

Remington Arms Company, Inc.
Manufacturing Process Document

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

Effective Date: 12-Oct-05
Origination Date: 30-Aug-96

General Instructions:

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

Process Routing Table:

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

INSPECT COMPONENTS BEFORE HEADING
(SHOULDER SINGLE PASS)
(SHOULDER SINGLE PASS: Smaller than .25
Chamber to Length (BELTED - MAGNUMS)
(BELTED - MAGNUMS)
Make Chamber Cast (Not Done on 100% of Product)
Barrel Assembly
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
Assemble Action
Trigger Guard
Spacer to Stock
Proof Test
Proof Test with slave bolt
Hand Chamfer Muzzle with a Live-Pilot Tool
Proof Stamp, Prick Punch and Obstruction In
Test and Target
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

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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 EMB	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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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 EMB		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)**

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 LB2000 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 - 270 WIN

D-49577-P REAMER (replaces B-53313)

A-41281 COLLAR

B-90098-V SHANK

STD Caliber - 280 REM

D-49577-R REAMER (replaces B-82248)

A-41281 COLLAR

B-90098-V SHANK

STD Caliber - 308 WIN

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

A-41281 COLLAR

B-90098-W SHANK

STD Caliber - 35 REM

D-49577-U REAMER (replaces B-86645)

A-41139 COLLAR

B-90098-Q SHANK

STD Caliber - 35 WHELEN

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

STD Caliber - 257 ROBERTS

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

STD Caliber - 7MM MAUSER

D-49577-D REAMER (replaces B-44998)
A-41281 COLLAR
B-90098-V 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 - 6.5x55 SWEDISH

D-49577-A REAMER (replaces C-49577-A)
A-41281 COLLAR
B-90098-R SHANK

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STD Caliber - 7x64 BRENNEKE
D-49577-C REAMER (replaces C-48878)
A-41281 COLLAR
B-90098-V SHANK

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

C-41560-A 25-06 REM MIN Heading Plug
C-41560-B 25-06 REM WMAX Heading Plug
C-41556-A 7MM-08 REM MIN Heading Plug
C-41556-B 7MM-08 REM 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-41560-A 30-06 MIN Heading Plug
C-41560-B 30-06 WMAX Heading Plug
C-52496-A 270 WSM - MIN Heading Plug
C-52496-B 270 WSM - WMAX Heading Plug

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 EMB		Centerfire Rifle		Date: 8/14/2006	
Operation No: 400		Operation: Fit and Head Bolt Assembly to Barrel Assembly (SHOULDER SINGLE PASS)				Work Center:	
Prod. Qty:		Prod. Order #:		Operator		Setup Inspected by & Date:	

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Gage Description and Characteristic	Gage Number	Gage Frequency	1st Shift	2nd Shift	3rd Shift	Remarks, Causes, Action Taken, Etc.
			INSPECT			
VISUAL	VISUAL	100%	REJECT INSPECT			
30-06 MIN Heading Plug	C-41560-A	100%	REJECT INSPECT			
30-06 WMAX Heading Plug	C-41560-B	100%	REJECT INSPECT			
30-06 MIN Heading Plug	C-41560-A	100%	REJECT INSPECT			
30-06 WMAX Heading Plug	C-41560-B	100%	REJECT INSPECT			
270 WIN MIN Heading Plug	C-41560-A	100%	REJECT INSPECT			
270 WIN WMAX Heading Plug	C-41560-B	100%	REJECT INSPECT			
25-06 REM MIN Heading Plug	C-41560-A	100%	REJECT INSPECT			
25-06 REM WMAX Heading Plug	C-41560-B	100%	REJECT INSPECT			
			REJECT INSPECT			
			REJECT INSPECT			
			REJECT INSPECT			
			REJECT			

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

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 - 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

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B-90098-S SHANK
STD Caliber - 223 REM
D-49577-K REAMER (replaces B-54136-S)
A-41133 COLLAR
B-90098-S 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
C-41185-B 17 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-41521-A 22-250 REM - MIN Heading Plug
C-41521-B 22-250 REM - WMAX Heading Plug
C-41556-A 243 WIN - MIN Heading Plug
C-41556-B 243 WIN - WMAX Heading Plug

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 EMB		Centerfire Rifle		Date: 8/14/2006	
Operation No: 405		Operation: Fit and Head Bolt Assembly to Barrel Assembly (SHOULDER SINGLE PASS; Smaller than .25 caliber)				Work Center:	
Prod. Qty:		Prod. Order #:		Operator		Setup Inspected by & Date:	

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Gage Description and Characteristic	Gage Number	Gage Frequency	1st Shift	2nd Shift	3rd Shift	Remarks, Causes, Action Taken, Etc.
			INSPECT			
VISUAL	VISUAL	100%	REJECT INSPECT			
17 REM - MIN Heading Plug	C-41185-A	100%	REJECT INSPECT			
17 REM - WMAX Heading Plug	C-41185-B	100%	REJECT INSPECT			
22-250 REM - MIN Heading Plug	C-41521-A	100%	REJECT INSPECT			
22-250 REM - WMAX Heading Plug	C-41521-B	100%	REJECT INSPECT			
222 REM - MIN Heading Plug	C-41154-A	100%	REJECT INSPECT			
222 REM - WMAX Heading Plug	C-41154-B	100%	REJECT INSPECT			
223 REM - MIN Heading Plug	C-41155-A	100%	REJECT INSPECT			
223 REM - WMAX Heading Plug	C-41155-B	100%	REJECT INSPECT			
243 WIN - MIN Heading Plug	C-41556-A	100%	REJECT INSPECT			
243 WIN - WMAX Heading Plug	C-41556-B	100%	REJECT INSPECT			
			REJECT			

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415 Fit and Head Bolt Assembly to Barrel Assy and Chamber to Length (BELTED - MAGNUMS)

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

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- 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.
- 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

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F-76039 Machine - Special Chambering Mach.
A-89656 Scraping Tool - Ejector hole
D-46967 Fixture

STD ACCU-LUBE 2400

STD STEELGARD 1302-NL

STD 264 Win Mag.

B-83838 REAMER - SHOULDER
A-41281 COLLAR
B-90098-U SHANK
B-53328-T REAMER - FACE
B-53328-V BELT CUTTER
B-53328-R CHAMBER GUIDE BUSHING

STD 7MM Mag.

B-84815 REAMER - SHOULDER
A-41281 COLLAR
B-90098-V SHANK
B-53328-F REAMER - FACE
B-53328-V BELT CUTTER
B-53328-R CHAMBER GUIDE BUSHING

STD 300 H&H Mag.

B-53311 REAMER - SHOULDER
A-41281 COLLAR
B-90098-T SHANK
B-53328-W REAMER - FACE
B-53328-V BELT CUTTER
B-53328-S CHAMBER GUIDE BUSHING

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STD 300 Win Mag.
B-86573 REAMER - SHOULDER
A-41281 COLLAR
B-90098-W SHANK
B-53328-W REAMER - FACE
B-53328-V BELT CUTTER
B-53328-R CHAMBER GUIDE BUSHING

STD 338 Win Mag.
C-47271 REAMER - SHOULDER
A-41281 COLLAR
B-90098-N SHANK
B-53328-J REAMER - FACE
B-53328-V BELT CUTTER
B-53328-J CHAMBER GUIDE BUSHING

STD 8MM REM Mag.
B-43096 REAMER - SHOULDER
A-41281 COLLAR
B-90098-N SHANK
B-53328-L REAMER - FACE
B-53328-V BELT CUTTER
B-53328-R CHAMBER GUIDE BUSHING

STD 416 REM Mag.
B-43096 REAMER - SHOULDER
A-41281 COLLAR
B-90098-N SHANK
B-53328-L REAMER - FACE
B-53328-V BELT CUTTER

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B-53328-R	CHAMBER GUIDE BUSHING
STD	300 WBV Mag.
C-48291	REAMER - SHOULDER
A-41281	COLLAR
B-90098-W	SHANK
B-53328-W	REAMER - FACE
B-53328-V	BELT CUTTER
B-53328-H	CHAMBER GUIDE BUSHING
STD	7MM WBV Mag.
C-48591	REAMER - SHOULDER
A-41281	COLLAR
B-90098-V	SHANK
B-53328-P	REAMER - FACE
B-53328-V	BELT CUTTER
B-53328-G	CHAMBER GUIDE BUSHING
STD.	375 H&H MAG
C-49820-L	COMBINATION SHOULDER & BELT REAMER
B-49820-Z	BELT CUTTER (FITS ON C-49820-L)
C-49820,DE	LOCK SCREW
C-49820-F	SHIM, 0.001 THICK
C-49820-G	SHIM, 0.005 THICK
C-49820-H	SHIM, 0.010 THICK
C-49820-J	SHIM, 0.050 THICK
C-49820-K	SHIM, 0.100 THICK
B-90098-Q	HEADING REAMER SHANK
A-41281	COLLAR
C-83853-A	7MM REM MAG - BELT - MIN Heading Plug
C-83853-B	7MM REM MAG - BELT - WMAX Heading Plug

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C-41561-A 7MM REM MAG - MIN Heading Plug
 C-41561-B 7MM REM MAG - WMAX Heading Plug
 C-83853-A 300 WIN MAG - BELT - MIN Heading Plug
 C-83853-B 300 WIN MAG - BELT - WMAX Heading Plug
 C-41546-A 300 WIN MAG - MIN Heading Plug
 C-41546-B 300 WIN MAG - WMAX Heading Plug
 C-83853-A 338 WIN MAG - BELT - MIN Heading Plug
 C-83853-B 338 WIN MAG - BELT - WMAX Heading Plug
 C-41561-A 338 WIN MAG - MIN Heading Plug
 C-41561-B 338 WIN MAG - WMAX Heading Plug

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 EMB		Centerfire Rifle			Date: 8/14/2006	
Operation No: 415	Operation: Fit and Head Bolt Assembly to Barrel Assy and Chamber to Length (BELTED - MAGNUMS)					Work Center:	
Prod. Qty:	Prod. Order #:	Operator			Setup inspected by & Date		
Gage Description and Characteristic	Gage Number	Gage Frequency	1st Shift	2nd Shift	3rd Shift	Remarks, Causes, Action Taken, Etc	
VISUAL	VISUAL	100%	INSPECT				
300 WIN MAG - BELT - MIN Heading Plug	C-83853-A	100%	REJECT INSPECT				
300 WIN MAG - BELT - WMAX Heading Plug	C-83853-B	100%	REJECT INSPECT				
300 WIN MAG - MIN Heading Plug	C-41546-A	100%	REJECT INSPECT				
300 WIN MAG - WMAX Heading Plug	C-41546-B	100%	REJECT INSPECT				

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			INSPECT			
338 WIN MAG - BELT MIN Heading Plug	C-83853-A	100%	REJECT INSPECT			
338 WIN MAG - BELT - WMAX Heading Plug	C-83853-B	100%	REJECT INSPECT			
338 WIN MAG - MIN Heading Plug	C-41561-A	100%	REJECT INSPECT			
338 WIN MAG - WMAX Heading Plug	C-41561-B	100%	REJECT INSPECT			
7MM REM MAG - BELT - MIN Heading Plug	C-83853-A	100%	REJECT INSPECT			
7MM REM MAG - BELT - WMAX Heading Plug	C-83853-B	100%	REJECT INSPECT			
7MM REM MAG - MIN Heading Plug	C-41561-A	100%	REJECT INSPECT			
7MM REM MAG - WMAX Heading Plug	C-41561-B	100%	REJECT INSPECT			
			REJECT INSPECT			
			REJECT INSPECT			
			REJECT INSPECT			
			REJECT INSPECT			
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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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Centerfire Rifle				Date: 8/14/2006	
				Work Center:	
Operator			Setup Inspected by & Date:		
2nd Shift		3rd Shift		Remarks, Causes, Action Taken, Etc.	

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425 Make Chamber Cast (Not Done on 100% of Product)

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

Step Operation / Step Description

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

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

PROCESS CONTROL INSPECTION RECORD THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES	Revision Date: 12-Oct-05	Processed by:
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Part No:

Operation No: 425

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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
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 EMB		Centerfire Rifle			Date: 8/14/2006
Operation No: 427	Operation: Assemble Rear Sight Assembly, Front 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 INSPECT			
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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 - Oil 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 EMB		Centerfire Rifle		Date: 8/14/2006	
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

Step Operation / Step Description

Form Radius on Edge of Firing Pin Hole Only done on .17 cal. And 25.06

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 EMB		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 REJECT				

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432 Assemble Riveted Extractor to Bolt - (MAGNUMS)

Step	Operation / Step Description
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PROCEDURE:

- 1 Extractor Must Be Shaped to Bolt Shroud by Adjusting Both Ends of (if Necessary)
 - Claw of Extractor Must Be Checked on Tension Plug for "Go" and "No Go"
 - a. Assemble Extractor to Bolt with Extractor Rivet
 - Blend Extractor with Shroud
 - b. Extractor Must Clear Min Tension Plug and Have Tension on Max Tension Plug
 - c. File to Remove Excess Rivet and 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.

