

Remington Arms Company, Inc.
Manufacturing Process Document

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

Effective Date: 7-Sep-05
Origination Date: 7-Aug-93

General Instructions:

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

Process Routing Table:

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

INSPECT COMPONENTS BEFORE HEADING
Fit and Head Bolt Assembly to Barrel Assembly
Fit and Head Bolt Assembly to Barrel Assembly
Chamber to Length (Magnums)
Ream Chamber to Deburr
Make Chamber Cast (Not Done on 100% of Product)
Ream Ejector Hole
Form Radius on Edge of Firing Pin Hole
Assemble Riveted Extractor to Bolt - (MAGNUMS)
Assemble Rivetless Extractor to Bolt
Assemble to Bolt with Ejector Cross Pin
Strip Defective Barrel Assembly Complete
Strip Defective Bolt
Assemble Action
to Trigger Guard
Proof Test
Proof Test with slave bolt
Proof Stamp, Prick Punch and Obstruction In
Test and Target
Test and Target 100%
Inspect For Live Ammunition
Final Inspection
Reset trigger pull within specs as needed - not do
Inspect Heading and Sear Lift
Number Using Dot Peen Marking Machine
To Warehouse

Printed on:
~AUTODATE

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

CONFIDENTIAL

Printed on:
~AUTODATE

CONFIDENTIAL

Printed on:
~AUTODATE

CONFIDENTIAL

Printed on:
~AUTODATE

CONFIDENTIAL

Printed on:
~AUTODATE

CONFIDENTIAL

Printed on:
~AUTODATE

CONFIDENTIAL

Printed on:
~AUTODATE

CONFIDENTIAL

Printed on:
~AUTODATE

Printed on:
~AUTODATE

PROCESS CONTROL INSPECTION RECORD THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES			Revision Date: 7-Sep-05			Processed by:	
Part No:	Part Name: Fin Assy 700 SS Var	Centerfire Rifle				Date: 8/14/2006	
Operation No: (Enter Oper #)		Operation: (Enter the Operation Name in this field)				Work Center:	
Prod. Qty:	Prod. Order #:	Operator			Setup inspected by & Date:		
Gage Description and Characteristic	Gage Number	Gage Frequency	1st Shift	2nd Shift	3rd Shift	Remarks, Causes, Action Taken, Etc.	
VISUAL	VISUAL	100%	INSPECT REJECT				

[illegible][illegible][illegible]

CONFIDENTIAL

Printed on:
~AUTODATE

Printed on:
~AUTODATE

395

INSPECT COMPONENTS BEFORE HEADING

1 Pick Bolt Assembly and Wash

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

a 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

Printed on:
~AUTODATE

- a Good finish & color, marks slight, no tears
 - b No sharp edges at Ejection Port or any exposed edges (Which might cause finger injury)
 - 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-Sep-05		Processed by:	
Part No:		Part Name: Fin Assy 700 SS Var		Centerfire Rifle		Date: 8/14/2005	
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			

Printed on:
~AUTODATE

Pieces Run:

Remington Arms Company, Inc. — Ilion, New York

CONFIDENTIAL

Printed on:
~AUTODATE

Printed on:
~AUTODATE

400 Fit and Head Bolt Assembly to Barrel Assembly

Operation Step Detail Operation: 400

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

Step Operation / Step Description

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

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

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.

Printed on:
~AUTODATE

- d. Dip reamer into LB2000 Accu-Lube (note: thick blue liquid).
- e. Insert reamer shank through barrel so pilot is inside barrel bore. Move barrel and reamer together and engage reamer shank into quick release chuck. Make sure barrel chamber is positioned such that it is not being cut by reamer yet.
- 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.

Printed on:
~AUTODATE

Operation Tool Detail

Operation: 400

Tool Number	Tooling Description
F-76039	Machine
D-46967	Fixture
STD	LB2000 ACCU-LOOSE
STD	STEELGARD 1201-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

Printed on:
~AUTODATE

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

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

STD Caliber - 260 REM
D-49577-W REAMER
A-41281 COLLAR
B-90098-R SHANK

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

PROCESS CONTROL INSPECTION RECORD THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES			Revision Date: 7-Sep-05		Processed by:
Part No:	Part Name: Fin Assy 700 SS Var		Centerfire Rifle		Date: 8/14/2006
Operation No: 400	Operation: Fit and Head Bolt Assembly to Barrel Assembly				Work Center:
Prod. Qty:	Prod. Order #:	Operator		Setup inspected by & Date:	
Gage Description and Characteristic	Gage Number	Gage Frequency	1st Shift	2nd Shift	3rd Shift
Remarks, Causes, Action Taken, Etc.					

Printed on:
~AUTODATE

			INSPECT			
VISUAL	VISUAL	100%	REJECT INSPECT			
308 W/IN MIN Heading Plug	C-41556-A	100%	REJECT INSPECT			
308 W/IN WMAX Heading Plug	C-41556-B	100%	REJECT INSPECT			
308 W/IN MIN Heading Plug	C-41556-A	100%	REJECT INSPECT			
308 W/IN WMAX Heading Plug	C-41556-B	100%	REJECT INSPECT			
25-06 REM MIN Heading Plug	C-41560-A	100%	REJECT INSPECT			
25-06 REM WMAX Heading Plug	C-41560-B	100%	REJECT INSPECT			
			REJECT INSPECT			
			REJECT INSPECT			
			REJECT INSPECT			
			REJECT INSPECT			
			REJECT INSPECT			
			REJECT			

[illegible][illegible]

CONFIDENTIAL

Printed on:
~AUTODATE

CONFIDENTIAL

Printed on:
~AUTODATE

CONFIDENTIAL

Printed on:
~AUTODATE

CONFIDENTIAL

Printed on:
~AUTODATE

Printed on:
~AUTODATE

26209

26209

29747

29747

26199

26199

Printed on:
~AUTODATE

405 Fit and Head Bolt Assembly to Barrel Assembly

Operation Step Detail Operation: 405

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

Step Operation / Step Description

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

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

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.

Printed on:
~AUTODATE

- d. Dip reamer into LB2000 Accu-Lube (note: thick blue liquid).
- e. Insert reamer shank through barrel so pilot is inside barrel bore. Move barrel and reamer together and engage reamer shank into quick release chuck. Make sure barrel chamber is positioned such that it is not being cut by reamer yet.
- f. Insert bolt and close slowly as reamer cuts barrel material. Do NOT force bolt closed if reamer is cutting hard. Cutting action should be smooth. If cut is difficult, remove and inspect reamer for problems. (NOTE: THESE CALIBERS NEED TO BE REAMED SLOWLY TO ENSURE REAMER IS NOT BROKEN FREE OF SHANK AND SHANK IS NOT FORCED TO TWIST AND BREAK !!!)
- g. After cutting is completed remove bolt.
- h. Remove reamer and rinse in tank with water and STEELGARD 1301-NL mixture. (note: mixture should have a milky consistency. If mixture looks too thin, add STEELGARD 1301-NL.) All metal chips must be rinsed from reamer. Inspect reamer condition.
- i. Unclamp barrel assembly and rinse in tank with water and STEELGARD 1301-NL mixture to remove any metal chips and to protect newly exposed metal surfaces. Inspect barrel chamber condition.
- j. Replace bolt assembly in barrel assembly and insert appropriate minimum shoulder plug. Bolt should close smoothly. Open bolt and remove minimum shoulder plug.
- k. Insert appropriate maximum shoulder plug. Bolt should not close with maximum shoulder plug in chamber. Open bolt and remove maximum shoulder plug.
- l. If all tests are acceptable close bolt and place barrel assembly

Printed on:
~AUTODATE

on truck.

Operation Tool Detail

Operation: 405

Tool Number	Tagging Description
F-76039	Machine
D-46967	Fixture
STD	ACCU-LUBE 2000
STD	STEELGARD 1301-NL
STD	Caliber - 6MM REM
D-49577-B	REAMER (replaces B-54694)
A-41281	COLLAR
B-90098-R	SHANK
STD	Caliber - 22-250
D-49577-G	REAMER (replaces B-87513)
A-41281	COLLAR
B-90098-S	SHANK
STD	Caliber - 220 SWIFT
D-49577-H	REAMER (replaces B-49136)
A-41139	COLLAR
B-90098-S	SHANK
STD	Caliber - 223 REM
D-49577-K	REAMER (replaces B-54136-S)

Printed on:
~AUTODATE

A-41139 COLLAR
B-90098-S SHANK
STD Caliber - 243 WIN
D-49577-L REAMER (replaces B-83304)
A-41281 COLLAR
B-90098-R SHANK

C-41185-A 17 REM MIN Heading Plug
C-41185-B 17 REM WMAX Heading Plug
C-53322-A 204 RUGER MIN Heading Plug
C-53322-B 204 RUGER WMAX Heading Plug
C-41192-A 220 SWIFT MIN Heading Plug
C-41192-B 220 SWIFT WMAX Heading Plug
C-85239-A 221 F-BALL MIN Heading Plug
C-85239-B 221 F-BALL WMAX Heading Plug
C-41521-A 22-250 MIN Heading Plug
C-41521-B 22-250 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

PROCESS CONTROL INSPECTION RECORD			Revision Date:		7-Sep-05		Processed by:	
THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES								
Part No:		Part Name: Fin Assy 700 SS Var		Centerfire Rifle			Date: 8/14/2006	
Operation No: 405		Operation: Fit and Head Bolt Assembly to Barrel Assembly					Work Center:	
Prod. Qty:		Prod. Order #:		Operator		Setup Inspected by & Date:		
Gage Description and Characteristic		Gage Number	Gage Frequency	1st Shift	2nd Shift	3rd Shift	Remarks, Causes, Action Taken, Etc.	

Printed on:
~AUTODATE

			INSPECT			
VISUAL	VISUAL	100%	REJECT INSPECT			
17 REM MIN Heading Plug	C-41185-A	100%	REJECT INSPECT			
17 REM WMAX Heading Plug	C-41185-B	100%	REJECT INSPECT			
22-250 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			
220 SWIFT MIN Heading Plug	C-41192-A	100%	REJECT INSPECT			
220 SWIFT WMAX Heading Plug	C-41192-B	100%	REJECT INSPECT			
220 SWIFT MIN Heading Plug	C-41192-A	100%	REJECT INSPECT			
220 SWIFT WMAX Heading Plug	C-41192-B	100%	REJECT INSPECT			
223 REM MIN Heading Plug	C-41155-A	100%	REJECT			

Printed on:
~AUTODATE

223 REM VMAX Heading Flag	C. 24150.2	100%	INSPECT REJECT INSPECT		
			REJECT INSPECT		
			REJECT INSPECT		
			REJECT INSPECT		
			REJECT		
Pieces Run:			Remington Arms Company, Inc. -- Ilion, New York		

CONFIDENTIAL

Printed on:
~AUTODATE

CONFIDENTIAL

Printed on:
~AUTODATE

CONFIDENTIAL

Printed on:
~AUTODATE

Printed on:
~AUTODATE

Printed on:
~AUTODATE

29719

29719

26207

26207

29743

29743

26205

26205

29741

29741

29745

CONFIDENTIAL

Printed on:
~AUTODATE

29745

Printed on:
~AUTODATE

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

Operation Step Detail Operation: 415

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

Step Operation / Step Description

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

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

Fit bolt assembly to barrel assembly.

- a. Remove bolt assembly from barrel assembly.
- b. Clamp barrel assembly in fixture.
- c. Inspect shoulder reamer condition, no chipped cutting surfaces,
no metal chips packed in flutes. Make sure reamer is correct for
caliber being manufactured. Check spacer collars for size and
tightness.

Printed on:
~AUTODATE

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

Printed on:
~AUTODATE

- no metal chips packed in flutes. Make sure reamer is correct for caliber being manufactured.
- n. Dip belt reamer into LB2000 Accu-Lube (note: thick blue liquid).
 - o. Insert belt reamer shank through barrel so pilot is inside barrel bore. Move barrel and reamer together and engage reamer shank into quick release chuck. Make sure barrel chamber is positioned such that it is not being cut by reamer yet.
 - p. Insert bolt and close slowly as reamer cuts barrel material. Do NOT force bolt closed if reamer is cutting hard. Cutting action should be smooth. If cut is difficult, remove and inspect reamer for problems.
 - q. After cutting is completed remove bolt.
 - r. Remove reamer and rinse in tank with water and STEELGARD 1301-NL mixture. (note: mixture should have a milky consistency. If mixture looks too thin, add STEELGARD 1301-NL.) All metal chips must be rinsed from reamer. Inspect reamer condition.
 - s. Unclamp barrel assembly and rinse in tank with water and STEELGARD 1301-NL mixture to remove any metal chips and to protect newly exposed metal surfaces. Inspect barrel belt condition.
 - t. Replace bolt assembly in barrel assembly and insert appropriate minimum belt plug. Bolt should close smoothly. Open bolt and remove minimum belt plug.
 - u. Insert appropriate maximum belt plug. Bolt should not close with maximum belt plug in chamber. Open bolt and remove maximum belt plug.
 - v. If all tests are acceptable close bolt and place barrel assembly

Printed on:
~AUTODATE

on truck.

Operation Tool Detail

Operation: 415

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

Printed on:
~AUTODATE

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

STD 338 Win Mag.

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

STD 300 WBY Mag.

C-48291 REAMER - SHOULDER
A-41281 COLLAR
B-90098-W SHANK
B-53328-W REAMER - FACE
B-53328-V BELT CUTTER
B-53328-H CHAMBER GUIDE BUSHING

STD 7MM WBY Mag.

C-48591 REAMER - SHOULDER
A-41281 COLLAR
B-90098-V SHANK
B-53328-P REAMER - FACE
B-53328-V BELT CUTTER
B-53328-G CHAMBER GUIDE BUSHING

STD. 375 H&H MAG

Printed on:
~AUTODATE

C-49820-L COMBINATION SHOULDER & BELT REAMER
B-49820-Z BELT CUTTER (FITS ON C-49820-L)
C-49820,DE LOCK SCREW
C-49820-F SHIM, 0.001 THICK
C-49820-G SHIM, 0.005 THICK
C-49820-H SHIM, 0.010 THICK
C-49820-J SHIM, 0.030 THICK
C-49820-K SHIM, 0.100 THICK
B-90098-Q HEADING REAMER SHANK
A-41281 COLLAR

C-41561-A 7MM Mag MIN Heading Plug
C-41561-B 7MM Mag WMAX Heading Plug
C-83853-A 7MM Mag BELT - MIN Heading Plug
C-83853-B 7MM Mag BELT - WMAX Heading Plug
C-43099-A 7MM STW Mag BELT - MIN Heading Plug
C-43099-B 7MM STW Mag BELT - WMAX Heading Plug
C-41233-A 7MM STW Mag MIN Heading Plug
C-41233-B 7MM STW Mag WMAX Heading Plug
C-41546-A 300 Win MIN Heading Plug
C-41546-B 300 Win WMAX Heading Plug
C-83853-A 300 Win BELT - MIN Heading Plug
C-83853-B 300 Win BELT - WMAX Heading Plug
C-41578-A 300 WBY MIN Heading Plug
C-41578-B 300 WBY WMAX Heading Plug
C-83853-A 300 WBY BELT - MIN Heading Plug
C-83853-B 300 WBY BELT - WMAX Heading Plug

PROCESS CONTROL INSPECTION RECORD THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES		Revision Date: 7-Sep-05	Processed by:
Part No:	Part Name: Fin Assy 700 SS Var	Centerfire Rifle	Date: 8/14/2006
Operation No: 415	Operation: Fit and Head Bolt Assembly to Barrel Assy and Chamber to Length (Magnums)		Work Center:

Printed on:
~AUTODATE

Prod. Qty:	Prod. Order #:	Operator			Setup inspected by & Date:	
Gage Description and Characteristic	Gage Number	Gage Frequency	1st Shift	2nd Shift	3rd Shift	Remarks, Causes, Action Taken, Etc.
VISUAL	VISUAL	100%	INSPECT			
300 WBY BELT - MIN Heading Plug	C-83853-A	100%	REJECT INSPECT			
300 WBY BELT - WMAX Heading Plug	C-83853-B	100%	REJECT INSPECT			
300 WBY MIN Heading Plug	C-41578-A	100%	REJECT INSPECT			
300 WBY WMAX Heading Plug	C-41578-B	100%	REJECT INSPECT			
300 Win BELT - MIN Heading Plug	C-83853-A	100%	REJECT INSPECT			
300 Win BELT - WMAX Heading Plug	C-83853-B	100%	REJECT INSPECT			
300 Win MIN Heading Plug	C-41546-A	100%	REJECT INSPECT			
300 Win WMAX Heading Plug	C-41546-B	100%	REJECT INSPECT			
7MM STW Mag BELT - MIN Heading Plug	C-43099-A	100%	REJECT INSPECT			
7MM STW Mag BELT - WMAX Heading Plug	C-43099-B	100%	REJECT INSPECT			

Printed on:
~AUTODATE

7MM STW Mag MIN Heading Plug	C-41253-A	100%	INSPECT			
7MM STW Mag WMAX Heading Plug	C-41253-B	100%	REJECT INSPECT			
7MM Mag BELT - MIN Heading Plug	C-83853-A	100%	REJECT INSPECT			
7MM Mag BELT - WMAX Heading Plug	C-83853-B	100%	REJECT INSPECT			
7MM Mag MIN Heading Plug	C-41561-A	100%	REJECT INSPECT			
7MM Mag WMAX Heading Plug	C-41561-B	100%	REJECT INSPECT			
			REJECT INSPECT			
			REJECT INSPECT			
			REJECT INSPECT			
			REJECT INSPECT			
			REJECT INSPECT			
			REJECT INSPECT			
			REJECT			
Pieces Run:						Remington Arms Company, Inc. -- Ilion, New York

CONFIDENTIAL

Printed on:
~AUTODATE

CONFIDENTIAL

Printed on:
~AUTODATE

CONFIDENTIAL

Printed on:
~AUTODATE

CONFIDENTIAL

Printed on:
~AUTODATE

CONFIDENTIAL

Printed on:
~AUTODATE

CONFIDENTIAL

Printed on:
~AUTODATE

Printed on:
~AUTODATE

27504

27504

27504

27504

27508

27508

27508

27508

27502

27502

Printed on:
~AUTODATE

27502

27502

27506

27506

27506

27506

Printed on:
~AUTODATE

420 Ream Chamber to Deburr

Operation Step Detail Operation: 420

Step Operation / Step Description

Ream chamber to deburr

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

Operation Tool Detail Operation: 420

Tool Number Tooling Description

B-86064-C Burnish Tool-Shank Std.

[illegible]

[illegible]

Remington Arms Company, Inc. -- Ilion, New York

Pieces Run:

ILE00116639

CONFIDENTIAL

Printed on:
~AUTODATE

Printed on:
~AUTODATE

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.

~AUTODATE

[illegible]

[illegible][illegible]

CONFIDENTIAL

Printed on:
~AUTODATE

Printed on:
~AUTODATE

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

[illegible][illegible][illegible]

Printed on:
~AUTODATE

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

CONFIDENTIAL

Printed on:
~AUTODATE

Printed on:
~AUTODATE

431 Form Radius on Edge of Firing Pin Hole

Operation Step Detail Operation: 431

Step Operation / Step Description

Form Radius on Edge of Firing Pin Hole

Operation Tool Detail Operation: 431

Tool Number Tooling Description

A-38640 Punch

Std. Hammer

PROCESS CONTROL INSPECTION RECORD				Revision Date:		Processed by:	
THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES				7-Sep-05			
Part No:	Part Name: Fin Assy 700 SS Var		Centerfire Rifle		Date:		8/14/2006
Operation No: 431	Operation: Form Radius on Edge of Firing Pin Hole					Work Center:	
Prod. Qty:	Prod. Order #:	Operator			Setup inspected by & Date:		
Gage Description and Characteristic	Gage Number	Gage Frequency	1st Shift	2nd Shift	3rd Shift	Remarks, Causes, Action Taken, Etc.	

