

C6611745

MODEL 700™ M24

Model SMS™

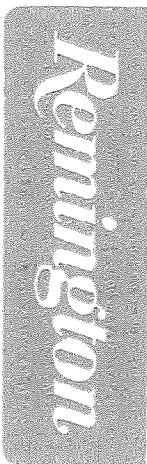
Action _____

Barrel Length _____

Capacity _____

Order No. 5715

* Includes 1 in chamber.



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: **RE00092931** Serial: C6611745 Model: M24 SWS Center Fire
 Verify Repair: [Redacted] Caliber: 7.62 NATO Produced: 03/18/1991 Repairman: [Redacted]
 Status: Closed 2/10/2005 1:14:00 PM

Address Information

Customer: ☒ Received From Return To: ☐ Received From

Name: **DEF DIST DEPOT ANNISTON** **DEF DIST DEPOT ANNISTON**

Address 1: [Redacted] Address 2: [Redacted] PO Box: [Redacted] PO Box: [Redacted]

City: **ANNISTON** **ANNISTON**

State: **AL** Zip Code: **362014199** Country: **US** State: **AL** Zip Code: **362014199** Country: **US**

FFL: [Redacted]

Contact / Condition **Problems** **Estimate** **History / Status** **Shipping / Billing**

Contact Information **Received Condition** **Accessories Received**

Phone: [Redacted] Condition: **Good**

Fax: [Redacted] Condition Notes: [Redacted]

Email: [Redacted] CSR Notes: [Redacted]

Comments: [Redacted]

Code	Desc	Qty
A007	With Stud	3
A010	Hard Case	1
A017	Scope Base	1
A026	Scope	1
A057	Frt and Rear Sgt Base	1

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

mag ell 2/14/2005 9:15 AM CAPS T NUM JINE BCPL

start 5 2 3 101532102

Serial Number: **C6611745**

Model: **M24 SWS**



RE00092931

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6611745.___0
FILE DATE AND TIME: 06/08/2005 08:34

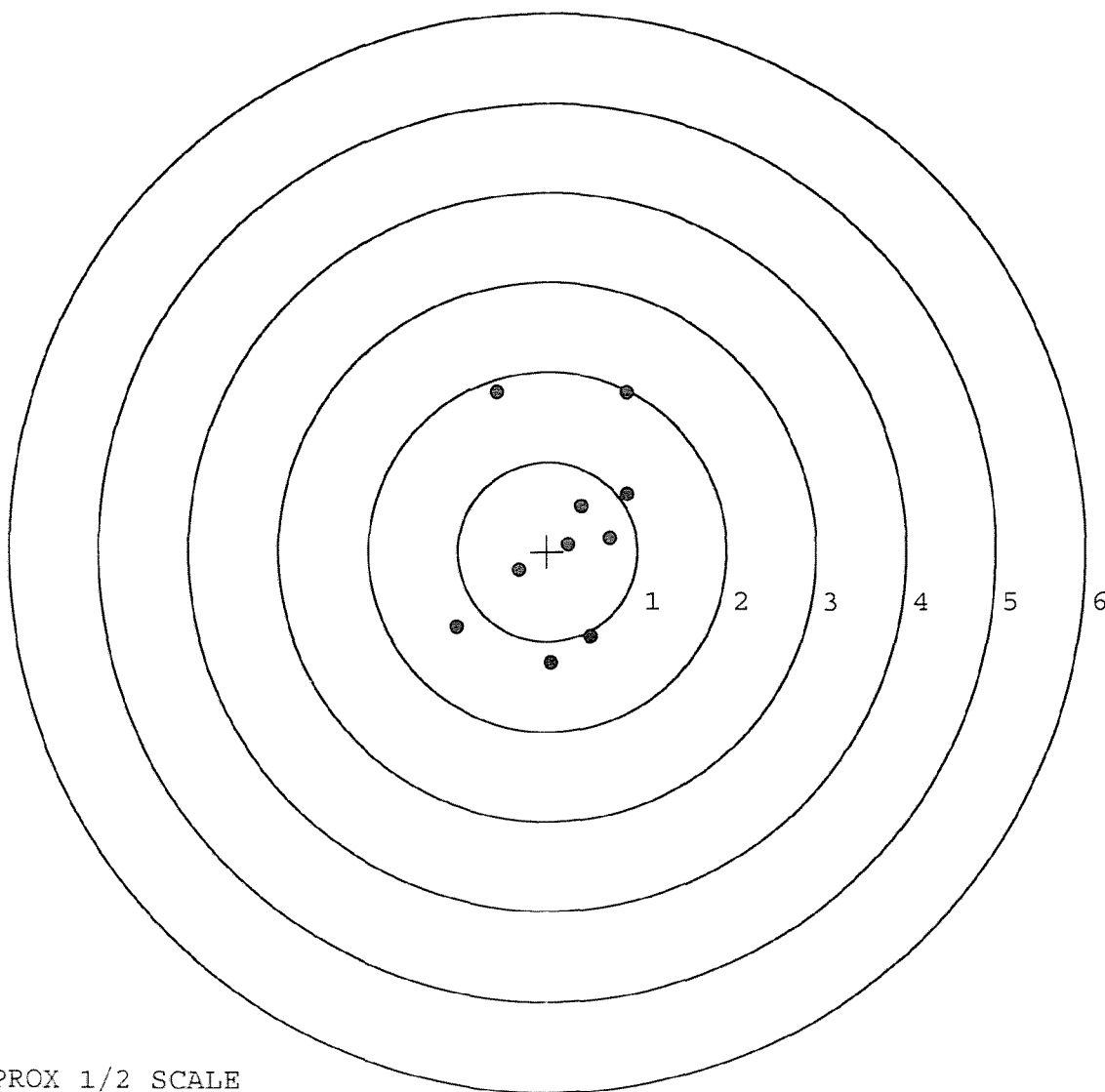
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.046
The Average Y Centroid of the Five Target Set:	0.052
The Average Point of Impact of the Five Target Set:	0.070
The Average Mean Radius of the Five Target Set:	0.927
The Distance from POA to Centroid Target #1:	0.237
The Distance from Centroid Target #2 to Centroid Target #1:	0.651
The Distance from Centroid Target #3 to Centroid Target #1:	0.338
The Distance from Centroid Target #4 to Centroid Target #1:	0.226
The Distance from Centroid Target #5 to Centroid Target #1:	0.463

