

C6594639

MODEL 700TM M24

Model **SMS**TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

M2400020886

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. 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: RE00136246

Serial: C6594639 Model M24 SWS Center Fire
Caliber: 7.62 NATO

Repairman:

Status:

Closed 11/2/2007 10:15:05 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

1:14 PM

CAPS

NUM

INS

SCRL

start

2 Mi...

5 Int...

4 Mi...

Part S...

longo...

Arms ...

1:14 PM

Serial Number: C6594639

Model: M24 SWS



RE00136246

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

R & E NUMBER 136246
SERIAL NUMBER C6594639
LOG-IN DATE 11-2-07

OPERATION #	OPERATION NAME	DATE	INITIAL
500	DIS-ASSEMBLE GUN	7-14-08	RTZ
505	RE-BARREL	7-18-08	RTZ
560	ASSEMBLE	7-15-08	ESW
600	PROOF	7-16-08	TRW
605	CHECK HEADSPACE	7-16-08	TRW
610	DIS-ASSEMBLE GUN	7-18-08	RTZ
612	MAGNAFLUX	7-25-08	BM
510	DRILL AND TAP	7-19-08	SP
615	ROLLMARK CALIBER	7-25-08	RT
618	ROTO-BLAST	7-25-08	RG
620	APPLY COATINGS	8-1	CM
625	FINAL ASSEMBLY	8-6-08	RTZ
640	FUNCTION TEST AND	8-26-08	TRW
650	TARGET	8-26-08	TRW
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
670	FINAL INSPECTION	8-20-08	FM
	A) HEADSPACE	9-10-08	RTZ
		9-10-08	RTZ
	B) TRIGGER PULL	2.41 2.35 2.34 2.37 2.39 9-8-08	Rgn
680	F) SAFETY ON FORCE	5.75 5.75 5.75 9-8-08	RTZ
	G) SAFETY OFF FORCE	3.0 3.0 3.0 9-8-08	RTZ
	I) FIRING PIN INDENT	.023 .023 .023 9-8-08	RTZ
690	PACK	19-10-08	TL

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6594639.__0
FILE DATE AND TIME: 08/27/2008 05:19

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.072
The Average Y Centroid of the Five Target Set:	-0.028
The Average Point of Impact of the Five Target Set:	0.078
The Average Mean Radius of the Five Target Set:	0.618
The Distance from POA to Centroid Target #1:	0.037
The Distance from Centroid Target #2 to Centroid Target #1:	0.346
The Distance from Centroid Target #3 to Centroid Target #1:	0.207
The Distance from Centroid Target #4 to Centroid Target #1:	0.092
The Distance from Centroid Target #5 to Centroid Target #1:	0.087

