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Research & Development Technical Center  
315 West Ring Road  
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# M/710 Trial & Pilot

## Test Plan

### Model 710, New Centerfire Rifle

#### Revision # 1

09/25/00

TLW0300

9:03 AM 09/26/00

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INTRODUCTION:.....4

INITIAL TESTS, MEASUREMENTS AND INSPECTIONS: .....5

*VISUAL EXAMINATION, PACKAGING AUDIT, PACKAGING TEST AND SELECTION OF "BEST" AND "WORST"*

*EXAMPLES - TLW0300A THROUGH TLW0300D: .....5*

TLW0300A - Visual Examination .....5

TLW0300B - Packaging Audit.....8

TLW0300C - Packaging Test.....9

TLW0300D - Selection of "Best" and "Worst" Examples for Marketing Review.....9

*HEADSPACE AND PROOF - TLW0300E THROUGH TLW0300G: .....10*

TLW0300E - Measure Headspace.....10

TLW0300F - Proof Test.....11

TLW0300G - Re-Measure Headspace after Proof.....14

*FORCES - TLW0300H THROUGH TLW0300Q AND TLW0300T: .....15*

TLW0300H - Measure Firing Pin Indent.....15

TLW0300I - Measure Sear/Trigger Engagement and Sear Lift.....16

TLW0300J - Measure Trigger Pull Forces.....17

TLW0300K - Measure Safe On/Off Forces.....17

TLW0300L - Measure Bolt Lift and Bolt Closing Forces.....18

TLW0300M - Measure Magazine Spring Force.....19

TLW0300N - Firing Pin Head / Sear Engagement.....20

TLW0300O - Bolt Stop Function Check.....20

TLW0300P - Function Check of ISS System.....21

TLW0300Q - Magazine Box Weld Strength Test.....21

TLW0300T - Perform Bore Sighting Using Bushnell Scope.....22

*GUN CHARACTERISTICS - TLW0300R THROUGH TLW0300S: .....23*

TLW0300R - Balance Point - "System (includes the Scope and mount rails)":.....23

TLW0300S - Balance Point - Rifle Only (Without Scope, rails and Iron Sights):.....24

*FIREARMS MEASUREMENTS - TLW0300T THROUGH TLW0300W: .....25*

TLW0300T - Chamber cast: .....25

TLW0300U - Bore Diameter: .....25

TLW0300V - Groove Diameter:.....26

TLW0300W - Twist Rate (.30-06).....26

J.R.Snedeker

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Remington Confidential

Revision # 0

ET53594

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Elizabethtown, KY 42701

TLW0300X - Magazine Capacity Test: 26
FUNCTION & ENDURANCE TESTING: 28
FUNCTION AND ENDURANCE TESTING - TLW0300Y THROUGH TLW0300AB 28
TLW0300Y - Ten (10) Round Safety Function Test with Lanyard: 28
TLW0300Z - Basic Jack Function Test (to 100 Rounds): 28
TLW0300AA - Extended Function & Endurance: 30
TLW0300AB - Clean Rifles and Inspect: 32
ACCURACY TESTING: 34
ACCURACY AND POI TESTING - TLW0300AC THROUGH TLW0300AF 34
TLW0300AC - POI & Group Size - Initial Test with High Quality 36X Scope: 34
TLW0300AD (@zero) - Group Size at 100 yards ( System Stability Test, w/Bushnell Scope @ "zero" rounds: 35
TLW0300AE (@100)- Group Size at 100 yards ( System Stability Test, w/Bushnell Scope @ "100" rounds: 35
TLW0300AF (@200) - Group Size at 100 yards ( System Stability Test, w/Bushnell Scope @ "200" rounds: 36
ENVIRONMENTAL TESTING: 38
TEMPERATURE & HUMIDITY - TLW0300AG THROUGH TLW0300AJ 38
TLW0300AG - Hot Function Test: 38
TLW0300AH - Cold Function Test: 38
TLW0300AJ - Heat & Humidity Function Test: 39
ABUSIVE TESTING: 40
IMPACT TESTING - TLW0300AJ THROUGH TLW0300AM 40
TLW0300AJ - SLAM Test: 40
TLW0300AK - SAAMI Drop Test - "System" (Includes the Scope and Mounting Rails): 41
TLW0300AL - SAAMI Jar-Off Test - "System" (Includes the Scope and Mounting Rails): 42
TLW0300AM - SAAMI Rotation Test - "System" (Includes the Scope and Mounting Rails): 44
TLW0300AN - SAAMI Drop Test - Rifle Only (Without the Scope and Mounting Rails): 45
TLW0300AO - SAAMI Jar-Off Test - Rifle Only (Without the Scope and Mounting Rails): 46
TLW0300AP - SAAMI Rotation Test - Rifle Only (Without Scope and Mounting Rails): 48
INTENTIONAL ABUSE- TLW0300AV THROUGH TLW0300AX 49
TLW0300AQ - Pierced Primer Test: 49
TLW0300AR - High Pressure Test: 50
TLW0300AS - Obstructed Bore Test: 51

J.R Snedeker

9:03 AM 9/21/00

TLW0300

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Revision # 0

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## **M/710 CENTERFIRE RIFLE TRIAL & PILOT TEST PLAN**

### **Introduction:**

This test is designed with the assumption that a production run of at least 300 rifles will be produced by the Mayfield plant using all available production processes intended for use in manufacturing this model. Thirty (30) rifles will be selected at random from the sample lot of 300 for use as Trial & Pilot evaluation samples.

The sample of 30 rifles will be divided into 3 groups of 10 rifles each; A1-A10, A11-A20 and A21 to A28 (two rifles of the 30 will be selected and sent to marketing for review.) Rifles A1-A30 will be used initially for visual and packaging evaluation. Rifles A11-A20 will be used for measurements and A21 to A28 will be used for initial accuracy using a high quality 36X scope to establish the baseline accuracy of the rifle without the included Bushnell scope, as well as bore-sight verification using the production Bushnell scope.

All 28 rifles will be shot, 10 rounds each, as a safety precaution with a lanyard prior to the continuation of the testing. After completion of the 10 round lanyard test, each rifle will be shot with 100 rounds of Remington ammunition, (5 types of 20 rounds each type), using the jack to establish the basic product malfunction rate.

Rifles A1-A10 will then be shot, in the jack, an additional 400 rounds each using a variety of Remington and major competitor's ammunition to evaluate malfunction rates, magazine box endurance and reliability and other wear and breakage characteristics.

Rifles A11-A20 will be used as samples for Environmental Testing and Abuse Testing.

Rifles A21 to A30 will be for a 200 round test of the Scope System for stability and reliability at 0, 100 and 200 round intervals.

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Page 4 of 51

9:03 AM 9/21/00

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Revision # 0

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## Initial Tests, Measurements and Inspections:

### VISUAL EXAMINATION, PACKAGING AUDIT, PACKAGING TEST AND SELECTION OF "BEST" AND "WORST" EXAMPLES - TLW0300A THROUGH TLW0300D:

#### TLW0300A - Visual Examination

A visual examination will be made of all 30 sample rifles prior to the start of any additional testing, measurement or inspection. A temporary hang-tag will be attached to the trigger bow of each rifle with the numbers V-1 to V-30 ("V" for "visual") along with the serial number of each rifle. These temporary tags will be used to identify each sample rifle for the purpose of recording observations. After selection of the "Best" and "Worst" examples permanent labels will be affixed to each test sample using the designations A-1 to A-28.

Clearly defined visual standards are not established for this model at this time. For purposes of this examination the attached "Warehouse Customer Focus Quality Audit Visual Demerit Identification" paper supplied by the Ilion site can be used as a guideline. Demerits, using the attached guidelines, will be assigned to each discrepancy and an average "demerits per gun" measure of visual quality will be calculated.

*(As supplied by Ilion)*

---

WAREHOUSE  
CUSTOMER FOCUS QUALITY AUDIT  
VISUAL DEMERIT IDENTIFICATION  
DRAFT

Note: The firearms selected for Visual Demerit Classification are the result of failure to meet the personal visual criteria of the auditors.

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Page 5 of 51

9:03 AM 9/21/00

TLW0300

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Demerit Classifications have been established as follows:

**ONE DEMERIT:** Next step above "comment" stage. A one-demerit classification would allow the firearm to continue to the warehouse. This level of demerit would not prevent the customer from buying the firearm but would require review with both front line and supervisor for corrective action.

Examples of one demerit classification:

- \* Fingerprints on pack box (minimal amount)
- \* Stock fit to receiver
- \* Dark mar on firearm
- \* Grease on Styrofoam insert
- \* Slight variances in checkering
- \* Minor imperfections in stock finish
- \* Minor bright mars

**FIVE DEMERITS:** A five-demerit classification would, under normal conditions, allow the firearm to continue to the warehouse. This level of demerit signifies that there has been a deviation from standard or the observation borders on customer rejection. More than one five-demerit classification on the same firearm could constitute the firearm returning to production for repairs. Supervision would need to assign someone to review demerit and report on follow up.

