C694538

MODEL 700 TH M24

Model 5HS TH

Action

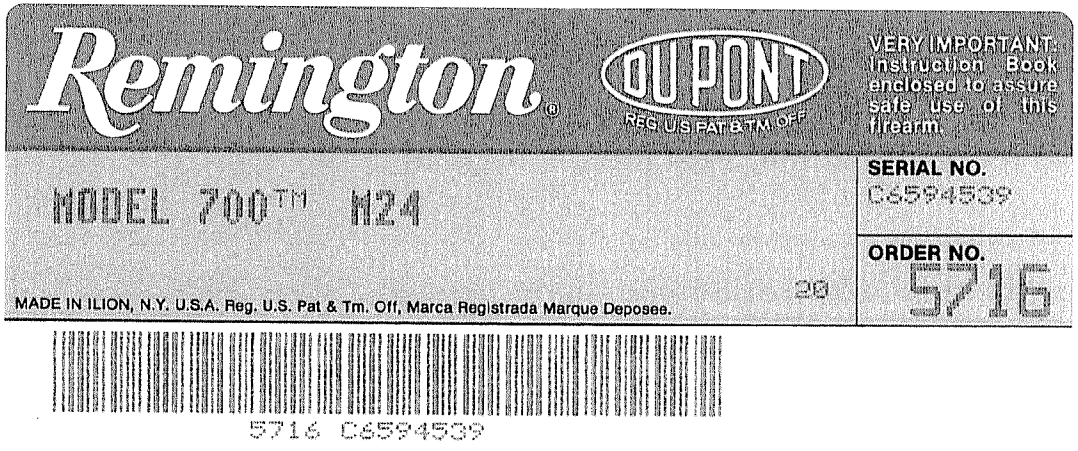
Barrel Length

Capacity

Order No. 57L6

*Includes 1 in chamber.

Remington



File Add Repair Estimate Repair Expedite Repair Inquiry Repair Tools CSR Tools Reports Table Maintenance System Maintenance Help

Repair Number: RE00080846

Verify Repair

Serial: C6594539 Model M24 SWS Center Fire
Caliber: 7.62 NATO

Repairman:

Status: Closed 5/12/2004 1:45:16 PM

Address Information

Customer		Received From	Return To:		Received From
Name:	CDR HHC 1-5 IN M585		CDR HHC 1-5 IN M585		
Address 1:	BOX 339500		BOX 339500		
Address 2:		PO Box:		PO Box:	
City:	FORT LEWIS		FORT LEWIS		
State:	WA	Zip Code: 98433 Country: US	State: WA	Zip Code: 98433	Country: US

FFL:

Contact / Condition | Problems | Estimate | History / Status | Shipping / Billing

Contact Information

Phone:
Fax:
Email:
Comments:

Received Condition

Good

Condition Notes:

CSR Notes:

Accessories Received

Code	Desc	Qty
A007	With Stud	3
A010	Hard Case	1
A017	Scope Base	1
A045	Bi Pod	1
C000	Frt and Rear Sgt Base	1

Repair Search | Refresh | Close

nagley 5/12/2004 3:29 PM CAPS NUM INS SCRL

start

Serial Number: C6594539

Model: M24 SWS

RE00080846

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFOMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6594539.__0
FILE DATE AND TIME: 06/03/2004 09:48

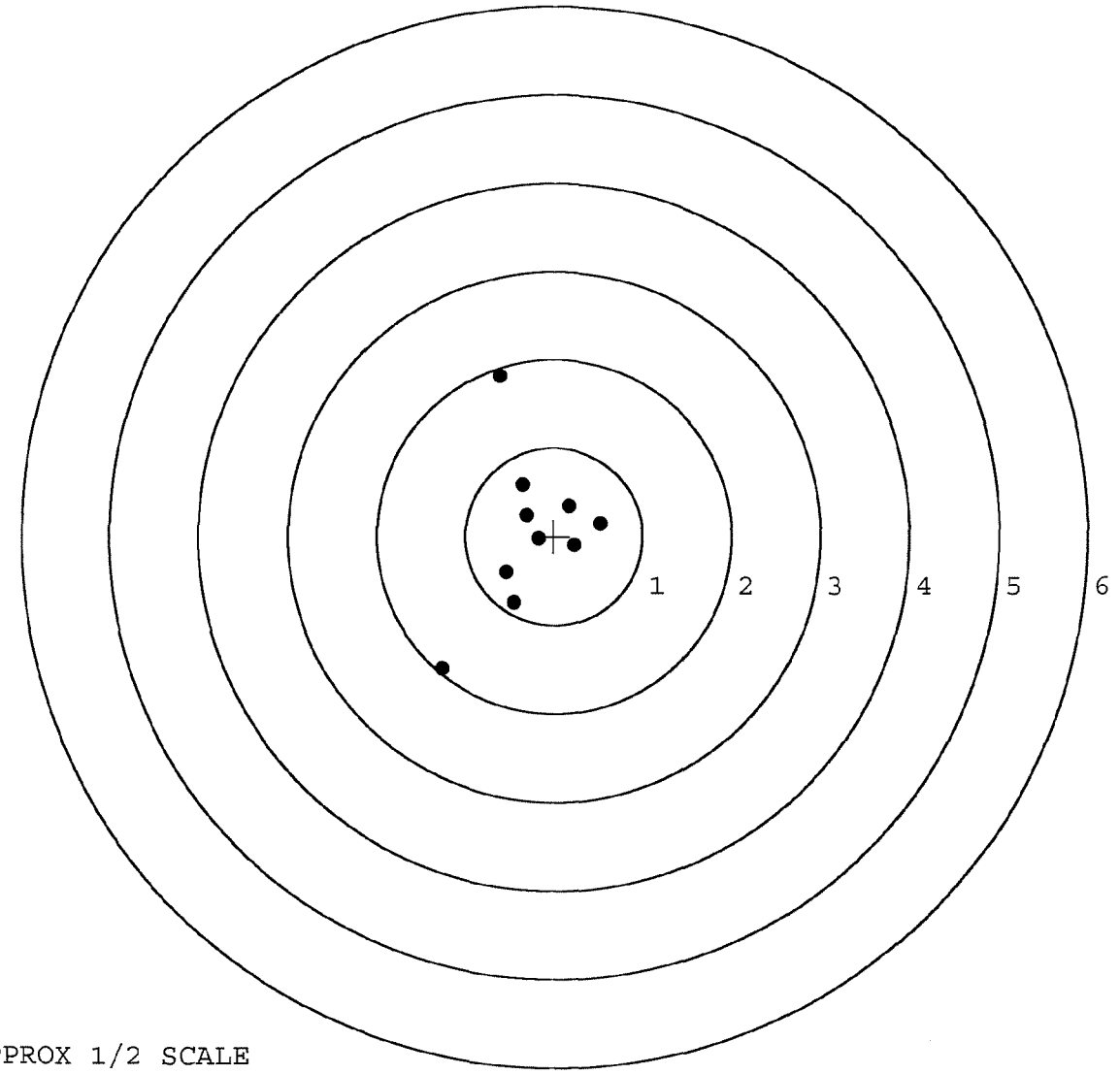
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.132
The Average Y Centroid of the Five Target Set:	-0.061
The Average Point of Impact of the Five Target Set:	0.146
The Average Mean Radius of the Five Target Set:	0.727
The Distance from POA to Centroid Target #1:	0.277
The Distance from Centroid Target #2 to Centroid Target #1:	0.399
The Distance from Centroid Target #3 to Centroid Target #1:	0.159
The Distance from Centroid Target #4 to Centroid Target #1:	0.087
The Distance from Centroid Target #5 to Centroid Target #1:	0.326

