

Remington Arms Company, Inc.
Manufacturing Process Document

Document ID: Fin Assy 700 Pol
Product Line: Centerfire Rifle

Effective Date:
Origination Date:

General Instructions:

Use the Control Buttons above and below to access the various sections of this process. If your screen is not wide enough to display all the section data, use the arrows at the lower right to pan the desired data into view. Simply click on a tab or a button to move to that section of the document.

Process Routing Table:

Click on the button below containing the operation number you wish to view.

INSPECT COMPONENTS BEFORE HEADING
(SHOULDER SINGLE PASS)
(SHOULDER SINGLE PASS: Smaller than .25
Chamber to Length (BELTED - MAGNUMS)
(BELTED - MAGNUMS)
Make Chamber Cast (Not Done on 100% of Product)
Ream Ejector Hole
Assemble Riveted Extractor to Bolt - (MAGNUMS)
Assemble Rivetless Extractor to Bolt
Assemble to Bolt with Ejector Cross Pin
Strip Defective Barrel Assembly Complete
Strip Defective Bolt
Assemble Action
Assemble Action
Tag to Barrel (DM)
to Trigger Guard
Tag to Barrel
PROOF TEST
telescope with lens covers
Spacer to Stock
FUNCTION TEST(100%) AND TARGET(100%)
Number Using Dot Peen Marking Machine
INSPECT FOR LIVE AMMUNITION
CLEAN AND INSPECT
PACK RIFLE AND DELIVER TO WAREHOUSE
Proof Test
Proof Test with slave bolt
Proof Stamp, Prick Punch and Obstruction In
Test and Target 100%
Inspect For Live Ammunition

Final Inspection

Reset trigger pull within specs as needed - not done on

Inspect Heading and Sear Lift

Number Using Dot Peen Marking Machine

Send Rifle to Custom Shop for Accuracy Enhancement
To Warehouse

22-Nov-05
15-Feb-93

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(Enter Oper #) (Enter the Operation Name in this field)

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PROCESS CONTROL INSPECTION RECORD THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES			Revision Date: 22-Nov-05			Processed by:	
Part No:	Part Name: Fin Assy 700 Pol		Centerfire Rifle			Date: 8/14/2006	
Operation No: (Enter Oper #)		Operation: (Enter the Operation Name in this field)				Work Center:	
Prod. Qty:		Prod. Order #:		Operator		Setup inspected by & Date:	
Gage Description and Characteristic	Gage Number	Gage Frequency	1st Shift	2nd Shift	3rd Shift	Remarks, Causes, Action Taken, Etc.	
VISUAL	VISUAL	100%	INSPECT REJECT				

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INSPECT COMPONENTS BEFORE HEADING

- 1 Pick Bolt Assembly and Wash
 - a Inspect for Rust, Marks or Slight Scratches
Wire Brush if Rusty
 - b Check for magnaflux stamp on left lug and braze test mark on right
lug and rear of handle If either the magnaflux stamp or the braze
test mark is missing send back to the appropriate dept
 - c No brass except thin line at joints
 - d Bolt lugs; no burrs, recoil surfaces good finish, all edges
chamfered
 - e Extraction Cam-no bad burrs
 - f Gas hole present
 - g Remove burr from ejector hole at face of Bolt
 - h Check for rings or tears in bolt face
- 2 Pick Barrel Assembly
 - a Good finish & color, marks slight, no tears
 - b No sharp edges at Ejection Port or any exposed edges(Which might
cause finger injury)

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- c Gas hole present in Receiver
 - d Four plug screw holes present and tapped
 - e Plug screw holes in alignment
 - f Barrel muzzle visual central, outside of barrel not visually bowed
 - g Inspect bore and wipe out any and all debris as necessary
- 3 Check for correct marking

PROCESS CONTROL INSPECTION RECORD THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES			Revision Date: 22-Nov-05			Processed by:		
Part No:		Part Name: Fin Assy 700 Pol		Centerfire Rifle		Date: 5/14/2006		
Operation No: 395		Operation: INSPECT COMPONENTS BEFORE HEADING				Work Center:		
Prod. Qty:		Prod. Order #:		Operator		Setup inspected by & Date:		
Gage Description and Characteristic	Gage Number	Gage Frequency	1st Shift	2nd Shift	3rd Shift	Remarks, Causes, Action Taken, Etc.		
VISUAL	VISUAL	100%	INSPECT					
			REJECT					
			INSPECT					
			REJECT					
		Pieces Run:				Remington Arms Company, Inc. -- Ilion, New York		

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400 Fit and Head Bolt Assembly to Barrel Assembly (SHOULDER SINGLE PASS)

Operation Step Detail Operation: 400

NOTE: The operator shall continuously monitor the condition of the cutter that is being used by visual inspection. Visual inspection using magnification is to be done as felt appropriate by the operator or by special request of supervision. In addition, poured chamber casts shall be taken after a cutter change, an operator change and one per hundred on large runs. Small lot sizes are subject to supervision discretion.

Step Operation / Step Description

FIT & HEAD BOLT ASSY TO BBL ASSY, CHAMBER TO LENGTH
NON-MAGNUMS, .25 CALIBER AND LARGER

- a. Remove bolt assembly from barrel assembly.
- b. Clamp barrel assembly in fixture.
- c. Inspect reamer condition, no chipped cutting surfaces, no metal chips packed in flutes. Make sure reamer is correct for caliber being manufactured. Check spacer collars for size and tightness.
- d. Dip reamer into LB2000 Accu-Lube (note: thick blue liquid).
- e. Insert reamer shank through barrel so pilot is inside barrel bore. Move barrel and reamer together and engage reamer shank into quick release chuck. Make sure barrel chamber is positioned such that it is not being cut by reamer yet.

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- f. Insert bolt and close slowly as reamer cuts barrel material. Do NOT force bolt closed if reamer is cutting hard. Cutting action should be smooth. If cut is difficult, remove and inspect reamer for problems.
- g. After cutting is completed remove bolt.
- h. Remove reamer and rinse in tank with water and STEELGARD 1301-NL mixture. (note: mixture should have a milky consistency. If mixture looks too thin, add STEELGARD 1301-NL.) All metal chips must be rinsed from reamer. Inspect reamer condition.
- i. Unclamp barrel assembly and rinse in tank with water and STEELGARD 1301-NL mixture to remove any metal chips and to protect newly exposed metal surfaces. Inspect barrel chamber condition.
- j. Replace bolt assembly in barrel assembly and insert appropriate minimum shoulder plug. Bolt should close smoothly. Open bolt and remove minimum shoulder plug.
- k. Insert appropriate maximum shoulder plug. Bolt should not close with maximum shoulder plug in chamber. Open bolt and remove maximum shoulder plug.
- l. If all tests are acceptable close bolt and place barrel assembly on truck.

Operation Tool Detail

Operation: 400

Tool Number	Tooling Description
F-76039	Machine
D-46967	Fixture

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STD LB2000 ACCU-LUBE

STD STEELGARD 1301-NL

STD Caliber - 34-06

D-49577-S REAMER (replaces B-53297)

A-41281 COLLAR

B-90098-W SHANK

STD Caliber - 308 WIN

D-49577-T REAMER (replaces B-54687)

A-41281 COLLAR

B-90098-W SHANK

C-35413-A 300 RUM MIN Heading Plug

C-35413-B 300 RUM WMAX Heading Plug

C-49963-A 300 SAUM MIN Heading Plug

C-49963-B 300 SAUM WMAX Heading Plug

C-41556-A 308 WIN MIN Heading Plug

C-41556-B 308 WIN WMAX Heading Plug

PROCESS CONTROL INSPECTION RECORD			Revision Date:		Processed by:
THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES			22-Nov-05		
Part No:	Part Name: Fin Assy 700 Pol	Centerfire Rifle		Date: 8/14/2006	
Operation No: 400	Operation: Fit and Head Bolt Assembly to Barrel Assembly (SHOULDER SINGLE PASS)			Work Center:	
Prod. Qty:	Prod. Order #:	Operator		Setup inspected by & Date:	
Gage Description and Characteristic	Gage Number	Gage Frequency	1st Shift	2nd Shift	3rd Shift
Remarks, Causes, Action Taken, Etc.					

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			INSPECT			
VISUAL	VISUAL	100%	REJECT INSPECT			
308 W/IN MIN Heading Plug	C-41556-A	100%	REJECT INSPECT			
308 W/IN WMAX Heading Plug	C-41556-B	100%	REJECT INSPECT			
308 W/IN MIN Heading Plug	C-41556-A	100%	REJECT INSPECT			
308 W/IN WMAX Heading Plug	C-41556-B	100%	REJECT INSPECT			
308 W/IN MIN Heading Plug	C-41556-A	100%	REJECT INSPECT			
308 W/IN WMAX Heading Plug	C-41556-B	100%	REJECT INSPECT			
308 W/IN MIN Heading Plug	C-41556-A	100%	REJECT INSPECT			
308 W/IN WMAX Heading Plug	C-41556-B	100%	REJECT INSPECT			
308 W/IN MIN Heading Plug	C-41556-A	100%	REJECT INSPECT			
308 W/IN WMAX Heading Plug	C-41556-B	100%	REJECT INSPECT			
308 W/IN MIN Heading Plug	C-41556-A	100%	REJECT			

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308 W/IN WMAX Heading Plug	C-41556-B	100%	INSPECT			
			REJECT INSPECT			
308 W/IN MIN Heading Plug	C-41556-A	100%	REJECT INSPECT			
308 W/IN WMAX Heading Plug	C-41556-B	100%	REJECT INSPECT			
308 W/IN MIN Heading Plug	C-41556-A	100%	REJECT INSPECT			
308 W/IN WMAX Heading Plug	C-41556-B	100%	REJECT INSPECT			
308 W/IN MIN Heading Plug	C-41556-A	100%	REJECT INSPECT			
308 W/IN WMAX Heading Plug	C-41556-B	100%	REJECT INSPECT			
			REJECT INSPECT			
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405 Fit and Head Bolt Assembly to Barrel Assembly
(SHOULDER SINGLE PASS: Smaller than .25 caliber)

Operation Step Detail Operation: 405

NOTE: The operator shall continuously monitor the condition of the cutter that is being used by visual inspection. Visual inspection using magnification is to be done as felt appropriate by the operator or by special request of supervision. In addition, poured chamber casts shall be taken after a cutter change, an operator change and one per hundred on large runs. Small lot sizes are subject to supervision discretion.

Step Operation / Step Description

FIT & HEAD BOLT ASSY TO BBL ASSY, CHAMBER TO LENGTH
NON-MAGNUMS: SMALLER THAN .25 CALIBER

- a. Remove bolt assembly from barrel assembly.
- b. Clamp barrel assembly in fixture.
- c. Inspect reamer condition, no chipped cutting surfaces, no metal chips packed in flutes. Make sure reamer is correct for caliber being manufactured. Check spacer collars for size and tightness.
- d. Dip reamer into LB2000 Accu-Lube (note: thick blue liquid).
- e. Insert reamer shank through barrel so pilot is inside barrel bore. Move barrel and reamer together and engage reamer shank into quick release chuck. Make sure barrel chamber is positioned such that

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it is not being cut by reamer yet.

- f. Insert bolt and close slowly as reamer cuts barrel material. Do NOT force bolt closed if reamer is cutting hard. Cutting action should be smooth. If cut is difficult, remove and inspect reamer for problems. (NOTE: THESE CALIBERS NEED TO BE REAMED SLOWLY TO ENSURE REAMER IS NOT BROKEN FREE OF SHANK AND SHANK IS NOT FORCED TO TWIST AND BREAK !!!)
- g. After cutting is completed remove bolt.
- h. Remove reamer and rinse in tank with water and STEELGARD 1301-NL mixture. (note: mixture should have a milky consistency. If mixture looks too thin, add STEELGARD 1301-NL.) All metal chips must be rinsed from reamer. Inspect reamer condition.
- i. Unclamp barrel assembly and rinse in tank with water and STEELGARD 1301-NL mixture to remove any metal chips and to protect newly exposed metal surfaces. Inspect barrel chamber condition.
- j. Replace bolt assembly in barrel assembly and insert appropriate minimum shoulder plug. Bolt should close smoothly. Open bolt and remove minimum shoulder plug.
- k. Insert appropriate maximum shoulder plug. Bolt should not close with maximum shoulder plug in chamber. Open bolt and remove maximum shoulder plug.
- l. If all tests are acceptable close bolt and place barrel assembly on truck

Operation Tool Detail

Operation: 405

Tool Number

Tooling Description

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F-78039 Machine
D-46967 Fixture
STD ACCU-LUBE 2000
STD STEELCARD 1301-NL
STD Caliber - 223 REM
D-49577-K REAMER (replaces B-54136-S)
A-41139 COLLAR
B-90098-S SHANK
C-41155-A 223 REM MIN Heading Plug
C-41155-B 223 REM WMAX Heading Plug

PROCESS CONTROL INSPECTION RECORD THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES				Revision Date: 22-Nov-05		Processed by:	
Part No:		Part Name: Fin Assy 700 Pol		Centerfire Rifle		Date: 8/14/2005	
Operation No: 405		Operation: Fit and Head Bolt Assembly to Barrel Assembly (SHOULDER SINGLE PASS: Smaller than .25 caliber)				Work Center:	
Prod. Qty:		Prod. Order #:		Operator		Setup Inspected by & Date:	
Gage Description and Characteristic		Gage Number	Gage Frequency	1st Shift	2nd Shift	3rd Shift	Remarks, Causes, Action Taken, Etc.
VISUAL		VISUAL	100%	INSPECT			
				REJECT			
223 REM MIN Heading Plug		C-41155-A	100%	INSPECT			
				REJECT			

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223 REM WMAX Heading Plug	C-41155-B	100%	INSPECT			
			REJECT			
			INSPECT			
223 REM MIN Heading Plug	C-41155-A	100%	REJECT			
			INSPECT			
223 REM WMAX Heading Plug	C-41155-B	100%	REJECT			
			INSPECT			
223 REM MIN Heading Plug	C-41155-A	100%	REJECT			
			INSPECT			
223 REM WMAX Heading Plug	C-41155-B	100%	REJECT			
			INSPECT			
223 REM MIN Heading Plug	C-41155-A	100%	REJECT			
			INSPECT			
223 REM WMAX Heading Plug	C-41155-B	100%	REJECT			
			INSPECT			
			REJECT			
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415 Fit and Head Bolt Assembly to Barrel Assy and Chamber to Length (BELTED - MAGNUMS)

Operation Step Detail Operation: 415

NOTE: The operator shall continuously monitor the condition of the cutter that is being used by visual inspection. Visual inspection using magnification is to be done as felt appropriate by the operator or by special request of supervision. In addition, poured chamber casts shall be taken after a cutter change, an operator change and one per hundred on large runs. Small lot sizes are subject to supervision discretion.

Step Operation / Step Description

FIT & HEAD BOLT ASSY TO BBL ASSY, CHAMBER TO LENGTH
BELTED MAGNUMS

- a. Remove bolt assembly from barrel assembly.
- b. Clamp barrel assembly in fixture.
- c. Inspect shoulder reamer condition, no chipped cutting surfaces, no metal chips packed in flutes. Make sure reamer is correct for caliber being manufactured. Check spacer collars for size and tightness.
- d. Dip shoulder reamer into LB2000 Accu-Lube (note: thick blue liquid).
- e. Insert shoulder reamer shank through barrel so pilot is inside barrel bore. Move barrel and reamer together and engage reamer shank into quick release chuck. Make sure barrel chamber is positioned

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- such that it is not being cut by reamer yet.
- f. Insert bolt and close slowly as reamer cuts barrel material. Do NOT force bolt closed if reamer is cutting hard. Cutting action should be smooth. If cut is difficult, remove and inspect reamer for problems.
 - g. After cutting is completed remove bolt.
 - h. Remove reamer and rinse in tank with water and STEELGARD 1301-NL mixture. (note: mixture should have a milky consistency. If mixture looks too thin, add STEELGARD 1301-NL.) All metal chips must be rinsed from reamer. Inspect reamer condition.
 - i. Unclamp barrel assembly and rinse in tank with water and STEELGARD 1301-NL mixture to remove any metal chips and to protect newly exposed metal surfaces. Inspect barrel chamber condition.
 - j. Replace bolt assembly in barrel assembly and insert appropriate minimum shoulder plug. Bolt should close smoothly. Open bolt and remove minimum shoulder plug.
 - k. Insert appropriate maximum shoulder plug. Bolt should not close with maximum shoulder plug in chamber. Open bolt and remove maximum shoulder plug.
 - l. Clamp barrel assembly in fixture.
 - m. Inspect belt reamer condition, no chipped cutting surfaces, no metal chips packed in flutes. Make sure reamer is correct for caliber being manufactured.
 - n. Dip belt reamer into LB2000 Accu-Lube (note: thick blue liquid).
 - o. Insert belt reamer shank through barrel so pilot is inside barrel

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- here. Move barrel and reamer together and engage reamer shank into quick release chuck. Make sure barrel chamber is positioned such that it is not being cut by reamer yet.
- p. Insert bolt and close slowly as reamer cuts barrel material. Do NOT force bolt closed if reamer is cutting hard. Cutting action should be smooth. If cut is difficult, remove and inspect reamer for problems.
 - q. After cutting is completed remove bolt.
 - r. Remove reamer and rinse in tank with water and STEELGARD 1301-NL mixture. (note: mixture should have a milky consistency. If mixture looks too thin, add STEELGARD 1301-NL.) All metal chips must be rinsed from reamer. Inspect reamer condition.
 - s. Unclamp barrel assembly and rinse in tank with water and STEELGARD 1301-NL mixture to remove any metal chips and to protect newly exposed metal surfaces. Inspect barrel belt condition.
 - t. Replace bolt assembly in barrel assembly and insert appropriate minimum belt plug. Bolt should close smoothly. Open bolt and remove minimum belt plug.
 - u. Insert appropriate maximum belt plug. Bolt should not close with maximum belt plug in chamber. Open bolt and remove maximum belt plug.
 - v. If all tests are acceptable close bolt and place barrel assembly on truck

Operation Tool Detail

Operation: 415

Tool Number

Tooling Description

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F-78039 Machine - Special Chambering Mach.

D-46967 ~~FIXTURE~~

STD ACCU-LUBE 2000

STD STEELCARD 1302-NL

STD 264 Win Mag.

B-83838 REAMER - SHOULDER

A-41281 COLLAR

B-90098-U SHANK

B-53328-T REAMER - FACE

B-53328-V BELT CUTTER

B-53328-R CHAMBER GUIDE BUSHING

STD 7MM Mag.

B-84815 REAMER - SHOULDER

A-41281 COLLAR

B-90098-V SHANK

B-53328-P REAMER - FACE

B-53328-V BELT CUTTER

B-53328-R CHAMBER GUIDE BUSHING

TD 00 Win Mag.

B-86573 REAMER - SHOULDER

A-41281 COLLAR

B-90098-W SHANK

B-53328-W REAMER - FACE

B-53328-V BELT CUTTER

B-53328-R CHAMBER GUIDE BUSHING

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TD 38 Win Mag.
C-47271 REAMER - SHOULDER
A-41281 COLLAR
B-90098-N SHANK
B-53328-L REAMER - FACE
B-53328-V BELT CUTTER
B-53328-J CHAMBER GUIDE BUSHING

STD 8MM REM Mag.

B-43096 REAMER - SHOULDER
A-41281 COLLAR
B-90098-N SHANK
B-53328-L REAMER - FACE
B-53328-V BELT CUTTER
B-53328-R CHAMBER GUIDE BUSHING

STD 416 REM Mag.

B-43096 REAMER - SHOULDER
A-41281 COLLAR
B-90098-N SHANK
B-53328-L REAMER - FACE
B-53328-V BELT CUTTER
B-53328-R CHAMBER GUIDE BUSHING

C-41561-A 7MM Mag MIN Heading Plug
C-41561-B 7MM Mag WMAX Heading Plug
C-83853-A 7MM Mag BELT - MIN Heading Plug
C-83853-B 7MM Mag BELT - WMAX Heading Plug
C-41546-A 300 Win MIN Heading Plug
C-41546-B 300 Win WMAX Heading Plug
C-83853-A 300 Win BELT - MIN Heading Plug
C-83853-B 300 Win BELT - WMAX Heading Plug

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PROCESS CONTROL INSPECTION RECORD THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES			Revision Date: 22-Nov-05			Processed by:
Part No:	Part Name:	Centerfire Rifle			Date:	8/14/2006
Operation No:	Operation: Fit and Head Bolt Assembly to Barrel Assy and Chamber to Length (BELTED - MAGNUMS)				Work Center:	
Prod. Qty:	Prod. Order #	Operator			Setup Inspected by & Date:	
Gage Description and Characteristic	Gage Number	Gage Frequency	1st Shift	2nd Shift	3rd Shift	Remarks, Causes, Action Taken, Etc.
VISUAL	VISUAL	100%	INSPECT			
300 Win BELT - MIN Heading Plug	C-83853-A	100%	REJECT INSPECT			
300 Win BELT - WMAX Heading Plug	C-83853-B	100%	REJECT INSPECT			
300 Win MIN Heading Plug	C-41546-A	100%	REJECT INSPECT			
300 Win WMAX Heading Plug	C-41546-B	100%	REJECT INSPECT			
300 Win BELT - MIN Heading Plug	C-83853-A	100%	REJECT INSPECT			
300 Win BELT - WMAX Heading Plug	C-83853-B	100%	REJECT INSPECT			
300 Win MIN Heading Plug	C-41546-A	100%	REJECT			

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			INSPECT			
300 Win WMAX Heading Plug	C-41546-B	100%	REJECT INSPECT			
7MM Mag BELT - MIN Heading Plug	C-83853-A	100%	REJECT INSPECT			
7MM Mag BELT - WMAX Heading Plug	C-83853-B	100%	REJECT INSPECT			
7MM Mag MIN Heading Plug	C-41561-A	100%	REJECT INSPECT			
7MM Mag WMAX Heading Plug	C-41561-B	100%	REJECT INSPECT			
300 SAUM MIN Heading Plug	C-49963-A	100%	REJECT INSPECT			
300 SAUM WMAX Heading Plug	C-49963-B	100%	REJECT INSPECT			
			REJECT			
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420 Ream Chamber to Deburr
(BELTED - MAGNUMS)

Operation Step Detail Operation: 420

Step Operation / Step Description

Ream Chamber to Deburr - (BELTED - MAGNUMS)

PROCEDURE:

1. Pick Barrel Assembly.
2. Position and clamp.
3. Pick reamer, dip in acculube synthetic oil and insert in chamber.
4. Turn handle while forcing(approx. 20-30 lbs) reamer until it bottoms to clear chamber.
5. Remove reamer and wipe clean and place to rest.
6. Unclamp, pick Barrel Assembly, wash breech end in STEELGARD and drain.
7. Return Barrel Assembly to truck.

Operation Tool Detail Operation: 420

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Tool Number: C-49758 Tooling Description: Furnish Tool Shank Std.

PROCESS CONTROL INSPECTION RECORD				Revision Date: 22-Nov-05		Processed by:	
THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES							
Part No:		Part Name: Fin Assy 700 Pol		Centerfire Rifle		Date: 3/14/2006	
Operation No: 420		Operation: Ream Chamber to Deburr				Work Center:	
Prod. Qty:		Prod. Order #:		Operator		Setup inspected by & Date:	
Gage Description and Characteristic		Gage Number	Gage Frequency	1st Shift	2nd Shift	3rd Shift	Remarks: Causes, Action Taken, Etc.
VISUAL		VISUAL	100%	INSPECT			
				REJECT INSPECT			
				REJECT INSPECT			
				REJECT INSPECT			
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425 Make Chamber Cast (Not Done on 100% of Product)

Operation Step Detail Operation: 425

NOTE: The operator shall continuously monitor the condition of the cutter that is being used by visual inspection. Visual inspection using magnification is to be done as felt appropriate by the operator or by special request of supervision. In addition, poured chamber casts shall be taken after a cutter change, an operator change and one per hundred on large runs. Small lot sizes are subject to supervision discretion.

Step Operation / Step Description

Make chamber cast. (Not done on 100% of product)

1. Plug in heater.
2. Wipe chamber.
3. Drop correct plug into chamber.
4. Position and clamp in vise, by Barrel Bracket.
5. Pour cast material to fill to back of chamber.
6. Remove cast & examine for rings and tears.

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430 Ream Ejector Hole

Operation Step Detail Operation: 430

Step Operation / Step Description

Ream Ejector Hole

Remove Burr thrown into Ejector Hole by Flat Scrape

1. Grind Flat on Point of Drill with Bench Lathe
2. Adjust Drill in Chuck to Bottom in Master Bait for Depth

Operation Tool Detail Operation: 430

Tool Number Tooling Description

STD #28 DRILL

PROCESS CONTROL INSPECTION RECORD		Revision Date:		22-Nov-05		Processed by:	
THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES							
Part No:	Part Name: Fin Assy 700 Pol	Centerfire Rifle		Date:		8/14/2006	
Operation No: 430	Operation: Ream Ejector Hole			Work Center:			
Prod. Qty:	Prod. Order #:	Operator		Setup inspected by & Date:			

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432 Assemble Riveted Extractor to Bolt - (MAGNUMS)

Operation Step Detail Operation: 432

Step Operation / Step Description

Assemble Riveted Extractor to Bolt - (MAGNUMS)

PROCEDURE:

- 1 Extractor Must Be Shaped to Bolt Shroud by Adjusting Both Ends of (If Necessary)
 - Claw of Extractor Must Be Checked on Tension Plug for "Go" and "No Go"
 - a. Assemble Extractor to Bolt with Extractor Rivet
 - Blend Extractor with Shroud
 - b. Extractor Must Clear Min Tension Plug and Have Tension on Max Tension Plug
 - c. File to Remove Excess Rivet and Rechamfer Bolt Rim at Rivet
- 2 Max Shell Head Plug Must Compress Extractor and Bottom on Face of Bolt
- 3 Blend Extractor to Bolt Shroud
- 4 Recolor area of Bolt where color was removed during the filing of the Extractor Rivet and rechamfering of the Bolt rim.
 - a. Swab Birchwood-Casey Super Blue directly onto the brightened metal left by filing. Work into surface and allow the chemical etch time to work (approx 30 seconds.)
 - b. Lightly wipe off excess Super Blue.

