

Remington Arms Company, Inc.
Manufacturing Process Document

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

Effective Date: 12-Oct-05
Origination Date: 7-Feb-93

General Instructions:

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

Process Routing Table:

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

INSPECT COMPONENTS BEFORE HEADING
Fit and Head Bolt Assembly to Barrel Assy REG
Fit and Head Bolt Assembly to Barrel Assy SMALL
Fit and Head Bolt Assembly to Barrel Assy MAGS
Ream Chamber to Deburr
Make Chamber Cast (Not Done on 100% of product)
Assemble Rear Sight Assembly and Front Sight
Assemble Front & Rear Scope Bases to Barrel
Ream Ejector Hole
Form Radius on Edge of Firing Pin Hole
Assemble Riveted Extractor to Bolt - (MAGNUMS)
Assemble Rivetless Extractor to Bolt
Assemble to Bolt with Ejector Cross Pin
460R Strip Defective Barrel Assembly Complete
Strip Defective Bolt
Assemble Action
to Barrel
Assemble Action
to Trigger Guard
Spacer to Stock
Proof Test
Proof Test with slave bolt
Proof Stamp, Prick Punch and Obstruction In
Test and Target (REG SIGHTS)
Test and Target
Attach scope rings, scope and bore sight
Inspect For Live Ammunition
Final Inspection (ADL)
Final Inspection
Reset trigger pull within specs as needed.

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Inspect Heading and Sear Lift
Number Using Dot Peen Marking Machine
Assemble Rear Swivel and Swivel Screw Spacer
blast.
PACK MTN GUNS
PACK REG GUNS
PACK SCOPED GUNS

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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 SS		Centerfire Rifle			Date: 8/14/2006	
Operation No: (Enter Oper #)		Operation: (Enter the Operation Name in this field)					Work Center:
Prod. Qty:	Prod. Order #:		Operator			Setup inspected by & Date:	
Gage Description and Characteristic	Gage Number	Gage Frequency	1st Shift	2nd Shift	3rd Shift	Remarks, Causes, Action Taken, Etc.	
VISUAL	VISUAL	100%	INSPECT REJECT				

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395 INSPECT COMPONENTS BEFORE HEADING

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

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

PROCESS CONTROL INSPECTION RECORD THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES			Revision Date: 12-Oct-05			Processed by:
Part No:	Part Name: Fin Assy 700 SS		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

Operation Step Detail Operation: 400

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

Step Operation / Step Description

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

NOTE: STAINLESS BOLT ASSEMBLIES WILL HAVE AN IDENTIFICATION RING OR UNDER-
CUT INSIDE THE BOLT COUNTERBORE AT THE REAR, THE BOLT HEAD WILL
ALSO BE BLACK IN COLOR WITH A STEEL GRAY BOLT BODY. THE STAINLESS
BARREL ASSEMBLY WILL HAVE 'S' IN THE SERIAL NUMBER.

- 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).

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

Operation Tool Detail

Operation: 400

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Tool Number	Tooling Description
E-76039	Machinist
D-46967	Fixture
STD	LB2000 ACCU-LUBE
STD	STEELCARD 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 - 25-06 REM

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D-49577-M REAMER (replaces B-37794)
A-41281 COLLAR
B-90098-U SHANK

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

STD Caliber - 260 REM

D-49577-W REAMER
A-41281 COLLAR
B-90098-R SHANK

C-41560-A 30-06 MIN Heading Plug
C-41560-B 30-06 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-41556-A 308 WIN MIN Heading Plug
C-41556-B 308 WIN WMAX Heading Plug
C-41560-A 25-06 REM MIN Heading Plug
C-41560-B 25-06 REM WMAX Heading Plug
C-41543-A 257 ROBERTS MIN Heading Plug
C-41543-B 257 ROBERTS WMAX Heading Plug
C-41556-A 7MM-08 REM MIN Heading Plug
C-41556-B 7MM-08 REM WMAX Heading Plug

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 SS		Centerfire Rifle			Date: 8/14/2006
Operation No: 400	Operation: Fit and Head Bolt Assembly to Barrel Assembly					Work Center:
Prod. Qty:	Prod. Order #:	Operator			Setup Inspected by & Date:	
Gage Description and Characteristic	Gage Number	Gage Frequency	1st Shift	2nd Shift	3rd Shift	Remarks, Causes, Action Taken, Etc.
VISUAL	VISUAL	100%	INSPECT REJECT			
30-06 MIN Heading Plug	C-41560-A	100%	INSPECT REJECT			
30-06 WMAX Heading Plug	C-41560-B	100%	INSPECT REJECT			
30-06 MIN Heading Plug	C-41560-A	100%	INSPECT REJECT			
30-06 WMAX Heading Plug	C-41560-B	100%	INSPECT REJECT			
30-06 MIN Heading Plug	C-41560-A	100%	INSPECT REJECT			
30-06 WMAX Heading Plug	C-41560-B	100%	INSPECT REJECT			
30-06 MIN Heading Plug	C-41560-A	100%	INSPECT REJECT			
30-06 WMAX Heading Plug	C-41560-B	100%	INSPECT REJECT			
270 WIN MIN Heading Plug	C-41560-A	100%	INSPECT REJECT			

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			INSPECT			
270 WIN 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			
270 WIN MIN Heading Plug	C-41560-A	100%	REJECT INSPECT			
270 WIN 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			
280 REM MIN Heading Plug	C-41544-A	100%	REJECT INSPECT			
280 REM WMAX Heading Plug	C-41544-B	100%	REJECT INSPECT			
280 REM MIN Heading Plug	C-41544-A	100%	REJECT INSPECT			
280 REM WMAX Heading Plug	C-41544-B	100%	REJECT INSPECT			
308 WIN MIN Heading Plug	C-41556-A	100%	REJECT			

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			INSPECT			
308 WIN WMAX Heading Plug	C-41556-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			
25-06 REM MIN Heading Plug	C-41560-A	100%	REJECT INSPECT			
25-06 REM WMAX Heading Plug	C-41560-B	100%	REJECT INSPECT			
257 ROBERTS MIN Heading Plug	C-41543-A	100%	REJECT INSPECT			
257 ROBERTS WMAX Heading Plug	C-41543-B	100%	REJECT INSPECT			
7MM-08 REM MIN Heading Plug	C-41556-A	100%	REJECT INSPECT			
7MM-08 REM WMAX Heading Plug	C-41556-B	100%	REJECT INSPECT			
			REJECT INSPECT			
			REJECT INSPECT			
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			REJECT			

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405 Fit and Head Bolt Assembly to Barrel Assembly

Operation Step Detail Operation: 405

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

Step Operation / Step Description

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

NOTE: STAINLESS BOLT ASSEMBLIES WILL HAVE AN IDENTIFICATION RING OR UNDER-
CUT INSIDE THE BOLT COUNTERBORE AT THE REAR, THE BOLT HEAD WILL
ALSO BE BLACK IN COLOR WITH A STEEL GRAY BOLT BODY. THE STAINLESS
BARREL ASSEMBLY WILL HAVE 'S' IN THE SERIAL NUMBER.

- 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).

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- e. Insert reamer shank through barrel so pilot is inside barrel bore. Move barrel and reamer together and engage reamer shank into quick release chuck. Make sure barrel chamber is positioned such that it is not being cut by reamer yet.
- 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.

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Operation	Tool Detail	Operation: 405
Tool Number	Tooling Description	
F-76039	Machine	
D-46967	Fixture	
STD	ACCU-LUBE 2000	
STD	STEELGARD 1301-NL	
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 - 223 REM	
D-49577-K	REAMER (replaces B-54136-S)	
A-41139	COLLAR	
B-90098-S	SHANK	

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STD Caliber - 243 WIN
D-49577-L REAMER (replaces B-83504)
A-41281 COLLAR
B-90098-B SHANK

C-41192-A 220 SWIFT MIN Heading Plug
C-41192-B 220 SWIFT WMAX Heading Plug
C-41155-A 223 REM MIN Heading Plug
C-41155-B 223 REM WMAX Heading Plug
C-41556-A 243 WIN MIN Heading Plug
C-41556-B 243 WIN WMAX Heading Plug
C-41195-A 6MM REM MIN Heading Plug
C-41195-B 6MM REM WMAX Heading Plug

PROCESS CONTROL INSPECTION RECORD THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES			Revision Date: 12-Oct-05			Processed by:
Part No:	Part Name: Fin Assy 700 SS	Centerfire Rifle			Date: 8/14/2008	
Operation No: 405	Operation: Fit and Head Bolt Assembly to Barrel Assembly				Work Center:	
Prod. Qty:	Prod. Order #:	Operator			Setup inspected by & Date:	
Gage Description and Characteristic	Gage Number	Gage Frequency	1st Shift	2nd Shift	3rd Shift	Remarks, Causes, Action Taken, Etc.
VISUAL	VISUAL	100%	INSPECT			
6MM REM MIN Heading Plug	C-41195-A	100%	REJECT INSPECT			
6MM REM WMAX Heading Plug	C-41195-B	100%	REJECT INSPECT			

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

Operation Step Detail Operation: 415

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

Step Operation / Step Description

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

NOTE: THE BOLT ASSEMBLIES WILL HAVE AN IDENTIFICATION RING OR UNDERCUT IN THE COUNTERBORE AT THE REAR AND A BOLT HEAD BLACK IN COLOR. THE STAINLESS BARREL ASSEMBLIES WILL HAVE AN 'S' IN THE SERIAL NUMBER.

- 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).

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- e. Insert shoulder reamer shank through barrel so pilot is inside barrel bore. Move barrel and reamer together and engage reamer shank into quick release chuck. Make sure barrel chamber is positioned 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.

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- n. Dip belt reamer into LB2000 Accu-Lube (note: thick blue liquid).
- 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.

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Operation Tool Detail

Operation: 415

Tool Number	Tooling Description
F-76039	Machine - Special Chambering Mach.
D-46967	Fixture
STD	ACCU-LUBE 2000
STD	STEELGARD 1302-NL
STD	7MM Mag.
B-84815	REAMER - SHOULDER
A-41281	COLLAR
B-90098-V	SHANK
B-53328-P	REAMER - FACE
B-53328-V	BELT CUTTER
B-53328-R	CHAMBER GUIDE BUSHING
=====	7MM STW
D-49577-X	REAMER - SHOULDER & NECK
A-41281	COLLAR
B-90098-V	SHANK
D-53328-P	REAMER - FACE (A/U 7MM REM MAG)
D-53328-V	BELT CUTTER
D-53328-R	CHAMBER GUIDE BUSHING (A/U 7MM REM MAG)
STD	300 Win Mag.
B-86573	REAMER - SHOULDER
A-41281	COLLAR
B-90098-W	SHANK

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B-53328-W REAMER - FACE
B-53328-V BELT CUTTER
B-53328-R CHAMBER GUIDE BUSHING

STD 348 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 300 WBY 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 WBY 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)

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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-41561-A	264 Win MIN Heading Plug
C-41561-B	264 Win WMAX Heading Plug
C-83853-A	264 Win BELT - MIN Heading Plug
C-83853-B	264 Win BELT - WMAX Heading Plug
C-41578-A	300 WBY MIN Heading Plug
C-41578-B	300 WBY WMAX Heading Plug
C-83853-A	300 WBY BELT - MIN Heading Plug
C-83853-B	300 WBY BELT - WMAX Heading Plug
C-41546-A	300 Win MIN Heading Plug
C-41546-B	300 Win WMAX Heading Plug
C-83853-A	300 Win BELT - MIN Heading Plug
C-83853-B	300 Win BELT - WMAX Heading Plug
C-41561-A	338 Win MIN Heading Plug
C-41561-B	338 Win WMAX Heading Plug
C-83853-A	338 Win BELT - MIN Heading Plug
C-83853-B	338 Win BELT - WMAX Heading Plug
C-42293-A	375 H&H MIN Heading Plug
C-42293-B	375 H&H WMAX Heading Plug
C-42405-A	375 H&H BELT - MIN Heading Plug
C-42405-B	375 H&H BELT - WMAX Heading Plug
C-41563-A	7MM Wby Mag MIN Heading Plug
C-41563-B	7MM Wby Mag WMAX Heading Plug
C-83853-A	7MM Wby Mag BELT - MIN Heading Plug
C-83853-B	7MM Wby Mag BELT - WMAX Heading Plug
C-41561-A	7MM Mag MIN Heading Plug
C-41561-B	7MM Mag WMAX Heading Plug

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C-83853-A 7MM Mag BELT - MIN Heading Plug
C-83853-B 7MM Mag BELT - 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 SS	Centerfire Rifle			Date:	8/14/2006
Operation No: 415	Operation: Fit and Head Bolt Assembly to Barrel Assy and Chamber to Length (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			
264 Win BELT - MIN Heading Plug	C-83853-A	100%	REJECT INSPECT			
264 Win BELT - WMAX Heading Plug	C-83853-B	100%	REJECT INSPECT			
264 Win MIN Heading Plug	C-41561-A	100%	REJECT INSPECT			
264 Win WMAX Heading Plug	C-41561-B	100%	REJECT INSPECT			
300 WBY BELT - MIN Heading Plug	C-83853-A	100%	REJECT INSPECT			
300 WBY BELT - WMAX Heading Plug	C-83853-B	100%	REJECT INSPECT			
300 WBY MIN Heading Plug	C-41578-A	100%	REJECT			

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300 WBY WMAX Heading Plug	C-41578-B	100%	INSPECT			
300 Win BELT - MIN Heading Plug	C-83853-A	100%	REJECT INSPECT			
300 Win BELT - WMAX Heading Plug	C-83853-B	100%	REJECT INSPECT			
300 Win MIN Heading Plug	C-41546-A	100%	REJECT INSPECT			
300 Win WMAX Heading Plug	C-41546-B	100%	REJECT INSPECT			
300 Win BELT - MIN Heading Plug	C-83853-A	100%	REJECT INSPECT			
300 Win BELT - WMAX Heading Plug	C-83853-B	100%	REJECT INSPECT			
300 Win MIN Heading Plug	C-41546-A	100%	REJECT INSPECT			
300 Win WMAX Heading Plug	C-41546-B	100%	REJECT INSPECT			
300 Win BELT - MIN Heading Plug	C-83853-A	100%	REJECT INSPECT			
300 Win BELT - WMAX Heading Plug	C-83853-B	100%	REJECT INSPECT			
300 Win MIN Heading Plug	C-41546-A	100%	REJECT			

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			INSPECT			
300 Win WMAX Heading Plug	C-41546-B	100%	REJECT INSPECT			
338 Win BELT - MIN Heading Plug	C-83853-A	100%	REJECT INSPECT			
338 Win BELT - WMAX Heading Plug	C-83853-B	100%	REJECT INSPECT			
338 Win MIN Heading Plug	C-41561-A	100%	REJECT INSPECT			
338 Win WMAX Heading Plug	C-41561-B	100%	REJECT INSPECT			
338 Win BELT - MIN Heading Plug	C-83853-A	100%	REJECT INSPECT			
338 Win BELT - WMAX Heading Plug	C-83853-B	100%	REJECT INSPECT			
338 Win MIN Heading Plug	C-41561-A	100%	REJECT INSPECT			
338 Win WMAX Heading Plug	C-41561-B	100%	REJECT INSPECT			
375 H&H BELT - MIN Heading Plug	C-42405-A	100%	REJECT INSPECT			
375 H&H BELT - WMAX Heading Plug	C-42405-B	100%	REJECT INSPECT			
375 H&H MIN Heading Plug	C-42293-A	100%	REJECT			

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			INSPECT			
375 H&H WMAX Heading Plug	C-42353-B	100%	REJECT INSPECT			
7MM Wby Mag BELT - MIN Heading Plug	C-83853-A	100%	REJECT INSPECT			
7MM Wby Mag BELT - WMAX Heading Plug	C-83853-B	100%	REJECT INSPECT			
7MM Wby Mag MIN Heading Plug	C-41563-A	100%	REJECT INSPECT			
7MM Wby Mag WMAX Heading Plug	C-41563-B	100%	REJECT INSPECT			
7MM Mag BELT - MIN Heading Plug	C-83853-A	100%	REJECT INSPECT			
7MM Mag BELT - WMAX Heading Plug	C-83853-B	100%	REJECT INSPECT			
7MM Mag MIN Heading Plug	C-41561-A	100%	REJECT INSPECT			
7MM Mag WMAX Heading Plug	C-41561-B	100%	REJECT INSPECT			
7MM Mag BELT - MIN Heading Plug	C-83853-A	100%	REJECT INSPECT			
7MM Mag BELT - WMAX Heading Plug	C-83853-B	100%	REJECT INSPECT			
7MM Mag MIN Heading Plug	C-41561-A	100%	REJECT			

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7MM Mag WMAX Heading Plug	C-41561-B	100%	INSPECT			
7MM Mag BELT - MIN Heading Plug	C-83853-A	100%	REJECT INSPECT			
7MM Mag BELT - WMAX Heading Plug	C-83853-B	100%	REJECT INSPECT			
7MM Mag MIN Heading Plug	C-41561-A	100%	REJECT INSPECT			
7MM Mag WMAX Heading Plug	C-41561-B	100%	REJECT INSPECT			
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420 Ream Chamber to Deburr

Operation Step Detail Operation: 420

Step Operation / Step Description

Ream chamber to deburr

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, wipe clean and place to rest.
6. Unclamp, pick Barrel Assembly, wash breech end in solvent and drain.
7. Return Barrel Assembly to truck.

Operation Tool Detail Operation: 420

Tool Number Tooling Description

B-86064-C Burnish Tool-Shank Std.

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 SS		Centerfire Rifle		Date:		8/14/2006	
Operation No: 420		Operation: Ream Chamber to Deburr				Work Center:			
Prod. Qty:		Prod. Order #:		Operator			Setup inspected by & Date:		
Gage Description and Characteristic		Gage Number	Gage Frequency	1st Shift	2nd Shift	3rd Shift	Remarks, Causes, Action Taken, Etc.		
VISUAL		VISUAL	100%	INSPECT					
				REJECT					
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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.

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

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

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427 Assemble Rear Sight Assembly
and Front Sight to Barrel Assembly

Operation Step Detail Operation: 427

Step	Operation / Step Description
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	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

Operation Tool Detail Operation: 427

Tool Number	Tooling Description
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E-82757 Front Sight Fixture
STD X15e
SEA 100 RM60 Air Screwdriver - Ingersoll Rand
1100 RPM
STD Bench

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 SS		Centerfire Rifle		Date: 8/14/2006	
Operation No: 427	Operation: Assemble Rear Sight Assembly				Work Center:	
Prod. Qty:	Prod. Order #:	Operator			Setup inspected by & Date	
Gage Description and Characteristic	Gage Number	Gage Frequency	1st Shift	2nd Shift	3rd Shift	Remarks, Causes, Action Taken, Etc.
VISUAL	VISUAL	100%	INSPECT			
			REJECT INSPECT			
			REJECT INSPECT			
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			REJECT INSPECT			

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~AUTODATE428 Assemble Front & Rear Scope Bases to 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 SS		Centerfire Rifle		Date: 8/14/2006	
Operation No: 428	Operation: Assemble Front & Rear Scope Bases to Barrel				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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430 Ream Ejector Hole

Operation Step Detail Operation: 430

Step Operation / Step Description

Ream Ejector Hole

Remove Burr thrown into Ejector Hole by Flat Scrape

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

Operation Tool Detail Operation: 430

Tool Number Tooling Description

STD #28 DRILL

PROCESS CONTROL INSPECTION RECORD THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES		Revision Date: 12-Oct-05	Processed by:
Part No:	Part Name: Fin Assy 700 SS	Centerfire Rifle	Date: 8/14/2006
Operation No: 430	Operation: Ream Ejector Hole		Work Center:

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Prod. Qty.	
Page Description and Unit Price	

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431 Form Radius on Edge of Firing Pin Hole

Operation Step Detail Operation: 431

Step Operation / Step Description

Form Radius on Edge of Firing Pin Hole

Operation Tool Detail Operation: 431

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 SS	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.					

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432 Assemble Riveted Extractor to Bolt - (MAGNUMS)

Operation Step Detail Operation: 432

Step Operation / Step Description

Assemble Riveted Extractor to Bolt - (MAGNUMS)

PROCEDURE:

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

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

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

Operation Tool Detail

Operation: 432

Tool Number	Tooling Description
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	Small Rifle
B-84831-B	Large Rifle
B-84831-C	Belted Magnums

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TENSION

B-87034-A Small Rifle
B-87034-C Large Rifle
B-87034-D Belted Magnums
B-87034-E Swedish 6.5x55 1994 Classic

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 SS	Center fire 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					
Small Rifle	B-84831-A	100%	REJECT INSPECT					
Large Rifle	B-84831-B	100%	REJECT INSPECT					
Belted Magnums	B-84831-C	100%	REJECT INSPECT					
Small Rifle	B-87034-A	100%	REJECT					

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Large Rifle	B-87034-C	100%	INSPECT		
			REJECT		
Bellevue Megatons	B-87034-D	100%	INSPECT		
			REJECT		
Swedish 6.5x55 1994 Classic	B-87034-E	100%	INSPECT		
			REJECT		
			INSPECT		
			REJECT		
			INSPECT		
			REJECT		
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435 Assemble Rivetless Extractor to Bolt

Operation Step Detail Operation: 435

Step	Operation / Step Description
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Assemble Rivetless Extractor to Bolt

- | | |
|---|---|
| 1 | <p>Extractor Must Be Shaped to Bolt Shroud by Adjusting Both Ends of (If Necessary)</p> <ul style="list-style-type: none"> - 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 | <p>Max Shell Head Plug Must Compress Extractor and Bottom on Face of Bolt</p> |
| 3 | <p>Blend Extractor to Bolt Shroud</p> <ul style="list-style-type: none"> a. Check Extractor with Pick - Must Not Be Deformed or Loose |

Operation Tool Detail Operation: 435

Tool Number	Tooling Description
-------------	---------------------

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

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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 700-55		Centerfire Rifle			Date: 8/14/2006		
Operation No: 435	Operation: Assemble Rifleless Extractor to Bolt					Work Center:		
Prod. Qty:	Prod. Order #:	Operator			Setup inspected by & Date:			
Gage Description and Characteristic	Gage Number	Gage Frequency	1st Shift	2nd Shift	3rd Shift	Remarks, Causes, Action Taken, Etc.		
VISUAL	VISUAL	100%	INSPECT					
Min Tension Plug - .445	B-87034-C	100%	REJECT INSPECT					
Max Tension Plug	B-84831-B	100%	REJECT INSPECT					
EXTRACTOR TENSION PLUG GAGE - 6.5X55	B-87034-E	100%	REJECT INSPECT					
			REJECT INSPECT					
			REJECT INSPECT					
			REJECT INSPECT					
			REJECT INSPECT					
			REJECT					

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

Operation Step Detail

Operation: 440

Step

Operation / Step Description

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

PROCEDURE:

- 1 Position Ejector with Ejector Spring in Bolt
- 2 Load Bolt Assembly into Fixture and Clamp
- 3 Position Ejector 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

Operation Tool Detail

Operation: 440

Tool Number

Tooling Description

C-51730

Fixture

C-40296

Fixture (L.H.)

