

C6594486

MODEL 760TM M24

Model **S&S**TM

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

Remington

Remington
MODEL 700™ H24

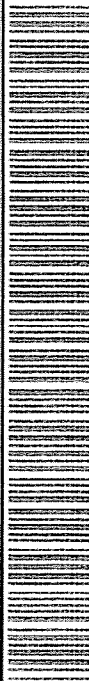
DUPONT
REG. U.S. PAT. & TM. OFF.

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

SERIAL NO.
 06594486

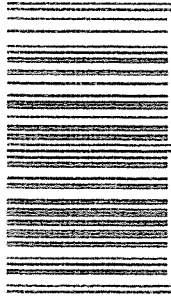
ORDER NO.
 5716

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



5716 06594486

UPC



0 4700 25716 7

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: **RE00089022** Serial: C6594486 Model M24 SWS Center Fire Caliber: 7.62 NATO Repairman: Status: Closed 12/6/2004 7:41:11 AM

Verify Repair

Address Information

Customer: ☒ Received From Return To: ☐ Received From

Name: **TRANSPORTATION OFFICER** **TRANSPORTATION OFFICER**

Address 1: **DEF DIST DEPOT ANNISTON AL** **DEF DIST DEPOT ANNISTON AL**

Address 2: PO Box: PO Box:

City: **ANNISTON** **ANNISTON**

State: **AL** Zip Code: **36201** Country: **US** State: **AL** Zip Code: **36201** 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
A006	Sling Strap	1
A007	With Stud	3
A010	Hard Case	1
A017	Scope Base	1
A026	Scope	1
A055	Deployment Kit	1
C000	FRT AND REAR SGT	1
C001	SCOPE CASE	1

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

logletj 12/6/2004 8:51 AM CAPS NUM INS SCPL

start 2 2 2 2 2 2 2 2

Serial Number: **C6594486**

Model: **M24 SWS**



RE00089022

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6594486.__0
FILE DATE AND TIME: 01/11/2005 11:24

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.000
The Average Y Centroid of the Five Target Set:	-0.093
The Average Point of Impact of the Five Target Set:	0.093
The Average Mean Radius of the Five Target Set:	0.573
The Distance from POA to Centroid Target #1:	0.114
The Distance from Centroid Target #2 to Centroid Target #1:	0.182
The Distance from Centroid Target #3 to Centroid Target #1:	0.237
The Distance from Centroid Target #4 to Centroid Target #1:	0.050
The Distance from Centroid Target #5 to Centroid Target #1:	0.166

SERIAL NUMBER: C6594486. __0

TARGET NUMBER: 1

FILE DATE: 01/11/2005

FILE TIME: 11:24

POINT#	X	Y
1:	0.781	0.028
2:	0.485	-0.055
3:	0.363	-0.263
4:	0.303	0.257
5:	-0.112	0.259
6:	-0.215	0.106
7:	-0.765	0.043
8:	-0.239	-0.138
9:	-0.561	-0.334
10:	-0.518	-0.936