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c. Apply a light coating of oil to prevent oxidation of the colored area.

SUGGESTION: If Bolts are processed in stages, Super Blue may be applied immediately after filing is complete. Process 10 or more Bolts through the filing and recoloring stage at a time, lining them up on the assembly bench. This will allow ample time for the color to take hold. After coloring, the entire row of Bolts may be wiped and oiled together.

Operation Tool Detail

Operation: 432

Tool Number	Tooling Description
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D-84993	Fixture
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C-71477-W	Punch
-----------	-------

STD	Hydraulic Press - Dennison
-----	----------------------------

Pressure Approx.- 2200 lbs.

NOTE: Too Much Pressure Breaks Extractors
Too Little makes a Poor Swage

TS-1764	.027 Deflection
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STD	Dental Grinder
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MAX SHELL

B-84831-A	Small Rifle
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B-84831-B	Large Rifle
-----------	-------------

B-84831-C	Belted Magnums
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TENSION

B-87034-A Small Rifle
B-87034-C Large Rifle
B-87034-D Belted Magnums

PROCESS CONTROL INSPECTION RECORD			Revision Date			Processed by:
THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES			22-Nov-05			
Part No:	Part Name: Fin Assy 700 Pol		Centerfire Rifle			Date: 8/14/2006
Operation No: 432	Operation: Assemble Riveted Extractor to Bolt - (MAGNUMS)					Work Center:
Prod. Qty:	Prod. Order #:	Operator			Setup Inspected by & Date:	
Gage Description and Characteristic	Gage Number	Gage Frequency	1st Shift	2nd Shift	3rd Shift	Remarks, Causes, Action Taken, Etc.
VISUAL	VISUAL	100%	INSPECT			
			REJECT			
Small Rifle	B-84831-A	100%	INSPECT			
			REJECT			
Large Rifle	B-84831-B	100%	INSPECT			
			REJECT			
6.8MM REM SPC	B-84831-E	100%	INSPECT			
			REJECT			
Small Rifle	B-87034-A	100%	INSPECT			
			REJECT			
Large Rifle	B-87034-C	100%	INSPECT			
			REJECT			

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Beefed Magnums	8,80034.0	100%	INSPECT REJECT INSPECT			
			REJECT INSPECT			
			REJECT INSPECT			
			REJECT INSPECT			
			REJECT INSPECT			
			REJECT INSPECT			
			REJECT			
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Run:	Remington Arms Company, Inc. - Ilion, New York			
	REJECT	INSPECT	REJECT	INSPECT
	REJECT	INSPECT	REJECT	INSPECT
	REJECT	INSPECT	REJECT	INSPECT

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435 Assemble Rivetless Extractor to Bolt

Operation Step Detail Operation: 435

Step Operation / Step Description

Assemble Rivetless Extractor to Bolt

- 1 Extractor Must Be Shaped to Bolt Shroud by Adjusting Both Ends of (If Necessary)
 - Claw of Extractor Must Be Checked on Tension Plug for "Go" and "No Go"
 - a. Extractor Must Clear Min Tension Plug and Have Tension on Max Tension Plug
- 2 Max Shell Head Plug Must Compress Extractor and Bottom on Face of Bolt
- 3 Blend Extractor to Bolt Shroud
 - a. Check Extractor with Pick
 - Must Not Be Deformed or Loose

Operation Tool Detail Operation: 435

Tool Number Tooling Description

B-87034-C Min Tension Plug - .445
B-84831-B Max Tension Plug

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B-84831-E 6.8MM REM SPC
B-87034-F 6.8MM REM SPC

PROCESS CONTROL INSPECTION RECORD				Revision Date:		Processed by:
THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES				22-Nov-05		
Part No:	Part Name:	Fin Assy 700 Bol		Centerfire Rifle		Date: 8/14/2006
Operation No: 435	Operation: Assemble Rivetless Extractor to Bolt					Work Center:
Prod. Qty:	Prod. Order #:	Operator			Setup Inspected by & Date:	
Gage Description and Characteristic	Gage Number	Gage Frequency	1st Shift	2nd Shift	3rd Shift	Remarks, Causes, Action Taken, Etc.
VISUAL	VISUAL	100%	INSPECT			
Min Tension Plug - .445	B-87034-C	100%	REJECT INSPECT			
Max Tension Plug	B-84831-B	100%	REJECT INSPECT			
			REJECT INSPECT			
			REJECT INSPECT			
			REJECT INSPECT			
			REJECT INSPECT			
			REJECT INSPECT			
			REJECT INSPECT			

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440 Assemble Ejector to Ejector Spring and then
Assemble to Bolt with Ejector Cross Pin

Operation Step Detail

Operation: 440

Step

Operation / Step Description

Assemble Ejector to Ejector Spring and then Assemble to Bolt with Ejector
Cross Pin

PROCEDURE:

- 1 Position Ejector with Ejector Spring in Bolt
- 2 Load Bolt Assembly into Fixture and Clamp
- 3 Position Ejector Pin in Hole - Drive in Below Outside Diameter of Body
 - a. Pin Must Be a Drive Fit
 - b. Try for Freedom - Ejector Must Not Stick

Operation Tool Detail

Operation: 440

Tool Number

Tooling Description

C-51730

Fixture

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C-40296 Fixture (L.H.)
A-48261 Pin Punch
B-54503 Drive Punch (Drive Out Tight Ejector Pin)
C-53663 Fixture

PROCESS CONTROL INSPECTION RECORD						Revision: Date	Processed by:
THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES						22-Nov-05	
Part No:	Part Name: Fin Assy 700 Pol		Centerfire Rifle			Date:	8/14/2006
Operation No: 440	Operation: Assemble Ejector to Ejector Spring and then					Work Center:	
Prod. Qty:	Prod. Order #:	Operator			Setup Inspected by & Date:		
Gage Description and Characteristic	Gage Number	Gage Frequency	1st Shift	2nd Shift	3rd Shift	Remarks, Causes, Action Taken, Etc.	
VISUAL	VISUAL	100%	INSPECT				
			REJECT INSPECT				
			REJECT INSPECT				
			REJECT INSPECT				
			REJECT INSPECT				
			REJECT INSPECT				

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460R Strip Defective Barrel Assembly Complete

PROCESS CONTROL INSPECTION RECORD			Revision Date: 22-Nov-05			Processed by:
THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES						
Part No:	Part Name: Fin Assy 700 Pol		Centerfire Rifle		Date: 8/14/2006	
Operation No: 460R	Operation: Strip Defective Barrel Assembly Complete					Work Center:
Prod. Qty:	Prod. Order #:	Operator:			Setup Inspected by & Date:	
Gage Description and Characteristic	Gage Number	Gage Frequency	1st Shift	2nd Shift	3rd Shift	Remarks, Causes, Action Taken, Etc.
VISUAL	VISUAL	100%	INSPECT			
			REJECT INSPECT			
			REJECT INSPECT			
			REJECT INSPECT			
			REJECT INSPECT			
			REJECT INSPECT			
			REJECT INSPECT			
			REJECT			

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465R Strip Defective Bolt

PROCESS CONTROL INSPECTION RECORD			Revision Date: 22-Nov-05			Processed by:
THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES						
Part No:	Part Name: Fin Assy 700 Pol		Centerfire Rifle		Date: 8/14/2006	
Operation No: 465R	Operation: Strip Defective Bolt				Work Center:	
Prod. Qty:	Prod. Order #:		Operator:		Setup Inspected by & Date:	
Gage Description and Characteristic	Gage Number	Gage Frequency	1st Shift	2nd Shift	3rd Shift	Remarks, Causes, Action Taken, Etc.
VISUAL	VISUAL	100%	INSPECT			
			REJECT			
			INSPECT			
			REJECT			
			INSPECT			
			REJECT			
			INSPECT			
			REJECT			
			INSPECT			
			REJECT			
			INSPECT			
			REJECT			

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580 Assemble Action

Operation Step Detail Operation: 580

Step Operation / Step Description

Assemble Action

PROCEDURE:

- 1 Select Action from Truck
 - Inspect for:
 - a. Magna-Flux Stamp
 - b. Serial # of Bolt Matches Receiver
 - c. Marks
 - d. Uniform Color
 - e. Place in Vise on Bench
- 2 Select (4) Plug Screws and Install in Scope Mounting Holes located in Receiver Using Ratchet Screwdriver
- 3 Select Firing Pin Assembly
 - Inspect for:
 - a. Point Not Marred
 - b. Bolt Plug Color
 - c. No Rust or Miscuts
- 4 Lubricate Entire Threads of Bolt Plug, Rear of Bolt Lugs and Cocking Cam on Bolt Body with Thin Film of Molykote GN Paste or Powder
 - APPLY WITH LUBE BRUSH

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- 5 Assemble Firing Pin Assembly to Bolt Body Assembly Using Bolt Assembly Tool
- 6 Check Firing Pin Protrusion
- 7 Insert Bolt into Action and Lock Down
 - Operate Bolt (3) Times to Verify Proper Fit
 - Remove Bolt and Place on Bench
- 8 Select Trigger Assembly
- 9 Insert Trigger Assembly in Receiver
 - Must Fit Freely
 - File Slot if Necessary
- 10 Select Sear Pin and Start in Sear Pin Hole
 - Drive in Flush with Inside of Bolt Stop Cut
- 11 Select Bolt Stop
 - Position in Receiver
 - Must Fit Freely
 - File Slot if Necessary
- 12 Select Bolt Stop Spring
 - Position in Receiver
- 13 Position Trigger Assembly
 - Select Bolt Stop Pin
 - Assemble to Receiver
- 14 Stake Sear Pin and Bolt Stop Pin
- 15 Hold Trigger & Press Down on Sear
 - Sear Must NOT Bind

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- 16 Try Safety
- Must be clearance between Sear and Trigger Connector with Safety in "ON" Position
 - a. Open Bolt
 - b. Place Safety in "S" or "DN" Position
 - c. Close Bolt and Lock Down
 - Must Lock Down Without Catching on Safety
 - Firing Pin Must NOT Follow Down
 - d. Open Bolt
 - Bolt Must Open with Safety in "ON" Position
- 17 Check Vertical Sear Engagement
- Minimum .015" Visual
 - a. Check for "Jar Off"
 - 1. Apply Steady Pressure on End of Firing Pin Head with Rifle Cocked and Safety in the "F" or "OFF" Position
 - Rifle Must NOT Fire
 - b. Open and Close Bolt Forcibly (3) Times
 - Remove Bolt Assembly
 - c. Place Safety in the "F" or "OFF" Position
 - 1. Insert Solid Bolt (Tool #C-47741)
 - 2. Apply Steady Pressure of 6-8 lbs at Rear of Bolt (Tool)
 - Vertical Sear Engagement Must NOT Change
 - Firing Pin Head Must NOT Move Forward
 - Bolt (Tool) Must Remain Engaged with Sear
- 18 Verify Firing Pin Head Will Release from the Cocking Notch
- a. Squeezing and Holding Trigger while Closing and Locking Down Bolt Slowly
 - Firing Pin MUST Follow Down
 - Slight Trigger Play May Be Detectable After Firing
- 19 Inspect Safety Function:

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- a. Place Safety in "S" or "ON" Position
 - 1. Apply Heavy Pressure to Trigger
 - Rifle Must NOT Fire
 - 2. Release Trigger
 - Trigger MUST Retract
- b. Place Safety Halfway Between "S" and "F"
 - 1. Pull Trigger
 - Rifle Must NOT Fire
- c. Place Safety in "F" or "OFF" Position
 - Firing Pin Must NOT Follow Down

Perform Checks a. thru c. (3) Times

- 20 Weigh Trigger Pull (4.75 to 5.75 lbs.) parallel with action.
- Must be Short & Crisp
 - No Creep Over or Overdraw

Try (3) Times

NOTE: Perform Monthly check on Trigger Pull scale to verify accuracy.
Follow procedure below using at least two different weights.

- a. Slowly lift dead weight off bench using trigger pull scale.
- b. Slowly return weight to bench and read scale.
 - Measurement must be within 1/8 lb of actual dead weight.
- c. If scale is not within above specification for any of the measured dead weights;
 - send scale to Gage Inspection for Re-Calibration.

- 21 Place Safety in "S" or "ON" Position

- 22 Close the Action and Lock Bolt Down

Operation Tool Detail

Operation: 580

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Tool Number	Tooling Description
STD	Ratchet Screwdriver
A-88003	Taper Reamer for Braze in Firing Pin Hole
7237T1	Lube Brush (McMaster-Carr Pin Ferroule, Natural Bristle Type Brush 5-3/4 O.A.L. 3/8" X 3/4" or Equivalent)
301467	Molykote GN Paste or Powder Lubricant
B-43447	Brass Wiping Rod
305787	VC-NYLTEX VINYL CAPS
STD	Ball Handle Ratchet Screwdriver (McMaster Carr no. 6962A14 or Equivalent)
D-48553	Bolt Assembly tool
5/32" pt.	Center Punch (Mc-Master Carr no.3417A1 or Equivalent)
STD	Hammer 8 oz. Set (Mc-Master Carr no. 5860A5 or Equivalent)

GAGES

B-70697	Trigger Pull Scales
STD	.006 Feeler Gage or Suitable Shim
C-47741	Sear Engagement Gage - Solid Bolt
D-44581	Sear Lift Dial Gage (.006 - .018)
B-52089	Firing Pin Protrusion Gage
B-80652	Pins Tight Tester

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STD
B-TS-7300Trigger Guard Clearence Shim Tool (.030")
Dummy Cartridge Rounds of Proper Caliber Being Built
Dest. E Scuff Template

PROCESS CONTROL INSPECTION RECORD				Revision Date:		Processed by:
THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES				22-Nov-05		
Part No:	Part Name: Fin Assy 700 Pol		Centerfire Rifle			Date: 8/14/2006
Operation No: 580	Operation: Assemble Action				Work Center:	
Prod. Qty:	Prod. Order #:	Operator			Setup Inspected by & Date:	
Gage Description and Characteristic	Gage Number	Gage Frequency	1st Shift	2nd Shift	3rd Shift	Remarks, Causes, Action Taken, Etc.
VISUAL	VISUAL	100%	INSPECT			
			REJECT			
Trigger Pull Scales	B-70697	100%	INSPECT			
			REJECT			
.006 Feeler Gage or Suitable Shim	STD	100%	INSPECT			
			REJECT			
Sear Engagement Gage - Solid Bolt	C-47741	100%	INSPECT			
			REJECT			
Sear Lift Dial Gage (.006 - .018)	D-44581	100%	INSPECT			
			REJECT			
Firing Pin Protrusion Gage	B-52089	100%	INSPECT			
			REJECT			
Pins Tight Tester	B-80652	100%	INSPECT			
			REJECT			

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Trigger Guard Clearance (Shim Tool (0.30"))	A-43977	100%	INSPECT REJECT INSPECT		
During Cartridge Rounds of Proper Caliber Being Built	STD	100%	REJECT INSPECT		
Dent & Scuff Template	B-TS-7300	100%	REJECT INSPECT		
			REJECT INSPECT		
			REJECT		
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581 Assemble Action

Operation Step Detail Operation: 581

Step Operation / Step Description

Assemble Action

PROCEDURE:

1. Pick Action from Truck - Inspect for: Magna-Flux Stamp, Serial # of Bolt Matches Receiver, Marks, and Uniform Color
2. Pick Firing Pin Assembly - Inspect for: Point Not Marred, Bolt Plug Color, No Rust or Miscuts
3. Lubricate Entire Threads of Bolt Plug, Rear of Bolt Lugs and Cocking Cam on Bolt Body with Thin Film of Molykote GN Paste or Powder - APPLY WITH LUBE BRUSH
4. Assemble Firing Pin Assembly to Bolt Body Assembly Using Bolt Assembly Tool
5. Check Firing Pin Protrusion
6. Insert Bolt into Action and Lock Down, Operate Bolt (3) Times to Verify Proper Fit - Remove Bolt and Place on Bench
7. Select Trigger Assembly

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8. Insert Trigger Assembly in Receiver (Must Fit Freely)
(File Slot if Necessary)
9. Select Sear Pin and Start in Sear Pin Hole (Drive in Flush with Inside of Bolt Stop Cut)
10. Select Bolt Stop - Position in Receiver (Must Fit Freely)
(File Slot if Necessary)
11. Select Bolt Stop Spring - Position in Receiver
12. Position Trigger Assembly - Select Bolt Stop Pin and Assemble to Receiver
13. Stake Sear Pin and Bolt Stop Pin
14. Hold Trigger & Press Down on Sear - Sear Must NOT Bind
15. Try Safety
 - a. Must be clearance between Sear and Trigger Connector with Safety in "ON" Position
 - b. With Bolt Open, Place Safety in "S" or "ON" Position - Close Bolt and Lock Down
 - Must Lock Down Without Catching on Safety
 - Firing Pin Must NOT Follow Down
 - Bolt Must Open with Safety in "ON" Position
16. Check Vertical Sear Engagement - Minimum .015" Visual
 - a. Check for "Jar Off"
 - Applying Steady Pressure on End of Firing Pin Head with Rifle Cocked and Safety in the "F" or "OFF" Position
 - Rifle Must NOT Fire
 - b. Open and Close Bolt Forcibly (3) Times - Remove Bolt Assembly
 - c. Place Safety in the "F" or "OFF" Position, Insert Solid Bolt
(Tool #C-47741)

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- Apply Steady Pressure of 6-8 lbs at Rear of Bolt (Tool)
 - Vertical Sear Engagement Must NOT Change
 - Firing Pin Head Must NOT Move Forward and the Bolt (Tool) Must Remain Engaged with Sear
17. Verify Firing Pin Head Will Release from the Cocking Notch by Squeezing and Holding Trigger while Closing and Locking Down Bolt Slowly
- Firing Pin MUST Follow Down
 - Slight Trigger Play may be detectable after firing
18. Inspect Safety Function:
- a. Place Safety in "S" or "ON" Position
 - Apply Heavy Pressure to Trigger
 - Rifle Must NOT Fire
 - Release Trigger
 - Trigger MUST Retract
 - b. Place Safety Halfway Between "S" and "F"
 - Pull Trigger
 - Rifle Must NOT Fire
 - c. Place Safety in "F" or "OFF" Position
 - Firing Pin Must NOT Follow Down
- Perform Checks a. thru c. (3) Times.
19. Weigh Trigger Pull (4.75 to 5.75 lbs.) parallel with action
- a. Must be Short & Crisp, No Creep Over or Overdraw
- Try (3) Times
- NOTE:** Perform Monthly check on Trigger Pull scale to verify accuracy. Follow procedure below using at least two different weights.
- a. Slowly lift dead weight off bench using trigger pull scale.
 - b. Slowly return weight to bench and read scale.
 - Measurement must be within 1/8 lb of actual dead weight.
 - c. If scale is not within above specification for any of the measured dead weights;
 - send scale to Gage Inspection for Re-Calibration.

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20. Place Safety in "S" or "ON" Position

21. Close the Action and Lock Bolt Down

Operation Tool Detail

Operation: 581

Tool Number	Tooling Description
A-88003	Taper Reamer for Braze in Firing Pin Hole
7237T1	Lube Brush - McMaster-Carr (or Equivalent) Tin Ferroule, Natural Bristle Type Brush - 3-3/4 O.A.L. 3/8W x 3/4L
43447	Brass Wiping Rod

Gages:

B-70697	Trigger Pull Scales
STD	.006 Feeler Gage or Suitable Shim
D-48553	Bolt Disassembly Tool
C-47741	Sear Engagement Gage - Solid Bolt
B-52089	Firing Pin Protrusion Gage
B-80652	Pins Tight Tester

PROCESS CONTROL INSPECTION RECORD		Revision Date:	22-Nov-05	Processed by:
THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES				
Part No:	Part Name: Fin Assy 700 Pol	Centerfire Rifle	Date:	8/14/2006

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Operation No: 581		Operation: Assemble Action				Work Center:
Prod. Qty:	Prod. Order #	Operator			Setup Inspected by & Date:	
Gage Description and Characteristic	Gage Number	Gage Frequency	1st Shift	2nd Shift	3rd Shift	Remarks, Causes, Action Taken, Etc.
VISUAL	VISUAL	100%	REJECT INSPECT			
Trigger Pull Scales	B-70697	100%	REJECT INSPECT			
.006 Feeler Gage or Suitable Shim	STD	100%	REJECT INSPECT			
Bolt Disassembly Tool	D-48553	100%	REJECT INSPECT			
Sear Engagement Gage - Solid Bolt	C-47741	100%	REJECT INSPECT			
Firing Pin Protrusion Gage	B-52089	100%	REJECT INSPECT			
Pins Tight Tester	B-80652	100%	REJECT INSPECT			
			REJECT INSPECT			
			REJECT INSPECT			
			REJECT INSPECT			

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				INSPECT					
				REJECT					
				INSPECT					
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583 Assemble Stock to Action and Attach Hang
Tag to Trigger Guard

Operation Step Detail Operation: 583

Step Operation / Step Description

Assemble Stock to Action

PROCEDURE:

- 1 Select Correct Stock
 - a. Inspect for:
 - Good Finish
 - Marks Slight
 - No Checks
 - Grip Outline Reasonably Uniform and Square
 - Butt Plate
 1. Black Rear Face
 2. No Burrs
 3. .005 Max. Opening at Face
 4. Tight (Finger Test)
 5. Screws Not Project Badly
 6. Burrs at Screw Holes Slight
 7. .02 Max. Mismatch of Butt Plate and Stock Either Way
 - Recoil Pad
 1. Good Color
 2. Rear Face
 3. No Burrs
 4. .005 Max. Opening at Face

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5. Tight (Finger Test)
6. Burrs at Screw Holes Slight
7. .02 Max. Mismatch of Recoil Pad and Stock Either Way
- b. Inspect and Reject for Visual Damage
 - Procedure to Reject Stock if Below Standards
 1. Hand Print Defect Code Number on Color Dot
 2. Affix Adhesive Color Dot to Stock Beside the Defect Being Noted
2. Position Stock on Action
3. Select Trigger Guard Assy.
 - a. Inspect for:
 - No Sharp Edges
 - Color
 - Marks
 - Pits
 - Position in Stock
4. Select Front, and Rear Trigger Guard Screws
 - a. Inspect for:
 - Color
 - Allen Head
 - Threads
 - Position in Holes
7. Assemble Floor Plate Assembly and Stock to Barrel Assembly Complete with Front and Rear Trigger Guard Screws.
 - Using Pneumatic Power Driver, or Ball Ratchet Screwdriver properly seated against the barrel bracket cut in the stock. (bbl. Assy. bracket to rear of barrel bracket cut in stock) First torque front take down screw - 65 IN*LBS - per torque spec. Next torque rear take down screw to 65 IN*LBS then(ADL'S) the center take down screw SNUG ONLY
 - a. Check Margin at Ejection Port and at Receiver Tang per Sample
 - Opening Between Stock and Receiver Uniform
 - No Bad Chipping

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- Barrel Must Seat within 1.5" of Front of Stock
- Vertical Squeeze Produces No Movement
- Guard Screws Tightened to 45 IN - LBS
- .020 Max. Opening Under Trigger Plate Except at Corners
- .025 Max. Opening Under Trigger Plate at Corners
- .025 Max. Opening With Stock
- b. Gas Hole in Receiver 50% Visible Above Stock
- c. Check for Trigger Clearance In Guard
 - Must Not Bind
 - Trigger Must Not Be Exposed Outside of Guard
 - A (.030) Shim Must Fit Between End of Trigger and Inside of Guard Bow While Trigger is in both the Full Rearward Position and the Relaxed Position
- 1. IF IT FAILS the SHIM
 - SEE PROCEDURE BELOW for Shim PLACEMENT UNDER THE TRIGGER GUARD

Shim Placement Procedure if Required;

- a. Remove Trigger Guard from Stock Assembly
- b. Apply a Small Amount of Loctite Black Max to the Stock Assembly in the Area Around the Guard Screw holes
- c. Remove Non-Stick Back from Shim 92850 Rear Guard Screw Spacer
- d. Place the Sticky Side of Spacer to the Wooden Stock
 - Align the Rear Guard Hole with the Hole in the Spacer
 - Press Firmly to Assure Adhesion
- e. Repeat Procedure a. thru d. for the 92849 Front Guard Screw Spacer
- e. If Two Shims are Necessary
 - Remove the Non-Stick Back from One Shim
 - Place It On the Top Surface of the Second Shim
 - Press Firmly Together
- f. Repeat Procedure a. thru e. for Installation of the Now Double Shims

NOTE: DO NOT USE MORE THAN TWO SHIMS - (ONE DOUBLE SHIM FRONT AND REAR)

5A SUPPLIER FURNISHED, HEAVY BARREL, SYNTHETIC STOCKS ONLY --
(H-S PRECISION, ETC.)

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Check the fit between the Barrel and the barrel channel in the Stock. The Barrel should "float" and be positioned centrally in the barrel channel.

- a. If the Barrel appears to be central with respect to the channel, no further action is needed. Continue with the subsequent steps.
- b. If the Barrel appears off-center, favoring one side or the other, it will be necessary to check the clearance between the Barrel and the Stock to see if it is within specs.

SPECIFICATION: At a distance of 9 1/2" from the front of the Barrel Bracket, the Barrel must be NO CLOSER than .032 and NO FURTHER than .076 with respect to the side of the Stock channel.

- c. PROCEDURE: On the close side, a .032 feeler (shim) MUST GO between the side of the Barrel and the Stock. (The feeler should stand unsupported between the Barrel and the Stock.) On the far side, a .076 feeler MUST *NOT* GO.

- If the feeler test is successful, continue with subsequent steps.
- If the assembly does not pass the feeler test, replace the Stock.

NOTES: This procedure is done 9 1/2" from the face of the Barrel Bracket. The measurement point is approximately 1 1/2" in from the front tip of the Stock, about where the bedding pad is found on other models. The checks are invalid closer to the Receiver. Do not force the feeler gage.

