C6587751

MODEL 700™ M24

Model SWS™

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: RE00060338

Verify Repair

Serial: C6587751 Model 700 Center Fire Caliber: 7.62 NATO M-24 (SWS)

Repairman:

Status: Closed 1/23/2003 1:44:54 PM

Address Information

Customer: (Received From)	Return To: (Received From)
Name: B CO 3 7 INF	B CO 3 7 INF
Address 1: BLDG 641	BLDG 641
Address 2: PO Box:	PO Box:
City: FORT STEWART	FORT STEWART
State: GA Zip Code: 31314 Country: US	State: GA Zip Code: 31314 Country: US

FFL:

Contact / Condition | Problems | Estimate | History / Status | Shipping / Billing

Contact Information

Phone:

Fax:

Email:

Comments:

Received Condition

Fair

Condition Notes:

CSR Notes:

Accessories Received

Code	Desc	Qt
A006	Sling Strap	1
A007	With Stud	1
X	FRT & REAR SGT BASES	1

Repair Search | Refresh | Close

nagletj | 1/23/2003 | 4:12 PM | CAPS | NUM | INS | SCRL

Start | Microsoft O... | Scorecard Daily | Arms Services ... | Print Search by ... | 2 Internet E... | 4:12 PM

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFOMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6587751.__0
FILE DATE AND TIME: 02/18/2003 10:21

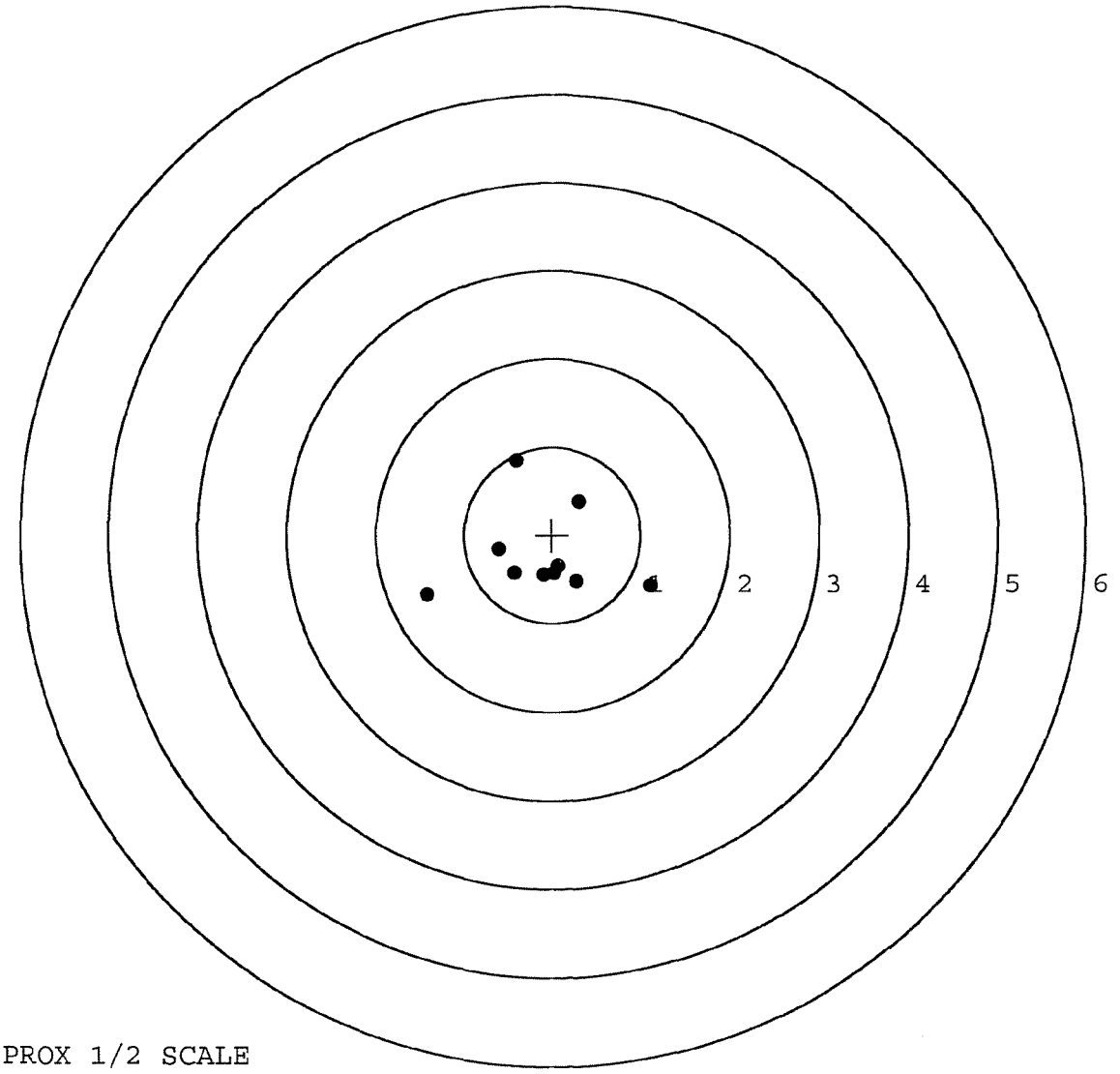
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.026
The Average Y Centroid of the Five Target Set:	-0.088
The Average Point of Impact of the Five Target Set:	0.092
The Average Mean Radius of the Five Target Set:	0.603
The Distance from POA to Centroid Target #1:	0.267
The Distance from Centroid Target #2 to Centroid Target #1:	0.297
The Distance from Centroid Target #3 to Centroid Target #1:	0.230
The Distance from Centroid Target #4 to Centroid Target #1:	0.309
The Distance from Centroid Target #5 to Centroid Target #1:	0.304

SERIAL NUMBER: C6587751.__0
TARGET NUMBER: 1
FILE DATE: 02/18/2003
FILE TIME: 10:21

X CENTROID:	-0.119
Y CENTROID:	-0.239
POA TO CENTROID:	0.267
HORZ SPREAD:	2.530
VERT SPREAD:	1.527
GROUP SPREAD:	2.532
MIN RADIUS:	0.220
MAX RADIUS:	1.375
MEAN RADIUS:	0.656
# IN 1 IN DIAMETER:	6
# IN 2 IN DIAMETER:	7
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	1.107	-0.580
2:	0.279	-0.526
3:	0.067	-0.359
4:	-0.094	-0.458
5:	-0.432	-0.432
6:	-0.603	-0.155
7:	-1.423	-0.675
8:	0.301	0.381
9:	-0.410	0.852
10:	0.022	-0.437

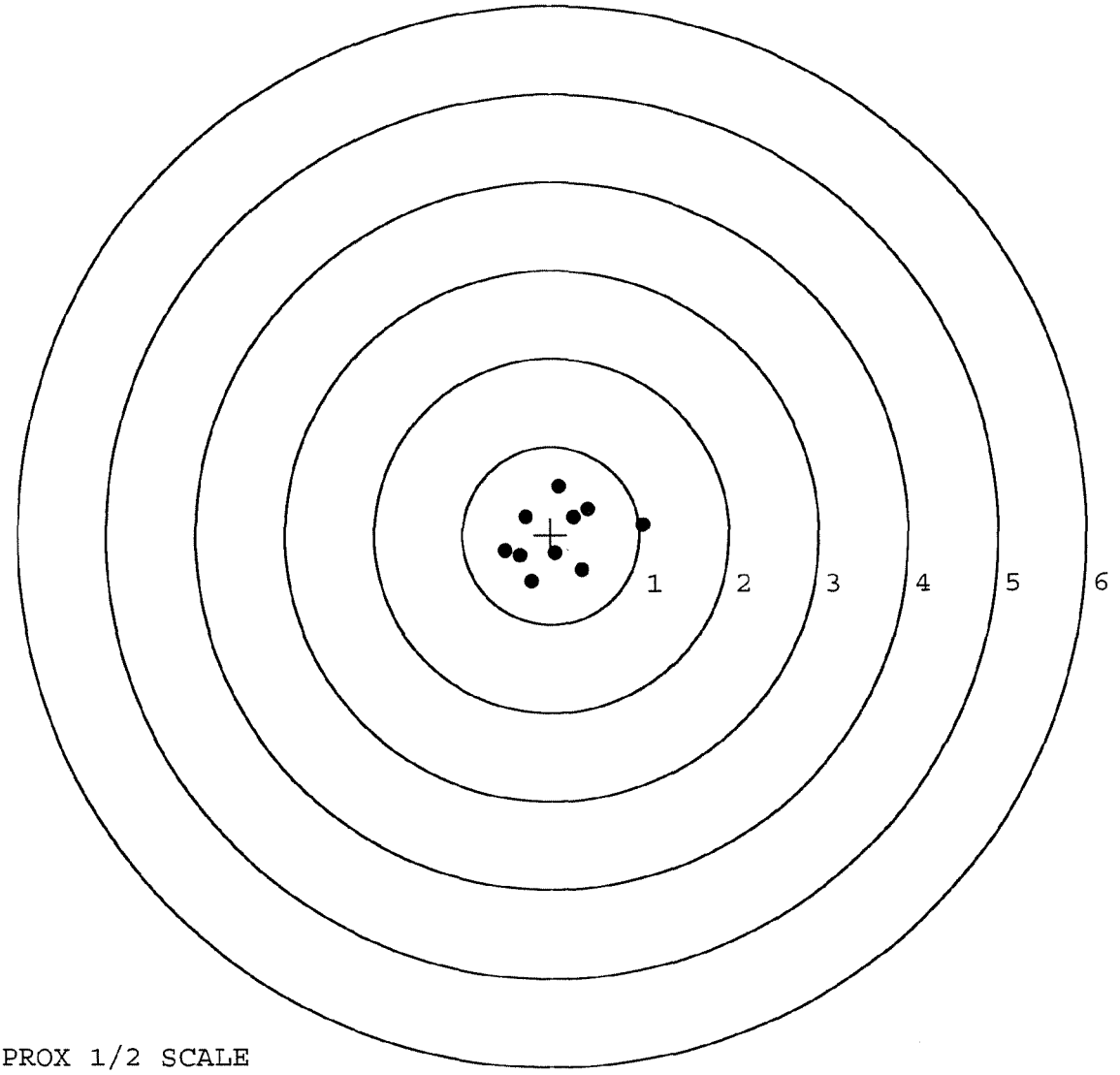


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6587751.__0
TARGET NUMBER: 2
FILE DATE: 02/18/2003
FILE TIME: 10:21

