

C6522189

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5716**

\*Includes 1 in chamber.

*Remington*

**Arms Services Repair & Estimate System**

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

**Repair Inquiry**

Repair Number: **RE00102775** Serial: C6522189 Model: M24 SWS Center Fire Caliber: 7 NATO Repairman: Status: Closed 10/26/2005 7:45:59 AM

**Address Information**

Customer: ☒ Received From Return To: ☐ Received From

Name: **PR W7LZ CAMP SHELBY DET 57** **PR W7LZ CAMP SHELBY DET 57**

Address 1: **OEF TRAINING BDE ROTATION** **OEF TRAINING BDE ROTATION**

Address 2: **BLDG 6520 WAREHOUSE AVE** **BLDG 6520 WAREHOUSE AVE** PO Box:

City: **CAMP SHELBY** **CAMP SHELBY**

State: **MS** Zip Code: **39407** Country: **US** State: **MS** Zip Code: **39407** Country: **US**

FFL: ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐

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

**Contact Information**

Phone: **601-558-4593**

Fax:

Email:

Comments:

**Received Condition**

Condition: **Fair**

Condition Notes:

CSR Notes:

**Accessories Received**

| Code | Desc           | Qty |
|------|----------------|-----|
| A006 | Sling Strap    | 1   |
| A010 | Hard Case      | 1   |
| A016 | Scope Rings    | 2   |
| A017 | Scope Base     | 1   |
| A026 | Scope          | 1   |
| A045 | Bi Pod         | 1   |
| C000 | TORQUE WRENCH  | 1   |
| C001 | SPOTTING SCOPE | 1   |

*ADS SCOPE*

**Repair Search** **Refresh** **Close**

naqlej 10/26/2005 9:34 AM CAPS NUM INS SCPL

start 2 2 3 Arms S

Serial Number:

**C6522189**Model: **M24 SWS****RE00102775**

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6522189.\_\_\_0

FILE DATE AND TIME: 11/18/2005 15:00

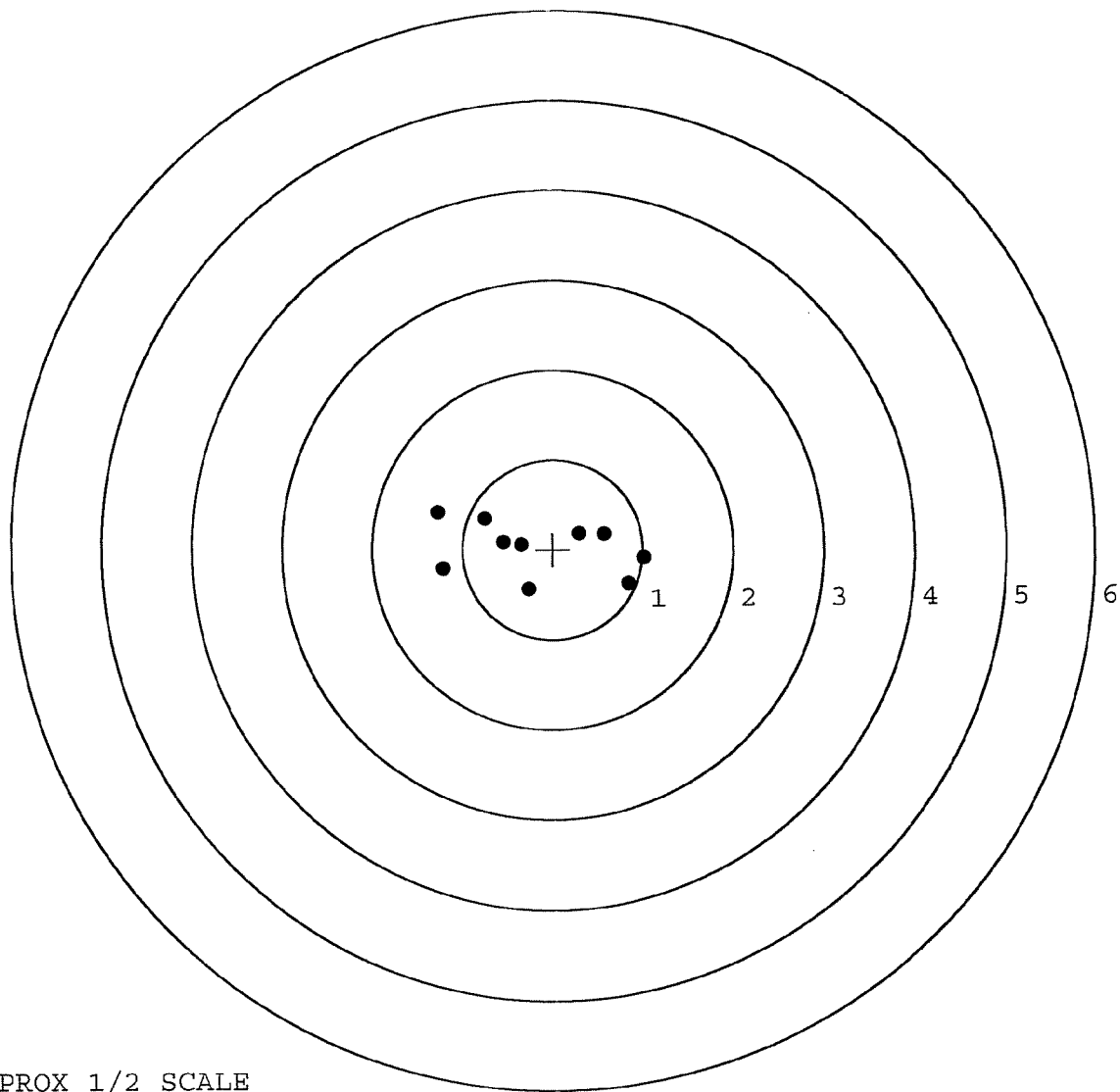
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

|                                                             |        |
|-------------------------------------------------------------|--------|
| The Average X Centroid of the Five Target Set:              | -0.097 |
| The Average Y Centroid of the Five Target Set:              | -0.052 |
| The Average Point of Impact of the Five Target Set:         | 0.110  |
| The Average Mean Radius of the Five Target Set:             | 0.642  |
| The Distance from POA to Centroid Target #1:                | 0.170  |
| The Distance from Centroid Target #2 to Centroid Target #1: | 0.069  |
| The Distance from Centroid Target #3 to Centroid Target #1: | 0.162  |
| The Distance from Centroid Target #4 to Centroid Target #1: | 0.137  |
| The Distance from Centroid Target #5 to Centroid Target #1: | 0.149  |

SERIAL NUMBER: C6522189. \_\_0  
 TARGET NUMBER: 1  
 FILE DATE: 11/18/2005  
 FILE TIME: 15:00

| POINT# | X      | Y      |
|--------|--------|--------|
| 1:     | 0.837  | -0.382 |
| 2:     | 1.012  | -0.105 |
| 3:     | 0.570  | 0.167  |
| 4:     | 0.296  | 0.174  |
| 5:     | -0.269 | -0.441 |
| 6:     | -0.348 | 0.058  |
| 7:     | -0.550 | 0.087  |
| 8:     | -0.751 | 0.353  |
| 9:     | -1.273 | 0.423  |
| 10:    | -1.216 | -0.208 |

