

06348899

MODEL 700™ M24

Model **SMS**™

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: **RE00112535** Serial: C6348999 Model M24 SWS Center Fire
 Verify Repair ☐ Caliber: 7.62 NATO Produced: 03/19/1990 Repairman:
 Status: Closed 5/18/2006 9:46:30 AM

Address Information

Customer: ☐ Received From ☒ Return To: ☐ Received From ☐

Name: **225TH BSB (SSA)** **225TH BSB (SSA)**

Address 1: **ATTN CW3 FUJIHARA (808-655-0211)** **ATTN CW3 FUJIHARA (808-655-0211)**

Address 2: **BLDG 1670 MELICHAMP ST.** **BLDG 1670 MELICHAMP ST.** P.O. Box:
 City: **SCHOFELD BARRACKS** **SCHOFIELD BARRACKS**

State: **HI** Zip Code: **96857** Country: **US** State: **HI** Zip Code: **96857** Country: **US**

FFL: ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐

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

Contact Information

Phone: **NA**

Fax:
 Email:
 Comments:
Received Condition

Fair

Condition Notes:
 CSR Notes:
Accessories Received

Code	Desc	Qty
A010	Hard Case	1
C000	FRONT BASE	1

Repair Search **Refresh** **Close**

maglet 5/23/2006 7:21 AM CAPS NUM LINS SCRL

start 2 Micr... Microsoft... 2 Inter... Part Sea... Arms Se... 7:21 AM

Serial Number: **C6348999**

Model: **M24 SWS**



RE00112535

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C634899.___0
FILE DATE AND TIME: 11/13/2006 21:23

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.194
The Average Y Centroid of the Five Target Set:	-0.289
The Average Point of Impact of the Five Target Set:	0.348
The Average Mean Radius of the Five Target Set:	0.620
The Distance from POA to Centroid Target #1:	0.294
The Distance from Centroid Target #2 to Centroid Target #1:	1.316
The Distance from Centroid Target #3 to Centroid Target #1:	0.316
The Distance from Centroid Target #4 to Centroid Target #1:	0.106
The Distance from Centroid Target #5 to Centroid Target #1:	0.485