SUGGESTION: If Bolts are processed in stages, Super Blue may be applied

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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
B-87034-D	TENSION Belted Magnums

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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 700-30L EMB		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 INSPECT				
			REJECT				

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435 Assemble Rivetless Extractor to Bolt

Step Operation / Step Description

Assemble Rivetless Extractor to Bolt

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

Tool Number

Tooling Description

B-87034-C	Min Tension Plug - .445
B-84831-B	Max Tension Plug
B-87034-E	EXTRACTOR TENSION PLUG GAGE - 6.5X55

PROCESS CONTROL INSPECTION RECORD THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES	Revision Date: 12-Oct-05	Processed by:
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Part No:		Part Name: Fin Assy 700 BDLEMB		Centerfire Rifle		Date: 8/14/2006
Operation No: 435		Operation: Assemble Rivetless Extractor to Bolt				Work Center:
Prod. Qty:	Prod. Order #:	Operator			Setup Inspected by & Date:	
Gage Description and Characteristic	Gage Number	Gage Frequency	1st Shift	2nd Shift	3rd Shift	Remarks, Causes, Action Taken, Etc.
VISUAL	VISUAL	100%	INSPECT REJECT			
Min Tension Plug - .445	B-87034-C	100%	INSPECT REJECT			
Max Tension Plug	B-84831-B	100%	INSPECT REJECT			
EXTRACTOR TENSION PLUG GAGE - 6.5X55	B-87034-E	100%	INSPECT REJECT			
			INSPECT REJECT			
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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 Cross 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

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			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 EMB		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			
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			REJECT			

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465R Strip Defective Bolt

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 EMB		Centerfire Rifle		Date: 8/14/2006	
Operation No: 465R	Operation: Strip Defective Bolt				Work Center:	
Prod. Qty:	Prod. Order #:	Operator:			Setup Inspected by & Date:	
Gage Description and Characteristic	Gage Number	Gage Frequency	1st Shift	2nd Shift	3rd Shift	Remarks, Causes, Action Taken, Etc.
VISUAL	VISUAL	100%	INSPECT			
			REJECT INSPECT			
			REJECT INSPECT			
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580

Assemble Action

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. Marris
- 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. Marris & Color, No Rust or Miscuts (Cam Cut & Cocking Notch present)
 - b. Presence of Naltex 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:
 - 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)

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- 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 1/3 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
 - 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!

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- 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 Screwdriver
- 8. Select Trigger Assembly
 - a. Check for Presence of Builders Stamp Number
 - 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
 - Maintain Slot Center and Straightness at ALL Times
- 12. Select Bolt Stop Spring
 - a. Position in Receiver

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- 13 Position Trigger Assembly
- Adjust Fire Control Location
 - Check that Bolt Stop Release is Free
 - Select Bolt Stop Pin and Assemble into Receiver
 - 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

- Inspect for:
 - Color
 - 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.

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

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

- 18 Close the Action and Lock Bolt Down

Tool Number

Tooling Description

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A-88003 Taper Reamer for Braze in Firing Pin Hole
 301467 Molykote GN Paste or Powder Lubricant
 305287 MC-NYLOTEX VINYL CAPS
 STD Ball Handle Ratchet Screwdriver
 (McMaster Carr no. 8962A14 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-80652 Pins Tight Tester
 B-52089 Firing Pin Protrusion Gage
 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 BDLEMB		Centerfire Rifle		Date: 8/14/2006
Operation No: 580	Operation: Assemble Action				Work Center:
Prod. Qty:	Prod. Order #:	Operator		Setup Inspected by & Date:	
Gage Description and Characteristic	Gage Number	Gage Frequency	1st Shift	2nd Shift	3rd Shift
Remarks, Causes, Action Taken, Etc.					

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585 Assemble Stock to Action & Attach Build to Tag
to Barrel

Step	Operation / Step Description
	Assemble stock to action and Attach Build to Tag to Barrel
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. Marks 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
- 5 Assemble Floor Plate Assembly and Stock to Barrel Assembly Complete with Front and Rear Trigger Guard Screws.
Using Pneumatic Power Driver, or Hall Ratchet 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"
Continue with Part "e"
- e) If Two Shims are Necessary

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- Remove the Non-Stick Back from One Shim and Place it on the Top Surface of the Second Shim and Press Firmly Together
- Repeat Above Procedures for the Installation of the now Double Shims

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

- 7 Assemble Front Survival Screw with Washer to Stock.
- 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

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"OFF" Position

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

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Touching Trigger

RIFLE MUST NOT FIRE

d) Proceed to Step "f" when All Three Cycles are Complete

f. Push Safety to "S" or "ON" Position

Note: 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

12 Check Trigger Pull (4.75 to 5.75 lbs.) parallel with action

- a. Must be Short & Crisp, No Creep Over or Overdraw
- Try (3) Times

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

Follow procedure below using at least two different weights.

- a. Slowly lift dead weight off bench using trigger pull scale.
- b. Slowly return weight to bench and read scale.

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

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

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- send scale to Gage Inspection for Re-Calibration.
- 14 Check for "Jar Off"
 - 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 Firmly (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

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

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
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
7237T1	Lube Brush (McMaster-Carr Tin Ferroule, 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

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C-47741 Sear Engagement Gage - Solid Bolt
A-43977 Trigger Guard Clearance Shim Tool (.030")
B-70697 Trigger Pull Scale
B-TS-7300 Dent & Scuff Template
STD Dummy Cartridge Rounds of Proper Caliber Being Built
B-70697 Trigger Pull Scale

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 EMB		Center fire Rifle			Date 8/14/2006		
Operation No: 585		Operation: Assemble Stock to Action & Attach Build to Tag						Work Center:	
Prod. Qty:		Prod. Order #:		Operator			Setup Inspected by & Date:		
Gage Description and Characteristic		Gage Number	Gage Frequency	1st Shift	2nd Shift	3rd Shift	Remarks, Causes, Action Taken, Etc.		
VISUAL		VISUAL	100%	INSPECT					
.006 Feeler Gage or Suitable Shim		STD	100%	REJECT INSPECT					
#REF!		#REF!	100%	REJECT INSPECT					
#REF!		#REF!	100%	REJECT INSPECT					
Sear Engagement Gage - Solid Bolt		C-47741	100%	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 Swival 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 EMB	Centerfire Rifle	Date: 8/14/2006

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Operation No: 563
Prod. Qty:

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600

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 SHOTGUN PROOF
BOOTH) unless told to do other wise. (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 rod (make sure action is open before inserting rod).
 - b. Insert into muzzle until rod is clearly visible through ejection port.

B. PROOF TEST

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

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

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

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

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

NOTE: Visually check the first gun from each side of the truck for obvious visual defects before 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

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removing shell.

- c. Place safe in "S" or "on" position, remove gun from proof jack and enter gun information and reject in computer.

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

10. Check fired case for:

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

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

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

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a. Stamp prick punch on the underside of the bolt handle, in addition to the proof mark on the Barrel.

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.
 1. Move Safe to "S" or "ON" position before removing gun from shooting device.

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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).

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 EMB	Centerfire Rifle	Date: 8/14/2006
Operation No: 600	Operation: Proof Test		Work Center:

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Prod. Qty.	
Page Description and Unit of Measure	

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			INSPECT			
			REJECT			
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Pieces Run:

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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				Revision Date: 18-May-05		Processed by:
THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL						
Part No:	Part Name: Fin Assy 700 ADL		Centerfire Rifle			Date: 8/14/2006
Operation No: 600R	Operation: Proof Test with slave bolt					Work Center:
Prod. Qty:	Prod. Order #:	Operator			Setup inspected by & Date:	
Gage Description and Characteristic	Gage Number	Gage Frequency	1st Shift	2nd Shift	3rd Shift	Remarks, Causes, Action Taken, Etc.
VISUAL	VISUAL	100%	INSPECT			
			REJECT			
			INSPECT			
			REJECT			

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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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		REJECT INSPECT	
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605R

Check Repaired Guns Returning to Gallery for
Proof Stamp, Prick Punch and Obstruction In
Barrel

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 EMB		Centerfire Rifle		Date:	9/14/2006
Operation No: 605R	Operation: Check Repaired Guns Returning to Gallery for				Work Center:	
Prod. Qty:	Prod. Order #:	Operator			Setup inspected by & Date	
Gage Description and Characteristic	Gage Number	Gage Frequency	1st Shift	2nd Shift	3rd Shift	Remarks, Causes, Action Taken, Etc.
VISUAL	VISUAL	100%	INSPECT			
			REJECT INSPECT			
			REJECT INSPECT			
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			REJECT			

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606

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 sampled 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

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operations are performed.

II. TEST AND TARGET OBJECTIVES

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

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.

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A. Test/Target Description

1. Pick up rifle from truck and inspect for:

- a. Live Ammo - Inspect chamber and Magazine-both must be empty.
- b. Caliber - To verify for shooter personal safety in selecting ammunition for test.
- c. Proof mark on Barrel - (REP) must be present, right rear side of barrel, ahead of Magnaflux stamp.
- d. Proof mark on Bolt - (.). Pick 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 - 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,

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raise the bolt.

a. Bolt must raise or open without excessive force.

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

a. Rifle must not fire.

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

a. Rifle must not fire.

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

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

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

a. Rifle must not fire.

b. Safety must not move to full "OFF" 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.

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12. For first rifle of a new caliber with iron sights, position 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
17 Rem.	25 gr. HPPL	5
.222 Rem.	50 gr. PSP	5
22-250 Rem.	55 gr. HPPL	4
. 223 Rem.	55 gr. PSP	5
.243 Win.	100 gr. PSPCL	4
25.06 Rem.	120 gr. PSPCL	4
.270 Win.	150 gr. SPCL	4
7mm Rem. Mag.	175 gr. PSPCL	3
30.06 Sprg.	180 gr. SPCL-150 gr. PSPCL	4
.300 Win. Mag.	180 gr. PSPCL	3
.338 Win. Mag.	250 gr. PSP	3
7mm08 Rem.	140 gr. PSP	4
270 WSM	130 gr. PSPCL	4

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.

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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.
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

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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.

24. Open guard. (If on accuracy device)

25. For the Targeted rifles (10% std. & 100% Police) Place Line-o-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

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be within the following specifications in relationship to the position of the crosshairs.

Elevation	Windage
2" High - 3" 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 be tight - not 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.

GROUP SIZE SPECIFICATIONS

A. FIELD GRADE RIFLES - (BDL)

MAX. GROUP CENTER TO CENTER

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CALIBER	AMMUNITION TYPE	3 SHOT	4 SHOT	5 SHOT
17 Rem.	25 gr. HPPL	1.5	2.0	2.2
22 Rem.	50 gr. PSP	1.5	2.0	2.2
22-250 Rem.	55 gr. HPPL	1.5	2.0	2.2
228 Rem.	55 gr. PSP	1.5	2.0	2.2
243 Win.	100 gr. PSPCL	1.5	2.0	2.2
25.06 Rem.	120 gr. PSPCL	1.7	2.2	2.7
270 Win.	150 gr. SPCL	1.7	2.2	2.7
7mm Rem. Mag.	175 gr. PSPCL	2.5	3.0	3.5
30.06 Sprg.	180 gr. SPCL	1.7	2.2	2.7
300 Win. Mag.	180 gr. PSPCL	2.5	3.0	3.5
338 Win. Mag.	250 gr. PSP	2.5	3.0	3.5
7mm08 Rem.	140 gr. PSP	1.5	2.0	2.2
270 WSM	130 gr. PSPCL	2.5	3.0	3.5

- d. Sights must be capable of adjustment to 0"±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)

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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 white repair ticket on rifle.
 - b. If a rifle fails to meet the target group size specifications, reject that rifle and target all remaining rifles on 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%
33. Place Shooters Test/Target ID Number (sticker) on rear of Tag (acceptable product only)
 - a. Rejected rifles do not get ID stickers .

