C6594652

MODEL 700™ M24

Model SWS™

Action

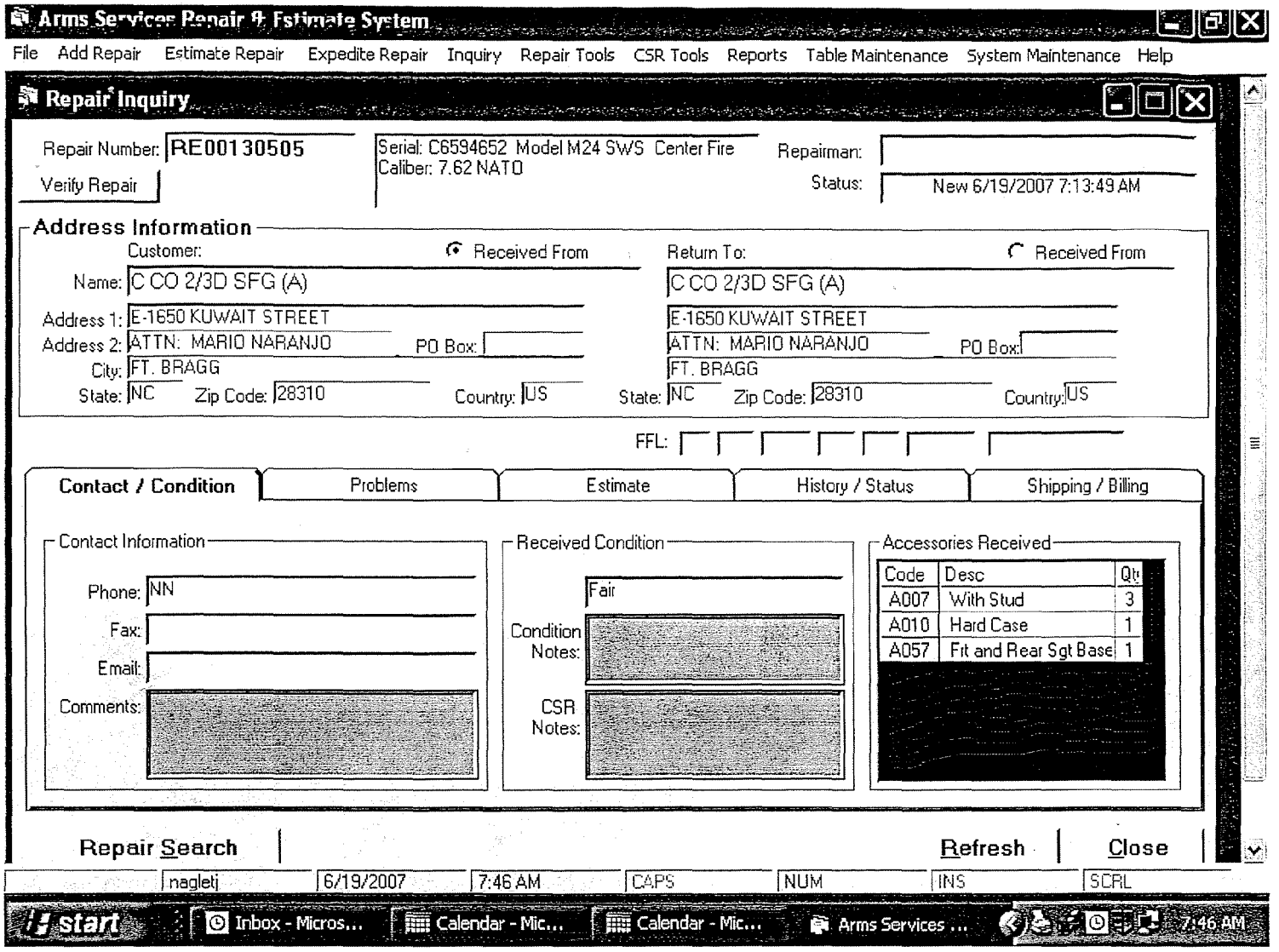
Barrel Length

Capacity

Order No. 5716

*Includes 1 in chamber.

Remington



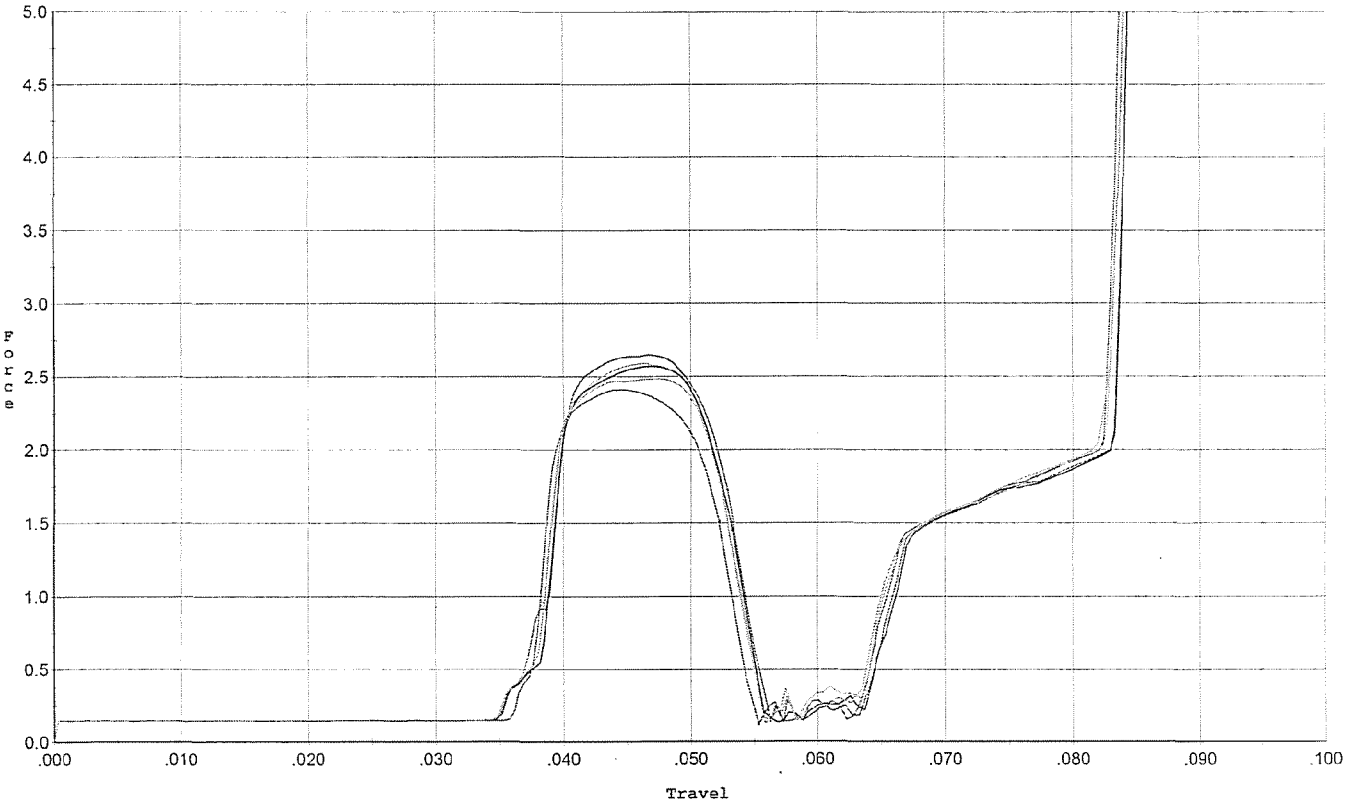
Serial Number: C6594652

Model: M24 SWS

RE00130505

Trigger Profile [lbs,inch]

Profile	SWS	**Model:**	M/24
GunType:	Rifle	**Serial No:**	Form #F005
Make:	Remington	**Trigger:**	2.5 lbs. ini. +/- .50 lbs.
Note:	R. Putch 7/17/07		



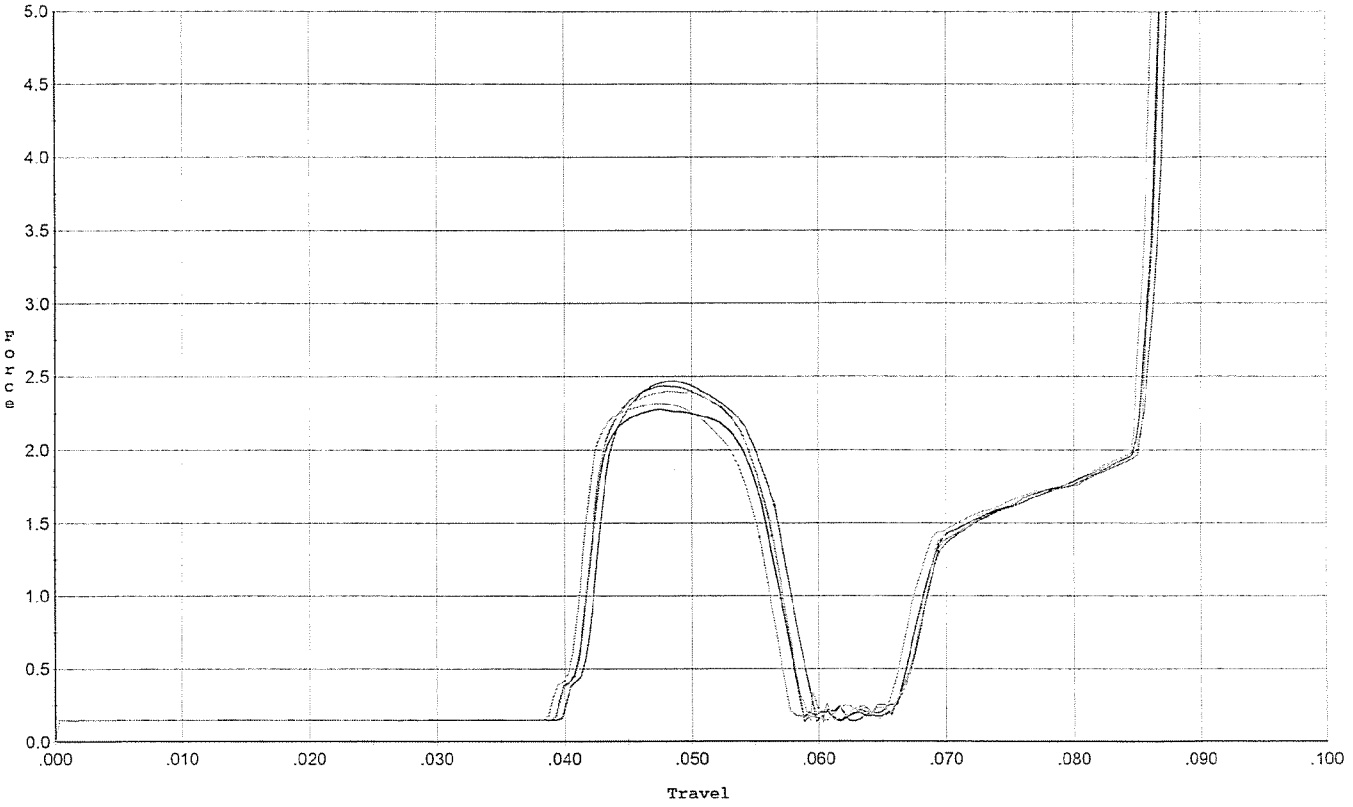
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.645	0.053	0.036	0.037	0.041		Set Trigger
2	2.569	0.053	0.035	0.038	0.040		Set Trigger
3	2.409	0.052	0.036	0.038	0.037		Set Trigger
4	2.588	0.052	0.035	0.038	0.040		Set Trigger
5	2.486	0.054	0.035	0.037	0.041		Set Trigger

Avg 2.53

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc.. 7/17/2007 10:17:42 PM

Trigger Profile [lbs,inch]

Profile	SWS	**Model:**	M/24
GunType:	Rifle	**Serial No:**	Form #F005
Make:	Remington	**Trigger:**	2.5 lbs. after 50 cycles +/- .50 lbs.
Note:	R. Putch 7/17/07		



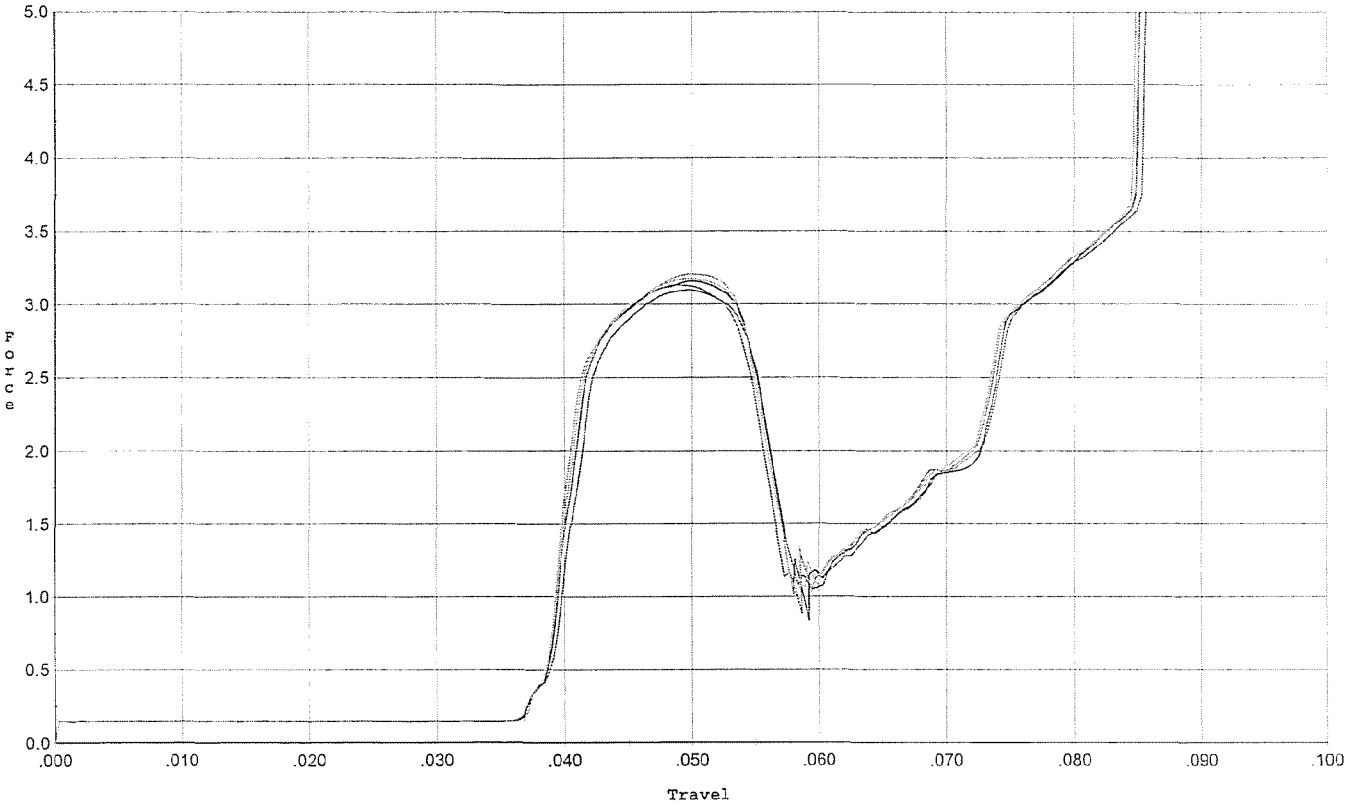
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.468	0.057	0.040	0.038	0.039		Set Trigger
2	2.274	0.057	0.040	0.038	0.038		Set Trigger
3	2.436	0.056	0.040	0.038	0.039		Set Trigger
4	2.395	0.056	0.040	0.038	0.039		Set Trigger
5	2.313	0.055	0.039	0.038	0.037		Set Trigger

