

Remington Arms Company, Inc.
Manufacturing Process Document

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

Effective Date: 12-Oct-05
Origination Date: 13-Feb-93

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
Fit and Head Bolt Assy to Bbl Assy (MAGNUMS)
(BELTED - MAGNUMS)
Make Chamber Cast (Not Done on 100% of Product)
Assemble Rear Sight Assembly and Front Sight
Assemble Front & Rear Scope Bases to Barrel
Ream Ejector Hole
Form Radius on Edge of Firing Pin 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
Wire brush and dry barrel
Assemble Action
Trigger Guard
Spacer to Stock
Proof Test
Proof Test with slave bolt
Hand Chamfer Muzzle with a Live-Pilot Tool
Test and Target
Test and Target
Attach scope rings, scope and bore sight
Inspect For Live Ammunition
Final Inspection
Reset trigger pull within specs as needed - not do
Inspect Heading and Sear Lift
Number Using Dot Peen Marking Machine

Assemble Hood to Front Sight Ramp
Print Box End Label & Pack Rifle
Print Box End Label & Pack Rifle
Repair Max Headers

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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: 12-Oct-05			Processed by:
Part No:	Part Name: Fin Assy 700 BDL	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			
			INSPECT			
			REJECT			
			INSPECT			
			REJECT			
			INSPECT			
			REJECT			

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395 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: 12-Oct-05			Processed by:
Part No:	Part Name: Fin Assy 700 BDL	Centerfire Rifle			Date: 8/14/2006	
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)

Viewing all

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
	Fit bolt assembly to barrel assembly.
	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.
 - 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.

Tool Number

Tooling Description

F-76039	Machine
A-89656	Scraping Tool - Ejector hole
D-46967	Fixture

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STD LE3000 ACCU-LUBE

STD STEELGARD 1301-NL

STD Caliber - 30-06

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

A-41281 COLLAR

B-90098-W SHANK

STD Caliber - 30-06

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

A-41281 COLLAR

B-90098-W SHANK

STD Caliber - 30-06

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

A-41281 COLLAR

B-90098-W SHANK

STD Caliber - 30-06

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

A-41281 COLLAR

B-90098-W SHANK

STD Caliber - 30-06

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

A-41281 COLLAR

B-90098-W SHANK

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STD Caliber - 30-06
D-49577-S REAMER (replaces B-53297)
A-41281 COLLAR
B-90098-W SHANK

STD Caliber - 30-06
D-49577-S REAMER (replaces B-53297)
A-41281 COLLAR
B-90098-W SHANK

STD Caliber - 30-06
D-49577-S REAMER (replaces B-53297)
A-41281 COLLAR
B-90098-W SHANK

STD Caliber - 30-06
D-49577-S REAMER (replaces B-53297)
A-41281 COLLAR
B-90098-W SHANK

STD Caliber - 30-06
D-49577-S REAMER (replaces B-53297)
A-41281 COLLAR
B-90098-W SHANK

STD Caliber - 30-06
D-49577-S REAMER (replaces B-53297)
A-41281 COLLAR
B-90098-W SHANK

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STD Caliber - 30-06
D-49577-S REAMER (replaces B-53297)
A-41281 COLLAR
B-90098-W SHANK

STD Caliber - 30-06
D-49577-S REAMER (replaces B-53297)
A-41281 COLLAR
B-90098-W SHANK

STD Caliber - 30-06
D-49577-S REAMER (replaces B-53297)
A-41281 COLLAR
B-90098-W SHANK

STD Caliber - 270 WSM
D-49577-MM REAMER
A-41281 COLLAR
B-90098-V SHANK

STD Caliber - 270 WSM
D-49577-MM REAMER
A-41281 COLLAR
B-90098-V SHANK

STD Caliber - 270
D-49577-P REAMER
A-41281 COLLAR

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B-90098-V	SHANK
STD	Caliber - 270
D-49577-P	REAMER
A-41281	COLLAR
B-90098-V	SHANK
STD	Caliber - 270
D-49577-P	REAMER
A-41281	COLLAR
B-90098-V	SHANK
STD	Caliber - 270
D-49577-P	REAMER
A-41281	COLLAR
B-90098-V	SHANK
STD	Caliber - 270
D-49577-P	REAMER
A-41281	COLLAR
B-90098-V	SHANK
STD	Caliber - 270
D-49577-P	REAMER
A-41281	COLLAR
B-90098-V	SHANK
STD	Caliber - 270
D-49577-P	REAMER

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A-41281	COLLAR
B-90098-V	SHANK
STD	Caliber - 270
D-49577-P	REAMER
A-41281	COLLAR
B-90098-V	SHANK
STD	Caliber - 270
D-49577-P	REAMER
A-41281	COLLAR
B-90098-V	SHANK
STD	Caliber - 270
D-49577-P	REAMER
A-41281	COLLAR
B-90098-V	SHANK
STD	Caliber - 270
D-49577-P	REAMER
A-41281	COLLAR
B-90098-V	SHANK
STD	Caliber - 204

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D-49577-NN
A-41281
B-90098-H

REAMER
COLLAR
SHANK

STD

Caliber - 204

D-49577-NN
A-41281
B-90098-H

REAMER
COLLAR
SHANK

STD

Caliber - 300 WSM

D-49577- PP
A-41281
B-90098-T

REAMER
COLLAR
SHANK

STD

Caliber - 257 Roberts

D-49577-N
A-41281
B-90098-U

REAMER
COLLAR
SHANK

STD

Caliber - 260 REM

D-49577-R
A-41281
B-90098-V

REAMER (replaces B-82248)
COLLAR
SHANK

STD

Caliber - 280 REM

D-49577-R
A-41281
B-90098-V

REAMER (replaces B-82248)
COLLAR
SHANK

STD

Caliber - 308 WIN

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

STD Caliber - 308 WIN

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

STD Caliber - 35 WHELEN

D-49577-V REAMER (replaces B-47587)
A-41281 COLLAR
B-90098-Q SHANK

STD Caliber - 35 WHELEN

D-49577-V REAMER (replaces B-47587)
A-41281 COLLAR
B-90098-Q SHANK

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STD Caliber - 257 ROBERTS
D-49577-N REAMER (replaces B-46079)
A-41281 COLLAR
B-90098-U SHANK

STD Caliber - 25-06 REM
D-49577-M REAMER (replaces B-37794)
A-41281 COLLAR
B-90098-U SHANK

STD Caliber - 25-06 REM
D-49577-M REAMER (replaces B-37794)
A-41281 COLLAR
B-90098-U SHANK

STD Caliber - 25-06 REM
D-49577-M REAMER (replaces B-37794)
A-41281 COLLAR
B-90098-U SHANK

STD Caliber - 7MM-08 REM
D-49577-E REAMER (replaces B-45106)
A-41281 COLLAR
B-90098-V SHANK

STD Caliber - 7MM-08 REM
D-49577-E REAMER (replaces B-45106)
A-41281 COLLAR
B-90098-V SHANK

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STD Caliber - 7MM-08 REM

D-49577-E REAMER (replaces B-45106)

A-41281 COLLAR

B-90098-V SHANK

STD Caliber - 300 Savage

D-49577-JJ REAMER (replaces B-45106)

A-41281 COLLAR

B-90098-T SHANK

STD Caliber - 25.06 REM.

D-49577- M REAMER (replaces B-45106)

A-41281 COLLAR

B-90098-U SHANK

C-41560-A 30-06 SPRG - MIN Heading Plug

C-41560-B 30-06 SPRG - WMAX Heading Plug

C-41560-A 30-06 SPRG - MIN Heading Plug

C-41560-B 30-06 SPRG - WMAX Heading Plug

C-41560-A 30-06 SPRG - MIN Heading Plug

C-41560-B 30-06 SPRG - WMAX Heading Plug

C-41560-A 30-06 SPRG - MIN Heading Plug

C-41560-B 30-06 SPRG - WMAX Heading Plug

C-41560-A 30-06 SPRG - MIN Heading Plug

C-41560-B 30-06 SPRG - WMAX Heading Plug

C-41560-A 30-06 SPRG - MIN Heading Plug

C-41560-B 30-06 SPRG - WMAX Heading Plug

C-41560-A 30-06 SPRG - MIN Heading Plug

C-41560-B 30-06 SPRG - WMAX Heading Plug

C-41560-A 30-06 SPRG - MIN Heading Plug

C-41560-B 30-06 SPRG - WMAX Heading Plug

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C-41560-A	30-06 SPRG - MIN Heading Plug
C-41560-B	30-06 SPRG - WMAX Heading Plug
C-41560-A	30-06 SPRG - MIN Heading Plug
C-41560-B	30-06 SPRG - WMAX Heading Plug
C-41560-A	30-06 SPRG - MIN Heading Plug
C-41560-B	30-06 SPRG - WMAX Heading Plug
C-41560-A	30-06 SPRG - MIN Heading Plug
C-41560-B	30-06 SPRG - WMAX Heading Plug
C-41560-A	30-06 SPRG - MIN Heading Plug
C-41560-B	30-06 SPRG - WMAX Heading Plug
C-41560-A	30-06 SPRG - MIN Heading Plug
C-41560-B	30-06 SPRG - WMAX Heading Plug
C-41560-A	270 WIN - MIN Heading Plug
C-41560-B	270 WIN - WMAX Heading Plug
C-41560-A	270 WIN - MIN Heading Plug
C-41560-B	270 WIN - WMAX Heading Plug
C-41560-A	270 WIN - MIN Heading Plug
C-41560-B	270 WIN - WMAX Heading Plug
C-41560-A	270 WIN - MIN Heading Plug
C-41560-B	270 WIN - WMAX Heading Plug
C-41560-A	270 WIN - MIN Heading Plug
C-41560-B	270 WIN - WMAX Heading Plug
C-41560-A	270 WIN - MIN Heading Plug
C-41560-B	270 WIN - WMAX Heading Plug
C-41560-A	270 WIN - MIN Heading Plug
C-41560-B	270 WIN - WMAX Heading Plug
C-41560-A	270 WIN - MIN Heading Plug
C-41560-B	270 WIN - WMAX Heading Plug
C-41544-A	280 REM - MIN Heading Plug
C-41544-B	280 REM - WMAX Heading Plug
C-41544-A	280 REM - MIN Heading Plug

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C-41544-B	280 REM - WMAX Heading Plug
C-70556-A	300 SAV - MIN Heading Plug
C-70556-B	300 SAV - WMAX Heading Plug
C-41556-A	308 WIN - MIN Heading Plug
C-41556-B	308 WIN - WMAX Heading Plug
C-41556-A	308 WIN - MIN Heading Plug
C-41556-B	308 WIN - WMAX Heading Plug
C-41556-A	308 WIN - MIN Heading Plug
C-41556-B	308 WIN - WMAX Heading Plug
C-41556-A	308 WIN - MIN Heading Plug
C-41556-B	308 WIN - WMAX Heading Plug
C-41356-A	35 WHELEN - MIN Heading Plug
C-41356-B	35 WHELEN - WMAX Heading Plug
C-41356-A	35 WHELEN - MIN Heading Plug
C-41356-B	35 WHELEN - WMAX Heading Plug
C-41560-A	25-06 REM - MIN Heading Plug
C-41560-B	25-06 REM - WMAX Heading Plug
C-41560-A	25-06 REM - MIN Heading Plug
C-41560-B	25-06 REM - WMAX Heading Plug
C-41560-A	25-06 REM - MIN Heading Plug
C-41560-B	25-06 REM - WMAX Heading Plug
C-41543-A	257 ROBERTS - MIN Heading Plug
C-41543-B	257 ROBERTS - WMAX Heading Plug
C-41556-A	7MM-08 REM - MIN Heading Plug
C-41556-B	7MM-08 REM - WMAX Heading Plug
C-41556-A	7MM-08 REM - MIN Heading Plug
C-41556-B	7MM-08 REM - WMAX Heading Plug
C-41556-A	7MM-08 REM - MIN Heading Plug
C-41556-B	7MM-08 REM - WMAX Heading Plug
C-52496-A	270 WSM - MIN Heading Plug
C-52496-B	270 WSM - WMAX Heading Plug
C-52496-A	270 WSM - MIN Heading Plug
C-52496-B	270 WSM - WMAX Heading Plug
C-52496-A	300 WSM - MIN Heading Plug
C-52496-B	300 WSM - WMAX Heading Plug

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C-82496-A
C-82496-B
C-70556-A
C-70556-B

300 WSM - MIN Heading Plug
300 WSM - WMAX Heading Plug
300 SAVAGE- MIN Heading Plug
300 SAVAGE- WMAX Heading Plug

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405

Fit and Head Bolt Assembly to Barrel Assembly
(SHOULDER SINGLE PASS: Smaller than .25 caliber)

Viewing all

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

Fit bolt assembly to barrel assembly.

- 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

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release chuck. Make sure barrel chamber is positioned 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. (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

Tool Number	Tooling Description
F-76039	Machine

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A-85656	Scraping Tool - Ejector hole
D-46967	Fixture
STD	ACCU-HUE 2000
STD	STEELCARD 1301-NL
STD	Caliber - 17 REM
D-49577-F	REAMER (replaces B-38161)
A-41139	COLLAR
B-90098-P	SHANK
STD	Caliber - 6MM REM
D-49577-B	REAMER (replaces B-54694)
A-41281	COLLAR
B-90098-R	SHANK
STD	Caliber - 22-250
D-49577-G	REAMER (replaces B-87513)
A-41281	COLLAR
B-90098-S	SHANK
STD	Caliber - 22-250
D-49577-G	REAMER (replaces B-87513)
A-41281	COLLAR
B-90098-S	SHANK
STD	Caliber - 22-250
D-49577-G	REAMER (replaces B-87513)
A-41281	COLLAR

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B-90098-S	SHANK
STD	Caliber - 220 SWIFT
D-49577-H	REAMER (replaces B-49136)
A-41139	COLLAR
B-90098-S	SHANK
STD	Caliber - 222 REM
D-49577-J	REAMER (replaces B-54136)
A-41139	COLLAR
B-90098-S	SHANK
STD	Caliber - 223 REM
D-49577-K	REAMER (replaces B-54136-S)
A-41139	COLLAR
B-90098-S	SHANK
STD	Caliber - 223 REM
D-49577-K	REAMER (replaces B-54136-S)
A-41139	COLLAR
B-90098-S	SHANK
STD	Caliber - 223 REM
D-49577-K	REAMER (replaces B-54136-S)
A-41139	COLLAR
B-90098-S	SHANK
STD	Caliber - 223 REM
D-49577-K	REAMER (replaces B-54136-S)
A-41139	COLLAR
B-90098-S	SHANK
STD	Caliber - 243 WIN
D-49577-L	REAMER (replaces B-83504)

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A-41281	COLLAR
B-90098-R	SHANK
STD	Caliber - 243 WIN
D-49577-L	REAMER (replaces B-83504)
A-41281	COLLAR
B-90098-R	SHANK
STD	Caliber - 243 WIN
D-49577-L	REAMER (replaces B-83504)
A-41281	COLLAR
B-90098-R	SHANK
STD	Caliber - 243 WIN
D-49577-L	REAMER (replaces B-83504)
A-41281	COLLAR
B-90098-R	SHANK
STD	Caliber - 243 WIN
D-49577-L	REAMER (replaces B-83504)
A-41281	COLLAR
B-90098-R	SHANK
STD	Caliber - 243 WIN
D-49577-L	REAMER (replaces B-83504)
A-41281	COLLAR
B-90098-R	SHANK
C-41185-A	17 REM - MIN Heading Plug

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C-41185-B	17 REM - WMAX Heading Plug
C-53322-A	204 RUGER - MIN Heading Plug
C-53322-B	204 RUGER - WMAX Heading Plug
C-53322-A	204 RUGER - MIN Heading Plug
C-53322-B	204 RUGER - WMAX Heading Plug
C-41521-A	22-250 REM - MIN Heading Plug
C-41521-B	22-250 REM - WMAX Heading Plug
C-41521-A	22-250 REM - MIN Heading Plug
C-41521-B	22-250 REM - WMAX Heading Plug
C-41521-A	22-250 REM - MIN Heading Plug
C-41521-B	22-250 REM - WMAX Heading Plug
C-41154-A	222 REM - MIN Heading Plug
C-41154-B	222 REM - WMAX Heading Plug
C-41155-A	223 REM - MIN Heading Plug
C-41155-B	223 REM - WMAX Heading Plug
C-41155-A	223 REM - MIN Heading Plug
C-41155-B	223 REM - WMAX Heading Plug
C-41155-A	223 REM - MIN Heading Plug
C-41155-B	223 REM - WMAX Heading Plug
C-41556-A	243 WIN - MIN Heading Plug
C-41556-B	243 WIN - WMAX Heading Plug
C-41556-A	243 WIN - MIN Heading Plug
C-41556-B	243 WIN - WMAX Heading Plug
C-41556-A	243 WIN - MIN Heading Plug
C-41556-B	243 WIN - WMAX Heading Plug
C-41556-A	243 WIN - MIN Heading Plug
C-41556-B	243 WIN - WMAX Heading Plug
C-41556-A	243 WIN - MIN Heading Plug
C-41556-B	243 WIN - WMAX Heading Plug
C-41556-A	243 WIN - MIN Heading Plug
C-41556-B	243 WIN - WMAX Heading Plug
C-41195-A	6MM REM - MIN Heading Plug
C-41195-B	6MM REM - WMAX Heading Plug

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415 Fit and Head Bolt Assembly to Barrel Assy and Chamber to Length (B)

7013

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

Fit bolt assembly to barrel assembly.

- 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

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- into quick release chuck. Make sure barrel chamber is positioned 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).

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- o. Insert belt 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.
- 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

Tool Number	Tooling Description
F-76039	Machine - Special Chambering Mach.

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A-88656
P-46967

STD

STD:

Scraping Tool - Ejector hole
Fixture

ACCU-RITE 2408

STEELGRIP 1302-NL

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420 Ream Chamber to Deburr (BELTED - MAGNUMS)

Step	Operation / Step Description
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Ream Chamber to Deburr - (BELTED - MAGNUMS)	
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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.

Tool Number

Tooling Description

C-49758

Burnish Tool
Shank Std.

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Make Chamber Cast (Not Done on 100% of Product - See NOTE below)

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 (1) per hundred on large runs. Small lots 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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Tool Number
D-52773

Tooling Description
Casting Ladle

PROCESS CONTROL INSPECTION RECORD THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES				Revision Date: 12-Oct-05		Processed by:	
#REF!	Part Name: Fin Assy 700-BDL		Centerfire Rifle			Date: 8/14/2006	
#REF!	Operation: #REF!					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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427 Assemble Rear Sight Assembly, Front Sight to Barrel Assembly

Step Operation / Step Description

Assemble Rear Sight Assembly and Front Sight to Barrel Assembly Complete

PROCEDURE:

- 1 Select Barrel Assembly Complete from Truck & Place in Vise

Note: Place a NALTEX VINYL CAP on the Ball of the Bolt Handle if one was not installed during the heading operation.

- 2 Apply a drop of Loctite 241 into rear front sight hole.
- 3 Select, Inspect, and Assemble Front Sight with (1) Screw
- 4 Select, Inspect, and Assemble Rear Sight Assembly with (2) Screws
- 5 Remove Barrel Assembly Complete from Vise, inspect sight alignment.
- 6 Place Barrel Assembly Complete in Barrel Truck

Tool Number

Tooling Description

E-82757	Front Sight Fixture (use on two sight piece only)
STD	Vise

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EPA 102 RM60

Air Screwdriver - Ingersoll Rand

1100 RPM

STD

Bench

PROCESS CONTROL INSPECTION RECORD THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES			Revision Date: 12-Oct-05			Processed by:
Part No:	Part Name: Fin Assy 700 BDL		Centerfire Rifle			Date: 8/14/2006
Operation No: 427	Operation: Assemble Rear Sight Assembly, Front Sight to Barrel Assembly					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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428 Assemble Front & Rear Scope Bases to Barrel Assembly Complete

PROCESS CONTROL INSPECTION RECORD THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES			Revision Date: 12-Oct-05			Processed by:
Part No:	Part Name: Fin Assy 700 BDL		Centerfire Rifle			Date: 8/14/2006
Operation No: 428	Operation: Assemble Front & Rear Scope Bases to 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			
Pieces Run:					Remington Arms Company, Inc. -- Ilion, New York	

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430 Ream Ejector Hole

Step	Operation / Step Description
	Ream Ejector Hole
	Remove Burr thrown into Ejector Hole by Flat Scrape
	1. Grind Flat on Point of Drill with Belt Sander
	2. Adjust Drill in Chuck to Bottom in Master Bolt for Depth

Tool Number	Tooling Description
STD	#28 DRILL

PROCESS CONTROL INSPECTION RECORD THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES				Revision Date: 12-Oct-05		Processed by:	
Part No:		Part Name: Fin Assy 700 BDL		Centerfire Rifle		Date: 3/14/2005	
Operation No: 430		Operation: Ream Ejector Hole					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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431 Form Radius on Edge of Firing Pin Hole
Note: Only done on 17 cal. BDL and 25.06 in this process.

Tool Number Tooling Description

A-38640 Punch

Std. Hammer

PROCESS CONTROL INSPECTION RECORD THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES			Revision Date 12-Oct-05			Processed by:
Part No:	Part Name: Fin Assy 700 BDL		Centerfire Rifle			Date: 8/14/2006
Operation No: 431	Operation: Form Radius on Edge of Firing Pin Hole					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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432 Assemble Riveted Extractor to Bolt - (MAGNUMS)

Step	Operation / Step Description
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	Assemble Riveted Extractor to Bolt - (MAGNUMS)
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PROCEDURE:

- 1 Extractor Must Be Shaped to Bolt Thread 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 Re chamfer 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 re chamfering 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.
 - c. Apply a light coating of oil to prevent oxidation of the colored area.

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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.

Tool Number	Tooling Description
D-84993	Fixture
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
STD	Dental Grinder
=====	=====
	MAX SHELL
B-84831-A	MAX SHELL Small Rifle
B-84831-B	MAX SHELL Large Rifle
B-84831-C	MAX SHELL Belted Magnums
=====	=====
	TENSION
B-87034-A	TENSION Small Rifle
B-87034-C	TENSION Large Rifle

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B-87034-D
B-87034-E

TENSION Belted Magnums
TENSION Swedish 6.5x55 1994 Classic

PROCESS CONTROL INSPECTION RECORD THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES				Revision Date: 12-Oct-05		Processed by:
Part No:	Part Name:	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			
MAX SHELL Small Rifle	B-84831-A	100%	REJECT INSPECT			
MAX SHELL Large Rifle	B-84831-B	100%	REJECT INSPECT			
MAX SHELL Belted Magnums	B-84831-C	100%	REJECT INSPECT			
TENSION Small Rifle	B-87034-A	100%	REJECT INSPECT			
TENSION Large Rifle	B-87034-C	100%	REJECT INSPECT			
TENSION Belted Magnums	B-87034-D	100%	REJECT			

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TENSION Swedish 6.625 1984 Classic	B-83034-E	100%	INSPECT REJECT INSPECT		
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			REJECT		
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435 Assemble Rivetless Extractor to Bolt

Step	Operation / Step Description
------	------------------------------

	Assemble Rivetless Extractor to Bolt
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- | | |
|----|---|
| 1 | Extractor Must Be Shaped to Bolt Shroud by Adjusting Both Ends of Claw of Extractor (if necessary) Must Be Checked on Tension Ring for "Go" and "No Go" |
| a. | Extractor Must Clear Min Tension Plug and Have Tension on Max Tension Plug |

Go gage should pass freely by the extractor, without touching it. If contact is noted, remove a small amount of material from the edge of the claw until the Go plug passes freely.

No-Go gage should NOT pass by the extractor without touching. SOME contact is required. If no contact is observed replace the extractor.

- | | |
|---|--|
| 2 | Max Shell Head Plug Must Compress Extractor and Bottom on Face of Bolt |
|---|--|

This plug MUST go past the extractor to the bolt face. "Noticeable" tension is expected with this gage. If the gage will not pass the extractor it may be possible to remove some material from the claw edge but the above gage must be satisfied. It may be necessary to replace the bolt assembly.

- | | |
|----|--------------------------------|
| 3 | Blend Extractor to Bolt Shroud |
| a. | Check Extractor with Pick |

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- Must Not Be Deformed or Loose

Tool Number	Tooling Description
B-87034-A	"Go" Tension Plug - .348 (17, 221, 222, 223)
B-87034-B	"No-Go" Tension Plug - .358
B-84831-A	"Max" Cartridge Plug - .378
B-87034-C	"Go" Tension Plug - .435 (22-250, 243, 300, 30-06, 270, etc.)
B-87034-D	"No-Go" Tension Plug - .445
B-84831-B	"Max" Cartridge Plug - .473
B-87034-D	"Go" Tension Plug - .495 (Belted Mag, Ultra-Mag, Short Ultra-Mag)
B-87034-D	"No-Go" Tension Plug - .505
B-84831-C	"Max" Cartridge Plug - .532

PROCESS CONTROL INSPECTION RECORD				Revision Date:		Processed by:	
THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES				12-Oct-05			
Part No:		Part Name: Fin Assy 700 BDL		Centerfire Rifle		Date: 8/14/2005	
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		Remarks, Causes, Action Taken, Etc.	
VISUAL		VISUAL		100%			
"Go" Tension Plug - .348 (17, 221, 222, 223)		B-87034-A		100%			

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440 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
 - c. Visual check of ejector's height in bolt (should not set down in bolt)

Tool Number	Tooling Description
C-51730	Fixture
A-89656	Scraping Tool - Ejector hole
C-40296	Fixture (L.H.)
A-48261	Pin Punch
B-54504	Drive Punch (Drive Out Tight Ejector Pin)
C-53663	Fixture

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460R Strip Defective Barrel Assembly Complete

PROCESS CONTROL INSPECTION RECORD THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES			Revision Date: 12-Oct-05			Processed by:
Part No:	Part Name: Fin Assy 700 BDL		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			
Pieces Run:					Remington Arms Company, Inc. -- Ilion, New York	

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465R Strip Defective Bolt

PROCESS CONTROL INSPECTION RECORD THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES			Revision Date: 12-Oct-05			Processed by:
Part No:	Part Name: Fin Assy 700 BDL		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			
Pieces Run:					Remington Arms Company, Inc. - Ilion, New York	

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Wire brush and dry barrel

Using a wire chamber brush, carefully scrub chamber to loosen all residue that may remain. Follow up with a chamber cleaning swab or flannel patch to clean and thoroughly dry the chamber.

Using a bore cleaning rod and flannel patch, slide rod through from the chamber end remove any residue from the bore that may run back into the chamber.

NOTE: Change flannel or swab frequently to insure effective cleaning.

Apply Rem Dry Lube -or- MolyKote dry powder to cloth swatch and lube chamber. Apply product evenly but sparingly to coat the entire chamber.

Tool Number	Description
Std	Cleaning rod
Std	"T" Handle
Std	Spool of flannel
Std	20 Gage bore brush to use as chamber brush
Std	Rem Dry Lube
Std	Moly-Kote dry powder

PROCESS CONTROL INSPECTION RECORD THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES		Revision Date: 31-Aug-05	Processed by:
Part No:	Part Name: Fin Assy 700 UM	Centerfire Rifle	Date: 8/14/2006

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Operation No: 575

Prod. Qty:

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

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

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580

Assemble Action

Step

Operation / Step Description

Assemble Rifle and Attach Build Tag to Trigger Guard.

