

C6594517

MODEL 700TM M24

Model **SMS**TM

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

Remington



MODEL 700™ M24

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

20

SERIAL NO.
C6594517

ORDER NO.
5716

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



5716 C6594517

UPC



0 47700 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: RE00136223

Serial: C6594517 Model M24 SWS Center Fire
Caliber: 7.62 NATO

Repairman:

Status:

New 11/2/2007 8:13:59 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

1:12 PM

C&PS

NUM

INS

SCRL



1:12 PM

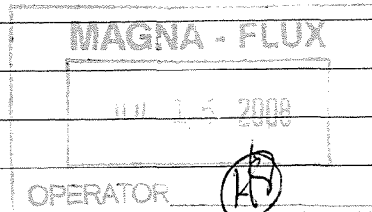
Serial Number: **C6594517**
 Model: **M24 SWS**

RE00136223

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

R & E NUMBER 136223
SERIAL NUMBER C6594577
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
560	ASSEMBLE	7-10-08	RTZ
600	PROOF	7-10-08	SD
605	CHECK HEADSPACE	7-10-08	SD
610	DIS-ASSEMBLE GUN	7-11-08	RTZ
612	MAGNAFLUX	7-11-08	(KJ)
510	DRILL AND TAP	7-11-08	SP
615	ROLLMARK CALIBER	7-15-08	RT
618	ROTO-BLAST	2-17	CR
620	APPLY COATINGS	2-24-08	RTZ
625	FINAL ASSEMBLY	2-24-08	RTZ
640	FUNCTION TEST AND	9-2-08	RTZ
650	TARGET	9-2-08	RTZ
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
670	FINAL INSPECTION	9-6-08	TRW
	A) HEADSPACE	9-10-08	RTZ
		9-10-08	RTZ
	B) TRIGGER PULL	2.36 2.48 2.29 2.36 2.36 9-8-08	RTW
680	F) SAFETY ON FORCE	6.0 6.0 6.0 9-8-08	RTZ
	G) SAFETY OFF FORCE	4.0 4.0 4.0 9-8-08	RTZ
	I) FIRING PIN INDENT	0.21 0.21 0.21 9-8-08	RTZ
690	PACK	9-11-08	TL



SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6594517.___0
FILE DATE AND TIME: 09/03/2008 11:53

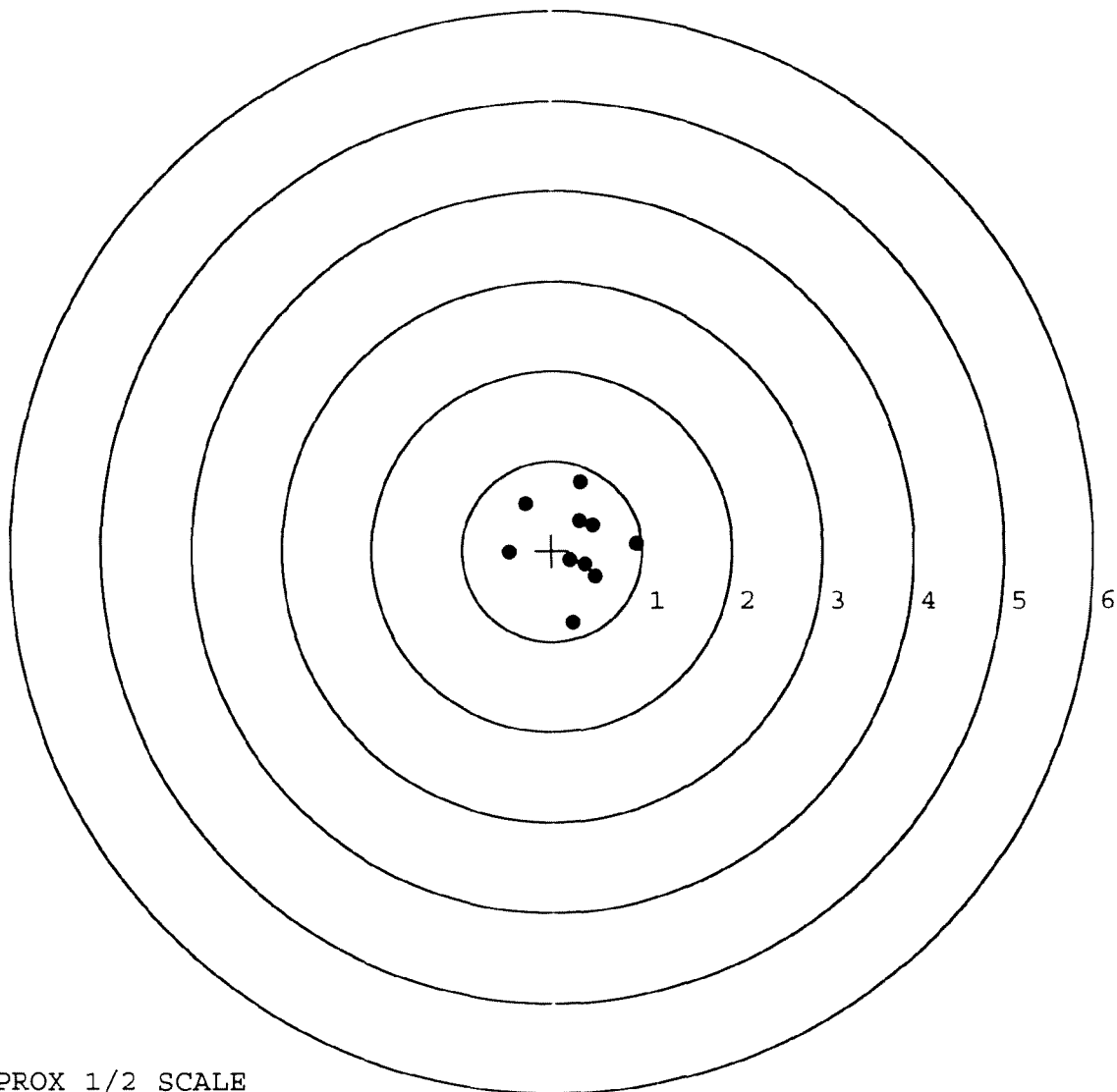
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.052
The Average Y Centroid of the Five Target Set:	0.063
The Average Point of Impact of the Five Target Set:	0.082
The Average Mean Radius of the Five Target Set:	0.560
The Distance from POA to Centroid Target #1:	0.260
The Distance from Centroid Target #2 to Centroid Target #1:	0.240
The Distance from Centroid Target #3 to Centroid Target #1:	0.414
The Distance from Centroid Target #4 to Centroid Target #1:	0.257
The Distance from Centroid Target #5 to Centroid Target #1:	0.134

