

C6594628

MODEL 780™ M24

Model **545**™

Action

Barrel Length

Capacity

Order No. **5715**

*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: RE00136217

Verify Repair

Serial: C6594628 Model M24 SWS Center Fire
Caliber: 7.62 NATO

Repairman:

Status:

Closed 11/2/2007 10:17:24 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

1:11 PM

CAPS

NUM

INS

SCRL



1:13 PM

Serial Number: C6594628

Model: M24 SWS



RE00136217

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

R & E NUMBER 136217
SERIAL NUMBER C6594628
LOG-IN DATE 11-2-07

OPERATION #	OPERATION NAME	DATE	INITIAL
500	DIS-ASSEMBLE GUN	7-9-08	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	7-15-08	RTZ
510	DRILL AND TAP	7-11-08	SP
615	ROLLMARK CALIBER	7-15-08	RT
618	ROTO-BLAST	7-17	CM
620	APPLY COATINGS	7-24-08	RTZ
625	FINAL ASSEMBLY	7-24-08	RTZ
640	FUNCTION TEST AND	8-4-04	TRW
650	TARGET	8-4-04	TRW
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
670	FINAL INSPECTION A) HEADSPACE	8-4-04 8-8-08 9-8-08	TRW RTZ RTZ
	BI TRIGGER PULL	2.47 2.66 2.59 2.66 2.69	8/15/08 FM
680	F) SAFETY ON FORCE	5.5 5.5 5.5	8-20 TC
	G) SAFETY OFF FORCE	4 4 4	8-20 TC
	I) FIRING PIN INDENT	.024 .024 .024	8-20 TC
690	PACK	9-9-08	TC

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6594628.___0
FILE DATE AND TIME: 08/05/2008 04:37

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.034
The Average Y Centroid of the Five Target Set:	-0.046
The Average Point of Impact of the Five Target Set:	0.057
The Average Mean Radius of the Five Target Set:	0.668
The Distance from POA to Centroid Target #1:	0.193
The Distance from Centroid Target #2 to Centroid Target #1:	0.269
The Distance from Centroid Target #3 to Centroid Target #1:	0.101
The Distance from Centroid Target #4 to Centroid Target #1:	0.208
The Distance from Centroid Target #5 to Centroid Target #1:	0.282

SERIAL NUMBER: C6594628. 0

TARGET NUMBER: 1

FILE DATE: 08/05/2008

FILE TIME: 04:37

POINT#	X	Y
1:	-0.371	0.946
2:	-0.270	0.688
3:	0.283	0.670
4:	0.027	-0.833
5:	-0.343	-1.001
6:	-0.179	-0.156
7:	-0.651	0.132
8:	-0.271	0.041
9:	-1.380	0.017
10:	1.280	-0.941