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V. SAFETY AFTER TEST

A. Open Bolt.

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

B. Inspect Chamber and Magazine for live ammunition.

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

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

C. Visual Inspect for marring by device or port.

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)

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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 REM. MAG, 338 WIN. MAG,	D-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
	22-250 REM.	C-46199 OR D-48349-E
	.243 WIN.	C-46194 OR D-48349-H
	30.06 SPRG., .270 WIN., 25.06 REM.	C-45930 OR D-48349-G

(Close Hard Plug Storage Cabinet is D-46202)

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 EMB	Centerfire Rifle		Date:	8/14/2006
Operation No: 606	Operation: Test and Target			Work Center:	
Prod. Qty:	Prod. Order #:	Operator	Setup Inspected by & Date:		

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Gage Description and Characteristic	Gage Number	Gage Frequency	1st Shift	2nd Shift	3rd Shift	Remarks, Causes, Action Taken, Etc.
VISUAL		100%	INSPECT			
			REJECT			
			INSPECT			
			REJECT			
			INSPECT			
			REJECT			
			INSPECT			
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			REJECT			

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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 EMB		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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			INSPECT			
			REJECT INSPECT			
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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
 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 for Mars
 - 4. Check for Finish
 - 5. Check for Brass in Bolt Head
 - 6. Check for Proof Mark On Underside of Bolt Handle
 - 7. 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
- b. Stock Rejects only:
 - 1. Place 3/4" Yellow Dot with Identification Stamp and Nonconformity

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Code, Close to Nonconformity on Stock Rejects

- 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.

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STD Cleaning Patches (Hoppes or equiv.)
STD Red 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 12-Oct-05			Processed by:
THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES						
Part No:	Part Name: Fin Assy 700 BDL EMB		Centerfire Rifle			Date: 8/14/2005
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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			INSPECT			
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Reset trigger pull within specs as needed.
(Not done on 100% of the product)

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

NOTE: 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.

Try (3) times

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. Redcheck the trigger pull with the pull scale.
 - a. Hold the pullscale parallel with the action.
 - b. Adjust again if necessary.
6. Apply Duro Cement to re-seal the adjustment screw.
 - a. Avoid runs, apply only enough to make an effective seal.
 - b. Allow a few seconds for cement to "skin" over.
7. Invert the action in the vise so bottom side is up.
8. Insert Magazine Spring with follower and re-assemble the stock assembly.
 - a. Properly torque the takedown screws.
9. Return rifle to Final Inspection.

Gages:

B-70697

Trigger Pull Scales

PROCESS CONTROL INSPECTION RECORD				Revision Date: 18-May-05		Processed by:	
THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL							
Part No:		Part Name: Fin Assy 700 ADL		Centerfire Rifle		Date: 8/14/2006	
Operation No: 648		Operation: Reset trigger pull within specs as needed.				Work Center:	
Prod. Qty:		Prod. Order #:		Operator		Setup Inspected by & Date:	
Gage Description and Characteristic		Gage Number	Gage Frequency	1st Shift	2nd Shift	3rd Shift	Remarks, Causes, Action Taken, Etc.
VISUAL		VISUAL	100%	INSPECT REJECT			

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				INSPECT				
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650 **Inspect Heading and Sear Lift**

Step	Operation / Step Description
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Inspect Heading and Sear Lift	
--------------------------------------	--

- | | |
|---|---|
| 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

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C-41185-C	17 REM - 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-41521-A	22-250 REM - MIN Heading Plug
C-41521-C	22-250 REM - IMAX Heading Plug
C-41556-A	243 WIN - MIN Heading Plug
C-41556-C	243 WIN - IMAX Heading Plug
C-41560-A	25-06 REM - MIN Heading Plug
C-41560-C	25-06 REM - IMAX Heading Plug
C-41556-A	7MM-08 REM - MIN Heading Plug
C-41556-C	7MM-08 REM - IMAX Heading Plug
C-41560-A	270 WIN - MIN Heading Plug
C-41560-C	270 WIN - IMAX Heading Plug
C-41544-A	280 REM - MIN Heading Plug
C-41544-C	280 REM - IMAX Heading Plug
C-41561-A	7MM REM MAG - MIN Heading Plug
C-41561-C	7MM REM MAG - IMAX Heading Plug
C-83853-A	7MM REM MAG - BELT - MIN Heading Plug
C-83853-C	7MM REM MAG - BELT - IMAX Heading Plug
C-41560-A	30-06 - MIN Heading Plug
C-41560-C	30-06 - IMAX Heading Plug
C-41546-A	300 Win - MIN Heading Plug
C-41546-C	300 Win - IMAX Heading Plug
C-83853-A	300 Win - BELT - MIN Heading Plug
C-83853-C	300 Win - BELT - IMAX Heading Plug
C-41561-A	338 Win - MIN Heading Plug
C-41561-C	338 Win - IMAX Heading Plug
C-83853-A	338 Win - BELT - MIN Heading Plug
C-83853-C	338 Win - BELT - IMAX Heading Plug
C-52496-A	270 WSM - MIN Heading Plug
C-52496-C	270 WSM - IMAX Heading Plug

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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 EMB	Centerfire Rifle			Date: 8/14/2006	
Operation No: 650	Operation: Inspect Heading and Seal Life				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			
Dial Gage	D-44581	100%	REJECT INSPECT			
Attribute Gage	C-47741	100%	REJECT INSPECT			
17 REM - MIN Heading Plug	C-41185-A	100%	REJECT INSPECT			
17 REM - IMAX Heading Plug	C-41185-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			

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223 REM - MIN Heading Plug	C-4155-A	100%	INSPECT			
223 REM - IMAX Heading Plug	C-4155-C	100%	REJECT INSPECT			
243 WIN - MIN Heading Plug	C-4155-A	100%	REJECT INSPECT			
243 WIN - IMAX Heading Plug	C-4155-C	100%	REJECT INSPECT			
30-06 - MIN Heading Plug	C-4156-A	100%	REJECT INSPECT			
30-06 - IMAX Heading Plug	C-4156-C	100%	REJECT INSPECT			
30-06 - MIN Heading Plug	C-4156-A	100%	REJECT INSPECT			
30-06 - IMAX Heading Plug	C-4156-C	100%	REJECT INSPECT			
270 WIN - MIN Heading Plug	C-4156-A	100%	REJECT INSPECT			
270 WIN - IMAX Heading Plug	C-4156-C	100%	REJECT INSPECT			
25-06 REM - MIN Heading Plug	C-4156-A	100%	REJECT INSPECT			
25-06 REM - IMAX Heading Plug	C-4156-C	100%	REJECT			

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300 Win - BELT - MIN Heading Plug	C-83853-A	100%	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 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			
7MM REM MAG - BELT - MIN Heading Plug	C-83853-A	100%	REJECT INSPECT			
7MM REM MAG - BELT - IMAX Heading Plug	C-83853-C	100%	REJECT INSPECT			
7MM REM MAG - MIN Heading Plug	C-41561-A	100%	REJECT INSPECT			
7MM REM MAG - IMAX Heading Plug	C-41561-C	100%	REJECT			

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

Step	Operation / Step Description
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	Mark Bolt to Match Receiver Serial Number Using Dot Peen Marking Machine
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- | | |
|---|--|
| 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
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40789	Dot Peen Marker
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E-TS-7583 Holding Fixture

A-51082 Stylus

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 EMB		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			
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660 Assemble Hood to Front Sight Ramp

Step Operation / Step Description

Assemble Front Sight Cover to Front Sight Ramp With Milbar Tool

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

Tool Number

Tooling Description

Milbar 47R, 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 EMB		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			

[illegible][illegible][illegible]

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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

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 EMB		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.	
VISUAL	VISUAL	100%	INSPECT REJECT				

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Dept	Oper	Operation Description	Part Numbers
9132	1	Issue from Crib	26023 26025 26027 26029 26031 26033 26035 26037 26039 25817 26041 26043 26430 26432 27025
8761	395	INSPECT COMPONENTS BEFORE HEADING.	26023 26025 26027 26029 26031 26033 26035 26037 26039 25817 26041 26043 26430 26432 27025
8761	400	Fit and Head Bolt Assembly to Barrel Assembly (SHOULDER SINGLE PASS)	26031 26033 26035 25817 26430 26432 27025
8761	405	Fit and Head Bolt Assembly to Barrel Assembly (SHOULDER SINGLE PASS; Smaller than .25 caliber)	26037 26023 26027 26025 26029
8761	415	Fit and Head Bolt Assembly to Barrel Assy and Chamber to Length (BELTED - MAGNUMS)	26039 26041 26043
8761	420	Ream Chamber to Length (BELTED - MAGNUMS)	26039 26041 26043
8761	425	Make Chamber Cast (Not Done on 100% of Product)	26023 26025 26027 26029 26031 26033 26035 26037 26039 25817 26041 26043 26430 26432 27025
8761	427	Assemble Rear Sight Assembly and Front Sight to Barrel Assembly	26023 26025 26027 26029 26031 26033 26035 26037 26039 25817 26041 26043 26430 26432
8761	430	Ream Ejector Hole	26023 26025 26027 26029 26031 26033 26035 26037 26039

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Dept	Oper	Operation Description	Part Numbers
			25817 26041 26043
			26430 26432 27025
8761	431	Form Radius on Edge of Firing Pin Hole	26031 26037
8761	432	Assemble Riveted Extractor to Bolt - (MAGNUMS)	26039 26041 26043
			27025
8761	435	Assemble Rivetless Extractor to Bolt	26023 26025 26027
			26029 26031 26033
			25817 26035 26037
			26430 26432
8761	440	Assemble Ejector to Ejector Spring and then Assemble to Bolt with Ejector Cross Pin.	26023 26025 26027
			26029 26031 26033
			26035 26037 26039
			25817 26041 26043
			26430 26432 27025
8761	460R	Strip Defective Barrel Assembly Complete	26023 26025 26027
			26029 26031 26033
			26035 26037 26039
			25817 26041 26043
			26430 26432 27025
8761	465R	Strip Defective Bolt	26023 26025 26027
			26029 26031 26033
			26035 26037 26039
			25817 26041 26043
			26430 26432 27025
8761	580	Assemble Action	26023 26025 26027
			26029 26031 26033
			26035 26037 26039
			25817 26041 26043
			26430 26432 27025
8761	585	Assemble Stock to Action & Attach Hang Tag to Trigger Guard	26023 26025 26027
			26029 26031 26033
			26035 26037 26039
			25817 26041 26043
			26430 26432 27025
8761	593	Assemble Front Swivel Screw and Swivel Screw Spacer to Stock	26023 26025 26027
			26029 26031 26033
			26035 26037 26039

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Dept	Oper	Operation Description	Part Numbers
			25817 26041 26043
			26430 26432 27025
8785	600	Proof Test	26023 26025 26027
			26029 26031 26033
			26035 26037 26039
			25817 26041 26043
			26430 26432 27025
8785	600R	Proof Test with slave bolt	26023 26025 26027
			26029 26031 26033
			26035 26037 26039
			25817 26041 26043
			26430 26432 27025
8785	604	Hand Chamfer Muzzle with a Live Pilot Tool	26023 26025 26027
			26029 26031 26033
			26035 26037 26039
			25817 26041 26043
			26430 26432 27025
8785	605R	Check Repaired Guns Returning to Gallery for Proof Stamp, Prick Punch and Obstruction In Barrel	26023 26025 26027
			26029 26031 26033
			26035 26037 26039
			25817 26041 26043
			26430 26432 27025
8785	606	Test and Target	26023 26025 26027
			26029 26031 26033
			26035 26037 26039
			25817 26041 26043
			26430 26432 27025
8785	620	Inspect For Live Ammunition	26023 26025 26027
			26029 26031 26033
			26035 26037 26039
			25817 26041 26043
			26430 26432 27025
8786	640	Final Inspection	26023 26025 26027
			26029 26031 26033
			26035 26037 26039
			25817 26041 26043
			26430 26432 27025
8786	640	Reset trigger pull within specs as needed -	26023 26025 26027

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Dept	Oper	Operation Description	Part Numbers
		not done on 100% of the product	26029 26031 26033 26035 26037 26039 25817 26041 26043 26430 26432 27025
8786	650	Inspect Heading and Sear Lift	26023 26025 26027 26029 26031 26033 26035 26037 26039 25817 26041 26043 26430 26432 27025
8786	655	Mark Bolt to Match Receiver Serial number Using Dot Peen Marking Machine	26023 26025 26027 26029 26031 26033 26035 26037 26039 25817 26041 26043 26430 26432 27025
8786	660	Assemble Hood to Front Sight Ramp	26023 26025 26027 26029 26031 26033 26035 26037 26039 25817 26041 26043 26430 26432
8786	676	Print Box End Label & Pack Rifle To Warehouse	26023 26025 26027 26029 26031 26033 26035 26037 26039 25817 26041 26043 26430 26432 27025

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Dept	Oper	Operation Description	Part Numbers
01	2	01	01
02	0	01	01
03	0	01	01
04	0	01	01
05	0	01	01
06	0	01	01
07	0	01	01
08	0	01	01
09	0	01	01
10	0	01	01
11	0	01	01
12	0	01	01
13	0	01	01
14	0	01	01
15	0	01	01
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17	0	01	01
18	0	01	01
19	0	01	01
20	0	01	01
21	0	01	01
22	0	01	01
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92	0	01	01
93	0	01	01
94	0	01	01
95	0	01	01
96	0	01	01
97	0	01	01
98	0	01	01
99	0	01	01
100	0	01	01

