

C6522345

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6522345.___0
FILE DATE AND TIME: 10/11/2008 06:45

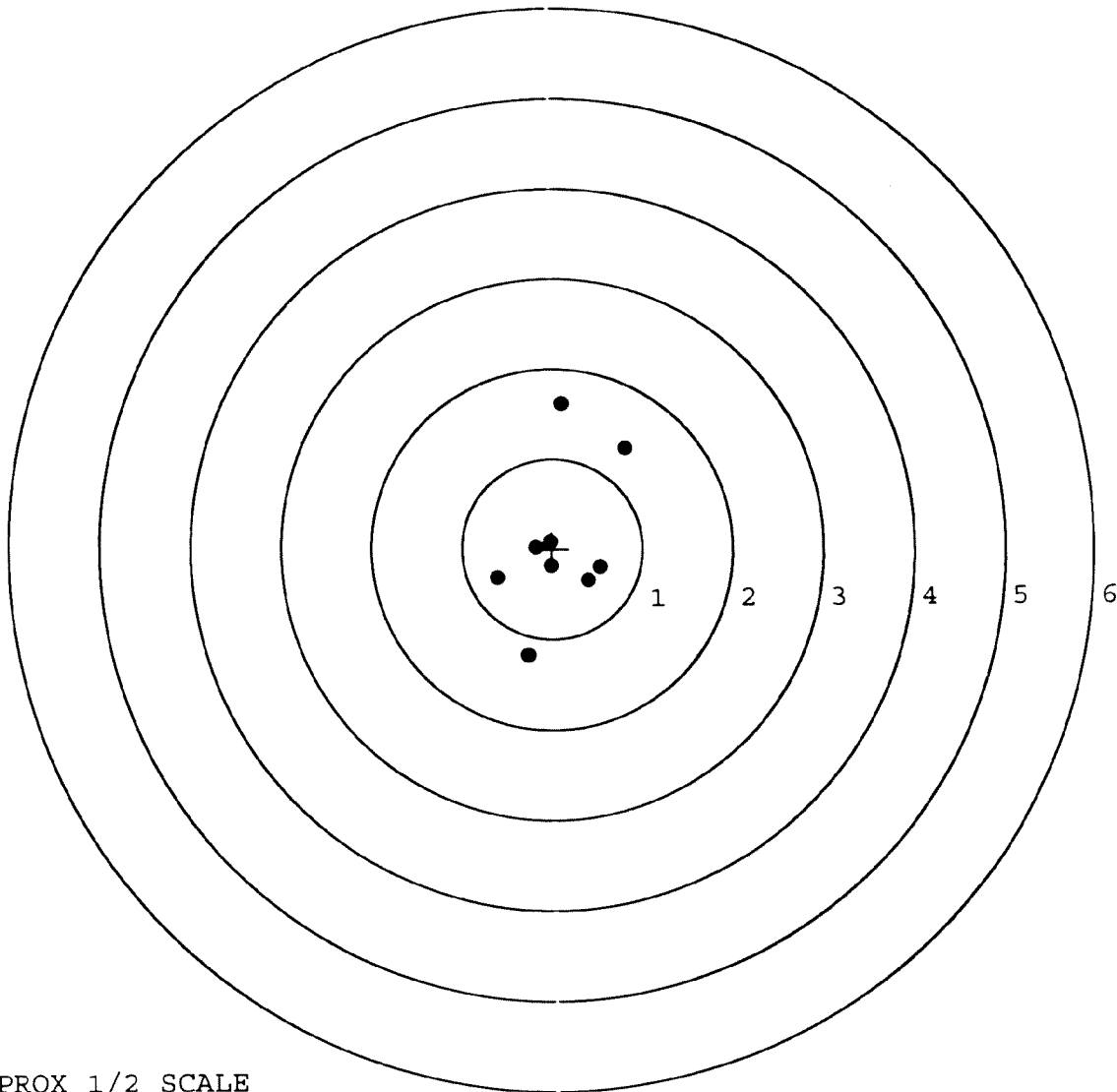
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.009
The Average Y Centroid of the Five Target Set:	0.085
The Average Point of Impact of the Five Target Set:	0.086
The Average Mean Radius of the Five Target Set:	0.623
The Distance from POA to Centroid Target #1:	0.079
The Distance from Centroid Target #2 to Centroid Target #1:	0.246
The Distance from Centroid Target #3 to Centroid Target #1:	0.185
The Distance from Centroid Target #4 to Centroid Target #1:	0.263
The Distance from Centroid Target #5 to Centroid Target #1:	0.126

SERIAL NUMBER: C6522345. __0
 TARGET NUMBER: 1
 FILE DATE: 10/11/2008
 FILE TIME: 06:45

POINT#	X	Y
1:	0.819	1.113
2:	0.119	1.613
3:	-0.609	-0.325
4:	-0.183	0.018
5:	-0.026	0.078
6:	-0.019	-0.197
7:	0.532	-0.212
8:	0.394	-0.355
9:	-0.271	-1.180
10:	-0.285	-1.184

X CENTROID: 0.047
 Y CENTROID: -0.063
 POA TO CENTROID: 0.079
 HORZ SPREAD: 1.428
 VERT SPREAD: 2.797
 GROUP SPREAD: 2.826
 MIN RADIUS: 0.149
 MAX RADIUS: 1.678
 MEAN RADIUS: 0.763
 # IN 1 IN DIAMETER: 4
 # IN 2 IN DIAMETER: 6
 # in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6522345. 0