X CENTROID: -0.169  
 Y CENTROID: 0.013  
 POA TO CENTROID: 0.170  
 HORZ SPREAD: 2.285  
 VERT SPREAD: 0.864  
 GROUP SPREAD: 2.345  
 MIN RADIUS: 0.184  
 MAX RADIUS: 1.187  
 MEAN RADIUS: 0.747  
 # IN 1 IN DIAMETER: 4  
 # IN 2 IN DIAMETER: 6  
 # in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6522189. 0

TARGET NUMBER: 2

FILE DATE: 11/18/2005

FILE TIME: 15:00

| POINT# | X      | Y      |
|--------|--------|--------|
| 1:     | 0.508  | -0.661 |
| 2:     | 0.481  | -0.022 |
| 3:     | -0.092 | -0.755 |
| 4:     | -0.436 | 1.086  |
| 5:     | -0.741 | 0.288  |
| 6:     | 0.151  | 0.403  |
| 7:     | 0.002  | 0.113  |
| 8:     | -0.102 | -0.010 |
| 9:     | -0.260 | -0.141 |
| 10:    | -0.517 | -0.269 |

X CENTROID: -0.101

Y CENTROID: 0.003

POA TO CENTROID: 0.101

HORZ SPREAD: 1.249

VERT SPREAD: 1.841

GROUP SPREAD: 1.986

MIN RADIUS: 0.013

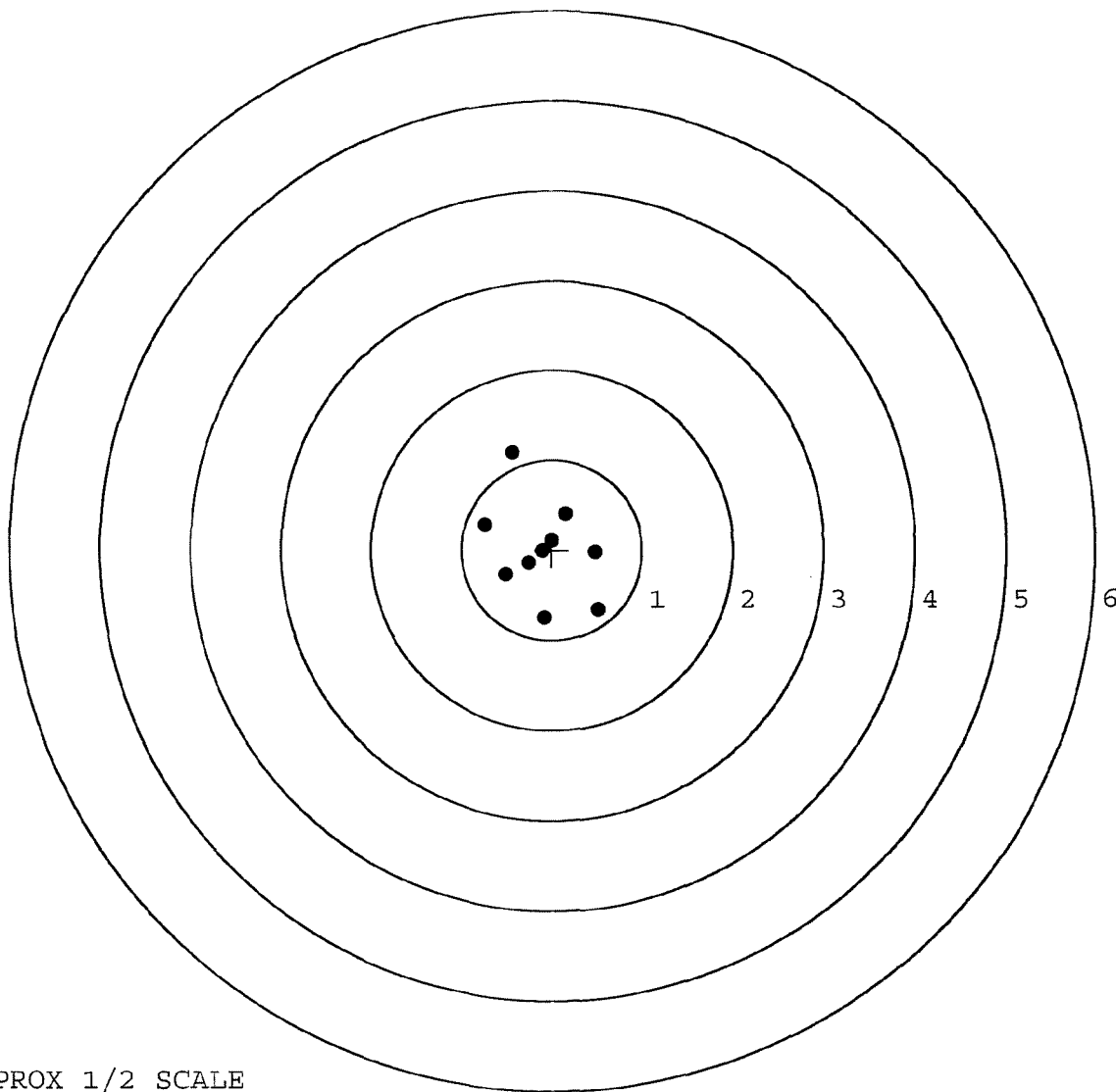
MAX RADIUS: 1.134

MEAN RADIUS: 0.542

# IN 1 IN DIAMETER: 5

# IN 2 IN DIAMETER: 9

# in 3 IN DIAMETER: 10

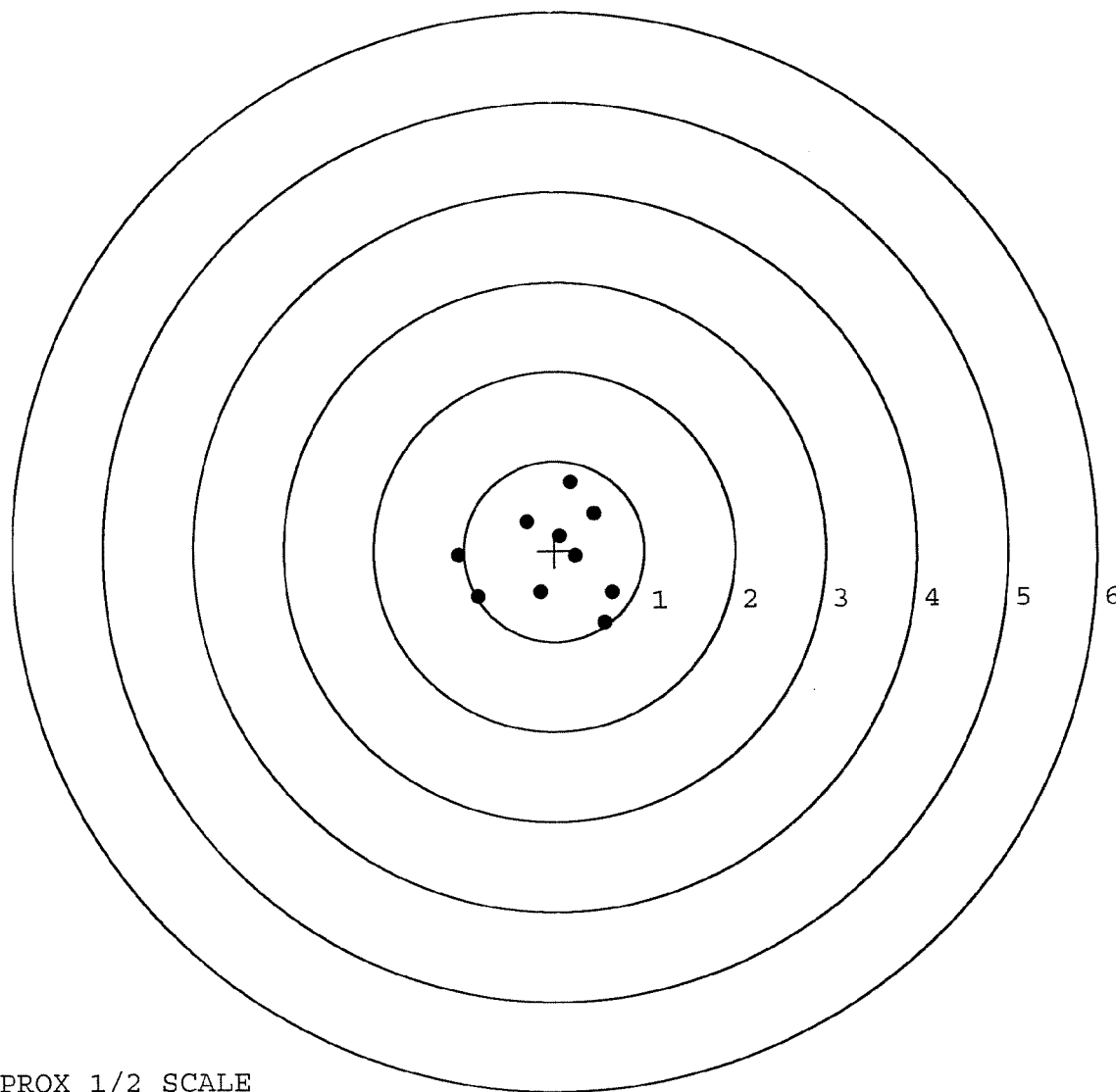


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6522189. \_\_0  