- 6 Turn Rifle Over in Vise
- 7 Check Safety
 - No Bind
 - Clears Stock

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- a. Safety Lever Must Have Noticeable Overtravel Before Stopping or Coming Into Contact with Stock Cuts
 - Forward Beyond "F" Detent
 - Rearward Beyond "S" Detent
8. Check Bolt
 - No Bind
 - Clears Stock
9. Check Trigger Pull (4.75 to 5.75 lbs.) parallel with action
 - Must be Short & Crisp
 - No Creep Over or Overdraw

Try (3) Times
- NOTE:** Perform Monthly check on Trigger Pull scale to verify accuracy. Follow procedure below using at least two different weights.
 - a. Slowly lift dead weight off bench using trigger pull scale.
 - b. Slowly return weight to bench and read scale.
 - Measurement must be within 1/8 lb of actual dead weight.
 - c. If scale is not within above specification for any of the measured dead weights:
 - send scale to Gage Inspection for Re-Calibration.
10. Select Correct Magazine Assembly
 - a. Inspect for:
 - Color
 - NO Rust
11. Use Dummy Cartridges to Check:
 - Feeding
 - Extraction
 - Ejection

(Single Load and Fully Loaded Magazine Assembly)

 - a. Load the Magazine Assy Fully - (4 Regular Rounds or 3 Magnum Rounds)
 - Press the Cartridges Down at Rear

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- Let the Follower Spring Return the Cartridges to Full Height
- If They Do Not Return to the Feed Lips
 - 1. DO NOT USE MAGAZINE ASSEMBLY
 - 2. REPLACE MAGAZINE ASSEMBLY
- b. Adjust the Forearm Bench Rest to Clear the Magazine Assy Opening
 - IT IS IMPORTANT NOT TO FORCE the Magazine Assembly Upward During Function Testing
- c. Place the Magazine Assembly in the Trigger Guard Until Latches Catch
 - This Should Not Require A Great Amount of Force
 - If A Great Amount of Force is Needed
 - 1. Assemble Another Trigger Guard
- d. Remove Bolt
- e. Insert Shell Coverage Gage
 - Check Every Round From Full Magazine Assembly With Gage
 - The Rim of Each Cartridge MUST FALL BETWEEN the Two Inscribed Lines
 - PERFORM THIS CHECK 100% ON ALL MAGAZINE ASSEMBLY'S
(This is to Ensure NO Over Rides or Jump Magazine Malfunctions Occur During Gallery Test)
 - Make Sure Rims of Dummies Are Not Severely Worn so as to give a False Reading
 - If Coverage Insufficient Change of the Guard or Stock is Required
- f. Function Testing Must Be Done in the Following Manner:
 - Remove Magazine Assembly and Fully load
 - Place Fully Loaded Magazine Assembly in Trigger Guard Until It Latches
 - Remove Magazine Assembly and Replace while Fully Loaded Twice
 - 1. Once with Bolt Open
 - 2. Once with Bolt Closed
 - Press the Cartridges Downward to Close Bolt on an Empty Chamber
 - Work Action Normally Checking for Any Malfunctions
 - Repeat Steps One or More Times as Required

12 Make All Necessary Repairs from Test

NOTE: Insert Brass Cleaning Rod in Chamber End with Cleaning Patch

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- Wipe Bore
- Rod Must Have Sufficient Flannel Cleaning Patch to Clean Bore

13 Attach Hang Tag to Trigger Guard

Operation Tool Detail Operation: 583

Tool Number	Tooling Description
Std	Ball Ratchet Screwdriver
43447	Brass Wiping Rod
Std	Torque screwdriver - McMaster-Carr Cat# 5652A28
Std	.032 Feeler Gage - Plastic
Std	.076 Feeler Gage - Plastic
B-70697	Trigger Pull Scale
B-TS-7300	Dent & Scuff Template
B-49668	Shell Coverage Gage

PROCESS CONTROL INSPECTION RECORD				Revision Date:		22-Nov-05		Processed by:	
THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES									
Part No:		Part Name: Fin Assy 700 Pol		Centerfire Rifle		Date:		8/14/2006	
Operation No: 583		Operation: Assemble Stock to Action and Attach Hang						Work Center:	
Prod. Qty:		Prod. Order #:		Operator			Setup inspected by & Date:		
Gage Description and Characteristic		Gage Number	Gage Frequency	1st Shift	2nd Shift	3rd Shift	Remarks, Causes, Action Taken, Etc.		
VISUAL		VISUAL	100%	INSPECT REJECT					

			INSPECT	/	/	
.002 Feeler Gage - Plastic	Std.	100%	REJECT INSPECT	/	/	
.076 Feeler Gage - Plastic	Std.	100%	REJECT INSPECT	/	/	
Trigger Pull Scale	B-70697	100%	REJECT INSPECT	/	/	
Dent & Scuff Template	B-TS-7300	100%	REJECT INSPECT	/	/	
Shell Coverage Gage	B-49668	100%	REJECT INSPECT	/	/	
			REJECT INSPECT	/	/	
			REJECT INSPECT	/	/	
			REJECT INSPECT	/	/	
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585 Assemble Stock to Action & Attach Hang Tag
to Trigger Guard

Operation Step Detail Operation: 585

Step Operation / Step Description

Assemble Stock to Action

PROCEDURE:

- 1 Select Correct Stock
 - a. Inspect for:
 - Good Finish
 - Marks Slight
 - No Checks
 - Grip Outline Reasonably Uniform and Square
 - Butt Plate
 1. Black Rear Face
 2. No Burrs
 3. .005 Max. Opening at Face
 4. Tight (Finger Test)
 5. Screws Not Project Badly
 6. Burrs at Screw Holes Slight
 7. .02 Max. Mismatch of Butt Plate and Stock Either Way
 - Recoil Pad
 1. Good Color
 2. Rear Face
 3. No Burrs
 4. .005 Max. Opening at Face

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5. Tight (Finger Test)
6. Burrs at Screw Holes Slight
7. .02 Max. Mismatch of Recoil Pad and Stock Either Way
- b. Inspect and Reject for Visual Damage
 - Procedure to Reject Stock if Below Standards
 - 1. Hand Print Defect Code Number on Color Dot
 - 2. Affix Adhesive Color Dot to Stock Beside the Defect Being Noted
2. Select Correct Magazine
 - a. Inspect for:
 - Color
 - NO Rust
3. Assemble Magazine to Receiver
4. Position Stock on Action
5. Select Trigger Guard Assy
 - a. Inspect for:
 - No Sharp Edges
 - Color
 - Marrs
 - Pits
 - Position in Stock
6. Select Front, and Rear Trigger Guard Screws
 - a. Inspect for:
 - Color
 - Allen Head
 - Threads
 - Position in Holes
7. Assemble Floor Plate Assembly and Stock to Barrel Assembly Complete with Front and Rear Trigger Guard Screws.
 - Using Pneumatic Power Driver, or Ball Ratchet Screwdriver

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properly seated against the barrel bracket cut in the stock. (bbl. Assy. bracket to rear of barrel bracket cut in stock) First torque front take down screw - 65 IN*LBS. - per torque spec. Next torque rear take down screw to 65 IN*LBS then (ADL'S) the center take down screw SNUG ONLY

a. Check Margin at Ejection Port and at Receiver Tang per Sample

- Opening Between Stock and Receiver Uniform
- No Bad Chipping
- Barrel Must Seat within 1.5" of Front of Stock
- Vertical Squeeze Produces No Movement
- Guard Screws Tightened to 45 IN - LBS
- .020 Max. Opening Under Trigger Plate Except at Corners
- .025 Max. Opening Under Trigger Plate at Corners
- .025 Max. Opening with Stock

b. Gas Hole in Receiver 50~ Visable Above Stock

c. Check for Trigger Clearance In Guard

- Must Not Bind
- Trigger Must Not Be Exposed Outside of Guard
- A (.030) Shim Must Fit Between End of Trigger and Inside of Guard Bow While Trigger is in both the Full Rearward Position and the Relaxed Position

1. IF IT FAILS the SHIM

- SEE PROCEDURE BELOW for Shim PLACEMENT UNDER THE TRIGGER GUARD

Shim Placement Procedure if Required;

- a. Remove Trigger Guard from Stock Assembly
- b. Apply a Small Amount of Loctite Black Max to the Stock Assembly in the Area Around the Guard Screw holes
- c. Remove Non-Stick Back from Shim 92850 Rear Guard Screw Spacer
- d. Place the Sticky Side of Spacer to the Wooden Stock
 - Align the Rear Guard Hole with the Hole in the Spacer
 - Press Firmly to Assure Adhesion
- e. Repeat Procedure a. thru d. for the 92849 Front Guard Screw Spacer
- e. If Two Shims are Necessary
 - Remove the Non-Stick Back from One Shim
 - Place It On the Top Surface of the Second Shim

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- Press Firmly Together
- f. Repeat Procedure a. thru e. for Installation of the New Double Shims

NOTE: DO NOT USE MORE THAN TWO SHIMS - (ONE DOUBLE SHIM FRONT AND REAR)

7A. SUPPLIER FURNISHED, HEAVY BARREL, SYNTHETIC STOCKS ONLY --
(H-S PRECISION, ETC.)

Check the fit between the Barrel and the barrel channel in the Stock.
The Barrel should "float" and be positioned centrally in the barrel
channel.

- a. If the Barrel appears to be central with respect to the channel, no
further action is needed. Continue with the subsequent steps.
- b. If the Barrel appears off-center, favoring one side or the other, it
will be necessary to check the clearance between the Barrel and the
Stock to see if it is within specs.

SPECIFICATION: At a distance of 9 1/2" from the front of the Barrel
Bracket, the Barrel must be NO CLOSER than .032 and NO FURTHER than
.076 with respect to the side of the Stock channel.

- c. PROCEDURE: On the close side, a .032 feeler (shim) MUST GO between
the side of the Barrel and the Stock. (The feeler should stand
unsupported between the Barrel and the Stock.) On the far side, a
.076 feeler MUST *NOT* GO.

- If the feeler test is successful, continue with subsequent steps.
- If the assembly does not pass the feeler test, replace the Stock.

NOTES: This procedure is done 9 1/2" from the face of the Barrel
Bracket. The measurement point is approximately 1 1/2" in from the
front tip of the Stock, about where the bedding pad is found on other
models. The checks are invalid closer to the Receiver. Do not force

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the feeler gage.

- 8 Assemble Magazine Spring to Magazine Follower
 - a. Install in Floor Plate W/ Floor Plate Insert (17, 204, 221, 222, 223 cal only)
 - b. Adjust Floor Plate to Latch Properly - (See Sample)
 - 9 Turn Rifle Over in Vice
 - 10 Check Safety
 - No Bind
 - Clears Stock
 - a. Safety Lever Must Have Noticeable Overtravel Before Stopping or Coming Into Contact with Stock Cuts
 - Forward Beyond "F" Detent
 - Rearward Beyond "S" Detent
 - 11 Check Bolt
 - No Bind
 - Clears Stock
 - 12 Check Trigger Pull (4.75 to 5.75 lbs.) parallel with action
 - Must be Short & Crisp
 - No Creep Over or Overdraw
- Try (3) Times

NOTE: Perform Monthly check on Trigger Pull scale to verify accuracy. Follow procedure below using at least two different weights.

- a. Slowly lift dead weight off bench using trigger pull scale.
- b. Slowly return weight to bench and read scale.
 - Measurement must be within 1/8 lb of actual dead weight.
- c. If scale is not within above specification for any of the measured dead weights;
 - send scale to Gage Inspection for Re-Calibration.

- 13 Single load and Full Magazine Dummy Cartridges to Check:

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- a. Feeding
- b. Extraction
- c. Ejection
- d. Adjust if Necessary

14. Make All Necessary Repairs from Test

NOTE: Insert Brass Cleaning Rod in Chamber End with Cleaning Patch
 - Wipe Bore
 - Rod Must Have Sufficient Flannel Cleaning Patch to Clean Bore

15 Attach Hang Tag to Trigger Guard

Operation Tool Detail

Operation: 585

Tool Number	Tooling Description
STD	Ball Ratchet Screwdriver
Std	Torque screwdriver - McMaster-Carr Cat# 5699A28
43447	Brass Wiping Rod
B-70697	Trigger Pull Scale
B-TS-7300	Dent & Scuff Template
Std	.032 Feeler Gage - Plastic
Std	.076 Feeler Gage - Plastic

PROCESS CONTROL INSPECTION RECORD THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES		Revision Date: 22-Nov-05	Processed by:
Part No:	Part Name: Fin Assy 700 Pol	Centerfire Rifle	Date: 8/14/2006

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Operation No: 585		Operation: Assemble Stock to Action & Attach Hang Tag				Work Center:
Prod. Qty:		Prod. Order #	Operator			Setup Inspected by & Date:
Gage Description and Characteristic	Gage Number	Gage Frequency	1st Shift	2nd Shift	3rd Shift	Remarks, Causes, Action Taken, Etc.
VISUAL	VISUAL	100%	REJECT INSPECT			
Trigger Pull Scale	B-70697	100%	REJECT INSPECT			
Dent & Scuff Template	B-TS-7300	100%	REJECT INSPECT			
.032 Feeler Gage - Plastic	Std	100%	REJECT INSPECT			
.076 Feeler Gage - Plastic	Std	100%	REJECT INSPECT			
			REJECT INSPECT			
			REJECT INSPECT			
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586 Assemble Stock to Action and Attach Hang
Tag to Trigger Guard

Operation Step Detail Operation: 586

Step Operation / Step Description

Assemble Stock to Action

Check for Barrel float and position in Stock
=====

These two clearance checks are to be done with the Stock assembled to the action, Barrel Bracket back against the aluminum bedding Stock surface.

Assemble Floor Plate Assembly and Stock to Barrel Assembly Complete with Front and Rear Trigger Guard Screws.

- Using Pneumatic Power Driver, or Ball Ratchet Screwdriver properly seated against the barrel bracket cut in the stock. (bbl. Assy. bracket to rear of barrel bracket cut in stock) First torque front take down screw - 65 IN*LBS - per torque spec. Next torque rear take down screw to 65 IN*LBS then(ADL'S) the center take down screw SNUG ONLY

Free float Barrel clearance:

A 1" wide by .010" thick plastic shim, located around the underside of the Barrel, must move freely the entire length of the fore-end back to the front face of the Barrel Bracket.

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Side-to-side centrality of fore-end (typically @ front):

SUPPLIER FURNISHED, HEAVY BARREL, SYNTHETIC STOCKS ONLY --
(H-S PRECISION, ETC.)

Check the fit between the Barrel and the barrel channel in the Stock.
The Barrel should "float" and be positioned centrally in the barrel
channel.

- a. If the Barrel appears to be central with respect to the channel, no
further action is needed. Continue with the subsequent steps.
- b. If the Barrel appears off-center, favoring one side or the other, it
will be necessary to check the clearance between the Barrel and the
Stock to see if it is within specs.

SPECIFICATION: At a distance of 9 1/2" from the front of the Barrel
Bracket, the Barrel must be NO CLOSER than .032 and NO FURTHER than
.076 with respect to the side of the Stock channel.

- c. PROCEDURE: On the close side, a .032 feeler (shim) MUST GO between
the side of the Barrel and the Stock. (The feeler should stand
unsupported between the Barrel and the Stock.) On the far side, a
.076 feeler MUST *NOT* GO.

- If the feeler test is successful, continue with subsequent steps.
- If the assembly does not pass the feeler test, replace the Stock.

NOTES: This procedure is done 9 1/2" from the face of the Barrel
Bracket. The measurement point is approximately 1 1/2" in from the
front tip of the Stock, about where the bedding pad is found on other
models. The checks are invalid closer to the Receiver. Do not force
the feeler gage.

Check Gunlock Function:

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Insert key in lock and rotate to the locked position. Assemble the Firing Pin Assembly to the Bolt Assembly in the locked position.

Try to close the Bolt with the safety on and again with the safety off.

- o Bolt should not close.
- o Bolt MAY close with the safety off (Forward position) and the gunlock locked but only with considerable effort. The Firing Pin must NOT fall when the trigger is pulled.

Rotate the gunlock to the unlocked position.

- o Perform regular functional checks at this time. (Feeding, extraction, etc.)

Close the action and rotate the gunlock part way towards the locked position but do NOT allow the detent to engage or click in place. Move the safety to the fire position.

- o Pull the trigger, firing pin should fall only part way.

Rotate the gunlock toward the fire position. Gunlock should lock into a detent position and should not move further.

- o Firing Pin may fall further but still only part way.
- o At this point the action MUST be opened to resume operation on the rifle.

Open the action and insert the key and roll the gunlock part way toward the fire position but do not allow the detent to engage. Close the action and try to fire.

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- o Firing Pin must not fall fully and gunlock should engage a detent.

Open the action, turn the gunlock to the fully unlocked position, return the Safety lever to the safe position (Rearward position) ready for gallery test.

Operation Tool Detail**Operation: 586**

Tool Number	Tooling Description
Std	Ball Ratchet Screwdriver
43447	Brass Wiping Rod
Std	Torque screwdriver - McMaster-Carr Cat# 5699A28
Std	.032 Feeler Gage - Plastic
B-TS-7300	Dent & Scuff Template
Std	.076 Feeler Gage - Plastic
B-70697	Trigger Pull Scale

PROCESS CONTROL INSPECTION RECORD THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES		Revision Date: 22-Nov-05		Processed by:	
Part No:	Part Name: Fin Assy 700 Pol	Centerfire Rifle		Date: 8/14/2006	
Operation No: 586		Operation: Assemble Stock to Action and Attach Hang			Work Center:
Prod. Qty:	Prod. Order #:	Operator		Setup Inspected by & Date:	

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Extra material found in original VAXcamps process

PROCEDURE:

1. Select Correct Stock
 - a. Inspect for Good Finish, Marrs Slight, No Checks - Grip Outline Reasonably Uniform and Square
 - b. Butt Plate Black, Rear Face - No Burrs, .005 Max. Opening at Face, Tight (Finger Test), Screws Not Project Badly, Burrs at Screw Holes Slight, .02 Max. Mismatch of Butt Plate and Stock Either Way
 - c. Inspect and Reject for Visual Damage
 - Procedure to Reject Stock if Below Standards
 - a. Hand Print Defect Code Number on Color Dot
 - b. Affix Adhesive Color Dot to Stock Beside the Defect Being Noted
2. Pick Correct Magazine
 - a. Inspect for Color, NO Rust
3. Assemble Magazine to Receiver
4. Select Trigger Guard Assy and place in Stock - Assemble Trigger Guard and Stock to Action with Front and Rear Trigger Guard Screws
Check for Trigger Clearance In Guard and Floor Plate - Must Not Bind
Trigger Must Not Be Exposed Outside of Guard - A (.030) Shim Must Fit Between End of Trigger and Inside of Guard Bow While Trigger is in Full Rearward or Relaxed Position - If it Fails the Shim, See Procedure Below for Shim Placement Under Trigger Guard

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Shim Placement Procedure if Required;

- a) Remove Trigger Guard from Stock Assembly
- b) Apply a small amount of Loctite Black Max to the Stock Assembly in the area around the Guard Screw holes. (SYNTHETIC STOCKS ONLY)
- c) Remove Non-Stick Back from Shim - 92850 (Rear Guard Screw Spacer) and Place the Sticky Side of Spacer to the Wooden Stock Aligning the Rear Guard Hole with the Hole in the Spacer and Press Firmly to Assure Adhesion
- d) Repeat Above Procedure for the Shim - 92849 (Front Guard Screw Spacer)
- e) If Two Shims are Necessary, Remove the Non-Stick Back from One Shim and Place it On the Top Surface of the Second Shim and Press Firmly Together - Repeat Above Procedures for the Installation of the Now Double Shims

NOTE: DO NOT USE MORE THAN TWO SHIMS - (ONE DOUBLE SHIM FRONT AND REAR)

5. Assemble Magazine Spring to Magazine Follower
 - a. Install in Floor Plate
 - b. Adjust Floor Plate to Latch Properly - (See Sample)
6. Inspect Margin at Ejection Port and Receiver Tang, per .030 Sample
 - a. Opening Between Stock & Receiver Should Be Uniform, No Chipped or Scratched Finish
 - b. Vertical Squeeze - No Movement
 - c. Guard Screws tight - See Sample for Max Opening Between Stock & Floor Plate - Reasonable Gap Between Floor Plate and Stock is Acceptable, If Uniform - Reject if Edge is Jagged
 - d. Gas Hole in Receiver 50% Visible Above Stock
7. Check Police Synthetic Stocks at Fore End Tip Each Side of Barrel with .020 Shim - Must Go 1/8"
8. Turn Rifle Over in Vise

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9. Check Safety - No Bind - Clears Stock
 - a. Safety Lever Must Have Noticeable Overtravel; Forward Beyond "F" Detent and Rearward Beyond "S" Detent Before Stopping or Coming Into Contact with Stock Cuts.

10. Check Bolt - No Bind - Clears Stock

11. Check Trigger Pull (4.5 to 5.5 lbs.)
 - Must be Short & Crisp
 - No Creep Over or Overdraw

Try (3) Times

NOTE: Perform Monthly check on Trigger Pull scale to verify accuracy.

Follow procedure below using at least two different weights.

- a. Slowly lift dead weight off bench using trigger pull scale.
- b. Slowly return weight to bench and read scale.
 - Measurement must be within 1/8 lb of actual dead weight.
- c. If scale is not within above specification for any of the measured dead weights;
 - send scale to Gage Inspection for Re-Calibration.

12. Use Dummy Cartridges to Check Feeding, Extraction, and Ejection (Single Load and Full Magazine)
 - a. Adjust if Necessary

13. Stamp Assemblers Number on Left Side of Barrel at Rear

14. Make All Necessary Repairs from Test

NOTE: Insert Brass Cleaning Rod in Chamber End with Cleaning Patch & Wipe Bore

- Rod Must Have Sufficient Flannel Cleaning Patch to Clean Bore

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588

PROOF TEST

Operation Step Detail

Operation: 588

Step

Operation / Step Description

SAFETY BEFORE TEST-All Plant rules, Gallery rules and Job
Safety keypoints are to be observed at all times.

I. GUNS TO BE PROOFED

A. All guns are to be proofed 100% after final assembly and prior to
function testing.

1. Use special remote operated steel covered proofing device and
approved booths only. (DO NOT PROOF RIFLES IN SHOTGUN PROOF
BOOTH)

II. PROOFING OBJECTIVE

A. To test each guns ability to withstand the proof round pressure
without damage to the gun or distortion of the proof round.

III. SAFETY

A. Water tanks are to be inspected each shift before shooting is
started and inspection sheet is to be signed. (Refer to General
Gallery Safety Rules, Section K.)

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- B. All assembled guns are to be stored with the action open and the safe in the "S" or "on" position.

IV. DESCRIPTION AND SEQUENCE OF PROOF TEST

- A. Preliminary inspection-Each gun prior to proof:
 - 1. No more than two different calibers per truck load.
 - 2. Inspect all rifle bores for obstruction with rod.
 - a. Use nylon or brass rod (make sure action is open before inserting rod).
 - b. Insert into muzzle until rod is clearly visible through ejection port.

B. PROOF TEST

NOTE: The first rifle proofed is to be left off of the truck so there will be an open space between tested and untested guns. Place first gun back on truck when the entire load has been completed.

- 1. Pick up first gun from truck and inspect for:
 - a. Ammunition - Inspect chamber and magazine-both must be empty.
 - b. Caliber - To verify for shooting safety.

Note: If the load has two different calibers on it, place a red tag on the muzzle end of one gun on the truck to alert the testers and targeters of this condition.

- c. Magnaflux Triangular Stamp-Must be present on right rear side of Barrel.
- d. Check for Firing Pin Protrusion or Foreign material at

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Face of Bolt:

1. Firing Pin must be retracted in the Bolt.
2. Bolt Face and Shroud must be free from any foreign material.

NOTE: Visually check the first gun from each side of the truck for obvious visual defects before and after proof test.

2. Move the Safe to the "OFF" (F) position. Open and close the bolt forcibly 3 times. The Firing Pin must not follow down.
3. With action open and the Safe in the "OFF" (F) position, place assembled gun in proofing rack - muzzle in port.
4. Load one (1) proof round into chamber of barrel and close the bolt.
5. Close protective steel doors of proofing device.
 - a. Closing of left hand door must activate air cylinder which clamps stock into fixture.
 - b. The stops on both doors must contact both relays to activate firing mechanism.
6. PULL large knob on side of proofing device and hold (to position triggering mechanism in fixture).
7. Push firing button on side of proofing device (to operate triggering mechanism).
8. If gun fails to fire, repeat procedure 6 & 7 listed above.
If gun fails to fire second time, wait one (1) minute before opening steel doors to remove shell.
 - a. Inspect unfired shell for firing pin indent. If indent appears sufficient to fire round, load another

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proof round and repeat procedures 4,5,6 & 7.

- b. If gun fails to fire, wait one (1) minute before removing shell.
- c. Place safe in "S" or "on" position, remove gun from proof jack and enter gun information and reject in computer.

9. After firing, open doors of proofing device and retrieve fired case.

10. Check fired case for:

- a. Primer indent-must be sufficient to fire round.
- b. Possible ruptures-must not be ruptured or swelled.
- c. Rings or roughness-slight rings are permissible - Rub fingernail over ring. If ring is large enough pick with nail, reject the gun.

NOTE: If primer blows out of the primer pocket or is pierced, complete sequence 11 and 12 (below) and then check receiver of gun for primer or the piece of the pierced primer. If primer or piece of primer can be found, remove it and pass the gun. If primer or piece of primer can't be found, enter gun information and reject code in computer, place reject ticket in envelope and place the gun on truck.

11. Move Safety to "S" or "on" position before removing gun from proofing device.

12. Inspect chamber and magazine for live ammunition before removing gun from port.

- a. Chamber must be empty.
- b. Follower must be visible.

13. Remove gun from device and place on bench.

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14. Stamp proof mark (REP), right rear side of Barrel ON ACCEPTABLE PRODUCTS ONLY.
15. If gun fails proof test - enter gun information and reject code into computer. Attach reject ticket to gun.
16. Place gun back on truck.
17. Repeat test on next and succeeding guns.

V. INTERPRETATION OF PROOF TEST

A. PASS GUN

1. If there is no failure at proof.
 - a. Gun must be free of defects. (Not broken, cracked, split, chipped, deformed or show stress marks)
2. If fired case is within visual specifications as outlined in Item IV-B10 (above)
3. If there are no serious visual defects found on wood or metal surfaces of the gun.

B. REJECT GUN

1. If gun has part breakage or action will not open.
2. If fired case fails to meet visual specifications.
3. If any serious visual defects are found before or after test.