SERIAL NUMBER: C6594539.__0
TARGET NUMBER: 1
FILE DATE: 06/03/2004
FILE TIME: 09:48

X CENTROID:	-0.275
Y CENTROID:	0.032
POA TO CENTROID:	0.277
HORZ SPREAD:	1.778
VERT SPREAD:	3.310
GROUP SPREAD:	3.371
MIN RADIUS:	0.125
MAX RADIUS:	1.818
MEAN RADIUS:	0.772
# IN 1 IN DIAMETER:	2
# IN 2 IN DIAMETER:	8
# in 3 IN DIAMETER:	8

POINT#	X	Y
1:	-0.616	1.810
2:	-0.356	0.583
3:	-0.308	0.240
4:	-0.168	-0.032
5:	-0.536	-0.407
6:	-0.448	-0.759
7:	-1.254	-1.500
8:	0.240	-0.105
9:	0.169	0.343
10:	0.524	0.151

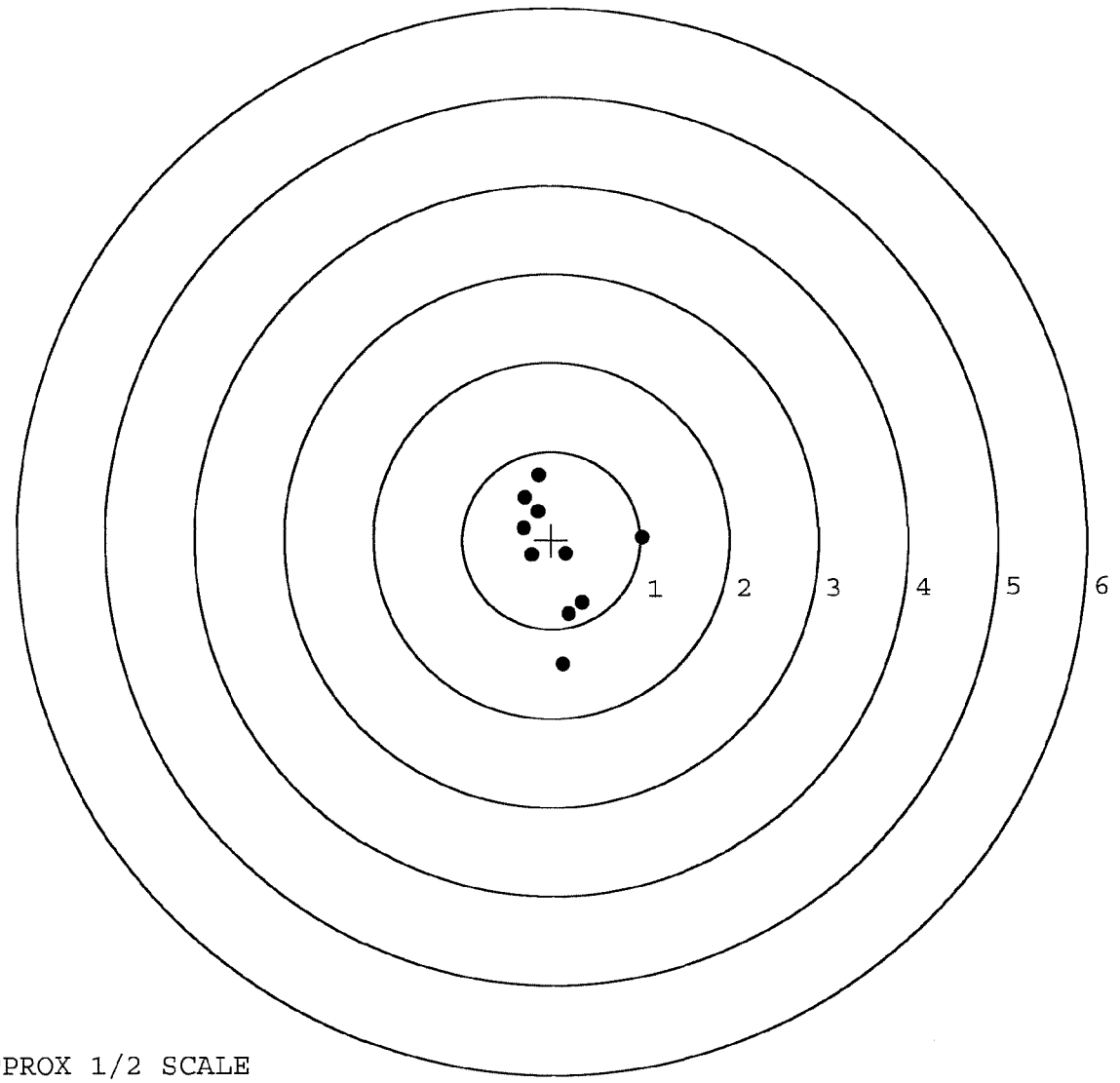


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6594539.__0
TARGET NUMBER: 2
FILE DATE: 06/03/2004
FILE TIME: 09:48

X CENTROID:	0.076
Y CENTROID:	-0.156
POA TO CENTROID:	0.174
HORZ SPREAD:	1.332
VERT SPREAD:	2.132
GROUP SPREAD:	2.149
MIN RADIUS:	0.086
MAX RADIUS:	1.240
MEAN RADIUS:	0.657
# IN 1 IN DIAMETER:	3
# IN 2 IN DIAMETER:	9
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	1.022	0.029
2:	0.162	-0.154
3:	0.350	-0.712
4:	0.200	-0.836
5:	0.133	-1.395
6:	-0.138	0.737
7:	-0.293	0.482
8:	-0.143	0.323
9:	-0.310	0.135
10:	-0.226	-0.172

