

C6348736

MODEL 700TM M24

Model **SWS**TM

Action

Barrel Length

Capacity

Order No. **5716**

*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: RE00131864

Serial: C6348736 Model M24 SWS Center Fire
Caliber: 7.62 NATO Produced: 12/13/1989

Repairman:

Status:

Closed 7/30/2007 9:47:06 AM

Verify Repair

Address Information

Customer:

Received From

Return To:

Received From

Name: 0002 AR RGT 03 B CO INF BN BCT (WDA6B0)

0002 AR RGT 03 B CO INF BN BCT (WDA6B0)

Address 1: ROSE BARRACKS

ROSE BARRACKS

Address 2: SOUTH CAMP BLDG 728

PO Box:

SOUTH CAMP BLDG 728

PO Box:

City: MILSECK

MILSECK

State: DE

Zip Code: 192249

Country: US

State: DE

Zip Code: 192249

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
A010	Hard Case	1
A017	Scope Base	1
A026	Scope	1
A055	Deployment Kit	1
A057	Fit and Rear Sgt Base	1

Repair Search

Refresh

Close

nagletj

7/31/2007

9:05 AM

CAPS

NUM

INS

SCRL

Serial Number:

C6348736

Model: M24 SWS



RE00131864

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6348736.___0

FILE DATE AND TIME: 08/20/2007 13:59

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.023
The Average Y Centroid of the Five Target Set:	-0.129
The Average Point of Impact of the Five Target Set:	0.131
The Average Mean Radius of the Five Target Set:	0.671
The Distance from POA to Centroid Target #1:	0.381
The Distance from Centroid Target #2 to Centroid Target #1:	0.288
The Distance from Centroid Target #3 to Centroid Target #1:	0.383
The Distance from Centroid Target #4 to Centroid Target #1:	0.412
The Distance from Centroid Target #5 to Centroid Target #1:	0.502

SERIAL NUMBER: C6348736. 0

TARGET NUMBER: 1

FILE DATE: 08/20/2007

FILE TIME: 13:59

POINT#	X	Y
1:	0.880	-0.431
2:	0.457	-0.097
3:	0.084	-0.209
4:	-0.274	-0.627
5:	-0.293	-0.037
6:	0.086	0.163
7:	-0.147	0.181
8:	-0.887	0.497
9:	1.896	-1.197
10:	1.387	-0.328

X CENTROID: 0.319

Y CENTROID: -0.208

POA TO CENTROID: 0.381

HORZ SPREAD: 2.783

VERT SPREAD: 1.694

GROUP SPREAD: 3.258

MIN RADIUS: 0.177

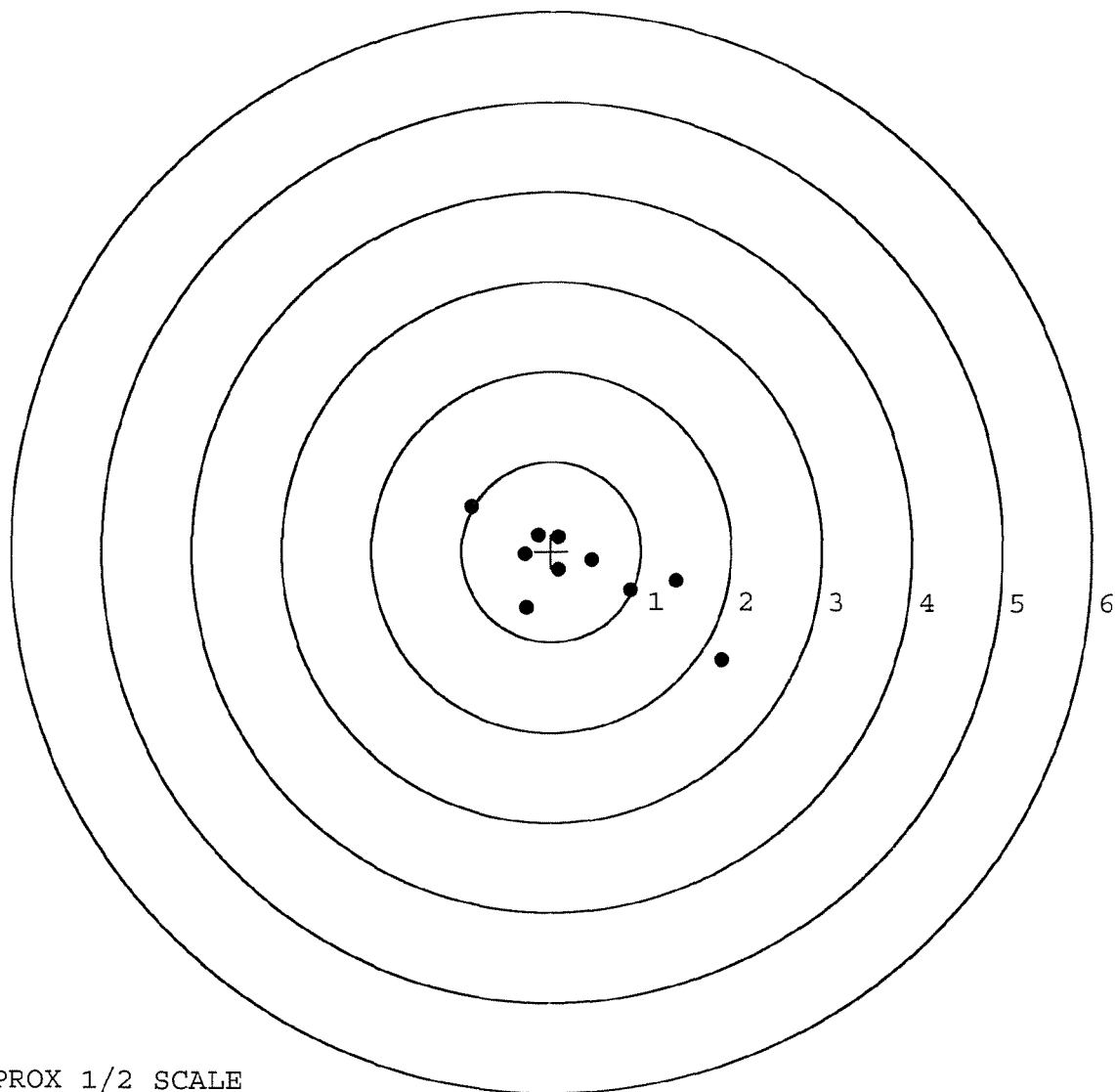
MAX RADIUS: 1.861

MEAN RADIUS: 0.776

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

BARBER - M24 0062692

SERIAL NUMBER: C6348736. 0

TARGET NUMBER: 2

FILE DATE: 08/20/2007

FILE TIME: 13:59

POINT#	X	Y
1:	0.164	-0.767
2:	0.044	-0.643
3:	-0.167	-0.375
4:	-0.182	-0.211
5:	-0.668	-0.294
6:	0.086	0.139
7:	0.199	0.330
8:	0.476	0.431
9:	0.113	0.935
10:	0.251	-1.772

