

C6587738

MODEL 700™ M24

Model **SWS**™

Action

Barrel Length

Capacity

Order No. **5716**

*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: RE00136229

Serial: C6527738 Model M24 SWS Center Fire
Caliber: 7.62 NATO

Repairman:

Verify Repair

Status:

Closed 11/2/2007 10:16:25 AM

C6587738

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

neglet

11/2/2007

1:12 PM

CAPS

NUM

INS

SCRL

start

2 Mi...

5 Int...

4 Mi...

Part S...

longo...

Arms ...

1:12 PM

Serial Number: C6587738

Model: M24 SWS



RE00136229

11-24
INSPECTION CHECKLIST - REPAIRS
CONTRACT #: W52H09-07-C-0207

R & E NUMBER	136229		
SERIAL NUMBER	C6587738		
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
420	ASSEMBLE	7-10-08	RTZ
440	PROOF	7-10-08	SD
460	CHECK HEADSPACE	7-10-08	SD
470	DIS-ASSEMBLE GUN	7-11-08	RTZ
480	MAGNAFLUX	7-11-08	(RTZ)
510	DRILL AND TAP	7-11-08	SP
500	ROLLMARK CALIBER	7-15-08	RT
520	GOFF BLAST BBL / REC	7-17	C
530 & 540	APPLY COATINGS	7-22-08	RTZ
560	FINAL ASSEMBLY	7-22-08	TL
640	FUNCTION TEST AND	9-2-08	SPD
650	TARGET	9-2-08	SPD
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
670	FINAL INSPECTION	9-2-08	TL
	A) HEADSPACE	PASS FAIL	RTZ
	B) TRIGGER PULL	2.46 2.46 2.48 2.45 2.47 9.808	RTZ
680	F) SAFETY ON FORCE	6.25 6.25 6.25 9.808	RTZ
	G) SAFETY OFF FORCE	3.0 3.0 3.0 9.808	RTZ
	I) FIRING PIN INDENT	.024 .024 .024 9.808	RTZ
690	PACK	9-11-08	TL

F006 REV 5/2006

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6587738.__0
FILE DATE AND TIME: 09/03/2008 10:54

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.083
The Average Y Centroid of the Five Target Set:	-0.010
The Average Point of Impact of the Five Target Set:	0.083
The Average Mean Radius of the Five Target Set:	0.545
The Distance from POA to Centroid Target #1:	0.207
The Distance from Centroid Target #2 to Centroid Target #1:	0.341
The Distance from Centroid Target #3 to Centroid Target #1:	0.221
The Distance from Centroid Target #4 to Centroid Target #1:	0.352
The Distance from Centroid Target #5 to Centroid Target #1:	0.408