SERIAL NUMBER: C6594639. __ 0

TARGET NUMBER: 1

FILE DATE: 08/27/2008

FILE TIME: 05:19

X CENTROID: -0.034

Y CENTROID: -0.015

POA TO CENTROID: 0.037

HORZ SPREAD: 1.492

VERT SPREAD: 1.151

GROUP SPREAD: 1.634

MIN RADIUS: 0.216

MAX RADIUS: 0.956

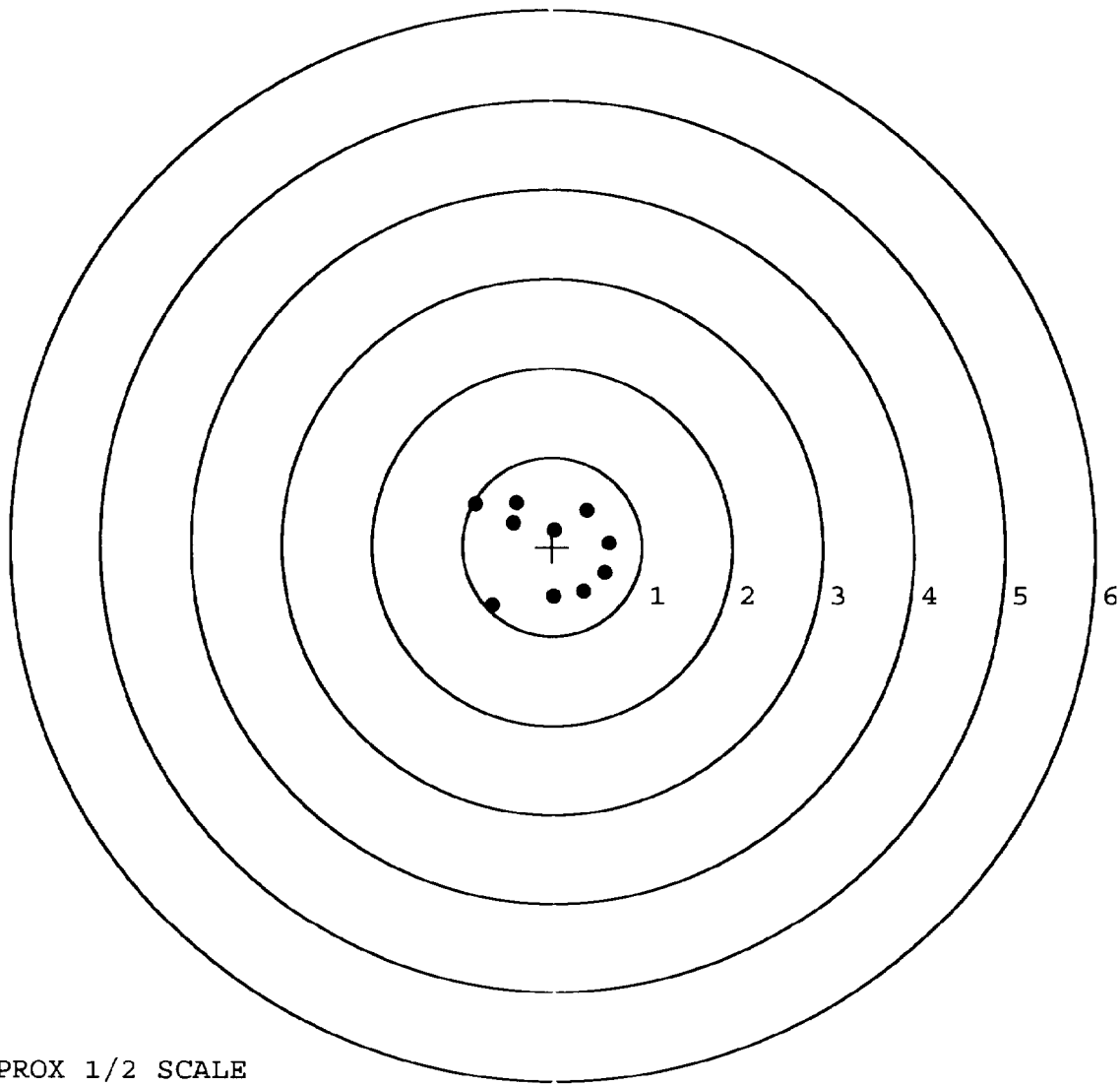
MEAN RADIUS: 0.632

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.668	-0.661
2:	0.019	-0.561
3:	0.347	-0.507
4:	0.582	-0.303
5:	0.640	0.045
6:	0.390	0.411
7:	0.027	0.192
8:	-0.396	0.490
9:	-0.432	0.268
10:	-0.852	0.480

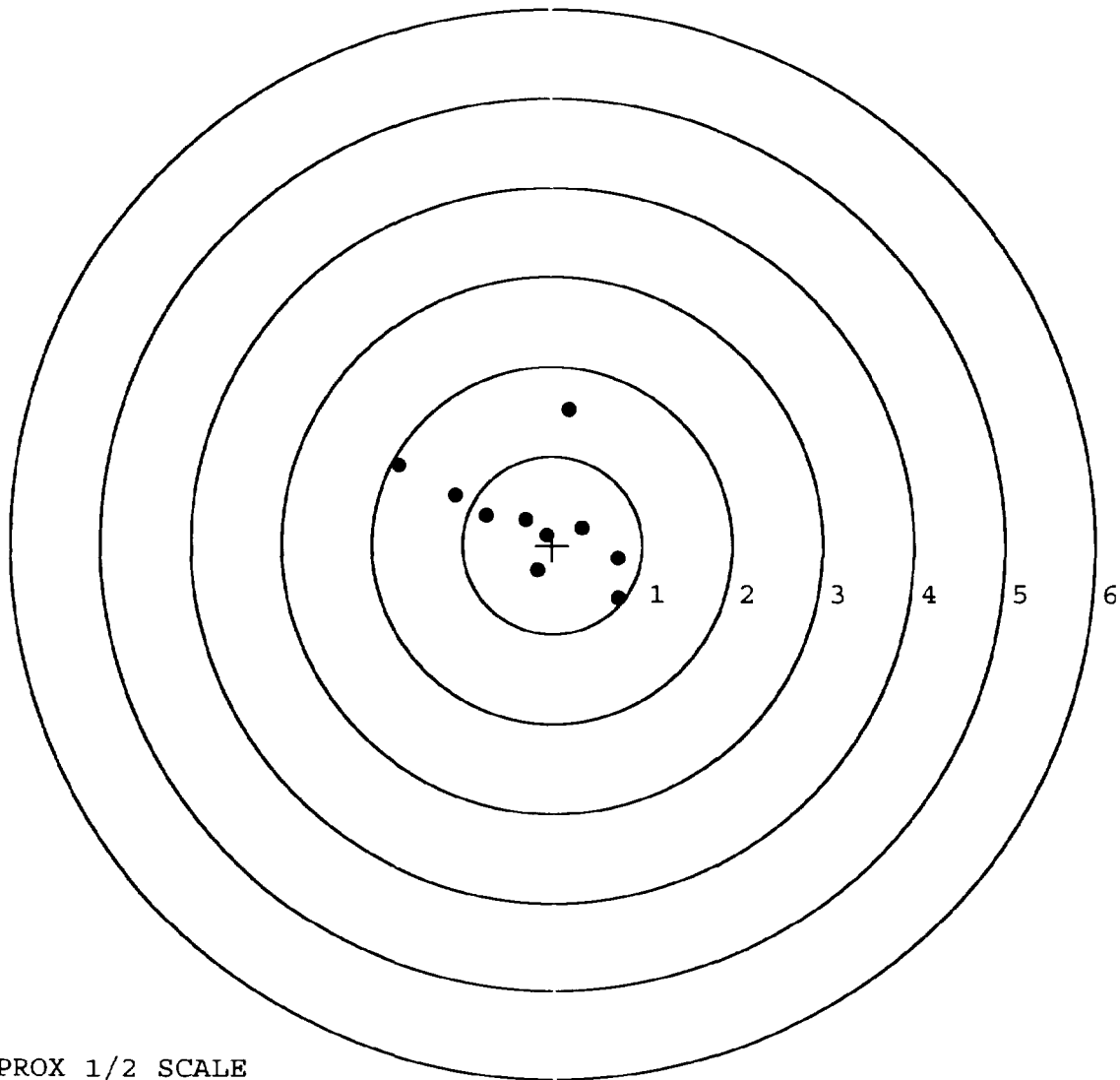


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6594639. __ 0
TARGET NUMBER: 2
FILE DATE: 08/27/2008
FILE TIME: 05:19

