

C6225237

MODEL 700™ M24

Model SMS™

Action

Barrel Length

Capacity

Order No. 5715

*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: **RE00010570** Serial: C6225237 Model 700 Center Fire Caliber: 7.62 NATO M/24 SWS 2 OF 2 Repairman: Status: New 6/22/00 9:37:22 AM

Address Information

Customer: ☒ Received From Return To: ☐ Received From

Name: **TRANSPORTATION OFFICER** **TRANSPORTATION OFFICER**

Address 1: **ATTN:AFZB - DL - TO, BLDG 873** **ATTN:AFZB - DL - TO, BLDG 873**

Address 2: **PO Box:** **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: **502 798 7154**

Fax:

Email:

Comments:

Received Condition

Fair

Condition Notes:

CSR Notes:

Accessories Received

Code	Desc	Qty
A007	With Stud	2
A008	With Swivel	2
A010	Hard Case	1
A017	Scope Base	1

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

magletj 6/23/00 7:43 AM CAPS NUM INS SCRL

Start Inb... Na... SA... Ex... Mi... Ar... Par... Ser... Pri... 7:43 AM

Number: **C6225237**

Model: **700**



RE00010570

96003-BBL

Remington Test Lab, Ilion, N.Y.

Centroidal distance calculations for Rifle # c6225237
7 Sep 2000

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0538
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1882
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .195739

THE AMR FOR THIS RIFLE IS: 1.044

CENTROIDAL DISTANCES

0	TO	1	.267854
1	TO	2	.0368782
1	TO	3	.223647
1	TO	4	.0523546
1	TO	5	.408011

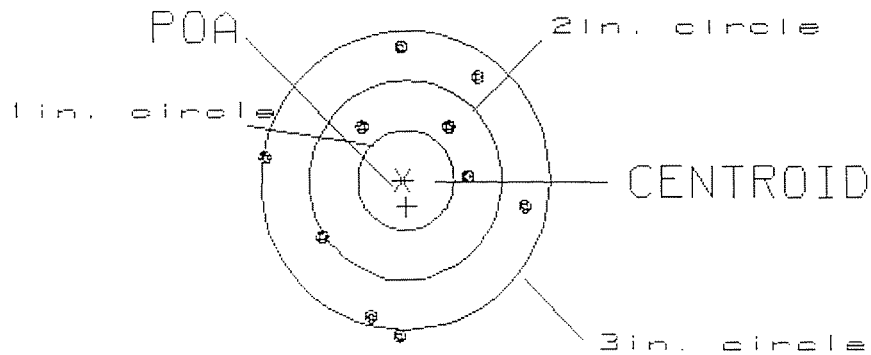
4
+³ 5 <----POA

PATTERN #: 1
 POA TO CENTROID: .268
 MIN RADIUS : .683
 MEAN RADIUS : 1.142
 MAX RADIUS : 1.603
 CENTROID X : -.039
 CENTROID Y : .265

7 Sep 2000

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6225237

CENTERFIRE PATTERN # 1



OF SHOTS= 10

IN CIRCLE

HS= 2.71

0

VS= 2.91

4

GS= 2.91

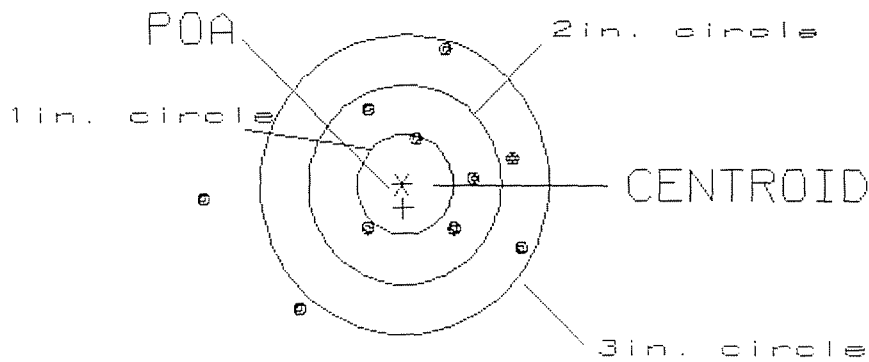
9

PATTERN #: 2
 POA TO CENTROID: .241
 MIN RADIUS : .507
 MEAN RADIUS : 1.109
 MAX RADIUS : 2.100
 CENTROID X : -.011
 CENTROID Y : .241

7 Sep 2000

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6225237

CENTERFIRE PATTERN # 2



OF SHOTS= 10

IN CIRCLE

HS= 3.35

0

VS= 2.66

5

GS= 3.40

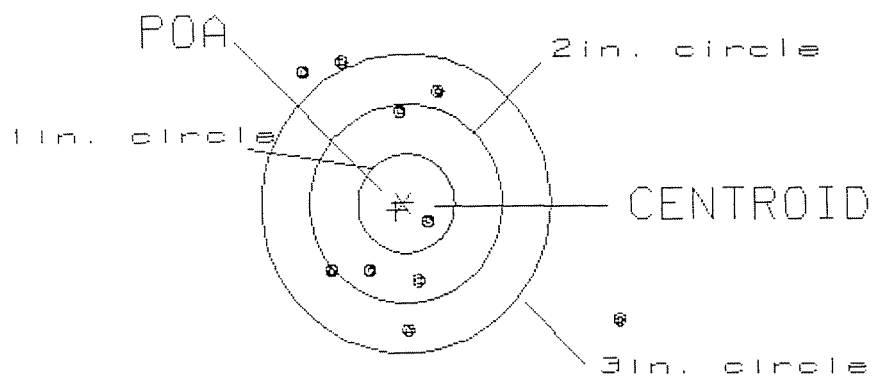
8

PATTERN #: 3
 POA TO CENTROID: .103
 MIN RADIUS : .313
 MEAN RADIUS : 1.205
 MAX RADIUS : 2.492
 CENTROID X : .074
 CENTROID Y : .072

