

PRE- STOCK		POST STOCK		FINAL INSP
4.50	u	5.00	d	4.75
4.50		4.50	u	4.75
4.25	u	4.50		4.50
4.75	d	4.25		4.25
5.25		5.25	d	5.00
5.00	d	4.75	u	5.00
4.75	d	4.00		4.00
4.50	d	3.75	u	4.00
4.50	d	3.75		3.75
4.75	u	5.00		5.00
4.50	u	5.50		5.50
4.75	u	5.50		5.50
4.25	u	4.50	d	4.25
4.50	u	4.75		4.75
4.50	u	4.75		4.75
4.75	u	5.50	d	5.00
5.00	u	5.25	d	5.00
4.75	u	5.00		5.00
4.00	u	4.25	d	4.00
4.00	u	4.25		4.25
4.25	u	4.75	d	4.00
4.50	u	4.75	d	4.50
4.50		4.50		4.50
4.50		4.50		4.50
4.50	d	3.50		3.50
4.25	u	4.50	d	3.75
4.25	u	4.50	d	3.50
4.50	u	5.00	d	4.75
4.75	u	5.00	d	4.75
4.75		4.75	u	5.00
4.25		4.25	d	4.00
4.25	u	4.50	d	4.25
4.25	u	4.50	d	4.00
4.25	u	4.75	d	3.75
4.00	d	3.75	u	4.00
4.25		4.25	d	3.75
5.00		5.00	d	4.75
5.00	u	5.25	d	4.75
5.00	u	5.50	d	4.75
4.25	u	4.50	d	4.00
4.25	u	4.50	d	4.00
4.25		4.25	d	3.75
4.50		4.50	d	4.25
4.50	d	4.25	d	4.00
4.50	d	4.25	d	4.00
4.75	u	6.25	d	6.00
5.00	u	5.75	d	5.25
5.00	d	4.75	u	5.50
4.50	d	4.00	u	4.25
4.50	u	4.75	d	4.50

4.75	u	4.75	d	4.25
4.25	u	5.00	d	4.25
4.50		4.50		4.50
4.25	u	4.75	d	4.50
4.00	d	3.75	u	4.00
4.00	u	4.25		4.25
4.50	d	4.25		4.25
4.50	u	4.75	d	4.00
4.25	u	4.50	d	4.25
4.25		4.25	d	4.00
4.50	u	5.00	d	4.50
4.50	u	5.75	d	5.50
4.50	u	5.75	d	5.50
4.50	d	4.25		4.25
4.50		4.50	d	4.25
4.50	u	4.75	d	4.50
4.50	d	4.25	d	4.00
4.50	d	4.25		4.25
4.50	d	4.25		4.25
4.25	u	4.50	d	3.75
4.50	u	4.75		4.75
4.50		4.50	u	4.75
4.50	u	4.75	d	4.50
4.50	u	4.75	d	4.50
4.50	u	4.75	d	4.50
4.25		4.25		4.25
4.50	u	4.75		4.75
4.50	u	5.00	d	4.50
4.75		4.75	d	4.25
4.50	u	5.00	d	4.75
4.75	d	4.50		4.50
4.75		4.75	d	4.50
4.75	u	5.25	d	4.50
4.50	u	4.75	d	4.25
4.50	u	4.75	d	4.50
4.75	u	5.25		5.25
5.00	u	5.25	d	5.00
4.50	u	4.75	d	4.50
4.50	u	5.00	d	4.50
4.75	u	4.50		4.50
4.00	d	3.75	u	4.00
4.00	u	4.50	d	4.00
4.00	d	3.75	u	4.00
5.00	d	4.25		4.25
5.00		5.00	d	4.50
5.00		5.00	d	4.25
4.50		4.50	d	4.25
4.00	u	5.00	d	4.50
4.50	u	5.00	d	4.75
4.50		4.00		4.00
4.50		4.50	u	5.00
4.00	u	5.00	d	4.75

	4.00		4.00		4.00
	4.00	u	4.50		4.50
	4.00	u	4.50	d	4.25
	4.50	u	4.75	d	4.50
	4.50		4.50	d	4.25
	4.50		4.50	d	4.00
	3.75		3.75	u	4.00
	3.75		3.75		3.75
	4.00		3.75	d	3.50
	4.00	u	4.25	d	4.00
	4.00	u	4.75	d	4.50
	4.00	u	4.75	d	4.50
	4.25	u	6.25	d	4.25
	4.50	u	5.25	d	4.00
	4.50	u	5.00	d	4.50
	4.00		4.00	u	3.75
	4.00	u	4.75	d	4.25
	4.00		4.00		4.00
	4.25	u	4.50	d	4.25
	4.25		4.25	u	4.50
	4.25	u	4.50	d	3.50
	4.00	u	4.25	d	3.25
	4.50	d	4.00		4.00
	4.50	d	4.00	u	4.25
	4.25	d	2.50	u	4.25
	4.50	d	3.75	u	4.00
	4.25	d	3.75	u	4.50
	5.00	u	5.25	d	4.00
	5.00	d	4.50	d	4.25
	4.75		4.75	d	4.25
	4.50		4.50	d	4.00
	4.25	u	4.50	d	4.25
	4.25		4.25	d	4.00
	4.50		4.50		4.50
	4.50	u	4.75	d	4.50
	4.25	u	4.50	d	3.75
	5.00	d	3.75	u	4.25
	4.75	d	4.25	d	3.75
	4.50	d	3.75	d	3.25
	4.50	u	5.50	d	4.75
	4.50	u	5.50	d	4.75
	4.25	u	5.00	d	4.25
AVE	4.44	AVE	4.63	AVE	4.36
MIN	3.75	MIN	2.50	MIN	3.25
MAX	5.25	MAX	6.25	MAX	6.00
RANGE	1.50	RANGE	3.75	RANGE	2.75

