

06523384

MODEL 700™ M24

Model **S&S**™

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: RE00136232

Verify Repair

Serial: C6523384 Model M24 SWS Center Fire
Caliber: 7.62 NATO

Repairman:

Status:

Closed 11/2/2007 10:15:59 AM

Address Information

Customer:

Received From

Return To:

Received From

Name: BARRY MOBERLY

BARRY MOBERLY

Address 1: L-3 COMMUNICATIONS

L-3 COMMUNICATIONS

Address 2: 5749 BRIAR HILL RD BLDG 221

PO Box:

5749 BRIAR HILL RD BLDG 221

PO Box:

City: LEXINGTON

LEXINGTON

State: KY

Zip Code: 40516

Country: US

State: KY

Zip Code: 40516

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
A008	With Swivel	3
A010	Hard Case	1
A026	Scope	1
A055	Deployment Kit	1
D000	SCOPE CASE	1

Repair Search

Refresh

Close

nagletj

11/2/2007

1:13 PM

CAPS

NUM

INS

SCRL



Serial Number: **C6523384**
 Model: **M24 SWS**

RE00136232

BARBER - M24 0027128 INSPECTION CHECKLIST - REPAIRS
CONTRACT #: W52H09-07-C-0207

R & E NUMBER	136232		
SERIAL NUMBER	C6523384		
LOG-IN DATE	11-2-07		
OPERATION #	OPERATION NAME	DATE	INITIAL
500	DIS-ASSEMBLE GUN	7-8-08	RTZ
505	RE-BARREL	7-9-08	RTZ
420	ASSEMBLE	7-10-08	LR
440	PROOF	7-10-08	SD
460	CHECK HEADSPACE	7-10-08	SD
470	DIS-ASSEMBLE GUN	7-11-08	RTZ
480	MAGNAFLUX	7-15-08	BB
510	DRILL AND TAP	7-11-08	JP
500	ROLLMARK CALIBER	7-15-08	RT
520	GOFF BLAST BBL / REC	7-17	com
530 & 540	APPLY COATINGS	7-22-08	RTZ
560	FINAL ASSEMBLY	7-22-08	RTZ
640	FUNCTION TEST AND	PASS FAIL 9-3-08	JP
650	TARGET	PASS FAIL 9-3-08	JP
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION N/A	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	9-3-08 TL
670	FINAL INSPECTION	9-10-08 RTZ	
	A) HEADSPACE	PASS FAIL 9-1-08	TL
	B) TRIGGER PULL	233 245 249 243 248 9-8-08	PSM
680	F) SAFETY ON FORCE	2 2 2 9-8-08	TL
	G) SAFETY OFF FORCE	3.5 3.5 3.5 9-8-08	TL
	I) FIRING PIN INDENT	.022 .023 .023 9-8-08	TL
690	PACK	9-11-08	TL

F006 REV 5/2006

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6523384.___0
FILE DATE AND TIME: 09/04/2008 11:57

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.040
The Average Y Centroid of the Five Target Set:	0.027
The Average Point of Impact of the Five Target Set:	0.048
The Average Mean Radius of the Five Target Set:	0.628
The Distance from POA to Centroid Target #1:	0.116
The Distance from Centroid Target #2 to Centroid Target #1:	0.098
The Distance from Centroid Target #3 to Centroid Target #1:	0.195
The Distance from Centroid Target #4 to Centroid Target #1:	0.343
The Distance from Centroid Target #5 to Centroid Target #1:	0.352

SERIAL NUMBER: C6523384. __0

TARGET NUMBER: 1

FILE DATE: 09/04/2008

FILE TIME: 11:57

POINT#	X	Y
1:	0.383	-1.298
2:	0.534	-0.674
3:	-0.075	-0.760
4:	0.718	0.885
5:	0.240	0.048
6:	-0.283	-0.282
7:	-0.320	-0.006
8:	-0.250	0.392
9:	-0.576	0.259
10:	-1.292	0.739