SERIAL NUMBER: C6611745. __0
TARGET NUMBER: 1
FILE DATE: 06/08/2005
FILE TIME: 08:34

POINT#	X	Y
1:	0.475	-0.947
2:	0.044	-1.243
3:	-1.017	-0.849
4:	-0.316	-0.212
5:	0.881	0.641
6:	0.696	0.151
7:	0.239	0.076
8:	0.379	0.509
9:	-0.573	1.775
10:	0.874	1.773

X CENTROID: 0.168
Y CENTROID: 0.167
POA TO CENTROID: 0.237
HORZ SPREAD: 1.898
VERT SPREAD: 3.018
GROUP SPREAD: 3.080
MIN RADIUS: 0.116
MAX RADIUS: 1.770
MEAN RADIUS: 1.017
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 5
in 3 IN DIAMETER: 7

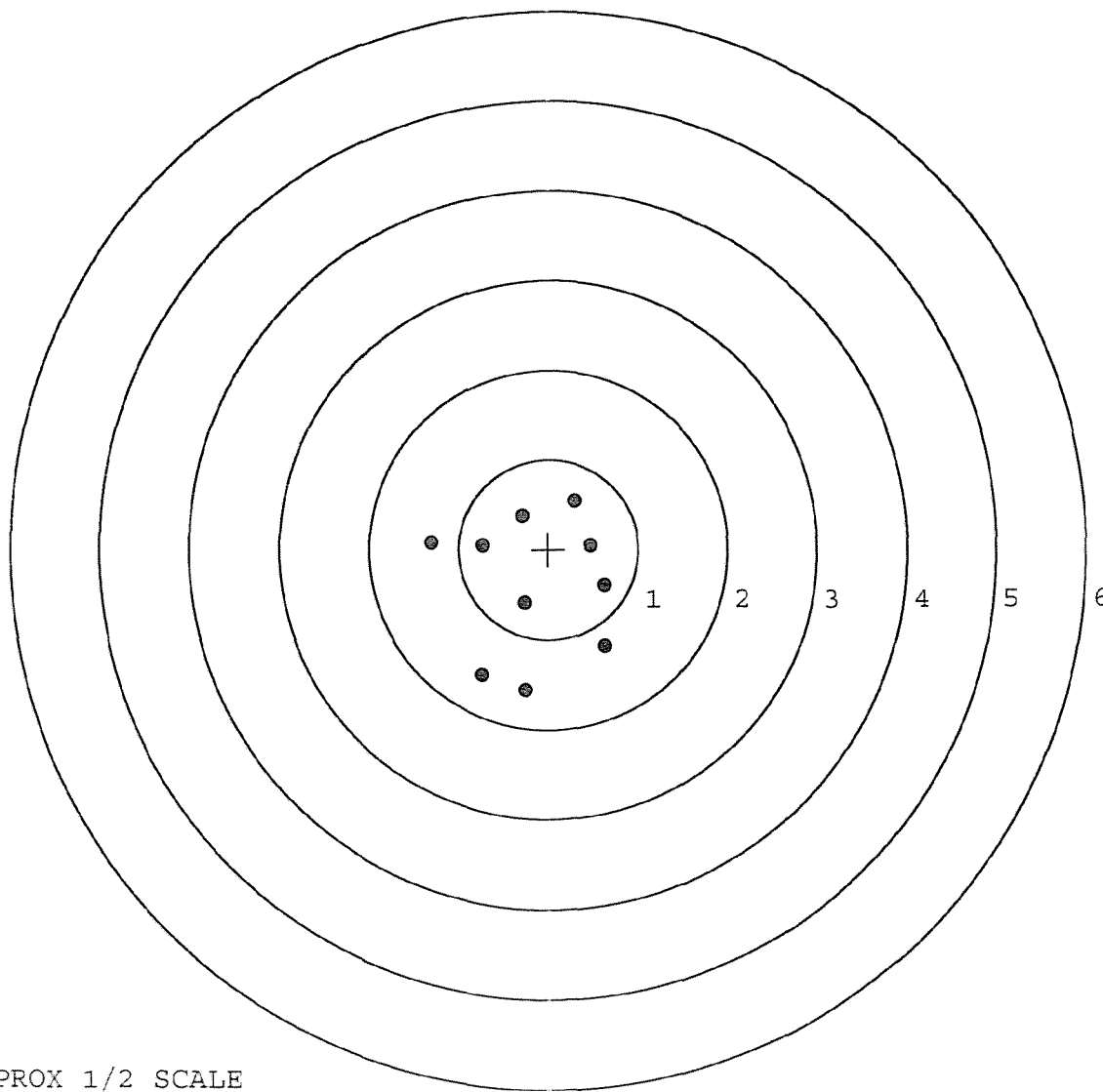


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6611745. __0
TARGET NUMBER: 2
FILE DATE: 06/08/2005
FILE TIME: 08:34

POINT#	X	Y
1:	0.627	-1.077
2:	-0.264	-1.563
3:	-0.743	-1.390
4:	-0.267	-0.600
5:	0.625	-0.401
6:	0.472	0.046
7:	0.289	0.534
8:	-0.298	0.379
9:	-0.733	0.048
10:	-1.306	0.074