Remington Product Proposal Short Form

Date: February 2, 2008

NPP# 2008-83**RAMAC**SAP Description: X-Mark Pro Trigger-Externally AdjustableSite Assignment: ☒ ILION ☐ MAYFIELD ☐ R & DCategory: ☐ SHOTGUNS ☒ CENTERFIRE ☐ RIMFIRE ☐ ACCESSORYProduct Description: ☒ NEW ☐ REPEAT ☐ MODIFY**Background:**

From review of our manufacturing processes, it was determined that the current XMP trigger design not be controlled to provide an average out of the box trigger pull of 3 1/2 pounds. To achieve this trigger must be set just prior to final pack. The most feasible way to achieve this trigger pull is to create an externally adjusted XMP trigger. Development of this trigger will also provide Sales and Marketing a very saleable feature for the Remington rifle line. Current CAR estimate is \$362,000.

The adjustable XMP project is a defensive measure to protect Model 700 market share.

Based on the proposed project economics of \$362,000 it would only take a loss of 1800 Model 700 to adversely impact our standard gross profit beyond that level. These calculations are based 2008 gross profit figures.

Marketing Overview:

Remington builds the best bolt action rifle available in the Model 700 and Model Seven. These models provide consumers with tremendous value, the best out of the box accuracy, dependability, and fun. The only weakness is our trigger. This is due to competitive introductions over the last 4 years. Trigger with Savage's introduction of the AccuTrigger offering the consumer adjustment of pull. Sako, Browning, Winchester, Thompson Center, Smith & Wesson now all offer consumers an adjustable trigger. It is critical that we develop an externally adjusted X-Mark Pro to protect our market share.

Product Description Detail:

Develop externally adjustable X-Mark Pro Trigger for the Model 700 and Model Seven line. Adjust to allow a 2 pound range of adjustment of 3-5 pounds. Fire control must provide same crisp feel with take up and break as cleanly as current X-Mark Pro. All guns to leave Ilion set at 3 1/2 pounds (+/- 1/2). Final trigger pull to be set just prior to going in box.

Special Instructions:

Phase In-Start phasing externally adjusted X-Mark Pro in the 3rd quarter of 2008. All 2009 new products to feature new externally adjusted trigger. Varmint and VTR line to get externally adjustable version when available.

Submitted By:
Revisions:J Fink

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Remington Product Proposal Short Form

Date 3-07-2007

NPP# 2008-24REV #1 5-24-07
ADDED SKU's and quant**RAMAC**SAP Description: New X-Mark Pro 40-X Model TriggerSite Assignment: ☒ ILION ☐ MAYFIELD ☐ R & DCategory: ☐ SHOTGUNS ☒ CENTERFIRE ☐ RIMFIRE ☐ ACCESSORYDist Channel: ☒ DOMESTIC ☐ INTERNATIONAL
☒ AGENCY ☐ LAW ENFORCEMENT
☒ NTL ACCOUNTSSales Type: ☒ CATALOG ☐ SPRING ☐ WINTER ☐ SHOW
☐ CUSTOMER SPECIALProduct Description: ☒ NEW ☐ REPEAT ☐ MODIFY**Product Description Detail:**New X-Mark Pro Trigger designed with an external adjustment--like the 40-X style trigger**Special Instructions:**Develop a 40-X style trigger that is externally adjustable on the new X-Mark pro trigger platformImplement this new trigger into all existing Model 700 "Varmint/Target" modelsModel 700 SPS Varmint: 84213 thru 84218--approx. 12,000 guns this yearModel 700 VTR: 84370 and 84371--approx. 1,900 gunsModel 700 VLSS TH: 27443, 27445, 27447--approx 3,000 gunsModel 700 Sendero SF II: 27307, 27311, 27313, 27315, 27318--approx 2,600 gunsModel 700 Varmint Left hand (will get the left hand configuration): 84225 thru 84229--approxModel 700 VSSF II: 26333, 26335, 26337, 26339, and 84352--approx. 2,100 guns

Year	Volumes	MSP	Invoice	FET	RemCash	Cost	\$Margin
			\$ -	\$ -	\$ -		\$ -

Key Dates & Quantities:

Event	Date	Qty	Event	Date	Qty	Event	Date
DAT			Catalog Decision	ASAP		Test ammo	
Start T&P			Photo Sample			Proof ammo	
Complete T & P			Writers Shooters			Gallery ammo	
Warehouse			Writers Display				
Structures			Sales Shooters				
			Sales Display				
			Rep Samples				
			Shot Show				

Submitted By: B. Lasley

Revisions: _____

ies

x. 2,600 guns

%Margin
#DIV/0!

