C687544

MODEL 700™ M24

Model 5W5 ™

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: RE00144844
Verify Repair

Serial: C6587544 Model M24 SWS Center Fire
Caliber: 7.62 NATO

Repairman:
Status: Closed 4/24/2008 10:55:51 AM

Address Information

Customer: (Received From)		Return To: (Received From)	
Name:	B/210TH BSB		B/210TH BSB
Address 1:	2 BCT		2 BCT
Address 2:	10 TH MTN DIV		10 TH MTN DIV
PO Box:		PO Box:	
City:	FORT DRUM		FORT DRUM
State:	NY	State:	NY
Zip Code:	13602	Zip Code:	13602
Country:	US	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	Qu
A007	With Stud	3
A008	With Swivel	2
A010	Hard Case	1
A026	Scope	1
A057	Frt and Rear Sgt Base	1

nagletj | 4/24/2008 | 12:26 PM | CAPS | NUM

start | 4 Micros... | The Asso... | 2 Micros... | SAP Logo... | Arms Ser...

Serial Number: C6587544
Model: M24 SWS
RE00144844

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFOMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6587544.__0
FILE DATE AND TIME: 05/23/2008 05:27

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

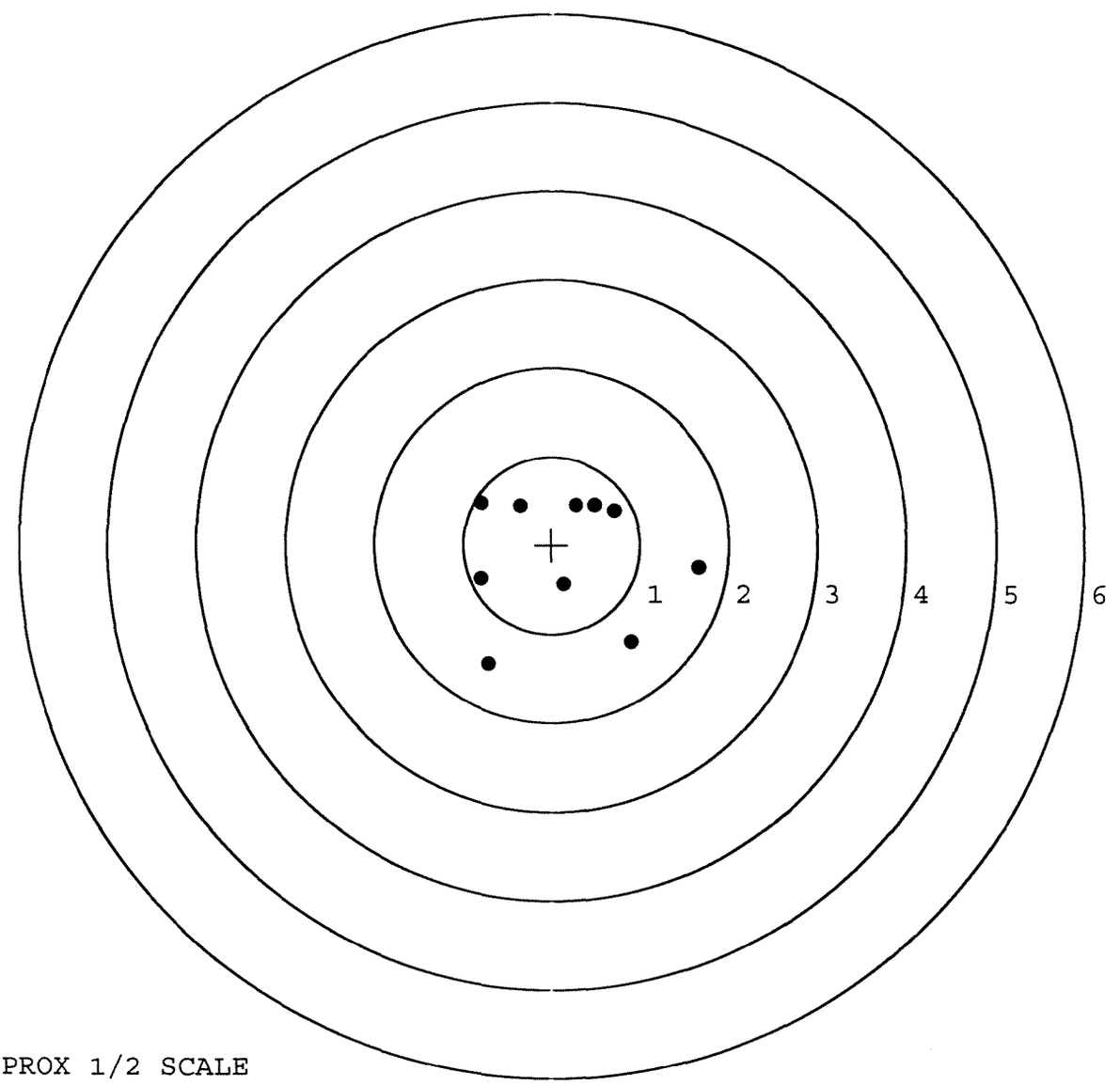
The Average X Centroid of the Five Target Set:	0.040
The Average Y Centroid of the Five Target Set:	-0.105
The Average Point of Impact of the Five Target Set:	0.112
The Average Mean Radius of the Five Target Set:	0.649
The Distance from POA to Centroid Target #1:	0.199
The Distance from Centroid Target #2 to Centroid Target #1:	0.113
The Distance from Centroid Target #3 to Centroid Target #1:	0.110
The Distance from Centroid Target #4 to Centroid Target #1:	0.206
The Distance from Centroid Target #5 to Centroid Target #1:	0.235

BARBER - M24 0022417

SERIAL NUMBER: C6587544.__0
TARGET NUMBER: 1
FILE DATE: 05/23/2008
FILE TIME: 05:27

X CENTROID:	0.152
Y CENTROID:	-0.128
POA TO CENTROID:	0.199
HORZ SPREAD:	2.463
VERT SPREAD:	1.817
GROUP SPREAD:	2.611
MIN RADIUS:	0.313
MAX RADIUS:	1.519
MEAN RADIUS:	0.944
# IN 1 IN DIAMETER:	1
# IN 2 IN DIAMETER:	6
# in 3 IN DIAMETER:	9

POINT#	X	Y
1:	0.900	-1.091
2:	1.666	-0.250
3:	0.710	0.388
4:	0.492	0.460
5:	0.277	0.447
6:	-0.796	-0.381
7:	-0.356	0.445
8:	-0.797	0.480
9:	0.135	-0.441
10:	-0.708	-1.337



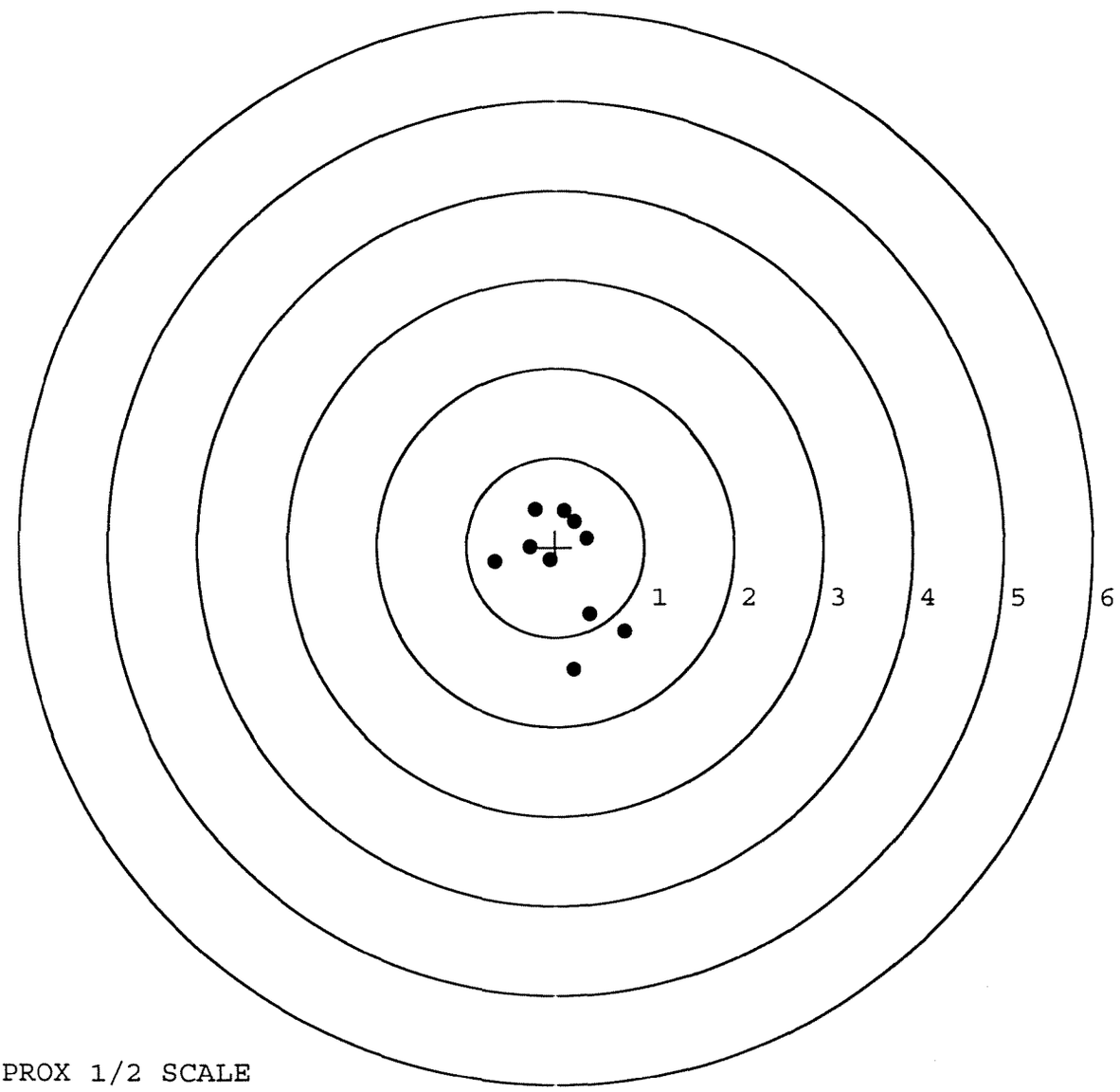
TARGET APPROX 1/2 SCALE

BARBER - M24 0022418

SERIAL NUMBER: C6587544.__0
TARGET NUMBER: 2
FILE DATE: 05/23/2008
FILE TIME: 05:27

X CENTROID:	0.079
Y CENTROID:	-0.214
POA TO CENTROID:	0.228
HORZ SPREAD:	1.453
VERT SPREAD:	1.786
GROUP SPREAD:	1.839
MIN RADIUS:	0.159
MAX RADIUS:	1.160
MEAN RADIUS:	0.636
# IN 1 IN DIAMETER:	3
# IN 2 IN DIAMETER:	8
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	0.777	-0.934
2:	0.390	-0.742
3:	0.211	-1.366
4:	-0.676	-0.162
5:	-0.062	-0.141
6:	-0.280	-0.006
7:	-0.228	0.420
8:	0.094	0.405
9:	0.213	0.282
10:	0.355	0.105