X CENTROID:	0.081
Y CENTROID:	-0.019
POA TO CENTROID:	0.083
HORZ SPREAD:	1.551
VERT SPREAD:	1.076
GROUP SPREAD:	1.578
MIN RADIUS:	0.192
MAX RADIUS:	0.961
MEAN RADIUS:	0.506
# IN 1 IN DIAMETER:	6
# IN 2 IN DIAMETER:	10
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	1.034	0.107
2:	0.418	0.299
3:	0.255	0.202
4:	0.090	0.548
5:	-0.287	0.202
6:	-0.517	-0.181
7:	-0.353	-0.237
8:	-0.224	-0.528
9:	0.348	-0.398
10:	0.047	-0.208

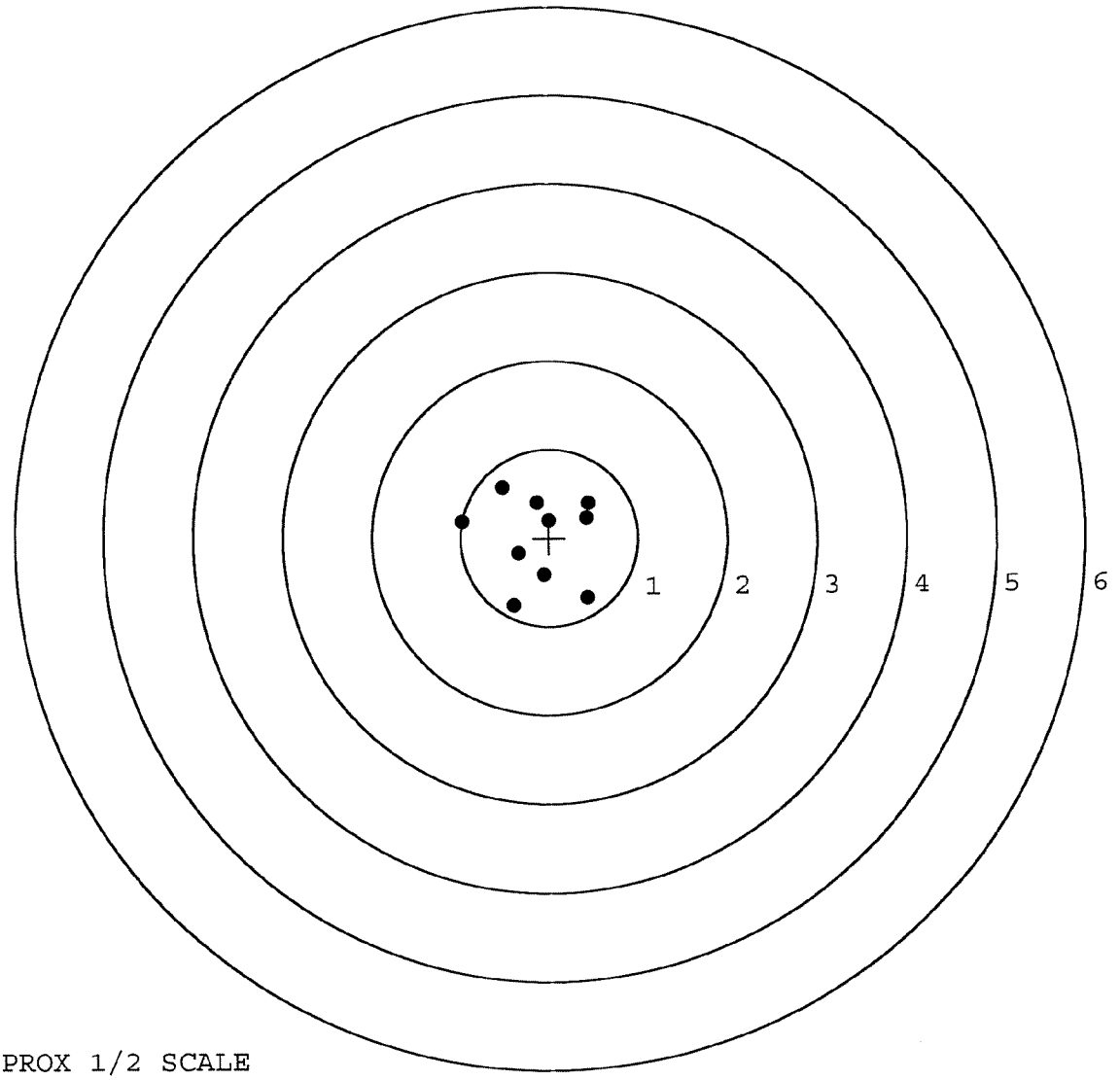


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6587751.__0
TARGET NUMBER: 3
FILE DATE: 02/18/2003
FILE TIME: 10:21

X CENTROID:	-0.116
Y CENTROID:	-0.009
POA TO CENTROID:	0.116
HORZ SPREAD:	1.427
VERT SPREAD:	1.335
GROUP SPREAD:	1.659
MIN RADIUS:	0.237
MAX RADIUS:	0.890
MEAN RADIUS:	0.590
# IN 1 IN DIAMETER:	4
# IN 2 IN DIAMETER:	10
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	0.427	-0.683
2:	-0.404	-0.768
3:	-0.061	-0.423
4:	-0.350	-0.179
5:	0.444	0.389
6:	0.423	0.225
7:	0.006	0.195
8:	-0.137	0.397
9:	-0.522	0.567
10:	-0.983	0.192

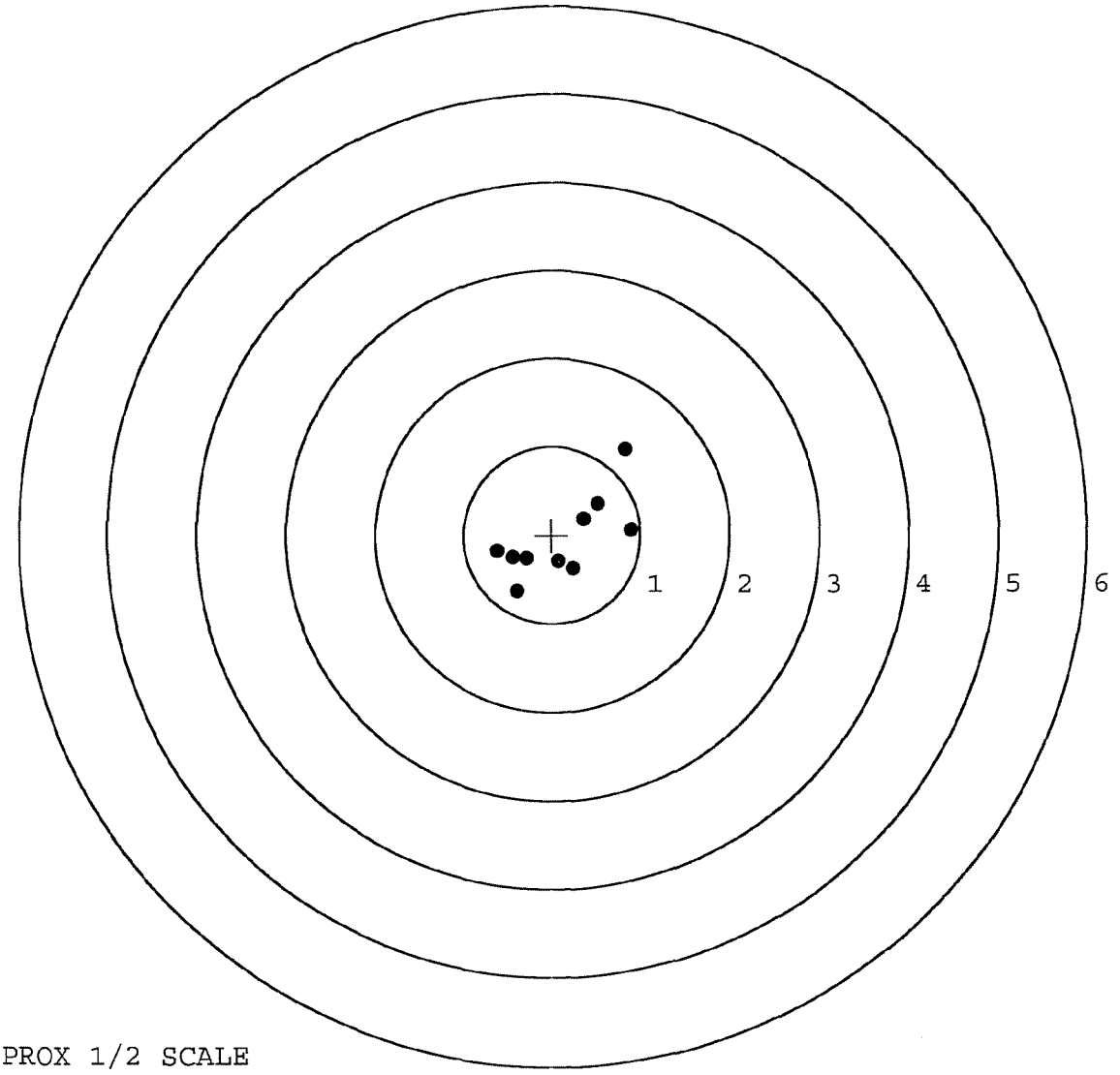


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6587751.__0
TARGET NUMBER: 4
FILE DATE: 02/18/2003
FILE TIME: 10:21

