

C6498828

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5716**

*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: RE00151220

Serial: C6498828 Model M24 SWS Center Fire
Caliber: 7.62 NATO

Repairman:

Status: Closed 9/16/2008 2:27:08 PM

Verify Repair

Address Information

Customer:

☒ Received From

Return To:

☐ Received From

Name: ISD ARMSROOM

ISD ARMSROOM

Address 1: 8TH DESERT STORM

8TH DESERT STORM

Address 2: BLDG 5210 BAY DOOR #30

PO Box:

BLDG 5210 BAY DOOR #30

PO Box:

City: FORT CAMPBELL

FORT CAMPBELL

State: KY

Zip Code: 42223

Country: US

State: KY

Zip Code: 42223

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
A017	Scope Base	1
A057	Fit and Rear Sgt Base	1

Repair Search

Refresh

Close

nagletj

9/16/2008

3:26 PM

CAPS

NUM

INS

SCRL

start

8 M

21

3 M

Ar...

Par...

Eas...

Sto...

9/16/08

3:26 PM

Serial Number: C6498828
Model M24 SWS
RE00151220

M-24 INSPECTION CHECKLIST
CONTRACT # DA44F-20-02-C-0140

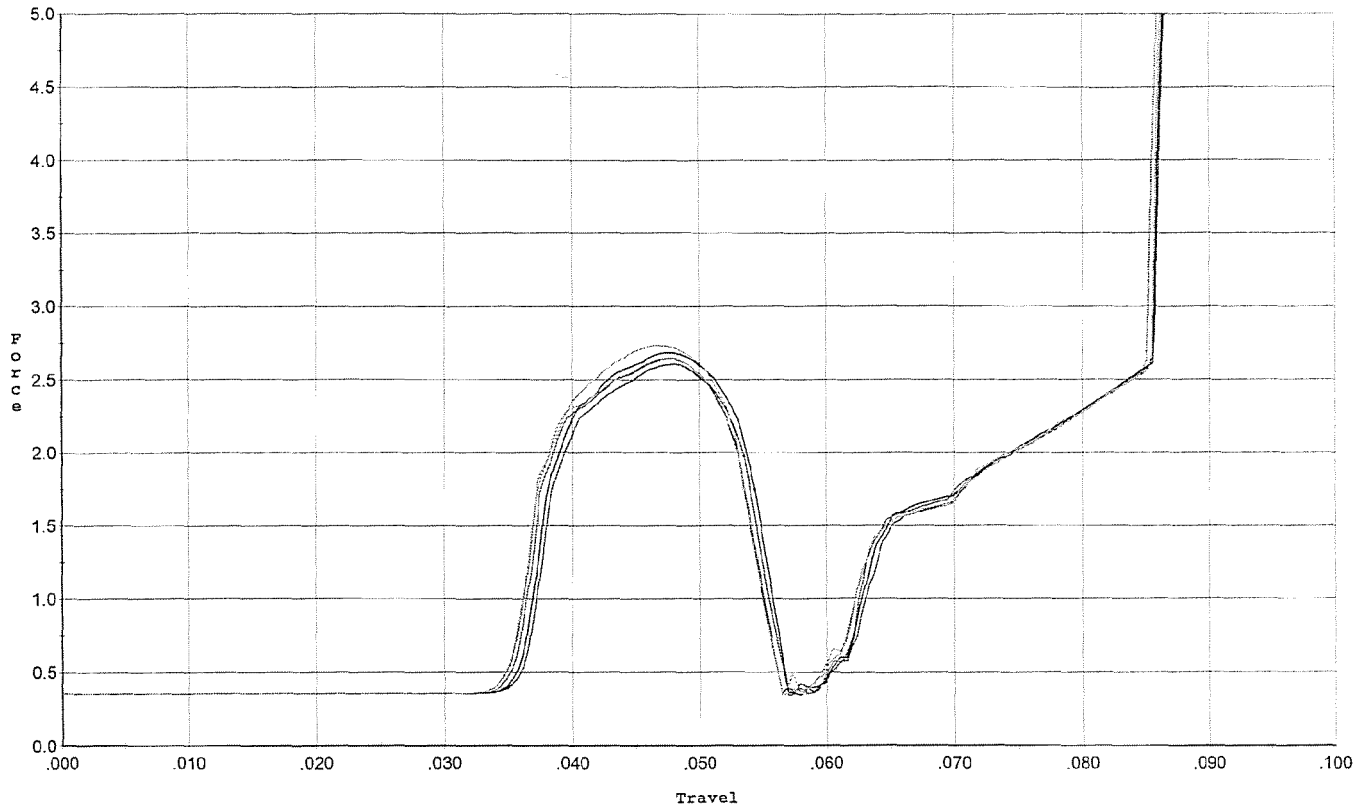
WALNUT: 151220
 SERIAL NUMBER: C6498828
 DATE: 9-16-08

OPERATION #	OPERATION NAME	DATE	INITIAL
590	DIS-ASSEMBLE GUN	9-18-08	RTZ
595	RE-BARREL	9-22-08	RTZ
560	ASSEMBLE	9-22-08	RTZ
600	PROOF	9-22-08	APD
605	CHECK HEADSPACE	9-22-08	APD
610	DIS-ASSEMBLE GUN	9-22-08	APD
612	MAGNAFLUX	9/30/08	RTZ
510	DRILL AND TAP	9-23-08	SL
615	ROLLMARK CALIBER	9/30/08	RT
618	ROTO-BLAST		
620	APPLY COATINGS	10-1	
625	FINAL ASSEMBLY	10-8-08	RTZ
640	FUNCTION TEST AND	10-9-08	TL
650	TARGET	10-9-08	TL
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
670	FINAL INSPECTION	10-9-08	FSW
	A) HEADSPACE	10-22-08	SL
		10-22-08	SL
	B) TRIGGER PULL	2.66 2.56 2.55 2.62 2.55	10-13-08 TL
	C) SAFETY ON FORCE	5.5 5.5 6.0	10-22-08 SL
	D) SAFETY OFF FORCE	5.0 5.0 5.0	10-22-08 SL
	E) FIRING PIN INDENT	.022 .022 .022	10-22-08 SL
690	PACK	10/3/08	FM

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 9/15/08

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



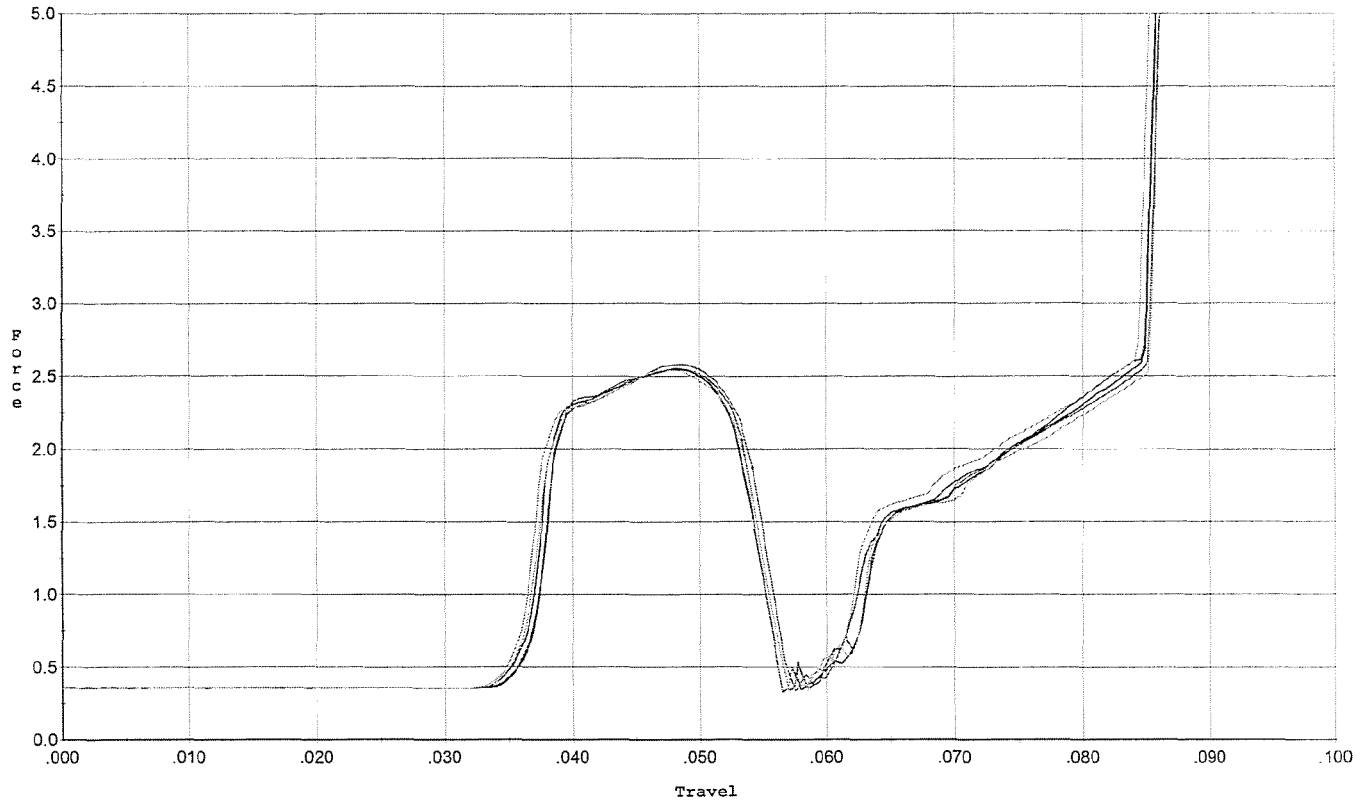
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.607	0.053	0.036	0.038	0.052		Set Trigger
2	2.683	0.054	0.035	0.037	0.055		Set Trigger
3	2.645	0.053	0.035	0.037	0.053		Set Trigger
4	2.639	0.053	0.035	0.037	0.053		Set Trigger
5	2.734	0.055	0.035	0.037	0.056		Set Trigger

