

E 670 3484

Repair Inquiry

Repair Number: RE00141249

Serial: E6703484 Model M24 SWS Center Fire
Caliber: 7.62 NATO Produced: 10/29/2001

Repairman:

Status:

Closed 2/5/2008 10:17:01 AM

Verify Repair

Address Information

Customer:

☒ Received From

Return To:

☐ Received From

Name: DODAAC: W91L3M

DODAAC: W91L3M

Address 1: WOODA FSB BAGRAM AFLD

WOODA FSB BAGRAM AFLD

Address 2: SMALL ARMS SUPPORT

PO Box:

SMALL ARMS SUPPORT

PO Box:

City: BAGRAM APO

BAGRAM APO

State: AF

Zip Code: 09354

Country: AE

State: AF

Zip Code: 09354

Country: AE

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
A026	Scope	1
A057	Fit and Rear Sgt Base	1

Repair Search

Refresh

Close

nagletj

2/7/2008

4:20 PM

NUM



Serial Number: E6703484

Model: M24 SWS



RE00141249

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: E6703484.__0

FILE DATE AND TIME: 03/03/2008 10:03

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.077
The Average Y Centroid of the Five Target Set:	-0.003
The Average Point of Impact of the Five Target Set:	0.077
The Average Mean Radius of the Five Target Set:	0.664
The Distance from POA to Centroid Target #1:	0.126
The Distance from Centroid Target #2 to Centroid Target #1:	0.196
The Distance from Centroid Target #3 to Centroid Target #1:	0.122
The Distance from Centroid Target #4 to Centroid Target #1:	0.218
The Distance from Centroid Target #5 to Centroid Target #1:	0.163

SERIAL NUMBER: E6703484. 0

TARGET NUMBER: 1

FILE DATE: 03/03/2008

FILE TIME: 10:03

POINT#	X	Y
1:	0.921	0.374
2:	0.713	0.420
3:	-0.190	0.511
4:	0.145	0.299
5:	-0.157	-0.552
6:	-0.265	-0.032
7:	-0.547	0.118
8:	-0.861	-0.400
9:	-0.780	-0.781
10:	-0.197	0.370

X CENTROID: -0.122

Y CENTROID: 0.033

POA TO CENTROID: 0.126

HORZ SPREAD: 1.782

VERT SPREAD: 1.292

GROUP SPREAD: 2.056

MIN RADIUS: 0.157

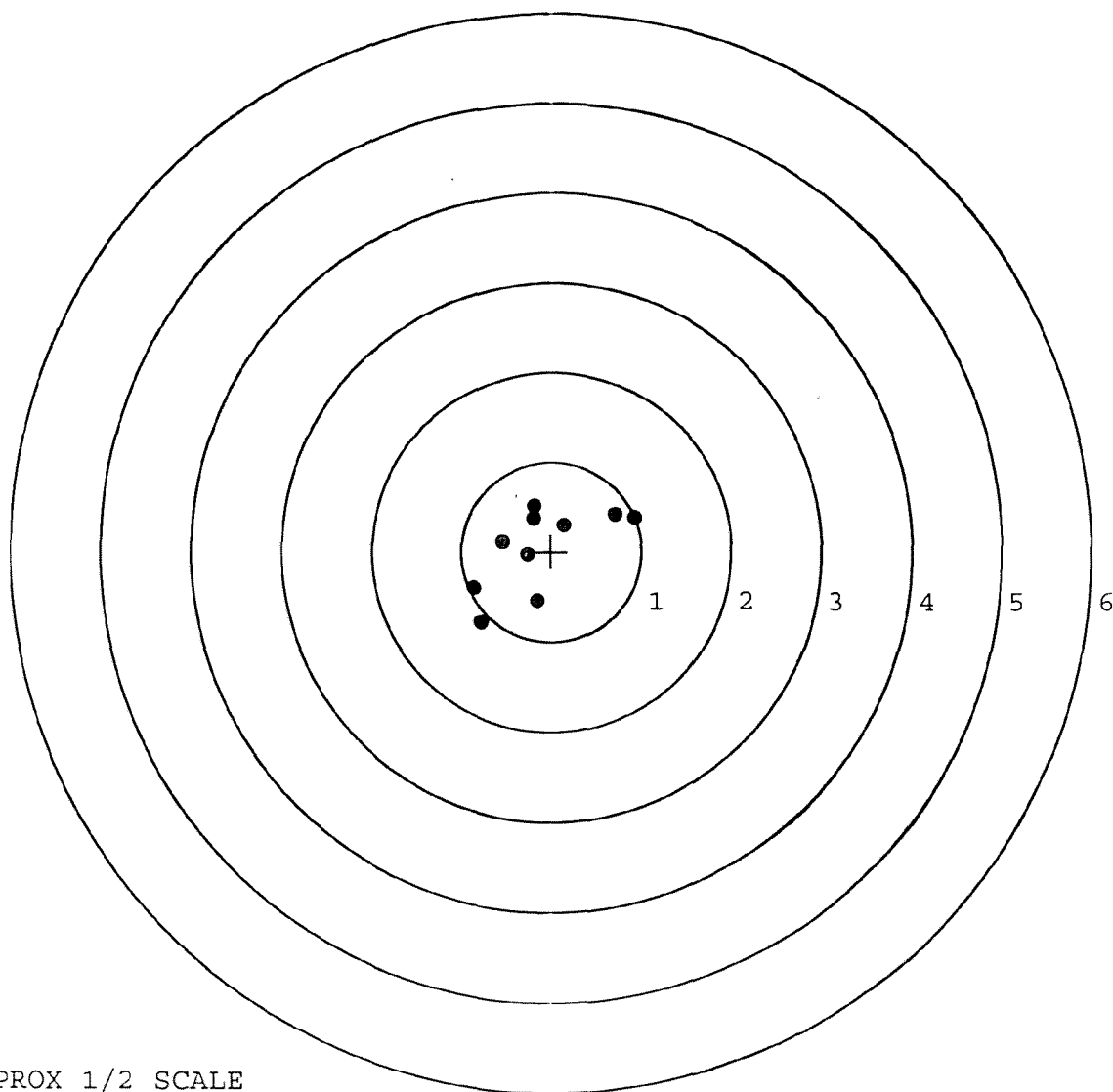
MAX RADIUS: 1.097

MEAN RADIUS: 0.630

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10

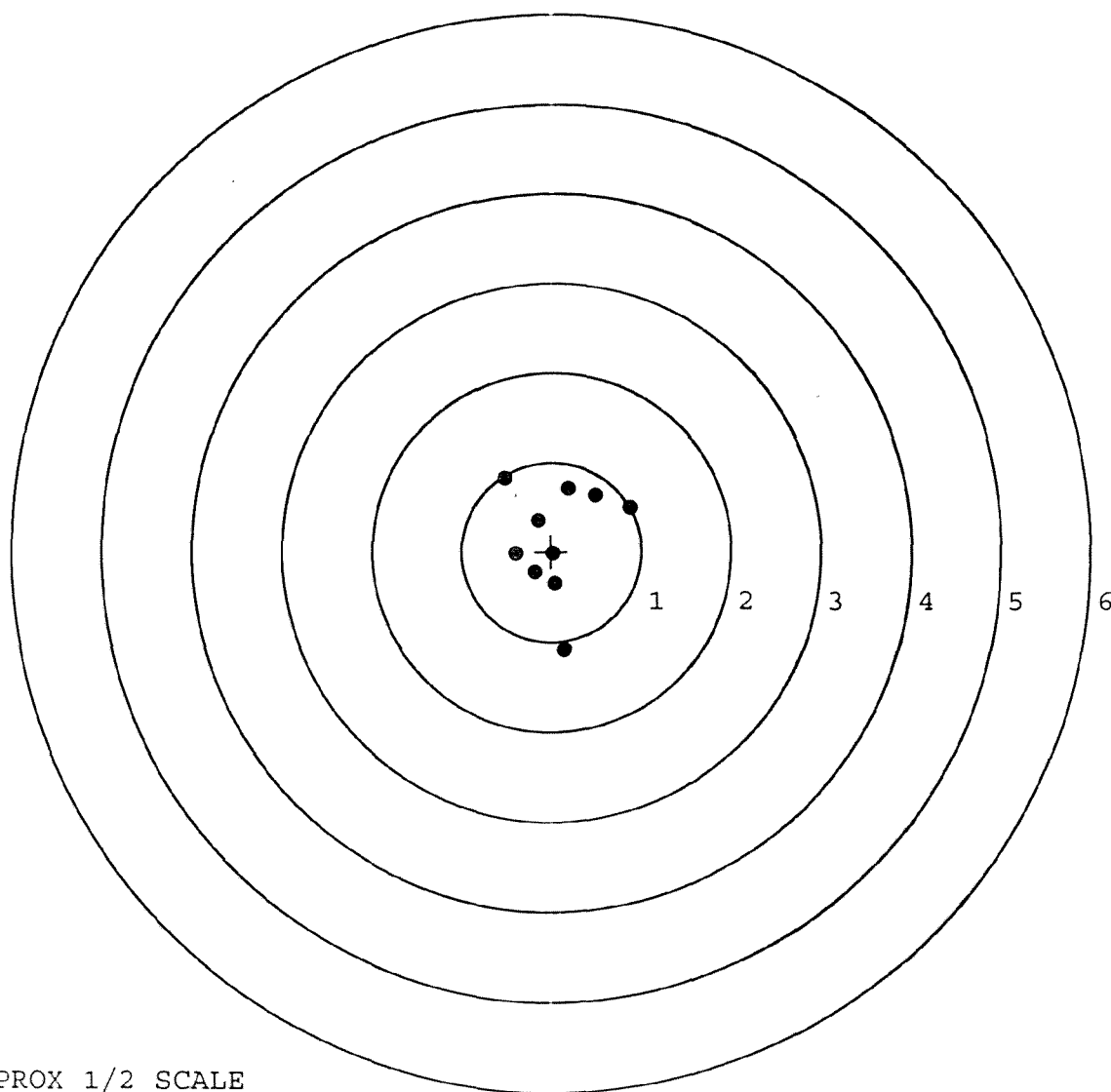


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: E6703484. _0
TARGET NUMBER: 2
FILE DATE: 03/03/2008
FILE TIME: 10:03