PROCEDURE:

- 1 Select Barrel Assembly Complete from Truck and Inspect for:
 - a. Magna-Flux Stamp
 - b. Serial Number Legible on Receiver
 - c. Rollmark Legible on Barrel
 - d. Uniform Color
 - e. Marrs
- 2 Select Firing Pin Assembly and Inspect for:
 - a. Point Not Marred
 - b. Bolt Plug Color
 - c. No Rust
- 3 Remove Bolt Assembly from Receiver and Inspect for:
 - a. Marrs & Color, No Rust or Miscuts (Cam Cut & Cocking Notch present)
 - b. Presence of Maltex Vinyl Cap on Ball of Bolt Handle
 - c. Presence of Hardness Test Prick Punch Stamp on Bolt Head
 - d. Presence of Pull Test Prick Punch Stamp on Bolt Head
 - e. Presence of Tensil Prick Punch Stamp on Bolt Handle
 - f. Handle Straight and Flush with Back of Bolt Body
 - g. Use Reamer A-88003 If Necessary, to Clear Firing Pin Hole
- 4 Assemble Firing Pin into Bolt Body:

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- a. Use Bolt Assembly Tool (D-48553) on Bolt Plug Fully Pull the Handle Back
 - Retracting the Firing Pin
 - b. Check for Firing Pin Head Cross Pin (Look Through Hole in Tool)
 - c. Lubricate Bolt Plug Threads and Firing Pin Assembly with Molykote Paste or Powder
 - d. Thread the Firing Pin Assembly into the Bolt Assembly until it Stops
 - The Firing Pin Head Slot Should Go Past the Cocking Notch by about 1/8 of a Turn
 - e. Back Thread the Firing Pin Assembly slightly
 - The Firing Pin Head Should Fall Into the Cam Cut when the Tool is Released
 - f. Check Firing Pin Protrusion using Gage B-52089
 - g. Retract the the Firing Pin as above in Step "a."
 - h. Thread the Firing Pin back in until it Stops
 - i. Release Assembly Tool and Rotate the Bolt Plug back until the Firing Pin Snaps Into the Cocking Notch
 - j. Remove Assembly Tool
 - k. Visually Check: Firing Pin Is Not Protruding through the Bolt Head
 - A GAP No Larger than .030 Should Exist between the Bolt Plug and the Back of the Bolt Handle
(Use Shim A-43977 for .030" Max.)
- 5 Check Bolt Operation:
- a. Insert Bolt into Receiver and Push Forward
 - Check that the Bolt Slides Freely With NO Drag
 - b. If the Bolt is Tight:
 - Perform the Following Checks
 - If Not:
 - Skip to Step "7"
 1. Check Bolt Plug Slot and Firing Pin Head for Alignment
 - Firing Pin Head Should Slide Freely with NO Drag
 2. Check Firing Pin Head for Marks
 - No Digs, Scratches or Surface Conditions of ANY kind should be Visible

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- If Surface Conditions are Noticed, Check Receiver Firing Pin Head Clearance Slot on Tang for Indications of Interference
- 3. Check Cocking Notch
 - DO NOT FILE!
 - If Out of Place, Skip to Step "6"
- 4. Check Bolt Handle Position
 - It Should Blend with Bolt Plug on the Bottom & Be Flush with the Back of the Bolt Body
 - If not, Skip to Step "6"
- 5. Reinsert Bolt Assembly into Receiver and Repeat Check for Tightness as in Step "5-a" Above
- 6. Scrap the Bolt Assembly and Return Barrel Assembly Complete to Heading
- 7. Select (4) Receiver Plug Screws and Install in Scope Mounting Holes on top of Receiver Using Ratchet Screwdriver
- 8. Select Trigger Assembly
 - a. Check for Presence of Builders Prick Punch Stamp
 - b. Check for Play in Safety Arm and that it Snaps Firmly from Detent to Detent
- 9. Insert Trigger Assembly in Receiver
 - a. Trigger Assembly Must Fit Freely
 - b. File Burrs If Necessary
 - DO NOT File Heavy on Slot Sides
 - Maintain Slot Center and Straightness at ALL Times
- 10. Select Sear Pin and Start in Sear Pin Hole
 - a. Drive in Flush to Inside of Bolt Stop Cut
- 11. Select Bolt Stop Release and Position in Receiver
 - a. Bolt Stop Must Fit Freely in Receiver
 - b. File Burrs If Necessary
 - DO NOT File Heavy on Slot Sides

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- Maintain Slot Center and Straightness at ALL Times
 - 12 Select Bolt Stop Spring
 - a. Position in Receiver
 - 13 Position Trigger Assembly
 - a. Adjust Fire Control Location
 - Check that Bolt Stop Release is Free
 - b. Select Bolt Stop Pin and Assemble into Receiver
 - c. Adjust Top Ear of Bolt Stop Release to Engage Notch in Bolt Stop
 - Release Should Work Freely
 - 14 Stake Sear Pin and Bolt Stop Pin with a Center Punch and Hammer
 - 15 Select Correct Magazine
 - a. Inspect for:
 - 1. Color
 - 2. NO Rust
 - 16 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.
- 17 Place Safety in "S" or "ON" Position

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18 Close the Action and Lock Bolt Down

Tool Number	Tooling Description
A-88003	Taper Reamer for Braze in Firing Pin Hole
301467	Molykote GM Paste or Powder Lubricant
305787	VC-NYLYEX VINYL CAPS
STD	Ball Handle Ratchet Screwdriver (Mcmaster Carr no. 6962A14 or Equivalent)
D-48553	Bolt Assembly tool
5/32" pt. dia.	Center Punch (Mc-Master Carr no.3417A1 or Equivalent)
STD	Hammer 8 oz. Set (Mc-Master Carr no. 5860A5 or Equivalent)
B-52089	Firing Pin Protrusion Gage
B-80652	Pins Tightness Tester
B-70697	Trigger Pull Scale

PROCESS CONTROL INSPECTION RECORD THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES		Revision Date: 12-Oct-05	Processed by:
Part No:	Part Name: Fin Assy 700 BDL	Centerfire Rifle	Date: 8/14/2006
Operation No: 580	Operation: Assemble Action		Work Center:

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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			
Firing Pin Protrusion Gage	B-52089	100%	INSPECT			
			REJECT			
Pins Tightness Tester	B-80652	100%	INSPECT			
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			REJECT			
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585 Assemble Stock to Action & Attach Build Tag to Trigger Guard

Step	Operation / Step Description
	ASSEMBLE STOCK TO ACTION
1	Place Magazine into Receiver a. Formed Sidewalls up towards Feedlips b. Position to be All the way Forward
2	Select Correct Stock Inspect for: a. Good Finish b. Marrs Slight c. No Checks d. Grip Outline Reasonably Uniform and Square Inspect Butt Plate for: a. Black b. Rear Face - No Burrs c. .005 Max. Opening at Face d. Tight (Finger Test) e. Screws Do Not Project Objectionably f. Burrs at Screw Holes are Slight g. .020 Max. Mismatch of Butt Plate and Stock Either Way Inspect and Reject for Visual Damage: a. Hand Print Defect Code Number on Color Dot b. Affix Adhesive Color Dot to Stock Beside the Defect
3	Place Stock onto Receiver/Barrel Assembly

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4. Select & Inspect Floor Plate Assembly
- Place in Stock
5. Assemble Floor Plate Assembly and Stock to Barrel Assembly Complete with Front and Rear Trigger Guard Screws.
- Using Pneumatic Power Driver, or Hall Patchet Screwdriver
With gun in vice hold stock firmly forward so that the Barrel Bracket is 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 - 35 IN*LBS - per torque spec. Next torque rear take down screw to 35 IN*LBS then (ADL'S) the center take down screw SHOTS ONLY
6. Check for Trigger Clearance In Guard and Floor Plate
 - a. Trigger Must Not Be Exposed Outside of Guard
 - b. A (.030) Shim Tool Must Fit Between End of Trigger and Inside of Guard Bow While Trigger is in Full Rearward or Relaxed Position
 - c. If it Fails the Tool, See Procedure Below for Shim Placement Under Trigger Guard

Note: Shim Tool Part No. A-43977

Shim Placement Procedure if Required;

- a) Remove Trigger Guard from Stock Assembly
- b) Remove Non-Stick Back from Shim
- 92850 (front)
Place the Sticky Side of Spacer to the Stock Aligning the Guard Hole with the Hole in the Spacer and Press Firmly to Ensure Adhesion
- c) Repeat Above Procedure for the Shim
- 92849 (rear)
- d) Check Trigger Clearance Again
 - If it Passes
Proceed to Step "22"
 - If it Fails
Continue with Part "e"

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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 Shim

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

6A 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

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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.

7. Assemble Front Swivel Screw with Washer to Stocks that call for a Swivel.
8. Assemble Magazine Spring to Magazine Follower
 - a. Install in Floor Plate
 - b. Adjust Floor Plate to Latch Properly - (See Sample)
9. Inspect Margin at Ejection Port and Receiver Tang, per .030 Shim
 - a. Opening Between Stock & Receiver Should Be Uniform, No Chip's 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 Acceptable if Uniform
 - Reject if Edge is Jagged
 - d. Gas Hole in Receiver 50% Visible Above Stock
10. Use Dummy Cartridges to Check Feeding, Extraction, and Ejection (Single Load and Full Magazine)
11. Check function of Safety
 - a. Cock Rifle
 - b. Move Safety Arm to "S" or "ON" Position
 1. No Bind
 2. Must Be Clearance Between Sear and Trigger Connector
 3. Good Detent

Note: Safety Should Snap in Detent in Both "S" or "ON" and in "F" or "OFF" Position

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4. Close Bolt and Lock Down
 - a. Must Lock Down Without Catching on Safety
 - b. Firing Pin Must NOT Follow Down
 - c. Bolt Must Open With Safety in "ON" Position
5. Pull Trigger
 - a. Apply Heavy Pressure to Trigger
 - b. Trigger MUST NOT Move
 - c. Action MUST NOT Fire
 - d. Release Trigger
 - e. Trigger MUST Retract
- c. Move Safety to "F" or "OFF" Position
 1. Moving the Safety from "S" to "F" MUST NOT Fire the Action
 2. Firing Pin Must NOT Follow Down
 3. Pull Trigger
 - a. No Click or Catch in Pull
 - b. Trigger MUST Retract when Released
 - c. Action MUST Fire
- d. Cock Rifle and Move Safe to "S" or "ON" Position
- e. Push Safety Forward toward "Fire" Position to a Null Position
 - Using Both Thumbs Attempt to Position Safety in a Stable Middle Location "Balanced" between Safe and Fire:
 1. If Safety CANNOT be "Balanced" between Safe and Fire Position
 - Safety MUST Move to "F" or "OFF" Position Under Tension when Released
 - Proceed to Step "f"
 2. If Safety CAN be "Balanced" between Safe and Fire Position
 - the Following Test Should be Performed 3 Times
 - a) With Safety "Balanced" in a Middle Location, Pull Trigger Firmly
 - Safety MUST NOT Move
 - RIFLE MUST NOT FIRE
 - b) Release Trigger
 - c) Move Safety from Middle Position to Fire Position Without Touching Trigger
 - RIFLE MUST NOT FIRE

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- d) Proceed to Step "f" when All Three Cycles are Complete
- f. Push Safety to "S" or "ON" Position

Notes: safety MUST Snap to "S" or "ON" Position Under Tension

Note: Bolt Handle Must Unlock with Safety in "S" or "ON" Position

- g. Close Bolt with Firm Pressure
 - 1. Firing Pin MUST NOT Follow Down
 - 2. Safety MUST Remain in "S" or "ON" Position
 - h. Check Bolt Function
 - 1. With Bolt Open Pull Safety to "S" or "ON" Position
 - 2. Close Bolt and Lock Down
 - 3. Bolt Must Lock Down Without Catching on Safety
 - 4. Bolt Must Open With Safety in "S" or "ON" Position
 - i. Perform the Above Checks "a" thru "c" (3) Times
- 12 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
- 13 Check Trigger Pull (4.75 to 5.75 lbs.) parallel with action
- 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.
- 14 Check for "Jar Off"

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- a. 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
 - Rifle Must NOT Fire
- 15 Check Sear Lift 130%
- a. Remove Bolt Assembly
 - b. Place Safety in "F" Position
 - Pull Trigger All The Way Rearward
 - Fully Depress Sear
 - Sear Must Return to Fully Up Position Without Drag
 - If Sear Binds or Drags
 - 1. REJECT THE RIFLE
 - 2. Mark the Reject Reason on the Reject Ticket
 - c. Place Safety in "F" Position and Bolt Removed
 - Insert Attribute Gage #C-47741 into Receiver
 - 1. Must Stop on Sear
 - If Gage Protrusion on the Bottom Overrides Sear
 - 1. REJECT THE RIFLE
 - 2. Mark the Reject Reason on the Reject Ticket
- 16 ALTERNATE SEAR LIFT CHECKING METHOD
- a. With Safety in "F" Position and Bolt Removed
 - 1. Insert dial Gage #D-44581 into Receiver
 - Must Stop on Sear
 - 2. Move Safety to "S" Position
 - 3. Observe Dial
 - Lift Must Be between .008 & .018
 - If Reading is Outside Range
 - 1. REJECT THE RIFLE
 - 2. Mark the Reject Reason on the Reject Ticket

NOTE: This Test Done Normally at Final Inspection and is Only Performed here as an Alternate Check

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- 17 Verify Firing Pin Head Will Release from Cocking Notch by Squeezing and Holding Trigger while Closing and Locking Down Bolt Slowly
 - a. Firing Pin MUST Follow Down
 - b. Slight Trigger Play May Be Detectable After Firing
- 18 Place Safety in "S" or "ON" Position
- 19 Place Assemblers ID Sticker Number on back of hang tag. Attach hang tag to trigger guard.
- 20 Make All Necessary Repairs from Test
- 21 Clean Bore
 - a. Insert Brass Cleaning Rod in Chamber End with Cleaning Patch
 - b. Wipe Bore
 - Rod Must Have Sufficient Flannel Cleaning Patch to Clean Bore

Tool Number	Tooling Description
STD	Pneumatic Power Driver or Ball Ratchet Screwdriver
STD	Dummy Cartridge Rounds of Proper Caliber Being Built
7237T1	Lube Brush (McMaster-Carr Tin Ferrule, Natural Bristle Type Brush 5-3/4 O.A.L. 3/8W x 3/4L or Equivalent)
B-43447	Brass Wiping Rod

GAGES

STD	.006 Feeler Gage or Suitable Shim
C-47741	Sear Engagement Gage - Solid Bolt
STD	.006 Feeler Gage or Suitable Shim

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C-47741	Sear Engagement Gage - Solid Bolt
A-43977	Trigger Guard Clearance Shim Tool (.030")
Std	.002 Feeler Gage - Plastic
Std	.006 Feeler Gage - Plastic
B-70697	Trigger Pull Scale
B-72-7330	Dent & Scratch Template

PROCESS CONTROL INSPECTION RECORD			Revision Date			Processed by:
THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES			12-Oct-05			
Part No:	Part Name: Fin Assy 700 BDL		Centerfire Rifle			Date: 8/14/2006
Operation No: 585	Operation: Assemble Stock to Action & Attach Build Tag to Trigger Guard					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			
.006 Feeler Gage or Suitable Shim	STD	100%	REJECT INSPECT			
Sear Engagement Gage - Solid Bolt	C-47741	100%	REJECT INSPECT			
.006 Feeler Gage or Suitable Shim	STD	100%	REJECT INSPECT			
Sear Engagement Gage - Solid Bolt	C-47741	100%	REJECT INSPECT			
Trigger Guard Clearance Shim Tool (.030")	A-43977	100%	REJECT			

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002 Feeler Gage - Plastic	Std	100%	INSPECT			
			REJECT			
			INSPECT			
003 Feeler Gage - Plastic	Std	100%	REJECT			
			INSPECT			
Trigger Pull Scale	B-70697	100%	REJECT			
			INSPECT			
Dent & Souff Template	B-TS-7300	100%	REJECT			
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Pieces Run:			REJECT			
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593 Assemble Front Swivel Screw and Swivel Screw
Spacer to Stock

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

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

PROCESS CONTROL INSPECTION RECORD THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES		Revision Date: 12-Oct-05	Processed by:
Part No:	Part Name: Fin Assy 700 BDL	Centerfire Rifle	Date: 8/14/2006

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Proof Test

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 shot gun proof
booths unless told to do otherwise.(supervision)

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.)

B. All assembled guns are to be stored with the action open and the

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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 boxes 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, from the builders, 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. (see quality standard sheet)
- d. Check for Firing Pin Protrusion or Foreign material at Face of Bolt:

1. Firing Pin must be retracted in the Bolt.

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2. Bolt Face and Shroud must be free from any foreign material.

NOTE: Visually check all guns 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 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. Fill out white reject ticket.
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 to 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 ticket 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 (REF), right rear side of Barrel ON ACCEPTABLE PRODUCTS ONLY.
 - a. Stamp prick punch on the underside of the bolt

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handle, in addition to the proof mark on the Barrel,
place tester sticker on back of hang tag.

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. Take first (1st) gun 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).

Tool Number

Tooling Description

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A-37058

Proof Stamp

C-37281

Proof Stamp Holder

STD.

Handset

STD.

Automatic Center Punch (CRANCHER no. 6C492 or equiv.)

PROCESS CONTROL INSPECTION RECORD			Revision Date			12-Oct-05			Processed by:		
THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES											
Part No:		Part Name: Fin Assy 700 BDL		Center fire Rifle			Date			8/14/2006	
Operation No: 600		Operation: Proof Test							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							

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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.

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Fired proof case will remain in the chamber.

Remove original bolt assembly from holder and insert in rifle.

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 THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES			Revision Date: 18-May-05			Processed by:
Part No:	Part Name: Fin Assy 700 ADL	Centerfire Rifle			Date: 8/14/2008	
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			
			REJECT			
			INSPECT			
			REJECT			

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604 Hand Chamfer Muzzle with a Live-Pilot Tool

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.

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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606

Test and Target

I. RIFLES TESTED AND TARGETED

NOTE: TARGET

This procedure is a deviation from 100% targeting that is in effect on this date, in favor of 10% sample targeting specified in the process (B).

From the beginning of each day a full load of each SKU that arrives for target must be targeted for group size. If all of the rifles on the load (at least 26) pass for group size then subsequent loads of the same SKU may be sample targeted, exactly as specified in the process record. If an initial SKU load does not pass then 100% target is required for the remainder of the day. Start over with 100% on all SKUs with each successive day.

- A. All rifles (100%) are to be tested after proof.
- B. 10% of std. models are to be targeted unless target rejects are found. If target rejects are found, 50 to 100% will be targeted. When calculating the initial 10% for std. models, always round up. (ie. for a 26 gun load, target 3)
- 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 testing jack can be used.
 - 1. If a testing jack is used, complete function test on entire truck. Then push the truck back to an accuracy device to target.

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.
 - f. Normal Sight Alignment as described below: (10%)
 - 1. Front and Rear Sight ramps must be central on barrel and straight with line of sight.
 - 2. Must conform to barrel - good fit - no excessive opening at side of ends, also must be screwed tight to barrel.
 - 3. Front and Rear Sights must be central on ramps - tight in dovetails, not twisted, bent or deformed.
 - 4. Mark on rear sight to coincide with fourth mark from rear of the rear sight ramp.
 - 5. Rear Sight Eyepiece must be positioned central to rear sight.

If not within specifications for items a-f 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.

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- 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" position.
9. If safety stops in halfway 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 11-13 pertain to guns being tested on accuracy device.

11. With Action open, position rifle in device and clamp.
12. For a rifle with iron sights, position sights if needed. Look down the sights and use to aim. Adjust device to point rifle on target paper. For a rifle without iron sights remove the bolt and look through bore to line up the device with paper.

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- a. For a rifle without sights that is difficult to target on the paper, an Optical Bore-Sight can be used. By inserting this unit in the muzzle using it's various adaptors, sighting can be achieved by looking through the eyepiece.
- b. For a rifle with iron sights that is difficult to target on paper, a line-o-sighter can be used on the sights to assist with gun alignment. By punching on the sights using the adapting fixture, sighting can be assisted.

14. 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. 17 Rem.	25 gr. HPPL	5
2. 222 Rem.	50 gr. PSP	5
3. 22-250 Rem.	55 gr. HPPL	4
4. 223 Rem.	55 gr. PSP	5
5. 6mm Rem.	80 gr. PSP	4
6. 243 Wir.	100 gr. PSPCL	4
7. 25.06 Rem.	120 gr. PSPCL	4
8. 257 Roberts	117 gr. SPCL	4
9. 270 Wir.	150 gr. SPCL	4
10. 280 Rem.	150 gr. PSPCL	4
11. 7mm-08 Rem.	140 gr. PSP	4
12. 204 Ruger	35 gr. ACCUTIP V	5
13. 7mm Rem. Mag.	175 gr. PSPCL	3
14. 300 Savage	150 gr. PSPCL	4
15. 30.06 Sprg.	180 gr. SPCL-150 gr. PSPCL	4
16. 308 Wir.	180 gr. SPCL-150 gr. PSPCL	4
17. 300 Wir. Mag.	180 gr. PSPCL	3
18. 35 Whelen OBS.	250 gr. PSP	4
19. 338 Wir. Mag.	250 gr. PSP	3
20. 416 Rem. Mag.	400 gr. PSP	3

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21.	300 WSM.	180 gr. Power PT (X300WSM)	3
22.	270 WSM.	130 gr. PSPCL	4

15. 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.

16. Open Bolt full stroke to rear position.

17. Close guard. (If on accuracy device)

18. 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.

19. Move safety to "F" or "OFF" position.

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20. If using accuracy device grip rifle in normal manner and fire by pulling trigger with finger. If using shooting jacks, fire rifle in same manner.
21. For the 10% of standard rifles and 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.
22. 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.
23. 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 3 to 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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24. Open guard. (If on accuracy device)

25. For the Targeted rifles (as outlined in I - B and C) Look through sighting glass and check point of Impact and group size.

- a. The average position of all shots fired in the group must be within the following specifications in relationship to the position of the crosshairs.

Elevation	Windage
2" High - 8" Low	9" Left - 9" Right

NOTE: Acceptance limits only apply when sights are positioned on the gun as described below.

Front Sight

-Front sight must not be bent, twisted, tipped or deformed

Rear Sight Ramp and Sight

-Ramp must be central in Barrel and straight with line of sight - level crosswise with Front Sight Ramp.

-Must conform to Barrel - good fit, no excessive opening at sides or ends, screwed tight to barrel.

-Rear Sight and Eyepiece must be level crosswise with line of sight as viewed from rear - Not tipped twisted or bent.

-Mark on elevating piece set to coincide with fourth mark from rear on rear sight ramp.

-Rear Sight Eyepiece good fit in dovetail of elevating slide - no excessive opening.

-Rear Sight Eyepiece positioned central crosswise with Windage Screw

- b. Use spotting scope, for rifles that do not have iron sights, to check group size.

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

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GROUP SIZE SPECIFICATIONS

700 BDL

CALIBER	AMMUNITION TYPE	MAX. GROUP CENTER TO CENTER		
		3 SHOT	4 SHOT	5 SHOT
1. 17 Rem.	25 gr. HPPL	1.5	2.0	2.2
2. 222 Rem.	50 gr. PSP	1.5	2.0	2.2
3. 204 Ruger	32 gr. ACCUTIE V	1.5	2.0	2.2
4. 22-250 Rem.	55 gr. HPPL	1.5	2.0	2.2
5. 223 Rem.	55 gr. PSP	1.5	2.0	2.2
6. 6mm Rem.	80 gr. PSI	1.5	2.0	2.2
7. 243 Wir.	100 gr. PSPCL	1.5	2.0	2.2
8. 25-06 Rem.	120 gr. PSPCL	1.7	2.2	2.7
9. 257 Roberts	117 gr. SPCL	1.7	2.2	2.7
10. 270 Wir.	150 gr. SPCL	1.7	2.2	2.7
11. 280 Rem.	150 gr. PSPCL	1.7	2.2	2.7
12. 7mm-08 Rem.	140 gr. PSP	1.7	2.2	2.7
13. 300 WSM	180 gr. Power PT	1.7	2.2	2.7
14. 270 WSM	130 gr. PSPCL	2.5	3.0	3.5
15. 7mm Rem. Mag.	175 gr. PSPCL	2.5	3.0	3.5
16. 30-06 Sprg.	180 gr. SPCL	1.7	2.2	2.7
17. 300 Savage	150 gr. PSPCL	2.5	3.0	3.5
18. 308 Wir.	180 gr. SPCL	1.7	2.2	2.7
19. 300 Wir. Mag.	180 gr. PSPCL	2.5	3.0	3.5
20. 35 Whelen OBS.	250 gr. PSP	2.5	3.0	3.5
21. 338 Wir. Mag.	250 gr. PSP	2.5	3.0	3.5
22. 416 Rem. Mag.	400 gr. PSP	2.5	3.0	3.5

- d. Rear Sight must be capable of adjustment for max. allowable windage and elevation.
- e. Rear sight elevating slide may be adjusted to any position between the second line from the rear to the

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- third line from the front of the ramp.
- f. The eye piece may be adjusted crosswise on the elevating piece to any position as long as there is full width of the screw retaining shoulder visible.

NOTE: It is not necessary to physically adjust the sight. As long as the sight is located as described in step 25, the measurement of the center of the groups using the line-o-sighter in step 25a determines adequacy of the sight to be adjusted to make P.O.A. coincide with P.O.I.

- 26. Remove line-o-sights. (If on accuracy device)
- 27. Unclamp and remove rifle from device. (If on accuracy device)
- 28. Inspect chamber and magazine for live ammunition.
 - a. Chamber must be empty.
 - b. Follower must be visible.
- 29. Pass all rifles that meet specifications for:
 - a. Visual
 - b. Functional
 - c. Accuracy, Point of impact to point of aim (If iron sights are present, Within limits of position)
 - d. Group size
- 30. Reject all rifles that do not meet specifications:
 - a. Enter all malfunctions into the computer and place ticket on rifle.
 - b. If a rifle fails to meet the target group size specifications, reject that rifle and target all remaining rifles on that side of the truck. If another rifle fails

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to meet group specifications, target the entire load.

31. Place rifle back on truck.

32. Repeat Test on next and succeeding rifles.

Note: If first truck of Pamac passed, follow next steps.

a. Randomly select 10 (Std. Rifles) and Target.

-If 10 rifles are on a truck, target 3

-If 21 rifles are on a truck, target 3

-If 20 rifles are on a truck, target 3

33. Place Shooters Test/Target ID Number (sticker) on rear of tag
(Acceptable Product Only)

a. Rejected rifles do not get ID stickers.

V. SAFETY AFTER TEST

A. Oper 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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1. Take first rifle from each side of truck, after test, and check for any possible damage to rifle from the test.

B. All rifles are moved to Ammunition Inspection Area.

Tool Number	Tooling Description
D-52367	Line-O-Sighter

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)

Std	CALIBER	USE CLOSE HARD PLUG
	7mm WBY. MAG.	C-48336-B
	7mm REM. MAG., 338 WIN. MAG.	C-46200-B OR D-46200-B
	300 WIN. MAG.	C-46200-A OR D-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 WIN., 6mm REM.	C-46195 OR D-48349-D
	22-250 REM.	C-46199 OR D-48349-E

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7mm EXP., .280 REM.		D-48349-G
7mm-308 REM., .308 WIN., .243 WIN.	C-46194	OR D-48349-H
25 WHELEN, 30.06 SPRG.	C-45930	OR D-48349-J
.270 WIN., 25.06 REM.	C-45930	OR D-48349-J
300 SAVAGE		D-48349-K
263 ROBERTS		D-48349-L
35 REM.		D-48349-M
204 RUGER		D-48349-CC

(Close Hard Plug Storage Cabinet is D-46302)

N/A Optical Bore-Sight Collimator Precision Aligner
Alley Supply Co.
Lafayette, Calif.

N/A Line-o-Sighter The Lyman Gun Sight Corp.
(Super Target spot) Middlefield Conn.

D-1-36871-C Fixture for line-o-sighter

PROCESS CONTROL INSPECTION RECORD			Revision Date:			12-Oct-05			Processed by:		
THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES											
Part No:		Part Name: Fin Assy 700 BDL		Centerfire Rifle				Date: 8/14/2006			
Operation No: 606		Operation: Test and Target						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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611 Test and Target

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

NOTE:

This procedure is a deviation from 100% targeting that is in effect on this date, in favor of 10% sample targeting specified in the process. From the beginning of each day a full load of each SKU that arrives for target must be targeted for group size. If all of the rifles on the load (at least 26) pass for group size then subsequent loads of the same SKU may be sample targeted, exactly as specified in the process record. If an initial SKU load does not pass then 100% target is required for the remainder of the day. Start over with 100% on all SKU's with each successive day.

- A. All rifles (100%) are to be tested after proof.
- B. 100% of Police rifles are to be targeted.
- C. 10% of std. models are to be targeted unless target rejects are found. If target rejects are found, 50 to 100% will be targeted. When calculating the initial 10% for std. models, always round up. (ie. for a 26 gun load, target 3)
- D. Record results of testing in computer as test and target operations are performed.