Examples of Five Demerit classification:

- \* Irregular steel / wood margins
- \* Wood match between stock & fore end
- \* Dents in stock or fore end
- \* Mis-packed accessories
- \* Some bright mars on firearm

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Page 6 of 51

9:03 AM 9/21/00

TLW0300

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ET53598

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- \* Dimples or dents in metal surfaces
- \* Irregular checkering
- \* Grease/Oil fingerprints on firearm
- \* Use of excessive oil

**TEN DEMERIT:** A ten-demerit classification indicates the observation would greatly influence the customer's decision to not purchase that firearm. This classification also indicates the possibility a standard or procedure was not followed. This level of demerit would require the firearm to be repaired or a part replaced before being returned to the warehouse. If the demerit was called due to a procedure or process not being followed, this is to be reviewed by the foreman or supervisor to the appropriate personnel within a twenty four-hour period and corrective action taken.

Examples of Ten Demerit Classifications:

- \* Bright mars in metal
- \* Improper repairs
- \* Wood dents & scratches ( beyond template )
- \* Dirty appearance of firearm
- \* Firearm packaged incorrectly
- \* Accessories missing
- \* Poor wood match
- \* Firearm mis-packed
- \* Excessive margins

The severity of dark and bright mars would determine the degree of Demerit. This procedure would be followed with dents and scratches to wood and synthetic stock & fore end assemblies also.

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In addition to the descriptions of demerits listed above, there will be special occurrences or unique items that will require the placement of demerits. These will be handled as they occur. The Audit Team and Staff Supervision will establish the demerit level for these occurrences.

In some instances, in place of Demerits, the item being reviewed could be listed as an ACTION ITEM and assigned to a specific department or engineer to review and report on. Based upon the report of the findings, a Demerit Level would be established if needed.

**FIFTY DEMERITS:** A Fifty-Demerit Classification indicates the firearm being reviewed does not meet the criteria established for the proper manual function of that firearm. If a Fifty-Demerit Classification is placed upon a reviewed firearm, this would mean immediate action is taken to identify the problem and correct it.

In addition the following will be checked on each sample:

- Check the muzzle for the presence and condition of the Crown.
- Make sure that the Metal to Stock fit is uniform.
- Check the fit of the Recoil Pad to the Stock.
- Check each sample for the presence of Dirt, Lint and Excess Oil.

Examine the samples for any other unusual appearance discrepancies that may not be listed above.

Make a list of the discrepancies and their assigned demerit values that are found on each test sample and photograph if necessary to document the finding. Calculate the average demerits per gun.

**TLW0300B – Packaging Audit**

The Packaging will be audited, as the firearms are unpacked. Each shipping box will be examined for:

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Page 8 of 51

9:03 AM 9/21/00

TLW0300

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- Match of Serial Number on Rifle to that on the box end label and owner's manual package.
- Check the inventory of all required paperwork, owner's manuals, videotapes, etc.
- Box examination for presence of tears in the cardboard, crushing, stains, box inserts, etc.

Note that the final configuration of the shipping carton is not yet completely determined and may be changed prior to commencement of shipping to the customer. Note all apparent discrepancies and photograph for documentation if necessary.

**TLW0300C – Packaging Test**

Two rifles and packaging materials will be selected for inclusion in a test of the packaging to include both the rifle and scope as a system. Also included in the test will be the appropriate customer included materials such as owner's manual, warranty materials, etc.

Test procedure is still to be defined but will closely follow standard package drop testing procedures used to certify packaging for shipping.

**TLW0300D – Selection of "Best" and "Worst" Examples for Marketing Review**

At the completion of the Visual examination two samples will be selected as representing the "Best" and the "Worst" of the submitted lot. These two rifles will be repackaged – in their original boxes and sent to A. Russo in Madison for review. The remaining 28 rifles will now be labeled permanently with designations of A-1 to A-28 for use with the remainder of the testing. Be sure to record on a sheet of paper the matching "V" number from the visual examination so that the records can be matched at a later time.

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Page 9 of 51

9:03 AM 9/21/00

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HEADSPACE AND PROOF - TLW0300E THROUGH TLW0300G:

TLW0300E – Measure Headspace

All test samples will be measured for headspace before being tested in either the jack or shot from the shoulder. The chamber, bolt face & locking lugs will be inspected for the presence of dirt or debris. If dirt or debris that could affect headspace measurement is present then these areas of the firearm will be cleaned before using the gauges.

Method:

The graduated headspace gauges based on Remington chamber dimensions (Ref.: Remington Gauge Drawing # 41560 ...A, ...B, ...C, & ...D) will be used and the headspace measurements will be recorded to the nearest .001" increment as indicated by the gauge. The .30-06 Remington chamber drawing LB-153 will be used for chamber dimensions.

The headspace measurements will be recorded to the nearest .001" increment as indicated by the gauge.

If the measurement is taken at the start of the test then headspace should be less than Min. + .005".

As the test progresses, headspace will be taken at each "Safety Inspection" scheduled in the plan and, in addition, at each "Clean & Inspect" activity scheduled by the plan.

The readings for each firearm will be recorded on the "Daily Test Data Sheet" to be kept with each firearm in the accompanying data packet.

For any firearms where the headspace is changing at each inspection point the firearm will be withdrawn from test and examined for the cause.

In no case will any firearm in the test program be allowed to continue test if the headspace exceeds Min. + .009".

Data Required:

Rifle serial number

Headspace measurements for each sample

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**TLW0300F - Proof Test**

All firearms in the 300-rifle sample as supplied by Mayfield should be proof tested prior to delivery to R&D for T&P testing. Each rifle in the selected 30-rifle sample will be examined for the presence of the Remington proof stamp. **If the rifles are not proof tested and properly stamped by Mayfield the following procedure will be used by R&D to proof test and stamp the rifles prior to any other live fire testing proceeds.**

All test sample firearms will be subjected to a standard .30-06 Factory Proof Load, shot in the blow-up room using a lanyard. This procedure will be completed before the firearm can be used for any additional firing tests.

Before proof testing the firearm should be inspected for:

- Barrel Obstructions
- Bore and chamber are free of grease or oil and other debris.

For fully assembled firearms, one definitive proof cartridge should be fired in each firearm. Definitive proof ammunition is to be used in accordance with the "Handling of Ammunition" procedure defined in the SAAMI Technical Committee Manual, Volume III, Section II, Page 2410 as follows.

- a. "Cartridges to be tested should be placed in a vertical position with primer end down in a recessed holding block."
- b. "... a cartridge should be lifted vertically from the block. It should be rotated slowly, end over end, in a vertical plane through 360° pausing momentarily when the powder is at the bullet end and again when the powder is at the primer end."
- c. "The cartridge is then rotated slowly, a minimum amount to enter chamber, keeping primer end in lowest possible position until inserted gently and carefully into the chamber."

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Page 11 of 51

9:03 AM 9/21/00

TLW0300

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- d. "The cartridge should be seated in the chamber as far as practicable with the fingers. The bolt or breech mechanism should be closed gently in order not to disturb the position of the powder in the cartridge case. The object of this method of handling cartridges is to position the propellant powder at the primer end of the cartridge case by permitting it to fall gently against the primer and while rotating the case."

Note that these procedures for proof testing were developed to consistently position the propellant thereby providing greater consistency of proof pressures. Failure to follow this procedure during the definitive proof testing of each chamber of the firearm could result in pressure levels significantly below the minimum proof pressure specification as determined for the cartridge.

Any firearms components, such as bolts, bolt heads, receivers including chambers, etc. which were previously subjected to proof testing and, which subsequently, have any proof sensitive components changed, altered, or substituted, should be re-proofed.

Method:

- Record headspace before proof testing (see previous procedure "TLW0300D - Measure Headspace.")
- After firing the proof round, the firearm will be carefully examined to determine if any damage to the product has occurred due to exposure to the proof pressure. This inspection includes:
  - Visual inspection for damage,
    - damaged receiver or bolt, especially the locking lugs on the bolt or the receiver
    - bulged chamber or bore; split, cracked or otherwise damaged barrel,
    - broken stock,
    - any other part subjected to the proofing stress, which can be visually examined for damage.
    - Any "suspicious" areas should be submitted to magna-flux inspection before proceeding.
- The fired proof cartridge should be examined to determine that no firearm fault has introduced cartridge failure, such as:
  - Expanded cartridge head.
  - Excessive roughness, rings, or bulging, which would affect extraction.

