

C6523467

MODEL 700™ M24

Model **SMS**™

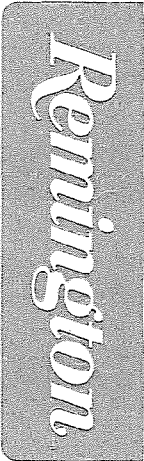
Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



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: RE00135765

Serial: C6523467 Model M24 SWS Center Fire
Caliber: 7.62 NATO Produced: 12/18/1990

Repairman:

Verify Repair

Status:

Closed 10/24/2007 8:43:25 AM

Address Information

Customer:

☒ Received From

Return To:

☐ Received From

Name: NEW MEXICO NATIONAL GUARD

NEW MEXICO NATIONAL GUARD

Address 1: BRENDA MALLARY

BRENDA MALLARY

Address 2: 10 BATAAN BLVD

PO Box:

10 BATAAN BLVD

PO Box:

City: SANTA FE

SANTA FE

State: NM

Zip Code: 87508

Country: US

State: NM

Zip Code: 87508

Country: US

FFL:

Contact / Condition

Problems

Estimate

History / Status

Shipping / Billing

Contact Information

Phone: NN

Fax:

Email:

Comments:

Received Condition

Fair

Condition
Notes:CSR
Notes:

Accessories Received

Code	Desc	Qty
A006	Sling Strap	1
A007	With Stud	3
A017	Scope Base	1
A026	Scope	1
A057	Fit and Rear Sgt Base	1

Repair Search

Refresh

Close

nagletj

10/25/2007

9:04 AM

CAPS

NUM

INS

SCRL

Serial
Number:

C6523467

Model: M24 SWS



RE00135765

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6523467.__0
FILE DATE AND TIME: 12/07/2007 09:08

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.072
The Average Y Centroid of the Five Target Set:	-0.064
The Average Point of Impact of the Five Target Set:	0.096
The Average Mean Radius of the Five Target Set:	0.766
The Distance from POA to Centroid Target #1:	0.264
The Distance from Centroid Target #2 to Centroid Target #1:	0.076
The Distance from Centroid Target #3 to Centroid Target #1:	0.387
The Distance from Centroid Target #4 to Centroid Target #1:	0.272
The Distance from Centroid Target #5 to Centroid Target #1:	0.384

BARBER - M24 0028576

SERIAL NUMBER: C6523467. __ 0

TARGET NUMBER: 1

FILE DATE: 12/07/2007

FILE TIME: 09:08

POINT#	X	Y
1:	0.611	-0.525
2:	0.553	-0.830
3:	0.621	-0.733
4:	0.406	0.410
5:	0.032	0.422
6:	0.012	-0.041
7:	-0.147	-0.379
8:	-0.627	0.239
9:	1.213	0.605
10:	-0.073	1.310

X CENTROID: 0.260

Y CENTROID: 0.048

POA TO CENTROID: 0.264

HORZ SPREAD: 1.840

VERT SPREAD: 2.140

GROUP SPREAD: 2.230

MIN RADIUS: 0.264

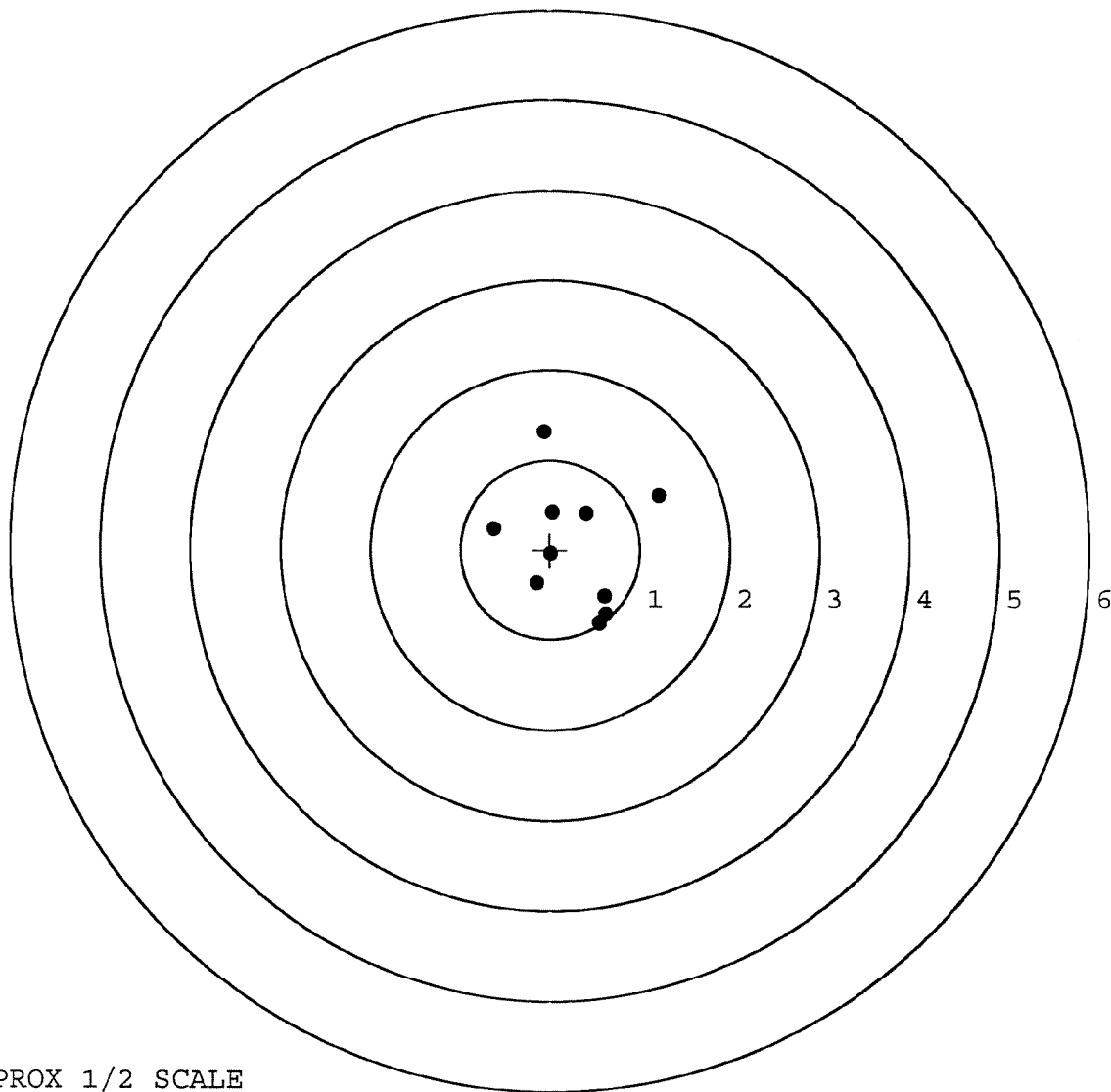
MAX RADIUS: 1.305

MEAN RADIUS: 0.746

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

BARBER - M24 0028577

SERIAL NUMBER: C6523467. __0

TARGET NUMBER: 2

FILE DATE: 12/07/2007

FILE TIME: 09:08

POINT#	X	Y
1:	1.096	-1.362
2:	0.311	-1.374
3:	1.139	1.189
4:	0.118	1.028
5:	0.045	0.523
6:	0.345	-0.060
7:	0.032	-0.335
8:	0.045	0.031
9:	-0.235	0.013
10:	-0.540	0.108