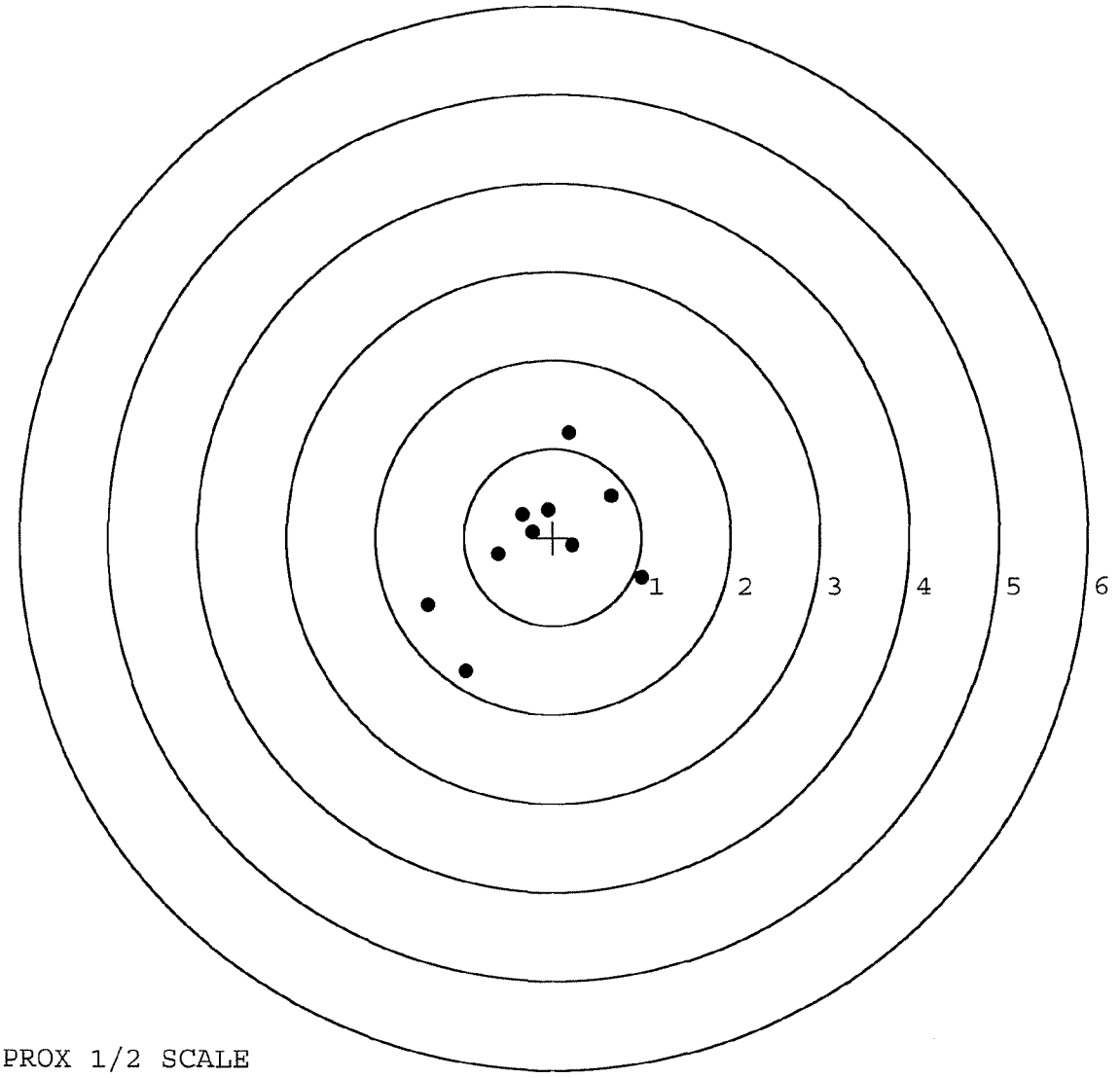


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6594539.__0
TARGET NUMBER: 3
FILE DATE: 06/03/2004
FILE TIME: 09:48

X CENTROID:	-0.159
Y CENTROID:	-0.076
POA TO CENTROID:	0.177
HORZ SPREAD:	2.415
VERT SPREAD:	2.698
GROUP SPREAD:	2.938
MIN RADIUS:	0.157
MAX RADIUS:	1.664
MEAN RADIUS:	0.839
# IN 1 IN DIAMETER:	5
# IN 2 IN DIAMETER:	6
# in 3 IN DIAMETER:	9

POINT#	X	Y
1:	0.182	1.175
2:	0.659	0.469
3:	1.003	-0.454
4:	0.221	-0.089
5:	-0.982	-1.523
6:	-1.412	-0.773
7:	-0.616	-0.198
8:	-0.350	0.258
9:	-0.066	0.312
10:	-0.233	0.063