 TARGET NUMBER: 3  
 FILE DATE: 11/18/2005  
 FILE TIME: 15:00

| POINT# | X      | Y      |
|--------|--------|--------|
| 1:     | 0.549  | -0.794 |
| 2:     | 0.636  | -0.464 |
| 3:     | 0.443  | 0.412  |
| 4:     | 0.182  | 0.765  |
| 5:     | -0.302 | 0.326  |
| 6:     | 0.057  | 0.162  |
| 7:     | 0.232  | -0.060 |
| 8:     | -0.159 | -0.458 |
| 9:     | -0.852 | -0.506 |
| 10:    | -1.066 | -0.051 |

X CENTROID: -0.028  
 Y CENTROID: -0.067  
 POA TO CENTROID: 0.072  
 HORZ SPREAD: 1.702  
 VERT SPREAD: 1.559  
 GROUP SPREAD: 1.778  
 MIN RADIUS: 0.244  
 MAX RADIUS: 1.038  
 MEAN RADIUS: 0.660  
 # IN 1 IN DIAMETER: 4  
 # IN 2 IN DIAMETER: 9  
 # in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6522189. \_\_0

TARGET NUMBER: 4

FILE DATE: 11/18/2005

FILE TIME: 15:00

| POINT# | X      | Y      |
|--------|--------|--------|
| 1:     | 0.735  | 0.472  |
| 2:     | 0.542  | 0.438  |
| 3:     | 0.205  | 0.332  |
| 4:     | 0.296  | -0.232 |
| 5:     | -0.404 | 0.614  |
| 6:     | -0.140 | -0.342 |
| 7:     | -0.355 | -0.946 |
| 8:     | -0.715 | -0.679 |
| 9:     | -0.557 | -0.440 |
| 10:    | -0.851 | -0.385 |