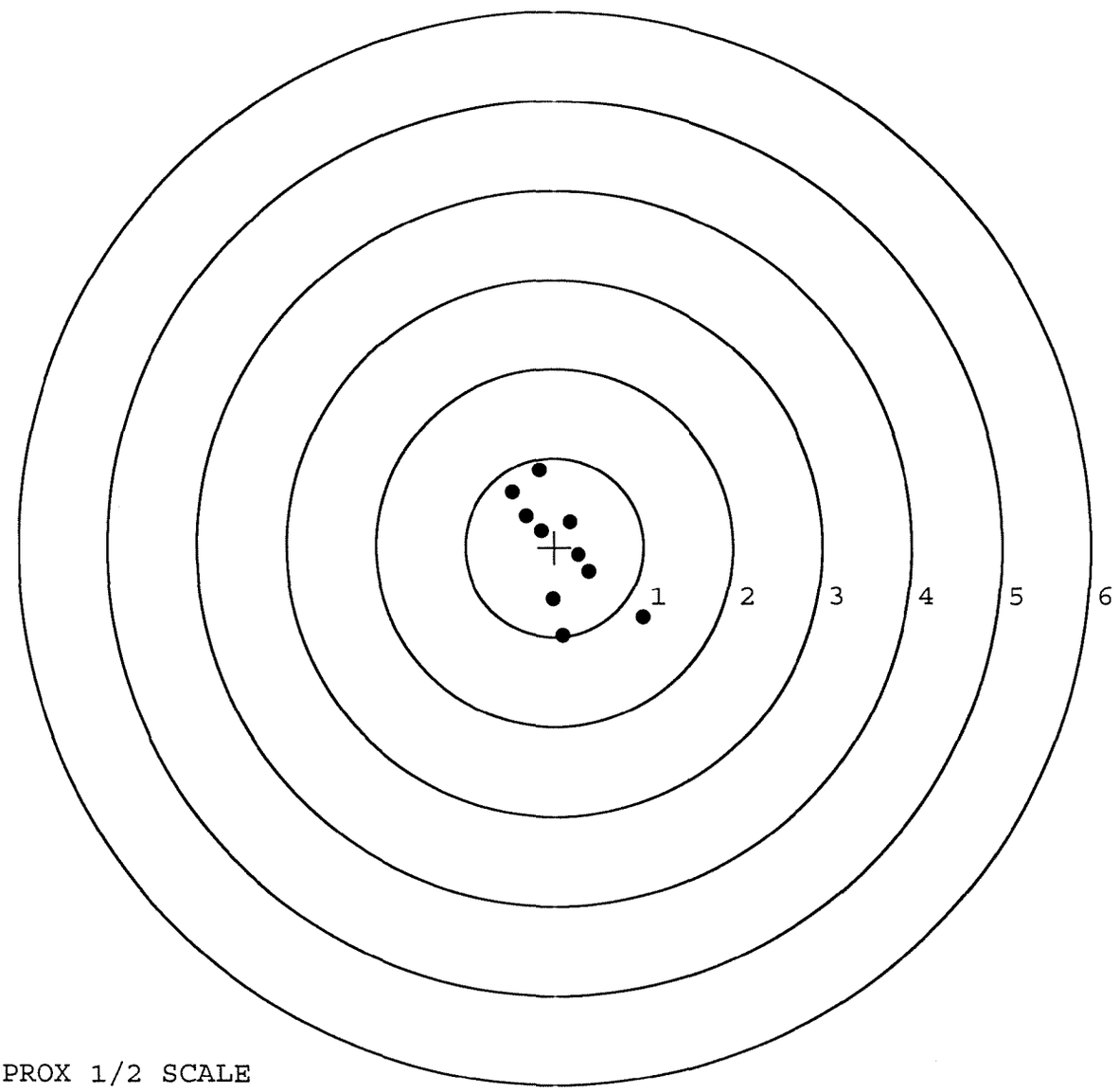
TARGET APPROX 1/2 SCALE

BARBER - M24 0022419

SERIAL NUMBER: C6587544.__0
TARGET NUMBER: 3
FILE DATE: 05/23/2008
FILE TIME: 05:27

X CENTROID:	0.080
Y CENTROID:	-0.045
POA TO CENTROID:	0.092
HORZ SPREAD:	1.466
VERT SPREAD:	1.853
GROUP SPREAD:	2.030
MIN RADIUS:	0.194
MAX RADIUS:	1.182
MEAN RADIUS:	0.627
# IN 1 IN DIAMETER:	4
# IN 2 IN DIAMETER:	9
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	0.995	-0.793
2:	0.096	-0.990
3:	-0.017	-0.580
4:	0.389	-0.276
5:	0.268	-0.093
6:	0.179	0.285
7:	-0.317	0.343
8:	-0.471	0.611
9:	-0.172	0.863
10:	-0.150	0.185



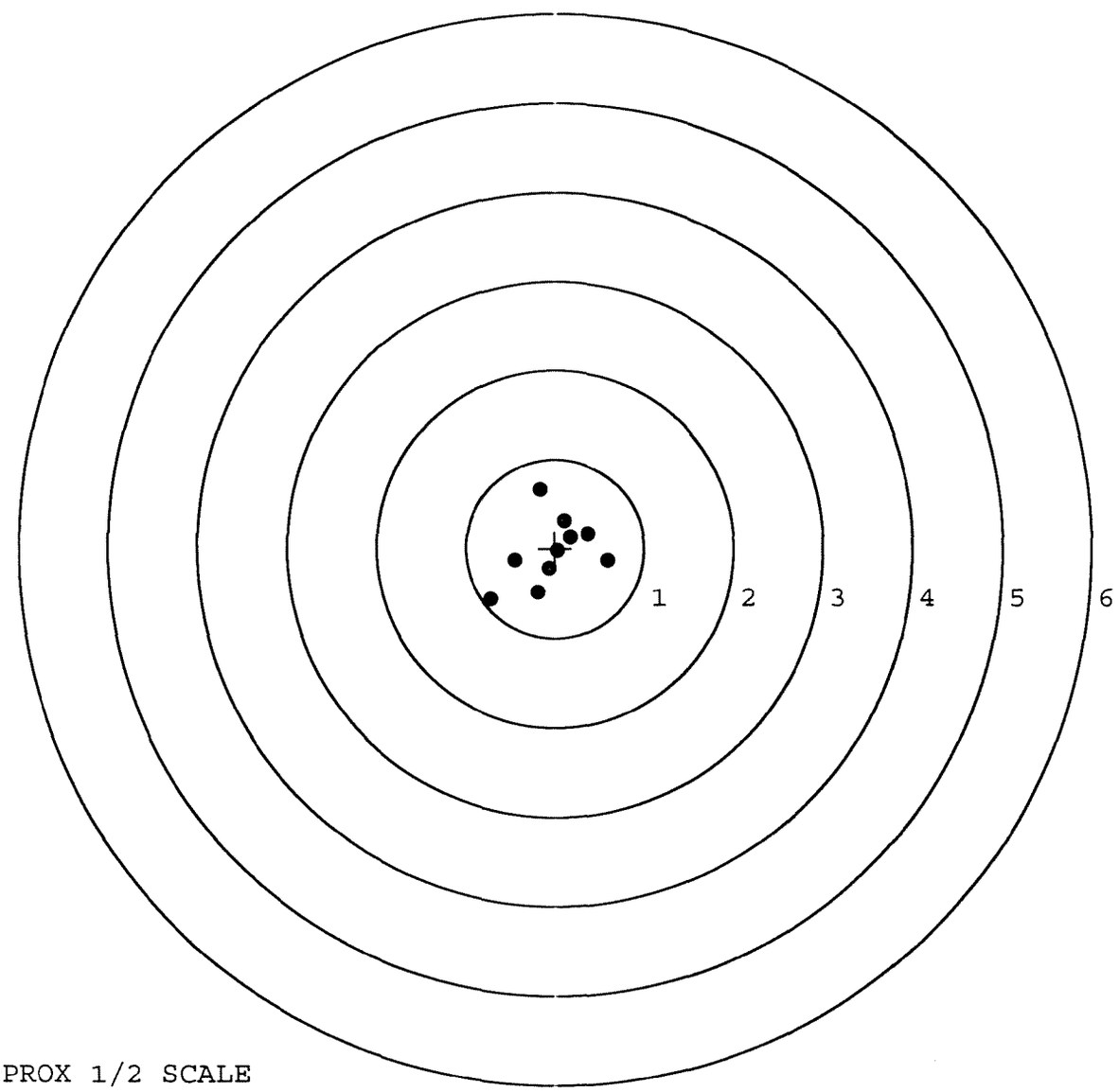
TARGET APPROX 1/2 SCALE

BARBER - M24 0022420

SERIAL NUMBER: C6587544.__0
TARGET NUMBER: 4
FILE DATE: 05/23/2008
FILE TIME: 05:27

X CENTROID:	-0.032
Y CENTROID:	-0.036
POA TO CENTROID:	0.048
HORZ SPREAD:	1.320
VERT SPREAD:	1.227
GROUP SPREAD:	1.389
MIN RADIUS:	0.065
MAX RADIUS:	0.872
MEAN RADIUS:	0.448
# IN 1 IN DIAMETER:	7
# IN 2 IN DIAMETER:	10
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	0.599	-0.139
2:	-0.168	0.657
3:	-0.449	-0.139
4:	-0.721	-0.570
5:	-0.194	-0.499
6:	-0.071	-0.233
7:	0.033	-0.027
8:	0.370	0.163
9:	0.180	0.126
10:	0.102	0.304