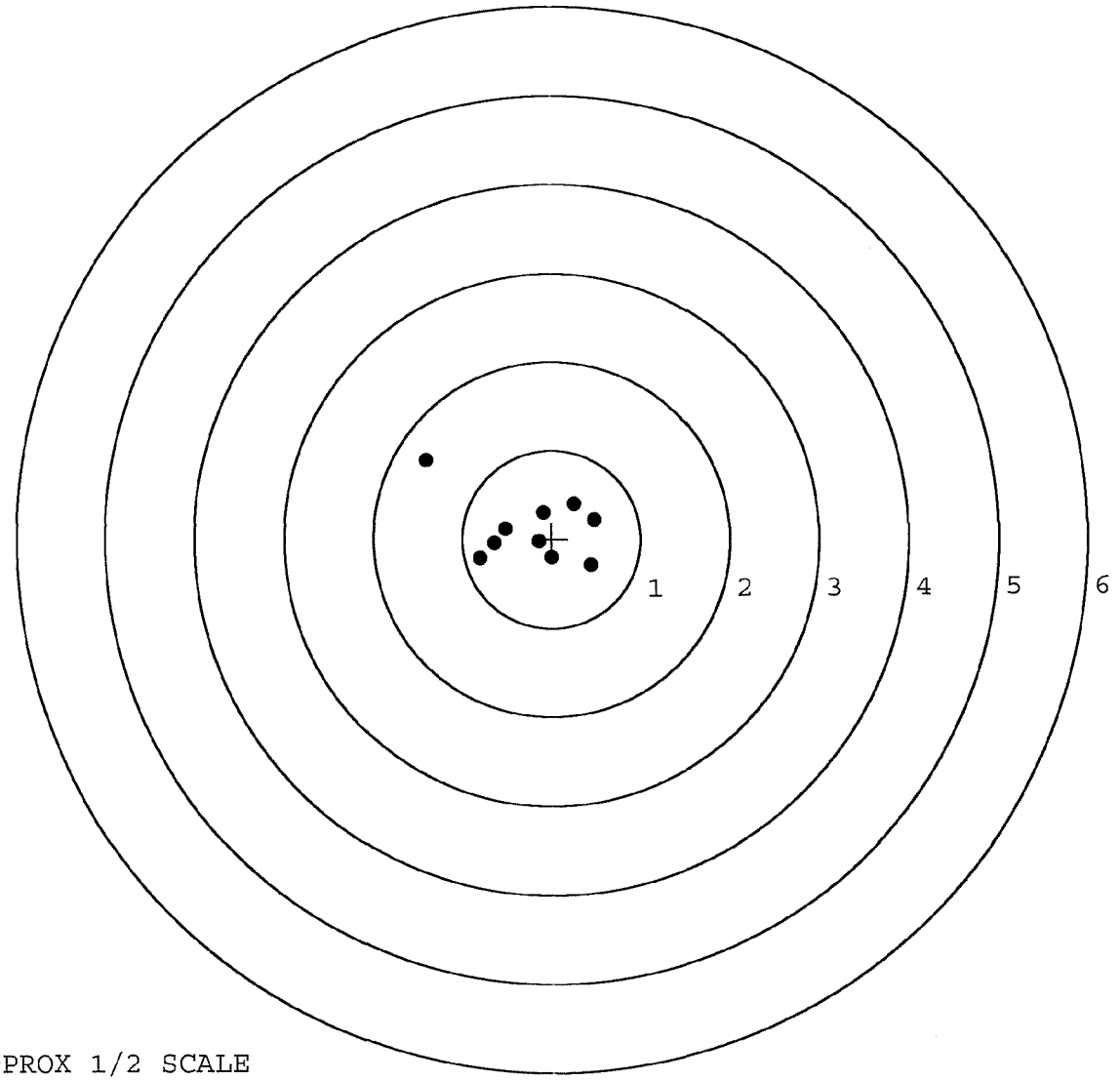


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6594539.__0
TARGET NUMBER: 4
FILE DATE: 06/03/2004
FILE TIME: 09:48

X CENTROID:	-0.240
Y CENTROID:	0.111
POA TO CENTROID:	0.264
HORZ SPREAD:	1.895
VERT SPREAD:	1.189
GROUP SPREAD:	2.197
MIN RADIUS:	0.169
MAX RADIUS:	1.401
MEAN RADIUS:	0.568
# IN 1 IN DIAMETER:	5
# IN 2 IN DIAMETER:	9
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	0.445	-0.298
2:	0.492	0.216
3:	0.002	-0.212
4:	0.264	0.394
5:	-0.092	0.294
6:	-0.142	-0.027
7:	-0.519	0.119
8:	-0.642	-0.048
9:	-0.801	-0.216
10:	-1.403	0.891

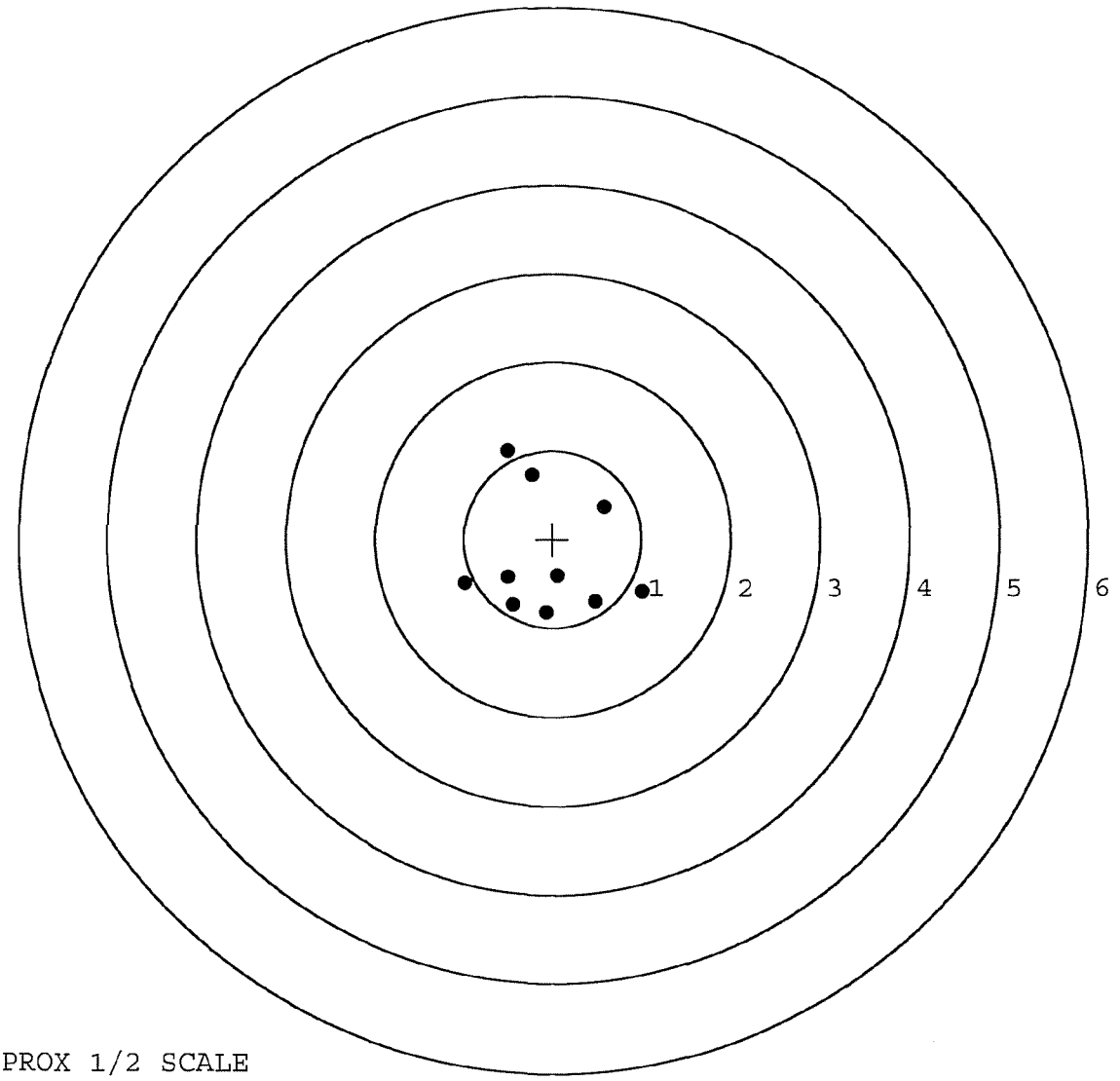


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6594539.__0
TARGET NUMBER: 5
FILE DATE: 06/03/2004
FILE TIME: 09:48

X CENTROID:	-0.063
Y CENTROID:	-0.215
POA TO CENTROID:	0.224
HORZ SPREAD:	2.003
VERT SPREAD:	1.832
GROUP SPREAD:	2.202
MIN RADIUS:	0.235
MAX RADIUS:	1.291
MEAN RADIUS:	0.798
# IN 1 IN DIAMETER:	2
# IN 2 IN DIAMETER:	8
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	-0.507	0.998
2:	-0.238	0.729
3:	0.576	0.372
4:	1.011	-0.597
5:	0.486	-0.713
6:	0.059	-0.416
7:	-0.074	-0.834
8:	-0.449	-0.747
9:	-0.504	-0.437
10:	-0.992	-0.503