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Page 12 of 51

9:03 AM 9/21/00

TLW0300

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- Beginning separation or material stretching in front of the case head indicating excessive headspace or excessive pressure as stated above.
- Any cartridge case failure indicating a firearm fault.
- In addition, the spent proof round should be examined for the presence of unusual deformation, split case or split head, and for any evidence of a pierced primer. Any of these conditions may be indicative that high-pressure gases may have vented into the action where other damage to components may have occurred.
- Take note of any indication of significant gas leakage, if present, it may indicate that the firearm was not subjected to full proof pressures and the proof test would then be invalid and would require re-proofing.
- A firearm is only properly proofed when the cartridge has been fired without evidence of significant gas leakage.
- Save the spent proof case in a Zip-Lock plastic bag and label and place in the data packet for further reference. If any parts were broken or otherwise damaged, place these parts in the same bag as the proof case and label. Place a label on the firearm and withdraw the firearm from the test.
- Each sample firearms' headspace (*see following procedure "TLW0300G - Re-Measure Headspace after Proof"*) must remain in range from min. to min. +.007" after proofing, with no individual firearm's headspace to grow more than .002" after firing one proof round. After successful proofing, the right lug on the bolt head will be marked in the center (i.e. center of top to bottom and center or front to rear) of the lug with a center punch to indicate that it has been proofed.
- After proof, if the firearm passes the inspection and headspace has been measured (*see next section of test plan*), stamp the firearm on the barrel with an authorized Remington proof stamp. Locate the proof mark on the right rear of the barrel in the specified location for the Remington proof stamp. **DO NOT STAMP** if the headspace exceeds Min + .009".
- Because of the higher pressures involved in shooting proof cartridges, adequate precautions, both mechanical and procedural, should be taken to protect personnel performing the firearms proof testing. To this end, the firearm should be securely mounted, completely shielded from the operator and firing accomplished by a remote control method.

Data Required:

- Rifle serial number

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Page 13 of 51

9:03 AM 9/21/00

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- Record and note any headspace growth and the corresponding round level.
- Record significant gas leakage and/or firearm damage.
- Record any case damage or other ammunition related malfunctions.
- Record any damage to the firearm resulting from the proof test. Document with Photographs as necessary.

**TLW0300G – Re-Measure Headspace after Proof**

All test samples will be re-measured for headspace after proof and before being tested in either the jack or shot from the shoulder. The chamber, bolt face & locking block/locking notch will be inspected for the presence of dirt or debris. If dirt or debris that could affect headspace measurement is present then these areas of the firearm will be thoroughly cleaned before using the gauges.

**Method:**

- The graduated headspace gauges based on Remington chamber dimensions (Ref.: Remington Gauge Drawing # 41560 ...A (mm), ...B (+.005), ...C (+.007), & ...D (+.009)) will again be used and the headspace measurements will be recorded to the nearest .001" increment as indicated by the gauge. The .30-06 Remington chamber drawing LB-153 will be used for chamber.
- The headspace measurement taken prior to the proof test should be less than min. + .005". If, after proof, the growth of the headspace is more than + .002" from the pre-proof condition, then stop and review the results with the test manager before continuing to the next phase of the test.
- In no case should the measurement for headspace after initial proof test be greater than min.+007" for a new firearm.
- If at any time during the test program the headspace exceeds a maximum of Min. + .009" do not continue to fire the rifle, tag the gun with a label reading "Do Not Shoot This Firearm – Exceeds Maximum Allowable Headspace" and return the firearm to the Test Manager for disposition.

**Data Required:**

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Page 14 of 51

9:03 AM 9/21/00

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Revision # 0

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- Rifle serial number
- Record and note any headspace growth and round level.

**FORCES - TLW0300H THROUGH TLW0300Q AND TLW0300T:**

**TLW0300H - Measure Firing Pin Indent:**

The firing pin indent will be measured for each of the sample rifles using SAAMI qualified copper crushers. The average of three trials per sample rifle will be calculated. The Average of three indents must be equal to or greater than 0.017".

Method:

- Using copper crushers, "burnish" both ends of the crusher slug by gently rubbing both ends on the granite base of the dial indicator stand (use outside edge of the plate).
- Place the copper crusher in a .30-06/.270-crusher holder, place the crusher holder on the base of the dial indicator and zero the dial indicator with the point of the indicator in the approximate center of the crusher.
- Carefully, with the gun held so that the muzzle is pointed down toward the floor, gently insert the crusher holder into the chamber, being sure that the extractor clearance cut on the crusher is properly oriented relative to the extractor position.
- While maintaining a firm hold on the bolt handle, gently, and slowly ease the bolt forward to the full forward position and then rotate down being sure that the action locks fully.
- Holding the firearm in a horizontal and level position, and pointing the firearm in a safe direction, pull the trigger until the firing pin releases.
- Carefully open the action and remove the crusher holder, being careful not to drop the copper crusher.
- Leave the crusher in the holder and place under the dial indicator.
- Move the crusher holder so that the point of the dial indicator finds the deepest portion of the firing pin indent.
- Record the dial indicator reading to the nearest .001".

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Page 15 of 51

9:03 AM 9/21/00

TLW0300

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Revision # 0

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- Repeat procedure two more times and record the dial indicator readings using a new copper crusher for each trial.
- Each firearm sample should have three readings that will be averaged.
- Record all three readings for the data file.

Data Required:

- Rifle serial number
- Each of the three trial indents
- The calculated average indent by rifle.

TLW03001 - Measure Sear/Trigger Engagement and Sear Lift

The Sear/Trigger Engagement will be measured. The amount of engagement must be measured between .020" and .025" measured with the bolt in the fully closed and locked position.

Method for measuring Sear/Trigger Engagement:

- The 30" Optical comparator will be used to measure the engagement at 50X magnification.
- With the barreled action held firmly in position, the barreled action will be aligned such that the action is held perpendicular to the lens in both the horizontal and vertical planes.
- With action closed and locked, the safety in the "fire" position, measure the amount of overlap between the sear and the trigger.

Method for measuring Sear Lift:

- Remove the bolt from the action.
- Place the Safety in the "Off-Safe" (i.e. "Fire") position.
- With the action held firmly in a horizontal position pre-load the sear in the downward position using a small screwdriver and with a dial indicator zeroed on the top of the sear, gently rotate the Safety to the "On-Safe" position.
- Record the amount of vertical movement of the sear.

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Page 16 of 51

9:03 AM 9/21/00

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- Minimum sear lift is 0.006" and maximum sear lift is 0.018"

Data Required:

- Rifle Serial number
- Record Sear/Trigger Engagement
- Record Sear Lift

TLW0300J - Measure Trigger Pull Forces:

Trigger pull force.

Method:

- Trigger pull is to be performed to the SAAMI standard; horizontal pull at the center of the finger radius of the trigger using the Test Lab apparatus designed for taking this measurement.
- Use the 1-10 lb. Chatillion Force digital force gauge.
- Force is measured parallel to the bore with the stock assembled to the action.
- Three pulls are to be taken on each sample rifle and the results averaged.
- The average force for the three trials must be between 4.0 lb. and 5.0 lb.

Data Required:

- Rifle Serial number
- All three data points for each trial rifle
- The average of the three measurements for each sample rifle.

TLW0300K - Measure Safe On/Off Forces:

Using the Chatillion Digital force gauge and the wooden holding fixture used to take trigger pull readings, push the Safe from the "Safe On" to the "Safe Off" position on each test sample. Complete three

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trials. Record all three readings for each firearm. A minimum of 1 lb. force in "Safe On" to "Safe Off" direction will be assumed as the reference criteria.

Method:

- Use trigger pull apparatus to hold the rifle for this test.
- Use the Chatillion Digital Force gauge (0-10 lb. range) with the disc point or the "v" shaped point. Use the same tip on all subsequent trials.
- Make three trials in specified direction for each sample.
- Average the results of each of the three trials.

Data Required:

- Rifle serial number
- Each of the three readings on each sample
- The average of each of the three sets of readings

TLW0300L - Measure Bolt Lift and Bolt Closing Forces:

The force required opening the bolt and closing the bolt will be measured for each sample. Both of these forces will be taken with the chamber empty and then repeated, this time with a new dummy round in the chamber. There is not a specification for these forces and the readings will be taken for information only.

Method:

- After locating the rifle in the trigger pull fixture and securely locking in place, (it may be necessary to clamp the fixture to the bench if not already securely fixed in place), locate the hook of the force gauge at the point on the bolt handle just behind the ball.
- With the chamber empty and using the Chatillion gauge, pull the gauge straight up and perpendicular to the bore, measure the force required to open the bolt.
- Lock the firearm in a horizontal position, using the trigger pull holding fixture, (i.e. shooting position) before taking the measurements.

J.R.Snedeker

Page 18 of 51

9:03 AM 9/21/00

TLW0300

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Revision # 0

ET53610

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- Take three readings for each gun in the sample.
- Record all readings.
- Repeat the procedure only this time push the bolt closed.
- Note that it may be necessary to start the bolt closed by hand so the firing pin head is depressed sufficiently out of the notch and can start up the cam surface of the bolt as the firing pin is cocked.
- Repeat the above procedure this time with a new, unused dummy round in the chamber.

