

C6594671

MODEL 700™ M24

Model **S&S**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



C-6594671

SCOPE 5/N 87-1119

Repair Number: RE00000735		Serial: C6594671 Model: 700 Center Fire Caliber: 7.62 SWS M-24, 2DF18		Repairman:																			
Verify Repair				Status: New 12/15/99 11:23:19 AM																			
Address Information																							
Customer:		☒ Received From		Return To: ☐ Received From																			
Name: TRANSPORTATION OFFICER		Name: TRANSPORTATION OFFICER																					
Address 1: XVIII AIRBORNE CORPS AND FORT BRAGG		Address 1: XVIII AIRBORNE CORPS AND FORT BRAGG																					
Address 2: BUILDING J-2050 ☐ PO Box		Address 2: BUILDING J-2050 ☐ PO Box																					
City: FORT BRAGG		City: FORT BRAGG																					
State: NC Zip Code: 28310 Country: US		State: NC Zip Code: 28310 Country: US																					
EFL: ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐																							
Contact / Condition		Problems		Estimate																			
History / Status		Shipping / Billing																					
Contact Information		Received Condition		Accessories Received																			
Phone:		Poor		<table border="1"><thead><tr><th>Code</th><th>Desc.</th><th>Qty</th></tr></thead><tbody><tr><td>A010</td><td>Hard Case</td><td>1</td></tr><tr><td>A016</td><td>Scope Mounts</td><td>2</td></tr><tr><td>A017</td><td>Scope Base</td><td>1</td></tr><tr><td>A026</td><td>Scope</td><td>1</td></tr><tr><td>7890</td><td>PL 000</td><td></td></tr></tbody></table>		Code	Desc.	Qty	A010	Hard Case	1	A016	Scope Mounts	2	A017	Scope Base	1	A026	Scope	1	7890	PL 000	
Code	Desc.	Qty																					
A010	Hard Case	1																					
A016	Scope Mounts	2																					
A017	Scope Base	1																					
A026	Scope	1																					
7890	PL 000																						
Fax:		Condition Notes:																					
Email:		CSR Notes:																					
Comments:																							
Repair Search		Refresh		Close																			

BBL 96003
B011 96005



TRACKING DOCUMENT

Repair Order Number



Repair Order Numbe
RE00000735

Description/Serial
C6594671

Repairman -
Date Received 12/15/1999

Account # - R-

Model 700 Center Fire Caliber: 7.62
SWS M-24, 2OF18

Estimate Date

Current Date - 12/16/1999

Customer

TRANSPORTATION OFFICER
XVIII AIRBORNE CORPS AND FORT B
BUILDING J-2050
FORT BRAGG NC 28310 US

Return To

TRANSPORTATION OFFICER
XVIII AIRBORNE CORPS AND FORT
BUILDING J-2050
FORT BRAGG NC 28310 US

Phone (H)
Phone (W)

Fax
Email

Problems

Reported

Found

Repair

Material #

MaterialDesc

Quantity
Needed

Quantity
From

Quantity
From

Warranty
(Y/N)

Total:

Serial Number: C6594671

Model ID: 700



RE00000735

Repairman	Proof	Clean	Test	Target	Pattern
Gallery Tester	Date	Date	Date	Date	Date

Remington Test Lab, Ilion, N.Y.

Centroidal distance calculations for Rifle # C6594671
5 Apr 2000

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .137
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0526
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .146751

THE AMR FOR THIS RIFLE IS: 1.239

CENTROIDAL DISTANCES

Ø TO	1	.427855
1 TO	2	.38184
1 TO	3	.627096
1 TO	4	.696329
1 TO	5	.371559

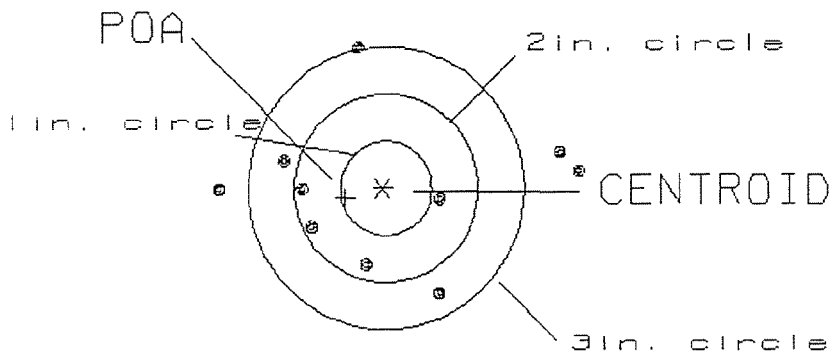
3	2	
	+	1 <----POA
4		5

PATTERN #: ☐ 1 ☐
 POA TO CENTROID: .428
 MIN RADIUS : .592
 MEAN RADIUS : 1.304
 MAX RADIUS : 2.081
 CENTROID X : .414
 CENTROID Y : .108