Qty

REMINGTON ARMS COMPANY, INC.
CAPITAL APPROPRIATION REQUEST

Date: 3/7/2008
 Title: **M/700 X-Mark Pro Trigger Assembly - Externally Adjustable**

Project No.

Site: Ilion, New York
 Category: Necessity & Support:
 Maintenance of Production
 Health & Safety
 Expansion & Improvement X
 R & D

Budget Amount:
 Budget Period:
 Annualized Cost: \$ 720,406
 R O I C: -217.7%
 Payback: -

	Expenditures
Capital Amount	\$ 293,995
Operations Amount	<u>\$ 36,861</u>
Total Project Commitment	<u>\$ 330,856</u>

Justification:

Current:

The current M/700 X-Mark Pro Trigger Assembly does not allow the consumer to adjust the Trigger pull themselves. Four years ago, Savage introduced the AccuTrigger which offers adjustment of Trigger pull by the consumer. Sako, Browning, Winchester, Thompson Center, and Smith & Wesson now all offer consumers an adjustable Trigger. It is critical that Remington develop an externally adjustable X-Mark Pro Trigger to protect our Market Share.

Proposed:

R&D has re-designed, and tested an externally adjustable X-Mark Pro Fire Control. This re-designed X-Mark Pro Fire Control will require a new Trigger and Trigger Housing Rear Spacer from PMPD, as well as additional processing. The design also introduces a secondary Trigger Pull Screw and Spring. The secondary Screw and Spring are easily accessible and will allow the customer to easily adjust the Trigger pull weight.

Benefits are highlighted below:

1. The new design allows the Trigger pull to be adjusted at Final Inspection without the need to remove the Stock from the Rifle.
2. The introduction of an externally adjustable Trigger matches our competition's offerings and preserves market share.
3. Minor changes to the processing and assembly of the new X-Mark Pro Fire Control will also allow us to produce the externally non-adjustable version of the X-Mark Pro Fire Control.

This CAR provides the needed funds required to produce M/700 Externally Adjustable X-Mark Pro Trigger Assembly.

An Economic analysis indicates a cost increase of (\$4.94)/unit on an incremental basis, and (\$720,406) annually based on (146,000) units.

Submitted By: Craig Becker

Approvals:

C. J. Lane Jr.	Date
R. Krol	Date
S. Perniciaro	Date
R. Skinner	Date

J. Gross	Date
J. Gyure	Date
S. Jackson	Date
T. Torbeck	Date

Sheet E BARBER - RE 0000011

Remington Arms Co., Inc.

Firearms Division

Ops Summarization (Supplement to Exhibit III)

**Do Not Fill In Shaded Areas

						Check One			
Quantity	Per Unit Cost	Cost	Shipping	Installation	Total Cost	Eng Estimate	Vendor Quote	Vendor Name	Useful Life
Molds, Gauges, Dies, Tooling	0	0				x			
Alter existing rivet fixtures	0	0			1,000	x			
					-				
	0	0			-				
Step Drill	24				400.00	x			
Step Drill	24				400.00	x			
Piloted C'Bore	24				500.00	x			
Taps	24				600.00	x			
Chatillion Scales	100	6			600.00	x			
Benches / Tables					5,000.00	x			
					-				
					-				
					-				
					-				
Total					8,500				
Ammo	25,500	0.30			7,650				
					-				
Total					7,650				
Guns M/700	38	180			13,000				
	-	-			-				
Total					13,000				
Total D&R			-		-				
Total T&P			-		-				
Total Travel		-	5,000.00		5,000.00				

REMINGTON ARMS COMPANY, INC.
CAPITAL APPROPRIATION REQUEST

Date: 2/20/2008
Title: X-Mark Pro Trigger - Externally Adjustable

Project No.

Site: Ilion, New York
Category: Necessity & Support:
Maintenance of Production
Health & Safety
Expansion & Improvement
R & D

Budget Amount:
Budget Period:
Annualized Savings: \$
R O I C:
Payback:

	Expenditures
Capital Amount	\$
Operations Amount	
Total Project Commitment	\$

Justification:

Current: Please describe below current situation & problems associated with it:

The current XMP trigger design can not be controlled to provide an average out of the box trigger pull of 3-1/2 lbs. The design also does not allow the consumer to self-adjust the trigger pull. Four years ago, Savage introduced the AccuTrigger which offers the customer these features. Following that product release, Sako, Browning, Winchester, Thompson Center and Smith & Wesson now all offer an adjustable trigger. It is critical the Remington develop an externally adjustable X-Mark Pro to protect our Market Share.

