

**CONFIDENTIAL**

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

Data Required:

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

**TLW0010E - 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.
- 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

J.R. Snedeker

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