X CENTROID: -0.160
Y CENTROID: -0.395
POA TO CENTROID: 0.426
HORZ SPREAD: 1.933
VERT SPREAD: 2.097
GROUP SPREAD: 2.250
MIN RADIUS: 0.231
MAX RADIUS: 1.238
MEAN RADIUS: 0.893
IN 1 IN DIAMETER: 1
IN 2 IN DIAMETER: 5
in 3 IN DIAMETER: 10

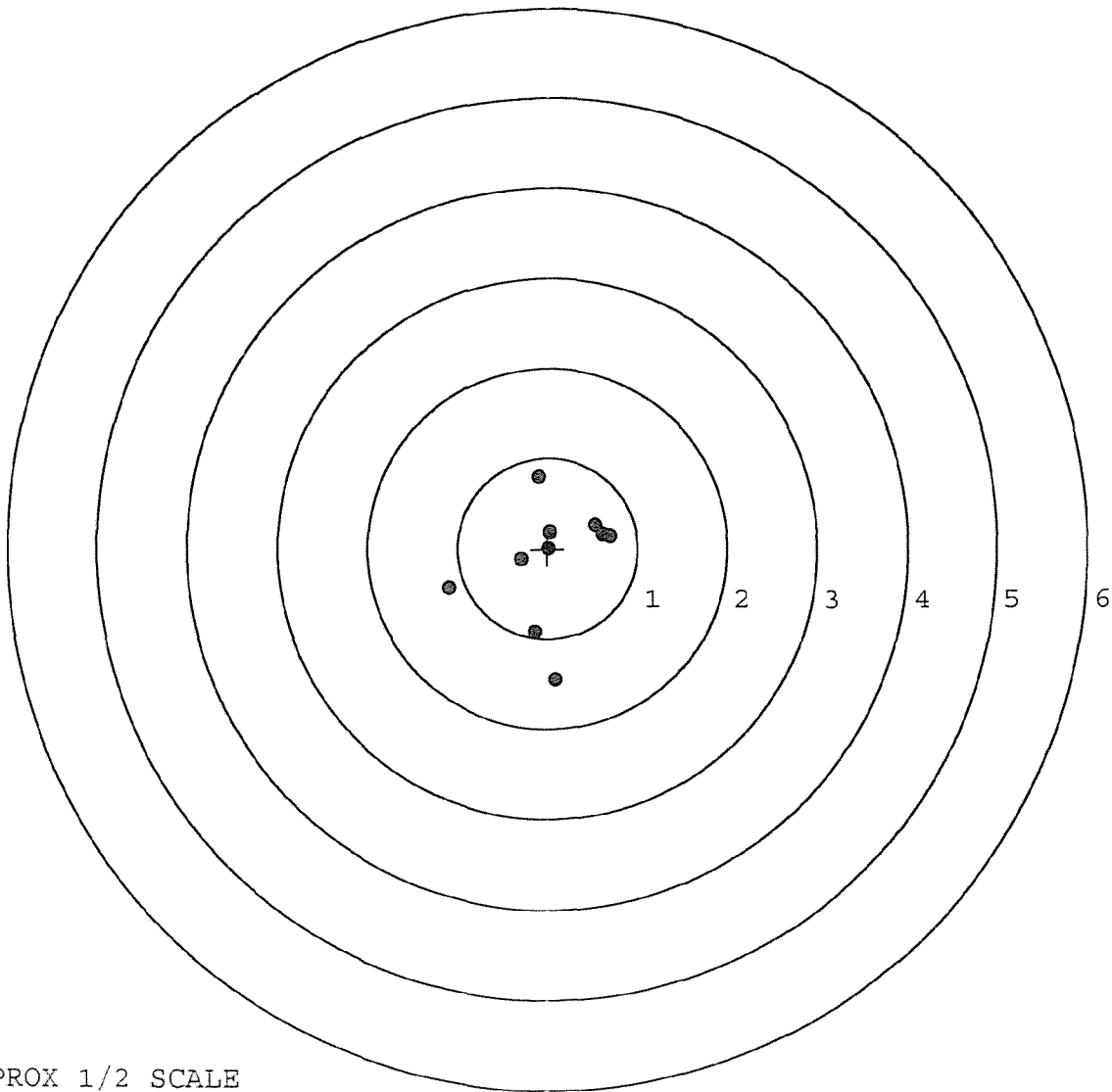


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6611745. __ 0
TARGET NUMBER: 3
FILE DATE: 06/08/2005
FILE TIME: 08:34

X CENTROID: 0.030
Y CENTROID: -0.142
POA TO CENTROID: 0.145
HORZ SPREAD: 1.788
VERT SPREAD: 2.249
GROUP SPREAD: 2.258
MIN RADIUS: 0.138
MAX RADIUS: 1.322
MEAN RADIUS: 0.704
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.007	-0.005
2:	0.092	-1.462
3:	-0.152	-0.931
4:	-1.096	-0.443
5:	-0.298	-0.115
6:	0.033	0.183
7:	0.525	0.263
8:	0.603	0.166
9:	0.692	0.142
10:	-0.106	0.787