AVG 2.37

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc.. 7/17/2007 10:22:08 PM

Trigger Profile [lbs,inch]

Profile	SWS	**Model:**	M/24
GunType:	Rifle	**Serial No:**	Form #F005
Make:	Remington	**Trigger:**	3.0 lbs. ini. +/- .75 lbs.
Note:	R. Putch 7/17/07		



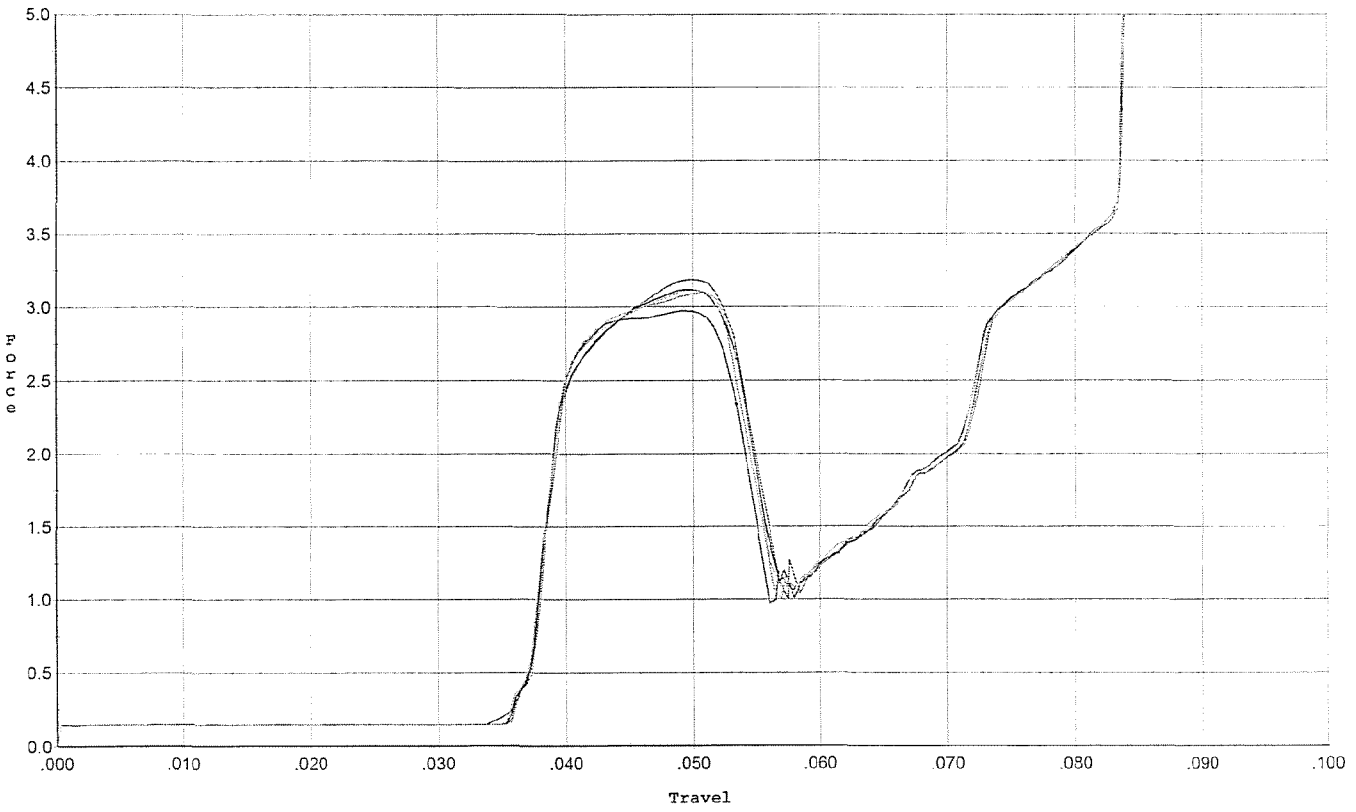
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.097	0.055	0.037	0.036	0.051		Set Trigger
2	3.157	0.055	0.037	0.036	0.053		Set Trigger
3	3.131	0.055	0.037	0.036	0.051		Set Trigger
4	3.175	0.054	0.037	0.036	0.051		Set Trigger
5	3.204	0.056	0.037	0.035	0.054		Set Trigger

Avg 3.15

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc.. 7/17/2007 10:25:18 PM

Trigger Profile [lbs,inch]

Profile	SWS	**Model:**	M/24
GunType:	Rifle	**Serial No:**	Form #F005
Make:	Remington	**Trigger:**	3.0 lbs. after 20 cycles +/- .75 lbs.
Note:	R. Putch 7/17/07		



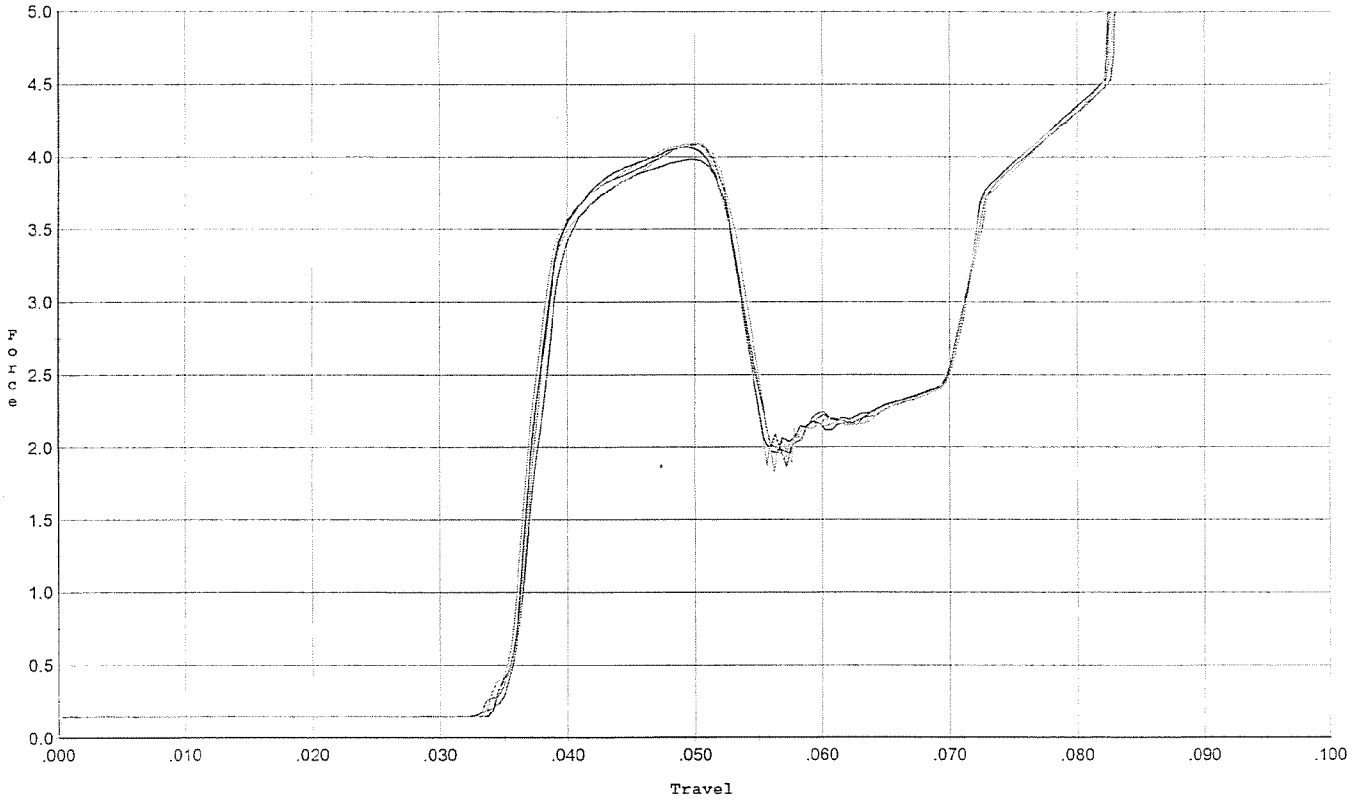
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.972	0.053	0.036	0.036	0.050		Set Trigger
2	3.115	0.053	0.036	0.036	0.052		Set Trigger
3	3.184	0.053	0.036	0.036	0.052		Set Trigger
4	3.111	0.054	0.036	0.036	0.053		Set Trigger
5	3.097	0.053	0.036	0.036	0.052		Set Trigger

Avg 3.09

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc.. 7/17/2007 10:28:12 PM

Trigger Profile [lbs,inch]

Profile	SWS	**Model:**	M/24
GunType:	Rifle	**Serial No:**	Form #F005
Make:	Remington	**Trigger:**	4.0 lbs. ini. +/- 1.0 lbs.
Note:	R. Putch 7/17/07		



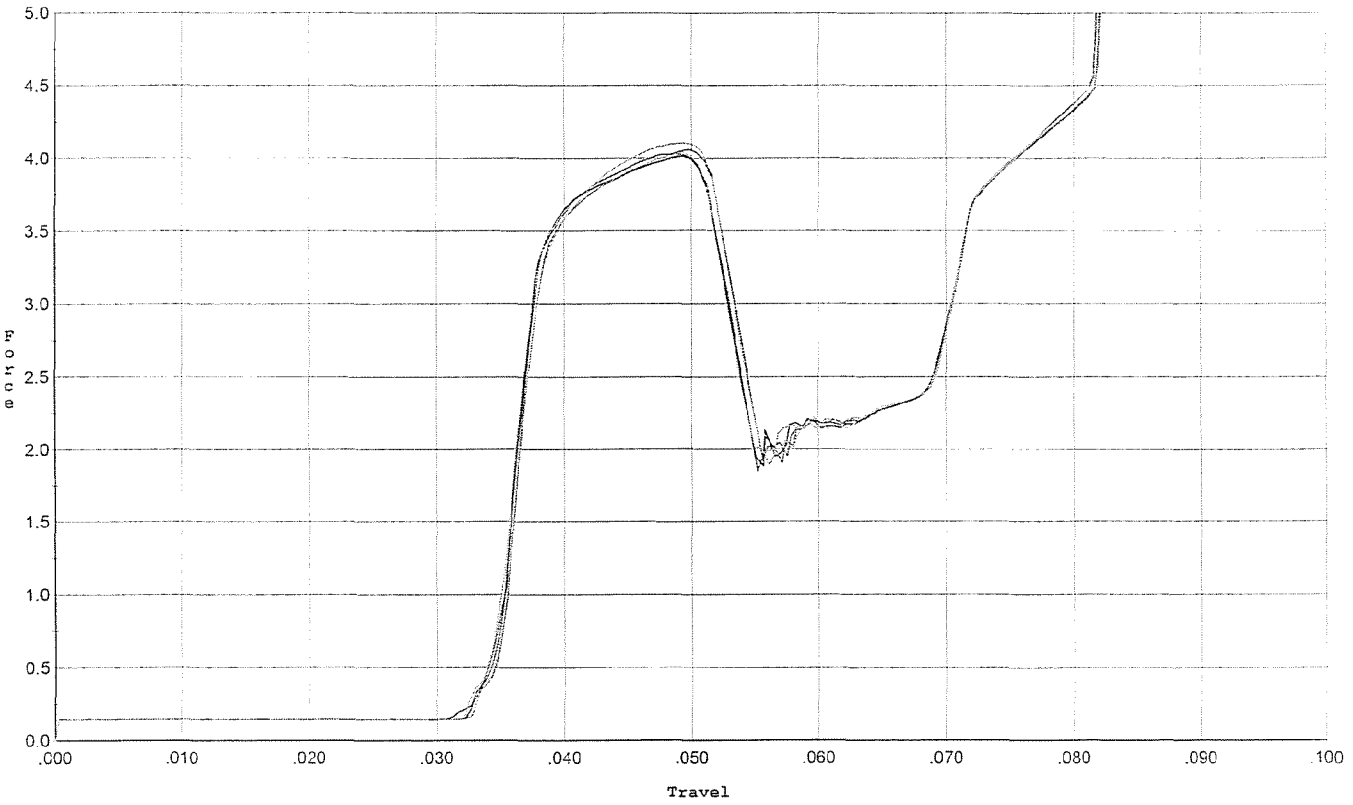
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.981	0.052	0.035	0.034	0.066		Set Trigger
2	4.069	0.053	0.035	0.034	0.068		Set Trigger
3	4.090	0.052	0.034	0.034	0.068		Set Trigger
4	4.096	0.053	0.034	0.034	0.070		Set Trigger
5	4.095	0.053	0.034	0.034	0.069		Set Trigger

Avg 4.06

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc.. 7/17/2007 10:30:07 PM

Trigger Profile [lbs,inch]

Profile	SWS	**Model:**	M/24
GunType:	Rifle	**Serial No:**	Form #F005
Make:	Remington	**Trigger:**	4.0 lbs. after 20 cycles +/- 1.0 lbs.
Note:	R. Putch 7/17/07		



