

C6587538

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

Remington

Small Services Repair & Estimate System

File Add Repair Estimate Repair Expedite Repair Inquiry Repair Tools CSR Tools Reports Table Maintenance System Maintenance Help

Go Repair Inquiry

Repair Number: **RE00089047** Serial: C6587538 Model M24 SWS Center Fire Caliber: 7.62 NATO Repairman: Status: Closed 12/6/2004 7:57:03 AM

Verify Repair

Address Information

Customer: (C) Received From: Return To: (C) 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

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	Frt and Rear Sgt Base	3

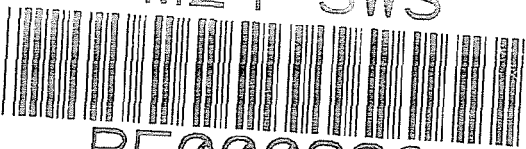
Repair Search **Refresh** **Close**

negate 12/6/2004 9:55 AM CAPS NUM INS SFL

start 2 2 2 2 2 2 2 2

Serial Number: **C6587538**

Model: **M24 SWS**



RE00089047

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6587538.___0
FILE DATE AND TIME: 01/12/2005 11:09

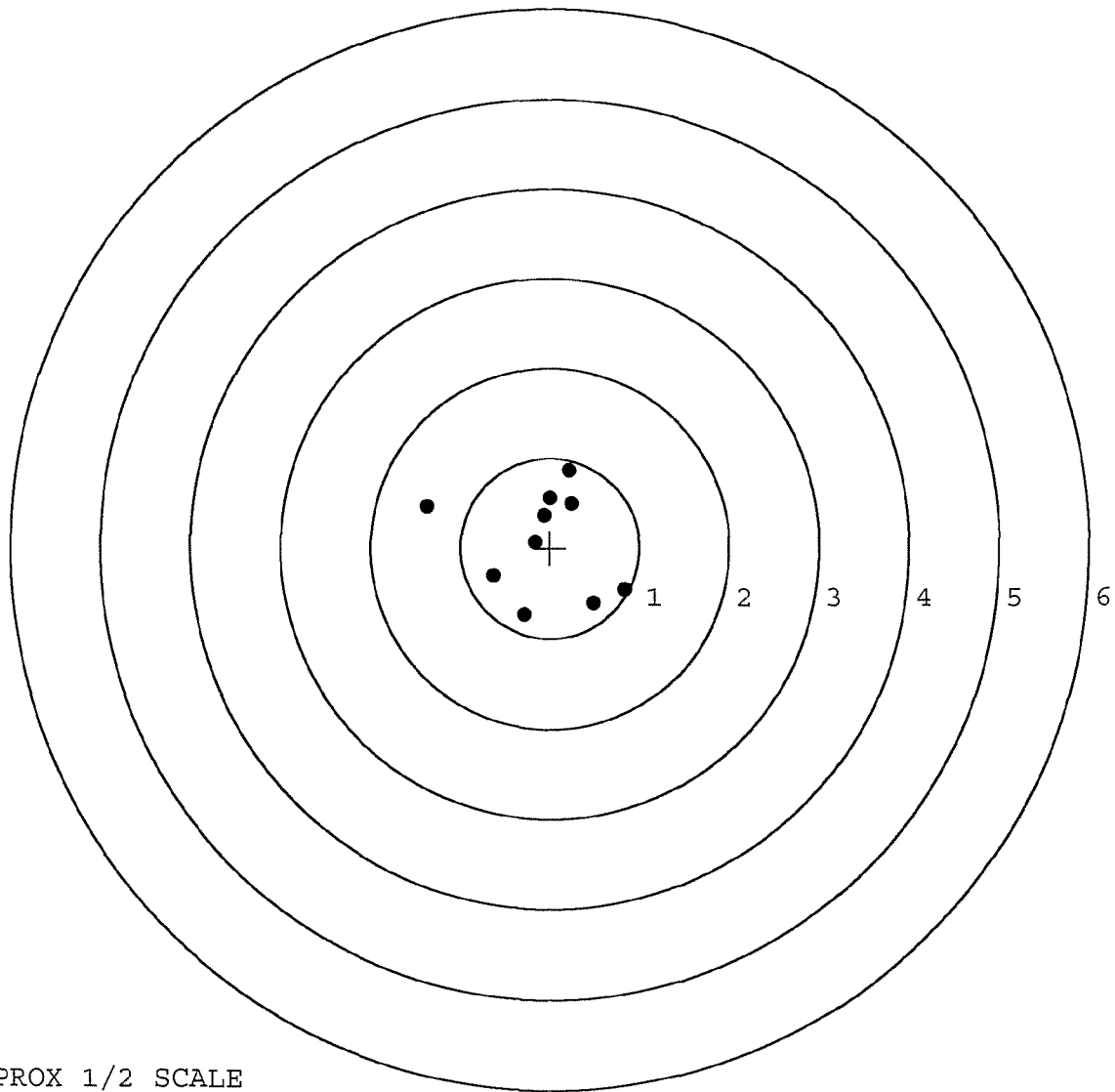
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.082
The Average Y Centroid of the Five Target Set:	0.016
The Average Point of Impact of the Five Target Set:	0.084
The Average Mean Radius of the Five Target Set:	0.630
The Distance from POA to Centroid Target #1:	0.099
The Distance from Centroid Target #2 to Centroid Target #1:	0.063
The Distance from Centroid Target #3 to Centroid Target #1:	0.120
The Distance from Centroid Target #4 to Centroid Target #1:	0.009
The Distance from Centroid Target #5 to Centroid Target #1:	0.132