SERIAL NUMBER: C6587738.___0

TARGET NUMBER: 1

FILE DATE: 09/03/2008

FILE TIME: 10:54

X CENTROID: -0.029

Y CENTROID: -0.205

POA TO CENTROID: 0.207

HORZ SPREAD: 2.118

VERT SPREAD: 1.884

GROUP SPREAD: 2.232

MIN RADIUS: 0.177

MAX RADIUS: 1.317

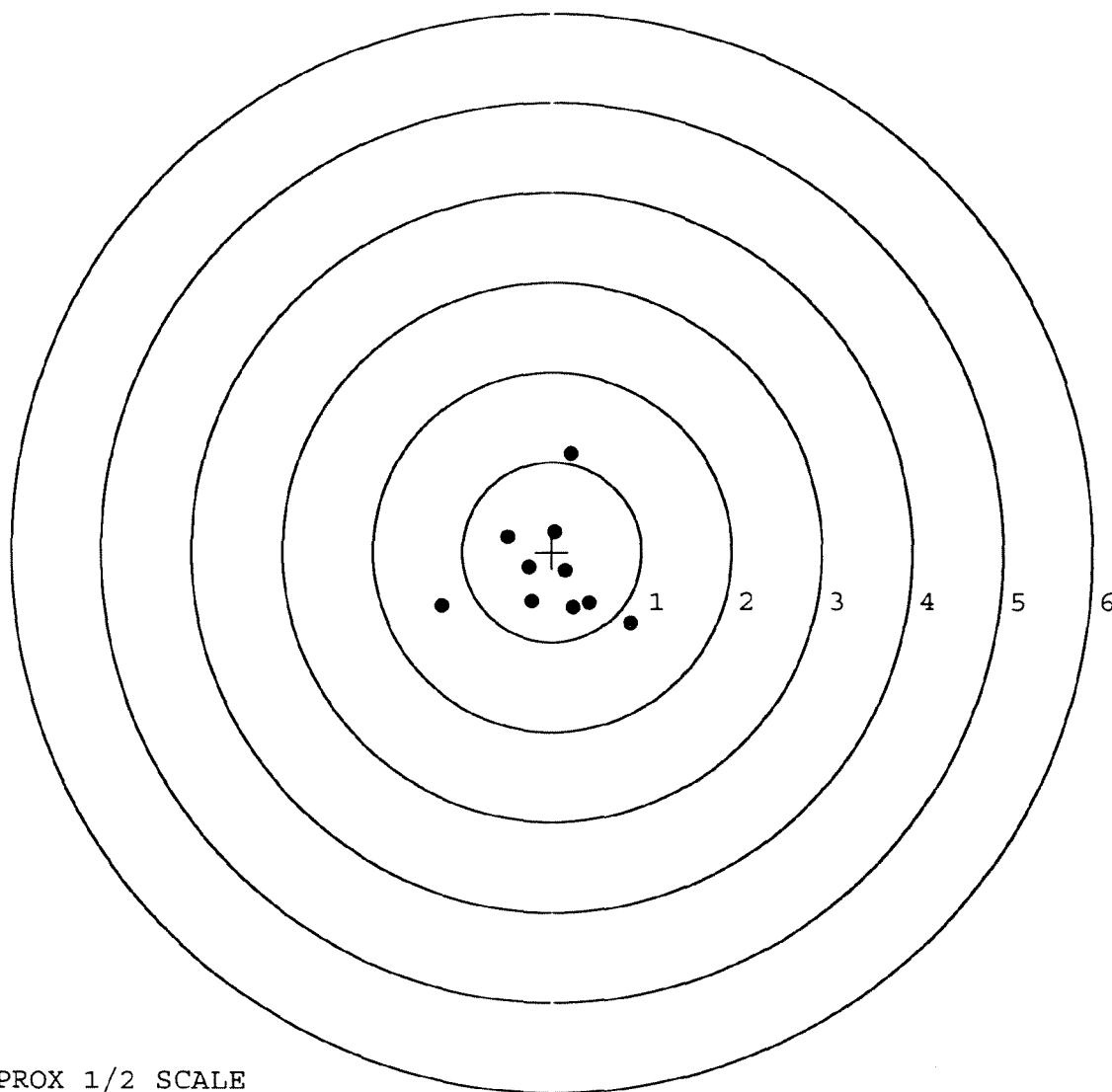
MEAN RADIUS: 0.658

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.879	-0.794
2:	0.414	-0.570
3:	0.237	-0.625
4:	-0.228	-0.551
5:	0.148	-0.207
6:	-0.257	-0.173
7:	-1.239	-0.607
8:	-0.496	0.164
9:	0.211	1.090
10:	0.040	0.226