TARGET NUMBER: 2

FILE DATE: 10/11/2008

FILE TIME: 06:45

X CENTROID: -0.055

Y CENTROID: 0.161

POA TO CENTROID: 0.170

HORZ SPREAD: 1.697

VERT SPREAD: 1.530

GROUP SPREAD: 2.235

MIN RADIUS: 0.033

MAX RADIUS: 1.447

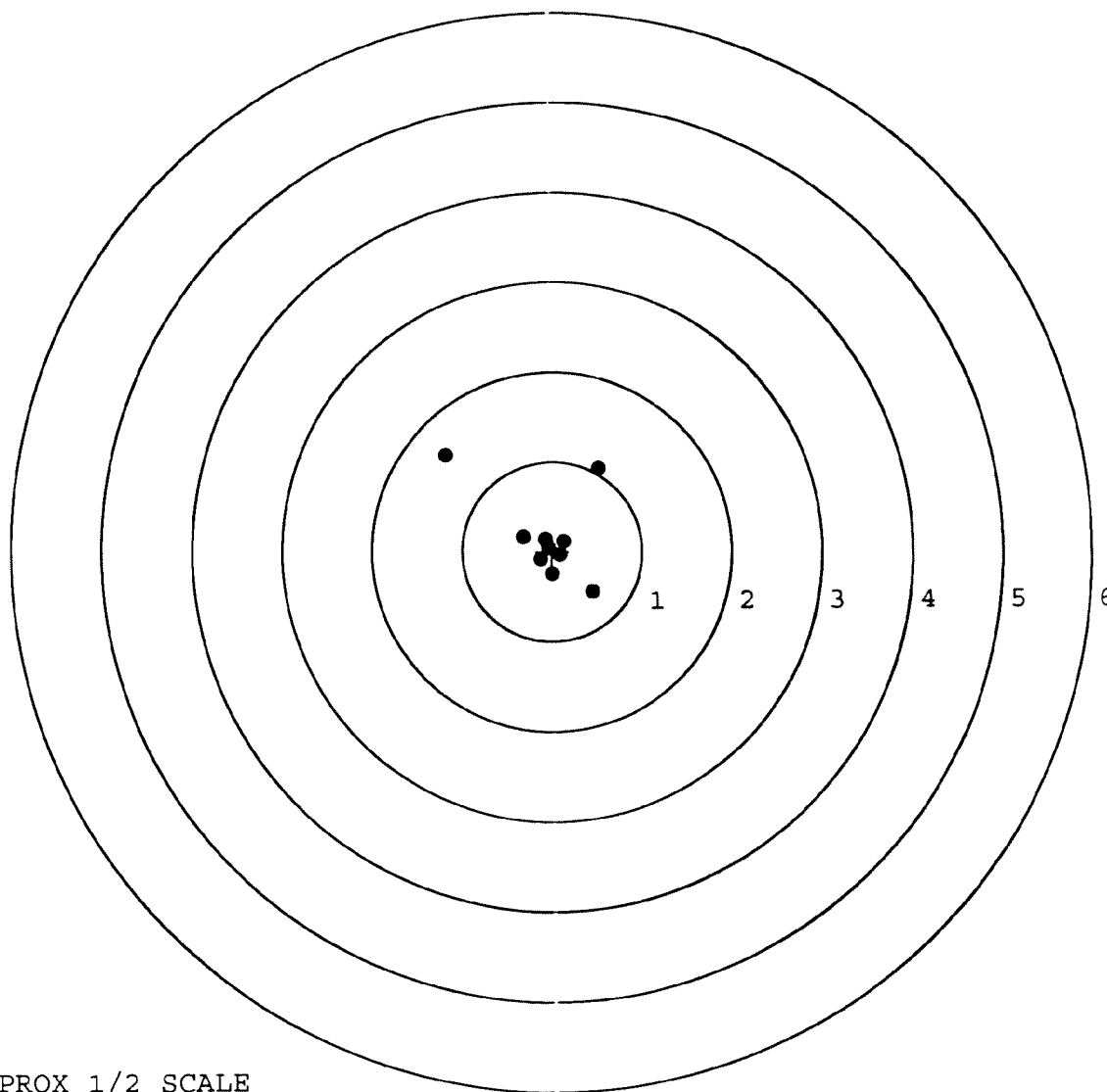
MEAN RADIUS: 0.474

IN 1 IN DIAMETER: 7

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-1.177	1.074
2:	0.520	0.920
3:	0.452	-0.456
4:	0.003	-0.257
5:	0.090	-0.041
6:	0.133	0.113
7:	-0.075	0.134
8:	-0.326	0.164
9:	-0.131	-0.091
10:	-0.042	0.046

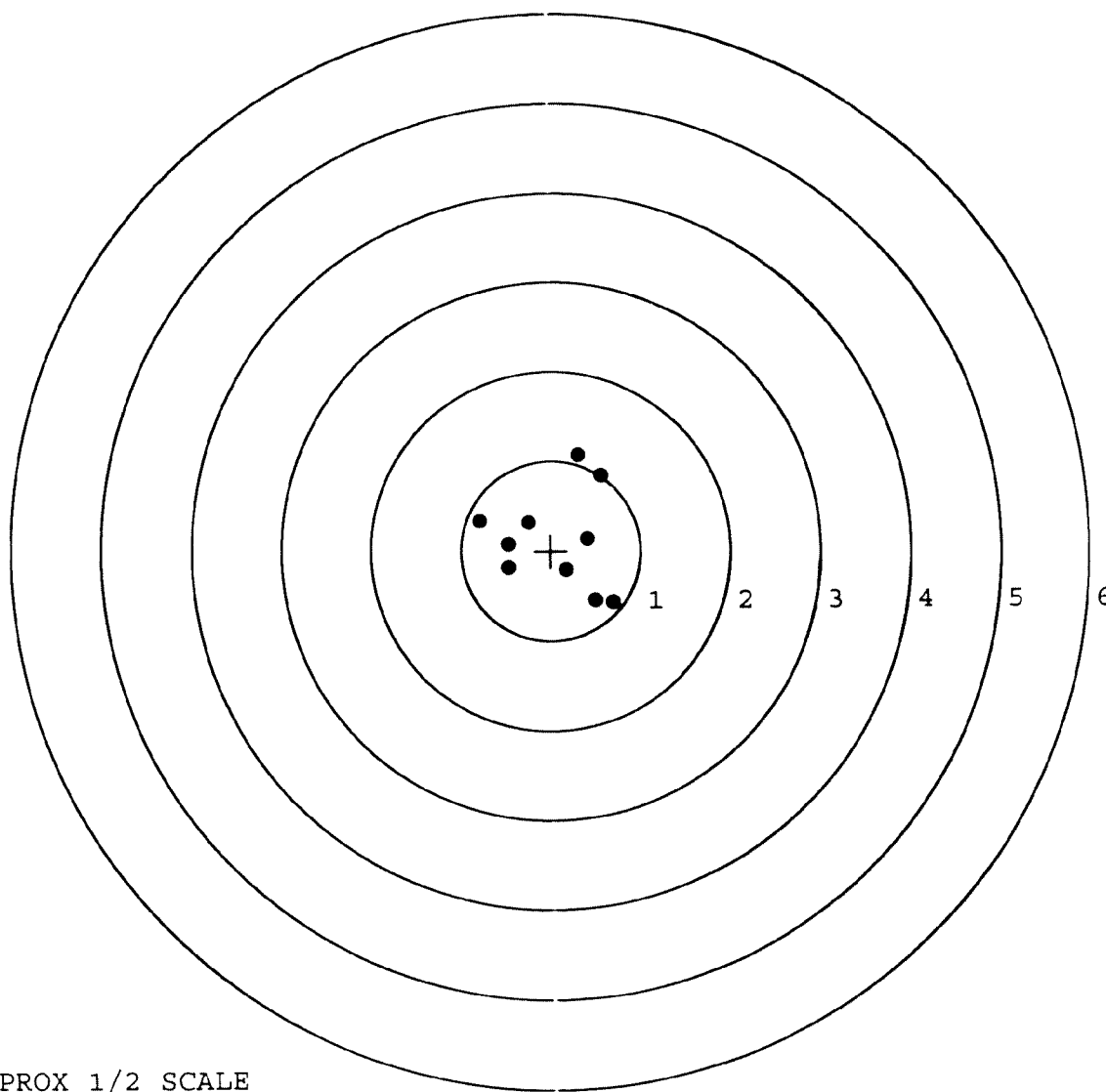


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6522345. __0
 TARGET NUMBER: 3
 FILE DATE: 10/11/2008
 FILE TIME: 06:45