Proposed:

Please describe below proposal by Technical group & the benefits associated with it:

The re-designed XMP will require an altogether new trigger and rear spacer from PMPD, as well as additional processing. The design also introduces a secondary trigger pull screw and spring. The secondary screw and spring are easily accessible by the customer, and will allow the setting of a 3-1/2 lb.trigger pull at final pack.

Benefits are highlighted below:

1. The new design allows the trigger pull to be adjusted at final pack without the need to remove the stock from the rifle.
2. The introduction of an externally adjustable trigger pull matches our competition's offerings and preserves market share.
3. If Marketing wishes to continue to offer a non adjustable XMP trigger, this design will allow for that flexibility. The elimination of several processing steps to the new trigger and rear spacer replicates the existing design.

Submitted By: Craig Becker

Approvals:

C. J. Lane Jr. Date

R. Skinner Date

R. Krol Date

J. Pugliese Date

S. Perniciaro Date

J. Gross Date

M/700 XMarkPro
Top / Bottom Grind
SAAMI Drop

JAR OFF TEST (See S.A.A.M.I. volume VII, centerfire rifle, section 7-95.04)							
12 inch drop measured from the lowest point of the firearm. Firearm in the SAFE OFF position.							
Fire Arm	Serial #	BV, MU	BV, MD	BH, BD	BH, BU	BH, RSU	BH, LSU
B1	G6679213	OK	OK	OK	OK	OK	OK
B2	G6679162	OK	OK	OK	OK	OK	OK
B3	G6681045	OK	OK	OK	OK	OK	OK
T1	G6679112	OK	OK	OK	OK	OK	OK
T2	G6681081	OK	OK	OK	OK	OK	OK
T3	G6681097	OK	OK	OK	OK	OK	OK

DROP TEST (see S.A.A.M.I. volume VII, centerfire rifle, section 7-95.02)							
48 inch drop measured from the center of gravity of the firearm. Firearm in the SAFE ON position.							
Fire Arm	Serial #	BV, MU	BV, MD	BH, BD	BH, BU	BH, RSU	BH, LSU
B1	G6679213	OK	OK	OK	OK	OK	OK
B2	G6679162	OK	OK	OK	OK	OK	OK
B3	G6681045	OK	OK	OK	OK	OK	OK
T1	G6679112	OK	OK	OK	OK	OK	OK
T2	G6681081	OK	OK	OK	OK	OK	OK
T3	G6681097	OK	OK	OK	OK	OK	OK

ROTATION TEST (see S.A.A.M.I. volume VII, centerfire rifle, section 7-95.03)							
With the butt on the mat, let the firearm fall to the right & left. Firearm in the SAFE ON position.							
		LEFT SIDE UP				RIGHT SIDE UP	
B1	G6679213	OK	OK	OK	OK	OK	OK
B2	G6679162	OK	OK	OK	OK	OK	OK
B3	G6681045	OK	OK	OK	OK	OK	OK
T1	G6679112	OK	OK	OK	OK	OK	OK
T2	G6681081	OK	OK	OK	OK	OK	OK
T3	G6681097	OK	OK	OK	OK	OK	OK

M/700 XMarkPro
Top / Bottom Grind
SAAMI Drop

B - Bottom grind

T - Top Grind

All stocks were cracked after the 4 foot drop.

DROP ORDER	FIREARM ATTITUDES
1	BARREL VERTICAL, MUZZLE UP
2	BARREL VERTICAL, MUZZLE DOWN
3	BARREL HORIZONTAL, BOTTOM DOWN
4	BARREL HORIZONTAL, BOTTOM UP
5	BARREL HORIZONTAL, RIGHT SIDE UP
6	BARREL HORIZONTAL, LEFT SIDE UP

BH	Barrel Horizontal
BV	Barrel Vertical
MU	Muzzle Up
MD	Muzzle Down
BD	Bottom Down
BU	Bottom Up
LSU	Left Side Up
RSU	Right Side Up

Measurements

Initial Measurements								
	Caliber	Serial #	Trigger Pull (lbs)	Safety Force (lbs)		Firing Pin Indent (in)	Sear Lift (in.)	Headspace Min + (in.)
				To On	To Off			
A1	223 Rem	G6710034	3.4	6.2	3.6	0.0213	0.013	0.002
A2	300 Win Mag	TT009856	3.4	5.5	2.9	0.0217	0.012	0.001
A3	243 Win	G6775952	3.7	6.3	3.6	0.0208	0.012	0.001
A4	270 WSM	S7666002	3.6	6.2	3.7	0.0202	0.013	0.002
A5	270 Win	G6794912	3.5	5.9	3.6	0.0208	0.012	0.000
A6	300 Win Mag	TT009886	3.7	6.7	3.2	0.0220	0.014	0.000
A7	30-06 Sprgfld	D6634319	3.5	5.5	3.4	0.0208	0.012	0.002
A8	223 Rem	G6710045	3.5	5.5	3.4	0.0208	0.012	0.002
A9	300 Win Mag	TT009620	3.5	5.7	3.1	0.0217	0.011	0.001
A10	270 Win	G6794916	3.2	5.8	2.8	0.0217	0.013	0.000
A11	270 WSM	S7666149	3.3	5.8	3.2	0.0197	0.012	0.002
A12	270 Win	G6794918	3.5	5.7	3.1	0.0217	0.012	0.001
A13	300 Win Mag	TT009888	3.6	6.3	3.0	0.0217	0.012	0.000
A14	270 WSM	S7666151	3.6	6.1	2.7	0.0192	0.012	0.002
A15	223 Rem	G6710093	3.7	6.2	3.1	0.0212	0.012	0.002
A16	270 Win	G6794937	3.4	6.2	3.0	0.0127	0.012	0.000
A17	243 Win	G6775976	3.4	5.9	3.1	0.0208	0.013	0.001
A18	30-06 Sprgfld	D6634391	3.4	6.0	3.2	0.0218	0.012	0.000
A19	30-06 Sprgfld	D6634389	3.6	5.3	3.1	0.0210	0.100	0.000
A20	243 Win	G6775991	3.4	5.2	3.0	0.0205	0.012	0.003
Averages			3.5	5.9	3.2	0.0206	0.017	0.001