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6587738. 0

TARGET NUMBER: 2

FILE DATE: 09/03/2008

FILE TIME: 10:54

X CENTROID: -0.160

Y CENTROID: 0.110

POA TO CENTROID: 0.195

HORZ SPREAD: 1.475

VERT SPREAD: 1.693

GROUP SPREAD: 1.694

MIN RADIUS: 0.149

MAX RADIUS: 0.899

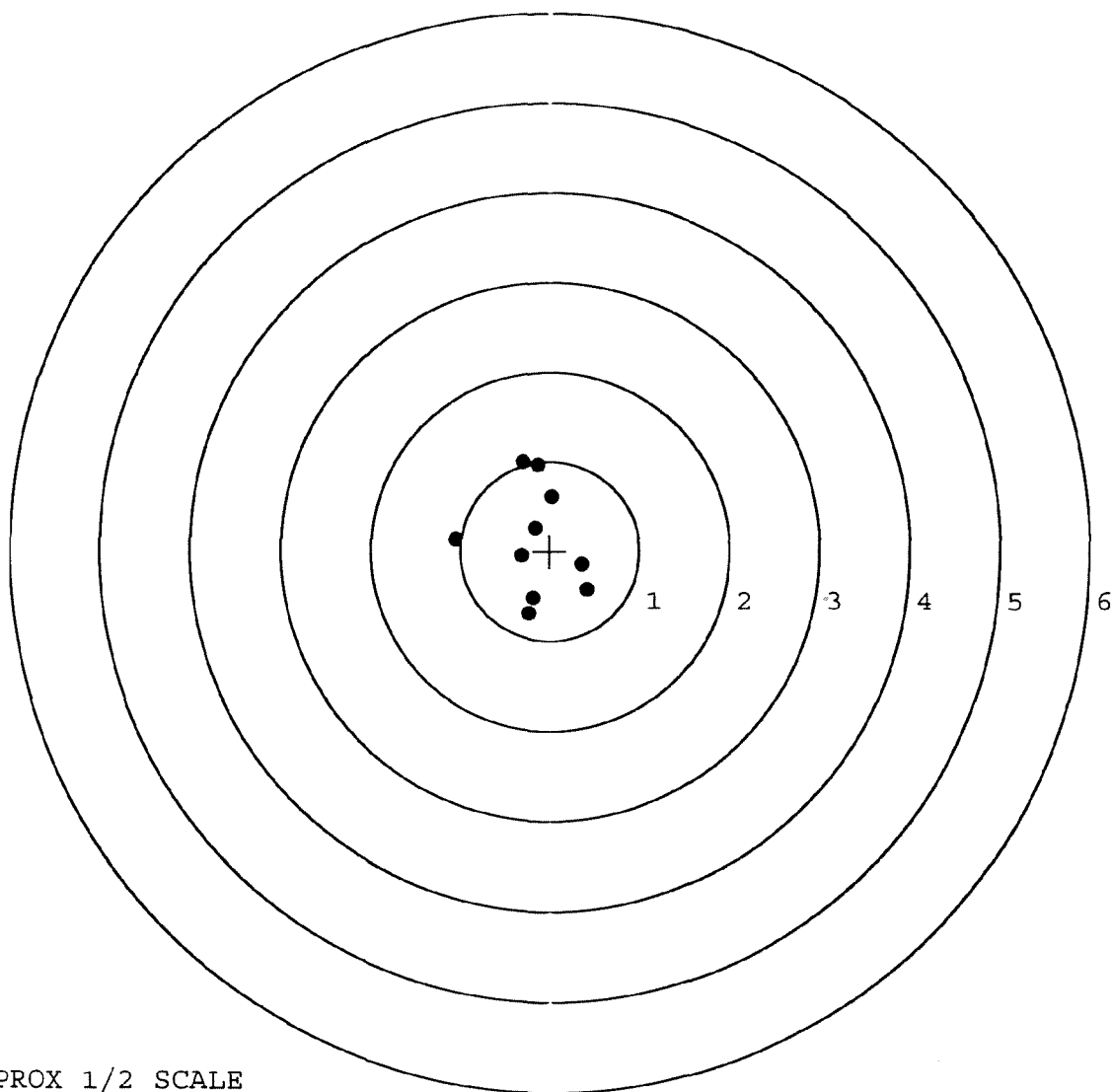
MEAN RADIUS: 0.637

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.421	-0.433
2:	0.360	-0.148
3:	-0.240	-0.695
4:	-0.193	-0.525
5:	-0.316	-0.054
6:	-0.168	0.259
7:	0.026	0.611
8:	-0.137	0.960
9:	-0.302	0.998
10:	-1.054	0.130



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6587738. __0

TARGET NUMBER: 3

FILE DATE: 09/03/2008

FILE TIME: 10:54

X CENTROID: 0.165

Y CENTROID: -0.098

POA TO CENTROID: 0.191

HORZ SPREAD: 1.296

VERT SPREAD: 1.271

GROUP SPREAD: 1.412

MIN RADIUS: 0.294

MAX RADIUS: 0.897

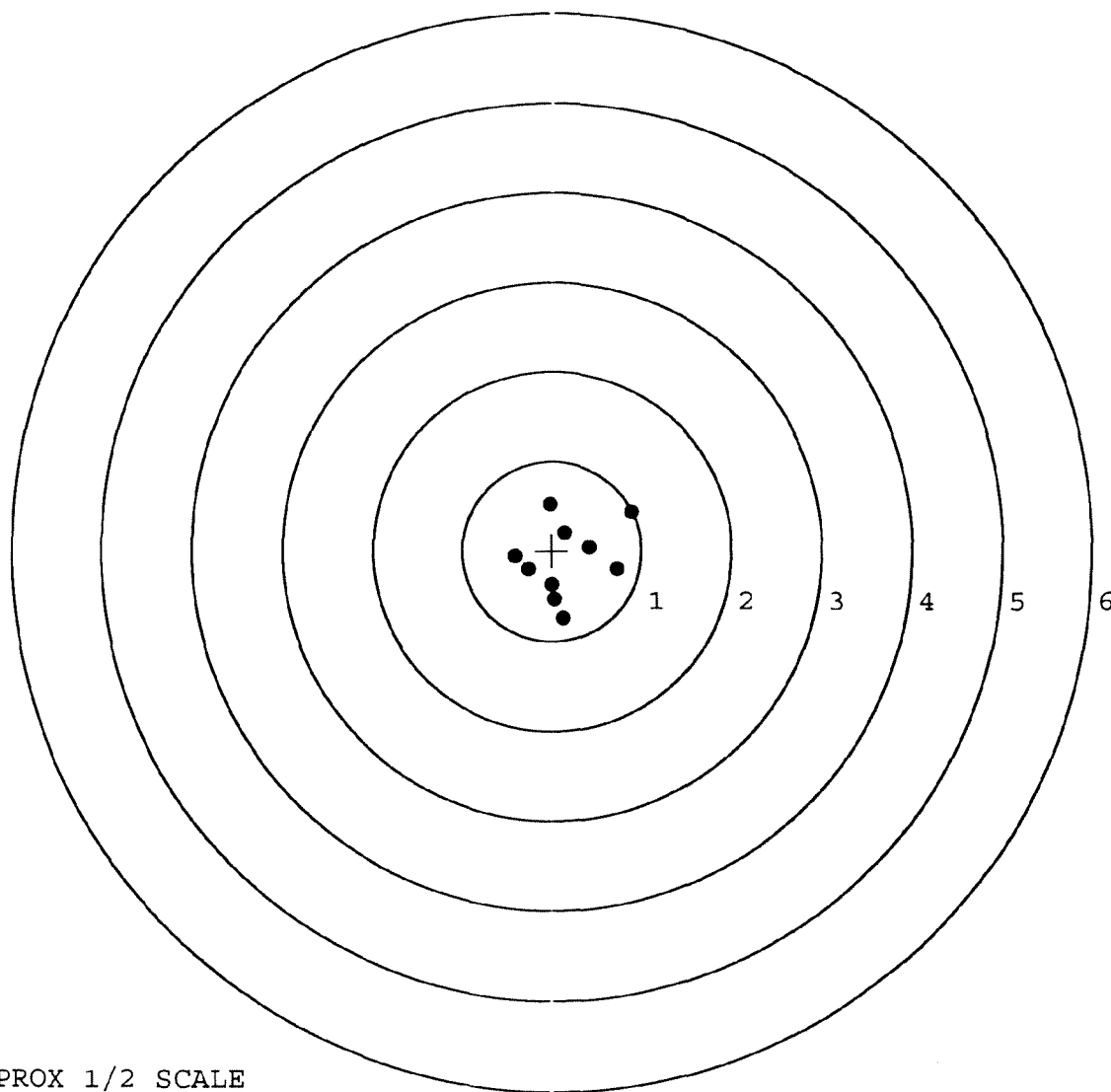
MEAN RADIUS: 0.518

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.129	-0.757
2:	0.030	-0.544
3:	-0.001	-0.386
4:	-0.262	-0.212
5:	-0.409	-0.065
6:	-0.023	0.514
7:	0.143	0.200
8:	0.422	0.045
9:	0.730	-0.205
10:	0.887	0.434