X CENTROID: -0.092

Y CENTROID: -0.070

POA TO CENTROID: 0.116

HORZ SPREAD: 2.010

VERT SPREAD: 2.183

GROUP SPREAD: 2.637

MIN RADIUS: 0.237

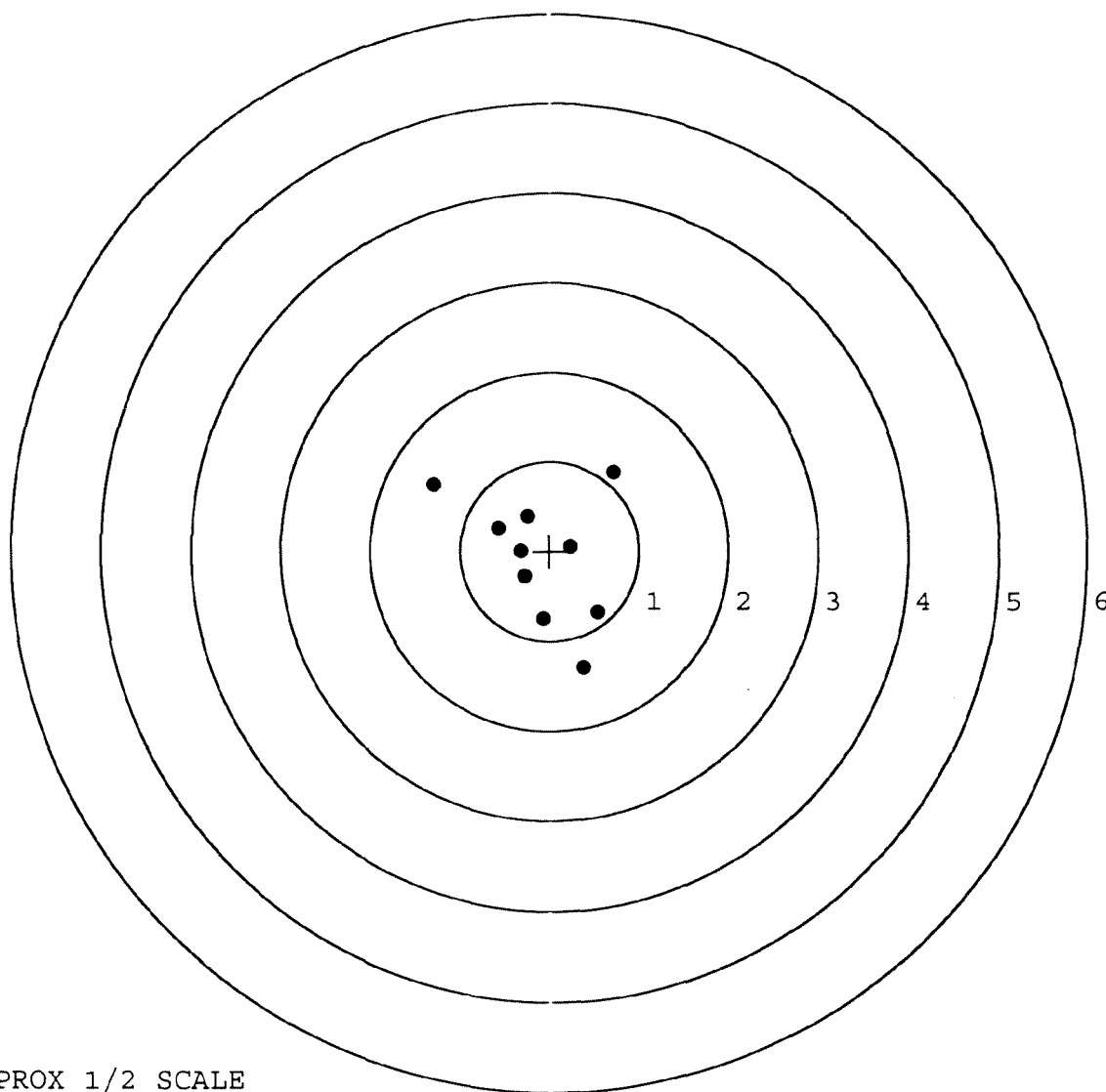
MAX RADIUS: 1.447

MEAN RADIUS: 0.752

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

BARBER - M24 0027131

SERIAL NUMBER: C6523384. __0

TARGET NUMBER: 2

FILE DATE: 09/04/2008

FILE TIME: 11:57

POINT#	X	Y
1:	-0.450	-0.408
2:	-0.749	-0.064
3:	-0.565	0.139
4:	0.155	-0.475
5:	0.236	-0.278
6:	0.267	-0.063
7:	0.395	0.163
8:	0.032	0.184
9:	-0.006	0.449
10:	0.230	0.515