X CENTROID: -0.124

Y CENTROID: -0.117

POA TO CENTROID: 0.171

HORZ SPREAD: 1.586

VERT SPREAD: 1.560

GROUP SPREAD: 1.851

MIN RADIUS: 0.226

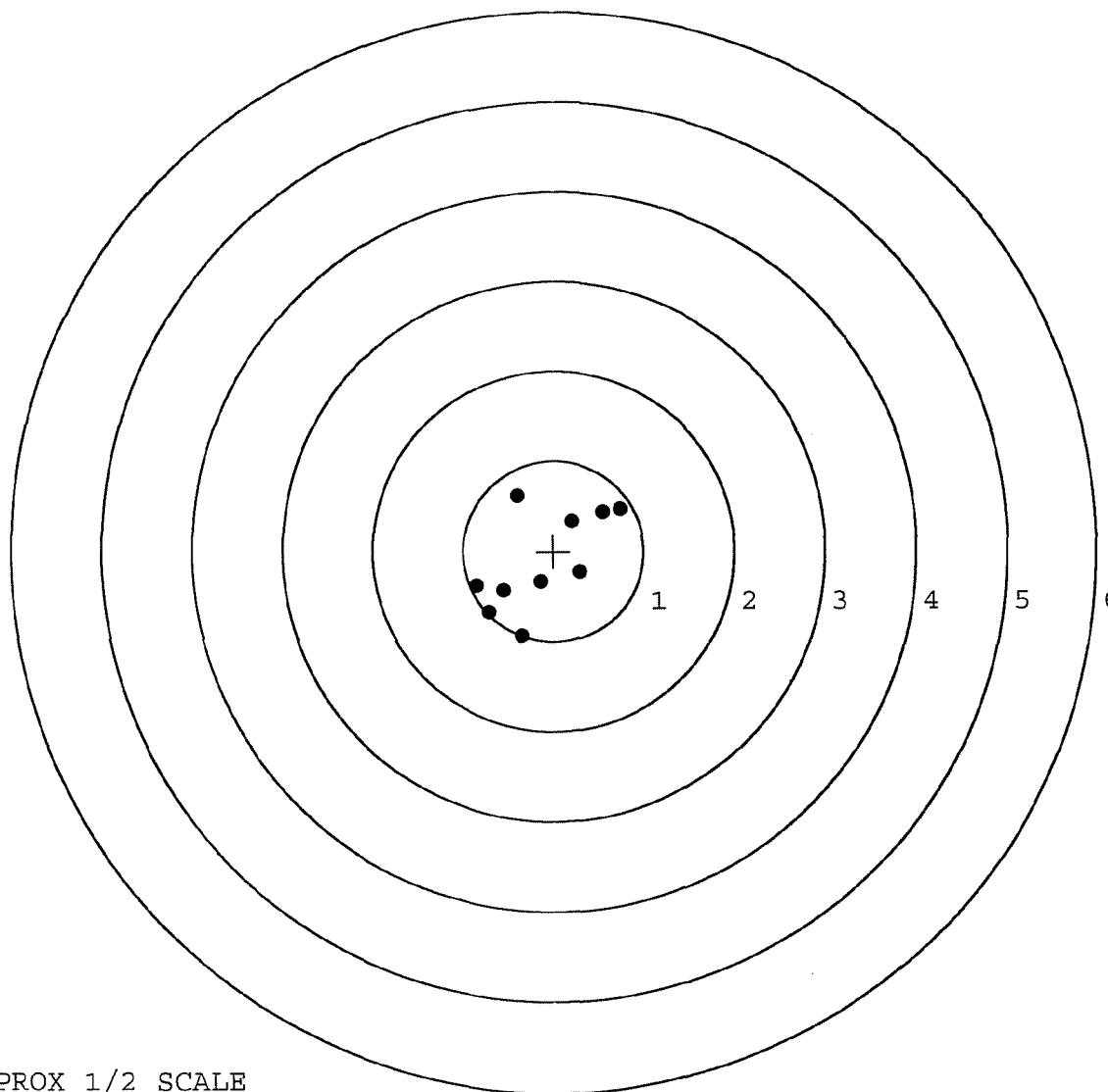
MAX RADIUS: 1.042

MEAN RADIUS: 0.690

# IN 1 IN DIAMETER: 2

# IN 2 IN DIAMETER: 9

# in 3 IN DIAMETER: 10

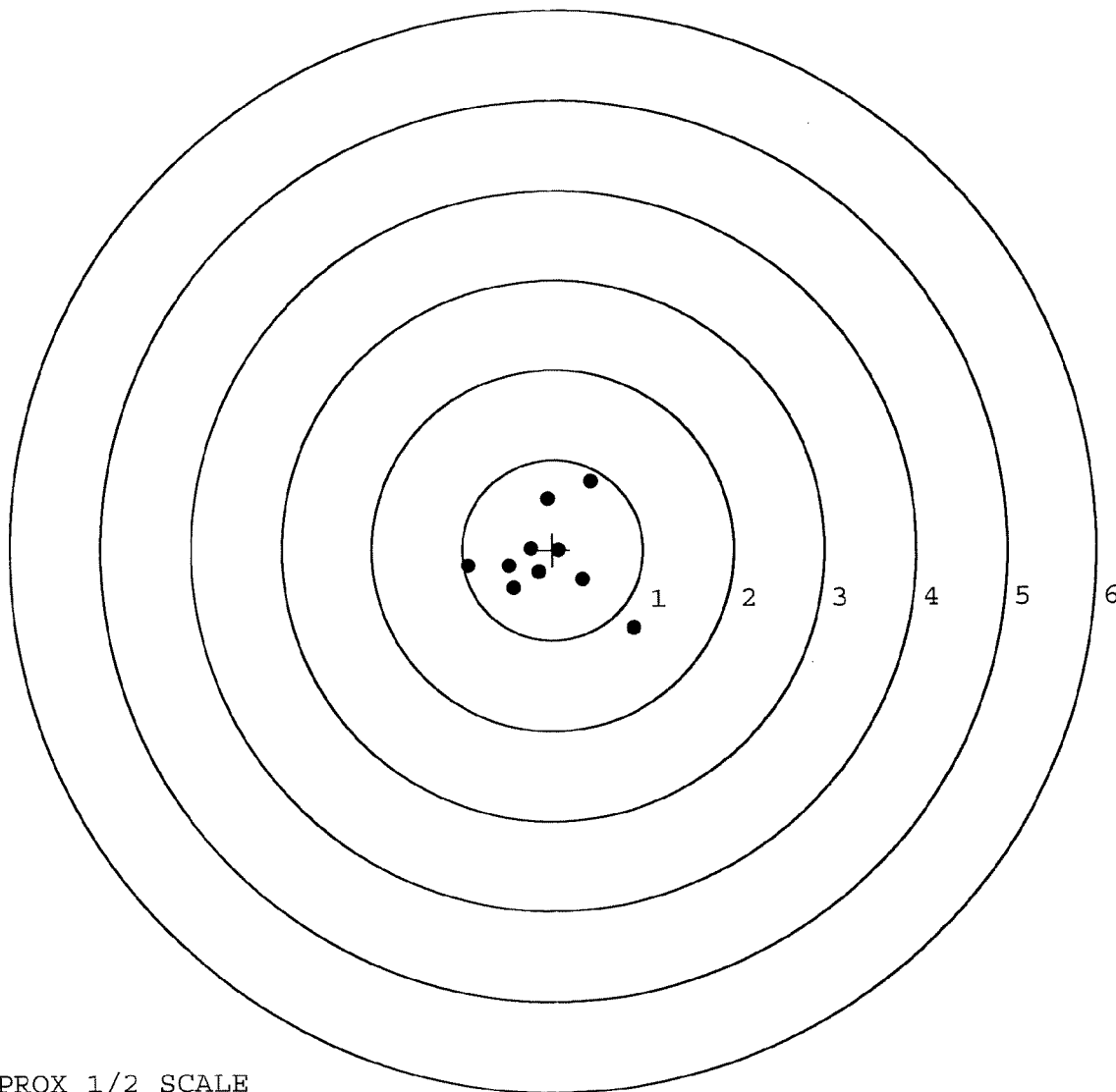


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6522189. 0  
 TARGET NUMBER: 5  
 FILE DATE: 11/18/2005  
 FILE TIME: 15:00

| POINT# | X      | Y      |
|--------|--------|--------|
| 1:     | 0.888  | -0.880 |
| 2:     | 0.327  | -0.340 |
| 3:     | 0.422  | 0.755  |
| 4:     | -0.054 | 0.573  |
| 5:     | -0.937 | -0.174 |
| 6:     | -0.491 | -0.177 |
| 7:     | -0.438 | -0.426 |
| 8:     | -0.157 | -0.249 |
| 9:     | 0.061  | -0.013 |
| 10:    | -0.241 | 0.019  |

X CENTROID: -0.062  
 Y CENTROID: -0.091  
 POA TO CENTROID: 0.110  
 HORZ SPREAD: 1.825  
 VERT SPREAD: 1.635  
 GROUP SPREAD: 1.957  
 MIN RADIUS: 0.146  
 MAX RADIUS: 1.235  
 MEAN RADIUS: 0.570  
 # IN 1 IN DIAMETER: 5  
 # IN 2 IN DIAMETER: 9  
 # in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

