

C6349219

173

MODEL 700TM M24

Model **SMS** TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

Remington 		VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.
MODEL 700™ H24		SERIAL NO. C6349219
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat & Tm. Off, Marca Registrada Marque Deposee.		ORDER NO. 5716



5716 C6349219

UPC



0 47700 25716 7

INTERCHANGEABILITY

M-24

363

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6349219

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	QUALITY AUDIT	4 12 90	RW
600	Proof		4 12 90	K
607	Check Headspace		4 12 90	K
610	Dis-assemble Gun		4 12 90	RW
612	Magnaflux Barrel Action		4-19-90	KCR
	Magnaflux Bolt		4-19-90	KCR
615	Rollmark Caliber		4-19 90	GL
617	Drill and Tap Sight Holes		4/23/90	FB
618	Polish Barrel RB		4/24/90	WB
620	Apply Coatings (Barrel Action)		4/28 90	JA
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		5/1/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/1/90	RW
	C) Inspect Ejector Hole for Chamfer		5/1/90	RW
	D) Oil Firing Pin Ass'y		5/1/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		5/16/90	GL

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			5/17/90	JH
	G) Safety Off Force	3	3	3			5/17/90	JH
	H) Trigger Pull Test & Retainability						5/16/90	JH
	I) Firing Pin Indent	.0225	.0225	.0225			5/17/90	JH
	J) Assemble Stock						5/17/90	RW
	K) Assemble Swivel Studs						6/13/90	JH
	L) Attach Front and Rear Sight Assemblies						5/17/90	RW
	M) Iron Sight Alignment						5/17/90	RW
	N) Detach Front & Rear Sights & place in numbered container						5/17/90	RW
	O) Attach Scope to Rifle						5/18/90	RW
	P) Detach & Attach Scope 20 Times						5/18/90	RW
640	Gallery Target & Test						5-18-90	AC
	A) Time						5-18-90	AC
	B) Malfunctions						5-18-90	AC
	C) Pierced Primers						5-18-90	AC
	D) Optical Clarity of Scope						5-18-90	AC
645	Inspect for Live Ammo						5-18-90	AC
655	Final Inspection							
	A) Headspace						6/13/90	JH
	B) Trigger Pull	2.43	2.59	2.82	2.76	2.85	6/13/90	GS
	C) Function						6/13/90	JH
660	Pack						6-20-90	DH

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C6349219

DATE 5/16/90

TESTER gcu

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.38	2.23	2.35	263	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.51	2.23	2.42	259	
PULL #3	2.35	2.25	2.40	282	
PULL #4	2.46	2.38	2.31	276	
PULL #5	2.24	2.31	2.30	285	
TOTAL	11.94	11.40	16.78		
AVG.	2.388	2.28	3.356		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.23	3.38		
PULL #2	3.22	3.33		
PULL #3	3.26	3.25		
PULL #4	3.22	3.27		
PULL #5	3.57	3.29		
TOTAL	16.50	16.52		
AVG.	3.3	3.304		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.34	4.34		4.22
PULL #2	4.30	4.39		4.45
PULL #3	4.27	4.31		4.39
PULL #4	4.30	4.33		4.34
PULL #5	4.38	4.30		4.35
TOTAL	21.59	21.67		21.75
AVG.	4.318	4.334		4.35