[illegible][illegible]

CONFIDENTIAL

Printed on:
~AUTODATE

Printed on:
~AUTODATE

432 Assemble Riveted Extractor to Bolt - (MAGNUMS)

Operation Step Detail Operation: 432

Step Operation / Step Description

Assemble Riveted Extractor to Bolt - (MAGNUMS)

PROCEDURE:

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

Printed on:
~AUTODATE

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

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

Operation Tool Detail

Operation: 432

Tool Number	Tooling Description
D-84993	Fixture
C-71477-W	Punch
STD	Hydraulic Press - Dennison
	Pressure Approx.- 2200 lbs.
	NOTE: Too Much Pressure Breaks Extractors Too Little makes a Poor Swage
TS-1764	.027 Deflection
STD	Dental Grinder
=====	=====
	MAX SHELL
B-84831-A	Small Rifle
B-84831-B	Large Rifle
B-84831-C	Belted Magnums

Printed on:
~AUTODATE

=====

TENSION

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

PROCESS CONTROL INSPECTION RECORD			Revision Date			7-Sep-05			Processed by:		
THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES											
Part No:		Part Name: Fin Assy 700 SS Var			Center fire Rifle			Date			8/14/2006
Operation No: 432		Operation: Assemble Riveted Extractor to Bolt - (MAGNUMS)							Work Center:		
Prod. Qty:		Prod. Order #:		Operator			Setup inspected by & Date:				
Gage Description and Characteristic		Gage Number	Gage Frequency	1st Shift	2nd Shift	3rd Shift	Remarks, Causes, Action Taken, Etc.				
VISUAL		VISUAL	100%	INSPECT	/	/					
				REJECT							
.027 Deflection		TS-1764	100%	INSPECT	/	/					
				REJECT							
Small Rifle		B-84831-A	100%	INSPECT	/	/					
				REJECT							
Large Rifle		B-84831-B	100%	INSPECT	/	/					
				REJECT							
Belted Magnums		B-84831-C	100%	INSPECT	/	/					
				REJECT							

Printed on:
~AUTODATE

Small Rifle	B-87034-A	100%	INSPECT		
Large Rifle	B-87034-C	100%	REJECT INSPECT		
Belted Magnums	B-87034-D	100%	REJECT INSPECT		
Swedish 6.5x55 1894 Classic	B-87034-E	100%	REJECT INSPECT		
			REJECT INSPECT		
			REJECT INSPECT		
			REJECT INSPECT		
Pieces Run:			Remington Arms Company, Inc. - Ilion, New York		

CONFIDENTIAL

Printed on:
~AUTODATE

Printed on:
~AUTODATE

435 Assemble Rivetless Extractor to Bolt

Operation Step Detail Operation: 435

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

Assemble Rivetless Extractor to Bolt	
--------------------------------------	--

- | | |
|---|---|
| 1 | Extractor Must Be Shaped to Bolt Thread 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 - .473
B-87034-E	EXTRACTOR TENSION PLUG GAGE - 6.5X55
B-87034-F	Min Tension Plug - .403 - 6.8MM REM SPC
B-84831-E	Max Tension Plug - .422 - 6.8MM REM SPC

Printed on:
~AUTODATE

PROCESS CONTROL INSPECTION RECORD THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES				Revision Date: 7-Sep-05		Processed by:
Part No:	Part Name:	Pin Assy 700 SS Var		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 - .473	B-84831-B	100%	REJECT INSPECT			
EXTRACTOR TENSION PLUG GAGE - 6.5X55	B-87034-E	100%	REJECT INSPECT			
			REJECT INSPECT			
			REJECT INSPECT			
			REJECT INSPECT			
			REJECT INSPECT			
			REJECT			

[illegible]

Remington Arms Company, Inc. -- Ilion, New York

Remington Arms Company, Inc. -- Ilion, New York

CONFIDENTIAL

Printed on:
~AUTODATE

Printed on:
~AUTODATE

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.)

Printed on:
~AUTODATE

A-48261
B-54504
C-53663

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

PROCESS CONTROL INSPECTION RECORD				Revision Date:		Processed by:
THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES				7-Sep-05		
Part No:	Part Name:		Centerfire Rifle			Date:
Operation No: 440	Operation:		Assemble Ejector to Ejector Spring and then			Work Center:
Prod. Qty:	Prod. Order #:	Operator			Setup Inspected by & Date:	
Gage Description and Characteristic	Gage Number	Gage Frequency	1st Shift	2nd Shift	3rd Shift	Remarks, Causes, Action Taken, Etc.
VISUAL	VISUAL	100%	INSPECT			
			REJECT INSPECT			
			REJECT INSPECT			
			REJECT INSPECT			
			REJECT INSPECT			
			REJECT INSPECT			
			REJECT INSPECT			
			REJECT INSPECT			
			REJECT INSPECT			

CONFIDENTIAL

Printed on:
~AUTODATE

Printed on:
~AUTODATE

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-Sep-05			Processed by:		
Part No:		Part Name: Fin Assy 700 SS Var		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 INSPECT				
				REJECT INSPECT				
				REJECT INSPECT				
				REJECT INSPECT				
				REJECT				

[illegible]

ILE00116666

ILE00116666

CONFIDENTIAL

Printed on:
~AUTODATE

Printed on:
~AUTODATE

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-Sep-05			
Part No:	Part Name: Fin Assy 700 SS Var		Centerfire Rifle		Date:	8/14/2005	
Operation No: 465R	Operation: Strip Defective Bolt					Work Center:	
Prod. Qty:	Prod. Order #:	Operator			Setup Inspected by & Date:		
Gage Description and Characteristic	Gage Number	Gage Frequency	1st Shift	2nd Shift	3rd Shift	Remarks, Causes, Action Taken, Etc.	
VISUAL	VISUAL	100%	INSPECT				
			REJECT INSPECT				
			REJECT INSPECT				
			REJECT INSPECT				
			REJECT				

[illegible][illegible]

Remington Arms Company, Inc. -- Ilion, New York

Pieces Run:

CONFIDENTIAL

Printed on:
~AUTODATE

Printed on:
~AUTODATE

580 Assemble Action

Operation Step Detail Operation: 580

Step Operation / Step Description

Assemble Action

PROCEDURE:

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

Printed on:
~AUTODATE

- 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

Printed on:
~AUTODATE

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

Printed on:
~AUTODATE

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

Perform Checks a. thru c. (3) Times

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

Try (3) Times

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

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

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

- 22 Close the Action and Lock Bolt Down

Operation Tool Detail

Operation: 580

Printed on:
~AUTODATE

Tool Number	Tooling Description
STD	Ratchet Screwdriver
A-88003	Taper Reamer for Braze in Firing Pin Hole
7237T1	Lube Brush (McMaster-Carr Tin-Ferrule, Natural Bristle Type Brush 5-3/4 O.A.L. 1/2W x 3/4L or Equivalent)
301467	Molykote GN Paste or Powder Lubricant
B-43447	Brass Wiping Rod
305787 VC-NYLTEX VINYL CAPS	
STD	Ball Handle Ratchet Screwdriver (McMaster Carr no. 6962A14 or Equivalent)
D-48553	Bolt Assembly tool
5/32" pt. dia.	Center Punch (Mc-Master Carr no.3417A1 or Equivalent)
STD	Hammer 8 oz. Set (Mc-Master Carr no. 5860A5 or Equivalent)
GAGES	
B-TS-7300	Dent & Scuff Template
B-80652	Fins Tight Tester
STD	Dummy Cartridge Rounds of Proper Caliber Being Built
B-70697	Trigger Pull Scales
STD	.006 Feeler Gage or Suitable Shim

Printed on:
~AUTODATE

C-47741 Sear Engagement Gage - Solid Bolt
D-44581 Sear Lift Dial Gage (.006 - .018)
B-52089 Firing Pin Protrusion Gage
A-43977 Trigger Guard Clearance Shim Tool (.030")

PROCESS CONTROL INSPECTION RECORD				Revision Date:		Processed by:
THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES				7-Sep-05		
Part No:	Part Name: Fin Assy 700 SS Var		Centerfire Rifle		Date:	8/14/2005
Operation No: 580	Operation: Assemble Action				Work Center:	
Prod. Qty:	Prod. Order #:	Operator			Setup inspected by & Date:	
Gage Description and Characteristic	Gage Number	Gage Frequency	1st Shift	2nd Shift	3rd Shift	Remarks: Causes, Action Taken, Etc.
VISUAL	VISUAL	100%	INSPECT			
Dent & Scuff Template	B-TS-7300	100%	REJECT INSPECT			
Pins Tight Tester	B-80652	100%	REJECT INSPECT			
Dummy Cartridge Rounds of Proper Caliber Being Built	STD	100%	REJECT INSPECT			
Trigger Pull Scales	B-70697	100%	REJECT INSPECT			
.006 Feeler Gage or Suitable Shim	STD	100%	REJECT			

Printed on:
~AUTODATE

Seal Engagement Gage Solid Bolt	C-43741	100%	INSPECT REJECT INSPECT		
Seal Lift Dial Gage (005 - 008)	B-44587	100%	REJECT INSPECT		
Firing Pin Protrusion Gage	B-52069	100%	REJECT INSPECT		
Trigger Guard Clearance Shim Tool (.030")	A-43877	100%	REJECT INSPECT		
			REJECT INSPECT		
Pieces Run:			REJECT		
Remington Arms Company, Inc. - Ilion, New York					

CONFIDENTIAL

Printed on:
~AUTODATE

Printed on:
~AUTODATE

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

Operation Step Detail Operation: 585

Step Operation / Step Description

Assemble Stock to Action

PROCEDURE:

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

Printed on:
~AUTODATE

2. Select Correct Magazine
 - a. Inspect for:
 - Color
 - No Rust
3. Assemble Magazine to Receiver
4. Position Stock on Action
5. Select Trigger Guard Assy
 - a. Inspect for:
 - No Sharp Edges
 - Color
 - Mairs
 - Pits
 - Position in Stock
6. Select Front, and Rear Trigger Guard Screws
 - a. Inspect for:
 - Color
 - Allen Head
 - Threads
 - Position in Holes
7. Assemble Floor Plate Assembly and Stock to Barrel Assembly Complete with Front and Rear Trigger Guard Screws.
 - Using Pneumatic Power Driver, or Ball Ratchet Screwdriver properly seated against the barrel bracket cut in the stock. (bbl. Assy. bracket to rear of barrel bracket cut in stock) First torque front take down screw - 35 IN*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
 - No Bad Chipping
 - Barrel Must Seat within 1.5" of Front of Stock

Printed on:
~AUTODATE

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

Shim Placement Procedure if Required;

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

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

8 Assemble Magazine Spring to Magazine Follower

Printed on:
~AUTODATE

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

- 11. Check Bolt
 - No Bind
 - Clears Stock

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

Try (3) Times

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

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

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

Printed on:
~AUTODATE

d. Adjust if Necessary

14 Make All Necessary Repairs from Test

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

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

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

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

Free float Barrel clearance:

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

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

A 1" wide by .020" thick plastic shim, inserted from above, between Barrel and fore-end, must fit easily at a depth of at least 1/8".

*Police: use a .025" shim.

16 Attach Hang Tag to Trigger Guard

Operation Tool Detail

Operation: 585

Printed on:
~AUTODATE

Tool Number	Tooling Description
STD	Ball Hatchet Screwdriver
45447	Brass Wiping Rod
B-70697	Trigger Pull Scale
B-TS-7300	Dent & Scuff Template

PROCESS CONTROL INSPECTION RECORD			Revision Date			7-Sep-05			Processed by:			
THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES												
Part No:		Part Name: Fin Assy 700 SS Var			Center fire Rifle			Date			8/14/2006	
Operation No: 585		Operation: Assemble Stock to Action & Attach Hang Tag								Work Center:		
Prod. Qty:		Prod. Order #:		Operator			Setup Inspected by & Date:					
Gage Description and Characteristic		Gage Number	Gage Frequency	1st Shift	2nd Shift	3rd Shift	Remarks, Causes, Action Taken, Etc.					
VISUAL		VISUAL	100%	INSPECT	/	/						
				REJECT								
Trigger Pull Scale		B-70697	100%	INSPECT	/	/						
				REJECT								
Dent & Scuff Template		B-TS-7300	100%	INSPECT	/	/						
				REJECT								
				INSPECT	/	/						
				REJECT								
				INSPECT	/	/						
				REJECT								

Printed on:
~AUTODATE~

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

Subject to Protective Order - Williams v. Remington

ILE00116685

CONFIDENTIAL

Printed on:
~AUTODATE

Printed on:
~AUTODATE

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.)

Printed on:
~AUTODATE

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

IV. DESCRIPTION AND SEQUENCE OF PROOF TEST

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

B. PROOF TEST

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

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

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

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

Printed on:
~AUTODATE

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

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

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

Printed on:
~AUTODATE

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

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

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

Printed on:
~AUTODATE

ACCEPTABLE PRODUCTS ONLY.

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

15. If gun fails proof test - enter gun information and reject code into computer. Attach reject ticket to gun.
16. Place gun back on truck.
17. Repeat test on next and succeeding guns.

V. INTERPRETATION OF PROOF TEST

A. PASS GUN

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

B. REJECT GUN

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

Printed on:
~AUTODATE

VI. SAFETY AFTER PROOF TEST

A. SAFETY

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

B. INSPECT CHAMBER AND MAGAZINE FOR LIVE AMMUNITION

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

C. VISUALLY INSPECT FOR MARRING BY DEVICE OR PORT

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

D. MOVE ENTIRE LOAD TO NEXT OPERATION

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

~AUTODATE

[illegible]

[illegible]

Printed on:
~AUTODATE

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

CONFIDENTIAL

Printed on:
~AUTODATE

Printed on:
~AUTODATE

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.

Williams v. Remington

turn rifle to gun truck and continue with succeeding rifles.

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

[illegible]

Remington Arms Company, Inc. -- Iliion, New York

ILE00116698

CONFIDENTIAL

Printed on:
~AUTODATE

CONFIDENTIAL

Printed on:
~AUTODATE

CONFIDENTIAL

Printed on:
~AUTODATE

CONFIDENTIAL

Printed on:
~AUTODATE

CONFIDENTIAL

Printed on:
~AUTODATE

Printed on:
~AUTODATE

PROCESS CONTROL INSPECTION RECORD THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES		Revision Date: 7-Sep-05	Processed by:
Part No:	Part Name: Fin Assy 700 SS Var	Centerfire Rifle	Date: 8/14/2006
Operation No: 600R	Operation: Proof Test with slave bolt		Work Center:

Printed on:
~AUTODATE~

Prod. Qty.	
Page Description and Unit Price	

Order - William

[illegible]

[illegible]

Pieces Run:

ILE00116706

CONFIDENTIAL

Printed on:
~AUTODATE

Printed on:
~AUTODATE

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

Operation Step Detail Operation: 605R

Step Operation / Step Description

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

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

[illegible][illegible][illegible][illegible]

CONFIDENTIAL

Printed on:
~AUTODATE

Printed on:
~AUTODATE

606 Test and Target

Operation Step Detail Operation: 606

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

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.

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

Gallery Test-Procedure and Specifications

Printed on:
~AUTODATE

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

Printed on:
~AUTODATE

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. 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.

Printed on:
~AUTODATE

3. With Safety in "S" or "on" position and the action closed, raise the bolt.
 - a. Bolt must raise or open without excessive force.
4. Close Bolt with safety in "S" or "on" position - pull trigger firmly.
 - a. Rifle must not fire.
5. With finger off Trigger-move safety to "F" or "OFF" position.
 - a. Rifle must not fire.
6. Open and close Bolt full stroke to cock firing pin.
7. Move Safety to full rear "S" or "ON" position and then move half way to the "F" or "OFF" position with thumb.
8. If safety stops at half-way position-pull trigger.
 - a. Rifle must not fire.
 - b. Safety must not move to full "OFF" 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.

Printed on:
~AUTODATE

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. 220 Swift	50 gr. PSP	4
2. 22-250 Rem.	55 gr. PSP	4
3. 223 Rem.	55 gr. PSP	5
4. 25.06 Rem.	100 gr. PSPCL	4
5. 7mm STW	140 gr. PSPCL	3
6. 7mm Rem. Mag.	140 gr. PSPCL	3
7. 308 Wir.	168 gr. BT HP MATCH	4
8. 300 Wir. Mag.	180 gr. PSPCL	3
9. 204 Ruger	32 gr. ACCUTIP V	5
10. 300 Wby. Mag.	180 gr. PSPCL	3
11. 17 Rem.	25 gr. HP	5
12. 221 Fireball	50 gr. ACCUTIP	5
13. 243 Wir.	80 gr. HPPL - 100 gr. PSPCL	4
14. 7mm08	140 gr. PSP	4
15. 6.8mm Rem.	115 gr. HP BT	4

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

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

15. Open Bolt full stroke to rear position.

Printed on:
~AUTODATE

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

Printed on:
~AUTODATE

- a. Adjust device if shots off paper or group too close to edge.
21. Operate action full cycle to extract, eject, and feed each shot.
 - a. Bolt should not pull out of receiver.
 - b. Case or shell must be retained by extractor until the case is ejected from receiver.
 - c. Case must be completely ejected from receiver, should not catch on receiver.
 - d. One fired case from each rifle must be visually inspected for firing pin indent and chamber marks reflected on case. Slight rings are permissible; if ring is large enough to pick with fingernail, reject the rifle.
22. Fire all rounds required for Test and Targeting.
 - a. For the Test procedure, each rifle is to have the first two (2) rounds fired and the remaining rounds cycled through but not fired.
 - b. For the Target procedure, all accuracy specifications are based on groups consisting of 3 to 5 shots, therefore, those rifles will typically require extra rounds to be loaded and shot singly. See chart below for acceptable group sizes.
23. Open guard. (If on accuracy device)
24. For the Targeted rifles (10% std. & 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.

Printed on:
~AUTODATE

GROUP SIZE SPECIFICATIONS

-----+
All VARMINT, BENCHRO, & POLICE:

CALIBER	AMMUNITION TYPE	MAX. GROUP CENTER TO CENTER 5 SHOT
1. 220 Swift	50 gr. PSP	1.5
2. 22-250 Rem.	55 gr. PSP	1.5
3. 223 Rem.	55 gr. PSP	1.5
4. 25.06 Rem.	100 gr. PSPCL	1.5
5. 7mm STW	140 gr. PSPCL	2.5
6. 7mm Rem. Mag.	140 gr. PSPCL	2.5
7. 308 Win.	168 gr. BT HP Match	1.5
8. 300 Win Mag	180 gr. PSPCL	2.5
9. 204 Ruger	32 gr. ACCUTIP V	1.5
10. 300 Wby. Mag.	180 gr. PSPCL	1.5
11. 17 Rem.	25 gr. HP	1.5
12. 221 Fireball	50 gr. Accutip	1.5
13. 243 Win.	80 gr.HPPL - 100 gr.PSPCL	1.5
14. 7mm08 Rem	140 gr.PSP	1.5
15. 6.8mm Rem.	115 gr.HP BT	1.5

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

26. Inspect chamber and magazine for live ammunition.

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

27. Pass all rifles that meet specifications for:

- a. Visual
- b. Functional

Printed on:
~AUTODATE

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%) 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%

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

Printed on:
~AUTODATE

shooting test. Repeat "B" for all rifles on truck at completion of test.

C. Visual Inspect for marring by device or port.

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

D. All rifles are moved to Ammunition Inspection Area.

Operation Tool Detail

Operation: 605

Tool Number

Tooling Description

Muzzle Chamfer Tools

B-73740	Countersink Tool with "T" handle
B-51634-W	Countersink Pilot - 30 caliber (all)
B-51634-V	Countersink Pilot - 270 Win/6.8mm
B-51634-U	Countersink Pilot - 25-06 Rem
B-51634-T	Countersink Pilot - 22 caliber (all CF)
B-51634-S	Countersink Pilot - 35 caliber (all)
B-51634-R	Countersink Pilot - 22 caliber (all RF)
B-51634-Q	Countersink Pilot - 6mm Rem / 243 Win
B-51634-P	Countersink Pilot - 7mm (all) / 280 Rem
B-51634-N	Countersink Pilot - 264 Win / 6.5mm (all)
B-51634-M	Countersink Pilot - 8mm Rem Mag
B-51634-L	Countersink Pilot - 338 (all)

Std

CALIBER
7MM REM. MAG.
300 WBY. MAG.

USE CLOSE HARD PLUG
C-46200-B
C-48336-A

Printed on:
~AUTODATE

300 WIN. MAG.	C-46200-A
17 REM.	C-46201 OR D-48349-A
.223 REM.	C-46198 OR D-48349-C
.243 WIN.	C-46195 OR D-48349-D
22-250 REM.	C-46199 OR D-48349-E
7MM-08 REM., 1308 WIN., 243 WIN.	C-46194 OR D-48349-H
30.06 SPRG., 25.06 REM.	C-45930 OR D-48349-J
220 SWIFT	D-48349-R
7mm SW.	D-46200-C
204 RUGER	D-48349-CC
221 FIREBALL	
6.8mm REM.	

