't feed up	All rimfire and shotgun pumps and autoloaders with a tubular magazine	Live round feeds back from magazine (or forward N66) but is not raised into position for bolt to carry it into the chamber.
40	DLO	Doesn't lock open (after last shell)	All centerfire and shotgun autoloaders	Bolt fails to remain in rearward position after firing last shell.
41	DLU	Doesn't lock-up	All pumps and autoloaders	Bolt fails to go all the way forward and action bar lock or disconnecter prevents proper trigger connection with sear.
42	DCU	Doesn't close-up	All autoloaders	Same as #41 DLU except it will be visually noted that bolt failed to move to its full forward position.

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44	DSM	Drops shell-magazine	870 family 1100 family	Live round jumps by latch and falls out of receiver through bottom loading port.
45	DTL	Doesn't trip latch	1100 family	Live round feeding back from magazine fails to trip carrier latch, preventing rising of carrier and the feeding of shell up in proper position. Action fails to close.
47	DX	Doesn't extract	All	When action is opened, fired case is not removed from chamber.
48	DCT	Double click in trigger	All using common trigger plate	A separate and distinct catch felt in trigger before connector engages sear.
49	DCS	Double click in safety switch	All except N/66	A separate and distinct catch is felt in safety switch before it is fully engaged or disengaged.
50	FC	Fails to connect	All using common trigger plate	When gun is cocked with hammer and sear engaged, connector does not engage in or stay engaged in sear notch when trigger is pulled; hammer is not released.
			N/66	When gun is cocked, with disconnect and striker engaged in fire position, trigger fails to engage in or stay in notch of disconnect.

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Code No.	Abr.	Malfunction	Models Involved	Explanation
51	EDS	Extractor drops shell	All	Fired shell drops down from extractor during extraction cycle.
52	ESB	Ejector sticks back	All centerfires	When depressed, ejector fails to return to full forward position.
53	ESCR	Empty shell catches receiver	All centerfires and shotguns	At start of the ejection cycle, front of fired case hangs or catches at front of receiver ejection port or bolt lug slot.
54	ESS	Extractor stems shell	All shotguns	The shell feeding up on carrier jumps out of position such that the front of the extractor strikes inside rim (most often occurs on loading first shell into the chamber).
55	FB	Follower binds	All except single shots	Follower binds in magazine preventing proper feeding of shells.
56	FF	Fails to fire	All	When trigger is pulled, hammer or striker is released but firing pin fails to strike cartridge (There is no primer indent).
57	FFM	Fails to feed from magazine	All shotguns	Live round fails to feed past latches out of magazine.

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58	FFP	Flat firing pin	All centerfires and shotguns	Front surface of firing pin tip is flat or has insufficient radius.
60	FOS	Fires on safe	All	Gun fires with safety switch in "ON" ("S") position when trigger is pulled.
61	FPHB	Firing pin hits barrel	All rimfires	On its forward motion, firing pin strikes rear face of barrel near chamber
62	FPO	Floor plate opens	700 family, 7	Floor plate opens (due to incorrect performance of floor plate latch).
63	FPOH	Floor plate opens hard	700 family, 7	Floor plate latch requires more than normal force to open.
64	FSR	Fires when safe is released	All bolt actions	Firing pin assembly moves forward to fired position when safety switch is moved from "S" to "F" position.
65	FT	Follower tips	700 family, 7 7400 family 7600 family	Magazine follower tips sideways or down at front; it may or may not stick out of position.
67	FD	Follows down	All using common trigger plate, (N/66)	Hammer (striker) fails to properly engage with sear and follows the forward motion of the action bar assembly (bolt) to the fired position.

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67	FD	Follows down	All bolt actions	Firing pin head or cocking piece fails to properly engage with sear and follows the cocking cam surface of the bolt to the fired position.
68	FPHI	Firing pin hits inside rim	All rimfire	Firing pin strikes completely inside periphery of cartridge rim leaving full imprint on case head (may cause #56 FF).
69	FA	Fires automatically	All autoloaders	After firing one (1) round with trigger pull, one or more succeeding rounds are fired without again pulling the trigger. (See also #67 FD).
70	HBL	Heavy bolt lift	All bolt actions	More than normal force is required during cocking cycle (lifting bolt handle to open bolt) after a round has been fired or over an empty chamber (not #199 BB).
71	HUE	Hard under extractor	All shotguns and rimfires	Shell feeding up does not force extractor outward enough to allow rim of shell to fully seat under extractor.
72	HUR	Hard under rail	700 family, 7	Live round catches on receiver rail when feeding out of magazine.