SERIAL NUMBER: C6587538. __0
TARGET NUMBER: 1
FILE DATE: 01/12/2005
FILE TIME: 11:09

X CENTROID: -0.073
Y CENTROID: 0.067
POA TO CENTROID: 0.099
HORZ SPREAD: 2.204
VERT SPREAD: 1.606
GROUP SPREAD: 2.393
MIN RADIUS: 0.089
MAX RADIUS: 1.354
MEAN RADIUS: 0.708
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.837	-0.469
2:	0.492	-0.619
3:	-0.290	-0.740
4:	-0.633	-0.315
5:	-1.367	0.464
6:	-0.161	0.063
7:	0.245	0.498
8:	0.220	0.866
9:	0.003	0.560
10:	-0.072	0.365



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6587538.___0

TARGET NUMBER: 2

FILE DATE: 01/12/2005

FILE TIME: 11:09

POINT#	X	Y
1:	1.005	-0.243
2:	0.447	-0.384
3:	0.099	-0.741
4:	-0.259	-0.795
5:	-0.209	0.815
6:	-0.230	0.719
7:	0.028	0.238
8:	-0.183	0.406
9:	-0.550	0.125
10:	-1.462	0.308

X CENTROID: -0.131

Y CENTROID: 0.045

POA TO CENTROID: 0.139

