

**Remington Arms Company, Inc.**  
**Manufacturing Process Document**

**Document ID:** Fin Assy 700 Pol  
**Product Line:** Centerfire Rifle

**Effective Date:** 28-Sep-05  
**Origination Date:** 15-Feb-93

**General Instructions:**

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

**Process Routing Table:**

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

INSPECT COMPONENTS BEFORE HEADING  
(SHOULDER SINGLE PASS)  
(SHOULDER SINGLE PASS: Smaller than .25  
Chamber to Length (BELTED - MAGNUMS)  
(BELTED - MAGNUMS)  
Make Chamber Cast (Not Done on 100% of Product)  
Ream Ejector 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  
Assemble Action  
Tag to Barrel (DM)  
to Trigger Guard  
Tag to Barrel  
PROOF TEST  
telescope with lens covers  
Spacer to Stock  
FUNCTION TEST(100%) AND TARGET(100%)  
Number Using Dot Peen Marking Machine  
INSPECT FOR LIVE AMMUNITION  
CLEAN AND INSPECT  
PACK RIFLE AND DELIVER TO WAREHOUSE  
Proof Test  
Proof Test with slave bolt  
Proof Stamp, Prick Punch and Obstruction In  
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

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

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|----------------------------------------------------------------------------------------------------------|-----------------------------|-----------------------------------------------------|-------------------|------------------------------------|-----------|-------------------------------------|--|
| <b>PROCESS CONTROL INSPECTION RECORD</b><br>THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES |                             |                                                     |                   | Revision Date:<br><b>28-Sep-05</b> |           | Processed by:                       |  |
| <b>Part No:</b>                                                                                          | Part Name: Fin Assy 700 Pol |                                                     | 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<br>REJECT |                                    |           |                                     |  |

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395      INSPECT COMPONENTS BEFORE HEADING

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

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

| PROCESS CONTROL INSPECTION RECORD<br>THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES |                                              |                | Revision Date:<br><b>28-Sep-05</b> |           |                                                 | Processed by:                       |
|---------------------------------------------------------------------------------------------------|----------------------------------------------|----------------|------------------------------------|-----------|-------------------------------------------------|-------------------------------------|
| Part No:                                                                                          | Part Name: Fin Assy 700 Pol                  |                | Centerfire Rifle                   |           |                                                 | Date: 8/14/2006                     |
| Operation No: 395                                                                                 | Operation: INSPECT COMPONENTS BEFORE HEADING |                |                                    |           |                                                 | Work Center:                        |
| Prod. Qty:                                                                                        | Prod. Order #:                               | Operator       |                                    |           | Setup inspected by & Date:                      |                                     |
| Gage Description and Characteristic                                                               | Gage Number                                  | Gage Frequency | 1st Shift                          | 2nd Shift | 3rd Shift                                       | Remarks, Causes, Action Taken, Etc. |
| VISUAL                                                                                            | VISUAL                                       | 100%           | INSPECT                            |           |                                                 |                                     |
|                                                                                                   |                                              |                | REJECT<br>INSPECT                  |           |                                                 |                                     |
|                                                                                                   |                                              |                | REJECT                             |           |                                                 |                                     |
| Pieces Run:                                                                                       |                                              |                |                                    |           | Remington Arms Company, Inc. -- Ilion, New York |                                     |

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

Operation Step Detail      Operation: 400

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

Step      Operation / Step Description

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

- a. Remove bolt assembly from barrel assembly.
- b. Clamp barrel assembly in fixture.
- c. Inspect reamer condition, no chipped cutting surfaces, no metal chips packed in flutes. Make sure reamer is correct for caliber being manufactured. Check spacer collars for size and tightness.
- d. Dip reamer into LB2000 Accu-Lube (note: thick blue liquid).
- e. Insert reamer shank through barrel so pilot is inside barrel bore. Move barrel and reamer together and engage reamer shank into quick release chuck. Make sure barrel chamber is positioned such that it is not being cut by reamer yet.

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

**Operation Tool Detail**

**Operation: 400**

| Tool Number | Tooling Description |
|-------------|---------------------|
| F-76039     | Machine             |
| D-46967     | Fixture             |

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STD LB2000 ACCU-LUBE

STD STEELGARD 1301-NL

STD Caliber - 34-06

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

A-41281 COLLAR

B-90098-W SHANK

STD Caliber - 308 WIN

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

A-41281 COLLAR

B-90098-W SHANK

C-35413-A 300 RUM MIN Heading Plug

C-35413-B 300 RUM WMAX Heading Plug

C-49963-A 300 SAUM MIN Heading Plug

C-49963-B 300 SAUM WMAX Heading Plug

C-41556-A 308 WIN MIN Heading Plug

C-41556-B 308 WIN WMAX Heading Plug

|                                                              |                                                                                 |                  |                |                            |               |
|--------------------------------------------------------------|---------------------------------------------------------------------------------|------------------|----------------|----------------------------|---------------|
| <b>PROCESS CONTROL INSPECTION RECORD</b>                     |                                                                                 |                  | Revision Date: |                            | Processed by: |
| THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES |                                                                                 |                  | 28-Sep-05      |                            |               |
| Part No:                                                     | Part Name: Fin Assy 700 Pol                                                     | Centerfire Rifle |                | Date:                      | 8/14/2006     |
| Operation No: 400                                            | Operation: Fit and Head Bolt Assembly to Barrel Assembly (SHOULDER SINGLE PASS) |                  |                | Work Center:               |               |
| Prod. Qty:                                                   | Prod. Order #:                                                                  | Operator         |                | Setup Inspected by & Date: |               |
| Gage Description and Characteristic                          | Gage Number                                                                     | Gage Frequency   | 1st Shift      | 2nd Shift                  | 3rd Shift     |
| Remarks, Causes, Action Taken, Etc.                          |                                                                                 |                  |                |                            |               |

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|----------------------------|-----------|------|-------------------|--|--|--|
|                            |           |      | INSPECT           |  |  |  |
| VISUAL                     | VISUAL    | 100% | REJECT<br>INSPECT |  |  |  |
| 308 W/IN MIN Heading Plug  | C-41556-A | 100% | REJECT<br>INSPECT |  |  |  |
| 308 W/IN WMAX Heading Plug | C-41556-B | 100% | REJECT<br>INSPECT |  |  |  |
| 308 W/IN MIN Heading Plug  | C-41556-A | 100% | REJECT<br>INSPECT |  |  |  |
| 308 W/IN WMAX Heading Plug | C-41556-B | 100% | REJECT<br>INSPECT |  |  |  |
| 308 W/IN MIN Heading Plug  | C-41556-A | 100% | REJECT<br>INSPECT |  |  |  |
| 308 W/IN WMAX Heading Plug | C-41556-B | 100% | REJECT<br>INSPECT |  |  |  |
| 308 W/IN MIN Heading Plug  | C-41556-A | 100% | REJECT<br>INSPECT |  |  |  |
| 308 W/IN WMAX Heading Plug | C-41556-B | 100% | REJECT<br>INSPECT |  |  |  |
| 308 W/IN MIN Heading Plug  | C-41556-A | 100% | REJECT<br>INSPECT |  |  |  |
| 308 W/IN WMAX Heading Plug | C-41556-B | 100% | REJECT<br>INSPECT |  |  |  |
| 308 W/IN MIN Heading Plug  | C-41556-A | 100% | REJECT            |  |  |  |

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|                            |           |      |         |  |  |  |
|----------------------------|-----------|------|---------|--|--|--|
| 308 W/IN WMAX Heading Plug | C-41556-B | 100% | INSPECT |  |  |  |
|                            |           |      | 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 |  |  |  |
|                            |           |      | REJECT  |  |  |  |
|                            |           |      | INSPECT |  |  |  |
|                            |           |      | REJECT  |  |  |  |
|                            |           |      | INSPECT |  |  |  |
|                            |           |      | REJECT  |  |  |  |
|                            |           |      | INSPECT |  |  |  |
|                            |           |      | REJECT  |  |  |  |

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

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

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

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it is not being cut by reamer yet.

- f. Insert bolt and close slowly as reamer cuts barrel material. Do NOT force bolt closed if reamer is cutting hard. Cutting action should be smooth. If cut is difficult, remove and inspect reamer for problems. (NOTE: THESE CALIBERS NEED TO BE REAMED SLOWLY TO ENSURE REAMER IS NOT BROKEN FREE OF SHANK AND SHANK IS NOT FORCED TO TWIST AND BREAK !!!)
- g. After cutting is completed remove bolt.
- h. Remove reamer and rinse in tank with water and STEELGARD 1301-NL mixture. (note: mixture should have a milky consistency. If mixture looks too thin, add STEELGARD 1301-NL.) All metal chips must be rinsed from reamer. Inspect reamer condition.
- i. Unclamp barrel assembly and rinse in tank with water and STEELGARD 1301-NL mixture to remove any metal chips and to protect newly exposed metal surfaces. Inspect barrel chamber condition.
- j. Replace bolt assembly in barrel assembly and insert appropriate minimum shoulder plug. Bolt should close smoothly. Open bolt and remove minimum shoulder plug.
- k. Insert appropriate maximum shoulder plug. Bolt should not close with maximum shoulder plug in chamber. Open bolt and remove maximum shoulder plug.
- l. If all tests are acceptable close bolt and place barrel assembly on truck

Operation Tool Detail

Operation: 405

Tool Number

Tooling Description

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F-78039 Machine  
D-46967 Fixture  
STD ACCU-LUBE 2000  
STD STEELCARD 1301-NL  
STD Caliber - 223 REM  
D-49577-K REAMER (replaces B-54136-S)  
A-41139 COLLAR  
B-90098-S SHANK  
C-41155-A 223 REM MIN Heading Plug  
C-41155-B 223 REM WMAX Heading Plug

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|---------------------------------------------------------------------------------------------------|--|-----------------------------------------------------------------------------------------------------------|----------------|------------------------------------|-----------|----------------------------|-------------------------------------|
| Part No:                                                                                          |  | Part Name: Fin Assy 700 Pol                                                                               |                | Centerfire Rifle                   |           | Date: 8/14/2005            |                                     |
| Operation No: 405                                                                                 |  | Operation: Fit and Head Bolt Assembly to Barrel Assembly (SHOULDER SINGLE PASS: Smaller than .25 caliber) |                |                                    |           | Work Center:               |                                     |
| Prod. Qty:                                                                                        |  | Prod. Order #:                                                                                            |                | Operator                           |           | Setup Inspected by & Date: |                                     |
| Gage Description and Characteristic                                                               |  | Gage Number                                                                                               | Gage Frequency | 1st Shift                          | 2nd Shift | 3rd Shift                  | Remarks, Causes, Action Taken, Etc. |
| VISUAL                                                                                            |  | VISUAL                                                                                                    | 100%           | INSPECT                            |           |                            |                                     |
|                                                                                                   |  |                                                                                                           |                | REJECT                             |           |                            |                                     |
| 223 REM MIN Heading Plug                                                                          |  | C-41155-A                                                                                                 | 100%           | INSPECT                            |           |                            |                                     |
|                                                                                                   |  |                                                                                                           |                | REJECT                             |           |                            |                                     |

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|                           |           |      |                                                 |  |  |  |
|---------------------------|-----------|------|-------------------------------------------------|--|--|--|
| 223 REM WMAX Heading Plug | C-41155-B | 100% | INSPECT                                         |  |  |  |
|                           |           |      | REJECT                                          |  |  |  |
|                           |           |      | INSPECT                                         |  |  |  |
| 223 REM MIN Heading Plug  | C-41155-A | 100% | REJECT                                          |  |  |  |
|                           |           |      | INSPECT                                         |  |  |  |
| 223 REM WMAX Heading Plug | C-41155-B | 100% | REJECT                                          |  |  |  |
|                           |           |      | INSPECT                                         |  |  |  |
| 223 REM MIN Heading Plug  | C-41155-A | 100% | REJECT                                          |  |  |  |
|                           |           |      | INSPECT                                         |  |  |  |
| 223 REM WMAX Heading Plug | C-41155-B | 100% | REJECT                                          |  |  |  |
|                           |           |      | INSPECT                                         |  |  |  |
| 223 REM MIN Heading Plug  | C-41155-A | 100% | REJECT                                          |  |  |  |
|                           |           |      | INSPECT                                         |  |  |  |
| 223 REM WMAX Heading Plug | C-41155-B | 100% | REJECT                                          |  |  |  |
|                           |           |      | INSPECT                                         |  |  |  |
|                           |           |      | REJECT                                          |  |  |  |
| Pieces Run:               |           |      | Remington Arms Company, Inc. -- Ilion, New York |  |  |  |

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

- Remove bolt assembly from barrel assembly.
- Clamp barrel assembly in fixture.
- 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.
- Dip shoulder reamer into LB2000 Accu-Lube (note: thick blue liquid).
- 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

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

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

Operation Tool Detail

Operation: 415

Tool Number

Tooling Description

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F-78039 Machine - Special Chambering Mach.

D-46967 ~~FIXTURE~~

STD ACCU-LUBE 2000

STD STEELCARD 1302-NL

STD 264 Win Mag.

B-83838 REAMER - SHOULDER

A-41281 COLLAR

B-90098-U SHANK

B-53328-T REAMER - FACE

B-53328-V BELT CUTTER

B-53328-R CHAMBER GUIDE BUSHING

STD 7MM Mag.

B-84815 REAMER - SHOULDER

A-41281 COLLAR

B-90098-V SHANK

B-53328-P REAMER - FACE

B-53328-V BELT CUTTER

B-53328-R CHAMBER GUIDE BUSHING

TD 00 Win Mag.

B-86573 REAMER - SHOULDER

A-41281 COLLAR

B-90098-W SHANK

B-53328-W REAMER - FACE

B-53328-V BELT CUTTER

B-53328-R CHAMBER GUIDE BUSHING

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TD 38 Win Mag.  
C-47271 REAMER - SHOULDER  
A-41281 COLLAR  
B-90098-N SHANK  
B-53328-L REAMER - FACE  
B-53328-V BELT CUTTER  
B-53328-J CHAMBER GUIDE BUSHING

STD 8MM REM Mag.

B-43096 REAMER - SHOULDER  
A-41281 COLLAR  
B-90098-N SHANK  
B-53328-L REAMER - FACE  
B-53328-V BELT CUTTER  
B-53328-R CHAMBER GUIDE BUSHING

STD 416 REM Mag.

B-43096 REAMER - SHOULDER  
A-41281 COLLAR  
B-90098-N SHANK  
B-53328-L REAMER - FACE  
B-53328-V BELT CUTTER  
B-53328-R CHAMBER GUIDE BUSHING

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-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

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| PROCESS CONTROL INSPECTION RECORD<br>THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES |                                                                                               |                  | Revision Date:<br><b>28-Sep-05</b> |           |                            | Processed by:                       |
|---------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------|------------------|------------------------------------|-----------|----------------------------|-------------------------------------|
| Part No:                                                                                          | Part Name:                                                                                    | Centerfire Rifle |                                    |           | Date:                      | 8/14/2006                           |
| Operation No:                                                                                     | Operation: Fit and Head Bolt Assembly to Barrel Assy and Chamber to Length (BELTED - MAGNUMS) |                  |                                    |           | Work Center:               |                                     |
| Prod. Qty:                                                                                        | Prod. Order #                                                                                 | Operator         |                                    |           | Setup Inspected by & Date: |                                     |
| Gage Description and Characteristic                                                               | Gage Number                                                                                   | Gage Frequency   | 1st Shift                          | 2nd Shift | 3rd Shift                  | Remarks, Causes, Action Taken, Etc. |
| VISUAL                                                                                            | VISUAL                                                                                        | 100%             | INSPECT                            |           |                            |                                     |
| 300 Win BELT - MIN Heading Plug                                                                   | C-83853-A                                                                                     | 100%             | REJECT<br>INSPECT                  |           |                            |                                     |
| 300 Win BELT - WMAX Heading Plug                                                                  | C-83853-B                                                                                     | 100%             | REJECT<br>INSPECT                  |           |                            |                                     |
| 300 Win MIN Heading Plug                                                                          | C-41546-A                                                                                     | 100%             | REJECT<br>INSPECT                  |           |                            |                                     |
| 300 Win WMAX Heading Plug                                                                         | C-41546-B                                                                                     | 100%             | REJECT<br>INSPECT                  |           |                            |                                     |
| 300 Win BELT - MIN Heading Plug                                                                   | C-83853-A                                                                                     | 100%             | REJECT<br>INSPECT                  |           |                            |                                     |
| 300 Win BELT - WMAX Heading Plug                                                                  | C-83853-B                                                                                     | 100%             | REJECT<br>INSPECT                  |           |                            |                                     |
| 300 Win MIN Heading Plug                                                                          | C-41546-A                                                                                     | 100%             | REJECT                             |           |                            |                                     |

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|                                  |           |      |                   |  |                                                |  |
|----------------------------------|-----------|------|-------------------|--|------------------------------------------------|--|
|                                  |           |      | INSPECT           |  |                                                |  |
| 300 Win WMAX Heading Plug        | C-41546-B | 100% | REJECT<br>INSPECT |  |                                                |  |
| 7MM Mag BELT - MIN Heading Plug  | C-83853-A | 100% | REJECT<br>INSPECT |  |                                                |  |
| 7MM Mag BELT - WMAX Heading Plug | C-83853-B | 100% | REJECT<br>INSPECT |  |                                                |  |
| 7MM Mag MIN Heading Plug         | C-41561-A | 100% | REJECT<br>INSPECT |  |                                                |  |
| 7MM Mag WMAX Heading Plug        | C-41561-B | 100% | REJECT<br>INSPECT |  |                                                |  |
| 300 SAUM MIN Heading Plug        | C-49963-A | 100% | REJECT<br>INSPECT |  |                                                |  |
| 300 SAUM WMAX Heading Plug       | C-49963-B | 100% | REJECT<br>INSPECT |  |                                                |  |
|                                  |           |      | REJECT            |  |                                                |  |
| Pieces Run:                      |           |      |                   |  | Remington Arms Company, Inc. - Ilion, New York |  |

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420 Ream Chamber to Deburr  
(BELTED - MAGNUMS)

Operation Step Detail      Operation: 420

Step      Operation / Step Description

Ream Chamber to Deburr - (BELTED - MAGNUMS)

**PROCEDURE:**

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

Operation Tool Detail      Operation: 420

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Tool Number

C-49758

Tooling Description

Burnish Tool  
Shank Std.

|                                                              |  |                                   |                |                   |           |              |                                     |                 |  |
|--------------------------------------------------------------|--|-----------------------------------|----------------|-------------------|-----------|--------------|-------------------------------------|-----------------|--|
| <b>PROCESS CONTROL INSPECTION RECORD</b>                     |  |                                   |                | Revision Date:    |           | 28-Sep-05    |                                     | Processed by:   |  |
| THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES |  |                                   |                |                   |           |              |                                     |                 |  |
| <b>Part No:</b>                                              |  | Part Name: Fin Assy 700 Pol       |                | Centerfire Rifle  |           |              |                                     | Date: 8/14/2005 |  |
| Operation No: 420                                            |  | Operation: Ream Chamber to Deburr |                |                   |           | Work Center: |                                     |                 |  |
| Prod. Qty:                                                   |  | Prod. Order #:                    |                | Operator          |           |              | Setup inspected by & Date:          |                 |  |
| Gage Description and Characteristic                          |  | Gage Number                       | Gage Frequency | 1st Shift         | 2nd Shift | 3rd Shift    | Remarks: Causes, Action Taken, Etc. |                 |  |
| VISUAL                                                       |  | VISUAL                            | 100%           | INSPECT           |           |              |                                     |                 |  |
|                                                              |  |                                   |                | REJECT<br>INSPECT |           |              |                                     |                 |  |
|                                                              |  |                                   |                | REJECT<br>INSPECT |           |              |                                     |                 |  |
|                                                              |  |                                   |                | REJECT<br>INSPECT |           |              |                                     |                 |  |
|                                                              |  |                                   |                | REJECT<br>INSPECT |           |              |                                     |                 |  |
|                                                              |  |                                   |                | REJECT<br>INSPECT |           |              |                                     |                 |  |
|                                                              |  |                                   |                | REJECT<br>INSPECT |           |              |                                     |                 |  |
|                                                              |  |                                   |                | REJECT<br>INSPECT |           |              |                                     |                 |  |

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

Operation Step Detail      Operation: 425

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

Step      Operation / Step Description

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

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

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**PROCESS CO**  
THIS RECORD MUST

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|  |  |  |  |                   |  |  |  |                                                 |
|--|--|--|--|-------------------|--|--|--|-------------------------------------------------|
|  |  |  |  | INSPECT           |  |  |  |                                                 |
|  |  |  |  | REJECT<br>INSPECT |  |  |  |                                                 |
|  |  |  |  | REJECT<br>INSPECT |  |  |  |                                                 |
|  |  |  |  | REJECT            |  |  |  |                                                 |
|  |  |  |  | Pieces Run:       |  |  |  | Remington Arms Company, Inc. -- Ilion, New York |

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### 430 Ream Ejector Hole

Operation Step Detail      Operation: 430

Step      Operation / Step Description

Ream Ejector Hole

Remove Burr thrown into Ejector Hole by Flat Scrape

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

Operation Tool Detail      Operation: 430

Tool Number      Tooling Description

STD      #28 DRILL

|                                                              |                              |                  |  |                            |  |               |  |
|--------------------------------------------------------------|------------------------------|------------------|--|----------------------------|--|---------------|--|
| <b>PROCESS CONTROL INSPECTION RECORD</b>                     |                              | Revision Date:   |  | 28-Sep-05                  |  | Processed by: |  |
| THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES |                              |                  |  |                            |  |               |  |
| Part No:                                                     | Part Name: Fin Assy 700 Pol  | Centerfire Rifle |  | Date:                      |  | 8/14/2006     |  |
| Operation No: 430                                            | Operation: Ream Ejector Hole |                  |  | Work Center:               |  |               |  |
| Prod. Qty:                                                   | Prod. Order #:               | Operator         |  | Setup inspected by & Date: |  |               |  |

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

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432 Assemble Riveted Extractor to Bolt - (MAGNUMS)

Operation Step Detail      Operation: 432

Step      Operation / Step Description

Assemble Riveted Extractor to Bolt - (MAGNUMS)

**PROCEDURE:**

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

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

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

#### Operation Tool Detail

Operation: 432

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

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TENSION

B-87034-A Small Rifle  
B-87034-C Large Rifle  
B-87034-D Belted Magnums

| PROCESS CONTROL INSPECTION RECORD                            |                                                           |                | Revision Date    |           |                            | Processed by:                       |
|--------------------------------------------------------------|-----------------------------------------------------------|----------------|------------------|-----------|----------------------------|-------------------------------------|
| THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES |                                                           |                | 28-Sep-05        |           |                            |                                     |
| Part No:                                                     | Part Name: Fin Assy 700 Pol                               |                | Centerfire Rifle |           |                            | Date: 8/14/2006                     |
| Operation No: 432                                            | Operation: Assemble Riveted Extractor to Bolt - (MAGNUMS) |                |                  |           |                            | Work Center:                        |
| Prod. Qty:                                                   | Prod. Order #:                                            | Operator       |                  |           | Setup Inspected by & Date: |                                     |
| Gage Description and Characteristic                          | Gage Number                                               | Gage Frequency | 1st Shift        | 2nd Shift | 3rd Shift                  | Remarks, Causes, Action Taken, Etc. |
| VISUAL                                                       | VISUAL                                                    | 100%           | INSPECT          |           |                            |                                     |
|                                                              |                                                           |                | REJECT           |           |                            |                                     |
| Small Rifle                                                  | B-84831-A                                                 | 100%           | INSPECT          |           |                            |                                     |
|                                                              |                                                           |                | REJECT           |           |                            |                                     |
| Large Rifle                                                  | B-84831-B                                                 | 100%           | INSPECT          |           |                            |                                     |
|                                                              |                                                           |                | REJECT           |           |                            |                                     |
| 6.8MM REM SPC                                                | B-84831-E                                                 | 100%           | INSPECT          |           |                            |                                     |
|                                                              |                                                           |                | REJECT           |           |                            |                                     |
| Small Rifle                                                  | B-87034-A                                                 | 100%           | INSPECT          |           |                            |                                     |
|                                                              |                                                           |                | REJECT           |           |                            |                                     |
| Large Rifle                                                  | B-87034-C                                                 | 100%           | INSPECT          |           |                            |                                     |
|                                                              |                                                           |                | REJECT           |           |                            |                                     |

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#### 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 Shroud by Adjusting Both Ends of (If Necessary)<br>- Claw of Extractor Must Be Checked on Tension Plug for "Go" and "No Go"<br>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<br>a. Check Extractor with Pick<br>- 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        |

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B-84831-E 6.8MM REM SPC  
B-87034-F 6.8MM REM SPC

| PROCESS CONTROL INSPECTION RECORD                            |                                                 |                  |                   | Revision Date:   |                            | Processed by:                       |
|--------------------------------------------------------------|-------------------------------------------------|------------------|-------------------|------------------|----------------------------|-------------------------------------|
| THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES |                                                 |                  |                   | 28-Sep-05        |                            |                                     |
| Part No:                                                     | Part Name:                                      | Fin Assy 700 Bol |                   | 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<br>INSPECT |                  |                            |                                     |
| Max Tension Plug                                             | B-84831-B                                       | 100%             | REJECT<br>INSPECT |                  |                            |                                     |
|                                                              |                                                 |                  | REJECT<br>INSPECT |                  |                            |                                     |
|                                                              |                                                 |                  | REJECT<br>INSPECT |                  |                            |                                     |
|                                                              |                                                 |                  | REJECT<br>INSPECT |                  |                            |                                     |
|                                                              |                                                 |                  | REJECT<br>INSPECT |                  |                            |                                     |
|                                                              |                                                 |                  | REJECT<br>INSPECT |                  |                            |                                     |
|                                                              |                                                 |                  | REJECT<br>INSPECT |                  |                            |                                     |



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

Operation Step Detail

Operation: 440

Step

Operation / Step Description

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

**PROCEDURE:**

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

Operation Tool Detail

Operation: 440

Tool Number

Tooling Description

C-51730

Fixture

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C-40296 Fixture (L.H.)  
A-48261 Pin Punch  
B-54503 Drive Punch (Drive Out Tight Ejector Pin)  
C-53663 Fixture

| PROCESS CONTROL INSPECTION RECORD                            |                                                        |                |                   |           |                            | Revision: Date                      | Processed by: |
|--------------------------------------------------------------|--------------------------------------------------------|----------------|-------------------|-----------|----------------------------|-------------------------------------|---------------|
| THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES |                                                        |                |                   |           |                            | 28-Sep-05                           |               |
| Part No:                                                     | Part Name: Fin Assy 700 Pol                            |                | Centerfire Rifle  |           |                            | Date:                               | 8/14/2005     |
| 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<br>INSPECT |           |                            |                                     |               |
|                                                              |                                                        |                | REJECT<br>INSPECT |           |                            |                                     |               |
|                                                              |                                                        |                | REJECT<br>INSPECT |           |                            |                                     |               |
|                                                              |                                                        |                | REJECT<br>INSPECT |           |                            |                                     |               |
|                                                              |                                                        |                | REJECT<br>INSPECT |           |                            |                                     |               |

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460R Strip Defective Barrel Assembly Complete

| PROCESS CONTROL INSPECTION RECORD                            |                                                     |                | Revision Date: 28-Sep-05 |           |                            | Processed by:                       |
|--------------------------------------------------------------|-----------------------------------------------------|----------------|--------------------------|-----------|----------------------------|-------------------------------------|
| THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES |                                                     |                |                          |           |                            |                                     |
| Part No:                                                     | Part Name: Fin Assy 700 Pol                         |                | Centerfire Rifle         |           | Date: 8/14/2006            |                                     |
| Operation No: 460R                                           | Operation: Strip Defective Barrel Assembly Complete |                |                          |           |                            | Work Center:                        |
| Prod. Qty:                                                   | Prod. Order #:                                      | Operator:      |                          |           | Setup Inspected by & Date: |                                     |
| Gage Description and Characteristic                          | Gage Number                                         | Gage Frequency | 1st Shift                | 2nd Shift | 3rd Shift                  | Remarks, Causes, Action Taken, Etc. |
| VISUAL                                                       | VISUAL                                              | 100%           | INSPECT                  |           |                            |                                     |
|                                                              |                                                     |                | REJECT                   |           |                            |                                     |
|                                                              |                                                     |                | INSPECT                  |           |                            |                                     |
|                                                              |                                                     |                | REJECT                   |           |                            |                                     |
|                                                              |                                                     |                | INSPECT                  |           |                            |                                     |
|                                                              |                                                     |                | REJECT                   |           |                            |                                     |
|                                                              |                                                     |                | INSPECT                  |           |                            |                                     |
|                                                              |                                                     |                | REJECT                   |           |                            |                                     |
|                                                              |                                                     |                | INSPECT                  |           |                            |                                     |
|                                                              |                                                     |                | REJECT                   |           |                            |                                     |
|                                                              |                                                     |                | INSPECT                  |           |                            |                                     |
|                                                              |                                                     |                | REJECT                   |           |                            |                                     |

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465R Strip Defective Bolt

| PROCESS CONTROL INSPECTION RECORD                            |                                 |                | Revision Date: 28-Sep-05 |           |                            | Processed by:                       |
|--------------------------------------------------------------|---------------------------------|----------------|--------------------------|-----------|----------------------------|-------------------------------------|
| THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES |                                 |                |                          |           |                            |                                     |
| Part No:                                                     | Part Name: Fin Assy 700 Pol     |                | Centerfire Rifle         |           |                            | Date: 8/14/2006                     |
| Operation No: 465R                                           | Operation: Strip Defective Bolt |                |                          |           |                            | Work Center:                        |
| Prod. Qty:                                                   | Prod. Order #:                  | Operator:      |                          |           | Setup Inspected by & Date: |                                     |
| Gage Description and Characteristic                          | Gage Number                     | Gage Frequency | 1st Shift                | 2nd Shift | 3rd Shift                  | Remarks, Causes, Action Taken, Etc. |
| VISUAL                                                       | VISUAL                          | 100%           | INSPECT                  |           |                            |                                     |
|                                                              |                                 |                | REJECT<br>INSPECT        |           |                            |                                     |
|                                                              |                                 |                | REJECT<br>INSPECT        |           |                            |                                     |
|                                                              |                                 |                | REJECT<br>INSPECT        |           |                            |                                     |
|                                                              |                                 |                | REJECT<br>INSPECT        |           |                            |                                     |
|                                                              |                                 |                | REJECT<br>INSPECT        |           |                            |                                     |
|                                                              |                                 |                | REJECT<br>INSPECT        |           |                            |                                     |
|                                                              |                                 |                | REJECT                   |           |                            |                                     |

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580 Assemble Action

Operation Step Detail      Operation: 580

Step      Operation / Step Description

Assemble Action

**PROCEDURE:**

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

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

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

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

Perform Checks a. thru c. (3) Times

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

Try (3) Times

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

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

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

- 22 Close the Action and Lock Bolt Down

Operation Tool Detail

Operation: 580

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

#### GAGES

|         |                                   |
|---------|-----------------------------------|
| B-70697 | Trigger Pull Scales               |
| STD     | .006 Feeler Gage or Suitable Shim |
| C-47741 | Sear Engagement Gage - Solid Bolt |
| D-44581 | Sear Lift Dial Gage (.006 - .018) |
| B-52089 | Firing Pin Protrusion Gage        |
| B-80652 | Pins Tight Tester                 |

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STD  
B-TS-7300Trigger Guard Clearance Shim Tool (.030")  
Dummy Cartridge Rounds of Proper Caliber Being Built  
Dest. E Scuff Template

| PROCESS CONTROL INSPECTION RECORD                            |                             |                |                   | Revision Date: |                            | Processed by:                       |
|--------------------------------------------------------------|-----------------------------|----------------|-------------------|----------------|----------------------------|-------------------------------------|
| THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES |                             |                |                   | 28-Sep-05      |                            |                                     |
| Part No:                                                     | Part Name: Fin Assy 700 Pol |                | Centerfire Rifle  |                |                            | Date: 8/14/2006                     |
| Operation No: 580                                            | Operation: Assemble Action  |                |                   |                | Work Center:               |                                     |
| Prod. Qty:                                                   | Prod. Order #:              | Operator       |                   |                | Setup Inspected by & Date: |                                     |
| Gage Description and Characteristic                          | Gage Number                 | Gage Frequency | 1st Shift         | 2nd Shift      | 3rd Shift                  | Remarks, Causes, Action Taken, Etc. |
|                                                              |                             |                | INSPECT           |                |                            |                                     |
| VISUAL                                                       | VISUAL                      | 100%           | REJECT<br>INSPECT |                |                            |                                     |
| Trigger Pull Scales                                          | B-70697                     | 100%           | REJECT<br>INSPECT |                |                            |                                     |
| .006 Feeler Gage or Suitable Shim                            | STD                         | 100%           | REJECT<br>INSPECT |                |                            |                                     |
| Sear Engagement Gage - Solid Bolt                            | C-47741                     | 100%           | REJECT<br>INSPECT |                |                            |                                     |
| Sear Lift Dial Gage (.006 - .018)                            | D-44581                     | 100%           | REJECT<br>INSPECT |                |                            |                                     |
| Firing Pin Protrusion Gage                                   | B-52089                     | 100%           | REJECT<br>INSPECT |                |                            |                                     |
| Pins Tight Tester                                            | B-80652                     | 100%           | REJECT            |                |                            |                                     |

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|                                                              |           |      |                                                |  |  |
|--------------------------------------------------------------|-----------|------|------------------------------------------------|--|--|
| Trigger Guard Clearance<br>Shim Tool (.030")                 | A-43077   | 100% | INSPECT<br>REJECT<br>INSPECT                   |  |  |
| During Cartridge Rounds of<br>Proper Caliber Being Built STD |           | 100% | REJECT<br>INSPECT                              |  |  |
| Dent & Scuff Template                                        | B-TS-7300 | 100% | REJECT<br>INSPECT                              |  |  |
|                                                              |           |      | REJECT<br>INSPECT                              |  |  |
|                                                              |           |      | REJECT                                         |  |  |
| Pieces Run:                                                  |           |      | Remington Arms Company, Inc. - Ilion, New York |  |  |

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581 Assemble Action

Operation Step Detail      Operation: 581

Step      Operation / Step Description

Assemble Action

**PROCEDURE:**

1. Pick Action from Truck - Inspect for: Magna-Flux Stamp, Serial # of Bolt Matches Receiver, Marks, and Uniform Color
2. Pick Firing Pin Assembly - Inspect for: Point Not Marred, Bolt Plug Color, No Rust or Miscuts
3. 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
4. Assemble Firing Pin Assembly to Bolt Body Assembly Using Bolt Assembly Tool
5. Check Firing Pin Protrusion
6. Insert Bolt into Action and Lock Down, Operate Bolt (3) Times to Verify Proper Fit - Remove Bolt and Place on Bench
7. Select Trigger Assembly

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8. Insert Trigger Assembly in Receiver (Must Fit Freely)  
(File Slot if Necessary)
9. Select Sear Pin and Start in Sear Pin Hole (Drive in Flush with Inside of Bolt Stop Cut)
10. Select Bolt Stop - Position in Receiver (Must Fit Freely)  
(File Slot if Necessary)
11. Select Bolt Stop Spring - Position in Receiver
12. Position Trigger Assembly - Select Bolt Stop Pin and Assemble to Receiver
13. Stake Sear Pin and Bolt Stop Pin
14. Hold Trigger & Press Down on Sear - Sear Must NOT Bind
15. Try Safety
  - a. Must be clearance between Sear and Trigger Connector with Safety in "ON" Position
  - b. With Bolt Open, Place Safety in "S" or "ON" Position - Close Bolt and Lock Down
    - Must Lock Down Without Catching on Safety
    - Firing Pin Must NOT Follow Down
    - Bolt Must Open with Safety in "ON" Position
16. Check Vertical Sear Engagement - Minimum .015" Visual
  - a. Check for "Jar Off"
    - Applying Steady Pressure on End of Firing Pin Head with Rifle Cocked and Safety in the "F" or "OFF" Position
    - Rifle Must NOT Fire
  - b. Open and Close Bolt Forcibly (3) Times - Remove Bolt Assembly
  - c. Place Safety in the "F" or "OFF" Position, Insert Solid Bolt  
(Tool #C-47741)

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- 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 and the Bolt (Tool) Must Remain Engaged with Sear
17. Verify Firing Pin Head Will Release from the Cocking Notch by Squeezing and Holding Trigger while Closing and Locking Down Bolt Slowly
- Firing Pin MUST Follow Down
  - Slight Trigger Play may be detectable after firing
18. Inspect Safety Function:
- a. Place Safety in "S" or "ON" Position
    - Apply Heavy Pressure to Trigger
    - Rifle Must NOT Fire
    - Release Trigger
    - Trigger MUST Retract
  - b. Place Safety Halfway Between "S" and "F"
    - 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.
19. Weigh Trigger Pull (4.75 to 5.75 lbs.) parallel with action
- a. Must be Short & Crisp, No Creep Over or Overdraw
- Try (3) Times
- NOTE:** Perform Monthly check on Trigger Pull scale to verify accuracy. Follow procedure below using at least two different weights.
- a. Slowly lift dead weight off bench using trigger pull scale.
  - b. Slowly return weight to bench and read scale.
    - Measurement must be within 1/8 lb of actual dead weight.
  - c. If scale is not within above specification for any of the measured dead weights;
    - send scale to Gage Inspection for Re-Calibration.

