

C6348731

MODEL 700TM M24

Model **SWS** TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington.

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

M2400062610

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: **RE00151232**

Serial: C6348731 Model M24 SWS Center Fire
Caliber: 7.62 NATO

Repairman:

Status:

Closed 9/16/2008 2:28:44 PM

Verify Repair

Address Information

Customer:

☒ Received From

Return To:

☐ Received From

Name: **ISD ARMSROOM**

ISD 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
A017	Scope Base	1
A057	Fit and Rear Sgt Base	1

Repair Search

Refresh

Close

nagletj

9/16/2008

3:27 PM

CAPS

NUM

INS

SCRL



Serial Number: **C6348731**

Model **M24 SWS**



RE00151232

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

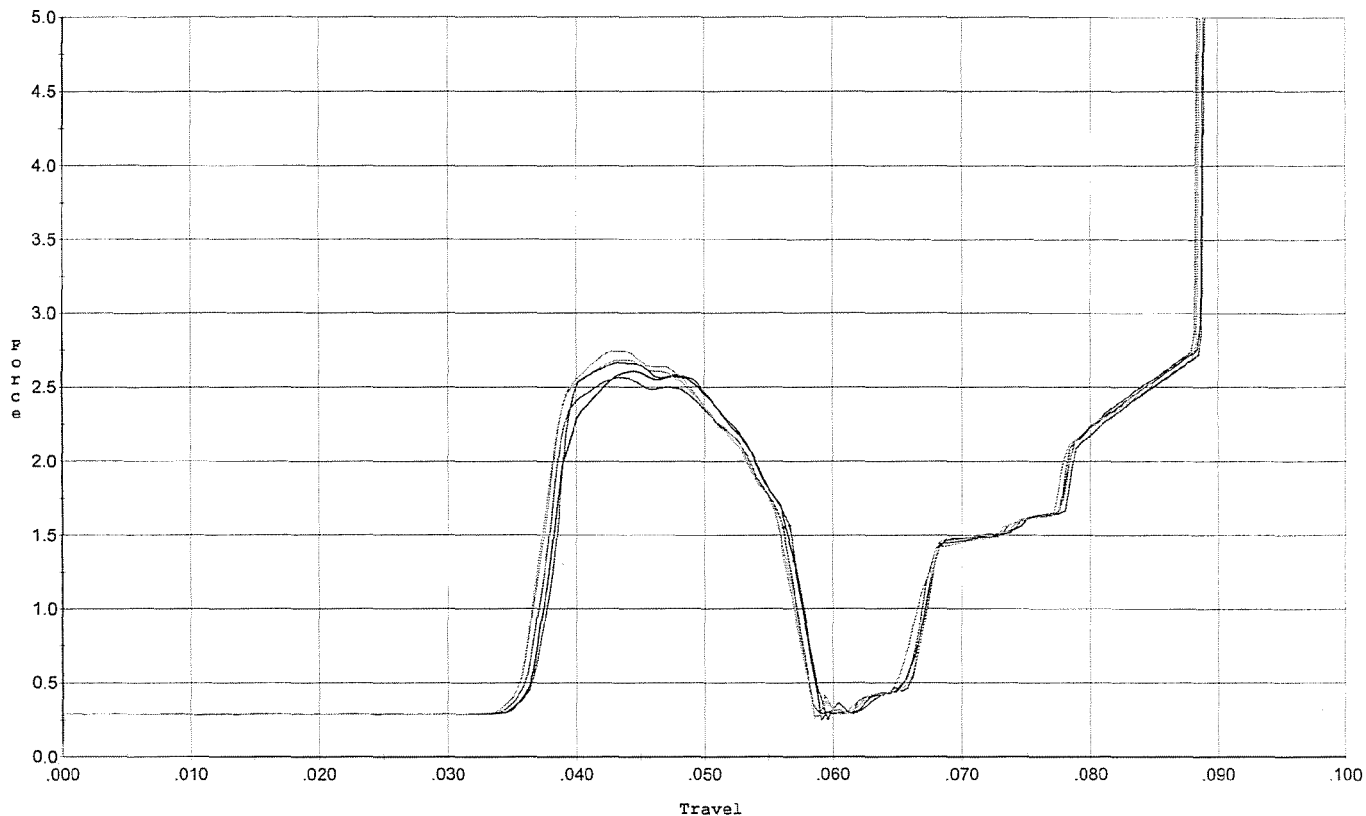
WALD NUMBER 151232
SERIAL NUMBER C6348731
LOG IN DATE 9-16-08

OPERATION #	OPERATION NAME	DATE	INITIAL
500	DIS-ASSEMBLE GUN	9-17-08	RTZ
505	RE-BARREL	9-22-08	LR
560	ASSEMBLE	9-22-08	RTZ
600	PROOF	9-22-08	RTZ
605	CHECK HEADSPACE	9-22-08	RTZ
610	DIS-ASSEMBLE GUN	9-22-08	RTZ
612	MAGNAFLUX	9/30/08	(RTZ)
510	DRILL AND TAP	9-23-08	SP
615	ROLLMARK CALIBER	9/30/08	RT
618	ROTO-BLAST		
620	APPLY COATINGS	10/1	✓
625	FINAL ASSEMBLY	10-7-08	RTZ
640	FUNCTION TEST AND	10-9-08	RTZ
650	TARGET	10-8-08	RTZ
	MALFUNCTION <i>Bac</i>	10-9-08	RTZ
	MALFUNCTION		
	MALFUNCTION		
	MALFUNCTION		
670	FINAL INSPECTION A) HEADSPACE	10-22-08	RTZ
	4.5 LBS MIN 2.50 LBS BI TRIGGER PULL MAX 4.0 LBS	2.43 2.47 2.45 2.38 2.47	10/16/08 Fm
	2 LBS MIN 10 LBS MAX	4.5 4.5 5.0	10-22-08 RTZ
	F) SAFETY ON FORCE	5.0 5.0 5.0	10-22-08 RTZ
	G) SAFETY OFF FORCE	5.0 5.0 5.0	10-22-08 RTZ
	I) FIRING PIN INDENT .020	.001 .020 .020	10-22-08 RTZ
690	PACK	10/24/08	Fm

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 9/2/08

Model: M/24
Serial No: Form #F005
Trigger: 2.5 lbs. ini. +/- .50 lbs.



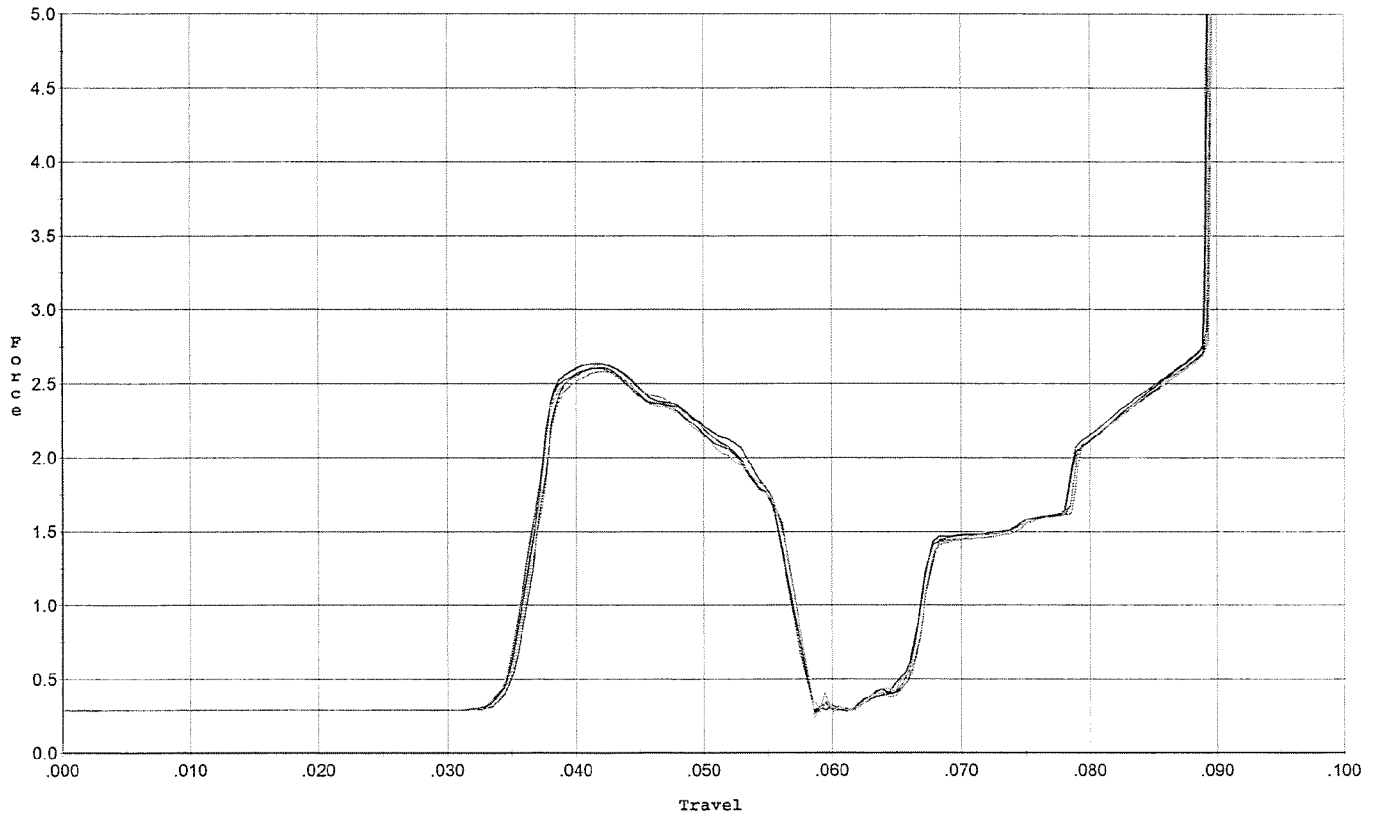
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.669	0.057	0.037	0.038	0.055		Set Trigger
2	2.609	0.057	0.036	0.038	0.055		Set Trigger
3	2.567	0.056	0.036	0.038	0.054		Set Trigger
4	2.685	0.057	0.036	0.037	0.056		Set Trigger
5	2.748	0.055	0.035	0.038	0.055		Set Trigger

Avg 2.65

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putsch 9/2/08

Model: M/24
Serial No: Form #F005
Trigger: 2.5 lbs. after 50 cycles +/- .50 lbs.