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6349219
18 May 1990

CENTROIDAL DISTANCES

0 TO	1	.499545
1 TO	2	.505653
1 TO	3	.258043
1 TO	4	.622772
1 TO	5	.681144

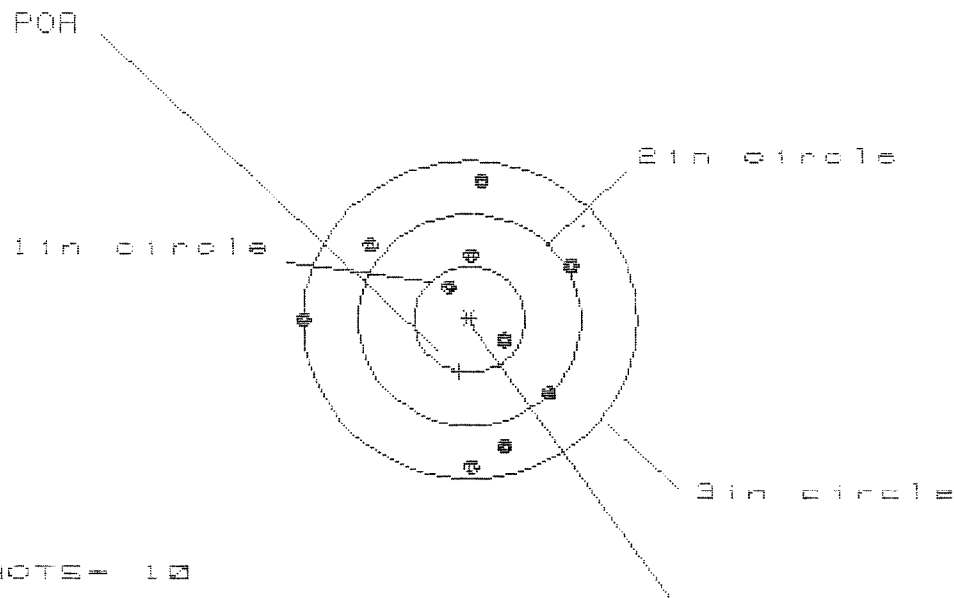
$\frac{1}{5}$
+34 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .3812
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .26
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .461425
THE AMR FOR THIS RIFLE IS: .9442

18 May 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C8349219

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1in = 2

2in = 4

3in = 10

HS = 2.398

VS = 2.652

GS = 2.653

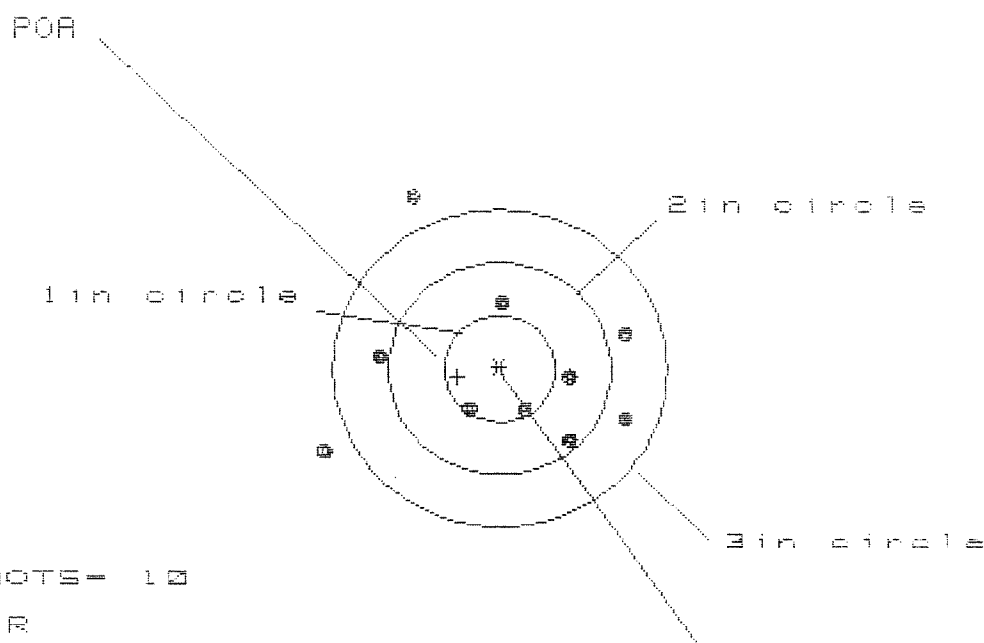
CENTROID #

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.953	.793	.780
MINIMUM X	:	-1.445	-1.010	-1.023
MAXIMUM Y	:	1.281	1.279	1.107
MINIMUM Y	:	-1.371	-1.373	-1.320
CENTROID X	:	.092	.252	.265
CENTROID Y	:	.491	.493	.665
POA TO CENTROID in.	:	.500	.554	.716
MIN RADIUS	:	.351	.258	.394
MEAN RADIUS	:	.986	.920	.848
MAX RADIUS	:	1.445	1.377	1.330
HORIZONTAL SPREAD	:	2.398	1.803	1.803
VERTICAL SPREAD	:	2.652	2.652	2.427
EXTREME SPREAD	:	2.653	2.653	2.435
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		10	