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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.

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 (10% std. & 100% Police).

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

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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 - (P) Prick punch mark must be present at bottom of Bolt Handle.
 - e. Visual Defects - Marring of wood or metal finishes.
 - f. Normal Sight Alignment-as described below:
 1. Front and Rear Sight ramps must be central on barrel and straight with line of sight.
 2. Must conform to barrel - good fit - no excessive opening at side or ends, also must be screwed tight to barrel.
 3. Rear Sight must be central on ramp not twisted, bent or deformed.
 4. Mark on rear sight to coincide with fourth mark from rear of the rear sight ramp.
 5. Rear Sight Eyepiece must be positioned central to rear sight.

If not within specifications for items a-f 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.

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- 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" position.
9. If safety stops in halfway 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 11-13 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 with iron sights, position

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line-o-sighter on sights and adjust device to point rifle on target paper. For first rifle of a new caliber without iron sights remove the bolt and look through bore to line up device with paper.

13. Remove line-o-sighter.

14. 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.	17 Rem.	25 gr. HPPL	3
2.	204 Ruger	32 gr. ACCUTIP V	5
3.	222 Rem.	50 gr. PSP	5
4.	22-250 Rem.	55 gr. HPPL	4
5.	223 Rem	55 gr. PSP	5
6.	6mm Rem.	80 gr. PSP	4
7.	243 Wir.	100 gr. PSPCL	4
8.	25.06 Rem.	120 gr. PSPCL	4
9.	257 Roberts	117 gr. SPCL	4
10.	270 WSM	130 gr. PSPCL	4
11.	300 WSM	180 gr. Power PT	3
12.	270 Wir.	150 gr. SPCL	4
13.	280 Rem.	150 gr. PSPCL	4
14.	7mm-08 Rem.	140 gr. PSP	4
15.	7mm Rem. Mag.	175 gr. PSPCL	3
16.	300 Savage	150 gr. PSPCL	4
17.	30.06 Sprg.	180 gr. SPCL-150 gr. PSPCL	4
18.	308 Wir.	180 gr. SPCL-150 gr. PSPCL	4
19.	300 Wir. Mag.	180 gr. PSPCL	3
20.	35 Whelen	250 gr. PSP	4
21.	338 Wir. Mag.	250 gr. PSP	3
22.	416 Rem. Mag.	400 gr. PSP	3

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15. Hold 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.

16. Open Bolt full stroke to rear position.

17. Close guard. (If on accuracy device)

18. 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.

19. Move safety to "F" or "OFF" position.

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20. 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.
21. For the 10% of standard rifles and 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.
22. 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.
23. 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 3 to 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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24. Open guard. (If on accuracy device)
25. For the Targeted rifles (10% std. & 100% Police) Place line-sighter onto sights (if sights are present) and check point of impact and group size.
- a. The average position of all shots fired in the group must be within the following specifications in relationship to the position of the crosshairs.

Elevation	Windage
2" High - 8" Low	9" Left - 9" Right

NOTE: Acceptance limits only apply when sights are positioned on the gun as described below.

Front sight must not be bent, twisted, tipped or deformed.

Rear Sight Ramp and Sight

-Ramp must be central in Barrel and straight with line of sight - level crosswise with Front Sight Ramp.

-Must conform to Barrel - good fit, no excessive opening at sides or ends, screwed tight to barrel.

-Rear Sight and Eyepiece must be level crosswise with line of sight as viewed from rear - Not tipped twisted or bent.

-Mark on elevating piece set to coincide with fourth mark from rear on rear sight ramp.

-Rear Sight Eyepiece good fit in dovetail of elevating slide - no excessive opening.

-Rear Sight Eyepiece positioned central crosswise with Windage Screw

- b. Use spotting scope, for rifles that do not have iron sights, to check group size.
- c. Maximum spread of the two extreme holes must be within group size specifications listed below.

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GROUP SIZE SPECIFICATIONS

M/700 ADL

	CALIBER	AMMUNITION TYPE	MAX. GROUP CENTER TO CENTER		
			3 SHOT	4 SHOT	5 SHOT
1.	17 Rem.	25 gr. HPPL	1.5	2.0	2.2
2.	222 Rem.	50 gr. PSP	1.5	2.0	2.2
3.	204 Ruger	32 gr. ACCUTIP V	1.5	2.0	2.2
4.	22-250 Rem.	55 gr. HPPL	1.5	2.0	2.2
5.	223 Rem.	55 gr. PSP	1.5	2.0	2.2
6.	6mm Rem.	80 gr. PSP	1.5	2.0	2.2
7.	243 Wir.	100 gr. PSPCL	1.5	2.0	2.2
8.	25.06 Rem.	120 gr. PSPCL	1.7	2.2	2.7
9.	257 Roberts	117 gr. SPCL	1.7	2.2	2.7
10.	270 Wir.	150 gr. SPCL	1.7	2.2	2.7
11.	280 Rem.	150 gr. PSPCL	1.7	2.2	2.7
12.	7mm-08 Rem.	140 gr. PSP	1.7	2.2	2.7
13.	270 WSM	130 gr. PSPCL	2.5	3.0	3.5
14.	300 WSM	180 gr. Power PT	2.5	3.0	3.5
15.	7mm Rem. Mag.	175 gr. PSPCL	2.5	3.0	3.5
16.	300 Savage	150 gr. PSPCL	1.7	2.2	2.7
17.	30.06 Sprg.	180 gr. SPCL	1.7	2.2	2.7
18.	308 Wir.	180 gr. SPCL	1.7	2.2	2.7
19.	300 Wir. Mag.	180 gr. PSPCL	2.5	3.0	3.5
20.	35 Whelen	250 gr. PSP	2.5	3.0	3.5
21.	338 Wir. Mag.	250 gr. PSP	2.5	3.0	3.5
22.	416 Rem. Mag.	400 gr. PSP	2.5	3.0	3.5

M/700 ADL YOUTH (20" BARREL)

CALIBER	AMMUNITION TYPE	MAX. GROUP CENTER TO CENTER		
		3 SHOT	4 SHOT	5 SHOT

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1. 243 Win 100 gr. PSP 1.7 2.2 2.7

- d. Sights must be capable of adjustment to 0"x 0".
- e. Rear sight elevating slide may be adjusted to any position between the second line from the rear to the third line from the front of the ramp.
- f. The eye piece may be adjusted crosswise on the elevating piece to any position as long as there is full width of the screw retaining shoulder visible.

NOTE: It is not necessary to physically adjust the sights. As long as sights are located as described in step 25, the measurement of the center of the groups using the line-o-sighter in step 25a determines adequacy of sights to be adjusted to make P.O.A. coincide with P.O.I.

- 26. Remove line-o-sights. (If on accuracy device)
- 27. Unclamp and remove rifle from device. (If on accuracy device)
- 28. Inspect chamber and magazine for live ammunition.
 - a. Chamber must be empty.
 - b. Follower must be visible.
- 29. Pass all rifles that meet specifications for:
 - a. Visual
 - b. Functional
 - c. Accuracy, Point of impact to point of aim (If iron sights are present, Within limits of position)
 - d. Group size

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30. Reject all rifles that do not meet specifications:

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

31. Place rifle back on truck.

32. Repeat Test on next and succeeding rifles.

- a. Randomly select 10* (Std. Rifles) and Target.
 - If 30 rifles are on a truck, target 3
 - If 21 rifles are on a truck, target 3
 - If 20 rifles are on a truck, target 2
- b. Target Police 100%

B. Test/Target Stickers-(Acceptable Product Only)

1. When all rifles have been tested / targeted
2. Place test sticker and target sticker on back of hang tag.
 - a. Rejected rifles do not get stickers.
3. Rifles that were tested for accuracy are to receive a total of two stickers on back of hang tag.

V. SAFETY AFTER TEST

A. Open Bolt

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

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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.

1. Take first rifle 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.

Tool Number	Tooling Description
D-52367	Line-O-Sighter

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

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B-51634-E Countersink Pilot - 7mm (all) / 280 Rem
B-51634-N Countersink Pilot - 264 Win / 6.5mm (all)
B-51634-L Countersink Pilot - 338 (all)

	CALIBER	USE CLOSE HARD PLUG
7MM REM MAG, 338 WIN MAG		C-46200-B
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 WIN., 6MM REM.		C-46195 OR D-48349-D
22-250 REM.		C-46199 OR D-48349-E
7MM EXP., .280 REM.		D-48349-G
7mm-08 REM., .308 WIN., .243 WIN.		C-46194 OR D-48349-H
35 WHELEN, 30-06 SPRG., .270 WIN., 25-06 REM.		C-45930 OR D-48349-J
300 SAVAGE		D-48349-K
257 ROBERTS		D-48349-L
204 RUGER		D-48349-CC

(Close Hard Plug Storage Cabinet is D-46201)

PROCESS CONTROL INSPECTION RECORD			Revision Date:			Processed by:		
THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES			12-Oct-05					
Part No:	Part Name:	Fin Assy 700 BDL				Centerfire Rifle	Date:	8/14/2006
Operation No: 611	Operation:	Test and Target					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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613 Attach scope rings, scope and bore sight

Step	Operation / Step Description
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	Attach the scope and rings to the receiver using the MAKITA cordless screwdriver in such a way that the eyepiece of the scope is as far towards the muzzle end of the gun as possible.
--	--

For rifles requiring bore sighting continue with the following instructions

*** NO LIVE AMMO IS TO BE USED FOR THIS PROCEEDURE***

With Jig E-49994 and optical collimator:

Place rifle firmly into the jig, allowing the butt of the stock to spring open the rear locator.

Assemble rifle scope to mounts already assembled to rifle. Fasten scope loosely at this time with top mount clamps.

Using the sighting grid in front of the jig as a guide, look through the scope and align the vertical reticle with the vertical line on the sighting grid.

Install the correct diameter bore locating pin on the optical collimator and position the collimator in the bore of the rifle.

Look through scope and align the scope reticle with the reticle in

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the collimator.

Replace dust caps on scope elevation and windage screws, make sure
all connections are tight and remove rifle from jig.

with Laser device

CAREFULLY insert laser into muzzle of the rifle-ensure proper pilot
is used

Place rifle into 100 yd custom shop range nest

Turn laser on

Locate laser on the paper using the scope to see down range

Use the scope elevation and windage adjustments to place the scope
cross hairs on the laser dot that is pojected on the target

Remove the gun from the nest and remove the laser from the muzzle

Use the top portion of the foam packing that the scope was received
in, to cover the scope as it sits on the gun.

place the the gun on the truck

Tool Number	Tooling Description
STD	MAKITA CORDLESS SCREWDRIVER
E-49994	Scope assembly and alignment jig.

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PROCESS CONTROL INSPECTION RECORD THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES				Revision Date: 12-Oct-05		Processed by:	
Part No:		Part Name: Fin Assy 700 BDL		Centerfire Rifle		Date: 8/14/2006	
Operation No: 613		Operation: Attach scope rings, scope and fore sight				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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620 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: 12-Oct-05			Processed by:
Part No:	Part Name: Fin Assy 700 BDL	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			
			REJECT			
			INSPECT			
			REJECT			
			INSPECT			
			REJECT			
			REJECT			

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640 Final Inspection

Step	Operation / Step Description
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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 of barrel
 2. Magnaflux - Triangle with Number - Center Right Side of Breech
 - A. Visible Above Stock

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- 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 Mars
 - 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. Mars
 - B. Finish
 - C. Proper Function
 - D. Trigger Guard Screws Tight
 - E. Assemble Correct Rear Swivel - If Specified on Gun Tag

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b. Stock Rejects only:

1. Place 3/4" Yellow Dot with Identification Stamp and Nonconformity Code, Close to Nonconformity on Stock Rejects

5A. 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, 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.

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- 6 METAL PARTS, FINISH
- a. Front Sight Head Not Jammed
 - b. Sights MUST Be Central
 - c. Sight 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 Hammer Handle
- 7 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

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- 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
- 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)

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.)

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STD Rem Oil
BTS-7300 Wood Dents & Scuff Template
A-43977 Trigger clearance shim tool (.030)
STD Dummy Cartridge Rounds of proper Caliber being built.
B-70697 Trigger Pull - Scale

PROCESS CONTROL INSPECTION RECORD			Revision Date			Processed by:	
THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES			12-Oct-05				
Part No:	Part Name: Fin Assy 700 BDL	Center fire Rifle	Date 8/14/2006				
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%	INSPECT REJECT	/	/		
Wood Dents & Scuff Template	BTS-7300	100%	INSPECT REJECT	/	/		
Trigger clearance shim tool (.030)	A-43977	100%	INSPECT REJECT	/	/		
Dummy Cartridge Rounds of proper Caliber being built.	STD	100%	INSPECT REJECT	/	/		
Trigger Pull - Scale	B-70697	100%	INSPECT REJECT	/	/		

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648

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

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.

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.

1. Clamp rifle in vise and remove takedown screws and stock assembly.
2. Locate adjusting screw (front edge, nearest to trigger) and break the
Duco Cement seal.
3. Rotate action in vise so top side is up.
4. With a small, flat-blade screw driver, adjust the trigger pull.
 - a. 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. Recheck 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:		18-May-05		Processed by:	
THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES									
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.		

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650 Inspect Heading and Sear Lift

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 b. If the Sear Binds or Drags, REJECT THE RIFLE - Mark Reject Reason on Reject Ticket

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- 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

Tool Number	Tooling Description
D-44581	Dial Gage Note: Use with 5/64 Balldriver Hex Tool Bondhus Cat. #10604, Series 106, or equivalent.
C-47741	Attribute Gage
C-41185-A	17 REM - MIN Heading Plug
C-41185-C	17 REM - IMAX Heading Plug

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C-41195-A	6MM REM - MIN Heading Plug
C-41195-C	6MM REM - IMAX Heading Plug
C-41521-A	22-256 REM - MIN Heading Plug
C-41521-C	22-256 REM - IMAX Heading Plug
C-53322-A	204 RUBER - MIN Heading Plug
C-53322-C	204 RUBER - IMAX Heading Plug
C-41154-A	222 REM - MIN Heading Plug
C-41154-C	222 REM - IMAX Heading Plug
C-41155-A	223 REM - MIN Heading Plug
C-41155-C	223 REM - IMAX Heading Plug
C-41556-A	243 WIN - MIN Heading Plug
C-41556-C	243 WIN - IMAX Heading Plug
C-41560-A	30-06 SPRG - MIN Heading Plug
C-41560-C	30-06 SPRG - IMAX Heading Plug
C-41560-A	270 WIN - MIN Heading Plug
C-41560-C	270 WIN - IMAX Heading Plug
C-52496-A	270 WSM - MIN Heading Plug
C-52496-C	270 WSM - IMAX Heading Plug
C-41544-A	280 REM - MIN Heading Plug
C-41544-C	280 REM - IMAX Heading Plug
C-70556-A	300 SAV - MIN Heading Plug
C-70556-C	300 SAV - IMAX Heading Plug
C-52496-A	300 WSM - MIN Heading Plug
C-52496-C	300 WSM - IMAX Heading Plug
C-41556-A	308 WIN - MIN Heading Plug
C-41556-C	308 WIN - IMAX Heading Plug
C-41356-A	35 WHELEN - MIN Heading Plug
C-41356-C	35 WHELEN - IMAX Heading Plug
C-41560-A	25-06 REM - MIN Heading Plug
C-41560-C	25-06 REM - IMAX Heading Plug
C-41543-A	257 ROBERTS - MIN Heading Plug
C-41543-C	257 ROBERTS - IMAX Heading Plug
C-41556-A	7MM-08 REM - MIN Heading Plug
C-41556-C	7MM-08 REM - IMAX Heading Plug
C-83853-A	300 Win BELT - MIN Heading Plug

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C-83853-C 300 Win BELT - IMAX Heading Plug
C-41546-A 300 Win - MIN Heading Plug
C-41546-C 300 Win - IMAX Heading Plug
C-83853-A 338 Win BELT - MIN Heading Plug
C-83853-C 338 Win BELT - IMAX Heading Plug
C-41561-A 338 Win - MIN Heading Plug
C-41561-C 338 Win - IMAX Heading Plug
C-43099-A 416 REM BELT - MIN Heading Plug
C-43099-C 416 REM BELT - IMAX Heading Plug
C-41233-A 416 REM - MIN Heading Plug
C-41233-C 416 REM - IMAX Heading Plug
C-83853-A 7MM Mag BELT - MIN Heading Plug
C-83853-C 7MM Mag BELT - IMAX Heading Plug
C-41561-A 7MM Mag - MIN Heading Plug
C-41561-C 7MM Mag - IMAX Heading Plug

PROCESS CONTROL INSPECTION RECORD THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES				Revision Date: 12-Oct-05		Processed by:	
Part No:		Part Name: Fin Assy 700 BDL		Centerfire Rifle		Date: 8/14/2005	
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			
Dial Gage		D-44581	100%	INSPECT REJECT			

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Attribute Gage	C-43741	100%	INSPECT			
17 REM - MIN Heading Plug	C-41185-A	100%	REJECT INSPECT			
17 REM - IMAX Heading Plug	C-41185-C	100%	REJECT INSPECT			
6MM REM - MIN Heading Plug	C-41195-A	100%	REJECT INSPECT			
6MM REM - IMAX Heading Plug	C-41195-C	100%	REJECT INSPECT			
22-250 REM - MIN Heading Plug	C-41521-A	100%	REJECT INSPECT			
22-250 REM - IMAX Heading Plug	C-41521-C	100%	REJECT INSPECT			
22-250 REM - MIN Heading Plug	C-41521-A	100%	REJECT INSPECT			
22-250 REM - IMAX Heading Plug	C-41521-C	100%	REJECT INSPECT			
222 REM - MIN Heading Plug	C-41154-A	100%	REJECT INSPECT			
222 REM - IMAX Heading Plug	C-41154-C	100%	REJECT INSPECT			
223 REM - MIN Heading Plug	C-41155-A	100%	REJECT			

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223 REM - IMAX Heading Plug	C-41556-C	100%	INSPECT			
243 WIN - MIN Heading Plug	C-41556-A	100%	REJECT INSPECT			
243 WIN - IMAX Heading Plug	C-41556-C	100%	REJECT INSPECT			
243 WIN - MIN Heading Plug	C-41556-A	100%	REJECT INSPECT			
243 WIN - IMAX Heading Plug	C-41556-C	100%	REJECT INSPECT			
30-06 SPRG - MIN Heading Plug	C-41560-A	100%	REJECT INSPECT			
30-06 SPRG - IMAX Heading Plug	C-41560-C	100%	REJECT INSPECT			
30-06 SPRG - MIN Heading Plug	C-41560-A	100%	REJECT INSPECT			
30-06 SPRG - IMAX Heading Plug	C-41560-C	100%	REJECT INSPECT			
30-06 SPRG - MIN Heading Plug	C-41560-A	100%	REJECT INSPECT			
30-06 SPRG - IMAX Heading Plug	C-41560-C	100%	REJECT INSPECT			
270 WIN - MIN Heading Plug	C-41560-A	100%	REJECT			

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270 W/IN - IMAX Heading Plug	C-41560-C	100%	INSPECT			
270 W/IN - MIN Heading Plug	C-41544-A	100%	REJECT INSPECT			
270 W/IN - IMAX Heading Plug	C-41560-C	100%	REJECT INSPECT			
280 REM - MIN Heading Plug	C-41544-A	100%	REJECT INSPECT			
280 REM - IMAX Heading Plug	C-41544-C	100%	REJECT INSPECT			
300 SAV - MIN Heading Plug	C-70556-A	100%	REJECT INSPECT			
300 SAV - IMAX Heading Plug	C-70556-C	100%	REJECT INSPECT			
308 W/IN - MIN Heading Plug	C-41556-A	100%	REJECT INSPECT			
308 W/IN - IMAX Heading Plug	C-41556-C	100%	REJECT INSPECT			
308 W/IN - MIN Heading Plug	C-41556-A	100%	REJECT INSPECT			
308 W/IN - IMAX Heading Plug	C-41556-C	100%	REJECT INSPECT			
35 WHELEN - MIN Heading Plug	C-41356-A	100%	REJECT			

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35 VVHELEN - IMAX Heading Plug	C-41356-C	100%	INSPECT			
25-06 REM - MIN Heading Plug	C-41560-A	100%	REJECT INSPECT			
25-06 REM - IMAX Heading Plug	C-41560-C	100%	REJECT INSPECT			
257 ROBERTS - MIN Heading Plug	C-41543-A	100%	REJECT INSPECT			
257 ROBERTS - IMAX Heading Plug	C-41543-C	100%	REJECT INSPECT			
7MM-08 REM - MIN Heading Plug	C-41556-A	100%	REJECT INSPECT			
7MM-08 REM - 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			
338 Win BELT - MIN Heading Plug	C-83853-A	100%	REJECT			

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338 Win BELT - IMAX Heading Plug	C-83853-C	100%	INSPECT			
			REJECT INSPECT			
338 Win - MIN Heading Plug	C-41561-A	100%	REJECT INSPECT			
338 Win - IMAX Heading Plug	C-41561-C	100%	REJECT INSPECT			
338 Win BELT - MIN Heading Plug	C-83853-A	100%	REJECT INSPECT			
338 Win BELT - IMAX Heading Plug	C-83853-C	100%	REJECT INSPECT			
338 Win - MIN Heading Plug	C-41561-A	100%	REJECT INSPECT			
338 Win - IMAX Heading Plug	C-41561-C	100%	REJECT INSPECT			
416 REM BELT - MIN Heading Plug	C-43099-A	100%	REJECT INSPECT			
416 REM BELT - IMAX Heading Plug	C-43099-C	100%	REJECT INSPECT			
416 REM - MIN Heading Plug	C-41233-A	100%	REJECT INSPECT			
416 REM - IMAX Heading Plug	C-41233-C	100%	REJECT INSPECT			
7MM Mag BELT - MIN Heading Plug	C-83853-A	100%	REJECT			

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7MM Mag BELT - IMAX Heading Plug	C-83853-C	100%	INSPECT			
7MM Mag - MIN Heading Plug	C-41561-A	100%	REJECT INSPECT			
7MM Mag - IMAX Heading Plug	C-41561-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			
			REJECT INSPECT			
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655 Mark Bolt to Match Receiver Serial
Number Using Dot Peen Marking Machine

Step	Operation / Step Description
------	------------------------------

- | | | |
|---|---|------------|
| | Mark Bolt to Match Receiver Serial Number Using
Dot Peen Marking Machine - (last four numbers) | ECN#301028 |
| 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 | |

Tool Number	Tooling Description
40789	Dot Peen Marker
E-TS-7583	Holding Fixture

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A-51082

Replacement Stylus

PROCESS CONTROL INSPECTION RECORD THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES				Revision Date: 12-Oct-05		Processed by:
Part No:	Part Name:	Centerfire Rifle			Date:	8/14/2006
Operation No: 655	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			
			REJECT INSPECT			
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			REJECT INSPECT			

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660 Assemble Hood to Front Sight Ramp

Step Operation / Step Description

Assemble Front Sight Cover to Front Sight (Ramp)

Insert Front Sight Cover into slots in Front Sight Ramp. Press until seated in Detents. Pointed ends forward.

Tool Number
MILBAR 47R
Bench

Tooling Description
Pliers for external retaining rings

PROCESS CONTROL INSPECTION RECORD THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES			Revision Date: 12-Oct-05			Processed by:	
Part No:	Part Name: Fin Assy 700 BDL	Centerfire Rifle			Date: 8/14/2006		
Operation No: 660	Operation: Assemble Hood to Front Sight Ramp					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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675 Oil, Assemble Packing Material, Print Box End
Label and Pack Gun, Label and Tape Box

To Warehouse

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 Bolt assy. from rifle, verify last 4 digits of serial # that is marked on bolt assy., and pack bolt assy.
9. Pack Rifle into Box.
Note: Pack Scope, base, and rings for 700 ADL's with scope also; If scope comes to pack with foam cover over mounted scope, pack the gun with the cover still on the scope.
10. Place Owners Manual in box over Scope
11. Seal Box using reinforced packing tape.
12. Place Box onto conveyor to travel to the warehouse.

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
D-51267	Pallet

PROCESS CONTROL INSPECTION RECORD THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES		Revision Date: 12-Oct-05	Processed by:
Part No:	Part Name: Fin Assy 700 BDL	Centerfire Rifle	Date: 8/14/2006

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Operation No: 675	Operation: Oil, Assemble Packing Material, Print Box End Label and Pack Gun, Label and Tape Box			Work Center:
Prod. Qty:	Prod. Order #	Setup Inspected by & Date:		
Gage Description and Characteristic	Gage Number	Gage Frequency	Operator	
			1st Shift	2nd Shift
			REJECT	REJECT
			REJECT	REJECT
VISUAL		100%		
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676 Print Box End Label & Pack Rifle

To Warehouse

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

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
D-51267	Pallet

PROCESS CONTROL INSPECTION RECORD THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES			Revision Date: 12-Oct-05		Processed by:	
Part No:	Part Name: Fin Assy 700 BDL	Centerfire Rifle		Date: 8/14/2006		
Operation No: 676	Operation: Print Box End Label & Pack Rifle			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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Repair Max Headers

Step

Operation / Step	Description
1	Initial Setup
2	System Configuration
3	Data Collection
4	Analysis and Reporting
5	Final Review

Repair Max. headers

1. Fit and head new Bolt.
2. Assemble Extractor and Ejector to Bolt.
3. Return to final assembler whose stamp appears on the back side of hang tag.
 - a. Insert Firing Pin.
 - b. Check protrusion.
 - c. Check function of Extractor & Ejector by using appropriate number of dummies.
4. Send to proof and test.