Avg 2.66

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 9/15/08

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



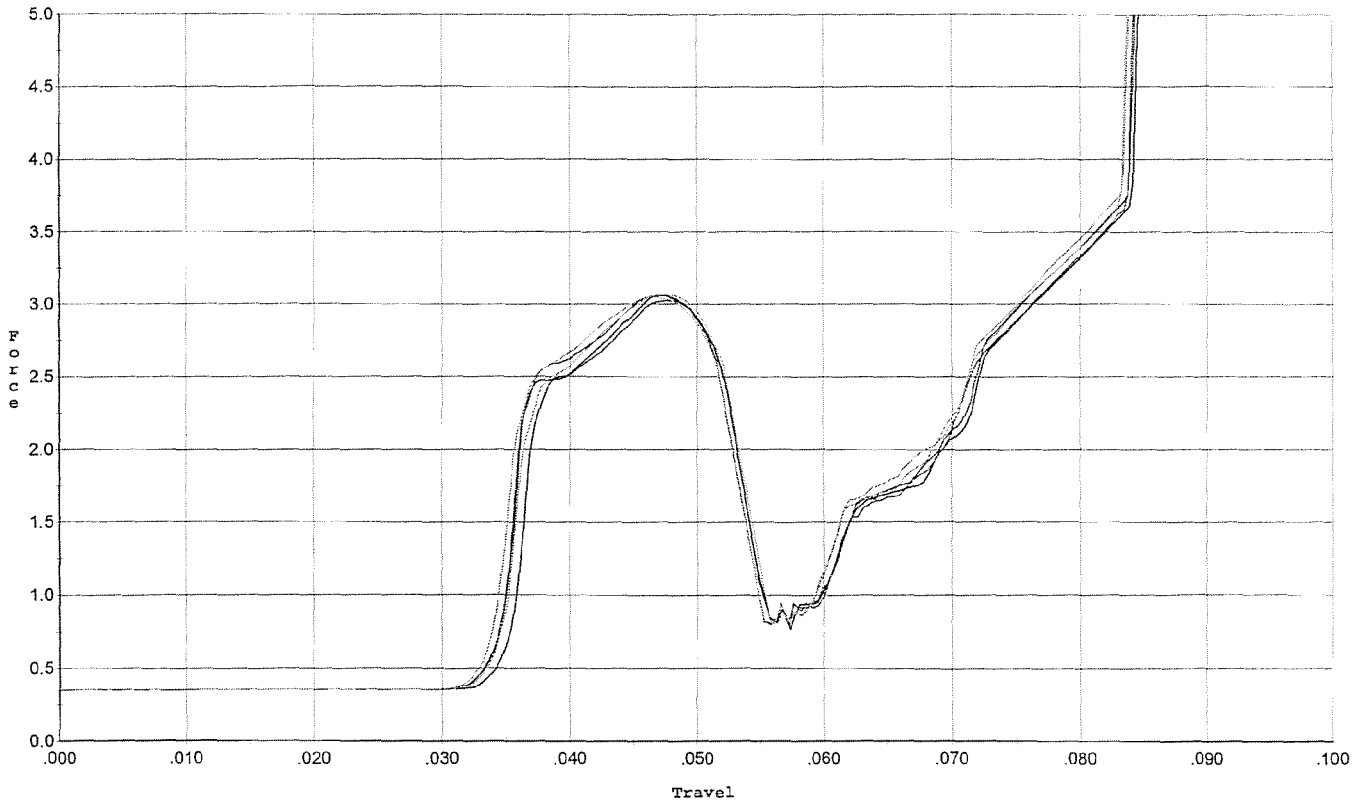
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.552	0.053	0.036	0.037	0.052		Set Trigger
2	2.548	0.054	0.036	0.037	0.053		Set Trigger
3	2.582	0.054	0.036	0.037	0.054		Set Trigger
4	2.545	0.054	0.035	0.037	0.053		Set Trigger
5	2.561	0.054	0.035	0.037	0.054		Set Trigger

Avg 2.55

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 9/15/08

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



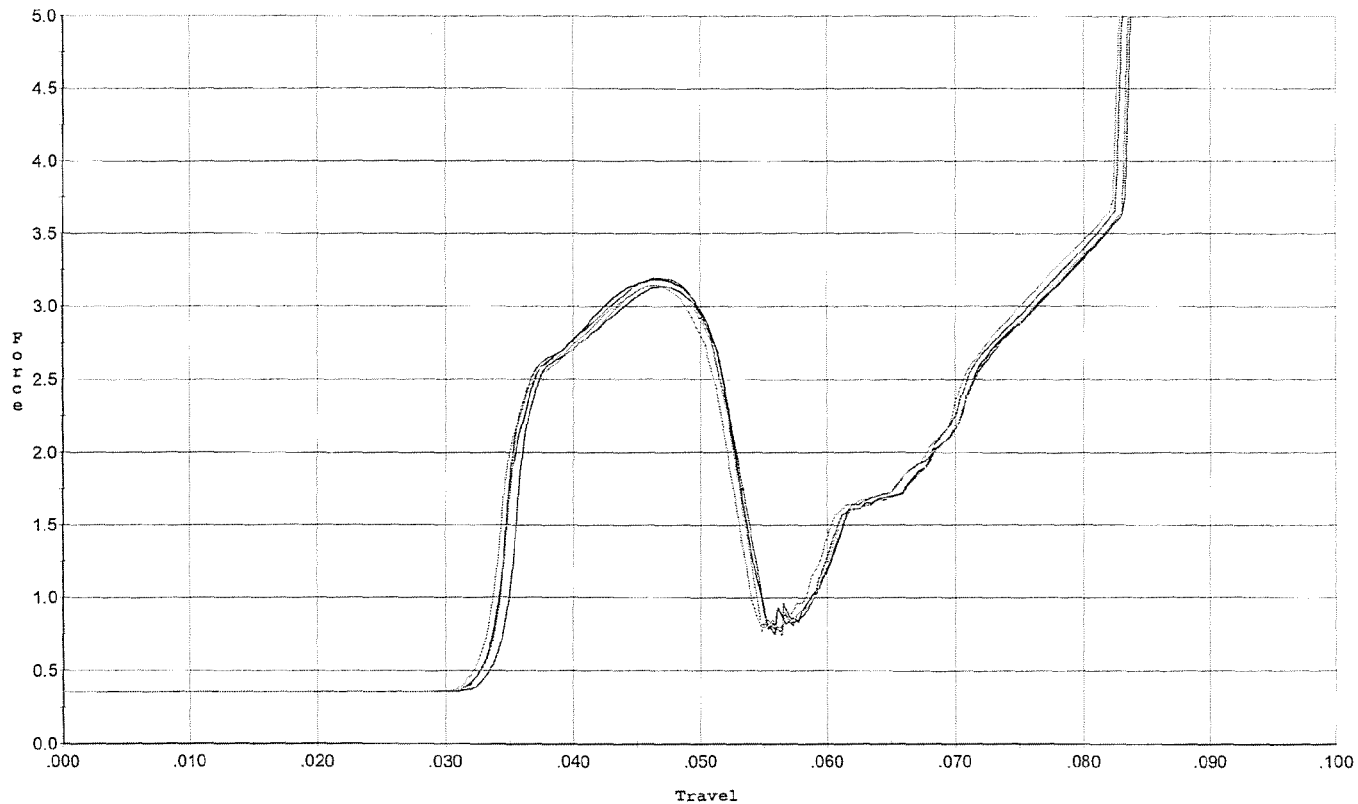
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.026	0.052	0.034	0.036	0.060		Set Trigger
2	3.058	0.052	0.035	0.036	0.058		Set Trigger
3	3.061	0.052	0.034	0.036	0.059		Set Trigger
4	3.069	0.054	0.034	0.035	0.062		Set Trigger
5	3.052	0.052	0.034	0.035	0.060		Set Trigger

Avg 3.05

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 9/15/08

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



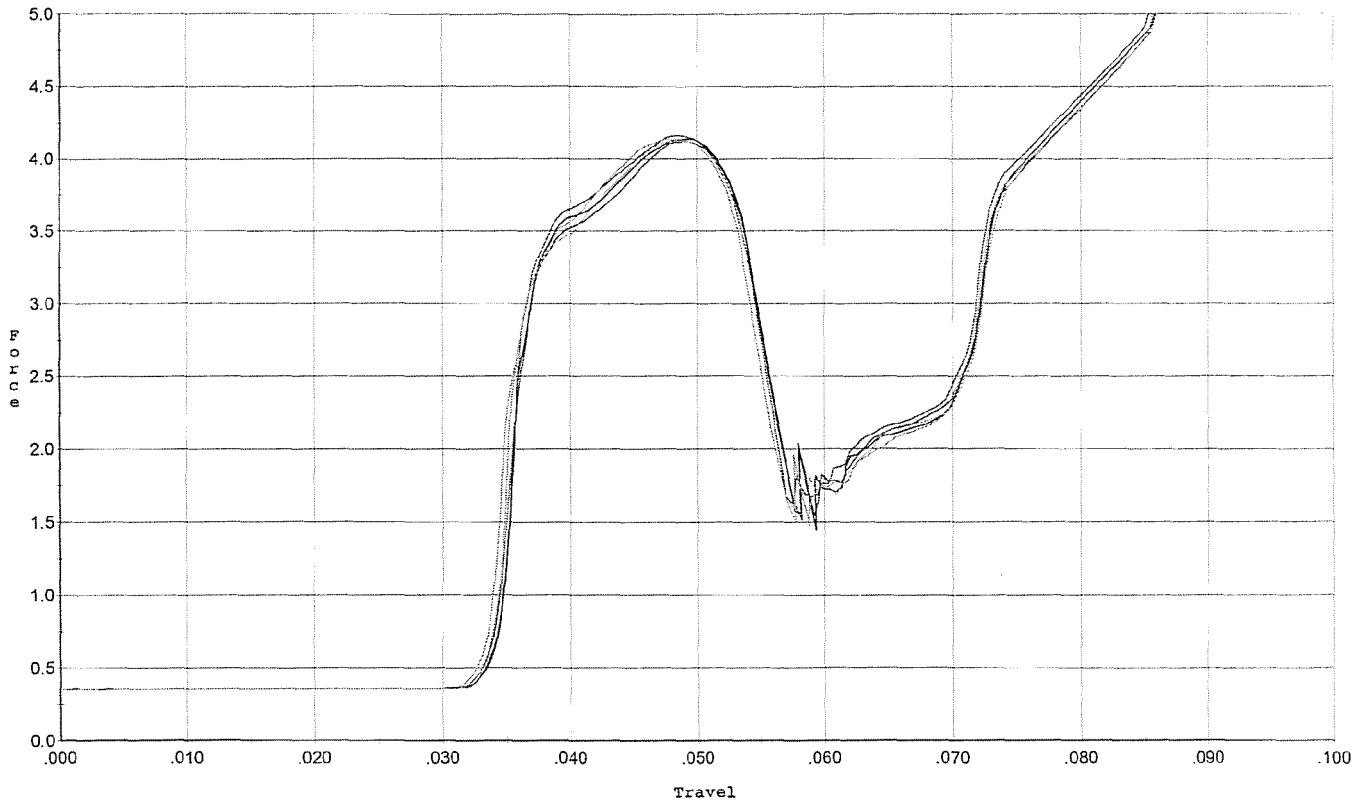
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.133	0.053	0.034	0.035	0.062		Set Trigger
2	3.184	0.052	0.033	0.035	0.062		Set Trigger
3	3.193	0.052	0.033	0.035	0.063		Set Trigger
4	3.148	0.052	0.033	0.035	0.062		Set Trigger
5	3.144	0.051	0.032	0.035	0.061		Set Trigger