X CENTROID: -0.045

Y CENTROID: 0.016

POA TO CENTROID: 0.048

HORZ SPREAD: 1.144

VERT SPREAD: 0.990

GROUP SPREAD: 1.166

MIN RADIUS: 0.185

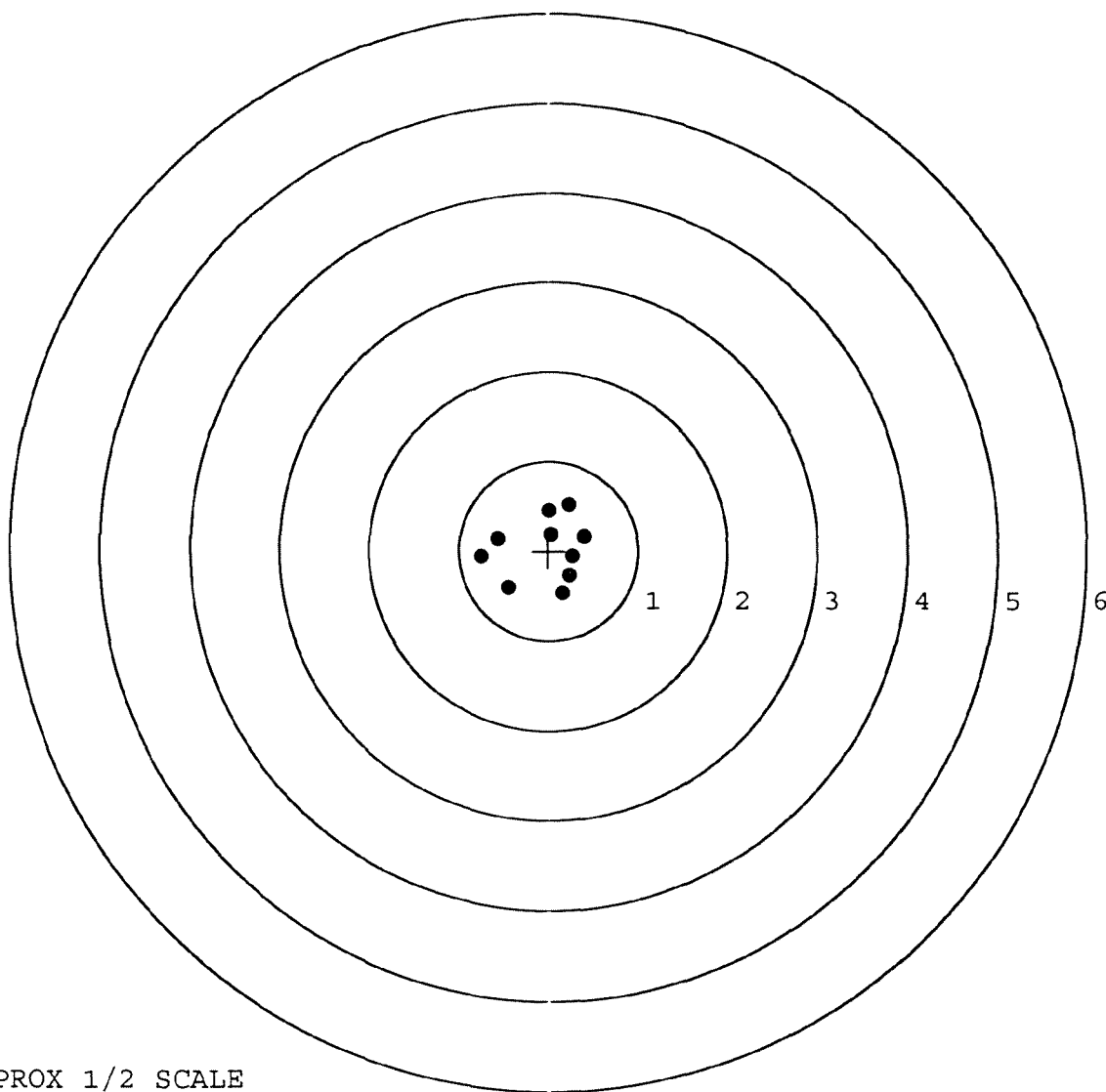
MAX RADIUS: 0.708

MEAN RADIUS: 0.474

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6523384. 0

TARGET NUMBER: 3

FILE DATE: 09/04/2008

FILE TIME: 11:57

POINT#	X	Y
1:	-0.974	-0.624
2:	-0.423	-0.527
3:	-0.565	-0.143
4:	-0.161	0.054
5:	-0.005	-0.184
6:	0.512	0.421
7:	0.610	0.094
8:	0.654	-0.696
9:	1.502	0.049
10:	-0.543	-0.359