X CENTROID: -0.188

Y CENTROID: -0.044

POA TO CENTROID: 0.193

HORZ SPREAD: 2.660

VERT SPREAD: 1.947

GROUP SPREAD: 2.827

MIN RADIUS: 0.113

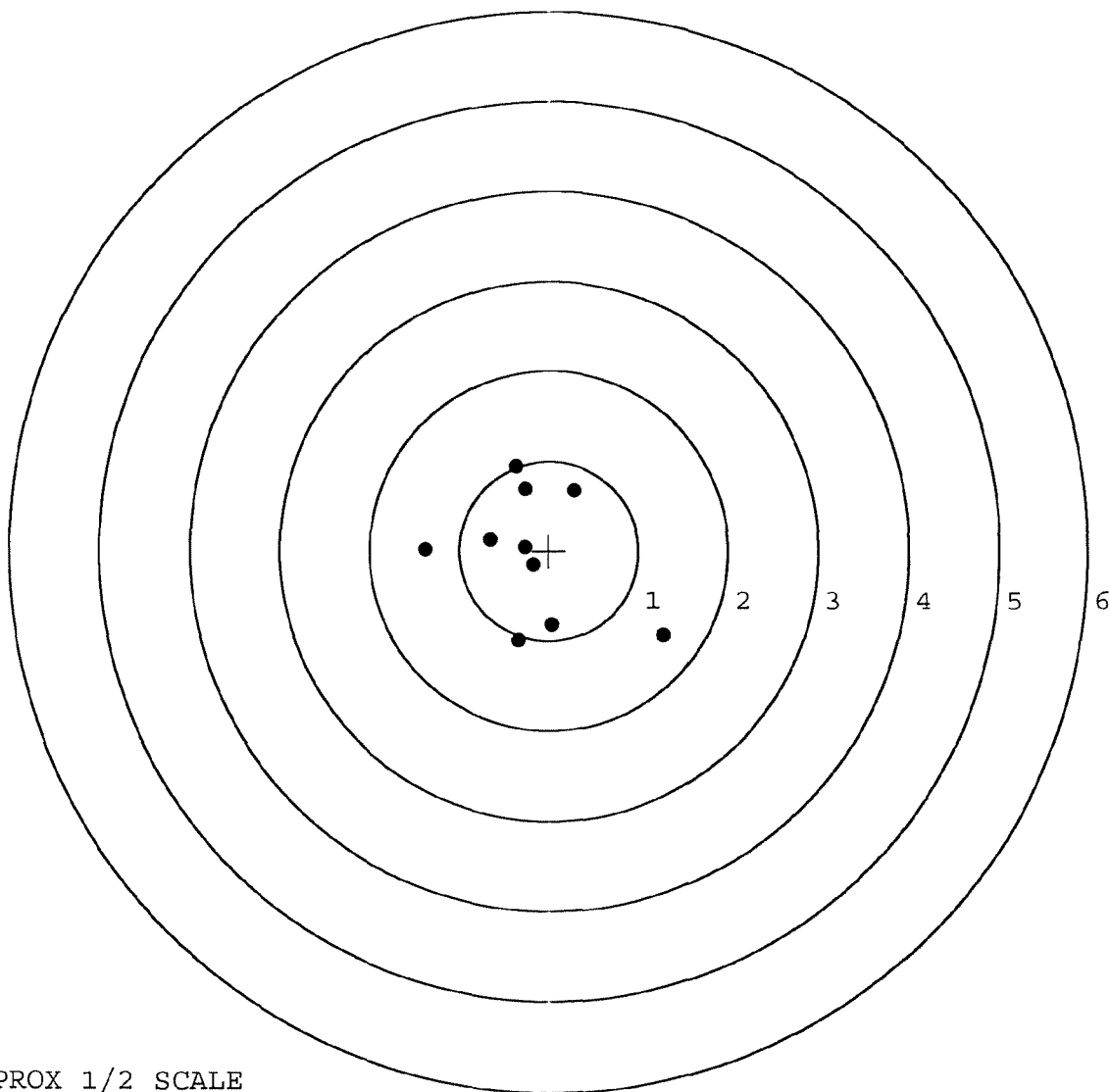
MAX RADIUS: 1.720

MEAN RADIUS: 0.803

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6594628. __0

TARGET NUMBER: 2

FILE DATE: 08/05/2008

FILE TIME: 04:37

POINT#	X	Y
1:	0.116	-1.217
2:	-0.065	-1.089
3:	-0.520	0.576
4:	-0.421	0.261
5:	0.354	0.233
6:	0.046	0.157
7:	-0.072	-0.335
8:	-0.045	-0.030
9:	0.511	-0.190
10:	0.372	-0.414