X CENTROID: -0.203
Y CENTROID: 0.287
POA TO CENTROID: 0.352
HORZ SPREAD: 2.438
VERT SPREAD: 2.124
GROUP SPREAD: 2.861
MIN RADIUS: 0.093
MAX RADIUS: 1.620
MEAN RADIUS: 0.812
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 6
in 3 IN DIAMETER: 9

POINT#	X	Y
1:	0.732	-0.603
2:	0.734	-0.159
3:	0.334	0.200
4:	-0.066	0.114
5:	-0.296	0.291
6:	-0.728	0.338
7:	-1.075	0.564
8:	-0.160	-0.289
9:	0.196	1.521
10:	-1.704	0.897



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6594639. __0

TARGET NUMBER: 3

FILE DATE: 08/27/2008

FILE TIME: 05:19

X CENTROID: 0.004

Y CENTROID: -0.218

POA TO CENTROID: 0.218

HORZ SPREAD: 1.169

VERT SPREAD: 1.554

GROUP SPREAD: 1.715

MIN RADIUS: 0.133

MAX RADIUS: 0.999

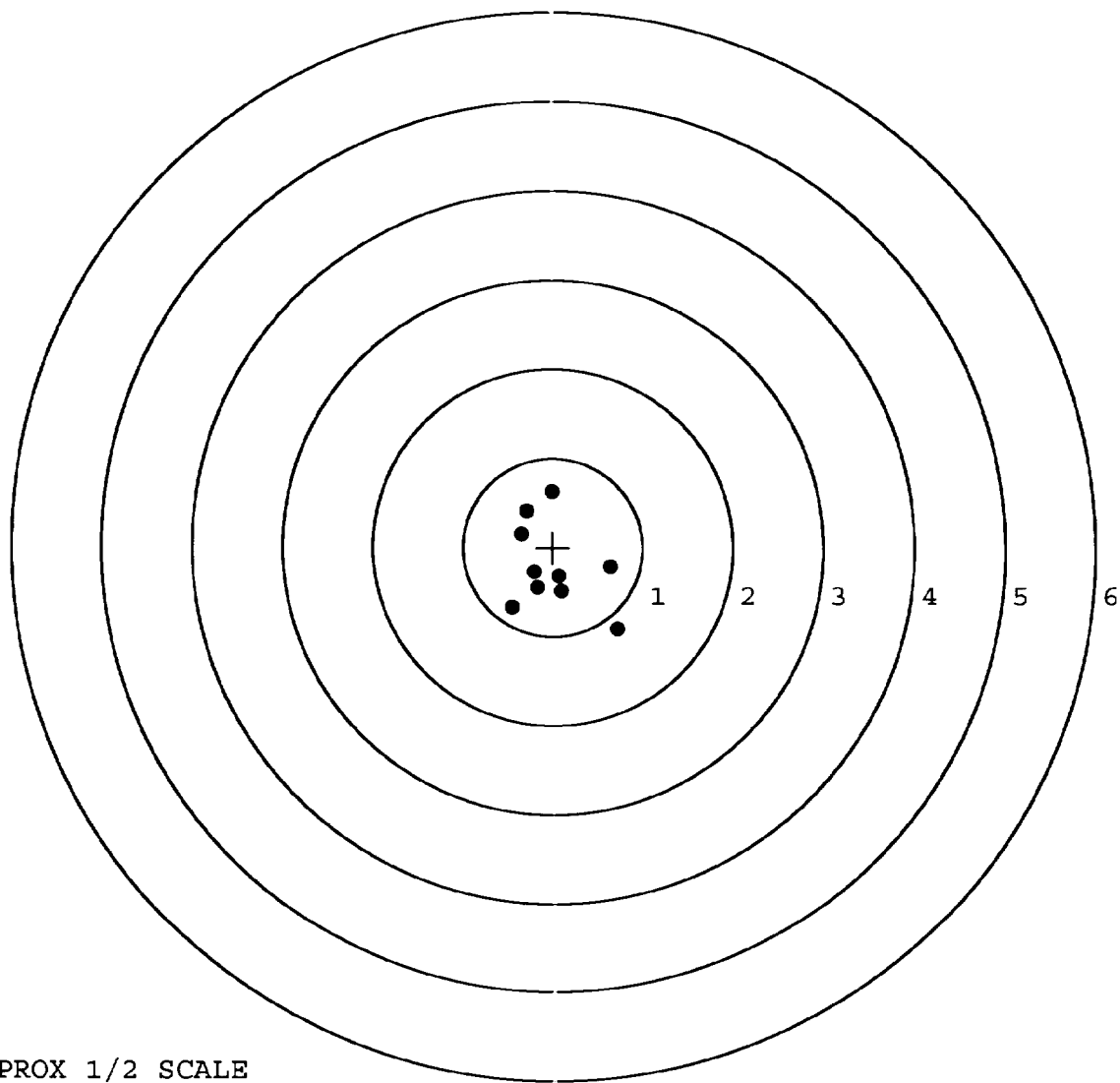
MEAN RADIUS: 0.530

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.714	-0.921
2:	0.641	-0.224
3:	-0.455	-0.674
4:	-0.352	0.159
5:	-0.288	0.414
6:	-0.011	0.633
7:	0.100	-0.494
8:	0.072	-0.332
9:	-0.211	-0.284
10:	-0.174	-0.459