PROCESS CONTROL INSPECTION RECORD THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES				Revision Date: 12-Oct-05			Processed by:		
Part No:		Part Name: Fin Assy 700 BDL		Centerfire Rifle			Date: 3/14/2006		
Operation No: 700R		Operation: Repair Max Headers						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 REFLECT	/	/			

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Dept	Oper	Operation Description	Part Numbers
9132		Issue from Crib	25801 25781 25798
			25783 25787 25785
			25753 25789 25791
			25797 25799 25803
			25793 25795 29665
			25755 25749 25819
			25811 25815 25818
			25813 25751 25807
			25805 26063 27545
			27546 27547 26448
			27331 26444 26446
			27507 27007 27015
			27011 27017 27047
			27049 27009 27019
			27013 27301 27101
			27103 27105 27107
			27109 27349 27351
			27353 27355 27357
			27359 27475 27477
			27361 27363 27479
			27481 27333 27385
			27387 27021 27299
			27375 27377 27379
			27023 27027 27029
8761	395	INSPECT COMPONENTS BEFORE HEADING	25801 25781 25798
			25783 25787 25785
			25753 25789 25791
			25797 25799 25803
			25793 25795 29665
			25755 25749 25819
			25811 25815 25818
			25813 25751 25807
			25805 26063 27545
			27546 27547 26448
			27331 26444 26446
			27507 27007 27015
			27011 27017 27047
			27049 27009 27019
			27013 27301 27101
			27103 27105 27107

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Dept	Oper	Operation Description	Part Numbers
			27109 27349 27351
			27353 27355 27357
			27359 27475 27477
			27361 27363 27479
			27481 27333 27385
			27387 27021 27299
			27375 27377 27379
			27023 27027 27029
8761	400	Fit and Head Bolt Assembly to Barrel Assembly (SHOULDER SINGLE PASS)	25753 25789 25791
			25797 25799 25755
			25795 25793 26063
			25811 25818 25813
			27545 27546 26448
			27331 26444 26446
			27507 27007 27015
			27011 27017 27009
			27019 27013 27301
			27103 27105 27107
			27357 27359 27477
			27361 27363 27479
			27481 27333 27299
			27375 27377 27379
			27023 27027 27029
8761	405	Fit and Head Bolt Assembly to Barrel Assembly (SHOULDER SINGLE PASS: Smaller than .25 caliber)	25801 25781 25798
			25783 25787 25785
			25749 25819 27101
			27349 27351 27353
			27355 27475 27021
8761	415	Fit and Head Bolt Assembly to Barrel Assy and Chamber to Length (BELTED - MAGNUMS)	29665 25815 25751
			25803 25807 25805
			27547 27047 27049
			27109 27385 27387
8761	420	Ream Chamber to Deburr (BELTED - MAGNUMS)	29665 25815 25751
			25803 25807 25805
			27547 27047 27049
			27109 27385 27387
8761	425	Make Chamber Cast (Not Done on 100% of Product)	25801 25781 25798
			25783 25787 25785
			25753 25789 25791
			25797 25799 25803
			25793 25795 29665

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Dept	Oper	Operation Description	Part Numbers
			25755 25749 25819
			25811 25815 25818
			25813 25751 25807
			25805 26063 27545
			27546 27547 26448
			27331 26444 26446
			27507 27007 27015
			27011 27017 27047
			27049 27009 27019
			27013 27301 27101
			27103 27105 27107
			27109 27349 27351
			27353 27355 27357
			27359 27475 27477
			27361 27363 27479
			27481 27333 27385
			27387 27021 27299
			27375 27377 27379
			27023 27027 27029
8761	427	Assemble Rear Sight Assembly and Front Sight to Barrel Assembly	25801 25781 25798
			25783 25787 25785
			25753 25789 25791
			25797 25799 25803
			25793 25795 29665
			25755 25749 25819
			25811 25815 25818
			25813 25751 25807
			25805 26063 26444
			26446 27023
8761	428	Assemble Front & Rear Scope Bases to Barrel Assembly Complete	26444 26446 27375
			27377 27379 27027
			27029
8761	430	Ream Ejector Hole	25801 25781 25798
			25783 25787 25785
			25753 25789 25791
			25797 25799 25803
			25793 25795 29665
			25755 25749 25819
			25811 25815 25818
			25813 25751 25807
			25805 26063 27545
			27546 27547 26448
			27331 26444 26446

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Dept	Oper	Operation Description	Part Numbers
			27007 27007 27015
			27011 27017 27047
			27049 27009 27019
			27013 27301 27101
			27103 27105 27107
			27109 27349 27351
			27353 27355 27357
			27359 27475 27477
			27361 27363 27479
			27481 27333 27385
			27387 27021 27299
			27375 27377 27379
			27023 27027 27029
8761	431	Form Radius on Edge of Firing Pin Hole	25753 25789 25801
			27009 27299
8761	432	Assemble Riveted Extractor to Bolt - (MAGNUMS)	25751 25803 25807
			25815 29665 27547
			27331 27047 27049
			27301 27109 27333
			27385 27387 27379
8761	435	Assemble Rivetless Extractor to Bolt	25801 25781 25798
			25783 25787 25785
			25753 25789 25791
			25797 25799 25805
			25793 25795 26063
			25755 25749 25819
			25811 25818 25813
			27545 27546 26448
			26444 26446 27507
			27007 27015 27011
			27017 27009 27019
			27013 27101 27103
			27105 27107 27349
			27351 27353 27355
			27357 27359 27475
			27477 27361 27363
			27479 27481 27021
			27299 27375 27377
			27023 27027 27029
8761	440	Assemble Ejector to Ejector Spring and then Assemble to Bolt with Ejector Cross Pin.	25801 25781 25798
			25783 25787 25785
			25753 25789 25791

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Dept	Oper	Operation Description	Part Numbers
25	12		25797 25799 25803
25	13		25793 25795 29665
25	14		25755 25749 25819
25	15		25811 25815 25818
25	16		25813 25751 25807
25	17		25805 26063 27545
25	18		27546 27547 26448
25	19		27331 26444 26446
25	20		27507 27007 27015
25	21		27011 27017 27047
25	22		27049 27009 27019
25	23		27013 27301 27101
25	24		27103 27105 27107
25	25		27109 27349 27351
25	26		27353 27355 27357
25	27		27359 27475 27477
25	28		27361 27363 27479
25	29		27481 27333 27385
25	30		27387 27021 27299
25	31		27375 27377 27379
25	32		27023 27027 27029
8761	460R	Strip Defective Barrel Assembly Complete	25801 25781 25798
			25783 25787 25785
			25753 25789 25791
			25797 25799 25803
			25793 25795 29665
			25755 25749 25819
			25811 25815 25818
			25813 25751 25807
			25805 26063 27545
			27546 27547 26448
			27331 26444 26446
			27507 27007 27015
			27011 27017 27047
			27049 27009 27019
			27013 27301 27101
			27103 27105 27107
			27109 27349 27351
			27353 27355 27357
			27359 27475 27477
			27361 27363 27479
			27481 27333 27385
			27387 27021 27299
			27375 27377 27379
			27023 27027 27029

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Dept	Oper	Operation Description	Part Numbers
8761	465R	Strip Defective Bolt	25801 25781 25798 25783 25787 25785 25753 25789 25791 25797 25799 25803 25793 25795 29665 25755 25749 25819 25811 25815 25818 25813 25751 25807 25805 26063 27545 27546 27547 26448 27331 26444 26446 27507 27007 27015 27011 27017 27047 27049 27009 27019 27013 27301 27101 27103 27105 27107 27109 27349 27351 27353 27355 27357 27359 27475 27477 27361 27363 27479 27481 27333 27385 27387 27021 27299 27375 27377 27379 27023 27027 27029
8761	575	Wire brush and dry barrel.	27331 27301 27333 27379
8761	580	Assemble Action	25801 25781 25798 25783 25787 25785 25753 25789 25791 25797 25799 25803 25793 25795 29665 25755 25749 25819 25811 25815 25818 25813 25751 25807 25805 26063 27545 27546 27547 26448 27331 26444 26446 27507 27007 27015 27011 27017 27047 27049 27009 27019 27013 27301 27101 27103 27105 27107 27109 27349 27351

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Dept	Oper	Operation Description	Part Numbers
			27353 27355 27357
			27359 27475 27477
			27361 27363 27479
			27481 27333 27385
			27387 27021 27299
			27375 27377 27379
			27023 27027 27029
8761	585	Assemble Stock to Action & Attach Hang Tag to Trigger Guard	25801 25781 25798
			25783 25787 25785
			25753 25789 25791
			25797 25799 25803
			25793 25795 29665
			25755 25749 25819
			25811 25815 25818
			25813 25751 25807
			25805 26063 27545
			27546 27547 26448
			27331 26444 26446
			27507 27007 27015
			27011 27017 27047
			27049 27009 27019
			27013 27301 27101
			27103 27105 27107
			27109 27349 27351
			27353 27355 27357
			27359 27475 27477
			27361 27363 27479
			27481 27333 27385
			27387 27021 27299
			27375 27377 27379
			27023 27027 27029
8761	593	Assemble Front Swivel Screw and Swivel Screw Spacer to Stock	25801 25781 25798
			25783 25787 25785
			25753 25789 25791
			25797 25799 25803
			25793 25795 29665
			25755 25749 25819
			25811 25815 25818
			25813 25751 25807
			25805 26063 27545
			27546 27547 26448
			27331 26444 26446
			27507 27007 27015
			27011 27017 27047

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Dept	Oper	Operation Description	Part Numbers
			27009 27009 27019
			27013 27101
			27103 27105 27107
			27109 27349 27351
			27353 27355 27357
			27359 27475 27477
			27479
			27481 27385
			27387 27021
			27023 27027 27029
8785	600	Proof Test	25801 25781 25798
			25783 25787 25785
			25753 25789 25791
			25797 25799 25803
			25793 25795 29665
			25755 25749 25819
			25811 25815 25818
			25813 25751 25807
			25805 26063 27545
			27546 27547 26448
			27331 26444 26446
			27507 27007 27015
			27011 27017 27047
			27049 27009 27019
			27013 27301 27101
			27103 27105 27107
			27109 27349 27351
			27353 27355 27357
			27359 27475 27477
			27361 27363 27479
			27481 27333 27385
			27387 27021 27299
			27375 27377 27379
			27023 27027 27029
8785	600R	Proof Test with slave bolt	25801 25781 25798
			25783 25787 25785
			25753 25789 25791
			25797 25799 25803
			25793 25795 29665
			25755 25749 25819
			25811 25815 25818
			25813 25751 25807
			25805 26063 27545
			27546 27547 26448

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Dept	Oper	Operation Description	Part Numbers
8785	604	Hand Chamfer Muzzle with a Live Pilot Tool	27331 26444 26446
			27507 27007 27015
			27011 27017 27047
			27049 27009 27019
			27013 27301 27101
			27103 27105 27107
			27109 27349 27351
			27353 27355 27357
			27359 27475 27477
			27361 27363 27479
			27481 27333 27385
			27387 27021 27299
			27375 27377 27379
			27023 27027 27029
8785	606	Test and Target	25801 25781 25798
			25783 25787 25785
			25753 25789 25791
			25797 25799 25803
			25793 25795 29665
			25755 25749 25819
			25811 25815 25818
			25813 25751 25807
			25805 26063 27545
			27546 27547 26448
			27331 26444 26446
			27507 27007 27015
			27011 27017 27047
			27049 27009 27019
			27013 27301 27101
			27103 27105 27107
			27109 27349 27351
			27353 27355 27357
			27359 27475 27477
			27361 27363 27479
			27481 27333 27385
			27387 27021 27299
			27375 27377 27379
			27023 27027 27029
8785	606	Test and Target	25801 25781 25798
			25783 25787 25785
			25753 25789 25791
			25797 25799 25803
			25793 25795 29665
			25755 25749 25819

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Dept	Oper	Operation Description	Part Numbers
			25811 25815 25818
			25813 25751 25807
			25805 26063 27545
			27546 27547 26448
			27331 27507 27007
			27015 27011 27017
			27047 27049 27009
			27019 27013 27301
			27101 27103 27105
			27107 27109 27349
			27351 27353 27355
			27357 27359 27475
			27477 27361 27363
			27479 27481 27333
			27385 27387 27021
			27299 27023
8785	611	Test and Target	26444 26446 27375
			27377 27379 27027
			27029
8785	613	Attach scope rings, scope and bore sight	26444 26446 27375
			27377 27379 27027
			27029
8785	620	Inspect For Live Ammunition	25801 25781 25798
			25783 25787 25785
			25753 25789 25791
			25797 25799 25803
			25793 25795 29665
			25755 25749 25819
			25811 25815 25818
			25813 25751 25807
			25805 26063 27545
			27546 27547 26448
			27331 26444 26446
			27507 27007 27015
			27011 27017 27047
			27049 27009 27019
			27013 27301 27101
			27103 27105 27107
			27109 27349 27351
			27353 27355 27357
			27359 27475 27477
			27361 27363 27479
			27481 27333 27385

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Dept	Oper	Operation Description	Part Numbers
			27387 27021 27299
			27375 27377 27379
			27023 27027 27029
8786	640	Final Inspection	25801 25781 25798
			25783 25787 25785
			25753 25789 25791
			25797 25799 25803
			25793 25795 29665
			25755 25749 25819
			25811 25815 25818
			25813 25751 25807
			25805 26063 27545
			27546 27547 26448
			27331 26444 26446
			27507 27007 27015
			27011 27017 27047
			27049 27009 27019
			27013 27301 27101
			27103 27105 27107
			27109 27349 27351
			27353 27355 27357
			27359 27475 27477
			27361 27363 27479
			27481 27333 27385
			27387 27021 27299
			27375 27377 27379
			27023 27027 27029
8761	648	Reset trigger pull within specs as needed.	25801 25781 25798
			25783 25787 25785
			25753 25789 25791
			25797 25799 25803
			25793 25795 29665
			25755 25749 25819
			25811 25815 25818
			25813 25751 25807
			25805 26063 27545
			27546 27547 26448
			27331 26444 26446
			27507 27007 27015
			27011 27017 27047
			27049 27009 27019
			27013 27301 27101
			27103 27105 27107
			27109 27349 27351

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Dept	Oper	Operation Description	Part Numbers
			27353 27355 27357
			27359 27475 27477
			27361 27363 27479
			27481 27333 27385
			27387 27021 27299
			27375 27377 27379
			27023 27027 27029
8786	650	Inspect Heading and Sear Lift	25801 25781 25798
			25783 25787 25785
			25753 25789 25791
			25797 25799 25803
			25793 25795 29665
			25755 25749 25819
			25811 25815 25818
			25813 25751 25807
			25805 26063 27545
			27546 27547 26448
			27331 26444 26446
			27507 27007 27015
			27011 27017 27047
			27049 27009 27019
			27013 27301 27101
			27103 27105 27107
			27109 27349 27351
			27353 27355 27357
			27359 27475 27477
			27361 27363 27479
			27481 27333 27385
			27387 27021 27299
			27375 27377 27379
			27023 27027 27029
8786	655	Mark Bolt to Match Receiver Serial Number Using Dot Peen Marking Machine	25801 25781 25798
			25783 25787 25785
			25753 25789 25791
			25797 25799 25803
			25793 25795 29665
			25755 25749 25819
			25811 25815 25818
			25813 25751 25807
			25805 26063 27545
			27546 27547 26448
			27331 26444 26446
			27507 27007 27015
			27011 27017 27047

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Dept	Oper	Operation Description	Part Numbers
			27049 27009 27019
			27013 27301 27101
			27103 27105 27107
			27109 27349 27351
			27353 27355 27357
			27359 27475 27477
			27361 27363 27479
			27481 27333 27385
			27387 27021 27299
			27375 27377 27379
			27023 27027 27029
8786	660	Assemble Hood to Front Sight Ramp	25801 25781 25798
			25783 25787 25785
			25753 25789 25791
			25797 25799 25803
			25793 25795 29665
			25755 25749 25819
			25811 25815 25818
			25813 25751 25807
			25805 26063 26444
			26446
8786	675	Oil, Assemble Packing Material, Print Box End Label and Pack Gun, Label and Tape Box To Warehouse	26444 26446 27375
			27377 27379 27027
			27029
8786	676	Print Box End Label & Pack Rifle To Warehouse	25801 25781 25798
			25783 25787 25785
			25753 25789 25791
			25797 25799 25803
			25793 25795 29665
			25755 25749 25819
			25811 25815 25818
			25813 25751 25807
			25805 26063 27545
			27546 27547 26448
			27331 27507 27007
			27015 27011 27017
			27047 27049 27009
			27019 27013 27301
			27101 27103 27105
			27107 27109 27349
			27351 27353 27355
			27357 27359 27475

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Dept	Oper	Operation Description	Part Numbers
			27477 27361 27363
			27479 27481 27333
			27385 27387 27021
			27299 27023
8761	700R	Repair Max Headers	25801 25781 25798
			25783 25787 25785
			25753 25789 25791
			25797 25799 25803
			25793 25795 29665
			25755 25749 25819
			25811 25815 25818
			25813 25751 25807
			25805 26063 27545
			27546 27547 26448
			27331 26444 26446
			27507 27007 27015
			27011 27017 27047
			27049 27009 27019
			27013 27301 27101
			27103 27105 27107
			27109 27349 27351
			27353 27355 27357
			27359 27475 27477
			27361 27363 27479
			27481 27333 27385
			27387 27021 27299
			27375 27377 27379
			27023

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Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
							RAMAC DESCRIPTION
							25891 700 BDL - 17 REM
							25781 700 BDL - 222 REM
							25798 700 BDL - 223 REM
							25783 700 BDL - 22-250 REM
							25787 700 BDL - 243 WIN
							25785 700 BDL - 6MM REM
							25793 700 BDL - 257 ROBERTS
							25789 700 BDL - 25-06 REM
							25791 700 BDL - 270 WIN
							25797 700 BDL - 280 REM
							25799 700 BDL - 7MM-08 REM
							25803 700 BDL - 7MM REM MAG
							25799 700 BDL - 300 SAVAGE
							25795 700 BDL - 308 WIN
							25793 700 BDL - 30-06 SPRG
							26063 700 BDL - 30-06 SPRG
							25807 700 BDL - 300 WIN MAG
							25805 700 BDL - 338 WIN MAG
							25796 700 BDL - 35 WHELEN - OBSOLETE
							29665 700 BDL - 416 REM MAG
							=====
							25749 700 BDL LH - 22-250 REM
							25819 700 BDL LH - 243 WIN
							25811 700 BDL LH - 270 WIN
							25815 700 BDL LH - 7MM REM MAG
							25818 700 BDL LH - 308 WIN
							25813 700 BDL LH - 30-06 SPRG
							25751 700 BDL LH - 338 WIN MAG
							=====
							27545 700 BDL - 270 Win w/o Sights
							27546 700 BDL - 30-06 w/o Sights
							27507 700 BDL - 30-06 w/o Sights DEJ#8
							27547 700 BDL - 7mm Rem Mag w/o Sights
							26444 700 BDL - 270 WIN W/SCOPE
							27301 700 BDL - 270 WSM W/SCOPE
							26446 700 BDL - 30-06 SPRG W/SCOPE
							26448 700 BDL - 30-06 SPRG W/SCOPE
							- NO SIGHT HOLE
							=====
							27021 700 CDL - 204 RUGER F OF NRA
							27007 700 CDL - 243 WIN

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Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
							27009 700 CDL - 25-06 REM
							27015 700 CDL - 7MM-08 REM
							27011 700 CDL - 270 WIN
							27027 700 CDL - 270 WIN W/SCOPE
							27013 700 CDL - 280 REM
							27017 700 CDL - 30-06 SPRG
							27023 700 CDL - 30-06 SPRG W/SIGHTS
							27029 700 CDL - 30-06 SPRG W/SCOPE
							27013 700 CDL - 35 WHELEN
							27047 700 CDL - 7MM REM MAG
							27049 700 CDL - 300 WIN MAG
							27101 700 CDL - 223 REM - LH
							27103 700 CDL - 243 WIN - LH
							27105 700 CDL - 270 WIN - LH
							27107 700 CDL - 30-06 SPRG - LH
							27109 700 CDL - 7MM REM MAG - LH
							=====
							27349 700 SPS S/A - 204 RUGER
							27351 700 SPS S/A - 223 REM
							27353 700 SPS S/A - 22-250 REM
							27355 700 SPS S/A - 243 WIN
							27357 700 SPS S/A - 7MM-08 REM
							27359 700 SPS S/A - 308 WIN
							=====
							27475 700 SPS S/A YTH - 243 WIN
							27477 700 SPS S/A YTH - 308 WIN
							=====
							27299 700 SPS L/A - 25-06 REM
							27361 700 SPS L/A - 270 WIN
							27363 700 SPS L/A - 30-06 SPRG
							=====
							27479 700 SPS L/A YTH - 270 WIN
							27481 700 SPS L/A YTH - 30-06 SPRG
							=====
							27331 700 SPS S/A MAG - 270 WSM
							27333 700 SPS S/A MAG - 300 WSM
							=====
							27385 700 SPS L/A MAG - 7MM REM MAG
							27387 700 SPS L/A MAG - 300 WIN MAG
							=====
							27375 700 SPS L/A - 270 WIN W/SCOPE
							27377 700 SPS L/A - 30-06 SPRG W/SCOPE
							27379 700 SPS S/A MAG - 300 WSM W/SCOPE
26448							700 BDL - 30-06 SPRG W/SCOPE - NO ST HOLE
		301049	502	676	1.000		Cable Lock

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Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
		246850	47	400	1.000		Barrel Assembly without sights
		28712	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	330	676	1.000		Box & Envelope Label
		1651	10	676	1.000		Carton Assembly
		3509	20	676	1.000		Instruction Book
		17017	410	440	1.000		Ejector
		94555	420	440	1.000		Ejector Pin
		17019	430	440	1.000		Ejector Spring
		93712	400	432	1.000		Extractor
		305630	160	580	1.000		Firing Pin Assy
		104129	290	585	1.000		Front Guard Screw
		16430	100	580	1.000		Magazine
		92218	230	585	1.000		Magazine Follower
		15677	90	585	1.000		Magazine Spring
		21717	340	600	1.000		PROOF ROUND
		104126	300	585	1.000		Rear Guard Screw
		17034	140	580	4.000		Receiver Plug Screw
		24476	180	580	1.000		Sear Pin
		201894	455	676	1.000		Scope - Bushnell 3X-9X 40mm
		200291	457	676	1.000		Scope Base w/screws & allen wrench
		200292	458	676	1.000		Scope Rings w/screws & allen wrench
		93617L	280	585	1.000		Stock Assembly
		15358	50	593	2.000		Swivel Screw
		94241	240	593	2.000		Swivel Screw Spacer
		27826	505	606	2.000		TEST ROUND 30-06 SPRG 150 gr.PSPCL
		21407	360	606	3.500		TARGET ROUND 30-06 SPRG 180 gr.SPCL
		26345	190	580	1.000		Trigger Assembly
		26371	210	585	1.000		Trigger Guard Assy
27547							700 BDL - 7mm Rem Mag w/o Sights
		301049	502	676	1.000		Cable Lock
		245304	67	415	1.000		Barrel Assembly
		98871	57	415	1.000		Bolt Assembly
		17013	130	580	1.000		Bolt Stop
		24475	170	580	1.000		Bolt Stop Pin
		15224	40	580	1.000		Bolt Stop Spring
		993002	330	676	1.000		Box & Envelope Label
		1444	10	676	1.000		Carton - RF-CF
		3509	20	676	1.000		Instruction Book
		17017	410	440	1.000		Ejector
		94555	420	440	1.000		Ejector Pin
		17019	430	440	1.000		Ejector Spring
		97322	400	432	1.000		Extractor

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Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
		27341	440	432	1.000		Extractor Rivet
		305636	160	580	1.000		Firing Pin Assy
		104129	290	585	1.000		Front Guard Screw
		16430	100	580	1.000		Magazine
		90952	230	585	1.000		Magazine Follower
		15677	90	585	1.000		Magazine Spring
		21736	340	600	1.150		PROOF ROUND
		104126	300	585	1.000		Rear Guard Screw
		17034	140	580	4.000		Receiver Plug Screw
		24476	180	580	1.000		Sear Pin
		106171	280	585	1.000		Stock Assembly
		97812	60	593	2.000		Swivel Screw
		27814	505	606	2.000		TEST ROUND 7MM REM MAG 175 gr.PSPCL
		27814	360	606	3.500		TARGET ROUND 7MM REM MAG 175 gr.PSPCL
		26345	190	580	1.000		Trigger Assembly
		94089	210	585	1.000		Trigger Guard Assy
27546							700 BDL - 30-06 w/o Sights
		301049	502	676	1.000		Cable Lock
		244903	47	400	1.000		Barrel Assembly
		98080	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	330	676	1.000		Box & Envelope Label
		1444	10	676	1.000		Carton - RF-CF
		3509	20	676	1.000		Instruction Book
		17017	410	440	1.000		Ejector
		94555	420	440	1.000		Ejector Pin
		17019	430	440	1.000		Ejector Spring
		93712	400	435	1.000		Extractor
		305636	160	580	1.000		Firing Pin Assy
		104129	290	585	1.000		Front Guard Screw
		16430	100	580	1.000		Magazine
		92218	230	585	1.000		Magazine Follower
		15677	90	585	1.000		Magazine Spring
		21717	340	600	1.100		PROOF ROUND
		104126	300	585	1.000		Rear Guard Screw
		17034	140	580	4.000		Receiver Plug Screw
		24476	180	580	1.000		Sear Pin
		106170	280	585	1.000		Stock Assembly
		97812	50	593	2.000		Swivel Screw
		27825	505	606	2.100		TEST ROUND 30-06 SPRG 150 gr.PSPCL
		21407	360	606	3.500		TARGET ROUND 30-06 SPRG 180 gr.SPCL
		26345	190	580	1.000		Trigger Assembly
		94089	210	585	1.000		Trigger Guard Assy

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Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
27507							700 BDL - 30-06 w/o Sights DEJ#8
		301049	502	676	1.000		Cable Lock
		202261	47	400	1.000		Barrel Assembly
		98080	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	330	676	1.000		Box & Envelope Label
		1444	10	676	1.000		Carton - RF-CF
		3509	20	676	1.000		Instruction Book
		17017	410	440	1.000		Ejector
		94555	420	440	1.000		Ejector Pin
		17019	430	440	1.000		Ejector Spring
		93712	400	435	1.000		Extractor
		305636	160	580	1.000		Firing Pin Assy
		104129	290	585	1.000		Front Guard Screw
		16430	100	580	1.000		Magazine
		92218	230	585	1.000		Magazine Follower
		15677	90	585	1.000		Magazine Spring
		21717	340	600	1.100		PROOF ROUND
		104126	300	585	1.000		Rear Guard Screw
		17034	140	580	4.000		Receiver Plug Screw
		24476	180	580	1.000		Sear Pin
		202259	280	585	1.000		Stock Assembly
		97812	50	593	2.000		Swivel Screw
		27826	505	606	2.000		TEST ROUND 30-06 SPRG 150 gr.PSPCL
		21407	360	606	3.500		TARGET ROUND 30-06 SPRG 180 gr.SPCL
		26345	190	580	1.000		Trigger Assembly
		202284	210	585	1.000		Trigger Guard Assy
		202264	550	676	1.000		ROYALTY - DEJ#8
27545							700 BDL - 270 Win w/o Sights
		301049	502	676	1.000		Cable Lock
		244902	47	400	1.000		Barrel Assembly
		98080	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	330	676	1.000		Box & Envelope Label
		1444	10	676	1.000		Carton - RF-CF
		3509	20	676	1.000		Instruction Book
		17017	410	440	1.000		Ejector
		94555	420	440	1.000		Ejector Pin
		17019	430	440	1.000		Ejector Spring
		93712	400	435	1.000		Extractor

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Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
		305636	160	580	1.000		Firing Pin Assy
		104129	290	585	1.000		Front Guard Screw
		16430	100	580	1.000		Magazine
		92219	230	585	1.000		Magazine Follower
		15677	90	585	1.000		Magazine Spring
		21709	340	600	1.100		PROOF ROUND
		104126	300	585	1.000		Rear Guard Screw
		17034	140	580	4.000		Receiver Plug Screw
		24476	180	580	1.000		Sear Pin
		106170	280	585	1.000		Stock Assembly
		97812	50	593	2.000		Swivel Screw
		27810	505	606	2.000		TEST ROUND 270 WIN 150 gr.SPCL
		27810	360	606	3.500		TARGET ROUND 270 WIN 150 gr.SPCL
		26345	190	580	1.000		Trigger Assembly
		94089	210	585	1.000		Trigger Guard Assy
25801							700 EDM - 17 REM
		33460	47	405	1.000		Barrel Assembly
		28710	37	405	1.000		Bolt Assembly
		110254	87	427	1.000		Front Sight
		111320	107	427	1.000		Rear Sight Assembly
		28505	117	427	3.000		Sight Screw
		17013	130	580	1.000		Bolt Stop
		24475	170	580	1.000		Bolt Stop Pin
		15224	30	580	1.000		Bolt Stop Spring
		993002	340	676	1.000		Box & Envelope Label
		1444	10	676	1.000		Carton - RF-CF
		3509	20	676	1.000		Instruction Book
		17017	410	440	1.000		Ejector
		94555	420	440	1.000		Ejector Pin
		17019	430	440	1.000		Ejector Spring
		97138	400	435	1.000		Extractor
		305631	160	580	1.000		Firing Pin Assy
		98880	350	585	1.000		Floor Plate Insert
		104127	310	585	1.000		Front Guard Screw
		15363	70	660	1.000		Front Sight Hood
		106605	120	580	1.000		Magazine Assy
		92508	230	585	1.000		Magazine Follower
		91133	240	585	1.000		Magazine Spring
		21727	360	600	1.100		PROOF ROUND
		104126	300	585	1.000		Rear Guard Screw
		17034	140	580	4.000		Receiver Plug Screw
		24476	180	580	1.000		Sear Pin
		93616L	290	585	1.000		Stock Assembly
		15358	60	593	2.000		Swivel Screw
		94241	250	593	2.000		Swivel Screw Spacer