X CENTROID: 0.032

Y CENTROID: -0.223

POA TO CENTROID: 0.225

HORZ SPREAD: 1.144

VERT SPREAD: 2.707

GROUP SPREAD: 2.711

MIN RADIUS: 0.214

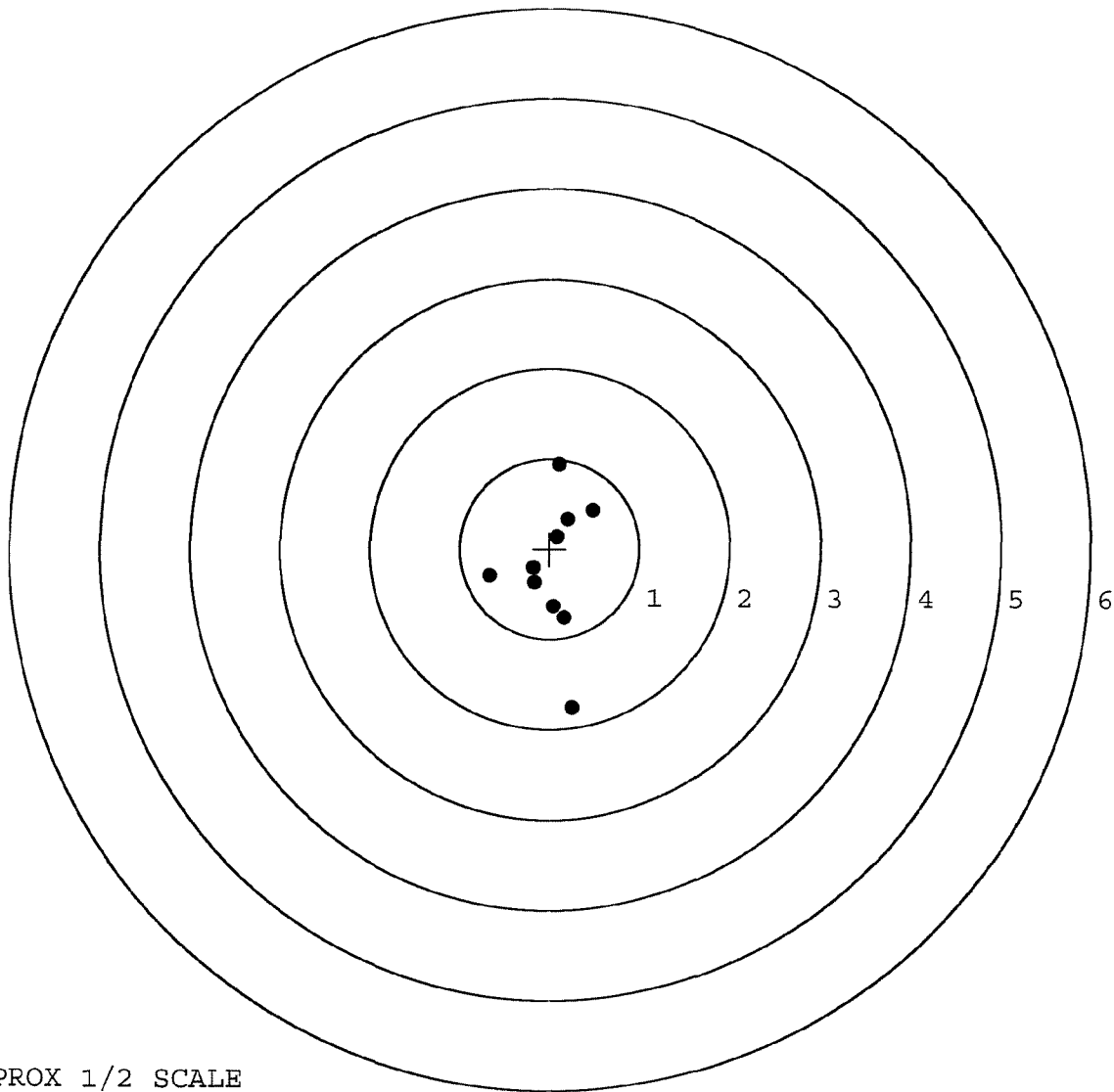
MAX RADIUS: 1.565

MEAN RADIUS: 0.661

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 9



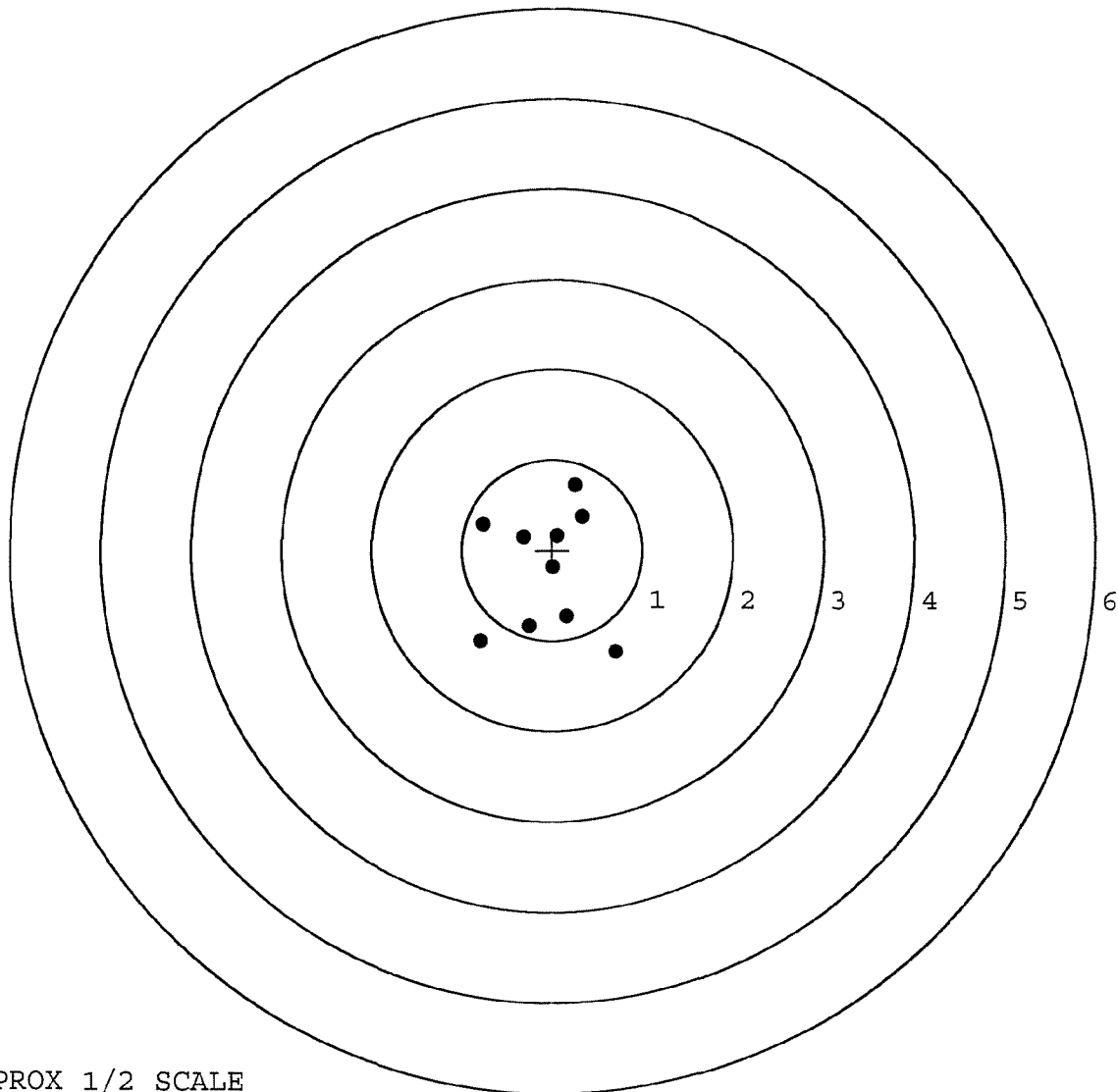
TARGET APPROX 1/2 SCALE

BARBER - M24 0062693

SERIAL NUMBER: C6348736. 0
 TARGET NUMBER: 3
 FILE DATE: 08/20/2007
 FILE TIME: 13:59

POINT#	X	Y
1:	0.701	-1.130
2:	0.161	-0.735
3:	-0.254	-0.841
4:	-0.796	-1.013
5:	-0.771	0.293
6:	-0.323	0.147
7:	0.008	-0.188
8:	0.054	0.163
9:	0.331	0.367
10:	0.250	0.715

X CENTROID: -0.064
 Y CENTROID: -0.222
 POA TO CENTROID: 0.231
 HORZ SPREAD: 1.497
 VERT SPREAD: 1.845
 GROUP SPREAD: 2.047
 MIN RADIUS: 0.080
 MAX RADIUS: 1.187
 MEAN RADIUS: 0.698
 # IN 1 IN DIAMETER: 3
 # IN 2 IN DIAMETER: 8
 # in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

BARBER - M24 0062694

SERIAL NUMBER: C6348736. 0

TARGET NUMBER: 4

FILE DATE: 08/20/2007

FILE TIME: 13:59

POINT#	X	Y
1:	-1.219	0.744
2:	-0.011	0.571
3:	-0.355	0.057
4:	-0.621	0.052
5:	-0.344	-0.381
6:	0.207	-0.552
7:	0.491	-0.424
8:	0.612	-0.240
9:	0.589	0.004
10:	0.298	0.179