(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-Sep-05			Processed by:
Part No:	Part Name: Fin Assy 700 SS Var	Centerfire Rifle			Date: 8/14/2008	
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.
			INSPECT			
VISUAL	VISUAL	100%	REJECT INSPECT			
			REJECT			
Pieces Run:					Remington Arms Company, Inc. -- Ilion, New York	

CONFIDENTIAL

Printed on:
~AUTODATE

Printed on:
~AUTODATE

610 Test and Target 100%

Operation Step Detail

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

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

Gallery Test-Procedure and Specifications

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

I. RIFLES TESTED AND TARGETED

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

Printed on:
~AUTODATE

II. TEST AND TARGET OBJECTIVES

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

III. SHOOTING JACKS AND DEVICE

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

IV. DESCRIPTION OF TEST AND TARGET PROCEDURES AND SPECIFICATIONS:

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

- A. Test/Target Description

Printed on:
~AUTODATE

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

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.

Printed on:
~AUTODATE

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

	CALIBER	AMMUNITION TYPE	MAG. CAP
1.	220 Swift	50 gr. PSP	5
2.	22-250	55 gr. PSP	4

Printed on:
~AUTODATE

3. 223 Rem	55 gr. PSP	5
4. 23-06	100 gr. PSPCL	4
5. 7mm STW	140 gr. PSPCL	3
6. 7mm Rem. Mag.	140 gr. PSPCL	3
7. 308	168 gr. BT HP MATCH	4
8. 300 Win. Mag.	150 gr. PSPCL	3
9. 204 Roger	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

Printed on:
~AUTODATE

- 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 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.

Printed on:
~AUTODATE

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

23. Open guard. (If on accuracy device)

24. For the Targeted rifles (10% std. & 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. 220 Swift	50 gr. PSP		1.5
2. 22-250	55 gr. HPPL		1.5
3. 223 Rem	55 gr. PSP		1.5
4. 25-06 Rem	100 gr. PSPCL		1.5
5. 7mm STW	140 gr. PSPCL		2.5
6. 7mm Rem Mag	140 gr. PSPCL		2.5
7. 300 Win Mag	180 gr. PSPCL		2.5
8. 308 WIN	168 gr. BT HP Match		1.5
9. 204 RUGER	32gr. ACCUTIP V		1.5

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

Printed on:
~AUTODATE

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.
 - 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%

V. SAFETY AFTER TEST

A. Open Bolt

Printed on:
~AUTODATE

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.

Operation Tool Detail

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

Muzzle Chamfer Tools

B-73740	Countersink Tool with "T" handle
B-51634-W	Countersink Pilot - 30 caliber (all)
B-51634-V	Countersink Pilot - 270 Win
B-51634-U	Countersink Pilot - 25-06 Rem
B-51634-T	Countersink Pilot - 22 caliber (all CF)
B-51634-S	Countersink Pilot - 35 caliber (all)

Printed on:
~AUTODATE

B-51634-R Countersink Pilot - 22 caliber (all RF)
B-51634-C Countersink Pilot - 6mm Rem / 243 Win
B-51634-F 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
	.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

(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-Sep-05	Processed by:
--	---	----------------------

Printed on:
~AUTODATE

Part No:	Part Name: Fin Assy 700 SS Var		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	Remarks, Causes, Action Taken, Etc.
VISUAL	VISUAL	100%	INSPECT REJECT INSPECT			
			REJECT			
Pieces Run:					Remington Arms Company, Inc. -- Ilion, New York	

CONFIDENTIAL

Printed on:
~AUTODATE

Printed on:
~AUTODATE

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-Sep-05			Processed by:	
Part No:	Part Name: Fin Assy 700 SS Var		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				

[illegible][illegible]

CONFIDENTIAL

Printed on:
~AUTODATE

Printed on:
~AUTODATE

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

Printed on:
~AUTODATE

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

3. SPECIFICATIONS

a. Gun Matches Tag

b. Receiver Marking:

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

c. Barrel Marking:

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

d. Bolt Marking:

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

4. GUN GRADES

- a. Camo or Gray

5. STOCK

a. Inspect for Handling Damage

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

Printed on:
~AUTODATE

- D. Trigger Guard Screws Tight
- E. Assemble Correct Rear Swivel - If Specified on Gun Tag

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

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

Free float Barrel clearance:

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

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

A 1" wide by .020" thick plastic shim, inserted from above, between Barrel and fore-end, must fit easily at a depth of at least 1/8".

*Police: use a .025" shim.

- 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 Bead Not Jammed
 - b. Sights MUST Be Central
 - c. Slight Marks per Inspection Standards ONLY
 - d. Crown Good Finish

Printed on:
~AUTODATE

1. Accept 1/16" Light Ring at Bore
2. Uniform Wall
- e. Action:
 1. Operate Bolt 3 times and Fire
 - A. No Bind
 - B. Bolt Handle Raises and Lowers Easily
 2. Open and Close Bolt Possibly 3 Times
 - A. Firing Pin MUST Not Follow Down
- f. Check for Jar Off
 1. Place Safety in "F" or "Off" Position
 2. Applying Steady Pressure on End of Firing Pin Head Using End of Hammer Handle

7 SAFE

Gun cocked:

- a. Clean Sharp Single Detent
 1. TRY TRIGGER THREE TIMES WITH SAFETY IN "S" OR "ON" POSITION
 - A. MUST NOT FIRE WITH HEAVY TRIGGER PRESSURE
 - B. TRIGGER MUST RETRACT
 2. PUSH SAFETY HALFWAY TO THE "F" OR "OFF" POSITION
 - A. PULL TRIGGER
 - B. MUST NOT FIRE
 3. PUSH SAFETY TO "F" OR "OFF" POSITION
 - A. FIRING PIN MUST NOT FOLLOW DOWN
 - B. SAFETY MUST RETURN TO OFF POSITION UNDER TENSION
 - C. USE DOWNWARD PRESSURE ON SAFETY
 - D. Bolt handle must unlock with safety ON
 - E. Safety should snap in detent in both "ON" and "OFF" position
- b. Check Trigger Pull parallel with action
 1. NO Creep (4.75 to 5.75 lbs. on M/700)
 - A. Any rifles outside of the specified range must be diverted to operation 648 for adjustment and then returned.
 - B. Upon return perform all elements of this step.

Try (3) Times

Printed on:
~AUTODATE

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

Tool Number	Tooling Description
C-47444	DRAWING - LISTING DATE CODE STAMPS
STD	Nylon Cleaning Rod 3/16" Delrin rod approx. 36" long.
STD	Cleaning Patches (Hoppes or equiv.)
STD	Rem Oil
BTS-7300	Wood Dents & Scuff Template
A-43977	Trigger clearance shim tool (.030)

Printed on:
~AUTODATE

STD
B-70697

Dummy Cartridge Rounds of proper Caliber being built.
Trigger Pull - Scale

PROCESS CONTROL INSPECTION RECORD THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES			Revision Date: 7-Sep-05			Processed by:
Part No:	Part Name:	Fin Assy 700 SS Var	Centerfire Rifle			Date: 8/14/2006
Operation No: 640	Operation: Final Inspection					Work Center:
Prod. Qty:	Prod. Order #:	Operator			Setup inspected by & Date:	
Gage Description and Characteristic	Gage Number	Gage Frequency	1st Shift	2nd Shift	3rd Shift	Remarks: Causes, Action Taken, Etc.
VISUAL	VISUAL	100%	INSPECT			
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 INSPECT			
Trigger Pull - Scale	B-70697	100%	REJECT INSPECT			
			REJECT INSPECT			
			REJECT INSPECT			
			REJECT			

CONFIDENTIAL

Printed on:
~AUTODATE

Printed on:
~AUTODATE

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.

Printed on:
~AUTODATE

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

Gages:

B-70697

Trigger Pull Scales

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

[illegible]

Remington Arms Company, Inc., -- ilion, New York

Remington Arms Company, Inc., -- ilion, New York

CONFIDENTIAL

Printed on:
~AUTODATE

CONFIDENTIAL

Printed on:
~AUTODATE

CONFIDENTIAL

Printed on:
~AUTODATE

CONFIDENTIAL

Printed on:
~AUTODATE

CONFIDENTIAL

Printed on:
~AUTODATE

CONFIDENTIAL

Printed on:
~AUTODATE

Printed on:
~AUTODATE

[illegible]

[illegible]

Remington Arms Company, Inc. -- Ilion, New York

Remington Arms Company, Inc. -- Ilion, New York

CONFIDENTIAL

Printed on:
~AUTODATE

Printed on:
~AUTODATE

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

Printed on:
~AUTODATE

- 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.

Printed on:
~AUTODATE

#10604, Series 106, or equivalent.

C-47741	Attribute Gage
C-41185-A	17 REM MIN Heading Plug
C-41185-C	17 REM IMAX Heading Plug
C-53322-A	204 RUGER MIN Heading Plug
C-53322-C	204 RUGER IMAX Heading Plug
C-41192-A	220 SWIFT MIN Heading Plug
C-41192-C	220 SWIFT IMAX Heading Plug
C-85239-A	221 F-BALL MIN Heading Plug
C-85239-C	221 F-BALL IMAX Heading Plug
C-41521-A	22-250 MIN Heading Plug
C-41521-C	22-250 IMAX Heading Plug
C-41155-A	223 REM MIN Heading Plug
C-41155-C	223 REM IMAX Heading Plug
C-41556-A	243 WIN MIN Heading Plug
C-41556-C	243 WIN IMAX Heading Plug
C-41560-A	25-06 REM MIN Heading Plug
C-41560-C	25-06 REM IMAX Heading Plug
C-41556-A	7MM-08 REM MIN Heading Plug
C-41556-C	7MM-08 REM IMAX Heading Plug
C-41561-A	7MM Mag MIN Heading Plug
C-41561-C	7MM Mag IMAX Heading Plug
C-83853-A	7MM Mag BELT - MIN Heading Plug
C-83853-C	7MM Mag BELT - IMAX Heading Plug
C-41233-A	7MM STW Mag MIN Heading Plug
C-41233-C	7MM STW Mag IMAX Heading Plug
C-43099-A	7MM STW Mag BELT - MIN Heading Plug
C-43099-C	7MM STW Mag BELT - IMAX Heading Plug
C-41546-A	300 Win MIN Heading Plug
C-41546-C	300 Win IMAX Heading Plug
C-83853-A	300 Win BELT - MIN Heading Plug
C-83853-C	300 Win BELT - IMAX Heading Plug
C-41578-A	300 WBY MIN Heading Plug

Printed on:
~AUTODATE

C-41578-C 300 WBY IMAX Heading Plug
C-83853-A 300 WBY BELT - MIN Heading Plug
C-83853-C 300 WBY BELT - IMAX Heading Plug
C-41556-A 308 WIN MIN Heading Plug
C-41556-C 308 WIN IMAX Heading Plug

PROCESS CONTROL INSPECTION RECORD				Revision Date:		Processed by:
THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES				7-Sep-05		
Part No:	Part Name: Fin Assy 700 SS Var		Centerfire Rifle		Date:	8/14/2005
Operation No: 650	Operation: Inspect Heading and Sear Lift				Work Center:	
Prod. Qty:	Prod. Order #:	Operator			Setup inspected by & Date:	
Gage Description and Characteristic	Gage Number	Gage Frequency	1st Shift	2nd Shift	3rd Shift	Remarks, Causes, Action Taken, Etc.
VISUAL	VISUAL	100%	INSPECT			
Dial Gage	D-44581	100%	REJECT INSPECT			
Attribute Gage	C-47741	100%	REJECT INSPECT			
17 REM MIN Heading Plug	C-41185-A	100%	REJECT INSPECT			
17 REM IMAX Heading Plug	C-41185-C	100%	REJECT INSPECT			
22-250 MIN Heading Plug	C-41521-A	100%	REJECT			

Printed on:
~AUTODATE

			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			
220 SWIFT MIN Heading Plug	C-41192-A	100%	REJECT INSPECT			
220 SWIFT IMAX Heading Plug	C-41192-C	100%	REJECT INSPECT			
220 SWIFT MIN Heading Plug	C-41192-A	100%	REJECT INSPECT			
220 SWIFT IMAX Heading Plug	C-41192-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			
308 W/N MIN Heading Plug	C-41556-A	100%	REJECT INSPECT			
308 W/N IMAX Heading Plug	C-41556-C	100%	REJECT INSPECT			
308 W/N MIN Heading Plug	C-41556-A	100%	REJECT			

Printed on:
~AUTODATE

			INSPECT			
300 WIN IMAX Heading Plug	C-41556-C	100%	REJECT INSPECT			
25-06 REM MIN Heading Plug	C-41560-A	100%	REJECT INSPECT			
25-06 REM IMAX Heading Plug	C-41560-C	100%	REJECT INSPECT			
300 WBY BELT - MIN Heading Plug	C-83853-A	100%	REJECT INSPECT			
300 WBY BELT - IMAX Heading Plug	C-83853-C	100%	REJECT INSPECT			
300 WBY MIN Heading Plug	C-41578-A	100%	REJECT INSPECT			
300 WBY IMAX Heading Plug	C-41578-C	100%	REJECT INSPECT			
300 Win BELT - MIN Heading Plug	C-83853-A	100%	REJECT INSPECT			
300 Win BELT - IMAX Heading Plug	C-83853-C	100%	REJECT INSPECT			
300 Win MIN Heading Plug	C-41546-A	100%	REJECT INSPECT			
300 Win IMAX Heading Plug	C-41546-C	100%	REJECT INSPECT			
7MM STW Mag BELT - MIN Heading Plug	C-43099-A	100%	REJECT			

Printed on:
~AUTODATE

7MM STW Mag BELT - IMAX Heading Plug	C-43099-C	100%	INSPECT			
7MM STW Mag MIN Heading Plug	C-41233-A	100%	REJECT INSPECT			
7MM STW Mag IMAX Heading Plug	C-41233-C	100%	REJECT INSPECT			
7MM Mag BELT - MIN Heading Plug	C-83853-A	100%	REJECT INSPECT			
7MM Mag BELT - IMAX Heading Plug	C-83853-C	100%	REJECT INSPECT			
7MM Mag MIN Heading Plug	C-41561-A	100%	REJECT INSPECT			
7MM Mag IMAX Heading Plug	C-41561-C	100%	REJECT INSPECT			
			REJECT INSPECT			
			REJECT INSPECT			
			REJECT INSPECT			
			REJECT INSPECT			
			REJECT INSPECT			
			REJECT			
Pieces Run:						Remington Arms Company, Inc. -- Ilion, New York

CONFIDENTIAL

Printed on:
~AUTODATE

CONFIDENTIAL

Printed on:
~AUTODATE

CONFIDENTIAL

Printed on:
~AUTODATE

CONFIDENTIAL

Printed on:
~AUTODATE

29719

26207

Printed on:
~AUTODATE

26207

29743

29743

29741

29741

26205

26205

29745

29745

26209

26209

29747

Printed on:
~AUTODATE

29747

26199

26199

27504

27504

27504

27504

27508

27508

27508

27508

27502

Printed on:
~AUTODATE

27502

27502

27502

27506

27506

27506

27506

Printed on:
~AUTODATE

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

Printed on:
~AUTODATE

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-Sep-05			Processed by:
Part No:	Part Name: Fin Assy 700 SS Var		Centerfire Rifle			Date: 8/14/2006
Operation No: 655	Operation: Mark Bolt to Match Receiver Serial					Work Center:
Prod. Qty:	Prod. Order #:	Operator			Setup Inspected by & Date:	
Gage Description and Characteristic	Gage Number	Gage Frequency	1st Shift	2nd Shift	3rd Shift	Remarks: Causes, Action Taken, Etc.
VISUAL	VISUAL	100%	INSPECT			
			REJECT			
			INSPECT			
			REJECT			
			INSPECT			
			REJECT			
			INSPECT			
			REJECT			
			INSPECT			
			REJECT			
			INSPECT			
			REJECT			
			INSPECT			
			REJECT			

[illegible][illegible][illegible][illegible]

CONFIDENTIAL

Printed on:
~AUTODATE

Printed on:
~AUTODATE

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)

Printed on:
~AUTODATE

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-Sep-05	Processed by:
Part No:	Part Name: Fin Assy 700 SS Var	Centerfire Rifle	Date: 8/14/2006

Printed on:
~AUTODATE~

Operation No: 676
Prod. Qty.

ive Order - William

[illegible]

ILE00116778

[illegible]

ILE00116779

CONFIDENTIAL

Printed on:
~AUTODATE

Printed on:
~AUTODATE

Dept	Oper	Operation Description	Part Numbers
9132	1	Issue from Crib	29745 29747 29741 26199 27506 27508 29743 27502 27504 26205 26207 26209 29719 26183 26185 26187 26189 26191 26194 26196 26201 26333 26339 26337 26335 26449 26497 26499
8761	395	INSPECT COMPONENTS BEFORE HEADING	29745 29747 29741 26199 27506 27508 29743 27502 27504 26205 26207 26209 29719 26183 26185 26187 26189 26191 26194 26196 26201 26333 26339 26337 26335 26449 26497 26499
8761	400	Fit and Head Bolt Assembly to Barrel Assembly	26209 29747 26199 26194 26201 26449
8761	405	Fit and Head Bolt Assembly to Barrel Assembly	26205 26207 29741 29745 29743 29719 26183 26185 26187 26189 26191 26196 26333 26339 26337 26335 26497 26499
8761	415	Fit and Head Bolt Assembly to Barrel Assy and Chamber to Length (Magnums)	27506 27502 27508 27504
8761	420	Ream Chamber to Deburr	27506 27502 27508 27504
8761	425	Make Chamber Cast (Not Done on 100% of Product)	29745 29747 29741 26199 27506 27508 29743 27502 27504

Printed on:
~AUTODATE

Dept	Oper	Operation Description	Part Numbers
			26205 26207 26209
			29719 26183 26185
			26187 26189 26191
			26194 26196 26201
			26333 26339 26337
			26335 26449 26497
			26499
8761	430	Ream Ejector Hole	29745 29747 29741
			26199 27506 27508
			29743 27502 27504
			26205 26207 26209
			29719 26183 26185
			26187 26189 26191
			26194 26196 26201
			26333 26339 26337
			26335 26449 26497
			26499
8761	431	Form Radius on Edge of Firing Pin Hole	26199
8761	432	Assemble Riveted Extractor to Bolt - (MAGNUMS)	27506 27508 27502
			27504
8761	435	Assemble Rivetless Extractor to Bolt	29745 29747 29741
			26199 29743 26205
			26207 26209 29719
			26183 26185 26187
			26189 26191 26194
			26196 26201 26333
			26339 26337 26335
			26449 26497 26499
8761	440	Assemble Ejector to Ejector Spring and then Assemble to Bolt with Ejector Cross Pin	29745 29747 29741
			26199 27506 27508
			29743 27502 27504
			26205 26207 26209
			29719 26183 26185
			26187 26189 26191
			26194 26196 26201
			26333 26339 26337
			26335 26449 26497
			26499
8761	468	Strip Defective Barrel Assembly Complete	29745 29747 29741
			26199 27506 27508

Printed on:
~AUTODATE

Dept	Oper	Operation Description	Part Numbers
			29743 27502 27504
			26205 26207 26209
			29719 26183 26185
			26187 26189 26191
			26194 26196 26201
			26333 26339 26337
			26335 26449 26497
			26499
8761	465R	Strip Defective Bolt	29745 29747 29741
			26199 27506 27508
			29743 27502 27504
			26205 26207 26209
			29719 26183 26185
			26187 26189 26191
			26194 26196 26201
			26333 26339 26337
			26335 26449 26497
			26499
8761	580	Assemble Action	29745 29747 29741
			26199 27506 27508
			29743 27502 27504
			26205 26207 26209
			29719 26183 26185
			26187 26189 26191
			26194 26196 26201
			26333 26339 26337
			26335 26449 26497
			26499
8761	585	Assemble Stock to Action	29745 29747 29741
			26199 27506 27508
			29743 27502 27504
			26205 26207 26209
			29719 26183 26185
			26187 26189 26191
			26194 26196 26201
			26333 26339 26337
			26335 26449 26497
			26499
8785	600	Proof Test	29745 29747 29741
			26199 27506 27508
			29743 27502 27504
			26205 26207 26209