VI. SAFETY AFTER PROOF TEST

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A. SAFETY

1. Move Safe to "S" or "ON" position before removing gun from shooting device.
2. Place the first gun proofed back onto the truck after complete load has been proofed.

B. INSPECT CHAMBER AND MAGAZINE FOR LIVE AMMUNITION

1. Chamber must be empty.
2. Follower must be visible.
3. Check chamber and follower on all guns upon completion of proof test.

C. VISUALLY INSPECT FOR MARRING BY DEVICE OR PORT

1. Check all guns from each side of the truck, after proof test, and carefully check gun for possible damage from the jack or port.
 - a. If any damage is found, stop testing and have the cause of damage corrected.
 - b. Resume testing only after correction has been made.

D. MOVE ENTIRE LOAD TO NEXT OPERATION

1. The Model 700 rejects will stay on the original truck when moved to the next operation (Test and Target).

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590 ASSEMBLE TRS SCOPE BASE, SCOPE RINGS, &
TELESCOPE WITH LENS COVERS

Operation Step Detail Operation: 590

Step Operation / Step Description

ASSEMBLE TRS SCOPE BASE, SCOPE RINGS, & TELESCOPE WITH LENS COVERS

PROCESS CONTROL INSPECTION RECORD THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES			Revision Date 22-Nov-05			Processed by:	
Part No:		Part Name: Fin Assy 700 Pol		Centerfire Rifle		Date: 8/14/2006	
Operation No: 590		Operation: ASSEMBLE TRS SCOPE BASE, SCOPE RINGS, &					Work Center:
Prod. Qty:		Prod. Order #:		Operator		Setup inspected by & Date:	
Gage Description and Characteristic		Gage Number	Gage Frequency	1st Shift	2nd Shift	3rd Shift	Remarks, Causes, Action Taken, Etc.
VISUAL		VISUAL	100%	INSPECT			
				REJECT			
				INSPECT			
				REJECT			
				INSPECT			
				REJECT			

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593 Assemble Front Swivel Screw and Swivel Screw
Spacer to Stock

Operation Step Detail Operation: 593

Step	Operation / Step Description
	Assemble Front Swivel Screw and Swivel Screw Spacer to Stock
1	Install Washer onto Swivel Screw
2	Start Front Swivel Screw in Stock by Hand
3	Thread Swivel Screw into Stock Full Depth - Tight without Stripping Hole
4	Align Swivel Hole - Perpendicular to Stock Center Line

Operation Tool Detail Operation: 593

Tool Number	Tooling Description
5/32 Point Dia	Prick Punch (McMaster Carr no.3417A1 or Equivalent)

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594 FUNCTION TEST(100%) AND TARGET(100%)

Operation Step Detail Operation: 594

Step Operation / Step Description

Gallery Test-Procedure and Specifications

Safety before Test: All plant rules, gallery rules and job safety key points are to be observed at all times.

I. RIFLES TESTED AND TARGETED

- A. All rifles (100%) are to be tested after proof.
- B. 100% of Police rifles are to be targeted.
- C. Record results of testing in computer as test and target operations are performed.

II. TEST AND TARGET OBJECTIVES

- A. Function: To check the ability of each rifle to satisfactorily load, feed, close, lock, fire, unlock, open, extract, eject and for proper operation of the Safety.
- B. Accuracy: To check the ability of each rifle to satisfactorily meet specifications for point of impact and/or group size.
- C. Visual: To check the ability of each rifle to satisfactorily meet appearance specifications for front and rear sights and general overall presentability.

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III. SHOOTING JACKS AND DEVICE

A. When performing an accuracy evaluation on a rifle use the accuracy device.

1. Adjust and set device with master rifle if the caliber and model to be shot is produced with iron sights.
2. Use 1" by 1" grid type targeting paper.

B. When performing a function test, either the accuracy device or a centerfire shooting jack can be used.

1. If a shooting jack is used, complete function test on entire truck. Then push the truck back to an accuracy device to target 100%.

IV. DESCRIPTION OF TEST AND TARGET PROCEDURES AND SPECIFICATIONS:

NOTE: The first rifle tested and targeted is to be left off of truck so there will be an open space between tested and untested rifles. Place first rifle back on truck when the entire load has been completed.

A. Test/Target Description

1. Pick up rifle from truck and inspect for:
 - a. Live Ammo - Inspect chamber and Magazine-both must be empty.
 - b. Caliber - To verify for shooter personal safety in selecting ammunition for test.
 - c. Proof mark on Barrel - (REP) must be present, right rear side of barrel, ahead of Magnaflux stamp.
 - d. Proof mark on Bolt - (.) Prick punch mark must be present at bottom of Bolt Handle.
 - e. Visual Defects - Marring of wood or metal finishes.

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If not within specifications for items a-e above, reject guns at this point.

2. With safety in "F" or "OFF" position-close Bolt crisply on empty chamber. Rifle must be pointed in safe direction at all times.

- a. Firing pin must not follow down as Bolt cams shut.
- b. Must not fire on closings.

3. With Safety in "S" or "on" position and the action closed, raise the bolt.

- a. Bolt must raise or open without excessive force.

4. Close Bolt with safety in "'S" or "on" position -- pull trigger firmly.

- a. Rifle must not fire

5. With finger off Trigger-move safety to "F" or "OFF" position.

- a. Rifle must not fire.

6. Open and close Bolt full stroke to cock firing pin.

7. Move Safety to full rear "S" or "ON" position and then move half way to the "F" or "OFF" position with thumb.

8. If safety stops at half-way position-pull trigger.

- a. Rifle must not fire.
- b. Safety must not move to full "OFF" or "F" position.

9. If safety stops in halfway position, move safety to "F" or

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"OFF" position after pulling trigger.

a. Rifle must not fire.

IMPORTANT-Perform Items 2-9 above, a total of three (3) times per gun.

10. Move safety to "S" or "ON" position.

NOTE: Steps 11-13 pertain to guns being tested as accuracy device.

11. With Action open, position rifle in device and clamp.

12. For first rifle of a new caliber remove the bolt and look through bore to line up device with paper.

13. Load Magazine to capacity: (see chart below)

- a. Magazine must accept total rounds specified.
- b. Cartridges must be retained by rails in receiver.

	CALIBER	AMMUNITION TYPE	MAG. CAP
1.	223 Rem	62 gr. HP MATCH	5
2.	308	168 gr. BT HP MATCH	4
3.	300 Win Mag	190 gr. EXTENDED RANGE BT	3
4.	7mm. Rem. Mag.	140 gr. PSP BT	3

14. Fold cartridges down in Magazine, start Bolt over Cartridge column and close Bolt on empty chamber.

a. Bolt must close over full magazine with normal pressure.

15. Open Bolt full stroke to rear position.

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16. Close guard. (If on accuracy device)
17. Close Bolt to feed shell into chamber and lock to start test.
 - a. Must feed single (1) shell with each operating stroke of Bolt.
 - b. Must not double feed.
 - c. Shells must not enter chamber or magazine. (Bind inside receiver or barrel.)
 - d. Bolt must not override shell in magazine.
 - e. Bolt must feed shell into chamber with normal pressure.
 - f. If, using normal force, the Bolt will not close over a live round in the chamber, perform the following test:
 1. Insert the appropriate close hard plug into the chamber while the rifle is held in the test device. (see Tool Detail Section for list of close hard plugs)
 2. Close and operate bolt:
 - a. If bolt closes hard over the plug, reject the rifle for Close Hard and record the malfunction in the computer and attach the slip to the rifle.
 - b. If bolt closes with normal pressure, do not reject the rifle. This indicates oversize ammunition.
18. Move safety to "F" or "OFF" position.
19. If using accuracy device fire rifle by pushing (2) two buttons on device simultaneously. If using shooting jacks, grip rifle in normal manner and pull trigger with finger.
20. For the 100% of Police rifles that are targeted, check each shot with spotting scope for rifle "seating in" and position of shots on paper. Use a maximum of 3 "seater" rounds per rifle. Use non-match ammunition for preliminary seaters to conserve the more

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expensive match ammunition.

a. Adjust device if shots off paper or group too close to edge.

21. Operate action full cycle to extract, eject, and feed each shot.

a. Bolt should not pull out of receiver.

b. Case or shell must be retained by extractor until the case is ejected from receiver.

c. Case must be completely ejected from receiver, should not catch on receiver.

d. One fired case from each rifle must be visually inspected for firing pin indent and chamber marks reflected on case. Slight rings are permissible; if ring is large enough to pick with fingernail, reject the rifle.

22. Fire all rounds required for Test and Targeting.

a. For the Test procedure, each rifle is to have the first two (2) rounds fired and the remaining rounds cycled through but not fired.

b. For the Target procedure, all accuracy specifications are based on groups consisting of 5 shots, therefore, those rifles will typically require extra rounds to be loaded and shot singly. See chart below for acceptable group sizes.

23. Open guard. (If on accuracy device)

24. For the Targeted rifles (100% Police)

a. Use spotting scope to check group size.

b. Maximum spread of the two extreme holes must be within group size specifications listed below.

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GROUP SIZE SPECIFICATIONS M/700 POLICE:

CALIBER	AMMUNITION TYPE	MAX. GROUP CENTER TO CENTER 5 SHOT
1. .223 REM (1/8 twist)	62 HP MATCH	1.5
2. .308	168 BT HP MATCH	1.5
3. .300 Win Mag	190 EXTENDED RANGE BT	1.5
4. 7mm. Rem. Mag.	140 PSP BT	1.5

25. Unclamp and remove rifle from device. (If on accuracy device).
26. Inspect chamber and magazine for live ammunition.
 - a. Chamber must be empty.
 - b. Follower must be visible.
27. Pass all rifles that meet specifications for:
 - a. Visual
 - b. Functional
 - c. Group size
28. Reject all rifles that do not meet specifications:
 - a. Enter all malfunctions into the computer and place white repair ticket on rifle.
 - b. If a rifle fails to meet the target group size specifications, reject that rifle and target all remaining.
29. Place rifle back on truck.

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10. Repeat Test on next and succeeding rifle.

a. Target Police rifles 100%

V. SAFETY AFTER TEST

A. Open Bolt

1. Move Bolt to open position before removing rifle from accuracy device.

B. Inspect Chamber and Magazine for live ammunition.

1. Rifle must be empty.
2. Follower must be visible.

NOTE: Perform "A" & "B" above on each individual rifle immediately after shooting test. Repeat "B" for all rifles on truck at completion of test.

C. Visual Inspect for marring by device or port.
check for any possible damage to rifle from the test.

D. All rifles are moved to Ammunition Inspection Area.

Operation Procedure Notes Operation: 594

Description

NOTE:

1. .308 POLICE DM (1/12 TWIST) TO SHOOT 168 gr. BT HP MATCH AMMO.
2. .223 REM (1/9 twist) to shoot 60 gr. HP MATCH AMMO.

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Operation Tool Detail

Operation: 594

Tool Number

Tooling Description

Plugs

The following is a list of all Close Hard Plugs used during
test and target in gallery: (POLICE CAL: MARKED *)

CALIBER	USE CLOSE HARD PLUG
7MM WEY MAG	C-48336-B
7MM REM MAG, 338 WIN MAG	C-46200-B
300 WEY MAG	C-48336-A
300 WIN MAG	C-46200-A
17 REM	C-46201 OR D-48349-A
.222 REM	C-46197 OR D-48349-B
.223 REM *	C-46198 OR D-48349-C
.243,6MM REM	C-46195 OR D-48349-D
22-250 REM	C-46199 OR D-48349-E
7MM MAUSER (7X57)	D-48349-F
7MM EXP, .280 REM	D-48349-G
7MM-08,.308,.243 *	C-46194 OR D-48349-H
35 WHELEN,30-06,.270,25-06	C-45930 OR D-48349-J
300 SAVAGE	D-48349-K
257 ROBERTS	D-48349-L
35 REM	D-48349-M
7MM BR	D-48349-N
7X64 BRENNKE	D-48349-P
220 SWIFT	D-48349-R
6.5X55 SWEDISH	D-48349-S

(Close Hard Plug Storage Cabinet is D-46202)

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595 Mark Bolt to Match Receiver Serial
 Number Using Dot Peen Marking Machine

Operation Step Detail Operation: 595

Step Operation / Step Description

Mark Bolt to Match Receiver Serial Number Using
Dot Peen Marking Machine

- 1 Load Program 700BOLT
- 2 Input Last Four Digits ONLY of Gun Serial Number
- 3 Remove Bolt from Gun
- 4 Place Bolt in Fixture and Clamp
- 5 Press Start to Mark Bolt
- 6 Remove Finished Bolt
- 7 Replace Bolt in Gun
- 8 Place Gun Back On truck

Operation Tool Detail Operation: 595

Tool Number

Tooling Description

40789

Dot Peen Marker

4-51082

Stylus

E-TS-7583

Holding Fixture

PROCESS CONTROL INSPECTION RECORD THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES				Revision Date: 22-Nov-05		Processed by:	
Part No:		Part Name: Fin Assy 700 Pol		Centerfire Rifle		Date: 8/14/2006	
Operation No: 595		Operation: Mark Bolt to Match Receiver Serial				Work Center:	
Prod. Qty:		Prod. Order #:		Operator		Setup Inspected by & Date:	
Gage Description and Characteristic		Gage Number	Gage Frequency	1st Shift	2nd Shift	3rd Shift	Remarks, Causes, Action Taken, Etc.
VISUAL		VISUAL	100%	INSPECT	/	/	/
				REJECT INSPECT	/	/	/
				REJECT INSPECT	/	/	/
				REJECT INSPECT	/	/	/
				REJECT INSPECT	/	/	/
				REJECT INSPECT	/	/	/
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596 INSPECT FOR LIVE AMMUNITION

Operation Step Detail Operation: 596

Step Operation / Step Description

INSPECT FOR LIVE AMMUNITION

PROCESS CONTROL INSPECTION RECORD THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES			Revision Date: 22-Nov-05			Processed by:	
Part No:	Part Name: Fin Assy 700 Pol		Centerfire Rifle			Date: 8/14/2005	
Operation No: 596	Operation: INSPECT FOR LIVE AMMUNITION					Work Center:	
Prod. Qty:	Prod. Order #:	Operator			Setup Inspected by & Date:		
Gage Description and Characteristic	Gage Number	Gage Frequency	1st Shift	2nd Shift	3rd Shift	Remarks, Causes, Action Taken, Etc.	
VISUAL	VISUAL	100%	INSPECT				
			REJECT				
			INSPECT				
			REJECT				
			INSPECT				
			REJECT				

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597 CLEAN AND INSPECT

Operation Step Detail Operation: 597

Step Operation / Step Description

CLEAN AND INSPECT

PROCESS CONTROL INSPECTION RECORD THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES			Revision Date: 22-Nov-05			Processed by:	
Part No:	Part Name: Fin Assy 700 Pol		Centerfire Rifle			Date: 8/14/2006	
Operation No: 597	Operation: CLEAN AND INSPECT					Work Center:	
Prod. Qty:	Prod. Order #:	Operator			Setup Inspected by & Date:		
Gage Description and Characteristic	Gage Number	Gage Frequency	1st Shift	2nd Shift	3rd Shift	Remarks, Causes, Action Taken, Etc.	
VISUAL	VISUAL	100%	INSPECT				
			REJECT				
			INSPECT				
			REJECT				
			INSPECT				
			REJECT				

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598 PACK RIFLE AND DELIVER TO WAREHOUSE

Operation Step Detail Operation: 598

Step Operation / Step Description

PACK RIFLE AND DELIVER TO WAREHOUSE

PROCESS CONTROL INSPECTION RECORD THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES			Revision Date: 22-Nov-05			Processed by:	
Part No:	Part Name: Fin Assy 700 Pol		Centerfire Rifle			Date: 8/14/2005	
Operation No: 598	Operation: PACK RIFLE AND DELIVER TO WAREHOUSE					Work Center:	
Prod. Qty:	Prod. Order #:	Operator			Setup Inspected by & Date:		
Gage Description and Characteristic	Gage Number	Gage Frequency	1st Shift	2nd Shift	3rd Shift	Remarks, Causes, Action Taken, Etc.	
VISUAL	VISUAL	100%	INSPECT				
			REJECT				
			INSPECT				
			REJECT				
			INSPECT				
			REJECT				

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600 **Proof Test**

Operation Step Detail Operation: 600

Step Operation / Step Description

1. DESCRIPTION AND SEQUENCE OF PROOF TEST

A. Preliminary Inspection-Each gun prior to proof:

1. No more than two different calibers per truck load.
2. Inspect all centerfire bores for obstruction with rod.

B. PROOF TEST

NOTE: The first rifle proofed is to be left off of the truck so there will be an open space between tested and untested guns. Place first gun back on truck when the entire load has been completed.

1. Pick up first gun from truck and inspect for:
 - a. Ammunition-Inspect chamber and magazine-both must be empty.
 - b. Caliber-To verify for shooting safety.

1. If the load has two different calibers on it, place a red tag on the barrel of one gun on the truck to alert the testers and targeters of this condition.

- c. Magnaflux Stamp-Must be present right rear side of Barrel.
 - d. Firing Pin Protrusion or Foreign material at Face of Bolt:

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1. Firing Pin must be retracted in the Bolt.
2. Bolt Face and Shroud must be free from any foreign material.

NOTE: Visually check the first gun from each side of the truck for obvious visual defects before proof and all guns after proof.

2. Move the safe to the "OFF" position. Open and close the bolt forcibly 3 times. The Firing Pin must not follow down.
3. With action open and the Safe in the "OFF" position, place assembled gun in proofing rack - muzzle in port.
4. Load one (1) proof round into chamber of barrel.
5. Close protective steel doors of proofing device.
 - a. Closing of left hand door must activate air cylinder which clamps stock into fixture.
 - b. The stops on both doors must contact both relays to activate firing mechanism.
6. PULL large knob on side of proofing device and hold (to position triggering mechanism in fixture).
7. Pull firing button on side of proofing device (to operate triggering mechanism).
8. If gun fails to fire, repeat procedure 6 & 7 listed above.
If gun fails to fire second time, wait one (1) minute before opening steel doors to remove shell.
 - a. Inspect unfired shell for firing pin indent. If indent appears sufficient to fire round, load another proof round and repeat procedures 4,5,6 & 7.
 - b. If gun fails to fire, wait one (1) minute before removing shell.

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- c. Place safe in "S" or "on" position, remove gun from proof jack and enter gun information and reject in computer.
- e. After firing, open doors to proofing device and retrieve fired case.
- 10. Check fired case for:
 - a. Primer indent-must be sufficient to fire round.
 - b. Possible ruptures-must not be ruptured or swelled.
 - c. Rings or roughness-slight rings are permissible-use fingernail test to determine if serious enough to reject.

NOTE: If primer blows or is pierced complete sequence 11 and 12 (below) and then check receiver of gun for primer or the piece of the pierced primer. If primer can be found, pass gun. If primer or piece of primer can't be found, enter gun information and reject code in computer, place reject ticket in envelope and place the gun on truck.

- 11. Move Safety to "S" or "on" position before removing gun from proofing device.
- 12. Inspect chamber and magazine for live ammunition before removing gun from port.
 - a. Chamber must be empty.
 - b. Follower must be visible.
- 13. Remove gun from device and place on bench.
- 14. Stamp proof mark (REP), right rear side of Barrel ON ACCEPTABLE PRODUCTS ONLY.

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15. If gun fails proof test - enter gun information and reject code into computer. Attach reject ticket to gun.

16. Place gun back on truck.

17. Repeat test on next and succeeding guns.

2. INTERPRETATION OF PROOF TEST

A. PASS GUN

1. If there is no failure at proof.

a. Gun must be free of defects. (Not broken, cracked, split, chipped, deformed or show stress marks)

2. If fired case is within visual specifications as outlined in Item 1-B9 (above)

3. If there are no serious visual defects found on wood or metal surfaces of the gun.

B. REJECT GUN

1. If gun fails to withstand proof round pressure.

2. If fired case fails to meet visual specifications.

3. If any serious visual defects are found before or after test.

3. SAFETY AFTER PROOF TEST

A. SAFETY

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1. Move Safe to "S" or "ON" position before removing gun from shooting device.
2. Place the first gun proofed back onto the truck after complete load has been proofed.

B. INSPECT CHAMBER AND MAGAZINE FOR LIVE AMMUNITION

1. Chamber must be empty.
2. Follower must be visible.
3. Repeat item B 1 and 2 (above) on all guns upon completion of proof test.

C. VISUALLY INSPECT FOR MARRING BY DEVICE OR PORT

1. Check all guns from each side of the truck, after proof test, and carefully check gun for possible damage from the jack or port.
 - a. If any damage is found, stop testing and have the cause of damage corrected.
 - b. Resume testing only after correction has been made.

D. MOVE ENTIRE LOAD TO NEXT OPERATION

1. The Model 700 rejects will stay on the original truck when moved to the next operation (Test and Target).

Operation Procedure Notes Operation: 600

Description

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SAFETY BEFORE TEST-All Plant rules, Gallery rules and Job
Safety keypoints are to be observed at all times.

1. GUNS TO BE PROOFED

- a. All guns are to be proofed 100' after final assembly and prior to
function testing.

1. Use special remote operated steel covered proofing device and
approved booths only. (DO NOT PROOF RIFLES IN SHOTGUN PROOF BOOTHS)

2. PROOFING OBJECTIVE

- a. To test each guns ability to withstand the proof round pressure without
damage to the gun or distortion of the proof round.

3. SAFETY

- a. Water tanks are to be inspected each shift before shooting is started
and inspection sheet is to be signed. (Refer to General Gallery Safety
Rules, Section K.)
- b. All assembled guns are to be stored with the action open and the safe in
the "S" or "on" position.
- c. If proof round fails to fire when activated:
1. Pull large knob on side of proofing device and hold (black handle).
 2. Pull firing button on side of proofing device (black button)
 3. If fails to fire second time, wait on (1) minute before opening
steel doors to remove shell.

PROCESS CONTROL INSPECTION RECORD THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES	Revision Date: 22-Nov-05	Processed by:
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Part No:

Operation No: 600

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600R

Proof Test with slave bolt

NOTE: This operation is intended for use only when directed by Gallery Supervision or Assembly Engineering to accommodate ammunition and other problems.

Remove rifle from truck, remove rod from bore and position rifle in proof fixture.

Load and fire (1) one service round through action.

Operate bolt release and remove original bolt assembly.

Place slave bolt assembly in action.

Place original bolt assembly aside in holder.

Push safety to "Fire" position & cycle slave bolt assembly once to insure operability in action.

Firing Pin should not follow-down and action must not fire when the safety is released (FD, FSR.)

Load proof round into chamber and close the action.

Close device doors and proof the rifle.

If proof round fails to fire, wait 1-minute and extract with original bolt assembly.

Open device doors, return safety to "Safe" position.

Open the slave bolt and remove it from the action.

Place slave bolt assembly in holder.

Operate the original bolt to engage the fired case for extraction and ejection.
If original bolt fails to engage the fired case, remove it with a rod down the bore.

Remove the rifle from device, stamp "REP" proof mark if gun passes.
Do NOT mark the bolt handle with a prick-punch.

Return rifle to gun truck and continue with succeeding rifles.

PROCESS CONTROL INSPECTION RECORD				Revision Date: 7-Sep-05		Processed by							
THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL													
Part No:		Part Name: Fin Assy 700 ADL		Centerfire Rifle		Date: 8/14/2006							
Operation No: 600R		Operation: Proof Test with slave bolt				Work Center:							
Prod. Qty:		Prod. Order #:		Operator			Setup inspected by & Date:						
Gage Description and Characteristic		Gage Number		Gage Frequency		1st Shift		2nd Shift		3rd Shift		Remarks, Causes, Action Taken, Etc.	
VISUAL		VISUAL		100%		INSPECT							
						REJECT							
						INSPECT							
						REJECT							
						INSPECT							
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						REJECT							
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						INSPECT							
						REJECT							

~~Remove~~ original bolt assembly from holder and insert in rifle.

Operate the original bolt to engage the fired case for extraction and ejection.

Remove the rifle from device, stamp "REP" proof mark if gun passes.

Return rifle to gun truck and continue with succeeding rifles.

PROCESS CONTROL INSPECTION RECORD				Revision Date: 7-Sep-05		Processed by	
THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL							
Part No:		Part Name: Fin Assy 700 ADL		Centerfire Rifle		Date: 8/14/2006	
Operation No: 600R		Operation: Proof Test with slave bolt				Work Center:	
Prod. Qty:		Prod. Order #:		Operator		Setup Inspected by & Date:	
Gage Description and Characteristic		Gage Number	Gage Frequency	1st Shift	2nd Shift	3rd Shift	Remarks, Causes, Action Taken, Etc.
VISUAL		VISUAL	100%	INSPECT			
				REJECT			
				INSPECT			
				REJECT			
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PROCESS CONTROL INSPECTION RECORD THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES		Revision Date: 22-Nov-05	Processed by:
Part No:	Part Name: Fin Assy 700 Pol	Centerfire Rifle	Date: 8/14/2006
Operation No: 600R	Operation: Proof Test with slave bolt		Work Center:

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Prod. Qty.	
Page Description and Unit Price	

Order - William

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605R Check Repaired Guns Returning to Gallery for
Proof Stamp and Obstruction In Barrel.

Operation Step Detail Operation: 605R

Step Operation / Step Description

Check previously rejected guns for proof stamp and obstruction in barrel.

PROCESS CONTROL INSPECTION RECORD THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES			Revision Date: 22-Nov-05			Processed by:	
Part No:		Part Name: Fin Assy 700 Pol		Centerfire Rifle		Date: 8/14/2006	
Operation No: 605R		Operation: Check Repaired Guns Returning to Gallery for				Work Center:	
Prod. Qty:		Prod. Order #:		Operator		Setup Inspected by & Date:	
Gage Description and Characteristic	Gage Number	Gage Frequency	1st Shift	2nd Shift	3rd Shift	Remarks, Causes, Action Taken, Etc.	
VISUAL	VISUAL	100%	INSPECT				
			REJECT INSPECT				
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606 Test and Target 100%

Operation Step Detail Operation: 606

Step	Operation / Step Description
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NOTE: Re-chamfer muzzle on all rifles on each load BEFORE targeting to insure that the bullet exits the barrel in a smooth chamfer that is concentric and perpendicular to the bore. The chamfer must be deep enough to apply a .020 minimum break at the bore's edge and clean up any deformity at the end of each rifling land. Chamfering must be done with the piloted tool listed in the Tooling Section.

