

CS348824

MODEL 700™ M24

Model **SWS**™

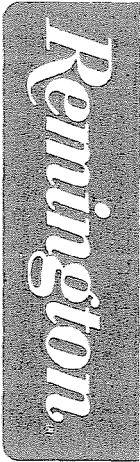
Action

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: **RE00129489** Serial: C6348824 Model M24 SWS Center Fire Repairman: _____
 Verify Repair Caliber: 7.62 NATO Status: New 5/18/2007 7:25:46 AM

Address Information

Customer: _____ Received From: _____ Return To: _____ Received From: _____
 Name: FMC 25TH BSB (1-25TH SBCT) FMC 25TH BSB (1-25TH SBCT)
 Address 1: ATTN: CW3 A.J. AIYETORO ATTN: CW3 A.J. AIYETORO
 Address 2: 1060 GAFFNEY ROAD #9100 PO Box: _____ 1060 GAFFNEY ROAD #9100 PO Box: _____
 City: FORT WAINWRIGHT FORT WAINWRIGHT
 State: AK Zip Code: 99703 Country: US State: AK Zip Code: 99703 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 <table border="1"> <thead> <tr> <th>Code</th> <th>Desc</th> <th>Qty</th> </tr> </thead> <tbody> <tr> <td>A007</td> <td>With Stud</td> <td>3</td> </tr> <tr> <td>A010</td> <td>Hard Case</td> <td>1</td> </tr> <tr> <td>A017</td> <td>Scope Base</td> <td>1</td> </tr> <tr> <td>A026</td> <td>Scope</td> <td>1</td> </tr> <tr> <td>A057</td> <td>Fit and Rear Sgt Base</td> <td>1</td> </tr> </tbody> </table>			Code	Desc	Qty	A007	With Stud	3	A010	Hard Case	1	A017	Scope Base	1	A026	Scope	1	A057	Fit and Rear Sgt Base	1
Code	Desc	Qty																				
A007	With Stud	3																				
A010	Hard Case	1																				
A017	Scope Base	1																				
A026	Scope	1																				
A057	Fit and Rear Sgt Base	1																				

Repair Search Refresh Close

naglej 5/18/2007 8:00 AM CAPS NUM INS SCRL

start 3 M... 2 M... 5 L... Part ... Arms... Stoc... 8:00 AM

Serial Number: **C6348824**

Model: **M24 SWS**



RE00129489

MAINTENANCE REQUEST For use of this form, see DA PAM 738-750 and 738-751; the proponent agency is DCSLOG						PAGE NO. 1	NO OF PAGES 3	REQUIREMENT CONTROL SYMBOL CSGLD-1047(R1)																	
SECTION I - CUSTOMER DATA						SECTION II - MAINTENANCE ACTIVITY DATA																			
1a. UIC CUSTOMER WDPRB0		1b. CUSTOMER UNIT NAME FMC 25 TH BSB		1c. PHONE NO 907-353-1721		3a. WORK ORDER NUMBER (WON)			3b. SHOP		3c. PHONE NO														
2a. SAMS-2 UIC/SAMS-I/TDA			2b. UTILIZATION CODE		2c. MCSR		4a. UIC SUPPORT UNIT			4b. SUPPORT UNIT NAME															
SECTION III - EQUIPMENT DATA																									
5. TYPE MNT REQ CODE		6. ID A		7. NSN 1005-01-240-2136		15a. FAILURE DETECTED DURING/WHEN DISCOVERED CODE (Enter code) F - See Maintenance SOP																			
8. MODEL M24						15b. FIRST INDICATION OF TROUBLE/ HOW RECOGNIZED CODE (Enter Code) See DA Maintenance SOP						16. MILES/KILOMETERS/HOURS/ROUNDS													
9. NOUN SNIPER WEAPON SYSTEM												H			K										
10a. ORG WON/DOC NO DPRO3A700531												10b. EIC			R										
11 SERIAL NUMBER C6348824				12. QTY 01		13. PD 02		17. PROJECT CODE (if assigned)		18. ACCOUNT ROCESSING CODE		19. IN WARRANTY? (enter Y or N)		20. ADMIN NO											
14. MALFUNCTION DESCRIPTION (for DSU, GSU/AVIM, DEPOT use)						21. REIMBURSABLE CUSTOMER (if In transit customer enter Y or N)																			
						22. LEVEL OF WORK D				23. SIGNATURE															
24. DESCRIBE DEFICIENCIES OR SYMPTOMS ON THE BASIS OF COMPLETE CHECKOUT AND DIAGNOSTIC PROCEDURES IN EQUIPMENT TM (Do not prescribe repairs) FRONT SIGHT POST BENT																									
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 A5419			35a. ACCEPTED BY			35c. DATE			36a. WORK STARTED BY			37a. INSPECTION 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			

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6348824.___0
FILE DATE AND TIME: 07/09/2007 07:04

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:	-0.035
The Average Point of Impact of the Five Target Set:	0.046
The Average Mean Radius of the Five Target Set:	0.745
The Distance from POA to Centroid Target #1:	0.161
The Distance from Centroid Target #2 to Centroid Target #1:	0.184
The Distance from Centroid Target #3 to Centroid Target #1:	0.126
The Distance from Centroid Target #4 to Centroid Target #1:	0.216
The Distance from Centroid Target #5 to Centroid Target #1:	0.247

BARBER - M24 0039087

SERIAL NUMBER: C6348824. __0

TARGET NUMBER: 1

FILE DATE: 07/09/2007

FILE TIME: 07:04

POINT#	X	Y
1:	0.524	-0.881
2:	0.816	-0.507
3:	1.083	-0.238
4:	0.131	0.820
5:	-0.397	1.255
6:	-0.453	0.265
7:	-0.658	0.037
8:	-0.647	-0.482
9:	-0.864	-0.293
10:	-1.142	0.146