X CENTROID: 0.028

Y CENTROID: -0.205

POA TO CENTROID: 0.207

HORZ SPREAD: 1.031

VERT SPREAD: 1.793

GROUP SPREAD: 1.902

MIN RADIUS: 0.164

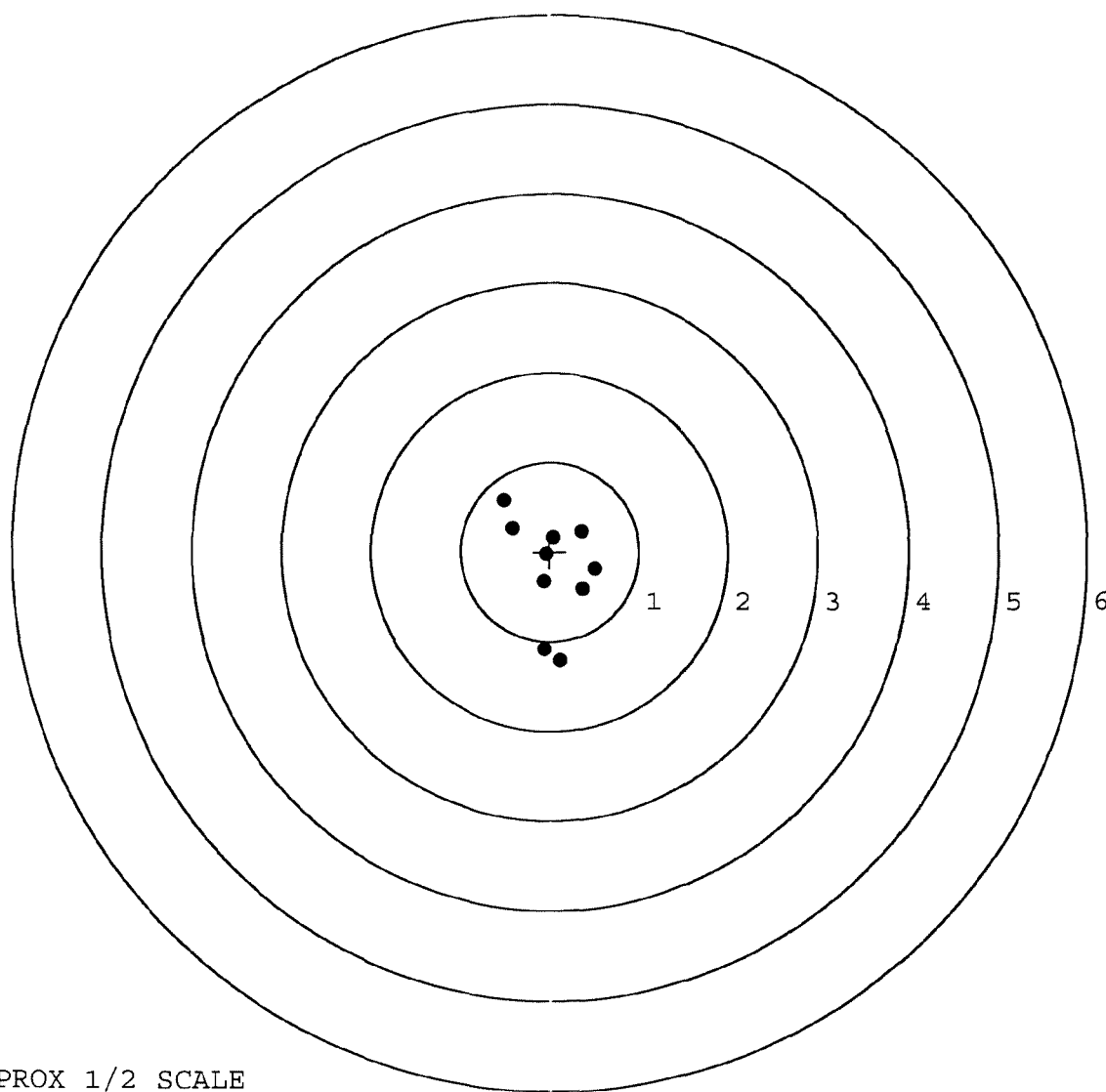
MAX RADIUS: 1.016

MEAN RADIUS: 0.565

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6594628.___0

TARGET NUMBER: 3

FILE DATE: 08/05/2008

FILE TIME: 04:37

X CENTROID: -0.089

Y CENTROID: -0.022