POINT#	X	Y
1:	0.147	-1.095
2:	0.874	0.488
3:	0.487	0.630
4:	0.189	0.706
5:	-0.517	0.823
6:	-0.153	0.351
7:	0.025	-0.024
8:	-0.399	-0.020
9:	0.041	-0.364
10:	-0.186	-0.238

X CENTROID: 0.051
Y CENTROID: 0.126
POA TO CENTROID: 0.136
HORZ SPREAD: 1.391
VERT SPREAD: 1.918
GROUP SPREAD: 2.030
MIN RADIUS: 0.152
MAX RADIUS: 1.224
MEAN RADIUS: 0.614
IN 1 IN DIAMETER: 5
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

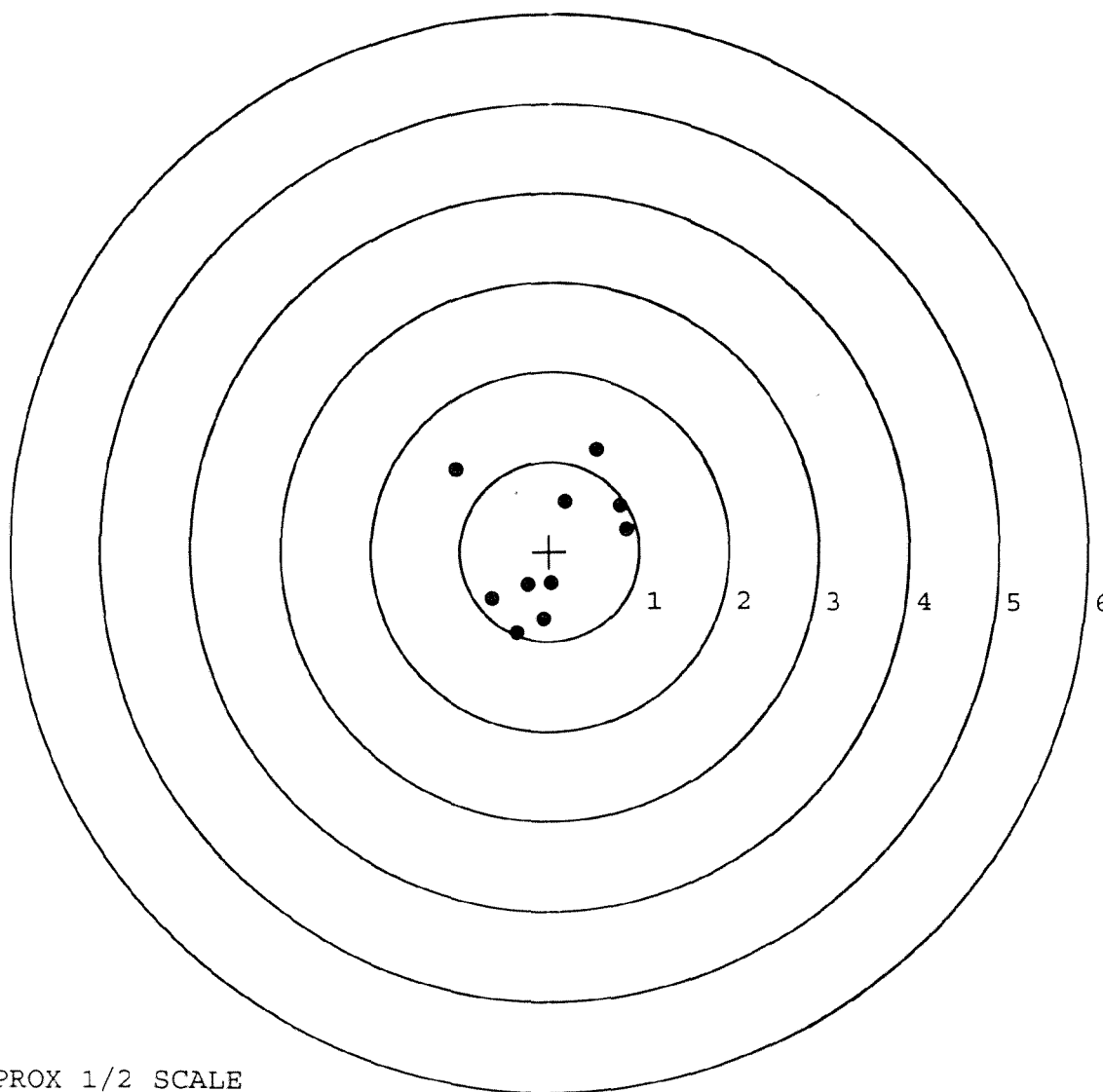


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: E6703484. __0
TARGET NUMBER: 3
FILE DATE: 03/03/2008
FILE TIME: 10:03

POINT#	X	Y
1:	0.849	0.251
2:	0.785	0.519
3:	0.179	0.558
4:	0.515	1.131
5:	-1.042	0.910
6:	0.026	-0.358
7:	-0.642	-0.532
8:	-0.070	-0.757
9:	-0.361	-0.912
10:	-0.242	-0.375

X CENTROID: 0.000
Y CENTROID: 0.043
POA TO CENTROID: 0.044
HORZ SPREAD: 1.891
VERT SPREAD: 2.043
GROUP SPREAD: 2.003
MIN RADIUS: 0.402
MAX RADIUS: 1.355
MEAN RADIUS: 0.847
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 10

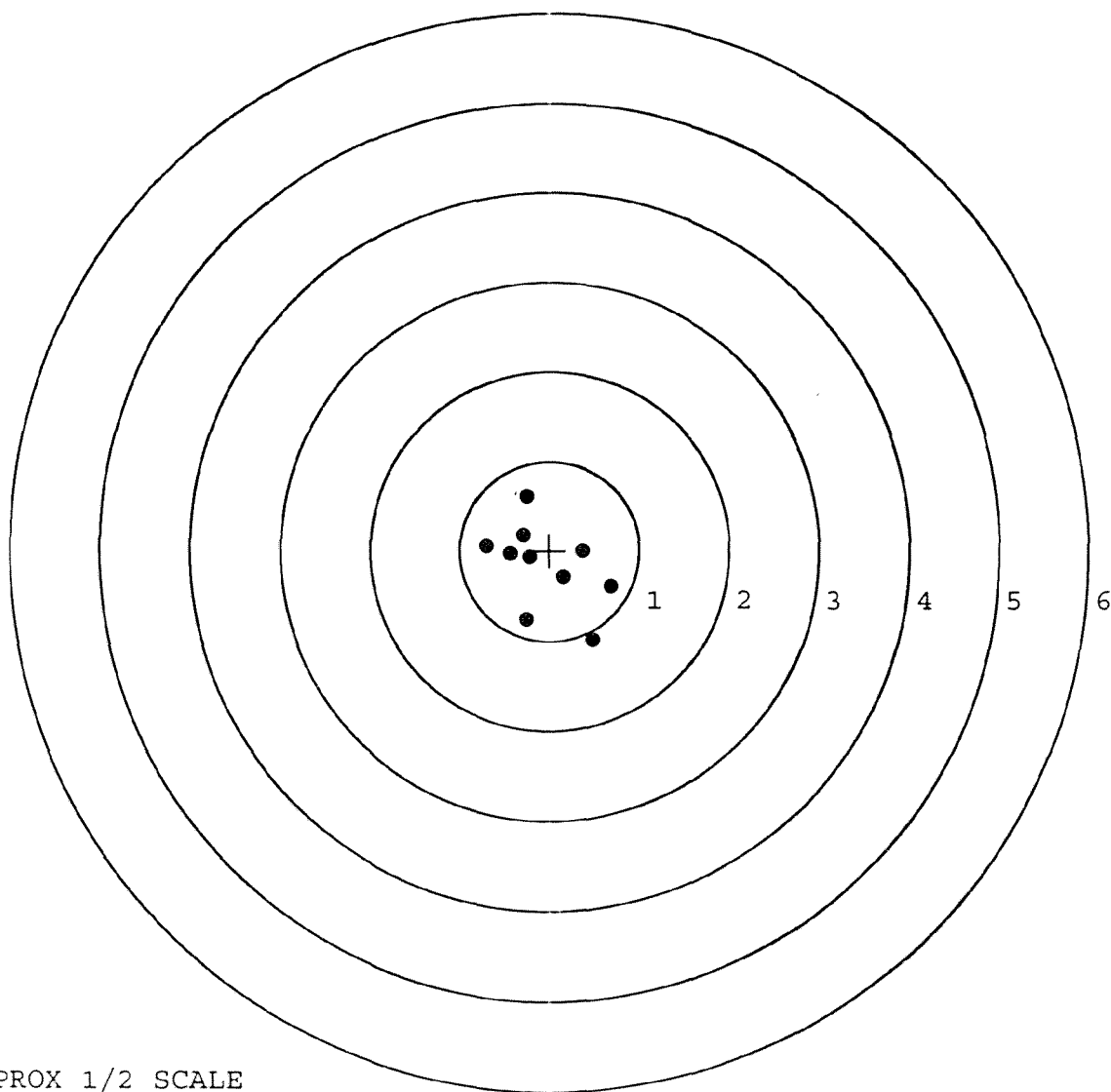


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: E6703484. __0
TARGET NUMBER: 4
FILE DATE: 03/03/2008
FILE TIME: 10:03

