C6522215

MODEL 700™ M24

Model SWS ™

Action

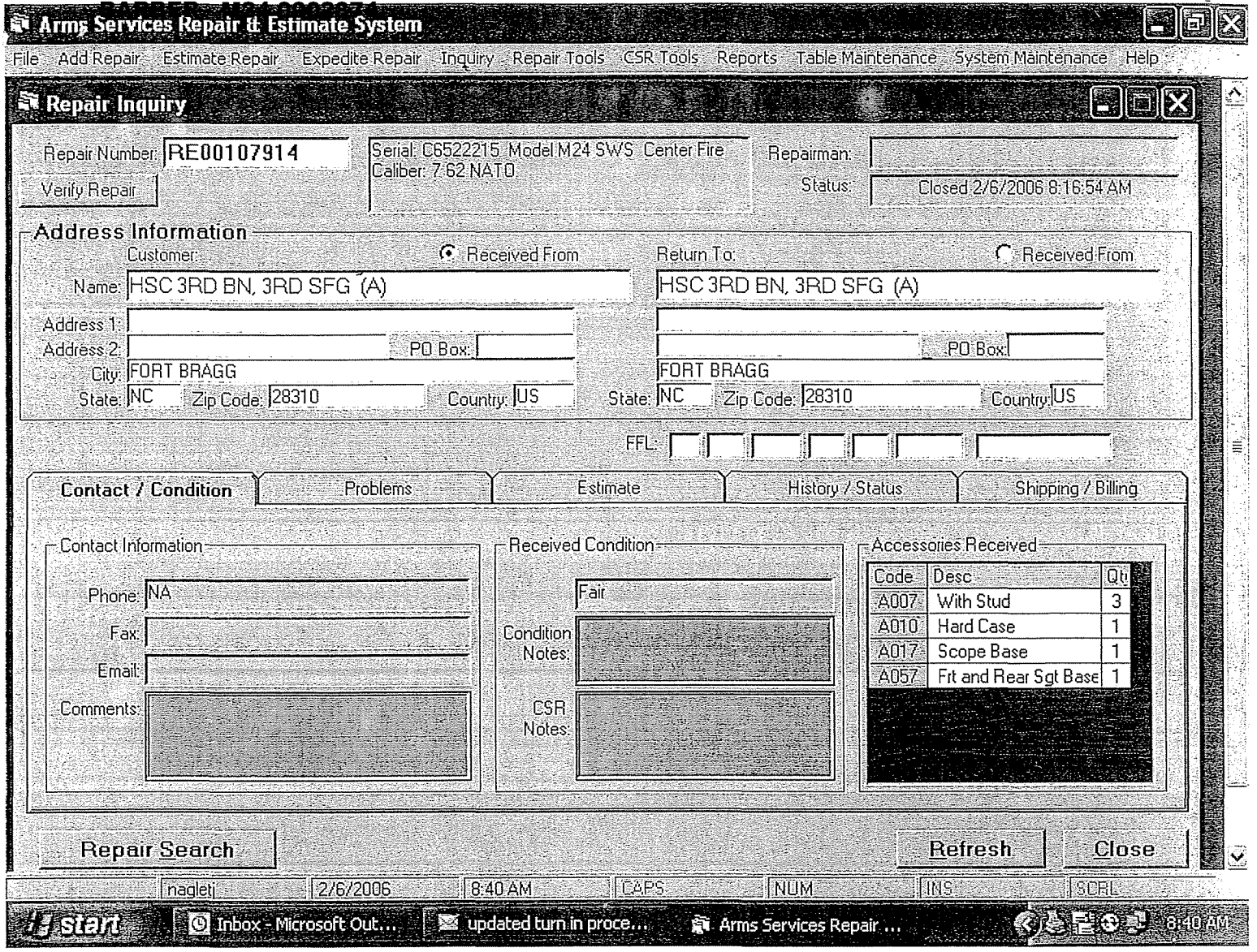
Barrel Length

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: RE00107914
Verify Repair
Serial: C6522215 Model: M24 SWS Center Fire
Caliber: 7.62 NATO
Repairman:
Status: Closed 2/6/2006 8:16:54 AM
Address Information
Customer:
Received From
Name: HSC 3RD BN, 3RD SFG (A)
Address 1:
Address 2:
PO Box:
City: FORT BRAGG
State: NC Zip Code: 28310 Country: US
Return To:
Received From
HSC 3RD BN, 3RD SFG (A)
PO Box:
FORT BRAGG
State: NC Zip Code: 28310 Country: US
FFL:
Contact / Condition
Problems
Estimate
History / Status
Shipping / Billing
Contact Information
Phone: NA
Fax:
Email:
Comments:
Received Condition
Fair
Condition Notes:
CSR Notes:
Accessories Received
Code Desc Qu
A007 With Stud 3
A010 Hard Case 1
A017 Scope Base 1
A057 Frt and Rear Sgt Base 1
Repair Search
Refresh
Close
naglelj
2/6/2006
8:40 AM
CAPS
NUM
INS
SCRL
start
Inbox - Microsoft Out...
updated turn in proce...
Arms Services Repair ...
8:40 AM


Serial Number:
C6522215
Model: M24 SWS
RE00107914

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFOMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6522215.__0
FILE DATE AND TIME: 02/15/2006 05:12

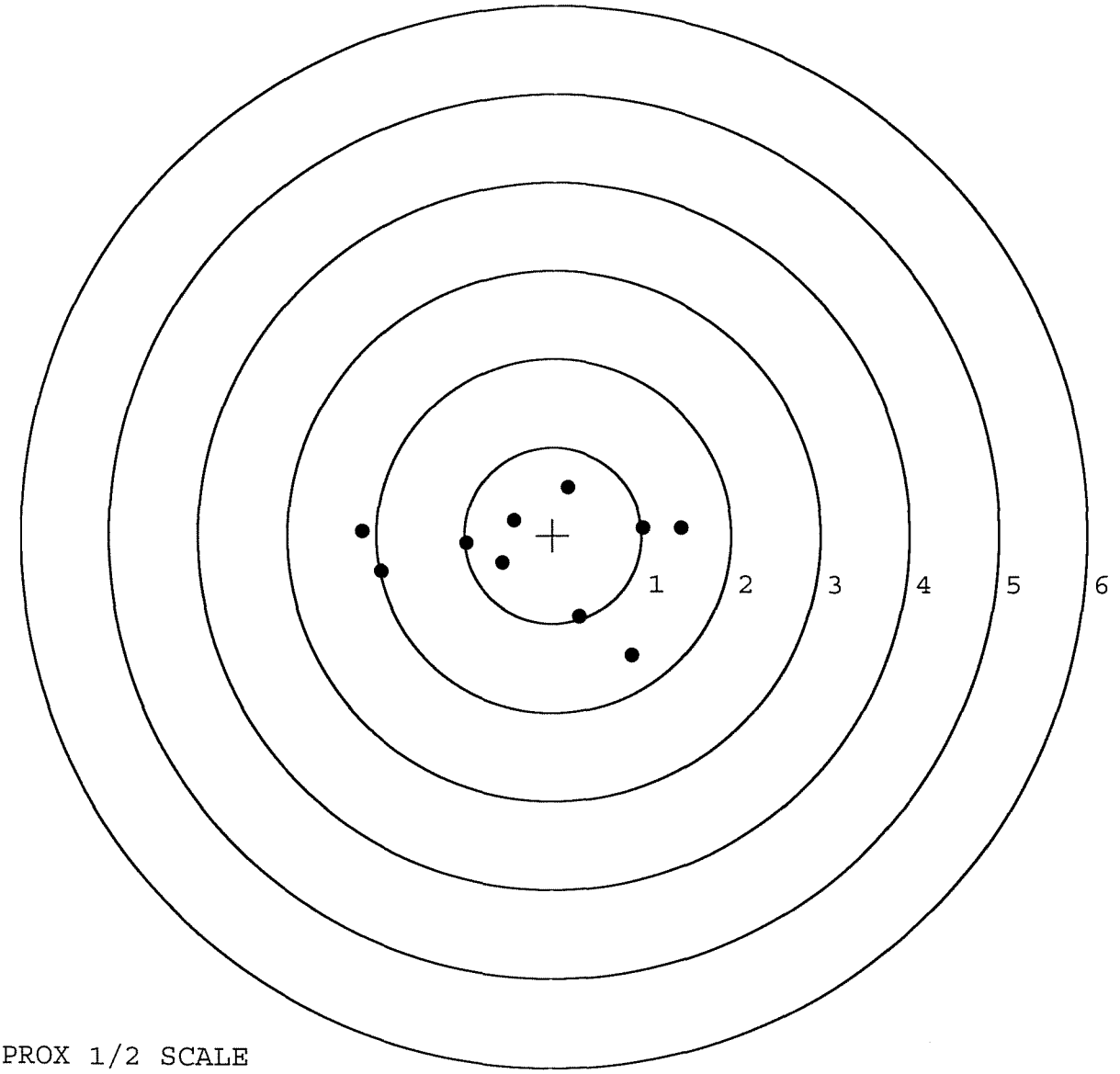
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.081
The Average Y Centroid of the Five Target Set:	-0.047
The Average Point of Impact of the Five Target Set:	0.093
The Average Mean Radius of the Five Target Set:	0.837
The Distance from POA to Centroid Target #1:	0.314
The Distance from Centroid Target #2 to Centroid Target #1:	0.195
The Distance from Centroid Target #3 to Centroid Target #1:	0.393
The Distance from Centroid Target #4 to Centroid Target #1:	0.215
The Distance from Centroid Target #5 to Centroid Target #1:	0.379

SERIAL NUMBER: C6522215.__0
TARGET NUMBER: 1
FILE DATE: 02/15/2006
FILE TIME: 05:12

X CENTROID:	-0.225
Y CENTROID:	-0.218
POA TO CENTROID:	0.314
HORZ SPREAD:	3.597
VERT SPREAD:	1.902
GROUP SPREAD:	3.597
MIN RADIUS:	0.358
MAX RADIUS:	1.948
MEAN RADIUS:	1.156
# IN 1 IN DIAMETER:	2
# IN 2 IN DIAMETER:	5
# in 3 IN DIAMETER:	6

POINT#	X	Y
1:	0.896	-1.358
2:	0.309	-0.933
3:	1.442	0.093
4:	1.014	0.088
5:	0.169	0.544
6:	-0.437	0.167
7:	-0.569	-0.318
8:	-0.979	-0.094
9:	-1.943	-0.418
10:	-2.155	0.046