Data Required:

- Rifle serial number
- Each of the three readings taken for each of the 4 states for each test sample
- The average of each set of three measurements per state

TLW0300M - Measure Magazine Spring Force:

The force produced by the compression of the Magazine Spring in the box with the follower attached will be measured. These measurements will be taken for information only. There is no specification currently defined for this characteristic.

Method:

- Use the Chatillon TCD200 Spring Testing Machine with the Chatillon Digital Force Gauge (0-10 lb. range). Use the disc probe (½" dia.) on the gauge.
- Place the magazine box, bottom side down, on the staging table.
- Zero force gauge with no load applied.
- Lower the gauge until it just touches the magazine follower, approximately in the middle location both side to side and front to rear.
- Zero force gauge again if necessary.
- Lower the gauge 0.200" and take the spring force measurements.
- Lower the gauge another 1.0".
- Take the force measurement at this depressed location of the spring.

J.R.Snedcker

Page 19 of 51

9:03 AM 9/21/00

TLW0300

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Revision # 0

ET53611

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- Repeat procedure two additional trials for each box.
- Average the 3 trials for each box and at each measurement location.

Data Required:

- Force Measurements taken on each trial per box at each of the measurement locations.
- The Average Force measurement per box.
- The serial number of the Chatillion Digital Force Gauge used for the procedure.

TLW0300N – Firing Pin Head / Sear Engagement:

Measure using technique developed by M. Keeney for previous DAT testing. Minimum acceptable engagement to be equal or greater than 0.049”.

TLW0300O – Bolt Stop Function Check

The Bolt Stop will be checked for proper function. The bolt stop must prevent the bolt from being unintentionally withdrawn from the receiver when in the “locked” position and must permit the bolt to be withdrawn when in the “un-locked” position. Measure the amount of force required to move the bolt stop from the locked position to the un-locked position and record.

Data required:

- Rifle serial number
- Measurements of force required to move bolt stop from the locked position to the unlocked position.
- Record check of bolt stop function relative to bolt retention.

J.R. Snedeker

Page 20 of 51

9:03 AM 9/21/00

TLW0300

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Revision # 0

ET53612

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**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

Page 21 of 51

9:03 AM 9/21/00

TLW0300

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Revision # 0

ET53613

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**TLW0300T – Perform Bore Sighting Using Bushnell Scope.**

Prior to the start of live fire testing and accuracy testing a sample of the rifles will be bore sighted using the Bushnell Scopes. Use rifles A21 - A28. Use standard Bore sighting procedures in the Long Range sighted in at 100 yards.

**Data required:**

- Rifle serial number
- POI relative to Point of Aim for each rifle.
- Review results prior to further live fire testing of the test lot.

**CONFIDENTIAL** 83

J.R.Snedeker

Page 22 of 51

9:03 AM 9/21/00

TLW0300

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Revision # 0

ET53614

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**GUN CHARACTERISTICS - TLW0300R THROUGH TLW0300S:**

**TLW0300R - Balance Point - "System (includes the Scope and mount rails)":**

Establish the balance point for this firearm system. (This measurement will also be used later for the SAAMI drop test.)

**Method:**

- Using a right angle block from the metrology lab, invert the block to provide a "sharp edge"
- Close the action over an empty chamber and with the magazine empty
- Using two hands, carefully place the firearm in a horizontal orientation, over the edge of the angle block with the bottom of the firearm in the down position.
- Again, using two hands, one on each side of the block edge about one foot from the block edge front to rear, carefully place the firearm on the edge and attempt to locate the balance point.
- With the assistance of another individual, place a light pencil mark at the likely balance point. After removing the firearm from the edge, measure the distance to the breech face with the bolt in the closed position. (The position of the breech face was determined when the barrel length was measured. This location, that is, the breech face can be established by measuring the specific distance from the muzzle to outside of the receiver and marked accordingly. The distance from the balance point to this breech face mark is the location of the balance point.)
- Repeat this procedure for the following condition:
  - Using .30-06 dummy shells, place one in the chamber and four in the magazine, close the action and measure the distance to the bolt face.

**Data Required:**

- Record rifle serial number
- Record balance point with firearm empty
- Record balance point with firearm "loaded"

J.R.Snedeker

Page 23 of 51

9:03 AM 9/21/00

TLW0300

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Revision # 0

ET53615

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TLW0300S – Balance Point – Rifle Only (Without Scope, rails and Iron Sights):

Establish the balance point for this firearm. (This measurement will also be used later for the SAAMI drop test.)

Method:

- Using a right angle block from the metrology lab, invert the block to provide a “sharp edge”.
- Close the action over an empty chamber and with the magazine empty
- Using two hands, carefully place the firearm in a horizontal orientation, over the edge of the angle block with the bottom of the firearm in the down position.
- Again, using two hands, one on each side of the block edge about one foot from the block edge front to rear, carefully place the firearm on the edge and attempt to locate the balance point.
- With the assistance of another individual, place a light pencil mark at the likely balance point. After removing the firearm from the edge, measure the distance to the breech face with the bolt in the closed position. (The position of the breech face was determined when the barrel length was measured. This location, that is, the breech face can be established by measuring the specific distance from the muzzle to outside of the receiver and marked accordingly. The distance from the balance point to this breech face mark is the location of the balance point.)
- Repeat this procedure for the following condition:
  - Using .30-06 dummy shells, place one in the chamber and four in the magazine, close the action and measure the distance to the bolt face.

Data Required:

- Record rifle serial number
- Record balance point with firearm empty
- Record balance point with firearm “loaded”

J.R.Snedeker

Page 24 of 51

9:03 AM 9/21/00

TLW0300

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Revision # 0

ET53616

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FIREARMS MEASUREMENTS - TLW0300T THROUGH TLW0010X:

TLW0300T - Chamber cast:

Use the .30-06-chamber drawing LB-153 for reference.

Method:

- Make chamber cast using standard procedure
- Use the 30" optical comparator
- Measure the following dimensions:
  - .4708/.4728
  - .4425/.4440
  - 34° 30" Angle
  - .3404/.3424
  - .3095/.3105

Data Required:

- Rifle serial numbers
- Record dimensions requested above.

TLW0300U - Bore Diameter:

Measure Bore Diameter using standard procedures.

Method:

- Measure .30-06 caliber
- Dimension equals .300/.301

Data Required:

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Page 25 of 51

9:03 AM 9/21/00

TLW0300

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Revision # 0

ET53617

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- Rifle serial numbers
- Measurements of each bore by serial number

**TLW0300V - Groove Diameter:**

Measure Groove Diameter using standard procedures.

Method:

- Measure .30-06 caliber
- Dimension equals .308/.309

Data Required:

- Rifle serial numbers
- Measurements of each bore by serial number

**TLW0300W - Twist Rate (.30-06)**

Measure Twist Rate using standard procedures.

Method:

- Measure .30-06 caliber
- 1 turn in 10" ± .25", RH

Data Required:

- Rifle serial numbers
- Measurements of each bore by serial number

**TLW0300X - Magazine Capacity Test:**

Rifles with the magazine fully loaded must be able to be inserted into firearm with the bolt closed and in the locked position. Model 710 must be able to accept 4 rounds in the magazine and load into a closed bolt.

J.R.Snedeker

Page 26 of 51

9:03 AM 9/21/00

TLW0300

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Revision # 0

ET53618

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Method:

- Check rifle for live ammunition
- With muzzle pointed in a safe direction, close the bolt and lock over an empty chamber
- Load 4 dummy rounds into the magazine
- Insert magazine into the rifle, it must lock securely in place
- Cycle the 4 dummy rounds through the chamber and eject each round
- Remove the magazine box and repeat test two additional times per sample rifle.

Data Required:

- Rifle serial number
- Record any failures to load and cycle properly by box and rifle.

**CONFIDENTIAL** 83

J.R.Snedeker

Page 27 of 51

9:03 AM 9/21/00

TLW0300

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Revision # 0

ET53619

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**FUNCTION & ENDURANCE TESTING:****FUNCTION AND ENDURANCE TESTING - TLW0300Y THROUGH TLW0300AB****TLW0300Y - Ten (10) Round Safety Function Test with Lanyard:**

As an additional safety precaution, each of the 28 sample rifles will be placed in the standard Remington test jack located in the Blow-Up Room and shot with ten rounds of standard load ammunition. Each shot will be fired with a lanyard with the shooter located outside of the room when the rifle is fired. At the completion of the ten rounds the rifle will be examined for any signs of damage or potential damage.

**TLW0300Z - Basic Jack Function Test (to 100 Rounds):**

To get a picture of the product's functional capability, a 100 round per rifle jack function test will be conducted. Five bullet types will be used, 20 rounds (all Remington) of each in each rifle to evaluate the potential for feeding problems. The test will be conducted in the test jacks with the "belly-protectors" in place and fully closed for each shot. All malfunctions and any unusual behavior will be noted on the data forms. The overall average of all sample rifles should be at or below 2-% malfunction rate. Up to two rifles from the sample of 28 are permitted to be removed from the averaging process if they have excessive malfunction rates relative to the remaining group of 26 samples. No major mechanical failures are allowed in the test sample. Major mechanical failures are defined as those failures that cannot easily be repaired with simple tools and/or readily available replacement parts. At the conclusion of this test the firearms will be carefully examined for signs of excessive wear, especially with respect to the plastic components.