SERIAL NUMBER: C6594517. __0
TARGET NUMBER: 1
FILE DATE: 09/03/2008
FILE TIME: 11:53

X CENTROID: 0.253
Y CENTROID: 0.062
POA TO CENTROID: 0.260
HORZ SPREAD: 1.417
VERT SPREAD: 1.571
GROUP SPREAD: 1.574
MIN RADIUS: 0.178
MAX RADIUS: 0.861
MEAN RADIUS: 0.514
IN 1 IN DIAMETER: 5
IN 2 IN DIAMETER: 10
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.227	-0.799
2:	0.481	-0.293
3:	0.943	0.074
4:	0.370	-0.159
5:	0.202	-0.109
6:	0.450	0.289
7:	0.306	0.335
8:	0.318	0.772
9:	-0.297	0.525
10:	-0.474	-0.019

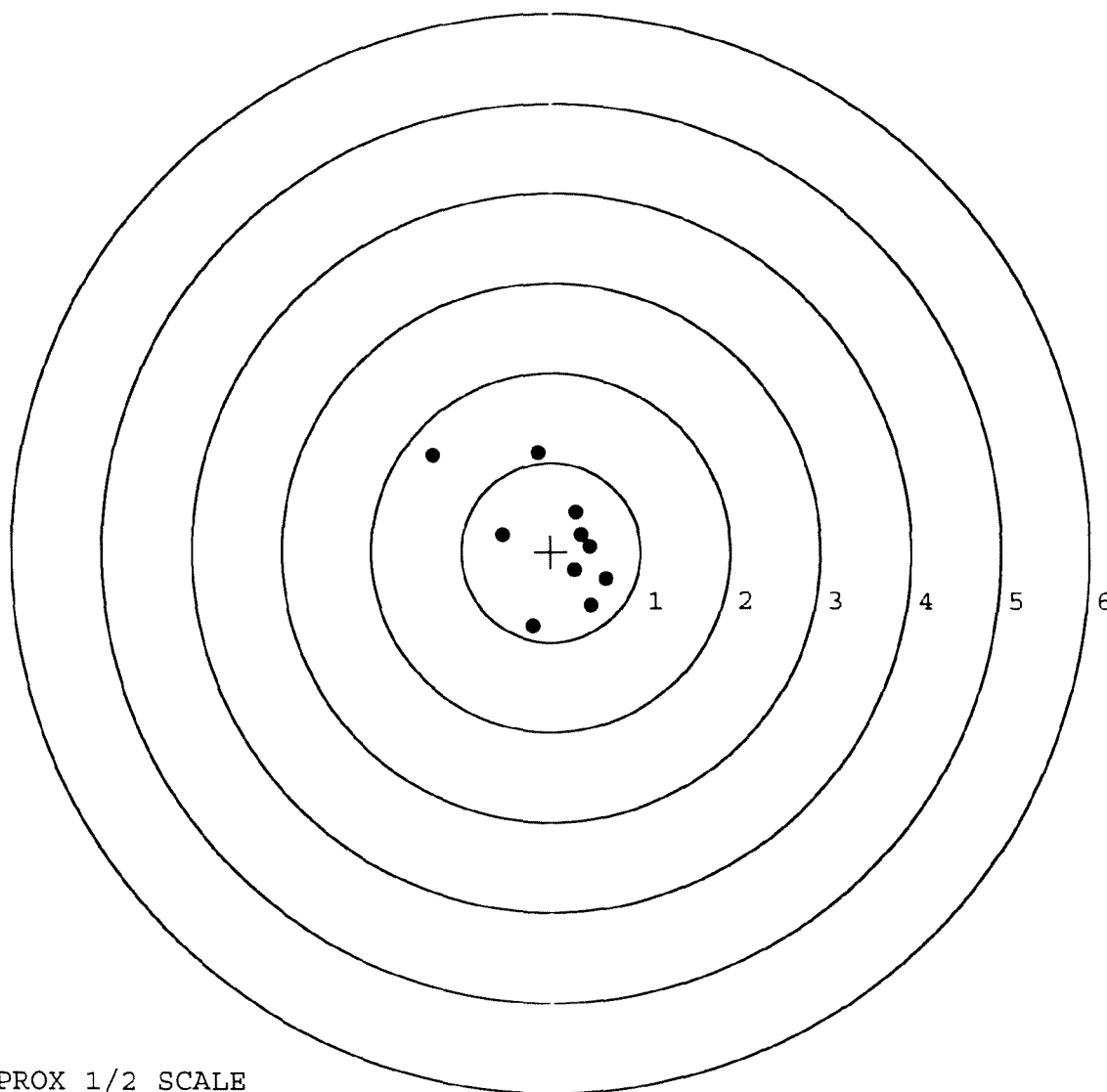


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6594517. 0
TARGET NUMBER: 2
FILE DATE: 09/03/2008
FILE TIME: 11:53

