

128

C649886Z

MODEL 700™ M24

Model **SWS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

M2400009118

128

C6498862

	
RECORDS CONTROL SCHEDULE	
RECORDS CATEGORY OR TITLE: [REDACTED]	
COPY "O" (OFFICIAL) ☐ "X" (EXTRA) ☒	
TOTAL RETENTION: [REDACTED]	
GS-11050 Rev. 8/78	

Repair Inquiry

Repair Number: RE00128539

Serial: C6498862 Model M24 SWS Center Fire
Caliber: 7.62 NATO

Repairman:

Verify Repair

Status:

New 4/24/2007 7:58:15 AM

Address Information

Customer:

Received From

Return To:

Received From

Name: ISSD ARMSROOM

ISSD ARMSROOM

Address 1: 8TH DESERT STORM

8TH DESERT STORM

Address 2: BLDG 5210 BAY DOOR #30

PO Box:

BLDG 5210 BAY DOOR #30

PO Box:

City: FORT CAMPBELL

FORT CAMPBELL

State: KY

Zip Code: 42223

Country: US

State: KY

Zip Code: 42223

Country: US

FFL:

Contact / Condition

Problems

Estimate

History / Status

Shipping / Billing

Contact Information

Phone: NN

Fax:

Email:

Comments:

Received Condition

Fair

Condition
Notes:CSR
Notes:

Accessories Received

Code	Desc	Qty
A007	With Stud	3
A010	Hard Case	1
A057	Fit and Rear Sgt Base	1

Repair Search

Refresh

Close

naglelj

4/24/2007

8:10 AM

CAPS

NUM

INS

SCRL

start

3 Mi...

5 In...

Arms ...

Part ...

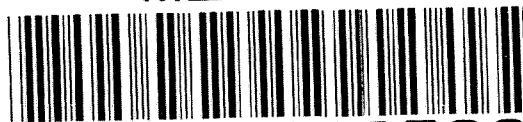
6 Mi...

2 W...

8:10 AM

Serial Number: C6498862

Model: M24 SWS



RE00128539

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6498862. __0

FILE DATE AND TIME: 05/31/2007 01:06

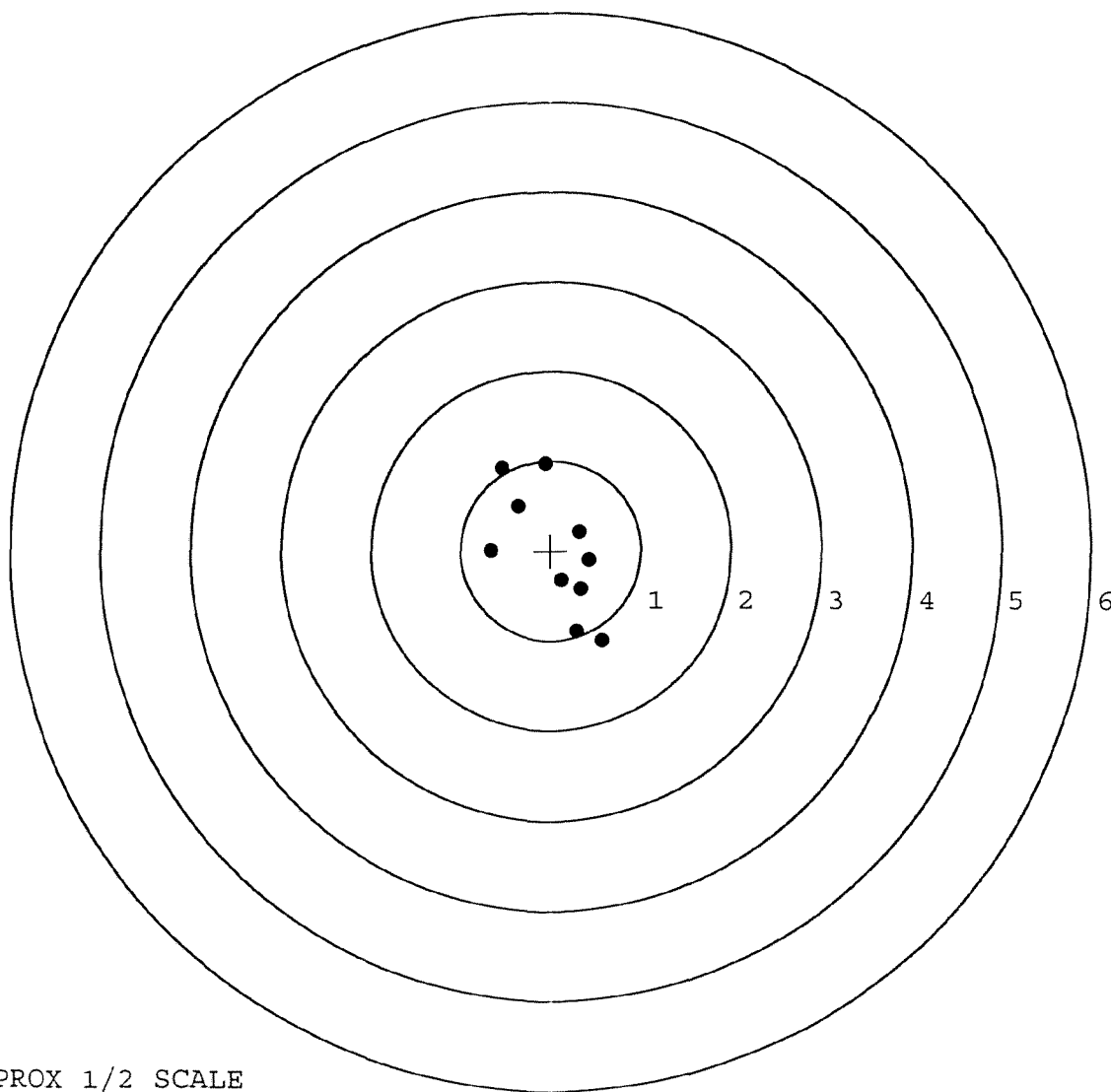
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.031
The Average Y Centroid of the Five Target Set:	-0.054
The Average Point of Impact of the Five Target Set:	0.062
The Average Mean Radius of the Five Target Set:	0.662
The Distance from POA to Centroid Target #1:	0.047
The Distance from Centroid Target #2 to Centroid Target #1:	0.121
The Distance from Centroid Target #3 to Centroid Target #1:	0.259
The Distance from Centroid Target #4 to Centroid Target #1:	0.222
The Distance from Centroid Target #5 to Centroid Target #1:	0.045

SERIAL NUMBER: C6498862. __0
TARGET NUMBER: 1
FILE DATE: 05/31/2007
FILE TIME: 01:06

POINT#	X	Y
1:	-0.066	0.968
2:	-0.546	0.907
3:	-0.366	0.493
4:	-0.673	-0.010
5:	0.318	0.210
6:	0.428	-0.107
7:	0.126	-0.330
8:	0.338	-0.427
9:	0.287	-0.905
10:	0.573	-1.008

X CENTROID: 0.042
Y CENTROID: -0.021
POA TO CENTROID: 0.047
HORZ SPREAD: 1.246
VERT SPREAD: 1.976
GROUP SPREAD: 2.218
MIN RADIUS: 0.320
MAX RADIUS: 1.121
MEAN RADIUS: 0.708
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10