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73	GRSO	Guide ring shot off	870 family	Barrel ring separates from barrel or becomes loose.
74	GCSO	Gas cyl. shot off	1100 family 870 comp. trap	Gas cylinder separates from barrel or becomes loose.
76	ILOP	Int. latch out of pos.	1100 family	Rear end of interceptor latch protrudes into receiver interfering with shell feeding from magazine.
76 1	ILRM	Int. latch ret. missing	1100 family	Self explanatory.
76 2	ILSOP	Int. latch spring out of position	1100 family	Tail of spring out of slot in latch.
77	ILSB	Int. latch stud broken	1100 family	Interceptor latch stud has become loose or separated from receiver.

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81	JCS	Jumps cartridge stop	All rimfires with removable tubular magazine	After one shell is fed, next round jumps by cartridge stop resulting in double feed.
82	JL	Jumps latch	870 family, 1100 family	After one shell is fed, next round jumps by latch resulting in double feed.
83	JM	Jumps magazine	All centerfire rifles	Shell jumps out of magazine and bolt picks up next shell resulting in double feed.
84	JO	Jars off	All	Hammer or striker fails to stay engaged with sear and falls to fired position when gun is jarred (not #67 FD).
88	LB	Light blow	All	Firing pin strikes primer or cartridge rim, but with insufficient force to make satisfactory indent and/or primer does not fire.

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92	MAH	Magazine assembles hard	All with removable clip magazine	Clip magazine will not assemble to gun freely (without pushing magazine latch) or lock in place correctly.
93	MCW	Magazine capacity wrong	All except single shots	Magazine fails to hold correct number of rounds (too many or too few).
94	MFA	Misfires (Ammunition)	All	Firing pin strikes primer or cartridge rim with proper blow but fails to fire due to faulty ammunition (This coding is for ammunition failure only). Not #56 FF or #88 LB.
95	MPOP	Magazine follower out of position	7400 family 7600 family	Follower jumps out of box at front.
96	BWCD	Bolt won't cam down	All bolt actions	Bolt will not rotate down to fully locked position with normal force.

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97	ML	Magazine loose (Falls out)	All with removable clip magazine	Magazine latch or lock fails to hold removable clip magazine properly in place.
98	MLH	Magazine loads hard	All except single shots	More than normal force is required to load live rounds into magazine.
99	MRH	Magazine removes hard (binds)	All with removable clip or removable tubular magazine	Magazine will not remove from gun freely pulling straight downward when release or lock is fully depressed (R.F: magazine removes downward and approximately 20° forward toward muzzle).
			Removable tubular magazine	Inner magazine tube catches or binds when being removed from or installed back into outer magazine tube.
101	MCSO	Magazine cap shot off	870 family, 870 C.T., 1100 family	Magazine cap shoots off of magazine tube.

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106	OH	Opens hard	All	Abnormally high force is required to open action by hand (On manually operated guns this is not to be considered a malfunction if action can be opened with one hand).
108	OR	Over-rides	All except single shot rifles	Bolt fails to pick up next shell in magazine resulting in action closing over an empty chamber (See #14 BSSM, #132 SOR).
112	PH	Pulls head	All shotguns	Paper or plastic body of shotgun shell is pulled completely or partially out of the brass head (Not #27 CO).

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201 through 213	RC	Rough or incorrect chamber	All centerfires	The appearance of the fired case suggests rings, tears, toolmarks, heading mismatch, out-of-round, etc, chamber surfaces. Refer to sketch for specific appearance illustrations at end of this section.
118	RDW	(Action) release doesn't work	All using common trigger plate except 552	Action fails to open or close manually.
119	RS	Rim stem	552, 572	Shell rim binds or catches in feeding groove in barrel preventing proper feed-up.
122	SCX	Shell catches extracting	All	Shell binds in breech end of barrel or in receiver during extraction cycle (May cause #1 AB).
121	SHI	Short indent	All rimfire	Firing pin indent appears as a small nick at rim of case with little or no coverage on shell head (May cause #56 FF).