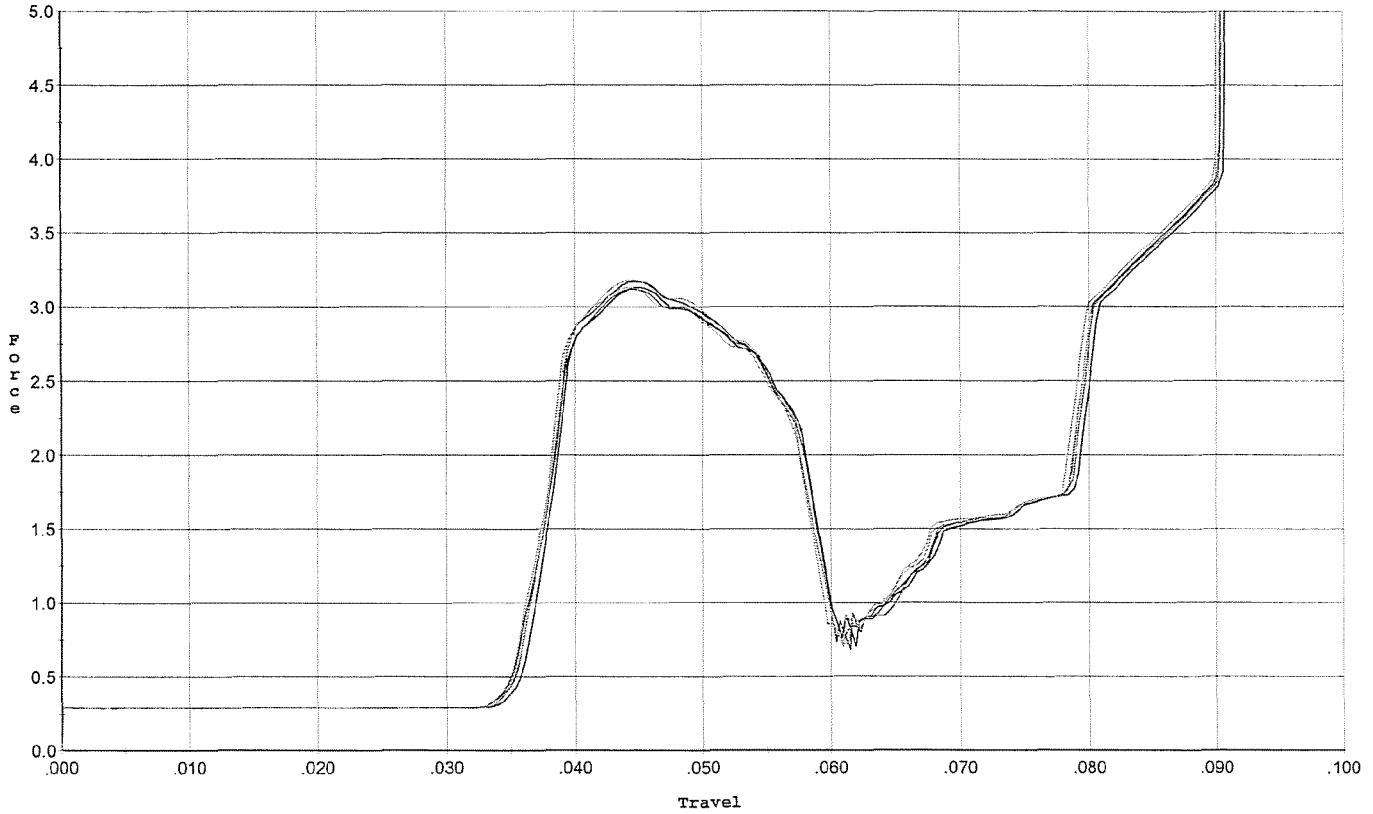
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.607	0.056	0.035	0.038	0.055		Set Trigger
2	2.635	0.055	0.035	0.038	0.055		Set Trigger
3	2.604	0.055	0.034	0.038	0.055		Set Trigger
4	2.582	0.056	0.035	0.038	0.055		Set Trigger
5	2.625	0.056	0.035	0.038	0.056		Set Trigger

Avg 2.61

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 9/2/08

Model: M/24
Serial No: Form #F005
Trigger: 3.0 lbs. ini. +/- .75 lbs.



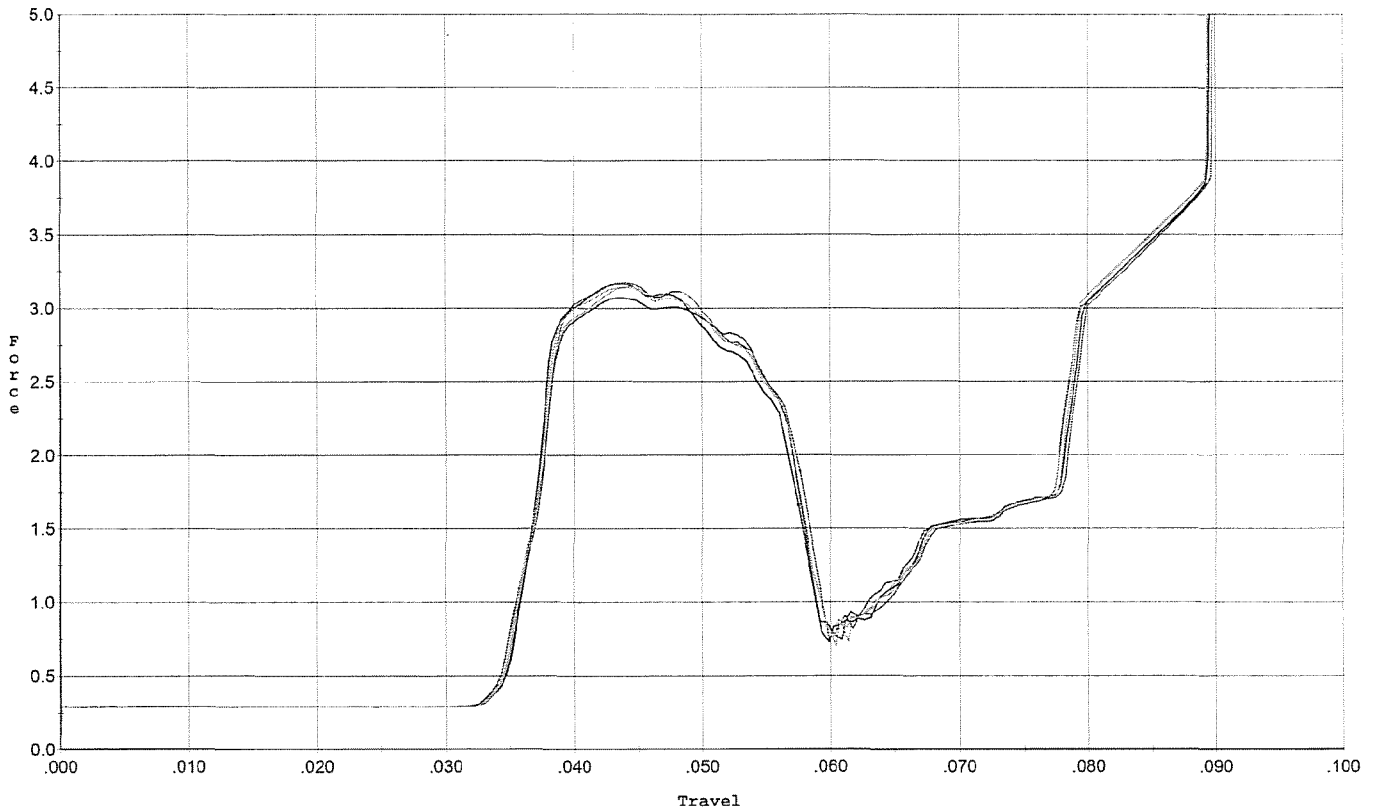
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.172	0.058	0.035	0.037	0.070		Set Trigger
2	3.131	0.058	0.036	0.037	0.068		Set Trigger
3	3.120	0.057	0.035	0.037	0.067		Set Trigger
4	3.179	0.057	0.035	0.037	0.068		Set Trigger
5	3.131	0.057	0.035	0.037	0.068		Set Trigger

Avg 3.14

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 9/2/08

Model: M/24
Serial No: Form #F005
Trigger: 3.0 lbs. after 20 cycles +/- .75 lbs.



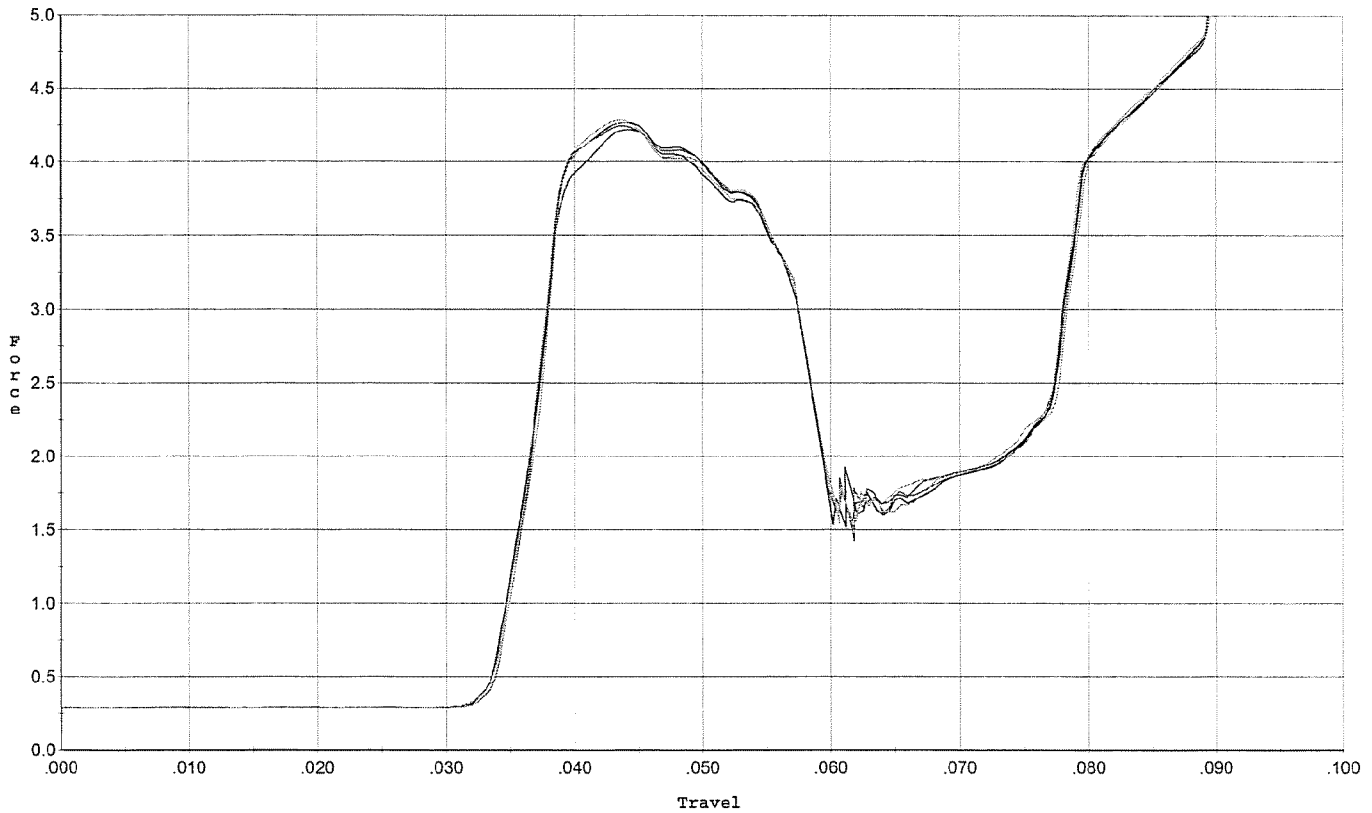
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.072	0.057	0.034	0.037	0.069		Set Trigger
2	3.163	0.057	0.035	0.037	0.069		Set Trigger
3	3.173	0.058	0.035	0.037	0.071		Set Trigger
4	3.142	0.057	0.034	0.037	0.069		Set Trigger
5	3.145	0.057	0.034	0.037	0.069		Set Trigger

Avg 3.13

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: R. Putsch 9/2/08

Model: M/24
Serial No: Form #F005
Trigger: 4.0 lbs. ini. +/- 1.0 lbs.