X CENTROID: -0.035

Y CENTROID: 0.001

POA TO CENTROID: 0.035

HORZ SPREAD: 1.831

VERT SPREAD: 1.296

GROUP SPREAD: 2.079

MIN RADIUS: 0.325

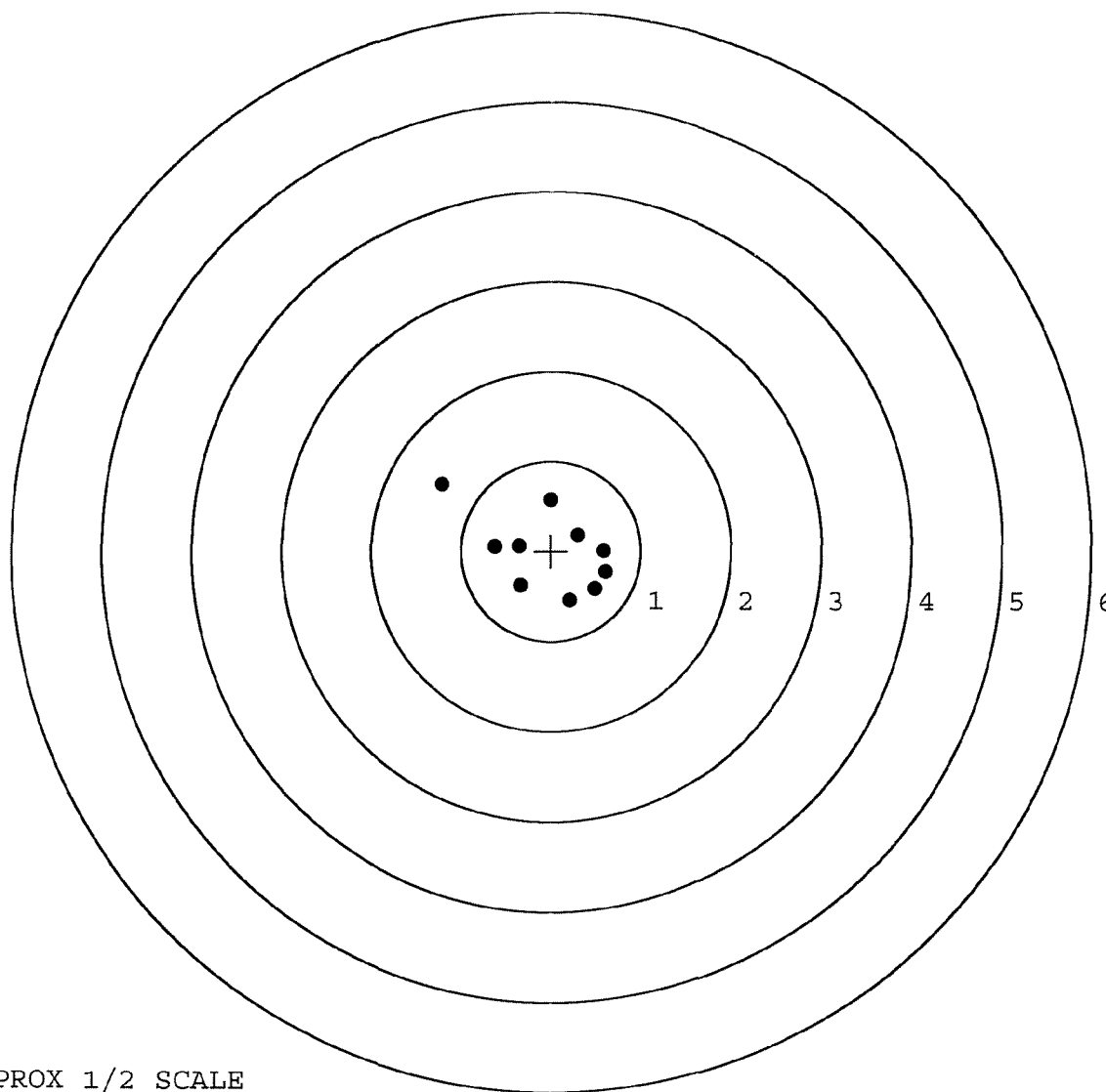
MAX RADIUS: 1.398

MEAN RADIUS: 0.634

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10



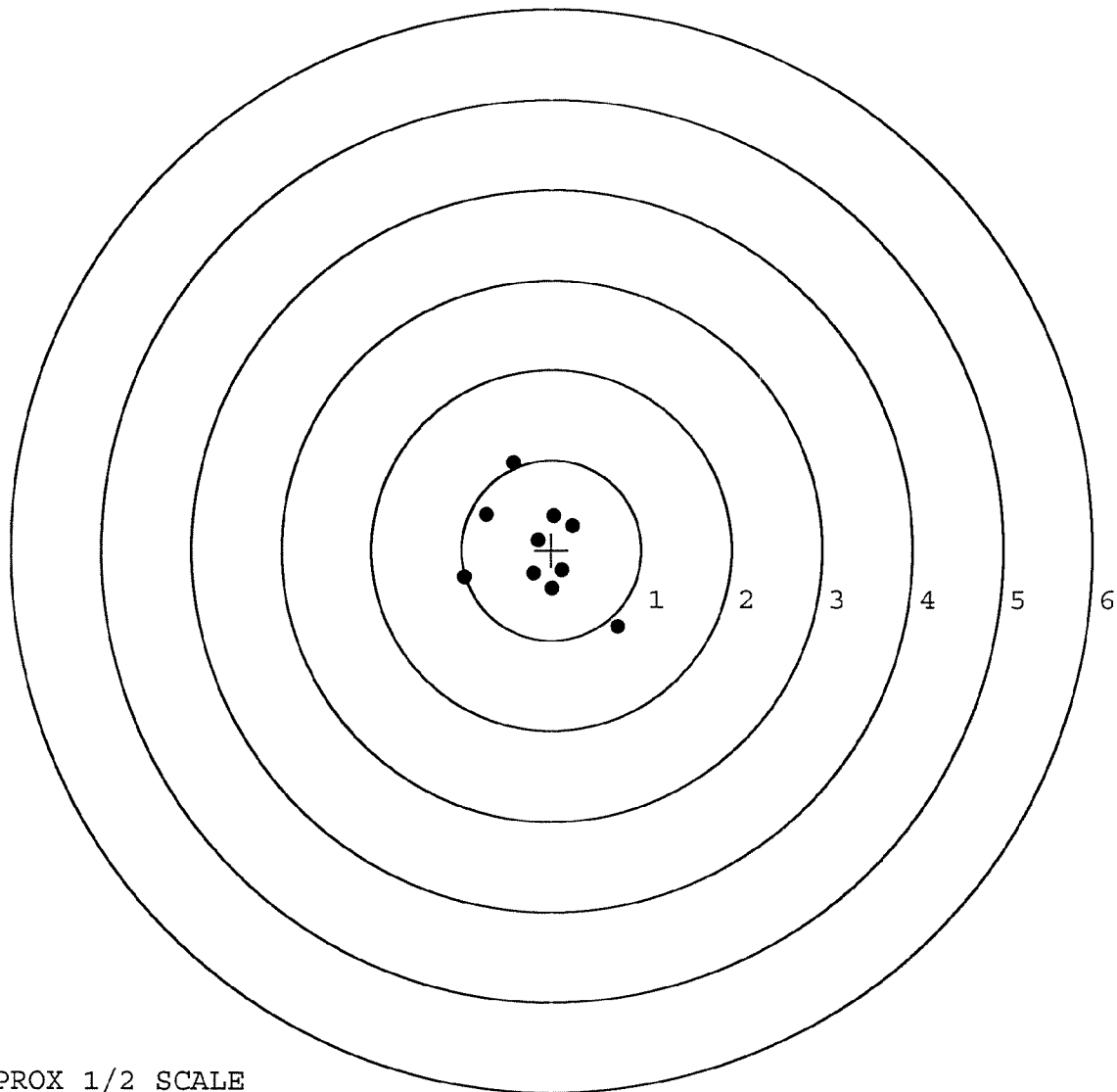
TARGET APPROX 1/2 SCALE

BARBER - M24 0062695

SERIAL NUMBER: C6348736. __0
 TARGET NUMBER: 5
 FILE DATE: 08/20/2007
 FILE TIME: 13:59

POINT#	X	Y
1:	0.734	-0.855
2:	-0.972	-0.301
3:	-0.724	0.397
4:	-0.423	0.969
5:	0.234	0.268
6:	0.030	0.384
7:	-0.152	0.113
8:	0.119	-0.230
9:	0.009	-0.430
10:	-0.204	-0.262

X CENTROID: -0.135
 Y CENTROID: 0.005
 POA TO CENTROID: 0.135
 HORZ SPREAD: 1.706
 VERT SPREAD: 1.824
 GROUP SPREAD: 2.160
 MIN RADIUS: 0.109
 MAX RADIUS: 1.223
 MEAN RADIUS: 0.588
 # IN 1 IN DIAMETER: 6
 # IN 2 IN DIAMETER: 8
 # in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

R & E NUMBER

131864

SERIAL NUMBER

C6348736

LOG-IN DATE

7-30-07

OPERATION #	OPERATION NAME	DATE	INITIAL
500	DIS-ASSEMBLE GUN	8-7-07	RTZ
505	RE-BARREL	8-9-07	RTZ
560	ASSEMBLE	8-9-07	RTZ
600	PROOF	8-9-07	mm
605	CHECK HEADSPACE	8-9-07	mm
610	DIS-ASSEMBLE GUN	8-9-07	SD
612	MAGNAFLUX	8-14-07	NRB
510	DRILL AND TAP	8-10-07	TRW
615	ROLLMARK CALIBER	8-10-07	CW
618	ROTO-BLAST	8-14-07	LY
620	APPLY COATINGS	8/15/07	RB
625	FINAL ASSEMBLY	8-20-07	RTZ
640	FUNCTION TEST AND	(PASS) FAIL	8-20-07 TRW
650	TARGET	(PASS) FAIL	8-20-07 TRW
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
670	FINAL INSPECTION		8/20/07 WR
	A) HEADSPACE	PASS FAIL	8/20/07 BA
	B) TRIGGER PULL	2.76 2.55 2.70 2.81 2.76	8-20-07 TRW
680	F) SAFETY ON FORCE	5.0 5.25 5.25	8-20-07 TRW
	G) SAFETY OFF FORCE	2.25 2.25 2.25	8-20-07 TRW
	I) FIRING PIN INDENT	.0215 .022 .0215	8-20-07 TRW
690	PACK		8-23-07 BA

Serial Number: C6348736

Model: 700

RE00075216

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6348736.___0
FILE DATE AND TIME: 01/26/2004 09:03

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.039
The Average Y Centroid of the Five Target Set:	-0.011
The Average Point of Impact of the Five Target Set:	0.041
The Average Mean Radius of the Five Target Set:	0.527
The Distance from POA to Centroid Target #1:	0.305
The Distance from Centroid Target #2 to Centroid Target #1:	0.431
The Distance from Centroid Target #3 to Centroid Target #1:	0.386
The Distance from Centroid Target #4 to Centroid Target #1:	0.367
The Distance from Centroid Target #5 to Centroid Target #1:	0.212

SERIAL NUMBER: C6348736. __0

TARGET NUMBER: 1

FILE DATE: 01/26/2004

FILE TIME: 09:03

POINT#	X	Y
1:	0.684	1.085
2:	0.394	0.941
3:	0.546	0.781
4:	0.812	0.327
5:	0.004	0.445
6:	-0.353	0.225
7:	-0.262	-0.024
8:	0.052	-0.432
9:	0.555	-0.879
10:	0.213	-0.956