POA TO CENTROID: 0.091

HORZ SPREAD: 1.398

VERT SPREAD: 1.855

GROUP SPREAD: 1.959

MIN RADIUS: 0.154

MAX RADIUS: 1.194

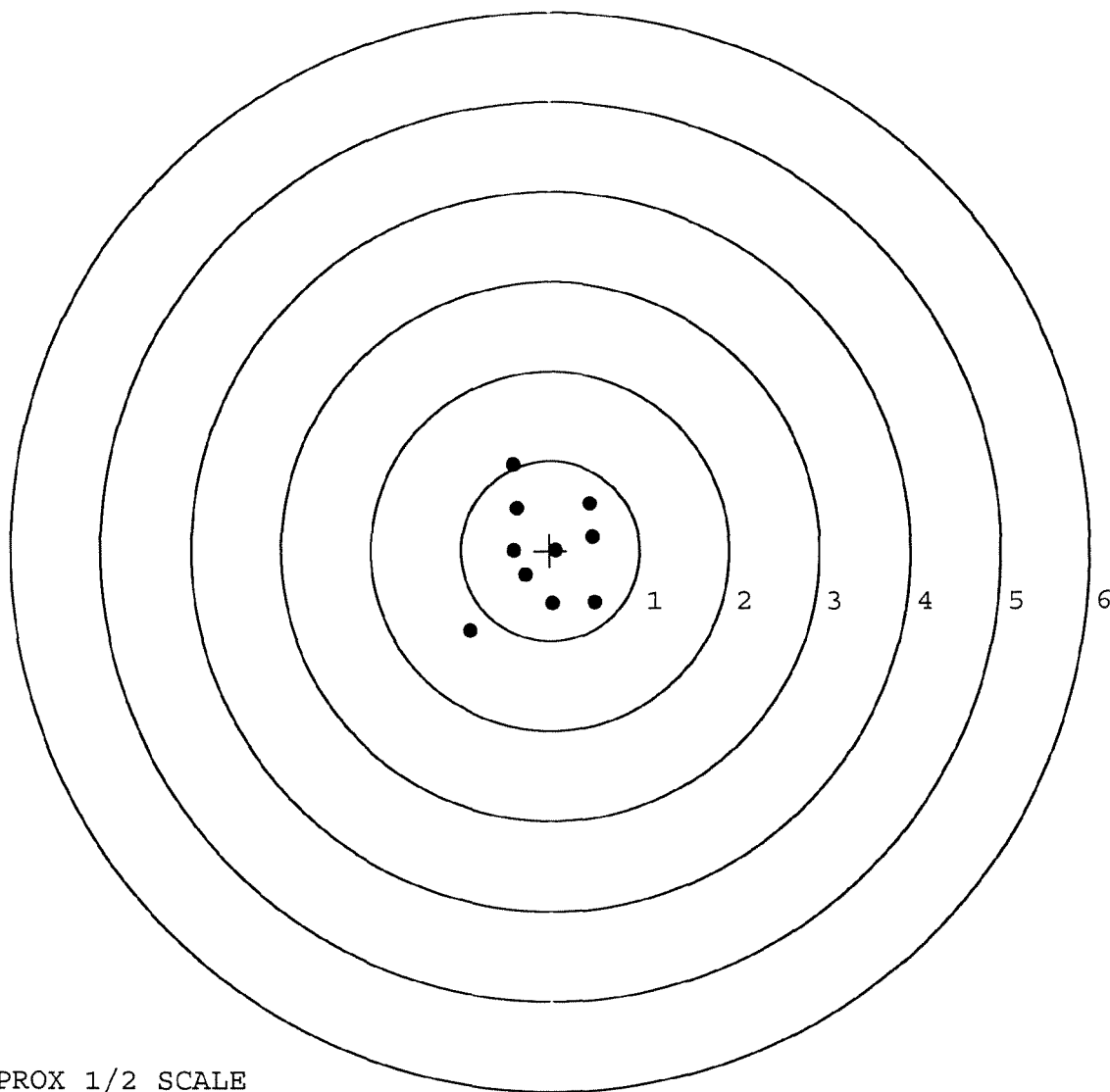
MEAN RADIUS: 0.633

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.415	0.958
2:	-0.377	0.467
3:	0.440	0.531
4:	0.476	0.158
5:	0.497	-0.570
6:	0.026	-0.593
7:	0.065	-0.006
8:	-0.284	-0.269
9:	-0.413	0.005
10:	-0.901	-0.897