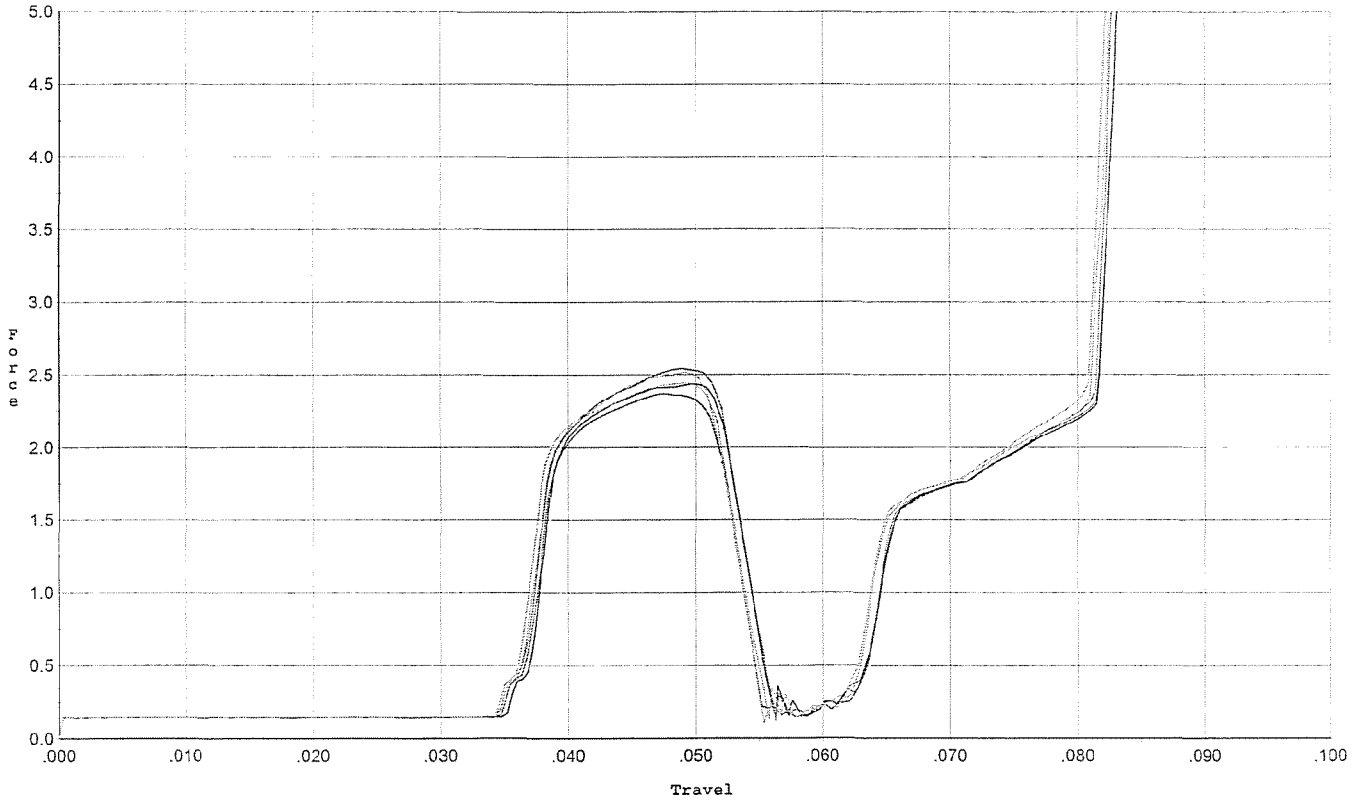
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.028	0.053	0.033	0.033	0.070		Set Trigger
2	4.012	0.051	0.033	0.034	0.067		Set Trigger
3	4.055	0.054	0.033	0.033	0.071		Set Trigger
4	4.040	0.051	0.033	0.034	0.068		Set Trigger
5	4.101	0.052	0.033	0.034	0.069		Set Trigger

AVG 4.04

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc.. 7/17/2007 10:31:33 PM

Trigger Profile [lbs,inch]

Profile	SWS	**Model:**	M/24
GunType:	Rifle	**Serial No:**	Form #F005
Make:	Remington	**Trigger:**	reset to 2.5 lbs. +/- .50 lbs. for final test
Note:	R. Putch 7/17/07		



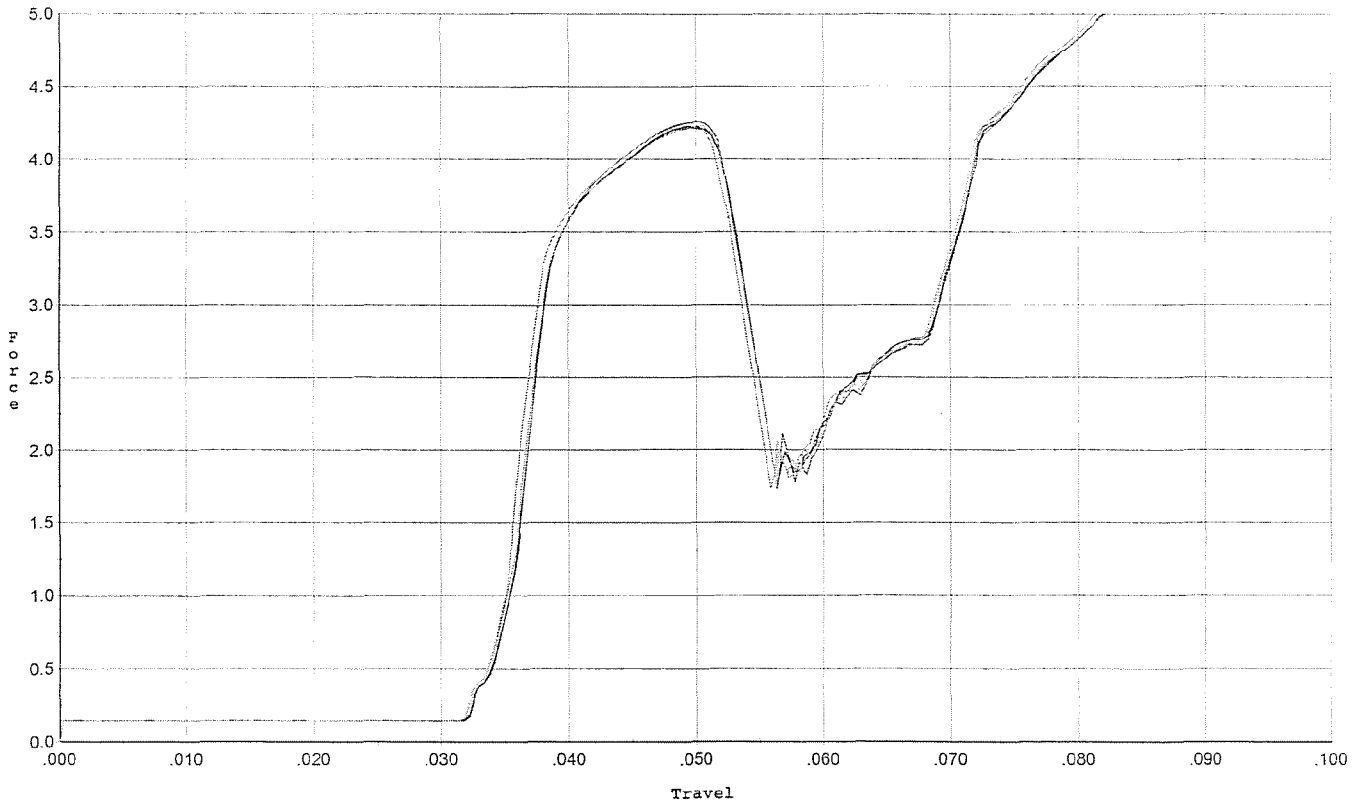
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.369	0.052	0.035	0.037	0.039		Set Trigger
2	2.436	0.052	0.036	0.037	0.040		Set Trigger
3	2.539	0.052	0.035	0.036	0.042		Set Trigger
4	2.448	0.052	0.035	0.037	0.040		Set Trigger
5	2.516	0.052	0.035	0.036	0.041		Set Trigger

Avg 2.46

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc.. 7/17/2007 10:35:14 PM

Trigger Profile [lbs,inch]

Profile	SWS	**Model:**	M/24
GunType:	Rifle	**Serial No:**	Form #F005
Make:	Remington	**Trigger:**	set to 4.0 lbs. +/- 1.0 lbs. for target & accuracy
Note:	R. Putch 7/17/07		



#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.218	0.054	0.033	0.033	0.074		Set Trigger
2	4.228	0.053	0.033	0.033	0.074		Set Trigger
3	4.264	0.053	0.032	0.033	0.074		Set Trigger
4	4.233	0.054	0.032	0.032	0.075		Set Trigger
5	4.253	0.053	0.032	0.032	0.073		Set Trigger

Avg 4.23

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc.. 7/17/2007 10:37:20 PM

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFOMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6594652.__0
FILE DATE AND TIME: 07/20/2007 22:59

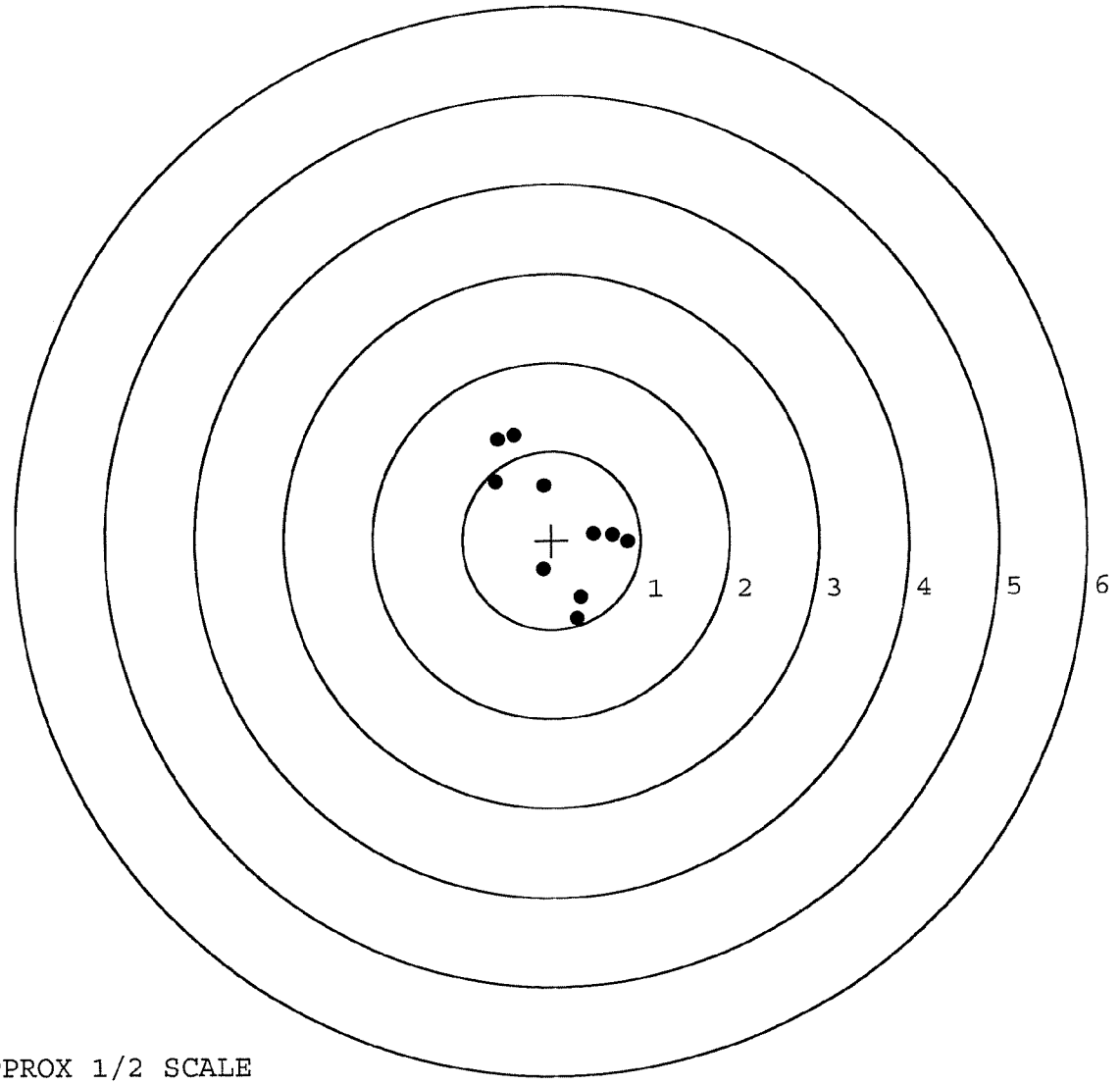
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.085
The Average Y Centroid of the Five Target Set:	-0.042
The Average Point of Impact of the Five Target Set:	0.095
The Average Mean Radius of the Five Target Set:	0.737
The Distance from POA to Centroid Target #1:	0.199
The Distance from Centroid Target #2 to Centroid Target #1:	0.431
The Distance from Centroid Target #3 to Centroid Target #1:	0.381
The Distance from Centroid Target #4 to Centroid Target #1:	0.365
The Distance from Centroid Target #5 to Centroid Target #1:	0.334

SERIAL NUMBER: C6594652.__0
TARGET NUMBER: 1
FILE DATE: 07/20/2007
FILE TIME: 22:59

X CENTROID:	0.079
Y CENTROID:	0.183
POA TO CENTROID:	0.199
HORZ SPREAD:	1.471
VERT SPREAD:	2.066
GROUP SPREAD:	2.204
MIN RADIUS:	0.405
MAX RADIUS:	1.168
MEAN RADIUS:	0.790
# IN 1 IN DIAMETER:	2
# IN 2 IN DIAMETER:	7
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	-0.599	1.134
2:	-0.415	1.181
3:	-0.621	0.658
4:	-0.086	0.613
5:	0.467	0.067
6:	0.682	0.055
7:	0.850	-0.021
8:	0.323	-0.644
9:	0.285	-0.885
10:	-0.095	-0.332