POINT#	X	Y
1:	0.475	-0.990
2:	0.684	-0.403
3:	0.370	-0.013
4:	0.158	-0.295
5:	-0.262	-0.761
6:	-0.259	0.613
7:	-0.221	-0.075
8:	-0.294	0.179
9:	-0.706	0.058
10:	-0.439	-0.040

X CENTROID: -0.049
Y CENTROID: -0.173
POA TO CENTROID: 0.180
HORZ SPREAD: 1.390
VERT SPREAD: 1.603
GROUP SPREAD: 1.763
MIN RADIUS: 0.197
MAX RADIUS: 0.971
MEAN RADIUS: 0.560
IN 1 IN DIAMETER: 5
IN 2 IN DIAMETER: 10
in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: E6703484. 0

TARGET NUMBER: 5

FILE DATE: 03/03/2008

FILE TIME: 10:03

POINT#	X	Y
1:	0.470	0.553
2:	-0.395	0.704
3:	-0.493	0.601
4:	-0.323	0.304
5:	-0.353	0.067
6:	-0.400	-0.400
7:	-1.053	-0.607
8:	0.230	-0.314
9:	0.541	-0.744
10:	-0.882	-0.607

X CENTROID: -0.266

Y CENTROID: -0.044

POA TO CENTROID: 0.269

HORZ SPREAD: 1.594

VERT SPREAD: 1.448

GROUP SPREAD: 1.724

MIN RADIUS: 0.141

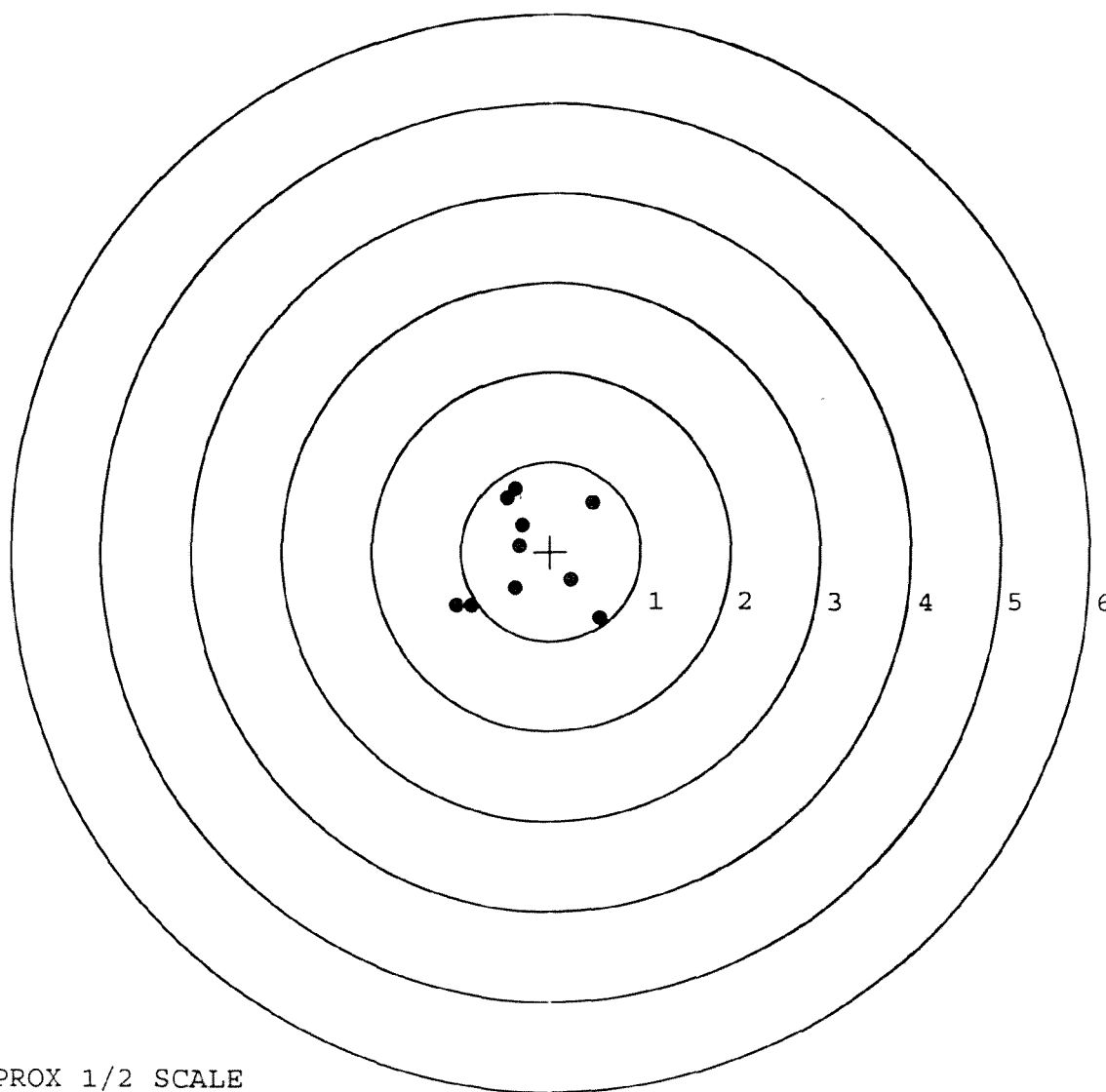
MAX RADIUS: 1.068

MEAN RADIUS: 0.670

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

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

R & E NUMBER		<u>00141249</u>	
SERIAL NUMBER		<u>E6703484 E6703484</u>	
LOG-IN DATE		<u>2-5-08</u>	

OPERATION #	OPERATION NAME	DATE	INITIAL
500	DIS-ASSEMBLE GUN	2-20-08	RT
505	RE-BARREL	2-20-08	RT
560	ASSEMBLE	2-20-08	RT
600	PROOF	2-20-08	TRW
605	CHECK HEADSPACE	2-20-08	TRW
610	DIS-ASSEMBLE GUN		
612	MAGNAFLUX	2/21/08	unus
510	DRILL AND TAP	2-21-08	Fm
615	ROLLMARK CALIBER	2-21-08	CW
618	ROTO-BLAST	2-22-08	DG
620	APPLY COATINGS	2-26-08	CM
625	FINAL ASSEMBLY	2-28-08	RT
640	FUNCTION TEST AND	2-29-08	TRW
650	TARGET	2-29-08	TRW
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
670	FINAL INSPECTION	2-29-08	RP
	A) HEADSPACE	3-3-08	DA
		3-3-08	DA
	B) TRIGGER PULL	2.50 2.41 2.40 2.45 2.40 3-3-08	DA
680	F) SAFETY ON FORCE	55 55 55 3-3-08	DA
	G) SAFETY OFF FORCE	25 2.5 2.5 3-3-08	DA
	I) FIRING PIN INDENT	.022 .023 .022 3-3-08	DA
690	PACK	3-4-08	Fm

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: **RE00111016**

Serial: E6703484 Model M24 SWS Center Fire
Caliber: 7.62 NATO

Repairman:

Verify Repair: **High Priority**

Status: Closed 4/12/2006 11:28:58 AM

Address Information

Customer:

Received From:

Return To:

Received From:

Name: HHC 1ST BN <ABN> 508TH IN

HHC 1ST BN <ABN> 508TH IN

Address 1: UNIT 31401 BOX 53

UNIT 31401 BOX 53

Address 2: PO Box:

PO Box:

City: APO

APD

State: CT Zip Code: 09630

Country: US

State: CT Zip Code: 09630

Country: US

FFL:

Contact / Condition

Problems

Estimate

History / Status

Shipping / Billing

Contact Information

Phone: NA

Fax:

Email:

Comments:

Received Condition

Fair

Condition Notes:

CSR Notes:

Accessories Received

Code	Desc	Qty
A007	With Stud	3
A017	Scope Base	1
A055	Deployment Kit	1
A057	Fit and Rear Sgt Base	1
C000	SCOPE CASE	1

Repair Search

Refresh

Close

nagletj

4/12/2006

1:16 PM

C&P's

NUM

INS

SCRL

start

51

A...

31

M...

P...

P...

S...

