

06594515

MODEL 760™ 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: **RE00089034** Serial: C6594515 Model: M24 SWS Center Fire Caliber: 7.62 NATO Repairman: Status: Closed 12/6/2004 7:55:55 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: **NA** Fax: Email: Comments:

Received Condition: Fair Condition Notes: CSR Notes:

Accessories Received:

Code	Desc	Qty
A006	Sling Strap	1
A007	With Studs	3
A010	Hard Case	1
A026	Scope w/case	1
A055	Deployment Kit	1
A057	Fit and Rear Sgt Base	3

Repair Search Refresh Close

Inqletj 12/6/2004 9:53 AM CAPS NUM IHS SCRL

start 2 2 2 2

Serial Number: **C6594515**

Model: **M24 SWS**



RE00089034

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6594515.___0
FILE DATE AND TIME: 01/11/2005 11:15

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.045
The Average Y Centroid of the Five Target Set:	-0.059
The Average Point of Impact of the Five Target Set:	0.074
The Average Mean Radius of the Five Target Set:	0.626
The Distance from POA to Centroid Target #1:	0.107
The Distance from Centroid Target #2 to Centroid Target #1:	0.207
The Distance from Centroid Target #3 to Centroid Target #1:	0.024
The Distance from Centroid Target #4 to Centroid Target #1:	0.249
The Distance from Centroid Target #5 to Centroid Target #1:	0.227

SERIAL NUMBER: C6594515. 0

TARGET NUMBER: 1

FILE DATE: 01/11/2005

FILE TIME: 11:15

X CENTROID: -0.101

Y CENTROID: 0.035

POA TO CENTROID: 0.107

HORZ SPREAD: 1.661

VERT SPREAD: 2.178

GROUP SPREAD: 2.302

MIN RADIUS: 0.192

MAX RADIUS: 1.435

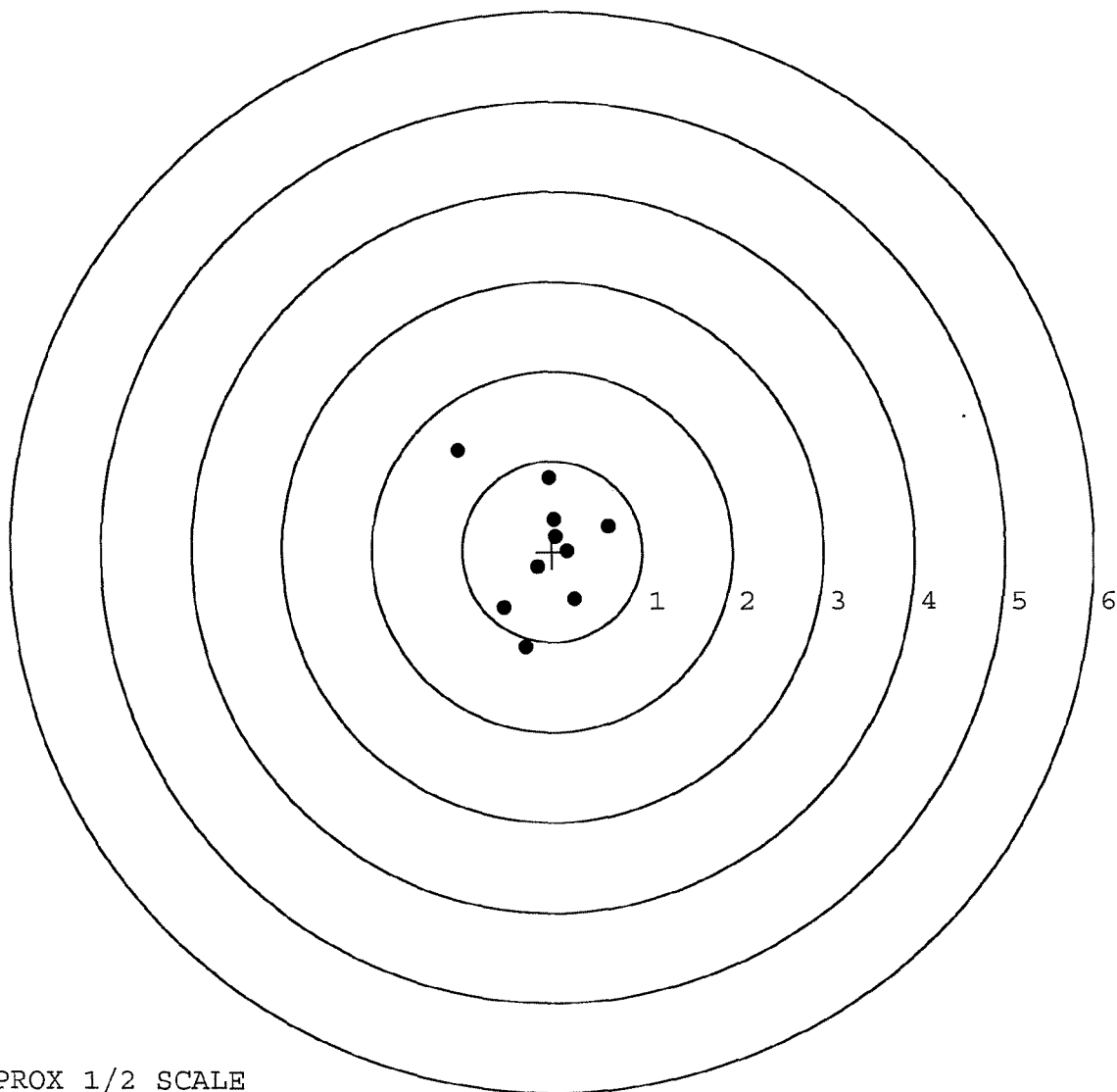
MEAN RADIUS: 0.657

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.301	-1.064
2:	0.252	-0.532
3:	-0.536	-0.623
4:	-0.038	0.820
5:	-1.047	1.114
6:	0.614	0.278
7:	0.020	0.354
8:	0.038	0.168
9:	0.161	0.010
10:	-0.172	-0.176