X CENTROID: 0.265

Y CENTROID: 0.151

POA TO CENTROID: 0.305

HORZ SPREAD: 1.165

VERT SPREAD: 2.041

GROUP SPREAD: 2.095

MIN RADIUS: 0.393

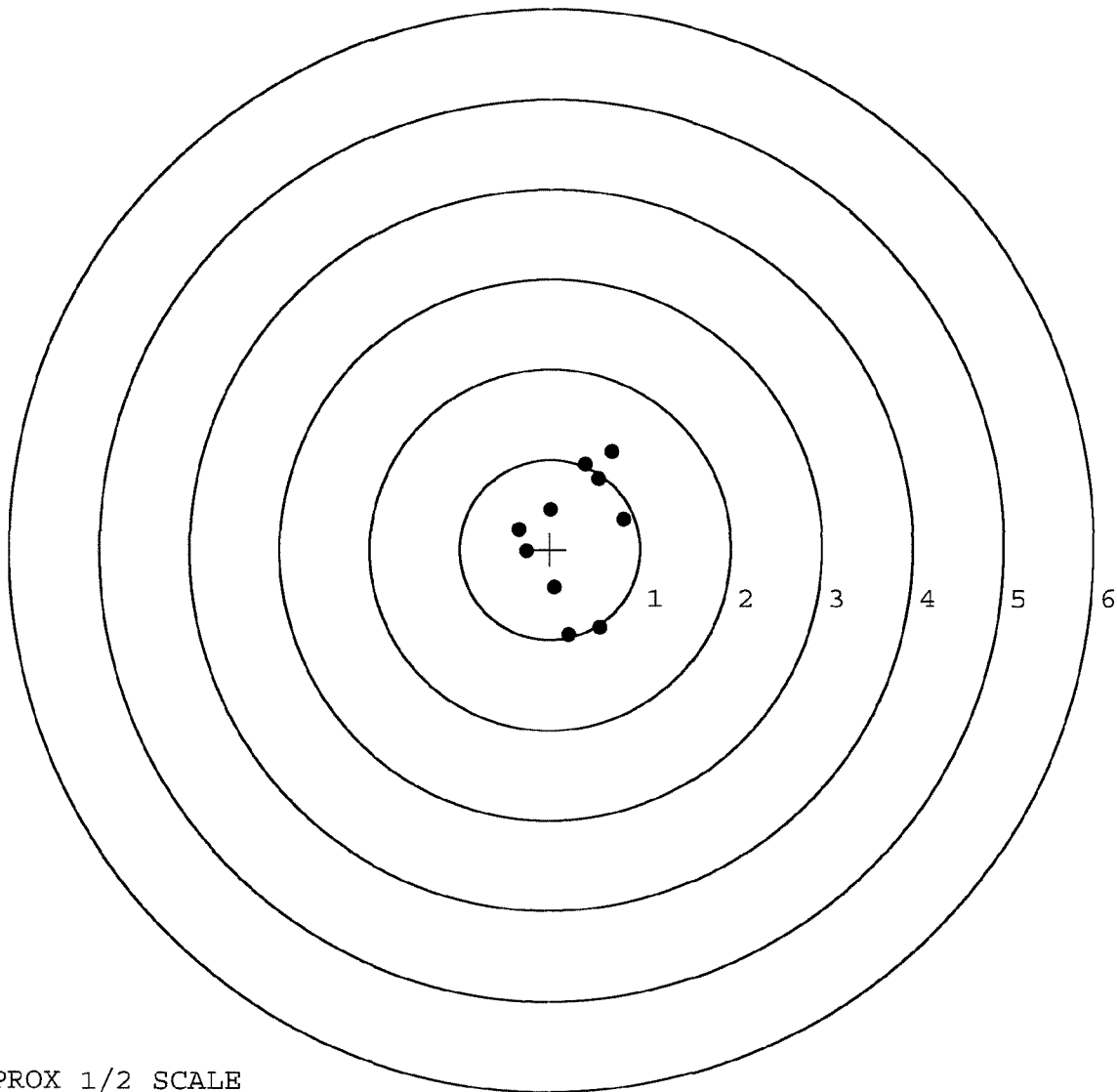
MAX RADIUS: 1.108

MEAN RADIUS: 0.746

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10



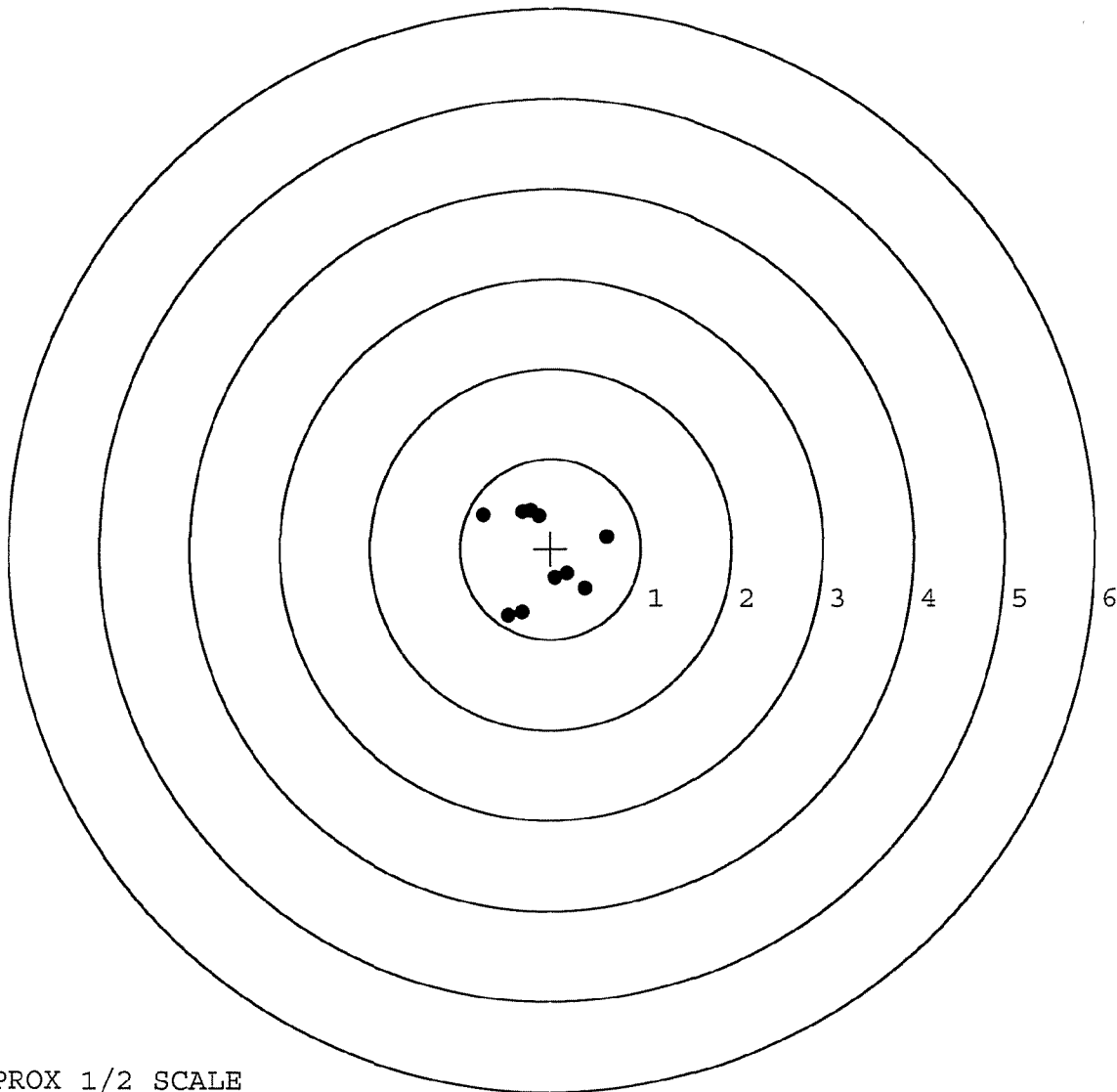
TARGET APPROX 1/2 SCALE

BARBER - M24 0062700

SERIAL NUMBER: C6348736. 0
 TARGET NUMBER: 2
 FILE DATE: 01/26/2004
 FILE TIME: 09:03

POINT#	X	Y
1:	-0.135	0.366
2:	-0.320	0.407
3:	-0.749	0.378
4:	-0.472	-0.734
5:	0.047	-0.325
6:	0.386	-0.443
7:	0.616	0.132
8:	-0.233	0.420
9:	0.181	-0.280
10:	-0.320	-0.704

X CENTROID: -0.100
 Y CENTROID: -0.078
 POA TO CENTROID: 0.127
 HORZ SPREAD: 1.365
 VERT SPREAD: 1.154
 GROUP SPREAD: 1.401
 MIN RADIUS: 0.287
 MAX RADIUS: 0.793
 MEAN RADIUS: 0.569
 # IN 1 IN DIAMETER: 3
 # IN 2 IN DIAMETER: 10
 # in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

BARBER - M24 0062701

SERIAL NUMBER: C6348736. __0

TARGET NUMBER: 3

FILE DATE: 01/26/2004

FILE TIME: 09:03

POINT#	X	Y
1:	0.604	-0.386
2:	0.323	-0.380
3:	0.107	-0.525
4:	-1.220	-0.302
5:	-0.438	-0.149
6:	-0.335	0.159
7:	0.349	0.182
8:	0.150	0.340
9:	-0.016	0.307
10:	-0.165	0.240

X CENTROID: -0.064

Y CENTROID: -0.051

POA TO CENTROID: 0.082

HORZ SPREAD: 1.824

VERT SPREAD: 0.865

GROUP SPREAD: 1.826

MIN RADIUS: 0.308

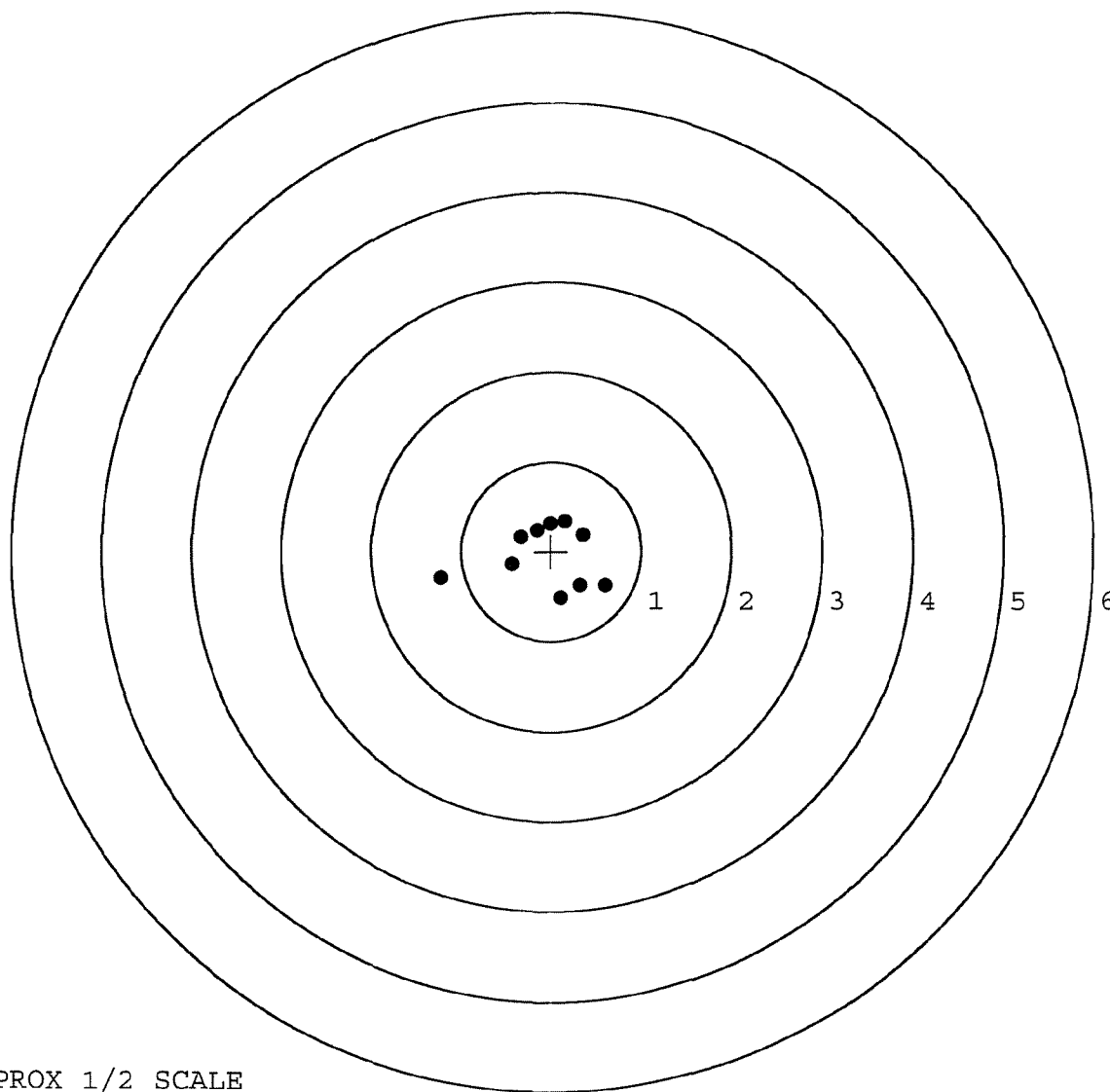
MAX RADIUS: 1.183

MEAN RADIUS: 0.526

IN 1 IN DIAMETER: 6

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

BARBER - M24 0062702

SERIAL NUMBER: C6348736. __0

TARGET NUMBER: 4

FILE DATE: 01/26/2004

FILE TIME: 09:03

POINT#	X	Y
1:	-0.346	0.632
2:	0.641	-0.273
3:	0.130	-0.489
4:	0.182	-0.178
5:	0.388	0.073
6:	0.030	0.167
7:	-0.099	-0.023
8:	-0.366	-0.032
9:	-0.602	-0.481
10:	-0.227	-0.107

