

CONFIDENTIAL

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

TLW 1012

- Attempt to close and lock-up the bolt. You should not be able to completely rotate the bolt to the fully locked up position (Bolt Handle down). If the bolt cannot be closed the test sample passes the test. Record results and proceed to Step 2.
 - If the bolt can be closed completely proceed as follows. **Remember that there is a primed case in the chamber. The muzzle of the gun will still be kept in the shooting port.**
 - Place the safety in the "Fire" position and pull the trigger. The firing pin must not fall completely and set off the primed case. If the primed case fires then the test sample fails the test. Note that the firing pin should move forward some (but not enough to make contact with the primer.)
 - If the primed case does not fire, attempt to unlock the ISS with the ISS key quickly by rotating the ISS plunger counterclockwise. Be careful; only apply enough force to see if you can unlock the ISS, without bending the tool. You may hear a click and the firing pin head may move a small amount but should not fall fully. This is considered normal. If the ISS cannot be fully unlocked then the gun passes this test, proceed to Step 2.
 - If the ISS can be fully unlocked after pulling the trigger and/or the primed case is fired at any time during this procedure the test sample fails the test. Record results and stop any further testing of this rifle. If the ISS cannot be fully unlocked and a primed case is not fired the test sample passes the test.
 - Record outcome of all steps taken.
2. If the test sample passes the above test then perform the following procedure.
- Move the safety to the "On Safe" position if it is not already there.
 - 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 on the top - See Pictures) using the ISS key. **Remember that there is still a primed case in the rifle.**
 - Push the bolt forward slowly, re-chambering the primed case, and fully lock the bolt by rotating the Operating Handle down.
 - Make sure the muzzle of the rifle is in the shooting port.
 - 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.
 - Open the action and eject the primed case.
 - Put the Safety in the "On" position.
 - Record results.
3. If the system passes both tests above then perform this procedure.
- Make sure the gun is completely unloaded of live ammo or primed cases.
 - Open the bolt to the rearward position and put the safety in the "On Safe" position.
 - Rotate the ISS to the locked position (*White* dot visible on the top - See Pictures) using the ISS key.
 - Attempt to unlock the ISS first using your fingers and then using a small screwdriver. You must not be able to unlock the ISS System with anything except the ISS key. (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 key.)
 - Record results.
4. For the final check unlock the ISS system (*Red* dot visible on the top - See Pictures) using the ISS key and make sure the Safety is in the "On Safe" position. ***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.***
- Load a primed case into the chamber by inserting with your hand.
 - Close and lockup the bolt.
 - Using the ISS key attempt to lock the ISS system (*White* dot visible on the top - See Pictures). Be careful; do not use excessive force or the ISS key will be damaged. You should not be able to **completely** lock the ISS system (See Pictures) with the bolt closed on a M/504.
 - Record results.
 - If the ISS can be rotated to an intermediate position, white dot visible but not on the top (See Pictures), then perform the following procedure.

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