

C6587549

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

Armies 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: **RE00092669** Serial: C6587549 Model: M24 SWS Center Fire Caliber: 7.62 NATO Repairman: Status: Closed 2/8/2005 7:41:36 AM

Verify Repair

Address Information

Customer: ☒ Received From Return To: ☐ Received From

Name: DEF DIST DEPOT ANNISTON DEF DIST DEPOT ANNISTON

Address 1: Address 2: PO Box: PO Box:

City: ANNISTON ANNISTON

State: AL Zip Code: 362014199 Country: US State: AL Zip Code: 362014199 Country: US

FFL: ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐

Contact / Condition Problems Estimate History / Status Shipping / Billing

Contact Information: Phone: Fax: Email: Comments:

Received Condition: Good Condition Notes: CSR Notes:

Accessories Received:

Code	Desc	Qty
A007	With Stud	3
A010	Hard Case	1
A017	Scope Base	1
A026	Scope	1
A057	Frt and Rear Sgt Base	1

Repair Search Refresh Close

magletj 2/8/2005 9:43 AM CAPS NUM INS SCPL

start 3 4

Serial Number: **C6587549**

Model: **M24 SWS**



RE00092669

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 3-7-05

TESTER TRL

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.79	2.12		2.82	
PULL #2	2.11	2.16		2.80	
PULL #3	2.04	2.44		2.77	
PULL #4	2.04	2.34		2.75	
PULL #5	2.03	2.36		2.72	
TOTAL	11.01	11.42		13.86	
AVERAGE	2.20	2.28		2.77	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.30	3.25		
PULL #2	3.34	3.39		
PULL #3	3.50	3.43		
PULL #4	3.37	3.43		
PULL #5	3.52	3.08		
TOTAL	17.03	16.58		
AVERAGE	3.40	3.31		

	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	4.24	4.10		4.09
PULL #2	4.24	4.31		4.02
PULL #3	4.00	4.26		3.93
PULL #4	4.46	4.16		4.15
PULL #5	4.38	4.22		4.10
TOTAL	21.32	21.05		20.29
AVERAGE	4.26	4.21		4.05

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6587549.___0
FILE DATE AND TIME: 03/09/2005 07:43

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.080
The Average Y Centroid of the Five Target Set:	-0.037
The Average Point of Impact of the Five Target Set:	0.089
The Average Mean Radius of the Five Target Set:	0.961
The Distance from POA to Centroid Target #1:	0.322
The Distance from Centroid Target #2 to Centroid Target #1:	0.128
The Distance from Centroid Target #3 to Centroid Target #1:	0.409
The Distance from Centroid Target #4 to Centroid Target #1:	0.175
The Distance from Centroid Target #5 to Centroid Target #1:	0.725

SERIAL NUMBER: C6587549. 0

TARGET NUMBER: 1

FILE DATE: 03/09/2005

FILE TIME: 07:43

POINT#	X	Y
1:	1.038	-0.567
2:	0.945	-0.378
3:	0.758	-0.261
4:	0.361	-0.982
5:	-0.468	-0.033
6:	0.028	0.583
7:	-0.187	0.776
8:	-0.630	0.670
9:	-0.235	0.466
10:	-2.339	-3.414