HORZ SPREAD: 2.467

VERT SPREAD: 1.610

GROUP SPREAD: 2.528

MIN RADIUS: 0.250

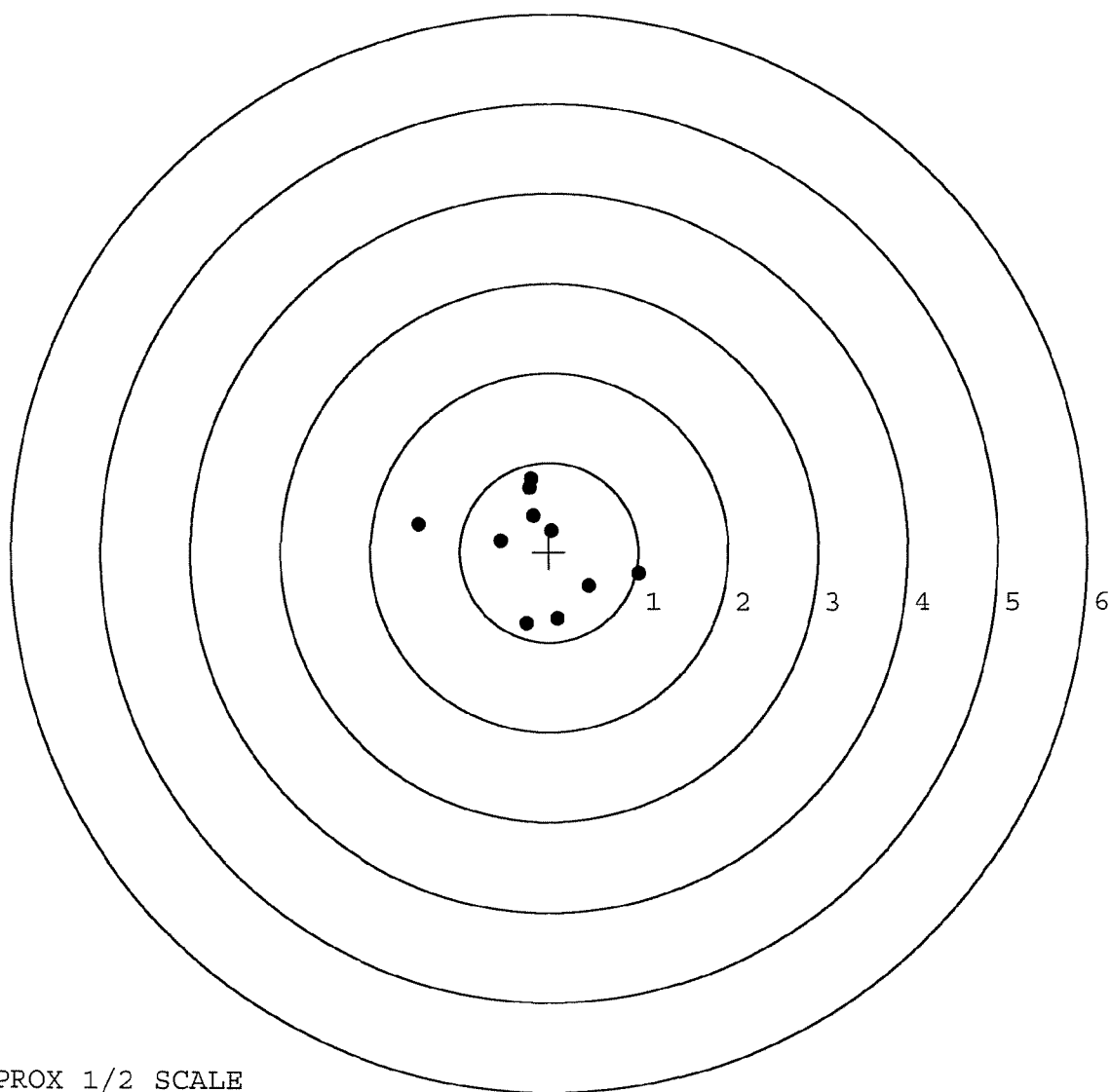
MAX RADIUS: 1.356

MEAN RADIUS: 0.741

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10

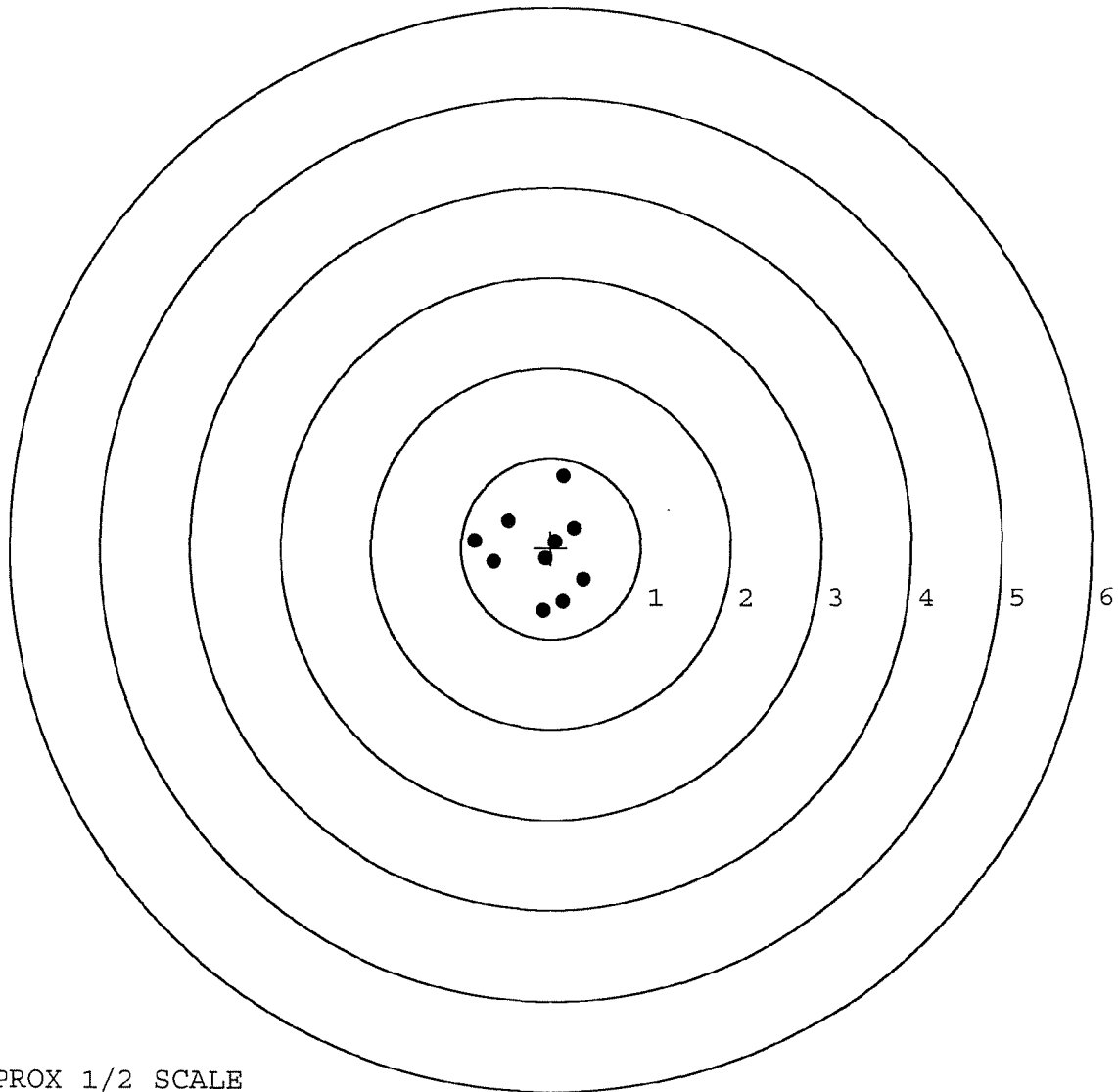


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6587538.___0
TARGET NUMBER: 3
FILE DATE: 01/12/2005
FILE TIME: 11:09

X CENTROID: -0.117
Y CENTROID: -0.045
POA TO CENTROID: 0.125
HORZ SPREAD: 1.210
VERT SPREAD: 1.497
GROUP SPREAD: 1.515
MIN RADIUS: 0.089
MAX RADIUS: 0.887
MEAN RADIUS: 0.523
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 10
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.360	-0.348
2:	0.136	-0.598
3:	-0.088	-0.694
4:	0.259	0.218
5:	0.048	0.072
6:	-0.066	-0.118
7:	-0.634	-0.154
8:	-0.480	0.296
9:	-0.850	0.077
10:	0.145	0.803



