

C6498800

MODEL 700™ M24

Model SMS™

Action

Barrel Length

Capacity

Order No. 5716

*Includes 1 in chamber.

Remington

79

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: RE00156490

Serial: C6498800 Model M24 SWS Center Fire
Caliber: 7.62 NATO Produced: 06/19/1990

Repairman:

Status: Closed 12/6/2008 7:41:41 AM

Verify Repair

Address Information

Customer:

Received From

Return To:

Received From

Name: DEPARTMENT OF THE ARMY SUPPLY OFFICER

DEPARTMENT OF THE ARMY SUPPLY OFFICER

Address 1: DOL SISA BLDG 9660 BAY A

DOL SISA BLDG 9660 BAY A

Address 2: BOX 339500 MAIL STOP 181

PO Box:

BOX 339500 MAIL STOP 181

PO Box:

City: FORT LEWIS

FORT LEWIS

State: WA

Zip Code: 98433

Country: US

State: WA

Zip Code: 98433

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
A017	Scope Base	1
A045	Bi Pod	1
A057	Fit and Rear Sgt Base	1

Repair Search

Refresh

Close

naglej

12/8/2008

12:28 PM

CAPS

NUM

INS

SCRL



Laser Filter
slings nylon

Serial Number: **C6498800**

Model: **M24 SWS**



RE00156490

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

P & E NUMBER

156490

SERIAL NUMBER

C6498800

LOG-IN DATE

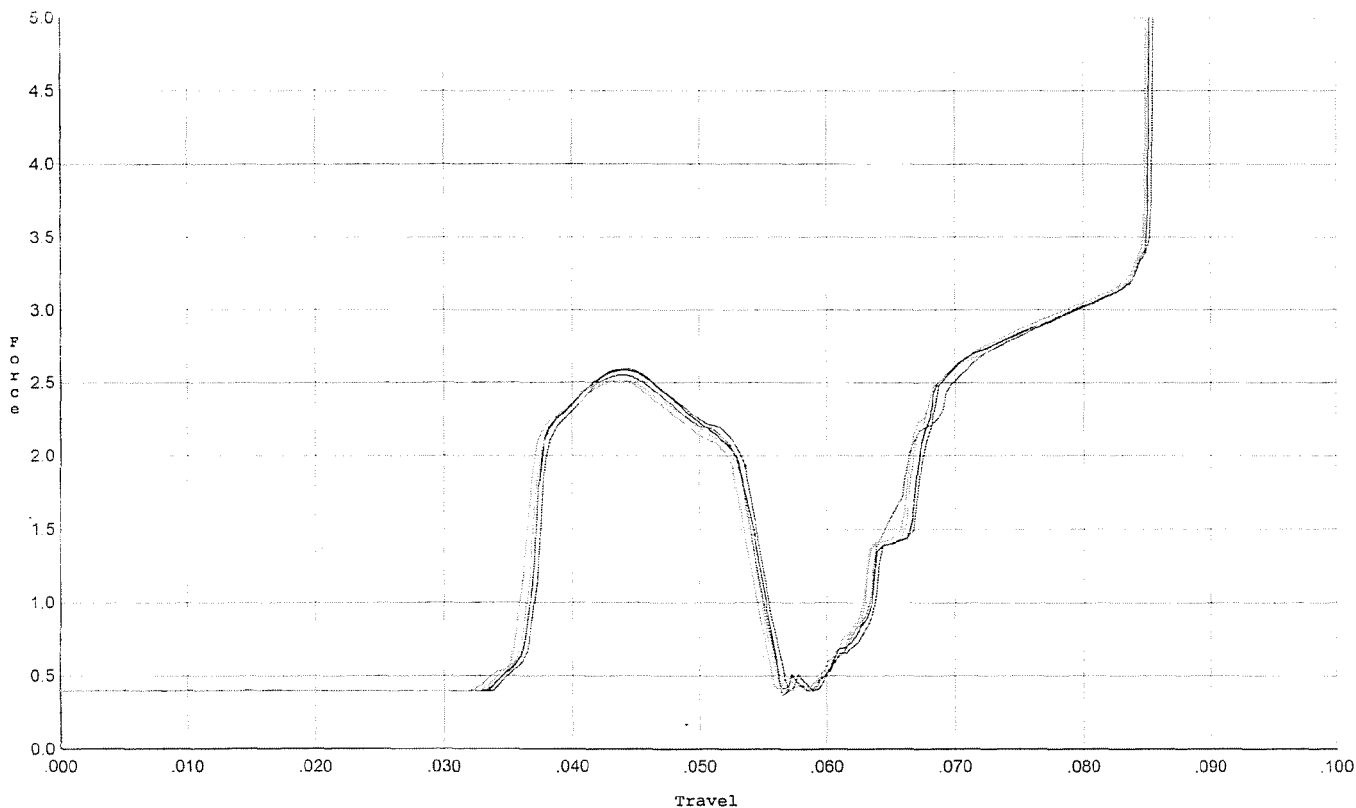
12-6-08

OPERATION #	OPERATION NAME	DATE	INITIAL
500	DIS-ASSEMBLE GUN	12-10-08	RTZ
505	RE-BARREL	12-10-08	RTZ
560	ASSEMBLE	12-10-08	RTZ
600	PROOF	12-15-08	RP
605	CHECK HEADSPACE	12-15-08	RP
610	DIS-ASSEMBLE GUN	12-15-08	RP
612	MAGNAFLUX	12-20-08	RP
510	DRILL AND TAP	12-16-08	SP
615	ROLLMARK CALIBER	12/20/08	RT
618	ROTO-BLAST	1/5	RT
620	APPLY COATINGS	1/7	—
625	FINAL ASSEMBLY	1-9-09	RTZ
640	FUNCTION TEST AND	1-9-09	RP
650	TARGET	1-9-09	RP
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
670	FINAL INSPECTION	1-9-09	RP
	A) HEADSPACE	1-12-09	RP
		1-12-09	RP
	B) TRIGGER PULL	2.57 2.58 2.65 2.58 2.63	1-12-09 TL
680	F) SAFETY ON FORCE	4.0 4.0 4.0	1-12-09 RP
	G) SAFETY OFF FORCE	6.0 6.0 6.0	1-12-09 RP
	H) FIRING PIN INDENT	-0.023 -0.023 -0.023	1-12-09 RP
690	PACK		1/12/09 PM

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putsch 11/19/08

Model: M/24
 Serial No: Form #F005
 Trigger: 2.5 lbs. ini. +/- .50 lbs.



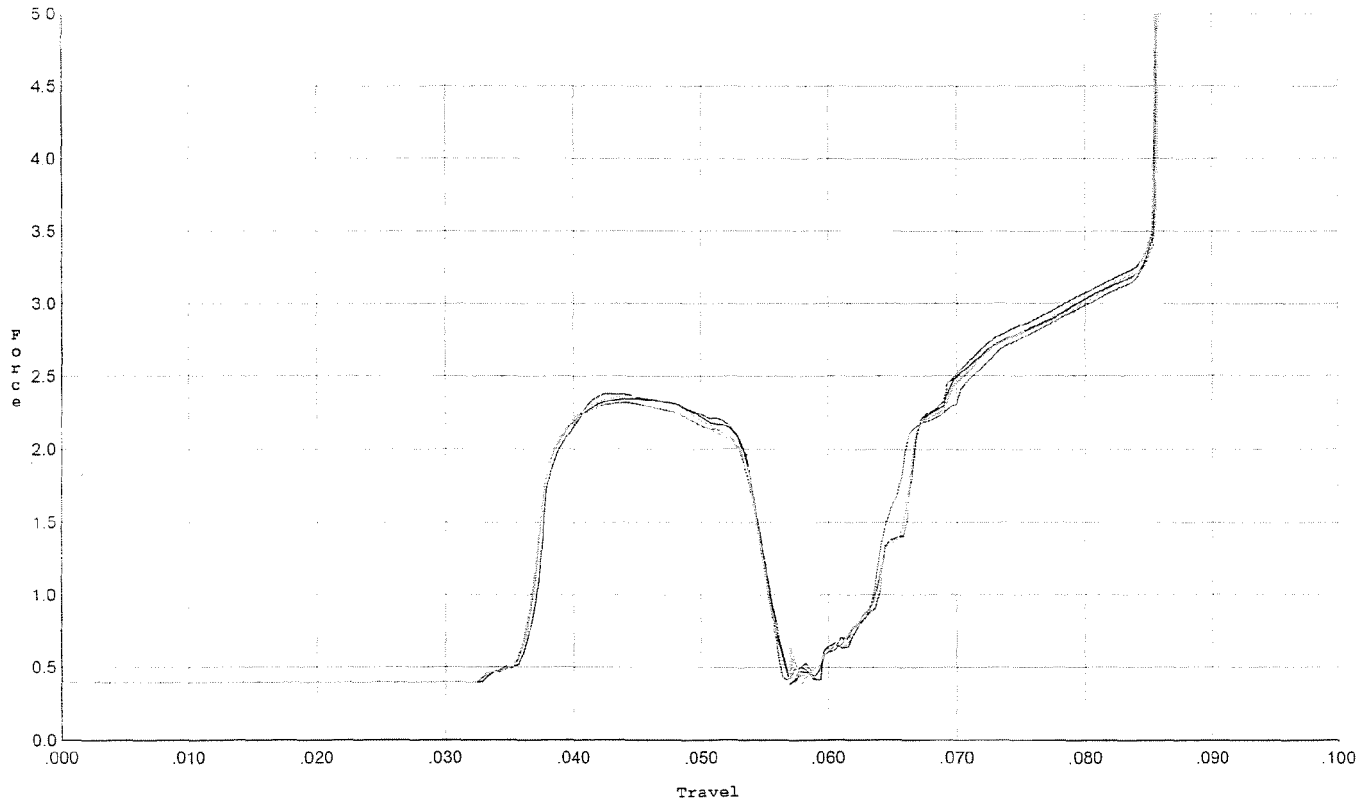
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.596	0.054	0.036	0.037	0.054		Set Trigger
2	2.586	0.054	0.036	0.037	0.055		Set Trigger
3	2.552	0.053	0.036	0.037	0.053		Set Trigger
4	2.513	0.053	0.036	0.037	0.053		Set Trigger
5	2.515	0.053	0.035	0.037	0.053		Set Trigger

Avg 2.55

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 11/19/08

Model: M/24
 Serial No: Form #F005
 Trigger: 2.5 lbs. after 50 cycles +/- .50 lbs.