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6594639.___0

TARGET NUMBER: 4

FILE DATE: 08/27/2008

FILE TIME: 05:19

X CENTROID: -0.084

Y CENTROID: -0.092

POA TO CENTROID: 0.124

HORZ SPREAD: 1.613

VERT SPREAD: 2.037

GROUP SPREAD: 2.489

MIN RADIUS: 0.371

MAX RADIUS: 1.645

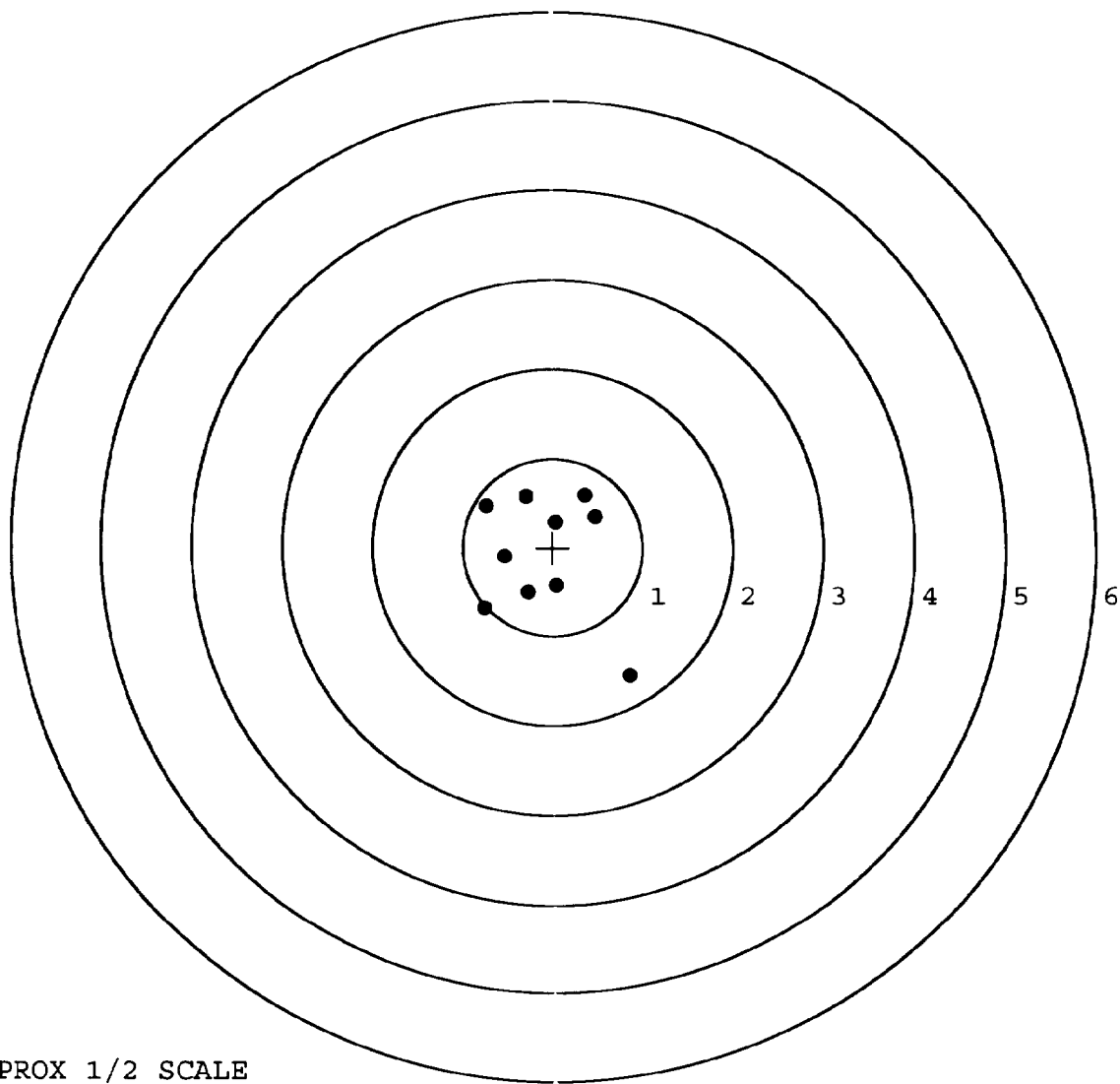
MEAN RADIUS: 0.733

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 9

POINT#	X	Y
1:	0.848	-1.447
2:	-0.765	-0.693
3:	-0.275	-0.512
4:	0.045	-0.439
5:	-0.534	-0.101
6:	-0.739	0.471
7:	-0.299	0.578
8:	0.476	0.350
9:	0.365	0.590
10:	0.035	0.287