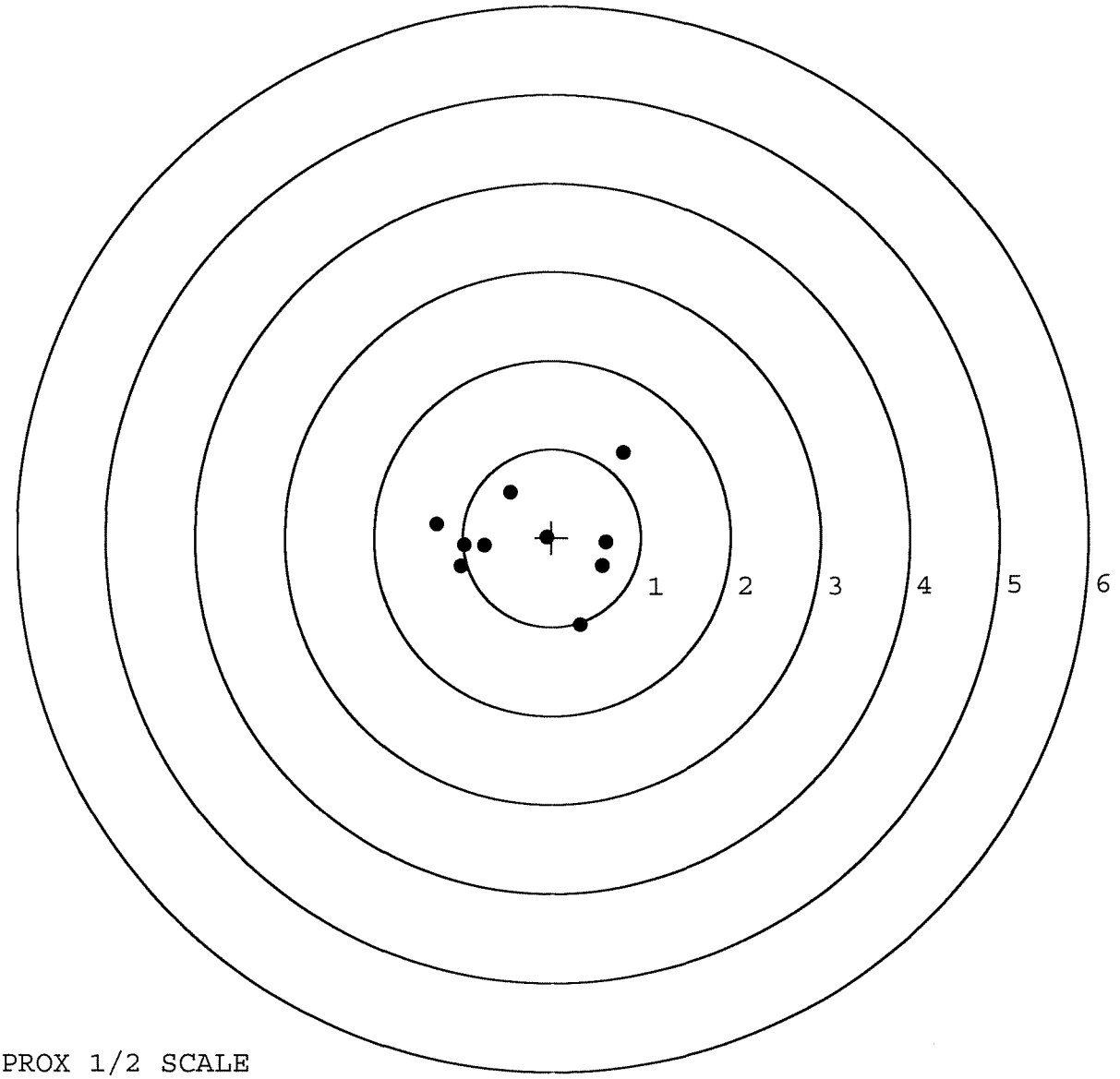


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6522215.__0
TARGET NUMBER: 2
FILE DATE: 02/15/2006
FILE TIME: 05:12

X CENTROID:	-0.226
Y CENTROID:	-0.024
POA TO CENTROID:	0.227
HORZ SPREAD:	2.112
VERT SPREAD:	1.943
GROUP SPREAD:	2.259
MIN RADIUS:	0.168
MAX RADIUS:	1.430
MEAN RADIUS:	0.821
# IN 1 IN DIAMETER:	1
# IN 2 IN DIAMETER:	7
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	0.326	-0.984
2:	0.570	-0.325
3:	0.612	-0.055
4:	0.813	0.959
5:	-0.060	0.001
6:	-0.459	0.511
7:	-0.755	-0.093
8:	-0.984	-0.084
9:	-1.023	-0.325
10:	-1.299	0.157

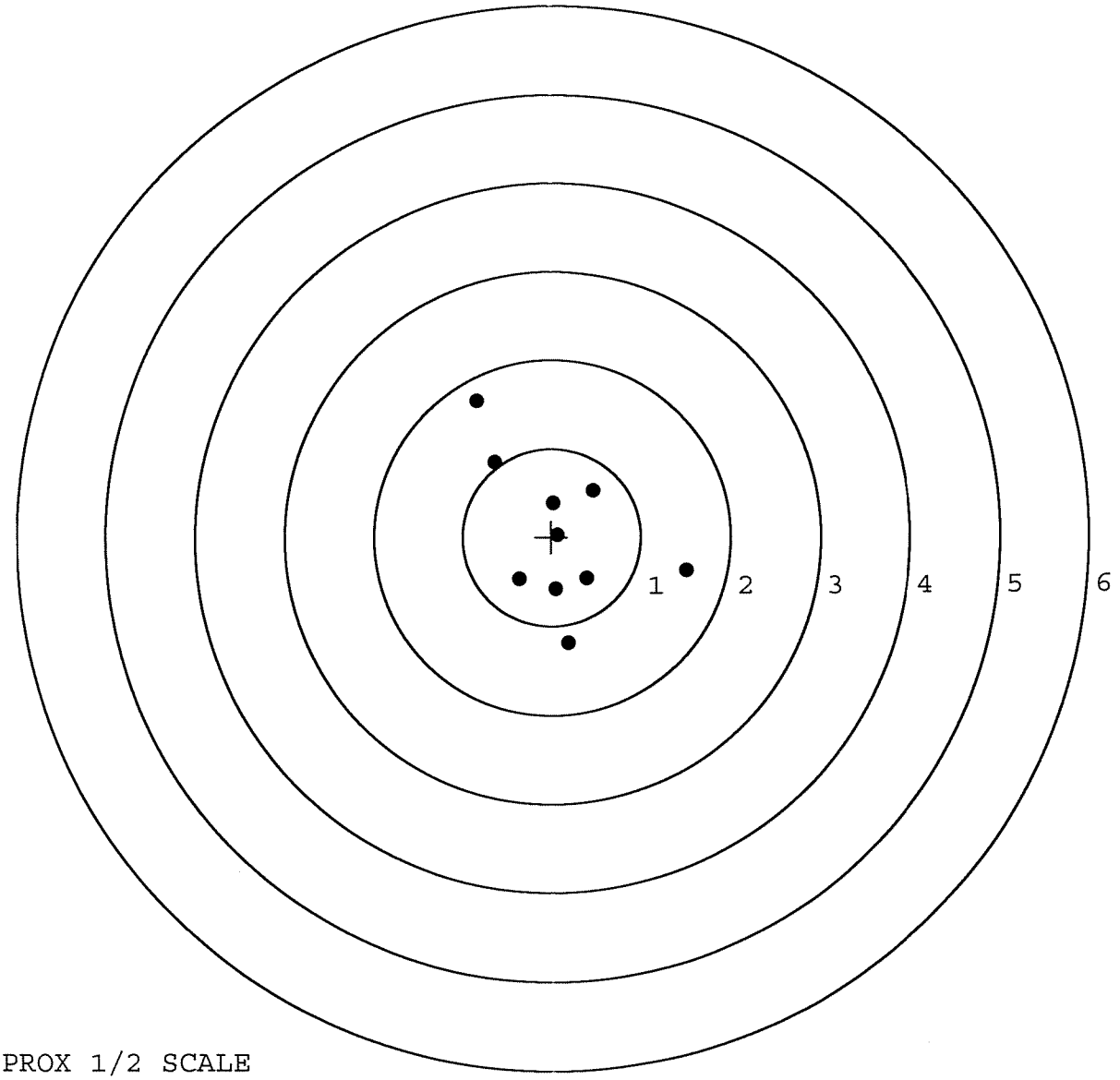


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6522215.__0
TARGET NUMBER: 3
FILE DATE: 02/15/2006
FILE TIME: 05:12

X CENTROID:	0.087
Y CENTROID:	0.021
POA TO CENTROID:	0.089
HORZ SPREAD:	2.337
VERT SPREAD:	2.739
GROUP SPREAD:	3.028
MIN RADIUS:	0.018
MAX RADIUS:	1.782
MEAN RADIUS:	0.845
# IN 1 IN DIAMETER:	2
# IN 2 IN DIAMETER:	6
# in 3 IN DIAMETER:	9

POINT#	X	Y
1:	1.500	-0.381
2:	0.189	-1.195
3:	0.400	-0.471
4:	0.053	-0.589
5:	-0.362	-0.480
6:	0.069	0.024
7:	0.024	0.383
8:	0.470	0.522
9:	-0.638	0.848
10:	-0.837	1.544