X CENTROID: -0.048

Y CENTROID: -0.103

POA TO CENTROID: 0.114

HORZ SPREAD: 1.546

VERT SPREAD: 1.195

GROUP SPREAD: 1.618

MIN RADIUS: 0.194

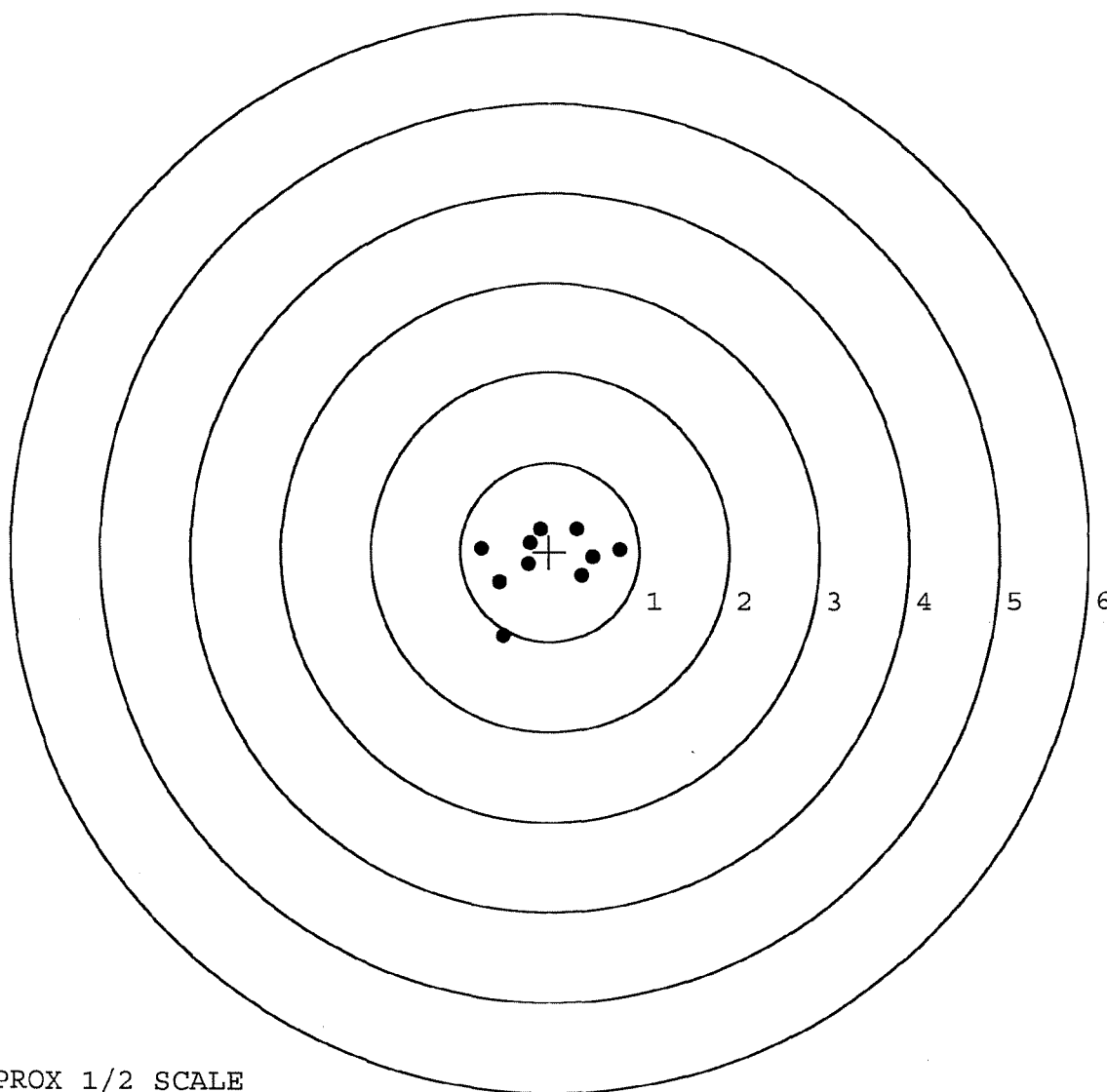
MAX RADIUS: 0.956

MEAN RADIUS: 0.540

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6594486. __0

TARGET NUMBER: 2

FILE DATE: 01/11/2005

FILE TIME: 11:24

POINT#	X	Y
1:	0.796	0.394
2:	0.642	0.273
3:	0.514	-0.427
4:	-0.468	-0.574
5:	-0.260	-0.124
6:	-0.480	0.551
7:	-0.298	0.605
8:	-0.585	0.122
9:	-0.681	-0.097
10:	-0.420	-0.100

