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

TLW0300P – Function Check of ISS System:

Check the ISS System for proper function. Make sure the chamber and magazine box are completely empty of live ammunition. This test will involve the use of a primed case, use appropriate safety procedures. With the bolt in the open and un-locked position, using the ISS tool, lock the ISS System in the secure mode and remove tool. Close the bolt, you should not be able to close and lock the bolt. (Note: If the bolt closes, attempt to place the safety in the "Fire" position and pull the trigger, the firing pin must not fall and set off the primed case. If the primed case fires then the test sample fails the test.)

If the bolt does not close and lock then make an attempt to rotate the ISS to the unsecured position using fingers and then try a small screwdriver, you must not be able to unlock the ISS System. (Be careful, do not use excessive force when using the screwdriver you just want to determine that the system will not unlock without the use of the proper tool.) Return the safety to the "On Safe" position.

Open the bolt and move to the rearward position, unlock the ISS System and continue to point the muzzle in a safe direction. **Remember that there is still a primed case in the chamber.** Put the muzzle of the rifle in the port of the shooting station (or other approved device). Place the Safety in the "Off Safe" position and pull the trigger, the firing pin must fall and set off the primed case. If the primed case is not fired then the test sample fails.

Data required:

- Rifle serial number
- Record check of ISS System function in both modes.
- Record whether the bolt could be closed and if closed did the primed case fire when the trigger was pulled.

TLW0300Q - Magazine Box Weld Strength Test:

Provide selected magazine box sample to M. Jiranek, Metallurgist for evaluation.

J.R.Snedeker

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