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

|                     |                         |                     |         |
|---------------------|-------------------------|---------------------|---------|
| R & E NUMBER        | 102775                  |                     |         |
| SERIAL NUMBER       | CAMP SHELBY<br>C6522189 |                     |         |
| LOG-IN DATE         | 10-26-05                |                     |         |
| INSPECT AND VERIFY: |                         |                     |         |
| OPERATION #         | OPERATION NAME          | DATE                | INITIAL |
| 550                 | DIS-ASSEMBLE GUN        | 11-2-05             | AC      |
| 560 A               | RE-BARREL               | 11-9-05             | AC      |
| B                   | DRILL AND TAP           | 11-11-05            | BR      |
| 575                 | ASSEMBLE                | 11-14-05            | CD      |
| 600                 | PROOF MAGNA-FLUX        | 11-14-05            | CD      |
| 605                 | CHECK HEADSPACE         | 11-14-05            | CD      |
| 610                 | DIS-ASSEMBLE GUN        | 11-14-05            | CD      |
| 612                 | MAGNAFLUX OPERATOR      | 11-15-05            | WJ      |
| 615                 | ROLLMARK CALIBER        | 11-15-05            | CW      |
| 618                 | ROTO-BLAST              | 11-16-05            | WB      |
| 620                 | APPLY COATINGS          | 11-16-05            | HP      |
| 625 A               | FINAL ASSEMBLY          | 11-17-05            | BG      |
| B                   | TRIGGER PULL TEST       |                     |         |
| C                   | SAFETY "ON" FORCE       | 11-22-05            | AC      |
| D                   | SAFETY "OFF" FORCE      | 11-22-05            | AC      |
| E                   | FIRING PIN INDENT       | 11-22-05            | AC      |
| 640                 | TARGET                  | 11-18-05            | TRW     |
| 655                 | FINAL INSPECT           | 11-22-05            | AC      |
| 660                 | PACK                    | 12-2-05             | DA      |
|                     |                         | SHIP DATE           |         |
|                     |                         | QAR INSPECTION DATE |         |

**Remington**  
MODEL 700™ H24

**UPONT**  
REG. U.S. PAT. & TM. OFF.

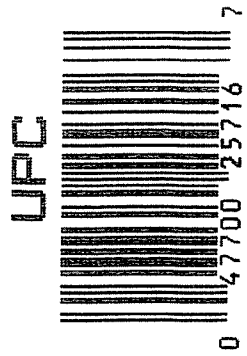
VERY IMPORTANT:  
Instruction Book  
enclosed to assure  
safe use of this  
firearm.

SERIAL NO.  
C6522189

ORDER NO.  
5716

MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.

Ø1



CENTROIDAL DISTANCE CALCULATIONS  
FOR RIFLE # C6522189  
25 Aug 1990

CENTROIDAL DISTANCES

|      |   |          |
|------|---|----------|
| Ø TO | 1 | .0596154 |
| 1 TO | 2 | .324607  |
| 1 TO | 3 | .374086  |
| 1 TO | 4 | .341     |
| 1 TO | 5 | .338895  |

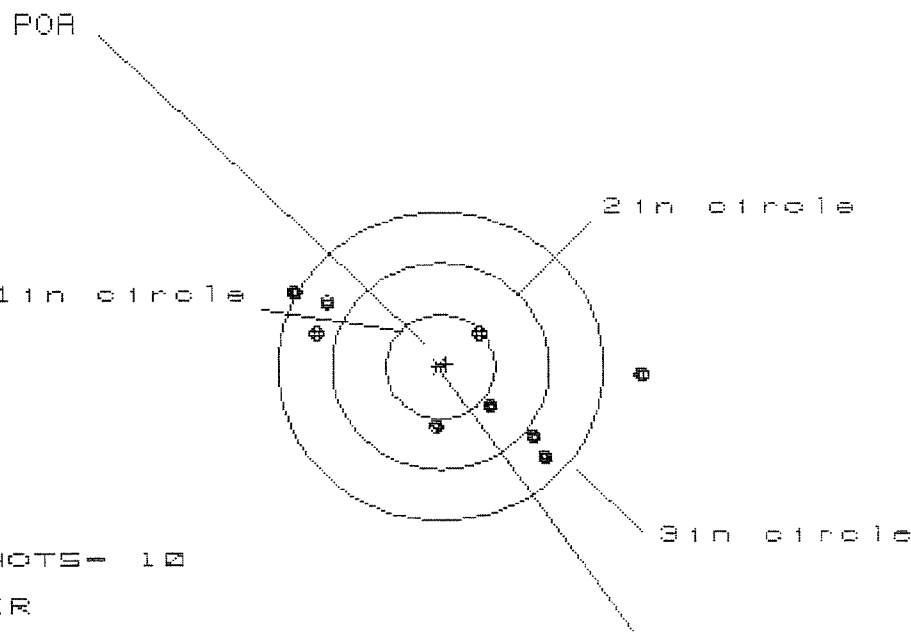
$\bar{x}$   $\bar{y}$  <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.2052  
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0466  
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .210425  
THE AMR FOR THIS RIFLE IS: .9572