18 May 1998

FILE:/PATTERNING/CENTERFIRE_PATT/06349213

CENTERFIRE PATTERNS # 2



OF SHOTS - 10

IN CIR

1in = 2

2in = 5

3in = 8

10 = 2.666

20 = 2.346

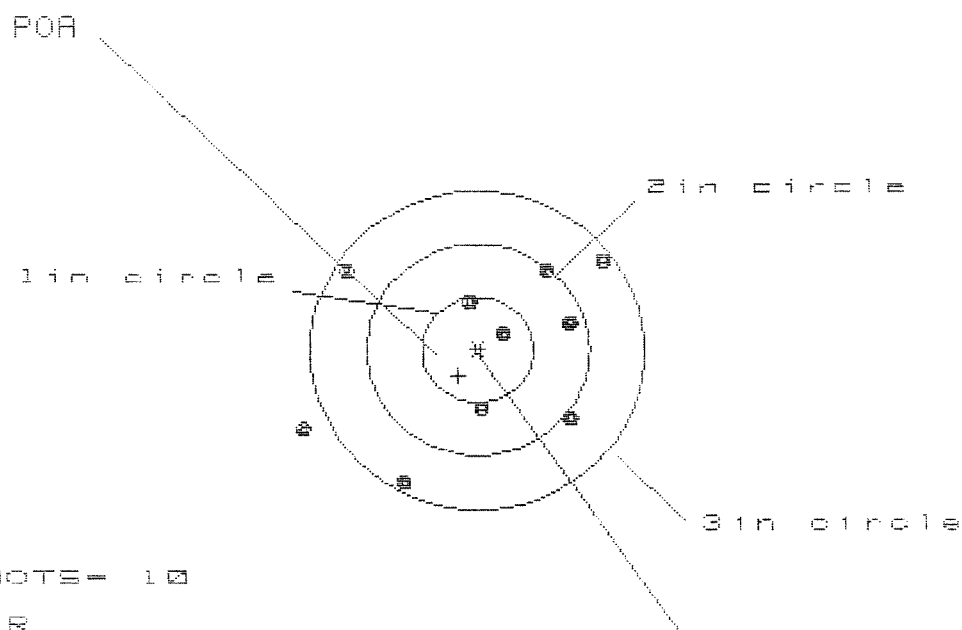
30 = 2.873

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.125	1.034	.830
MINIMUM X	:	-1.541	-1.632	-1.329
MAXIMUM Y	:	1.599	.815	.743
MINIMUM Y	:	-.747	-.569	-.616
CENTROID X	:	.378	.469	.673
CENTROID Y	:	.074	-.104	-.033
POA TO CENTROID in.	:	.385	.480	.673
MIN RADIUS	:	.451	.253	.329
MEAN RADIUS	:	1.013	.889	.759
MAX RADIUS	:	1.797	1.728	1.359
HORIZONTAL SPREAD	:	2.666	2.666	2.159
VERTICAL SPREAD	:	2.346	1.384	1.359
EXTREME SPREAD	:	2.873	2.858	2.266
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

18 May 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C8349213

CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1 in = 2

2 in = 5

3 in = 9

HS = 2.552

VS = 2.075

GS = 3.099

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.092	.919	.807
MINIMUM X	:	-1.560	-1.362	-1.474
MAXIMUM Y	:	.868	.787	.626
MINIMUM Y	:	-1.207	-1.288	-1.886
CENTROID X	:	.173	.346	.458
CENTROID Y	:	.246	.327	.488
POA TO CENTROID in.	:	.300	.476	.669
MIN RADIUS	:	.224	.035	.161
MEAN RADIUS	:	1.008	.881	.782
MAX RADIUS	:	1.725	1.567	1.546
HORIZONTAL SPREAD	:	2.652	2.281	2.281
VERTICAL SPREAD	:	2.075	2.075	1.512
EXTREME SPREAD	:	3.099	2.754	2.396
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

15 May 1938

FILE:/PATTERNING/CENTERFIRE_PATT/08349213

CENTERFIRE PATTERNS

4

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS- 10

IN CIR

1 in = 1

2 in = 5

3 in = 10

HS= 2.834

VS= 1.955

GS= 2.835

PATTERN #

4

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.439

1.164

1.056

MINIMUM X

-1.395

-1.235

-1.343

MAXIMUM Y

.940

.948

.823

MINIMUM Y

-1.015

-1.007

-1.027

CENTROID X

.490

.330

.438

CENTROID Y

.012

.004

.129

POA TO CENTROID in.