Avg 3.16

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 9/15/08

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



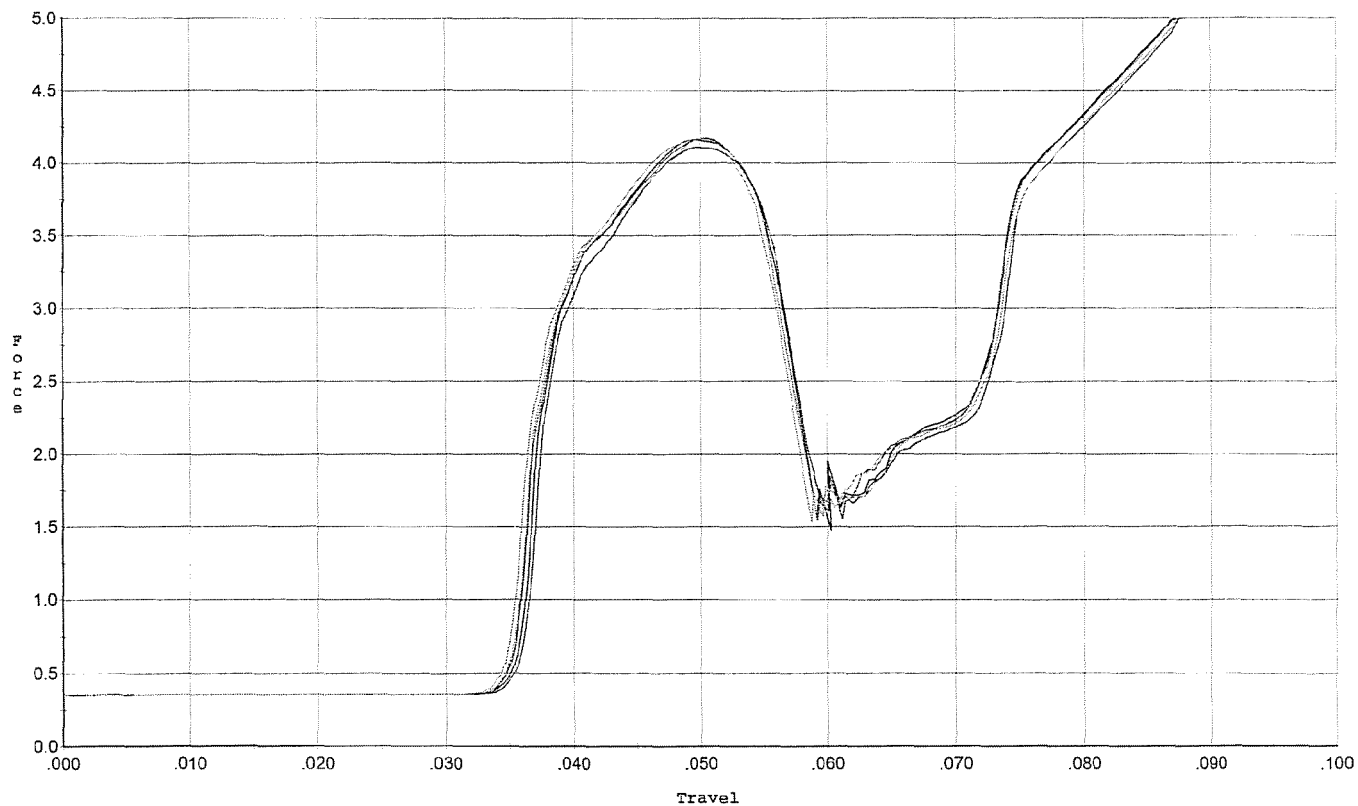
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.123	0.054	0.034	0.035	0.083		Set Trigger
2	4.140	0.054	0.034	0.035	0.083		Set Trigger
3	4.159	0.054	0.033	0.035	0.085		Set Trigger
4	4.126	0.053	0.033	0.035	0.082		Set Trigger
5	4.136	0.053	0.033	0.035	0.084		Set Trigger

Avg 4.13

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 9/15/08

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



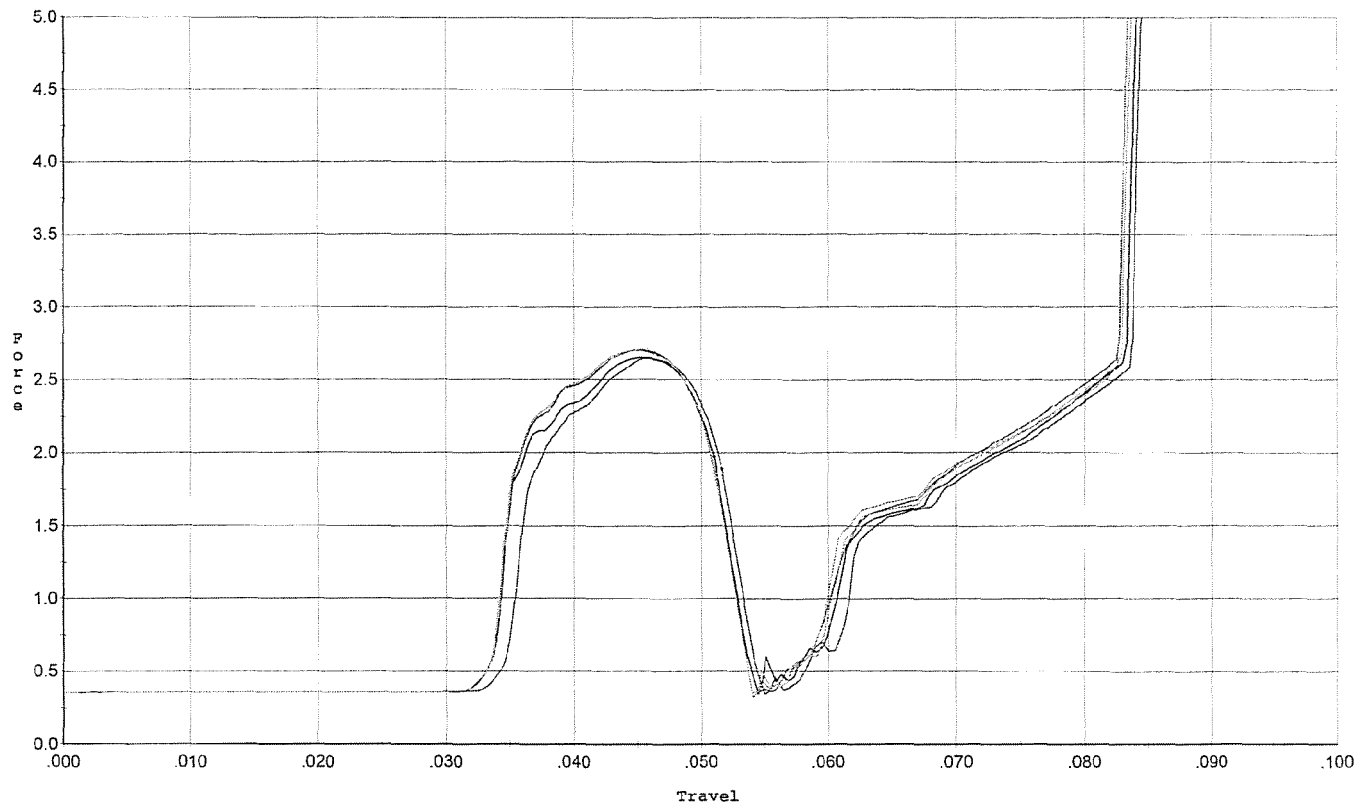
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.108	0.056	0.035	0.036	0.084		Set Trigger
2	4.161	0.056	0.035	0.035	0.086		Set Trigger
3	4.169	0.055	0.035	0.035	0.084		Set Trigger
4	4.174	0.055	0.035	0.035	0.084		Set Trigger
5	4.164	0.056	0.035	0.035	0.086		Set Trigger

Avg 4.15

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 9/15/08

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



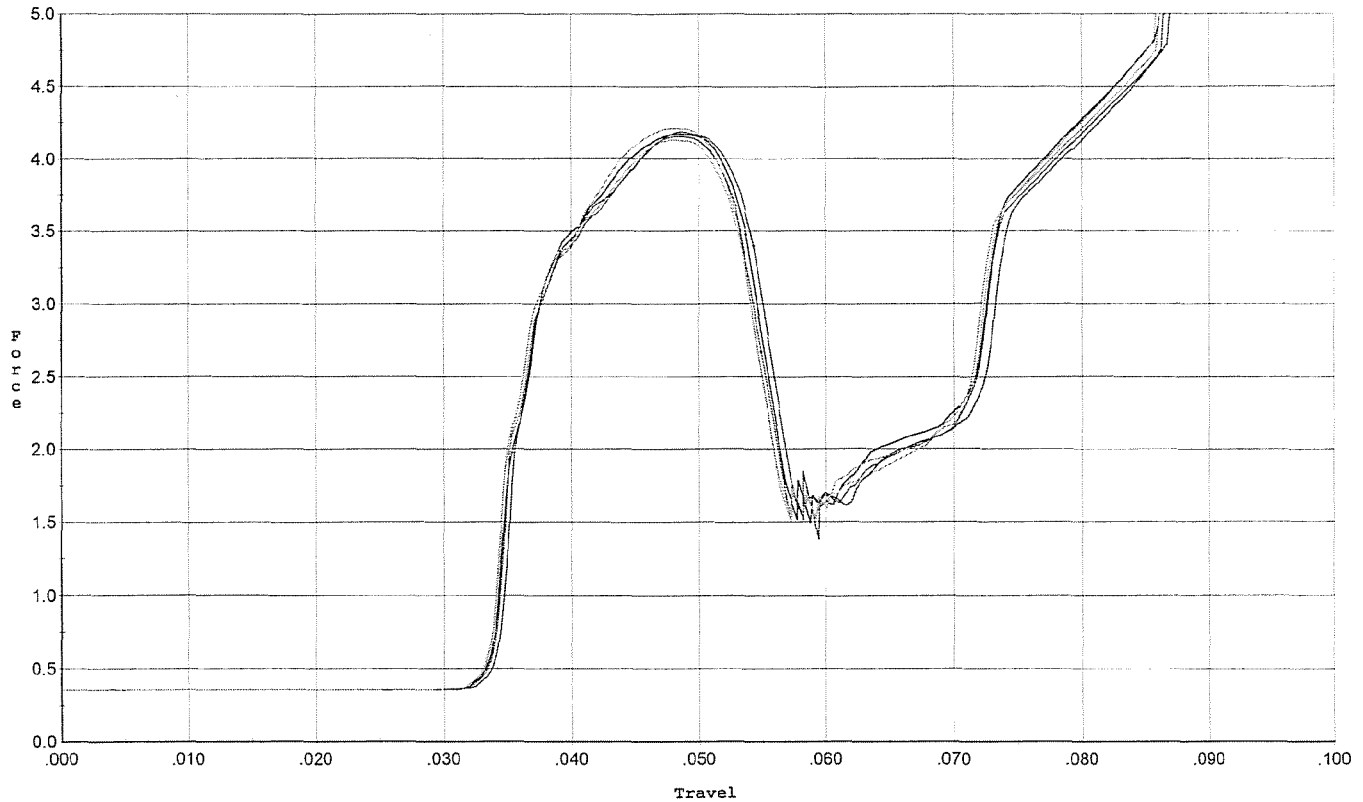
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.647	0.052	0.035	0.037	0.051		Set Trigger
2	2.651	0.051	0.034	0.037	0.052		Set Trigger
3	2.706	0.051	0.034	0.036	0.053		Set Trigger
4	2.704	0.051	0.034	0.036	0.053		Set Trigger
5	2.712	0.051	0.034	0.036	0.054		Set Trigger