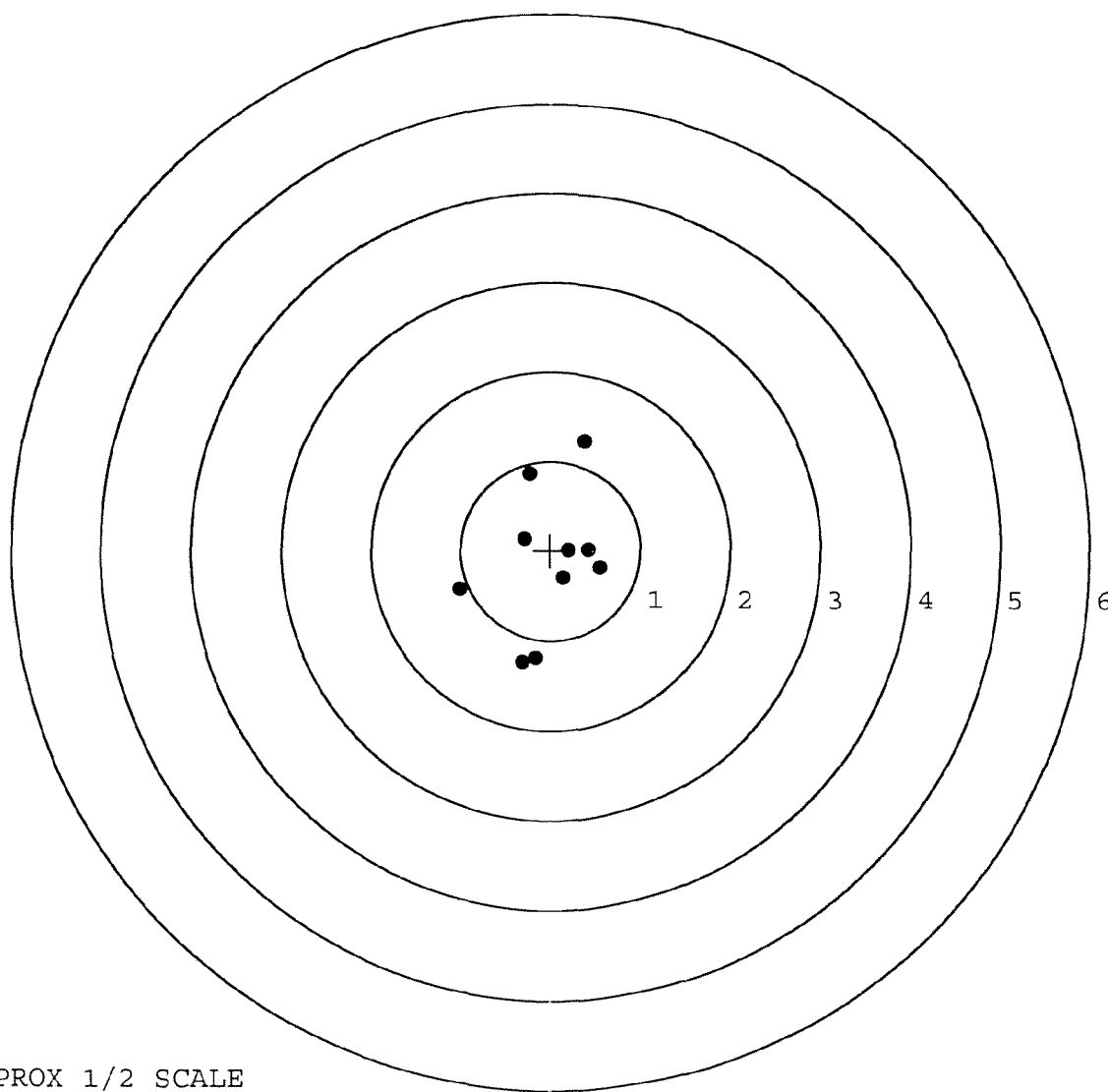
TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6498862. __0
TARGET NUMBER: 2
FILE DATE: 05/31/2007
FILE TIME: 01:06

X CENTROID: -0.031
Y CENTROID: -0.117
POA TO CENTROID: 0.121
HORZ SPREAD: 1.560
VERT SPREAD: 2.471
GROUP SPREAD: 2.563
MIN RADIUS: 0.259
MAX RADIUS: 1.402
MEAN RADIUS: 0.761

POINT#	X	Y
1:	-0.229	0.861
2:	0.374	1.225
3:	-1.010	-0.445
4:	-0.307	-1.246
5:	-0.165	-1.196
6:	0.142	-0.311
7:	0.203	-0.005
8:	0.421	0.012
9:	0.550	-0.196
10:	-0.288	0.130

IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 6
in 3 IN DIAMETER: 10

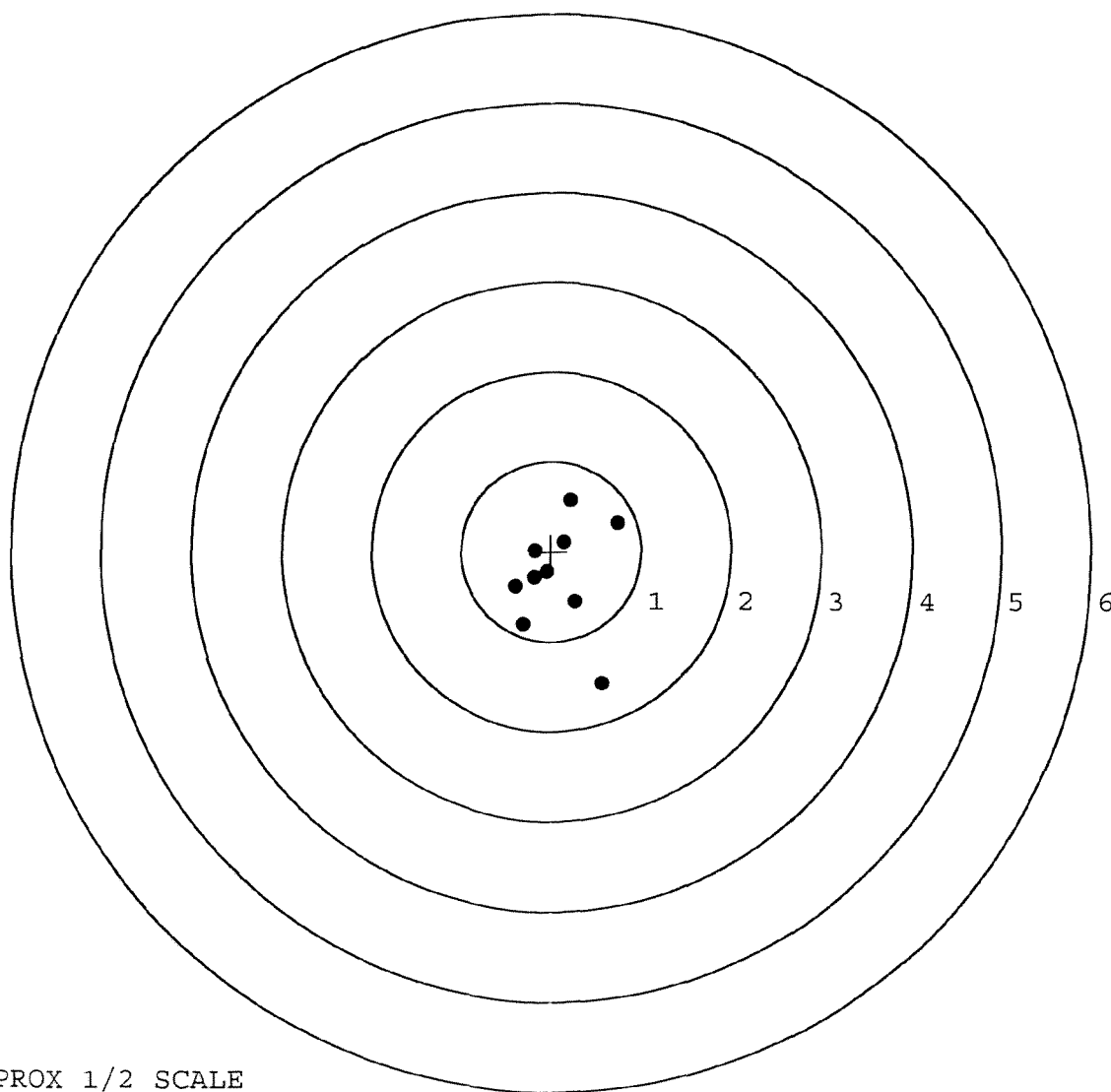


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6498862. 0
TARGET NUMBER: 3
FILE DATE: 05/31/2007
FILE TIME: 01:06

POINT#	X	Y
1:	0.217	0.561
2:	0.145	0.104
3:	0.734	0.320
4:	-0.186	0.007
5:	-0.051	-0.231
6:	-0.396	-0.387
7:	0.271	-0.563
8:	-0.315	-0.809
9:	0.568	-1.477
10:	-0.189	-0.293

X CENTROID: 0.080
Y CENTROID: -0.277
POA TO CENTROID: 0.288
HORZ SPREAD: 1.130
VERT SPREAD: 2.038
GROUP SPREAD: 2.068
MIN RADIUS: 0.139
MAX RADIUS: 1.296
MEAN RADIUS: 0.571
IN 1 IN DIAMETER: 6
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

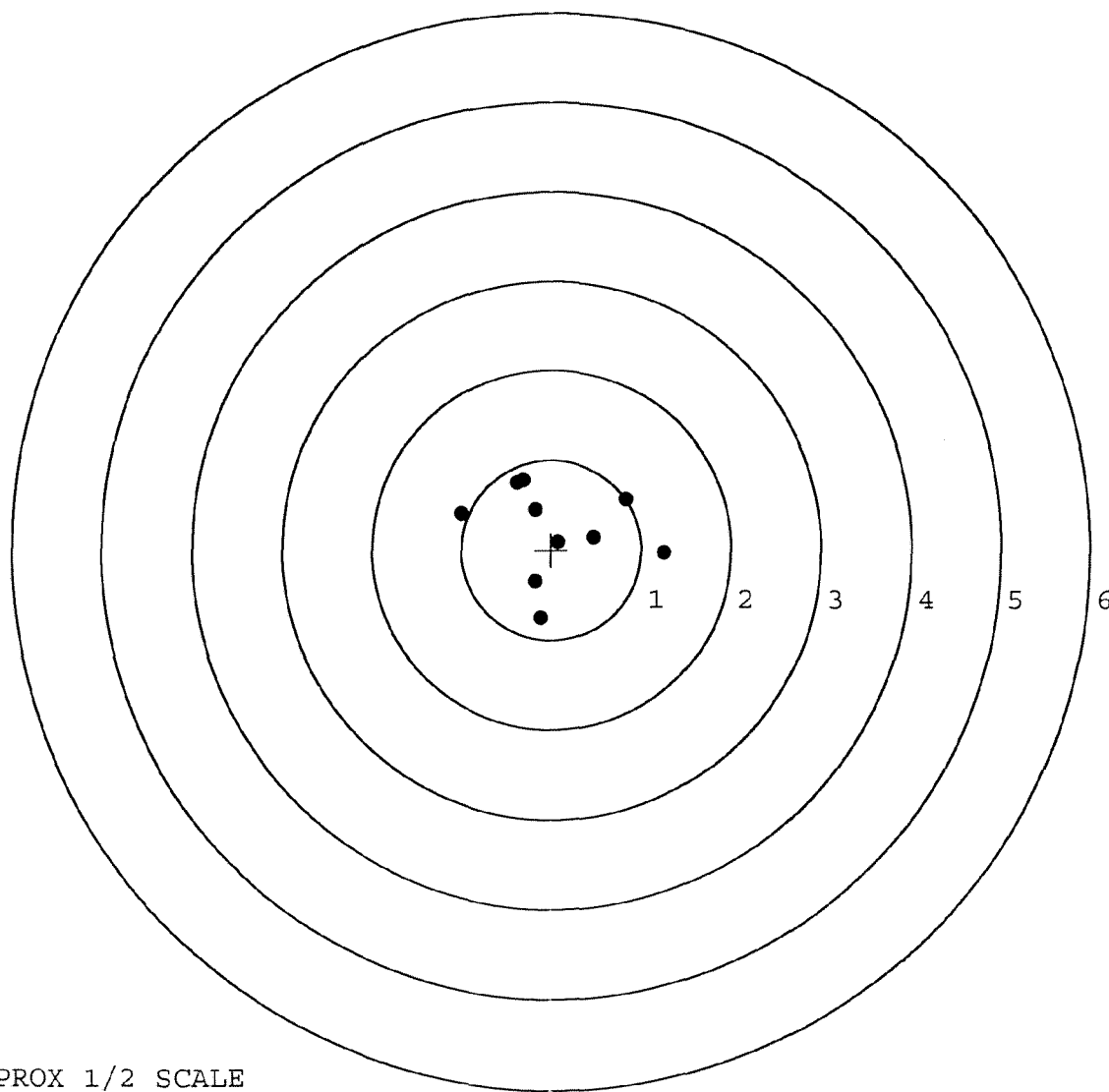


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6498862. 0
TARGET NUMBER: 4
FILE DATE: 05/31/2007
FILE TIME: 01:06

POINT#	X	Y
1:	-0.378	0.753
2:	-0.177	0.447
3:	0.079	0.089
4:	0.472	0.142
5:	0.829	0.566
6:	1.256	-0.037
7:	-0.176	-0.354
8:	-0.115	-0.766
9:	-1.002	0.398
10:	-0.307	0.774

X CENTROID: 0.048
Y CENTROID: 0.201
POA TO CENTROID: 0.207
HORZ SPREAD: 2.258
VERT SPREAD: 1.540
GROUP SPREAD: 2.300
MIN RADIUS: 0.116
MAX RADIUS: 1.231
MEAN RADIUS: 0.699
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10