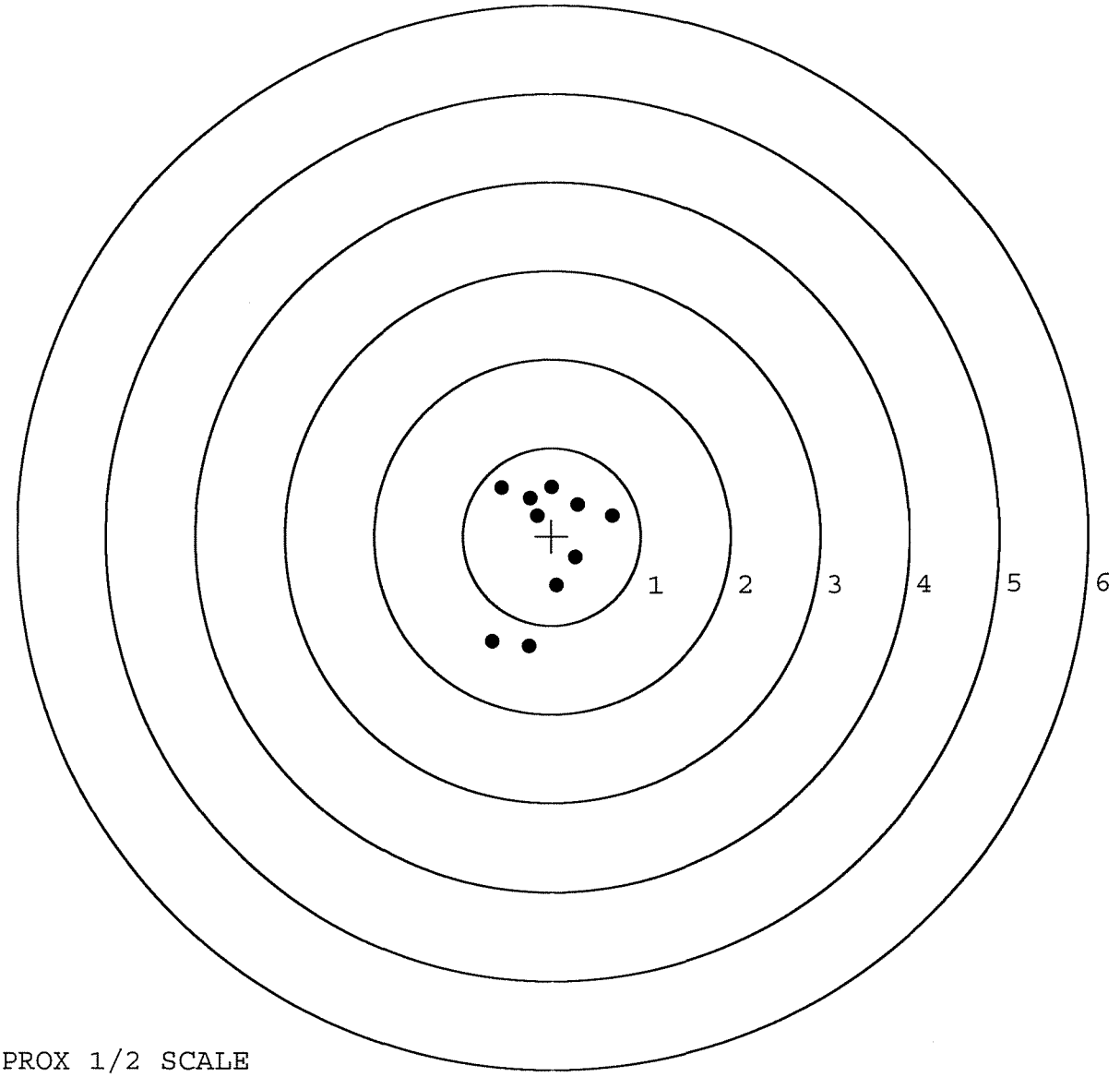


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6522215.__0
TARGET NUMBER: 4
FILE DATE: 02/15/2006
FILE TIME: 05:12

X CENTROID:	-0.056
Y CENTROID:	-0.087
POA TO CENTROID:	0.103
HORZ SPREAD:	1.354
VERT SPREAD:	1.796
GROUP SPREAD:	1.958
MIN RADIUS:	0.334
MAX RADIUS:	1.259
MEAN RADIUS:	0.699
# IN 1 IN DIAMETER:	3
# IN 2 IN DIAMETER:	8
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	-0.256	-1.238
2:	-0.671	-1.185
3:	0.059	-0.554
4:	0.272	-0.246
5:	0.683	0.230
6:	0.303	0.357
7:	0.008	0.558
8:	-0.160	0.231
9:	-0.556	0.547
10:	-0.238	0.433

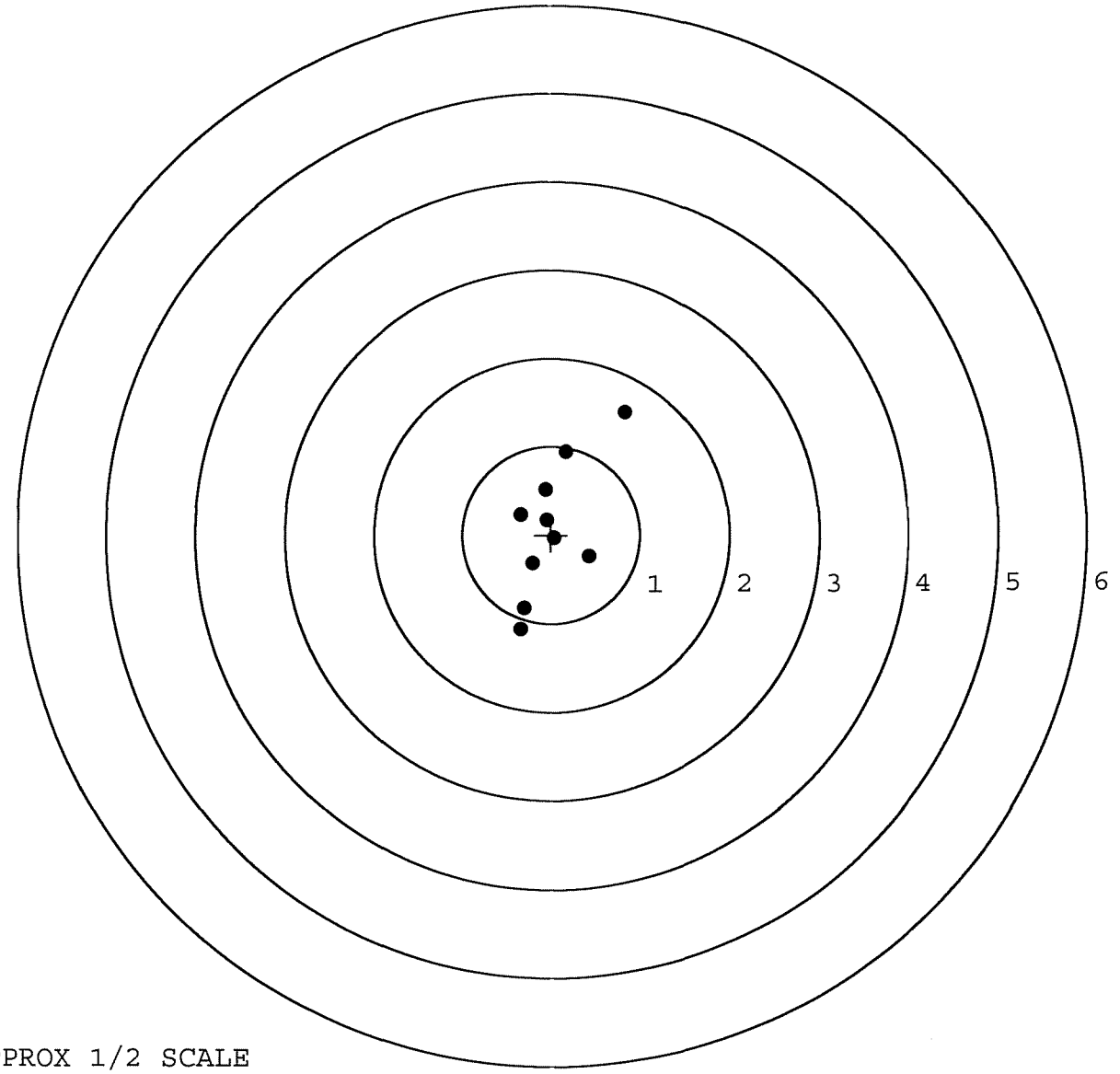


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6522215.__0
TARGET NUMBER: 5
FILE DATE: 02/15/2006
FILE TIME: 05:12

X CENTROID:	0.017
Y CENTROID:	0.073
POA TO CENTROID:	0.075
HORZ SPREAD:	1.176
VERT SPREAD:	2.453
GROUP SPREAD:	2.720
MIN RADIUS:	0.111
MAX RADIUS:	1.544
MEAN RADIUS:	0.662
# IN 1 IN DIAMETER:	5
# IN 2 IN DIAMETER:	8
# in 3 IN DIAMETER:	9

POINT#	X	Y
1:	0.834	1.383
2:	0.170	0.935
3:	-0.054	0.513
4:	-0.342	0.232
5:	-0.051	0.167
6:	0.035	-0.037
7:	0.432	-0.243
8:	-0.208	-0.321
9:	-0.303	-0.829
10:	-0.341	-1.070

