

Remington Arms Company, Inc.
Manufacturing Process Document

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

Effective Date: 7-Jun-05
Origination Date: 17-May-94

General Instructions:

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

Process Routing Table:

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

INSPECT COMPONENTS BEFORE HEADING
(SHOULDER SINGLE PASS)
(SHOULDER SINGLE PASS: Smaller than .25
Make Chamber Cast (Not Done on 100% of Product)
Ream Ejector Hole
Assemble Rivetless Extractor to Bolt
Assemble to Bolt with Ejector Cross Pin
Strip Defective Barrel Assembly Complete
Strip Defective Bolt
Assemble Action
to Trigger Guard
Spacer to Stock
Proof Test
Proof Test with slave bolt
Proof Stamp, Prick Punch and Obstruction In
Part and Target
Test and Target 100%
Inspect For Live Ammunition
Final Inspection
not done on 100% of the product
Inspect Heading and Sear Lift
Number Using Dot Peen Marking Machine
To Warehouse

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

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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: 7-Jun-05			Processed by:		
Part No:	Part Name: Fin Assy 700 VLS		Centerfire Rifle			Date: 5/14/2006		
Operation No: 395	Operation: INSPECT COMPONENTS BEFORE HEADING					Work Center:		
Prod. Qty:	Prod. Order #:	Operator			Setup inspected by & Date:			
Gage Description and Characteristic	Gage Number	Gage Frequency	1st Shift	2nd Shift	3rd Shift	Remarks, Causes, Action Taken, Etc.		
VISUAL	VISUAL	100%	INSPECT					
			REJECT					
			INSPECT					
			REJECT					
Pieces Run:					Remington Arms Company, Inc. -- Ilion, New York			

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

Operation Step Detail Operation: 400

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

Step Operation / Step Description

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

Fit bolt assembly to barrel assembly.

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

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

Operation Tool Detail

Operation: 400

Tool Number	Tooling Description
F-76039	Machine

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D-46967	Fixture
STD	182006 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 - 35 REM
D-49577-U	REAMER (replaces B-86645)
A-41139	COLLAR

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B-90098-Q	SHANK
STD	Caliber - 35 WHELEN
D-49577-V	REAMER (replaces B-47587)
A-41281	COLLAR
B-90098-Q	SHANK
STD	Caliber - 257 ROBERTS
D-49577-N	REAMER (replaces B-46079)
A-41281	COLLAR
B-90098-U	SHANK
STD	Caliber - 7MM MAUSER
D-49577-D	REAMER (replaces B-44998)
A-41281	COLLAR
B-90098-V	SHANK
STD	Caliber - 25-06 REM
D-49577-M	REAMER (replaces B-37794)
A-41281	COLLAR
B-90098-U	SHANK
STD	Caliber - 7MM-08 REM
D-49577-E	REAMER (replaces B-45106)
A-41281	COLLAR
B-90098-V	SHANK
STD	Caliber - 6.5x55 SWEDISH
D-49577-A	REAMER (replaces C-49577-A)

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A-41281
B-90098-R

COLLAR
SHANK

STD

Caliber - 7.62x BRENNEKE

D-49577-C

REAMER (replaces C-48878)

A-41281

COLLAR

B-90098-V

SHANK

C-41556-A

260 REM MIN Heading Plug

C-41556-B

260 REM WMAX Heading Plug

C-41556-A

308 WIN MIN Heading Plug

C-41556-B

308 WIN 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				Revision Date:		Processed by:	
THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES				7-Jun-05			
Part No:	Part Name: Fin Assy 700 VLS		Centerfire Rifle		Date:	8/14/2008	
Operation No: 400	Operation: Fit and Head Bolt Assembly to Barrel Assembly (SHOULDER SINGLE PASS)					Work Center:	
Prod. Qty:	Prod. Order #:	Operator			Setup inspected by & Date:		
Gage Description and Characteristic	Gage Number	Gage Frequency	1st Shift	2nd Shift	3rd Shift	Remarks, Causes, Action Taken, Etc.	
			INSPECT				
VISUAL	VISUAL	100%	REJECT INSPECT				
260 REM MIN Heading Plug	C-41556-A	100%	REJECT INSPECT				
260 REM WMAX Heading Plug	C-41556-B	100%	REJECT				

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

Operation Step Detail Operation: 405

NOTE: The operator shall continuously monitor the condition of the cutter that is being used by visual inspection. Visual inspection using magnification is to be done as felt appropriate by the operator or by special request of supervi. 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
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FIT & HEAD BOLT ASSY TO BEE ASSY, CHAMBER TO LENGTH
NON-MAGNUMS; SMALLER THAN .25 CALIBER

Fit bolt assembly to barrel assembly.

- a. Remove bolt assembly from barrel assembly.
- b. Clamp barrel assembly in fixture.
- c. Inspect reamer condition, no chipped cutting surfaces, no metal chips packed in flutes. Make sure reamer is correct for caliber being manufactured. Check spacer collars for size and tightness.
- d. Dip reamer into LE2000 Accu-Lube (note: thick blue liquid).
- e. Insert reamer shank through barrel so pilot is inside barrel bore. Move barrel and reamer together and engage reamer shank into quick release chuck. Make sure barrel chamber is positioned such that it is not being cut by reamer yet.
- 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

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mixture. (note: mixture should have a milky consistency. If mixture looks too thin, add STEELGARD 1301-NL.) All metal chips must be rinsed from reamer. Inspect reamer condition.

- i. Unclamp barrel assembly and rinse in tank with water and STEELGARD 1301-NL mixture to remove any metal chips and to protect newly exposed metal surfaces. Inspect barrel chamber condition.
- j. Replace bolt assembly in barrel assembly and insert appropriate minimum shoulder plug. Bolt should close smoothly. Open bolt and remove minimum shoulder plug.
- k. Insert appropriate maximum shoulder plug. Bolt should not close with maximum shoulder plug in chamber. Open bolt and remove maximum shoulder plug.
- l. If all tests are acceptable close bolt and place barrel assembly on truck

Operation Tool Detail

Operation: 405

Tool Number	Tooling Description
F-76039	Machine
D-46967	Fixture
STD	ACCU-LUBE 2000
STD	STEELGARD 1301-NL
STD	Caliber - 17 REM
D-49577-F	REAMER (replaces B-38161)
A-41139	COLLAR
B-90098-P	SHANK
STD	Caliber - 22 REM
D-49577-B	REAMER (replaces B-54694)
A-41281	COLLAR
B-90098-R	SHANK
STD	Caliber - 22-250
D-49577-C	REAMER (replaces B-87513)
A-41281	COLLAR
B-90098-S	SHANK

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STD Caliber - 220 SWIFT

D-49577-H REAMER (replaces B-49136)
A-41139 COLLAR
B-90098-S SHANK

STD Caliber - 222 REM

D-49577-J REAMER (replaces B-54136)
A-41139 COLLAR
B-90098-S SHANK

STD Caliber - 223 REM

D-49577-K REAMER (replaces B-54136-S)
A-41139 COLLAR
B-90098-S SHANK

STD Caliber - 243 WIN

D-49577-L REAMER (replaces B-83504)
A-41281 COLLAR
B-90098-R SHANK

STD Caliber - 264 RUGER

D-49577-NN REAMER STORE # 710740
A-41281 COLLAR
B-90098-P SHANK

C-41195-A 6MM REM MIN Heading Plug
C-41195-B 6MM REM WMAX Heading Plug
C-41521-A 22-250 MIN Heading Plug
C-41521-B 22-250 WMAX Heading Plug
C-41154-A 222 REM MIN Heading Plug
C-41154-B 222 REM WMAX Heading Plug
C-41155-A 223 REM MIN Heading Plug
C-41155-B 223 REM WMAX Heading Plug
C-41556-A 243 WIN MIN Heading Plug
C-41556-B 243 WIN WMAX Heading Plug
C-5322-A 264 RUGER MIN Heading Plug
C-5322-B 264 RUGER MAX Heading Plug

PROCESS CONTROL INSPECTION RECORD THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES		Revision Date: 7-Jun-05
Part No:	Part Name: Fin Assy 700 VLS	Centerfire Rifle

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Operation No: 405		Operation: Fit and Head Bolt Assembly to Barrel Assembly (SHOULDER SINGLE PASS: Smaller than .25 calib						
Prod. Qty:		Prod. Order #:		Operator			Setup inspected by & Date:	
Gage Description and Characteristic		Gage Number	Gage Frequency	1st Shift	2nd Shift	3rd Shift	Remarks, t	
				INSPECT				
VISUAL	VISUAL	100%		REJECT INSPECT				
6MM REM MIN Heading Plug	C-41195-A	100%		REJECT INSPECT				
6MM REM WMAX Heading Plug	C-41195-B	100%		REJECT INSPECT				
6MM REM MIN Heading Plug	C-41195-A	100%		REJECT INSPECT				
6MM REM WMAX Heading Plug	C-41195-B	100%		REJECT INSPECT				
22-250 MIN Heading Plug	C-41521-A	100%		REJECT INSPECT				
22-250 WMAX Heading Plug	C-41521-B	100%		REJECT INSPECT				
22-250 MIN Heading Plug	C-41521-A	100%		REJECT INSPECT				
22-250 WMAX Heading Plug	C-41521-B	100%		REJECT INSPECT				
22-250 MIN Heading Plug	C-41521-A	100%		REJECT INSPECT				
22-250 WMAX Heading Plug	C-41521-B	100%		REJECT INSPECT				
222 REM MIN Heading Plug	C-41154-A	100%		REJECT INSPECT				
222 REM WMAX Heading Plug	C-41154-B	100%		REJECT INSPECT				
223 REM MIN Heading Plug	C-41155-A	100%		REJECT INSPECT				
223 REM WMAX Heading Plug	C-41155-B	100%		REJECT				

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

Operation Step Detail Operation: 425

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

Step Operation / Step Description

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

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

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430 Ream Ejector Hole

Operation Step Detail Operation: 430

Step Operation / Step Description

Ream Ejector Hole

Remove Burr thrown into Ejector Hole by Flat Scrape

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

Operation Tool Detail Operation: 430

Tool Number Tooling Description

STD #28 DRILL

PROCESS CONTROL INSPECTION RECORD		Revision Date:		7-Jun-05		Processed by:	
THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES							
Part No:	Part Name: Fin Assy 700 VLS	Centerfire Rifle		Date:		8/14/2006	
Operation No: 430	Operation: Ream Ejector Hole			Work Center:			
Prod. Qty:	Prod. Order #:	Operator		Setup inspected by & Date:			

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

Operation Tool Detail Operation: 435

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

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

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PROCESS CONTROL INSPECTION RECORD THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES				Revision Date: 7-Jun-05		Processed by:
Part No:	Part Name:	Pin Assy 700 VLS		Centerfire Rifle		Date: 8/14/2006
Operation No: 435	Operation: Assemble Rivetless Extractor to Bolt					Work Center:
Prod. Qty:	Prod. Order #	Operator			Setup Inspected by & Date:	
Gage Description and Characteristic	Gage Number	Gage Frequency	1st Shift	2nd Shift	3rd Shift	Remarks, Causes, Action Taken, Etc.
VISUAL	VISUAL	100%	INSPECT			
Min Tension Plug - .445	B-87034-C	100%	REJECT INSPECT			
Max Tension Plug	B-84831-B	100%	REJECT INSPECT			
EXTRACTOR TENSION PLUG GAGE - 6.5X55	B-87034-E	100%	REJECT INSPECT			
			REJECT INSPECT			
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440 Assemble Ejector to Ejector Spring and then
Assemble to Bolt with Ejector Cross Pin.