SERIAL NUMBER: C634899. __0

TARGET NUMBER: 1

FILE DATE: 11/13/2006

FILE TIME: 21:23

X CENTROID: 0.004

Y CENTROID: -0.294

POA TO CENTROID: 0.294

HORZ SPREAD: 0.829

VERT SPREAD: 1.053

GROUP SPREAD: 1.190

MIN RADIUS: 0.276

MAX RADIUS: 0.654

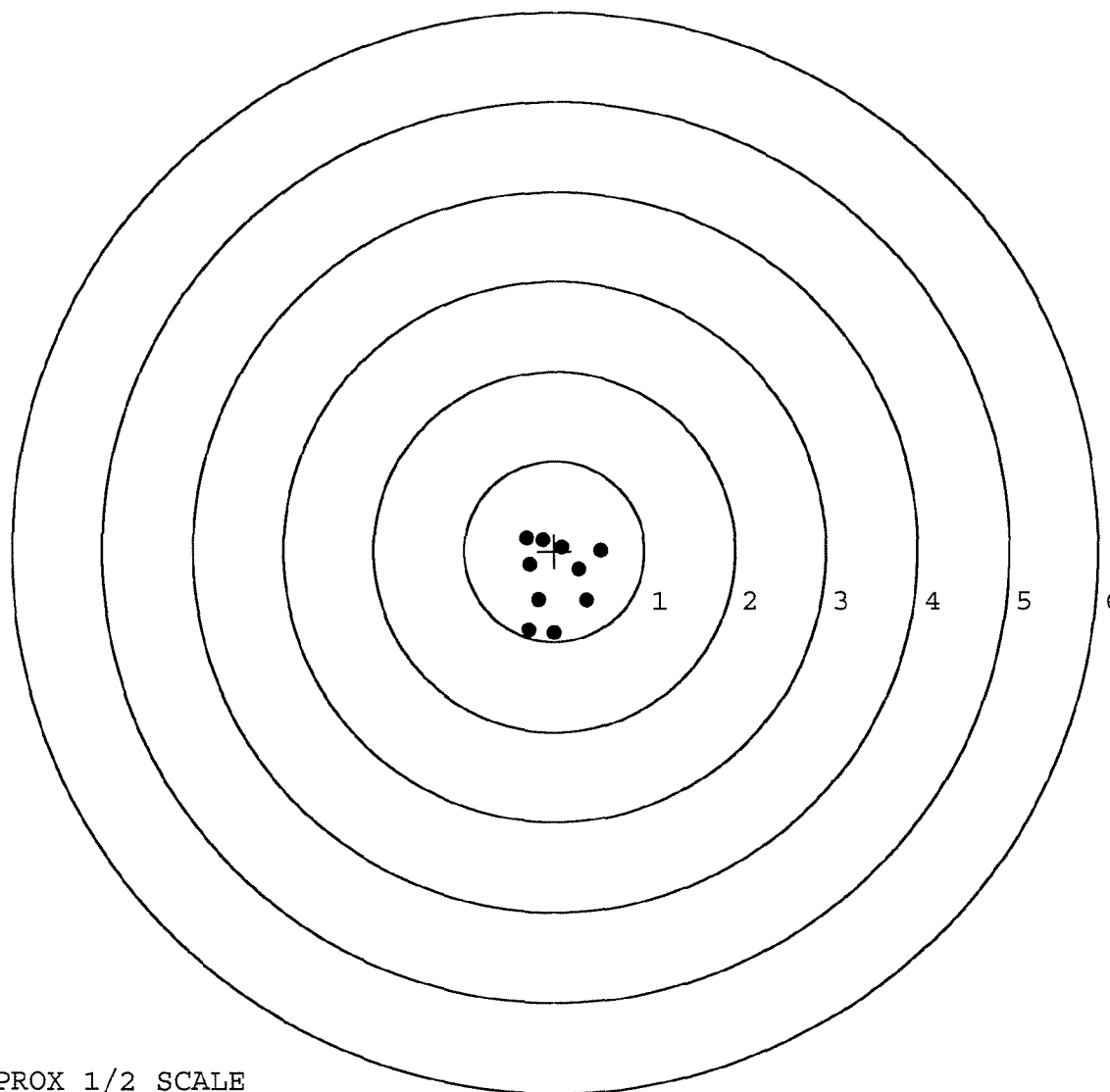
MEAN RADIUS: 0.452

IN 1 IN DIAMETER: 6

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.313	0.141
2:	-0.278	-0.157
3:	-0.128	0.123
4:	0.081	0.046
5:	0.267	-0.209
6:	0.357	-0.547
7:	0.516	0.000
8:	-0.183	-0.543
9:	0.006	-0.912
10:	-0.285	-0.880