POINT#	X	Y
1:	0.688	-0.577
2:	0.499	-0.557
3:	0.171	-0.215
4:	0.409	0.127
5:	0.564	0.834
6:	0.309	1.061
7:	-0.790	0.336
8:	-0.474	-0.193
9:	-0.477	0.076
10:	-0.247	0.317

X CENTROID: 0.065
 Y CENTROID: 0.121
 POA TO CENTROID: 0.137
 HORZ SPREAD: 1.478
 VERT SPREAD: 1.638
 GROUP SPREAD: 1.681
 MIN RADIUS: 0.344
 MAX RADIUS: 0.971
 MEAN RADIUS: 0.670
 # IN 1 IN DIAMETER: 3
 # IN 2 IN DIAMETER: 10
 # in 3 IN DIAMETER: 10

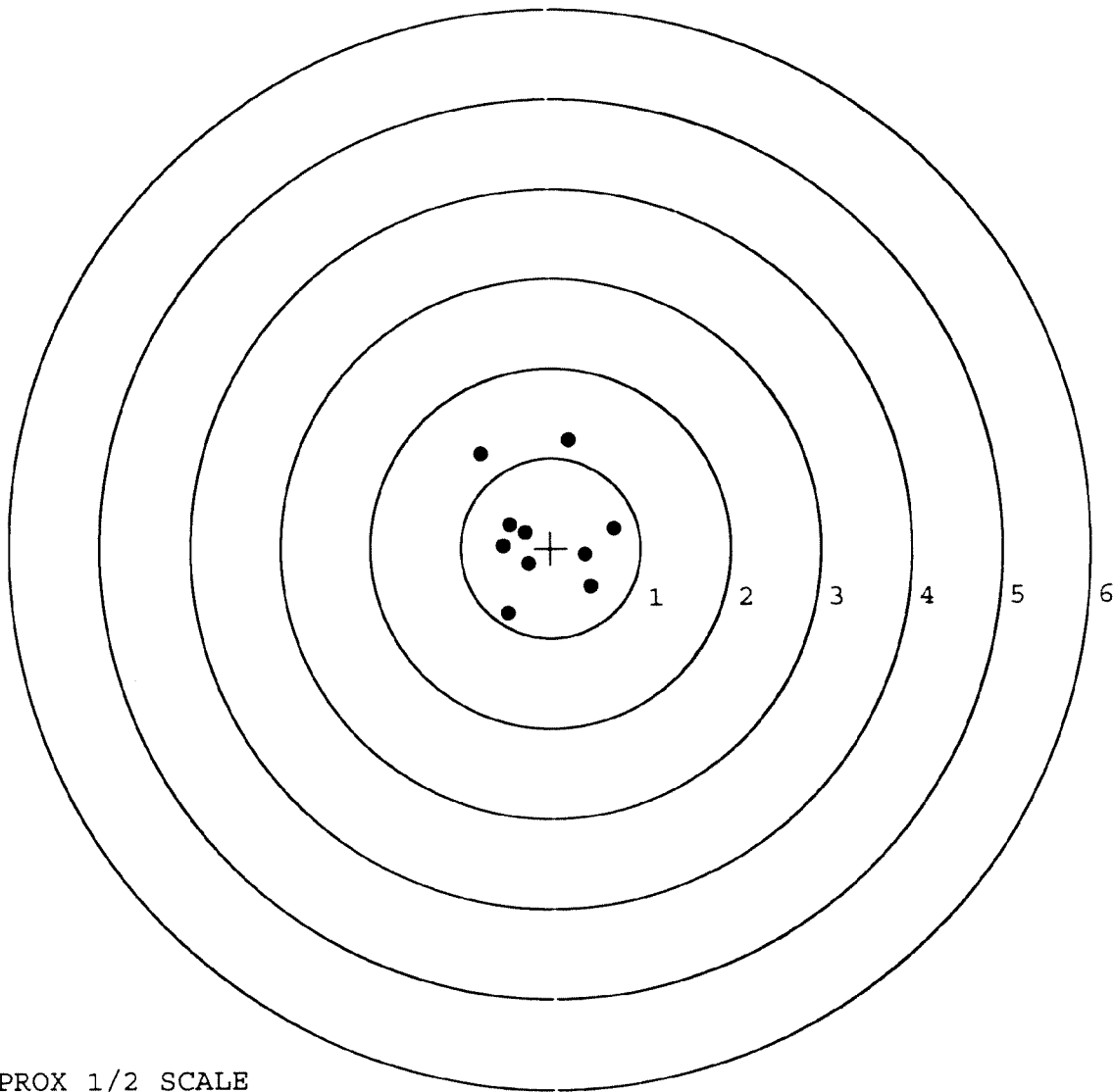


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6522345. __0
 TARGET NUMBER: 4
 FILE DATE: 10/11/2008
 FILE TIME: 06:45

POINT#	X	Y
1:	-0.770	1.048
2:	0.212	1.197
3:	0.705	0.214
4:	0.380	-0.075
5:	0.440	-0.431
6:	-0.286	0.177
7:	-0.456	0.262
8:	-0.528	0.033
9:	-0.249	-0.178
10:	-0.484	-0.725

X CENTROID: -0.104
 Y CENTROID: 0.152
 POA TO CENTROID: 0.184
 HORZ SPREAD: 1.475
 VERT SPREAD: 1.922
 GROUP SPREAD: 1.911
 MIN RADIUS: 0.184
 MAX RADIUS: 1.116
 MEAN RADIUS: 0.666
 # IN 1 IN DIAMETER: 4
 # IN 2 IN DIAMETER: 8
 # in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6522345. __0