4 Apr 2000

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/C6594671

CENTERFIRE PATTERN # 1



OF SHOTS= 10

IN CIRCLE

HS= 3.88

0

VS= 2.60

4

GS= 3.89

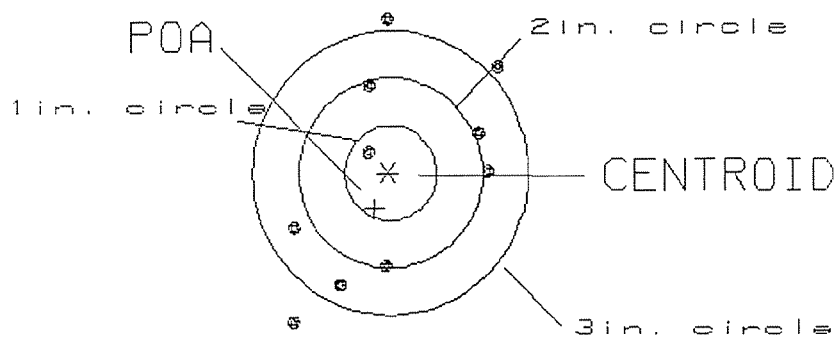
6

PATTERN #: 2
 POA TO CENTROID: .403
 MIN RADIUS : .274
 MEAN RADIUS : 1.193
 MAX RADIUS : 1.922
 CENTROID X : .143
 CENTROID Y : .377

4 Apr 2000

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/C6594671

CENTERFIRE PATTERN # 2



OF SHOTS= 10

IN CIRCLE

HS= 2.22

1

VS= 3.21

3

GS= 3.49

7

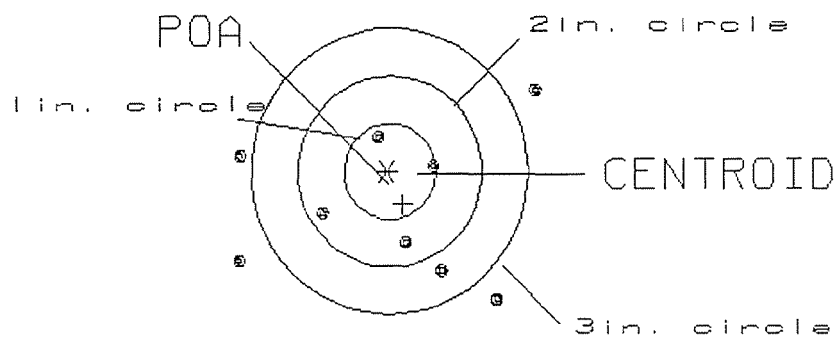
PATTERN #: 3

POA TO CENTROID: .379
 MIN RADIUS : .393
 MEAN RADIUS : 1.401
 MAX RADIUS : 3.134
 CENTROID X : -.169
 CENTROID Y : .339

4 Apr 2000

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/C6594671

CENTERFIRE PATTERN # 3



OF SHOTS= 10

IN CIRCLE

HS= 3.29

2

VS= 4.46

4

GS= 4.54

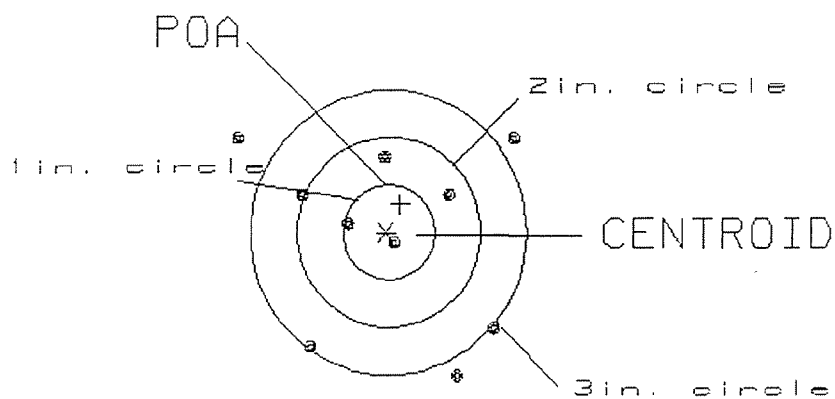
5

PATTERN #: ☐ 4 ☐
 POA TO CENTROID: .334
 MIN RADIUS : .090
 MEAN RADIUS : 1.136
 MAX RADIUS : 1.898
 CENTROID X : -.151
 CENTROID Y : -.299