X CENTROID: -0.161

Y CENTROID: 0.012

POA TO CENTROID: 0.161

HORZ SPREAD: 2.225

VERT SPREAD: 2.136

GROUP SPREAD: 2.258

MIN RADIUS: 0.386

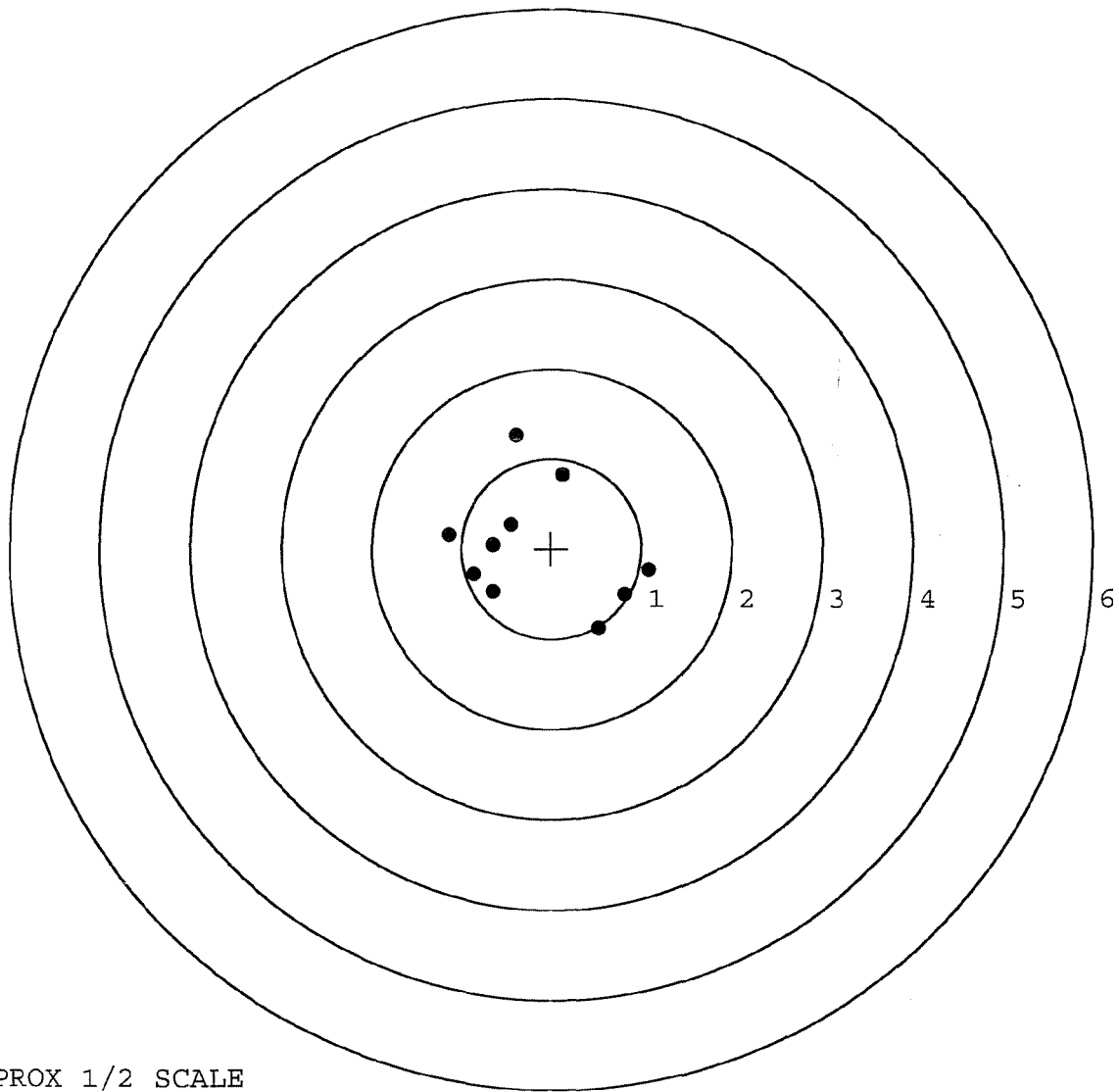
MAX RADIUS: 1.269

MEAN RADIUS: 0.896

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

BARBER - M24 0039088

SERIAL NUMBER: C6348824. 0

TARGET NUMBER: 2

FILE DATE: 07/09/2007

FILE TIME: 07:04

POINT#	X	Y
1:	0.012	-1.205
2:	-0.912	-0.447
3:	0.306	-0.530
4:	0.357	-0.250
5:	0.818	0.309
6:	0.535	0.660
7:	0.240	0.181
8:	0.153	0.333
9:	-0.299	0.510
10:	-1.000	0.866