7 Sep 2000

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6225237

CENTERFIRE PATTERN # 3



OF SHOTS= 10

IN CIRCLE

HS= 3.29

1

VS= 2.76

4

GS= 4.14

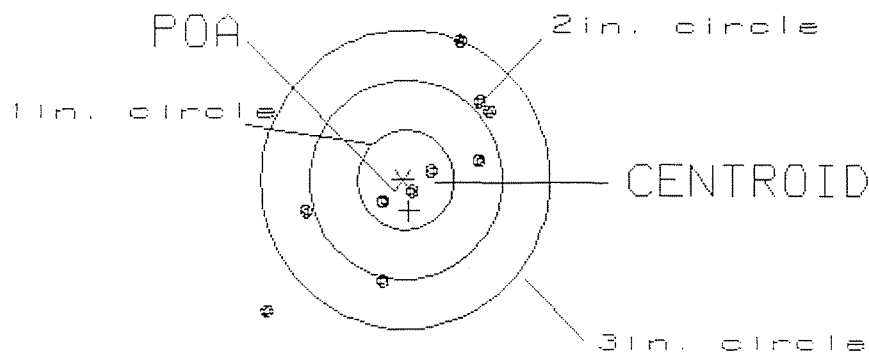
7

PATTERN #: 4
 POA TO CENTROID: .318
 MIN RADIUS : .151
 MEAN RADIUS : .871
 MAX RADIUS : 1.918
 CENTROID X : -.064
 CENTROID Y : .311

7 Sep 2000

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6225237

CENTERFIRE PATTERN # 4



OF SHOTS= 11

IN CIRCLE

HS= 2.25

4

VS= 2.68

5

GS= 3.31

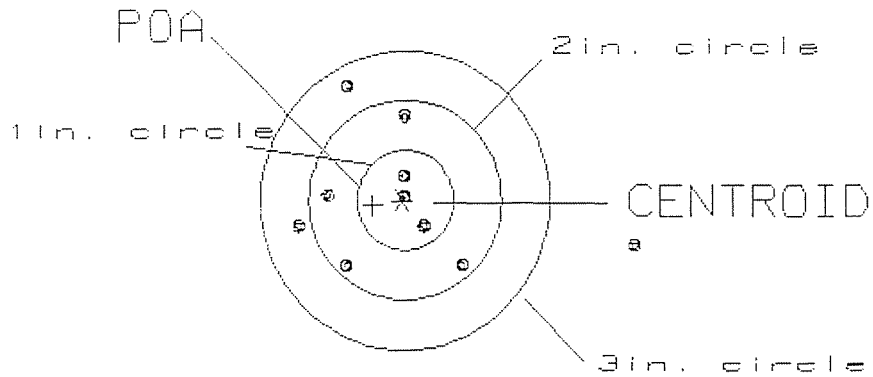
10

PATTERN #: 5
 POA TO CENTROID: .313
 MIN RADIUS : .057
 MEAN RADIUS : .894
 MAX RADIUS : 2.456
 CENTROID X : .309
 CENTROID Y : .052

7 Sep 2000

FILE://Hqbasic/Accuracy/Patterning/Centerfire_Patt/c6225237

CENTERFIRE PATTERN # 5



OF SHOTS= 10

IN CIRCLE

HS= 3.55

3

US= 1.64

7

GS= 3.55

9

Final Inspection

Sn: C6225237 DATE REC'D: 6-19-00 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

[illegible]

Remington

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

MODEL 700™ M24**SERIAL NO.**

C6225237

ORDER NO.**5716**

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

20



5716 C6225237

UPC

0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6225237

OP. #	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and stock	8	9/88	FB
600	Proof	9	7/88	RW
607	Check Headspace	9	7/88	RW
610	Dis-assemble gun	9	7/88	RW
612	Magnaflux Barrel Action		9-14-88	AJC.
	Magnaflux Bolt		9-14-88	AJC.
615	Rollmark Caliber		10/22	GS.
617	Drill & Tap Sight Holes		10/23	FB
618	Polish Barrel		10/24	WOT
620	Apply Coatings (Barrel Action)		10-31-88	TJA
	Apply Coatings (Bolt)		10-31-88	TJA
625	Final Assembly A) Clean inside of Bolt Assembly		1/12/89	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		1/12/89	RW
	C) Inspect Ejector Hole for Chamfer		1/12/89	RW

OVER

OP.#		READINGS	DATE	INITIAL
625 cont.	D) Oil Firing Pin Ass'y		1/12/89	RW
	E) Adjust Trigger Pull to Min. Setting and Stake		12 Jan 89	JSJ
	F) Safety on Force	<u>6</u> <u>5</u> <u>5</u>	12 Jan 89	JSJ
	G) Safety off Force	<u>3</u> <u>3</u> <u>3</u>	12 Jan 89	JSJ
	H) Trigger Pull Test & Retainability		12 Jan 89	JSJ
	I) Firing Pin Indent	.0205 .021 .021	12 Jan 89	JSJ
	J) Assemble Stock		1/12/89	RW
	K) Assemble Swivel Studs		31 Jan 89	JSJ
	L) Attach Front & Rear Sight Assemblies		1/12/89	RW
	M) Iron Sight Alignment		1/12/89	RW
	N) Detach Front & Rear Sights & place in numbered container		1/12/89	RW
	O) Attach Scope to Rifle		13 Jan 89	JSJ
	P) Detach & Attach Scope 20 times		13 Jan 89	JSJ
640	Gallery Target & Test	532 100L	1/25/89	K
	A) Optical Clarity of Scope	OK	1/25/89	K
645	Inspect for Live Ammo	NONE.	1/25/89	K
655	Final Inspection			
	A) Headspace		31 Jan 89	JSJ
	B) Trigger Pull		31 Jan 89	JSJ
	C) Function		31 Jan 89	JSJ
660	Pack		3/22	WJ