4 Apr 2000

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/C6594671

CENTERFIRE PATTERN # 4



OF SHOTS= 10

IN CIRCLE

HS= 2.95

2

VS= 2.44

4

GS= 3.42

7

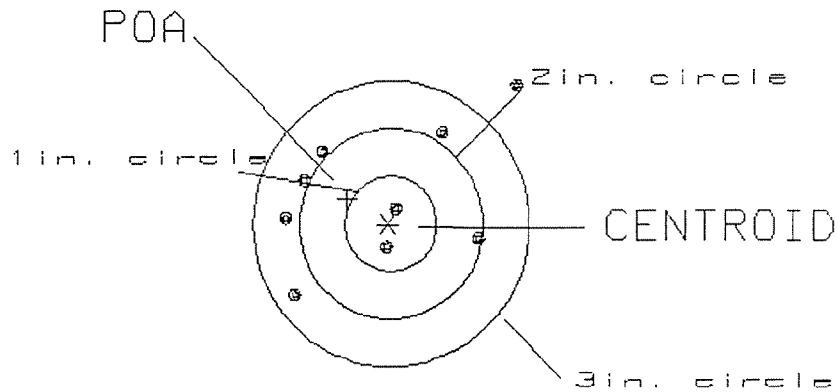
PATTERN #: ☐ 5 ☐

POA TO CENTROID: .518
 MIN RADIUS : .148
 MEAN RADIUS : 1.160
 MAX RADIUS : 2.755
 CENTROID X : .448
 CENTROID Y : -.262

4 Apr 2000

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/C6594671

CENTERFIRE PATTERN # 5



OF SHOTS= 10

IN CIRCLE

HS= 2.49
 VS= 4.01
 GS= 4.03

2
 3
 5

21 DAY TURN - AROUND

M-24

CONTRACT # DAAA09-92-C-0834

R&E NO.

SERIAL NO.

C6594671

LOG IN DATE: / /		DATE	INIT.
INSPECT & VERIFY:			
OP. #	OP. NAME		
550	DIS-ASSEMBLE GUN	<i>12-24-00</i>	<i>RW</i>
560 A	RE-BARREL AT CUSTOM SHOP		
B	DRILL & TAP		
C	POLISH		
575	ASSEMBLE		
600	PROOF	<i>1-12-00</i>	<i>RW</i>
605	CHECK HEADSPACE	<i>1-12-00</i>	<i>RW</i>
610	DIS-ASSEMBLE		
612	MAGNAFLUX		
615	ROLLMARK CALIBER		
618	ROTO-BLAST		
620	APPLY COATINGS		
625 A	FINAL ASSEMBLY		
B	TRIGGER PULL TEST		
C	SAFETY ON FORCE		
D	SAFETY OFF FORCE		
E	FIRING PIN INDENT		
640	TARGET	<i>4-3-00</i>	<i>RW</i>
655	FINAL INSPECT	<i>4-10-00</i>	<i>RW</i>
660	PACK		
QAR INSPECTION		SHIP DATE	

FINAL Inspection

Sr: C6594671

DATE REC'D: 12-12-99

DATE RET'D:

AUDITOR: RW

Item:

BARREL ASSY.

☒ BARREL

☒ RECEIVER

☒ FRONT SIGHT BLOCK

☒ REAR SIGHT BLOCK

☒ SCREWS

☒ FINISH

SCOPE ASSY.

☒ SCOPE

☒ SCOPE RINGS

☒ MOUNTING SCREWS

☒ MOUNTING BASE

☒ SCREWS

☒ FINISH

☒ LOOSENESS

☒ CLARITY

MISC.

DD-250

BAR CODE

PACKAGING

Item:

STOCK ASSY.