5798	301049	502
	28373	37
	28710	47

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Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
		110254	87	427	1.000		Front Sight
		111320	107	427	1.000		Rear Sight Assembly
		28505	117	427	3.000		Sight Screw
		17013	130	580	1.000		Bolt Stop
		24475	170	580	1.000		Bolt Stop Pin
		15224	30	580	1.000		Bolt Stop Spring
		993002	340	676	1.000		Box & Envelope Label
		1444	10	676	1.000		Carton - RF-CF
		3509	20	676	1.000		Instruction Book
		17017	410	440	1.000		Ejector
		94555	420	440	1.000		Ejector Pin
		17019	430	440	1.000		Ejector Spring
		97138	400	435	1.000		Extractor
		305631	160	580	1.000		Firing Pin Assy
		98880	350	585	1.000		Floor Plate Insert
		104127	310	585	1.000		Front Guard Screw
		15363	70	660	1.000		Front Sight Hood
		106605	120	580	1.000		Magazine Assy
		92508	230	585	1.000		Magazine Follower
		91133	240	585	1.000		Magazine Spring
		21774	360	600	1.100		PROOF ROUND
		104126	300	585	1.000		Rear Guard Screw
		17034	140	580	4.000		Receiver Plug Screw
		24476	180	580	1.000		Sear Pin
		93616L	290	585	1.000		Stock Assembly
		15358	60	593	2.000		Swivel Screw
		94241	250	593	2.000		Swivel Screw Spacer
		28399	505	606	2.000		TEST ROUND 223 REM 55 gr.PSP
		28399	370	606	3.500		TARGET ROUND 223 REM 55 gr.PSP
		26345	190	580	1.000		Trigger Assembly
		26370	210	585	1.000		Trigger Guard Assy
25783							700 BDL - 22-250 REM
		301049	502	676	1.000		Cable Lock
		33452	47	405	2.000		Barrel Assembly
		28711	37	405	1.000		Bolt Assembly
		110254	87	427	1.000		Front Sight
		111320	107	427	1.000		Rear Sight Assembly
		28505	117	427	3.000		Sight Screw
		17013	130	580	1.000		Bolt Stop
		24475	170	580	1.000		Bolt Stop Pin
		15224	30	580	1.000		Bolt Stop Spring
		993002	340	676	1.000		Box & Envelope Label
		1444	10	676	1.000		Carton - RF-CF
		3509	20	676	1.000		Instruction Book
		17017	410	440	1.000		Ejector

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Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
		94555	420	440	1.000		Ejector Pin
		17019	430	440	1.000		Ejector Spring
		93712	400	435	1.000		Extractor
		305631	160	580	1.000		Firing Pin Assy
		104127	300	585	1.000		Front Guard Screw
		15363	60	660	1.000		Front Sight Hood
		16715	120	580	1.000		Magazine
		90982	230	585	1.000		Magazine Follower
		15699	90	585	1.000		Magazine Spring
		21853	340	600	1.100		PROOF ROUND
		104126	290	585	1.000		Rear Guard Screw
		17034	140	580	4.000		Receiver Plug Screw
		24476	180	580	1.000		Sear Pin
		93616L	280	585	1.000		Stock Assembly
		15358	50	593	2.000		Swivel Screw
		94241	240	593	2.000		Swivel Screw Spacer
		21313	505	606	2.000		TEST ROUND 22-250 REM 55 gr.HPPL
		21313	350	606	3.000		TARGET ROUND 22-250 REM 55 gr.HPPL
		26345	190	580	1.000		Trigger Assembly
		26370	210	585	1.000		Trigger Guard Assy
25787							700 BDL - 243 WIN
		301049	502	676	1.000		Cable Lock
		33451	47	405	1.000		Barrel Assembly
		28711	37	425	1.000		Bolt Assembly
		110254	87	427	1.000		Front Sight
		111320	107	427	1.000		Rear Sight Assembly
		28505	117	427	3.000		Sight Screw
		17013	120	580	1.000		Bolt Stop
		24475	160	580	1.000		Bolt Stop Pin
		15224	30	580	1.000		Bolt Stop Spring
		993002	330	575	1.000		Box & Envelope Label
		1444	10	676	1.000		Carton - RF-CF
		3509	20	676	1.000		Instruction Book
		17013	410	440	2.000		Ejector
		94555	420	440	1.000		Ejector Pin
		17019	430	440	1.000		Ejector Spring
		93712	400	435	1.000		Extractor
		305631	160	580	1.000		Firing Pin Assy
		104127	290	585	1.000		Front Guard Screw
		15363	60	660	1.000		Front Sight Hood
		16715	110	580	1.000		Magazine
		90982	220	585	1.000		Magazine Follower
		15699	140	585	1.000		Magazine Spring
		21699	340	600	1.190		PROOF ROUND
		104126	280	585	1.000		Rear Guard Screw

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Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
		17034	130	580	4.000		Receiver Plug Screw
		24476	170	580	1.000		Sear Pin
		93616L	270	585	1.000		Stock Assembly
		15358	50	593	2.000		Swivel Screw
		94241	230	593	2.000		Swivel Screw Spacer
		27802	505	606	2.000		TEST ROUND 243 WIN 100 gr.PSPCL
		27802	360	606	3.500		TARGET ROUND 243 WIN 100 gr.PSPCL
		26345	180	580	1.000		Trigger Assembly
		26370	200	585	1.000		Trigger Guard Assy
25785							700 BDL - 6MM REM
		301049	502	676	1.000		Cable Lock
		33452	47	405	1.000		Barrel Assembly
		28711	37	405	1.000		Bolt Assembly
		110254	87	427	1.000		Front Sight
		111320	107	427	1.000		Rear Sight Assembly
		28505	117	427	3.000		Sight Screw
		17013	120	580	1.000		Bolt Stop
		24475	170	580	1.000		Bolt Stop Pin
		15224	30	580	1.000		Bolt Stop Spring
		993002	330	676	1.000		Box & Envelope Label
		1444	10	676	1.000		Carton - RF-CF
		3509	20	676	1.000		Instruction Book
		17017	410	440	1.000		Ejector
		94555	420	440	1.000		Ejector Pin
		17019	430	440	1.000		Ejector Spring
		93712	400	435	1.000		Extractor
		305631	160	580	1.000		Firing Pin Assy
		104127	300	585	1.000		Front Guard Screw
		15363	60	660	1.000		Front Sight Hood
		16715	110	580	1.000		Magazine
		90982	230	585	1.000		Magazine Follower
		15699	140	585	1.000		Magazine Spring
		21844	340	600	1.100		PROOF ROUND
		104128	290	585	2.000		Rear Guard Screw
		17034	130	580	4.000		Receiver Plug Screw
		24476	180	580	1.000		Sear Pin
		93616L	280	585	1.000		Stock Assembly
		15358	50	593	2.000		Swivel Screw
		94241	240	593	2.000		Swivel Screw Spacer
		29051	505	606	2.000		Test Round 6MM REM 100 gr.PSP
		29051	350	606	3.500		Target Round 6MM REM 100 gr.PSP
		26345	190	580	1.000		Trigger Assembly
		26370	210	585	1.000		Trigger Guard Assy
25753							700 BDL - 257 Roberts

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Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
		301049	502	676	1.000		Cable Lock
		94643	67	400	1.000		Barrel Assembly
		28712	37	400	1.000		Bolt Assembly
		110254	87	427	1.000		Front Sight
		111320	107	427	1.000		Rear Sight Assembly
		28505	117	427	3.000		Sight Screw
		17013	130	580	1.000		Bolt Stop
		24475	160	580	1.000		Bolt Stop Pin
		15224	30	580	1.000		Bolt Stop Spring
		993002	320	676	1.000		Box & Envelope Label
		1444	10	676	1.000		Carton - RF-CF
		3509	20	676	1.000		Instruction Book
		17017	410	440	1.000		Ejector
		94555	420	440	1.000		Ejector Pin
		17019	430	440	1.000		Ejector Spring
		93712	400	435	1.000		Extractor
		305630	150	580	1.000		Firing Pin Assy
		104125	280	585	1.000		Front Guard Screw
		15363	60	660	1.000		Front Sight Hood
		16430	100	580	1.000		Magazine
		92218	220	585	1.000		Magazine Follower
		15699	90	585	1.000		Magazine Spring
		21704	330	600	1.100		PROOF ROUND
		104126	290	585	1.000		Rear Guard Screw
		17034	140	580	4.000		Receiver Plug Screw
		24476	170	580	1.000		Sear Pin
		93617L	270	585	1.000		Stock Assembly
		15358	50	585	2.000		Swivel Screw
		94241	230	593	2.000		Swivel Screw Spacer
		28335	505	606	2.000		TEST ROUND 257 ROBERTS 117 gr.SPCL
		28335	340	606	3.500		TARGET ROUND 257 ROBERTS 117 gr.SPCL
		26345	180	580	1.000		Trigger Assembly
		26371	200	585	1.000		Trigger Guard Assy
25789							700 BDL - 25-06 REM
		301049	502	676	1.000		Cable Lock
		33456	42	400	1.000		Barrel Assembly
		28712	37	400	1.000		Bolt Assembly
		110254	87	427	1.000		Front Sight
		111320	107	427	1.000		Rear Sight Assembly
		28505	117	427	3.000		Sight Screw
		17013	130	580	1.000		Bolt Stop
		24475	170	580	1.000		Bolt Stop Pin
		15224	30	580	1.000		Bolt Stop Spring
		993002	320	676	1.000		Box & Envelope Label
		1444	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	410	440	1.000		Ejector
		94555	420	440	1.000		Ejector Pin
		17019	430	440	1.000		Ejector Spring
		93712	400	435	1.000		Extractor
		305630	160	580	1.000		Firing Pin Assy
		104129	290	585	1.000		Front Guard Screw
		15363	60	660	1.000		Front Sight Hood
		16430	100	580	1.000		Magazine
		92218	230	585	1.000		Magazine Follower
		15677	90	585	1.000		Magazine Spring
		21714	340	600	1.100		PROOF ROUND
		104126	300	585	1.000		Rear Guard Screw
		17034	140	580	4.000		Receiver Plug Screw
		24476	180	580	1.000		Sear Pin
		93617L	280	585	1.000		Stock Assembly
		15358	50	593	2.000		Swivel Screw
		94241	240	593	2.000		Swivel Screw Spacer
		21515	505	606	2.000		TEST ROUND 25-06 REM 120 gr.PSPCL
		21515	360	606	3.500		TARGET ROUND 25-06 REM 120 gr.PSPCL
		26345	190	580	1.000		Trigger Assembly
		26371	210	585	1.000		Trigger Guard Assy
25791							700 BDL - 270 WIN
		301049	502	876	1.000		Cable Lock
		33454	47	400	1.000		Barrel Assembly
		28712	37	400	1.000		Bolt Assembly
		110254	87	427	1.000		Front Sight
		111320	107	427	1.000		Rear Sight Assembly
		28505	117	427	3.000		Sight Screw
		17013	130	580	1.000		Bolt Stop
		24475	170	580	1.000		Bolt Stop Pin
		15224	20	580	1.000		Bolt Stop Spring
		993002	330	676	1.000		Box & Envelope Label
		1444	10	876	2.000		Carton - RF-CF
		3509	20	676	1.000		Instruction Book
		17017	410	440	1.000		Ejector
		94555	420	440	1.000		Ejector Pin
		17019	430	440	1.000		Ejector Spring
		93712	400	435	1.000		Extractor
		305630	160	580	1.000		Firing Pin Assy
		104129	290	585	1.000		Front Guard Screw
		15363	60	660	1.000		Front Sight Hood
		16430	100	580	1.000		Magazine
		92218	230	585	1.000		Magazine Follower
		15677	90	585	1.000		Magazine Spring

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Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
		21709	340	600	1.100		PROOF ROUND
		104126	300	585	1.000		Rear Guard Screw
		17034	140	580	4.000		Receiver Plug Screw
		24476	180	580	1.000		Sear Pin
		93617L	280	585	1.000		Stock Assembly
		15358	50	593	2.000		Swivel Screw
		94241	240	593	2.000		Swivel Screw Spacer
		27810	505	606	2.000		TEST ROUND 270 WIN 150 gr.SPCL
		27810	360	606	3.500		TARGET ROUND 270 WIN 150 gr.SPCL
		26345	190	580	1.000		Trigger Assembly
		26371	210	585	1.000		Trigger Guard Assy
25797							400 BDL - 280 REM
		301049	502	676	1.000		Cable Lock
		33462	47	400	1.000		Barrel Assembly
		28712	37	400	1.000		Bolt Assembly
		110254	87	427	1.000		Front Sight
		111320	107	427	1.000		Rear Sight Assembly
		28505	117	427	3.000		Sight Screw
		17013	130	580	1.000		Bolt Stop
		24475	160	580	1.000		Bolt Stop Pin
		15224	30	580	1.000		Bolt Stop Spring
		993002	320	676	1.000		Box & Envelope Label
		1444	10	676	1.000		Carton - RF-CF
		3509	20	676	1.000		Instruction Book
		17017	410	440	1.000		Ejector
		94555	420	440	1.000		Ejector Pin
		17019	430	440	1.000		Ejector Spring
		93712	400	436	1.000		Extractor
		305630	150	580	1.000		Firing Pin Assy
		104129	280	585	1.000		Front Guard Screw
		15363	60	560	1.000		Front Sight Hood
		16430	100	580	1.000		Magazine
		92218	220	585	1.000		Magazine Follower
		15677	90	585	2.000		Magazine Spring
		21710	330	600	1.075		PROOF ROUND
		104126	290	585	1.000		Rear Guard Screw
		17034	140	580	4.000		Receiver Plug Screw
		24476	170	580	1.000		Sear Pin
		93617L	270	585	1.000		Stock Assembly
		15358	50	593	2.000		Swivel Screw
		94241	230	593	2.000		Swivel Screw Spacer
		29069	505	606	2.000		TEST ROUND 280 REM 150 gr.PSPCL
		29069	340	606	3.500		TARGET ROUND 280 REM 150 gr.PSPCL
		26345	180	580	1.000		Trigger Assembly
		26371	200	585	1.000		Trigger Guard Assy

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Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
25799							700 BDL - 7MM-08 REM
		301049	502	676	1.000		Cable Lock
		28370	37	400	1.000		Barrel Assembly
		28711	47	400	1.000		Bolt Assembly
		110254	87	427	1.000		Front Sight
		111320	107	427	1.000		Rear Sight Assembly
		28505	117	427	3.000		Sight Screw
		17013	120	580	1.000		Bolt Stop
		24475	170	580	1.000		Bolt Stop Pin
		15224	30	580	1.000		Bolt Stop Spring
		993002	330	676	1.000		Box & Envelope Label
		1444	10	676	1.000		Carton - RF-CF
		3509	20	676	1.000		Instruction Book
		17017	410	440	1.000		Ejector
		94555	420	440	1.000		Ejector Pin
		17019	430	440	1.000		Ejector Spring
		93712	400	435	1.000		Extractor
		305631	160	580	1.000		Firing Pin Assy
		104127	300	585	1.000		Front Guard Screw
		15363	60	660	1.000		Front Sight Hood
		16715	110	580	1.000		Magazine
		90982	230	585	1.000		Magazine Follower
		15699	140	585	1.000		Magazine Spring
		21779	340	580	1.100		PROOF ROUND
		104126	290	585	1.000		Rear Guard Screw
		17034	130	580	4.000		Receiver Plug Screw
		24476	180	580	1.000		Sear Pin
		93616L	280	585	1.000		Stock Assembly
		15358	50	593	2.000		Swivel Screw
		94241	240	593	2.000		Swivel Screw Spacer
		21337	505	595	2.000		TEST ROUND 7MM-08 REM 140 gr.PSP
		21337	350	596	8.000		TARGET ROUND 7MM-08 REM 140 gr.PSP
		26345	190	580	1.000		Trigger Assembly
		26372	210	585	1.000		Trigger Guard Assy
25803							700 BDL - 7MM Rem Mag
		301049	502	676	1.000		Cable Lock
		33459	67	415	1.000		Barrel Assembly
		33273	57	415	1.000		Bolt Assembly
		110255	87	427	1.000		Front Sight
		111321	107	427	1.000		Rear Sight Assembly
		28505	117	427	3.000		Sight Screw
		17013	130	580	1.000		Bolt Stop
		24475	170	580	1.000		Bolt Stop Pin
		15224	40	580	1.000		Bolt Stop Spring

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Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
		993002	330	676	1.000		Box & Envelope Label
		1444	10	676	1.000		Carton - RF-CF
		3509	20	676	1.000		Instruction Book
		17017	410	440	1.000		Ejector
		94555	420	440	1.000		Ejector Pin
		17019	430	440	1.000		Ejector Spring
		97322	400	432	1.000		Extractor
		27341	440	432	1.000		Extractor Rivet
		305630	160	580	1.000		Firing Pin Assy
		104129	290	585	1.000		Front Guard Screw
		15363	70	660	1.000		Front Sight Hood
		16430	100	580	1.000		Magazine
		90952	230	585	1.000		Magazine Follower
		15677	90	585	1.000		Magazine Spring
		21736	340	600	1.132		PROOF ROUND
		104126	300	585	1.000		Rear Guard Screw
		17034	140	580	4.000		Receiver Plug Screw
		24476	180	580	1.000		Sear Pin
		202345L	280	585	1.000		Stock Assembly R3
		15358	60	593	2.000		Swivel Screw
		94241	240	593	2.000		Swivel Screw Spacer
		27814	505	606	2.000		TEST ROUND 7MM REM MAG 175 gr.PSPCL
		27814	360	606	3.500		TARGET ROUND 7MM REM MAG 175 gr.PSPCL
		26345	190	580	1.000		Trigger Assembly
		26371	210	585	1.000		Trigger Guard Assy
25755							700 BDL - 300 Savage
		301049	502	676	1.000		Cable Lock
		94764	67	400	1.000		Barrel Assembly
		28711	37	400	1.000		Bolt Assembly
		110254	87	427	1.000		Front Sight
		111320	107	427	1.000		Rear Sight Assembly
		28505	117	427	3.000		Sight Screw
		17013	120	580	1.000		Bolt Stop
		24473	160	580	2.000		Bolt Stop Pin
		15224	30	580	1.000		Bolt Stop Spring
		993002	340	676	1.000		Box & Envelope Label
		1444	10	676	1.000		Carton - RF-CF
		3509	20	676	1.000		Instruction Book
		17017	410	440	1.000		Ejector
		94555	420	440	1.000		Ejector Pin
		17019	430	440	1.000		Ejector Spring
		97322	400	432	1.000		Extractor
		305631	150	580	1.000		Firing Pin Assy
		104127	290	585	1.000		Front Guard Screw
		15363	60	660	1.000		Front Sight Hood

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Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
		16715	110	580	1.000		Magazine
		90982	220	585	1.000		Magazine Follower
		15699	140	585	1.000		Magazine Spring
		21719	350	600	1.100		PROOF ROUND
		104126	280	585	1.000		Rear Guard Screw
		17034	130	580	4.000		Receiver Plug Screw
		24476	170	580	1.000		Sear Pin
		93616L	270	585	1.000		Stock Assembly
		15358	50	593	2.000		Swivel Screw
		94241	230	593	2.000		Swivel Screw Spacer
		21465	505	606	2.000		TEST ROUND 300 SAVAGE 150 gr.PSPCL
		21465	360	606	3.500		TARGET ROUND 300 SAVAGE 150 gr.PSPCL
		26345	180	580	1.000		Trigger Assembly
		26370	200	585	1.000		Trigger Guard Assy
25795							*700 BDL - 308 WIN
		301049	502	676	1.000		Cable Lock
		33453	47	400	1.000		Barrel Assembly
		28711	37	400	1.000		Bolt Assembly
		110254	87	427	1.000		Front Sight
		111320	107	427	1.000		Rear Sight Assembly
		28505	117	427	3.000		Sight Screw
		17013	120	580	1.000		Bolt Stop
		24475	170	580	1.000		Bolt Stop Pin
		15224	30	580	1.000		Bolt Stop Spring
		993002	330	676	1.000		Box & Envelope Label
		1444	10	676	1.000		Carton - RF-CF
		3509	20	676	1.000		Instruction Book
		17017	410	440	1.000		Ejector
		94555	420	440	1.000		Ejector Pin
		17019	430	440	1.000		Ejector Spring
		93712	400	435	1.000		Extractor
		305631	160	580	1.000		Firing Pin Assy
		104127	300	585	1.000		Front Guard Screw
		15363	60	580	2.000		Front Sight Hood
		16715	110	580	1.000		Magazine
		90982	220	585	1.000		Magazine Follower
		15699	140	585	1.000		Magazine Spring
		21723	340	600	1.175		PROOF ROUND
		104126	280	585	1.000		Rear Guard Screw
		17034	130	580	4.000		Receiver Plug Screw
		24476	180	580	1.000		Sear Pin
		93616L	280	585	1.000		Stock Assembly
		15358	50	593	2.000		Swivel Screw
		94241	240	593	2.000		Swivel Screw Spacer
		27842	505	606	2.000		TEST ROUND 308 WIN 150 gr.PSPCL

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Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
25793		27844	360	606	3.500		TARGET ROUND 308 WIN 180 gr.SPCL
		26345	190	580	1.000		Trigger Assembly
		26370	210	585	1.000		Trigger Guard Assy
							700 BDL - 30-06 SPRG
		301049	502	676	1.000		Cable Lock
		33455	47	400	1.000		Barrel Assembly
		28712	37	400	1.000		Bolt Assembly
		110254	87	427	1.000		Front Sight
		111320	107	427	1.000		Rear Sight Assembly
		28505	117	427	3.000		Sight Screw
		17013	130	580	1.000		Bolt Stop
		24475	170	580	1.000		Bolt Stop Pin
		15224	30	580	1.000		Bolt Stop Spring
		993002	330	676	1.000		Box & Envelope Label
		1444	10	676	1.000		Carton - RF-CF
		3509	20	676	1.000		Instruction Book
		17017	410	440	1.000		Ejector
		94555	420	440	1.000		Ejector Pin
		17019	430	440	1.000		Ejector Spring
		93712	400	435	1.000		Extractor
		305630	160	580	1.000		Firing Pin Assy
		104129	290	585	1.000		Front Guard Screw
		15363	60	660	1.000		Front Sight Hood
		16430	100	580	1.000		Magazine
		92218	230	585	1.000		Magazine Follower
		15677	90	585	1.000		Magazine Spring
		21717	340	600	1.100		PROOF ROUND
		104126	300	585	1.000		Rear Guard Screw
		17034	140	580	4.000		Receiver Plug Screw
		24476	180	580	1.000		Sear Pin
		93617L	280	585	1.000		Stock Assembly
		15358	50	593	2.000		Swivel Screw
		94241	240	593	2.000		Swivel Screw Spacer
		27828	505	606	2.000		TEST ROUND 30-06 SPRG 150 gr.PSPCL
		21407	160	606	3.500		TARGET ROUND 30-06 SPRG 180 gr.SPCL
		26345	190	580	1.000		Trigger Assembly
		26371	210	585	1.000		Trigger Guard Assy
26063							700 BDL - 30-06 SPRG (Eliphalet 200 B-Day)
		301049	502	676	1.000		Cable Lock
		97911	57	400	1.000		Barrel Assembly
		97912	67	400	1.000		Bolt Assembly
		110254	87	427	1.000		Front Sight
		97914	107	427	1.000		Rear Sight Assembly
		28505	117	427	3.000		Sight Screw

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Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
		17013	110	580	1.000		Bolt Stop
		24475	130	580	1.000		Bolt Stop Pin
		15224	20	580	1.000		Bolt Stop Spring
		993002	270	676	1.000		Box & Envelope Label
		1444	10	676	1.000		Carton - RF-CF
		3509	300	676	1.000		Instruction Book
		17017	410	440	1.000		Ejector
		94555	420	440	1.000		Ejector Pin
		17019	430	440	1.000		Ejector Spring
		93712	400	435	1.000		Extractor
		97915	220	580	1.000		Firing Pin Assy
		15291	30	585	1.000		Floor Plate Latch
		16451	90	585	1.000		Floor Plate Latch Pin
		16452	100	585	1.000		Floor Plate Latch Spring
		104129	250	585	1.000		Front Guard Screw
		15363	50	660	1.000		Front Sight Hood
		16430	80	580	1.000		Magazine
		92218	170	585	1.000		Magazine Follower
		15677	70	585	1.000		Magazine Spring
		21717	310	600	1.100		PROOF ROUND
		104126	260	585	1.000		Rear Guard Screw
		17034	120	580	4.000		Receiver Plug Screw
		24476	140	580	1.000		Sear Pin
		97916	230	585	1.000		Stock Assembly
		15358	40	593	2.000		Swivel Screw
		94241	180	593	2.000		Swivel Screw Spacer
		27826	505	606	2.000		TEST ROUND 30-06 SPRG 150 gr.PSPCL
		21407	330	606	3.500		TARGET ROUND 30-06 SPRG 180 gr.SPCL
		26345	150	580	1.000		Trigger Assembly
		97919	240	585	1.000		Trigger Guard Sub-Assy
25807							700 BDL - 300 Win Mag
		301049	500	676	1.000		Cable Lock
		33458	57	415	1.000		Barrel Assembly
		33273	47	415	2.000		Bolt Assembly
		110255	87	427	1.000		Front Sight
		111321	102	427	1.000		Rear Sight Assembly
		28505	117	427	3.000		Sight Screw
		17013	130	580	1.000		Bolt Stop
		24475	170	580	1.000		Bolt Stop Pin
		15224	40	580	1.000		Bolt Stop Spring
		993002	330	676	1.000		Box & Envelope Label
		1444	10	676	1.000		Carton - RF-CF
		3509	20	676	1.000		Instruction Book
		17017	410	440	1.000		Ejector
		94555	420	440	1.000		Ejector Pin

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Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
		17019	430	440	1.000		Ejector Spring
		97322	400	432	1.000		Extractor
		27341	440	432	1.000		Extractor Rivet
		305630	160	580	1.000		Firing Pin Assy
		104129	290	585	1.000		Front Guard Screw
		15363	70	660	1.000		Front Sight Hood
		16430	100	580	1.000		Magazine
		90952	230	585	1.000		Magazine Follower
		15677	90	585	1.000		Magazine Spring
		21846	340	600	1.100		PROOF ROUND
		104126	300	585	1.000		Rear Guard Screw
		17034	140	580	4.000		Receiver Plug Screw
		24476	180	580	1.000		Sear Pin
		202345L	280	585	1.000		Stock Assembly R3
		15358	60	593	2.000		Swivel Screw
		94241	240	593	2.000		Swivel Screw Spacer
		29497	505	606	2.000		TEST ROUND 300 WIN MAG 180 gr.PSPCL
		29497	360	606	3.000		TARGET ROUND 300 WIN MAG 180 gr.PSPCL
		26345	190	580	1.000		Trigger Assembly
		26371	210	585	1.000		Trigger Guard Assy
25805							700 BDL - 338 Win Mag
		301049	502	676	1.000		Cable Lock
		93609	57	415	1.000		Barrel Assembly
		33273	47	415	1.000		Bolt Assembly
		110255	87	427	1.000		Front Sight
		111321	107	427	1.000		Rear Sight Assembly
		28505	117	427	3.000		Sight Screw
		17013	130	580	1.000		Bolt Stop
		24475	160	580	1.000		Bolt Stop Pin
		15224	40	580	1.000		Bolt Stop Spring
		993002	320	576	1.000		Box & Envelope Label
		1444	10	676	1.000		Carton - RF-CF
		3509	20	676	1.000		Instruction Book
		17013	410	440	2.000		Ejector
		94555	420	440	1.000		Ejector Pin
		17019	430	440	1.000		Ejector Spring
		97322	400	432	1.000		Extractor
		27341	440	432	1.000		Extractor Rivet
		305630	150	580	1.000		Firing Pin Assy
		104129	280	585	1.000		Front Guard Screw
		15363	70	660	1.000		Front Sight Hood
		16430	100	580	1.000		Magazine
		90952	220	585	1.000		Magazine Follower
		15677	90	585	1.000		Magazine Spring
		21790	330	600	1.115		PROOF ROUND