X CENTROID: 0.018
Y CENTROID: 0.112
POA TO CENTROID: 0.113
HORZ SPREAD: 1.928
VERT SPREAD: 1.939
GROUP SPREAD: 2.429
MIN RADIUS: 0.336
MAX RADIUS: 1.644
MEAN RADIUS: 0.731
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 9

POINT#	X	Y
1:	-0.201	-0.829
2:	0.442	-0.603
3:	0.616	-0.304
4:	0.261	-0.208
5:	0.434	0.054
6:	0.345	0.188
7:	0.278	0.441
8:	-0.146	1.110
9:	-0.534	0.190
10:	-1.312	1.077



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6594517. __0

TARGET NUMBER: 3

FILE DATE: 09/03/2008

FILE TIME: 11:53

POINT#	X	Y
1:	0.467	-0.729
2:	0.336	-0.339
3:	0.410	0.075
4:	0.024	-0.308
5:	-0.305	-0.061
6:	-0.268	0.116
7:	-0.206	0.275
8:	-0.602	-0.540
9:	-0.572	0.077
10:	-0.710	0.812

X CENTROID: -0.143

Y CENTROID: -0.062

POA TO CENTROID: 0.156

HORZ SPREAD: 1.177

VERT SPREAD: 1.541

GROUP SPREAD: 1.939

MIN RADIUS: 0.162

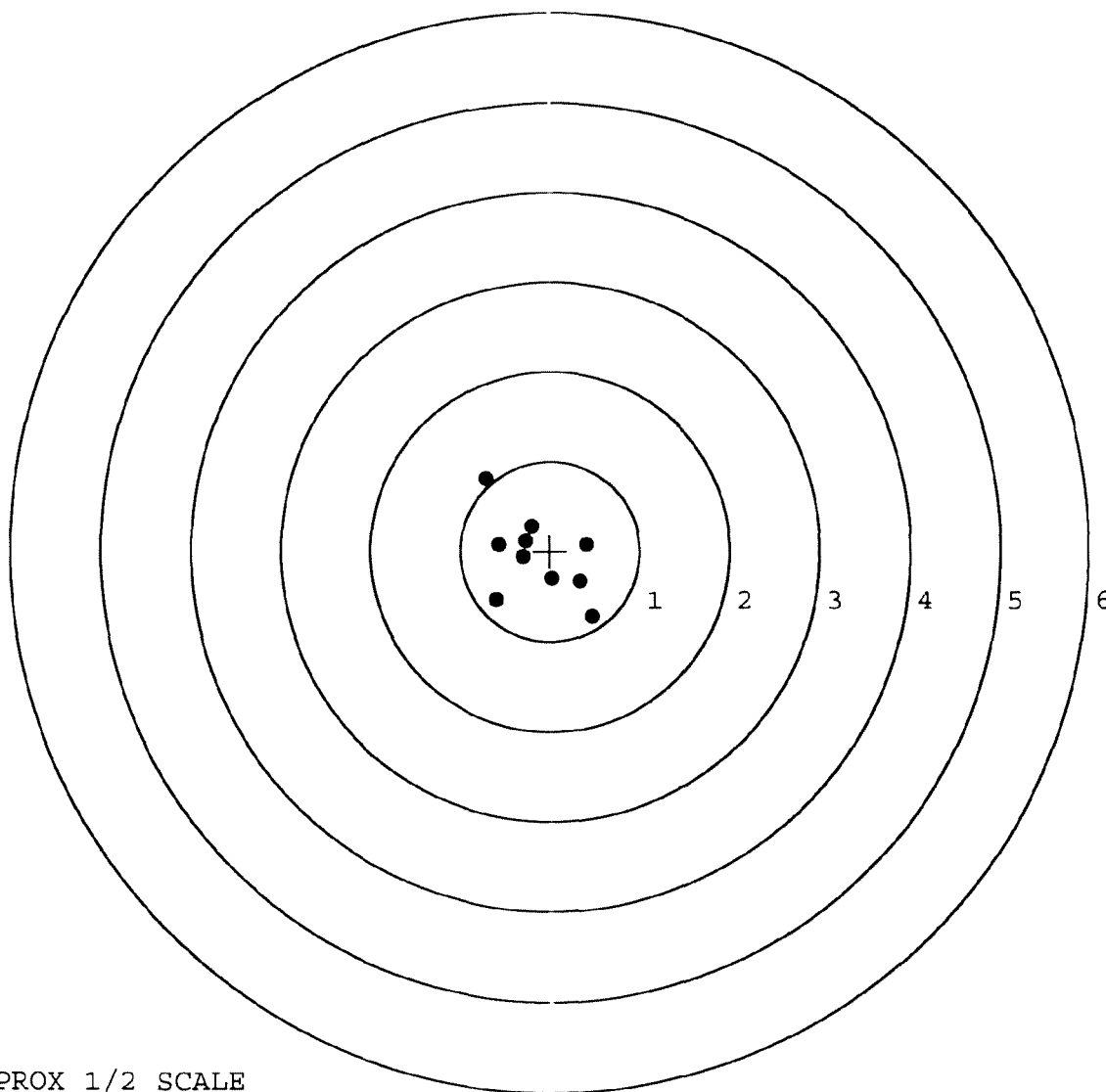
MAX RADIUS: 1.042

MEAN RADIUS: 0.520

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10

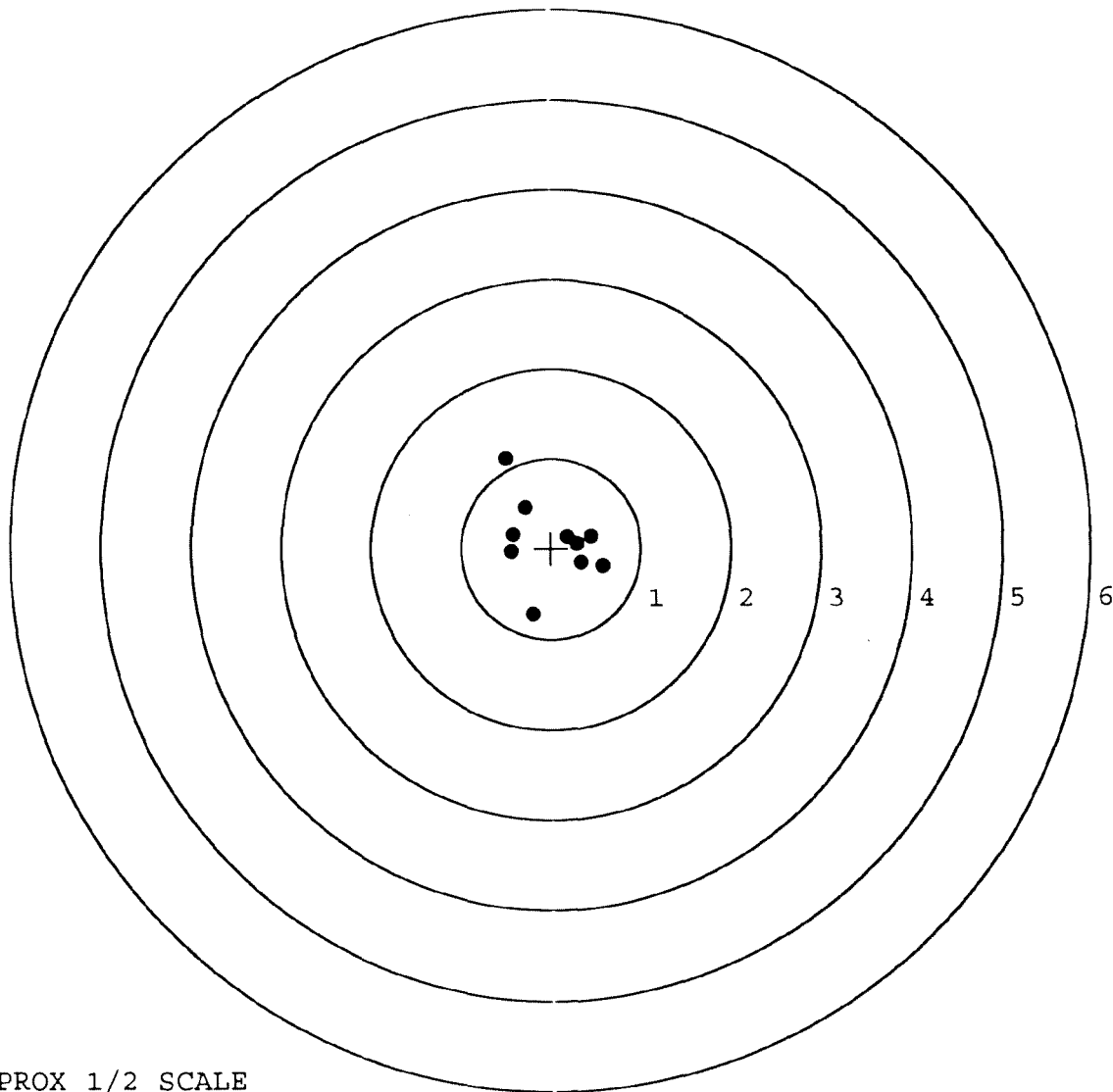


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6594517.___0
TARGET NUMBER: 4
FILE DATE: 09/03/2008
FILE TIME: 11:53

X CENTROID: -0.004
Y CENTROID: 0.083
POA TO CENTROID: 0.083
HORZ SPREAD: 1.083
VERT SPREAD: 1.738
GROUP SPREAD: 1.763
MIN RADIUS: 0.193
MAX RADIUS: 1.049
MEAN RADIUS: 0.525
IN 1 IN DIAMETER: 7
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.208	-0.733
2:	-0.504	1.005
3:	-0.290	0.457
4:	-0.426	0.155
5:	-0.446	-0.036
6:	0.182	0.136
7:	0.448	0.138
8:	0.579	-0.195
9:	0.336	-0.156
10:	0.291	0.056