TARGET APPROX 1/2 SCALE

FINAL INSPECTION CHECKLIST M-24 REPAIRS
CONTRACT #: DAAE-20-02-D-0127

SERIAL # C6594539 INSPECTED BY: RTL

DATE REC'D: 5-12-04 DATE RET'D: 6-7-04

ITEM		ITEM	
BARREL ASSEMBLY		STOCK ASSEMBLY	
✓	BARREL	✓	STOCK
✓	RECEIVER	✓	SLING AWIVEL STUDS
✓	FRONT SIGHT BASE	✓	ADJUSTABLE
✓	REAR SIGHT BASE	✓	BUTT PLATE
✓	SCREWS	✓	LOCK NUTS
✓	FINISH	✓	BARREL CLEARANCE
		✓	COLOR / FINISH
SCOPE ASSEMBLY		SYSTEMS CASE	
	SCOPE		SCOPE CASE
	SCOPE RINGS		IRON SIGHTS
	MOUNTING SCREWS		DEPLOYMENT KIT
	MOUNTING BASE		
	SCREWS		
	FINISH	TRIGGER ASSEMBLY	
	CLARITY	✓	SAFETY OPERATION
		✓	RE-SET TO FACTORY SPECS

COMMENTS:

M-24 INSPECTION CHECKLIST
CONTRACT #: DAAE-20-02-D-0127

R & E NUMBER	80846		
SERIAL NUMBER	C6594539		
LOG-IN DATE	5/12/04		
INSPECT AND VERIFY:			
OPERATION #	OPERATION NAME	DATE	INITIAL
550	DIS-ASSEMBLE GUN	5/14/04	RTC
560 A	RE-BARREL	5/14/04	RTC
B	DRILL AND TAP	5-20-04	TRW
575	ASSEMBLE	5-14-04	RTC
600	PROOF	5-18-04	AC
605	CHECK HEADSPACE	5-18-04	AC
610	DIS-ASSEMBLE GUN	5-18-04	RTC
612	MAGNAFLUX OPERATOR RL		
615	ROLLMARK CALIBER	5/28/04	RB
618	ROTO-BLAST	5/24/04	DG
620	APPLY COATINGS	6-1	TA
625 A	FINAL ASSEMBLY	6-2-04	RTC
B	TRIGGER PULL TEST		
C	SAFETY "ON" FORCE		
D	SAFETY "OFF" FORCE		
E	FIRING PIN INDENT		
640	TARGET	6-3-04	AC
655	FINAL INSPECT	6-7-04	RTC
660	PACK	6/16/04	DA
		SHIP DATE	
	QAR INSPECTION DATE		

MAGNA-FLUX INSPECTED JUN 21 2004

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6594539

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	1228	90	RW
600	Proof	1228	90	RW
607	Check Headspace	1228	90	RW
610	Dis-assemble Gun	1228	90	RW
612	Magnaflux Barrel Action		1-7-91	KR
	Magnaflux Bolt		"	KR
615	Rollmark Caliber		"	GS
617	Drill and Tap Sight Holes	1 10 91		FB
618	Polish Barrel	1 10 91		WB
620	Apply Coatings (Barrel Action)		1-18-91	TH
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		1/19/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		1/19/91	RW
	C) Inspect Ejector Hole for Chamfer		1/19/91	RW
	D) Oil Firing Pin Ass'y		1/19/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		1-22-91	DH

op. #	OP. NAME	READINGS			DATE	INIT
625 cont.	F) Safety On Force	3½	3½	3½	1/22/91	WB
	G) Safety Off Force	2	2	2	1/22/91	WB
	H) Trigger Pull Test & Retainability				1/22/91	JH
	I) Firing Pin Indent	.0225	.0215	.0215	1/22/91	WB
	J) Assemble Stock				1/24/91	RW
	K) Assemble Swivel Studs				2-4-91	AC
	L) Attach Front and Rear Sight Assemblies				1/24/91	RW
	M) Iron Sight Alignment				1/24/91	RW
	N) Detach Front & Rear Sights & place in numbered container				1/24/91	RW
	O) Attach Scope to Rifle				1/24/91	RW
	P) Detach & Attach Scope 20 Times				1/24/91	RW
640	Gallery Target & Test				1-24-91	AF
	A) Time				"	AF
	B) Malfunctions				"	AF
	C) Pierced Primers				"	AF
	D) Optical Clearity of Scope				"	AF
645	Inspect for Live Ammo				1-24-91	AF
655	Final Inspection A) Headspace				2-4-91	AC
	B) Trigger Pull	2.23	2.32 2.37	2.38 2.28	2-1-91	JH
	C) Function				2-4-91	AC
660	Pack				3-19-91	DH