**Method:**

- Check each rifle for the presence of the proof stamp(s) - do not shoot unless the stamp(s) are present.
- Check each rifle for headspace

J.R.Snedeker

Page 28 of 51

9:03 AM 9/21/00

TLW0300

Remington Confidential

Revision # 0

ET53620

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- Draw ammunition from stores – See test lab manager for ammo types to be used for this test.
- Each tester to have five rifles for test at any given time.
- The muzzle of each rifle will be inserted into the shooting port and the rifle placed securely in the test jack before the rifle is loaded.
- Load the five rounds into the rifle, one in the chamber and four in the magazine, do not shoot single shot by hand-feeding single rounds into the chamber.
- Push the safe to the “fire” position, be sure that the barrel is far enough within the port hole so that the muzzle will stay in the port when the rifle recoils. If there is any question, re-adjust the jack into a better position.
- With the lid on the belly protector closed, fire the first round in the chamber, listen for any off-sounds, and be alert for any other unusual behavior.
- Open the bolt; eject the spent round, note any extraction or ejection problems.
- Close the bolt to load the first round from the magazine into the chamber, note any feeding or stemming problems.
- Continue to fire the remaining rounds in the magazine until the last round is fired.
- Push the Safety to “On Safe” position, the safety will be pushed to the fire position at the start of every five round trial and will be pushed to the On Safe position at the end of every five round trial. Repetitive action of the safety lever on the trigger assembly side-plate needs to be determined.
- After firing twenty rounds (1 box of ammo) the rifle will be checked carefully for the presence of any live ammunition and if empty will be removed from the test jack and placed in the cooling rack. The safety will be in the “On Safe” position and the bolt will be unlocked and fully open at all times. Compressed air may be used, if necessary to cool the inside of the chamber area if the rifle is excessively hot from firing.
- All malfunctions will be recorded on the data sheets.

Data Required:

- Rifle serial number
- Tester’s name
- Date of test firing

J.R. Snedeker

Page 29 of 51

9:03 AM 9/21/00

TLW0300

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Revision # 0

ET53621

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- The TLW#
- The ammunition used for the test with the ammo lot code number of the rounds actually used.
- Any malfunctions noted or other unusual items of note.

**TLW0300AA - Extended Function & Endurance:**

This Extended Function & Endurance Test will be shot to determine an estimate of the product's expected malfunction rate over an extended period of shooting. For purposes of definition, a component failure will be one that prevents (or could prevent) the firearm from functioning as intended. These are failures that can be fixed relatively easily by the simple replacement of a part such as could be done by the gun owner using only simple household tools. System failures are defined as failures of a major nature, the extent of which would require specialized tooling or methods to repair not normally available to the average gun owner. Such a repair would be most likely made by a qualified gunsmith or by return to the factory.

This Extended Function & Endurance Test will be shot in the test jacks and the testers will use gloves for protection. The covers on the "belly protectors" will be down and in-place for each test shot. Careful monitoring of each test gun is essential to evaluate the malfunction rate for each firearm. The standard Remington test jacks will be used for all jack-related testing.

Each rifle will be shot, using a variety of Centerfire ammunition comprised of light, medium and heavy bullets. In addition, ammunition from the three major manufacturers (Remington, Winchester and Federal) of Centerfire ammunition shall be included in the mix.

Each rifle will be shot no more than 20 rounds before being put aside for cooling. Compressed air applied to the inside of the chamber will be an acceptable method to assist in the cool-down process.

The S.A.A.M.I. recommendation for the minimum acceptable malfunction rate for a bolt action rifle is a malfunction rate of < 2%. In this case, if the overall malfunction rate average for the test samples is > 2%, the test will be stopped. If the overall average malfunction rate is < 2% but one of the firearms is significantly greater than 2% malfunction rate, the test may continue with the other nine test samples. After assessment and repair, this gun will again be required to pass the 100 round jack function test at < 2% malfunction rate. If the

J.R. Snedeker

Page 30 of 51

9:03 AM 9/21/00

TLW0300

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Revision # 0

ET53622

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gun passes these criteria it will then be re-introduced into the Endurance test. It is important that total endurance rounds on the gun include any rounds that are put through the gun for re-test purposes.

The test will be performed according to Remington's standard endurance test procedures for centerfire rifle. Rounds for this test will be ten rifles to 400 rounds each.

Record all instances of malfunctions and failures, and replace parts when they become unserviceable noting the round level when they were replaced.

After every 100 rounds one live round will be extracted and ejected from the chamber to check on live round ejection. The ejected round will then be re-inserted into the chamber and fired to help keep the endurance round count accurate.

Method:

- Disassemble, thoroughly clean, lubricate per the design team's instructions, and re-assemble. Record headspace for each.
- Fire each test firearm in accordance with the firing procedure (number of rounds, firing cycle) specified by engineering and the test plan.
- Ammunition will be used that comprises at least five types of bullets, change ammunition type every 100 rounds.
- Before commencing design acceptance testing, calibrate, adjust, or re-build the shooting jacks, if necessary.
- Allow the firearm to completely recover in the shooting jack between each shot and do not lean or "stiff arm" the firearm while shooting the gun.
- All ammunition is to be functioned through the magazine - no "single shot" hand feeding permitted.
- Allow the rifle to cool between cycles. One cycle is 20 rounds fired. The use of forced air to accelerate cooling of the barrels between firing trials is permitted. The air should be directed from the chamber toward the muzzle to prevent it from washing the lubricant from the firearm's action.
- Cycle the safety from fire to safe every 5 rounds, from Safe to Fire at the start of the five round cycle and from Fire to Safe at the end of the 5 round cycle.
- After 400 rounds, disassemble, inspect, clean and lubricate the entire mechanism and take all required measurements.

J.R. Snedeker

Page 31 of 51

9:03 AM 9/21/00

TLW0300

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Revision # 0

ET53623

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- The Standard Remington Jacks (using the heavy configuration) are to be used for this test.

Data Required:

- Rifle serial number
- Tester's name
- The Test Jack Identification
- TLW#
- Date of actual testing
- Headspace after the 400 round interval.
- Malfunctions per ammo type, breakage, and replacement parts used.
- Any failure that requires the gun to be removed from testing completely.
- Notify management of any unusual events or malfunctions immediately.
- Any firing of the firearm without the trigger being pulled.
- Record ammunition lot code information as it is used throughout the test.
- Bullet type used for each 20 rounds of the test.

CONFIDENTIAL 83

TEW0300AB - Clean Rifles and Inspect:

After 400 rounds of Extended Function & Endurance, unless other wise specified, each rifle will be disassembled, cleaned and thoroughly inspected.

A list of inspection points will be provided in the gun packet for check-off and sign-off by the inspector. The inspector will be looking for any signs of unusual wear, especially on critical components and surfaces as well as for anything such as cracks or deformed material that might present a safety concern. Photographs will be taken to document unusual wear, damage or other notable characteristics. Use the following checklist for inspection:

J.R.Snedeker

Page 32 of 51

9:03 AM 9/21/00

TLW0300

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ET53624

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### Clean & Inspect Checklist

Model: \_\_\_\_\_ 710 \_\_\_\_\_

Project: \_\_\_\_\_ 241095 \_\_\_\_\_

Rifle: \_\_\_\_\_

TLW #: \_\_\_\_\_ TLW0300 \_\_\_\_\_

Date: \_\_\_\_\_ / \_\_\_\_\_ / \_\_\_\_\_

Inspector: \_\_\_\_\_

Round Level: \_\_\_\_\_

- Measure Headspace \_\_\_\_\_.
- Firing Pin Indent 1<sup>st</sup>. \_\_\_\_\_ 2<sup>nd</sup>. \_\_\_\_\_ 3<sup>rd</sup>. \_\_\_\_\_ Ave. \_\_\_\_\_
- Sear Engagement: \_\_\_\_\_.
- Trigger Pull: 1<sup>st</sup>. \_\_\_\_\_ 2<sup>nd</sup>. \_\_\_\_\_ 3<sup>rd</sup>. \_\_\_\_\_ Ave. \_\_\_\_\_
- Measure Feed Lip on Mag. Box at front: \_\_\_\_\_ & rear: \_\_\_\_\_.

Check the following areas for signs of unusual wear or breakage:

- Receiver insert
- Rear surface of Bolt Lugs
- Check for "galling" on rear of Bolt Lugs
- Bolt Plug
- Bolt Plug Insert "ears" on firing pin assembly
- Check for loose or missing pins – make note and re-stake if necessary
- Check plastic inserts for cracks or other damage.