1:16 PM

Serial Number: **E6703484**

Model: **M24 SWS**



RE00111016

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: E6703484.__0

FILE DATE AND TIME: 05/01/2006 16:27

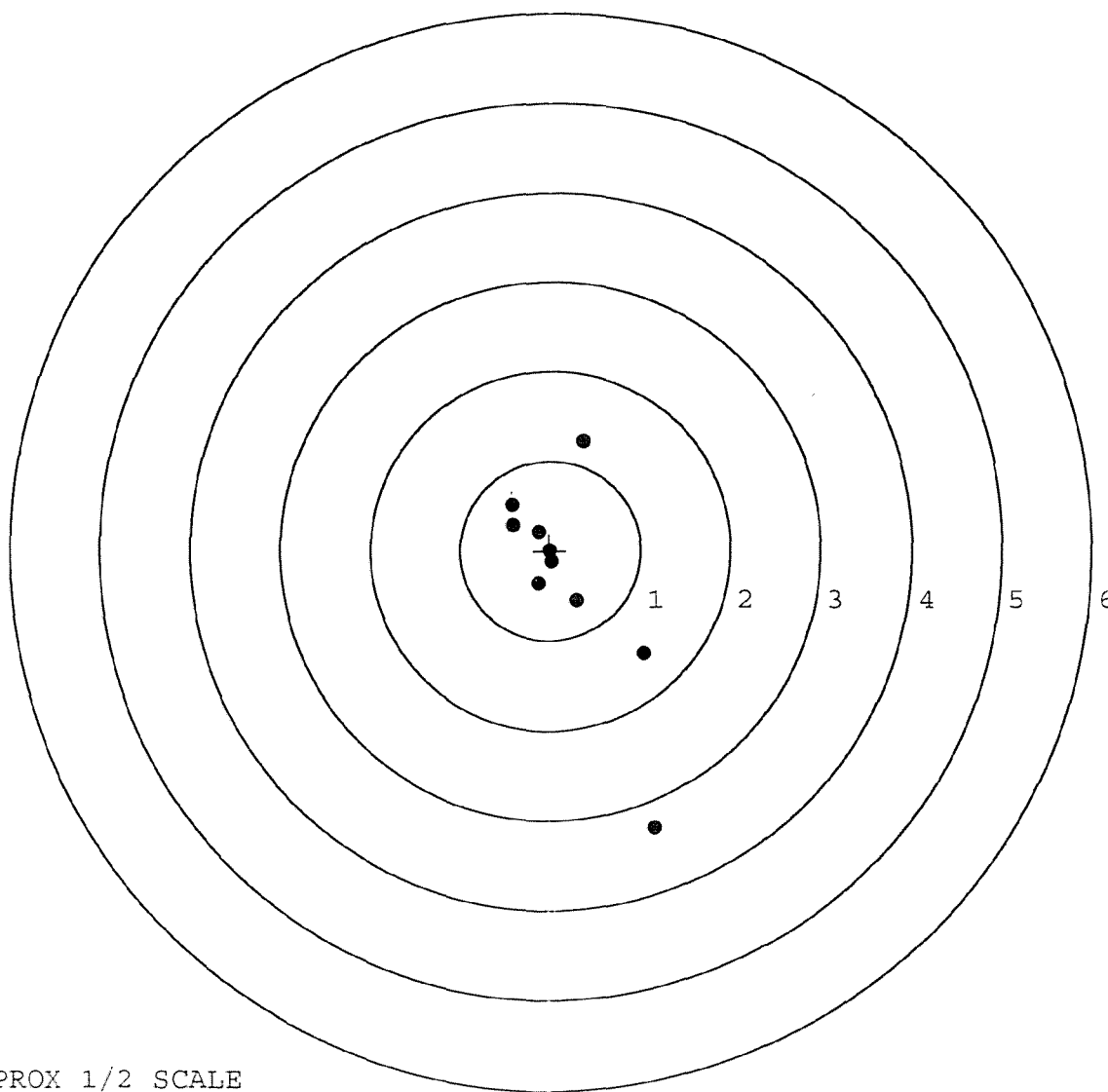
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.100
The Average Y Centroid of the Five Target Set:	-0.184
The Average Point of Impact of the Five Target Set:	0.209
The Average Mean Radius of the Five Target Set:	0.741
The Distance from POA to Centroid Target #1:	0.357
The Distance from Centroid Target #2 to Centroid Target #1:	0.173
The Distance from Centroid Target #3 to Centroid Target #1:	0.380
The Distance from Centroid Target #4 to Centroid Target #1:	0.274
The Distance from Centroid Target #5 to Centroid Target #1:	0.075

SERIAL NUMBER: E6703484. __0
TARGET NUMBER: 1
FILE DATE: 05/01/2006
FILE TIME: 16:27

POINT#	X	Y
1:	-0.424	0.507
2:	-0.414	0.286
3:	-0.129	0.209
4:	0.003	0.000
5:	-0.133	-0.369
6:	0.297	-0.566
7:	0.370	1.215
8:	1.039	-1.159
9:	1.162	-3.090
10:	0.023	-0.125

X CENTROID: 0.179
Y CENTROID: -0.309
POA TO CENTROID: 0.357
HORZ SPREAD: 1.586
VERT SPREAD: 4.305
GROUP SPREAD: 4.377
MIN RADIUS: 0.242
MAX RADIUS: 2.949
MEAN RADIUS: 0.935
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 6
in 3 IN DIAMETER: 8



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: E6703484. __0

TARGET NUMBER: 2

FILE DATE: 05/01/2006

FILE TIME: 16:27

POINT#	X	Y
1:	-0.442	0.133
2:	-0.280	0.131
3:	-0.487	-0.242
4:	-0.326	-0.496
5:	0.039	-0.306
6:	0.007	-0.219
7:	0.263	-0.015
8:	0.462	-0.273
9:	0.510	-1.016
10:	0.810	0.418

