

**CONFIDENTIAL**

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

**TLW 1005**

- Shotgun serial number
- Record and note any headspace growth and round level.
- TLW Number
- Testers' Names

**TLW1005E -Measure Trigger Pull Forces:**

Trigger pull (force required to manually operate the trigger)

**Method:**

- Trigger pull is to be performed to the SAAMI standard, with a horizontal pull at the center of the finger radius of the trigger with force measured parallel to the bore.
- Use the Dvorak trigger pull device to make these measurements. Note: if Dvorak trigger pull device is not setup for the model 1100 then the spring scale may be used to make these measurements.
- Three pulls are to be taken on each sample shotgun and the results averaged.
- A printout of the force/distance curve will be retained for record.
- The average force for the three trials must be between 3-1/2 lb. and 6-3/2 lb. for each shotgun. (Ref.: Run Process Record, Operation, 725, M/1100 Final Assembly, Step 12D.) The (3-trial average) minimum trigger pull force must not be below 3.0 lb. force for any sample - (This is the established S.A.A.M.I. minimum for trigger pull force for non-target type guns.) (Ref.: SAAMI Technical Manual Vol. VIII, Shotgun, Section 8-170.01, issued 9/21/78)

**Data Required:**

- Shotgun Serial numbers tested
- All three trigger pull force data points for each sample shotgun
- The average of the three measurements for each sample shotgun
- A force/distance curve from the Dvorak system (use the third trial) for each shotgun tested.
- TLW Number
- Testers' Names

**TLW1005F -Measure Bolt Opening Force / Bolt Release Closing Forces (for information only):**

The force required to open the bolt (using the operating handle) and close the bolt (i.e. the force required to push on the carrier release to close 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:****Bolt Opening Force (chamber empty):**

- Lock the firearm in a horizontal position, (i.e. shooting position) before taking the measurements.
- Locate the shotgun in vise and/or other fixture and securely lock in place, (it may be necessary to clamp the fixture and/or holding device to the bench if not already securely fixed in place.)
- Check to be sure the shotgun contains no live ammunition in either the chamber or in the magazine tube.
- With the chamber empty and the bolt closed, use the Chatillon gauge (0-50 lb. range) and locate the hook of the force gauge at the point on the operating handle at the approximate center. Pull the gauge straight back and parallel to the bore, measure the force required to open the bolt.
- Take three readings for each gun in the sample.

J.R. Smedeker

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Subject to Protective Order - Williams v. Remington