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A-48261
B-54504
C-53663

Pin Punch
Drive Punch (Drive Out Tight Ejector Pin)
Fixture

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 SS		Centerfire Rifle		Date:	8/14/2006
Operation No: 440	Operation: Assemble Ejector to Ejector Spring and then				Work Center:	
Prod. Qty:	Prod. Order #:	Operator			Setup Inspected by & Date:	
Gage Description and Characteristic	Gage Number	Gage Frequency	1st Shift	2nd Shift	3rd Shift	Remarks, Causes, Action Taken, Etc.
VISUAL	VISUAL	100%	INSPECT			
			REJECT INSPECT			
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460R 460R Strip Defective Barrel Assembly Complete

Operation Step Detail Operation: 460R

Step Operation / Step Description

Strip Defective Barrel Assembly Complete

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 SS		Centerfire Rifle			Date: 8/14/2005	
Operation No: 460R	Operation: 460R 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				
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465R Strip Defective Bolt

Operation Step Detail Operation: 465R

Step Operation / Step Description

Strip Defective Bolt

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 SS		Centerfire Rifle		Date	8/14/2005	
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				
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550 Assemble Action

Operation Step Detail Operation: 550

Step Operation / Step Description

Assemble Action

PROCEDURE:

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

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

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

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

Perform Checks a. thru c. (3) Times

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

Try (3) Times

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

Follow procedure below using at least two different weights.

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

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

- 22 Close the Action and Lock Bolt Down

- 23 Select Correct Magazine Box

- Inspect for:
 - a. Good Color
 - b. Rust

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- c. Breaks
- d. Deformities

24 Assemble Magazine Box to Action with Magazine Tab Screw
ADL ONLY

Operation Tool Detail

Operation: 550

Tool Number	Tooling Description
STD	Ratchet Screwdriver
A-88003	Taper Reamer for Braze in Firing Pin Hole
7237T1	Lube Brush - MacMaster-Carr (or Equivalent) Tin Ferroule, Natural Bristle type Brush 5-3/4 O.A. - 3/8W x AP 3/4"L
43447	Brass Wiping Rod

Gages:

B-80652	Pin Tight Tester - Sear Retracts Without Hesitation
B-70697	Trigger Pull Scales
Std	.006 Feeler Gage or Suitable Shim
C-47741	Sear Engagement Gage - Solid Bolt
B-52089	Firing Pin Protrusion Gage

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 SS	Centerfire Rifle	Date:	8/14/2006

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Operation No: 550		Operation: Assemble Action				Work Center:
Prod. Qty:	Prod. Order #	Operator			Setup inspected by & Date:	
Gage Description and Characteristic	Gage Number	Gage Frequency	1st Shift	2nd Shift	3rd Shift	Remarks, Causes, Action Taken, Etc.
VISUAL	VISUAL	100%	REJECT INSPECT			
Pin Tight Tester - Sear Retracts Without Hesitation	B-80652	100%	REJECT INSPECT			
Trigger Pull Scales	B-70697	100%	REJECT INSPECT			
.006 Feeler Gage or Suitable Shim	Std	100%	REJECT INSPECT			
Sear Engagement Gage - Solid Bolt	C-47741	100%	REJECT INSPECT			
Firing Pin Protrusion Gage	B-52089	100%	REJECT INSPECT			
			REJECT INSPECT			
			REJECT INSPECT			
			REJECT INSPECT			
			REJECT INSPECT			
			REJECT INSPECT			

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

Operation Step Detail Operation: 565

Step Operation / Step Description

Assemble Stock to Action

PROCEDURE:

- 1 Select Correct Stock
 - a. Inspect for:
 - Good Finish
 - Marks Slight
 - No Checks
 - Grip Outline Reasonably Uniform and Square
 - Recoil Pad
 1. Good Color
 2. Rear Face
 3. No Burrs
 4. .005 Max. Opening at Face
 5. Tight (Finger Test)
 6. Burrs at Screw Holes Slight
 7. .02 Max. Mismatch of Recoil Pad and Stock Either Way
 - b. Inspect and Reject for Visual Damage
 - Procedure to Reject Stock if Below Standards
 1. Hand Print Defect Code Number on Color Dot
 2. Affix Adhesive Color Dot to Stock Beside the Defect Being Noted

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- 2 Assemble Magazine Spring to Magazine Follower
- Assemble to Magazine
- 3 Position Stock on Action
- 4 Select Trigger Guard Assy
 - a. Inspect for:
 - No Sharp Edges
 - Color
 - Marks
 - Pits
 - Position in Stock
- 5 Select Front, Center, and Rear Trigger Guard Screws
 - a. Inspect for:
 - Color
 - Allen Head
 - Threads
 - Position in Holes
- 6 Assemble Floor Plate Assembly and Stock to Barrel Assembly Complete with Front and Rear Trigger Guard Screws.
 - Using Pneumatic Power Driver, or Ball Ratchet Screwdriver properly seated against the barrel bracket cut in the stock. (bbl. Assy. bracket to rear of barrel bracket cut in stock) First torque front take down screw - 35 IN*LBF - per torque spec. Next torque rear take down screw to 35 IN*LBF then(ADL'S) the center take down screw SNUG ONLY
 - a. Check Margin at Ejection Port and at Receiver Tang per Sample
 - Opening Between Stock and Receiver Uniform
 - No Bad Chipping
 - Barrel Must Seat within 1.5" of Front of Stock
 - Vertical Squeeze Produces No Movement
 - Guard Screws Tight

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- .020 Max. Opening Under Trigger Plate Except at Corners
- .025 Max. Opening Under Trigger Plate at Corners
- .025 Max. Opening with Stock
- b. Gas Hole in Receiver 50% Visible Above Stock
- c. Barrel to be Free Floating
 - .005 Min Clearance (Mountain Rifle ONLY)
- d. Check for Trigger Clearance in Guard
 - Must Not Bind
 - Trigger Must Not Be Exposed Outside of Guard
 - A (.030) Shim Must Fit Between End of Trigger and Inside of Guard Bow While Trigger is in both the Full Rearward Position and the Relaxed Position
- 1. IF IT FAILS the SHIM
 - SEE PROCEDURE BELOW for SHIM PLACEMENT UNDER THE TRIGGER GUARD

Shim Placement Procedure if Required;

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

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

- 7 Turn Rifle Over in Vise
- 8 Check Safety

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

- 9 Check Bolt
- No Bind
 - Clears Stock
- 10 Check Trigger Pull (4.75 to 5.75 lbs.) parallel with action
- Must be Short & Crisp
 - No Creep Over or Overdraw

Try (3) Times

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

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

- 11 Single load and Full Magazine Dummy Cartridges to Check:
- a. Feeding
 - b. Extraction
 - c. Ejection
 - d. Adjust if Necessary

- 12 Make All Necessary Repairs from Test

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

- Wipe Bore

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- Rod Must Have Sufficient Flannel Cleaning Patch to Clean Bore

13 Attach Hang Tag to Trigger Guard

Operation Tool Detail

Operation: 565

Tool Number	Tooling Description
STD	Ball Ratchet Screwdriver
43447	Brass Wiping Rod
B-70697	Trigger Pull Scale
B-TS-7300	Dent & Scuff Template

PROCESS CONTROL INSPECTION RECORD				Revision Date:		Processed by:	
THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES				12-Oct-05			
Part No:	Part Name: Fin Assy 700 SS		Centerfire Rifle		Date:	8/14/2006	
Operation No: 565	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				
Trigger Pull Scale	B-70697	100%	REJECT INSPECT				
Dent & Scuff Template	B-TS-7300	100%	REJECT				

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580 Assemble Action

Operation Step Detail Operation: 580

Step Operation / Step Description

Assemble Action

PROCEDURE:

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

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

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

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

Perform Checks a. thru c. (3) Times

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

Try (3) Times

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

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

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

- 22 Close the Action and Lock Bolt Down

Operation Tool Detail

Operation: 580

Tool Number

Tooling Description

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

GAGES

STD	Dummy Cartridge Rounds of Proper Caliber Being Built
B-70697	Trigger Pull Scales
B-80652	Pins Tight Tester
B-TS-7300	Dent & Scuff Template
STD	.006 Feeler Gage or Suitable Shim
C-47741	Sear Engagement Gage - Solid Bolt
D-44581	Sear Lift Dial Gage (.006 - .018)
B-52089	Firing Pin Protrusion Gage
A-43977	Trigger Guard Clearance Shim Tool (.030")

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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 700-55		Centerfire Rifle			Date: 8/14/2006		
Operation No: 580	Operation: Assemble Action					Work Center:		
Prod. Qty:	Prod. Order #:	Operator			Setup inspected by & Date:			
Gage Description and Characteristic	Gage Number	Gage Frequency	1st Shift	2nd Shift	3rd Shift	Remarks, Causes, Action Taken, Etc.		
VISUAL	VISUAL	100%	INSPECT					
Dummy Cartridge Rounds of Proper Caliber Being Built	STD	100%	REJECT INSPECT					
Trigger Pull Scales	B-70697	100%	REJECT INSPECT					
Pins Tight Tester	B-80652	100%	REJECT INSPECT					
Dent & Scuff Template	B-TS-7300	100%	REJECT INSPECT					
.006 Feeler Gage or Suitable Shim	STD	100%	REJECT INSPECT					
Sear Engagement Gage - Solid Bolt	C-47741	100%	REJECT INSPECT					
Sear Lift Dial Gage (.006 - .018)	D-44581	100%	REJECT					

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Hang Pin Intrusion Gage	S-52086	100%	INSPECT		
			REJECT		
			INSPECT		
Trigger Guard Clearance	A-43877	100%	REJECT		
Shim Tool (1997)			INSPECT		
			REJECT		
			INSPECT		
			REJECT		
Pieces Run:					Remington Arms Company, Inc. -- Ilion, New York

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585 Assemble Stock to Action & Attach Hang Tag
to Trigger Guard

Operation Step Detail Operation: 585

Step Operation / Step Description

Assemble Stock to Action

PROCEDURE:

- 1 Select Correct Stock
 - a. Inspect for:
 - Good Finish
 - Marks Slight
 - No Checks
 - Grip Outline Reasonably Uniform and Square
 - Recoil Pad
 1. Good Color
 2. Rear Face
 3. No Burrs
 4. .005 Max. Opening at Face
 5. Tight (Finger Test)
 6. Burrs at Screw Holes Slight
 7. .02 Max. Mismatch of Recoil Pad and Stock Either Way
 - b. Inspect and Reject for Visual Damage
 - Procedure to Reject Stock if Below Standards
 1. Hand Print Defect Code Number on Color Dot
 2. Affix Adhesive Color Dot to Stock Beside the Defect Being Noted

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2. Select Correct Magazine
 - a. Inspect for:
 - Color
 - No Rust
3. Assemble Magazine to Receiver
4. Position Stock on Action
5. Select Trigger Guard Assy
 - a. Inspect for:
 - No Sharp Edges
 - Color
 - Marks
 - Pits
 - Position in Stock
6. Select Front, and Rear Trigger Guard Screws
 - a. Inspect for:
 - Color
 - Allen Head
 - Threads
 - Position in Holes
7. Assemble Floor Plate Assembly and Stock to Barrel Assembly Complete with Front and Rear Trigger Guard Screws.
 - Using Pneumatic Power Driver, or Ball Ratchet Screwdriver 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*LBF - per torque spec. Next torque rear take down screw to 35 IN*LBF then(ADL'S) the center take down screw SNUG ONLY
 - a. Check Margin at Ejection Port and at Receiver Tang per Sample
 - Opening Between Stock and Receiver Uniform
 - No Bad Chipping
 - Barrel Must Seat within 1.5" of Front of Stock

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- Vertical Squeeze Produces No Movement
- Guard Screws Tight
- .025 Max. Opening Under Trigger Plate Except at Corners
- .025 Max. Opening Under Trigger Plate at Corners
- .025 Max. Opening with Stock
- b. Gas Hole in Receiver 50% Visible Above Stock
- c. Barrel to be Free Floating
 - .005 Min Clearance (Mountain Rifle ONLY)
- d. Check for Trigger Clearance in Guard
 - Must Not Bind
 - Trigger Must Not Be Exposed Outside of Guard
 - A (.030) Shim Must Fit Between End of Trigger and Inside of Guard Bow While Trigger is in both the Full Forward Position and the Relaxed Position
- 1. IF IT FAILS the SHIM
 - SEE PROCEDURE BELOW for Shim PLACEMENT UNDER THE TRIGGER GUARD

Shim Placement Procedure if Required;

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

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

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- a. Install in Floor Plate
- b. Adjust Floor Plate to Latch Properly - (See Sample)
- a. Turn Rifle Over in Vise
- 10. Check Safety:
 - No Bind
 - Clears Stock
 - a. Safety Lever Must Have Noticeable Overtravel Before Stopping or Coming Into Contact with Stock Cuts
 - Forward Beyond "F" Detent
 - Rearward Beyond "S" Detent

- 11. Check Bolt
 - No Bind
 - Clears Stock

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

Try (3) Times

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

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

- 13. Single load and Full Magazine Dummy Cartridges to Check:
 - a. Feeding
 - b. Extraction
 - c. Ejection

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d. Adjust if Necessary

14 Make All Necessary Repairs from Test

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

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

15 Attach Hang Tag to Trigger Guard

Operation Tool Detail

Operation: 585

Tool Number	Tooling Description
STD	Ball Ratchet Screwdriver
43447	Brass Wiping Rod
B-70697	Trigger Pull Scale
B-TS-7300	Dent & Scuff Template

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 SS		Centerfire Rifle			Date: 8/14/2006	
Operation No: 585		Operation: Assemble Stock to Action & Attach Hang Tag						Work Center:
Prod. Qty:		Prod. Order #:		Operator			Setup Inspected by & Date:	
Gage Description and Characteristic		Gage Number	Gage Frequency	1st Shift	2nd Shift	3rd Shift	Remarks, Causes, Action Taken, Etc.	

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593 Assemble Front Swivel Screw and Swivel Screw
Spacer to Stock

Operation Step Detail Operation: 593

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

Operation Tool Detail Operation: 593

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

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600 **Proof Test**

Operation Step Detail Operation: 600

Step Operation / Step Description

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

I. GUNS TO BE PROOFED

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

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

II. PROOFING OBJECTIVE

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

III. SAFETY

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

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

IV. DESCRIPTION AND SEQUENCE OF PROOF TEST

A. Preliminary inspection-Each gun prior to proof:

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

B. PROOF TEST

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

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

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

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

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- b. If gun fails to fire, wait one (1) minute before removing shell.
 - c. Place safe in "S" or "on" position, remove gun from proof jack and enter gun information and reject in computer.
 9. After firing, open doors of proofing device and retrieve fired case.
 10. Check fired case for:
 - a. Primer indent must be sufficient to fire round.
 - b. Possible ruptures must not be ruptured or swelled.
 - c. Rings or roughness - slight rings are permissible - Rub fingernail over ring. If ring is large enough pick with nail, reject the gun.

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

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

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ACCEPTABLE PRODUCTS ONLY.

- 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.

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VI. SAFETY AFTER PROOF TEST

A. SAFETY

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

B. INSPECT CHAMBER AND MAGAZINE FOR LIVE AMMUNITION

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

C. VISUALLY INSPECT FOR MARRING BY DEVICE OR PORT

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

D. MOVE ENTIRE LOAD TO NEXT OPERATION

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

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

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Prod. Qty.	
Page Description and Unit Price	

Order - William

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Pieces Run:

1
 2
 3
 4
 5

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605R Check Repaired Guns Returning To Gallery For
Proof Stamp, Prick Punch and Obstruction In
Barrel

Operation Step Detail Operation: 605R

Step Operation / Step Description

Check previously rejected guns for proof stamp, prick punch on bolt
handle and obstruction in barrel.

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 SS		Centerfire Rifle		Date: 8/14/2006	
Operation No: 605R		Operation: Check Repaired Guns Returning To Gallery For				Work Center:	
Prod. Qty:		Prod. Order #:		Operator		Setup inspected by & Date:	
Gage Description and Characteristic		Gage Number	Gage Frequency	1st Shift	2nd Shift	3rd Shift	Remarks, Causes, Action Taken, Etc.
VISUAL		VISUAL	100%	INSPECT			
				REJECT INSPECT			
				REJECT INSPECT			
				REJECT INSPECT			

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606 Test and Target

Operation Step Detail Operation: 606

NOTE: Rechamfer 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 tool section.

Step Operation / Step Description

NOTE: TARGET

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

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

Gallery Test-Procedure and Specifications

Safety before Test: All plant rules, gallery rules and job safety key

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points are to be observed at all times.

I. RIFLES TESTED AND TARGETED

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

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.

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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).

IV. DESCRIPTION OF TEST AND TARGET PROCEDURES AND SPECIFICATIONS:

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

A. Test/Target Description

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

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

2. With safety in "F" or "OFF" position-close Bolt crisply on empty chamber. Rifle must be pointed in safe direction at all times.
 - a. Firing pin must not follow down as Bolt cams shut.
 - b. Must not fire on closings.

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

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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 11-12 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 remove the bolt and look through bore to line up device with paper.

13. Load Magazine to capacity: (see chart below)
a. Magazine must accept total rounds specified.
b. Cartridges must be retained by rails in receiver.

CALIBER	AMMUNITION TYPE	MAG. CAP
1. 220 Swift	50 gr. PSP	3
2. 223 Rem.	55 gr. PSP	5
3. 6mm Rem.	100 gr. PSP	4
4. 243 Win.	100 gr. PSPCL - 80 gr. HP	4
5. 25.06 Rem.	120 gr. PSPCL	4
6. 257 Roberts	117 gr. SPCL	4
7. 270 Win.	150 gr. SPCL	4
8. 280 Rem.	150 gr. PSPCL	4
9. 7mm 08 Rem.	140 gr. PSP	4
10. 7mm Rem. Mag.	175 gr. PSPCL	3
11. 7mm Wby. Mag.	175 gr. PSPCL	3
12. 30.06 Sprg.	180 gr. SPCL-150 gr. PSPCL	4
13. 300 WBY. Mag.	220 gr. SPCL	3
14. 308 Win.	180 gr. SPCL-150 gr. PSPCL	4
15. 300 Win. Mag.	180 gr. PSPCL	3
16. 338 Win. Mag.	250 gr. PSP	3
17. 375 H&F MAG	270 gr. SP	3

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

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

15. Open Bolt full stroke to rear position.

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16. Close guard. (If on accuracy device)
17. Close Bolt to feed shell into chamber and lock to start test.
 - a. Must feed single (1) shell with each operating stroke of Bolt.
 - b. Must not double feed.
 - c. Shells must not stem chamber or magazine. (Bind inside receiver or barrel.)
 - d. Bolt must not override shell in magazine.
 - e. Bolt must feed shell into chamber with normal pressure.
 - f. If, using normal force, the Bolt will not close over a live round in the chamber, perform the following test:
 1. Insert the appropriate close hard plug into the chamber while the rifle is held in the test device. (see Tool Detail Section for list of close hard plugs)
 2. Close and operate bolt:
 - a. If bolt closes hard over the plug, reject the rifle for Close Hard and record the malfunction in the computer and attach the slip to the rifle.
 - b. If bolt closes with normal pressure, do not reject the rifle. This indicates oversize ammunition.
18. Move safety to "F" or "OFF" position.
19. If using accuracy device fire rifle by pushing (2) two buttons on device simultaneously. If using shooting jacks, grip rifle in normal manner and pull trigger with finger.
20. For the 10~ of standard rifles that are targeted, check each shot with spotting scope for rifle "seating in" and position of shots on paper. Use a maximum of 3 "seater" rounds per rifle.

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- a. Adjust device if shots off paper or group too close to edge.
21. Operate action full cycle to extract, eject, and feed each shot.
 - a. Bolt should not pull out of receiver.
 - b. Case or shell must be retained by extractor until the case is ejected from receiver.
 - c. Case must be completely ejected from receiver, should not catch on receiver.
 - d. One fired case from each rifle must be visually inspected for firing pin indent and chamber marks reflected on case. Slight rings are permissible; if ring is large enough to pick with fingernail, reject the rifle.
22. Fire all rounds required for Test and Targeting.
 - a. For the Test procedure, each rifle is to have the first two (2) rounds fired and the remaining rounds cycled through but not fired.
 - b. For the Target procedure, all accuracy specifications are based on groups consisting of 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.
23. Open guard. (If on accuracy device)
24. For the Targeted rifles (10% std.)
 - a. Use spotting scope to check group size.
 - b. Maximum spread of the two extreme holes must be within group size specifications listed below.

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GROUP SIZE SPECIFICATIONS

A. FIELD GRADE RIFLES - (ADL,BDL)

CALIBER	AMMUNITION TYPE	MAX. GROUP CENTER TO CENTER		
		3 SHOT	4 SHOT	5 SHOT
1. 220 Swift	50 gr. PSP	1.5	2.0	2.2
2. 223 Rem.	55 gr. PSP	1.5	2.0	2.2
3. 6mm Rem.	100 gr. PSP	1.5	2.0	2.2
4. 243 Win.	100 gr. PSPCL - 80 gr. HP	-	-	1.5
5. 25.06 Rem.	120 gr. PSPCL	1.7	2.2	2.7
6. 257 Roberts	117 gr. SPCL	1.7	2.2	2.7
7. 270 Win.	150 gr. SPCL	1.7	2.2	2.7
8. 280 Rem.	150 gr. PSPCL	1.7	2.2	2.7
9. 7mm-08 Rem.	140 gr. PSP	1.7	2.2	2.7
10. 7mm Rem. Mag.	175 gr. PSPCL	2.5	3.0	3.5
11. 7mm Wby. Mag.	175 gr. PSPCL	2.5	3.0	3.5
12. 30.06 Rem.	180 gr. SPCL- 150 gr. PSPCL	1.7	2.2	2.7
13. 300 WBY. Mag.	220 gr. SPCL	2.5	3.0	3.5
14. 308 Win.	180 gr. SPCL- 150 gr. PSPCL	1.7	2.2	2.7
15. 300 Win. Mag.	180 gr. PSPCL	2.5	3.0	3.5
16. 338 Win. Mag.	250 gr. PSP	2.5	3.0	3.5
17. 375 H&H Mag.	270 gr. SP	2.5	3.0	3.5

25. Unclamp and remove rifle from device.(If on accuracy device)

26. Inspect chamber and magazine for live ammunition.

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

27. Pass all rifles that meet specifications for:

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- a. Visual
- b. Functional
- c. Group size

28. Reject all rifles that do not meet specifications:

- a. Enter all malfunctions into the computer and place 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.

29. Place rifle back on truck.

30. 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

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.

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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. Check all rifles from each side of truck, after test, and check for any possible damage to rifle from the test.

D. All rifles are moved to Ammunition Inspection Area.

Operation Tool Detail

Operation: 606

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)

Tool Number

Tooling Description

Std

CALIBER
7MM WBY MAG

USE CLOSE HARD PLUG
C-48336-B

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

(Close Hard Plug Storage Cabinet is D-46202)

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 SS		Centerfire Rifle		Date: 8/14/2006	
Operation No: 606		Operation: Test and Target				Work Center:	
Prod. Qty:		Prod. Order #:		Operator		Setup Inspected by & Date:	
Gage Description and Characteristic		Gage Number	Gage Frequency	1st Shift	2nd Shift	3rd Shift	Remarks, Causes, Action Taken, Etc.

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611 Test and Target

Step Operation / Step Description

Gallery Test-Procedure and Specifications

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

I. RIFLES TESTED AND TARGETED

NOTE:

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

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

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II. TEST AND TARGET OBJECTIVES

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

III. SHOOTING JACKS AND DEVICE

- A. When performing an accuracy evaluation on a rifle use the accuracy device.
 - 1. Adjust and set device with master rifle if the caliber and model to be shot is produced with iron sights.
 - 2. Use 1" by 1" grid type targeting paper.
- B. When performing a function test, either the accuracy device or a centerfire shooting jack can be used.
 - 1. If a shooting jack is used, complete function test on entire truck. Then push the truck back to an accuracy device to target (10% std. & 100% Police).