Gallery Test-Procedure and Specifications

Safety before Test: All plant rules, gallery rules and job safety key points are to be observed at all times.

I. RIFLES TESTED AND TARGETED

- A. All rifles (100%) are to be tested after proof.
- B. 100% of Police rifles are to be targeted.
- C. Record results of testing in computer as test and target operations are performed.

II. TEST AND TARGET OBJECTIVES

- A. Function: To check the ability of each rifle to satisfactorily load, feed, close, lock, fire, unlock, open, extract, eject and

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for proper operation of the Safety.

- B. Accuracy: To check the ability of each rifle to satisfactorily meet specifications for point of impact and/or group size.
- C. Visual: To check the ability of each rifle to satisfactorily meet appearance specifications for front and rear sights and general overall presentability.

III. SHOOTING JACKS AND DEVICE

- A. When performing an accuracy evaluation on a rifle use the accuracy device.
 - 1. Adjust and set device with master rifle if the caliber and model to be shot is produced with iron sights.
 - 2. Use 1" by 1" grid type targeting paper.
- B. When performing a function test, either the accuracy device or a centerfire shooting jack can be used.
 - 1. If a shooting jack is used, complete function test on entire truck. Then push the truck back to an accuracy device to target 100%.

IV. DESCRIPTION OF TEST AND TARGET PROCEDURES AND SPECIFICATIONS:

NOTE: The first rifle tested and targeted is to be left off of truck so there will be an open space between tested and untested rifles. Place first rifle back on truck when the entire load has been completed.

A. Test/Target Description

- 1. Pick up rifle from truck and inspect for:
 - a. Live Ammo - Inspect chamber and Magazine-both must be empty.
 - b. Caliber - To verify for shooter personal safety in

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- selecting ammunition for test.
- c. Proof mark on Barrel - (REP) must be present, right rear side of barrel, ahead of Magnaflux stamp.
 - d. Proof mark on Bolt - (.) Prick punch mark must be present at bottom of Bolt handle.
 - e. Visual Defects - Marring of wood or metal finishes.
- If not within specifications for items a-e above, reject guns at this point.
- 2. With safety in "F" or "OFF" position close Bolt crisply on empty chamber. Rifle must be pointed in safe direction at all times.
 - a. Firing pin must not follow down as Bolt cams shut.
 - b. Must not fire on closings.
 - 3. With Safety in "S" or "on" position and the action closed, raise the bolt.
 - a. Bolt must raise or open without excessive force.
 - 4. Close Bolt with safety in "'S" or "on" position - pull trigger firmly.
 - a. Rifle must not fire
 - 5. With finger off Trigger-move safety to "F" or "OFF" position.
 - a. Rifle must not fire.
 - 6. Open and close Bolt full stroke to cock firing pin.
 - 7. Move Safety to full rear "S" or "ON" position and then move half way to the "F" or "OFF" position with thumb.

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8. If safety stops at half-way position-pull trigger.
 - a. Rifle must not fire.
 - b. Safety must not move to full "OFF" or "FIRE" position.
9. If safety stops in half-way position, move safety to "F" or "OFF" position after pulling trigger.
 - a. Rifle must not fire.

IMPORTANT-Perform Items 2-9 above, a total of three (3) times per gun.

10. Move safety to "S" or "ON" position.

NOTE: Steps 11-12 pertain to guns being tested on accuracy device.

11. With Action open, position rifle in device and clamp.
12. For first rifle of a new caliber remove the bolt and lock through bore to line up device with paper.
13. Load Magazine to capacity: (see chart below)
 - a. Magazine must accept total rounds specified.
 - b. Cartridges must be retained by rails in receiver.
 - c. Load magazine to capacity: (see chart below)

CALIBER	AMMUNITION TYPE	MAG. CAP
223 Rem	62 gr. HP MATCH	5
308	168 gr. BT HP MATCH	4
300 SAUM	180 gr. PSP	3
300 Wir. Mag.	190 gr. EXTENDED RANGE BT	3

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- f. Push full magazine up into trigger guard until the two latches catch. Magazine must latch with normal pressure.
- 14. Fold cartridges down in Magazine, start Bolt over Cartridge column and close Bolt on empty chamber.
 - a. Bolt must close over full magazine with normal pressure.
- 15. Open Bolt full stroke to rear position.
- 16. Close guard. (If on accuracy device)
- 17. Close Bolt to feed shell into chamber and lock to start test.
 - a. Must feed single (1) shell with each operating stroke of Bolt.
 - b. Must not double feed.
 - c. Shells must not stem chamber or magazine. (Bind inside receiver or barrel.)
 - d. Bolt must not override shell in magazine.
 - e. Bolt must feed shell into chamber with normal pressure.
 - f. If, using normal force, the Bolt will not close over a live round in the chamber, perform the following test:
 - 1. Insert the appropriate close hard plug into the chamber while the rifle is held in the test device. (see Tool Detail Section for list of close hard plugs)
 - 2. Close and operate bolt:
 - a. If bolt closes hard over the plug, reject the rifle for Close Hard and record the malfunction in the computer and attach the slip to the rifle.
 - b. If bolt closes with normal pressure, do not reject the rifle. This indicates oversize ammunition.
- 18. Move safety to "F" or "OFF" position.

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19. If using accuracy device fire rifle by pushing (2) two buttons on device simultaneously. If using shooting jacks, grip rifle in normal manner and pull trigger with finger.
20. For the 100% of Police rifles that are targeted, check each shot with spotting scope for rifle "seating in" and position of shots on paper. Use a maximum of 3 "seater" rounds per rifle.
 - a. Adjust device if shots off paper or group too close to edge.
21. Operate action full cycle to extract, eject, and feed each shot.
 - a. Bolt should not pull out of receiver.
 - b. Case or shell must be retained by extractor until the case is ejected from receiver.
 - c. Case must be completely ejected from receiver, should not catch on receiver.
 - d. One fired case from each rifle must be visually inspected for firing pin indent and chamber marks reflected on case. Slight rings are permissible; if ring is large enough to pick with fingernail, reject the rifle.
22. Fire all rounds required for Test and Targeting.
 - a. For the Test procedure, each rifle is to have the first two (2) rounds fired and the remaining rounds cycled through but not fired.
 - b. For the Target procedure, all accuracy specifications are based on groups consisting of 5 shots, therefore, those rifles will typically require extra rounds to be loaded and shot singly. See chart below for acceptable group sizes.

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23. Open guard. (If on accuracy device)
24. For the Targeted rifles (100+ Police)
 - a. Use spotting scope to check group size.
 - b. Maximum spread of the two extreme holes must be within group size specifications listed below.

GROUP SIZE SPECIFICATIONS

MAX. GROUP CENTER TO CENTER		
CALIBER	AMMUNITION TYPE	5 SHOT GROUP
223 Rem(1/9 twist)	62 gr. HP MATCH	1.5
308 Win.	168 gr. BT HP MATCH	1.5
300 Win. Mag.	180 gr. PSPCL - 190 gr. PSPCL	2.5
300 Rem Ultra Mag	180 gr. PSPCL	2.5
300 SA Ultra Mag	180 gr. PSPCL	2.5
6.8mm Rem.	115 gr. HPBT	1.5
7MM Rem. Mag.	140 gr. PSP BT	2.5

25. Unclamp and remove rifle from device. (If on accuracy device)
26. Inspect chamber and magazine for live ammunition.
 - a. Chamber must be empty.
 - b. Follower must be visible.
27. Pass all rifles that meet specifications for:
 - a. Visual

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- b. Functional
- c. Group size

28. Reject all rifles that do not meet specifications:

- a. Enter all malfunctions into the computer and place white repair ticket on rifle.
- b. If a rifle fails to meet the target group size specifications, reject that rifle and target all remaining rifles on the truck.

29. Place rifle back on truck.

30. Repeat Test on next and succeeding rifles.

- a. Target Police 100%

V. SAFETY AFTER TEST

A. Open Bolt

- 1. Move Bolt to open position before removing rifle from accuracy device.

B. Inspect Chamber and Magazine for live ammunition.

- 1. Rifle must be empty.
- 2. Follower must be visible.

NOTE: Perform "A" & "B" above on each individual rifle immediately after shooting test. Repeat "B" for all rifles on truck at completion of test.

C. Visual Inspect for marring by device or port.

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- C. Check all rifles from each side of truck, after test, and check for any possible damage to rifle from the test.
- D. All rifles are moved to Ammunition Inspection Area.

Operation Procedure Notes

Operation: 606

Description

NOTE:

1. .308 POLICE DM (1/12 TWIST) TO SHOOT 165 gr. BT HP MATCH AMMO.
2. .223 REM (1/9 twist) to shoot 60 gr. HP MATCH AMMO.
3. 7mm. Rem. Mag. (1/9 1/4 twist) to shoot 140 gr. P3E BT ammo.

Operation Tool Detail

Operation: 606

Tool Number

Tooling Description

Muzzle Chamfer Tools

B-73740	Countersink Tool with "T" handle
B-51634-W	Countersink Pilot - 30 caliber (all)
B-51634-V	Countersink Pilot - 270 Win
B-51634-U	Countersink Pilot - 25-06 Rem
B-51634-T	Countersink Pilot - 22 caliber (all CF)
B-51634-S	Countersink Pilot - 35 caliber (all)
B-51634-R	Countersink Pilot - 22 caliber (all RF)
B-51634-Q	Countersink Pilot - 6mm Rem / 243 Win
B-51634-P	Countersink Pilot - 7mm (all) / 280 Rem
B-51634-N	Countersink Pilot - 264 Win / 6.5mm (all)
B-51634-M	Countersink Pilot - 8mm Rem Mag
B-51634-L	Countersink Pilot - 338 (all)

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Plugs

The following is a list of all Close Hard Plugs used during
test and target in gallery: (POLICE CAL MARKED *)

CALIBER	USE CLOSE HARD PLUG
7MM REM MAG.	C-46200-B
300 WIN. MAG.	C-46200-A
.223 REM.*	C-46198 OR D-48349-C
308 Win.	C-46194 OR D-48349-H
6.8mm Rem. ITR	
300 S/A ULTRA MAG.	
300 ULTRA MAG.	D-48349-T

(Close Hard Plug Storage Cabinet is D-46202)

PROCESS CONTROL INSPECTION RECORD				Revision Date:		Processed by:	
THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES				22-Nov-05			
Part No:	Part Name: Fin Assy 700 Pol		Centerfire Rifle			Date: 8/14/2005	
Operation No: 606	Operation: Test and Target 100%					Work Center:	
Prod. Qty:	Prod. Order #:	Operator			Setup Inspected by & Date:		
Gage Description and Characteristic	Gage Number	Gage Frequency	1st Shift	2nd Shift	3rd Shift	Remarks, Causes, Action Taken, Etc.	
VISUAL	VISUAL	100%	INSPECT				
			REJECT				
			INSPECT				
			REJECT				

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620 ~~Inspect For Live Ammunition~~

Operation Step Detail Operation: 620

Step Operation / Step Description

Inspect for live ammunition

Inspect rifle for live ammunition before leaving
Gallery. Chamber must be empty and follower visible.

PROCESS CONTROL INSPECTION RECORD THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES			Revision Date: 22-Nov-05			Processed by:	
Part No:	Part Name: Fin Assy 700 Pol		Centerfire Rifle			Date: 8/14/2006	
Operation No: 620	Operation: Inspect For Live Ammunition					Work Center:	
Prod. Qty:	Prod. Order #:	Operator			Setup inspected by & Date:		
Gage Description and Characteristic	Gage Number	Gage Frequency	1st Shift	2nd Shift	3rd Shift	Remarks, Causes, Action Taken, Etc.	
VISUAL	VISUAL	100%	INSPECT				
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640 Final Inspection

Operation Step Detail Operation: 640

Step Operation / Step Description

FINAL INSPECTION

SEQUENCE OF INSPECTION POINTS (See Following)

1. SAFETY
2. STAMPS
3. SPECIFICATIONS
4. GUN GRADES
5. STOCK
6. METAL PARTS, FINISH
7. SAFE
8. STAMP DATE CODE ON BARREL AT LEFT-REAR OF BARREL, JUST AHEAD OF RECEIVER. (PASSED GUNS)

1. SAFETY
 - a. Inspect chamber and Magazine
 1. NO LIVE AMMUNITION
 2. Must See Follower

NOTE: WIPE BORE WITH BRASS CLEANING ROD & CLEANING PATCH SOAKED IN
REM OIL

- 2 STAMPS
 - a. On Barrel
 1. Proof (Rep) - On Right Side Rear

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2. Magnaflyx - Triangle with Number - Center Right Side of Breech
 - A. Visible Above Stock

3. SPECIFICATIONS

a. Gun Matches Tag

b. Receiver Marking:

1. Remington Model and Serial No., On Left Side
2. Model No. MUST Be Recognizable

c. Barrel Marking:

1. Patent & Cal. On Left Side -- (Cal. per Gun Tag)

d. Bolt Marking:

1. Remove Bolt
2. Check Bolt Release
 - A. MUST Be Free
3. Check Serial #
 - A. MUST Agree with Receiver #
4. Check for Marks
5. Check for Finish
6. Check for Brass in Bolt Head
7. Check for Proof Mark On Undersize of Bolt Handle
8. Check for Extractor in position
 - A. Only Extractor Claw Should Be Visible

4. GUN GRADES

a. BDL

5. STOCK

a. Inspect for Handling Damage

1. Max Allowance for Stock - Rec Gap at Tang is .030"
2. Trigger Guard & Floor Plate Stock Opening May Be Excessive but MUST Be Uniform, NOT Jagged
3. Inspect Floor Plate for:
 - A. Marks
 - B. Finish
 - C. Proper Function

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- D. Trigger Guard Screws Tight
- E. Assemble Correct Rear Swivel - If Specified on Gun Tag
- b. Stock Rejects only:
 - 1. Place 3/4" Yellow Dot with Identification Stamp and Nonconformity Code, Close to Nonconformity on Stock Rejects

Check for Barrel Float and position in Stock

=====

These two clearance checks are to be done with the Stock assembled to the action, Barrel Bracket back against the aluminum bedding Stock surface and Guard Screws tightened normally.

Free float Barrel clearance:

A 1" wide by .010" thick plastic shim, located around the underside of the Barrel, must move freely the entire length of the fore-end back to the front face of the Barrel Bracket.

Side-to-side centrality of fore-end (typically @ front):

SUPPLIER FURNISHED, HEAVY BARREL, SYNTHETIC STOCKS ONLY --
(H-S PRECISION, ETC.)

Check the fit between the Barrel and the barrel channel in the Stock. The Barrel should "float" and be positioned centrally in the barrel channel.

- a. If the Barrel appears to be central with respect to the channel, no further action is needed. Continue with the subsequent steps.
- b. If the Barrel appears off-center, favoring one side or the other, it will be necessary to check the clearance between the Barrel and the Stock to see if it is within specs.

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SPECIFICATION: At a distance of 9 1/2" from the front of the Barrel Bracket, the Barrel must be NO CLOSER than .032 and NO FURTHER than .076 with respect to the side of the Stock channel.

c. PROCEDURE: On the close side, a .032 feeler (shim) MUST GO between the side of the Barrel and the Stock. The feeler should stand unsupported between the Barrel and the Stock. On the far side, a .076 feeler MUST NOT GO.

- If the feeler test is successful, continue with subsequent steps.
- If the assembly does not pass the feeler test, reject the rifle.

NOTES: This procedure is done 9 1/2" from the face of the Barrel Bracket. The measurement point is approximately 1 1/2" in from the front tip of the Stock, about where the bedding pad is found on other models. The checks are invalid closer to the Receiver. Do not force the feeler gage.

- 6 METAL PARTS, FINISH
- a. Front Sight Bead Not Jammed
 - b. Sights MUST Be Central
 - c. Slight Marks per Inspection Standards ONLY
 - d. Crown Good Finish
 - 1. Accept 1/16" Light Ring at Bore
 - 2. Uniform Wall
 - e. Action:
 - 1. Operate Bolt 3 times and Fire
 - A. No Bind
 - B. Bolt Handle Raises and Lowers Easily
 - 2. Open and Close Bolt Forcibly 3 Times
 - A. Firing Pin MUST Not Follow Down
 - f. Check for Jar Off
 - 1. Place Safety in "F" or "Off" Position
 - 2. Applying Steady Pressure on End of Firing Pin Head Using End of

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Hammer Handle

SAFE

Gun cocked:

a. Clean Sharp Single Detent

1. TRY TRIGGER THREE TIMES WITH SAFETY IN "S" OR "ON" POSITION

A. MUST NOT FIRE WITH HEAVY TRIGGER PRESSURE

B. TRIGGER MUST RETRACT

2. PUSH SAFETY HALFWAY TO THE "F" OR "OFF" POSITION

A. PULL TRIGGER

B. MUST NOT FIRE

3. PUSH SAFETY TO "F" OR "OFF" POSITION

A. FIRING PIN MUST NOT FOLLOW DOWN

B. SAFETY MUST RETURN TO OFF POSITION UNDER TENSION

C. USE DOWNWARD PRESSURE ON SAFETY

D. Bolt handle must unlock with safety ON

E. Safety should snap in detent in both "ON" and "OFF" position

b. Check Trigger Pull parallel with action

1. NO Creep (4.75 to 5.75 lbs. on M/700)

A. Any rifles outside of the specified range must be diverted to operation 648
for adjustment and then returned.

B. Upon return perform all elements of this step.

Try (3) Times

NOTE: Perform Monthly check on Trigger Pull scale to verify accuracy.

Follow procedure below using at least two different weights.

a. Slowly lift dead weight off bench using trigger pull scale.

b. Slowly return weight to bench and read scale.

- Measurement must be within 1/8 lb of actual dead weight.

c. If scale is not within above specification for any of the measured dead weights;

- send scale to Gage Inspection for Re-Calibration.

2. Check for Trigger Clearance In Guard and Floor Plate

A. Must Not Bind

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- B. Trigger Must Not Be Exposed Outside of Guard
- C. A (.030) Shim Must Fit Between End of Trigger and Inside of Guard Bow with Trigger in Full Rearward or Relaxed Position
- c. Open Bolt and Place Safety in "On" Position
 - 1. Close Bolt and Lock Down
 - A. Bolt MUST Lock Down Without Catching Safety
 - B. Bolt MUST Open with Safety "On"

8 STAMP DATE CODE ON BARREL AT LEFT REAR OF BARREL, JUST AHEAD OF RECEIVER. (PASSED GUNS)

Operation Tool Detail Operation: 640

Tool Number	Tooling Description
C-47444	DRAWING - LISTING DATE CODE STAMPS
STD	Nylon Cleaning Rod 3/16" Delrin rod approx. 36" long.
STD	Cleaning Patches (Hoppes or equiv.)
STD	Rem Oil
BTS-7300	Wood Dents & Scuff Template
STD	Dummy Cartridge Rounds of proper Caliber being built.
B-70697	Trigger Pull - Scale
A-43977	Trigger clearance shim tool (.030)
Std	.032 Feeler Gage - Plastic
Std	.076 Feeler Gage - Plastic

PROCESS CONTROL INSPECTION RECORD		Revision Date:	22-Nov-05	Processed by:
THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES				
Part No:	Part Name: Fin Assy 700 Pol	Centerfire Rifle	Date:	8/14/2006

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Operation No: 640		Operation: Final Inspection				Work Center:	
Prod. Qty:		Prod. Order #		Operator		Setup inspected by & Date:	
Gage Description and Characteristic	Gage Number	Gage Frequency	1st Shift	2nd Shift	3rd Shift	Remarks, Causes, Action Taken, Etc.	
VISUAL	VISUAL	100%	REJECT INSPECT				
Wood Dents & Scuff Template	BTS-7300	100%	REJECT INSPECT				
Dummy Cartridge Rounds of proper Caliber being built.	STD	100%	REJECT INSPECT				
Trigger Pull - Scale	B-70697	100%	REJECT INSPECT				
Trigger clearance shim loc: (.030)	A-43977	100%	REJECT INSPECT				
.032 Feeler Gage - Plastic	Std	100%	REJECT INSPECT				
.076 Feeler Gage - Plastic	Std	100%	REJECT INSPECT				
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Reset trigger pull within specs as needed.
(Not done on 100% of the product)

Reset Trigger Pull to within 4.75 to 5.75 pounds on rifles returned from Final Inspection

NOTE: Check trigger pull "over-the-comb" of the stock with the pull scale parallel with the action as seen from above. Use slow even force to insure accuracy and repeatability.

Try (3) Times

NOTE: Perform Monthly check on Trigger Pull scale to verify accuracy. Follow procedure below using at least two different weights.

- Slowly lift dead weight off bench using trigger pull scale.
- Slowly return weight to bench and read scale.
 - Measurement must be within 1/8 lb of actual dead weight.
- If scale is not within above specification for any of the measured dead weights:
 - send scale to Gage Inspection for Re-Calibration.

- Clamp rifle in vise and remove takedown screws and stock assembly.
- Locate adjusting screw (front edge, nearest to trigger) and break the Duco Cement seal.
- Rotate action in vise so top side is up.
- With a small, flat-blade screw driver, adjust the trigger pull.
 - Turn screw clockwise to increase poundage, counterclockwise to decrease.

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- b. Do not break the seal on, or tamper with the other 2 screws.
5. Redcheck the trigger pull with the pull scale.
 - a. Hold the pullscale parallel with the action.
 - b. Adjust again if necessary.
6. Apply Duro Cement to re-seal the adjustment screw.
 - a. Avoid runs, apply only enough to make an effective seal.
 - b. Allow a few seconds for cement to "skin" over.
7. Invert the action in the vise so bottom side is up.
8. Insert Magazine Spring with follower and re-assemble the stock assembly.
 - a. Properly torque the takedown screws.
9. Return rifle to Final Inspection.

Gages:

B-70697

Trigger Pull Scales

PROCESS CONTROL INSPECTION RECORD			Revision Date: 7-Sep-05			Processed by:
THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL						
Part No:	Part Name: Fin Assy 700 ADL		Centerfire Rifle			Date: 8/14/2006
Operation No: 648	Operation: Reset trigger pull within specs as needed.					Work Center:
Prod. Qty:	Prod. Order #:	Operator			Setup Inspected by & Date:	
Gage Description and Characteristic	Gage Number	Gage Frequency	1st Shift	2nd Shift	3rd Shift	Remarks, Causes, Action Taken, Etc.
VISUAL	VISUAL	100%	INSPECT REJECT	/	/	
			INSPECT REJECT	/	/	
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650 Inspect Heading and Sear Lift

Operation Step Detail Operation: 650

Step Operation / Step Description

Inspect Heading and Sear Lift

Inspect Heading

- 1 Insert Min Heading Plug in Chamber and Close Bolt
 - a. Must Close with No More than Slight Drag
 - b. Remove Heading Plug
- 2 Insert Inspection Max Plug in Chamber and Close Bolt
 - a. Bolt Must Stop or Lock with Noticable Pressure
 - b. Remove Heading Plug

Sear Lift Test

- 1 Remove Bolt
- 2 Place Safety in "F" Position
- 3 Pull Trigger Fully Rearward
- 4 Depress Sear Fully Down
- 5 Release Sear
 - a. The Sear MUST Return to its Fully UP Position Without Drag

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- b. If the Sear Binds or Drags, REJECT THE RIFLE - Mark Reject Reason on Reject Ticket
- 6 Release Trigger
- 7 Keep Safety in "F" Position
- 8 Insert Attribute Gage Fully Into Receiver
 - a. This MUST Stop on Sear
 - b. If Gage Goes In Fully (or Pin on Bottom Overrides Sear), REJECT THIS RIFLE - Mark Reject Reason on Reject Ticket
- 9 Remove Attribute Gage
- 10 Insert Dial Gage Fully into Receiver
 - a. Pin MUST Stop on Sear
- 11 Release Lever and Set Dial to Zero
- 12 Move Safety to "S" Position
- 13 Observe Dial - Lift MUST be .008/.018
 - a. Readings Outside of Range - REJECT THIS RIFLE - Mark Reject Reason on Reject Ticket
- 14 Remove Dial Gage

Operation Tool Detail

Operation: 650

Tool Number	Tooling Description
D-44581	Dial Gage Note: Use with 5/64 Balldriver Hex Tool Bondhus Cat.

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#10604, Series 106, or equivalent.