Endurance Function Measurer								
	Caliber	Serial #	500 rds			1000 rds		
			Trigger Pull (lbs)	Sear Lift (in)	Headspace Min + (in.)	Trigger Pull (lbs)	Sear Lift (in)	Headspace Min + (in.)
A1	223 Rem	G6710034	5.8	0.013	0.001	=	=	=
A2	300 Win Mag	TT009856	3.7	0.011	0.001	=	=	=
A3	243 Win	G6775952	4.7	0.012	0.001	=	=	=
A4	270 WSM	S7666002	4.4	0.013	0.002	=	=	=
A5	270 Win	G6794912	3.7	0.012	0.000	=	=	=
A6	300 Win Mag	TT009886	=	=	=	3.7	0.014	0.001
A7	30-06 Sprgfld	D6634319	=	=	=	3.9	0.012	0.001
A8	223 Rem	G6710045	=	=	=	3.9	0.012	0.001
A9	300 Win Mag	TT009620	=	=	=			
A10	270 Win	G6794916	=	=	=	5.7	0.013	0.000
A11	270 WSM	S7666149	=	=	=	33	0.012	0.002

Measurements

A12	270 Win	G6794918	=	=	=	3.5	0.012	0.000
A13	300 Win Mag	TT009888	=	=	=			
A14	270 WSM	S7666151	=	=	=			
A15	223 Rem	G6710093	=	=	=	5.5	0.012	0.002
A16	270 Win	G6794937	=	=	=	6	0.012	0.000
A17	243 Win	G6775976	3.6	0.013	0.001	=	=	=
A18	30-06 Sprgfld	D6634391	3.4	0.011	0.000	=	=	=
A19	30-06 Sprgfld	D6634389	5.2	0.010	0.001	=	=	=
A20	243 Win	G6775991	4.0	0.012	0.003	=	=	=

Measurements for Drop & Slam Test

Caliber		Serial #	Trigger Pull (lbs)	Safety Force (lbs)		Firing Pin Indent	Sear Lift (in.)	Headspace Min + (in.)
				To On	To Off			
A21	300 WSM	TT010146	3.1	5.4	3.2	0.0217	0.012	0.001
A22	300 WSM	TT010147	3.0	5.2	3.1	0.0207	0.012	0.001
A23	300 WSM	TT010152	3.0	6.0	2.8	0.0215	0.012	0.001
A24	270 Win	G6794927	3.0	5.7	3.2	0.0220	0.012	0.000
A25	270 Win	G6794930	3.0	6.2	3.4	0.0220	0.012	0.000
A26	270 Win	G6795071	3.0	5.3	3.0	0.0212	0.011	0.000
A27	270 WSM	S7666167	3.0	5.1	3.4	0.0195	0.012	0.002
A28	270 WSM	S7666183	3.0	5.8	2.5	0.0190	0.012	0.003
A29	270 WSM	S7666215	3.0	6.5	3.5	0.0205	0.012	0.001
A30	223 Rem	G6714165	3.0	5.4	3.0	0.0213	0.013	0.001
A31	223 Rem	G6714181	3.0	6.5	3.0	0.0215	0.011	0.001
A32	223 Rem	G6714199	3.0	6.8	2.7	0.0215	0.013	0.001
A33	30-06 Sprgfld	D6634401	3.0	5.4	2.9	0.0218	0.011	0.000
A34	30-06 Sprgfld	D6634412	3.0	6.7	2.9	0.0215	0.012	0.001
A35	30-06 Sprgfld	D6634316	3.0	5.4	3.1	0.0203	0.012	0.001
A36	243 Win	G6776006	3.0	6.8	3.9	0.0210	0.013	0.001
A37	243 Win	G6776016	3.0	5.3	2.9	0.0210	0.012	0.003
A38	243 Win	G6776018	3.0	5.2	3.0	0.0213	0.012	0.001
	Averages		3.0	5.8	3.1	0.0211	0.012	0.001