IV. DESCRIPTION OF TEST AND TARGET PROCEDURES AND SPECIFICATIONS:

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

- A. Test/Target Description

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1. Pick up rifle from truck and inspect for:
 - a. Live Ammo - Inspect chamber and Magazine-both must be empty.
 - b. Caliber - To verify for shooter personal safety in selecting ammunition for test.
 - c. Proof mark on Barrel - (REP) must be present, right rear side of barrel, ahead of Magnaflux stamp.
 - d. Proof mark on Bolt - (.) Prick punch mark must be present at bottom of Bolt Handle.
 - e. Visual Defects - Marring of wood or metal finishes.
 - f. Normal Sight Alignment-as described below:
 1. Front and Rear Sight ramps must be central on barrel and straight with line of sight.
 2. Must conform to barrel - good fit - no excessive opening at side or ends, also must be screwed tight to barrel.
 3. Rear Sight must be central on ramp not twisted, bent or deformed.
 4. Mark on rear sight to coincide with fourth mark from rear of the rear sight ramp.
 5. Rear Sight Eyepiece must be positioned central to rear sight.

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

2. With safety in "F" or "OFF" position-close Bolt crisply on empty chamber. Rifle must be pointed in safe direction at all times.
 - a. Firing pin must not follow down as Bolt cams shut.
 - b. Must not fire on closings.
3. With Safety in "S" or "on" position and the action closed, raise the bolt.
 - a. Bolt must raise or open without excessive force.

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4. Close Bolt with safety in "'S" or "on" position - pull trigger firmly.
 - a. Rifle must not fire.
5. With finger off trigger-move safety to "F" or "OFF" position.
 - a. Rifle must not fire.
6. Open and close Bolt full stroke to cock firing pin.
7. Move Safety to full rear "S" or "ON" position and then move half way to the "F" or "OFF" position with thumb.
8. If safety stops at half-way position-pull trigger.
 - a. Rifle must not fire.
 - b. Safety must not move to full "OFF" position.
9. If safety stops in halfway position, move safety to "F" or "OFF" position after pulling trigger.
 - a. Rifle must not fire.

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

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

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

11. With Action open, position rifle in device and clamp.
12. For first rifle of a new caliber with iron sights, position line-o-sighter on sights and adjust device to point

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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-sighter.

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

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

CALIBER	AMMUNITION TYPE	MAG. CAP
1. 220 Swift	50 gr. PSP	4
2. 223 Rem.	55 gr. PSP	5
3. 6mm Rem.	100 gr. PSP	4
4. 243 Wir.	100 gr. PSPCL - 80 gr. SP	4
5. 25.06 Rem.	120 gr. PSPCL	4
6. 257 Roberts	117 gr.	4
7. 270 Wir.	150 gr. SPCL	4
8. 280 Rem.	150 gr. PSPCL	4
9. 7mm-08 Rem.	140 gr. PSP	4
10. 7mm Rem. Mag.	175 gr. PSPCL	3
11. 7mm Wby. Mag.	175 gr. PSPCL	3
12. 30.06 Sprg.	180 gr. SPCL-150 gr. PSPCL	4
13. 300 Wby. Mag.	220 gr. SPCL	3
14. 308 Wir.	180 gr. SPCL-150 gr. PSPCL	4
15. 300 Wir. Mag.	180 gr. PSPCL	3
15. 260 Rem.	140 gr. PSPCL	4
16. 338 Wir. Mag.	250 gr. PSP	4
17. 375 H&F	270 gr. SP	3

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

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- a. Bolt must close over full magazine with normal pressure.
16. Open Bolt full stroke to rear position.
17. Close guard. (If on accuracy device)
18. Close Bolt to feed shell into chamber and lock to start test.
 - a. Must feed single (1) shell with each operating stroke of Bolt.
 - b. Must not double feed.
 - c. Shells must not stem chamber or magazine. (Bind inside receiver or barrel.)
 - d. Bolt must not override shell in magazine.
 - e. Bolt must feed shell into chamber with normal pressure.
 - f. If, using normal force, the Bolt will not close over a five 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 that are targeted, check each

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shot with spotting scope for rifle "seating in" and position of shots on paper. Use a maximum of 3 "seater" rounds per rifle.

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

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

a. Bolt should not pull out of receiver.

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

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

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

23. Fire all rounds required for Test and Targeting.

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

b. For the Target procedure, all accuracy specifications are based on groups consisting of 3 to 5 shots, therefore, those rifles will typically require extra rounds to be loaded and shot singly. See chart below for acceptable group sizes.

24. Open guard. (If on accuracy device)

25. For the Targeted rifles (10% std.) Place Line-o-sighter onto sights (if sights are present) and check point of impact and group size.

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

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

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

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

Rear Sight Ramp and Sight

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

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

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

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

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

-Rear Sight Eyepiece positioned central crosswise with Windage Screw

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

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

GROUP SIZE SPECIFICATIONS

M/700 ADL

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

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1.	220 Swift	50 gr. PSP	1.5	2.0	2.2
2.	223 Rem.	55 gr. PSP	1.5	2.0	2.2
3.	6mm Rem.	100 gr. PSP	1.5	2.0	2.2
4.	243 Wir.	100 gr. PSPCL - 80 gr.HP	-	-	1.5
5.	25.06 Rem.	120 gr. PSPCL	1.7	2.2	2.7
6.	257 Roberts	117 gr. SPCL	1.7	2.2	2.7
7.	270 Wir.	150 gr. SPCL	1.7	2.2	2.7
8.	280 Rem.	150 gr. PSPCL	1.7	2.2	2.7
9.	7mm-08 Rem.	140 gr. PSP	1.7	2.2	2.7
10.	7mm Rem. Mag.	175 gr. PSPCL	2.5	3.0	3.5
11.	7mm Wby. Mag.	175 gr. PSPCL	2.5	3.0	3.5
12.	30.06 Rem.	180 gr. SPCL-150 gr. PSPCL	1.7	2.2	2.7
13.	300 Wby. Mag.	220 gr. SPCL	2.5	3.0	3.5
14.	308 Wir.	180 gr. SPCL-150 gr. PSPCL	1.7	2.2	2.7
15.	300 Wir. Mag.	180 gr. PSPCL	2.5	3.0	3.5
16.	338 Wir. Mag.	250 gr. PSP	2.5	3.0	3.5
17.	375 H&E Mag.	270 gr. SP	2.5	3.0	3.5

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

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

26. Remove line-o-sights.(If on accuracy device)
27. Unclamp and remove rifle from device.(If on accuracy device)

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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 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. Test/Target Stickers-(Acceptable Product Only)

- 1. When all rifles have been tested / targeted

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

V. SAFETY AFTER TEST

A. Open Bolt

1. Move Bolt to open position before removing rifle from accuracy 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. Check all rifles from each side of truck, after test, and check for any possible damage to rifle from the test.

D. All rifles are moved to Ammunition Inspection Area.

Tool Number

Tooling Description

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D-52367

Line-O-Sighter

Muzzle Chamfer Tools

B-73740 Countersink Tool with "T" handle
B-51634-W Countersink Pilot - 30 caliber (all)
B-51634-V Countersink Pilot - 270 Win
B-51634-U Countersink Pilot - 25-06 Rem
B-51634-T Countersink Pilot - 22 caliber (all RF)
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)

CALIBER
7MM REM. MAG., 338 WIN. MAG.
300 WIN. MAG.
.223 REM.
.243 WIN., 6MM REM.
.280 REM.
7MM-08 REM., .308 WIN., .243 WIN.
30.06 SPRG., .270 REM., 25.06 REM.
257 ROBERTS

USE CLOSE HARD PLUG
C-46200-B
C-46200-A
C-46198 OR D-48349-C
C-46195 OR D-48349-D
D-48349-G
C-46194 OR D-48349-H
C-45930 OR D-48349-J
D-48349-L

(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 SS	Centerfire Rifle	Date: 8/14/2006

Printed on:
~AUTODATE

Operation No: 611	Operation: Test and Target		Work Center:	
Prod. Qty:	Prod. Order #	Setup Inspected by & Date:		
Gage Description and Characteristic	Gage Number	Gage Frequency	Operator	
			1st Shift	2nd Shift
			REJECT	REJECT
			REJECT	REJECT
VISUAL		100%	REJECT	REJECT
	Pieces Run:		Remington Arms Company, Inc. -- Ilion, New York	
	Remarks, Causes, Action Taken, Etc.			

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613 Attach scope rings, scope and bore sight

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

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

For rifles requiring bore sighting continue with the following instructions

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

With Jig E-49994 and optical collimator:

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

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

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

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

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

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the collimator.

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

With Laser device:

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

Place rifle into 100 yd custom shop range nest

Turn laser on

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

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

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

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

place the the gun on the truck

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

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PROCESS CONTROL INSPECTION RECORD THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES				Revision Date: 12-Oct-05		Processed by:	
Part No:		Part Name: Fin Assy 700 SS		Centerfire Rifle		Date: 8/14/2006	
Operation No: 613		Operation: Attach scope rings, scope and fore sight				Work Center:	
Prod. Qty:		Prod. Order #		Operator		Setup Inspected by & Date:	
Gage Description and Characteristic	Gage Number	Gage Frequency	1st Shift	2nd Shift	3rd Shift	Remarks, Causes, Action Taken, Etc.	
VISUAL	VISUAL	100%	INSPECT				
			REJECT				
			INSPECT				
			REJECT				
		Pieces Run:				Remington Arms Company, Inc. - Ilion, New York	

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620 ~~Inspect For Live Ammunition~~

Operation Step Detail Operation: 620

Step Operation / Step Description

Inspect for live ammunition

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

PROCESS CONTROL INSPECTION RECORD THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES			Revision Date: 12-Oct-05			Processed by:	
Part No:	Part Name: Fin Assy 700 SS		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				
			REJECT				

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635 Final Inspection (APL)

Operation Step Detail Operation: 635

Step Operation / Step Description

FINAL INSPECTION

SEQUENCE OF INSPECTION POINTS (See Following)

1. SAFETY
2. STAMPS
3. SPECIFICATIONS
4. GUN GRADES
5. STOCK
6. METAL PARTS, FINISH
7. SAFE
8. STAMP FINAL INSPECTION AND CODE MARKS

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

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

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

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

3. SPECIFICATIONS

a. Gun Matches Hang Tag

b. Receiver Marking:

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

c. Barrel Marking:

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

d. Bolt Marking:

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

4. GUN GRADES

a. ADL

5. STOCK

a. Inspect for Handling Damage

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

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- D. Trigger Guard Screws Tight
 - E. Assemble Correct Rear Swivel - If Specified on Gun Tag
 - b. Stock Rejects only:
 - 1. Place 3/4" Yellow Dot with Identification Stamp and Nonconformity Code, Close to Nonconformity on Stock Rejects
- 6 METAL PARTS, FINISH
 - a. Front Sight Head Not Jammed
 - b. Sights MUST Be Central
 - c. Slight Marks per Inspection Standards ONLY
 - d. Crown Good Finish
 - 1. Accept 1/16" Light Ring at Bore
 - 2. Uniform Wall
 - e. Action:
 - 1. Operate Bolt 3 times and Fire
 - A. No Bind
 - B. Bolt Handle Raises and Lowers Easily
 - 2. Open and Close Bolt Forcibly 3 Times
 - A. Firing Pin MUST Not Follow Down
 - f. Check for Jar Off
 - 1. Place Safety in "F" or "Off" Position
 - 2. Applying Steady Pressure on End of Firing Pin Head Using End of 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

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- E. SAFETY MUST RETURN TO OFF POSITION UNDER TENSION
- C. USE DOWNWARD PRESSURE ON SAFETY
- D. Bolt handle must unlock with safety ON
- E. Safety should snap in detent in both "ON" and "OFF" position
- b. Check Trigger Pull parallel with action
- 4. 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 FINAL INSPECTION AND CODE MARKS

- a. Apply sticker to Gun Tag

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Operation Tool Detail

Operation: 635

Tool Number	Tooling Description
STD	Nylon Cleaning Rod 3/16" Delrin rod approx. 36" long.
STD	Cleaning Brushes (Hoppes or equiv.)
STD	Rem Oil
STD	Dummy Cartridge Rounds of proper Caliber being built.
B-70697	Trigger Pull - Scale
B-TS-7300	Wood Dents & Scuff Template
A-43977	Trigger clearance shim tool (.030)

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 SS		Centerfire Rifle			Date:	8/14/2008
Operation No: 635	Operation: Final Inspection (ADL)					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.	
			INSPECT				
VISUAL	VISUAL	100%	REJECT INSPECT				
Dummy Cartridge Rounds of proper Caliber being built.	STD	100%	REJECT INSPECT				
Trigger Pull - Scale	B-70697	100%	REJECT				

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640 Final Inspection

Operation Step Detail Operation: 640

Step Operation / Step Description

FINAL INSPECTION

SEQUENCE OF INSPECTION POINTS (See Following)

1. SAFETY
2. STAMPS
3. SPECIFICATIONS
4. GUN GRADES
5. STOCK
6. METAL PARTS, FINISH
7. SAFE
8. STAMP FINAL INSPECTION AND CODE MARKS

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

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

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

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

3. SPECIFICATIONS

a. Gun Matches Hang Tag

b. Receiver Marking:

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

c. Barrel Marking:

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

d. Bolt Marking:

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

4. GUN GRADES

- a. Camo or Gray

5. STOCK

a. Inspect for Handling Damage

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

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- D. Trigger Guard Screws Tight
 - E. Assemble Correct Rear Swivel - If Specified on Gun Tag
 - b. Stock Rejects only:
 - 1. Place 3/4" Yellow Dot with Identification Stamp and Nonconformity Code, Close to Nonconformity on Stock Rejects
- 6 METAL PARTS, FINISH
 - a. Front Sight Head Not Jammed
 - b. Sights MUST Be Central
 - c. Slight Marks per Inspection Standards ONLY
 - d. Crown Good Finish
 - 1. Accept 1/16" Light Ring at Base
 - 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

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- E. SAFETY MUST RETURN TO OFF POSITION UNDER TENSION
- C. USE DOWNWARD PRESSURE ON SAFETY
- D. Bolt handle must unlock with safety ON
- E. Safety should snap in detent in both "ON" and "OFF" position
- b. Check Trigger Pull parallel with action
- 4. 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 FINAL INSPECTION AND CODE MARKS

- a. Apply sticker to Gun Tag

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Operation Tool Detail

Operation: 640

Tool Number	Tooling Description
STD	Nylon Cleaning Rod 3/16" Delrin rod approx. 36" long.
STD	Cleaning Brushes (Hoppes or equiv.)
STD	Rem Oil
STD	Dummy Cartridge Rounds of proper Caliber being built.
B-70697	Trigger Pull - Scale
BTS-7300	Wood Dents & Scuff Template
A-43977	Trigger clearance shim tool (.030)

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 SS		Centerfire Rifle			Date:	8/14/2008
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.	
			INSPECT				
VISUAL	VISUAL	100%	REJECT INSPECT				
Dummy Cartridge Rounds of proper Caliber being built.	STD	100%	REJECT INSPECT				
Trigger Pull - Scale	B-70697	100%	REJECT				

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648

Reset trigger pull within specs as needed.
(Not done on 100% of the product)

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

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

Try (3) Times

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

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

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

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- b. Do not break the seal on, or tamper with the other 2 screws.
5. Rerecheck 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-Apr-05			Processed by:	
THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL							
Part No:	Part Name: Fin Assy 700 ADL		Centerfire Rifle			Date: 8/14/2006	
Operation No: 648	Operation: Reset trigger pull within specs as needed.					Work Center:	
Prod. Qty:	Prod. Order #:	Operator			Setup Inspected by & Date:		
Gage Description and Characteristic	Gage Number	Gage Frequency	1st Shift	2nd Shift	3rd Shift	Remarks, Causes, Action Taken, Etc.	
VISUAL	VISUAL	100%	INSPECT REJECT	/	/		
			INSPECT REJECT	/	/		
			INSPECT REJECT	/	/		
			INSPECT REJECT	/	/		
			INSPECT REJECT	/	/		
			INSPECT REJECT	/	/		

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PROCESS CONTROL INSPECTION RECORD THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES			Revision Date: 12-Oct-05			Processed by:
Part No:	Part Name:	Centerfire Rifle			Date:	8/14/2006
Operation No: 648	Operation: Reset trigger pull within specs as needed				Work Center:	
Prod. Qty:	Prod. Order #	Operator			Setup Inspected by & Date:	
Gage Description and Characteristic	Gage Number	Gage Frequency	1st Shift	2nd Shift	3rd Shift	Remarks, Causes, Action Taken, Etc.
VISUAL	VISUAL	100%	INSPECT			
			REJECT INSPECT			
			REJECT INSPECT			
			REJECT INSPECT			
			REJECT INSPECT			
			REJECT INSPECT			
			REJECT INSPECT			
			REJECT INSPECT			
			REJECT INSPECT			
			REJECT			

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

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650 Inspect Heading and Sear Lift

Operation Step Detail Operation: 650

Step Operation / Step Description

Inspect Heading and Sear Lift

Inspect Heading

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

Sear Lift Test

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

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

Operation Tool Detail

Operation: 650

Tool Number	Tooling Description
C-41195-A	6MM REM MIN Heading Plug
C-41195-C	6MM REM IMAX Heading Plug
C-41155-A	223 REM MIN Heading Plug
C-41155-C	223 REM IMAX Heading Plug

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C-41556-A	243 WIN MIN Heading Plug
C-41556-C	243 WIN IMAX Heading Plug
C-41560-A	30-06 MIN Heading Plug
C-41560-C	30-06 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-41556-A	308 WIN MIN Heading Plug
C-41556-C	308 WIN IMAX Heading Plug
C-41560-A	25-06 REM MIN Heading Plug
C-41560-C	25-06 REM IMAX Heading Plug
C-41543-A	257 ROBERTS MIN Heading Plug
C-41543-C	257 ROBERTS IMAX Heading Plug
C-41556-A	7MM-08 REM MIN Heading Plug
C-41556-C	7MM-08 REM IMAX Heading Plug
C-41561-A	264 Win MIN Heading Plug
C-41561-C	264 Win IMAX Heading Plug
C-83853-A	264 Win BELT - MIN Heading Plug
C-83853-C	264 Win BELT - IMAX Heading Plug
C-41578-A	300 WBY MIN Heading Plug
C-41578-C	300 WBY IMAX Heading Plug
C-83853-A	300 WBY BELT - MIN Heading Plug
C-83853-C	300 WBY BELT - 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-42293-A	375 H&H MIN Heading Plug
C-42293-C	375 H&H IMAX Heading Plug
C-42405-A	375 H&H BELT - MIN Heading Plug

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C-42405-C 375 H&H BELT - IMAX Heading Plug
 C-41563-A 7MM Wby Mag MIN Heading Plug
 C-41563-C 7MM Wby Mag IMAX Heading Plug
 C-83853-A 7MM Wby Mag BELT - MIN Heading Plug
 C-83853-C 7MM Wby Mag BELT - IMAX Heading Plug
 C-41561-A 7MM Mag MIN Heading Plug
 C-41561-C 7MM Mag IMAX Heading Plug
 C-83853-A 7MM Mag BELT - MIN Heading Plug
 C-83853-C 7MM Mag BELT - IMAX Heading Plug

D-44581 Dial Gage

Note: Use with 5/64 Balldriver Hex Tool Bondhus Cat.
 #10604, Series 100, or equivalent.

C-47741 Attribute Gage

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 SS		Centerfire Rifle			Date: 8/14/2008		
Operation No: 650	Operation: Inspect Heading and Sear Lift					Work Center:		
Prod. Qty:	Prod. Order #:	Operator			Setup inspected by & Date:			
Gage Description and Characteristic	Gage Number	Gage Frequency	1st Shift	2nd Shift	3rd Shift	Remarks, Causes, Action Taken, Etc.		
			INSPECT					
VISUAL	VISUAL	100%	REJECT INSPECT					
Dial Gage	D-44581	100%	REJECT INSPECT					
Attribute Gage	C-47741	100%	REJECT					

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6MM REM MIN Heading Plug	C-41195-A	100%	INSPECT			
6MM REM IMAX Heading Plug	C-41195-C	100%	REJECT INSPECT			
223 REM MIN Heading Plug	C-41155-A	100%	REJECT INSPECT			
223 REM IMAX Heading Plug	C-41155-C	100%	REJECT INSPECT			
243 WIN MIN Heading Plug	C-41556-A	100%	REJECT INSPECT			
243 WIN IMAX Heading Plug	C-41556-C	100%	REJECT INSPECT			
30-06 MIN Heading Plug	C-41560-A	100%	REJECT INSPECT			
30-06 IMAX Heading Plug	C-41560-C	100%	REJECT INSPECT			
30-06 MIN Heading Plug	C-41560-A	100%	REJECT INSPECT			
30-06 IMAX Heading Plug	C-41560-C	100%	REJECT INSPECT			
30-06 MIN Heading Plug	C-41560-A	100%	REJECT INSPECT			
30-06 IMAX Heading Plug	C-41560-C	100%	REJECT			

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			INSPECT			
30-06 MIN Heading Plug	C-41560-A	100%	REJECT INSPECT			
30-06 IMAX Heading Plug	C-41560-C	100%	REJECT INSPECT			
270 WIN MIN Heading Plug	C-41560-A	100%	REJECT INSPECT			
270 WIN IMAX Heading Plug	C-41560-C	100%	REJECT INSPECT			
270 WIN MIN Heading Plug	C-41560-A	100%	REJECT INSPECT			
270 WIN IMAX Heading Plug	C-41560-C	100%	REJECT INSPECT			
270 WIN MIN Heading Plug	C-41560-A	100%	REJECT INSPECT			
270 WIN IMAX Heading Plug	C-41560-C	100%	REJECT INSPECT			
270 WIN MIN Heading Plug	C-41560-A	100%	REJECT INSPECT			
270 WIN IMAX Heading Plug	C-41560-C	100%	REJECT INSPECT			
280 REM MIN Heading Plug	C-41544-A	100%	REJECT INSPECT			
280 REM IMAX Heading Plug	C-41544-C	100%	REJECT			

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			INSPECT			
280 REM MIN Heading Plug	C-41544-A	100%	REJECT INSPECT			
280 REM IMAX Heading Plug	C-41544-C	100%	REJECT INSPECT			
308 WIN MIN Heading Plug	C-41556-A	100%	REJECT INSPECT			
308 WIN IMAX Heading Plug	C-41556-C	100%	REJECT INSPECT			
25-06 REM MIN Heading Plug	C-41560-A	100%	REJECT INSPECT			
25-06 REM IMAX Heading Plug	C-41560-C	100%	REJECT INSPECT			
25-06 REM MIN Heading Plug	C-41560-A	100%	REJECT INSPECT			
25-06 REM IMAX Heading Plug	C-41560-C	100%	REJECT INSPECT			
257 ROBERTS MIN Heading Plug	C-41543-A	100%	REJECT INSPECT			
257 ROBERTS IMAX Heading Plug	C-41543-C	100%	REJECT INSPECT			
7MM-03 REM MIN Heading Plug	C-41556-A	100%	REJECT INSPECT			
7MM-03 REM IMAX Heading Plug	C-41556-C	100%	REJECT			

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264 Win BELT - MIN Heading Plug	C-83853-A	100%	INSPECT			
264 Win BELT - IMAX Heading Plug	C-83853-C	100%	REJECT INSPECT			
264 Win MIN Heading Plug	C-41561-A	100%	REJECT INSPECT			
264 Win IMAX Heading Plug	C-41561-C	100%	REJECT INSPECT			
300 WBY BELT - MIN Heading Plug	C-83853-A	100%	REJECT INSPECT			
300 WBY BELT - IMAX Heading Plug	C-83853-C	100%	REJECT INSPECT			
300 WBY MIN Heading Plug	C-41578-A	100%	REJECT INSPECT			
300 WBY IMAX Heading Plug	C-41578-C	100%	REJECT INSPECT			
300 Win BELT - MIN Heading Plug	C-83853-A	100%	REJECT INSPECT			
300 Win BELT - IMAX Heading Plug	C-83853-C	100%	REJECT INSPECT			
300 Win MIN Heading Plug	C-41546-A	100%	REJECT INSPECT			
300 Win IMAX Heading Plug	C-41546-C	100%	REJECT			

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

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338 Win BELT - MIN Heading Plug	C-83853-A	100%	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			
375 H&H BELT - MIN Heading Plug	C-42405-A	100%	REJECT INSPECT			
375 H&H BELT - IMAX Heading Plug	C-42405-C	100%	REJECT INSPECT			
375 H&H MIN Heading Plug	C-42293-A	100%	REJECT INSPECT			
375 H&H IMAX Heading Plug	C-42293-C	100%	REJECT INSPECT			
7MM Wby Mag BELT - MIN Heading Plug	C-83853-A	100%	REJECT INSPECT			
7MM Wby Mag BELT - IMAX Heading Plug	C-83853-C	100%	REJECT INSPECT			
7MM Wby Mag MIN Heading Plug	C-41563-A	100%	REJECT INSPECT			
7MM Wby Mag IMAX Heading Plug	C-41563-C	100%	REJECT			

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7MM Mag BELT - MIN Heading Plug	C-83853-A	100%	INSPECT			
7MM Mag BELT - IMAX Heading Plug	C-83853-C	100%	REJECT INSPECT			
7MM Mag MIN Heading Plug	C-41561-A	100%	REJECT INSPECT			
7MM Mag IMAX Heading Plug	C-41561-C	100%	REJECT INSPECT			
7MM Mag BELT - MIN Heading Plug	C-83853-A	100%	REJECT INSPECT			
7MM Mag BELT - IMAX Heading Plug	C-83853-C	100%	REJECT INSPECT			
7MM Mag MIN Heading Plug	C-41561-A	100%	REJECT INSPECT			
7MM Mag IMAX Heading Plug	C-41561-C	100%	REJECT INSPECT			
7MM Mag BELT - MIN Heading Plug	C-83853-A	100%	REJECT INSPECT			
7MM Mag BELT - IMAX Heading Plug	C-83853-C	100%	REJECT INSPECT			
7MM Mag MIN Heading Plug	C-41561-A	100%	REJECT INSPECT			
7MM Mag IMAX Heading Plug	C-41561-C	100%	REJECT			

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

Operation Step Detail Operation: 655

Step Operation / Step Description

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

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

Operation Tool Detail Operation: 655

Tool Number

Tooling Description

Dot Pen Marker

Stylus

Holding Fixture

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665 Assemble Rear Swivel and Swivel Screw Spacer

Operation Step Detail Operation: 665

Step Operation / Step Description

Assemble Rear Swivel Screw and Swivel Screw Spacer

Operation Procedure Notes Operation: 665

Description

Assemble Swivel Screw Spacer and Swivel Screw to Stock Assembly

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 SS		Centerfire Rifle			Date: 8/14/2006	
Operation No: 665	Operation: Assemble Rear Swivel and Swivel Screw Spacer					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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668R Repair bright mars using manual glass bead
blast.