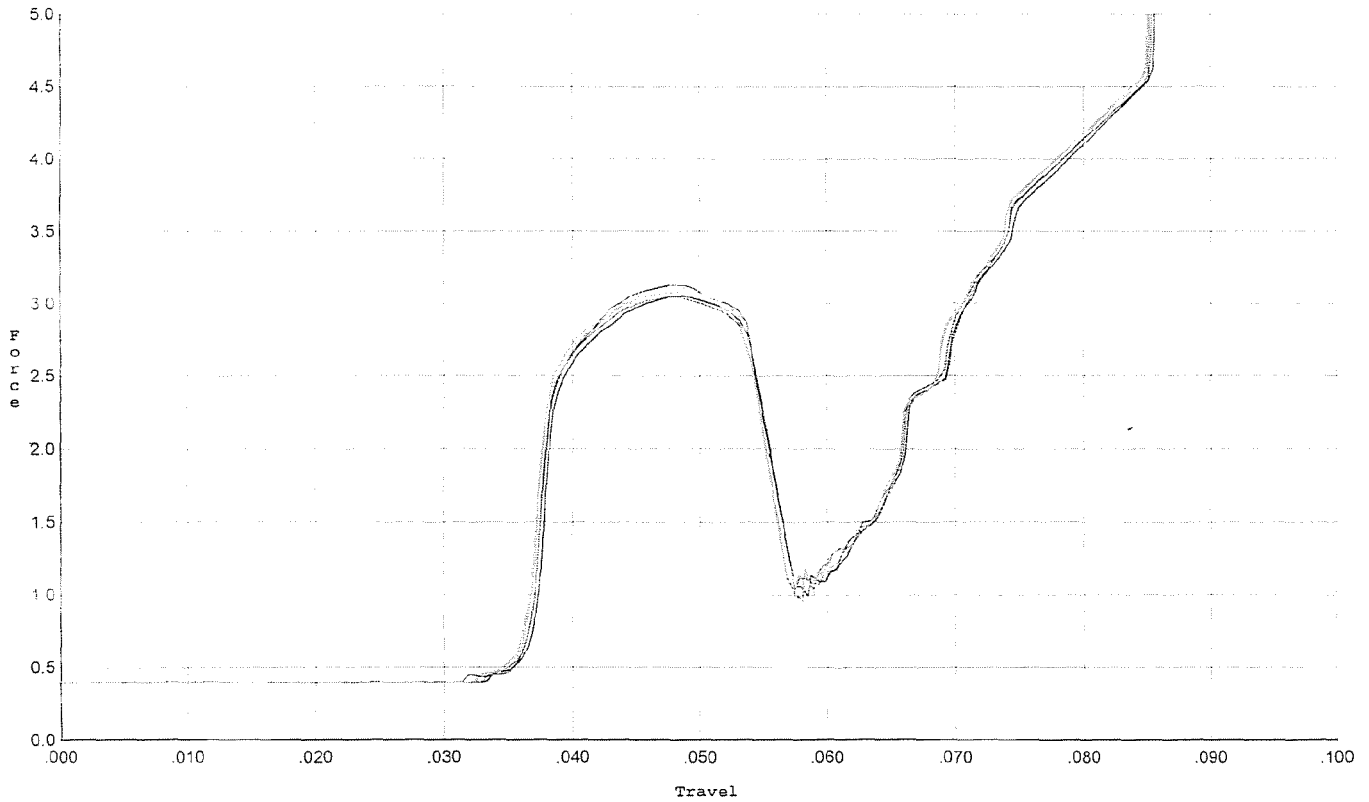
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.377	0.054	0.036	0.037	0.052		Set Trigger
2	2.345	0.054	0.036	0.037	0.052		Set Trigger
3	2.318	0.054	0.036	0.037	0.052		Set Trigger
4	2.323	0.054	0.036	0.037	0.052		Set Trigger
5	2.361	0.054	0.036	0.037	0.052		Set Trigger

Avg 2.34

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 11/19/08

Model: M/24
Serial No: Form #F005
Trigger: 3.0 lbs. ini. +/- .75 lbs.



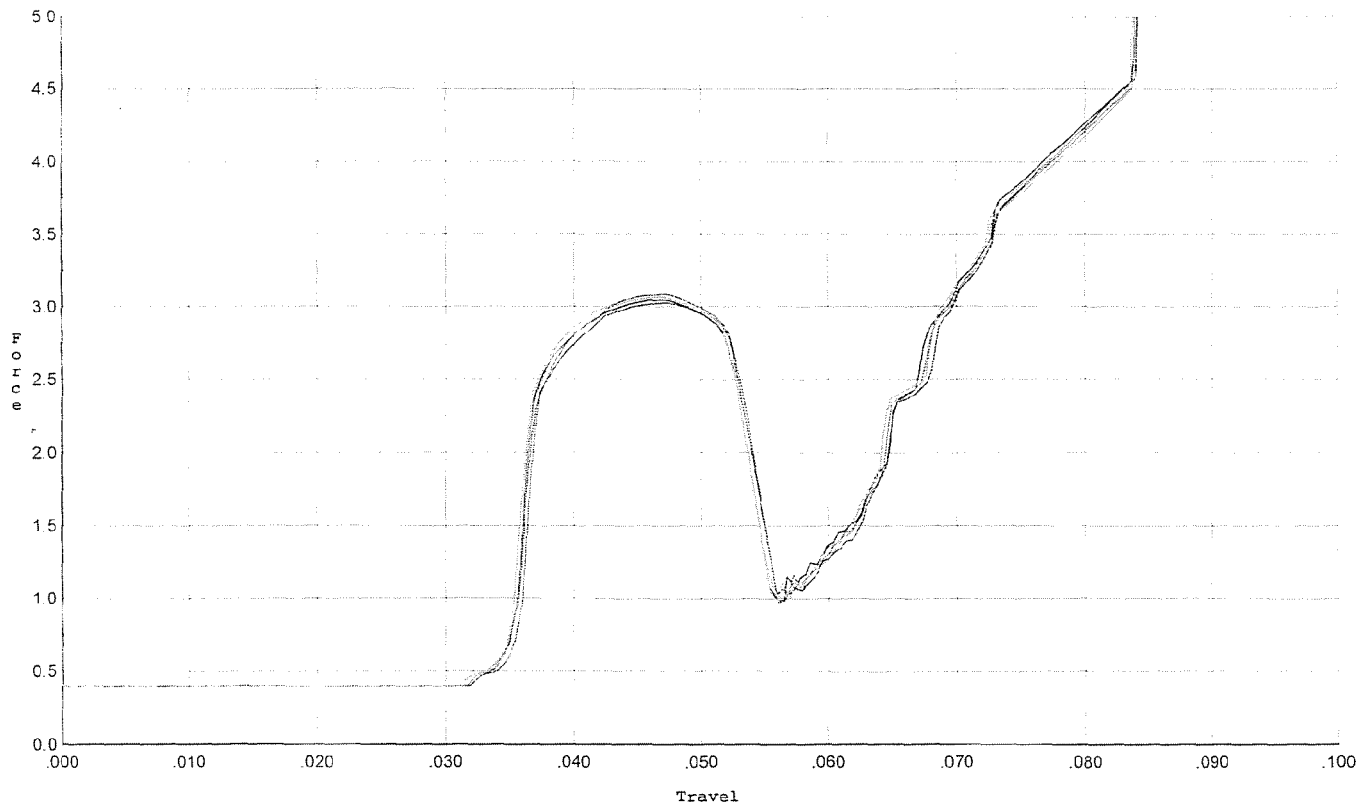
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.128	0.055	0.036	0.036	0.067		Set Trigger
2	3.053	0.056	0.037	0.036	0.065		Set Trigger
3	3.045	0.054	0.036	0.036	0.064		Set Trigger
4	3.112	0.054	0.036	0.036	0.065		Set Trigger
5	3.076	0.054	0.036	0.036	0.065		Set Trigger

Aug 3.08

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 11/19/08

Model: M/24
 Serial No: Form #F005
 Trigger: 3.0 lbs. after 20 cycles +/- .75 lbs.



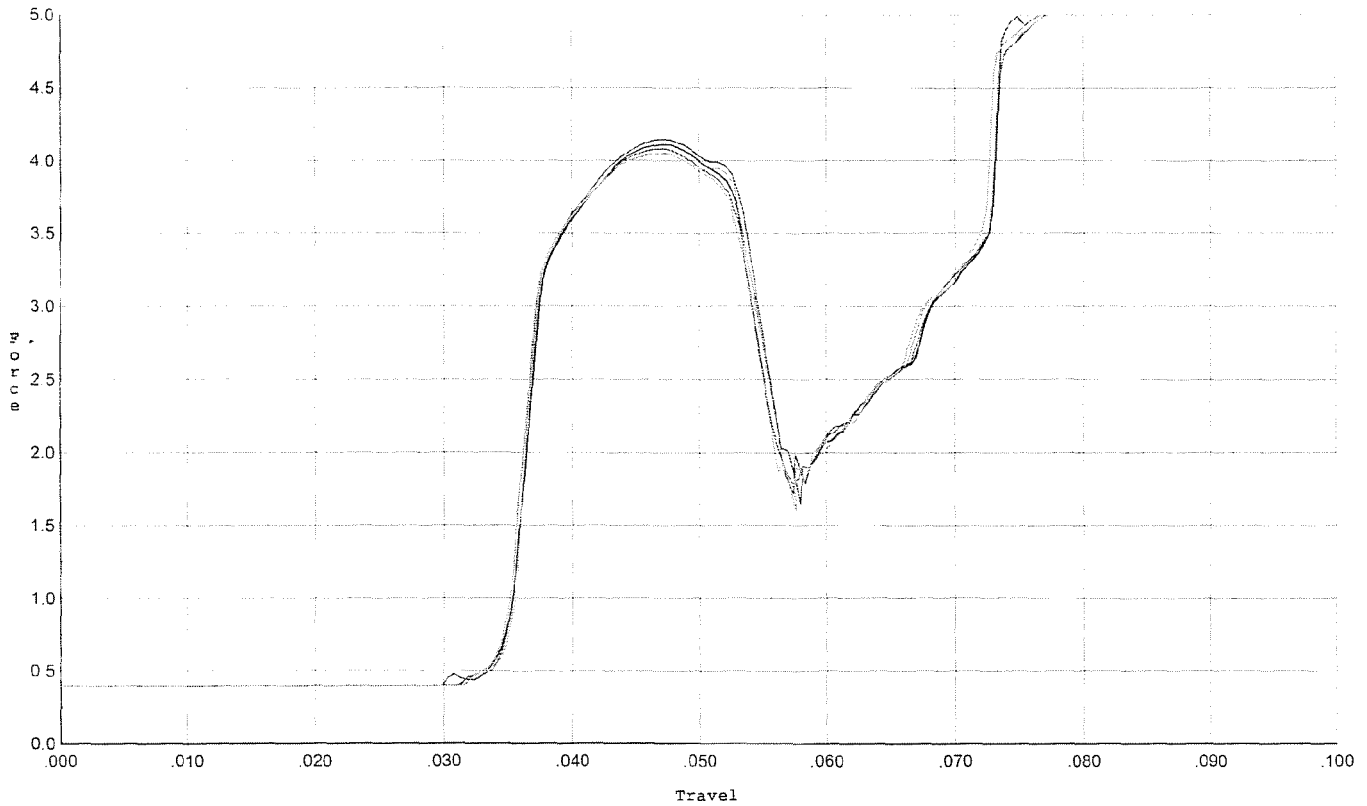
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.026	0.054	0.035	0.035	0.065		Set Trigger
2	3.047	0.053	0.035	0.036	0.063		Set Trigger
3	3.085	0.053	0.035	0.035	0.065		Set Trigger
4	3.072	0.053	0.032	0.036	0.063		Set Trigger
5	3.064	0.053	0.035	0.035	0.064		Set Trigger

Avg 3.05

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putsch 11/19/08

Model: M/24
 Serial No: Form #F005
 Trigger: 4.0 lbs. ini. +/- 1.0 lbs.