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6594515.___0

TARGET NUMBER: 2

FILE DATE: 01/11/2005

FILE TIME: 11:15

X CENTROID: 0.103

Y CENTROID: -0.003

POA TO CENTROID: 0.103

HORZ SPREAD: 2.331

VERT SPREAD: 1.563

GROUP SPREAD: 2.350

MIN RADIUS: 0.153

MAX RADIUS: 1.283

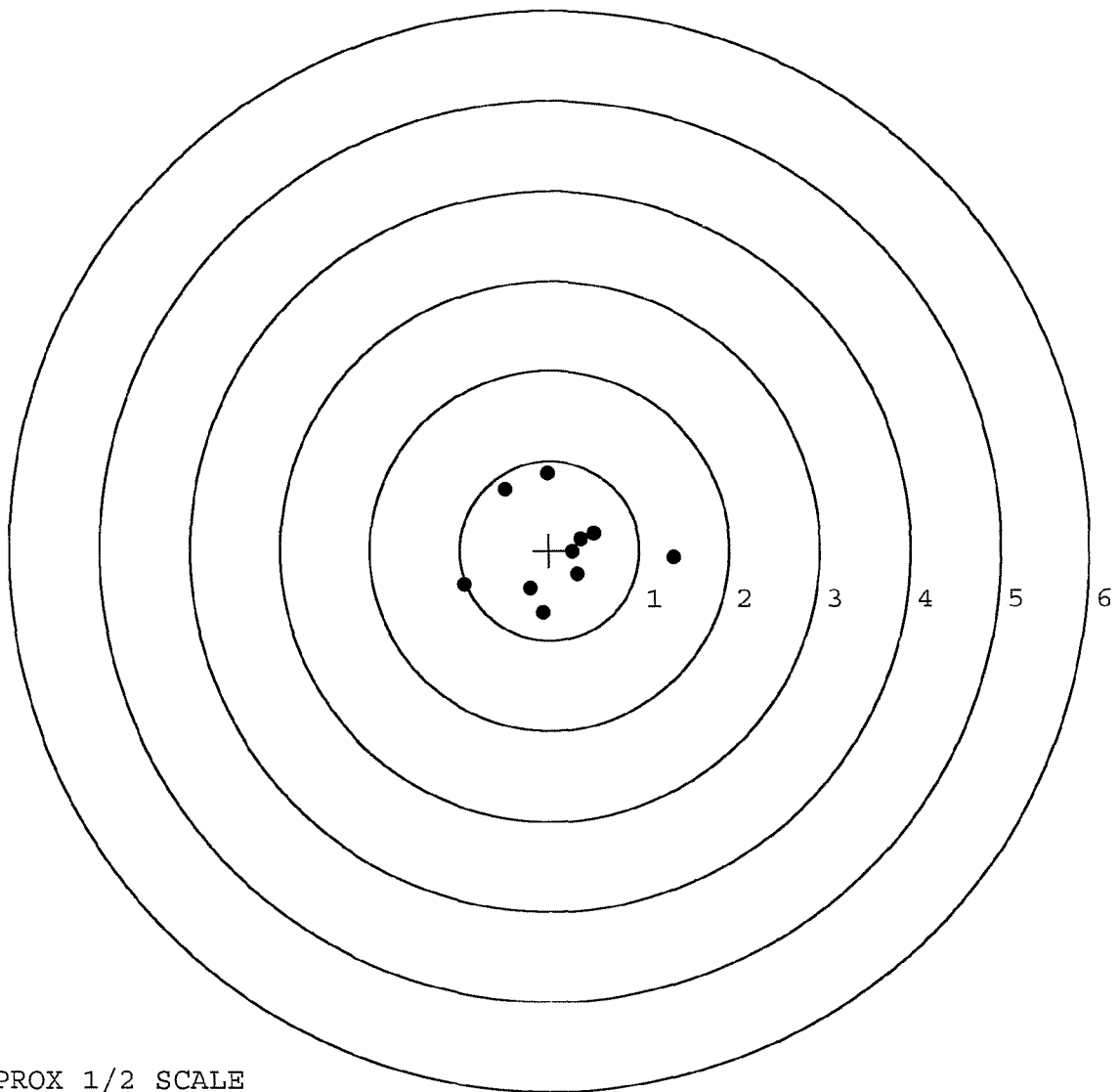
MEAN RADIUS: 0.665

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	1.383	-0.087
2:	-0.079	-0.706
3:	-0.219	-0.428
4:	-0.948	-0.386
5:	-0.025	0.857
6:	-0.495	0.682
7:	0.498	0.192
8:	0.350	0.127
9:	0.255	-0.014
10:	0.308	-0.272