Operation Step Detail Operation: 668R

Step Operation / Step Description

Repair bright mars using manual glass bead blast.

OPERATION TO BE PERFORMED BY TRAINED PERSONNEL ONLY. ALWAYS WEAR
APPROVED PERSONEL PROTECTIVE EQUIPMENT. PERFORM OPERATION IN A DEDICATED
AREA AWAY FROM OTHER EMPLOYEES. MEDIA IS VERY SLIPPERY UNDER FOOT, MOVE
CAREFULLY - RUBBER MATS RECOMMENDED. NEVER TRIGGER THE BLAST GUN WITHOUT
THE RUBBER TIP IN POSITION AND PRESSED FIRMLY AGAINST A WORKPIECE.

Rifles with bright mars can be repaired by spot blasting the affected
areas using a hand-held glass bead blaster as long as there is no metal
damage or deformation. A marred barrel for example may be repaired
without any disassembly of the rifle.

- 1) Pick rifle from gun truck and identify the area to be repaired.
 * It may be necessary to mark the affected area lightly with a pencil
 to assist in locating the mar to be repaired.
- 2) Lock rifle into position in bench vise, or similar fixture with area
 to be repaired facing operator.
- 3) Press rubber blast chamber of gun onto the surface in the area to be

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repaired. Squeeze trigger for 1-2 seconds and check the repaired area to make sure the bright mar is gone.

* There are several interchangeable rubber tips for use with the gun. Each one has a specialized shape and purpose. Use the tip that best seals the media from escaping. The outside of a barrel can be done best with the "v" shaped tip.

4) Return the rifle to the gun truck.

Operation Tool Detail

Operation: 668R

Tool Number	Tooling Description
STD	Gravity Feed Arasive Blasting Gun McMaster-Carr 31195K11
STD	Spot Blasting Kit McMaster-Carr 31195K12
STD	Replacement Ceramic Nozzle McMaster-Carr 31195K13

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 SS		Centerfire Rifle		Date:	8/14/2006
Operation No: 668R	Operation:	Repair bright mars using manual glass bead				Work Center:	
Prod. Qty:	Prod. Order #:	Operator		Setup Inspected by & Date:			

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670 Oil, Assemble Packing Material, Print Box End
Label and Pack Gun, Label and Tape Box

To Warehouse

Operation Step Detail

Operation: 670

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)

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- b. Side of Box (Label)
- c. End of Box (UPS Label)

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.

Operation Tool Detail

Operation: 670

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

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

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676 Oil, Assemble Packing Material, Print Box End
Label and Pack Gun, Label and Tape Box

To Warehouse

Operation Step Detail

Operation: 676

Step

Operation / Step Description

Print Box End label and Pack Rifle

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

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- b. Side of Box (Label)
- c. End of Box (UPS Label)

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.

Operation Tool Detail

Operation: 676

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

PROCESS CONTROL INSPECTION RECORD		Revision Date:	Processed by:
THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES		12-Oct-05	
Part No:	Part Name: Fin Assy 700 SS	Centerfire Rifle	Date: 8/14/2006
Operation No: 676	Operation: Oil, Assemble Packing Material, Print Box End		Work Center:

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Prod. Qty.	
Page Description and Unit Price	

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680 Oil, Assemble Packing Material, Print Box End Label (LABEL MUST STATE "WITH LEUPOLD BASES & RINGS") and Pack Gun, Label and Tape Box, To Warehouse

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

Print Box End label and Pack Rifle

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

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8. Remove Bolt Assy. from rifle, verify last 4 digits of serial # that is marked on bolt Assy., and pack bolt Assy.
9. Pack Rifle into Box.
Note: Pack Scope, base, and rings for 700 ADL's
10. Place Owners Manual in box over Stock
11. Seal Box using reinforced packing tape.
12. Place Box onto conveyor to travel to the warehouse.

Tool Number	Tooling Description
D-43447	Rod
Std	Clean White Cloth Wipes
	Packaging Box Assembly
A-P-1233 1233	Reinforced Packing Tape - 16"x1/2" - 3M #898
Std	Shell Solvent
Std	Steelgard
D-51267	Pallet

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

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Operation No: 680	Operation: OIL Assemble Packing Material Print Box End Label (LABEL MUST STATE WITH LEUPOLD BALL WORK CENTER:					
Prod. Qty:	Prod. Order #:	Setup Inspected by & Date:				
Gage Description and Characteristics	Gage Number	Gage Frequency	Operator			Remarks, Causes, Action Taken, Etc.
			1st Shift	2nd Shift	3rd Shift	
VISUAL	VISUAL	100%	INSPECT			
			REJECT			
			REJECT			
Pieces Run:			Remington Arms Company, Inc. -- Ilion, New York			

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Dept	Oper	Operation Description	Part Numbers
9132	1	Issue from Crib	29690 29692 29694 29696 29706 29707 29708 29709 29711 29712 29713 29717 29727 29729 29731 29735 29737 29739 25929 25931 25933 25935 25943 29728 26293 26295 26297 26299 25881 29715 26420 26440 25883 27263 27265 27267 27269 27271 27273 27253 27255 27251 26309 26311 27137 27139 27141 26336 26407 26409 26425
8761	395	INSPECT COMPONENTS BEFORE HEADING	29690 29692 29694 29696 29706 29707 29708 29709 29711 29712 29713 29717 29727 29729 29731 29735 29737 29739 25929 25931 25933 25935 25943 29728 26293 26295 26297 26299 25881 29715 26420 26440 25883 27263 27265 27267 27269 27271 27273 27253 27255 27251 26309 26311 27137 27139 27141 26336 26407 26409 26425
8761	400	Fit and Head Bolt Assembly to Barrel Assembly	29737 29739 29706 29708 29711 29712 29707 25881 29709 29713 29717 25929 25931 26293 26295 27265 27267 27269

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Dept	Oper	Operation Description	Part Numbers
			27253 27255 27251
			26309 26311 27137
			27139 26407 26409
			26425
8761	405	Fit and Head Bolt Assembly to Barrel Assembly	29729 29735 29731
			25883 27263 26336
8761	415	Fit and Head Bolt Assembly to Barrel Assy and Chamber to Length (Magnums)	29692 29690 29694
			29727 29696 29728
			25933 25935 25943
			26297 26299 29715
			26420 26440 27271
			27273 27141
8761	420	Ream Chamber to Deburr	29692 29690 29694
			29727 29696 29728
			25933 25935 25943
			26297 26299 29715
			26420 26440 27271
			27273 27141
8761	425	Make Chamber Cast (Not Done on 100% of product)	29690 29692 29694
			29696 29706 29707
			29708 29709 29711
			29712 29713 29717
			29727 29729 29731
			29735 29737 29739
			25929 25931 25933
			25935 25943 29728
			26293 26295 26297
			26299 25881 29715
			26420 26440 25883
			27263 27265 27267
			27269 27271 27273
			27253 27255 27251
			26309 26311 27137
			27139 27141 26336
			26407 26409 26425
8761	427	Assemble Rear Sight Assembly and Front Sight to Barrel Assembly	29728
8761	428	Assemble Front & Rear Scope Bases to Barrel Assembly Complete	27137 27139 27141

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Dept	Oper	Operation Description	Part Numbers
8761	430	Ream Ejector Hole	29690 29692 29694 29696 29706 29707 29708 29709 29711 29712 29713 29717 29727 29729 29731 29735 29737 29739 25929 25931 25933 25935 25943 29728 26293 26295 26297 26299 25881 29715 26420 26440 25883 27263 27265 27267 27269 27271 27273 27253 27255 27251 26309 26311 27137 27139 27141 26336 26407 26409 26425
8761	431	Form Radius on Edge of Firing Pin Hole	29706 27251
8761	432	Assemble Riveted Extractor to Bolt - (MAGNUMS)	29692 29690 29694 29727 29696 29728 25935 25943 26295 26299 29715 26420 26440 27271 27273 27253 27255 26309 26311 27141
8761	435	Assemble Rivetless Extractor to Bolt	29707 29709 29713 29717 29729 29735 29731 29737 29739 29706 29708 29711 29712 25929 25933 26293 26297 25881 25931 25883 27263 27265 27267 27269 27251 27137 27139 26336 26407 26409 26425
8761	440	Assemble Ejector to Ejector Spring and then Assemble to Bolt with Ejector Cross Pin	29707 29709 29713 29717 29692 29690 29694 29727 29696 29729 29735 29731 29737 29739 29706 29708 29711 29712

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Dept	Oper	Operation Description	Part Numbers
			25928 25929 25931
			25933 25935 25943
			26299 26293 26295
			26297 25881 29715
			26420 26440 25883
			27263 27265 27267
			27269 27271 27273
			27253 27255 27251
			26309 26311 27137
			27139 27141 26336
			26407 26409 26425
8761	460R	Strip Defective Barrel Assembly Complete	29707 29709 29713
			29717 29692 29690
			29694 29727 29696
			29729 29735 29731
			29737 29739 29706
			29708 29711 29712
			29728 25929 25931
			25933 25935 25943
			26299 26293 26295
			26297 25881 29715
			26420 26440 25883
			27263 27265 27267
			27269 27271 27273
			27253 27255 27251
			26309 26311 27137
			27139 27141 26336
			26407 26409 26425
8761	465R	Strip Defective Bolt	29707 29709 29713
			29717 29692 29690
			29694 29727 29696
			29729 29735 29731
			29737 29739 29706
			29708 29711 29712
			29728 25929 25931
			25933 25935 25943
			26299 26293 26295
			26297 25881 29715
			26420 26440 25883
			27263 27265 27267
			27269 27271 27273
			27253 27255 27251
			26309 26311 27137
			27139 27141 26336

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Dept	Oper	Operation Description	Part Numbers
			26407 26409 26425
8761	550	Assemble Action	29706 29708 29711
			29712 26407 26409
8761	565	Assemble Stock to Action & Attach Build to Tag to Barrel	29706 29708 29711
			29712 26407 26409
8761	580	Assemble Action	29707 29709 29713
			29717 29692 29690
			29694 29727 29696
			29729 29735 29731
			29737 29739 25929
			25931 25933 25935
			25943 29728 26293
			26295 26297 26299
			25881 29715 26420
			26440 25883 27263
			27265 27267 27269
			27271 27273 27253
			27255 27251 26309
			26311 27137 27139
			27141 26336 26425
8761	585	Assemble Stock to Action & Attach Hang Tag to Trigger Guard	29707 29709 29713
			29717 29692 29690
			29694 29727 29696
			29729 29735 29731
			29737 29739 25929
			25931 25933 25935
			25943 29728 26293
			26295 26297 26299
			25881 29715 26420
			26440 25883 27263
			27265 27267 27269
			27271 27273 27253
			27255 27251 26309
			26311 27137 27139
			27141 26336 26425
8761	593	Assemble Front Swivel Screw and Swivel Screw Spacer to Stock	29707 29709 29713
			29717 29692 29690
			29694 29727 29696
			29729 29735 29731
			29737 29739 29706
			29708 29711 29712

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Dept	Oper	Operation Description	Part Numbers
			25929 25931 25933
			25935 25943 29728
			26293 26295 26297
			26299 25881 29715
			26420 26440 25883
			27263 27265 27271
			27273 26309 26311
			26336 26425
8785	600	Proof Test	29707 29709 29713
			29717 29692 29690
			29694 29727 29696
			29729 29735 29731
			29737 29739 29706
			29708 29711 29712
			25929 25931 25933
			25935 25943 29728
			26293 26295 26297
			26299 25881 29715
			26420 26440 25883
			27263 27265 27267
			27269 27271 27273
			27253 27255 27251
			26309 26311 27137
			27139 27141 26336
			26407 26409 26425
8785	600R	Proof Test with slave bolt	29707 29709 29713
			29717 29692 29690
			29694 29727 29696
			29729 29735 29731
			29737 29739 29706
			29708 29711 29712
			25929 25931 25933
			25935 25943 29728
			26293 26295 26297
			26299 25881 29715
			26420 26440 25883
			27263 27265 27267
			27269 27271 27273
			27253 27255 27251
			26309 26311 27137
			27139 27141 26336
			26407 26409 26425
8785	605R	Check Repaired Guns Returning To Gallery For	29707 29709 29713

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Dept	Oper	Operation Description	Part Numbers
		Proof Stamp, Prick Punch and Obstruction In	29717 29692 29690
		Barrel	29694 29727 29696
			29729 29735 29731
			29737 29739 29706
			29708 29711 29712
			25929 25931 25933
			25935 25943 29728
			26293 26295 26297
			26299 25881 29715
			26420 26440 25883
			27263 27265 27267
			27269 27271 27273
			27253 27255 27251
			26309 26311 27137
			27139 27141 26336
			26407 26409 26425
8785	606	Test and Target	29707 29709 29713
			29717 29692 29690
			29694 29727 29696
			29729 29735 29731
			29737 29739 25929
			25931 25933 25935
			25943 29728 26293
			26295 26297 26299
			25881 29715 26420
			26440 25883 27263
			27265 27267 27269
			27271 27273 27253
			27255 27251 26309
			26311 26336 26407
			26409 29706 29708
			29711 29712 26425
8785	611	Test and Target	27137 27139 27141
8785	613	Attach scope rings, scope and bore sight	27137 27139 27141
8785	620	Inspect For Live Ammunition	29707 29709 29713
			29717 29692 29690
			29694 29727 29696
			29729 29735 29731
			29737 29739 29706
			29708 29711 29712
			25929 25931 25933
			25935 25943 29728

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Dept	Oper	Operation Description	Part Numbers
			26293 26295 26297
			26299 25881 29715
			26420 26440 25883
			27263 27265 27267
			27269 27271 27273
			27253 27255 27251
			26309 26311 27137
			27139 27141 26336
			26407 26409 26425
8786	635	Final Inspection (ADL)	29706 29708 29711
			29712 26407 26409
8786	640	Final Inspection	29707 29709 29713
			29717 29692 29690
			29694 29727 29696
			29729 29735 29731
			29737 29739 25929
			25931 25933 25935
			25943 29728 26293
			26295 26297 26299
			25881 29715 26420
			26440 25883 27263
			27265 27267 27269
			27271 27273 27253
			27255 27251 26309
			26311 27137 27139
			27141 26336 26425
8761	648	Reset trigger pull within specs as needed.	29707 29709 29713
			29717 29692 29690
			29694 29727 29696
			29729 29735 29731
			29737 29739 25929
			25931 25933 25935
			25943 29728 26293
			26295 26297 26299
			25881 29715 26420
			26440 25883 27263
			27265 27267 27269
			27271 27273 27253
			27255 27251 26309
			26311 27137 27139
			27141 26336 26407
			26409 29706 29708
			29711 29712 26425

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Dept	Oper	Operation Description	Part Numbers		
8786	650	Inspect Heading and Sear Lift	29707	29709	29713
			29717	29692	29690
			29694	29727	29696
			29729	29735	29731
			29737	29739	29706
			29708	29711	29712
			25929	25931	25933
			25935	25943	29728
			26293	26295	26297
			26299	25881	29715
			26420	26440	25883
			27263	27265	27267
			27269	27271	27273
			27253	27255	27251
			26309	26311	27137
			27139	27141	26336
			26407	26409	26425
8786	655	Mark Bolt to Match Receiver Serial Number Using Dot Peen Marking Machine	29707	29709	29713
			29717	29692	29690
			29694	29727	29696
			29729	29735	29731
			29737	29739	29706
			29708	29711	29712
			25929	25931	25933
			25935	25943	29728
			26293	26295	26297
			26299	25881	29715
			26420	26440	25883
			27263	27265	27267
			27269	27271	27273
			27253	27255	27251
			26309	26311	27137
			27139	27141	26336
			26407	26409	26425
8786	665	Assemble Rear Swivel and Swivel Screw Spacer	29707	29709	29713
			29717	29692	29690
			29694	29727	29696
			29729	29735	29731
			29737	29739	29706
			29708	29711	29712
			25929	25931	25933
			25935	25943	29728
			26293	26295	26297

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Dept	Oper	Operation Description	Part Numbers
			26299 25881 29715
			26420 26440 25883
			27263 27265 27271
			27273 26309 26311
			26336 26425
8761	668R	Repair bright mars using manual glass bead blast.	29707 29709 29713
			29717 29692 29690
			29694 29727 29696
			29729 29735 29731
			29737 29739 29706
			29708 29711 29712
			25929 25931 25933
			25935 25943 29728
			26293 26295 26297
			26299 25881 29715
			26420 26440 25883
			27253 27255 27251
			26309 26311 26336
			26407 26409 26425
8786	670	Oil, Assemble Packing Material, Print Box End Label and Pack Gun, Label and Tape Box To Warehouse	29706 29708 29711
			29712 26407 26409
8786	676	Oil, Assemble Packing Material, Print Box End Label and Pack Gun, Label and Tape Box To Warehouse	29707 29709 29713
			29717 29692 29690
			29694 29727 29696
			29729 29735 29731
			29737 29739 25929
			25931 25933 25935
			25943 29728 26293
			26295 26297 26299
			25881 29715 26420
			26440 25883 27263
			27265 27267 27269
			27271 27273 27253
			27255 27251 26309
			26311 26336 26425
8786	680	Oil, Assemble Packing Material, Print Box End Label and Pack Gun, Label and Tape Box To Warehouse	27137 27139 27141

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Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
							26309 700 LSS S/A MAG - 270 WSM
							- (BLACK LAMINATE)
							26311 700 LSS S/A MAG - 300 WSM
							- (BLACK LAMINATE)
							=====
							26294 700 SS L/A BDL LS LH - 270 WIN
							- (BLACK LAMINATE)
							26297 700 SS L/A BDL LS LH - 7MM REM MAG
							- (BLACK LAMINATE)
							26298 700 SS L/A BDL LS LH - 30-06 SPRG
							- (BLACK LAMINATE)
							26299 700 SS L/A BDL LS LH - 300 WIN MAG
							- (BLACK LAMINATE)
							=====
							25931 700 SS L/A BDL - 30-06 MILLENNIUM
							26425 700 SS L/A CDL FL LTD ED - 30-06 SPRG
							26420 700 BDL SS LIMITED - 7MM REM MAG
							=====
							27263 700 SS S/A SPS - 243 WIN
							27265 700 SS S/A SPS - 7MM-08 REM
							27253 700 SS S/A MAG SPS - 270 WSM
							27255 700 SS S/A MAG SPS - 300 WSM
							=====
							27251 700 SS L/A SPS - 25-06 REM
							27267 700 SS L/A SPS - 270 WIN
							27137 700 SS L/A SPS - 270 WIN W/SCOPE
							27269 700 SS L/A SPS - 30-06 SPRG
							27139 700 SS L/A SPS - 30-06 SPRG W/SCOPE
							27271 700 SS L/A SPS - 7MM REM MAG
							27273 700 SS L/A SPS - 300 WIN MAG
							27141 700 SS L/A SPS - 300 WIN MAG W/SCOPE
							=====
							26407 700 SS ADL SYN CAMO - (NO SIGHTS)
							RT HARDWOODS GRAY HD - 270 WIN
							26409 700 SS ADL SYN CAMO - (NO SIGHTS)
							RT HARDWOODS GRAY HD - 30-06 SPRG
29715							700 SS L/A BDL - .264 WIN MAG
		301049	582	676	1.000		Cable Lock
		105387	37	415	1.000		BARREL ASSEMBLY 26"
		105441	7	415	1.000		BOLT ASSEMBLY
		97444	100	580	1.000		Bolt Stop
		24475	60	580	1.000		Bolt Stop Pin
		15224	30	580	1.000		Bolt Stop Spring
		993002	240	676	1.000		Box & Envelope Label
		3509	20	676	1.000		Instruction Book