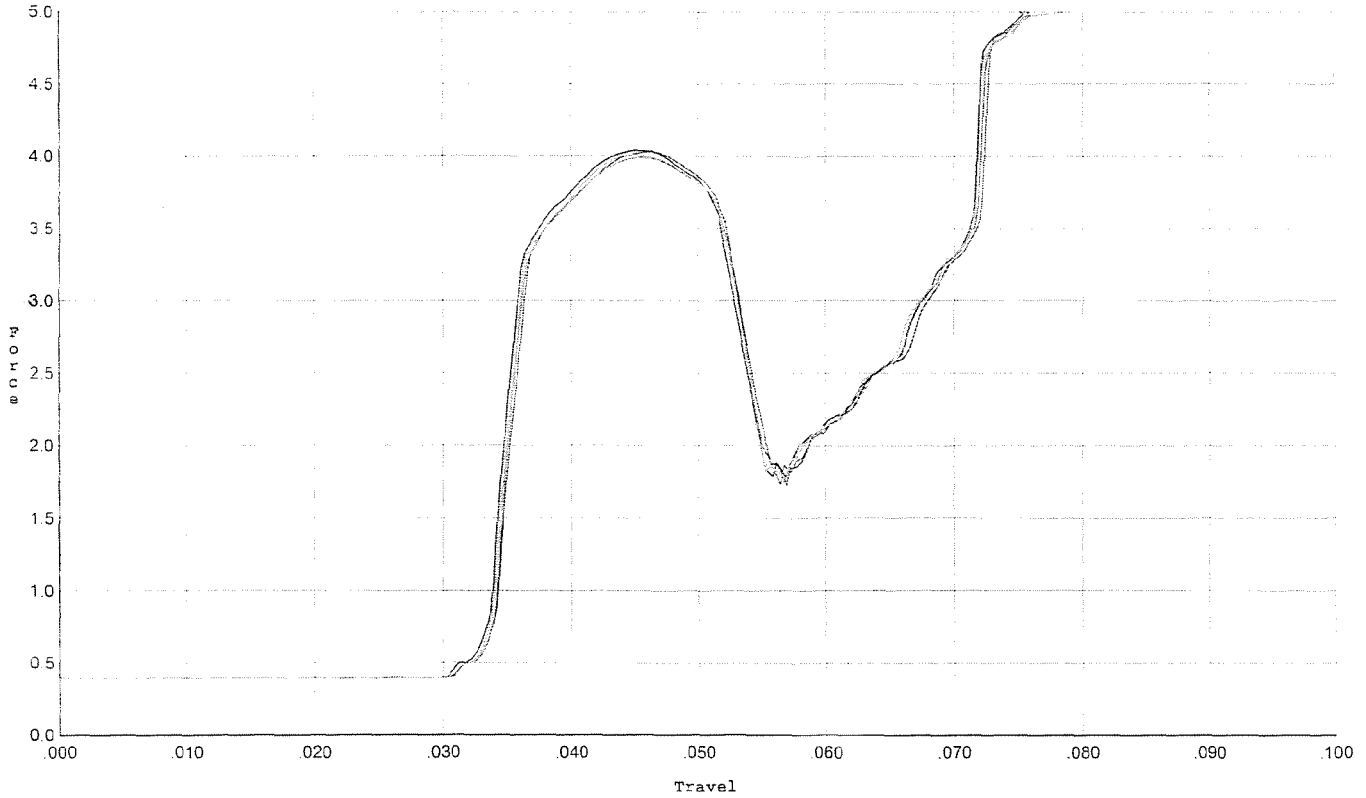
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.147	0.053	0.034	0.034	0.084		Set Trigger
2	4.110	0.054	0.034	0.034	0.084		Set Trigger
3	4.081	0.053	0.034	0.034	0.082		Set Trigger
4	4.049	0.054	0.035	0.034	0.084		Set Trigger
5	4.053	0.053	0.034	0.034	0.082		Set Trigger

Avg 4.08

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 11/19/08

Model: M/24
 Serial No: Form #F005
 Trigger: 4.0 lbs. after 20 cycles +/- 1.0 lbs.



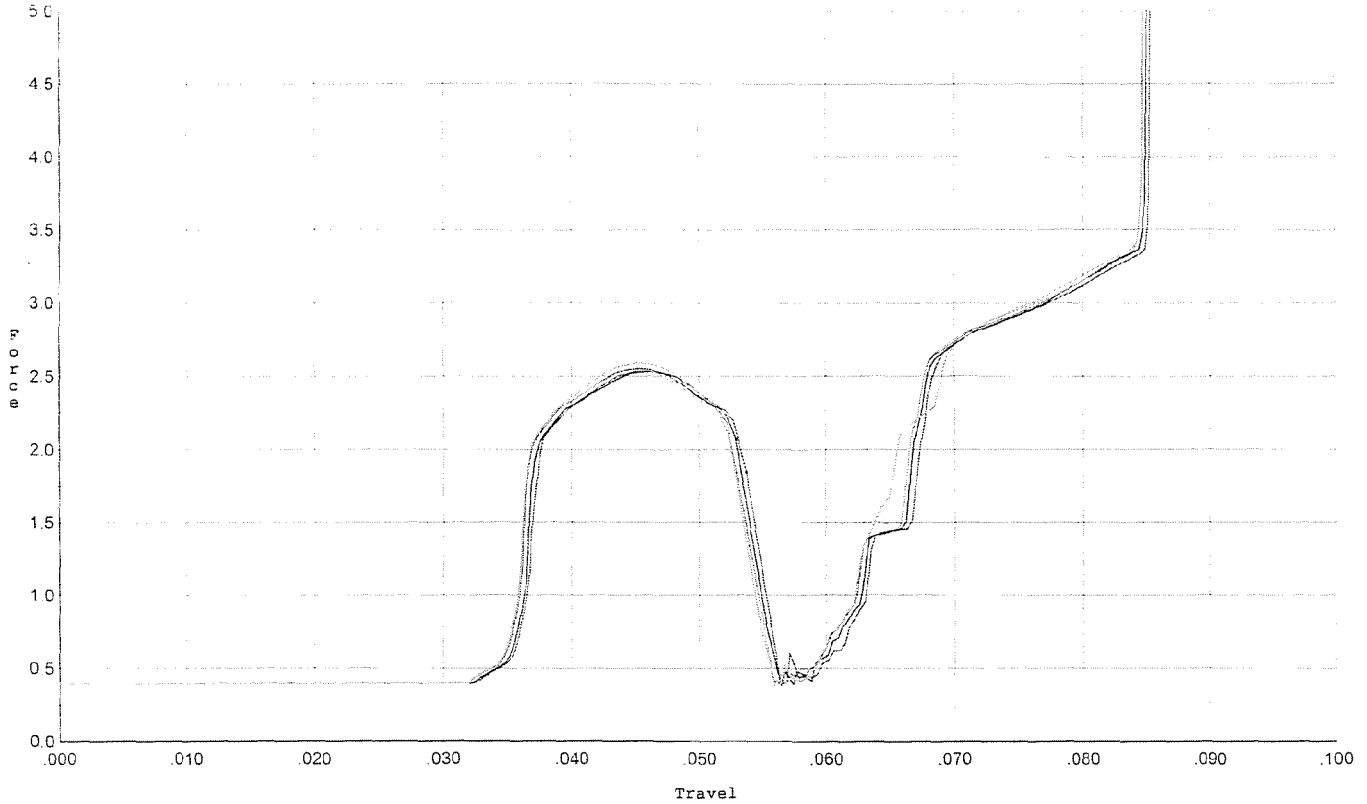
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.028	0.052	0.031	0.034	0.081		Set Trigger
2	4.039	0.053	0.031	0.034	0.084		Set Trigger
3	3.991	0.052	0.031	0.034	0.081		Set Trigger
4	4.010	0.053	0.031	0.034	0.082		Set Trigger
5	3.987	0.052	0.033	0.034	0.081		Set Trigger

Avg 4.01

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 11/19/08

Model: M/24
 Serial No: Form #F005
 Trigger: reset to 2.5 lbs. +/- .50 lbs. for final test



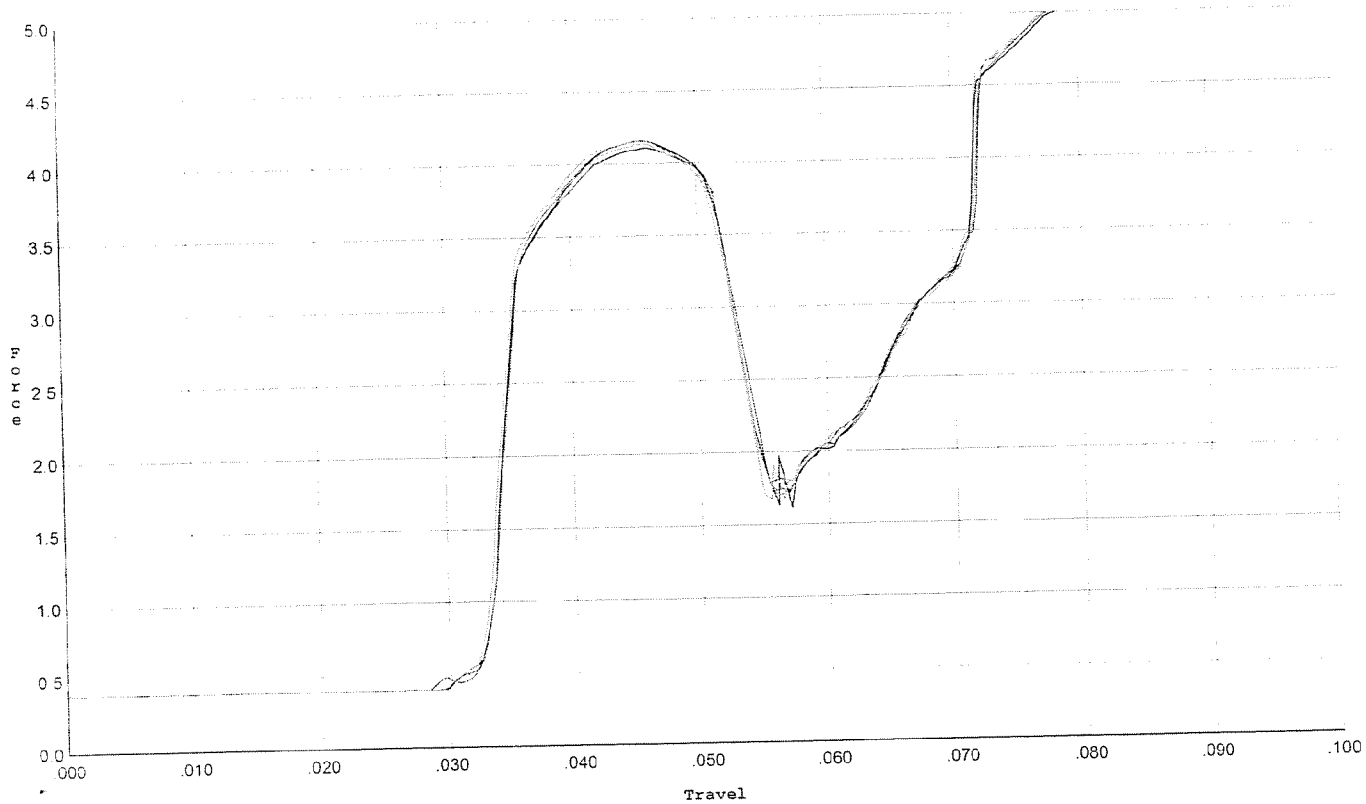
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.529	0.054	0.036	0.037	0.055		Set Trigger
2	2.529	0.053	0.035	0.037	0.054		Set Trigger
3	2.550	0.054	0.035	0.036	0.056		Set Trigger
4	2.588	0.054	0.035	0.036	0.056		Set Trigger
5	2.535	0.052	0.035	0.036	0.054		Set Trigger

Avg 2.54

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 11/19/08

Model: M/24
 Serial No: Form #F005
 Trigger: set to 4.0 lbs. +/- 1.0 lbs. for target & accuracy



#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.106	0.051	0.032	0.034	0.082		Set Trigger
2	4.159	0.051	0.033	0.034	0.083		Set Trigger
3	4.157	0.051	0.033	0.034	0.082		Set Trigger
4	4.131	0.052	0.033	0.034	0.082		Set Trigger
5	4.147	0.052	0.033	0.034	0.084		Set Trigger

Avg 4.14

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6498800. 0
FILE DATE AND TIME: 01/12/2009 07:55

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.058
The Average Y Centroid of the Five Target Set:	-0.003
The Average Point of Impact of the Five Target Set:	0.059
The Average Mean Radius of the Five Target Set:	0.743
The Distance from POA to Centroid Target #1:	0.124
The Distance from Centroid Target #2 to Centroid Target #1:	0.140
The Distance from Centroid Target #3 to Centroid Target #1:	0.150
The Distance from Centroid Target #4 to Centroid Target #1:	0.103
The Distance from Centroid Target #5 to Centroid Target #1:	0.189