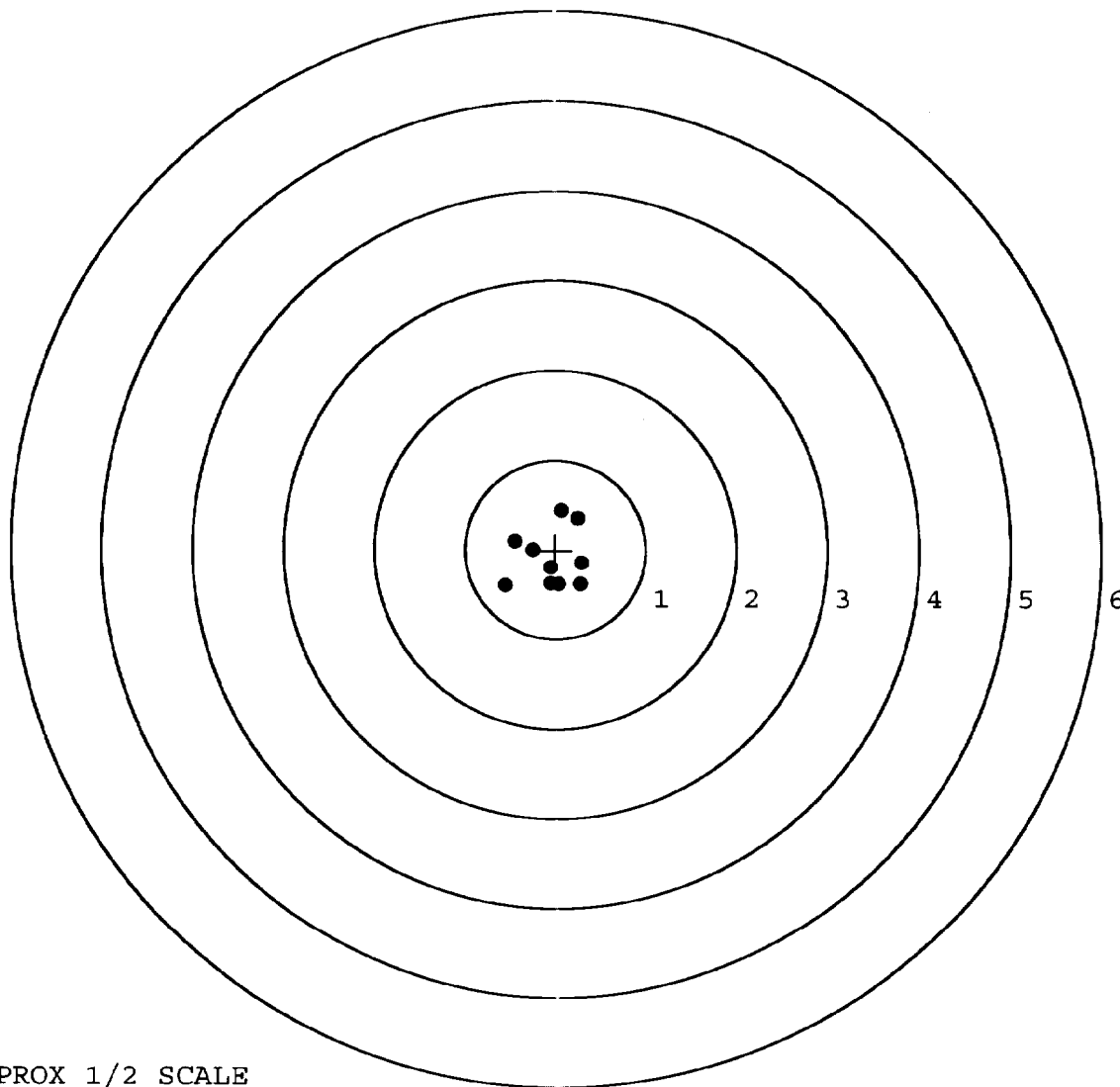


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6594639. __0
TARGET NUMBER: 5
FILE DATE: 08/27/2008
FILE TIME: 05:19

X CENTROID: -0.044
Y CENTROID: -0.101
POA TO CENTROID: 0.111
HORZ SPREAD: 0.845
VERT SPREAD: 0.842
GROUP SPREAD: 1.107
MIN RADIUS: 0.100
MAX RADIUS: 0.595
MEAN RADIUS: 0.383
IN 1 IN DIAMETER: 7
IN 2 IN DIAMETER: 10
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.250	0.354
2:	0.072	0.440
3:	-0.451	0.104
4:	-0.558	-0.402
5:	-0.248	0.001
6:	-0.055	-0.201
7:	-0.056	-0.384
8:	0.280	-0.389
9:	0.287	-0.149
10:	0.040	-0.389



TARGET APPROX 1/2 SCALE

Remington®



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

MODEL 700™ M24

SERIAL NO.
C6594639

ORDER NO.
5716

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

20



5716 C6594639

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6594639

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	1 16	91	RW
600	Proof	1 16	91	RW
607	Check Headspace	1 18	91	RW
610	Dis-assemble Gun	1 18	91	RW
612	Magnaflux Barrel Action	1 18	91	KR
	Magnaflux Bolt	1 18	91	KR
615	Rollmark Caliber	1 18	91	SS
617	Drill and Tap Sight Holes	1 24	91	LB
618	Polish Barrel	1 24	91	WB
620	Apply Coatings (Barrel Action)		2-15-91	SA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		2/18/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		2/18/91	RW
	C) Inspect Ejector Hole for Chamfer		2/18/91	RW
	D) Oil Firing Pin Ass'y		2/18/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		3-1-91	JH