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6587538. 0

TARGET NUMBER: 4

FILE DATE: 01/12/2005

FILE TIME: 11:09

POINT#	X	Y
1:	0.791	0.590
2:	0.364	0.240
3:	-0.024	0.681
4:	-0.009	0.366
5:	-0.082	0.214
6:	0.001	-0.484
7:	-0.406	-0.415
8:	-0.518	-0.895
9:	-1.039	-0.268
10:	0.280	0.665

X CENTROID: -0.064

Y CENTROID: 0.069

POA TO CENTROID: 0.095

HORZ SPREAD: 1.830

VERT SPREAD: 1.576

GROUP SPREAD: 1.980

MIN RADIUS: 0.146

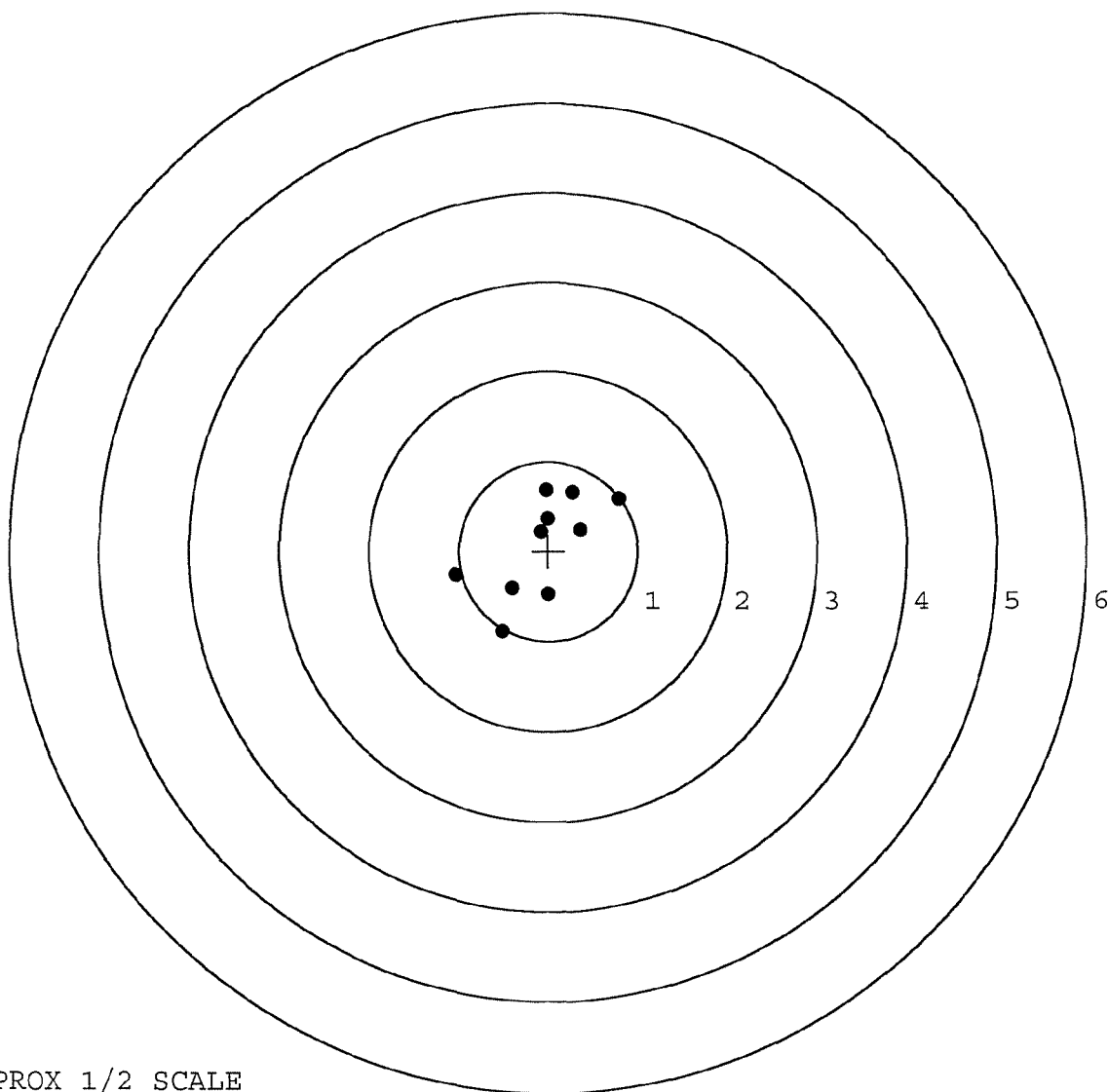
MAX RADIUS: 1.066

MEAN RADIUS: 0.646

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6587538. 0

TARGET NUMBER: 5

FILE DATE: 01/12/2005

FILE TIME: 11:09

POINT#	X	Y
1:	0.932	0.787
2:	0.038	0.506
3:	0.199	-1.057
4:	-0.473	-0.401
5:	-0.558	-0.197
6:	-0.673	0.051
7:	0.168	-0.216
8:	0.195	0.074
9:	-0.111	-0.027
10:	0.029	-0.077