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6594517. 0

TARGET NUMBER: 5

FILE DATE: 09/03/2008

FILE TIME: 11:53

X CENTROID: 0.133

Y CENTROID: 0.123

POA TO CENTROID: 0.181

HORZ SPREAD: 1.086

VERT SPREAD: 1.454

GROUP SPREAD: 1.489

MIN RADIUS: 0.299

MAX RADIUS: 0.884

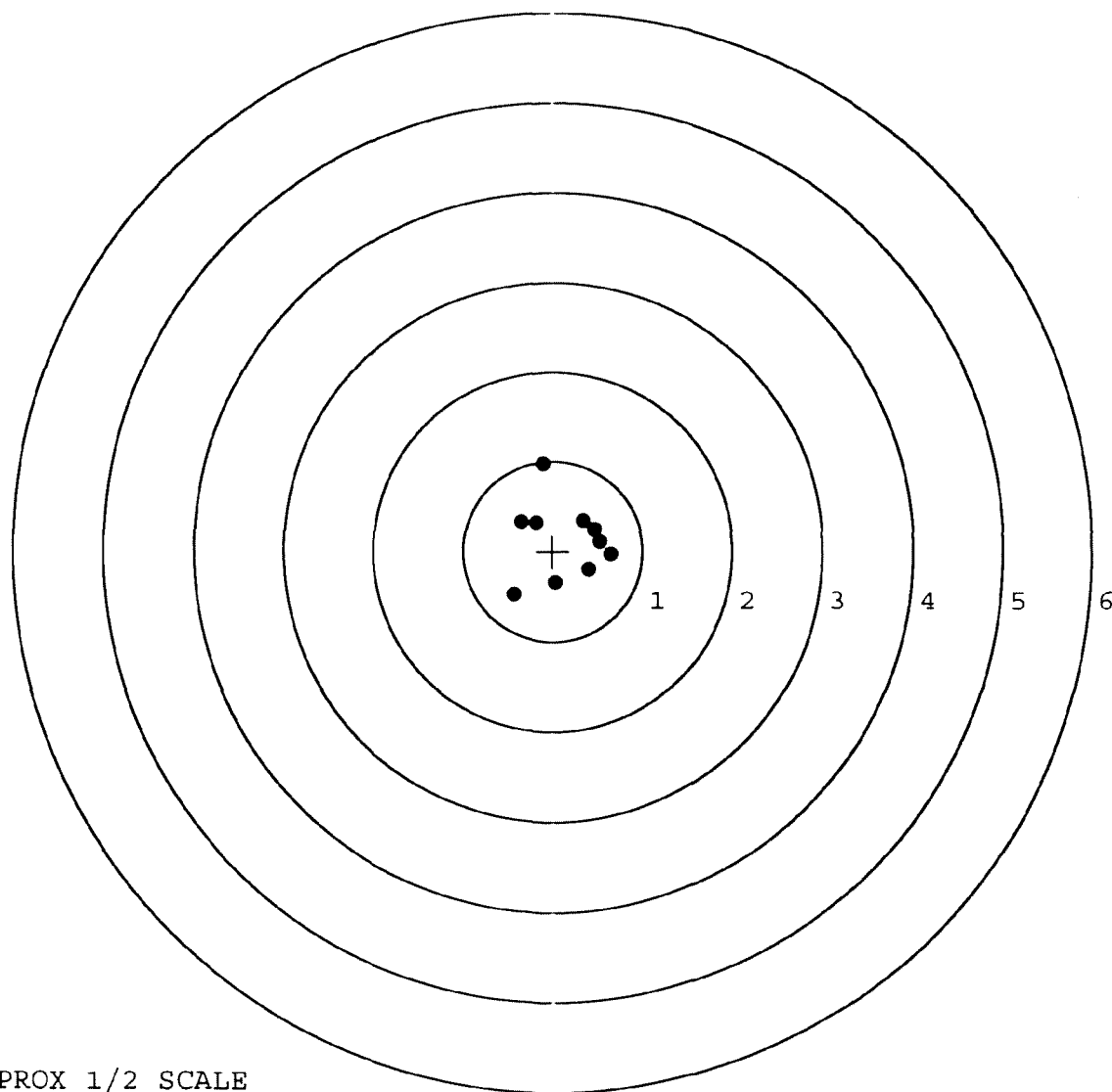
MEAN RADIUS: 0.511

IN 1 IN DIAMETER: 6

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.434	-0.482
2:	0.033	-0.349
3:	0.401	-0.203
4:	0.652	-0.035
5:	0.527	0.112
6:	0.468	0.241
7:	0.343	0.336
8:	-0.187	0.309
9:	-0.357	0.324
10:	-0.113	0.972



TARGET APPROX 1/2 SCALE

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # **C6594517**

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		12/26/90	K.S.
600	Proof		12/26/90	K.S.
607	Check Headspace		12/26/90	K.S.
610	Dis-assemble Gun		12/26/90	K.S.
612	Magnaflux Barrel Action		1-7-91	KR
	Magnaflux Bolt		1-7-91	KR
615	Rollmark Caliber		1-7-91	22
617	Drill and Tap Sight Holes	1	10 91	FB
618	Polish Barrel	1	10 91	WB
620	Apply Coatings (Barrel Action)		1-26-91	JA
	Apply Coating (Bolt)		1-26-91	JA
625	Final Assembly A) Clean inside of Bolt Assembly		2/6/91	KA
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		2/6/91	KA
	C) Inspect Ejector Hole for Chamfer		2/6/91	KA
	D) Oil Firing Pin Ass'y		2/6/91	KA
	E) Adjust Trigger Pull to Min Setting and Stake		2/7/91	JA

