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 Research & Development Technical Center
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TLW0300P – Function Check of ISS System:

To check the ISS system for proper function follow the four step procedure which follows. If the system fails during any of these procedures stop the test for that gun and continue with the next sample. To be considered a proper functioning ISS system each sample must pass all four of the procedures as outlined below.

1. 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. This test should be performed with the muzzle of the gun inserted into a shooting port or other approved device. With the bolt in the open and un-locked position and safety "On", using the ISS tool, lock the ISS System in the secure mode (no red dot visible) and remove tool. Attempt to close and lockup the bolt after placing a primed case into the chamber. You should not be able to close and lock the bolt easily, without applying excessive force. If the bolt cannot be closed the test sample passes the test. (Note: If the bolt can be closed, place the safety in the "Fire" position and then 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 primed case does not fire, attempt to unlock the ISS with the tool. Be careful, only apply enough force to see if you can unlock the ISS, without bending the tool. If the primed case is fired at any time during this procedure the test sample fails the test. If the primed case does not fire the test sample passes the test.) Record outcome of all steps taken and Pass/Fail results.
2. If the test sample passes the above test in either of the two possible ways (bolt cannot be closed or primed case does not fire) then perform the following test. Open the bolt and move partially to the rearward position (do not open bolt far enough to eject the primed case), unlock the ISS System (red dot visible) using the ISS tool. Move the safety to the "On Safe" position if it is not already there. **Remember that there is still a primed case in the chamber.** Push the bolt forward slowly, re-chambering the primed case, and fully lock the bolt. Make sure the muzzle of the rifle is in the port of the shooting station (or other approved device). Place the Safety in the "Off Safe" position and

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Revision # 3

ET53521