.490

.330

.456

MIN RADIUS

.417

.436

.365

MEAN RADIUS

1.018

.964

.903

MAX RADIUS

1.441

1.402

1.349

HORIZONTAL SPREAD

2.834

2.399

2.399

VERTICAL SPREAD

1.955

1.955

1.850

EXTREME SPREAD

2.835

2.702

2.524

NUMBER IN ONE INCH CIRCLE =

1

NUMBER IN TWO INCH CIRCLE =

5

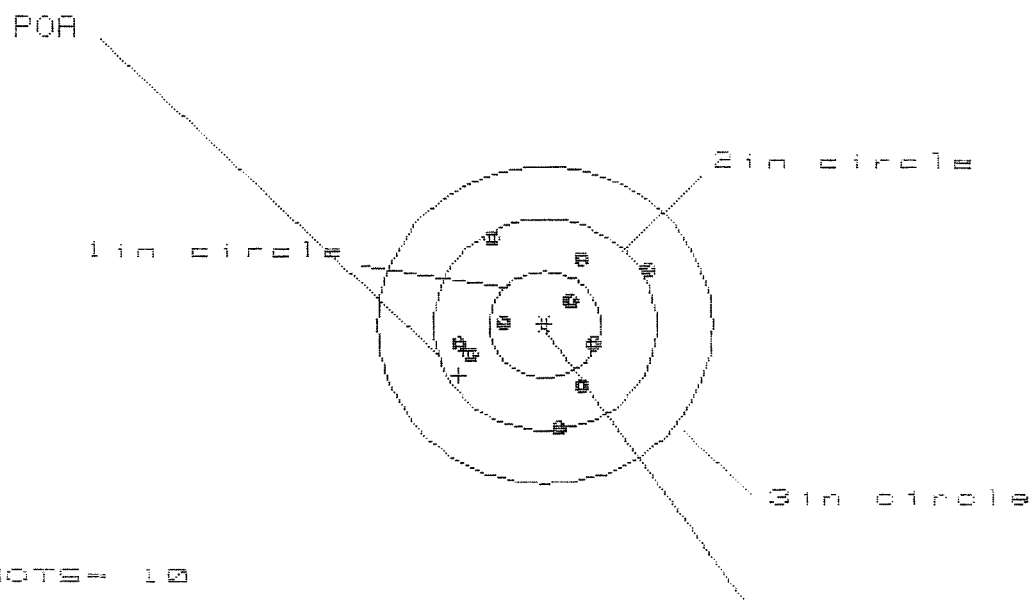
NUMBER IN THREE INCH CIRCLE =

10

18 May 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6348219

CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1 in = 3

2 in = 8

3 in = 10

HS= 1.675

VS= 1.816

GS= 1.911

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.924	.532	.483
MINIMUM X	:	-.751	-.648	-.697
MAXIMUM Y	:	.872	.929	.812
MINIMUM Y	:	-.944	-.887	-.771
CENTROID X	:	.773	.670	.719
CENTROID Y	:	.477	.420	.304
POA TO CENTROID in.	:	.908	.791	.780
MIN RADIUS	:	.284	.286	.368
MEAN RADIUS	:	.696	.649	.597
MAX RADIUS	:	1.059	1.008	.892
HORIZONTAL SPREAD	:	1.675	1.180	1.180
VERTICAL SPREAD	:	1.816	1.816	1.583
EXTREME SPREAD	:	1.911	1.911	1.598
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	

INTERCHANGEABILITY

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06349219
18 Jun 1990

CENTROIDAL DISTANCES

0 TO 1	.455593
1 TO 2	.584706
1 TO 3	.13336
1 TO 4	.188513
1 TO 5	.563876

gtd <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .2048
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.11
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .232472
THE AMR FOR THIS RIFLE IS: .9864