Arg 2.68

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 9/15/08

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
4.188	0.054	0.034	0.035	0.085		Set Trigger
171	0.054	0.034	0.035	0.084		Set Trigger
	0.055	0.034	0.035	0.084		Set Trigger
	0.053	0.033	0.035	0.082		Set Trigger
	0.053	0.033	0.035	0.083		Set Trigger

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6498828.__0
FILE DATE AND TIME: 10/09/2008 15:46

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.062
The Average Y Centroid of the Five Target Set:	0.015
The Average Point of Impact of the Five Target Set:	0.064
The Average Mean Radius of the Five Target Set:	0.678
The Distance from POA to Centroid Target #1:	0.072
The Distance from Centroid Target #2 to Centroid Target #1:	0.122
The Distance from Centroid Target #3 to Centroid Target #1:	0.095
The Distance from Centroid Target #4 to Centroid Target #1:	0.314
The Distance from Centroid Target #5 to Centroid Target #1:	0.090

SERIAL NUMBER: C6498828. __0

TARGET NUMBER: 1

FILE DATE: 10/09/2008

FILE TIME: 15:46

X CENTROID: -0.029

Y CENTROID: -0.066

POA TO CENTROID: 0.072

HORZ SPREAD: 1.398

VERT SPREAD: 2.242

GROUP SPREAD: 2.422

MIN RADIUS: 0.361

MAX RADIUS: 1.320

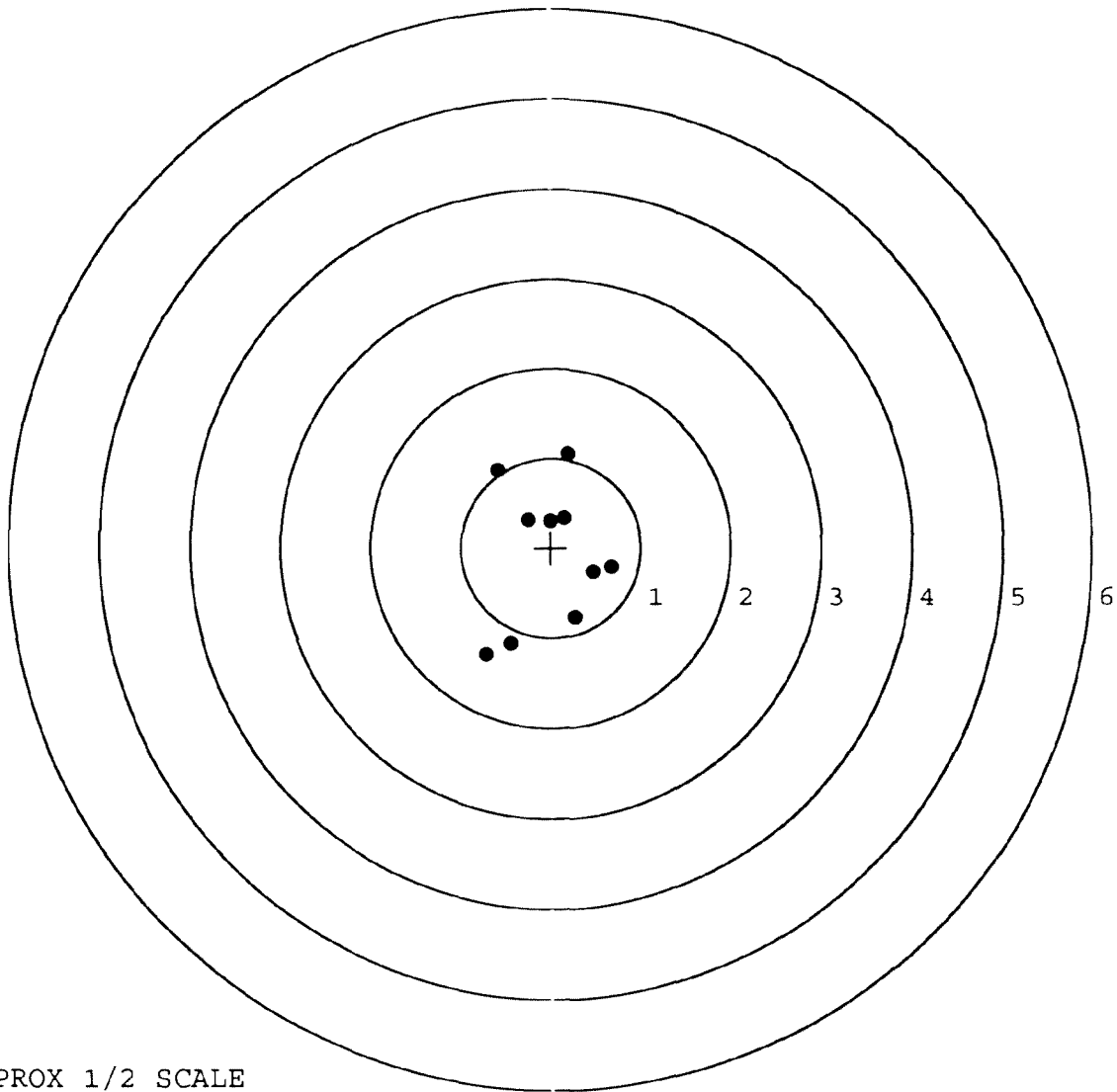
MEAN RADIUS: 0.790

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.195	1.053
2:	-0.593	0.872
3:	-0.722	-1.189
4:	-0.453	-1.067
5:	0.267	-0.775
6:	0.676	-0.214
7:	0.469	-0.271
8:	0.147	0.327
9:	-0.013	0.295
10:	-0.258	0.313

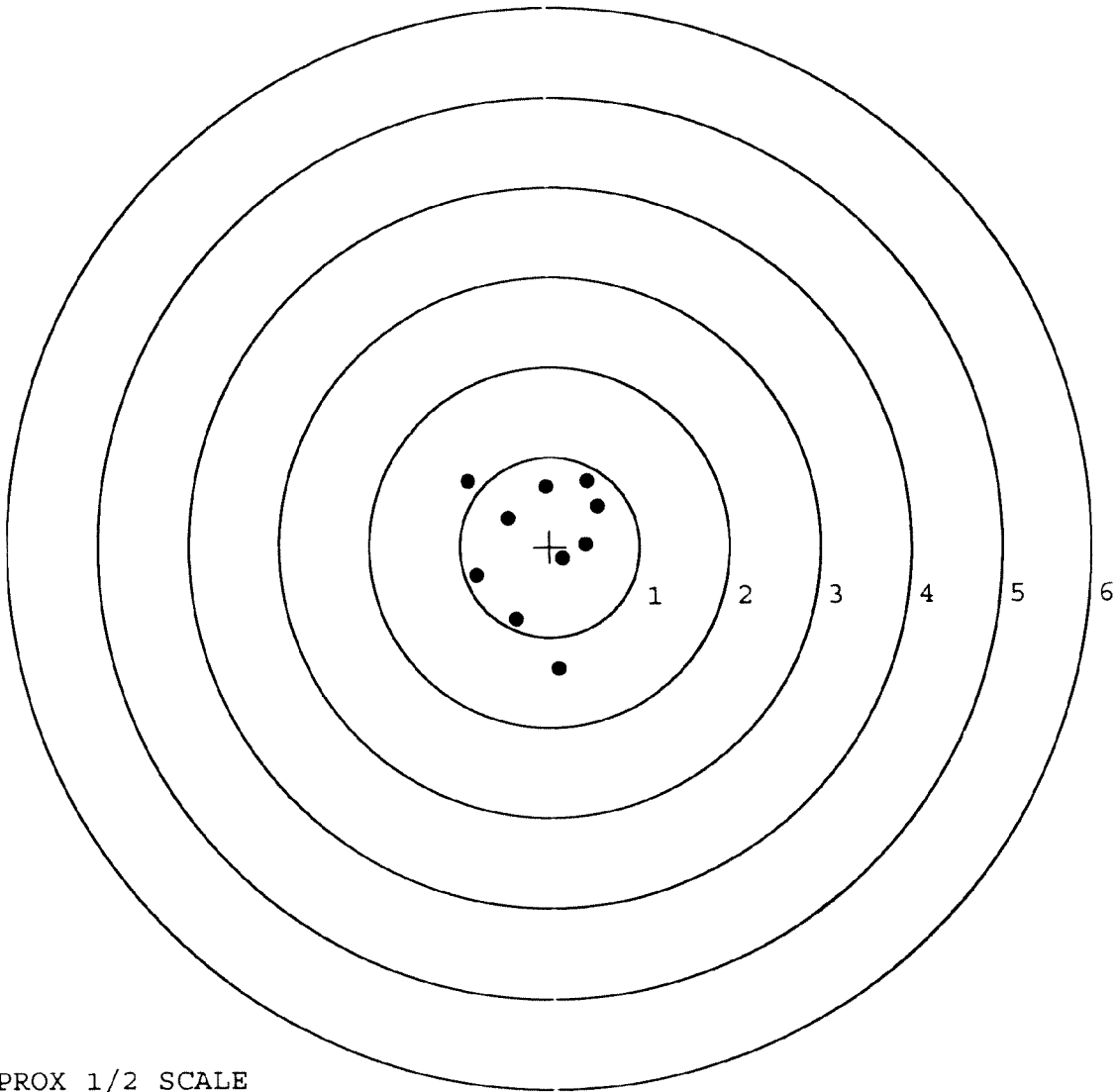


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6498828. __0
 TARGET NUMBER: 2
 FILE DATE: 10/09/2008
 FILE TIME: 15:46