X CENTROID: -0.025

Y CENTROID: -0.056

POA TO CENTROID: 0.061

HORZ SPREAD: 1.605

VERT SPREAD: 1.844

GROUP SPREAD: 1.984

MIN RADIUS: 0.058

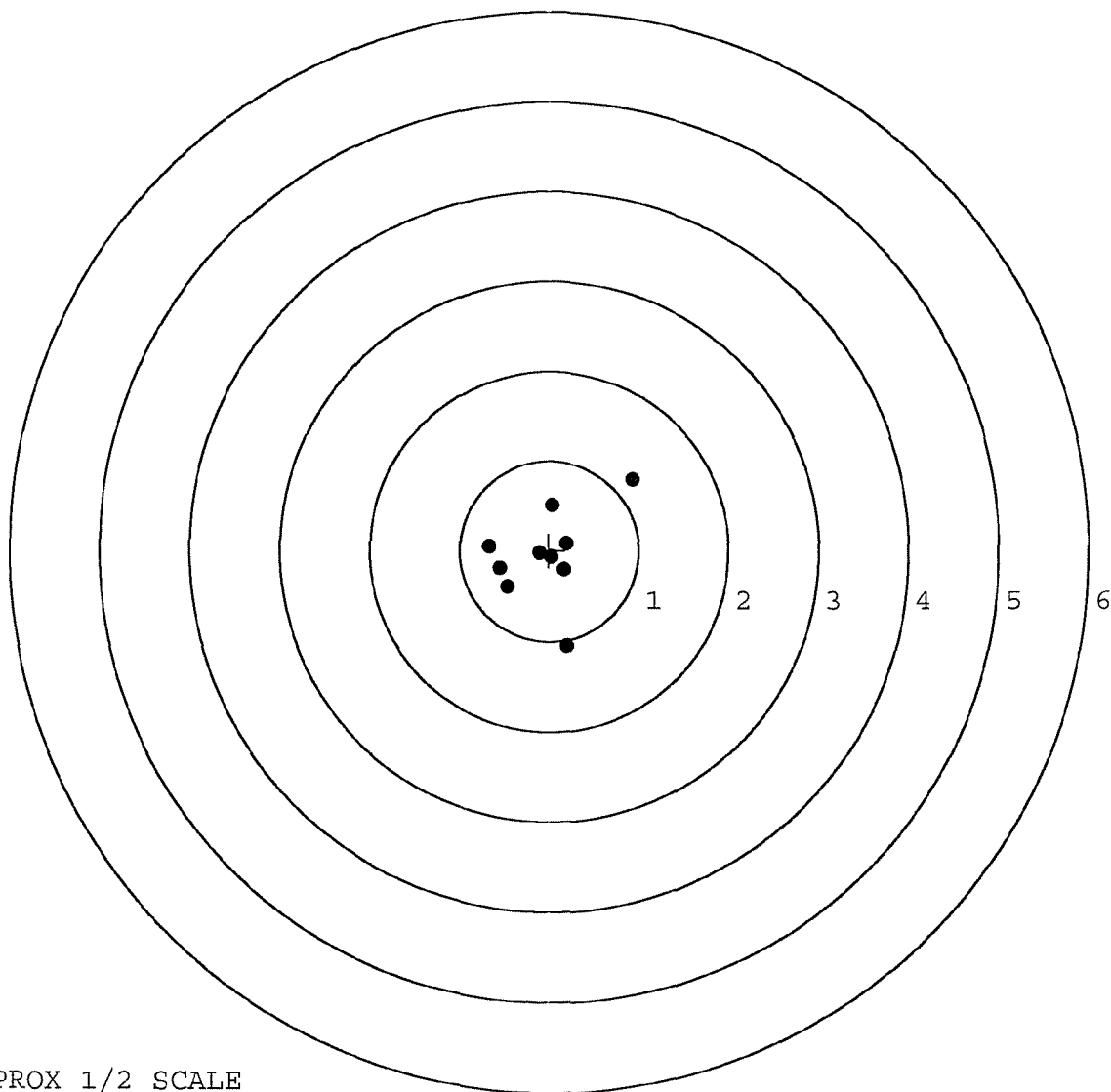
MAX RADIUS: 1.275

MEAN RADIUS: 0.530

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

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

R & E NUMBER	89047		
SERIAL NUMBER	06587538		
LOG-IN DATE	12-6-04		
INSPECT AND VERIFY:			
OPERATION #	OPERATION NAME	DATE	INITIAL
550	DIS-ASSEMBLE GUN	12-8-04	RTL
560 A	RE-BARREL	12-15-04	RTL
B	DRILL AND TAP	12-27-04	TRW
575	ASSEMBLE	12-16-04	RTL
600	PROOF	12-16-04	RTL
605	CHECK HEADSPACE	12-16-04	RTL
610	DIS-ASSEMBLE GUN	12-27-04	RTL
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	1-10-05	RTL
B	TRIGGER PULL TEST	N/A	
C	SAFETY "ON" FORCE		
D	SAFETY "OFF" FORCE		
E	FIRING PIN INDENT		
640	TARGET	1-12-05	TRW
655	FINAL INSPECT	1-13-05	STE
660	PACK	3-1-05	GA
		SHIP DATE	
QAR INSPECTION DATE			

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

Remington[®]

MODEL 700TM H24

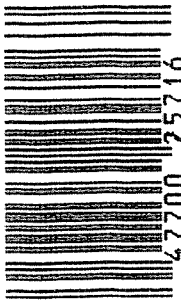
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.

UPPONT
REG. U.S. PAT. & T.M. OFF.