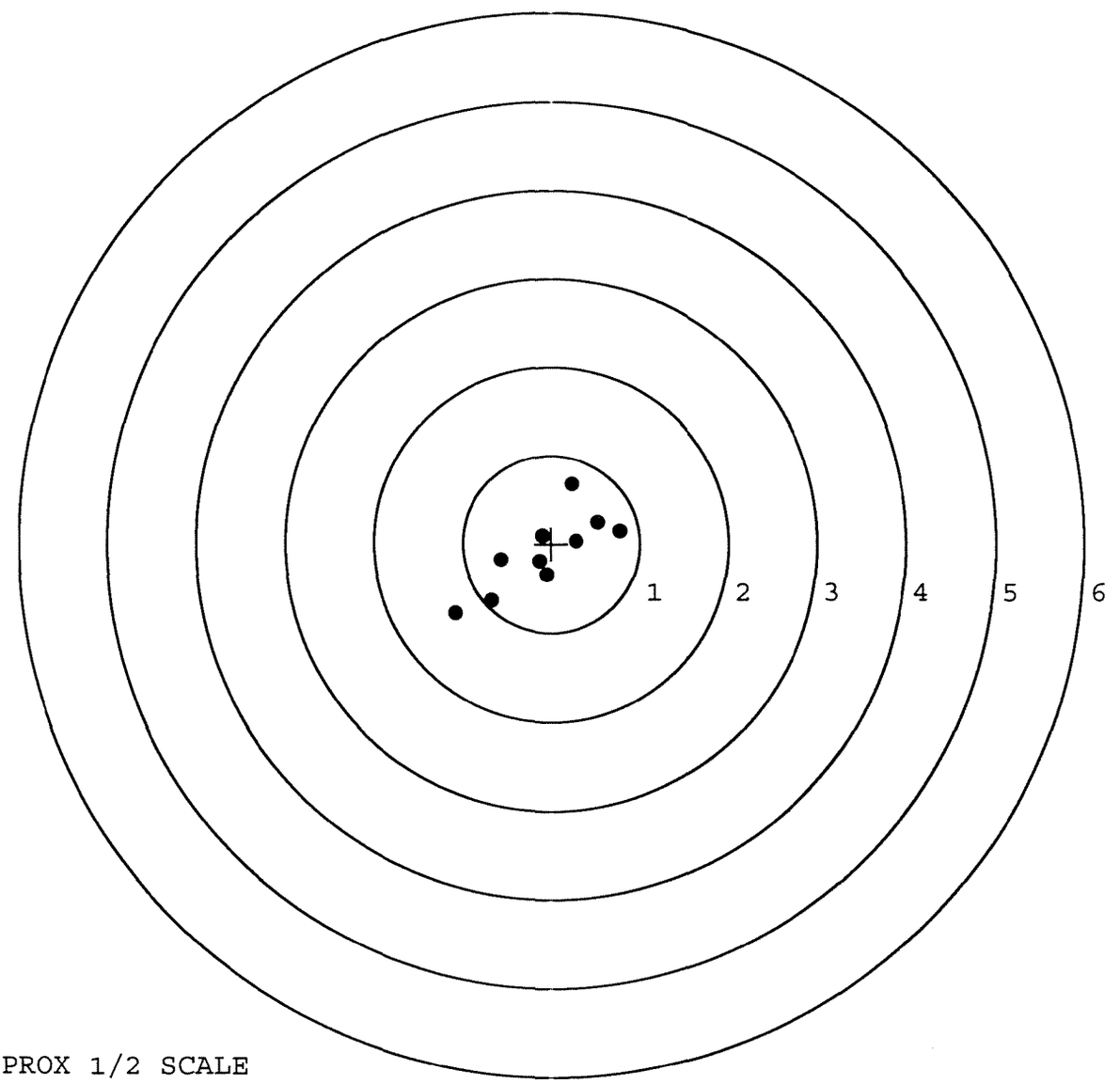
TARGET APPROX 1/2 SCALE

BARBER - M24 0022421

SERIAL NUMBER: C6587544.__0
TARGET NUMBER: 5
FILE DATE: 05/23/2008
FILE TIME: 05:27

X CENTROID:	-0.081
Y CENTROID:	-0.101
POA TO CENTROID:	0.129
HORZ SPREAD:	1.862
VERT SPREAD:	1.469
GROUP SPREAD:	2.085
MIN RADIUS:	0.120
MAX RADIUS:	1.220
MEAN RADIUS:	0.591
# IN 1 IN DIAMETER:	5
# IN 2 IN DIAMETER:	9
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	0.776	0.145
2:	0.527	0.243
3:	0.239	0.676
4:	0.280	0.029
5:	-0.059	-0.357
6:	-0.140	-0.205
7:	-0.105	0.091
8:	-0.570	-0.189
9:	-0.671	-0.650
10:	-1.086	-0.793



TARGET APPROX 1/2 SCALE

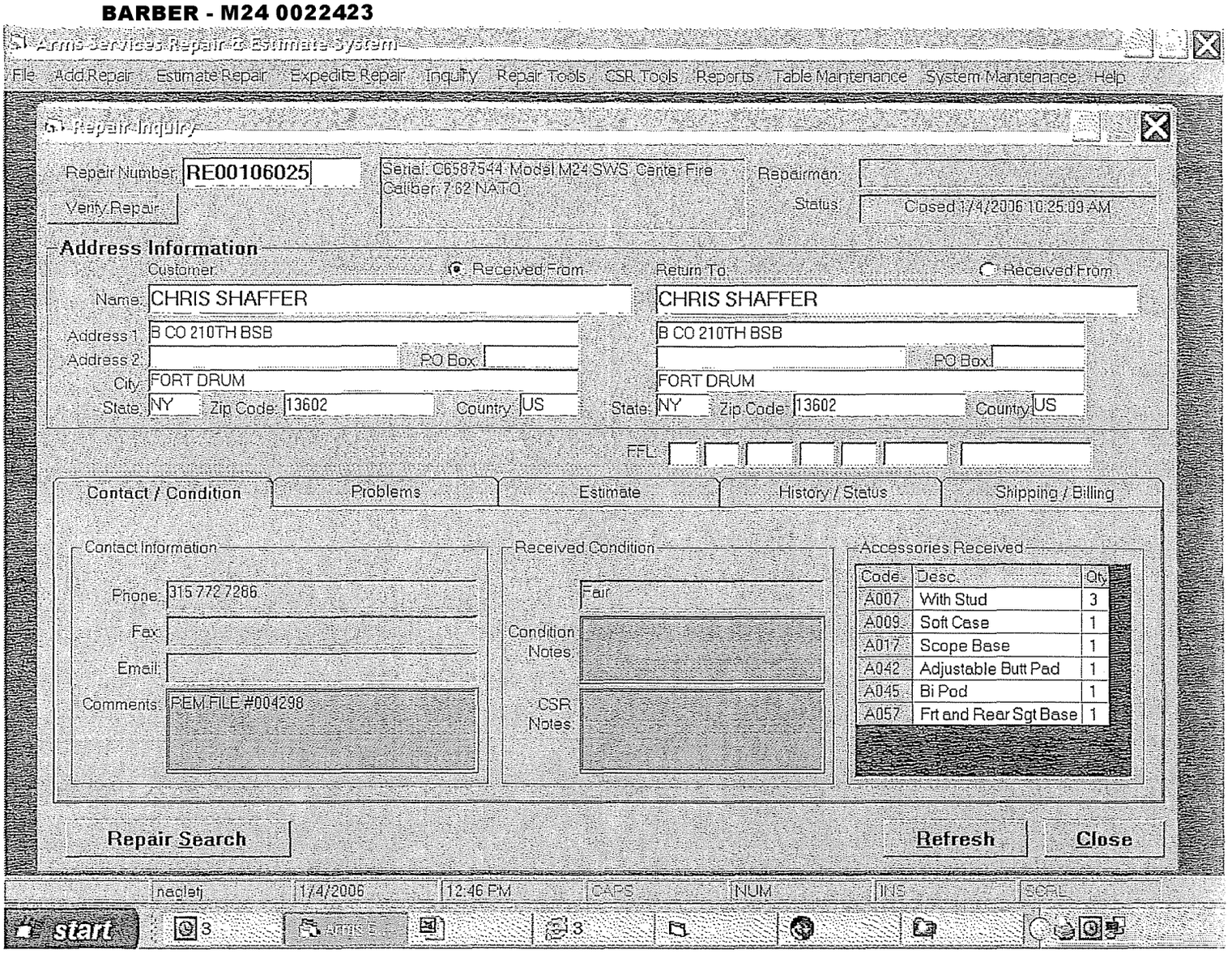
M-24 INSPECTION CHECKLIST
CONTRACT #: DAAE-20-02-C-0149

R & E NUMBER 144844

SERIAL NUMBER C6587544

LOG-IN DATE 4-24-08

OPERATION #	OPERATION NAME		DATE	INITIAL
500	DIS-ASSEMBLE GUN		5-5-08	RTC
505	RE-BARREL		5-6-08	RTC
560	ASSEMBLE		5-6-08	RTC
600	PROOF	MAGNA - FLUX	5-7-08	TRW
605	CHECK HEADSPACE	MAY 2008	5-7-08	TRW
610	DIS-ASSEMBLE GUN		5-7-08	RTC
612	MAGNAFLUX	OPERATOR	5/9/08	
510	DRILL AND TAP		5-7-08	TRW
615	ROLLMARK CALIBER		5-7-08	CW
618	ROTO-BLAST		5-9-08	DC
620	APPLY COATINGS		5/19/08	
625	FINAL ASSEMBLY		5-22-08	RTC
640	FUNCTION TEST AND	(PASS) FAIL	5-22-08	SD
650	TARGET	(PASS) FAIL	5-22-08	SD
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION N/A		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION	5-22-08	RP
670	FINAL INSPECTION A) HEADSPACE	(PASS) FAIL	5/27/08 5/27/08	FM FM
	B) TRIGGER PULL (+/- .5 LBS, MIN 2.50 LBS, MAX 4.0 LBS)	2.36 2.29 2.36 2.25 2.25	5-27-08	TRW
680	F) SAFETY ON FORCE (2 LBS MIN, 10 LBS MAX)	6- 6- 6-	5/27/08	FM
	G) SAFETY OFF FORCE (2 LBS MIN)	2½ 2⅝ 3-	5/27/08	FM
	I) FIRING PIN INDENT (.020)	.022 .023 .023	5/27/08	FM
690	PACK		5/27/08	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: RE00106025
Verify Repair
Serial: C6587544 Model M24 SWS Center Fire Caliber: 7.62 NATO
Repairman:
Status: Closed 1/4/2006 10:25:09 AM
Address Information
Customer
Received From
Name: CHRIS SHAFFER
Address 1: B CO 210TH BSB
Address 2:
PO Box:
City: FORT DRUM
State: NY Zip Code: 13602 Country: US
Return To:
Received From
CHRIS SHAFFER
B CO 210TH BSB
PO Box:
FORT DRUM
State: NY Zip Code: 13602 Country: US
FFL:
Contact / Condition
Problems
Estimate
History / Status
Shipping / Billing
Contact Information
Phone: 315 772 7286
Fax:
Email:
Comments: PEM FILE #004298
Received Condition
Fair
Condition Notes:
CSR Notes:
Accessories Received
Code Desc. Qty
A007 With Stud 3
A009 Soft Case 1
A017 Scope Base 1
A042 Adjustable Butt Pad 1
A045 Bi Pod 1
A057 Frt and Rear Sgt Base 1
Repair Search
Refresh
Close
neclatj
1/4/2006
12:46 PM
CAPS
NUM
INS
SCRL
start


Serial Number:
C6587544
Model: M24 SWS
RE00106025

BARBER - M24 0022424

MAINTENANCE REQUEST

For use of this form, see DA PAM 738-750 and 738-751; the proponent agency is DCSLOG

PAGE NO	NO OF PAGES	REQUIREMENT CONTROL SYMBOL CSGLD-1047(*R1*)