X CENTROID: 0.061

Y CENTROID: -0.192

POA TO CENTROID: 0.201

HORZ SPREAD: 2.476

VERT SPREAD: 1.117

GROUP SPREAD: 2.566

MIN RADIUS: 0.066

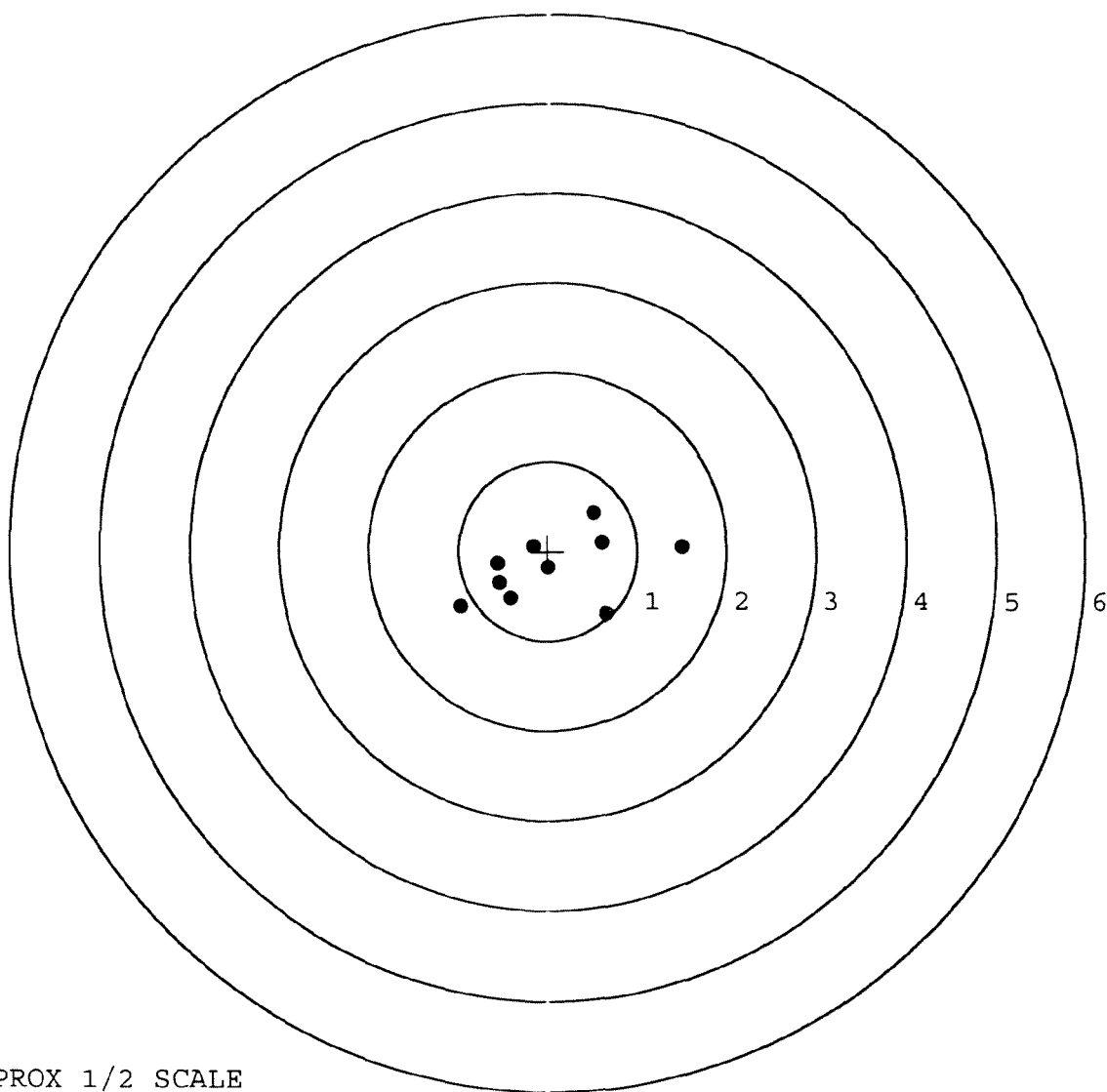
MAX RADIUS: 1.461

MEAN RADIUS: 0.698

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6523384. 0

TARGET NUMBER: 4

FILE DATE: 09/04/2008

FILE TIME: 11:57

X CENTROID: 0.139

Y CENTROID: 0.183

POA TO CENTROID: 0.230

HORZ SPREAD: 2.059

VERT SPREAD: 1.503

GROUP SPREAD: 2.386

MIN RADIUS: 0.011

MAX RADIUS: 1.331

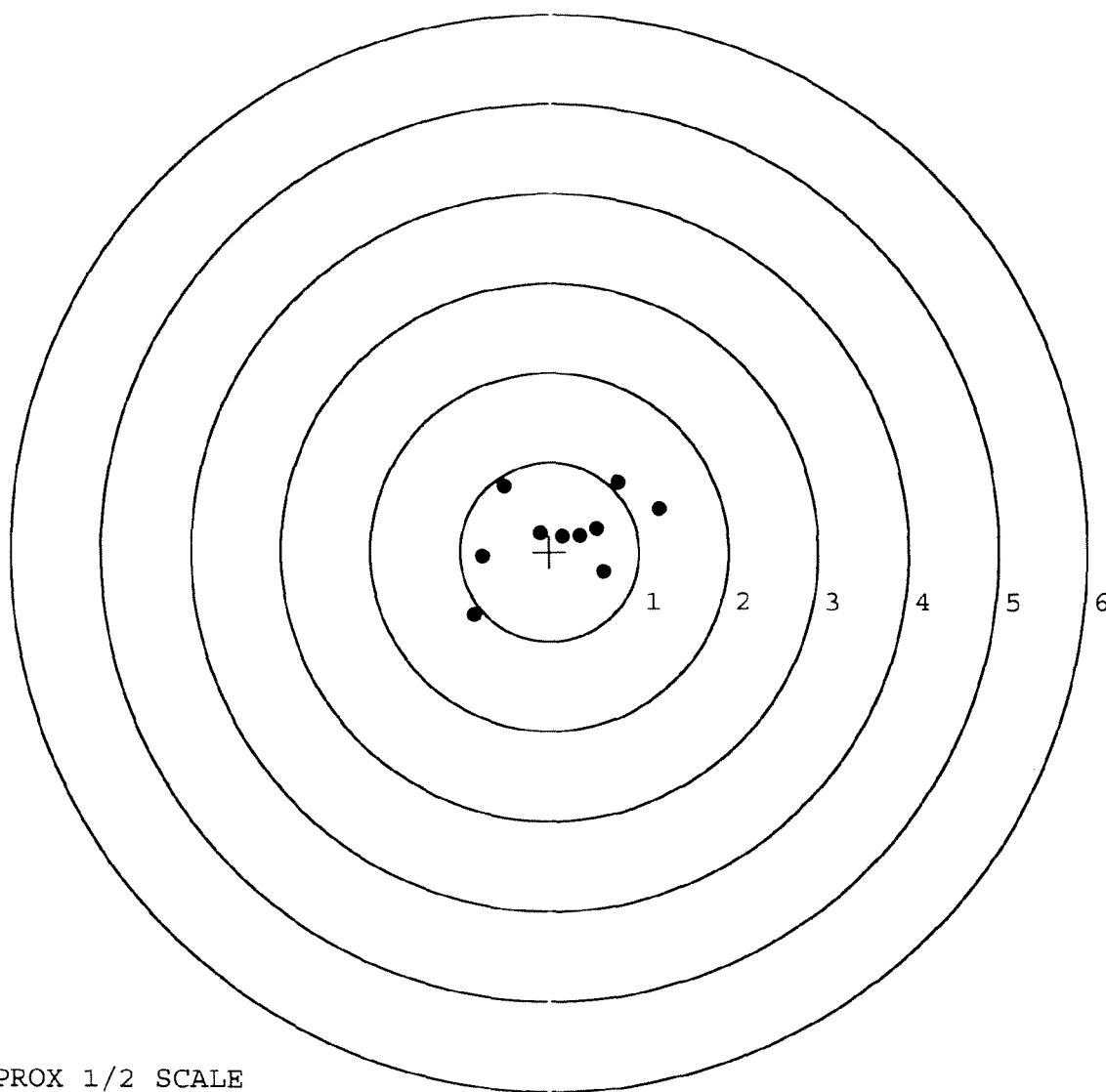
MEAN RADIUS: 0.656

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.511	0.738
2:	-0.750	-0.057
3:	-0.839	-0.720
4:	-0.104	0.209
5:	0.145	0.174