SERIAL NO.
C6587538

ORDER NO.
5716

UPC



0 47700 25716 7



5716 C6587538

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6587538

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	1023	90	RW
600	Proof	1023	90	RW
607	Check Headspace	1023	90	RW
610	Dis-assemble Gun	1023	90	RW
612	Magnaflux Barrel Action		10/24/90	KR
	Magnaflux Bolt		11	KR
615	Rollmark Caliber		11	LS
617	Drill and Tap Sight Holes		10/25/90	FB
618	Polish Barrel RB		10/26/90	WB
620	Apply Coatings (Barrel Action)		11-7-90	TH
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		11/12/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		11/12/90	RW
	C) Inspect Ejector Hole for Chamfer		11/12/90	RW
	D) Oil Firing Pin Ass'y		11/12/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		11/19/90	WB

op. #	OP. NAME	READINGS			DATE	INIT
625 cont.	F) Safety On Force	4 1/4	4 1/4	4 1/4	11/21/90	WB
	G) Safety Off Force	7 1/4	7 1/4	7 1/4	11/21/90	WB
	H) Trigger Pull Test & Retainability				11/19/90	WB
	I) Firing Pin Indent	.023	.023	.023	11/21/90	WB
	J) Assemble Stock				11/27/90	RW
	K) Assemble Swivel Studs				11-28-90	JSB
	L) Attach Front and Rear Sight Assemblies				11/27/90	RW
	M) Iron Sight Alignment				11/27/90	RW
	N) Detach Front & Rear Sights & place in numbered container				11/27/90	RW
	O) Attach Scope to Rifle				11/27/90	RW
	P) Detach & Attach Scope 20 Times				11/27/90	RW
640	Gallery Target & Test				11/27/90	NF
	A) Time				"	NF
	B) Malfunctions				"	NF
	C) Pierced Primers				"	NF
	D) Optical Clarity of Scope				"	NF
645	Inspect for Live Ammo				11/27/90	NF
655	Final Inspection					
	A) Headspace				11-28-90	JSB
	B) Trigger Pull	285	259	291	11-28-90	JSB
	C) Function				11-28-90	JSB
660	Pack				12-17-90	DH

SWS TRIGGER PULL TEST

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

SERIAL NO. C6587538
DATE 11/19/90
TESTER WB

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.51	2.50	2.40	2.85	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.50	2.43	2.43	2.59	
PULL #3	2.46	2.36	2.44	2.91	
PULL #4	2.51	2.41	2.46	2.86	
PULL #5	2.52	2.36	2.40	2.63	
TOTAL	12.50	12.06	12.13		
AVG.	2.50	2.41	2.43		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.12	3.13		
PULL #2	3.29	3.25		
PULL #3	3.20	3.30		
PULL #4	3.17	3.28		
PULL #5	3.27	3.30		
TOTAL	16.05	16.26		
AVG.	3.21	3.25		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.30	4.40		4.17
PULL #2	4.34	4.28		4.13
PULL #3	4.31	4.23		4.28
PULL #4	4.31	4.15		4.15
PULL #5	4.33	4.11		4.12
TOTAL	21.59	21.17		20.85
AVG.	4.32	4.23		4.17

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6587538
28 Nov 1990

CENTROIDAL DISTANCES

0 TO	1	.165024
1 TO	2	.152315
1 TO	3	.295296
1 TO	4	.511001
1 TO	5	.264433

$\frac{34}{4}$ <----POA

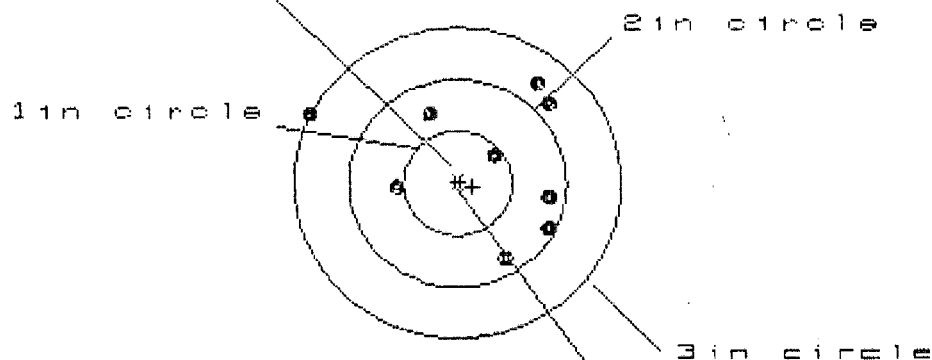
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1724
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1176
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .20869
THE AMR FOR THIS RIFLE IS: .905