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C634899. 0

TARGET NUMBER: 2

FILE DATE: 11/13/2006

FILE TIME: 21:23

X CENTROID: -1.048

Y CENTROID: -1.086

POA TO CENTROID: 1.509

HORZ SPREAD: 1.638

VERT SPREAD: 2.028

GROUP SPREAD: 1.897

MIN RADIUS: 0.394

MAX RADIUS: 1.004

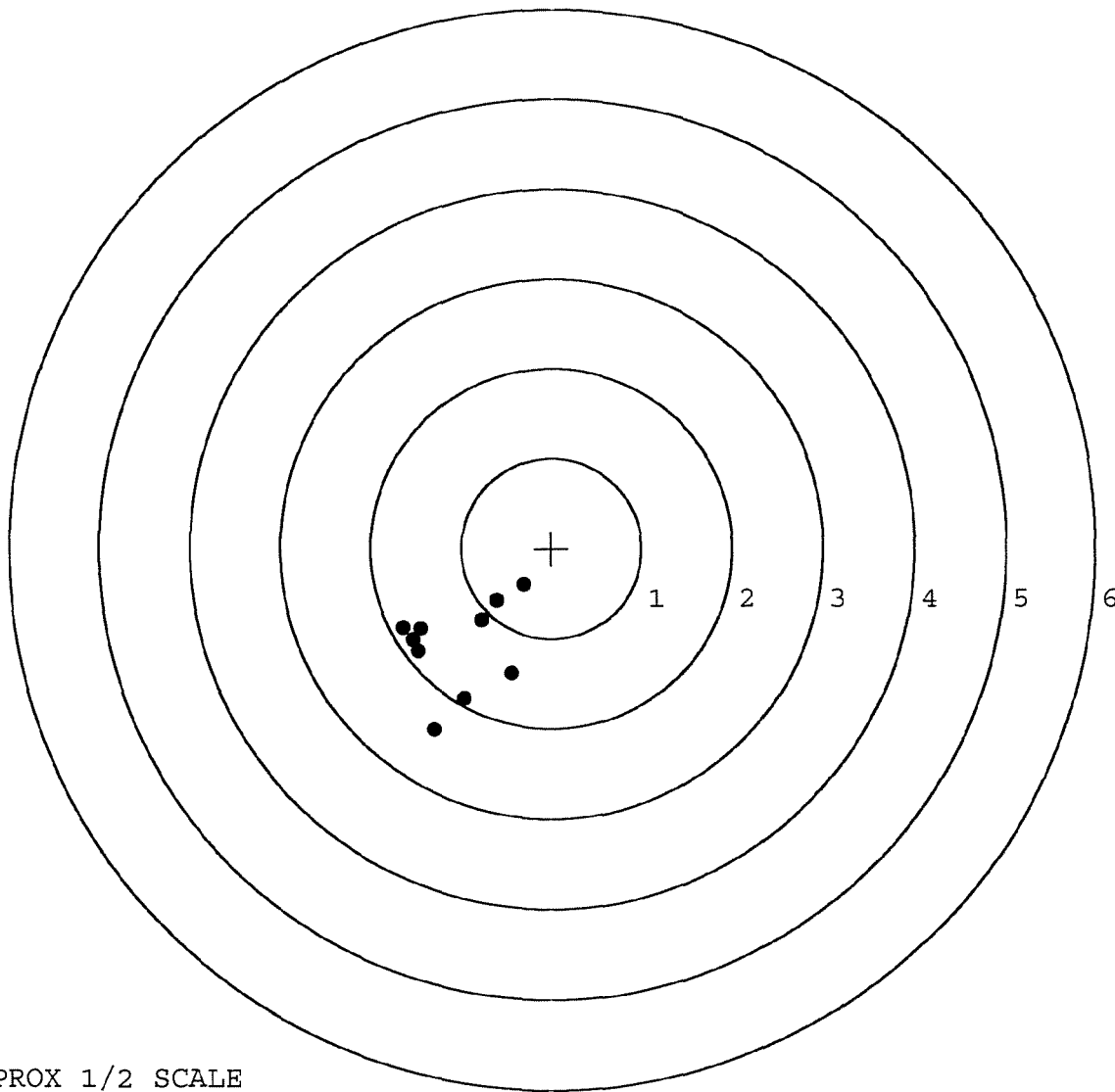
MEAN RADIUS: 0.628

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.313	-0.401
2:	-0.612	-0.584
3:	-1.441	-0.905
4:	-1.638	-0.893
5:	-1.531	-1.021
6:	-1.472	-1.147
7:	-1.288	-2.028
8:	-0.964	-1.679
9:	-0.444	-1.396
10:	-0.772	-0.804