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6594539
25 Jan 1991

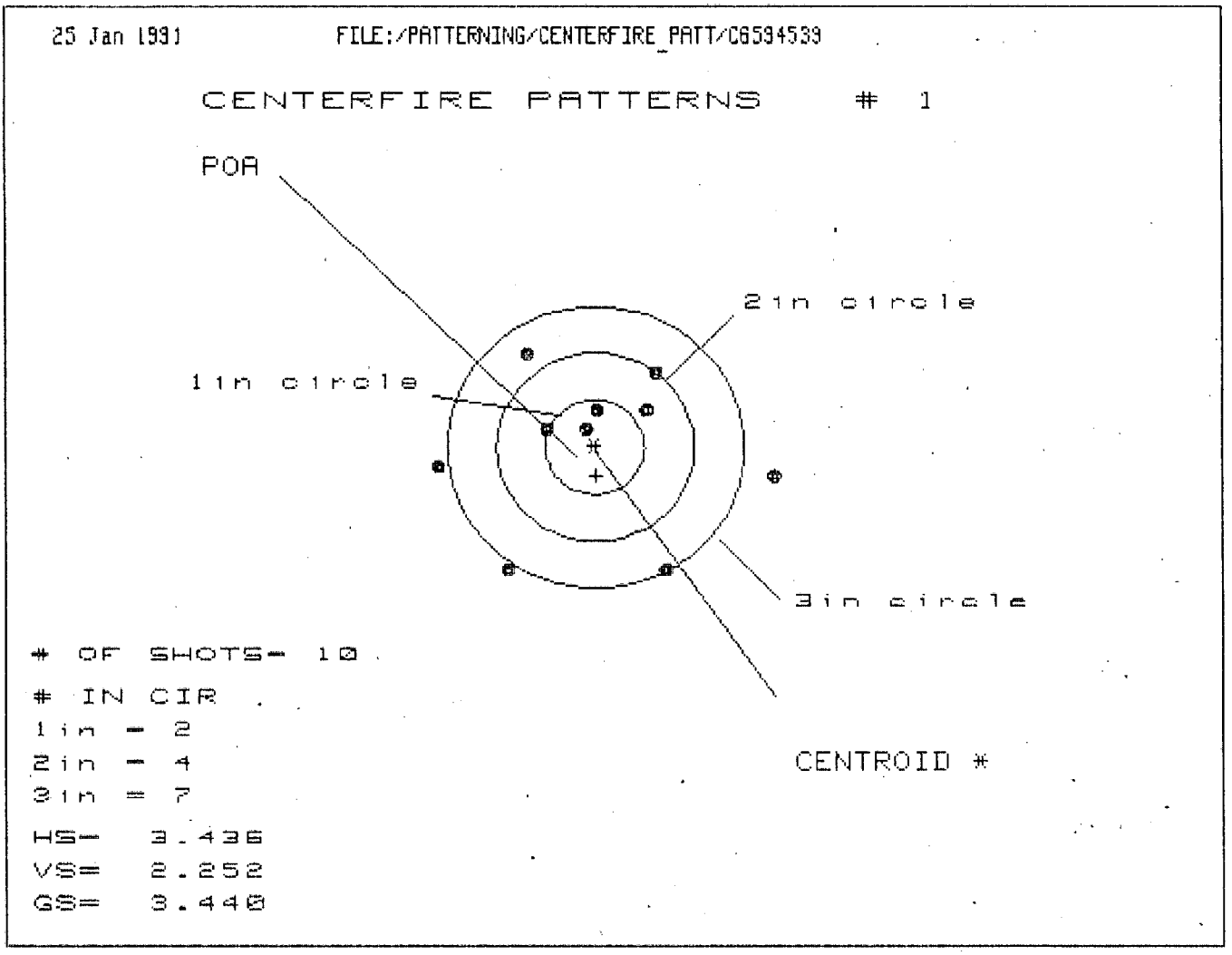
CENTROIDAL DISTANCES

0	TO	1	.30228
1	TO	2	.117324
1	TO	3	.31145
1	TO	4	.390643
1	TO	5	.385996

<----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1408
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1648
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .216757

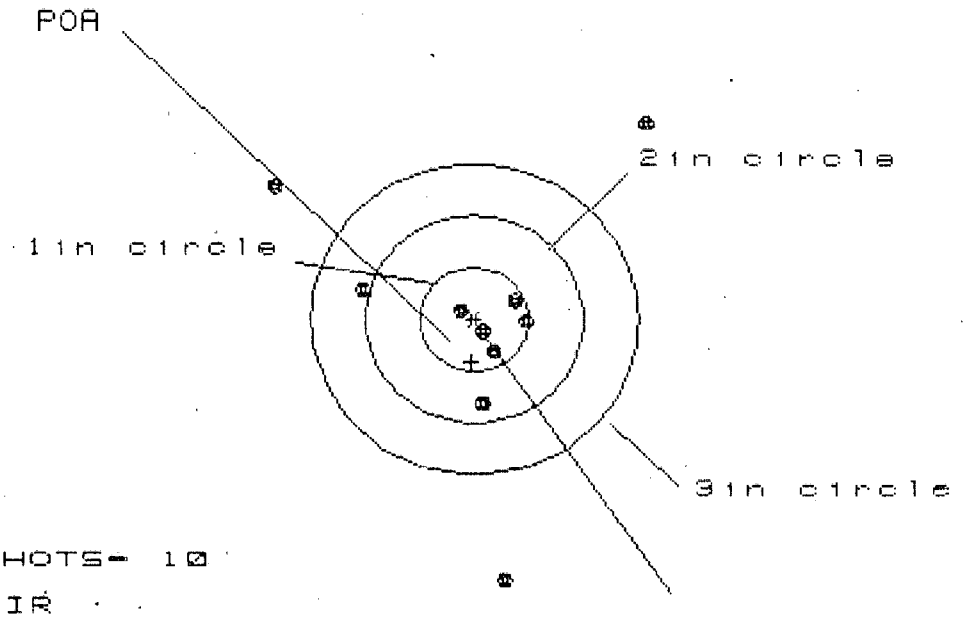
THE AMR FOR THIS RIFLE IS: 1.073



PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.849	.943	.770
MINIMUM X	:	-1.588	-1.382	-.873
MAXIMUM Y	:	.974	.937	.911
MINIMUM Y	:	-1.277	-1.315	-1.341
CENTROID X	:	-.013	-.218	-.045
CENTROID Y	:	.302	.340	.366
POA TO CENTROID in.	:	.303	.404	.369
MIN RADIUS	:	.242	.233	.172
MEAN RADIUS	:	1.054	.942	.860
MAX RADIUS	:	1.880	1.608	1.600
HORIZONTAL SPREAD	:	3.436	2.325	1.643
VERTICAL SPREAD	:	2.252	2.252	2.252
EXTREME SPREAD	:	3.440	2.647	2.647
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		7	

25 Jan 1991 FILE:/PATTERNING/CENTERFIRE_PATT/C6594539

CENTERFIRE PATTERNS # 2

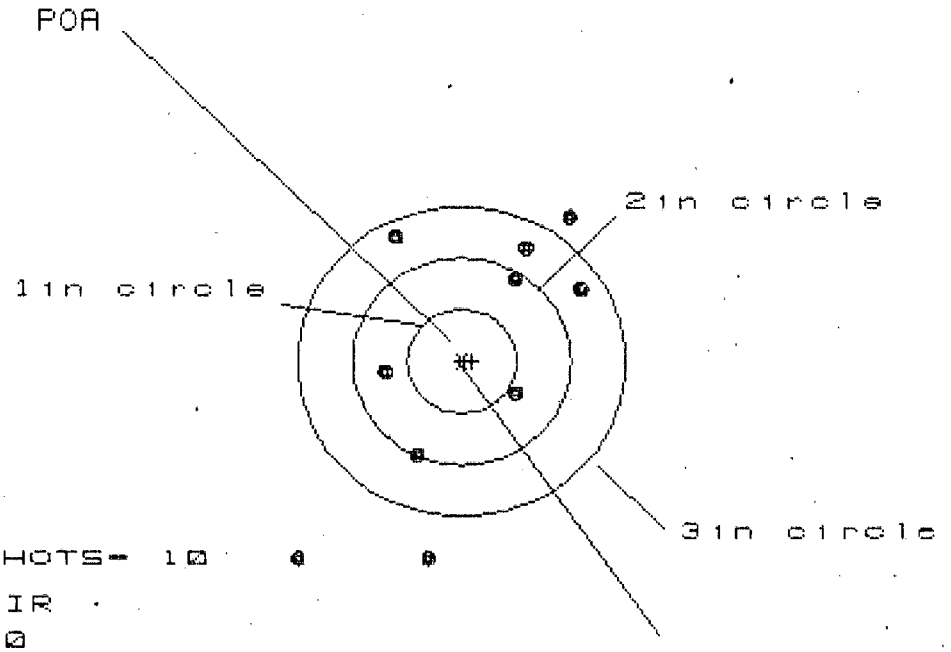


# OF SHOTS= 10
# IN CIR
1in = 5
2in = 6
3in = 7
HS= 3.411
VS= 4.432
GS= 4.634

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.623	1.653	.684
MINIMUM X	:	-1.788	-1.758	-1.552
MAXIMUM Y	:	1.909	1.629	1.203
MINIMUM Y	:	-2.523	-1.077	-.874
CENTROID X	:	.025	-.005	-.211
CENTROID Y	:	.413	.693	.490
POA TO CENTROID in.	:	.414	.693	.533
MIN RADIUS	:	.094	.234	.080
MEAN RADIUS	:	1.061	.960	.748
MAX RADIUS	:	2.537	2.320	1.964
HORIZONTAL SPREAD	:	3.411	3.411	2.236
VERTICAL SPREAD	:	4.432	2.706	2.077
EXTREME SPREAD	:	4.634	3.469	2.799
NUMBER IN ONE INCH CIRCLE	=		5	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		7	