☒ STOCK

☒ SLING SWIVEL STUDS

☒ ADJUSTABLE BUTT PLATE

☒ LOCK NUTS

☒ BARREL CLEARANCE

☒ COLOR/FINISH

SYSTEMS CASE

☒ SCOPE CASE

IRON SIGHTS

DEPLOYMENT KIT

TRIGGER

☒ SAFETY OPERATION

☒ SET

Comments:

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. C6594671

ORDER NO. 5716

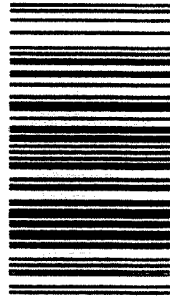
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.

20



5716 C6594671

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6594671

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 16 91		RW
610	Dis-assemble Gun	1 16 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		FB
618	Polish Barrel	1 24 91		WB
620	Apply Coatings (Barrel Action)		2-15-91	TH
	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		2-22-91	STL

Op. #	Op. NAME	READINGS						
625 cont.	F) Safety On Force	6	5 $\frac{1}{4}$	5	2-22-91	DH		
	G) Safety Off Force	3	3	3	2-22-91	DH		
	H) Trigger Pull Test & Retainability				2-21-91	HL		
	I) Firing Pin Indent	.0215	.0205	.0205	2-22-91	DH		
	J) Assemble Stock				3/4/91	RW		
	K) Assemble Swivel Studs				3/2/91	WB		
	L) Attach Front and Rear Sight Assemblies				3/1/91	RW		
	M) Iron Sight Alignment				3/1/91	RW		
	N) Detach Front & Rear Sights & place in numbered container				3/1/91	RW		
	O) Attach Scope to Rifle				3/1/91	RW		
	P) Detach & Attach Scope 20 Times				3/1/91	RW		
640	Gallery Target & Test				3-1-91	NF		
	A) Time				"	NF		
	B) Malfunctions				"	NF		
	C) Pierced Primers				"	NF		
	D) Optical Clarity of Scope				"	NF		
645	Inspect for Live Ammo				3-1-91	NF		
655	Final Inspection				3/2/91	WB		
	A) Headspace							
	B) Trigger Pull	2.20	2.25	2.24	2.28	2.35	3/2/91	OP
	C) Function						3/2/91	WB
660	Pack						3-11-91	NF

SWS TRIGGER PULL TEST

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

SERIAL NO. CC594671
DATE 2-21-91
TESTER DH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.51	2.53	2.33	2.20	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.47	2.47	2.53	2.25	
PULL #3	2.39	2.39	2.43	2.24	
PULL #4	2.48	2.39	2.41	2.28	
PULL #5	2.47	2.35	2.45	2.35	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.39	3.36		
PULL #2	3.32	3.22		
PULL #3	3.38	3.22		
PULL #4	3.39	3.38		
PULL #5	3.34	3.22		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.20	4.15		4.18
PULL #2	4.25	4.42		4.00
PULL #3	4.19	4.39		4.03
PULL #4	4.28	4.34		4.09
PULL #5	4.28	4.01		3.96
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6594671
1 Mar 1991

CENTROIDAL DISTANCES

0 TO	1	.178084
1 TO	2	.334073
1 TO	3	.351648
1 TO	4	.256644
1 TO	5	.13813

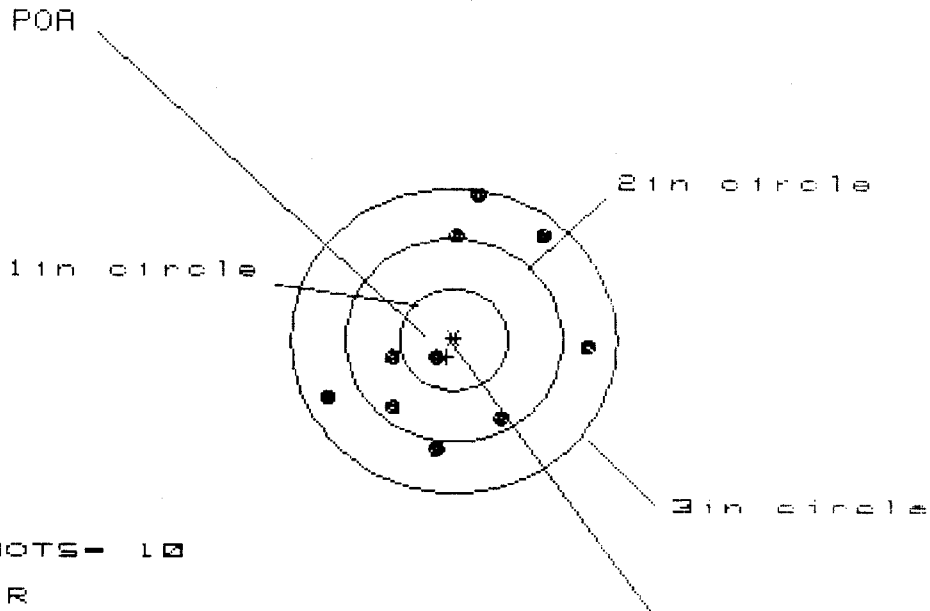
34 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0948
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1398
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .168911
THE AMR FOR THIS RIFLE IS: .8806