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6611745. __0

TARGET NUMBER: 4

FILE DATE: 06/08/2005

FILE TIME: 08:34

X CENTROID: 0.394

Y CENTROID: 0.186

POA TO CENTROID: 0.436

HORZ SPREAD: 2.139

VERT SPREAD: 2.561

GROUP SPREAD: 2.886

MIN RADIUS: 0.545

MAX RADIUS: 1.670

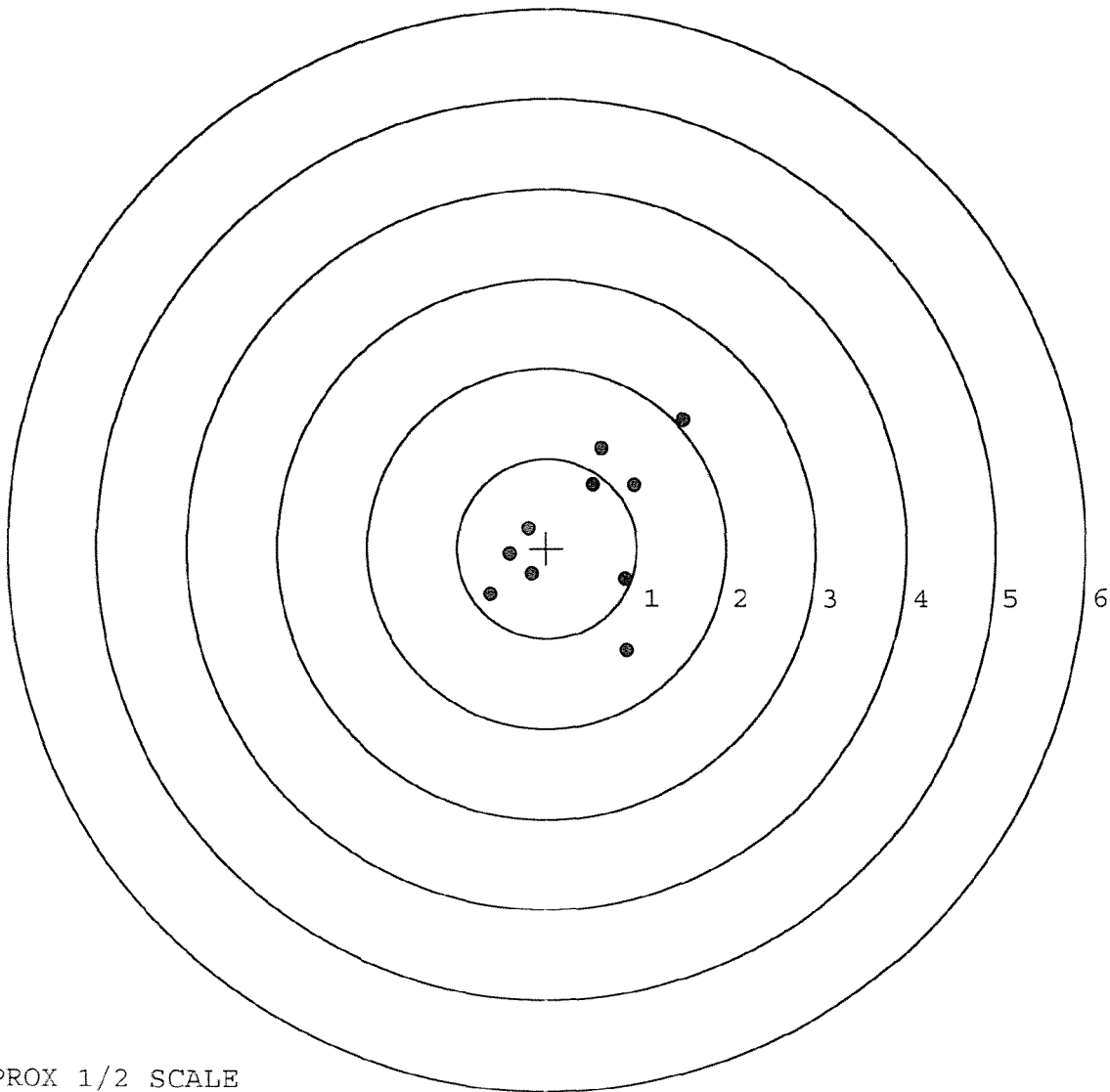
MEAN RADIUS: 0.950

IN 1 IN DIAMETER: 0

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 9

POINT#	X	Y
1:	0.890	-1.134
2:	0.870	-0.341
3:	0.973	0.712
4:	0.511	0.718
5:	0.602	1.119
6:	-0.213	0.224
7:	-0.410	-0.062
8:	-0.169	-0.292
9:	-0.627	-0.510
10:	1.512	1.427

