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Remington Arms Company Inc.
RESEARCH & DEVELOPMENT TECHNICAL CENTER
315 WEST RING ROAD
ELIZABETHTOWN, KY 42701

Method:

- Use digital height gauge and one-tenth dial indicator attachment.
- Visually check to ensure the firearm is unloaded.
- Clamp firearm in portable vise and set on top of granite table.
- Remove the bolt assembly.
- Place the safety in the "Fire" position.
- Use a small bubble level to level the top of the receiver relative to the granite table.
- Zero indicator on the receiver insert just rearward of the sear.
- Lightly depress the sear until contact with the trigger is felt and hold in place.
- Indicate to the top of the rear portion of the sear and record the measurement.
- Reinstall the bolt assembly and close over an empty chamber.
- Use pin gauges to measure the gap between the receiver insert and the bottom of the firing pin head, record the gap width.
- Subtract the gap width from the indicated measurement and record as the firing pin to sear engagement.

Data Required:

- Firearm Serial Number
- Indicated measurement
- Pin gauge gap width measurement
- Firing pin head to sear engagement.

TLW03000 – Bolt Stop Function Check

The Bolt Stop will be checked for proper function. The bolt stop must prevent the bolt from being unintentionally withdrawn from the receiver when in the "locked" position and must permit the bolt to be withdrawn when in the "un-locked" position. Measure the amount of force required to move the bolt stop from the locked position to the un-locked position and record. Determine if the bolt stop can be operated by a bare hand and then a gloved hand without the aid of a tool.

J.R. Snedeker

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Revision # 3