1 Mar 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6594671

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 10

HS= 2.422

VS= 2.580

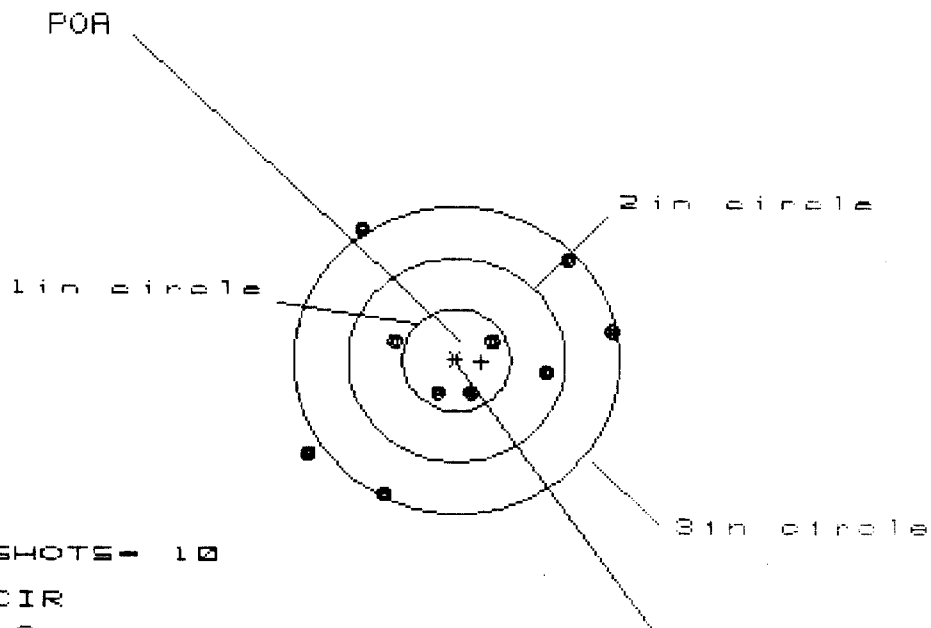
GS= 2.611

PATTERN #	1	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.212	1.235	1.086
MINIMUM X	-1.210	-1.187	-0.697
MAXIMUM Y	1.468	1.205	1.152
MINIMUM Y	-1.112	-0.949	-1.002
CENTROID X	.067	.044	.193
CENTROID Y	.165	.002	.055
POA TO CENTROID in.	.178	.044	.200
MIN RADIUS	.226	.161	.308
MEAN RADIUS	1.002	.916	.895
MAX RADIUS	1.482	1.450	1.327
HORIZONTAL SPREAD	2.422	2.422	1.783
VERTICAL SPREAD	2.580	2.154	2.154
EXTREME SPREAD	2.611	2.577	2.367
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	10		