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20. Place Safety in "S" or "ON" Position

21. Close the Action and Lock Bolt Down

Operation Tool Detail

Operation: 581

| Tool Number | Tooling Description                                                                                                  |
|-------------|----------------------------------------------------------------------------------------------------------------------|
| A-88003     | Taper Reamer for Braze in Firing Pin Hole                                                                            |
| 7237T1      | Lube Brush - McMaster-Carr (or Equivalent) Tin Ferroule,<br>Natural Bristle Type Brush - 3-3/4 O.A.L.<br>3/8W x 3/4L |
| 43447       | Brass Wiping Rod                                                                                                     |

Gages:

|         |                                   |
|---------|-----------------------------------|
| B-70697 | Trigger Pull Scales               |
| STD     | .006 Feeler Gage or Suitable Shim |
| D-48553 | Bolt Disassembly Tool             |
| C-47741 | Sear Engagement Gage - Solid Bolt |
| B-52089 | Firing Pin Protrusion Gage        |
| B-80652 | Pins Tight Tester                 |

|                                                              |                             |                  |           |               |
|--------------------------------------------------------------|-----------------------------|------------------|-----------|---------------|
| <b>PROCESS CONTROL INSPECTION RECORD</b>                     |                             | Revision Date:   | 28-Sep-05 | Processed by: |
| THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES |                             |                  |           |               |
| Part No:                                                     | Part Name: Fin Assy 700 Pol | Centerfire Rifle | Date:     | 8/14/2006     |

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|                                     |               |                            |                   |           |                            |                                     |
|-------------------------------------|---------------|----------------------------|-------------------|-----------|----------------------------|-------------------------------------|
| Operation No: 581                   |               | Operation: Assemble Action |                   |           |                            | Work Center:                        |
| Prod. Qty:                          | Prod. Order # | Operator                   |                   |           | Setup inspected by & Date: |                                     |
| Gage Description and Characteristic | Gage Number   | Gage Frequency             | 1st Shift         | 2nd Shift | 3rd Shift                  | Remarks, Causes, Action Taken, Etc. |
| VISUAL                              | VISUAL        | 100%                       | REJECT<br>INSPECT |           |                            |                                     |
| Trigger Pull Scales                 | B-70697       | 100%                       | REJECT<br>INSPECT |           |                            |                                     |
| .006 Feeler Gage or Suitable Shim   | STD           | 100%                       | REJECT<br>INSPECT |           |                            |                                     |
| Bolt Disassembly Tool               | D-48553       | 100%                       | REJECT<br>INSPECT |           |                            |                                     |
| Sear Engagement Gage - Solid Bolt   | C-47741       | 100%                       | REJECT<br>INSPECT |           |                            |                                     |
| Firing Pin Protrusion Gage          | B-52089       | 100%                       | REJECT<br>INSPECT |           |                            |                                     |
| Pins Tight Tester                   | B-80652       | 100%                       | REJECT<br>INSPECT |           |                            |                                     |
|                                     |               |                            | REJECT<br>INSPECT |           |                            |                                     |
|                                     |               |                            | REJECT<br>INSPECT |           |                            |                                     |
|                                     |               |                            | REJECT<br>INSPECT |           |                            |                                     |

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583 Assemble Stock to Action and Attach Hang  
Tag to Trigger Guard

Operation Step Detail      Operation: 583

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
    - Butt Plate
      1. Black Rear Face
      2. No Burrs
      3. .005 Max. Opening at Face
      4. Tight (Finger Test)
      5. Screws Not Project Badly
      6. Burrs at Screw Holes Slight
      7. .02 Max. Mismatch of Butt Plate and Stock Either Way
    - Recoil Pad
      1. Good Color
      2. Rear Face
      3. No Burrs
      4. .005 Max. Opening at Face

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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
2. Position Stock on Action
3. Select Trigger Guard Assy.
  - a. Inspect for:
    - No Sharp Edges
    - Color
    - Marks
    - Pits
    - Position in Stock
4. 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 - 65 IN\*LBS - per torque spec. Next torque rear take down screw to 65 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

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- Barrel Must Seat within 1.5" of Front of Stock
- Vertical Squeeze Produces No Movement
- Guard Screws Tightened to 45 IN - LBS
- .020 Max. Opening Under Trigger Plate Except at Corners
- .025 Max. Opening Under Trigger Plate at Corners
- .025 Max. Opening With Stock
- b. Gas Hole in Receiver 50% Visible Above Stock
- c. Check for Trigger Clearance In Guard
  - Must Not Bind
  - Trigger Must Not Be Exposed Outside of Guard
  - A (.030) Shim Must Fit Between End of Trigger and Inside of Guard Bow While Trigger is in both the Full Rearward Position and the Relaxed Position
- 1. IF IT FAILS the SHIM
  - SEE PROCEDURE BELOW for Shim PLACEMENT UNDER THE TRIGGER GUARD

Shim Placement Procedure if Required;

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

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

5A SUPPLIER FURNISHED, HEAVY BARREL, SYNTHETIC STOCKS ONLY --  
(H-S PRECISION, ETC.)

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Check the fit between the Barrel and the barrel channel in the Stock. The Barrel should "float" and be positioned centrally in the barrel channel.

- a. If the Barrel appears to be central with respect to the channel, no further action is needed. Continue with the subsequent steps.
- b. If the Barrel appears off-center, favoring one side or the other, it will be necessary to check the clearance between the Barrel and the Stock to see if it is within specs.

SPECIFICATION: At a distance of 9 1/2" from the front of the Barrel Bracket, the Barrel must be NO CLOSER than .032 and NO FURTHER than .076 with respect to the side of the Stock channel.

- c. PROCEDURE: On the close side, a .032 feeler (shim) MUST GO between the side of the Barrel and the Stock. (The feeler should stand unsupported between the Barrel and the Stock.) On the far side, a .076 feeler MUST \*NOT\* GO.

- If the feeler test is successful, continue with subsequent steps.
- If the assembly does not pass the feeler test, replace the Stock.

NOTES: This procedure is done 9 1/2" from the face of the Barrel Bracket. The measurement point is approximately 1 1/2" in from the front tip of the Stock, about where the bedding pad is found on other models. The checks are invalid closer to the Receiver. Do not force the feeler gage.

- 6 Turn Rifle Over in Vise
- 7 Check Safety
  - No Bind
  - Clears Stock

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- a. Safety Lever Must Have Noticeable Overtravel Before Stopping or Coming Into Contact with Stock Cuts
  - Forward Beyond "F" Detent
  - Rearward Beyond "S" Detent
8. Check Bolt
  - No Bind
  - Clears Stock
9. 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.
10. Select Correct Magazine Assembly
    - a. Inspect for:
      - Color
      - NO Rust
  11. Use Dummy Cartridges to Check:
    - Feeding
    - Extraction
    - Ejection(Single Load and Fully Loaded Magazine Assembly)
    - a. Load the Magazine Assy Fully - (4 Regular Rounds or 3 Magnum Rounds)
      - Press the Cartridges Down at Rear

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- Let the Follower Spring Return the Cartridges to Full Height
- If They Do Not Return to the Feed Lips
  - 1. DO NOT USE MAGAZINE ASSEMBLY
  - 2. REPLACE MAGAZINE ASSEMBLY
- b. Adjust the Forearm Bench Rest to Clear the Magazine Assy Opening
  - IT IS IMPORTANT NOT TO FORCE the Magazine Assembly Upward During Function Testing
- c. Place the Magazine Assembly in the Trigger Guard Until Latches Catch
  - This Should Not Require A Great Amount of Force
  - If A Great Amount of Force is Needed
    - 1. Assemble Another Trigger Guard
- d. Remove Bolt
- e. Insert Shell Coverage Gage
  - Check Every Round From Full Magazine Assembly With Gage
  - The Rim of Each Cartridge MUST FALL BETWEEN the Two Inscribed Lines
  - PERFORM THIS CHECK 100% ON ALL MAGAZINE ASSEMBLY'S  
(This is to Ensure NO Over Rides or Jump Magazine Malfunctions Occur During Gallery Test)
  - Make Sure Rims of Dummies Are Not Severely Worn so as to give a False Reading
  - If Coverage Insufficient Change of the Guard or Stock is Required
- f. Function Testing Must Be Done in the Following Manner:
  - Remove Magazine Assembly and Fully load
  - Place Fully Loaded Magazine Assembly in Trigger Guard Until It Latches
  - Remove Magazine Assembly and Replace while Fully Loaded Twice
    - 1. Once with Bolt Open
    - 2. Once with Bolt Closed
  - Press the Cartridges Downward to Close Bolt on an Empty Chamber
  - Work Action Normally Checking for Any Malfunctions
  - Repeat Steps One or More Times as Required

12 Make All Necessary Repairs from Test

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

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

13 Attach Hang Tag to Trigger Guard

**Operation Tool Detail**

**Operation: 583**

| Tool Number | Tooling Description                             |
|-------------|-------------------------------------------------|
| Std         | Ball Ratchet Screwdriver                        |
| 43447       | Brass Wiping Rod                                |
| Std         | Torque screwdriver - McMaster-Carr Cat# 5652A28 |
| Std         | .032 Feeler Gage - Plastic                      |
| Std         | .076 Feeler Gage - Plastic                      |
| B-70697     | Trigger Pull Scale                              |
| B-TS-7300   | Dent & Scuff Template                           |
| B-49668     | Shell Coverage Gage                             |

|                                                              |  |                                                     |                |                   |           |           |                                     |               |  |
|--------------------------------------------------------------|--|-----------------------------------------------------|----------------|-------------------|-----------|-----------|-------------------------------------|---------------|--|
| <b>PROCESS CONTROL INSPECTION RECORD</b>                     |  |                                                     |                | Revision Date:    |           | 28-Sep-05 |                                     | Processed by: |  |
| THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES |  |                                                     |                |                   |           |           |                                     |               |  |
| <b>Part No:</b>                                              |  | Part Name: Fin Assy 700 Pol                         |                | Centerfire Rifle  |           | Date:     |                                     | 8/14/2006     |  |
| Operation No: 583                                            |  | Operation: Assemble Stock to Action and Attach Hang |                |                   |           |           |                                     | 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<br>REJECT |           |           |                                     |               |  |

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|                            |             |      |                   |  |  |                                                 |
|----------------------------|-------------|------|-------------------|--|--|-------------------------------------------------|
|                            |             |      | INSPECT           |  |  |                                                 |
| 0.02 Feeler Gage - Plastic | Std         | 100% | REJECT<br>INSPECT |  |  |                                                 |
| 0.03 Feeler Gage - Plastic | Std         | 100% | REJECT<br>INSPECT |  |  |                                                 |
| Trigger Pull Scale         | B-70697     | 100% | REJECT<br>INSPECT |  |  |                                                 |
| Dent & Scuff Template      | B-TS-7300   | 100% | REJECT<br>INSPECT |  |  |                                                 |
| Shell Coverage Gage        | B-49668     | 100% | REJECT<br>INSPECT |  |  |                                                 |
|                            |             |      | REJECT<br>INSPECT |  |  |                                                 |
|                            |             |      | REJECT<br>INSPECT |  |  |                                                 |
|                            |             |      | REJECT<br>INSPECT |  |  |                                                 |
|                            |             |      | REJECT<br>INSPECT |  |  |                                                 |
|                            |             |      | REJECT<br>INSPECT |  |  |                                                 |
|                            |             |      | REJECT<br>INSPECT |  |  |                                                 |
|                            |             |      | REJECT            |  |  |                                                 |
|                            | Pieces Run: |      |                   |  |  | Remington Arms Company, Inc. -- Ilion, New York |

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

Operation Step Detail      Operation: 585

Step      Operation / Step Description

Assemble Stock to Action

**PROCEDURE:**

- 1 Select Correct Stock
  - a. Inspect for:
    - Good Finish
    - Marks Slight
    - No Checks
    - Grip Outline Reasonably Uniform and Square
    - Butt Plate
      1. Black Rear Face
      2. No Burrs
      3. .005 Max. Opening at Face
      4. Tight (Finger Test)
      5. Screws Not Project Badly
      6. Burrs at Screw Holes Slight
      7. .02 Max. Mismatch of Butt Plate and Stock Either Way
    - Recoil Pad
      1. Good Color
      2. Rear Face
      3. No Burrs
      4. .005 Max. Opening at Face

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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
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
    - Marrs
    - 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

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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 - 65 IN\*LBS. - per torque spec. Next torque rear take down screw to 65 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

- Vertical Squeeze Produces No Movement

- Guard Screws Tightened to 45 IN - LBS

- .020 Max. Opening Under Trigger Plate Except at Corners

- .025 Max. Opening Under Trigger Plate at Corners

- .025 Max. Opening with Stock

b. Gas Hole in Receiver 50~ Visable Above Stock

c. Check for Trigger Clearance In Guard

- Must Not Bind

- Trigger Must Not Be Exposed Outside of Guard

- A (.030) Shim Must Fit Between End of Trigger and Inside of Guard

- Bow While Trigger is in both the Full Rearward Position and the Relaxed Position

1. IF IT FAILS the SHIM

- SEE PROCEDURE BELOW for Shim PLACEMENT UNDER THE TRIGGER GUARD

Shim Placement Procedure if Required;

a. Remove Trigger Guard from Stock Assembly

b. Apply a Small Amount of Loctite Black Max to the Stock Assembly in the Area Around the Guard Screw holes

c. Remove Non-Stick Back from Shim 92850 Rear Guard Screw Spacer

d. Place the Sticky Side of Spacer to the Wooden Stock

- Align the Rear Guard Hole with the Hole in the Spacer

- Press Firmly to Assure Adhesion

e. Repeat Procedure a. thru d. for the 92849 Front Guard Screw Spacer

e. If Two Shims are Necessary

- Remove the Non-Stick Back from One Shim

- Place It On the Top Surface of the Second Shim

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- Press Firmly Together
- f. Repeat Procedure a. thru e. for Installation of the New Double Shims

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

7A. SUPPLIER FURNISHED, HEAVY BARREL, SYNTHETIC STOCKS ONLY --  
(H-S PRECISION, ETC.)

Check the fit between the Barrel and the barrel channel in the Stock.  
The Barrel should "float" and be positioned centrally in the barrel  
channel.

- a. If the Barrel appears to be central with respect to the channel, no  
further action is needed. Continue with the subsequent steps.
- b. If the Barrel appears off-center, favoring one side or the other, it  
will be necessary to check the clearance between the Barrel and the  
Stock to see if it is within specs.

SPECIFICATION: At a distance of 9 1/2" from the front of the Barrel  
Bracket, the Barrel must be NO CLOSER than .032 and NO FURTHER than  
.076 with respect to the side of the Stock channel.

- c. PROCEDURE: On the close side, a .032 feeler (shim) MUST GO between  
the side of the Barrel and the Stock. (The feeler should stand  
unsupported between the Barrel and the Stock.) On the far side, a  
.076 feeler MUST \*NOT\* GO.

- If the feeler test is successful, continue with subsequent steps.
- If the assembly does not pass the feeler test, replace the Stock.

NOTES: This procedure is done 9 1/2" from the face of the Barrel  
Bracket. The measurement point is approximately 1 1/2" in from the  
front tip of the Stock, about where the bedding pad is found on other  
models. The checks are invalid closer to the Receiver. Do not force

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the feeler gage.

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

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- a. Feeding
- b. Extraction
- c. Ejection
- d. Adjust if Necessary

14. Make All Necessary Repairs from Test

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

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

15. Attach Hang Tag to Trigger Guard

**Operation Tool Detail**

**Operation: 585**

| Tool Number | Tooling Description                             |
|-------------|-------------------------------------------------|
| STD         | Ball Ratchet Screwdriver                        |
| Std         | Torque screwdriver - McMaster-Carr Cat# 5699A28 |
| 43447       | Brass Wiping Rod                                |
| B-70697     | Trigger Pull Scale                              |
| B-TS-7300   | Dent & Scuff Template                           |
| Std         | .032 Feeler Gage - Plastic                      |
| Std         | .076 Feeler Gage - Plastic                      |

|                                                                                                          |                             |                                    |                 |
|----------------------------------------------------------------------------------------------------------|-----------------------------|------------------------------------|-----------------|
| <b>PROCESS CONTROL INSPECTION RECORD</b><br>THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES |                             | Revision Date:<br><b>28-Sep-05</b> | Processed by:   |
| <b>Part No:</b>                                                                                          | Part Name: Fin Assy 700 Pol | Centerfire Rifle                   | Date: 8/14/2006 |

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|                   |
|-------------------|
| Operation No: 585 |
| Prod. Qty:        |

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586 Assemble Stock to Action and Attach Hang  
Tag to Trigger Guard

Operation Step Detail      Operation: 586

Step      Operation / Step Description

Assemble Stock to Action

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.

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 - 65 IN\*LBS - per torque spec. Next torque rear take down screw to 65 IN\*LBS then( ADL'S) the center take down screw SNUG ONLY

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.

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

-----  
SUPPLIER FURNISHED, HEAVY BARREL, SYNTHETIC STOCKS ONLY --  
(H-S PRECISION, ETC.)

Check the fit between the Barrel and the barrel channel in the Stock.  
The Barrel should "float" and be positioned centrally in the barrel  
channel.

- a. If the Barrel appears to be central with respect to the channel, no  
further action is needed. Continue with the subsequent steps.
- b. If the Barrel appears off-center, favoring one side or the other, it  
will be necessary to check the clearance between the Barrel and the  
Stock to see if it is within specs.

SPECIFICATION: At a distance of 9 1/2" from the front of the Barrel  
Bracket, the Barrel must be NO CLOSER than .032 and NO FURTHER than  
.076 with respect to the side of the Stock channel.

- c. PROCEDURE: On the close side, a .032 feeler (shim) MUST GO between  
the side of the Barrel and the Stock. (The feeler should stand  
unsupported between the Barrel and the Stock.) On the far side, a  
.076 feeler MUST \*NOT\* GO.

- If the feeler test is successful, continue with subsequent steps.
- If the assembly does not pass the feeler test, replace the Stock.

NOTES: This procedure is done 9 1/2" from the face of the Barrel  
Bracket. The measurement point is approximately 1 1/2" in from the  
front tip of the Stock, about where the bedding pad is found on other  
models. The checks are invalid closer to the Receiver. Do not force  
the feeler gage.

Check Gunlock Function:

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-----  
Insert key in lock and rotate to the locked position. Assemble the Firing Pin Assembly to the Bolt Assembly in the locked position.

Try to close the Bolt with the safety on and again with the safety off.

- o Bolt should not close.
- o Bolt MAY close with the safety off (Forward position) and the gunlock locked but only with considerable effort. The Firing Pin must NOT fall when the trigger is pulled.

Rotate the gunlock to the unlocked position.

- o Perform regular functional checks at this time. (Feeding, extraction, etc.)

Close the action and rotate the gunlock part way towards the locked position but do NOT allow the detent to engage or click in place. Move the safety to the fire position.

- o Pull the trigger, firing pin should fall only part way.

Rotate the gunlock toward the fire position. Gunlock should lock into a detent position and should not move further.

- o Firing Pin may fall further but still only part way.
- o At this point the action MUST be opened to resume operation on the rifle.

Open the action and insert the key and roll the gunlock part way toward the fire position but do not allow the detent to engage. Close the action and try to fire.

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- o Firing Pin must not fall fully and gunlock should engage a detent.

Open the action, turn the gunlock to the fully unlocked position, return the Safety lever to the safe position (Rearward position) ready for gallery test.

**Operation Tool Detail****Operation: 586**

| Tool Number | Tooling Description                             |
|-------------|-------------------------------------------------|
| Std         | Ball Ratchet Screwdriver                        |
| 43447       | Brass Wiping Rod                                |
| Std         | Torque screwdriver - McMaster-Carr Cat# 5699A28 |
| Std         | .032 Feeler Gage - Plastic                      |
| B-TS-7300   | Dent & Scuff Template                           |
| Std         | .076 Feeler Gage - Plastic                      |
| B-70697     | Trigger Pull Scale                              |

|                                                                                                          |                             |                                                     |  |                            |              |
|----------------------------------------------------------------------------------------------------------|-----------------------------|-----------------------------------------------------|--|----------------------------|--------------|
| <b>PROCESS CONTROL INSPECTION RECORD</b><br>THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES |                             | Revision Date:<br><b>28-Sep-05</b>                  |  | Processed by:              |              |
| <b>Part No:</b>                                                                                          | Part Name: Fin Assy 700 Pol | Centerfire Rifle                                    |  | Date: 8/14/2006            |              |
| Operation No: 586                                                                                        |                             | Operation: Assemble Stock to Action and Attach Hang |  |                            | Work Center: |
| Prod. Qty:                                                                                               | Prod. Order #:              | Operator                                            |  | Setup Inspected by & Date: |              |

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| Page-Description and<br>Characteristic |
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|  |             |  |                                                 |
|--|-------------|--|-------------------------------------------------|
|  | Pieces Run: |  | Remington Arms Company, Inc. -- Ilion, New York |
|--|-------------|--|-------------------------------------------------|

**Extra material found in original VAXcamps process**

PROCEDURE:

1. Select Correct Stock
  - a. Inspect for Good Finish, Marrs Slight, No Checks - Grip Outline Reasonably Uniform and Square
  - b. Butt Plate Black, Rear Face - No Burrs, .005 Max. Opening at Face, Tight (Finger Test), Screws Not Project Badly, Burrs at Screw Holes Slight, .02 Max. Mismatch of Butt Plate and Stock Either Way
  - c. Inspect and Reject for Visual Damage
    - Procedure to Reject Stock if Below Standards
      - a. Hand Print Defect Code Number on Color Dot
      - b. Affix Adhesive Color Dot to Stock Beside the Defect Being Noted
2. Pick Correct Magazine
  - a. Inspect for Color, NO Rust
3. Assemble Magazine to Receiver
4. Select Trigger Guard Assy and place in Stock - Assemble Trigger Guard and Stock to Action with Front and Rear Trigger Guard Screws  
Check for Trigger Clearance In Guard and Floor Plate - 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 Full Rearward or Relaxed Position - If it Fails the Shim, See Procedure Below for Shim Placement Under Trigger Guard

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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. (SYNTHETIC STOCKS ONLY)
- c) Remove Non-Stick Back from Shim - 92850 (Rear Guard Screw Spacer) and Place the Sticky Side of Spacer to the Wooden Stock Aligning the Rear Guard Hole with the Hole in the Spacer and Press Firmly to Assure Adhesion
- d) Repeat Above Procedure for the Shim - 92849 (Front Guard Screw Spacer)
- e) If Two Shims are Necessary, Remove the Non-Stick Back from One Shim and Place it On the Top Surface of the Second Shim and Press Firmly Together - Repeat Above Procedures for the Installation of the Now Double Shims

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

5. Assemble Magazine Spring to Magazine Follower
  - a. Install in Floor Plate
  - b. Adjust Floor Plate to Latch Properly - (See Sample)
6. Inspect Margin at Ejection Port and Receiver Tang, per .030 Sample
  - a. Opening Between Stock & Receiver Should Be Uniform, No Chipped or Scratched Finish
  - b. Vertical Squeeze - No Movement
  - c. Guard Screws tight - See Sample for Max Opening Between Stock & Floor Plate - Reasonable Gap Between Floor Plate and Stock is Acceptable, If Uniform - Reject if Edge is Jagged
  - d. Gas Hole in Receiver 50% Visible Above Stock
7. Check Police Synthetic Stocks at Fore End Tip Each Side of Barrel with .020 Shim - Must Go 1/8"
8. Turn Rifle Over in Vise

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

10. Check Bolt - No Bind - Clears Stock

11. Check Trigger Pull (4.5 to 5.5 lbs.)
  - 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.

12. Use Dummy Cartridges to Check Feeding, Extraction, and Ejection (Single Load and Full Magazine)
  - a. Adjust if Necessary

13. Stamp Assemblers Number on Left Side of Barrel at Rear

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

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588

**PROOF TEST**

Operation Step Detail

Operation: 588

Step

Operation / Step Description

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

I. GUNS TO BE PROOFED

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

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

II. PROOFING OBJECTIVE

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

III. SAFETY

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

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

#### IV. DESCRIPTION AND SEQUENCE OF PROOF TEST

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

#### B. PROOF TEST

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

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

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

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

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Face of Bolt:

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

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

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

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

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

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

10. Check fired case for:

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

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

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

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

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

13. Remove gun from device and place on bench.

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

#### V. INTERPRETATION OF PROOF TEST

##### A. PASS GUN

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

##### B. REJECT GUN

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

#### VI. SAFETY AFTER PROOF TEST

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A. SAFETY

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

B. INSPECT CHAMBER AND MAGAZINE FOR LIVE AMMUNITION

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

C. VISUALLY INSPECT FOR MARRING BY DEVICE OR PORT

1. 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).

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590 ASSEMBLE TRS SCOPE BASE, SCOPE RINGS, &  
TELESCOPE WITH LENS COVERS

Operation Step Detail Operation: 590

Step Operation / Step Description

ASSEMBLE TRS SCOPE BASE, SCOPE RINGS, & TELESCOPE WITH LENS COVERS

|                                                                                                          |  |                                                    |                                   |                  |           |                            |                                     |
|----------------------------------------------------------------------------------------------------------|--|----------------------------------------------------|-----------------------------------|------------------|-----------|----------------------------|-------------------------------------|
| <b>PROCESS CONTROL INSPECTION RECORD</b><br>THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES |  |                                                    | Revision Date<br><b>28-Sep-05</b> |                  |           | Processed by:              |                                     |
| <b>Part No:</b>                                                                                          |  | Part Name: Fin Assy 700 Pol                        |                                   | Centerfire Rifle |           | Date: 8/14/2006            |                                     |
| Operation No: 590                                                                                        |  | Operation: ASSEMBLE TRS SCOPE BASE, SCOPE RINGS, & |                                   |                  |           |                            | Work Center:                        |
| Prod. Qty:                                                                                               |  | Prod. Order #:                                     |                                   | <b>Operator</b>  |           | Setup inspected by & Date: |                                     |
| Gage Description and Characteristic                                                                      |  | Gage Number                                        | Gage Frequency                    | 1st Shift        | 2nd Shift | 3rd Shift                  | Remarks, Causes, Action Taken, Etc. |
| VISUAL                                                                                                   |  | VISUAL                                             | 100%                              | INSPECT          |           |                            |                                     |
|                                                                                                          |  |                                                    |                                   | REJECT           |           |                            |                                     |
|                                                                                                          |  |                                                    |                                   | INSPECT          |           |                            |                                     |
|                                                                                                          |  |                                                    |                                   | REJECT           |           |                            |                                     |
|                                                                                                          |  |                                                    |                                   | INSPECT          |           |                            |                                     |
|                                                                                                          |  |                                                    |                                   | REJECT           |           |                            |                                     |

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593 Assemble Front Swivel Screw and Swivel Screw  
Spacer to Stock

Operation Step Detail      Operation: 593

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

Operation Tool Detail      Operation: 593

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

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594 FUNCTION TEST(100%) AND TARGET(100%)

Operation Step Detail      Operation: 594

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. 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.

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### 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 100%.

### 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.

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

2. With safety in "F" or "OFF" position-close Bolt crisply on empty chamber. Rifle must be pointed in safe direction at all times.

- a. Firing pin must not follow down as Bolt cams shut.
- b. Must not fire on closings.

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

- a. Bolt must raise or open without excessive force.

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

- a. Rifle must not fire

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

- a. Rifle must not fire.

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

7. Move Safety to full rear "S" or "ON" position and then move 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" or "F" position.

9. If safety stops in halfway position, move safety to "F" or

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"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 "A" or "ON" position.

NOTE: Steps 11-13 pertain to guns being tested as 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. | 223 Rem        | 62 gr. HP MATCH           | 5        |
| 2. | 308            | 168 gr. BT HP MATCH       | 4        |
| 3. | 300 Win Mag    | 190 gr. EXTENDED RANGE BT | 3        |
| 4. | 7mm. Rem. Mag. | 140 gr. PSP BT            | 3        |

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

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

15. Open Bolt full stroke to rear position.

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

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expensive match ammunition.