SECTION I - CUSTOMER DATA

1a. UIC CUSTOMER	1b. CUSTOMER UNIT NAME	1c. PHONE NO
WHNKTP	HHC 4-31	

2a. SAMS-2 UIC/SAMS-I/TDA	2b. UTILIZATION CODE	2c. MCSR

SECTION II - MAINTENANCE ACTIVITY DATA

3a. WORK ORDER NUMBER (*WON*)	3b. SHOP	3c. PHONE NO

4a. UIC SUPPORT UNIT	4b. SUPPORT UNIT NAME

SECTION III - EQUIPMENT DATA

5. TYPE MNT REQ CODE	6. ID	7. NSN
		1005-01-240-2136

8. MODEL	M24
9. NOUN	SWS

10a ORG WON/DOC NO	10b. EIC

11. SERIAL NUMBER	12. QTY	13. PD
C65875 44	01	02

15a. FAILURE DETECTED DURING/WHEN DISCOVERED CODE (*Enter code*) See DA Pamphlets 738-750 and 738-751

15b. FIRST INDICATION OF TROUBLE/HOW RECOGNIZED CODE (*Enter Code*) See DA Pamphlets 738-750 and 738-751

16. MILES/KILOMETERS/HOURS/ROUNDS

M		K	
H		R	

17. PROJECT CODE (*if assigned*)	18. ACCOUNT PROCESSING CODE	19. IN WARRANTY? (*enter Y or N*)	20. ADMIN NO

14. MALFUNCTION DESCRIPTION (*for DSU, GSU/AVIM, DEPOT use*)

21. REIMBURSABLE CUSTOMER (*if Intransit customer enter Y or N*)

22. LEVEL OF WORK

23. SIGNATURE

24. DESCRIBE DEFICIENCIES OR SYMPTOMS ON THE BASIS OF COMPLETE CHECKOUT AND DIAGNOSTIC PROCEDURES IN EQUIPMENT TM (*Do not prescribe repairs*) Rear lion sight bracket gouged. Telescope & lion sights OK

25. REMARKS

26. TECHNICAL REFERENCES

SECTION IV - TASK REQUIREMENTS DATA

27a. FILE INPUT ACT CD	27b. TASK NO	27c. ACT CODE	27d. TASK DESCRIPTION	27e. QTY TO BE RPR	27f. WORK CENTER	27g. FAILURE CODE	27h. MH PROJ	27i. MH EXP

SECTION V - PART REQUIREMENTS

28a FILE INPUT ACT CD	28b. TASK NO	28c. ID NO	28d. NSN OR PART NUMBER	28e. SFX CD	28f. QTY RQD	28g. QTY ISSUED	28h. NMCS CD	28i. FAILURE CODE	28j. STORAGE LOCATION	28k. INITIALS	28l. COST $

28m. TOTAL MANHOURS	28n. TOTAL MANHOURS COSTS $	28o. TOTAL PARTS COSTS $	

SECTION VI - COMPLETION DATA

29. QTY RPR	30. QTY CONDEMN	31. QTY NRTS	32. EVAC WON	33. EVAC UNIT NAME

SECTION VII - ACTION SIGNATURES

34a. SUBMITTED BY	35a. ACCEPTED BY	35c. DATE	36a. WORK STARTED BY	37a. INSPECTED BY	38a. PICKED UP BY

34b. DATE	35b. STATUS	35d. TIME	36b. STATUS	36c. DATE	36d. TIME	37b. STATUS	37c. DATE	37d. TIME	38b. STATUS	38c. DATE	38d. TIME

DA FORM 2407, JUL 94

NMP COPY 2

7202
7203

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFOMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6587544.__0
FILE DATE AND TIME: 01/16/2006 11:44

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

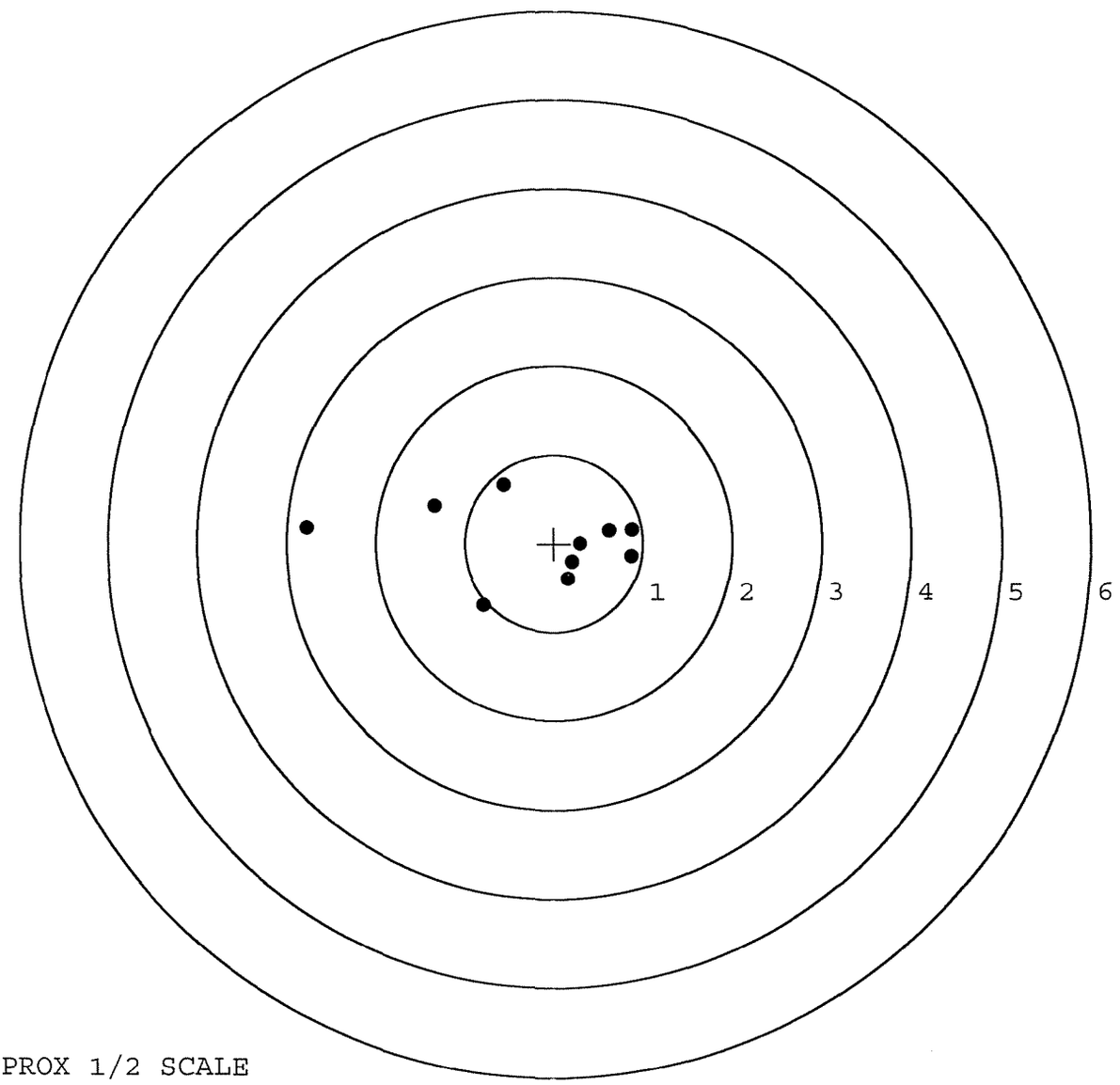
The Average X Centroid of the Five Target Set:	-0.090
The Average Y Centroid of the Five Target Set:	0.096
The Average Point of Impact of the Five Target Set:	0.132
The Average Mean Radius of the Five Target Set:	1.060
The Distance from POA to Centroid Target #1:	0.244
The Distance from Centroid Target #2 to Centroid Target #1:	0.421
The Distance from Centroid Target #3 to Centroid Target #1:	0.501
The Distance from Centroid Target #4 to Centroid Target #1:	0.814
The Distance from Centroid Target #5 to Centroid Target #1:	0.483

BARBER - M24 0022426

SERIAL NUMBER: C6587544.__0
TARGET NUMBER: 1
FILE DATE: 01/16/2006
FILE TIME: 11:44

X CENTROID:	-0.244
Y CENTROID:	0.010
POA TO CENTROID:	0.244
HORZ SPREAD:	3.648
VERT SPREAD:	1.361
GROUP SPREAD:	3.661
MIN RADIUS:	0.498
MAX RADIUS:	2.536
MEAN RADIUS:	1.008
# IN 1 IN DIAMETER:	1
# IN 2 IN DIAMETER:	6
# in 3 IN DIAMETER:	9

POINT#	X	Y
1:	0.873	-0.149
2:	0.874	0.155
3:	0.625	0.153
4:	0.295	0.000
5:	0.205	-0.207
6:	0.158	-0.403
7:	-0.783	-0.703
8:	-0.565	0.658
9:	-1.345	0.420
10:	-2.774	0.175