1 Mar 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6594671

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 5

3 in = 7

HS= 2.818

VS= 2.654

GS= 3.104

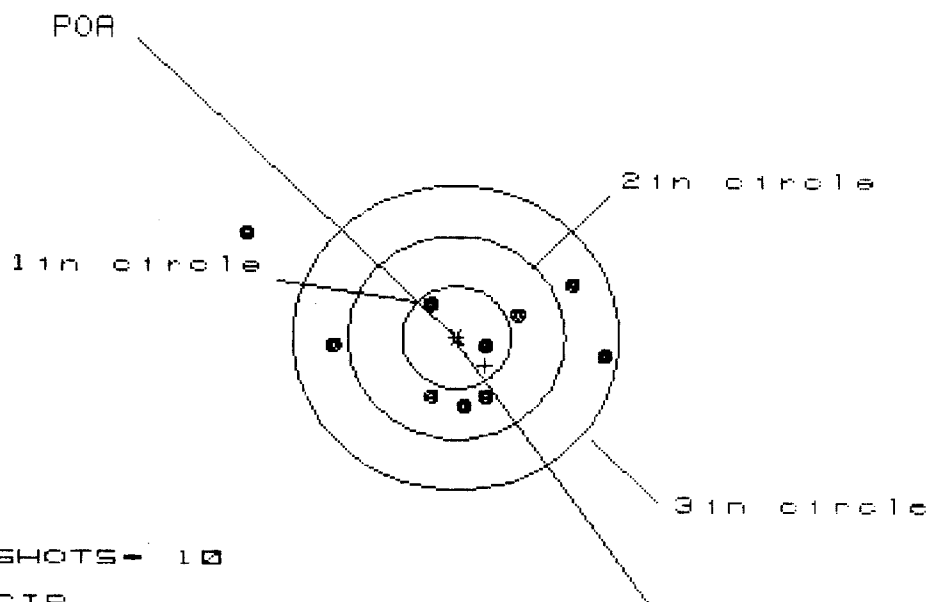
CENTROID *

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.415	1.259	1.134
MINIMUM X	:	-1.403	-.996	-.954
MAXIMUM Y	:	1.313	1.211	1.047
MINIMUM Y	:	-1.341	-1.443	-1.292
CENTROID X	:	-.231	-.075	.050
CENTROID Y	:	.014	.116	-.035
POA TO CENTROID in.	:	.231	.138	.061
MIN RADIUS	:	.303	.144	.188
MEAN RADIUS	:	1.001	.914	.812
MAX RADIUS	:	1.677	1.665	1.606
HORIZONTAL SPREAD	:	2.818	2.255	2.088
VERTICAL SPREAD	:	2.654	2.654	2.339
EXTREME SPREAD	:	3.104	2.899	2.899
NUMBER IN ONE INCH CIRCLE	=	3		
NUMBER IN TWO INCH CIRCLE	=	5		
NUMBER IN THREE INCH CIRCLE	=	7		