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 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 (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.

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GROUP SIZE SPECIFICATIONS M/700 POLICE:

| CALIBER                 | AMMUNITION TYPE       | MAX. GROUP CENTER TO CENTER<br>5 SHOT |
|-------------------------|-----------------------|---------------------------------------|
| 1. .223 REM (1/8 twist) | 62 HP MATCH           | 1.5                                   |
| 2. .308                 | 168 BT HP MATCH       | 1.5                                   |
| 3. .300 Win Mag         | 190 EXTENDED RANGE BT | 1.5                                   |
| 4. 7mm. Rem. Mag.       | 140 PSP 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
  - c. Group size
28. Reject all rifles that do not meet specifications:
  - a. Enter all malfunctions into the computer and place white repair ticket on rifle.
  - b. If a rifle fails to meet the target group size specifications, reject that rifle and target all remaining.
29. Place rifle back on truck.

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10. Repeat Test on next and succeeding rifle.

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

C. Visual Inspect for marring by device or port.  
check for any possible damage to rifle from the test.

D. All rifles are moved to Ammunition Inspection Area.

Operation Procedure Notes      Operation: 594

Description

NOTE:

1. .308 POLICE DM (1/12 TWIST) TO SHOOT 168 gr. BT HP MATCH AMMO.
2. .223 REM (1/9 twist) to shoot 60 gr. HP MATCH AMMO.

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Operation Tool Detail

Operation: 594

Tool Number

Tooling Description

Plugs

The following is a list of all Close Hard Plugs used during  
test and target in gallery: (POLICE CAL: MARKED \*)

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

(Close Hard Plug Storage Cabinet is D-46202)

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|  |  |  | INSPECT            |  |  |                                                 |
|--|--|--|--------------------|--|--|-------------------------------------------------|
|  |  |  | REJECT<br>INSPECT  |  |  |                                                 |
|  |  |  | REJECT<br>INSPECT  |  |  |                                                 |
|  |  |  | REJECT             |  |  |                                                 |
|  |  |  | <b>Pieces Run:</b> |  |  |                                                 |
|  |  |  |                    |  |  | Remington Arms Company, Inc. -- Ilion, New York |

|                          |  |  |                   |                                                 |  |  |  |
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|                          |  |  | INSPECT           |                                                 |  |  |  |
|                          |  |  | REJECT<br>INSPECT |                                                 |  |  |  |
|                          |  |  | REJECT<br>INSPECT |                                                 |  |  |  |
|                          |  |  | REJECT            |                                                 |  |  |  |
| Pieces Run:              |  |  |                   | Remington Arms Company, Inc. -- Ilion, New York |  |  |  |

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

Operation Step Detail      Operation: 595

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: 595

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|             |                     |
|-------------|---------------------|
| Tool Number | Tooling Description |
| 40789       | Dot Pen Marker      |
| A-51082     | Stylus              |
| E-TS-7583   | Holding Fixture     |

|                                                                                                          |                                               |                |                                    |           |                            |                                     |
|----------------------------------------------------------------------------------------------------------|-----------------------------------------------|----------------|------------------------------------|-----------|----------------------------|-------------------------------------|
| <b>PROCESS CONTROL INSPECTION RECORD</b><br>THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES |                                               |                | Revision Date:<br><b>28-Sep-05</b> |           |                            | Processed by:                       |
| <b>Part No:</b>                                                                                          | Part Name: Fin Assy 700 Pol                   |                | Centerfire Rifle                   |           |                            | Date: 8/14/2006                     |
| Operation No: 595                                                                                        | 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                             |           |                            |                                     |
|                                                                                                          |                                               |                | REJECT                             |           |                            |                                     |
|                                                                                                          |                                               |                | REJECT                             |           |                            |                                     |
|                                                                                                          |                                               |                | REJECT                             |           |                            |                                     |
|                                                                                                          |                                               |                | REJECT                             |           |                            |                                     |
|                                                                                                          |                                               |                | REJECT                             |           |                            |                                     |
|                                                                                                          |                                               |                | REJECT                             |           |                            |                                     |

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596 INSPECT FOR LIVE AMMUNITION

Operation Step Detail Operation: 596

Step Operation / Step Description

INSPECT FOR LIVE AMMUNITION

|                                                                                                          |                                        |                |                                    |           |                            |                                     |  |
|----------------------------------------------------------------------------------------------------------|----------------------------------------|----------------|------------------------------------|-----------|----------------------------|-------------------------------------|--|
| <b>PROCESS CONTROL INSPECTION RECORD</b><br>THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES |                                        |                | Revision Date:<br><b>28-Sep-05</b> |           |                            | Processed by:                       |  |
| Part No:                                                                                                 | Part Name: Fin Assy 700 Pol            |                | Centerfire Rifle                   |           |                            | Date: 8/14/2005                     |  |
| Operation No: 596                                                                                        | Operation: INSPECT FOR LIVE AMMUNITION |                |                                    |           |                            | Work Center:                        |  |
| Prod. Qty:                                                                                               | Prod. Order #:                         | Operator       |                                    |           | Setup Inspected by & Date: |                                     |  |
| Gage Description and Characteristic                                                                      | Gage Number                            | Gage Frequency | 1st Shift                          | 2nd Shift | 3rd Shift                  | Remarks, Causes, Action Taken, Etc. |  |
| VISUAL                                                                                                   | VISUAL                                 | 100%           | INSPECT                            |           |                            |                                     |  |
|                                                                                                          |                                        |                | REJECT                             |           |                            |                                     |  |
|                                                                                                          |                                        |                | INSPECT                            |           |                            |                                     |  |
|                                                                                                          |                                        |                | REJECT                             |           |                            |                                     |  |
|                                                                                                          |                                        |                | INSPECT                            |           |                            |                                     |  |
|                                                                                                          |                                        |                | REJECT                             |           |                            |                                     |  |

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597 CLEAN AND INSPECT

Operation Step Detail Operation: 597

Step Operation / Step Description

CLEAN AND INSPECT

|                                                                                                          |  |                              |                                    |                              |           |                            |                                     |
|----------------------------------------------------------------------------------------------------------|--|------------------------------|------------------------------------|------------------------------|-----------|----------------------------|-------------------------------------|
| <b>PROCESS CONTROL INSPECTION RECORD</b><br>THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES |  |                              | Revision Date:<br><b>28-Sep-05</b> |                              |           | Processed by:              |                                     |
| <b>Part No:</b>                                                                                          |  | Part Name: Fin Assy 700 Pol  |                                    | Centerfire Rifle             |           | Date: 8/14/2005            |                                     |
| Operation No: 597                                                                                        |  | Operation: CLEAN AND INSPECT |                                    |                              |           |                            | 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<br>REJECT<br>INSPECT | /         | /                          |                                     |
|                                                                                                          |  |                              |                                    | REJECT<br>INSPECT            | /         | /                          |                                     |
|                                                                                                          |  |                              |                                    | REJECT<br>INSPECT            | /         | /                          |                                     |
|                                                                                                          |  |                              |                                    | REJECT<br>INSPECT            | /         | /                          |                                     |
|                                                                                                          |  |                              |                                    | REJECT                       | /         | /                          |                                     |

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598 PACK RIFLE AND DELIVER TO WAREHOUSE

Operation Step Detail Operation: 598

Step Operation / Step Description

PACK RIFLE AND DELIVER TO WAREHOUSE

|                                                                                                          |                                                |                |                                    |           |                            |                                     |  |
|----------------------------------------------------------------------------------------------------------|------------------------------------------------|----------------|------------------------------------|-----------|----------------------------|-------------------------------------|--|
| <b>PROCESS CONTROL INSPECTION RECORD</b><br>THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES |                                                |                | Revision Date:<br><b>28-Sep-05</b> |           |                            | Processed by:                       |  |
| Part No:                                                                                                 | Part Name: Fin Assy 700 Pol                    |                | Centerfire Rifle                   |           |                            | Date: 8/14/2005                     |  |
| Operation No: 598                                                                                        | Operation: PACK RIFLE AND DELIVER TO WAREHOUSE |                |                                    |           |                            | Work Center:                        |  |
| Prod. Qty:                                                                                               | Prod. Order #:                                 | Operator       |                                    |           | Setup Inspected by & Date: |                                     |  |
| Gage Description and Characteristic                                                                      | Gage Number                                    | Gage Frequency | 1st Shift                          | 2nd Shift | 3rd Shift                  | Remarks, Causes, Action Taken, Etc. |  |
| VISUAL                                                                                                   | VISUAL                                         | 100%           | INSPECT                            | /         | /                          |                                     |  |
|                                                                                                          |                                                |                | REJECT                             |           |                            |                                     |  |
|                                                                                                          |                                                |                | INSPECT                            |           |                            |                                     |  |
|                                                                                                          |                                                |                | REJECT                             |           |                            |                                     |  |
|                                                                                                          |                                                |                | INSPECT                            |           |                            |                                     |  |
|                                                                                                          |                                                |                | REJECT                             |           |                            |                                     |  |

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600      **Proof Test**

Operation Step Detail      Operation: 600

Step      Operation / Step Description

1. 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 centerfire bores for obstruction with rod.

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.

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

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

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

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

2. Move the safe to the "OFF" 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" position, place assembled gun in proofing rack - muzzle in port.
4. Load one (1) proof round into chamber of barrel.
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. Pull firing button on side of proofing device (to operate triggering mechanism).
8. If gun fails to fire, repeat procedure 6 & 7 listed above.  
If gun fails to fire second time, wait one (1) minute before opening steel doors to remove shell.
  - a. Inspect unfired shell for firing pin indent. If indent appears sufficient to fire round, load another proof round and repeat procedures 4,5,6 & 7.
  - b. If gun fails to fire, wait one (1) minute before removing shell.

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- c. Place safe in "S" or "on" position, remove gun from proof jack and enter gun information and reject in computer.
- 9. After firing, open doors to 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-use fingernail test to determine if serious enough to reject.

NOTE: If primer blows 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 can be found, pass gun. If primer or piece of primer can't be found, enter gun information and reject code in computer, place reject ticket in envelope and place the gun on truck.

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

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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.

## 2. 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 1-B9 (above)
3. If there are no serious visual defects found on wood or metal surfaces of the gun.

### B. REJECT GUN

1. If gun fails to withstand proof round pressure.
2. If fired case fails to meet visual specifications.
3. If any serious visual defects are found before or after test.

## 3. SAFETY AFTER PROOF TEST

### A. SAFETY

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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. Repeat item B 1 and 2 (above) 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).

Operation Procedure Notes      Operation: 600

Description

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

1. 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 BOOTHS)

2. 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.

3. SAFETY

- a. Water tanks are to be inspected each shift before shooting is started  
and inspection sheet is to be signed. (Refer to General Gallery Safety  
Rules, Section K.)
- b. All assembled guns are to be stored with the action open and the safe in  
the "S" or "on" position.
- c. If proof round fails to fire when activated:
1. Pull large knob on side of proofing device and hold (black handle).
  2. Pull firing button on side of proofing device (black button)
  3. If fails to fire second time, wait on (1) minute before opening  
steel doors to remove shell.

|                                                                                                             |                                        |               |
|-------------------------------------------------------------------------------------------------------------|----------------------------------------|---------------|
| <b>PROCESS CONTROL INSPECTION RECORD</b><br>THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL<br>TIMES | Revision Date:<br><br><b>28-Sep-05</b> | Processed by: |
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**Part No:**

Operation No: 600

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600R

#### Proof Test with slave bolt

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

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

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

Operate bolt release and remove original bolt assembly.

Place slave bolt assembly in action.

Place original bolt assembly aside in holder.

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

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

Load proof round into chamber and close the action.

Close device doors and proof the rifle.

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

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

Open the slave bolt and remove it from the action.

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Fired proof case will remain in the chamber.

Remove original bolt assembly from holder and insert in rifle.

Place slave bolt assembly in holder.

Operate the original bolt to engage the fired case for extraction and ejection.

If original bolt fails to engage the fired case, remove it with a rod down the bore.

Remove the rifle from device, stamp "REP" proof mark if gun passes.

Do NOT mark the bolt handle with a prick-punch.

Return rifle to gun truck and continue with succeeding rifles.

| PROCESS CONTROL INSPECTION RECORD                      |                                       |                | Revision Date: 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<br>REJECT       |           |                            |                                     |
|                                                        |                                       |                | INSPECT<br>REJECT       |           |                            |                                     |
|                                                        |                                       |                | INSPECT<br>REJECT       |           |                            |                                     |
|                                                        |                                       |                | INSPECT<br>REJECT       |           |                            |                                     |
|                                                        |                                       |                | INSPECT<br>REJECT       |           |                            |                                     |
|                                                        |                                       |                | INSPECT<br>REJECT       |           |                            |                                     |
|                                                        |                                       |                | INSPECT<br>REJECT       |           |                            |                                     |
|                                                        |                                       |                | INSPECT<br>REJECT       |           |                            |                                     |
|                                                        |                                       |                | INSPECT<br>REJECT       |           |                            |                                     |
|                                                        |                                       |                | INSPECT<br>REJECT       |           |                            |                                     |
|                                                        |                                       |                | INSPECT<br>REJECT       |           |                            |                                     |
|                                                        |                                       |                | INSPECT<br>REJECT       |           |                            |                                     |
|                                                        |                                       |                | INSPECT<br>REJECT       |           |                            |                                     |
|                                                        |                                       |                | INSPECT<br>REJECT       |           |                            |                                     |
|                                                        |                                       |                | INSPECT<br>REJECT       |           |                            |                                     |

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|                                                                                                          |                                       |                                    |                 |
|----------------------------------------------------------------------------------------------------------|---------------------------------------|------------------------------------|-----------------|
| <b>PROCESS CONTROL INSPECTION RECORD</b><br>THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES |                                       | Revision Date:<br><b>28-Sep-05</b> | Processed by:   |
| <b>Part No:</b>                                                                                          | Part Name: Fin Assy 700 Pol           | Centerfire Rifle                   | Date: 8/14/2006 |
| Operation No: 600R                                                                                       | Operation: Proof Test with slave bolt |                                    | Work Center:    |

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|                                    |  |
|------------------------------------|--|
| Prod. Qty.                         |  |
| Page Description and<br>Unit Price |  |

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## Pieces Run:

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

Operation Step Detail Operation: 605R

Step Operation / Step Description

Check previously rejected guns for proof stamp and obstruction in barrel.

|                                                                                                          |  |                                                         |                                    |                   |           |                            |                                     |
|----------------------------------------------------------------------------------------------------------|--|---------------------------------------------------------|------------------------------------|-------------------|-----------|----------------------------|-------------------------------------|
| <b>PROCESS CONTROL INSPECTION RECORD</b><br>THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES |  |                                                         | Revision Date:<br><b>28-Sep-05</b> |                   |           | Processed by:              |                                     |
| Part No:                                                                                                 |  | Part Name: Fin Assy 700 Pol                             |                                    | 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<br>INSPECT |           |                            |                                     |
|                                                                                                          |  |                                                         |                                    | REJECT<br>INSPECT |           |                            |                                     |
|                                                                                                          |  |                                                         |                                    | REJECT<br>INSPECT |           |                            |                                     |

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## 606 Test and Target 100%

Operation Step Detail      Operation: 606

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

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

### 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. Record results of testing in computer as test and target operations are performed.

#### II. TEST AND TARGET OBJECTIVES

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

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for proper operation of the Safety.

- B. Accuracy: To check the ability of each rifle to satisfactorily meet specifications for point of impact and/or group size.
- C. Visual: To check the ability of each rifle to satisfactorily meet appearance specifications for front and rear sights and general overall presentability.

### III. SHOOTING JACKS AND DEVICE

- A. When performing an accuracy evaluation on a rifle use the accuracy device.
  - 1. Adjust and set device with master rifle if the caliber and model to be shot is produced with iron sights.
  - 2. Use 1" by 1" grid type targeting paper.
- B. When performing a function test, either the accuracy device or a centerfire 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 100%.

### IV. DESCRIPTION OF TEST AND TARGET PROCEDURES AND SPECIFICATIONS:

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

#### A. Test/Target Description

- 1. Pick up rifle from truck and inspect for:
  - a. Live Ammo - Inspect chamber and Magazine-both must be empty.
  - b. Caliber - To verify for shooter personal safety in

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- selecting ammunition for test.
- c. Proof mark on Barrel - (REP) must be present, right rear side of barrel, ahead of Magnaflux stamp.
  - d. Proof mark on Bolt - (.) Prick punch mark must be present at bottom of Bolt handle.
  - e. Visual Defects - Marring of wood or metal finishes.
- If not within specifications for items a-e above, reject guns at this point.
- 2. With safety in "F" or "OFF" position close Bolt crisply on empty chamber. Rifle must be pointed in safe direction at all times.
    - a. Firing pin must not follow down as Bolt cams shut.
    - b. Must not fire on closings.
  - 3. With Safety in "S" or "on" position and the action closed, raise the bolt.
    - a. Bolt must raise or open without excessive force.
  - 4. Close Bolt with safety in "'S" or "on" position - pull trigger firmly.
    - a. Rifle must not fire
  - 5. With finger off Trigger-move safety to "F" or "OFF" position.
    - a. Rifle must not fire.
  - 6. Open and close Bolt full stroke to cock firing pin.
  - 7. Move Safety to full rear "S" or "ON" position and then move half way to the "F" or "OFF" position with thumb.

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8. If safety stops at half-way position-pull trigger.
  - a. Rifle must not fire.
  - b. Safety must not move to full "OFF" or "FIRE" position.
9. If safety stops in half-way 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 lock 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.
  - c. Load magazine to capacity: (see chart below)

| CALIBER       | AMMUNITION TYPE           | MAG. CAP |
|---------------|---------------------------|----------|
| 223 Rem       | 62 gr. HP MATCH           | 5        |
| 308           | 168 gr. BT HP MATCH       | 4        |
| 300 SAUM      | 180 gr. PSP               | 3        |
| 300 Wir. Mag. | 190 gr. EXTENDED RANGE BT | 3        |

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

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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 100% of Police rifles that are targeted, check each shot with spotting scope for rifle "seating in" and position of shots on paper. Use a maximum of 3 "seater" rounds per rifle.
  - a. Adjust device if shots off paper or group too close to edge.
21. Operate action full cycle to extract, eject, and feed each shot.
  - a. Bolt should not pull out of receiver.
  - b. Case or shell must be retained by extractor until the case is ejected from receiver.
  - c. Case must be completely ejected from receiver, should not catch on receiver.
  - d. One fired case from each rifle must be visually inspected for firing pin indent and chamber marks reflected on case. Slight rings are permissible; if ring is large enough to pick with fingernail, reject the rifle.
22. Fire all rounds required for Test and Targeting.
  - a. For the Test procedure, each rifle is to have the first two (2) rounds fired and the remaining rounds cycled through but not fired.
  - b. For the Target procedure, all accuracy specifications are based on groups consisting of 5 shots, therefore, those rifles will typically require extra rounds to be loaded and shot singly. See chart below for acceptable group sizes.

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23. Open guard. (If on accuracy device)
24. For the Targeted rifles (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

| MAX. GROUP CENTER TO CENTER |                               |              |
|-----------------------------|-------------------------------|--------------|
| CALIBER                     | AMMUNITION TYPE               | 5 SHOT GROUP |
| 223 Rem(1/9 twist)          | 62 gr. HP MATCH               | 1.5          |
| 308 Win.                    | 168 gr. BT HP MATCH           | 1.5          |
| 300 Win. Mag.               | 180 gr. PSPCL - 190 gr. PSPCL | 2.5          |
| 300 Rem Ultra Mag           | 180 gr. PSPCL                 | 2.5          |
| 300 SA Ultra Mag            | 180 gr. PSPCL                 | 2.5          |
| 6.8mm Rem.                  | 115 gr. HPBT                  | 1.5          |
| 7MM Rem. Mag.               | 140 gr. PSP BT                | 2.5          |

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

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- b. Functional
- c. Group size

28. Reject all rifles that do not meet specifications:

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

29. Place rifle back on truck.

30. Repeat Test on next and succeeding rifles.

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

##### C. Visual Inspect for marring by device or port.

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- C. 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 Procedure Notes      Operation: 606**

**Description**

**NOTE:**

1. .308 POLICE DM (1/12 TWIST) TO SHOOT 165 gr. BT HP MATCH AMMO.
2. .223 REM (1/9 twist) to shoot 60 gr. HP MATCH AMMO.
3. 7mm. Rem. Mag. (1/9 1/4 twist) to shoot 140 gr. P3E BT ammo.

**Operation Tool Detail      Operation: 606**

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

**Muzzle Chamfer Tools**

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

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Plugs

The following is a list of all Close Hard Plugs used during  
test and target in gallery: (POLICE CAL MARKED \*)

| CALIBER            | USE CLOSE HARD PLUG  |
|--------------------|----------------------|
| 7MM REM MAG.       | C-46200-B            |
| 300 WIN. MAG.      | C-46200-A            |
| .223 REM.*         | C-46198 OR D-48349-C |
| 308 Win.           | C-46194 OR D-48349-H |
| 6.8mm Rem. ITR     |                      |
| 300 S/A ULTRA MAG. |                      |
| 300 ULTRA MAG.     | D-48349-T            |

(Close Hard Plug Storage Cabinet is D-46202)

| PROCESS CONTROL INSPECTION RECORD                            |                                 |                |                  | Revision Date: |                            | Processed by:                       |           |
|--------------------------------------------------------------|---------------------------------|----------------|------------------|----------------|----------------------------|-------------------------------------|-----------|
| THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES |                                 |                |                  | 28-Sep-05      |                            |                                     |           |
| Part No:                                                     | Part Name: Fin Assy 700 Pol     |                | Centerfire Rifle |                | Date:                      |                                     | 8/14/2005 |
| Operation No: 606                                            | 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           |                |                            |                                     |           |

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Subject to Protective Order - Williams v. Remington

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620      ~~Inspect For Live Ammunition~~

Operation Step Detail      Operation: 620

Step      Operation / Step Description

Inspect for live ammunition

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

|                                                                                                          |  |                                           |                                    |                   |           |                            |                                     |
|----------------------------------------------------------------------------------------------------------|--|-------------------------------------------|------------------------------------|-------------------|-----------|----------------------------|-------------------------------------|
| <b>PROCESS CONTROL INSPECTION RECORD</b><br>THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES |  |                                           | Revision Date:<br><b>28-Sep-05</b> |                   |           | Processed by:              |                                     |
| <b>Part No:</b>                                                                                          |  | Part Name:    Fin Assy 700 Pol            |                                    | 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<br>INSPECT |           |                            |                                     |
|                                                                                                          |  |                                           |                                    | REJECT<br>INSPECT |           |                            |                                     |
|                                                                                                          |  |                                           |                                    | REJECT<br>INSPECT |           |                            |                                     |

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640 Final Inspection

Operation Step Detail      Operation: 640

Step      Operation / Step Description

FINAL INSPECTION

SEQUENCE OF INSPECTION POINTS (See Following)

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

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

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

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

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

3. SPECIFICATIONS

a. Gun Matches 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. BDL

5. STOCK

a. Inspect for Handling Damage

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

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- D. Trigger Guard Screws Tight
- E. Assemble Correct Rear Swivel - If Specified on Gun Tag
- b. Stock Rejects only:
  - 1. Place 3/4" Yellow Dot with Identification Stamp and Nonconformity Code, Close to Nonconformity on Stock Rejects

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):

-----

SUPPLIER FURNISHED, HEAVY BARREL, SYNTHETIC STOCKS ONLY --  
(H-S PRECISION, ETC.)

Check the fit between the Barrel and the barrel channel in the Stock. The Barrel should "float" and be positioned centrally in the barrel channel.

- a. If the Barrel appears to be central with respect to the channel, no further action is needed. Continue with the subsequent steps.
- b. If the Barrel appears off-center, favoring one side or the other, it will be necessary to check the clearance between the Barrel and the Stock to see if it is within specs.

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SPECIFICATION: At a distance of 9 1/2" from the front of the Barrel Bracket, the Barrel must be NO CLOSER than .032 and NO FURTHER than .076 with respect to the side of the Stock channel.

c. PROCEDURE: On the close side, a .032 feeler (shim) MUST GO between the side of the Barrel and the Stock. The feeler should stand unsupported between the Barrel and the Stock. On the far side, a .076 feeler MUST NOT GO.

- If the feeler test is successful, continue with subsequent steps.
- If the assembly does not pass the feeler test, reject the rifle.

NOTES: This procedure is done 9 1/2" from the face of the Barrel Bracket. The measurement point is approximately 1 1/2" in from the front tip of the Stock, about where the bedding pad is found on other models. The checks are invalid closer to the Receiver. Do not force the feeler gage.

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

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Hammer Handle

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

**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

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- 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
  - i. 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                              |
| STD         | Dummy Cartridge Rounds of proper Caliber being built.    |
| B-70697     | Trigger Pull - Scale                                     |
| A-43977     | Trigger clearance shim tool (.030)                       |
| Std         | .032 Feeler Gage - Plastic                               |
| Std         | .076 Feeler Gage - Plastic                               |

|                                                                                                          |                                |                  |           |               |
|----------------------------------------------------------------------------------------------------------|--------------------------------|------------------|-----------|---------------|
| <b>PROCESS CONTROL INSPECTION RECORD</b><br>THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES |                                | Revision Date:   | 28-Sep-05 | Processed by: |
|                                                                                                          |                                |                  |           |               |
| Part No:                                                                                                 | Part Name:    Fin Assy 700 Pol | Centerfire Rifle | Date:     | 8/14/2006     |

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|                                                       |             |                             |                   |           |           |                                     |  |
|-------------------------------------------------------|-------------|-----------------------------|-------------------|-----------|-----------|-------------------------------------|--|
| 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%                        | REJECT<br>INSPECT |           |           |                                     |  |
| Wood Dents & Scuff Template                           | BTS-7300    | 100%                        | REJECT<br>INSPECT |           |           |                                     |  |
| Dummy Cartridge Rounds of proper Caliber being built. | STD         | 100%                        | REJECT<br>INSPECT |           |           |                                     |  |
| Trigger Pull - Scale                                  | B-70697     | 100%                        | REJECT<br>INSPECT |           |           |                                     |  |
| Trigger clearance shim loc: (.030)                    | A-43977     | 100%                        | REJECT<br>INSPECT |           |           |                                     |  |
| .032 Feeler Gage - Plastic                            | Std         | 100%                        | REJECT<br>INSPECT |           |           |                                     |  |
| .076 Feeler Gage - Plastic                            | Std         | 100%                        | REJECT<br>INSPECT |           |           |                                     |  |
|                                                       |             |                             | REJECT<br>INSPECT |           |           |                                     |  |
|                                                       |             |                             | REJECT<br>INSPECT |           |           |                                     |  |
|                                                       |             |                             | REJECT<br>INSPECT |           |           |                                     |  |



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648

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

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

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

Try (3) Times

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

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

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

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- b. Do not break the seal on, or tamper with the other 2 screws.
5. Redcheck the trigger pull with the pull scale.
  - a. Hold the pullscales 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<br>REJECT       | /         | /                          |                                     |
|                                                        |                                                       |                | INSPECT<br>REJECT       | /         | /                          |                                     |
|                                                        |                                                       |                | INSPECT<br>REJECT       | /         | /                          |                                     |
|                                                        |                                                       |                | INSPECT<br>REJECT       | /         | /                          |                                     |
|                                                        |                                                       |                | INSPECT<br>REJECT       | /         | /                          |                                     |
|                                                        |                                                       |                | INSPECT<br>REJECT       | /         | /                          |                                     |

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| PROCESS CONTROL INSPECTION RECORD<br>THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES |                                                      |                  | Revision Date:<br><b>28-Sep-05</b> |           |                            | Processed by:                       |
|---------------------------------------------------------------------------------------------------|------------------------------------------------------|------------------|------------------------------------|-----------|----------------------------|-------------------------------------|
| Part No:                                                                                          | Part Name:                                           | Centerfire Rifle |                                    |           | Date:                      | 8/14/2006                           |
| Operation No: 648                                                                                 | Operation: Reset trigger pull within specs as needed |                  |                                    |           | Work Center:               |                                     |
| Prod. Qty:                                                                                        | Prod. Order #                                        | Operator         |                                    |           | Setup Inspected by & Date: |                                     |
| Gage Description and Characteristic                                                               | Gage Number                                          | Gage Frequency   | 1st Shift                          | 2nd Shift | 3rd Shift                  | Remarks, Causes, Action Taken, Etc. |
| VISUAL                                                                                            | VISUAL                                               | 100%             | INSPECT                            |           |                            |                                     |
|                                                                                                   |                                                      |                  | REJECT<br>INSPECT                  |           |                            |                                     |
|                                                                                                   |                                                      |                  | REJECT<br>INSPECT                  |           |                            |                                     |
|                                                                                                   |                                                      |                  | REJECT<br>INSPECT                  |           |                            |                                     |
|                                                                                                   |                                                      |                  | REJECT<br>INSPECT                  |           |                            |                                     |
|                                                                                                   |                                                      |                  | REJECT<br>INSPECT                  |           |                            |                                     |
|                                                                                                   |                                                      |                  | REJECT<br>INSPECT                  |           |                            |                                     |
|                                                                                                   |                                                      |                  | REJECT<br>INSPECT                  |           |                            |                                     |
|                                                                                                   |                                                      |                  | REJECT<br>INSPECT                  |           |                            |                                     |
|                                                                                                   |                                                      |                  | REJECT                             |           |                            |                                     |



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650      Inspect Heading and Sear Lift

Operation Step Detail      Operation: 650

Step      Operation / Step Description

Inspect Heading and Sear Lift

Inspect Heading

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

Sear Lift Test

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

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- b. If the Sear Binds or Drags, REJECT THE RIFLE - Mark Reject Reason on Reject Ticket
- 6 Release Trigger
- 7 Keep Safety in "F" Position
- 8 Insert Attribute Gage Fully Into Receiver
  - a. This MUST Stop on Sear
  - b. If Gage Goes In Fully (or Pin on Bottom Overrides Sear), REJECT THIS RIFLE - Mark Reject Reason on Reject Ticket
- 9 Remove Attribute Gage
- 10 Insert Dial Gage Fully into Receiver
  - a. Pin MUST Stop on Sear
- 11 Release Lever and Set Dial to Zero
- 12 Move Safety to "S" Position
- 13 Observe Dial - Lift MUST be .008/.0018
  - 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<br>Note: Use with 5/64 Balldriver Hex Tool Bondhus Cat. |

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#10604, Series 106, or equivalent.