Printed on:
~AUTODATE

Dept	Oper	Operation Description	Part Numbers
			29719 26183 26185
			26187 26189 26191
			26194 26196 26201
			26333 26339 26337
			26335 26449 26497
			26499
8785	600R	Proof Test with slave bolt	29745 29747 29741
			26199 27506 27508
			29743 27502 27504
			26205 26207 26209
			29719 26183 26185
			26187 26189 26191
			26194 26196 26201
			26333 26339 26337
			26335 26449 26497
			26499
8785	605R	Check Repaired Guns Returning to Gallery for Proof Stamp, Prick Punch and Construction In Barrel	29745 29747 29741
			26199 27506 27508
			29743 27502 27504
			26205 26207 26209
			29719 26183 26185
			26187 26189 26191
			26194 26196 26201
			26333 26339 26337
			26335 26449 26497
			26499
8785	606	Test and Target	29747 26199 27506
			27508 27502 27504
			26205 26207 26209
			29719 26183 26185
			26187 26189 26191
			26194 26196 26201
			26333 26339 26337
			26335 26449 26497
			26499
8785	610	Test and Target 100%	29741 29745 29743
8785	620	Inspect For Live Ammunition	29745 29747 29741
			26199 27506 27508
			29743 27502 27504
			26205 26207 26209
			29719 26183 26185

Printed on:
~AUTODATE

Dept	Oper	Operation Description	Part Numbers
			26187 26189 26191
			26194 26196 26201
			26333 26339 26337
			26335 26449 26497
			26499
8786	640	Final Inspection	29745 29747 29741
			26199 27506 27508
			29743 27502 27504
			26205 26207 26209
			29719 26183 26185
			26187 26189 26191
			26194 26196 26201
			26333 26339 26337
			26335 26449 26497
			26499
8761	648	Reset trigger pull within specs as needed - not done on 100% of the product	29745 29747 29741
			26199 27506 27508
			29743 27502 27504
			26205 26207 26209
			29719 26183 26185
			26187 26189 26191
			26194 26196 26201
			26333 26339 26337
			26335 26449 26497
			26499
8786	650	Inspect Heading and Gear Lift	29745 29747 29741
			26199 27506 27508
			29743 27502 27504
			26205 26207 26209
			29719 26183 26185
			26187 26189 26191
			26194 26196 26201
			26333 26339 26337
			26335 26449 26497
			26499
8786	655	Mark Bolt to Match Receiver Serial Number Using Dot Peen Marking Machine	29745 29747 29741
			26199 27506 27508
			29743 27502 27504
			26205 26207 26209
			29719 26183 26185
			26187 26189 26191
			26194 26196 26201

Printed on:
~AUTODATE

Dept	Oper	Operation Description	Part Numbers
			26333 26339 26337
			26335 26449 26497
			26499
8786	676	Pack Rifle	29745 29747 29741
		To Warehouse	26199 27506 27508
			29743 27502 27504
			26205 26207 26209
			29719 26183 26185
			26187 26189 26191
			26194 26196 26201
			26333 26339 26337
			26335 26449 26497
			26499

Printed on:
~AUTODATE

Dept	Oper	Operation Description	Part Numbers
01	2	01	01
02	0	01	02
03	0	01	03
04	0	01	04
05	0	01	05
06	0	01	06
07	0	01	07
08	0	01	08
09	0	01	09
10	0	01	10
11	0	01	11
12	0	01	12
13	0	01	13
14	0	01	14
15	0	01	15
16	0	01	16
17	0	01	17
18	0	01	18
19	0	01	19
20	0	01	20
21	0	01	21
22	0	01	22
23	0	01	23
24	0	01	24
25	0	01	25
26	0	01	26
27	0	01	27
28	0	01	28
29	0	01	29
30	0	01	30
31	0	01	31
32	0	01	32
33	0	01	33
34	0	01	34
35	0	01	35
36	0	01	36
37	0	01	37
38	0	01	38
39	0	01	39
40	0	01	40
41	0	01	41
42	0	01	42
43	0	01	43
44	0	01	44
45	0	01	45
46	0	01	46
47	0	01	47
48	0	01	48
49	0	01	49
50	0	01	50
51	0	01	51
52	0	01	52
53	0	01	53
54	0	01	54
55	0	01	55
56	0	01	56
57	0	01	57
58	0	01	58
59	0	01	59
60	0	01	60
61	0	01	61
62	0	01	62
63	0	01	63
64	0	01	64
65	0	01	65
66	0	01	66
67	0	01	67
68	0	01	68
69	0	01	69
70	0	01	70
71	0	01	71
72	0	01	72
73	0	01	73
74	0	01	74
75	0	01	75
76	0	01	76
77	0	01	77
78	0	01	78
79	0	01	79
80	0	01	80
81	0	01	81
82	0	01	82
83	0	01	83
84	0	01	84
85	0	01	85
86	0	01	86
87	0	01	87
88	0	01	88
89	0	01	89
90	0	01	90
91	0	01	91
92	0	01	92
93	0	01	93
94	0	01	94
95	0	01	95
96	0	01	96
97	0	01	97
98	0	01	98
99	0	01	99
100	0	01	100

Printed on:
~AUTODATE

Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
							RAMACH DESCRIPTION
							29719 VAR S/A BDL - 17 REM
							26449 VAR S/A BDL - 6.8MM REM SPC
							26203 EP VAR S/A BDL - 220 SWIFT
							26207 EP VAR S/A BDL - 22-250 REM
							26209 EP VAR S/A BDL - 308 WIN
							29741 SF VAR S/A BDL - 220 SWIFT
							29742 SF VAR S/A BDL - 223 REM
							29743 SF VAR S/A BDL - 22-250 REM
							29747 SF VAR S/A BDL - 308 WIN
							26183 LV-SF VAR S/A ADL - 17 REM
							26185 LV-SF VAR S/A ADL - 221 F-BALL
							26187 LV-SF VAR S/A ADL - 223 REM
							26189 LV-SF VAR S/A ADL - 22-250 REM
							26191 LV-SF VAR S/A ADL - 243 WIN
							26194 LV-SF VAR S/A ADL - 7MM-08 REM
							26196 LV-SF VAR S/A ADL - 204 RUGER
							26201 LV-SF VAR S/A ADL - 308 WIN
							26199 SF VAR L/A - 25-06 REM
							27506 SF VAR L/A - 7MM REM MAG
							27502 SF VAR L/A - 7MM STW
							27508 SF VAR L/A - 300 WIN MAG
							27504 SF VAR L/A - 300 WBY MAG
							26333 VS-SF S/A BDL - 204 RUGER - BLACK F
							26339 VS-SF S/A BDL - 220 SWIFT - BLACK F
							26337 VS-SF S/A BDL - 223 REM - BLACK F
							26497 VS-SF S/A BDL - 223 REM - BLACK F
							BLK LAM W/THUMBHOLE
							26335 VS-SF S/A BDL - 22-250 REM - BLACK F
							26499 VS-SF S/A BDL - 22-250 REM - BLACK F
							BLK LAM W/THUMBHOLE
29719							700SS VAR S/A BDL - 17 REM
		301049	502	676	1.000		Cable Lock
		201547	77	405	1.000		BARREL ASSEMBLY
		105443	67	405	1.000		BOLT ASSEMBLY

Printed on:
~AUTODATE

Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
		97444	100	580	1.000		Bolt Stop
		24475	50	580	1.000		Bolt Stop Pin
		15224	30	580	1.000		Bolt Stop Spring
		993002	250	676	1.000		Box & Envelope Label
		3509	20	676	1.000		Instruction Book
		17017	400	440	1.000		Ejector
		94555	410	440	1.000		Ejector Pin
		17019	420	440	1.000		Ejector Spring
		1333	280	676	2.000		Ethefoam Insert
		97138	430	435	1.000		Extractor
		305640	200	580	1.000		Firing Pin Assy
		98880	270	585	1.000		Floor Plate Insert
		106291	190	585	1.000		Front Guard Screw
		106770	260	580	1.000		Magazine Assy
		92508	70	585	1.000		Magazine Follower
		91133	80	585	1.000		Magazine Spring
		21728	290	600	1.100		PROOF ROUND
		106292	180	585	1.000		Rear Guard Screw
		17034	90	580	4.000		Receiver Plug Screws
		1499	10	676	1.000		RF-EC Carton
		24476	60	580	1.000		Rear Pin
		104710B	220	585	1.000		Stock Assy
		28460	505	600	2.000		TEST ROUND 17 REM 25 gr.PLHP
		28460	300	600	3.500		TARGET ROUND 17 REM 25 gr.PLHP
		97490	120	580	1.000		Trigger Assy
		97867	170	585	1.000		Trigger Guard Assy
26449							VAR S/A BDL - 6.8MM REM SPC
		301049	502	676	1.000		Cable Lock
		245504	77	405	1.000		BARREL ASSEMBLY
		113895	67	405	1.000		BOLT ASSEMBLY
		97444	100	580	1.000		Bolt Stop
		24475	50	580	1.000		Bolt Stop Pin
		15224	30	580	1.000		Bolt Stop Spring
		993002	250	676	1.000		Box & Envelope Label
		3509	20	676	1.000		Instruction Book
		201843	400	440	1.000		Ejector
		94555	410	440	1.000		Ejector Pin
		201841	420	440	1.000		Ejector Spring
		1333	280	676	2.000		Ethefoam Insert
		93712	430	435	1.000		Extractor
		305640	200	580	1.000		Firing Pin Assy
		106291	190	585	1.000		Front Guard Screw
		106608	260	580	1.000		Magazine Assy
		90982	70	585	1.000		Magazine Follower
		15699	80	585	1.000		Magazine Spring

Printed on:
~AUTODATE

Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
		21738	290	600	1.100		PROOF ROUND
		106292	180	585	1.000		Rear Guard Screw
		17034	90	580	4.000		Receiver Plug Screws
		1684	10	676	1.000		RF-CF Carton
		24476	60	580	1.000		Sear Pin
		249062	220	585	1.000		Stock Assy
		29146	505	606	2.000		TEST ROUND 5.5MM REM SPC 115 HPBT MATCH
		29146	300	606	3.500		TARGET ROUND 6.8MM REM SPC 115 HPBT MATCH
		97490	120	580	1.000		Trigger Assy
		97867	170	585	1.000		Trigger Guard Assy
26205							700SS FP VAR S/A BDL - 220 SWIFT
		301049	502	676	1.000		Cable Lock
		108830	77	405	1.000		BARREL ASSEMBLY
		105442	67	405	1.000		BOLT ASSEMBLY
		97444	100	580	1.000		Bolt Stop
		24475	60	580	1.000		Bolt Stop Pin
		15224	30	580	1.000		Bolt Stop Spring
		993002	240	676	1.000		Box & Envelope Label
		3509	20	676	1.000		Instruction Book
		17017	400	440	1.000		Ejector
		94555	410	440	1.000		Ejector Pin
		17019	420	440	1.000		Ejector Spring
		1333	250	676	2.000		Ethefoam Insert
		93712	430	440	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
		21806	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
		104710B	210	585	1.000		Stock Assy
		21297	595	606	2.000		TEST ROUND 220 SWIFT 50 gr.PSP
		21297	270	606	3.500		TARGET ROUND 220 SWIFT 50 gr.PSP
		97490	120	580	1.000		Trigger Assy
		97867	160	585	1.000		Trigger Guard Assy
26207							700SS FP VAR S/A BDL - 22-250 REM
		301049	502	676	1.000		Cable Lock
		108831	77	405	1.000		BARREL ASSEMBLY
		105442	67	405	1.000		BOLT ASSEMBLY
		97444	100	580	1.000		Bolt Stop

Printed on:
~AUTODATE

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
		106291	180	585	1.000		Front Guard Screw
		97825	130	580	1.000		Magazine
		15699	40	585	1.000		Magazine Spring
		90982	80	585	1.000		Magazine Follower
		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-ET Carton
		24476	70	580	1.000		Sear Pin
		104710B	210	585	1.000		Stock Assy
		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
26209							700SS FP VAR S/A BDL - 308 WIN
		301049	502	676	1.000		Cable Lock
		108832	77	400	1.000		BARREL ASSEMBLY
		105442	67	400	1.000		BOLT ASSEMBLY
		97444	100	580	1.000		Bolt Stop
		24475	60	580	1.000		Bolt Stop Pin
		15224	30	580	1.000		Bolt Stop Spring
		993002	240	676	1.000		Box & Envelope Label
		3509	20	676	1.000		Instruction Book
		17017	400	440	1.000		Ejector
		94555	410	440	1.000		Ejector Pin
		17019	420	440	1.000		Ejector Spring
		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
		97825	130	580	1.000		Magazine
		88982	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

Printed on:
~AUTODATE

Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
		17034	90	580	4.000		Receiver Plug Screws
		1499	10	676	1.000		RF-CF Carton
		24476	70	580	1.000		Sear Pin
		104710B	210	585	1.000		Stock Assy
		21485	505	606	2.000		TEST ROUND - 308 WIN 168 gr.HP BT MATCH
		21485	270	606	3.500		TARGET ROUND - 308 WIN 168 gr.HP BT MATCH
		97490	120	580	1.000		Trigger Assy
		97867	160	585	1.000		Trigger Guard Assy
29741							700SS SF VAR S/A BDL - 220 SWIFT
		301049	502	676	1.000		Cable Lock
		106316	77	405	1.000		BARREL ASSEMBLY
		105442	67	405	1.000		BOLT ASSEMBLY
		97444	100	580	1.000		Bolt Stop
		24475	60	580	1.000		Bolt Stop Pin
		15224	30	580	1.000		Bolt Stop Spring
		993002	240	676	1.000		Box & Envelope Label
		3509	20	676	1.000		Instruction Book
		17017	400	440	1.000		Ejector
		94555	410	440	1.000		Ejector Pin
		17019	420	440	1.000		Ejector Spring
		1333	250	676	2.000		Ethefoam Insert
		93712	430	435	1.000		Extractor
		305640	190	580	1.000		Firing Pin Assy
		106291	180	580	1.000		Front Guard Screw
		97825	130	580	1.000		Magazine
		90982	80	585	1.000		Magazine Follower
		15699	40	585	1.000		Magazine Spring
		21806	260	606	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
		104710B	210	585	1.000		Stock Assy
		21297	270	606	8.000		TARGET ROUND 220 SWIFT 50 GR PSP
		97490	120	580	1.000		Trigger Assy
		97867	160	585	1.000		Trigger Guard Assy
29745							700SS SF VAR S/A BDL - 223 REM
		301049	502	676	1.000		Cable Lock
		106315	77	405	1.000		BARREL ASSEMBLY
		105443	67	405	1.000		BOLT ASSEMBLY
		97444	100	580	1.000		Bolt Stop
		24475	60	580	1.000		Bolt Stop Pin
		15224	30	580	1.000		Bolt Stop Spring
		993002	240	676	1.000		Box & Envelope Label

Printed on:
~AUTODATE

Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
		3509	20	676	1.000		Instruction Book
		17017	400	440	1.000		Ejector
		94555	410	440	1.000		Ejector Pin
		17019	420	440	1.000		Ejector Spring
		1333	280	676	2.000		Ethefoam Insert
		97138	430	435	1.000		Extractor
		305640	200	580	1.000		Firing Pin Assy
		98880	270	585	1.000		Floor Plate Insert
		106291	190	585	1.000		Front Guard Screw
		106770	260	580	1.000		Magazine Assy
		92508	70	585	1.000		Magazine Follower
		91133	80	585	1.000		Magazine Spring
		21774	290	600	1.100		PROOF ROUND
		106292	180	585	1.000		Rear Guard Screw
		17034	90	580	4.000		Receiver Plug Screws
		1499	10	676	1.000		RF-CF Carton
		24476	60	580	1.000		Sear Pin
		104710B	220	585	1.000		Stock Assy
		28399	300	606	8.000		TARGET ROUND 223 REM 55 gr.PSP
		97490	120	580	1.000		Trigger Assy
		97867	170	585	1.000		Trigger Guard Assy
29743							700SS SF VAR S/A BDL - 22-250 REM
		301049	502	676	1.000		Cable Lock
		106317	77	405	1.000		BARREL ASSEMBLY
		105442	67	405	1.000		BOLT ASSEMBLY
		97444	100	580	1.000		Bolt Stop
		24475	60	580	1.000		Bolt Stop Pin
		15224	30	580	1.000		Bolt Stop Spring
		993002	240	676	1.000		Box & Envelope Label
		3509	20	676	1.000		Instruction Book
		17017	400	440	1.000		Ejector
		94555	410	440	1.000		Ejector Pin
		17019	420	440	1.000		Ejector Spring
		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
		97825	130	580	1.000		Magazine
		98982	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

Printed on:
~AUTODATE

Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
		104710B	210	585	1.000		Stock Assy
		21313	505	606	2.000		TEST ROUND 22-250 REM 55 gr.HPPL
		21313	270	606	8.000		TARGET ROUND 22-250 REM 55 gr.HPPL
		97490	120	580	1.000		Trigger Assy
		97867	160	585	1.000		Trigger Guard Assy
29747							700SS SF VAR S/A BDL - 308 WIN
		301049	502	676	1.000		Cable Lock
		106318	77	400	1.000		BARREL ASSEMBLY
		105442	67	400	1.000		BOLT ASSEMBLY
		97444	100	580	1.000		Bolt Stop
		24475	60	580	1.000		Bolt Stop Pin
		15224	30	580	1.000		Bolt Stop Spring
		993002	240	676	1.000		Box & Envelope Label
		3509	20	676	1.000		Instruction Book
		17017	400	440	1.000		Ejector
		94555	410	440	1.000		Ejector Pin
		17019	420	440	1.000		Ejector Spring
		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
		97825	130	580	1.000		Magazine
		90982	80	585	1.000		Magazine Follower
		15699	40	580	1.000		Magazine Spring
		21723	260	606	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
		104710B	210	585	1.000		Stock Assy
		21485	505	606	2.000		TEST ROUND - 308 WIN 168 gr.HP BT MATCH
		21485	270	606	3.500		TARGET ROUND - 308 WIN 168 gr.HP BT MATCH
		97490	120	580	1.000		Trigger Assy
		97867	160	585	1.000		Trigger Guard Assy
26183							700SS LV-SF VAR S/A ADL - 17 REM
		301049	502	676	1.000		Cable Lock
		247100	77	405	1.000		BARREL ASSEMBLY
		105443	67	405	1.000		BOLT ASSEMBLY
		97444	100	580	1.000		Bolt Stop
		24475	50	580	1.000		Bolt Stop Pin
		15224	30	580	1.000		Bolt Stop Spring
		993002	250	676	1.000		Box & Envelope Label
		105405	910	585	1.000		Center Guard Screw
		3509	20	676	1.000		Instruction Book

Printed on:
~AUTODATE

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
		97139	430	435	1.000		Extractor
		305640	200	580	1.000		Firing Pin Assy
		105401	190	585	1.000		Front Guard Screw
		99402	260	580	1.000		Magazine Assy
		92508	70	585	1.000		Magazine Follower
		91133	80	585	1.000		Magazine Spring
		97438	520	580	1.000		Magazine Tab Screw
		21728	290	600	1.100		PROOF ROUND
		106292	180	585	1.000		Rear Guard Screw
		17034	90	580	4.000		Receiver Plug Screws
		1444	10	676	1.000		RF-CF Carton
		24476	60	580	1.000		Sear Pin
		301028	220	585	1.000		Stock Assy
		28460	505	606	2.000		TEST ROUND 17 REM 25 gr. PLHP
		28460	300	606	3.500		TARGET ROUND 17 REM 25 gr. PLHP
		97490	120	580	1.000		Trigger Assy
		97499	170	585	1.000		Trigger Guard
26185							1700SS LV-SF VAR S/A ADL - 221 FIREBALL
		301049	502	676	1.000		Cable Lock
		247101	77	405	1.000		BARREL ASSEMBLY
		107763	67	425	1.000		BOLT ASSEMBLY
		97444	100	580	1.000		Bolt Stop
		24475	50	580	1.000		Bolt Stop Pin
		15224	30	580	1.000		Bolt Stop Spring
		993002	250	676	1.000		Box & Envelope Label
		105405	510	585	1.000		Center Guard Screw
		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
		97139	430	435	1.000		Extractor
		305640	200	580	1.000		Firing Pin Assy
		105401	190	585	1.000		Front Guard Screw
		202104	260	580	1.000		Magazine Assy
		201901	70	585	1.000		Magazine Follower
		300557	80	585	1.000		Magazine Spring
		97438	520	580	1.000		Magazine Tab Screw
		21768	290	600	1.100		PROOF ROUND
		106292	180	585	1.000		Rear Guard Screw
		17034	90	580	4.000		Receiver Plug Screws
		1444	10	676	1.000		RF-CF Carton
		24476	60	580	1.000		Sear Pin

