

CONFIDENTIAL

## Remington Arms Company Inc.

RESEARCH & DEVELOPMENT TECHNICAL CENTER  
315 WEST RING ROAD

- With the chamber empty, pull the trigger to release the firing pin. Using the Chatillion gauge, pull the gauge straight up and perpendicular to the bore, measure the force required to open the bolt.
- Lock the firearm in a horizontal position, using the trigger pull holding fixture, (i.e. shooting position) before taking the measurements.
- Take three readings for each gun in the sample.
- Record all readings.
- Repeat the procedure only this time rotate the bolt closed by pulling downward on the bolt handle.
- Note that it may be necessary to start the bolt closed by hand. A forward force may have to be applied on the bolt handle before bolt closing can be started so the firing pin head is depressed sufficiently to clear the notch and can then start up the cam surface of the bolt as the firing pin is cocked.
- Repeat the above procedure 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 4 states for each test sample
- The average of each set of three measurements per state

**TLW0683I - 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.) on the gauge.
- Place the magazine box, bottom side down, on the staging table.
- Zero force gauge with no load applied.
- Lower the gauge until it just touches the magazine follower, approximately in the middle location both side to side and front to rear.
- Zero force gauge again if necessary.
- Lower the gauge 0.200" and take the spring force measurements.

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05/24/06

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Revision # 1.1

Subject to Protective Order - Williams v. Remington

BARBER - 5.30.06R0001479

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