

C6611802

MODEL 700<sup>TM</sup> M24

Model **SMS**<sup>TM</sup>

Action

Barrel Length

Capacity

Order No. **5715**

\*Includes 1 in chamber.

*Remington*

## Arms Services Repair &amp; Estimate System

File Add Repair Estimate Repair Expedite Repair Inquiry Repair Tools CSR Tools Reports Table Maintenance System Maintenance Help

## Repair Inquiry

Repair Number: RE00146509

Serial: C6611802 Model M24 SWS Center Fire  
Caliber: 7.62 NATO

Repairman:

Verify Repair

Status:

Closed 6/17/2008 9:50:17 AM

## Address Information

Customer:

Received From

Return To:

Received From

Name: DEF DIST DEPOT

DEF DIST DEPOT

Address 1: 7 FRANKFORD AVE BLDG 362

7 FRANKFORD AVE BLDG 362

Address 2:

PO Box:

PO Box:

City: ANNISTON

ANNISTON

State: AL

Zip Code: 36201

Country: US

State: AL

Zip Code: 36201

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   |
| A008 | With Swivel           | 2   |
| A009 | Soft Case             | 1   |
| A010 | Hard Case             | 1   |
| A017 | Scope Base            | 1   |
| A026 | Scope                 | 1   |
| A057 | Frt and Rear Sgt Base | 1   |

## Repair Search

## Refresh

## Close

nagletj

6/17/2008

10:48 AM

CAPS

NUM

INS

SCRL



Number: C6611802

Model: M24 SWS



RE00146509

## INSPECTION CHECKLIST - REPAIRS

CONTRACT #: W52H09-07-C-0207

ISSUED 10/1/2007

R &amp; E NUMBER

146509

SERIAL NUMBER

C6611802

LOG-IN DATE

6-17-08

| OPERATION # | OPERATION NAME       | DATE                     | INITIAL    |
|-------------|----------------------|--------------------------|------------|
| 500         | DIS-ASSEMBLE GUN     | 7-13-09                  | KTZ        |
| 505         | RE-BARREL            | 7-16-09                  | KTZ        |
| 420         | ASSEMBLE             | 7-16-09                  | KTZ        |
| 440         | PROOF                | 7-16-09                  | RP         |
| 460         | CHECK HEADSPACE      | 7-16-09                  | RP         |
| 470         | DIS-ASSEMBLE GUN     | 7-16-09                  | RP         |
| 480         | MAGNAFLUX            | 7-18-09                  | RP         |
| 510         | DRILL AND TAP        | 7-17-09                  | SP         |
| 500         | ROLLMARK CALIBER     | 7-21-09                  | ALVO       |
| 520         | GOFF BLAST BBL / REC | 7-21-09                  | ALVO       |
| 530 & 540   | APPLY COATINGS       | 7-21-09                  | -          |
| 560         | FINAL ASSEMBLY       | 7-30-09                  | KTZ        |
| 640         | FUNCTION TEST AND    | 8-6-09                   | S.P.D.     |
| 650         | TARGET               | 8-6-09                   | S.P.D.     |
|             | MALFUNCTION          | CORRECTION               |            |
|             | MALFUNCTION          | CORRECTION               |            |
|             | MALFUNCTION          | CORRECTION               |            |
|             | MALFUNCTION          | CORRECTION               | 8/6/09 RP  |
| 670         | FINAL INSPECTION     | 8-17-09                  | RP         |
|             | A) HEADSPACE         | (PASS) FAIL              | 8-17-09 RP |
|             | B) TRIGGER PULL      | 2.62 2.61 2.70 2.65 2.60 | 8-17-09 RP |
| 680         | F) SAFETY ON FORCE   | 2.0 2.2 2.2              | 8-17-09 RP |
|             | G) SAFETY OFF FORCE  | 4.0 3.8 3.8              | 8-17-09 RP |
|             | I) FIRING PIN INDENT | .028 .028 .028           | 8-17-09 RP |
| 690         | PACK                 | 9-17-09                  | FM         |

F006 REV 1/2009

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6611802.\_\_\_0  
FILE DATE AND TIME: 08/07/2009 05:24

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

|                                                             |        |
|-------------------------------------------------------------|--------|
| The Average X Centroid of the Five Target Set:              | 0.060  |
| The Average Y Centroid of the Five Target Set:              | -0.013 |
| The Average Point of Impact of the Five Target Set:         | 0.061  |
| The Average Mean Radius of the Five Target Set:             | 0.732  |
| The Distance from POA to Centroid Target #1:                | 0.114  |
| The Distance from Centroid Target #2 to Centroid Target #1: | 0.112  |
| The Distance from Centroid Target #3 to Centroid Target #1: | 0.168  |
| The Distance from Centroid Target #4 to Centroid Target #1: | 0.158  |
| The Distance from Centroid Target #5 to Centroid Target #1: | 0.258  |

SERIAL NUMBER: C6611802. \_\_0

TARGET NUMBER: 1

FILE DATE: 08/07/2009

FILE TIME: 05:24

X CENTROID: 0.110

Y CENTROID: 0.030

POA TO CENTROID: 0.114

HORZ SPREAD: 2.190

VERT SPREAD: 1.489

GROUP SPREAD: 2.214

MIN RADIUS: 0.205

MAX RADIUS: 1.414

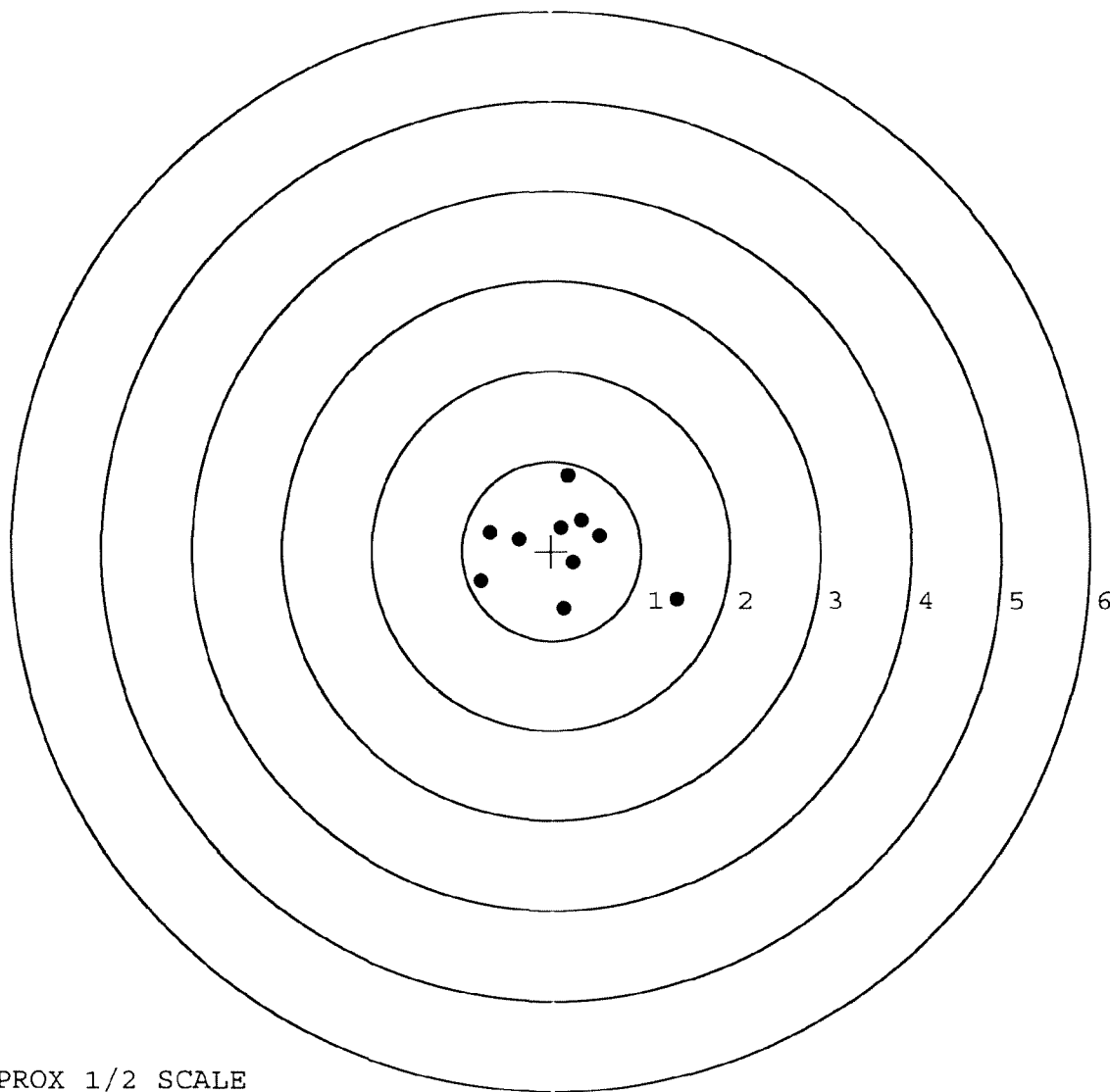
MEAN RADIUS: 0.645

# IN 1 IN DIAMETER: 5

# IN 2 IN DIAMETER: 9

# in 3 IN DIAMETER: 10

| POINT# | X      | Y      |
|--------|--------|--------|
| 1:     | 1.403  | -0.542 |
| 2:     | 0.180  | 0.846  |
| 3:     | -0.787 | -0.339 |
| 4:     | 0.136  | -0.643 |
| 5:     | 0.240  | -0.129 |
| 6:     | -0.682 | 0.202  |
| 7:     | -0.366 | 0.130  |
| 8:     | 0.104  | 0.263  |
| 9:     | 0.329  | 0.341  |
| 10:    | 0.545  | 0.173  |