5537

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. 5599DATE 6/29/90TESTER J.P.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#	COMMENTS
PULL #1	2.31	2.18	2.30	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.43	2.14	2.20	
PULL #3	2.24	2.32	2.25	
PULL #4	2.37	2.26	2.30	
PULL #5	2.26	2.22	2.20	
TOTAL	11.61	11.12	11.25	
AVG.	2.322	2.224	2.05	

	3.00# INITIAL	3.00# AFTER 20 CYCLES	COMMENTS
PULL #1	3.17	3.16	
PULL #2	3.12	3.34	
PULL #3	3.50	3.40	
PULL #4	3.23	3.29	
PULL #5	3.11	3.37	
TOTAL	16.13	16.56	
AVG.	3.226	3.312	

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.15	4.46		4.49
PULL #2	4.25	4.32		4.28
PULL #3	4.12	4.32		4.35
PULL #4	4.19	4.36		4.39
PULL #5	4.34	4.33		4.54
TOTAL	21.05	21.79		22.05
AVG.	4.21	4.358		4.41

Boat
GTOP

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06225237
26 Jan 1989

CENTROIDAL DISTANCES

0 TO	1	.676571
1 TO	2	.72716
1 TO	3	.996243
1 TO	4	.732007
1 TO	5	1.29729

1
3 4 2
5
-----POB

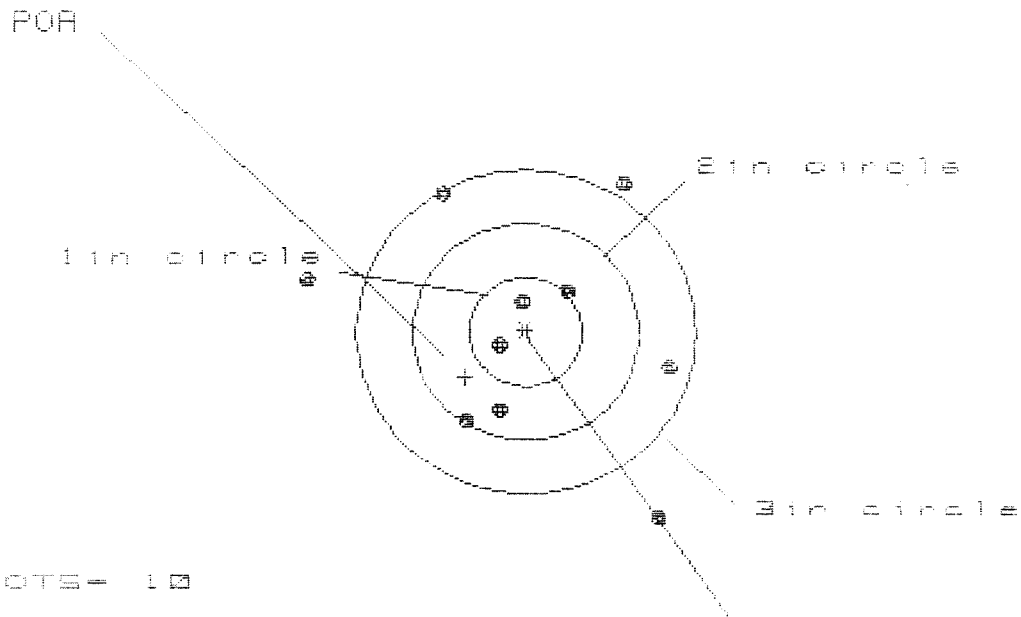
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0544
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1366
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .147834
THE AMR FOR THIS RIFLE IS: 1.053

26 Jan 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C8225237

CENTERFIRE PATTERNS

1



OF SHOTS = 10

IN CIR

1 in = 2

2 in = 5

3 in = 7

HS = 3.191

VS = 3.142

GS = 3.848

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.269	1.481	1.178
MINIMUM X	-1.922	-1.790	-1.862
MAXIMUM Y	1.379	1.183	1.218
MINIMUM Y	-1.763	-1.005	-1.970
CENTROID X	.532	.400	.623
CENTROID Y	.418	.614	.579
POA TO CENTROID in.	.677	.733	.851
MIN RADIUS	.253	.159	.119
MEAN RADIUS	1.130	1.012	.888
MAX RADIUS	2.130	1.812	1.435
HORIZONTAL SPREAD	3.191	3.191	2.040
VERTICAL SPREAD	3.142	2.188	2.188
EXTREME SPREAD	3.848	3.287	2.581
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	7		