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6594515.___0

TARGET NUMBER: 3

FILE DATE: 01/11/2005

FILE TIME: 11:15

X CENTROID: -0.084

Y CENTROID: 0.053

POA TO CENTROID: 0.099

HORZ SPREAD: 2.044

VERT SPREAD: 2.358

GROUP SPREAD: 2.103

MIN RADIUS: 0.319

MAX RADIUS: 1.304

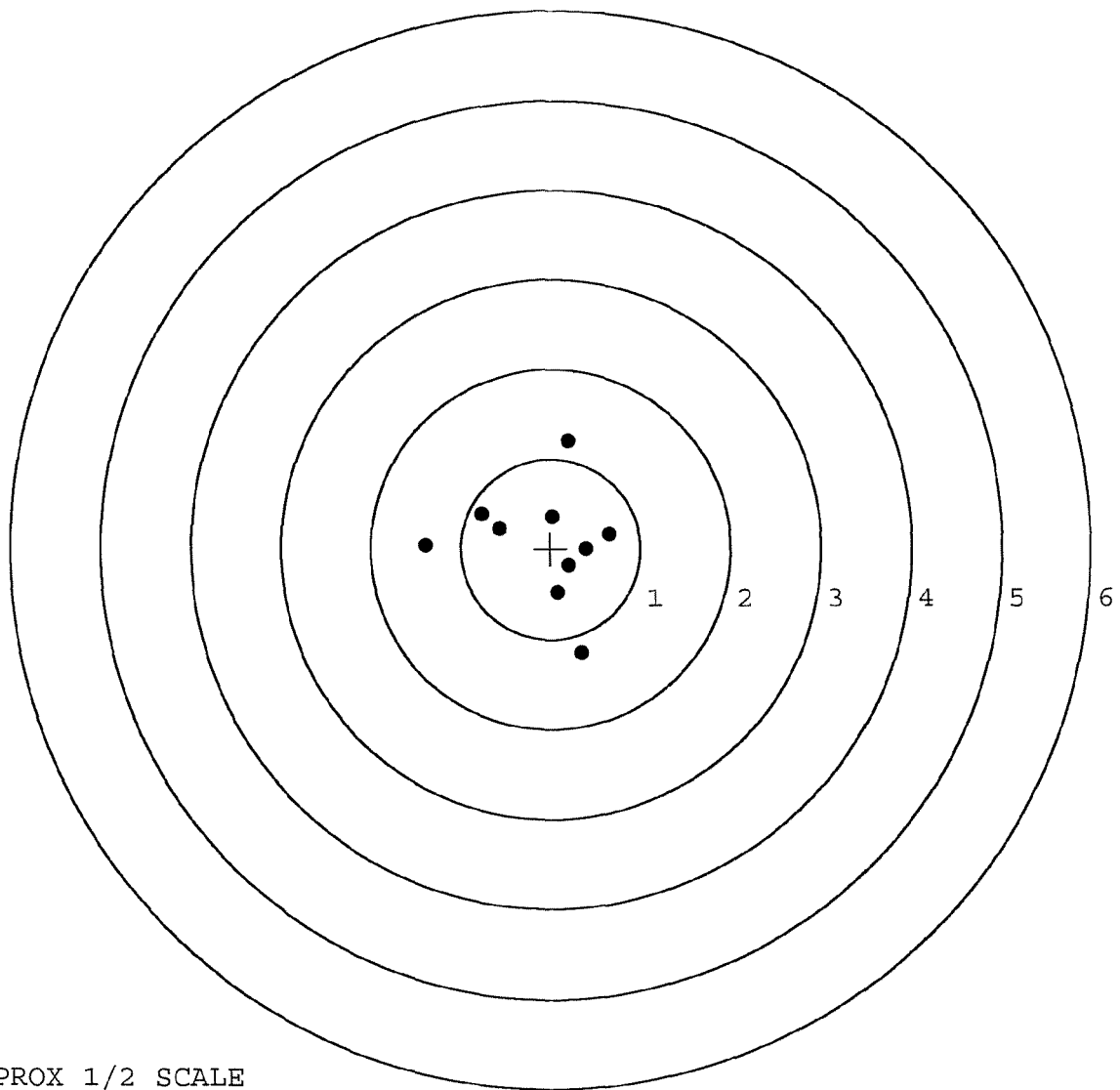
MEAN RADIUS: 0.755

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.342	-1.157
2:	0.198	1.201
3:	0.014	0.356
4:	-0.570	0.226
5:	-0.773	0.387
6:	-1.388	0.039
7:	0.656	0.162
8:	0.397	-0.008
9:	0.205	-0.191
10:	0.078	-0.490