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6594628. __0

TARGET NUMBER: 4

FILE DATE: 08/05/2008

FILE TIME: 04:37

X CENTROID: 0.020

Y CENTROID: -0.052

POA TO CENTROID: 0.056

HORZ SPREAD: 1.046

VERT SPREAD: 1.288

GROUP SPREAD: 1.456

MIN RADIUS: 0.191

MAX RADIUS: 0.752

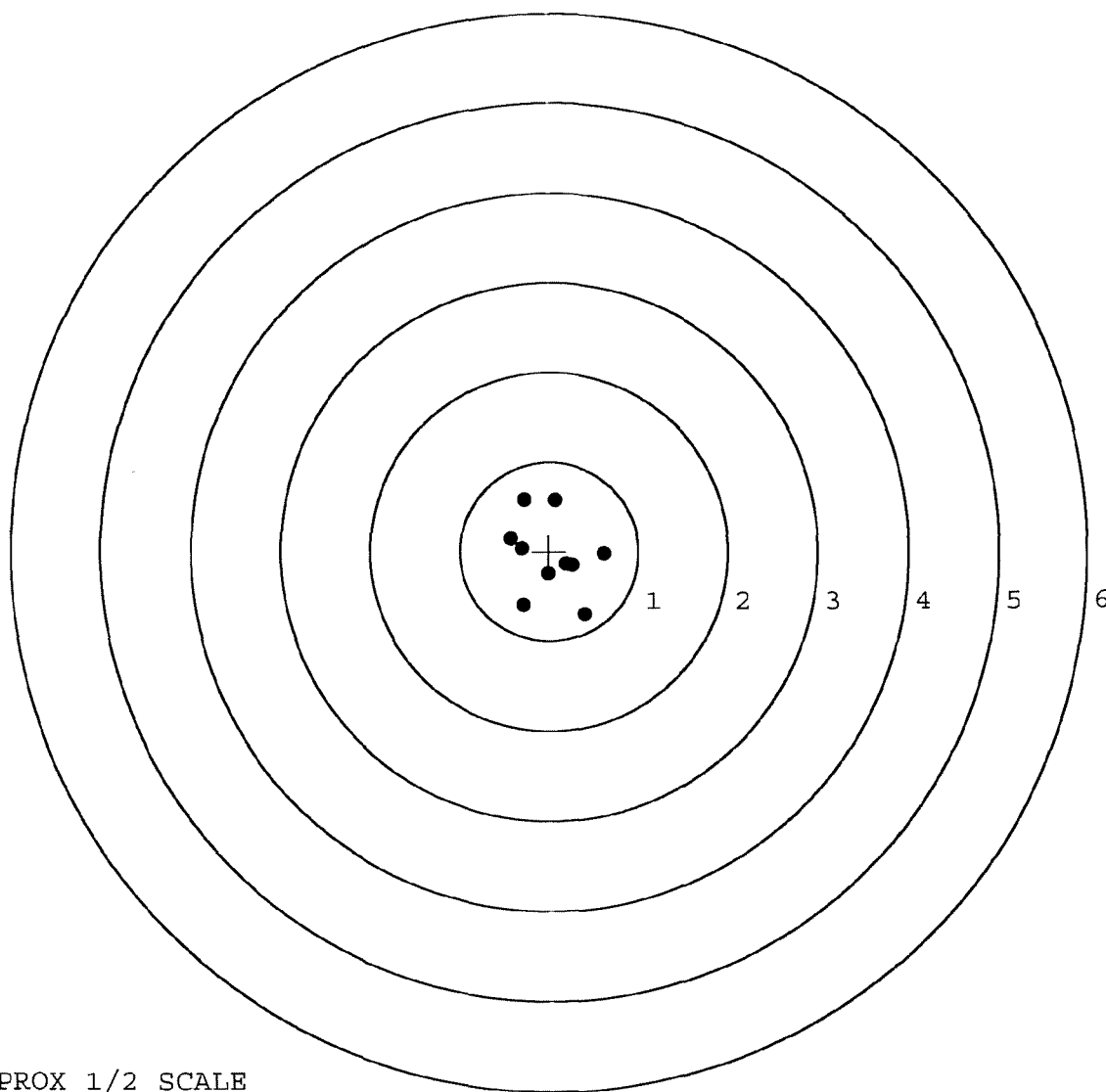
MEAN RADIUS: 0.481

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.298	-0.605
2:	0.398	-0.702
3:	0.619	-0.021
4:	0.262	-0.154
5:	0.067	0.579
6:	-0.282	0.586
7:	-0.427	0.153
8:	-0.307	0.039
9:	-0.014	-0.249
10:	0.187	-0.145



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6594628. __0

TARGET NUMBER: 5

FILE DATE: 08/05/2008

FILE TIME: 04:37

POINT#	X	Y
1:	0.010	1.423
2:	0.307	0.931
3:	1.216	0.766
4:	0.543	-0.787
5:	0.061	-1.260
6:	-0.208	-0.509
7:	-0.484	-0.425
8:	-0.114	0.281
9:	-0.299	0.428
10:	-0.443	0.095