SERIAL NUMBER: C6498800. 0

TARGET NUMBER: 1

FILE DATE: 01/12/2009

FILE TIME: 07:55

X CENTROID: -0.084

Y CENTROID: 0.092

POA TO CENTROID: 0.124

HORZ SPREAD: 1.119

VERT SPREAD: 2.404

GROUP SPREAD: 2.486

MIN RADIUS: 0.156

MAX RADIUS: 1.738

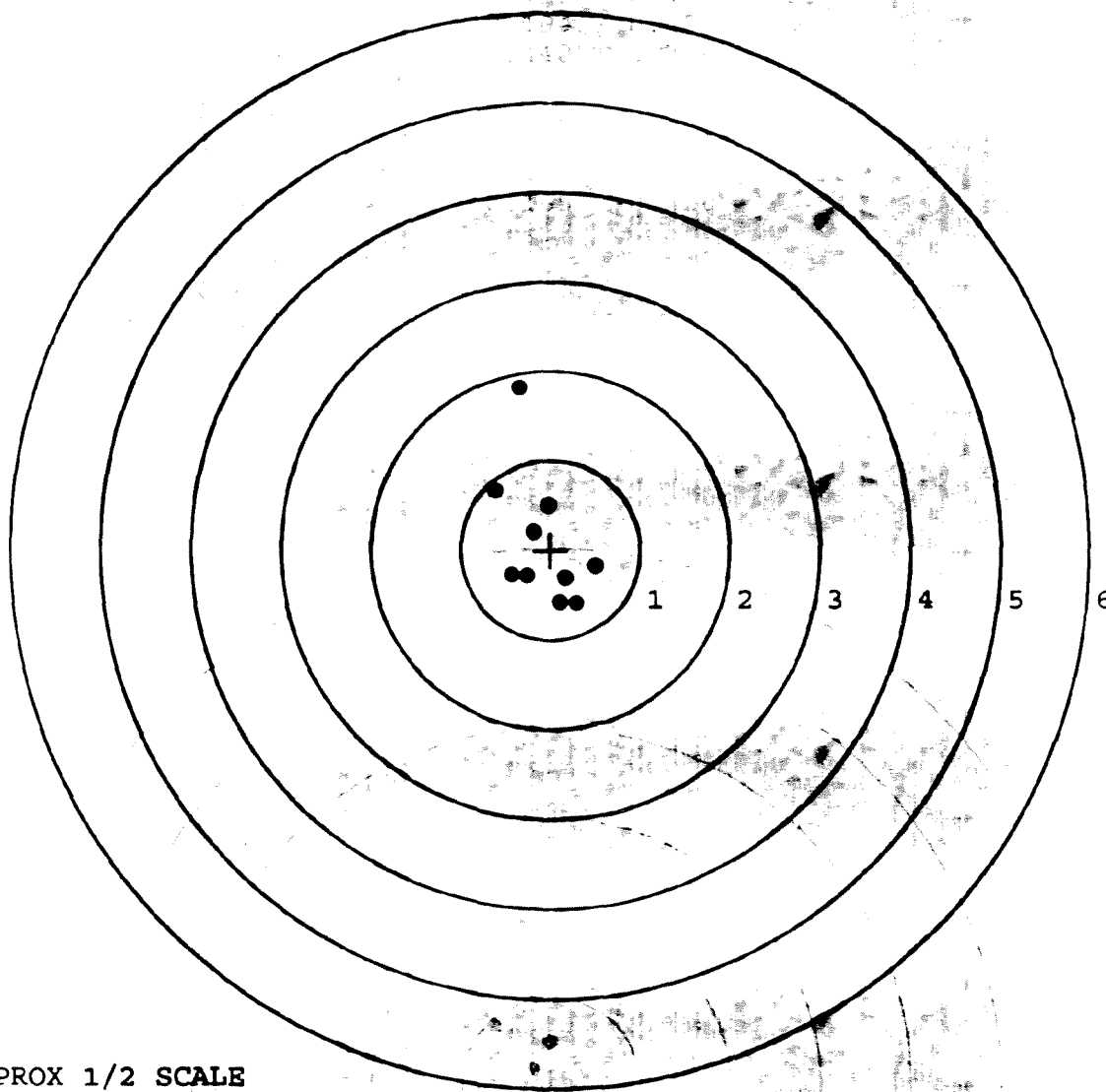
MEAN RADIUS: 0.663

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 9

POINT#	X	Y
1:	-0.348	1.809
2:	-0.617	-0.660
3:	-0.029	0.498
4:	-0.194	0.202
5:	-0.440	-0.276
6:	-0.269	-0.289
7:	0.502	-0.185
8:	0.285	-0.595
9:	0.102	-0.589
10:	0.165	-0.320



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6498800. _0

TARGET NUMBER: 2

FILE DATE: 01/12/2009

FILE TIME: 07:55

X CENTROID: -0.183

Y CENTROID: -0.008

POA TO CENTROID: 0.184

HORZ SPREAD: 1.970

VERT SPREAD: 2.151

GROUP SPREAD: 2.917

MIN RADIUS: 0.164

MAX RADIUS: 1.553

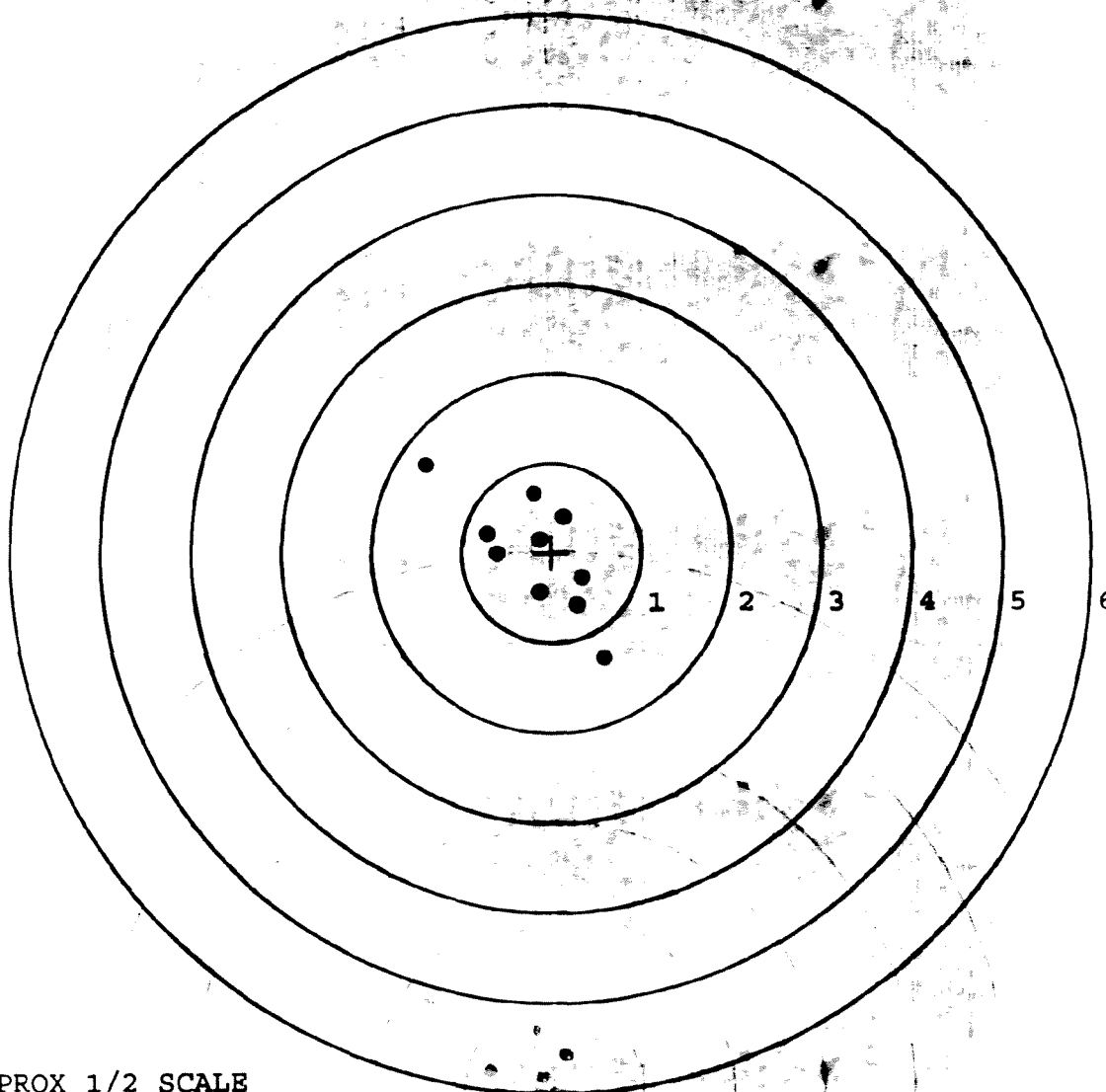
MEAN RADIUS: 0.708

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 9

POINT#	X	Y
1:	-1.387	0.974
2:	-0.198	0.663
3:	0.139	0.401
4:	-0.717	0.220
5:	-0.613	-0.007
6:	-0.129	0.147
7:	-0.136	-0.441
8:	0.283	-0.581
9:	0.340	-0.274
10:	0.583	-1.177



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6498800. __0

TARGET NUMBER: 3

FILE DATE: 01/12/2009

FILE TIME: 07:55

X CENTROID: -0.028

Y CENTROID: -0.048

POA TO CENTROID: 0.055

HORZ SPREAD: 2.357

VERT SPREAD: 1.937

GROUP SPREAD: 2.458

MIN RADIUS: 0.219

MAX RADIUS: 1.592

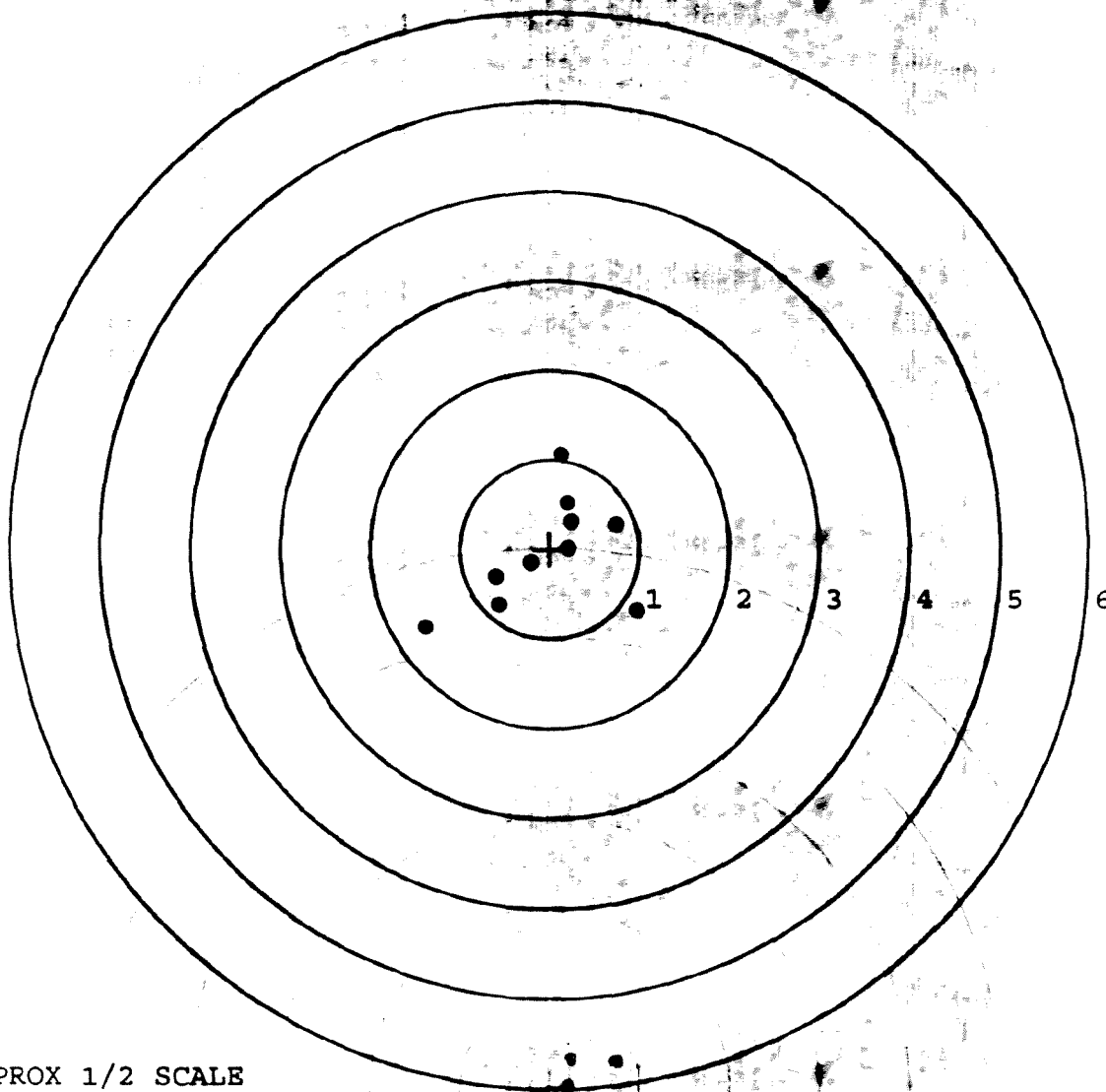
MEAN RADIUS: 0.769

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 9

POINT#	X	Y
1:	0.131	1.054
2:	0.195	0.526
3:	0.736	-0.287
4:	0.974	-0.686
5:	0.211	0.010
6:	-0.219	-0.155
7:	-0.601	-0.316
8:	-0.571	-0.629
9:	-1.383	-0.883
10:	0.245	0.314