X CENTROID: -0.073

Y CENTROID: -0.314

POA TO CENTROID: 0.322

HORZ SPREAD: 3.377

VERT SPREAD: 4.190

GROUP SPREAD: 4.710

MIN RADIUS: 0.485

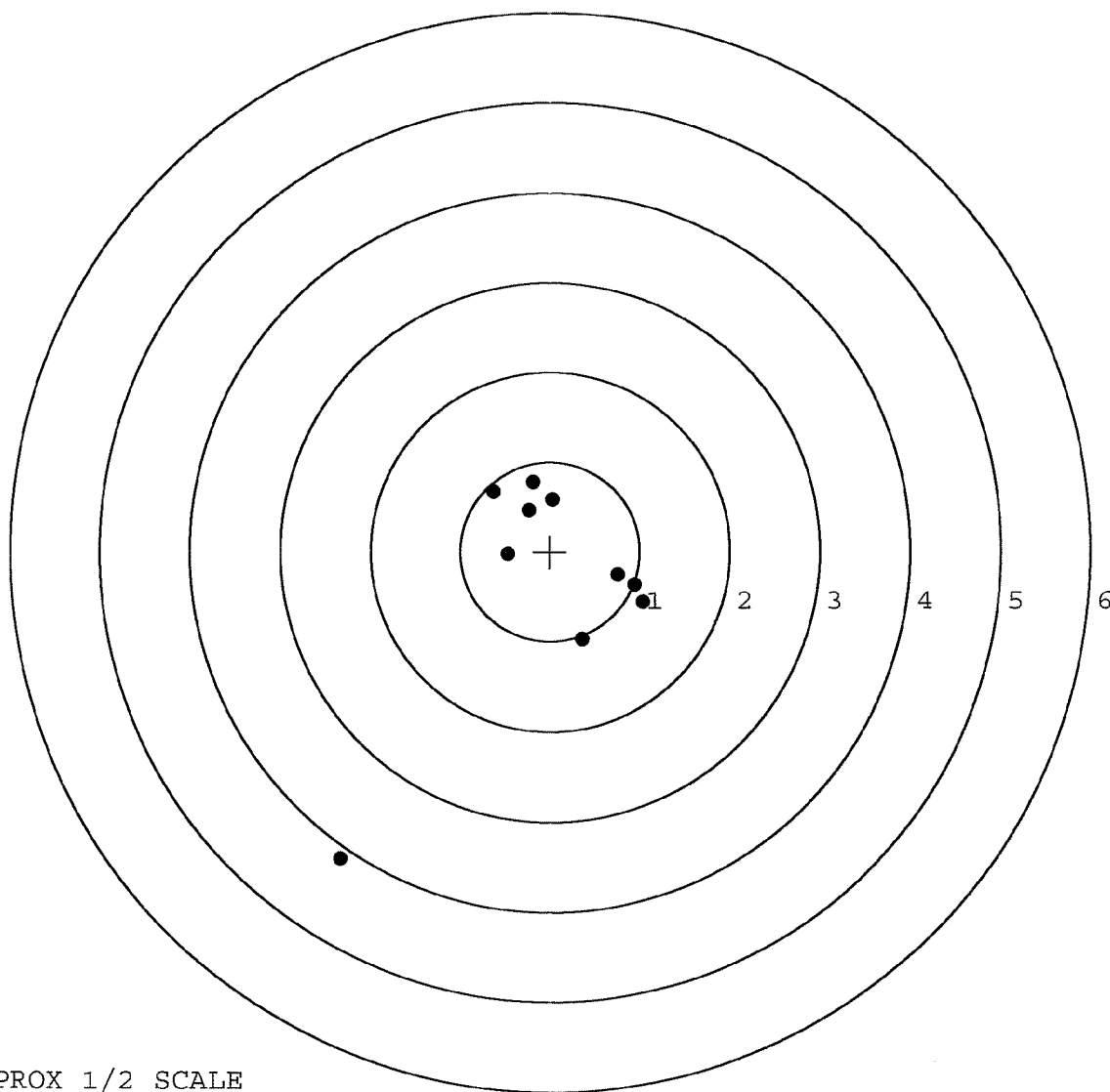
MAX RADIUS: 3.840

MEAN RADIUS: 1.204

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 5

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6587549. 0

TARGET NUMBER: 2

FILE DATE: 03/09/2005

FILE TIME: 07:43

X CENTROID: -0.111

Y CENTROID: -0.192

POA TO CENTROID: 0.222

HORZ SPREAD: 2.780

VERT SPREAD: 2.737

GROUP SPREAD: 2.843

MIN RADIUS: 0.140

MAX RADIUS: 1.801

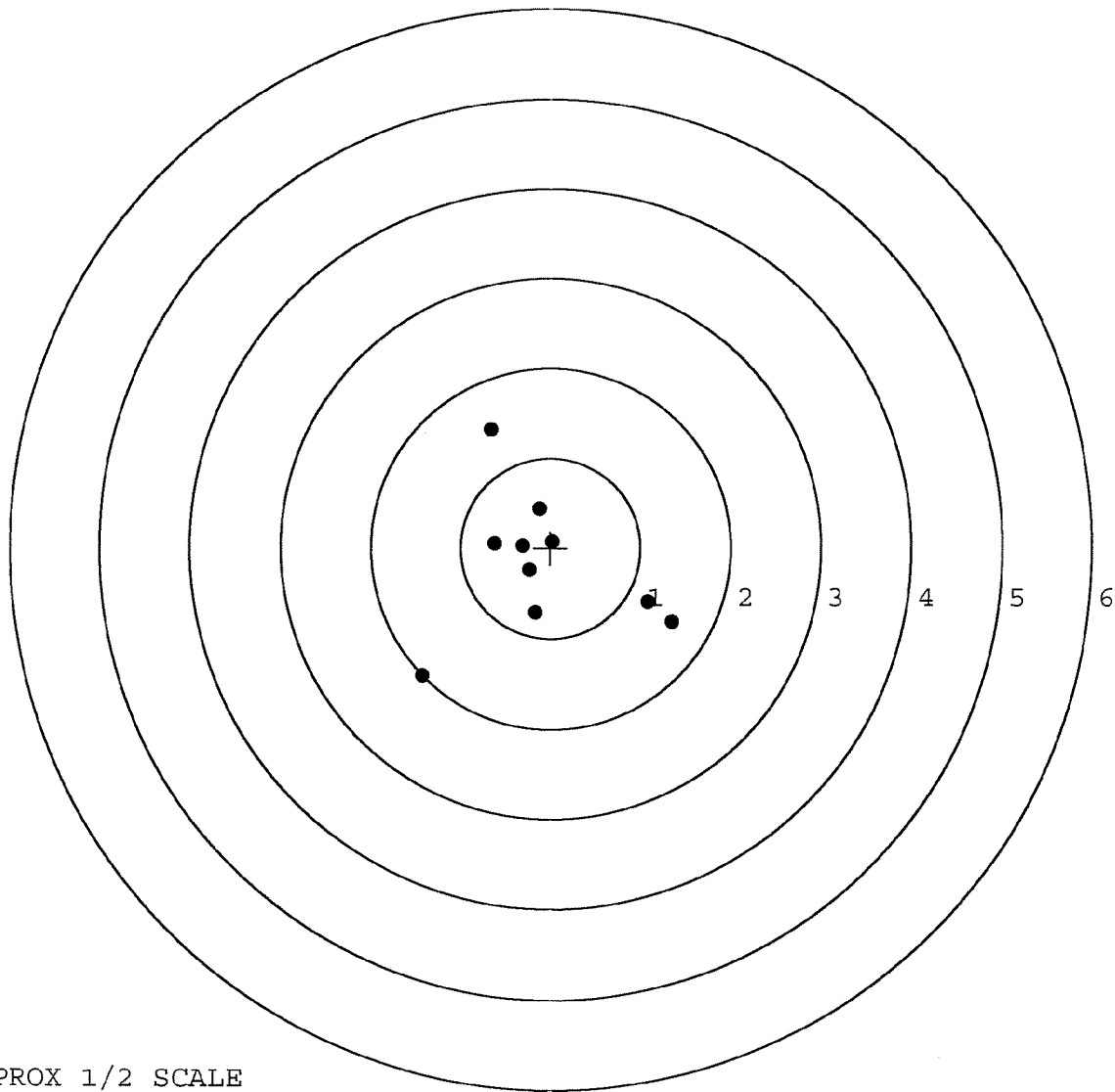
MEAN RADIUS: 0.872

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 7

POINT#	X	Y
1:	1.349	-0.822
2:	1.081	-0.601
3:	-0.173	-0.722
4:	-1.431	-1.418
5:	-0.122	0.434
6:	-0.624	0.053
7:	0.023	0.067
8:	-0.238	-0.252
9:	-0.312	0.022
10:	-0.666	1.319