C-47741 Attribute Gage
C-41155-A 223 REM MIN Heading Plug
C-41155-C 223 REM IMAX Heading Plug
C-41556-A 308 WIN MIN Heading Plug
C-41556-C 308 WIN IMAX Heading Plug
C-41546-A 300 WIN MIN Heading Plug
C-41546-C 300 WIN IMAX Heading Plug
C-83853-A 300 Win BELT - MIN Heading Plug
C-83853-C 300 Win BELT - IMAX Heading Plug
C-41561-A 7MM Mag MIN Heading Plug
C-41561-C 7MM Mag IMAX Heading Plug
C-83853-A 7MM Mag BELT - MIN Heading Plug
C-83853-C 7MM Mag BELT - IMAX Heading Plug
C-35413-A 300 RUM MIN Heading Plug
C-35413-C 300 RUM IMAX Heading Plug
C-49963-A 300 SAUM MIN Heading Plug
C-49963-C 300 SAM IMAX Heading Plug

PROCESS CONTROL INSPECTION RECORD			Revision Date:			Processed by:		
THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES			22-Nov-05					
Part No:	Part Name:	Centerfire Rifle				Date:	8/14/2006	
Operation No: 650	Operation: Inspect Heading and Sear Lift					Work Center:		
Prod. Qty:	Prod. Order #:	Operator			Setup Inspected by & Date:			
Gage Description and Characteristic	Gage Number	Gage Frequency	1st Shift	2nd Shift	3rd Shift	Remarks, Causes, Action Taken, Etc.		
VISUAL	VISUAL	100%	INSPECT REJECT					

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			INSPECT			
Dial Gage	D-44581	100%	REJECT INSPECT			
Altitude Gage	C-47741	100%	REJECT INSPECT			
223 REM MIN Heading Plug	C-41155-A	100%	REJECT INSPECT			
223 REM IMAX Heading Plug	C-41155-C	100%	REJECT INSPECT			
223 REM MIN Heading Plug	C-41155-A	100%	REJECT INSPECT			
223 REM IMAX Heading Plug	C-41155-C	100%	REJECT INSPECT			
223 REM MIN Heading Plug	C-41155-A	100%	REJECT INSPECT			
223 REM IMAX Heading Plug	C-41155-C	100%	REJECT INSPECT			
223 REM MIN Heading Plug	C-41155-A	100%	REJECT INSPECT			
223 REM IMAX Heading Plug	C-41155-C	100%	REJECT INSPECT			
223 REM MIN Heading Plug	C-41155-A	100%	REJECT INSPECT			
223 REM IMAX Heading Plug	C-41155-C	100%	REJECT			

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			INSPECT			
308 WIN MIN Heading Plug	C-41556-A	100%	REJECT INSPECT			
308 WIN IMAX Heading Plug	C-41556-C	100%	REJECT INSPECT			
308 WIN MIN Heading Plug	C-41556-A	100%	REJECT INSPECT			
308 WIN IMAX Heading Plug	C-41556-C	100%	REJECT INSPECT			
308 WIN MIN Heading Plug	C-41556-A	100%	REJECT INSPECT			
308 WIN IMAX Heading Plug	C-41556-C	100%	REJECT INSPECT			
308 WIN MIN Heading Plug	C-41556-A	100%	REJECT INSPECT			
308 WIN IMAX Heading Plug	C-41556-C	100%	REJECT INSPECT			
308 WIN MIN Heading Plug	C-41556-A	100%	REJECT INSPECT			
308 WIN IMAX Heading Plug	C-41556-C	100%	REJECT INSPECT			
308 WIN MIN Heading Plug	C-41556-A	100%	REJECT INSPECT			
308 WIN IMAX Heading Plug	C-41556-C	100%	REJECT			

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			INSPECT			
308 WIN MIN Heading Plug	C-41556-A	100%	REJECT INSPECT			
308 WIN IMAX Heading Plug	C-41556-C	100%	REJECT INSPECT			
308 WIN MIN Heading Plug	C-41556-A	100%	REJECT INSPECT			
308 WIN IMAX Heading Plug	C-41556-C	100%	REJECT INSPECT			
308 WIN MIN Heading Plug	C-41556-A	100%	REJECT INSPECT			
308 WIN IMAX Heading Plug	C-41556-C	100%	REJECT INSPECT			
300 Win BELT - MIN Heading Plug	C-83853-A	100%	REJECT INSPECT			
300 Win BELT - IMAX Heading Plug	C-83853-C	100%	REJECT INSPECT			
300 Win MIN Heading Plug	C-41546-A	100%	REJECT INSPECT			
300 Win IMAX Heading Plug	C-41546-C	100%	REJECT INSPECT			
300 Win BELT - MIN Heading Plug	C-83853-A	100%	REJECT INSPECT			
300 Win BELT - IMAX Heading Plug	C-83853-C	100%	REJECT			

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			INSPECT			
300 Win MIN Heading Plug	C-41546-A	100%	REJECT INSPECT			
300 Win IMAX Heading Plug	C-41546-C	100%	REJECT INSPECT			
7MM Mag BELT - MIN Heading Plug	C-83853-A	100%	REJECT INSPECT			
7MM Mag BELT - IMAX Heading Plug	C-83853-C	100%	REJECT INSPECT			
7MM Mag MIN Heading Plug	C-41561-A	100%	REJECT INSPECT			
7MM Mag IMAX Heading Plug	C-41561-C	100%	REJECT INSPECT			
300 RUM MIN Heading Plug	C-35413-A	100%	REJECT INSPECT			
300 RUM IMAX Heading Plug	C-35413-C	100%	REJECT INSPECT			
			REJECT INSPECT			
			REJECT INSPECT			
			REJECT INSPECT			
			REJECT INSPECT			
			REJECT			

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655 Mark Bolt to Match Receiver Serial
 Number Using Dot Peen Marking Machine

Operation Step Detail Operation: 655

Step Operation / Step Description

Mark Bolt to Match Receiver Serial Number Using
Dot Peen Marking Machine

- 1 Load Program 700BOLT
- 2 Input Last Four Digits ONLY of Gun Serial Number
- 3 Remove Bolt from Gun
- 4 Place Bolt in Fixture and Clamp
- 5 Press Start to Mark Bolt
- 6 Remove Finished Bolt
- 7 Replace Bolt in Gun
- 8 Place Gun Back On truck

Operation Tool Detail Operation: 655

Tool Number

Tooling Description

40789

Dot Peen Marker

A-51082

Stylus

~~ETS-7583~~

Holding Fixture

Remington Arms Company, Inc. • Illion, New York

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670 Send Rifle to Custom Shop for Accuracy Enhancement

Operation Step Detail Operation: 670

Step Operation / Step Description

PROCESS CONTROL INSPECTION RECORD			Revision Date: 22-Nov-05			Processed by:
THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES						
Part No:	Part Name: Fin Assy 700 Pol		Centerfire Rifle			Date: 5/14/2006
Operation No: 670	Operation: Send Rifle to Custom Shop for Accuracy Enhancement					Work Center:
Prod. Qty:	Prod. Order #:	Operator			Setup Inspected by & Date:	
Gage Description and Characteristic	Gage Number	Gage Frequency	1st Shift	2nd Shift	3rd Shift	Remarks, Causes, Action Taken, etc.
VISUAL	VISUAL	100%	INSPECT			
			REJECT			
			INSPECT			
			REJECT			
			INSPECT			
			REJECT			
			INSPECT			
			REJECT			

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676 Pack Rifle
 To Warehouse

Operation Step Detail Operation: 676

Step Operation / Step Description

Print Box End label and Pack Rifle

1. Log onto Computer (Start of shift).
2. Type in index number (RAMAC) of rifle model currently being inspected.
3. Oil bore of rifle just inspected.
4. Wipe exterior metal parts with oily rag. Only a light coating of oil should be left. Wipe stock clean of smudges and fingerprints using a clean cloth.
5. Remove VC-687-1 Naltex Vinyl Cap from Bolt Handle and save for return to Assembly.
6. Type in Serial Number of gun. Type in Serial Number of gun 2nd time for verification.
7. Apply printed labels and UPS code label to:
 - a) Owners Manual (Label)
 - b) Side of Box (Label)
 - c) End of Box (UPS Label)

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8. Remove VGN Tape for European Sales
9. Remove Bolt assy. from rifle, verify last 4 digits of serial # that is marked on Bolt assy., and pack bolt assy.
10. Pack Rifle into Box.
11. Place Owners Manual in box over Stock
12. Seal Box using reinforced packing tape.
13. Place Box onto conveyor to travel to the warehouse.

Operation Tool Detail

Operation: 676

Tool Number	Tooling Description
D-43447	Rod
Std	Clean White Cloth Wipes
	Packaging Box Assembly
A-P-1233 1233	Reinforced Packing Tape - 16"x1/2" - 3M #898
Std	Shell Solvent
Std	Steelgard

PROCESS CONTROL INSPECTION RECORD		Revision Date:	22-Nov-05	Processed by:
THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES				
Part No:	Part Name: Fin Assy 700 Pol	Centerfire Rifle	Date:	8/14/2006
Operation No: 676	Operation: Pack Rifle	Work Center:		

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Prod. Qty.	
Page Description and Unit Price	

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Pieces Run

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Dept	Oper	Operation Description	Part Numbers
9132	1	Issue from Crib	25743 25744 25745 25746 25707 25709 25715 25747 25726 25714 25717 25713 25718 25735 25711 25737 25739 25712 25681 26175 26177 26179 26181 25635 25677 25657 25639 27503 27223
8761	395	INSPECT COMPONENTS BEFORE HEADING	25743 25744 25745 25746 25707 25709 25715 25747 25726 25714 25717 25713 25718 25735 25711 25737 25739 25712 25681 26175 26177 26179 26181 25635 25677 25657 25639 27503 27223
8761	400	Fit and Head Bolt Assembly to Barrel Assembly (SHOULDER SINGLE PASS)	25744 25746 25747 25709 25715 25712 25713 25739 25711 26175 26177 26179 26181 25635 25735 25681 25677 25657 25639 27503 27223
8761	405	Fit and Head Bolt Assembly to Barrel Assembly (SHOULDER SINGLE PASS: Smaller than .25 caliber)	25743 25745 25714 25707 25737
8761	415	Fit and Head Bolt Assembly to Barrel Assy and Chamber to Length (BELTED - MAGNUMS)	25717 25718 25726
8761	420	Ream Chamber to Deburr (BELTED - MAGNUMS)	25717 25718 25726
8761	425	Make Chamber Cast (Not Done on 100% of Product)	25743 25744 25745 25746 25707 25709

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Dept	Oper	Operation Description	Part Numbers
			25715 25747 25726
			25714 25717 25713
			25718 25735 25711
			25737 25739 25712
			25681 26175 26177
			26179 26181 25635
			25677 25657 25639
			27503 27223
8761	430	Ream Ejector Hole	25743 25744 25745
			25746 25707 25709
			25715 25714 25717
			25713 25718 25735
			25737 25739 25747
			25711 25712 25726
			25681 26175 26177
			26179 26181 25635
			25677 25657 25639
			27503 27223
8761	432	Assemble Riveted Extractor to Bolt - (MAGNUMS)	25717 25718 25735
			25726 25681
8761	435	Assemble Rivetless Extractor to Bolt	25743 25744 25745
			25707 25709 25715
			25714 25713 25746
			25737 25739 25747
			25711 25712 26175
			26177 26179 26181
			25635 25677 25657
			25639 27503 27223
8761	440	Assemble Ejector to Ejector Spring and then Assemble to Bolt with Ejector Cross Pin	25743 25744 25745
			25746 25707 25709
			25715 25714 25717
			25713 25718 25735
			25737 25739 25747
			25711 25712 25726
			25681 26175 26177
			26179 26181 25635
			25677 25657 25639
			27503 27223
8761	460R	Strip Defective Barrel Assembly Complete	25743 25744 25745
			25746 25707 25709
			25715 25747 25726

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Dept	Oper	Operation Description	Part Numbers
			25714 25717 25713
			25718 25735 25711
			25737 25739 25712
			25681 26175 26177
			26179 26181 25635
			25677 25657 25639
			27503 27223
8761	465R	Strip Defective Bolt	25743 25744 25745
			25746 25707 25709
			25715 25747 25726
			25714 25717 25713
			25718 25735 25711
			25737 25739 25712
			25681 26175 26177
			26179 26181 25635
			25677 25657 25639
			27503 27223
8761	580	Assemble Action	25743 25744 25745
			25746 25707 25709
			25715 25714 25717
			25713 25718 25735
			25737 25739 25747
			25726 25681 26175
			26177 26179 26181
			25677 25657 25639
			27503 27223
8761	581	Assemble Action	25712 25711 25635
8761	583	Assemble Stock to Action and Attach Build to Tag to Barrel (DM)	25715 25717 25713
8761	585	Assemble Stock to Action & Attach Hang Tag to Trigger Guard	25743 25744 25745
			25746 25707 25709
			25714 25718 25735
			25737 25739 25747
			25726 25681 26175
			26177 26179 26181
			25677 25657 25639
			27503 27223
8761	586	Assemble Stock to Action and Attach Build to Tag to Barrel	25712 25711 25635

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Dept	Oper	Operation Description	Part Numbers
8785	588	PROOF TEST	25712 25711 25635
8488	590	ASSEMBLE TRS SCOPE BASE, SCOPE RINGS, & TELESCOPE WITH LENS COVERS TO GUN	25712 25711 25635
8761	593	Assemble Front Swivel Screw and Swivel Screw Spacer to Stock	25743 25744
8488	594	FUNCTION TEST(100%) AND TARGET(100%)	25712 25711 25635
8786	595	Mark Bolt to Match Receiver Serial Number Using Dot Peen Marking Machine	25712 25711 25635
8786	596	INSPECT FOR LIVE AMMUNITION	25712 25711 25635
8786	597	CLEAN AND INSPECT	25712 25711 25635
8786	598	PACK RIFLE AND DELIVER TO WAREHOUSE	25712 25711 25635
8785	600	Proof Test	25743 25744 25745 25746 25707 25709 25715 25714 25717 25713 25718 25735 25737 25739 25747 25726 25681 26175 26177 26179 26181 25677 25657 25639 27503 27223
8785	600R	Proof Test with slave bolt	25743 25744 25745 25746 25707 25709 25715 25714 25717 25713 25718 25735 25737 25739 25747 25726 25681 26175 26177 26179 26181 25712 25711 25635 25677 25657 25639 27503 27223
8785	605R	Check Repaired Guns Returning to Gallery for Proof Stamp, Pick Punch and Obstruction In Barrel	25743 25744 25745 25746 25707 25709 25715 25714 25717 25713 25718 25735 25737 25739 25747 25726 25681 26175

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Dept	Oper	Operation Description	Part Numbers
			26177 26179 26181
			25677 25657 25639
			27503 27223
8785	606	Test and Target 1003	25743 25744 25745
			25746 25707 25709
			25715 25714 25717
			25713 25718 25735
			25737 25739 25747
			25726 25681 26175
			26177 26179 26181
			25677 25657 25639
			27503 27223
8785	620	Inspect For Live Ammunition	25743 25744 25745
			25746 25707 25709
			25715 25714 25717
			25713 25718 25735
			25737 25739 25747
			25726 25681 26175
			26177 26179 26181
			25677 25657 25639
			27503 27223
8786	640	Final Inspection	25743 25744 25745
			25746 25707 25709
			25715 25714 25717
			25713 25718 25735
			25737 25739 25747
			25726 25681 26175
			26177 26179 26181
			25677 25657 25639
			27503 27223
8761	648	Reset trigger pull within specs as needed - not done on 100% of the product	25743 25744 25745
			25746 25707 25709
			25715 25714 25717
			25713 25718 25735
			25737 25739 25747
			25726 25681 26175
			26177 26179 26181
			25677 25657 25639
			27503 27223
8786	650	Inspect Heading and Sear Lift	25743 25744 25745
			25746 25707 25709

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Dept	Oper	Operation Description	Part Numbers
			25715 25714 25717
			25713 25718 25735
			25737 25739 25747
			25726 25681 26175
			26177 26179 26181
			25677 25657 25639
			27503 27223
8786	655	Mark Bolt to Match Receiver Serial Number Using Dot Peen Marking Machine	25743 25744 25745 25746 25707 25709 25715 25714 25717 25713 25718 25735 25737 25739 25747 25726 25681 26175 26177 26179 26181 25677 25657 25639 27503 27223
8488	670	Send Rifle to Custom Shop for Accuracy Enhancement	27223
8786	676	Pack Rifle To Warehouse	25743 25744 25745 25746 25707 25709 25715 25714 25717 25713 25718 25735 25737 25739 25747 25726 25681 26175 26177 26179 26181 25677 25657 25639 27503 27223

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Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
							RAMAC# RESCRIPTION
							25743 700 Pol - (Wood) - 223 REM - 24
							25744 700 Pol - (Wood) - 308 WIN - 24
							25745 700 Pol - (Syn) - 223 REM - 24
							25746 700 Pol - (Syn) - 308 WIN - 24
							25747 700 Pol - 308 WIN - Ltd LTRS - 20
							25714 700 Pol 1/9" Twist - 223 REM - 26
							25707 700 Pol 1/12" Twist - 223 REM - 26
							25709 700 Pol - (Syn) - 308 WIN - 26
							27223 700 Pol - (Syn) CS - 308 WIN - 26
							25713 700 Pol DM - (Syn) - 308 WIN - 26
							25717 700 Pol DM - (Syn) - 308 WIN MAG - 26
							25713 700 Pol DM URBAN - (Syn) - 308 WIN - 20
							25737 700 Pol Floor Plt 223 Rem LTR - 20
							25677 700 Pol Floor Plt 6.8MM Rem LTR - 20
							25681 700 Pol Floor Plt 300 SAUM LTR - 20
							25739 700 Pol Floor Plt 308 Win LTR - 20
							25657 700SS Pol Floor Plt 308 Win FL RB-20
							25639 700SS Pol Floor Plt 308 Win FL RB-26
							25726 700 Pol Floor Plt 7mm Rem Mag - 26
							25718 700 Pol Floor Plt 300 Win Mag - 26
							25735 700 Pol Floor Plt 300 Ultra - 26
							25635 700 Pol TWS 308 WIN - 20
							25711 700 Pol TRS (Syn) 308 WIN - 26
							25712 700 Pol DM TWS (Syn) 308 WIN - 26
							26179 700 Pol - Syn - 308 WIN Fluted - 24
							26181 700 Pol - Syn - 308 WIN Fluted - 26
							26177 700 Pol - Syn - 308 WIN Non Fl - 24
							26175 700 Pol - Syn - 308 WIN Non Fl - 26
							27503 700 Pol - Syn - 6.8mm Rem SPC Fl - 26
25635							700 Police TWS - 308 WIN - 20"
		108516	37	581	1.000		Barrel Assembly (20" LTR)
		94098	57	400	1.000		Bolt Assembly

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Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
		96117	310	598	1.000		BI-POD ASSEMBLY
		17013	90	581	1.000		Bolt Stop
		24475	130	581	1.000		Bolt Stop Pin
		15224	30	581	1.000		Bolt Stop Spring
		17017	32	450	1.000		700 Ejector
		94555	42	460	1.000		700 Ejector Pin (Spirol)
		17019	52	470	1.000		700 Ejector Spring
		93712	90	480	1.000		700 Extractor Reg. (7400,710)
		3509	20	598	1.000		Instruction Book
		305634	120	581	1.000		Firing Pin Assembly
		104127	250	586	1.000		Front Guard Screw
		99472	290	590	1.000		LENS COVERS - FLIP OPEN - EYE END
		99473	285	590	1.000		LENS COVERS - FLIP OPEN - OBJECT END
		16715	80	586	1.000		Magazine
		90982	170	586	1.000		Magazine Follower
		15699	50	586	1.000		Magazine Spring
		202538	300	598	1.000		PELICAN HARD CASE #1720
		21723	420	588	1.190		PROOF ROUND
		104126	240	586	1.000		Rear Guard Screw
		24476	140	581	1.000		Seal Pin
		97094	320	598	1.000		SLING 1"
		201324	200	586	1.000		Stock Assembly
		21485	505	594	2.000		TEST ROUND 308 WIN 168 gr.BT HP MATCH
		21485	430	594	7.000		TARGET ROUND 308 WIN 168 gr.BT HP MATCH
		26345	150	581	1.000		Trigger Assembly
		94535	210	586	1.000		Trigger Guard Assembly
		97091	280	590	1.000		TRS SCOPE BASE
		97090	270	590	1.000		TRS SCOPE RINGS
		97089	260	590	1.000		TRS TELESCOPE
		26555	140	598	2.000		Swivel Assembly
26175							700 Police - Syn - 308 Win - 26" Non Flute
		106644	30	400	1.000		Barrel Assembly (26")
		94098	50	400	1.000		Bolt Assembly
		17013	90	581	1.000		Bolt Stop
		24475	130	581	1.000		Bolt Stop Pin
		15224	30	581	1.000		Bolt Stop Spring
		993002	280	676	1.000		Box & Envelope Label
		1499	10	676	1.000		Carton - RF-CF
		3509	20	676	1.000		Instruction Book
		1333	290	676	2.000		Ethefoam Insert
		17017	400	440	1.000		Ejector
		94555	410	440	1.000		Ejector Pin
		17019	420	440	1.000		Ejector Spring
		93712	430	435	1.000		Extractor
		305634	130	580	1.000		Firing Pin Assembly

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Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
		104127	250	585	1.000		Front Guard Screw
		16715	80	580	1.000		Magazine
		90982	170	585	1.000		Magazine Follower
		15699	50	585	1.000		Magazine Spring
		21723	300	600	1.130		PROOF ROUND
		104126	240	585	1.000		Rear Guard Screw
		17034	100	580	4.000		Receiver Plug Screw
		24476	140	580	1.000		Sear Pin
		202085B	200	585	1.000		Stock Assembly - BLACK W/SPRUCE GREEN WEB
		21485	505	606	2.000		TEST ROUND 308 WIN 168 gr.BT HP MATCH
		21485	310	606	7.000		TARGET ROUND 308 WIN 168 gr.BT HP MATCH
		26345	150	580	1.000		Trigger Assembly
		94535	210	585	1.000		Trigger Guard Assembly
26177							700 Police - Syn - 308 Win - 24" Non Flute
		245501	37	400	1.000		Barrel Assembly (24")
		94098	57	400	1.000		Bolt Assembly
		17013	90	580	1.000		Bolt Stop
		24475	130	580	1.000		Bolt Stop Pin
		15224	30	580	1.000		Bolt Stop Spring
		993002	280	676	1.000		Box & Envelope Label
		1499	10	676	1.000		Carton - RF-CF
		3509	20	676	1.000		Instruction Book
		1333	290	676	2.000		Ethefoam Insert
		17017	400	440	1.000		Ejector
		94555	410	440	1.000		Ejector Pin
		17019	420	440	1.000		Ejector Spring
		93712	430	435	1.000		Extractor
		305634	120	580	1.000		Firing Pin Assembly
		104127	250	585	1.000		Front Guard Screw
		16715	80	580	1.000		Magazine
		90982	170	585	1.000		Magazine Follower
		15699	50	585	1.000		Magazine Spring
		21723	300	600	1.130		PROOF ROUND
		104126	240	585	1.000		Rear Guard Screw
		17034	100	580	4.000		Receiver Plug Screw
		24476	140	580	1.000		Sear Pin
		94519B	200	585	1.000		Stock Assembly
		21485	505	606	2.000		TEST ROUND 308 WIN 168 gr.BT HP MATCH
		21485	310	606	7.000		TARGET ROUND 308 WIN 168 gr.BT HP MATCH
		26345	150	580	1.000		Trigger Assembly
		94535	210	585	1.000		Trigger Guard Assembly
26179							700 Police - Syn - 308 Win - 24" Fluted
		245702	37	400	1.000		Barrel Assembly (24")
		94098	57	400	1.000		Bolt Assembly

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Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
		17013	90	580	1.000		Bolt Stop
		24475	130	580	1.000		Bolt Stop Pin
		15224	30	580	1.000		Bolt Stop Spring
		993002	280	676	1.000		Box & Envelope Label
		1499	10	676	1.000		Carton - RF-CF
		3509	20	676	1.000		Instruction Book
		1333	290	676	2.000		Ethafoam Insert
		17017	400	440	1.000		Ejector
		94555	410	440	1.000		Ejector Pin
		17019	420	440	1.000		Ejector Spring
		93712	430	435	1.000		Extractor
		305634	120	580	1.000		Firing Pin Assembly
		104127	250	585	1.000		Front Guard Screw
		16715	80	580	1.000		Magazine
		90982	170	585	1.000		Magazine Follower
		15699	50	585	1.000		Magazine Spring
		21723	300	600	1.130		PROOF ROUND
		104126	240	585	1.000		Rear Guard Screw
		17034	100	580	4.000		Receiver Plug Screw
		24476	140	580	1.000		Sear Pin
		94519B	200	585	1.000		Stock Assembly
		21485	505	606	2.000		TEST ROUND 308 WIN 168 gr.BT HP MATCH
		21485	310	606	7.000		TARGET ROUND 308 WIN 168 gr.BT HP MATCH
		26345	150	580	1.000		Trigger Assembly
		94535	210	585	1.000		Trigger Guard Assembly
26181							700 Police - Syn - 308 Win - 26" Fluted
		245701	37	400	1.000		Barrel Assembly (26")
		94098	57	400	1.000		Bolt Assembly
		17013	90	580	1.000		Bolt Stop
		24475	130	580	1.000		Bolt Stop Pin
		15224	30	580	1.000		Bolt Stop Spring
		993002	280	676	1.000		Box & Envelope Label
		1499	10	676	1.000		Carton - RF-CF
		3509	20	676	1.000		Instruction Book
		1333	290	676	2.000		Ethafoam Insert
		17017	400	440	1.000		Ejector
		94555	410	440	1.000		Ejector Pin
		17019	420	440	1.000		Ejector Spring
		93712	430	435	1.000		Extractor
		305634	120	580	1.000		Firing Pin Assembly
		104127	250	585	1.000		Front Guard Screw
		16715	80	580	1.000		Magazine
		90982	170	585	1.000		Magazine Follower
		15699	50	585	1.000		Magazine Spring
		21723	300	600	1.130		PROOF ROUND

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Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
		104126	240	585	1.000		Rear Guard Screw
		17034	100	580	4.000		Receiver Plug Screw
		24476	140	580	1.000		Sear Pin
		94519B	200	585	1.000		Stock Assembly
		21485	505	606	2.000		TEST ROUND 308 WIN 168 gr.BT HP MATCH
		21485	310	606	7.000		TARGET ROUND 308 WIN 168 gr.BT HP MATCH
		26345	150	580	1.000		Trigger Assembly
		94535	210	585	1.000		Trigger Guard Assembly
27503							700 Police - Syn - 6.8mm Rem SPC - 26" Fluted
		245704	37	400	1.000		Barrel Assembly (26")
		113869	57	400	1.000		Bolt Assembly
		17013	90	580	1.000		Bolt Stop
		24475	130	580	1.000		Bolt Stop Pin
		15224	30	580	1.000		Bolt Stop Spring
		993002	280	676	1.000		Box & Envelope Label
		1687	10	676	1.000		Carton - RF-CF
		3509	20	676	1.000		Instruction Book
		1333	290	676	2.000		Ethefoam Insert
		17017	400	440	1.000		Ejector
		94555	410	440	1.000		Ejector Pin
		17019	420	440	1.000		Ejector Spring
		93712	430	435	1.000		Extractor
		305634	120	580	1.000		Firing Pin Assembly
		104127	250	585	1.000		Front Guard Screw
		106607	80	580	1.000		Magazine
		92508	170	585	1.000		Magazine Follower
		91133	50	585	1.000		Magazine Spring
		21738	300	600	1.130		PROOF ROUND
		104126	240	585	1.000		Rear Guard Screw
		17034	100	580	4.000		Receiver Plug Screw
		24476	140	580	1.000		Sear Pin
		94519B	200	585	1.000		Stock Assembly
		29148	505	606	2.000		Test Round 6.8mm REM SPC 115gr.HPBT Match
		29148	310	606	7.000		Target Round 6.8mm REM SPC 115gr.HPBT
		26345	150	580	1.000		Trigger Assembly
		94535	210	585	1.000		Trigger Guard Assembly
25726							700 Police Syn Floor Plt 7mm Rem Mag - 26"
		109822	37	400	1		Barrel Assembly
		94100	57	400	1		Bolt Assembly
		17013	90	580	1		Bolt Stop
		24475	130	580	1		Bolt Stop Pin
		15224	30	580	1		Bolt Stop Spring
		993002	280	676	1		Box & Envelope Label