X CENTROID: 0.236

Y CENTROID: -0.024

POA TO CENTROID: 0.237

HORZ SPREAD: 1.679

VERT SPREAD: 2.563

GROUP SPREAD: 2.582

MIN RADIUS: 0.115

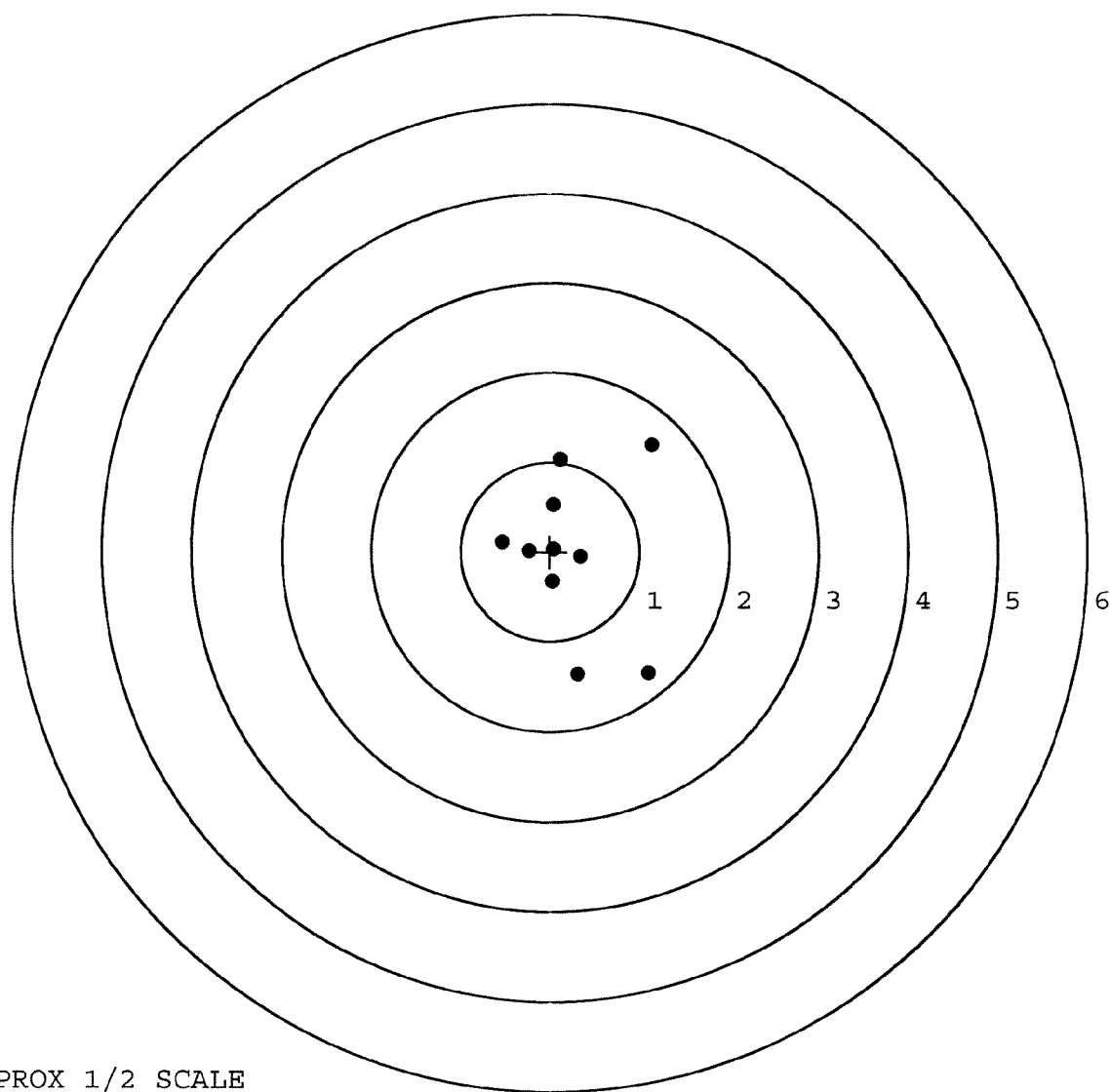
MAX RADIUS: 1.591

MEAN RADIUS: 0.804

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 8



TARGET APPROX 1/2 SCALE

BARBER - M24 0028578

SERIAL NUMBER: C6523467. __0

TARGET NUMBER: 3

FILE DATE: 12/07/2007

FILE TIME: 09:08

POINT#	X	Y
1:	0.309	1.344
2:	0.165	0.830
3:	0.757	0.245
4:	0.390	0.038
5:	-0.599	-1.559
6:	-0.665	-1.125
7:	0.076	-0.531
8:	-0.175	-0.531
9:	-0.406	0.183
10:	-0.690	-0.181

X CENTROID: -0.084

Y CENTROID: -0.129

POA TO CENTROID: 0.154

HORZ SPREAD: 1.447

VERT SPREAD: 2.903

GROUP SPREAD: 3.042

MIN RADIUS: 0.413

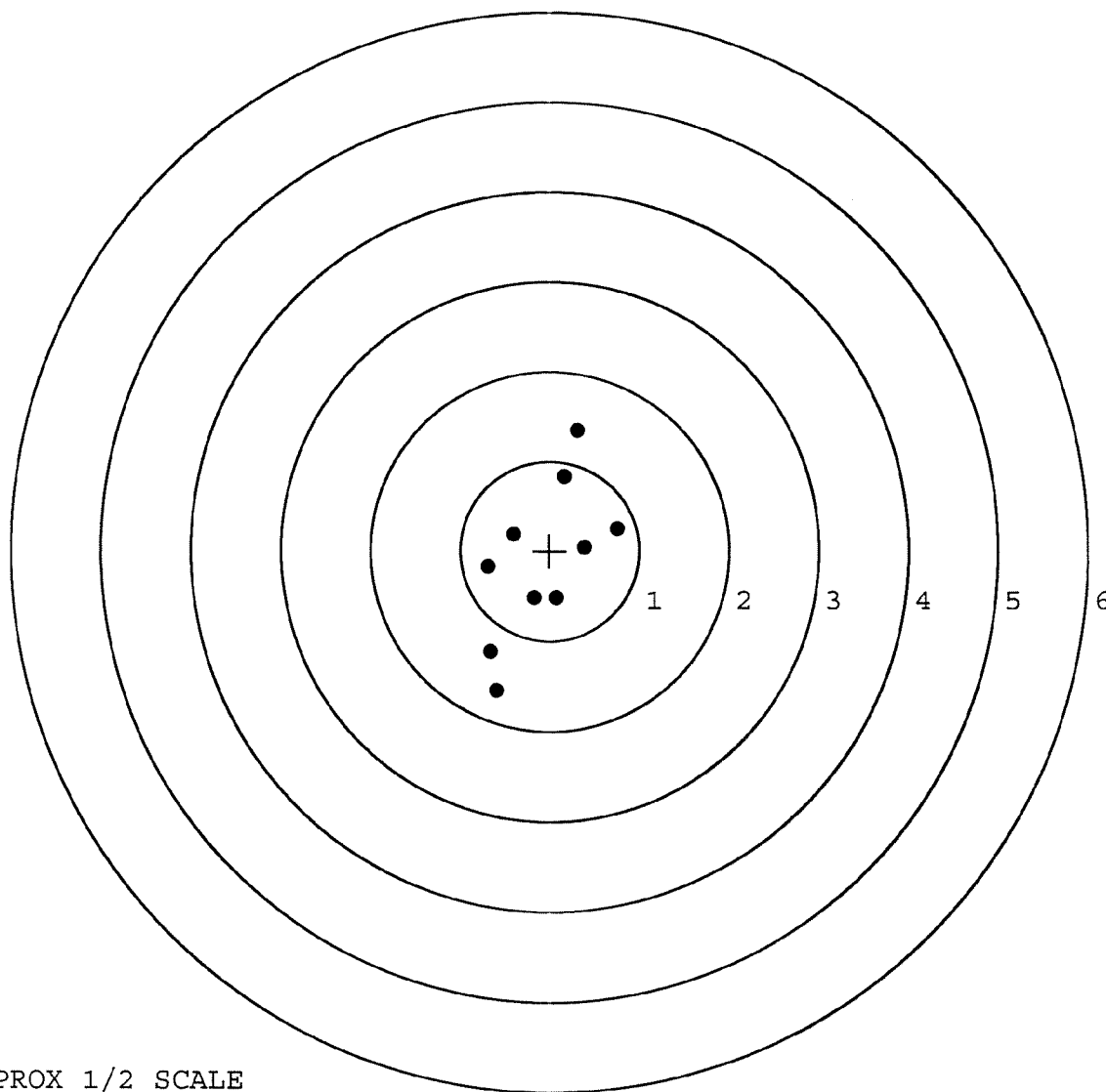
MAX RADIUS: 1.524

MEAN RADIUS: 0.851

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 8



TARGET APPROX 1/2 SCALE

BARBER - M24 0028579

SERIAL NUMBER: C6523467. __0

TARGET NUMBER: 4

FILE DATE: 12/07/2007

FILE TIME: 09:08

POINT#	X	Y
1:	1.125	-1.041
2:	0.749	0.149
3:	0.246	0.406
4:	0.516	-0.203
5:	0.268	-0.274
6:	0.046	-0.580
7:	-0.527	0.093
8:	-0.920	-0.405
9:	-0.662	0.543
10:	-0.362	0.083