25 Aug 1998

FILE:/PATTERNING/CENTERFIRE\_PATT/06522189

## CENTERFIRE PATTERNS # 1



# OF SHOTS- 10

# IN CIR

1 in = 0

2 in = 3

3 in = 8

HS= 3.182

VS= 1.573

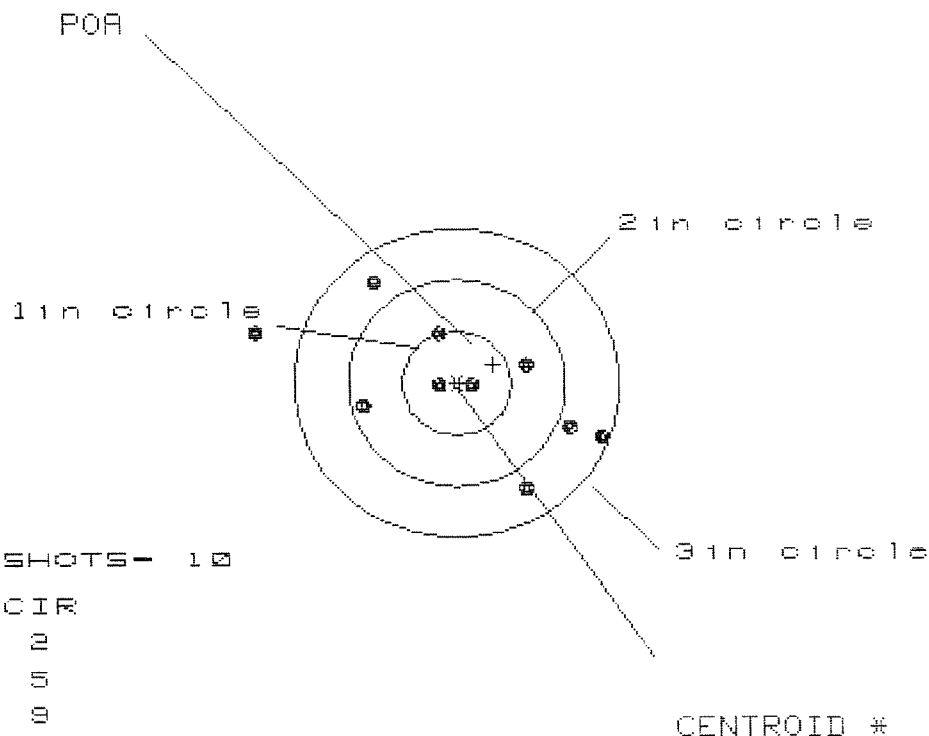
GS= 3.281

| PATTERN #                     | 1      | 2      | 3      |
|-------------------------------|--------|--------|--------|
| SHOTS (BEST OF)               | 10     | 9      | 8      |
| MAXIMUM X                     | 1.851  | 1.208  | 1.068  |
| MINIMUM X                     | -1.331 | -1.126 | -1.051 |
| MAXIMUM Y                     | .694   | .682   | .689   |
| MINIMUM Y                     | -.879  | -.891  | -.806  |
| CENTROID X                    | -.055  | -.260  | -.120  |
| CENTROID Y                    | -.023  | -.011  | -.096  |
| POA TO CENTROID in.           | .059   | .261   | .154   |
| MIN RADIUS                    | .506   | .623   | .513   |
| MEAN RADIUS                   | 1.103  | 1.015  | .957   |
| MAX RADIUS                    | 1.854  | 1.501  | 1.338  |
| HORIZONTAL SPREAD             | 3.182  | 2.334  | 2.119  |
| VERTICAL SPREAD               | 1.573  | 1.573  | 1.495  |
| EXTREME SPREAD                | 3.281  | 2.815  | 2.510  |
| NUMBER IN ONE INCH CIRCLE =   | 0      |        |        |
| NUMBER IN TWO INCH CIRCLE =   | 3      |        |        |
| NUMBER IN THREE INCH CIRCLE = | 8      |        |        |

25 Aug 1998

FILE:/PATTERNING/CENTERFIRE\_PATT/C6522189

## CENTERFIRE PATTERNS # 2



# OF SHOTS- 10

# IN CIR

1 in = 2

2 in = 5

3 in = 9

HS= 3.278

VS= 1.977

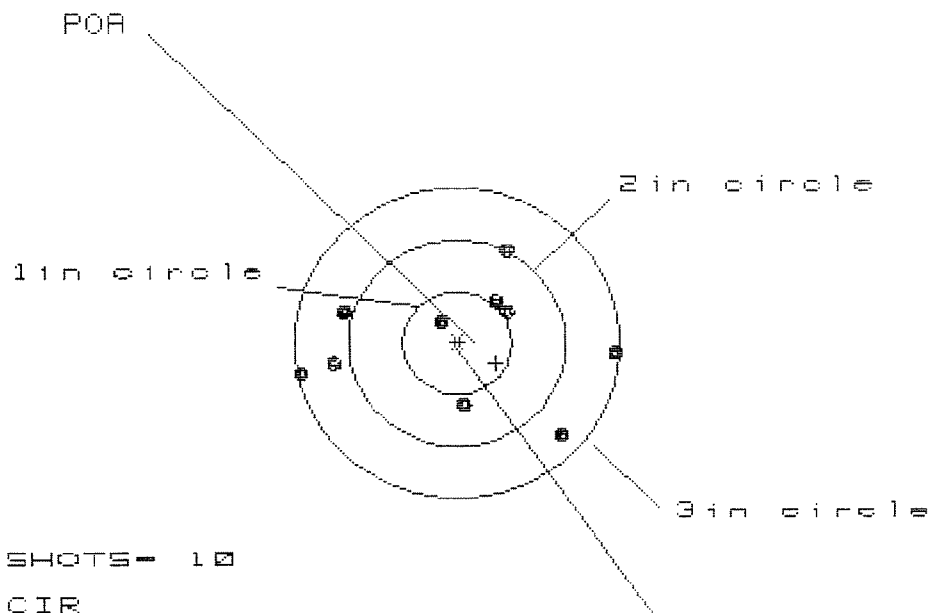
GS= 3.421

| PATTERN #                   | : | 2      |        |       |
|-----------------------------|---|--------|--------|-------|
| SHOTS (BEST OF)             | : | 10     | 9      | 8     |
| MAXIMUM X                   | : | 1.368  | 1.155  | .991  |
| MINIMUM X                   | : | -1.911 | -1.109 | -.964 |
| MAXIMUM Y                   | : | .993   | 1.043  | .984  |
| MINIMUM Y                   | : | -.984  | -.934  | -.993 |
| CENTROID X                  | : | -.338  | -.125  | -.270 |
| CENTROID Y                  | : | -.182  | -.232  | -.172 |
| POA TO CENTROID in.         | : | .384   | .264   | .320  |
| MIN RADIUS                  | : | .122   | .098   | .077  |
| MEAN RADIUS                 | : | .942   | .822   | .745  |
| MAX RADIUS                  | : | 1.963  | 1.446  | 1.304 |
| HORIZONTAL SPREAD           | : | 3.278  | 2.264  | 1.955 |
| VERTICAL SPREAD             | : | 1.977  | 1.977  | 1.977 |
| EXTREME SPREAD              | : | 3.421  | 2.639  | 2.438 |
| NUMBER IN ONE INCH CIRCLE   | = |        | 2      |       |
| NUMBER IN TWO INCH CIRCLE   | = |        | 5      |       |
| NUMBER IN THREE INCH CIRCLE | = |        | 9      |       |