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6611802. \_\_0

TARGET NUMBER: 2

FILE DATE: 08/07/2009

FILE TIME: 05:24

| POINT# | X      | Y      |
|--------|--------|--------|
| 1:     | -0.361 | 0.902  |
| 2:     | 0.609  | 0.407  |
| 3:     | 0.863  | -0.427 |
| 4:     | 0.573  | -0.300 |
| 5:     | 0.157  | -0.582 |
| 6:     | 0.069  | -0.369 |
| 7:     | -0.866 | -0.205 |
| 8:     | -0.579 | -0.040 |
| 9:     | -0.240 | 0.236  |
| 10:    | -0.069 | 0.084  |

X CENTROID: 0.016

Y CENTROID: -0.029

POA TO CENTROID: 0.033

HORZ SPREAD: 1.729

VERT SPREAD: 1.484

GROUP SPREAD: 1.807

MIN RADIUS: 0.141

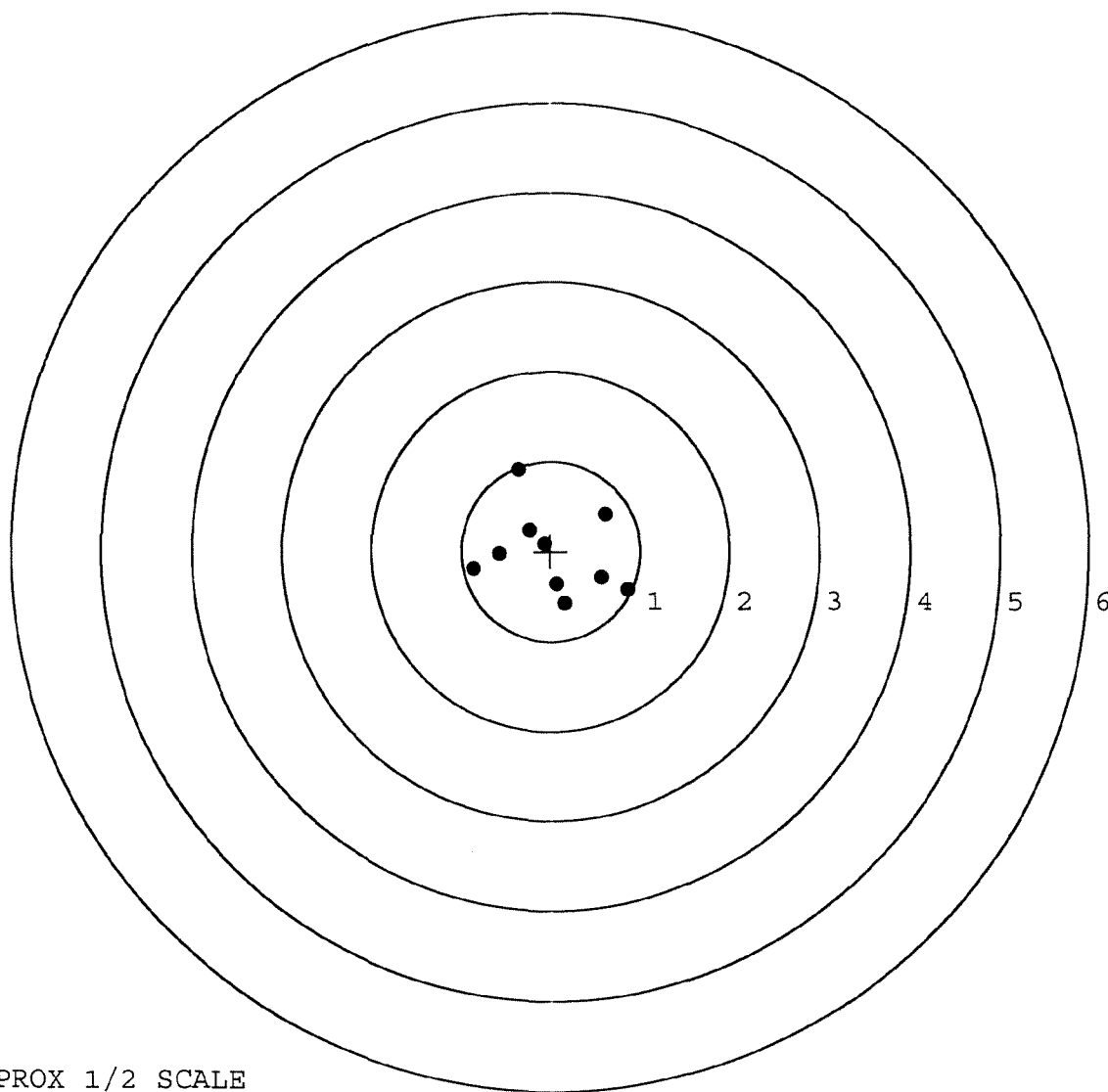
MAX RADIUS: 1.005

MEAN RADIUS: 0.621

# IN 1 IN DIAMETER: 3

# IN 2 IN DIAMETER: 9

# in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6611802. \_\_0

TARGET NUMBER: 3

FILE DATE: 08/07/2009

FILE TIME: 05:24

| POINT# | X      | Y      |
|--------|--------|--------|
| 1:     | 0.366  | 1.947  |
| 2:     | -0.089 | 1.404  |
| 3:     | -0.016 | -0.572 |
| 4:     | 0.313  | -0.665 |
| 5:     | 0.463  | -0.429 |
| 6:     | 0.271  | -0.154 |
| 7:     | -0.262 | 0.207  |
| 8:     | -0.128 | 0.573  |
| 9:     | -0.399 | 0.693  |
| 10:    | 1.644  | -1.393 |

X CENTROID: 0.216

Y CENTROID: 0.161

POA TO CENTROID: 0.270

HORZ SPREAD: 2.043

VERT SPREAD: 3.340

GROUP SPREAD: 3.576

MIN RADIUS: 0.320

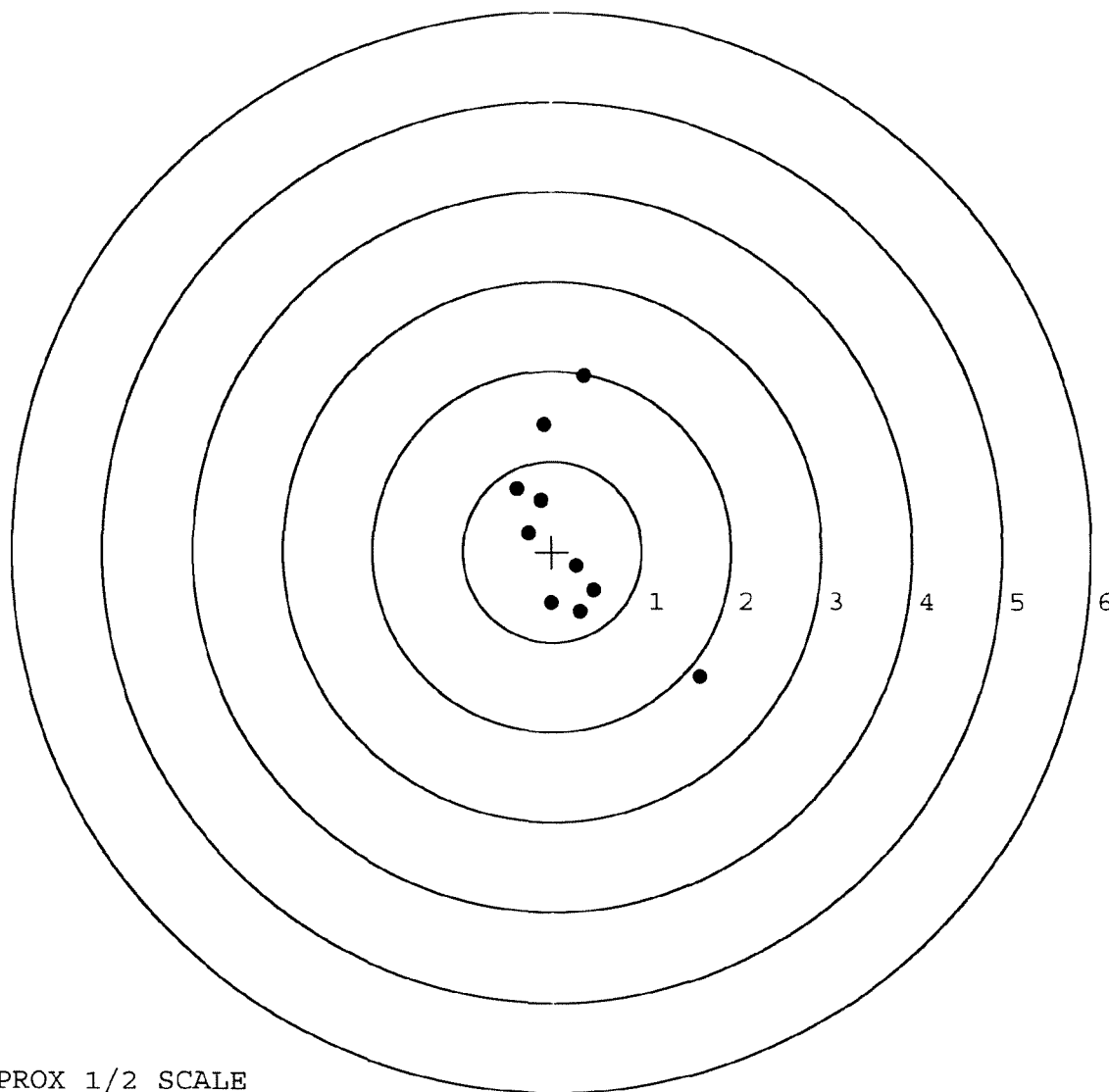
MAX RADIUS: 2.110

MEAN RADIUS: 0.957

# IN 1 IN DIAMETER: 2

# IN 2 IN DIAMETER: 7

# in 3 IN DIAMETER: 8



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6611802. 0

TARGET NUMBER: 4

FILE DATE: 08/07/2009

FILE TIME: 05:24

| POINT# | X      | Y      |
|--------|--------|--------|
| 1:     | -0.519 | 1.113  |
| 2:     | 0.148  | 0.672  |
| 3:     | -0.510 | 0.218  |
| 4:     | -0.063 | 0.161  |
| 5:     | 0.024  | -0.253 |
| 6:     | -0.428 | -0.757 |
| 7:     | 1.190  | -0.521 |
| 8:     | 0.650  | -0.489 |
| 9:     | 0.159  | -0.785 |
| 10:    | -0.017 | -0.562 |