Operation Step Detail

Operation: 440

Step

Operation / Step Description

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

PROCEDURE:

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

Operation Tool Detail

Operation: 440

Tool Number

Tooling Description

C-51730	Fixture
C-40296	Fixture (L.H.)
A-48261	Pin Punch

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B-54504
C-53663

Drive Punch (Drive Out Tight Ejector Pin)
Fixture

PROCESS CONTROL INSPECTION RECORD THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES				Revision Date: 7-Jun-05		Processed by:
Part No:	Part Name:	Fin Assy 100-VLB		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 Strip Defective Barrel Assembly Complete

Operation Step Detail Operation: 460R

Step Operation / Step Description

Strip Defective Barrel Assembly Complete

PROCESS CONTROL INSPECTION RECORD THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES			Revision Date: 7-Jun-05			Processed by:	
Part No:	Part Name: Fin Assy 700 VLS		Centerfire Rifle			Date: 8/14/2005	
Operation No: 460R	Operation: Strip Defective Barrel Assembly Complete					Work Center:	
Prod. Qty:	Prod. Order #:	Operator			Setup Inspected by & Date:		
Gage Description and Characteristic	Gage Number	Gage Frequency	1st Shift	2nd Shift	3rd Shift	Remarks, Causes, Action Taken, Etc.	
VISUAL	VISUAL	100%	INSPECT	/	/		
			REJECT				
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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				7-Jun-05			
Part No:	Part Name: Fin Assy 700 VLS		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				
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			INSPECT				
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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. Marks
 - c. Uniform Color
 - d. 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 "ON" 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:
- a. Place Safety in "S" or "ON" Position

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

Perform Checks a. thru c. (3) Times

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

Try (3) Times

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

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

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

- 22 Close the Action and Lock Bolt Down

Operation Tool Detail

Operation: 580

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Tool Number	Tooling Description
A-88003	Taper Reamer for Braze in Firing Pin Hole
7233T1	Tube 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:		Processed by:	
THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES				7-Jun-05			
Part No:	Part Name: Fin Assy 700 VLS		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.	
			INSPECT				
VISUAL	VISUAL	100%	REJECT INSPECT				
Pin Tight Tester - Sear Retracts Without Hesitation	B-80652	100%	REJECT				

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

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
 - Inspect for:
 - a. Color
 - b. No Rust
 - c. Breaks
 - d. Deformities
3. Assemble Magazine to Receiver
4. Position Stock on Action
5. Select Trigger Guard Assy and Place in Stock
 - 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
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*LBS - per torque spec. Next torque rear take down screw to 35 IN*LBS then(ADL'S) the center take down screw SNUG ONLY
 - a. Check Margin at Ejection Port and at Receiver Tang per Sample
 - Opening Between Stock and Receiver Uniform

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- No Bad Chipping
- Barrel Must Seat within 1.5" of Front of Stock
- Vertical Squeeze Produces No Movement
- Guard Screws Tight
- .020 Max. Opening Under Trigger Plate Except at Corners
- .025 Max. Opening Under Trigger Plate at Corners
- .025 Max. Opening with Stock
- See Sample for Max Opening Between Stock & Floor Plate
 - a. Reasonable Gap Between Floor Plate and Stock is Acceptable
 - If Uniform
 - Reject if Edge is Jagged
 - b. Gas Hole in Receiver 50% Visible Above Stock
 - c. Check for Trigger Clearance In Guard
 - Must Not Bind
 - Trigger Must Not Be Exposed Outside of Guard
 - A (.030) Shim Must Fit Between End of Trigger and Inside of Guard Bow While Trigger is in both the Full Rearward Position and the Relaxed Position
 - 1. IF IT FAILS the SHIM
 - SEE PROCEDURE BELOW for Shim PLACEMENT UNDER THE TRIGGER GUARD

Shim Placement Procedure if Required;

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

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

- 8 Assemble Magazine Spring to Magazine Follower and Assemble to Magazine
 - a. Install in Floor Plate W/ Floor Plate Insert (17,204,221,222,223 Cal.Only)
 - b. Adjust Floor Plate to Latch Properly - (See Sample)
- 9 Turn Rifle Over in 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.

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- 13 Single Load and Full Magazine Dummy Cartridges to Check:
- Feeding
 - Extraction
 - Ejection
 - 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

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 THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES			Revision Date: 7-Jun-05		Processed by:
Part No:	Part Name: Fin Assy 700 VLS	Centerfire Rifle		Date: 8/14/2006	
Operation No: 585	Operation: Assemble Stock to Action and Attach Build to			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

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Face of Bolt:

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

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

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

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

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

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

10. Check fired case for:

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

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

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

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

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

13. Remove gun from device and place on bench.

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

V. INTERPRETATION OF PROOF TEST

A. PASS GUN

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

B. REJECT GUN

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

VI. SAFETY AFTER PROOF TEST

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A. SAFETY

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

B. INSPECT CHAMBER AND MAGAZINE FOR LIVE AMMUNITION

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

C. VISUALLY INSPECT FOR MARRING BY DEVICE OR PORT

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

D. MOVE ENTIRE LOAD TO NEXT OPERATION

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

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600R

Proof Test with slave bolt

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

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

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

Operate bolt release and remove original bolt assembly.

Place slave bolt assembly in action.

Place original bolt assembly aside in holder.

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

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

Load proof round into chamber and close the action.

Close device doors and proof the rifle.

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

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

Open the slave bolt and remove it from the action.

Place slave tool
Operate the ori
If original
the bore.

assembly in holder.
trial bolt to engage the
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fired case for extra
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and ejection.
a rod down

PROCESS CONTROL INSPECTION RECORD				Revision Date:		3-Mar-05		Processed by	
THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL									
Part No:		Part Name: Fin Assy 700 ADL		Centerfire Rifle				Date: 5/14/2006	
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					
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PROCESS CONTROL INSPECTION RECORD				Revision Date:		Processed by:
THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES				7-Jun-05		
Part No:	Part Name:		Centerfire Rifle		Date:	8/14/2006
Operation No: 600R	Operation:		Proof Test with slave bolt		Work Center:	
Prod. Qty:	Prod. Order #:	Operator			Setup Inspected by & Date:	
Gage Description and Characteristic	Gage Number	Gage Frequency	1st Shift	2nd Shift	3rd Shift	Remarks, Causes, Action Taken, Etc.
VISUAL	VISUAL	100%	INSPECT			
			REJECT INSPECT			
			REJECT INSPECT			
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			REJECT INSPECT			

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

Operation Step Detail Operation: 605R

Step Operation / Step Description

Check previously rejected guns for proof stamp and obstruction in barrel

PROCESS CONTROL INSPECTION RECORD THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES			Revision Date: 7-Jun-05			Processed by:	
Part No:		Part Name: Fin Assy 700 VLS		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

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

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

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

I. RIFLES TESTED AND TARGETED

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

II. TEST AND TARGET OBJECTIVES

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

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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.).

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. Visual Defects - Marring of wood or metal finishes.

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

2. With safety in "F" or "OFF" position-close Bolt crisply on empty chamber. Rifle must be pointed in safe direction at all times.
 - a. Firing pin must not follow down as Bolt cams shut.
 - b. Must not fire on closings.
3. With Safety in "S" or "on" position and the action closed, raise the bolt.

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- a. Bolt must raise or open without excessive force.
4. Close Bolt with safety in "S" or "on" position - pull trigger firmly.
 - a. Rifle must not fire
5. With finger off Trigger move safety to "P" 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. 222 Rem.	50 gr. PSP	5
2. 22-250 Rem.	55 gr. HPPL	4
3. 223 Rem.	55 gr. PSP	5
4. 6mm Rem.	100 gr. PSP	4
5. 243 Wir.	100 gr. PSPCL - 80 gr. HP	4
6. 7mm-08 Rem.	140 gr. PSP	4
7. 308	168 gr. BT HP Match	4
8. 260 Rem.	140 gr. PSPCL	4
9. 204 Ruger	32 gr. ACCUTIP V	5

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

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

15. Open Bolt full stroke to rear position.

16. Close guard. (If on accuracy device)

17. Close Bolt to feed shell into chamber and lock to start test.

- a. Must feed single (1) shell with each operating stroke of Bolt.
- b. Must not double feed.
- c. Shells must not stem chamber or magazine. (Bind inside

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- 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 and 100% of Police rifles that are targeted, check each shot with spotting scope for rifle "seating in" and position of shots on paper. Use a maximum of 3 "seater" rounds per rifle.
- a. Adjust device if shots off paper or group too close to edge.
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

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catch on receiver.

- d. One fired case from each rifle must be visually inspected for firing pin indent and chamber marks reflected on case. Flight 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 a group of 5 shots, therefore, those rifles will typically require extra rounds to be loaded and shot singly. See chart below for acceptable group sizes.

23. Open guard. (If on accuracy device)

24. For the Targeted rifles (10% std. & 100% Police)

- a. Use spotting scope to check group size.
- b. Maximum spread of the two extreme holes must be within group size specifications listed below.

GROUP SIZE SPECIFICATIONS

All VARMINT, SENDERO, & POLICE:

CALIBER	AMMUNITION TYPE	MAX. GROUP CENTER TO CENTER
		5 SHOT
1. 222 Rem.	50 gr. PSP	1.5
2. 22-250 Rem.	55 gr. HPPL	1.5
3. 223 Rem.	55 gr. PSP	1.5

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4. 6mm Rem.	100 gr. PSP	1.5
5. 243 Win.	100 gr. PSPCL - 80 gr. HP	1.5
6. 7mm-08 Rem.	140 gr. PSP	1.5
7. 308 Win.	168 gr. BT HP Match	1.5
8. 260 Rem.	140 gr. PSPCL	1.5
9. 204 Ruger	32 gr. ACCUTIP V	1.5

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

26. Inspect chamber and magazine for live ammunition.

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

27. Pass all rifles that meet specifications for:

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

28. Reject all rifles that do not meet specifications:

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

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- If 30 rifles are on a truck, target 3
- If 21 rifles are on a truck, target 3
- If 20 rifles are on a truck, target 2
- b. Target Police 100%

B. Test/Target Stamping (Acceptable Product Only)

1. When all rifles have been tested/targeted, move entire load to Inspection Door.
 - a. Rejected rifles get white reject tickets.

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. (Inspection Door)

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Operation Tool Detail

Operation: 606

Tool Number

Tooling Description

Muzzle Chamber 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 EF)
B-51634-Q	Countersink Pilot - 6mm Rem / 243 Win
B-51634-P	Countersink Pilot - 7mm (all) / 280 Rem
B-51634-N	Countersink Pilot - 264 Win / 6.5mm (all)
B-51634-M	Countersink Pilot - 8mm Rem Mag
B-51634-L	Countersink Pilot - 338 (all)

Std

CALIBER

USE CLOSE HARD PLUG

7MM WBY MAG	C-48336-B
7MM REM MAG, 338 WIN MAG	C-46200-B
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

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35 WHELEN, 30-06, .270, 25-06
300 SAVAGE
257 ROBERTS
35 REM
7MM BR
3X64 BERNNEKE
220 SWIFT
6.5X55 SWEDISH
204 RUGER

C-45930 OR D-48349-J
D-48349-K
D-48349-L
D-48349-M
D-48349-N
D-48349-P
D-48349-R
D-48349-S
D-48349-CC

(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: 7-Jun-05			Processed by:
Part No:	Part Name: Fin Assy 700 VLS	Centerfire Rifle			Date: 5/14/2006	
Operation No: 606	Operation: Test and Target				Work Center:	
Prod. Qty:	Prod. Order #:	Operator			Setup inspected by & Date:	
Gage Description and Characteristic	Gage Number	Gage Frequency	1st Shift	2nd Shift	3rd Shift	Remarks, Causes, Action Taken, Etc.
VISUAL	VISUAL	100%	INSPECT			
			REJECT			
			INSPECT			
			REJECT			
			INSPECT			
			REJECT			

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610 Test and Target 100%

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

Gallery Test-Procedure and Specifications

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

I. RIFLES TESTED AND TARGETED

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

II. TEST AND TARGET OBJECTIVES

- A. Function: To check the ability of each rifle to satisfactorily

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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.).

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.

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- 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, 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

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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.

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.	222 Rem.	50 gr. PSP	5
2.	22-250 Rem.	55 gr. HPPL	4
3.	223 Rem.	55 gr. PSP	5
4.	6mm Rem.	100 gr. PSP	4
5.	243 Win.	100 gr. PSPCL - 80 gr.HP	4
6.	7mm-08 Rem.	140 gr. PSP	4

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7. 308 Win.	168 gr. BT HP Match	4
8. 240 Rem.	140 gr. PSPCL	4
9. 204 Ruger	32 gr. ACCUTIP V	5

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

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

15. Open Bolt full stroke to rear position.

16. Close guard. (If on accuracy device)

17. Close Bolt to feed shell into chamber and lock to start test.

a. Must feed single (1) shell with each operating stroke of Bolt.

b. Must not double feed.

c. Shells must not stem chamber or magazine. (Bind inside receiver or barrel.)

d. Bolt must not override shell in magazine.

e. Bolt must feed shell into chamber with normal pressure.

f. If, using normal force, the Bolt will not close over a live round in the chamber, perform the following test:

1. Insert the appropriate close hard plug into the chamber while the rifle is held in the test device. (see Tool Detail Section for list of close hard plugs)

2. Close and operate bolt:

a. If bolt closes hard over the plug, reject the rifle for Close Hard and record the malfunction in the computer and attach the slip to the rifle.

b. If bolt closes with normal pressure, do not reject the rifle. This indicates oversize ammunition.

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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 and 100% of Police rifles that are targeted, check each shot with spotting scope for rifle "seating in" and position of shots on paper. Use a maximum of 3 "seater" rounds per rifle.
 - a. Adjust device if shots off paper or group too close to edge.
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

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group sizes.

23. Open guard. (If on accuracy device)

24. For the Targeted rifles (10% std. & 100% Police)

- a. Use spotting scope to check group size.
- b. Maximum spread of the two extreme holes must be within group size specifications listed below.

GROUP SIZE SPECIFICATIONS

All VARMINT, SENDERO:

CALIBER	AMMUNITION TYPE	MAX. GROUP CENTER TO CENTER
		5 SHOT
1. 222 Rem.	50 gr. PSP	1.5
2. 22-250 Rem.	55 gr. HPPL	1.5
3. 223 Rem.	55 gr. PSP	1.5
4. 6mm Rem.	100 gr. PSP	1.5
5. 243 Win.	100 gr. PSPCL - 80 gr. HP	1.5
6. 7mm-08 Rem.	140 gr. PSP	1.5
7. 308 Win.	168 gr. BT HP Match	1.5
8. 260 Rem.	140 gr. PSPCL	1.5
9. 204 Ruger	32 gr. ACCUTIP V	1.5

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

26. Inspect chamber and magazine for live ammunition.

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

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27. Pass all rifles that meet specifications for:

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

28. Reject all rifles that do not meet specifications:

- a. Enter all malfunctions into the computer and place 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
- b. Target Police 100%

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

- 1. When all rifles have been tested/targeted, move entire load to Inspection Door.
 - a. Rejected rifles get white reject tickets.