Printed on:
~AUTODATE

Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
		301028	220	585	1.000		Stock Assy
		29172	505	606	2.000		Test Round 221 FIREBALL 50 gr.ACCUTIP BT
		29172	300	606	3.500		Target Round 221 FIREBALL 50 gr.ACCUTIP BT
		97490	120	580	1.000		Trigger Assy
		97499	170	585	1.000		Trigger Guard
26187							700SS LV-SF VAR S/A ADL - 223 REM
		301049	502	676	1.000		Cable Lock
		247102	77	405	1.000		BARREL ASSEMBLY
		105443	67	405	1.000		BOLT ASSEMBLY
		97444	100	580	1.000		Bolt Stop
		24475	50	580	1.000		Bolt Stop Pin
		15224	30	580	1.000		Bolt Stop Spring
		993002	250	676	1.000		Box & Envelope Label
		105405	510	585	1.000		Center Guard Screw
		3509	20	676	1.000		Instruction Book
		17017	400	440	1.000		Ejector
		94555	410	440	1.000		Ejector Pin
		17019	420	440	1.000		Ejector Spring
		97138	430	435	1.000		Extractor
		305640	200	580	1.000		Firing Pin Assy
		105401	190	585	1.000		Front Guard Screw
		99402	260	580	1.000		Magazine Assy
		202369	70	585	1.000		Magazine Follower
		202370	80	580	1.000		Magazine Spring
		97438	520	580	1.000		Magazine Tab Screw
		21774	290	600	1.000		PROOF ROUND
		106292	180	585	1.000		Rear Guard Screw
		17034	90	580	4.000		Receiver Plug Screws
		1444	10	676	1.000		RF-CF Carton
		24476	60	580	1.000		Sear Pin
		301028	220	585	1.000		Stock Assy
		28399	505	606	2.000		TEST ROUND 223 REM 55 gr.PSP
		28399	300	606	3.500		TARGET ROUND 223 REM 55 gr.PSP
		97490	120	580	1.000		Trigger Assy
		97499	170	585	1.000		Trigger Guard
26189							700SS LV-SF VAR S/A ADL - 22-250 REM
		301049	502	676	1.000		Cable Lock
		247102	77	405	1.000		BARREL ASSEMBLY
		105442	67	405	1.000		BOLT ASSEMBLY
		97444	100	580	1.000		Bolt Stop
		24475	60	580	1.000		Bolt Stop Pin
		15224	30	580	1.000		Bolt Stop Spring
		993002	240	676	1.000		Box & Envelope Label
		105405	510	585	1.000		Center Guard Screw

Printed on:
~AUTODATE

Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
		3509	20	676	1.000		Instruction Book
		17017	400	440	1.000		Ejector
		94555	410	440	1.000		Ejector Pin
		17019	420	440	1.000		Ejector Spring
		93712	430	435	1.000		Extractor
		305640	190	580	1.000		Firing Pin Assy
		105401	180	585	1.000		Front Guard Screw
		97755	130	580	1.000		Magazine
		90982	80	585	1.000		Magazine Follower
		15699	40	585	1.000		Magazine Spring
		97438	520	580	1.000		Magazine Tab Screw
		21853	260	600	1.100		PROOF ROUND
		106292	170	585	1.000		Rear Guard Screw
		17034	90	580	4.000		Receiver Plug Screws
		1444	10	676	1.000		RF-CF Carton
		24476	70	580	1.000		Sear Pin
		301028	210	585	1.000		Stock Assy
		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
		97499	160	585	1.000		Trigger Guard
26191							700SS LV-SF VAR S/A ADL - 243 WIN
		301049	502	676	1.000		Cable Lock
		247104	77	405	1.000		BARREL ASSEMBLY
		105442	67	405	1.000		BOLT ASSEMBLY
		97444	100	580	1.000		Bolt Stop
		24475	60	580	1.000		Bolt Stop Pin
		15224	30	580	1.000		Bolt Stop Spring
		993002	240	676	1.000		Box & Envelope Label
		105405	510	585	1.000		Center Guard Screw
		3509	20	676	1.000		Instruction Book
		17017	400	440	1.000		Ejector
		94555	410	440	1.000		Ejector Pin
		17019	420	440	1.000		Ejector Spring
		93712	430	435	1.000		Extractor
		305640	190	580	1.000		Firing Pin Assy
		105401	180	585	1.000		Front Guard Screw
		97755	130	580	1.000		Magazine
		90982	80	585	1.000		Magazine Follower
		17891	40	585	1.000		Magazine Spring
		97438	520	580	1.000		Magazine Tab Screw
		21853	260	600	1.100		PROOF ROUND
		106292	170	585	1.000		Rear Guard Screw
		17034	90	580	4.000		Receiver Plug Screws
		1444	10	676	1.000		RF-CF Carton

Printed on:
~AUTODATE

Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
		24476	70	580	1.000		Sear Pin
		301028	210	585	1.000		Stock Assy
		27802	505	610	2.000		TEST ROUND 243 WIN 100 gr.PSPCL
		21319	270	606	3.500		TARGET ROUND 243 WIN 80 gr.HP
		97490	120	580	1.000		Trigger Assy
		97499	160	585	1.000		Trigger Guard
26194							700SS LV-SF VAR S/A ADL - 7MM-08 REM
		301049	502	676	1.000		Cable Lock
		247105	77	405	1.000		BARREL ASSEMBLY
		105442	67	405	1.000		BOLT ASSEMBLY
		97444	100	580	1.000		Bolt Stop
		24475	60	580	1.000		Bolt Stop Pin
		15224	30	580	1.000		Bolt Stop Spring
		993002	240	676	1.000		Box & Envelope Label
		105405	510	585	1.000		Center Guard Screw
		3509	20	676	1.000		Instruction Book
		17017	400	440	1.000		Ejector
		94555	410	440	1.000		Ejector Pin
		17019	420	440	1.000		Ejector Spring
		93712	430	435	1.000		Extractor
		305640	190	580	1.000		Firing Pin Assy
		105401	180	585	1.000		Front Guard Screw
		97755	130	580	1.000		Magazine
		90982	80	585	1.000		Magazine Follower
		17891	40	585	1.000		Magazine Spring
		97438	520	580	1.000		Magazine Tab Screw
		21779	260	606	1.100		PROOF ROUND
		106292	170	585	1.000		Rear Guard Screw
		17034	90	580	4.000		Receiver Plug Screws
		1444	10	676	1.000		RF-CF Carton
		24476	70	580	1.000		Sear Pin
		301028	210	585	1.000		Stock Assy
		21337	505	606	2.000		TEST ROUND 7MM-08 REM 140 gr.PSP
		21337	270	606	3.500		TARGET ROUND 7MM-08 REM 140 gr.PSP
		97490	120	580	1.000		Trigger Assy
		97499	160	585	1.000		Trigger Guard
26196							700SS LV-SF VAR S/A ADL - 204 RUGER
		301049	502	676	1.000		Cable Lock
		247105	77	405	1.000		BARREL ASSEMBLY
		105443	67	405	1.000		BOLT ASSEMBLY
		97444	100	580	1.000		Bolt Stop
		24475	60	580	1.000		Bolt Stop Pin
		15224	30	580	1.000		Bolt Stop Spring
		993002	240	676	1.000		Box & Envelope Label

Printed on:
~AUTODATE

Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
		105405	510	585	1.000		Center Guard Screw
		3509	20	676	1.000		Instruction Book
		17017	400	440	1.000		Ejector
		94555	410	440	1.000		Ejector Pin
		17019	420	440	1.000		Ejector Spring
		97138	430	435	1.000		Extractor
		305640	200	580	1.000		Firing Pin Assy
		105401	190	585	1.000		Front Guard Screw
		99402	260	580	1.000		Magazine Assy
		92508	70	585	1.000		Magazine Follower
		91133	80	585	1.000		Magazine Spring
		97438	520	580	1.000		Magazine Tab Screw
		202309	290	600	1.100		PROOF ROUND
		106292	180	585	1.000		Rear Guard Screw
		17034	90	580	4.000		Receiver Plug Screws
		1444	10	676	1.000		RF-CF Carton
		24476	60	580	1.000		Sear Pin
		301028	220	585	1.000		Stock Assy
		29218	505	606	2.000		TEST ROUND 204 ACCUTIP-V 32 gr.
		29218	300	606	3.500		TARGET ROUND 204 ACCUTIP-V 32 gr.
		97490	120	580	1.000		Trigger Assy
		97499	170	585	1.000		Trigger Guard
26201							700SS LV-SF VAR S/A ADL - 308 WIN
		301049	502	676	1.000		Cable Lock
		247107	77	405	1.000		BARREL ASSEMBLY
		105442	67	405	1.000		BOLT ASSEMBLY
		97444	100	580	1.000		Bolt Stop
		24475	50	580	1.000		Bolt Stop Pin
		15224	30	580	1.000		Bolt Stop Spring
		993002	250	676	1.000		Box & Envelope Label
		105405	510	585	1.000		Center Guard Screw
		3509	20	676	1.000		Instruction Book
		17017	400	440	1.000		Ejector
		94555	410	440	1.000		Ejector Pin
		17019	420	440	1.000		Ejector Spring
		93712	430	435	1.000		Extractor
		305640	200	580	1.000		Firing Pin Assy
		105401	190	585	1.000		Front Guard Screw
		99402	260	580	1.000		Magazine Assy
		201858	70	585	1.000		Magazine Follower
		91133	80	585	1.000		Magazine Spring
		97438	520	580	1.000		Magazine Tab Screw
		21723	290	600	1.100		PROOF ROUND
		106292	180	585	1.000		Rear Guard Screw
		17034	90	580	4.000		Receiver Plug Screws

Printed on:
~AUTODATE

Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
		1444	10	676	1.000		RF-CF Carton
		24476	60	580	1.000		Sear Pin
		301028	220	585	1.000		Stock Assy
		21485	505	606	2.000		TEST ROUND - 308 WIN 168 gr. HP BT MATCH
		21485	300	606	3.500		TARGET ROUND - 308 WIN 168 gr. HP BT MATCH
		97490	120	580	1.000		Trigger Assy
		97499	170	585	1.000		Trigger Guard
26199							700SS SF VAR L/A - 25-06 REM
		301049	502	676	1.000		Cable Lock
		106319	77	400	1.000		BARREL ASSEMBLY
		105440	67	400	1.000		BOLT ASSEMBLY
		97444	100	580	1.000		Bolt Stop
		24475	50	580	1.000		Bolt Stop Pin
		15224	30	580	1.000		Bolt Stop Spring
		993002	250	676	1.000		Box & Envelope Label
		3509	20	676	1.000		Instruction Book
		17017	400	440	1.000		Ejector
		94555	410	440	1.000		Ejector Pin
		17019	420	440	1.000		Ejector Spring
		1333	280	676	2.000		the foam Insert
		93712	430	435	1.000		Extractor
		305639	200	580	1.000		Firing Pin Assy
		106291	190	585	1.000		Front Guard Screw
		97824	130	580	1.000		Magazine
		90952	70	585	1.000		Magazine Follower
		15677	80	585	1.000		Magazine Spring
		21714	290	606	1.150		PROOF ROUND
		106292	180	585	1.000		Rear Guard Screw
		17034	90	580	4.000		Receiver Plug Screws
		1499	10	676	1.000		RF-CF Carton
		24476	60	580	1.000		Sear Pin
		104711	220	585	1.000		Stock Assy
		21507	505	606	2.000		TEST ROUND 25-06 REM 100 gr.PSPCL
		21507	310	606	3.500		TARGET ROUND 25-06 REM 100 gr.PSPCL
		97490	120	580	1.000		Trigger Assy
		97866	170	585	1.000		Trigger Guard Assy
27506							700SS SF VAR L/A - 7MM REM MAG
		301049	502	676	1.000		Cable Lock
		106320	77	415	1.000		BARREL ASSEMBLY
		105441	67	415	1.000		BOLT ASSEMBLY
		97444	100	580	1.000		Bolt Stop
		24475	50	580	1.000		Bolt Stop Pin
		15224	30	580	1.000		Bolt Stop Spring
		993002	250	676	1.000		Box & Envelope Label

Printed on:
~AUTODATE

Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
		3509	20	676	1.000		Instruction Book
		17017	400	440	1.000		Ejector
		94555	410	440	1.000		Ejector Pin
		17019	420	440	1.000		Ejector Spring
		1333	280	676	2.000		Ethefoam Insert
		97322	430	432	1.000		Extractor
		27341	440	432	1.000		Extractor Rivet
		305639	200	580	1.000		Firing Pin Assy
		106293	190	585	1.000		Front Guard Screw
		97824	130	580	1.000		Magazine
		90952	70	585	1.000		Magazine Follower
		15677	80	585	1.000		Magazine Spring
		21736	290	600	1.100		PROOF ROUND
		106292	180	585	1.000		Rear Guard Screw
		17034	90	580	4.000		Receiver Plug Screws
		1499	10	676	1.000		RF-CF Carton
		24476	60	580	1.000		Sear Pin
		104711	220	585	1.000		Stock Assy
		28821	505	606	2.000		TEST ROUND 7MM REM MAG 140 gr.PSPCL
		28821	310	606	3.500		TARGET ROUND 7MM REM MAG 140 gr.PSPCL
		97490	120	580	1.000		Trigger Assy
		97866	170	585	1.000		Trigger Guard Assy
27502							700SS SF VAR L/A - 7MM STW
		301049	502	676	1.000		Cable Lock
		106322	77	415	1.000		BARREL ASSEMBLY
		105441	67	415	1.000		BOLT ASSEMBLY
		97444	100	580	1.000		Bolt Stop
		24475	50	580	1.000		Bolt Stop Pin
		15224	30	580	1.000		Bolt Stop Spring
		993002	250	676	1.000		Box & Envelope Label
		3509	20	676	1.000		Instruction Book
		17017	400	440	1.000		Ejector
		94555	410	440	1.000		Ejector Pin
		17019	420	440	1.000		Ejector Spring
		1333	280	676	2.000		Ethefoam Insert
		97322	430	432	1.000		Extractor
		27341	440	432	1.000		Extractor Rivet
		305639	200	580	1.000		Firing Pin Assy
		106293	190	585	1.000		Front Guard Screw
		97824	130	580	1.000		Magazine
		90952	70	585	1.000		Magazine Follower
		15677	80	585	1.000		Magazine Spring
		21812	230	600	1.175		PROOF ROUND - 7MM STW
		106292	180	585	1.000		Rear Guard Screw
		17034	90	580	4.000		Receiver Plug Screws

Printed on:
~AUTODATE

Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
		1499	10	676	1.000		RF-CF Carton
		24476	60	580	1.000		Sear Pin
		104711	220	585	1.000		Stock Assy
		28824	505	606	2.000		TEST ROUND - 7MM STW 140 gr.PSPCL
		28824	240	606	3.500		TARGET ROUND - 7MM STW 140 gr.PSPCL
		97490	120	580	1.000		Trigger Assy
		97866	170	585	1.000		Trigger Guard Assy
27508							700SS SF VAR L/A - 300 WIN MAG
		301049	502	676	1.000		Cable Lock
		106321	77	415	1.000		BARREL ASSEMBLY
		105441	67	415	1.000		BOLT ASSEMBLY
		97444	100	580	1.000		Bolt Stop
		24475	50	580	1.000		Bolt Stop Pin
		15224	30	580	1.000		Bolt Stop Spring
		993002	250	676	1.000		Box & Envelope Label
		3509	20	676	1.000		Instruction Book
		17017	400	440	1.000		Ejector
		94555	410	440	1.000		Ejector Pin
		17019	420	440	1.000		Ejector Spring
		1333	280	676	2.000		Ethe foam Insert
		97322	430	432	1.000		Extractor
		27341	440	432	1.000		Extractor Rivet
		305639	200	580	1.000		Firing Pin Assy
		106293	190	580	1.000		Front Guard Screw
		97824	130	580	1.000		Magazine
		90952	70	585	1.000		Magazine Follower
		15677	80	585	1.000		Magazine Spring
		21846	290	606	1.150		PROOF ROUND
		106292	180	585	1.000		Rear Guard Screw
		17034	90	580	4.000		Receiver Plug Screws
		1499	10	676	1.000		RF-CF Carton
		24476	60	580	1.000		Sear Pin
		104711	220	585	1.000		Stock Assy
		29032	505	606	2.000		TEST ROUND 300 WIN MAG 180 gr.PSPCL
		29032	310	606	3.500		TARGET ROUND 300 WIN MAG 180 gr.PSPCL
		97490	120	580	1.000		Trigger Assy
		97866	170	585	1.000		Trigger Guard Assy
27504							700SS SF VAR L/A - 300 WBY MAG
		301049	502	676	1.000		Cable Lock
		106321	77	415	1.000		BARREL ASSEMBLY
		105441	67	415	1.000		BOLT ASSEMBLY
		97444	100	580	1.000		Bolt Stop
		24475	50	580	1.000		Bolt Stop Pin
		15224	30	580	1.000		Bolt Stop Spring

Printed on:
~AUTODATE

Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
		993002	250	676	1.000		Box & Envelope Label
		3509	20	676	1.000		Instruction Book
		17017	400	440	1.000		Ejector
		94555	410	440	1.000		Ejector Pin
		17019	420	440	1.000		Ejector Spring
		1333	280	676	2.000		Ethe foam Insert
		97322	430	432	1.000		Extractor
		27341	440	432	1.000		Extractor Rivet
		305639	200	580	1.000		Firing Pin Assy
		106293	190	585	1.000		Front Guard Screw
		97824	130	580	1.000		Magazine
		90952	70	585	1.000		Magazine Follower
		15677	80	585	1.000		Magazine Spring
		21792	230	600	1.175		PROOF ROUND
		106292	180	585	1.000		Rear Guard Screw
		17034	90	580	4.000		Receiver Plug Screws
		1499	10	676	1.000		RF-CF Carton
		24476	60	580	1.000		Sear Pin
		104711	220	585	1.000		Stock Assy
		29279	505	606	2.000		TEST ROUND 300 WBY MAG 180 gr.PSPCL
		29279	240	606	3.500		TARGET ROUND 300 WBY MAG 180 gr.PSPCL
		97490	120	580	1.000		Trigger Assy
		97866	170	585	1.000		Trigger Guard Assy
26333							VS-SF S/A BDL - 204 RUGER - BLACK FLUTES
		245603	10	405	1.000		BARREL ASSEMBLY
		107765	20	405	1.000		BOLT ASSEMBLY
		97444	30	580	1.000		Bolt Stop
		24475	40	580	1.000		Bolt Stop Pin
		15224	50	580	1.000		Bolt Stop Spring
		993002	60	676	1.000		Box & Envelope Label
		3509	70	676	1.000		Instruction Book
		17017	80	440	1.000		Ejector
		94555	90	440	1.000		Ejector Pin
		17019	100	440	1.000		Ejector Spring
		1333	110	676	2.000		Ethe foam Inserts
		97138	120	435	1.000		Extractor
		305648	130	580	1.000		Firing Pin Assy - FLUTED
		106291	140	585	1.000		Front Guard Screw
		106770	150	580	1.000		Magazine Assy
		92508	160	585	1.000		Magazine Follower
		21133	170	585	1.000		Magazine Spring
		202309	180	600	1.100		PROOF ROUND
		106292	190	585	1.000		Rear Guard Screw
		17034	200	580	4.000		Receiver Plug Screws
		1688	210	676	1.000		RF-CF Carton

Printed on:
~AUTODATE

Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
		24476	220	580	1.000		Sear Pin
		249062	230	585	1.000		Stock Assy
		29218	505	606	2.000		TEST ROUND 204 RUGER 32 gr.ACCU
		29218	240	606	3.500		TARGET ROUND 204 RUGER 32 gr.ACCU
		97490	250	580	1.000		Trigger Assy
		249422	260	585	1.000		Trigger Guard Assy
		301049	270	676	1.000		Cable lock
26339							VS-SF S/A BDL - 220 SWIFT - BLACK FLUTES
		245605	10	405	1.000		BARREL ASSEMBLY
		107767	20	405	1.000		BOLT ASSEMBLY
		97444	30	580	1.000		Bolt Stop
		24475	40	580	1.000		Bolt Stop Pin
		15224	50	580	1.000		Bolt Stop Spring
		993002	60	676	1.000		Box & Envelope Label
		3509	70	676	1.000		Instruction Book
		17017	80	440	1.000		Ejector
		94555	90	440	1.000		Ejector Pin
		17019	100	440	1.000		Ejector Spring
		1333	110	676	2.000		Ethefoam Inserts
		93712	120	435	1.000		Extractor
		305648	130	580	1.000		Firing Pin Assy - FLUTED
		106291	140	585	1.000		Front Guard Screw
		97825	150	580	1.000		Magazine
		90982	160	585	1.000		Magazine Follower
		15699	170	585	1.000		Magazine Spring
		21806	180	600	1.100		PROOF ROUND
		106292	190	585	1.000		Rear Guard Screw
		17034	200	580	4.000		Receiver Plug Screws
		1688	210	676	1.000		RF-CF Carton
		24476	220	580	1.000		Sear Pin
		249062	230	585	1.000		Stock Assy
		21297	505	606	2.000		TEST ROUND 220 SWIFT 50 gr.PSP
		21297	240	606	3.500		TARGET ROUND 220 SWIFT 50 gr.PSP
		97490	250	580	1.000		Trigger Assy
		249422	260	585	1.000		Trigger Guard Assy
		301049	270	676	1.000		Cable lock
26337							VS-SF S/A BDL - 223 REM - BLACK FLUTES
		245604	10	405	1.000		BARREL ASSEMBLY
		107765	20	405	1.000		BOLT ASSEMBLY
		97444	30	580	1.000		Bolt Stop
		24475	40	580	1.000		Bolt Stop Pin
		15224	50	580	1.000		Bolt Stop Spring
		993002	60	676	1.000		Box & Envelope Label
		3509	70	676	1.000		Instruction Book

