

| SEQ. NO.                       | PREP. FUNC. | DEPARTURE (DWELL) | Z ARC OFF (SIN) | X ARC OFF (LEAD) | Z ARC OFF (COS) | K ARC OFF (LEAD) | F FEED RATE | S SPIN. FEED | T TOOL SEL | M MISC. FUNC. | SPEED        |     | FEED  |       | ACCUMULATED       |                | OPERATIONS - REMARKS |                   |
|--------------------------------|-------------|-------------------|-----------------|------------------|-----------------|------------------|-------------|--------------|------------|---------------|--------------|-----|-------|-------|-------------------|----------------|----------------------|-------------------|
|                                |             |                   |                 |                  |                 |                  |             |              |            |               | RPM          | SFM | IPM   | IPR   | ED X FROM ZERO    | ED Z FROM ZERO |                      |                   |
| REWIND STOP CODE AT THIS POINT |             |                   |                 |                  |                 |                  |             |              |            |               | INITIALIZE S |     | 96998 | 23747 | FROM SPINDLE NOSE |                |                      |                   |
| N001                           | G04         | X02               |                 |                  |                 |                  |             |              |            | M07           |              |     |       |       | 96998             | -23243         | FROM PROGRAM ZERO    |                   |
| N002                           | G01         |                   | Z2293           |                  | K9999           | F095             |             |              |            |               |              |     |       |       | "                 | -0313          | POSITION TO "HOME"   |                   |
| N003                           | G04         | X02               |                 |                  |                 |                  |             |              |            | M06           |              |     |       |       | "                 | "              |                      |                   |
| N004                           |             |                   |                 |                  |                 |                  |             |              |            | M02           |              |     |       |       | "                 | "              |                      |                   |
| 12 INCHES OF LEADER            |             |                   |                 |                  |                 |                  |             |              |            |               |              |     |       |       |                   |                |                      | GEAR RANGE - HIGH |
| REWIND STOP CODE AT THIS POINT |             |                   |                 |                  |                 |                  |             |              |            |               | LH PROFILE   |     |       |       |                   |                |                      |                   |
| N001                           | G04         | X02               |                 |                  |                 |                  |             |              |            | M07           |              |     |       |       | 96998             | -0313          | "HOME" POSITION      |                   |
| N002                           | G01         | X-0.8998          |                 | I9999            |                 | F095             |             |              |            |               | 1196         | 425 | 14.7  | 011   | 08000             | "              |                      |                   |
| N003                           | G04         | X02               |                 |                  |                 |                  |             | 521          |            | M06           | M03          | M08 |       |       | "                 | "              |                      |                   |
| N004                           | G01         | X-0.1425          |                 | I9999            |                 | F005             |             |              |            |               |              |     |       |       | 06575             | "              |                      |                   |
| N005                           |             |                   | Z0865           |                  | K9999           | F0147            |             |              |            |               |              |     |       |       | "                 | 08337          | TURN TO 1.252 DIA    |                   |
| N006                           |             | X01               |                 | I9999            |                 | F005             |             |              |            |               |              |     |       |       | 07565             | "              | PULL OUT             |                   |
| N007                           |             |                   | Z-0865          |                  | K9999           | F02              |             |              |            |               |              |     |       |       | "                 | -08813         | RE POSITION          |                   |
| N008                           |             | X-0.925           |                 | I9999            |                 | F005             | 326         |              |            |               | 1434         | 425 | 19.4  | 011   | 05650             | "              | FEED IN              |                   |
| N009                           |             |                   | Z0865           |                  | K9999           | F0194            |             |              |            |               |              |     |       |       | "                 | 08337          | TURN TO 1.130 ±005   |                   |
| N010                           |             | X0236             |                 | I9999            |                 | F005             |             |              |            |               |              |     |       |       | 08000             | "              | RETRACT              |                   |
| N011                           | G04         | X02               |                 |                  |                 |                  |             |              |            | M07           |              |     |       |       | "                 | "              |                      |                   |
| N012                           | G01         | X0.8998           |                 | I9999            |                 | F095             |             |              |            |               | RH PROFILE   |     |       |       | 96998             | "              |                      |                   |
| N013                           | G04         | X02               |                 |                  |                 |                  |             |              |            | T33           |              |     |       |       | 101685            | -4170          |                      |                   |
| N014                           | G05         |                   | Z21782          |                  | K9999           |                  |             |              |            |               |              |     |       |       | "                 | 213650         |                      |                   |
| N015                           | G01         | X-9385            |                 | I9999            |                 |                  |             |              |            |               |              |     |       |       | 08000             | "              |                      |                   |
| N016                           | G04         | X02               |                 |                  |                 |                  |             |              |            | M02           |              |     |       |       | "                 | "              |                      |                   |
| N017                           | G01         | X-04              |                 | I9999            |                 | F0032            | 511         |              |            |               | 721          | 230 | 3.2   | 0045  | 04000             | "              | FACE OFF             |                   |
| N018                           | G04         | X02               |                 |                  |                 |                  |             |              |            | M07           |              |     |       |       | "                 | "              |                      |                   |
| N019                           | G01         | X9                |                 | I9999            |                 | F095             |             |              |            |               |              |     |       |       | 94000             | "              |                      |                   |
| N020                           | G04         | X02               |                 |                  |                 |                  |             |              |            | T77           |              |     |       |       | 89313             | 206783         |                      |                   |
| N021                           | G01         | X-81313           | Z-0718          | I9999            | K9999           |                  |             |              |            |               |              |     |       |       | 08000             | 213963         |                      |                   |
| N022                           | G04         | X02               |                 |                  |                 |                  |             | 524          |            | M06           | 1339         |     |       |       | "                 | "              |                      |                   |