Take digital photographs, if appropriate, to record unusual wear, damage or other noteworthy observations. List the digital file name for reference along with any comments below.

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**ACCURACY TESTING:****ACCURACY AND POI TESTING - TLW0300AC THROUGH TLW0300AF****TLW0300AC - POI & Group Size - Initial Test with High Quality 36X Scope:**

The point of impact test involves the verification of the firearms sighting system adjustment and the potential to hit the point of aim. Random variation and/or extreme difference in shot to shot point of impact (as well as group size) typically indicate improper barrel processing and is used as a final inspection flag in production. Shoot three, 5-shot groups from each test rifle. Use the same code of ammunition for all point of impact test shots.

**Method:**

- Certify the ammunition selected for muzzle velocity and pressure.
- Pick the point of aim on the target
- Adjust point of aim to the bulls-eye at 100 yards.
- Shoot five "warmer" shots
- Shoot three, 5 shot groups

**Data Required:**

- Measure the center of the impact groups to the point of aim in terms of "x" and "y" positions.
- Record takedown screw torque
- Record ammunition lot number used during the test
- Record and label any fail-to-fire ammunition

J.R.Snedeker

Page 34 of 51

9:03 AM 9/21/00

TLW0300

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Revision # 0

ET53626

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**TLW0300AD (@zero) - Group Size at 100 yards ( System Stability Test, w/Bushnell Scope @ "zero" rounds**

One hundred-yard accuracy testing will be completed utilizing standard factory ammunition. The test will consist of three, 5-shot groups. Guns will be cooled after every other group. Each firearm will be cleaned and fired with five fouling shots prior to beginning the accuracy work-up. Group sizes will be measured from actual targets and recorded. The same code of ammunition and same type of ammunition will be used for all group size test shots. Average group sizes must be  $\leq 3$ " at 100 yards.

**Method:**

- Certify the ammunition selected for muzzle velocity and pressure.
- Fire three, 5-shot groups at 100 yards, for each ammunition type selected. Prior to beginning of the test, clean the bore and shoot 5 "fouling" shots to seat in the rifle.
- Cycle the safety from fire to safe every 5 rounds.
- Accuracy should be shot from a receding rest. Shoulder shooting is acceptable but not the preferred way.

**Data Required:**

- Measure group sizes center to center
- Record takedown screw torque
- Record make and identifier of scope
- Record ammunition type used.
- Record ammunition lot numbers used during the test
- Record and label any fail-to-fire ammunition.
- Record any malfunctions that occur during the test.

**TLW0300AE (@100)- Group Size at 100 yards ( System Stability Test, w/Bushnell Scope @ "100" rounds**

J.R.Snedeker

Page 35 of 51

9:03 AM 9/21/00

TLW0300

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Revision # 0

ET53627

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One hundred-yard accuracy testing will be completed utilizing standard factory ammunition. The test will consist of three, 5-shot groups. Guns will be cooled after every other group. Each firearm will be cleaned and fired with five fouling shots prior to beginning the accuracy work-up. Group sizes will be measured from actual targets and recorded. The same code of ammunition and same type of ammunition will be used for all group size test shots. Average group sizes must be  $\leq 3''$  at 100 yards.

Method:

- Certify the ammunition selected for muzzle velocity and pressure.
- Fire three, 5-shot groups at 100 yards, for each ammunition type selected. Prior to beginning of the test, clean the bore and shoot 5 "fouling" shots to seat in the rifle.
- Cycle the safety from fire to safe every 5 rounds.
- Accuracy should be shot from a recoiling rest. Shoulder shooting is acceptable but not the preferred way.

Data Required:

- Measure group sizes center to center
- Record takedown screw torque
- Record make and identifier of scope
- Record ammunition type used
- Record ammunition lot numbers used during the test
- Record and label any fail-to-fire ammunition.
- Record any malfunctions that occur during the test.

TLW0300AF (@200) - Group Size at 100 yards ( System Stability Test, w/Bushnell Scope @ "200" rounds

One hundred-yard accuracy testing will be completed utilizing standard factory ammunition. The test will consist of three, 5-shot groups. Guns will be cooled after every other group. Each firearm will be cleaned and fired with five fouling shots prior to beginning the accuracy work-up. Group sizes will be measured from

J.R.Snedeker

Page 36 of 51

9:03 AM 9/21/00

TLW0300

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Revision # 0

ET53628

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actual targets and recorded. The same code of ammunition and same type of ammunition will be used for all group size test shots. Average group sizes must be  $\leq 3"$  at 100 yards.

Method:

- Certify the ammunition selected for muzzle velocity and pressure.
- Fire three, 5-shot groups at 100 yards, for each ammunition type selected. Prior to beginning of the test, clean the bore and shoot 5 "fouling" shots to seat in the rifle.
- Cycle the safety from fire to safe every 5 rounds.
- Accuracy should be shot from a recoiling rest. Shoulder shooting is acceptable but not the preferred way.

Data Required:

- Measure group sizes center to center
- Record takedown screw torque
- Record make and identifier of scope
- Record ammunition type used.
- Record ammunition lot numbers used during the test
- Record and label any fail-to-fire ammunition.
- Record any malfunctions that occur during the test.

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# ENVIRONMENTAL TESTING:

## TEMPERATURE & HUMIDITY – TLW0300AG THROUGH TLW0300AI

### TLW0300AG - Hot Function Test:

This test evaluates the effect of extreme high temperatures on the functioning performance of firearms.

#### Method:

- Condition test firearm and 100 rounds of ammunition of each caliber in a climatic chamber for at least 6 hours at a temperature of 120 degrees F. (or as close to 120 degrees F. as the equipment can be maintained.)
- Test each firearm after removing from the chamber as follows:
  - Fire 20 rounds of ammunition. Replace the rifle in the chamber. Wait 2 hours and repeat procedure until all 100 rounds have been fired.
  - Do not perform maintenance during the 100 round cycle.
  - Cycle the safety from fire to safe every 5 rounds.
  - The tester should wear gloves to protect his hands from the hot metal.
- After 100 rounds have been fired through each firearm, disassemble, thoroughly inspect, clean and lubricate.

#### Data Required:

- Record temperature and exposure times
- Record all malfunctions.
- Record damage noted during inspection

### TLW0300AH - Cold Function Test:

This test evaluates the effect of extreme low temperatures on the functioning performance of the firearms. Shoot the firearm after removing from the environmental test cabinet.

#### Method:

J.R. Snedeker

Page 38 of 51

9:03 AM 9/21/00

TLW0300

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Revision # 0

ET53630

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- Condition the firearm and 100 rounds of ammunition of climatic chamber for at least 6 hours at a temperature of -20 degrees F.
- Test each firearm after removing from the chamber as follows:
- Fire 20 rounds of ammunition. Return the firearm to the chamber. Wait 2 hours and repeat procedure until all 100 rounds have been fired.
- Do not perform maintenance during the 100 round cycle.
- Cycle the safety from fire to safe every 5 rounds.
- After 100 rounds have been fired through the firearm, disassemble, thoroughly inspect, clean and lubricate.

Data Required:

- Record temperature and exposure times
- Record all malfunctions.
- Record damage noted during inspection

TLW0300AI - Heat & Humidity Function Test:

Method:

- Shoot the firearm after removing from the environmental test cabinet in the long range.
- Store the gun and ammunition for a minimum of six hours at a temperature of +100°F and 80-90% Relative Humidity.
- Shoot 100 rounds and record all malfunctions or other unusual events.
- Test each firearm after removing from the chamber as follows:
- Fire 20 rounds of ammunition. Return the firearm to the chamber. Wait 2 hours and repeat procedure until all 100 rounds have been fired.
- Do not perform maintenance during the 100 round cycle.
- Cycle the safety from fire to safe every 5 rounds.
- After 100 rounds have been fired through the firearm, disassemble, thoroughly inspect, clean and lubricate.

Data Required:

J.R.Snedeker

Page 39 of 51

9:03 AM 9/21/00

TLW0300

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Revision # 0

ET53631

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- Record temperature and exposure times
- Record all malfunctions.
- Record damage noted during inspection

## ABUSIVE TESTING

### IMPACT TESTING – TLW0300AJ THROUGH TLW0300AM

#### TLW0300AJ – SLAM Test:

For this test the sample firearm will be placed in the standard Remington test jack. Four live rounds will be loaded into the rifle's magazine and the magazine installed in the rifle. The tester will use a glove for hand protection.

For each of the four rounds in the magazine the tester will close the bolt "smartly" – (i.e. as quickly as practical) – and be prepared for the rifle to inadvertently follow down or fire. After each bolt closing the round will be fired then the bolt will be opened and the spent round will be ejected and the next round in the box will again be loaded into the chamber in a "smart" manner. The purpose of this test is to determine if the firing pin will "follow-down" if the round is rammed home into the chamber as quickly as possible. Repeat this cycle until all 20 rounds of the test are completed. There should be no follow-downs or inadvertent firings.