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Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
		1688	10	676	1		Carton - RF-CF
		3509	20	676	1.000		Instruction Book
		1333	290	676	2.000		Ethefoam Insert
		17017	400	440	1.000		Ejector
		94555	410	440	1.000		Ejector Pin
		17019	420	440	1.000		Ejector Spring
		97322	430	432	1.000		Extractor
		27341	435	432	1.000		Extractor Rivet
		305633	120	580	1.000		Firing Pin Assembly
		104129	250	585	1.000		Front Guard Screw
		16430	80	580	1.000		Magazine
		90952	170	585	1.000		Magazine Follower
		15677	50	585	1.000		Magazine Spring
		21846	300	600	1.130		PROOF ROUND
		104126	240	585	1.000		Rear Guard Screw
		17034	100	580	4.000		Receiver Plug Screw
		24476	140	580	1.000		Sear Pin
		201309	200	585	1.000		Stock Assembly
		28976	505	606	2.000		TEST ROUND 7mm. 140gr.PSP BT
		28976	310	606	7.000		TARGET ROUND 7mm. 140gr.PSP BT
		26345	150	580	1.000		Trigger Assembly
		94089	210	585	1.000		Trigger Guard Assembly
25743							700 Police - (Wood) - 223 REM - 24"
		33478	37	405	1.000		Barrel Assembly (24")
		99347	47	405	1.000		Bolt Assembly
		17013	90	580	1.000		Bolt Stop
		24475	130	580	1.000		Bolt Stop Pin
		15224	30	580	1.000		Bolt Stop Spring
		993002	270	676	1.000		Box & Envelope Label
		1499	10	676	1.000		Carton - RF-CF
		3509	20	676	1.000		Instruction Book
		17017	400	440	1.000		Ejector
		94555	410	440	1.000		Ejector Pin
		17019	420	440	1.000		Ejector Spring
		91906	430	435	1.000		Extractor
		305634	120	580	1.000		Firing Pin Assembly
		98880	300	585	1.000		Floor Plate Insert
		104127	250	585	1.000		Front Guard Screw
		106602	80	580	1.000		Magazine Assembly
		93353	260	585	1.000		Magazine Follower
		91133	160	585	1.000		Magazine Spring
		21774	310	600	1.100		PROOF ROUND
		104126	240	585	1.000		Rear Guard Screw
		17034	100	580	4.000		Receiver Plug Screw
		24476	140	580	1.000		Sear Pin

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Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
		102821	280	585	1.000		Stock Assembly
		15358	50	593	2.000		Swivel Screw
		94241	200	593	2.000		Swivel Screw Spacer
		22106	505	606	2.000		TEST ROUND 223 REM 62 gr.HP MATCH
		22106	320	606	7.000		TARGET ROUND 223 REM 62 gr.HP MATCH
		26345	150	580	1.000		Trigger Assembly
		94535	210	585	1.000		Trigger Guard Assembly
25744							700 Police - (Wood) - 308 WIN - 24"
		33479	37	400	1.000		Barrel Assembly (24")
		94098	57	400	1.000		Bolt Assembly
		17013	90	580	1.000		Bolt Stop
		24475	130	580	1.000		Bolt Stop Pin
		15224	30	580	1.000		Bolt Stop Spring
		993002	260	676	1.000		Box & Envelope Label
		1499	10	676	1.000		Carton - RF-CF
		3509	20	676	1.000		Instruction Book
		17017	400	440	1.000		Ejector
		94555	410	440	1.000		Ejector Pin
		17019	420	440	1.000		Ejector Spring
		93712	430	435	1.000		Extractor
		305634	120	580	1.000		Firing Pin Assembly
		104127	240	585	1.000		Front Guard Screw
		16715	80	580	1.000		Magazine
		93120	270	585	1.000		Magazine Follower
		15699	50	585	1.000		Magazine Spring
		21723	290	600	1.190		PROOF ROUND
		104126	230	585	1.000		Rear Guard Screw
		17034	100	580	4.000		Receiver Plug Screw
		24476	140	580	1.000		Sear Pin
		102821	280	585	1.000		Stock Assembly
		15358	50	593	2.000		Swivel Screw
		94241	200	593	2.000		Swivel Screw Spacer
		21485	505	606	2.000		TEST ROUND 308 WIN 168 gr.BT HP MATCH
		21485	300	606	7.000		TARGET ROUND 308 WIN 168 gr.BT HP MATCH
		26345	150	580	1.000		Trigger Assembly
		94535	200	585	1.000		Trigger Guard Assembly
25745							700 Police - (Syn) - 223 REM - 24"
		33479	37	405	1.000		Barrel Assembly (24")
		99347	47	405	1.000		Bolt Assembly
		17013	90	580	1.000		Bolt Stop
		24475	130	580	1.000		Bolt Stop Pin
		15224	30	580	1.000		Bolt Stop Spring
		993002	240	676	1.000		Box & Envelope Label
		1688	10	676	1.000		Carton - RF-CF

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Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
		3509	20	676	1.000		Instruction Book
		17017	400	440	1.000		Ejector
		94555	410	440	1.000		Ejector Pin
		17019	420	440	1.000		Ejector Spring
		91906	430	435	1.000		Extractor
		305634	120	580	1.000		Firing Pin Assembly
		98880	300	585	1.000		Floor Plate Insert
		104127	260	585	1.000		Front Guard Screw
		106605	80	580	1.000		Magazine
		93353	170	585	1.000		Magazine Follower
		91133	180	585	1.000		Magazine Spring
		21774	310	600	1.100		PROOF ROUND
		104126	250	585	1.000		Rear Guard Screw
		17034	100	580	4.000		Receiver Plug Screw
		24476	140	580	1.000		Sear Pin
		94519B	210	585	1.000		Stock Assembly
		22108	505	606	2.000		TEST ROUND 223 REM 62 gr.HP MATCH
		22106	320	606	7.000		TARGET ROUND 223 REM 62 gr.HP MATCH
		26345	150	580	1.000		Trigger Assembly
		94535	220	585	1.000		Trigger Guard Assembly
25746							700 Police - (Syn) - 308 WIN - 24"
		33479	37	400	1.000		Barrel Assembly (24")
		94098	57	400	1.000		Bolt Assembly
		17013	90	580	1.000		Bolt Stop
		24475	130	580	1.000		Bolt Stop Pin
		15224	30	580	1.000		Bolt Stop Spring
		993002	280	676	1.000		Box & Envelope Label
		1688	10	676	1.000		Carton - RF-CF
		3509	20	676	1.000		Instruction Book
		17017	400	440	1.000		Ejector
		94555	410	440	1.000		Ejector Pin
		17019	420	440	1.000		Ejector Spring
		93712	430	435	1.000		Extractor
		305634	120	580	1.000		Firing Pin Assembly
		104127	260	585	1.000		Front Guard Screw
		16715	80	580	1.000		Magazine
		93120	170	585	1.000		Magazine Follower
		15699	30	585	1.000		Magazine Spring
		21774	310	600	1.130		PROOF ROUND
		104126	240	585	1.000		Rear Guard Screw
		17034	100	580	4.000		Receiver Plug Screw
		24476	140	580	1.000		Sear Pin
		94519B	200	585	1.000		Stock Assembly
		21485	500	606	2.000		TEST ROUND 308 WIN 168 gr.BT HP MATCH
		21485	300	606	7.000		TARGET ROUND 308 WIN 168 gr.BT HP MATCH

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Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
		26345	150	580	1.000		Trigger Assembly
		94535	210	585	1.000		Trigger Guard Assembly
25747							700 Pol - 308 WIN - Etd LTRS - 20
		108515	47	400	1.000		Barrel Assembly 20"
		94098	37	400	1.000		Bolt Assembly
		17013	130	580	1.000		Bolt Stop
		24475	170	580	1.000		Bolt Stop Pin
		15224	30	580	1.000		Bolt Stop Spring
		993002	50	676	1.000		Box & Envelope Label
		3509	20	676	1.000		Instruction Book
		17017	400	440	1.000		Ejector
		94555	410	440	1.000		Ejector Pin
		17019	420	440	1.000		Ejector Spring
		93712	430	435	1.000		Extractor
		305634	160	580	1.000		Firing Pin Assembly
		104127	300	585	1.000		Front Guard Screw
		106399	90	585	1.000		Magazine Assembly - Black Oxide
		21723	310	600	1.000		PROOF POUND
		104126	290	585	1.000		Rear Guard Screw
		24476	180	580	1.000		Sear Pin
		200028	100	585	1.000		Stock Assembly
		21485	505	606	2.000		TEST ROUND 308 Win. 168gr.BT HP Match
		21485	360	606	7.000		Target ROUND 308 Win. 168gr.BT HP Match
		26345	190	580	1.000		Trigger Assembly
		106352	110	585	1.000		Trigger Guard
		96117	440	676	1.000		Bi-Pod Assembly
		99472	450	676	1.000		Lens Cover - Flip Open - Eye end
		99473	460	676	1.000		Lens Cover - Flip Open - Object end
		97092	470	676	1.000		Pelican Hard Case
		97091	480	676	1.000		Scope Base
		97090	490	676	1.000		Scope Rings
		97094	500	676	1.000		Sling - 1"
		97089	510	676	1.000		Telescope
		15358	520	676	2.000		Swivel Screw
		26555	530	676	2.000		Swivel Stud
25714							700 Police 1/9" Twist -(Syn)-223 REM - 26"
		106654	37	405	1.000		Barrel Assembly (26") 1/9" Twist
		94098	47	405	1.000		Bolt Assembly
		17013	90	580	1.000		Bolt Stop
		24475	130	580	1.000		Bolt Stop Pin
		15224	30	580	1.000		Bolt Stop Spring
		993002	290	676	1.000		Box & Envelope Label
		1688	10	676	1.000		Carton - RF-CF
		3509	20	676	1.000		Instruction Book

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Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
		1333	310	676	2.000		Ethefoam Insert
		17017	400	440	1.000		Ejector
		94555	410	440	1.000		Ejector Pin
		17019	420	440	1.000		Ejector Spring
		97138	430	435	1.000		Extractor
		305634	120	580	1.000		Firing Pin Assembly
		98880	300	585	1.000		Floor Plate Insert
		104127	260	585	1.000		Front Guard Screw
		106605	80	580	1.000		Magazine
		92508	170	585	1.000		Magazine Follower
		91133	180	585	1.000		Magazine Spring
		21774	320	600	1.125		PROOF ROUND
		104126	250	585	1.000		Rear Guard Screw
		17034	100	580	4.000		Receiver Plug Screw
		24476	140	580	1.000		Sear Pin
		94519B	210	585	1.000		Stock Assembly
		22108	505	606	2.000		TEST ROUND 223 REM 62 gr.HP MATCH
		22106	330	606	7.000		TARGET ROUND 223 REM 62 gr.HP MATCH
		26345	150	580	1.000		Trigger Assembly
		94535	220	585	1.000		Trigger Guard Assembly
25707							700 Police - (Syn) - 223 REM - 26"
		106643	37	405	1.000		Barrel Assembly (26")
		99347	47	405	1.000		Bolt Assembly
		17013	90	580	1.000		Bolt Stop
		24475	130	580	1.000		Bolt Stop Pin
		15224	30	580	1.000		Bolt Stop Spring
		993002	290	676	1.000		Box & Envelope Label
		1499	10	676	1.000		Carton - RF-CF
		3509	20	676	1.000		Instruction Book
		1333	310	676	2.000		Ethefoam Insert
		17017	400	440	1.000		Ejector
		94555	410	440	1.000		Ejector Pin
		17019	420	440	1.000		Ejector Spring
		97138	430	435	1.000		Extractor
		305634	120	580	1.000		Firing Pin Assembly
		98880	300	585	1.000		Floor Plate Insert
		104127	260	585	1.000		Front Guard Screw
		106605	80	580	1.000		Magazine
		92508	170	585	1.000		Magazine Follower
		91133	180	585	1.000		Magazine Spring
		21774	320	600	1.125		PROOF ROUND
		104126	250	585	1.000		Rear Guard Screw
		17034	100	580	4.000		Receiver Plug Screw
		24476	140	580	1.000		Sear Pin
		94519B	210	585	1.000		Stock Assembly

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Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
		22106	505	606	2.000		TEST ROUND 223 REM 62gr HP MATCH
		22106	330	606	7.000		TARGET ROUND 223 REM 62gr HP MATCH
		26345	150	580	1.000		Trigger Assembly
		94535	220	585	1.000		Trigger Guard Assembly
25709							700 Police - (Syn) - 308 WIN - 26"
		106644	37	400	1.000		Barrel Assembly (26")
		94098	57	400	1.000		Bolt Assembly
		17013	90	580	1.000		Bolt Stop
		24475	130	580	1.000		Bolt Stop Pin
		15224	30	580	1.000		Bolt Stop Spring
		993002	280	676	1.000		Box & Envelope Label
		1688	10	676	1.000		Carton - RF-CF
		3509	20	676	1.000		Instruction Book
		1333	290	676	2.000		Ethefoam Insert
		17017	400	440	1.000		Ejector
		94555	410	440	1.000		Ejector Pin
		17019	420	440	1.000		Ejector Spring
		93712	430	435	1.000		Extractor
		305634	120	580	1.000		Firing Pin Assembly
		104127	250	585	1.000		Front Guard Screw
		16715	80	580	1.000		Magazine
		90982	170	585	1.000		Magazine Follower
		15699	50	585	1.000		Magazine Spring
		21723	300	606	1.130		PROOF ROUND
		104126	240	585	1.000		Rear Guard Screw
		17034	100	580	4.000		Receiver Plug Screw
		24476	140	580	1.000		Sear Pin
		94519B	200	585	1.000		Stock Assembly
		21485	310	606	2.000		TEST ROUND 308 WIN 168gr BT HP MATCH
		21485	310	606	7.000		TARGET ROUND 308 WIN 168gr BT HP MATCH
		26345	150	580	1.000		Trigger Assembly
		94535	220	585	1.000		Trigger Guard Assembly
27223							700 Police - (Syn) CS - 308 WIN - 26"
		106644	37	400	1.000		Barrel Assembly (26")
		94098	57	400	1.000		Bolt Assembly
		17013	90	580	1.000		Bolt Stop
		24475	130	580	1.000		Bolt Stop Pin
		15224	30	580	1.000		Bolt Stop Spring
		993002	280	676	1.000		Box & Envelope Label
		1688	10	676	1.000		Carton - RF-CF
		3509	20	676	1.000		Instruction Book
		1333	290	676	2.000		Ethefoam Insert
		17017	400	440	1.000		Ejector
		94555	410	440	1.000		Ejector Pin

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Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
		17019	420	440	1.000		Ejector Spring
		93712	430	435	1.000		Extractor
		305634	120	580	1.000		Firing Pin Assembly
		104127	250	585	1.000		Front Guard Screw
		16715	80	580	1.000		Magazine
		90982	170	585	1.000		Magazine Follower
		15699	50	585	1.000		Magazine Spring
		21723	300	600	1.130		PROOF ROUND
		104126	240	585	1.000		Rear Guard Screw
		17034	100	580	4.000		Receiver Plug Screw
		24476	140	580	1.000		Sear Pin
		94519B	200	585	1.000		Stock Assembly
		21485	310	606	2.000		TEST ROUND 308 WIN 168gr.BT HP MATCH
		21485	310	606	7.000		TARGET ROUND 308 WIN 168gr.BT HP MATCH
		27591	150	580	1.000		Trigger Assembly - XR100P
		94535	210	585	1.000		Trigger Guard Assembly
25715							700 Police DM - (Syn) - 308 WIN - 26"
		107117	47	400	1.000		Barrel Assembly 26"
		94098	37	400	1.000		Bolt Assembly
		17013	90	580	1.000		Bolt Stop
		24475	130	580	1.000		Bolt Stop Pin
		15224	30	580	1.000		Bolt Stop Spring
		993002	280	676	1.000		Box & Envelope Label
		1499	10	676	1.000		Carton - RF-CF
		3509	20	676	1.000		Instruction Book
		1333	290	676	2.000		Ethefoam Insert
		17017	400	440	1.000		Ejector
		94555	410	440	1.000		Ejector Pin
		17019	420	440	1.000		Ejector Spring
		93712	430	435	1.000		Extractor
		305634	120	580	1.000		Firing Pin Assembly
		104127	250	585	1.000		Front Guard Screw
		106399	80	580	1.000		Magazine Assembly
		21723	300	600	1.130		PROOF ROUND
		104126	240	585	1.000		Rear Guard Screw
		17034	100	580	4.000		Receiver Plug Screw
		24476	140	580	1.000		Sear Pin
		94519B	200	585	1.000		Stock Assembly
		21485	310	606	2.000		TEST ROUND 308 WIN 168gr.BT HP MATCH
		21485	310	606	7.000		TARGET ROUND 308 WIN 168gr.BT HP MATCH
		26345	150	580	1.000		Trigger Assembly
		106352	210	583	1.000		Trigger Guard
25717							700 Pol DM (Syn) - 300 WIN MAG - 26"
		107116	57	415	1.000		Barrel Assembly

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Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
		94100	47	415	1.000		Bolt Assembly
		17013	60	580	1.000		Bolt Stop
		24475	70	580	1.000		Bolt Stop Pin
		15224	80	580	1.000		Bolt Stop Spring
		993002	30	676	1.000		Box & Envelope Label
		1499	10	676	1.000		Carton - RF-CF
		3509	20	676	1.000		Instruction Book
		1333	50	676	2.000		Ethefoam Insert
		17017	400	440	1.000		Ejector
		94555	410	440	1.000		Ejector Pin
		17019	420	440	1.000		Ejector Spring
		97322	430	432	1.000		Extractor
		27341	440	432	1.000		Extractor Rivet
		305633	90	580	1.000		Firing Pin Assembly
		104129	100	583	1.000		Front Guard Screw
		106346	110	580	1.000		Magazine Assembly
		21846	180	600	1.200		PROOF ROUND
		104126	130	583	1.000		Rear Guard Screw
		24476	140	580	1.000		Sear Pin
		99708	150	583	1.000		Stock Assembly
		29497	505	606	2.000		TEST ROUND 300 WIN SAFARI 180gr.PSP
		29497	190	606	7.000		TARGET ROUND 300 WIN SAFARI 180gr.PSP
		26345	160	580	1.000		Trigger Assembly
		105837	170	583	1.000		Trigger Guard
25713							700 DM BDL S/A - 308 WIN
		108515	47	400	1.000		Barrel Assembly 20"
		94098	37	400	1.000		Bolt Assembly
		17013	130	580	1.000		Bolt Stop
		24475	170	580	1.000		Bolt Stop Pin
		15224	30	580	1.000		Bolt Stop Spring
		993002	30	676	1.000		Box & Envelope Label
		3509	20	676	1.000		Instruction Book
		17017	400	440	1.000		Ejector
		94555	410	440	1.000		Ejector Pin
		17019	420	440	1.000		Ejector Spring
		93712	430	432	1.000		Extractor
		305634	160	580	1.000		Firing Pin Assembly
		104127	200	583	1.000		Front Guard Screw
		106347	90	580	1.000		Magazine Assembly - Black Oxide
		21723	310	600	1.100		PROOF ROUND
		104126	290	583	1.000		Rear Guard Screw
		24476	180	580	1.000		Sear Pin
		200028	100	583	1.000		Stock Assembly
		27842	500	606	2.000		TEST ROUND 308 WIN 150gr. PSPCL
		27844	350	606	7.000		TARGET ROUND 308 WIN 168gr. SPCL

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Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
		26345	190	580	1.000		Trigger Assembly
		106352	110	583	1.000		Trigger Guard
25718							700 Police Syn Floor Plt 300 Win Mag - 26
		109820	37	400	1.000		Barrel Assembly
		94100	57	400	1.000		Bolt Assembly
		17013	90	580	1.000		Bolt Stop
		24475	130	580	1.000		Bolt Stop Pin
		15224	30	580	1.000		Bolt Stop Spring
		993002	280	676	1.000		Box & Envelope Label
		1688	10	676	1.000		Carton - RF-CF
		3509	20	676	1.000		Instruction Book
		1333	290	676	2.000		Ethefoam Insert
		17017	400	440	1.000		Ejector
		94555	410	440	1.000		Ejector Pin
		17019	420	440	1.000		Ejector Spring
		97322	430	432	1.000		Extractor
		27341	435	432	1.000		Extractor Rivet
		305633	120	580	1.000		Firing Pin Assembly
		104129	250	585	1.000		Front Guard Screw
		16430	80	580	1.000		Magazine
		90952	170	585	1.000		Magazine Follower
		15677	50	585	1.000		Magazine Spring
		21846	300	600	1.130		PROOF ROUND
		104126	240	580	1.000		Rear Guard Screw
		17034	100	580	1.000		Receiver Plug Screw
		24476	140	580	1.000		Sear Pin
		201309	200	585	1.000		Stock Assembly
		29497	505	606	2.000		TEST ROUND 300 Win Mag 180gr.PSPCL
		27684	310	606	7.000		TARGET ROUND 300 Win Mag 190gr.PSPCL
		26345	150	580	1.000		Trigger Assembly
		94089	210	580	1.000		Trigger Guard Assembly
25735							700 Police Syn Floor Plt. 300 Ultra - 26
		109820	37	400	1.000		Barrel Assembly
		94100	57	400	1.000		Bolt Assembly
		17013	90	580	1.000		Bolt Stop
		24475	130	580	1.000		Bolt Stop Pin
		15224	30	580	1.000		Bolt Stop Spring
		993002	280	676	1.000		Box & Envelope Label
		1688	10	676	1.000		Carton - RF-CF
		3509	20	676	1.000		Instruction Book
		1333	290	676	2.000		Ethefoam Insert
		17017	400	440	1.000		Ejector
		94555	410	440	1.000		Ejector Pin
		17019	420	440	1.000		Ejector Spring

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Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
		97322	430	432	1.000		Extractor
		27341	439	432	1.000		Extractor Rivet
		305633	120	580	1.000		Firing Pin Assembly
		104129	250	585	1.000		Front Guard Screw
		300248	80	580	1.000		Magazine
		90952	170	585	1.000		Magazine Follower
		15677	50	585	1.000		Magazine Spring
		21836	300	600	1.130		PROOF ROUND
		104126	240	585	1.000		Rear Guard Screw
		17034	100	580	4.000		Receiver Plug Screw
		24476	140	580	1.000		Sear Pin
		201309	200	585	1.000		Stock Assembly
		27948	505	606	2.000		TEST ROUND 300 Rem U \ Mag 180gr.PSPCL
		27948	310	606	7.000		TARGET ROUND 300 Rem U \ Mag 180gr.PSPCL
		26345	150	580	1.000		Trigger Assembly
		94089	210	585	1.000		Trigger Guard Assembly
25737							700 Police Syn Floor Plt 223 Win LTR - 20
		108517	37	400	1.000		Barrel Assembly (20")
		99347	57	400	1.000		Bolt Assembly
		17013	90	580	1.000		Bolt Stop
		24475	130	580	1.000		Bolt Stop Pin
		15224	30	580	1.000		Bolt Stop Spring
		993002	280	676	1.000		Box & Envelope Label
		1499	10	676	1.000		Carton - RF-CF
		3509	20	676	1.000		Instruction Book
		1333	290	676	2.000		Ethefoam Insert
		17017	400	440	1.000		Ejector
		94555	410	440	1.000		Ejector Pin
		17019	420	440	1.000		Ejector Spring
		97138	430	435	1.000		Extractor
		305634	120	580	1.000		Firing Pin Assembly
		104127	250	585	1.000		Front Guard Screw
		106605	80	580	1.000		Magazine
		98888	350	585	1.000		Floor Plate Insert
		92508	170	585	1.000		Magazine Follower
		91133	50	585	1.000		Magazine Spring
		21774	300	600	1.130		PROOF ROUND
		104126	240	585	1.000		Rear Guard Screw
		17034	100	580	4.000		Receiver Plug Screw
		24476	140	580	1.000		Sear Pin
		201324	200	585	1.000		Stock Assembly
		23108	505	606	2.000		TEST ROUND 223 Rem 62 gr.HP MATCH
		22106	310	606	7.000		TARGET ROUND 223 Rem 62 gr.HP MATCH
		26345	150	580	1.000		Trigger Assembly
		94535	210	585	1.000		Trigger Guard Assembly

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Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
25677							700 Pol Floor Plt 6.8MM Rem SPC LTR - 20
		245703	37	400	1.000		Barrel Assembly (20")
		113869	57	400	1.000		Bolt Assembly
		17013	90	580	1.000		Bolt Stop
		24475	130	580	1.000		Bolt Stop Pin
		15224	30	580	1.000		Bolt Stop Spring
		993002	280	676	1.000		Box & Envelope Label
		1687	10	676	1.000		Carton - RF-CF
		3509	20	676	1.000		Instruction Book
		1333	290	676	2.000		Ethefoam Insert
		17017	400	440	1.000		Ejector
		94555	410	440	1.000		Ejector Pin
		17019	420	440	1.000		Ejector Spring
		93712	430	435	1.000		Extractor
		305634	120	580	1.000		Firing Pin Assembly
		104127	250	585	1.000		Front Guard Screw
		106607	80	580	1.000		Magazine Assy
		92508	170	585	1.000		Magazine Follower
		91133	50	585	1.000		Magazine Spring
		21738	320	600	1.000		PRCCF ROUND
		104126	240	585	1.000		Rear Guard Screw
		17034	100	580	4.000		Receiver Plug Screw
		24476	140	580	1.000		Sear Pin
		201324	200	585	1.000		Stock Assembly
		29146	505	606	2.000		Test Round 6.8mm REM SPC 115gr.HPBT Match
		29146	340	606	8.000		Target Round 6.8mm REM SPC 115gr.HPBT
		26345	150	580	1.000		Trigger Assembly
		94535	210	585	1.000		Trigger Guard Assembly
25681							700 Police Syn Floor Plt 300 SAUM LTR - 20
		245700	37	400	1.000		Barrel Assembly (20")
		201903	57	400	1.000		Bolt Assembly
		17013	90	580	1.000		Bolt Stop
		24475	130	580	1.000		Bolt Stop Pin
		15224	30	580	1.000		Bolt Stop Spring
		993002	280	676	1.000		Box & Envelope Label
		1499	10	676	1.000		Carton - RF-CF
		3509	20	676	1.000		Instruction Book
		1333	290	676	2.000		Ethefoam Insert
		201843	400	440	1.000		Ejector
		94555	410	440	1.000		Ejector Pin
		201841	420	440	1.000		Ejector Spring
		97322	430	435	1.000		Extractor
		27341	430	435	1.000		Extractor Rivet
		305634	120	580	1.000		Firing Pin Assembly