TARGET NUMBER: 5

FILE DATE: 10/11/2008

FILE TIME: 06:45

X CENTROID: 0.003

Y CENTROID: 0.055

POA TO CENTROID: 0.055

HORZ SPREAD: 1.129

VERT SPREAD: 1.922

GROUP SPREAD: 2.078

MIN RADIUS: 0.073

MAX RADIUS: 1.226

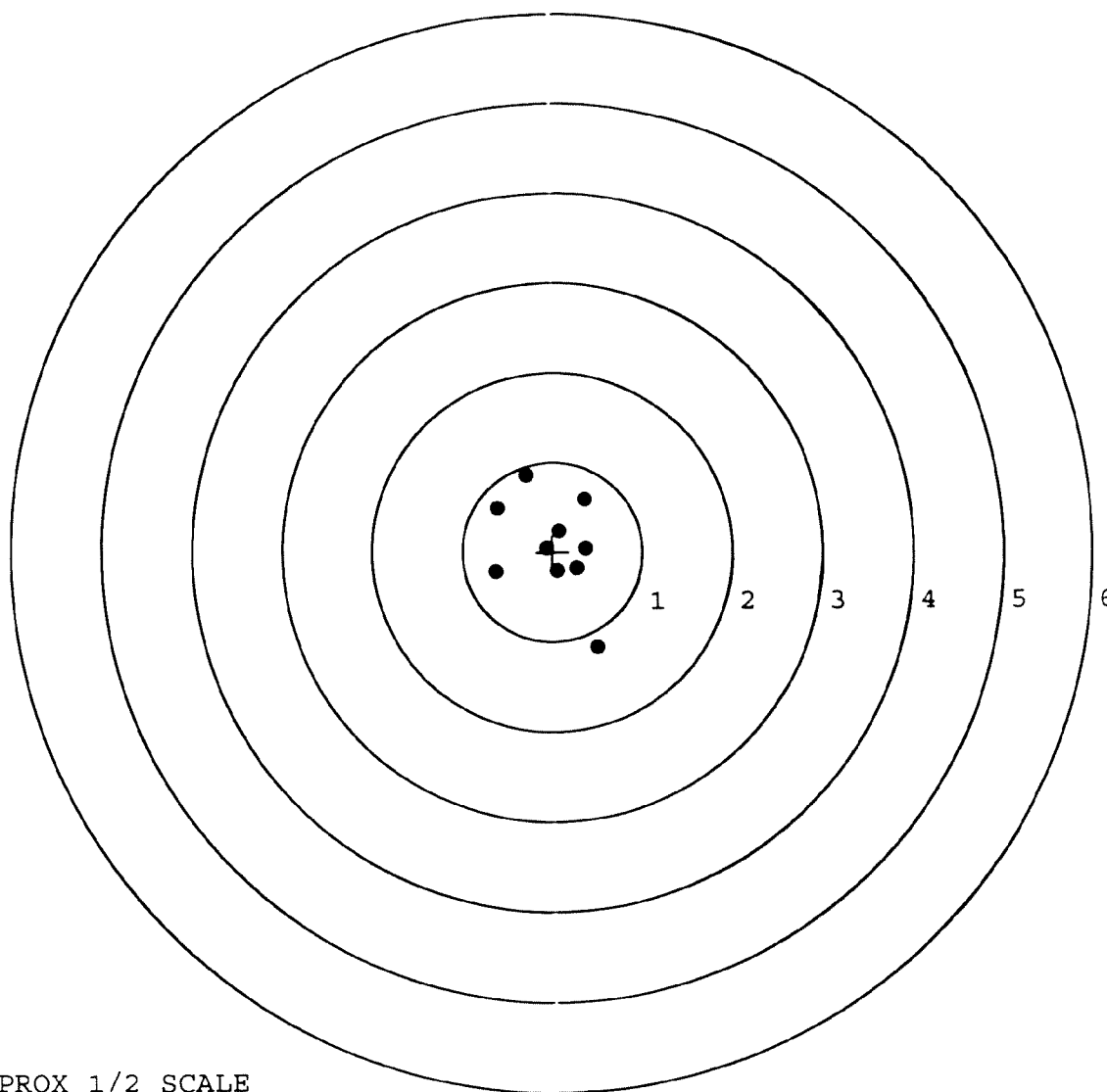
MEAN RADIUS: 0.544

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.364	0.586
2:	-0.293	0.855
3:	-0.613	0.492
4:	-0.631	-0.224
5:	0.498	-1.067
6:	0.373	0.038
7:	0.269	-0.191
8:	0.054	-0.214
9:	-0.070	0.046
10:	0.075	0.228



TARGET APPROX 1/2 SCALE

Repair Inquiry

Repair Number: RE00151221

Serial: C6522345 Model M24 SWS Center Fire
Caliber: 7.62 NATO

Repairman:

Verify Repair

Status:

Closed 9/16/2008 2:27:04 PM

Address Information

Customer:

☒ Received From

Return To:

☐ Received From

Name: ISD ARMSROOM

ISD ARMSROOM

Address 1: 8TH DESERT STORM

8TH DESERT STORM

Address 2: BLDG 5210 BAY DOOR #30

PO Box:

BLDG 5210 BAY DOOR #30

PO Box:

City: FORT CAMPBELL

FORT CAMPBELL

State: KY

Zip Code: 42223

Country: US

State: KY

Zip Code: 42223

Country: US

FFL:

Contact / Condition

Problems

Estimate

History / Status

Shipping / Billing

Contact Information

Phone: NN

Fax:

Email:

Comments:

Received Condition

Fair

Condition Notes:

CSR Notes:

Accessories Received

Code	Desc	Qty
A007	With Stud	3
A017	Scope Base	1
A057	Frt and Rear Sgt Base	1

Repair Search

Refresh

Close

nagletj

9/16/2008

3:26 PM

CAPS

NUM

INS

SCRL



Serial Number: C6522345

Model M24 SWS



RE00151221

M-24 INSPECTION CHECKLIST
CONTRACT #: DAAE-20-02-C-0149

R & I NUMBER

151221

SERIAL NUMBER

C6522345

LOG-IN DATE

9-16-08

OPERATION #	OPERATION NAME	DATE	INITIAL
500	DIS-ASSEMBLE GUN	9-18-08	RTZ
505	RE-BARREL	9-22-08	RTZ
560	ASSEMBLE	9-22-08	RTZ
600	PROOF	9-23-08	SPD
605	CHECK HEADSPACE	9-23-08	SPD
610	DIS-ASSEMBLE GUN	9-23-08	SPD
612	MAGNAFLUX	9/30/08	(AS)
510	DRILL AND TAP	9-23-08	J
615	ROLLMARK CALIBER	9/30/08	RT
618	ROTO-BLAST		
620	APPLY COATINGS	10/1	—
625	FINAL ASSEMBLY	10-2-08	RTZ
640	FUNCTION TEST AND	PASS FAIL 10-10-08	TL
650	TARGET	PASS FAIL 10-10-08	TL
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
670	FINAL INSPECTION	10-10-08	SPD
	A) HEADSPACE	PASS FAIL 10-22-08	SPD
		2.31 2.29 2.31 2.42 2.37	10/16/08 FM
680	F) SAFETY ON FORCE	4.0 4.0 4.0	10-22-08 SPD
	G) SAFETY OFF FORCE	4.0 4.0 4.0	10-22-08 SPD
	I) FIRING PIN INDENT	.022 .022 .021	10-22-08 SPD
690	PACK		10/31/08 FM

RECEIVING AND ESTIMATING REPORT

BARBER - M24 0005516

COMMENTS

ORDER
R 99-09172

INITIAL
SWS

CUSTOMER ORDER NO.
394

DATE RECEIVED 04/07/99	DATE OPENED 04/08/99	DATE CODE OK 7-90	SERIAL NUMBER C6522345	NEW SERIAL NUMBER	MODEL AND GRADE 700 7.62 M24
ACCESSORIES W/STUDS SCOPE BASE					

FROM:	SHIP TO:
US ARMY ATTN: JAMES C STARNES JR GSC 5TH SFG (A) FORT CAMPBELL KY 42223	US ARMY ATTN: JAMES C STARNES JR GSC 5TH SFG (A) FORT CAMPBELL KY 42223

CUST NO: 200414 C.O.D.