25 Aug 1990

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## CENTERFIRE PATTERNS # 3



# OF SHOTS- 10

# IN CIR

1in = 1

2in = 5

3in = 10

HS= 2.863

VS= 1.792

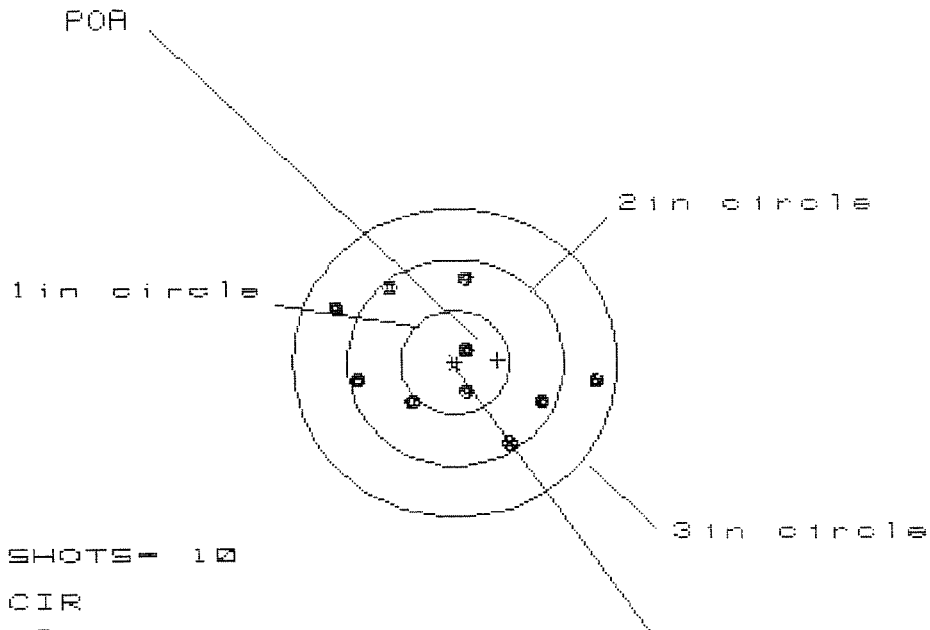
GS= 2.867

| PATTERN #                   | : | 3      |        |        |
|-----------------------------|---|--------|--------|--------|
| SHOTS (BEST OF)             | : | 10     | 9      | 8      |
| MAXIMUM X                   | : | 1.413  | 1.252  | .909   |
| MINIMUM X                   | : | -1.450 | -1.274 | -1.118 |
| MAXIMUM Y                   | : | .863   | .834   | .815   |
| MINIMUM Y                   | : | -.929  | -.958  | -.977  |
| CENTROID X                  | : | -.359  | -.198  | -.354  |
| CENTROID Y                  | : | .195   | .224   | .243   |
| POA TO CENTROID in.         | : | .408   | .299   | .429   |
| MIN RADIUS                  | : | .292   | .385   | .256   |
| MEAN RADIUS                 | : | .938   | .859   | .803   |
| MAX RADIUS                  | : | 1.474  | 1.303  | 1.334  |
| HORIZONTAL SPREAD           | : | 2.863  | 2.526  | 2.027  |
| VERTICAL SPREAD             | : | 1.792  | 1.792  | 1.792  |
| EXTREME SPREAD              | : | 2.867  | 2.529  | 2.314  |
| NUMBER IN ONE INCH CIRCLE   | = |        | 1      |        |
| NUMBER IN TWO INCH CIRCLE   | = |        | 5      |        |
| NUMBER IN THREE INCH CIRCLE | = |        | 10     |        |

25 Aug 1998

FILE:/PATTERNING/CENTERFIRE\_PATT/C6522183

## CENTERFIRE PATTERNS # 4



# OF SHOTS = 10

# IN CIR

1 in = 2

2 in = 8

3 in = 10

HS = 2.422

VS = 1.552

GS = 2.496

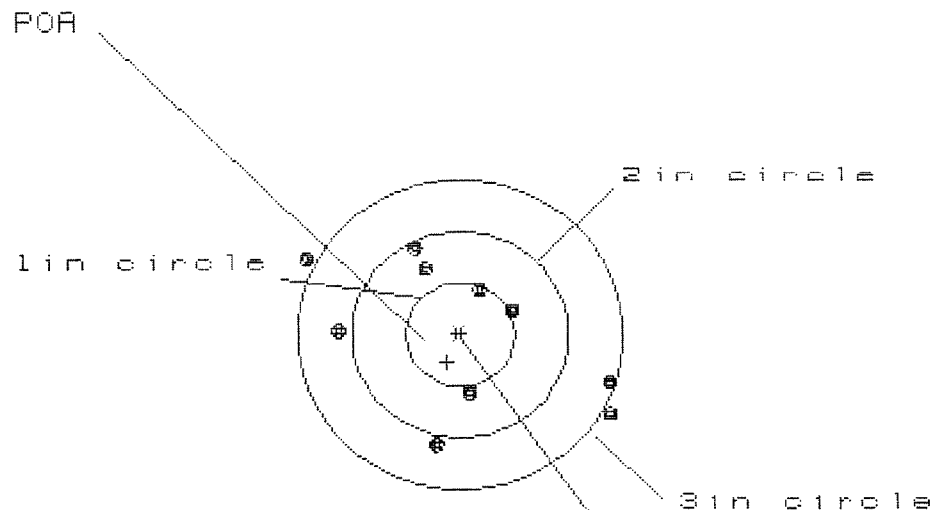
CENTROID #

| PATTERN #                   | : | 4      |       |       |
|-----------------------------|---|--------|-------|-------|
| SHOTS (BEST OF)             | : | 10     | 9     | 8     |
| MAXIMUM X                   | : | 1.281  | .963  | .838  |
| MINIMUM X                   | : | -1.141 | -.998 | -.896 |
| MAXIMUM Y                   | : | .791   | .777  | .835  |
| MINIMUM Y                   | : | -.761  | -.775 | -.717 |
| CENTROID X                  | : | -.396  | -.539 | -.414 |
| CENTROID Y                  | : | -.023  | -.009 | -.067 |
| POA TO CENTROID in.         | : | .397   | .539  | .419  |
| MIN RADIUS                  | : | .168   | .287  | .211  |
| MEAN RADIUS                 | : | .806   | .756  | .691  |
| MAX RADIUS                  | : | 1.288  | 1.101 | .952  |
| HORIZONTAL SPREAD           | : | 2.422  | 1.961 | 1.734 |
| VERTICAL SPREAD             | : | 1.552  | 1.552 | 1.552 |
| EXTREME SPREAD              | : | 2.496  | 2.131 | 1.844 |
| NUMBER IN ONE INCH CIRCLE   | = |        | 2     |       |
| NUMBER IN TWO INCH CIRCLE   | = |        | 8     |       |
| NUMBER IN THREE INCH CIRCLE | = |        | 10    |       |

25 Aug 1990

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## CENTERFIRE PATTERNS # 5



# OF SHOTS- 10

# IN CIR

1 in = 1

2 in = 5

3 in = 8

HS= 2.846

VS= 1.879

GS= 3.202

CENTROID #

| PATTERN #                   | : | 5      |        |        |
|-----------------------------|---|--------|--------|--------|
| SHOTS (BEST OF)             | : | 10     | 9      | 8      |
| MAXIMUM X                   | : | 1.401  | 1.240  | 1.387  |
| MINIMUM X                   | : | -1.445 | -1.239 | -1.092 |
| MAXIMUM Y                   | : | .804   | .890   | .800   |
| MINIMUM Y                   | : | -1.075 | -.989  | -1.079 |
| CENTROID X                  | : | .122   | .283   | .136   |
| CENTROID Y                  | : | .266   | .180   | .270   |
| POA TO CENTROID in.         | : | .292   | .335   | .302   |
| MIN RADIUS                  | : | .467   | .408   | .458   |
| MEAN RADIUS                 | : | .997   | .920   | .845   |
| MAX RADIUS                  | : | 1.639  | 1.383  | 1.466  |
| HORIZONTAL SPREAD           | : | 2.846  | 2.479  | 2.479  |
| VERTICAL SPREAD             | : | 1.879  | 1.879  | 1.879  |
| EXTREME SPREAD              | : | 3.202  | 2.573  | 2.537  |
| NUMBER IN ONE INCH CIRCLE   | = |        | 1      |        |
| NUMBER IN TWO INCH CIRCLE   | = |        | 5      |        |
| NUMBER IN THREE INCH CIRCLE | = |        | 8      |        |