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Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
		17017	400	440	1.000		Ejector
		94555	410	440	1.000		Ejector Pin
		17019	420	440	1.000		Ejector Spring
		97322	430	432	1.000		Extractor
		27341	440	432	1.000		Extractor Rivet
		305639	190	580	1.000		Firing Pin Assy
		105403	180	585	1.000		Front Guard Screw
		97824	130	580	1.000		Magazine
		90952	80	585	1.000		Magazine Follower
		15677	40	585	1.000		Magazine Spring
		21764	250	600	1.150		PROOF ROUND .264 WIN MAG
		106292	170	585	1.000		Rear Guard Screw
		17034	90	580	4.000		Receiver Plug Screw
		1687	10	676	1.000		RF-CF Carton
		24476	70	580	1.000		Sear Pin
		106171	210	585	1.000		Stock Assy
		97812	110	593	2.000		Swivel Screw
		94241	500	593	2.000		Swivel Screw Spacer
		29493	505	606	2.000		TEST ROUND .264 WIN MAG 140 gr.PSPCL
		29493	270	606	3.500		TARGET ROUND .264 WIN MAG 140 gr.PSPCL
		97490	120	580	1.000		Trigger Assy
		97866	160	585	1.000		Trigger Guard Assy
25931							700 SS L/A BDL - 30-06 SPRG
		301049	502	676	1.000		Cable Lock
		105577	77	400	1.000		BARREL ASSEMBLY
		105440	67	400	1.000		BOLT ASSEMBLY
		97444	100	580	1.000		Bolt Stop
		24475	60	580	1.000		Bolt Stop Pin
		15224	30	580	1.000		Bolt Stop Spring
		993002	239	676	1.000		Box & Envelope Label
		3509	20	676	1.000		Instruction Book
		17017	400	440	1.000		Ejector
		94555	410	440	1.000		Ejector Pin
		17019	420	440	1.000		Ejector Spring
		93712	430	435	1.000		Extractor
		305639	190	580	1.000		Firing Pin Assy
		105401	180	585	1.000		Front Guard Screw
		97824	130	580	1.000		Magazine
		92218	80	585	1.000		Magazine Follower
		15677	40	585	1.000		Magazine Spring
		21717	240	600	1.100		PROOF ROUND
		106292	170	585	1.000		Rear Guard Screw
		17034	90	580	4.000		Receiver Plug Screw
		1684	10	676	1.000		RF-CF Carton

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Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
		24476	70	580	1.000		Sear Pin
		202708	210	585	1.000		Stock Assy
		15358	110	593	2.000		Swivel Screw
		27826	505	606	2.000		TEST ROUND 30-06 SPRG 150 gr.PSPCL
		21407	260	606	3.500		TARGET ROUND 30-06 SPRG 180 gr.SPCL
		97490	120	580	1.000		Trigger Assy
		97866	160	585	1.000		Trigger Guard Assy
25881							700 SS L/A BDL - 257 RBTS
		301049	502	676	1.000		Cable Lock
		105585	77	400	1.000		BARREL ASSEMBLY
		105440	67	400	1.000		BOLT ASSEMBLY
		97444	100	580	1.000		Bolt Stop
		24475	60	580	1.000		Bolt Stop Pin
		15224	30	580	1.000		Bolt Stop Spring
		993002	230	676	1.000		Box & Envelope Label
		3509	20	676	1.000		Instruction Book
		17017	400	440	1.000		Ejector
		94555	410	440	1.000		Ejector Pin
		17019	420	440	1.000		Ejector Spring
		93712	430	435	1.000		Extractor
		305639	190	580	1.000		Firing Pin Assy
		105401	180	585	1.000		Front Guard Screw
		97824	130	580	1.000		Magazine
		92218	80	585	1.000		Magazine Follower
		15677	40	585	1.000		Magazine Spring
		21704	240	580	1.100		PROOF ROUND
		106292	170	585	1.000		Rear Guard Screw
		17034	90	580	4.000		Receiver Plug Screw
		1684	10	676	1.000		RF-CF Carton
		24476	70	580	1.000		Sear Pin
		34592	210	585	1.000		Stock Assy
		15358	110	593	2.000		Swivel Screw
		28335	505	606	2.000		TEST ROUND - 257 ROBERTS 117 gr. SPCL
		28335	250	606	3.500		TARGET ROUND - 257 ROBERTS 117 gr. SPCL
		97490	120	580	1.000		Trigger Assy
		97866	160	585	1.000		Trigger Guard Assy
29729							700 SS S/A BDL - 223 REM
		301049	502	676	1.000		Cable Lock
		105578	77	400	1.000		BARREL ASSEMBLY
		105443	67	400	1.000		BOLT ASSEMBLY
		97444	100	580	1.000		Bolt Stop
		24475	50	580	1.000		Bolt Stop Pin
		15224	30	580	1.000		Bolt Stop Spring

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Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
		993002	250	676	1.000		Box & Envelope Label
		3509	20	676	1.000		Instruction Book
		17017	400	440	1.000		Ejector
		94555	410	440	1.000		Ejector Pin
		17019	420	440	1.000		Ejector Spring
		97138	430	435	1.000		Extractor
		305640	200	580	1.000		Firing Pin Assy
		98880	300	585	1.000		Floor Plate Insert
		106293	190	585	1.000		Front Guard Screw
		106770	130	580	1.000		Magazine Assy
		92508	70	585	1.000		Magazine Follower
		91133	80	585	1.000		Magazine Spring
		21774	260	600	1.100		PROOF ROUND
		106292	180	585	1.000		Rear Guard Screw
		17034	90	580	4.000		Receiver Plug Screw
		1684	10	676	1.000		RE-CF Carton
		24476	60	580	1.000		Rear Pin
		106172	220	585	1.000		Stock Assy
		97812	110	593	2.000		Swivel Screw
		94241	500	593	2.000		Swivel Screw Spacer
		28399	505	606	2.000		TEST ROUND 223 REM 55 gr.PSP
		28399	270	606	3.500		TARGET ROUND 223 REM 55 gr.PSP
		97490	120	580	1.000		Trigger Assy
		97867	170	585	1.000		Trigger Guard Assy
29735							700 SS S/A BDL - 243 WIN
		301049	502	676	1.000		Cable Lock
		105579	77	405	1.000		BARREL ASSEMBLY
		105442	67	405	1.000		BOLT ASSEMBLY
		97444	100	580	1.000		Bolt Stop
		24475	60	580	1.000		Bolt Stop Pin
		15224	30	580	1.000		Bolt Stop Spring
		993002	250	676	1.000		Box & Envelope Label
		3509	20	676	1.000		Instruction Book
		17017	400	440	1.000		Ejector
		94555	410	440	1.000		Ejector Pin
		17019	420	440	1.000		Ejector Spring
		93712	430	435	1.000		Extractor
		305640	190	580	1.000		Firing Pin Assy
		106293	180	585	1.000		Front Guard Screw
		97825	130	580	1.000		Magazine
		90882	80	585	1.000		Magazine Follower
		15699	40	585	1.000		Magazine Spring
		21699	250	600	1.100		PROOF ROUND
		106292	170	585	1.000		Rear Guard Screw

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Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
		17034	90	580	4.000		Receiver Plug Screw
		1684	10	676	1.000		RF-CF Carton
		24476	70	580	1.000		Sear Pin
		106172	210	585	1.000		Stock Assy
		97812	110	593	2.000		Swivel Screw
		94241	500	593	2.000		Swivel Screw Spacer
		27802	505	606	2.000		TEST ROUND 243 WIN 100 gr.PSPCL
		27802	270	606	3.500		TARGET ROUND 243 WIN 100 gr.PSPCL
		97490	120	580	1.000		Trigger Assy
		97867	160	585	1.000		Trigger Guard Assy
29731							700 SS S/A BDL - 6MM REM
		301049	502	676	1.000		Cable Lock
		105580	77	405	1.000		BARREL ASSEMBLY
		105442	67	405	1.000		BOLT ASSEMBLY
		97444	100	580	1.000		Bolt Stop
		24475	60	580	1.000		Bolt Stop Pin
		15224	30	580	1.000		Bolt Stop Spring
		993002	240	676	1.000		Box & Envelope Label
		3509	20	676	1.000		Instruction Book
		17017	400	440	1.000		Ejector
		94555	410	440	1.000		Ejector Pin
		17019	420	440	1.000		Ejector Spring
		93712	430	435	1.000		Extractor
		305640	190	580	1.000		Firing Pin Assy
		106293	180	585	1.000		Front Guard Screw
		97825	130	580	1.000		Magazine
		90982	80	580	1.000		Magazine Follower
		15699	40	585	1.000		Magazine Spring
		21844	250	600	1.000		PROOF ROUND
		106292	170	585	1.000		Rear Guard Screw
		17034	90	580	4.000		Receiver Plug Screw
		1684	10	676	1.000		RF-CF Carton
		24476	70	580	1.000		Sear Pin
		106172	210	585	1.000		Stock Assy
		97812	110	593	2.000		Swivel Screw
		94241	500	593	2.000		Swivel Screw Spacer
		29051	505	606	2.000		Test Round 6MM REM 100 gr.PSP
		29051	260	606	3.500		Target Round 6MM REM 100 gr.PSP
		97490	120	580	1.000		Trigger Assy
		97867	160	585	1.000		Trigger Guard Assy
29737							700 SS S/A BDL - 7MM-08 REM
		301049	502	676	1.000		Cable Lock
		105581	77	400	1.000		BARREL ASSEMBLY

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Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
		105442	67	400	1.000		BOLT ASSEMBLY
		97444	100	580	1.000		Bolt Stop
		24475	60	580	1.000		Bolt Stop Pin
		15224	30	580	1.000		Bolt Stop Spring
		993002	240	676	1.000		Box & Envelope Label
		3509	20	676	1.000		Instruction Book
		17017	400	440	1.000		Ejector
		94555	410	440	1.000		Ejector Pin
		17019	420	440	1.000		Ejector Spring
		93712	430	435	1.000		Extractor
		305640	190	580	1.000		Firing Pin Assy
		106293	180	585	1.000		Front Guard Screw
		97825	130	580	1.000		Magazine
		15699	40	585	1.000		Magazine Spring
		90982	80	585	1.000		Magazine Follower
		21779	250	600	1.100		BROOF ROUND
		106292	170	585	1.000		Rear Guard Screw
		17034	90	580	4.000		Receiver Plug Screw
		1684	10	676	1.000		RF-CF Carton
		24476	70	580	1.000		Sear Pin
		106172	210	585	1.000		Stock Assy
		97812	110	593	2.000		Swivel Screw
		94241	500	593	2.000		Swivel Screw Spacer
		21337	505	606	2.000		TEST ROUND 7MM-08 REM 140 gr.PSP
		21337	260	606	10.000		TARGET ROUND 7MM-08 REM 140 gr.PSP
		97490	120	580	1.000		Trigger Assy
		97867	160	585	1.000		Trigger Guard Assy
29739							700 SS S/A BDL - 308 WIN
		301049	502	676	1.000		Cable Lock
		105582	77	400	1.000		BARREL ASSEMBLY
		105442	67	400	1.000		BOLT ASSEMBLY
		97444	100	580	1.000		Bolt Stop
		24475	60	580	1.000		Bolt Stop Pin
		15224	30	580	1.000		Bolt Stop Spring
		993002	240	676	1.000		Box & Envelope Label
		3509	20	676	1.000		Instruction Book
		17017	400	440	1.000		Ejector
		94555	410	440	1.000		Ejector Pin
		17019	420	440	1.000		Ejector Spring
		93712	430	435	1.000		Extractor
		305640	190	580	1.000		Firing Pin Assy
		106293	180	585	1.000		Front Guard Screw
		97825	130	580	1.000		Magazine
		15699	40	585	1.000		Magazine Spring

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Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
		90982	80	585	1.000		Magazine Follower
		21723	250	600	1.200		PROOF ROUND
		106292	170	585	1.000		Rear Guard Screw
		17034	90	580	4.000		Receiver Plug Screw
		1684	10	676	1.000		RF-CF Carton
		24476	70	580	1.000		Sear Pin
		106172	210	585	1.000		Stock Assy
		97812	110	593	2.000		Swivel Screw
		94241	500	593	2.000		Swivel Screw Spacer
		27842	505	606	2.000		TEST ROUND 308 WIN 150 gr.PSPCL
		27844	270	606	3.500		TARGET ROUND 308 WIN 180 gr.SPCL
		97490	120	580	1.000		Trigger Assy
		97867	160	585	1.000		Trigger Guard Assy
25883							700 SS 3/A CLASSIC - 220 SWIFT
		301049	502	676	1.000		Cable Lock
		246252	77	405	1.000		BARREL ASSEMBLY
		105442	67	405	1.000		BOLT ASSEMBLY
		97444	100	580	1.000		Bolt Stop
		24475	60	580	1.000		Bolt Stop Pin
		15224	30	580	1.000		Bolt Stop Spring
		993002	240	676	1.000		Box & Envelope Label
		3509	20	676	1.000		Instruction Book
		17017	400	440	1.000		Ejector
		94555	410	440	1.000		Ejector Pin
		17019	420	440	1.000		Ejector Spring
		93712	430	435	1.000		Extractor
		305640	190	580	1.000		Firing Pin Assy
		106293	180	585	1.000		Front Guard Screw
		97825	130	580	1.000		Magazine
		90982	80	585	1.000		Magazine Follower
		15699	40	585	1.000		Magazine Spring
		21806	250	600	1.100		PROOF ROUND
		106292	170	585	1.000		Rear Guard Screw
		17034	90	580	4.000		Receiver Plug Screw
		1684	10	676	1.000		RF-CF Carton
		24476	70	580	1.000		Sear Pin
		93475L	210	585	1.000		Stock Assy
		15356	110	593	2.000		Swivel Screw
		21297	505	606	2.000		TEST ROUND 220 SWIFT 50 gr.PSP
		21297	270	606	3.500		TARGET ROUND 220 SWIFT 50 gr.PSP
		97490	120	580	1.000		Trigger Assy
		97867	160	585	1.000		Trigger Guard Assy
29706							700 SS L/A ADL MTN - 25-06 REM

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Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
		301049	502	676	1.000		Cable Lock
		105560	77	400	1.000		BARREL ASSEMBLY
		105440	67	400	1.000		BOLT ASSEMBLY
		97444	100	550	1.000		Bolt Stop
		24475	50	550	1.000		Bolt Stop Pin
		15224	30	550	1.000		Bolt Stop Spring
		993002	240	670	1.000		Box & Envelope Label
		105405	180	565	1.000		Center Guard Screw
		3509	20	670	1.000		Instruction Book
		17017	400	440	1.000		Ejector
		94555	410	440	1.000		Ejector Pin
		17019	420	440	1.000		Ejector Spring
		93712	430	435	1.000		Extractor
		305639	190	550	1.000		Firing Pin Assy
		105401	170	565	1.000		Front Guard Screw
		97484	120	565	1.000		Front Guard Screw Bushing
		97445	110	550	1.000		Magazine
		92492	70	565	1.000		Magazine Follower
		17028	40	565	1.000		Magazine Spring
		97438	90	565	1.000		Magazine Tab Screw
		21714	250	600	1.100		PROOF ROUND
		106292	160	565	1.000		Rear Guard Screw
		17034	80	550	1.000		Reciever Plug Screw
		1684	10	670	1.000		RF-CF Carton
		24476	60	550	1.000		Rear Pin
		106176	210	565	1.000		Stock Assy
		97812	130	593	2.000		Swivel Screw
		94241	500	593	2.000		Swivel Screw Spacer
		21515	505	606	2.000		TEST ROUND 25-06 REM 120 gr.PSPCL
		21515	270	606	3.500		TARGET ROUND 25-06 REM 120 gr.PSPCL
		97490	140	550	1.000		Trigger Assy
		97499	150	565	1.000		Trigger Guard
29708							700 SS L/A ADL MTN - 270 WIN
		301049	502	676	1.000		Cable Lock
		105561	77	400	1.000		BARREL ASSEMBLY
		105440	67	400	1.000		BOLT ASSEMBLY
		97444	100	550	1.000		Bolt Stop
		24475	50	550	1.000		Bolt Stop Pin
		15224	30	550	1.000		Bolt Stop Spring
		993002	240	670	1.000		Box & Envelope Label
		105405	180	565	1.000		Center Guard Screw
		3509	20	670	1.000		Instruction Book
		17017	400	440	1.000		Ejector
		94555	410	440	1.000		Ejector Pin

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Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
		17019	420	440	1.000		Ejector Spring
		93712	430	435	1.000		Extractor
		305639	190	550	1.000		Firing Pin Assy
		105401	170	565	1.000		Front Guard Screw
		97484	120	565	1.000		Front Guard Screw Bushing
		97445	110	550	1.000		Magazine
		92492	70	565	1.000		Magazine Follower
		17028	40	565	1.000		Magazine Spring
		97438	90	565	1.000		Magazine Tab Screw
		21709	250	600	1.100		PROOF ROUND
		106292	160	565	1.000		Rear Guard Screw
		17034	80	550	4.000		Reliever Plug Screw
		1684	10	670	1.000		RF-CF Carton
		24476	60	550	1.000		Sear Pin
		106176	210	565	1.000		Stock Assy
		97812	130	593	2.000		Swivel Screw
		94241	500	593	2.000		Swivel Screw Spacer
		27810	505	606	2.000		TEST ROUND 270 WIN 150 gr.SPCL
		27810	270	606	3.500		TARGET ROUND 270 WIN 150 gr.SPCL
		97490	140	550	1.000		Trigger Assy
		97499	150	565	1.000		Trigger Guard
29711							700 SS L/A ADL MTN - 280 REM
		301049	502	675	1.000		Cable Lock
		105562	77	400	1.000		BARREL ASSEMBLY
		105440	67	400	1.000		BOLT ASSEMBLY
		97444	100	550	1.000		Bolt Stop
		24475	50	550	1.000		Bolt Stop Pin
		15224	30	550	1.000		Bolt Stop Spring
		993002	240	670	1.000		Box & Envelope Label
		105405	180	565	1.000		Center Guard Screw
		3509	20	670	1.000		Instruction Book
		17017	400	440	1.000		Ejector
		94555	410	440	1.000		Ejector Pin
		17019	420	440	1.000		Ejector Spring
		93712	430	435	1.000		Extractor
		305639	190	550	1.000		Firing Pin Assy
		105401	170	565	1.000		Front Guard Screw
		97484	120	565	1.000		Front Guard Screw Bushing
		97445	110	550	1.000		Magazine
		92492	70	565	1.000		Magazine Follower
		17028	40	565	1.000		Magazine Spring
		97438	90	565	1.000		Magazine Tab Screw
		21710	250	600	1.100		PROOF ROUND
		106292	160	565	1.000		Rear Guard Screw

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Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
		17034	80	550	4.000		Reciever Plug Screw
		1684	10	670	1.000		RF-CF Carton
		24476	60	550	1.000		Sear Pin
		106176	210	565	1.000		Stock Assy
		97812	130	593	2.000		Swivel Screw
		94241	500	593	2.000		Swivel Screw Spacer
		29069	505	606	2.000		TEST ROUND 280 REM 150 gr.PSPCL
		29069	260	606	3.500		TARGET ROUND 280 REM 150 gr.PSPCL
		97490	140	550	1.000		Trigger Assy
		97499	150	565	1.000		Trigger Guard
29712							700 SS L/A ADL MTN - 30-06 SPRG
		301049	502	676	1.000		Cable Lock
		105563	77	400	1.000		BARREL ASSEMBLY
		105440	67	400	1.000		BOLT ASSEMBLY
		97444	100	550	1.000		Bolt Stop
		24475	50	550	1.000		Bolt Stop Pin
		15224	30	550	1.000		Bolt Stop Spring
		993002	240	670	1.000		Box & Envelope Label
		105405	180	565	1.000		Center Guard Screw
		3509	20	670	1.000		Instruction Book
		17017	400	440	1.000		Ejector
		94555	410	440	1.000		Ejector Pin
		17019	420	440	1.000		Ejector Spring
		93712	430	435	1.000		Extractor
		305639	190	550	1.000		Firing Pin Assy
		105401	170	565	1.000		Front Guard Screw
		97484	120	565	1.000		Front Guard Screw Bushing
		97445	110	550	1.000		Magazine
		17028	40	565	1.000		Magazine Spring
		92492	70	565	1.000		Magazine Follower
		97438	90	565	1.000		Magazine Tab Screw
		21717	250	600	1.100		PROOF ROUND
		106292	160	565	1.000		Rear Guard Screw
		17034	80	550	4.000		Reciever Plug Screw
		1684	10	670	1.000		RF-CF Carton
		24476	60	550	1.000		Sear Pin
		106176	210	565	1.000		Stock Assy
		97812	130	593	2.000		Swivel Screw
		94241	500	593	2.000		Swivel Screw Spacer
		27826	505	606	2.000		TEST ROUND 30-06 SPRG 150 gr.PSPCL
		21467	270	606	3.500		TARGET ROUND 30-06 SPRG 180 gr.SPCL
		97490	140	550	1.000		Trigger Assy
		97499	150	565	1.000		Trigger Guard

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Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
29707							700 SS L/A BDL - 25-06 REM
		301049	502	676	1.000		Cable Lock
		105574	77	400	1.000		BARREL ASSEMBLY
		105440	67	400	1.000		BOLT ASSEMBLY
		97444	100	580	1.000		Bolt Stop
		24475	60	580	1.000		Bolt Stop Pin
		15224	30	580	1.000		Bolt Stop Spring
		993002	240	676	1.000		Box & Envelope Label
		3509	20	676	1.000		Instruction Book
		17017	400	440	1.000		Ejector
		94555	410	440	1.000		Ejector Pin
		17019	420	440	1.000		Ejector Spring
		93712	430	435	1.000		Extractor
		305639	190	580	1.000		Firing Pin Assy
		105401	180	585	1.000		Front Guard Screw
		97824	130	580	1.000		Magazine
		92218	80	585	1.000		Magazine Follower
		15677	40	585	1.000		Magazine Spring
		21714	250	600	1.000		PROOF ROUND
		106292	170	585	1.000		Rear Guard Screw
		17034	90	580	4.000		Receiver Plug Screw
		1684	10	676	1.000		RF-CP Carton
		24476	70	580	1.000		Rear Pin
		111302	210	585	1.000		Stock Assy
		97812	110	593	2.000		Swivel Screw
		94241	500	593	2.000		Swivel Screw Spacer
		21515	505	606	3.500		TEST ROUND 25-06 REM 120 gr.PSPCL
		21515	270	606	3.500		TARGET ROUND 25-06 REM 120 gr.PSPCL
		97490	120	580	1.000		Trigger Assy
		97866	160	585	1.000		Trigger Guard Assy
29709							700 SS L/A BDL - 270 WIN
		301049	502	676	1.000		Cable Lock
		105575	77	400	1.000		BARREL ASSEMBLY
		105440	67	400	1.000		BOLT ASSEMBLY
		97444	100	580	1.000		Bolt Stop
		24475	60	580	1.000		Bolt Stop Pin
		15224	30	580	1.000		Bolt Stop Spring
		993002	240	676	1.000		Box & Envelope Label
		3509	20	676	1.000		Instruction Book
		17017	400	440	1.000		Ejector
		94555	410	440	1.000		Ejector Pin
		17019	420	440	1.000		Ejector Spring
		93712	430	435	1.000		Extractor
		305639	190	580	1.000		Firing Pin Assy