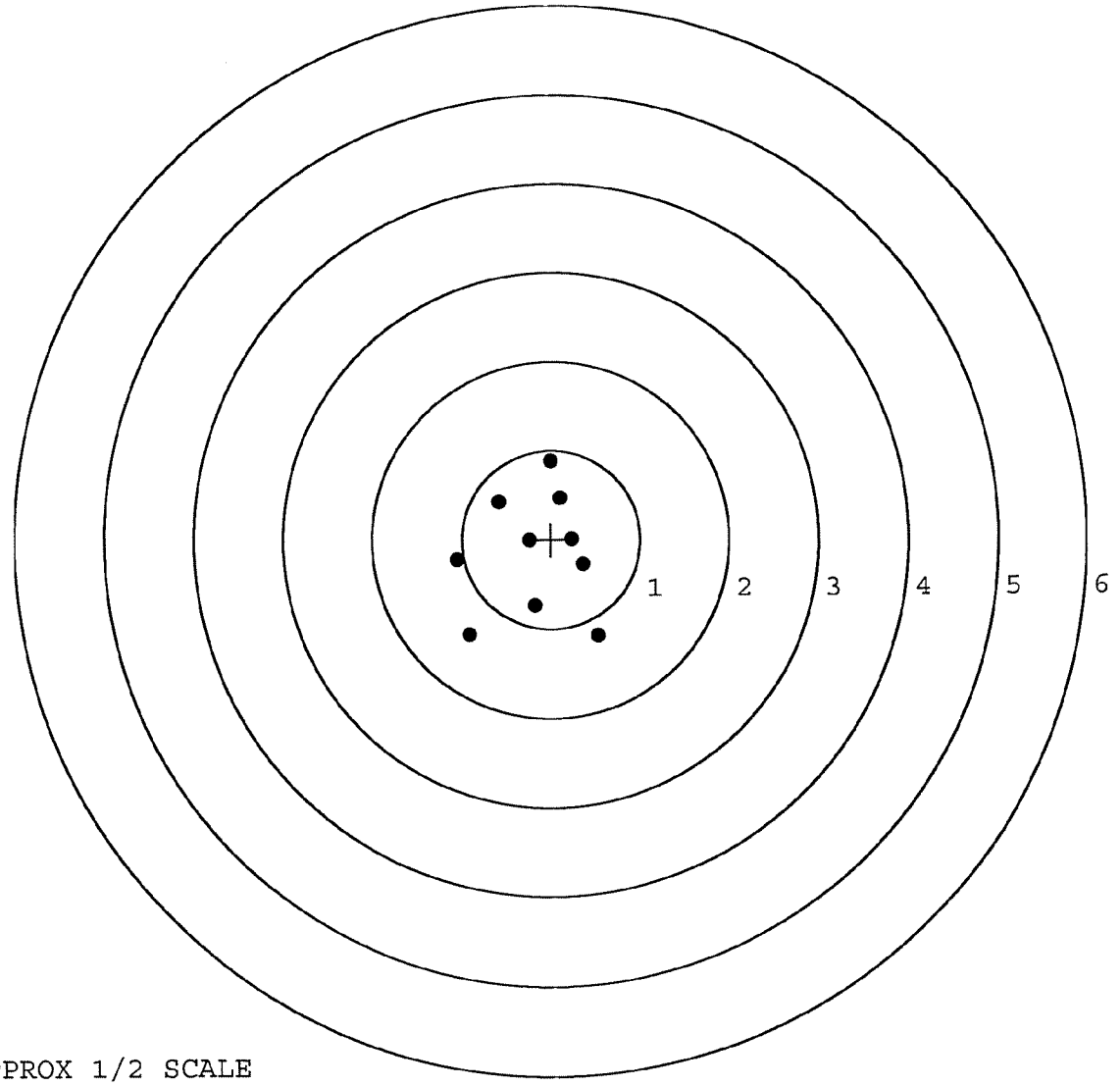


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6594652.__0
TARGET NUMBER: 2
FILE DATE: 07/20/2007
FILE TIME: 22:59

X CENTROID:	-0.179
Y CENTROID:	-0.163
POA TO CENTROID:	0.242
HORZ SPREAD:	1.575
VERT SPREAD:	1.965
GROUP SPREAD:	2.152
MIN RADIUS:	0.165
MAX RADIUS:	1.166
MEAN RADIUS:	0.739
# IN 1 IN DIAMETER:	2
# IN 2 IN DIAMETER:	7
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	0.000	0.883
2:	0.102	0.468
3:	0.227	-0.003
4:	0.356	-0.281
5:	0.521	-1.082
6:	-0.189	-0.742
7:	-0.921	-1.062
8:	-1.054	-0.223
9:	-0.244	-0.011
10:	-0.585	0.428

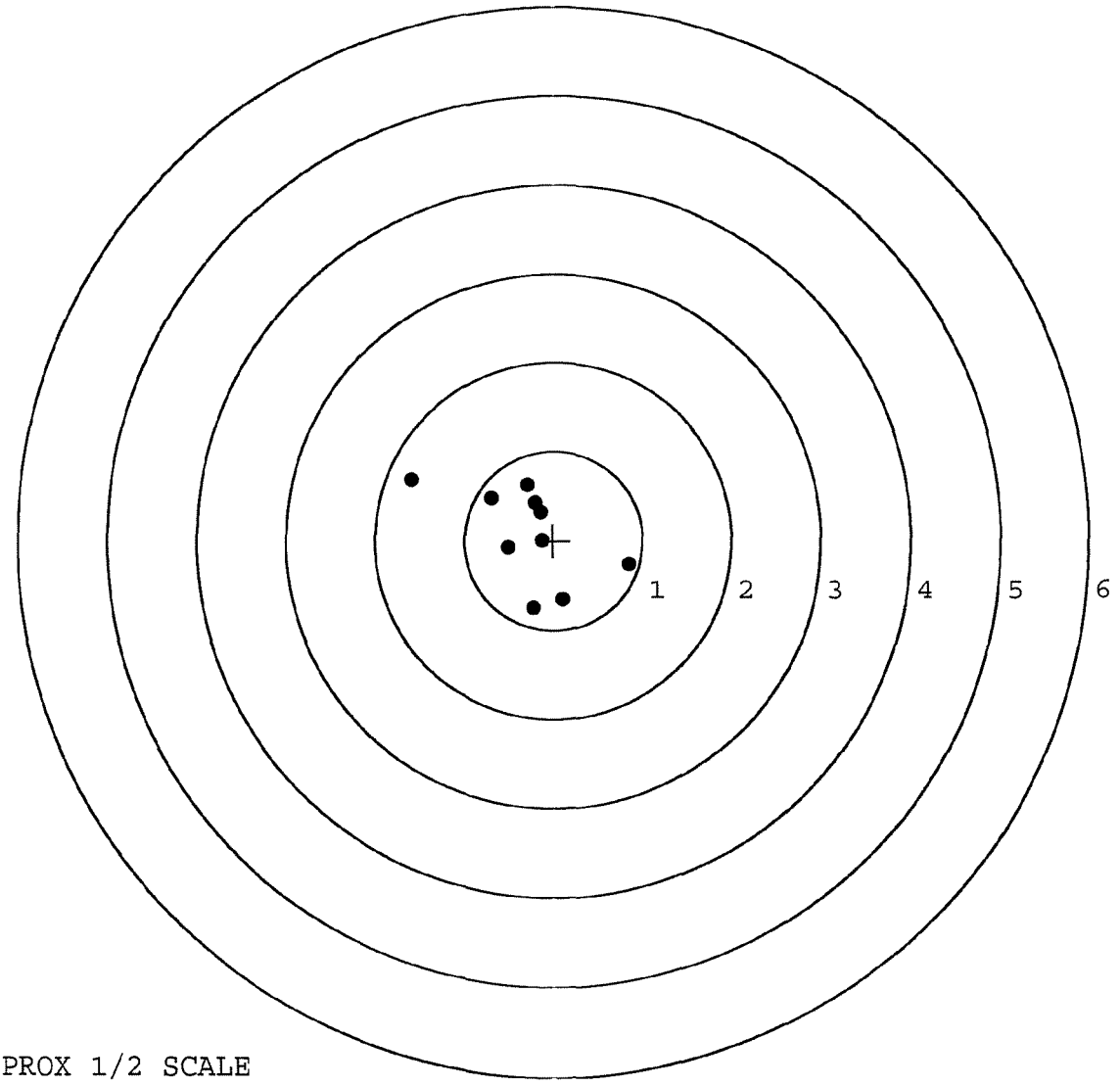


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6594652.__0
TARGET NUMBER: 3
FILE DATE: 07/20/2007
FILE TIME: 22:59

X CENTROID:	-0.287
Y CENTROID:	0.076
POA TO CENTROID:	0.297
HORZ SPREAD:	2.441
VERT SPREAD:	1.444
GROUP SPREAD:	2.620
MIN RADIUS:	0.171
MAX RADIUS:	1.441
MEAN RADIUS:	0.649
# IN 1 IN DIAMETER:	4
# IN 2 IN DIAMETER:	8
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	-1.593	0.685
2:	-0.699	0.476
3:	-0.298	0.624
4:	-0.147	0.314
5:	-0.132	0.004
6:	-0.509	-0.076
7:	-0.229	-0.759
8:	0.100	-0.661
9:	0.848	-0.268
10:	-0.209	0.423

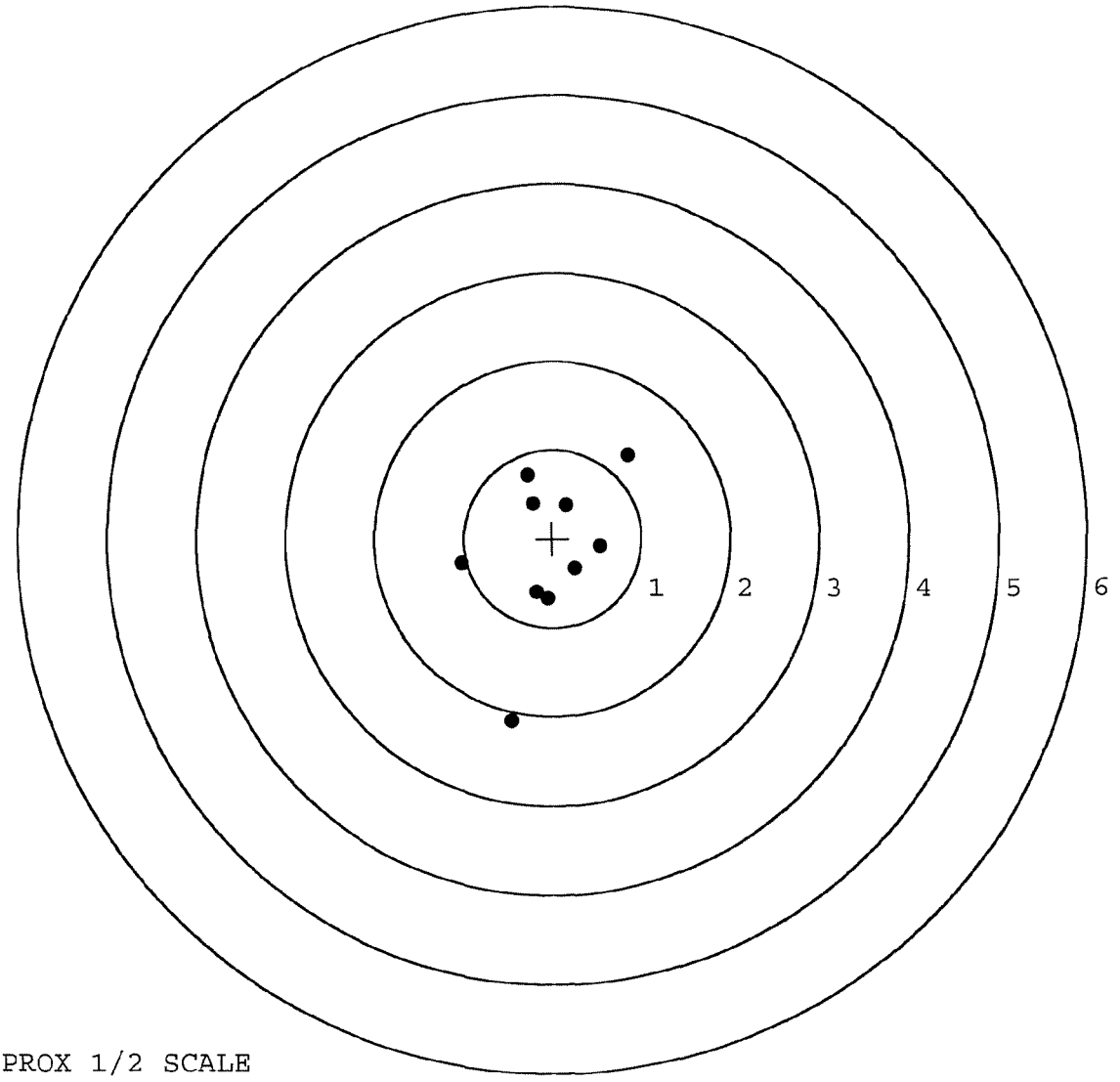


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6594652.__0
TARGET NUMBER: 4
FILE DATE: 07/20/2007
FILE TIME: 22:59

X CENTROID:	-0.045
Y CENTROID:	-0.161
POA TO CENTROID:	0.167
HORZ SPREAD:	1.873
VERT SPREAD:	2.997
GROUP SPREAD:	3.274
MIN RADIUS:	0.340
MAX RADIUS:	1.945
MEAN RADIUS:	0.832
# IN 1 IN DIAMETER:	2
# IN 2 IN DIAMETER:	8
# in 3 IN DIAMETER:	9

POINT#	X	Y
1:	-0.283	0.715
2:	-0.221	0.395
3:	0.152	0.374
4:	0.850	0.938
5:	0.537	-0.082
6:	0.250	-0.331
7:	-0.055	-0.675
8:	-0.185	-0.606
9:	-1.023	-0.280
10:	-0.468	-2.059

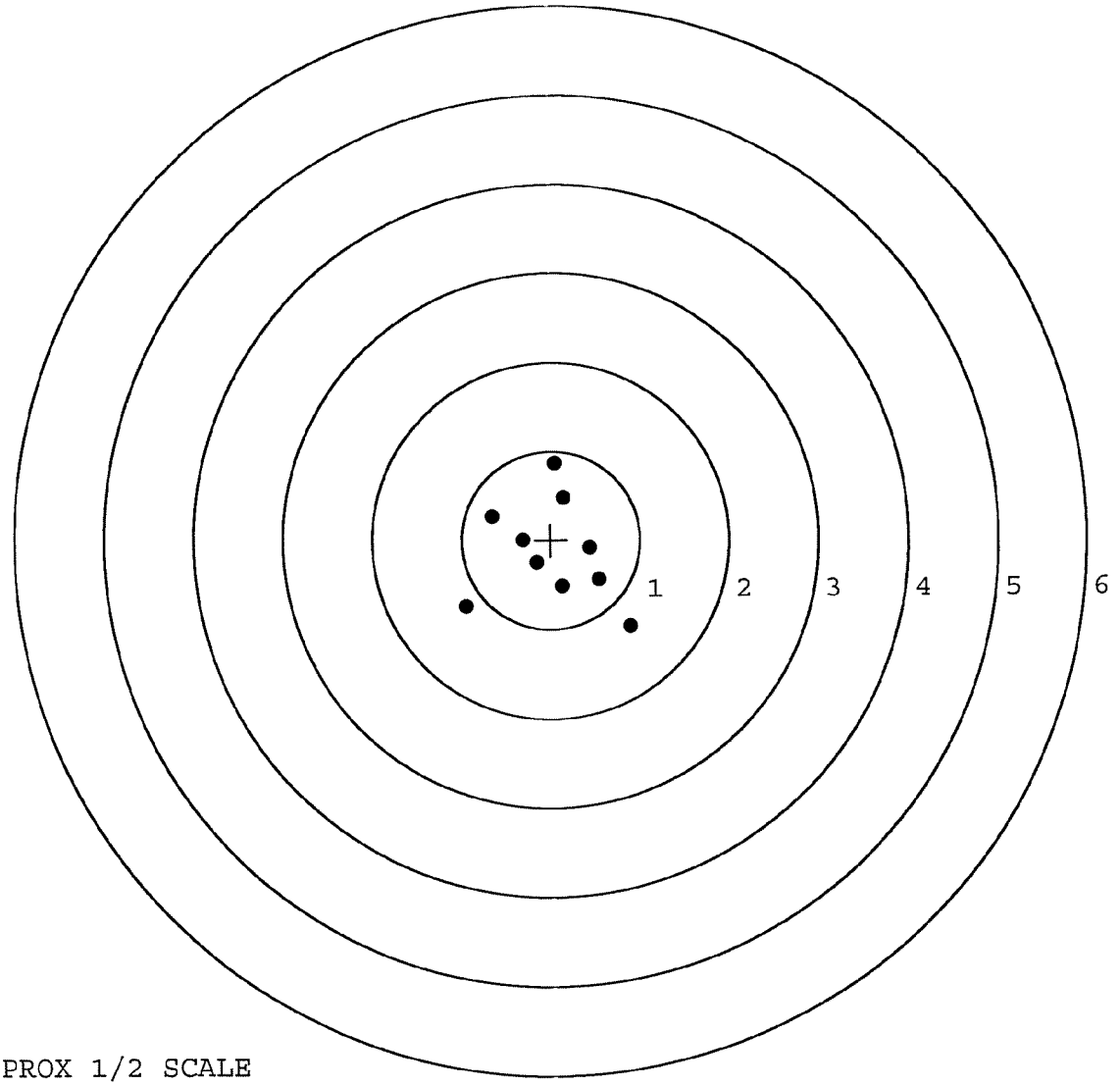


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6594652.__0
TARGET NUMBER: 5
FILE DATE: 07/20/2007
FILE TIME: 22:59