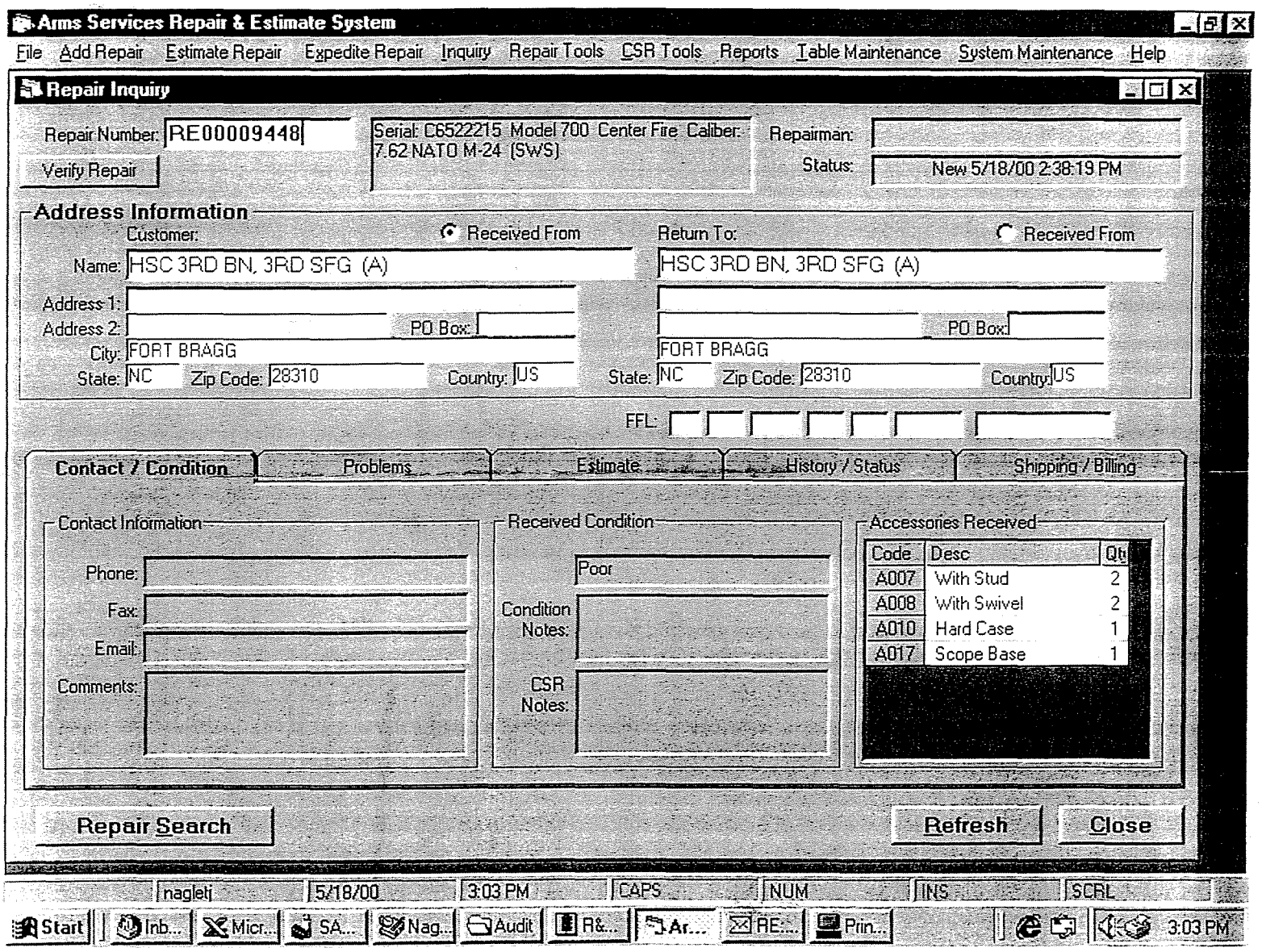


TARGET APPROX 1/2 SCALE

M-24 INSPECTION CHECKLIST
CONTRACT #: DAAE-20-02-C-0149

R & E NUMBER	107914			
SERIAL NUMBER	C0652215			
LOG-IN DATE	2-6-06			

OPERATION #	OPERATION NAME		DATE	INITIAL
500	DIS-ASSEMBLE GUN		2-6-06	RTC
505	RE-BARREL		2-8-06	RTC
560	ASSEMBLE		2-8-06	RTC
600	PROOF	MAGNA-FLUX INSPECTED FEB 9 2006	2-8-06	RTC
605	CHECK HEADSPACE		2-8-06	RTC
610	DIS-ASSEMBLE GUN		2-8-06	RTC
612	MAGNAFLUX	OPERATOR	2/9/06	
510	DRILL AND TAP		2-9-06	TRW
615	ROLLMARK CALIBER		2-10-06	CW
618	ROTO-BLAST		2-10	LB
620	APPLY COATINGS		2/14/06	
625	FINAL ASSEMBLY		2-14-06	
640	FUNCTION TEST AND	PASS FAIL	2-15-06 TRW	TRW
650	TARGET	PASS FAIL		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION N/A		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION	2/15/06	RC
670	FINAL INSPECTION		2-15-06	AC
	A) HEADSPACE	PASS FAIL	2-15-06	AC
	B) TRIGGER PULL (+/- .5 LBS, MIN 2.50 LBS, MAX 4.0 LBS)			N/A
680	F) SAFETY ON FORCE (2 LBS MIN, 10 LBS)	4 lbs 4 lbs 4 lbs		AC
	G) SAFETY OFF FORCE (2 LBS MIN)	4 lbs 4 lbs 4 lbs		AC
	I) FIRING PIN INDENT (.020)	.023 .023 .023		AC
690	PACK		2/24/06	AC



Serial Number: C6522215

Model: 700

96003 - BBL

RE00009448

Remington Test Lab, Ilion, N.Y.

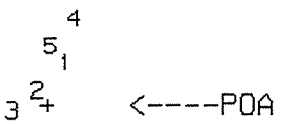
Centroidal distance calculations for Rifle # c6522215
8 Sep 2000

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0062
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .2552
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .255275

THE AMR FOR THIS RIFLE IS: .964

CENTROIDAL DISTANCES

0	TO	1	.294593
1	TO	2	.251024
1	TO	3	.462871
1	TO	4	.289171
1	TO	5	.139603

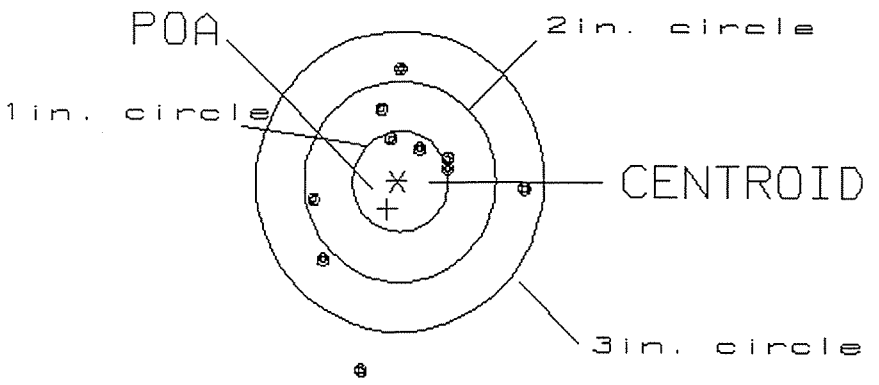


REMINGTON CENTERFIRE ACCURACY TEST REMINGTON TEST LAB, ILION, N.Y.

PATTERN #:	1
POA TO CENTROID:	.294
MIN RADIUS :	.382
MEAN RADIUS :	.909
MAX RADIUS :	1.951
CENTROID X :	.103
CENTROID Y :	.276

8 Sep 2000 FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/cc6522215

CENTERFIRE PATTERN # 1



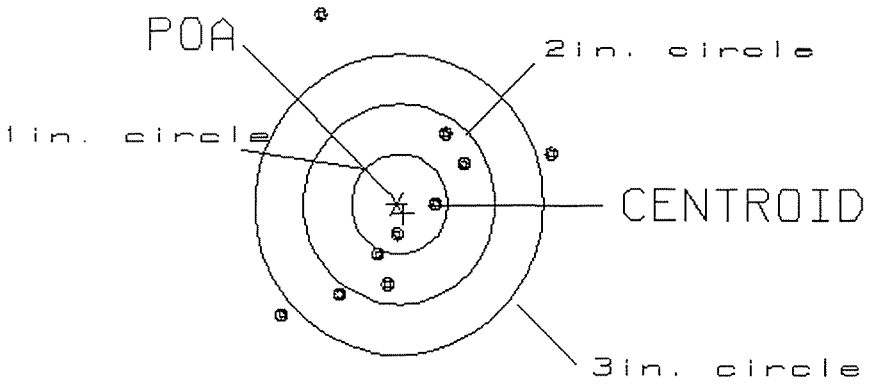
# OF SHOTS= 10	# IN CIRCLE
HS= 2.24	3
VS= 3.07	6
GS= 3.10	9

REMINGTON CENTERFIRE ACCURACY TEST REMINGTON TEST LAB, ILION, N.Y.

PATTERN #:		2
POA TO CENTROID:		.123
MIN RADIUS	:	.340
MEAN RADIUS	:	1.009
MAX RADIUS	:	2.064
CENTROID X	:	-.074
CENTROID Y	:	.098