X CENTROID: 0.021

Y CENTROID: 0.043

POA TO CENTROID: 0.048

HORZ SPREAD: 1.818

VERT SPREAD: 2.071

GROUP SPREAD: 2.305

MIN RADIUS: 0.259

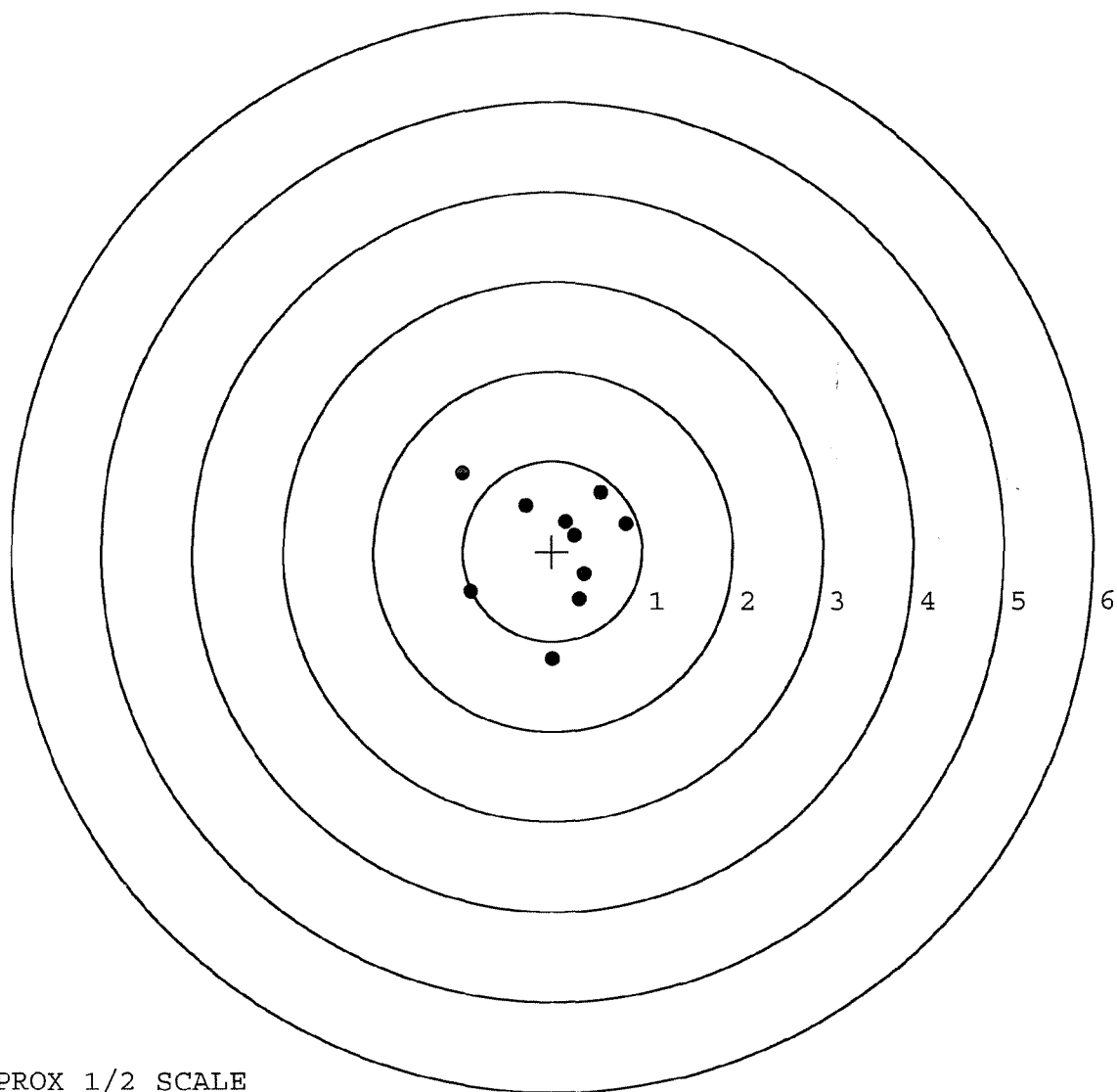
MAX RADIUS: 1.312

MEAN RADIUS: 0.749

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

BARBER - M24 0039089

SERIAL NUMBER: C6348824. 0

TARGET NUMBER: 3

FILE DATE: 07/09/2007

FILE TIME: 07:04

POINT#	X	Y
--------	---	---

1:	0.258	-1.136
----	-------	--------

2:	-0.145	-0.839
----	--------	--------

3:	0.290	-0.467
----	-------	--------

4:	-0.095	-0.270
----	--------	--------

5:	-0.153	0.089
----	--------	-------

6:	0.180	0.040
----	-------	-------

7:	0.070	0.316
----	-------	-------

8:	-0.106	0.675
----	--------	-------

9:	-0.740	0.098
----	--------	-------

10:	-0.826	0.398
-----	--------	-------

X CENTROID: -0.127

Y CENTROID: -0.110

POA TO CENTROID: 0.168

HORZ SPREAD: 1.116

VERT SPREAD: 1.811

GROUP SPREAD: 1.878

MIN RADIUS: 0.164

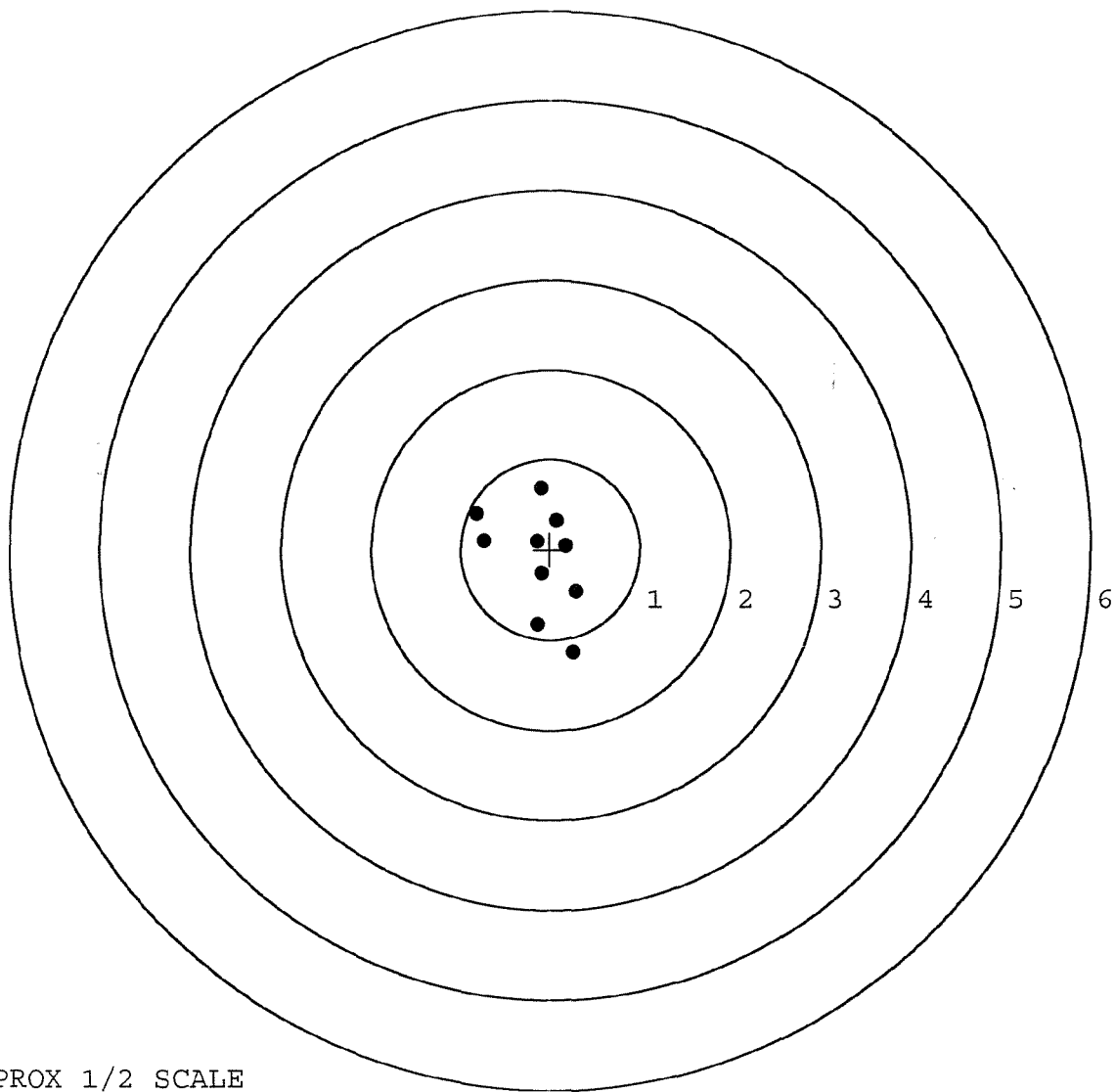
MAX RADIUS: 1.096

MEAN RADIUS: 0.585

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

BARBER - M24 0039090

SERIAL NUMBER: C6348824. __0

TARGET NUMBER: 4

FILE DATE: 07/09/2007

FILE TIME: 07:04

POINT#	X	Y
1:	-0.309	-0.657
2:	0.111	-0.505
3:	0.056	-0.022
4:	0.945	-0.457
5:	0.573	-0.180
6:	0.720	0.005
7:	0.639	0.302
8:	-0.558	0.681
9:	-0.561	0.373
10:	-1.107	0.144

X CENTROID: 0.051

Y CENTROID: -0.032

POA TO CENTROID: 0.060

HORZ SPREAD: 2.052

VERT SPREAD: 1.338

GROUP SPREAD: 2.138

MIN RADIUS: 0.011

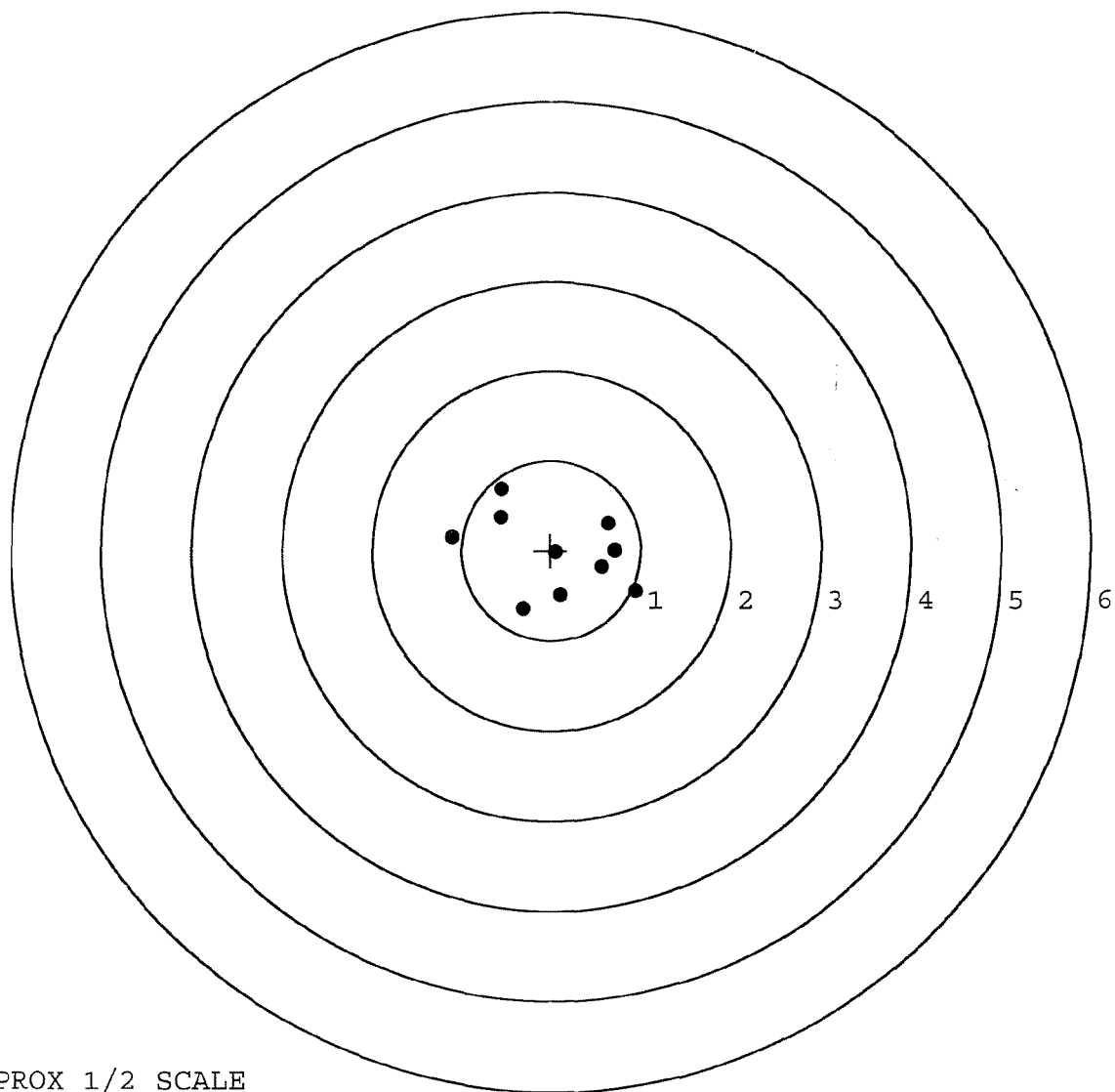
MAX RADIUS: 1.171

MEAN RADIUS: 0.693

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

BARBER - M24 0039091

SERIAL NUMBER: C6348824. __ 0

TARGET NUMBER: 5

FILE DATE: 07/09/2007

FILE TIME: 07:04

POINT#	X	Y
1:	1.247	-0.948
2:	-0.025	-0.955
3:	0.266	-0.571
4:	0.206	-0.249
5:	0.739	-0.195
6:	-0.633	-0.497
7:	-0.588	0.258
8:	-0.091	0.321
9:	-0.438	0.732
10:	-0.028	1.232