25 Jan 1991 FILE:/PATTERNING/CENTERFIRE_PATT/C6594539

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

# IN CIR
1in = 0
2in = 4
3in = 7

HS= 2.577
VS= 3.374
GS= 4.214

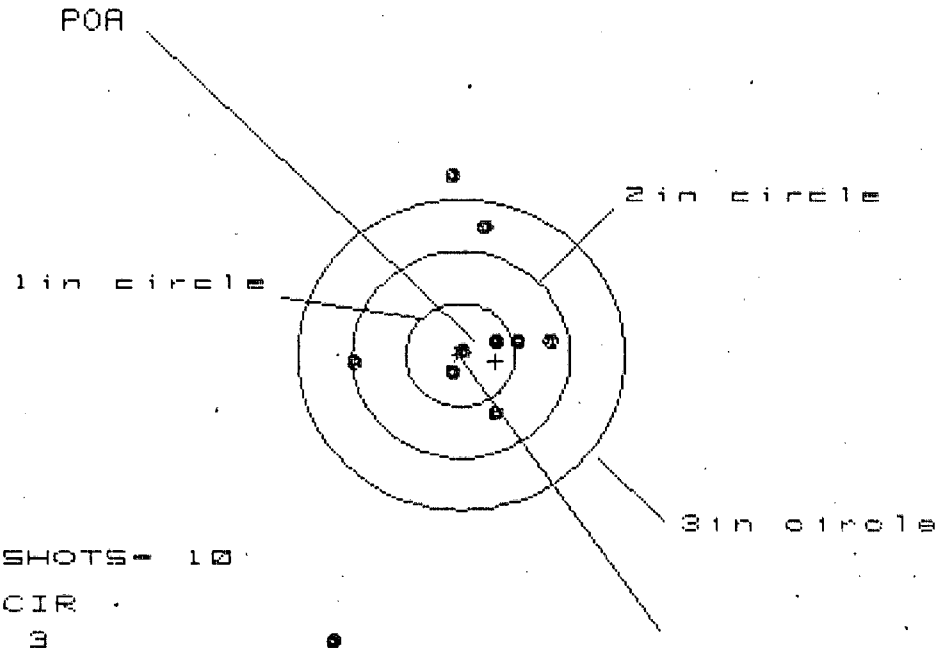
PATTERN # : 3

SHOTS (BEST OF) :	10	9	8
MAXIMUM X :	1.047	.877	.811
MINIMUM X :	-1.530	-.889	-.955
MAXIMUM Y :	1.432	1.216	.957
MINIMUM Y :	-1.942	-2.074	-1.349
CENTROID X :	-.093	.077	.143
CENTROID Y :	.001	.217	.476
POA TO CENTROID in.:	.093	.230	.497
MIN RADIUS :	.613	.654	.433
MEAN RADIUS :	1.317	1.148	.975
MAX RADIUS :	2.472	2.140	1.488
HORIZONTAL SPREAD :	2.577	1.766	1.766
VERTICAL SPREAD :	3.374	3.290	2.306
EXTREME SPREAD :	4.214	3.557	2.691

NUMBER IN ONE INCH CIRCLE = 0
NUMBER IN TWO INCH CIRCLE = 4
NUMBER IN THREE INCH CIRCLE = 7

25 Jan 1991 FILE:/PATTERNING/CENTERFIRE_PATT/C6594539

CENTERFIRE PATTERNS # 4

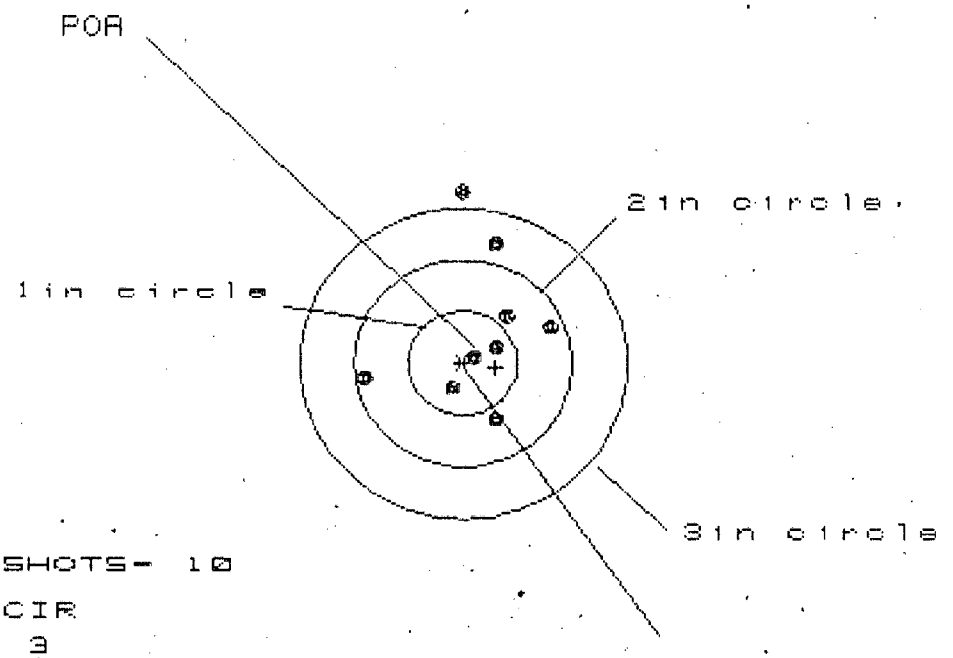


# OF SHOTS= 10
# IN CIR
1in = 3
2in = 7
3in = 8
HS= 1.982
VS= 4.558
GS= 4.695

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.820	.690	.670
MINIMUM X	:	-1.162	-1.063	-1.083
MAXIMUM Y	:	1.765	1.455	1.091
MINIMUM Y	:	-2.793	-.848	-.666
CENTROID X	:	-.322	-.192	-.172
CENTROID Y	:	.063	.373	.191
POA TO CENTROID in.	:	.328	.420	.257
MIN RADIUS	:	.079	.236	.126
MEAN RADIUS	:	.962	.727	.578
MAX RADIUS	:	3.025	1.464	1.097
HORIZONTAL SPREAD	:	1.982	1.753	1.753
VERTICAL SPREAD	:	4.558	2.303	1.757
EXTREME SPREAD	:	4.695	2.329	1.764
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		8	