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Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
		104126	290	585	1.000		Rear Guard Screw
		17034	140	580	4.000		Receiver Plug Screw
		24476	170	580	1.000		Sear Pin
		202345L	270	585	1.000		Stock Assembly
		15358	60	593	2.000		Swivel Screw
		94241	230	593	2.000		Swivel Screw Spacer
		22191	350	606	1.750		TEST ROUND 338 WIN MAG 250 PSP
		26345	180	580	1.000		Trigger Assembly
		26371	200	585	1.000		Trigger Guard Assy
29665							700 BDL - 416 REM MAG (Special Offering)
		301049	502	676	1.000		Cable Lock
		200173	17	400	1.000		Barrel Assembly
		33273	27	400	1.000		Bolt Assembly
		110252	87	427	1.000		Front Sight
		111321	107	427	1.000		Rear Sight Assembly
		28505	117	427	3.000		Sight Screw
		17013	30	580	1.000		Bolt Stop
		24475	40	580	1.000		Bolt Stop Pin
		15224	50	580	1.000		Bolt Stop Spring
		993002	60	676	1.000		Box & Envelope Label
		1444	70	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
		97322	430	432	1.000		Extractor
		27341	440	432	1.000		Extractor Rivet
		305630	80	580	1.000		Firing Pin Assembly
		108492	90	585	1.000		Front Guard Screw
		16430	130	580	1.000		Magazine
		200370	200	580	1.000		Magazine Spacer
		90952	140	585	1.000		Magazine Follower
		15677	150	585	1.000		Magazine Spring
		108492	160	585	2.000		Rear Guard Screw
		17034	180	580	4.000		Receiver Plug Screw
		24476	190	580	1.000		Sear Pin
		200246	210	585	1.000		Stock Assembly
		15358	220	593	2.000		Swivel Screw
		94241	230	593	2.000		Swivel Screw Spacer
		26345	240	580	1.000		Trigger Assembly
		200296	250	585	1.000		Trigger Guard Assembly
		21800	270	600	1.100		Proof Round
		27934	505	606	2.000		Test Round - 416 REM Mag 400 gr.Solid
		27934	280	606	3.500		Target Round - 416 REM Mag 400 gr.Solid

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Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
25749							700 BDL LH - 22-250 REM
		301049	502	676	1.000		Cable Lock
		33490	47	405	1.000		Barrel Assembly
		28757	37	405	1.000		Bolt Assembly
		110254	87	427	1.000		Front Sight
		111320	107	427	1.000		Rear Sight Assembly
		28505	117	427	3.000		Sight Screw
		17013	130	580	1.000		Bolt Stop
		24475	170	580	1.000		Bolt Stop Pin
		90554	30	580	1.000		Bolt Stop Spring
		993002	320	676	1.000		Box & Envelope Label
		1444	10	676	1.000		Carton - RF-CF
		3509	20	676	1.000		Instruction Book
		17017	410	440	1.000		Ejector
		94555	420	440	1.000		Ejector Pin
		17019	430	440	1.000		Ejector Spring
		93712	400	435	1.000		Extractor
		305631	160	580	1.000		Firing Pin Assy
		104127	290	585	1.000		Front Guard Screw
		15363	60	660	1.000		Front Sight Hood
		16715	120	580	1.000		Magazine
		90982	230	585	1.000		Magazine Follower
		15699	90	585	1.000		Magazine Spring
		21853	350	600	1.100		PROOF ROUND
		104126	280	585	1.000		Rear Guard Screw
		17034	140	580	1.000		Receiver Plug Screw
		24476	180	580	1.000		Sear Pin
		103603	270	585	1.000		Stock Assembly
		15358	50	593	2.000		Swivel Screw
		94241	340	593	2.000		Swivel Screw Spacer
		21313	503	606	2.000		TEST ROUND 22-250 REM 55 gr.HPPL
		21313	360	606	3.500		TARGET ROUND 22-250 REM 55 gr.HPPL
		32895	220	580	1.000		Trigger Assembly
		26370	200	585	1.000		Trigger Guard Assy
25819							700 BDL LH - 243 WIN
		301049	502	676	1.000		Cable Lock
		33492	47	405	1.000		Barrel Assembly
		28757	37	405	1.000		Bolt Assembly
		110254	87	427	1.000		Front Sight
		111320	107	427	1.000		Rear Sight Assembly
		28505	117	427	3.000		Sight Screw
		17013	130	580	1.000		Bolt Stop
		24475	160	580	1.000		Bolt Stop Pin
		90554	30	580	1.000		Bolt Stop Spring
		993002	330	676	1.000		Box & Envelope Label

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Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
		1444	10	676	1.000		Carton - RF-CF
		3509	20	676	1.000		Instruction Book
		17017	410	440	1.000		Ejector
		94555	420	440	1.000		Ejector Pin
		17019	430	440	1.000		Ejector Spring
		93712	400	435	1.000		Extractor
		305631	150	580	1.000		Firing Pin Assy
		104127	290	585	1.000		Front Guard Screw
		15363	60	660	1.000		Front Sight Hood
		16715	120	580	1.000		Magazine
		90982	220	585	1.000		Magazine Follower
		15699	90	585	1.000		Magazine Spring
		21699	340	600	1.150		PROOF ROUND
		104126	280	585	1.000		Rear Guard Screw
		17034	140	580	4.000		Receiver Plug Screw
		24476	170	580	1.000		Sear Pin
		103603	270	585	1.000		Stock Assembly
		15358	50	593	2.000		Swivel Screw
		94241	230	593	1.000		Swivel Screw Spacer
		27802	505	606	2.000		LEAD ROUND 243 WIN 100 gr.PSPCL
		21319	360	606	2.500		TARGET ROUND 243 WIN 80 gr.TARGET
		32895	210	580	1.000		Trigger Assembly
		26370	190	585	1.000		Trigger Guard Assy
25811							700 BDL LH - 270 WIN
		301049	502	676	1.000		Cable Lock
		33495	47	400	1.000		Barrel Assembly
		28755	37	400	1.000		Bolt Assembly
		110254	87	427	1.000		Front Sight
		111320	107	427	1.000		Rear Sight Assembly
		28505	117	427	3.000		Sight Screw
		17013	120	580	1.000		Bolt Stop
		24475	160	580	1.000		Bolt Stop Pin
		90554	220	580	1.000		Bolt Stop Spring
		993002	330	676	1.000		Box & Envelope Label
		1444	10	676	1.000		Carton - RF-CF
		3509	20	676	1.000		Instruction Book
		17017	410	440	1.000		Ejector
		94555	420	440	1.000		Ejector Pin
		17019	430	440	1.000		Ejector Spring
		93712	400	435	1.000		Extractor
		305630	150	580	1.000		Firing Pin Assy
		104128	290	585	1.000		Front Guard Screw
		15363	60	660	1.000		Front Sight Hood
		16430	90	580	1.000		Magazine
		92218	230	585	1.000		Magazine Follower

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Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
		15677	80	585	1.000		Magazine Spring
		21709	340	600	1.100		PROOF ROUND
		104126	300	585	1.000		Rear Guard Screw
		17034	130	580	4.000		Receiver Plug Screw
		24476	170	580	1.000		Sear Pin
		103604	280	585	1.000		Stock Assembly
		15358	40	593	2.000		Swivel Screw
		94241	240	593	2.000		Swivel Screw Spacer
		27810	505	606	2.000		TEST ROUND 270 WIN 150 gr.SPCL
		27810	360	606	3.500		TARGET ROUND 270 WIN 150 gr.SPCL
		32895	210	580	1.000		Trigger Assembly
		26371	190	585	1.000		Trigger Guard Assy
25815							700 BDL LH - 7MM Rem Mag
		301049	502	676	1.000		Cable Lock
		33497	67	415	1.000		Barrel Assembly
		33307	57	415	1.000		Bolt Assembly
		110255	87	427	1.000		Front Sight
		111321	107	427	1.000		Rear Sight Assembly
		28505	117	427	3.000		Sight Screw
		17013	120	580	1.000		Bolt Stop
		24475	160	580	1.000		Bolt Stop Pin
		90554	220	580	1.000		Bolt Stop Spring
		993002	330	676	1.000		Box & Envelope Label
		1444	10	676	1.000		Carton - RF-CF
		3509	20	676	1.000		Instruction Book
		17017	410	440	1.000		Ejector
		94555	420	440	1.000		Ejector Pin
		17019	430	440	1.000		Ejector Spring
		97322	400	432	1.000		Extractor
		27341	440	432	1.000		Extractor Rivet
		305630	150	580	1.000		Firing Pin Assy
		104129	290	585	1.000		Front Guard Screw
		15363	60	660	1.000		Front Sight Hood
		16430	90	580	2.000		Magazine
		90952	230	585	1.000		Magazine Follower
		15677	80	585	1.000		Magazine Spring
		21736	350	600	1.125		PROOF ROUND
		104126	300	585	1.000		Rear Guard Screw
		17034	130	580	4.000		Receiver Plug Screw
		24476	170	580	1.000		Sear Pin
		113138	280	585	1.000		Stock Assembly R3
		15358	50	593	2.000		Swivel Screw
		94241	240	593	2.000		Swivel Screw Spacer
		27814	505	606	2.000		TEST ROUND 7MM REM MAG 175 gr.PSPCL
		27814	370	606	3.500		TARGET ROUND 7MM REM MAG 175 gr.PSPCL

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Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
25818		32895	210	580	1.000		Trigger Assembly
		26371	190	585	1.000		Trigger Guard Assy
							700 BDL LH - 308 WIN
		301049	502	676	1.000		Cable Lock
		33493	47	400	1.000		Barrel Assembly
		28757	37	400	1.000		Bolt Assembly
		110254	87	427	1.000		Front Sight
		111320	107	427	1.000		Rear Sight Assembly
		28505	117	427	3.000		Sight Screw
		17013	130	580	1.000		Bolt Stop
		24475	170	580	1.000		Bolt Stop Pin
		90554	30	580	1.000		Bolt Stop Spring
		993002	320	676	1.000		Box & Envelope Label
		1444	10	676	1.000		Carton - RF-CF
		3509	20	676	1.000		Instruction Book
		17017	410	440	1.000		Ejector
		94555	420	440	1.000		Ejector Pin
		17019	430	440	1.000		Ejector Spring
		93712	400	435	1.000		Extractor
		305631	160	585	1.000		Firing Pin Assy
		104127	290	585	1.000		Front Guard Screw
		15363	60	660	1.000		Front Sight Hood
		16715	120	580	1.000		Magazine
		90982	230	585	1.000		Magazine Follower
		15699	90	585	1.000		Magazine Spring
		21723	330	600	1.450		PROOF ROUND
		104126	280	585	1.000		Rear Guard Screw
		17034	140	580	4.000		Receiver Plug Screw
		24476	180	580	1.000		Sear Pin
		103603	270	585	1.000		Stock Assembly
		15358	50	593	2.000		Swivel Screw
		94241	310	593	2.000		Swivel Screw Spacer
		27842	505	606	2.000		TEST ROUND 308 WIN 150 gr.PSFCL
		27844	350	606	3.500		TARGET ROUND 308 WIN 180 gr.SPCL
		32895	220	580	1.000		Trigger Assembly
		26370	200	585	1.000		Trigger Guard Assy
							700 BDL LH - 30-06 SPRG
		301049	502	676	1.000		Cable Lock
		33494	47	400	1.000		Barrel Assembly
		28755	37	400	1.000		Bolt Assembly
		110254	87	427	1.000		Front Sight
		111320	107	427	1.000		Rear Sight Assembly
		28505	117	427	3.000		Sight Screw
		17013	120	580	1.000		Bolt Stop
25813							

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Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
		24475	160	580	1.000		Bolt Stop Pin
		90554	220	580	1.000		Bolt Stop Spring
		993002	330	676	1.000		Box & Envelope Label
		1444	10	676	1.000		Carton - RF-CF
		3509	20	676	1.000		Instruction Book
		17017	410	440	1.000		Ejector
		94555	420	440	1.000		Ejector Pin
		17019	430	440	1.000		Ejector Spring
		93712	400	435	1.000		Extractor
		305630	150	580	1.000		Firing Pin Assy
		104129	290	585	1.000		Front Guard Screw
		15363	50	660	1.000		Front Sight Hood
		16430	90	580	1.000		Magazine
		92219	230	585	1.000		Magazine Follower
		15677	80	585	1.000		Magazine Spring
		21717	340	600	1.100		*PROOF ROUND
		104126	300	585	1.000		*Rear Guard Screw
		17034	130	580	4.000		*Receiver Plug Screw
		24476	170	580	1.000		Sear Pin
		103604	280	585	1.000		Stock Assembly
		15358	40	593	2.000		Swivel Screw
		94241	240	593	2.000		Swivel Screw Spacer
		27826	505	606	2.000		TEST ROUND 30-06 SPRG 150 gr.PSPCL
		21407	360	606	3.500		TARGET ROUND 30-06 SPRG 180 gr.SPCL
		32895	210	580	1.000		Trigger Assembly
		26371	190	585	1.000		Trigger Guard Assy
25751							700 BDL LH - 338 Win Mag
		301049	502	676	1.000		Cable Lock
		33498	57	415	1.000		Barrel Assembly
		33307	47	415	1.000		Bolt Assembly
		110255	87	427	1.000		Front Sight
		111321	107	427	1.000		Rear Sight Assembly
		28505	117	427	3.000		Sight Screw
		17013	120	580	2.000		Bolt Stop
		24475	150	580	1.000		Bolt Stop Pin
		90554	210	580	1.000		Bolt Stop Spring
		993002	310	676	1.000		Box & Envelope Label
		1444	10	676	1.000		Carton - RF-CF
		3509	20	676	1.000		Instruction Book
		17017	410	440	1.000		Ejector
		94555	420	440	1.000		Ejector Pin
		17019	430	440	1.000		Ejector Spring
		97322	400	432	1.000		Extractor
		27341	440	432	1.000		Extractor Rivet
		305630	140	580	1.000		Firing Pin Assy

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Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
		104129	280	585	1.000		Front Guard Screw
		15363	60	660	1.000		Front Sight Hood
		16430	90	580	1.000		Magazine
		90952	220	585	1.000		Magazine Follower
		15677	80	585	1.000		Magazine Spring
		21790	320	600	1.150		PROOF ROUND
		104126	290	585	1.000		Rear Guard Screw
		17034	130	580	4.000		Receiver Plug Screw
		24476	160	580	1.000		Sear Pin
		113138	270	585	1.000		Stock Assembly
		15358	50	593	2.000		Swivel Screw
		94241	230	593	2.000		Swivel Screw Spacer
		22191	505	606	2.000		TEST ROUND 338 WIN MAG 250 gr.PSP
		22191	340	606	3.500		TARGET ROUND 338 WIN MAG 250 gr.PSP
		32895	200	580	1.000		Trigger Assembly
		26371	180	585	1.000		Trigger Guard Assy
26444							700 BDL - 270 WIN W/SCOPE
		301049	502	676	1.000		Cable Lock
		33454	47	400	1.000		Barrel Assembly
		28712	37	400	1.000		Bolt Assembly
		110254	87	427	1.000		Front Sight
		111320	107	427	1.000		Rear Sight Assembly
		28505	117	427	3.000		Sight Screw
		17013	130	580	1.000		Bolt Stop
		24475	170	580	1.000		Bolt Stop Pin
		15224	30	580	1.000		Bolt Stop Spring
		993002	330	676	1.000		Box & Envelope Label
		1651	10	680	1.000		CARTON ASSY
		3509	20	676	1.000		Instruction Book
		17017	410	440	1.000		Ejector
		94555	420	440	1.000		Ejector Pin
		17019	430	440	1.000		Ejector Spring
		93712	400	435	1.000		Extractor
		305630	160	580	2.000		Firing Pin Assy
		104129	290	585	1.000		Front Guard Screw
		15363	60	660	1.000		Front Sight Hood
		16430	100	580	1.000		Magazine
		92218	230	585	1.000		Magazine Follower
		15677	90	585	1.000		Magazine Spring
		21709	340	600	1.100		PROOF ROUND
		104126	300	585	1.000		Rear Guard Screw
		17034	140	580	4.000		Receiver Plug Screw
		24476	160	580	1.000		Sear Pin
		93617L	280	585	1.000		Stock Assembly
		15358	50	593	2.000		Swivel Screw

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Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
		94241	240	593	2.000		Swivel Screw Spacer
		27810	505	606	2.000		TEST ROUND 270 WIN 150 gr.SPCL
		27810	360	606	3.500		TARGET ROUND 270 WIN 150 gr.SPCL
		26345	190	580	1.000		Trigger Assembly
		26371	210	585	1.000		Trigger Guard Assy
		202173	510	613	1.000		LEUPOLD VX-1 GLOSS 3-9x40 SCOPE
		202182	520	428	1.000		LEUPOLD GLOSS BLACK 2 PIECE BASE
		202181	530	613	1.000		LEUPOLD GLOSS BLACK MEDIUM 1" RINGS
27301							700 BDL - 270 WSM W/SCOPE
		301049	502	676	1.000		Cable Lock
		245325	20	400	1.000		Barrel Assembly
		201903	30	400	1.000		Bolt Assembly
		17013	40	580	1.000		Bolt Stop
		24475	50	580	1.000		Bolt Stop Pin
		15224	60	580	1.000		Bolt Stop Spring
		993002	70	676	1.000		Box & Envelope Label
		1651	80	676	1.000		Carton - RF-CF
		3509	90	676	1.000		Instruction Book
		201843	100	440	1.000		Ejector
		94555	110	440	1.000		Ejector Pin
		201841	120	440	1.000		Ejector Spring
		97322	130	435	1.000		Extractor
		305634	140	580	1.000		Firing Pin Assy
		104127	150	585	1.000		Front Guard Screw
		110847	160	580	1.000		Magazine
		110855	170	585	1.000		Magazine Follower
		201849	180	585	1.000		Magazine Spring
		202720	190	600	1.100		PROOF ROUND
		104126	200	585	1.000		Rear Guard Screw
		17034	210	580	4.000		Receiver Plug Screw
		24476	220	580	1.000		Sear Pin
		113529	230	585	1.000		Stock Assembly
		28940	505	606	2.000		TEST ROUND 270 WSM OHL
		28940	250	606	3.500		TARGET ROUND 270 WSM OHL
		26345	260	580	1.000		Trigger Assembly
		94535	270	585	1.000		Trigger Guard Assy
		202421	280	676	1.000		LEUPOLD 3x9x40 MATTE SCOPE (#56160)
		202422	290	676	1.000		LEUPOLD SCOPE MOUNTS (#55890)
		202423	300	676	1.000		LEUPOLD VERTICAL SPLIT RINGS (#55850)
26446							700 BDL - 30-06 SPRG W/SCOPE
		301049	502	676	1.000		Cable Lock
		33455	47	400	1.000		Barrel Assembly
		28712	37	400	1.000		Bolt Assembly
		110254	87	427	1.000		Front Sight

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Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
		111320	107	427	1.000		Rear Sight Assembly
		28505	117	427	3.000		Sight Screw
		17013	130	580	1.000		Bolt Stop
		24475	170	580	1.000		Bolt Stop Pin
		15224	30	580	1.000		Bolt Stop Spring
		993002	330	676	1.000		Box & Envelope Label
		1651	10	680	1.000		CARTON ASSY
		3509	20	676	1.000		Instruction Book
		17017	410	440	1.000		Ejector
		94555	420	440	1.000		Ejector Pin
		17019	430	440	1.000		Ejector Spring
		93712	400	435	1.000		Extractor
		305630	160	580	1.000		Firing Pin Assy
		104129	290	585	1.000		Front Guard Screw
		15363	60	660	1.000		Front Sight Hood
		16430	100	580	1.000		Magazine
		92218	230	585	1.000		Magazine Follower
		15677	90	585	1.000		Magazine Spring
		21717	340	600	1.100		PROOF ROUND
		104126	300	585	1.000		Rear Guard Screw
		17034	140	580	4.000		Receiver Plug Screw
		24476	180	580	1.000		Sear Pin
		93617L	280	585	1.000		Stock Assembly
		15358	50	592	2.000		Swivel Screw
		94241	240	592	2.000		Swivel Screw Spacer
		27826	505	606	2.000		TEST ROUND 30-06 SPRG 150 gr.PSPCL
		21407	360	606	3.500		TARGET ROUND 30-06 SPRG 180 gr.SPCL
		26345	190	580	1.000		Trigger Assembly
		26371	210	585	1.000		Trigger Guard Assy
		202173	510	613	1.000		LEUPOLD VX-1 GLOSS 3-9x40 SCOPE
		202182	520	428	1.000		LEUPOLD GLOSS BLACK 2 PIECE BASE
		202181	530	613	1.000		LEUPOLD GLOSS BLACK MEDIUM 1" RINGS
27021							700 CDL - 204 RUGER - FRIENDS OF NRA
		301049	502	676	1.000		Cable Lock
		248021	17	415	1.000		Barrel Assembly
		99166	27	415	1.000		Bolt Assembly
		17013	20	580	1.000		Bolt Stop
		24475	30	580	1.000		Bolt Stop Pin
		15224	40	580	1.000		Bolt Stop Spring
		993002	50	676	1.000		Box & Envelope Label
		1444	70	676	1.000		Carton Assy
		3509	80	676	1.000		Instruction Book
		17017	100	440	1.000		Ejector
		94555	110	440	1.000		Ejector Pin
		17019	120	440	1.000		Ejector Spring

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Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
		97138	130	432	1.000		Extractor
		109580	150	580	1.000		Firing Pin Assy
		98880	350	585	1.000		Floor Plate Insert
		104127	160	585	1.000		Front Guard Screw
		106605	180	580	1.000		Magazine Assy
		92508	190	585	1.000		Magazine Follower
		91133	200	585	1.000		Magazine Spring
		202309	340	600	1.150		PROOF ROUND
		104126	220	585	1.000		Rear Guard Screw
		17034	230	580	4.000		Receiver Plug Screw
		24476	240	580	1.000		Sear Pin
		202265	250	585	1.000		Stock Assembly
		15358	260	593	2.000		Swivel Screw
		94241	270	593	2.000		Swivel Screw Spacer
		29218	505	606	2.000		Test Round 32 gr. ACCUTIP V
		29218	375	606	3.500		Target Round 32 gr. ACCUTIP V
		26345	290	580	1.000		Trigger Assembly
		202286	300	585	1.000		Trigger Guard Assy
27007							100 CDL - 243 WIN
		301049	502	676	1.000		Cable Lock
		248010	17	415	1.000		Barrel Assembly
		98079	27	415	1.000		Bolt Assembly
		17013	20	580	1.000		Bolt Stop
		24475	30	580	1.000		Bolt Stop Pin
		15224	40	580	1.000		Bolt Stop Spring
		993002	50	676	1.000		Box & Envelope Label
		1444	70	676	1.000		Carton Assy
		3509	80	676	1.000		Instruction Book
		17017	100	440	1.000		Ejector
		94555	110	440	1.000		Ejector Pin
		17019	120	440	1.000		Ejector Spring
		93712	130	432	1.000		Extractor
		305637	150	580	1.000		Firing Pin Assy
		104127	160	585	1.000		Front Guard Screw
		16715	180	580	1.000		Magazine
		90982	190	585	1.000		Magazine Follower
		15699	200	585	1.000		Magazine Spring
		21699	340	600	1.150		PROOF ROUND
		104126	220	585	1.000		Rear Guard Screw
		17034	230	580	4.000		Receiver Plug Screw
		24476	240	580	1.000		Sear Pin
		202265	250	585	1.000		Stock Assembly
		15358	260	593	2.000		Swivel Screw
		94241	270	593	2.000		Swivel Screw Spacer
		27802	505	606	2.000		TEST ROUND 243 WIN 100 gr.PSPCL

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Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
		27802	360	606	3.500		TARGET ROUND 243 WIN 100 gr.FSPCL
		26345	290	580	1.000		Trigger Assembly
		202286	300	585	1.000		Trigger Guard Assy
27009							700 CDL - 25-06 REM
		301049	502	676	1.000		Cable Lock
		248019	17	415	1.000		Barrel Assembly
		98080	27	415	1.000		Bolt Assembly
		17013	20	580	1.000		Bolt Stop
		24475	30	580	1.000		Bolt Stop Pin
		15224	40	580	1.000		Bolt Stop Spring
		993002	50	676	1.000		Box & Envelope Label
		1444	70	676	1.000		Carton Assy
		3509	80	676	1.000		Instruction Book
		17017	100	440	1.000		Ejector
		94555	110	440	1.000		Ejector Pin
		17019	120	440	1.000		Ejector Spring
		93712	130	432	1.000		Extractor
		305636	150	580	1.000		Firing Pin Assy
		104125	160	585	1.000		Front Guard Screw
		16430	180	580	1.000		Magazine
		92218	190	585	1.000		Magazine Follower
		15677	200	585	1.000		Magazine Spring
		21714	340	600	1.100		PROOF ROUND
		104126	220	585	1.000		Rear Guard Screw
		17034	230	580	4.000		Receiver Plug Screw
		24476	240	580	1.000		Sear Pin
		202266	250	585	1.000		Stock Assembly
		15358	260	593	2.000		Swivel Screw
		94241	270	593	2.000		Swivel Screw Spacer
		21515	503	606	2.000		TEST ROUND 25-06 REM 120 gr.FSPCL
		21515	360	606	3.500		TARGET ROUND 25-06 REM 120 gr.FSPCL
		26345	290	580	1.000		Trigger Assembly
		202284	300	585	1.000		Trigger Guard Assy
27015							700 CDL - 7MM-08 REM
		301049	502	676	1.000		Cable Lock
		248011	17	415	1.000		Barrel Assembly
		98079	27	415	1.000		Bolt Assembly
		17013	20	580	1.000		Bolt Stop
		24475	30	580	1.000		Bolt Stop Pin
		15224	40	580	1.000		Bolt Stop Spring
		993002	50	676	1.000		Box & Envelope Label
		1444	70	676	1.000		Carton Assy
		3509	80	676	1.000		Instruction Book
		17017	100	440	1.000		Ejector

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Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
		94555	110	440	1.000		Ejector Pin
		17019	120	440	1.000		Ejector Spring
		93712	130	432	1.000		Extractor
		305637	150	580	1.000		Firing Pin Assy
		104127	160	585	1.000		Front Guard Screw
		16715	180	580	1.000		Magazine
		90982	190	585	1.000		Magazine Follower
		15699	200	585	1.000		Magazine Spring
		21779	340	600	1.100		PROOF ROUND
		104126	220	585	1.000		Rear Guard Screw
		17034	230	580	4.000		Receiver Plug Screw
		24476	240	580	1.000		Sear Pin
		202265	250	585	1.000		Stock Assembly
		15358	260	593	2.000		Swivel Screw
		94241	270	593	2.000		Swivel Screw Spacer
		21337	505	606	2.000		TEST ROUND 7MM-08 REM 140 gr.PSP
		21337	350	606	8.000		TARGET ROUND 7MM-08 REM 140 gr.PSP
		26345	290	580	1.000		Trigger Assembly
		202286	300	585	1.000		Trigger Guard Assy
27011							700 CDL - 270 WIN
		301049	502	676	1.000		Cable Lock
		248012	17	415	1.000		Barrel Assembly
		98080	27	415	1.000		Bolt Assembly
		17013	20	580	1.000		Bolt Stop
		24475	30	580	1.000		Bolt Stop Pin
		15224	40	580	1.000		Bolt Stop Spring
		993002	50	676	1.000		Box & Envelope Label
		1444	70	676	1.000		Carton Assy
		3509	80	676	1.000		Instruction Book
		17017	100	440	1.000		Ejector
		94555	110	440	1.000		Ejector Pin
		17019	120	440	1.000		Ejector Spring
		93712	130	432	1.000		Extractor
		305636	150	580	1.000		Firing Pin Assy
		104125	160	585	1.000		Front Guard Screw
		16430	180	580	1.000		Magazine
		92218	190	585	1.000		Magazine Follower
		15677	200	585	1.000		Magazine Spring
		21779	340	600	1.100		PROOF ROUND
		104126	220	585	1.000		Rear Guard Screw
		17034	230	580	4.000		Receiver Plug Screw
		24476	240	580	1.000		Sear Pin
		202266	250	585	1.000		Stock Assembly
		15358	260	593	2.000		Swivel Screw
		94241	270	593	2.000		Swivel Screw Spacer