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124	SBC	Stems bottom chamber	All	Forward motion of the action is stopped as a result of the nose of the bullet or shotgun shell jamming on the bottom edge of the chamber.
125	SBE	Stems barrel extension	7400 family 7600 family	Forward motion of the action is stopped as a result of the bullet nose jamming into the barrel extension.
126	SC	Stems chamber	All centerfire rifles	Bullet nose enters chamber but jams.
129	SI	Stems incline (ramp)	All centerfire rifles	Forward motion in closing the action is stopped as the result of the bullet jamming on the feed ramp or incline before entering chamber.
130	SL	Shaves lead	All rifles except single shots	Excessive amount of lead (or copper) is shaved off bullet as cartridge enters chamber.
131	SLC	Stems left side of chamber	All	Forward motion of the action is stopped as a result of the nose of the bullet or shotgun shell jamming on the left side edge of the chamber.

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132	SOR	Stem over-ride	All rifles except single shots	When the shell is partially out of the magazine, bolt face over-rides cartridge rim (See #14 BSSM, #108 OR).
133	SP	Stems port	552, 572	During feeding, forward motion of the action is stopped as a result of bullet nose striking ejection port.
134	SRC	Stems right side of chamber	All	The forward motion of the action is stopped as a result of the nose of the bullet or shotgun shell jamming on the right side edge of chamber.
135	STC	Stems top chamber	All	The forward motion of the action is stopped as a result of the nose of the bullet or shotgun shell jamming on the top edge of the chamber.
136	SSC	Shell stems carrier	870 family, 1100 family	Shell feeding from magazine catches on front end of carrier.
137	SWE	Safety switch works too easily	All	Safety switch doesn't have enough tension or "snap" to engage in specified positions properly.

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<u>TYPE</u>	<u>Explanation & Code No's. for Gallery</u>	<u>TIME</u>	<u>DEPT. NO. 8085</u>	<u>PAGE 18</u>	<u>OF 21</u>
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DESCRIPTIVE INFORMATION

MALFUNCTION INDEX - Explanation and Code Number to be used in reporting Functional Test Results

NOTES:

Code No.	Abr.	Malfunction	Models Involved	Explanation
138	SWH	Safety switch works too hard	All	Safety switch requires too much force to move from one position to another properly.
139	SWW	Safety switch won't work	All	Safety (switch) won't go to "S" (on) or "F" (off) position.
143	TD	Tips down	541X	Front end of shell is not supported, permitting nose of bullet to tip down when feeding (May cause #124 SBC).
144	TU	Tips up	552, 572	When feeding toward chamber, live round fails to align properly: Bullet end of shell is tipped upward causing bolt to jam against it (May cause #135 STC).
145	TWP	Trigger won't pull	All	Trigger won't move when pulled.
146	TWR	Trigger won't retract	All	Trigger won't fully retract after pulling.

PART NAME	Malfunction Index	COOLANT	SET UP	MODEL NO.	OPER.
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		TIME			
TYPE	Explanation & Code No's. for Gallery	MACH. HRS.	DEPT. NO. 8085	PAGE 19	OF 21

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DESCRIPTIVE INFORMATION

MALFUNCTION INDEX - Explanation and Code Number to be used in reporting Functional Test Results

NOTES:

<u>Code No.</u>	<u>Abr.</u>	<u>Malfunction</u>	<u>Models Involved</u>	<u>Explanation</u>
147	XH	Extracts hard	All	Shell or cartridge extracts but requires more than normal force (Not #106 OH).
148	XHB	Extractor hits barrel	Models using rimmed cartridges	Forward motion of the action is stopped as a result of the extractor jamming breech area of barrel. Action need not be feeding cartridge at time.
150		Uncoded nonconformity	All	Any nonconformity not currently included in this list.