26 Jan 1988

FILE:/PATTERNING/CENTERFIRE_PATT/06225237

CENTERFIRE PATTERNS

2

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS - 10

IN CIR

1in = 1

2in = 6

3in = 8

HS# 2.085

VS# 4.185

GS# 4.215

PATTERN #

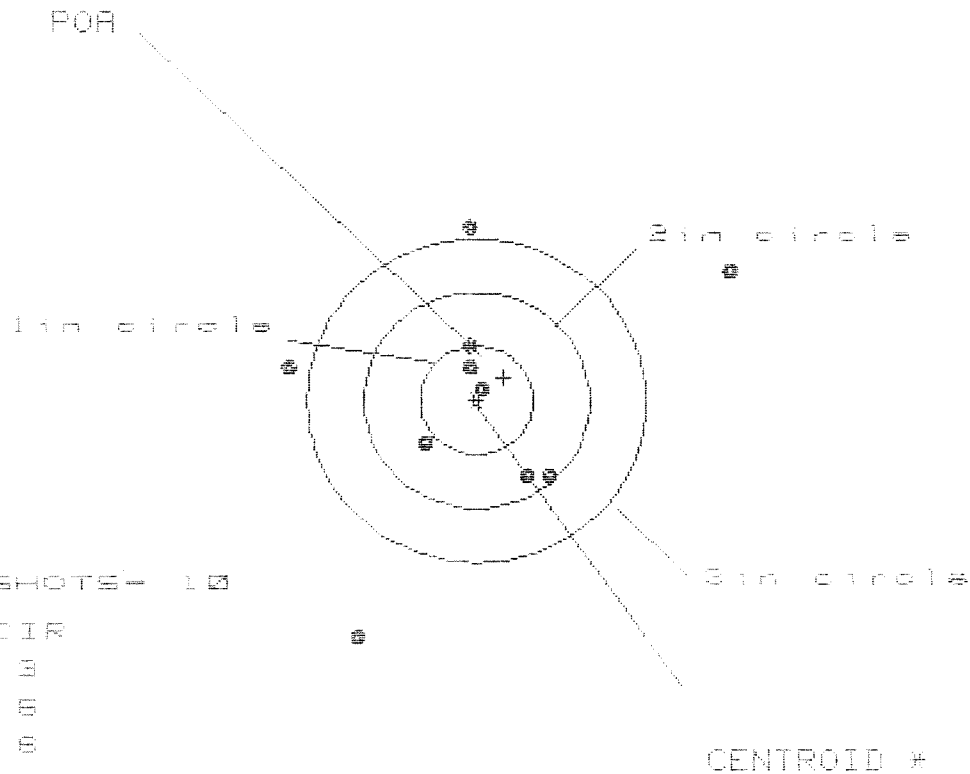
2

SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.096	1.042	.912
MINIMUM X	:	-.989	-1.043	-.841
MAXIMUM Y	:	2.260	1.091	.882
MINIMUM Y	:	-1.925	-1.674	-.968
CENTROID X	:	.288	.342	.472
CENTROID Y	:	-.267	-.518	-.309
POA TO CENTROID in.	:	.393	.621	.564
MIN RADIUS	:	.210	.176	.323
MEAN RADIUS	:	1.068	.916	.784
MAX RADIUS	:	2.311	1.972	1.182
HORIZONTAL SPREAD	:	2.085	2.085	1.753
VERTICAL SPREAD	:	4.185	2.765	1.850
EXTREME SPREAD	:	4.215	2.851	2.181
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

26 Jan 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C8225237

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 3

2in = 3

3in = 4

HS= 3.889

VS= 3.777

GS= 4.741

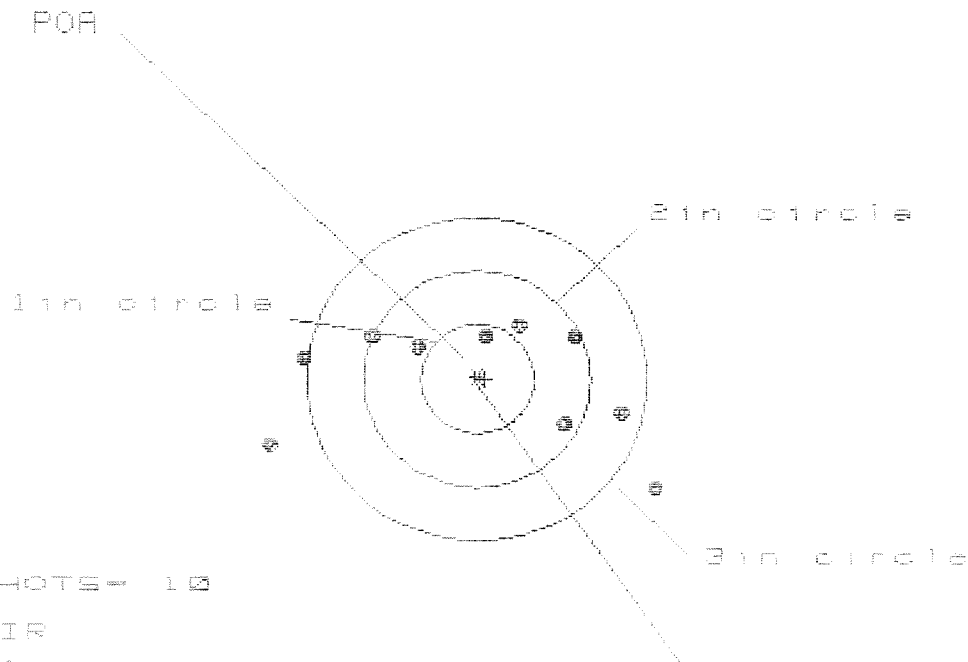
PATTERN #	3	3	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	2.243	.880	.774
MINIMUM X	-1.656	-1.407	-1.513
MAXIMUM Y	1.573	1.702	1.442
MINIMUM Y	-2.204	-2.075	-1.830
CENTROID X	-.243	-.492	-.386
CENTROID Y	-.208	-.337	-.078
POA TO CENTROID in.	.320	.596	.393
MIN RADIUS	.129	.347	.204
MEAN RADIUS	1.149	1.023	.809
MAX RADIUS	2.525	2.242	1.529
HORIZONTAL SPREAD	3.899	2.287	2.267
VERTICAL SPREAD	3.777	3.777	2.272
EXTREME SPREAD	4.741	3.910	2.502
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		6	

26 Jan 1989

FILE:/PATTERNING/CENTERFIRE_PATT/08225237

CENTERFIRE PATTERNS

4



OF SHOTS= 10

IN CIR

1in = 1

2in = 5

3in = 7

HDI= 3.253

VS= 1.493

GS= 3.388

PATTERN #	4	4	4
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.537	1.334	1.192
MINIMUM X	-1.826	-1.745	-1.579
MAXIMUM Y	.507	.443	.312
MINIMUM Y	-.986	-1.050	-.586
CENTROID X	-.071	.132	-.035
CENTROID Y	.003	.067	.198
POA TO CENTROID in.	.071	.148	.201
MIN RADIUS	.355	.321	.156
MEAN RADIUS	1.105	.979	.860
MAX RADIUS	1.916	1.751	1.579
HORIZONTAL SPREAD	3.363	3.079	2.770
VERTICAL SPREAD	1.493	1.493	.898
EXTREME SPREAD	3.388	3.303	2.815
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		7	