X CENTROID:	0.119
Y CENTROID:	-0.041
POA TO CENTROID:	0.126
HORZ SPREAD:	1.510
VERT SPREAD:	1.610
GROUP SPREAD:	2.023
MIN RADIUS:	0.261
MAX RADIUS:	1.239
MEAN RADIUS:	0.613
# IN 1 IN DIAMETER:	4
# IN 2 IN DIAMETER:	9
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	0.896	0.062
2:	0.517	0.362
3:	0.831	0.973
4:	0.243	-0.377
5:	0.080	-0.299
6:	-0.394	-0.637
7:	-0.288	-0.261
8:	-0.440	-0.249
9:	-0.614	-0.175
10:	0.360	0.191

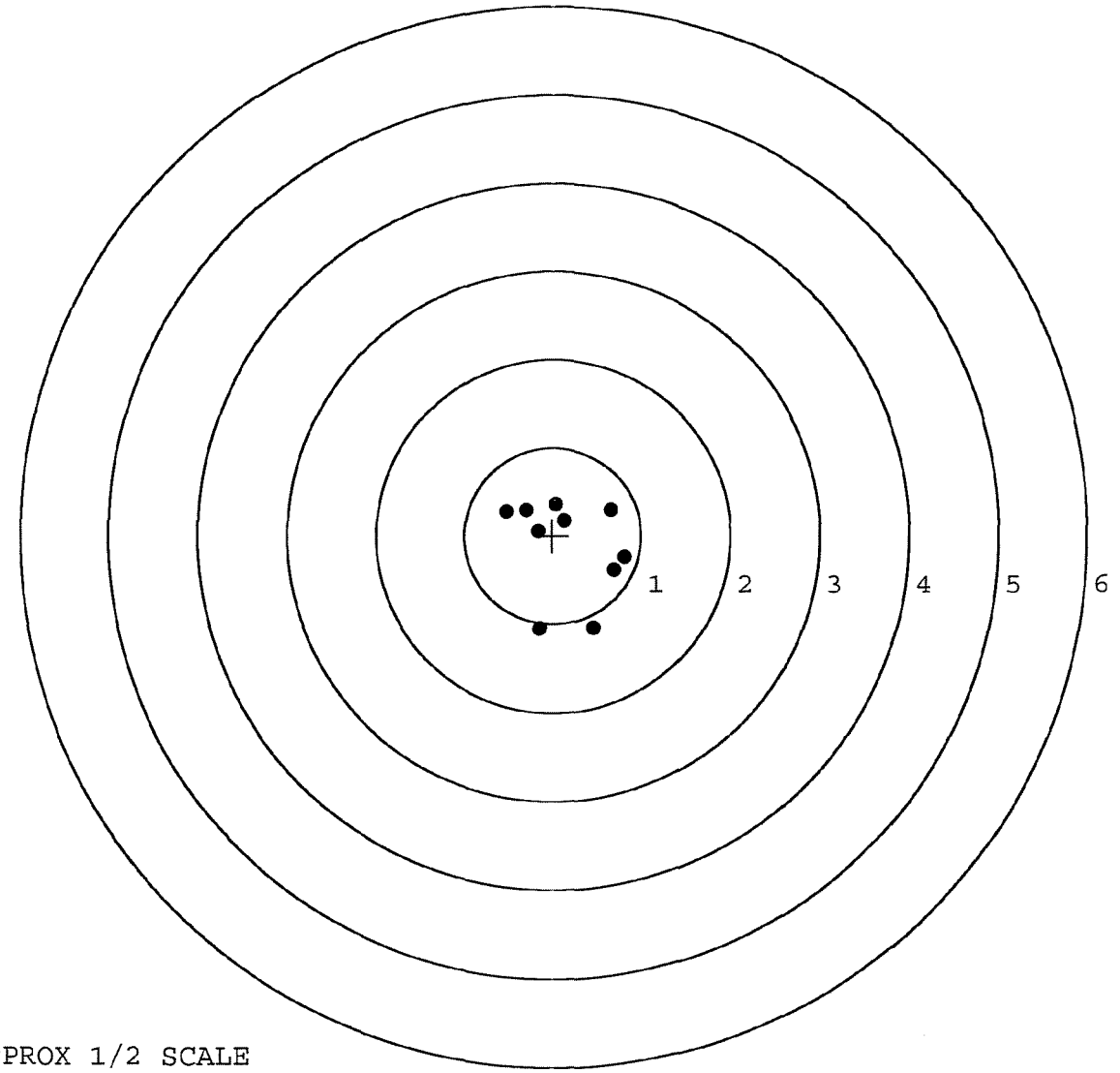


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6587751.__0
TARGET NUMBER: 5
FILE DATE: 02/18/2003
FILE TIME: 10:21

X CENTROID:	0.166
Y CENTROID:	-0.131
POA TO CENTROID:	0.211
HORZ SPREAD:	1.349
VERT SPREAD:	1.419
GROUP SPREAD:	1.583
MIN RADIUS:	0.302
MAX RADIUS:	0.985
MEAN RADIUS:	0.648
# IN 1 IN DIAMETER:	2
# IN 2 IN DIAMETER:	10
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	0.698	-0.390
2:	0.819	-0.242
3:	0.659	0.296
4:	0.464	-1.053
5:	-0.151	-1.064
6:	0.127	0.168
7:	0.037	0.355
8:	-0.530	0.279
9:	-0.302	0.288
10:	-0.165	0.051



TARGET APPROX 1/2 SCALE

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

SERIAL # C6587751 INSPECTED BY: RWJ

DATE REC'D: 1-23-03 DATE RET'D: 2-8-03

ITEM		ITEM	
BARREL ASSEMBLY		**STOCK ASSEMBLY**	
✓	BARREL	✓	STOCK
✓	RECEIVER	✓	SLING AWIVEL STUDS
✓	FRONT SIGHT BASE	✓	ADJUSTABLE
✓	REAR SIGHT BASE	✓	BUTT PLATE
✓	SCREWS	✓	LOCK NUTS
✓	FINISH	✓	BARREL CLEARANCE
		✓	COLOR / FINISH
SCOPE ASSEMBLY		**SYSTEMS CASE**	
	SCOPE		SCOPE CASE
	SCOPE RINGS		IRON SIGHTS
	MOUNTING SCREWS		DEPLOYMENT KIT
✓	MOUNTING BASE		
✓	SCREWS		
	FINISH	**TRIGGER ASSEMBLY**	
	CLARITY	✓	SAFETY OPERATION
		✓	RE-SET TO FACTORY SPECS

COMMENTS:

2.50# ± .50#

4.00# ± 1.00#

DATE 1-27-03

TESTER TRW

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.54	2.51		2.80	MIN. SETTING,
PULL #2	2.57	2.54		2.55	NO AVG. OF 5
PULL #3	2.58	2.55		2.52	READINGS ACCEPT
PULL #4	2.61	2.61		2.59	ABLE LESS THAN
PULL #5	2.58	2.59		2.57	
TOTAL	12.88	12.80		13.03	
AVG.	2.57	2.56		2.60	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.28	3.23		
PULL #2	3.26	3.15		
PULL #3	3.21	3.23		
PULL #4	3.04	3.26		
PULL #5	3.31	3.27		
TOTAL	16.10	16.14		
AVG.	3.22	3.22		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# & TARGET & ACCU
PULL #1	4.21	4.05		4.25
PULL #2	4.30	4.16		4.17
PULL #3	4.27	4.13		4.20
PULL #4	4.22	4.17		4.18
PULL #5	4.26	4.19		4.19
TOTAL	21.26	20.70		20.99
AVG.	4.25	4.14		4.19