X CENTROID: 0.059

Y CENTROID: 0.094

POA TO CENTROID: 0.111

HORZ SPREAD: 1.700

VERT SPREAD: 2.683

GROUP SPREAD: 2.683

MIN RADIUS: 0.254

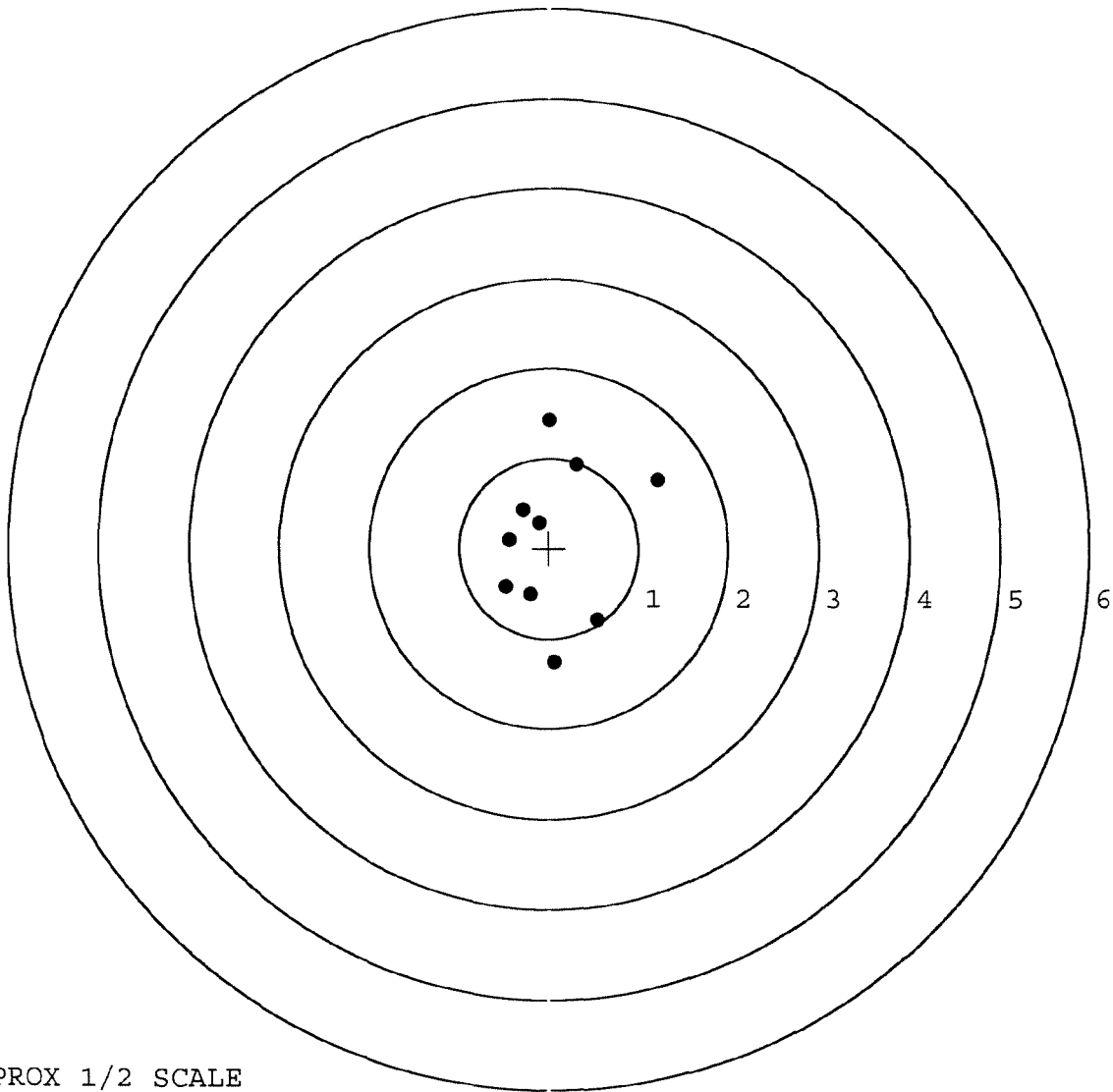
MAX RADIUS: 1.354

MEAN RADIUS: 0.856

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

Remington®

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

DUPONT

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

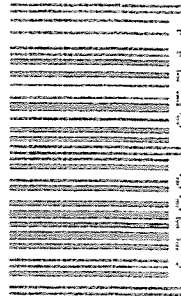
MODEL 700™ H24

SERIAL NO.
06594628

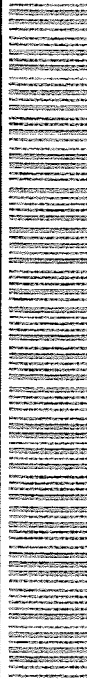
ORDER NO.
5716

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

UPC



0 4700 25716 7



5716 06594628

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C 6594628

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		12/24/90	K.S.
600	Proof		12/24/90	K.S.
607	Check Headspace		12/24/90	K.S.
610	Dis-assemble Gun		12/24/90	K.S.
612	Magnaflux Barrel Action		1-7-91	KR
	Magnaflux Bolt		1-7-91	KR
615	Rollmark Caliber		1-7-91	GL
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)			
625	Final Assembly A) Clean inside of Bolt Assembly		2/4/91	KA
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		2/4/91	KA
	C) Inspect Ejector Hole for Chamfer		2/4/91	KA
	D) Oil Firing Pin Ass'y		2/4/91	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	6 1/2	6 3/4	6 3/4			7/7/91	WB
	G) Safety Off Force	3	3	3 1/4			7/7/91	WB
	H) Trigger Pull Test & Retainability						2/7/91	SM
	I) Firing Pin Indent	.0205	.0205	.0205			7/7/91	WB
	J) Assemble Stock						2/7/91	KH
	K) Assemble Swivel Studs						2-22-91	AC
	L) Attach Front and Rear Sight Assemblies						2/7/91	KH
	M) Iron Sight Alignment						2/7/91	KH
	N) Detach Front & Rear Sights & place in numbered container						2/7/91	KH
	O) Attach Scope to Rifle						2/7/91	KH
	P) Detach & Attach Scope 20 Times						2/7/91	KH
640	Gallery Target & Test						2-8-91	AC
	A) Time						2-8-91	AC
	B) Malfunctions						2-8-91	AC
	C) Pierced Primers						2-8-91	AC
	D) Optical Clarity of Scope						2-8-91	AC
645	Inspect for Live Ammo						2-8-91	AC
655	Final Inspection							
	A) Headspace						2-22-91	AC
	B) Trigger Pull	2.24	2.30	2.20	2.30	2.26	7/19/91	WB
	C) Function						2-22-91	AC
660	Pack						7-18-91	DH

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

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

SERIAL NO. C6594628

DATE 2/7/91

TESTER JEL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.42	2.15	2.26	2.24	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.39	2.30	2.29	2.30	
PULL #3	2.27	2.28	2.40	2.20	
PULL #4	2.32	2.40	2.33	2.30	
PULL #5	2.26	2.24	2.28	2.26	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.44	3.26		
PULL #2	3.24	3.20		
PULL #3	3.14	3.17		
PULL #4	3.12	3.18		
PULL #5	3.26	3.21		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.38	4.39		4.37
PULL #2	4.45	4.45		4.41
PULL #3	4.47	4.15		4.50
PULL #4	4.48	4.45		4.50
PULL #5	4.20	4.32		4.46
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6594628
8 Feb 1991

CENTROIDAL DISTANCES

0 TO	1	.332254
1 TO	2	.521211
1 TO	3	.145248
1 TO	4	.280471
1 TO	5	.255031

⊙ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1238
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0086
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .124098
THE AMR FOR THIS RIFLE IS: .8284

8 Feb 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06594628

CENTERFIRE PATTERNS

1

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 4

2in = 5

3in = 9

HS= 2.890

VS= 1.964

GS= 2.933

CENTROID *

PATTERN #

1

SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.708	1.429	1.330
MINIMUM X	:	-1.182	-.993	-1.092
MAXIMUM Y	:	1.040	1.000	.880
MINIMUM Y	:	-.924	-.964	-.516
CENTROID X	:	.332	.143	.242
CENTROID Y	:	.013	.053	.173
POA TO CENTROID in.	:	.333	.152	.297
MIN RADIUS	:	.148	.167	.323
MEAN RADIUS	:	.875	.767	.707
MAX RADIUS	:	1.744	1.432	1.346
HORIZONTAL SPREAD	:	2.890	2.422	2.422
VERTICAL SPREAD	:	1.964	1.964	1.396
EXTREME SPREAD	:	2.933	2.430	2.430
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		5	