X CENTROID: 0.048

Y CENTROID: -0.123

POA TO CENTROID: 0.132

HORZ SPREAD: 2.045

VERT SPREAD: 1.584

GROUP SPREAD: 2.388

MIN RADIUS: 0.267

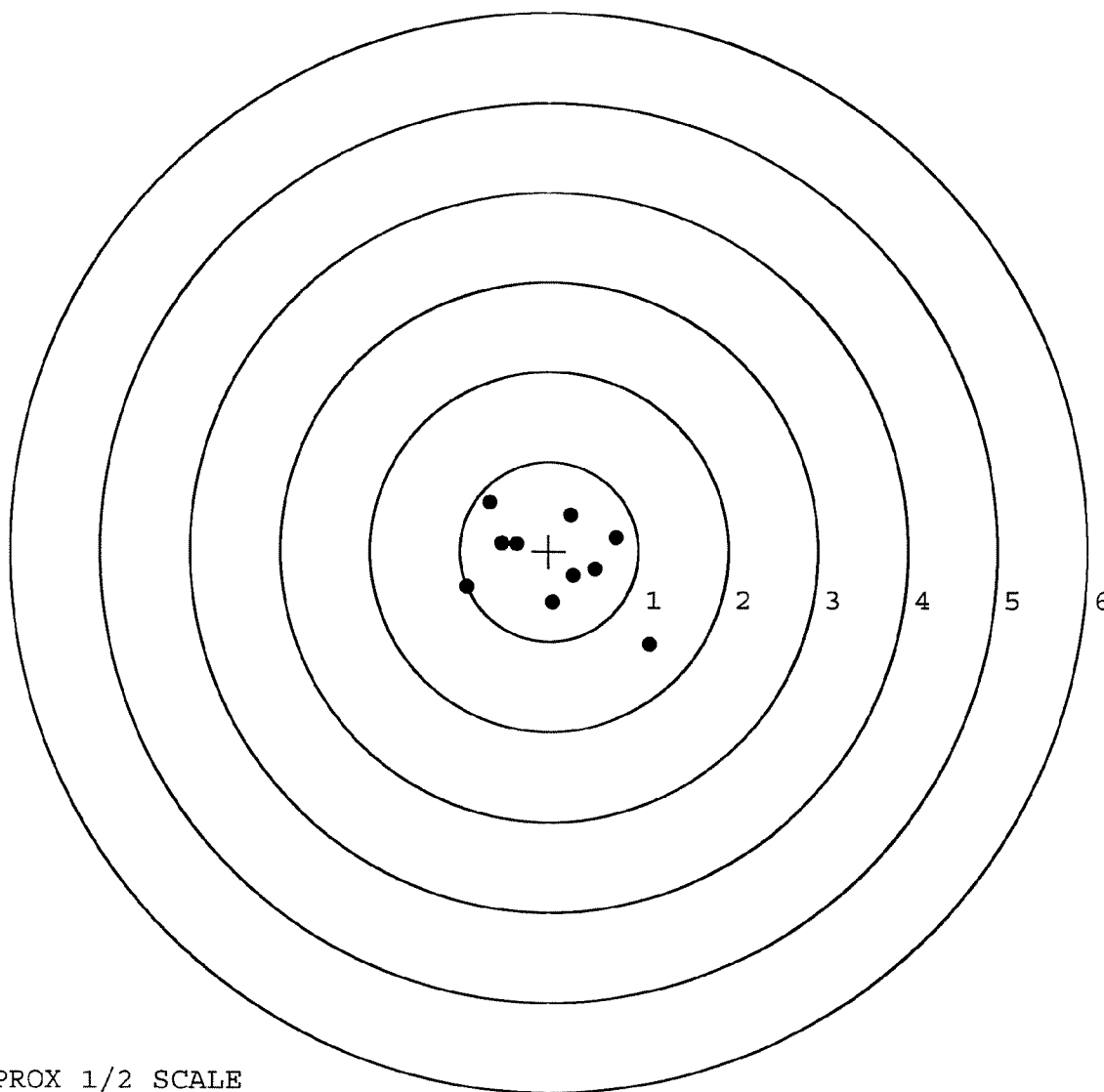
MAX RADIUS: 1.415

MEAN RADIUS: 0.699

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

BARBER - M24 0028580

SERIAL NUMBER: C6523467. __0

TARGET NUMBER: 5

FILE DATE: 12/07/2007

FILE TIME: 09:08

POINT#	X	Y
1:	-0.296	-1.380
2:	0.460	0.657
3:	-1.035	0.719
4:	-0.267	0.413
5:	-0.045	0.242
6:	-0.417	0.036
7:	-0.704	-0.156
8:	0.316	-0.278
9:	0.719	-0.568
10:	0.292	-0.592

X CENTROID: -0.098

Y CENTROID: -0.091

POA TO CENTROID: 0.133

HORZ SPREAD: 1.754

VERT SPREAD: 2.099

GROUP SPREAD: 2.225

MIN RADIUS: 0.337

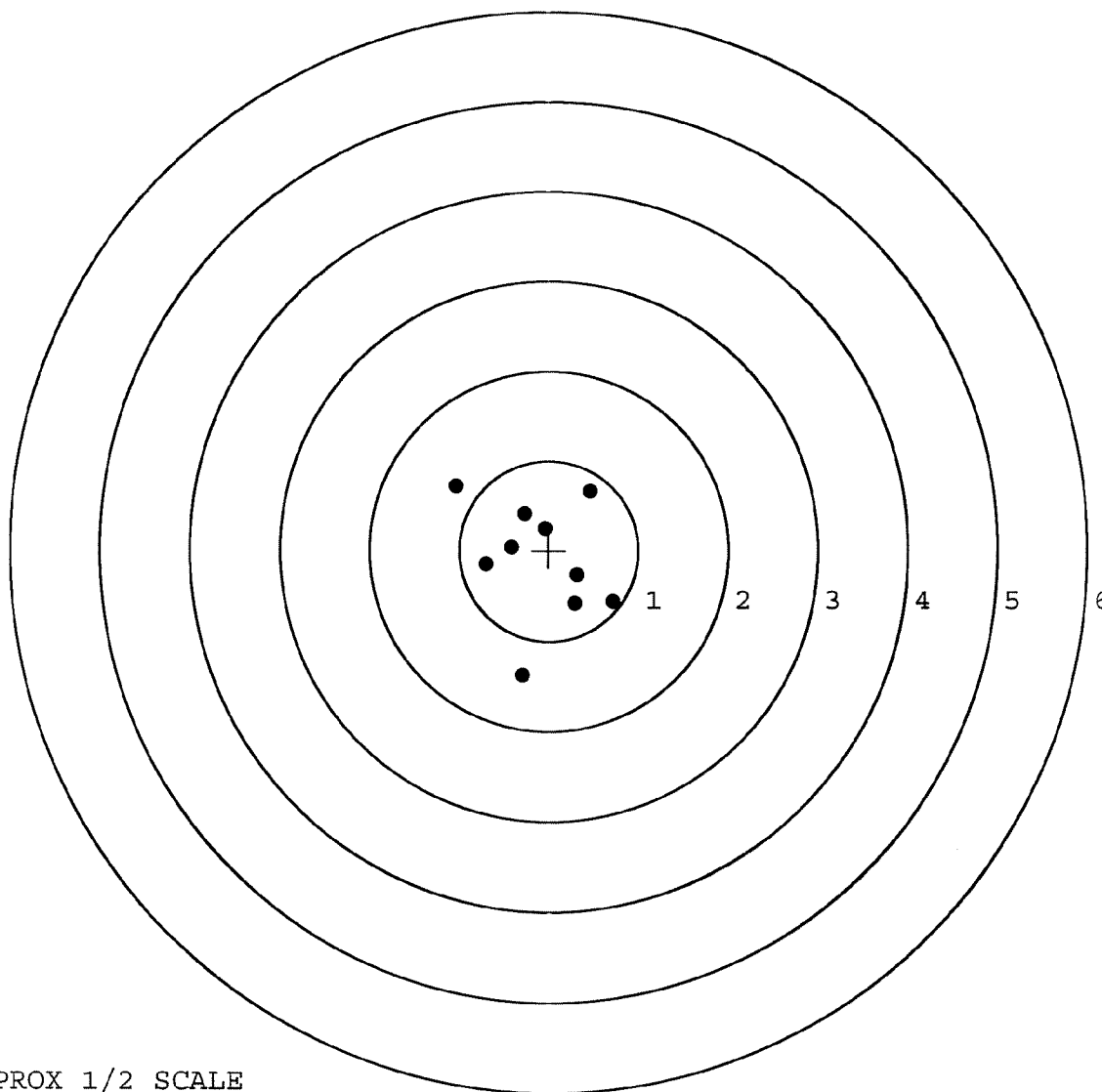
MAX RADIUS: 1.304

MEAN RADIUS: 0.733

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

M-24 INSPECTION CHECKLIST
CONTRACT #: DAAE-20-02-C-0149R & E NUMBER 135765SERIAL NUMBER C6523467LOG-IN DATE 10/25/07

OPERATION #	OPERATION NAME	DATE	INITIAL
500	DIS-ASSEMBLE GUN	11-7-07	SPD
505	RE-BARREL	11-8-07	SPD
560	ASSEMBLE	11-8-07	RTZ
600	PROOF	11-12-07	TRW
605	CHECK HEADSPACE	11-12-07	TRW
610	DIS-ASSEMBLE GUN	11-13-07	RTZ
612	MAGNAFLUX	11-14-07	JB
510	DRILL AND TAP	11-13-07	TRW
615	ROLLMARK CALIBER	11-13-07	CW
618	ROTO-BLAST	11-14-07	JB
620	APPLY COATINGS	11-27-07	JB
625	FINAL ASSEMBLY	12-5-07	RTZ
640	FUNCTION TEST AND	<u>PASS</u> FAIL	12-5-07 TRW
650	TARGET	<u>PASS</u> FAIL	12-5-07 TRW
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	12-5-07 FM
670	FINAL INSPECTION		12-10-07 RA
	A) HEADSPACE	<u>PASS</u> FAIL	12-10-07 RA
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	2.78 2.74 2.75 2.77 2.75 12/10/07 RA
680	F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX	4.5 4.5 4.5 12/10/07 RA
	G) SAFETY OFF FORCE	2 LBS MAX	3.0 3.0 3.0 12/10/07 RA
	I) FIRING PIN INDENT	.020	.022 .02175 .02150 12/10/07 RA
690	PACK		12/10/07 RA