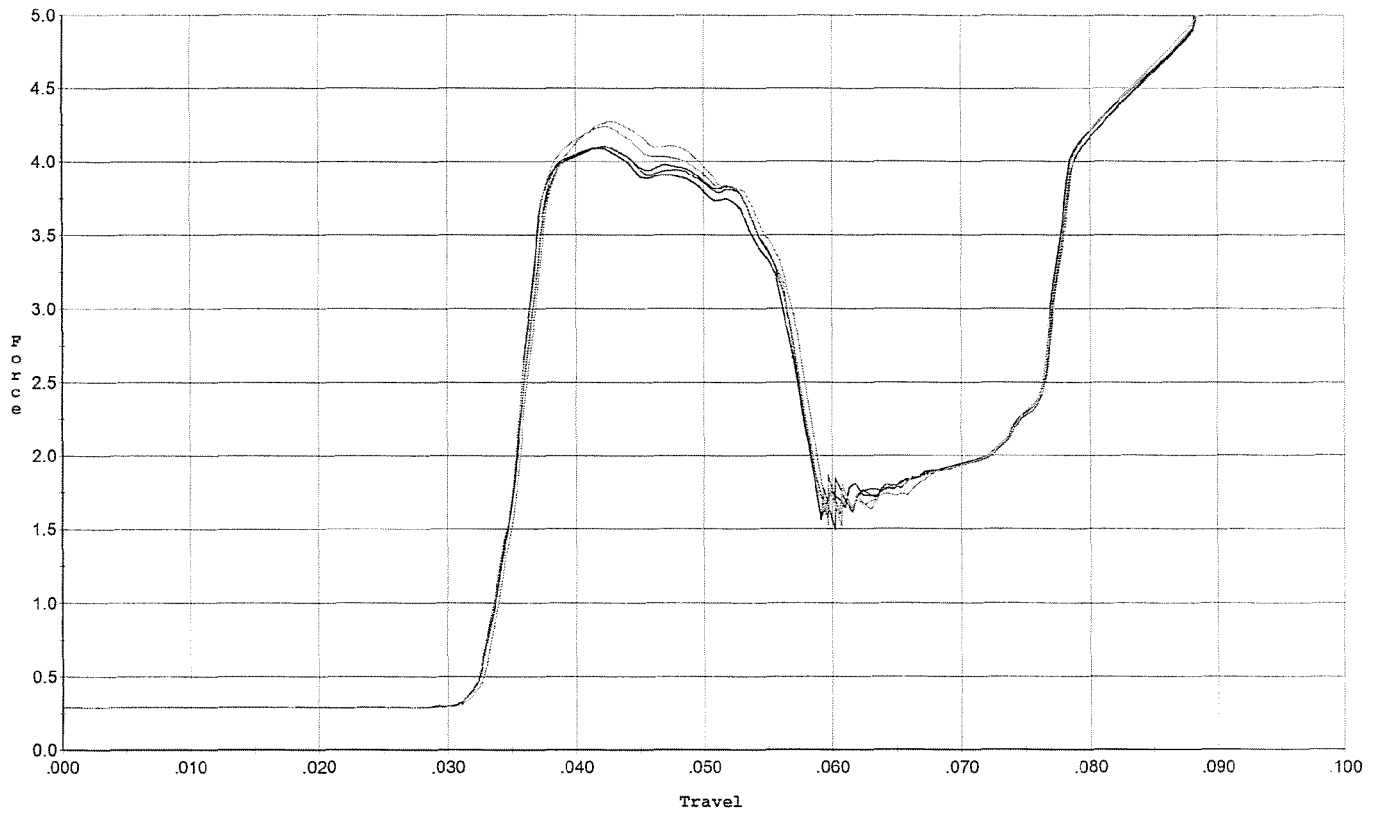
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.220	0.057	0.033	0.035	0.092		Set Trigger
2	4.269	0.057	0.034	0.035	0.094		Set Trigger
3	4.246	0.057	0.034	0.035	0.093		Set Trigger
4	4.269	0.057	0.034	0.035	0.092		Set Trigger
5	4.286	0.057	0.033	0.035	0.093		Set Trigger

Avg 4.25

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: R. Putch 9/2/08

Model: M/24
Serial No: Form #F005
Trigger: 4.0 lbs. after 20 cycles +/- 1.0 lbs.



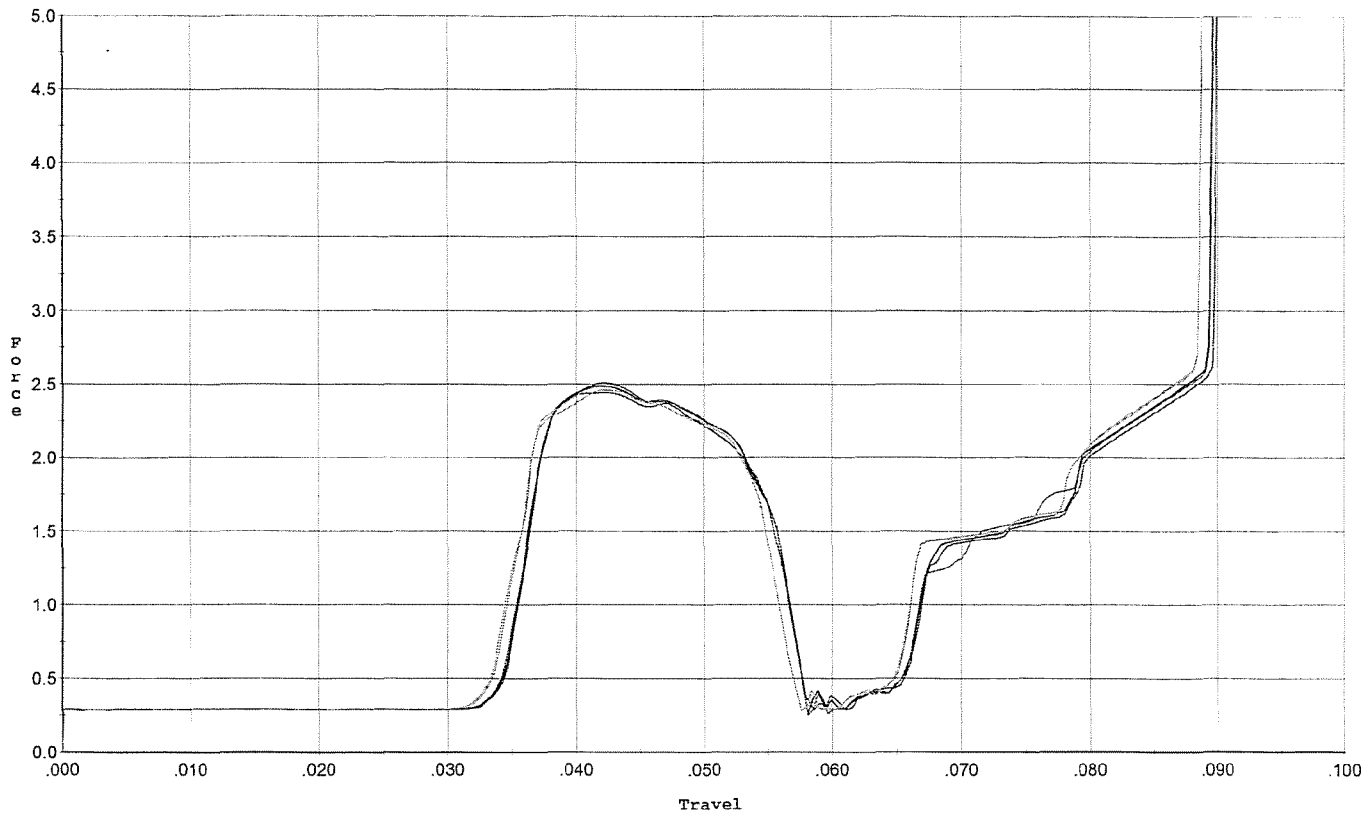
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.103	0.056	0.032	0.035	0.092		Set Trigger
2	4.091	0.057	0.032	0.034	0.093		Set Trigger
3	4.101	0.056	0.032	0.035	0.092		Set Trigger
4	4.238	0.056	0.032	0.035	0.093		Set Trigger
5	4.270	0.057	0.033	0.034	0.095		Set Trigger

Avg 4.16

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 9/2/08

Model: M/24
Serial No: Form #F005
Trigger: reset to 2.5 lbs. +/- .50 lbs. for final test



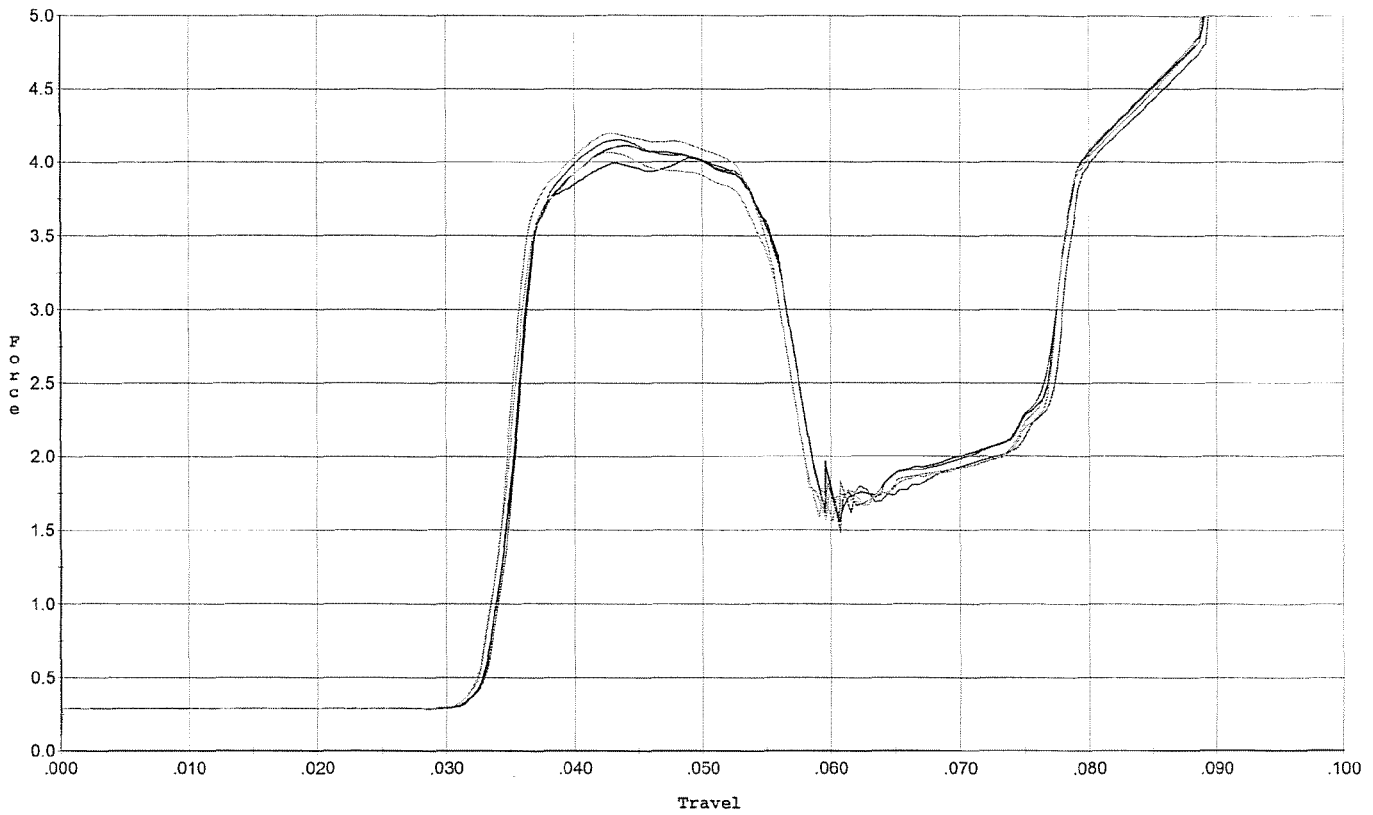
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.510	0.056	0.034	0.038	0.055		Set Trigger
2	2.489	0.056	0.034	0.038	0.056		Set Trigger
3	2.444	0.056	0.034	0.038	0.055		Set Trigger
4	2.479	0.054	0.033	0.038	0.055		Set Trigger
5	2.458	0.054	0.033	0.038	0.054		Set Trigger