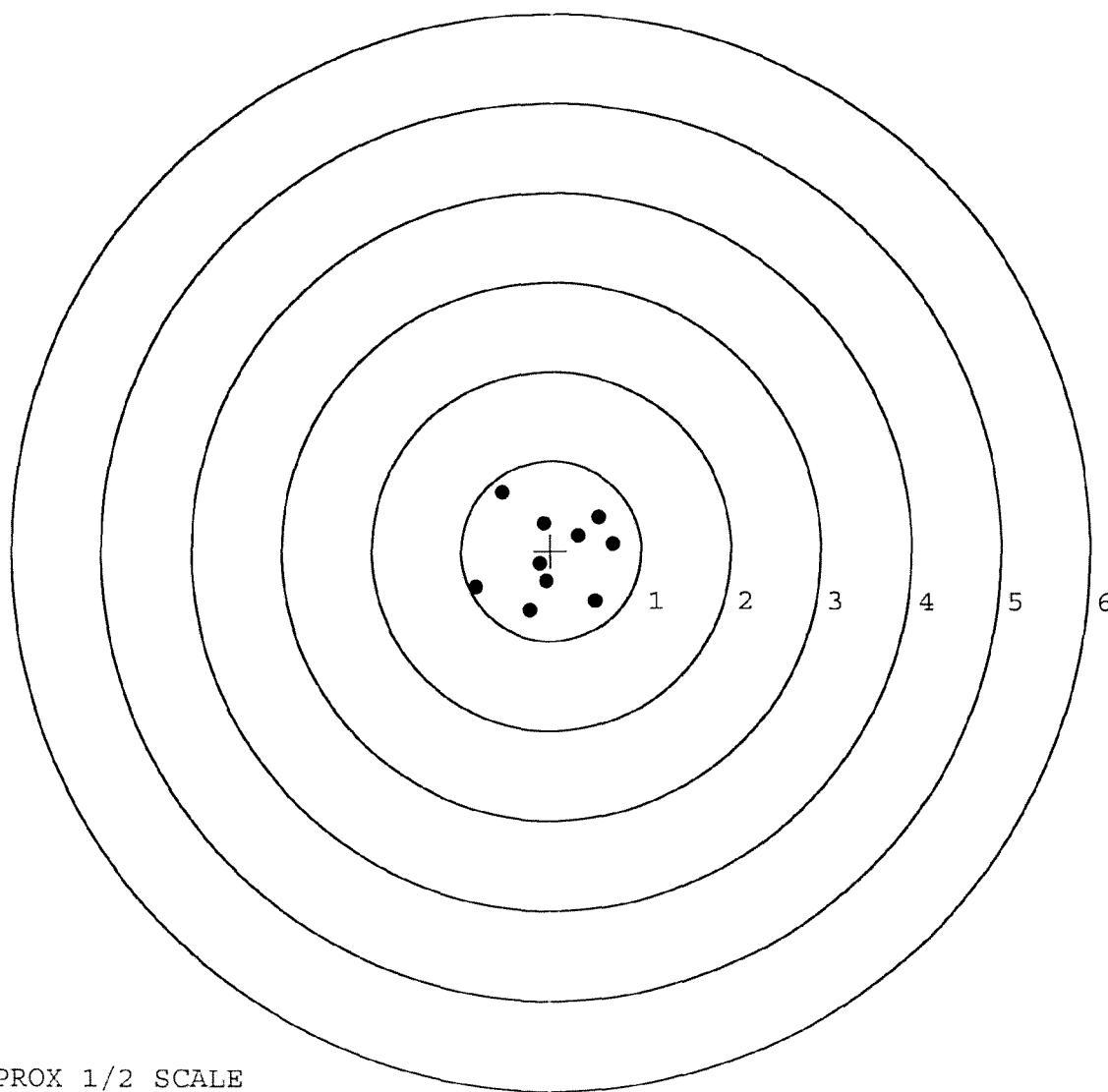


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6498862. 0
TARGET NUMBER: 5
FILE DATE: 05/31/2007
FILE TIME: 01:06

POINT#	X	Y
1:	-0.544	0.644
2:	-0.836	-0.410
3:	-0.236	-0.663
4:	0.498	-0.563
5:	-0.049	-0.346
6:	-0.122	-0.141
7:	-0.084	0.301
8:	0.301	0.162
9:	0.527	0.372
10:	0.684	0.081

X CENTROID: 0.014
Y CENTROID: -0.056
POA TO CENTROID: 0.058
HORZ SPREAD: 1.520
VERT SPREAD: 1.307
GROUP SPREAD: 1.597
MIN RADIUS: 0.160
MAX RADIUS: 0.921
MEAN RADIUS: 0.571
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 10
in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

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

R & E NUMBER		128539	
SERIAL NUMBER		C6498862	
LOG-IN DATE		128539	

OPERATION #	OPERATION NAME	DATE	INITIAL
500	DIS-ASSEMBLE GUN	5-16-07	RTZ
505	RE-BARREL	5-18-07	RTZ
560	ASSEMBLE	5-18-07	RTZ
600	PROOF	5-18-07	TRW
605	CHECK HEADSPACE	5-18-07	TRW
610	DIS-ASSEMBLE GUN	5-21-07	RTZ
612	MAGNAFLUX	5-21-07	mmw
510	DRILL AND TAP	5-21-07	TRW
615	ROLLMARK CALIBER	5-21-07	CW
618	ROTO-BLAST	5-22-07	LB
620	APPLY COATINGS	5-24-07	CW
625	FINAL ASSEMBLY	5-30-07	RTZ
640	FUNCTION TEST AND	5-30-07	TRW
650	TARGET	5-30-07	TRW
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
670	FINAL INSPECTION	6-8-07	RTZ
	A) HEADSPACE	6-8-07	RTZ
	B) TRIGGER PULL	2.73 2.74 2.65 2.79 2.84	6-1-07 RA
680	F) SAFETY ON FORCE	4.2 4.2 4.2	6-1-07 RA
	G) SAFETY OFF FORCE	3.5 3.5 3.5	6-1-07 RA
	I) FIRING PIN INDENT	.021 .023 .023	6-1-07 RA
690	PACK	6-8-07	RA

MAINTENANCE REQUEST		PAGE NO.	NO. OF PAGES	REQUIREMENTS CONTROL SYMBOL
For use of this form, see DA PAM 738-750; the proponent agency is DCSLOG		1	1	CSGLD - 1047(R1)
SECTION I - EQUIPMENT DATA				
CONTROL NUMBER		WORK ORDER NO.	WESDC	ORG. PD
1A. ORGANIZATION		B. LOCATION		C. UNIT IDENT CODE
2. SERIAL NO.		3. NOUN NOMENCLATURE	4. LINE NO.	5. MODEL
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)		
16A. DESCRIBE DEFICIENCIES OR SYMPTOMS ON THE BASIS OF COMPLETE CHECKOUT AND DIAGNOSTIC PROCEDURE IN EQUIPMENT TM (Do not prescribe repairs).				
B. REMARKS				
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		24. RECEIVED BY		
JULIAN DATE		JULIAN DATE		

COMMENTS

R ORDER
95-30907

W/LEUPOLD 10X SCOPE

SCOPE 89-0987

FROM: _____ SHIP TO: _____

TRANSPORTATION OFFICE
FT CAMPBELL KY
42223

CUST NO: 087942 C.O.D

WRITE _____

PROM. DATE	ESTIMATED	VIA UPS
------------	-----------	------------

REPAIR CHARGE
EXCISE
TAX
INSURANCE
UPS
PARCEL POST
TOTAL

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

COMMENTS

Repowerlter Cast Trigger Guard
Assy & Front Sight Base
Reding Scope Base, Rings
& Swivel Studs