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6587738. __0

TARGET NUMBER: 4

FILE DATE: 09/03/2008

FILE TIME: 10:54

X CENTROID: -0.350

Y CENTROID: -0.060

POA TO CENTROID: 0.355

HORZ SPREAD: 1.289

VERT SPREAD: 1.040

GROUP SPREAD: 1.536

MIN RADIUS: 0.082

MAX RADIUS: 0.838

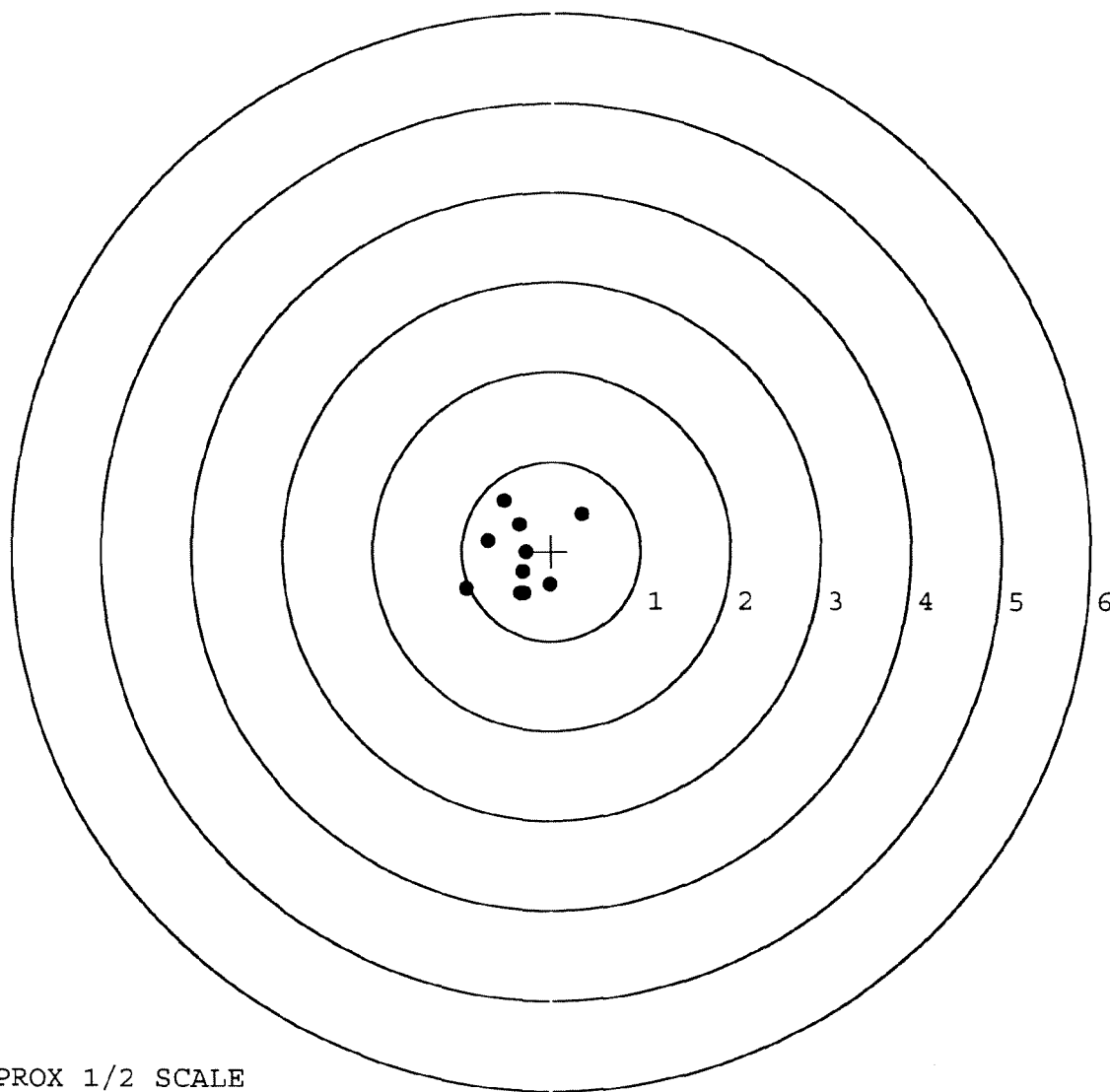
MEAN RADIUS: 0.450

IN 1 IN DIAMETER: 7

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.015	-0.376
2:	-0.351	-0.477
3:	-0.322	-0.230
4:	-0.285	-0.010
5:	-0.366	0.297
6:	-0.719	0.115
7:	-0.948	-0.421
8:	0.341	0.414
9:	-0.530	0.563
10:	-0.307	-0.477