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Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
		104127	250	585	1.000		Front Guard Screw
		110845	80	580	1.000		Magazine
		110855	170	585	1.000		Magazine Follower
		201849	50	585	1.000		Magazine Spring
		21830	300	600	1.130		PROOF ROUND 300 Rem SA Ultra Mag - PRF300SM3
		104126	240	585	1.000		Rear Guard Screw
		17034	100	580	4.000		Receiver Plug Screw
		24476	140	580	1.000		Sear Pin
		201324	200	585	1.000		Stock Assembly
		29040	505	606	2.000		TEST ROUND - 300 S/A U/M 180 gr.PSPCL
		29040	310	606	7.000		TARGET ROUND 300 S/A U/M 180 gr.PSPCL
		26345	150	580	1.000		Trigger Assembly
		94535	210	585	1.000		Trigger Guard Assembly
25739							700 Police Syn Floor Plt 308 Win LTR - 20
		108516	37	400	1.000		Barrel Assembly (20")
		94098	57	400	1.000		Bolt Assembly
		17013	90	580	1.000		Bolt Stop
		24475	130	580	1.000		Bolt Stop Pin
		15224	30	580	1.000		Bolt Stop Spring
		993002	280	676	1.000		Box & Envelope Label
		1499	10	676	1.000		Carton - RF-CF
		3509	20	676	1.000		Instruction Book
		1333	290	676	2.000		Ethefoam Insert
		17017	400	440	1.000		Ejector
		94555	410	440	1.000		Ejector Pin
		17019	420	440	1.000		Ejector Spring
		93712	430	435	1.000		Extractor
		305634	120	580	1.000		Firing Pin Assembly
		104127	250	585	1.000		Front Guard Screw
		16715	80	580	1.000		Magazine
		90982	170	585	1.000		Magazine Follower
		15699	50	585	1.000		Magazine Spring
		21723	300	600	1.130		PROOF ROUND
		104126	240	585	1.000		Rear Guard Screw
		17034	100	580	4.000		Receiver Plug Screw
		24476	140	580	1.000		Sear Pin
		201324	200	585	1.000		Stock Assembly
		21485	505	606	2.000		TEST ROUND 308 WIN 168 gr.BT HP MATCH
		21485	310	606	7.000		TARGET ROUND 308 WIN 168 gr.BT HP MATCH
		26345	150	580	1.000		Trigger Assembly
		94535	210	585	1.000		Trigger Guard Assembly
25657							700SS Pol Floor Plt 308 Win FL ROTBLAST-20
		109283	37	400	1.000		Barrel Assembly (20")
		105442	57	400	1.000		Bolt Assembly

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Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
		97444	90	580	1.000		Bolt Stop
		24475	130	580	1.000		Bolt Stop Pin
		15224	30	580	1.000		Bolt Stop Spring
		993002	280	676	1.000		Box & Envelope Label
		1684	10	676	1.000		Carton - RF-CF
		3509	20	676	1.000		Instruction Book
		17017	400	440	1.000		Ejector
		94555	410	440	1.000		Ejector Pin
		17019	420	440	1.000		Ejector Spring
		93712	430	435	1.000		Extractor
		305640	120	580	1.000		Firing Pin Assembly
		106293	250	585	1.000		Front Guard Screw
		97825	80	580	1.000		Magazine
		90982	170	585	1.000		Magazine Follower
		15699	50	585	1.000		Magazine Spring
		21723	300	600	1.130		PROOF ROUND
		106292	240	585	1.000		Rear Guard Screw
		17034	100	580	4.000		Receiver Plug Screw
		24476	140	580	1.000		Sear Pin
		201324	200	585	1.000		Stock Assembly
		21485	505	606	2.000		TEXT ROUND 308 WIN 168 gr.BT HP MATCH
		21485	310	606	7.000		TARGET ROUND 308 WIN 168 gr.BT HP MATCH
		97490	150	580	1.000		Trigger Assembly
		97867	210	585	1.000		Trigger Guard Assembly
25639							700SS Pol Floor Plt 308 Win FL ROTOBLAST-26
		249233	37	400	1.000		Barrel Assembly (26")
		105442	57	400	1.000		Bolt Assembly
		97444	90	580	1.000		Bolt Stop
		24475	130	580	1.000		Bolt Stop Pin
		15224	30	580	1.000		Bolt Stop Spring
		993002	280	676	1.000		Box & Envelope Label
		1687	10	676	1.000		Carton - RF-CF
		3509	20	676	1.000		Instruction Book
		17017	400	440	1.000		Ejector
		94555	410	440	1.000		Ejector Pin
		17019	420	440	1.000		Ejector Spring
		93712	430	435	1.000		Extractor
		305640	120	580	1.000		Firing Pin Assembly
		106293	250	585	1.000		Front Guard Screw
		97825	80	580	1.000		Magazine
		90982	170	585	1.000		Magazine Follower
		15699	50	585	1.000		Magazine Spring
		21723	300	600	1.130		PROOF ROUND
		106292	240	585	1.000		Rear Guard Screw
		17034	100	580	4.000		Receiver Plug Screw

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Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
		24476	140	580	1.000		Sear Pin
		94519	200	585	1.000		Stock Assembly
		21485	505	606	2.000		TEST ROUND 308 WIN 168 gr.BT HP MATCH
		21485	310	606	7.000		TARGET ROUND 308 WIN 168 gr.BT HP MATCH
		97490	150	580	1.000		Trigger Assembly
		97867	210	585	1.000		Trigger Guard Assembly
25711							700 Police TRS - (Syn) - 308 WIN - 26"
		106664	37	581	1.000		Barrel Assembly (26")
		94098	57	400	1.000		Bolt Assembly
		96117	310	598	1.000		BI-POD ASSEMBLY
		17013	90	581	1.000		Bolt Stop
		24475	130	581	1.000		Bolt Stop Pin
		15224	30	581	1.000		Bolt Stop Spring
		3509	20	598	1.000		Instruction Book
		17017	500	440	1.000		Ejector
		94555	510	440	1.000		Ejector Pin
		17019	520	440	1.000		Ejector Spring
		93712	530	435	1.000		Extractor
		305634	120	581	1.000		Firing Pin Assembly
		104127	250	586	1.000		Front Guard Screw
		99472	290	590	1.000		LENS COVERS - FLIP OPEN - EYE END
		99473	285	590	1.000		LENS COVERS - FLIP OPEN - OBJECT END
		16715	80	586	1.000		Magazine
		90962	170	586	1.000		Magazine Follower
		15699	50	586	1.000		Magazine Spring
		97092	300	598	1.000		PELICAN HARD CASE
		21723	420	588	1.190		PROOF ROUND
		104126	240	586	1.000		Rear Guard Screw
		24476	140	581	1.000		Sear Pin
		97094	320	598	1.000		SLING 1"
		94519B	200	585	1.000		Stock Assembly
		21485	505	606	2.000		TEST ROUND 308 WIN 168 gr.BT HP MATCH
		21485	430	606	7.000		TARGET ROUND 308 WIN 168 gr.BT HP MATCH
		26345	150	580	1.000		Trigger Assembly
		94535	210	586	1.000		Trigger Guard Assembly
		97091	280	590	1.000		TRS SCOPE BASE
		97090	270	590	1.000		TRS SCOPE RINGS
		97089	260	590	1.000		TRS TELESCOPE
		15358	40	598	2.000		Swivel Screw
		26555	10	598	2.000		Swivel Assembly
25712							700 Police DM TWS (Syn) - 308 WIN - 26"
		107117	47	581	1.000		Barrel Assembly 26"
		94098	37	400	1.000		Bolt Assembly
		96117	310	598	1.000		BI-POD ASSEMBLY

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Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
		17013	90	581	1.000		Bolt Stop
		24475	130	581	1.000		Bolt Stop Pin
		15224	30	581	1.000		Bolt Stop Spring
		3509	20	598	1.000		Instruction Book
		17017	500	440	1.000		Ejector
		94555	510	440	1.000		Ejector Pin
		17019	520	440	1.000		Ejector Spring
		93712	530	435	1.000		Extractor
		305634	120	581	1.000		Firing Pin Assembly
		104127	250	586	1.000		Front Guard Screw
		99472	290	590	1.000		LENS COVERS - FLIP OPEN - EYE END
		99473	285	590	1.000		LENS COVERS - FLIP OPEN - OBJECT END
		106399	80	586	1.000		Magazine Assembly
		97092	300	598	1.000		PELICAN HARD CASE
		21723	420	588	1.190		PROOF ROUND
		104126	240	586	1.000		Rear Guard Screw
		97091	280	590	1.000		SCOPE BASE
		97090	270	590	1.000		SCOPE RINGS
		24476	140	581	1.000		Sear Pin
		97094	320	598	1.000		SLIDE 1"
		99359B	200	586	1.000		Stock Assembly
		97089	260	590	1.000		TELESCOPE
		21485	505	594	2.000		TEST ROUND 308 WIN 168 gr. BT HP Match
		21485	430	594	7.000		TARGET ROUND 308 WIN 168 gr. BT HP Match
		26345	150	581	1.000		Trigger Assembly
		106352	210	586	1.000		Trigger Guard
		15358	40	598	2.000		Swivel Screw
		26555	10	598	2.000		Swivel Stud

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Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
01	10	05	2	01	2	05	10
02	15	20	0	01	0	20	10
03	10	50	0	01	0	50	10
04	10	20	0	01	0	20	10
05	10	00	0	01	0	00	10
06	10	00	0	01	0	00	10
07	10	00	0	01	0	00	10
08	10	00	0	01	0	00	10
09	10	00	0	01	0	00	10
10	10	00	0	01	0	00	10
11	10	00	0	01	0	00	10
12	10	00	0	01	0	00	10
13	10	00	0	01	0	00	10
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100	10	00	0	01	0	00	10

Printed on:
~AUTODATE

Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
01	10	05	2	01	2	05	10
02	15	20	0	01	0	20	10
03	10	50	0	01	0	50	10
04	10	20	0	01	0	20	10
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99	10	00	0	01	0	00	10
100	10	00	0	01	0	00	10

Printed on:
~AUTODATE

Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
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02	15	20	0	01	0	20	10
03	10	50	0	01	0	50	10
04	10	00	0	01	0	00	10
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99	10	00	0	01	0	00	10
100	10	00	0	01	0	00	10

Printed on:
~AUTODATE

Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
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02	15	20	0	01	0	20	10
03	10	50	0	01	0	50	10
04	10	20	0	01	0	20	10
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98	10	00	0	01	0	00	10
99	10	00	0	01	0	00	10
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Printed on:
~AUTODATE

[illegible]

Printed on:
~AUTODATE

Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
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02	15	20	0	01	0	20	10
03	10	50	0	01	0	50	10
04	10	00	0	01	0	00	10
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92	10	00	0	01	0	00	10
93	10	00	0	01	0	00	10
94	10	00	0	01	0	00	10
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98	10	00	0	01	0	00	10
99	10	00	0	01	0	00	10
100	10	00	0	01	0	00	10

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Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
01	10	05	2	01	2	05	10
02	15	20	0	01	0	20	10
03	10	50	0	01	0	50	10
04	10	20	0	01	0	20	10
05	10	00	0	01	0	00	10
06	10	00	0	01	0	00	10
07	10	00	0	01	0	00	10
08	10	00	0	01	0	00	10
09	10	00	0	01	0	00	10
10	10	00	0	01	0	00	10
11	10	00	0	01	0	00	10
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13	10	00	0	01	0	00	10
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98	10	00	0	01	0	00	10
99	10	00	0	01	0	00	10
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Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
01	10	05	21	01	2	05	10
02	15	20	01	21	0	20	10
03	10	50	01	21	0	50	10
04	10	20	01	21	0	20	10
05	10	00	01	21	0	00	10
06	10	00	01	01	0	00	10
07	10	00	01	01	0	00	10
08	10	00	01	21	0	00	10
09	10	00	01	21	0	00	10
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Date:	Reason for Revision:	Eng:	Log #:
16-May-01	Copied entire process from VAXcamps #384757	RLJ	304220
24-Aug-01	4.5 to 5.5 lb trigger pull was 4 to 5 pounds.	RLJ	305059
5-Sep-01	Added accuracy spec to 300 RUM caliber Police rifles.	RLJ	305062
8-Sep-01	Added muzzle re-chamfering instructions & tools at target	RLJ	305064
12-Oct-01	Replaced F1721 Doc Envelope Assy with 350B Instruction Book.	RLJ	305075
31-Oct-01	In Sequence of Operations section: op 586 - Dept 8761 was 8785, op 590 - Dept 8488 was 8761, op 594 - Dept 8488 was 8785.	RLJ	305388
7-Jan-02	Changed structure to revert to original, short non-ISS style Firing Pin Assy. P/N 94093 was 109589 and 94094 was 109588.	RLJ	305407
4-Apr-02	Trigger pull 4.5 to 6.5 was 4.5 to 5.5	RLJ	305777
18-Jun-02	OP#640- STAMP DATE CODE ON BARREL AT LEFT-REAR OF BARREL, JUST AHEAD OF RECEIVER. (PASSED GUNS) WAS "STAMP FINAL INSPECTION AND Q&Q MARKS" IN TWO PLACES - REMOVE "a. Apply sticker to Gun Tag" - ADD C-47444 - DRAWING LISTING DATE CODE STAMPS	GLC	307049
3-Sep-02	ADD RAMAC 25681	GLC	307240
4-Feb-03	Added SKU# 26175, 26177, 26179 & 26181 per DCR 14988 BOS 110. Removed Build to Tag 3487 - expensed item now	RLJ	308219
24-Feb-03	PT#202085 WAS 120086 Spruce Green Web FOR RAMAC #6175	GLC	308776
26-Feb-03	Updated to current practice (details only) Updated Description in op: 440 & 585 (Router)	ERF	307607
19-Aug-03	RAMAC#25681 - CORRECT MAGAZINE PT# - WAS 110845	GLC	310154
13-Nov-03	Added SKU 25635	RFL	310339

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Date:	Reason for Revision:	Eng:	Log #:
21-Nov-03	RAMAC#25711 & 25712 - ADD PT#17017 - Ejector - ADD PT#94555 - Ejector Pin - ADD PT#17019 - Ejector Spring - ADD PT#93712 - Extractor RAMAC#25635 - ADD PT#98576 - BORE CLEANER - ADD PT#98575 - REM OIL - ADD PT#15358 - Swivel Screw	GLC	310751
21-Nov-03	Removed #98576-Bore Cleaner, #98575-Rem Oil, #15358-Swivel screw From RAMAC 5635	RFL	306917
17-Jun-04	Added operation 648 and information to Step 3 on oper 640. Trigger pull spec reduced from 4.5 to 6.5 to 4.5 to 5.5 on ops 583, 585, 586, 640. Added operation 600R for special slave bolt proof procedure.	RLJ	310367
24-Jun-04	Replaced ISS Firing Pin Assy with Non-ISS Fluted Firing Pin Assy. 94093 now 305634, 94094 now 305633.	RLJ	311851
26-Jul-04	Trigger pull 4.75 to 5.75 pounds was 4.5 to 5.5 pounds. Trigger pull revised to compensate for a change in the direction of pull. - 4.5 pounds Min was used when trigger pull was measured in the direction of the top of the stock comb. - New SAAMI trigger pull standard requires the trigger to be pulled parallel to the centerline of the barrel. This results in the minimum trigger pull being changed to 4.75 pounds and the maximum trigger pull being changed to 5.75 pounds.	RLJ	311856
5-Nov-04	OP#400, 405, 415 & 650 - UPDATE INFO AND REESTABLISH LINKS FOR HEADING PLUGS MOVE RAMAC#25735 & 25681 FROM OP#415 TO 400 REMOVE RAMAC#25735 & 25681 FROM OP#420	GLC	313053
4-Jan-05	Changed Pelican Case #97092 to #202536 for SKU #25635 - new shorter case to be used on 20" TWS.	MFS	313184
4-Jan-05	OP 580 581 583 585 586 640 648 added pull scale verification process	DWB	313324
11-Jan-05	RAMAC#25681 - MAGAZINE PT#110845 WAS 110847	GLC	313605
14-Jan-05	ADD OP#395 FOR ALL PART #'S	GLC	313608

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Date:	Reason for Revision:	Eng:	Log #:
	REMOVE INSPECTION INFO FROM OP#400,405,& 415		
18-Jan-05	ADD OP#650 AGAIN - MISSING FROM ROUTING	GLC	313623
2-Feb-05	Replace Sub-contract stk 99986 with purchased 99986B	RJL	312487
	Replace Sub-contract stk 202085 with purchased 202085B		
	Replace Sub-contract stk 94519 with purchased 94519B		
14-Mar-05	RAMAC#25709 - Carton - RF-CF PT#1688 WAS 1499	GLC	314069
	RAMAC#25714 - Carton - RF-CF PT#1688 WAS 1499		
	RAMAC#25726 - Carton - RF-CF PT#1688 WAS 1499		
	RAMAC#25718 - Carton - RF-CF PT#1688 WAS 1499		
	RAMAC#25735 - Carton - RF-CF PT#1688 WAS 1499		
14-Apr-05	Added To Op. 585 Floor Plate Insert F98020 Ramac 25737	ERF	311637
18-Apr-05	ADD RAMAC#25677 - 700 Pol Floor Plt 6.8MM Rem SPC LTR - 20	GLC	314426
	OP#435 - ADD TENSION PLUGS FOR 6.8MM REM SPC		
27-Apr-05	ADD RAMAC#25657 - 700SS Pol Floor Plt 308 Win FL RB - 20	GLC	314546
	ADD RAMAC#25639 - 700SS Pol Floor Plt 308 Win FL RB - 26		
	DCR#15798		
18-May-05	RAMAC#25639 & 25657 - Firing Pin Assembly PT#305640 WAS 105411	GLC	314720
3-Jun-05	RAMAC#25639 - Barrel Assembly (26") PT#249233 WAS 106328	GLC	314916
3-Jun-05	RAMAC#25639 & 25657 - ADD Trigger Loc PT#201392	GLC	314917
29-Jun-05	On SKU #25677, test and target ammo #29146 was #27676; changed due to ammo availability.	MFS	314529
8-Jul-05	Added SKU #27593 per NFP #2005-ML37.	MFS	314537
16-Jul-05	RAMAC#27593 - Carton - RF-CF PT#1687 WAS 1499	GLC	315288
17-Aug-05	On SKU #25677, Firing Pin Assy #305634 was #94093 - corrected to Non-ISS Fluted Firing Pin Assy.	MFS	315261
18-Aug-05	On SKU's #25657 and #25639, Bolt Assembly #105442 was #1135257 per DCR# 15986.	MFS	315266
19-Aug-05	On SKU #25677, Magazine Follower #92508 was #90982 and Magazine Spring #15699 was #91133; were incorrect on parts lists.	MFS	315267

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Date:	Reason for Revision:	Eng:	Log #:
7-Sep-05	On SKU's #25677 and #27503, Ejector #201843 was #17017 and Ejector Spring #201841 was #17019; per DCR# 15996.	MFS	315487
8-Sep-05	RAMAC#25681 - Ejector Spring PT#201841 was #17019 DCR# 15996	GLC	315545
16-Sep-05	Changed targeting spec in Op 606 from 1.5" to 2.5" for .300 Win Mag, .300 Rem Ultra Mag, .300 Rem S/A Ultra Mag and 7mm Rem Mag.	MFS	315492
28-Sep-05	On SKU #25657, Carton #1684 was #1687; BOM incorrect.	MFS	315500
29-Sep-05	Removed trigger lock 201392 from all police SKU's. No longer needed on police offerings	RJO	314949
30-Sep-05	On SKU #25677, Ejector #17017 was #201843 and Ejector Spring #17019 was #201841; On SKU #27503, Ejector #17017 was #201843, Ejector Spring #17019 was #20184, Magazine Follower #92508 was #90982 and Magazine Spring #91133 was #15699.	MFS	315501
4-Oct-05	On SKU's #25639, 25707, 25745, 25746, 26177, 26179, 26181 and 27503, changed carton to #1688.	MFS	315504
28-Oct-05	Added SKU #27223 per NFF #2005-ML73, DCR #16082.	MFS	315951
21-Nov-05	Op. 650 - corrected typo, sear lift must be .008/.018 (was .008/.0018)	PJZ	316074

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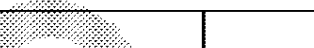
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Subject to Protective Order - Williams v. Remington

ILE00080267

Comprehensive Project Overview and Key Milestones									
Project Identification		Detailed Task Breakdown				Resource Allocation and Status			
Dept	Num	Procedure by Steps				Safety Key Points			
A	01	1	2	3	4	5	6	7	8
B	02	1	2	3	4	5	6	7	8
C	03	1	2	3	4	5	6	7	8
D	04	1	2	3	4	5	6	7	8
E	05	1	2	3	4	5	6	7	8
F	06	1	2	3	4	5	6	7	8
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H	08	1	2	3	4	5	6	7	8
I	09	1	2	3	4	5	6	7	8
J	10	1	2	3	4	5	6	7	8
K	11	1	2	3	4	5	6	7	8
L	12	1	2	3	4	5	6	7	8
M	13	1	2	3	4	5	6	7	8
N	14	1	2	3	4	5	6	7	8
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P	16	1	2	3	4	5	6	7	8
Q	17	1	2	3	4	5	6	7	8
R	18	1	2	3	4	5	6	7	8
S	19	1	2	3	4	5	6	7	8
T	20	1	2	3	4	5	6	7	8
U	21	1	2	3	4	5	6	7	8
V	22	1	2	3	4	5	6	7	8
W	23	1	2	3	4	5	6	7	8
X	24	1	2	3	4	5	6	7	8
Y	25	1	2	3	4	5	6	7	8
Z	26	1	2	3	4	5	6	7	8
AA	27	1	2	3	4	5	6	7	8
AB	28	1	2	3	4	5	6	7	8
AC	29	1	2	3	4	5	6	7	8
AD	30	1	2	3	4	5	6	7	8
AE	31	1	2	3	4	5	6	7	8
AF	32	1	2	3	4	5	6	7	8
AG	33	1	2	3	4	5	6	7	8
AH	34	1	2	3	4	5	6	7	8
AI	35	1	2	3	4	5	6	7	8
AJ	36	1	2	3	4	5	6	7	8
AK	37	1	2	3	4	5	6	7	8
AL	38	1	2	3	4	5	6	7	8
AM	39	1	2	3	4	5	6	7	8
AN	40	1	2	3	4	5	6	7	8
AO	41	1	2	3	4	5	6	7	8
AP	42	1	2	3	4	5	6	7	8
AQ	43	1	2	3	4	5	6	7	8
AR	44	1	2	3	4	5	6	7	8
AS	45	1	2	3	4	5	6	7	8
AT	46	1	2	3	4	5	6	7	8
AU	47	1	2	3	4	5	6	7	8
AV	48	1	2	3	4	5	6	7	8
AW	49	1	2	3	4	5	6	7	8
AX	50	1	2	3	4	5	6	7	8
AY	51	1	2	3	4	5	6	7	8
AZ	52	1	2	3	4	5	6	7	8
BA	53	1	2	3	4	5	6	7	8
BB	54	1	2	3	4	5	6	7	8
BC	55	1	2	3	4	5	6	7	8
BD	56	1	2	3	4	5	6	7	8
BE	57	1	2	3	4	5	6	7	8
BF	58	1	2	3	4	5	6	7	8
BG	59	1	2	3	4	5	6	7	8
BH	60	1	2	3	4	5	6	7	8
BI	61	1	2	3	4	5	6	7	8
BJ	62	1	2	3	4	5	6	7	8

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			INSPECT			
			REJECT			
			INSPECT			
			REJECT			
Pieces Run:			Remington Arms Company, Inc. -- Ilion, New York			

Type "Ctrl+h" from the desired destination to insert this form. Execute *before* the next form below.

PROCESS CONTROL INSPECTION RECORD				Revision Date: 22-Nov-05		Inspected by:				
THIS RECORD MUST REMAIN IN HEAT TREAT INSPECTION FOR ONE YEAR				Part No:		Prod. Qty:				
				Production Order #:						
Part Name: Fin Assy 700 Pol		Centerfire Rifle								
Operation No: Part No:		Operation: Part Name:		Work Center:		Inspec. Date: 8/14/2006				
Furnace and Load Number	Draw Temp	Furnace Date	Hardness Specification		Hardness Specification		Hardness Specification		Break Test	
			H Rc	INSPECT REJECT	H15n	INSPECT REJECT	H45n	INSPECT REJECT	INSPECT	REJECT
HRc		H15n		H15n		H45n		Break Test Results (lbs)		
Tester No		Tester No		Tester No		Tester No				
35		60		81		37				
36		61		82		38				
37		62		83		39				
38		63		84		40				
39		64		85		41				
40		65		86		42				
41		66		87		43				
42		67		88		44				
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46		71		92		48				
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48		73		94		50				
49		74		95		51				
50		75		96		52				
51		76		97		53				
52		77		98		54				
53		78		99		55				
54		79		100		56				
Sample Plan										
Lot Size	Sample Size	Allowable Outside								
1-5	All	0								
6 - 50	6	0								
51 - 100	7	0								
101 - 200	7	0								
201 - 800	16	1								
801 - 3000	17	1								
3001 - 20000	27	2								

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Type "Ctrl+r" from the desired destination to insert this form. Execute after the HTPCIR above.

PROCESS RECORD - HEAT TREAT SPECIFICATION

Process

Material:
Furnace:
Rack:
Maximum Load:

Temperature:
Soak Time:
Carbon %:
Quench:
Wash:
Notes:

Inspection

Hardness:

Break Test:
Color Only:
Appearance of Parts:

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Unassigned Button Clicked

You have clicked a button that is not assigned to a process sheet

Click the button to return to the Header Sheet