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Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
							RAMAC DESCRIPTION
							26037 700 BDL - 17 REM Embellished
							26023 700 BDL - 222 REM Embellished
							26027 700 BDL - 223 REM Embellished
							26024 700 BDL - 22-250 REM Embellished
							26029 700 BDL - 243 WIN Embellished
							26031 700 BDL - 25-06 REM Embellished
							26033 700 BDL - 270 WIN Embellished
							26039 700 BDL - 7MM REM MAG Embellished
							26035 700 BDL - 30-06 SPRG Embellished
							26041 700 BDL - 300 WIN MAG Embellished
							26043 700 BDL - 338 WIN MAG Embellished
							25817 700 BDL - 30-06 SPRG Emb (UMWA)
							26430 700 BDL - 7MM-08 REM Embellished
							26432 700 BDL - 280 REM Embellished
							27025 700 CDL - 270 WSM Embellished (NWTF)
26037							700 BDL - 17 REM Embellished
		301049	502	676	1		Cable Lock
		107840	47	405	1		Barrel Assembly
		28710	37	405	1		Bolt Assembly
		110254	87	427	1		Front Sight
		111320	107	427	1		Rear Sight Assembly
		28505	117	427	3		Sight Screw
		17013	136	580	1		Bolt Stop
		24475	170	580	1		Bolt Stop Pin
		15224	39	580	1		Bolt Stop Spring
		993002	240	676	1		Box & Envelope Label
		1444	10	676	1		Carton - RF-CF
		3508	20	676	1		Instruction Book
		17017	410	440	1		Ejector
		94555	420	440	1		Ejector Pin
		17018	430	440	1		Ejector Spring
		99413	360	676	1		EMBELLISHMENT ROYALTY - RECEIVER
		3487	400	585	1		Build To Tag
		97138	440	435	1		Extractor
		305631	160	580	1.000		Firing Pin Assy
		88880	350	585	1.000		Floor Plate Insert
		104127	310	585	1.000		Front Guard Screw
		15363	200	660	1.000		Front Sight Hood
		106605	120	580	1.000		Magazine Assy

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Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
		92508	230	585	1.000		Magazine Follower
		91133	240	585	1.000		Magazine Spring
		21728	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
		28460	505	606	2.000		TEST ROUND 17 REM 25 gr.HPPL
		28460	370	606	3.500		TARGET ROUND 17 REM 25 gr.HPPL
		26345	190	580	1.000		Trigger Assembly
		99689	210	585	1.000		Trigger Guard Assy
26023							700 BDL - 222 REM Embellished
		301049	502	676	1.000		Cable Lock
		107841	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
		3487	400	585	1.000		Build To Tag
		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
		99413	388	676	1.000		EMBELLISHMENT ROYALTY - RECEIVER
		97138	440	435	1.000		Extractor
		305631	180	580	1.000		Firing Pin Assy
		98886	350	585	1.000		Floor Plate Insert
		104127	310	585	1.000		Front Guard Screw
		15363	70	600	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
		21696	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

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Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
		94241	250	593	2.000		Swivel Screw Spacer
		21303	505	606	2.000		TEST ROUND 223 REM 50 gr.PSP
		21303	370	606	3.500		TARGET ROUND 223 REM 50 gr.PSP
		26345	190	580	1.000		Trigger Assembly
		99689	210	585	1.000		Trigger Guard Assy
26027							700 BDL - 223 REM Embellished
		301049	502	676	1.000		Cable Lock
		107842	37	405	1.000		Barrel Assembly
		28710	47	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
		3487	400	585	1.000		Build To Tag
		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
		99413	380	676	1.000		EMBELLISHMENT ROYALTY - RECEIVER
		97138	440	440	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	650	1.100		PROOF ROUND
		104126	300	585	1.000		Rear Guard Screw
		17034	140	580	1.000		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
		99689	210	585	1.000		Trigger Guard Assy
26025							700 BDL - 22-250 REM Embellished
		301049	502	676	1.000		Cable Lock

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Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
		107843	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	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
		3487	400	585	1.000		Build To Tag
		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
		99413	380	676	1.000		EMBELLISHMENT ROYALTY - RECEIVER
		93712	440	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	358	606	3.500		TARGET ROUND 22-250 REM 55 gr.HPPL
		26345	190	580	1.000		Trigger Assembly
		99689	210	585	1.000		Trigger Guard Assy
26029							700 BDL - 243 WIN Embellished
		301049	502	676	1.000		Cable Lock
		107844	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	160	580	1.000		Bolt Stop Pin
		15224	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
		3487	400	585	1.000		Build To Tag
		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
		99413	380	676	1.000		EMBELLISHMENT ROYALTY - RECEIVER
		93712	440	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	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
		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
		99689	200	585	1.000		Trigger Guard Assy
26031							700 BDL - 25-06 REM Embellished
		301049	502	676	1.000		Cable Lock
		107846	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
		24476	170	580	1.000		Bolt Stop Pin
		15224	30	580	3.000		Bolt Stop Spring
		993002	330	676	1.000		Box & Envelope Label
		3487	400	585	1.000		Build To Tag
		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
		99413	380	676	1.000		EMBELLISHMENT ROYALTY - RECEIVER
		93712	440	435	1.000		Extractor
		305630	150	580	1.000		Firing Pin Assy

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Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
		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
		99690	210	585	1.000		Trigger Guard Assy
26033							700 BBL - 270 WIN Embellished
		301049	502	676	1.000		Cable Lock
		107845	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
		3487	400	585	1.000		Build To Tag
		1444	100	676	1.000		Carton - RF-CF
		3509	20	676	1.000		Instruction Book
		17017	418	440	1.000		Ejector
		94555	420	440	1.000		Ejector Pin
		17019	430	440	1.000		Ejector Spring
		99413	380	676	1.000		EMBELLISHMENT ROYALTY - RECEIVER
		93712	440	435	3.000		Extractor
		305630	100	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

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Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
		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
		99690	210	585	1.000		Trigger Guard Assy
26039							700 BDL - 7MM Rem Mag Embellished
		301049	502	676	1.000		Cable Lock
		107840	67	415	1.000		Barrel Assembly
		33279	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
		993002	330	676	1.000		Box & Envelope Label
		3487	400	585	1.000		Child To Tag
		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	440	432	1.000		Extractor
		99413	380	676	1.000		EMBELLISHMENT ROYALTY - RECEIVER
		27341	450	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	1.150		PROOF ROUND
		104126	300	585	3.000		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
		15358	60	593	2.000		Swivel Screw
		94241	240	593	2.000		Swivel Screw Spacer
		27810	505	606	2.000		TEST ROUND 7MM REM MAG 175 gr.PSPCL
		27810	360	606	3.500		TARGET ROUND 7MM REM MAG 175 gr.PSPCL
		26345	190	580	1.000		Trigger Assembly
		99690	210	585	1.000		Trigger Guard Assy

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Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
26035							700 BDL - 30-06 SPRG Embellished
		301049	502	676	1.000		Cable Lock
		107847	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
		3487	400	585	1.000		Build To Tag
		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
		99413	380	676	1.000		EMBELLISHMENT ROYALTY - RECEIVER
		93712	440	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	1.000		Receiver Plug Screw
		24476	180	580	1.000		Sear Pin
		93617L	280	585	1.000		Stock Assembly
		15358	58	593	2.000		Swivel Screw
		94241	240	583	2.000		Swivel Screw Spacer
		27826	505	606	2.000		TEST ROUND 30-06 SPRG 150 gr.PSPCL
		21403	360	606	1.575		TARGET ROUND 30-06 SPRG 180 gr.SPCL
		26345	190	580	1.000		Trigger Assembly
		99690	210	585	1.000		Trigger Guard Assy
26041							700 BDL - 300 Win Mag Embellished
		301049	502	676	1.000		Cable Lock
		107849	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

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Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
		24475	170	580	1.000		Bolt Stop Pin
		15224	40	580	1.000		Bolt Stop Spring
		993002	330	676	1.000		Box & Envelope Label
		3487	400	585	1.000		Build To Tag
		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
		99413	380	676	1.000		EMBELLISHMENT ROYALTY - RECEIVER
		97322	440	432	1.000		Extractor
		27341	450	432	1.000		Extractor Rivet
		305630	160	580	1.000		Flaring 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	1.000		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
		202345L	280	585	1.000		Stock Assembly
		15358	60	585	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	3.500		TARGET ROUND 300 WIN MAG 180 gr.PSPCL
		26345	190	580	1.000		Trigger Assembly
		99690	210	585	1.000		Trigger Guard Assy
26043							700 BDL - 338 Win Mag Embellished
		301049	502	676	1.000		Cable Lock
		107850	57	415	1.000		Barrel Assembly
		33273	47	415	1.000		Bolt Assembly
		110258	87	427	3.000		Front Sight
		111321	107	427	1.000		Rear Sight Assembly
		28505	117	427	3.000		Sight Screw
		17913	130	580	1.000		Bolt Stop
		24475	160	580	1.000		Bolt Stop Pin
		15224	40	580	1.000		Bolt Stop Spring
		993002	320	676	1.000		Box & Envelope Label
		3487	400	585	1.000		Build To Tag
		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
		99413	380	676	1.000		EMBELLISHMENT ROYALTY - RECEIVER
		97322	440	432	1.000		Extractor
		27341	450	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 ROUNDS
		104126	290	585	1.000		Rear Guard Screw
		17034	140	580	4.000		Receiver Plug Screw
		24476	170	580	1.000		Rear Pin
		202345L	270	585	1.000		Stock Assembly
		15358	60	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	350	606	3.500		TARGET ROUND 338 WIN MAG 250 gr.PSP
		26345	180	580	1.000		Trigger Assembly
		99690	200	585	1.000		Trigger Guard Assy
25817							700 BDL 30-06 SPRG Embellished (UMWA LOGO)
		301049	502	676	1.000		Cable Lock
		107847	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	28	580	1.000		Bolt Stop
		15224	30	580	1.000		Bolt Stop Spring
		24475	40	580	1.000		Bolt Stop Pin
		993008	50	676	1.000		Box & Envelope Label
		34874	60	585	3.000		Build To Tag
		1444	70	676	1.000		Carton - RF-CF
		3509	80	676	1.000		Instruction Book
		17917	30	440	1.000		Ejector
		94555	420	440	1.000		Ejector Pin
		17019	430	440	1.000		Ejector Spring
		99413	130	676	1.000		EMBELLISHMENT ROYALTY - RECEIVER
		97322	140	435	1.000		Extractor
		305630	150	580	1.000		Firing Pin Assy
		104129	180	585	1.000		Front Guard Screw
		15363	170	660	1.000		Front Sight Hood

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Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
		16430	180	580	1.000		Magazine
		92218	190	585	1.000		Magazine Follower
		15677	200	585	1.000		Magazine Spring
		21717	210	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
		200248	250	585	1.000		Stock Assembly (UMWA LOGO)
		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	290	606	3.500		TARGET ROUND 30-06 SPRG 180 gr.SPCL
		26345	300	580	1.000		Trigger Assembly
		99690	310	585	1.000		Trigger Guard Assy
26430							700 BDL - 7MM-08 REM Embellished
		301049	502	676	1.000		Cable Lock
		244900	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
		3487	390	585	1.000		Build To Tag
		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
		104123	200	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
		15625	140	585	1.000		Magazine Spring
		21779	240	600	1.100		PROOF ROUND
		104126	240	585	1.000		Rear Guard Screw
		17034	150	580	4.000		Receiver Plug Screw
		24476	180	580	1.000		Sear Pin
		200248	280	585	1.000		Stock Assembly
		15358	50	593	2.000		Swivel Screw
		94241	240	593	2.000		Swivel Screw Spacer

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Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
		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	190	580	1.000		Trigger Assembly
		26370	210	585	1.000		Trigger Guard Assy
		99413	130	676	1.000		EMBELLISHMENT ROYALTY - RECEIVER
26432							700 BDL - 280 REM Embellished
		301049	502	676	1.000		Cable Lock
		244901	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	150	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
		3487	390	585	1.000		Build Up Tag
		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	155	580	1.000		Firing Pin Assy
		104129	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
		15677	90	585	1.000		Magazine Spring
		21710	330	600	1.075		PROOF ROUND
		104126	290	585	1.000		Rear Guard Screw
		17034	140	560	4.000		Receiver Plug Screw
		24476	170	560	1.000		Sear Pin
		936171	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	160	580	1.000		Trigger Assembly
		26371	200	585	1.000		Trigger Guard Assy
		99413	130	676	1.000		EMBELLISHMENT ROYALTY - RECEIVER
27025							700 CDL - 270 WSM Embellished - NWTf Maple
		301049	502	676	1.000		Cable Lock
		202801	47	400	1.000		Barrel Assembly