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5 1/2	5 1/2	5 1/2			2/7/91	WB
	G) Safety Off Force	3	3	3			2/7/91	WB.
	H) Trigger Pull Test & Retainability						2/7/91	JY
	I) Firing Pin Indent	.0202	.0202	.0202			2/7/91	WB
	J) Assemble Stock						2/8/91	KH
	K) Assemble Swivel Studs						2-26-91	AC
	L) Attach Front and Rear Sight Assemblies						2/8/91	KH
	M) Iron Sight Alignment						2/8/91	KH
	N) Detach Front & Rear Sights & place in numbered container						2/8/91	KH
	O) Attach Scope to Rifle						2/8/91	KH
	P) Detach & Attach Scope 20 Times						2/8/91	KH
640	Gallery Target & Test						2-1-91	AC
	A) Time						2-1-91	AC
	B) Malfunctions						2-1-91	AC
	C) Pierced Primers						2-1-91	AC
	D) Optical Clarity of Scope						2-1-91	AC
645	Inspect for Live Ammo						2-1-91	AC
655	Final Inspection							
	A) Headspace						2-26-91	AC
	B) Trigger Pull	2.54	2.53	2.48	2.59	2.50	2/25/91	JY.
	C) Function						2-26-91	AC
660	Pack						3/14/91	WB

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

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

SERIAL NO. C6594517

DATE 2/2/91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.44	2.43	2.46	2.54	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.47	2.45	2.40	2.55	
PULL #3	2.49	2.36	2.45	2.48	
PULL #4	2.42	2.48	2.49	2.59	
PULL #5	2.45	2.45	2.46	2.50	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.35	3.14		
PULL #2	3.32	3.26		
PULL #3	3.29	3.37		
PULL #4	3.35	3.37		
PULL #5	3.19	3.49		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.45	4.33		4.45
PULL #2	4.40	4.25		4.53
PULL #3	4.50	4.50		4.38
PULL #4	4.49	4.30		4.50
PULL #5	4.56	4.29		4.53
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6594516
26 Jan 1991

CENTROIDAL DISTANCES

0 TO	1	.287089
1 TO	2	.192398
1 TO	3	.428141
1 TO	4	.171207
1 TO	5	.272208

 <----POA

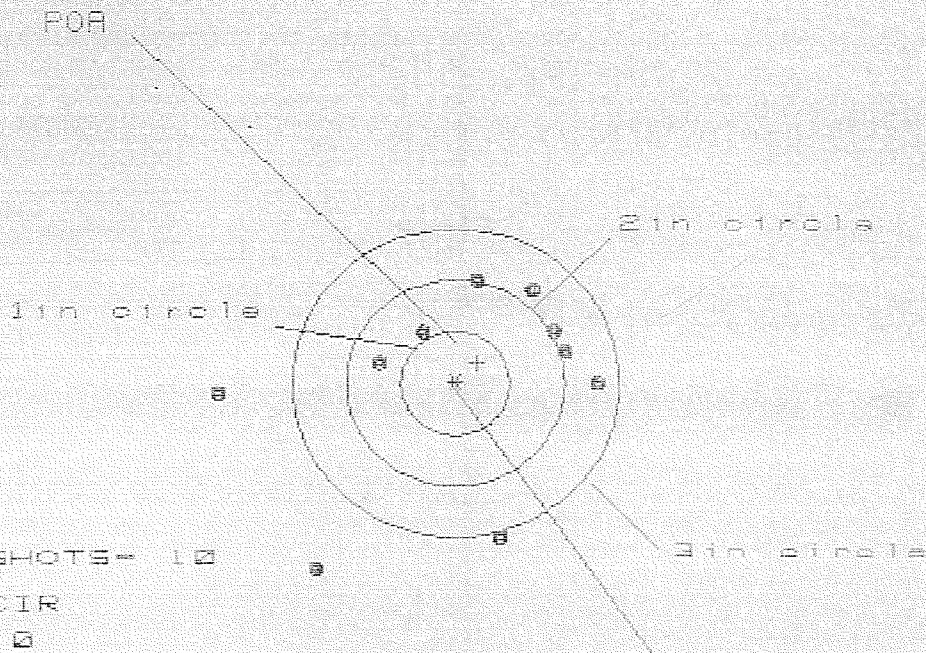
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.063
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0612
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0878319
THE AMR FOR THIS RIFLE IS: 1.027

26 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08594516

CENTERFIRE PATTERNS

1



OF SHOTS= 10

IN CIR

1in = 0

2in = 3

3in = 7

HS= 3.430

VS= 2.762

GS= 3.433

CENTROID #

PATTERN #

	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.270	1.125	.837
MINIMUM X	-2.160	-2.305	-1.090
MAXIMUM Y	.974	.776	.736
MINIMUM Y	-1.788	-1.674	-1.714
CENTROID X	-.204	-.059	.229
CENTROID Y	-.202	-.004	.036
POA TO CENTROID in.	.287	.059	.232
MIN RADIUS	.581	.533	.528
MEAN RADIUS	1.262	1.090	.876
MAX RADIUS	2.212	2.327	1.715
HORIZONTAL SPREAD	3.430	3.430	1.927
VERTICAL SPREAD	2.762	2.450	2.450
EXTREME SPREAD	3.433	3.433	2.456
NUMBER IN ONE INCH CIRCLE =	0	0	0
NUMBER IN TWO INCH CIRCLE =	3	3	3
NUMBER IN THREE INCH CIRCLE =	7	7	7