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6587549. __0

TARGET NUMBER: 3

FILE DATE: 03/09/2005

FILE TIME: 07:43

X CENTROID: 0.075

Y CENTROID: 0.067

POA TO CENTROID: 0.101

HORZ SPREAD: 1.370

VERT SPREAD: 2.383

GROUP SPREAD: 2.409

MIN RADIUS: 0.140

MAX RADIUS: 1.525

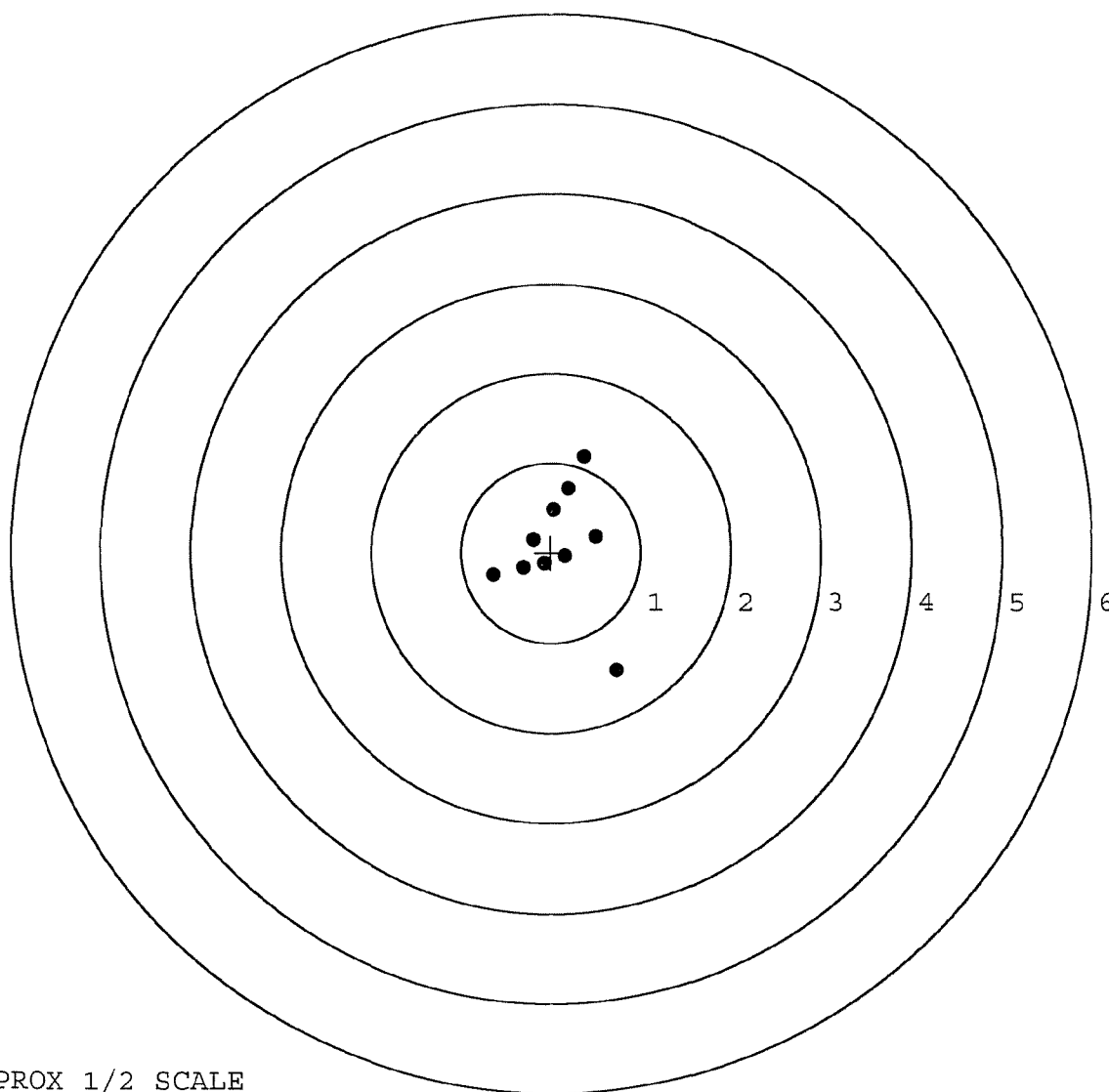
MEAN RADIUS: 0.598

IN 1 IN DIAMETER: 6

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 9

POINT#	X	Y
1:	0.502	0.178
2:	0.371	1.072
3:	0.189	0.709
4:	0.026	0.477
5:	0.158	-0.045
6:	-0.195	0.142
7:	-0.074	-0.124
8:	-0.311	-0.173
9:	-0.643	-0.251
10:	0.727	-1.311



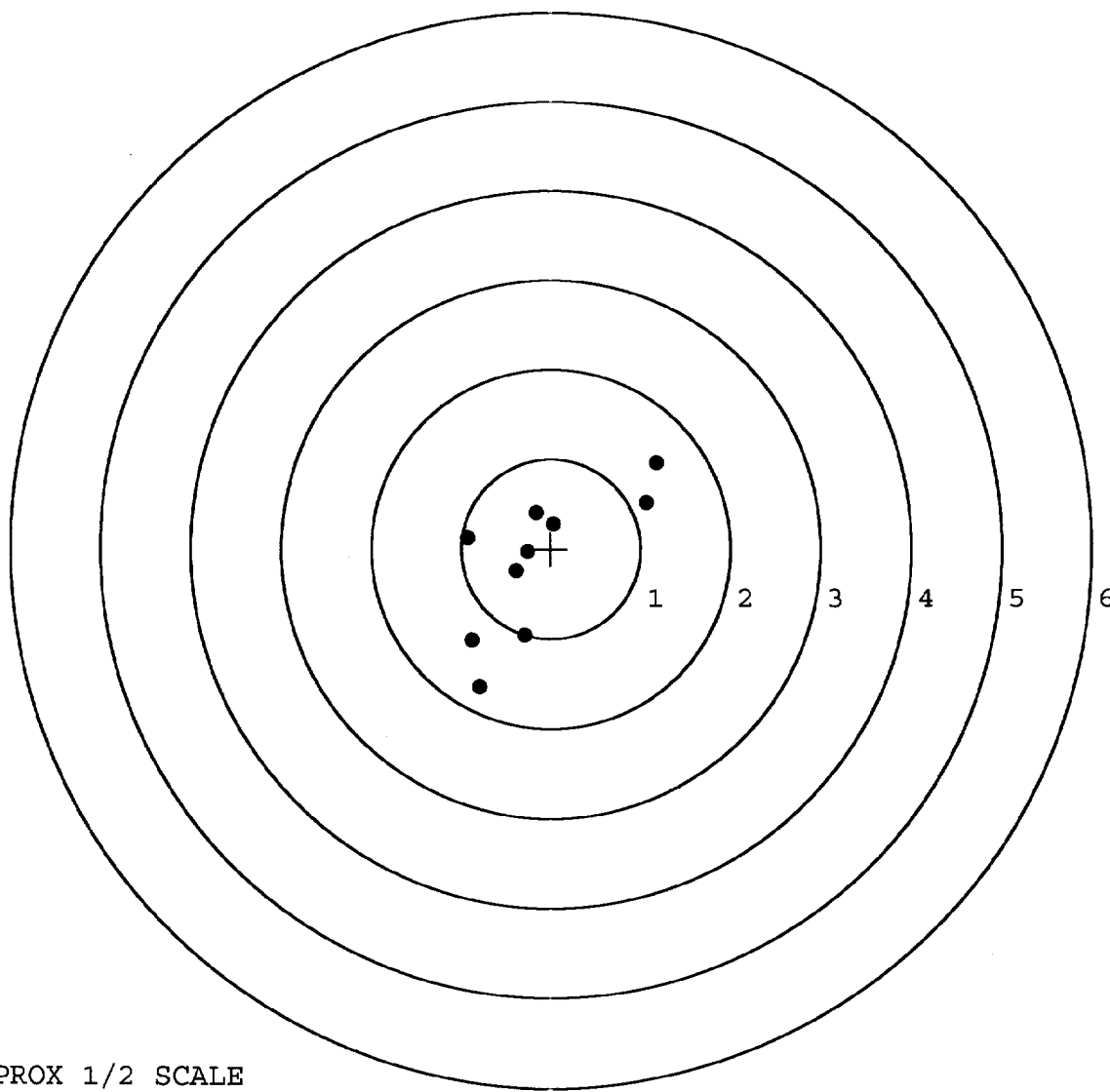
TARGET APPROX 1/2 SCALE

BARBER - M24 0022513

SERIAL NUMBER: C6587549. __ 0
 TARGET NUMBER: 4
 FILE DATE: 03/09/2005
 FILE TIME: 07:43

POINT#	X	Y
1:	1.066	0.517
2:	1.174	0.956
3:	-0.170	0.401
4:	0.030	0.276
5:	-0.265	-0.035
6:	-0.388	-0.250
7:	-0.298	-0.969
8:	-0.799	-1.545
9:	-0.882	-1.023
10:	-0.933	0.125