X CENTROID: 0.066

Y CENTROID: -0.087

POA TO CENTROID: 0.109

HORZ SPREAD: 1.880

VERT SPREAD: 2.187

GROUP SPREAD: 2.525

MIN RADIUS: 0.214

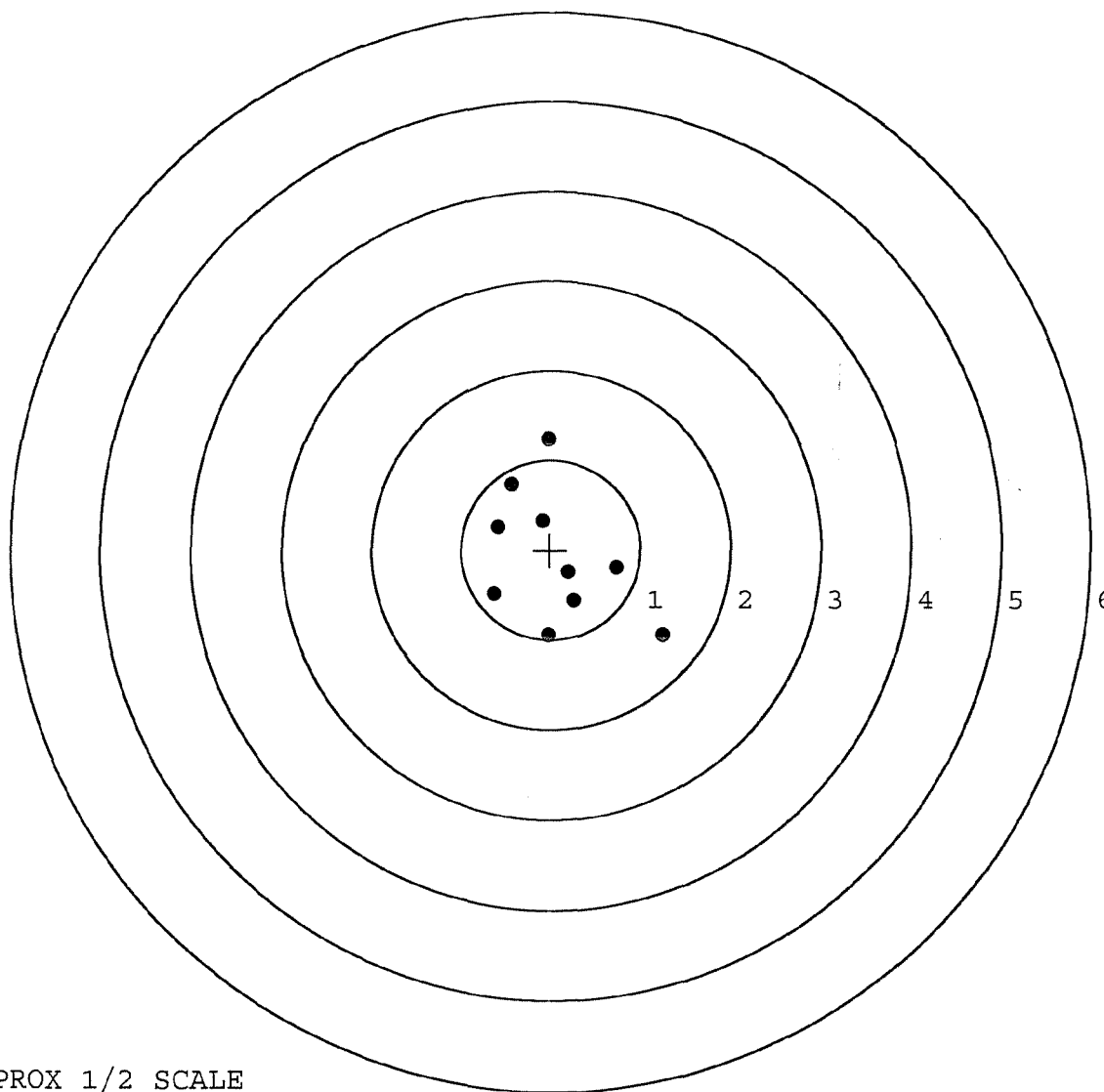
MAX RADIUS: 1.462

MEAN RADIUS: 0.802

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

R & E NUMBER	129489			
SERIAL NUMBER	C6348824			
LOG-IN DATE	5-18-07			
OPERATION #	OPERATION NAME		DATE	INITIAL
500	DIS-ASSEMBLE GUN		6-12-07	RTZ
505	RE-BARREL		6-15-07	RTZ
560	ASSEMBLE		6-18-07	RTZ
600	PROOF		6-18-07	TRW
605	CHECK HEADSPACE		6-18-07	TRW
610	DIS-ASSEMBLE GUN		6-18-07	RTZ
612	MAGNAFLUX	OPERATOR Wms	6-19-07	Wms
510	DRILL AND TAP		6-18-07	SD
615	ROLLMARK CALIBER		6-19-07	CW
618	ROTO-BLAST		6-19-07	DG
620	APPLY COATINGS		6-21-07	TRW
625	FINAL ASSEMBLY		7-5-07	R.P.D.
640	FUNCTION TEST AND	PASS FAIL	7-6-07	TRW
650	TARGET	PASS FAIL	7-6-07	TRW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION	7-6-07	MAD
670	FINAL INSPECTION		7-10-07	DA
	A) HEADSPACE	PASS FAIL	7-10-07	DA
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	2.76 2.77 2.85 2.84 2.88 7.9.07	DA
680	F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX	4.5 4.5 4.5 7.9.07	DA
	G) SAFETY OFF FORCE	2 LBS MIN	2.2 2.5 2.5 7.9.07	DA
	I) FIRING PIN INDENT	.020	1.022 1.022 .023 7.9.07	DA
690	PACK		7-11-07	DA

BARBER - M24 0039093 RECEIVING AND ESTIMATING REPORT

COMMENTS

ORDER
R 96-02005

INITIAL JLM CUSTOMER ORDER NO.

W/LEUPOLD SCOPE W/BI-POD
W/DEPLOYMENT KIT

DATE RECEIVED 01/16/96	DATE OPENED 01/17/96	DATE CODE	SERIAL NUMBER C6348024	NEW SERIAL NUMBER	MODEL AND GRADE 700 7.62	NATO
ACCESSORIES HARD CASE SCOPE MNTS SCOPE BASE						

FROM:

SHIP TO:

US ARMY
HHC 4/9 INF
FT WAINWRIGHT

AK 99703

US ARMY
HHC 4/9 INF
FT WAINWRIGHT

AK
99703

CUST NO: 135896 C.O.D.

ACCOUNT NUMBER	ACCOUNT NUMBER N/C	WRITE ☐	PROM. DATE	ESTIMATED	VIA UPS
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
✓ Barrel - 96003	
✓ Stock - 96018	
✓ Mag Spring - 15677	
✓ Scope Dust Cover front & Rear - 96043 + 96044	
✓ Bipod - 96117	Re powder Coat - Trigger Guard
✓ Soft Carrying Case - 96076	ASSY Front + Rear Sight Bases
	Re line Scope Base, Rings & Swivel Studs
REPAIRMAN Rw	PROOF ✓
GALLERY TESTER Rw	CLEAN ✓
	TEST Ac
	TARGET Ac
	PATTERN
	DATE 1/23/96
	DATE 2/1/96
	DATE 2/1/96
	DATE 2/1/96

OFFICE COPY

RD5925 REV. 1/94

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

BARBER - M24 0039093 39132

PAGE NO.

REPLACES EDITION OF 1 APR 63, WHICH MAY BE USED.

BARBER - M24 0039094

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER

BARBER - M24 063989439133

Public reporting burden for this collection of information is estimated to average 2 minutes per response, including the time for reviewing instructions, searching existing data sources, gathering and maintaining the data needed, and completing and reviewing the collection of information. Send comments regarding this burden estimate or any other aspect of this collection of information, including suggestions for reducing this burden, to Department of Defense, Washington Headquarters Services, Directorate for Information Operations and Reports, 1215 Jefferson Davis Highway, Suite 1204, Arlington, VA 22202-4302, and to the Office of Management and Budget, Paperwork Reduction Project (0702-0027), Washington, DC 20503. Please DO NOT RETURN your form to either of these addresses.

SECTION A - To be completed by the SHIPPER.