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4 ³ / ₄	4 ³ / ₄	4 ³ / ₄			3/1/91	WB
	G) Safety Off Force	2 ³ / ₄	2 ³ / ₄	2 ³ / ₄			3/1/91	WB
	H) Trigger Pull Test & Retainability						3-1-91	JS
	I) Firing Pin Indent	.0235	.0235	.0235			3/1/91	WB
	J) Assemble Stock						3/2/91	RW
	K) Assemble Swivel Studs						3-6-91	DH
	L) Attach Front and Rear Sight Assemblies						3/2/91	RW
	M) Iron Sight Alignment						3/2/91	RW
	N) Detach Front & Rear Sights & place in numbered container						3/2/91	RW
	O) Attach Scope to Rifle						3/2/91	RW
	P) Detach & Attach Scope 20 Times						3/2/91	RW
640	Gallery Target & Test						3-4-91	DH
	A) Time						3-4-91	DH
	B) Malfunctions						3-4-91	DH
	C) Pierced Primers						3-4-91	DH
	D) Optical Clarity of Scope						3-4-91	DH
645	Inspect for Live Ammo						3-4-91	DH
655	Final Inspection							
	A) Headspace						3-6-91	DH
	B) Trigger Pull	2.48	2.36	2.32	2.37	2.35	3-5-91	JS
	C) Function						3-6-91	DH
660	Pack						3-15-91	DH

SWS TRIGGER PULL TEST

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

SERIAL NO. C6594639

DATE 3-1-91

TESTER [Signature]

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.46	2.36	2.29	2.48	MIN. SETTING,
PULL #2	2.36	2.28	2.32	2.36	NO AVG. OF 5
PULL #3	2.39	2.39	2.26	2.32	READINGS ACCEPT-
PULL #4	2.32	2.38	2.29	2.37	ABLE LESS THAN 2#
PULL #5	2.34	2.26	2.24	2.35	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.23	3.51		
PULL #2	3.45	3.41		
PULL #3	3.43	3.19		
PULL #4	3.44	3.35		
PULL #5	3.37	3.35		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.43	4.42		4.43
PULL #2	4.42	4.41		4.39
PULL #3	4.46	4.41		4.37
PULL #4	4.40	4.44		4.37
PULL #5	4.38	4.41		4.37
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06594639
4 Mar 1991

CENTROIDAL DISTANCES

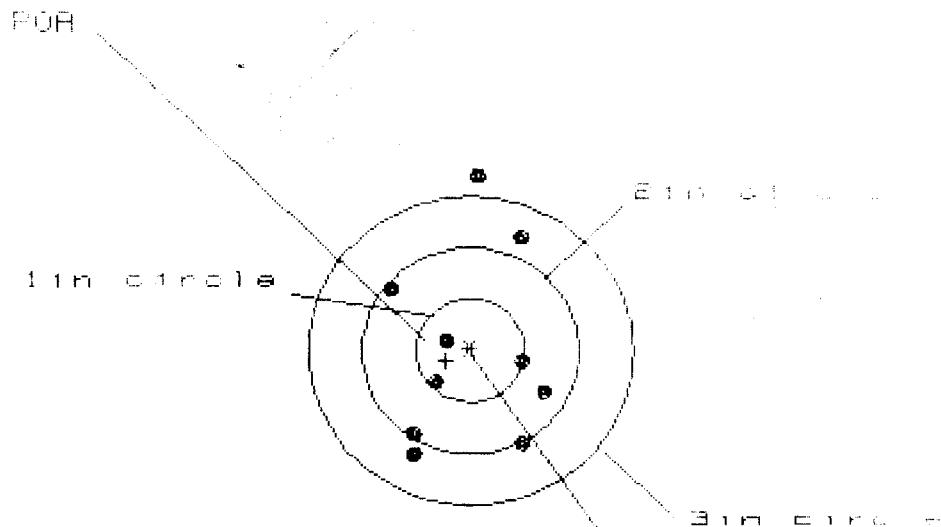
0 TO	1	.246333
1 TO	2	.227783
1 TO	3	.0888369
1 TO	4	.0945304
1 TO	5	.342584

+8 <----FOR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .2924
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0254
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .293581

THE AMP FOR THIS RIFLE IS: .9064

CENTERFIRE PATTERN



OF SHOTS - 10

IN CIR

1in = 2

2in = 6

3in = 9

HS = 1.437

VS = 2.720

GS = 2.781

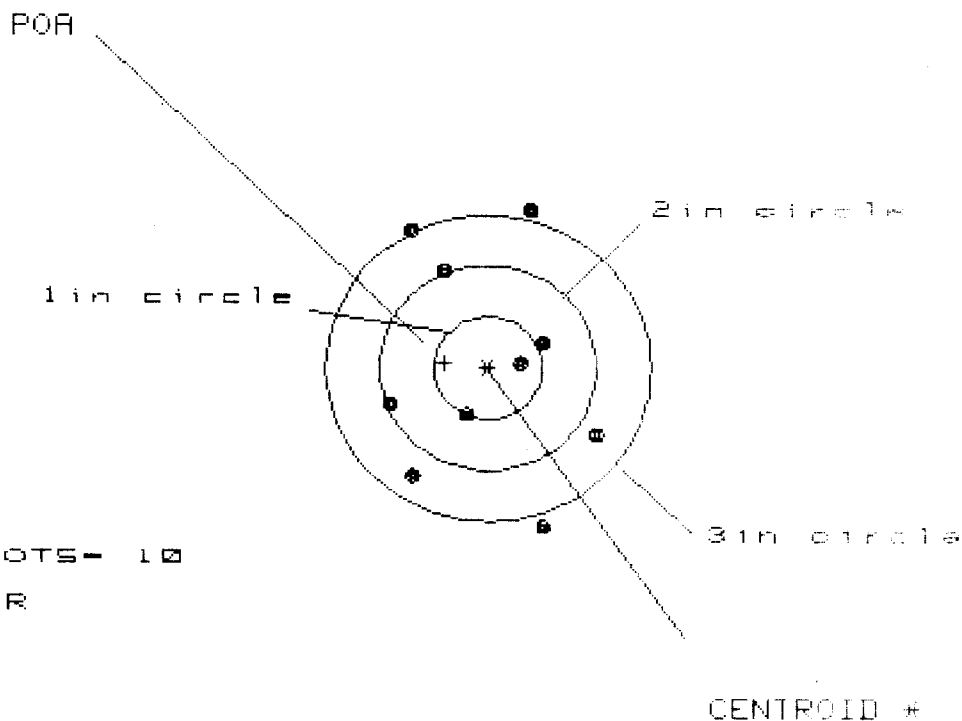
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.696	.704	.770
MINIMUM X	-.741	-.733	-.667
MAXIMUM Y	1.740	1.271	.921
MINIMUM Y	-.980	-.787	-.628
CENTROID X	.226	.218	.152
CENTROID Y	.098	-.095	-.254
FOR TO CENTROID in.	.246	.238	.296
MIN RADIUS	.233	.318	.206
MEAN RADIUS	.897	.778	.685
MAX RADIUS	1.741	1.375	1.137
HORIZONTAL SPREAD	1.437	1.437	1.407
VERTICAL SPREAD	2.720	2.058	1.847
EXTREME SPREAD	2.781	2.300	1.998
CUMBER IN ONE INCH CIRCLE =	2		
CUMBER IN TWO INCH CIRCLE =	6		
CUMBER IN THREE INCH CIRCLE =	9		