X CENTROID: 0.063

Y CENTROID: -0.120

POA TO CENTROID: 0.136

HORZ SPREAD: 1.709

VERT SPREAD: 1.898

GROUP SPREAD: 2.364

MIN RADIUS: 0.138

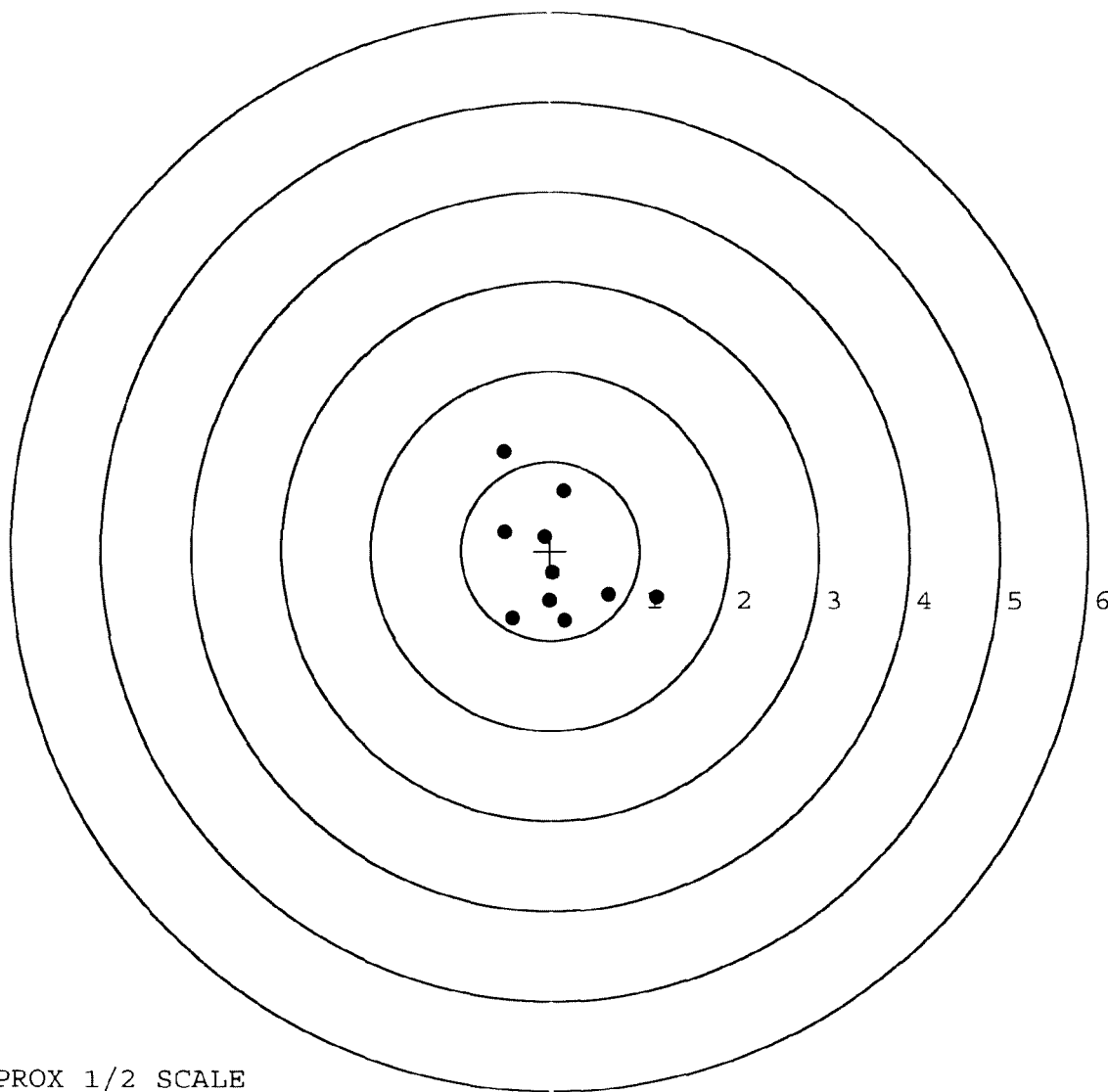
MAX RADIUS: 1.364

MEAN RADIUS: 0.709

# IN 1 IN DIAMETER: 3

# IN 2 IN DIAMETER: 8

# in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE



SERIAL NUMBER: C6611802. 0

TARGET NUMBER: 5

FILE DATE: 08/07/2009

FILE TIME: 05:24

X CENTROID: -0.107

Y CENTROID: -0.108

POA TO CENTROID: 0.152

HORZ SPREAD: 1.400

VERT SPREAD: 1.981

GROUP SPREAD: 2.036

MIN RADIUS: 0.138

MAX RADIUS: 1.266

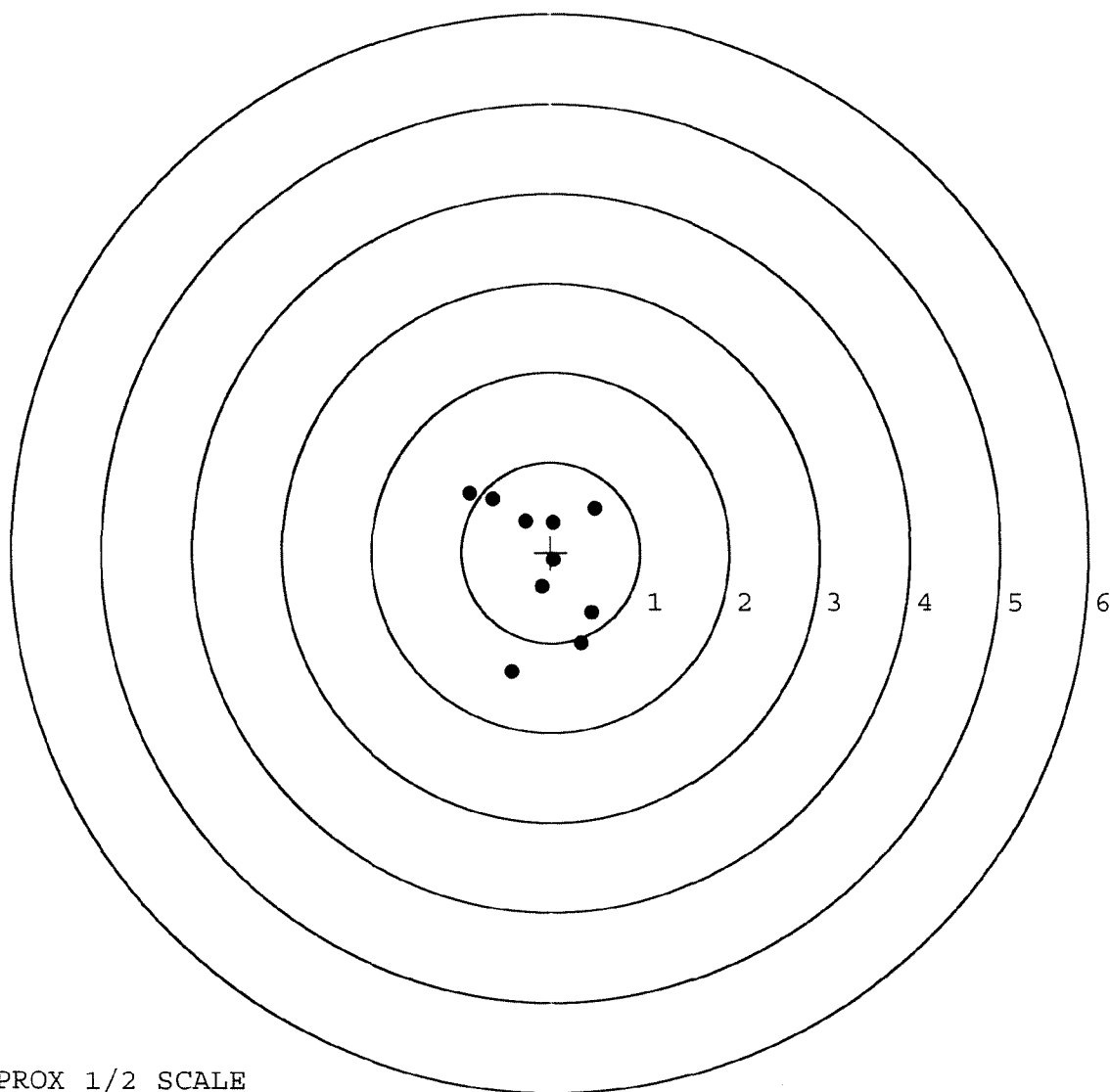
MEAN RADIUS: 0.725

# IN 1 IN DIAMETER: 4

# IN 2 IN DIAMETER: 7

# in 3 IN DIAMETER: 10

| POINT# | X      | Y      |
|--------|--------|--------|
| 1:     | -0.913 | 0.652  |
| 2:     | -0.652 | 0.591  |
| 3:     | -0.293 | 0.346  |
| 4:     | 0.021  | 0.327  |
| 5:     | 0.487  | 0.481  |
| 6:     | 0.028  | -0.081 |
| 7:     | -0.102 | -0.384 |
| 8:     | 0.455  | -0.670 |
| 9:     | 0.335  | -1.010 |
| 10:    | -0.441 | -1.329 |