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: **RE00092442** Serial: C6523467 Model: M24 SWS Center Fire Caliber: 7.62 NATO Produced: 12/13/1990 Repairman: Status: Closed 2/3/2005 1:26:10 PM

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: **36201 4199** Country: **US** State: **AL** Zip Code: **36201 4199** 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
A017	Scope Base	1
A057	Fit and Rear Sgt Base	1

Repair Search Refresh Close

start 3 2

Serial Number: **C6523467**

Model: **M24 SWS**



RE00092442

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6523467.___0
FILE DATE AND TIME: 09/02/2005 11:01

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.030
The Average Y Centroid of the Five Target Set:	-0.096
The Average Point of Impact of the Five Target Set:	0.101
The Average Mean Radius of the Five Target Set:	0.862
The Distance from POA to Centroid Target #1:	0.100
The Distance from Centroid Target #2 to Centroid Target #1:	0.344
The Distance from Centroid Target #3 to Centroid Target #1:	0.088
The Distance from Centroid Target #4 to Centroid Target #1:	0.079
The Distance from Centroid Target #5 to Centroid Target #1:	0.048

SERIAL NUMBER: C6523467. __0

TARGET NUMBER: 1

FILE DATE: 09/02/2005

FILE TIME: 11:01

POINT#	X	Y
1:	1.528	0.731
2:	0.700	0.699
3:	0.910	-0.126
4:	0.568	-0.019
5:	0.134	-0.273
6:	-0.194	-0.526
7:	-0.429	-1.109
8:	-0.721	-0.159
9:	-0.592	0.079
10:	-0.968	0.359

X CENTROID: 0.094

Y CENTROID: -0.034

POA TO CENTROID: 0.100

HORZ SPREAD: 2.496

VERT SPREAD: 1.840

GROUP SPREAD: 2.686

MIN RADIUS: 0.242

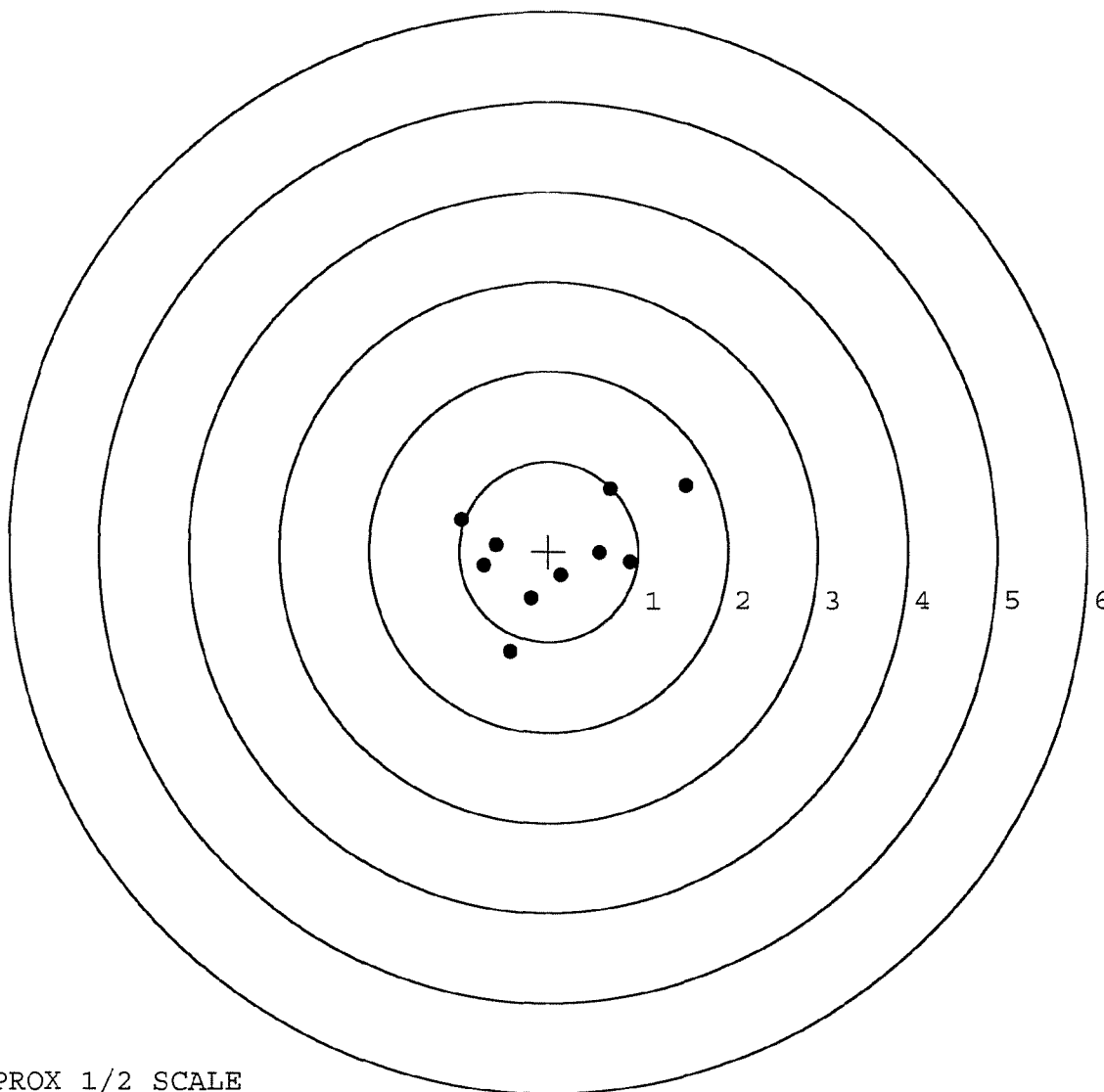
MAX RADIUS: 1.626

MEAN RADIUS: 0.853

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

BARBER - M24 0028585

SERIAL NUMBER: C6523467. __0

TARGET NUMBER: 2

FILE DATE: 09/02/2005

FILE TIME: 11:01

POINT#	X	Y
1:	1.081	-1.270
2:	0.067	-2.149
3:	-0.114	-0.682
4:	0.731	0.138
5:	0.439	0.465
6:	-0.147	0.107
7:	-0.201	0.314
8:	-0.441	0.110
9:	-0.299	0.187
10:	-1.684	-0.653