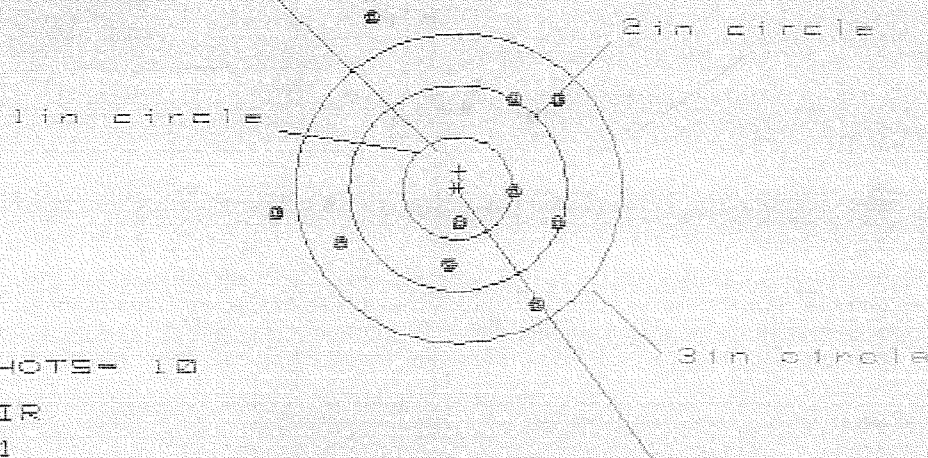
26 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08594516

CENTERFIRE PATTERNS

2

POA



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 4

3 in = 8

HS= 2.535

VS= 2.849

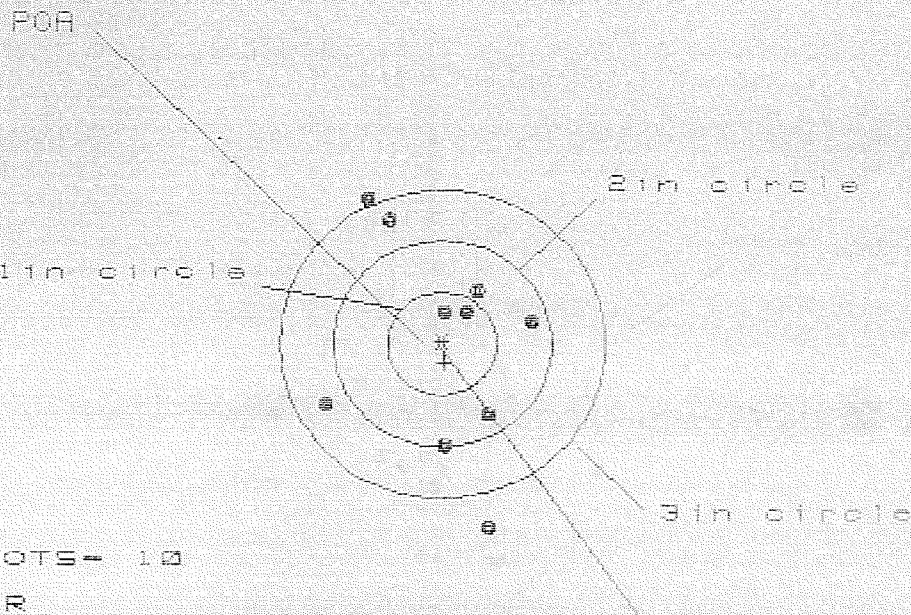
GS= 3.189

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.898	.814	.599
MINIMUM X	:	-1.637	-1.721	-1.373
MAXIMUM Y	:	1.782	1.104	1.094
MINIMUM Y	:	-1.147	-.958	-.968
CENTROID X	:	-.015	.069	.284
CENTROID Y	:	-.166	-.355	-.345
POA TO CENTROID in.	:	.166	.361	.447
MIN RADIUS	:	.379	.204	.303
MEAN RADIUS	:	1.097	.961	.836
MAX RADIUS	:	1.861	1.723	1.427
HORIZONTAL SPREAD	:	2.535	2.535	1.972
VERTICAL SPREAD	:	2.849	2.062	2.062
EXTREME SPREAD	:	3.189	2.759	2.411
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	

28 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08534516

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1in = 2

2in = 5

3in = 8

HS= 1.931

VS= 3.132

GS= 3.337

CENTROID *

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.831	.879	.795
MINIMUM X	:	-1.100	-1.052	-1.136
MAXIMUM Y	:	1.382	1.187	1.125
MINIMUM Y	:	-1.750	-1.202	-1.053
CENTROID X	:	-.023	-.071	.013
CENTROID Y	:	.186	.381	.233
POA TO CENTROID in.	:	.188	.387	.233
MIN RADIUS	:	.328	.143	.283
MEAN RADIUS	:	.994	.856	.808
MAX RADIUS	:	1.803	1.365	1.284
HORIZONTAL SPREAD	:	1.931	1.931	1.931
VERTICAL SPREAD	:	3.132	2.389	2.178
EXTREME SPREAD	:	3.337	2.505	2.241
NUMBER IN ONE INCH CIRCLE =	:	2	2	2
NUMBER IN TWO INCH CIRCLE =	:	5	5	5
NUMBER IN THREE INCH CIRCLE =	:	8	8	8

26 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8534516

CENTERFIRE PATTERNS

4

POA

1 in circle

2 in circle

3 in circle

CENTROID *

* OF SHOTS= 10

IN CIR

1 in = 4

2 in = 7

3 in = 10

HS= 2.167

VS= 2.019

GS= 2.302

PATTERN #

4

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.457

.877

.968

MINIMUM X

-.710

-.549

-.458

MAXIMUM Y

1.024

1.012

.887

MINIMUM Y

-.995

-1.007

-.463

CENTROID X

-.100

-.261

-.352

CENTROID Y

-.066

-.054

.071

POA TO CENTROID in.