V. SAFETY AFTER TEST

A. Open Bolt

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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. (Inspection Door)

Operation Tool Detail

Tool Number	Tooling Description
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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)

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B-51634-R Countersink Pilot - 22 caliber (all RF)
B-51634-Q Countersink Pilot - 6mm Rem / 243 Win
B-51634-P Countersink Pilot - 7mm (all) / 280 Rem
B-51634-N Countersink Pilot - 264 Win / 6.5mm (all)
B-51634-M Countersink Pilot - 8mm Rem Mag
B-51634-L Countersink Pilot - 338 (all)

Std	CALIBER	USE CLOSE HARD PLUG
	7MM WBY MAG	C-48336-B
	7MM REM MAG, 338 WIN MAG	C-48200-B
	300 WBY MAG	C-48336-A
	300 WIN MAG	C-48200-A
	.47 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-46194 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-I
	300 SAVAGE	D-48349-K
	257 ROBERTS	D-48349-L
	35 REM	D-48349-M
	7MM BR	D-48349-N
	7X64 BRENNEKE	D-48349-P
	220 SWIFT	D-48349-R
	6.5X55 SWEDISH	D-48349-S
	204 RUGER	D-48349-CC

(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: 7-Jun-05	Processed by:
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Part No:	Part Name:	Fin Assy 700 VLS	Centerfire Rifle	Date:	8/14/2006
Operation No: 610	Operation:	Test and Target 100%		Work Center:	
Prod. Qty:	Prod. Order #:	Operator		Setup Inspected by & Date:	
Gage Description and Characteristic	Gage Number	Gage Frequency	1st Shift	2nd Shift	3rd Shift
VISUAL	VISUAL	100%	INSPECT	REJECT	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: 7-Jun-05			Processed by:	
Part No:	Part Name: Fin Assy 700 VLS		Centerfire Rifle			Date: 8/14/2006	
Operation No: 620	Operation: Inspect For Live Ammunition					Work Center:	
Prod. Qty:	Prod. Order #:	Operator			Setup inspected by & Date:		
Gage Description and Characteristic	Gage Number	Gage Frequency	1st Shift	2nd Shift	3rd Shift	Remarks, Causes, Action Taken, Etc.	
VISUAL	VISUAL	100%	INSPECT				
			REJECT				
			INSPECT				
			REJECT				
			INSPECT				
			REJECT				

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640 Final Inspection

Operation Step Detail Operation: 640

Step Operation / Step Description

FINAL INSPECTION

SEQUENCE OF INSPECTION POINTS (See Following)

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

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

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

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

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

3. SPECIFICATIONS

a. Gun Matches 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 # (last four numbers)
4. Check for Marks
5. Check for Finish
6. Check for Brass in Bolt Head
7. Check for Proof Mark On Undersize of Bolt Handle
8. Check for Extractor in position
 - A. Only Extractor Claw Should Be Visible

4. GUN GRADES

- a. 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 Hang 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 DATE CODE ON BARREL AT LEFT-REAR OF BARREL, JUST AHEAD OF RECEIVER. (PASSED GUNS)

Operation Tool Detail Operation: 640

C-47444 DRAWING - LISTING DATE CODE STAMPS

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

PROCESS CONTROL INSPECTION RECORD			Revision Date:			Processed by:		
THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES			7-Jun-05					
Part No:	Part Name: Fin Assy 700 VLS		Centerfire Rifle			Date: 5/14/2005		
Operation No: 640	Operation: Final Inspection					Work Center:		
Prod. Qty:	Prod. Order #:	Operator			Setup inspected by & Date:			
Gage Description and Characteristic	Gage Number	Gage Frequency	1st Shift	2nd Shift	3rd Shift	Remarks, Causes, Action Taken, Etc.		
			INSPECT					
VISUAL	VISUAL	100%	REJECT INSPECT					
Wood Dents & Scuff Template	BTS-7300	100%	REJECT INSPECT					
Trigger clearance shim tool (.030)	A-43977	100%	REJECT INSPECT					
Dummy Cartridge Rounds of proper Caliber being built.	STD	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. Redcheck the trigger pull with the pull scale.
 - a. Hold the pullscale parallel with the action.
 - b. Adjust again if necessary.
6. Apply Duro Cement to re-seal the adjustment screw.
 - a. Avoid runs, apply only enough to make an effective seal.
 - b. Allow a few seconds for cement to "skin" over.
7. Invert the action in the vise so bottom side is up.
8. Insert Magazine Spring with follower and re-assemble the stock assembly.
 - a. Properly torque the takedown screws.
9. Return rifle to Final Inspection.

Gages:

B-70697

Trigger Pull Scales

PROCESS CONTROL INSPECTION RECORD			Revision Date: 3-Mar-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 7-Jun-05			Processed by
Part No:	Part Name:	Centerfire Rifle			Date	8/14/2008
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			

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650 Inspect Heading and Sear Lift

Operation Step Detail Operation: 650

Step Operation / Step Description

Inspect Heading and Sear Lift

Inspect Heading

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

Sear Lift Test

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

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

Operation Tool Detail

Operation: 650

Tool Number	Tooling Description
D-44581	Dial Gage
	Note: Use with 5/64 Balldriver Hex Tool Bondhus Cat. #10604, Series 106, or equivalent.

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C-47741 Attribute Gage
C-41195-A 6MM REM MIN Heading Plug
C-41195-C 6MM REM IMAX Heading Plug
C-41521-A 22-250 MIN Heading Plug
C-41521-C 22-250 IMAX Heading Plug
C-41154-A 222 REM MIN Heading Plug
C-41154-C 222 REM IMAX Heading Plug
C-41155-A 223 REM MIN Heading Plug
C-41155-C 223 REM IMAX Heading Plug
C-41556-A 243 WIN MIN Heading Plug
C-41556-C 243 WIN IMAX Heading Plug
C-41556-A 260 REM MIN Heading Plug
C-41556-C 260 REM IMAX Heading Plug
C-41556-A 308 WIN MIN Heading Plug
C-41556-C 308 WIN IMAX Heading Plug
C-41556-A 7MM-08 REM MIN Heading Plug
C-41556-C 7MM-08 REM IMAX Heading Plug
C-5322-A 204 RUGER MIN Heading Plug
C-5322-D 204 RUGER MAX Heading Plug

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

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			INSPECT			
Dial Gage	D-4455-1	100%	REJECT INSPECT			
Altitude Gage	C-4774-1	100%	REJECT INSPECT			
6MM REM MIN Heading Plug	C-41195-A	100%	REJECT INSPECT			
6MM REM IMAX Heading Plug	C-41195-C	100%	REJECT INSPECT			
6MM REM MIN Heading Plug	C-41195-A	100%	REJECT INSPECT			
6MM REM IMAX Heading Plug	C-41195-C	100%	REJECT INSPECT			
22-250 MiN Heading Plug	C-41521-A	100%	REJECT INSPECT			
22-250 IMAX Heading Plug	C-41521-C	100%	REJECT INSPECT			
22-250 MiN Heading Plug	C-41521-A	100%	REJECT INSPECT			
22-250 IMAX Heading Plug	C-41521-C	100%	REJECT INSPECT			
22-250 MiN Heading Plug	C-41521-A	100%	REJECT INSPECT			
22-250 IMAX Heading Plug	C-41521-C	100%	REJECT			

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			INSPECT			
222 REM MIN Heading Plug	C-41154-A	100%	REJECT INSPECT			
222 REM IMAX Heading Plug	C-41154-C	100%	REJECT INSPECT			
223 REM MIN Heading Plug	C-41155-A	100%	REJECT INSPECT			
223 REM IMAX Heading Plug	C-41155-C	100%	REJECT INSPECT			
223 REM MIN Heading Plug	C-41155-A	100%	REJECT INSPECT			
223 REM IMAX Heading Plug	C-41155-C	100%	REJECT INSPECT			
223 REM MIN Heading Plug	C-41155-A	100%	REJECT INSPECT			
223 REM IMAX Heading Plug	C-41155-C	100%	REJECT INSPECT			
243 WIN MIN Heading Plug	C-41556-A	100%	REJECT INSPECT			
243 WIN IMAX Heading Plug	C-41556-C	100%	REJECT INSPECT			
243 WIN MIN Heading Plug	C-41556-A	100%	REJECT INSPECT			
243 WIN IMAX Heading Plug	C-41556-C	100%	REJECT			

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			INSPECT			
260 REM MIN Heading Plug	C-41556-A	100%	REJECT INSPECT			
260 REM IMAX Heading Plug	C-41556-C	100%	REJECT INSPECT			
308 WIN MIN Heading Plug	C-41556-A	100%	REJECT INSPECT			
308 WIN IMAX Heading Plug	C-41556-C	100%	REJECT INSPECT			
308 WIN MIN Heading Plug	C-41556-A	100%	REJECT INSPECT			
308 WIN IMAX Heading Plug	C-41556-C	100%	REJECT INSPECT			
7MM-08 REM MIN Heading Plug	C-41556-A	100%	REJECT INSPECT			
7MM-08 REM IMAX Heading Plug	C-41556-C	100%	REJECT INSPECT			
7MM-08 REM MIN Heading Plug	C-41556-A	100%	REJECT INSPECT			
7MM-08 REM IMAX Heading Plug	C-41556-C	100%	REJECT INSPECT			
204 RUGER MIN Heading Plug	C-5322-A	100%	REJECT INSPECT			
204 RUGER MAX Heading Plug	C-5322-C	100%	REJECT			

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204 RUGER IMAX Pkg	Heading C-5322-D	100%	INSPECT REJECT INSPECT REJECT						
Pieces Run:									Remington Arms Company, Inc. -- Ilion, New York

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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

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Tool Number	Tooling Description
40789	Dot Seen Marker
A-51082	Stylus
ETS-7583	Holding Fixture

PROCESS CONTROL INSPECTION RECORD THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES			Revision Date: 7-Jun-05			Processed by:
Part No:	Part Name: Fin Assy 700 VLS		Centerfire Rifle			Date: 8/14/2006
Operation No: 655	Operation: Mark Bolt to Match Receiver Serial					Work Center:
Prod. Qty:	Prod. Order #:	Operator			Setup Inspected by & Date:	
Gage Description and Characteristic	Gage Number	Gage Frequency	1st Shift	2nd Shift	3rd Shift	Remarks: Causes, Action Taken, Etc.
VISUAL	VISUAL	100%	INSPECT			
			REJECT			
			INSPECT			
			REJECT			
			INSPECT			
			REJECT			
			INSPECT			
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			REJECT			

Subject to Protective Order - Williams v. Remington

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676

Pack Rifle

To Warehouse

Operation Step Detail

Operation: 676

Step

Operation / Step Description

Print Box End label and Pack Rifle

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

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8. Remove 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: If Box Assy. #1499 is used, Ethafoam blocks (2), are used to separate bottom tray pieces at center to ensure snug fit in 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 THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES		Revision Date: 7-Jun-05	Processed by:
Part No:	Part Name: Fin Assy 700 VLS	Centerfire Rifle	Date: 8/14/2006

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Operation No: 676
Prod. Qty:

ive Order - William

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Dept	Oper	Operation Description	Part Numbers
9132		Issue from Crib	27486 27490 27488 27494 27492 27496 27498 27491 27489 27495 27497 27499 27487 27493 27448 27450 27465 27445 27447 27467 27443
8761	395	INSPECT COMPONENTS BEFORE BEADING	27486 27490 27488 27494 27492 27496 27498 27491 27489 27495 27497 27499 27487 27493 27448 27450 27465 27445 27447 27467 27443
8761	400	Fit and Head Bolt Assembly to Barrel Assembly (SHOULDER SINGLE PASS)	27496 27498 27487 27497 27499 27465
8761	405	Fit and Head Bolt Assembly to Barrel Assembly (SHOULDER SINGLE PASS: Smaller than .25 caliber)	27486 27490 27488 27494 27492 27491 27489 27495 27493 27448 27450 27445 27447 27467 27443
8761	425	Make Chamber Cast (Not Done on 100% of Product)	27486 27490 27488 27494 27492 27496 27498 27491 27489 27495 27497 27499 27487 27493 27448 27450 27465 27445 27447 27467 27443
8761	430	Ream Ejector Hole	27486 27490 27488 27494 27492 27496 27498 27491 27489 27495 27497 27499 27487 27493 27448 27450 27465 27445 27447 27467 27443