X CENTROID: -0.057

Y CENTROID: -0.343

POA TO CENTROID: 0.348

HORZ SPREAD: 2.765

VERT SPREAD: 2.614

GROUP SPREAD: 2.640

MIN RADIUS: 0.343

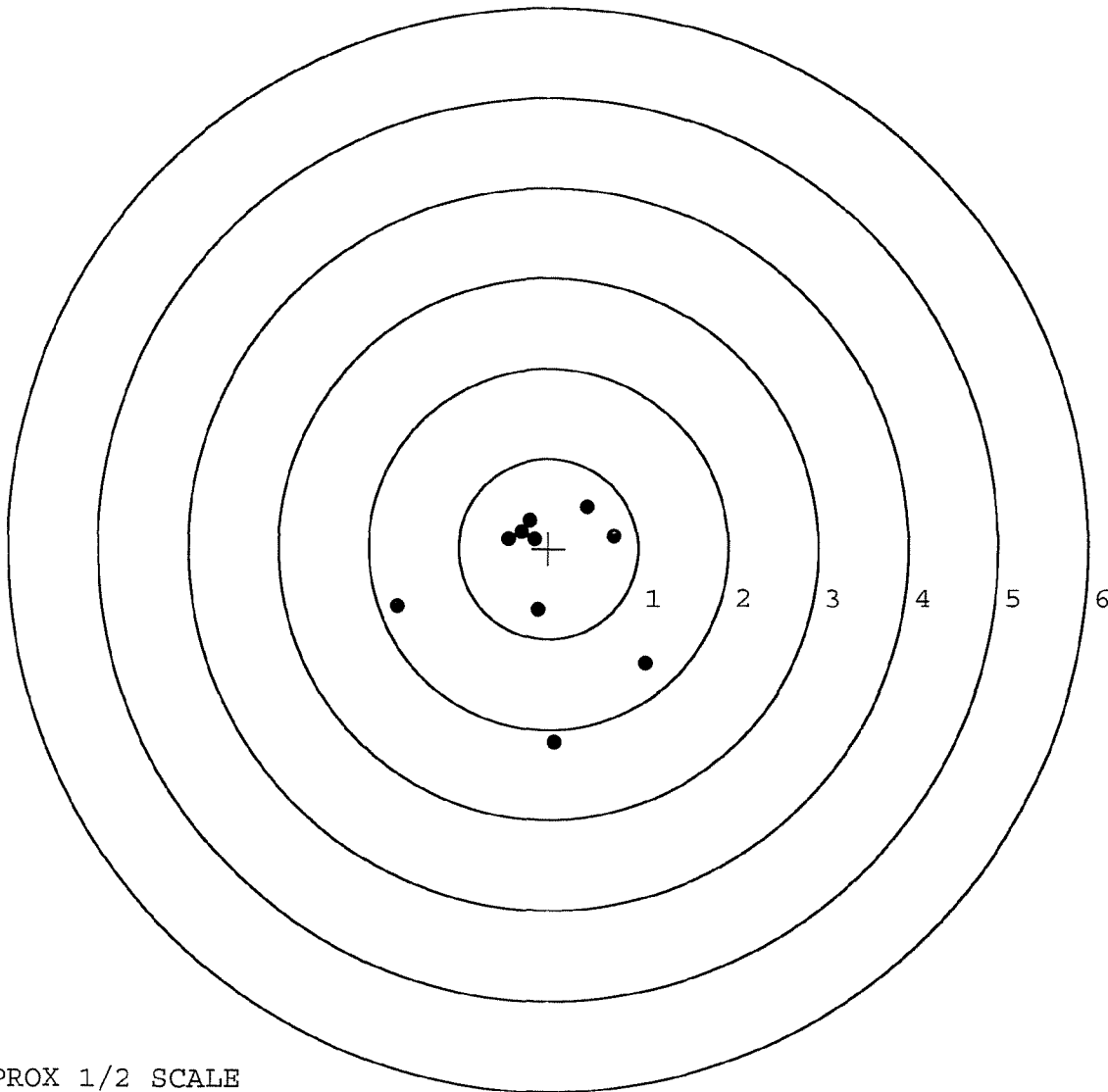
MAX RADIUS: 1.810

MEAN RADIUS: 0.946

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 8



TARGET APPROX 1/2 SCALE

BARBER - M24 0028586

SERIAL NUMBER: C6523467. __0

TARGET NUMBER: 3

FILE DATE: 09/02/2005

FILE TIME: 11:01

POINT#	X	Y
1:	1.093	-0.299
2:	0.849	-0.178
3:	0.510	-0.462
4:	-0.228	-0.804
5:	-0.214	-0.230
6:	-0.814	-0.255
7:	-0.846	0.242
8:	-0.635	0.504
9:	0.041	0.610
10:	0.338	0.778