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6498800. __0

TARGET NUMBER: 4

FILE DATE: 01/12/2009

FILE TIME: 07:55

X CENTROID: -0.017

Y CENTROID: 0.013

POA TO CENTROID: 0.022

HORZ SPREAD: 2.312

VERT SPREAD: 1.825

GROUP SPREAD: 2.327

MIN RADIUS: 0.618

MAX RADIUS: 1.414

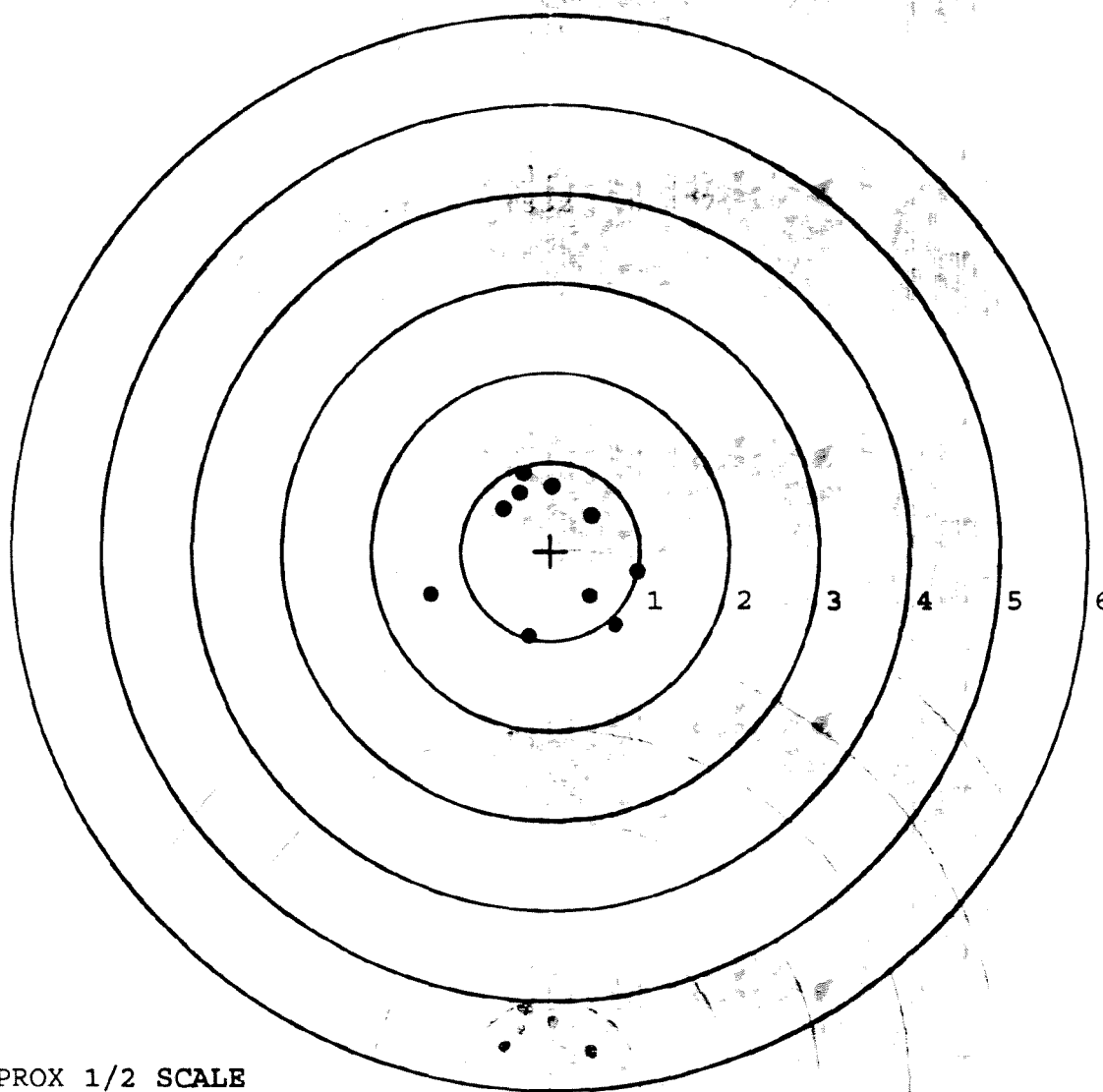
MEAN RADIUS: 0.889

IN 1 IN DIAMETER: 0

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-1.338	-0.491
2:	-0.252	-0.948
3:	0.721	-0.824
4:	0.436	-0.509
5:	0.974	-0.230
6:	0.462	0.403
7:	0.015	0.723
8:	-0.310	0.877
9:	-0.347	0.655
10:	-0.532	0.477



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6498800. 0

TARGET NUMBER: 5

FILE DATE: 01/12/2009

FILE TIME: 07:55

X CENTROID: 0.021

Y CENTROID: -0.066

POA TO CENTROID: 0.069

HORZ SPREAD: 1.573

VERT SPREAD: 1.903

GROUP SPREAD: 1.947

MIN RADIUS: 0.131

MAX RADIUS: 1.129

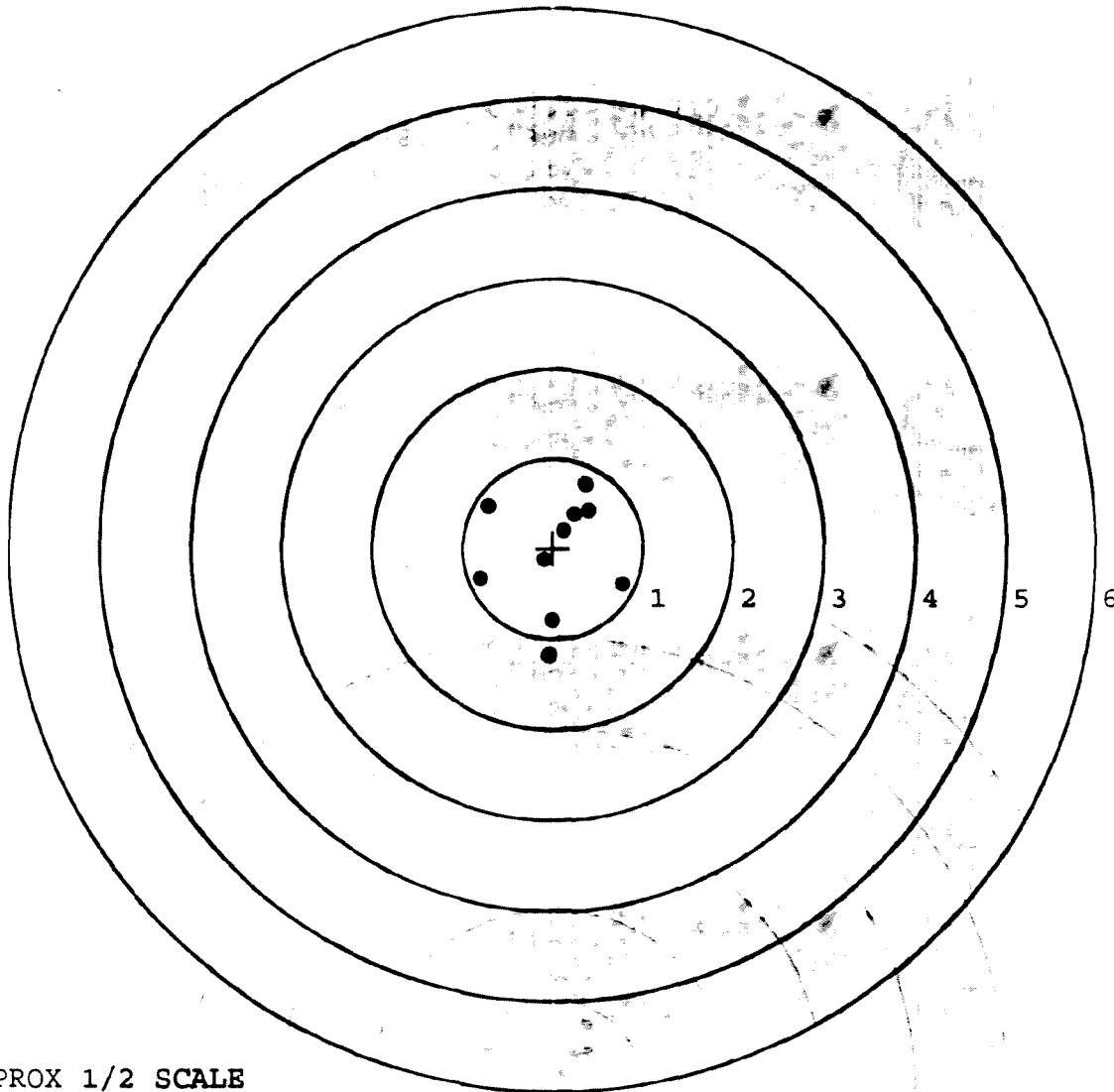
MEAN RADIUS: 0.684

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.714	0.473
2:	-0.802	-0.336
3:	-0.095	-0.127
4:	-0.049	-1.193
5:	-0.017	-0.801
6:	0.771	-0.394
7:	0.361	-0.710
8:	0.397	0.426
9:	0.117	0.198
10:	0.239	0.386



TARGET APPROX 1/2 SCALE

Arm 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: **RE00092212** Serial: C6498800 Model: M24 SWS Center Fire Caliber: 7.62 NATO Produced: 06/19/1990 Repairman: Status: Closed 2/1/2005 7:06:13 AM

Verify Repair

Address Information

Customer: ☒ Received From Return To: ☐ Received From

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

Address 1: Address 2: P.O. Box: P.O. Box:

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

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

FFL: ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐

Contact / Condition Problems Estimate History / Status Shipping / Billing

Contact Information

Phone: Fax: Email: Comments:

Received Condition

Condition: **Good**

Notes: CSR Notes:

Accessories Received

Code	Desc	Qty
A007	With Stud	3
A017	Scope Base	1
A026	Scope	1
A057	Front and Rear Sgt Base	1

Repair Search Refresh Close

negletj 2/7/2005 11:08 AM CAPS NUM INS SCPL

start 3 3 M 9

Serial Number: **C6498800**

Model: **M24 SWS**



RE00092212

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: ~~C6498800~~ ^{C6498800}__0

FILE DATE AND TIME: 08/10/2005 09:10

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.018
The Average Y Centroid of the Five Target Set:	0.034
The Average Point of Impact of the Five Target Set:	0.039
The Average Mean Radius of the Five Target Set:	0.970
The Distance from POA to Centroid Target #1:	0.128
The Distance from Centroid Target #2 to Centroid Target #1:	0.503
The Distance from Centroid Target #3 to Centroid Target #1:	0.213
The Distance from Centroid Target #4 to Centroid Target #1:	0.073
The Distance from Centroid Target #5 to Centroid Target #1:	0.200