X CENTROID: -0.027

Y CENTROID: -0.071

POA TO CENTROID: 0.076

HORZ SPREAD: 1.243

VERT SPREAD: 1.121

GROUP SPREAD: 1.339

MIN RADIUS: 0.087

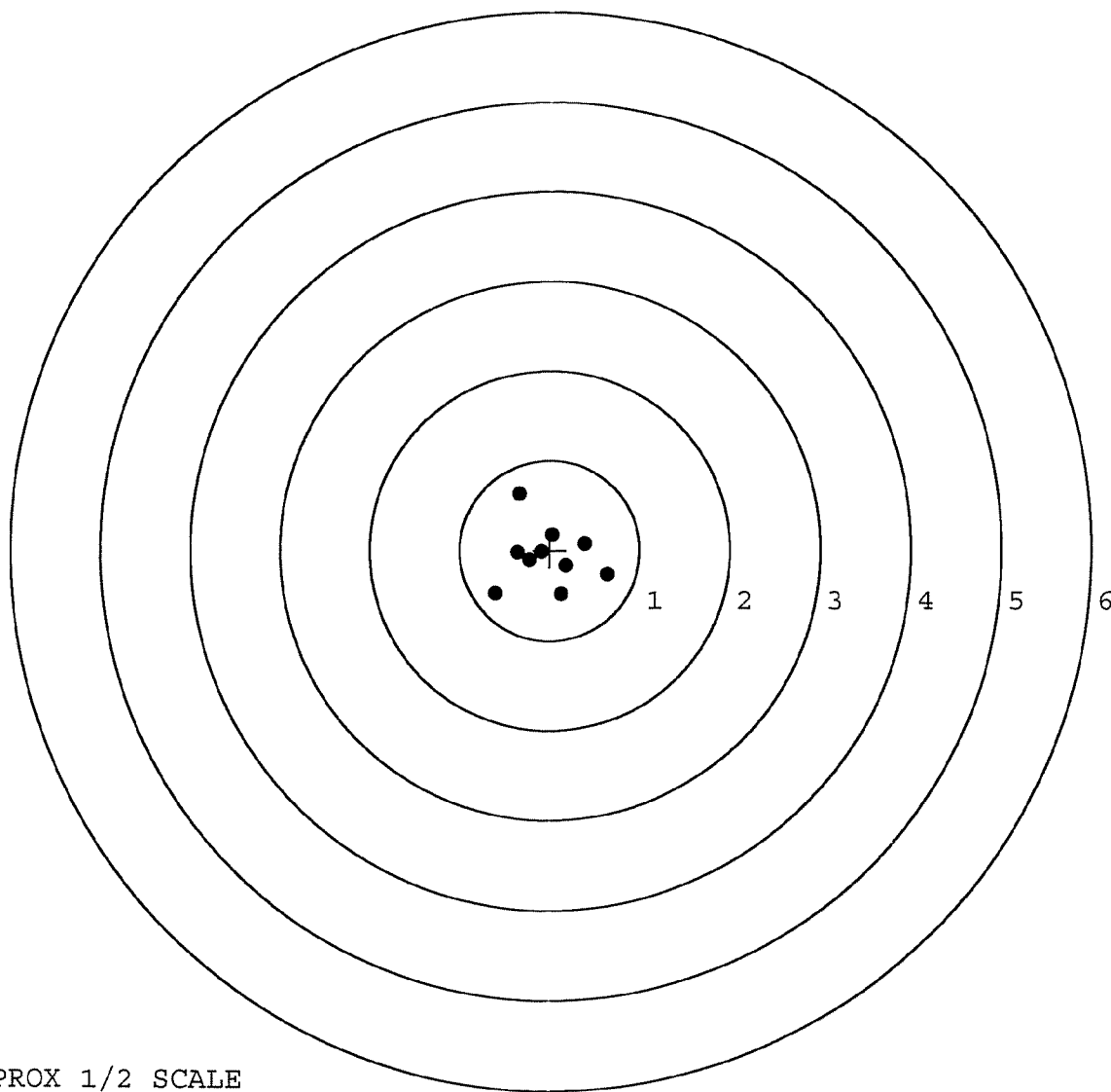
MAX RADIUS: 0.772

MEAN RADIUS: 0.417

IN 1 IN DIAMETER: 7

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10



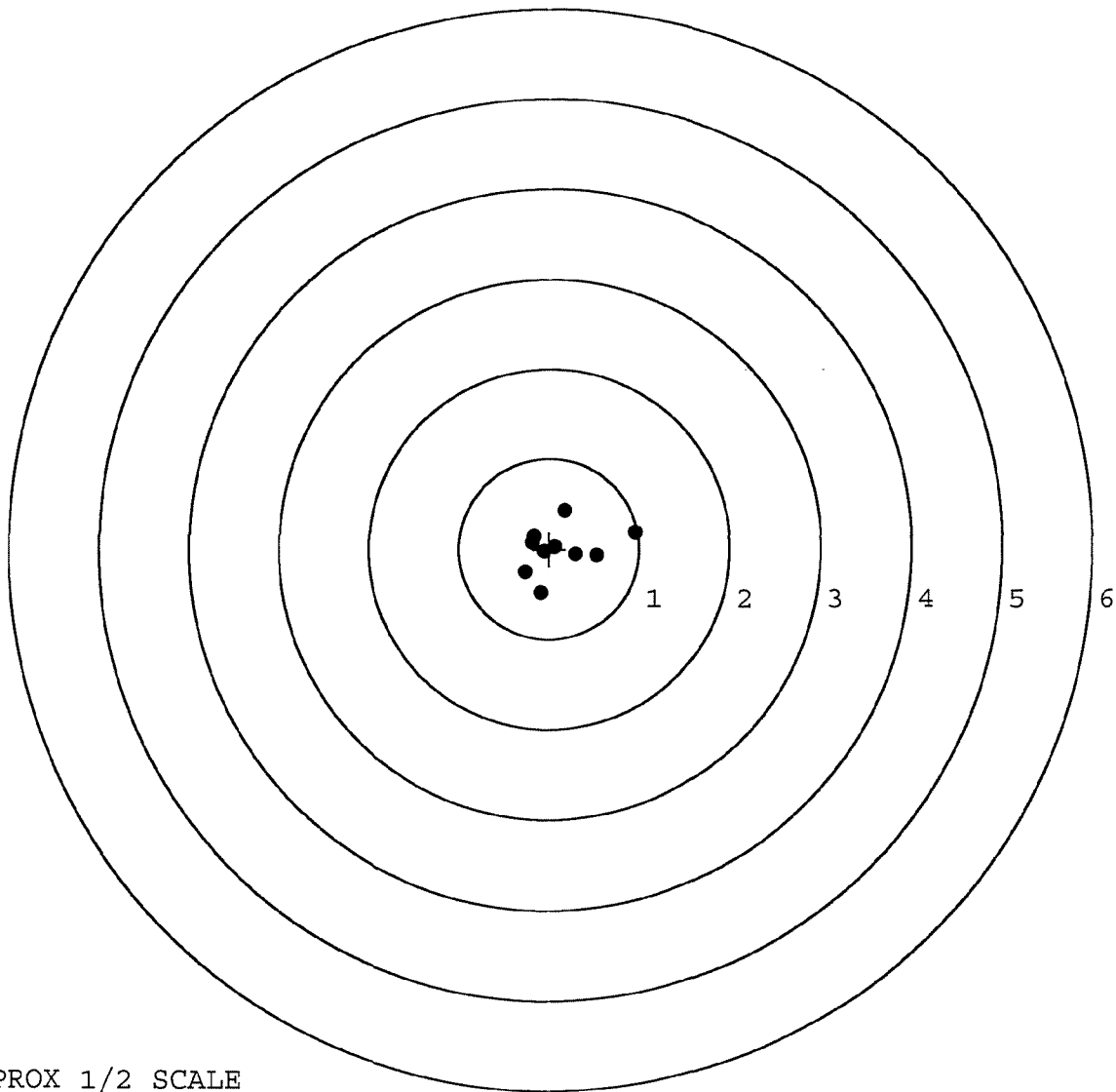
TARGET APPROX 1/2 SCALE

BARBER - M24 0062703

SERIAL NUMBER: C6348736. __0
 TARGET NUMBER: 5
 FILE DATE: 01/26/2004
 FILE TIME: 09:03

POINT#	X	Y
1:	0.959	0.182
2:	0.527	-0.077
3:	0.297	-0.066
4:	0.169	0.424
5:	-0.173	0.144
6:	-0.096	-0.493
7:	-0.270	-0.258
8:	-0.058	-0.028
9:	0.064	0.031
10:	-0.188	0.075

X CENTROID: 0.123
 Y CENTROID: -0.007
 POA TO CENTROID: 0.123
 HORZ SPREAD: 1.229
 VERT SPREAD: 0.917
 GROUP SPREAD: 1.305
 MIN RADIUS: 0.070
 MAX RADIUS: 0.857
 MEAN RADIUS: 0.379
 # IN 1 IN DIAMETER: 8
 # IN 2 IN DIAMETER: 10
 # in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

BARBER - M24 **M2400062743**

RECEIVING AND ESTIMATING REPORT

COMMENTS

ORDER

R 95-10942

INITIAL FJB	CUSTOMER ORDER NO.		W/10X SCOPE SNIPER W/DEPLOYMENT KIT ATTN: FRED MARTIN <i>Scope # 88-0380</i>		
DATE RECEIVED 03/30/95	DATE OPENED 03/31/95	DATE CODE EJ 10-89	SERIAL NUMBER C6348736	NEW SERIAL NUMBER	MODEL AND GRADE 700 7.42 NATO
ACCESSORIES SLING STRAP		SCOPE MNTS		SCOPE BASE	HARD CASE SOFT CASE