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Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
01	1.0	0.0	0.1	0.0	0.1	0	1.0
02	1.0	0.0	0.1	0.0	0.1	0	1.0
03	1.0	0.0	0.1	0.0	0.1	0	1.0
04	1.0	0.0	0.1	0.0	0.1	0	1.0
05	1.0	0.0	0.1	0.0	0.1	0	1.0
06	1.0	0.0	0.1	0.0	0.1	0	1.0
07	1.0	0.0	0.1	0.0	0.1	0	1.0
08	1.0	0.0	0.1	0.0	0.1	0	1.0
09	1.0	0.0	0.1	0.0	0.1	0	1.0
10	1.0	0.0	0.1	0.0	0.1	0	1.0
11	1.0	0.0	0.1	0.0	0.1	0	1.0
12	1.0	0.0	0.1	0.0	0.1	0	1.0
13	1.0	0.0	0.1	0.0	0.1	0	1.0
14	1.0	0.0	0.1	0.0	0.1	0	1.0
15	1.0	0.0	0.1	0.0	0.1	0	1.0
16	1.0	0.0	0.1	0.0	0.1	0	1.0
17	1.0	0.0	0.1	0.0	0.1	0	1.0
18	1.0	0.0	0.1	0.0	0.1	0	1.0
19	1.0	0.0	0.1	0.0	0.1	0	1.0
20	1.0	0.0	0.1	0.0	0.1	0	1.0
21	1.0	0.0	0.1	0.0	0.1	0	1.0
22	1.0	0.0	0.1	0.0	0.1	0	1.0
23	1.0	0.0	0.1	0.0	0.1	0	1.0
24	1.0	0.0	0.1	0.0	0.1	0	1.0
25	1.0	0.0	0.1	0.0	0.1	0	1.0
26	1.0	0.0	0.1	0.0	0.1	0	1.0
27	1.0	0.0	0.1	0.0	0.1	0	1.0
28	1.0	0.0	0.1	0.0	0.1	0	1.0
29	1.0	0.0	0.1	0.0	0.1	0	1.0
30	1.0	0.0	0.1	0.0	0.1	0	1.0
31	1.0	0.0	0.1	0.0	0.1	0	1.0
32	1.0	0.0	0.1	0.0	0.1	0	1.0
33	1.0	0.0	0.1	0.0	0.1	0	1.0
34	1.0	0.0	0.1	0.0	0.1	0	1.0
35	1.0	0.0	0.1	0.0	0.1	0	1.0
36	1.0	0.0	0.1	0.0	0.1	0	1.0
37	1.0	0.0	0.1	0.0	0.1	0	1.0
38	1.0	0.0	0.1	0.0	0.1	0	1.0
39	1.0	0.0	0.1	0.0	0.1	0	1.0
40	1.0	0.0	0.1	0.0	0.1	0	1.0
41	1.0	0.0	0.1	0.0	0.1	0	1.0
42	1.0	0.0	0.1	0.0	0.1	0	1.0
43	1.0	0.0	0.1	0.0	0.1	0	1.0
44	1.0	0.0	0.1	0.0	0.1	0	1.0
45	1.0	0.0	0.1	0.0	0.1	0	1.0
46	1.0	0.0	0.1	0.0	0.1	0	1.0
47	1.0	0.0	0.1	0.0	0.1	0	1.0
48	1.0	0.0	0.1	0.0	0.1	0	1.0
49	1.0	0.0	0.1	0.0	0.1	0	1.0
50	1.0	0.0	0.1	0.0	0.1	0	1.0
51	1.0	0.0	0.1	0.0	0.1	0	1.0
52	1.0	0.0	0.1	0.0	0.1	0	1.0
53	1.0	0.0	0.1	0.0	0.1	0	1.0
54	1.0	0.0	0.1	0.0	0.1	0	1.0
55	1.0	0.0	0.1	0.0	0.1	0	1.0
56	1.0	0.0	0.1	0.0	0.1	0	1.0
57	1.0	0.0	0.1	0.0	0.1	0	1.0
58	1.0	0.0	0.1	0.0	0.1	0	1.0
59	1.0	0.0	0.1	0.0	0.1	0	1.0
60	1.0	0.0	0.1	0.0	0.1	0	1.0
61	1.0	0.0	0.1	0.0	0.1	0	1

Printed on:
~AUTODATE

Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
01	1.0	0.5	0.1	0.5	0.1	0	1.0
02	1.0	0.5	0.1	0.5	0.1	0	1.0
03	1.0	0.5	0.1	0.5	0.1	0	1.0
04	1.0	0.5	0.1	0.5	0.1	0	1.0
05	1.0	0.5	0.1	0.5	0.1	0	1.0
06	1.0	0.5	0.1	0.5	0.1	0	1.0
07	1.0	0.5	0.1	0.5	0.1	0	1.0
08	1.0	0.5	0.1	0.5	0.1	0	1.0
09	1.0	0.5	0.1	0.5	0.1	0	1.0
10	1.0	0.5	0.1	0.5	0.1	0	1.0
11	1.0	0.5	0.1	0.5	0.1	0	1.0
12	1.0	0.5	0.1	0.5	0.1	0	1.0
13	1.0	0.5	0.1	0.5	0.1	0	1.0
14	1.0	0.5	0.1	0.5	0.1	0	1.0
15	1.0	0.5	0.1	0.5	0.1	0	1.0
16	1.0	0.5	0.1	0.5	0.1	0	1.0
17	1.0	0.5	0.1	0.5	0.1	0	1.0
18	1.0	0.5	0.1	0.5	0.1	0	1.0
19	1.0	0.5	0.1	0.5	0.1	0	1.0
20	1.0	0.5	0.1	0.5	0.1	0	1.0
21	1.0	0.5	0.1	0.5	0.1	0	1.0
22	1.0	0.5	0.1	0.5	0.1	0	1.0
23	1.0	0.5	0.1	0.5	0.1	0	1.0
24	1.0	0.5	0.1	0.5	0.1	0	1.0
25	1.0	0.5	0.1	0.5	0.1	0	1.0
26	1.0	0.5	0.1	0.5	0.1	0	1.0
27	1.0	0.5	0.1	0.5	0.1	0	1.0
28	1.0	0.5	0.1	0.5	0.1	0	1.0
29	1.0	0.5	0.1	0.5	0.1	0	1.0
30	1.0	0.5	0.1	0.5	0.1	0	1.0
31	1.0	0.5	0.1	0.5	0.1	0	1.0
32	1.0	0.5	0.1	0.5	0.1	0	1.0
33	1.0	0.5	0.1	0.5	0.1	0	1.0
34	1.0	0.5	0.1	0.5	0.1	0	1.0
35	1.0	0.5	0.1	0.5	0.1	0	1.0
36	1.0	0.5	0.1	0.5	0.1	0	1.0
37	1.0	0.5	0.1	0.5	0.1	0	1.0
38	1.0	0.5	0.1	0.5	0.1	0	1.0
39	1.0	0.5	0.1	0.5	0.1	0	1.0
40	1.0	0.5	0.1	0.5	0.1	0	1.0
41	1.0	0.5	0.1	0.5	0.1	0	1.0
42	1.0	0.5	0.1	0.5	0.1	0	1.0
43	1.0	0.5	0.1	0.5	0.1	0	1.0
44	1.0	0.5	0.1	0.5	0.1	0	1.0
45	1.0	0.5	0.1	0.5	0.1	0	1.0
46	1.0	0.5	0.1	0.5	0.1	0	1.0
47	1.0	0.5	0.1	0.5	0.1	0	1.0
48	1.0	0.5	0.1	0.5	0.1	0	1.0
49	1.0	0.5	0.1	0.5	0.1	0	1.0
50	1.0	0.5	0.1	0.5	0.1	0	1.0
51	1.0	0.5	0.1	0.5	0.1	0	1.0
52	1.0	0.5	0.1	0.5	0.1	0	1.0
53	1.0	0.5	0.1	0.5	0.1	0	1.0
54	1.0	0.5	0.1	0.5	0.1	0	1.0
55	1.0	0.5	0.1	0.5	0.1	0	1.0
56	1.0	0.5	0.1	0.5	0.1	0	1.0
57	1.0	0.5	0.1	0.5	0.1	0	1.0
58	1.0	0.5	0.1	0.5	0.1	0	1.0
59	1.0	0.5	0.1	0.5	0.1	0	1.0
60	1.0	0.5	0.1	0.5	0.1	0	1.0
61	1.0	0.5	0.1	0.5	0.1	0	1

Printed on:
~AUTODATE

Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
01	1.0	0.0	0.1	0.0	0.1	0	1.0
02	1.0	0.0	0.1	0.0	0.1	0	1.0
03	1.0	0.0	0.1	0.0	0.1	0	1.0
04	1.0	0.0	0.1	0.0	0.1	0	1.0
05	1.0	0.0	0.1	0.0	0.1	0	1.0
06	1.0	0.0	0.1	0.0	0.1	0	1.0
07	1.0	0.0	0.1	0.0	0.1	0	1.0
08	1.0	0.0	0.1	0.0	0.1	0	1.0
09	1.0	0.0	0.1	0.0	0.1	0	1.0
10	1.0	0.0	0.1	0.0	0.1	0	1.0
11	1.0	0.0	0.1	0.0	0.1	0	1.0
12	1.0	0.0	0.1	0.0	0.1	0	1.0
13	1.0	0.0	0.1	0.0	0.1	0	1.0
14	1.0	0.0	0.1	0.0	0.1	0	1.0
15	1.0	0.0	0.1	0.0	0.1	0	1.0
16	1.0	0.0	0.1	0.0	0.1	0	1.0
17	1.0	0.0	0.1	0.0	0.1	0	1.0
18	1.0	0.0	0.1	0.0	0.1	0	1.0
19	1.0	0.0	0.1	0.0	0.1	0	1.0
20	1.0	0.0	0.1	0.0	0.1	0	1.0
21	1.0	0.0	0.1	0.0	0.1	0	1.0
22	1.0	0.0	0.1	0.0	0.1	0	1.0
23	1.0	0.0	0.1	0.0	0.1	0	1.0
24	1.0	0.0	0.1	0.0	0.1	0	1.0
25	1.0	0.0	0.1	0.0	0.1	0	1.0
26	1.0	0.0	0.1	0.0	0.1	0	1.0
27	1.0	0.0	0.1	0.0	0.1	0	1.0
28	1.0	0.0	0.1	0.0	0.1	0	1.0
29	1.0	0.0	0.1	0.0	0.1	0	1.0
30	1.0	0.0	0.1	0.0	0.1	0	1.0
31	1.0	0.0	0.1	0.0	0.1	0	1.0
32	1.0	0.0	0.1	0.0	0.1	0	1.0
33	1.0	0.0	0.1	0.0	0.1	0	1.0
34	1.0	0.0	0.1	0.0	0.1	0	1.0
35	1.0	0.0	0.1	0.0	0.1	0	1.0
36	1.0	0.0	0.1	0.0	0.1	0	1.0
37	1.0	0.0	0.1	0.0	0.1	0	1.0
38	1.0	0.0	0.1	0.0	0.1	0	1.0
39	1.0	0.0	0.1	0.0	0.1	0	1.0
40	1.0	0.0	0.1	0.0	0.1	0	1.0
41	1.0	0.0	0.1	0.0	0.1	0	1.0
42	1.0	0.0	0.1	0.0	0.1	0	1.0
43	1.0	0.0	0.1	0.0	0.1	0	1.0
44	1.0	0.0	0.1	0.0	0.1	0	1.0
45	1.0	0.0	0.1	0.0	0.1	0	1.0
46	1.0	0.0	0.1	0.0	0.1	0	1.0
47	1.0	0.0	0.1	0.0	0.1	0	1.0
48	1.0	0.0	0.1	0.0	0.1	0	1.0
49	1.0	0.0	0.1	0.0	0.1	0	1.0
50	1.0	0.0	0.1	0.0	0.1	0	1.0
51	1.0	0.0	0.1	0.0	0.1	0	1.0
52	1.0	0.0	0.1	0.0	0.1	0	1.0
53	1.0	0.0	0.1	0.0	0.1	0	1.0
54	1.0	0.0	0.1	0.0	0.1	0	1.0
55	1.0	0.0	0.1	0.0	0.1	0	1.0
56	1.0	0.0	0.1	0.0	0.1	0	1.0
57	1.0	0.0	0.1	0.0	0.1	0	1.0
58	1.0	0.0	0.1	0.0	0.1	0	1.0
59	1.0	0.0	0.1	0.0	0.1	0	1.0
60	1.0	0.0	0.1	0.0	0.1	0	1.0
61	1.0	0.0	0.1	0.0	0.1	0	1