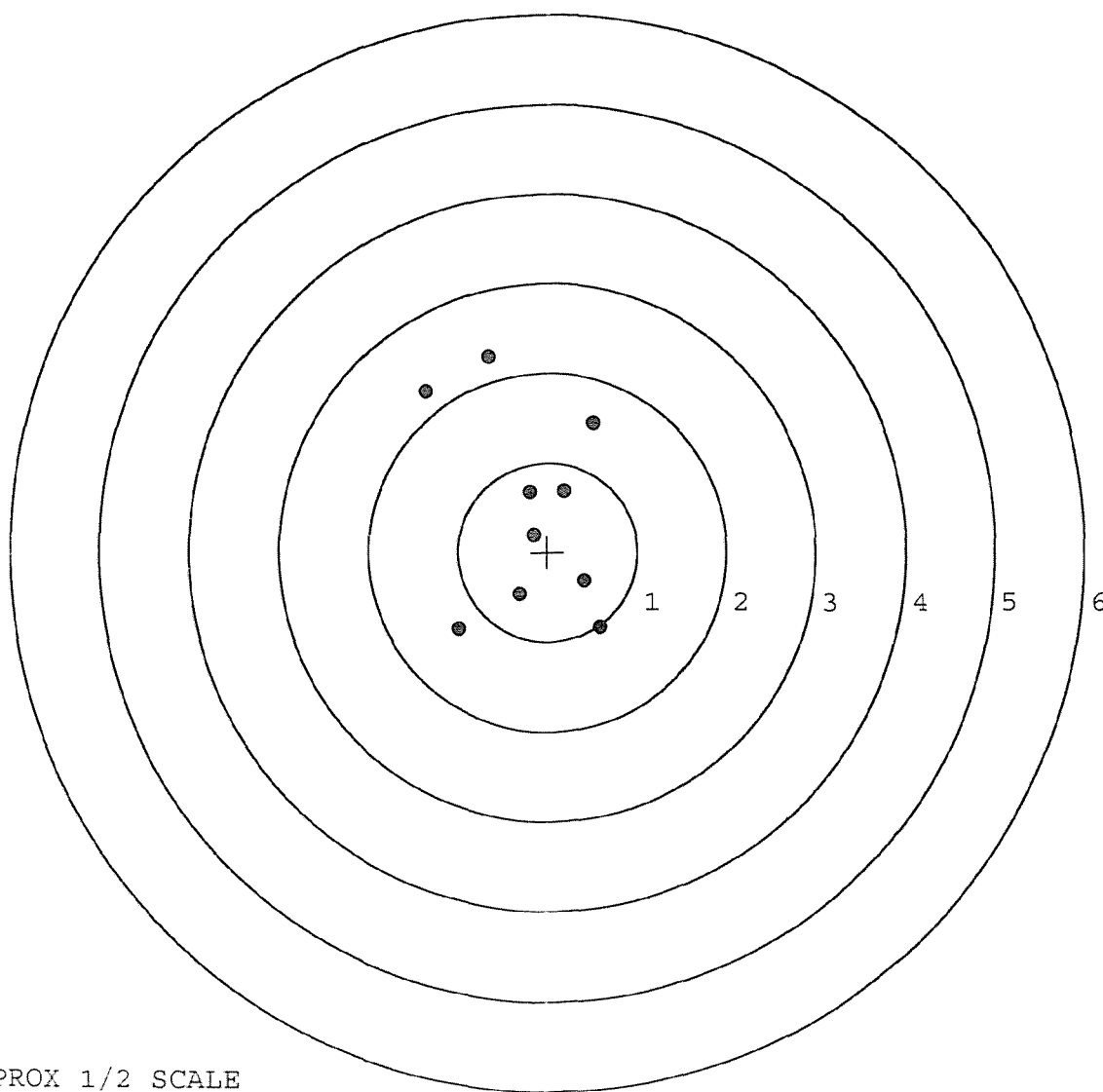


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6611745. __ 0
TARGET NUMBER: 5
FILE DATE: 06/08/2005
FILE TIME: 08:34

X CENTROID: -0.202
Y CENTROID: 0.445
POA TO CENTROID: 0.488
HORZ SPREAD: 1.957
VERT SPREAD: 3.041
GROUP SPREAD: 3.264
MIN RADIUS: 0.233
MAX RADIUS: 1.790
MEAN RADIUS: 1.069
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 5
in 3 IN DIAMETER: 6

POINT#	X	Y
1:	0.586	-0.840
2:	0.409	-0.328
3:	-0.317	-0.474
4:	-0.989	-0.867
5:	-0.161	0.188
6:	0.185	0.682
7:	-0.201	0.678
8:	0.504	1.441
9:	-0.666	2.174
10:	-1.371	1.793



TARGET APPROX 1/2 SCALE

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

R & E NUMBER	92931		
SERIAL NUMBER	C6611745		
LOG-IN DATE	2-10-08		
INSPECT AND VERIFY:			
OPERATION #	OPERATION NAME	DATE	INITIAL
550	DIS-ASSEMBLE GUN	4-25-05	RTZ
560 A	RE-BARREL	5-3-05	RTZ
B	DRILL AND TAP	5-5-05	TRW
575	ASSEMBLE	5-3-05	RTZ
600	PROOF	5-4-05	AC
605	CHECK HEADSPACE	5-4-05	AC
610	DIS-ASSEMBLE GUN	5-6-05	RTZ
612	MAGNAFLUX		
615	ROLLMARK CALIBER	5-9-05	CW
618	ROTO-BLAST	5-9-05	LB
620	APPLY COATINGS	5-16-05	CW
625 A	FINAL ASSEMBLY	6-2-05	RTZ
B	TRIGGER PULL TEST		
C	SAFETY "ON" FORCE	6-9-05	AC
D	SAFETY "OFF" FORCE	6-9-05	AC
E	FIRING PIN INDENT	6-9-05	AC
640	TARGET	6-8-05	TRW
655	FINAL INSPECT	6-9-05	AC
660	PACK		
		SHIP DATE	
QAR INSPECTION DATE			

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

Remington[®]

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

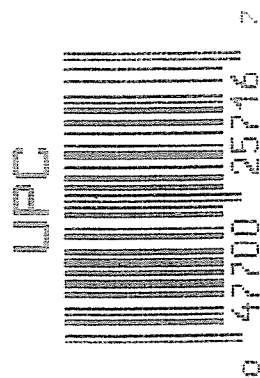
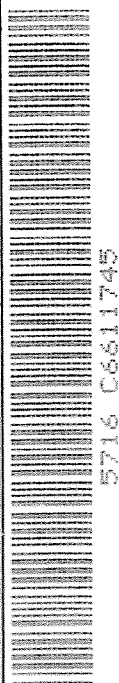
DU PONT

MODEL 700[™] M24

SERIAL NO.
C6811745

ORDER NO.
5716

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



CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6611745

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	1 10 91		RW
600	Proof	1 10 91		RW
607	Check Headspace	1 10 91		RW
610	Dis-assemble Gun	1 10 91		RW
612	Magnaflux Barrel Action		1/16/91	KR
	Magnaflux Bolt		"	KR
615	Rollmark Caliber		"	ES
617	Drill and Tap Sight Holes	1 17 91		WB
618	Polish Barrel	1 17 91		WB
620	Apply Coatings (Barrel Action)		2-18-91	JA
	Apply Coating (Bolt)			JA
625	Final Assembly A) Clean inside of Bolt Assembly		2/19/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		2/19/91	RW
	C) Inspect Ejector Hole for Chamfer		2/19/91	RW
	D) Oil Firing Pin Ass'y		2/19/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		3-8-91	JA