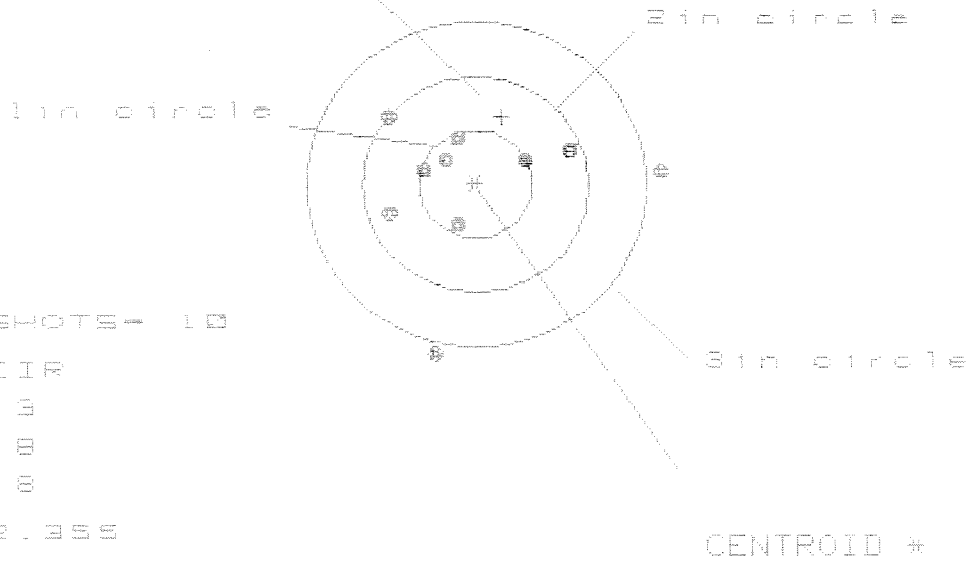
26 Jan 1989

FILE:/PATTERNING/CENTERFIRE_PATT/06225237

CENTERFIRE PATTERNS

5

POA



OF SHOTS- 10

IN CIR

1in = 3

2in = 3

3in = 8

HS= 2.355

VS= 2.147

GS= 2.595

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.614	.992	.972
MINIMUM X	-.741	-.561	-.581
MAXIMUM Y	.615	.635	.446
MINIMUM Y	-1.532	-1.512	-.551
CENTROID X	-.234	-.414	-.334
CENTROID Y	-.629	-.649	-.468
POA TO CENTROID in.	.672	.770	.606
MIN RADIUS	.391	.310	.159
MEAN RADIUS	.811	.690	.549
MAX RADIUS	1.624	1.520	.991
HORIZONTAL SPREAD	2.355	1.553	1.553
VERTICAL SPREAD	2.147	2.147	.597
EXTREME SPREAD	2.595	2.214	1.693
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		8	
NUMBER IN THREE INCH CIRCLE =		8	

RECEIVING AND ESTIMATING REPORT

ORDER
R 96-11026

INITIAL
JJM

CUSTOMER ORDER NO.

M-24 SNIPER

DATE RECEIVED
04/23/96

DATE OPENED
04/24/96

DATE CODE

SERIAL NUMBER
C6225237

NEW SERIAL NUMBER

MODEL AND GRADE
700 7.62

NATO

ACCESSORIES
HARD CASE

FROM:

SHIP TO:

U S ARMY
D CO 1/5 SFG (A)
FT CAMPBELL

KY 42223

U S ARMY
D CO 1/5 SFG (A)
FT CAMPBELL

KY 42223

L

CUST NO:142073 C.O.D.L

ACCOUNT NUMBER

ACCOUNT NUMBER N/C

WRITE ☐

PROM. DATE

ESTIMATED

VIA
UPS

GUN CONDITION

REPAIR CHARGE

☐ NEW

☐ LIGHTLY WORN

☐ WORN

☐ VERY WORN

☐ UNREPAIRABLE

☐ MARRED

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

PARTS

Barrel - 96003
Bolt - 96006

COMMENTS

Re powder Coat Trigger Guard Assy, Front & Rear Sight Base
Re-zinc Scope Base & Swivel Studs