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6594515.___0

TARGET NUMBER: 4

FILE DATE: 01/11/2005

FILE TIME: 11:15

X CENTROID: -0.142

Y CENTROID: -0.211

POA TO CENTROID: 0.254

HORZ SPREAD: 1.878

VERT SPREAD: 1.577

GROUP SPREAD: 1.881

MIN RADIUS: 0.182

MAX RADIUS: 1.041

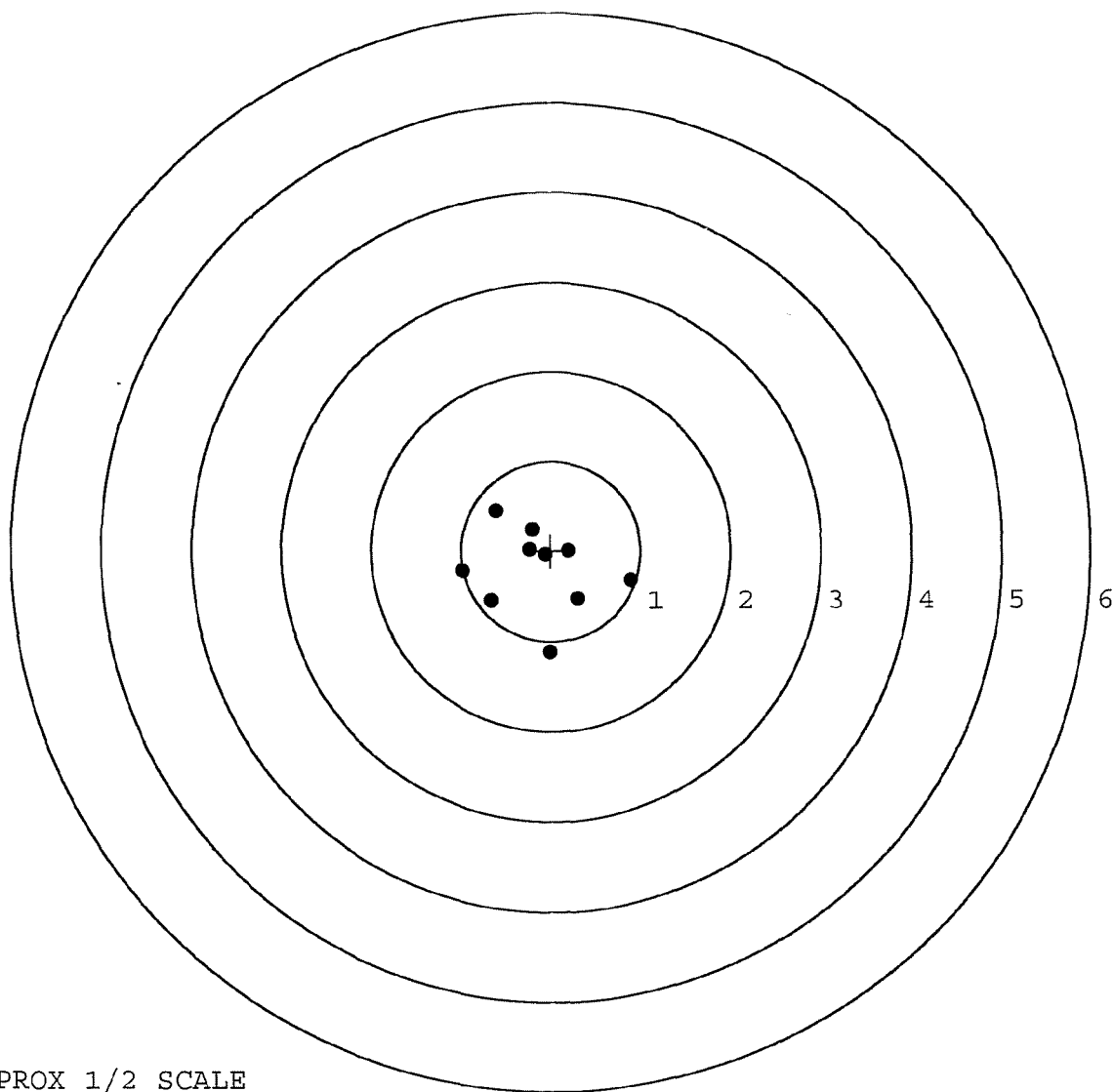
MEAN RADIUS: 0.607

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.892	-0.330
2:	0.294	-0.533
3:	-0.019	-1.124
4:	-0.673	-0.553
5:	-0.986	-0.223
6:	0.196	-0.001
7:	-0.064	-0.046
8:	-0.237	0.015
9:	-0.209	0.235
10:	-0.617	0.453