X CENTROID: -0.101
 Y CENTROID: 0.032
 POA TO CENTROID: 0.106
 HORZ SPREAD: 1.443
 VERT SPREAD: 2.094
 GROUP SPREAD: 2.320
 MIN RADIUS: 0.299
 MAX RADIUS: 1.404
 MEAN RADIUS: 0.770
 # IN 1 IN DIAMETER: 2
 # IN 2 IN DIAMETER: 8
 # in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.093	-1.358
2:	-0.386	-0.802
3:	-0.815	-0.319
4:	-0.905	0.736
5:	0.538	0.451
6:	0.422	0.732
7:	-0.041	0.672
8:	-0.465	0.325
9:	0.403	0.023
10:	0.145	-0.137



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6498828. 0

TARGET NUMBER: 3

FILE DATE: 10/09/2008

FILE TIME: 15:46

X CENTROID: -0.061

Y CENTROID: -0.155

POA TO CENTROID: 0.166

HORZ SPREAD: 1.630

VERT SPREAD: 1.436

GROUP SPREAD: 1.796

MIN RADIUS: 0.046

MAX RADIUS: 1.321

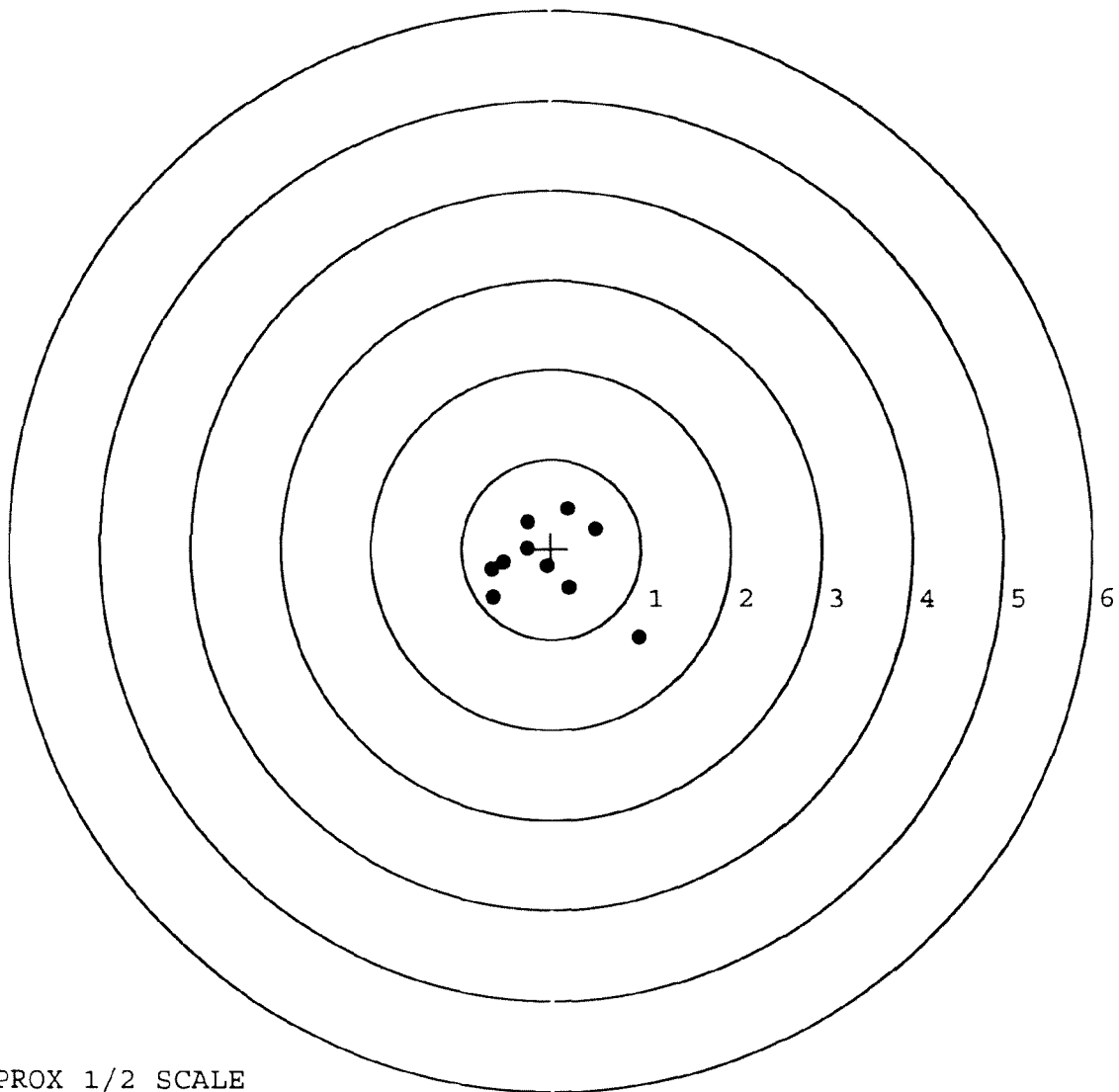
MEAN RADIUS: 0.563

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.967	-0.984
2:	0.180	0.452
3:	0.491	0.231
4:	-0.272	0.300
5:	0.196	-0.436
6:	-0.050	-0.199
7:	-0.272	0.008
8:	-0.648	-0.540
9:	-0.663	-0.229
10:	-0.539	-0.151

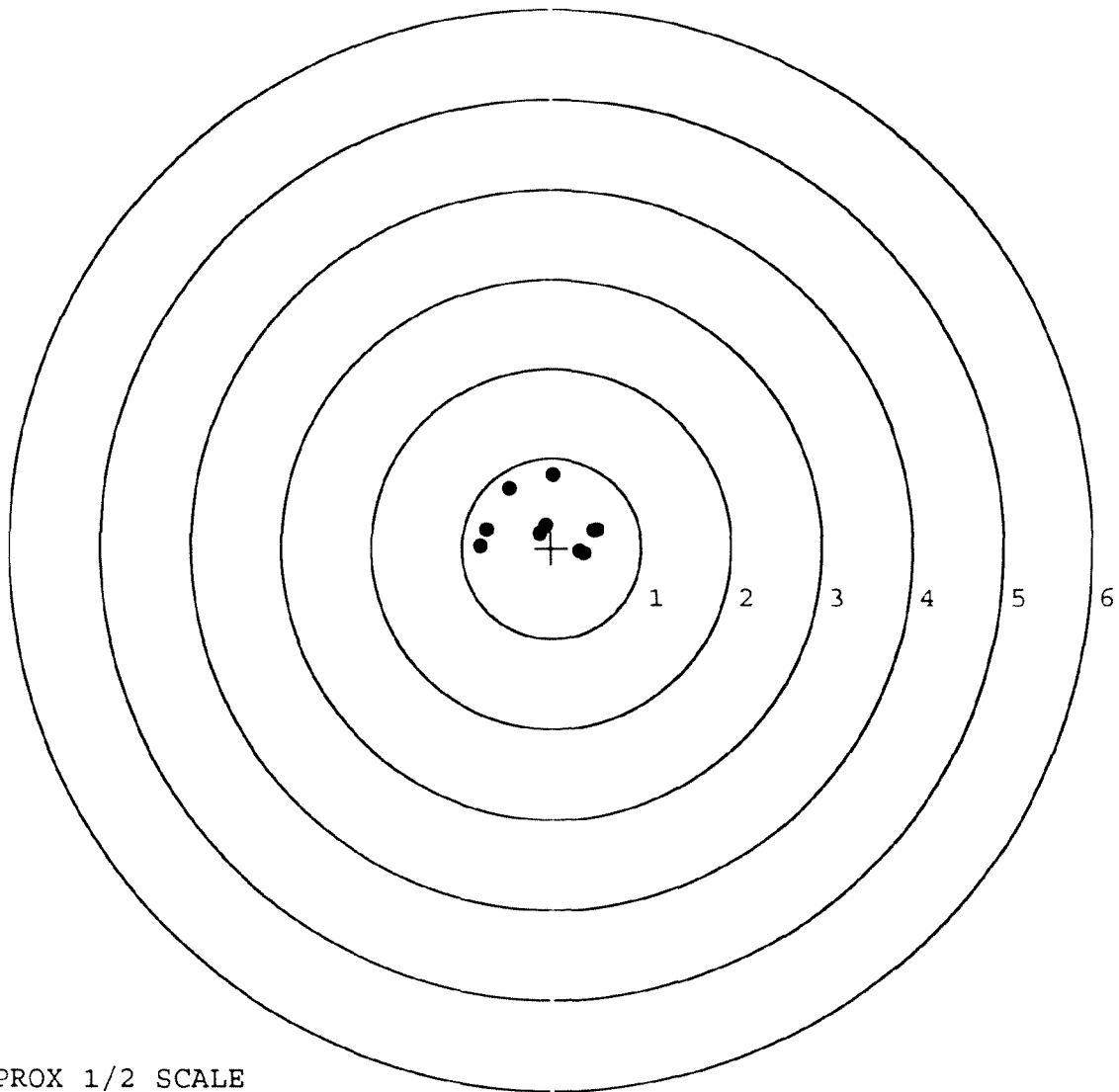


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6498828. 0
 TARGET NUMBER: 4
 FILE DATE: 10/09/2008
 FILE TIME: 15:46

X CENTROID: -0.050
 Y CENTROID: 0.247
 POA TO CENTROID: 0.252
 HORZ SPREAD: 1.294
 VERT SPREAD: 0.865
 GROUP SPREAD: 1.307
 MIN RADIUS: 0.020
 MAX RADIUS: 0.769
 MEAN RADIUS: 0.479
 # IN 1 IN DIAMETER: 3
 # IN 2 IN DIAMETER: 10
 # in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.320	-0.027
2:	0.470	0.201
3:	0.022	0.810
4:	-0.473	0.665
5:	-0.788	0.032
6:	-0.721	0.213
7:	-0.132	0.161
8:	-0.066	0.259
9:	0.363	-0.055
10:	0.506	0.213