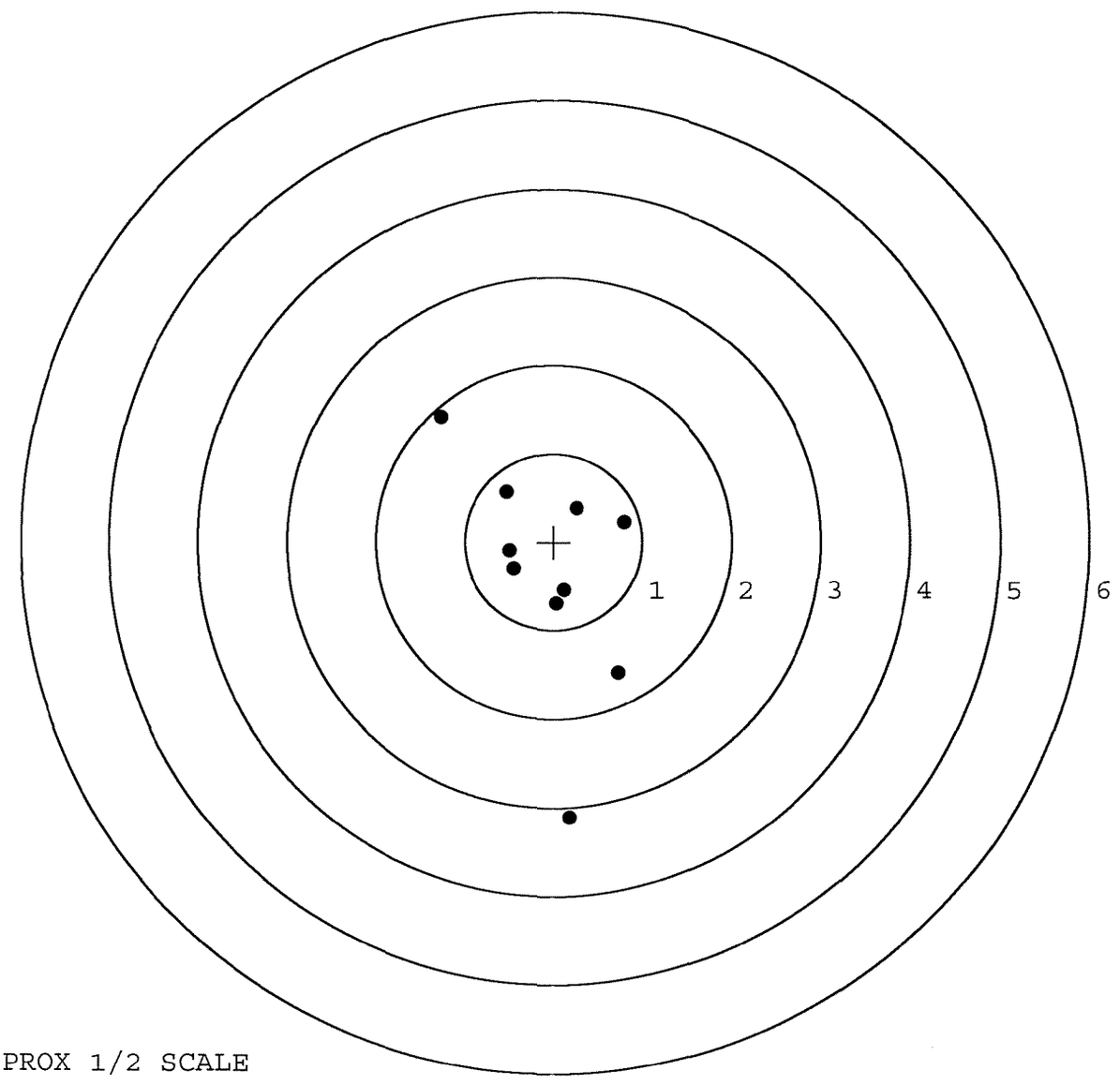
TARGET APPROX 1/2 SCALE

BARBER - M24 0022427

SERIAL NUMBER: C6587544.__0
TARGET NUMBER: 2
FILE DATE: 01/16/2006
FILE TIME: 11:44

X CENTROID:	-0.061
Y CENTROID:	-0.369
POA TO CENTROID:	0.374
HORZ SPREAD:	2.069
VERT SPREAD:	4.527
GROUP SPREAD:	4.759
MIN RADIUS:	0.260
MAX RADIUS:	2.761
MEAN RADIUS:	1.070
# IN 1 IN DIAMETER:	3
# IN 2 IN DIAMETER:	5
# in 3 IN DIAMETER:	8

POINT#	X	Y
1:	0.736	-1.484
2:	0.036	-0.703
3:	0.126	-0.550
4:	0.794	0.222
5:	0.262	0.384
6:	-0.452	-0.307
7:	-0.499	-0.105
8:	-0.532	0.562
9:	-1.275	1.409
10:	0.192	-3.118



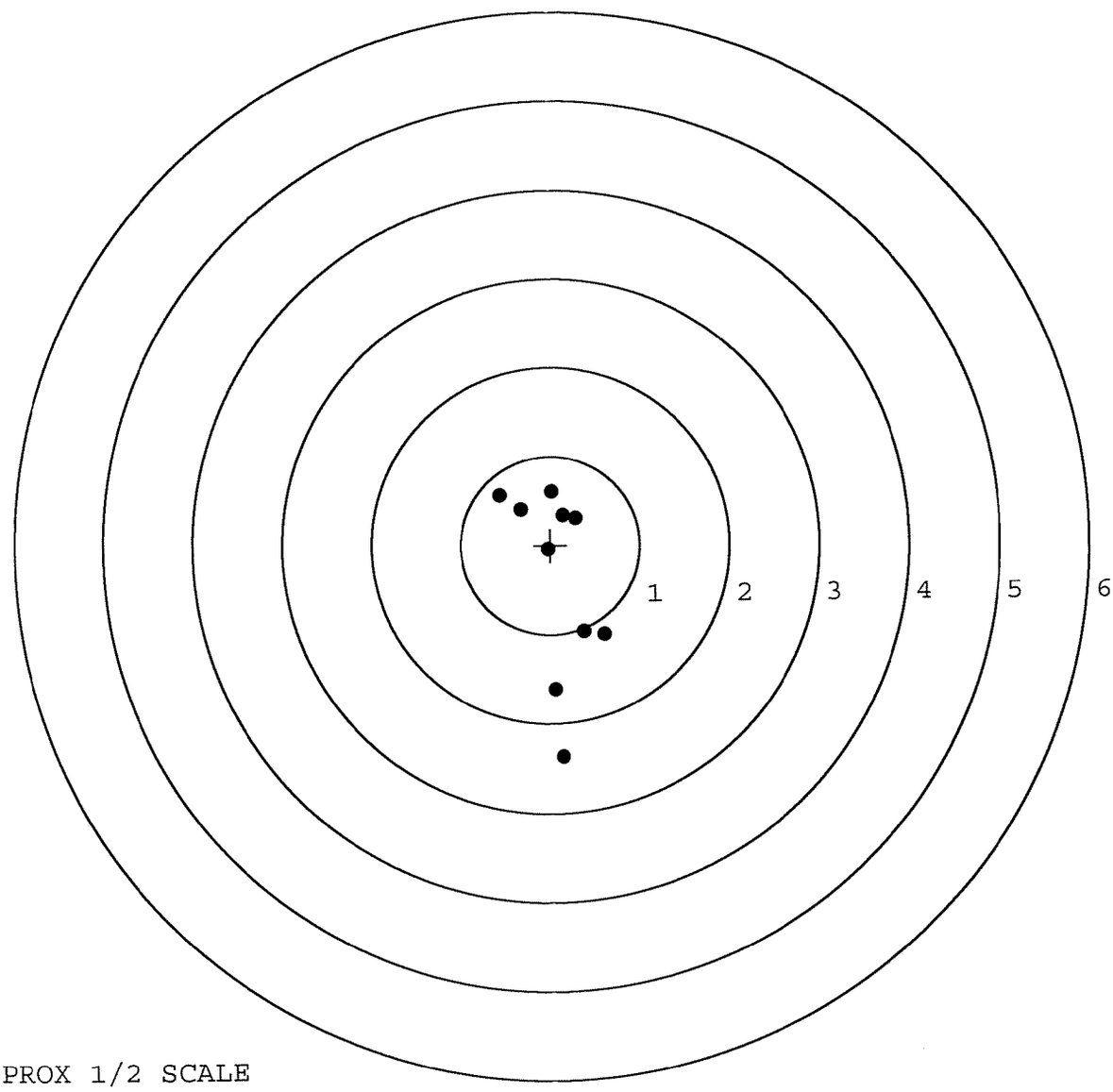
TARGET APPROX 1/2 SCALE

BARBER - M24 0022428

SERIAL NUMBER: C6587544.__0
TARGET NUMBER: 3
FILE DATE: 01/16/2006
FILE TIME: 11:44

X CENTROID:	0.071
Y CENTROID:	-0.381
POA TO CENTROID:	0.387
HORZ SPREAD:	1.165
VERT SPREAD:	2.984
GROUP SPREAD:	3.025
MIN RADIUS:	0.343
MAX RADIUS:	1.998
MEAN RADIUS:	0.951
# IN 1 IN DIAMETER:	1
# IN 2 IN DIAMETER:	7
# in 3 IN DIAMETER:	9

POINT#	X	Y
1:	0.137	-2.378
2:	0.052	-1.621
3:	0.604	-1.001
4:	0.379	-0.968
5:	0.293	0.305
6:	0.145	0.335
7:	-0.031	-0.053
8:	-0.561	0.565
9:	-0.332	0.402
10:	0.020	0.606



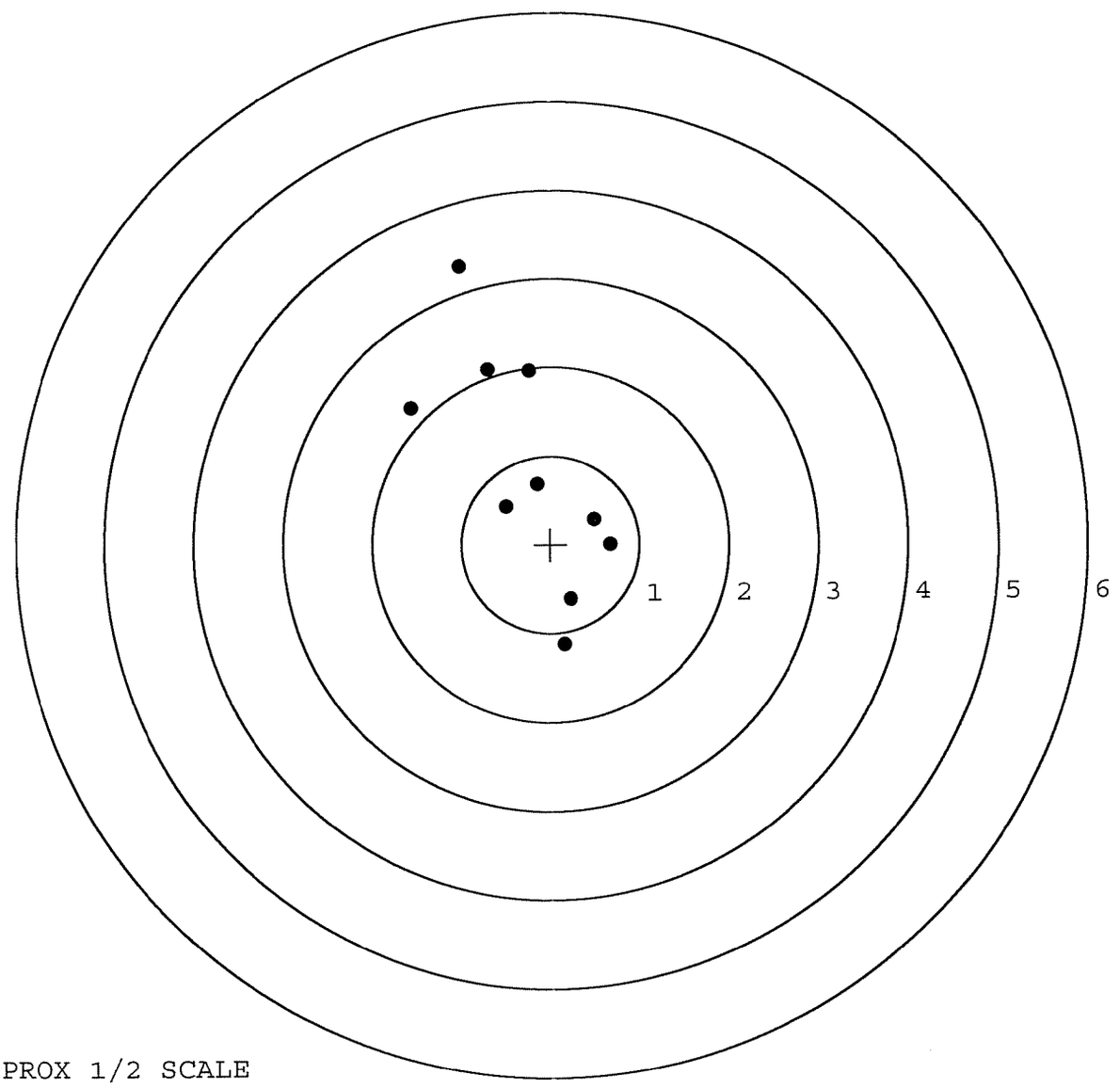
TARGET APPROX 1/2 SCALE

BARBER - M24 0022429

SERIAL NUMBER: C6587544.__0
TARGET NUMBER: 4
FILE DATE: 01/16/2006
FILE TIME: 11:44

X CENTROID:	-0.260
Y CENTROID:	0.824
POA TO CENTROID:	0.864
HORZ SPREAD:	2.242
VERT SPREAD:	4.266
GROUP SPREAD:	4.424
MIN RADIUS:	0.180
MAX RADIUS:	2.434
MEAN RADIUS:	1.263
# IN 1 IN DIAMETER:	2
# IN 2 IN DIAMETER:	3
# in 3 IN DIAMETER:	7