6:	0.521	0.260
7:	0.606	-0.226
8:	1.220	0.485
9:	0.761	0.783
10:	0.343	0.184



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6523384. __0

TARGET NUMBER: 5

FILE DATE: 09/04/2008

FILE TIME: 11:57

POINT#	X	Y
1:	-0.958	0.611
2:	-0.635	0.101
3:	-0.024	-0.630
4:	0.405	-0.151
5:	0.413	-0.008
6:	0.484	0.156
7:	0.692	0.481
8:	0.542	0.661
9:	0.316	0.532
10:	0.127	0.230

X CENTROID: 0.136

Y CENTROID: 0.198

POA TO CENTROID: 0.241

HORZ SPREAD: 1.650

VERT SPREAD: 1.291

GROUP SPREAD: 1.655

MIN RADIUS: 0.033

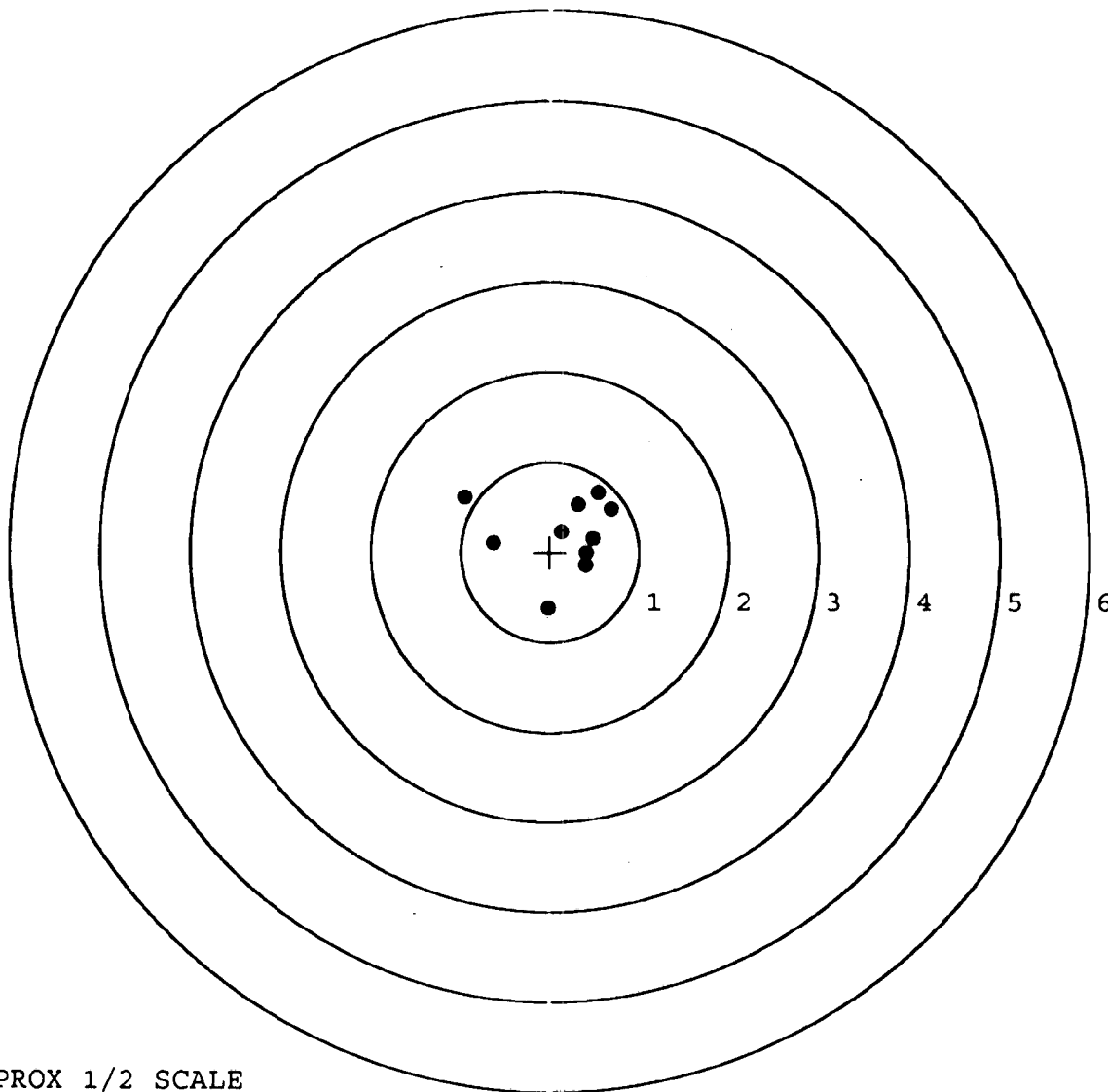
MAX RADIUS: 1.169

MEAN RADIUS: 0.558

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

Remington® **DU PONT**
REG. U.S. PAT. & TM. OFF.