PART NAME	Malfunction Index	COOLANT	SET UP	MODEL NO.	OPER. NO.
TYPE	Explanation & Code No's. for Gallery	MACH. HRS.	TIME	DEPT. NO. 8085	PAGE 20 OF 21
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<p>207</p>	<p>208</p>	<p>209</p>	<p>210</p>	<p>211</p>	<p>212</p>
<p>213</p>					

TYPE: RPOD ... CENTERFIRE CHAMBER IMPROVEMENT
 DATE: SUMMARY OF POSSIBLE CHAMBER DEFECTS
 AS SEEN ON FIRED CASE ... 2/1/85 ... 10/7 ... 74

PART NAME Malfunction Index
NO.

COOLANT

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DESCRIPTIVE INFORMATION

MALFUNCTION INDEX - Explanation and Code Number to be used in reporting Functional Test Results

NOTES:

<u>Code No.</u>	<u>Abr.</u>	<u>Malfunction</u>	<u>Models Involved</u>	<u>Explanation</u>
180	AI-P	Assembly incomplete at proof	All	Inoperable because working part(s) of gun omitted.
181	BC-P	Blows cases at proof	All	Shell bursts, splits or blows out at any part of brass portion (Not at centerfire primer).
182	BEB-P	Barrel extension broken at proof	All shotguns, 7400 family, 7600 family	Barrel extension is broken or shows crack.
183	BS-P	Barrel split at proof	All	A visible crack or complete rupture occurs anywhere on barrel.
184	DLOS-P	Doesn't lock over shell at proof	All	Bolt will not close and lock over chambered round.
185	ESB-P	Ejector sticks back at proof	All centerfire rifles	After proof round is fired, action is operated and ejector fails to return to its full forward position.
186	FF-P	Fails to fire at proof	All	Proof round does not fire; can be gun, ammunition or proof device related.
187	GRSO-P	Guide ring shot off at proof	870 family	Barrel guide ring separates from barrel, or becomes loose.

PART NAME	Malfunction Index	COOLANT	SET UP	MODEL NO.	OPER. NO.
TYPE	Explanation & Code No's. for Proof		TIME MACH. HRS.	DEPT. NO. 8085	PAGE 1 OF 3
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AND REASONS FOR REVISIONS 4/1/55

COMPLETION DATE

DESCRIPTIVE INFORMATION

MALFUNCTION INDEX - Explanation and Code Number to be used in reporting Functional Test Results

NOTES:

Code No.	Abr.	Malfunction	Models Involved	Explanation
188	GCSO-P	Gas cylinder shot off at proof	1100 family, 870 C.T.	Gas cyl. separates from barrel or becomes loose.
189	BLSO-P	Barrel lug shot off at proof	7400 family	Barrel lug separates from barrel or becomes loose.
190	BBB	Barrel bracket cracked or broken at proof	700 family, 7	Self explanatory.
191	MCSO-P	Magazine cap shot off at proof	870 family, 870 C.T., 1100 family	Magazine cap shoots off of magazine tube.
193	FESO-P	Fore end shot off at proof	1100 family, 7400 family	Self explanatory.
194	PP-P	Pierced primer at proof	All centerfire and shotgun	Face of primer is ruptured allowing gas to escape. There is little or no material missing from face of primer.
195	BP-P	Blown primer at proof	All centerfire and shotgun	Primer is blown out or is loose in primer pocket.
196	BLP-P	Blanked primer at proof	All centerfire and shotgun	Circular disc of material is blown out of rear face of primer. This corresponds in size to firing pin hole in bolt face.

PART NAME	Malfunction Index	COOLANT	SET UP	MODEL NO.	OPER.
NO.					
		TIME			
TYPE	Explanation & Code No's. for Proof	MACH. HRS.	DEPT. NO. 8085	PAGE 2	OF 3
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DESCRIPTIVE INFORMATION

MALFUNCTION INDEX - Explanation and Code Number to be used in reporting Functional Test Results

NOTES:

<u>Code No.</u>	<u>Abr.</u>	<u>Malfunction</u>	<u>Models Involved</u>	<u>Explanation</u>
200		Uncoded proof malfunctions	All	Any proof malfunction not currently listed above.

PART NAME Malfunction Index NO.	COOLANT	SET UP	MODEL NO.	OPER.
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