TARGET APPROX 1/2 SCALE

**Remington**

**MODEL 700™ M24**

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

**REMINGTON**  
REG. U.S. PAT. & TM. OFF.

**SERIAL NO.**  
C-6611802

**ORDER NO.**  
5716

**20**

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

  
5716 C6611802

**UPC**

  
0 47700 25716 7

| MOD.      |      | GA.<br>CAL.                 | GUN # <u>6611802</u>  |
|-----------|------|-----------------------------|-----------------------|
| #<br>TEST | DATE | MALFUNCTION/DEFECT          | ASSEM.<br>#           |
|           | 1st  | <i>Creep<br/>in trigger</i> | <i>KS</i>             |
|           | 2nd  | <i>POLISHED<br/>SEAR</i>    | <i>KS<br/>1/14/91</i> |
|           | 3rd  |                             |                       |
|           | 4th  |                             |                       |
|           |      | FUNCTION                    | RD 6654 Rev 1         |

| TEST INIT. ACTION TO CORRECT |          | ASSEM.<br># |
|------------------------------|----------|-------------|
| PROOF                        |          |             |
| TEST                         |          |             |
| TGT                          |          |             |
| PROOF                        |          |             |
| TEST                         |          |             |
| TGT                          |          |             |
| PROOF                        | ENGINEER |             |
| TEST                         |          |             |
| TGT                          |          |             |
| PROOF                        | ENGINEER |             |
| TEST                         |          |             |
| TGT                          |          |             |

## Repair Inquiry

Repair Number: RE00092999

Serial: C6611802 Model: M24 SWS Center Fire  
Caliber: 7.62 NATO Produced: 03/20/99

Repairman:

Status:

Closed 2/11/2005 7:31:51 AM

## Address Information

Customer

☒ Received From

Return To:

☐ Received From

Name: DEF DIST DEPOT ANNISTON

DEF DIST DEPOT ANNISTON

Address 1:

Address 2:

PO Box:

PO 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

Good

Condition

Notes:

CSP

Notes:

Accessories Received

| Code | Desc                  | Qty |
|------|-----------------------|-----|
| A007 | With Stud             | 3   |
| A010 | Hard Case             | 1   |
| A017 | Scope Base            | 1   |
| A026 | Scope                 | 1   |
| A057 | Frt and Rear Sgt Base | 1   |

Repair Search

Refresh

Close

maglev

2/14/2005

9:13 AM

CAPS

NOM

JLS

SCPL

start

5

2

3

Arms Service

Serial Number: C6611802

Model: M24 SWS



RE00092999

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6611802.\_\_0

FILE DATE AND TIME: 04/01/2005 08:59

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

|                                                             |        |
|-------------------------------------------------------------|--------|
| The Average X Centroid of the Five Target Set:              | 0.017  |
| The Average Y Centroid of the Five Target Set:              | -0.017 |
| The Average Point of Impact of the Five Target Set:         | 0.024  |
| The Average Mean Radius of the Five Target Set:             | 0.796  |
| The Distance from POA to Centroid Target #1:                | 0.281  |
| The Distance from Centroid Target #2 to Centroid Target #1: | 0.534  |
| The Distance from Centroid Target #3 to Centroid Target #1: | 0.281  |
| The Distance from Centroid Target #4 to Centroid Target #1: | 0.412  |
| The Distance from Centroid Target #5 to Centroid Target #1: | 0.354  |

SERIAL NUMBER: C6611802. \_\_0

TARGET NUMBER: 1

FILE DATE: 04/01/2005

FILE TIME: 08:59

| POINT# | X      | Y      |
|--------|--------|--------|
| 1:     | 0.070  | 0.940  |
| 2:     | -0.335 | 0.610  |
| 3:     | -0.532 | 0.098  |
| 4:     | -0.011 | 0.238  |
| 5:     | 0.188  | 0.146  |
| 6:     | 0.101  | -0.162 |
| 7:     | 0.844  | 0.173  |
| 8:     | 0.815  | -0.278 |
| 9:     | 1.099  | -1.113 |
| 10:    | 0.370  | -1.690 |