REPAIRMAN

PROOF

CLEAN

TEST

TARGET

PATTERN

GALLERY TESTER

DATE

DATE

DATE

DATE

DATE

rw

rw

✓

✓

✓

✓

rw

4/29/96

5/8/96

5/8/96

5/8/96

MAINTENANCE REQUEST				PAGE NO. 1	NO. OF PAGES 1	REQUIREMENTS CONTROL SYMBOL CSGLD - 1047(R1)	
SECTION I - EQUIPMENT DATA							
CONTROL NUMBER		WORK ORDER NO.		WESDC	ORG. PD	PD AUTHENTICATION	
☒ Work Request ☐ MWO ☐ Warranty Claim		1A. ORGANIZATION Dco 15 of 6(A)		B. LOCATION Ft Campbell Ky 42223		C. UNIT IDENT CODE WH04D0	
2. SERIAL NO. C6225237		3. NOUN NOMENCLATURE M-24 Sniper Rifle 7.62mm		4. LINE NO.		5. MODEL	
6. NATIONAL STOCK NUMBER 1005-01-240-2136							
7A. MAINTENANCE ACTIVITY		B. LEVEL		8. UTILIZATION CODE		9A. MCSR ITEM	
14. FAILURE DETECTED DURING (Select one - use ☒ or X)				15. FIRST INDICATION OF TROUBLE (Select one - use ☒ or X)			
☐ A Sch. Main. ☐ C Test ☐ E Storage ☐ G Flight ☐ B Handling ☐ D Normal Op ☐ F Inspection ☐ H Other				☐ 068 Inoperative ☐ 258 Overheating ☐ 790 Out of Adjustment ☐ 008 Noisy ☐ 387 Low Performance ☐ Other			
16A. DESCRIBE DEFICIENCIES OR SYMPTOMS ON THE BASIS OF COMPLETE CHECKOUT AND DIAGNOSTIC PROCEDURE IN EQUIPMENT TM (Do not prescribe repairs). Cracked Bolt handle / weapon will not Group							
B. REMARKS Poa Mutarelli; Matthew R. Br Arms Room BLD 3218 198007 (50A) 714 3868 # 3868 Excessive Rounds							
PREPARATION INSTRUCTIONS (Prior to using this form, read DA PAM 738-750 for detailed preparation instructions)							
1. Place a " ☒ " or an "X" in the box for the type of action required. 2. Enter the WESDC if the item is Materiel Condition Status Reportable. 3. Enter the priority designator as determined from the urgency of need and force activity designator. 4. The Unit Commander, Chief of TDA activity or their designated representative will authenticate, by signature, a priority of 01 through 08. 5. Block 1A. Enter the name of the organization submitting the request. 6. Block 1B. Enter the unit submitting the request; units overseas enter APO only. 7. Block 1C. Enter the unit identification code of the unit in block 1A. 8. Block 2. Enter the equipment serial number. For ammunition, enter the lot number. For administrative-use vehicles, enter the USA registration number. 9. Block 3. Enter the noun abbreviation of the item. 10. Block 4. Enter the item line number, if applicable. 11. Block 5. Enter the model number. 12. Block 6. Enter the National Stock Number of the item listed in Block 3.				13. Block 7. Enter the name of the support activity. 14. Block 7A. Enter the symbol of the maintenance category (O, F, H, D, or L). 15. Block 8. Enter the utilization code. 16. Block 9A. Enter the word "yes" if the item is Materiel Condition Status Reportable. 17. Block 9B. Enter the equipment readiness code, if applicable. 18. Block 9C. Enter the word "yes" if the item is a pacing item. 19. Block 10. Enter the hour reading, if applicable. 20. Block 11. Enter the mileage from the odometer, if applicable. 21. Block 12. Enter the total rounds fired, if applicable. 22. Block 13. For turbine engines, enter the number of hot starts. 23. Block 14. Enter a " ☒ " or "X" in the proper block. 24. Block 15. Enter a " ☒ " or "X" in the proper block. 25. Block 16. Describe briefly the fault or symptoms needing correction.			
23. SUBMITTED BY Matthew R. Br		24. RECEIVED BY					
JULIAN DATE 6071		JULIAN DATE					

NMP COPY 2

Final Inspection

Sn: C6225937

DATE REC'D: 4/24/96

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:

Barrel & Bolt

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # *C6225237*

OP. #	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and Stock		<i>4/29/96</i>	<i>RW</i>
600	Proof		<i>4/29/96</i>	<i>RW</i>
607	Check Headspace		<i>4/29/96</i>	<i>RW</i>
610	Dis-assemble Gun		<i>4/29/96</i>	<i>RW</i>
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		<i>5/8/96</i>	<i>RW</i>
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		<i>5/8/96</i>	<i>RW</i>
	C) Inspect Ejector Hole for Chamfer		<i>5/8/96</i>	<i>RW</i>
	D) Oil Firing Pin Ass'y		<i>5/8/96</i>	<i>RW</i>
	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		5/8/96	PA
	A) Time			
	B) Malfunctions			
	C) Pierced Primers			
	D) Optical Clarity of Scope			
645	Inspect for Live Ammo		5/8/96	PA
655	Final Inspection			
	A) Headspace		5/11/96	PW
	B) Trigger Pull		5/11/96	PW
	C) Function		5/11/96	PW
660	Pack			

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6225237
12 Mar 1966

CENTROIDAL DISTANCES

0 TO	1	.518337
1 TO	2	.404599
1 TO	3	.382969
1 TO	4	.292277
1 TO	5	.414287

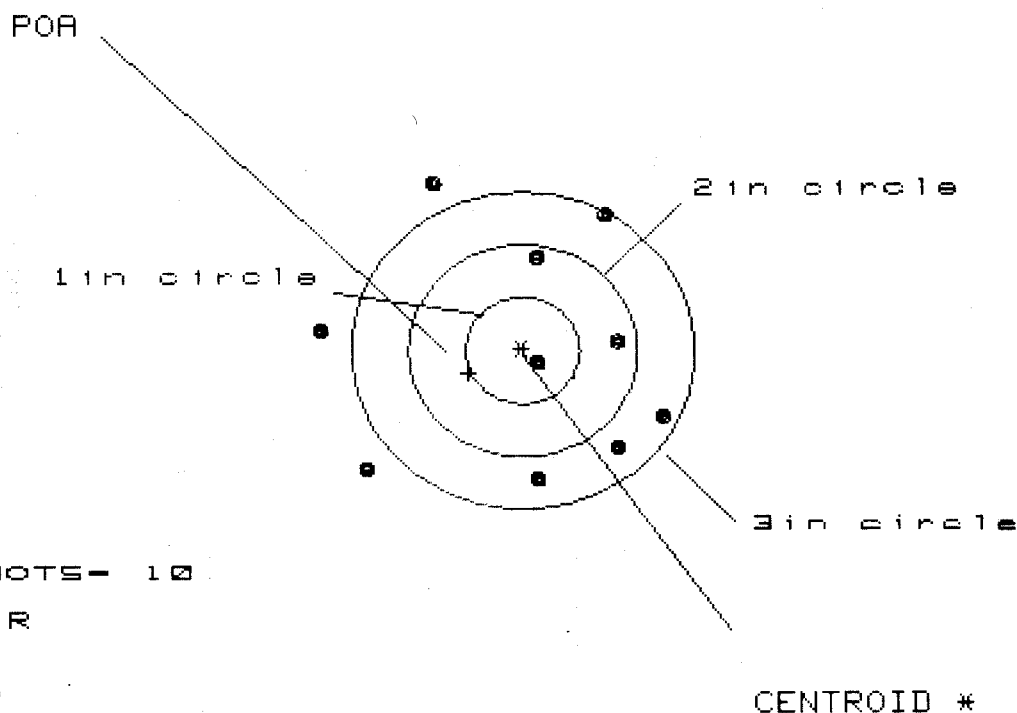
243
+ (----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .4594
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .4446
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .63931
THE AMR FOR THIS RIFLE IS: .996