X CENTROID: -0.124

Y CENTROID: 0.062

POA TO CENTROID: 0.139

HORZ SPREAD: 1.477

VERT SPREAD: 1.179

GROUP SPREAD: 1.592

MIN RADIUS: 0.231

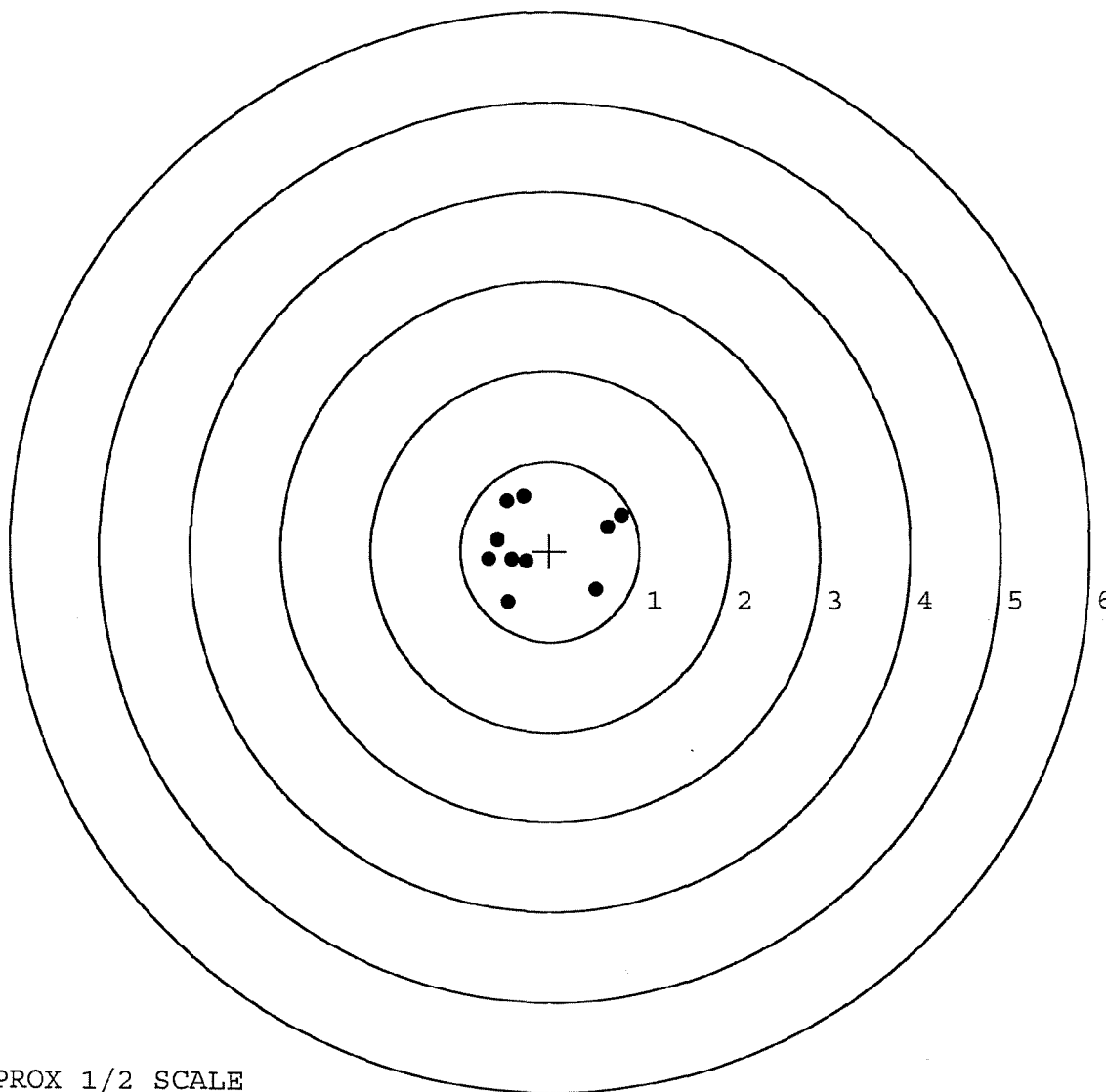
MAX RADIUS: 0.978

MEAN RADIUS: 0.609

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6594486. __0

TARGET NUMBER: 3

FILE DATE: 01/11/2005

FILE TIME: 11:24

X CENTROID: 0.128

Y CENTROID: -0.262

POA TO CENTROID: 0.292

HORZ SPREAD: 1.198

VERT SPREAD: 1.132

GROUP SPREAD: 1.287

MIN RADIUS: 0.125

MAX RADIUS: 0.711

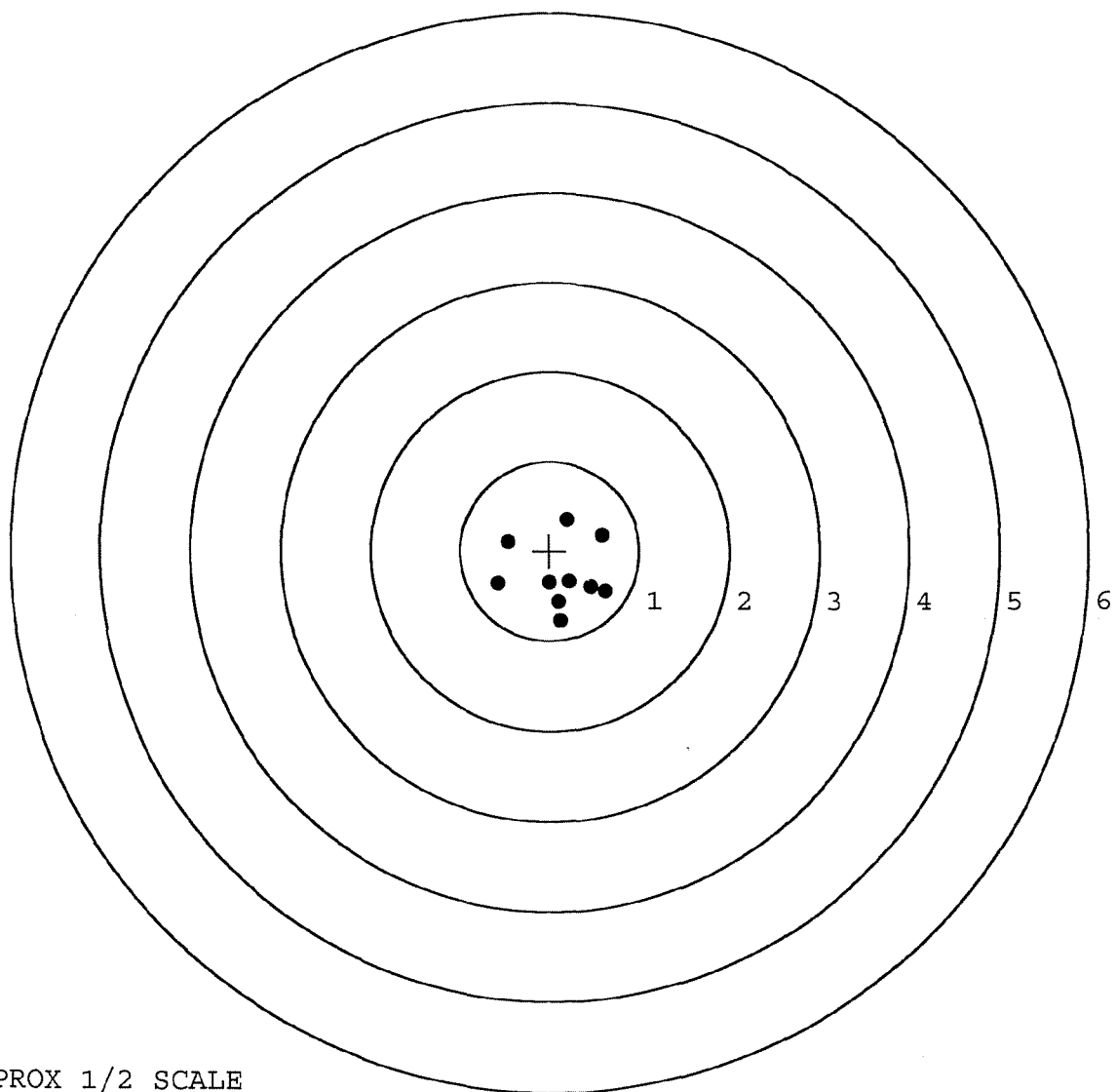
MEAN RADIUS: 0.467

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.590	0.184
2:	0.196	0.347
3:	-0.461	0.104
4:	-0.576	-0.361
5:	0.622	-0.441
6:	0.465	-0.398
7:	0.222	-0.345
8:	-0.004	-0.359
9:	0.103	-0.567
10:	0.126	-0.785