8 Mar 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06594639

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 7

HS= 1.882

VS= 3.108

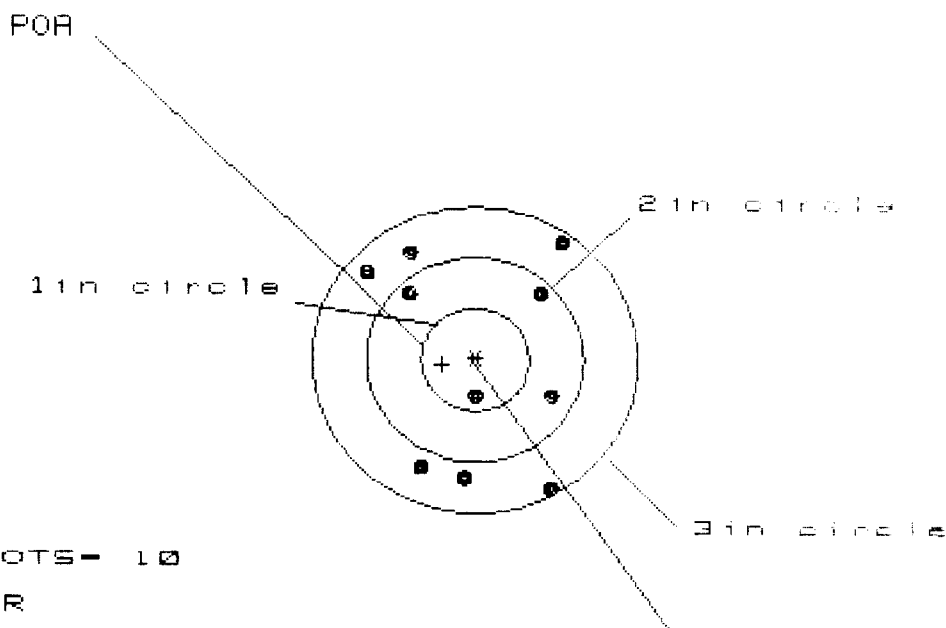
GS= 3.150

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.013	1.068	1.130
MINIMUM X	:	-.869	-.814	-.752
MAXIMUM Y	:	1.538	1.363	1.349
MINIMUM Y	:	-1.570	-1.193	-1.022
CENTROID X	:	.400	.345	.283
CENTROID Y	:	-.049	.126	-.045
POA TO CENTROID in.	:	.403	.367	.287
MIN RADIUS	:	.312	.399	.429
MEAN RADIUS	:	1.049	.985	.911
MAX RADIUS	:	1.648	1.450	1.459
HORIZONTAL SPREAD	:	1.882	1.882	1.882
VERTICAL SPREAD	:	3.108	2.556	2.371
EXTREME SPREAD	:	3.150	2.790	2.650
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	5		
NUMBER IN THREE INCH CIRCLE	=	7		