FROM: COMMANDER (W52H094138H226)
DEFENSE DIST DEPOT ANNISTON
ATTN DDAA-UR BLDG 112
ANNISTON AL 36201-5025

SHIP TO: COMMANDER (W52H094138H226)
DEFENSE DIST DEPOT ANNISTON
ATTN DDAA-UR BLDG 112
ANNISTON AL 36201-5025

CUST NO: 098397 C.O.D.L

ACCOUNT NUMBER	ACCOUNT NUMBER N/C	WRITE ☐	PROM. DATE	ESTIMATED <i>6-28-96</i> W/A UPS
GUN CONDITION			REPAIR CHARGE	
☐ NEW			EXCISE	
☐ LIGHTLY WORN			TAX	
☐ WORN			INSURANCE	
☐ VERY WORN			UPS	
☐ UNREPAIRABLE			PARCEL POST	
☐ MARRED			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	COMMENTS
<i>NEW BARREL</i> <i>Stock</i> <i>TRIGGER ASSY</i> <i>✓ FIRING PIN ASSY</i> <i>FRONT LENS COVER</i> <i>REAR LENS COVER</i>	
REPAIRMAN <i>KEP</i>	PROOF
GALLERY TESTER	DATE
CLEAN	DATE
TEST <i>A</i>	DATE <i>7/10/96</i>
TARGET <i>A</i>	DATE <i>7/10/96</i>
PATTERN	DATE

OFFICE COPY

RD6925 REV. 1/94

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6848736

DATE 6-22-96

TESTER WJA

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#	COMMENTS
PULL #1	2.53	2.23	2.37	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.52	2.24	2.35	
PULL #3	2.68	2.32	2.36	
PULL #4	2.72	2.27	2.38	
PULL #5	2.80	2.42	2.39	
TOTAL	13.25	11.48	11.85	
AVG.	2.65	2.29	2.37	

	3.00# INITIAL	3.00# AFTER 20 CYCLES	COMMENTS
PULL #1	3.24	3.27	
PULL #2	3.30	3.32	
PULL #3	3.23	3.30	
PULL #4	3.29	3.34	
PULL #5	3.31	3.35	
TOTAL	16.39	16.58	
AVG.	3.27	3.31	

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.18	3.85		4.03
PULL #2	4.10	3.85		4.00
PULL #3	4.00	3.90		4.04
PULL #4	4.00	3.86		4.01
PULL #5	4.04	3.88		4.02
TOTAL	20.32	19.34		20.10
AVG.	4.06	3.86		4.02

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

OP. #	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and Stock			
600	Proof			
607	Check Headspace			
610	Dis-assemble Gun			
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		6-27	REP
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		6-27	REP
	C) Inspect Ejector Hole for Chamfer		6-27	REP
	D) Oil Firing Pin Ass'y		6-27	REP
	E) Adjust Trigger Pull to Min Setting and Stake			

op. #	BARBER - M24 0062708 OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	7			6-27	REP
	G) Safety Off Force	4	3	4			6-27	REP
	H) Trigger Pull Test & Retainability							
	I) Firing Pin Indent	.021	.022	.022			6-27	REP
	J) Assemble Stock						6-27	REP
	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						6-27	REP
	P) Detach & Attach Scope 20 Times							
640	Gallery Target & Test							
	A) Time							
	B) Malfunctions							
	C) Pierced Primers							
	D) Optical Clarity of Scope							
645	Inspect for Live Ammo							
655	Final Inspection A) Headspace							
	B) Trigger Pull	2.76	2.70	2.68	2.58	2.68	7/12/96	RW
	C) Function							
660	Pack							

CENTROIDAL DISTANCES

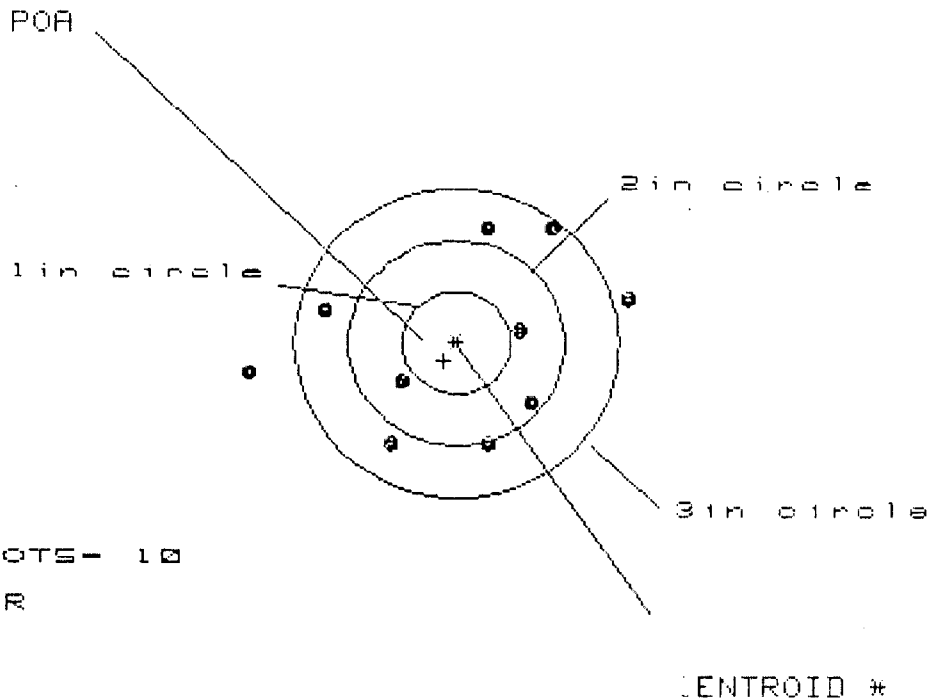
0	TO	1	.209404
1	TO	2	.628485
1	TO	3	.139032
1	TO	4	.456089
1	TO	5	.00707107

$\bar{x}_e$ <----POA

1 Jan 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C6348736

CENTERFIRE PATTERNS # 1



OF SHOTS - 10

IN CIR

1 in = 0

2 in = 4

3 in = 8

HS = 3.533

VS = 2.184

GS = 3.605

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.580	1.363	.834
MINIMUM X	-1.953	-1.422	-1.251
MAXIMUM Y	1.168	1.138	1.190
MINIMUM Y	-1.016	-1.046	-.994
CENTROID X	.115	.332	.161
CENTROID Y	.175	.205	.153
POA TO CENTROID in.	.209	.390	.222
MIN RADIUS	.577	.361	.539
MEAN RADIUS	1.170	1.057	1.007
MAX RADIUS	1.971	1.447	1.398
HORIZONTAL SPREAD	3.533	2.785	2.085
VERTICAL SPREAD	2.184	2.184	2.184
EXTREME SPREAD	3.605	2.789	2.562
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	8		

1 Jan 1900

FILE:/PATTERNING/CENTERFIRE_PATT/06348736

CENTERFIRE PATTERNS

2

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 1

2in = 4

3in = 6

HS= 3.451

VS= 2.613

GS= 3.500

PATTERN #

2

SHOTS (BEST OF)	:	10		8
MAXIMUM X	:	1.793	1.969	1.229
MINIMUM X	:	-1.658	-1.482	-1.236
MAXIMUM Y	:	1.336	1.194	1.138
MINIMUM Y	:	-1.277	-1.225	-1.281
CENTROID X	:	.578	.402	.156
CENTROID Y	:	-.250	-.108	-.051
POA TO CENTROID in.	:	.630	.416	.164
MIN RADIUS	:	.373	.386	.508
MEAN RADIUS	:	1.279	1.160	1.024
MAX RADIUS	:	2.035	2.020	1.447
HORIZONTAL SPREAD	:	3.451	3.451	2.465
VERTICAL SPREAD	:	2.613	2.419	2.419
EXTREME SPREAD	:	3.500	3.458	2.588
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		6	

1 Jan 1900

FILE:/PATTERNING/CENTERFIRE_PATT/C6348736

CENTERFIRE PATTERNS # 3

POA

1in circle

2in circle

3in circle

OF SHOTS - 10

IN CIR

1in = 0

2in = 3

3in = 7

HS = 2.398

VS = 3.209

GS = 3.731

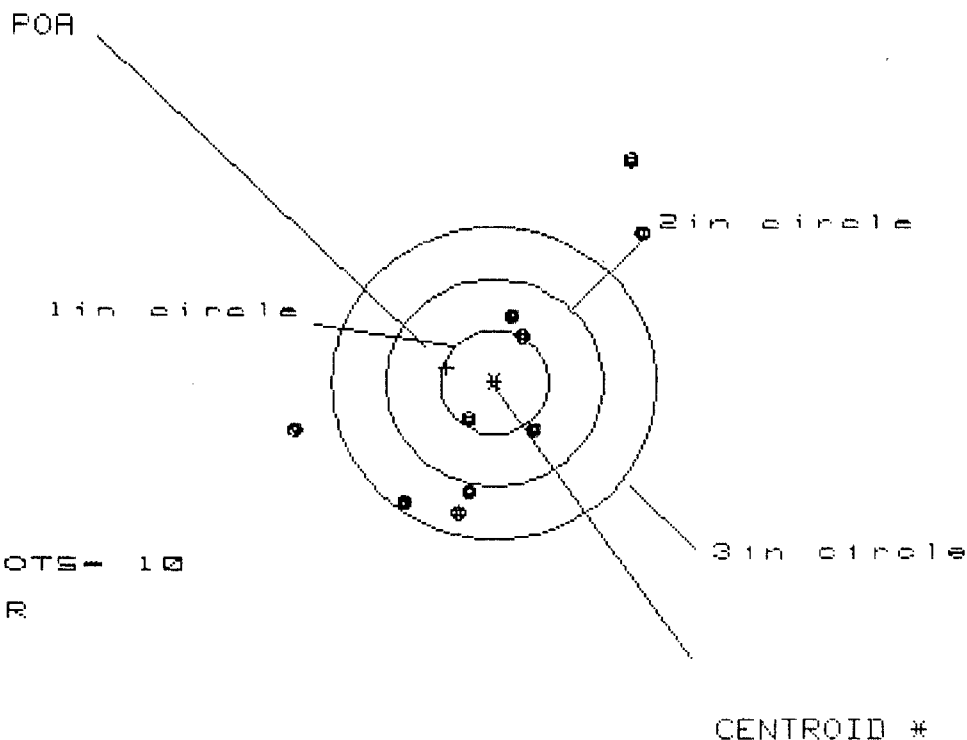
CENTROID #

PATTERN #	3	4	8
SHOTS (BEST OF)	10	5	8
MAXIMUM X	1.391	1.279	1.387
MINIMUM X	-1.007	-0.850	-0.742
MAXIMUM Y	1.153	.924	.699
MINIMUM Y	-2.056	-1.805	-1.177
CENTROID X	-.024	.088	-.020
CENTROID Y	.172	.401	.626
POA TO CENTROID in.	.174	.410	.627
MIN RADIUS	.512	.623	.469
MEAN RADIUS	1.216	1.067	.893
MAX RADIUS	2.298	2.004	1.393
HORIZONTAL SPREAD	2.398	2.129	2.129
VERTICAL SPREAD	3.209	2.729	1.876
EXTREME SPREAD	3.731	2.973	2.493
NUMBER IN ONE INCH CIRCLE =		0	
NUMBER IN TWO INCH CIRCLE =		3	
NUMBER IN THREE INCH CIRCLE =		7	