Measurements

Measurements					
2000 rds			3000 rds		
Trigger Pull (lbs)	Sear Lift (in)	Headspace Min + (in.)	Trigger Pull (lbs)	Sear Lift (in)	Headspace Min + (in.)
—	—	—	—	—	—
—	—	—	—	—	—
—	—	—	—	—	—
—	—	—	—	—	—
—	—	—	—	—	—
—	—	—	—	—	—
3.5	0.012	0.002	—	—	—
			—	—	—
5.7	0.012	0.000	3.4	0.012	0.000

Measurements

3.4	0.012	0.000	=	=	=
			=	=	=
=	=	=	=	=	=
=	=	=	=	=	=
=	=	=	=	=	=
=	=	=	=	=	=
=	=	=	=	=	=
=	=	=	=	=	=
=	=	=	=	=	=

Trigger Pull (lbs) After Drop
3.3
2.9
3.0
2.9
Bolt Handle Broke @ Braze
3.1
3.0
2.6
2.7
3.3
3.5
3.2
3.4
3.1
3.6
3.3
3.3
3.3
3.1

Endurance Summary

MALFUNCTIONS SORTED BY SERIAL NUMBER									
Serial #	# of	# of	Malf.	Malfunction					
	Malf	Rds. Fired	Rate	BOR	DE	SLC	SOR	SRC	SC
G6710034	0	500	0.0%	0					
TT009856	0	500	0.0%	0					
G6775952	0	500	0.0%	0					
S7666002	4	500	0.8%	4					
G6794912	0	1000	0.0%	0					
TT009886	0	1000	0.0%	0					
D6634319	0	2000	0.0%	0					
G6710045	0	2000	0.0%						
TT009620	0	3000	0.0%						
G6794916	0	3000	0.0%	0					
S7666149	0	3000	0.0%						
G6794918	0	2000	0.0%	0					
TT009888	0	2000	0.0%						
S7666151	0	1000	0.0%						
G6710093	0	1000	0.0%	0					
G6794937	0	500	0.0%	0					
G6775976	0	500	0.0%	0					
D6634391	0	500	0.0%	0					
D6634389	0	500	0.0%	0					
G6775991	0	500	0.0%	0					
TOTALS	4	25500	0.0%	4	0	0	0	0	0

MALFUNCTIONS SORTED BY TESTER									
Tester	# of	# of	Malf.	Malfunction					
	Malf	Rds. Fired	Rate	BOR	SI	SLC	SOR	SRC	SC
TOTALS	0	0	#DIV/0!	0	0	0	0	0	0

Endurance Summary

Ammunition		Description

BOR	Bolt Over Ride
SI	Stems Incline
SLC	Stems Left Chamber
SOR	Stem Override
SRC	Stems Right Chamber
SC	Stems Chamber

[illegible]

84268 700 ALASKAN TI 300 WSM 24"

Was

26368	Obsolete M/700 Ti 7mm RUM 24"
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SEVEN XCR CAMO 270 WSM 22

Was

29553 SEVEN SS 300 REM SA U.MAG 2

[illegible]

M/700

<u>Serial #</u>	<u>SKU</u>	<u>Caliber</u>
	27337	30-06
	27337	30-06
	27337	30-06
D6634401	27337	30-06
D6634412	27337	
	27011	
G6794916	27011	270 Win
	27011	270 Win
	27011	270 Win
G6794928	27011	270 Win
G6794926	27011	270 Win
G6795071	27011	270 Win
TT009620	84266	<u>300 Win Mag</u>
	84266	300WinMag
	84266	300WinMag
	84266	300WinMag
TT009901	84266	300WinMag
TT009904	84266	300WinMag
TT010047	84266	300WinMag
TT010138	84268	<u>300WSM</u>
TT010140	84268	300WSM
TT010142	84268	300WSM
TT010144	84268	300WSM
TT010146	84268	300WSM
TT010147	84268	300WSM
TT010152	84268	300WSM
	27491	
	27491	223 Rem
	27491	223 Rem
G6714165	27491	223 Rem
G6714181	27491	223 Rem
G6714199	27491	223 Rem
	27475	
	27475	243 Win
	27475	243 Win
G6776006	27475	243 Win
G6776016	27475	243 Win
G6776018	27475	243 Win

M/7

<u>Serial #</u>	<u>SKU</u>	<u>Caliber</u>
7834821	85953	22-250
7835982	85953	22-250
7837370	85953	22-250
7837403	85953	22-250
7837475	85953	22-250
7837672	85953	22-250
7837676	85953	<u>22-250</u>
	86053	
S7666149	86053	270WSM
	86053	270WSM
S7666167	86053	270WSM
S7666183	86053	270WSM
S7666215	86053	270WSM