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Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
		993002	50	676	1.000		Box & Envelope Label
		1444	70	676	1.000		Carton Assy
		3509	80	676	1.000		Instruction Book
		17017	100	440	1.000		Ejector
		94555	110	440	1.000		Ejector Pin
		17019	120	440	1.000		Ejector Spring
		93712	130	432	1.000		Extractor
		305636	150	580	1.000		Firing Pin Assy
		104125	160	585	1.000		Front Guard Screw
		16430	180	580	1.000		Magazine
		92218	190	585	1.000		Magazine Follower
		15677	200	585	1.000		Magazine Spring
		21710	330	600	1.075		PROOF ROUND
		104126	220	585	1.000		Rear Guard Screw
		17034	230	580	4.000		Receiver Plug Screw
		24476	240	580	1.000		Sear Pin
		202266	250	585	1.000		Stock Assembly
		15358	260	593	2.000		Swivel Screw
		94241	270	593	2.000		Swivel Screw Spacer
		29069	505	606	2.000		LEAD ROUND 280 REM 150 gr.PSPCL
		29069	340	606	2.500		TARGET ROUND 280 REM 150 gr.PSPCL
		26345	290	580	1.000		Trigger Assembly
		202284	300	585	1.000		Trigger Guard Assy
27017							700 CDL - 30-06 SPRG
		301049	502	676	1.000		Cable Lock
		248013	17	415	1.000		Barrel Assembly
		98080	27	415	1.000		Bolt Assembly
		17013	20	580	1.000		Bolt Stop
		24475	30	580	1.000		Bolt Stop Pin
		15224	40	580	1.000		Bolt Stop Spring
		993002	50	676	1.000		Box & Envelope Label
		1444	70	676	1.000		Carton Assy
		3509	80	676	1.000		Instruction Book
		17017	100	440	1.000		Ejector
		94555	110	440	1.000		Ejector Pin
		17019	120	440	1.000		Ejector Spring
		93712	130	432	1.000		Extractor
		305636	150	580	1.000		Firing Pin Assy
		104125	160	585	1.000		Front Guard Screw
		16430	180	580	1.000		Magazine
		92218	190	585	1.000		Magazine Follower
		15677	200	585	1.000		Magazine Spring
		21710	340	600	1.100		PROOF ROUND
		104126	220	585	1.000		Rear Guard Screw
		17034	230	580	4.000		Receiver Plug Screw

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Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
		24476	240	580	1.000		Sear Pin
		202266	250	585	1.000		Stock Assembly
		15358	260	593	2.000		Swivel Screw
		94241	270	593	2.000		Swivel Screw Spacer
		27826	505	606	2.000		TEST ROUND 30-06 SPRG 150 gr.PSPCL
		21407	360	606	3.500		TARGET ROUND 20-06 SPRG 180 gr.SPCL
		26345	290	580	1.000		Trigger Assembly
		202284	300	585	1.000		Trigger Guard Assy
27023							700 CDL - 30-06 SPRG W/SIGHTS
		301049	502	676	1.000		Cable Lock
		248022	17	415	1.000		Barrel Assembly
		98080	27	415	1.000		Bolt Assembly
		17013	20	580	1.000		Bolt Stop
		24475	30	580	1.000		Bolt Stop Pin
		15224	40	580	1.000		Bolt Stop Spring
		993002	50	676	1.000		Box & Envelope Label
		1684	70	676	1.000		Carton Assy
		3509	80	676	1.000		Instruction Book
		17017	100	440	1.000		Ejector
		94555	110	440	1.000		Ejector Pin
		17019	120	440	1.000		Ejector Spring
		93712	130	432	1.000		Extractor
		305636	150	580	1.000		Firing Pin Assy
		104125	160	580	1.000		Front Guard Screw
		110254	87	427	1.000		Front Sight
		16430	180	580	1.000		Magazine
		92218	190	585	1.000		Magazine Follower
		15677	200	585	1.000		Magazine Spring
		21717	340	600	1.000		PROOF ROUND
		104126	220	585	1.000		Rear Guard Screw
		17034	230	580	4.000		Receiver Plug Screw
		111320	107	427	1.000		Rear Sight Assembly
		24476	240	580	1.000		Sear Pin
		28508	117	427	3.000		Sight Screw
		202266	250	585	1.000		Stock Assembly
		15358	260	593	2.000		Swivel Screw
		94241	270	593	2.000		Swivel Screw Spacer
		27826	505	606	2.000		TEST ROUND 30-06 SPRG 150 gr.PSPCL
		21407	360	606	3.500		TARGET ROUND 30-06 SPRG 180 gr.SPCL
		26345	290	580	1.000		Trigger Assembly
		202284	300	585	1.000		Trigger Guard Assy
27029							700 CDL - 30-06 SPRG W/SCOPE
		301049	502	676	1.000		Cable Lock
		248013	17	415	1.000		Barrel Assembly

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Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
		98080	27	415	1.000		Bolt Assembly
		17013	20	580	1.000		Bolt Stop
		24475	30	580	1.000		Bolt Stop Pin
		15224	40	580	1.000		Bolt Stop Spring
		993002	50	676	1.000		Box & Envelope Label
		1651	70	676	1.000		Carton Assy
		3509	80	676	1.000		Instruction Book
		17017	100	440	1.000		Ejector
		94555	110	440	1.000		Ejector Pin
		17019	120	440	1.000		Ejector Spring
		93712	130	432	1.000		Extractor
		305636	150	580	1.000		Firing Pin Assy
		104125	160	585	1.000		Front Guard Screw
		16430	180	580	1.000		Magazine
		92218	190	585	1.000		Magazine Follower
		15677	200	585	1.000		Magazine Spring
		21717	340	600	1.000		PROOF ROUND
		104126	220	585	1.000		Rear Guard Screw
		17034	230	580	1.000		Receiver Plug Screw
		24476	240	580	1.000		Sear Pin
		202266	250	585	1.000		Stock Assembly
		15358	260	593	1.000		Swivel Screw
		94241	270	593	2.000		Swivel Screw Spacer
		27826	505	600	2.000		TEST ROUND 30-06 SPRG 150 gr.PSPCL
		21407	360	580	3.500		TARGET ROUND 30-06 SPRG 180 gr.SPCL
		26345	290	580	1.000		Trigger Assembly
		202284	300	585	1.000		Trigger Guard Assy
		202012	480	425	1.000		LEUPOLD BASES - MATTE
		202612	490	613	1.000		LEUPOLD RINGS - MATTE
		202613	500	613	1.000		LEUPOLD VX-1 3-9x40 SCOPE - MATTE
27019							700 CDL - 35 WHELEN
		301049	502	676	1.000		Cable Lock
		248018	17	415	1.000		Barrel Assembly
		98080	27	415	1.000		Bolt Assembly
		17013	20	580	1.000		Bolt Stop
		24475	30	580	1.000		Bolt Stop Pin
		15224	40	580	1.000		Bolt Stop Spring
		993002	50	676	1.000		Box & Envelope Label
		1651	70	676	1.000		Carton Assy
		3509	80	676	1.000		Instruction Book
		17017	100	440	1.000		Ejector
		94555	110	440	1.000		Ejector Pin
		17019	120	440	1.000		Ejector Spring
		93712	130	432	1.000		Extractor
		305636	150	580	1.000		Firing Pin Assy

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Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
		104125	160	585	1.000		Front Guard Screw
		16430	180	580	1.000		Magazine
		92218	190	585	1.000		Magazine Follower
		15677	200	585	1.000		Magazine Spring
		21834	340	600	1.100		PROOF ROUND
		104126	220	585	1.000		Rear Guard Screw
		17034	230	580	4.000		Receiver Plug Screw
		24476	240	580	1.000		Sear Pin
		202266	250	585	1.000		Stock Assembly
		15358	260	593	2.000		Swivel Screw
		94241	270	593	2.000		Swivel Screw Spacer
		21495	505	606	2.000		TEST ROUND 35 WHELEN 200 gr.1PSP
		21499	360	606	3.500		TARGET ROUND 35 WHELEN 250 gr.PSP
		26345	290	580	1.000		Trigger Assembly
		202284	300	585	1.000		Trigger Guard Assy
27047							700 CCL - 7MM REM MAG
		301049	502	676	1.000		Cable Lock
		248014	17	415	1.000		Barrel Assembly
		98871	27	415	1.000		Bolt Assembly
		17013	20	580	1.000		Bolt Stop
		24475	30	580	1.000		Bolt Stop Pin
		15224	40	580	1.000		Bolt Stop Spring
		993002	50	676	1.000		Box & Envelope Label
		1687	70	676	1.000		Carton Assy
		3509	80	676	1.000		Instruction Book
		17017	100	440	1.000		Ejector
		94555	110	440	1.000		Ejector Pin
		17019	120	440	1.000		Ejector Spring
		97322	130	432	1.000		Extractor
		27341	140	432	1.000		Extractor Rivet
		305636	150	580	1.000		Firing Pin Assy
		104125	160	585	1.000		Front Guard Screw
		16430	180	580	1.000		Magazine
		90952	190	585	1.000		Magazine Follower
		15677	200	585	1.000		Magazine Spring
		21736	350	600	1.125		PROOF ROUND
		104126	220	585	1.000		Rear Guard Screw
		17034	230	580	4.000		Receiver Plug Screw
		24476	240	580	1.000		Sear Pin
		202267	250	585	1.000		Stock Assembly
		15358	260	593	2.000		Swivel Screw
		94241	270	593	2.000		Swivel Screw Spacer
		27814	505	606	2.000		TEST ROUND 7MM REM MAG 175 gr.PSPCL
		27814	370	606	3.500		TARGET ROUND 7MM REM MAG 175 gr.PSPCL
		26345	290	580	1.000		Trigger Assembly

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Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
		17019	430	440	1.000		Ejector Spring
		93712	400	435	1.000		Extractor
		110455	160	580	1.000		Firing Pin Assy
		98080	350	585	1.000		Floor Plate Insert
		104127	310	585	1.000		Front Guard Screw
		106605	120	580	1.000		Magazine Assy
		92508	230	585	1.000		Magazine Follower
		91133	240	585	1.000		Magazine Spring
		21774	360	600	1.100		PROOF ROUND
		104126	300	585	1.000		Rear Guard Screw
		17034	140	580	4.000		Receiver Plug Screw
		24476	180	580	1.000		Sear Pin
		113500	290	585	1.000		Stock Assembly
		15358	60	593	2.000		Swivel Screw
		94241	250	593	2.000		Swivel Screw Spacer
		28399	505	606	2.000		TEST ROUND 223 REM 55 gr.PSP
		28399	370	606	3.500		TARGET ROUND 223 REM 55 gr.PSP
		32895	190	580	1.000		Trigger Assembly
		202286	210	585	1.000		Trigger Guard Assy
27103							700 CDL - 243 WIN - LH
		301049	502	676	1.000		Cable Lock
		113431	17	415	1.000		Barrel Assembly
		113356	27	415	1.000		Bolt Assembly
		17013	20	580	1.000		Bolt Stop
		24475	30	580	1.000		Bolt Stop Pin
		90554	40	580	1.000		Bolt Stop Spring
		993002	50	676	1.000		Box & Envelope Label
		1444	70	676	1.000		Carton Assy
		3509	80	676	1.000		Instruction Book
		17017	100	440	1.000		Ejector
		94555	110	440	1.000		Ejector Pin
		17019	120	440	1.000		Ejector Spring
		93712	130	432	1.000		Extractor
		110455	150	580	1.000		Firing Pin Assy
		104127	160	585	1.000		Front Guard Screw
		16715	180	580	1.000		Magazine
		90982	190	585	1.000		Magazine Follower
		15699	200	585	1.000		Magazine Spring
		21774	340	600	1.150		PROOF ROUND
		104126	220	585	1.000		Rear Guard Screw
		17034	230	580	4.000		Receiver Plug Screw
		24476	240	580	1.000		Sear Pin
		113500	250	585	1.000		Stock Assembly
		15358	260	593	2.000		Swivel Screw
		94241	270	593	2.000		Swivel Screw Spacer

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Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
		27802	505	606	2.000		TEST ROUND 243 WIN 100 gr.PSFCL
		21319	360	606	3.500		TARGET ROUND 243 WIN 80 gr.TARGET
		32895	290	580	1.000		Trigger Assembly
		202286	300	585	1.000		Trigger Guard Assy
27105							700 CDL - 270 WIN - LH
		301049	502	676	1.000		Cable Lock
		113432	17	415	1.000		Barrel Assembly
		105484	27	415	1.000		Bolt Assembly
		17013	20	580	1.000		Bolt Stop
		24475	30	580	1.000		Bolt Stop Pin
		90554	40	580	1.000		Bolt Stop Spring
		993002	50	676	1.000		Box & Envelope Label
		1444	70	676	1.000		Carton Assy
		3509	80	676	1.000		Instruction Book
		17017	100	440	1.000		Ejector
		94555	110	440	1.000		Ejector Pin
		17019	120	440	1.000		Ejector Spring
		93712	130	432	1.000		Extractor
		110454	150	580	1.000		Firing Pin Assy
		104125	160	585	1.000		Front Guard Screw
		16430	180	580	1.000		Magazine
		92218	190	585	1.000		Magazine Follower
		15677	200	585	1.000		Magazine Spring
		21709	340	580	1.100		PROOF ROUND
		104126	220	585	1.000		Rear Guard Screw
		17034	230	580	4.000		Receiver Plug Screw
		24476	240	580	1.000		Sear Pin
		113501	250	585	1.000		Stock Assembly
		15358	260	593	2.000		Swivel Screw
		94241	270	593	2.000		Swivel Screw Spacer
		27810	505	606	2.000		TEST ROUND 270 WIN 150 gr.SPCL
		27810	360	606	3.500		TARGET ROUND 270 WIN 150 gr.SPCL
		32895	290	580	1.000		Trigger Assembly
		202286	300	585	1.000		Trigger Guard Assy
27107							700 CDL - 30-06 SPRG - LH
		301049	502	676	1.000		Cable Lock
		113432	17	415	1.000		Barrel Assembly
		105484	27	415	1.000		Bolt Assembly
		17013	20	580	1.000		Bolt Stop
		24475	30	580	1.000		Bolt Stop Pin
		90554	40	580	1.000		Bolt Stop Spring
		993002	50	676	1.000		Box & Envelope Label
		1444	70	676	1.000		Carton Assy
		3509	80	676	1.000		Instruction Book

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Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
		17017	100	440	1.000		Ejector
		94555	110	440	1.000		Ejector Pin
		17019	120	440	1.000		Ejector Spring
		93712	130	432	1.000		Extractor
		110454	150	580	1.000		Firing Pin Assy
		104125	160	585	1.000		Front Guard Screw
		16430	180	580	1.000		Magazine
		92218	190	585	1.000		Magazine Follower
		15677	200	585	1.000		Magazine Spring
		21717	340	600	1.100		PROOF ROUND
		104126	220	585	1.000		Rear Guard Screw
		17034	230	580	4.000		Receiver Plug Screw
		24476	240	580	1.000		Sear Pin
		113501	250	585	1.000		Stock Assembly
		15358	260	593	2.000		Swivel Screw
		94241	270	593	2.000		Swivel Screw Spacer
		27826	350	606	1.600		TEST ROUND 30-06 SPRG 150 PSPCL
		21407	360	606	1.375		TEST ROUND 30-06 SPRG 180 SPCL
		32895	290	580	1.000		Trigger Assembly
		202284	300	585	1.000		Trigger Guard Assy
27109							700 CDL - 7MM REM MAG - LH
		301049	502	676	1.000		Cable Lock
		113434	17	415	1.000		Barrel Assembly
		113480	27	415	1.000		Bolt Assembly
		17013	20	580	1.000		Bolt Stop
		24475	30	580	1.000		Bolt Stop Pin
		90554	40	580	1.000		Bolt Stop Spring
		993002	50	676	1.000		Box & Envelope Label
		1499	70	676	1.000		Carton Assy
		3509	80	676	1.000		Instruction Book
		201843	100	440	1.000		Ejector
		94555	110	440	1.000		Ejector Pin
		201841	120	440	1.000		Ejector Spring
		97322	130	432	1.000		Extractor
		27341	140	432	1.000		Extractor Rivet
		110454	150	580	1.000		Firing Pin Assy
		104125	160	585	1.000		Front Guard Screw
		16430	180	580	1.000		Magazine
		90952	190	585	1.000		Magazine Follower
		15677	200	585	1.000		Magazine Spring
		21736	350	600	1.125		PROOF ROUND
		104126	220	585	1.000		Rear Guard Screw
		17034	230	580	4.000		Receiver Plug Screw
		24476	240	580	1.000		Sear Pin
		113502	250	585	1.000		Stock Assembly

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Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
		3509	20	676	1.000		Instruction Book
		17017	410	440	1.000		Ejector
		94555	420	440	1.000		Ejector Pin
		17019	430	440	1.000		Ejector Spring
		97138	400	435	1.000		Extractor
		305634	160	580	1.000		Firing Pin Assy
		98880	350	585	1.000		Floor Plate Insert
		104127	310	585	1.000		Front Guard Screw
		106605	120	580	1.000		Magazine Assy
		92508	230	585	1.000		Magazine Follower
		91133	240	585	1.000		Magazine Spring
		21774	360	600	1.100		PROOF ROUND
		104126	300	585	1.000		Rear Guard Screw
		17034	140	580	4.000		Receiver Plug Screw
		24476	180	580	1.000		Sear Pin
		113527	290	585	1.000		Stock Assembly
		94996	60	593	2.000		Swivel Screw
		28399	505	606	2.000		TEST ROUND 223 REM 55 gr.PSP
		28399	370	606	3.500		TARGET ROUND 223 REM 55 PSP
		26345	190	580	1.000		Trigger Assembly
		94535	210	585	1.000		Trigger Guard Assy
		301049	502	676	1.000		Cable Lock
27353							700 SPS S/A - 22-250 REM
		244915	47	485	1.000		Barrel Assembly
		94098	37	405	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	330	676	1.000		Box & Envelope Label
		1687	10	676	1.000		Carton - RF-CF
		3509	20	676	1.000		Instruction Book
		17017	410	440	1.000		Ejector
		94555	420	440	1.000		Ejector Pin
		17019	430	440	1.000		Ejector Spring
		93712	400	435	1.000		Extractor
		305634	160	580	1.000		Firing Pin Assy
		104127	310	585	1.000		Front Guard Screw
		16715	120	580	1.000		Magazine
		92455	230	585	1.000		Magazine Follower
		15699	90	585	1.000		Magazine Spring
		21893	340	600	1.100		PROOF ROUND
		104126	290	585	1.000		Rear Guard Screw
		17034	140	580	4.000		Receiver Plug Screw
		24476	180	580	1.000		Sear Pin
		113527	280	585	1.000		Stock Assembly

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Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
		94996	50	593	2.000		Swivel Screw
		21313	505	606	2.000		TEST ROUND 22-250 REM 55 gr.HPPL
		21313	350	606	3.500		TARGET ROUND 22-250 REM 55 gr.HPPL
		26345	190	580	1.000		Trigger Assembly
		94535	210	585	1.000		Trigger Guard Assy
		301049	502	676	1.000		Cable Lock
27355							700 SPS S/A - 243 WIN
		244917	47	405	1.000		Barrel Assembly
		94098	37	405	1.000		Bolt Assembly
		17013	120	580	1.000		Bolt Stop
		24475	160	580	1.000		Bolt Stop Pin
		15224	30	580	1.000		Bolt Stop Spring
		993002	330	676	1.000		Box & Envelope Label
		1444	10	676	1.000		Carton - RF-CF
		3509	20	676	1.000		Instruction Book
		17017	410	440	1.000		Ejector
		94555	420	440	1.000		Ejector Pin
		17019	430	440	1.000		Ejector Spring
		93712	400	435	1.000		Extractor
		305634	150	580	1.000		Firing Pin Assy
		104127	290	585	1.000		Front Guard Screw
		16715	110	580	1.000		Magazine
		92455	220	585	1.000		Magazine Follower
		15699	140	585	1.000		Magazine Spring
		21699	340	600	1.190		PROOF ROUND
		104126	280	585	1.000		Rear Guard Screw
		17034	130	580	4.000		Receiver Plug Screw
		24476	170	580	1.000		Sear Pin
		113527	270	585	1.000		Stock Assembly
		94996	50	593	2.000		Swivel Screw
		27802	505	606	2.000		TEST ROUND 243 WIN 100 gr.PSPCL
		21319	360	606	3.500		TARGET ROUND 243 WIN 80 gr.TARGET
		26345	180	580	1.000		Trigger Assembly
		94535	200	585	1.000		Trigger Guard Assy
		301049	502	676	1.000		Cable Lock
27357							700 SPS S/A - 7MM-08 REM
		244917	37	400	1.000		Barrel Assembly
		94098	47	400	1.000		Bolt Assembly
		17013	120	580	1.000		Bolt Stop
		24475	170	580	1.000		Bolt Stop Pin
		15224	30	580	1.000		Bolt Stop Spring
		993002	330	676	1.000		Box & Envelope Label
		1444	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
		17017	410	440	1.000		Ejector
		94555	420	440	1.000		Ejector Pin
		17019	430	440	1.000		Ejector Spring
		93712	400	435	1.000		Extractor
		305634	160	580	1.000		Firing Pin Assy
		104127	300	585	1.000		Front Guard Screw
		16715	110	580	1.000		Magazine
		92455	230	585	1.000		Magazine Follower
		15699	140	585	1.000		Magazine Spring
		21779	340	600	1.100		PROOF ROUND
		104126	290	585	1.000		Rear Guard Screw
		17034	130	580	4.000		Receiver Plug Screw
		24476	180	580	1.000		Sear Pin
		113527	280	585	1.000		Stock Assembly
		94996	50	593	2.000		Swivel Screw
		21337	505	606	2.000		TEST ROUND 7MM-08 REM 140 gr.PSP
		21337	350	606	3.500		TARGET ROUND 7MM-08 REM 140 gr.PSP
		26345	190	580	1.000		Trigger Assembly
		94535	210	585	1.000		Trigger Guard Assy
		301049	502	676	1.000		Cable Lock
27359							700 SPS S/A - 308 WIN
		244918	47	400	1.000		Barrel Assembly
		94098	37	400	1.000		Bolt Assembly
		17013	120	580	1.000		Bolt Stop
		24475	170	580	1.000		Bolt Stop Pin
		15224	30	580	1.000		Bolt Stop Spring
		993002	330	676	1.000		Box & Envelope Label
		1444	10	676	1.000		Carton - RF-CF
		3509	20	676	1.000		Instruction Book
		17017	410	440	1.000		Ejector
		94555	420	440	1.000		Ejector Pin
		17019	430	440	1.000		Ejector Spring
		93712	400	435	1.000		Extractor
		305634	160	580	1.000		Firing Pin Assy
		104127	300	585	1.000		Front Guard Screw
		16715	110	580	1.000		Magazine
		92455	230	585	1.000		Magazine Follower
		15699	140	585	1.000		Magazine Spring
		21779	340	600	1.175		PROOF ROUND
		104126	290	585	1.000		Rear Guard Screw
		17034	130	580	4.000		Receiver Plug Screw
		24476	180	580	1.000		Sear Pin
		113527	280	585	1.000		Stock Assembly
		94996	50	593	2.000		Swivel Screw
		27842	350	606	1.750		TEST ROUND 308 WIN 150 PSPCL

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Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
		27844	360	606	1.750		TEST ROUND 308 WIN 180 SPCL
		26345	190	580	1.000		Trigger Assembly
		94535	210	585	1.000		Trigger Guard Assy
		301049	502	676	1.000		Cable Lock
27475							700 SPS S/A YTH - 243 WIN
		244922	47	405	1.000		Barrel Assembly
		94098	37	405	1.000		Bolt Assembly
		17013	120	580	1.000		Bolt Stop
		24475	160	580	1.000		Bolt Stop Pin
		15224	30	580	1.000		Bolt Stop Spring
		993002	330	676	1.000		Box & Envelope Label
		1444	10	676	1.000		Carton - RF-CF
		3509	20	676	1.000		Instruction Book
		17017	410	440	1.000		Ejector
		94555	420	440	1.000		Ejector Pin
		17019	430	440	1.000		Ejector Spring
		93712	400	435	1.000		Extractor
		305634	150	580	1.000		Firing Pin Assy
		104127	290	585	1.000		Front Guard Screw
		16715	110	580	1.000		Magazine
		92455	220	585	1.000		Magazine Follower
		15699	140	585	1.000		Magazine Spring
		21699	340	600	1.190		PROOF ROUND
		104126	280	585	1.000		Rear Guard Screw
		17034	130	580	1.000		Receiver Plug Screw
		24476	170	580	1.000		Sear Pin
		113525	270	585	1.000		Stock Assembly
		94996	50	593	2.000		Swivel Screw
		27802	505	606	2.000		TEST ROUND 243 WIN 100 gr.PSPCL
		21319	360	606	3.500		TARGET ROUND 243 WIN 80 gr.TARGET
		26345	190	580	1.000		Trigger Assembly
		94535	210	585	1.000		Trigger Guard Assy
		301049	502	676	1.000		Cable Lock
27477							700 SPS S/A YTH - 308 WIN
		244923	47	405	1.000		Barrel Assembly
		94098	37	405	1.000		Bolt Assembly
		17013	120	580	1.000		Bolt Stop
		24475	160	580	1.000		Bolt Stop Pin
		15224	30	580	1.000		Bolt Stop Spring
		993002	330	676	1.000		Box & Envelope Label
		1444	10	676	1.000		Carton - RF-CF
		3509	20	676	1.000		Instruction Book
		17017	410	440	1.000		Ejector
		94555	420	440	1.000		Ejector Pin

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Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
		17019	430	440	1.000		Ejector Spring
		93712	400	435	1.000		Extractor
		305634	160	580	1.000		Firing Pin Assy
		104127	300	585	1.000		Front Guard Screw
		16715	110	580	1.000		Magazine
		92455	230	585	1.000		Magazine Follower
		15699	140	585	1.000		Magazine Spring
		21723	340	600	1.175		PROOF ROUND
		104126	290	585	1.000		Rear Guard Screw
		17034	130	580	4.000		Receiver Plug Screw
		24476	180	580	1.000		Sear Pin
		113525	280	585	1.000		Stock Assembly
		94996	50	593	2.000		Swivel Screw
		27842	505	606	2.000		TEST ROUND 308 WIN 150 gr.PSPCL
		27844	360	606	3.500		TARGET ROUND 308 WIN 180 gr.SPCL
		26345	190	580	1.000		Trigger Assembly
		94535	210	585	1.000		Trigger Guard Assy
		301049	502	676	1.000		Cable Lock
27299							700 SPS L/A - 25-06 REM
		244929	47	400	1.000		Barrel Assembly
		94097	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	330	676	1.000		Box & Envelope Label
		1684	10	676	1.000		Carton - RF-CF
		3509	20	676	1.000		Instruction Book
		17017	410	440	1.000		Ejector
		94555	420	440	1.000		Ejector Pin
		17019	430	440	1.000		Ejector Spring
		93712	400	435	1.000		Extractor
		305633	160	580	1.000		Firing Pin Assy
		104129	290	585	1.000		Front Guard Screw
		16430	100	580	1.000		Magazine
		92492	230	585	1.000		Magazine Follower
		15677	90	585	1.000		Magazine Spring
		21714	340	600	1.100		PROOF ROUND
		104126	300	585	1.000		Rear Guard Screw
		17034	140	580	4.000		Receiver Plug Screw
		24476	180	580	1.000		Sear Pin
		113528	280	585	1.000		Stock Assembly
		21515	505	606	2.000		TEST ROUND 25-06 REM 120 gr.PSPCL
		21515	360	606	3.500		TARGET ROUND 25-06 REM 120 gr.PSPCL
		26345	190	580	1.000		Trigger Assembly
		94089	210	585	1.000		Trigger Guard Assy

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Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
		16430	100	580	1.000		Magazine
		92492	230	585	1.000		Magazine Follower
		15677	90	585	1.000		Magazine Spring
		21717	340	600	1.100		PROOF ROUND
		104126	300	585	1.000		Rear Guard Screw
		17034	140	580	4.000		Receiver Plug Screw
		24476	180	580	1.000		Sear Pin
		113528	280	585	1.000		Stock Assembly
		27826	505	606	2.000		TEST ROUND 30-06 SPRG 150 gr.SPCL
		21407	360	606	3.500		TARGET ROUND 30-06 SPRG 180 gr.SPCL
		26345	190	580	1.000		Trigger Assembly
		94089	210	585	1.000		Trigger Guard Assy
		301049	502	676	1.000		Cable Lock
27479							700 SPS L/A YTH - 270 WIN
		244925	47	400	1.000		Barrel Assembly
		94097	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	330	676	1.000		Box & Envelope Label
		1444	10	676	1.000		Carton - RF-CF
		3509	20	676	1.000		Instruction Book
		17017	410	440	1.000		Ejector
		94555	420	440	1.000		Ejector Pin
		17019	430	440	1.000		Ejector Spring
		93712	400	435	1.000		Extractor
		305633	160	580	1.000		Firing Pin Assy
		104129	290	585	1.000		Front Guard Screw
		16430	100	580	1.000		Magazine
		92492	230	585	1.000		Magazine Follower
		15677	90	585	1.000		Magazine Spring
		21709	340	600	1.100		PROOF ROUND
		104126	300	585	1.000		Rear Guard Screw
		17034	140	580	4.000		Receiver Plug Screw
		24476	180	580	1.000		Sear Pin
		113526	280	585	1.000		Stock Assembly
		94996	50	593	2.000		Swivel Screw
		27810	505	606	2.000		TEST ROUNDS 270 WIN 150 gr.SPCL
		27810	360	606	3.500		TARGET ROUNDS 270 WIN 150 gr.SPCL
		26345	190	580	1.000		Trigger Assembly
		94089	210	585	1.000		Trigger Guard Assy
		301049	502	676	1.000		Cable Lock
27481							700 SPS L/A YTH - 30-06 SPRG
		244926	47	400	1.000		Barrel Assembly