28 Nov 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6587538

CENTERFIRE PATTERNS # 1

FOR



OF SHOTS - 10

IN CIR

1in = 1

2in = 5

3in = 8

HS = 2.583

VS = 3.063

GS = 3.893

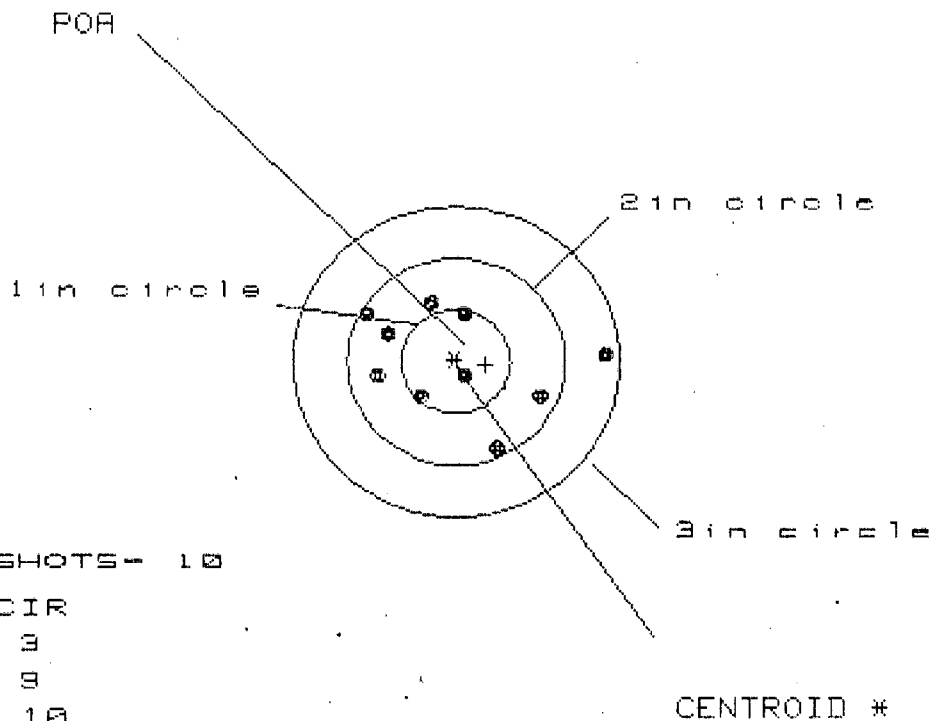
CENTROID #

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.871	.680	.485
MINIMUM X	:	-1.712	-1.566	-.978
MAXIMUM Y	:	.955	.720	.781
MINIMUM Y	:	-2.108	-.971	-.910
CENTROID X	:	-.137	.054	.249
CENTROID Y	:	.029	.264	.203
FOR TO CENTROID in.	:	.140	.269	.322
MIN RADIUS	:	.429	.152	.100
MEAN RADIUS	:	1.092	.841	.706
MAX RADIUS	:	2.716	1.638	1.007
HORIZONTAL SPREAD	:	2.583	2.246	1.463
VERTICAL SPREAD	:	3.063	1.691	1.691
EXTREME SPREAD	:	3.893	2.502	1.715
NUMBER IN ONE INCH CIRCLE =			1	
NUMBER IN TWO INCH CIRCLE =			6	
NUMBER IN THREE INCH CIRCLE =			8	

28 Nov 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C6587538

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 8

3 in = 10

HS= 2.157

VS= 1.363

GS= 2.200

PATTERN #	2		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.373	.943	.864
MINIMUM X	-.784	-.631	-.603
MAXIMUM Y	.560	.563	.620
MINIMUM Y	-.803	-.800	-.743
CENTROID X	-.277	-.429	-.350
CENTROID Y	.032	.029	-.028
POA TO CENTROID in.	.278	.430	.351
MIN RADIUS	.210	.321	.224
MEAN RADIUS	.714	.619	.598
MAX RADIUS	1.374	1.001	.908
HORIZONTAL SPREAD	2.157	1.574	1.467
VERTICAL SPREAD	1.363	1.363	1.363
EXTREME SPREAD	2.200	1.763	1.566
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		9	
NUMBER IN THREE INCH CIRCLE =		10	

28 Nov 1998

FILE:/PATTERNING/CENTERFIRE_PATT/06587538

CENTERFIRE PATTERNS # 3

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS= 10

IN CIR

1in = 6

2in = 9

3in = 10

HS= 1.480

VS= 1.724

GS= 2.118

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.845	.869	.554
MINIMUM X	:	-.615	-.521	-.412
MAXIMUM Y	:	1.063	.521	.562
MINIMUM Y	:	-.661	-.543	-.502
CENTROID X	:	-.013	-.107	-.216
CENTROID Y	:	-.176	-.294	-.335
POA TO CENTROID in.	:	.176	.313	.399
MIN RADIUS	:	.060	.117	.197
MEAN RADIUS	:	.554	.449	.383
MAX RADIUS	:	1.358	.931	.574
HORIZONTAL SPREAD	:	1.460	1.390	.966
VERTICAL SPREAD	:	1.724	1.064	1.064
EXTREME SPREAD	:	2.118	1.519	1.070
NUMBER IN ONE INCH CIRCLE	=		6	
NUMBER IN TWO INCH CIRCLE	=		9	
NUMBER IN THREE INCH CIRCLE	=		10	