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Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
		105401	180	585	1.000		Front Guard Screw
		97824	130	580	1.000		Magazine
		92218	80	585	1.000		Magazine Follower
		15677	40	585	1.000		Magazine Spring
		21709	250	600	1.100		PROOF ROUND
		106292	170	585	1.000		Rear Guard Screw
		17034	90	580	4.000		Receiver Plug Screw
		1684	10	676	1.000		RE-CF Carton
		24476	70	580	1.000		Sear Pin
		106170	210	585	1.000		Stock Assy
		97812	110	593	2.000		Swivel Screw
		94241	500	593	2.000		Swivel Screw Spacer
		27810	505	606	2.000		TEST ROUND 270 WIN 150 gr.SPCL
		27810	270	606	3.500		TARGET ROUND 270 WIN 150 gr.SPCL
		97490	120	580	1.000		Trigger Assy
		97866	160	585	1.000		Trigger Guard Assy
29713							700 SS L/A BDL - 280 REM
		301049	502	676	1.000		Cable Lock
		105576	77	400	1.000		BARREL ASSEMBLY
		105440	67	400	1.000		BOLT ASSEMBLY
		97444	100	580	1.000		Bolt Stop
		24475	60	580	1.000		Bolt Stop Pin
		15224	30	580	1.000		Bolt Stop Spring
		993002	240	676	1.000		Box & Envelope Label
		3509	20	676	1.000		Instruction Book
		17017	400	440	1.000		Ejector
		94555	410	440	1.000		Ejector Pin
		17019	420	440	1.000		Ejector Spring
		93712	430	435	1.000		Extractor
		305639	190	580	1.000		Firing Pin Assy
		105401	180	585	1.000		Front Guard Screw
		97824	130	580	1.000		Magazine
		92218	80	585	1.000		Magazine Follower
		15677	40	585	1.000		Magazine Spring
		21710	250	600	1.100		PROOF ROUND
		106292	170	585	1.000		Rear Guard Screw
		17034	90	580	4.000		Receiver Plug Screw
		1684	10	676	1.000		RE-CF Carton
		24476	70	580	1.000		Sear Pin
		106170	210	585	1.000		Stock Assy
		97812	110	593	2.000		Swivel Screw
		94241	500	593	2.000		Swivel Screw Spacer
		29069	505	606	2.000		TEST ROUND 280 REM 150 gr.PSPCL
		29069	260	606	3.500		TARGET ROUND 280 REM 150 gr.PSPCL

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Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
		97490	120	580	1.000		Trigger Assy
		97866	160	585	1.000		Trigger Guard Assy
29692							700 SS L/A BDL - 7MM REM MAG
		301049	502	676	1.000		Cable Lock
		105564	87	415	1.000		BARREL ASSEMBLY
		105441	77	415	1.000		BOLT ASSEMBLY
		97444	100	580	1.000		Bolt Stop
		24475	60	580	1.000		Bolt Stop Pin
		15224	30	580	1.000		Bolt Stop Spring
		993002	240	676	1.000		Box & Envelope Label
		3509	20	676	1.000		Instruction Book
		17017	400	440	1.000		Ejector
		94555	410	440	1.000		Ejector Pin
		17019	420	440	1.000		Ejector Spring
		97322	430	432	1.000		Extractor
		27341	440	432	1.000		Extractor Rivet
		305639	190	580	1.000		Firing Pin Assy
		105401	180	585	1.000		Front Guard Screw
		97824	130	580	1.000		Magazine
		90952	80	585	1.000		Magazine Follower
		15677	40	585	1.000		Magazine Spring
		21736	250	600	1.150		BROOF ROUND
		106292	170	585	1.000		Rear Guard Screw
		17034	90	580	1.000		Receiver Plug Screw
		1684	10	676	1.000		RF-CF Carton
		24476	70	580	1.000		Sear Pin
		111303	210	580	1.000		Stock Assy
		97812	110	593	2.000		Swivel Screw
		94241	500	593	2.000		Swivel Screw Spacer
		27814	505	606	2.000		TEST ROUND 7MM REM MAG 175 gr.PSPCL
		27814	270	606	3.500		TARGET ROUND 7MM REM MAG 175 gr.PSPCL
		97490	120	580	1.000		Trigger Assy
		97866	160	585	1.000		Trigger Guard Assy
29690							700 SS L/A BDL - 7MM WBY Mag
		301049	502	676	1.000		Cable Lock
		105565	87	415	1.000		BARREL ASSEMBLY
		105441	77	415	1.000		BOLT ASSEMBLY
		97444	100	580	1.000		Bolt Stop
		24475	60	580	1.000		Bolt Stop Pin
		15224	30	580	1.000		Bolt Stop Spring
		993002	240	676	1.000		Box & Envelope Label
		3509	20	676	1.000		Instruction Book
		17017	400	440	1.000		Ejector

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Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
		94555	410	440	1.000		Ejector Pin
		17019	420	440	1.000		Ejector Spring
		97322	430	432	1.000		Extractor
		27341	440	432	1.000		Extractor Rivet
		305639	190	580	1.000		Firing Pin Assy
		105401	180	585	1.000		Front Guard Screw
		97824	130	580	1.000		Magazine
		90952	80	585	1.000		Magazine Follower
		15677	40	585	1.000		Magazine Spring
		21796	250	600	1.150		PROOF ROUND
		106292	170	585	1.000		Rear Guard Screw
		17034	90	580	4.000		Receiver Plug Screw
		1684	10	676	1.000		RF-CF Carton
		24476	70	580	1.000		Sear Pin
		106171	210	585	1.000		Stock Assy
		97812	110	593	2.000		Swivel Screw
		94241	500	593	2.000		Swivel Screw Spacer
		27963	505	606	2.000		TEST ROUND 7MM WBY MAG 175 gr.PSPCL
		27963	270	606	3.500		TARGET ROUND 7MM WBY MAG 175 gr.PSPCL
		97490	120	580	1.000		Trigger Assy
		97866	160	585	1.000		Trigger Guard Assy
29717							700 SS L/A BDL - 30-06 SPRG
		301049	502	676	1.000		Cable Lock
		105577	77	400	1.000		BARREL ASSEMBLY
		105440	67	400	1.000		BOLT ASSEMBLY
		97444	100	580	1.000		Bolt Stop
		24475	60	580	1.000		Bolt Stop Pin
		15224	30	580	1.000		Bolt Stop Spring
		993002	230	676	1.000		Box & Envelope Label
		3509	29	676	1.000		Instruction Book
		17017	400	440	1.000		Ejector
		94555	410	440	1.000		Ejector Pin
		17019	420	440	1.000		Ejector Spring
		93712	430	432	1.000		Extractor
		305639	190	580	1.000		Firing Pin Assy
		105401	180	585	1.000		Front Guard Screw
		97824	130	580	1.000		Magazine
		92316	80	585	1.000		Magazine Follower
		15677	40	585	1.000		Magazine Spring
		21717	240	600	1.100		PROOF ROUND
		106292	170	585	1.000		Rear Guard Screw
		17034	90	580	4.000		Receiver Plug Screw
		1684	10	676	1.000		RF-CF Carton
		24476	70	580	1.000		Sear Pin

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Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
		111302	210	585	1.000		Stock Assy
		97812	110	593	2.000		Swivel Screw
		94241	500	593	2.000		Swivel Screw Spacer
		27826	505	606	2.000		TEST ROUND 30-06 SPRG 150 gr.PSPCL
		21407	260	606	3.500		TARGET ROUND 30-06 SPRG 180 gr.SPCL
		97490	120	580	1.000		Trigger Assy
		97866	160	585	1.000		Trigger Guard Assy
29694							700 SS L/A BDL - 300 WIN MAG
		301049	502	676	1.000		Cable Lock
		105566	87	415	1.000		BARREL ASSEMBLY
		105441	77	415	1.000		BOLT ASSEMBLY
		97444	100	580	1.000		Bolt Stop
		24475	60	580	1.000		Bolt Stop Pin
		15224	30	580	1.000		Bolt Stop Spring
		993002	240	676	1.000		Box & Envelope Label
		3509	20	676	1.000		Instruction Book
		17017	400	440	1.000		Ejector
		94555	410	440	1.000		Ejector Pin
		17019	420	440	1.000		Ejector Spring
		97322	430	432	1.000		Extractor
		27341	440	432	1.000		Extractor Rivet
		305639	190	580	1.000		Firing Pin Assy
		105403	180	585	1.000		Front Guard Screw
		97824	130	580	1.000		Magazine
		90952	80	585	1.000		Magazine Follower
		15677	40	585	1.000		Magazine Spring
		21846	250	606	1.150		PROOF ROUND
		106292	170	585	1.000		Rear Guard Screw
		17034	90	580	4.000		Receiver Plug Screw
		1684	10	676	1.000		RF-CF Carton
		24476	70	580	1.000		Sear Pin
		111303	210	585	1.000		Stock Assy
		97812	110	593	2.000		Swivel Screw
		94241	500	593	2.000		Swivel Screw Spacer
		29497	505	606	2.000		TEST ROUND 300 WIN MAG 180 gr.PSPCL
		29497	270	606	3.500		TARGET ROUND 300 WIN MAG 180 gr.PSPCL
		97490	120	580	1.000		Trigger Assy
		97866	160	585	1.000		Trigger Guard Assy
26440							700 SS L/A BDL - 300 WIN MAG - RMEF 2004
		301049	502	676	1.000		Cable Lock
		105566	87	415	1.000		BARREL ASSEMBLY
		105441	77	415	1.000		BOLT ASSEMBLY
		97444	100	580	1.000		Bolt Stop

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Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
		24475	60	580	1.000		Bolt Stop Pin
		15224	30	580	1.000		Bolt Stop Spring
		993002	240	676	1.000		Box & Envelope Label
		3509	20	676	1.000		Instruction Book
		17017	400	440	1.000		Ejector
		94555	410	440	1.000		Ejector Pin
		17019	420	440	1.000		Ejector Spring
		97322	430	432	1.000		Extractor
		27341	440	432	1.000		Extractor Rivet
		305639	190	580	1.000		Firing Pin Assy
		105403	180	585	1.000		Front Guard Screw
		97824	130	580	1.000		Magazine
		90952	80	585	1.000		Magazine Follower
		15677	40	585	1.000		Magazine Spring
		21846	250	600	1.150		PROOF ROUND
		106292	170	585	1.000		Rear Guard Screw
		17034	90	580	4.000		Receiver Plug Screw
		1684	10	676	1.000		RF-CF Carton
		24476	70	580	1.000		Sear Pin
		111517	210	585	1.000		Stack Assy SYN CAMO - RTH GRAY HD
		97812	110	593	2.000		Swivel Screw
		29497	505	606	2.000		TEST ROUND 300 WIN MAG 180 gr.PSPCL
		29497	270	606	3.500		TARGET ROUND 300 WIN MAG 180 gr.PSPCL
		97490	120	580	1.000		Trigger Assy
		202180	160	585	1.000		Trigger Guard Assy
29727							700 SS L/A BDL - 300 WBY MAG
		301049	502	676	1.000		Cable Lock
		105568	87	415	1.000		BARREL ASSEMBLY
		105441	77	415	1.000		BOLT ASSEMBLY
		97444	100	580	1.000		Bolt Stop
		24475	60	580	1.000		Bolt Stop Pin
		15224	30	580	1.000		Bolt Stop Spring
		993002	240	676	1.000		Box & Envelope Label
		3509	20	676	1.000		Instruction Book
		17017	400	440	1.000		Ejector
		94555	410	440	1.000		Ejector Pin
		17019	420	440	1.000		Ejector Spring
		97322	430	432	1.000		Extractor
		27341	440	432	1.000		Extractor Rivet
		305639	190	580	1.000		Firing Pin Assy
		105403	180	585	1.000		Front Guard Screw
		97824	130	580	1.000		Magazine
		90952	80	585	1.000		Magazine Follower
		15677	40	585	1.000		Magazine Spring

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Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
		21792	250	600	1.175		PROOF ROUND
		106292	170	585	1.000		Rear Guard Screw
		17034	90	580	4.000		Receiver Plug Screw
		1684	10	676	1.000		RF-CF Carton
		24476	70	580	1.000		Sear Pin
		106171	210	585	1.000		Stock Assy
		97812	110	593	2.000		Swivel Screw
		94241	500	593	2.000		Swivel Screw Spacer
		29281	270	606	3.500		TEST ROUND 300 WBY MAG 220 SPCL
		29281	270	606	3.500		TEST ROUND 300 WBY MAG 220 SPCL
		97490	120	580	1.000		Trigger Assy
		97866	160	585	1.000		Trigger Guard Assy
29696							700 35 L/A BDL - 338 WIN MAG
		301049	502	676	1.000		Cable Lock
		105567	87	415	1.000		BARREL ASSEMBLY
		105441	77	415	1.000		BOLT ASSEMBLY
		97444	100	580	1.000		Bolt Stop
		24475	60	580	1.000		Bolt Stop Pin
		15224	30	580	1.000		Bolt Stop Spring
		993002	240	676	1.000		Box & Envelope Label
		3509	20	676	1.000		Instruction Book
		17017	400	440	1.000		Ejector
		94555	410	440	1.000		Ejector Pin
		17019	420	440	1.000		Ejector Spring
		97322	430	432	1.000		Extractor
		27341	440	432	1.000		Extractor Rivet
		305639	190	580	1.000		Firing Pin Assy
		105401	180	585	1.000		Front Guard Screw
		97824	130	580	1.000		Magazine
		90952	80	585	1.000		Magazine Follower
		15677	40	585	1.000		Magazine Spring
		21790	250	600	1.150		PROOF ROUND
		106292	170	585	1.000		Rear Guard Screw
		17034	90	580	4.000		Receiver Plug Screw
		1684	10	676	1.000		RF-CF Carton
		24476	70	580	1.000		Sear Pin
		106171	210	585	1.000		Stock Assy
		97812	110	593	2.000		Swivel Screw
		94241	500	593	2.000		Swivel Screw Spacer
		22191	500	606	2.000		TEST ROUND 338 WIN MAG 250 gr.PSP
		22191	270	606	3.500		TARGET ROUND 338 WIN MAG 250 gr.PSP
		97490	120	580	1.000		Trigger Assy
		97866	160	585	1.000		Trigger Guard Assy

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Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
29728							700 SS L/A BDL - 375 H&H Mag
		301049	502	676	1.000		Cable Lock
		105583	77	415	1.000		BARREL ASSEMBLY
		105441	67	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
		97444	100	580	1.000		Bolt Stop
		24475	60	580	1.000		Bolt Stop Pin
		15224	30	580	1.000		Bolt Stop Spring
		993002	240	676	1.000		Box & Envelope Label
		3509	20	676	1.000		Instruction Book
		17017	400	440	1.000		Ejector
		94555	410	440	1.000		Ejector Pin
		17019	420	440	1.000		Ejector Spring
		97322	430	432	1.000		Extractor
		27341	440	432	1.000		Extractor Rivet
		305639	190	580	1.000		Fixing Pin Assy
		105401	180	585	1.000		Front Guard Screw
		97824	130	580	1.000		Magazine
		90952	80	585	1.000		Magazine Follower
		15677	40	585	1.000		Magazine Spring
		21685	360	600	1.200		PROOF ROUND
		106292	170	585	1.000		Rear Guard Screw
		97437	90	580	4.000		Receiver Plug Screw
		1684	10	676	1.000		RF-CF Carton
		24476	70	580	1.000		Sear Pin
		106171	210	585	1.000		Stock Assy
		97812	110	593	2.000		Swivel Screw
		94241	500	593	2.000		Swivel Screw Spacer
		27917	505	606	2.000		TEST ROUND 375 H&H MAG RS375MA 300 gr.PSP
		27917	370	606	3.500		TARGET ROUND 375 H&H MAG RS375MA 300 gr.PSP
		97490	120	580	1.000		Trigger Assy
		97866	160	585	1.000		Trigger Guard Assy
25929							700 SS L/A BDL LS - 270 WIN
		301049	502	676	1.000		Cable Lock
		105575	77	400	1.000		BARREL ASSEMBLY
		105440	67	400	1.000		BOLT ASSEMBLY
		97444	100	580	1.000		Bolt Stop
		24475	60	580	1.000		Bolt Stop Pin
		15224	30	580	1.000		Bolt Stop Spring
		993002	240	676	1.000		Box & Envelope Label
		3509	20	676	1.000		Instruction Book
		17017	400	440	1.000		Ejector

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Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
		94555	410	440	1.000		Ejector Pin
		17019	420	440	1.000		Ejector Spring
		93712	430	435	1.000		Extractor
		305639	190	580	1.000		Firing Pin Assy
		105403	180	585	1.000		Front Guard Screw
		97824	130	580	1.000		Magazine
		92218	80	585	1.000		Magazine Follower
		15677	40	585	1.000		Magazine Spring
		21709	250	600	1.100		PROOF ROUND
		106292	170	585	1.000		Rear Guard Screw
		17034	90	580	4.000		Receiver Plug
		1684	10	676	1.000		RF-CF Carton-Green
		24476	70	580	1.000		Sear Pin
		202708	210	585	1.000		Stock Assy
		15358	110	593	2.000		Swivel Screw
		27810	505	606	2.000		TEST ROUND 270 WIN 150 gr.SPCL
		27810	270	606	3.500		TARGET ROUND 270 WIN 150 gr.SPCL
		97490	120	580	1.000		Trigger Assy
		97866	160	585	1.000		Trigger Guard Assy
25933							700 SS L/A BDL LS - 7MM REM MAG
		301049	502	676	1.000		Cable Lock
		105564	87	415	1.000		BARREL ASSEMBLY
		105441	77	415	1.000		BOLT ASSEMBLY
		97444	100	580	1.000		Bolt Stop
		24475	60	580	1.000		Bolt Stop Pin
		15224	30	580	1.000		Bolt Stop Spring
		993002	240	676	1.000		Box & Envelope Label
		3509	20	676	1.000		Instruction Book
		17017	400	440	1.000		Ejector
		94555	410	440	1.000		Ejector Pin
		17019	420	440	1.000		Ejector Spring
		97322	430	435	1.000		Extractor
		27341	440	435	1.000		Extractor Rivet
		305639	190	580	1.000		Firing Pin Assy
		105403	180	585	1.000		Front Guard Screw
		97824	130	580	1.000		Magazine
		90952	80	585	1.000		Magazine Follower
		15677	40	585	1.000		Magazine Spring
		21736	250	600	1.150		PROOF ROUND
		106292	170	585	1.000		Rear Guard Screw
		17034	90	580	4.000		Receiver Plug
		1684	10	676	1.000		RF-CF Carton-Green
		24476	70	580	1.000		Sear Pin
		202346	210	585	1.000		Stock Assy R3

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Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
		15358	110	593	2.000		Swivel Screw
		27814	505	606	2.000		TEST ROUND 7MM REM MAG 175 gr.PSPCL
		27814	270	606	3.500		TARGET ROUND 7MM REM MAG 175 gr.PSPCL
		97490	120	580	1.000		Trigger Assy
		97866	160	585	1.000		Trigger Guard Assy
25935							700 SS L/A BDL LS - 300 WIN MAG
		301049	502	676	1.000		Cable Lock
		105566	87	415	1.000		BARREL ASSEMBLY
		105441	77	415	1.000		BOLT ASSEMBLY
		97444	100	580	1.000		Bolt Stop
		24475	60	580	1.000		Bolt Stop Pin
		15224	30	580	1.000		Bolt Stop Spring
		993002	240	676	1.000		Box & Envelope Label
		3509	20	676	1.000		Instruction Book
		17017	400	440	1.000		Ejector
		94555	410	440	1.000		Ejector Pin
		17019	420	440	1.000		Ejector Spring
		97322	430	432	1.000		Extractor
		27341	440	432	1.000		Extractor Rivet
		305639	190	580	1.000		Firing Pin Assy
		105403	180	585	1.000		Front Guard Screw
		15677	40	585	1.000		Magazine Spring
		97824	130	580	1.000		Magazine
		90952	80	585	1.000		Magazine Follower
		21846	250	600	1.150		PROOF ROUND
		106292	170	585	1.000		Rear Guard Screw
		17034	90	580	4.000		Receiver Plug
		1684	10	676	1.000		RF-CF Carton-Green
		24476	70	580	1.000		Sear Pin
		2023461	210	585	1.000		Stock Assy R3
		15358	110	593	2.000		Swivel Screw
		29497	505	606	2.000		TEST ROUND 300 WIN MAG 180 gr.PSPCL
		29497	270	606	3.500		TARGET ROUND 300 WIN MAG 180 gr.PSPCL
		97490	120	580	1.000		Trigger Assy
		97866	160	585	1.000		Trigger Guard Assy
25943							700 SS L/A BDL LS - 338 WIN MAG
		301049	502	676	1.000		Cable Lock
		105567	87	415	1.000		BARREL ASSEMBLY
		105441	77	415	1.000		BOLT ASSEMBLY
		97444	100	580	1.000		Bolt Stop
		24475	60	580	1.000		Bolt Stop Pin
		15224	30	580	1.000		Bolt Stop Spring
		993002	240	676	1.000		Box & Envelope Label

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Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
		3509	20	676	1.000		Instruction Book
		17017	400	440	1.000		Ejector
		94555	410	440	1.000		Ejector Pin
		17019	420	440	1.000		Ejector Spring
		97322	430	432	1.000		Extractor
		27341	440	432	1.000		Extractor Rivet
		305639	190	580	1.000		Firing Pin Assy
		105401	180	585	1.000		Front Guard Screw
		97824	130	580	1.000		Magazine
		90952	80	585	1.000		Magazine Follower
		15677	40	585	1.000		Magazine Spring
		21790	250	600	1.150		PROOF ROUND
		106292	170	585	1.000		Rear Guard Screw
		17034	90	580	4.000		Receiver Plug
		1684	10	676	1.000		RF-CF Carton-Green
		24476	70	580	1.000		Sear Pin
		202346	210	585	1.000		Stock Assy
		15358	110	593	2.000		Swivel Screw
		22191	505	606	2.000		TEST ROUND 338 WIN MAG 250 gr.PSP
		22191	270	606	3.500		TARGET ROUND 338 WIN MAG 250 gr.PSP
		97490	120	580	1.000		Trigger Assy
		97866	160	585	1.000		Trigger Guard Assy
26336							700 LSS S/A BDL - 243 WIN - (BLACK LAMINATE)
		301049	502	676	1.000		Cable Lock
		105579	77	405	1.000		BARREL ASSEMBLY
		105442	67	405	1.000		BOLT ASSEMBLY
		97444	100	580	1.000		Bolt Stop
		24475	60	580	1.000		Bolt Stop Pin
		15224	30	580	1.000		Bolt Stop Spring
		993002	240	676	1.000		Box & Envelope Label
		3509	20	676	1.000		Instruction Book
		17017	400	440	1.000		Ejector
		94555	410	440	1.000		Ejector Pin
		17019	420	440	1.000		Ejector Spring
		93712	430	435	1.000		Extractor
		305640	190	580	1.000		Firing Pin Assy
		106293	180	585	1.000		Front Guard Screw
		97825	130	580	1.000		Magazine
		90982	80	585	1.000		Magazine Follower
		15699	40	585	1.000		Magazine Spring
		21899	250	600	1.100		PROOF ROUND
		106292	170	585	1.000		Rear Guard Screw
		17034	90	580	4.000		Receiver Plug Screw
		1684	10	676	1.000		RF-CF Carton

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Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
		24476	70	580	1.000		Sear Pin
		202682	210	585	1.000		Stock Assy
		97812	110	593	2.000		Swivel Screw
		94241	500	593	2.000		Swivel Screw Spacer
		27802	505	606	2.000		TEST ROUND 243 WIN 100 gr.PSPCL
		21319	270	606	3.500		TEST ROUND 243 WIN 80 gr.TARGET
		97490	120	580	1.000		Trigger Assy
		97867	160	585	1.000		Trigger Guard Assy
26309							700 LSS S/A MAG - 270 WSM -(BLACK LAMINATE)
		301049	502	676	1.000		Cable Lock
		245316	17	400	1.000		BARREL ASSEMBLY
		98478	27	400	1.000		BOLT ASSEMBLY
		97444	100	580	1.000		Bolt Stop
		24475	60	580	1.000		Bolt Stop Pin
		15224	30	580	1.000		Bolt Stop Spring
		993002	240	676	1.000		Box & Envelope Label
		3509	20	676	1.000		Instruction Book
		201843	400	440	1.000		Ejector
		94555	410	440	1.000		Ejector Pin
		201841	420	440	1.000		Ejector Spring
		97322	430	435	1.000		Extractor
		27341	440	432	1.000		Extractor Rivet
		305640	190	580	1.000		Firing Pin Assy
		106293	180	585	1.000		Front Guard Screw
		110648	130	580	1.000		Magazine
		110855	80	585	1.000		Magazine Follower
		201849	40	585	1.000		Magazine Spring
		202720	250	600	1.000		PROOF ROUND
		106292	170	585	1.000		Rear Guard Screw
		17034	90	580	4.000		Receiver Plug Screw
		1684	10	676	1.000		RF-CF Carton-Green
		24476	70	580	1.000		Sear Pin
		202591	210	585	1.000		Stock Assy - BLACK LAMINATE
		97812	110	593	2.000		Swivel Screw
		28940	505	606	2.000		TEST ROUND 270 WSM OHL
		28940	270	606	3.500		TARGET ROUND 270 WSM OHL
		97490	120	580	1.000		Trigger Assy
		97867	160	585	1.000		Trigger Guard Assy
26311							700 LSS S/A MAG - 300 WSM -(BLACK LAMINATE)
		301049	502	676	1.000		Cable Lock
		245316	17	400	1.000		BARREL ASSEMBLY
		98478	27	400	1.000		BOLT ASSEMBLY
		97444	100	580	1.000		Bolt Stop
		24475	60	580	1.000		Bolt Stop Pin