C-47741 Attribute Gage  
C-41155-A 223 REM MIN Heading Plug  
C-41155-C 223 REM IMAX Heading Plug  
C-41556-A 308 WIN MIN Heading Plug  
C-41556-C 308 WIN IMAX Heading Plug  
C-41546-A 300 WIN MIN Heading Plug  
C-41546-C 300 WIN IMAX Heading Plug  
C-83853-A 300 Win BELT - MIN Heading Plug  
C-83853-C 300 Win BELT - IMAX Heading Plug  
C-41561-A 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-35413-A 300 RUM MIN Heading Plug  
C-35413-C 300 RUM IMAX Heading Plug  
C-49963-A 300 SAUM MIN Heading Plug  
C-49963-C 300 SAM IMAX Heading Plug

| PROCESS CONTROL INSPECTION RECORD                            |                             |                                          | Revision Date:    |           |                            | Processed by:                       |  |  |
|--------------------------------------------------------------|-----------------------------|------------------------------------------|-------------------|-----------|----------------------------|-------------------------------------|--|--|
| THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES |                             |                                          | 28-Sep-05         |           |                            |                                     |  |  |
| Part No:                                                     | Part Name: Fin Assy 700 Pol |                                          | Centerfire Rifle  |           |                            | Date: 8/14/2006                     |  |  |
| Operation No: 650                                            |                             | Operation: Inspect Heading and Sear Lift |                   |           |                            | Work Center:                        |  |  |
| Prod. Qty:                                                   | Prod. Order #:              | Operator                                 |                   |           | Setup Inspected by & Date: |                                     |  |  |
| Gage Description and Characteristic                          | Gage Number                 | Gage Frequency                           | 1st Shift         | 2nd Shift | 3rd Shift                  | Remarks, Causes, Action Taken, Etc. |  |  |
| VISUAL                                                       | VISUAL                      | 100%                                     | INSPECT<br>REJECT |           |                            |                                     |  |  |

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|                           |           |      |                   |  |  |  |
|---------------------------|-----------|------|-------------------|--|--|--|
|                           |           |      | INSPECT           |  |  |  |
| Dial Gage                 | D-44581   | 100% | REJECT<br>INSPECT |  |  |  |
| Altitude Gage             | C-47741   | 100% | REJECT<br>INSPECT |  |  |  |
| 223 REM MIN Heading Plug  | C-41155-A | 100% | REJECT<br>INSPECT |  |  |  |
| 223 REM IMAX Heading Plug | C-41155-C | 100% | REJECT<br>INSPECT |  |  |  |
| 223 REM MIN Heading Plug  | C-41155-A | 100% | REJECT<br>INSPECT |  |  |  |
| 223 REM IMAX Heading Plug | C-41155-C | 100% | REJECT<br>INSPECT |  |  |  |
| 223 REM MIN Heading Plug  | C-41155-A | 100% | REJECT<br>INSPECT |  |  |  |
| 223 REM IMAX Heading Plug | C-41155-C | 100% | REJECT<br>INSPECT |  |  |  |
| 223 REM MIN Heading Plug  | C-41155-A | 100% | REJECT<br>INSPECT |  |  |  |
| 223 REM IMAX Heading Plug | C-41155-C | 100% | REJECT<br>INSPECT |  |  |  |
| 223 REM MIN Heading Plug  | C-41155-A | 100% | REJECT<br>INSPECT |  |  |  |
| 223 REM IMAX Heading Plug | C-41155-C | 100% | REJECT            |  |  |  |

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|                           |           |      |                   |  |  |  |
|---------------------------|-----------|------|-------------------|--|--|--|
|                           |           |      | INSPECT           |  |  |  |
| 308 WIN MIN Heading Plug  | C-41556-A | 100% | REJECT<br>INSPECT |  |  |  |
| 308 WIN IMAX Heading Plug | C-41556-C | 100% | REJECT<br>INSPECT |  |  |  |
| 308 WIN MIN Heading Plug  | C-41556-A | 100% | REJECT<br>INSPECT |  |  |  |
| 308 WIN IMAX Heading Plug | C-41556-C | 100% | REJECT<br>INSPECT |  |  |  |
| 308 WIN MIN Heading Plug  | C-41556-A | 100% | REJECT<br>INSPECT |  |  |  |
| 308 WIN IMAX Heading Plug | C-41556-C | 100% | REJECT<br>INSPECT |  |  |  |
| 308 WIN MIN Heading Plug  | C-41556-A | 100% | REJECT<br>INSPECT |  |  |  |
| 308 WIN IMAX Heading Plug | C-41556-C | 100% | REJECT<br>INSPECT |  |  |  |
| 308 WIN MIN Heading Plug  | C-41556-A | 100% | REJECT<br>INSPECT |  |  |  |
| 308 WIN IMAX Heading Plug | C-41556-C | 100% | REJECT<br>INSPECT |  |  |  |
| 308 WIN MIN Heading Plug  | C-41556-A | 100% | REJECT<br>INSPECT |  |  |  |
| 308 WIN IMAX Heading Plug | C-41556-C | 100% | REJECT            |  |  |  |

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|                                  |           |      |                   |  |  |  |
|----------------------------------|-----------|------|-------------------|--|--|--|
|                                  |           |      | INSPECT           |  |  |  |
| 308 WIN MIN Heading Plug         | C-41556-A | 100% | REJECT<br>INSPECT |  |  |  |
| 308 WIN IMAX Heading Plug        | C-41556-C | 100% | REJECT<br>INSPECT |  |  |  |
| 308 WIN MIN Heading Plug         | C-41556-A | 100% | REJECT<br>INSPECT |  |  |  |
| 308 WIN IMAX Heading Plug        | C-41556-C | 100% | REJECT<br>INSPECT |  |  |  |
| 308 WIN MIN Heading Plug         | C-41556-A | 100% | REJECT<br>INSPECT |  |  |  |
| 308 WIN IMAX Heading Plug        | C-41556-C | 100% | REJECT<br>INSPECT |  |  |  |
| 300 Win BELT - MIN Heading Plug  | C-83853-A | 100% | REJECT<br>INSPECT |  |  |  |
| 300 Win BELT - IMAX Heading Plug | C-83853-C | 100% | REJECT<br>INSPECT |  |  |  |
| 300 Win MIN Heading Plug         | C-41546-A | 100% | REJECT<br>INSPECT |  |  |  |
| 300 Win IMAX Heading Plug        | C-41546-C | 100% | REJECT<br>INSPECT |  |  |  |
| 300 Win BELT - MIN Heading Plug  | C-83853-A | 100% | REJECT<br>INSPECT |  |  |  |
| 300 Win BELT - IMAX Heading Plug | C-83853-C | 100% | REJECT            |  |  |  |

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|                                     |           |      |                   |  |  |  |
|-------------------------------------|-----------|------|-------------------|--|--|--|
|                                     |           |      | INSPECT           |  |  |  |
| 300 Win MIN Heading Plug            | C-41546-A | 100% | REJECT<br>INSPECT |  |  |  |
| 300 Win IMAX Heading Plug           | C-41546-C | 100% | REJECT<br>INSPECT |  |  |  |
| 7MM Mag BELT - MIN<br>Heading Plug  | C-83853-A | 100% | REJECT<br>INSPECT |  |  |  |
| 7MM Mag BELT - IMAX<br>Heading Plug | C-83853-C | 100% | REJECT<br>INSPECT |  |  |  |
| 7MM Mag MIN Heading<br>Plug         | C-41561-A | 100% | REJECT<br>INSPECT |  |  |  |
| 7MM Mag IMAX Heading<br>Plug        | C-41561-C | 100% | REJECT<br>INSPECT |  |  |  |
| 300 RUM MIN Heading Plug            | C-35413-A | 100% | REJECT<br>INSPECT |  |  |  |
| 300 RUM IMAX Heading<br>Plug        | C-35413-C | 100% | REJECT<br>INSPECT |  |  |  |
|                                     |           |      | REJECT<br>INSPECT |  |  |  |
|                                     |           |      | REJECT<br>INSPECT |  |  |  |
|                                     |           |      | REJECT<br>INSPECT |  |  |  |
|                                     |           |      | REJECT<br>INSPECT |  |  |  |
|                                     |           |      | REJECT            |  |  |  |



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

Operation Step Detail      Operation: 655

Step      Operation / Step Description

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

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

Operation Tool Detail      Operation: 655

Tool Number

### Tooling Description

40789

Dot Peen Marker

A-51082

## Stylus

~~ETS-7583~~

## Holding Fixture

[illegible]

Subject to Protective Order - Williams v. Remington

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676      Pack Rifle  
                                 To Warehouse

Operation Step Detail      Operation: 676

Step      Operation / Step Description

Print Box End label and Pack Rifle

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

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8. Remove VGN Tape for European Sales
9. Remove Bolt assy. from rifle, verify last 4 digits of serial # that is marked on Bolt assy., and pack bolt assy.
10. Pack Rifle into Box.
11. Place Owners Manual in box over Stock
12. Seal Box using reinforced packing tape.
13. 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                                    |

|                                                              |                             |                  |           |               |
|--------------------------------------------------------------|-----------------------------|------------------|-----------|---------------|
| <b>PROCESS CONTROL INSPECTION RECORD</b>                     |                             | Revision Date:   | 28-Sep-05 | Processed by: |
| THIS RECORD MUST STAY WITH THE PRODUCTION ORDER AT ALL TIMES |                             |                  |           |               |
| Part No:                                                     | Part Name: Fin Assy 700 Pol | Centerfire Rifle | Date:     | 8/14/2006     |
| Operation No: 676                                            | Operation: Pack Rifle       | Work Center:     |           |               |

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|                                    |  |
|------------------------------------|--|
| Prod. Qty.                         |  |
| Page Description and<br>Unit Price |  |

Order - William

[illegible]

## Pieces Run:

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| Dept | Oper | Operation Description                                                                                | Part Numbers                                                                                                                                                                                       |
|------|------|------------------------------------------------------------------------------------------------------|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| 9132 | 1    | Issue from Crib                                                                                      | 25743 25744 25745<br>25746 25707 25709<br>25715 25747 25726<br>25714 25717 25713<br>25718 25735 25711<br>25737 25739 25712<br>25681 26175 26177<br>26179 26181 25635<br>25677 25657 25639<br>27503 |
| 8761 | 395  | INSPECT COMPONENTS BEFORE HEADING                                                                    | 25743 25744 25745<br>25746 25707 25709<br>25715 25747 25726<br>25714 25717 25713<br>25718 25735 25711<br>25737 25739 25712<br>25681 26175 26177<br>26179 26181 25635<br>25677 25657 25639<br>27503 |
| 8761 | 400  | Fit and Head Bolt Assembly to Barrel Assembly<br>(SHOULDER SINGLE PASS)                              | 25744 25746 25747<br>25709 25715 25712<br>25713 25739 25711<br>26175 26177 26179<br>26181 25635 25735<br>25681 25677 25657<br>25639 27503                                                          |
| 8761 | 405  | Fit and Head Bolt Assembly to Barrel Assembly<br>(SHOULDER SINGLE PASS: Smaller than .25<br>caliber) | 25743 25745 25714<br>25707 25737                                                                                                                                                                   |
| 8761 | 415  | Fit and Head Bolt Assembly to Barrel Assy and<br>Chamber to Length (BELTED - MAGNUMS)                | 25717 25718 25726                                                                                                                                                                                  |
| 8761 | 420  | Ream Chamber to Deburr<br>(BELTED - MAGNUMS)                                                         | 25717 25718 25726                                                                                                                                                                                  |
| 8761 | 425  | Make Chamber Cast (Not Done on 100% of Product)                                                      | 25743 25744 25745<br>25746 25707 25709                                                                                                                                                             |

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| Dept | Oper | Operation Description                                                                  | Part Numbers      |
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|      |      |                                                                                        | 25715 25747 25726 |
|      |      |                                                                                        | 25714 25717 25713 |
|      |      |                                                                                        | 25718 25735 25711 |
|      |      |                                                                                        | 25737 25739 25712 |
|      |      |                                                                                        | 25681 26175 26177 |
|      |      |                                                                                        | 26179 26181 25635 |
|      |      |                                                                                        | 25677 25657 25639 |
|      |      |                                                                                        | 27503             |
| 8761 | 430  | Ream Ejector Hole                                                                      | 25743 25744 25745 |
|      |      |                                                                                        | 25746 25707 25709 |
|      |      |                                                                                        | 25715 25714 25717 |
|      |      |                                                                                        | 25713 25718 25735 |
|      |      |                                                                                        | 25737 25739 25747 |
|      |      |                                                                                        | 25711 25712 25726 |
|      |      |                                                                                        | 25681 26175 26177 |
|      |      |                                                                                        | 26179 26181 25635 |
|      |      |                                                                                        | 25677 25657 25639 |
|      |      |                                                                                        | 27503             |
| 8761 | 432  | Assemble Riveted Extractor to Bolt - (MAGNUMS)                                         | 25717 25718 25735 |
|      |      |                                                                                        | 25726 25681       |
| 8761 | 435  | Assemble Rivetless Extractor to Bolt                                                   | 25743 25744 25745 |
|      |      |                                                                                        | 25707 25709 25715 |
|      |      |                                                                                        | 25714 25713 25746 |
|      |      |                                                                                        | 25737 25739 25747 |
|      |      |                                                                                        | 25711 25712 26175 |
|      |      |                                                                                        | 26177 26179 26181 |
|      |      |                                                                                        | 25635 25677 25657 |
|      |      |                                                                                        | 25639 27503       |
| 8761 | 440  | Assemble Ejector to Ejector Spring and then<br>Assemble to Bolt with Ejector Cross Pin | 25743 25744 25745 |
|      |      |                                                                                        | 25746 25707 25709 |
|      |      |                                                                                        | 25715 25714 25717 |
|      |      |                                                                                        | 25713 25718 25735 |
|      |      |                                                                                        | 25737 25739 25747 |
|      |      |                                                                                        | 25711 25712 25726 |
|      |      |                                                                                        | 25681 26175 26177 |
|      |      |                                                                                        | 26179 26181 25635 |
|      |      |                                                                                        | 25677 25657 25639 |
|      |      |                                                                                        | 27503             |
| 8761 | 460R | Strip Defective Barrel Assembly Complete                                               | 25743 25744 25745 |
|      |      |                                                                                        | 25746 25707 25709 |
|      |      |                                                                                        | 25715 25747 25726 |

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| Dept | Oper | Operation Description                                              | Part Numbers      |
|------|------|--------------------------------------------------------------------|-------------------|
|      |      |                                                                    | 25714 25717 25713 |
|      |      |                                                                    | 25718 25735 25711 |
|      |      |                                                                    | 25737 25739 25712 |
|      |      |                                                                    | 25681 26175 26177 |
|      |      |                                                                    | 26179 26181 25635 |
|      |      |                                                                    | 25677 25657 25639 |
|      |      |                                                                    | 27503             |
| 8761 | 465R | Strip Defective Bolt                                               | 25743 25744 25745 |
|      |      |                                                                    | 25746 25707 25709 |
|      |      |                                                                    | 25715 25747 25726 |
|      |      |                                                                    | 25714 25717 25713 |
|      |      |                                                                    | 25718 25735 25711 |
|      |      |                                                                    | 25737 25739 25712 |
|      |      |                                                                    | 25681 26175 26177 |
|      |      |                                                                    | 26179 26181 25635 |
|      |      |                                                                    | 25677 25657 25639 |
|      |      |                                                                    | 27503             |
| 8761 | 580  | Assemble Action                                                    | 25743 25744 25745 |
|      |      |                                                                    | 25746 25707 25709 |
|      |      |                                                                    | 25715 25714 25717 |
|      |      |                                                                    | 25713 25718 25735 |
|      |      |                                                                    | 25737 25739 25747 |
|      |      |                                                                    | 25726 25681 26175 |
|      |      |                                                                    | 26177 26179 26181 |
|      |      |                                                                    | 25677 25657 25639 |
|      |      |                                                                    | 27503             |
| 8761 | 581  | Assemble Action                                                    | 25712 25711 25635 |
| 8761 | 583  | Assemble Stock to Action and Attach Build to<br>Tag to Barrel (DM) | 25715 25717 25713 |
| 8761 | 585  | Assemble Stock to Action & Attach Hang Tag<br>to Trigger Guard     | 25743 25744 25745 |
|      |      |                                                                    | 25746 25707 25709 |
|      |      |                                                                    | 25714 25718 25735 |
|      |      |                                                                    | 25737 25739 25747 |
|      |      |                                                                    | 25726 25681 26175 |
|      |      |                                                                    | 26177 26179 26181 |
|      |      |                                                                    | 25677 25657 25639 |
|      |      |                                                                    | 27503             |
| 8761 | 586  | Assemble Stock to Action and Attach Build to<br>Tag to Barrel      | 25712 25711 25635 |

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| Dept | Oper | Operation Description                                                                                | Part Numbers                                                                                                                                                                                       |
|------|------|------------------------------------------------------------------------------------------------------|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| 8785 | 588  | PROOF TEST                                                                                           | 25712 25711 25635                                                                                                                                                                                  |
| 8488 | 590  | ASSEMBLE TRS SCOPE BASE, SCOPE RINGS, &<br>TELESCOPE WITH LENS COVERS TO GUN                         | 25712 25711 25635                                                                                                                                                                                  |
| 8761 | 593  | Assemble Front Swivel Screw and Swivel Screw<br>Spacer to Stock                                      | 25743 25744                                                                                                                                                                                        |
| 8488 | 594  | FUNCTION TEST(100%) AND TARGET(100%)                                                                 | 25712 25711 25635                                                                                                                                                                                  |
| 8786 | 595  | Mark Bolt to Match Receiver Serial<br>Number Using Dot Peen Marking Machine                          | 25712 25711 25635                                                                                                                                                                                  |
| 8786 | 596  | INSPECT FOR LIVE AMMUNITION                                                                          | 25712 25711 25635                                                                                                                                                                                  |
| 8786 | 597  | CLEAN AND INSPECT                                                                                    | 25712 25711 25635                                                                                                                                                                                  |
| 8786 | 598  | PACK RIFLE AND DELIVER TO WAREHOUSE                                                                  | 25712 25711 25635                                                                                                                                                                                  |
| 8785 | 600  | Proof Test                                                                                           | 25743 25744 25745<br>25746 25707 25709<br>25715 25714 25717<br>25713 25718 25735<br>25737 25739 25747<br>25726 25681 26175<br>26177 26179 26181<br>25677 25657 25639<br>27503                      |
| 8785 | 600R | Proof Test with slave bolt                                                                           | 25743 25744 25745<br>25746 25707 25709<br>25715 25714 25717<br>25713 25718 25735<br>25737 25739 25747<br>25726 25681 26175<br>26177 26179 26181<br>25712 25711 25635<br>25677 25657 25639<br>27503 |
| 8785 | 605R | Check Repaired Guns Returning to Gallery for<br>Proof Stamp, Pick Punch and Obstruction In<br>Barrel | 25743 25744 25745<br>25746 25707 25709<br>25715 25714 25717<br>25713 25718 25735<br>25737 25739 25747<br>25726 25681 26175                                                                         |

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| Dept | Oper | Operation Description                                                          | Part Numbers      |
|------|------|--------------------------------------------------------------------------------|-------------------|
|      |      |                                                                                | 26177 26179 26181 |
|      |      |                                                                                | 25677 25657 25639 |
|      |      |                                                                                | 27503             |
| 8785 | 606  | Test and Target 1003                                                           | 25743 25744 25745 |
|      |      |                                                                                | 25746 25707 25709 |
|      |      |                                                                                | 25715 25714 25717 |
|      |      |                                                                                | 25713 25718 25735 |
|      |      |                                                                                | 25737 25739 25747 |
|      |      |                                                                                | 25726 25681 26175 |
|      |      |                                                                                | 26177 26179 26181 |
|      |      |                                                                                | 25677 25657 25639 |
|      |      |                                                                                | 27503             |
| 8785 | 620  | Inspect For Live Ammunition                                                    | 25743 25744 25745 |
|      |      |                                                                                | 25746 25707 25709 |
|      |      |                                                                                | 25715 25714 25717 |
|      |      |                                                                                | 25713 25718 25735 |
|      |      |                                                                                | 25737 25739 25747 |
|      |      |                                                                                | 25726 25681 26175 |
|      |      |                                                                                | 26177 26179 26181 |
|      |      |                                                                                | 25677 25657 25639 |
|      |      |                                                                                | 27503             |
| 8786 | 640  | Final Inspection                                                               | 25743 25744 25745 |
|      |      |                                                                                | 25746 25707 25709 |
|      |      |                                                                                | 25715 25714 25717 |
|      |      |                                                                                | 25713 25718 25735 |
|      |      |                                                                                | 25737 25739 25747 |
|      |      |                                                                                | 25726 25681 26175 |
|      |      |                                                                                | 26177 26179 26181 |
|      |      |                                                                                | 25677 25657 25639 |
|      |      |                                                                                | 27503             |
| 8761 | 648  | Reset trigger pull within specs as needed -<br>not done on 100% of the product | 25743 25744 25745 |
|      |      |                                                                                | 25746 25707 25709 |
|      |      |                                                                                | 25715 25714 25717 |
|      |      |                                                                                | 25713 25718 25735 |
|      |      |                                                                                | 25737 25739 25747 |
|      |      |                                                                                | 25726 25681 26175 |
|      |      |                                                                                | 26177 26179 26181 |
|      |      |                                                                                | 25677 25657 25639 |
|      |      |                                                                                | 27503             |
| 8786 | 650  | Inspect Heading and Sear Lift                                                  | 25743 25744 25745 |
|      |      |                                                                                | 25746 25707 25709 |

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| Dept | Oper | Operation Description                                                       | Part Numbers      |
|------|------|-----------------------------------------------------------------------------|-------------------|
|      |      |                                                                             | 25715 25714 25717 |
|      |      |                                                                             | 25713 25718 25735 |
|      |      |                                                                             | 25737 25739 25747 |
|      |      |                                                                             | 25726 25681 26175 |
|      |      |                                                                             | 26177 26179 26181 |
|      |      |                                                                             | 25677 25657 25639 |
|      |      |                                                                             | 27503             |
| 8786 | 655  | Mark Bolt to Match Receiver Serial<br>Number Using Dot Peen Marking Machine | 25743 25744 25745 |
|      |      |                                                                             | 25746 25707 25709 |
|      |      |                                                                             | 25715 25714 25717 |
|      |      |                                                                             | 25713 25718 25735 |
|      |      |                                                                             | 25737 25739 25747 |
|      |      |                                                                             | 25726 25681 26175 |
|      |      |                                                                             | 26177 26179 26181 |
|      |      |                                                                             | 25677 25657 25639 |
|      |      |                                                                             | 27503             |
| 8786 | 676  | Pack Rifle<br>To Warehouse                                                  | 25743 25744 25745 |
|      |      |                                                                             | 25746 25707 25709 |
|      |      |                                                                             | 25715 25714 25717 |
|      |      |                                                                             | 25713 25718 25735 |
|      |      |                                                                             | 25737 25739 25747 |
|      |      |                                                                             | 25726 25681 26175 |
|      |      |                                                                             | 26177 26179 26181 |
|      |      |                                                                             | 25677 25657 25639 |
|      |      |                                                                             | 27503             |

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| Parent | Rv | Child  | Fnd | Oper | Qty   | UM |
|--------|----|--------|-----|------|-------|----|
|        | 21 | 17013  | 90  | 581  | 1.000 |    |
|        | 21 | 24475  | 130 | 581  | 1.000 |    |
|        | 21 | 15224  | 30  | 581  | 1.000 |    |
|        | 21 | 17017  | 32  | 450  | 1.000 |    |
|        | 21 | 94555  | 42  | 460  | 1.000 |    |
|        | 21 | 17019  | 52  | 470  | 1.000 |    |
|        | 21 | 93712  | 90  | 480  | 1.000 |    |
|        | 21 | 3509   | 20  | 598  | 1.000 |    |
|        | 21 | 305634 | 120 | 581  | 1.000 |    |
|        | 21 | 104127 | 250 | 586  | 1.000 |    |
|        | 21 | 99472  | 290 | 590  | 1.000 |    |
|        | 21 | 99473  | 285 | 590  | 1.000 |    |
|        | 21 | 16715  | 80  | 586  | 1.000 |    |
|        | 21 | 90982  | 170 | 586  | 1.000 |    |
|        | 21 | 15699  | 50  | 586  | 1.000 |    |
|        | 21 | 202536 | 300 | 598  | 1.000 |    |
|        | 21 | 21723  | 420 | 588  | 1.190 |    |
|        | 21 | 104126 | 240 | 586  | 1.000 |    |
|        | 21 | 24476  | 140 | 581  | 1.000 |    |
|        | 21 | 97094  | 320 | 598  | 1.000 |    |
|        | 21 | 201324 | 200 | 586  | 1.000 |    |
|        | 21 | 21485  | 505 | 594  | 2.000 |    |
|        | 21 | 21485  | 430 | 594  | 7.000 |    |
|        | 21 | 26345  | 150 | 581  | 1.000 |    |
|        | 21 | 94535  | 210 | 586  | 1.000 |    |
|        | 21 | 97091  | 280 | 590  | 1.000 |    |
|        | 21 | 97090  | 270 | 590  | 1.000 |    |
|        | 21 | 97089  | 260 | 590  | 1.000 |    |
|        | 21 | 26555  | 10  | 596  | 2.000 |    |
| 26175  | 21 | 106644 | 37  | 400  | 1.000 |    |
|        | 21 | 94098  | 57  | 400  | 1.000 |    |
|        | 21 | 17013  | 90  | 580  | 1.000 |    |
|        | 21 | 24475  | 130 | 580  | 1.000 |    |
|        | 21 | 15224  | 30  | 580  | 1.000 |    |
|        | 21 | 993002 | 280 | 676  | 1.000 |    |
|        | 21 | 1499   | 10  | 676  | 1.000 |    |
|        | 21 | 3509   | 20  | 676  | 1.000 |    |
|        | 21 | 1333   | 290 | 676  | 2.000 |    |
|        | 21 | 17017  | 400 | 440  | 1.000 |    |
|        | 21 | 94555  | 410 | 440  | 1.000 |    |
|        | 21 | 17019  | 420 | 440  | 1.000 |    |
|        | 21 | 93712  | 430 | 435  | 1.000 |    |
|        | 21 | 305634 | 120 | 580  | 1.000 |    |
|        | 21 | 104127 | 250 | 585  | 1.000 |    |

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| Parent | Rv | Child   | Fnd | Oper | Qty   | UM |
|--------|----|---------|-----|------|-------|----|
|        | 21 | 16715   | 80  | 580  | 1.000 |    |
|        | 21 | 90982   | 170 | 585  | 1.000 |    |
|        | 21 | 15699   | 50  | 585  | 1.000 |    |
|        | 21 | 21723   | 300 | 600  | 1.130 |    |
|        | 21 | 104126  | 240 | 585  | 1.000 |    |
|        | 21 | 17034   | 100 | 580  | 4.000 |    |
|        | 21 | 24476   | 140 | 580  | 1.000 |    |
|        | 21 | 202085B | 200 | 585  | 1.000 |    |
|        | 21 | 21485   | 505 | 606  | 2.000 |    |
|        | 21 | 21485   | 310 | 606  | 7.000 |    |
|        | 21 | 26345   | 150 | 580  | 1.000 |    |
|        | 21 | 94535   | 210 | 585  | 1.000 |    |
| 26177  | 21 |         |     |      |       |    |
|        | 21 | 245501  | 37  | 400  | 1.000 |    |
|        | 21 | 94098   | 57  | 400  | 1.000 |    |
|        | 21 | 17013   | 90  | 580  | 1.000 |    |
|        | 21 | 24475   | 130 | 580  | 1.000 |    |
|        | 21 | 15224   | 30  | 580  | 1.000 |    |
|        | 21 | 993002  | 280 | 676  | 1.000 |    |
|        | 21 | 1499    | 10  | 676  | 1.000 |    |
|        | 21 | 3509    | 20  | 676  | 1.000 |    |
|        | 21 | 1333    | 290 | 676  | 2.000 |    |
|        | 21 | 17017   | 400 | 440  | 1.000 |    |
|        | 21 | 94555   | 410 | 440  | 1.000 |    |
|        | 21 | 17019   | 420 | 440  | 1.000 |    |
|        | 21 | 93712   | 430 | 435  | 1.000 |    |
|        | 21 | 305634  | 120 | 580  | 1.000 |    |
|        | 21 | 104127  | 250 | 585  | 1.000 |    |
|        | 21 | 16715   | 80  | 580  | 1.000 |    |
|        | 21 | 90982   | 170 | 585  | 1.000 |    |
|        | 21 | 15699   | 50  | 585  | 1.000 |    |
|        | 21 | 21723   | 300 | 600  | 1.130 |    |
|        | 21 | 104126  | 240 | 585  | 1.000 |    |
|        | 21 | 17034   | 100 | 580  | 4.000 |    |
|        | 21 | 24476   | 140 | 580  | 1.000 |    |
|        | 21 | 94519B  | 200 | 585  | 1.000 |    |
|        | 21 | 21485   | 505 | 606  | 2.000 |    |
|        | 21 | 21485   | 310 | 606  | 7.000 |    |
|        | 21 | 26345   | 150 | 580  | 1.000 |    |
|        | 21 | 94535   | 210 | 585  | 1.000 |    |
| 26179  | 21 |         |     |      |       |    |
|        | 21 | 245702  | 37  | 400  | 1.000 |    |
|        | 21 | 94098   | 57  | 400  | 1.000 |    |
|        | 21 | 17013   | 90  | 580  | 1.000 |    |

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| Parent | Rv | Child  | Fnd | Oper | Qty   | UM |
|--------|----|--------|-----|------|-------|----|
|        | 21 | 24475  | 130 | 580  | 1.000 |    |
|        | 21 | 15224  | 30  | 580  | 1.000 |    |
|        | 21 | 993002 | 280 | 676  | 1.000 |    |
|        | 21 | 1499   | 10  | 676  | 1.000 |    |
|        | 21 | 3509   | 20  | 676  | 1.000 |    |
|        | 21 | 1333   | 290 | 676  | 2.000 |    |
|        | 21 | 17017  | 400 | 440  | 1.000 |    |
|        | 21 | 94555  | 410 | 440  | 1.000 |    |
|        | 21 | 17019  | 420 | 440  | 1.000 |    |
|        | 21 | 93712  | 430 | 435  | 1.000 |    |
|        | 21 | 305634 | 120 | 580  | 1.000 |    |
|        | 21 | 104127 | 250 | 585  | 1.000 |    |
|        | 21 | 16715  | 80  | 580  | 1.000 |    |
|        | 21 | 90982  | 170 | 585  | 1.000 |    |
|        | 21 | 15699  | 50  | 585  | 1.000 |    |
|        | 21 | 21723  | 300 | 600  | 1.130 |    |
|        | 21 | 104126 | 240 | 585  | 1.000 |    |
|        | 21 | 17034  | 100 | 580  | 4.000 |    |
|        | 21 | 24476  | 140 | 580  | 1.000 |    |
|        | 21 | 94519B | 200 | 585  | 1.000 |    |
|        | 21 | 21485  | 505 | 606  | 2.000 |    |
|        | 21 | 21485  | 310 | 606  | 2.000 |    |
|        | 21 | 26345  | 150 | 580  | 1.000 |    |
|        | 21 | 94535  | 210 | 585  | 1.000 |    |
| 26181  | 21 |        |     |      |       |    |
|        | 21 | 245701 | 37  | 400  | 1.000 |    |
|        | 21 | 94098  | 57  | 400  | 1.000 |    |
|        | 21 | 17013  | 90  | 580  | 1.000 |    |
|        | 21 | 24475  | 130 | 580  | 1.000 |    |
|        | 21 | 15224  | 30  | 580  | 1.000 |    |
|        | 21 | 993002 | 280 | 676  | 1.000 |    |
|        | 21 | 1499   | 10  | 676  | 1.000 |    |
|        | 21 | 3509   | 20  | 676  | 1.000 |    |
|        | 21 | 1333   | 290 | 676  | 2.000 |    |
|        | 21 | 17017  | 400 | 440  | 1.000 |    |
|        | 21 | 94555  | 410 | 440  | 1.000 |    |
|        | 21 | 17019  | 420 | 440  | 1.000 |    |
|        | 21 | 93712  | 430 | 435  | 1.000 |    |
|        | 21 | 305634 | 120 | 580  | 1.000 |    |
|        | 21 | 104127 | 250 | 585  | 1.000 |    |
|        | 21 | 16715  | 80  | 580  | 1.000 |    |
|        | 21 | 90982  | 170 | 585  | 1.000 |    |
|        | 21 | 15699  | 50  | 585  | 1.000 |    |
|        | 21 | 21723  | 300 | 600  | 1.130 |    |
|        | 21 | 104126 | 240 | 585  | 1.000 |    |

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| Parent | Rv | Child  | Fnd | Oper | Qty   | UM |
|--------|----|--------|-----|------|-------|----|
| 27503  |    | 17034  | 100 | 580  | 4.000 |    |
|        |    | 24476  | 140 | 580  | 1.000 |    |
|        |    | 94519B | 200 | 585  | 1.000 |    |
|        |    | 21485  | 505 | 606  | 2.000 |    |
|        |    | 21485  | 310 | 606  | 7.000 |    |
|        |    | 26345  | 150 | 580  | 1.000 |    |
|        |    | 94535  | 210 | 585  | 1.000 |    |
|        |    |        |     |      |       |    |
|        |    | 245704 | 37  | 400  | 1.000 |    |
|        |    | 113869 | 57  | 400  | 1.000 |    |
|        |    | 17013  | 90  | 580  | 1.000 |    |
|        |    | 24475  | 130 | 580  | 1.000 |    |
|        |    | 15224  | 30  | 580  | 1.000 |    |
|        |    | 993002 | 280 | 676  | 1.000 |    |
|        |    | 1687   | 10  | 676  | 1.000 |    |
|        |    | 3509   | 20  | 676  | 1.000 |    |
|        |    | 1333   | 290 | 676  | 2.000 |    |
|        |    | 201843 | 400 | 440  | 1.000 |    |
|        |    | 94555  | 410 | 440  | 1.000 |    |
|        |    | 201841 | 420 | 440  | 1.000 |    |
|        |    | 93712  | 430 | 435  | 1.000 |    |
|        |    | 305634 | 120 | 580  | 1.000 |    |
|        |    | 104127 | 250 | 585  | 1.000 |    |
|        |    | 106607 | 80  | 580  | 1.000 |    |
|        |    | 90982  | 170 | 585  | 1.000 |    |
|        |    | 15699  | 50  | 585  | 1.000 |    |
|        |    | 21738  | 300 | 600  | 1.130 |    |
|        |    | 104126 | 240 | 585  | 1.000 |    |
|        |    | 17034  | 100 | 580  | 4.000 |    |
|        |    | 24476  | 140 | 580  | 1.000 |    |
|        |    | 94519B | 200 | 585  | 1.000 |    |
|        |    | 29146  | 505 | 606  | 2.000 |    |
|        |    | 29146  | 310 | 606  | 7.000 |    |
|        |    | 26345  | 150 | 580  | 1.000 |    |
|        |    | 94535  | 210 | 585  | 1.000 |    |
|        |    |        |     |      |       |    |
| 25726  |    | 109822 | 37  | 400  | 1     |    |
|        |    | 94100  | 57  | 400  | 1     |    |
|        |    | 17013  | 90  | 580  | 1     |    |
|        |    | 24475  | 130 | 580  | 1     |    |
|        |    | 15224  | 30  | 580  | 1     |    |
|        |    | 993002 | 280 | 676  | 1     |    |
|        |    | 1688   | 10  | 676  | 1     |    |
|        |    | 3509   | 20  | 676  | 1.000 |    |