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6594515.___0

TARGET NUMBER: 5

FILE DATE: 01/11/2005

FILE TIME: 11:15

X CENTROID: 0.001

Y CENTROID: -0.167

POA TO CENTROID: 0.167

HORZ SPREAD: 1.266

VERT SPREAD: 1.155

GROUP SPREAD: 1.362

MIN RADIUS: 0.066

MAX RADIUS: 0.844

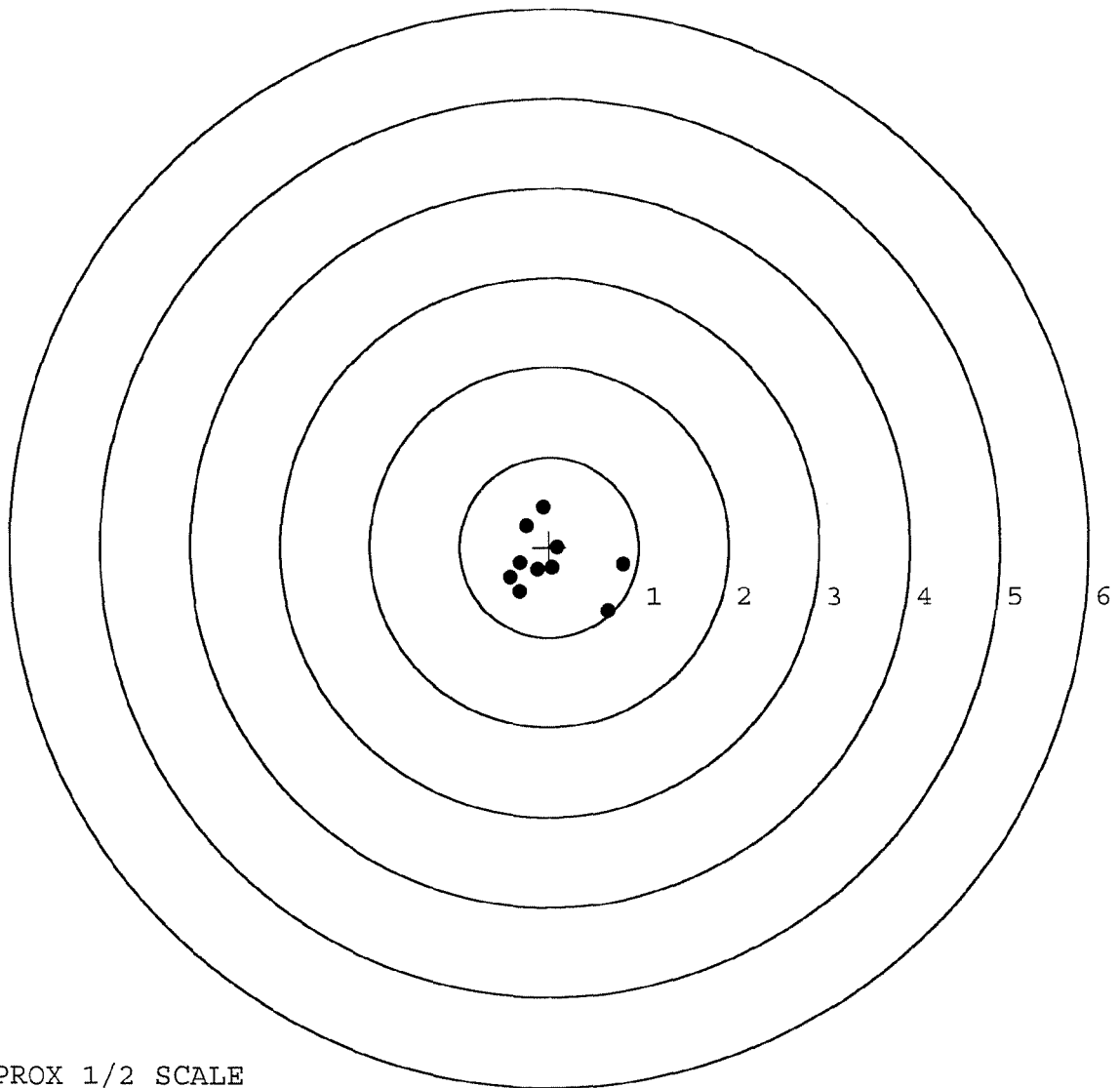
MEAN RADIUS: 0.447

IN 1 IN DIAMETER: 7

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.825	-0.187
2:	0.650	-0.707
3:	-0.072	0.448
4:	-0.265	0.245
5:	0.088	0.000
6:	0.030	-0.227
7:	-0.134	-0.251
8:	-0.330	-0.168
9:	-0.441	-0.337
10:	-0.338	-0.490

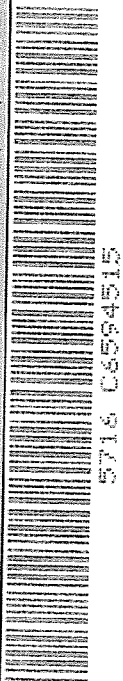


TARGET APPROX 1/2 SCALE

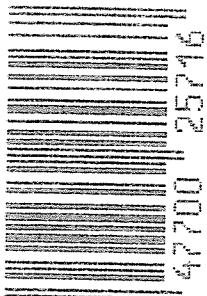
M-24 INSPECTION CHECKLIST
CONTRACT #: DAAE-20-02-D-0127

R & E NUMBER	89034		
SERIAL NUMBER	C6594315		
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	HP
625 A	FINAL ASSEMBLY	1-6-05	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	DM
		SHIP DATE	
QAR INSPECTION DATE			

Remington® REG. U.S. PAT. & TM. OFF.		VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.	
MODEL 700™ H24		SERIAL NO. 06594515	ORDER NO. 5716
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.		20	



UPC



CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6594515

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		"	LG
617	Drill and Tap Sight Holes	1	10 91	FB
618	Polish Barrel	1	10 91	WB
620	Apply Coatings (Barrel Action)		1-12-91	JA
	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		1/28/91	JA

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5 1/2	5 1/2	5 1/2			1/28/91	WB
	G) Safety Off Force	2 1/4	2 1/4	2 1/4			1/28/91	WB
	H) Trigger Pull Test & Retainability						1/28/91	JH
	I) Firing Pin Indent	.022	.0215	.0215			1/28/91	WB
	J) Assemble Stock						1/30/91	RW
	K) Assemble Swivel Studs						2-4-91	AC
	L) Attach Front and Rear Sight Assemblies						1/30/91	RW
	M) Iron Sight Alignment						1/30/91	RW
	N) Detach Front & Rear Sights & place in numbered container						1/30/91	RW
	O) Attach Scope to Rifle						1/30/91	RW
	P) Detach & Attach Scope 20 Times						1/30/91	RW
640	Gallery Target & Test						1-30-91	DH
	A) Time						1-30-91	DH
	B) Malfunctions						1-30-91	DH
	C) Pierced Primers						1-30-91	DH
	D) Optical Clarity of Scope						1-30-91	DH
645	Inspect for Live Ammo						1-30-91	DH
655	Final Inspection							
	A) Headspace						2-4-91	AC
	B) Trigger Pull	2.52	2.53	2.58	2.49	2.50	2-4-91	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. C6594515