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Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
		15224	30	580	1.000		Bolt Stop Spring
		993002	240	676	1.000		Box & Envelope Label
		3509	20	676	1.000		Instruction Book
		201843	400	440	1.000		Ejector
		94555	410	440	1.000		Ejector Pin
		201841	420	440	1.000		Ejector Spring
		97322	430	435	1.000		Extractor
		27341	440	432	1.000		Extractor Rivet
		305640	190	580	1.000		Firing Pin Assy
		106293	180	585	1.000		Front Guard Screw
		110848	130	580	1.000		Magazine
		110855	80	585	1.000		Magazine Follower
		201849	40	585	1.000		Magazine Spring
		114200	250	600	1.100		PROOF ROUND - DF300WSM 180GR WIN. POWER PT
		106292	170	585	1.000		Rear Guard Screw
		17034	90	580	4.000		Receiver Plug Screw
		1684	10	676	1.000		RE-CF Carton-Green
		24476	70	580	1.000		Rear Pin
		202591	210	585	1.000		Stock Assy - BLACK LAMINATE
		97812	110	593	2.000		Swivel Screw
		114220	505	606	2.000		TEST ROUND - X300WSM 180gr.WIN POWER PT
		114220	270	606	3.500		TARGET ROUND - X300WSM 180gr.WIN POWER PT
		97490	120	580	1.000		Trigger Assy
		97867	160	585	1.000		Trigger Guard Assy
26293							700 SS L/A BDL LS LH - 270 WIN
							(BLACK LAMINATE)
		301049	502	676	1.000		Cable Lock
		108290	17	400	1.000		BARREL ASSEMBLY
		108315	27	400	1.000		BOLT ASSEMBLY
		97444	109	580	1.000		Bolt Stop
		24475	60	580	1.000		Bolt Stop Pin
		90554	30	580	1.000		Bolt Stop Spring
		993002	240	676	1.000		Box & Envelope Label
		3509	20	676	1.000		Instruction Book
		17017	400	440	1.000		Ejector
		94555	410	440	1.000		Ejector Pin
		17019	420	440	1.000		Ejector Spring
		93712	430	435	1.000		Extractor
		305640	190	580	1.000		Firing Pin Assy
		105402	180	585	1.000		Front Guard Screw
		97824	130	580	1.000		Magazine
		92216	80	585	1.000		Magazine Follower
		15677	40	585	1.000		Magazine Spring
		21709	250	600	1.100		PROOF ROUND
		106292	170	585	1.000		Rear Guard Screw

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Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
		17034	90	580	4.000		Receiver Plug Screw
		1684	10	676	1.000		RF-CF Carton-Green
		24476	70	580	1.000		Sear Pin
		105795	210	585	1.000		Stock Assy
		15358	110	593	2.000		Swivel Screw
		27810	505	606	2.000		TEST ROUND 270 WIN 150 gr.SPCL
		27810	270	606	3.500		TARGET ROUND 270 WIN 150 gr.SPCL
		99861	120	580	1.000		Trigger Assy
		97866	160	585	1.000		Trigger Guard Assy
26297							700 SS L/A BDL LS LH - 7MM REM MAG
							(BLACK LAMINATE)
		301049	502	676	1.000		Cable Lock
		108292	17	400	1.000		BARREL ASSEMBLY
		108316	27	400	1.000		BOLT ASSEMBLY
		97444	100	580	1.000		Bolt Stop
		24475	60	580	1.000		Bolt Stop Pin
		90554	30	580	1.000		Bolt Stop Spring
		993002	240	676	1.000		Box & Envelope Label
		3509	20	676	1.000		Instruction Book
		17017	400	440	1.000		Ejector
		94555	410	440	1.000		Ejector Pin
		17019	420	440	1.000		Ejector Spring
		97322	430	432	1.000		Extractor
		27341	440	432	1.000		Extractor Rivet
		305639	190	580	1.000		Firing Pin Assy
		105402	180	585	1.000		Front Guard Screw
		97824	130	580	1.000		Magazine
		90952	80	585	1.000		Magazine Follower
		15677	40	585	1.000		Magazine Spring
		21736	250	600	1.150		PROOF ROUND
		106292	170	585	1.000		Rear Guard Screw
		17034	90	580	4.000		Receiver Plug Screw
		1684	10	676	1.000		RF-CF Carton-Green
		24476	70	580	1.000		Sear Pin
		113137	210	585	1.000		Stock Assy
		15358	110	593	2.000		Swivel Screw
		27814	505	606	2.000		TEST ROUND 7MM REM MAG 175 gr.PSPCL
		27814	270	606	3.500		TARGET ROUND 7MM REM MAG 175 gr.PSPCL
		99861	120	580	1.000		Trigger Assy
		97866	160	585	1.000		Trigger Guard Assy
26295							700 SS L/A BDL LS LH - 30-06 SPRG
							(BLACK LAMINATE)
		301049	502	676	1.000		Cable Lock

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Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
		108291	17	400	1.000		BARREL ASSEMBLY
		108315	27	400	1.000		BOLT ASSEMBLY
		97444	100	580	1.000		Bolt Stop
		24475	60	580	1.000		Bolt Stop Pin
		90554	30	580	1.000		Bolt Stop Spring
		993002	230	676	1.000		Box & Envelope Label
		3509	20	676	1.000		Instruction Book
		17017	400	440	1.000		Ejector
		94555	410	440	1.000		Ejector Pin
		17019	420	440	1.000		Ejector Spring
		93712	430	435	1.000		Extractor
		305639	190	580	1.000		Firing Pin Assy
		105402	180	585	1.000		Front Guard Screw
		97824	130	580	1.000		Magazine
		92218	80	585	1.000		Magazine Follower
		15677	40	585	1.000		Magazine Spring
		21717	250	600	1.100		PROOF ROUND
		106292	170	585	1.000		Rear Guard Screw
		17034	90	580	4.000		Receiver Plug Screw
		1684	10	676	1.000		RF-CP Carton-Green
		24476	70	580	1.000		Sear Pin
		105795	210	585	1.000		Stock Assy
		15358	110	593	2.000		Swivel Screw
		27826	505	606	2.000		TEST ROUND 30-06 SPRG 150 gr.PSPCL
		21407	270	606	3.500		TARGET ROUND 30-06 SPRG 180 gr.SPCL
		99861	120	580	1.000		Trigger Assy
		97866	160	585	1.000		Trigger Guard Assy
26299							700 SS L/A BDL LS LH - 300 WIN MAG
							(BLACK LAMINATE)
		301049	50	676	1.000		Cable Lock
		108293	17	400	1.000		BARREL ASSEMBLY
		108316	27	400	1.000		BOLT ASSEMBLY
		97444	100	580	1.000		Bolt Stop
		24475	60	580	1.000		Bolt Stop Pin
		90554	30	580	1.000		Bolt Stop Spring
		993002	240	676	1.000		Box & Envelope Label
		3509	20	676	1.000		Instruction Book
		17017	400	440	1.000		Ejector
		94555	410	440	1.000		Ejector Pin
		17019	420	440	1.000		Ejector Spring
		93712	430	432	1.000		Extractor
		27341	440	432	1.000		Extractor Rivet
		305639	190	580	1.000		Firing Pin Assy
		105402	180	585	1.000		Front Guard Screw

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Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
		97824	130	580	1.000		Magazine
		90952	80	585	1.000		Magazine Follower
		15677	40	585	1.000		Magazine Spring
		21846	250	600	1.150		PROOF ROUND
		106292	170	585	1.000		Rear Guard Screw
		17034	90	580	4.000		Receiver Plug Screw
		1684	10	676	1.000		RF-CF Carton Green
		24476	70	580	1.000		Sear Pin
		113137	210	585	1.000		Stock Assy
		15358	110	593	2.000		Swivel Screw
		29497	505	606	2.000		TEST ROUND 300 WIN MAG 180 gr.PSPCL
		29497	270	606	3.500		TARGET ROUND 300 WIN MAG 180 gr.PSPCL
		99861	120	580	1.000		Trigger Assy
		97866	160	585	1.000		Trigger Guard Assy
26425							700 SS L/A CDL FL LTD ED - 30-06 SPRG
		301049	502	676	1.000		Cable Lock
		109284	77	400	1.000		BARREL ASSEMBLY
		105440	67	400	1.000		BOLT ASSEMBLY
		97444	100	580	1.000		Bolt Stop
		24475	60	580	1.000		Bolt Stop Pin
		15224	30	580	1.000		Bolt Stop Spring
		993002	230	676	1.000		Box & Envelope Label
		3509	20	676	1.000		Instruction Book
		17017	400	440	1.000		Ejector
		94555	410	440	1.000		Ejector Pin
		17019	420	440	1.000		Ejector Spring
		93712	430	440	1.000		Extractor
		305639	190	580	1.000		Firing Pin Assy
		106293	180	585	1.000		Front Guard Screw
		97824	130	580	1.000		Magazine
		92218	80	585	1.000		Magazine Follower
		15677	40	585	1.000		Magazine Spring
		21717	240	600	1.100		PROOF ROUND
		106292	170	585	1.000		Rear Guard Screw
		17034	90	580	4.000		Receiver Plug Screw
		1684	10	676	1.000		RF-CF Carton
		24476	70	580	1.000		Sear Pin
		202267	210	585	1.000		Stock Assy
		15358	110	593	2.000		Swivel Screw
		94241	500	593	2.000		Swivel Screw Spacer
		27828	250	606	2.000		TEST ROUND 30-06 SPRG 150 gr.PSPCL
		21407	270	606	3.500		TARGET ROUND 30-06 SPRG 180 gr.SPCL
		97490	120	580	1.000		Trigger Assy
		202810	160	585	1.000		Trigger Guard Assy

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Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
26420							700 BDL SS LIMITED - 7MM REM MAG
		301049	502	676	1.000		Cable Lock
		202094	87	415	1.000		BARREL ASSEMBLY LIMITED
		105441	77	415	1.000		BOLT ASSEMBLY
		97444	100	580	1.000		Bolt Stop
		24475	60	580	1.000		Bolt Stop Pin
		15224	30	580	1.000		Bolt Stop Spring
		993002	240	676	1.000		Box & Envelope Label
		3509	20	676	1.000		Instruction Book
		17017	400	440	1.000		Ejector
		94555	410	440	1.000		Ejector Pin
		17019	420	440	1.000		Ejector Spring
		97322	430	432	1.000		Extractor
		27341	440	432	1.000		Extractor Rivet
		305639	190	580	1.000		Fixing Pin Assy
		105401	180	585	1.000		Front Guard Screw
		97824	130	580	1.000		Magazine
		90952	80	585	1.000		Magazine Follower
		15677	40	585	1.000		Magazine Spring
		21736	250	600	1.150		PROOF ROUND
		106292	170	585	1.000		Rear Guard Screw
		17034	90	580	4.000		Receiver Plug Screw
		1684	10	676	1.000		RF-CF Carton
		24476	70	580	1.000		Rear Pin
		98979	210	585	1.000		Stock Assy
		97812	110	593	2.000		Swivel Screw
		27814	505	606	2.000		TEST ROUND 7MM REM MAG 175 gr.PSPCL
		27814	270	606	3.500		TARGET ROUND 7MM REM MAG 175 gr.PSPCL
		97490	120	580	1.000		Trigger Assy
		97866	160	585	1.000		Trigger Guard Assy
27263							700 SS S/A SPS - 243 WIN
		301049	502	676	1.000		Cable Lock
		249220	72	405	1.000		BARREL ASSEMBLY
		105442	8	405	1.000		BOLT ASSEMBLY
		97444	100	580	1.000		Bolt Stop
		24475	60	580	1.000		Bolt Stop Pin
		15224	30	580	1.000		Bolt Stop Spring
		993002	240	676	1.000		Box & Envelope Label
		3509	20	676	1.000		Instruction Book
		17017	400	440	1.000		Ejector
		94555	410	440	1.000		Ejector Pin
		17019	420	440	1.000		Ejector Spring
		93712	430	435	1.000		Extractor

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Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
		305640	190	580	1.000		Firing Pin Assy
		106293	180	585	1.000		Front Guard Screw
		97825	130	580	1.000		Magazine
		92455	80	585	1.000		Magazine Follower
		15699	40	585	1.000		Magazine Spring
		21699	250	600	1.100		PROOF ROUND
		106292	170	585	1.000		Rear Guard Screw
		17034	90	580	4.000		Receiver Plug Screw
		1684	10	676	1.000		RF-CF Carton
		24476	70	580	1.000		Sear Pin
		113527	210	585	1.000		Stock Assy
		94996	110	593	2.000		Swivel Screw
		27802	505	606	2.000		TEST ROUND 243 WIN 100 gr.PSPCL
		21319	270	606	3.500		TEST ROUND 243 WIN 80 gr.TARGET
		97490	120	580	1.000		Trigger Assy
		97867	160	585	1.000		Trigger Guard Assy
27265							700 S&W 3/A SPS - 7MM-08 REM
		301049	502	676	1.000		Cable Lock
		249221	77	400	1.000		BARREL ASSEMBLY
		105442	67	400	1.000		BOLT ASSEMBLY
		97444	100	580	1.000		Bolt Stop
		24475	60	580	1.000		Bolt Stop Pin
		15224	30	580	1.000		Bolt Stop Spring
		993002	240	676	1.000		Box & Envelope Label
		3509	20	676	1.000		Instruction Book
		17017	400	440	1.000		Ejector
		94555	410	440	1.000		Ejector Pin
		17019	420	440	1.000		Ejector Spring
		93712	430	435	1.000		Extractor
		305640	190	580	1.000		Firing Pin Assy
		106293	180	585	1.000		Front Guard Screw
		97825	130	580	1.000		Magazine
		15699	40	585	1.000		Magazine Spring
		92455	80	585	1.000		Magazine Follower
		21779	250	600	1.100		PROOF ROUND
		106292	170	585	1.000		Rear Guard Screw
		17034	90	580	4.000		Receiver Plug Screw
		1684	10	676	1.000		RF-CF Carton
		24476	70	580	1.000		Sear Pin
		113527	210	585	1.000		Stock Assy
		94996	110	593	2.000		Swivel Screw
		21337	505	606	2.000		TEST ROUND 7MM-08 REM 140 gr.PSP
		21337	260	606	8.000		TARGET ROUND 7MM-08 REM 140 gr.PSP
		97490	120	580	1.000		Trigger Assy

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Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
		97867	160	585	1.000		Trigger Guard Assy
27253							700 SS S/A MAG SPS - 270 WSM
		301049	502	676	1.000		Cable Lock
		249231	17	400	1.000		BARREL ASSEMBLY
		98478	27	400	1.000		BOLT ASSEMBLY
		97444	100	580	1.000		Bolt Stop
		24475	60	580	1.000		Bolt Stop Pin
		15224	30	580	1.000		Bolt Stop Spring
		993002	240	676	1.000		Box & Envelope Label
		3509	20	676	1.000		Instruction Book
		201843	400	440	1.000		Ejector
		94555	410	440	1.000		Ejector Pin
		201841	420	440	1.000		Ejector Spring
		97322	430	435	1.000		Extractor
		27341	440	432	1.000		Extractor Rivet
		305640	190	580	1.000		Firing Pin Assy
		106293	180	585	1.000		Front Guard Screw
		110848	130	580	1.000		Magazine
		110855	80	585	1.000		Magazine Follower
		201849	40	585	1.000		Magazine Spring
		202720	250	600	1.000		PROOF ROUND
		106292	170	585	1.000		Rear Guard Screw
		17034	90	580	4.000		Receiver Plug Screw
		1684	10	676	1.000		RF-CF Carton-Green
		24476	70	580	1.000		Sear Pin
		113529	210	585	1.000		Stock Assy
		28940	505	606	2.000		TEST ROUND 270 WSM OHL
		28940	270	606	3.500		Target ROUND 270 WSM OHL
		97490	120	580	1.000		Trigger Assy
		97867	160	585	1.000		Trigger Guard Assy
27255							700 SS S/A MAG SPS - 300 WSM
		301049	502	676	1.000		Cable Lock
		249232	17	400	1.000		BARREL ASSEMBLY
		98478	27	400	1.000		BOLT ASSEMBLY
		97444	100	580	1.000		Bolt Stop
		24475	60	580	1.000		Bolt Stop Pin
		15224	30	580	1.000		Bolt Stop Spring
		993002	240	676	1.000		Box & Envelope Label
		3509	20	676	1.000		Instruction Book
		201843	400	440	1.000		Ejector
		94555	410	440	1.000		Ejector Pin
		201841	420	440	1.000		Ejector Spring
		97322	430	435	1.000		Extractor

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Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
		27341	440	432	1.000		Extractor Rivet
		305640	190	580	1.000		Firing Pin Assy
		106293	180	585	1.000		Front Guard Screw
		110848	130	580	1.000		Magazine
		110855	80	585	1.000		Magazine Follower
		201849	40	585	1.000		Magazine Spring
		114200	250	600	1.100		PROOF ROUND - DP300WSM 180GR WIN. POWER PT
		106292	170	585	1.000		Rear Guard Screw
		17034	90	580	4.000		Receiver Plug Screw
		1684	10	676	1.000		RF-CF Carton-Green
		24476	70	580	1.000		Sear Pin
		113529	210	585	1.000		Stock Assy
		114220	505	606	2.000		TEST ROUND - X300WSM 180gr.WIN. POWER PT
		114220	270	606	3.500		TARGET ROUND - X300WSM 180gr.WIN. POWER PT
		97490	120	580	1.000		Trigger Assy
		97867	160	585	1.000		Trigger Guard Assy
27251							300 SS L/A SPS - 25-06 REM
		301049	502	676	1.000		Cable Lock
		249230	17	400	1.000		BARREL ASSEMBLY
		105440	27	400	1.000		BOLT ASSEMBLY
		97444	100	580	1.000		Bolt Stop
		24475	60	580	1.000		Bolt Stop Pin
		15224	30	580	1.000		Bolt Stop Spring
		993002	240	676	1.000		Box & Envelope Label
		3509	20	676	1.000		Instruction Book
		17017	400	440	1.000		Ejector
		94555	410	440	1.000		Ejector Pin
		17019	420	440	1.000		Ejector Spring
		93712	430	435	1.000		Extractor
		305639	190	580	1.000		Firing Pin Assy
		105401	180	585	1.000		Front Guard Screw
		97824	130	580	1.000		Magazine
		92492	80	585	1.000		Magazine Follower
		15677	40	585	1.000		Magazine Spring
		21714	250	600	1.100		PROOF ROUND
		106292	170	585	1.000		Rear Guard Screw
		17034	90	580	4.000		Receiver Plug Screw
		1684	10	676	1.000		RF-CF Carton-Green
		24476	70	580	1.000		Sear Pin
		113528	210	585	1.000		Stock Assy
		21515	505	606	2.000		TEST ROUND 25-06 REM 120 gr.PSPCL
		21515	270	606	3.500		TARGET ROUND 25-06 REM 120 gr.PSPCL
		97490	120	580	1.000		Trigger Assy
		97866	160	585	1.000		Trigger Guard Assy

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Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
27267							700 SS L/A SPS - 270 WIN
		301049	502	676	1.000		Cable Lock
		249222	17	400	1.000		BARREL ASSEMBLY
		105440	27	400	1.000		BOLT ASSEMBLY
		97444	100	580	1.000		Bolt Stop
		24475	60	580	1.000		Bolt Stop Pin
		15224	30	580	1.000		Bolt Stop Spring
		993002	240	676	1.000		Box & Envelope Label
		3509	20	676	1.000		Instruction Book
		17017	400	440	1.000		Ejector
		94555	410	440	1.000		Ejector Pin
		17019	420	440	1.000		Ejector Spring
		93712	430	435	1.000		Extractor
		305639	190	580	1.000		Firing Pin Assy
		105401	180	585	1.000		Front Guard Screw
		97824	130	580	1.000		Magazine
		92492	80	585	1.000		Magazine Follower
		15677	40	585	1.000		Magazine Spring
		21709	250	600	1.000		PROOF ROUND
		106292	170	585	1.000		Rear Guard Screw
		17034	90	580	4.000		Receiver Plug Screw
		1684	10	676	1.000		RF-CP Carton-Green
		24476	70	580	1.000		Rear Pin
		113528	210	585	1.000		Stock Assy
		27810	505	606	2.000		TEST ROUND 270 WIN 150 gr.SPCL
		27810	270	606	3.500		TARGET ROUND 270 WIN 150 gr.SPCL
		97490	120	580	1.000		Trigger Assy
		97866	160	585	1.000		Trigger Guard Assy
27137							700 SS L/A SPS - 270 WIN W/SCOPE
		301049	502	676	1.000		Cable Lock
		249222	17	400	1.000		BARREL ASSEMBLY
		105440	27	400	1.000		BOLT ASSEMBLY
		97444	100	580	1.000		Bolt Stop
		24475	60	580	1.000		Bolt Stop Pin
		15224	30	580	1.000		Bolt Stop Spring
		993002	240	676	1.000		Box & Envelope Label
		3509	20	676	1.000		Instruction Book
		17017	400	440	1.000		Ejector
		94555	410	440	1.000		Ejector Pin
		17019	420	440	1.000		Ejector Spring
		93712	430	435	1.000		Extractor
		305639	190	580	1.000		Firing Pin Assy
		105401	180	585	1.000		Front Guard Screw
		97824	130	580	1.000		Magazine

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Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
		92492	80	585	1.000		Magazine Follower
		15677	40	585	1.000		Magazine Spring
		21709	250	600	1.100		PROOF ROUND
		106292	170	585	1.000		Rear Guard Screw
		1668	10	676	1.000		HARD CASE SHIPPER OVERPACK
		120149	15	676	1.000		HARD CASE (GREEN FLAMBEAU W/GOLD REMINGTON)
		202613	510	680	1.000		LEUPOLD VX-1 3-9-40 MATTE SCOPE (#56600)
		202422	520	680	1.000		LEUPOLD MATTE SCOPE MOUNTS (#55890)
		202665	530	680	1.000		LEUPOLD MATTE VERTICAL SPLIT RINGS (#55860)
		24476	70	580	1.000		Sear Pin
		113528	210	585	1.000		Stock Assy
		27810	505	606	2.000		TEST ROUND 270 WIN 150 gr.SPCL
		27810	270	606	3.500		TARGET ROUND 270 WIN 150 gr.SPCL
		97490	120	580	1.000		Trigger Assy
		97866	160	585	1.000		Trigger Guard Assy
27269							700 SS LVA SPS - 30-06 SPRG
		301049	502	676	1.000		Cable Lock
		249223	17	400	1.000		BARREL ASSEMBLY
		105440	27	400	1.000		BOLT ASSEMBLY
		97444	100	580	1.000		Bolt Stop
		24475	60	580	1.000		Bolt Stop Pin
		15224	30	580	1.000		Bolt Stop Spring
		993002	230	676	1.000		Box & Envelope Label
		3509	20	676	1.000		Instruction Book
		17017	400	440	1.000		Ejector
		94555	410	440	1.000		Ejector Pin
		17019	420	440	1.000		Ejector Spring
		93712	430	435	1.000		Extractor
		305639	190	580	1.000		Firing Pin Assy
		105401	180	585	1.000		Front Guard Screw
		97824	130	580	1.000		Magazine
		92492	80	585	1.000		Magazine Follower
		15677	40	585	1.000		Magazine Spring
		21717	250	600	1.100		PROOF ROUND
		106292	170	585	1.000		Rear Guard Screw
		17034	90	580	4.000		Receiver Plug Screw
		1684	10	676	1.000		RF-CF Carton-Green
		24476	70	580	1.000		Sear Pin
		113528	210	585	1.000		Stock Assy
		27826	505	606	2.000		TEST ROUND 30-06 SPRG 150 gr.PSPCL
		27826	270	606	3.500		TARGET ROUND 30-06 SPRG 180 gr.SPCL
		97490	120	580	1.000		Trigger Assy
		97866	160	585	1.000		Trigger Guard Assy