1 Mar 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6594671

CENTERFIRE PATTERNS # 3



OF SHOTS - 10

IN CIR

1 in = 2

2 in = 6

3 in = 9

HS = 3.245

VS = 1.646

GS = 3.445

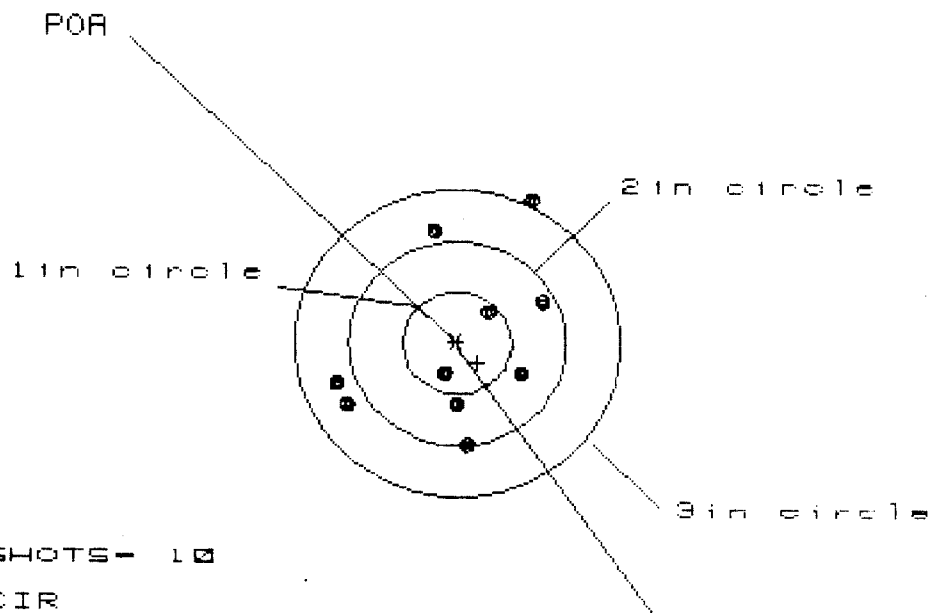
CENTROID *

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.361	1.152	1.015
MINIMUM X	:	-1.884	-1.385	-1.241
MAXIMUM Y	:	1.013	.593	.589
MINIMUM Y	:	-.633	-.521	-.525
CENTROID X	:	-.267	-.058	-.202
CENTROID Y	:	.275	.163	.167
POA TO CENTROID in.	:	.384	.173	.262
MIN RADIUS	:	.251	.065	.186
MEAN RADIUS	:	.899	.711	.661
MAX RADIUS	:	2.139	1.385	1.241
HORIZONTAL SPREAD	:	3.245	2.537	2.256
VERTICAL SPREAD	:	1.646	1.114	1.114
EXTREME SPREAD	:	3.445	2.537	2.332
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	6		
NUMBER IN THREE INCH CIRCLE	=	9		

1 Mar 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6594671

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 2

2in = 6

3in = 9

HS= 1.822

VS= 2.387

GS= 2.621

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.758	.834	.717
MINIMUM X	-1.064	-.988	-1.105
MAXIMUM Y	1.392	1.265	1.209
MINIMUM Y	-.995	-.840	-.896
CENTROID X	-.188	-.264	-.147
CENTROID Y	.194	.039	.095
POA TO CENTROID in.	.270	.267	.175
MIN RADIUS	.309	.141	.237
MEAN RADIUS	.884	.783	.744
MAX RADIUS	1.553	1.274	1.239
HORIZONTAL SPREAD	1.822	1.822	1.822
VERTICAL SPREAD	2.387	2.105	2.105
EXTREME SPREAD	2.621	2.130	2.130
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	9		

1 Mar 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6594671

CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 6

2in = 9

3in = 9

HS= 2.529

VS= .837

GS= 2.543

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.773	.799	.729
MINIMUM X	-.756	-.559	-.469
MAXIMUM Y	.436	.421	.369
MINIMUM Y	-.401	-.416	-.452
CENTROID X	.145	-.052	.018
CENTROID Y	.051	.066	.118
POA TO CENTROID in.	.154	.084	.119
MIN RADIUS	.281	.112	.198
MEAN RADIUS	.617	.425	.401
MAX RADIUS	1.778	.807	.748
HORIZONTAL SPREAD	2.529	1.358	1.198
VERTICAL SPREAD	.837	.837	.821
EXTREME SPREAD	2.543	1.391	1.269
NUMBER IN ONE INCH CIRCLE =		6	
NUMBER IN TWO INCH CIRCLE =		9	
NUMBER IN THREE INCH CIRCLE =		9	

RECEIVING AND ESTIMATING REPORT

COMMENTS

ORDER

R 94-18777

INITIAL JJM	CUSTOMER ORDER NO. DAAA09-92-C-0834		W/10X SCOPE M-24 SNIPER W/DEPLOYMENT KIT ATTN FRED MARTIN SCOPE 90-0120		
DATE RECEIVED 06/14/94	DATE OPENED 06/15/94	DATE CODE	SERIAL NUMBER C6594671	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-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	
<u>\$223.31</u>	
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

M2400021574

SWS TRIGGER PULL TEST

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

SERIAL NO. C6594671

DATE 11-11-95

TESTER DA

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#	COMMENTS
PULL #1	2.72	2.88	2.63	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.69	2.87	2.71	
PULL #3	2.65	2.85	2.69	
PULL #4	2.66	2.81	2.72	
PULL #5	2.72	2.82	2.57	
TOTAL	13.44	14.23	13.32	
AVG.	2.68	2.84	2.66	

	3.00# INITIAL	3.00# AFTER 20 CYCLES	COMMENTS
PULL #1	3.11	3.00	
PULL #2	3.12	3.00	
PULL #3	3.08	2.91	
PULL #4	3.02	2.90	
PULL #5	3.00	2.87	
TOTAL	15.33	14.68	
AVG.	3.06	2.93	

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.25	4.08	4.08	4.11
PULL #2	4.11	4.28		4.11
PULL #3	4.27	4.28		4.07
PULL #4	4.30	4.31		4.06
PULL #5	4.23	4.28		4.09
TOTAL	21.16	21.23		20.44
AVG.	4.23	4.24		4.08

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C-6594671

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	4.0	4.0	4.5			12-13-95	DA
	G) Safety Off Force	3.2	3.0	3.0			12-13-95	DA
	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	2.74	2.74	2.67	2.70	2.68	12-13-95	DA
	C) Function							
660	Pack							