X CENTROID: 0.009

Y CENTROID: -0.009

POA TO CENTROID: 0.013

HORZ SPREAD: 1.939

VERT SPREAD: 1.582

GROUP SPREAD: 2.013

MIN RADIUS: 0.314

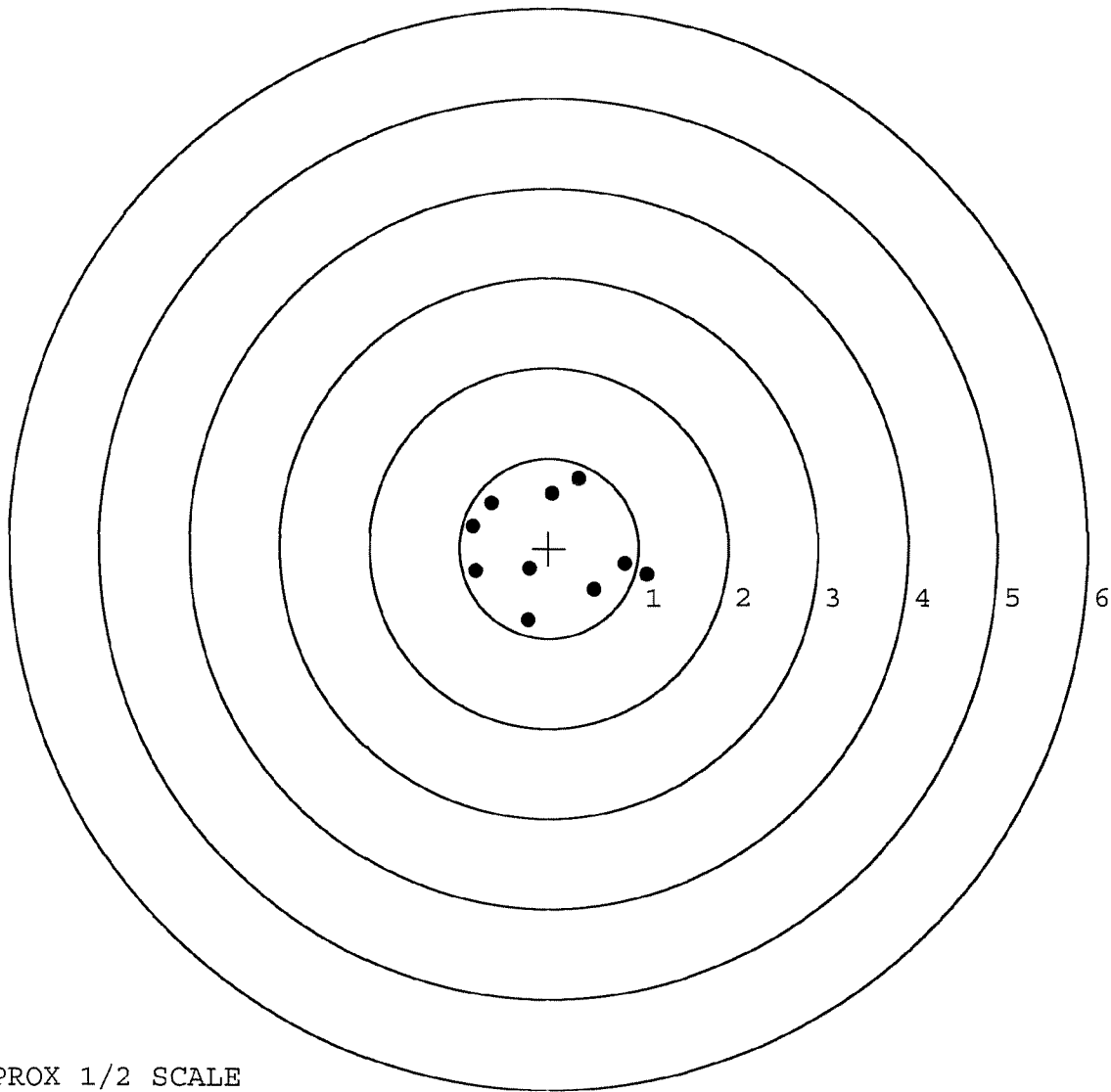
MAX RADIUS: 1.122

MEAN RADIUS: 0.784

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10



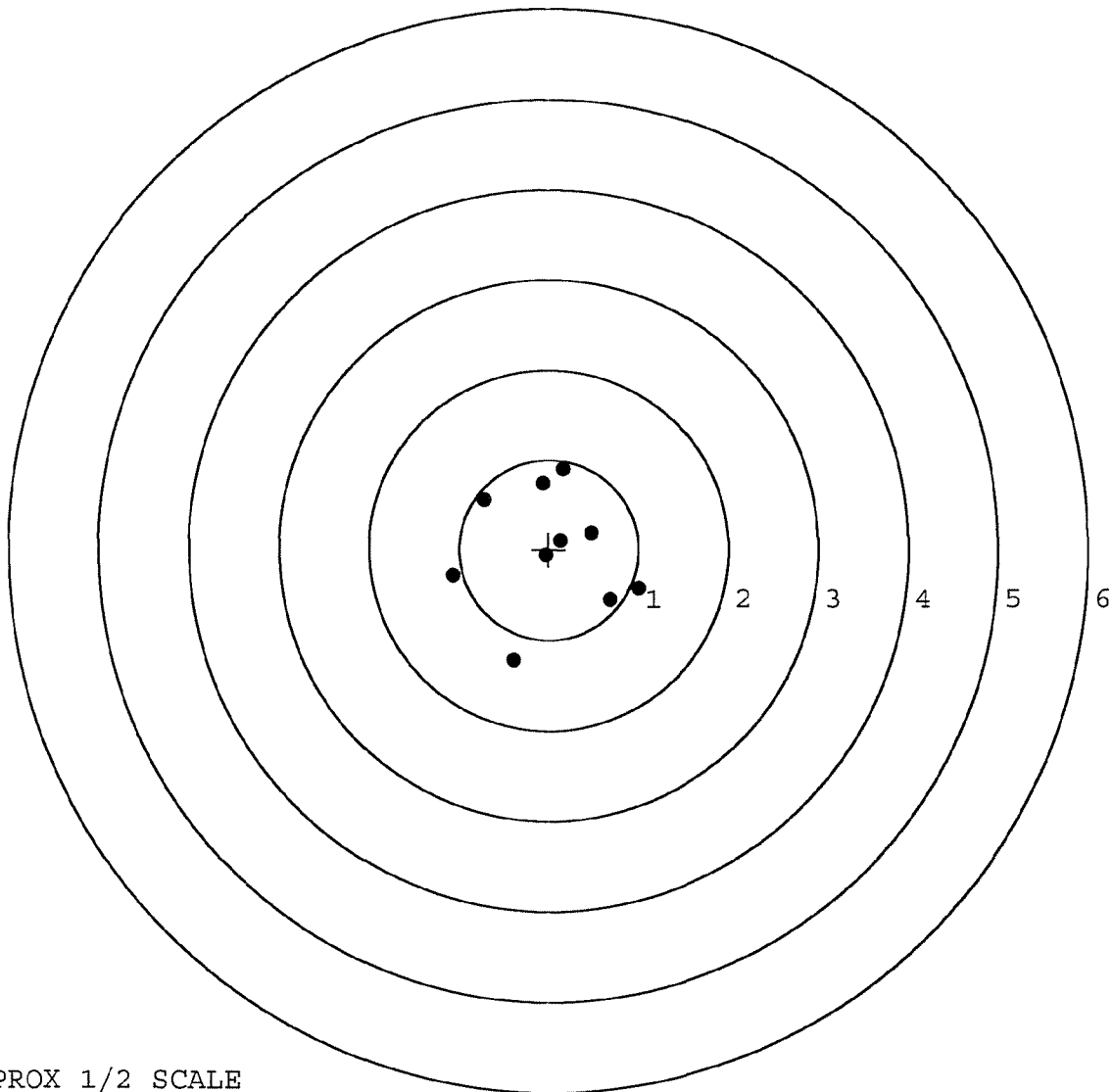
TARGET APPROX 1/2 SCALE

BARBER - M24 0028587

SERIAL NUMBER: C6523467. __0
 TARGET NUMBER: 4
 FILE DATE: 09/02/2005
 FILE TIME: 11:01

POINT#	X	Y
1:	1.002	-0.436
2:	0.692	-0.562
3:	-0.387	-1.229
4:	0.482	0.185
5:	0.131	0.094
6:	-0.038	-0.073
7:	0.156	0.897
8:	-0.065	0.738
9:	-0.721	0.548
10:	-1.073	-0.295

X CENTROID: 0.018
 Y CENTROID: -0.013
 POA TO CENTROID: 0.022
 HORZ SPREAD: 2.075
 VERT SPREAD: 2.126
 GROUP SPREAD: 2.194
 MIN RADIUS: 0.082
 MAX RADIUS: 1.281
 MEAN RADIUS: 0.770
 # IN 1 IN DIAMETER: 2
 # IN 2 IN DIAMETER: 7
 # in 3 IN DIAMETER: 10



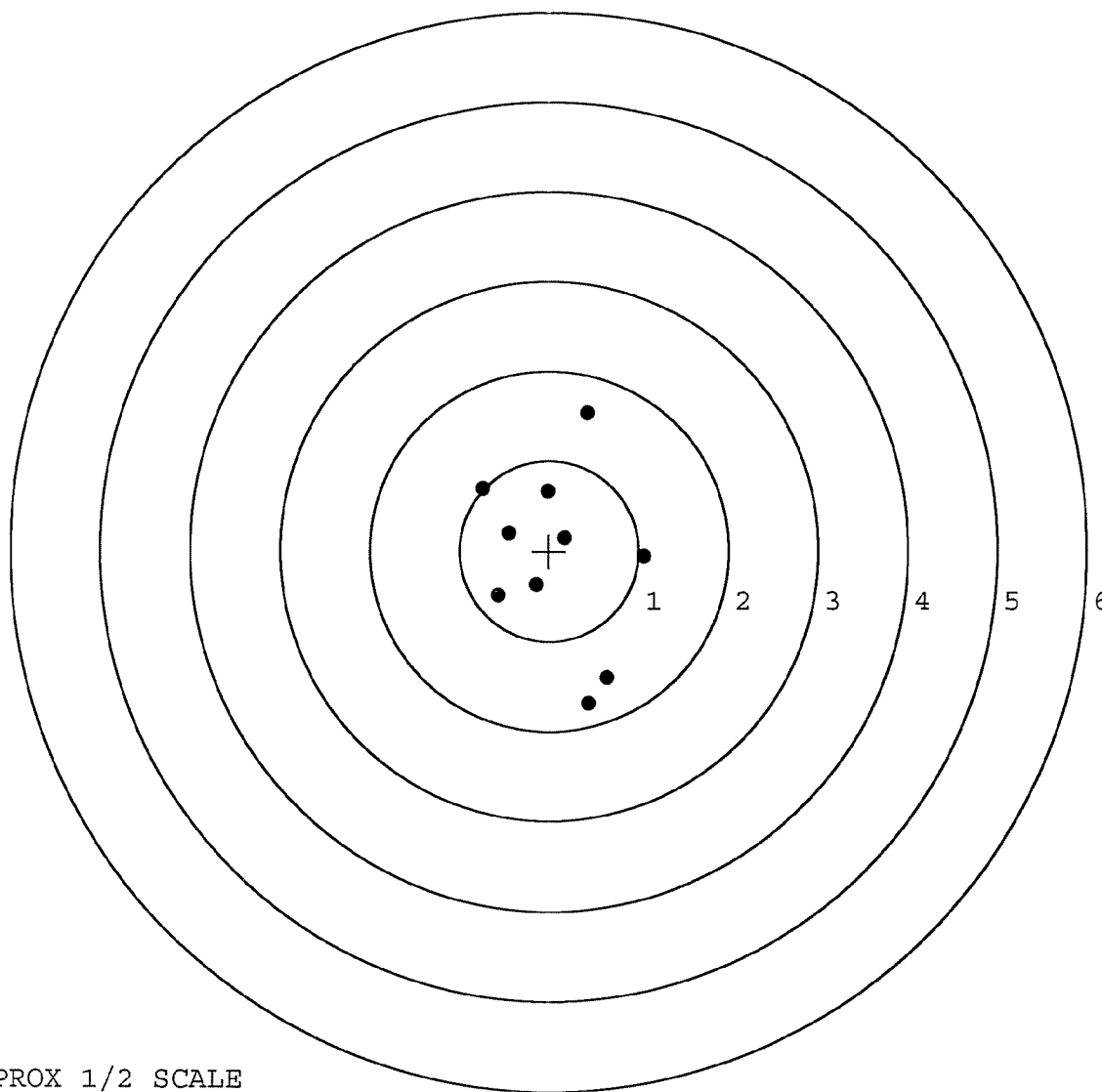
TARGET APPROX 1/2 SCALE

BARBER - M24 0028588

SERIAL NUMBER: C6523467.____0
 TARGET NUMBER: 5
 FILE DATE: 09/02/2005
 FILE TIME: 11:01

POINT#	X	Y
1:	1.056	-0.066
2:	0.431	1.528
3:	-0.014	0.663
4:	0.178	0.146
5:	-0.450	0.197
6:	-0.745	0.692
7:	-0.142	-0.374
8:	-0.569	-0.494
9:	0.652	-1.412
10:	0.446	-1.696

X CENTROID: 0.084
 Y CENTROID: -0.082
 POA TO CENTROID: 0.117
 HORZ SPREAD: 1.801
 VERT SPREAD: 3.224
 GROUP SPREAD: 3.224
 MIN RADIUS: 0.246
 MAX RADIUS: 1.654
 MEAN RADIUS: 0.960
 # IN 1 IN DIAMETER: 2
 # IN 2 IN DIAMETER: 6
 # in 3 IN DIAMETER: 8



TARGET APPROX 1/2 SCALE

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

R & E NUMBER	92442		
SERIAL NUMBER	C6523467		
LOG-IN DATE	2-3-05		
INSPECT AND VERIFY:			
OPERATION #	OPERATION NAME	DATE	INITIAL
550	DIS-ASSEMBLE GUN	8-16-05	RTZ
560 A	RE-BARREL	8-23-05	RTZ
B	DRILL AND TAP	8-25-05	TRW
575	ASSEMBLE	8-24-05	RTZ
600	PROOF	8-24-05	AC
605	CHECK HEADSPACE	8-24-05	AC
610	DIS-ASSEMBLE GUN	8-25-05	RR
612	MAGNAFLUX	8-25-05	
615	ROLLMARK CALIBER	8-25-05	CW
618	ROTO-BLAST	8-26-05	LB
620	APPLY COATINGS	8/29/05	RB
625 A	FINAL ASSEMBLY	9-1-05	RTZ
B	TRIGGER PULL TEST		
C	SAFETY "ON" FORCE	9-6-05	AC
D	SAFETY "OFF" FORCE	9-6-05	AC
E	FIRING PIN INDENT	9-6-05	AC
640	TARGET	9-2-05	TRW
655	FINAL INSPECT	9-6-05	AC
660	PACK	9-12-05	RTA
		SHIP DATE	
		QAR INSPECTION DATE	

BARBER M24 0028599 RECEIVING AND ESTIMATING REPORT

COMMENTS

R

ORDER
94-18277

INITIAL CUSTOMER ORDER NO.
FDC DAAA09-92-C-0834

W/10X SCOPE, M-24 SNIPER, W/DEPLOYMENT KIT
ATTN: FRED MARTIN

DATE RECEIVED 06/10/94	DATE OPENED 06/10/94	DATE CODE	SERIAL NUMBER C6523467	NEW SERIAL NUMBER	MODEL AND GRADE 700 7-62 NATO
ACCESSORIES SLING STRAP HARD CASE SCOPE MNTS SCOPE BASE			90-0797		

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.O.D.L.