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Dept	Oper	Operation Description	Part Numbers
8761	435	Assemble Rivetless Extractor to Bolt	27486 27490 27488
			27494 27492 27496
			27498 27491 27489
			27495 27497 27499
			27487 27493 27448
			27450 27465 27445
			27447 27467 27443
8761	440	Assemble Ejector to Ejector Spring and then Assemble to Bolt with Ejector Cross Pin	27486 27490 27488
			27494 27492 27496
			27498 27491 27489
			27495 27497 27499
			27487 27493 27448
			27450 27465 27445
			27447 27467 27443
8761	460R	Strip Defective Barrel Assembly Complete	27486 27490 27488
			27494 27492 27496
			27498 27491 27489
			27495 27497 27499
			27487 27493 27448
			27450 27465 27445
			27447 27467 27443
8761	465R	Strip Defective Bolt	27486 27490 27488
			27494 27492 27496
			27498 27491 27489
			27495 27497 27499
			27487 27493 27448
			27450 27465 27445
			27447 27467 27443
8761	580	Assemble Action	27486 27490 27488
			27494 27492 27496
			27498 27491 27489
			27495 27497 27499
			27487 27493 27448
			27450 27465 27445
			27447 27467 27443
8761	585	Assemble Stock to Action and Attach Hang Tag to Trigger Guard	27486 27490 27488
			27494 27492 27496
			27498 27491 27489
			27495 27497 27499
			27487 27493 27448
			27450 27465 27445

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Dept	Oper	Operation Description	Part Numbers
			27447 27467 27443
8761	593	Assemble Front Swivel Screw and Swivel Screw	27486 27490 27488
		Spacer to Stock	27494 27492 27496
			27498 27491 27489
			27495 27497 27499
			27487 27493 27448
			27450 27465 27445
			27447 27467 27443
8785	600	Proof Test	27486 27490 27488
			27494 27492 27496
			27498 27491 27489
			27495 27497 27499
			27487 27493 27448
			27450 27465 27445
			27447 27467 27443
8785	600R	Proof Test with slave bolt	27486 27490 27488
			27494 27492 27496
			27498 27491 27489
			27495 27497 27499
			27487 27493 27448
			27450 27465 27445
			27447 27467 27443
8785	605R	Check Repaired Guns Returning to Gallery for Proof Stamp, Brick Punch and Obstruction In Barrel	27486 27490 27488
			27494 27492 27496
			27498 27491 27489
			27495 27497 27499
			27487 27493 27448
			27450 27465 27445
			27447 27467 27443
8785	606	Test and Target	27486 27490 27488
			27494 27492 27496
			27498 27491 27489
			27497 27499 27487
			27448 27450 27465
			27445 27447 27467
			27443
8785	610	Test and Target 100%	27493 27495
8785	620	Inspect For Live Ammunition	27486 27490 27488
			27494 27492 27496

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Dept	Oper	Operation Description	Part Numbers
			27488 27491 27489
			27495 27497 27499
			27487 27493 27448
			27450 27465 27445
			27447 27467 27443
8786	640	Final Inspection	27486 27490 27488
			27494 27492 27496
			27498 27491 27489
			27495 27497 27499
			27487 27493 27448
			27450 27465 27445
			27447 27467 27443
8761	648	Reset trigger pull within specs as needed - not done on 100% of the product	27486 27490 27488
			27494 27492 27496
			27498 27491 27489
			27495 27497 27499
			27487 27493 27448
			27450 27465 27445
			27447 27467 27443
8786	650	Inspect Heading and Sear Lift	27486 27490 27488
			27494 27492 27496
			27498 27491 27489
			27495 27497 27499
			27487 27493 27448
			27450 27465 27445
			27447 27467 27443
8786	655	Mark Bolt to Match Receiver Serial Number Using Dot Peen Marking Machine	27486 27490 27488
			27494 27492 27496
			27498 27491 27489
			27495 27497 27499
			27487 27493 27448
			27450 27465 27445
			27447 27467 27443
8786	676	Pack Rifle To Warehouse	27486 27490 27488
			27494 27492 27496
			27498 27491 27489
			27495 27497 27499
			27487 27493 27448
			27450 27465 27445
			27447 27467 27443

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Dept	Oper	Operation Description	Part Numbers
01	2	01	01
02	0	01	01
03	0	01	01
04	0	01	01
05	0	01	01
06	0	01	01
07	0	01	01
08	0	01	01
09	0	01	01
10	0	01	01
11	0	01	01
12	0	01	01
13	0	01	01
14	0	01	01
15	0	01	01
16	0	01	01
17	0	01	01
18	0	01	01
19	0	01	01
20	0	01	01
21	0	01	01
22	0	01	01
23	0	01	01
24	0	01	01
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26	0	01	01
27	0	01	01
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99	0	01	01

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Parent	Rv	Child	End	Oper	Qty	UM	Description
							RAMACH DESCRIPTION
							27486 700 VLS - 222 REM
							27490 700 VLS - 223 REM
							27488 700 VLS - 22-250 REM
							27484 700 VLS - 243 WIN
							27492 700 VLS - 6MM REM
							27496 700 VLS - 7MM-08 REM
							27498 700 VLS - 308 WIN
							27467 700 VLS - 204 RUGER
							27491 700 VLS - 223 REM (HEAVY STOCK)
							27489 700 VLS - 22-250 REM (HEAVY STOCK)
							27495 700 VLS - 243 WIN (HEAVY STOCK)
							27493 700 VLS - 6MM REM (HEAVY STOCK)
							27487 700 VLS - 260 REM (HEAVY STOCK)
							27497 700 VLS - 7MM-08 REM (HEAVY STOCK)
							27499 700 VLS - 308 WIN (HEAVY STOCK)
							27448 700 VLS - 223 REM (NO FLUTES)
							27450 700 VLS - 22-250 REM (NO FLUTES)
							27465 700 VLS - 308 Win (NO FLUTES)
							27443 700 VLS - 204 RUGER BROWN LAM STK
							W/THUMBHOLE (NO FLUTES)
							27445 700 VLS - 223 REM BROWN LAM STK
							W/THUMBHOLE (NO FLUTES)
							27447 700 VLS - 22-250 REM BROWN LAM STK
							W/THUMBHOLE (NO FLUTES)
27465							700 VLS - 308 WIN (NO FLUTES) Limited Run
		301042	502	676	1.000		Cable Lock
		109372	17	395	1.000		Barrel Assembly
		105442	27	395	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
		3899	20	676	1.000		Instruction Book
		17917	400	440	1.000		Ejector
		94555	410	440	1.000		Ejector Pin
		17019	420	440	1.000		Ejector Spring
		1333	250	676	2.000		Ethafoam Insert

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Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
		93712	430	435	1.000		Extractor
		305640	190	580	1.000		Firing Pin Assy
		106291	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
		21723	260	600	1.100		PROOF ROUND
		106292	170	585	1.000		Rear Guard Screw
		17034	90	580	4.000		Receiver Plug Screws
		1499	10	676	1.000		RF-CF Carton
		24476	70	580	1.000		Sear Pin
		99976	210	585	1.000		Stock Assy - Brown Laminate
		21485	505	606	2.000		TEST ROUND 308 WIN 168 gr.BT HP MATCH
		21485	270	606	3.500		TARGET ROUND 308 WIN 168 gr.BT HP MATCH
		97490	120	580	1.000		Trigger Assy
		97867	160	585	1.000		Trigger Guard Assy
27448							700 ML3 - 223 REM (NO FLUTES)
		301049	502	676	1.000		Cable Lock
		109370	17	395	1.000		Barrel Assembly
		105443	27	395	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
		1333	250	676	2.000		Ethefoam Insert
		93712	430	435	1.000		Extractor
		305640	190	580	1.000		Firing Pin Assy
		106291	180	585	1.000		Front Guard Screw
		106670	130	580	1.000		Magazine
		92508	80	585	1.000		Magazine Follower
		91133	40	585	1.000		Magazine Spring
		98880	300	585	1.000		Floor Plate Insert
		21774	260	600	1.100		PROOF ROUND
		106292	170	585	1.000		Rear Guard Screw
		17034	90	580	4.000		Receiver Plug Screws
		1499	10	676	1.000		RF-CF Carton
		24476	70	580	1.000		Sear Pin
		99976	210	585	1.000		Stock Assy - Black Laminate
		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

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Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
		97867	160	585	1.000		Trigger Guard Assy
27450							700 VLS - 22-250 REM (NO FLUTES)
		301049	502	676	1.000		Cable Lock
		109371	17	395	1.000		Barrel Assembly
		105442	27	395	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
		1333	250	676	2.000		Etheron Insert
		93712	430	435	1.000		Extractor
		305640	190	580	1.000		Firing Pin Assy
		106291	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
		21853	260	600	1.100		PROOF ROUND
		106292	170	585	1.000		Rear Guard Screw
		17034	90	580	4.000		Receiver Plug Screws
		1499	10	676	1.000		RF-CF Carton
		24476	70	580	1.000		Sear Pin
		201839	210	585	1.000		Stock Assy - Black Laminate
		21313	505	606	2.000		TEST ROUND 22-250 REM 55 gr.PSP
		21313	270	606	2.500		TARGET ROUND 22-250 REM 55 gr.PSP
		97490	120	580	1.000		Trigger Assy
		97867	160	585	1.000		Trigger Guard Assy
27486							700 VLS - 222 REM
		301049	502	676	1.000		Cable Lock
		106645	47	395	1.000		Barrel Assembly (26")
		99166	37	395	1.000		Bolt Assembly
		17013	100	580	1.000		Bolt Stop
		24475	140	580	1.000		Bolt Stop Pin
		15224	30	580	1.000		Bolt Stop Spring
		993002	240	676	1.000		Box & Envelope Label
		1499	10	676	1.000		Carton Assembly
		3509	20	676	1.000		Document Envelope Assembly
		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

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Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
		305637	130	580	1.000		Firing Pin Assembly
		98880	300	585	1.000		Floor Plate Insert
		104127	260	585	1.000		Front Guard Screw
		106605	90	580	1.000		Magazine Assembly
		92508	190	585	1.000		Magazine Follower
		91133	200	585	1.000		Magazine Spring
		21696	310	600	1.100		PROOF ROUND
		104126	250	585	1.000		Rear Guard Screw
		17034	110	580	4.000		Receiver Plug Screw
		24476	150	580	1.000		Sear Pin
		99976	240	585	1.000		Stock Assembly
		15358	60	593	2.000		Swivel Screw
		94241	210	593	2.000		Swivel Screw Spacer
		21303	505	606	2.000		TEST ROUND 222 REM 50 gr.PSP
		21303	321	606	3.500		TARGET ROUND 222 REM 50 gr.PSP
		26345	160	580	1.000		Trigger Assembly
		202286	170	585	1.000		Trigger Guard Assembly
27490							700 VES - 223 REM
		301049	502	676	1.000		Cable Lock
		106646	47	395	1.000		Barrel Assembly (26")
		99166	37	395	1.000		Bolt Assembly
		17013	100	580	1.000		Bolt Stop
		24475	140	580	1.000		Bolt Stop Pin
		15224	30	580	1.000		Bolt Stop Spring
		993002	290	676	1.000		Box & Envelope Label
		1499	10	676	1.000		Carton Assembly
		3509	20	676	1.000		Document Envelope Assembly
		17017	400	440	1.000		Ejector
		94555	410	440	1.000		Ejector Pin
		17019	420	440	1.000		Ejector Spring
		97138	430	433	1.000		Extractor
		305637	130	580	1.000		Firing Pin Assembly
		98880	300	585	1.000		Floor Plate Insert
		104127	260	585	1.000		Front Guard Screw
		106605	90	580	1.000		Magazine Assembly
		92508	190	585	1.000		Magazine Follower
		91133	200	585	1.000		Magazine Spring
		21774	310	600	1.100		PROOF ROUND
		104126	250	585	1.000		Rear Guard Screw
		17034	110	580	4.000		Receiver Plug Screw
		24476	150	580	1.000		Sear Pin
		99976	240	585	1.000		Stock Assembly
		15358	60	593	2.000		Swivel Screw
		94241	210	593	2.000		Swivel Screw Spacer
		28399	505	606	2.000		TEST ROUND 223 REM 55 gr.PSP