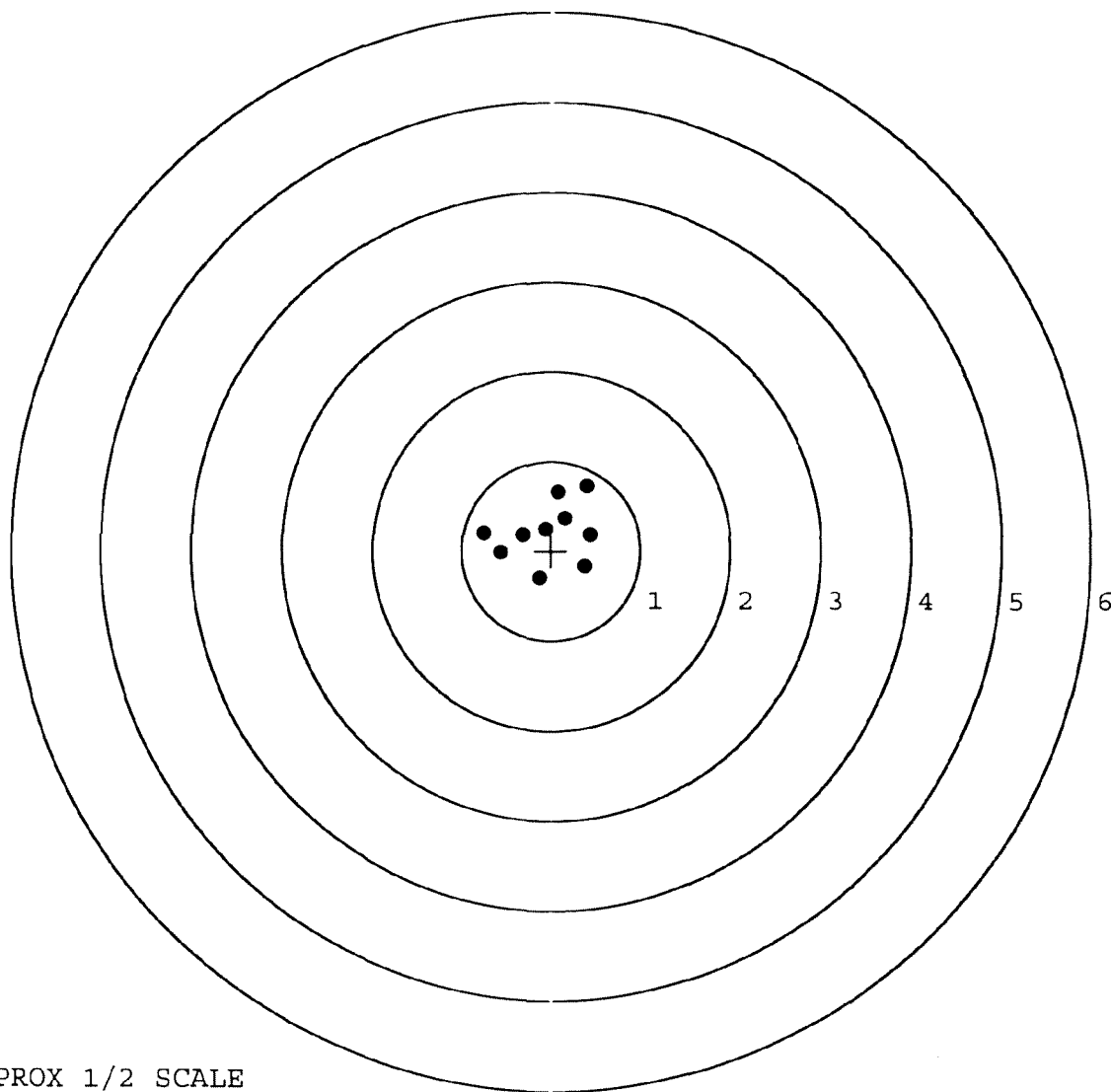


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6587738. 0
TARGET NUMBER: 5
FILE DATE: 09/03/2008
FILE TIME: 10:54

X CENTROID: -0.039
Y CENTROID: 0.204
POA TO CENTROID: 0.207
HORZ SPREAD: 1.192
VERT SPREAD: 1.038
GROUP SPREAD: 1.274
MIN RADIUS: 0.048
MAX RADIUS: 0.717
MEAN RADIUS: 0.460
IN 1 IN DIAMETER: 5
IN 2 IN DIAMETER: 10
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.380	-0.179
2:	0.436	0.186
3:	-0.133	-0.313
4:	-0.325	0.174
5:	-0.564	-0.023
6:	-0.756	0.197
7:	0.075	0.659
8:	0.403	0.725
9:	0.158	0.365
10:	-0.064	0.244



TARGET APPROX 1/2 SCALE

Remington



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

MODEL 700™ M24

SERIAL NO.
C6587738

ORDER NO.
5716

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

20



5716 C6587738

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6587738

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		10/24/90	KR
615	Rollmark Caliber		10/24/90	BLS
617	Drill and Tap Sight Holes		10/25/90	FB
618	Polish Barrel RWB		10/26/90	WB
620	Apply Coatings (Barrel Action)		11-7-90	TSA
	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		11/17/90	WB

op. #	OP. NAME	READINGS			DATE	INIT		
625 cont.	F) Safety On Force	4	4	4	11/16/90	WB		
	G) Safety Off Force	2	2	2	11/16/90	WB		
	H) Trigger Pull Test & Retainability				11/17/90	WB		
	I) Firing Pin Indent	.022	.022	.022	11/16/90	WB		
	J) Assemble Stock				12/4/90	RW		
	K) Assemble Swivel Studs				12-6-90	QB		
	L) Attach Front and Rear Sight Assemblies				12/4/90	RW		
	M) Iron Sight Alignment				12/4/90	RW		
	N) Detach Front & Rear Sights & place in numbered container				12/4/90	RW		
	O) Attach Scope to Rifle				12/4/90	RW		
	P) Detach & Attach Scope 20 Times				12/4/90	RW		
640	Gallery Target & Test				12/4/90	NF		
	A) Time				"	NF		
	B) Malfunctions				"	NF		
	C) Pierced Primers				"	NF		
	D) Optical Clarity of Scope				"	NF		
645	Inspect for Live Ammo				12/4/90	NF		
655	Final Inspection							
	A) Headspace				12-6-90	QB		
	B) Trigger Pull	270	269	273	265	276	12-6-90	QB
	C) Function						12-6-90	QB
660	Pack						12/14/90	NF