Scope Sent back to Vendor
to be Checked

REPAIRMAN <i>RW</i>	PROOF <i>L</i>	CLEAN <i>L</i>	TEST <i>L</i>	TARGET <i>L</i>	PATTERN
GALLERY TESTER <i>RW</i>	DATE <i>12/4/95</i>	DATE <i>1/5/96</i>	DATE <i>1/8/96</i>	DATE <i>1/8/96</i>	DATE

FOEDER REV. 1/89

OFFICE COPY

FD-302 (REV. 1-25-64)

M2400009129

Final Inspection

Sn: C6498862

DATE REC'D: 12/04/95

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: _____

CONTRACT # DAAA21-87-C-0086

New Barre /

GUN SERIAL # C 6498862

OP. #	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and Stock		12/21/95	RW
600	Proof		12/21/95	RW
607	Check Headspace		12/21/95	RW
610	Dis-assemble Gun		12/21/95	RW
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		1/5/96	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		1/5/96	RW
	C) Inspect Ejector Hole for Chamfer		1/5/96	RW
	D) Oil Firing Pin Ass'y		1/5/96	RW
	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						1/8/96	RW
	A) Time							
	B) Malfunctions							
	C) Pierced Primers							
	D) Optical Clarity of Scope							
645	Inspect for Live Ammo						1/8/96	RW
655	Final Inspection							
	A) Headspace						1/10/96	RW
	B) Trigger Pull	2.78	2.74	2.84	2.81	2.80	1/10/96	RW
	C) Function						1/10/96	RW
660	Pack							

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06498862
7 Jan 1980

CENTROIDAL DISTANCES

0 TO	1	1.04456
1 TO	2	.523749
1 TO	3	.776192
1 TO	4	.844344
1 TO	5	.249634

4
2
3 5 1

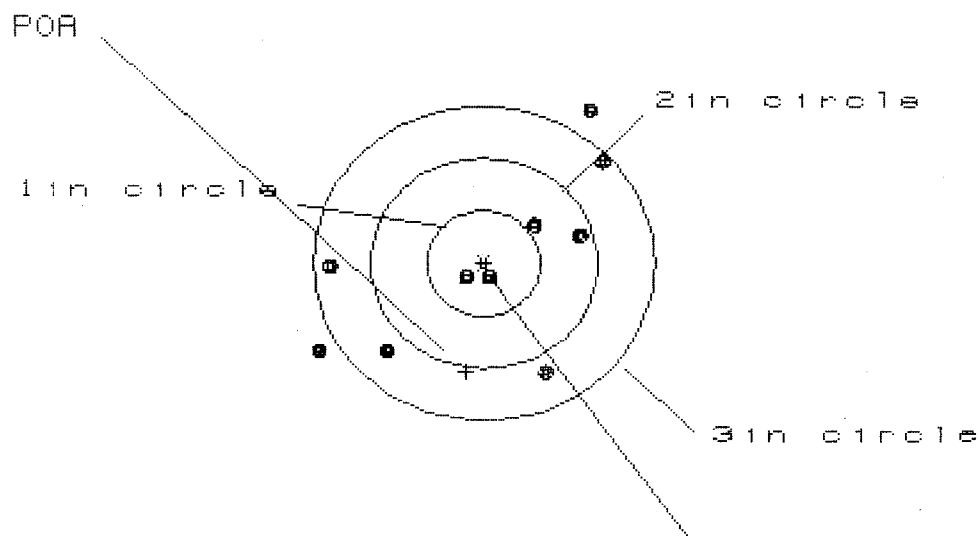
+ -----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1496
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: 1.3108
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: 1.31931
THE AMR FOR THIS RIFLE IS: 1.211

7 Jan 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C6496862

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 2

2in = 4

3in = 8

HS= 2.505

VS= 2.521

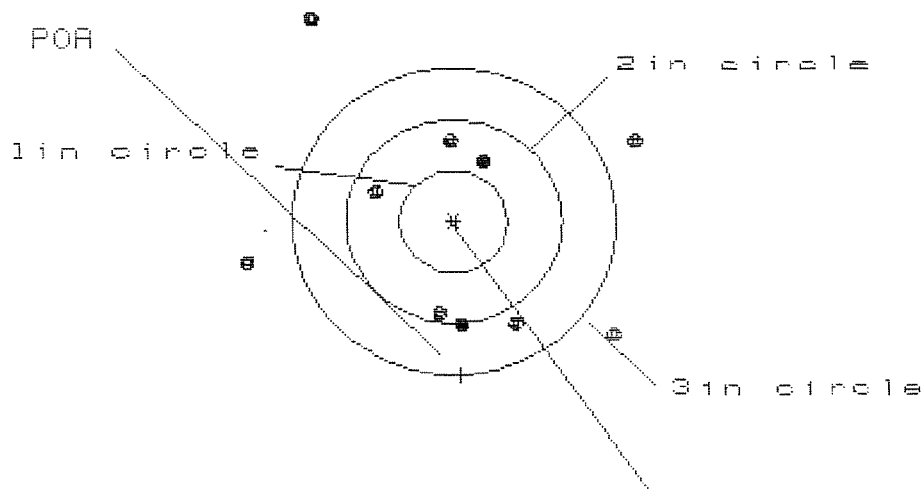
GS= 3.287

PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.022	1.123	.950
MINIMUM X	:	-1.483	-1.382	-1.384
MAXIMUM Y	:	1.442	1.170	1.088
MINIMUM Y	:	-1.079	-.918	-1.000
CENTROID X	:	.155	.054	.227
CENTROID Y	:	1.033	.872	.954
POA TO CENTROID in.	:	1.044	.874	.981
MIN RADIUS	:	.188	.051	.090
MEAN RADIUS	:	1.036	.942	.854
MAX RADIUS	:	1.703	1.621	1.444
HORIZONTAL SPREAD	:	2.505	2.505	2.334
VERTICAL SPREAD	:	2.521	2.088	2.088
EXTREME SPREAD	:	3.287	3.099	2.626
NUMBER IN ONE INCH CIRCLE =	:	2		
NUMBER IN TWO INCH CIRCLE =	:	4		