1	G6710034	<u>223 Rem</u>	
2	TT009856	<u>300 Win Mag</u>	
3	G6775952	<u>243 Win</u>	
4	S7666002	<u>270 WSM</u>	500
5	G6794912	<u>270 Win</u>	
6	TT009886	<u>300 Win Mag</u>	1000
7	D6634319	<u>30-06</u>	
8	G6710045	<u>223 Rem</u>	2000
9			
10			
11			
12	G6794918	<u>270 Win</u>	
13	TT009888	<u>300 Win Mag</u>	2000
14	S7666151	<u>270 WSM</u>	
15	G6710093	<u>223 Rem</u>	1000
16	G6794937	<u>270 Win</u>	
17	G6775976	<u>243 Win</u>	
18	D6634391	<u>30-06</u>	
19	D6634390	<u>30-06</u>	
20	G6775991	<u>243 Win</u>	500

M/700 XMP
Adjustible

Fire Control 1

Trigger Pull	0	5000	10000
1	3.7	3.9	4.3
2	3.5	3.8	4.1
3	3.4	4.0	4.3
4	3.6	3.9	4.0
5	3.6	4.2	4.0
Average	3.5	4.0	4.1
Sear Lift	0.012	0.011	0.011

Fire Control 2

Trigger Pull	0	5000	10000
1	3.5	4.2	4.1
2	3.5	4.0	4.2
3	3.3	3.9	3.6
4	3.7	4.2	4.0
5	3.4	3.9	3.8
Average	3.5	4.0	3.9
Sear Lift	0.010	0.01	0.011

Fire Control 3

Trigger Pull	0	5000	10000
1	3.8	Trigger broke @ 5000 rounds - Operator Malfunction	
2	3.5		
3	3.3		
4	3.7		
5	3.5		
Average	3.6		
Sear Lift	0.012		

Fire Control 4

Trigger Pull	0	5000	10000
1	3.3	4.2	3.9
2	3.7	4.6	4
3	3.4	4.8	3.7
4	3.8	4.2	4.1
5	3.6	4.8	3.8
Average	3.6	4.5	3.9
Sear Lift	0.012	0.013	0.013

Fire Control 5

Trigger Pull	0	5000	10000
1	3.8	3.8	3.8
2	3.5	3.5	3.5
3	3.4	3.4	3.4
4	3.6	3.6	3.6
5	3.3	3.3	3.3
Average	3.5	3.5	3.5
Sear Lift	0.01	0.011	0.01

Fire Control 6

Trigger Pull	0	5000	10000
1	3.5	3.5	3.5
2	3.5	3.5	3.5
3	3.6	3.6	3.6
4	3.3	3.3	3.3
5	3.5	3.5	3.5
Average	3.5	3.5	3.5
Sear Lift	0.012	0.012	0.012

Fire Control 7

Trigger Pull	0	5000	10000
1	3.4	3.2	3.6
2	3.2	3.7	3.9
3	3.4	3.4	3.7
4	3.2	3.2	3.6
5	3.2	3.3	3.9
Average	3.3	3.4	3.7
Sear Lift	0.012	0.01	0.011

Fire Control 8

Trigger Pull	0	5000	10000
1	3.4	4.8	5.1
2	3.3	4.6	5.2
3	3.3	4.7	4.2
4	3.5	4.7	5
5	3.2	5	4.5
Average	3.3	4.8	4.8
Sear Lift	0.012	0.012	0.012

Fire Control 9

Trigger Pull	0	5000	10000
1	3.4	3.5	3.9
2	3.6	3.5	3.8
3	3.5	3.7	3.8
4	3.6	3.6	3.4
5	3.2	4	3.8
Average	3.5	3.7	3.7
Sear Lift	0.012	0.012	0.012

Fire Control 10

Trigger Pull	0	5000	10000
1	3.3	4.3	3.6
2	3.4	4.2	4.1
3	3.6	3.9	4.1
4	3.6	4.3	3.9
5	3.6	4.1	4
Average	3.5	4.2	3.9
Sear Lift	0.011	0.011	0.011

M/700 LH XMarkPro
Trial and Pilot
Measurements

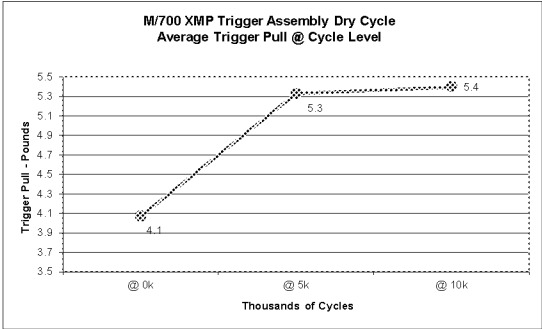
Caliber	Serial #	# Rds
223 Rem	G6416876	500
223 Rem	G6416737	500
223 Rem	G6416849	1000
223 Rem	G6417517	3000
223 Rem	G6416863	3000
223 Rem	G6417487	500
308 Win	G6419182	500
308 Win	G6416473	500
308 Win	G6416500	1000
308 Win	G6417873	3000
308 Win	G6417216	2000
308 Win	G6416276	1000
308 Win	G6419156	500
270 Win	G6518019	500
270 Win	G6517529	2000
270 Win	G6517431	2000
223 Rem	G6417484	2000
270 Win	G6517963	1000
270 Win	G6518109	500
270 Win	G6517453	500
270 Win	G6517949	500