DATE 1-28/91

TESTER QEP

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.43	2.29	2.10	2.52	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.24	2.18	2.42	2.53	
PULL #3	2.32	2.33	2.34	2.58	
PULL #4	2.23	2.24	2.26	2.49	
PULL #5	2.24	2.24	2.29	2.50	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.31	3.31		
PULL #2	3.35	3.32		
PULL #3	3.21	3.26		
PULL #4	3.35	3.31		
PULL #5	3.37	3.27		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.27	4.27		4.50
PULL #2	4.25	4.22		4.51
PULL #3	4.24	4.13		4.41
PULL #4	4.16	4.21		4.39
PULL #5	4.31	4.22		4.42
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6594515
30 Jan 1991

CENTROIDAL DISTANCES

0 TO	1	.249425
1 TO	2	.318944
1 TO	3	.386339
1 TO	4	.303402
1 TO	5	.2533

42 <----POA

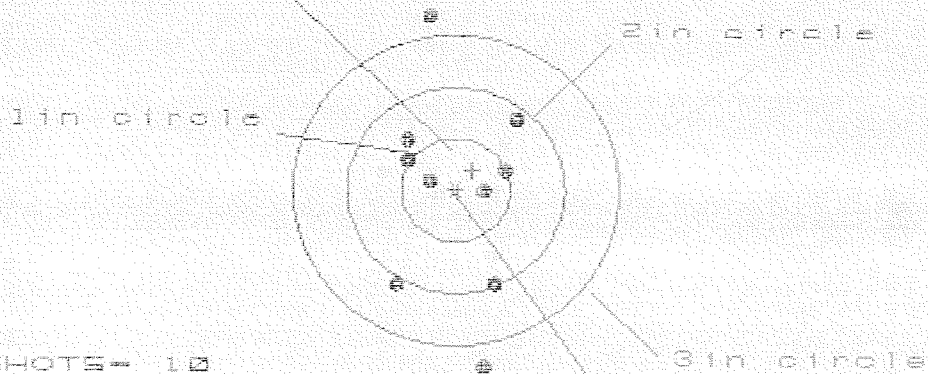
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1452
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0344
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .149219
THE AMR FOR THIS RIFLE IS: .6572

30 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6534515

CENTERFIRE PATTERNS # 1

POA



OF SHOTS= 10

IN CIR

1 in = 3

2 in = 7

3 in = 8

HS= 1.042

VS= 3.414

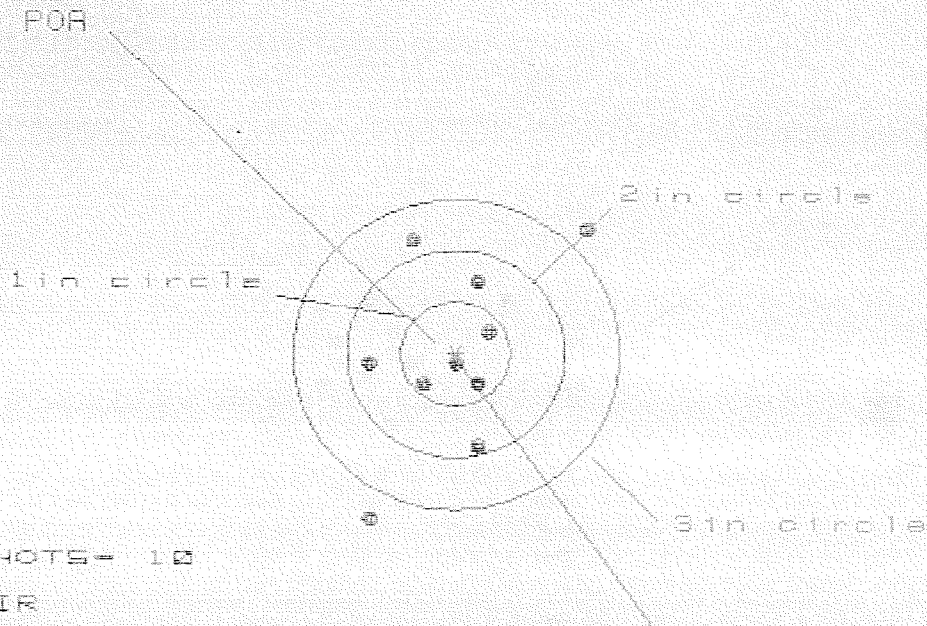
GS= 3.447

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.537	.514	.544
MINIMUM X	:	-.505	-.528	-.498
MAXIMUM Y	:	1.734	.885	.699
MINIMUM Y	:	-1.680	-1.487	-.910
CENTROID X	:	-.158	-.135	-.165
CENTROID Y	:	-.193	-.386	-.200
POA TO CENTROID in.	:	.250	.409	.259
MIN RADIUS	:	.281	.310	.278
MEAN RADIUS	:	.859	.779	.644
MAX RADIUS	:	1.747	1.506	1.037
HORIZONTAL SPREAD	:	1.042	1.042	1.042
VERTICAL SPREAD	:	3.414	2.372	1.609
EXTREME SPREAD	:	3.447	2.388	1.917
NUMBER IN ONE INCH CIRCLE =	:	3	7	8
NUMBER IN TWO INCH CIRCLE =	:	7	8	8
NUMBER IN THREE INCH CIRCLE =	:	8	8	8