Avg 2.47

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 9/2/08

Model: M/24
Serial No: Form #F005
Trigger: set to 4.0 lbs. +/- 1.0 lbs. for target & accuracy



#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.028	0.056	0.033	0.035	0.092		Set Trigger
2	4.113	0.056	0.033	0.035	0.093		Set Trigger
3	4.151	0.056	0.033	0.035	0.093		Set Trigger
4	4.066	0.056	0.032	0.035	0.091		Set Trigger
5	4.195	0.056	0.032	0.035	0.094		Set Trigger

Avg 4.11

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6348731.___0

FILE DATE AND TIME: 10/08/2008 15:48

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.009
The Average Y Centroid of the Five Target Set:	-0.014
The Average Point of Impact of the Five Target Set:	0.016
The Average Mean Radius of the Five Target Set:	0.819
The Distance from POA to Centroid Target #1:	0.062
The Distance from Centroid Target #2 to Centroid Target #1:	0.124
The Distance from Centroid Target #3 to Centroid Target #1:	0.095
The Distance from Centroid Target #4 to Centroid Target #1:	0.177
The Distance from Centroid Target #5 to Centroid Target #1:	0.035

SERIAL NUMBER: C6348731. __0

TARGET NUMBER: 1

FILE DATE: 10/08/2008

FILE TIME: 15:48

POINT#	X	Y
1:	0.556	0.983
2:	-1.254	0.050
3:	-0.738	-0.499
4:	-0.208	0.423
5:	-0.227	-0.322
6:	0.202	0.089
7:	0.280	-0.200
8:	0.862	-0.300
9:	0.391	-0.304
10:	0.048	-0.538

X CENTROID: -0.009

Y CENTROID: -0.062

POA TO CENTROID: 0.062

HORZ SPREAD: 2.116

VERT SPREAD: 1.521

GROUP SPREAD: 2.145

MIN RADIUS: 0.259

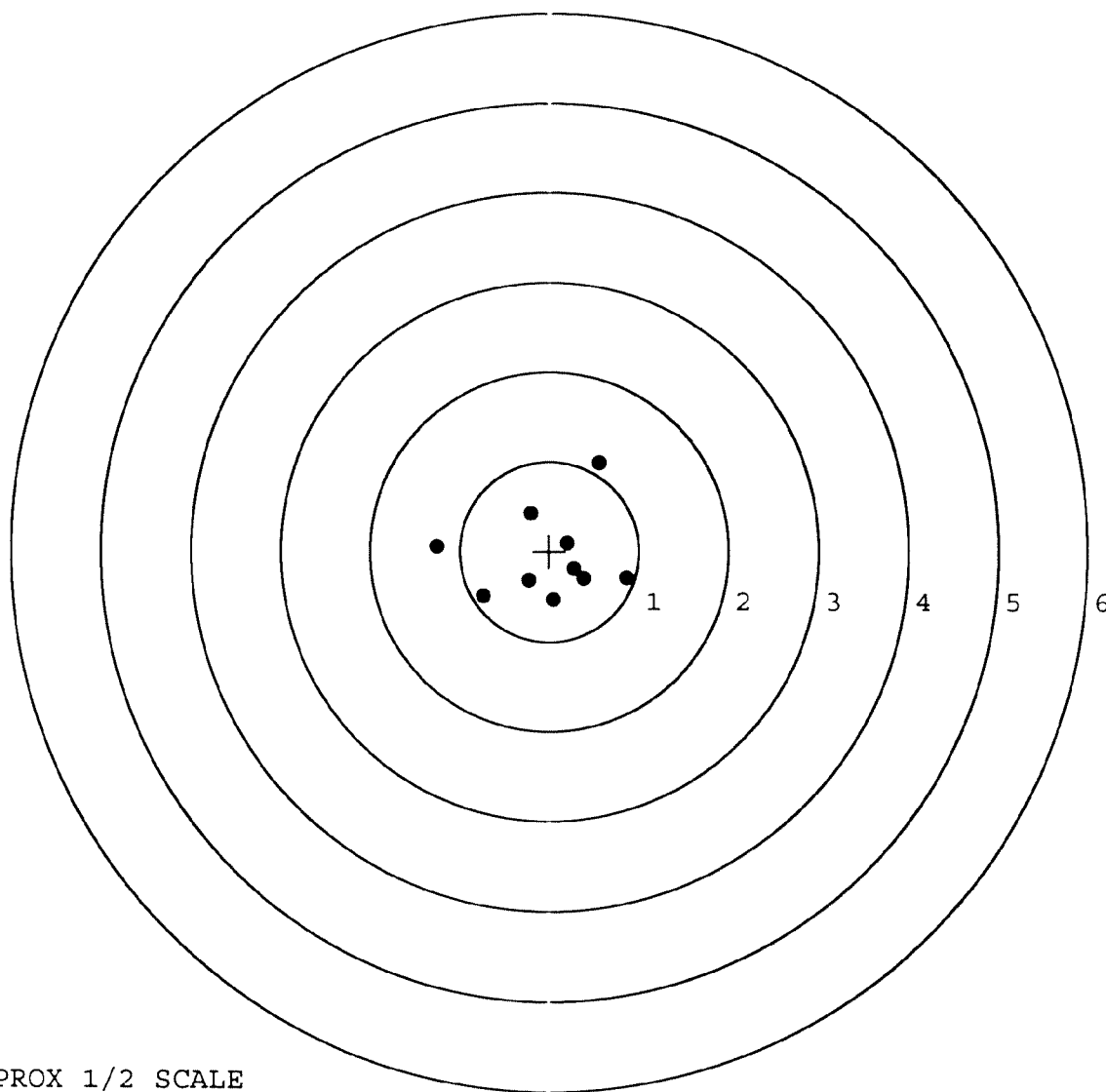
MAX RADIUS: 1.250

MEAN RADIUS: 0.658

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6348731. __0

TARGET NUMBER: 2

FILE DATE: 10/08/2008

FILE TIME: 15:48

POINT#	X	Y
1:	-1.380	-0.672
2:	-0.857	-0.524
3:	1.086	0.610
4:	0.815	0.027
5:	0.258	0.910
6:	-0.167	0.630
7:	-0.260	0.476
8:	0.093	-0.107
9:	0.276	-0.233
10:	0.313	-0.528

X CENTROID: 0.018

Y CENTROID: 0.059

POA TO CENTROID: 0.062

HORZ SPREAD: 2.466

VERT SPREAD: 1.582

GROUP SPREAD: 2.779

MIN RADIUS: 0.182

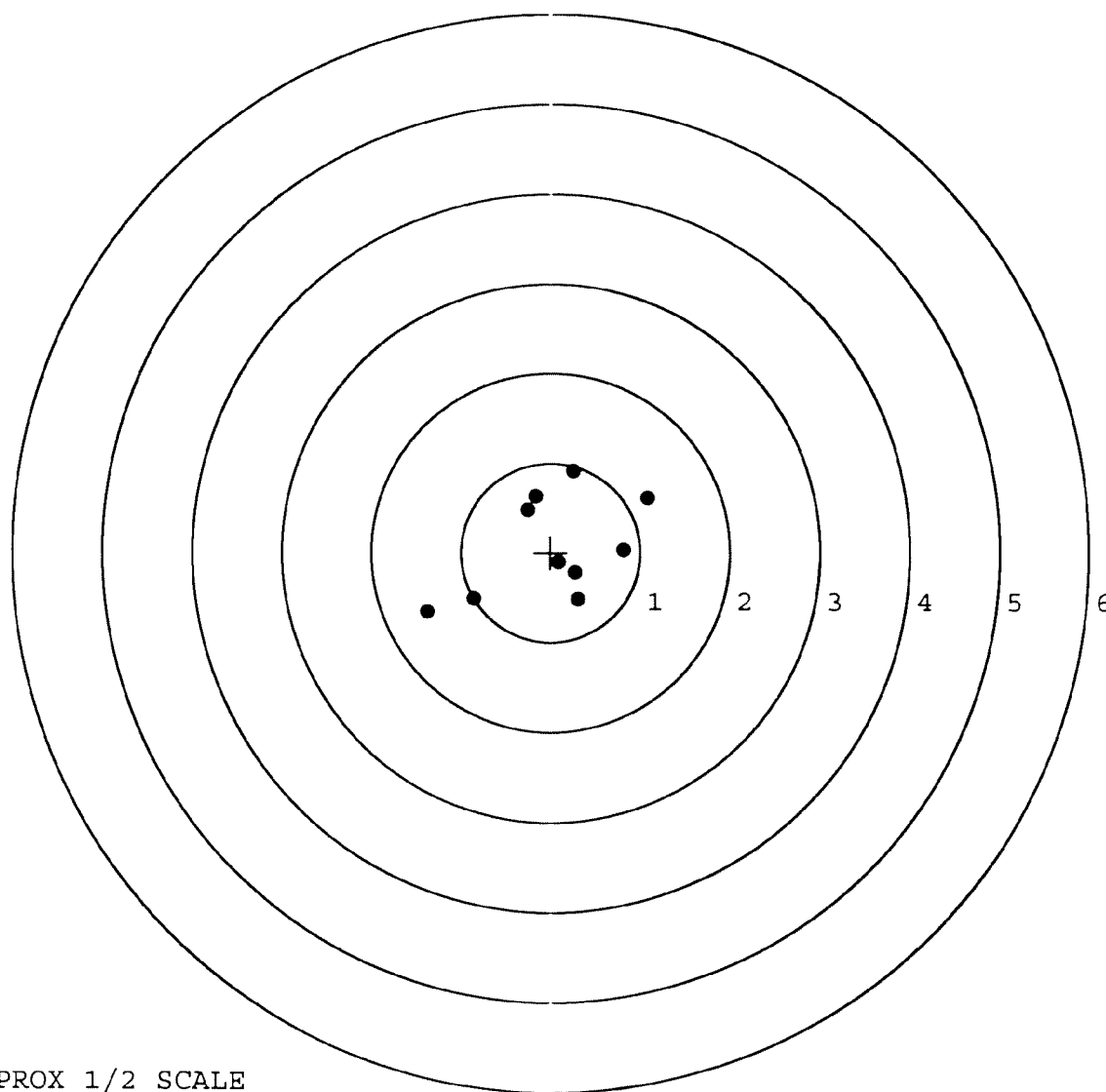
MAX RADIUS: 1.577

MEAN RADIUS: 0.784

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6348731. __0

TARGET NUMBER: 3

FILE DATE: 10/08/2008

FILE TIME: 15:48

POINT#	X	Y
1:	-0.553	1.553
2:	0.049	0.575
3:	0.692	0.532
4:	-0.682	0.148
5:	-0.856	-0.617
6:	-0.318	-0.463
7:	-0.130	-1.055
8:	0.190	-0.927
9:	0.472	-0.685
10:	0.724	-0.572