7 Jan 1988

FILE:/PATTERNING/CENTERFIRE_PATTERNING

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

CENTROID *

IN CIR

1in = 0

2in = 5

3in = 6

HS= 3.615

VS= 3.133

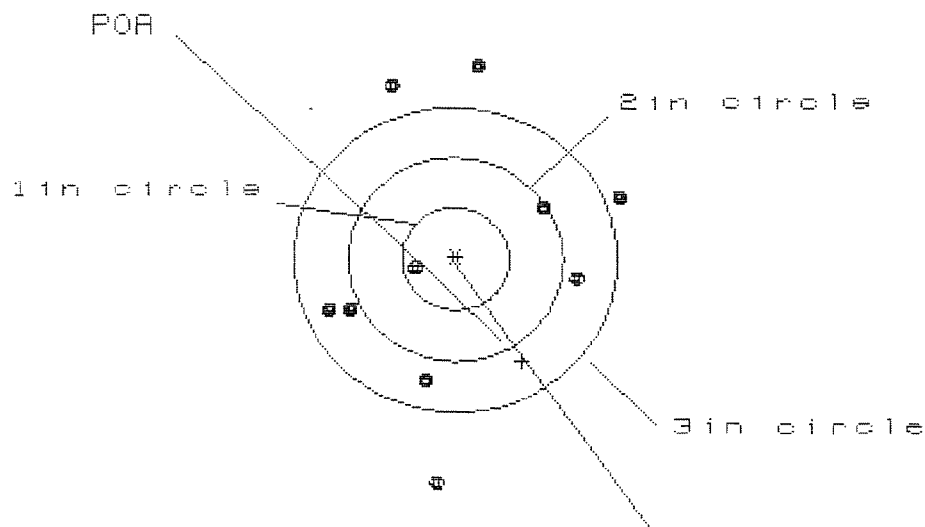
GS= 4.236

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.714	1.564	1.308
MINIMUM X	:	-1.901	-2.051	-1.167
MAXIMUM Y	:	2.008	1.042	1.023
MINIMUM Y	:	-1.125	-1.962	-1.921
CENTROID X	:	-.072	.077	.333
CENTROID Y	:	1.505	1.261	1.301
POA TO CENTROID in.	:	1.507	1.284	1.343
MIN RADIUS	:	.614	.739	.763
MEAN RADIUS	:	1.344	1.205	1.098
MAX RADIUS	:	2.417	2.057	1.660
HORIZONTAL SPREAD	:	3.615	3.615	2.475
VERTICAL SPREAD	:	3.133	1.944	1.944
EXTREME SPREAD	:	4.236	3.807	2.681
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		6	

7 Jan 1988

FILE:/PATTERNING/CENTERFIRE_PATT/CB498862

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 1

2in = 2

3in = 6

HS= 2.743

VS= 4.105

GS= 4.135

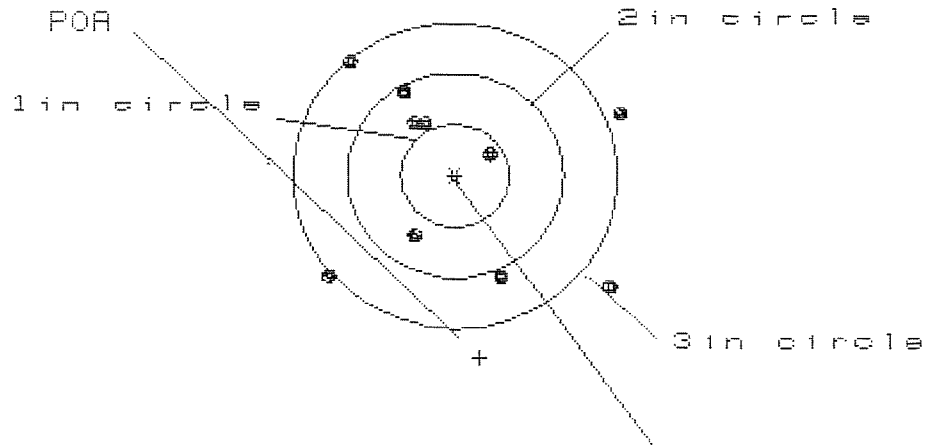
CENTROID *

PATTERN #	3		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.530	1.505	1.535
MINIMUM X	-1.213	-1.238	-1.208
MAXIMUM Y	1.901	1.656	1.645
MINIMUM Y	-2.204	-1.440	-1.233
CENTROID X	-.620	-.595	-.625
CENTROID Y	.990	1.235	1.028
POA TO CENTROID in.	1.168	1.371	1.203
MIN RADIUS	.392	.529	.398
MEAN RADIUS	1.367	1.274	1.194
MAX RADIUS	2.216	1.674	1.736
HORIZONTAL SPREAD	2.743	2.743	2.743
VERTICAL SPREAD	4.105	3.096	2.878
EXTREME SPREAD	4.135	3.152	2.953
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		2	
NUMBER IN THREE INCH CIRCLE =		6	

7 Jan 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C8498862

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 7

HS= 2.718

VS= 2.191

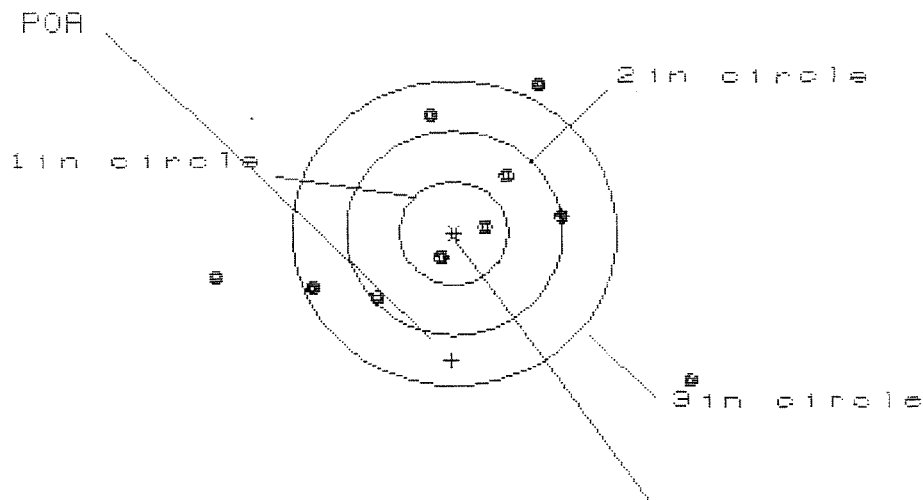
GS= 3.193

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.496	1.649	.784
MINIMUM X	:	-1.222	-1.069	-.862
MAXIMUM Y	:	1.070	.945	1.001
MINIMUM Y	:	-1.121	-1.143	-1.087
CENTROID X	:	-.225	-.378	-.585
CENTROID Y	:	1.787	1.912	1.856
POR TO CENTROID in.	:	1.802	1.949	1.946
MIN RADIUS	:	.368	.384	.442
MEAN RADIUS	:	1.072	.959	.863
MAX RADIUS	:	1.778	1.709	1.340
HORIZONTAL SPREAD	:	2.718	2.718	1.646
VERTICAL SPREAD	:	2.191	2.088	2.088
EXTREME SPREAD	:	3.193	3.117	2.496
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		7	

7 Jan 1968

FILE:/PATTERNING/CENTERFIRE_PATT/C6498882

CENTERFIRE PATTERNS # 5



OF SHOTS = 10

IN CIR

1 in = 2

2 in = 4

3 in = 7

HQ = 4.422

VS = 2.842

GS = 4.527

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.159	1.262	1.009
MINIMUM X	:	-2.263	-2.023	-1.310
MAXIMUM Y	:	1.417	1.258	1.182
MINIMUM Y	:	-1.425	-.819	-.895
CENTROID X	:	.014	-.226	.027
CENTROID Y	:	1.239	1.398	1.474
POA TO CENTROID in.	:	1.239	1.416	1.475
MIN RADIUS	:	.267	.419	.336
MEAN RADIUS	:	1.235	1.103	.926
MAX RADIUS	:	2.587	2.114	1.532
HORIZONTAL SPREAD	:	4.422	3.285	2.319
VERTICAL SPREAD	:	2.842	2.077	2.077
EXTREME SPREAD	:	4.527	3.549	2.848
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		7	