Data required:

- Record whether or not the firearm fires or follows-down.
- Record round level on the firearm.
- Record the serial number of the rifle.

J.R. Snedeker

Page 40 of 51

9:03 AM 9/21/00

TLW0300

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Revision # 0

ET53632

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**TLW0300AK - SAAMI Drop Test – “System’ (Includes the Scope and Mounting Rails):**

This test will simulate abusive dropping of the firearm from a distance of 48 inches onto a 1” thick 85 durometer (Shore A) rubber mat backed by concrete. Trigger Pull weight will be adjusted to minimum specification (4 lb.) The Trigger/Sear engagement will be set to the minimum specification (0.020”). Test will be performed according to SAAMI Technical Committee procedures. Magazine capacity will be filled according to SAAMI procedures. After each series of test, the primed case will be discharged to insure validity of test. This test will be performed on a sample of six firearms of .30-06 caliber.

**Method:**

- With the firearm safety in the SAFE state, the firearm shall be capable of passing the below test criteria for drop testing from a height of four feet onto an 85±5 Durometer, Shore A, rubber mat, one-inch thick backed by concrete. The mat and concrete shall be large enough so that when the gun is dropped it will fall and come to rest without interference within the perimeter of the mat. The four feet shall be measured from the surface of the rubber mat to the center of gravity of the firearm. The center of gravity shall be determined to an accuracy of ± one inch by any recognized method for finding the center of gravity of an irregular shaped object. The primed case shall be discharged following the drop and a fresh primed cartridge re-chambered prior to the next drop. A “fresh” firearm may be substituted into the test at any point.
- The firearm or firearms shall be dropped in such a way as to strike the rubber mat surface once in each of the following attitudes:
  - Barrel vertical, muzzle down.
  - Barrel vertical, muzzle up.
  - Barrel horizontal, bottom up.
  - Barrel horizontal, bottom down.
  - Barrel horizontal, left side up.
  - Barrel horizontal, right side up.

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- Tests shall be conducted with the trigger pull force set at the minimum force specified, with engagement set to the minimum specified, and with the firecontrol lubricated as in the owner's manual.
- The test shall be conducted with the magazine or clip fully loaded with dummy cartridges and inserted in the firearm.
- Parts breakage or other damage as a result of drop testing does not constitute failure as long as the empty primed case does not fire and the firearm can be unloaded safely after each drop. More stocks are required than the amount of test guns to allow for breakage due to the drop testing. If a stock cracks - replace before continuing test.

Data required:

- Record whether or not the firearm fires an empty primed case of its designated cartridge when tested in accordance with this procedure.
- Record round level

TLW0300AL - SAAMI Jar-Off Test - "System" (Includes the Scope and Mounting Rails):

The objective of the jar-off test is to simulate the abusive impacting (bumping) of the firearm against a hard surface with the firearm in a condition of maximum readiness. With the firearm in the ready to fire condition, the firearm shall be capable of withstanding a jar-off shock equivalent to being dropped from a height of 12 inches onto a 1" thick 85 Durometer (Shore A) rubber mat backed by concrete. Trigger Pull weight will be adjusted to minimum specification. The test will be performed according to SAAMI Technical Committee procedures. Magazine will be loaded to maximum capacity with dummy rounds according to SAAMI procedures. A fresh primed case will be chambered prior to each drop. After each drop the primed case will be discharged to verify its validity. This test will be performed on a sample of firearms made up of .30-06 caliber.

Method:

J.R.Snedeker

Page 42 of 51

9:03 AM 9/21/00

TLW0300

Remington Confidential

Revision # 0

ET53634

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- With the firearm cocked and the safety in the FIRE position the firearm shall be capable of withstanding jar-off shock equivalent to being dropped from a height of twelve inches onto a 85±5 Durometer, Shore A, rubber mat, one-inch thick backed by concrete. The mat and concrete shall be large enough so that when the gun is dropped it will fall within the perimeter of the mat striking the mat once. The twelve inches will be measured from the test surface to the lowest point on the firearm. As an alternate to free dropping, other methods may be substituted if they provide equivalent impact characteristics. The primed case shall be discharged following the drop and a fresh primed cartridge re-chambered prior to the next drop. A "fresh" firearm may be substituted into the test at any point.
- The firearm or firearms shall be dropped in such a way as to strike the rubber mat surface once in each of the following attitudes:
  - Barrel vertical, muzzle down.
  - Barrel vertical, muzzle up.
  - Barrel horizontal, bottom up
  - Barrel horizontal, bottom down.
  - Barrel horizontal, left side up.
  - Barrel horizontal, right side up.
- Tests shall be conducted with the trigger pull force set at the minimum force specified, with engagement set to the minimum specified, and with the firecontrol lubricated per the owner's manual.
- The test shall be conducted with the magazine or clip fully loaded with dummy cartridges and inserted in the firearm.
- Parts breakage or other damage as a result of drop testing does not constitute failure as long as the empty primed case does not fire and the firearm can be unloaded safely after each drop. More stocks are required than the amount of test guns to allow for breakage due to the drop testing. If a stock cracks - replace before continuing test.

Data required:

- Record engagement and trigger pull.

J.R.Snedeker

Page 43 of 51

9:03 AM 9/21/00

TLW0300

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Revision # 0

ET53635

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- Record whether or not the firearm fires an empty primed case of its designated cartridge when tested in accordance with this procedure.
- Record the round level on the firearm.

**TLW0300AM - SAAMI Rotation Test – “System” (Includes the Scope and Mounting Rails):**

The test will be conducted according to SAAMI Technical Committee procedures. The firearm will be placed in the “Safe Carrying” condition and dropped from an upright position with its butt resting on the surface of a 1” thick 85 durometer (Shore A) rubber mat backed by concrete. Trigger Pull weight will be adjusted to minimum specification. Magazine will be loaded to maximum capacity with dummy rounds according to SAAMI procedures. The firearm shall be tested (dropped) on both the right and left sides. After each rotation, the primed case will be discharged to insure validity of test.

**Method:**

- With the firearm safety in the SAFE state, the firearm shall be capable of passing the below test criteria when allowed to fall freely from an upright position with its butt resting on the surface of a 85±5 Durometer, Shore A, rubber mat, one-inch thick backed by concrete. The mat and concrete shall be large enough so that when the gun falls it will come to a rest without interference within the perimeter of the mat. The firearm shall be tested so as to fall once on its right-hand side and once on its left-hand side. The primed case shall be discharged following the drop and a fresh primed cartridge re-chambered prior to the next drop. A “fresh” firearm may be substituted into the test at any point.
- Tests shall be conducted with the trigger pull force set at the minimum force specified, with engagement set to the minimum specified, and with the firecontrol lubricated per the owner’s manual.
- The test shall be conducted with the magazine or clip fully loaded with dummy cartridges, inserted in the firearm.
- Parts breakage or other damage as a result of drop testing does not constitute failure as long as the empty primed case does not fire and the firearm can be unloaded safely after each drop. More stocks are required

J.R.Snedeker

Page 44 of 51

9:03 AM 9/21/00

TLW0300

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Revision # 0

ET53636

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than the amount of test guns to allow for breakage due to the drop testing. If a stock cracks - replace before continuing test.

Data required:

- Record whether or not the firearm fires an empty primed case of its designated cartridge when tested in accordance with this procedure.
- Record round level on the firearm

TLW0300AN - SAAMI Drop Test – Rifle Only (Without the Scope and Mounting Rails):

83

This test will simulate abusive dropping of the firearm from a distance of 48 inches onto a 1" thick 85 durometer (Shore A) rubber mat backed by concrete. Trigger Pull weight will be adjusted to minimum specification (4 lb.) The Trigger/Sear engagement will be set to the minimum specification (0.020"). Test will be performed according to SAAMI Technical Committee procedures. Magazine will be loaded to maximum capacity with dummy rounds according to SAAMI procedures. After each series of test, the primed case will be discharged to insure validity of test. This test will be performed on a sample of four firearms (for Phase I) and six firearms (Phase II) of .30-06 calibers only and six rifles of .270 caliber when available.

Method:

- With the firearm safety in the SAFE state, the firearm shall be capable of passing the below test criteria for drop testing from a height of four feet onto an 85±5 Durometer, Shore A, rubber mat, one-inch thick backed by concrete. The mat and concrete shall be large enough so that when the gun is dropped it will fall and come to rest without interference within the perimeter of the mat. The four feet shall be measured from the surface of the rubber mat to the center of gravity of the firearm. The center of gravity shall be determined to an accuracy of ± one inch by any recognized method for finding the center of gravity of an irregular shaped object. The primed case shall be discharged following the drop and a fresh primed cartridge re-chambered prior to the next drop. A "fresh" firearm may be substituted into the test at any point.
- The firearm or firearms shall be dropped in such a way as to strike the rubber mat surface once in each of the following attitudes:

J.R.Snedeker

Page 45 of 51

9:03 AM 9/21/00

TLW0300

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Revision # 0

ET53637

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- Barrel vertical, muzzle down.
  - Barrel vertical, muzzle up.
  - Barrel horizontal, bottom up.
  - Barrel horizontal, bottom down.
  - Barrel horizontal, left side up.
  - Barrel horizontal, right side up.
- Tests shall be conducted with the trigger pull force set at the minimum force specified, with engagement set to the minimum specified, and with the firecontrol lubricated as in the owner's manual.
  - The test shall be conducted with the magazine or clip fully loaded with dummy cartridges and inserted in the firearm.
  - Parts breakage or other damage as a result of drop testing does not constitute failure as long as the empty primed case does not fire and the firearm can be unloaded safely after each drop. More stocks are required than the amount of test guns to allow for breakage due to the drop testing. If a stock cracks - replace before continuing test.