[illegible]

16. CUSTODY RECORD (Continued)

[illegible]

BARBER - M24 M3409939136

1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41	42	43	44	45	46	47	48	49	50	51	52	53	54	55	56	57	58	59	60	61	62	63	64	65	66	67	68	69	70	71	72	73	74	75	76	77	78	79	80
DOC. IDENT.		RI FROM		M A S	STOCK NUMBER										UNIT OF ISSUE		QUANTITY		DOCUMENT NUMBER										SUPPLEMENTARY ADDRESS		FUND SIGNAL	DISTRIBUTION	PROJECT	PRI ORITY	REQ'D DEL DATE	ADVICE	RI	UNIT PRICE																																									
					FSC NIIN ADD												SERV		REQUISITIONER DATE SERIAL										SERV										DOLLARS CTS																																								
A0A					1005 012402136										RANNN3		1071		53125401																						51450																																						
SHIPPED FROM HHC 419 TNE FT WALKER AR 77703															SHIP TO KEARINGTON HAMS CO 14 HURLOCK AVE ILLINOIS NY 1337-1216															MARK FOR PROJECT ATTN: RITA BROWN 304 782-5711										TOTAL PRICE DOLLARS CTS																																							
WAREHOUSE LOCATION															TYPE OF CARGO		UNIT PACK		UNIT WEIGHT		UNIT CUBE		U F C		NMFC		FREIGHT RATE		DOCUMENT DATE		MAT COND		QUANTITY																																														
F															G		H		I		J		K		L		M		N		O		P		Q		S																																										
SUBSTITUTE DATA (ITEM ORIGINALLY REQUESTED)															FREIGHT CLASSIFICATION NOMENCLATURE																																																																
T															U															V SN 10341111																																																	
W LINE# R95387															X RIFLE 7.62MM SNIPER M24/W COMPONENTS																																																																
→ SELECTED BY AND DATE					TYPE OF CONTAINER(S)					TOTAL WEIGHT					→ RECEIVED BY AND DATE					INSPECTED BY AND DATE																																																											
SHIPPERS PACKED BY AND DATE					CS					180					RECEIVERS 5345					38																																																											
4					2 NO. OF CONTAINERS					3 TOTAL CUBE					7 WAREHOUSED BY AND DATE					8 WAREHOUSE LOCATION																																																											
					3					18					50 X 16 X 12					WT. CU																																																											
					5					6					9					10																																																											
REMARKS: Repair + Return to HHC 419 INF / SST STOUTS / ER MC 907-353-2458/273																																																																															
AA FIRST DESTINATION ADDRESS															BB DATE SHIPPED															DD SIGNATURE SERVICE REC'D															EE																																		
11 DAA09-92-C-0834															12															FF															GG																																		
13 TRANSPORTATION CHARGEABLE TO															14 B/LADING, AWB, OR RECEIVER'S SIGNATURE (AND DATE)															15 RECEIVER'S DOCUMENT NUMBER																																																	
DD FORM 1348-1 (6 PT) 1 MAR 74															EDITION OF 1 JAN 64 MAY BE USED UNTIL EXHAUSTED															DOD SINGLE LINE ITEM RELEASE/RECEIPT DOCUMENT																																																	

CONTRACT # DAAA21-87-C-0086

New Barrel
Stock

GUN SERIAL # C6348824

OP. #	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and Stock		1/22/96	RW
600	Proof		1/22/96	RW
607	Check Headspace		1/22/96	RW
610	Dis-assemble Gun		1/22/96	RW
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		1/31/96	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		1/31/96	RW
	C) Inspect Ejector Hole for Chamfer		1/31/96	RW
	D) Oil Firing Pin Ass'y		1/31/96	RW
	E) Adjust Trigger Pull to Min Setting and Stake			

op. #	BARBER - M24 0039099 OP. NAME	READINGS	DATE	INIT
625 cont.	F) Safety On Force			
	G) Safety Off Force			
	H) Trigger Pull Test & Retainability			
	I) Firing Pin Indent			
	J) Assemble Stock		1/31/96	RW
	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		2/1/96	AO
	A) Time			
	B) Malfunctions			
	C) Pierced Primers			
	D) Optical Clarity of Scope			
645	Inspect for Live Ammo		2/1/96	AO
655	Final Inspection			
	A) Headspace		2/2/96	RW
	B) Trigger Pull			
	C) Function		2/2/96	RW
660	Pack			

Final Inspection

S.N: C6348824

DATE REC'D: 1/17/96

DATE RET'D:

AUDITOR: *AW*

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 # C6348824
3 Jan 1988

CENTROIDAL DISTANCES

0 TO 1	1.53277
1 TO 2	.3972
1 TO 3	.272413
1 TO 4	.329317
1 TO 5	.354006

21

+ <----POA

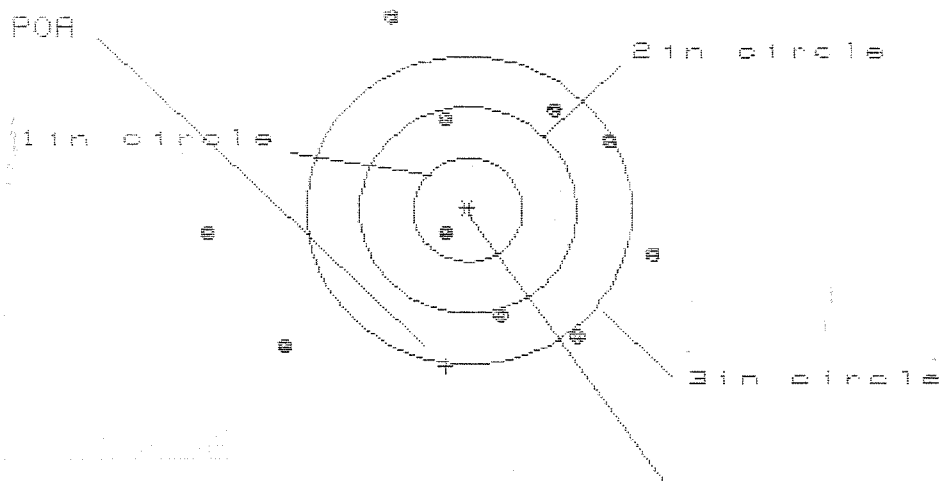
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.008
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: 1.385
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: 1.38502

THE AMR FOR THIS RIFLE IS: 1.214

2 Jan 1988

FILE:/PATTERNING/CENTERFIRE_PATT/0634B024

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

CENTROID *

IN CIR

1in = 1

2in = 2

3in = 5

HS= 4.108

VS= 3.173

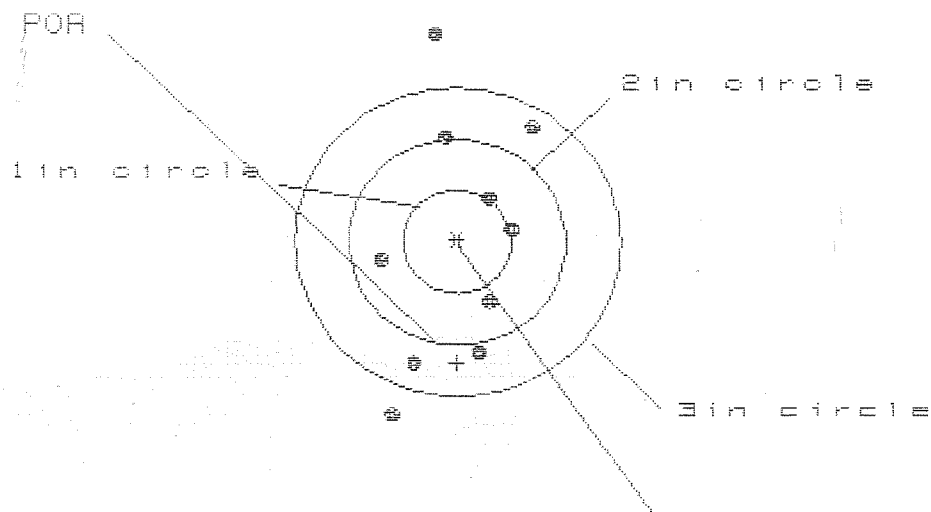
GS= 4.116

PATTERN #	1	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.721	1.456	1.213
MINIMUM X	-2.387	-1.943	-1.186
MAXIMUM Y	1.885	1.865	1.702
MINIMUM Y	-1.208	-1.308	-1.405
CENTROID X	.205	.470	.713
CENTROID Y	1.519	1.539	1.702
POA TO CENTROID in.	1.532	1.609	1.846
MIN RADIUS	.287	.502	.794
MEAN RADIUS	1.487	1.364	1.220
MAX RADIUS	2.394	2.343	2.074
HORIZONTAL SPREAD	4.108	3.399	2.399
VERTICAL SPREAD	3.173	3.173	3.107
EXTREME SPREAD	4.116	3.586	3.536
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	2		
NUMBER IN THREE INCH CIRCLE =	5		

