

**CONFIDENTIAL**

Remington Arms Company Inc.  
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- Repeat procedure, only this time open bolt with the firing pin in the fired or fully forward position.
- Repeat the procedure again only this time push the bolt closed.
- Note that it may be necessary to start the bolt closed by hand so the firing pin head is depressed sufficiently out of the notch and can start up the cam surface of the bolt as the firing pin is cocked.
- Repeat all the above procedures only this time with a new, unused dummy round in the chamber.

Data Required:

- Rifle serial number
- Each of the three readings taken for each of the 6 states for each test sample
  1. Bolt opening force with empty chamber, firing pin cocked.
  2. Bolt opening force with empty chamber, firing pin uncocked (fired)
  3. Bolt closing force with empty chamber.
  4. Bolt opening force with dummy round in chamber, firing pin cocked.
  5. Bolt opening force with dummy round in chamber, firing pin uncocked (fired)
  6. Bolt closing force with dummy round in chamber.
- The average of each set of three measurements per state

**TLW0300M - Measure Magazine Spring Force:**

The force produced by the compression of the Magazine Spring in the box with the follower attached will be measured. These measurements will be taken for information only. There is no specification currently defined for this characteristic.

Method:

- Use the Chatillion TCD200 Spring Testing Machine with the Chatillion Digital Force Gauge (0-10 lb. range). Use the disc probe (1/2" dia.) with the gauge.
- Place the magazine box, bottom side down, on the staging table.
- Zero force gauge with no load applied.

J.R.Snedeker

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