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Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
		28399	320	606	3.500		TARGET ROUND 223 REM 55 gr.PSP
		26345	160	580	1.000		Trigger Assembly
		202286	170	585	1.000		Trigger Guard Assembly
27488							700 VLS - 22-250 REM
		301049	502	676	1.000		Cable Lock
		106647	47	395	1.000		Barrel Assembly (26")
		98079	37	395	1.000		Bolt Assembly
		17013	100	580	1.000		Bolt Stop
		24475	140	580	1.000		Bolt Stop Pin
		15224	30	580	1.000		Bolt Stop Spring
		993002	280	676	1.000		Box & Envelope Label
		1499	10	676	1.000		Carton Assembly
		3509	20	676	1.000		Document Envelope Assembly
		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
		305637	130	580	1.000		Firing Pin Assembly
		104127	250	585	1.000		Front Guard Screw
		16715	90	580	1.000		Magazine
		90982	190	585	1.000		Magazine Follower
		15699	60	585	1.000		Magazine Spring
		21853	310	600	1.100		PROOF ROUND
		104126	240	585	1.000		Rear Guard Screw
		17034	110	580	1.000		Receiver Plug Screw
		24476	150	580	1.000		Sear Pin
		99976	230	585	1.000		Stock Assembly
		15358	50	593	2.000		Swivel Screw
		94241	200	593	2.000		Swivel Screw Spacer
		21313	500	606	2.000		TEST ROUND 22-250 REM 55 gr.HPPL
		21313	320	606	3.500		TARGET ROUND 22-250 REM 55 gr.HPPL
		26345	160	580	1.000		Trigger Assembly
		202286	170	585	1.000		Trigger Guard Assembly
27494							700 VLS - 243 WIN
		301049	502	676	1.000		Cable Lock
		106648	47	395	1.000		Barrel Assembly (26")
		98079	37	395	1.000		Bolt Assembly
		17013	100	580	1.000		Bolt Stop
		24475	140	580	1.000		Bolt Stop Pin
		15224	30	580	1.000		Bolt Stop Spring
		993002	280	676	1.000		Box & Envelope Label
		1499	10	676	1.000		Carton Assembly
		3509	20	676	1.000		Document Envelope Assembly
		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
		305637	120	580	1.000		Firing Pin Assembly
		104127	240	585	1.000		Front Guard Screw
		16715	90	580	1.000		Magazine
		90982	180	585	1.000		Magazine Follower
		15699	60	585	1.000		Magazine Spring
		21699	290	600	1.175		PROOF ROUND
		104126	230	585	1.000		Rear Guard Screw
		17034	110	580	4.000		Receiver Plug Screw
		24476	140	580	1.000		Sear Pin
		99976	220	585	1.000		Stock Assembly
		15358	50	593	2.000		Swivel Screw
		94241	190	593	2.000		Swivel Screw Spacer
		27802	505	606	2.000		TEST ROUND 243 WIN 100 gr.PSPCL
		21319	200	610	3.500		TARGET ROUND 243 WIN 80 gr.HP
		26345	150	580	1.000		Trigger Assembly
		202286	160	585	1.000		Trigger Guard Assembly
27492							700 VLS - 6MM REM
		301049	502	676	1.000		Cable Lock
		106649	47	395	1.000		Barrel Assembly (26")
		98079	37	395	1.000		Bolt Assembly
		17013	100	580	1.000		Bolt Stop
		24475	140	580	1.000		Bolt Stop Pin
		15224	30	580	1.000		Bolt Stop Spring
		993002	210	676	1.000		Box & Envelope Label
		1499	10	676	1.000		Carton Assembly
		3509	20	676	1.000		Document Envelope Assembly
		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
		305637	130	580	1.000		Firing Pin Assembly
		104127	250	585	1.000		Front Guard Screw
		16715	90	580	1.000		Magazine
		90982	190	585	1.000		Magazine Follower
		15699	60	585	1.000		Magazine Spring
		21844	260	600	1.095		PROOF ROUND
		104126	240	585	1.000		Rear Guard Screw
		17034	110	580	4.000		Receiver Plug Screw
		24476	150	580	1.000		Sear Pin
		99976	230	585	1.000		Stock Assembly
		15358	50	593	2.000		Swivel Screw
		94241	200	593	2.000		Swivel Screw Spacer

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Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
		20951	505	606	2.000		Test Round 6MM REM 100 gr.PSP
		20951	270	606	3.500		Target Round 6MM REM 100 gr.PSP
		26345	160	580	1.000		Trigger Assembly
		202286	170	585	1.000		Trigger Guard Assembly
27496							700 VLS - 7MM-08 REM
		301049	502	676	1.000		Cable Lock
		106650	47	395	1.000		Barrel Assembly (26")
		98079	37	395	1.000		Bolt Assembly
		17013	100	580	1.000		Bolt Stop
		24475	140	580	1.000		Bolt Stop Pin
		15224	30	580	1.000		Bolt Stop Spring
		993002	280	676	1.000		Box & Envelope Label
		1499	10	676	1.000		Carton Assembly
		3509	20	676	1.000		Document Envelope Assembly
		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
		305637	130	580	1.000		Firing Pin Assembly
		104127	250	585	1.000		Front Guard Screw
		16715	90	580	1.000		Magazine
		90982	190	585	1.000		Magazine Follower
		15699	60	585	1.000		Magazine Spring
		21779	290	600	1.100		PROOF ROUND
		104126	240	585	1.000		Rear Guard Screw
		17034	110	580	4.000		Receiver Plug Screw
		24476	150	580	1.000		Sear Pin
		99976	230	585	1.000		Stock Assembly
		15358	50	593	2.000		Swivel Screw
		94241	200	593	2.000		Swivel Screw Spacer
		21337	500	606	2.000		TEST ROUND 7MM-08 REM 140 gr.PSP
		21337	300	606	8.000		TARGET ROUND 7MM-08 REM 140 gr.PSP
		26345	160	580	1.000		Trigger Assembly
		202286	170	585	1.000		Trigger Guard Assembly
27498							700 VLS - 308 WIN
		301049	502	676	1.000		Cable Lock
		106651	47	395	1.000		Barrel Assembly (26")
		98079	37	395	1.000		Bolt Assembly
		17013	100	580	1.000		Bolt Stop
		24475	140	580	1.000		Bolt Stop Pin
		15224	30	580	1.000		Bolt Stop Spring
		993002	280	676	1.000		Box & Envelope Label
		1499	10	676	1.000		Carton Assembly
		3509	20	676	1.000		Document Envelope Assembly

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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
		93712	430	435	1.000		Extractor
		305637	130	580	1.000		Firing Pin Assembly
		104127	250	585	1.000		Front Guard Screw
		16715	90	580	1.000		Magazine
		90982	190	585	1.000		Magazine Follower
		15699	60	585	1.000		Magazine Spring
		21723	290	600	1.190		PROOF ROUND
		104126	240	585	1.000		Rear Guard Screw
		17034	110	580	4.000		Receiver Plug Screw
		24476	150	580	1.000		Sear Pin
		99976	230	585	1.000		Stock Assembly
		15358	50	593	2.000		Swivel Screw
		94241	200	593	2.000		Swivel Screw Spacer
		21485	505	606	2.000		TEST ROUND 308 WIN 168 gr.BT HP MATCH
		21485	300	606	3.500		TARGET ROUND 308 WIN 168 gr.BT HP MATCH
		26345	160	580	1.000		Trigger Assembly
		202286	170	585	1.000		Trigger Guard Assembly
27467							700 VLS - 204 RUGER
		301049	502	676	1.000		Cable Lock
		245502	47	395	1.000		Barrel Assembly (26")
		99166	37	395	1.000		Bolt Assembly
		17013	100	580	1.000		Bolt Stop
		24475	140	580	1.000		Bolt Stop Pin
		15224	30	580	1.000		Bolt Stop Spring
		993002	290	676	1.000		Box & Envelope Label
		1499	10	676	1.000		Carton Assembly
		3509	20	676	1.000		Document Envelope Assembly
		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
		305637	130	580	1.000		Firing Pin Assembly
		98880	300	585	1.000		Floor Plate Insert
		104127	250	585	1.000		Front Guard Screw
		106605	90	580	1.000		Magazine Assembly
		98880	350	585	1.000		Floor Plate Insert
		92508	190	585	1.000		Magazine Follower
		91133	200	585	1.000		Magazine Spring
		102309	310	600	1.100		PROOF ROUND
		104126	240	585	1.000		Rear Guard Screw
		17034	110	580	4.000		Receiver Plug Screw
		24476	150	580	1.000		Sear Pin

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Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
		99976	240	585	1.000		Stock Assembly
		15358	60	593	2.000		Swivel Screw
		94241	210	593	2.000		Swivel Screw Spacer
		29218	505	606	2.000		TEST ROUND 204 RUGER 32 gr.ACCUTIP
		29218	320	606	3.500		TARGET ROUND 204 RUGER 32 gr.ACCUTIP
		26345	160	580	1.000		Trigger Assembly
		202286	170	585	1.000		Trigger Guard Assembly
27491							700 VLS - 223 REM (HEAVY FOREARM STOCK)
		301049	502	676	1.000		Cable Lock
		106646	47	395	1.000		Barrel Assembly (26")
		99166	37	395	1.000		Bolt Assembly
		17013	100	580	1.000		Bolt Stop
		24475	140	580	1.000		Bolt Stop Pin
		15224	30	580	1.000		Bolt Stop Spring
		993002	290	676	1.000		Box & Envelope Label
		1499	10	676	1.000		Carton Assembly
		3509	20	676	1.000		Document Envelope Assembly
		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
		305637	130	580	1.000		Firing Pin Assembly
		98880	300	585	1.000		Floor Plate Insert
		104127	260	585	1.000		Front Guard Screw
		106605	90	580	1.000		Magazine Assembly
		92508	190	585	1.000		Magazine Follower
		91133	200	585	1.000		Magazine Spring
		21774	310	600	1.100		PROOF ROUND
		104126	250	585	1.000		Rear Guard Screw
		17034	110	580	4.000		Receiver Plug Screw
		24476	130	580	1.000		Sear Pin
		99976	240	585	1.000		Stock Assembly
		15358	60	593	2.000		Swivel Screw
		94241	210	593	2.000		Swivel Screw Spacer
		28399	505	606	2.000		TEST ROUND 223 REM 55 gr.PSP
		28399	320	606	3.500		TARGET ROUND 223 REM 55 gr.PSP
		26345	160	580	1.000		Trigger Assembly
		202286	170	585	1.000		Trigger Guard Assembly
27489							700 VLS - 22-250 REM (HEAVY FOREARM STOCK)
		301049	502	676	1.000		Cable Lock
		106647	47	395	1.000		Barrel Assembly (26")
		98079	37	395	1.000		Bolt Assembly
		17013	100	580	1.000		Bolt Stop
		24475	140	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	280	676	1.000		Box & Envelope Label
		1499	10	676	1.000		Carton Assembly
		3509	20	676	1.000		Document Envelope Assembly
		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
		305637	130	580	1.000		Firing Pin Assembly
		104127	250	585	1.000		Front Guard Screw
		16715	90	580	1.000		Magazine
		90982	190	585	1.000		Magazine Follower
		15699	60	585	1.000		Magazine Spring
		21853	310	600	1.100		PROOF ROUND
		104126	240	585	1.000		Rear Guard Screw
		17034	110	580	4.000		Receiver Plug Screw
		24476	150	580	1.000		Sear Pin
		99976	230	585	1.000		Stock Assembly
		15358	50	593	2.000		Swivel Screw
		94241	200	593	2.000		Swivel Screw Spacer
		21313	505	606	2.000		TEST ROUND 22-250 REM 55 gr.HPPL
		21313	320	606	2.500		TARGET ROUND 22-250 REM 55 gr.HPPL
		26345	160	580	1.000		Trigger Assembly
		202286	170	585	1.000		Trigger Guard Assembly
27495							700 VLS - 243 WIN (HEAVY FOREARM STOCK)
		301049	502	676	1.000		Cable Lock
		106648	47	395	1.000		Barrel Assembly (26")
		98079	37	395	1.000		Bolt Assembly
		17013	100	580	1.000		Bolt Stop
		24475	130	580	1.000		Bolt Stop Pin
		15224	30	580	1.000		Bolt Stop Spring
		993002	280	676	1.000		Box & Envelope Label
		1499	10	676	1.000		Carton Assembly
		3509	20	676	1.000		Document Envelope Assembly
		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
		305637	130	580	1.000		Firing Pin Assembly
		104127	250	585	1.000		Front Guard Screw
		16715	90	580	1.000		Magazine
		90982	180	585	1.000		Magazine Follower
		15699	60	585	1.000		Magazine Spring
		21699	290	600	1.175		PROOF ROUND
		104126	230	585	1.000		Rear Guard Screw