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| Parent | Rv | Child  | Fnd | Oper | Qty   | UM |
|--------|----|--------|-----|------|-------|----|
|        | 21 | 1333   | 290 | 676  | 2.000 |    |
|        | 21 | 17017  | 400 | 440  | 1.000 |    |
|        | 21 | 94555  | 410 | 440  | 1.000 |    |
|        | 21 | 17019  | 420 | 440  | 1.000 |    |
|        | 21 | 97322  | 430 | 432  | 1.000 |    |
|        | 21 | 27341  | 435 | 432  | 1.000 |    |
|        | 21 | 305633 | 120 | 580  | 1.000 |    |
|        | 21 | 104129 | 250 | 585  | 1.000 |    |
|        | 21 | 16430  | 80  | 580  | 1.000 |    |
|        | 21 | 90952  | 170 | 585  | 1.000 |    |
|        | 21 | 15677  | 50  | 585  | 1.000 |    |
|        | 21 | 21846  | 300 | 600  | 1.130 |    |
|        | 21 | 104126 | 240 | 585  | 1.000 |    |
|        | 21 | 17034  | 100 | 580  | 4.000 |    |
|        | 21 | 24476  | 140 | 580  | 1.000 |    |
|        | 21 | 201309 | 200 | 585  | 1.000 |    |
|        | 21 | 28976  | 505 | 606  | 2.000 |    |
|        | 21 | 28976  | 310 | 606  | 7.000 |    |
|        | 21 | 26345  | 150 | 580  | 1.000 |    |
|        | 21 | 94089  | 210 | 585  | 1.000 |    |
| 25743  | 21 |        |     |      |       |    |
|        | 21 | 33478  | 37  | 405  | 1.000 |    |
|        | 21 | 99347  | 47  | 405  | 1.000 |    |
|        | 21 | 17013  | 90  | 580  | 1.000 |    |
|        | 21 | 24475  | 130 | 580  | 1.000 |    |
|        | 21 | 15224  | 30  | 580  | 1.000 |    |
|        | 21 | 993002 | 270 | 676  | 1.000 |    |
|        | 21 | 1499   | 10  | 676  | 1.000 |    |
|        | 21 | 3509   | 20  | 676  | 1.000 |    |
|        | 21 | 17017  | 400 | 440  | 1.000 |    |
|        | 21 | 94555  | 410 | 440  | 1.000 |    |
|        | 21 | 17019  | 420 | 440  | 1.000 |    |
|        | 21 | 91906  | 430 | 435  | 1.000 |    |
|        | 21 | 305633 | 120 | 580  | 1.000 |    |
|        | 21 | 98880  | 300 | 585  | 1.000 |    |
|        | 21 | 104127 | 250 | 585  | 1.000 |    |
|        | 21 | 106605 | 80  | 580  | 1.000 |    |
|        | 21 | 93353  | 260 | 585  | 1.000 |    |
|        | 21 | 21133  | 180 | 585  | 1.000 |    |
|        | 21 | 21774  | 310 | 600  | 1.100 |    |
|        | 21 | 104126 | 240 | 585  | 1.000 |    |
|        | 21 | 17034  | 100 | 580  | 4.000 |    |
|        | 21 | 24476  | 140 | 580  | 1.000 |    |
|        | 21 | 102821 | 280 | 585  | 1.000 |    |
|        | 21 | 15358  | 50  | 593  | 2.000 |    |

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| Parent | Rv | Child  | Fnd | Oper | Qty   | UM |
|--------|----|--------|-----|------|-------|----|
|        |    | 94241  | 200 | 593  | 2.000 |    |
|        |    | 22106  | 505 | 606  | 2.000 |    |
|        |    | 22106  | 320 | 606  | 7.000 |    |
|        |    | 26345  | 150 | 580  | 1.000 |    |
|        |    | 94535  | 210 | 585  | 1.000 |    |
| 25744  |    |        |     |      |       |    |
|        |    | 33479  | 37  | 400  | 1.000 |    |
|        |    | 94098  | 57  | 400  | 1.000 |    |
|        |    | 17013  | 90  | 580  | 1.000 |    |
|        |    | 24475  | 130 | 580  | 1.000 |    |
|        |    | 15224  | 30  | 580  | 1.000 |    |
|        |    | 993002 | 260 | 676  | 1.000 |    |
|        |    | 1499   | 10  | 676  | 1.000 |    |
|        |    | 3509   | 20  | 676  | 1.000 |    |
|        |    | 17017  | 400 | 440  | 1.000 |    |
|        |    | 94555  | 410 | 440  | 1.000 |    |
|        |    | 17019  | 420 | 440  | 1.000 |    |
|        |    | 93712  | 430 | 435  | 1.000 |    |
|        |    | 305634 | 120 | 580  | 1.000 |    |
|        |    | 104127 | 240 | 585  | 1.000 |    |
|        |    | 16715  | 80  | 580  | 1.000 |    |
|        |    | 93120  | 270 | 585  | 1.000 |    |
|        |    | 15699  | 50  | 585  | 1.000 |    |
|        |    | 21723  | 290 | 580  | 1.190 |    |
|        |    | 104126 | 230 | 585  | 1.000 |    |
|        |    | 17034  | 100 | 580  | 4.000 |    |
|        |    | 24476  | 140 | 580  | 1.000 |    |
|        |    | 102821 | 280 | 585  | 1.000 |    |
|        |    | 15358  | 40  | 593  | 2.000 |    |
|        |    | 94241  | 190 | 593  | 2.000 |    |
|        |    | 21485  | 505 | 606  | 2.000 |    |
|        |    | 21485  | 300 | 606  | 7.000 |    |
|        |    | 26345  | 150 | 580  | 1.000 |    |
|        |    | 94535  | 200 | 585  | 2.000 |    |
| 25745  |    |        |     |      |       |    |
|        |    | 33478  | 37  | 400  | 1.000 |    |
|        |    | 99347  | 47  | 400  | 1.000 |    |
|        |    | 17013  | 90  | 580  | 1.000 |    |
|        |    | 24475  | 130 | 580  | 1.000 |    |
|        |    | 15224  | 30  | 580  | 1.000 |    |
|        |    | 993002 | 290 | 676  | 1.000 |    |
|        |    | 1499   | 10  | 676  | 1.000 |    |
|        |    | 3509   | 20  | 676  | 1.000 |    |
|        |    | 17017  | 400 | 440  | 1.000 |    |

Printed on:  
~AUTODATE

| Parent | Rv | Child  | Fnd | Oper | Qty   | UM |
|--------|----|--------|-----|------|-------|----|
|        | 21 | 94555  | 410 | 440  | 1.000 |    |
|        | 21 | 17019  | 420 | 440  | 1.000 |    |
|        | 21 | 91906  | 430 | 435  | 1.000 |    |
|        | 21 | 305634 | 120 | 580  | 1.000 |    |
|        | 21 | 98880  | 300 | 585  | 1.000 |    |
|        | 21 | 104127 | 260 | 585  | 1.000 |    |
|        | 21 | 106605 | 80  | 580  | 1.000 |    |
|        | 21 | 93353  | 170 | 585  | 1.000 |    |
|        | 21 | 91133  | 180 | 585  | 1.000 |    |
|        | 21 | 21774  | 310 | 600  | 1.100 |    |
|        | 21 | 104126 | 250 | 585  | 1.000 |    |
|        | 21 | 17034  | 100 | 580  | 4.000 |    |
|        | 21 | 24476  | 140 | 580  | 1.000 |    |
|        | 21 | 94519B | 210 | 585  | 1.000 |    |
|        | 21 | 22106  | 505 | 606  | 2.000 |    |
|        | 21 | 22106  | 320 | 606  | 7.000 |    |
|        | 21 | 26345  | 150 | 580  | 1.000 |    |
|        | 21 | 94535  | 220 | 585  | 1.000 |    |
| 25746  | 21 |        |     |      |       |    |
|        | 21 | 33479  | 37  | 400  | 1.000 |    |
|        | 21 | 94098  | 57  | 400  | 1.000 |    |
|        | 21 | 17013  | 90  | 580  | 1.000 |    |
|        | 21 | 24475  | 130 | 580  | 1.000 |    |
|        | 21 | 15224  | 30  | 580  | 1.000 |    |
|        | 21 | 993002 | 280 | 676  | 1.000 |    |
|        | 21 | 1499   | 10  | 676  | 1.000 |    |
|        | 21 | 3509   | 20  | 676  | 1.000 |    |
|        | 21 | 17017  | 400 | 440  | 1.000 |    |
|        | 21 | 94555  | 410 | 440  | 1.000 |    |
|        | 21 | 17019  | 420 | 440  | 1.000 |    |
|        | 21 | 93712  | 430 | 435  | 1.000 |    |
|        | 21 | 305634 | 120 | 580  | 1.000 |    |
|        | 21 | 104127 | 250 | 585  | 1.000 |    |
|        | 21 | 16713  | 80  | 580  | 1.000 |    |
|        | 21 | 93120  | 170 | 585  | 1.000 |    |
|        | 21 | 15699  | 50  | 585  | 1.000 |    |
|        | 21 | 21723  | 290 | 600  | 1.130 |    |
|        | 21 | 104126 | 240 | 585  | 1.000 |    |
|        | 21 | 17034  | 100 | 580  | 4.000 |    |
|        | 21 | 24476  | 140 | 580  | 1.000 |    |
|        | 21 | 94519B | 200 | 585  | 1.000 |    |
|        | 21 | 21485  | 505 | 606  | 2.000 |    |
|        | 21 | 21485  | 380 | 606  | 7.000 |    |
|        | 21 | 26345  | 150 | 580  | 1.000 |    |
|        | 21 | 94535  | 210 | 585  | 1.000 |    |

Printed on:  
~AUTODATE

| Parent | Rv | Child  | Fnd | Oper | Qty   | UM |
|--------|----|--------|-----|------|-------|----|
| 25747  |    |        |     |      |       |    |
|        |    | 108515 | 47  | 400  | 1.000 |    |
|        |    | 94098  | 37  | 400  | 1.000 |    |
|        |    | 17013  | 130 | 580  | 1.000 |    |
|        |    | 24475  | 170 | 580  | 1.000 |    |
|        |    | 15224  | 30  | 580  | 1.000 |    |
|        |    | 993002 | 50  | 676  | 1.000 |    |
|        |    | 3509   | 20  | 676  | 1.000 |    |
|        |    | 17017  | 400 | 440  | 1.000 |    |
|        |    | 94555  | 410 | 440  | 1.000 |    |
|        |    | 17019  | 420 | 440  | 1.000 |    |
|        |    | 93712  | 430 | 435  | 1.000 |    |
|        |    | 305634 | 160 | 580  | 1.000 |    |
|        |    | 104127 | 300 | 585  | 1.000 |    |
|        |    | 106399 | 90  | 585  | 1.000 |    |
|        |    | 21723  | 310 | 600  | 1.000 |    |
|        |    | 104126 | 290 | 585  | 1.000 |    |
|        |    | 24476  | 180 | 580  | 1.000 |    |
|        |    | 200028 | 100 | 585  | 1.000 |    |
|        |    | 21485  | 505 | 606  | 2.000 |    |
|        |    | 21485  | 360 | 606  | 2.000 |    |
|        |    | 26345  | 190 | 580  | 1.000 |    |
|        |    | 106352 | 110 | 585  | 1.000 |    |
|        |    | 96117  | 440 | 676  | 1.000 |    |
|        |    | 99472  | 450 | 676  | 1.000 |    |
|        |    | 99473  | 460 | 676  | 1.000 |    |
|        |    | 97092  | 470 | 676  | 1.000 |    |
|        |    | 97091  | 480 | 676  | 1.000 |    |
|        |    | 97090  | 490 | 676  | 1.000 |    |
|        |    | 97094  | 500 | 676  | 1.000 |    |
|        |    | 97089  | 510 | 676  | 1.000 |    |
|        |    | 15358  | 530 | 676  | 2.000 |    |
|        |    | 26555  | 530 | 676  | 2.000 |    |
| 25714  |    |        |     |      |       |    |
|        |    | 106654 | 37  | 400  | 1.000 |    |
|        |    | 99347  | 47  | 400  | 1.000 |    |
|        |    | 17013  | 90  | 580  | 1.000 |    |
|        |    | 24475  | 130 | 580  | 1.000 |    |
|        |    | 15224  | 30  | 580  | 1.000 |    |
|        |    | 993002 | 290 | 676  | 1.000 |    |
|        |    | 16888  | 10  | 676  | 1.000 |    |
|        |    | 3509   | 20  | 676  | 1.000 |    |
|        |    | 1333   | 310 | 676  | 2.000 |    |
|        |    | 17017  | 400 | 440  | 1.000 |    |

Printed on:  
~AUTODATE

| Parent | Rv | Child  | Fnd | Oper | Qty   | UM |
|--------|----|--------|-----|------|-------|----|
|        | 21 | 94555  | 410 | 440  | 1.000 |    |
|        | 21 | 17019  | 420 | 440  | 1.000 |    |
|        | 21 | 97138  | 430 | 435  | 1.000 |    |
|        | 21 | 305634 | 120 | 580  | 1.000 |    |
|        | 21 | 98880  | 300 | 585  | 1.000 |    |
|        | 21 | 104127 | 260 | 585  | 1.000 |    |
|        | 21 | 106605 | 80  | 580  | 1.000 |    |
|        | 21 | 92508  | 170 | 585  | 1.000 |    |
|        | 21 | 91133  | 180 | 585  | 1.000 |    |
|        | 21 | 21774  | 320 | 600  | 1.125 |    |
|        | 21 | 104126 | 250 | 585  | 1.000 |    |
|        | 21 | 17034  | 100 | 580  | 4.000 |    |
|        | 21 | 24476  | 140 | 580  | 1.000 |    |
|        | 21 | 94519B | 210 | 585  | 1.000 |    |
|        | 21 | 22106  | 505 | 606  | 2.000 |    |
|        | 21 | 22106  | 330 | 606  | 7.000 |    |
|        | 21 | 26345  | 150 | 580  | 1.000 |    |
|        | 21 | 94535  | 220 | 585  | 1.000 |    |
| 25707  | 21 |        |     |      |       |    |
|        | 21 | 106643 | 37  | 405  | 1.000 |    |
|        | 21 | 99347  | 47  | 405  | 1.000 |    |
|        | 21 | 17013  | 90  | 580  | 1.000 |    |
|        | 21 | 24475  | 130 | 580  | 1.000 |    |
|        | 21 | 15224  | 30  | 580  | 1.000 |    |
|        | 21 | 993002 | 290 | 676  | 1.000 |    |
|        | 21 | 1499   | 10  | 676  | 1.000 |    |
|        | 21 | 3509   | 20  | 676  | 1.000 |    |
|        | 21 | 1333   | 310 | 676  | 2.000 |    |
|        | 21 | 17017  | 400 | 440  | 1.000 |    |
|        | 21 | 94555  | 410 | 440  | 1.000 |    |
|        | 21 | 17019  | 420 | 440  | 1.000 |    |
|        | 21 | 97138  | 430 | 435  | 1.000 |    |
|        | 21 | 305634 | 120 | 580  | 1.000 |    |
|        | 21 | 98880  | 300 | 585  | 1.000 |    |
|        | 21 | 104127 | 260 | 585  | 1.000 |    |
|        | 21 | 106605 | 80  | 580  | 1.000 |    |
|        | 21 | 92508  | 170 | 585  | 1.000 |    |
|        | 21 | 91133  | 180 | 585  | 1.000 |    |
|        | 21 | 21774  | 320 | 600  | 1.125 |    |
|        | 21 | 104126 | 250 | 585  | 1.000 |    |
|        | 21 | 17034  | 100 | 580  | 4.000 |    |
|        | 21 | 24476  | 140 | 580  | 1.000 |    |
|        | 21 | 94519B | 210 | 585  | 1.000 |    |
|        | 21 | 22106  | 505 | 606  | 2.000 |    |
|        | 21 | 22106  | 330 | 606  | 7.000 |    |

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~AUTODATE

| Parent | Rv | Child  | Fnd | Oper | Qty   | UM |
|--------|----|--------|-----|------|-------|----|
|        | 21 | 26345  | 150 | 580  | 1.000 |    |
|        | 21 | 94535  | 220 | 585  | 1.000 |    |
| 25709  | 21 |        |     |      |       |    |
|        | 21 | 106644 | 37  | 400  | 1.000 |    |
|        | 21 | 94098  | 57  | 400  | 1.000 |    |
|        | 21 | 17013  | 90  | 580  | 1.000 |    |
|        | 21 | 24475  | 130 | 580  | 1.000 |    |
|        | 21 | 15224  | 30  | 580  | 1.000 |    |
|        | 21 | 993002 | 280 | 676  | 1.000 |    |
|        | 21 | 1689   | 10  | 676  | 1.000 |    |
|        | 21 | 3509   | 20  | 676  | 1.000 |    |
|        | 21 | 1333   | 290 | 676  | 2.000 |    |
|        | 21 | 17017  | 400 | 440  | 1.000 |    |
|        | 21 | 94555  | 410 | 440  | 1.000 |    |
|        | 21 | 17019  | 420 | 440  | 1.000 |    |
|        | 21 | 93712  | 430 | 435  | 1.000 |    |
|        | 21 | 305634 | 120 | 580  | 1.000 |    |
|        | 21 | 104127 | 250 | 585  | 1.000 |    |
|        | 21 | 16715  | 80  | 580  | 1.000 |    |
|        | 21 | 90982  | 170 | 585  | 1.000 |    |
|        | 21 | 15699  | 50  | 585  | 1.000 |    |
|        | 21 | 21723  | 300 | 600  | 1.130 |    |
|        | 21 | 104126 | 240 | 585  | 1.000 |    |
|        | 21 | 17034  | 100 | 580  | 4.000 |    |
|        | 21 | 24476  | 140 | 580  | 1.000 |    |
|        | 21 | 94519B | 200 | 585  | 1.000 |    |
|        | 21 | 21485  | 310 | 606  | 2.000 |    |
|        | 21 | 21485  | 310 | 606  | 7.000 |    |
|        | 21 | 26345  | 150 | 580  | 1.000 |    |
|        | 21 | 94535  | 210 | 585  | 1.000 |    |
| 25715  | 21 |        |     |      |       |    |
|        | 21 | 107117 | 47  | 400  | 1.000 |    |
|        | 21 | 94098  | 37  | 400  | 1.000 |    |
|        | 21 | 17013  | 90  | 580  | 1.000 |    |
|        | 21 | 24475  | 130 | 580  | 1.000 |    |
|        | 21 | 15224  | 30  | 580  | 1.000 |    |
|        | 21 | 993002 | 280 | 676  | 1.000 |    |
|        | 21 | 1689   | 10  | 676  | 1.000 |    |
|        | 21 | 3509   | 20  | 676  | 1.000 |    |
|        | 21 | 1333   | 290 | 676  | 2.000 |    |
|        | 21 | 17017  | 400 | 440  | 1.000 |    |
|        | 21 | 94555  | 410 | 440  | 1.000 |    |
|        | 21 | 17019  | 420 | 440  | 1.000 |    |
|        | 21 | 93712  | 430 | 435  | 1.000 |    |

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| Parent | Rv | Child  | Fnd | Oper | Qty   | UM |
|--------|----|--------|-----|------|-------|----|
|        |    | 305634 | 120 | 580  | 1.000 |    |
|        |    | 104127 | 250 | 583  | 1.000 |    |
|        |    | 106399 | 80  | 580  | 1.000 |    |
|        |    | 21723  | 300 | 600  | 1.130 |    |
|        |    | 104126 | 240 | 583  | 1.000 |    |
|        |    | 17034  | 100 | 580  | 4.000 |    |
|        |    | 24476  | 140 | 580  | 1.000 |    |
|        |    | 99359B | 200 | 583  | 1.000 |    |
|        |    | 21485  | 505 | 606  | 2.000 |    |
|        |    | 21485  | 310 | 606  | 7.000 |    |
|        |    | 26345  | 150 | 580  | 1.000 |    |
|        |    | 106352 | 210 | 583  | 1.000 |    |
| 25717  |    |        |     |      |       |    |
|        |    | 107116 | 57  | 415  | 1.000 |    |
|        |    | 94100  | 47  | 415  | 1.000 |    |
|        |    | 17013  | 60  | 580  | 1.000 |    |
|        |    | 24475  | 70  | 580  | 1.000 |    |
|        |    | 15224  | 80  | 580  | 1.000 |    |
|        |    | 993002 | 30  | 676  | 1.000 |    |
|        |    | 1499   | 10  | 676  | 1.000 |    |
|        |    | 3509   | 20  | 676  | 1.000 |    |
|        |    | 1333   | 50  | 676  | 2.000 |    |
|        |    | 17017  | 400 | 440  | 1.000 |    |
|        |    | 94555  | 410 | 440  | 1.000 |    |
|        |    | 17019  | 420 | 440  | 1.000 |    |
|        |    | 97322  | 430 | 432  | 1.000 |    |
|        |    | 27341  | 440 | 432  | 1.000 |    |
|        |    | 305633 | 90  | 580  | 1.000 |    |
|        |    | 104129 | 100 | 583  | 1.000 |    |
|        |    | 106346 | 110 | 580  | 1.000 |    |
|        |    | 21846  | 180 | 606  | 1.200 |    |
|        |    | 104126 | 130 | 583  | 1.000 |    |
|        |    | 24476  | 140 | 580  | 1.000 |    |
|        |    | 99708  | 150 | 583  | 2.000 |    |
|        |    | 29497  | 505 | 606  | 2.000 |    |
|        |    | 29497  | 180 | 606  | 7.000 |    |
|        |    | 26345  | 160 | 580  | 1.000 |    |
|        |    | 105827 | 170 | 583  | 1.000 |    |
| 25713  |    |        |     |      |       |    |
|        |    | 106515 | 470 | 400  | 1.000 |    |
|        |    | 94088  | 37  | 400  | 1.000 |    |
|        |    | 17013  | 130 | 580  | 1.000 |    |
|        |    | 24475  | 170 | 580  | 1.000 |    |
|        |    | 15224  | 30  | 580  | 1.000 |    |

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| Parent | Rv | Child  | Fnd | Oper | Qty   | UM |
|--------|----|--------|-----|------|-------|----|
|        | 21 | 993002 | 50  | 676  | 1.000 |    |
|        | 21 | 3509   | 20  | 676  | 1.000 |    |
|        | 21 | 17017  | 400 | 440  | 1.000 |    |
|        | 21 | 94555  | 410 | 440  | 1.000 |    |
|        | 21 | 17019  | 420 | 440  | 1.000 |    |
|        | 21 | 93712  | 430 | 435  | 1.000 |    |
|        | 21 | 305634 | 160 | 580  | 1.000 |    |
|        | 21 | 104127 | 300 | 583  | 1.000 |    |
|        | 21 | 106399 | 90  | 580  | 1.000 |    |
|        | 21 | 21723  | 310 | 600  | 1.100 |    |
|        | 21 | 104126 | 290 | 583  | 1.000 |    |
|        | 21 | 24476  | 180 | 580  | 1.000 |    |
|        | 21 | 200028 | 100 | 583  | 1.000 |    |
|        | 21 | 27842  | 505 | 606  | 2.000 |    |
|        | 21 | 27844  | 350 | 606  | 7.000 |    |
|        | 21 | 26345  | 190 | 580  | 1.000 |    |
|        | 21 | 106352 | 110 | 583  | 1.000 |    |
| 25718  | 21 | 109820 | 37  | 400  | 1.000 |    |
|        | 21 | 94100  | 57  | 400  | 1.000 |    |
|        | 21 | 17013  | 90  | 580  | 1.000 |    |
|        | 21 | 24475  | 130 | 580  | 1.000 |    |
|        | 21 | 15224  | 30  | 580  | 1.000 |    |
|        | 21 | 993002 | 280 | 676  | 1.000 |    |
|        | 21 | 1688   | 10  | 676  | 1.000 |    |
|        | 21 | 3509   | 20  | 676  | 1.000 |    |
|        | 21 | 1333   | 290 | 676  | 2.000 |    |
|        | 21 | 17017  | 400 | 440  | 1.000 |    |
|        | 21 | 94555  | 410 | 440  | 1.000 |    |
|        | 21 | 17019  | 420 | 440  | 1.000 |    |
|        | 21 | 97322  | 430 | 432  | 1.000 |    |
|        | 21 | 27341  | 435 | 432  | 1.000 |    |
|        | 21 | 305633 | 120 | 580  | 1.000 |    |
|        | 21 | 104129 | 250 | 585  | 1.000 |    |
|        | 21 | 16430  | 80  | 580  | 1.000 |    |
|        | 21 | 90952  | 170 | 585  | 1.000 |    |
|        | 21 | 15677  | 50  | 585  | 1.000 |    |
|        | 21 | 21846  | 300 | 600  | 1.130 |    |
|        | 21 | 104126 | 240 | 585  | 1.000 |    |
|        | 21 | 17034  | 100 | 580  | 4.000 |    |
|        | 21 | 24476  | 140 | 580  | 1.000 |    |
|        | 21 | 281309 | 200 | 585  | 1.000 |    |
|        | 21 | 29497  | 585 | 606  | 2.000 |    |
|        | 21 | 27684  | 310 | 606  | 7.000 |    |
|        | 21 | 26345  | 150 | 580  | 1.000 |    |

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| Parent | Rv | Child  | Fnd | Oper | Qty   | UM |
|--------|----|--------|-----|------|-------|----|
| 25735  | 21 | 94089  | 210 | 585  | 1.000 |    |
|        | 21 |        |     |      |       |    |
|        | 21 |        |     |      |       |    |
|        | 21 |        |     |      |       |    |
|        | 21 |        |     |      |       |    |
|        | 21 |        |     |      |       |    |
|        | 21 |        |     |      |       |    |
|        | 21 |        |     |      |       |    |
|        | 21 |        |     |      |       |    |
|        | 21 |        |     |      |       |    |
|        | 21 |        |     |      |       |    |
|        | 21 |        |     |      |       |    |
|        | 21 |        |     |      |       |    |
|        | 21 |        |     |      |       |    |
|        | 21 |        |     |      |       |    |
|        | 21 |        |     |      |       |    |
|        | 21 |        |     |      |       |    |
|        | 21 |        |     |      |       |    |
|        | 21 |        |     |      |       |    |
|        | 21 |        |     |      |       |    |
|        | 21 |        |     |      |       |    |
|        | 21 |        |     |      |       |    |
|        | 21 |        |     |      |       |    |
|        | 21 |        |     |      |       |    |
|        | 21 |        |     |      |       |    |
| 25737  | 21 | 109821 | 37  | 400  | 1.000 |    |
|        | 21 |        |     |      |       |    |
|        | 21 |        |     |      |       |    |
|        | 21 |        |     |      |       |    |
|        | 21 |        |     |      |       |    |
|        | 21 |        |     |      |       |    |
|        | 21 |        |     |      |       |    |
|        | 21 |        |     |      |       |    |
|        | 21 |        |     |      |       |    |
|        | 21 |        |     |      |       |    |
|        | 21 |        |     |      |       |    |
|        | 21 |        |     |      |       |    |
|        | 21 |        |     |      |       |    |
|        | 21 |        |     |      |       |    |
|        | 21 |        |     |      |       |    |
|        | 21 |        |     |      |       |    |
|        | 21 |        |     |      |       |    |
|        | 21 |        |     |      |       |    |
|        | 21 |        |     |      |       |    |
|        | 21 |        |     |      |       |    |
|        | 21 |        |     |      |       |    |
|        | 21 |        |     |      |       |    |
|        | 21 |        |     |      |       |    |
|        | 21 |        |     |      |       |    |
|        | 21 |        |     |      |       |    |
|        | 21 |        |     |      |       |    |
|        | 21 |        |     |      |       |    |

Printed on:  
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| Parent | Rv | Child  | Fnd | Oper | Qty   | UM |
|--------|----|--------|-----|------|-------|----|
|        | 21 | 305634 | 120 | 580  | 1.000 |    |
|        | 21 | 104127 | 250 | 585  | 1.000 |    |
|        | 21 | 106605 | 80  | 580  | 1.000 |    |
|        | 21 | 98880  | 350 | 585  | 1.000 |    |
|        | 21 | 92508  | 170 | 585  | 1.000 |    |
|        | 21 | 91133  | 50  | 585  | 1.000 |    |
|        | 21 | 21774  | 300 | 600  | 1.130 |    |
|        | 21 | 104126 | 240 | 585  | 1.000 |    |
|        | 21 | 17034  | 100 | 580  | 4.000 |    |
|        | 21 | 24476  | 140 | 580  | 1.000 |    |
|        | 21 | 201324 | 200 | 585  | 1.000 |    |
|        | 21 | 22106  | 505 | 606  | 2.000 |    |
|        | 21 | 22106  | 310 | 606  | 7.000 |    |
|        | 21 | 26345  | 150 | 580  | 1.000 |    |
|        | 21 | 94535  | 210 | 585  | 1.000 |    |
| 25677  | 21 | 245703 | 37  | 400  | 1.000 |    |
|        | 21 | 113869 | 57  | 400  | 1.000 |    |
|        | 21 | 17013  | 90  | 580  | 1.000 |    |
|        | 21 | 24475  | 130 | 580  | 1.000 |    |
|        | 21 | 15224  | 30  | 580  | 1.000 |    |
|        | 21 | 993002 | 280 | 676  | 1.000 |    |
|        | 21 | 1687   | 10  | 676  | 1.000 |    |
|        | 21 | 3509   | 20  | 676  | 1.000 |    |
|        | 21 | 1333   | 290 | 676  | 2.000 |    |
|        | 21 | 201843 | 400 | 440  | 1.000 |    |
|        | 21 | 94555  | 410 | 440  | 1.000 |    |
|        | 21 | 201841 | 420 | 440  | 1.000 |    |
|        | 21 | 93712  | 430 | 435  | 1.000 |    |
|        | 21 | 305634 | 120 | 580  | 1.000 |    |
|        | 21 | 104127 | 250 | 585  | 1.000 |    |
|        | 21 | 106607 | 80  | 580  | 1.000 |    |
|        | 21 | 92508  | 170 | 585  | 1.000 |    |
|        | 21 | 91133  | 50  | 585  | 1.000 |    |
|        | 21 | 21798  | 320 | 600  | 1.100 |    |
|        | 21 | 104126 | 240 | 585  | 1.000 |    |
|        | 21 | 17034  | 100 | 580  | 4.000 |    |
|        | 21 | 24476  | 140 | 580  | 1.000 |    |
|        | 21 | 201324 | 200 | 585  | 1.000 |    |
|        | 21 | 29146  | 505 | 606  | 2.000 |    |
|        | 21 | 29146  | 340 | 606  | 8.000 |    |
|        | 21 | 26345  | 150 | 580  | 1.000 |    |
|        | 21 | 94535  | 210 | 585  | 1.000 |    |
| 25681  | 21 |        |     |      |       |    |