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6498828. __0

TARGET NUMBER: 5

FILE DATE: 10/09/2008

FILE TIME: 15:46

X CENTROID: -0.069

Y CENTROID: 0.014

POA TO CENTROID: 0.071

HORZ SPREAD: 1.991

VERT SPREAD: 2.203

GROUP SPREAD: 2.281

MIN RADIUS: 0.328

MAX RADIUS: 1.255

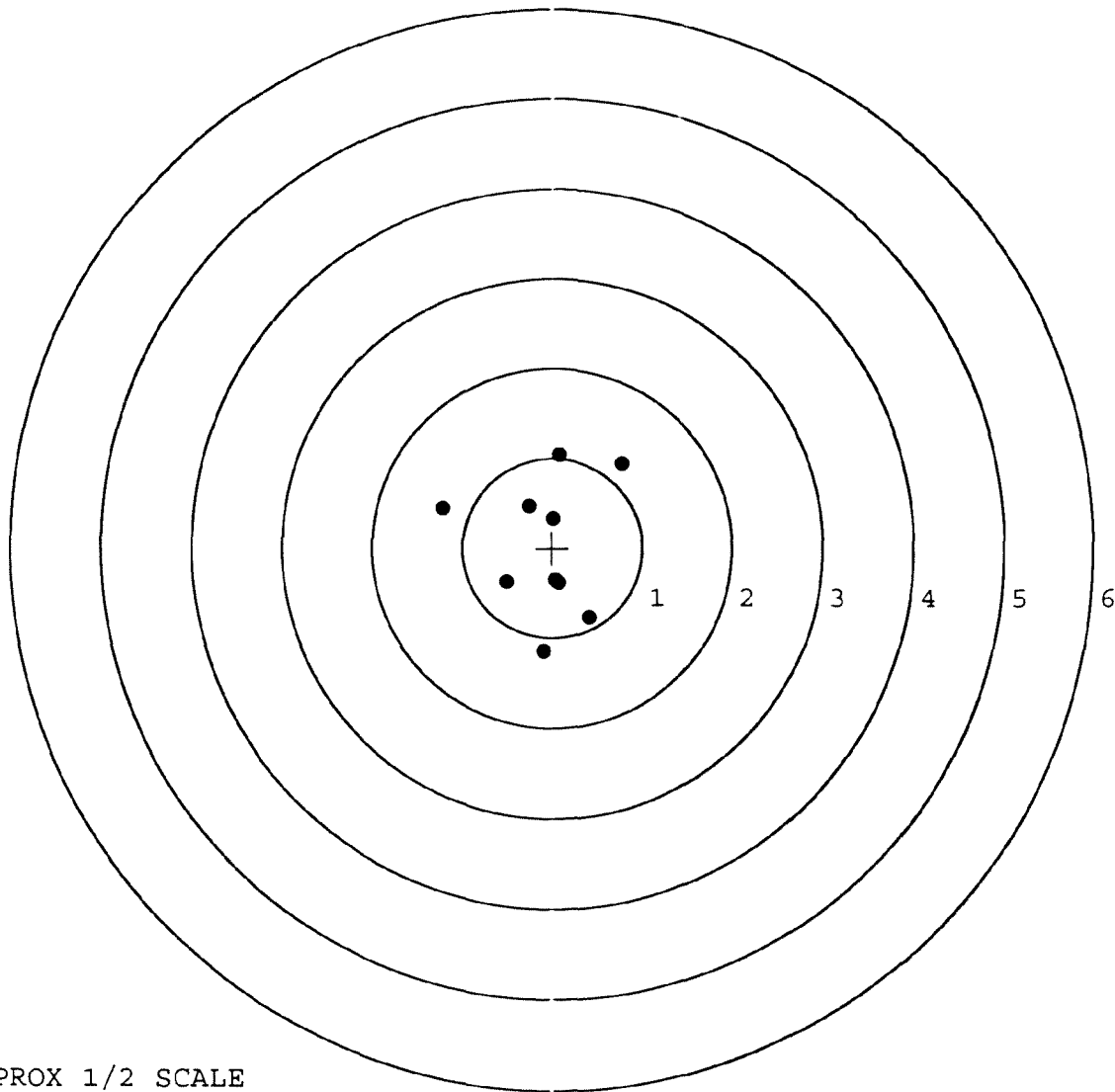
MEAN RADIUS: 0.787

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.777	0.941
2:	-1.214	0.446
3:	0.083	1.037
4:	-0.266	0.472
5:	0.010	0.333
6:	-0.097	-1.166
7:	0.413	-0.777
8:	-0.512	-0.381
9:	0.036	-0.365
10:	0.079	-0.396



TARGET APPROX 1/2 SCALE

BARBER - M24 0008452 RECEIVING AND ESTIMATING REPORT

COMMENTS

ORDER
R 99-09170

INITIAL
SWS

CUSTOMER ORDER NO.
374

DATE RECEIVED
04/07/99

DATE OPENED
04/08/99

DATE CODE
OK 7-90

SERIAL NUMBER
C6498828

NEW SERIAL NUMBER

MODEL AND GRADE
700 7.62

M24

ACCESSORIES
W/STUDS

SCOPE BASE

FROM:

US ARMY
ATTN: JAMES C STARNES JR
GSC 5TH SFG (A)
FORT CAMPBELL

KY 42223

SHIP TO:

US ARMY
ATTN: JAMES C STARNES JR
GSC 5TH SFG (A)
FORT CAMPBELL

KY

42223

CUST NO: 208414 C.O.D.L

ACCOUNT NUMBER

ACCOUNT NUMBER N/C

WRITE ☐

PROM. DATE

ESTIMATED

VIA

DOOR

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

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

Barrel
Extractor

96003
91816

REPAIRMAN

PROOF

CLEAN

TEST

TARGET

PATTERN

GALLERY TESTER

DATE

DATE

DATE

DATE

DATE

OFFICE COPY

RD5025 REV. 7/97

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

BARBER - M24 0008452

Receipt Of Firearm(s) Delivered to the Plant for Repair
Firearm Checked For Live Ammunition ☒

File #

00374

Delivery Date 4/17/99Customer Name (Print) US ARMY JAMES L. STOKES JR.Address 656 5TH ST State FL Zip 32223Phone Number (502)- 798-2882 / 7932Firearm Description Model 700 (M24) Cal./ Ga. 762Serial Number 06498828

Stock/ Fore-end Condition circle the description

(Excellent; Good; Fair; Poor; Fancy; Plain; Synthetic; Wood)

Comments on Stock/ Fore-end condition _____

Metal Condition circle the description

(Excellent; Good; Fair; Poor; Fancy; Plain; Stainless Steel)

Comments on Metal condition _____

Barrel Type (VT. Rib; Plain; Deer; Stainless Steel) Barrel length _____List additional accessories IE Scope, Sling, Gun case and description;
_____Customer request: RECONDITIONINGReturn Process Return to Clark St. Ent. ☐ Return via UPS ☒

By signing this receipt the person delivering the firearm understands to be the only person to receive the firearm upon completion of repairs.

Signature James Stokes Date 4/17/99

person delivering firearm.

Signature [Signature] Date 4/17/99

security officer

Signature [Signature] Date 4/17/99

arms service / CSR

Customer Pick Up Verification

I certify, I am the same person whom delivered the above described firearm to the Remington Ilion plant for repair and may lawfully possess a firearm in New York State

Signature _____ Date ____/____/____

person receiving firearm must be the same whom delivered

Signature _____ Date ____/____/____

security officer or other witness returning the firearm

BARBER - M24 0008454

Remington Test Lab, Ilion, N.Y.

Centroidal distance calculations for Rifle # c6498828
21 Jun 1999

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .2586
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0342
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .260852

THE AMR FOR THIS RIFLE IS: 1.02

CENTROIDAL DISTANCES

0 TO	1	.109078
1 TO	2	.64438
1 TO	3	.284478
1 TO	4	.321442
1 TO	5	.190252

4 5 3 <----POA
+1 2

REMINGTON CENTERFIRE ACCURACY TEST

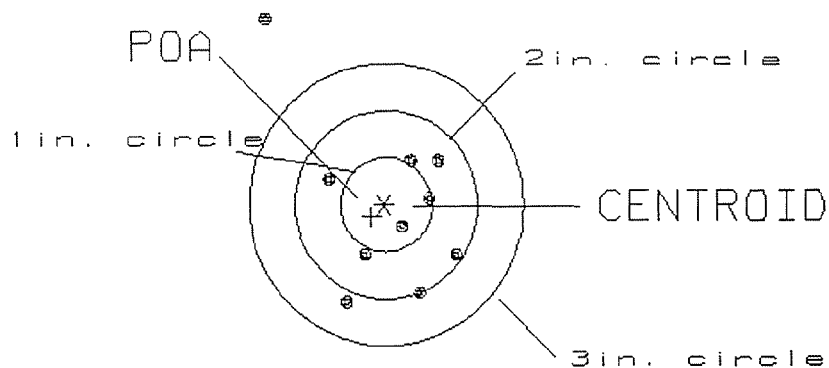
REMINGTON TEST LAB, ILION, N.Y.

PATTERN #: ☐ 1 ☐
 POA TO CENTROID: .185
 MIN RADIUS : .245
 MEAN RADIUS : .855
 MAX RADIUS : 2.358
 CENTROID X : .133
 CENTROID Y : .129

21 Jun 1999

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6498828.1

CENTERFIRE PATTERN # 1



OF SHOTS= 10

IN CIRCLE

HS= 2.03

2

VS= 2.98

7

GS= 3.36

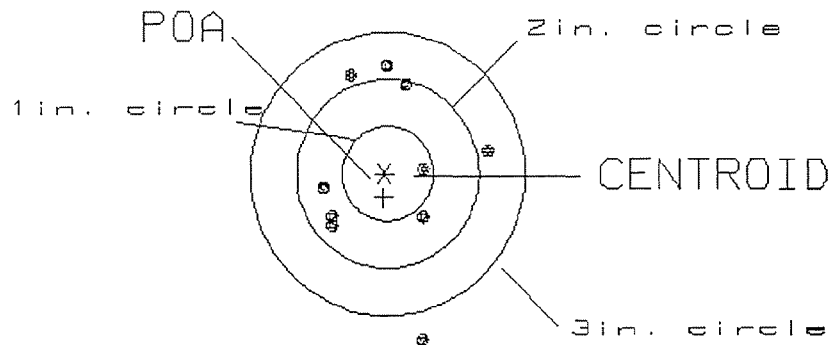
9

PATTERN #: 020
 POA TO CENTROID: .253
 MIN RADIUS : .413
 MEAN RADIUS : .952
 MAX RADIUS : 1.807
 CENTROID X : .008
 CENTROID Y : .253

21 Jun 1999

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6498828.1

CENTERFIRE PATTERN # 2



OF SHOTS= 10

IN CIRCLE

HS= 1.82
 VS= 2.87
 GS= 2.97

1
 6
 9

REMINGTON CENTERFIRE ACCURACY TEST

REMINGTON TEST LAB, ILION, N.Y.