SERIAL NUMBER: C6498808. __0

TARGET NUMBER: 1

FILE DATE: 08/10/2005

FILE TIME: 09:10

X CENTROID: -0.117

Y CENTROID: 0.051

POA TO CENTROID: 0.128

HORZ SPREAD: 3.315

VERT SPREAD: 2.920

GROUP SPREAD: 3.807

MIN RADIUS: 0.441

MAX RADIUS: 2.258

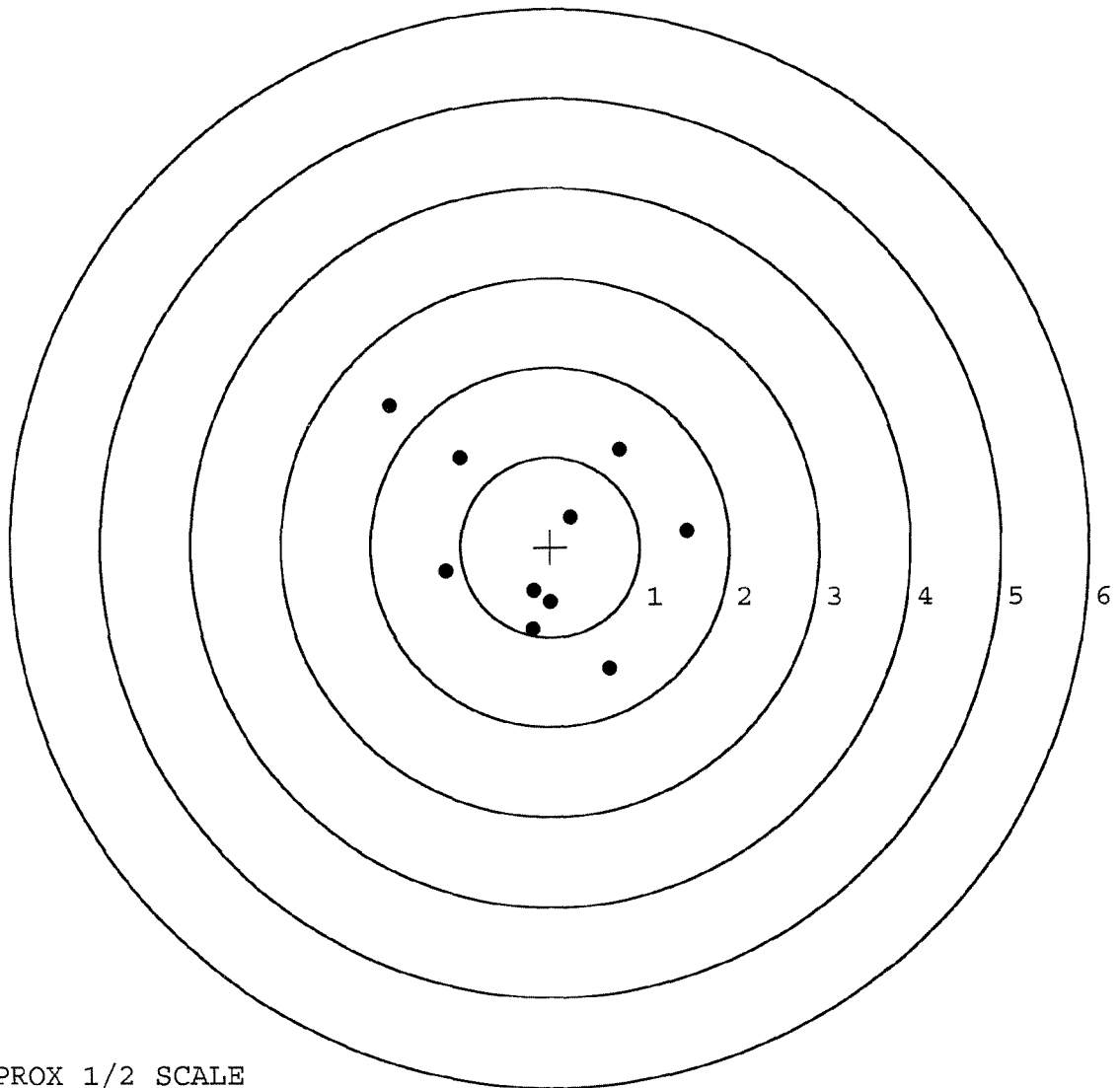
MEAN RADIUS: 1.187

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 4

in 3 IN DIAMETER: 7

POINT#	X	Y
1:	-0.007	-0.608
2:	0.654	-1.351
3:	-0.203	-0.916
4:	-1.162	-0.276
5:	0.226	0.328
6:	0.777	1.081
7:	-1.004	0.989
8:	1.526	0.177
9:	-1.789	1.569
10:	-0.188	-0.480

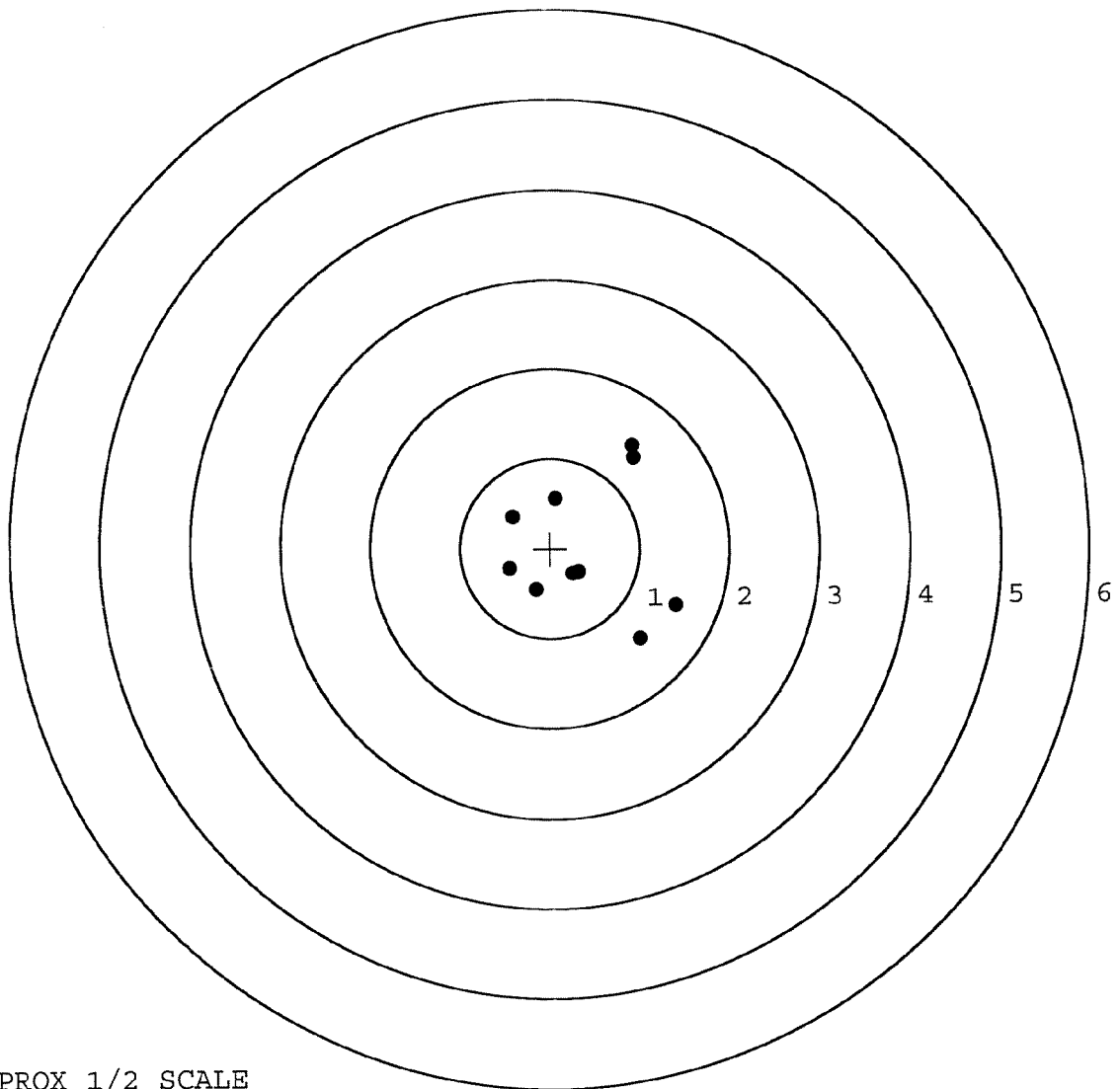


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6498808. __0
 TARGET NUMBER: 2
 FILE DATE: 08/10/2005
 FILE TIME: 09:10

POINT#	X	Y
1:	0.315	-0.262
2:	-0.164	-0.460
3:	-0.459	-0.226
4:	-0.414	0.356
5:	0.062	0.554
6:	0.999	-1.007
7:	1.400	-0.643
8:	0.937	1.003
9:	0.922	1.138
10:	0.251	-0.285

X CENTROID: 0.385
 Y CENTROID: 0.017
 POA TO CENTROID: 0.385
 HORZ SPREAD: 1.859
 VERT SPREAD: 2.145
 GROUP SPREAD: 2.146
 MIN RADIUS: 0.287
 MAX RADIUS: 1.243
 MEAN RADIUS: 0.850
 # IN 1 IN DIAMETER: 2
 # IN 2 IN DIAMETER: 6
 # in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6498808. 0

TARGET NUMBER: 3

FILE DATE: 08/10/2005

FILE TIME: 09:10

X CENTROID: -0.246

Y CENTROID: 0.220

POA TO CENTROID: 0.330

HORZ SPREAD: 2.510

VERT SPREAD: 3.153

GROUP SPREAD: 3.263

MIN RADIUS: 0.094

MAX RADIUS: 1.910

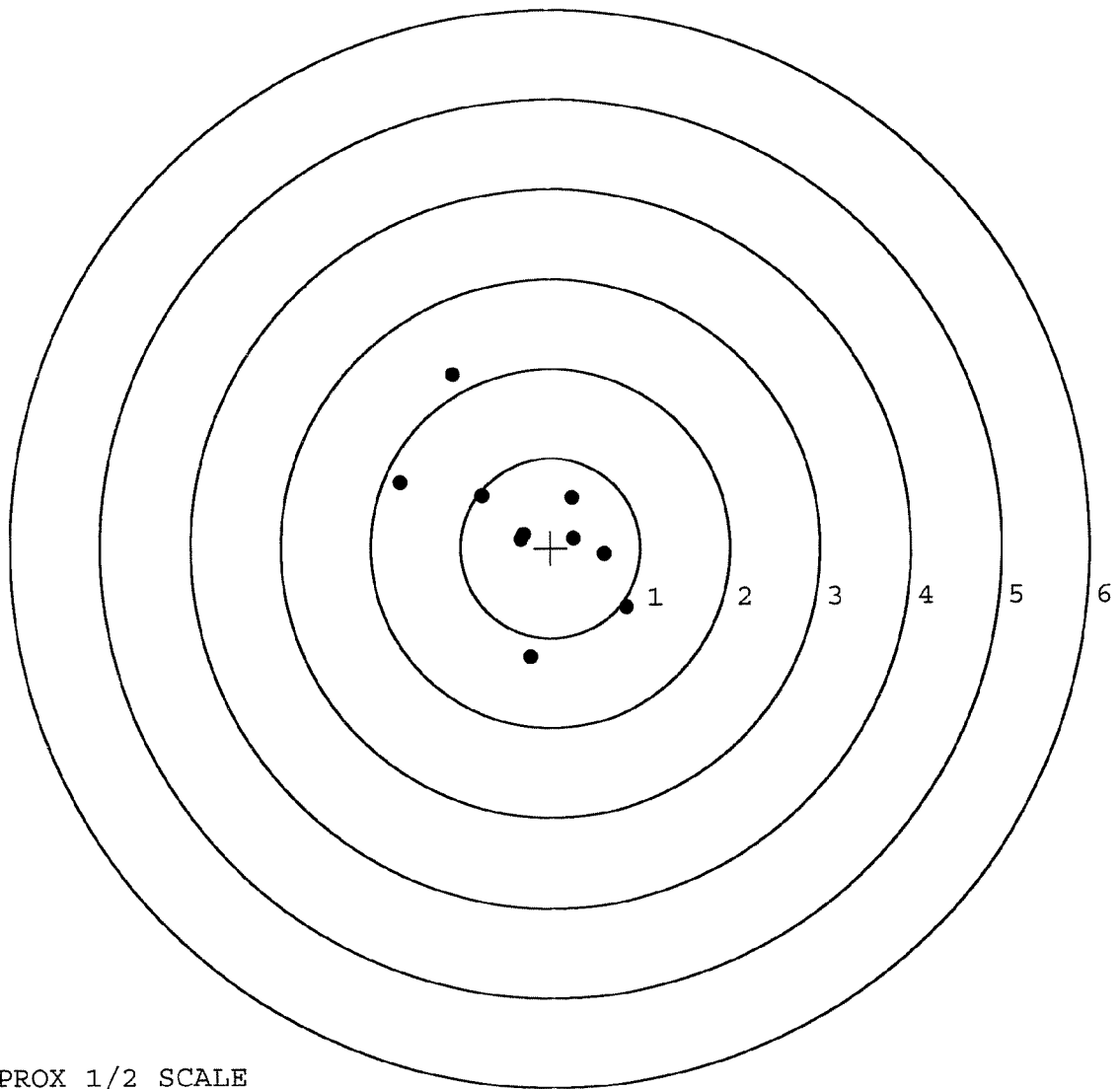
MEAN RADIUS: 0.914

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 8

POINT#	X	Y
1:	0.840	-0.664
2:	0.597	-0.072
3:	-0.336	0.095
4:	-0.238	-1.214
5:	-0.766	0.582
6:	-1.670	0.729
7:	-1.080	1.939
8:	-0.305	0.147
9:	0.242	0.556
10:	0.257	0.106