NUMBER IN THREE INCH CIRCLE =

9

8 Feb 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6594628

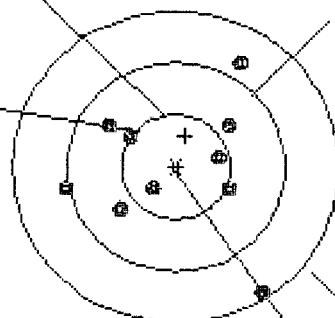
CENTERFIRE PATTERNS # 2

POA

1in circle

2in circle

3in circle



OF SHOTS- 10

IN CIR

1in = 3

2in = 7

3in = 10

HS= 1.791

VS= 2.133

GS= 2.139

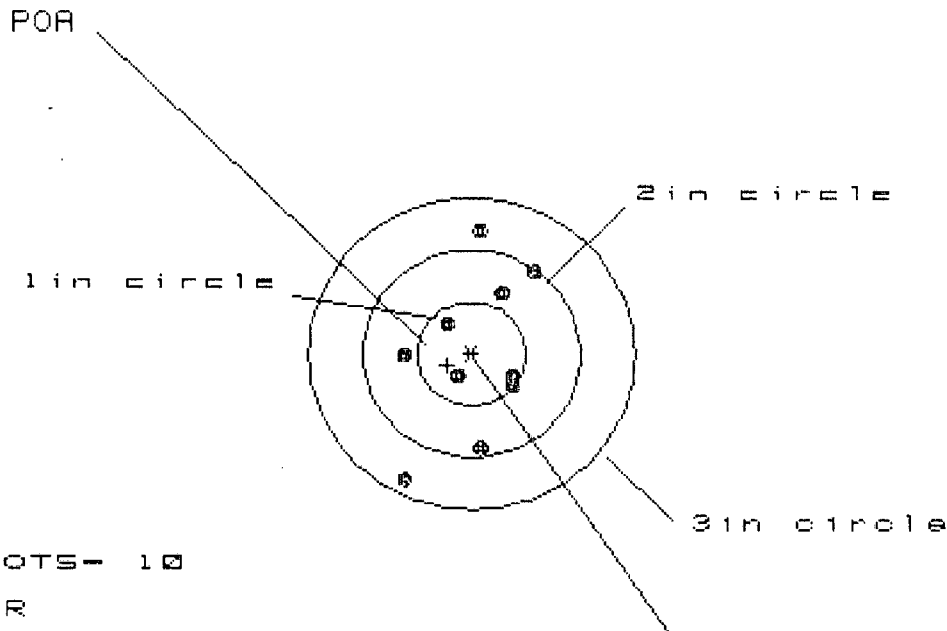
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.738	.659	.645
MINIMUM X	:	-1.052	-.970	-.888
MAXIMUM Y	:	.957	.827	.408
MINIMUM Y	:	-1.176	-.510	-.407
CENTROID X	:	-.087	-.170	-.252
CENTROID Y	:	-.297	-.167	-.270
POA TO CENTROID in.	:	.310	.238	.369
MIN RADIUS	:	.299	.320	.278
MEAN RADIUS	:	.726	.644	.578
MAX RADIUS	:	1.388	1.057	.908
HORIZONTAL SPREAD	:	1.791	1.629	1.533
VERTICAL SPREAD	:	2.133	1.337	.815
EXTREME SPREAD	:	2.139	1.976	1.618
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

8 Feb 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06594628

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 4

2 in = 8

3 in = 10

HS= 1.224

VS= 2.322

GS= 2.420

CENTROID *

PATTERN #	3	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.560	.489	.484
MINIMUM X	-.664	-.735	-.740
MAXIMUM Y	1.146	1.015	.786
MINIMUM Y	-1.176	-1.072	-.945
CENTROID X	.223	.294	.299
CENTROID Y	.109	.240	.113
POA TO CENTROID in.	.248	.380	.320
MIN RADIUS	.204	.337	.252
MEAN RADIUS	.720	.650	.587
MAX RADIUS	1.341	1.072	.945
HORIZONTAL SPREAD	1.224	1.224	1.224
VERTICAL SPREAD	2.322	2.087	1.731
EXTREME SPREAD	2.420	2.087	1.798
NUMBER IN ONE INCH CIRCLE =	4		
NUMBER IN TWO INCH CIRCLE =	8		
NUMBER IN THREE INCH CIRCLE =	10		