PATTERN #: 3

POA TO CENTROID: .353

MIN RADIUS : .286

MEAN RADIUS : 1.001

MAX RADIUS : 2.716

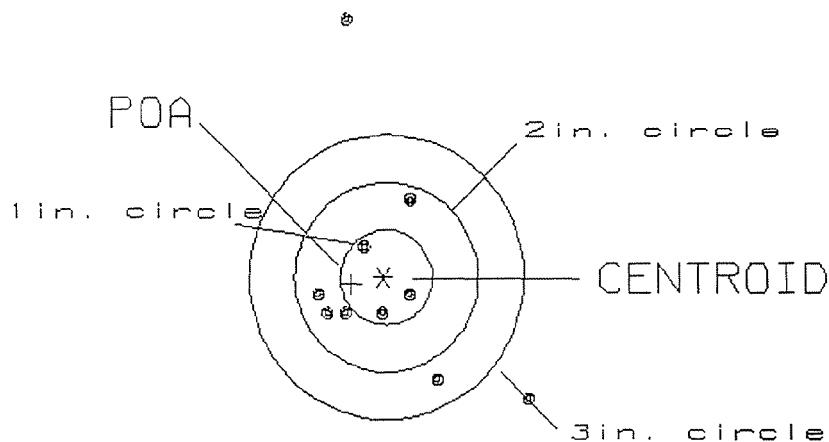
CENTROID X : .345

CENTROID Y : .075

21 Jun 1999

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6498828.1

CENTERFIRE PATTERN # 3



OF SHOTS= 10

IN CIRCLE

HS= 2.32

3

VS= 3.94

7

GS= 4.42

8

REMINGTON CENTERFIRE ACCURACY TEST

REMINGTON TEST LAB, ILION, N.Y.

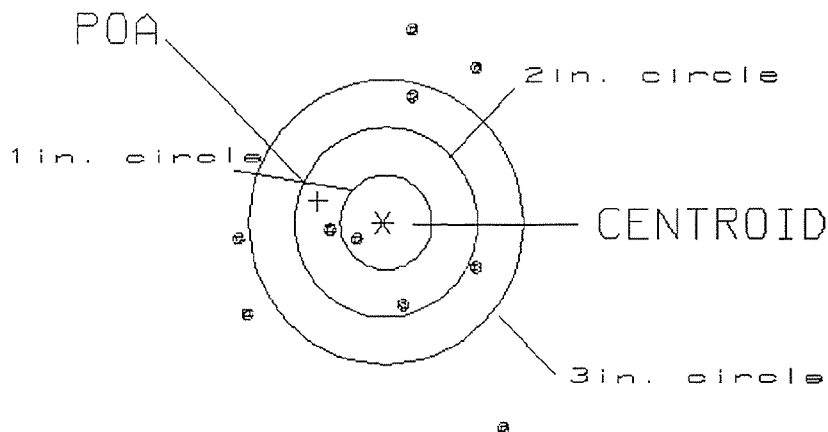
PATTERN #: 4

POA TO CENTROID: .749
 MIN RADIUS : .351
 MEAN RADIUS : 1.411
 MAX RADIUS : 2.525
 CENTROID X : .714
 CENTROID Y : -.229

21 Jun 1999

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6498828.1

CENTERFIRE PATTERN # 4



OF SHOTS= 10

IN CIRCLE

H3= 2.89
 V5= 4.14
 G5= 4.27

1
 3
 5

REMINGTON CENTERFIRE ACCURACY TEST

REMINGTON TEST LAB, ILION, N.Y.

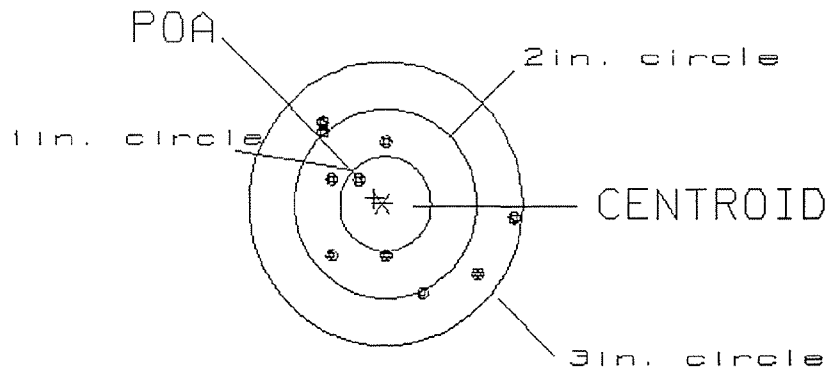
PATTERN #: 5

POA TO CENTROID: .109
 MIN RADIUS : .434
 MEAN RADIUS : .883
 MAX RADIUS : 1.451
 CENTROID X : .093
 CENTROID Y : -.057

21 Jun 1999

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6498828.1

CENTERFIRE PATTERN # 5



OF SHOTS= 10

IN CIRCLE

H3= 2.17
 V5= 1.80
 G5= 2.40

1
 7
 10

Remington[®]

MODEL 700TM M24

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

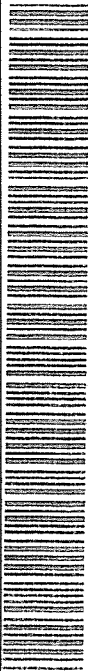
VERY IMPORTANT!
Instruction Book
enclosed to assure
safe use of this
firearm.

REMINGTON
REG. U.S. PAT. & T.M. OFF.

SERIAL NO.
C6498828

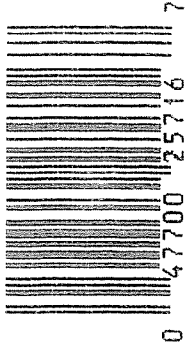
ORDER NO.
5716

01



5716 C6498828

UPC



0 47700 25716 7

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6498828

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	7 12 90		RW
600	Proof	7 12 90		RW
607	Check Headspace	7 12 90		RW
610	Dis-assemble Gun	7 12 90		RW
612	Magnaflux Barrel Action		7-17-90	KR
	Magnaflux Bolt		7-17-90	KR
615	Rollmark Caliber		7-17-90	LS
617	Drill and Tap Sight Holes		7/29/90	LB
618	Polish Barrel RB		7/24/90	WB
620	Apply Coatings (Barrel Action)		7-16-90	LS
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/8/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/8/90	RW
	C) Inspect Ejector Hole for Chamfer		8/8/90	RW
	D) Oil Firing Pin Ass'y		8/8/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		9-13-90	JH

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			8/14/90	gll
	G) Safety Off Force	3	3	3			8/14/90	gll
	H) Trigger Pull Test & Retainability						9-13-90	gll
	I) Firing Pin Indent	.022	.021	.0215			8/14/90	gll
	J) Assemble Stock						8/14/90	Rw
	K) Assemble Swivel Studs						9/14/90	gll
	L) Attach Front and Rear Sight Assemblies						8/14/90	Rw
	M) Iron Sight Alignment						8/14/90	Rw
	N) Detach Front & Rear Sights & place in numbered container						8/14/90	Rw
	O) Attach Scope to Rifle						8/14/90	Rw
	P) Detach & Attach Scope 20 Times						8/14/90	Rw
640	Gallery Target & Test						8/15/90	NE
	A) Time						8/15/90	NE
	B) Malfunctions						8/15/90	NE
	C) Pierced Primers						8/15/90	NE
	D) Optical Clarity of Scope						8/15/90	NE
645	Inspect for Live Ammo						8/15/90	NE
655	Final Inspection							
	A) Headspace						9/14/90	gll
	B) Trigger Pull	2.49	2.32	2.34	2.21	2.24	9-13-90	gll
	C) Function						9/14/90	gll
660	Pack						9-18-90	gll

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6498828

DATE 9-13-90

TESTER JLL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.52	2.34	2.24	2.49	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.51	2.33	2.24	2.32	
PULL #3	2.26	2.48	2.23	2.34	
PULL #4	2.43	2.45	2.34	2.21	
PULL #5	2.41	2.29	2.21	2.24	
TOTAL	12.13	11.89	11.26	11.60	
AVG.	2.426	2.378	2.252	2.32	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.23	3.13		
PULL #2	3.51	3.22		
PULL #3	3.20	3.50		
PULL #4	3.14	3.15		
PULL #5	3.13	3.20		
TOTAL	16.21	16.20		
AVG.	3.242	3.24		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.27	4.20		4.29
PULL #2	4.32	4.22		4.34
PULL #3	4.26	4.45		4.28
PULL #4	4.19	4.43		4.27
PULL #5	4.34	4.51		4.41
TOTAL	21.38	21.81		21.59
AVG.	4.276	4.362		4.318

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6498828
16 Aug 1990

CENTROIDAL DISTANCES

0 TO	1	.439659
1 TO	2	.328381
1 TO	3	.6228
1 TO	4	.106888
1 TO	5	.435984

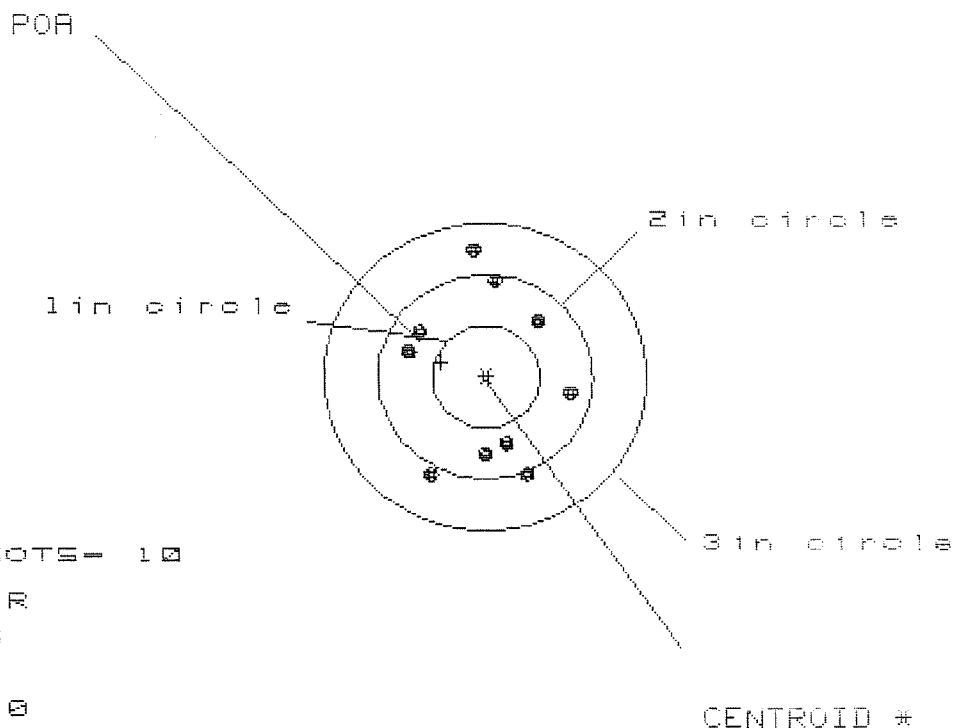
$\frac{1}{5} \times 12$ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .3134
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.2488
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .395227
THE AMR FOR THIS RIFLE IS: .8888