MODEL 700™ M24

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

01

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

SERIAL NO.
 C6523384

ORDER NO.
 5716

5716 C6523384

UPC

0 47700 25716 7

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6523384

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	9 24	90	RW
600	Proof	9 24	90	RW
607	Check Headspace	9 24	90	RW
610	Dis-assemble Gun	9 24	90	RW
612	Magnaflux Barrel Action		9-25-90	KR
	Magnaflux Bolt		9-25-90	KR
615	Rollmark Caliber		9-25-90 S.S.	○
617	Drill and Tap Sight Holes		9-25-90	FB
618	Polish Barrel <i>RB</i>		9/26/90	WB
620	Apply Coatings (Barrel Action)		10-2-90	TS*
	Apply Coating (Bolt)		10-2-90	TS*
625	Final Assembly A) Clean inside of Bolt Assembly		10/9/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/9/90	RW
	C) Inspect Ejector Hole for Chamfer		10/9/90	RW
	D) Oil Firing Pin Ass'y		10/9/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		10/11/90	JL

op. #	OP. NAME	READINGS			DATE	INIT		
635 cont.	F) Safety On Force	4 1/2	4 1/2	4 1/4	11/1/90	WLB		
	G) Safety Off Force	2 1/2	2 1/2	2 1/2	11/1/90	WLB		
	H) Trigger Pull Test & Retainability				11/1/90	98		
	I) Firing Pin Indent	.0215	.021	.021	11/1/90	WLB		
	J) Assemble Stock				11/1/90	RW		
	K) Assemble Swivel Studs				11/19/90	98		
	L) Attach Front and Rear Sight Assemblies				11/1/90	RW		
	M) Iron Sight Alignment				11/1/90	RW		
	N) Detach Front & Rear Sights & place in numbered container				11/1/90	RW		
	O) Attach Scope to Rifle				11/1/90	RW		
	P) Detach & Attach Scope 20 Times				11/1/90	RW		
640	Gallery Target & Test				11/1/90	NF		
	A) Time				"	NF		
	B) Malfunctions				"	NF		
	C) Pierced Primers				"	NF		
	D) Optical Clarity of Scope				"	NF		
645	Inspect for Live Ammo				11/1/90	NF		
655	Final Inspection							
	A) Headspace				11/19/90	98		
	B) Trigger Pull	2.64	249	273	276	265	11/19/90	98
	C) Function						11/19/90	98
660	Pack						12/18/90	NF

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C652384
2 Nov 1990

CENTROIDAL DISTANCES

0 TO 1	.0730068
1 TO 2	.184133
1 TO 3	.150652
1 TO 4	.137594
1 TO 5	.16315

* <----POA

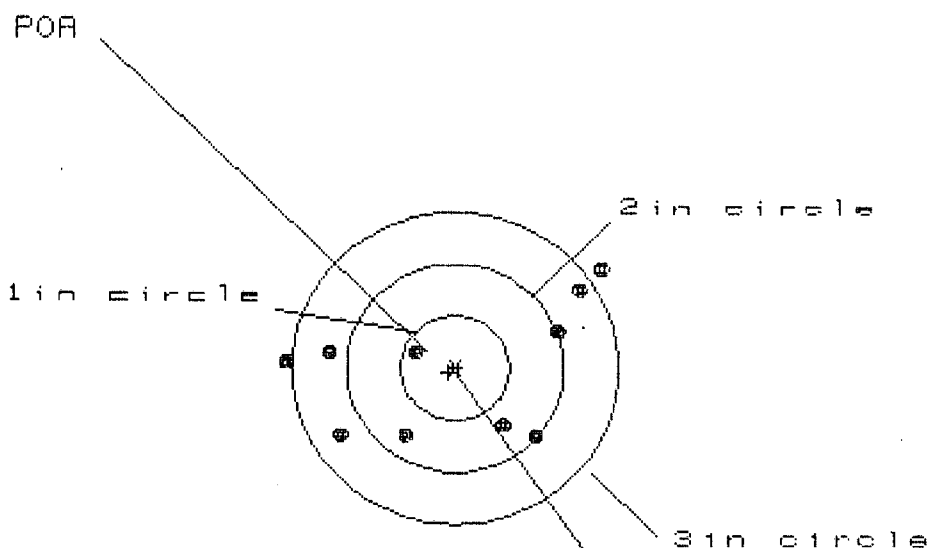
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .077
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.066
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .101415

THE AMR FOR THIS RIFLE IS: 1.049

2 May 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C65233B4

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 4

3 in = 8

IS= 2.921

VS= 1.626

GS= 3.056

CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.377	1.245	1.071
MINIMUM X	-1.544	-1.391	-1.199
MAXIMUM Y	.960	.872	.893
MINIMUM Y	-.666	-.559	-.538
CENTROID X	.059	-.094	.080
CENTROID Y	.043	-.064	-.084
POA TO CENTROID in.	.073	.114	.116
MIN RADIUS	.429	.382	.518
MEAN RADIUS	1.102	1.015	.962
MAX RADIUS	1.679	1.520	1.395
HORIZONTAL SPREAD	2.921	2.636	2.270
VERTICAL SPREAD	1.626	1.431	1.431
EXTREME SPREAD	3.056	2.728	2.594
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	8		