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Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
		17034	110	580	4.000		Receiver Plug Screw
		24476	140	580	1.000		Sear Pin
		99976	220	585	1.000		Stock Assembly
		15358	50	593	2.000		Swivel Screw
		94241	190	593	2.000		Swivel Screw Spacer
		21319	200	610	8.000		TARGET ROUNDS 243 WIN 80 gr.HP
		26345	150	580	1.000		Trigger Assembly
		202286	160	585	1.000		Trigger Guard Assembly
27493							700 VLS - 6MM REM (HEAVY STOCK)
		301049	502	676	1.000		Cable Lock
		106649	47	395	1.000		Barrel Assembly (26")
		98079	37	395	1.000		Bolt Assembly
		17013	100	580	1.000		Bolt Stop
		24475	140	580	1.000		Bolt Stop Pin
		15224	30	580	1.000		Bolt Stop Spring
		993002	210	676	1.000		Box & Envelope Label
		1499	10	676	1.000		Carton Assembly
		3509	20	676	1.000		Document Envelope Assembly
		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
		305637	130	580	1.000		Firing Pin Assembly
		104127	250	585	1.000		Front Guard Screw
		16715	90	580	1.000		Magazine
		90982	190	585	1.000		Magazine Follower
		15699	60	585	1.000		Magazine Spring
		21844	260	600	1.000		PROOF ROUND
		104126	240	585	1.000		Rear Guard Screw
		17034	110	580	4.000		Receiver Plug Screw
		24476	140	580	1.000		Sear Pin
		99976	220	585	1.000		Stock Assembly
		15358	50	593	2.000		Swivel Screw
		94241	200	593	2.000		Swivel Screw Spacer
		20951	270	606	8.000		Target 6MM REM 100 gr.PSP
		26345	160	580	1.000		Trigger Assembly
		202286	170	585	1.000		Trigger Guard Assembly
27487							700 VLS - 260 REM (HEAVY FOREARM STOCK)
		301049	502	676	1.000		Cable Lock
		106649	47	395	1.000		Barrel Assembly (26")
		98079	37	395	1.000		Bolt Assembly
		17013	100	580	1.000		Bolt Stop
		24475	140	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	280	676	1.000		Box & Envelope Label
		1499	10	676	1.000		Carton Assembly
		3509	20	676	1.000		Document Envelope Assembly
		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
		305637	120	580	1.000		Firing Pin Assembly
		104127	240	585	1.000		Front Guard Screw
		16715	90	580	1.000		Magazine
		90982	180	585	1.000		Magazine Follower
		15699	60	585	1.000		Magazine Spring
		21770	290	600	1.175		PROOF ROUND
		104126	230	585	1.000		Rear Guard Screw
		17034	110	580	4.000		Receiver Plug Screw
		24476	140	580	1.000		Sear Pin
		99976	220	585	1.000		Stock Assembly
		15358	50	593	2.000		Swivel Screw
		94241	190	593	2.000		Swivel Screw Spacer
		21292	505	606	2.000		TEST ROUND 260 REM 140 gr.PSPCL
		21292	310	606	3.500		TARGET ROUND 260 REM 140 gr.PSPCL
		26345	150	580	1.000		Trigger Assembly
		202286	160	585	1.000		Trigger Guard Assembly
27497							700 VLS - 7MM-08 REM (HEAVY FOREARM STOCK
		301049	502	676	1.000		Cable Lock
		106650	47	395	1.000		Barrel Assembly (26")
		98079	37	395	1.000		Bolt Assembly
		17013	100	580	1.000		Bolt Stop
		24475	140	580	1.000		Bolt Stop Pin
		15224	30	580	1.000		Bolt Stop Spring
		993002	280	676	1.000		Box & Envelope Label
		1499	10	676	1.000		Carton Assembly
		3509	20	676	1.000		Document Envelope Assembly
		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
		305637	120	580	1.000		Firing Pin Assembly
		104127	240	585	1.000		Front Guard Screw
		16715	90	580	1.000		Magazine
		90982	180	585	1.000		Magazine Follower
		15699	60	585	1.000		Magazine Spring
		21779	290	600	1.100		PROOF ROUND
		104126	240	585	1.000		Rear Guard Screw
		17034	110	580	4.000		Receiver Plug Screw

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Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
		24476	150	580	1.000		Sear Pin
		99976	230	585	1.000		Stock Assembly
		15358	50	593	2.000		Swivel Screw
		94241	200	593	2.000		Swivel Screw Spacer
		21337	505	606	2.000		TEST ROUND 7MM-08 REM 140 gr.PSP
		21337	300	606	8.000		TARGET ROUND 7MM-08 REM 140 gr.PSP
		26345	160	580	1.000		Trigger Assembly
		202286	170	585	1.000		Trigger Guard Assembly
27499							700 VLS - 308 WIN (HEAVY FOREARM STOCK)
		301049	502	676	1.000		Cable Lock
		106651	47	395	1.000		Barrel Assembly (26")
		98079	37	395	1.000		Bolt Assembly
		17013	100	580	1.000		Bolt Stop
		24475	140	580	1.000		Bolt Stop Pin
		15224	30	580	1.000		Bolt Stop Spring
		993002	280	676	1.000		Box & Envelope Label
		1499	10	676	1.000		Carton Assembly
		3509	20	676	1.000		Document Envelope Assembly
		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
		305637	130	580	1.000		Firing Pin Assembly
		104127	250	585	1.000		Front Guard Screw
		16715	90	580	1.000		Magazine
		90982	190	585	1.000		Magazine Follower
		15699	60	585	1.000		Magazine Spring
		21723	290	600	1.150		PROOF ROUND
		104126	240	585	1.000		Rear Guard Screw
		17034	110	580	4.000		Receiver Plug Screw
		24476	130	580	1.000		Sear Pin
		99976	230	585	1.000		Stock Assembly
		15358	50	593	2.000		Swivel Screw
		94241	200	593	2.000		Swivel Screw Spacer
		21485	505	606	2.000		TEST ROUND 308 WIN 168 gr. BT HP MATCH
		21485	300	606	3.500		TARGET ROUND 308 WIN 168 gr. BT HP MATCH
		26345	160	580	1.000		Trigger Assembly
		202286	170	585	1.000		Trigger Guard Assembly
27443							700 VLS - 204 RUGER BROWN LAM STK W/THUMBHOLE (NO FLUTES)
		301049	502	676	1.000		Cable Lock
		245503	17	395	1.000		Barrel Assembly
		105443	27	395	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
		1333	250	676	2.000		Ethefoam Insert
		93712	430	435	1.000		Extractor
		305640	190	580	1.000		Firing Pin Assy
		106293	180	585	1.000		Front Guard Screw
		106770	130	580	1.000		Magazine
		92508	80	585	1.000		Magazine Follower
		91133	40	585	1.000		Magazine Spring
		98880	300	585	1.000		Floor Plate Insert
		202309	260	600	1.100		PROOF ROUND
		106292	170	585	1.000		Rear Guard Screw
		17034	90	580	4.000		Receiver Plug Screws
		1688	10	676	1.000		RF-CF Carton
		24476	70	580	1.000		Seal Pin
		202187	210	585	1.000		Stock Assy - Brown Laminate W/ Thumbhole
		15358	510	593	2.000		Swivel Screw
		94241	530	593	2.000		Swivel Screw Spacer
		29218	505	606	2.000		TEST ROUND 204 RUGER 32 gr. ACCUTIP
		29218	270	606	3.500		TARGET ROUND 204 RUGER 32 gr. ACCUTIP
		97490	120	580	1.000		Trigger Assy
		97867	160	585	1.000		Trigger Guard Assy
27445							223 REM BRN LAM W/THUMBHOLE (NO FLUTES)
		301049	502	676	1.000		Cable Lock
		109370	17	395	1.000		Barrel Assembly
		105443	27	395	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
		1333	250	676	2.000		Ethefoam Insert
		93712	430	435	1.000		Extractor
		305640	190	580	1.000		Firing Pin Assy
		106293	180	585	1.000		Front Guard Screw
		106770	130	580	1.000		Magazine
		92508	80	585	1.000		Magazine Follower

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Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
		91133	40	585	1.000		Magazine Spring
		98880	300	585	1.000		Floor Plate Insert
		21774	260	600	1.100		PROOF ROUND
		106292	170	585	1.000		Rear Guard Screw
		17034	90	580	4.000		Receiver Plug Screws
		1688	10	676	1.000		RF-CF Carton
		24476	70	580	1.000		Sear Pin
		202187	210	585	1.000		Stock Assy - Brown Laminate W/ Thumbhole
		15358	510	593	2.000		Swivel Screw
		94241	530	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	160	585	1.000		Trigger Guard Assy
27447							22-250 REM BRN LAM W/THUMBHOLE (NO FLUTES)
		301049	502	676	1.000		Cable Lock
		109371	17	395	1.000		Barrel Assembly
		105442	27	395	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
		1333	250	676	2.000		Ethefoam Insert
		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
		21853	260	600	1.100		PROOF ROUND
		106292	170	585	1.000		Rear Guard Screw
		17034	90	580	4.000		Receiver Plug Screws
		1688	10	676	1.000		RF-CF Carton
		24476	70	580	1.000		Sear Pin
		202187	210	585	1.000		Stock Assy - Brown Laminate W/ Thumbhole
		15358	510	593	2.000		Swivel Screw
		94241	530	593	2.000		Swivel Screw Spacer
		21311	505	606	2.000		TEST ROUND 22-250 REM 55 gr.PSP
		21311	270	606	3.500		TARGET ROUND 22-250 REM 55 gr.PSP
		97490	120	580	1.000		Trigger Assy
		97867	160	585	1.000		Trigger Guard Assy

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Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
10	10	00	2	0	0	0	
20	10	00	0	0	0	0	
30	10	00	0	0	0	0	
40	10	00	0	0	0	0	
50	10	00	0	0	0	0	
60	10	00	0	0	0	0	
70	10	00	0	0	0	0	
80	10	00	0	0	0	0	
90	10	00	0	0	0	0	
100	10	00	0	0	0	0	
110	10	00	0	0	0	0	
120	10	00	0	0	0	0	
130	10	00	0	0	0	0	
140	10	00	0	0	0	0	
150	10	00	0	0	0	0	
160	10	00	0	0	0	0	
170	10	00	0	0	0	0	
180	10	00	0	0	0	0	
190	10	00	0	0	0	0	
200	10	00	0	0	0	0	
210	10	00	0	0	0	0	
220	10	00	0	0	0	0	
230	10	00	0	0	0	0	
240	10	00	0	0	0	0	
250	10	00	0	0	0	0	
260	10	00	0	0	0	0	
270	10	00	0	0	0	0	
280	10	00	0	0	0	0	
290	10	00	0	0	0	0	
300	10	00	0	0	0	0	
310	10	00	0	0	0	0	
320	10	00	0	0	0	0	
330	10	00	0	0	0	0	
340	10	00	0	0	0	0	
350	10	00	0	0	0	0	
360	10	00	0	0	0	0	
370	10	00	0	0	0	0	
380	10	00	0	0	0	0	
390	10	00	0	0	0	0	
400	10	00	0	0	0	0	
410	10	00	0	0	0	0	
420	10	00	0	0	0	0	
430	10	00	0	0	0	0	
440	10	00	0	0	0	0	
450	10	00	0	0	0	0	
460	10	00	0	0	0	0	
470	10	00	0	0	0	0	
480	10	00	0	0	0	0	
490	10	00	0	0	0	0	
500	10	00	0	0	0	0	
510	10	00	0	0	0	0	
520	10	00	0	0	0	0	
530	10	00	0	0	0	0	
540	10	00	0	0	0	0	
550	10	00	0	0	0	0	
560	10	00	0	0	0	0	
570	10	00	0	0	0	0	
580	10	00	0	0	0	0	
590	10	00	0	0	0	0	
600	10	00	0	0	0	0	
610	10	00	0	0	0	0	
620	10	00	0	0	0	0	
630	10	00	0	0	0	0	
640	10	00	0	0	0	0	
650	10	00	0	0	0	0	
660	10	00	0	0	0	0	
670	10	00	0	0	0	0	
680	10	00	0	0	0	0	
690	10	00	0	0	0	0	
700	10	00	0	0	0	0	
710	10	00	0	0	0	0	
720	10	00	0	0	0	0	
730	10	00	0	0	0	0	
740							

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Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
01	1.0	0.0	2	0	0	0	
02	1.0	0.0	0	0	0	0	
03	1.0	0.0	0	0	0	0	
04	1.0	0.0	0	0	0	0	
05	1.0	0.0	0	0	0	0	
06	1.0	0.0	0	0	0	0	
07	1.0	0.0	0	0	0	0	
08	1.0	0.0	0	0	0	0	
09	1.0	0.0	0	0	0	0	
10	1.0	0.0	0	0	0	0	
11	1.0	0.0	0	0	0	0	
12	1.0	0.0	0	0	0	0	
13	1.0	0.0	0	0	0	0	
14	1.0	0.0	0	0	0	0	
15	1.0	0.0	0	0	0	0	
16	1.0	0.0	0	0	0	0	
17	1.0	0.0	0	0	0	0	
18	1.0	0.0	0	0	0	0	
19	1.0	0.0	0	0	0	0	
20	1.0	0.0	0	0	0	0	
21	1.0	0.0	0	0	0	0	
22	1.0	0.0	0	0	0	0	
23	1.0	0.0	0	0	0	0	
24	1.0	0.0	0	0	0	0	
25	1.0	0.0	0	0	0	0	
26	1.0	0.0	0	0	0	0	
27	1.0	0.0	0	0	0	0	
28	1.0	0.0	0	0	0	0	
29	1.0	0.0	0	0	0	0	
30	1.0	0.0	0	0	0	0	
31	1.0	0.0	0	0	0	0	
32	1.0	0.0	0	0	0	0	
33	1.0	0.0	0	0	0	0	
34	1.0	0.0	0	0	0	0	
35	1.0	0.0	0	0	0	0	
36	1.0	0.0	0	0	0	0	
37	1.0	0.0	0	0	0	0	
38	1.0	0.0	0	0	0	0	
39	1.0	0.0	0	0	0	0	
40	1.0	0.0	0	0	0	0	
41	1.0	0.0	0	0	0	0	
42	1.0	0.0	0	0	0	0	
43	1.0	0.0	0	0	0	0	
44	1.0	0.0	0	0	0	0	
45	1.0	0.0	0	0	0	0	
46	1.0	0.0	0	0	0	0	
47	1.0	0.0	0	0	0	0	
48	1.0	0.0	0	0	0	0	
49	1.0	0.0	0	0	0	0	
50	1.0	0.0	0	0	0	0	
51	1.0	0.0	0	0	0	0	
52	1.0	0.0	0	0	0	0	
53	1.0	0.0	0	0	0	0	
54	1.0	0.0	0	0	0	0	
55	1.0	0.0	0	0	0	0	
56	1.0	0.0	0	0	0	0	
57	1.0	0.0	0	0	0	0	
58	1.0	0.0	0	0	0	0	
59	1.0	0.0	0	0	0	0	
60	1.0	0.0	0	0	0	0	
61	1.0	0.0	0	0	0	0	
62	1.0	0.0	0	0	0	0	
63	1.0	0.0	0	0	0	0	
64	1.0	0.0	0	0	0	0	
65	1.0	0.0	0	0	0	0	
66	1.0	0.0	0	0	0	0	
67	1.0	0.0	0	0	0	0	
68	1.0	0.0	0	0	0	0	
69	1.0	0.0	0	0	0	0	
70	1.0	0.0	0	0	0	0	
71	1.0	0.0	0	0	0	0	
72	1.0	0.0	0	0	0	0	</