Printed on:
~AUTODATE

Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
01	1.0	0.5	0.1	0.5	0.1	0	1.0
02	1.0	0.5	0.1	0.5	0.1	0	1.0
03	1.0	0.5	0.1	0.5	0.1	0	1.0
04	1.0	0.5	0.1	0.5	0.1	0	1.0
05	1.0	0.5	0.1	0.5	0.1	0	1.0
06	1.0	0.5	0.1	0.5	0.1	0	1.0
07	1.0	0.5	0.1	0.5	0.1	0	1.0
08	1.0	0.5	0.1	0.5	0.1	0	1.0
09	1.0	0.5	0.1	0.5	0.1	0	1.0
10	1.0	0.5	0.1	0.5	0.1	0	1.0
11	1.0	0.5	0.1	0.5	0.1	0	1.0
12	1.0	0.5	0.1	0.5	0.1	0	1.0
13	1.0	0.5	0.1	0.5	0.1	0	1.0
14	1.0	0.5	0.1	0.5	0.1	0	1.0
15	1.0	0.5	0.1	0.5	0.1	0	1.0
16	1.0	0.5	0.1	0.5	0.1	0	1.0
17	1.0	0.5	0.1	0.5	0.1	0	1.0
18	1.0	0.5	0.1	0.5	0.1	0	1.0
19	1.0	0.5	0.1	0.5	0.1	0	1.0
20	1.0	0.5	0.1	0.5	0.1	0	1.0
21	1.0	0.5	0.1	0.5	0.1	0	1.0
22	1.0	0.5	0.1	0.5	0.1	0	1.0
23	1.0	0.5	0.1	0.5	0.1	0	1.0
24	1.0	0.5	0.1	0.5	0.1	0	1.0
25	1.0	0.5	0.1	0.5	0.1	0	1.0
26	1.0	0.5	0.1	0.5	0.1	0	1.0
27	1.0	0.5	0.1	0.5	0.1	0	1.0
28	1.0	0.5	0.1	0.5	0.1	0	1.0
29	1.0	0.5	0.1	0.5	0.1	0	1.0
30	1.0	0.5	0.1	0.5	0.1	0	1.0
31	1.0	0.5	0.1	0.5	0.1	0	1.0
32	1.0	0.5	0.1	0.5	0.1	0	1.0
33	1.0	0.5	0.1	0.5	0.1	0	1.0
34	1.0	0.5	0.1	0.5	0.1	0	1.0
35	1.0	0.5	0.1	0.5	0.1	0	1.0
36	1.0	0.5	0.1	0.5	0.1	0	1.0
37	1.0	0.5	0.1	0.5	0.1	0	1.0
38	1.0	0.5	0.1	0.5	0.1	0	1.0
39	1.0	0.5	0.1	0.5	0.1	0	1.0
40	1.0	0.5	0.1	0.5	0.1	0	1.0
41	1.0	0.5	0.1	0.5	0.1	0	1.0
42	1.0	0.5	0.1	0.5	0.1	0	1.0
43	1.0	0.5	0.1	0.5	0.1	0	1.0
44	1.0	0.5	0.1	0.5	0.1	0	1.0
45	1.0	0.5	0.1	0.5	0.1	0	1.0
46	1.0	0.5	0.1	0.5	0.1	0	1.0
47	1.0	0.5	0.1	0.5	0.1	0	1.0
48	1.0	0.5	0.1	0.5	0.1	0	1.0
49	1.0	0.5	0.1	0.5	0.1	0	1.0
50	1.0	0.5	0.1	0.5	0.1	0	1.0
51	1.0	0.5	0.1	0.5	0.1	0	1.0
52	1.0	0.5	0.1	0.5	0.1	0	1.0
53	1.0	0.5	0.1	0.5	0.1	0	1.0
54	1.0	0.5	0.1	0.5	0.1	0	1.0
55	1.0	0.5	0.1	0.5	0.1	0	1.0
56	1.0	0.5	0.1	0.5	0.1	0	1.0
57	1.0	0.5	0.1	0.5	0.1	0	1.0
58	1.0	0.5	0.1	0.5	0.1	0	1.0
59	1.0	0.5	0.1	0.5	0.1	0	1.0
60	1.0	0.5	0.1	0.5	0.1	0	1.0
61	1.0	0.5	0.1	0.5	0.1	0	1

Printed on:
~AUTODATE

Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
01	1.0	0.5	0.1	0.5	0.1	0	1.0
02	1.0	0.5	0.1	0.5	0.1	0	1.0
03	1.0	0.5	0.1	0.5	0.1	0	1.0
04	1.0	0.5	0.1	0.5	0.1	0	1.0
05	1.0	0.5	0.1	0.5	0.1	0	1.0
06	1.0	0.5	0.1	0.5	0.1	0	1.0
07	1.0	0.5	0.1	0.5	0.1	0	1.0
08	1.0	0.5	0.1	0.5	0.1	0	1.0
09	1.0	0.5	0.1	0.5	0.1	0	1.0
10	1.0	0.5	0.1	0.5	0.1	0	1.0
11	1.0	0.5	0.1	0.5	0.1	0	1.0
12	1.0	0.5	0.1	0.5	0.1	0	1.0
13	1.0	0.5	0.1	0.5	0.1	0	1.0
14	1.0	0.5	0.1	0.5	0.1	0	1.0
15	1.0	0.5	0.1	0.5	0.1	0	1.0
16	1.0	0.5	0.1	0.5	0.1	0	1.0
17	1.0	0.5	0.1	0.5	0.1	0	1.0
18	1.0	0.5	0.1	0.5	0.1	0	1.0
19	1.0	0.5	0.1	0.5	0.1	0	1.0
20	1.0	0.5	0.1	0.5	0.1	0	1.0
21	1.0	0.5	0.1	0.5	0.1	0	1.0
22	1.0	0.5	0.1	0.5	0.1	0	1.0
23	1.0	0.5	0.1	0.5	0.1	0	1.0
24	1.0	0.5	0.1	0.5	0.1	0	1.0
25	1.0	0.5	0.1	0.5	0.1	0	1.0
26	1.0	0.5	0.1	0.5	0.1	0	1.0
27	1.0	0.5	0.1	0.5	0.1	0	1.0
28	1.0	0.5	0.1	0.5	0.1	0	1.0
29	1.0	0.5	0.1	0.5	0.1	0	1.0
30	1.0	0.5	0.1	0.5	0.1	0	1.0
31	1.0	0.5	0.1	0.5	0.1	0	1.0
32	1.0	0.5	0.1	0.5	0.1	0	1.0
33	1.0	0.5	0.1	0.5	0.1	0	1.0
34	1.0	0.5	0.1	0.5	0.1	0	1.0
35	1.0	0.5	0.1	0.5	0.1	0	1.0
36	1.0	0.5	0.1	0.5	0.1	0	1.0
37	1.0	0.5	0.1	0.5	0.1	0	1.0
38	1.0	0.5	0.1	0.5	0.1	0	1.0
39	1.0	0.5	0.1	0.5	0.1	0	1.0
40	1.0	0.5	0.1	0.5	0.1	0	1.0
41	1.0	0.5	0.1	0.5	0.1	0	1.0
42	1.0	0.5	0.1	0.5	0.1	0	1.0
43	1.0	0.5	0.1	0.5	0.1	0	1.0
44	1.0	0.5	0.1	0.5	0.1	0	1.0
45	1.0	0.5	0.1	0.5	0.1	0	1.0
46	1.0	0.5	0.1	0.5	0.1	0	1.0
47	1.0	0.5	0.1	0.5	0.1	0	1.0
48	1.0	0.5	0.1	0.5	0.1	0	1.0
49	1.0	0.5	0.1	0.5	0.1	0	1.0
50	1.0	0.5	0.1	0.5	0.1	0	1.0
51	1.0	0.5	0.1	0.5	0.1	0	1.0
52	1.0	0.5	0.1	0.5	0.1	0	1.0
53	1.0	0.5	0.1	0.5	0.1	0	1.0
54	1.0	0.5	0.1	0.5	0.1	0	1.0
55	1.0	0.5	0.1	0.5	0.1	0	1.0
56	1.0	0.5	0.1	0.5	0.1	0	1.0
57	1.0	0.5	0.1	0.5	0.1	0	1.0
58	1.0	0.5	0.1	0.5	0.1	0	1.0
59	1.0	0.5	0.1	0.5	0.1	0	1.0
60	1.0	0.5	0.1	0.5	0.1	0	1.0
61	1.0	0.5	0.1	0.5	0.1	0	1

Printed on:
~AUTODATE

Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
01	1.0	0.0	0.1	0.0	0.1	0	1.0
02	1.0	0.0	0.1	0.0	0.1	0	1.0
03	1.0	0.0	0.1	0.0	0.1	0	1.0
04	1.0	0.0	0.1	0.0	0.1	0	1.0
05	1.0	0.0	0.1	0.0	0.1	0	1.0
06	1.0	0.0	0.1	0.0	0.1	0	1.0
07	1.0	0.0	0.1	0.0	0.1	0	1.0
08	1.0	0.0	0.1	0.0	0.1	0	1.0
09	1.0	0.0	0.1	0.0	0.1	0	1.0
10	1.0	0.0	0.1	0.0	0.1	0	1.0
11	1.0	0.0	0.1	0.0	0.1	0	1.0
12	1.0	0.0	0.1	0.0	0.1	0	1.0
13	1.0	0.0	0.1	0.0	0.1	0	1.0
14	1.0	0.0	0.1	0.0	0.1	0	1.0
15	1.0	0.0	0.1	0.0	0.1	0	1.0
16	1.0	0.0	0.1	0.0	0.1	0	1.0
17	1.0	0.0	0.1	0.0	0.1	0	1.0
18	1.0	0.0	0.1	0.0	0.1	0	1.0
19	1.0	0.0	0.1	0.0	0.1	0	1.0
20	1.0	0.0	0.1	0.0	0.1	0	1.0
21	1.0	0.0	0.1	0.0	0.1	0	1.0
22	1.0	0.0	0.1	0.0	0.1	0	1.0
23	1.0	0.0	0.1	0.0	0.1	0	1.0
24	1.0	0.0	0.1	0.0	0.1	0	1.0
25	1.0	0.0	0.1	0.0	0.1	0	1.0
26	1.0	0.0	0.1	0.0	0.1	0	1.0
27	1.0	0.0	0.1	0.0	0.1	0	1.0
28	1.0	0.0	0.1	0.0	0.1	0	1.0
29	1.0	0.0	0.1	0.0	0.1	0	1.0
30	1.0	0.0	0.1	0.0	0.1	0	1.0
31	1.0	0.0	0.1	0.0	0.1	0	1.0
32	1.0	0.0	0.1	0.0	0.1	0	1.0
33	1.0	0.0	0.1	0.0	0.1	0	1.0
34	1.0	0.0	0.1	0.0	0.1	0	1.0
35	1.0	0.0	0.1	0.0	0.1	0	1.0
36	1.0	0.0	0.1	0.0	0.1	0	1.0
37	1.0	0.0	0.1	0.0	0.1	0	1.0
38	1.0	0.0	0.1	0.0	0.1	0	1.0
39	1.0	0.0	0.1	0.0	0.1	0	1.0
40	1.0	0.0	0.1	0.0	0.1	0	1.0
41	1.0	0.0	0.1	0.0	0.1	0	1.0
42	1.0	0.0	0.1	0.0	0.1	0	1.0
43	1.0	0.0	0.1	0.0	0.1	0	1.0
44	1.0	0.0	0.1	0.0	0.1	0	1.0
45	1.0	0.0	0.1	0.0	0.1	0	1.0
46	1.0	0.0	0.1	0.0	0.1	0	1.0
47	1.0	0.0	0.1	0.0	0.1	0	1.0
48	1.0	0.0	0.1	0.0	0.1	0	1.0
49	1.0	0.0	0.1	0.0	0.1	0	1.0
50	1.0	0.0	0.1	0.0	0.1	0	1.0
51	1.0	0.0	0.1	0.0	0.1	0	1.0
52	1.0	0.0	0.1	0.0	0.1	0	1.0
53	1.0	0.0	0.1	0.0	0.1	0	1.0
54	1.0	0.0	0.1	0.0	0.1	0	1.0
55	1.0	0.0	0.1	0.0	0.1	0	1.0
56	1.0	0.0	0.1	0.0	0.1	0	1.0
57	1.0	0.0	0.1	0.0	0.1	0	1.0
58	1.0	0.0	0.1	0.0	0.1	0	1.0
59	1.0	0.0	0.1	0.0	0.1	0	1.0
60	1.0	0.0	0.1	0.0	0.1	0	1.0
61	1.0	0.0	0.1	0.0	0.1	0	1