XMarkPro
MM Sear
Dry Cycle

Trigger Pull				
Trigger Assembly	Cycles			
	0	5000	10000	
1	3.7	4.5	4.2	
2	3.4	4.2	4.2	
3	3.5	4.6	5.1	
4	3.5	5.4	5.1	
5	3.8	5.5	5.9	
6	4.7	5.3	4.8	
7	5.4	6.0	9.5	
8	3.9	7.3	5.4	
9	4.2	5.3	4.3	
10	4.6	5.2	5.5	
Average	4.1	5.3	5.4	

Sear Lift				
Trigger Assembly	Cycles			
	0	5000	10000	
1	0.010	0.010	0.010	
2	0.010	0.010	0.010	
3	0.012	0.012	0.012	
4	0.012	0.012	0.012	
5	0.012	0.012	0.012	
6	0.012	0.012	0.012	
7	0.012	0.012	0.012	
8	0.012	0.012	0.012	
9	0.012	0.012	0.012	
10	0.011	0.011	0.011	
Average	0.0115	0.0115	0.0115	

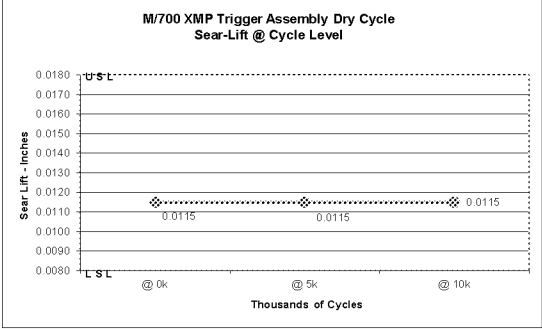
Trigger Assembly	Trigger Pull @ Cycles		
	@ 0k	@ 5k	@ 10k
1	3.7	4.5	4.2
2	3.4	4.2	4.2
3	3.5	4.6	5.1
4	3.5	5.4	5.1
5	3.8	5.5	5.9
6	4.7	5.3	4.8
7	5.4	6.0	9.5
8	3.9	7.3	5.4
9	4.2	5.3	4.3
10	4.6	5.2	5.5
Average	4.1	5.3	5.4



Safety On		
Trigger Assembly	Cycles	
	0	10000
1	6.5	6.1
2	5.5	5.1
3	6.2	5.8
4	6.6	5.9
5	6.5	6.2
6	6.0	4.0
7	7.0	7.4
8	6.9	5.8
9	6.9	5.0
10	6.7	5.4
Average	6.5	6.7

Safety Off		
Trigger Assembly	Cycles	
	0	10000
1	3.0	2.6
2	3.0	2.6
3	3.1	3.0
4	3.0	3.4
5	3.5	2.5
6	2.9	2.0
7	3.3	3.2
8	3.0	2.6
9	3.1	2.6
10	3.3	2.5
Average	3.1	2.7

Trigger Assembly	Sear Lift @ Cycles		
	@ 0k	@ 5k	@ 10k
1	0.010	0.010	0.010
2	0.010	0.010	0.010
3	0.012	0.012	0.012
4	0.012	0.012	0.012
5	0.012	0.012	0.012
6	0.012	0.012	0.012
7	0.012	0.012	0.012
8	0.012	0.012	0.012
9	0.012	0.012	0.012
10	0.011	0.011	0.011
Average	0.0115	0.0115	0.0115



M/700 XMP
MIM

Fire Control 1

Trigger Pull	0	5000	10000
1			
2			
3			
4			
5			
Average			
Safety(on-off)			
Sear Lift			

Fire Control 2

Trigger Pull	0	5000	10000
1			
2			
3			
4			
5			
Average			
Safety(on-off)			
Sear Lift			

Fire Control 3

Trigger Pull	0	5000	10000
1			
2			
3			
4			
5			
Average			
Safety(on-off)			
Sear Lift			

Fire Control 4

Trigger Pull	0	5000	10000
1			
2			
3			
4			
5			
Average			
Safety(on-off)			
Sear Lift			

Fire Control 5

Trigger Pull	0	5000	10000
1			
2			
3			
4			
5			
Average			
Safety(on-off)			
Sear Lift			

Fire Control 6

Trigger Pull	0	5000	10000
1			
2			
3			
4			
5			
Average			
Safety(on-off)			
Sear Lift			

Fire Control 7

Trigger Pull	0	5000	10000
1			
2			
3			
4			
5			
Average			
Safety(on-off)			
Sear Lift			

Fire Control 8

Trigger Pull	0	5000	10000
1			
2			
3			
4			
5			
Average			
Safety(on-off)			
Sear Lift			

Fire Control 9

Trigger Pull	0	5000	10000
1			
2			
3			
4			
5			
Average			
Safety(on-off)			
Sear Lift			

Fire Control 10

Trigger Pull	0	5000	10000
1			
2			
3			
4			
5			
Average			
Safety(on-off)			
Sear Lift			