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Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
		94097	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	330	676	1.000		Box & Envelope Label
		1444	10	676	1.000		Carton - RF-CF
		3509	20	676	1.000		Instruction Book
		17017	410	440	1.000		Ejector
		94555	420	440	1.000		Ejector Pin
		17019	430	440	1.000		Ejector Spring
		93712	400	435	1.000		Extractor
		305633	160	580	1.000		Firing Pin Assy
		104129	290	585	1.000		Front Guard Screw
		16430	100	580	1.000		Magazine
		92492	230	585	1.000		Magazine Follower
		15677	90	585	1.000		Magazine Spring
		21717	340	600	1.000		PROOF ROUND
		104126	300	585	1.000		Rear Guard Screw
		17034	140	580	1.000		Receiver Plug Screw
		24476	180	580	1.000		Rear Pin
		113526	280	585	1.000		Stack Assembly
		94996	50	593	2.000		Swivel Screw
		27826	505	606	2.000		TEST ROUND 30-06 SPRG 150 gr.PSPCL
		21407	360	606	3.500		TARGET ROUND 30-06 SPRG 180 gr.SPCL
		26345	190	580	1.000		Trigger Assembly
		94089	210	585	1.000		Trigger Guard Assy
		301049	502	676	1.000		Cable Lock
27331							700 SPS S/A MAG - 270 WSM
		245325	47	400	1.000		Barrel Assembly
		201903	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	330	676	1.000		Box & Envelope Label
		1444	10	676	1.000		Carton - RF-CF
		3509	20	676	1.000		Instruction Book
		201843	410	440	1.000		Ejector
		94555	420	440	1.000		Ejector Pin
		201841	430	440	1.000		Ejector Spring
		97322	400	435	1.000		Extractor
		27341	440	432	1.000		Extractor Rivet
		305634	160	580	1.000		Firing Pin Assy
		104127	290	585	1.000		Front Guard Screw
		110847	100	580	1.000		Magazine
		110855	230	585	1.000		Magazine Follower

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Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
		201849	90	585	1.000		Magazine Spring
		202720	340	600	1.100		PROOF ROUND
		104126	300	585	1.000		Rear Guard Screw
		17034	140	580	4.000		Receiver Plug Screw
		24476	180	580	1.000		Sear Pin
		113529	280	585	1.000		Stock Assembly
		94996	50	593	2.000		Swivel Screw
		28940	505	606	2.000		TEST ROUND 270 WSM OHL
		28940	360	606	3.500		TARGET ROUND 270 WSM OHL
		26345	190	580	1.000		Trigger Assembly
		94535	210	585	1.000		Trigger Guard Assy
		301049	502	676	1.000		Cable Lock
27333							700 SPS S/A MAG - 300 WSM
		245333	47	400	1.000		Barrel Assembly
		201903	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	330	676	1.000		Box & Envelope Label
		1444	10	676	1.000		Carton - RF-CF
		3509	20	676	1.000		Instruction Book
		201843	410	440	1.000		Ejector
		94555	420	440	1.000		Ejector Pin
		201841	430	440	1.000		Ejector Spring
		97322	400	435	1.000		Extractor
		27341	440	432	1.000		Extractor Rivet
		305634	160	580	1.000		Firing Pin Assy
		104127	290	585	1.000		Front Guard Screw
		110847	100	580	1.000		Magazine
		110855	230	585	1.000		Magazine Follower
		201849	90	585	1.000		Magazine Spring
		114200	340	600	1.100		PROOF ROUND -DP300WSM 180GR WIN. POWER PT
		104126	300	585	1.000		Rear Guard Screw
		17034	140	580	4.000		Receiver Plug Screw
		24476	180	580	1.000		Sear Pin
		113529	280	585	1.000		Stock Assembly
		114220	505	606	2.000		TEST ROUND -X300WSM 180 gr.WIN. POWER PT
		114220	360	606	3.500		TEST ROUND -X300WSM 180 gr.WIN. POWER PT
		26345	190	580	1.000		Trigger Assembly
		94535	210	585	1.000		Trigger Guard Assy
		301049	502	676	1.000		Cable Lock
27385							700 SPS L/A MAG - 7MM REM MAG
		245329	67	415	1.000		Barrel Assembly
		94100	57	415	1.000		Bolt Assembly

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Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
		17013	130	580	1.000		Bolt Stop
		24475	170	580	1.000		Bolt Stop Pin
		15224	40	580	1.000		Bolt Stop Spring
		993002	330	676	1.000		Box & Envelope Label
		1444	10	676	1.000		Carton - RF-CF
		3509	20	676	1.000		Instruction Book
		17017	410	440	1.000		Ejector
		94555	420	440	1.000		Ejector Pin
		17019	430	440	1.000		Ejector Spring
		97322	400	432	1.000		Extractor
		27341	440	432	1.000		Extractor Rivet
		305633	160	580	1.000		Firing Pin Assy
		104129	290	585	1.000		Front Guard Screw
		16430	100	580	1.000		Magazine
		92492	230	585	1.000		Magazine Follower
		15677	90	585	1.000		Magazine Spring
		21736	340	600	1.150		PROOF ROUND
		104126	300	585	1.000		Rear Guard Screw
		17034	140	580	1.000		Receiver Plug Screw
		24476	180	580	1.000		Rear Pin
		113530	280	585	1.000		Stack Assembly
		94996	60	593	2.000		Swivel Screw
		27814	505	606	2.000		TEST ROUND 7MM REM MAG 175 gr.PSPCL
		27814	360	606	3.500		TARGET ROUND 7MM REM MAG 175 gr.PSPCL
		26345	190	580	1.000		Trigger Assembly
		94089	210	585	1.000		Trigger Guard Assy
		301049	502	676	1.000		Cable Lock
27387							700 SPS L/A MAG - 300 WIN MAG
		245330	57	415	1.000		Barrel Assembly
		94100	47	415	1.000		Bolt Assembly
		17013	130	580	1.000		Bolt Stop
		24475	170	580	1.000		Bolt Stop Pin
		15224	40	580	1.000		Bolt Stop Spring
		993002	330	676	1.000		Box & Envelope Label
		1687	10	676	1.000		Carton - RF-CF
		3509	20	676	1.000		Instruction Book
		17017	410	440	1.000		Ejector
		94555	420	440	1.000		Ejector Pin
		17019	430	440	1.000		Ejector Spring
		97322	400	432	1.000		Extractor
		27341	440	432	1.000		Extractor Rivet
		305633	160	580	1.000		Firing Pin Assy
		104129	290	585	1.000		Front Guard Screw
		16430	100	580	1.000		Magazine
		92492	230	585	1.000		Magazine Follower

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Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
		15677	90	585	1.000		Magazine Spring
		21846	340	600	1.100		PROOF ROUND
		104126	300	585	1.000		Rear Guard Screw
		17034	140	580	4.000		Receiver Plug Screw
		24476	180	580	1.000		Sear Pin
		113530	280	585	1.000		Stock Assembly
		94996	60	593	2.000		Swivel Screw
		29497	505	606	2.000		TEST ROUND 300 WIN MAG 180 gr.PSPCL
		29497	360	606	3.500		TARGET ROUND 300 WIN MAG 180 gr.PSPCL
		26345	190	580	1.000		Trigger Assembly
		94089	210	585	1.000		Trigger Guard Assy
		301049	502	676	1.000		Cable Lock
27375							700 SPS L/A - 270 WIN W/SCOPE
		244920	47	400	1.000		Barrel Assembly
		94097	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	330	676	1.000		Box & Envelope Label
		1684	10	676	1.000		Carton - RF-CF
		3509	20	676	1.000		Instruction Book
		17017	410	440	1.000		Ejector
		94555	420	440	1.000		Ejector Pin
		17019	430	440	1.000		Ejector Spring
		93712	400	435	1.000		Extractor
		305633	160	580	1.000		Firing Pin Assy
		104129	290	585	1.000		Front Guard Screw
		16430	100	580	1.000		Magazine
		92492	230	585	1.000		Magazine Follower
		15677	90	585	1.000		Magazine Spring
		21709	340	600	1.100		PROOF ROUND
		104126	300	585	1.000		Rear Guard Screw
		17034	140	580	4.000		Receiver Plug Screw
		24476	180	580	1.000		Sear Pin
		113526	280	585	1.000		Stock Assembly
		27810	505	606	2.000		TEST ROUND 270 WIN 150 gr.SPCL
		27810	360	606	3.500		TARGET ROUND 270 WIN 150 gr.SPCL
		26345	190	580	1.000		Trigger Assembly
		94089	210	585	1.000		Trigger Guard Assy
		301049	502	676	1.000		Cable Lock
		202172	510	613	1.000		RED HEAD SCOPE 3-9x40
		200291	457	676	1.000		Scope Base w/screws & allen wrench
		200292	458	676	1.000		Scope Rings w/screws & allen wrench
27377							700 SPS L/A - 30-06 SPRG W/SCOPE

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Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
		244921	47	400	1.000		Barrel Assembly
		94097	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	330	676	1.000		Box & Envelope Label
		1684	10	676	1.000		Carton - RF-CF
		3509	20	676	1.000		Instruction Book
		17017	410	440	1.000		Ejector
		94555	420	440	1.000		Ejector Pin
		17019	430	440	1.000		Ejector Spring
		93712	400	435	1.000		Extractor
		305633	160	580	1.000		Firing Pin Assy
		104129	290	585	1.000		Front Guard Screw
		16430	100	580	1.000		Magazine
		92492	230	585	1.000		Magazine Follower
		15677	90	585	1.000		Magazine Spring
		21717	340	600	1.000		PROOF ROUND
		104126	300	585	1.000		Rear Guard Screw
		17034	140	580	3.500		Receiver Plug Screw
		24476	180	580	1.000		Sear Pin
		113528	280	585	1.000		Stock Assembly
		27826	505	600	2.000		TEST ROUND 30-06 SPRG 150 gr.PSPCL
		21407	360	600	3.500		TARGET ROUND 30-06 SPRG 180 gr.SPCL
		26345	190	580	1.000		Trigger Assembly
		94089	210	585	1.000		Trigger Guard Assy
		301049	502	676	1.000		Cable Lock
		202172	510	633	1.000		RED HEAD SCOPE 3-9x40
		200291	457	676	1.000		Scope Base w/screws & allen wrench
		200292	458	676	1.000		Scope Rings w/screws & allen wrench
27379							700 SPS S/A MAG - 300 WSM W/SCOPE
		245333	47	400	1.000		Barrel Assembly
		201903	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	330	676	1.000		Box & Envelope Label
		1684	10	676	1.000		Carton - RF-CF
		3509	20	676	1.000		Instruction Book
		17017	410	440	1.000		Ejector
		94555	420	440	1.000		Ejector Pin
		17019	430	440	1.000		Ejector Spring
		97322	400	435	1.000		Extractor
		27341	440	432	1.000		Extractor Rivet
		305634	160	580	1.000		Firing Pin Assy

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Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
		104127	290	585	1.000		Front Guard Screw
		110847	100	580	1.000		Magazine
		110855	230	585	1.000		Magazine Follower
		201049	90	585	1.000		Magazine Spring
		114200	340	600	1.100		PROOF ROUND -DP300WSM 180GR WIN. POWER PT
		104126	300	585	1.000		Rear Guard Screw
		17034	140	580	4.000		Receiver Plug Screw
		24476	180	580	1.000		Sear Pin
		113529	280	585	1.000		Stock Assembly
		114220	505	606	2.000		TEST ROUND -X300WSM 180 gr.WIN. POWER PT
		114220	360	606	3.500		TARGET ROUND-X300WSM 180 gr.WIN. POWER PT
		26345	190	580	1.000		Trigger Assembly
		94535	210	585	1.000		Trigger Guard Assy
		301049	502	676	1.000		Cable Lock
		202172	510	613	1.000		RED HEAD SCOPE 3-9x40
		200291	457	676	1.000		Scope Base w/screws & allen wrench
		200292	458	676	1.000		Scope Rings w/screws & allen wrench

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Date:	Reason for Revision:	Eng:	Log #:
24-Apr-01	Copied entire process from VAXcamps #304175 Stock Assy 200559 was 103605	RLJ	304220
25-Jul-01	Added pallet D-51267 to Op 676.	RLJ	304887
24-Aug-01	4.5 to 5.5 lb trigger pull was 4 to 5 pounds.	RLJ	305059
7-Sep-01	Added muzzle re-chamfering instructions & tools at target.	RFL	305064
9-Oct-01	Front Sight 110254 was 15373, 110255 was 14859, 110252 was 15719, removed Front Sight Ramp & 3 Front Sight Ramp Screws 28505 was 4. Changed assembly procedure and operation name at operation 427. Replaced F1721 Doc Envelope Assy with 3509 Instruction Book.	RLJ	305074
26-Oct-01	Added scraping tool for ejector hole.	RLJ	305385
14-Nov-01	Stock Assy 300394 was 103602 on SKUs 25803, 25805, 25807	RLJ	305393
15-Nov-01	On S/A LH SKUs: F.P.Assy 110451 was 109576 and on L/A LH SKUs: F.P.Assy 110450 was 109575	RLJ	305396
19-Dec-01	Added Op 604 to chamfer muzzle by hand.	RLJ	305401
7-Mar-02	Added SKUs 27545, 27546 & 27547.	RLJ	305773
3-Apr-02	Trigger pull 4.5 to 6.5 was 4.5 to 5.5	RLJ	305777
7-May-02	Corrected bolt assy for SKUs 27545, 27546 & 27547 Was Polished bolt assy's - changed to Glass Bead Bolts 98080 replaces 28712 and 98871 replaces 33273	RJL	306366
20-May-02	Corrected ammo. usage for 7MM-08 cal. RAMAC	RFL	305783
21-May-02	Added SKU 26448 per DCR 14726 & BOS 089	RLJ	305785
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 CODE MARKS" IN TWO PLACES - REMOVE "& Apply sticker to Gun Tag" - ADD C-47444 - DRAWING LISTING DATE CODE STAMPS	GLC	307036

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Date:	Reason for Revision:	Eng:	Log #:
27-Jun-02	Updated 17 cal ammo SKU 28460 was 28463 and added part numbers for scope 201894, scope base 200291 and rings 200292 on 26448	RLJ	306818
8-Oct-02	Front guard screw 104125 was 104129 on 25752.	RLJ	307610
9-Nov-02	Change Test Ammo to 100 GR (29051) from 80 GR (28533) PSP	ERF	307625
12-Dec-02	Updated To Current Practice (details only) -- Rear Sight changed part number to 111320 from 103145 and Mag. to 111321 from 103148 - Updated Description in 140 & 335 (Router)	ERF	307607
2-May-03	ADD RAMAC #27331 - 700 BDL - 270 WSM	GLC	309143
6-May-03	CORRECT MAGAZINE FOR RAMAC #27331 - WAS 110845	GLC	309155
19-May-03	ADD AMMO INFO FOR RAMAC #27331	GLC	309232
22-May-03	ADD RAMAC#26444 - 700 BDL - 270 WIN W/SCOPE ADD RAMAC#26446 - 700 BDL - 30-06 SPRG W/SCOPE	GLC	309403
11-Aug-03	Added Line-O-Sighter part number to process Op. 606,611	RFL	306911
19-Aug-03	RAMAC#27331 - Firing Pin Assy WAS PT#109575 - UPDATE PROOF ROUND INFO - WAS PT#29347 WITH DESCRIPTION - PROOF ROUND	GLC	310156
8-Sep-03	Added operation 575 to SKU 27331 (270 WSM) and added tools for 270 WSM to operation 400.	RLJ	310331
17-Sep-03	ADD RAMAC#27507 - 700 BDL - 30-06 w/o Sights DEJ#8 OP#427 - REMOVE PT#27545, 27546, & 27547 OP#660 - REMOVE PT#27545, 27546, & 27547	GLC	310443
29-Sep-03	ADD RAMAC#27007 - 700 CDL - 243 WIN ADD RAMAC#27015 - 700 CDL - 7MM-08 REM ADD RAMAC#27011 - 700 CDL - ADD RAMAC#270 WIN ADD RAMAC#27017 - 700 CDL - 30-06 SPRG ADD RAMAC#27047 - 700 CDL - 7MM REM MAG ADD RAMAC#27049 - 700 CDL - 300 WIN MAG	GLC	310480
17-Oct-03	Updated info on operation 435.	RLJ	310333
27-Oct-03	RAMAC#27007 - Bolt Assembly - PT#98079 WAS 28711	GLC	310583

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Date:	Reason for Revision:	Eng:	Log #:
	- Firing Pin Assy - PT#109580 WAS 22041		
	- Trigger Guard Assy - PT#202286 WAS 26370		
	- REMOVE - TRIGGER LOCK - PT#201392		
	- ADD - KEY ASSY - PT#201207		
	RAMAC#27015 - Bolt Assembly - PT#98079 WAS 28711		
	- Firing Pin Assy - PT#109580 WAS 22041		
	- Trigger Guard Assy - PT#202286 WAS 26370		
	- REMOVE - TRIGGER LOCK - PT#201392		
	- ADD - KEY ASSY - PT#201207		
	RAMAC#27011 - Bolt Assembly - PT#98080 WAS 28712		
	- Firing Pin Assy - PT#109579 WAS 22040		
	- Trigger Guard Assy - PT#202284 WAS 26371		
	- REMOVE - TRIGGER LOCK - PT#201392		
	- ADD - KEY ASSY - PT#201207		
	RAMAC#27017 - Bolt Assembly - PT#98080 WAS 28712		
	- Firing Pin Assy - PT#109579 WAS 22040		
	- Trigger Guard Assy - PT#202284 WAS 26371		
	- REMOVE - TRIGGER LOCK - PT#201392		
	- ADD - KEY ASSY - PT#201207		
	RAMAC#27047 - Bolt Assembly - PT#98071 WAS 33273		
	- Firing Pin Assy - PT#109579 WAS 22040		
	- Trigger Guard Assy - PT#202284 WAS 26371		
	- REMOVE - TRIGGER LOCK - PT#201392		
	- ADD - KEY ASSY - PT#201207		
	RAMAC#27049 - Bolt Assembly - PT#98071 WAS 33273		
	- Firing Pin Assy - PT#109579 WAS 22040		
	- Trigger Guard Assy - PT#202284 WAS 26371		
	- REMOVE - TRIGGER LOCK - PT#201392		
	- ADD - KEY ASSY - PT#201207		
28-Jan-04	RAMAC #27507 - Trigger Guard Assy PT#202284 WAS 94089	GLC	311023
23-Feb-04	RAMAC #27017 - Magazine Follower PT#92218 WAS 90952	GLC	311345
	RAMAC #27011 - Magazine Follower PT#92218 WAS 90952		
5-Mar-04	ADD RAMAC #27009 - 700 CDL - 25-06 REM	GLC	311378
	ADD RAMAC #27019 - 700 CDL - 35 WHELEN		
12-Mar-04	Stock Assy R3 - 113138 was Stock Assy - 200559 FOR:	GLC	311428
	25815 700 BDL LH - 7MM REM MAG		
	Stock Assy R3 - 113135 was Stock Assy - 300394 FOR:		
	25803 700 BDL - 7MM REM MAG		
	25807 700 BDL - 300 WIN MAG		
19-May-04	ADD RAMAC#27013 - 700 CDL - 280 REM	GLC	311723

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Date:	Reason for Revision:	Eng:	Log #:
3-Jun-04	ADD RAMAC#27301 - 700 BDL - 270 WSM W/SCQPE	GLC	311847
17-Jun-04	Added operation 648 and information to step 7 on oper 640. Trigger pull spec reduced from 4.5 to 6.5 to 4.5 to 5.5 on opers 585, 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. 109575, 110450 now 305630, 109576, 110451 now 305631, 109578 now 305634, 110454 now 305633, 109579 now 305636, 109580 now 305637.	RLJ	311851
25-Jun-04	ADD RAMAC#27101 - 700 CDL - 223 REM - LH ADD RAMAC#27103 - 700 CDL - 243 WIN - LH ADD RAMAC#27105 - 700 CDL - 270 WIN - LH ADD RAMAC#27107 - 700 CDL - 30-06 SPRG - LH ADD RAMAC#27109 - 700 CDL - 7MM REM MAG - LH	GLC	312142
7-Jul-04	ADD RAMAC#27349 - 700 SPS S/A - 204 RUGER ADD RAMAC#27351 - 700 SPS S/A - 223 REM ADD RAMAC#27353 - 700 SPS S/A - 22-250 REM ADD RAMAC#27355 - 700 SPS S/A - 243 WIN ADD RAMAC#27357 - 700 SPS S/A - 7MM-08 REM ADD RAMAC#27359 - 700 SPS S/A - 308 WIN ADD RAMAC#27475 - 700 SPS S/A YTH - 243 WIN ADD RAMAC#27477 - 700 SPS S/A YTH - 308 WIN ADD RAMAC#27361 - 700 SPS L/A - 270 WIN ADD RAMAC#27363 - 700 SPS L/A - 30-06 SPRG ADD RAMAC#27479 - 700 SPS L/A YTH - 270 WIN ADD RAMAC#27481 - 700 SPS L/A YTH - 30-06 SPRG ADD RAMAC#27331 - 700 SPS S/A MAG - 270 WSM NOTE: THIS RAMAC WAS ORIGINALLY SET UP AS FOLLOWS: ADD RAMAC#27331 - 700 BDL - 270 WSM - MARKETING REQUESTED THE CHANGE - DESCRIPTION AND MATERIALS LIST UPDATED ADD RAMAC#27333 - 700 SPS S/A MAG - 300 WSM NOTE: THIS RAMAC WAS HAS BEEN SET UP WITHOUT AMMO NUMBERS ADD RAMAC#27385 - 700 SPS L/A MAG - 7MM REM MAG ADD RAMAC#27387 - 700 SPS L/A MAG - 300 WIN MAG	GLC	312173
7-Jul-04	Added ammo 202447 204 Ruger 40 Gr to SKU 27349 and quantity on ammo 202310 was 3.5 rounds	RLJ	311852
8-Jul-04	ADD RAMAC#27021 - 700 CDL - 204 RUGER - FRIENDS OF NRA	GLC	312179
15-Jul-04	RAMAC#27387 - Firing Pin Assy PT#305633 WAS 305630	GLC	312194

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Date:	Reason for Revision:	Eng:	Log #:
20-Jul-04	RAMAC#25783 - PROOF ROUND PT#21853 WAS 21832 RAMAC#27353 - PROOF ROUND PT#21853 WAS 21852	GLC	312321
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
26-Jul-04	Added cable lock 301049, removed 153 Gunlock keys (2) 201207, removed procedure for checking gunlock function and added 35 in-lb spec for takedown screw.	RLJ	311858
27-Sep-04	RAMAC#27357 - TEST RDS QTY - 3.500 WAS 10.000	GLC	312766
28-Sep-04	RAMAC#27361 - Magazine PT#16430 WAS 15284 RAMAC#27363 - Magazine PT#16430 WAS 15284 RAMAC#27385 - Magazine PT#16430 WAS 15284 RAMAC#27387 - Magazine PT#16430 WAS 15284 RAMAC#27331 - Magazine PT#110847 WAS 110848 RAMAC#27333 - Magazine PT#110847 WAS 110848	GLC	312768
12-Oct-04	Op. 425 Added NOTE to Chamber Cast	ERF	311621
20-Oct-04	OP#400, 405, & 650 - UPDATE INFO AND REESTABLISH LINKS FOR HEADING PLUGS RAMAC#27109 - Carton Assy PT#1499 WAS 1444	GLC	312860
10-Nov-04	ADD OP#395 FOR ALL PART #'S REMOVE INSPECTION INFO FROM OP#400, 405, & 415	GLC	313271
13-Dec-04	ADDED PART # F98860 TO RAMACS 27021, 27101, 27349, 27351	ERF	311622
3-Jan-05	op 580, 585, 640, 648, added weigh trigger pull and pull scale inspection	DWB	313311
17-Feb-05	Changed stock number - F113135 from F300394	ERF	311625
23-Feb-05	ADD RAMAC#27299 - 700 SP3 L/A - 25-06 REM	GLC	313902

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Date:	Reason for Revision:	Eng:	Log #:
2-Mar-05	ADD RAMAC#27375 - 700 SPS L/A - 270 WIN W/SCOPE ADD RAMAC#27377 - 700 SPS L/A - 30-06 SPRG W/SCOPE ADD RAMAC#27379 - 700 SPS S/A MAG - 300 WSM W/SCOPE	GLC	313911
3-Mar-05	Added P/N's to WSM Proof and Test Ammo	AJL	313851
9-Mar-05	ADD RAMAC#27023 - 700 CDL - 30-06 SPRG W/SIGHTS	GLC	314055
10-Mar-05	RAMAC#27301 - Stock Assembly PT#113529 WAS 106189	GLC	314056
11-Mar-05	Removed Swivel Screw (94996) from RAMAC's 7375, 7377, 7379 Removed OP#593 from RAMAC's 7375, 7377, 7379 Additional 1/2 rnd Test Ammo for OP#600 on RAMAC's 5798, 5787, 5791, 5819, 5812, 7545, 6444, 7021, 7007, 7011, 7101, 7103, 7105, 7349, 7351, 7355, 7475, 7361, 7479, 7375	AJL	313855
21-Mar-05	ADD RAMAC#27027 - 700 CDL - 270 WIN W/SCOPE ADD RAMAC#27029 - 700 CDL - 30-06 SPRG W/SCOPE	GLC	314163
4-Apr-05	RAMAC#27475 27477 27479 27481 27349 27353 27351 27355 27359 27357 27361 27363 27331 27333 27385 27387 - SWIVEL SCREW PT#94996 WAS 97812	GLC	314295
12-Apr-05	Replaced Test and Target Ammo, 202310-202447 With 29218 Ramac 27021 & 27349	ERF	311630
14-Apr-05	RAMAC#27331 & 27333 - Ejector PT#201843 WAS 17017 Ejector Spring PT#201841 WAS 17019	GLC	314370
18-Apr-05	Removed Swivel (97812, 94996) and Op 593 from Ramac 27299, 27361, 27363, 27301, 27333	ERF	311641
25-Jun-05	Changed Followers in Ramac - 27475 27477 27353 27355 27357 27359 Pt. # F92455 WAS F90982 AND Changed Followers in Ramac - 27381 27383 27479 27481 Pt. # F92492 WAS F92218	ERF	314657
26-Jun-05	Changed Followers in Ramac - 27299 27375 27377 Pt. # F92492 WAS F92218	ERF	314659
26-May-05	RAMAC#27301 & 27331 - PROOF ROUND PT#202720 WAS PROOF ROUND - PRF270WSM 150GR SP CORELOKT PT#21816	GLC	314788
9-Jul-05	RAMAC#27385 27387 - Magazine Follower PT#92492 WAS 90952	GLC	315188

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Date:	Reason for Revision:	Eng:	Log #:
16-Jul-05	RAMAC#25803 25805 & 25807 - Stock Assy PT#202345L WAS 113135	GLC	315284
16-Aug-05	RAMAC#25801 25781 25798 25783 25787 25786 25799 25755 25795 - STOCK ASSEMBLY PT#93616L WAS 103600	GLC	315323
31-Aug-05	RAMAC#27101 27103 27105 27107 27108 25749 25819 25818 - Bolt Stop Spring PT#90554 WAS 15224	GLC	315355
11-Oct-05	Stock Assy 93617L was 103601	DLB	315380

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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