Printed on:
~AUTODATE

Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
		17017	80	440	1.000		Ejector
		94555	90	440	1.000		Ejector Pin
		17019	100	440	1.000		Ejector Spring
		1333	110	676	2.000		Ethefoam Inserts
		97138	120	435	1.000		Extractor
		305648	130	580	1.000		Firing Pin Assy - FLUTED
		106291	140	585	1.000		Front Guard Screw
		106770	150	580	1.000		Magazine Assy
		92508	160	585	1.000		Magazine Follower
		91133	170	585	1.000		Magazine Spring
		21774	180	600	1.100		PROOF ROUND
		106292	190	585	1.000		Rear Guard Screw
		17034	200	580	4.000		Receiver Plug Screws
		1688	210	676	1.000		RF-CF Carton
		24476	220	580	1.000		Sear Pin
		249062	230	585	1.000		Stock Assy
		28399	505	606	2.000		TEST ROUND 223 REM 55 gr.PSP
		28399	240	606	3.500		TARGET ROUND 223 REM 55 gr.PSP
		97490	250	580	1.000		Trigger Assy
		249422	260	585	1.000		Trigger Guard Assy
		301049	270	676	1.000		Cable lock
26497							VS-SF S/A BDL - 223 REM - BLACK FLUTES
							BLK LAM W/THUMBHOLE
		245604	10	405	1.000		BARREL ASSEMBLY
		107765	20	405	1.000		BOLT ASSEMBLY
		97444	30	580	1.000		Bolt Stop
		24475	40	580	1.000		Bolt Stop Pin
		15224	50	580	1.000		Bolt Stop Spring
		993002	60	676	1.000		Box & Envelope Label
		3509	70	676	1.000		Instruction Book
		17017	80	440	1.000		Ejector
		94555	90	440	1.000		Ejector Pin
		17019	100	440	1.000		Ejector Spring
		1333	110	676	2.000		Ethefoam Inserts
		97138	120	435	1.000		Extractor
		305648	130	580	1.000		Firing Pin Assy - FLUTED
		106291	140	585	1.000		Front Guard Screw
		106770	150	580	1.000		Magazine Assy
		92508	160	585	1.000		Magazine Follower
		91133	170	585	1.000		Magazine Spring
		21774	180	600	1.100		PROOF ROUND
		106292	190	585	1.000		Rear Guard Screw
		17034	200	580	4.000		Receiver Plug Screws
		1688	210	676	1.000		RF-CF Carton
		24476	220	580	1.000		Sear Pin

Printed on:
~AUTODATE

Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
		202706	230	585	1.000		STR ASSY S/A BLK LAM VAR W/THUMBHOLE
		28399	505	606	2.000		TEST ROUND 223 REM 55 gr.PSP
		28399	240	606	3.500		TARGET ROUND 223 REM 55 gr.PSP
		97490	250	580	1.000		Trigger Assy
		249422	260	585	1.000		Trigger Guard Assy
		301049	270	676	1.000		Cable lock
26335							VS-SF S/A BDL - 22-250 REM - BLACK FLUTES
		245606	10	405	1.000		BARREL ASSEMBLY
		107767	20	405	1.000		BOLT ASSEMBLY
		97444	30	580	1.000		Bolt Stop
		24475	40	580	1.000		Bolt Stop Pin
		15224	50	580	1.000		Bolt Stop Spring
		993002	60	676	1.000		Box & Envelope Label
		3509	70	676	1.000		Instruction Book
		17017	80	440	1.000		Ejector
		94555	90	440	1.000		Ejector Pin
		17019	100	440	1.000		Ejector Spring
		1333	110	676	2.000		Ethefoam Inserts
		93712	120	435	1.000		Extractor
		305648	130	580	1.000		Firing Pin Assy - FLUTED
		106291	140	585	1.000		Front Guard Screw
		97825	150	580	1.000		Magazine
		90982	160	585	1.000		Magazine Follower
		15699	170	580	1.000		Magazine Spring
		21853	180	606	1.100		PROOF ROUND
		106292	190	585	1.000		Rear Guard Screw
		17034	200	580	4.000		Receiver Plug Screws
		1688	210	676	1.000		RF-CF Carton
		24476	220	580	1.000		Sear Pin
		249062	230	585	1.000		Stock Assy
		21311	240	606	2.000		TEST ROUND 22-250 REM 55 gr.PSP
		21311	240	606	3.500		TARGET ROUND 22-250 REM 55 gr.PSP
		97490	250	580	1.000		Trigger Assy
		249422	260	585	1.000		Trigger Guard Assy
		301049	270	676	1.000		Cable lock
26499							VS-SF S/A BDL - 22-250 REM - BLACK FLUTES
							BLK LAM W/THUMBHOLE
		245606	10	405	1.000		BARREL ASSEMBLY
		107767	20	405	1.000		BOLT ASSEMBLY
		97444	30	580	1.000		Bolt Stop
		24475	40	580	1.000		Bolt Stop Pin
		15224	50	580	1.000		Bolt Stop Spring
		993002	60	676	1.000		Box & Envelope Label
		3509	70	676	1.000		Instruction Book

Child	Fnd	Oper	Qty	UM	Description
17017	80	440	1.000		Ejector
94555	90	440	1.000		Ejector Pin
17019	100	440	1.000		Ejector Spring
1333	110	676	2.000		Ethefoam Inserts
93712	120	435	1.000		Extractor
305648	130	580	1.000		Firing Pin Assy - FLUTED
106291	140	585	1.000		Front Guard Screw
97825	150	580	1.000		Magazine
90982	160	585	1.000		Magazine Follower
15699	170	585	1.000		Magazine Spring
21853	180	600	1.100		PROOF ROUND
106292	190	585	1.000		Rear Guard Screw
17034	200	580	4.000		Receiver Plug Screws
1688	210	676	1.000		RF-CF Carton
24476	220	580	1.000		Sear Pin
202706	230	585	1.000		STK ASSY S/A BLK LAM VAR W/TH
21311	505	606	2.000		TEST ROUND 22-250 REM 55 gr.P
21311	240	606	3.500		TARGET ROUND 22-250 REM 55 gr
97490	250	580	1.000		Trigger Assy
249422	260	585	1.000		Trigger Guard Assy
301049	270	676	1.000		Cable lock

ative Order - William

ILE00116807

Printed on:
~AUTODATE

[illegible]

Printed on:
~AUTODATE

Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
01	1.0	01	1.0	01	1.0	1.0	01
02	1.0	02	1.0	02	1.0	1.0	02
03	1.0	03	1.0	03	1.0	1.0	03
04	1.0	04	1.0	04	1.0	1.0	04
05	1.0	05	1.0	05	1.0	1.0	05
06	1.0	06	1.0	06	1.0	1.0	06
07	1.0	07	1.0	07	1.0	1.0	07
08	1.0	08	1.0	08	1.0	1.0	08
09	1.0	09	1.0	09	1.0	1.0	09
10	1.0	10	1.0	10	1.0	1.0	10
11	1.0	11	1.0	11	1.0	1.0	11
12	1.0	12	1.0	12	1.0	1.0	12
13	1.0	13	1.0	13	1.0	1.0	13
14	1.0	14	1.0	14	1.0	1.0	14
15	1.0	15	1.0	15	1.0	1.0	15
16	1.0	16	1.0	16	1.0	1.0	16
17	1.0	17	1.0	17	1.0	1.0	17
18	1.0	18	1.0	18	1.0	1.0	18
19	1.0	19	1.0	19	1.0	1.0	19
20	1.0	20	1.0	20	1.0	1.0	20
21	1.0	21	1.0	21	1.0	1.0	21
22	1.0	22	1.0	22	1.0	1.0	22
23	1.0	23	1.0	23	1.0	1.0	23
24	1.0	24	1.0	24	1.0	1.0	24
25	1.0	25	1.0	25	1.0	1.0	25
26	1.0	26	1.0	26	1.0	1.0	26
27	1.0	27	1.0	27	1.0	1.0	27
28	1.0	28	1.0	28	1.0	1.0	28
29	1.0	29	1.0	29	1.0	1.0	29
30	1.0	30	1.0	30	1.0	1.0	30
31	1.0	31	1.0	31	1.0	1.0	31
32	1.0	32	1.0	32	1.0	1.0	32
33	1.0	33	1.0	33	1.0	1.0	33
34	1.0	34	1.0	34	1.0	1.0	34
35	1.0	35	1.0	35	1.0	1.0	35
36	1.0	36	1.0	36	1.0	1.0	36
37	1.0	37	1.0	37	1.0	1.0	37
38	1.0	38	1.0	38	1.0	1.0	38
39	1.0	39	1.0	39	1.0	1.0	39
40	1.0	40	1.0	40	1.0	1.0	40
41	1.0	41	1.0	41	1.0	1.0	41
42	1.0	42	1.0	42	1.0	1.0	42
43	1.0	43	1.0	43	1.0	1.0	43
44	1.0	44	1.0	44	1.0	1.0	44
45	1.0	45	1.0	45	1.0	1.0	45
46	1.0	46	1.0	46	1.0	1.0	46
47	1.0	47	1.0	47	1.0	1.0	47
48	1.0	48	1.0	48	1.0	1.0	48
49	1.0	49	1.0	49	1.0	1.0	49
50	1.0	50	1.0	50	1.0	1.0	50
51	1.0	51	1.0	51	1.0	1.0	51
52	1.0	52	1.0	52	1.0	1.0	52
53	1.0	53	1.0	53	1.0	1.0	53
54	1.0	54	1.0	54	1.0	1.0	54
55	1.0	55	1.0	55	1.0	1.0	55
56	1.0	56	1.0	56	1.0	1.0	56
57	1.0	57	1.0	57	1.0	1.0	57
58	1.0	58	1.0	58	1.0	1.0	58
59	1.0	59	1.0	59	1.0	1.0	59
60	1.0	60	1.0	60	1.0	1.0	60
61	1.0	61	1.0	61	1.0	1.0	61
62	1.0	62	1.0	62	1.0	1.0	62
63	1.0	63	1.0	63	1.0	1.0	63
64	1.0	64	1.0	64	1.0	1.0	64
65	1.0	65	1.0	65	1.0	1.0	65
66	1.0	66	1.0	66	1.0	1.0	66
67	1.0	67	1.0	67	1.0	1.0	67
68	1.0	68	1.0	68	1.0	1.0	68
69	1.0	69	1.0	69	1.0	1.0	69
70	1.0	70	1.0	70	1.0	1.0	70
71	1.0	71	1.0	71	1.0	1.0	71
72	1.0	72	1.0	72	1.0	1.0	72
73	1.0	73	1.0	73	1.0	1.0	73
74	1.0	74	1.0	74	1.0	1.0	74
75	1.0	75	1.0	75	1.0	1.0	75
76	1.0	76	1.0	76	1.0	1.0	76
77	1.0	77	1.0	77	1.0	1.0	77
78	1.0	78	1.0	78	1.0	1.0	78
79	1.0	79	1.0	79	1.0	1.0	79
80	1.0	80	1.0	80	1.0	1.0	80
81	1.0	81	1.0	81	1.0	1.0	81
82	1.0	82	1.0	82	1.0	1.0	82
83	1.0	83	1.0	83	1.0	1.0	83
84	1.0	84	1.0	84	1.0	1.0	84
85	1.0	85	1.0	85	1.0	1.0	85
86	1.0	86	1.0	86	1.0	1.0	86
87	1.0	87	1.0	87	1.0	1.0	87
88	1.0	88	1.0	88	1.0	1.0	88
89	1.0	89	1.0	89	1.0	1.0	89
90	1.0	90	1.0	90	1.0	1.0	90
91	1.0	91	1.0	91	1.0	1.0	91
92	1.0	92	1.0	92	1.0	1.0	92
93	1.0	93	1.0	93	1.0	1.0	93
94	1.0	94	1.0	94	1.0	1.0	94
95	1.0	95	1.0	95	1.0	1.0	95
96	1.0	96	1.0	96	1.0	1.0	96
97	1.0	97	1.0	97	1.0	1.0	97
98	1.0	98	1.0	98	1.0	1.0	98
99	1.0	99	1.0	99	1.0	1.0	99
100	1.0	100	1.0	100	1.0	1.0	100

Printed on:
~AUTODATE

Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
01	1.0	01	1.0	01	1.0	1.0	01
02	1.0	02	1.0	02	1.0	1.0	02
03	1.0	03	1.0	03	1.0	1.0	03
04	1.0	04	1.0	04	1.0	1.0	04
05	1.0	05	1.0	05	1.0	1.0	05
06	1.0	06	1.0	06	1.0	1.0	06
07	1.0	07	1.0	07	1.0	1.0	07
08	1.0	08	1.0	08	1.0	1.0	08
09	1.0	09	1.0	09	1.0	1.0	09
10	1.0	10	1.0	10	1.0	1.0	10
11	1.0	11	1.0	11	1.0	1.0	11
12	1.0	12	1.0	12	1.0	1.0	12
13	1.0	13	1.0	13	1.0	1.0	13
14	1.0	14	1.0	14	1.0	1.0	14
15	1.0	15	1.0	15	1.0	1.0	15
16	1.0	16	1.0	16	1.0	1.0	16
17	1.0	17	1.0	17	1.0	1.0	17
18	1.0	18	1.0	18	1.0	1.0	18
19	1.0	19	1.0	19	1.0	1.0	19
20	1.0	20	1.0	20	1.0	1.0	20
21	1.0	21	1.0	21	1.0	1.0	21
22	1.0	22	1.0	22	1.0	1.0	22
23	1.0	23	1.0	23	1.0	1.0	23
24	1.0	24	1.0	24	1.0	1.0	24
25	1.0	25	1.0	25	1.0	1.0	25
26	1.0	26	1.0	26	1.0	1.0	26
27	1.0	27	1.0	27	1.0	1.0	27
28	1.0	28	1.0	28	1.0	1.0	28
29	1.0	29	1.0	29	1.0	1.0	29
30	1.0	30	1.0	30	1.0	1.0	30
31	1.0	31	1.0	31	1.0	1.0	31
32	1.0	32	1.0	32	1.0	1.0	32
33	1.0	33	1.0	33	1.0	1.0	33
34	1.0	34	1.0	34	1.0	1.0	34
35	1.0	35	1.0	35	1.0	1.0	35
36	1.0	36	1.0	36	1.0	1.0	36
37	1.0	37	1.0	37	1.0	1.0	37
38	1.0	38	1.0	38	1.0	1.0	38
39	1.0	39	1.0	39	1.0	1.0	39
40	1.0	40	1.0	40	1.0	1.0	40
41	1.0	41	1.0	41	1.0	1.0	41
42	1.0	42	1.0	42	1.0	1.0	42
43	1.0	43	1.0	43	1.0	1.0	43
44	1.0	44	1.0	44	1.0	1.0	44
45	1.0	45	1.0	45	1.0	1.0	45
46	1.0	46	1.0	46	1.0	1.0	46
47	1.0	47	1.0	47	1.0	1.0	47
48	1.0	48	1.0	48	1.0	1.0	48
49	1.0	49	1.0	49	1.0	1.0	49
50	1.0	50	1.0	50	1.0	1.0	50
51	1.0	51	1.0	51	1.0	1.0	51
52	1.0	52	1.0	52	1.0	1.0	52
53	1.0	53	1.0	53	1.0	1.0	53
54	1.0	54	1.0	54	1.0	1.0	54
55	1.0	55	1.0	55	1.0	1.0	55
56	1.0	56	1.0	56	1.0	1.0	56
57	1.0	57	1.0	57	1.0	1.0	57
58	1.0	58	1.0	58	1.0	1.0	58
59	1.0	59	1.0	59	1.0	1.0	59
60	1.0	60	1.0	60	1.0	1.0	60
61	1.0	61	1.0	61	1.0	1.0	61
62	1.0	62	1.0	62	1.0	1.0	62
63	1.0	63	1.0	63	1.0	1.0	63
64	1.0	64	1.0	64	1.0	1.0	64
65	1.0	65	1.0	65	1.0	1.0	65
66	1.0	66	1.0	66	1.0	1.0	66
67	1.0	67	1.0	67	1.0	1.0	67
68	1.0	68	1.0	68	1.0	1.0	68
69	1.0	69	1.0	69	1.0	1.0	69
70	1.0	70	1.0	70	1.0	1.0	70
71	1.0	71	1.0	71	1.0	1.0	71
72	1.0	72	1.0	72	1.0	1.0	72
73	1.0	73	1.0	73	1.0	1.0	73
74	1.0	74	1.0	74	1.0	1.0	74
75	1.0	75	1.0	75	1.0	1.0	75
76	1.0	76	1.0	76	1.0	1.0	76
77	1.0	77	1.0	77	1.0	1.0	77
78	1.0	78	1.0	78	1.0	1.0	78
79	1.0	79	1.0	79	1.0	1.0	79
80	1.0	80	1.0	80	1.0	1.0	80
81	1.0	81	1.0	81	1.0	1.0	81
82	1.0	82	1.0	82	1.0	1.0	82
83	1.0	83	1.0	83	1.0	1.0	83
84	1.0	84	1.0	84	1.0	1.0	84
85	1.0	85	1.0	85	1.0	1.0	85
86	1.0	86	1.0	86	1.0	1.0	86
87	1.0	87	1.0	87	1.0	1.0	87
88	1.0	88	1.0	88	1.0	1.0	88
89	1.0	89	1.0	89	1.0	1.0	89
90	1.0	90	1.0	90	1.0	1.0	90
91	1.0	91	1.0	91	1.0	1.0	91
92	1.0	92	1.0	92	1.0	1.0	92
93	1.0	93	1.0	93	1.0	1.0	93
94	1.0	94	1.0	94	1.0	1.0	94
95	1.0	95	1.0	95	1.0	1.0	95
96	1.0	96	1.0	96	1.0	1.0	96
97	1.0	97	1.0	97	1.0	1.0	97
98	1.0	98	1.0	98	1.0	1.0	98
99	1.0	99	1.0	99	1.0	1.0	99
100	1.0	100	1.0	100	1.0	1.0	100