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6498808. __0

TARGET NUMBER: 4

FILE DATE: 08/10/2005

FILE TIME: 09:10

X CENTROID: -0.049

Y CENTROID: 0.024

POA TO CENTROID: 0.055

HORZ SPREAD: 1.647

VERT SPREAD: 1.999

GROUP SPREAD: 2.421

MIN RADIUS: 0.536

MAX RADIUS: 1.353

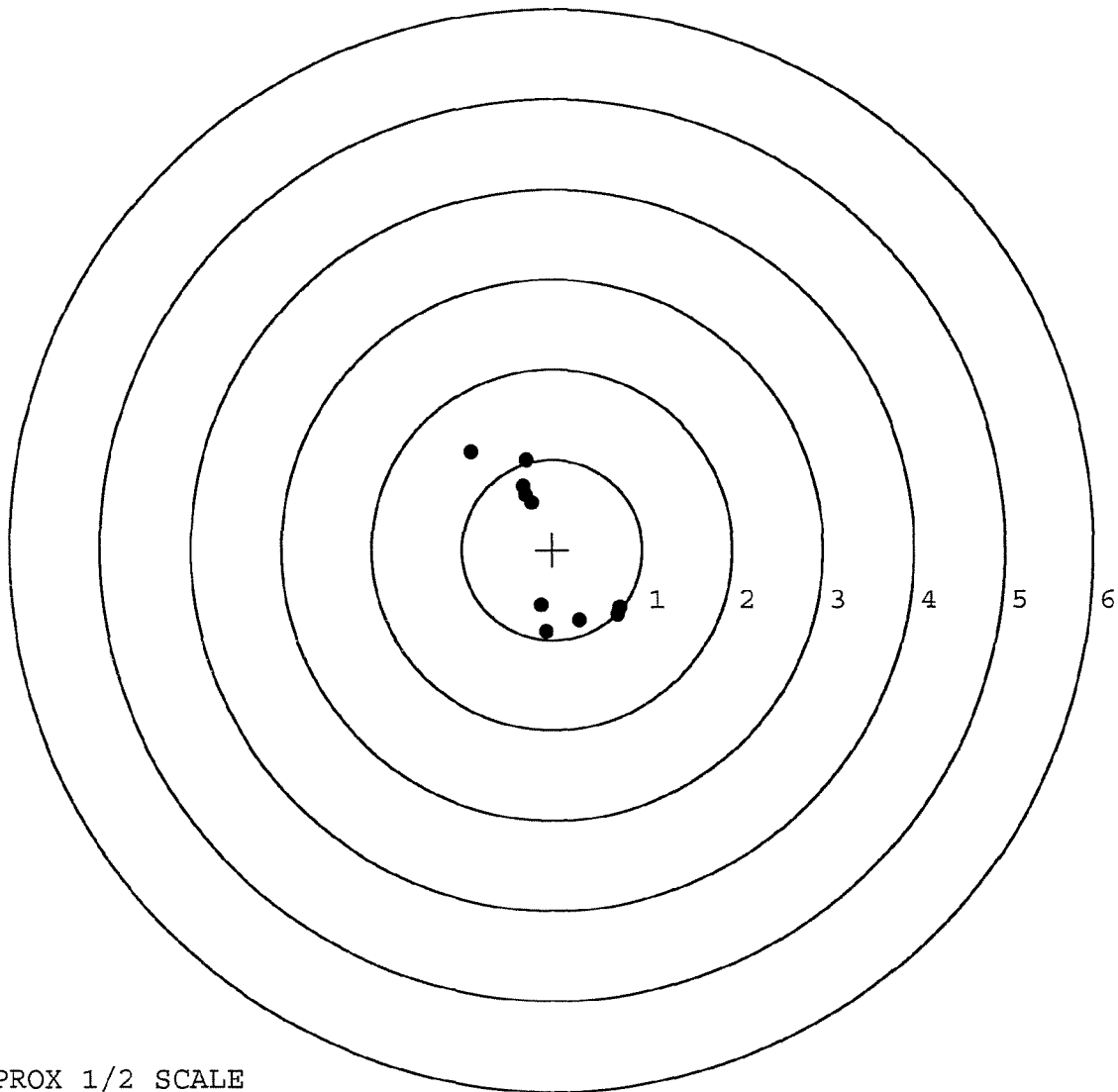
MEAN RADIUS: 0.884

IN 1 IN DIAMETER: 0

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.726	-0.717
2:	0.296	-0.781
3:	-0.079	-0.918
4:	-0.127	-0.619
5:	-0.895	1.081
6:	-0.293	0.990
7:	-0.240	0.525
8:	-0.330	0.703
9:	-0.305	0.613
10:	0.752	-0.635

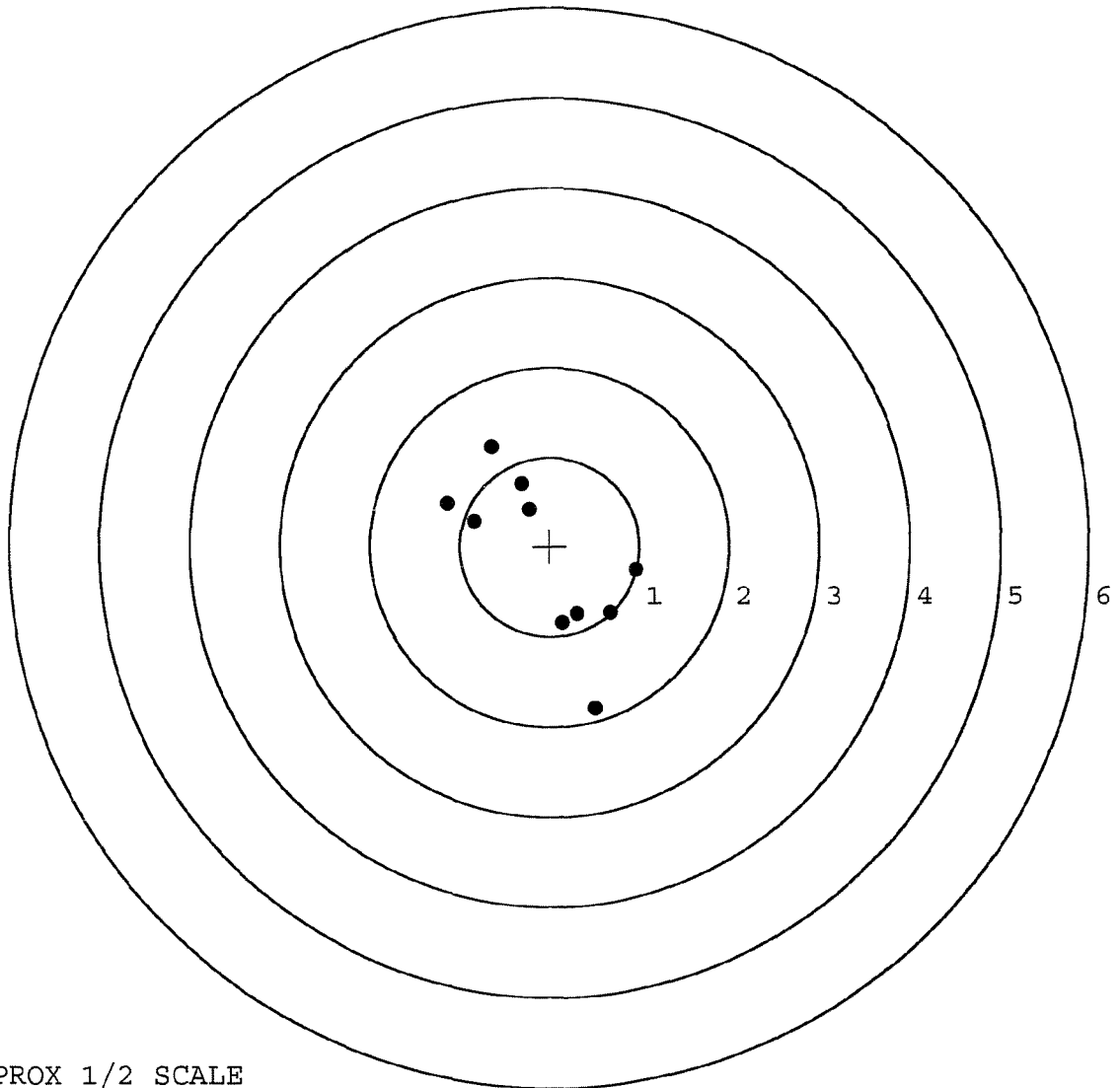


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6498808. __0
 TARGET NUMBER: 5
 FILE DATE: 08/10/2005
 FILE TIME: 09:10

X CENTROID: -0.061
 Y CENTROID: -0.141
 POA TO CENTROID: 0.153
 HORZ SPREAD: 2.107
 VERT SPREAD: 2.911
 GROUP SPREAD: 3.130
 MIN RADIUS: 0.583
 MAX RADIUS: 1.747
 MEAN RADIUS: 1.016
 # IN 1 IN DIAMETER: 0
 # IN 2 IN DIAMETER: 6
 # in 3 IN DIAMETER: 9

POINT#	X	Y
1:	-0.647	1.116
2:	-0.314	0.703
3:	-0.238	0.415
4:	-1.145	0.474
5:	-0.841	0.285
6:	0.672	-0.740
7:	0.138	-0.852
8:	0.502	-1.795
9:	0.304	-0.750
10:	0.962	-0.264



TARGET APPROX 1/2 SCALE

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

R. & E NUMBER	92212		
SERIAL NUMBER	C649 8800		
LOG-IN DATE	2-1-05		
INSPECT AND VERIFY:			
OPERATION #	OPERATION NAME	DATE	INITIAL
550	DIS-ASSEMBLE GUN	6-15-05	RTZ
560 A	RE-BARREL	6-20-05	RTZ
B	DRILL AND TAP	6-22-05	TRW
575	ASSEMBLE	6-20-05	RTZ
600	PROOF	6-22-05	RTZ
605	CHECK HEADSPACE	6-22-05	RTZ
610	DIS-ASSEMBLE GUN	6-22-05	RTZ
612	MAGNAFLUX	6/23/05	unus
615	ROLLMARK CALIBER	6-23-05	CW
618	ROTO-BLAST	7/7/05	JS
620	APPLY COATINGS	7-18-05	W
625 A	FINAL ASSEMBLY	8-8-05	
B	TRIGGER PULL TEST		
C	SAFETY "ON" FORCE	8-16-05	AC
D	SAFETY "OFF" FORCE	8-16-05	AC
E	FIRING PIN INDENT	8-16-05	AC
640	TARGET	8-10-05	AC
655	FINAL INSPECT	8-16-05	AC
660	PACK	9-19-05	DA
		SHIP DATE	
		QAR INSPECTION DATE	

Remington



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

MODEL 700™ M24

SERIAL NO.

C6498800

ORDER NO.