8 Feb 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6594628

CENTERFIRE PATTERNS

4

POA

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 3

2 in = 7

3 in = 9

HS= 1.813

VS= 2.641

GS= 2.782

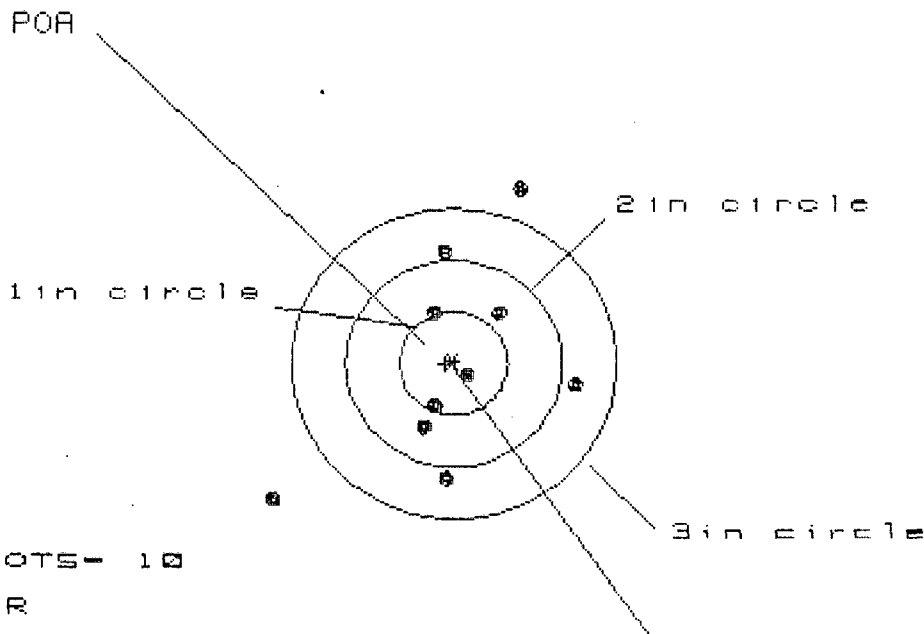
CENTROID #

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.901	.993	1.018
MINIMUM X	-.912	-.820	-.696
MAXIMUM Y	1.456	.650	.522
MINIMUM Y	-1.185	-1.023	-.847
CENTROID X	.074	-.018	-.142
CENTROID Y	.123	-.039	.089
POA TO CENTROID in.	.143	.043	.167
MIN RADIUS	.255	.248	.070
MEAN RADIUS	.837	.738	.584
MAX RADIUS	1.672	1.425	1.073
HORIZONTAL SPREAD	1.813	1.813	1.714
VERTICAL SPREAD	2.641	1.673	1.369
EXTREME SPREAD	2.782	2.169	1.905
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	9		

8 Feb 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06594628

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 8

HS= 2.8000

VS= 3.025

GS= 3.775

CENTROID #

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.171	.989	1.044
MINIMUM X	-1.637	-.409	-.354
MAXIMUM Y	1.722	1.577	1.156
MINIMUM Y	-1.303	-1.281	-1.084
CENTROID X	.077	.259	.204
CENTROID Y	.009	.154	-.043
POA TO CENTROID in.	.077	.301	.208
MIN RADIUS	.215	.273	.089
MEAN RADIUS	.984	.853	.724
MAX RADIUS	2.092	1.637	1.174
HORIZONTAL SPREAD	2.808	1.398	1.398
VERTICAL SPREAD	3.025	2.858	2.240
EXTREME SPREAD	3.775	2.943	2.240
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	8		

RECEIVING AND ESTIMATING REPORT

COMMENTS

ORDER
R 94-18795

INITIALS CUSTOMER ORDER NO.

JJM DAAA09-92-C-0834

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

ATTN FRED MARTIN

Scope 89-0589

DATE RECEIVED

DATE OPENED

DATE CODE

SERIAL NUMBER

NEW SERIAL NUMBER

MODEL AND GRADE

06/14/94

06/15/94

C6594628

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

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

AL 36201-5025

AL
36201-5025

CUST NO: 098397 C.B.D.L

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

Trigger Assy

\$173.31

COMMENTS

CTT

50.00

\$223.31

REPAIRMAN

PROOF

CLEAN

TEST

TARGET

PATTERN

GALLERY TESTER

DATE

DATE

DATE

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OFFICE COPY

RD6925 REV. 1/94

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

M2400020653

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

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

SERIAL NO. C16594628

DATE 11-1-94

TESTER BM

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#	COMMENTS
PULL #1	2.65	2.84	2.78	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.80	2.34	2.63	
PULL #3	2.72	2.47	2.76	
PULL #4	2.64	2.31	2.68	
PULL #5	2.71	2.42	2.57	
TOTAL	13.52	12.38	13.42	
AVG.	2.70	2.47	2.68	

	3.00# INITIAL	3.00# AFTER 20 CYCLES	COMMENTS
PULL #1	3.32	3.12	
PULL #2	3.27	3.47	
PULL #3	3.30	3.19	
PULL #4	3.13	3.48	
PULL #5	3.33	3.17	
TOTAL	16.35	16.43	
AVG.	3.27	3.28	

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.12	4.01		4.12
PULL #2	4.00	4.09		4.21
PULL #3	4.26	4.26		4.08
PULL #4	3.90	4.18		4.04
PULL #5	4.09	4.21		3.98
TOTAL	20.37	20.75		20.43
AVG.	4.07	4.15		4.08

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6594628

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	6 1/2	6 1/2	6 1/2			1/25/96	W.B.
	G) Safety Off Force	3	3	3			1/25/96	W.B.
	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						1/22/96	W.B.
	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	2.67	2.65	2.65	2.65	2.65	1/25/96	W.B.
	C) Function							
660	Pack							