2 Nov 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6523384

CENTERFIRE PATTERNS

2

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS- 10

IN CIR

1 in = 1

2 in = 5

3 in = 8

HS= 2.660

VS= 1.847

GS= 3.067

PATTERN #	2
SHOTS (BEST OF)	10
MAXIMUM X	1.147
MINIMUM X	-1.512
MAXIMUM Y	1.060
MINIMUM Y	-.787
CENTROID X	.202
CENTROID Y	-.073
POA TO CENTROID in.	.214
MIN RADIUS	.493
MEAN RADIUS	.992
MAX RADIUS	1.583
HORIZONTAL SPREAD	2.660
VERTICAL SPREAD	1.847
EXTREME SPREAD	3.067
NUMBER IN ONE INCH CIRCLE =	1
NUMBER IN TWO INCH CIRCLE =	5
NUMBER IN THREE INCH CIRCLE =	8

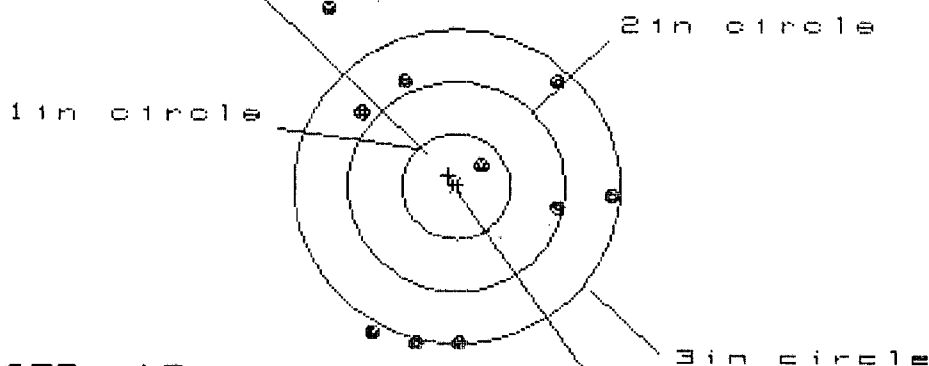
2 Nov 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6523384

CENTERFIRE PATTERNS

3

POA



OF SHOTS - 10

IN CIR

1in = 1

2in = 2

3in = 7

HS = 2.617

VS = 3.212

GS = 3.438

CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.457	1.328	1.221
MINIMUM X	-1.160	-1.035	-1.142
MAXIMUM Y	1.675	1.235	1.088
MINIMUM Y	-1.537	-1.351	-1.498
CENTROID X	.073	.202	.309
CENTROID Y	-.107	-.293	-.146
POA TO CENTROID in.	.130	.356	.342
MIN RADIUS	.305	.393	.231
MEAN RADIUS	1.296	1.203	1.135
MAX RADIUS	2.038	1.463	1.525
HORIZONTAL SPREAD	2.617	2.363	2.363
VERTICAL SPREAD	3.212	2.586	2.586
EXTREME SPREAD	3.438	2.905	2.778
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	2		
NUMBER IN THREE INCH CIRCLE =	7		