REMINGTON ARMS CO., INC. - PROGRAM MANUSCRIPT FOR L. & S. AVS 20-13 LATHE - Sht. 2/2

Part Name \_\_\_\_\_ Drawing No. \_\_\_\_\_ Tape No. \_\_\_\_\_ Date \_\_\_\_\_ Programmer \_\_\_\_\_ Mat'l \_\_\_\_\_

| N<br>SEQ.<br>NO. | G<br>PRE-DEPARTURE<br>FUNC. | X<br>DEPARTURE<br>(DWELL) | Z<br>DEPARTURE | X<br>ARC OFF<br>(SIN)(LEAD) | K<br>ARC OFF<br>(COS)(LEAD) | F<br>FEED<br>RATE | S<br>SPIN<br>SPEED | T<br>TOOL<br>SEL | M<br>MISC<br>FUNC | SPEED |     | FEED |      | ACCUMULAT-<br>ED X<br>FROM ZERO | ACCUMULAT-<br>ED Z<br>FROM ZERO | OPERATIONS - REMARKS |
|------------------|-----------------------------|---------------------------|----------------|-----------------------------|-----------------------------|-------------------|--------------------|------------------|-------------------|-------|-----|------|------|---------------------------------|---------------------------------|----------------------|
|                  |                             |                           |                |                             |                             |                   |                    |                  |                   | RPM   | SFM | IPM  | IPR  |                                 |                                 |                      |
| N023             | G01                         | X-0277                    |                | J99999                      |                             | F005              |                    |                  |                   |       |     |      |      | 0.0000                          | 213963                          |                      |
| N024             | G01                         | X01083                    | Z-01083        | I70711                      | K70711                      | F02               |                    |                  |                   |       |     |      |      | 0.5230                          | "                               |                      |
| N025             | G05                         | X00075                    | Z-155          |                             |                             | F0125             | S23                |                  |                   | 1291  | 395 | 19.4 | 0.05 | 0.7063                          | 57880                           | CHAMFER              |
| N026             | G01                         | X0065                     | Z-36           |                             |                             | F0333             | S22                |                  |                   | 1244  | 440 | 12   | 0.08 | 0.7713                          | 21880                           |                      |
| N027             |                             |                           | Z-1338         |                             | K99999                      | F012              |                    |                  |                   |       |     |      |      | "                               | 0.9500                          |                      |
| N028             | G04                         | X02                       |                |                             |                             |                   |                    | M07              |                   |       |     |      |      | "                               | "                               |                      |
| N029             | G01                         | X09285                    | Z-23187        | J99999                      | K99999                      | F005              |                    |                  |                   |       |     |      |      | 9.6498                          | -19607                          | READY FOR T11        |
| N030             | G04                         | X02                       |                |                             |                             |                   |                    | M06              |                   |       |     |      |      | "                               | "                               |                      |
| N031             |                             |                           |                |                             |                             |                   |                    | M08              |                   |       |     |      |      |                                 |                                 |                      |