Jan 1900

FILE:/PATTERNING/CENTERFIRE_PATT/C6348736

CENTERFIRE PATTERNS # 4



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 4

3 in = 7

HS = 3.220

VS = 3.440

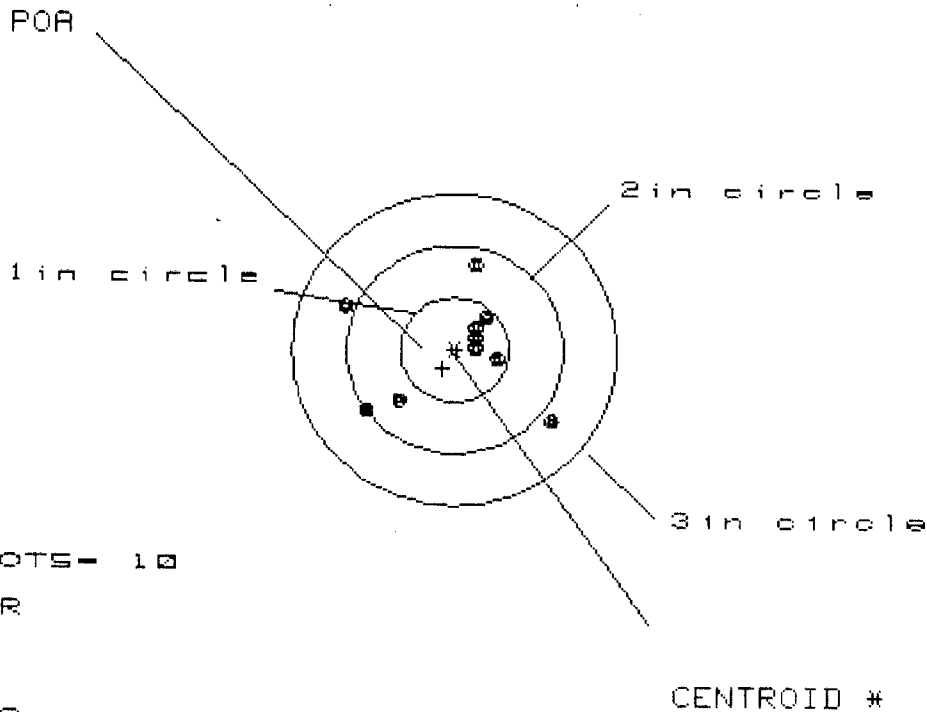
GS = 4.003

PATTERN #	:	4	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.409	1.544	.671
MINIMUM X	:	-1.812	-1.676	-1.483
MAXIMUM Y	:	2.189	1.738	1.082
MINIMUM Y	:	-1.251	-1.008	-.790
CENTROID X	:	.439	.304	.111
CENTROID Y	:	-.146	-.389	-.607
POA TO CENTROID in.	:	.463	.494	.617
MIN RADIUS	:	.468	.196	.098
MEAN RADIUS	:	1.237	1.044	.845
MAX RADIUS	:	2.504	2.325	1.484
HORIZONTAL SPREAD	:	3.220	3.220	2.154
VERTICAL SPREAD	:	3.440	2.746	1.872
EXTREME SPREAD	:	4.003	3.752	2.264
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	4		
NUMBER IN THREE INCH CIRCLE	=	7		

1 Jan 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C6348738

CENTERFIRE PATTERNS # 5



OF SHOTS - 10

IN CIR

1 in - 5

2 in - 8

3 in - 10

HS - 1.964

VS - 1.491

GS - 2.249

PATTERN #	:	5	8	10
SHOTS (BEST OF)	:	10	8	10
MAXIMUM X	:	.922	.409	.922
MINIMUM X	:	-1.042	-.789	-1.042
MAXIMUM Y	:	.787	.748	.787
MINIMUM Y	:	-.704	-.627	-.704
CENTROID X	:	.110	.125	.110
CENTROID Y	:	.180	.219	.180
POA TO CENTROID in.	:	.211	.252	.211
MIN RADIUS	:	.176	.164	.176
MEAN RADIUS	:	.630	.491	.630
MAX RADIUS	:	1.160	1.008	1.160
HORIZONTAL SPREAD	:	1.964	1.198	1.964
VERTICAL SPREAD	:	1.491	1.375	1.491
EXTREME SPREAD	:	2.249	1.653	2.249
NUMBER IN ONE INCH CIRCLE	=	5		5
NUMBER IN TWO INCH CIRCLE	=	8		8
NUMBER IN THREE INCH CIRCLE	=	10		10

GUN SERIAL # C6348736

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		10-9 89	RW
600	Proof		10-9 89	AC
607	Check Headspace		10-9 89	RW
610	Dis-assemble Gun			RW
612	Magnaflux Barrel Action		11/2/89	KCR
	Magnaflux Bolt		11/2/89	KCR
615	Rollmark Caliber		11/2/89	C.S.
7	Drill and Tap Sight Holes			
618	Polish Barrel			
620	Apply Coatings (Barrel Action)		11-3-89	TJA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		11/6/89	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		11/6/89	RW
	C) Inspect Ejector Hole for Chamfer		11/6/89	RW
	D) Oil Firing Pin Ass'y		11/6/89	RW
	E) Adjust Trigger Pull to Min Setting and Stake		8/20/89	928

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			11-8-89	JK
	G) Safety Off Force	3	3	3			11-8-89	JK
	H) Trigger Pull Test & Retainability						8/NOV/89	JD
	I) Firing Pin Indent	.0215	.021	.021			11-8-89	JK
	J) Assemble Stock						11/9/89	JK
	K) Assemble Swivel Studs						14/NOV/89	JD
	L) Attach Front and Rear Sight Assemblies						11/9/89	JK
	M) Iron Sight Alignment						11/9/89	JK
	N) Detach Front & Rear Sights & place in numbered container						11/9/89	JK
	O) Attach Scope to Rifle						11-9/89	JK
	P) Detach & Attach Scope 20 Times						11-9/89	JK
640	Gallery Target & Test						11-13-89	D/H
	A) Time						11-13-89	D/H
	B) Malfunctions						11-13-89	D/H
	C) Pierced Primers						11-13-89	D/H
	D) Optical Clarity of Scope						11-13-89	D/H
645	Inspect for Live Ammo						11-13-89	D/H
655	Final Inspection						14/NOV/89	JD
	A) Headspace						14/NOV/89	JD
	B) Trigger Pull	240	223	258	249	233	14/NOV/89	JD
	C) Function						14/NOV/89	JD
660	Pack						15/NOV/89	JD

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. 06348736

DATE 2-7-90

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.38	2.43	2.35		MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.43	2.42	2.40		
PULL #3	2.35	2.42	2.42		
PULL #4	2.46	2.43	2.44		
PULL #5	2.40	2.40	2.30		
TOTAL	12.02	12.10	11.91		
AVG.	2.404	2.42	2.382		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.26	3.29		
PULL #2	3.27	3.34		
PULL #3	3.30	3.36		
PULL #4	3.15	3.30		
PULL #5	3.28	3.34		
TOTAL	16.26	16.63		
AVG.	3.252	3.326		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.41	4.33		4.37
PULL #2	4.40	4.37		4.39
PULL #3	4.38	4.38		4.38
PULL #4	4.38	4.26		4.35
PULL #5	4.38	4.12		4.17
TOTAL	21.95	21.46		21.66
AVG.	4.39	4.292		4.332

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06348736
13 Nov 1989

CENTROIDAL DISTANCES

0 TO	1	.472001
1 TO	2	.750051
1 TO	3	.954116
1 TO	4	.592156
1 TO	5	.891242

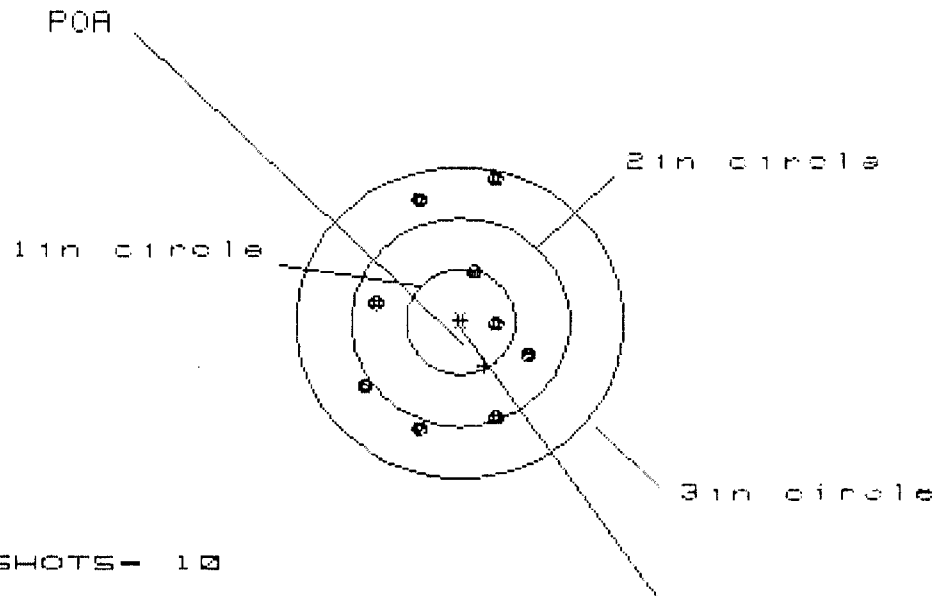
$\frac{1}{4} + \frac{2}{5}$ (----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0836
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0548
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .09996
THE AMR FOR THIS RIFLE IS: .9976