8 Sep 2000 FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/cc6522215

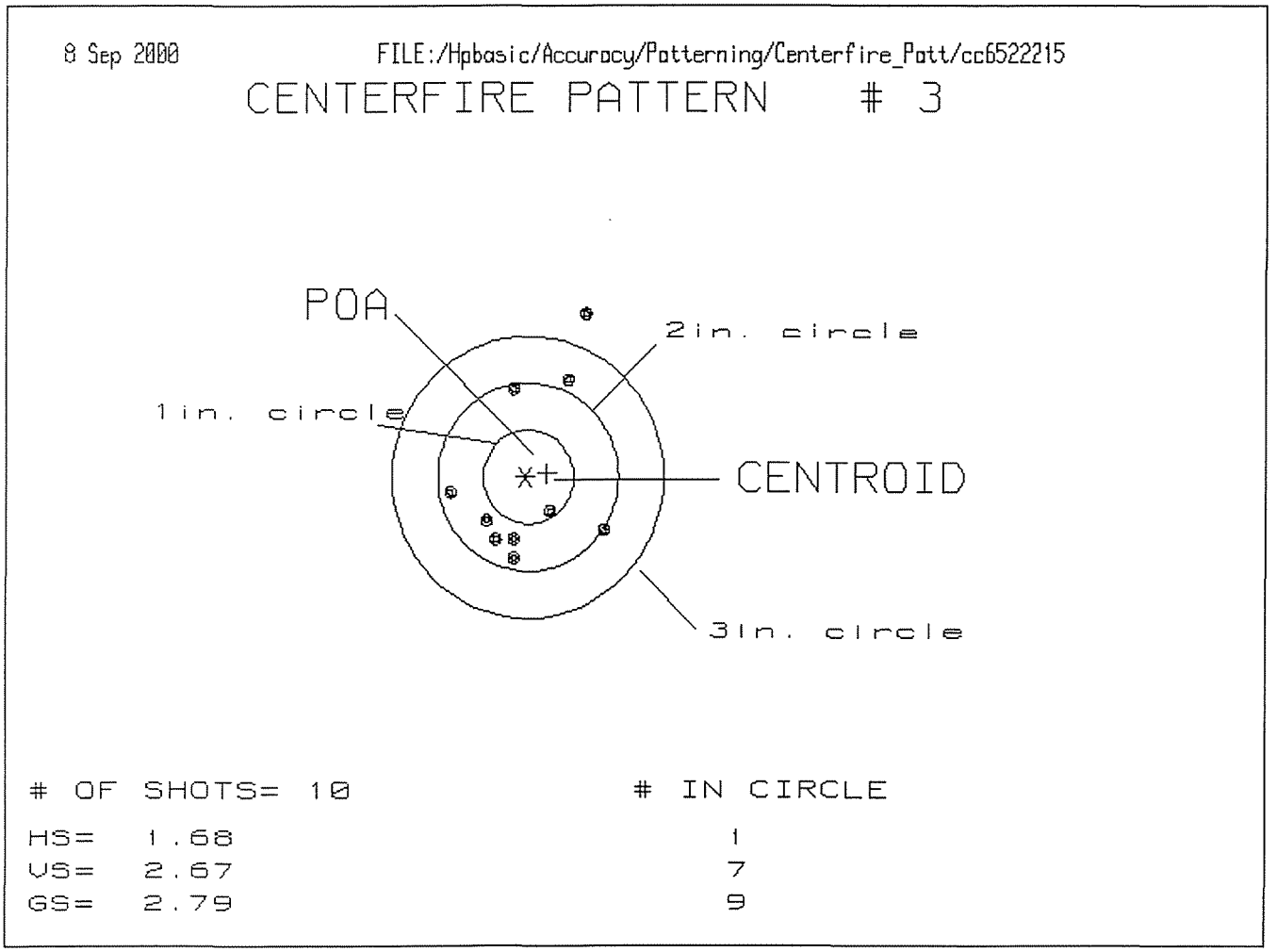
CENTERFIRE PATTERN # 2



# OF SHOTS= 10	# IN CIRCLE
HS= 2.76	2
VS= 3.04	6
GS= 3.22	7

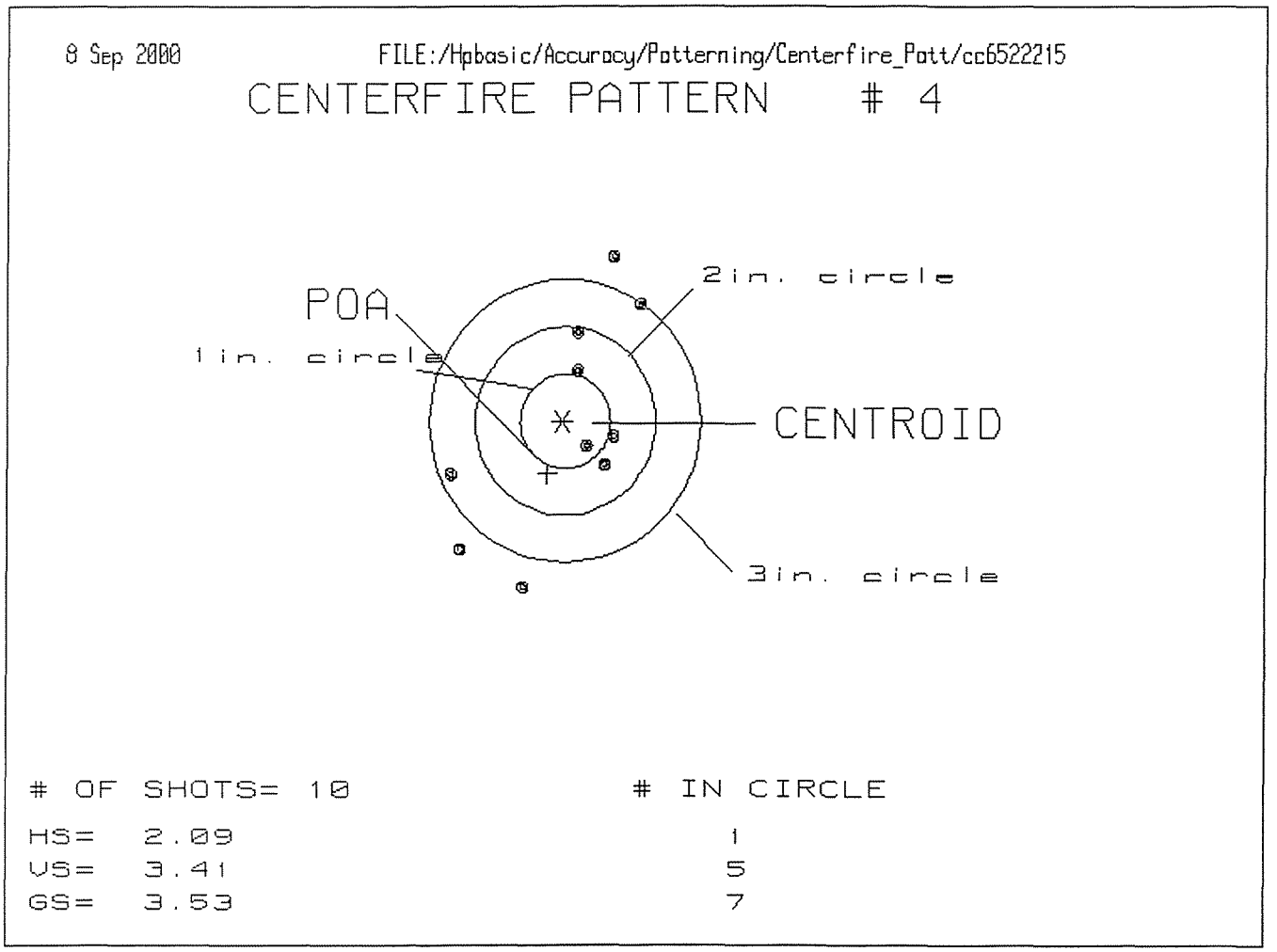
REMINGTON CENTERFIRE ACCURACY TEST REMINGTON TEST LAB, ILION, N.Y.

PATTERN #:	3
POA TO CENTROID:	.240
MIN RADIUS :	.419
MEAN RADIUS :	.924
MAX RADIUS :	1.881
CENTROID X :	-.238
CENTROID Y :	-.037



REMINGTON CENTERFIRE ACCURACY TEST REMINGTON TEST LAB, ILION, N.Y.

PATTERN #:		4
POA TO CENTROID:		.582
MIN RADIUS	:	.329
MEAN RADIUS	:	1.121
MAX RADIUS	:	1.793
CENTROID X	:	.167
CENTROID Y	:	.558

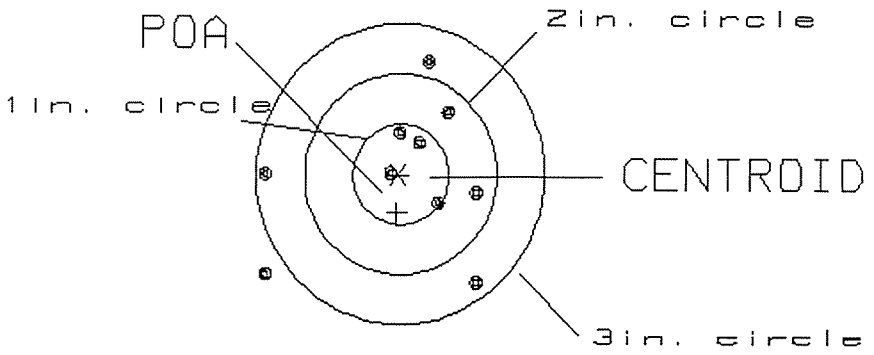


REMINGTON CENTERFIRE ACCURACY TEST REMINGTON TEST LAB, ILION, N.Y.

PATTERN #:		5
POA TO CENTROID:		.382
MIN RADIUS	:	.084
MEAN RADIUS	:	.857
MAX RADIUS	:	1.717
CENTROID X	:	.011
CENTROID Y	:	.381

8 Sep 2000 FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/cc6522215

CENTERFIRE PATTERN # 5



# OF SHOTS= 10	# IN CIRCLE
HS= 2.18	4
VS= 2.24	6
GS= 2.71	9

FINAL INSPECTION

S/N: C6522215	DATE REC'D: 5-12-00	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: _____

M-24 INSPECTION CHECKLIST
CONTRACT #: DAAE-20-97-C-242

R & E NUMBER	0000 9448
SERIAL NUMBER	C6522215
LOG-IN DATE	5-12-00

INSPECT AND VERIFY:			
OPERATION #	OPERATION NAME	DATE	INITIAL
550	DIS-ASSEMBLE GUN	5-15-00	RW
560 A	RE-BARREL AT CUSTOM SHOP		
B	DRILL AND TAP		
C	POLISH		
575	ASSEMBLE		
600	PROOF	5-23-00	RW
605	CHECK HEADSPACE	5-23-00	RW
610	DIS-ASSEMBLE GUN		
612	MAGNAFLUX		
615	ROLLMARK CALIBER		
618	ROTO-BLAST		
620	APPLY COATINGS		
625 A	FINAL ASSEMBLY	9-8-00	CK
B	TRIGGER PULL TEST		
C	SAFETY "ON" FORCE		
D	SAFETY "OFF" FORCE		
E	FIRING PIN INDENT		
640	TARGET	9-8-00	RW
655	FINAL INSPECT	9-12-00	RW
660	PACK		
		SHIP DATE	
	QAR INSPECTION DATE		

BARBER - M24 M2400002931

RECEIVING AND ESTIMATING REPORT

ORDER R 93-02454

INITIAL	CUSTOMER ORDER NO.	
PS		WOG 6 OF 30 W/10X SCOPE & DEPLOYMENT KIT M24

DATE RECEIVED	DATE OPENED	DATE CODE	SERIAL NUMBER	NEW SERIAL NUMBER	MODEL AND GRADE
1/25/93	01/25/93	DK 9-90	C6522215		700 7-62 NATO

ACCESSORIES: W/STUDS W/SWIVELS SOFT CASE SCOPE BASE

FROM:

MCHALE; EDWARD J CPT;SF
HSC 3RD BN 3RD SFG (A)
FT BRAGG NC 28307

SHIP TO:

MCHALE; EDWARD J CPT;SF
HSC 3RD BN 3RD SFG (A)
FT BRAGG NC 28307

CUST NO:073985 C.@.D

ACCOUNT NUMBER	ACCOUNT NUMBER N/C		PROM. DATE	ESTIMATED	VIA
		WRITE ☐ CLEAN/TEST			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: Rust on Gun

PARTS: Trigger ASSy - 96024

COMMENTS: Zinc phosphate Scope Rings, Swivels & Swivel Studs
Re-powder Coat Barrel ASSy - 96001

REPAIRMAN	PROOF	CLEAN	TEST	TARGET	PATTERN
RW		✓	✓		
GALLERY TESTER	**DATE**	**DATE**	**DATE**	**DATE**	**DATE**
RW		2/17/93	2/26/93		