X CENTROID:	0.007
Y CENTROID:	-0.144
POA TO CENTROID:	0.144
HORZ SPREAD:	1.836
VERT SPREAD:	1.838
GROUP SPREAD:	2.019
MIN RADIUS:	0.207
MAX RADIUS:	1.208
MEAN RADIUS:	0.677
# IN 1 IN DIAMETER:	4
# IN 2 IN DIAMETER:	7
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	0.047	0.862
2:	0.142	0.474
3:	-0.660	0.268
4:	-0.318	0.005
5:	-0.165	-0.260
6:	0.437	-0.095
7:	0.124	-0.526
8:	0.534	-0.448
9:	0.882	-0.976
10:	-0.954	-0.743



TARGET APPROX 1/2 SCALE

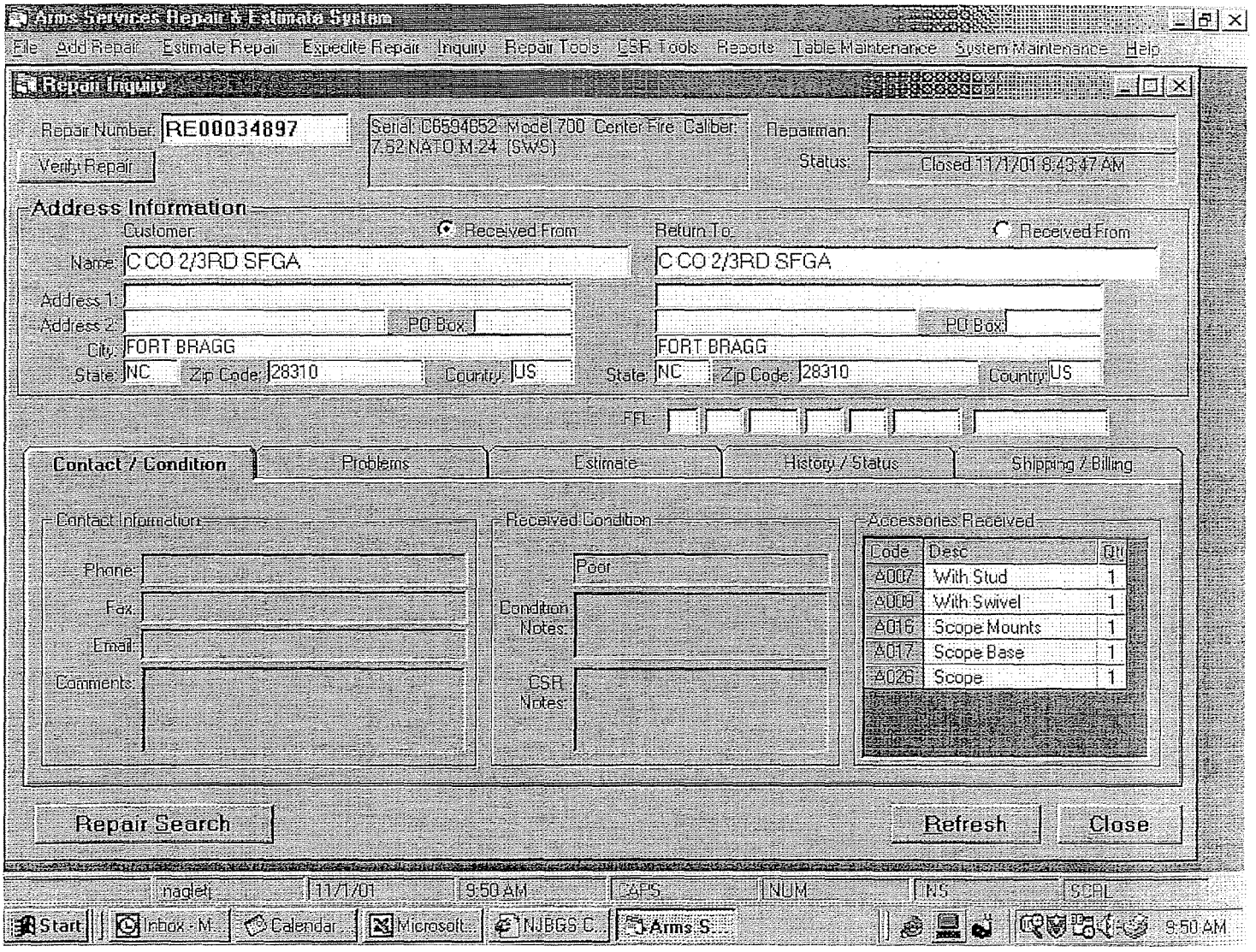
M-24 INSPECTION CHECKLIST
CONTRACT #: DAAE-20-02-C-0149

R & E NUMBER 00130505

SERIAL NUMBER C6594652

LOG-IN DATE 6-26-07

OPERATION #	OPERATION NAME		DATE	INITIAL
500	DIS-ASSEMBLE GUN		6-26-07	[illegible]
505	RE-BARREL		6-28-07	[illegible]
560	ASSEMBLE		7-9-07	RR
600	PROOF		7-10-07	TRW
605	CHECK HEADSPACE		7-10-07	TRW
610	DIS-ASSEMBLE GUN		7-11-07	RTZ
612	MAGNAFLUX	OPERATOR [illegible]	7/12/07	[illegible]
510	DRILL AND TAP		7-11-07	SD
615	ROLLMARK CALIBER		7-12-07	CW
618	ROTO-BLAST		7-12-07	UB
620	APPLY COATINGS		7/13/07	[illegible]
625	FINAL ASSEMBLY		7/19/07	[illegible]
640	FUNCTION TEST AND	(PASS) FAIL	7-20-07	TRW
650	TARGET	(PASS) FAIL	7-20-07	TRW
	MALFUNCTION	CORRECTION N/A		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION	7-2007	FM
670	FINAL INSPECTION			
	A) HEADSPACE	PASS FAIL	7-23-07	DA
	B) TRIGGER PULL (+/- .5 LBS, MIN 2.50 LBS, MAX 4.0 LBS)	2.37 2.35 2.34 2.32 2.28	7-23-07	DA
680	F) SAFETY ON FORCE (2 LBS MIN, 10 LBS MAX)	6# 5# 5#	7-23-07	DA
	G) SAFETY OFF FORCE (2 LBS MIN)	4.0# 4.0# 4.0#	7-23-07	DA
	I) FIRING PIN INDENT .020	.023 .022 .022	7-23-07	DA
690	PACK			



Serial Number: C6594652

Model: 700

RE00034897

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFOMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6594652.__0
FILE DATE AND TIME: 11/20/2001 09:55

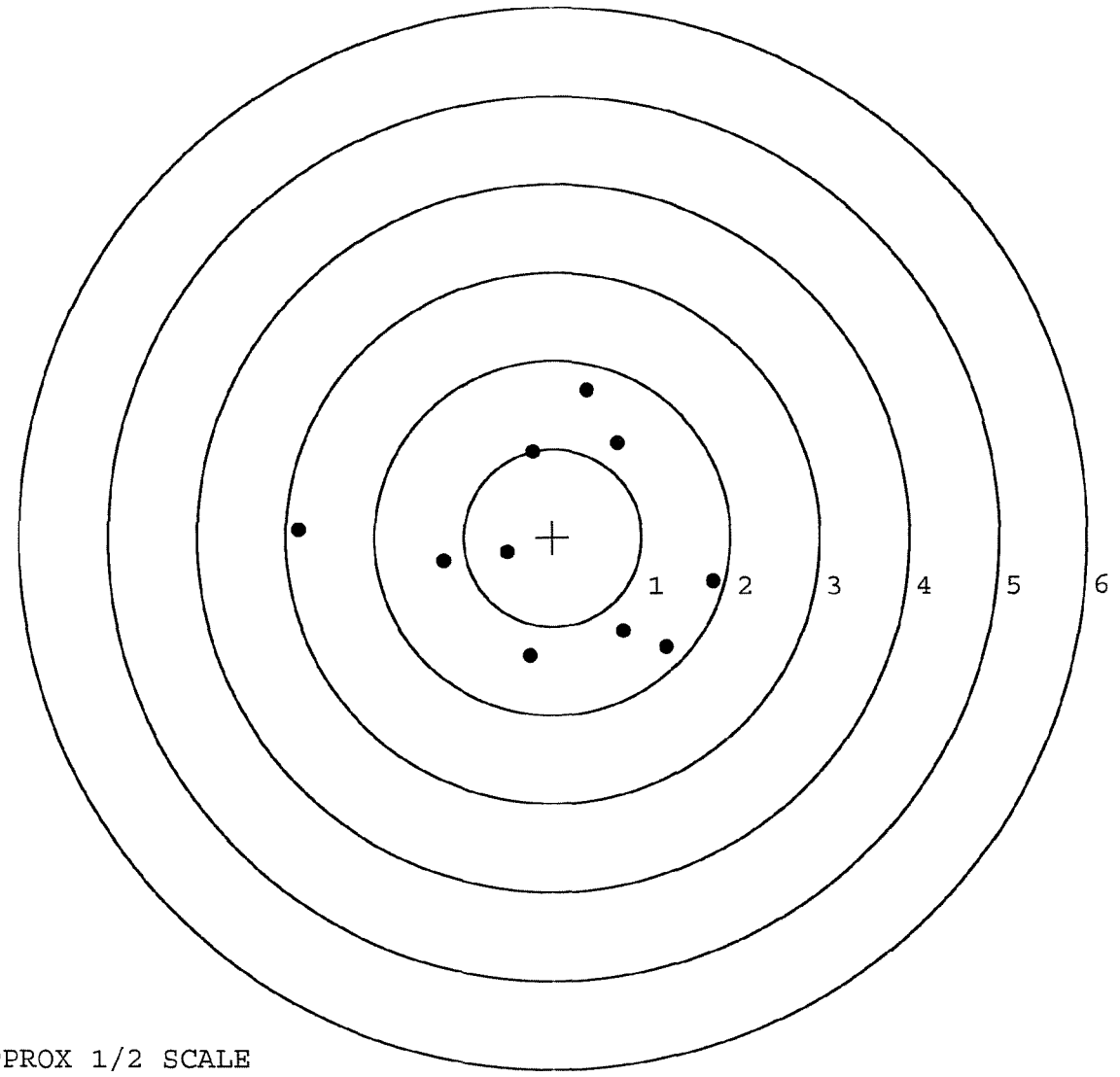
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.070
The Average Y Centroid of the Five Target Set:	0.059
The Average Point of Impact of the Five Target Set:	0.091
The Average Mean Radius of the Five Target Set:	1.122
The Distance from POA to Centroid Target #1:	0.080
The Distance from Centroid Target #2 to Centroid Target #1:	0.306
The Distance from Centroid Target #3 to Centroid Target #1:	0.239
The Distance from Centroid Target #4 to Centroid Target #1:	0.168
The Distance from Centroid Target #5 to Centroid Target #1:	0.197

SERIAL NUMBER: C6594652.__0
TARGET NUMBER: 1
FILE DATE: 11/20/2001
FILE TIME: 09:55

X CENTROID:	-0.008
Y CENTROID:	-0.080
POA TO CENTROID:	0.080
HORZ SPREAD:	4.667
VERT SPREAD:	2.997
GROUP SPREAD:	4.705
MIN RADIUS:	0.513
MAX RADIUS:	2.854
MEAN RADIUS:	1.496
# IN 1 IN DIAMETER:	0
# IN 2 IN DIAMETER:	1
# in 3 IN DIAMETER:	6

POINT#	X	Y
1:	0.383	1.660
2:	0.729	1.063
3:	-0.220	0.973
4:	-0.513	-0.171
5:	-1.220	-0.271
6:	-2.857	0.092
7:	-0.258	-1.337
8:	0.787	-1.054
9:	1.282	-1.246
10:	1.810	-0.506