2 Jan 1988

FILE:/PATTERNING/CENTERFIRE_PATT/06348824

CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1in = 1

2in = 5

3in = 8

HS = 1.362

VS = 3.668

GS = 3.687

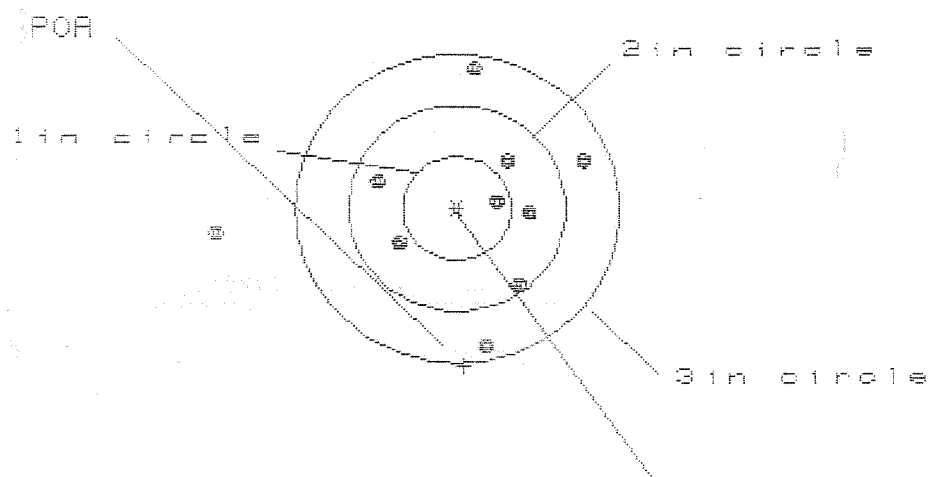
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.674	.653	.581
MINIMUM X	:	-.688	-.709	-.781
MAXIMUM Y	:	1.995	1.358	1.176
MINIMUM Y	:	-1.673	-1.451	-1.131
CENTROID X	:	.003	.024	.096
CENTROID Y	:	1.177	.955	1.137
FOR TO CENTROID in.	:	1.177	.956	1.141
MIN RADIUS	:	.473	.388	.451
MEAN RADIUS	:	1.068	.945	.852
MAX RADIUS	:	2.004	1.561	1.312
HORIZONTAL SPREAD	:	1.362	1.362	1.362
VERTICAL SPREAD	:	3.668	2.809	2.307
EXTREME SPREAD	:	3.687	3.066	2.543
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

2 Jan 1900

FILE:/PATTERNING/CENTERFIRE_PATT/C634B024

CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 6

3 in = 3

HS = 3.415

VS = 2.728

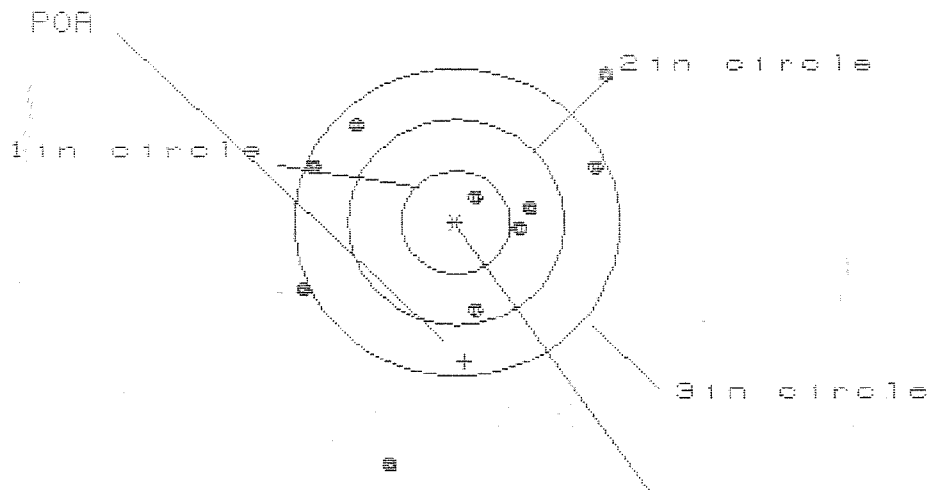
GS = 3.494

PATTERN #	3	3	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.134	.881	.883
MINIMUM X	-2.281	-1.022	-1.019
MAXIMUM Y	1.361	1.335	1.161
MINIMUM Y	-1.367	-1.393	-.929
CENTROID X	-.067	.186	.183
CENTROID Y	1.534	1.560	1.734
POA TO CENTROID in.	1.536	1.571	1.743
MIN RADIUS	.328	.075	.170
MEAN RADIUS	1.031	.827	.753
MAX RADIUS	2.292	1.393	1.167
HORIZONTAL SPREAD	3.415	1.903	1.903
VERTICAL SPREAD	2.728	2.728	2.090
EXTREME SPREAD	3.494	2.732	2.134
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	9		

2 Jan 1968

FILE:/PATTERNING/CENTERFIRE_PATT/08345824

CENTERFIRE PATTERNS # 4



+ OF SHOTS- 10

CENTROID +

IN CIR

1 in = 1

2 in = 4

3 in = 7

HS= 2.780

VS= 3.743

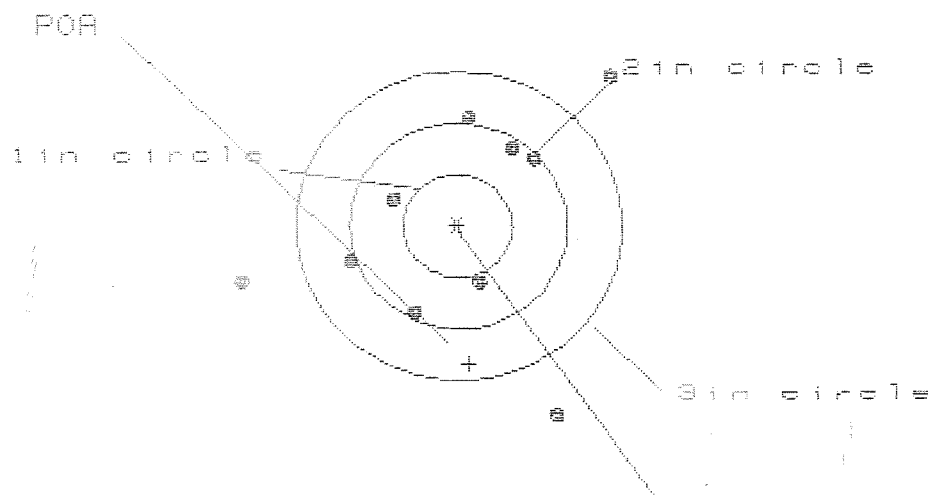
GS= 4.207

PATTERN #	4	4	4
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.349	1.286	1.357
MINIMUM X	-1.431	-1.494	-1.333
MAXIMUM Y	1.409	1.149	.782
MINIMUM Y	-2.334	-1.141	-.997
CENTROID X	-.088	-.017	-.178
CENTROID Y	1.354	1.614	1.470
POA TO CENTROID in.	1.357	1.614	1.481
MIN RADIUS	.330	.131	.329
MEAN RADIUS	1.253	1.088	1.030
MAX RADIUS	2.403	1.742	1.531
HORIZONTAL SPREAD	2.780	2.780	2.690
VERTICAL SPREAD	3.743	2.290	1.779
EXTREME SPREAD	4.207	3.452	2.951
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	7		