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Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
10	10	00	2	0	0	0	
20	10	20	0	0	0	0	
30	10	30	0	0	0	0	
40	10	40	0	0	0	0	
50	10	50	0	0	0	0	
60	10	60	0	0	0	0	
70	10	70	0	0	0	0	
80	10	80	0	0	0	0	
90	10	90	0	0	0	0	
100	10	00	0	0	0	0	
110	10	10	0	0	0	0	
120	10	20	0	0	0	0	
130	10	30	0	0	0	0	
140	10	40	0	0	0	0	
150	10	50	0	0	0	0	
160	10	60	0	0	0	0	
170	10	70	0	0	0	0	
180	10	80	0	0	0	0	
190	10	90	0	0	0	0	
200	10	00	0	0	0	0	
210	10	10	0	0	0	0	
220	10	20	0	0	0	0	
230	10	30	0	0	0	0	
240	10	40	0	0	0	0	
250	10	50	0	0	0	0	
260	10	60	0	0	0	0	
270	10	70	0	0	0	0	
280	10	80	0	0	0	0	
290	10	90	0	0	0	0	
300	10	00	0	0	0	0	
310	10	10	0	0	0	0	
320	10	20	0	0	0	0	
330	10	30	0	0	0	0	
340	10	40	0	0	0	0	
350	10	50	0	0	0	0	
360	10	60	0	0	0	0	
370	10	70	0	0	0	0	
380	10	80	0	0	0	0	
390	10	90	0	0	0	0	
400	10	00	0	0	0	0	
410	10	10	0	0	0	0	
420	10	20	0	0	0	0	
430	10	30	0	0	0	0	
440	10	40	0	0	0	0	
450	10	50	0	0	0	0	
460	10	60	0	0	0	0	
470	10	70	0	0	0	0	
480	10	80	0	0	0	0	
490	10	90	0	0	0	0	
500	10	00	0	0	0	0	
510	10	10	0	0	0	0	
520	10	20	0	0	0	0	
530	10	30	0	0	0	0	
540	10	40	0	0	0	0	
550	10	50	0	0	0	0	
560	10	60	0	0	0	0	
570	10	70	0	0	0	0	
580	10	80	0	0	0	0	
590	10	90	0	0	0	0	
600	10	00	0	0	0	0	
610	10	10	0	0	0	0	
620	10	20	0	0	0	0	
630	10	30	0	0	0	0	
640	10	40	0	0	0	0	
650	10	50	0	0	0	0	
660	10	60	0	0	0	0	
670	10	70	0	0	0	0	
680	10	80	0	0	0	0	
690	10	90	0	0	0	0	
700	10	00	0	0	0	0	
710	10	10	0	0	0	0	
720	10	20	0	0	0	0	
730	10	30	0	0	0	0	
740							

Printed on:
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Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
01	1.0	0.0	2	0	0	0	
02	1.0	0.0	0	0	0	0	
03	1.0	0.0	0	0	0	0	
04	1.0	0.0	0	0	0	0	
05	1.0	0.0	0	0	0	0	
06	1.0	0.0	0	0	0	0	
07	1.0	0.0	0	0	0	0	
08	1.0	0.0	0	0	0	0	
09	1.0	0.0	0	0	0	0	
10	1.0	0.0	0	0	0	0	
11	1.0	0.0	0	0	0	0	
12	1.0	0.0	0	0	0	0	
13	1.0	0.0	0	0	0	0	
14	1.0	0.0	0	0	0	0	
15	1.0	0.0	0	0	0	0	
16	1.0	0.0	0	0	0	0	
17	1.0	0.0	0	0	0	0	
18	1.0	0.0	0	0	0	0	
19	1.0	0.0	0	0	0	0	
20	1.0	0.0	0	0	0	0	
21	1.0	0.0	0	0	0	0	
22	1.0	0.0	0	0	0	0	
23	1.0	0.0	0	0	0	0	
24	1.0	0.0	0	0	0	0	
25	1.0	0.0	0	0	0	0	
26	1.0	0.0	0	0	0	0	
27	1.0	0.0	0	0	0	0	
28	1.0	0.0	0	0	0	0	
29	1.0	0.0	0	0	0	0	
30	1.0	0.0	0	0	0	0	
31	1.0	0.0	0	0	0	0	
32	1.0	0.0	0	0	0	0	
33	1.0	0.0	0	0	0	0	
34	1.0	0.0	0	0	0	0	
35	1.0	0.0	0	0	0	0	
36	1.0	0.0	0	0	0	0	
37	1.0	0.0	0	0	0	0	
38	1.0	0.0	0	0	0	0	
39	1.0	0.0	0	0	0	0	
40	1.0	0.0	0	0	0	0	
41	1.0	0.0	0	0	0	0	
42	1.0	0.0	0	0	0	0	
43	1.0	0.0	0	0	0	0	
44	1.0	0.0	0	0	0	0	
45	1.0	0.0	0	0	0	0	
46	1.0	0.0	0	0	0	0	
47	1.0	0.0	0	0	0	0	
48	1.0	0.0	0	0	0	0	
49	1.0	0.0	0	0	0	0	
50	1.0	0.0	0	0	0	0	
51	1.0	0.0	0	0	0	0	
52	1.0	0.0	0	0	0	0	
53	1.0	0.0	0	0	0	0	
54	1.0	0.0	0	0	0	0	
55	1.0	0.0	0	0	0	0	
56	1.0	0.0	0	0	0	0	
57	1.0	0.0	0	0	0	0	
58	1.0	0.0	0	0	0	0	
59	1.0	0.0	0	0	0	0	
60	1.0	0.0	0	0	0	0	
61	1.0	0.0	0	0	0	0	
62	1.0	0.0	0	0	0	0	
63	1.0	0.0	0	0	0	0	
64	1.0	0.0	0	0	0	0	
65	1.0	0.0	0	0	0	0	
66	1.0	0.0	0	0	0	0	
67	1.0	0.0	0	0	0	0	
68	1.0	0.0	0	0	0	0	
69	1.0	0.0	0	0	0	0	
70	1.0	0.0	0	0	0	0	
71	1.0	0.0	0	0	0	0	
72	1.0	0.0	0	0	0	0	</

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Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
10	10	00	2	0	0	0	
20	10	20	0	0	0	0	
30	10	30	0	0	0	0	
40	10	40	0	0	0	0	
50	10	50	0	0	0	0	
60	10	60	0	0	0	0	
70	10	70	0	0	0	0	
80	10	80	0	0	0	0	
90	10	90	0	0	0	0	
100	10	00	0	0	0	0	
110	10	10	0	0	0	0	
120	10	20	0	0	0	0	
130	10	30	0	0	0	0	
140	10	40	0	0	0	0	
150	10	50	0	0	0	0	
160	10	60	0	0	0	0	
170	10	70	0	0	0	0	
180	10	80	0	0	0	0	
190	10	90	0	0	0	0	
200	10	00	0	0	0	0	
210	10	10	0	0	0	0	
220	10	20	0	0	0	0	
230	10	30	0	0	0	0	
240	10	40	0	0	0	0	
250	10	50	0	0	0	0	
260	10	60	0	0	0	0	
270	10	70	0	0	0	0	
280	10	80	0	0	0	0	
290	10	90	0	0	0	0	
300	10	00	0	0	0	0	
310	10	10	0	0	0	0	
320	10	20	0	0	0	0	
330	10	30	0	0	0	0	
340	10	40	0	0	0	0	
350	10	50	0	0	0	0	
360	10	60	0	0	0	0	
370	10	70	0	0	0	0	
380	10	80	0	0	0	0	
390	10	90	0	0	0	0	
400	10	00	0	0	0	0	
410	10	10	0	0	0	0	
420	10	20	0	0	0	0	
430	10	30	0	0	0	0	
440	10	40	0	0	0	0	
450	10	50	0	0	0	0	
460	10	60	0	0	0	0	
470	10	70	0	0	0	0	
480	10	80	0	0	0	0	
490	10	90	0	0	0	0	
500	10	00	0	0	0	0	
510	10	10	0	0	0	0	
520	10	20	0	0	0	0	
530	10	30	0	0	0	0	
540	10	40	0	0	0	0	
550	10	50	0	0	0	0	
560	10	60	0	0	0	0	
570	10	70	0	0	0	0	
580	10	80	0	0	0	0	
590	10	90	0	0	0	0	
600	10	00	0	0	0	0	
610	10	10	0	0	0	0	
620	10	20	0	0	0	0	
630	10	30	0	0	0	0	
640	10	40	0	0	0	0	
650	10	50	0	0	0	0	
660	10	60	0	0	0	0	
670	10	70	0	0	0	0	
680	10	80	0	0	0	0	
690	10	90	0	0	0	0	
700	10	00	0	0	0	0	
710	10	10	0	0	0	0	
720	10	20	0	0	0	0	
730	10	30	0	0	0	0	
740							

Printed on:
~AUTODATE

Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
10	10	00	2	0	0	0	
20	10	20	0	0	0	0	
30	10	30	0	0	0	0	
40	10	40	0	0	0	0	
50	10	50	0	0	0	0	
60	10	60	0	0	0	0	
70	10	70	0	0	0	0	
80	10	80	0	0	0	0	
90	10	90	0	0	0	0	
100	10	00	0	0	0	0	
110	10	10	0	0	0	0	
120	10	20	0	0	0	0	
130	10	30	0	0	0	0	
140	10	40	0	0	0	0	
150	10	50	0	0	0	0	
160	10	60	0	0	0	0	
170	10	70	0	0	0	0	
180	10	80	0	0	0	0	
190	10	90	0	0	0	0	
200	10	00	0	0	0	0	
210	10	10	0	0	0	0	
220	10	20	0	0	0	0	
230	10	30	0	0	0	0	
240	10	40	0	0	0	0	
250	10	50	0	0	0	0	
260	10	60	0	0	0	0	
270	10	70	0	0	0	0	
280	10	80	0	0	0	0	
290	10	90	0	0	0	0	
300	10	00	0	0	0	0	
310	10	10	0	0	0	0	
320	10	20	0	0	0	0	
330	10	30	0	0	0	0	
340	10	40	0	0	0	0	
350	10	50	0	0	0	0	
360	10	60	0	0	0	0	
370	10	70	0	0	0	0	
380	10	80	0	0	0	0	
390	10	90	0	0	0	0	
400	10	00	0	0	0	0	
410	10	10	0	0	0	0	
420	10	20	0	0	0	0	
430	10	30	0	0	0	0	
440	10	40	0	0	0	0	
450	10	50	0	0	0	0	
460	10	60	0	0	0	0	
470	10	70	0	0	0	0	
480	10	80	0	0	0	0	
490	10	90	0	0	0	0	
500	10	00	0	0	0	0	
510	10	10	0	0	0	0	
520	10	20	0	0	0	0	
530	10	30	0	0	0	0	
540	10	40	0	0	0	0	
550	10	50	0	0	0	0	
560	10	60	0	0	0	0	
570	10	70	0	0	0	0	
580	10	80	0	0	0	0	
590	10	90	0	0	0	0	
600	10	00	0	0	0	0	
610	10	10	0	0	0	0	
620	10	20	0	0	0	0	
630	10	30	0	0	0	0	
640	10	40	0	0	0	0	
650	10	50	0	0	0	0	
660	10	60	0	0	0	0	
670	10	70	0	0	0	0	
680	10	80	0	0	0	0	
690	10	90	0	0	0	0	
700	10	00	0	0	0	0	
710	10	10	0	0	0	0	
720	10	20	0	0	0	0	
730	10	30	0	0	0	0	
740							