POINT#	X	Y
1:	0.156	-1.128
2:	0.229	-0.620
3:	0.678	-0.004
4:	0.499	0.284
5:	-0.151	0.681
6:	-0.500	0.427
7:	-0.240	1.956
8:	-0.695	1.971
9:	-1.564	1.535
10:	-1.016	3.138



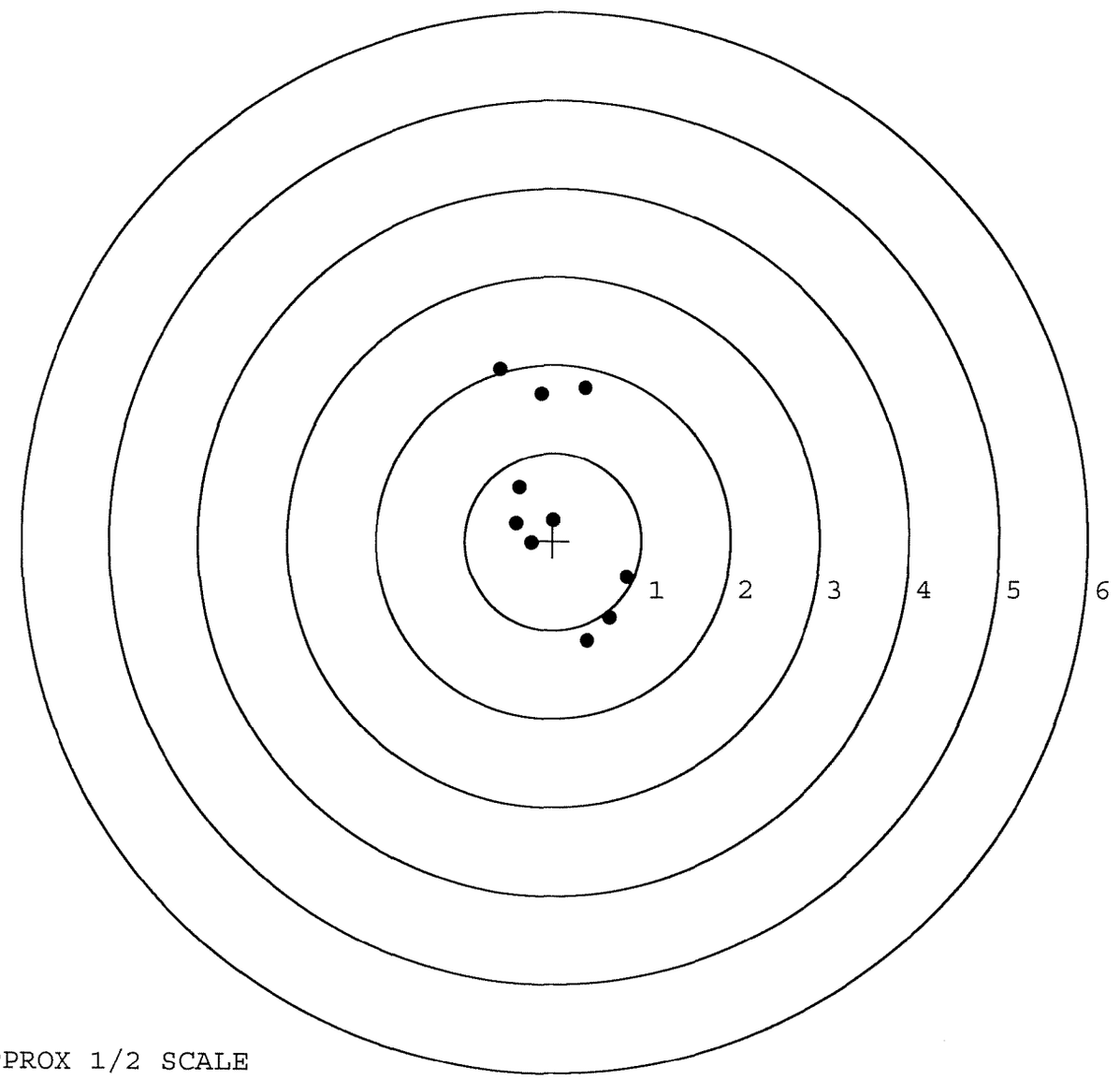
TARGET APPROX 1/2 SCALE

BARBER - M24 0022430

SERIAL NUMBER: C6587544.__0
TARGET NUMBER: 5
FILE DATE: 01/16/2006
FILE TIME: 11:44

X CENTROID:	0.045
Y CENTROID:	0.397
POA TO CENTROID:	0.399
HORZ SPREAD:	1.439
VERT SPREAD:	3.070
GROUP SPREAD:	3.227
MIN RADIUS:	0.169
MAX RADIUS:	1.683
MEAN RADIUS:	1.010
# IN 1 IN DIAMETER:	2
# IN 2 IN DIAMETER:	4
# in 3 IN DIAMETER:	8

POINT#	X	Y
1:	0.835	-0.413
2:	0.645	-0.865
3:	0.390	-1.121
4:	0.363	1.736
5:	-0.135	1.671
6:	-0.604	1.949
7:	-0.386	0.607
8:	-0.001	0.234
9:	-0.417	0.201
10:	-0.240	-0.032



TARGET APPROX 1/2 SCALE

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS
2.50 LBS (plus or minus 0.50 LBS)
3.00 LBS (plus or minus 0.75 LBS)
4.00 LBS (plus or minus 1.00 LBS)

SERIAL NO. _____

DATE 12-30-05

TESTER TRW

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.36	2.33		2.54	
PULL #2	2.42	2.43		2.63	
PULL #3	2.48	2.22		2.60	
PULL #4	2.50	2.64		2.57	
PULL #5	2.59	2.59		2.64	
TOTAL	12.35	12.21		12.98	
AVERAGE	2.47	2.44		2.59	

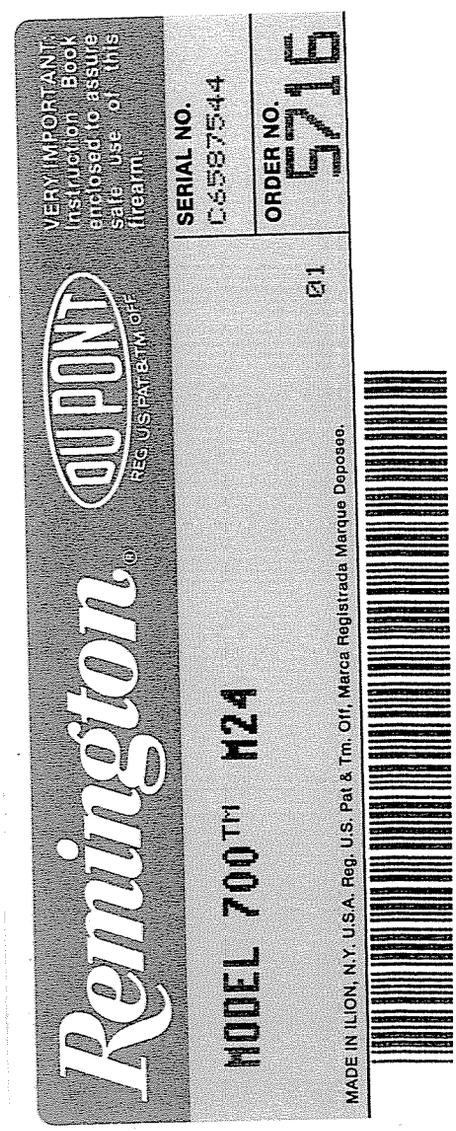
	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.32	3.23		
PULL #2	3.14	3.48		
PULL #3	3.22	3.45		
PULL #4	3.25	3.34		
PULL #5	3.05	3.36		
TOTAL	15.98	16.86		
AVERAGE	3.19	3.37		

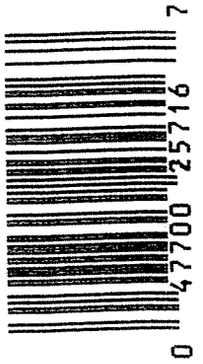
	4.00 LBS INITIAL	4.00 LBS AFTER 20 CYCLES	MAX SETTING GREATER THAN 4 LBS	RESET TO 4 LBS FOR TARGET & ACCURACY
PULL #1	4.22	4.06		4.46
PULL #2	4.08	4.44		4.51
PULL #3	4.44	4.45		4.62
PULL #4	4.21	3.86		4.59
PULL #5	4.16	4.45		4.52
TOTAL	21.11	21.26		22.70
AVERAGE	4.22	4.25		4.54

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

R & E NUMBER	106029			
SERIAL NUMBER	C6587544			
LOG-IN DATE	1-4-06			
OPERATION #	OPERATION NAME		DATE	INITIAL
500	DIS-ASSEMBLE GUN		1-5-06	RTC
505	RE-BARREL		1-6-06	RTC
560	ASSEMBLE		1-6-06	RTC
600	PROOF	MAGNA-FLUX INSPECTED JAN 10 2006	1-6-06	BC
605	CHECK HEADSPACE		1-6-06	AC
610	DIS-ASSEMBLE GUN		1-6-06	AC
612	MAGNAFLUX	OPERATOR [illegible]	1/10/06	[illegible]
510	DRILL AND TAP		1-10-06	TRW
615	ROLLMARK CALIBER		1-10-06	CW
618	ROTO-BLAST		1-10-06	LB
620	APPLY COATINGS		1/11	HP
625	FINAL ASSEMBLY		1-13-06	RTC
640	FUNCTION TEST AND	PASS FAIL	1-16-06	TRW
650	TARGET	PASS FAIL		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION	1-16-06	TRW
670	FINAL INSPECTION		1-23-06	AC
	A) HEADSPACE	PASS FAIL	1-23-06	AC
	B) TRIGGER PULL (+/- .5 LBS, MIN 2.50 LBS, MAX 4.0 LBS)	2.32 2.33 2.34 2.02 2.25		AC
680	F) SAFETY ON FORCE (2 LBS MIN 10 LBS)	5 lbs 5 lbs 5 lbs		AC
	G) SAFETY OFF FORCE (2 LBS MIN)	2 lbs 2 lbs 2 lbs		AC
	I) FIRING PIN INDENT (.020)			
690	PACK		1-24-06	RTC

N/A


Remington
DUPONT
REG. U.S. PAT. & TM. OFF.
VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.
MODEL 700 TM M24
SERIAL NO.
C6587544
ORDER NO.
5716
01
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat & Tm. Off. Marca Registrada Marque Deposee.
5716 C6587544