X CENTROID: -0.041

Y CENTROID: -0.151

POA TO CENTROID: 0.157

HORZ SPREAD: 1.580

VERT SPREAD: 2.608

GROUP SPREAD: 2.642

MIN RADIUS: 0.417

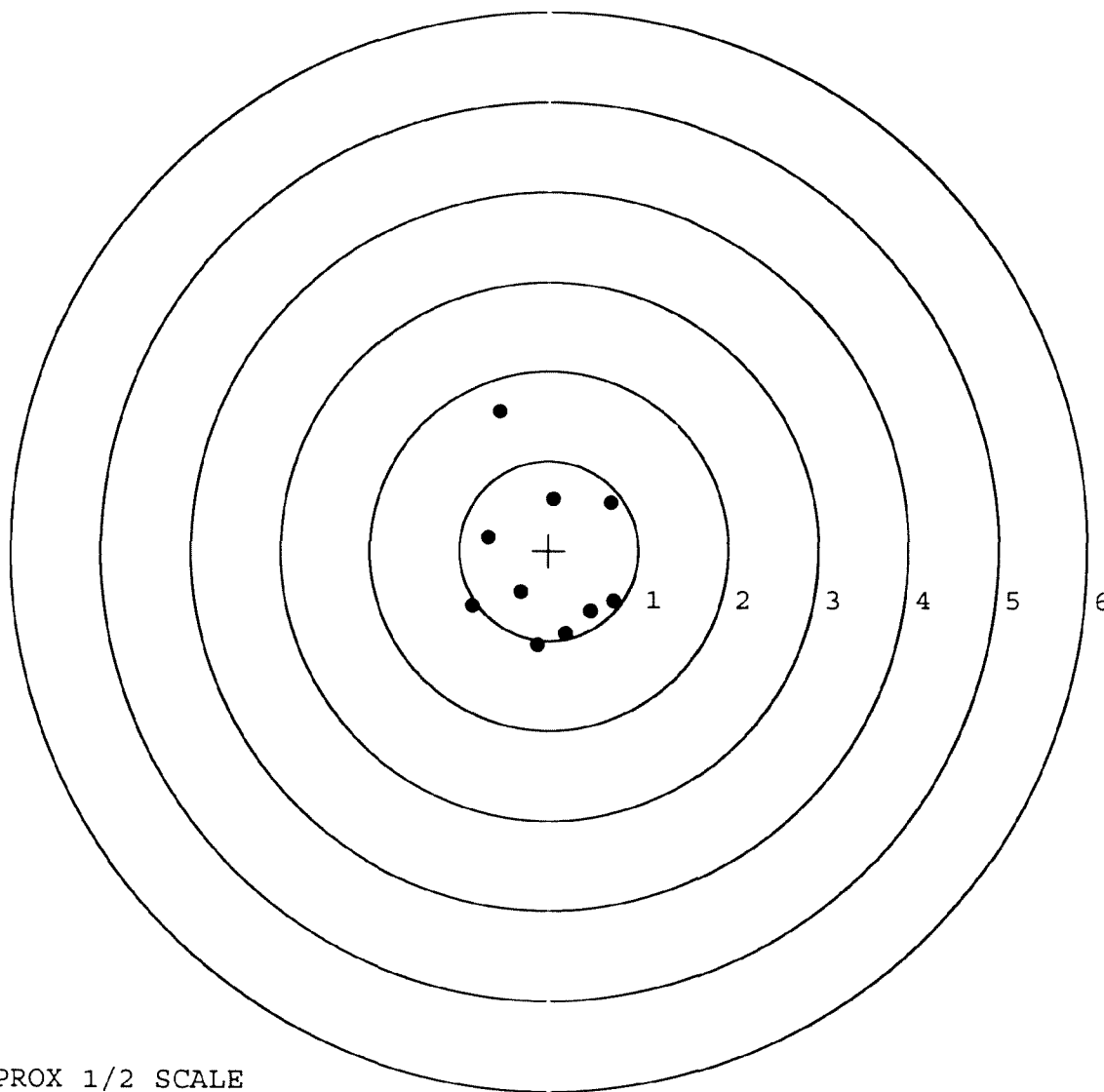
MAX RADIUS: 1.779

MEAN RADIUS: 0.891

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 9

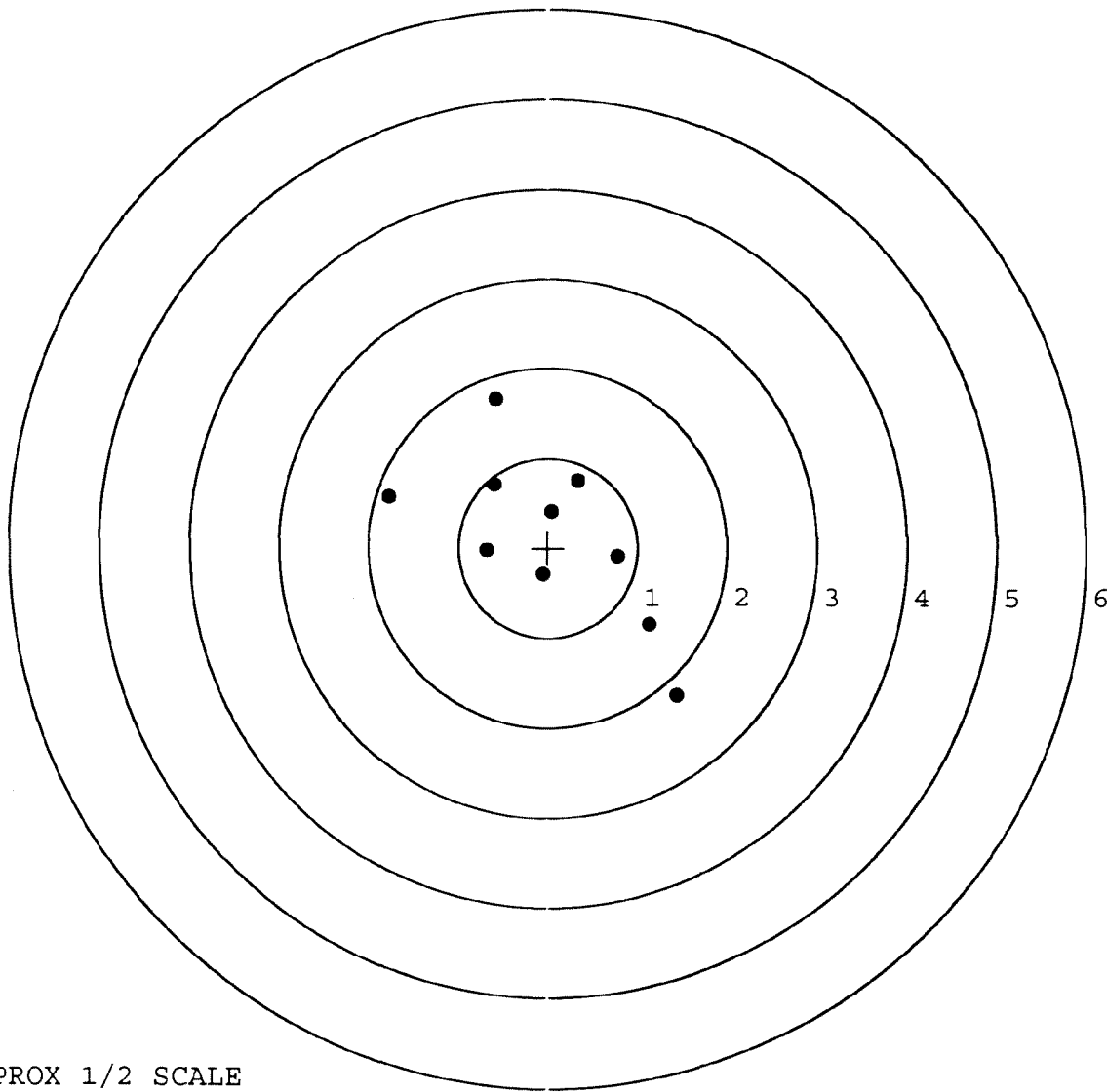


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6348731.____0
TARGET NUMBER: 4
FILE DATE: 10/08/2008
FILE TIME: 15:48

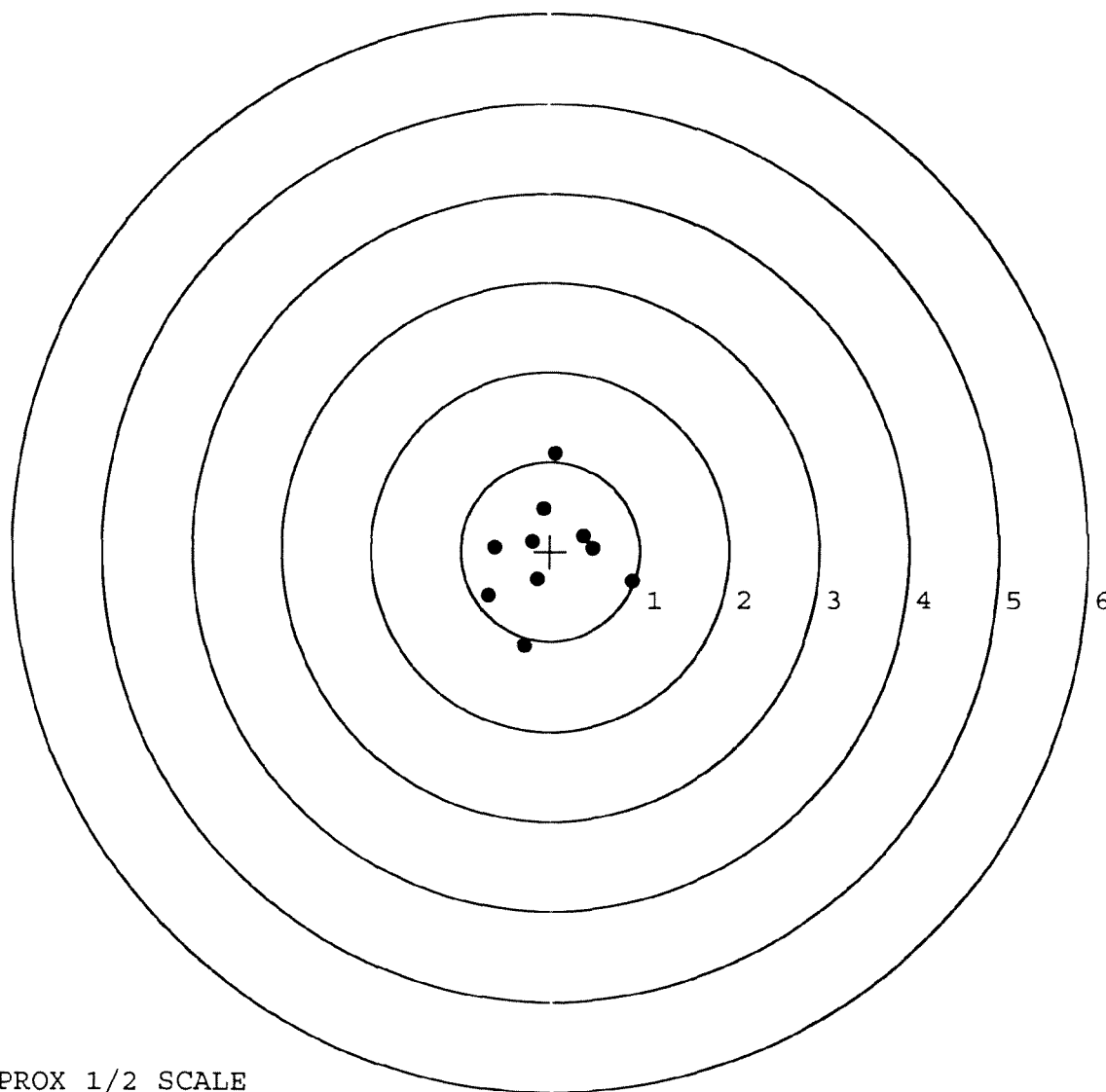
POINT#	X	Y
1:	-0.583	1.651
2:	1.442	-1.641
3:	1.134	-0.858
4:	0.778	-0.098
5:	-1.769	0.566
6:	-0.680	-0.031
7:	-0.058	-0.300
8:	-0.603	0.705
9:	0.047	0.402
10:	0.343	0.749