X CENTROID: 0.261

Y CENTROID: -0.104

POA TO CENTROID: 0.281

HORZ SPREAD: 1.631

VERT SPREAD: 2.630

GROUP SPREAD: 2.647

MIN RADIUS: 0.170

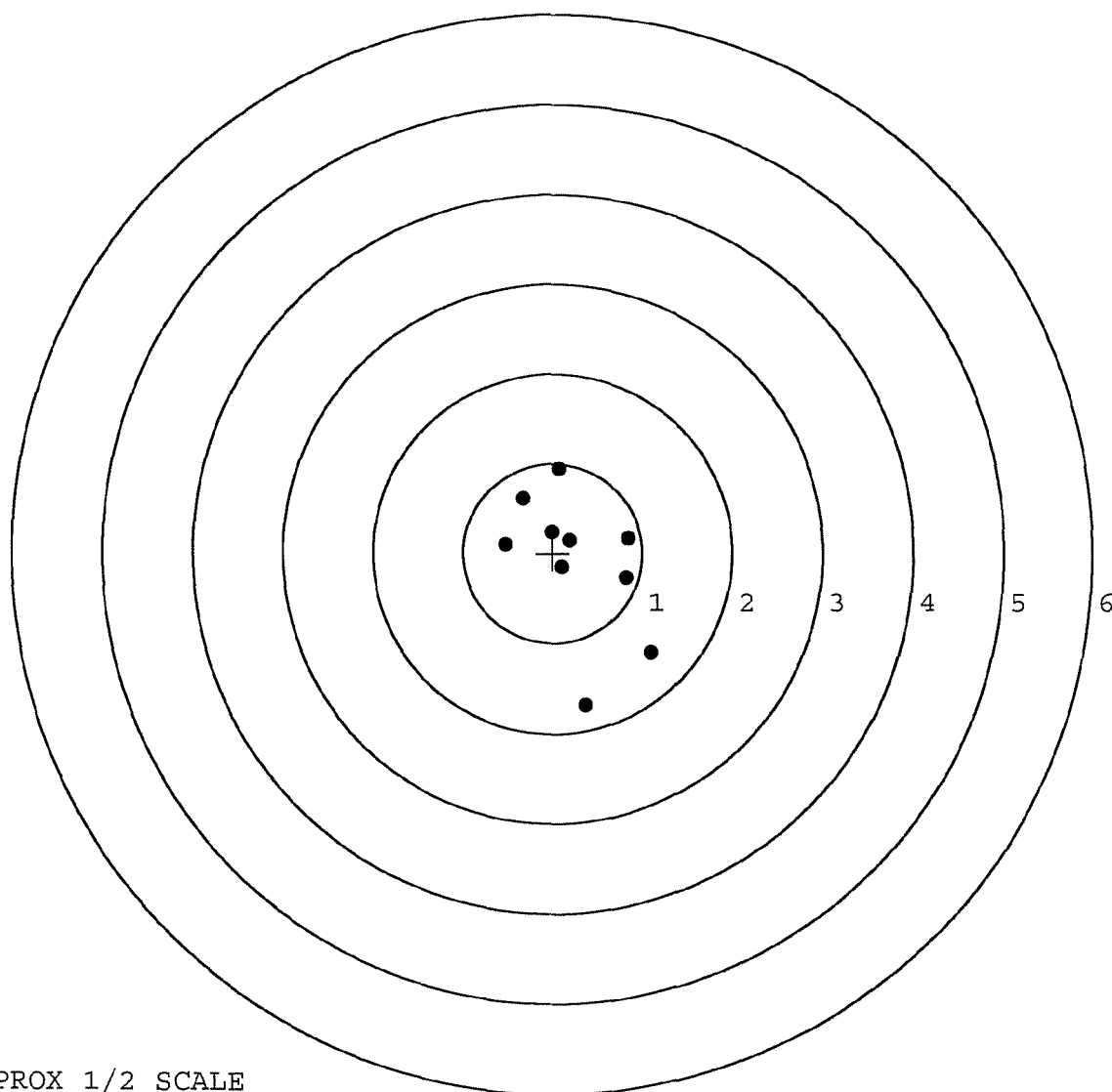
MAX RADIUS: 1.590

MEAN RADIUS: 0.780

# IN 1 IN DIAMETER: 3

# IN 2 IN DIAMETER: 7

# in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6611802. \_\_0

TARGET NUMBER: 2

FILE DATE: 04/01/2005

FILE TIME: 08:59

X CENTROID: -0.226

Y CENTROID: 0.115

POA TO CENTROID: 0.254

HORZ SPREAD: 1.487

VERT SPREAD: 3.199

GROUP SPREAD: 3.210

MIN RADIUS: 0.405

MAX RADIUS: 1.746

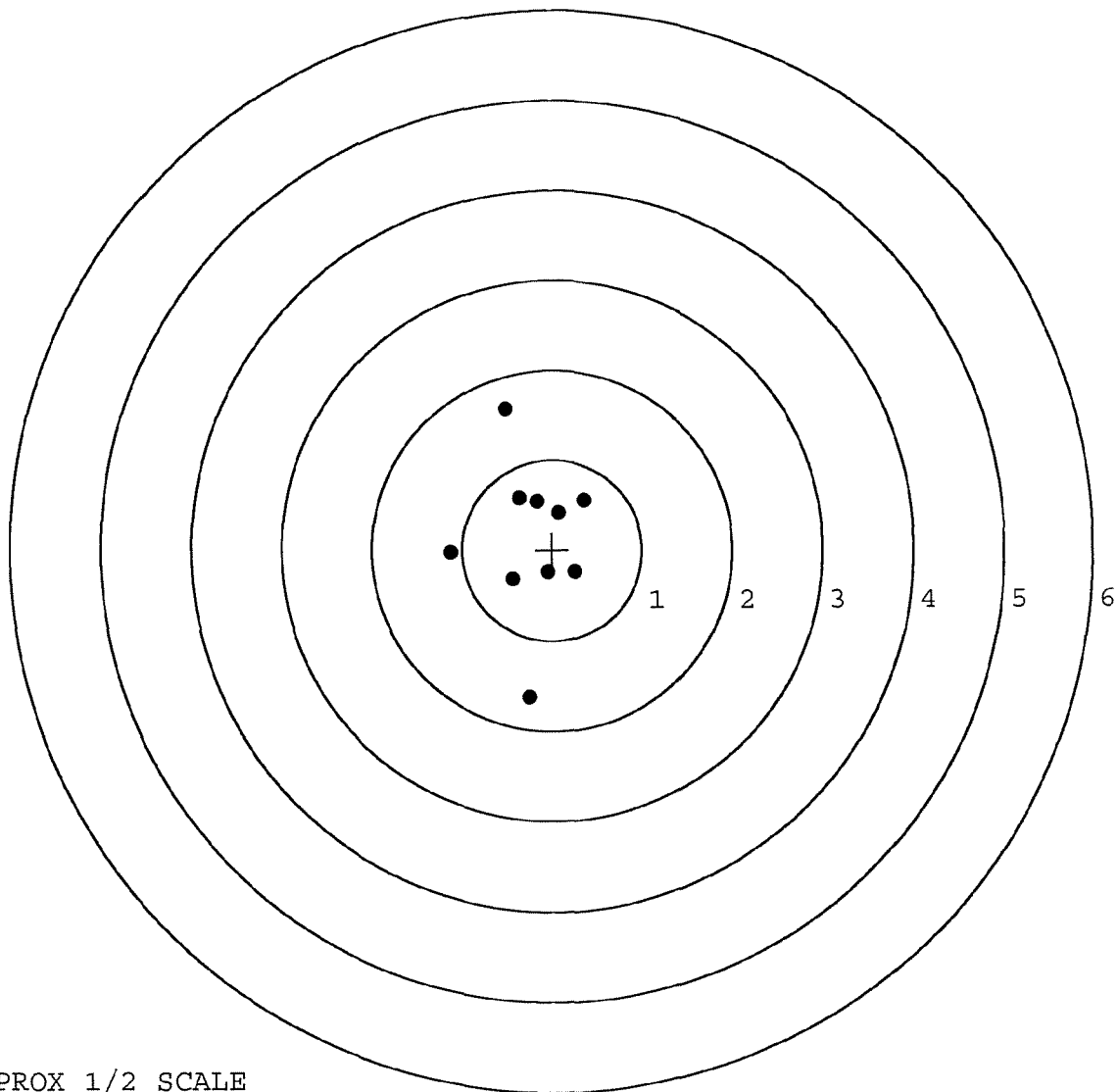
MEAN RADIUS: 0.770

# IN 1 IN DIAMETER: 5

# IN 2 IN DIAMETER: 8

# in 3 IN DIAMETER: 9

| POINT# | X      | Y      |
|--------|--------|--------|
| 1:     | -0.525 | 1.568  |
| 2:     | -1.130 | -0.040 |
| 3:     | -0.262 | -1.631 |
| 4:     | -0.443 | -0.325 |
| 5:     | -0.049 | -0.249 |
| 6:     | 0.260  | -0.244 |
| 7:     | -0.367 | 0.578  |
| 8:     | -0.169 | 0.539  |
| 9:     | 0.068  | 0.407  |
| 10:    | 0.357  | 0.548  |



TARGET APPROX 1/2 SCALE



SERIAL NUMBER: C6611802. \_\_0

TARGET NUMBER: 3

FILE DATE: 04/01/2005

FILE TIME: 08:59

X CENTROID: 0.035

Y CENTROID: -0.271

POA TO CENTROID: 0.274

HORZ SPREAD: 2.097

VERT SPREAD: 1.775

GROUP SPREAD: 2.582

MIN RADIUS: 0.265

MAX RADIUS: 1.354

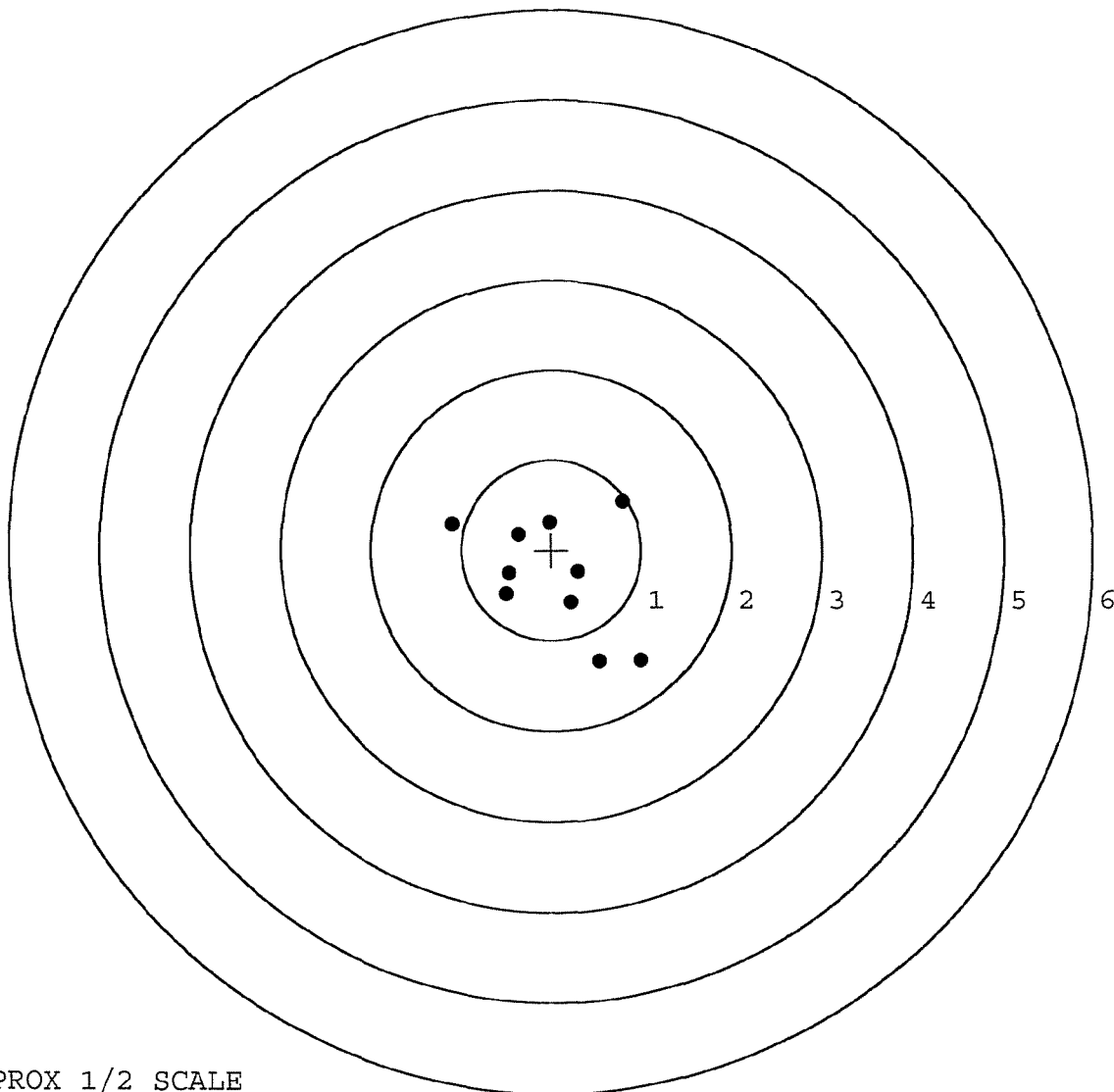
MEAN RADIUS: 0.773

# IN 1 IN DIAMETER: 2

# IN 2 IN DIAMETER: 6

# in 3 IN DIAMETER: 10

| POINT# | X      | Y      |
|--------|--------|--------|
| 1:     | 0.791  | 0.544  |
| 2:     | -0.030 | 0.310  |
| 3:     | -0.367 | 0.175  |
| 4:     | -1.100 | 0.282  |
| 5:     | -0.478 | -0.256 |
| 6:     | -0.513 | -0.492 |
| 7:     | 0.298  | -0.239 |
| 8:     | 0.219  | -0.581 |
| 9:     | 0.997  | -1.225 |
| 10:    | 0.535  | -1.231 |