AVERAGE PULL FORCE BETWEEN  
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6522189

DATE 8/24/90

TESTER JLL

|         | 2.50#<br>INITIAL | 2.50# AFTER<br>50 CYCLES | FINAL TEST &<br>TO RESET 2.50# |       | COMMENTS                                                               |
|---------|------------------|--------------------------|--------------------------------|-------|------------------------------------------------------------------------|
| PULL #1 | 2.37             | 2.30                     | 2.36                           | 2.53  | MIN. SETTING,<br>NO AVG. OF 5<br>READINGS ACCEPT-<br>ABLE LESS THAN 2# |
| PULL #2 | 2.36             | 2.39                     | 2.40                           | 2.48  |                                                                        |
| PULL #3 | 2.36             | 2.39                     | 2.44                           | 2.52  |                                                                        |
| PULL #4 | 2.35             | 2.44                     | 2.38                           | 2.46  |                                                                        |
| PULL #5 | 2.36             | 2.48                     | 2.40                           | 2.41  |                                                                        |
| TOTAL   | 11.80            | 12.00                    | 11.98                          | 12.40 |                                                                        |
| AVG.    | 2.36             | 2.4                      | 2.396                          | 2.48  |                                                                        |

|         | 3.00#<br>INITIAL | 3.00# AFTER<br>20 CYCLES |  | COMMENTS |
|---------|------------------|--------------------------|--|----------|
| PULL #1 | 3.13             | 3.19                     |  |          |
| PULL #2 | 3.27             | 3.25                     |  |          |
| PULL #3 | 3.25             | 3.12                     |  |          |
| PULL #4 | 3.10             | 3.30                     |  |          |
| PULL #5 | 3.21             | 3.27                     |  |          |
| TOTAL   | 15.96            | 16.13                    |  |          |
| AVG.    | 3.192            | 3.226                    |  |          |

|         | 4.00#<br>INITIAL | 4.00# AFTER<br>20 CYCLES | MAX SETTING<br>GREATER THAN 4# | RESET TO 4# FOR<br>TARGET & ACCURACY |
|---------|------------------|--------------------------|--------------------------------|--------------------------------------|
| PULL #1 | 4.41             | 4.38                     |                                | 4.38                                 |
| PULL #2 | 4.36             | 4.43                     |                                | 4.39                                 |
| PULL #3 | 4.33             | 4.37                     |                                | 4.40                                 |
| PULL #4 | 4.36             | 4.43                     |                                | 4.39                                 |
| PULL #5 | 4.40             | 4.39                     |                                | 4.43                                 |
| TOTAL   | 21.86            | 22.00                    |                                | 21.99                                |
| AVG.    | 4.372            | 4.4                      |                                | 4.398                                |

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C 6522189

| OP. #     | OP. NAME                                                 | READINGS | DATE    | INIT |
|-----------|----------------------------------------------------------|----------|---------|------|
| 575 & 580 | Assemble Action and Stock                                |          | 8/1/90  | KS   |
| 600       | Proof                                                    |          | 8/1/90  | KS   |
| 607       | Check Headspace                                          |          | 8/1/90  | KS   |
| 610       | Dis-assemble Gun                                         |          | 8/1/90  | KS   |
| 612       | Magnaflux Barrel Action                                  |          | 8/6/90  | KR   |
|           | Magnaflux Bolt                                           |          | 8/6/90  | KR   |
| 615       | Rollmark Caliber                                         |          | 8/6/90  | LS   |
| 617       | Drill and Tap Sight Holes                                |          | 8/10/90 | FB   |
| 618       | Polish Barrel <i>RB</i>                                  |          | 8/14/90 | WB   |
| 620       | Apply Coatings (Barrel Action)                           |          | 8-22-90 | TA   |
|           | Apply Coating (Bolt)                                     |          |         |      |
| 625       | Final Assembly                                           |          |         |      |
|           | A) Clean inside of Bolt Assembly                         |          | 8/23/90 | KS   |
|           | B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head |          | 8/23/90 | KS   |
|           | C) Inspect Ejector Hole for Chamfer                      |          | 8/23/90 | KS   |
|           | D) Oil Firing Pin Ass'y                                  |          | 8/23/90 | KS   |
|           | E) Adjust Trigger Pull to Min Setting and Stake          |          | 8/24/90 | RL   |

| op. #        | OP. NAME                                                    | READINGS |      |      |      |      | DATE    | INIT |
|--------------|-------------------------------------------------------------|----------|------|------|------|------|---------|------|
| 625<br>cont. | F) Safety On Force                                          | 5        | 5    | 5    |      |      | 8/24/90 | WB   |
|              | G) Safety Off Force                                         | 2 1/4    | 2    | 2    |      |      | 8/24/90 | WB   |
|              | H) Trigger Pull Test & Retainability                        |          |      |      |      |      | 8/24/90 | KL   |
|              | I) Firing Pin Indent                                        | .024     | .024 | .024 |      |      | 8/24/90 | WB   |
|              | J) Assemble Stock                                           |          |      |      |      |      | 8/24/90 | KS   |
|              | K) Assemble Swivel Studs                                    |          |      |      |      |      | 8/31/90 | JS   |
|              | L) Attach Front and Rear Sight Assemblies                   |          |      |      |      |      | 8/24/90 | KS   |
|              | M) Iron Sight Alignment                                     |          |      |      |      |      | 8/24/90 | KS   |
|              | N) Detach Front & Rear Sights & place in numbered container |          |      |      |      |      | 8/24/90 | KS   |
|              | O) Attach Scope to Rifle                                    |          |      |      |      |      | 8/24/90 | KS   |
|              | P) Detach & Attach Scope 20 Times                           |          |      |      |      |      | 8/24/90 | KS   |
| 640          | Gallery Target & Test                                       |          |      |      |      |      | 8-25-90 | AC   |
|              | A) Time                                                     |          |      |      |      |      | 8-25-90 | AC   |
|              | B) Malfunctions                                             |          |      |      |      |      | 8-25-90 | AC   |
|              | C) Pierced Primers                                          |          |      |      |      |      | 8-25-90 | AC   |
|              | D) Optical Clarity of Scope                                 |          |      |      |      |      | 8-25-90 | AC   |
| 645          | Inspect for Live Ammo                                       |          |      |      |      |      | 8-25-90 | AC   |
| 655          | Final Inspection                                            |          |      |      |      |      |         |      |
|              | A) Headspace                                                |          |      |      |      |      | 8/31/90 | JS   |
|              | B) Trigger Pull                                             | 2.53     | 2.48 | 2.52 | 2.46 | 2.41 | 8/30/90 | KL   |
|              | C) Function                                                 |          |      |      |      |      | 8/31/90 | JS   |
| 660          | Pack                                                        |          |      |      |      |      | 9/19/90 | NE   |