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			3/8/91	WLB
	G) Safety Off Force	2 1/2	2 1/2	2 1/2			3/8/91	WLB
	H) Trigger Pull Test & Retainability						3-8-91	RL
	I) Firing Pin Indent	.0235	.0232	.023			3/8/91	WLB
	J) Assemble Stock						3/8/91	RW
	K) Assemble Swivel Studs						3-11-91	DH
	L) Attach Front and Rear Sight Assemblies						3/8/91	RW
	M) Iron Sight Alignment						3/8/91	RW
	N) Detach Front & Rear Sights & place in numbered container						3/8/91	RW
	O) Attach Scope to Rifle						3/8/91	RW
	P) Detach & Attach Scope 20 Times						3/8/91	RW
640	Gallery Target & Test						3/8/91	14
	A) Time							19
	B) Malfunctions							18
	C) Pierced Primers							19
	D) Optical Clarity of Scope							19
645	Inspect for Live Ammo						3/8/91	14
655	Final Inspection							
	A) Headspace						3-11-91	DH
	B) Trigger Pull	2.44	2.36	2.23	2.36	2.38	3/9/01	RL
	C) Function						3-11-91	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. C6611745

DATE 3-8-91

TESTER JR

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.23	2.23	2.25	2.44	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.40	2.29	2.30	2.36	
PULL #3	2.38	2.29	2.28	2.23	
PULL #4	2.41	2.35	2.29	2.36	
PULL #5	2.34	2.31	2.33	2.38	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.51	3.47		
PULL #2	3.50	3.50		
PULL #3	3.49	3.54		
PULL #4	3.44	3.28		
PULL #5	3.49	3.27		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.48	4.49		4.46
PULL #2	4.44	4.52		4.54
PULL #3	4.47	4.53		4.49
PULL #4	4.47	4.49		4.48
PULL #5	4.51	4.50		4.47
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 16611745
8 Mar 1991

CENTROIDAL DISTANCES

0 TO	1	.236038
1 TO	2	.144669
1 TO	3	.27272
1 TO	4	.367523
1 TO	5	.385922

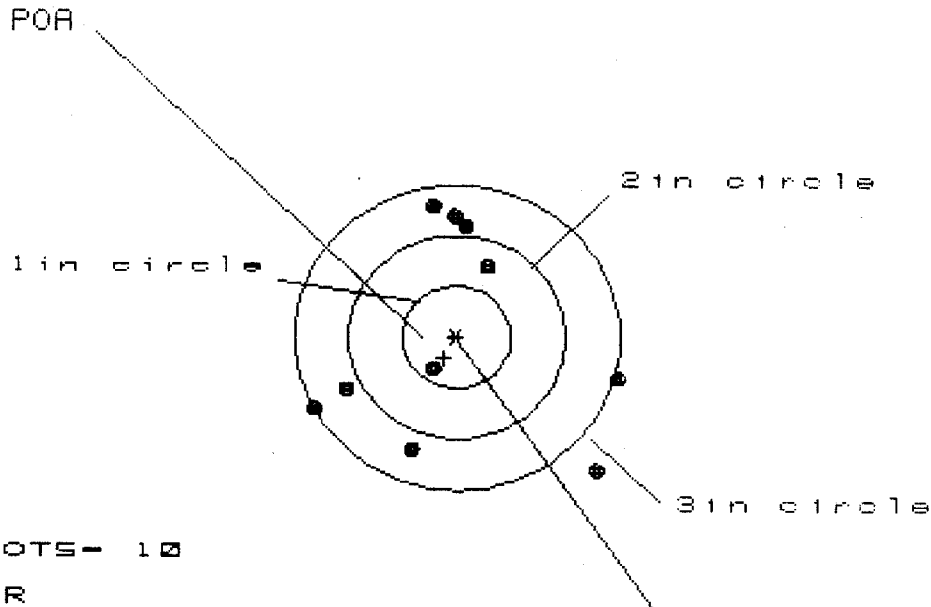
5/3 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0482
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0326
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0581893
THE AMR FOR THIS RIFLE IS: 1.003