5716

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

01



5716 C6498800

UPC



0 47700 25716 7

BARBER - M24 0007967

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

BARBER - M24 000796708006

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6498800

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		5/17/90	RW
600	Proof		5/17/90	RW
607	Check Headspace		5/17/90	RW
610	Dis-assemble Gun		5/17/90	RW
612	Magnaflux Barrel Action		5/22/90	KCR
	Magnaflux Bolt		5/22/90	KCR
615	Rollmark Caliber		6/22/90	CS
617	Drill and Tap Sight Holes		5/23/90	FB
618	Polish Barrel RB		5/24/90	WB
620	Apply Coatings (Barrel Action)		6/4/90	HA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		6/4/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		6/4/90	RW
	C) Inspect Ejector Hole for Chamfer		6/4/90	RW
	D) Oil Firing Pin Ass'y		6/4/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		6/8/90	SH

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	3	3	3			6/12/90	JH
	G) Safety Off Force	3	3	3			6/12/90	JH
	H) Trigger Pull Test & Retainability						6/9/90	JH
	I) Firing Pin Indent	.0225	.023	.023			6/11/90	WB
	J) Assemble Stock						6/13/90	RW
	K) Assemble Swivel Studs						6/18/90	WB
	L) Attach Front and Rear Sight Assemblies						6/13/90	RW
	M) Iron Sight Alignment						6/13/90	RW
	N) Detach Front & Rear Sights & place in numbered container						6/13/90	RW
	O) Attach Scope to Rifle						6/13/90	JH
	P) Detach & Attach Scope 20 Times						6/13/90	JH
640	Gallery Target & Test						6-14-90	AC
	A) Time						6-14-90	AC
	B) Malfunctions						6-14-90	AC
	C) Pierced Primers						6-14-90	AC
	D) Optical Clarity of Scope						6-14-90	AC
645	Inspect for Live Ammo						6-14-90	AC
655	Final Inspection						6/18/90	WB
	A) Headspace							
	B) Trigger Pull	2.45	2.35	2.35	2.36	2.37	6/18/90	RW
	C) Function						6/18/90	WB
660	Pack						6-19-90	DH

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C6498800

DATE 6/9/90

TESTER JL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.31	2.21	2.40	2.45	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.22	2.41	2.44	2.35	
PULL #3	2.34	2.41	2.35	2.35	
PULL #4	2.29	2.45	2.45	2.36	
PULL #5	2.30	2.39	2.38	2.37	
TOTAL	11.46	11.87	12.02	11.88	
AVG.	2.292	2.374	2.404	2.38	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.49	3.43		
PULL #2	3.50	3.37		
PULL #3	3.43	3.59		
PULL #4	3.29	3.37		
PULL #5	3.37	3.37		
TOTAL	17.08	16.93		
AVG.	3.416	3.386		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.14	4.47		4.41
PULL #2	4.21	4.45		4.41
PULL #3	4.45	4.39		4.22
PULL #4	4.34	4.37		4.31
PULL #5	4.50	4.43		4.30
TOTAL	21.64	22.11		21.65
AVG.	4.328	4.422		4.33

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6498800
18 Jun 1990

CENTROIDAL DISTANCES

0 TO	1	.675077
1 TO	2	.0730068
1 TO	3	.469707
1 TO	4	.943274
1 TO	5	.668225

$\bar{x}$ <----POA
 $\bar{y}$
 4

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1836
 THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.3996
 THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .43976
 THE AMR FOR THIS RIFLE IS: .8144

15 Jun 1998

FILE:/PATTERNING/CENTERFIRE_PATT/06498080

CENTERFIRE PATTERNS

1

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS = 10

IN CIR

1in = 2

2in = 4

3in = 10

HS = 2.100

VS = 2.297

GS = 2.433

PATTERN #	:	1	2	3
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.906	.851	.904
MINIMUM X	:	-1.194	-1.249	-1.196
MAXIMUM Y	:	1.261	1.390	1.026
MINIMUM Y	:	-1.036	-.895	-.722
CENTROID X	:	.505	.560	.507
CENTROID Y	:	-.448	-.589	-.762
POA TO CENTROID in.	:	.676	.812	.916
MIN RADIUS	:	.095	.131	.247
MEAN RADIUS	:	.937	.873	.795
MAX RADIUS	:	1.353	1.452	1.367
HORIZONTAL SPREAD	:	2.100	2.100	2.100
VERTICAL SPREAD	:	2.297	2.285	1.748
EXTREME SPREAD	:	2.433	2.428	2.413
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	4		
NUMBER IN THREE INCH CIRCLE	=	10		

15 Jun 1998

FILE:/PATTERNING/CENTERFIRE_PATT/06498888

CENTERFIRE PATTERNS # 2

POA

1in circle

2in circle

3in circle

CENTROID #

OF SHOTS = 10

IN CIR

1in = 1

2in = 7

3in = 10

HS = 1.996

VS = 1.707

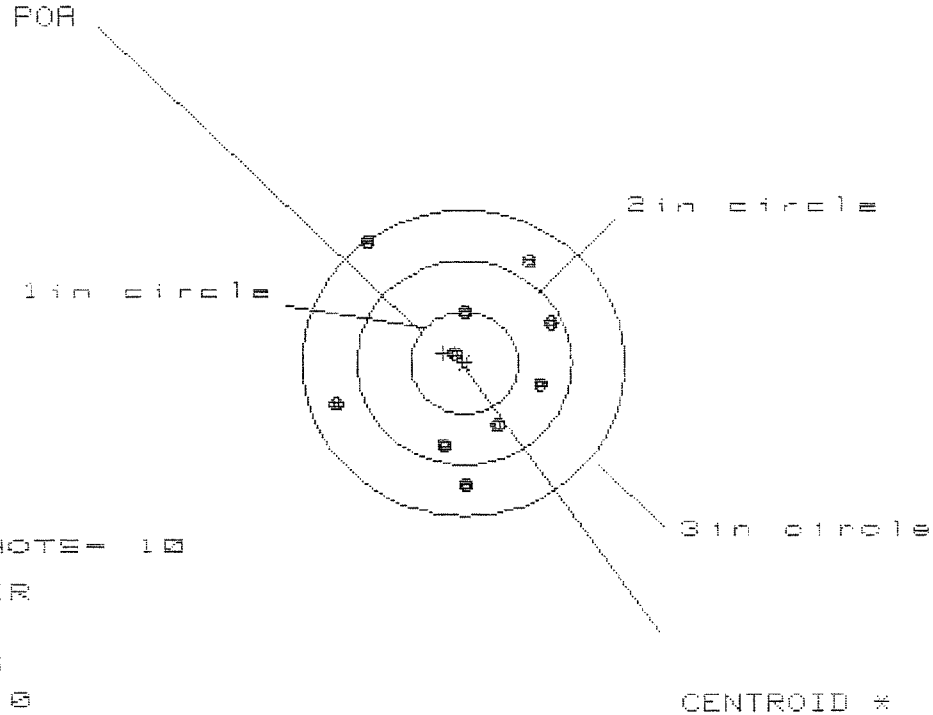
GS = 2.411

PATTERN #	2	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.149	.871	.781
MINIMUM X	-.847	-.719	-.683
MAXIMUM Y	.920	.861	.956
MINIMUM Y	-.787	-.846	-.751
CENTROID X	.462	.334	.424
CENTROID Y	-.507	-.448	-.543
POA TO CENTROID in.	.686	.559	.689
MIN RADIUS	.252	.291	.204
MEAN RADIUS	.851	.797	.750
MAX RADIUS	1.266	1.049	1.015
HORIZONTAL SPREAD	1.996	1.590	1.464
VERTICAL SPREAD	1.707	1.707	1.707
EXTREME SPREAD	2.411	2.072	1.884
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	10		

15 Jun 1990

FILE:/PATTERNING/CENTERFIRE_PATT/C64968800

CENTERFIRE PATTERNS # 3



OF SHOTS - 10

IN CIR

1 in = 1

2 in = 6

3 in = 10

HS = 2.061

VS = 2.379

GS = 2.530

PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	.831
MINIMUM X	-1.230
MAXIMUM Y	1.193
MINIMUM Y	-1.186
CENTROID X	.194
CENTROID Y	-.096
POA TO CENTROID in.	.216
MIN RADIUS	.128
MEAN RADIUS	.900
MAX RADIUS	1.472
HORIZONTAL SPREAD	2.061
VERTICAL SPREAD	2.379
EXTREME SPREAD	2.530
NUMBER IN ONE INCH CIRCLE =	1
NUMBER IN TWO INCH CIRCLE =	6
NUMBER IN THREE INCH CIRCLE =	10

15 Jun 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6496800

CENTERFIRE PATTERNS # 4

POA

1in circle

2in circle

3in circle

OF SHOTS= 10

IN CIR

1in = 2

2in = 10

3in = 10

HS= 1.586

VS= 1.258

GS= 1.693

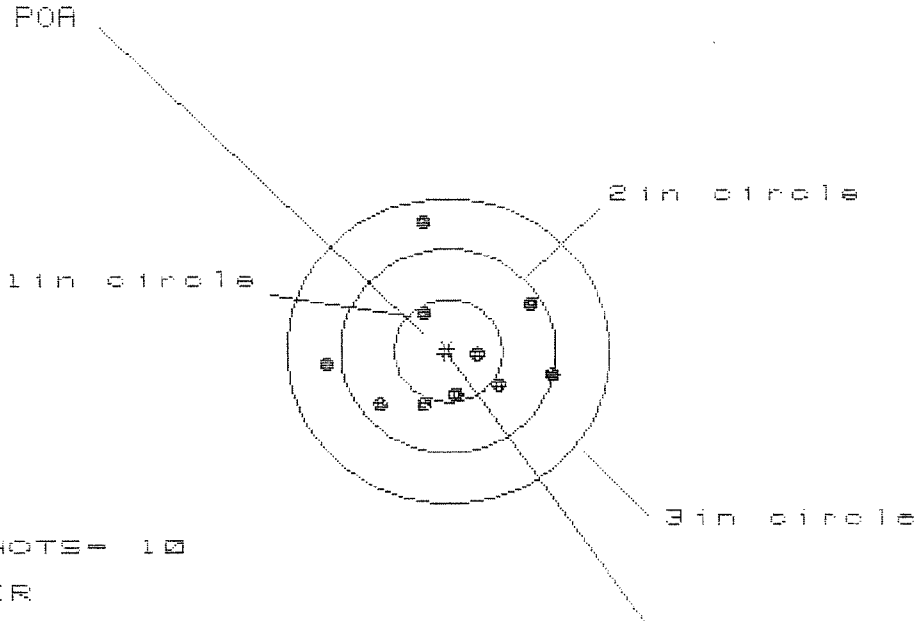
CENTROID *

PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.707	.609	.533
MINIMUM X	-.879	-.725	-.801
MAXIMUM Y	.532	.557	.470
MINIMUM Y	-.726	-.701	-.533
CENTROID X	-.278	-.180	-.104
CENTROID Y	-.974	-.999	-.912
POA TO CENTROID in.	1.013	1.015	.918
MIN RADIUS	.115	.019	.124
MEAN RADIUS	.644	.600	.554
MAX RADIUS	.908	.928	.861
HORIZONTAL SPREAD	1.586	1.334	1.334
VERTICAL SPREAD	1.258	1.258	1.003
EXTREME SPREAD	1.693	1.562	1.545
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		10	
NUMBER IN THREE INCH CIRCLE =		10	

15 Jun 1998

FILE:/PATTERNING/CENTERFIRE_PATT/CG498800

CENTERFIRE PATTERNS # 5



OF SHOTS = 10

IN CIR

1 in = 3

2 in = 8

3 in = 10

HS = 2.084

VS = 1.809

GS = 2.084

CENTROID #

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.932	.911	.765
MINIMUM X	-1.152	-1.173	-1.798
MAXIMUM Y	1.264	.638	.635
MINIMUM Y	-.545	-.404	-.407
CENTROID X	.035	.056	.202
CENTROID Y	.027	-.114	-.111
POA TO CENTROID in.	.044	.127	.231
MIN RADIUS	.305	.271	.181
MEAN RADIUS	.740	.655	.567
MAX RADIUS	1.278	1.173	.879
HORIZONTAL SPREAD	2.084	2.084	1.563
VERTICAL SPREAD	1.809	1.042	1.042
EXTREME SPREAD	2.084	2.084	1.699
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		8	
NUMBER IN THREE INCH CIRCLE =		10	