X CENTROID: 0.056

Y CENTROID: -0.189

POA TO CENTROID: 0.197

HORZ SPREAD: 1.297

VERT SPREAD: 1.434

GROUP SPREAD: 1.465

MIN RADIUS: 0.057

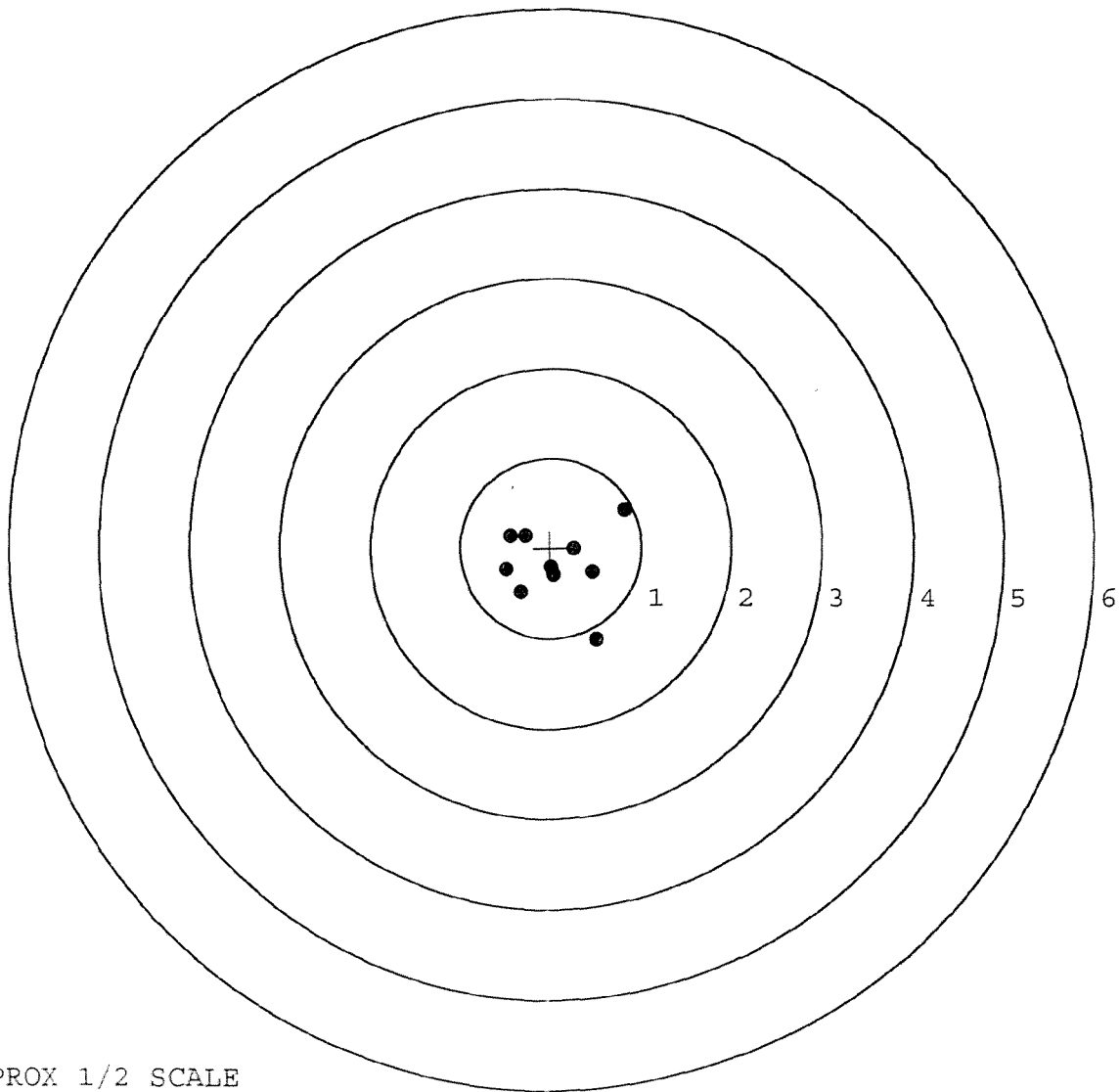
MAX RADIUS: 0.968

MEAN RADIUS: 0.486

IN 1 IN DIAMETER: 6

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10



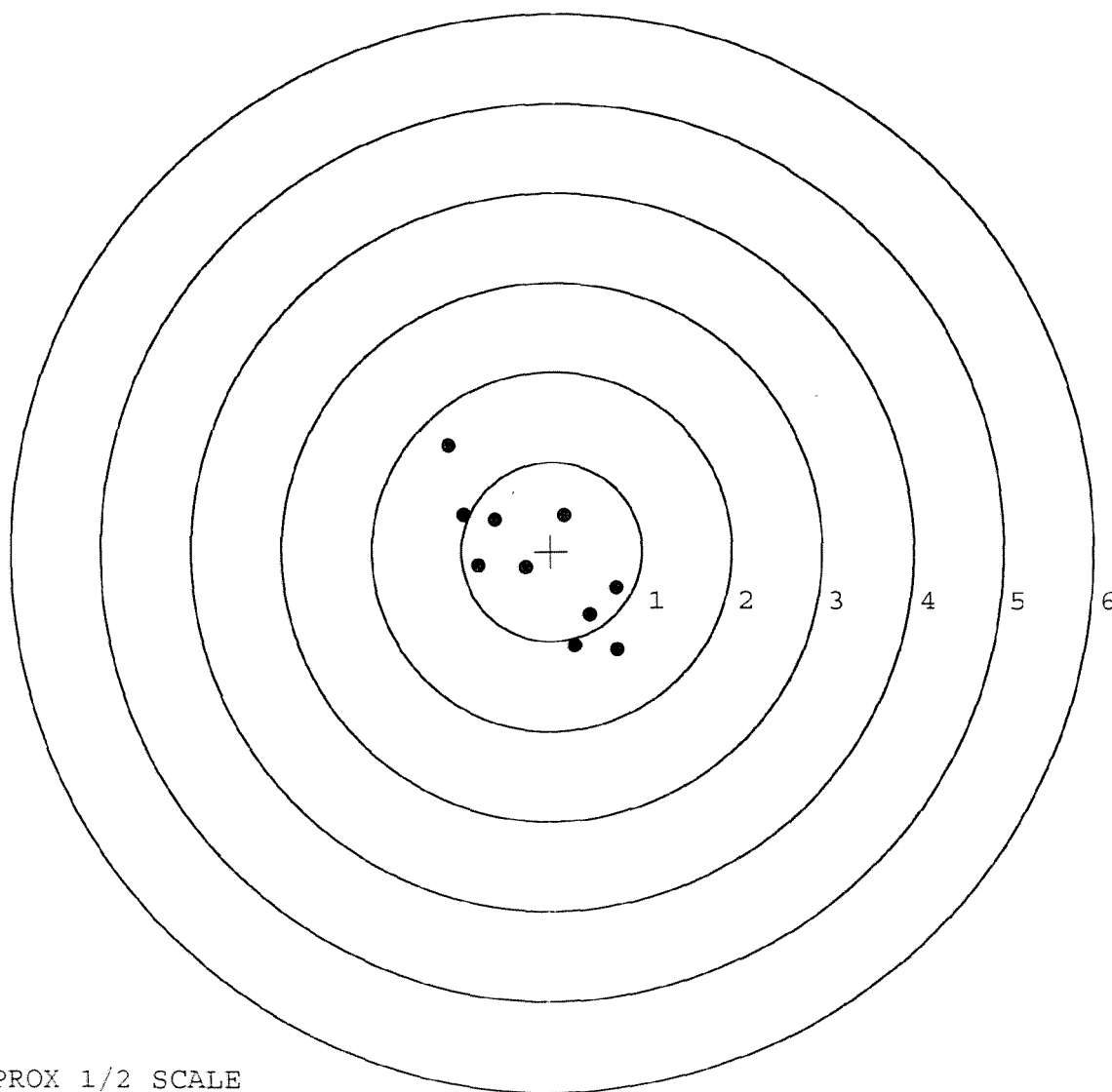
TARGET APPROX 1/2 SCALE

SERIAL NUMBER: E6703484. __0
TARGET NUMBER: 3
FILE DATE: 05/01/2006
FILE TIME: 16:27

POINT#	X	Y
1:	-0.286	-0.182
2:	-0.808	-0.163
3:	-0.628	0.354
4:	-0.975	0.400
5:	-1.152	1.175
6:	0.143	0.404
7:	0.714	-0.418
8:	0.432	-0.708
9:	0.272	-1.054
10:	0.737	-1.104

X CENTROID: -0.155
Y CENTROID: -0.130
POA TO CENTROID: 0.202
HORZ SPREAD: 1.889
VERT SPREAD: 2.279
GROUP SPREAD: 2.960
MIN RADIUS: 0.141
MAX RADIUS: 1.642
MEAN RADIUS: 0.878

IN 1 IN DIAMETER: 1
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 9

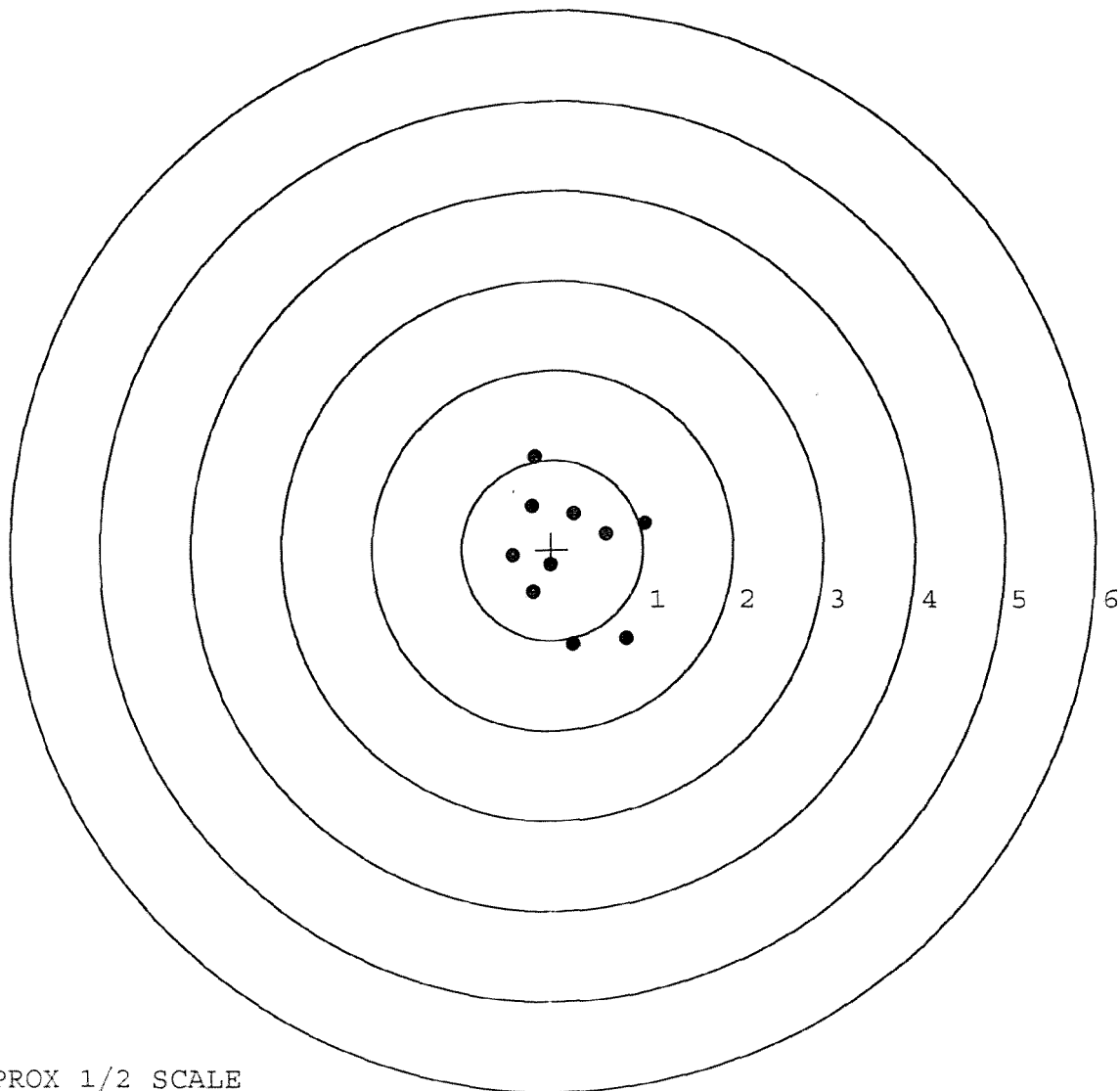


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: E6703484. __0
TARGET NUMBER: 4
FILE DATE: 05/01/2006
FILE TIME: 16:27

POINT#	X	Y
1:	-0.221	0.487
2:	0.243	0.397
3:	-0.198	1.034
4:	-0.436	-0.068
5:	-0.210	-0.467
6:	0.241	-1.047
7:	0.826	-0.989
8:	1.019	0.298
9:	0.588	0.174
10:	-0.020	-0.168

X CENTROID: 0.183
Y CENTROID: -0.035
POA TO CENTROID: 0.186
HORZ SPREAD: 1.455
VERT SPREAD: 2.081
GROUP SPREAD: 2.267
MIN RADIUS: 0.243
MAX RADIUS: 1.150
MEAN RADIUS: 0.720
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 10