2 Jan 1968

FILE:/PATTERNING/CENTERFIRE_PATT/08348824

CENTERFIRE PATTERNS # 5



OF SHOTS = 10

CENTROID #

IN CIR

1 in = 0

2 in = 5

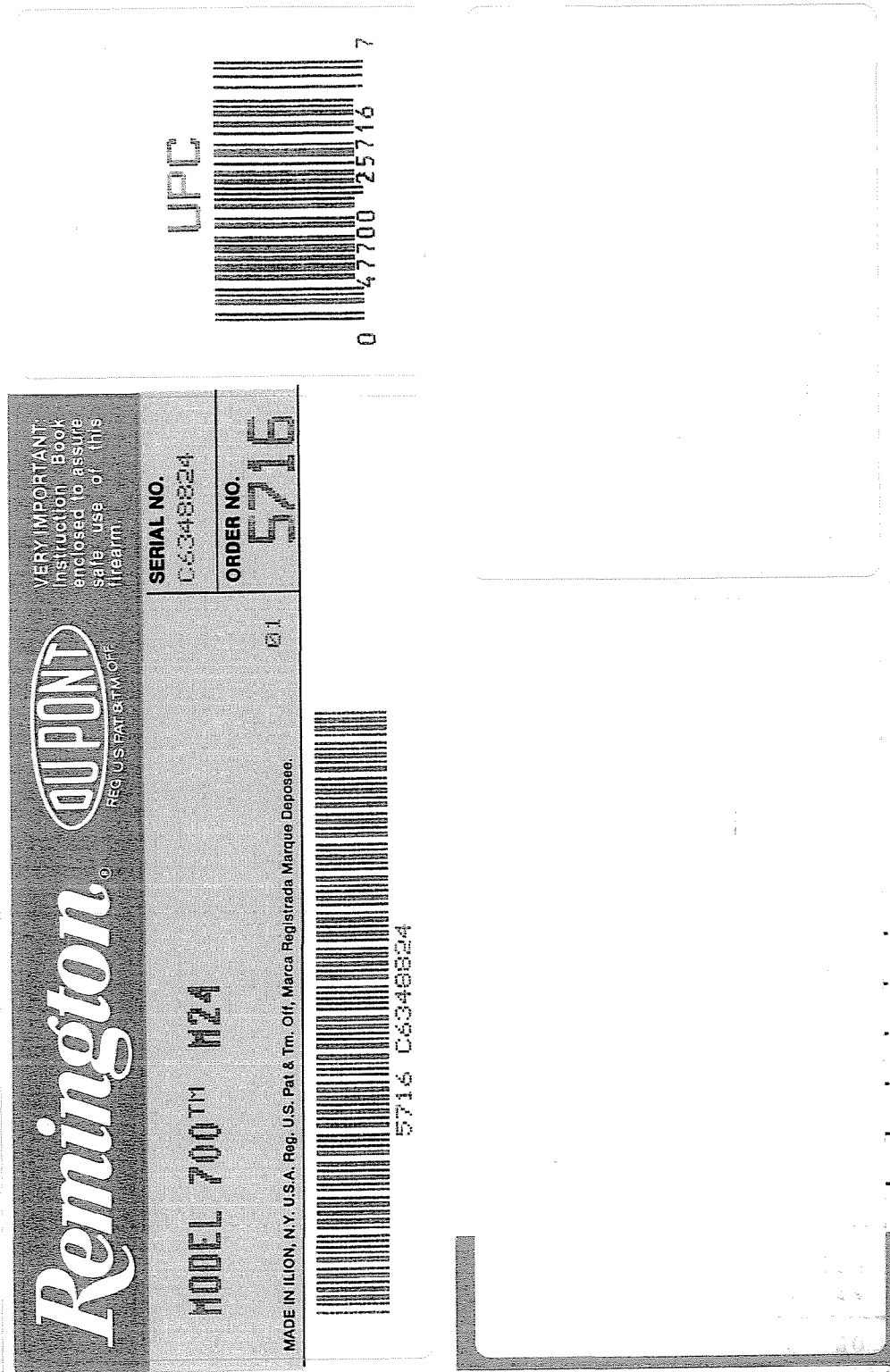
3 in = 7

HS = 3.404

VS = 3.315

QS = 3.967

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	1.445
MINIMUM X	-1.959
MAXIMUM Y	1.470
MINIMUM Y	-1.845
CENTROID X	-1.101
CENTROID Y	1.341
POA TO CENTROID in.	1.345
MIN RADIUS	.562
MEAN RADIUS	1.230
MAX RADIUS	2.070
HORIZONTAL SPREAD	3.404
VERTICAL SPREAD	3.315
EXTREME SPREAD	3.967
NUMBER IN ONE INCH CIRCLE =	0
NUMBER IN TWO INCH CIRCLE =	5
NUMBER IN THREE INCH CIRCLE =	7



CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

CG348824

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	9 14	89	RW
600	Proof	9 14	89	RW
607	Check Headspace	9 14	89	RW
610	Dis-assemble Gun	9 14	89	RW
612	Magnaflux Barrel Action	9-14-89		KCR
	Magnaflux Bolt	9-14-89		KCR
615	Rollmark Caliber		9-15-89	G.S.
7	Drill and Tap Sight Holes	9 15	89	FB
618	Polish Barrel	9 15	89	BT
620	Apply Coatings (Barrel Action)		9-25-89	TJA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		9/26/89	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		9/26/89	RW
	C) Inspect Ejector Hole for Chamfer		9/26/89	RW
	D) Oil Firing Pin Ass'y		9/26/89	RW
	E) Adjust Trigger Pull to Min Setting and Stake		1/6/89	JS

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			10/16/89	92/
	G) Safety Off Force	3	3	3			10/16/89	92/
	H) Trigger Pull Test & Retainability						10/16/89	92/
	I) Firing Pin Indent	.021	.021	.0225			10/14/89	92/
	J) Assemble Stock						10/17/89	92/
	K) Assemble Swivel Studs						10/17/89	92/
	L) Attach Front and Rear Sight Assemblies						12/11/89	RW
	M) Iron Sight Alignment						12/11/89	RW
	N) Detach Front & Rear Sights & place in numbered container						12/11/89	RW
	O) Attach Scope to Rifle						10/17/89	92/
	P) Detach & Attach Scope 20 Times						10/17/89	92/
640	Gallery Target & Test						10-18-89	DH
	A) Time						10-18-89	DH
	B) Malfunctions						10-18-89	DH
	C) Pierced Primers						10-18-89	DH
	D) Optical Clarity of Scope						10-18-89	DH
645	Inspect for Live Ammo						10-18-89	DH
655	Final Inspection							
	A) Headspace						250/89	92/
	B) Trigger Pull	237	247	251	250	253	250/89	92/
	C) Function						250/89	92/
660	Pack						15 Dec 89	92/

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#
3.00# ± .75#
4.00# ± 1.00#

SERIAL NO. C6348854

DATE 13 MAR 1980

TESTER J28

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	235	245		257	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	250	250		254	
PULL #3	245	251		257	
PULL #4	249	250		258	
PULL #5	251	254		258	
TOTAL	1230	1250			
AVG.	246	250			

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	328	337		
PULL #2	334	324		
PULL #3	320	333		
PULL #4	337	329		
PULL #5	335	336		
TOTAL	1654	1659		
AVG.	3308	3318		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	443	448		
PULL #2	450	449		
PULL #3	439	453		
PULL #4	446	442		
PULL #5	414	416		
TOTAL	2192	2202		
AVG.	4384	4404		

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6348824
18 Oct 1989

CENTROIDAL DISTANCES

0 TO	1	.452435
1 TO	2	.497926
1 TO	3	.706416
1 TO	4	.797527
1 TO	5	.829759

1.25 (----POA

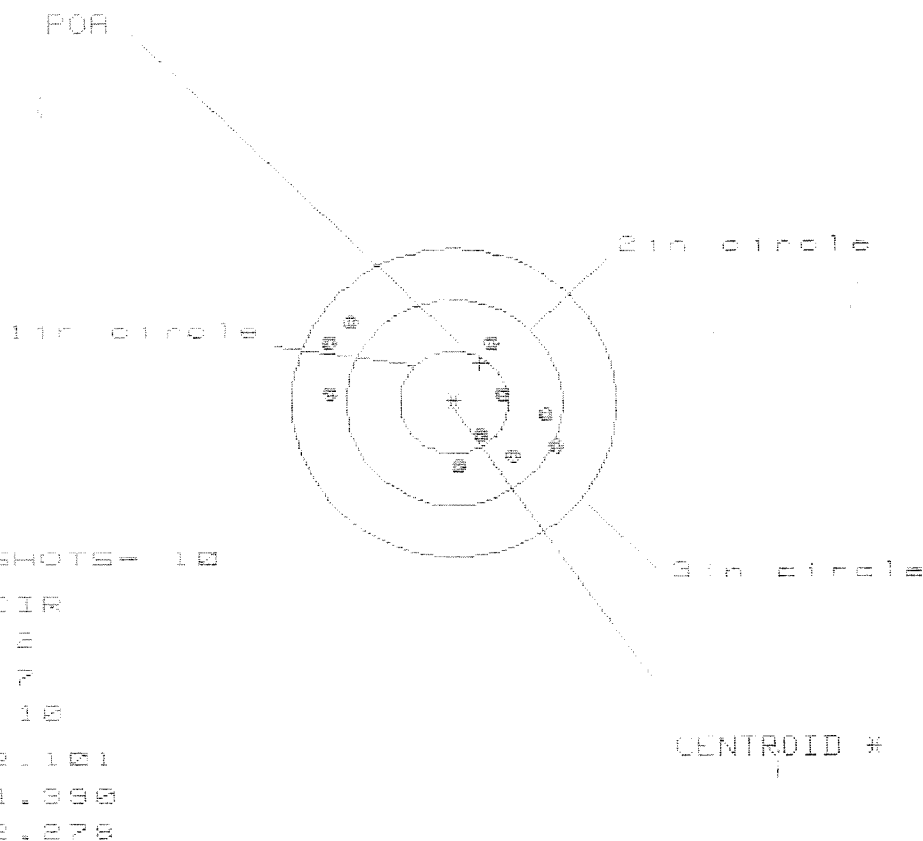
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .2854
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.219
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .359742
THE AMR FOR THIS RIFLE IS: .9772