13 Nov 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C634B736

CENTERFIRE PATTERNS # 1



OF SHOTS - 10

IN CIR

1in = 2

2in = 5

3in = 10

HS = 1.516

VS = 2.384

GS = 2.484

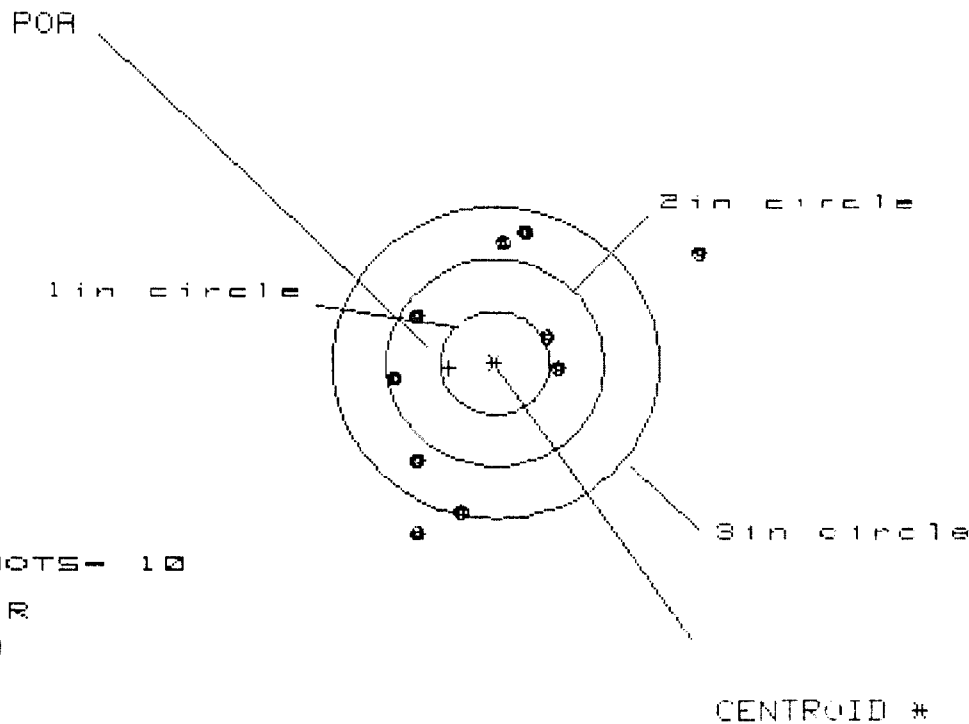
CENTROID *

PATTERN #	:	1	2	3
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.655	.695	.652
MINIMUM X	:	-.861	-.821	-.864
MAXIMUM Y	:	1.396	1.315	.765
MINIMUM Y	:	-.988	-.833	-.669
CENTROID X	:	-.223	-.263	-.220
CENTROID Y	:	.416	.261	.097
POA TO CENTROID in.	:	.472	.370	.240
MIN RADIUS	:	.315	.361	.401
MEAN RADIUS	:	.879	.808	.722
MAX RADIUS	:	1.441	1.359	.974
HORIZONTAL SPREAD	:	1.516	1.516	1.516
VERTICAL SPREAD	:	2.384	2.148	1.434
EXTREME SPREAD	:	2.484	2.175	1.574
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	

13 May 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C6348736

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 0

2 in = 4

3 in = 8

HS= 2.775

VS= 2.912

GS= 3.702

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.892	.734	.671
MINIMUM X	:	-.883	-.673	-.736
MAXIMUM Y	:	1.308	1.422	1.236
MINIMUM Y	:	-1.604	-1.490	-1.525
CENTROID X	:	.426	.216	.278
CENTROID Y	:	.040	-.074	.112
POA TO CENTROID in.	:	.428	.228	.300
MIN RADIUS	:	.525	.673	.640
MEAN RADIUS	:	1.177	1.061	.974
MAX RADIUS	:	2.153	1.573	1.531
HORIZONTAL SPREAD	:	2.775	1.407	1.407
VERTICAL SPREAD	:	2.912	2.912	2.761
EXTREME SPREAD	:	3.702	3.083	2.823
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	

13 Nov 1989

FILE:/PATTERNING/CENTERFIRE_PATT/06348736

CENTERFIRE PATTERNS # 3

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS - 10

IN CIR

1 in = 0

2 in = 3

3 in = 9

HS = 2.554

VS = 2.721

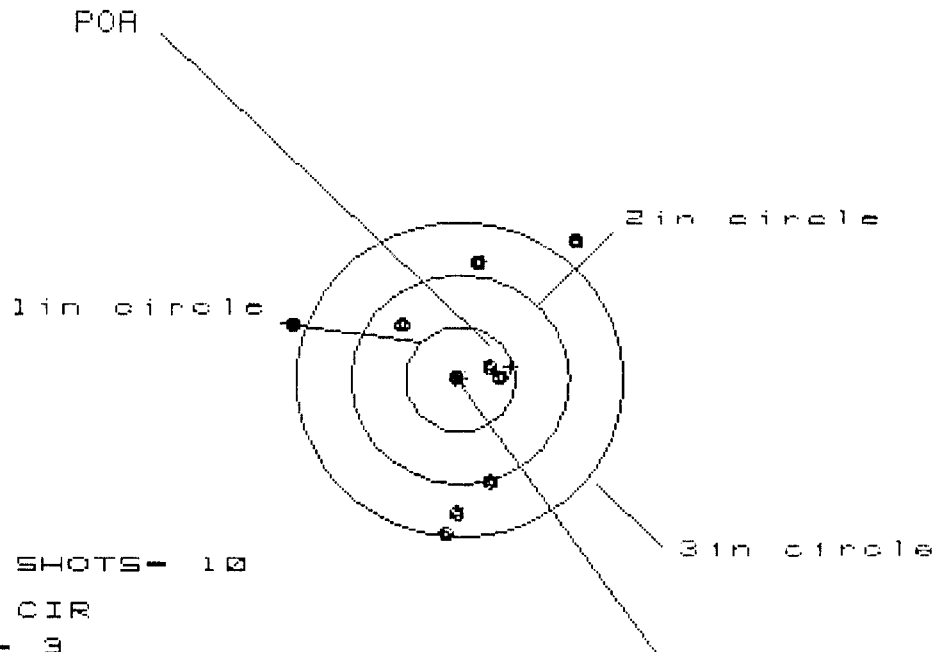
GS = 2.919

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.397	1.452	1.410
MINIMUM X	:	-1.157	-1.102	-1.921
MAXIMUM Y	:	1.229	1.063	1.000
MINIMUM Y	:	-1.492	-0.988	-1.051
CENTROID X	:	.258	.203	.022
CENTROID Y	:	-.408	-.242	-.179
POA TO CENTROID in.	:	.482	.316	.180
MIN RADIUS	:	.585	.532	.680
MEAN RADIUS	:	1.161	1.099	1.022
MAX RADIUS	:	1.570	1.537	1.419
HORIZONTAL SPREAD	:	2.554	2.554	2.331
VERTICAL SPREAD	:	2.721	2.051	2.051
EXTREME SPREAD	:	2.919	2.777	2.359
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		9	

13 May 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C6348736

CENTERFIRE PATTERNS # 4



OF SHOTS - 10

IN CIR

1 in = 3

2 in = 4

3 in = 8

HS = 2.582

VS = 2.792

GS = 3.026

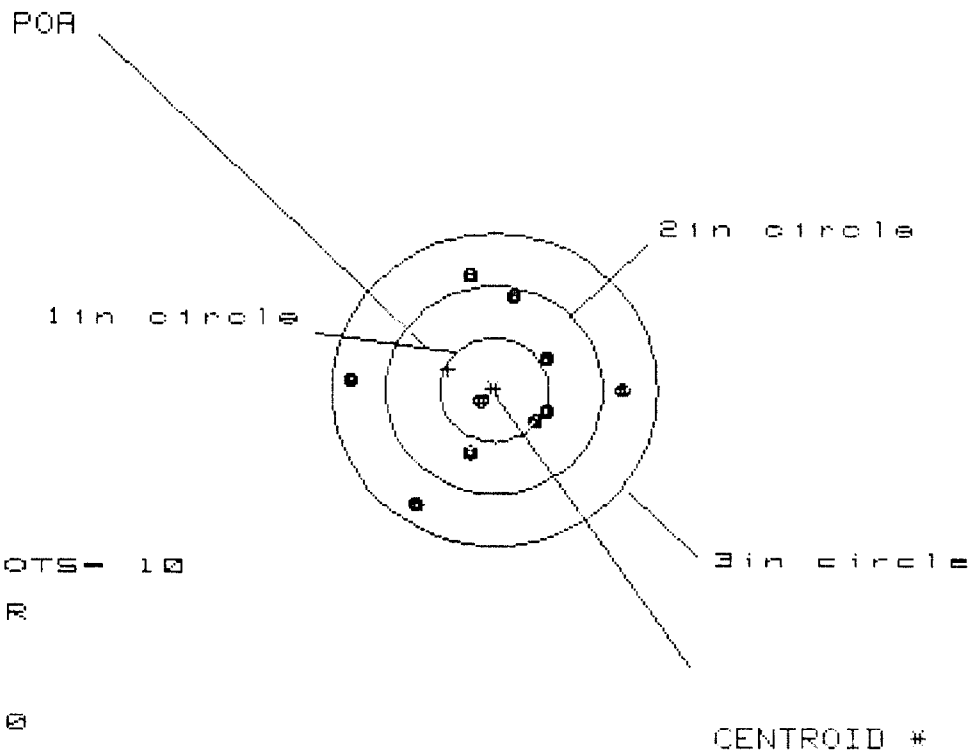
CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.048	.523	.346
MINIMUM X	:	-1.534	-1.417	-.567
MAXIMUM Y	:	1.358	1.231	1.319
MINIMUM Y	:	-1.434	-1.283	-1.195
CENTROID X	:	-.466	-.583	-.406
CENTROID Y	:	-.124	-.275	-.363
POA TO CENTROID in.	:	.483	.644	.544
MIN RADIUS	:	.048	.236	.289
MEAN RADIUS	:	.964	.911	.804
MAX RADIUS	:	1.716	1.581	1.321
HORIZONTAL SPREAD	:	2.582	1.940	.913
VERTICAL SPREAD	:	2.792	2.514	2.514
EXTREME SPREAD	:	3.026	2.527	2.527
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	

13 Nov 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C634B736

CENTERFIRE PATTERNS # 5



OF SHOTS - 10

IN CIR

1 in = 2

2 in = 6

3 in = 10

HS = 2.431

VS = 2.221

GS = 2.433

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.145	1.062	.891
MINIMUM X	:	-1.286	-1.369	-.525
MAXIMUM Y	:	1.089	.963	.957
MINIMUM Y	:	-1.133	-.683	-.689
CENTROID X	:	.423	.506	.677
CENTROID Y	:	-.198	-.073	-.067
POA TO CENTROID in.	:	.468	.511	.680
MIN RADIUS	:	.138	.288	.251
MEAN RADIUS	:	.807	.744	.639
MAX RADIUS	:	1.355	1.370	1.081
HORIZONTAL SPREAD	:	2.431	2.431	1.416
VERTICAL SPREAD	:	2.221	1.646	1.646
EXTREME SPREAD	:	2.433	2.433	1.782
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	

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safe use of this
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