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| Parent | Rv | Child  | Fnd | Oper | Qty   | UM |
|--------|----|--------|-----|------|-------|----|
|        | 21 | 245700 | 37  | 400  | 1.000 |    |
|        | 21 | 201903 | 57  | 400  | 1.000 |    |
|        | 21 | 17013  | 90  | 580  | 1.000 |    |
|        | 21 | 24475  | 130 | 580  | 1.000 |    |
|        | 21 | 15224  | 30  | 580  | 1.000 |    |
|        | 21 | 993002 | 280 | 676  | 1.000 |    |
|        | 21 | 1499   | 10  | 676  | 1.000 |    |
|        | 21 | 3509   | 20  | 676  | 1.000 |    |
|        | 21 | 1333   | 290 | 676  | 2.000 |    |
|        | 21 | 201843 | 400 | 440  | 1.000 |    |
|        | 21 | 94555  | 410 | 440  | 1.000 |    |
|        | 21 | 201841 | 420 | 440  | 1.000 |    |
|        | 21 | 97322  | 430 | 435  | 1.000 |    |
|        | 21 | 27341  | 435 | 435  | 1.000 |    |
|        | 21 | 305634 | 120 | 580  | 1.000 |    |
|        | 21 | 104127 | 250 | 585  | 1.000 |    |
|        | 21 | 110845 | 80  | 580  | 1.000 |    |
|        | 21 | 110855 | 170 | 585  | 1.000 |    |
|        | 21 | 201849 | 50  | 585  | 1.000 |    |
|        | 21 | 21830  | 300 | 600  | 1.130 |    |
|        | 21 | 104126 | 240 | 585  | 1.000 |    |
|        | 21 | 17034  | 100 | 580  | 1.000 |    |
|        | 21 | 24476  | 140 | 580  | 1.000 |    |
|        | 21 | 201324 | 200 | 585  | 1.000 |    |
|        | 21 | 29040  | 505 | 600  | 2.000 |    |
|        | 21 | 29040  | 310 | 600  | 7.000 |    |
|        | 21 | 26345  | 150 | 580  | 1.000 |    |
|        | 21 | 94535  | 210 | 585  | 1.000 |    |
| 25739  | 21 |        |     |      |       |    |
|        | 21 | 108516 | 37  | 400  | 1.000 |    |
|        | 21 | 94098  | 57  | 400  | 1.000 |    |
|        | 21 | 17013  | 90  | 580  | 1.000 |    |
|        | 21 | 24475  | 130 | 580  | 1.000 |    |
|        | 21 | 15224  | 30  | 580  | 1.000 |    |
|        | 21 | 993002 | 280 | 676  | 1.000 |    |
|        | 21 | 1499   | 10  | 676  | 1.000 |    |
|        | 21 | 3509   | 20  | 676  | 1.000 |    |
|        | 21 | 1333   | 290 | 676  | 2.000 |    |
|        | 21 | 17017  | 400 | 440  | 1.000 |    |
|        | 21 | 94555  | 410 | 440  | 1.000 |    |
|        | 21 | 17019  | 420 | 440  | 1.000 |    |
|        | 21 | 97312  | 430 | 435  | 1.000 |    |
|        | 21 | 305634 | 120 | 580  | 1.000 |    |
|        | 21 | 104127 | 250 | 585  | 1.000 |    |
|        | 21 | 16715  | 80  | 580  | 1.000 |    |

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| Parent | Rv | Child  | Fnd | Oper | Qty   | UM |
|--------|----|--------|-----|------|-------|----|
|        | 21 | 90982  | 170 | 585  | 1.000 |    |
|        | 01 | 15699  | 50  | 585  | 1.000 |    |
|        | 01 | 21723  | 300 | 600  | 1.130 |    |
|        | 21 | 104126 | 240 | 585  | 1.000 |    |
|        | 01 | 17034  | 100 | 580  | 4.000 |    |
|        | 01 | 24476  | 140 | 580  | 1.000 |    |
|        | 01 | 201324 | 200 | 585  | 1.000 |    |
|        | 01 | 21485  | 505 | 606  | 2.000 |    |
|        | 01 | 21485  | 310 | 606  | 7.000 |    |
|        | 01 | 26345  | 150 | 580  | 1.000 |    |
|        | 01 | 94535  | 210 | 585  | 1.000 |    |
| 25657  | 01 |        |     |      |       |    |
|        | 01 | 109283 | 37  | 400  | 1.000 |    |
|        | 01 | 105442 | 57  | 400  | 1.000 |    |
|        | 01 | 97444  | 90  | 580  | 1.000 |    |
|        | 01 | 24475  | 130 | 580  | 1.000 |    |
|        | 01 | 15224  | 30  | 580  | 1.000 |    |
|        | 01 | 993002 | 280 | 676  | 1.000 |    |
|        | 01 | 1684   | 10  | 676  | 1.000 |    |
|        | 01 | 3509   | 20  | 676  | 1.000 |    |
|        | 01 | 17017  | 400 | 440  | 1.000 |    |
|        | 01 | 94555  | 410 | 440  | 1.000 |    |
|        | 01 | 17019  | 420 | 440  | 1.000 |    |
|        | 01 | 93712  | 430 | 440  | 1.000 |    |
|        | 01 | 305640 | 120 | 580  | 1.000 |    |
|        | 01 | 106293 | 250 | 585  | 1.000 |    |
|        | 01 | 97825  | 80  | 580  | 1.000 |    |
|        | 01 | 90982  | 170 | 585  | 1.000 |    |
|        | 01 | 15699  | 50  | 585  | 1.000 |    |
|        | 01 | 21723  | 300 | 600  | 1.130 |    |
|        | 01 | 106292 | 240 | 585  | 1.000 |    |
|        | 01 | 17034  | 100 | 580  | 4.000 |    |
|        | 01 | 24476  | 140 | 580  | 1.000 |    |
|        | 01 | 201324 | 200 | 585  | 1.000 |    |
|        | 01 | 21485  | 505 | 606  | 2.000 |    |
|        | 01 | 21485  | 310 | 606  | 7.000 |    |
|        | 01 | 97490  | 150 | 580  | 1.000 |    |
|        | 01 | 97867  | 210 | 585  | 1.000 |    |
| 25639  | 01 |        |     |      |       |    |
|        | 01 | 249233 | 37  | 400  | 1.000 |    |
|        | 01 | 105442 | 57  | 400  | 1.000 |    |
|        | 01 | 97444  | 90  | 580  | 1.000 |    |
|        | 01 | 24475  | 130 | 580  | 1.000 |    |
|        | 01 | 15224  | 30  | 580  | 1.000 |    |

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| Parent | Rv | Child  | Fnd | Oper | Qty   | UM |
|--------|----|--------|-----|------|-------|----|
|        |    | 993002 | 280 | 676  | 1.000 |    |
|        |    | 1687   | 10  | 676  | 1.000 |    |
|        |    | 3509   | 20  | 676  | 1.000 |    |
|        |    | 17017  | 400 | 440  | 1.000 |    |
|        |    | 94555  | 410 | 440  | 1.000 |    |
|        |    | 17019  | 420 | 440  | 1.000 |    |
|        |    | 93712  | 430 | 435  | 1.000 |    |
|        |    | 305640 | 120 | 580  | 1.000 |    |
|        |    | 106293 | 250 | 585  | 1.000 |    |
|        |    | 97825  | 80  | 580  | 1.000 |    |
|        |    | 90982  | 170 | 585  | 1.000 |    |
|        |    | 15699  | 50  | 585  | 1.000 |    |
|        |    | 21723  | 300 | 600  | 1.130 |    |
|        |    | 106292 | 240 | 585  | 1.000 |    |
|        |    | 17034  | 100 | 580  | 4.000 |    |
|        |    | 24476  | 140 | 580  | 1.000 |    |
|        |    | 94519  | 200 | 585  | 1.000 |    |
|        |    | 21485  | 505 | 606  | 2.000 |    |
|        |    | 21485  | 310 | 606  | 7.000 |    |
|        |    | 97490  | 150 | 580  | 1.000 |    |
|        |    | 97867  | 210 | 585  | 1.000 |    |
| 25711  |    |        |     |      |       |    |
|        |    | 106664 | 37  | 581  | 1.000 |    |
|        |    | 94098  | 57  | 581  | 1.000 |    |
|        |    | 96117  | 310 | 598  | 1.000 |    |
|        |    | 17013  | 90  | 581  | 1.000 |    |
|        |    | 24475  | 130 | 581  | 1.000 |    |
|        |    | 15224  | 30  | 581  | 1.000 |    |
|        |    | 3509   | 20  | 598  | 1.000 |    |
|        |    | 17017  | 500 | 440  | 1.000 |    |
|        |    | 94555  | 510 | 440  | 1.000 |    |
|        |    | 17019  | 520 | 440  | 1.000 |    |
|        |    | 93712  | 530 | 435  | 1.000 |    |
|        |    | 305640 | 120 | 581  | 1.000 |    |
|        |    | 104127 | 250 | 586  | 1.000 |    |
|        |    | 99472  | 280 | 590  | 1.000 |    |
|        |    | 99473  | 285 | 590  | 1.000 |    |
|        |    | 16715  | 80  | 586  | 1.000 |    |
|        |    | 90982  | 170 | 586  | 1.000 |    |
|        |    | 15699  | 50  | 586  | 1.000 |    |
|        |    | 97092  | 300 | 598  | 1.000 |    |
|        |    | 21723  | 420 | 588  | 1.190 |    |
|        |    | 104126 | 240 | 586  | 1.000 |    |
|        |    | 24476  | 140 | 581  | 1.000 |    |
|        |    | 97094  | 320 | 598  | 1.000 |    |

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| Parent | Rv | Child  | Fnd | Oper | Qty   | UM |
|--------|----|--------|-----|------|-------|----|
|        | 21 | 94519B | 200 | 586  | 1.000 |    |
|        | 21 | 21485  | 505 | 594  | 2.000 |    |
|        | 21 | 21485  | 430 | 594  | 7.000 |    |
|        | 21 | 26345  | 150 | 581  | 1.000 |    |
|        | 21 | 94535  | 210 | 586  | 1.000 |    |
|        | 21 | 97091  | 280 | 590  | 1.000 |    |
|        | 21 | 97090  | 270 | 590  | 1.000 |    |
|        | 21 | 97089  | 260 | 590  | 1.000 |    |
|        | 21 | 15358  | 40  | 598  | 2.000 |    |
|        | 21 | 26555  | 10  | 598  | 2.000 |    |
| 25712  | 21 |        |     |      |       |    |
|        | 21 | 107117 | 47  | 581  | 1.000 |    |
|        | 21 | 94098  | 37  | 400  | 1.000 |    |
|        | 21 | 96117  | 310 | 598  | 1.000 |    |
|        | 21 | 17013  | 90  | 581  | 1.000 |    |
|        | 21 | 24475  | 130 | 581  | 1.000 |    |
|        | 21 | 15224  | 30  | 581  | 1.000 |    |
|        | 21 | 3509   | 20  | 598  | 1.000 |    |
|        | 21 | 17017  | 500 | 440  | 1.000 |    |
|        | 21 | 94555  | 510 | 440  | 1.000 |    |
|        | 21 | 17019  | 520 | 440  | 1.000 |    |
|        | 21 | 93712  | 530 | 435  | 1.000 |    |
|        | 21 | 305634 | 120 | 581  | 1.000 |    |
|        | 21 | 104127 | 250 | 586  | 1.000 |    |
|        | 21 | 99472  | 290 | 590  | 1.000 |    |
|        | 21 | 99473  | 285 | 590  | 1.000 |    |
|        | 21 | 106399 | 80  | 586  | 1.000 |    |
|        | 21 | 97092  | 300 | 590  | 1.000 |    |
|        | 21 | 21723  | 400 | 588  | 1.190 |    |
|        | 21 | 104126 | 240 | 586  | 1.000 |    |
|        | 21 | 97091  | 280 | 590  | 1.000 |    |
|        | 21 | 97090  | 270 | 590  | 1.000 |    |
|        | 21 | 24476  | 140 | 581  | 1.000 |    |
|        | 21 | 97094  | 320 | 586  | 1.000 |    |
|        | 21 | 993598 | 200 | 586  | 1.000 |    |
|        | 21 | 97089  | 260 | 590  | 1.000 |    |
|        | 21 | 21485  | 505 | 594  | 2.000 |    |
|        | 21 | 21485  | 430 | 594  | 7.000 |    |
|        | 21 | 26345  | 150 | 581  | 1.000 |    |
|        | 21 | 106352 | 210 | 586  | 1.000 |    |
|        | 21 | 15358  | 40  | 598  | 2.000 |    |
|        | 21 | 26555  | 10  | 598  | 2.000 |    |

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| Parent | Rv | Child | Fnd | Oper | Qty | UM |
|--------|----|-------|-----|------|-----|----|
| 01     | 01 | 01    | 01  | 01   | 01  | 01 |
| 02     | 01 | 02    | 01  | 02   | 01  | 02 |
| 03     | 01 | 03    | 01  | 03   | 01  | 03 |
| 04     | 01 | 04    | 01  | 04   | 01  | 04 |
| 05     | 01 | 05    | 01  | 05   | 01  | 05 |
| 06     | 01 | 06    | 01  | 06   | 01  | 06 |
| 07     | 01 | 07    | 01  | 07   | 01  | 07 |
| 08     | 01 | 08    | 01  | 08   | 01  | 08 |
| 09     | 01 | 09    | 01  | 09   | 01  | 09 |
| 10     | 01 | 10    | 01  | 10   | 01  | 10 |
| 11     | 01 | 11    | 01  | 11   | 01  | 11 |
| 12     | 01 | 12    | 01  | 12   | 01  | 12 |
| 13     | 01 | 13    | 01  | 13   | 01  | 13 |
| 14     | 01 | 14    | 01  | 14   | 01  | 14 |
| 15     | 01 | 15    | 01  | 15   | 01  | 15 |
| 16     | 01 | 16    | 01  | 16   | 01  | 16 |
| 17     | 01 | 17    | 01  | 17   | 01  | 17 |
| 18     | 01 | 18    | 01  | 18   | 01  | 18 |
| 19     | 01 | 19    | 01  | 19   | 01  | 19 |
| 20     | 01 | 20    | 01  | 20   | 01  | 20 |
| 21     | 01 | 21    | 01  | 21   | 01  | 21 |
| 22     | 01 | 22    | 01  | 22   | 01  | 22 |
| 23     | 01 | 23    | 01  | 23   | 01  | 23 |
| 24     | 01 | 24    | 01  | 24   | 01  | 24 |
| 25     | 01 | 25    | 01  | 25   | 01  | 25 |
| 26     | 01 | 26    | 01  | 26   | 01  | 26 |
| 27     | 01 | 27    | 01  | 27   | 01  | 27 |
| 28     | 01 | 28    | 01  | 28   | 01  | 28 |
| 29     | 01 | 29    | 01  | 29   | 01  | 29 |
| 30     | 01 | 30    | 01  | 30   | 01  | 30 |
| 31     | 01 | 31    | 01  | 31   | 01  | 31 |
| 32     | 01 | 32    | 01  | 32   | 01  | 32 |
| 33     | 01 | 33    | 01  | 33   | 01  | 33 |
| 34     | 01 | 34    | 01  | 34   | 01  | 34 |
| 35     | 01 | 35    | 01  | 35   | 01  | 35 |
| 36     | 01 | 36    | 01  | 36   | 01  | 36 |
| 37     | 01 | 37    | 01  | 37   | 01  | 37 |
| 38     | 01 | 38    | 01  | 38   | 01  | 38 |
| 39     | 01 | 39    | 01  | 39   | 01  | 39 |
| 40     | 01 | 40    | 01  | 40   | 01  | 40 |
| 41     | 01 | 41    | 01  | 41   | 01  | 41 |
| 42     | 01 | 42    | 01  | 42   | 01  | 42 |
| 43     | 01 | 43    | 01  | 43   | 01  | 43 |
| 44     | 01 | 44    | 01  | 44   | 01  | 44 |
| 45     | 01 | 45    | 01  | 45   | 01  | 45 |
| 46     | 01 | 46    | 01  | 46   | 01  | 46 |
| 47     | 01 | 47    | 01  | 47   | 01  | 47 |
| 48     | 01 | 48    | 01  | 48   | 01  | 48 |
| 49     | 01 | 49    | 01  | 49   | 01  | 49 |
| 50     | 01 | 50    | 01  | 50   | 01  | 50 |
| 51     | 01 | 51    | 01  | 51   | 01  | 51 |
| 52     | 01 | 52    | 01  | 52   | 01  | 52 |
| 53     | 01 | 53    | 01  | 53   | 01  | 53 |
| 54     | 01 | 54    | 01  | 54   | 01  | 54 |
| 55     | 01 | 55    | 01  | 55   | 01  | 55 |
| 56     | 01 | 56    | 01  | 56   | 01  | 56 |
| 57     | 01 | 57    | 01  | 57   | 01  | 57 |
| 58     | 01 | 58    | 01  | 58   | 01  | 58 |
| 59     | 01 | 59    | 01  | 59   | 01  | 59 |
| 60     | 01 | 60    | 01  | 60   | 01  | 60 |
| 61     | 01 | 61    | 01  | 61   | 01  | 61 |
| 62     | 01 | 62    | 01  | 62   | 01  | 62 |
| 63     | 01 | 63    | 01  | 63   | 01  | 63 |
| 64     | 01 | 64    | 01  | 64   | 01  | 64 |
| 65     | 01 | 65    | 01  | 65   | 01  | 65 |
| 66     | 01 | 66    | 01  | 66   | 01  | 66 |
| 67     | 01 | 67    | 01  | 67   | 01  | 67 |
| 68     | 01 | 68    | 01  | 68   | 01  | 68 |
| 69     | 01 | 69    | 01  | 69   | 01  | 69 |
| 70     | 01 | 70    | 01  | 70   | 01  | 70 |
| 71     | 01 | 71    | 01  | 71   | 01  | 71 |
| 72     | 01 | 72    | 01  | 72   | 01  | 72 |
| 73     | 01 | 73    | 01  | 73   | 01  | 73 |
| 74     | 01 | 74    | 01  | 74   | 01  | 74 |
| 75     | 01 | 75    | 01  | 75   | 01  | 75 |

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~AUTODATE

| Parent | Rv | Child | Fnd | Oper | Qty | UM  |
|--------|----|-------|-----|------|-----|-----|
| 01     | 21 | 0     | 10  | 10   | 0   | 0   |
| 02     | 11 | 0     | 10  | 10   | 0   | 0   |
| 03     | 01 | 0     | 10  | 10   | 0   | 0   |
| 04     | 01 | 0     | 10  | 10   | 0   | 0   |
| 05     | 21 | 0     | 10  | 10   | 0   | 0   |
| 06     | 21 | 0     | 10  | 10   | 0   | 0   |
| 07     | 21 | 0     | 10  | 10   | 0   | 0   |
| 08     | 01 | 0     | 10  | 10   | 0   | 0   |
| 09     | 01 | 0     | 10  | 10   | 0   | 0   |
| 10     | 01 | 0     | 10  | 10   | 0   | 0   |
| 11     | 01 | 0     | 10  | 10   | 0   | 0   |
| 12     | 01 | 0     | 10  | 10   | 0   | 0   |
| 13     | 01 | 0     | 10  | 10   | 0   | 0   |
| 14     | 01 | 0     | 10  | 10   | 0   | 0   |
| 15     | 01 | 0     | 10  | 10   | 0   | 0   |
| 16     | 01 | 0     | 10  | 10   | 0   | 0   |
| 17     | 01 | 0     | 10  | 10   | 0   | 0   |
| 18     | 01 | 0     | 10  | 10   | 0   | 0   |
| 19     | 01 | 0     | 10  | 10   | 0   | 0   |
| 20     | 01 | 0     | 10  | 10   | 0   | 0   |
| 21     | 01 | 0     | 10  | 10   | 0   | 0   |
| 22     | 01 | 0     | 10  | 10   | 0   | 0   |
| 23     | 01 | 0     | 10  | 10   | 0   | 0   |
| 24     | 01 | 0     | 10  | 10   | 0   | 0   |
| 25     | 01 | 0     | 10  | 10   | 0   | 0   |
| 26     | 01 | 0     | 10  | 10   | 0   | 0   |
| 27     | 01 | 0     | 10  | 10   | 0   | 0   |
| 28     | 01 | 0     | 10  | 10   | 0   | 0   |
| 29     | 01 | 0     | 10  | 10   | 0   | 0   |
| 30     | 01 | 0     | 10  | 10   | 0   | 0   |
| 31     | 01 | 0     | 10  | 10   | 0   | 0   |
| 32     | 01 | 0     | 10  | 10   | 0   | 0   |
| 33     | 01 | 0     | 10  | 10   | 0   | 0   |
| 34     | 01 | 0     | 10  | 10   | 0   | 0   |
| 35     | 01 | 0     | 10  | 10   | 0   | 0   |
| 36     | 01 | 0     | 10  | 10   | 0   | 0   |
| 37     | 01 | 0     | 10  | 10   | 0   | 0   |
| 38     | 01 | 0     | 10  | 10   | 0   | 0   |
| 39     | 01 | 0     | 10  | 10   | 0   | 0   |
| 40     | 01 | 0     | 10  | 10   | 0   | 0   |
| 41     | 01 | 0     | 10  | 10   | 0   | 0   |
| 42     | 01 | 0     | 10  | 10   | 0   | 0   |
| 43     | 01 | 0     | 10  | 10   | 0   | 0   |
| 44     | 01 | 0     | 10  | 10   | 0   | 0   |
| 45     | 01 | 0     | 10  | 10   | 0   | 0   |
| 46     | 01 | 0     | 10  | 10   | 0   | 0   |
| 47     | 01 | 0     | 10  | 10   | 0   | 0   |
| 48     | 01 | 0     | 10  | 10   | 0   | 0   |
| 49     | 01 | 0     | 10  | 10   | 0   | 0   |
| 50     | 01 | 0     | 10  | 10   | 0   | 0   |
| 51     | 01 | 0     | 10  | 10   | 0   | 0   |
| 52     | 01 | 0     | 10  | 10   | 0   | 0   |
| 53     | 01 | 0     | 10  | 10   | 0   | 0   |
| 54     | 01 | 0     | 10  | 10   | 0   | 0   |
| 55     | 01 | 0     | 10  | 10   | 0   | 0   |
| 56     | 01 | 0     | 10  | 10   | 0   | 0   |
| 57     | 01 | 0     | 10  | 10   | 0   | 0   |
| 58     | 01 | 0     | 10  | 10   | 0   | 0   |
| 59     | 01 | 0     | 10  | 10   | 0   | 0   |
| 60     | 01 | 0     | 10  | 10   | 0   | 0   |
| 61     | 01 | 0     | 10  | 10   | 0   | 0   |
| 62     | 01 | 0     | 10  | 10   | 0   | 0   |
| 63     | 01 | 0     | 10  | 10   | 0   | 0   |
| 64     | 01 | 0     | 10  | 10   | 0   | 0   |
| 65     | 01 | 0     | 10  | 10   | 0   | 0   |
| 66     | 01 | 0     | 10  | 10   | 0   | 0   |
| 67     | 01 | 0     | 10  | 10   | 0   | 0   |
| 68     | 01 | 0     | 10  | 10   | 0   | 0   |
| 69     | 01 | 0     | 10  | 10   | 0   | 0   |
| 70     | 01 | 0     | 10  | 10   | 0   | 0   |
| 71     | 01 | 0     | 10  | 10   | 0   | 0   |
| 72     | 01 | 0     | 10  | 10   | 0   | 0   |
| 73     | 01 | 0     | 10  | 10   | 0   | 0   |
| 74     | 01 | 0     | 10  | 10   | 0   | 0   |
| 75     | 01 | 0     | 10  | 10   | 0   | 0   |
| 76     | 01 | 0     | 10  | 10   | 0   | 0   |
| 77     | 01 | 0     | 10  | 10   | 0   | 0   |
| 78     | 01 | 0     | 10  | 10   | 0   | 0   |
| 79     | 01 | 0     | 10  | 10   | 0   | 0</ |

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| Parent | Rv | Child | Fnd | Oper | Qty | UM  |
|--------|----|-------|-----|------|-----|-----|
| 01     | 21 | 0     | 10  | 10   | 0   | 0   |
| 02     | 11 | 0     | 10  | 10   | 0   | 0   |
| 03     | 01 | 0     | 10  | 10   | 0   | 0   |
| 04     | 01 | 0     | 10  | 10   | 0   | 0   |
| 05     | 21 | 0     | 10  | 10   | 0   | 0   |
| 06     | 21 | 0     | 10  | 10   | 0   | 0   |
| 07     | 21 | 0     | 10  | 10   | 0   | 0   |
| 08     | 01 | 0     | 10  | 10   | 0   | 0   |
| 09     | 01 | 0     | 10  | 10   | 0   | 0   |
| 10     | 01 | 0     | 10  | 10   | 0   | 0   |
| 11     | 01 | 0     | 10  | 10   | 0   | 0   |
| 12     | 01 | 0     | 10  | 10   | 0   | 0   |
| 13     | 01 | 0     | 10  | 10   | 0   | 0   |
| 14     | 01 | 0     | 10  | 10   | 0   | 0   |
| 15     | 01 | 0     | 10  | 10   | 0   | 0   |
| 16     | 01 | 0     | 10  | 10   | 0   | 0   |
| 17     | 01 | 0     | 10  | 10   | 0   | 0   |
| 18     | 01 | 0     | 10  | 10   | 0   | 0   |
| 19     | 01 | 0     | 10  | 10   | 0   | 0   |
| 20     | 01 | 0     | 10  | 10   | 0   | 0   |
| 21     | 01 | 0     | 10  | 10   | 0   | 0   |
| 22     | 01 | 0     | 10  | 10   | 0   | 0   |
| 23     | 01 | 0     | 10  | 10   | 0   | 0   |
| 24     | 01 | 0     | 10  | 10   | 0   | 0   |
| 25     | 01 | 0     | 10  | 10   | 0   | 0   |
| 26     | 01 | 0     | 10  | 10   | 0   | 0   |
| 27     | 01 | 0     | 10  | 10   | 0   | 0   |
| 28     | 01 | 0     | 10  | 10   | 0   | 0   |
| 29     | 01 | 0     | 10  | 10   | 0   | 0   |
| 30     | 01 | 0     | 10  | 10   | 0   | 0   |
| 31     | 01 | 0     | 10  | 10   | 0   | 0   |
| 32     | 01 | 0     | 10  | 10   | 0   | 0   |
| 33     | 01 | 0     | 10  | 10   | 0   | 0   |
| 34     | 01 | 0     | 10  | 10   | 0   | 0   |
| 35     | 01 | 0     | 10  | 10   | 0   | 0   |
| 36     | 01 | 0     | 10  | 10   | 0   | 0   |
| 37     | 01 | 0     | 10  | 10   | 0   | 0   |
| 38     | 01 | 0     | 10  | 10   | 0   | 0   |
| 39     | 01 | 0     | 10  | 10   | 0   | 0   |
| 40     | 01 | 0     | 10  | 10   | 0   | 0   |
| 41     | 01 | 0     | 10  | 10   | 0   | 0   |
| 42     | 01 | 0     | 10  | 10   | 0   | 0   |
| 43     | 01 | 0     | 10  | 10   | 0   | 0   |
| 44     | 01 | 0     | 10  | 10   | 0   | 0   |
| 45     | 01 | 0     | 10  | 10   | 0   | 0   |
| 46     | 01 | 0     | 10  | 10   | 0   | 0   |
| 47     | 01 | 0     | 10  | 10   | 0   | 0   |
| 48     | 01 | 0     | 10  | 10   | 0   | 0   |
| 49     | 01 | 0     | 10  | 10   | 0   | 0   |
| 50     | 01 | 0     | 10  | 10   | 0   | 0   |
| 51     | 01 | 0     | 10  | 10   | 0   | 0   |
| 52     | 01 | 0     | 10  | 10   | 0   | 0   |
| 53     | 01 | 0     | 10  | 10   | 0   | 0   |
| 54     | 01 | 0     | 10  | 10   | 0   | 0   |
| 55     | 01 | 0     | 10  | 10   | 0   | 0   |
| 56     | 01 | 0     | 10  | 10   | 0   | 0   |
| 57     | 01 | 0     | 10  | 10   | 0   | 0   |
| 58     | 01 | 0     | 10  | 10   | 0   | 0   |
| 59     | 01 | 0     | 10  | 10   | 0   | 0   |
| 60     | 01 | 0     | 10  | 10   | 0   | 0   |
| 61     | 01 | 0     | 10  | 10   | 0   | 0   |
| 62     | 01 | 0     | 10  | 10   | 0   | 0   |
| 63     | 01 | 0     | 10  | 10   | 0   | 0   |
| 64     | 01 | 0     | 10  | 10   | 0   | 0   |
| 65     | 01 | 0     | 10  | 10   | 0   | 0   |
| 66     | 01 | 0     | 10  | 10   | 0   | 0   |
| 67     | 01 | 0     | 10  | 10   | 0   | 0   |
| 68     | 01 | 0     | 10  | 10   | 0   | 0   |
| 69     | 01 | 0     | 10  | 10   | 0   | 0   |
| 70     | 01 | 0     | 10  | 10   | 0   | 0   |
| 71     | 01 | 0     | 10  | 10   | 0   | 0   |
| 72     | 01 | 0     | 10  | 10   | 0   | 0   |
| 73     | 01 | 0     | 10  | 10   | 0   | 0   |
| 74     | 01 | 0     | 10  | 10   | 0   | 0   |
| 75     | 01 | 0     | 10  | 10   | 0   | 0   |
| 76     | 01 | 0     | 10  | 10   | 0   | 0   |
| 77     | 01 | 0     | 10  | 10   | 0   | 0   |
| 78     | 01 | 0     | 10  | 10   | 0   | 0   |
| 79     | 01 | 0     | 10  | 10   | 0   | 0</ |