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

- 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	COMMENTS
-------	----------

Barrel 96003
Stock 96018
Extractor 91816

REPAIRMAN RW	PROOF ✓	CLEAN ✓	TEST ✓	TARGET ✓	PATTERN
GALLERY TESTER RW	DATE	DATE 6-11-99	DATE 6-14-99	DATE 6-14-99	DATE

OFFICE COPY

RD0025 REV. 7/97

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

BARBER - M24 0005516

Receipt Of Firearm(s) Delivered to the Plant for Repair
Firearm Checked For Live Ammunition []

File # 00394

Delivery Date 4/7/99Customer Name (Print) US Army, James C Starns Jr
Address 55C 5th SAGE, Ft Campbell State KY Zip 42223
Phone Number (502) - 798-2882/7932Firearm Description Model M700 (M24) Cal./ Ga. 7.62Serial Number C6522345

Stock/ Fore-end Condition circle the description

(Excellent; Good; Fair; Poor; Fancy; Plain, Synthetic, Wood)

Comments on Stock/ Fore-end condition _____

Metal Condition circle the description

(Excellent; Good; Fair; Poor; Fancy; Plain Stainless Steel)

Comments on Metal condition _____

Barrel Type (VT. Rib; Plain; Deer; Stainless Steel) Barrel length _____

List additional accessories IE, Scope, Sling, Gun case and description; _____

Customer request: Reconditioning

Return Process Return to Clark St. Ent. [] Return via UPS [X]

By signing this receipt the person delivering the firearm understands to be the only person to receive the firearm upon completion of repairs.

Signature James C Starns Jr Date 4/7/99
person delivering firearmSignature [Signature] Date 4/7/99
security officerSignature [Signature] Date 4/7/99
arms service / CSR

Customer Pick Up Verification

I certify, I am the same person whom delivered the above described firearm to the Remington Ilion plant for repair and may lawfully possess a firearm in New York State

Signature _____ Date ____/____/____
person receiving firearm must be the same whom deliveredSignature _____ Date ____/____/____
security officer or other witness returning the firearm

BARBER - M24 0005518

Remington Test Lab, Ilion, N.Y.

Centroidal distance calculations for Rifle # c6522345
21 Jun 1999

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: $-.1332$
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: $.0942$
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: $.163144$

THE AMR FOR THIS RIFLE IS: 1.026

CENTROIDAL DISTANCES

0 TO	1	.856248
1 TO	2	.875434
1 TO	3	1.11343
1 TO	4	1.01788
1 TO	5	.495997

1
5
2 <----POA
43

REMINGTON CENTERFIRE ACCURACY TEST

REMINGTON TEST LAB, ILION, N.Y.

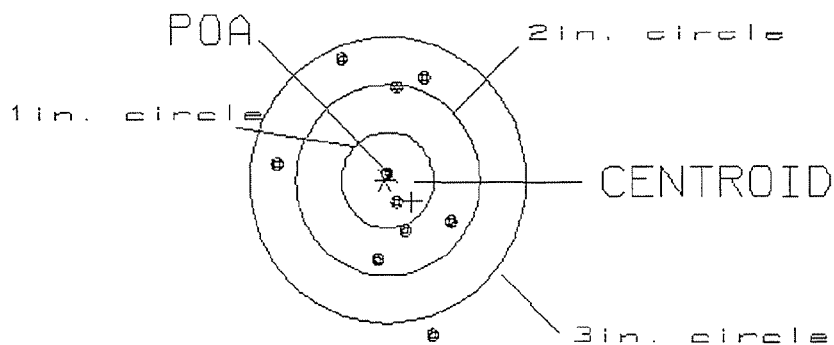
PATTERN #: 1

POA TO CENTROID: .372
 MIN RADIUS : .106
 MEAN RADIUS : .891
 MAX RADIUS : 1.723
 CENTROID X : -.295
 CENTROID Y : .228

21 Jun 1999

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6522345

CENTERFIRE PATTERN # 1



OF SHOTS= 10

IN CIRCLE

HS= 1.83

2

VS= 2.94

6

GS= 3.11

9

REMINGTON CENTERFIRE ACCURACY TEST

REMINGTON TEST LAB, ILION, N.Y.

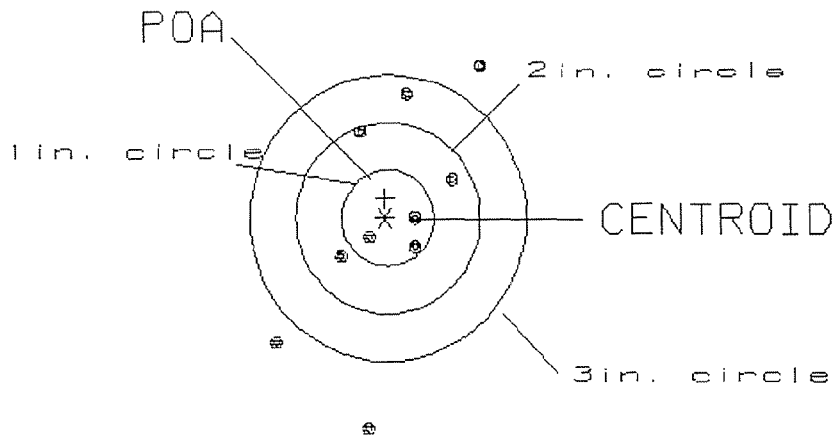
PATTERN #: ☐ 2 ☐

POA TO CENTROID: .200
 MIN RADIUS : .260
 MEAN RADIUS : 1.050
 MAX RADIUS : 2.206
 CENTROID X : .004
 CENTROID Y : -.200

21 Jun 1999

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6522345

CENTERFIRE PATTERN # 2



OF SHOTS= 10

IN CIRCLE

HS= 2.13
 VS= 3.79
 GS= 3.97

3
 6
 7

REMINGTON CENTERFIRE ACCURACY TEST

REMINGTON TEST LAB, ILION, N.Y.