18 Jun 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C8348219.1

CENTERFIRE PATTERNS

1

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS= 10

IN CIR

1 in = 4

2 in = 6

3 in = 9

HS= 2.776

VS= 1.744

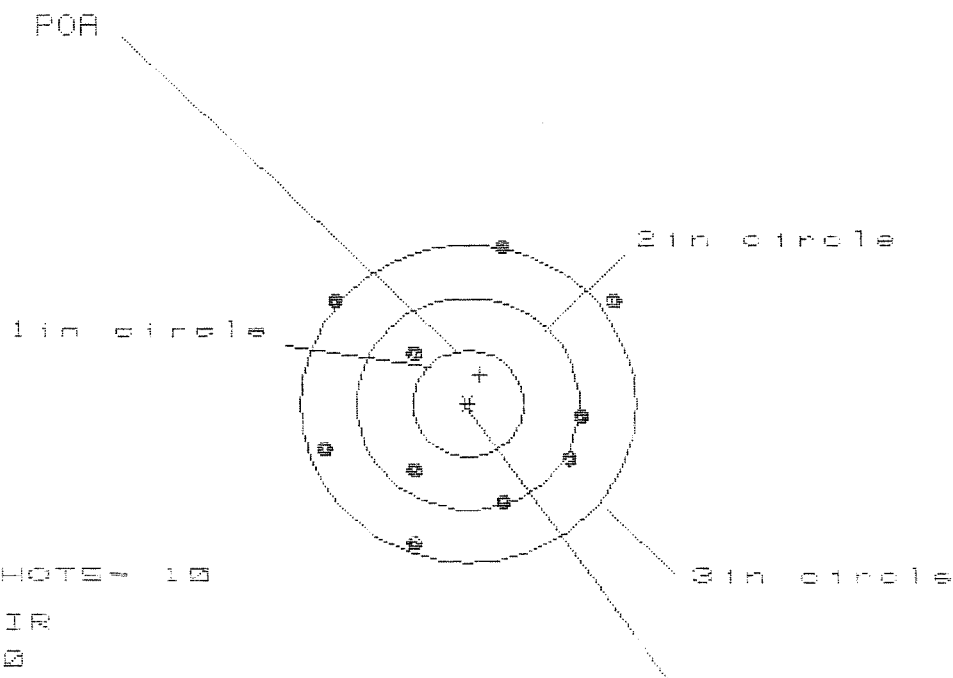
GS= 2.870

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.291	.942	.775
MINIMUM X	-1.485	-1.342	-.951
MAXIMUM Y	.797	.488	.508
MINIMUM Y	-.947	-.858	-.838
CENTROID X	.446	.303	.470
CENTROID Y	-.093	-.182	-.262
POA TO CENTROID in.	.456	.353	.512
MIN RADIUS	.143	.294	.203
MEAN RADIUS	.766	.732	.601
MAX RADIUS	1.517	1.351	1.268
HORIZONTAL SPREAD	2.776	2.284	1.726
VERTICAL SPREAD	1.744	1.346	1.346
EXTREME SPREAD	2.870	2.288	1.935
NUMBER IN ONE INCH CIRCLE =	4		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	9		

18 Jun 1998

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 0

2 in = 2

3 in = 8

HS= 2.588

VS= 2.768

GS= 2.842

CENTROID *

PATTERN #	2	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.350	1.187	1.052
MINIMUM X	-1.249	-1.099	-1.234
MAXIMUM Y	1.467	1.573	1.713
MINIMUM Y	-1.301	-1.195	-1.055
CENTROID X	-1.109	-1.259	-1.124
CENTROID Y	-1.277	-1.383	-1.523
POA TO CENTROID in.	.298	.462	.537
MIN RADIUS	.634	.611	.616
MEAN RADIUS	1.195	1.122	1.047
MAX RADIUS	1.654	1.639	1.743
HORIZONTAL SPREAD	2.599	2.286	2.286
VERTICAL SPREAD	2.768	2.768	2.768
EXTREME SPREAD	2.942	2.876	2.876
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	2		
NUMBER IN THREE INCH CIRCLE =	8		