18 Oct 1989

FILE:/PATTERNING/CENTERFIRE_PATT/06948824

CENTERFIRE PATTERNS

1



PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.911	.783	.618
MINIMUM X	-1.190	-1.318	-1.200
MAXIMUM Y	.736	.796	.817
MINIMUM Y	-.654	-.594	-.573
CENTROID X	-.244	-.116	.049
CENTROID Y	-.381	-.441	-.462
POR TO CENTROID in.	.452	.456	.464
MIN RADIUS	.394	.289	.177
MEAN RADIUS	.839	.745	.620
MAX RADIUS	1.279	1.329	1.458
HORIZONTAL SPREAD	2.101	2.101	1.826
VERTICAL SPREAD	1.390	1.390	1.390
EXTREME SPREAD	2.278	2.164	2.155
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		10	

18 Oct 1989

FILE:/PATTERNING/CENTERFIRE_PATT/06040824

CENTERFIRE PATTERNS

2

POF

1in circle

2in circle

3in circle

OF SHOTS= 10

IN CIR

1in = 1

2in = 7

3in = 9

HS= 2.291

VS= 1.863

GS= 2.446

CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.977	.831	.578
MINIMUM X	-1.314	-.564	-.460
MAXIMUM Y	.996	1.098	1.190
MINIMUM Y	-.867	-.765	-.628
CENTROID X	.239	.385	.281
CENTROID Y	-.260	-.362	-.499
POA TO CENTROID in.	.353	.528	.572
MIN RADIUS	.342	.283	.113
MEAN RADIUS	.932	.832	.700
MAX RADIUS	1.602	1.377	1.249
HORIZONTAL SPREAD	2.291	1.395	1.038
VERTICAL SPREAD	1.863	1.863	1.818
EXTREME SPREAD	2.446	2.181	1.869
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		9	

18 Oct 1989

FILE:/PATTERNING/CENTERFIRE_PATT/06346824

CENTERFIRE PATTERNS # 3

POR

1 in circle

2 in circle

3 in circle

OF SHOTS= 10

IN CIR

1 in = 1

2 in = 4

3 in = 8

HS= 2.177

VS= 3.063

GS= 3.074

CENTROID #

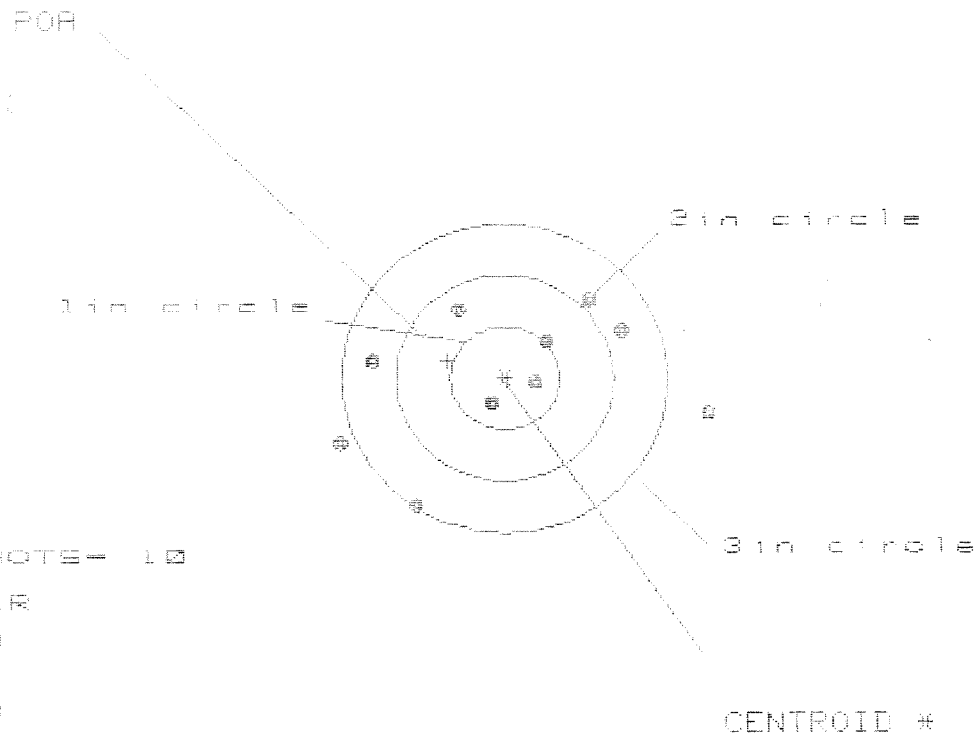
PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	1.266
MINIMUM X	-1.909
MAXIMUM Y	1.537
MINIMUM Y	-1.526
CENTROID X	.324
CENTROID Y	.039
POR TO CENTROID in.	.326
MIN RADIUS	.220
MEAN RADIUS	1.018
MAX RADIUS	1.548
HORIZONTAL SPREAD	2.177
VERTICAL SPREAD	3.063
EXTREME SPREAD	3.074
NUMBER IN ONE INCH CIRCLE =	1
NUMBER IN TWO INCH CIRCLE =	4
NUMBER IN THREE INCH CIRCLE =	8

18 Oct 1985

FILE:/PATTERNING/CENTERFIRE_PATT/08340824

CENTERFIRE PATTERNS

4



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 4

3 in = 8

HS= 3.364

VS= 1.967

GS= 3.371

CENTROID #

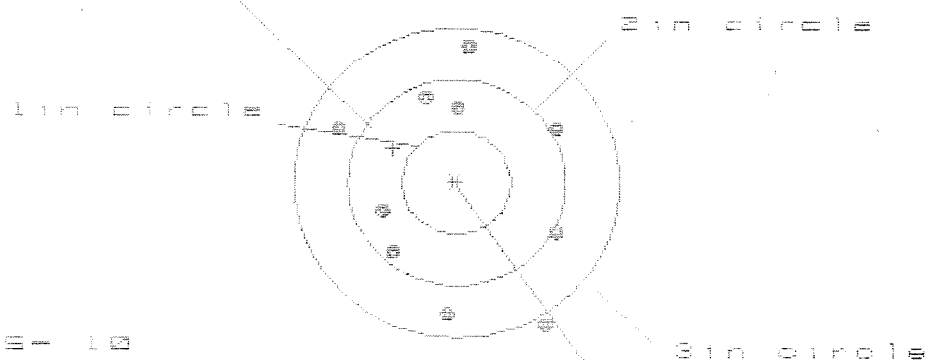
PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.835	1.231	1.065
MINIMUM X	-1.529	-1.325	-1.235
MAXIMUM Y	.766	.724	.645
MINIMUM Y	-1.201	-1.243	-1.322
CENTROID X	.524	.320	.486
CENTROID Y	-.166	-.124	-.045
POR TO CENTROID in.	.550	.343	.438
MIN RADIUS	.237	.288	.297
MEAN RADIUS	1.022	.940	.836
MAX RADIUS	1.873	1.468	1.550
HORIZONTAL SPREAD	3.364	2.556	2.300
VERTICAL SPREAD	1.967	1.967	1.967
EXTREME SPREAD	3.371	2.769	2.527
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		4	
NUMBER IN THREE INCH CIRCLE =		8	

18 Oct 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C6834B824

CENTERFIRE PATTERNS # 5

FOR



OF SHOTS- 10

IN CIR

1 in = 0

2 in = 4

3 in = 9

HS = 2.058

VS = 2.663

GS = 2.740

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.930	1.017	1.044
MINIMUM X	:	-1.128	-1.041	-1.014
MAXIMUM Y	:	1.318	1.169	.839
MINIMUM Y	:	-1.345	-1.386	-1.240
CENTROID X	:	.584	.497	.470
CENTROID Y	:	-.327	-.178	-.324
FOR TO CENTROID in.	:	.669	.528	.571
MIN RADIUS	:	.742	.615	.600
MEAN RADIUS	:	1.075	.998	.972
MAX RADIUS	:	1.553	1.387	1.242
HORIZONTAL SPREAD	:	2.058	2.058	2.058
VERTICAL SPREAD	:	2.663	2.555	2.079
EXTREME SPREAD	:	2.740	2.561	2.262
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		9	