TARGET APPROX 1/2 SCALE

BARBER - M24 0041070

SERIAL NUMBER: C634899. __0

TARGET NUMBER: 3

FILE DATE: 11/13/2006

FILE TIME: 21:23

X CENTROID: -0.031

Y CENTROID: 0.020

POA TO CENTROID: 0.037

HORZ SPREAD: 1.821

VERT SPREAD: 1.663

GROUP SPREAD: 2.126

MIN RADIUS: 0.167

MAX RADIUS: 1.290

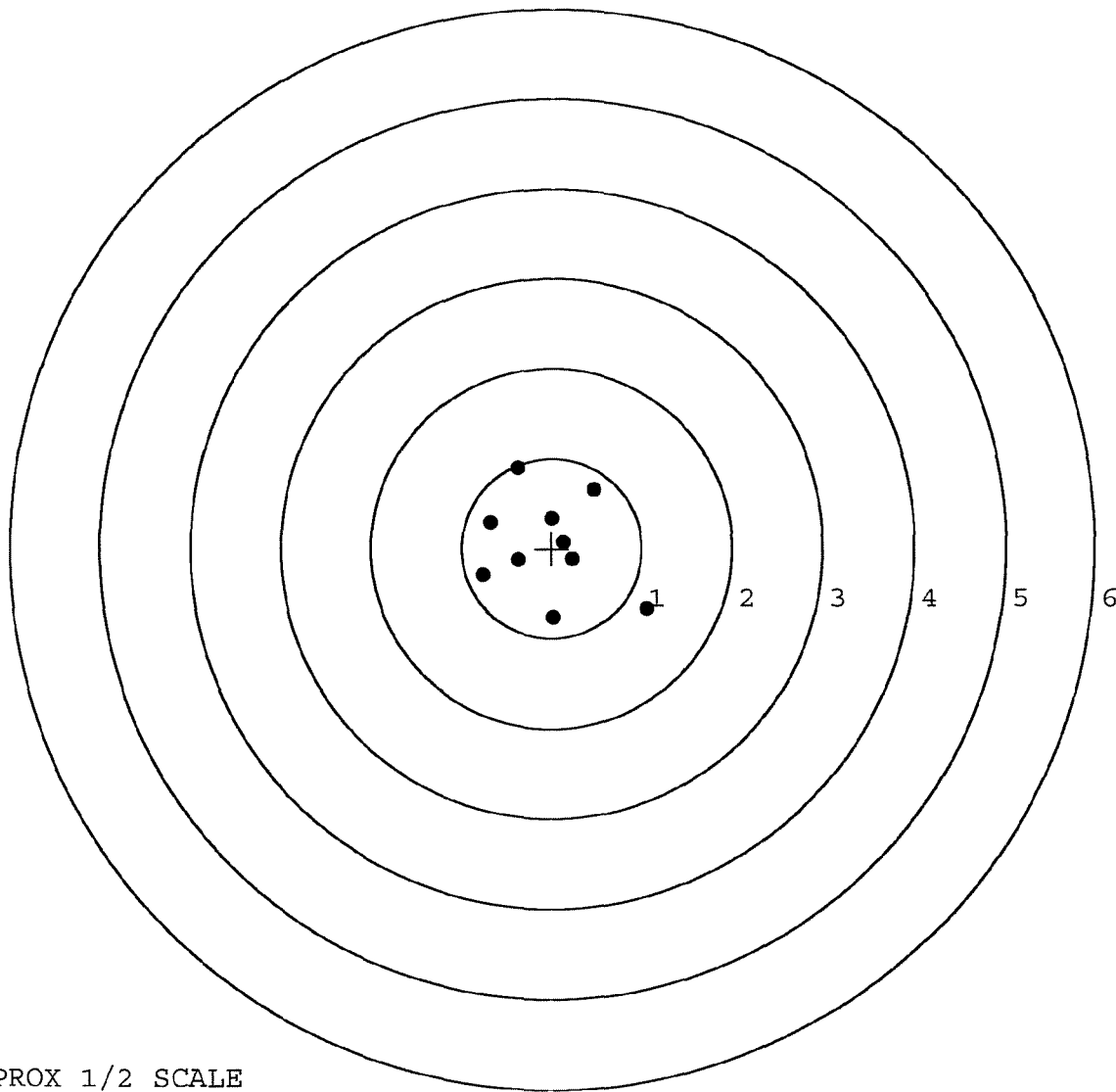
MEAN RADIUS: 0.649

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.385	0.888
2:	0.469	0.653
3:	-0.010	0.329
4:	0.128	0.072
5:	0.233	-0.126
6:	1.057	-0.674
7:	-0.375	-0.140
8:	-0.764	-0.303
9:	-0.683	0.280
10:	0.025	-0.775