Printed on:
~AUTODATE

Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
01	1.0	0.5	0.1	0.5	0.1	0	1.0
02	1.0	0.5	0.1	0.5	0.1	0	1.0
03	1.0	0.5	0.1	0.5	0.1	0	1.0
04	1.0	0.5	0.1	0.5	0.1	0	1.0
05	1.0	0.5	0.1	0.5	0.1	0	1.0
06	1.0	0.5	0.1	0.5	0.1	0	1.0
07	1.0	0.5	0.1	0.5	0.1	0	1.0
08	1.0	0.5	0.1	0.5	0.1	0	1.0
09	1.0	0.5	0.1	0.5	0.1	0	1.0
10	1.0	0.5	0.1	0.5	0.1	0	1.0
11	1.0	0.5	0.1	0.5	0.1	0	1.0
12	1.0	0.5	0.1	0.5	0.1	0	1.0
13	1.0	0.5	0.1	0.5	0.1	0	1.0
14	1.0	0.5	0.1	0.5	0.1	0	1.0
15	1.0	0.5	0.1	0.5	0.1	0	1.0
16	1.0	0.5	0.1	0.5	0.1	0	1.0
17	1.0	0.5	0.1	0.5	0.1	0	1.0
18	1.0	0.5	0.1	0.5	0.1	0	1.0
19	1.0	0.5	0.1	0.5	0.1	0	1.0
20	1.0	0.5	0.1	0.5	0.1	0	1.0
21	1.0	0.5	0.1	0.5	0.1	0	1.0
22	1.0	0.5	0.1	0.5	0.1	0	1.0
23	1.0	0.5	0.1	0.5	0.1	0	1.0
24	1.0	0.5	0.1	0.5	0.1	0	1.0
25	1.0	0.5	0.1	0.5	0.1	0	1.0
26	1.0	0.5	0.1	0.5	0.1	0	1.0
27	1.0	0.5	0.1	0.5	0.1	0	1.0
28	1.0	0.5	0.1	0.5	0.1	0	1.0
29	1.0	0.5	0.1	0.5	0.1	0	1.0
30	1.0	0.5	0.1	0.5	0.1	0	1.0
31	1.0	0.5	0.1	0.5	0.1	0	1.0
32	1.0	0.5	0.1	0.5	0.1	0	1.0
33	1.0	0.5	0.1	0.5	0.1	0	1.0
34	1.0	0.5	0.1	0.5	0.1	0	1.0
35	1.0	0.5	0.1	0.5	0.1	0	1.0
36	1.0	0.5	0.1	0.5	0.1	0	1.0
37	1.0	0.5	0.1	0.5	0.1	0	1.0
38	1.0	0.5	0.1	0.5	0.1	0	1.0
39	1.0	0.5	0.1	0.5	0.1	0	1.0
40	1.0	0.5	0.1	0.5	0.1	0	1.0
41	1.0	0.5	0.1	0.5	0.1	0	1.0
42	1.0	0.5	0.1	0.5	0.1	0	1.0
43	1.0	0.5	0.1	0.5	0.1	0	1.0
44	1.0	0.5	0.1	0.5	0.1	0	1.0
45	1.0	0.5	0.1	0.5	0.1	0	1.0
46	1.0	0.5	0.1	0.5	0.1	0	1.0
47	1.0	0.5	0.1	0.5	0.1	0	1.0
48	1.0	0.5	0.1	0.5	0.1	0	1.0
49	1.0	0.5	0.1	0.5	0.1	0	1.0
50	1.0	0.5	0.1	0.5	0.1	0	1.0
51	1.0	0.5	0.1	0.5	0.1	0	1.0
52	1.0	0.5	0.1	0.5	0.1	0	1.0
53	1.0	0.5	0.1	0.5	0.1	0	1.0
54	1.0	0.5	0.1	0.5	0.1	0	1.0
55	1.0	0.5	0.1	0.5	0.1	0	1.0
56	1.0	0.5	0.1	0.5	0.1	0	1.0
57	1.0	0.5	0.1	0.5	0.1	0	1.0
58	1.0	0.5	0.1	0.5	0.1	0	1.0
59	1.0	0.5	0.1	0.5	0.1	0	1.0
60	1.0	0.5	0.1	0.5	0.1	0	1.0
61	1.0	0.5	0.1	0.5	0.1	0	1

Printed on:
~AUTODATE

Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
01	1.0	0.5	0.1	0.5	0.1	0	1.0
02	1.0	0.5	0.1	0.5	0.1	0	1.0
03	1.0	0.5	0.1	0.5	0.1	0	1.0
04	1.0	0.5	0.1	0.5	0.1	0	1.0
05	1.0	0.5	0.1	0.5	0.1	0	1.0
06	1.0	0.5	0.1	0.5	0.1	0	1.0
07	1.0	0.5	0.1	0.5	0.1	0	1.0
08	1.0	0.5	0.1	0.5	0.1	0	1.0
09	1.0	0.5	0.1	0.5	0.1	0	1.0
10	1.0	0.5	0.1	0.5	0.1	0	1.0
11	1.0	0.5	0.1	0.5	0.1	0	1.0
12	1.0	0.5	0.1	0.5	0.1	0	1.0
13	1.0	0.5	0.1	0.5	0.1	0	1.0
14	1.0	0.5	0.1	0.5	0.1	0	1.0
15	1.0	0.5	0.1	0.5	0.1	0	1.0
16	1.0	0.5	0.1	0.5	0.1	0	1.0
17	1.0	0.5	0.1	0.5	0.1	0	1.0
18	1.0	0.5	0.1	0.5	0.1	0	1.0
19	1.0	0.5	0.1	0.5	0.1	0	1.0
20	1.0	0.5	0.1	0.5	0.1	0	1.0
21	1.0	0.5	0.1	0.5	0.1	0	1.0
22	1.0	0.5	0.1	0.5	0.1	0	1.0
23	1.0	0.5	0.1	0.5	0.1	0	1.0
24	1.0	0.5	0.1	0.5	0.1	0	1.0
25	1.0	0.5	0.1	0.5	0.1	0	1.0
26	1.0	0.5	0.1	0.5	0.1	0	1.0
27	1.0	0.5	0.1	0.5	0.1	0	1.0
28	1.0	0.5	0.1	0.5	0.1	0	1.0
29	1.0	0.5	0.1	0.5	0.1	0	1.0
30	1.0	0.5	0.1	0.5	0.1	0	1.0
31	1.0	0.5	0.1	0.5	0.1	0	1.0
32	1.0	0.5	0.1	0.5	0.1	0	1.0
33	1.0	0.5	0.1	0.5	0.1	0	1.0
34	1.0	0.5	0.1	0.5	0.1	0	1.0
35	1.0	0.5	0.1	0.5	0.1	0	1.0
36	1.0	0.5	0.1	0.5	0.1	0	1.0
37	1.0	0.5	0.1	0.5	0.1	0	1.0
38	1.0	0.5	0.1	0.5	0.1	0	1.0
39	1.0	0.5	0.1	0.5	0.1	0	1.0
40	1.0	0.5	0.1	0.5	0.1	0	1.0
41	1.0	0.5	0.1	0.5	0.1	0	1.0
42	1.0	0.5	0.1	0.5	0.1	0	1.0
43	1.0	0.5	0.1	0.5	0.1	0	1.0
44	1.0	0.5	0.1	0.5	0.1	0	1.0
45	1.0	0.5	0.1	0.5	0.1	0	1.0
46	1.0	0.5	0.1	0.5	0.1	0	1.0
47	1.0	0.5	0.1	0.5	0.1	0	1.0
48	1.0	0.5	0.1	0.5	0.1	0	1.0
49	1.0	0.5	0.1	0.5	0.1	0	1.0
50	1.0	0.5	0.1	0.5	0.1	0	1.0
51	1.0	0.5	0.1	0.5	0.1	0	1.0
52	1.0	0.5	0.1	0.5	0.1	0	1.0
53	1.0	0.5	0.1	0.5	0.1	0	1.0
54	1.0	0.5	0.1	0.5	0.1	0	1.0
55	1.0	0.5	0.1	0.5	0.1	0	1.0
56	1.0	0.5	0.1	0.5	0.1	0	1.0
57	1.0	0.5	0.1	0.5	0.1	0	1.0
58	1.0	0.5	0.1	0.5	0.1	0	1.0
59	1.0	0.5	0.1	0.5	0.1	0	1.0
60	1.0	0.5	0.1	0.5	0.1	0	1.0
61	1.0	0.5	0.1	0.5	0.1	0	1

Printed on:
~AUTODATE

Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
01	1.0	0.0	0.1	0.0	0.1	0	1.0
02	1.0	0.0	0.1	0.0	0.1	0	1.0
03	1.0	0.0	0.1	0.0	0.1	0	1.0
04	1.0	0.0	0.1	0.0	0.1	0	1.0
05	1.0	0.0	0.1	0.0	0.1	0	1.0
06	1.0	0.0	0.1	0.0	0.1	0	1.0
07	1.0	0.0	0.1	0.0	0.1	0	1.0
08	1.0	0.0	0.1	0.0	0.1	0	1.0
09	1.0	0.0	0.1	0.0	0.1	0	1.0
10	1.0	0.0	0.1	0.0	0.1	0	1.0
11	1.0	0.0	0.1	0.0	0.1	0	1.0
12	1.0	0.0	0.1	0.0	0.1	0	1.0
13	1.0	0.0	0.1	0.0	0.1	0	1.0
14	1.0	0.0	0.1	0.0	0.1	0	1.0
15	1.0	0.0	0.1	0.0	0.1	0	1.0
16	1.0	0.0	0.1	0.0	0.1	0	1.0
17	1.0	0.0	0.1	0.0	0.1	0	1.0
18	1.0	0.0	0.1	0.0	0.1	0	1.0
19	1.0	0.0	0.1	0.0	0.1	0	1.0
20	1.0	0.0	0.1	0.0	0.1	0	1.0
21	1.0	0.0	0.1	0.0	0.1	0	1.0
22	1.0	0.0	0.1	0.0	0.1	0	1.0
23	1.0	0.0	0.1	0.0	0.1	0	1.0
24	1.0	0.0	0.1	0.0	0.1	0	1.0
25	1.0	0.0	0.1	0.0	0.1	0	1.0
26	1.0	0.0	0.1	0.0	0.1	0	1.0
27	1.0	0.0	0.1	0.0	0.1	0	1.0
28	1.0	0.0	0.1	0.0	0.1	0	1.0
29	1.0	0.0	0.1	0.0	0.1	0	1.0
30	1.0	0.0	0.1	0.0	0.1	0	1.0
31	1.0	0.0	0.1	0.0	0.1	0	1.0
32	1.0	0.0	0.1	0.0	0.1	0	1.0
33	1.0	0.0	0.1	0.0	0.1	0	1.0
34	1.0	0.0	0.1	0.0	0.1	0	1.0
35	1.0	0.0	0.1	0.0	0.1	0	1.0
36	1.0	0.0	0.1	0.0	0.1	0	1.0
37	1.0	0.0	0.1	0.0	0.1	0	1.0
38	1.0	0.0	0.1	0.0	0.1	0	1.0
39	1.0	0.0	0.1	0.0	0.1	0	1.0
40	1.0	0.0	0.1	0.0	0.1	0	1.0
41	1.0	0.0	0.1	0.0	0.1	0	1.0
42	1.0	0.0	0.1	0.0	0.1	0	1.0
43	1.0	0.0	0.1	0.0	0.1	0	1.0
44	1.0	0.0	0.1	0.0	0.1	0	1.0
45	1.0	0.0	0.1	0.0	0.1	0	1.0
46	1.0	0.0	0.1	0.0	0.1	0	1.0
47	1.0	0.0	0.1	0.0	0.1	0	1.0
48	1.0	0.0	0.1	0.0	0.1	0	1.0
49	1.0	0.0	0.1	0.0	0.1	0	1.0
50	1.0	0.0	0.1	0.0	0.1	0	1.0
51	1.0	0.0	0.1	0.0	0.1	0	1.0
52	1.0	0.0	0.1	0.0	0.1	0	1.0
53	1.0	0.0	0.1	0.0	0.1	0	1.0
54	1.0	0.0	0.1	0.0	0.1	0	1.0
55	1.0	0.0	0.1	0.0	0.1	0	1.0
56	1.0	0.0	0.1	0.0	0.1	0	1.0
57	1.0	0.0	0.1	0.0	0.1	0	1.0
58	1.0	0.0	0.1	0.0	0.1	0	1.0
59	1.0	0.0	0.1	0.0	0.1	0	1.0
60	1.0	0.0	0.1	0.0	0.1	0	1.0
61	1.0	0.0	0.1	0.0	0.1	0	1