25 Jan 1991 FILE:/PATTERNING/CENTERFIRE_PATT/C6594539

CENTERFIRE PATTERNS # 5



OF SHOTS= 10

# IN CIR
1in = 3
2in = 7
3in = 8

HS= 1.947
VS= 4.596
GS= 4.729

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.805	.678	.659
MINIMUM X	:	-1.142	-1.002	-1.021
MAXIMUM Y	:	1.681	1.357	1.024
MINIMUM Y	:	-2.915	-.890	-.720
CENTROID X	:	-.301	-.174	-.155
CENTROID Y	:	.045	.369	.199
POA TO CENTROID in.	:	.304	.408	.252
MIN RADIUS	:	.106	.223	.121
MEAN RADIUS	:	.972	.704	.579
MAX RADIUS	:	3.130	1.366	1.053
HORIZONTAL SPREAD	:	1.947	1.680	1.680
VERTICAL SPREAD	:	4.596	2.247	1.744
EXTREME SPREAD	:	4.729	2.267	1.757
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		8	

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS
2.50# ± .50#
3.00# ± .75#
4.00# ± 1.00#

SERIAL NO. C6594539

DATE 1-22-91

TESTER JZ

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.27	2.38	2.23	2.23	MIN. SETTING,
PULL #2	2.40	2.43	2.21	2.32	NO AVG. OF 5
PULL #3	2.40	2.40	2.24	2.37	READINGS ACCEPT-
PULL #4	2.38	2.40	2.30	2.38	ABLE LESS THAN 2#
PULL #5	2.41	2.36	2.32	2.28	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.49	3.47		
PULL #2	3.23	3.14		
PULL #3	3.31	3.26		
PULL #4	3.34	3.43		
PULL #5	3.46	3.43		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.42	4.30		4.28
PULL #2	4.29	4.24		4.33
PULL #3	4.17	4.46		4.29
PULL #4	4.35	4.42		4.32
PULL #5	4.32	4.36		4.32
TOTAL				
AVG.				

RECEIVING AND ESTIMATING REPORT

COMMENTS: W/10X SCOPE, M-24 SNIPER, W/DEPLOYMENT KIT
ATTN: FRED MARTIN Scope # S/N 91 0279

ORDER R 94-18336

INITIAL	CUSTOMER ORDER NO.
FDC	DAAA09-92-C-0834

DATE RECEIVED	DATE OPENED	DATE CODE	SERIAL NUMBER	NEW SERIAL NUMBER	MODEL AND GRADE
06/11/94	06/11/94		C6594539		700 7.62 NATO

ACCESSORIES: SLING STRAP HARD CASE SCOPE MNTS SCOPE BASE

FROM:

COMMANDER (W52H094138H226)
DEFENSE DIST DEPOT ANNISTON
ATTN DDAA-UR BLDG 112
ANNISTON AL 36201-5025

SHIP TO:

COMMANDER (W52H094138H226)
DEFENSE DIST DEPOT ANNISTON
ATTN DDAA-UR BLDG 112
ANNISTON AL
36201-5025

CUST NO: 098397 C.O.D.

ACCOUNT NUMBER	ACCOUNT NUMBER N/C	WRITE ☐	PROM. DATE	ESTIMATED	VIA
					FRT

GUN CONDITION
- ☐ NEW
- ☐ LIGHTLY WORN
- ☐ WORN
- ☐ VERY WORN
- ☐ UNREPAIRABLE
- ☐ MARRED

REPAIR CHARGE	
EXCISE	
TAX	
INSURANCE	
UPS	
PARCEL POST	
TOTAL	

CUSTOMER CONCERN	AMMO	FUNCTION	FINISH	ACCURACY	FIT	INSPECT
CYCLE	A1	B1				
TRIGGER GROUP		B2			E1	F1
BOLT ASSY.		B3			E2	F2
BARREL ASSY.		B4		D1	E3	F3
REC. ASSY.		B5		D2	E4	F4
WOOD			C1	D3	E5	F5
METAL			C2			

MAIN FAULT

PARTS

Trigger Assy	$173.31
Front Sight Assy	56.75
Rear Sight Assy	231.01
Inspect/Clean/Test	50.00
	$511.07

COMMENTS

REPAIRMAN	PROOF	CLEAN	TEST	TARGET	PATTERN
			K		
GALLERY TESTER	DATE	DATE	DATE 2/23	DATE	DATE

OFFICE COPY

RD6925 REV. 1/94

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS
2.50# ± .50#
3.00# ± .75#
4.00# ± 1.00#

SERIAL NO. C6594539
DATE 2-22-96
TESTER DA

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.74	2.73	2.76		MIN. SETTING,
PULL #2	2.75	2.78	2.79		NO AVG. OF 5
PULL #3	2.75	2.80	2.81		READINGS ACCEPT-
PULL #4	2.76	2.80	2.80		ABLE LESS THAN 2#
PULL #5	2.78	2.77	2.77		
TOTAL	1378	1388	1393		
AVG.	2.75	2.77	2.78		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.16	3.01		
PULL #2	3.07	2.97		
PULL #3	3.07	3.08		
PULL #4	3.13	3.07		
PULL #5	3.08	3.08		
TOTAL	1551	1521		
AVG.	3.10	3.04		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.23	4.03		4.39
PULL #2	4.10	4.08		4.42
PULL #3	4.13	4.07		4.44
PULL #4	4.07	4.10		4.41
PULL #5	4.11	4.04		4.42
TOTAL	2064	2032		2208
AVG.	4.12	4.06		4.41

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6594539

OP. #	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and Stock			
600	Proof			
607	Check Headspace			
610	Dis-assemble Gun			
612	Magnaflux Barrel Action			
	Magnaflux Bolt			
615	Rollmark Caliber			
617	Drill and Tap Sight Holes			
618	Polish Barrel			
620	Apply Coatings (Barrel Action)			
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly			
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head			
	C) Inspect Ejector Hole for Chamfer			
	D) Oil Firing Pin Ass'y			
	E) Adjust Trigger Pull to Min Setting and Stake			

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			3/7	[illegible]
	G) Safety Off Force	4	4	4			3/7	[illegible]
	H) Trigger Pull Test & Retainability							
	I) Firing Pin Indent							
	J) Assemble Stock							
	K) Assemble Swivel Studs							
	L) Attach Front and Rear Sight Assemblies							
	M) Iron Sight Alignment							
	N) Detach Front & Rear Sights & place in numbered container							
	O) Attach Scope to Rifle							
	P) Detach & Attach Scope 20 Times							
640	Gallery Target & Test							
	A) Time							
	B) Malfunctions							
	C) Pierced Primers							
	D) Optical Clearity of Scope							
645	Inspect for Live Ammo							
655	Final Inspection A) Headspace							
	B) Trigger Pull	2.66	2.72	2.71	2.73	2.72	3/7/96	WB
	C) Function							
660	Pack							