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C634899. __0

TARGET NUMBER: 4

FILE DATE: 11/13/2006

FILE TIME: 21:23

POINT#	X	Y
1:	0.175	0.377
2:	0.365	0.463
3:	-0.225	0.213
4:	-0.406	0.018
5:	0.145	0.006
6:	0.211	-0.271
7:	-0.434	-0.347
8:	-0.519	-0.790
9:	-0.711	-1.259
10:	0.518	-0.814

X CENTROID: -0.088

Y CENTROID: -0.240

POA TO CENTROID: 0.256

HORZ SPREAD: 1.229

VERT SPREAD: 1.722

GROUP SPREAD: 2.031

MIN RADIUS: 0.301

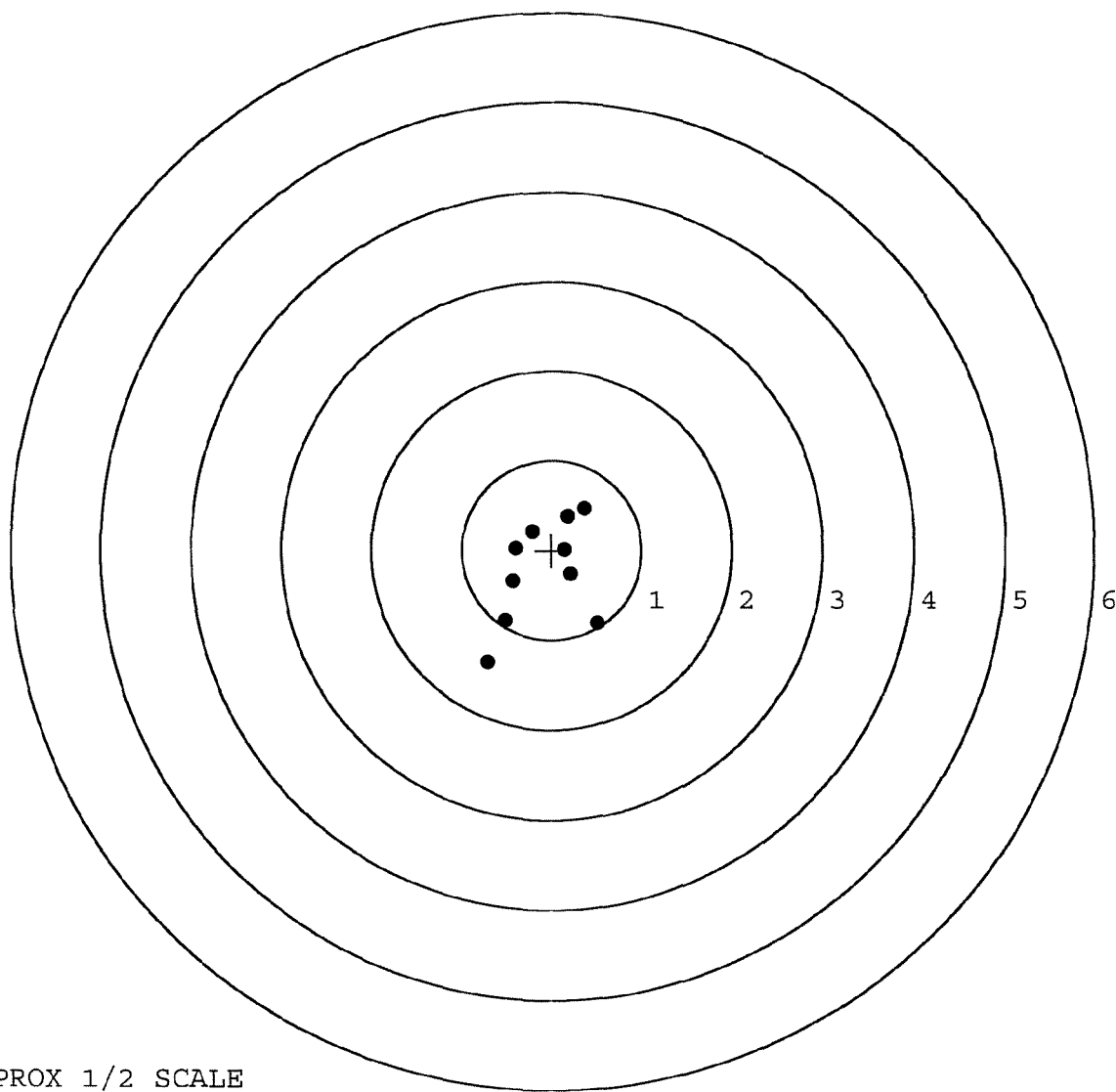
MAX RADIUS: 1.194

MEAN RADIUS: 0.612

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C634899. 0

TARGET NUMBER: 5

FILE DATE: 11/13/2006

FILE TIME: 21:23

POINT#	X	Y
1:	-0.142	1.228
2:	1.266	1.283
3:	0.674	0.134
4:	0.345	0.169
5:	0.149	0.470
6:	-0.508	0.392
7:	-0.316	-0.108
8:	0.210	-0.218
9:	-0.235	-0.631
10:	0.457	-1.173