X CENTROID: -0.147
 Y CENTROID: -0.155
 POA TO CENTROID: 0.213
 HORZ SPREAD: 2.107
 VERT SPREAD: 2.501
 GROUP SPREAD: 3.186
 MIN RADIUS: 0.168
 MAX RADIUS: 1.726
 MEAN RADIUS: 0.890
 # IN 1 IN DIAMETER: 3
 # IN 2 IN DIAMETER: 6
 # in 3 IN DIAMETER: 8



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6587549. 0

TARGET NUMBER: 5

FILE DATE: 03/09/2005

FILE TIME: 07:43

POINT#	X	Y
1:	2.017	1.158
2:	0.646	0.328
3:	1.031	-0.120
4:	0.048	-0.709
5:	-0.175	-0.224
6:	-0.636	-0.092
7:	-0.847	0.139
8:	-0.241	1.716
9:	-1.416	1.620
10:	-1.890	0.254

X CENTROID: -0.146

Y CENTROID: 0.407

POA TO CENTROID: 0.432

HORZ SPREAD: 3.907

VERT SPREAD: 2.425

GROUP SPREAD: 4.010

MIN RADIUS: 0.632

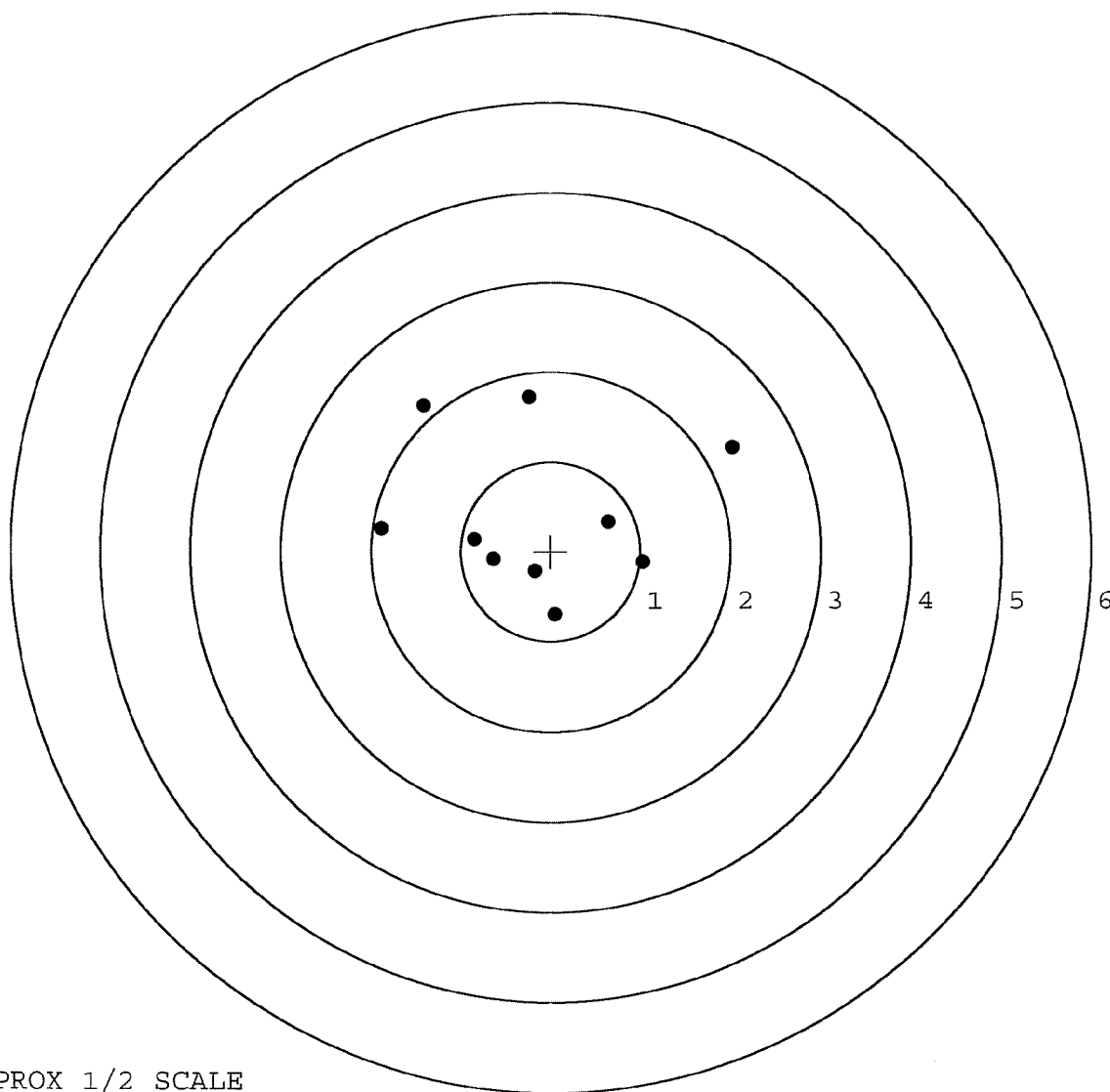
MAX RADIUS: 2.290

MEAN RADIUS: 1.241

IN 1 IN DIAMETER: 0

IN 2 IN DIAMETER: 4

in 3 IN DIAMETER: 7



TARGET APPROX 1/2 SCALE

M-24 INSPECTION CHECKLIST
CONTRACT #: DAAE-20-02-D-0127

R & E NUMBER	92669		
SERIAL NUMBER	C6587549		
LOG-IN DATE	2-8-05		
INSPECT AND VERIFY:			
OPERATION #	OPERATION NAME	DATE	INITIAL
550	DIS-ASSEMBLE GUN	2-12-05	RTL
560 A	RE-BARREL	2-16-05	RTL
B	DRILL AND TAP	2-17-05	TRW
575	ASSEMBLE	2-16-05	RTL
600	PROOF	2-17-05	MAGNA-FLUX INSPECTED
605	CHECK HEADSPACE	2-17-05	AC
610	DIS-ASSEMBLE GUN	2-17-05	RTL
612	MAGNAFLUX		OPERATOR
615	ROLLMARK CALIBER	2-18-05	CW
618	ROTO-BLAST	2-18-05	LB
620	APPLY COATINGS	3-1-05	HP
625 A	FINAL ASSEMBLY	3-7-05	RTL
B	TRIGGER PULL TEST	3-17-05	TRW
C	SAFETY "ON" FORCE	3-17-05	AC
D	SAFETY "OFF" FORCE	3-17-05	AC
E	FIRING PIN INDENT	3-17-05	AC
640	TARGET	3-9-05	AC
655	FINAL INSPECT	3-17-05	AC
660	PACK	3-17-05	DA
		SHIP DATE	
		QAR INSPECTION DATE	