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6611802. 0

TARGET NUMBER: 4

FILE DATE: 04/01/2005

FILE TIME: 08:59

X CENTROID: -0.150

Y CENTROID: -0.063

POA TO CENTROID: 0.162

HORZ SPREAD: 1.719

VERT SPREAD: 2.834

GROUP SPREAD: 2.922

MIN RADIUS: 0.130

MAX RADIUS: 1.689

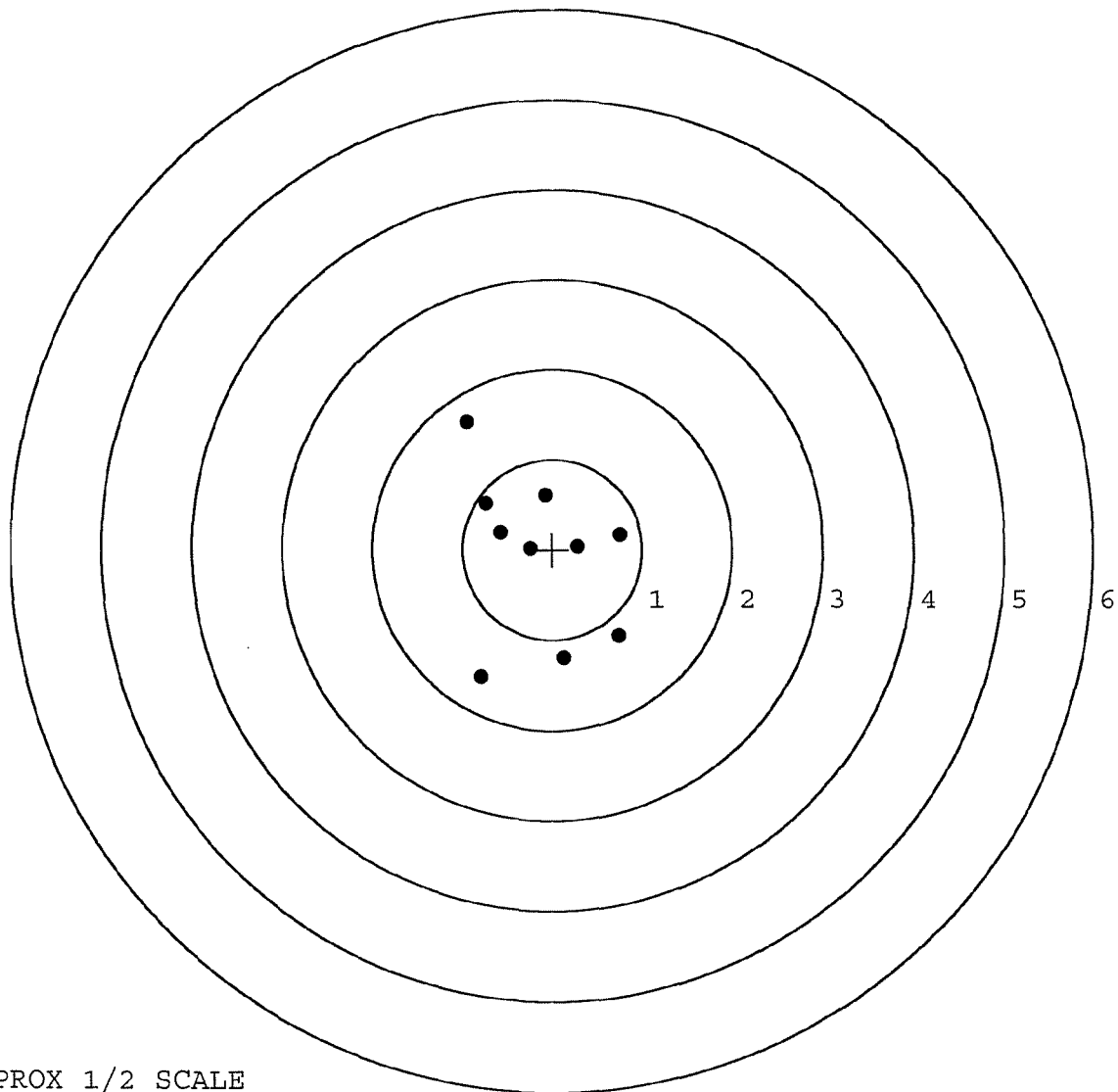
MEAN RADIUS: 0.912

# IN 1 IN DIAMETER: 3

# IN 2 IN DIAMETER: 6

# in 3 IN DIAMETER: 9

| POINT# | X      | Y      |
|--------|--------|--------|
| 1:     | -0.960 | 1.418  |
| 2:     | -0.743 | 0.508  |
| 3:     | -0.082 | 0.604  |
| 4:     | -0.578 | 0.188  |
| 5:     | -0.252 | 0.017  |
| 6:     | 0.283  | 0.034  |
| 7:     | 0.759  | 0.173  |
| 8:     | 0.740  | -0.958 |
| 9:     | 0.131  | -1.202 |
| 10:    | -0.794 | -1.416 |



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6611802. \_\_0

TARGET NUMBER: 5

FILE DATE: 04/01/2005

FILE TIME: 08:59

X CENTROID: 0.163

Y CENTROID: 0.236

POA TO CENTROID: 0.287

HORZ SPREAD: 1.796

VERT SPREAD: 1.784

GROUP SPREAD: 2.171

MIN RADIUS: 0.093

MAX RADIUS: 1.354

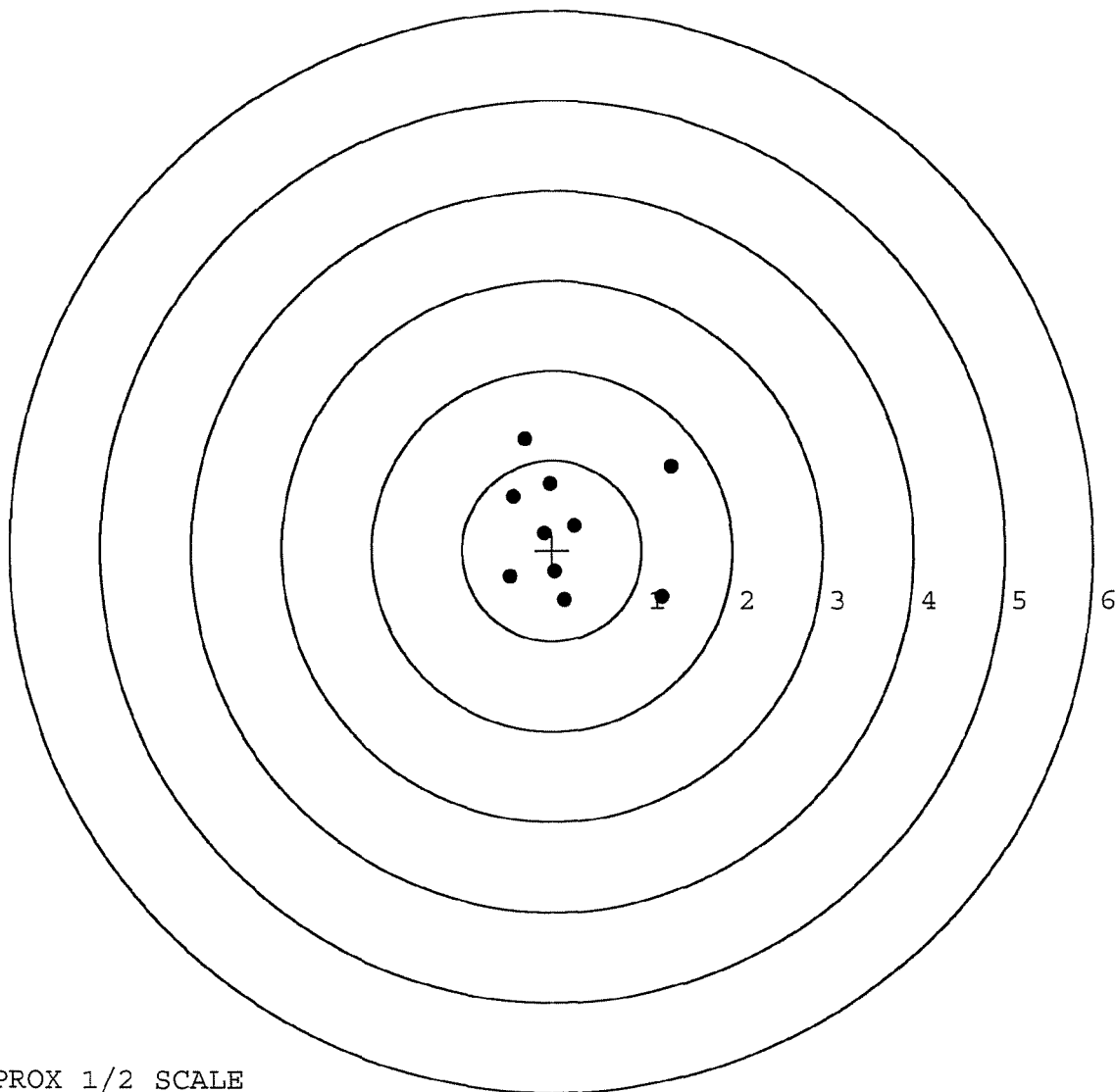
MEAN RADIUS: 0.745

# IN 1 IN DIAMETER: 3

# IN 2 IN DIAMETER: 7

# in 3 IN DIAMETER: 10

| POINT# | X      | Y      |
|--------|--------|--------|
| 1:     | -0.305 | 1.236  |
| 2:     | -0.031 | 0.735  |
| 3:     | 1.326  | 0.930  |
| 4:     | 1.223  | -0.517 |
| 5:     | -0.436 | 0.599  |
| 6:     | 0.251  | 0.268  |
| 7:     | -0.092 | 0.187  |
| 8:     | -0.470 | -0.289 |
| 9:     | 0.137  | -0.548 |
| 10:    | 0.031  | -0.237 |