11 Mar 1900

FILE:/PATTERNING/CENTERFIRE_PATT/C6225237

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 1

2in = 3

3in = 7

HS= 3.019

VS= 2.800

GS= 3.238

PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.221	1.063	.819
MINIMUM X	:	-1.798	-1.956	-1.208
MAXIMUM Y	:	1.540	1.412	1.421
MINIMUM Y	:	-1.260	-1.388	-1.379
CENTROID X	:	.473	.631	.875
CENTROID Y	:	.212	.340	.331
POA TO CENTROID in.	:	.519	.717	.936
MIN RADIUS	:	.157	.219	.343
MEAN RADIUS	:	1.259	1.168	1.031
MAX RADIUS	:	1.829	1.957	1.865
HORIZONTAL SPREAD	:	3.019	3.019	2.027
VERTICAL SPREAD	:	2.800	2.800	2.800
EXTREME SPREAD	:	3.238	3.121	2.963
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	3		
NUMBER IN THREE INCH CIRCLE	=	7		

11 Mar 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C6225237

CENTERFIRE PATTERNS # 2

POA

1 in circle

2 in circle

3 in circle

OF SHOTS = 10

IN CIR

1 in = 2

2 in = 8

3 in = 10

HS = 1.885

VS = 1.443

GS = 2.207

CENTROID #

PATTERN #	:	2	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.160	1.222	.728
MINIMUM X	:	-.825	-.696	-.543
MAXIMUM Y	:	.560	.510	.522
MINIMUM Y	:	-.883	-.933	-.870
CENTROID X	:	.163	.034	-.119
CENTROID Y	:	.472	.522	.459
POA TO CENTROID in.	:	.499	.523	.474
MIN RADIUS	:	.190	.052	.137
MEAN RADIUS	:	.764	.670	.570
MAX RADIUS	:	1.246	1.324	1.108
HORIZONTAL SPREAD	:	1.985	1.918	1.271
VERTICAL SPREAD	:	1.443	1.443	1.392
EXTREME SPREAD	:	2.207	2.040	1.857
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	