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

MODEL 700™ H24	SERIAL NO. C6498862
01	ORDER NO. 5716

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



CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6498862

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	5 2	90	RW
600	Proof	5 2	90	RW
607	Check Headspace	5 2	90	RW
610	Dis-assemble Gun	5 2	90	RW
612	Magnaflux Barrel Action	5-8-90		KCR
	Magnaflux Bolt	5-8-90		KCR
615	Rollmark Caliber		5/8/90	GS
617	Drill and Tap Sight Holes		5/9/90	FB
618	Polish Barrel <i>WB</i>		5/10/90	WB
620	Apply Coatings (Barrel Action)		5/16/90	TJA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		5/18/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/18/90	RW
	C) Inspect Ejector Hole for Chamfer		5/18/90	RW
	D) Oil Firing Pin Ass'y		5/18/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		5/22/90	RM

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	4 3/4	5/23/90		WB	
	G) Safety Off Force	2 3/4	2 1/2	2 3/4	5/23/90		WB	
	H) Trigger Pull Test & Retainability				5/22/90		JK	
	I) Firing Pin Indent	.023	.023	.023	5/23/90		WB	
	J) Assemble Stock				5/23/90		RW	
	K) Assemble Swivel Studs				29 May 90		JS	
	L) Attach Front and Rear Sight Assemblies				5/23/90		RW	
	M) Iron Sight Alignment				5/23/90		RW	
	N) Detach Front & Rear Sights & place in numbered container				5/23/90		RW	
	O) Attach Scope to Rifle				5/24/90		WB	
	P) Detach & Attach Scope 20 Times				5/24/90		WB	
640	Gallery Target & Test				5-25-90		JK	
	A) Time				"		JK	
	B) Malfunctions				"		JK	
	C) Pierced Primers				"		JK	
	D) Optical Clarity of Scope				"		JK	
645	Inspect for Live Ammo				5-25-90		JK	
655	Final Inspection							
	A) Headspace				29 May 90		JS	
	B) Trigger Pull	223	233	224	212	225	29 May 90	JS
	C) Function				29 May 90		JS	
660	Pack				6-20-90		JK	

SWS TRIGGER PULL TEST

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

SERIAL NO C6498862
DATE 5/22/90
TESTER JP

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.55	2.32	2.39	2.23	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.41	2.40	2.44	2.33	
PULL #3	2.32	2.18	2.24	2.24	
PULL #4	2.27	2.31	2.55	2.12	
PULL #5	2.21	2.28	2.45	2.25	
TOTAL	11.76	11.49	12.07		
AVG.	2.352	2.298	2.414		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.35	3.19		
PULL #2	3.01	3.33		
PULL #3	3.21	3.33		
PULL #4	3.19	3.27		
PULL #5	3.16	3.24		
TOTAL	15.92	16.36		
AVG.	3.184	3.272		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.43	4.44		4.22
PULL #2	4.53	4.36		4.15
PULL #3	4.44	4.43		4.04
PULL #4	4.44	4.43		4.25
PULL #5	4.43	4.49		4.28
TOTAL	22.27	22.15		20.94
AVG.	4.454	4.43		4.188

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6498862
29 May 1990

CENTROIDAL DISTANCES

0 TO	1	.130188
1 TO	2	.0828553
1 TO	3	.34377
1 TO	4	.768784
1 TO	5	.627498

37⁵⁴ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .26
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0246
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .261161
THE AMR FOR THIS RIFLE IS: .867

29 May 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6498862

CENTERFIRE PATTERNS

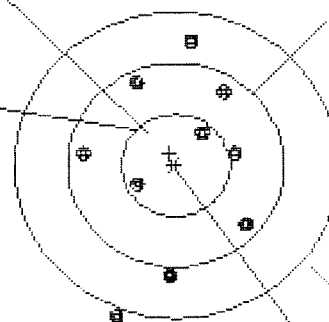
1

POA

1 in circle

2 in circle

3 in circle



OF SHOTS - 10

IN CIR

1 in = 2

2 in = 7

3 in = 9

HS = 1.478

VS = 2.708

GS = 2.809

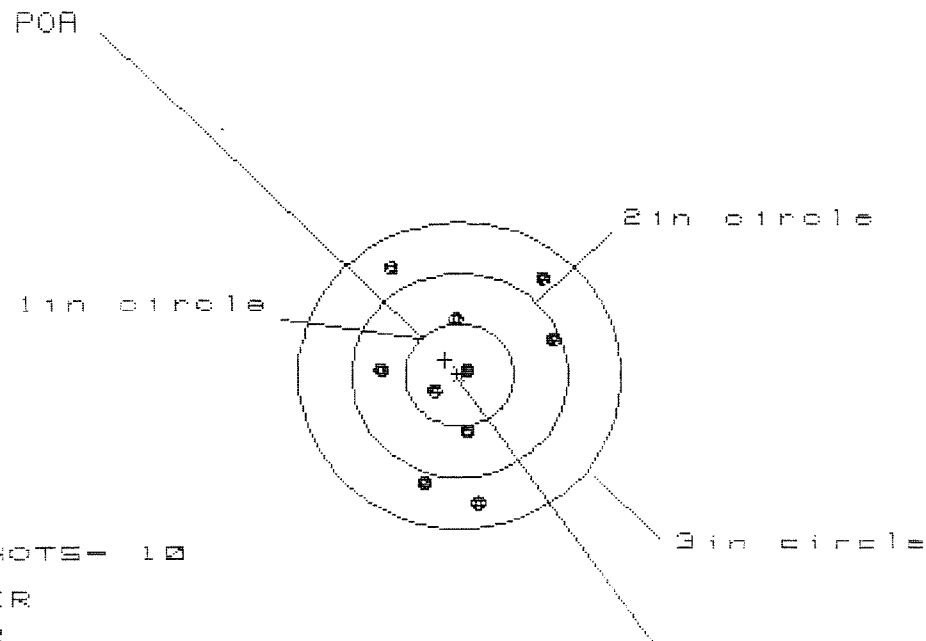
CENTROID #

PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.660	.597	.612
MINIMUM X	:	-.818	-.881	-.866
MAXIMUM Y	:	1.224	1.059	.750
MINIMUM Y	:	-1.484	-1.239	-1.106
CENTROID X	:	.055	.118	.103
CENTROID Y	:	-.118	.047	-.036
POA TO CENTROID in.	:	.131	.127	.134
MIN RADIUS	:	.376	.253	.360
MEAN RADIUS	:	.873	.766	.733
MAX RADIUS	:	1.587	1.245	1.112
HORIZONTAL SPREAD	:	1.478	1.478	1.478
VERTICAL SPREAD	:	2.708	2.298	1.856
EXTREME SPREAD	:	2.809	2.311	1.886
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