18 Jun 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6349219.1

CENTERFIRE PATTERNS

3

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS= 10

IN CIR

1in = 1

2in = 5

3in = 8

HE= 2.884

VE= 2.404

GE= 2.974

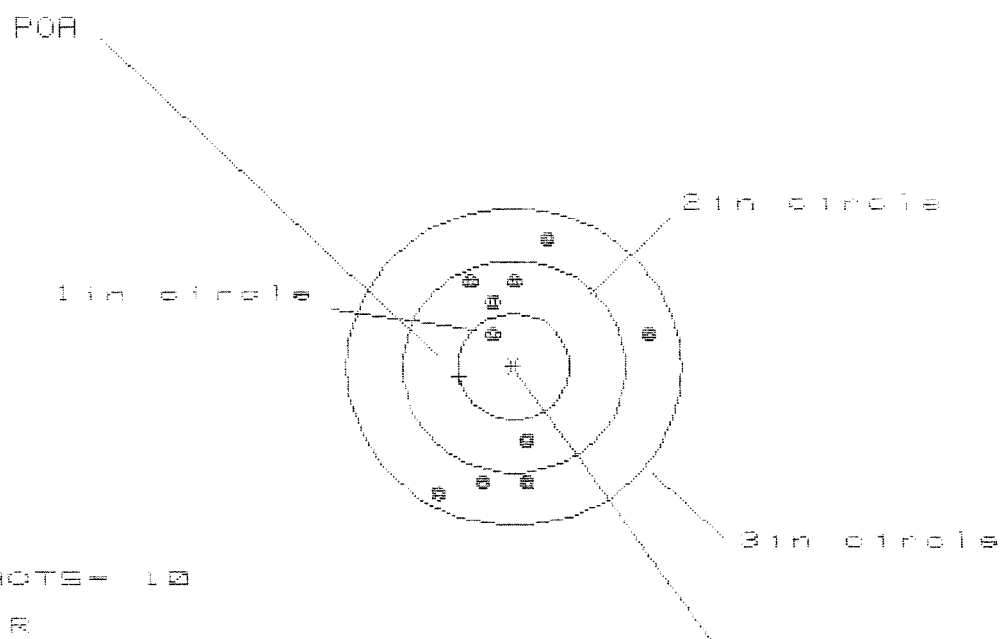
PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.528	1.128	1.076
MINIMUM X	:	-1.356	-1.186	-1.238
MAXIMUM Y	:	1.405	1.381	.655
MINIMUM Y	:	-.999	-1.023	-.850
CENTROID X	:	.314	.144	.196
CENTROID Y	:	-.112	-.087	-.260
POA TO CENTROID in.	:	.333	.168	.326
MIN RADIUS	:	.469	.390	.535
MEAN RADIUS	:	.952	.866	.795
MAX RADIUS	:	1.544	1.443	1.401
HORIZONTAL SPREAD	:	2.884	2.314	2.314
VERTICAL SPREAD	:	2.404	2.404	1.505
EXTREME SPREAD	:	2.974	2.658	2.636
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