Printed on:
~AUTODATE

Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
01	1.0	01	1.0	01	1.0	1.0	01
02	1.0	02	1.0	02	1.0	1.0	02
03	1.0	03	1.0	03	1.0	1.0	03
04	1.0	04	1.0	04	1.0	1.0	04
05	1.0	05	1.0	05	1.0	1.0	05
06	1.0	06	1.0	06	1.0	1.0	06
07	1.0	07	1.0	07	1.0	1.0	07
08	1.0	08	1.0	08	1.0	1.0	08
09	1.0	09	1.0	09	1.0	1.0	09
10	1.0	10	1.0	10	1.0	1.0	10
11	1.0	11	1.0	11	1.0	1.0	11
12	1.0	12	1.0	12	1.0	1.0	12
13	1.0	13	1.0	13	1.0	1.0	13
14	1.0	14	1.0	14	1.0	1.0	14
15	1.0	15	1.0	15	1.0	1.0	15
16	1.0	16	1.0	16	1.0	1.0	16
17	1.0	17	1.0	17	1.0	1.0	17
18	1.0	18	1.0	18	1.0	1.0	18
19	1.0	19	1.0	19	1.0	1.0	19
20	1.0	20	1.0	20	1.0	1.0	20
21	1.0	21	1.0	21	1.0	1.0	21
22	1.0	22	1.0	22	1.0	1.0	22
23	1.0	23	1.0	23	1.0	1.0	23
24	1.0	24	1.0	24	1.0	1.0	24
25	1.0	25	1.0	25	1.0	1.0	25
26	1.0	26	1.0	26	1.0	1.0	26
27	1.0	27	1.0	27	1.0	1.0	27
28	1.0	28	1.0	28	1.0	1.0	28
29	1.0	29	1.0	29	1.0	1.0	29
30	1.0	30	1.0	30	1.0	1.0	30
31	1.0	31	1.0	31	1.0	1.0	31
32	1.0	32	1.0	32	1.0	1.0	32
33	1.0	33	1.0	33	1.0	1.0	33
34	1.0	34	1.0	34	1.0	1.0	34
35	1.0	35	1.0	35	1.0	1.0	35
36	1.0	36	1.0	36	1.0	1.0	36
37	1.0	37	1.0	37	1.0	1.0	37
38	1.0	38	1.0	38	1.0	1.0	38
39	1.0	39	1.0	39	1.0	1.0	39
40	1.0	40	1.0	40	1.0	1.0	40
41	1.0	41	1.0	41	1.0	1.0	41
42	1.0	42	1.0	42	1.0	1.0	42
43	1.0	43	1.0	43	1.0	1.0	43
44	1.0	44	1.0	44	1.0	1.0	44
45	1.0	45	1.0	45	1.0	1.0	45
46	1.0	46	1.0	46	1.0	1.0	46
47	1.0	47	1.0	47	1.0	1.0	47
48	1.0	48	1.0	48	1.0	1.0	48
49	1.0	49	1.0	49	1.0	1.0	49
50	1.0	50	1.0	50	1.0	1.0	50
51	1.0	51	1.0	51	1.0	1.0	51
52	1.0	52	1.0	52	1.0	1.0	52
53	1.0	53	1.0	53	1.0	1.0	53
54	1.0	54	1.0	54	1.0	1.0	54
55	1.0	55	1.0	55	1.0	1.0	55
56	1.0	56	1.0	56	1.0	1.0	56
57	1.0	57	1.0	57	1.0	1.0	57
58	1.0	58	1.0	58	1.0	1.0	58
59	1.0	59	1.0	59	1.0	1.0	59
60	1.0	60	1.0	60	1.0	1.0	60
61	1.0	61	1.0	61	1.0	1.0	61
62	1.0	62	1.0	62	1.0	1.0	62
63	1.0	63	1.0	63	1.0	1.0	63
64	1.0	64	1.0	64	1.0	1.0	64
65	1.0	65	1.0	65	1.0	1.0	65
66	1.0	66	1.0	66	1.0	1.0	66
67	1.0	67	1.0	67	1.0	1.0	67
68	1.0	68	1.0	68	1.0	1.0	68
69	1.0	69	1.0	69	1.0	1.0	69
70	1.0	70	1.0	70	1.0	1.0	70
71	1.0	71	1.0	71	1.0	1.0	71
72	1.0	72	1.0	72	1.0	1.0	72
73	1.0	73	1.0	73	1.0	1.0	73
74	1.0	74	1.0	74	1.0	1.0	74
75	1.0	75	1.0	75	1.0	1.0	75
76	1.0	76	1.0	76	1.0	1.0	76
77	1.0	77	1.0	77	1.0	1.0	77
78	1.0	78	1.0	78	1.0	1.0	78
79	1.0	79	1.0	79	1.0	1.0	79
80	1.0	80	1.0	80	1.0	1.0	80
81	1.0	81	1.0	81	1.0	1.0	81
82	1.0	82	1.0	82	1.0	1.0	82
83	1.0	83	1.0	83	1.0	1.0	83
84	1.0	84	1.0	84	1.0	1.0	84
85	1.0	85	1.0	85	1.0	1.0	85
86	1.0	86	1.0	86	1.0	1.0	86
87	1.0	87	1.0	87	1.0	1.0	87
88	1.0	88	1.0	88	1.0	1.0	88
89	1.0	89	1.0	89	1.0	1.0	89
90	1.0	90	1.0	90	1.0	1.0	90
91	1.0	91	1.0	91	1.0	1.0	91
92	1.0	92	1.0	92	1.0	1.0	92
93	1.0	93	1.0	93	1.0	1.0	93
94	1.0	94	1.0	94	1.0	1.0	94
95	1.0	95	1.0	95	1.0	1.0	95
96	1.0	96	1.0	96	1.0	1.0	96
97	1.0	97	1.0	97	1.0	1.0	97
98	1.0	98	1.0	98	1.0	1.0	98
99	1.0	99	1.0	99	1.0	1.0	99
100	1.0	100	1.0	100	1.0	1.0	100

Printed on:
~AUTODATE

[illegible]

Printed on:
~AUTODATE

Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
01	1.0	01	1.0	01	1.0	1.0	01
02	1.0	02	1.0	02	1.0	1.0	02
03	1.0	03	1.0	03	1.0	1.0	03
04	1.0	04	1.0	04	1.0	1.0	04
05	1.0	05	1.0	05	1.0	1.0	05
06	1.0	06	1.0	06	1.0	1.0	06
07	1.0	07	1.0	07	1.0	1.0	07
08	1.0	08	1.0	08	1.0	1.0	08
09	1.0	09	1.0	09	1.0	1.0	09
10	1.0	10	1.0	10	1.0	1.0	10
11	1.0	11	1.0	11	1.0	1.0	11
12	1.0	12	1.0	12	1.0	1.0	12
13	1.0	13	1.0	13	1.0	1.0	13
14	1.0	14	1.0	14	1.0	1.0	14
15	1.0	15	1.0	15	1.0	1.0	15
16	1.0	16	1.0	16	1.0	1.0	16
17	1.0	17	1.0	17	1.0	1.0	17
18	1.0	18	1.0	18	1.0	1.0	18
19	1.0	19	1.0	19	1.0	1.0	19
20	1.0	20	1.0	20	1.0	1.0	20
21	1.0	21	1.0	21	1.0	1.0	21
22	1.0	22	1.0	22	1.0	1.0	22
23	1.0	23	1.0	23	1.0	1.0	23
24	1.0	24	1.0	24	1.0	1.0	24
25	1.0	25	1.0	25	1.0	1.0	25
26	1.0	26	1.0	26	1.0	1.0	26
27	1.0	27	1.0	27	1.0	1.0	27
28	1.0	28	1.0	28	1.0	1.0	28
29	1.0	29	1.0	29	1.0	1.0	29
30	1.0	30	1.0	30	1.0	1.0	30
31	1.0	31	1.0	31	1.0	1.0	31
32	1.0	32	1.0	32	1.0	1.0	32
33	1.0	33	1.0	33	1.0	1.0	33
34	1.0	34	1.0	34	1.0	1.0	34
35	1.0	35	1.0	35	1.0	1.0	35
36	1.0	36	1.0	36	1.0	1.0	36
37	1.0	37	1.0	37	1.0	1.0	37
38	1.0	38	1.0	38	1.0	1.0	38
39	1.0	39	1.0	39	1.0	1.0	39
40	1.0	40	1.0	40	1.0	1.0	40
41	1.0	41	1.0	41	1.0	1.0	41
42	1.0	42	1.0	42	1.0	1.0	42
43	1.0	43	1.0	43	1.0	1.0	43
44	1.0	44	1.0	44	1.0	1.0	44
45	1.0	45	1.0	45	1.0	1.0	45
46	1.0	46	1.0	46	1.0	1.0	46
47	1.0	47	1.0	47	1.0	1.0	47
48	1.0	48	1.0	48	1.0	1.0	48
49	1.0	49	1.0	49	1.0	1.0	49
50	1.0	50	1.0	50	1.0	1.0	50
51	1.0	51	1.0	51	1.0	1.0	51
52	1.0	52	1.0	52	1.0	1.0	52
53	1.0	53	1.0	53	1.0	1.0	53
54	1.0	54	1.0	54	1.0	1.0	54
55	1.0	55	1.0	55	1.0	1.0	55
56	1.0	56	1.0	56	1.0	1.0	56
57	1.0	57	1.0	57	1.0	1.0	57
58	1.0	58	1.0	58	1.0	1.0	58
59	1.0	59	1.0	59	1.0	1.0	59
60	1.0	60	1.0	60	1.0	1.0	60
61	1.0	61	1.0	61	1.0	1.0	61
62	1.0	62	1.0	62	1.0	1.0	62
63	1.0	63	1.0	63	1.0	1.0	63
64	1.0	64	1.0	64	1.0	1.0	64
65	1.0	65	1.0	65	1.0	1.0	65
66	1.0	66	1.0	66	1.0	1.0	66
67	1.0	67	1.0	67	1.0	1.0	67
68	1.0	68	1.0	68	1.0	1.0	68
69	1.0	69	1.0	69	1.0	1.0	69
70	1.0	70	1.0	70	1.0	1.0	70
71	1.0	71	1.0	71	1.0	1.0	71
72	1.0	72	1.0	72	1.0	1.0	72
73	1.0	73	1.0	73	1.0	1.0	73
74	1.0	74	1.0	74	1.0	1.0	74
75	1.0	75	1.0	75	1.0	1.0	75
76	1.0	76	1.0	76	1.0	1.0	76
77	1.0	77	1.0	77	1.0	1.0	77
78	1.0	78	1.0	78	1.0	1.0	78
79	1.0	79	1.0	79	1.0	1.0	79
80	1.0	80	1.0	80	1.0	1.0	80
81	1.0	81	1.0	81	1.0	1.0	81
82	1.0	82	1.0	82	1.0	1.0	82
83	1.0	83	1.0	83	1.0	1.0	83
84	1.0	84	1.0	84	1.0	1.0	84
85	1.0	85	1.0	85	1.0	1.0	85
86	1.0	86	1.0	86	1.0	1.0	86
87	1.0	87	1.0	87	1.0	1.0	87
88	1.0	88	1.0	88	1.0	1.0	88
89	1.0	89	1.0	89	1.0	1.0	89
90	1.0	90	1.0	90	1.0	1.0	90
91	1.0	91	1.0	91	1.0	1.0	91
92	1.0	92	1.0	92	1.0	1.0	92
93	1.0	93	1.0	93	1.0	1.0	93
94	1.0	94	1.0	94	1.0	1.0	94
95	1.0	95	1.0	95	1.0	1.0	95
96	1.0	96	1.0	96	1.0	1.0	96
97	1.0	97	1.0	97	1.0	1.0	97
98	1.0	98	1.0	98	1.0	1.0	98
99	1.0	99	1.0	99	1.0	1.0	99
100	1.0	100	1.0	100	1.0	1.0	100

Printed on:
~AUTODATE

[illegible]

Printed on:
~AUTODATE

Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
01	1.0	01	1.0	01	1.0	01	
02	1.0	02	1.0	02	1.0	02	
03	1.0	03	1.0	03	1.0	03	
04	1.0	04	1.0	04	1.0	04	
05	1.0	05	1.0	05	1.0	05	
06	1.0	06	1.0	06	1.0	06	
07	1.0	07	1.0	07	1.0	07	
08	1.0	08	1.0	08	1.0	08	
09	1.0	09	1.0	09	1.0	09	
10	1.0	10	1.0	10	1.0	10	
11	1.0	11	1.0	11	1.0	11	
12	1.0	12	1.0	12	1.0	12	
13	1.0	13	1.0	13	1.0	13	
14	1.0	14	1.0	14	1.0	14	
15	1.0	15	1.0	15	1.0	15	
16	1.0	16	1.0	16	1.0	16	
17	1.0	17	1.0	17	1.0	17	
18	1.0	18	1.0	18	1.0	18	
19	1.0	19	1.0	19	1.0	19	
20	1.0	20	1.0	20	1.0	20	
21	1.0	21	1.0	21	1.0	21	
22	1.0	22	1.0	22	1.0	22	
23	1.0	23	1.0	23	1.0	23	
24	1.0	24	1.0	24	1.0	24	
25	1.0	25	1.0	25	1.0	25	
26	1.0	26	1.0	26	1.0	26	
27	1.0	27	1.0	27	1.0	27	
28	1.0	28	1.0	28	1.0	28	
29	1.0	29	1.0	29	1.0	29	
30	1.0	30	1.0	30	1.0	30	
31	1.0	31	1.0	31	1.0	31	
32	1.0	32	1.0	32	1.0	32	
33	1.0	33	1.0	33	1.0	33	
34	1.0	34	1.0	34	1.0	34	
35	1.0	35	1.0	35	1.0	35	
36	1.0	36	1.0	36	1.0	36	
37	1.0	37	1.0	37	1.0	37	
38	1.0	38	1.0	38	1.0	38	
39	1.0	39	1.0	39	1.0	39	
40	1.0	40	1.0	40	1.0	40	
41	1.0	41	1.0	41	1.0	41	
42	1.0	42	1.0	42	1.0	42	
43	1.0	43	1.0	43	1.0	43	
44	1.0	44	1.0	44	1.0	44	
45	1.0	45	1.0	45	1.0	45	
46	1.0	46	1.0	46	1.0	46	
47	1.0	47	1.0	47	1.0	47	
48	1.0	48	1.0	48	1.0	48	
49	1.0	49	1.0	49	1.0	49	
50	1.0	50	1.0	50	1.0	50	
51	1.0	51	1.0	51	1.0	51	
52	1.0	52	1.0	52	1.0	52	
53	1.0	53	1.0	53	1.0	53	
54	1.0	54	1.0	54	1.0	54	
55	1.0	55	1.0	55	1.0	55	
56	1.0	56	1.0	56	1.0	56	
57	1.0	57	1.0	57	1.0	57	
58	1.0	58	1.0	58	1.0	58	
59	1.0	59	1.0	59	1.0	59	
60	1.0	60	1.0	60	1.0	60	
61	1.0	61	1.0	61	1.0	61	
62	1.0	62	1.0	62	1.0	62	
63	1.0	63	1.0	63	1.0	63	
64	1.0	64	1.0	64	1.0	64	
65	1.0	65	1.0	65	1.0	65	
66	1.0	66	1.0	66	1.0	66	
67	1.0	67	1.0	67	1.0	67	
68	1.0	68	1.0	68	1.0	68	
69	1.0	69	1.0	69	1.0	69	
70	1.0	70	1.0	70	1.0	70	
71	1.0	71	1.0	71	1.0	71	
72	1.0	72	1.0	72	1.0	72	
73	1.0	73	1.0	73	1.0	73	
74	1.0	74	1.0	74	1.0	74	
75	1.0	75	1.0	75	1.0	75	
76	1.0	76	1.0	76	1.0	76	
77	1.0	77	1.0	77	1.0	77	
78	1.0	78	1.0	78	1.0	78	
79	1.0	79	1.0	79	1.0	79	
80	1.0	80	1.0	80	1.0	80	
81	1.0	81	1.0	81	1.0	81	
82	1.0	82	1.0	82	1.0	82	
83	1.0	83	1.0	83	1.0	83	
84	1.0	84	1.0	84	1.0	84	
85	1.0	85	1.0	85	1.0	85	
86	1.0	86	1.0	86	1.0	86	
87	1.0	87	1.0	87	1.0	87	
88	1.0	88	1.0	88	1.0	88	
89	1.0	89	1.0	89	1.0	89	
90	1.0	90	1.0	90	1.0	90	
91	1.0	91	1.0	91	1.0	91	
92	1.0	92	1.0	92	1.0	92	
93	1.0	93	1.0	93	1.0	93	
94	1.0	94	1.0	94	1.0	94	
95	1.0	95	1.0	95	1.0	95	
96	1.0	96	1.0	96	1.0	96	
97	1.0	97	1.0	97	1.0	97	
98	1.0	98	1.0	98	1.0	98	
99	1.0	99	1.0	99	1.0	99	
100	1.0	100	1.0	100	1.0	100	

Printed on:
~AUTODATE

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

Printed on:
~AUTODATE

Parent	Rv	Child	Fnd	Oper	Qty	UM	Description
01	1.0	01	1.0	01	1.0	1.0	01
02	1.0	02	1.0	02	1.0	1.0	02
03	1.0	03	1.0	03	1.0	1.0	03
04	1.0	04	1.0	04	1.0	1.0	04
05	1.0	05	1.0	05	1.0	1.0	05
06	1.0	06	1.0	06	1.0	1.0	06
07	1.0	07	1.0	07	1.0	1.0	07
08	1.0	08	1.0	08	1.0	1.0	08
09	1.0	09	1.0	09	1.0	1.0	09
10	1.0	10	1.0	10	1.0	1.0	10
11	1.0	11	1.0	11	1.0	1.0	11
12	1.0	12	1.0	12	1.0	1.0	12
13	1.0	13	1.0	13	1.0	1.0	13
14	1.0	14	1.0	14	1.0	1.0	14
15	1.0	15	1.0	15	1.0	1.0	15
16	1.0	16	1.0	16	1.0	1.0	16
17	1.0	17	1.0	17	1.0	1.0	17
18	1.0	18	1.0	18	1.0	1.0	18
19	1.0	19	1.0	19	1.0	1.0	19
20	1.0	20	1.0	20	1.0	1.0	20
21	1.0	21	1.0	21	1.0	1.0	21
22	1.0	22	1.0	22	1.0	1.0	22
23	1.0	23	1.0	23	1.0	1.0	23
24	1.0	24	1.0	24	1.0	1.0	24
25	1.0	25	1.0	25	1.0	1.0	25
26	1.0	26	1.0	26	1.0	1.0	26
27	1.0	27	1.0	27	1.0	1.0	27
28	1.0	28	1.0	28	1.0	1.0	28
29	1.0	29	1.0	29	1.0	1.0	29
30	1.0	30	1.0	30	1.0	1.0	30
31	1.0	31	1.0	31	1.0	1.0	31
32	1.0	32	1.0	32	1.0	1.0	32
33	1.0	33	1.0	33	1.0	1.0	33
34	1.0	34	1.0	34	1.0	1.0	34
35	1.0	35	1.0	35	1.0	1.0	35
36	1.0	36	1.0	36	1.0	1.0	36
37	1.0	37	1.0	37	1.0	1.0	37
38	1.0	38	1.0	38	1.0	1.0	38
39	1.0	39	1.0	39	1.0	1.0	39
40	1.0	40	1.0	40	1.0	1.0	40
41	1.0	41	1.0	41	1.0	1.0	41
42	1.0	42	1.0	42	1.0	1.0	42
43	1.0	43	1.0	43	1.0	1.0	43
44	1.0	44	1.0	44	1.0	1.0	44
45	1.0	45	1.0	45	1.0	1.0	45
46	1.0	46	1.0	46	1.0	1.0	46
47	1.0	47	1.0	47	1.0	1.0	47
48	1.0	48	1.0	48	1.0	1.0	48
49	1.0	49	1.0	49	1.0	1.0	49
50	1.0	50	1.0	50	1.0	1.0	50
51	1.0	51	1.0	51	1.0	1.0	51
52	1.0	52	1.0	52	1.0	1.0	52
53	1.0	53	1.0	53	1.0	1.0	53
54	1.0	54	1.0	54	1.0	1.0	54
55	1.0	55	1.0	55	1.0	1.0	55
56	1.0	56	1.0	56	1.0	1.0	56
57	1.0	57	1.0	57	1.0	1.0	57
58	1.0	58	1.0	58	1.0	1.0	58
59	1.0	59	1.0	59	1.0	1.0	59
60	1.0	60	1.0	60	1.0	1.0	60
61	1.0	61	1.0	61	1.0	1.0	61
62	1.0	62	1.0	62	1.0	1.0	62
63	1.0	63	1.0	63	1.0	1.0	63
64	1.0	64	1.0	64	1.0	1.0	64
65	1.0	65	1.0	65	1.0	1.0	65
66	1.0	66	1.0	66	1.0	1.0	66
67	1.0	67	1.0	67	1.0	1.0	67
68	1.0	68	1.0	68	1.0	1.0	68
69	1.0	69	1.0	69	1.0	1.0	69
70	1.0	70	1.0	70	1.0	1.0	70
71	1.0	71	1.0	71	1.0	1.0	71
72	1.0	72	1.0	72	1.0	1.0	72
73	1.0	73	1.0	73	1.0	1.0	73
74	1.0	74	1.0	74	1.0	1.0	74
75	1.0	75	1.0	75	1.0	1.0	75
76	1.0	76	1.0	76	1.0	1.0	76
77	1.0	77	1.0	77	1.0	1.0	77
78	1.0	78	1.0	78	1.0	1.0	78
79	1.0	79	1.0	79	1.0	1.0	79
80	1.0	80	1.0	80	1.0	1.0	80
81	1.0	81	1.0	81	1.0	1.0	81
82	1.0	82	1.0	82	1.0	1.0	82
83	1.0	83	1.0	83	1.0	1.0	83
84	1.0	84	1.0	84	1.0	1.0	84
85	1.0	85	1.0	85	1.0	1.0	85
86	1.0	86	1.0	86	1.0	1.0	86
87	1.0	87	1.0	87	1.0	1.0	87
88	1.0	88	1.0	88	1.0	1.0	88
89	1.0	89	1.0	89	1.0	1.0	89
90	1.0	90	1.0	90	1.0	1.0	90
91	1.0	91	1.0	91	1.0	1.0	91
92	1.0	92	1.0	92	1.0	1.0	92
93	1.0	93	1.0	93	1.0	1.0	93
94	1.0	94	1.0	94	1.0	1.0	94
95	1.0	95	1.0	95	1.0	1.0	95
96	1.0	96	1.0	96	1.0	1.0	96
97	1.0	97	1.0	97	1.0	1.0	97
98	1.0	98	1.0	98	1.0	1.0	98
99	1.0	99	1.0	99	1.0	1.0	99
100	1.0	100	1.0	100	1.0	1.0	100