TARGET APPROX 1/2 SCALE

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

|                            |                    |           |         |
|----------------------------|--------------------|-----------|---------|
| R & E NUMBER               | 92999              |           |         |
| SERIAL NUMBER              | C6611802           |           |         |
| LOG-IN DATE                | 2-11-05            |           |         |
| <b>INSPECT AND VERIFY:</b> |                    |           |         |
| OPERATION #                | OPERATION NAME     | DATE      | INITIAL |
| 550                        | DIS-ASSEMBLE GUN   | 2-21-05   | RTL     |
| 560 A                      | RE-BARREL          | 2-22-05   | RTL     |
| B                          | DRILL AND TAP      | 2-28-05   | TRL     |
| 575                        | ASSEMBLE           | 2-23-05   | RTL     |
| 600                        | PROOF              | 2-24-05   | Ac      |
| 605                        | CHECK HEADSPACE    | 2-24-05   | Ac      |
| 610                        | DIS-ASSEMBLE GUN   | 2-24-05   | RTL     |
| 612                        | MAGNAFLUX          | OPERATOR  |         |
| 615                        | ROLLMARK CALIBER   | 3-1-05    | CW      |
| 618                        | ROTO-BLAST         | 3-3-05    | LB      |
| 620                        | APPLY COATINGS     | 3/10/05   | HA      |
| 625 A                      | FINAL ASSEMBLY     | 3-31-05   | RTL     |
| B                          | TRIGGER PULL TEST  |           |         |
| C                          | SAFETY "ON" FORCE  | 4-17-05   | Ac      |
| D                          | SAFETY "OFF" FORCE | 4-7-05    | Ac      |
| E                          | FIRING PIN INDENT  | 4-7-05    | Ac      |
| 640                        | TARGET             | 4-1-05    | AC      |
| 655                        | FINAL INSPECT      | 4-7-05    | Ac      |
| 660                        | PACK               | 4-26-05   | DA      |
|                            |                    | SHIP DATE |         |
| QAR INSPECTION DATE        |                    |           |         |

CFM

GUN SERIAL #

C6611802

| OP. #     | OP. NAME                                                 | READINGS | DATE    | INIT |
|-----------|----------------------------------------------------------|----------|---------|------|
| 575 & 580 | Assemble Action and Stock                                |          | 1/22/91 | KS   |
| 600       | Proof                                                    |          | 1/22/91 | KS   |
| 607       | Check Headspace                                          |          | 1/22/91 | KS   |
| 610       | Dis-assemble Gun                                         |          | 1/22/91 | KS   |
| 612       | Magnaflux Barrel Action                                  |          | 1/29/91 | KR   |
|           | Magnaflux Bolt                                           |          | "       | KR   |
| 615       | Rollmark Caliber                                         |          | "       | JS   |
| 617       | Drill and Tap Sight Holes                                | 2 2 91   |         | KB   |
| 618       | Polish Barrel RBB                                        | 2 2 91   |         | WB   |
| 620       | Apply Coatings (Barrel Action)                           |          | 2-1-91  | TH   |
|           | Apply Coating (Bolt)                                     |          |         |      |
| 625       | Final Assembly                                           |          | 12/2/91 | KS   |
|           | A) Clean inside of Bolt Assembly                         |          |         |      |
|           | B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head |          | 12/2/91 | KS   |
|           | C) Inspect Ejector Hole for Chamfer                      |          | 12/2/91 | KS   |
|           | D) Oil Firing Pin Ass'y                                  |          | 12/2/91 | KS   |
|           | E) Adjust Trigger Pull to Min Setting and Stake          |          | 2/13/91 | JS   |

| op. #        | BARBER - M24 0036247<br>OP. NAME                            | READINGS |       |       |      |      | DATE    | INIT |
|--------------|-------------------------------------------------------------|----------|-------|-------|------|------|---------|------|
| 625<br>cont. | F) Safety On Force                                          | 6 1/2    | 6 1/2 | 6 1/2 |      |      | 2/13/91 | W/B  |
|              | G) Safety Off Force                                         | 2 3/4    | 2 3/4 | 2 3/4 |      |      | 2/13/91 | W/B  |
|              | H) Trigger Pull Test & Retainability                        |          |       |       |      |      | 2/13/91 | JK   |
|              | I) Firing Pin Indent                                        | .020     | .0205 | .020  |      |      | 2/13/91 | W/B  |
|              | J) Assemble Stock                                           |          |       |       |      |      | 2/13/91 | JK   |
|              | K) Assemble Swivel Studs                                    |          |       |       |      |      | 2-25-91 | AC   |
|              | L) Attach Front and Rear Sight Assemblies                   |          |       |       |      |      | 2/13/91 | JK   |
|              | M) Iron Sight Alignment                                     |          |       |       |      |      | 2/13/91 | JK   |
|              | N) Detach Front & Rear Sights & place in numbered container |          |       |       |      |      | 2/13/91 | JK   |
|              | O) Attach Scope to Rifle                                    |          |       |       |      |      | 2/13/91 | JK   |
|              | P) Detach & Attach Scope 20 Times                           |          |       |       |      |      | 2/13/91 | JK   |
| 640          | Gallery Target & Test                                       |          |       |       |      |      | 2-14-91 | AC   |
|              | A) Time                                                     |          |       |       |      |      | 2-14-91 | AC   |
|              | B) Malfunctions                                             |          |       |       |      |      | 2-14-91 | AC   |
|              | C) Pierced Primers                                          |          |       |       |      |      | 2-14-91 | AC   |
|              | D) Optical Clarity of Scope                                 |          |       |       |      |      | 2-14-91 | AC   |
| 645          | Inspect for Live Ammo                                       |          |       |       |      |      | 2-14-91 | AC   |
| 655          | Final Inspection                                            |          |       |       |      |      |         |      |
|              | A) Headspace                                                |          |       |       |      |      | 2-25-91 | AC   |
|              | B) Trigger Pull                                             | 2.46     | 2.50  | 2.36  | 2.52 | 2.54 | 2/21/91 | JK   |
|              | C) Function                                                 |          |       |       |      |      | 2-25-91 | AC   |
| 660          | Pack                                                        |          |       |       |      |      | 3-19-91 | NF   |

AVERAGE PULL FORCE BETWEEN  
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6611802

DATE 2/13/91

TESTER JM

|         | 2.50#<br>INITIAL | 2.50# AFTER<br>50 CYCLES | FINAL TEST &<br>TO RESET 2.50# |      | COMMENTS                                                               |
|---------|------------------|--------------------------|--------------------------------|------|------------------------------------------------------------------------|
| PULL #1 | 2.32             | 2.21                     | 2.49                           | 2.46 | MIN. SETTING,<br>NO AVG. OF 5<br>READINGS ACCEPT-<br>ABLE LESS THAN 2# |
| PULL #2 | 2.23             | 2.18                     | 2.52                           | 2.50 |                                                                        |
| PULL #3 | 2.30             | 2.22                     | 2.48                           | 2.36 |                                                                        |
| PULL #4 | 2.30             | 2.45                     | 2.50                           | 2.52 |                                                                        |
| PULL #5 | 2.33             | 2.50                     | 2.51                           | 2.54 |                                                                        |
| TOTAL   |                  |                          |                                |      |                                                                        |
| AVG.    |                  |                          |                                |      |                                                                        |

|         | 3.00#<br>INITIAL | 3.00# AFTER<br>20 CYCLES |  | COMMENTS |
|---------|------------------|--------------------------|--|----------|
| PULL #1 | 3.53             | 3.51                     |  |          |
| PULL #2 | 3.49             | 3.46                     |  |          |
| PULL #3 | 3.38             | 3.50                     |  |          |
| PULL #4 | 3.30             | 3.52                     |  |          |
| PULL #5 | 3.53             | 3.48                     |  |          |
| TOTAL   |                  |                          |  |          |
| AVG.    |                  |                          |  |          |

|         | 4.00#<br>INITIAL | 4.00# AFTER<br>20 CYCLES | MAX SETTING<br>GREATER THAN 4# | RESET TO 4# FOR<br>TARGET & ACCURACY |
|---------|------------------|--------------------------|--------------------------------|--------------------------------------|
| PULL #1 | 4.53             | 4.34                     |                                | 4.31                                 |
| PULL #2 | 4.54             | 4.34                     |                                | 4.42                                 |
| PULL #3 | 4.41             | 4.36                     |                                | 4.26                                 |
| PULL #4 | 4.25             | 4.28                     |                                | 4.37                                 |
| PULL #5 | 4.37             | 4.38                     |                                | 4.40                                 |
| TOTAL   |                  |                          |                                |                                      |
| AVG.    |                  |                          |                                |                                      |

CENTROIDAL DISTANCE CALCULATIONS  
FOR RIFLE # C6611802  
14 Feb 1991

CENTROIDAL DISTANCES

|        |         |
|--------|---------|
| 0 TO 1 | .339591 |
| 1 TO 2 | .537557 |
| 1 TO 3 | .318912 |
| 1 TO 4 | .539557 |
| 1 TO 5 | .287089 |

$\frac{x}{1}$  <----FOR

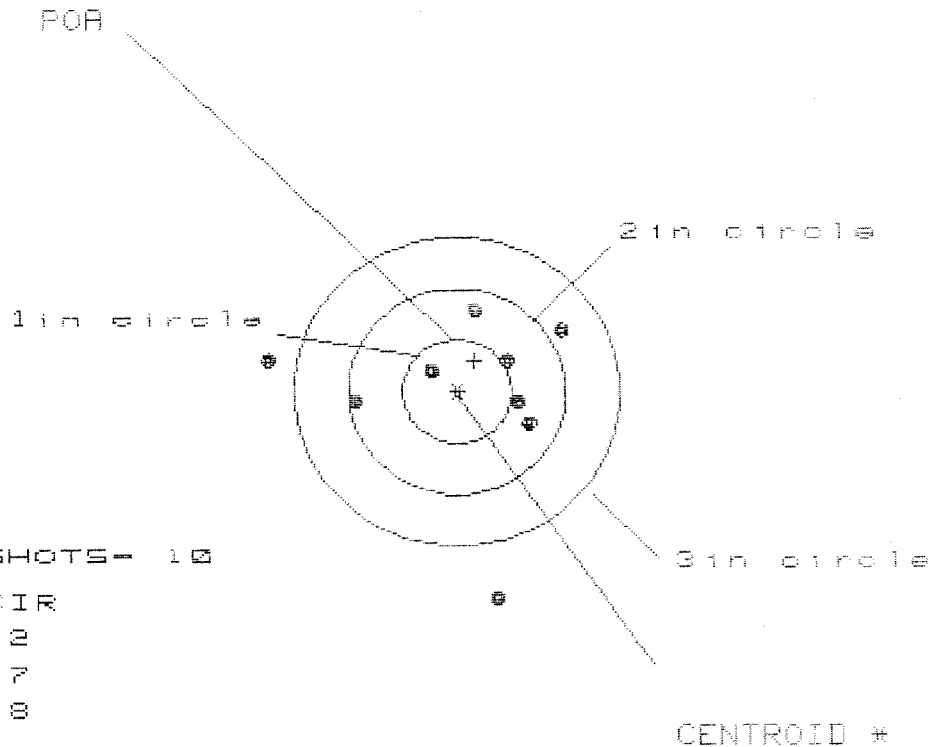
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0286  
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0284  
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0403053  
THE AMR FOR THIS RIFLE IS: .9132