BARBER - M24 9022516 RECEIVING AND ESTIMATING REPORT

COMMENTS

ORDER
R 94-21340

INITIAL JJM	CUSTOMER ORDER NO.		W/LEUPOLD 10X SCOPE, DEPLOYMENT KIT			
DATE RECEIVED 07/15/94	DATE OPENED 07/18/94	DATE CODE	SERIAL NUMBER C6587549	NEW SERIAL NUMBER	MODEL AND GRADE Scope S/N 90 0772	NATO
ACCESSORIES SCOPE MNTS		SCOPE BASE				

FROM:

SHIP TO:

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

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

CUST NO: 098397 C-D-DL

ACCOUNT NUMBER	ACCOUNT NUMBER N/C	WRITE ☐	PROM. DATE	ESTIMATED	VIA UPS
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- 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				
✓ Front & Rear Sight Assy					
✓ New Barrel					
✓ Stock					
✓ Trigger Assy					
✓ Firing Pin Assy					
✓ Mag Box					
✓ Mag Spring					
✓ Mag Follower					
REPAIRMAN	PROOF	CLEAN	TEST	TARGET	PATTERN
GALLERY TESTER	DATE	DATE	DATE	DATE	DATE
			5/14/96	5/14/96	

OFFICE COPY

RD6925 REV. 1/94

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

BARBER - M24 9022516

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. 65 87549

DATE 5-7-96

TESTER _____

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#	COMMENTS
PULL #1	2.25	2.29	2.49	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.26	2.29	2.50	
PULL #3	2.25	2.31	2.49	
PULL #4	2.27	2.30	2.45	
PULL #5	2.30	2.39	2.45	
TOTAL	11.33	11.58	12.38	
AVG.	2.26	2.31	2.47	

	3.00# INITIAL	3.00# AFTER 20 CYCLES	COMMENTS
PULL #1	3.35	3.32	
PULL #2	3.39	3.26	
PULL #3	3.40	3.25	
PULL #4	3.41	3.23	
PULL #5	3.29	3.28	
TOTAL	16.83	16.34	
AVG.	3.36	3.26	

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.27	4.26		4.09
PULL #2	4.10	4.25		4.12
PULL #3	4.30	4.00		4.12
PULL #4	4.29	4.25		4.11
PULL #5	4.00	4.21		4.13
TOTAL	20.96	20.97		20.57
AVG.	4.19	4.19		4.11

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6587549
18 Mar 1900

CENTROIDAL DISTANCES

0 TO	1	.336305
1 TO	2	.537217
1 TO	3	.163933
1 TO	4	.27425
1 TO	5	.297123

<----POA

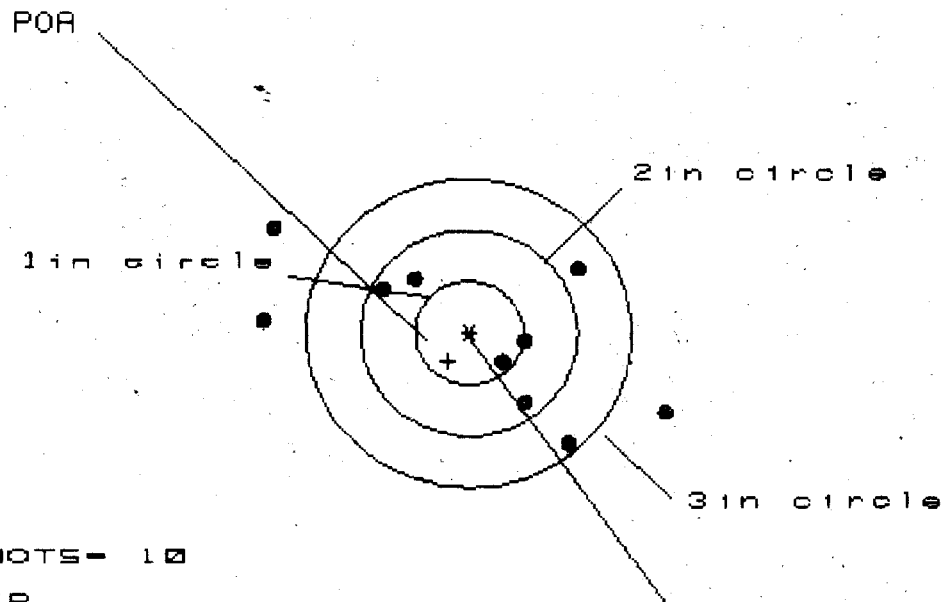
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0348
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .134
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .138445

THE AMR FOR THIS RIFLE IS: 1.102

18 Mar 1900

FILE:/PATTERNING/CENTERFIRE_PATT/C6587549

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 7

HS= 3.639

VS= 2.179

GS= 3.981

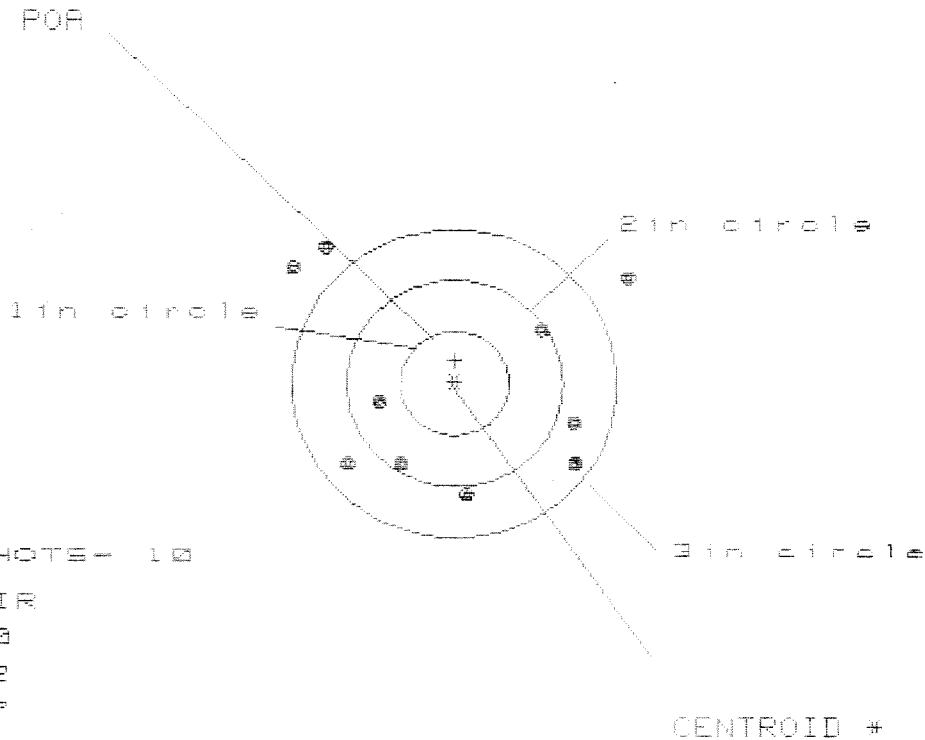
CENTROID *

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.762	1.563	1.004
MINIMUM X	:	-1.877	-2.076	-1.881
MAXIMUM Y	:	1.059	.766	.689
MINIMUM Y	:	-1.120	-1.003	-1.080
CENTROID X	:	.195	.394	.199
CENTROID Y	:	.274	.157	.234
POA TO CENTROID in.	:	.336	.424	.307
MIN RADIUS	:	.405	.179	.377
MEAN RADIUS	:	1.174	1.019	.966
MAX RADIUS	:	2.081	2.095	1.892
HORIZONTAL SPREAD	:	3.639	3.639	2.885
VERTICAL SPREAD	:	2.179	1.769	1.769
EXTREME SPREAD	:	3.981	3.749	3.026
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		7	