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6594486. __0

TARGET NUMBER: 4

FILE DATE: 01/11/2005

FILE TIME: 11:24

POINT#	X	Y
1:	0.730	0.369
2:	0.180	0.241
3:	0.004	0.613
4:	-0.985	0.062
5:	-0.653	-0.530
6:	0.324	-0.092
7:	-0.010	-0.310
8:	-0.143	-0.478
9:	-0.124	-0.684
10:	0.223	-0.727

X CENTROID: -0.045

Y CENTROID: -0.154

POA TO CENTROID: 0.160

HORZ SPREAD: 1.715

VERT SPREAD: 1.340

GROUP SPREAD: 1.742

MIN RADIUS: 0.160

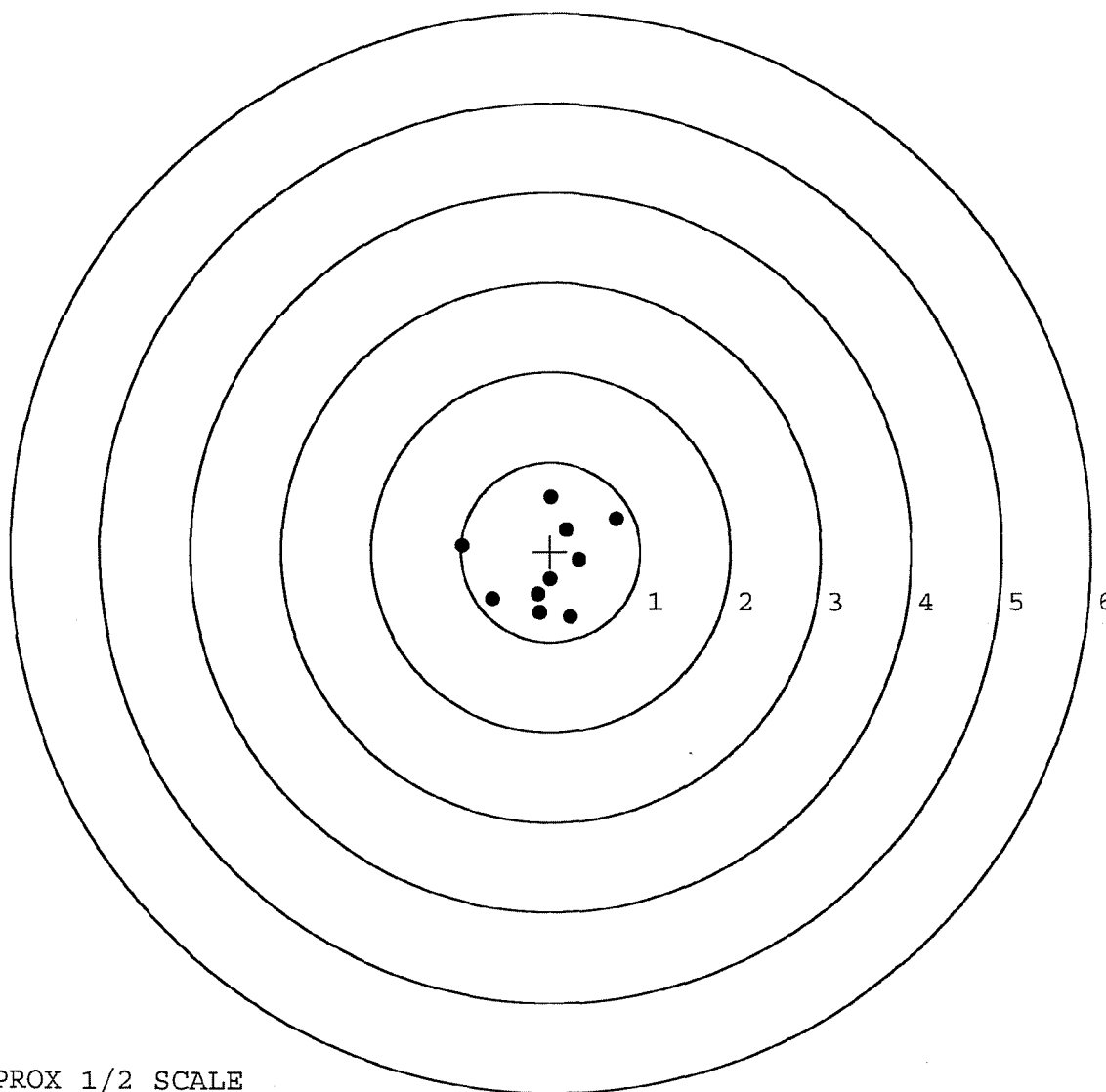
MAX RADIUS: 0.964

MEAN RADIUS: 0.588

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6594486. __0

TARGET NUMBER: 5

FILE DATE: 01/11/2005

FILE TIME: 11:24

POINT#	X	Y
1:	0.908	0.750
2:	0.267	0.644
3:	0.629	0.201
4:	0.581	-0.347
5:	0.148	-0.232
6:	-0.239	-0.271
7:	-0.239	0.030
8:	-1.293	-0.281
9:	-0.362	-0.714
10:	0.488	0.128