UPC
0 47700 25716 7

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6587544

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		1023 90	RW
600	Proof		1023 90	RW
607	Check Headspace		1023 90	RW
610	Dis-assemble Gun		1023 90	RW
612	Magnaflux Barrel Action		10/24/90	KP
	Magnaflux Bolt		10/24/90	KP
615	Rollmark Caliber		10/24/90	JS
617	Drill and Tap Sight Holes		10/25/90	FB
618	Polish Barrel RB		10/26/90	WB
620	Apply Coatings (Barrel Action)		11-7-90	TA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		11/12/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		11/12/90	RW
	C) Inspect Ejector Hole for Chamfer		11/12/90	RW
	D) Oil Firing Pin Ass'y		11/12/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		11/19/90	WB

QUALITY AUDIT

op. #	OP. NAME	READINGS			DATE	INIT
625 cont.	F) Safety On Force	4 3/4	4 3/4	4 3/4	11/19/90	WB
	G) Safety Off Force	2 3/4	2 3/4	2 3/4	11/19/90	WB
	H) Trigger Pull Test & Retainability				11/19/90	WB
	I) Firing Pin Indent	.0235	.0235	.0235	11/19/90	WB
	J) Assemble Stock				11/26/90	RW
	K) Assemble Swivel Studs				11-27-90	DSS
	L) Attach Front and Rear Sight Assemblies				11/26/90	RW
	M) Iron Sight Alignment				11/26/90	RW
	N) Detach Front & Rear Sights & place in numbered container				11/26/90	RW
	O) Attach Scope to Rifle				11/26/90	RW
	P) Detach & Attach Scope 20 Times				11/26/90	RW
640	Gallery Target & Test				11/26/90	VF
	A) Time				"	VF
	B) Malfunctions				"	VF
	C) Pierced Primers				"	VF
	D) Optical Clearity of Scope				"	VF
645	Inspect for Live Ammo				11/26/90	VF
655	Final Inspection A) Headspace				11-27-90	DSS
	B) Trigger Pull	281	259	244	268	252	11-27-90	DSS
	C) Function				11-27-90	DSS
660	Pack				12/14/90	VF

SWS TRIGGER PULL TEST

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

SERIAL NO. C6587544
DATE 11/19/90
TESTER WB

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.46	2.29	2.23	281	MIN. SETTING,
PULL #2	2.38	2.33	2.20	259	NO AVG. OF 5
PULL #3	2.34	2.35	2.36	244	READINGS ACCEPT-
PULL #4	2.31	2.30	2.37	268	ABLE LESS THAN 2#
PULL #5	2.35	2.46	2.18	252	
TOTAL	11.84	11.73	11.34		
AVG.	2.37	2.35	2.27		

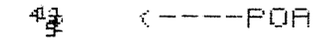
	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.35	3.32		
PULL #2	3.38	3.24		
PULL #3	3.32	3.35		
PULL #4	3.36	3.26		
PULL #5	3.23	3.41		
TOTAL	16.74	16.58		
AVG.	3.35	3.31		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.38	4.36		4.00
PULL #2	4.37	4.35		4.22
PULL #3	4.24	4.39		4.13
PULL #4	4.12	4.33		4.11
PULL #5	4.29	4.38		4.19
TOTAL	21.40	21.81		20.65
AVG.	4.28	4.36		4.13

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6587544
27 Nov 1990

CENTROIDAL DISTANCES

0	TO	1	.260634
1	TO	2	.343874
1	TO	3	.217706
1	TO	4	.143136
1	TO	5	.346182

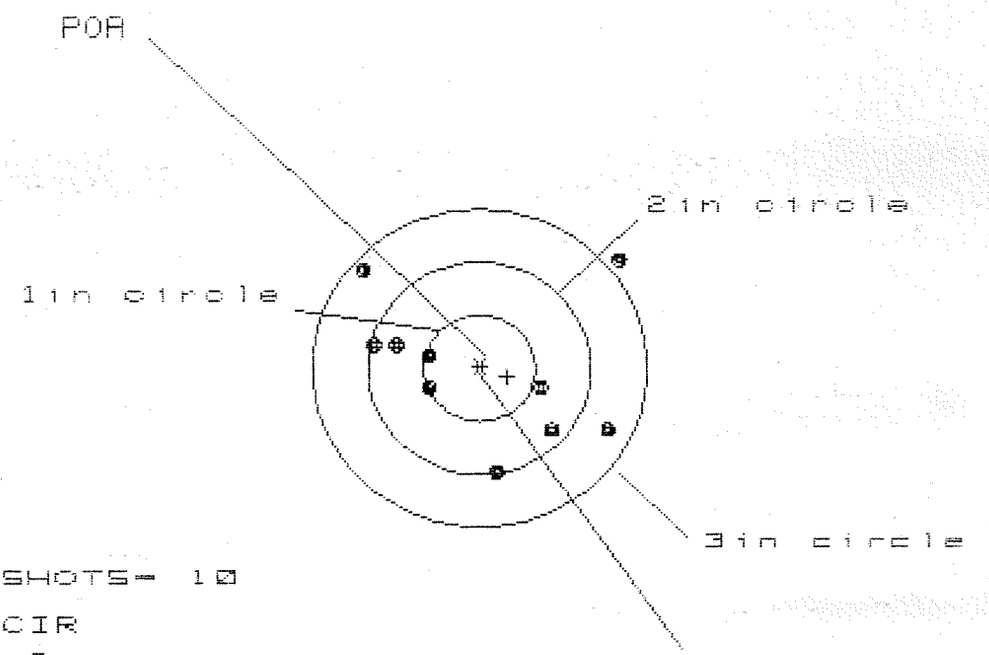


THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.141
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0348
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .145231

THE AMR FOR THIS RIFLE IS: .9054

27 Nov 1998 FILE:/PATTERNING/CENTERFIRE_PATT/C6587544

CENTERFIRE PATTERNS # 1

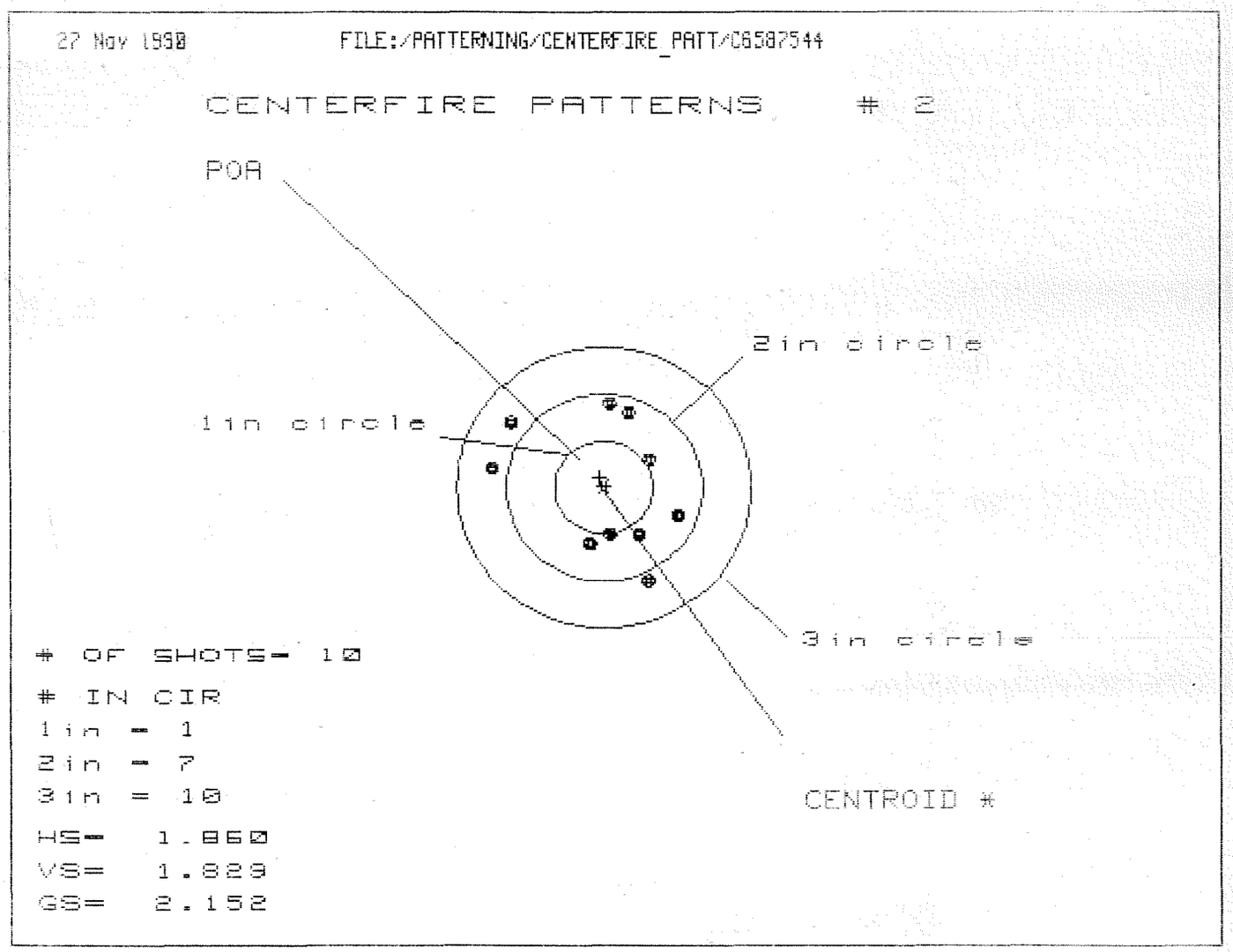


OF SHOTS= 10

# IN CIR
1in = 2
2in = 7
3in = 9

HS= 2.336
VS= 1.928
GS= 2.593

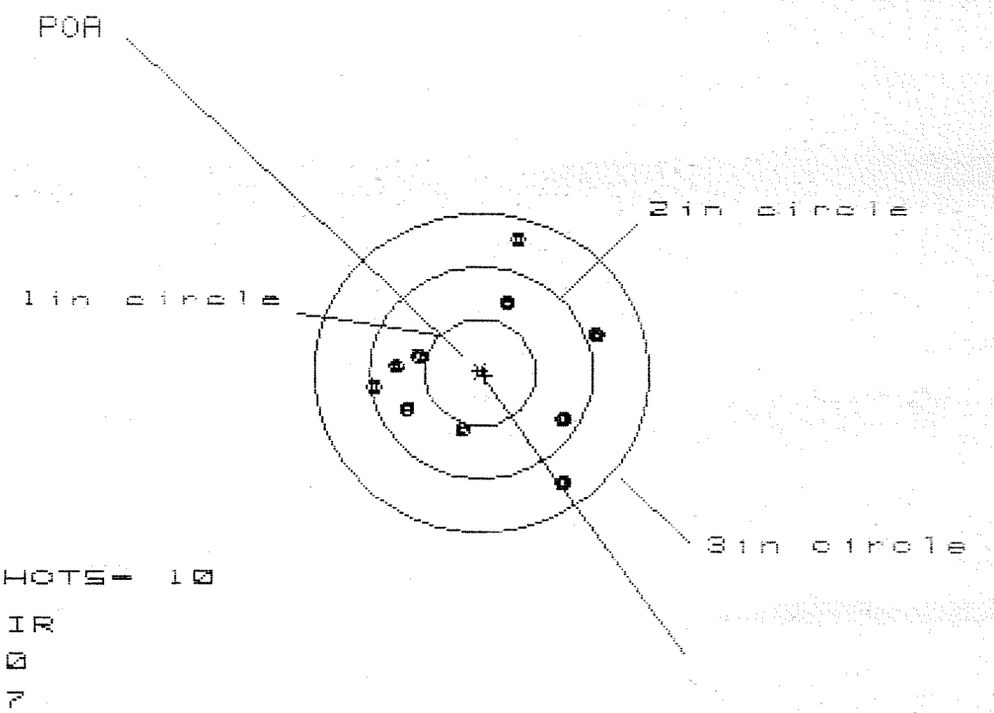
PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.267	1.247	1.131
MINIMUM X	:	-1.069	-.928	-.949
MAXIMUM Y	:	.987	.984	.444
MINIMUM Y	:	-.939	-.829	-.706
CENTROID X	:	-.249	-.390	-.279
CENTROID Y	:	.077	-.033	-.156
POA TO CENTROID in.	:	.260	.391	.315
MIN RADIUS	:	.443	.272	.382
MEAN RADIUS	:	.922	.813	.748
MAX RADIUS	:	1.606	1.353	1.171
HORIZONTAL SPREAD	:	2.336	2.175	2.079
VERTICAL SPREAD	:	1.926	1.813	1.150
EXTREME SPREAD	:	2.593	2.593	2.210
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	



PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.742	.641	.488
MINIMUM X	:	-1.118	-1.219	-.446
MAXIMUM Y	:	.874	.957	.990
MINIMUM Y	:	-.955	-.872	-.839
CENTROID X	:	.044	.145	.298
CENTROID Y	:	-.103	-.186	-.219
POA TO CENTROID in.	:	.112	.236	.370
MIN RADIUS	:	.482	.431	.394
MEAN RADIUS	:	.811	.742	.652
MAX RADIUS	:	1.179	1.247	1.014
HORIZONTAL SPREAD	:	1.860	1.860	.934
VERTICAL SPREAD	:	1.829	1.829	1.829
EXTREME SPREAD	:	2.152	1.922	1.867
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

27 Nov 1990 FILE:/PATTERNING/CENTERFIRE_PATT/C8587544

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

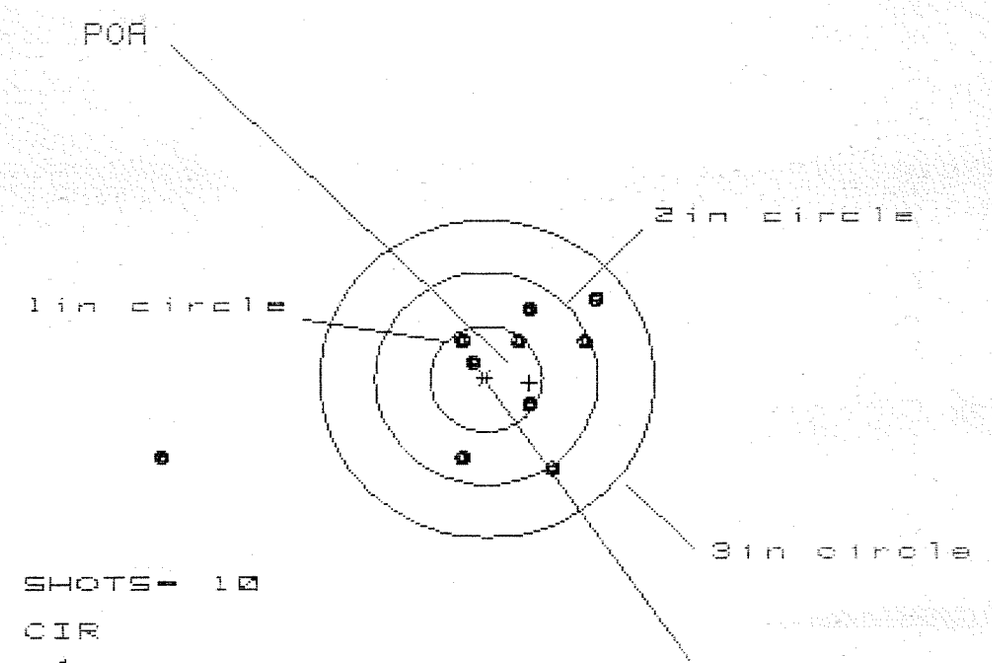
# IN CIR
1in = 0
2in = 7
3in = 10

HS= 1.961
VS= 2.291
GS= 2.324

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.001	1.039	1.135
MINIMUM X	:	-.960	-.922	-.827
MAXIMUM Y	:	1.241	.805	.691
MINIMUM Y	:	-1.050	-.912	-.519
CENTROID X	:	-.035	-.073	-.169
CENTROID Y	:	.037	-.101	.013
POA TO CENTROID in.	:	.051	.124	.169
MIN RADIUS	:	.569	.426	.462
MEAN RADIUS	:	.875	.811	.743
MAX RADIUS	:	1.286	1.191	1.203
HORIZONTAL SPREAD	:	1.961	1.961	1.961
VERTICAL SPREAD	:	2.291	1.717	1.210
EXTREME SPREAD	:	2.324	2.033	2.033
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

27 Nov 1990 FILE:/PATTERNING/CENTERFIRE_PATT/C6587544

CENTERFIRE PATTERNS # 4

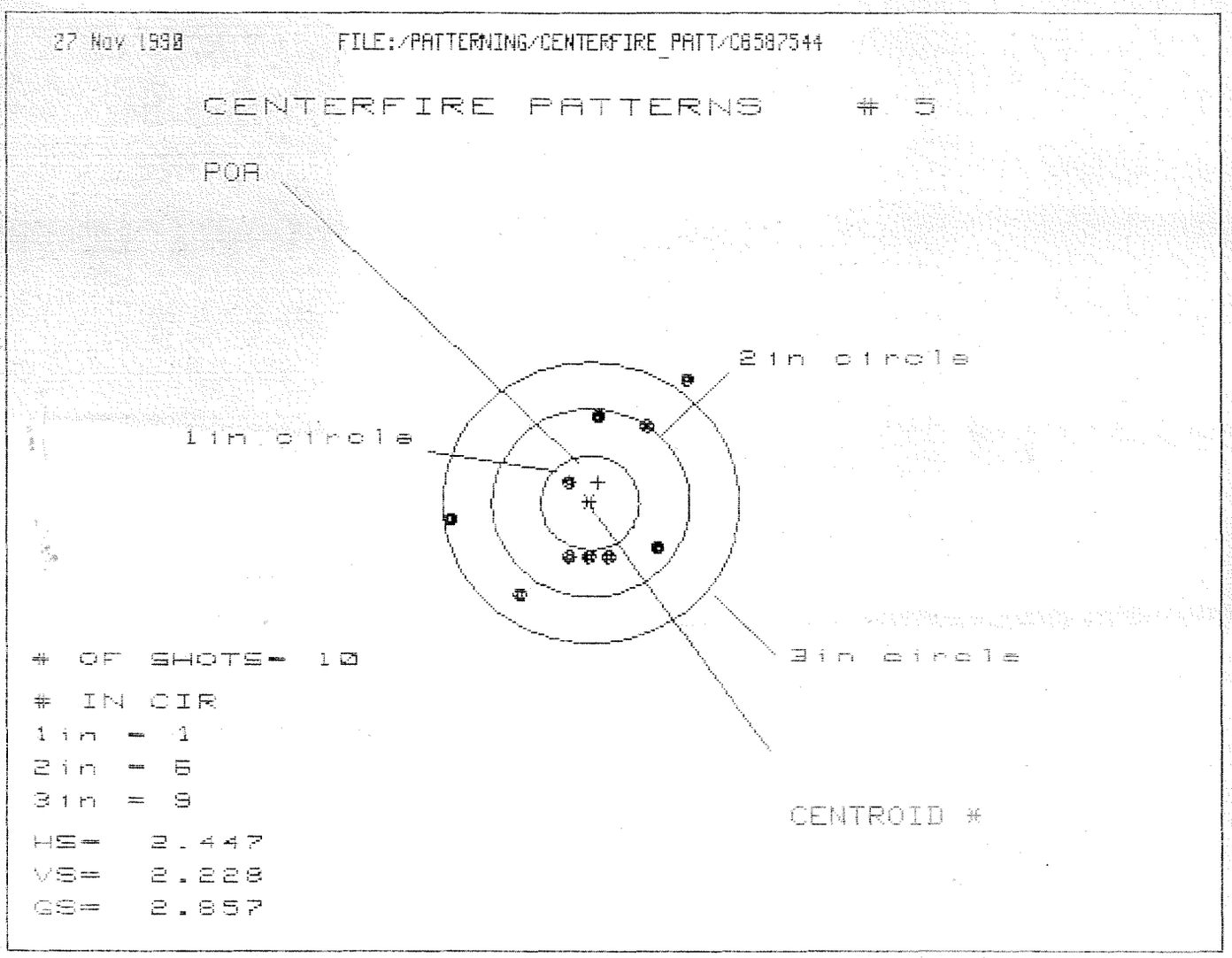


# OF SHOTS= 10
# IN CIR
1in = 4
2in = 7
3in = 9
HS= 3.980
VS= 1.612
GS= 4.268

PATTERN # : **4**

SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.018	.689	.671
MINIMUM X	:	-2.962	-.560	-.473
MAXIMUM Y	:	.758	.671	.642
MINIMUM Y	:	-.854	-.941	-.857
CENTROID X	:	-.387	-.058	-.145
CENTROID Y	:	.039	.126	.043
POA TO CENTROID in.	:	.389	.139	.151
MIN RADIUS	:	.235	.254	.292
MEAN RADIUS	:	.935	.643	.599
MAX RADIUS	:	3.064	.979	.928
HORIZONTAL SPREAD	:	3.980	1.249	1.144
VERTICAL SPREAD	:	1.612	1.612	1.499
EXTREME SPREAD	:	4.268	1.896	1.516

NUMBER IN ONE INCH CIRCLE = 4
NUMBER IN TWO INCH CIRCLE = 7
NUMBER IN THREE INCH CIRCLE = 9



PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.012	.817	.652
MINIMUM X	:	-1.435	-1.323	-.760
MAXIMUM Y	:	1.286	1.045	1.040
MINIMUM Y	:	-.942	-.799	-.804
CENTROID X	:	-.078	-.190	-.025
CENTROID Y	:	-.224	-.367	-.362
POA TO CENTROID in.	:	.238	.414	.363
MIN RADIUS	:	.346	.409	.418
MEAN RADIUS	:	.914	.807	.731
MAX RADIUS	:	1.637	1.324	1.127
HORIZONTAL SPREAD	:	2.447	2.140	1.412
VERTICAL SPREAD	:	2.228	1.844	1.844
EXTREME SPREAD	:	2.857	2.287	2.217
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	