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

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

SERIAL NO. C6587738

DATE 11/17/90

TESTER W.B.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.57	2.52	2.55	2.70	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.54	2.53	2.56	2.69	
PULL #3	2.55	2.55	2.54	2.73	
PULL #4	2.54	2.48	2.48	2.65	
PULL #5	2.50	2.50	2.51	2.76	
TOTAL	12.70	12.58	12.64		
AVG.	2.54	2.51	2.53		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.27	3.30		
PULL #2	3.20	3.35		
PULL #3	3.21	3.15		
PULL #4	3.27	3.15		
PULL #5	3.20	3.23		
TOTAL	16.15	16.18		
AVG.	3.23	3.23		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.32	4.19		4.11
PULL #2	4.06	4.10		4.12
PULL #3	4.16	4.21		4.11
PULL #4	4.16	4.26		4.12
PULL #5	4.24	4.30		4.08
TOTAL	20.94	21.06		20.54
AVG.	4.19	4.21		4.11

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6587738
5 Dec 1998

CENTROIDAL DISTANCES

0 TO	1	.0534603
1 TO	2	.184567
1 TO	3	.0144222
1 TO	4	.116726
1 TO	5	.629287

3 \$ <----POA

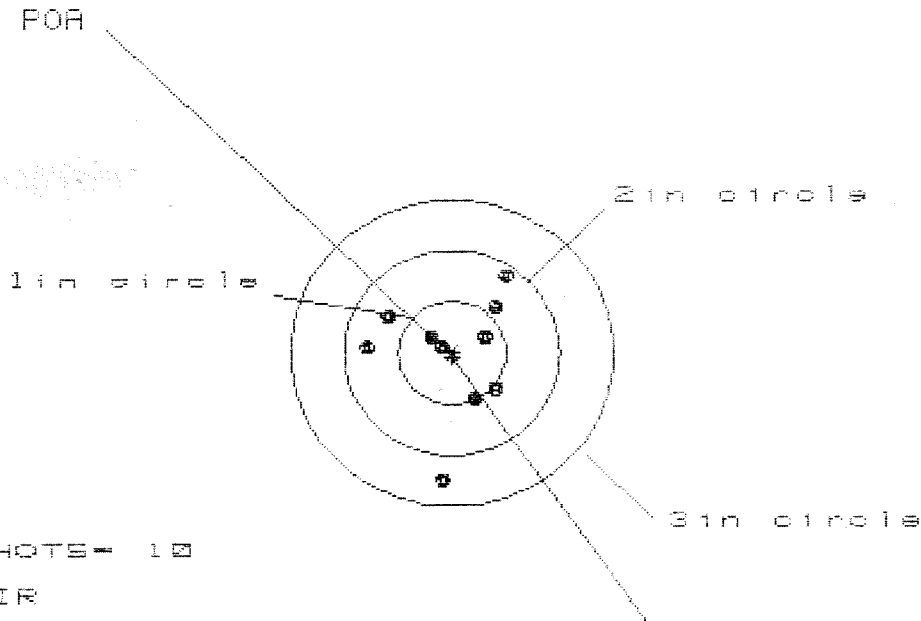
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0842
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1018
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .132109
THE AMP FOR THIS RIFLE IS: .8402