X CENTROID: 0.005
Y CENTROID: 0.115
POA TO CENTROID: 0.115
HORZ SPREAD: 3.211
VERT SPREAD: 3.292
GROUP SPREAD: 3.896
MIN RADIUS: 0.291
MAX RADIUS: 2.269
MEAN RADIUS: 1.101
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 6
in 3 IN DIAMETER: 7



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6348731. __0	POINT#	X	Y
TARGET NUMBER: 5	1:	0.065	1.100
FILE DATE: 10/08/2008	2:	-0.296	-1.058
FILE TIME: 15:48	3:	-0.690	-0.502
	4:	-0.622	0.044
X CENTROID: -0.019	5:	0.918	-0.344
Y CENTROID: -0.028	6:	-0.147	-0.315
POA TO CENTROID: 0.034	7:	-0.202	0.113
HORZ SPREAD: 1.608	8:	-0.069	0.475
VERT SPREAD: 2.158	9:	0.375	0.169
GROUP SPREAD: 2.188	10:	0.478	0.034
MIN RADIUS: 0.231			
MAX RADIUS: 1.132			
MEAN RADIUS: 0.661			
# IN 1 IN DIAMETER: 3			
# IN 2 IN DIAMETER: 8			
# in 3 IN DIAMETER: 10			



TARGET APPROX 1/2 SCALE

RECEIVING AND ESTIMATING REPORT

COMMENTS

ORDER

R 99-09171

INITIAL CUSTOMER ORDER NO.

SWS

393

DATE RECEIVED

DATE OPENED

DATE CODE

SERIAL NUMBER

NEW SERIAL NUMBER

MODEL AND GRADE

04/07/99

04/08/99

RJ 11-89

C6348731

700 7.62

M24

ACCESSORIES

W/STUDS

SCOPE BASE

FROM:

SHIP TO:

US ARMY
ATTN: JAMES C STARNES JR
GSC 5TH SFG (A)
FORT CAMPBELL

KY 42223

US ARMY
ATTN: JAMES C STARNES JR
GSC 5TH SFG (A)
FORT CAMPBELL

KY

42223

CUST NO: 208414 C.O.D.L

ACCOUNT NUMBER

ACCOUNT NUMBER N/C

WRITE ☐

FROM DATE

ESTIMATED

VIA

DOOR

GUN CONDITION

☐ NEW☐ LIGHTLY WORN☐ WORN☐ VERY WORN☐ UNREPAIRABLE☐ MARRED

REPAIR CHARGE

EXCISE

TAX

INSURANCE

UPS

PARCEL POST

TOTAL

CUSTOMER CONCERN	AMMO	FUNCTION	FINISH	ACCURACY	FIT	INSPECT
CYCLE	A1	B1				
TRIGGER GROUP		B2			E1	F1
BOLT ASSY.		B3			E2	F2
BARREL ASSY.		B4		D1	E3	F3
REC. ASSY.		B5		D2	E4	F4
WOOD			C1	D3	E5	F5
METAL			C2			

MAIN FAULT

PARTS

COMMENTS

Barrel 96003
Extractor 91816

REPAIRMAN

PROOF

CLEAN

TEST

TARGET

PATTERN

GALLERY TESTER

DATE

DATE

DATE

DATE

DATE

OFFICE COPY

RD6925 REV. 7/97

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

M2400062627

Receipt Of Firearm(s) Delivered to the Plant for Repair
Firearm Checked For Live Ammunition []

File # 00393

Delivery Date 4/7/99

Customer Name (Print) US Army James C Starns Jr.
Address GSC 5th SFG (A) Ft Campbell State KY Zip 42223
Phone Number (502) - 798-2882 / 7932

Firearm Description Model 700 (m24) Cal./ Ga. 7.62
Serial Number C6348731

Stock/ Fore-end Condition circle the description
(Excellent; Good ; Fair; Poor; Fancy; Plain, Synthetic, Wood)

Comments on Stock/ Fore-end condition _____

Metal Condition circle the description
(Excellent; Good ; Fair; Poor; Fancy; Plain Stainless Steel)

Comments on Metal condition _____

Barrel Type (VT. Rib; Plain; Deer; Stainless Steel) Barrel length _____

List additional accessories IE Scope, Sling, Gun case and description;

Customer request: Reconditioning

Return Process Return to Clark St. Ent. [] Return via UPS ☒

By signing this receipt the person delivering the firearm understands to be the only person to receive the firearm upon completion of repairs.

Signature James C Starns Jr. Date 4/7/99
person delivering firearm

Signature [Signature] Date 4/7/99
security officer

Signature [Signature] Date 4/7/99
arms service / CSR

Customer Pick Up Verification

I certify, I am the same person whom delivered the above described firearm to the Remington Ilion plant for repair and may lawfully possess a firearm in New York State

Signature _____ Date ____/____/____
person receiving firearm must be the same whom delivered

Signature _____ Date ____/____/____
security officer or other witness returning the firearm

Remington Test Lab, Ilion, N.Y.

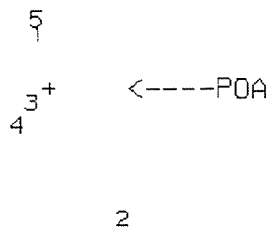
Centroidal distance calculations for Rifle # c6348731
21 Jun 1999

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0054
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0796
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .079783

THE AMR FOR THIS RIFLE IS: 1.242

CENTROIDAL DISTANCES

0 TO 1	.376175
1 TO 2	1.36746
1 TO 3	.469564
1 TO 4	.635012
1 TO 5	.0907965

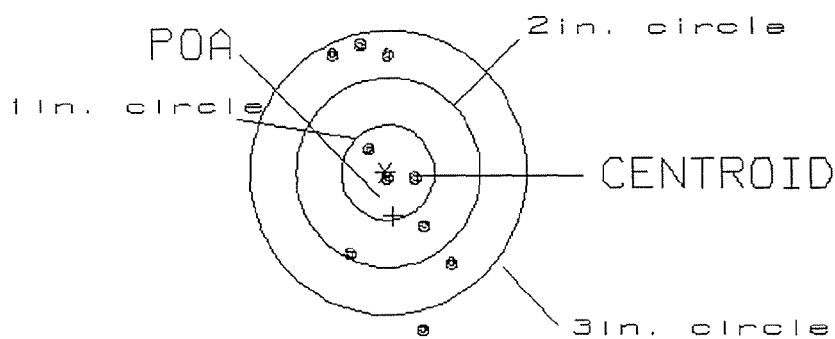


PATTERN #: 1
 POA TO CENTROID: .466
 MIN RADIUS : .022
 MEAN RADIUS : .919
 MAX RADIUS : 1.691
 CENTROID X : -.090
 CENTROID Y : .458

21 Jun 1999

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6348731

CENTERFIRE PATTERN # 1



OF SHOTS= 10

IN CIRCLE

HS= 1.28

3

VS= 2.99

5

GS= 3.07

9

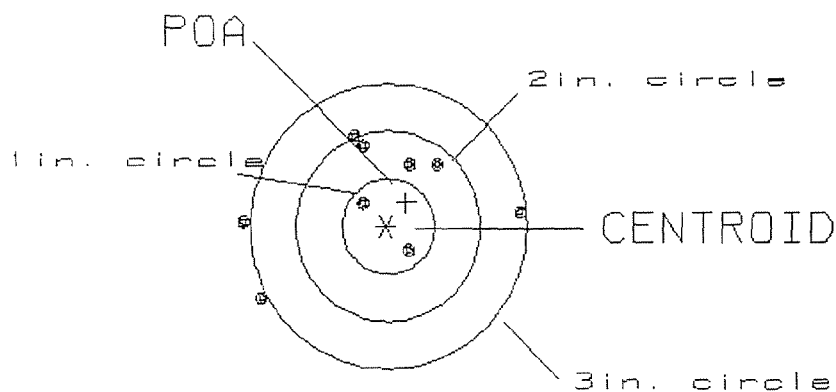
PATTERN #: ☐ 2 ☐

POA TO CENTROID: .336
 MIN RADIUS : .295
 MEAN RADIUS : 1.151
 MAX RADIUS : 2.984
 CENTROID X : -.224
 CENTROID Y : -.250

21 Jun 1999

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6348731

CENTERFIRE PATTERN # 2



OF SHOTS= 10

IN CIRCLE

HS= 3.07

2

VS= 3.49

6

GS= 4.04

7

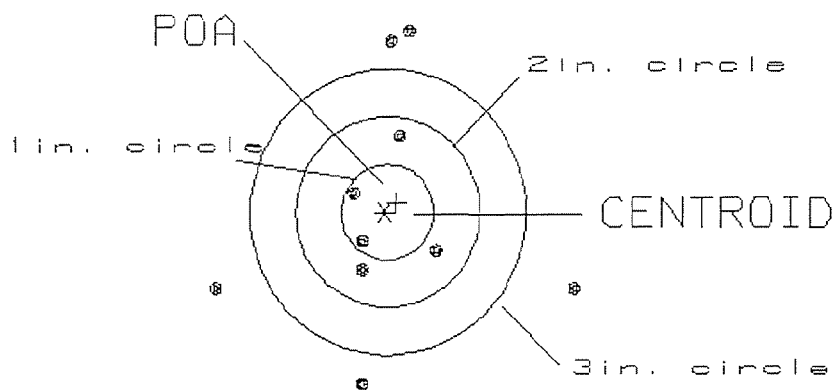
PATTERN #: 3

POA TO CENTROID: .161
 MIN RADIUS : .409
 MEAN RADIUS : 1.271
 MAX RADIUS : 2.191
 CENTROID X : -.127
 CENTROID Y : -.099