29 May 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6498862

CENTERFIRE PATTERNS # 2



OF SHOTS - 10

IN CIR

1in = 2

2in = 6

3in = 10

HS = 1.612

VS = 2.342

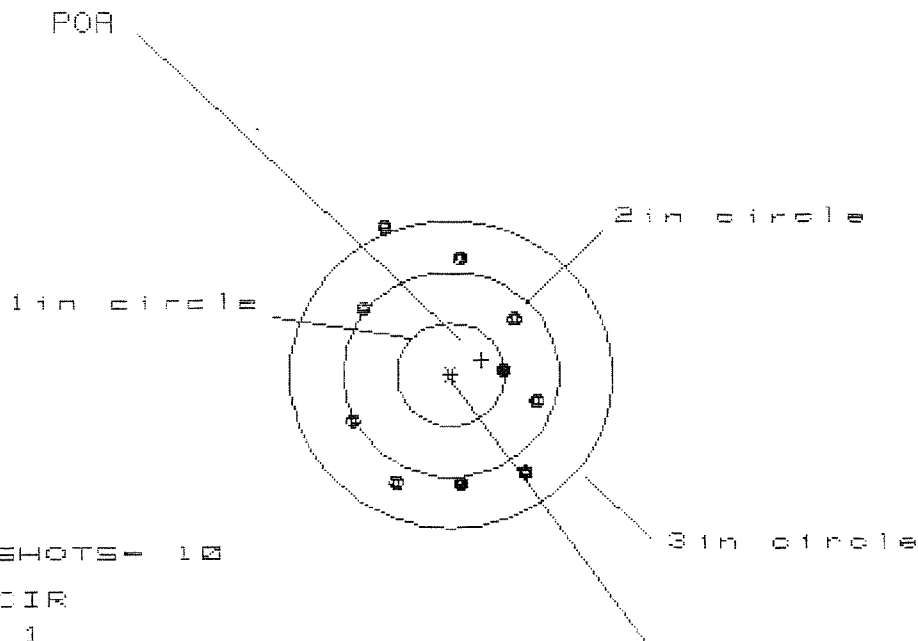
GS = 2.473

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.899	.914	.832
MINIMUM X	:	-.713	-.698	-.780
MAXIMUM Y	:	1.058	.915	.911
MINIMUM Y	:	-1.284	-1.185	-1.070
CENTROID X	:	.131	.116	.198
CENTROID Y	:	-.151	-.008	-.123
POA TO CENTROID in.	:	.200	.117	.233
MIN RADIUS	:	.132	.136	.064
MEAN RADIUS	:	.813	.755	.697
MAX RADIUS	:	1.290	1.226	1.153
HORIZONTAL SPREAD	:	1.612	1.612	1.612
VERTICAL SPREAD	:	2.342	2.100	1.981
EXTREME SPREAD	:	2.473	2.268	2.268
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	

29 May 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6498862

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 1

2in = 4

3in = 5

HS= 1.731

VS= 2.525

GS= 2.657

CENTROID #

PATTERN #	3	3	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.836	.773	.703
MINIMUM X	-.895	-.958	-1.028
MAXIMUM Y	1.431	1.301	1.184
MINIMUM Y	-1.094	-.935	-1.038
CENTROID X	-.288	-.225	-.155
CENTROID Y	-.141	-.300	-.183
POA TO CENTROID in.	.321	.375	.240
MIN RADIUS	.498	.468	.369
MEAN RADIUS	1.030	.954	.919
MAX RADIUS	1.539	1.301	1.186
HORIZONTAL SPREAD	1.731	1.731	1.731
VERTICAL SPREAD	2.525	2.236	2.222
EXTREME SPREAD	2.657	2.306	2.223
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	9		

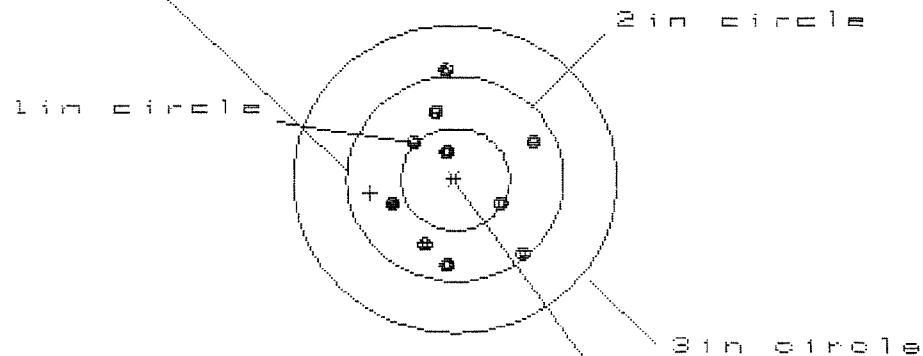
29 May 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C649B862

CENTERFIRE PATTERNS

4

POA



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 9

3 in = 10

HS= 1.227

VS= 1.961

GS= 1.961

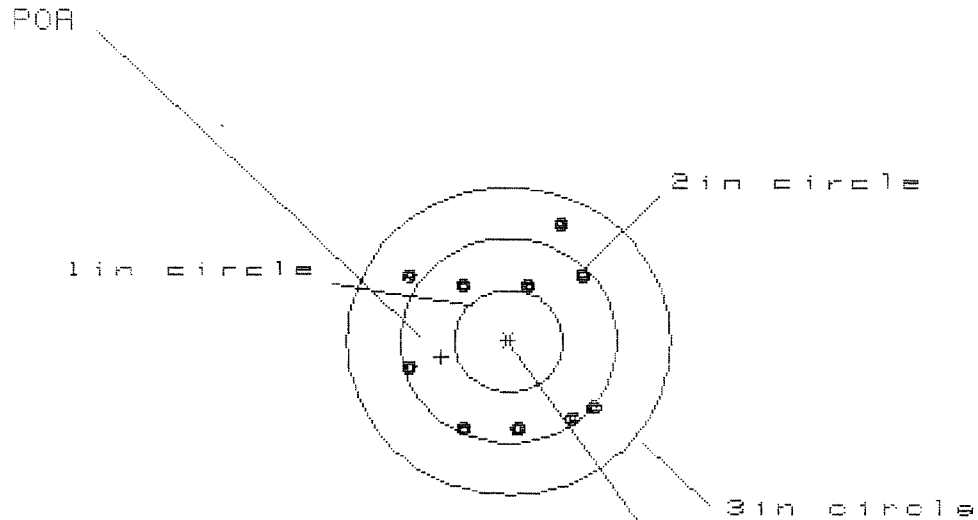
CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.677	.668	.739
MINIMUM X	:	-.550	-.559	-.489
MAXIMUM Y	:	1.104	.780	.706
MINIMUM Y	:	-.857	-.735	-.809
CENTROID X	:	.782	.791	.721
CENTROID Y	:	.132	.010	.084
POA TO CENTROID in.	:	.793	.791	.725
MIN RADIUS	:	.298	.420	.338
MEAN RADIUS	:	.690	.641	.607
MAX RADIUS	:	1.107	.816	.826
HORIZONTAL SPREAD	:	1.227	1.227	1.227
VERTICAL SPREAD	:	1.961	1.515	1.515
EXTREME SPREAD	:	1.961	1.565	1.517
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		9	
NUMBER IN THREE INCH CIRCLE	=		10	

29 May 1980

FILE:/PATTERNING/CENTERFIRE_PATT/C6498862

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in = 0

2 in = 7

3 in = 10

HS= 1.762

VS= 2.012

GS= 2.185

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.811	.861	.748
MINIMUM X	-.951	-.901	-.982
MAXIMUM Y	1.147	.775	.849
MINIMUM Y	-.865	-.738	-.641
CENTROID X	.620	.570	.683
CENTROID Y	.155	.028	-.069
POA TO CENTROID in.	.639	.571	.686
MIN RADIUS	.524	.660	.642
MEAN RADIUS	.929	.889	.838
MAX RADIUS	1.230	1.189	1.052
HORIZONTAL SPREAD	1.762	1.762	1.730
VERTICAL SPREAD	2.012	1.513	1.490
EXTREME SPREAD	2.185	2.173	1.846
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	10		