X CENTROID: 0.089

Y CENTROID: -0.009

POA TO CENTROID: 0.089

HORZ SPREAD: 2.201

VERT SPREAD: 1.464

GROUP SPREAD: 2.431

MIN RADIUS: 0.231

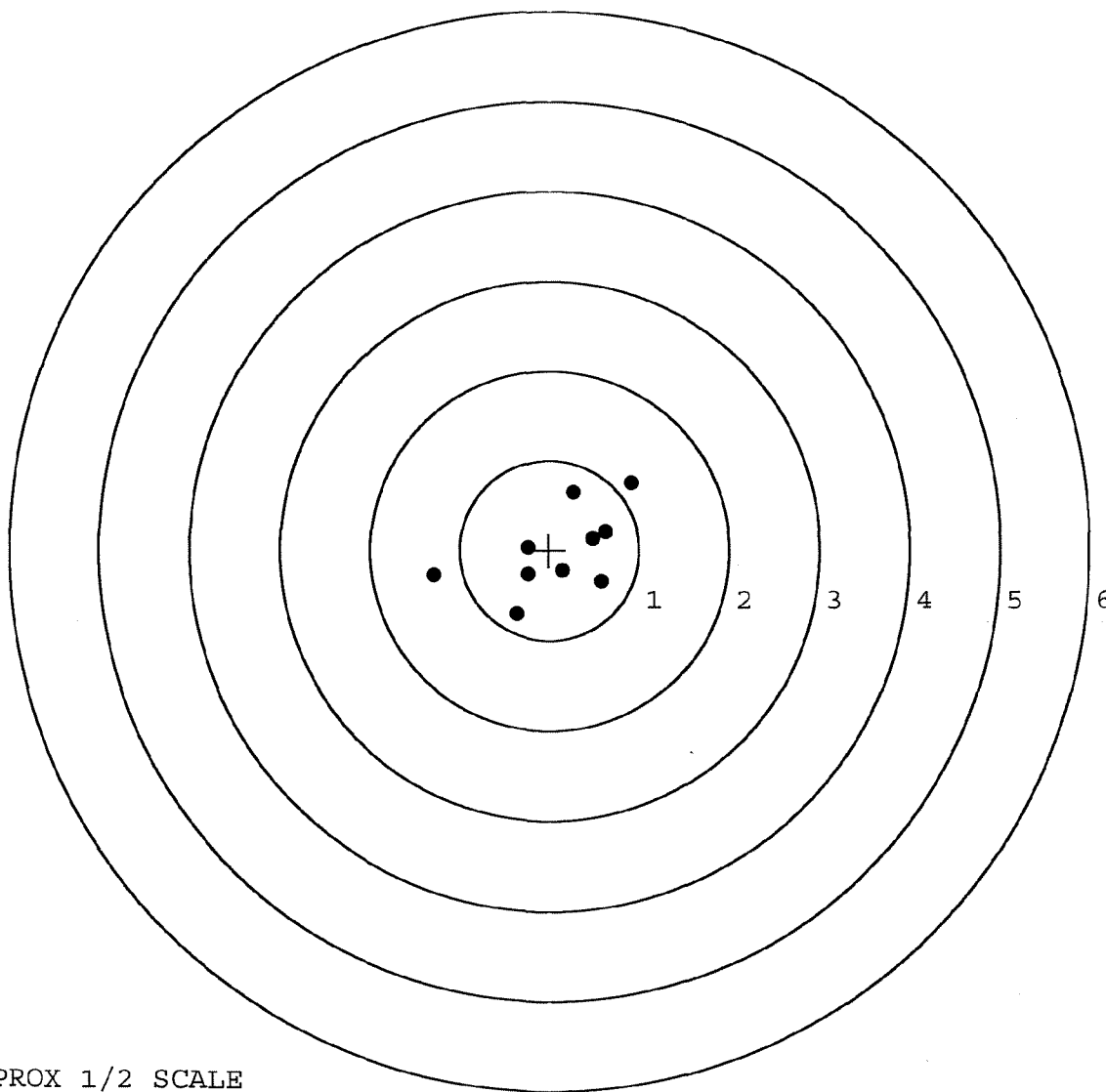
MAX RADIUS: 1.408

MEAN RADIUS: 0.662

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

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

R & E NUMBER	89022		
SERIAL NUMBER	C6594486		
LOG-IN DATE	12-6-04		
INSPECT AND VERIFY:			
OPERATION #	OPERATION NAME	DATE	INITIAL
550	DIS-ASSEMBLE GUN	12-7-04	RTZ
560 A	RE-BARREL	12-15-04	RTZ
B	DRILL AND TAP	12-27-04	TRW
575	ASSEMBLE	12-16-04	RTZ
600	PROOF	12-16-04	RTZ
605	CHECK HEADSPACE	12-16-04	RTZ
610	DIS-ASSEMBLE GUN	12-27-04	RTZ
612	MAGNAFLUX	OPERATOR	
615	ROLLMARK CALIBER	12-27-04	CW
618	ROTO-BLAST	12/28/04	DG
620	APPLY COATINGS	1/3/05	#P
625 A	FINAL ASSEMBLY	1-7-05	RTZ
B	TRIGGER PULL TEST	N/A	
C	SAFETY "ON" FORCE		
D	SAFETY "OFF" FORCE		
E	FIRING PIN INDENT		
640	TARGET	1-11-05	TRW
655	FINAL INSPECT	1-12-05	AC
660	PACK	3-1-05	DA
		SHIP DATE	
		QAR INSPECTION DATE	

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6594486

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	1240 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		1-7-91	KR
615	Rollmark Caliber		11	JS.
617	Drill and Tap Sight Holes	1 10 91		KB
618	Polish Barrel	1 10 91		KB
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		1-23-91	JS