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

R & E NUMBER	60338		
SERIAL NUMBER	C6587751		
LOG-IN DATE	1-23-03		
INSPECT AND VERIFY:			
OPERATION #	OPERATION NAME	DATE	INITIAL
550	DIS-ASSEMBLE GUN	1-27-03	RTL
560 A	RE-BARREL	1-28-03	DA
B	DRILL AND TAP	1-28-03	TRW
575	ASSEMBLE	1-28-03	RW
600	PROOF	1-28-03	RW
605	CHECK HEADSPACE	1-28-03	RW
610	DIS-ASSEMBLE GUN	1-28-03	RW
612	MAGNAFLUX OPERATOR		
615	ROLLMARK CALIBER		
618	ROTO-BLAST	1-31-03	J-80
620	APPLY COATINGS	2-11	TH
625 A	FINAL ASSEMBLY	2-12-03	RW
B	TRIGGER PULL TEST	2.73, 2.70, 2.60, 2.60, 2.54	RW
C	SAFETY "ON" FORCE	9, 9, 9	RW
D	SAFETY "OFF" FORCE	2.5, 2.5, 2.5	RW
E	FIRING PIN INDENT		
640	TARGET	2-17-03	AC
655	FINAL INSPECT	2-17-03	RW
660	PACK	2-19-03	DA
		SHIP DATE	
	QAR INSPECTION DATE		

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

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

8. MODEL

9. NOUN

10a ORG WON/DOC NO | 10b. EIC

11. SERIAL NUMBER | 12. QTY | 13. PD

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

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

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*)

25. REMARKS

FORSCOM
1084
Condition Code F
Sign.
Date 30JAN03

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
		F	M24 SWS Sniper Rifle					
		M	Condition Code F					
			NRTS					
		G	M24 SWS Sniper Rifle					

CODE F

NRTS

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

ORGANIZATION COPY 4

BARBER M24 0026399

RECEIVING AND ESTIMATING REPORT

COMMENTS: W/ULTRA 10X-M3A SCOPE M-24

ORDER: R 96-12123

INITIAL	CUSTOMER ORDER NO.
HAM	

DATE RECEIVED	DATE OPENED	DATE CODE	SERIAL NUMBER	NEW SERIAL NUMBER	MODEL AND GRADE
05/09/96	05/10/96	BL 1-91	C6587751		700 7.62 NATO

ACCESSORIES: SOFT CASE SCOPE MNTS SCOPE BASE

FROM:

DEPT. OF THE ARMY
BRAVO CO. 3RD BN 7TH INF.
FT STEWART GA 31314

SHIP TO:

DEPT. OF THE ARMY
BRAVO CO. 3RD BN 7TH INF.
FT STEWART GA
31314

CUST NO: 142909 C.O.D.

ACCOUNT NUMBER	ACCOUNT NUMBER N/C	WRITE ☐	PROM. DATE	ESTIMATED	VIA
					R229495973

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

142
6/10

W52H096

PARTS

Barrel
Stock
Trigger Guard Assy
Soft Carrying Case
mag Spring

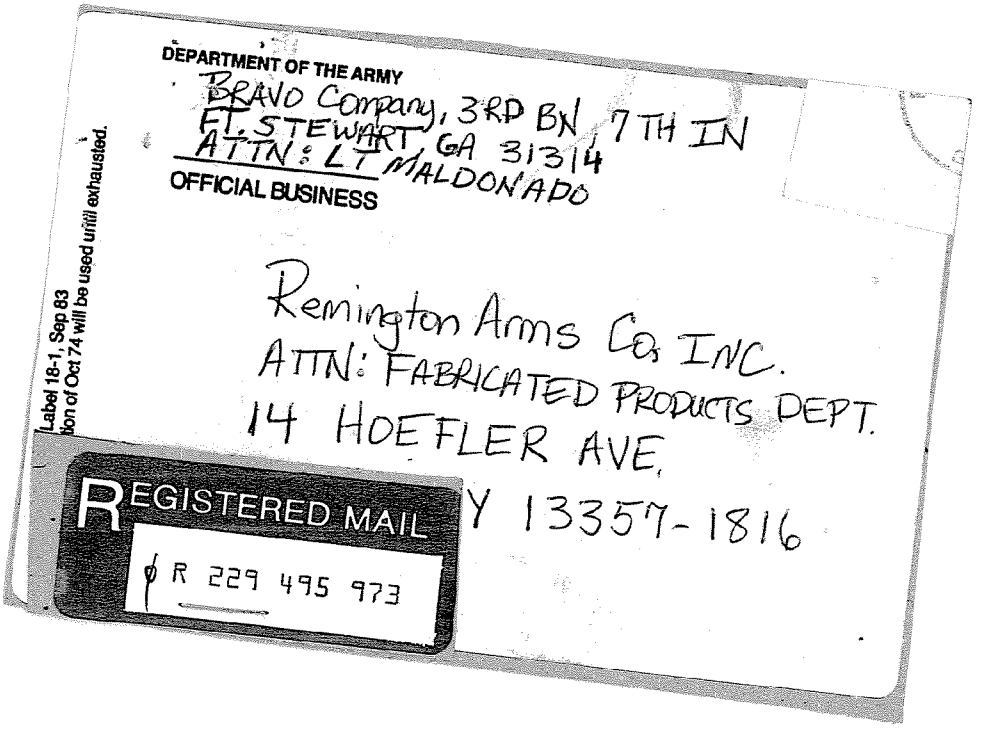
COMMENTS

Repair Butt Cap Trigger Guard Assy, Front & Rear Sight Base Retaining Screw Base, Rings & Swivel Studs

REPAIRMAN	PROOF	CLEAN	TEST	TARGET	PATTERN
RW	V	L	L	L	
GALLERY TESTER	DATE	DATE	DATE	DATE	DATE
	5/10/96	6/5/96	6/6/96	6/6/96	

OFFICE COPY

RD6925 REV. 1/94


DEPARTMENT OF THE ARMY
BRAVO Company, 3RD BN, 7TH IN
FT. STEWART, GA 31314
ATTN: LT MALDONADO
OFFICIAL BUSINESS
Label 18-1, Sep 83
tion of Oct 74 will be used until exhausted.
Remington Arms Co, INC.
ATTN: FABRICATED PRODUCTS DEPT.
14 HOEFLER AVE,
Y 13357-1816
REGISTERED MAIL
R 229 495 973

DEPARTMENT OF THE ARMY
Bravo Company, 3rd BN, 7th IN
Ft. Stewart, Ga 31314

AFZP-VAM-BC 08 MAY 1996

MEMORANDUM FOR REMINGTON ARMS COMPANY

MEMORANDUM FROM LT MALDONADO, ARMS ROOM OFFICER

SUBJECT: Return shipment of M24 SWS.

1. When repairs are complete return the M24 SWS to the following address:

Bravo Company, 3rd BN, 7th IN
ATTN: 2LT Maldonado
Ft. Stewart, Ga 31314

2. Point of contact for this action is LT Maldonado, (912) 767-7793/7802.

L. Enrique Maldonado
2LT, IN
Arms Room Officer

WAQ480

21 DAY TURN - AROUND

Barrel
Stock

M-24
CONTRACT # DAAA09-92-C-0834

R&E NO. **SERIAL NO.** C6587751

LOG IN DATE: 5/09/96		**DATE**	**INIT.**
INSPECT & VERIFY:			
OP. #	**OP. NAME**		
550	DIS-ASSEMBLE GUN		
560 A	RE-BARREL AT CUSTOM SHOP	5/10/96	
B	DRILL & TAP	5/10/96	
C	POLISH	5/10/96	
575	ASSEMBLE		
600	PROOF	5/10/96	RW
605	CHECK HEADSPACE		
610	DIS-ASSEMBLE		
612	MAGNAFLUX	5/13/96	
615	ROLLMARK CALIBER	5/13/96	
618	ROTO-BLAST	5/13/96	
620	APPLY COATINGS		
625 A	FINAL ASSEMBLY		
B	TRIGGER PULL TEST		
C	SAFETY ON FORCE	_____ _____	_____
D	SAFETY OFF FORCE	_____ _____	_____
E	FIRING PIN INDENT	_____ _____	_____
640	TARGET		
655	FINAL INSPECT		
660	PACK		
	QAR INSPECTION	SHIP DATE	

SWS/Repair

Final Inspection

Sn: C658725	DATE REC'D: 5/09/96	DATE RET'D:

Auditor: RW

Item:

Barrel Assy.
- ✓ Barrel
- ✓ Receiver
- ✓ Front Sight Block
- ✓ Rear Sight Block
- ✓ Screws
- ✓ Finish

Scope Assy.
- ✓ Scope
- ✓ Scope Rings
- ✓ Mounting Screws
- ✓ Mounting Base
- ✓ Screws
- ✓ Finish
- ✓ Looseness
- ✓ Clarity

Misc.
- ___ DD-250
- ___ Bar Code
- ___ Packaging

Item:

Stock Assy.
- ✓ Stock
- ✓ Sling Swivel Studs
- ✓ Adjustable Butt Plate
- ✓ Lock Nuts
- ✓ Barrel Clearance
- ✓ Color/Finish

Systems Case
- ___ Scope Case
- ___ Iron Sights
- ___ Deployment Kit

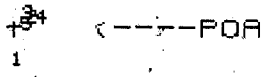
Trigger
- ✓ Safety Operation
- ✓ Set
- ___