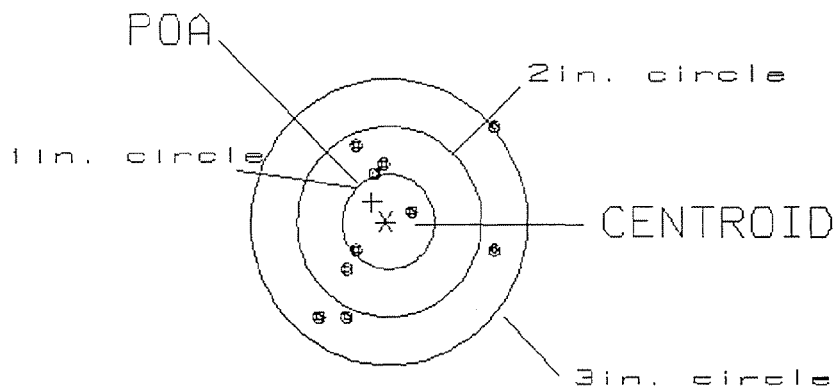
PATTERN #: 3

POA TO CENTROID: .257
 MIN RADIUS : .314
 MEAN RADIUS : .854
 MAX RADIUS : 1.527
 CENTROID X : .156
 CENTROID Y : -.205

21 Jun 1999

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6522345

CENTERFIRE PATTERN # 3



OF SHOTS= 10

IN CIRCLE

HS= 1.90
 VS= 2.00
 GS= 2.76

2
 6
 9

REMINGTON CENTERFIRE ACCURACY TEST

REMINGTON TEST LAB, ILION, N.Y.

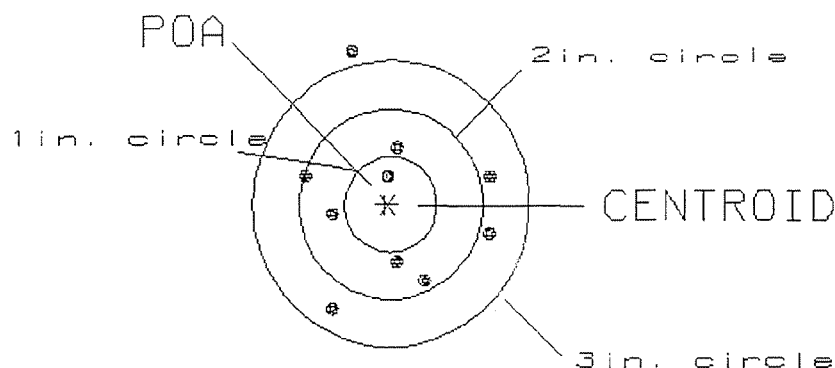
PATTERN #: 4

POA TO CENTROID: .031
 MIN RADIUS : .319
 MEAN RADIUS : .924
 MAX RADIUS : 1.611
 CENTROID X : .031
 CENTROID Y : .002

21 Jun 1999

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6522345

CENTERFIRE PATTERN # 4



OF SHOTS= 10

IN CIRCLE

HS= 2.03
 VS= 2.69
 GS= 2.70

1
 6
 9

REMINGTON CENTERFIRE ACCURACY TEST

REMINGTON TEST LAB, ILION, N.Y.

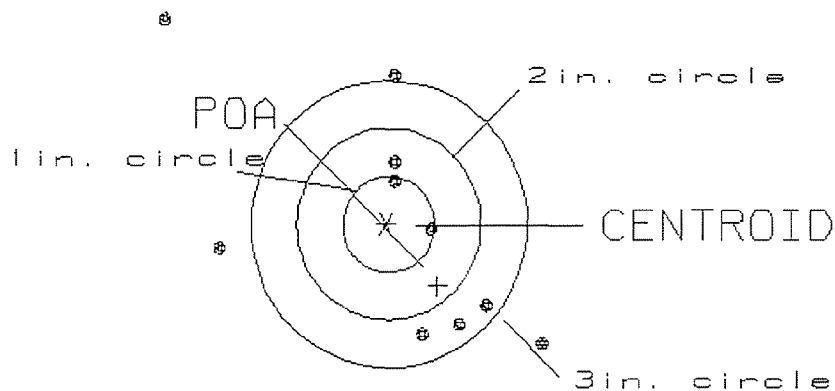
PATTERN #: 5

POA TO CENTROID: .856
 MIN RADIUS : .428
 MEAN RADIUS : 1.411
 MAX RADIUS : 3.243
 CENTROID X : -.562
 CENTROID Y : .646

21 Jun 1999

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6522345

CENTERFIRE PATTERN # 5



OF SHOTS= 10

IN CIRCLE

HS= 4.10
 VS= 3.40
 GS= 5.33

2
 3
 5

Remington[®] **DUPONT**
REG. U.S. PAT. & TM. OFF.

MODEL 700TM M24

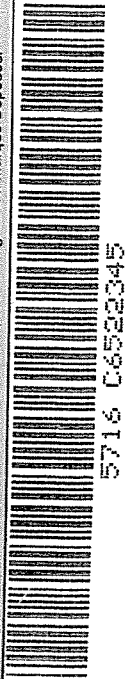
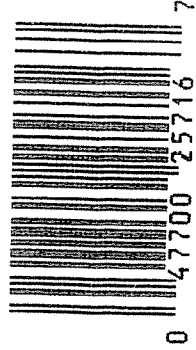
VERY IMPORTANT:
Instruction Book
enclosed to assure
safe use of this
firearm.

SERIAL NO.
C6522345

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 # 06522345
23 Aug 1990

CENTROIDAL DISTANCES

0 TO	1	.177229
1 TO	2	.680541
1 TO	3	.212897
1 TO	4	.331103
1 TO	5	.112432


 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0496
 THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0438
 THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .066171
 THE AVE FOR THIS RIFLE IS: .9094

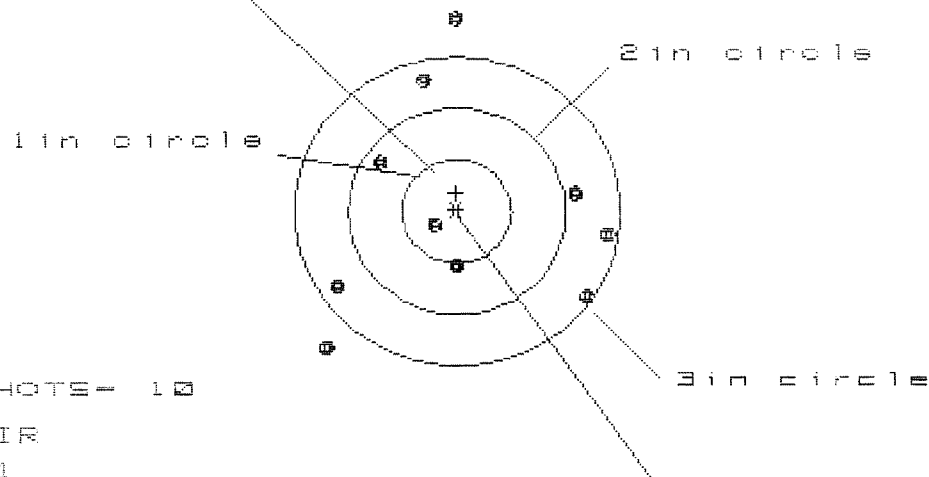
23 Aug 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C8522345