30 Jan 1981

FILE:/PATTERNING/CENTERFIRE_PATT/C8594515

CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1 in = 4

2 in = 7

3 in = 8

HS = 2.037

VS = 2.729

GS = 3.405

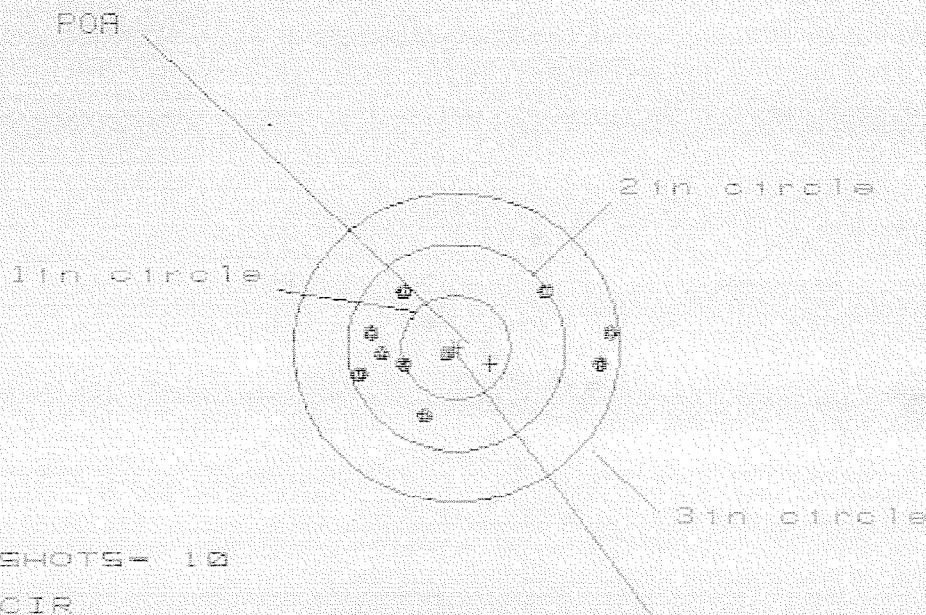
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.245	1.157	.325
MINIMUM X	:	-.792	-.873	-.729
MAXIMUM Y	:	1.186	1.014	1.062
MINIMUM Y	:	-1.543	-1.055	-.928
CENTROID X	:	-.089	.079	-.065
CENTROID Y	:	.089	.261	.134
POA TO CENTROID in.	:	.090	.272	.149
MIN RADIUS	:	.051	.181	.094
MEAN RADIUS	:	.822	.736	.606
MAX RADIUS	:	1.735	1.538	1.102
HORIZONTAL SPREAD	:	2.037	2.038	1.054
VERTICAL SPREAD	:	2.729	2.069	1.990
EXTREME SPREAD	:	3.405	2.389	2.076
NUMBER IN ONE INCH CIRCLE =			4	
NUMBER IN TWO INCH CIRCLE =			7	
NUMBER IN THREE INCH CIRCLE =			8	

30 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8594513

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1in = 2

2in = 8

3in = 10

HS= 2.316

VS= 1.204

GS= 2.344

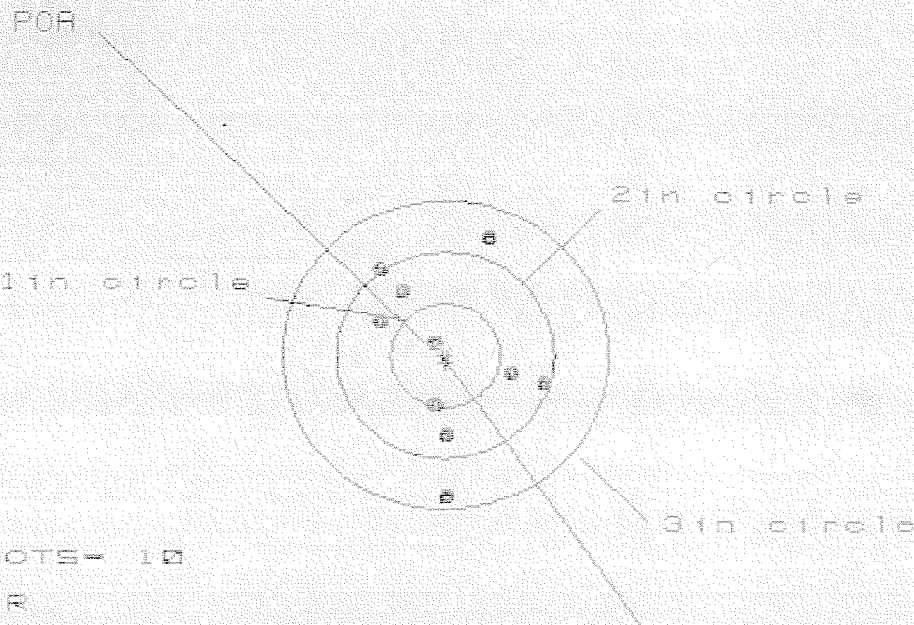
CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.442	1.461	1.178
MINIMUM X	:	-.874	-.714	-.528
MAXIMUM Y	:	.563	.577	.556
MINIMUM Y	:	-.641	-.627	-.648
CENTROID X	:	-.315	-.475	-.661
CENTROID Y	:	.160	.146	.167
POA TO CENTROID in.	:	.354	.497	.681
MIN RADIUS	:	.064	.121	.218
MEAN RADIUS	:	.816	.702	.557
MAX RADIUS	:	1.448	1.491	1.200
HORIZONTAL SPREAD	:	2.316	2.195	1.706
VERTICAL SPREAD	:	1.204	1.204	1.204
EXTREME SPREAD	:	2.344	2.195	1.860
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	