OFFICE COPY

RD6925 REV. 1/92

BARBER - M24 0002892

RECEIVING AND ESTIMATING REPORT

COMMENTS

ORDER R93-02451

INITIAL	CUSTOMER ORDER NO.	
PS		WOG 4 OF 30 W/10X SCOPE & DEPLOYMENT KIT M24

DATE RECEIVED	DATE OPENED	DATE CODE	SERIAL NUMBER	NEW SERIAL NUMBER	MODEL AND GRADE
1/25/93	01/25/93	EK 10-90	C6523329		700 7-62 NATO

ACCESSORIES: W/STUDS W/SWIVELS SOFT CASE SCOPE BASE

FROM:

MCHALE; EDWARD J CPT;SF
HSC 3RD BN 3RD SFG (A)
FT BRAGG NC 28307

SHIP TO:

MCHALE; EDWARD J CPT;SF
HSC 3RD BN 3RD SFG (A)
FT BRAGG NC 28307

CUST NO:073985 C.O.D

ACCOUNT NUMBER	ACCOUNT NUMBER N/C		PROM. DATE	ESTIMATED	VIA
		WRITE ☐ CLEAN/TEST			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: Rust on Gun

PARTS

Firing pin ASSY - 96007
Magazine / - 96013
Trigger ASSY - 96024
Stock ASSY - 96018
Barrel ASSY Complete - 96001
Bolt Stop / - 17013
Front Guard Screw - 96010
Rear Guard Screw - 96015
Front Sight ASSY - 96118
Rear Sight ASSY - 96119

COMMENTS

Zinc phosphate Scope Base, Scope Rings, Swivels & Swivel Studs Re-powder Coat Floor plate, latch, Trigger Guard, Front & Rear Sight Bases

REPAIRMAN	PROOF	CLEAN	TEST	TARGET	PATTERN
RW	✓	✓	✓	✓	
GALLERY TESTER	**DATE**	**DATE**	**DATE**	**DATE**	**DATE**
RW	2/4/93	2/9/93	3/2/93	3/2/93	

OFFICE COPY

RD6925 REV. 1/92

M-24

GFM

CONTRACT # DAAA21-87-C-0086

Repair

GUN SERIAL # C6522215

OP. #	OP. NAME	READINGS	DATE	INIT
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		2/17/93	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		2/17/93	RW
	C) Inspect Ejector Hole for Chamfer		2/17/93	RW
	D) Oil Firing Pin Ass'y		2/17/93	RW
	E) Adjust Trigger Pull to Min Setting and Stake		2/17/93	RW

Op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			2/17/93	RW
	G) Safety Off Force	3.5	3	3			2/17/93	RW
	H) Trigger Pull Test & Retainability						2/17/93	RW
	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						2/17/93	RW
	P) Detach & Attach Scope 20 Times							
640	Gallery Target & Test						2/26/93	RW
	A) Time							
	B) Malfunctions							
	C) Pierced Primers							
	D) Optical Clearity of Scope							
645	Inspect for Live Ammo						2/26/93	RW
655	Final Inspection A) Headspace						3/4/93	RW
	B) Trigger Pull	2.40	2.34	2.38	2.38	2.34	3/4/93	RW
	C) Function						3/4/93	RW
660	Pack							

SWS TRIGGER PULL TEST

New Trigger ASSY

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

SERIAL NO. C6522215

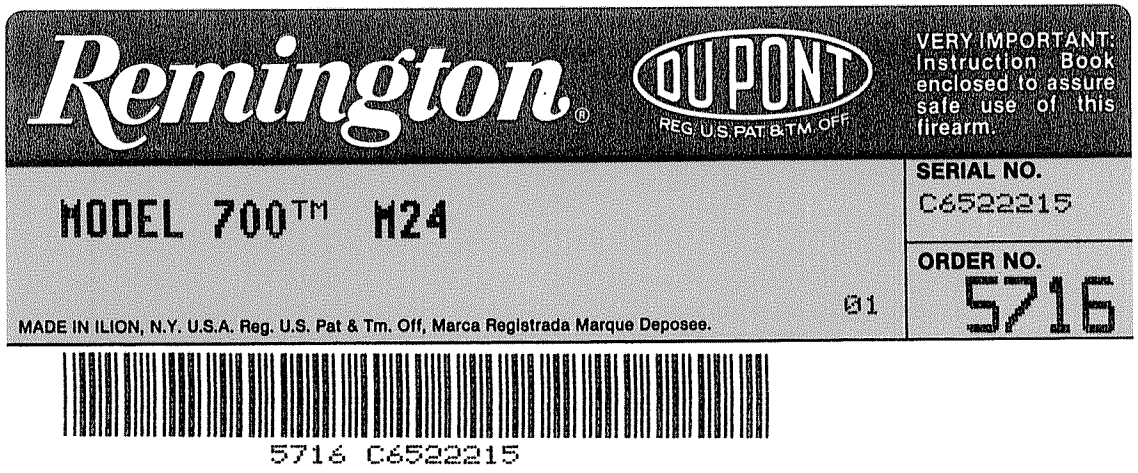
DATE 2/17/93

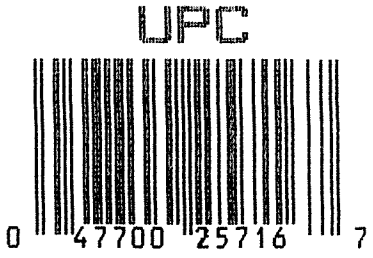
TESTER RW

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.42	2.30	2.55		MIN. SETTING,
PULL #2	2.37	2.25	2.46		NO AVG. OF 5
PULL #3	2.32	2.24	2.44		READINGS ACCEPT-
PULL #4	2.31	2.26	2.47		ABLE LESS THAN 2#
PULL #5	2.36	2.20	2.26		
TOTAL	11.78	11.25	12.18		
AVG.	2.36	2.25	2.44		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.19	3.21		
PULL #2	3.17	3.13		
PULL #3	3.17	3.27		
PULL #4	3.14	3.15		
PULL #5	3.11	3.23		
TOTAL	15.78	15.99		
AVG.	3.16	3.20		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.07	4.07		4.28
PULL #2	4.09	4.05		4.26
PULL #3	4.05	4.09		4.28
PULL #4	4.01	4.05		4.32
PULL #5	4.02	4.09		4.23
TOTAL	20.24	20.35		21.37
AVG.	4.05	4.07		4.27





BARBER - M24 0002897

RECEIVING AND ESTIMATING REPORT

COMMENTS

ORDER R 93-02454

TIAL	CUSTOMER ORDER NO.	COMMENTS
S		WOG 6 OF 30 W/10X SCOPE & DEPLOYMENT KIT M24

TE RECEIVED	DATE OPENED	DATE CODE	SERIAL NUMBER	NEW SERIAL NUMBER	MODEL AND GRADE
/25/93	01/25/93	DK 9-90	C6522215		700 7-62 NATO

CESSORIES W/STUDS W/SWIVELS SOFT CASE SCOPE BASE

OM:

MCHALE; EDWARD J CPT;SF
HSC 3RD BN 3RD SFG (A)
FT BRAGG NC 28307

SHIP TO:

MCHALE; EDWARD J CPT;SF
HSC 3RD BN 3RD SFG (A)
FT BRAGG NC 28307

CUST NO:073985 C.O.D

COUNT NUMBER	ACCOUNT NUMBER N/C		PROM. DATE	ESTIMATED	VIA
		WRITE ☐ CLEAN/TEST			UPS

N CONDITION
NEW
LIGHTLY WORN
WORN
VERY WORN
UNREPAIRABLE
MARRED

REPAIR CHARGE	
EXCISE	
TAX	
INSURANCE	
UPS	
PARCEL POST	
TOTAL	

STOMER CONCERN	AMMO	FUNCTION	FINISH	ACCURACY	FIT	INSPECT
CLE	A1	B1				
GGER GROUP		B2			E1	F1
LT ASSY.		B3			E2	F2
RREL ASSY.		B4		D1	E3	F3
C. ASSY.		B5		D2	E4	F4
OD			C1	D3	E5	F5
TAL			C2			