CENTERFIRE PATTERNS

1

POA



OF SHOTS= 10

IN CIR

1in = 1

2in = 3

3in = 6

HS= 2.650

VS= 3.202

GS= 3.428

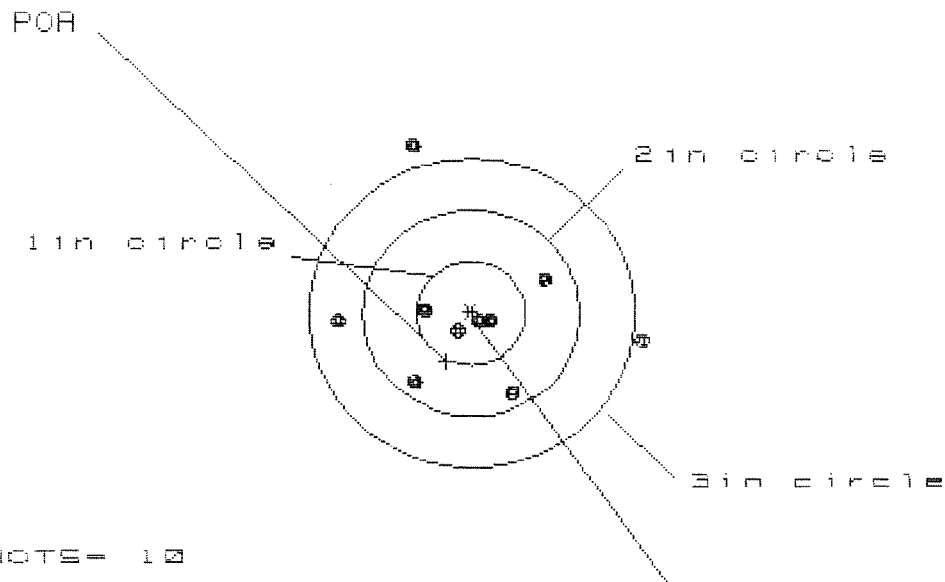
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.403	1.400	1.244
MINIMUM X	-1.247	-1.250	-1.226
MAXIMUM Y	1.890	1.447	1.309
MINIMUM Y	-1.312	-1.102	-0.754
CENTROID X	.009	.012	.168
CENTROID Y	-.177	-.387	-.249
POA TO CENTROID in.	.177	.387	.300
MIN RADIUS	.239	.262	.384
MEAN RADIUS	1.181	1.080	1.015
MAJ RADIUS	1.890	1.666	1.401
HORIZONTAL SPREAD	2.650	2.650	2.470
VERTICAL SPREAD	3.202	2.549	2.063
EXTREME SPREAD	3.428	2.848	2.535
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	3		
NUMBER IN THREE INCH CIRCLE =	6		

23 Aug 1998

FILE:/PATTERNING/CENTERFIRE_PATT/06522345

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1in = 4

2in = 7

3in = 8

HS= 2.744

VS= 2.415

ES= 2.791

CENTROID #

PATTERN #	2	2	2
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.552	1.497	.765
MINIMUM X	-1.192	-1.247	-1.060
MAXIMUM Y	1.655	.476	.470
MINIMUM Y	-.760	-.577	-.583
CENTROID X	.229	.284	.097
CENTROID Y	.467	.283	.289
POA TO CENTROID in.	.520	.401	.305
MIN RADIUS	.120	.073	.024
MEAN RADIUS	.782	.652	.534
MAX RADIUS	1.728	1.498	1.071
HORIZONTAL SPREAD	2.744	2.744	1.825
VERTICAL SPREAD	2.415	1.053	1.053
EXTREME SPREAD	2.791	2.752	1.852
NUMBER IN ONE INCH CIRCLE =	4		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	8		

23 Aug 1990

FILE:/PATTERNING/CENTERFIRE_PATT/06522345

CENTERFIRE PATTERNS # 3

POA

1in circle

2in circle

3in circle

OF SHOTS= 10

IN CIR

1in = 1

2in = 6

3in = 8

HS= 2.804

VS= 1.371

GS= 3.007

CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.269	1.098	.885
MINIMUM X	:	-1.535	-1.706	-1.026
MAXIMUM Y	:	.664	.606	.661
MINIMUM Y	:	-.707	-.765	-.710
CENTROID X	:	.044	.215	.428
CENTROID Y	:	.033	.091	.036
POA TO CENTROID in.	:	.056	.233	.430
MIN RADIUS	:	.232	.135	.298
MEAN RADIUS	:	.923	.799	.658
MAX RADIUS	:	1.621	1.762	1.064
HORIZONTAL SPREAD	:	2.804	2.804	1.911
VERTICAL SPREAD	:	1.371	1.371	1.371
EXTREME SPREAD	:	3.007	3.007	2.094
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

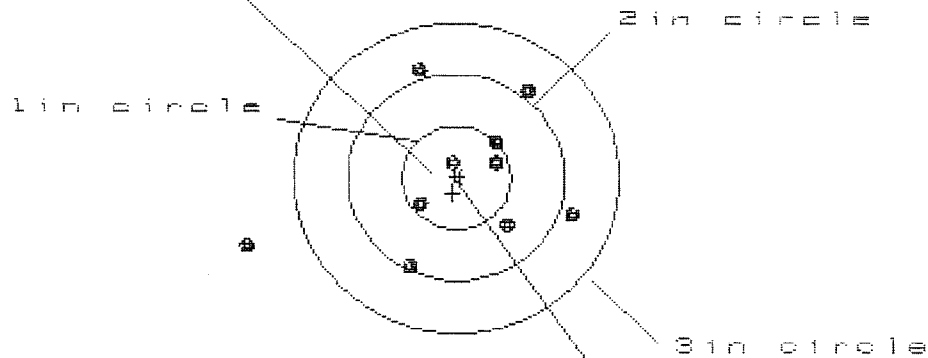
23 Aug 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6522345