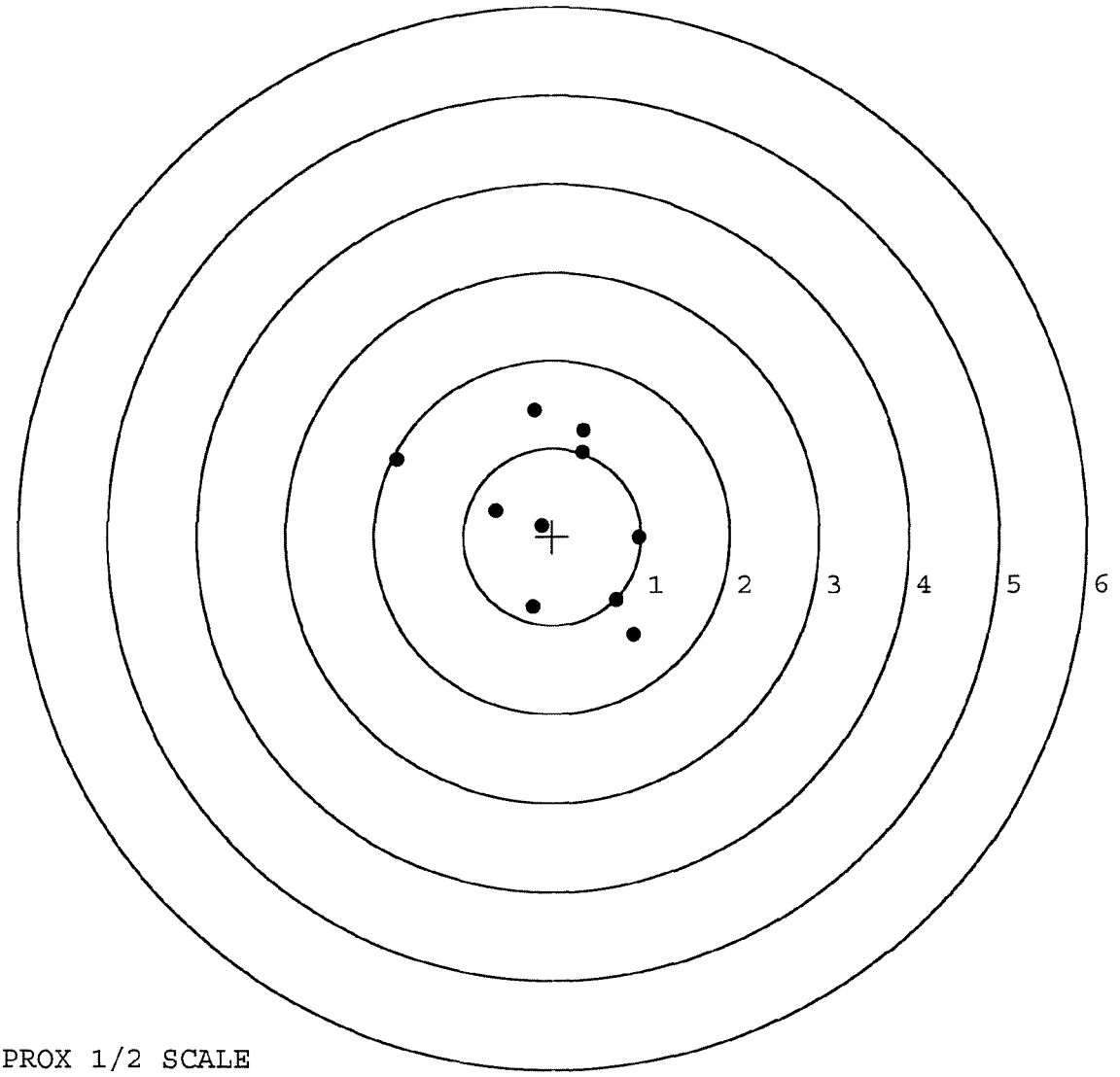


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6594652.__0
TARGET NUMBER: 2
FILE DATE: 11/20/2001
FILE TIME: 09:55

X CENTROID:	0.038
Y CENTROID:	0.223
POA TO CENTROID:	0.226
HORZ SPREAD:	2.719
VERT SPREAD:	2.549
GROUP SPREAD:	3.334
MIN RADIUS:	0.185
MAX RADIUS:	1.901
MEAN RADIUS:	1.062
# IN 1 IN DIAMETER:	1
# IN 2 IN DIAMETER:	4
# in 3 IN DIAMETER:	8

POINT#	X	Y
1:	-0.205	1.429
2:	0.359	1.203
3:	0.343	0.958
4:	-0.639	0.295
5:	-1.744	0.886
6:	-0.117	0.122
7:	-0.225	-0.800
8:	0.715	-0.724
9:	0.919	-1.120
10:	0.975	-0.019

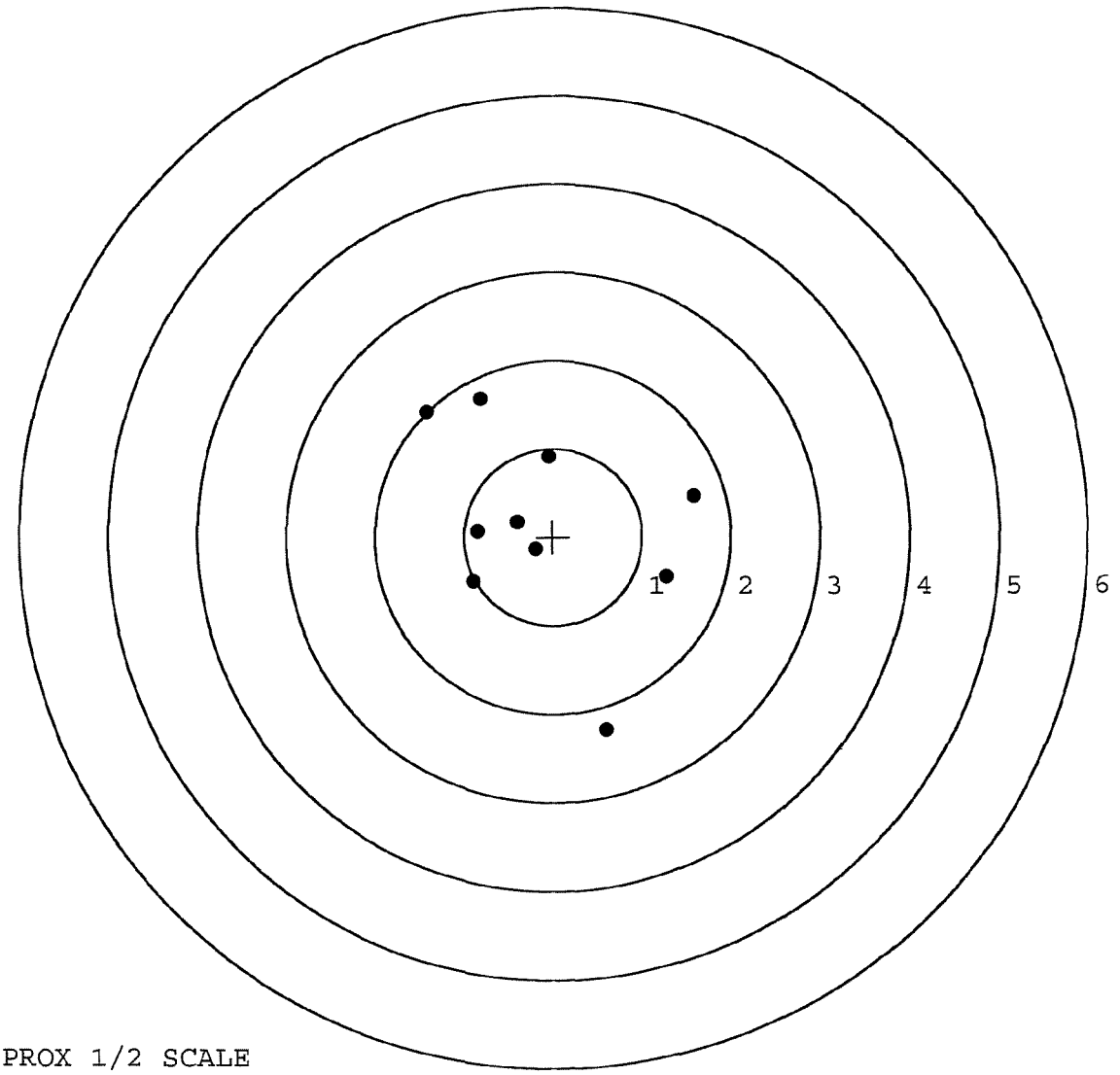


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6594652.__0
TARGET NUMBER: 3
FILE DATE: 11/20/2001
FILE TIME: 09:55

X CENTROID:	-0.119
Y CENTROID:	0.131
POA TO CENTROID:	0.177
HORZ SPREAD:	3.004
VERT SPREAD:	3.753
GROUP SPREAD:	4.129
MIN RADIUS:	0.283
MAX RADIUS:	2.423
MEAN RADIUS:	1.219
# IN 1 IN DIAMETER:	2
# IN 2 IN DIAMETER:	4
# in 3 IN DIAMETER:	5

POINT#	X	Y
1:	-0.820	1.569
2:	-1.424	1.418
3:	-0.053	0.909
4:	-0.195	-0.142
5:	-0.410	0.173
6:	-0.845	0.068
7:	-0.895	-0.506
8:	1.274	-0.457
9:	0.594	-2.184
10:	1.580	0.463

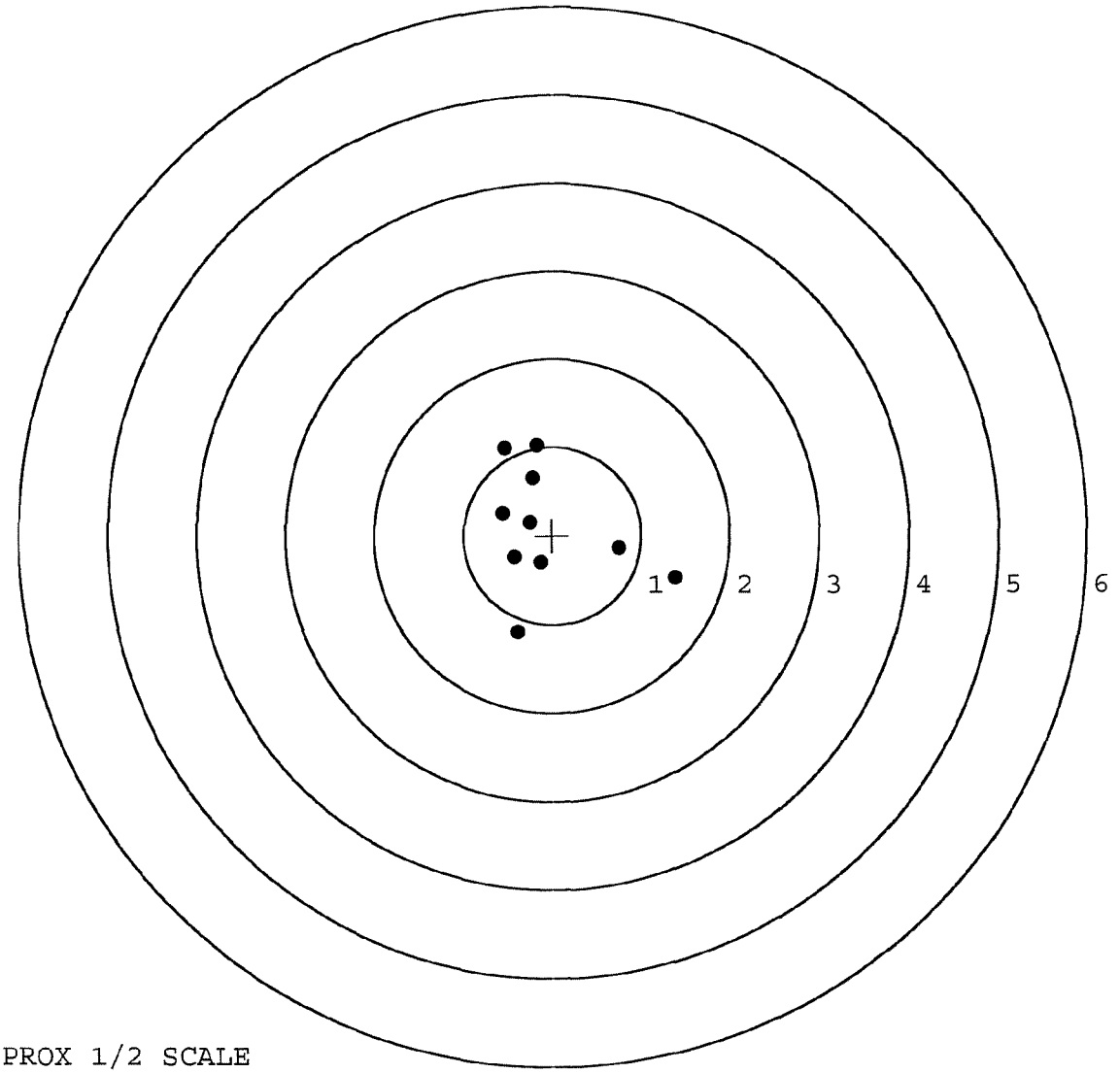


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6594652.__0
TARGET NUMBER: 4
FILE DATE: 11/20/2001
FILE TIME: 09:55

X CENTROID:	-0.058
Y CENTROID:	0.081
POA TO CENTROID:	0.099
HORZ SPREAD:	1.948
VERT SPREAD:	2.106
GROUP SPREAD:	2.416
MIN RADIUS:	0.214
MAX RADIUS:	1.547
MEAN RADIUS:	0.780
# IN 1 IN DIAMETER:	3
# IN 2 IN DIAMETER:	7
# in 3 IN DIAMETER:	9

POINT#	X	Y
1:	-0.179	1.016
2:	-0.535	0.987
3:	-0.223	0.652
4:	-0.563	0.257
5:	-0.260	0.151
6:	-0.433	-0.241
7:	-0.128	-0.303
8:	-0.393	-1.090
9:	0.753	-0.140
10:	1.385	-0.479

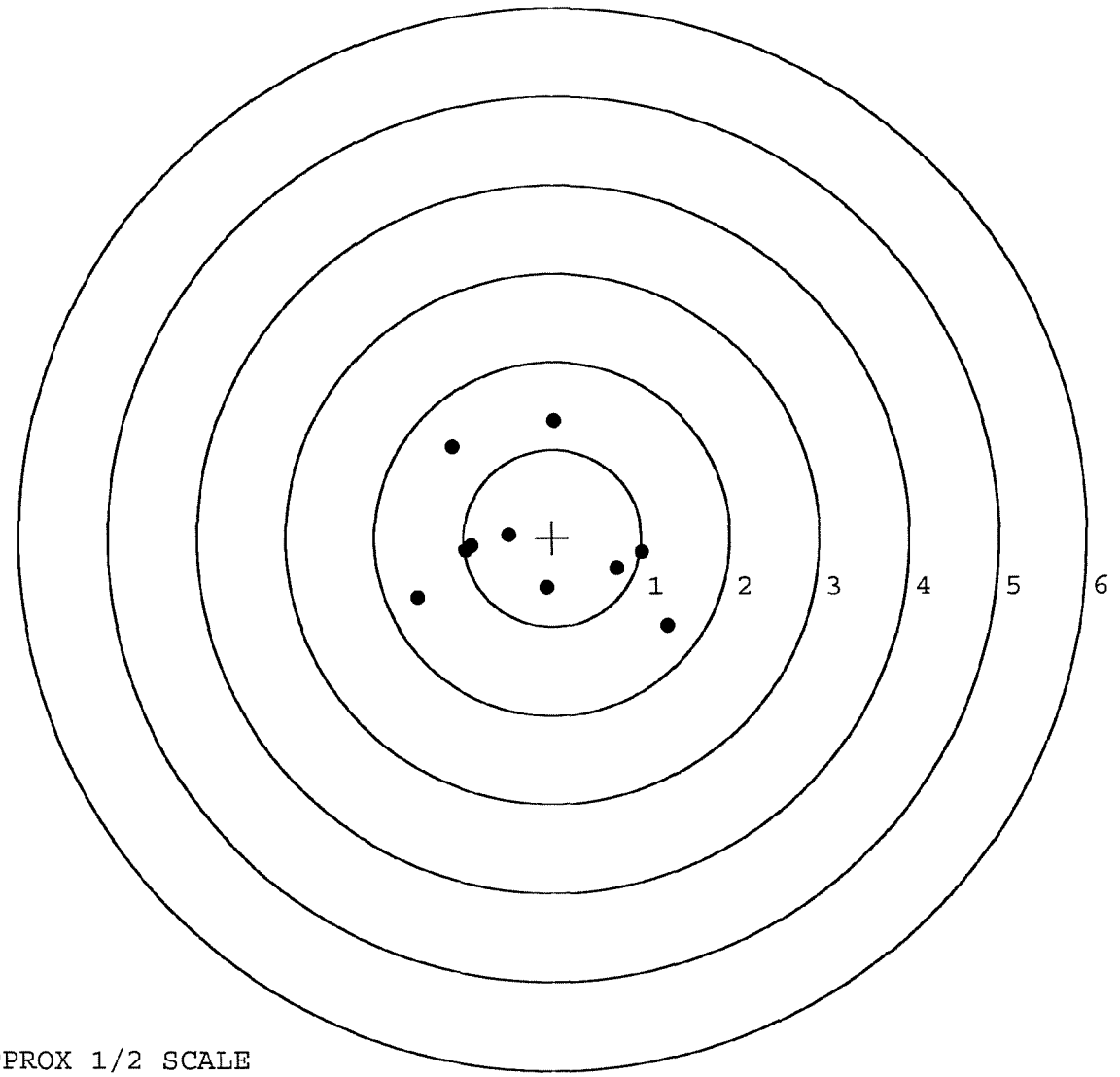


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6594652.__0
TARGET NUMBER: 5
FILE DATE: 11/20/2001
FILE TIME: 09:55