18 Mar 1968

FILE:/PATTERNING/CENTERFIRE_PATT/C8587549

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 0

2in = 0

3in = 7

HS= 3.093

VS= 2.374

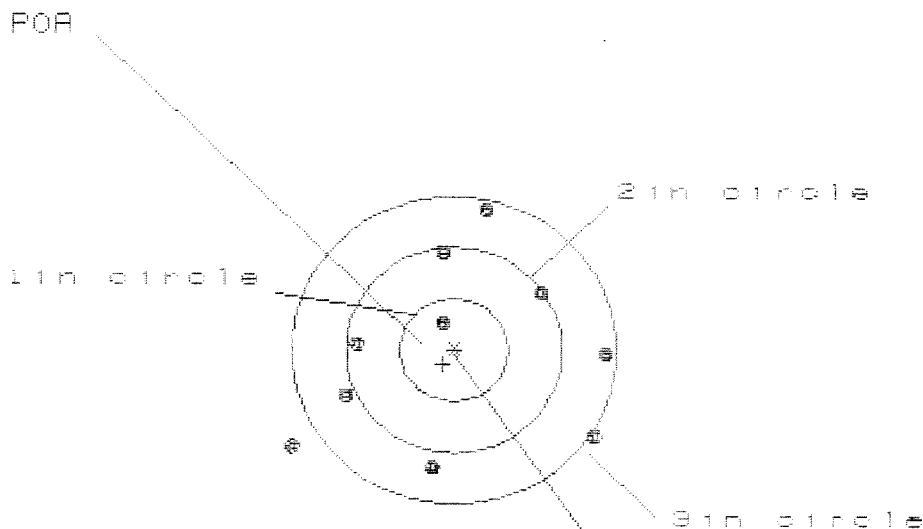
CS= 3.206

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.631	1.297	1.137
MINIMUM X	-1.462	-1.281	-1.206
MAXIMUM Y	1.286	1.486	1.552
MINIMUM Y	-1.088	-0.974	-0.822
CENTROID X	-0.004	-0.185	-0.025
CENTROID Y	-0.225	-0.339	-0.491
POA TO CENTROID in.	.225	.386	.492
MIN RADIUS	.700	.499	.658
MEAN RADIUS	1.303	1.198	1.100
MAX RADIUS	1.926	1.766	1.966
HORIZONTAL SPREAD	3.093	2.578	2.343
VERTICAL SPREAD	2.374	2.374	2.374
EXTREME SPREAD	3.206	3.206	3.140
NUMBER IN ONE INCH CIRCLE	=	0	
NUMBER IN TWO INCH CIRCLE	=	2	
NUMBER IN THREE INCH CIRCLE	=	7	

18 Mar 1968

FILE:/PATTERNING/CENTERFIRE_PATT/06587549

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 4

3 in = 8

HE= 2.212

VS= 2.506

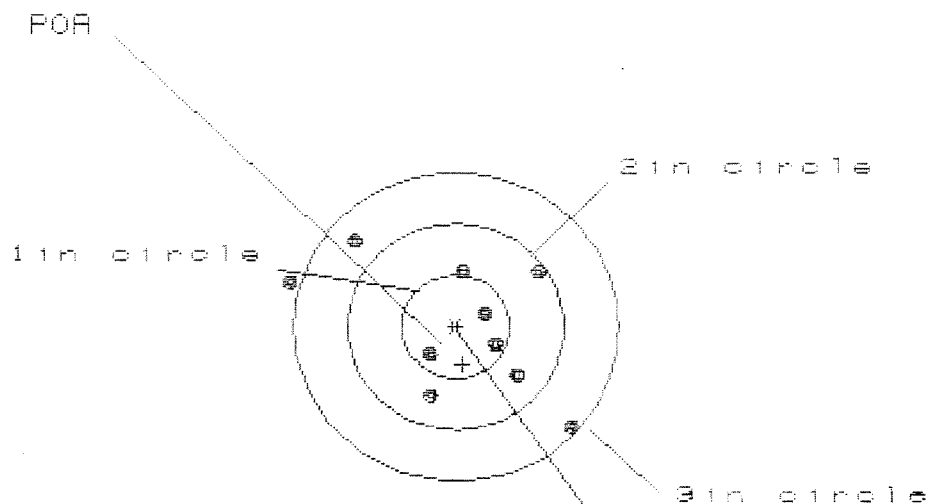
GS= 3.033

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.390	1.221	1.368
MINIMUM X	-1.522	-1.191	-1.044
MAXIMUM Y	1.393	1.294	1.183
MINIMUM Y	-1.113	-1.212	-1.323
CENTROID X	.102	.271	.124
CENTROID Y	.139	.239	.350
POA TO CENTROID in.	.173	.361	.372
MIN RADIUS	.287	.306	.122
MEAN RADIUS	1.151	1.070	.979
MAX RADIUS	1.764	1.476	1.391
HORIZONTAL SPREAD	2.912	2.412	2.412
VERTICAL SPREAD	2.506	2.506	2.506
EXTREME SPREAD	3.033	2.576	2.576
NUMBER IN ONE INCH CIRCLE	=	1	
NUMBER IN TWO INCH CIRCLE	=	4	
NUMBER IN THREE INCH CIRCLE	=	8	