21 Jun 1999

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6348731

CENTERFIRE PATTERN # 3



OF SHOTS= 10

IN CIRCLE

HS= 3.90

2

VS= 3.71

5

GS= 3.90

5

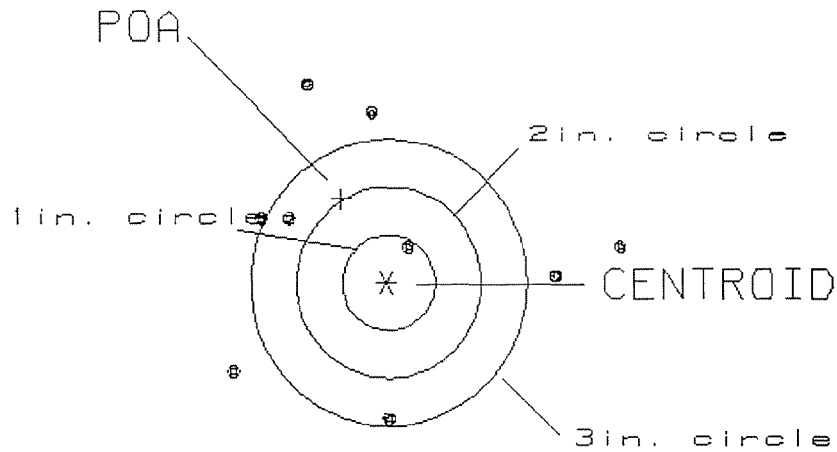
PATTERN #: 4

POA TO CENTROID: 1.004
 MIN RADIUS : .452
 MEAN RADIUS : 1.869
 MAX RADIUS : 3.752
 CENTROID X : .492
 CENTROID Y : -.875

21 Jun 1999

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6348731

CENTERFIRE PATTERN # 4



OF SHOTS= 10

IN CIRCLE

HS= 4.14
 VS= 5.74
 GS= 5.97

1
 1
 3

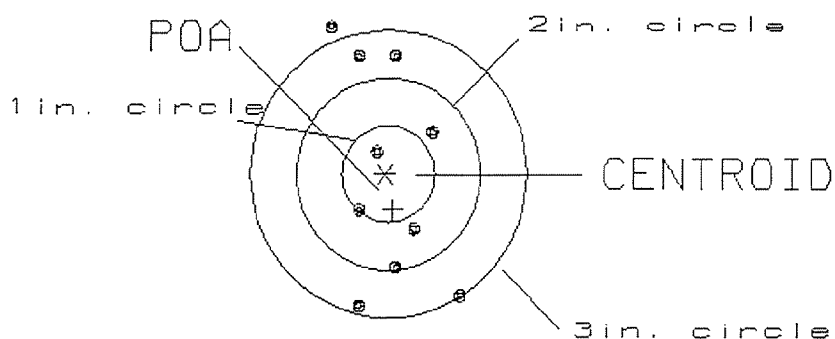
PATTERN #: ☐ 5 ☐

POA TO CENTROID: .377
 MIN RADIUS : .288
 MEAN RADIUS : .998
 MAX RADIUS : 1.652
 CENTROID X : -.078
 CENTROID Y : .368

21 Jun 1999

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6348731

CENTERFIRE PATTERN # 5



OF SHOTS= 10

IN CIRCLE

HS= 1.41

2

VS= 2.67

4

GS= 3.13

9




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

MODEL 700™ H24

SERIAL NO.
C6348731

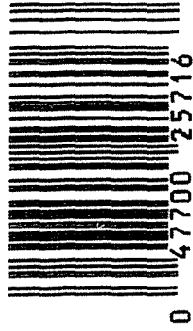
ORDER NO.
5716

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



5716 C6348731

UPC



RC-15
Replaced

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6348731

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	10-9	89	RW
600	Proof	10-9	89	A
607	Check Headspace	10-9	89	RW
610	Dis-assemble Gun	10-9	89	RW
612	Magnaflux Barrel Action	REJECTED	11/3/89	KCR
	Magnaflux Bolt		11/2/89	KCR
615	Rollmark Caliber			
.7	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			
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head			
	C) Inspect Ejector Hole for Chamfer			
	D) Oil Firing Pin Ass'y			
	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						
	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						
	C) Function						
660	Pack						

EIAQ

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6348731

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		11-2 89	RW
600	Proof		11-2 89	AT
607	Check Headspace		11-2 89	RW
610	Dis-assemble Gun		11-2 89	RW
612	Magnaflux Barrel Action		11-9-89	KCR
	Magnaflux Bolt		11-9-89	KCR
615	Rollmark Caliber		11/9/89	CS
17	Drill and Tap Sight Holes		11 9 89	7B
618	Polish Barrel RB		11 9 89	BT
620	Apply Coatings (Barrel Action)		11-11-89	TJA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		1/8/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		1/8/90	RW
	C) Inspect Ejector Hole for Chamfer		1/8/90	RW
	D) Oil Firing Pin Ass'y		1/8/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		10/24/90	QSS

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			1-10-90	JS
	G) Safety Off Force	3	3	3			1-10-90	JS
	H) Trigger Pull Test & Retainability						10/10/90	JS
	I) Firing Pin Indent	.020	.020	.020			1-10-90	JS
	J) Assemble Stock						1/10/90	RW
	K) Assemble Swivel Studs						3/15/90	WB
	L) Attach Front and Rear Sight Assemblies						1/26/90	RW
	M) Iron Sight Alignment						1/26/90	RW
	N) Detach Front & Rear Sights & place in numbered container						1/26/90	RW
	O) Attach Scope to Rifle						3/2/90	RW
	P) Detach & Attach Scope 20 Times						3/2/90	RW
640	Gallery Target & Test						3-5-90	J.S. Temp. Help
	A) Time							
	B) Malfunctions							
	C) Pierced Primers							
	D) Optical Clarity of Scope							
645	Inspect for Live Ammo							
655	Final Inspection							
	A) Headspace						16/10/90	JS
	B) Trigger Pull	2.15	2.43	2.66	2.68	2.73	16/10/90	JS
	C) Function						16/10/90	JS
660	Pack						19/10/90	JS

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6348731

DATE 18 Jan 90

TESTER 928

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	257	231	239	215	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	245	241	222	243	
PULL #3	233	235	237	266	
PULL #4	229	213	223	268	
PULL #5	230	212	247	273	
TOTAL	1194	1132	1168	1265	
AVG.	2388	2264	2336	253	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	353	346		
PULL #2	344	352		
PULL #3	353	347		
PULL #4	314	348		
PULL #5	343	350		
TOTAL	1707	1743		
AVG.	3414	3486		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.00	3.97		3.87
PULL #2	4.04	3.98		3.99
PULL #3	4.04	4.03		3.98
PULL #4	4.03	3.89		3.95
PULL #5	4.00	3.67		3.98
TOTAL	20.11	19.54		19.77
AVG.	4.022	3.908		3.954

MOD. _____ GA. CAL. _____ GUN # C6348731

#	DATE	MALFUNCTION/DEFECT	ASSEM. #
TEST	1st		
T+A	5/22/90	Bolt hits stock when closing	
	2nd	Fire Bolt 5/10 T	3/15/90 RW
	3rd		
	4th		
		FUNCTION	RD 6654 Rev 1

TEST INIT. ACTION TO CORRECT		ASSEM. #
PROOF		
TEST		
TGT		
PROOF		
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6348731
5 Mar 1990

CENTROIDAL DISTANCES

0 TO	1	.199832
1 TO	2	.988661
1 TO	3	.502757
1 TO	4	.846463
1 TO	5	.913585

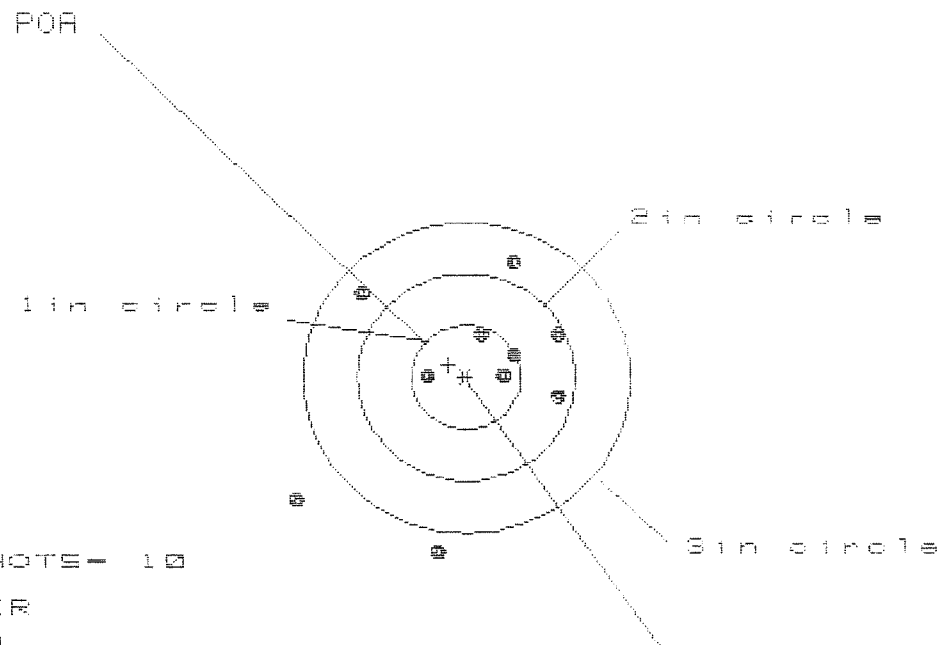
2
4 3 5 (----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .4708
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .125
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .487112
THE AMR FOR THIS RIFLE IS: 1.132

5 Mar 1998

FILE:/PATTERNING/CENTERFIRE_PATT/06948731

CENTERFIRE PATTERNS # 1



OF SHOTS - 10

IN CIR

1in = 3

2in = 6

3in = 8

HS = 2.411

VS = 2.745

GS = 3.050

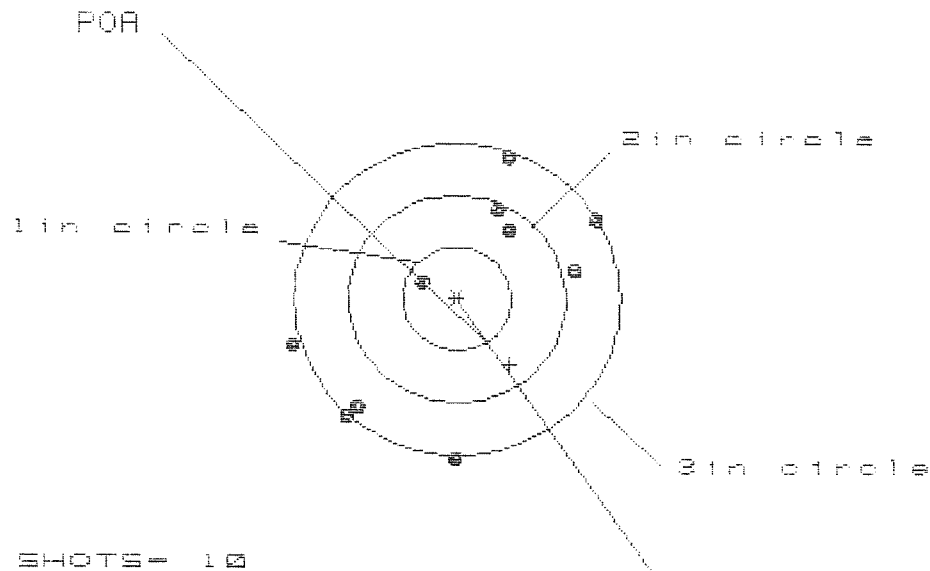
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.859	.687	.637
MINIMUM X	-1.552	-1.114	-1.164
MAXIMUM Y	1.092	.960	.737
MINIMUM Y	-1.653	-1.785	-1.533
CENTROID X	.162	.334	.384
CENTROID Y	-.117	.015	.238
POA TO CENTROID in.	.199	.334	.451
MIN RADIUS	.315	.179	.148
MEAN RADIUS	.945	.767	.607
MAX RADIUS	1.951	1.828	1.260
HORIZONTAL SPREAD	2.411	1.801	1.801
VERTICAL SPREAD	2.745	2.745	1.270
EXTREME SPREAD	3.050	2.834	2.658
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	8		