Comments: _____

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6587751
10 Apr 1900

CENTROIDAL DISTANCES

0	TO	1	.575243
1	TO	2	.856394
1	TO	3	.902718
1	TO	4	.935101
1	TO	5	.69823

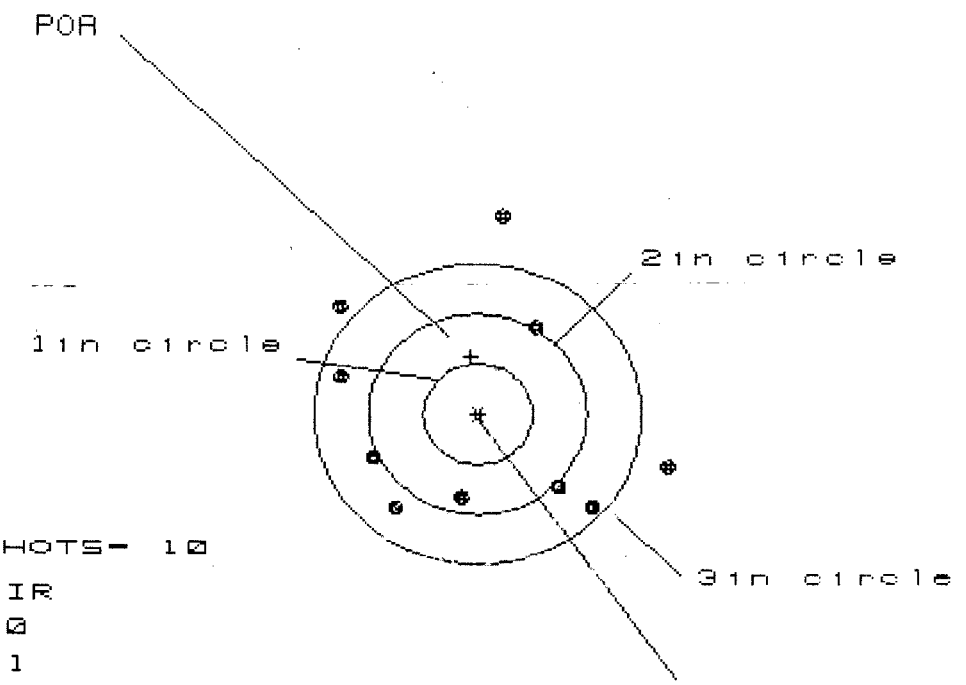


THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .2948
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0606
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .300964

THE AMR FOR THIS RIFLE IS: 1.09

18 Apr 1900 FILE:/PATTERNING/CENTERFIRE_PATT/C6587751

CENTERFIRE PATTERNS # 1



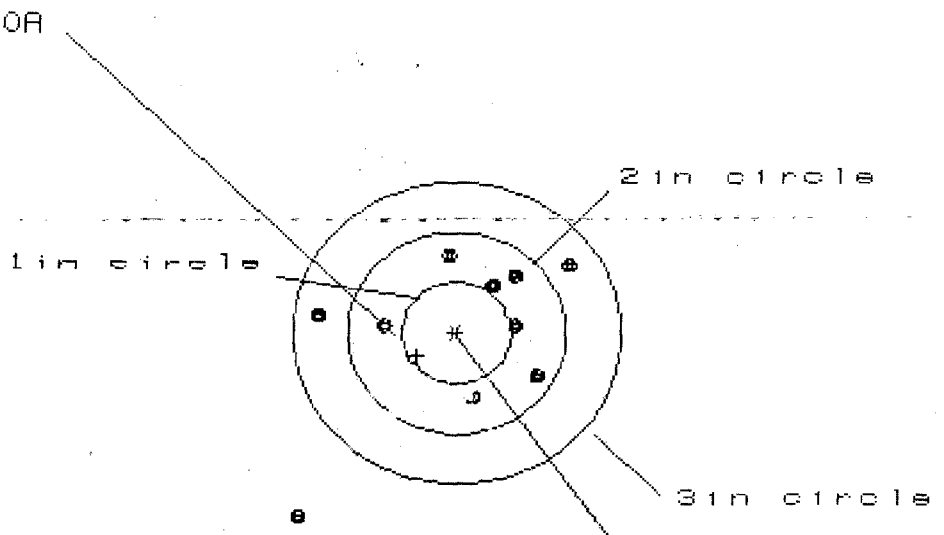
# OF SHOTS= 10
# IN CIR
1in = 0
2in = 1
3in = 7
HS= 2.941
VS= 2.937
GS= 3.366

PATTERN #	:	[illegible]		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.69[illegible]	1.725	1.254
MINIMUM X	:	-1.2[illegible]	-1.216	-1.001
MAXIMUM Y	:	1.971	1.302	1.261
MINIMUM Y	:	-.966	-.747	-.788
CENTROID X	:	.061	.034	-.181
CENTROID Y	:	-.572	-.791	-.750
POA TO CENTROID in.	:	.576	.792	.771
MIN RADIUS	:	.795	.575	.605
MEAN RADIUS	:	1.317	1.202	1.113
MAX RADIUS	:	1.986	1.782	1.610
HORIZONTAL SPREAD	:	2.941	2.941	2.255
VERTICAL SPREAD	:	2.937	2.049	2.049
EXTREME SPREAD	:	3.366	3.366	3.047

NUMBER IN ONE INCH CIRCLE = 0
NUMBER IN TWO INCH CIRCLE = 1
NUMBER IN THREE INCH CIRCLE = 7

10 Apr 1900 FILE:/PATTERNING/CENTERFIRE_PATT/C6587751

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

# IN CIR
1in = 0
2in = 7
3in = 9

HS= 2.428
VS= 2.553
GS= 3.454

CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10		8
MAXIMUM X	:	1.00	.851	.675
MINIMUM X	:	-1.4	-1.404	-.966
MAXIMUM Y	:	.7	.576	.577
MINIMUM Y	:	-1.7	-.810	-.809
CENTROID X	:	.364	.521	.697
CENTROID Y	:	.229	.427	.426
POA TO CENTROID in.	:	.430	.674	.817
MIN RADIUS	:	.519	.268	.223
MEAN RADIUS	:	.954	.741	.621
MAX RADIUS	:	2.276	1.404	.975
HORIZONTAL SPREAD	:	2.428	2.255	1.641
VERTICAL SPREAD	:	2.553	1.386	1.386
EXTREME SPREAD	:	3.454	2.304	1.751
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

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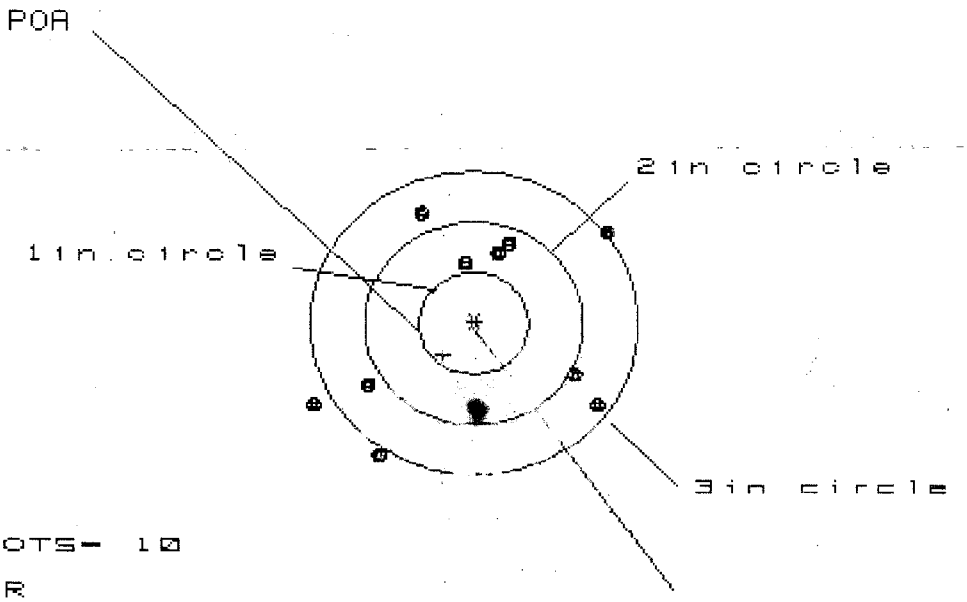
CENTERFIRE PATTERNS # 3



# OF SHOTS= 10
# IN CIR
1in = 0
2in = 3
3in = 7
HS= 2.702
VS= 2.365
GS= 3.185

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.[illegible]	1.106	1.068
MINIMUM X	:	-1.[illegible]	-1.099	-.961
MAXIMUM Y	:	[illegible]	.999	1.101
MINIMUM Y	:	-1.[illegible]	-1.366	-1.264
CENTROID X	:	.[illegible]	.438	.300
CENTROID Y	:	.304	.391	.289
POA TO CENTROID in.	:	.412	.587	.416
MIN RADIUS	:	.564	.527	.582
MEAN RADIUS	:	1.154	1.070	1.045
MAX RADIUS	:	1.636	1.698	1.535
HORIZONTAL SPREAD	:	2.702	2.205	2.029
VERTICAL SPREAD	:	2.365	2.365	2.365
EXTREME SPREAD	:	3.185	3.040	2.459
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		7	