X CENTROID:	-0.204
Y CENTROID:	-0.062
POA TO CENTROID:	0.213
HORZ SPREAD:	2.817
VERT SPREAD:	2.326
GROUP SPREAD:	3.158
MIN RADIUS:	0.302
MAX RADIUS:	1.771
MEAN RADIUS:	1.056
# IN 1 IN DIAMETER:	1
# IN 2 IN DIAMETER:	5
# in 3 IN DIAMETER:	9

POINT#	X	Y
1:	0.024	1.325
2:	-1.123	1.028
3:	-0.491	0.034
4:	-0.978	-0.142
5:	-1.520	-0.679
6:	-0.071	-0.572
7:	1.010	-0.171
8:	0.721	-0.350
9:	1.297	-1.001
10:	-0.911	-0.090



TARGET APPROX 1/2 SCALE

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

R & E NUMBER	34897		
SERIAL NUMBER	C6594652		
LOG-IN DATE	11-1-01		
INSPECT AND VERIFY:			
OPERATION #	OPERATION NAME	DATE	INITIAL
550	DIS-ASSEMBLE GUN	11-5-01	RHL
560 A	RE-BARREL	11/6	BWT
B	DRILL AND TAP	11/7	BWT
575	ASSEMBLE	11-7-01	RW
600	PROOF MAGNA - FLUX INSPECTED	11-7-01	RW
605	CHECK HEADSPACE NOV 1 2 2001	11-7-01	RW
610	DIS-ASSEMBLE GUN	11-7-01	RW
612	MAGNAFLUX OPERATOR NRD		
615	ROLLMARK CALIBER	11/12	
618	ROTO-BLAST	11/14	
620	APPLY COATINGS	11-15	
625 A	FINAL ASSEMBLY	11-20-01	RW
B	TRIGGER PULL TEST		
C	SAFETY "ON" FORCE		
D	SAFETY "OFF" FORCE		
E	FIRING PIN INDENT		
640	TARGET	11-20-01	RW
655	FINAL INSPECT	11-28-01	RHL
660	PACK	11-28-01	WA
		SHIP DATE	
	QAR INSPECTION DATE		

SWS/Repair

[redacted]

Final Inspection

In: C6594652	Date Rec'd: 11/1/01	Date Ret'd: 11/28/01

Auditor: RH

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

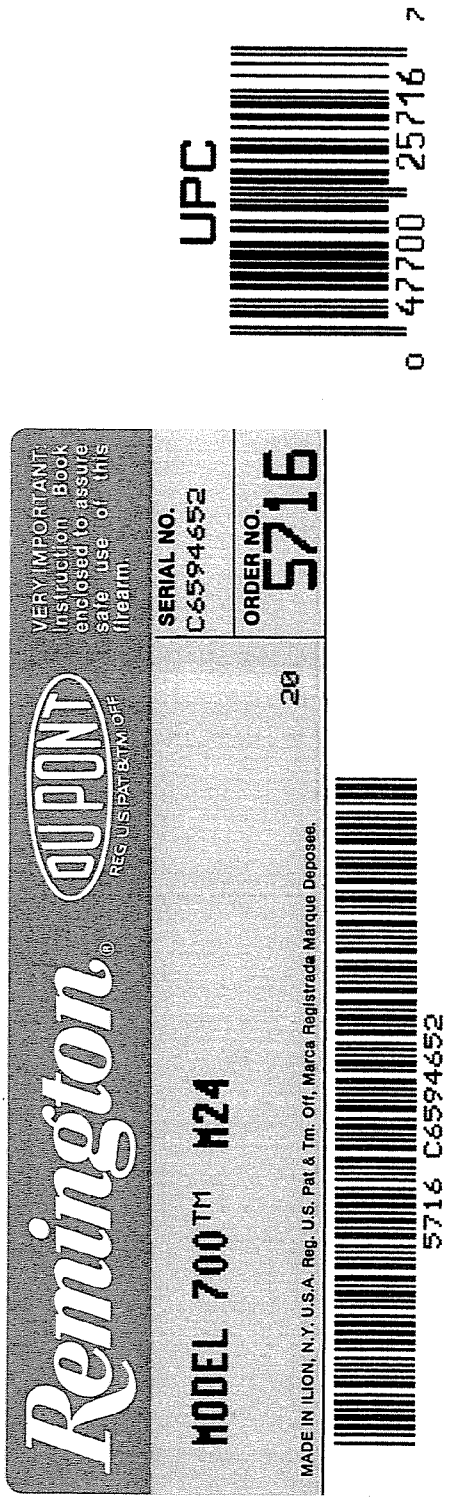
Item:

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: _____


Remington
DUPONT
REG. U.S. PAT. & TM. OFF.
VERY IMPORTANT!! Instruction Book enclosed to assure safe use of this firearm.
MODEL 700 TM M24
SERIAL NO. C6594652
ORDER NO. 5716
20
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off., Marca Registrada Marque Deposee.
5716 C6594652
UPC
0 47700 25716 7

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6594652

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		12/21/90	K.S.
600	Proof		12/21/90	K.S.
607	Check Headspace		12/21/90	K.S.
610	Dis-assemble Gun		12/21/90	K.S.
612	Magnaflux Barrel Action		1/9/91	KR
	Magnaflux Bolt		"	KR
615	Rollmark Caliber		"	DS.
617	Drill and Tap Sight Holes		1 10 91	EB
618	Polish Barrel		1 16 91	WB
620	Apply Coatings (Barrel Action)		1-22-91	
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		2/6/91	
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		2/6/91	
	C) Inspect Ejector Hole for Chamfer		2/6/91	
	D) Oil Firing Pin Ass'y		2/6/91	
	E) Adjust Trigger Pull to Min Setting and Stake		2/8/91	

Op. #	Op. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			2/8/91	WB
	G) Safety Off Force	3	3	3			2/8/91	WB
	H) Trigger Pull Test & Retainability						2/8/91	
	I) Firing Pin Indent	.0205	.0205	.0205			2/8/91	WB
	J) Assemble Stock						2/11/91	
	K) Assemble Swivel Studs						2-21-91	
	L) Attach Front and Rear Sight Assemblies						2/11/91	
	M) Iron Sight Alignment						2/11/91	
	N) Detach Front & Rear Sights & place in numbered container						2/11/91	
	O) Attach Scope to Rifle						2/11/91	
	P) Detach & Attach Scope 20 Times						2/11/91	
640	Gallery Target & Test						2-12-91	AC
	A) Time						2-12-91	AC
	B) Malfunctions						2-12-91	AC
	C) Pierced Primers						2-12-91	AC
	D) Optical Clearity of Scope						2-12-91	AC
645	Inspect for Live Ammo						2-12-91	AC
655	Final Inspection A) Headspace						2-21-91	
	B) Trigger Pull	2.43	2.46	2.44	2.40	2.42	2/19/91	WB
	C) Function						2-21-91	
660	Pack						3/14/91	WB

SWS TRIGGER PULL TEST

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

SERIAL NO. C6594652

DATE 2-8-91

TESTER

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.36	2.20	2.16	2.43	MIN. SETTING,
PULL #2	2.33	2.50	2.25	2.46	NO AVG. OF 5
PULL #3	2.23	2.53	2.31	2.44	READINGS ACCEPT-
PULL #4	2.18	2.41	2.22	2.40	ABLE LESS THAN 2#
PULL #5	2.29	2.40	2.44	2.47	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.42	3.17		
PULL #2	3.31	3.23		
PULL #3	3.10	3.29		
PULL #4	3.29	3.21		
PULL #5	3.34	3.25		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.25	4.23		4.27
~~PULL~~ #2	4.33	4.32		4.11
PULL #3	4.24	4.36		4.17
PULL #4	4.26	4.37		4.26
PULL #5	4.24	4.38		4.47
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6594652
12 Feb 1991

CENTROIDAL DISTANCES

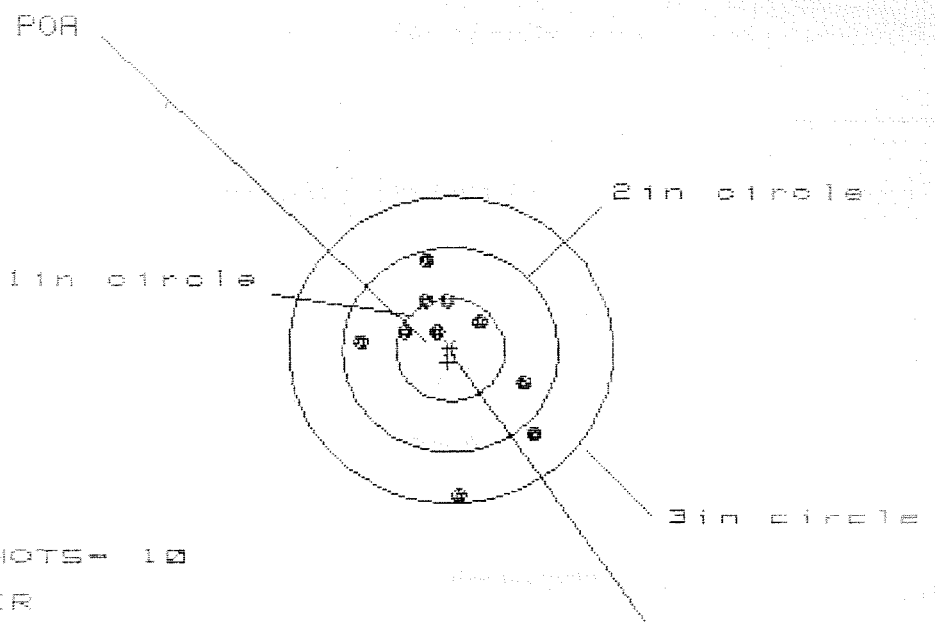
0	TO	1	.124664
1	TO	2	.110023
1	TO	3	.379816
1	TO	4	.0957549
1	TO	5	.292219

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0758
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0104
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0765101

THE AMR FOR THIS RIFLE IS: .7996

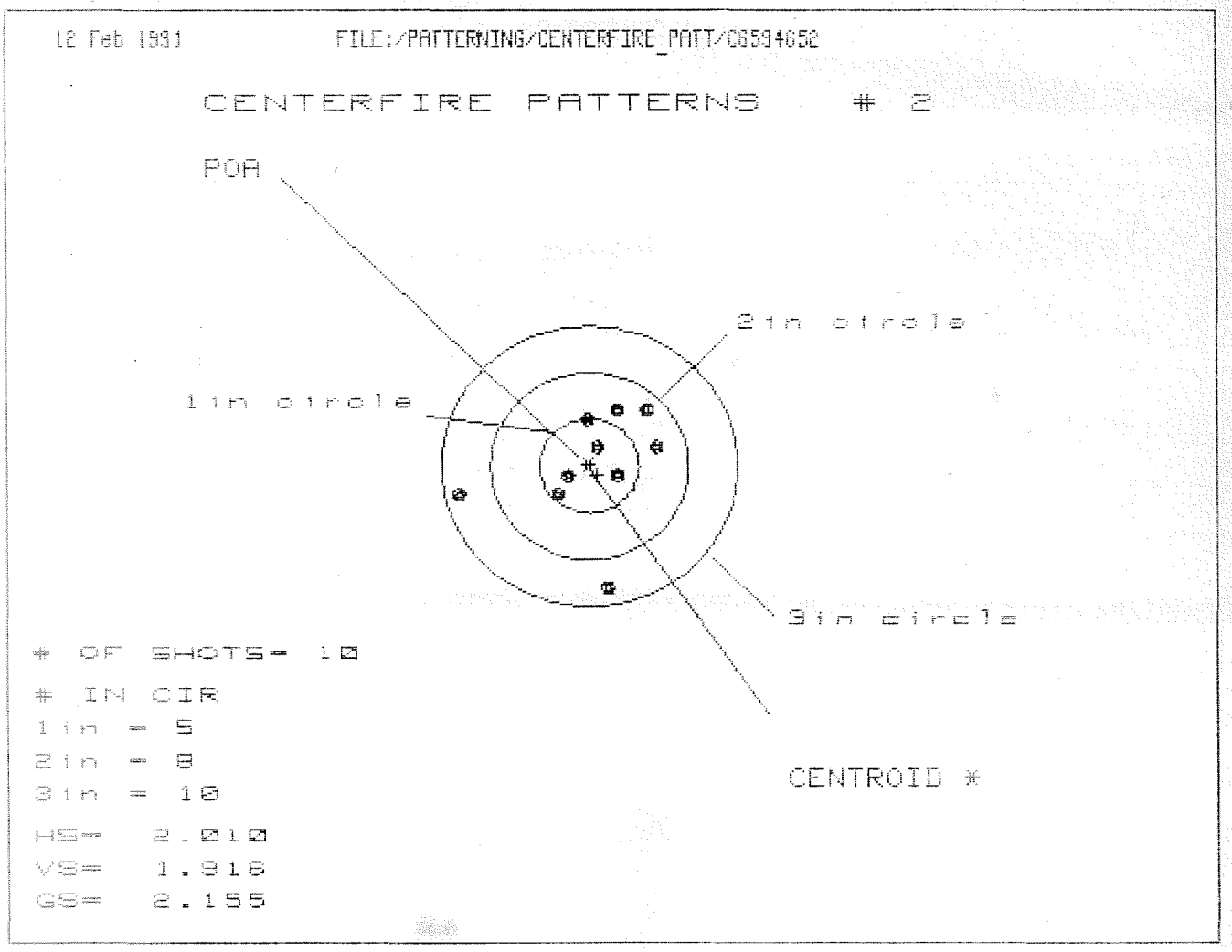
12 Feb 1991 FILE:/PATTERNING/CENTERFIRE_PATT/C6534652