Printed on:
~AUTODATE

Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
01	1.0	0.0	0.1	0.0	0.1	0	1.0
02	1.0	0.0	0.1	0.0	0.1	0	1.0
03	1.0	0.0	0.1	0.0	0.1	0	1.0
04	1.0	0.0	0.1	0.0	0.1	0	1.0
05	1.0	0.0	0.1	0.0	0.1	0	1.0
06	1.0	0.0	0.1	0.0	0.1	0	1.0
07	1.0	0.0	0.1	0.0	0.1	0	1.0
08	1.0	0.0	0.1	0.0	0.1	0	1.0
09	1.0	0.0	0.1	0.0	0.1	0	1.0
10	1.0	0.0	0.1	0.0	0.1	0	1.0
11	1.0	0.0	0.1	0.0	0.1	0	1.0
12	1.0	0.0	0.1	0.0	0.1	0	1.0
13	1.0	0.0	0.1	0.0	0.1	0	1.0
14	1.0	0.0	0.1	0.0	0.1	0	1.0
15	1.0	0.0	0.1	0.0	0.1	0	1.0
16	1.0	0.0	0.1	0.0	0.1	0	1.0
17	1.0	0.0	0.1	0.0	0.1	0	1.0
18	1.0	0.0	0.1	0.0	0.1	0	1.0
19	1.0	0.0	0.1	0.0	0.1	0	1.0
20	1.0	0.0	0.1	0.0	0.1	0	1.0
21	1.0	0.0	0.1	0.0	0.1	0	1.0
22	1.0	0.0	0.1	0.0	0.1	0	1.0
23	1.0	0.0	0.1	0.0	0.1	0	1.0
24	1.0	0.0	0.1	0.0	0.1	0	1.0
25	1.0	0.0	0.1	0.0	0.1	0	1.0
26	1.0	0.0	0.1	0.0	0.1	0	1.0
27	1.0	0.0	0.1	0.0	0.1	0	1.0
28	1.0	0.0	0.1	0.0	0.1	0	1.0
29	1.0	0.0	0.1	0.0	0.1	0	1.0
30	1.0	0.0	0.1	0.0	0.1	0	1.0
31	1.0	0.0	0.1	0.0	0.1	0	1.0
32	1.0	0.0	0.1	0.0	0.1	0	1.0
33	1.0	0.0	0.1	0.0	0.1	0	1.0
34	1.0	0.0	0.1	0.0	0.1	0	1.0
35	1.0	0.0	0.1	0.0	0.1	0	1.0
36	1.0	0.0	0.1	0.0	0.1	0	1.0
37	1.0	0.0	0.1	0.0	0.1	0	1.0
38	1.0	0.0	0.1	0.0	0.1	0	1.0
39	1.0	0.0	0.1	0.0	0.1	0	1.0
40	1.0	0.0	0.1	0.0	0.1	0	1.0
41	1.0	0.0	0.1	0.0	0.1	0	1.0
42	1.0	0.0	0.1	0.0	0.1	0	1.0
43	1.0	0.0	0.1	0.0	0.1	0	1.0
44	1.0	0.0	0.1	0.0	0.1	0	1.0
45	1.0	0.0	0.1	0.0	0.1	0	1.0
46	1.0	0.0	0.1	0.0	0.1	0	1.0
47	1.0	0.0	0.1	0.0	0.1	0	1.0
48	1.0	0.0	0.1	0.0	0.1	0	1.0
49	1.0	0.0	0.1	0.0	0.1	0	1.0
50	1.0	0.0	0.1	0.0	0.1	0	1.0
51	1.0	0.0	0.1	0.0	0.1	0	1.0
52	1.0	0.0	0.1	0.0	0.1	0	1.0
53	1.0	0.0	0.1	0.0	0.1	0	1.0
54	1.0	0.0	0.1	0.0	0.1	0	1.0
55	1.0	0.0	0.1	0.0	0.1	0	1.0
56	1.0	0.0	0.1	0.0	0.1	0	1.0
57	1.0	0.0	0.1	0.0	0.1	0	1.0
58	1.0	0.0	0.1	0.0	0.1	0	1.0
59	1.0	0.0	0.1	0.0	0.1	0	1.0
60	1.0	0.0	0.1	0.0	0.1	0	1.0
61	1.0	0.0	0.1	0.0	0.1	0	1

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Date:	Reason for Revision:	Eng:	Log #:
27-Apr-01	Copied entire process from VAXcamps #304475	RLJ	304220
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
10-Sep-01	Added 26430 - 700 BDL 7mm-08 Rem Embellished and 26432 - 700 BDL 280 Rem Embellished per DCR 014490	RJL	305098
9-Oct-01	Front Sight 110254 was 15373, 110255 was 14659, 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 26039, 26041, 26043	RLJ	305393
19-Dec-01	Added Op 604 to chamber muzzle by hand.	RLJ	305401
3-Apr-02	Trigger pull 4.5 to 6.5 was 4.5 to 5.5	RLJ	305777
20-Apr-02	Corrected Ammo. usage for RAMAC 6430, 7MM-08 cal.	RFL	305783
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 "a. Apply sticker to Gun Tag" - ADD C-47444 - DRAWING LISTING DATE CODE STAMPS	GLC	307035
17-Jul-02	17 Cal Ammo SKU 28460 was 28463.	RLJ	306826
29-Jan-03	CORRECT Rear Sight Assembly Pt#s as follows: PT#111320 was Pt#103145 for RAMACS 26037, 26023, 26027, 26025, 26029, 26031, 26033, 26035, 25817, 26430, & 26432 PT#111321 was Pt#103148 for RAMACS 26039, 26041, & 26043	GLC	308535
10-Feb-03	Updated to current practice (details only) - Updated Description in Op. 440 & 585 (Router)	ERF	307607

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Date:	Reason for Revision:	Eng:	Log #:
11-Aug-03	Added Line-0-Sighter part number to process OP. # 606	RFL	306911
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
23-Jun-04	Replaced ISS Firing Pin Assy with Non-ISS Fluted Firing Pin Assy. 109575 now 305630, 109576 now 305631.	RLJ	311851
26-Jul-04	Trigger pull 4.75 to 5.75 pounds was 4.5 to 5.5 pounds. Trigger pull revised to compensate for a change in the direction of pull. - 4.5 pounds Min was used when trigger pull was measured in the direction of the top of the stock comb. - New SAAMI trigger pull standard requires the trigger to be pulled parallel to the centerline of the barrel. This results in the minimum trigger pull being changed to 4.75 pounds and the maximum trigger pull being changed to 5.75 pounds.	RLJ	311856
26-Jul-04	Added cable lock 301049, removed IFS Gunlock keys (2) 201207, removed procedure for checking gunlock function and added 35 in-lb spec for takedown screw.	RLJ	311858
21-Oct-04	OP#400, 405, 415 & 650 - UPDATE INFO AND REESTABLISH LINKS FOR HEADING PLUGS	GLC	312984
8-Dec-04	ADD OP#395 FOR ALL PART #'S REMOVE INSPECTION INFO FROM OP#400,405,& 415	GLC	313346
3-Jan-05	OP 580 added weigh trigger pull; OP 585, 640, 648 added pull scale verification procedure	DWB	313312
17-Feb-05	Changed stock number - F113135 from F300394	ERF	311625
16-Jul-05	RAMAC#26039 26041 & 26043 - Stock Assy PT#202345L WAS 113135	GLC	315285
2-Aug-05	Added SKU #27029 per NPP #2005-80.	MFS	315250
16-Aug-05	RAMAC#26037 26023 26027 26025 26029 26430 Stock Assembly PT#93616L WAS 103600	GLC	315322

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Date:		Reason for Revision:	Eng:	Log #:
11-Oct-05	11	Stock Assy 93617L was 103601	DLB	315380
01	10		01	01
02	10		01	01
03	10		01	01
04	10		01	01
05	10		01	01
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100	10		01	01

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Date:		Reason for Revision:		Eng:		Log #:	
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100	100	100	100	100	100	100	100

Comprehensive Project Overview and Key Milestones									
Project Identification		Detailed Task Breakdown				Resource Allocation and Status			
Dept	Num	Procedure by Steps				Safety Key Points			
A	01	1	2	3	4	5	6	7	8
B	02	1	2	3	4	5	6	7	8
C	03	1	2	3	4	5	6	7	8
D	04	1	2	3	4	5	6	7	8
E	05	1	2	3	4	5	6	7	8
F	06	1	2	3	4	5	6	7	8
G	07	1	2	3	4	5	6	7	8
H	08	1	2	3	4	5	6	7	8
I	09	1	2	3	4	5	6	7	8
J	10	1	2	3	4	5	6	7	8
K	11	1	2	3	4	5	6	7	8
L	12	1	2	3	4	5	6	7	8
M	13	1	2	3	4	5	6	7	8
N	14	1	2	3	4	5	6	7	8
O	15	1	2	3	4	5	6	7	8
P	16	1	2	3	4	5	6	7	8
Q	17	1	2	3	4	5	6	7	8
R	18	1	2	3	4	5	6	7	8
S	19	1	2	3	4	5	6	7	8
T	20	1	2	3	4	5	6	7	8
U	21	1	2	3	4	5	6	7	8
V	22	1	2	3	4	5	6	7	8
W	23	1	2	3	4	5	6	7	8
X	24	1	2	3	4	5	6	7	8
Y	25	1	2	3	4	5	6	7	8
Z	26	1	2	3	4	5	6	7	8
AA	27	1	2	3	4	5	6	7	8
AB	28	1	2	3	4	5	6	7	8
AC	29	1	2	3	4	5	6	7	8
AD	30	1	2	3	4	5	6	7	8
AE	31	1	2	3	4	5	6	7	8
AF	32	1	2	3	4	5	6	7	8
AG	33	1	2	3	4	5	6	7	8
AH	34	1	2	3	4	5	6	7	8
AI	35	1	2	3	4	5	6	7	8
AJ	36	1	2	3	4	5	6	7	8
AK	37	1	2	3	4	5	6	7	8
AL	38	1	2	3	4	5	6	7	8
AM	39	1	2	3	4	5	6	7	8
AN	40	1	2	3	4	5	6	7	8
AO	41	1	2	3	4	5	6	7	8
AP	42	1	2	3	4	5	6	7	8
AQ	43	1	2	3	4	5	6	7	8
AR	44	1	2	3	4	5	6	7	8
AS	45	1	2	3	4	5	6	7	8
AT	46	1	2	3	4	5	6	7	8
AU	47	1	2	3	4	5	6	7	8
AV	48	1	2	3	4	5	6	7	8
AW	49	1	2	3	4	5	6	7	8
AX	50	1	2	3	4	5	6	7	8
AY	51	1	2	3	4	5	6	7	8
AZ	52	1	2	3	4	5	6	7	8
BA	53	1	2	3	4	5	6	7	8
BB	54	1	2	3	4	5	6	7	8
BC	55	1	2	3	4	5	6	7	8
BD	56	1	2	3	4	5	6	7	8
BE	57	1	2	3	4	5	6	7	8
BF	58	1	2	3	4	5	6	7	8
BG	59	1	2	3	4	5	6	7	8
BH	60	1	2	3	4	5	6	7	8
BI	61	1	2	3	4	5	6	7	8
BJ	62	1	2	3	4	5	6	7	8

[illegible]

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

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

PROCESS CONTROL INSPECTION RECORD				Revision: 12-Oct-05		Inspected by:	
THIS RECORD MUST REMAIN IN HEAT TREAT INSPECTION FOR ONE YEAR				Part No:		Prod. Qty:	
Part Name: Fin Assy 700 BDL EMB Centrefire Rifle				Inspection Date:		Production Order #:	
Operation No. Part No:		Operation:		Part Name:		Work Center:	
Furnace and Load Number		Draw Temp		Furnace Date		Inspection Date: 8/14/2006	
Hardness Specification		Hardness Specification		Hardness Specification		Break Test	
HRC		H15n		H45n		INSPECT REJECT	
HRC		H15n		H45n		Break Test Results (lbs)	
Tester No		Tester No		Tester No		Tester No	
35		60		81		37	
36		61		82		38	
37		62		83		39	
38		63		84		40	
39		64		85		41	
40		65		86		42	
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49		74		95		51	
50		75		96		52	
51		76		97		53	
52		77		98		54	
53		78		99		55	
54		79		100		56	

Sample Plan		
Lot Size	Sample Size	Allowable Outside
1-5	All	0
6-50	6	0
51-100	7	0
101-200	7	0
201-800	16	1
801-3000	17	1
3001-20000	27	2

35	80	101	57	Rev 0
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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:

CONFIDENTIAL

CONFIDENTIAL

—

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