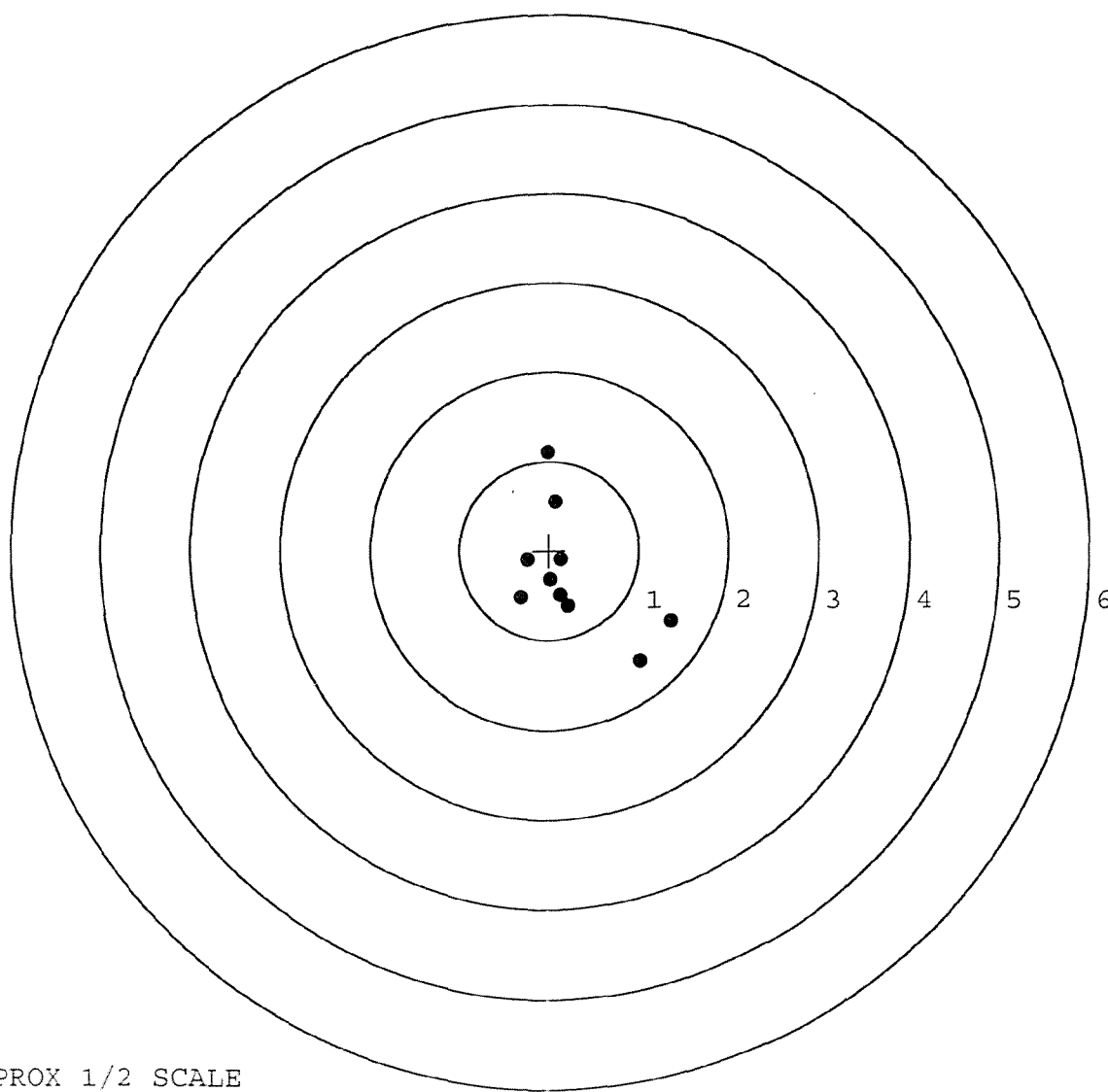


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: E6703484. __0
TARGET NUMBER: 5
FILE DATE: 05/01/2006
FILE TIME: 16:27

POINT#	X	Y
1:	-0.246	-0.105
2:	0.137	-0.105
3:	0.015	-0.331
4:	-0.317	-0.529
5:	0.213	-0.625
6:	0.132	-0.504
7:	1.014	-1.235
8:	1.357	-0.797
9:	0.068	0.542
10:	-0.025	1.105

X CENTROID: 0.235
Y CENTROID: -0.258
POA TO CENTROID: 0.349
HORZ SPREAD: 1.674
VERT SPREAD: 2.340
GROUP SPREAD: 2.560
MIN RADIUS: 0.182
MAX RADIUS: 1.388
MEAN RADIUS: 0.687
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

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

R & E NUMBER	111016		
SERIAL NUMBER	156703484		
LOG-IN DATE	4-12-06		
OPERATION #	OPERATION NAME	DATE	INITIAL
500	DIS-ASSEMBLE GUN	4-18-06	RTZ
505	RE-BARREL	4-20-06	RTZ
560	ASSEMBLE	4-20-06	RTZ
600	PROOF	4-20-06	RTZ
605	CHECK HEADSPACE	4-20-06	RTZ
610	DIS-ASSEMBLE GUN	4-20-06	RTZ
612	MAGNAFLUX	4/21/06	correct
510	DRILL AND TAP	4-21-06	TRW
615	ROLLMARK CALIBER	4-21-06	CW
618	ROTO-BLAST	4-21-06	LB
620	APPLY COATINGS	4/25/06	TRB
625	FINAL ASSEMBLY	4-27-06	RTZ
640	FUNCTION TEST AND	PASS FAIL	
650	TARGET	PASS FAIL	5-1-06 L.P.D.
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
670	FINAL INSPECTION	5-1-06	AC
	A) HEADSPACE	PASS FAIL	5-1-06 AC
	B) TRIGGER PULL	N/A AC	
		+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	
680	F) SAFETY ON FORCE	6 lbs 6 lbs 6 lbs AC	
		2 LBS MIN 10 LBS MAX	
	G) SAFETY OFF FORCE	4 lbs 4 lbs 4 lbs AC	
		2 LBS MAX	
	I) FIRING PIN INDENT	.021 .021 .021 AC	
		.020	
690	PACK	5-10-06 DR	

VERY IMPORTANT!
Instruction Book
enclosed to assure
safe use of this
rifle.

Remington®

MODEL 700™ M24
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO

Made in Union, NY Reg. U.S. Pat. & Tm. Off. Marca Registrada. Marque Déposée.

SERIAL NO. E6703484	J
ORDER NO. 25716	46
29EV	

5716 E6703484

ORDER 25716
MODEL 700™ M24
UPC



ORDER 25716
MODEL 700™ M24
UPC



SERIAL NO.

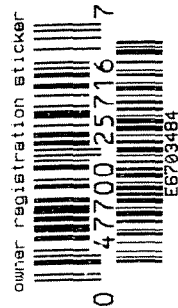
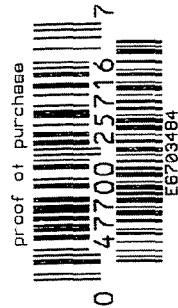


MODEL 700™ M24
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO

DOCUMENT ENVELOPE ASSEMBLY:

- INSTRUCTION BOOK
- PRODUCT OWNER'S CARD
- SAFETY BOOKLET

46 FORM 1444



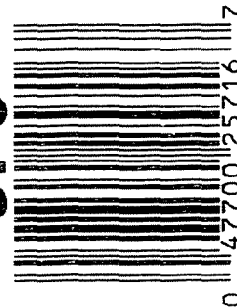
ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

E6703484

UPC



AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. E6203482f

DATE 5/17/01

TESTER VH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	223	241		257	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	227	250		254	
PULL #3	226	249		251	
PULL #4	234	248		244	
PULL #5	235	248		255	
TOTAL	1145	1236		1261	
AVG.	229	247		252	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	319	307		
PULL #2	318	307		
PULL #3	314	316		
PULL #4	318	308		
PULL #5	319	313		
TOTAL	1588	1551		
AVG.	317	310		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	406	4.03		4.22
PULL #2	4.06	4.17		4.19
PULL #3	408	429		4.20
PULL #4	4.09	4.02		4.24
PULL #5	408	4.05		4.23
TOTAL	2037	2056		2108
AVG.	407	411		421

Remington Test Lab, Ilion, N.Y.

Centroidal distance calculations for Rifle # E6703484
31 Aug 2001

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .4654
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.024
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .466018

THE AMR FOR THIS RIFLE IS: 1.321

CENTROIDAL DISTANCES

0 TO	1	1.2092
1 TO	2	.675918
1 TO	3	1.37076
1 TO	4	.805201
1 TO	5	1.04767

4
3 + <----POA
5 2

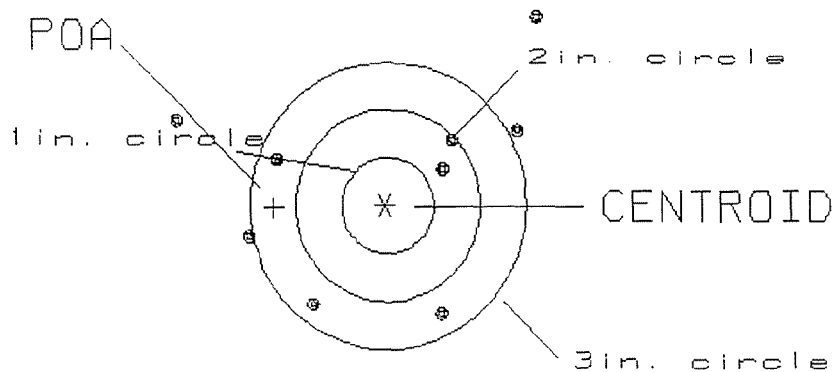
PATTERN #: ☐ 1 ☐

POA TO CENTROID: 1.210
 MIN RADIUS : .693
 MEAN RADIUS : 1.657
 MAX RADIUS : 2.909
 CENTROID X : 1.209
 CENTROID Y : .022