ACCOUNT NUMBER

ACCOUNT NUMBER N/C

WRITE ☐

PROM. DATE

ESTIMATED

VIA

FRT

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

Trigger Assy 173.71
Scope Repair 119.43
Clean/Insp/Prep 50.00
343.14

REPAIRMAN

PROOF

CLEAN

TEST

TARGET

PATTERN

GALLERY TESTER

DATE

DATE

DATE

DATE

DATE

OFFICE COPY

RD5925 REV. 1/94

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

BARBER - M24 0028599 0028629

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

SERIAL NO. C6523467
DATE 10-18-95
TESTER DA

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#	COMMENTS
PULL #1	2.41	2.44	2.64	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.32	2.60	2.58	
PULL #3	2.49	2.75	2.62	
PULL #4	2.48	2.62	2.44	
PULL #5	2.46	2.58	2.53	
TOTAL	12.16	12.99	12.81	
AVG.	2.43	2.59	2.56	

	3.00# INITIAL	3.00# AFTER 20 CYCLES	COMMENTS
PULL #1	3.17	2.95	
PULL #2	3.10	3.04	
PULL #3	3.01	2.99	
PULL #4	2.97	2.95	
PULL #5	3.01	3.03	
TOTAL	15.24	14.96	
AVG.	3.05	2.99	

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.22	3.90	4.13	
PULL #2	4.00	3.95	3.95	
PULL #3	3.96	4.05	4.00	
PULL #4	4.03	3.85	3.92	
PULL #5	4.04	3.97	3.90	
TOTAL	20.25	19.72	19.90	
AVG.	4.05	3.94	3.98	

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C 6523467

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			

BARBER - M24 0028593

op. #	OP. NAME	READINGS					DATE	INIT
525 cont.	F) Safety On Force	6 1/2	6 1/2	6 1/4			11/28	W.B.
	G) Safety Off Force	3 1/2	3 1/2	3 1/2			11/28	W.B.
	H) Trigger Pull Test & Retainability							
	I) Firing Pin Indent							
	J) Assemble Stock							
	K) Assemble Swivel Studs							
	L) Attach Front and Rear Sight Assemblies							
	M) Iron Sight Alignment							
	N) Detach Front & Rear Sights & place in numbered container							
	O) Attach Scope to Rifle							
	P) Detach & Attach Scope 20 Times							
640	Gallery Target & Test							
	A) Time							
	B) Malfunctions							
	C) Pierced Primers							
	D) Optical Clarity of Scope							
645	Inspect for Live Ammo							
655	Final Inspection							
	A) Headspace							
	B) Trigger Pull	2.32	2.40	2.30	2.36	2.37	11/28	W.B.
	C) Function							
660	Pack							

Remington® **DUPONT**
REG. U.S. PAT. & TM. OFF.

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

MODEL 700™ M24

SERIAL NO.
C6523467

ORDER NO.
5716

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

01

5716 C6523467

UPC

0 47700 25716 7

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6523467

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	9 24	90	RW
600	Proof	9 24	90	RW
607	Check Headspace	9 24	90	RW
610	Dis-assemble Gun	9 24	90	RW
612	Magnaflux Barrel Action		9-25-90	KR
	Magnaflux Bolt		9-25-90	KR
615	Rollmark Caliber		9-25-90	SS
617	Drill and Tap Sight Holes		9-25-90	FB
618	Polish Barrel AB		9/28/90	WB
620	Apply Coatings (Barrel Action)		10-2-90	TJA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		10/9/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/9/90	RW
	C) Inspect Ejector Hole for Chamfer		10/9/90	RW
	D) Oil Firing Pin Ass'y		10/9/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		10/18/90	SH

op. #	OP. NAME	READINGS					DATE	INIT
605 nt.	F) Safety On Force	4 1/2	4 1/2	4 1/2			10/24/90	WB
	G) Safety Off Force	2 1/2	2 1/2	2 1/2			10/24/90	WB
	H) Trigger Pull Test & Retainability						10/18/90	YJ
	I) Firing Pin Indent	.021	.0205	.0205			10/24/90	WB
	J) Assemble Stock						10/29/90	RW
	K) Assemble Swivel Studs						3/10/90	YJ
	L) Attach Front and Rear Sight Assemblies						10/29/90	RW
	M) Iron Sight Alignment						10/29/90	RW
	N) Detach Front & Rear Sights & place in numbered container						10/29/90	RW
	O) Attach Scope to Rifle						10/29/90	RW
	P) Detach & Attach Scope 20 Times						10/29/90	RW
640	Gallery Target & Test						10-30-90	AF
	A) Time						10-30-90	AF
	B) Malfunctions						10-30-90	AF
	C) Pierced Primers						10-30-90	AF
	D) Optical Clarity of Scope						10-30-90	AF
645	Inspect for Live Ammo						10-30-90	AF
655	Final Inspection							
	A) Headspace						3/10/90	YJ
	B) Trigger Pull	259	262	268	269	290	3/10/90	YJ
	C) Function						3/10/90	YJ
660	Pack						12-17-90	DH

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO C6523467

DATE 10-18-90

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.27	2.43	2.43	2.59	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.39	2.46	2.43	2.62	
PULL #3	2.41	2.46	2.50	2.68	
PULL #4	2.42	2.46	2.48	2.69	
PULL #5	2.47	2.48	2.48	2.90	
TOTAL	11.96	12.29	12.32		
AVG.	2.392	2.458	2.464		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.26	3.34		
PULL #2	3.34	3.40		
PULL #3	3.22	3.39		
PULL #4	3.33	3.38		
PULL #5	3.36	3.44		
TOTAL	16.51	16.97		
AVG.	3.302	3.394		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.45	4.15		4.44
PULL #2	4.45	4.44		4.43
PULL #3	4.17	4.43		4.40
PULL #4	4.32	4.44		4.38
PULL #5	4.42	4.36		4.40
TOTAL	21.81	21.82		22.05
AVG.	3.362	4.364		4.41

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6523467
31 Oct 1990

CENTROIDAL DISTANCES

0 TO	1	.343984
1 TO	2	.537261
1 TO	3	.219002
1 TO	4	.449003
1 TO	5	.450281

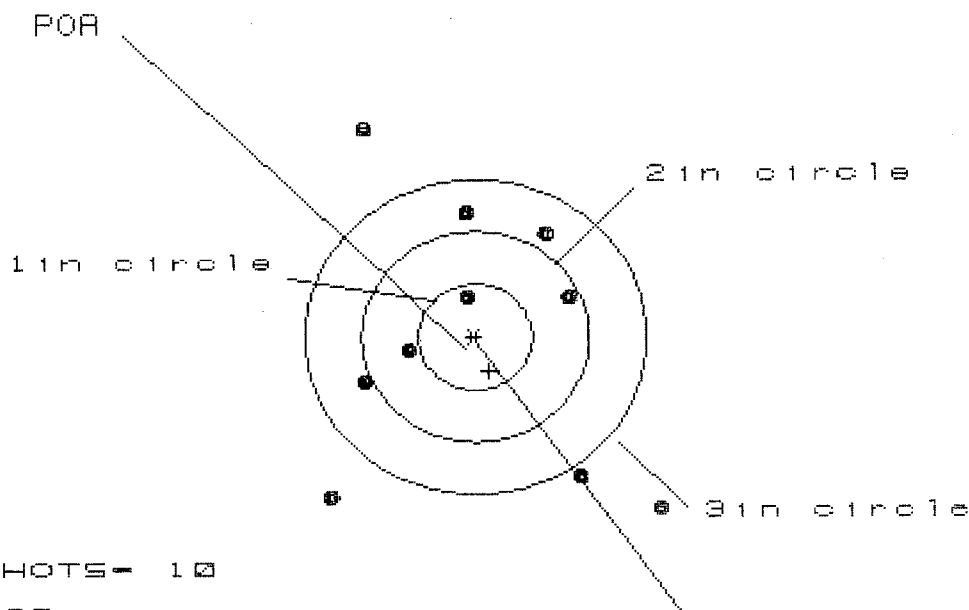
$\frac{1}{5}$ <----FOR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0868
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0042
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0869016
THE AMR FOR THIS RIFLE IS: .9594