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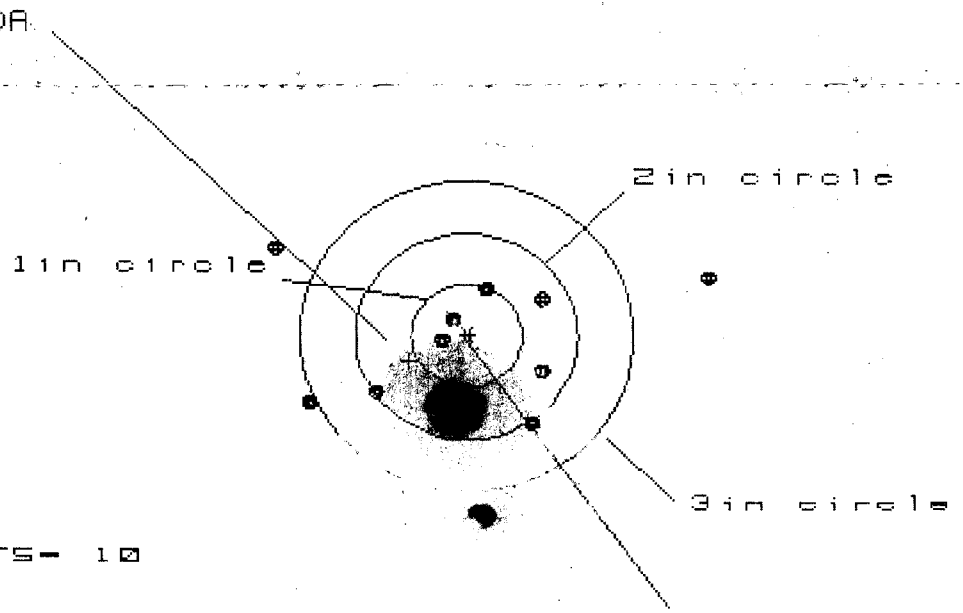
CENTERFIRE PATTERNS # 4



# OF SHOTS= 10
# IN CIR
1in = 2
2in = 6
3in = 7
HS= 3.925
VS= 1.723
GS= 3.934

PATTERN #	:	4		
SHOTS (BEST OF)	:	10		8
MAXIMUM X	:	2.1[illegible]	[illegible]98	.768
MINIMUM X	:	-1.[illegible]2	1.522	-1.364
MAXIMUM Y	:	.[illegible]8	.927	.684
MINIMUM Y	:	.[illegible]3	-.796	-.680
CENTROID X	:	.5[illegible]9	.283	.473
CENTROID Y	:	.241	.174	.058
POA TO CENTROID in.	:	.576	.332	.477
MIN RADIUS	:	.227	.008	.215
MEAN RADIUS	:	1.040	.895	.783
MAX RADIUS	:	2.244	1.782	1.452
HORIZONTAL SPREAD	:	3.925	2.480	2.132
VERTICAL SPREAD	:	1.723	1.723	1.364
EXTREME SPREAD	:	3.934	2.940	2.384
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		7	

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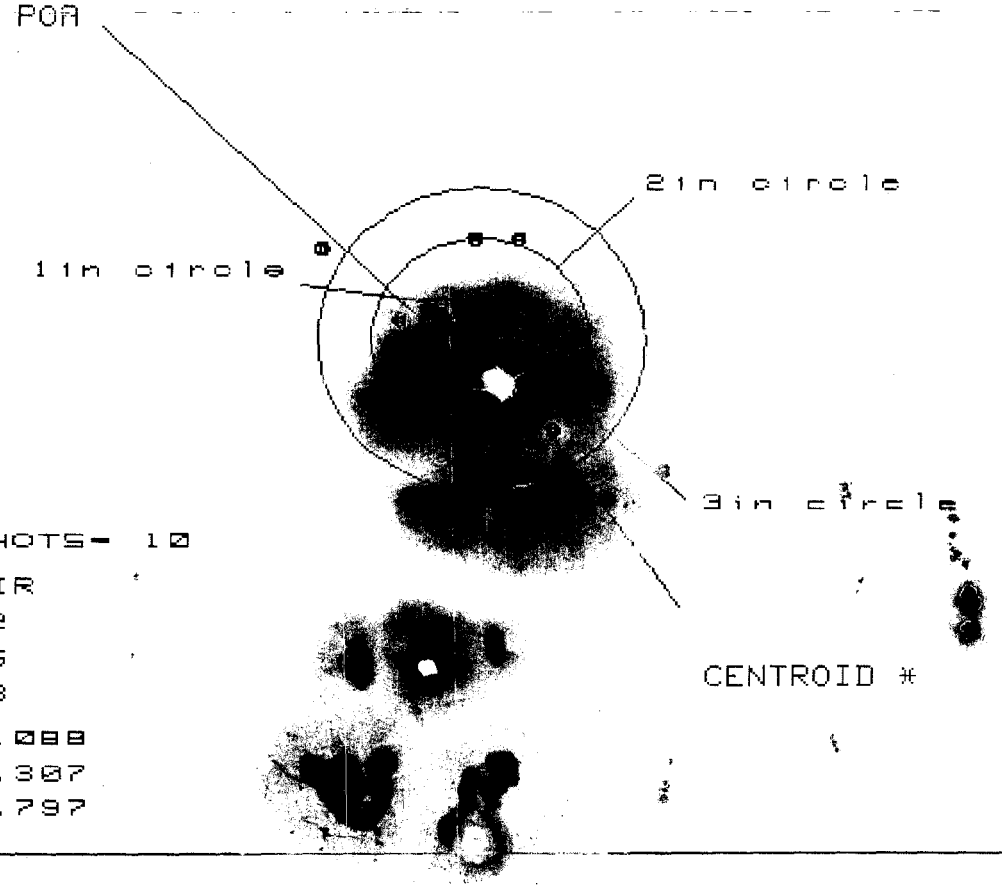
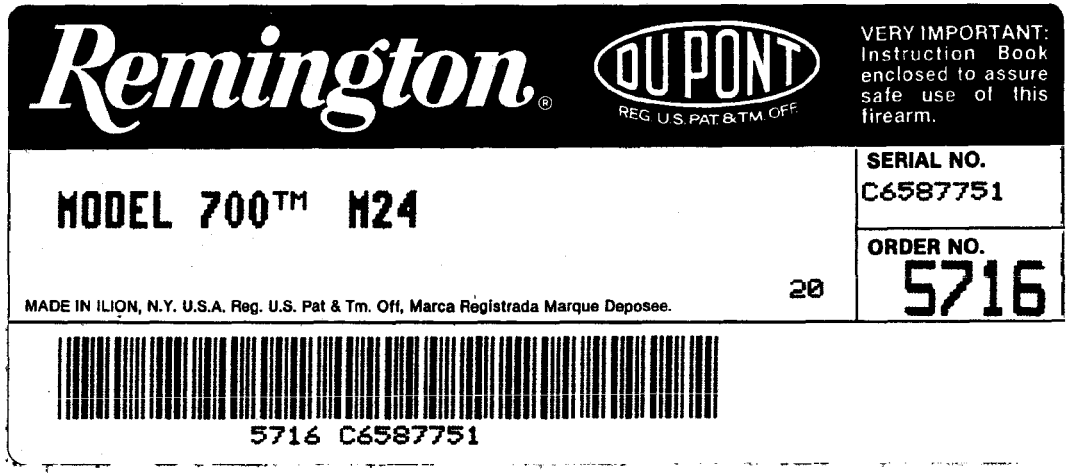
CENTERFIRE PATTERNS # 5

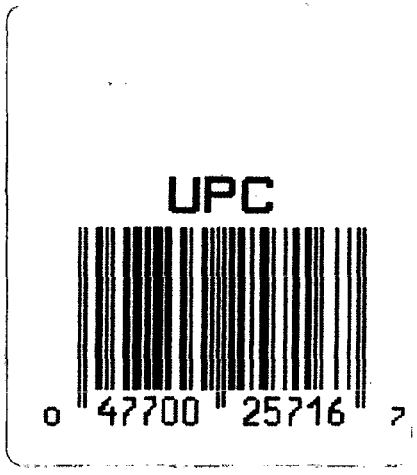


# OF SHOTS= 10
# IN CIR
1in = 2
2in = 6
3in = 8
HS= 3.088
VS= 2.307
GS= 3.797

PATTERN #	:	5		
SHOTS (BEST OF)	:	10		8
MAXIMUM X	:	1.[illegible]	.837	.679
MINIMUM X	:	[illegible]	-.258	-.740
MAXIMUM Y	:	[illegible]	.833	.927
MINIMUM Y	:	-1.[illegible]	-1.047	-.955
CENTROID X	:	[illegible]	.064	.222
CENTROID Y	:	[illegible]	.248	.156
POA TO CENTROID in.	:	.267	.256	.271
MIN RADIUS	:	.328	.093	.275
MEAN RADIUS	:	.984	.828	.750
MAX RADIUS	:	2.114	1.459	1.172
HORIZONTAL SPREAD	:	3.088	2.095	1.419
VERTICAL SPREAD	:	2.307	1.882	1.882
EXTREME SPREAD	:	3.797	2.752	1.976

NUMBER IN ONE INCH CIRCLE = 2
NUMBER IN TWO INCH CIRCLE = 6
NUMBER IN THREE INCH CIRCLE = 8





M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6587751

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	1228	90	RW
600	Proof	1228	90	RW
607	Check Headspace	1228	90	RW
610	Dis-assemble Gun	1228	90	RW
612	Magnaflux Barrel Action		1-7-91	KR
	Magnaflux Bolt		"	KR
615	Rollmark Caliber		"	DS.
617	Drill and Tap Sight Holes	1 10	91	FB
618	Polish Barrel	1 10	91	WB
620	Apply Coatings (Barrel Action)		1-26-91	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		1/28/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		1/28/91	RW
	C) Inspect Ejector Hole for Chamfer		1/28/91	RW
	D) Oil Firing Pin Ass'y		1/28/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		2/7/91	JH