18 Mar 1968

FILE:/PATTERNING/CENTERFIRE_PATT/06587543

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 7

3 in = 9

HS= 2.656

VS= 1.753

GS= 3.003

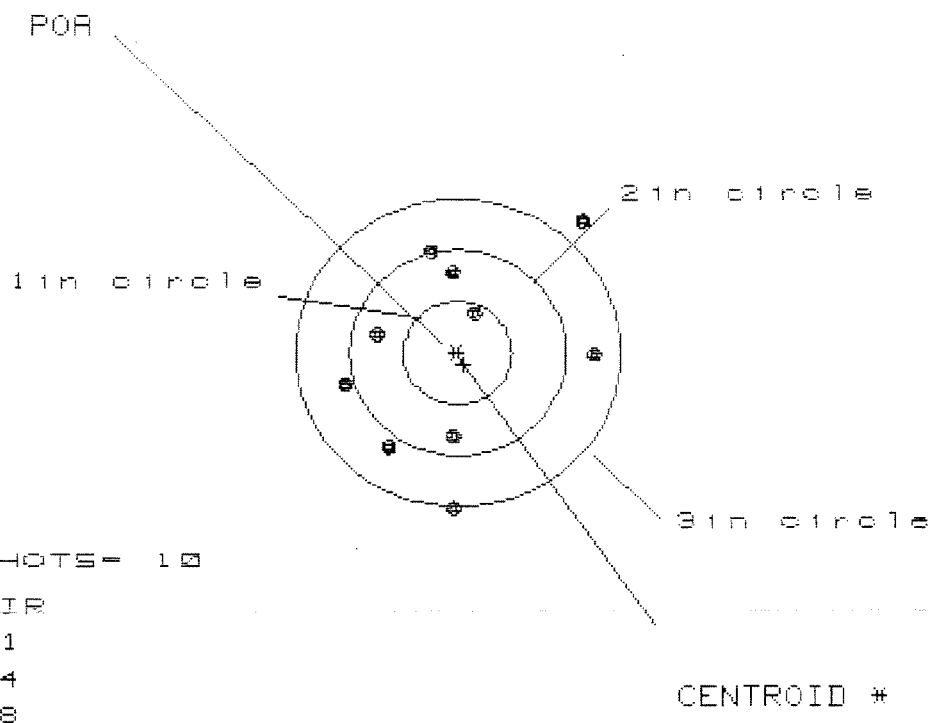
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.083	.908	.671
MINIMUM X	-1.573	-1.132	-1.019
MAXIMUM Y	.806	.856	.744
MINIMUM Y	-.947	-.897	-.764
CENTROID X	-.071	.112	-.001
CENTROID Y	.351	.317	.429
POA TO CENTROID in.	.374	.336	.429
MIN RADIUS	.323	.283	.244
MEAN RADIUS	.837	.714	.653
MAX RADIUS	1.637	1.419	1.261
HORIZONTAL SPREAD	2.656	2.040	1.690
VERTICAL SPREAD	1.753	1.753	1.508
EXTREME SPREAD	3.003	2.690	2.004
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	9		

18 Mar 1988

FILE:/PATTERNING/CENTERFIRE_PATT/06587549

CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 4

3 in = 8

HS= 2.308

VS= 2.777

GS= 3.027

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.295	1.428	1.444
MINIMUM X	:	-1.013	-.980	-.864
MAXIMUM Y	:	1.257	1.159	.986
MINIMUM Y	:	-1.520	-1.380	-.935
CENTROID X	:	-.255	-.189	-.205
CENTROID Y	:	.147	.325	.147
POA TO CENTROID in.	:	1.128	1.191	.253
MIN RADIUS	:	.384	.572	.449
MEAN RADIUS	:	1.045	.957	.879
MAX RADIUS	:	1.737	1.437	1.444
HORIZONTAL SPREAD	:	2.308	2.308	2.308
VERTICAL SPREAD	:	2.777	2.539	1.922
EXTREME SPREAD	:	3.027	2.546	2.333
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C 6587549

OP. #	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and Stock			
600	Proof			
607.	Check Headspace			
610	Dis-assemble Gun			
612	Magnaflux Barrel Action			
	Magnaflux Bolt			
615	Rollmark Caliber			
617	Drill and Tap Sight Holes			
618	Polish Barrel			
620	Apply Coatings (Barrel Action)			
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly			
	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. #	BARBER - M24 0022525 OP. NAME	READINGS				DATE	INIT
625 cont.	F) Safety On Force	6	6	6		5/29/96	AC
	G) Safety Off Force	3	3	3		5/29/96	AC
	H) Trigger Pull Test & Retainability						
	I) Firing Pin Indent	.023	.023	.023		5/29/96	AC
	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	2.52	2.77	2.72	2.71	2.73	5/29/96 WB
	C) Function						
660	Pack						

Remington®

MODEL 700™ H24

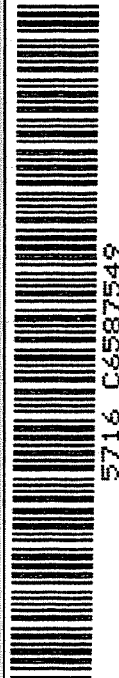
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat & Tm. Off. Marca Registrada Marque Deposee.

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

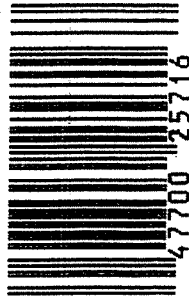
DUPONT
REG. U.S. PAT. & TM. OFF.

SERIAL NO. C6587549	ORDER NO. 5716
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01



UPC



CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6587549

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	KR
	Magnaflux Bolt		10/25/90	KR
615	Rollmark Caliber		10/24/90	LS
617	Drill and Tap Sight Holes		10/25/90	F03
618	Polish Barrel <i>RIB</i>		10/26/90	WB
620	Apply Coatings (Barrel Action)		11-7-90	TH
	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		11-15-90	TH

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	3 ³ / ₄	3 ³ / ₄	3 ³ / ₄			11/19/90	WB
	G) Safety Off Force	2 ¹ / ₄	2 ¹ / ₄	2 ¹ / ₄			11/19/90	WB
	H) Trigger Pull Test & Retainability						11-15-90	JH
	I) Firing Pin Indent	.022	.0225	.022			11/19/90	WB
	J) Assemble Stock						11/15/90	RW
	K) Assemble Swivel Studs						11-20-90	DH
	L) Attach Front and Rear Sight Assemblies						11/15/90	RW
	M) Iron Sight Alignment						11/15/90	RW
	N) Detach Front & Rear Sights & place in numbered container						11/15/90	RW
	O) Attach Scope to Rifle						11/15/90	RW
	P) Detach & Attach Scope 20 Times						11/15/90	RW
640	Gallery Target & Test						11-17-90	DH
	A) Time						11-17-90	DH
	B) Malfunctions						11-17-90	DH
	C) Pierced Primers						11-17-90	DH
	D) Optical Clarity of Scope						11-17-90	DH
645	Inspect for Live Ammo						11-17-90	DH
655	Final Inspection							
	A) Headspace						11-20-90	DH
	B) Trigger Pull	261	262	263	251	253	11-20-90	DH
	C) Function						11-20-90	DH
660	Pack							

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C6587549

DATE 11-15-90

TESTER JLI

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.35	2.32	2.30	261	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.48	2.29	2.30	262	
PULL #3	2.32	2.34	2.26	263	
PULL #4	2.34	2.28	2.32	251	
PULL #5	2.33	2.26	2.30	253	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.20	3.15		
PULL #2	3.39	3.22		
PULL #3	3.21	3.19		
PULL #4	3.27	3.25		
PULL #5	3.23	3.37		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.36	4.28		4.30
PULL #2	4.28	4.22		4.23
PULL #3	4.27	4.25		4.21
PULL #4	4.30	4.28		4.48
PULL #5	4.28	4.28		4.30
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6587549
17 Nov 1998

CENTROIDAL DISTANCES

Ø TO 1	.0450111
1 TO 2	.159289
1 TO 3	.330553
1 TO 4	.133297
1 TO 5	.177789

24# <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0236
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0622
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0665267