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4 1/4	4 1/4	4 1/4			1/23/91	WB
	G) Safety Off Force	2	2	2			1/23/91	WB
	H) Trigger Pull Test & Retainability						1-23-91	JH
	I) Firing Pin Indent	.020	.020	.020			1/23/91	WB
	J) Assemble Stock						1/24/91	RW
	K) Assemble Swivel Studs						2-4-91	K
	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	DH
	A) Time						1-24-91	DH
	B) Malfunctions						1-24-91	DH
	C) Pierced Primers						1-24-91	DH
	D) Optical Clarity of Scope						1-24-91	DH
645	Inspect for Live Ammo						1-24-91	DH
655	Final Inspection							
	A) Headspace						2-4-91	K
	B) Trigger Pull	2.36	2.47	2.27	2.21	2.32	2-1-91	JH
	C) Function						2-4-91	AC
660	Pack						3-19-91	N

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

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

SERIAL NO. 06594486

DATE 1-23-91

TESTER JL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.20	2.29	2.15	2.36	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.52	2.19	2.19	2.42	
PULL #3	2.36	2.24	2.31	2.27	
PULL #4	2.49	2.32	2.30	2.21	
PULL #5	2.25	2.20	2.30	2.32	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.25	3.28		
PULL #2	3.34	3.32		
PULL #3	3.44	3.45		
PULL #4	3.39	3.40		
PULL #5	3.48	3.20		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.21	4.26		4.28
PULL #2	4.26	4.20		4.26
PULL #3	4.25	4.46		4.20
PULL #4	4.26	4.39		4.20
PULL #5	4.21	4.39		4.25
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6594486
25 Jan 1991

CENTROIDAL DISTANCES

Ø TO	1	.143098
1 TO	2	.424438
1 TO	3	.26524
1 TO	4	.114978
1 TO	5	.171172

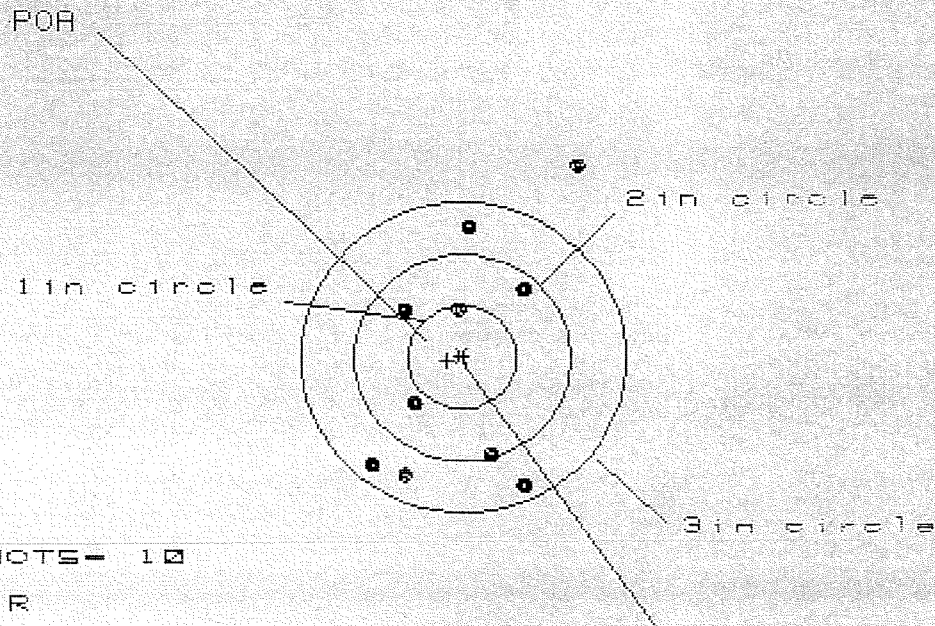
234 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0394
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0728
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .082778
THE AMR FOR THIS RIFLE IS: 1.04