4 Mar 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06594639

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 1

2in = 4

3in = 10

HS= 1.827

VS= 2.392

GS= 2.717

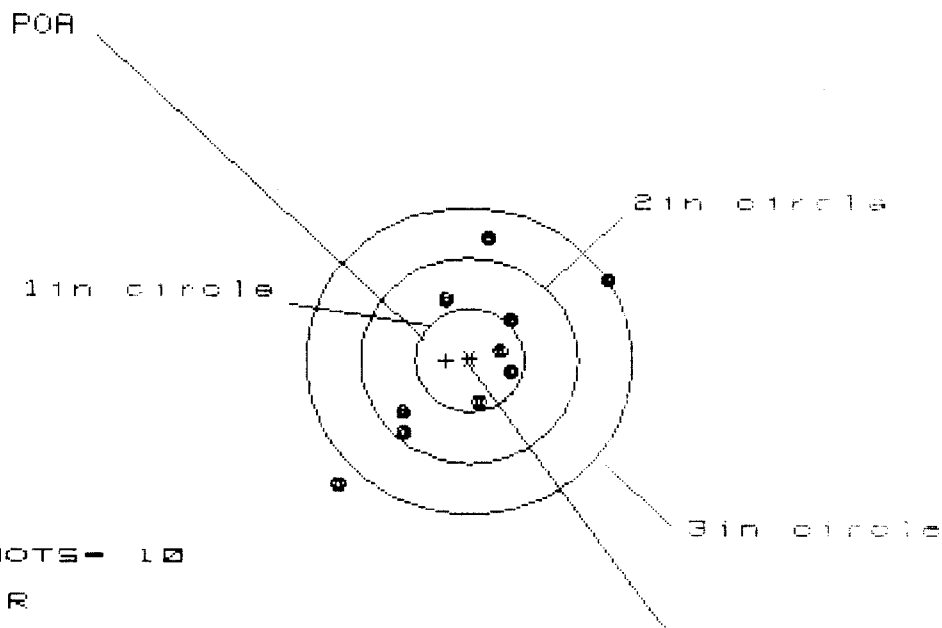
CENTROID +

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.833	.907	.837
MINIMUM X	:	-.994	-.920	-.887
MAXIMUM Y	:	1.110	.968	.999
MINIMUM Y	:	-1.282	-1.340	-1.219
CENTROID X	:	.302	.228	.115
CENTROID Y	:	.052	.194	.073
POA TO CENTROID in.	:	.307	.299	.136
MIN RADIUS	:	.370	.520	.441
MEAN RADIUS	:	1.062	1.016	.969
MAX RADIUS	:	1.446	1.341	1.221
HORIZONTAL SPREAD	:	1.827	1.827	1.644
VERTICAL SPREAD	:	2.392	2.308	2.218
EXTREME SPREAD	:	2.717	2.566	2.278
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		10	

4 Mar 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08594639

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 3

2in = 7

3in = 8

HS= 2.509

VS= 2.424

GS= 3.233

CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.318	1.186	.487
MINIMUM X	:	-1.191	-.764	-.616
MAXIMUM Y	:	1.184	1.047	1.129
MINIMUM Y	:	-1.240	-.876	-.794
CENTROID X	:	.216	.348	.280
CENTROID Y	:	.004	.141	.059
POA TO CENTROID in.	:	.216	.376	.288
MIN RADIUS	:	.261	.128	.265
MEAN RADIUS	:	.841	.714	.646
MAX RADIUS	:	1.719	1.358	1.148
HORIZONTAL SPREAD	:	2.509	1.950	1.823
VERTICAL SPREAD	:	2.424	1.923	1.923
EXTREME SPREAD	:	3.233	2.484	2.891
NUMBER IN ONE INCH CIRCLE =			3	
NUMBER IN TWO INCH CIRCLE =			7	
NUMBER IN THREE INCH CIRCLE =			8	

4 Mar 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06594639

CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 4

2in = 8

3in = 10

HS= 1.916

VS= 1.785

GS= 2.276

PATTERN #	:	5	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.625	.482	.454
MINIMUM X	:	-1.290	-.758	-.786
MAXIMUM Y	:	1.197	1.270	.376
MINIMUM Y	:	-.588	-.515	-.356
CENTROID X	:	.318	.461	.489
CENTROID Y	:	-.232	-.305	-.484
POA TO CENTROID in.	:	.393	.553	.674
MIN RADIUS	:	.192	.037	.165
MEAN RADIUS	:	.683	.558	.461
MAX RADIUS	:	1.450	1.290	.811
HORIZONTAL SPREAD	:	1.916	1.240	1.240
VERTICAL SPREAD	:	1.785	1.785	.732
EXTREME SPREAD	:	2.276	1.914	1.244
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	

RECEIVING AND ESTIMATING REPORT

COMMENTS

ORDER

R 94-18858

INITIAL CUSTOMER ORDER NO.
JJM DAAA09-92-C-0834

W/10X SCOPE M-24 SNIPER W/DEPLOYMENT KIT
ATTN FRED MARTIN Scope 89-0153

DATE RECEIVED 06/14/94	DATE OPENED 06/15/94	DATE CODE	SERIAL NUMBER C6594639	NEW SERIAL NUMBER	MODEL AND GRADE 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.O.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 WB AC	TARGET	PATTERN
GALLERY TESTER	DATE	DATE	DATE 11/2/95	DATE	DATE

OFFICE COPY

12-1095

RD6825 REV. 1/94

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

M2400020905

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

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

SERIAL NO. C6594639

DATE 12-7-94

TESTER BM

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.54	2.33	2.44		MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.68	2.59	2.77		
PULL #3	2.66	2.83	2.55		
PULL #4	2.57	2.51	2.77		
PULL #5	2.62	2.52	2.76		
TOTAL	13.07	12.78	13.29		
AVG.	2.61	2.55	2.65		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.05	2.99		
PULL #2	3.28	3.01		
PULL #3	3.14	2.94		
PULL #4	3.04	2.93		
PULL #5	3.04	3.07		
TOTAL	15.55	14.94		
AVG.	3.11	2.98		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.02	4.21		4.27
PULL #2	4.06	4.22		4.10
PULL #3	4.00	4.19		4.19
PULL #4	4.30	4.26		4.17
PULL #5	4.08	4.17		4.17
TOTAL	20.46	21.05		20.90
AVG.	4.09	4.21		4.18

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6594639

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 1/4	6 1/4	6			12/14	WB
	G) Safety Off Force	3 1/4	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	2.54	2.48	2.48	2.49	2.49	12/14	WB
	C) Function							
660	Pack							