31 Aug 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/E6703404

CENTERFIRE PATTERN # 1



OF SHOTS= 10

IN CIRCLE

HS= 3.90

0

VS= 4.67

2

GS= 4.94

5

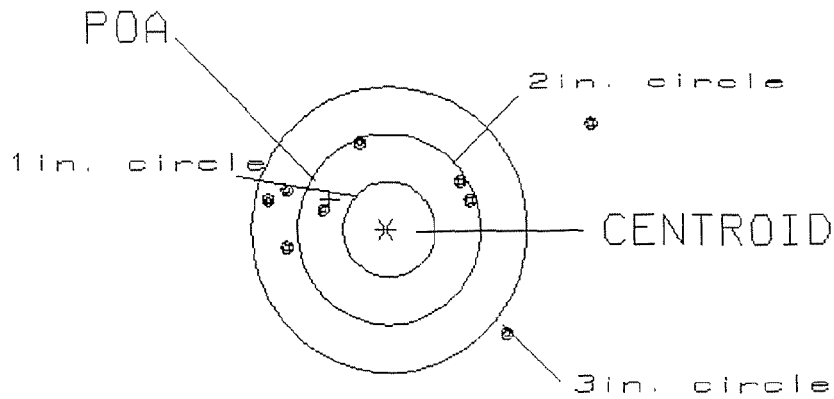
PATTERN #: ☐ 2 ☐

POA TO CENTROID: .690
 MIN RADIUS : .704
 MEAN RADIUS : 1.379
 MAX RADIUS : 2.505
 CENTROID X : .618
 CENTROID Y : -.306

31 Aug 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/E6703404

CENTERFIRE PATTERN # 2



OF SHOTS= 10

IN CIRCLE

HS= 3.50
 VS= 3.56
 GS= 4.54

0
 4
 7

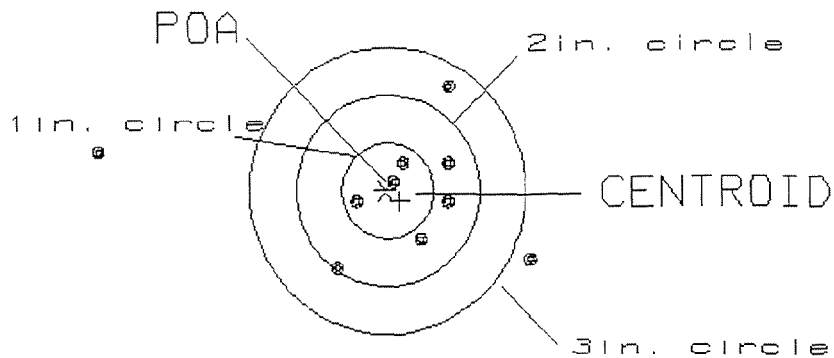
PATTERN #: ☐ 3 ☐

POA TO CENTROID: .192
 MIN RADIUS : .073
 MEAN RADIUS : .990
 MAX RADIUS : 3.195
 CENTROID X : -.159
 CENTROID Y : .109

31 Aug 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/E6703404

CENTERFIRE PATTERN # 3



OF SHOTS= 10

IN CIRCLE

HS= 4.72
 VS= 1.90
 GS= 4.85

3
 7
 0

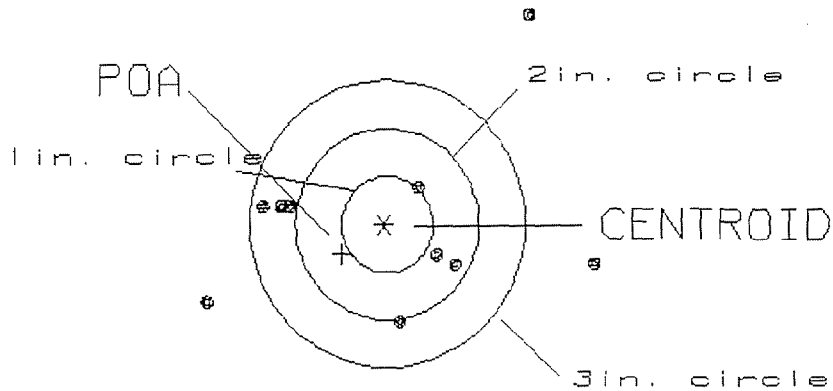
PATTERN #: ☐ 4 ☐

POA TO CENTROID: .556
 MIN RADIUS : .492
 MEAN RADIUS : 1.375
 MAX RADIUS : 2.662
 CENTROID X : .459
 CENTROID Y : .315

31 Aug 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/E6703404

CENTERFIRE PATTERN # 4



OF SHOTS= 10

IN CIRCLE

HS= 4.15
 VS= 3.20
 GS= 4.60

1
 3
 7

PATTERN #: ☐ 5 ☐

POA TO CENTROID: .328

MIN RADIUS : .202

MEAN RADIUS : 1.203

MAX RADIUS : 1.911

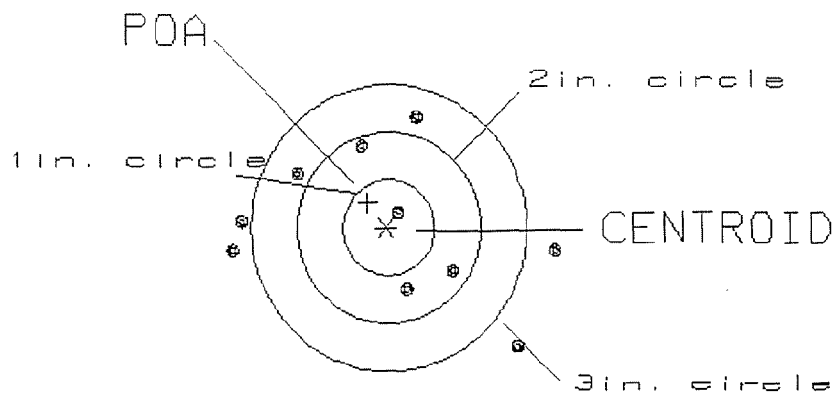
CENTROID X : .200

CENTROID Y : -.260

31 Aug 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/E6703484

CENTERFIRE PATTERN # 5



OF SHOTS= 10

IN CIRCLE

HS= 3.49

1

US= 2.40

4

GS= 3.49

6

Remington Test Lab, Ilion, N.Y.

Centroidal distance calculations for Rifle # E6703484
12 Sep 2001

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: $-.4826$
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: $.1844$
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: $.51663$