8 Mar 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611745

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 1

2in = 2

3in = 8

HS= 2.734

VS= 2.588

GS= 2.980

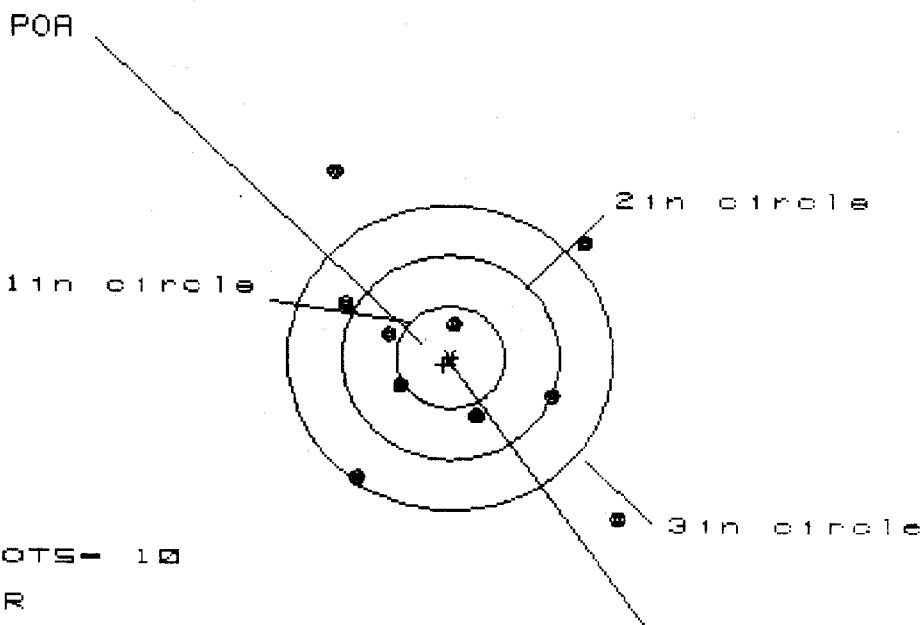
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.453	1.596	.635
MINIMUM X	-1.281	-1.138	-.939
MAXIMUM Y	1.306	1.163	1.090
MINIMUM Y	-1.282	-1.252	-1.325
CENTROID X	.117	-.026	-.225
CENTROID Y	.205	.348	.421
POA TO CENTROID in.	.236	.348	.477
MIN RADIUS	.370	.435	.508
MEAN RADIUS	1.182	1.089	1.002
MAX RADIUS	1.813	1.700	1.326
HORIZONTAL SPREAD	2.734	2.734	1.574
VERTICAL SPREAD	2.588	2.415	2.415
EXTREME SPREAD	2.980	2.743	2.424
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	2		
NUMBER IN THREE INCH CIRCLE =	8		

8 Mar 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06611745

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 7

HS= 2.576

VS= 3.442

GS= 4.299

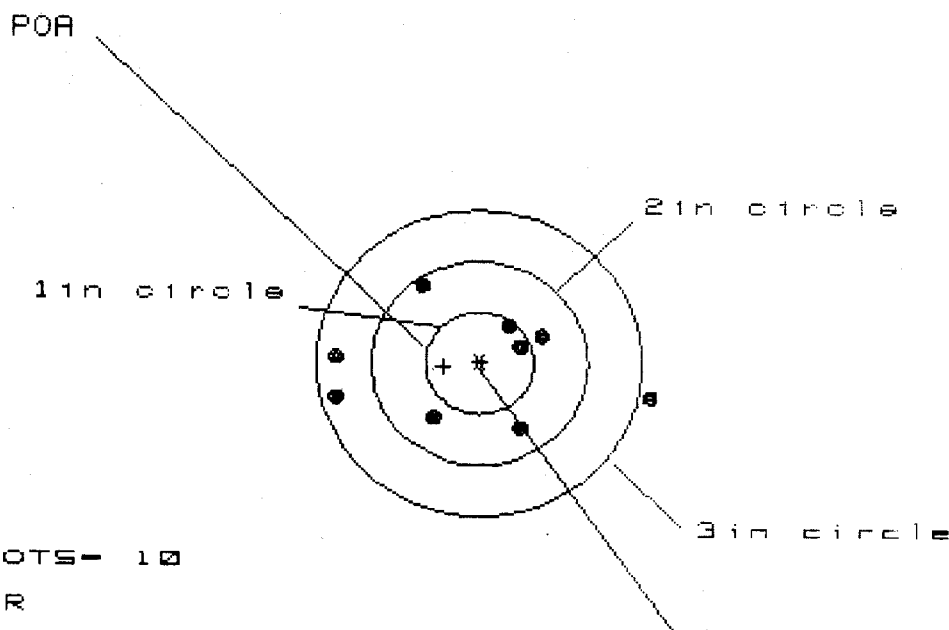
CENTROID *

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.486	1.354	1.238
MINIMUM X	:	-1.091	-.925	-.889
MAXIMUM Y	:	1.823	1.643	1.144
MINIMUM Y	:	-1.619	-1.393	-1.188
CENTROID X	:	.065	-.101	.015
CENTROID Y	:	.070	.250	.045
POA TO CENTROID in.	:	.095	.270	.047
MIN RADIUS	:	.317	.270	.356
MEAN RADIUS	:	1.155	1.018	.898
MAX RADIUS	:	2.197	1.886	1.686
HORIZONTAL SPREAD	:	2.576	2.279	2.127
VERTICAL SPREAD	:	3.442	3.036	2.332
EXTREME SPREAD	:	4.299	3.115	3.115
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	5		
NUMBER IN THREE INCH CIRCLE	=	7		