5 Dec 1998

FILE:/PATTERNING/CENTERFIRE_PATT/08587738

CENTERFIRE PATTERNS

1



OF SHOTS - 10

IN CIR

1in = 4

2in = 9

3in = 10

HS = 1.336

VS = 1.994

GS = 2.075

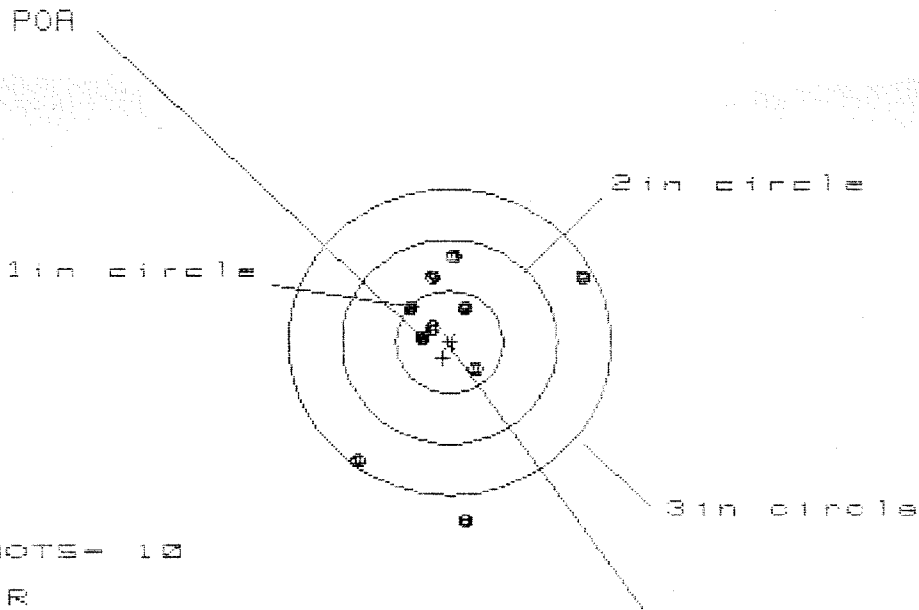
CENTROID *

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.530	.525	.476
MINIMUM X	:	-.806	-.811	-.745
MAXIMUM Y	:	.752	.614	.437
MINIMUM Y	:	-1.242	-.629	-.552
CENTROID X	:	-.005	-.000	-.066
CENTROID Y	:	.045	.183	.106
POA TO CENTROID in.	:	.045	.183	.125
MIN RADIUS	:	.115	.117	.031
MEAN RADIUS	:	.605	.522	.472
MAX RADIUS	:	1.243	.815	.745
HORIZONTAL SPREAD	:	1.336	1.336	1.221
VERTICAL SPREAD	:	1.994	1.243	.989
EXTREME SPREAD	:	2.075	1.506	1.298
NUMBER IN ONE INCH CIRCLE =			4	
NUMBER IN TWO INCH CIRCLE =			9	
NUMBER IN THREE INCH CIRCLE =			10	

5 Dec 1990

FILE:/PATTERNING/CENTERFIRE_PATT/06587738

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 4

2in = 7

3in = 9

HS= 2.112

VS= 2.569

GS= 2.781

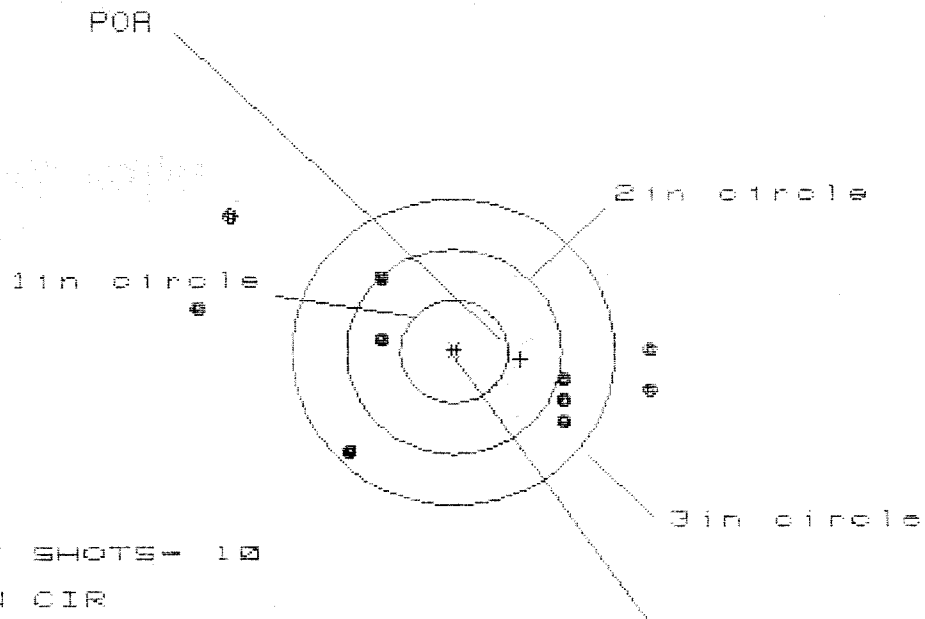
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.270	1.290	.437
MINIMUM X	:	-.842	-.822	-.661
MAXIMUM Y	:	.862	.672	.731
MINIMUM Y	:	-1.707	-1.338	-1.279
CENTROID X	:	.060	.040	-.121
CENTROID Y	:	.157	.347	.288
POA TO CENTROID in.	:	.168	.349	.312
MIN RADIUS	:	.246	.142	.058
MEAN RADIUS	:	.795	.637	.527
MAX RADIUS	:	1.717	1.570	1.439
HORIZONTAL SPREAD	:	2.112	2.112	1.098
VERTICAL SPREAD	:	2.569	2.010	2.010
EXTREME SPREAD	:	2.781	2.781	2.191
NUMBER IN ONE INCH CIRCLE =			4	
NUMBER IN TWO INCH CIRCLE =			7	
NUMBER IN THREE INCH CIRCLE =			9	

5 Dec 1998

FILE:/PATTERNING/CENTERFIRE_PATT/06597738

CENTERFIRE PATTERNS # 3



OF SHOTS - 10

IN CIR

1in = 0

2in = 3

3in = 6

HS = 4.238

VS = 2.366

GS = 4.320

PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	1.857
MINIMUM X	-2.381
MAXIMUM Y	1.374
MINIMUM Y	-0.992
CENTROID X	-0.622
CENTROID Y	0.072
POA TO CENTROID in.	0.626
MIN RADIUS	0.685
MEAN RADIUS	1.501
MAX RADIUS	2.487
HORIZONTAL SPREAD	4.238
VERTICAL SPREAD	2.366
EXTREME SPREAD	4.320
NUMBER IN ONE INCH CIRCLE =	0
NUMBER IN TWO INCH CIRCLE =	3
NUMBER IN THREE INCH CIRCLE =	6

5 Dec 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C8587738

CENTERFIRE PATTERNS

4

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS = 10

IN CIR

1in = 6

2in = 9

3in = 10

HS = 1.702

VS = 1.278

GS = 1.907

PATTERN #

4

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.113

.961

.939

MINIMUM X

-.589

-.465

-.487

MAXIMUM Y

.474

.230

.136

MINIMUM Y

-.804

-.751

-.304

CENTROID X

.007

-.117

-.095

CENTROID Y

.053

.000

.094

POA TO CENTROID in.