N FAULT

TS	COMMENTS

REPAIRMAN	PROOF	CLEAN	TEST	TARGET	PATTERN
GALLERY TESTER	**DATE**	**DATE**	**DATE**	**DATE**	**DATE**

RD6925 REV. 1/92

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6522215
1 Nov 1990

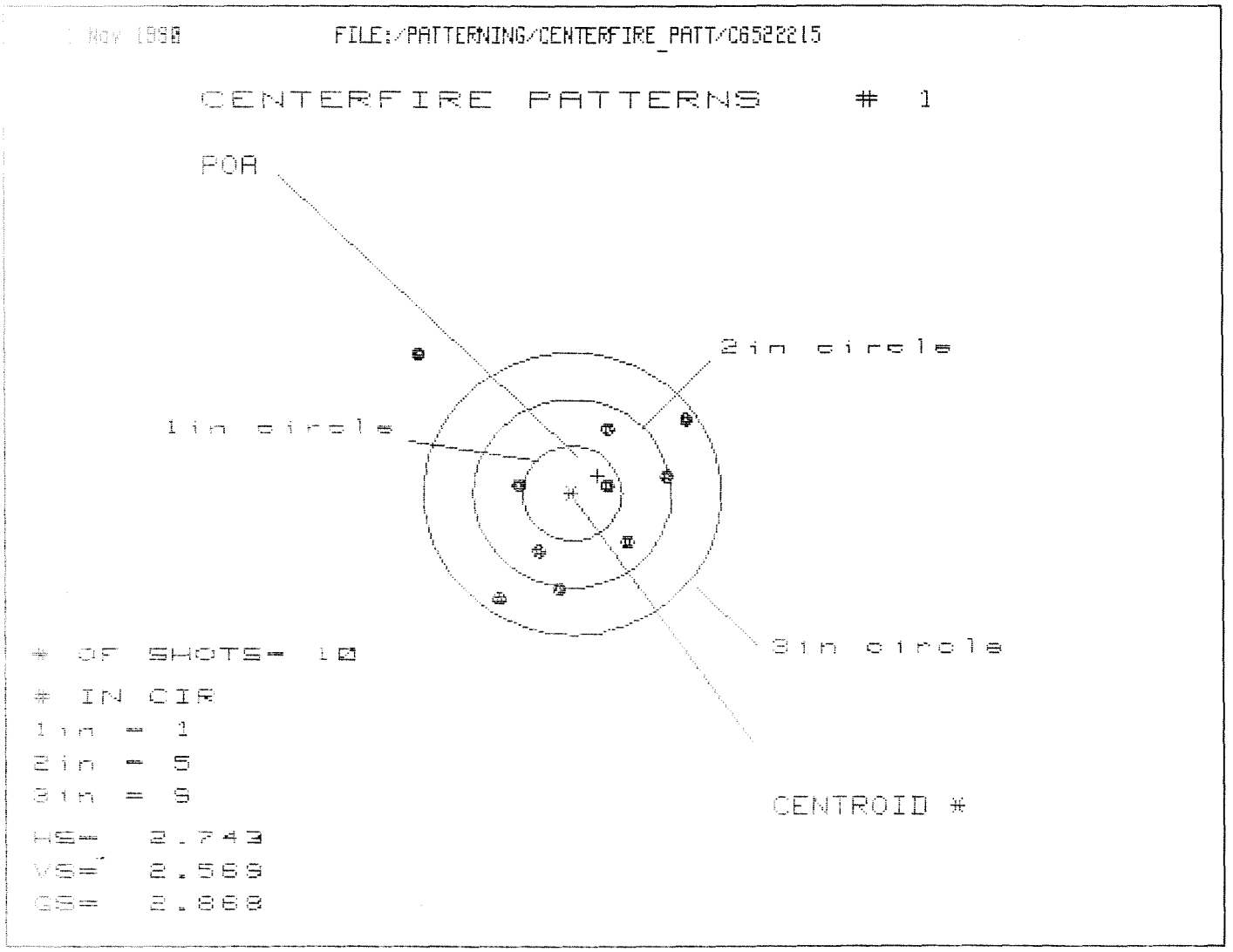
CENTROIDAL DISTANCES

0	TO	1	.315628
1	TO	2	.497403
1	TO	3	.45771
1	TO	4	.209476
1	TO	5	.303488

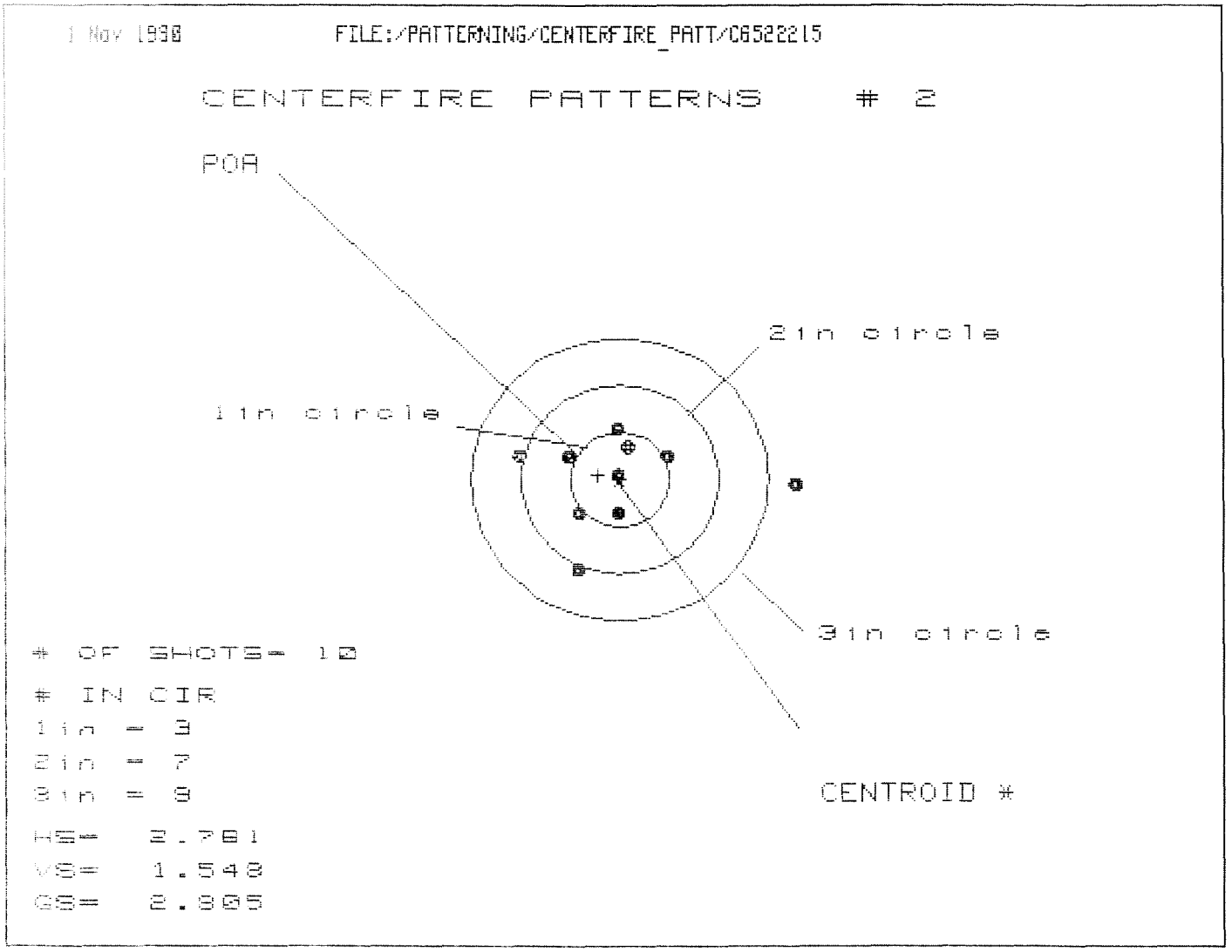
<----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0286
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.003
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0436688

THE AMR FOR THIS RIFLE IS: .9374



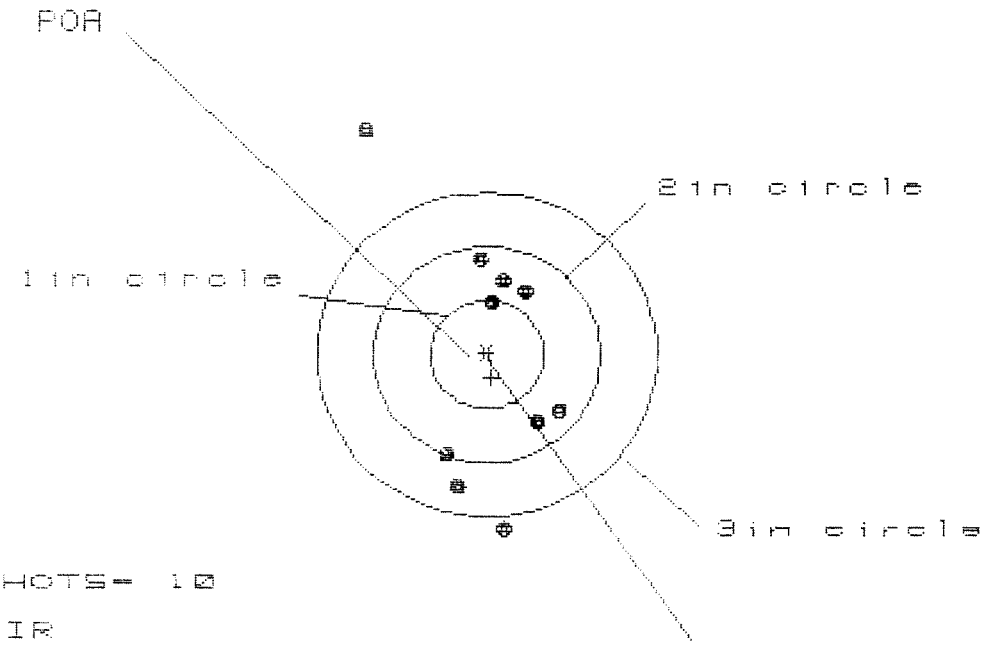
PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.177	1.003	.954
MINIMUM X	:	-1.566	-.929	-.803
MAXIMUM Y	:	1.459	.953	1.010
MINIMUM Y	:	-1.110	-.948	-.829
CENTROID X	:	-.255	-.081	-.206
CENTROID Y	:	-.186	-.348	-.467
POA TO CENTROID in.	:	.316	.357	.511
MIN RADIUS	:	.348	.270	.442
MEAN RADIUS	:	1.019	.859	.788
MAX RADIUS	:	2.140	1.384	1.154
HORIZONTAL SPREAD	:	2.743	1.932	1.757
VERTICAL SPREAD	:	2.569	1.901	1.839
EXTREME SPREAD	:	2.868	2.710	2.181
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	



PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.762	.711	.689
MINIMUM X	:	-1.019	-.823	-.845
MAXIMUM Y	:	.547	.539	.413
MINIMUM Y	:	-1.001	-1.009	-.478
CENTROID X	:	.222	.026	.048
CENTROID Y	:	-.045	-.037	.089
POA TO CENTROID in.	:	.227	.045	.102
MIN RADIUS	:	.085	.208	.179
MEAN RADIUS	:	.687	.557	.483
MAX RADIUS	:	1.764	1.025	.859
HORIZONTAL SPREAD	:	2.781	1.534	1.534
VERTICAL SPREAD	:	1.548	1.548	.891
EXTREME SPREAD	:	2.805	1.583	1.534
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