15 Aug 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C849B828

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1 in = 0

2 in = 7

3 in = 10

HS = 1.499

VS = 2.113

GS = 2.191

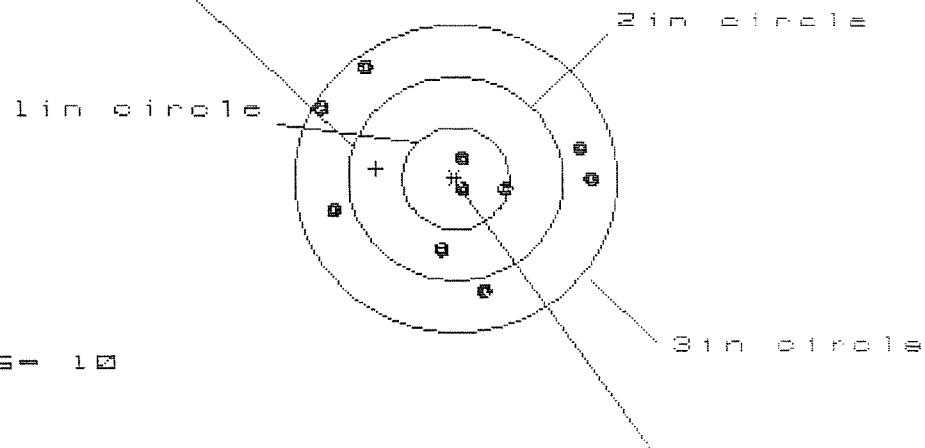
PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.772	.756	.694
MINIMUM X	-.727	-.743	-.805
MAXIMUM Y	1.202	1.067	.971
MINIMUM Y	-.911	-.778	-.874
CENTROID X	.414	.430	.492
CENTROID Y	-.148	-.281	-.185
POA TO CENTROID in.	.440	.514	.525
MIN RADIUS	.708	.596	.672
MEAN RADIUS	.873	.820	.805
MAX RADIUS	1.210	1.071	.971
HORIZONTAL SPREAD	1.499	1.499	1.499
VERTICAL SPREAD	2.113	1.845	1.845
EXTREME SPREAD	2.191	1.930	1.873
NUMBER IN ONE INCH CIRCLE =		0	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		10	

15 Aug 1998

FILE:/PATTERNING/CENTERFIRE_PATT/0649B028

CENTERFIRE PATTERNS # 2

POA



OF SHOTS = 10

IN CIR

1 in = 3

2 in = 4

3 in = 10

HS = 2.480

VS = 2.172

GS = 2.565

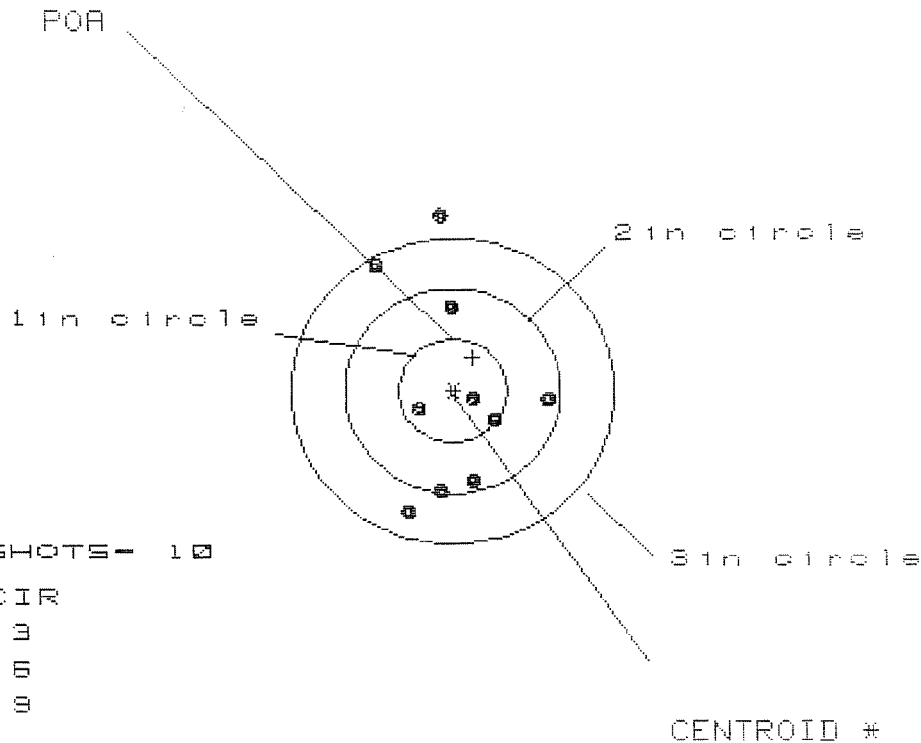
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.277	1.143	1.020
MINIMUM X	:	-1.203	-1.276	-1.399
MAXIMUM Y	:	1.078	1.154	.488
MINIMUM Y	:	-1.094	-1.018	-.874
CENTROID X	:	.739	.873	.996
CENTROID Y	:	-.101	-.177	-.321
POA TO CENTROID in.	:	.746	.891	1.046
MIN RADIUS	:	.084	.082	.202
MEAN RADIUS	:	.904	.828	.739
MAX RADIUS	:	1.384	1.516	1.401
HORIZONTAL SPREAD	:	2.480	2.419	2.419
VERTICAL SPREAD	:	2.172	2.172	1.362
EXTREME SPREAD	:	2.565	2.448	2.441
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		10	

15 Aug 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6498828

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 6

3 in = 9

HS= 1.645

VS= 2.847

GS= 2.871

CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.931	.923	.833
MINIMUM X	:	-.714	-.722	-.547
MAXIMUM Y	:	1.701	1.371	1.216
MINIMUM Y	:	-1.146	-.956	-.785
CENTROID X	:	-.184	-.176	-.086
CENTROID Y	:	-.322	-.511	-.682
POA TO CENTROID in.	:	.371	.540	.687
MIN RADIUS	:	.207	.191	.270
MEAN RADIUS	:	.914	.789	.669
MAX RADIUS	:	1.703	1.549	1.219
HORIZONTAL SPREAD	:	1.645	1.645	1.380
VERTICAL SPREAD	:	2.847	2.327	2.001
EXTREME SPREAD	:	2.871	2.342	2.053
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

15 Aug 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C649B028

CENTERFIRE PATTERNS

4

POA

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 2

2 in = 5

3 in = 9

HS= 2.583

VS= 2.645

GS= 2.662

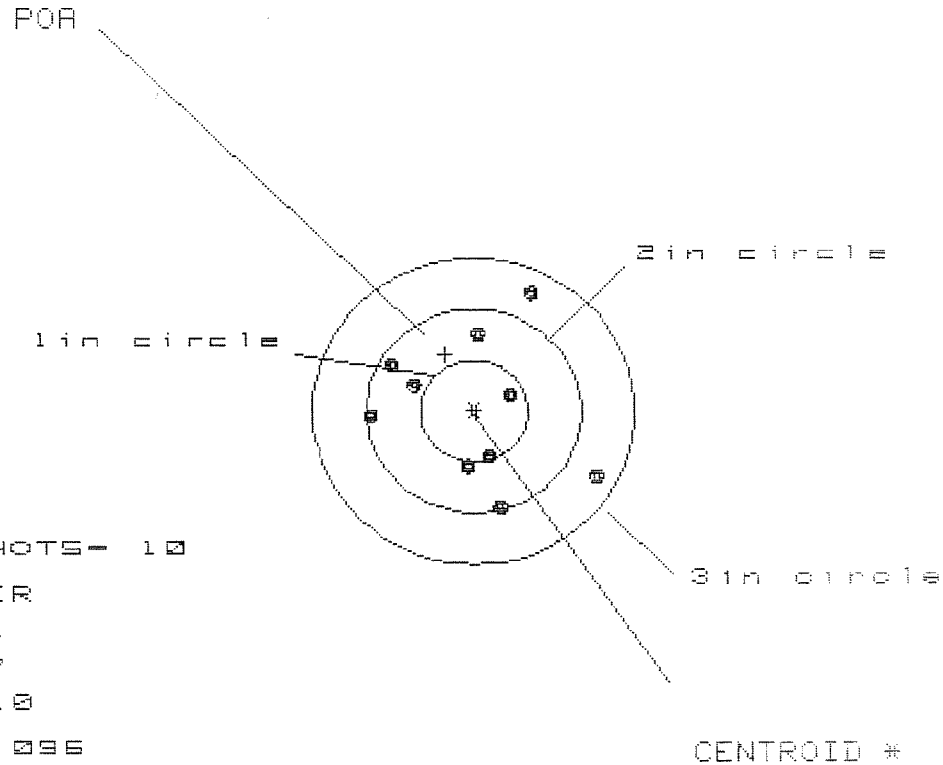
CENTROID #

PATTERN #	4
SHOTS (BEST OF)	10
MAXIMUM X	1.689
MINIMUM X	-.894
MAXIMUM Y	1.319
MINIMUM Y	-1.326
CENTROID X	.335
CENTROID Y	-.076
POA TO CENTROID in.	.344
MIN RADIUS	.183
MEAN RADIUS	.933
MAX RADIUS	1.689
HORIZONTAL SPREAD	2.583
VERTICAL SPREAD	2.645
EXTREME SPREAD	2.662
NUMBER IN ONE INCH CIRCLE	2
NUMBER IN TWO INCH CIRCLE	5
NUMBER IN THREE INCH CIRCLE	9

15 Aug 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C643B828

CENTERFIRE PATTERNS # 5



OF SHOTS - 10

IN CIR

1 in = 1

2 in = 7

3 in = 10

HS = 2.0996

VS = 2.049

GS = 2.200

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.090	.641	.518
MINIMUM X	:	-1.006	-.885	-.805
MAXIMUM Y	:	1.112	1.035	.819
MINIMUM Y	:	-.937	-1.014	-.884
CENTROID X	:	.263	.142	.062
CENTROID Y	:	-.557	-.480	-.610
POA TO CENTROID in.	:	.616	.501	.613
MIN RADIUS	:	.340	.441	.481
MEAN RADIUS	:	.820	.762	.693
MAX RADIUS	:	1.291	1.218	.993
HORIZONTAL SPREAD	:	2.096	1.526	1.323
VERTICAL SPREAD	:	2.049	2.049	1.703
EXTREME SPREAD	:	2.200	2.067	1.744
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	