CENTERFIRE PATTERNS # 1

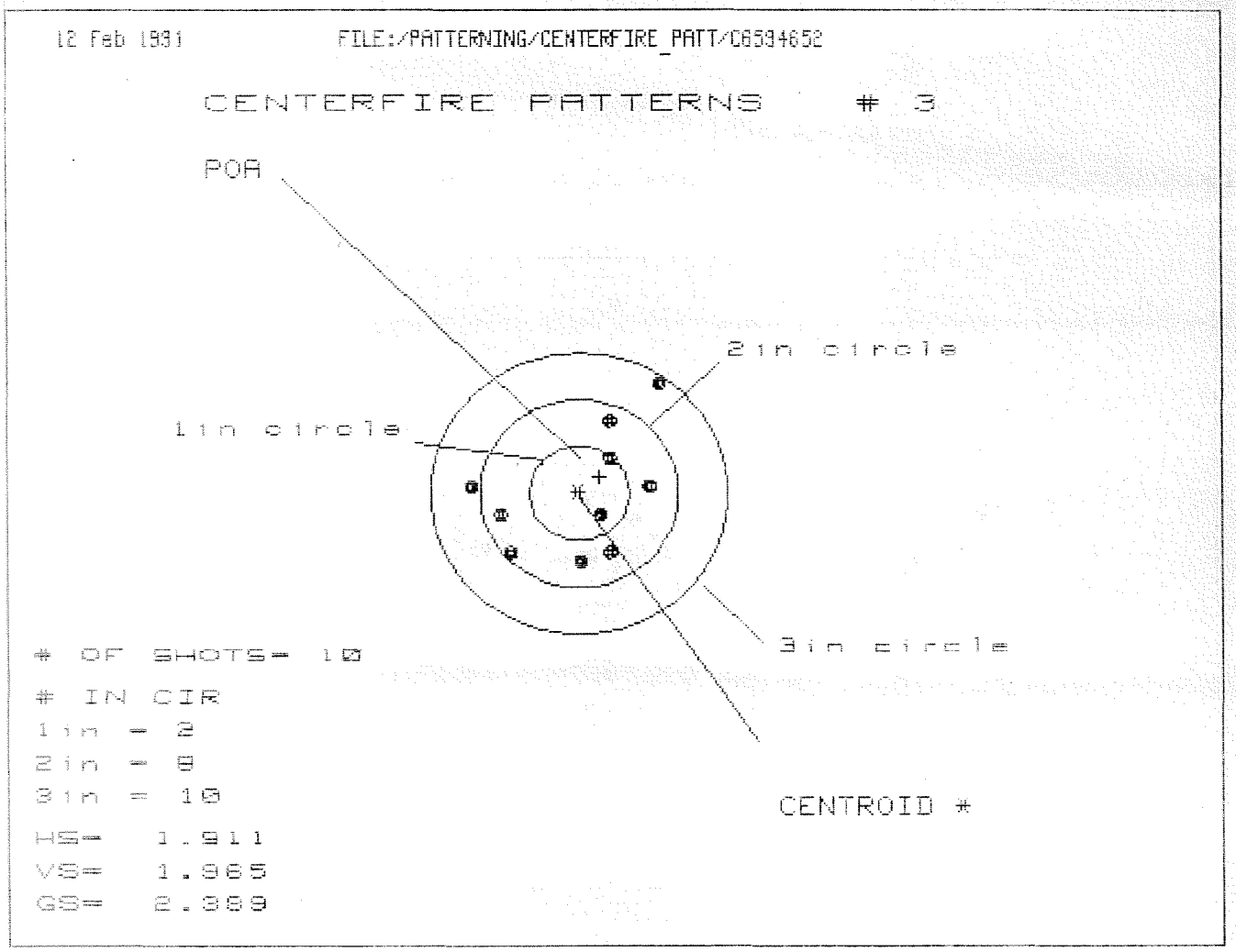


# OF SHOTS= 10
# IN CIR
1in = 4
2in = 8
3in = 10
HS= 1.585
VS= 2.284
GS= 2.308

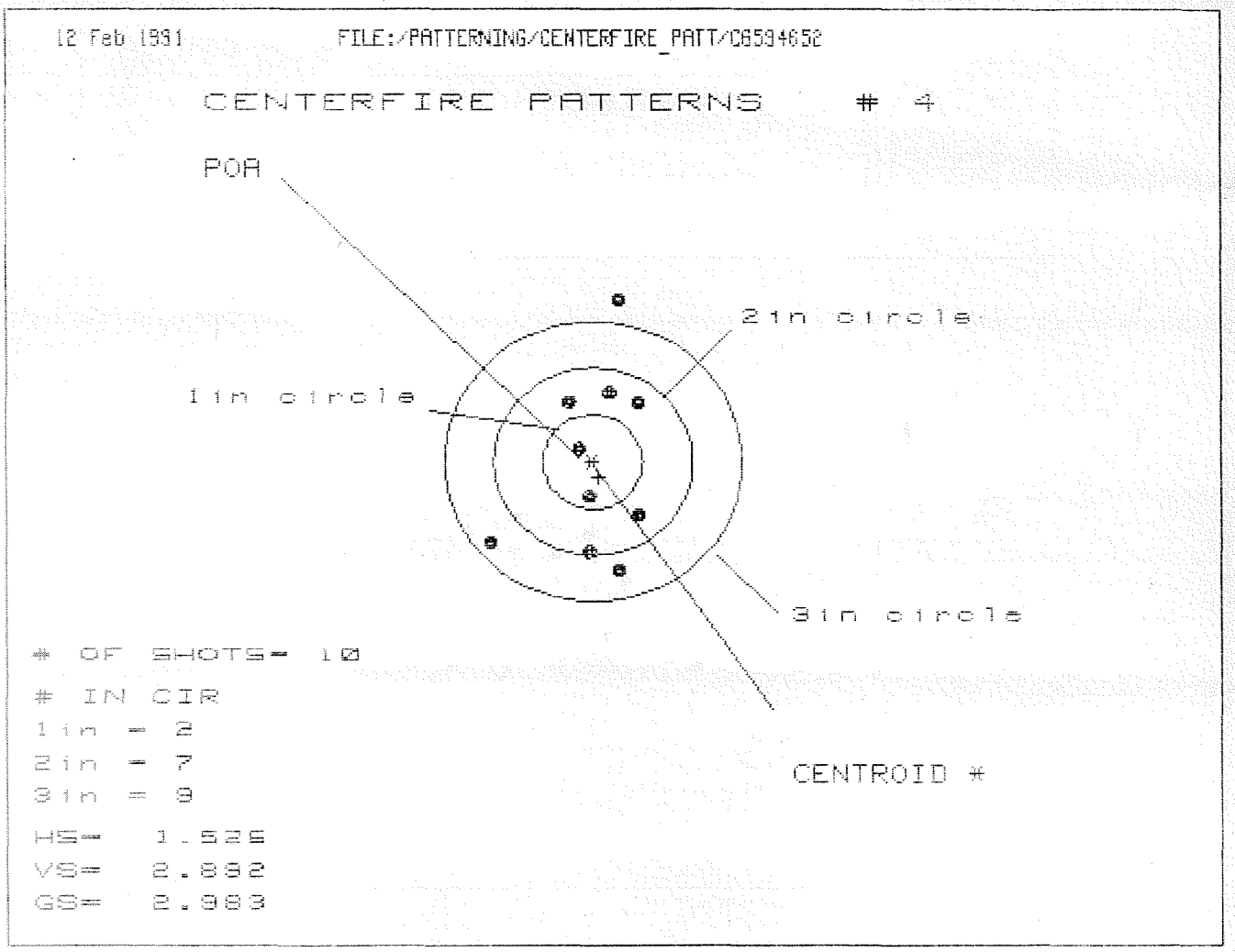
PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.759	.771	.792
MINIMUM X	:	-.826	-.814	-.718
MAXIMUM Y	:	.892	.737	.620
MINIMUM Y	:	-1.392	-.937	-.603
CENTROID X	:	.030	.018	-.078
CENTROID Y	:	.121	.276	.393
POA TO CENTROID in.	:	.125	.276	.400
MIN RADIUS	:	.188	.075	.107
MEAN RADIUS	:	.707	.578	.464
MAX RADIUS	:	1.396	1.213	.995
HORIZONTAL SPREAD	:	1.585	1.585	1.510
VERTICAL SPREAD	:	2.284	1.674	1.223
EXTREME SPREAD	:	2.308	1.942	1.555
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	



PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.666	.517	.516
MINIMUM X	:	-1.344	-.488	-.489
MAXIMUM Y	:	.615	.583	.416
MINIMUM Y	:	-1.301	-1.333	-.537
CENTROID X	:	-.078	.071	.072
CENTROID Y	:	.100	.132	.299
POA TO CENTROID in.	:	.127	.150	.308
MIN RADIUS	:	.207	.157	.118
MEAN RADIUS	:	.664	.568	.444
MAX RADIUS	:	1.376	1.333	.726
HORIZONTAL SPREAD	:	2.010	1.005	1.005
VERTICAL SPREAD	:	1.916	1.916	.953
EXTREME SPREAD	:	2.155	1.972	1.345
NUMBER IN ONE INCH CIRCLE	=		5	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	



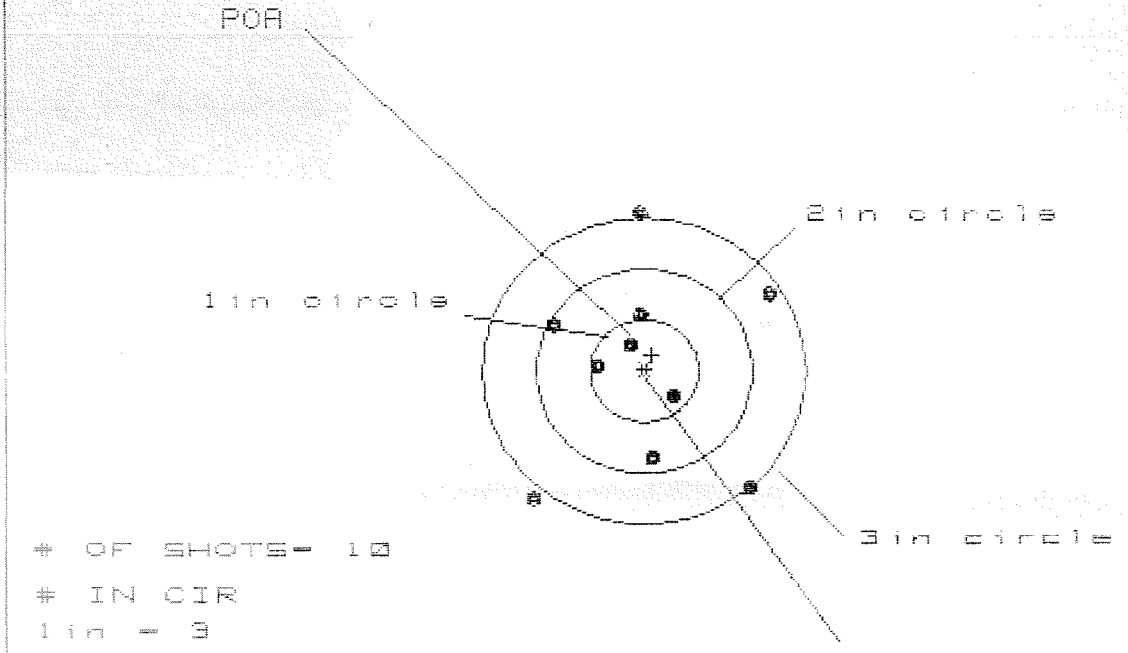
PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.824	.752	.627
MINIMUM X	:	-1.087	-.995	-.839
MAXIMUM Y	:	1.218	.887	.915
MINIMUM Y	:	-.747	-.612	-.584
CENTROID X	:	-.208	-.300	-.175
CENTROID Y	:	-.175	-.310	-.338
POA TO CENTROID in.	:	.272	.431	.381
MIN RADIUS	:	.323	.307	.184
MEAN RADIUS	:	.801	.713	.647
MAX RADIUS	:	1.471	1.021	.946
HORIZONTAL SPREAD	:	1.911	1.747	1.466
VERTICAL SPREAD	:	1.965	1.499	1.499
EXTREME SPREAD	:	2.389	1.748	1.682
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	



PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.463	.495	.366
MINIMUM X	:	-1.064	-1.031	-.355
MAXIMUM Y	:	1.761	.910	.822
MINIMUM Y	:	-1.131	-.936	-1.024
CENTROID X	:	-.057	-.089	.040
CENTROID Y	:	.161	-.034	.054
POA TO CENTROID in.	:	.171	.095	.067
MIN RADIUS	:	.186	.175	.307
MEAN RADIUS	:	.874	.761	.695
MAX RADIUS	:	1.784	1.248	1.035
HORIZONTAL SPREAD	:	1.526	1.526	.721
VERTICAL SPREAD	:	2.892	1.846	1.846
EXTREME SPREAD	:	2.983	2.194	1.851
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

12 Feb 1991 FILE:/PATTERNING/CENTERFIRE_PATT/C8594652

CENTERFIRE PATTERNS # 5



OF SHOTS= 10

# IN CIR
1in = 3
2in = 6
3in = 7

HS= 2.217
VS= 2.848
GS= 3.024

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.161	1.043	1.024
MINIMUM X	:	-1.056	-.936	-.955
MAXIMUM Y	:	1.589	1.449	.747
MINIMUM Y	:	-1.259	-1.317	-1.136
CENTROID X	:	-.066	.052	.071
CENTROID Y	:	-.155	-.015	-.196
POA TO CENTROID in.	:	.168	.054	.208
MIN RADIUS	:	.292	.285	.222
MEAN RADIUS	:	.952	.872	.797
MAX RADIUS	:	1.644	1.583	1.424
HORIZONTAL SPREAD	:	2.217	1.979	1.979
VERTICAL SPREAD	:	2.848	2.766	1.883
EXTREME SPREAD	:	3.024	2.953	2.416
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		7	