18 Jun 1990

FILE:/PATTERNING/CENTERFIRE_PATT/C8849219.1

CENTERFIRE PATTERNS

4



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 5

3 in = 10

HS = 1.040

VS = 2.451

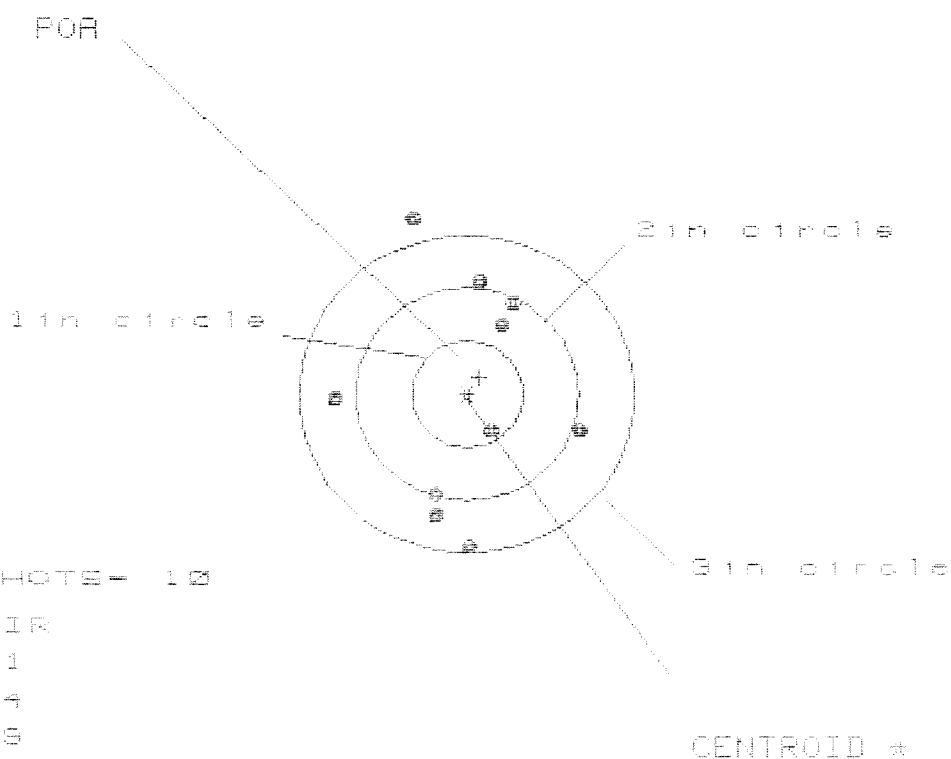
GS = 2.674

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.212	1.131	1.163
MINIMUM X	:	-.733	-.471	-.439
MAXIMUM Y	:	1.241	1.106	.822
MINIMUM Y	:	-1.210	-1.272	-1.133
CENTROID X	:	.487	.569	.537
CENTROID Y	:	.091	.226	.087
POA TO CENTROID in.	:	.496	.612	.544
MIN RADIUS	:	.383	.340	.414
MEAN RADIUS	:	.957	.885	.862
MAX RADIUS	:	1.415	1.320	1.206
HORIZONTAL SPREAD	:	1.946	1.602	1.602
VERTICAL SPREAD	:	2.451	2.378	1.955
EXTREME SPREAD	:	2.674	2.454	2.078
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		10	

18 Jun 1988

FILE:/PATTERNING/CENTERFIRE_PATT/06345219.1

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 1

2in = 4

3in = 9

HS= 2.123

VS= 3.058

GS= 3.101

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.974	.924	.926
MINIMUM X	:	-1.149	-1.199	-1.197
MAXIMUM Y	:	1.638	1.277	1.123
MINIMUM Y	:	-1.420	-1.238	-1.152
CENTROID X	:	-.114	-.064	-.066
CENTROID Y	:	-.159	-.341	-.187
POR TO CENTROID in.	:	.196	.347	.198
MIN RADIUS	:	.360	.194	.310
MEAN RADIUS	:	1.062	.966	.931
MAX RADIUS	:	1.699	1.281	1.203
HORIZONTAL SPREAD	:	2.123	2.123	2.123
VERTICAL SPREAD	:	3.058	2.515	2.275
EXTREME SPREAD	:	3.101	2.516	2.317
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		9	

RECEIVING AND ESTIMATING REPORT

COMMENTS

ORDER

R 94-18174

INITIAL CUSTOMER ORDER NO.

FDC

DAAA09-92-C-0834

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

SCOPE 90-0262

DATE RECEIVED

06/10/94

DATE OPENED

06/10/94

DATE CODE

SERIAL NUMBER

C6349219

NEW SERIAL NUMBER

MODEL AND GRADE

700 7-62

NATO

ACCESSORIES

SLING STRAP

HARD CASE

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
ANNISTON

AL

36201-5025

CUST NO: 098397 CJO.DL

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

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

ARTS

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

M2400110418

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6349219

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						
	G) Safety Off Force						
	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	2.80					
	C) Function						
660	Pack						

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C6349219

DATE 8-28-95

TESTER DAB

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.64	2.68	2.51		MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.66	2.39	2.48		
PULL #3	2.70	2.33	2.51		
PULL #4	2.74	2.38	2.28		
PULL #5	2.80	2.15	2.25		
TOTAL	13.54	11.93	9.78		
AVG.	2.70	2.38	1.95		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.17	3.24		
PULL #2	3.00	3.68		
PULL #3	3.15	3.25		
PULL #4	3.20	3.71		
PULL #5	3.20	3.27		
TOTAL	15.72	17.15		
AVG.	3.14	3.43		

	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	4.00	
PULL #2	4.20	4.01	4.13	
PULL #3	4.20	4.00	4.18	
PULL #4	4.09	4.11	4	
PULL #5	4.06	4.00	4	
TOTAL	20.67	20.42	20.13	
AVG.	4.13	4.08	4.02	

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C 6349219

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 1/2	6 1/2	6 1/2			12/6	WB
	G) Safety Off Force	3 1/2	3 1/2	3 1/2			12/6	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	2.47	2.62	2.62	2.64	2.51	12/6	WB
	C) Function							
660	Pack							