1 Nov 1988 FILE:/PATTERNING/CENTERFIRE_PATT/C6522215

CENTERFIRE PATTERNS # 3



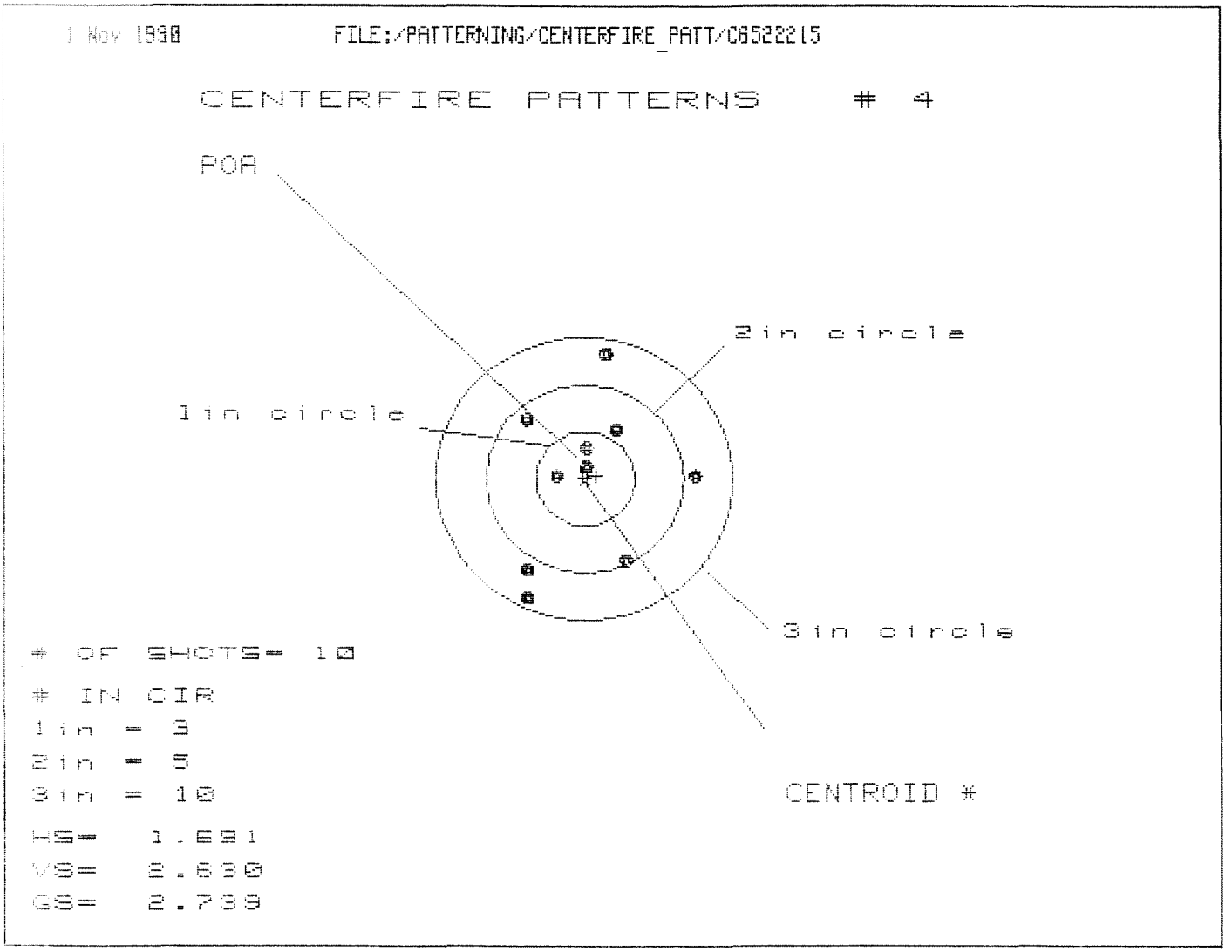
OF SHOTS= 10

# IN CIR
1in = 0
2in = 5
3in = 8

HS= 1.695
VS= 3.718
GS= 3.909

PATTERN # : 3

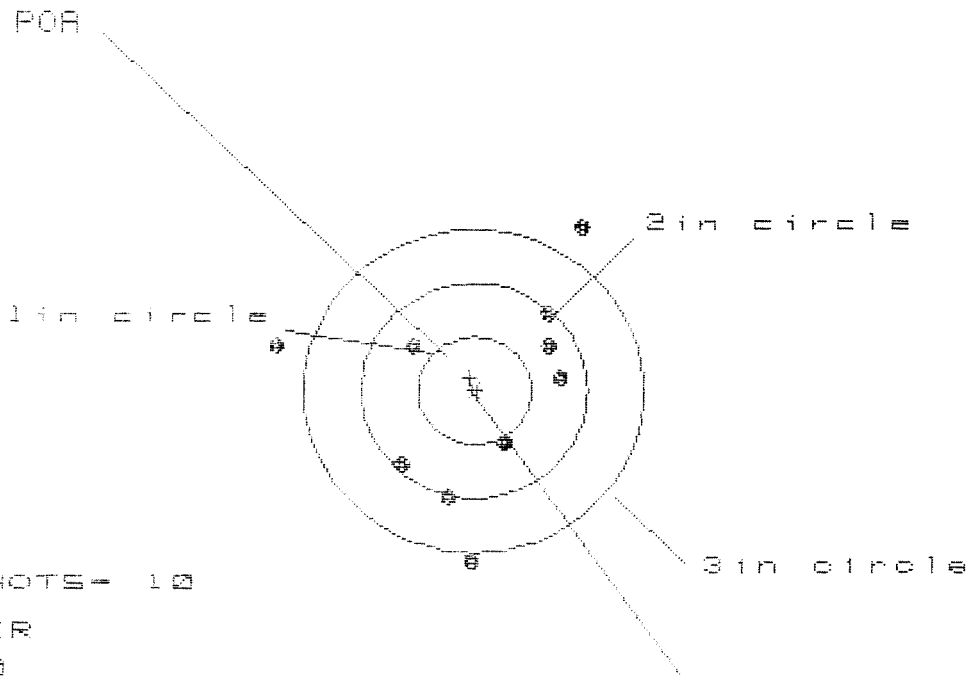
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.649	.533	.539
MINIMUM X	:	-1.046	-.457	-.451
MAXIMUM Y	:	2.100	1.132	.959
MINIMUM Y	:	-1.618	-1.384	-1.124
CENTROID X	:	-.038	.078	.072
CENTROID Y	:	.217	-.017	.156
POA TO CENTROID in.	:	.220	.080	.172
MIN RADIUS	:	.504	.497	.576
MEAN RADIUS	:	1.056	.893	.815
MAX RADIUS	:	2.346	1.385	1.196
HORIZONTAL SPREAD	:	1.695	.990	.990
VERTICAL SPREAD	:	3.718	2.516	2.083
EXTREME SPREAD	:	3.909	2.525	2.098
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	



PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.076	1.010	1.022
MINIMUM X	:	-.615	-.681	-.668
MAXIMUM Y	:	1.346	1.204	.669
MINIMUM Y	:	-1.284	-1.147	-.997
CENTROID X	:	-.113	-.047	-.060
CENTROID Y	:	-.032	.110	-.040
POA TO CENTROID in.	:	.118	.120	.072
MIN RADIUS	:	.165	.043	.172
MEAN RADIUS	:	.841	.737	.708
MAX RADIUS	:	1.416	1.322	1.187
HORIZONTAL SPREAD	:	1.691	1.691	1.691
VERTICAL SPREAD	:	2.630	2.351	1.666
EXTREME SPREAD	:	2.739	2.470	1.966
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		10	

Nov 1990 FILE:/PATTERNING/CENTERFIRE_PATT/C6522215

CENTERFIRE PATTERNS # 5



OF SHOTS= 10

# IN CIR
1in = 0
2in = 7
3in = 7

HS= 2.712
VS= 3.114
CS= 3.271

PATTERN # : 5

SHOTS (BEST OF)	10	9	8
MAXIMUM X	.970	.867	.663
MINIMUM X	-1.742	-1.635	-.774
MAXIMUM Y	1.543	.893	.965
MINIMUM Y	-1.571	-1.400	-1.328
CENTROID X	.041	-.066	.138
CENTROID Y	-.119	-.290	-.362
POA TO CENTROID in.	.126	.298	.387
MIN RADIUS	.528	.454	.268
MEAN RADIUS	1.084	.992	.867
MAX RADIUS	1.822	1.732	1.334
HORIZONTAL SPREAD	2.712	2.502	1.437
VERTICAL SPREAD	3.114	2.293	2.293
EXTREME SPREAD	3.271	2.611	2.385
NUMBER IN ONE INCH CIRCLE =		0	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		7	

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6522215

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	9 24	90	RW
600	Proof	9 24	90	RW
607	Check Headspace	9 24	90	RW
610	Dis-assemble Gun	9 24	90	RW
612	Magnaflux Barrel Action		9-25-90	KR
	Magnaflux Bolt		9-25-90	KR
615	Rollmark Caliber		9-25-90	DS
617	Drill and Tap Sight Holes		9-25-90	F.B
618	Polish Barrel RB		9/28/90	WB
620	Apply Coatings (Barrel Action)		10-2-90	TH
	Apply Coating (Bolt)		10-2-90	TH
625	Final Assembly A) Clean inside of Bolt Assembly		10/9/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/9/90	RW
	C) Inspect Ejector Hole for Chamfer		10/9/90	RW
	D) Oil Firing Pin Ass'y		10/9/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		10/30/90	RH

op. #	OP. NAME	READINGS			DATE	INIT
625 ont.	F) Safety On Force	5	5	5	10/31/90	WB
	G) Safety Off Force	3	3	3	10/31/90	WB
	H) Trigger Pull Test & Retainability				10/30/90	
	I) Firing Pin Indent	.021	.020	.021	10/31/90	WB
	J) Assemble Stock				10/31/90	RW
	K) Assemble Swivel Studs				3/6/90	
	L) Attach Front and Rear Sight Assemblies				10/31/90	RW
	M) Iron Sight Alignment				10/31/90	RW
	N) Detach Front & Rear Sights & place in numbered container				10/31/90	RW
	O) Attach Scope to Rifle				10/31/90	RW
	P) Detach & Attach Scope 20 Times				10/31/90	RW
640	Gallery Target & Test				10/31/90	AF
	A) Time				"	AF
	B) Malfunctions				"	AF
	C) Pierced Primers				"	AF
	D) Optical Clearity of Scope				"	AF
645	Inspect for Live Ammo				10/31/90	AF
655	Final Inspection A) Headspace				3/6/90	
	B) Trigger Pull	272	264 256	241 212	3/6/90	
	C) Function				3/6/90	
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. C522215

DATE 10/30/90

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.20	2.47	2.44	2.72	MIN. SETTING,
PULL #2	2.45	2.39	2.40	2.64	NO AVG. OF 5
PULL #3	2.50	2.43	2.38	2.56	READINGS ACCEPT-
PULL #4	2.48	2.45	2.43	2.41	ABLE LESS THAN 2#
PULL #5	2.43	2.43	2.40	2.12	
TOTAL	12.06	12.17	12.05		
AVG.	2.412	2.434	2.41		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.20	3.36		
PULL #2	3.23	3.39		
PULL #3	3.31	3.28		
PULL #4	3.32	3.33		
PULL #5	3.34	3.19		
TOTAL	16.4	16.55		
AVG.	3.28	3.31		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.24	4.34		4.13
PULL #2	4.19	4.32		4.43
PULL #3	4.20	4.41		4.33
PULL #4	4.46	4.40		4.33
PULL #5	4.29	4.35		4.10
TOTAL	21.38	21.82		21.32
AVG.	4.276	4.364		4.264