.053

.117

.133

MIN RADIUS

.129

.075

.039

MEAN RADIUS

.497

.378

.321

MAX RADIUS

1.210

.981

.944

HORIZONTAL SPREAD

1.702

1.426

1.426

VERTICAL SPREAD

1.278

.981

.440

EXTREME SPREAD

1.907

1.485

1.426

NUMBER IN ONE INCH CIRCLE =

6

NUMBER IN TWO INCH CIRCLE =

9

NUMBER IN THREE INCH CIRCLE =

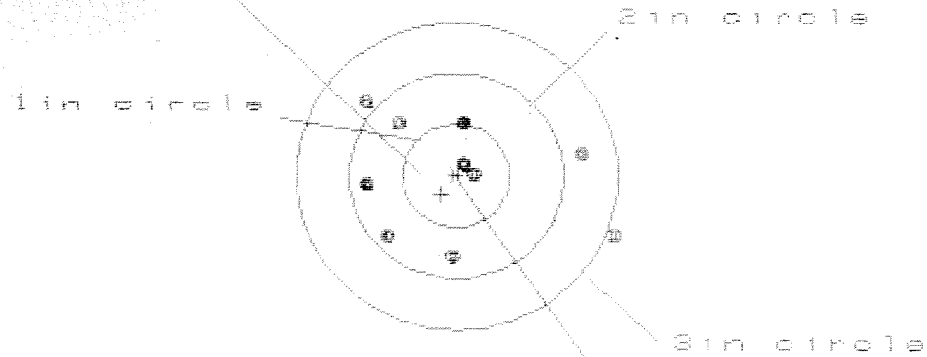
10

5 Dec 1998

FILE:/PATTERNING/CENTERFIRE_PATT/G6582738

CENTERFIRE PATTERNS # 5

POA



OF SHOTS = 10

IN CIR

1in = 2

2in = 7

3in = 9

HS = 2.373

VS = 1.482

GS = 2.710

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.502	1.330	.512
MINIMUM X	:	-.871	-.704	-.537
MAXIMUM Y	:	.707	.640	.655
MINIMUM Y	:	-.775	-.842	-.827
CENTROID X	:	.139	-.028	-.195
CENTROID Y	:	.182	.249	.234
POA TO CENTROID in.	:	.229	.251	.385
MIN RADIUS	:	.095	.217	.384
MEAN RADIUS	:	.803	.708	.633
MAX RADIUS	:	1.618	1.335	.869
HORIZONTAL SPREAD	:	2.373	2.034	1.049
VERTICAL SPREAD	:	1.482	1.482	1.482
EXTREME SPREAD	:	2.710	2.100	1.685
NUMBER IN ONE INCH CIRCLE =			2	
NUMBER IN TWO INCH CIRCLE =			7	
NUMBER IN THREE INCH CIRCLE =			9	

RECEIVING AND ESTIMATING REPORT

COMMENTS

ORDER
R 94-21332

INITIAL CUSTOMER ORDER NO.

JJM

W/LEUPOLD 10X SCOPE, DEPLOYMENT KIT

L/STOCK

Scope

90-0266

DATE RECEIVED
07/15/94DATE OPENED
07/18/94

DATE CODE

SERIAL NUMBER
C6587738

NEW SERIAL NUMBER

MODEL AND GRADE
700 7.62

NATO

ACCESSORIES

SCOPE MNTS

SCOPE BASE

FROM:

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

AL 36201-5025

SHIP TO:

COMMANDER (W52H094138H226)
DEFENSE DIST DEPOT ANNISTON
ATTN DDAA-UR BLDG 112
ANNISTONAL
36201-5025

CUST NO: 098397 C.O.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

COMMENTS

✓ Stock

\$471.11

✓ Trigger Assy

173.31

✓ Firing Pin Assy

9.96

✓ Mag Spring

1.70

✓ Mag Follower

6.12

CTI

50.00

\$712.20

REPAIRMAN

PROOF

CLEAN

TEST

TARGET

PATTERN

GALLERY TESTER

DATE

DATE

DATE

DATE

DATE

11/1/95

OFFICE COPY

RD6925 REV. 1/94

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

M2400026216

SWS TRIGGER PULL TEST

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

SERIAL NO 06587738
DATE 8-31-95
TESTER DA

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.70	2.48	2.71		MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.80	2.40	2.81		
PULL #3	2.70	2.40	2.46		
PULL #4	2.90	2.30	2.63		
PULL #5	2.90	2.30	2.79		
TOTAL	14.00	11.88	13.40		
AVG.	2.80	2.37	2.68		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.01	3.13		
PULL #2	3.00	3.00		
PULL #3	3.00	2.95		
PULL #4	2.95	3.01		
PULL #5	2.90	3.10		
TOTAL	14.86	15.19		
AVG.	2.97	3.03		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.11	4.21	4.13	
PULL #2	4.04	4.14	4.15	
PULL #3	4.00	4.07	4.14	
PULL #4	4.17	4.08	4.07	
PULL #5	4.06	4.00	4.00	
TOTAL	20.38	20.50	20.49	
AVG.	4.07	4.10	4.09	

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6587738

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 3/4	6 3/4	6 3/4			12/4	WB
	G) Safety Off Force	3	3	3			12/4	WB
	H) Trigger Pull Test & Retainability							
	I) Firing Pin Indent	.0225	.023	.0225			12/4	WB
	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	2.47	2.58	2.61	2.58	2.64	12/4	WB
	C) Function							
660	Pack							