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			2/8/91	WB
	G) Safety Off Force	2	2	2			2/8/91	WB
	H) Trigger Pull Test & Retainability						2/7-91	JH
	I) Firing Pin Indent	.0225	.0225	.0225			2/8/91	WB
	J) Assemble Stock						2/8/91	RW
	K) Assemble Swivel Studs						2-21-91	A
	L) Attach Front and Rear Sight Assemblies						2/8/91	RW
	M) Iron Sight Alignment						2/8/91	RW
	N) Detach Front & Rear Sights & place in numbered container						2/8/91	RW
	O) Attach Scope to Rifle						2/8/91	RW
	P) Detach & Attach Scope 20 Times						2/8/91	RW
640	Gallery Target & Test						2/8/91	KJ
	A) Time						"	KJ
	B) Malfunctions						"	KJ
	C) Pierced Primers						"	KJ
	D) Optical Clearity of Scope						"	KJ
645	Inspect for Live Ammo						2/8/91	KJ
655	Final Inspection A) Headspace						2-21-91	A
	B) Trigger Pull	2.24	2.27	2.29	2.26	2.24	2/19/91	WB
	C) Function						2-21-91	A
660	Pack						3/14/91	WB

SWS TRIGGER PULL TEST

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

SERIAL NO. C6587751
DATE 2-7-91
TESTER [illegible]

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.39	2.19	2.25	2.24	MIN. SETTING,
PULL #2	2.37	2.24	2.28	2.27	NO AVG. OF 5
PULL #3	2.29	2.18	2.30	2.29	READINGS ACCEPT-
PULL #4	2.30	2.32	2.38	2.26	ABLE LESS THAN 2#
PULL #5	2.39	2.30	2.30	2.24	
TOTAL					
AVG.					

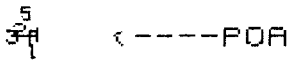
	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.28	3.42		
PULL #2	3.50	3.48		
PULL #3	3.38	3.48		
PULL #4	3.48	3.26		
PULL #5	3.52	3.20		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.25	4.30		4.37
PULL #2	4.40	4.40		4.42
PULL #3	4.25	4.38		4.40
PULL #4	4.30	4.39		4.50
PULL #5	4.36	4.40		4.33
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6587751
9 Feb 1991

CENTROIDAL DISTANCES

Ø	TO	1	.261123
1	TO	2	.446525
1	TO	3	.444946
1	TO	4	.314531
1	TO	5	.712341

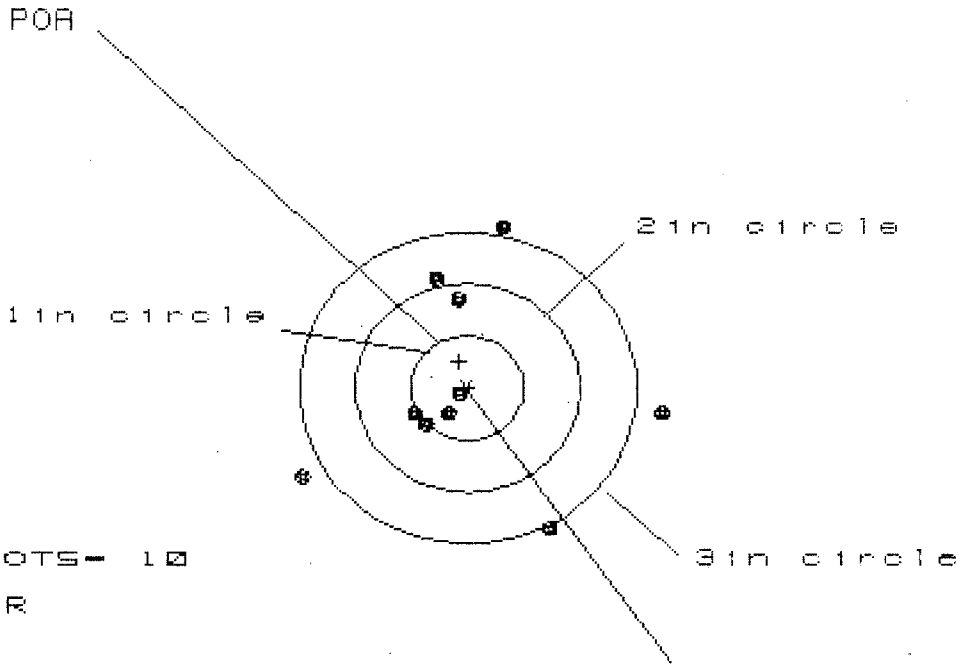


THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0562
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0854
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .102233

THE AMR FOR THIS RIFLE IS: .966

8 Feb 1991 FILE:/PATTERNING/CENTERFIRE_PATT/C6587751

CENTERFIRE PATTERNS # 1

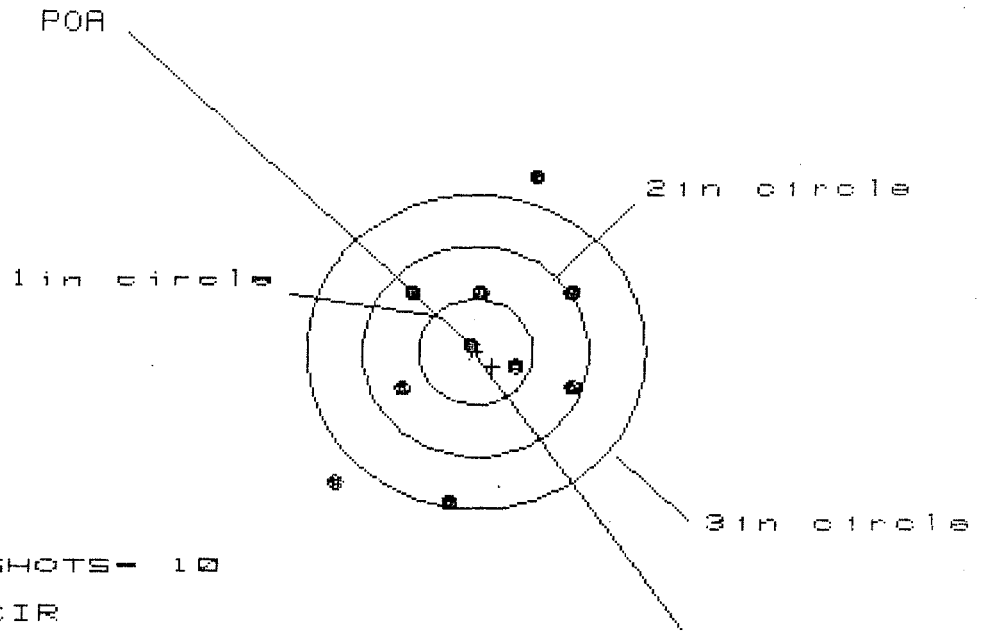


# OF SHOTS= 10
# IN CIR
1in = 3
2in = 5
3in = 6
HS= 3.223
VS= 2.900
GS= 3.281

PATTERN #	:	[redacted]		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.777	.912	.756
MINIMUM X	:	-1.446	-1.248	-.385
MAXIMUM Y	:	1.538	1.507	1.393
MINIMUM Y	:	-1.363	-1.393	-1.507
CENTROID X	:	.072	-.126	.030
CENTROID Y	:	-.251	-.221	-.107
POA TO CENTROID in.	:	.262	.255	.111
MIN RADIUS	:	.129	.110	.207
MEAN RADIUS	:	.998	.871	.817
MAX RADIUS	:	1.798	1.665	1.686
HORIZONTAL SPREAD	:	3.223	2.160	1.141
VERTICAL SPREAD	:	2.900	2.900	2.900
EXTREME SPREAD	:	3.281	3.022	2.921
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		6	