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| Parent | Rv | Child | Fnd | Oper | Qty | UM |
|--------|----|-------|-----|------|-----|----|
| 01     | 21 | 0     | 1.0 | 1.0  | 0.0 | 0  |
| 02     | 11 | 2     | 1.0 | 1.0  | 0.0 | 0  |
| 03     | 01 | 0     | 1.0 | 1.0  | 0.0 | 0  |
| 04     | 01 | 0     | 1.0 | 1.0  | 0.0 | 0  |
| 05     | 21 | 0     | 1.0 | 1.0  | 0.0 | 0  |
| 06     | 21 | 0     | 1.0 | 1.0  | 0.0 | 0  |
| 07     | 21 | 0     | 1.0 | 1.0  | 0.0 | 0  |
| 08     | 01 | 0     | 1.0 | 1.0  | 0.0 | 0  |
| 09     | 01 | 0     | 1.0 | 1.0  | 0.0 | 0  |
| 10     | 01 | 0     | 1.0 | 1.0  | 0.0 | 0  |
| 11     | 01 | 0     | 1.0 | 1.0  | 0.0 | 0  |
| 12     | 01 | 0     | 1.0 | 1.0  | 0.0 | 0  |
| 13     | 01 | 0     | 1.0 | 1.0  | 0.0 | 0  |
| 14     | 01 | 0     | 1.0 | 1.0  | 0.0 | 0  |
| 15     | 01 | 0     | 1.0 | 1.0  | 0.0 | 0  |
| 16     | 01 | 0     | 1.0 | 1.0  | 0.0 | 0  |
| 17     | 01 | 0     | 1.0 | 1.0  | 0.0 | 0  |
| 18     | 01 | 0     | 1.0 | 1.0  | 0.0 | 0  |
| 19     | 01 | 0     | 1.0 | 1.0  | 0.0 | 0  |
| 20     | 01 | 0     | 1.0 | 1.0  | 0.0 | 0  |
| 21     | 01 | 0     | 1.0 | 1.0  | 0.0 | 0  |
| 22     | 01 | 0     | 1.0 | 1.0  | 0.0 | 0  |
| 23     | 01 | 0     | 1.0 | 1.0  | 0.0 | 0  |
| 24     | 01 | 0     | 1.0 | 1.0  | 0.0 | 0  |
| 25     | 01 | 0     | 1.0 | 1.0  | 0.0 | 0  |
| 26     | 01 | 0     | 1.0 | 1.0  | 0.0 | 0  |
| 27     | 01 | 0     | 1.0 | 1.0  | 0.0 | 0  |
| 28     | 01 | 0     | 1.0 | 1.0  | 0.0 | 0  |
| 29     | 01 | 0     | 1.0 | 1.0  | 0.0 | 0  |
| 30     | 01 | 0     | 1.0 | 1.0  | 0.0 | 0  |
| 31     | 01 | 0     | 1.0 | 1.0  | 0.0 | 0  |
| 32     | 01 | 0     | 1.0 | 1.0  | 0.0 | 0  |
| 33     | 01 | 0     | 1.0 | 1.0  | 0.0 | 0  |
| 34     | 01 | 0     | 1.0 | 1.0  | 0.0 | 0  |
| 35     | 01 | 0     | 1.0 | 1.0  | 0.0 | 0  |
| 36     | 01 | 0     | 1.0 | 1.0  | 0.0 | 0  |
| 37     | 01 | 0     | 1.0 | 1.0  | 0.0 | 0  |
| 38     | 01 | 0     | 1.0 | 1.0  | 0.0 | 0  |
| 39     | 01 | 0     | 1.0 | 1.0  | 0.0 | 0  |
| 40     | 01 | 0     | 1.0 | 1.0  | 0.0 | 0  |
| 41     | 01 | 0     | 1.0 | 1.0  | 0.0 | 0  |
| 42     | 01 | 0     | 1.0 | 1.0  | 0.0 | 0  |
| 43     | 01 | 0     | 1.0 | 1.0  | 0.0 | 0  |
| 44     | 01 | 0     | 1.0 | 1.0  | 0.0 | 0  |
| 45     | 01 | 0     | 1.0 | 1.0  | 0.0 | 0  |
| 46     | 01 | 0     | 1.0 | 1.0  | 0.0 | 0  |
| 47     | 01 | 0     | 1.0 | 1.0  | 0.0 | 0  |
| 48     | 01 | 0     | 1.0 | 1.0  | 0.0 | 0  |
| 49     | 01 | 0     | 1.0 | 1.0  | 0.0 | 0  |
| 50     | 01 | 0     | 1.0 | 1.0  | 0.0 | 0  |
| 51     | 01 | 0     | 1.0 | 1.0  | 0.0 | 0  |
| 52     | 01 | 0     | 1.0 | 1.0  | 0.0 | 0  |
| 53     | 01 | 0     | 1.0 | 1.0  | 0.0 | 0  |
| 54     | 01 | 0     | 1.0 | 1.0  | 0.0 | 0  |
| 55     | 01 | 0     | 1.0 | 1.0  | 0.0 | 0  |
| 56     | 01 | 0     | 1.0 | 1.0  | 0.0 | 0  |
| 57     | 01 | 0     | 1.0 | 1.0  | 0.0 | 0  |
| 58     | 01 | 0     | 1.0 | 1.0  | 0.0 | 0  |
| 59     | 01 | 0     | 1.0 | 1.0  | 0.0 | 0  |
| 60     | 01 | 0     | 1.0 | 1.0  | 0.0 | 0  |
| 61     | 01 | 0     | 1.0 | 1.0  | 0.0 | 0  |
| 62     | 01 | 0     | 1.0 | 1.0  | 0.0 | 0  |
| 63     | 01 | 0     | 1.0 | 1.0  | 0.0 | 0  |
| 64     | 01 | 0     | 1.0 | 1.0  | 0.0 | 0  |
| 65     | 01 | 0     | 1.0 | 1.0  | 0.0 | 0  |
| 66     | 01 | 0     | 1.0 | 1.0  | 0.0 | 0  |
| 67     | 01 | 0     | 1.0 | 1.0  | 0.0 | 0  |
| 68     | 01 | 0     | 1.0 | 1.0  | 0.0 | 0  |
| 69     | 01 | 0     | 1.0 | 1.0  | 0.0 | 0  |
| 70     | 01 | 0     | 1.0 | 1.0  | 0.0 | 0  |
| 71     | 01 | 0     | 1.0 | 1.0  | 0.0 | 0  |
| 72     | 01 | 0     | 1.0 | 1.0  | 0.0 | 0  |
| 73     | 01 | 0     | 1.0 | 1.0  | 0.0 | 0  |
| 74     | 01 | 0     | 1.0 | 1.0  | 0.0 | 0  |
| 75     | 01 | 0     | 1.0 | 1.0  | 0.0 | 0  |
| 76     | 01 | 0     | 1.0 | 1.0  | 0.0 | 0  |
| 77     | 01 | 0     | 1.0 | 1.0  | 0.0 | 0  |
| 78     | 01 | 0     | 1.0 | 1.0  | 0.0 | 0  |
| 79     | 01 | 0     | 1.0 | 1.0  | 0.0 | 0  |
| 80     | 01 | 0     | 1.0 | 1.0  | 0.0 | 0  |
| 81     | 01 | 0     | 1.0 | 1.0  | 0.0 | 0  |
| 82     | 01 | 0     | 1.0 | 1.0  | 0.0 | 0  |
| 83     | 01 | 0     | 1.0 | 1.0  | 0.0 | 0  |
| 84     | 01 | 0     | 1.0 | 1.0  | 0.0 | 0  |
| 85     | 01 | 0     | 1.0 | 1.0  | 0.0 | 0  |
| 86     | 01 | 0     | 1.0 | 1.0  | 0.0 | 0  |
| 87     | 01 | 0     | 1.0 | 1.0  | 0.0 | 0  |
| 88     | 01 | 0     | 1.0 | 1.0  | 0.0 | 0  |
| 89     | 01 | 0     | 1.0 | 1.0  | 0.0 | 0  |
| 90     | 01 | 0     | 1.0 | 1.0  | 0.0 | 0  |
| 91     | 01 | 0     | 1.0 | 1.0  | 0.0 | 0  |
| 92     | 01 | 0     | 1.0 | 1.0  | 0.0 | 0  |
| 93     | 01 | 0     | 1.0 | 1.0  | 0.0 | 0  |
| 94     | 01 | 0     | 1.0 | 1.0  | 0.0 | 0  |
| 95     | 01 | 0     | 1.0 | 1.0  | 0.0 | 0  |
| 96     | 01 | 0     | 1.0 | 1.0  | 0.0 | 0  |
| 97     | 01 | 0     | 1.0 | 1.0  | 0.0 | 0  |
| 98     | 01 | 0     | 1.0 | 1.0  | 0.0 | 0  |
| 99     | 01 | 0     | 1.0 | 1.0  | 0.0 | 0  |
| 100    | 01 | 0     | 1.0 | 1.0  | 0.0 | 0  |

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| Parent | Rv | Child | Fnd | Oper | Qty | UM  |
|--------|----|-------|-----|------|-----|-----|
| 01     | 21 | 0     | 10  | 10   | 0   | 0   |
| 02     | 11 | 0     | 10  | 10   | 0   | 0   |
| 03     | 01 | 0     | 10  | 10   | 0   | 0   |
| 04     | 01 | 0     | 10  | 10   | 0   | 0   |
| 05     | 21 | 0     | 10  | 10   | 0   | 0   |
| 06     | 21 | 0     | 10  | 10   | 0   | 0   |
| 07     | 21 | 0     | 10  | 10   | 0   | 0   |
| 08     | 01 | 0     | 10  | 10   | 0   | 0   |
| 09     | 01 | 0     | 10  | 10   | 0   | 0   |
| 10     | 01 | 0     | 10  | 10   | 0   | 0   |
| 11     | 01 | 0     | 10  | 10   | 0   | 0   |
| 12     | 01 | 0     | 10  | 10   | 0   | 0   |
| 13     | 01 | 0     | 10  | 10   | 0   | 0   |
| 14     | 01 | 0     | 10  | 10   | 0   | 0   |
| 15     | 01 | 0     | 10  | 10   | 0   | 0   |
| 16     | 01 | 0     | 10  | 10   | 0   | 0   |
| 17     | 01 | 0     | 10  | 10   | 0   | 0   |
| 18     | 01 | 0     | 10  | 10   | 0   | 0   |
| 19     | 01 | 0     | 10  | 10   | 0   | 0   |
| 20     | 01 | 0     | 10  | 10   | 0   | 0   |
| 21     | 01 | 0     | 10  | 10   | 0   | 0   |
| 22     | 01 | 0     | 10  | 10   | 0   | 0   |
| 23     | 01 | 0     | 10  | 10   | 0   | 0   |
| 24     | 01 | 0     | 10  | 10   | 0   | 0   |
| 25     | 01 | 0     | 10  | 10   | 0   | 0   |
| 26     | 01 | 0     | 10  | 10   | 0   | 0   |
| 27     | 01 | 0     | 10  | 10   | 0   | 0   |
| 28     | 01 | 0     | 10  | 10   | 0   | 0   |
| 29     | 01 | 0     | 10  | 10   | 0   | 0   |
| 30     | 01 | 0     | 10  | 10   | 0   | 0   |
| 31     | 01 | 0     | 10  | 10   | 0   | 0   |
| 32     | 01 | 0     | 10  | 10   | 0   | 0   |
| 33     | 01 | 0     | 10  | 10   | 0   | 0   |
| 34     | 01 | 0     | 10  | 10   | 0   | 0   |
| 35     | 01 | 0     | 10  | 10   | 0   | 0   |
| 36     | 01 | 0     | 10  | 10   | 0   | 0   |
| 37     | 01 | 0     | 10  | 10   | 0   | 0   |
| 38     | 01 | 0     | 10  | 10   | 0   | 0   |
| 39     | 01 | 0     | 10  | 10   | 0   | 0   |
| 40     | 01 | 0     | 10  | 10   | 0   | 0   |
| 41     | 01 | 0     | 10  | 10   | 0   | 0   |
| 42     | 01 | 0     | 10  | 10   | 0   | 0   |
| 43     | 01 | 0     | 10  | 10   | 0   | 0   |
| 44     | 01 | 0     | 10  | 10   | 0   | 0   |
| 45     | 01 | 0     | 10  | 10   | 0   | 0   |
| 46     | 01 | 0     | 10  | 10   | 0   | 0   |
| 47     | 01 | 0     | 10  | 10   | 0   | 0   |
| 48     | 01 | 0     | 10  | 10   | 0   | 0   |
| 49     | 01 | 0     | 10  | 10   | 0   | 0   |
| 50     | 01 | 0     | 10  | 10   | 0   | 0   |
| 51     | 01 | 0     | 10  | 10   | 0   | 0   |
| 52     | 01 | 0     | 10  | 10   | 0   | 0   |
| 53     | 01 | 0     | 10  | 10   | 0   | 0   |
| 54     | 01 | 0     | 10  | 10   | 0   | 0   |
| 55     | 01 | 0     | 10  | 10   | 0   | 0   |
| 56     | 01 | 0     | 10  | 10   | 0   | 0   |
| 57     | 01 | 0     | 10  | 10   | 0   | 0   |
| 58     | 01 | 0     | 10  | 10   | 0   | 0   |
| 59     | 01 | 0     | 10  | 10   | 0   | 0   |
| 60     | 01 | 0     | 10  | 10   | 0   | 0   |
| 61     | 01 | 0     | 10  | 10   | 0   | 0   |
| 62     | 01 | 0     | 10  | 10   | 0   | 0   |
| 63     | 01 | 0     | 10  | 10   | 0   | 0   |
| 64     | 01 | 0     | 10  | 10   | 0   | 0   |
| 65     | 01 | 0     | 10  | 10   | 0   | 0   |
| 66     | 01 | 0     | 10  | 10   | 0   | 0   |
| 67     | 01 | 0     | 10  | 10   | 0   | 0   |
| 68     | 01 | 0     | 10  | 10   | 0   | 0   |
| 69     | 01 | 0     | 10  | 10   | 0   | 0   |
| 70     | 01 | 0     | 10  | 10   | 0   | 0   |
| 71     | 01 | 0     | 10  | 10   | 0   | 0   |
| 72     | 01 | 0     | 10  | 10   | 0   | 0   |
| 73     | 01 | 0     | 10  | 10   | 0   | 0   |
| 74     | 01 | 0     | 10  | 10   | 0   | 0   |
| 75     | 01 | 0     | 10  | 10   | 0   | 0   |
| 76     | 01 | 0     | 10  | 10   | 0   | 0   |
| 77     | 01 | 0     | 10  | 10   | 0   | 0   |
| 78     | 01 | 0     | 10  | 10   | 0   | 0   |
| 79     | 01 | 0     | 10  | 10   | 0   | 0</ |

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~AUTODATE

| Parent | Rv | Child | Fnd | Oper | Qty | UM  |
|--------|----|-------|-----|------|-----|-----|
| 01     | 21 | 0     | 10  | 10   | 0   | 0   |
| 02     | 11 | 0     | 10  | 10   | 0   | 0   |
| 03     | 01 | 0     | 10  | 10   | 0   | 0   |
| 04     | 01 | 0     | 10  | 10   | 0   | 0   |
| 05     | 21 | 0     | 10  | 10   | 0   | 0   |
| 06     | 21 | 0     | 10  | 10   | 0   | 0   |
| 07     | 21 | 0     | 10  | 10   | 0   | 0   |
| 08     | 01 | 0     | 10  | 10   | 0   | 0   |
| 09     | 01 | 0     | 10  | 10   | 0   | 0   |
| 10     | 01 | 0     | 10  | 10   | 0   | 0   |
| 11     | 01 | 0     | 10  | 10   | 0   | 0   |
| 12     | 01 | 0     | 10  | 10   | 0   | 0   |
| 13     | 01 | 0     | 10  | 10   | 0   | 0   |
| 14     | 01 | 0     | 10  | 10   | 0   | 0   |
| 15     | 01 | 0     | 10  | 10   | 0   | 0   |
| 16     | 01 | 0     | 10  | 10   | 0   | 0   |
| 17     | 01 | 0     | 10  | 10   | 0   | 0   |
| 18     | 01 | 0     | 10  | 10   | 0   | 0   |
| 19     | 01 | 0     | 10  | 10   | 0   | 0   |
| 20     | 01 | 0     | 10  | 10   | 0   | 0   |
| 21     | 01 | 0     | 10  | 10   | 0   | 0   |
| 22     | 01 | 0     | 10  | 10   | 0   | 0   |
| 23     | 01 | 0     | 10  | 10   | 0   | 0   |
| 24     | 01 | 0     | 10  | 10   | 0   | 0   |
| 25     | 01 | 0     | 10  | 10   | 0   | 0   |
| 26     | 01 | 0     | 10  | 10   | 0   | 0   |
| 27     | 01 | 0     | 10  | 10   | 0   | 0   |
| 28     | 01 | 0     | 10  | 10   | 0   | 0   |
| 29     | 01 | 0     | 10  | 10   | 0   | 0   |
| 30     | 01 | 0     | 10  | 10   | 0   | 0   |
| 31     | 01 | 0     | 10  | 10   | 0   | 0   |
| 32     | 01 | 0     | 10  | 10   | 0   | 0   |
| 33     | 01 | 0     | 10  | 10   | 0   | 0   |
| 34     | 01 | 0     | 10  | 10   | 0   | 0   |
| 35     | 01 | 0     | 10  | 10   | 0   | 0   |
| 36     | 01 | 0     | 10  | 10   | 0   | 0   |
| 37     | 01 | 0     | 10  | 10   | 0   | 0   |
| 38     | 01 | 0     | 10  | 10   | 0   | 0   |
| 39     | 01 | 0     | 10  | 10   | 0   | 0   |
| 40     | 01 | 0     | 10  | 10   | 0   | 0   |
| 41     | 01 | 0     | 10  | 10   | 0   | 0   |
| 42     | 01 | 0     | 10  | 10   | 0   | 0   |
| 43     | 01 | 0     | 10  | 10   | 0   | 0   |
| 44     | 01 | 0     | 10  | 10   | 0   | 0   |
| 45     | 01 | 0     | 10  | 10   | 0   | 0   |
| 46     | 01 | 0     | 10  | 10   | 0   | 0   |
| 47     | 01 | 0     | 10  | 10   | 0   | 0   |
| 48     | 01 | 0     | 10  | 10   | 0   | 0   |
| 49     | 01 | 0     | 10  | 10   | 0   | 0   |
| 50     | 01 | 0     | 10  | 10   | 0   | 0   |
| 51     | 01 | 0     | 10  | 10   | 0   | 0   |
| 52     | 01 | 0     | 10  | 10   | 0   | 0   |
| 53     | 01 | 0     | 10  | 10   | 0   | 0   |
| 54     | 01 | 0     | 10  | 10   | 0   | 0   |
| 55     | 01 | 0     | 10  | 10   | 0   | 0   |
| 56     | 01 | 0     | 10  | 10   | 0   | 0   |
| 57     | 01 | 0     | 10  | 10   | 0   | 0   |
| 58     | 01 | 0     | 10  | 10   | 0   | 0   |
| 59     | 01 | 0     | 10  | 10   | 0   | 0   |
| 60     | 01 | 0     | 10  | 10   | 0   | 0   |
| 61     | 01 | 0     | 10  | 10   | 0   | 0   |
| 62     | 01 | 0     | 10  | 10   | 0   | 0   |
| 63     | 01 | 0     | 10  | 10   | 0   | 0   |
| 64     | 01 | 0     | 10  | 10   | 0   | 0   |
| 65     | 01 | 0     | 10  | 10   | 0   | 0   |
| 66     | 01 | 0     | 10  | 10   | 0   | 0   |
| 67     | 01 | 0     | 10  | 10   | 0   | 0   |
| 68     | 01 | 0     | 10  | 10   | 0   | 0   |
| 69     | 01 | 0     | 10  | 10   | 0   | 0   |
| 70     | 01 | 0     | 10  | 10   | 0   | 0   |
| 71     | 01 | 0     | 10  | 10   | 0   | 0   |
| 72     | 01 | 0     | 10  | 10   | 0   | 0   |
| 73     | 01 | 0     | 10  | 10   | 0   | 0   |
| 74     | 01 | 0     | 10  | 10   | 0   | 0   |
| 75     | 01 | 0     | 10  | 10   | 0   | 0   |
| 76     | 01 | 0     | 10  | 10   | 0   | 0   |
| 77     | 01 | 0     | 10  | 10   | 0   | 0   |
| 78     | 01 | 0     | 10  | 10   | 0   | 0   |
| 79     | 01 | 0     | 10  | 10   | 0   | 0</ |



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| Parent | Rv | Child | Fnd | Oper | Qty | UM  |
|--------|----|-------|-----|------|-----|-----|
| 01     | 21 | 0     | 10  | 10   | 0   | 0   |
| 02     | 11 | 0     | 10  | 10   | 0   | 0   |
| 03     | 01 | 0     | 10  | 10   | 0   | 0   |
| 04     | 01 | 0     | 10  | 10   | 0   | 0   |
| 05     | 21 | 0     | 10  | 10   | 0   | 0   |
| 06     | 21 | 0     | 10  | 10   | 0   | 0   |
| 07     | 21 | 0     | 10  | 10   | 0   | 0   |
| 08     | 01 | 0     | 10  | 10   | 0   | 0   |
| 09     | 01 | 0     | 10  | 10   | 0   | 0   |
| 10     | 01 | 0     | 10  | 10   | 0   | 0   |
| 11     | 01 | 0     | 10  | 10   | 0   | 0   |
| 12     | 01 | 0     | 10  | 10   | 0   | 0   |
| 13     | 01 | 0     | 10  | 10   | 0   | 0   |
| 14     | 01 | 0     | 10  | 10   | 0   | 0   |
| 15     | 01 | 0     | 10  | 10   | 0   | 0   |
| 16     | 01 | 0     | 10  | 10   | 0   | 0   |
| 17     | 01 | 0     | 10  | 10   | 0   | 0   |
| 18     | 01 | 0     | 10  | 10   | 0   | 0   |
| 19     | 01 | 0     | 10  | 10   | 0   | 0   |
| 20     | 01 | 0     | 10  | 10   | 0   | 0   |
| 21     | 01 | 0     | 10  | 10   | 0   | 0   |
| 22     | 01 | 0     | 10  | 10   | 0   | 0   |
| 23     | 01 | 0     | 10  | 10   | 0   | 0   |
| 24     | 01 | 0     | 10  | 10   | 0   | 0   |
| 25     | 01 | 0     | 10  | 10   | 0   | 0   |
| 26     | 01 | 0     | 10  | 10   | 0   | 0   |
| 27     | 01 | 0     | 10  | 10   | 0   | 0   |
| 28     | 01 | 0     | 10  | 10   | 0   | 0   |
| 29     | 01 | 0     | 10  | 10   | 0   | 0   |
| 30     | 01 | 0     | 10  | 10   | 0   | 0   |
| 31     | 01 | 0     | 10  | 10   | 0   | 0   |
| 32     | 01 | 0     | 10  | 10   | 0   | 0   |
| 33     | 01 | 0     | 10  | 10   | 0   | 0   |
| 34     | 01 | 0     | 10  | 10   | 0   | 0   |
| 35     | 01 | 0     | 10  | 10   | 0   | 0   |
| 36     | 01 | 0     | 10  | 10   | 0   | 0   |
| 37     | 01 | 0     | 10  | 10   | 0   | 0   |
| 38     | 01 | 0     | 10  | 10   | 0   | 0   |
| 39     | 01 | 0     | 10  | 10   | 0   | 0   |
| 40     | 01 | 0     | 10  | 10   | 0   | 0   |
| 41     | 01 | 0     | 10  | 10   | 0   | 0   |
| 42     | 01 | 0     | 10  | 10   | 0   | 0   |
| 43     | 01 | 0     | 10  | 10   | 0   | 0   |
| 44     | 01 | 0     | 10  | 10   | 0   | 0   |
| 45     | 01 | 0     | 10  | 10   | 0   | 0   |
| 46     | 01 | 0     | 10  | 10   | 0   | 0   |
| 47     | 01 | 0     | 10  | 10   | 0   | 0   |
| 48     | 01 | 0     | 10  | 10   | 0   | 0   |
| 49     | 01 | 0     | 10  | 10   | 0   | 0   |
| 50     | 01 | 0     | 10  | 10   | 0   | 0   |
| 51     | 01 | 0     | 10  | 10   | 0   | 0   |
| 52     | 01 | 0     | 10  | 10   | 0   | 0   |
| 53     | 01 | 0     | 10  | 10   | 0   | 0   |
| 54     | 01 | 0     | 10  | 10   | 0   | 0   |
| 55     | 01 | 0     | 10  | 10   | 0   | 0   |
| 56     | 01 | 0     | 10  | 10   | 0   | 0   |
| 57     | 01 | 0     | 10  | 10   | 0   | 0   |
| 58     | 01 | 0     | 10  | 10   | 0   | 0   |
| 59     | 01 | 0     | 10  | 10   | 0   | 0   |
| 60     | 01 | 0     | 10  | 10   | 0   | 0   |
| 61     | 01 | 0     | 10  | 10   | 0   | 0   |
| 62     | 01 | 0     | 10  | 10   | 0   | 0   |
| 63     | 01 | 0     | 10  | 10   | 0   | 0   |
| 64     | 01 | 0     | 10  | 10   | 0   | 0   |
| 65     | 01 | 0     | 10  | 10   | 0   | 0   |
| 66     | 01 | 0     | 10  | 10   | 0   | 0   |
| 67     | 01 | 0     | 10  | 10   | 0   | 0   |
| 68     | 01 | 0     | 10  | 10   | 0   | 0   |
| 69     | 01 | 0     | 10  | 10   | 0   | 0   |
| 70     | 01 | 0     | 10  | 10   | 0   | 0   |
| 71     | 01 | 0     | 10  | 10   | 0   | 0   |
| 72     | 01 | 0     | 10  | 10   | 0   | 0   |
| 73     | 01 | 0     | 10  | 10   | 0   | 0   |
| 74     | 01 | 0     | 10  | 10   | 0   | 0   |
| 75     | 01 | 0     | 10  | 10   | 0   | 0   |
| 76     | 01 | 0     | 10  | 10   | 0   | 0   |
| 77     | 01 | 0     | 10  | 10   | 0   | 0   |
| 78     | 01 | 0     | 10  | 10   | 0   | 0   |
| 79     | 01 | 0     | 10  | 10   | 0   | 0</ |

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| Description                    |                                           |
|--------------------------------|-------------------------------------------|
| RAMAC#                         | DESCRIPTION                               |
| 25743                          | 700 Pol - (Wood) - 223 REM - 24           |
| 25744                          | 700 Pol - (Wood) - 308 WIN - 24           |
| 25745                          | 700 Pol - (Syn) - 223 REM - 24            |
| 25746                          | 700 Pol - (Syn) - 308 WIN - 24            |
| 25747                          | 700 Pol - 308 WIN - Ltd LTRS - 20         |
| 25714                          | 700 Pol 1/9" Twist - 223 REM - 26         |
| 25707                          | 700 Pol 1/12" Twist - 223 REM - 26        |
| 25709                          | 700 Pol - (Syn) - 308 WIN - 26            |
| 25715                          | 700 Pol DM - (Syn) - 308 WIN - 26         |
| 25717                          | 700 Pol DM - (Syn) - 300 WIN MAG - 26     |
| 25713                          | 700 Pol DM URBAN - (Syn) - 308 WIN - 26   |
| 25737                          | 700 Pol Floor Plt 223 Rem LTR - 20        |
| 25677                          | 700 Pol Floor Plt 6.8MM Rem LTR - 20      |
| 25681                          | 700 Pol Floor Plt 300 SAUM LTR - 20       |
| 25739                          | 700 Pol Floor Plt 308 Win LTR - 20        |
| 25657                          | 700SS Pol Floor Plt 308 Win FL RB - 20    |
| 25639                          | 700SS Pol Floor Plt 308 Win FL RB - 26    |
| 25726                          | 700 Pol Floor Plt 7mm Rem Mag - 26        |
| 25718                          | 700 Pol Floor Plt 300 Win Mag - 26        |
| 25735                          | 700 Pol Floor Plt 300 Ultra - 26          |
| 25635                          | 700 Pol TWS 308 WIN - 20                  |
| 25711                          | 700 Pol TRS (Syn) 308 WIN - 26            |
| 25712                          | 700 Pol DM TWS (Syn) 308 WIN - 26         |
| 26179                          | 700 Pol - Syn - 308 WIN Fluted - 24       |
| 26181                          | 700 Pol - Syn - 308 WIN Fluted - 26       |
| 26177                          | 700 Pol - Syn - 308 WIN Non Fl - 24       |
| 26175                          | 700 Pol - Syn - 308 WIN Non Fl - 26       |
| 27503                          | 700 Pol - Syn - 6.8mm Rem SPC Fluted - 26 |
| 700 Police TWS - 308 WIN - 20" |                                           |
| Barrel Assembly (20" LTR)      |                                           |
| Bolt Assembly                  |                                           |
| BI-POD ASSEMBLY                |                                           |

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| Description                                |
|--------------------------------------------|
| Bolt Stop                                  |
| Bolt Stop Pin                              |
| Bolt Stop Spring                           |
| 700 Ejector                                |
| 700 Ejector Pin (Spirol)                   |
| 700 Ejector Spring                         |
| 700 Extractor Reg. (7400,710)              |
| Instruction Book                           |
| Firing Pin Assembly                        |
| Front Guard Screw                          |
| LENS COVERS - FLIP OPEN - EYE END          |
| LENS COVERS - FLIP OPEN - OBJECT END       |
| Magazine                                   |
| Magazine Follower                          |
| Magazine Spring                            |
| PELICAN HARD CASE #1720                    |
| PROOF ROUND                                |
| Rear Guard Screw                           |
| Sear Pin                                   |
| SLING 1"                                   |
| Stock Assembly                             |
| TEST ROUND 308 WIN 168 gr.BT HP MATCH      |
| TARGET ROUND 308 WIN 168 gr.BT HP MATCH    |
| Trigger Assembly                           |
| Trigger Guard Assembly                     |
| TRS SCOPE BASE                             |
| TRS SCOPE RINGS                            |
| TRS TELESCOPE                              |
| Swivel Assembly                            |
| 700 Police - Syn - 308 Win - 26" Non Flute |
| Barrel Assembly (26")                      |
| Bolt Assembly                              |
| Bolt Stop                                  |
| Bolt Stop Pin                              |
| Bolt Stop Spring                           |
| Box & Envelope Label                       |
| Carton - RF-CF                             |
| Instruction Book                           |
| Ethefoam Insert                            |
| Ejector                                    |
| Ejector Pin                                |
| Ejector Spring                             |
| Extractor                                  |
| Firing Pin Assembly                        |
| Front Guard Screw                          |

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| Description                                |
|--------------------------------------------|
| Magazine                                   |
| Magazine Follower                          |
| Magazine Spring                            |
| PROOF ROUND                                |
| Rear Guard Screw                           |
| Receiver Plug Screw                        |
| Sear Pin                                   |
| Stock Assembly - BLACK W/SPRUCE GREEN WEB  |
| TEST ROUND 308 WIN 168 gr.BT HP MATCH      |
| TARGET ROUND 308 WIN 168 gr.BT HP MATCH    |
| Trigger Assembly                           |
| Trigger Guard Assembly                     |
| 700 Police - Syn - 308 Win - 24" Non Flute |
| Barrel Assembly (24")                      |
| Bolt Assembly                              |
| Bolt Stop                                  |
| Bolt Stop Pin                              |
| Bolt Stop Spring                           |
| Box & Envelope Label                       |
| Carton - RF-CF                             |
| Instruction Book                           |
| Ethefoam Insert                            |
| Ejector                                    |
| Ejector Pin                                |
| Ejector Spring                             |
| Extractor                                  |
| Firing Pin Assembly                        |
| Front Guard Screw                          |
| Magazine                                   |
| Magazine Follower                          |
| Magazine Spring                            |
| PROOF ROUND                                |
| Rear Guard Screw                           |
| Receiver Plug Screw                        |
| Sear Pin                                   |
| Stock Assembly                             |
| TEST ROUND 308 WIN 168 gr.BT HP MATCH      |
| TARGET ROUND 308 WIN 168 gr.BT HP MATCH    |
| Trigger Assembly                           |
| Trigger Guard Assembly                     |
| 700 Police - Syn - 308 Win - 24" Fluted    |
| Barrel Assembly (24")                      |
| Bolt Assembly                              |
| Bolt Stop                                  |

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| Description                             |
|-----------------------------------------|
| Bolt Stop Pin                           |
| Bolt Stop Spring                        |
| Box & Envelope Label                    |
| Carton - RF-CF                          |
| Instruction Book                        |
| Ethefoam Insert                         |
| Ejector                                 |
| Ejector Pin                             |
| Ejector Spring                          |
| Extractor                               |
| Firing Pin Assembly                     |
| Front Guard Screw                       |
| Magazine                                |
| Magazine Follower                       |
| Magazine Spring                         |
| PROOF ROUND                             |
| Rear Guard Screw                        |
| Receiver Plug Screw                     |
| Sear Pin                                |
| Stock Assembly                          |
| TEST ROUND 308 WIN 168 gr.BT HP MATCH   |
| TARGET ROUND 308 WIN 168 gr.BT HP MATCH |
| Trigger Assembly                        |
| Trigger Guard Assembly                  |
| 700 Police - Syn - 308 Win - 26" Fluted |
| Barrel Assembly (26")                   |
| Bolt Assembly                           |
| Bolt Stop                               |
| Bolt Stop Pin                           |
| Bolt Stop Spring                        |
| Box & Envelope Label                    |
| Carton - RF-CF                          |
| Instruction Book                        |
| Ethefoam Insert                         |
| Ejector                                 |
| Ejector Pin                             |
| Ejector Spring                          |
| Extractor                               |
| Firing Pin Assembly                     |
| Front Guard Screw                       |
| Magazine                                |
| Magazine Follower                       |
| Magazine Spring                         |
| PROOF ROUND                             |
| Rear Guard Screw                        |

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| Description                                   |
|-----------------------------------------------|
| Receiver Plug Screw                           |
| Sear Pin                                      |
| Stock Assembly                                |
| TEST ROUND 308 WIN 168 gr.BT HP MATCH         |
| TARGET ROUND 308 WIN 168 gr.BT HP MATCH       |
| Trigger Assembly                              |
| Trigger Guard Assembly                        |
| 700 Police - Syn - 6.8mm Rem SPC - 26" Fluted |
| Barrel Assembly (26")                         |
| Bolt Assembly                                 |
| Bolt Stop                                     |
| Bolt Stop Pin                                 |
| Bolt Stop Spring                              |
| Box & Envelope Label                          |
| Carton - RF-CF                                |
| Instruction Book                              |
| Ethefoam Insert                               |
| Ejector                                       |
| Ejector Pin                                   |
| Ejector Spring                                |
| Extractor                                     |
| Firing Pin Assembly                           |
| Front Guard Screw                             |
| Magazine                                      |
| Magazine Follower                             |
| Magazine Spring                               |
| PROOF ROUND                                   |
| Rear Guard Screw                              |
| Receiver Plug Screw                           |
| Sear Pin                                      |
| Stock Assembly                                |
| Test Round 6.8mm REM SPC 115gr.HPBT Match     |
| Target Round 6.8mm REM SPC 115gr.HPBT         |
| Trigger Assembly                              |
| Trigger Guard Assembly                        |
| 700 Police Syn Floor Plt. 7mm Rem Mag - 26"   |
| Barrel Assembly                               |
| Bolt Assembly                                 |
| Bolt Stop                                     |
| Bolt Stop Pin                                 |
| Bolt Stop Spring                              |
| Box & Envelope Label                          |
| Carton - RF-CF                                |
| Instruction Book                              |

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| Description                         |
|-------------------------------------|
| Ethefoam Insert                     |
| Ejector                             |
| Ejector Pin                         |
| Ejector Spring                      |
| Extractor                           |
| Extractor Rivet                     |
| Firing Pin Assembly                 |
| Front Guard Screw                   |
| Magazine                            |
| Magazine Follower                   |
| Magazine Spring                     |
| PROOF ROUND                         |
| Rear Guard Screw                    |
| Receiver Plug Screw                 |
| Sear Pin                            |
| Stock Assembly                      |
| TEST ROUND 7mm. 140gr.PSP BT        |
| TARGET ROUND 7mm. 140gr.PSP ET      |
| Trigger Assembly                    |
| Trigger Guard Assembly              |
| 700 Police - (Wood) - 223 REM - 24" |
| Barrel Assembly (24")               |
| Bolt Assembly                       |
| Bolt Stop                           |
| Bolt Stop Pin                       |
| Bolt Stop Spring                    |
| Box & Envelope Label                |
| Carton - RF-CF                      |
| Instruction Book                    |
| Ejector                             |
| Ejector Pin                         |
| Ejector Spring                      |
| Extractor                           |
| Firing Pin Assembly                 |
| Floor Plate Insert                  |
| Front Guard Screw                   |
| Magazine Assembly                   |
| Magazine Follower                   |
| Magazine Spring                     |
| PROOF ROUND                         |
| Rear Guard Screw                    |
| Receiver Plug Screw                 |
| Sear Pin                            |
| Stock Assembly                      |
| Swivel Screw                        |