31 Oct 1998

FILE:/PATTERNING/CENTERFIRE_PATT/ C6523467

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 1

2in = 3

3in = 6

HS= 2.818

VS= 3.616

GS= 4.443

CENTROID *

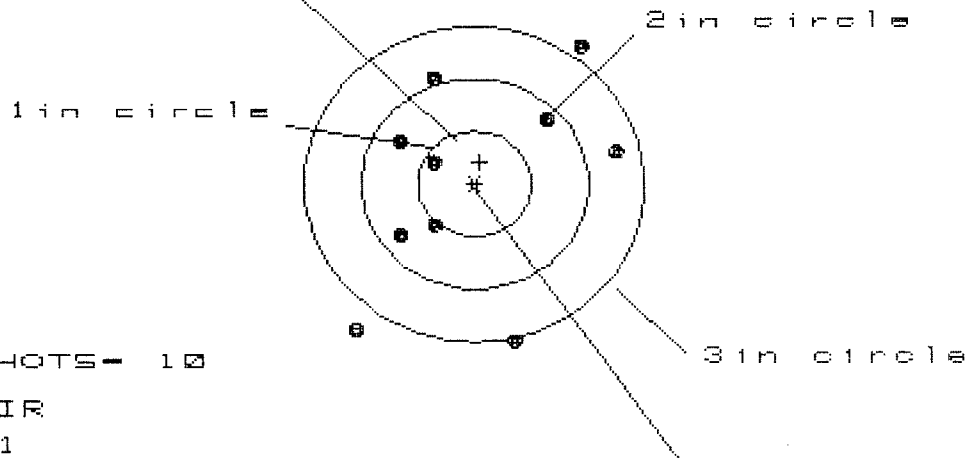
PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.589	1.063	.961
MINIMUM X	:	-1.229	-1.052	-1.154
MAXIMUM Y	:	1.967	1.784	1.247
MINIMUM Y	:	-1.649	-1.703	-1.480
CENTROID X	:	-.121	-.298	-.196
CENTROID Y	:	.322	.505	.282
POA TO CENTROID in.	:	.344	.586	.343
MIN RADIUS	:	.386	.231	.421
MEAN RADIUS	:	1.339	1.194	1.113
MAX RADIUS	:	2.290	2.002	1.877
HORIZONTAL SPREAD	:	2.818	2.115	2.115
VERTICAL SPREAD	:	3.616	3.487	2.727
EXTREME SPREAD	:	4.443	3.745	3.108
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	3		
NUMBER IN THREE INCH CIRCLE	=	6		

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CENTERFIRE PATTERNS # 2

POA



OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 7

HS= 2.319

VS= 2.757

GS= 3.335

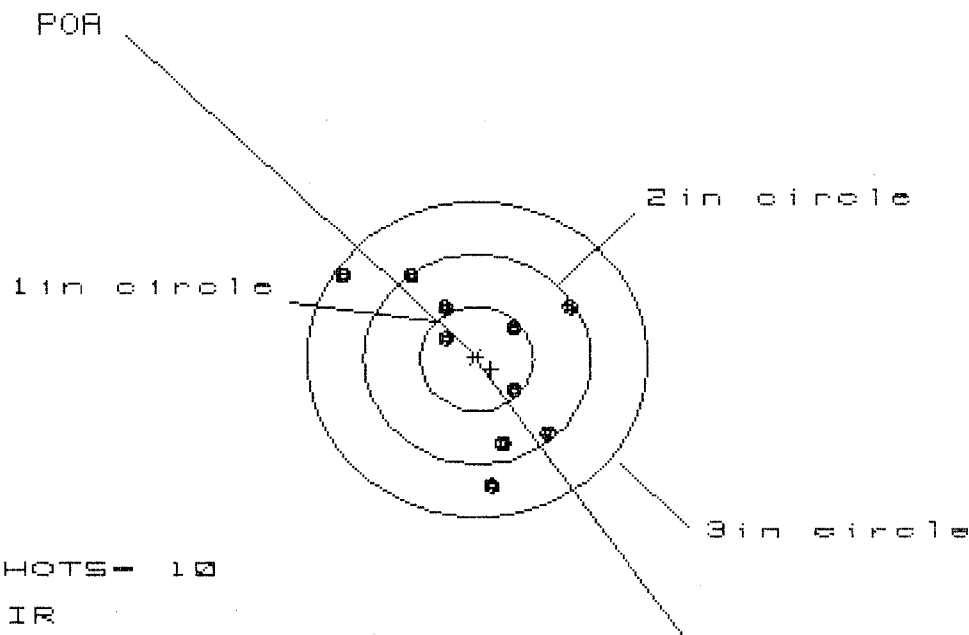
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.291	1.176	1.283
MINIMUM X	:	-1.028	-.801	-.694
MAXIMUM Y	:	1.285	1.131	.958
MINIMUM Y	:	-1.472	-1.626	-1.484
CENTROID X	:	-.046	.069	-.038
CENTROID Y	:	-.210	-.056	-.197
POA TO CENTROID in.:	:	.215	.089	.201
MIN RADIUS	:	.406	.450	.404
MEAN RADIUS	:	1.063	.988	.913
MAX RADIUS	:	1.726	1.648	1.531
HORIZONTAL SPREAD	:	2.319	1.977	1.977
VERTICAL SPREAD	:	2.757	2.757	2.442
EXTREME SPREAD	:	3.335	2.819	2.541
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		7	

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CENTERFIRE PATTERNS # 3



OF SHOTS - 10

IN CIR

1in = 3

2in = 8

3in = 10

HS = 2.048

VS = 2.083

GS = 2.440

CENTROID *

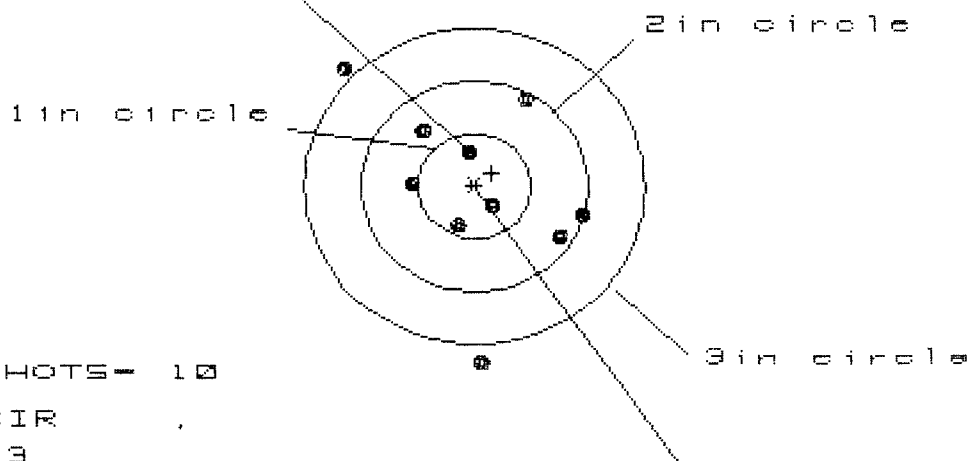
PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.854	.721	.714
MINIMUM X	:	-1.194	-.756	-.763
MAXIMUM Y	:	.833	.854	.709
MINIMUM Y	:	-1.250	-1.158	-.806
CENTROID X	:	-.122	.011	.018
CENTROID Y	:	.103	.011	.156
POA TO CENTROID in.	:	.160	.015	.157
MIN RADIUS	:	.376	.280	.295
MEAN RADIUS	:	.819	.732	.668
MAX RADIUS	:	1.456	1.159	1.042
HORIZONTAL SPREAD	:	2.048	1.477	1.477
VERTICAL SPREAD	:	2.083	2.012	1.515
EXTREME SPREAD	:	2.440	2.130	1.896
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 4

POA



OF SHOTS - 10

IN CIR

1in - 3

2in - 8

3in = 8

HS= 2.035

VS= 2.713

GS= 2.962

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.917	.924	.785
MINIMUM X	:	-1.118	-1.111	-.701
MAXIMUM Y	:	1.086	.905	.801
MINIMUM Y	:	-1.627	-.625	-.512
CENTROID X	:	-.151	-.158	-.020
CENTROID Y	:	-.126	.055	-.058
POA TO CENTROID in.	:	.196	.168	.062
MIN RADIUS	:	.181	.112	.197
MEAN RADIUS	:	.808	.708	.612
MAX RADIUS	:	1.628	1.433	.857
HORIZONTAL SPREAD	:	2.035	2.035	1.486
VERTICAL SPREAD	:	2.713	1.530	1.313
EXTREME SPREAD	:	2.962	2.426	1.550
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		8	

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FILE:/PATTERNING/CENTERFIRE_PATT/ CB523467

CENTERFIRE PATTERNS # 5

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS- 10

IN CIR

1 in - 3

2 in - 7

3 in = 10

HS= 1.424

VS= 2.361

GS= 2.419

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.571	.529	.542
MINIMUM X	-.853	-.895	-.882
MAXIMUM Y	1.225	1.149	1.024
MINIMUM Y	-1.136	-1.000	-.617
CENTROID X	.006	.048	.035
CENTROID Y	-.110	-.246	-.121
POA TO CENTROID in.	.110	.251	.127
MIN RADIUS	.473	.331	.454
MEAN RADIUS	.768	.685	.653
MAX RADIUS	1.282	1.159	1.037
HORIZONTAL SPREAD	1.424	1.424	1.424
VERTICAL SPREAD	2.361	2.149	1.641
EXTREME SPREAD	2.419	2.149	1.716
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		10	