THE AMR FOR THIS RIFLE IS: .8766

- 17 Nov 1998

FILE:/PATTERNING/CENTERFIRE_PATT/G6587543

CENTERFIRE PATTERNS # 1

POA

1 in circle

2 in circle

3 in circle

OF SHOTS = 10

IN CIR

1 in = 3

2 in = 5

3 in = 9

HS = 2.171

VS = 2.405

GS = 2.588

CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.839	.834	.680
MINIMUM X	-1.332	-1.239	-.819
MAXIMUM Y	1.124	.982	.977
MINIMUM Y	-1.281	-1.024	-1.029
CENTROID X	.001	-.092	.062
CENTROID Y	.045	.187	.192
POA TO CENTROID in.	.045	.209	.202
MIN RADIUS	.424	.304	.278
MEAN RADIUS	.887	.790	.714
MAX RADIUS	1.531	1.239	1.147
HORIZONTAL SPREAD	2.171	2.073	1.499
VERTICAL SPREAD	2.405	2.006	2.006
EXTREME SPREAD	2.588	2.139	2.120
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	9		

17 Nov 1998

FILE:/PATTERNING/CENTERFIRE_PATT/06587543

CENTERFIRE PATTERNS # 2

POA

1 in circle

2 in circle

3 in circle

OF SHOTS = 10

IN CIR

1 in = 1

2 in = 6

3 in = 10

HS = 1.722

VS = 1.826

GS = 2.184

CENTROID #

PATTERN #	2		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.766	.780	.672
MINIMUM X	-.956	-.871	-.883
MAXIMUM Y	.719	.596	.492
MINIMUM Y	-1.107	-.983	-1.087
CENTROID X	.119	.034	.142
CENTROID Y	.152	.275	.379
POA TO CENTROID in.	.193	.277	.405
MIN RADIUS	.446	.392	.273
MEAN RADIUS	.841	.761	.669
MAX RADIUS	1.346	1.205	1.254
HORIZONTAL SPREAD	1.722	1.651	1.555
VERTICAL SPREAD	1.826	1.579	1.579
EXTREME SPREAD	2.184	2.184	2.043
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		10	

17 Nov 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C8587549

CENTERFIRE PATTERNS # 3

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS = 10

IN CIR

1in = 2

2in = 7

3in = 10

HS = 1.843

VS = 2.346

GS = 2.419

PATTERN #	3	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.635	.627	.475
MINIMUM X	-1.208	-1.216	-.762
MAXIMUM Y	.921	.762	.702
MINIMUM Y	-1.425	-.869	-.929
CENTROID X	-.111	-.103	.049
CENTROID Y	-.266	-.107	-.047
POA TO CENTROID in.	.288	.149	.068
MIN RADIUS	.322	.392	.347
MEAN RADIUS	.820	.738	.652
MAX RADIUS	1.427	1.307	1.001
HORIZONTAL SPREAD	1.843	1.843	1.237
VERTICAL SPREAD	2.346	1.631	1.631
EXTREME SPREAD	2.419	2.126	1.631
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	10		

17 May 1998

FILE:/PATTERNING/CENTERFIRE_PATT/08587549

CENTERFIRE PATTERNS

4

POA

1in circle

2in circle

3in circle

OF SHOTS = 10

IN CIR

1in = 1

2in = 4

3in = 10

CENTROID #

HS = 1.971

VS = 2.084

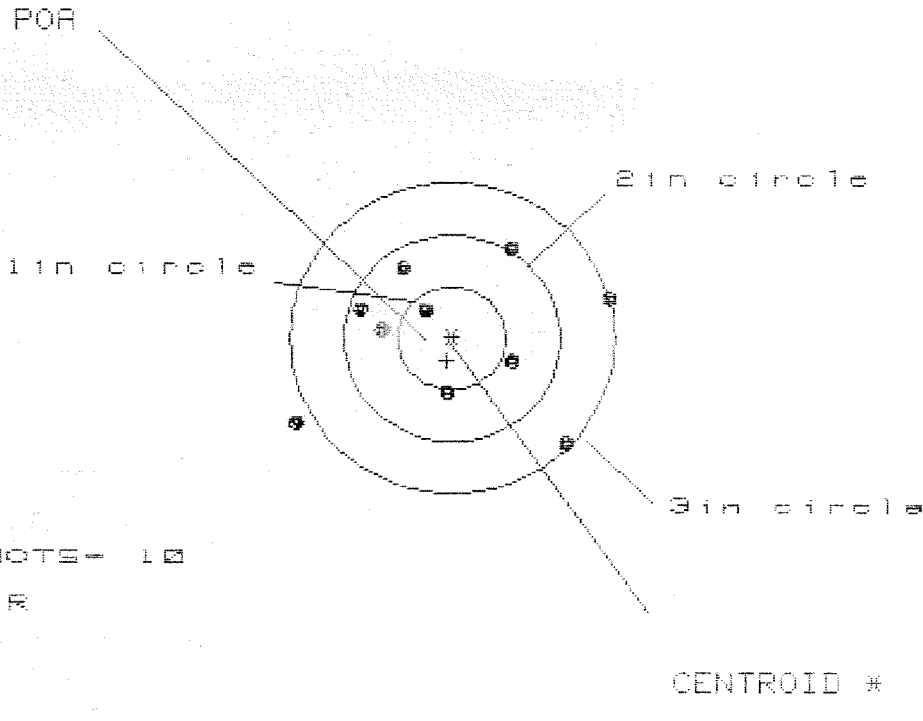
GS = 2.269

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.785	.653	.538
MINIMUM X	:	-1.186	-1.149	-1.068
MAXIMUM Y	:	.970	1.030	1.073
MINIMUM Y	:	-1.114	-1.054	-.925
CENTROID X	:	.063	.195	.114
CENTROID Y	:	.163	.103	-.026
POA TO CENTROID in.	:	.175	.221	.116
MIN RADIUS	:	.284	.389	.462
MEAN RADIUS	:	.885	.831	.770
MAX RADIUS	:	1.304	1.219	1.170
HORIZONTAL SPREAD	:	1.971	1.802	1.606
VERTICAL SPREAD	:	2.084	2.084	1.998
EXTREME SPREAD	:	2.269	2.225	2.063
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		10	

17 Nov 1990

FILE:/PATTERNING/CENTERFIRE_PATT/08587549

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 6

3 in = 7

HS= 2.852

VS= 1.901

GS= 3.114

PATTERN #	5	6	7
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.449	1.293	1.411
MINIMUM X	-1.403	-.974	-.856
MAXIMUM Y	.849	.756	.613
MINIMUM Y	-1.052	-1.145	-.727
CENTROID X	.046	.202	.084
CENTROID Y	.217	.310	.453
POA TO CENTROID in.	.222	.370	.461
MIN RADIUS	.379	.449	.293
MEAN RADIUS	.950	.879	.774
MAX RADIUS	1.635	1.483	1.422
HORIZONTAL SPREAD	2.852	2.267	2.267
VERTICAL SPREAD	1.901	1.901	1.340
EXTREME SPREAD	3.114	2.358	2.271
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	7		