Data required:

- Record whether or not the firearm fires an empty primed case of its designated cartridge when tested in accordance with this procedure.
- Record round level

**TLW0300AO - SAAMI Jar-Off Test – Rifle Only (Without the Scope and Mounting Rails):**

The objective of the jar-off test is to simulate the abusive impacting (bumping) of the firearm against a hard surface with the firearm in a condition of maximum readiness. With the firearm in the ready to fire condition, the firearm shall be capable of withstanding a jar-off shock equivalent to being dropped from a height

J.R.Snedeker

Page 46 of 51

9:03 AM 9/21/00

TLW0300

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Revision # 0

ET53638

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of 12" inches onto a 1" thick 85 Durometer (Shore A) rubber mat backed by concrete. Trigger Pull weight will be adjusted to minimum specification. The test will be performed according to SAAMI Technical Committee procedures. Magazine will be loaded to maximum capacity with dummy rounds according to SAAMI procedures. A fresh primed case will be chambered prior to each drop. After each drop the primed case will be discharged to verify its validity. This test will be performed on a sample of firearms made up of .30-06 caliber.

Method:

- With the firearm cocked and the safety in the FIRE position the firearm shall be capable of withstanding jar-off shock equivalent to being dropped from a height of twelve inches onto a 85±5 Durometer, Shore A, rubber mat, one-inch thick backed by concrete. The mat and concrete shall be large enough so that when the gun is dropped it will fall within the perimeter of the mat striking the mat once. The twelve inches will be measured from the test surface to the lowest point on the firearm. As an alternate to free dropping, other methods may be substituted if they provide equivalent impact characteristics. The primed case shall be discharged following the drop and a fresh primed cartridge re-chambered prior to the next drop. A "fresh" firearm may be substituted into the test at any point.
- The firearm or firearms shall be dropped in such a way as to strike the rubber mat surface once in each of the following attitudes:
  - Barrel vertical, muzzle down.
  - Barrel vertical, muzzle up.
  - Barrel horizontal, bottom up
  - Barrel horizontal, bottom down.
  - Barrel horizontal, left side up.
  - Barrel horizontal, right side up.
- Tests shall be conducted with the trigger pull force set at the minimum force specified, with engagement set to the minimum specified, and with the firecontrol lubricated per the owner's manual.
- The test shall be conducted with the magazine or clip fully loaded with dummy cartridges and inserted in the firearm.

J.R. Snedeker

Page 47 of 51

9:03 AM 9/21/00

TLW0300

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Revision # 0

ET53639

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- Parts breakage or other damage as a result of drop testing does not constitute failure as long as the empty primed case does not fire and the firearm can be unloaded safely after each drop. More stocks are required than the amount of test guns to allow for breakage due to the drop testing. If a stock cracks - replace before continuing test.

Data required:

- Record engagement and trigger pull.
- Record whether or not the firearm fires an empty primed case of its designated cartridge when tested in accordance with this procedure.
- Record the round level on the firearm.

**TLW0300AP - SAAMI Rotation Test – Rifle Only (Without Scope and Mounting Rails):**

The test will be conducted according to SAAMI Technical Committee procedures. The firearm will be placed in the "Safe Carrying" condition and dropped from an upright position with its butt resting on the surface of a 1" thick 85 durometer (Shore A) rubber mat backed by concrete. Trigger Pull weight will be adjusted to minimum specification. Magazine will be loaded to maximum capacity with dummy rounds according to SAAMI procedures. The firearm shall be tested (dropped) on both the right and left sides. After each rotation, the primed case will be discharged to insure validity of test.

Method:

- With the firearm safety in the SAFE state, the firearm shall be capable of passing the below test criteria when allowed to fall freely from an upright position with its butt resting on the surface of a 85±5 Durometer, Shore A, rubber mat, one-inch thick backed by concrete. The mat and concrete shall be large enough so that when the gun falls it will come to a rest without interference within the perimeter of the mat. The firearm shall be tested so as to fall once on its right-hand side and once on its left-hand side. The primed case shall be discharged following the drop and a fresh primed cartridge re-chambered prior to the next drop. A "fresh" firearm may be substituted into the test at any point.

J.R.Snedeker

Page 48 of 51

9:03 AM 9/21/00

TLW0300

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Revision # 0

ET53640

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- Tests shall be conducted with the trigger pull force set at the minimum force specified, with engagement set to the minimum specified, and with the firecontrol lubricated per the owner's manual.
- The test shall be conducted with the magazine or clip fully loaded with dummy cartridges, inserted in the firearm.
- Parts breakage or other damage as a result of drop testing does not constitute failure as long as the empty primed case does not fire and the firearm can be unloaded safely after each drop. More stocks are required than the amount of test guns to allow for breakage due to the drop testing. If a stock cracks - replace before continuing test.

Data required:

- Record whether or not the firearm fires an empty primed case of its designated cartridge when tested in accordance with this procedure.
- Record round level on the firearm

INTENTIONAL ABUSE- TLW0300AV THROUGH TLW0300AX

Note that for all of the following tests, the rounds are to be loaded remotely and the test setup shall have the capability of unloading live rounds remotely if required.

TLW0300AQ - Pierced Primer Test:

For this test, a firing pin will be altered to have a "wedge-shaped" point. This type of firing pin point should produce a pierced primer when fired. The purpose of piercing the primer is to allow high-pressure gases to escape into the action and thereby determine the effect of high-pressure gases when dumped into the bolt, magazine box and receiver areas. All standard Remington high-pressure ammunition safety procedures will be used for this test. A standard round of .30-06 ammunition will be used.

J.R.Snedeker

Page 49 of 51

9:03 AM 9/21/00

TLW0300

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Revision # 0

ET53641

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After firing the rifle will be examined for damage. Photographs of damaged components will be taken and kept for record. The rifle will be tagged and saved for possible future review.

Method:

- Position firearm in test jack located in the "Blow-up" room with the muzzle through the port.
- Set witness paper at the rear of the action perpendicular to the bore.
- Locate witness paper at the approximate location expected for the shooter's face.
- Set up the High Speed Video to tape the firing test.
- Fasten a lanyard around the stock and run through the trigger guard in front of the trigger.
- Load a standard factory .30-06 round into the chamber, and carefully close the bolt.
- All personnel are to leave the room.
- When ready to conduct the test start the high speed video and pull the lanyard.
- Carefully examine the scene looking for any broken or missing parts, holes in the witness paper etc.

Data Required:

- Rifle serial number.
- The condition of the witness paper.
- Notes of any broken or missing parts.
- Photographs of broken or missing parts.

TLW0300AR - High Pressure Test:

The rifle will be tested to 120,000 psi. The purpose of this test is to determine the extent of damage if an individual does purposely or accidentally handload an extremely high pressure load. Use standard Remington high-pressure ammunition safety procedures for these tests. The pressures for the test round will be worked up using various grain size loads giving pressures below 95,000 psi, (approaching the limits of the transducer gauges.) The grain size load will be plotted and a curve extrapolated to determine the load expected to produce a load of approximately 120,000-psi.

J.R.Sncdeker

Page 50 of 51

9:03 AM 9/21/00

TLW0300

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Revision # 0

ET53642

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All testing will be done in the blow-up room using the high-speed video camera and witness paper. Before removing or otherwise disturbing the test samples after blow-up, photographs will be taken for the record. After collection and removal of the parts additional photographs of the various individual components will be taken for the record. All parts will be put in sample bags, boxed and temporarily stored for review if required.

**TLW0300AS - Obstructed Bore Test:**

One of the sample rifles will have a rifle bullet driven into the bore to a position immediately ahead of the chamber. A standard round (.30-06, 220 gr. factory load) will be loaded and fired remotely. All testing will be done in the blow-up room using the high-speed video camera and witness paper. Before removing or otherwise disturbing the test samples after blow-up photographs will be taken for the record. After collection and removal of the parts additional photographs of the various individual components will be taken for the record. All parts and will put in sample bags, boxed and temporarily stored for review if required.

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J.R.Snedeker

Page 51 of 51

9:03 AM 9/21/00

TLW0300

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Revision # 0

ET53643