2 Nov 1938

FILE:/PATTERNING/CENTERFIRE_PATT/C6523384

CENTERFIRE PATTERNS # 4

POA

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in - 1

2 in - 7

3 in = 10

HS- 2.039

VS= 1.974

GS= 2.282

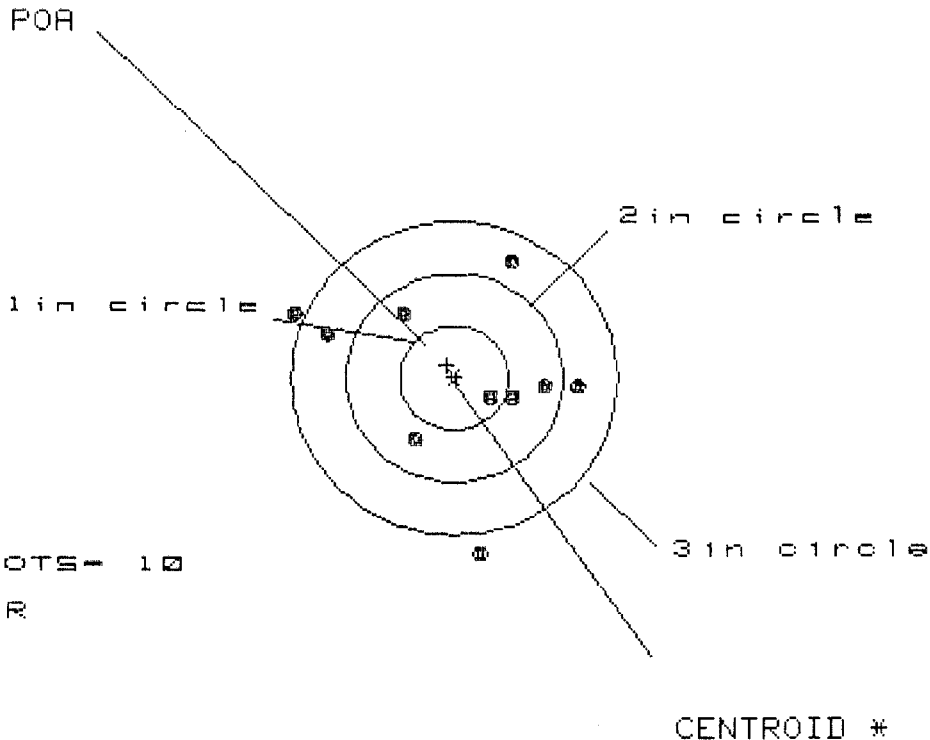
CENTROID #

PATTERN #	4		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.064	.723	.736
MINIMUM X	-.975	-.856	-.843
MAXIMUM Y	1.071	1.005	.657
MINIMUM Y	-.903	-.969	-.843
CENTROID X	-.015	-.134	-.147
CENTROID Y	-.073	-.007	-.133
POA TO CENTROID in.	.075	.134	.198
MIN RADIUS	.421	.292	.320
MEAN RADIUS	.846	.787	.757
MAX RADIUS	1.220	1.098	.996
HORIZONTAL SPREAD	2.039	1.579	1.579
VERTICAL SPREAD	1.974	1.974	1.500
EXTREME SPREAD	2.282	2.015	1.912
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		10	

2 Nov 1998

FILE:/PATTERNING/CENTERFIRE_PATT/06523384

CENTERFIRE PATTERNS # 5



PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.088	1.110	.928
MINIMUM X	-1.472	-1.450	-1.372
MAXIMUM Y	1.075	.892	.941
MINIMUM Y	-1.646	-.745	-.696
CENTROID X	.066	.044	.226
CENTROID Y	-.120	.063	.014
POA TO CENTROID in.	.137	.077	.226
MIN RADIUS	.395	.520	.366
MEAN RADIUS	1.009	.940	.828
MAX RADIUS	1.658	1.502	1.401
HORIZONTAL SPREAD	2.560	2.560	2.300
VERTICAL SPREAD	2.721	1.637	1.637
EXTREME SPREAD	2.774	2.635	2.348
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. C6623384

DATE 11/1/90

TESTER JLP

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.39	2.34	2.25	2.64	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.51	2.12	2.22	2.49	
PULL #3	2.41	2.39	2.32	2.73	
PULL #4	2.47	2.36	2.30	2.76	
PULL #5	2.45	2.34	2.36	2.65	
TOTAL	12.23	11.55	11.45		
AVG.	2.446	2.31	2.29		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.35	3.38		
PULL #2	3.42	3.37		
PULL #3	3.42	3.37		
PULL #4	3.38	3.37		
PULL #5	3.33	3.25		
TOTAL	16.9	16.74		
AVG.	3.38	3.348		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.17	4.38		4.12
PULL #2	4.14	4.31		4.23
PULL #3	4.26	4.23		4.40
PULL #4	4.30	4.30		4.31
PULL #5	4.32	4.42		4.36
TOTAL	21.19	21.64		21.42
AVG.	4.238	4.328		4.284

BARBER M24-0027145 RECEIVING AND ESTIMATING REPORT

COMMENTS

ORDER
R 94-18400

INITIAL FDC	CUSTOMER ORDER NO. DAAA09-92-C-0834	W/10X SCOPE, M-24 SNIPER, W/DEPLOYMENT KIT ATTN: FRED MARTIN <i>SCOPE 90-0975</i>			
DATE RECEIVED 06/11/94	DATE OPENED 06/11/94	DATE CODE	SERIAL NUMBER C6523384	NEW SERIAL NUMBER	MODEL AND GRADE 700 7.62 NATO
ACCESSORIES SLING STRAP HARD CASE SCOPE MNTS SCOPE BASE					

FROM:

SHIP TO:

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

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

CUST NO: 098397 C.O.D L

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

COMMENTS

Trigger Assy \$173.31
CTL 50.00
\$223.31

REPAIRMAN PROOF CLEAN TEST TARGET PATTERN

GALLERY TESTER DATE DATE DATE DATE DATE DATE

OFFICE COPY

RD6925 REV. 1/94

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

BARBER - M24 0027145

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C6523384DATE 11-30-94TESTER B.M.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.44	2.46	2.68		MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.66	2.47	2.69		
PULL #3	2.52	2.46	2.69		
PULL #4	2.55	2.46	2.67		
PULL #5	2.53	2.46	2.64		
TOTAL	12.70	12.25	13.37		
AVG.	2.54	2.45	2.67		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.22	3.16		
PULL #2	3.26	3.20		
PULL #3	3.08	3.21		
PULL #4	3.26	3.21		
PULL #5	3.25	3.22		
TOTAL	16.09	16.00		
AVG.	3.22	3.20		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.09	4.13		4.29
PULL #2	4.14	4.16		4.31
PULL #3	4.14	4.17		4.06
PULL #4	4.11	4.14		4.27
PULL #5	4.15	4.16		4.29
TOTAL	20.63	20.77		21.22
AVG.	4.13	4.15		4.24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6523384

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	5 1/4	5 1/4	5 1/4			12/4	WB
	G) Safety Off Force	3	2 3/4	2 3/4			12/4	WB
	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 Clarity of Scope							
645	Inspect for Live Ammo							
655	Final Inspection							
	A) Headspace							
	B) Trigger Pull	2.80	2.70	2.83	2.80	2.80	12/4	WB
	C) Function							
660	Pack							