Printed on:
~AUTODATE

Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
01	1.0	0.0	2	0	0	0	
02	1.0	0.0	0	0	0	0	
03	1.0	0.0	0	0	0	0	
04	1.0	0.0	0	0	0	0	
05	1.0	0.0	0	0	0	0	
06	1.0	0.0	0	0	0	0	
07	1.0	0.0	0	0	0	0	
08	1.0	0.0	0	0	0	0	
09	1.0	0.0	0	0	0	0	
10	1.0	0.0	0	0	0	0	
11	1.0	0.0	0	0	0	0	
12	1.0	0.0	0	0	0	0	
13	1.0	0.0	0	0	0	0	
14	1.0	0.0	0	0	0	0	
15	1.0	0.0	0	0	0	0	
16	1.0	0.0	0	0	0	0	
17	1.0	0.0	0	0	0	0	
18	1.0	0.0	0	0	0	0	
19	1.0	0.0	0	0	0	0	
20	1.0	0.0	0	0	0	0	
21	1.0	0.0	0	0	0	0	
22	1.0	0.0	0	0	0	0	
23	1.0	0.0	0	0	0	0	
24	1.0	0.0	0	0	0	0	
25	1.0	0.0	0	0	0	0	
26	1.0	0.0	0	0	0	0	
27	1.0	0.0	0	0	0	0	
28	1.0	0.0	0	0	0	0	
29	1.0	0.0	0	0	0	0	
30	1.0	0.0	0	0	0	0	
31	1.0	0.0	0	0	0	0	
32	1.0	0.0	0	0	0	0	
33	1.0	0.0	0	0	0	0	
34	1.0	0.0	0	0	0	0	
35	1.0	0.0	0	0	0	0	
36	1.0	0.0	0	0	0	0	
37	1.0	0.0	0	0	0	0	
38	1.0	0.0	0	0	0	0	
39	1.0	0.0	0	0	0	0	
40	1.0	0.0	0	0	0	0	
41	1.0	0.0	0	0	0	0	
42	1.0	0.0	0	0	0	0	
43	1.0	0.0	0	0	0	0	
44	1.0	0.0	0	0	0	0	
45	1.0	0.0	0	0	0	0	
46	1.0	0.0	0	0	0	0	
47	1.0	0.0	0	0	0	0	
48	1.0	0.0	0	0	0	0	
49	1.0	0.0	0	0	0	0	
50	1.0	0.0	0	0	0	0	
51	1.0	0.0	0	0	0	0	
52	1.0	0.0	0	0	0	0	
53	1.0	0.0	0	0	0	0	
54	1.0	0.0	0	0	0	0	
55	1.0	0.0	0	0	0	0	
56	1.0	0.0	0	0	0	0	
57	1.0	0.0	0	0	0	0	
58	1.0	0.0	0	0	0	0	
59	1.0	0.0	0	0	0	0	
60	1.0	0.0	0	0	0	0	
61	1.0	0.0	0	0	0	0	
62	1.0	0.0	0	0	0	0	
63	1.0	0.0	0	0	0	0	
64	1.0	0.0	0	0	0	0	
65	1.0	0.0	0	0	0	0	
66	1.0	0.0	0	0	0	0	
67	1.0	0.0	0	0	0	0	
68	1.0	0.0	0	0	0	0	
69	1.0	0.0	0	0	0	0	
70	1.0	0.0	0	0	0	0	
71	1.0	0.0	0	0	0	0	
72	1.0	0.0	0	0	0	0	

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Date:	Reason for Revision:	Eng:	Log #:
21-Jun-01	Copied entire process from VAXcamps #384872	RLJ	304220
27-Aug-01	4.5 to 5.5 lb trigger pull was 4 to 5 pounds.	RLJ	305059
8-Sep-01	Added muzzle re-chamfering instructions & tools at target	RLJ	305064
12-Oct-01	Replaced Fl721 Doc Envelope Assy with 3309 Instruction Book.	RLJ	305075
21-Jan-02	Added new SKU 27465 "2002 Limited Run" - 308 Win VLS	RJL	305788
4-Apr-02	Trigger pull 4.5 to 6.5 was 4.5 to 5.5	RLJ	305777
5-Apr-02	Changed stock used on SKU 27448 & 27450 to 201839 Black Laminate (was Brown Laminate)	RJL	306361
20-May-02	Corrected ammo. usage for 700-06 cal. RAMAC's	RFL	305783
19-Jun-02	OP#640- STAMP DATE CODE ON BARREL AT LEFT-REAR OF BARREL, JUST AHEAD OF RECEIVER. (PASSED GUNS) WAS "STAMP FINAL INSPECTION AND CODE MARKS" IN TWO PLACES - REMOVE "a. Apply sticker to Gun Tag" - ADD C-47444 - DRAWING LISTING DATE CODE STAMPS	GLC	307056
9-Nov-02	Changed Test Ammo to 100 GR. (29051) From 80 GR (28533) PSP	ERF	307625
28-Apr-03	Updated to current practice (details only) Updated Description in op. 440 & 585 (Router)	ERF	307607
28-May-03	ADD RAMAC#27445 - 700 VLS - 223 REM BROWN LAM STK W/THUMBHOLE (NO FLUTES) ADD RAMAC#27447 - 700 VLS - 22-250 REM BROWN LAM STK W/THUMBHOLE (NO FLUTES)	GLC	309589
17-Sep-03	RAMAC#27445 & 27447 - RF-CF Carton PT#1651 WAS 1499 & Front Guard Screw PT#106293 WAS 106291	GLC	310440
22-Dec-03	ADDED RAMAC 27467 - 700 VLS 204 RUGER; REMOVED #3487 "BUILD TO TAG" FROM ALL B.O.M.'S;	JLP	310634

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Date:	Reason for Revision:	Eng:	Log #:
9-Mar-04	Details only - Added details (204 Ruger) to op. 400 Heading Plugs, Heading Reamer - op.606 Close Hard Plug, Ammo Type - op. 650 Heading Plugs.	ERF	308018
15-Apr-04	Removed Detail 14 from op. 585 (Assembler Stamp on bbl.)	ERF	308023
10-May-04	Updated to current practice (Details Only)	ERF	311618
8-Jun-04	ADD RAMAC#27443 - 700 VLS - 204 ROGER BROWN LAM STK W/THUMBHOLE (NO FLUTES)	GLC	311920
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 ops 585, 640. Added operation 600R for special slave bolt proof procedure.	RLJ	310367
9-Jul-04	Replaced ISS Firing Pin Assy with Non-ISS Fluted Firing Pin Assy. 109576 now 305631, 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 301049, removed ISS Gunlock keys (2) 201207, removed procedure for checking gunlock function and added 35 in-lb spec for take-down screw.	RLJ	311858
23-Aug-04	RAMAC#27486 - Trigger Guard Assy PT#202286 WAS 26370 RAMAC#27490 - Trigger Guard Assy PT#202286 WAS 26370 RAMAC#27488 - Trigger Guard Assy PT#202286 WAS 26370 RAMAC#27494 - Trigger Guard Assy PT#202286 WAS 26370 RAMAC#27492 - Trigger Guard Assy PT#202286 WAS 26370 RAMAC#27496 - Trigger Guard Assy PT#202286 WAS 26370 RAMAC#27498 - Trigger Guard Assy PT#202286 WAS 26370 RAMAC#27467 - Trigger Guard Assy PT#202286 WAS 26370 RAMAC#27491 - Trigger Guard Assy PT#202286 WAS 26370 RAMAC#27489 - Trigger Guard Assy PT#202286 WAS 26370	GLC	312578

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Date:	Reason for Revision:	Eng:	Log #:
	RAMAC#27495 - Trigger Guard Assy PT#202286 WAS 26370		
	RAMAC#27493 - Trigger Guard Assy PT#202286 WAS 26370		
	RAMAC#27487 - Trigger Guard Assy PT#202286 WAS 26370		
	RAMAC#27497 - Trigger Guard Assy PT#202286 WAS 26370		
	RAMAC#27499 - Trigger Guard Assy PT#202286 WAS 26370		
13-Oct-04	MOVE RAMAC#27493 & 27495 FROM OP#606 TO 610 INCREASE THE TEST AMMO QUANTITIES TO 12 FROM 3.5 FOR THE SAME RAMACS	GLC	312843
14-Oct-04	RAMAC #27494 & 27495 ADDED TARGET AMMO PT#21319	AJL	312654
4-Nov-04	OP#400, 405, & 650 - UPDATE INFO AND REESTABLISH LINKS FOR HEADING PLUGS	GLC	313042
18-Nov-04	ADD OP#395 FOR ALL PART #'S REMOVE INSPECTION INFO FROM OP#400 & 405	GLC	313275
5-Jan-05	OP 580 585 640 648 added pull scale verification process	DWB	313534
19-Jan-05	RAMAC #27486 - BOLT ASSY PT#99166 WAS 28710 & FIRING PIN ASSY PT#305637 WAS 305631 RAMAC #27490 - BOLT ASSY PT#99166 WAS 28710 & FIRING PIN ASSY PT#305637 WAS 305631 RAMAC #27488 - BOLT ASSY PT#98079 WAS 28711 & FIRING PIN ASSY PT#305637 WAS 305631 RAMAC #27494 - BOLT ASSY PT#98079 WAS 28711 & FIRING PIN ASSY PT#305637 WAS 305631 RAMAC #27492 - BOLT ASSY PT#98079 WAS 28711 & FIRING PIN ASSY PT#305637 WAS 305631 RAMAC #27496 - BOLT ASSY PT#98079 WAS 28711 & FIRING PIN ASSY PT#305637 WAS 305631 RAMAC #27498 - BOLT ASSY PT#98079 WAS 28711 & FIRING PIN ASSY PT#305637 WAS 305631 RAMAC #27467 - BOLT ASSY PT#99166 WAS 28710 & FIRING PIN ASSY PT#305637 WAS 305631 RAMAC #27491 - BOLT ASSY PT#99166 WAS 28710 & FIRING PIN ASSY PT#305637 WAS 305631 RAMAC #27489 - BOLT ASSY PT#98079 WAS 28711 & FIRING PIN ASSY PT#305637 WAS 305631 RAMAC #27495 - BOLT ASSY PT#98079 WAS 28711 & FIRING PIN ASSY PT#305637 WAS 305631 RAMAC #27493 - BOLT ASSY PT#98079 WAS 28711 & FIRING PIN ASSY PT#305637 WAS 305631 RAMAC #27490 - BOLT ASSY PT#98079 WAS 28711 & FIRING PIN ASSY PT#305637 WAS 305631	GLC	313628

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Date:	Reason for Revision:	Eng:	Log #:
	RAMAC #27499 - BOLT ASSY PT#98079 WAS 28711 & FIRING PIN ASSY PT#305637 WAS 305631		
	RAMAC #27487 - BOLT ASSY PT#98079 WAS 28711 & FIRING PIN ASSY PT#305637 WAS 305631		
14-Mar-05	RAMAC#27443 - RF-CF Carton PT#1688 WAS 1651 RAMAC#27445 - RF-CF Carton PT#1688 WAS 1651 RAMAC#27447 - RF-CF Carton PT#1688 WAS 1651	GLC	314150
13-Apr-05	Added To Op.585 Floor Plate Insert PT. # 98980 Ramac 27467 Changed ammo to 29218	ERF	311635
27-May-05	Ramac 27493 Op. 610 Changed # of rounds to 10 from 12 - Ramac 27495 removed ammo 27802 - changed ammo (21319) number of rounds to 10 from 12	ERF	314660
29-Sep-05	Eliminated test from BOM for SKU's 27493 and 27495. These guns are targeted 100% so the first 2 master rounds act as the test rounds. Test rounds were 20951 and 27802.	RJO	314951

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

[illegible]

PROCESS CONTROL INSPECTION RECORD				Revision Date: 7-Jun-05		Inspected by:																												
THIS RECORD MUST REMAIN IN HEAT TREAT INSPECTION FOR ONE YEAR				Part No:		Production Order #:																												
				Prod. Qty:																														
Part Name: Fin Assy 700 VLS		Centerfire Rifle																																
Operation No: Part No:		Operation: Part Name:		Work Center:		Inspec. Date: 8/14/2006																												
Furnace and Load Number	Draw Temp	Furnace Date	Hardness Specification		Hardness Specification		Hardness Specification		Break Test																									
			HRC	INSPECT REJECT	H15n	INSPECT REJECT	H45n	INSPECT REJECT	INSPECT	REJECT																								
HRC	Tester No	H15n	Tester No	H15n	Tester No	H45n	Tester No	Break Test Results (lbs)																										
35		60		81		37																												
36		61		82		38																												
37		62		83		39																												
38		63		84		40																												
39		64		85		41																												
40		65		86		42																												
41		66		87		43																												
42		67		88		44																												
43		68		89		45																												
44		69		90		46																												
45		70		91		47		Sample Plan <table border="1"> <thead> <tr> <th>Lot Size</th> <th>Sample Size</th> <th>Allowable Outside</th> </tr> </thead> <tbody> <tr><td>1-5</td><td>All</td><td>0</td></tr> <tr><td>6 - 50</td><td>6</td><td>0</td></tr> <tr><td>51 - 100</td><td>7</td><td>0</td></tr> <tr><td>101 - 200</td><td>7</td><td>0</td></tr> <tr><td>201 - 800</td><td>16</td><td>1</td></tr> <tr><td>801 - 3000</td><td>17</td><td>1</td></tr> <tr><td>3001 - 20000</td><td>27</td><td>2</td></tr> </tbody> </table>			Lot Size	Sample Size	Allowable Outside	1-5	All	0	6 - 50	6	0	51 - 100	7	0	101 - 200	7	0	201 - 800	16	1	801 - 3000	17	1	3001 - 20000	27	2
Lot Size	Sample Size	Allowable Outside																																
1-5	All	0																																
6 - 50	6	0																																
51 - 100	7	0																																
101 - 200	7	0																																
201 - 800	16	1																																
801 - 3000	17	1																																
3001 - 20000	27	2																																
46		71		92		48																												
47		72		93		49																												
48		73		94		50																												
49		74		95		51																												
50		75		96		52																												
51		76		97		53																												
52		77		98		54																												
53		78		99		55																												
54		79		100		56																												

85	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