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

TLW 1005

- Record all three readings.

Bolt Close 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 rod of the force gauge at the point on the carrier release button at the approximate center. Push the gauge straight up and perpendicular to the bore, measure the force required to release the bolt so that it closes on the chamber.
- Take three readings for each gun in the sample.
- Record all three readings.

Bolt Opening & Bolt Closing Forces (dummy round in chamber)

- Repeat the above procedures, this time with a new, unused dummy round in the chamber.

Data Required:

- Shotgun serial numbers used for this test.
- Each of the three readings taken for each of the 4 states (i.e. opening force and closing force and with and without a dummy in the chamber) for each test sample.
- The average of each set of three measurements per each of the 4 states
- TLW Number
- Testers' Names

TLW1005G -Function Check of ISS:

To check the ISS System for proper function perform the three-step procedure that follows. If the system fails during any of the steps stop the test for that gun and continue with the next sample. To be considered a proper functioning ISS system each sample must pass all three of the steps outlined below. For proper operation of the ISS system refer to "Remington Instruction Book Supplement To Be Used with the following Instruction Book Model 1100. (Remington Form RD 7054, Orig. 1099)

Note: Start this procedure with the gun empty, the bolt locked open, the safety in the "On-Safe" position (red band not showing), and the ISS White pointer lined up with the Red dot.

Method:

1. Make sure the chamber and magazine tube are completely empty of live ammunition.
 - With the bolt in the locked open position and safety in the "On-Safe", using the ISS key, lock the ISS System in the secure mode (White pointer lined up with the White dot -See Pictures, Fig. 1) and then remove the key.
 - Push the carrier release to close and lock-up the bolt
 - Attempt to push the safety to the "Off-Safe" position. With the ISS system engaged you should not be able to push the safety to the "Off-Safe" position. If the safety can be pushed from the "On-Safe" position to the "Off-Safe" position then the test fails.
 - Attempt to pull the trigger. The hammer must not fall. If the hammer releases and falls then the test sample fails the test.
 - Record outcome of steps taken.
2. If the test sample passes the above test then perform the following procedure.

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