14 Feb 1991

FILE:/PATTERNING/CENTERFIRE\_PATT/C8611802

## CENTERFIRE PATTERNS # 1



# OF SHOTS- 10

# IN CIR

1 in = 2

2 in = 7

3 in = 8

HS= 2.719

VS= 2.813

GS= 3.104

| PATTERN #           | 1      | 2      | 3      |
|---------------------|--------|--------|--------|
| SHOTS (BEST OF)     | 10     | 9      | 8      |
| MAXIMUM X           | .999   | 1.034  | .824   |
| MINIMUM X           | -1.720 | -1.685 | -1.084 |
| MAXIMUM Y           | .815   | .593   | .608   |
| MINIMUM Y           | -1.998 | -.488  | -.473  |
| CENTROID X          | -.161  | -.196  | .014   |
| CENTROID Y          | -.299  | -.077  | -.092  |
| POA TO CENTROID in. | .340   | .211   | .093   |
| MIN RADIUS          | .294   | .205   | .258   |
| MEAN RADIUS         | .904   | .746   | .609   |
| MAX RADIUS          | 2.023  | 1.689  | 1.118  |
| HORIZONTAL SPREAD   | 2.719  | 2.719  | 1.908  |
| VERTICAL SPREAD     | 2.813  | 1.081  | 1.081  |

| EXTREME SPREAD                | 1     | 2     | 3     |
|-------------------------------|-------|-------|-------|
| EXTREME SPREAD                | 3.104 | 2.734 | 2.029 |
| NUMBER IN ONE INCH CIRCLE =   | 2     | 7     | 8     |
| NUMBER IN TWO INCH CIRCLE =   | 7     | 8     | 8     |
| NUMBER IN THREE INCH CIRCLE = | 8     | 8     | 8     |

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## CENTERFIRE PATTERNS

# 2

POA

1in circle

2in circle

3in circle

# OF SHOTS- 10

# IN CIR

1in = 2

2in = 6

3in = 8

HS= 3.054

VS= 2.252

GS= 3.054

CENTROID \*

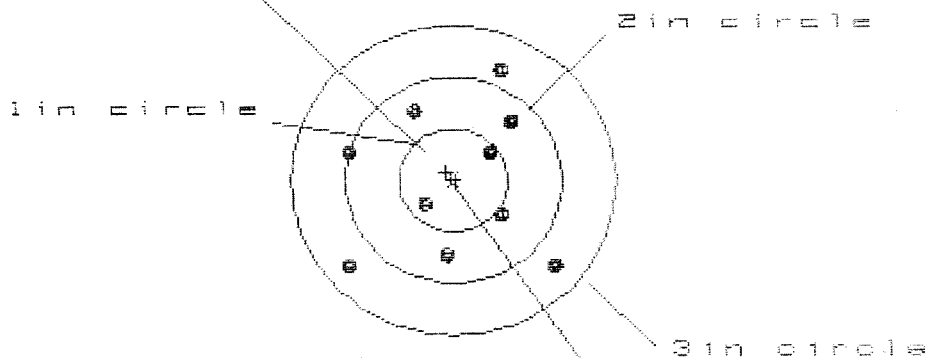
| PATTERN #                   | : | 2      |        |        |
|-----------------------------|---|--------|--------|--------|
| SHOTS (BEST OF)             | : | 10     | 9      | 8      |
| MAXIMUM X                   | : | 1.738  | .737   | .765   |
| MINIMUM X                   | : | -1.316 | -1.122 | -1.030 |
| MAXIMUM Y                   | : | 1.474  | 1.396  | .852   |
| MINIMUM Y                   | : | -.778  | -.856  | -.681  |
| CENTROID X                  | : | .177   | -.017  | -.109  |
| CENTROID Y                  | : | .119   | .197   | .022   |
| POA TO CENTROID in.         | : | .213   | .197   | .111   |
| MIN RADIUS                  | : | .287   | .431   | .237   |
| MEAN RADIUS                 | : | .957   | .845   | .728   |
| MAX RADIUS                  | : | 1.873  | 1.579  | 1.188  |
| HORIZONTAL SPREAD           | : | 3.054  | 1.859  | 1.795  |
| VERTICAL SPREAD             | : | 2.252  | 2.252  | 1.533  |
| EXTREME SPREAD              | : | 3.054  | 2.852  | 1.927  |
| NUMBER IN ONE INCH CIRCLE   | = |        | 2      |        |
| NUMBER IN TWO INCH CIRCLE   | = |        | 6      |        |
| NUMBER IN THREE INCH CIRCLE | = |        | 8      |        |

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## CENTERFIRE PATTERNS # 3

POA



# OF SHOTS - 10

# IN CIR

1 in - 2

2 in - 6

3 in - 10

HS= 1.935

VS= 1.957

GS= 2.407

CENTROID #

| PATTERN #                     | 10    | 9      | 8     |
|-------------------------------|-------|--------|-------|
| SHOTS (BEST OF)               | 10    | 9      | 8     |
| MAXIMUM X                     | .964  | .856   | .499  |
| MINIMUM X                     | -.971 | -1.064 | -.957 |
| MAXIMUM Y                     | 1.097 | 1.001  | .892  |
| MINIMUM Y                     | -.860 | -.874  | -.951 |
| CENTROID X                    | .066  | .174   | .067  |
| CENTROID Y                    | -.075 | .021   | .130  |
| POA TO CENTROID in.           | .100  | .175   | .146  |
| MIN RADIUS                    | .416  | .295   | .349  |
| MEAN RADIUS                   | .844  | .780   | .722  |
| MAX RADIUS                    | 1.297 | 1.223  | .990  |
| HORIZONTAL SPREAD             | 1.935 | 1.920  | 1.456 |
| VERTICAL SPREAD               | 1.957 | 1.875  | 1.843 |
| EXTREME SPREAD                | 2.407 | 2.212  | 1.905 |
| NUMBER IN ONE INCH CIRCLE =   | 2     |        |       |
| NUMBER IN TWO INCH CIRCLE =   | 6     |        |       |
| NUMBER IN THREE INCH CIRCLE = | 10    |        |       |

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## CENTERFIRE PATTERNS

# 4

POB

1in circle

2in circle

3in circle

# OF SHOTS- 10

# IN CIR

1in = 2

2in = 4

3in = 9

HS= 2.581

VS= 2.913

GS= 3.022

CENTROID #

PATTERN #

:

4

SHOTS (BEST OF)

:

10

9

8

MAXIMUM X

:

1.425

1.390

.893

MINIMUM X

:

-1.156

-1.191

-1.017

MAXIMUM Y

:

1.024

.814

.730

MINIMUM Y

:

-1.889

-1.140

-1.224

CENTROID X

:

.018

.053

-.120

CENTROID Y

:

.210

.420

.504

POB TO CENTROID in.:

.211

.423

.518

MIN RADIUS

:

.344

.229

.186

MEAN RADIUS

:

1.021

.892

.794

MAX RADIUS

:

1.916

1.543

1.258

HORIZONTAL SPREAD

:

2.581

2.581

1.911

VERTICAL SPREAD

:

2.913

1.954

1.954

EXTREME SPREAD

:

3.022

2.678

2.029

NUMBER IN ONE INCH CIRCLE =

2

NUMBER IN TWO INCH CIRCLE =

4

NUMBER IN THREE INCH CIRCLE =

9

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# CENTERFIRE PATTERNS # 5

POA

1 in circle

2 in circle

3 in circle

CENTROID \*

# OF SHOTS - 10

# IN CIR

1 in = 1

2 in = 7

3 in = 9

HS = 1.927

VS = 2.683

GS = 2.829

| PATTERN #                   | : | 10     | 9     | 8     |
|-----------------------------|---|--------|-------|-------|
| SHOTS (BEST OF)             | : | 10     | 9     | 8     |
| MAXIMUM X                   | : | 1.260  | 1.333 | 1.312 |
| MINIMUM X                   | : | -.667  | -.594 | -.615 |
| MAXIMUM Y                   | : | 1.268  | 1.111 | .607  |
| MINIMUM Y                   | : | -1.415 | -.780 | -.641 |
| CENTROID X                  | : | .043   | -.030 | -.009 |
| CENTROID Y                  | : | -.097  | .060  | -.079 |
| POA TO CENTROID in.         | : | .106   | .067  | .079  |
| MIN RADIUS                  | : | .313   | .249  | .258  |
| MEAN RADIUS                 | : | .840   | .736  | .684  |
| MAX RADIUS                  | : | 1.560  | 1.341 | 1.312 |
| HORIZONTAL SPREAD           | : | 1.927  | 1.927 | 1.927 |
| VERTICAL SPREAD             | : | 2.683  | 1.891 | 1.248 |
| EXTREME SPREAD              | : | 2.829  | 2.028 | 2.028 |
| NUMBER IN ONE INCH CIRCLE   | = | 1      |       |       |
| NUMBER IN TWO INCH CIRCLE   | = | 7      |       |       |
| NUMBER IN THREE INCH CIRCLE | = | 9      |       |       |