.120

.267

.359

MIN RADIUS

.083

.079

.211

MEAN RADIUS

.737

.620

.552

MAX RADIUS

1.461

1.240

.970

HORIZONTAL SPREAD

2.167

1.426

1.426

VERTICAL SPREAD

2.019

2.019

1.350

EXTREME SPREAD

2.302

2.230

1.545

NUMBER IN ONE INCH CIRCLE =

4

NUMBER IN TWO INCH CIRCLE =

7

NUMBER IN THREE INCH CIRCLE =

10

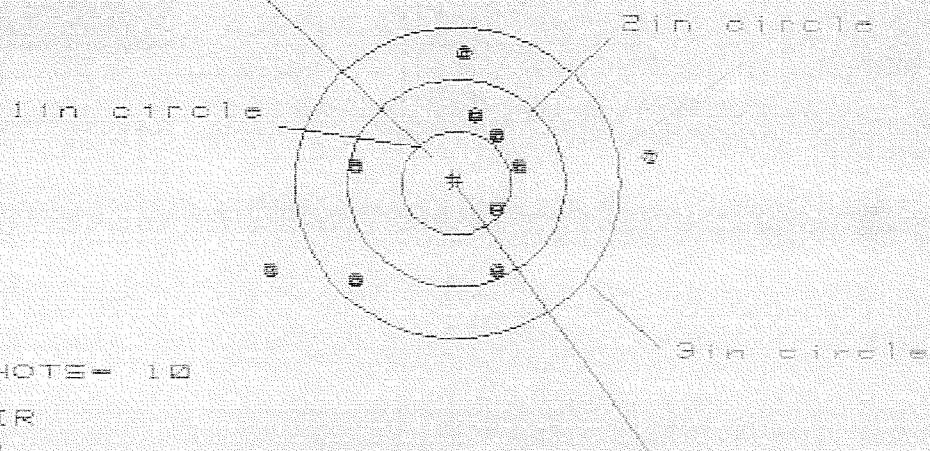
26 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6594516

CENTERFIRE PATTERNS

5

FOR



OF SHOTS = 10

IN CIR

1in = 1

2in = 5

3in = 8

HS = 3.563

VS = 2.243

GS = 3.738

CENTROID #

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.790	1.593	.554
MINIMUM X	-1.773	-1.146	-.947
MAXIMUM Y	1.259	1.161	1.181
MINIMUM Y	-.985	-1.082	-1.062
CENTROID X	.027	.224	.025
CENTROID Y	-.058	.040	.020
FOR TO CENTROID in.	.064	.228	.032
MIN RADIUS	.407	.343	.453
MEAN RADIUS	1.046	.892	.827
MAX RADIUS	1.977	1.601	1.399
HORIZONTAL SPREAD	3.563	2.739	1.501
VERTICAL SPREAD	2.243	2.243	2.243
EXTREME SPREAD	3.738	2.973	2.458
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		8	

RECEIVING AND ESTIMATING REPORT

COMMENTS

ORDER

R 94-18732

INITIAL CUSTOMER ORDER NO.

JJM DAAA09-92-C-0834

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

ATTN FRED MARTIN

SCOPE 90-0242

DATE RECEIVED

DATE OPENED

DATE CODE

SERIAL NUMBER

NEW SERIAL NUMBER

MODEL AND GRADE

06/14/94

06/15/94

C6594517

700

7.62

NATO

ACCESSORIES

HARD CASE

SCOPE MNTS

SCOPE BASE

SLING STRAP

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.B.D.

ACCOUNT NUMBER

ACCOUNT NUMBER N/C

WRITE

PROM. DATE

ESTIMATED

VIA

UPS

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
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

M2400018523

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C6594517

DATE 10-30-95

TESTER DA

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.74	2.42	2.54		MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.22	2.43	2.65		
PULL #3	2.80	2.52	2.69		
PULL #4	2.83	2.47	2.56		
PULL #5	2.74	2.47	2.59		
TOTAL	13.83	12.31	13.03		
AVG.	2.76	2.46	2.60		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.16	3.16		
PULL #2	3.20	3.12		
PULL #3	3.27	3.17		
PULL #4	3.35	3.22		
PULL #5	3.29	3.10		
TOTAL	16.27	15.77		
AVG.	3.25	3.15		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.13	4.11	4.12	
PULL #2	4.03	4.08	4.18	
PULL #3	4.13	4.17	4.08	
PULL #4	4.07	4.08	4.05	
PULL #5	4.08	4.07	4.19	
TOTAL	20.44	20.51	20.62	
AVG.	4.08	4.10	4.12	

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6594517

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
525 cont.	F) Safety On Force	6	6	6			12/14	WB
	G) Safety Off Force	3	3	3			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	2.42	2.36	2.39	2.42	2.31	12/14	WB
	C) Function							
660	Pack							