25 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C85944B6

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 9

HS= 1.873

VS= 3.155

GS= 3.468

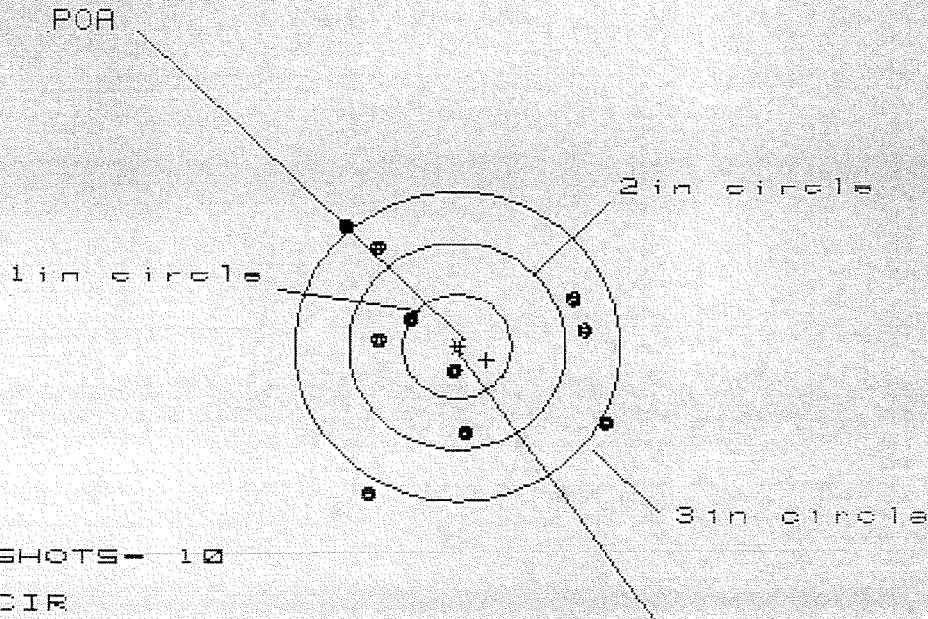
CENTROID #

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.032	.715	.796
MINIMUM X	:	-.841	-.727	-.646
MAXIMUM Y	:	1.898	1.487	1.357
MINIMUM Y	:	-1.257	-1.046	-1.057
CENTROID X	:	.139	.025	-.056
CENTROID Y	:	.034	-.177	-.047
POA TO CENTROID in.	:	.143	.179	.073
MIN RADIUS	:	.424	.397	.428
MEAN RADIUS	:	1.101	.958	.912
MAX RADIUS	:	2.161	1.493	1.373
HORIZONTAL SPREAD	:	1.873	1.442	1.442
VERTICAL SPREAD	:	3.155	2.533	2.414
EXTREME SPREAD	:	3.468	2.584	2.482
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

25 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C65944B6

CENTERFIRE PATTERNS # 2



OF SHOTS - 10

IN CIR

1 in = 2

2 in = 4

3 in = 7

HS= 2.383

VS= 2.597

GS= 3.053

CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.384	1.293	1.233
MINIMUM X	:	-.999	-1.090	-.928
MAXIMUM Y	:	1.130	1.023	.912
MINIMUM Y	:	-1.417	-.958	-1.069
CENTROID X	:	-.273	-.182	-.344
CENTROID Y	:	.136	.293	.404
POA TO CENTROID in.	:	.304	.345	.530
MIN RADIUS	:	.238	.414	.340
MEAN RADIUS	:	1.066	1.014	.921
MAX RADIUS	:	1.635	1.567	1.302
HORIZONTAL SPREAD	:	2.383	2.383	2.161
VERTICAL SPREAD	:	2.597	1.981	1.981
EXTREME SPREAD	:	3.053	3.053	2.377
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/C6594486

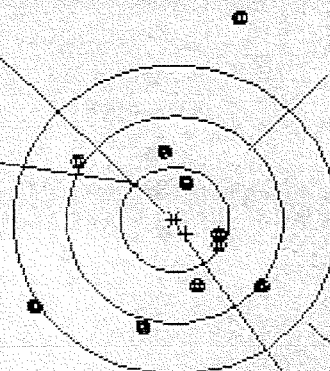
CENTERFIRE PATTERNS # 3

POA

1in circle

2in circle

3in circle



CENTROID *

OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 8

HS= 2.058

VS= 3.033

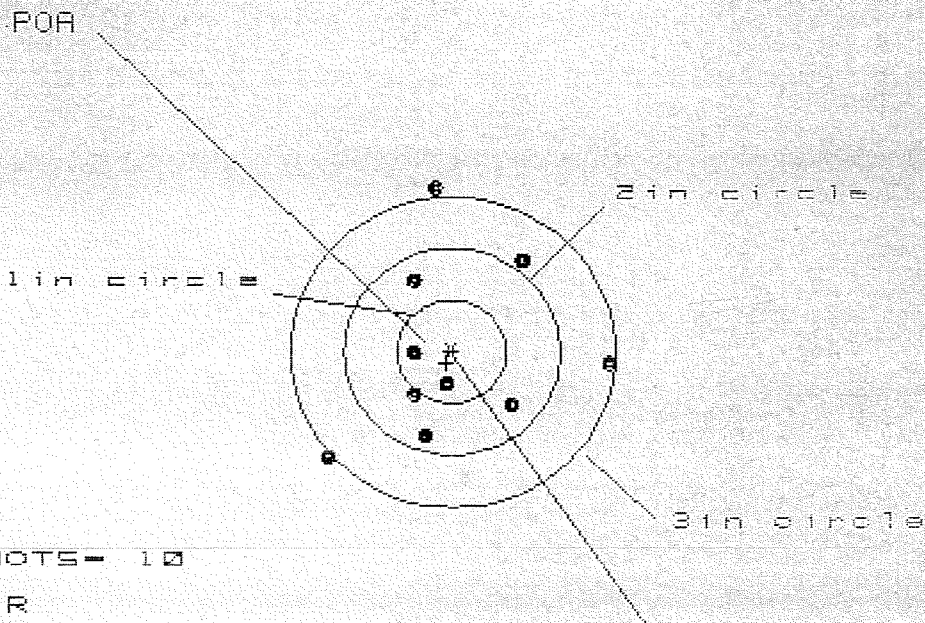
GS= 3.464

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.782	.854	.704
MINIMUM X	:	-1.276	-1.204	-.959
MAXIMUM Y	:	2.003	.855	.773
MINIMUM Y	:	-1.030	-.807	-.889
CENTROID X	:	-.105	-.177	-.027
CENTROID Y	:	.138	-.085	-.003
POA TO CENTROID in.	:	.173	.197	.027
MIN RADIUS	:	.405	.473	.318
MEAN RADIUS	:	.944	.809	.696
MAX RADIUS	:	2.106	1.370	1.186
HORIZONTAL SPREAD	:	2.058	2.058	1.663
VERTICAL SPREAD	:	3.033	1.662	1.662
EXTREME SPREAD	:	3.464	2.068	2.068
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