5 Mar 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C8348731

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 3

3 in = 6

HS= 2.769

VS= 2.825

GS= 2.984

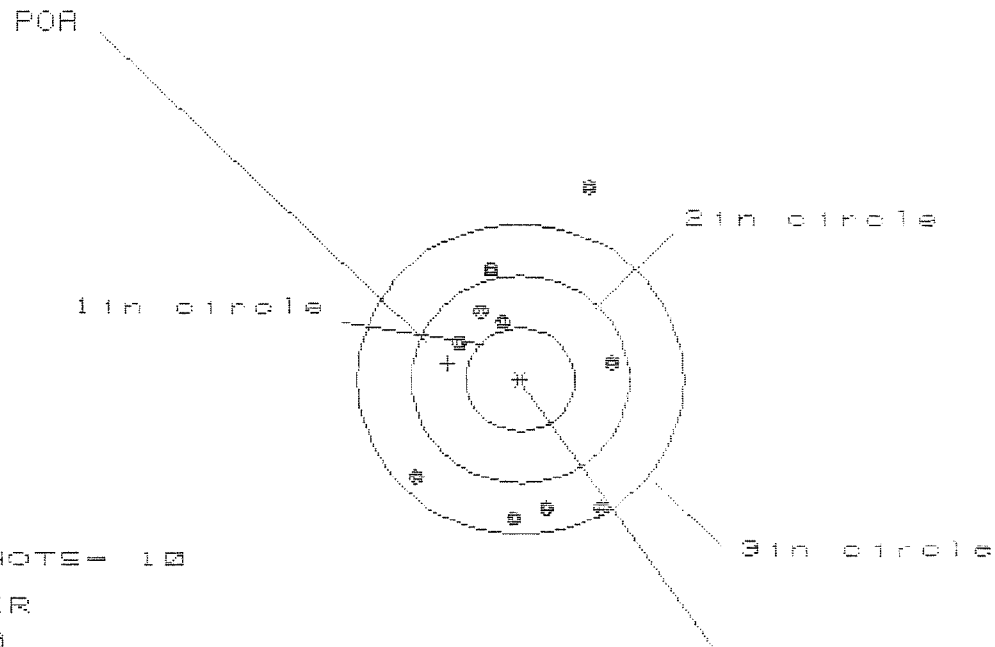
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.271	1.105	.952
MINIMUM X	:	-1.498	-1.223	-1.203
MAXIMUM Y	:	1.328	1.285	1.138
MINIMUM Y	:	-1.497	-1.540	-1.687
CENTROID X	:	-.481	-.315	-.162
CENTROID Y	:	.634	.677	.824
POA TO CENTROID in.	:	.796	.747	.839
MIN RADIUS	:	.352	.496	.492
MEAN RADIUS	:	1.207	1.151	1.032
MAX RADIUS	:	1.547	1.692	1.712
HORIZONTAL SPREAD	:	2.769	2.328	2.155
VERTICAL SPREAD	:	2.825	2.825	2.825
EXTREME SPREAD	:	2.984	2.974	2.963
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		6	

5 Mar 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6348731

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 6

2in = 4

3in = 9

HS= 1.741

VS= 3.184

GS= 3.258

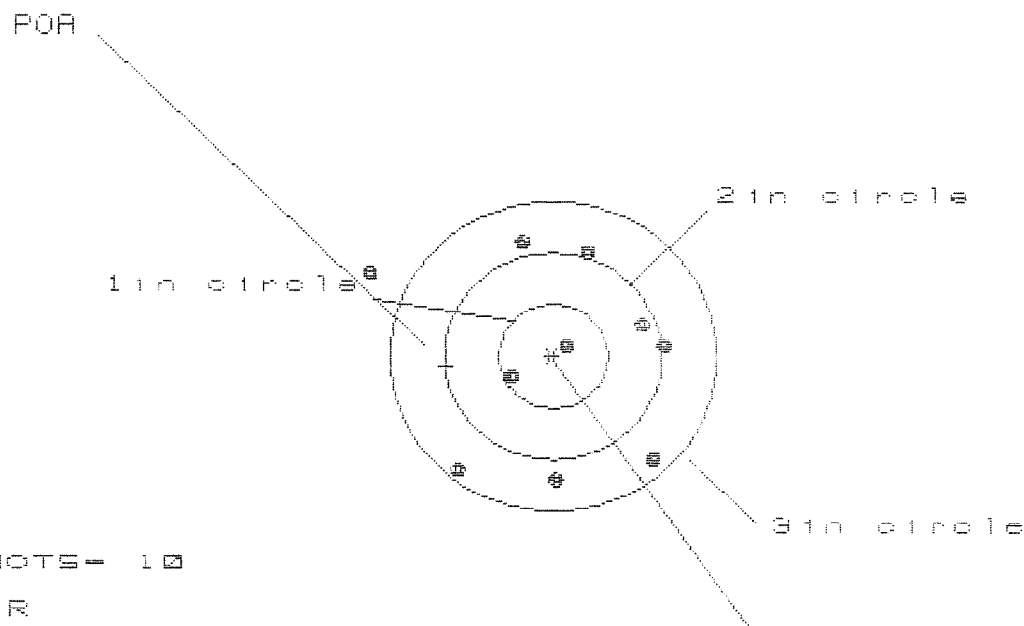
CENTROID *

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.801	.869	.975
MINIMUM X	:	-.940	-.872	-.766
MAXIMUM Y	:	1.815	1.293	1.169
MINIMUM Y	:	-1.369	-1.167	-1.291
CENTROID X	:	.663	.595	.489
CENTROID Y	:	-.159	-.361	-.237
POA TO CENTROID in.	:	.682	.696	.543
MIN RADIUS	:	.587	.769	.613
MEAN RADIUS	:	1.127	1.045	.984
MAX RADIUS	:	1.916	1.309	1.294
HORIZONTAL SPREAD	:	1.741	1.741	1.741
VERTICAL SPREAD	:	3.184	2.460	2.460
EXTREME SPREAD	:	3.259	2.514	2.467
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		9	

5 Mar 1998

FILE:/PATTERNING/CENTERFIRE_PATT/06348731

CENTERFIRE PATTERNS # 4



OF SHOTS - 10

IN CIR

1 in = 2

2 in = 3

3 in = 8

HS = 2.718

VS = 2.286

GS = 3.122

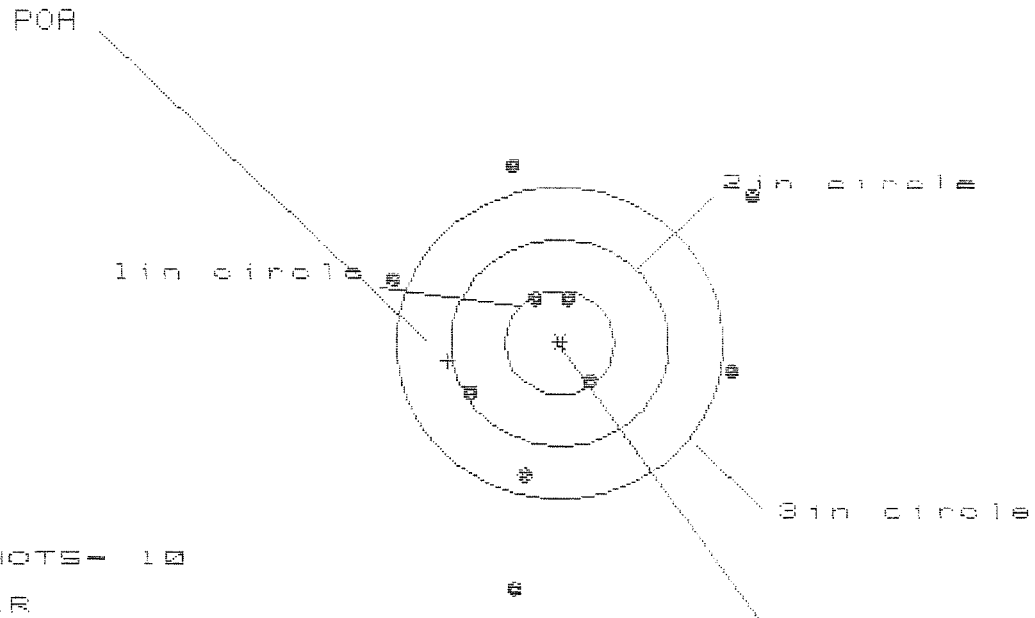
CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.056	.872	.736
MINIMUM X	:	-1.662	-1.082	-1.740
MAXIMUM Y	:	1.134	1.219	1.098
MINIMUM Y	:	-1.152	-1.067	-1.188
CENTROID X	:	.982	1.166	1.301
CENTROID Y	:	.093	.008	.129
POA TO CENTROID in.	:	.986	1.166	1.308
MIN RADIUS	:	.159	.166	.184
MEAN RADIUS	:	1.044	.941	.857
MAX RADIUS	:	1.828	1.451	1.258
HORIZONTAL SPREAD	:	2.718	1.954	1.477
VERTICAL SPREAD	:	2.286	2.286	2.286
EXTREME SPREAD	:	3.122	2.427	2.427
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		9	

5 Mar 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6348731

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 4

3 in = 5

HE= 3.312

VS= 4.100

GS= 4.324

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.741	1.695	1.758
MINIMUM X	:	-1.571	-1.617	-1.405
MAXIMUM Y	:	1.775	1.517	1.663
MINIMUM Y	:	-2.325	-1.509	-1.363
CENTROID X	:	1.028	1.074	.862
CENTROID Y	:	.174	.432	.286
POA TO CENTROID in.	:	1.042	1.157	.908
MIN RADIUS	:	.438	.216	.280
MEAN RADIUS	:	1.335	1.198	1.073
MAX RADIUS	:	2.361	2.058	1.802
HORIZONTAL SPREAD	:	3.312	3.312	3.163
VERTICAL SPREAD	:	4.100	3.026	3.026
EXTREME SPREAD	:	4.324	3.402	3.296
NUMBER IN ONE INCH CIRCLE =			3	
NUMBER IN TWO INCH CIRCLE =			4	
NUMBER IN THREE INCH CIRCLE =			5	