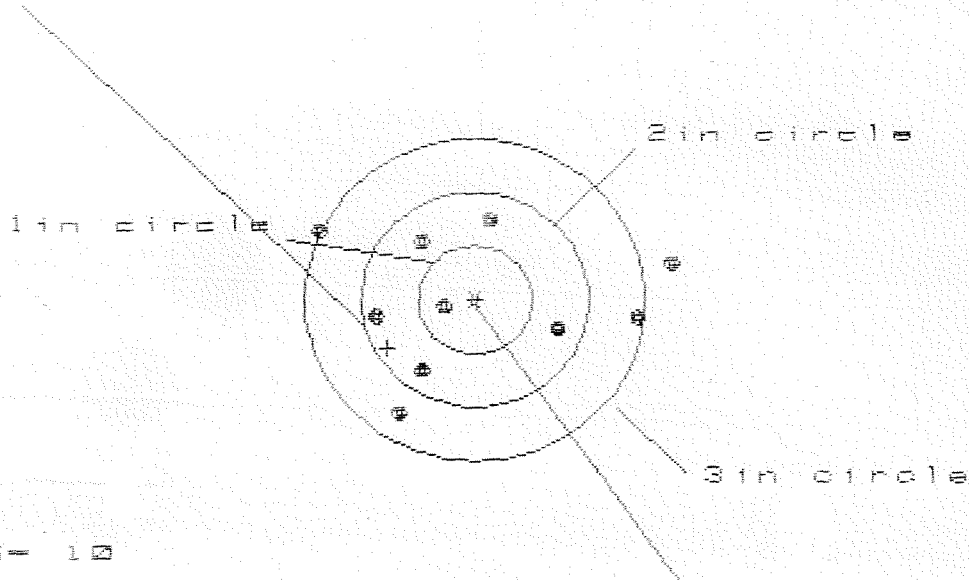
11 Mar 1968

FILE:/PATTERNING/CENTERFIRE_PATT/C8225237

CENTERFIRE PATTERNS

3

POA



OF SHOTS= 10

IN CIR

1in = 1

2in = 6

3in = 8

HS= 3.131

VS= 1.745

GS= 3.147

CENTROID #

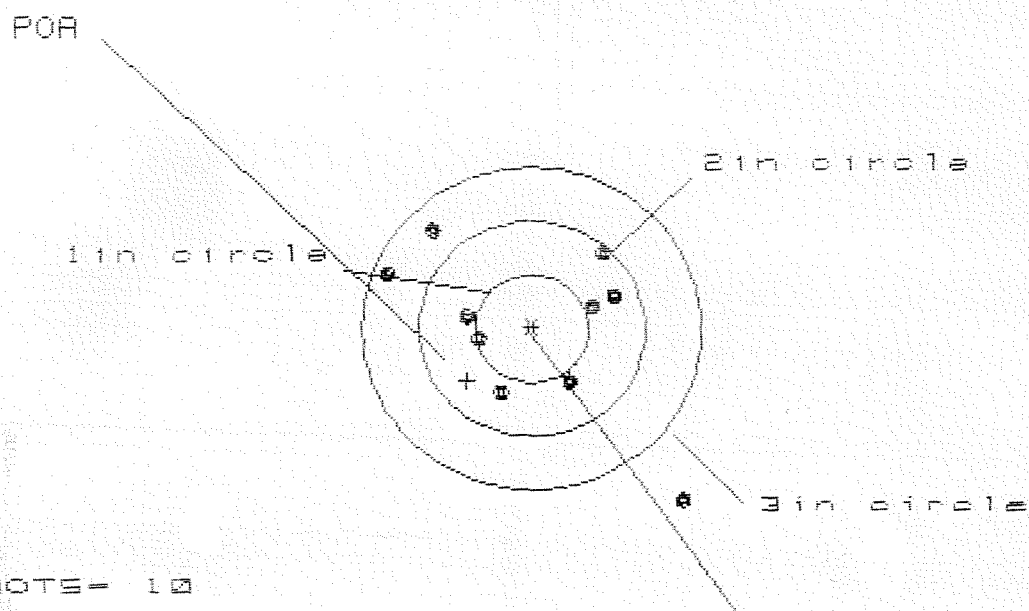
PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.767	1.642	1.496
MINIMUM X	-1.364	-1.167	-.816
MAXIMUM Y	.720	.758	.846
MINIMUM Y	-1.025	-.987	-.899
CENTROID X	.769	.572	.718
CENTROID Y	.455	.417	.329
POA TO CENTROID in.	.893	.708	.790
MIN RADIUS	.241	.052	.183
MEAN RADIUS	1.014	.880	.839
MAX RADIUS	1.801	1.643	1.496
HORIZONTAL SPREAD	3.131	2.809	2.312
VERTICAL SPREAD	1.745	1.745	1.745
EXTREME SPREAD	3.147	2.913	2.338
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	8		

11 Mar 1968

FILE:/PATTERNING/CENTERFIRE_PATT/C8225237

CENTERFIRE PATTERNS

4



OF SHOTS= 10

IN CIR

1 in = 6

2 in = 7

3 in = 9

HS= 2.548

VS= 2.455

GS= 3.246

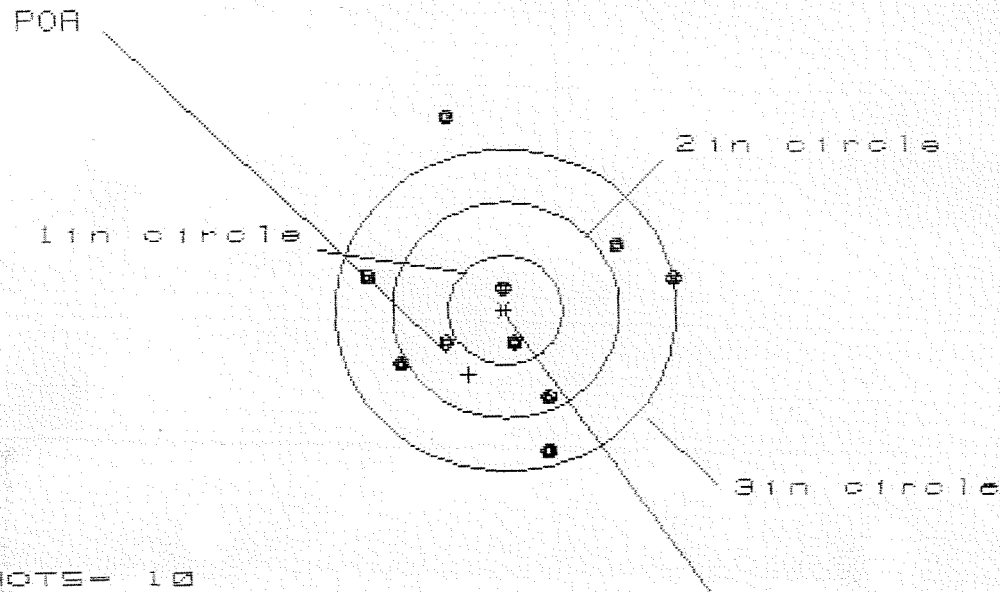
CENTROID *

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.278	.873	.732
MINIMUM X	-1.278	-1.128	-.844
MAXIMUM Y	.915	.744	.781
MINIMUM Y	-1.540	-.796	-.759
CENTROID X	.572	.430	.571
CENTROID Y	.487	.658	.621
POA TO CENTROID in.	.751	.786	.844
MIN RADIUS	.520	.430	.505
MEAN RADIUS	.930	.799	.742
MAX RADIUS	2.001	1.167	1.150
HORIZONTAL SPREAD	2.548	2.001	1.576
VERTICAL SPREAD	2.455	1.540	1.540
EXTREME SPREAD	3.246	2.011	1.821
NUMBER IN ONE INCH CIRCLE =	6	7	9
NUMBER IN TWO INCH CIRCLE =	7	7	9
NUMBER IN THREE INCH CIRCLE =	9	9	9

11 Mar 1968

FILE:/PATTERNING/CENTERFIRE_PATT/CG225237

CENTERFIRE PATTERNS # 5



OF SHOTS = 10

IN CIR

1 in = 2

2 in = 4

3 in = 8

HS = 2.734

VS = 3.114

GS = 3.238

CENTROID *

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.466	1.407	1.102
MINIMUM X	-1.253	-1.327	-1.151
MAXIMUM Y	1.774	.753	.814
MINIMUM Y	-1.340	-1.143	-1.082
CENTROID X	.320	.379	.203
CENTROID Y	.597	.490	.337
POA TO CENTROID in.	.678	.551	.395
MIN RADIUS	.208	.054	.193
MEAN RADIUS	1.013	.890	.806
MAX RADIUS	1.852	1.490	1.370
HORIZONTAL SPREAD	2.734	2.734	2.253
VERTICAL SPREAD	3.114	1.896	1.896
EXTREME SPREAD	3.238	2.734	2.337
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	9		