25 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6594486

CENTERFIRE PATTERNS # 4



OF SHOTS - 10

IN CIR

1 in = 2

2 in = 6

3 in = 9

HS = 2.531

VS = 2.554

GS = 2.726

CENTROID #

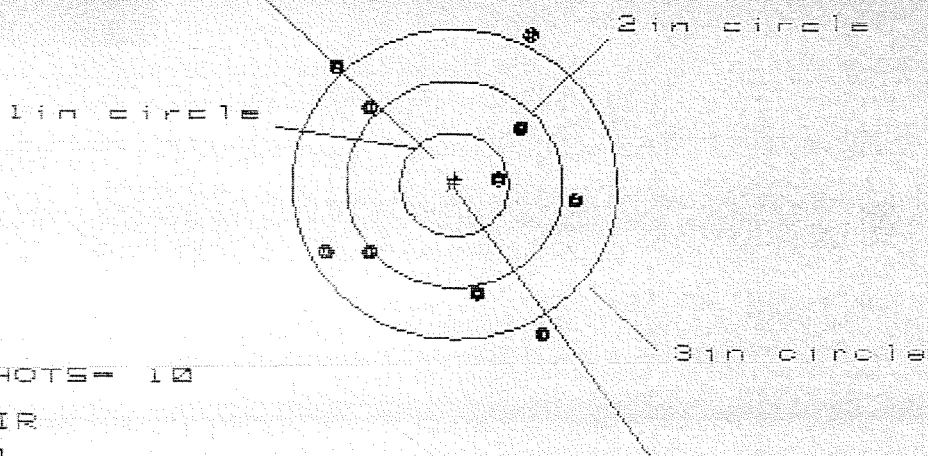
PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.428	1.411	1.271
MINIMUM X	:	-1.103	-1.120	-.520
MAXIMUM Y	:	1.560	1.072	.969
MINIMUM Y	:	-.994	-.821	-.739
CENTROID X	:	.051	.068	.208
CENTROID Y	:	.108	-.065	.038
POA TO CENTROID in.	:	.120	.094	.211
MIN RADIUS	:	.322	.158	.320
MEAN RADIUS	:	.913	.807	.764
MAX RADIUS	:	1.567	1.412	1.272
HORIZONTAL SPREAD	:	2.531	2.531	1.791
VERTICAL SPREAD	:	2.554	1.893	1.708
EXTREME SPREAD	:	2.726	2.681	1.936
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

25 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6534486

CENTERFIRE PATTERNS # 5

FOR



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 2

3 in = 7

HS = 2.340

VS = 2.934

GS = 3.239

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.158	1.249	1.345
MINIMUM X	:	-1.182	-1.091	-.995
MAXIMUM Y	:	1.444	1.278	1.145
MINIMUM Y	:	-1.490	-1.196	-1.036
CENTROID X	:	-.009	-.100	-.196
CENTROID Y	:	-.052	.114	-.046
POA TO CENTROID in.	:	.052	.152	.201
MIN RADIUS	:	.387	.492	.573
MEAN RADIUS	:	1.176	1.115	1.060
MAX RADIUS	:	1.700	1.492	1.438
HORIZONTAL SPREAD	:	2.340	2.340	2.340
VERTICAL SPREAD	:	2.934	2.474	2.181
EXTREME SPREAD	:	3.239	2.821	2.562
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		2	
NUMBER IN THREE INCH CIRCLE	=		7	

RECEIVING AND ESTIMATING REPORT

COMMENTS

ORDER

R 94-18102

INITIAL

CUSTOMER ORDER NO.

FDC

DAAA09-92-C-0834

W/10X SCOPE M-24 SNIPER, W/DEPLOYMENT KIT

ATTN: FRED MARTIN

90-
Scope 0949

DATE RECEIVED

DATE OPENED

DATE CODE

SERIAL NUMBER

NEW SERIAL NUMBER

MODEL AND GRADE

06/09/94

06/09/94

C6594486

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-J.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

BOLT ASSY.

B3

BARREL ASSY.

B4

D1

REC. ASSY.

B5

D2

WOOD

C1

D3

METAL

C2

MAIN FAULT

PARTS

COMMENTS

Trigger Assy \$173.31

CTI 50.00

\$223.31

REPAIRMAN

PROOF

CLEAN

TEST

TARGET

PATTERN

GALLERY TESTER

DATE

DATE

DATE

DATE

DATE

OFFICE COPY

RD6925 REV. 1/94

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

M2400017983

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

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

SERIAL NO. C6594486

DATE 12-4-94

TESTER BM

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.74	2.62	2.58		MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.65	2.67	2.78		
PULL #3	2.61	2.56	2.57		
PULL #4	2.62	2.57	2.76		
PULL #5	2.55	2.54	2.57		
TOTAL	13.17	12.96	13.26		
AVG.	2.63	2.54	2.65		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.08	3.10		
PULL #2	3.28	3.25		
PULL #3	3.25	3.07		
PULL #4	3.14	3.06		
PULL #5	3.20	3.15		
TOTAL	15.95	15.63		
AVG.	3.19	3.12		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.01	4.07		4.22
PULL #2	4.04	3.97		4.04
PULL #3	4.05	3.98		4.00
PULL #4	4.16	4.12		4.06
PULL #5	3.92	4.01		4.08
TOTAL	20.18	20.15		20.40
AVG.	4.03	4.03		4.08

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C 6594486

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 1/2	4 1/2	4 1/2			12/14	WB
	G) Safety Off Force	2 3/4	2 3/4	2 3/4			12/14	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	2.49	2.57	2.64	2.51	2.46	12/14	WB
	C) Function							
660	Pack							