B Mar 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611745

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 3

2in = 7

3in = 9

HS= 2.825

VS= 1.352

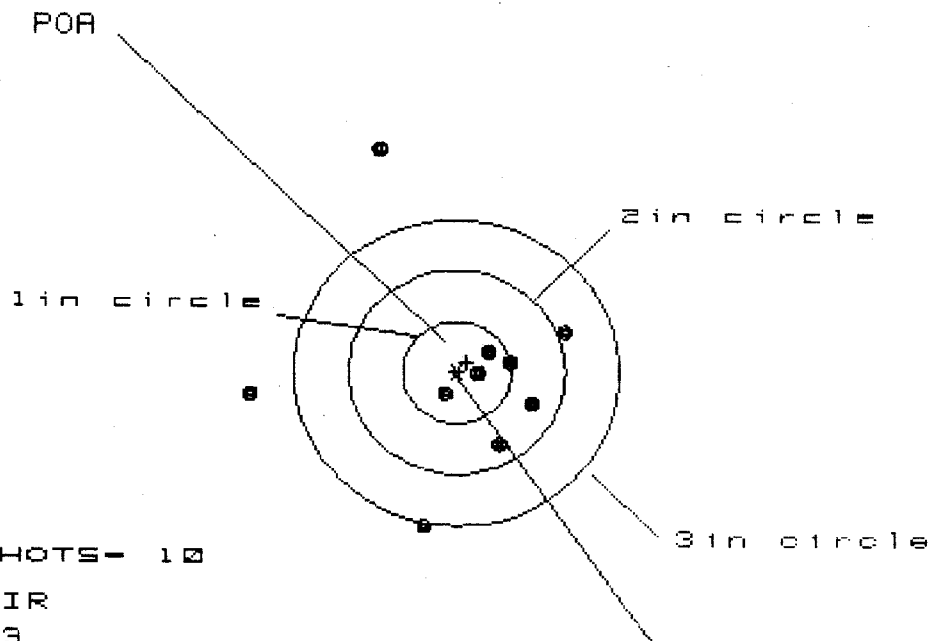
GS= 2.848

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.540	.787	.648
MINIMUM X	:	-1.285	-1.114	-1.252
MAXIMUM Y	:	.722	.684	.642
MINIMUM Y	:	-.630	-.668	-.710
CENTROID X	:	.327	.156	.295
CENTROID Y	:	.031	.069	.111
POA TO CENTROID in.	:	.328	.170	.315
MIN RADIUS	:	.396	.540	.395
MEAN RADIUS	:	.843	.779	.690
MAX RADIUS	:	1.577	1.164	1.253
HORIZONTAL SPREAD	:	2.825	1.901	1.900
VERTICAL SPREAD	:	1.352	1.352	1.352
EXTREME SPREAD	:	2.848	1.991	1.918
NUMBER IN ONE INCH CIRCLE =	:	3	7	9
NUMBER IN TWO INCH CIRCLE =	:	7	9	9
NUMBER IN THREE INCH CIRCLE =	:	9	9	9

8 Mar 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08611745

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 6

3 in = 8

HS= 2.903

VS= 3.697

GS= 3.719

CENTROID *

PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.981	.903	.653
MINIMUM X	:	-1.922	-2.000	-.623
MAXIMUM Y	:	2.234	.601	.603
MINIMUM Y	:	-1.463	-1.215	-1.213
CENTROID X	:	-.091	-.013	.236
CENTROID Y	:	-.098	-.346	-.348
POA TO CENTROID in.	:	.134	.346	.421
MIN RADIUS	:	.210	.220	.271
MEAN RADIUS	:	.965	.786	.586
MAX RADIUS	:	2.342	2.000	1.363
HORIZONTAL SPREAD	:	2.903	2.903	1.276
VERTICAL SPREAD	:	3.697	1.816	1.816
EXTREME SPREAD	:	3.719	2.961	2.219
NUMBER IN ONE INCH CIRCLE =	:	3		
NUMBER IN TWO INCH CIRCLE =	:	6		
NUMBER IN THREE INCH CIRCLE =	:	8		

B Mar 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08611745

CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 3

2in = 7

3in = 8

HS= 3.125

VS= 1.645

GS= 3.125

CENTROID *

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.257	1.049	.893
MINIMUM X	-1.868	-1.251	-1.113
MAXIMUM Y	.606	.636	.510
MINIMUM Y	-1.039	-1.009	-.726
CENTROID X	-.177	.031	.187
CENTROID Y	-.045	-.075	.052
POA TO CENTROID in.	.182	.081	.194
MIN RADIUS	.288	.157	.099
MEAN RADIUS	.869	.694	.530
MAX RADIUS	1.887	1.607	1.113
HORIZONTAL SPREAD	3.125	2.300	2.006
VERTICAL SPREAD	1.645	1.645	1.235
EXTREME SPREAD	3.125	2.669	2.017
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		9	

RECEIVING AND ESTIMATING REPORT

COMMENTS

ORDER

R 94-18040

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

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

SCOPE 90-0636

DATE RECEIVED 06/09/94 DATE OPENED 06/09/94 DATE CODE SERIAL NUMBER C6611745 NEW SERIAL NUMBER MODEL AND GRADE 700 7-62 NATO
ACCESSORIES SLING STRAP HARD CASE SCOPE MNTS SCOPE BASE

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.D.D.L

ACCOUNT NUMBER

ACCOUNT NUMBER N/C

WRITE ☐

PROM. DATE

ESTIMATED

VIA

FRT

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	D1				
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
C172 80.00
\$253.31

REPAIRMAN PROOF CLEAN TEST TARGET PATTERN

GALLERY TESTER DATE DATE DATE DATE DATE DATE

BB

✓
12-9-95

OFFICE COPY

RD625 REV. 1/94

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

M2400035256

SWS TRIGGER PULL TEST

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

SERIAL NO. C6611745
DATE 11-4-95
TESTER DA

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#	COMMENTS
PULL #1	2.31	2.22	2.33	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.27	2.25	2.36	
PULL #3	2.40	2.29	2.21	
PULL #4	2.33	2.37	2.22	
PULL #5	2.38	2.30	2.20	
TOTAL	11.69	2.29 11.35	11.32	
AVG.	2.33	2.27	2.26	

	3.00# INITIAL	3.00# AFTER 20 CYCLES	COMMENTS
PULL #1	3.02	3.33	
PULL #2	3.00	3.19	
PULL #3	3.30	3.26	
PULL #4	3.27	3.00	
PULL #5	3.34	3.25	
TOTAL	15.93	16.03	
AVG.	3.18	3.20	

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.12	4.30	4.09	
PULL #2	4.14	4.82	4.07	
PULL #3	4.25	4.20	4.16	
PULL #4	4.29	4.34	4.12	
PULL #5	4.28	4.31	4.15	
TOTAL	21.08	21.47	20.59	
AVG.	4.21	4.29	4.11	

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C 6611745

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	5	5	5			12/14	WB
	G) Safety Off Force	2	2 1/2	2 1/4			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	2.16	2.20	2.24	2.16	2.14	12/14	WB
	C) Function							
660	Pack							