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| Description                             |
|-----------------------------------------|
| Swivel Screw Spacer                     |
| TEST ROUND 223 REM 62 gr.HP MATCH       |
| TARGET ROUND 223 REM 62 gr.HP MATCH     |
| Trigger Assembly                        |
| Trigger Guard Assembly                  |
| 700 Police - (Wood) - 308 WIN - 24"     |
| Barrel Assembly (24")                   |
| Bolt Assembly                           |
| Bolt Stop                               |
| Bolt Stop Pin                           |
| Bolt Stop Spring                        |
| Box & Envelope Label                    |
| Carton - RF-CF                          |
| Instruction Book                        |
| Ejector                                 |
| Ejector Pin                             |
| Ejector Spring                          |
| Extractor                               |
| Firing Pin Assembly                     |
| Front Guard Screw                       |
| Magazine                                |
| Magazine Follower                       |
| Magazine Spring                         |
| PROOF ROUND                             |
| Rear Guard Screw                        |
| Receiver Plug Screw                     |
| Sear Pin                                |
| Stock Assembly                          |
| Swivel Screw                            |
| Swivel Screw Spacer                     |
| TEST ROUND 308 WIN 168 gr.BT HP MATCH   |
| TARGET ROUND 308 WIN 168 gr.BT HP MATCH |
| Trigger Assembly                        |
| Trigger Guard Assembly                  |
| 700 Police - (Syn) - 223 REM - 24"      |
| Barrel Assembly (24")                   |
| Bolt Assembly                           |
| Bolt Stop                               |
| Bolt Stop Pin                           |
| Bolt Stop Spring                        |
| Box & Envelope Label                    |
| Carton - RF-CF                          |
| Instruction Book                        |
| Ejector                                 |

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| Description                             |
|-----------------------------------------|
| Ejector Pin                             |
| Ejector Spring                          |
| Extractor                               |
| Firing Pin Assembly                     |
| Floor Plate Insert                      |
| Front Guard Screw                       |
| Magazine                                |
| Magazine Follower                       |
| Magazine Spring                         |
| PROOF ROUND                             |
| Rear Guard Screw                        |
| Receiver Plug Screw                     |
| Sear Pin                                |
| Stock Assembly                          |
| TEST ROUND 223 REM 62 gr.HP MATCH       |
| TARGET ROUND 223 REM 62 gr.HP MATCH     |
| Trigger Assembly                        |
| Trigger Guard Assembly                  |
| 700 Police - (Syn) - 308 WIN - 24"      |
| Barrel Assembly (24")                   |
| Bolt Assembly                           |
| Bolt Stop                               |
| Bolt Stop Pin                           |
| Bolt Stop Spring                        |
| Box & Envelope Label                    |
| Carton - RF-CF                          |
| Instruction Book                        |
| Ejector                                 |
| Ejector Pin                             |
| Ejector Spring                          |
| Extractor                               |
| Firing Pin Assembly                     |
| Front Guard Screw                       |
| Magazine                                |
| Magazine Follower                       |
| Magazine Spring                         |
| PROOF ROUND                             |
| Rear Guard Screw                        |
| Receiver Plug Screw                     |
| Sear Pin                                |
| Stock Assembly                          |
| TEST ROUND 308 WIN 168 gr.BT HP MATCH   |
| TARGET ROUND 308 WIN 168 gr.BT HP MATCH |
| Trigger Assembly                        |
| Trigger Guard Assembly                  |

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| Description                                 |
|---------------------------------------------|
| 700 Pol - 308 WIN - Ltd LTRS - 20           |
| Barrel Assembly 20"                         |
| Bolt Assembly                               |
| Bolt Stop                                   |
| Bolt Stop Pin                               |
| Bolt Stop Spring                            |
| Box & Envelope Label                        |
| Instruction Book                            |
| Ejector                                     |
| Ejector Pin                                 |
| Ejector Spring                              |
| Extractor                                   |
| Firing Pin Assembly                         |
| Front Guard Screw                           |
| Magazine Assembly - Black Oxide             |
| PROOF ROUND                                 |
| Rear Guard Screw                            |
| Sear Pin                                    |
| Stock Assembly                              |
| TEST ROUND 308 Win. 168gr.BT HP Match       |
| Target ROUND 308 Win. 168gr.BT HP Match     |
| Trigger Assembly                            |
| Trigger Guard                               |
| Bi-Pod Assembly                             |
| Lens Cover - Flip Open - Eye end            |
| Lens Cover - Flip Open - Object end         |
| Pelican Hard Case                           |
| Scope Base                                  |
| Scope Rings                                 |
| Sling - 1"                                  |
| Telescope                                   |
| Swivel Screw                                |
| Swivel Stud                                 |
| 700 Police 1/9" Twist - (Syn)-223 REM - 26" |
| Barrel Assembly (26") 1/9" Twist            |
| Bolt Assembly                               |
| Bolt Stop                                   |
| Bolt Stop Pin                               |
| Bolt Stop Spring                            |
| Box & Envelope Label                        |
| Carton - RF-CF                              |
| Instruction Book                            |
| Ethefoam Insert                             |
| Ejector                                     |

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| Description                         |
|-------------------------------------|
| Ejector Pin                         |
| Ejector Spring                      |
| Extractor                           |
| Firing Pin Assembly                 |
| Floor Plate Insert                  |
| Front Guard Screw                   |
| Magazine                            |
| Magazine Follower                   |
| Magazine Spring                     |
| PROOF ROUND                         |
| Rear Guard Screw                    |
| Receiver Plug Screw                 |
| Sear Pin                            |
| Stock Assembly                      |
| TEST ROUND 223 REM 62 gr.HP MATCH   |
| TARGET ROUND 223 REM 62 gr.HP MATCH |
| Trigger Assembly                    |
| Trigger Guard Assembly              |
| 700 Police - (Syn) - 223 REM - 26"  |
| Barrel Assembly (26")               |
| Bolt Assembly                       |
| Bolt Stop                           |
| Bolt Stop Pin                       |
| Bolt Stop Spring                    |
| Box & Envelope Label                |
| Carton - RF-CF                      |
| Instruction Book                    |
| Ethefoam Insert                     |
| Ejector                             |
| Ejector Pin                         |
| Ejector Spring                      |
| Extractor                           |
| Firing Pin Assembly                 |
| Floor Plate Insert                  |
| Front Guard Screw                   |
| Magazine                            |
| Magazine Follower                   |
| Magazine Spring                     |
| PROOF ROUND                         |
| Rear Guard Screw                    |
| Receiver Plug Screw                 |
| Sear Pin                            |
| Stock Assembly                      |
| TEST ROUND 223 REM 62gr.HP MATCH    |
| TARGET ROUND 223 REM 62gr.HP MATCH  |

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| Description                            |
|----------------------------------------|
| Trigger Assembly                       |
| Trigger Guard Assembly                 |
| 700 Police - (Syn) - 308 WIN - 26"     |
| Barrel Assembly (26")                  |
| Bolt Assembly                          |
| Bolt Stop                              |
| Bolt Stop Pin                          |
| Bolt Stop Spring                       |
| Box & Envelope Label                   |
| Carton - RF-CF                         |
| Instruction Book                       |
| Ethefoam Insert                        |
| Ejector                                |
| Ejector Pin                            |
| Ejector Spring                         |
| Extractor                              |
| Firing Pin Assembly                    |
| Front Guard Screw                      |
| Magazine                               |
| Magazine Follower                      |
| Magazine Spring                        |
| PROOF ROUND                            |
| Rear Guard Screw                       |
| Receiver Plug Screw                    |
| Sear Pin                               |
| Stock Assembly                         |
| TEST ROUND 308 WIN 168gr.BT HP MATCH   |
| TARGET ROUND 308 WIN 168gr.BT HP MATCH |
| Trigger Assembly                       |
| Trigger Guard Assembly                 |
| 700 Police DM - (Syn) - 308 WIN - 26"  |
| Barrel Assembly 26"                    |
| Bolt Assembly                          |
| Bolt Stop                              |
| Bolt Stop Pin                          |
| Bolt Stop Spring                       |
| Box & Envelope Label                   |
| Carton - RF-CF                         |
| Instruction Book                       |
| Ethefoam Insert                        |
| Ejector                                |
| Ejector Pin                            |
| Ejector Spring                         |
| Extractor                              |

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| Description                            |
|----------------------------------------|
| Firing Pin Assembly                    |
| Front Guard Screw                      |
| Magazine Assembly                      |
| PROOF ROUND                            |
| Rear Guard Screw                       |
| Receiver Plug Screw                    |
| Sear Pin                               |
| Stock Assembly                         |
| TEST ROUND 308 WIN 168gr.BT HP MATCH   |
| TARGET ROUND 308 WIN 168gr.BT HP MATCH |
| Trigger Assembly                       |
| Trigger Guard                          |
| 700 Pol DM (Syn) - 300 WIN MAG - 26"   |
| Barrel Assembly                        |
| Bolt Assembly                          |
| Bolt Stop                              |
| Bolt Stop Pin                          |
| Bolt Stop Spring                       |
| Box & Envelope Label                   |
| Carton - RF-CF                         |
| Instruction Book                       |
| Ethefoam Insert                        |
| Ejector                                |
| Ejector Pin                            |
| Ejector Spring                         |
| Extractor                              |
| Extractor Rivet                        |
| Firing Pin Assembly                    |
| Front Guard Screw                      |
| Magazine Assembly                      |
| PROOF ROUND                            |
| Rear Guard Screw                       |
| Sear Pin                               |
| Stock Assembly                         |
| TEST ROUND 300 WIN SAFARI 180gr.PSP    |
| TARGET ROUND 300 WIN SAFARI 180gr.PSP  |
| Trigger Assembly                       |
| Trigger Guard                          |
| 700 DM BDL S/A - 308 WIN               |
| Barrel Assembly 26"                    |
| Bolt Assembly                          |
| Bolt Stop                              |
| Bolt Stop Pin                          |
| Bolt Stop Spring                       |

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| Description                               |
|-------------------------------------------|
| Box & Envelope Label                      |
| Instruction Book                          |
| Ejector                                   |
| Ejector Pin                               |
| Ejector Spring                            |
| Extractor                                 |
| Firing Pin Assembly                       |
| Front Guard Screw                         |
| Magazine Assembly - Black Oxide           |
| PROOF ROUND                               |
| Rear Guard Screw                          |
| Sear Pin                                  |
| Stock Assembly                            |
| TEST ROUND 308 WIN 150gr. PSPCL           |
| TARGET ROUND 308 WIN 168gr. SPCL          |
| Trigger Assembly                          |
| Trigger Guard                             |
| 700 Police Syn Floor Plt 300 Win Mag - 26 |
| Barrel Assembly                           |
| Bolt Assembly                             |
| Bolt Stop                                 |
| Bolt Stop Pin                             |
| Bolt Stop Spring                          |
| Box & Envelope Label                      |
| Carton - RF-CF                            |
| Instruction Book                          |
| Ethefoam Insert                           |
| Ejector                                   |
| Ejector Pin                               |
| Ejector Spring                            |
| Extractor                                 |
| Extractor Rivet                           |
| Firing Pin Assembly                       |
| Front Guard Screw                         |
| Magazine                                  |
| Magazine Follower                         |
| Magazine Spring                           |
| PROOF ROUND                               |
| Rear Guard Screw                          |
| Receiver Plug Screw                       |
| Sear Pin                                  |
| Stock Assembly                            |
| TEST ROUND 308 Win Mag 180gr.PSPCL        |
| TARGET ROUND 300 Win Mag 190gr.PSPCL      |
| Trigger Assembly                          |

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| Description                               |
|-------------------------------------------|
| Trigger Guard Assembly                    |
| 700 Police Syn Floor Plt. 300 Ultra - 26  |
| Barrel Assembly                           |
| Bolt Assembly                             |
| Bolt Stop                                 |
| Bolt Stop Pin                             |
| Bolt Stop Spring                          |
| Box & Envelope Label                      |
| Carton - RF-CF                            |
| Instruction Book                          |
| Ethefoam Insert                           |
| Ejector                                   |
| Ejector Pin                               |
| Ejector Spring                            |
| Extractor                                 |
| Extractor Rivet                           |
| Firing Pin Assembly                       |
| Front Guard Screw                         |
| Magazine                                  |
| Magazine Follower                         |
| Magazine Spring                           |
| PROOF ROUND                               |
| Rear Guard Screw                          |
| Receiver Plug Screw                       |
| Sear Pin                                  |
| Stock Assembly                            |
| TEST ROUND 300 Rem U \ Mag 180gr.FSPCL    |
| TARGET ROUND 300 Rem U \ Mag 180gr.FSPCL  |
| Trigger Assembly                          |
| Trigger Guard Assembly                    |
| 700 Police Syn Floor Plt 223 Win LTR - 20 |
| Barrel Assembly (20")                     |
| Bolt Assembly                             |
| Bolt Stop                                 |
| Bolt Stop Pin                             |
| Bolt Stop Spring                          |
| Box & Envelope Label                      |
| Carton - RF-CF                            |
| Instruction Book                          |
| Ethefoam Insert                           |
| Ejector                                   |
| Ejector Pin                               |
| Ejector Spring                            |
| Extractor                                 |

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| Description                                |
|--------------------------------------------|
| Firing Pin Assembly                        |
| Front Guard Screw                          |
| Magazine                                   |
| Floor Plate Insert                         |
| Magazine Follower                          |
| Magazine Spring                            |
| PROOF ROUND                                |
| Rear Guard Screw                           |
| Receiver Plug Screw                        |
| Sear Pin                                   |
| Stock Assembly                             |
| TEST ROUND 223 Rem 62 gr.HP MATCH          |
| TARGET ROUND 223 Rem 62 gr.HP MATCH        |
| Trigger Assembly                           |
| Trigger Guard Assembly                     |
| 700 Pol Floor Plt 6.8MM Rem SPC LTR - 20   |
| Barrel Assembly (20")                      |
| Bolt Assembly                              |
| Bolt Stop                                  |
| Bolt Stop Pin                              |
| Bolt Stop Spring                           |
| Box & Envelope Label                       |
| Carton - RF-CF                             |
| Instruction Book                           |
| Ethefoam Insert                            |
| Ejector                                    |
| Ejector Pin                                |
| Ejector Spring                             |
| Extractor                                  |
| Firing Pin Assembly                        |
| Front Guard Screw                          |
| Magazine Assy                              |
| Magazine Follower                          |
| Magazine Spring                            |
| PROOF ROUND                                |
| Rear Guard Screw                           |
| Receiver Plug Screw                        |
| Sear Pin                                   |
| Stock Assembly                             |
| Test Round 6.8mm REM SPC 115gr.HPBT Match  |
| Target Round 6.8mm REM SPC 115gr.HPBT      |
| Trigger Assembly                           |
| Trigger Guard Assembly                     |
| 700 Police Syn Floor Plt 500 SAUM LTR - 20 |

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| Description                                  |
|----------------------------------------------|
| Barrel Assembly (20")                        |
| Bolt Assembly                                |
| Bolt Stop                                    |
| Bolt Stop Pin                                |
| Bolt Stop Spring                             |
| Box & Envelope Label                         |
| Carton - RF-CF                               |
| Instruction Book                             |
| Ethefoam Insert                              |
| Ejector                                      |
| Ejector Pin                                  |
| Ejector Spring                               |
| Extractor                                    |
| Extractor Rivet                              |
| Firing Pin Assembly                          |
| Front Guard Screw                            |
| Magazine                                     |
| Magazine Follower                            |
| Magazine Spring                              |
| PROOF ROUND 300 Rem SA Ultra Mag - PRF300533 |
| Rear Guard Screw                             |
| Receiver Plug Screw                          |
| Sear Pin                                     |
| Stock Assembly                               |
| TEST ROUND - 300 S/A U/M 180 gr. PSPCL       |
| TARGET ROUND - 300 S/A U/M 180 gr. PSPCL     |
| Trigger Assembly                             |
| Trigger Guard Assembly                       |
| 700 Police Syn Floor Plt 200 Win LTR - 20    |
| Barrel Assembly (20")                        |
| Bolt Assembly                                |
| Bolt Stop                                    |
| Bolt Stop Pin                                |
| Bolt Stop Spring                             |
| Box & Envelope Label                         |
| Carton - RF-CF                               |
| Instruction Book                             |
| Ethefoam Insert                              |
| Ejector                                      |
| Ejector Pin                                  |
| Ejector Spring                               |
| Extractor                                    |
| Firing Pin Assembly                          |
| Front Guard Screw                            |
| Magazine                                     |

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| Description                                 |
|---------------------------------------------|
| Magazine Follower                           |
| Magazine Spring                             |
| PROOF ROUND                                 |
| Rear Guard Screw                            |
| Receiver Plug Screw                         |
| Sear Pin                                    |
| Stock Assembly                              |
| TEST ROUND 308 WIN 168 gr.BT HP MATCH       |
| TARGET ROUND 308 WIN 168 gr.BT HP MATCH     |
| Trigger Assembly                            |
| Trigger Guard Assembly                      |
| 700SS Pol Floor Plt 308 Win FL ROTOBlast-20 |
| Barrel Assembly (20")                       |
| Bolt Assembly                               |
| Bolt Stop                                   |
| Bolt Stop Pin                               |
| Bolt Stop Spring                            |
| Box & Envelope Label                        |
| Carton - RF-CF                              |
| Instruction Book                            |
| Ejector                                     |
| Ejector Pin                                 |
| Ejector Spring                              |
| Extractor                                   |
| Firing Pin Assembly                         |
| Front Guard Screw                           |
| Magazine                                    |
| Magazine Follower                           |
| Magazine Spring                             |
| PROOF ROUND                                 |
| Rear Guard Screw                            |
| Receiver Plug Screw                         |
| Sear Pin                                    |
| Stock Assembly                              |
| TEST ROUND 308 WIN 168 gr.BT HP MATCH       |
| TARGET ROUND 308 WIN 168 gr.BT HP MATCH     |
| Trigger Assembly                            |
| Trigger Guard Assembly                      |
| 700SS Pol Floor Plt 308 Win FL ROTOBlast-26 |
| Barrel Assembly (26")                       |
| Bolt Assembly                               |
| Bolt Stop                                   |
| Bolt Stop Pin                               |
| Bolt Stop Spring                            |

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| Description                             |
|-----------------------------------------|
| Box & Envelope Label                    |
| Carton - RF-CF                          |
| Instruction Book                        |
| Ejector                                 |
| Ejector Pin                             |
| Ejector Spring                          |
| Extractor                               |
| Firing Pin Assembly                     |
| Front Guard Screw                       |
| Magazine                                |
| Magazine Follower                       |
| Magazine Spring                         |
| PROOF ROUND                             |
| Rear Guard Screw                        |
| Receiver Plug Screw                     |
| Sear Pin                                |
| Stock Assembly                          |
| TEST ROUND 308 WIN 168 gr.BT HP MATCH   |
| TARGET ROUND 308 WIN 168 gr.BT HP MATCH |
| Trigger Assembly                        |
| Trigger Guard Assembly                  |
| 700 Police TRS - (Syn) - 308 WIN - 26"  |
| Barrel Assembly (26")                   |
| Bolt Assembly                           |
| BT-POD ASSEMBLY                         |
| Bolt Stop                               |
| Bolt Stop Pin                           |
| Bolt Stop Spring                        |
| Instruction Book                        |
| Ejector                                 |
| Ejector Pin                             |
| Ejector Spring                          |
| Extractor                               |
| Firing Pin Assembly                     |
| Front Guard Screw                       |
| LENS COVERS - FLIP OPEN - EYE END       |
| LENS COVERS - FLIP OPEN - OBJECT END    |
| Magazine                                |
| Magazine Follower                       |
| Magazine Spring                         |
| PELICAN HARD CASE                       |
| PROOF ROUND                             |
| Rear Guard Screw                        |
| Sear Pin                                |
| SLING 1"                                |

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| Description                              |
|------------------------------------------|
| Stock Assembly                           |
| TEST ROUND 308 WIN 168 gr.BT HP MATCH    |
| TARGET ROUND 308 WIN 168 gr.BT HP MATCH  |
| Trigger Assembly                         |
| Trigger Guard Assembly                   |
| TRS SCOPE BASE                           |
| TRS SCOPE RINGS                          |
| TRS TELESCOPE                            |
| Swivel Screw                             |
| Swivel Assembly                          |
| 700 Police DM TWS (Syn) - 308 WIN - 26"  |
| Barrel Assembly 26"                      |
| Bolt Assembly                            |
| BI-POD ASSEMBLY                          |
| Bolt Stop                                |
| Bolt Stop Pin                            |
| Bolt Stop Spring                         |
| Instruction Book                         |
| Ejector                                  |
| Ejector Pin                              |
| Ejector Spring                           |
| Extractor                                |
| Firing Pin Assembly                      |
| Front Guard Screw                        |
| LENS COVERS - FLIP OPEN - EYE END        |
| LENS COVERS - FLIP OPEN - OBJECT END     |
| Magazine Assembly                        |
| PELICAN HARD CASE                        |
| PROOF ROUND                              |
| Rear Guard Screw                         |
| SCOPE BASE                               |
| SCOPE RINGS                              |
| Sear Pin                                 |
| SLING 1"                                 |
| Stock Assembly                           |
| TELESCOPE                                |
| TEST ROUND 308 WIN 168 gr. BT HP Match   |
| TARGET ROUND 308 WIN 168 gr. BT HP Match |
| Trigger Assembly                         |
| Trigger Guard                            |
| Swivel Screw                             |
| Swivel Stud                              |

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| Description |  |
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Subject to Protective Order - Williams v. Remington

ILE00117164

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| Description |  |
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ILE00117165

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| Description |  |
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ILE00117166

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| Description |  |
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ILE00117167

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| Description |  |
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ILE00117168

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| Description |  |
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| Description |  |
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Subject to Protective Order - Williams v. Remington

ILE00117171

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| Description |  |
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| Date:     | Reason for Revision:                                                                                                                                                                                                                                   | Eng: | Log #: |
|-----------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|------|--------|
| 16-May-01 | Copied entire process from VAXcamps #384757                                                                                                                                                                                                            | RLJ  | 304220 |
| 24-Aug-01 | 4.5 to 5.5 lb trigger pull was 4 to 5 pounds.                                                                                                                                                                                                          | RLJ  | 305059 |
| 5-Sep-01  | Added accuracy spec to 300 RUM caliber Police rifles.                                                                                                                                                                                                  | RLJ  | 305062 |
| 8-Sep-01  | Added muzzle re-chamfering instructions & tools at target                                                                                                                                                                                              | RLJ  | 305064 |
| 12-Oct-01 | Replaced F1721 Doc Envelope Assy with 350B Instruction Book.                                                                                                                                                                                           | RLJ  | 305075 |
| 31-Oct-01 | In Sequence of Operations section: op 586 - Dept 8761 was 8785, op 590 - Dept 8488 was 8761, op 594 - Dept 8488 was 8785.                                                                                                                              | RLJ  | 305388 |
| 7-Jan-02  | Changed structure to revert to original, short non-ISS style Firing Pin Assy. P/N 94093 was 109589 and 94094 was 109588.                                                                                                                               | RLJ  | 305407 |
| 4-Apr-02  | Trigger pull 4.5 to 6.5 was 4.5 to 5.5                                                                                                                                                                                                                 | RLJ  | 305777 |
| 18-Jun-02 | OP#640- STAMP DATE CODE ON BARREL AT LEFT-REAR OF BARREL, JUST AHEAD OF RECEIVER. (PASSED GUNS) WAS "STAMP FINAL INSPECTION AND Q&Q MARKS" IN TWO PLACES<br>- REMOVE "a. Apply sticker to Gun Tag"<br>- ADD C-47444 - DRAWING LISTING DATE CODE STAMPS | GLC  | 307049 |
| 3-Sep-02  | ADD RAMAC 25581                                                                                                                                                                                                                                        | GLC  | 307240 |
| 4-Feb-03  | Added SKU# 26175, 26177, 26179 & 26181 per DCR 14988 BOS 110. Removed Build to Tag 3487 - expensed item now                                                                                                                                            | RLJ  | 308219 |
| 24-Feb-03 | PT#202085 WAS 120086 Spruce Green Web FOR RAMAC #6175                                                                                                                                                                                                  | GLC  | 308776 |
| 26-Feb-03 | Updated to current practice (details only) Updated Description in op: 440 & 585 (Router)                                                                                                                                                               | ERF  | 307607 |
| 19-Aug-03 | RAMAC#25581 - CORRECT MAGAZINE PT# - WAS 110845                                                                                                                                                                                                        | GLC  | 310154 |
| 13-Nov-03 | Added SKU 25635                                                                                                                                                                                                                                        | RFL  | 310339 |

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| Date:     | Reason for Revision:                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   | Eng: | Log #: |
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| 21-Nov-03 | RAMAC#25711 & 25712 - ADD PT#17017 - Ejector<br>- ADD PT#94555 - Ejector Pin<br>- ADD PT#17019 - Ejector Spring<br>- ADD PT#93712 - Extractor<br>RAMAC#25635 - ADD PT#98576 - BORE CLEANER<br>- ADD PT#98575 - REM OIL<br>- ADD PT#15358 - Swivel Screw                                                                                                                                                                                                                                                | GLC  | 310751 |
| 21-Nov-03 | Removed #98576-Bore Cleaner, #98575-Rem Oil, #15358-Swivel screw From RAMAC 5635                                                                                                                                                                                                                                                                                                                                                                                                                       | RFL  | 306917 |
| 17-Jun-04 | Added operation 648 and information to Step 3 on oper 640. Trigger pull spec reduced from 4.5 to 6.5 to 4.5 to 5.5 on ops 583, 585, 586, 640. Added operation 600R for special slave bolt proof procedure.                                                                                                                                                                                                                                                                                             | RLJ  | 310367 |
| 24-Jun-04 | Replaced ISS Firing Pin Assy with Non-ISS Fluted Firing Pin Assy. 94093 now 305634, 94094 now 305633.                                                                                                                                                                                                                                                                                                                                                                                                  | 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.<br><br>- 4.5 pounds Min was used when trigger pull was measured in the direction of the top of the stock comb.<br><br>- 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 |
| 5-Nov-04  | OP#400, 405, 415 & 650 - UPDATE INFO AND REESTABLISH LINKS FOR HEADING PLUGS<br>MOVE RAMAC#25735 & 25681 FROM OP#415 TO 400<br>REMOVE RAMAC#25735 & 25681 FROM OP#420                                                                                                                                                                                                                                                                                                                                  | GLC  | 313053 |
| 4-Jan-05  | Changed Pelican Case #97092 to #202536 for SKU #25635 - new shorter case to be used on 20" TWS.                                                                                                                                                                                                                                                                                                                                                                                                        | MFS  | 313184 |
| 4-Jan-05  | OP 580 581 583 585 586 640 648 added pull scale verification process                                                                                                                                                                                                                                                                                                                                                                                                                                   | DWB  | 313324 |
| 11-Jan-05 | RAMAC#25681 - MAGAZINE PT#110845 WAS 110847                                                                                                                                                                                                                                                                                                                                                                                                                                                            | GLC  | 313605 |
| 14-Jan-05 | ADD OP#395 FOR ALL PART #'S                                                                                                                                                                                                                                                                                                                                                                                                                                                                            | GLC  | 313608 |

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| Date:     | Reason for Revision:                                                                                                     | Eng: | Log #: |
|-----------|--------------------------------------------------------------------------------------------------------------------------|------|--------|
|           | REMOVE INSPECTION INFO FROM OP#400,405,& 415                                                                             |      |        |
| 18-Jan-05 | ADD OP#650 AGAIN - MISSING FROM ROUTING                                                                                  | GLC  | 313623 |
| 2-Feb-05  | Replace Sub-contract stk 99986 with purchased 99986B                                                                     | RJL  | 312487 |
|           | Replace Sub-contract stk 202085 with purchased 202085B                                                                   |      |        |
|           | Replace Sub-contract stk 94519 with purchased 94519B                                                                     |      |        |
| 14-Mar-05 | RAMAC#25709 - Carton - RF-CF PT#1688 WAS 1499                                                                            | GLC  | 314069 |
|           | RAMAC#25714 - Carton - RF-CF PT#1688 WAS 1499                                                                            |      |        |
|           | RAMAC#25726 - Carton - RF-CF PT#1688 WAS 1499                                                                            |      |        |
|           | RAMAC#25718 - Carton - RF-CF PT#1688 WAS 1499                                                                            |      |        |
|           | RAMAC#25735 - Carton - RF-CF PT#1688 WAS 1499                                                                            |      |        |
| 14-Apr-05 | Added To Op. 585 Floor Plate Insert F98020 Ramac 25737                                                                   | ERF  | 311637 |
| 18-Apr-05 | ADD RAMAC#25677 - 700 Pol Floor Plt 6.8MM Rem SPC LTR - 20                                                               | GLC  | 314426 |
|           | OP#435 - ADD TENSION PLUGS FOR 6.8MM REM SPC                                                                             |      |        |
| 27-Apr-05 | ADD RAMAC#25657 - 700SS Pol Floor Plt 308 Win FL RB - 20                                                                 | GLC  | 314546 |
|           | ADD RAMAC#25639 - 700SS Pol Floor Plt 308 Win FL RB - 26                                                                 |      |        |
|           | DCR#15798                                                                                                                |      |        |
| 18-May-05 | RAMAC#25639 & 25657 - Firing Pin Assembly PT#305640 WAS 105411                                                           | GLC  | 314720 |
| 3-Jun-05  | RAMAC#25639 - Barrel Assembly (26") PT#249233 WAS 106328                                                                 | GLC  | 314916 |
| 3-Jun-05  | RAMAC#25639 & 25657 - ADD Trigger Loc PT#201392                                                                          | GLC  | 314917 |
| 29-Jun-05 | On SKU #25677, test and target ammo #29146 was #27676; changed due to ammo availability.                                 | MFS  | 314529 |
| 8-Jul-05  | Added SKU #27593 per NFP #2005-ML37.                                                                                     | MFS  | 314537 |
| 16-Jul-05 | RAMAC#27593 - Carton - RF-CF PT#1687 WAS 1499                                                                            | GLC  | 315288 |
| 17-Aug-05 | On SKU #25677, Firing Pin Assy #305634 was #94093 - corrected to Non-ISS Fluted Firing Pin Assy.                         | MFS  | 315261 |
| 18-Aug-05 | On SKU's #25657 and #25639, Bolt Assembly #105442 was #1135257 per DCR# 15986.                                           | MFS  | 315266 |
| 19-Aug-05 | On SKU #25677, Magazine Follower #92508 was #90982 and Magazine Spring #15699 was #91133; were incorrect on parts lists. | MFS  | 315267 |

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| Date:     | Reason for Revision:                                                                                                             | Eng: | Log #: |
|-----------|----------------------------------------------------------------------------------------------------------------------------------|------|--------|
| 7-Sep-05  | On SKU's #25677 and #27503, Ejector #201843 was #17017 and Ejector Spring #201841 was #17019; per DCR# 15996.                    | MFS  | 315487 |
| 8-Sep-05  | RAMAC#25681 - Ejector Spring PT#201841 was #17019 DCR# 15996                                                                     | GLC  | 315545 |
| 16-Sep-05 | Changed targeting spec in Op 606 from 1.5" to 2.5" for .300 Win Mag, .300 Rem Ultra Mag, .300 Rem S/A Ultra Mag and 7mm Rem Mag. | MFS  | 315492 |
| 28-Sep-05 | On SKU #25657, Carton #1684 was #1687; BOM incorrect.                                                                            | MFS  | 315500 |
| 29-Sep-05 | Removed trigger lock 201392 from all police SKU's. No longer needed on police offerings                                          | RJO  | 314949 |



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Type "Ctrl+r" from the desired destination to insert this form. Execute after the HTPCIR above.

PROCESS RECORD - HEAT TREAT SPECIFICATION

Process

Material:  
Furnace:  
Rack:  
Maximum Load:  
  
Temperature:  
Soak Time:  
Carbon %:  
Quench:  
Wash:  
Notes:

Inspection

Hardness:  
  
Break Test:  
Color Only:  
Appearance of Parts:

CONFIDENTIAL

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*Unassigned Button Clicked*

*You have clicked a button that is not assigned to a process sheet*

*Click the button to return to the Header Sheet*