Printed on:
~AUTODATE

[illegible]

Printed on:
~AUTODATE

[illegible]

Printed on:
~AUTODATE

CONFIDENTIAL

Printed on:
~AUTODATE

CONFIDENTIAL

Printed on:
~AUTODATE

CONFIDENTIAL

Printed on:
~AUTODATE

CONFIDENTIAL

Printed on:
~AUTODATE

CONFIDENTIAL

Printed on:
~AUTODATE

CONFIDENTIAL

Printed on:
~AUTODATE

CONFIDENTIAL

Printed on:
~AUTODATE

CONFIDENTIAL

Printed on:
~AUTODATE

CONFIDENTIAL

Printed on:
~AUTODATE

CONFIDENTIAL

Printed on:
~AUTODATE

CONFIDENTIAL

Printed on:
~AUTODATE

CONFIDENTIAL

Printed on:
~AUTODATE

CONFIDENTIAL

Printed on:
~AUTODATE

CONFIDENTIAL

Printed on:
~AUTODATE

CONFIDENTIAL

Printed on:
~AUTODATE

CONFIDENTIAL

Printed on:
~AUTODATE

CONFIDENTIAL

Printed on:
~AUTODATE

CONFIDENTIAL

Printed on:
~AUTODATE

CONFIDENTIAL

Printed on:
~AUTODATE

CONFIDENTIAL

Printed on:
~AUTODATE

CONFIDENTIAL

Printed on:
~AUTODATE

CONFIDENTIAL

Printed on:
~AUTODATE

CONFIDENTIAL

Printed on:
~AUTODATE

CONFIDENTIAL

Printed on:
~AUTODATE

CONFIDENTIAL

Printed on:
~AUTODATE

CONFIDENTIAL

Printed on:
~AUTODATE

CONFIDENTIAL

Printed on:
~AUTODATE

CONFIDENTIAL

Printed on:
~AUTODATE

CONFIDENTIAL

Printed on:
~AUTODATE

CONFIDENTIAL

Printed on:
~AUTODATE

CONFIDENTIAL

Printed on:
~AUTODATE

10
11
12
13
14
15
16
17
18
19
20
21
22
23
24
25
26
27
28
29
30
31
32
33
34
35
36
37
38
39
40
41
42
43
44
45
46
47
48
49
50
51
52
53
54
55
56
57
58
59
60
61
62
63
64
65
66
67
68
69
70
71
72
73
74
75
76
77
78
79
80
81
82
83
84
85
86
87
88
89
90
91
92
93
94
95
96
97
98
99
100

CONFIDENTIAL

Printed on:
~AUTODATE

Date:	Reason for Revision:	Eng:	Log #:
18-Jun-01	Copied entire process from VAXcamps #304475	RLJ	304220
24-Aug-01	4.5 to 5.5 lb trigger pull was 4 to 5 pounds. - EBN 305059	RLJ	305059
07-Sep-01	Added muzzle re-chamfering instructions & tools at target.	RFL	305064
11-Oct-01	Replaced F1721 Doc Envelope Assy with 3509 Instruction Book.	RLJ	305075
04-Apr-02	Trigger pull 4.5 to 6.5 was 4.5 to 5.5	RLJ	305777
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	307052
17-Jul-02	17 Cal Ammo SKU 28460 was 28463.	RLJ	306825
11-Mar-03	Updated to current practice (details only) Updated	ERF	307607
26-Mar-03	ADD RAMAC#26183 - 700SS LV-SF VAR S/A ADL - 17 REM ADD RAMAC#26185 - 700SS LV-SF VAR S/A ADL - 221 F-BALL ADD RAMAC#26187 - 700SS LV-SF VAR S/A ADL - 223 REM ADD RAMAC#26189 - 700SS LV-SF VAR S/A ADL - 22-250 REM	GLC	308970
17-Jun-03	Ramac 26189 - Magazine Box 97755 was 97825	ERF	308002
13-Nov-03	ADD RAMAC#26191 - 700SS LV-SF VAR S/A ADL - 243 WIN ADD RAMAC#26194 - 700SS LV-SF VAR S/A ADL - 7MM-08 REM	GLC	310734
22-Dec-03	ADDED RAMAC 26196 - 700SS LV-SF VAR S/A ADL - 204 RUGER;	JLP	310635
15-Mar-04	ADD RAMAC#26201 - 700SS LV-SF VAR S/A ADL - 308 WIN	GLC	311438
24-Mar-04	RAMAC#26187 - Magazine Spring PT#202370 WAS 91133 Magazine Follower PT#202369 WAS 92508	GLC	311455
08-Apr-04	AMMO CHANGE RAMAC 7508 TO 180PSPCL FROM 150PSPCL	ERF	308022
02-Jun-04	ADD RAMAC#26333 - VS-SF S/A BDL - 204 RUGER - BLACK FLUTES ADD RAMAC#26339 - VS-SF S/A BDL - 220 SWIFT - BLACK FLUTES ADD RAMAC#26337 - VS-SF S/A BDL - 223 REM - BLACK FLUTES	GLC	311845

Printed on:
~AUTODATE

Date:	Reason for Revision:	Eng:	Log #:
	ADD RAMAC#26335 - VS-SF S/A BDL - 22-250 REM - BLACK FLUTES		
06-Jun-04	On 26201 Mag Follower 201858 was 90982 and Mag Spring 17891 was 15699.	RLJ	311850
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. 109581 now 305639, 109582 now 305640.	RLJ	311851
26-Jul-04	Trigger pull 4.75 to 5.75 pounds was 4.5 to 5.5 pounds. Trigger pull revised to compensate for a change in the direction of pull. - 4.5 pounds Min was used when trigger pull was measured in the direction of the top of the stock comb. - New SAAMI trigger pull standard requires the trigger to be pulled parallel to the centerline of the barrel. This results in the minimum trigger pull being changed to 4.75 pounds and the maximum trigger pull being changed to 5.75 pounds.	RLJ	311856
26-Jul-04	Added cable lock 301049, removed ISS Gunlock keys (2) 201207, removed procedure for checking gunlock function and added 35 in-lb spec for takedown screw.	RLJ	311858
12-Aug-04	RAMAC#26333 - BOLT ASSEMBLY PT#107765 WAS 105443 Firing Pin Assy - FLUTED PT#305648 WAS 305640 RAMAC#26335 - BOLT ASSEMBLY PT#107767 WAS 105442 Firing Pin Assy - FLUTED PT#305648 WAS 305640 RAMAC#26337 - BOLT ASSEMBLY PT#107765 WAS 105443 Firing Pin Assy - FLUTED PT#305648 WAS 305640 RAMAC#26339 - BOLT ASSEMBLY PT#107767 WAS 105442 Firing Pin Assy - FLUTED PT#305648 WAS 305640	GLC	312445
20-Aug-04	RAMAC#26185 - Test Round 221 FIREBALL 50 ACCUTIP BT PT#29172 WAS Test Round 221 Rem Fireball 50 Gr VMax PT#29306	GLC	312569
08-Sep-04	RAMAC#26333 - Trigger Guard Assy PT#249422 WAS 97867 RAMAC#26335 - Trigger Guard Assy PT#249422 WAS 97867 RAMAC#26337 - Trigger Guard Assy PT#249422 WAS 97867	GLC	312619

Printed on:
~AUTODATE

Date:	Reason for Revision:	Eng:	Log #:
	RAMAC#26335 - Trigger Guard Assy PT#249422 WAS 97867		
13-Oct-04	MOVE RAMAC#29741, 29745, & 29743 FROM OP#606 TO 610 INCREASE THE TEST AMMO QUANTITIES TO 12 FROM 3.5 FOR THE SAME RAMACS	GLC	312842
14-Oct-04	RAMAC #26191 ADDED TARGET AMMO PT#21319	AJL	312655
01-Nov-04	RAMAC#26191 & 26194 - Magazine Spring ET#17891 WAS 15699	GLC	313038
4-Nov-04	OP#400, 405, 415 & 650 - UPDATE INFO AND REESTABLISH LINKS FOR HEADING PLUGS	GLC	313046
08-Dec-04	ADD OP#395 FOR ALL PART #'S REMOVE INSPECTION INFO FROM OP#400, 405, & 415	GLC	313355
04-Jan-05	OP 580 585 640 648 added pull scale verification process	DWB	313329
02-Feb-05	Replace Sub-contract stk 104710 with purchased 104710B	RJL	312488
14-Mar-05	RAMAC#26333 - RF-CF Carton PT#1688 WAS 1499 RAMAC#26339 - RF-CF Carton PT#1688 WAS 1499 RAMAC#26335 - RF-CF Carton PT#1688 WAS 1499 RAMAC#26337 - RF-CF Carton PT#1688 WAS 1499	GLC	314071
04-Apr-05	RAMAC#26187 26191 26194 26201 26189 26183 26185 26196 Stock Assy PT#301028 WAS 111653	GLC	314294
12-Apr-05	Replaced Test and Target Ammo, 202310-202447 With 29218 Ramac 26196 - 26333	ERF	311631
19-Apr-05	ADD RAMAC#26449 - VAR S/A BDL - 6.8MM REM SPC	GLC	314436
01-Jun-05	ADD RAMAC#26497 - VS-SF S/A BDL - 223 REM - BLACK FLUTES ADD RAMAC#26499 - VS-SF S/A BDL - 22-250 REM - BLACK FLUTES	GLC	314898
03-Jun-05	Ramac 29741, 29743, 29745 Changed # of rounds to 10 was 12 - Ramac 29743 Changed Ammo to 21313 was 21311 Test & Target	ERF	314661
04-Jun-05	RAMAC#26497 & 26499 - PT#202706 - STK ASSY S/A BLK LAM VAR W/THUMBHOLE WAS STK ASSY - RF-CF Carton PT#1688 WAS 1684 - ADDED TO GUN DESCRIPTION - BLK LAM W/THUMBHOLE	GLC	314920
29-Jun-05	On SKU #26449, test and target ammo #29146 was #27676; changed due to ammo availability.	MFS	314531

Printed on:
~AUTODATE

Date:	Reason for Revision:	Eng:	Log #:
17-Aug-05	Added targeting information for 6.8mm Rem S&C.	MFS	315263
01-Sep-05	Changed box for SKU #26449 from 1687 to 1684; improve fit.	MFS	315275
7-Sep-05	On SKU #26449, Ejector #201843 was #17017 and Ejector Spring #201841 was #17019; per DCR# 15996.	MFS	315489
29-Sep-05	eliminated test rounds from BOM for SKU's 29741, 29743 and 29745. Test rounds were 21297, 21313 and 28329. These SKU's are targeted 100% therefore the first two seating rounds shot at target are also the test rounds.	RJO	314950

Comprehensive Project Overview: Q3 2024									
Department		Project Details			Timeline & Status			Resource Allocation	
Dept	Num	Procedure by Steps			Start	End	Progress	Safety Key Points	
A	01	1	2	3	2024-07-01	2024-07-15	75%	Wear PPE, No Smoking	
B	02	4	5	6	2024-07-16	2024-07-30	60%	Check for leaks, Ventilate area	
C	03	7	8	9	2024-07-31	2024-08-14	80%	Use proper lifting techniques	
D	04	10	11	12	2024-08-15	2024-08-29	50%	Avoid contact with chemicals	
E	05	13	14	15	2024-08-30	2024-09-13	90%	Secure all equipment	
F	06	16	17	18	2024-09-14	2024-09-28	40%	Follow fire safety protocols	
G	07	19	20	21	2024-09-29	2024-10-13	70%	Maintain clear exit paths	
H	08	22	23	24	2024-10-14	2024-10-28	30%	Use handrails on stairs	
I	09	25	26	27	2024-10-29	2024-11-12	85%	Prohibit unauthorized access	
J	10	28	29	30	2024-11-13	2024-11-27	65%	Report any incidents immediately	
K	11	31	32	33	2024-11-28	2024-12-12	55%	Keep work area organized	
L	12	34	35	36	2024-12-13	2024-12-27	45%	Use safety barriers	
M	13	37	38	39	2024-12-28	2025-01-11	70%	Follow emergency procedures	
N	14	40	41	42	2025-01-12	2025-01-26	35%	No running or horseplay	
O	15	43	44	45	2025-01-27	2025-02-10	60%	Use proper disposal methods	
P	16	46	47	48	2025-02-11	2025-02-25	50%	Keep first aid kit accessible	
Q	17	49	50	51	2025-02-26	2025-03-12	75%	Regular safety training	
R	18	52	53	54	2025-03-13	2025-03-27	40%	Use fall protection	
S	19	55	56	57	2025-03-28	2025-04-11	80%	Secure all loose items	
T	20	58	59	60	2025-04-12	2025-04-26	60%	Follow lockout/tagout procedures	
U	21	61	62	63	2025-04-27	2025-05-11	55%	Use proper electrical safety	
V	22	64	65	66	2025-05-12	2025-05-26	45%	No open flames	
W	23	67	68	69	2025-05-27	2025-06-10	70%	Use proper material handling	
X	24	70	71	72	2025-06-11	2025-06-25	30%	Keep fire extinguishers	
Y	25	73	74	75	2025-06-26	2025-07-10	65%	Use proper ventilation	
Z	26	76	77	78	2025-07-11	2025-07-25	50%	Follow all safety signs	
AA	27	79	80	81	2025-07-26	2025-08-09	75%	Use proper tool usage	
AB	28	82	83	84	2025-08-10	2025-08-24	40%	No unauthorized modifications	
AC	29	85	86	87	2025-08-25	2025-09-08	60%	Use proper storage	
AD	30	88	89	90	2025-09-09	2025-09-23	55%	Follow all safety protocols	
AE	31	91	92	93	2025-09-24	2025-10-08	70%	Use proper communication	
AF	32	94	95	96	2025-10-09	2025-10-23	45%	No distractions	
AG	33	97	98	99	2025-10-24	2025-11-07	60%	Use proper team coordination	
AH	34	100	101	102	2025-11-08	2025-11-22	30%	Follow all safety instructions	
AI	35	103	104	105	2025-11-23	2025-12-07	65%	Use proper safety equipment	
AJ	36	106	107	108	2025-12-08	2025-12-22	50%	No shortcuts	
AK	37	109	110	111	2025-12-23	2026-01-06	75%	Use proper safety procedures	
AL	38	112	113	114	2026-01-07	2026-01-21	40%	Follow all safety guidelines	
AM	39	115	116	117	2026-01-22	2026-02-05	60%	Use proper safety practices	
AN	40	118	119	120	2026-02-06	2026-02-20	55%	Follow all safety rules	
AO	41	121	122	123	2026-02-21	2026-03-07	70%	Use proper safety measures	
AP	42	124	125	126	2026-03-08	2026-03-22	45%	No unsafe acts	
AQ	43	127	128	129	2026-03-23	2026-04-06	60%	Use proper safety techniques	
AR	44	130	131	132	2026-04-07	2026-04-21	30%	Follow all safety standards	
AS	45	133	134	135	2026-04-22	2026-05-06	65%	Use proper safety protocols	
AT	46	136	137	138	2026-05-07	2026-05-21	50%	No unauthorized access	
AU	47	139	140	141	2026-05-22	2026-06-05	75%	Use proper safety equipment	
AV	48	142	143	144	2026-06-06	2026-06-20	40%	Follow all safety guidelines	
AW	49	145	146	147	2026-06-21	2026-07-05	60%	Use proper safety practices	
AX	50	148	149	150	2026-07-06	2026-07-20	55%	Follow all safety rules	
AY	51	151	152	153	2026-07-21	2026-08-04	70%	Use proper safety measures	
AZ	52	154	155	156	2026-08-05	2026-08-19	45%	No unsafe acts	
BA	53	157	158	159	2026-08-20	2026-09-03	60%	Use proper safety techniques	
BB	54	160	161	162	2026-09-04	2026-09-18	30%	Follow all safety standards	
BC	55	163	164	165	2026-09-19	2026-10-03	65%	Use proper safety protocols	
BD	56	166	167	168	2026-10-04	2026-10-18	50%	No unauthorized access	
BE	57	169	170	171	2026-10-19	2026-11-02	75%	Use proper safety equipment	
BF	58	172	173	174	2026-11-03	2026-11-17	40%	Follow all safety guidelines	
BG	59	175	176	177	2026-11-18	2026-12-02	60%	Use proper safety practices	
BH	60	178	179	180	2026-12-03	2026-12-17	55%	Follow all safety rules	
BI	61	181	182	183	2026-12-18	2027-01-01	70%	Use proper safety measures	
BJ	62	184	185	186	2027-01-02	2027-01-16	45%	No unsafe acts	
BK	63	187	188	189	2027-01-17	2027-01-31	60%	Use proper safety techniques	
BL	64	190	191	192	2027-02-01	2027-02-15	30%	Follow all safety standards	
BM	65	193	194	195	2027-02-16	2027-03-02	65%	Use proper safety protocols	
BN	66	196	197	198	2027-03-03	2027-03-17	50%	No unauthorized access	
BO	67	199	200	201	2027-03-18	2027-04-01	75%	Use proper safety equipment	
BP	68	202	203	204	2027-04-02	2027-04-16	40%	Follow all safety guidelines	
BQ	69	205	206	207	2027-04-17	2027-05-01	60%	Use proper safety practices	
BR	70	208	209	210	2027-05-02	2027-05-16	55%	Follow all safety rules	
BS	71	211	212	213	2027-05-17	2027-06-01	70%	Use proper safety measures	
BT	72	214	215	216	2027-06-02	2027-06-16	45%	No unsafe acts	
BU	73	217	218	219	2027-06-17	2027-07-01	60%	Use proper safety techniques	
BV	74	220	221	222	2027-07-02	2027-07-16	30%	Follow all safety standards	
BW	75	223	224	225	2027-07-17	2027-08-01	65%	Use proper safety protocols	
BX	76	226	227	228	2027-08-02	2027-08-16	50%	No unauthorized access	
BY	77	229	230	231	2027-08-17	2027-09-01	75%	Use proper safety equipment	
BZ	78	232	233	234	2027-09-02	2027-09-16	40%	Follow all safety guidelines	
CA	79	235	236	237	2027-09-17	2027-10-01	60%	Use proper safety practices	
CB	80	238	239	240	2027-10-02	2027-10-16	55%	Follow all safety rules	
CC	81	241	242	243	2027-10-17	2027-11-01	70%	Use proper safety measures	
CD	82	244	245	246	2027-11-02	2027-11-16	45%	No unsafe acts	
CE	83	247	248	249	2027-11-17	2027-12-01	60%	Use proper safety techniques	
CF	84	250	251	252	2027-12-02	2027-12-16	30%	Follow all safety standards	
CG	85	253	254	255	2027-12-17	2028-01-01	65%	Use proper safety protocols	
CH	86	256	257	258	2028-01-02	2028-01-16	50%	No unauthorized access	
CI	87	259	260	261	2028-01-17	2028-02-01	75%	Use proper safety equipment	
CJ	88	262	263	264	2028-02-02	2028-02-16	40%	Follow all safety guidelines	
CK	89	265	266	267	2028-02-17	2028-03-03	60%	Use proper safety practices	
CL	90	268	269	270	2028-03-04	2028-03-18	55%	Follow all safety rules	
CM	91	271	272	273	2028-03-19	2028-04-02	70%	Use proper safety measures	
CN	92	274	275	276	2028-04-03	2028-04-17	45%	No unsafe acts	
CO	93	277	278	279	2028-04-18	2028-05-02	60%	Use proper safety techniques	
CP	94	280	281	282	2028-05-03	2028-05-17	30%	Follow all safety standards	
CQ	95	283	284	285	2028-05-18	2028-06-01	65%	Use proper safety protocols	
CR	96	286	287	288	2028-06-02	2028-06-16	50%	No unauthorized access	
CS	97	289	290	291	2028-06-17	2028-07-01	75%	Use proper safety equipment	
CT	98	292	293	294	2028-07-02	2028-07-16	40%	Follow all safety guidelines	
CU	99	295	296	297	2028-07-17	2028-08-01	60%	Use proper safety practices	
CV	100	298	299	300	2028-08-02	2028-08-16	55%	Follow all safety rules	

CONFIDENTIAL

35	80	101	57	Rev 0
----	----	-----	----	-------

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