THE AMR FOR THIS RIFLE IS: $.9662$

CENTROIDAL DISTANCES

0	TO	1	.591082
1	TO	2	.333542
1	TO	3	.359156
1	TO	4	.563916
1	TO	5	.0407063

3
5 2 + <----POA
4

PATTERN #: ☐ 1 ☐

POA TO CENTROID: .591

MIN RADIUS : .332

MEAN RADIUS : 1.136

MAX RADIUS : 1.816

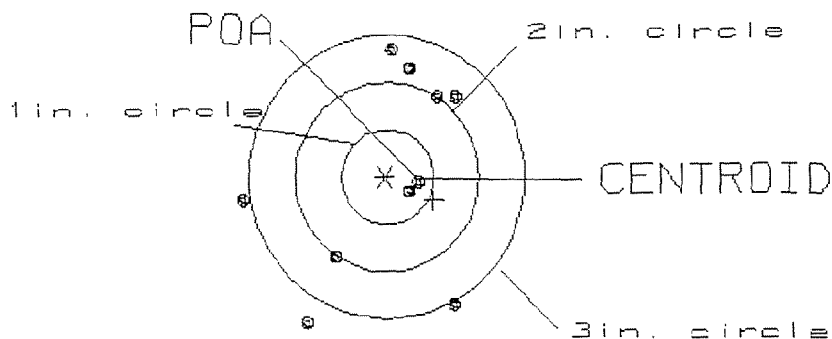
CENTROID X : -.537

CENTROID Y : .247

11 Sep 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/EG703484.1

CENTERFIRE PATTERN # 1



OF SHOTS= 10

IN CIRCLE

HS= 2.27

2

VS= 2.95

3

GS= 3.10

7

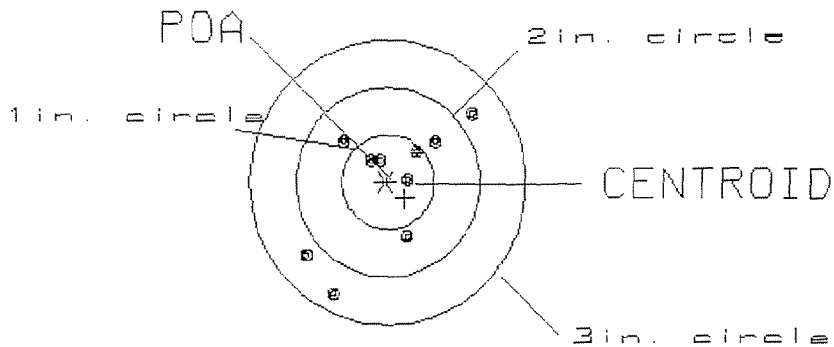
PATTERN #: ☐ 2 ☐

POA TO CENTROID: .273
 MIN RADIUS : .225
 MEAN RADIUS : .688
 MAX RADIUS : 1.343
 CENTROID X : -.212
 CENTROID Y : .172

11 Sep 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/E6703404.1

CENTERFIRE PATTERN # 2



OF SHOTS= 10

IN CIRCLE

HS= 1.75
 VS= 1.96
 GS= 2.45

4
 7
 10

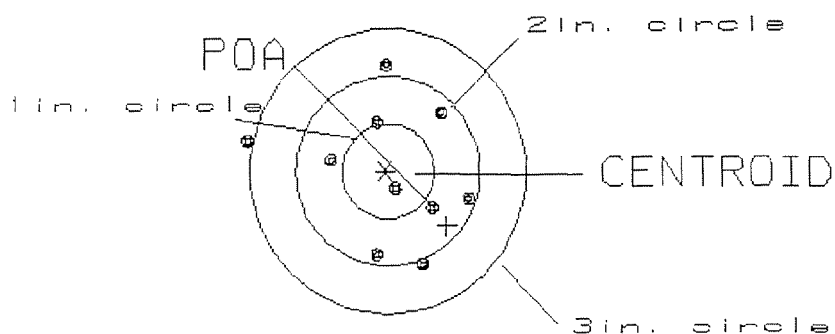
PATTERN #: ☐ 3 ☐

POA TO CENTROID: .889
 MIN RADIUS : .174
 MEAN RADIUS : .828
 MAX RADIUS : 1.533
 CENTROID X : -.674
 CENTROID Y : .579

11 Sep 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/E6703484.1

CENTERFIRE PATTERN # 3



OF SHOTS= 10

IN CIRCLE

HS= 2.40

1

VS= 2.06

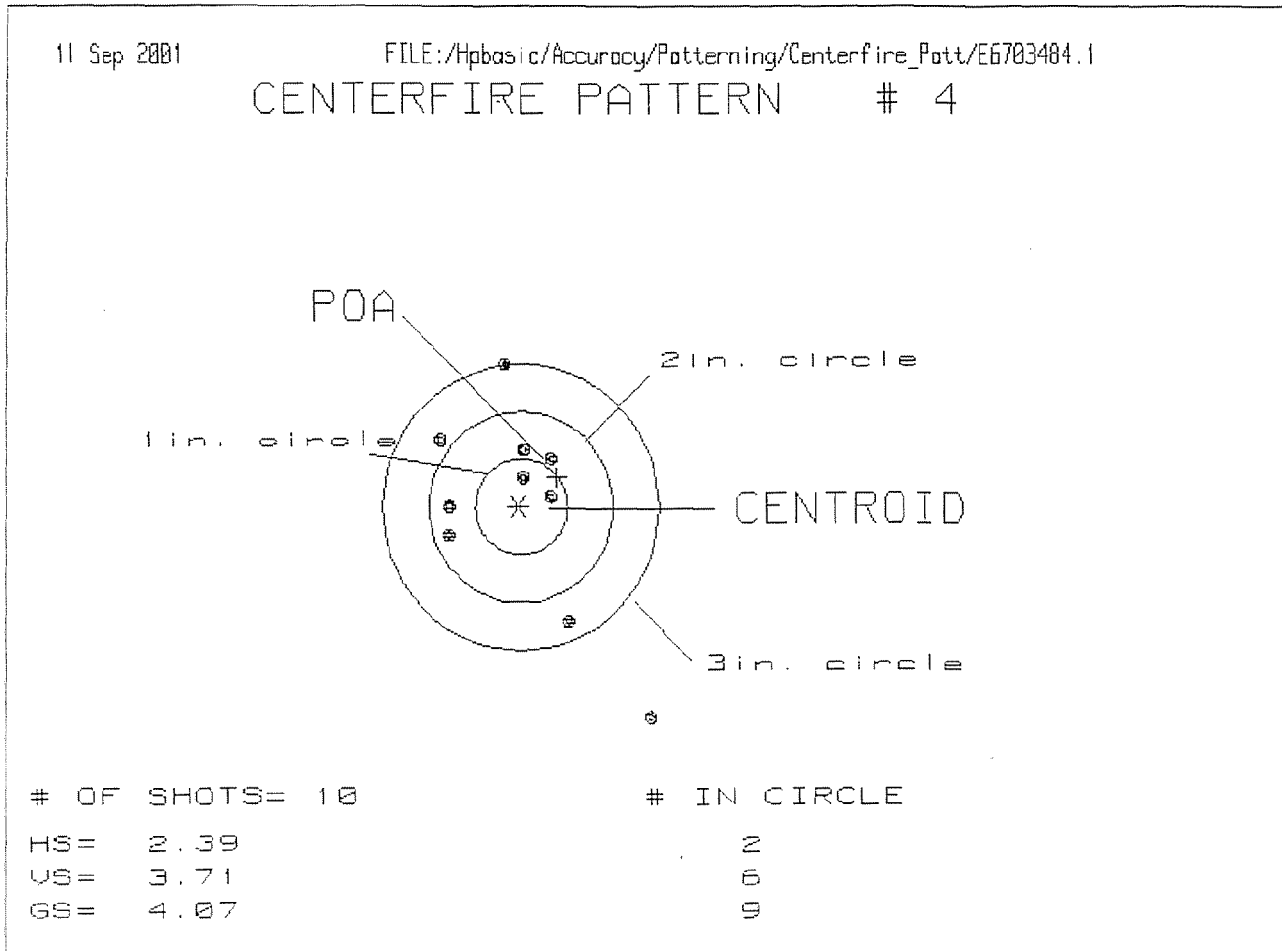
7

GS= 2.47

9

PATTERN #: ☐ 4 ☐

POA TO CENTROID: .516
 MIN RADIUS : .321
 MEAN RADIUS : 1.014
 MAX RADIUS : 2.680
 CENTROID X : -.417
 CENTROID Y : -.304



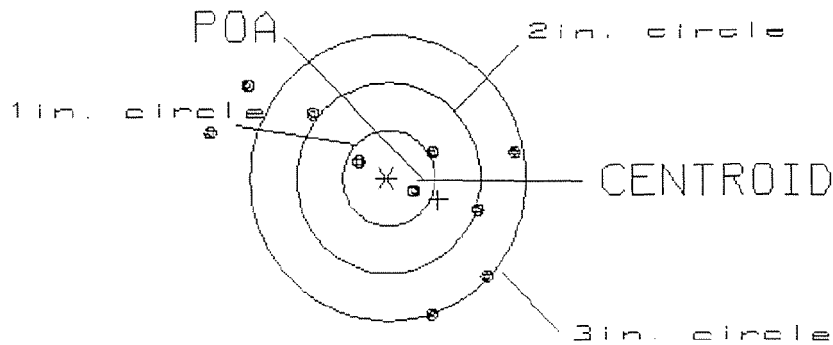
PATTERN #: 5

POA TO CENTROID: .617
 MIN RADIUS : .289
 MEAN RADIUS : 1.165
 MAX RADIUS : 1.974
 CENTROID X : -.573
 CENTROID Y : .228

11 Sep 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/E6703404.1

CENTERFIRE PATTERN # 5



OF SHOTS= 10

IN CIRCLE

HS= 3.32
 VS= 2.43
 GS= 3.36

2
 3
 7

CONTRACT #

GUN SERIAL # F 6703484

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		7/27/01	KHL
600	PROOF		7/27/01	KHL
607	CHECK HEADSPACE		7/27/01	KHL
610	DIS-ASSEMBLE GUN		7/27/01	KHL
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT		7/28/01	AC
615	ROLLMARK CALIBER		7/28/01	KHL
617	DRILL AND TAP SIGHT HOLES		7/28/01	BT
618	POLISH BARREL		7/31/01	GD
620	APPLY COATINGS (BARREL ACTION)		7/31/01	TA
	(BOLT)		7/31/01	TR
625	FINAL ASSEMBLY			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		8/14/01	KHL
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		8/16/01	KHL
	C) INSPECT EJECTOR HOLE FOR CHAMFER		8/16/01	KHL
	D) OIL FIRING PIN ASSEMBLY		8/16/01	KHL
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE		8/16/01	KHL

OP #	OPERATION NAME	READINGS			DATE	INITIAL
625	F) SAFETY ON FORCE	<u>7.9</u>	<u>6.9</u>	<u>6.9</u>	9/12/01	DA
CONT.						
	G) SAFETY OFF FORCE	<u>2.5</u>	<u>2.5</u>	<u>2.5</u>	9/12/01	DA
	H) TRIGGER PULL TEST AND RETAINABILITY					
	I) FIRING PIN INDENT	<u>.022</u>	<u>.022</u>	<u>.022</u>	9/12/01	DA
	J) ASSEMBLE STOCK				7/27/01	KH
	K) ASSEMBLE SWIVEL STUDS				10-26-01	HL
	L) ATTACH FRONT AND REAR SIGHT ASSY'S				10-26-01	HL
	M) IRON SIGHT ALIGNMENT				10-26-01	HL
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER				10-26-01	HL
640	GALLERY TEST AND TARGET				9/10 8/30	K
	A) MALFUNCTIONS				9/10 8/30	K
	B) PIERCED PRIMERS				9/10 8/30	K
645	INSPECT FOR LIVE AMMO				9/10 8/30	K
655	FINAL INSPECTION A) HEADSPACE				10-26-01	HL
	B) TRIGGER PULL	<u>2.52</u>	<u>2.37</u>	<u>2.48</u> <u>2.43</u> <u>2.57</u>	9/12/01	DA
	C) FUNCTION				10-26-01	HL
660	PACK				10-26-01	DA