CENTERFIRE PATTERNS

4

POB



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 6

3 in = 9

HS= 2.905

VS= 1.807

CS= 2.992

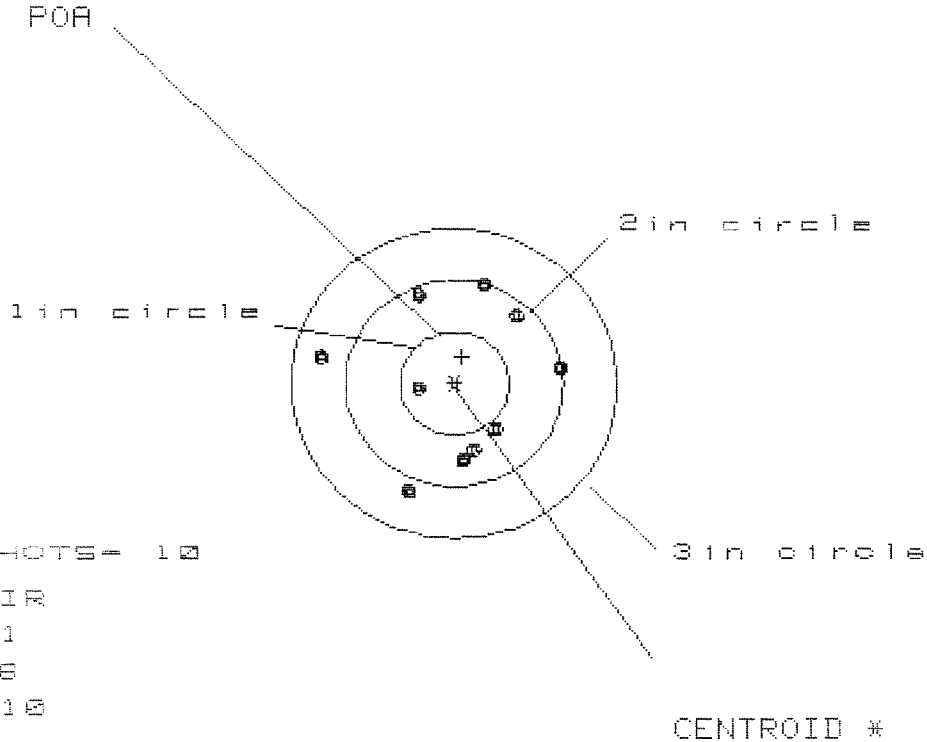
CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.015	.805	.863
MINIMUM X	:	-1.890	-.597	-.539
MAXIMUM Y	:	.998	.926	1.028
MINIMUM Y	:	-.909	-.881	-.779
CENTROID X	:	.036	.246	.188
CENTROID Y	:	.153	.225	.123
POB TO CENTROID in.	:	.157	.334	.225
MIN RADIUS	:	.146	.122	.222
MEAN RADIUS	:	.824	.657	.625
MOD RADIUS	:	1.998	1.066	1.130
HORIZONTAL SPREAD	:	2.905	1.402	1.402
VERTICAL SPREAD	:	1.807	1.807	1.807
EXTREME SPREAD	:	2.992	2.005	1.901
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

23 Aug 1998

FILE:/PATTERNING/CENTERFIRE_PATT/08522345

CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1in = 1

2in = 8

3in = 10

HS= 2.175

VS= 1.956

GS= 2.177

CENTROID *

PATTERN #	5		
SHOTS - BEST OF	10	9	8
MAXIMUM X	.957	.822	.754
MINIMUM X	-1.218	-.546	-.555
MAXIMUM Y	.932	.962	.838
MINIMUM Y	-1.024	-.994	-.829
CENTROID X	-.070	.065	.133
CENTROID Y	-.257	-.287	-.163
POA TO CENTROID in.	.267	.294	.210
MIG RADIUS	.358	.422	.516
MEAN RADIUS	.837	.779	.736
W3 RADIUS	1.246	1.134	.953
HORIZONTAL SPREAD	2.175	1.368	1.309
VERTICAL SPREAD	1.956	1.956	1.667
EXTREME SPREAD	2.177	2.077	1.687
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		8	
NUMBER IN THREE INCH CIRCLE =		10	

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6522345

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	6 29	90	RW
600	Proof	6 29	90	RW
607	Check Headspace	6 29	90	RW
610	Dis-assemble Gun	6 29	90	RW
612	Magnaflux Barrel Action		7-12-90	KR
	Magnaflux Bolt		7-12-90	KR
615	Rollmark Caliber		7-12-90	G.L.
617	Drill and Tap Sight Holes		7/13/90	LB
618	Polish Barrel RB		7/16/90	WB
620	Apply Coatings (Barrel Action)		7-23-90	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		7/25/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		7/25/90	RW
	C) Inspect Ejector Hole for Chamfer		7/25/90	RW
	D) Oil Firing Pin Ass'y		7/25/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		8/18/90	JK

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			8/12/90	RL
	G) Safety Off Force	4	4	4			8/12/90	RL
	H) Trigger Pull Test & Retainability						8/15/90	RL
	I) Firing Pin Indent	.0225	.023	.023			8/16/90	RL
	J) Assemble Stock						8/22/90	RW
	K) Assemble Swivel Studs						8/30/90	LS
	L) Attach Front and Rear Sight Assemblies						8/22/90	RW
	M) Iron Sight Alignment						8/22/90	RW
	N) Detach Front & Rear Sights & place in numbered container						8/22/90	RW
	O) Attach Scope to Rifle						8/22/90	RW
	P) Detach & Attach Scope 20 Times						8/22/90	RW
640	Gallery Target & Test						8/22/90	RI
	A) Time						8/22/90	RI
	B) Malfunctions						8/22/90	RI
	C) Pierced Primers						8/22/90	RI
	D) Optical Clarity of Scope						8/22/90	RI
645	Inspect for Live Ammo						8/22/90	RI
655	Final Inspection						8/30/90	LS
	A) Headspace							
	B) Trigger Pull	2.26	2.16	2.26	2.23	2.27	8/30/90	RL
	C) Function						8/30/90	LS
660	Pack						8/18/90	RL

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#
3.00# + .75#
4.00# + 1.00#

SERIAL NO. 06522345DATE 8/18/90TESTER JL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.31	2.41	2.31	2.26	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.40	2.49	2.19	2.16	
PULL #3	2.31	2.37	2.31	2.26	
PULL #4	2.44	2.43	2.31	2.23	
PULL #5	2.40	2.37	2.39	2.27	
TOTAL	11.86	12.07	11.51	11.18	
AVG.	2.372	2.414	2.302	2.236	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.34	3.36		
PULL #2	3.33	3.33		
PULL #3	3.36	3.30		
PULL #4	3.36	3.19		
PULL #5	3.39	3.33		
TOTAL	16.78	16.51		
AVG.	3.356	3.302		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.45	4.38		4.17
PULL #2	4.47	4.47		4.45
PULL #3	4.39	4.46		4.21
PULL #4	4.46	4.36		4.46
PULL #5	4.36	4.30		4.45
TOTAL	22.13	21.97		21.74
AVG.	4.426	4.394		4.348