28 Nov 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6587538

CENTERFIRE PATTERNS

4

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS- 10

IN CIR

1 in = 2

2 in = 5

3 in = 8

HS= 3.400

VS= 3.684

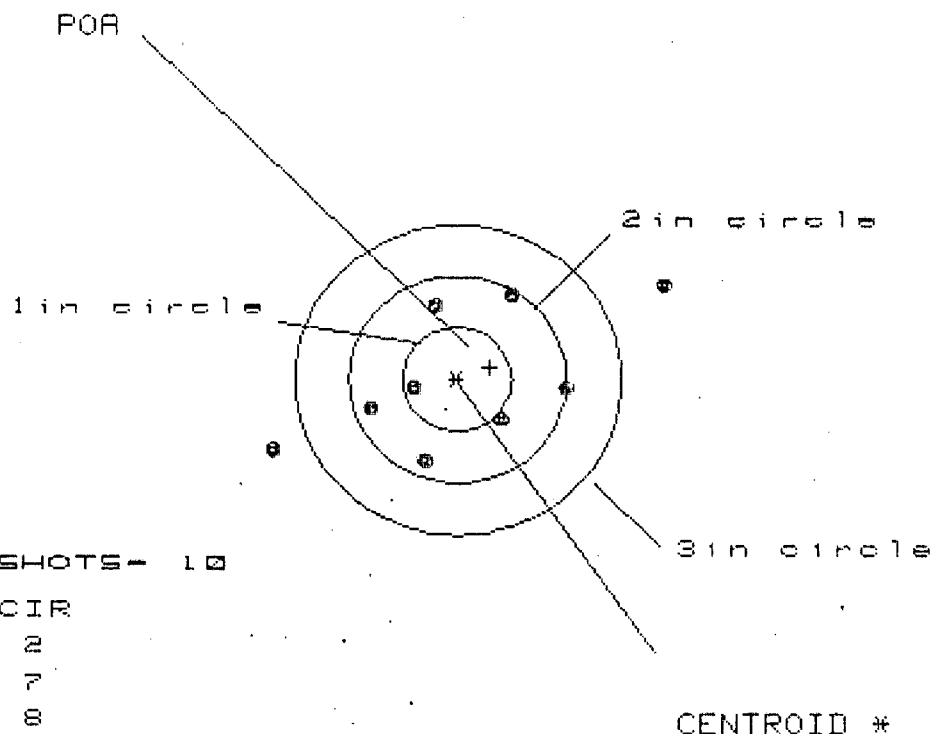
GS= 4.874

PATTERN #	4		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.391	1.168	1.288
MINIMUM X	-2.009	-.961	-.841
MAXIMUM Y	1.723	1.505	.828
MINIMUM Y	-1.961	-1.074	-.885
CENTROID X	-.136	.087	-.033
CENTROID Y	-.419	-.201	-.390
POA TO CENTROID in.	.441	.220	.391
MIN RADIUS	.363	.337	.389
MEAN RADIUS	1.199	1.020	.895
MAX RADIUS	2.807	1.785	1.386
HORIZONTAL SPREAD	3.400	2.129	2.129
VERTICAL SPREAD	3.684	2.579	1.713
EXTREME SPREAD	4.874	3.215	2.598
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		8	

28 Nov 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6587538

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 2

2in = 7

3in = 8

HS= 3.585

VS= 1.714

GS= 3.934

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.888	1.223	1.037
MINIMUM X	-1.698	-1.488	-.757
MAXIMUM Y	.917	.907	.832
MINIMUM Y	-.797	-.695	-.770
CENTROID X	-.299	-.509	-.323
CENTROID Y	-.117	-.219	-.144
POA TO CENTROID in.	.322	.554	.354
MIN RADIUS	.407	.198	.380
MEAN RADIUS	.966	.792	.710
MAX RADIUS	2.099	1.604	1.042
HORIZONTAL SPREAD	3.585	2.711	1.794
VERTICAL SPREAD	1.714	1.602	1.602
EXTREME SPREAD	3.934	2.772	1.801
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	8		

RECEIVING AND ESTIMATING REPORT

COMMENTS

ORDER

R 94-18776

INITIAL CUSTOMER ORDER NO.

JJM

DAAA09-92-C-0834

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

SCOPE 90-0661

DATE RECEIVED

DATE OPENED

DATE CODE

SERIAL NUMBER

NEW SERIAL NUMBER

MODEL AND GRADE

06/14/94

06/15/94

C6587538

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

BOLT ASSY.

B3

BARREL ASSY.

B4

REC. ASSY.

B5

WOOD

C1

D3

METAL

C2

D3

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

M2400022343

SWS TRIGGER PULL TEST

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

SERIAL NO. C6587538

DATE 11-11-95

TESTER DA

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#	COMMENTS
PULL #1	2.60	2.77	2.62	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.72	2.73	2.74	
PULL #3	2.69	2.76	2.73	
PULL #4	2.66	2.75	2.74	
PULL #5	2.71	2.77	2.71	
TOTAL	13.38	13.72	13.56	
AVG.	2.67	2.74	2.71	

	3.00# INITIAL	3.00# AFTER 20 CYCLES	COMMENTS
PULL #1	3.22	3.14	
PULL #2	3.17	3.15	
PULL #3	3.20	3.16	
PULL #4	3.21	3.00	
PULL #5	3.20	3.20	
TOTAL	16.00	15.65	
AVG.	3.20	3.13	

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.14	4.16		4.13
PULL #2	4.13	4.09		4.21
PULL #3	4.16	4.09		4.17
PULL #4	4.17	4.20		4.16
PULL #5	4.27	4.20		4.19
TOTAL	20.89	20.74		20.86
AVG.	4.17	4.14		4.17

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CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C-6587538

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	4.5	4.0	4.0			12-13-95	DA
	G) Safety Off Force	3.0	3.5	3.5			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	2.57	2.61	2.54	2.55	2.54	12-13-95	DA
	C) Function							
660	Pack							