8 Feb 1991 FILE:/PATTERNING/CENTERFIRE_PATT/C6587751

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

# IN CIR
1in = 2
2in = 5
3in = 8

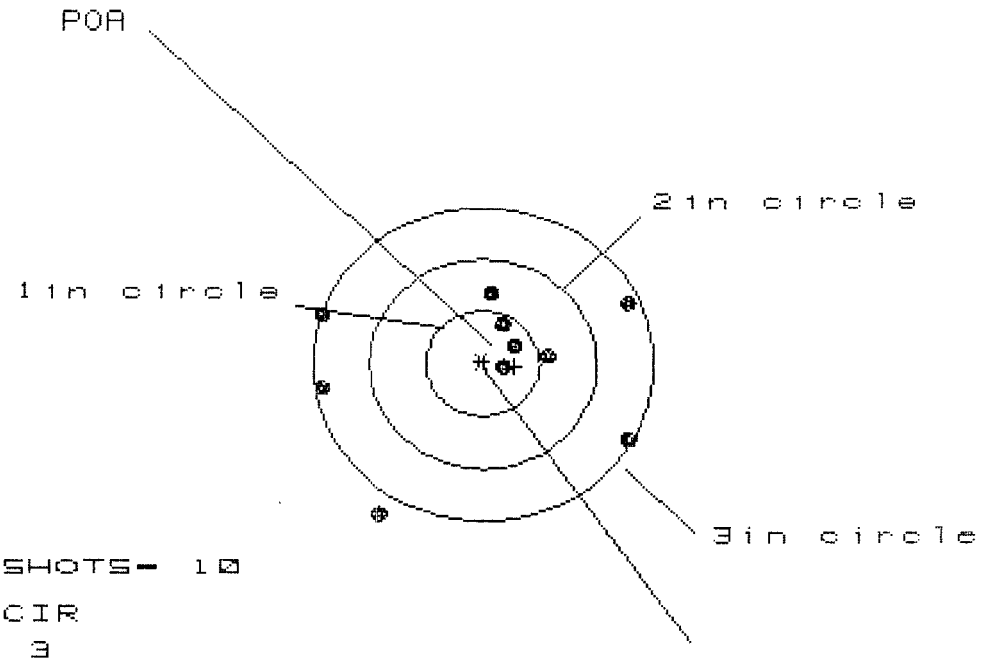
HS= 2.091
VS= 3.168
GS= 3.462

PATTERN # : 2

SHOTS (BEST OF) :	10	9	8
MAXIMUM X :	.868	.931	.786
MINIMUM X :	-1.223	-1.160	-.721
MAXIMUM Y :	1.699	.793	.659
MINIMUM Y :	-1.469	-1.280	-1.414
CENTROID X :	-.149	-.212	-.068
CENTROID Y :	.137	-.052	.082
POA TO CENTROID in.:	.202	.219	.106
MIN RADIUS :	.069	.252	.162
MEAN RADIUS :	.955	.886	.753
MAX RADIUS :	1.792	1.580	1.455
HORIZONTAL SPREAD :	2.091	2.091	1.507
VERTICAL SPREAD :	3.168	2.073	2.073
EXTREME SPREAD :	3.462	2.801	2.358
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		8	

8 Feb 1991 FILE:/PATTERNING/CENTERFIRE_PATT/C6587751

CENTERFIRE PATTERNS # 3



# OF SHOTS= 10
# IN CIR
1in = 3
2in = 5
3in = 8

HS= 2.687
VS= 2.080
GS= 2.939

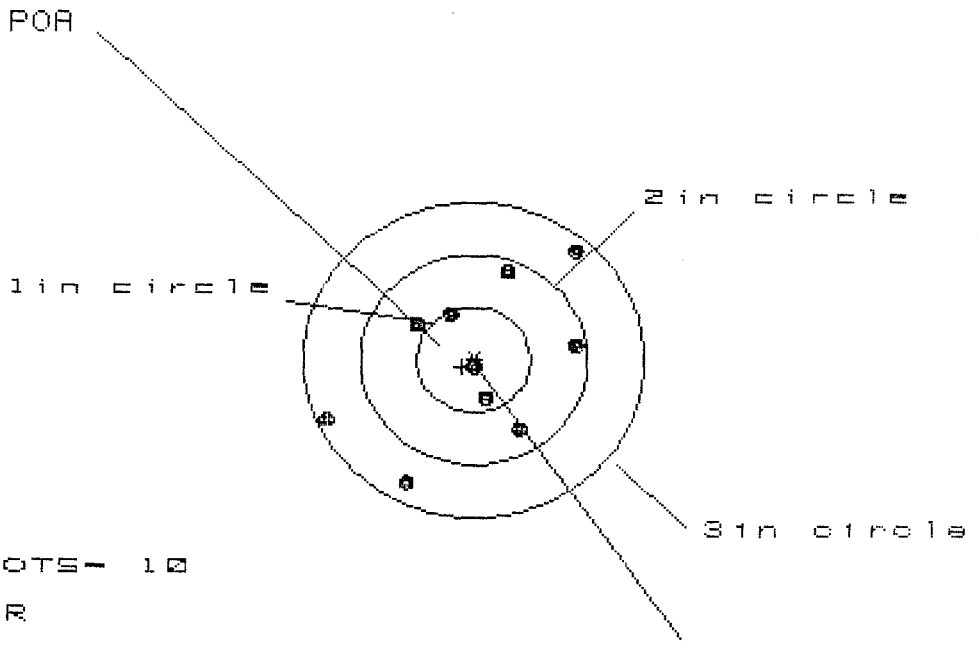
PATTERN # : 3

SHOTS (BEST OF) :	10	9	8
MAXIMUM X :	1.257	1.157	.965
MINIMUM X :	-1.430	-1.530	-1.705
MAXIMUM Y :	.681	.525	.568
MINIMUM Y :	-1.399	-.850	-.807
CENTROID X :	-.277	-.177	.015
CENTROID Y :	.025	.181	.138
POA TO CENTROID in.:	.278	.253	.139
MIN RADIUS :	.172	.135	.098
MEAN RADIUS :	.956	.816	.684
MAX RADIUS :	1.664	1.571	1.746
HORIZONTAL SPREAD :	2.687	2.687	2.670
VERTICAL SPREAD :	2.080	1.375	1.375
EXTREME SPREAD :	2.939	2.939	2.776

NUMBER IN ONE INCH CIRCLE = 3
NUMBER IN TWO INCH CIRCLE = 5
NUMBER IN THREE INCH CIRCLE = 8

8 Feb 1991 FILE:/PATTERNING/CENTERFIRE_PATT/C6507751

CENTERFIRE PATTERNS # 4



OF SHOTS= 10

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

HS= 2.264
VS= 2.148
GS= 2.735

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.933	.785	.840
MINIMUM X	:	-1.331	-.792	-.694
MAXIMUM Y	:	1.008	.949	.913
MINIMUM Y	:	-1.140	-1.199	-1.080
CENTROID X	:	.103	.251	.152
CENTROID Y	:	.062	.121	.002
POA TO CENTROID in.	:	.120	.278	.153
MIN RADIUS	:	.103	.195	.042
MEAN RADIUS	:	.821	.753	.667
MAX RADIUS	:	1.431	1.436	1.283
HORIZONTAL SPREAD	:	2.264	1.577	1.533
VERTICAL SPREAD	:	2.148	2.148	1.993
EXTREME SPREAD	:	2.735	2.665	2.196
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	

NUMBER IN THREE INCH CIRCLE = 10

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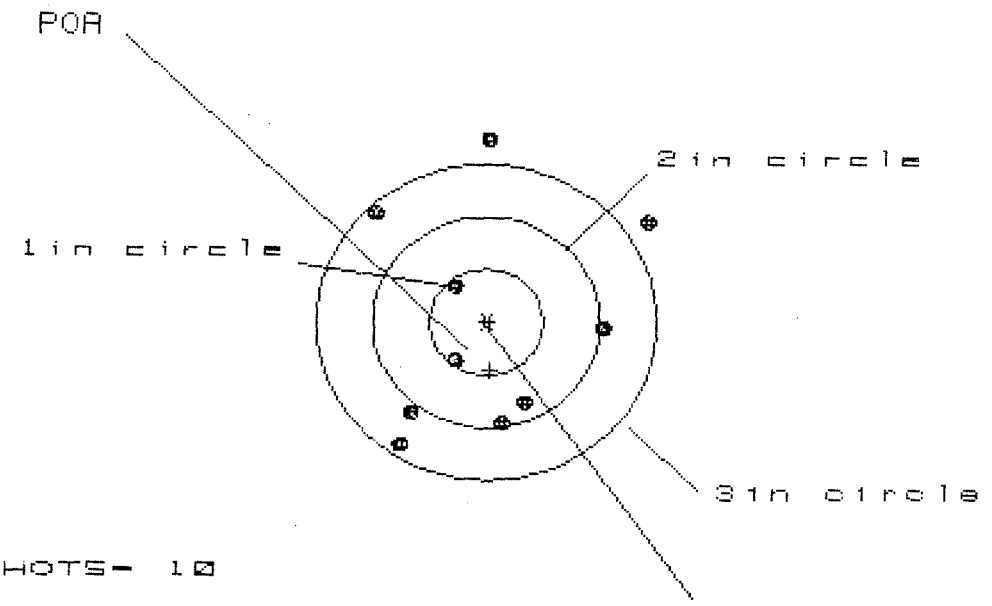
CENTERFIRE PATTERNS # 5



OF SHOTS= 10

# IN CIR
1in = 2
2in = 5
3in = 8

HS= 2.401
VS= 2.855
GS= 3.041

PATTERN # : 5

SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.455	1.149	1.177
MINIMUM X	:	-.946	-.785	-.757
MAXIMUM Y	:	1.712	1.821	1.392
MINIMUM Y	:	-1.142	-1.034	-.806
CENTROID X	:	-.030	-.191	-.219
CENTROID Y	:	.454	.346	.118
POA TO CENTROID in.	:	.455	.395	.249
MIN RADIUS	:	.441	.274	.059
MEAN RADIUS	:	1.100	.992	.824
MAX RADIUS	:	1.753	1.835	1.584
HORIZONTAL SPREAD	:	2.401	1.934	1.934
VERTICAL SPREAD	:	2.855	2.855	2.198
EXTREME SPREAD	:	3.041	2.962	2.293

NUMBER IN ONE INCH CIRCLE = 2
NUMBER IN TWO INCH CIRCLE = 5
NUMBER IN THREE INCH CIRCLE = 8