30 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/CB534515

CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1in = 1

2in = 7

3in = 10

HS= 1.412

VS= 2.546

GS= 2.572

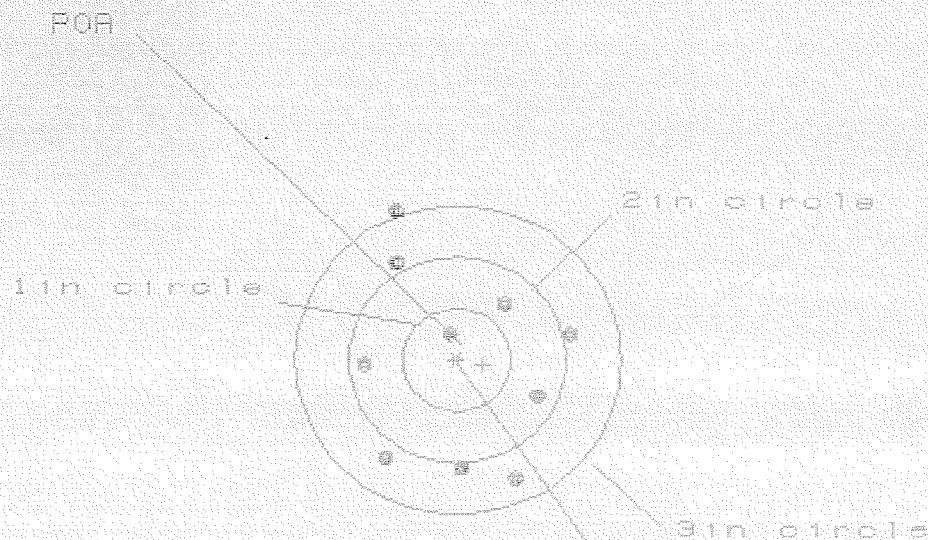
CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.862	.861	.905
MINIMUM X	:	-.550	-.551	-.507
MAXIMUM Y	:	1.153	.998	.830
MINIMUM Y	:	-1.393	-.951	-.827
CENTROID X	:	-.005	-.004	-.048
CENTROID Y	:	.069	.224	.100
POA TO CENTROID in.	:	.070	.224	.111
MIN RADIUS	:	.203	.133	.152
MEAN RADIUS	:	.799	.721	.668
MAX RADIUS	:	1.393	1.059	.971
HORIZONTAL SPREAD	:	1.412	1.412	1.412
VERTICAL SPREAD	:	2.546	1.949	1.656
EXTREME SPREAD	:	2.572	1.989	1.775
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

30 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6594515

CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1in = 1

2in = 4

3in = 9

HS= 1.875

VS= 2.573

GS= 2.838

CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.021	.953	1.018
MINIMUM X	-.854	-.922	-.857
MAXIMUM Y	1.418	1.140	1.016
MINIMUM Y	-1.155	-.998	-.985
CENTROID X	-.239	-.171	-.236
CENTROID Y	.047	-.110	.014
POA TO CENTROID in.	.243	.203	.236
MIN RADIUS	.314	.485	.346
MEAN RADIUS	.990	.926	.885
MAX RADIUS	1.543	1.302	1.161
HORIZONTAL SPREAD	1.875	1.975	1.875
VERTICAL SPREAD	2.573	2.138	2.001
EXTREME SPREAD	2.838	2.427	2.110
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	9		

RECEIVING AND ESTIMATING REPORT

COMMENTS

ORDER
R 94-18095INITIAL
FDC CUSTOMER ORDER NO.
DAAA09-92-C-0834W/10X SCOPE M-24 SNIPER, W/DEPLOYMENT KIT
ATTN: FRED MARTINDATE RECEIVED
06/09/94 DATE OPENED
06/09/94 DATE CODESERIAL NUMBER
C6594515

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
ANNISTONAL
36201-5025

CUST NO: 098397 CJO.DL

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

New Trigger Assy \$173.31
CTI 50.00
223.31

REPAIRMAN

PROOF

CLEAN

TEST

TARGET

PATTERN

GALLERY TESTER

DATE

DATE

DATE

DATE

DATE

OFFICE COPY

RD6525 REV. 1/94

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

M2400018477

SWS TRIGGER PULL TEST

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

SERIAL NO. 16594515
DATE 12-14
TESTER BM

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.67	2.72	2.61		MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.60	2.67	2.54		
PULL #3	2.63	2.58	2.57		
PULL #4	2.61	2.66	2.62		
PULL #5	2.62	2.55	2.59		
TOTAL	13.13	13.18	12.93		
AVG.	2.62	2.63	2.58		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	2.95	2.97		
PULL #2	3.08	2.98		
PULL #3	2.92	2.99		
PULL #4	3.00	3.06		
PULL #5	3.03	2.97		
TOTAL	14.98	14.97		
AVG.	2.99	2.99		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.25	4.00		4.05
PULL #2	4.25	4.11		4.08
PULL #3	4.14	3.98		4.20
PULL #4	4.22	4.12		4.05
PULL #5	4.15	4.09		4.15
TOTAL	21.01	20.30		20.53
AVG.	4.20	4.06		4.10

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6594515

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	4 3/4	5			12/14	WB
	G) Safety Off Force	2 1/2	2 1/2	2 1/2			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	2.50	2.70	2.66	2.64	2.72	12/14	WB
	C) Function							
660	Pack							