readings for each firearm. Repeat the test, this time pushing the Safe to the "Safe On" position on each trial. Record all three readings. Average each of the three sets of readings in each direction for each test sample. These measurements are for information only. A minimum of 1 lb. force in either direction will be assumed as the reference criteria.

Method:

- Use trigger pull apparatus to hold the rifle for this test.
- Use either the Spring Scale or 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 each direction for each sample.
- Average the results of each of the three trials.
- The ISS system will be checked for proper function.

Data Required:

- Rifle serial number
- Each of the three readings for each direction on each sample
- The average of each of the three sets of readings
- The results of the ISS system check.

TLW0630H - Measure Bolt Lift and Bolt Closing Forces – (Do This Test on the Stainless Version)

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.