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Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
27139							700 SS L/A SPS - 30-06 SPRG W/SCOPE
		301049	502	676	1.000		Cable Lock
		249223	17	400	1.000		BARREL ASSEMBLY
		105440	27	400	1.000		BOLT ASSEMBLY
		97444	100	580	1.000		Bolt Stop
		24475	60	580	1.000		Bolt Stop Pin
		15224	30	580	1.000		Bolt Stop Spring
		993002	240	676	1.000		Box & Envelope Label
		3509	20	676	1.000		Instruction Book
		17017	400	440	1.000		Ejector
		94555	410	440	1.000		Ejector Pin
		17019	420	440	1.000		Ejector Spring
		93712	430	435	1.000		Extractor
		305639	190	580	1.000		Firing Pin Assy
		105401	180	585	1.000		Front Guard Screw
		97824	130	580	1.000		Magazine
		92492	80	585	1.000		Magazine Follower
		15677	40	585	1.000		Magazine Spring
		21717	250	600	1.000		PROOF ROUND
		106292	170	585	1.000		Rear Guard Screw
		1668	10	676	1.000		HARD CASE SHIPPER OVERPACK
		120149	15	676	1.000		HARD CASE (GREEN FLAMBEAU W/GOLD REMINGTON)
		202613	510	680	1.000		LEUPOLD VX-1 3-9x40 MATTE SCOPE (#56600)
		202422	520	680	1.000		LEUPOLD MATTE SCOPE MOUNTS (#55890)
		202665	530	680	1.000		LEUPOLD MATTE VERTICAL SPLIT RINGS (#55860)
		24476	70	580	1.000		Sear Pin
		113528	210	585	1.000		Stock Assy
		27826	505	606	2.000		TEST ROUND 30-06 SPRG 150 gr.PSPCL
		21407	270	606	3.500		TARGET ROUND 30-06 SPRG 180 gr.SPCL
		97490	120	580	1.000		Trigger Assy
		97866	160	585	1.000		Trigger Guard Assy
27271							700 SS L/A SPS - 7MM REM MAG
		301049	502	676	1.000		Cable Lock
		249224	17	400	1.000		BARREL ASSEMBLY
		105441	27	400	1.000		BOLT ASSEMBLY
		97444	100	580	1.000		Bolt Stop
		24475	60	580	1.000		Bolt Stop Pin
		15224	30	580	1.000		Bolt Stop Spring
		993002	240	676	1.000		Box & Envelope Label
		3509	20	676	1.000		Instruction Book
		17017	400	440	1.000		Ejector
		94555	410	440	1.000		Ejector Pin
		17019	420	440	1.000		Ejector Spring
		97322	430	432	1.000		Extractor

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Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
		27341	440	432	1.000		Extractor Rivet
		305639	190	580	1.000		Firing Pin Assy
		105401	180	585	1.000		Front Guard Screw
		97824	130	580	1.000		Magazine
		92492	80	585	1.000		Magazine Follower
		15677	40	585	1.000		Magazine Spring
		21736	250	600	1.150		PROOF ROUND
		106292	170	585	1.000		Rear Guard Screw
		17034	90	580	4.000		Receiver Plug Screw
		1687	10	676	1.000		RF-CF Carton-Green
		24476	70	580	1.000		Sear Pin
		113530	210	585	1.000		Stock Assy
		94996	110	593	2.000		Swivel Screw
		27814	505	606	2.000		TEST ROUND 7MM REM MAG 175 gr.PSPCL
		27814	270	606	3.500		TARGET ROUND 7MM REM MAG 175 gr.PSPCL
		97490	120	580	1.000		Trigger Assy
		97866	160	585	1.000		Trigger Guard Assy
27273							700 SS L/A SPS - 300 WIN MAG
		301049	502	676	1.000		Cable Lock
		249225	17	400	1.000		BARREL ASSEMBLY
		105441	27	400	1.000		BOLT ASSEMBLY
		97444	100	580	1.000		Bolt Stop
		24475	60	580	1.000		Bolt Stop Pin
		15224	30	580	1.000		Bolt Stop Spring
		993002	240	676	1.000		Box & Envelope Label
		3509	20	676	1.000		Instruction Book
		17017	400	440	1.000		Ejector
		94555	410	440	1.000		Ejector Pin
		17019	420	440	1.000		Ejector Spring
		97322	430	432	1.000		Extractor
		27341	440	432	1.000		Extractor Rivet
		305639	190	580	1.000		Firing Pin Assy
		105401	180	585	1.000		Front Guard Screw
		97824	130	580	1.000		Magazine
		92492	80	585	1.000		Magazine Follower
		15677	40	585	1.000		Magazine Spring
		21846	250	600	1.150		PROOF ROUND
		106292	170	585	1.000		Rear Guard Screw
		17034	90	580	4.000		Receiver Plug Screw
		1687	10	676	1.000		RF-CF Carton-Green
		24476	70	580	1.000		Sear Pin
		113530	210	585	1.000		Stock Assy
		94996	110	593	2.000		Swivel Screw
		29497	505	606	2.000		TEST ROUND 300 WIN MAG 180 gr.PSPCL

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Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
		29497	270	606	3.500		TARGET ROUND 300 WIN MAG 180 gr.PSPCL
		97490	120	580	1.000		Trigger Assy
		97866	160	585	1.000		Trigger Guard Assy
27141							700 SS L/A SPS - 300 WIN MAG W/SCOPE
		301049	502	676	1.000		Cable Lock
		249225	17	400	1.000		BARREL ASSEMBLY
		105441	27	400	1.000		BOLT ASSEMBLY
		97444	100	580	1.000		Bolt Stop
		24475	60	580	1.000		Bolt Stop Pin
		15224	30	580	1.000		Bolt Stop Spring
		993002	240	676	1.000		Box & Envelope Label
		3509	20	676	1.000		Instruction Book
		17017	400	440	1.000		Ejector
		94555	410	440	1.000		Ejector Pin
		17019	420	440	1.000		Ejector Spring
		97322	430	432	1.000		Extractor
		27341	440	432	1.000		Extractor Rivet
		305639	190	580	1.000		Firing Pin Assy
		105401	180	585	1.000		Front Guard Screw
		97824	130	580	1.000		Magazine
		92492	80	585	1.000		Magazine Follower
		15677	40	585	1.000		Magazine Spring
		21846	250	600	1.100		PROOF ROUND
		106292	170	585	1.000		Rear Guard Screw
		1668	10	676	1.000		HARD CASE SHIPPER OVERPACK
		120149	15	676	1.000		HARD CASE (GREEN FLAMBEAU W/GOLD REMINGTON)
		202613	510	680	1.000		LEUPOLD VX-1 3-9x40 MATTE SCOPE (#56600)
		202422	520	680	1.000		LEUPOLD MATTE SCOPE MOUNTS (#55890)
		202665	530	680	1.000		LEUPOLD MATTE VERTICAL SPLIT RINGS (#55860)
		24476	70	580	1.000		Sear Pin
		113530	210	585	1.000		Stock Assy
		29497	50	606	2.000		TEST ROUND 300 WIN MAG 180 gr.PSPCL
		29497	270	606	3.500		TARGET ROUND 300 WIN MAG 180 gr.PSPCL
		97490	120	580	1.000		Trigger Assy
		97866	160	585	1.000		Trigger Guard Assy
26407							700 SS ADL SYN CAMO - (NO SIGHTS)
							REALTREE HARDWOODS GRAY HD - 270 WIN
		249222	77	395	1.000		Barrel Assembly (24")
		105440	47	395	1.000		Bolt Assembly
		97444	80	580	1.000		Bolt Stop
		24475	120	550	1.000		Bolt Stop Pin
		15224	30	550	1.000		Bolt Stop Spring
		993002	310	670	1.000		Box & Envelope Label

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Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
		105405	270	585	1.000		Center Guard Screw
		3509	20	670	1.000		Instruction Book
		17017	400	440	1.000		Ejector
		94555	410	440	1.000		Ejector Pin
		17019	420	440	1.000		Ejector Spring
		93712	430	435	1.000		Extractor
		305639	110	550	1.000		Firing Pin Assy
		105401	250	585	1.000		Front Guard Screw
		97445	40	550	1.000		Magazine
		92492	180	585	1.000		Magazine Follower
		17028	100	585	1.000		Magazine Spring
		97438	70	585	1.000		Magazine Tab Screw
		21709	320	600	1.125		PROOF ROUND
		106292	260	585	1.000		Rear Guard Screw
		17034	90	550	4.000		Receiver Plug Screw
		1684	10	670	1.000		RE-CF Carton
		24476	130	550	1.000		Rear Pin
		114134	230	585	1.000		Stock Assy - REALTREE HARDWOODS GRAY HD
		27810	505	606	2.000		TEST ROUND 270 WIN 150 gr.SPCL
		27810	340	606	3.500		TARGET ROUND 270 WIN 150 gr.SPCL
		97490	140	550	1.000		Trigger Assy
		97499	200	585	1.000		Trigger Guard
		301049	502	670	1.000		Cable Lock
		201892	510	670	1.000		CAMO ROYALTY - REALTREE HARDWOODS GRAY HD
26409							700 SS ADL SYN CAMO - (NO SIGHTS)
							REALTREE HARDWOODS GRAY HD - 30-06 SPRG
		249223	77	395	1.000		Barrel Assembly (24")
		105440	47	395	1.000		Bolt Assembly
		97444	80	550	1.000		Bolt Stop
		24475	120	550	1.000		Bolt Stop Pin
		15224	30	550	1.000		Bolt Stop Spring
		993002	310	670	1.000		Box & Envelope Label
		105405	270	585	1.000		Center Guard Screw
		3509	20	670	1.000		Instruction Book
		17017	400	440	1.000		Ejector
		94555	410	440	1.000		Ejector Pin
		17019	420	440	1.000		Ejector Spring
		93712	430	435	1.000		Extractor
		305639	110	550	1.000		Firing Pin Assy
		105401	250	585	1.000		Front Guard Screw
		97445	40	550	1.000		Magazine
		92492	180	585	1.000		Magazine Follower
		17028	100	585	1.000		Magazine Spring
		97438	70	585	1.000		Magazine Tab Screw
		21717	320	600	1.100		PROOF ROUND

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Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
		106292	260	585	1.000		Rear Guard Screw
		17034	90	550	4.000		Receiver Plug Screw
		1684	10	670	1.000		RF-CF Carton
		24476	130	550	1.000		Sear Pin
		114134	230	585	1.000		Stock Assy - REALTREE HARDWOODS GRAY HD
		27826	505	606	2.000		TEST ROUND 30-06 SPRG 150 gr.PSPCL
		21407	340	606	3.500		TARGET ROUND 30-06 SPRG 180 gr.SPCL
		97490	140	550	1.000		Trigger Assy
		97499	200	585	1.000		Trigger Guard
		301049	502	670	1.000		Cable Lock
		201892	510	670	1.000		CAMO ROYALTY REALTREE HARDWOODS GRAY HD

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Date:	Reason for Revision:	Eng:	Log #:
17-May-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
11-Oct-01	Front Sight 110255 was 94095, 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
15-Nov-01	On LH SKUs: F.P.Assy 110452 was 109581	RLJ	305396
4-Apr-02	Trigger pull 4.5 to 6.5 was 4.5 to 5.5	RLJ	305777
20-May-02	Corrected ammo. usage for 7MM-08 cal. RAMAC 29737	RFL	305783
11-Oct-02	Changed stock assy 106170 to 111302 for SKU's 9709, 9717 and stock assy 106171 to 111303 for SKU 9692, 9694 per DCR 14864	RJL	307718
9-Nov-02	Changed Test Ammo to 100 gr from 80 gr	ERF	307625
30-Jan-03	CORRECT Rear Sight Assembly Ft#s as follows: Pt#111321 was Pt#103147 for RAMAC 29728	GLC	308543
4-Mar-03	ADD RAMAC#26420 - 700 BDL SS LIMITED - 7MM REM MAG Removed Build-To-Tag 3487 from all BOM's - expensed item	GLC	308806
28-Mar-03	Updated to current practice (details only) Updated Description in op. 440 & 585 (Routing only)	ERF	307607
16-Jun-03	ADD RAMAC#26440 - 700 SS L/A BDL - 300 WIN MAG - RMEF 2004	GLC	309733
19-Feb-04	ADD RAMAC#25863 - 700 SS S/A CLASSIC - 220 SWIFT	GLC	311262
27-Feb-04	CORRECT REAR GUARD SCREW QUANTITY - 1 WAS 4 FOR THE FOLLOWING RAMAC#s: 29713 25931 25861 29729 29735 29731 29737 29739 25863 29707 29709 29713 29692 29690 29717 29694 26440 29727 29696 29728 25929 25933 25935 25943 26293 26297 26295 26299 & 26420	GLC	311358

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Date:	Reason for Revision:	Eng:	Log #:
12-Mar-04	Stock Assy R3 - 113136 was Stock Assy - 92892 FOR: RAMAC#25933 - 700 SS L/A BDL LS - 7MM REM MAG - (BLACK LAMINATE) RAMAC#25935 - 700 SS L/A BDL LS - 300 WIN MAG - (BLACK LAMINATE)	GLC	311430
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, 635, 640. Added operation 600R for special slave bolt proof procedure.	RLJ	310367
6-Jul-04	ADD RAMAC#27263 - 700 SS S/A SPS - 243 WIN ADD RAMAC#27265 - 700 SS S/A SPS - 7MM-08 REM ADD RAMAC#27267 - 700 SS L/A SPS - 270 WIN ADD RAMAC#27269 - 700 SS L/A SPS - 30-06 SPRG ADD RAMAC#27271 - 700 SS L/A SPS - 7MM REM MAG ADD RAMAC#27273 - 700 SS L/A SPS - 300 WIN MAG	GLC	312161
9-Jul-04	Replaced ISS Firing Pin Assy with Non-ISS Fluted Firing Pin Assy. 109581, 110452 now 305639, 109582 now 305640.	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 201044, removed ISS Gunlock keys (2) 201207, removed procedure for checking gunlock function and added 35 in-lb spec for takedown screw.	RLJ	311858
7-Oct-04	On SKU 27263, 27265 Bolt Assy 107760 was 113575, F.P. Assy 305640 was 305643. On SKU 27267, 27269 Bolt Assy 105444 was 113577, F.P. Assy 305639 was 305642. On SKU 27271, 27273 Bolt Assy 107762 was 113579, F.P. Assy 305639 was 305642.	RLJ	311862
4-Nov-04	OP#400, 405, 415 & 650 - UPDATE INFO AND REESTABLISH LINKS FOR HEADING PLUGS	GLC	313049

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Date:	Reason for Revision:	Eng:	Log #:
4-Jan-05	OP 550 565 580 585 635 640 648 added pull scale verification process	DWB	313325
14-Jan-05	ADD OP#395 FOR ALL PART #'S REMOVE INSPECTION INFO FROM OP#400, 405, & 415	GLC	313607
9-Feb-05	F113575 was F107760 Bolt Assy. (RAMAC 7263, 7265) F113577 was F105444 Bolt Assy. (RAMAC 7267, 7269) F113579 was F107762 Bolt Assy. (RAMAC 7271, 7273) Box assy 1499 changed to 1687 Box assy 1444 changed to 1684	AJL	313560
17-Feb-05	Changed stock number - F113137 from F105794	ERF	311625
8-Mar-05	ADD RAMAC#27253 - 700 SS S/A MAG SPS - 270 WSM ADD RAMAC#27255 - 700 SS S/A MAG SPS - 300 WSM ADD RAMAC#27251 - 700 SS L/A SPS - 2500 REM	GLC	314050
21-Mar-05	ADD RAMAC#26309 - 700 LSS S/A MAG - 270 WSM - (BLACK LAM) ADD RAMAC#26311 - 700 LSS S/A MAG - 300 WSM - (BLACK LAM)	GLC	314168
4-Apr-05	RAMAC#27263 - Swivel Screw PT#94996 WAS 97812 RAMAC#27265 - Swivel Screw PT#94996 WAS 97812 RAMAC#27267 - Swivel Screw PT#94996 WAS 97812 RAMAC#27269 - Swivel Screw PT#94996 WAS 97812 RAMAC#27271 - Swivel Screw PT#94996 WAS 97812 RAMAC#27273 - Swivel Screw PT#94996 WAS 97812 RAMAC#29706 - ADD Swivel Screw Spacer PT#94241 QTY OF 2 RAMAC#29708 - ADD Swivel Screw Spacer PT#94241 QTY OF 2 RAMAC#29711 - ADD Swivel Screw Spacer PT#94241 QTY OF 2 RAMAC#29712 - ADD Swivel Screw Spacer PT#94241 QTY OF 2 RAMAC#29707 - ADD Swivel Screw Spacer PT#94241 QTY OF 2 Stock Assy PT#111302 WAS 106170 RAMAC#29709 - ADD Swivel Screw Spacer PT#94241 QTY OF 2 Stock Assy PT#106170 WAS 111302 RAMAC#29713 - ADD Swivel Screw Spacer PT#94241 QTY OF 2 RAMAC#29717 - ADD Swivel Screw Spacer PT#94241 QTY OF 2 RAMAC#29715 - ADD Swivel Screw Spacer PT#94241 QTY OF 2 RAMAC#29692 - ADD Swivel Screw Spacer PT#94241 QTY OF 2 RAMAC#29690 - ADD Swivel Screw Spacer PT#94241 QTY OF 2 RAMAC#29694 - ADD Swivel Screw Spacer PT#94241 QTY OF 2 RAMAC#29727 - ADD Swivel Screw Spacer PT#94241 QTY OF 2 RAMAC#29696 - ADD Swivel Screw Spacer PT#94241 QTY OF 2 RAMAC#29728 - ADD Swivel Screw Spacer PT#94241 QTY OF 2 RAMAC#29729 - ADD Swivel Screw Spacer PT#94241 QTY OF 2	GLC	314293

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Date:	Reason for Revision:	Eng:	Log #:
	RAMAC#29735 - ADD Swivel Screw Spacer PT#94241 QTY OF 2		
	RAMAC#29731 - ADD Swivel Screw Spacer PT#94241 QTY OF 2		
	RAMAC#29737 - ADD Swivel Screw Spacer PT#94241 QTY OF 2		
	RAMAC#29739 - ADD Swivel Screw Spacer PT#94241 QTY OF 2		
18-Apr-05	Removed Swivel (94996) Op 593 and Op. 665 from Ramac 27251, 27267, 27269, 27253, 27255	ERF	311642
22-Apr-05	ADD RAMAC#27137 - 700 SS L/A SPS - 270 WIN W/SCOPE	GLC	314457
	ADD RAMAC#27139 - 700 SS L/A SPS - 30-06 SPRG W/SCOPE		
	ADD RAMAC#27141 - 700 SS L/A SPS - 300 WIN MAG W/SCOPE		
25-Apr-05	OP#593 & 665 - REMOVE RAMAC#27141	GLC	314459
	RAMAC#27137 27139 27141 - REMOVE RECEIVER PLUG SCREWS		
	PT#17034		
27-Apr-05	RAMAC#27137, 27139, & 27141 - LEUPOLD VX-1 3-9x40 MATTE SCOPE (#56600) PT#202671 WAS 202613 - DCR#15807	GLC	314544
4-May-05	RAMAC#27255 - Magazine PT#110848 WAS 110847	GLC	314560
	RAMAC#27253 - Magazine PT#110848 WAS 110845		
27-Apr-05	RAMAC#27137, 27139, & 27141 - LEUPOLD VX-1 3-9x40 MATTE SCOPE (#56600) PT#202613 WAS 202671 - DCR#15842	GLC	314648
25-Jun-05	Follower Change - Ramac 27141 27273 27271 MAG. Pt.#F92492 Was F90952 - Ramac 27263 27265 S/A Pt.# F92455 Was F90982 - Ramac 27267 27269 27251 27137 27139 Pt.# F92492 Was F92218 L/A		
26-May-05	RAMAC#27253 & 26303 - PROOF ROUND PT#202720 WAS PROOF ROUND - PRF270WSM 150GR SP CORELOKT PT#21816	GLC	314789
1-Jun-05	ADD RAMAC#26335 - 700 LSS S/A BDL - 243WIN (BLACK LAMINATE)	GLC	314897
	RAMAC#25929 & 25931 - Stock Assy PT#202708 WAS 98891		
	DCR#15825 - NPP-2005-74		
13-Jun-05	ADD RAMAC#26407 - 700 SS ADL SYN CAMO - (NO SIGHTS)	GLC	315025
	RT HARDWOODS GRAY HD - 270 WIN		
	ADD RAMAC#26409 - 700 SS ADL SYN CAMO - (NO SIGHTS)		
	RT HARDWOODS GRAY HD - 30-06 SPRG		
	DCR#15885 NPP-2005-79 BOS#224		
15-Jun-05	RAMAC#29706, 29708, 29711, & 29712 - ADD TO OP#606 & 648 - MISSING	GLC	315029

Printed on:
~AUTODATE

Date:	Reason for Revision:	Eng:	Log #:
	OP#665 - REMOVE RAMAC #26407 & 26409 - SWIVELS ALREADY IN PLACE		
11-Jul-05	For SKU#'s 27137,27139,27251,27267,27269 - bolt assembly 105440 was 113577. For SKU#'s 27271,27273,27141 - bolt assembly 105441 was 113579. For SKU#'s 27261,27265, bolt assembly 105442 was 113575. For SKU#'s 27252,27255 - bolt assembly 98478 was 113581. Changed to a jeweled bolt assembly to improve final product quality.	RJO	314934
16-Jul-05	RAMAC#25883 - Stock Assy PT#93475L WAS 34590	GLC	315281
28-Sep-05	ADD RAMAC#26425 - 700 SS L/A CBL EL LTD ED - 30-06 SPRG	GLC	315678
11-Oct-05	Stk Assy 202346L was 113136	DLE	315380

Dept		Num		Procedure by Steps		Safety Key Points	
U	1	01	01	U	1	01	01
U	1	01	02	U	1	02	02
U	1	01	03	U	1	03	03
U	1	01	04	U	1	04	04
U	1	01	05	U	1	05	05
U	1	01	06	U	1	06	06
U	1	01	07	U	1	07	07
U	1	01	08	U	1	08	08
U	1	01	09	U	1	09	09
U	1	01	10	U	1	10	10
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U	1	01	12	U	1	12	12
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U	1	01	14	U	1	14	14
U	1	01	15	U	1	15	15
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U	1	01	100	U	1	100	100

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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