X CENTROID: 0.190

Y CENTROID: 0.155

POA TO CENTROID: 0.245

HORZ SPREAD: 1.774

VERT SPREAD: 2.456

GROUP SPREAD: 2.586

MIN RADIUS: 0.156

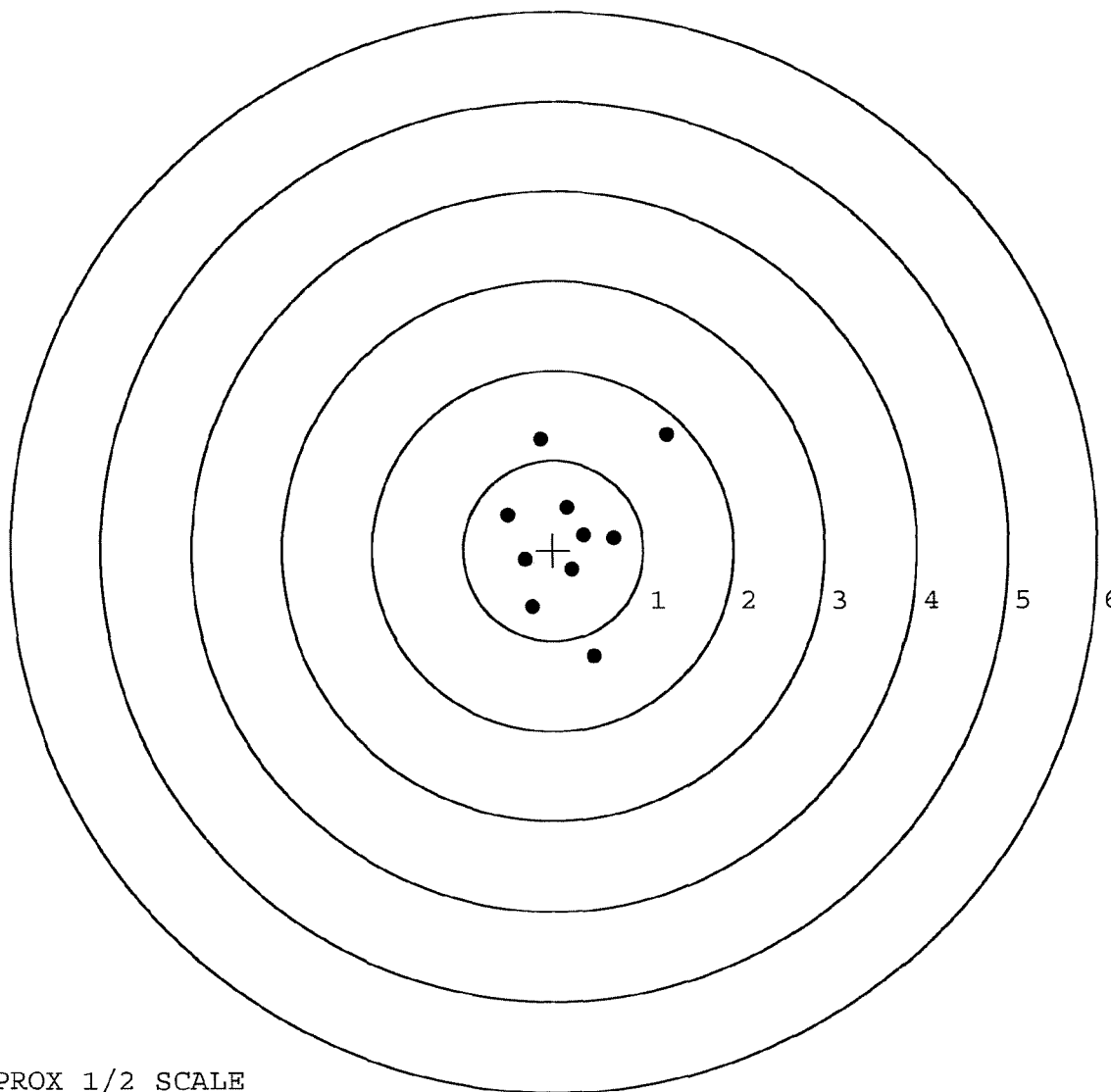
MAX RADIUS: 1.559

MEAN RADIUS: 0.757

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

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

A-2

R & E NUMBER	112535			
SERIAL NUMBER	060348999			
LOG-IN DATE	5-18-06			
OPERATION #	OPERATION NAME		DATE	INITIAL
500	DIS-ASSEMBLE GUN		5-23-06	RTZ
505	RE-BARREL		5-26-06	RTZ
560	ASSEMBLE		5-30-06	RTZ
600	PROOF	MAGNA-FLUX INSPECTED		
605	CHECK HEADSPACE	INSPECTED		
610	DIS-ASSEMBLE GUN	JUN 02 2006	6-1-06	RTZ
612	MAGNAFLUX	OPERATOR (APD)	6-2-06	APD
510	DRILL AND TAP		6-1-06	TRW
615	ROLLMARK CALIBER	9-20-06 CW	6-2-06	CW
618	ROTO-BLAST		6-2-06	LB
620	APPLY COATINGS	9/22/06 PB	6/5/06	TRW
625	FINAL ASSEMBLY		11-14-06	RTZ
640	FUNCTION TEST AND	(PASS) FAIL	11-11-06	TRW
650	TARGET	(PASS) FAIL	11-11-06	TRW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
670	FINAL INSPECTION		11-11-06	TRW
	A) HEADSPACE	(PASS) FAIL	11-15-06	RTZ
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	2.62 2.61 2.64 2.61 2.61 11-14-06	RTZ
680	F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX	5.0 5.0 5.0 11-14-06	RTZ
	G) SAFETY OFF FORCE	2 LBS	2.0 2.25 2.0 11-14-06	RTZ
	I) FIRING PIN INDENT	.020	.021 .021 .021 11-14-06	RTZ
690	PACK		11-15-06	RTZ

BARBER M24 0041074 RECEIVING AND ESTIMATING REPORT

COMMENTS

ORDER
R 95-10966

INITIAL CUSTOMER ORDER NO.

FJB

W/10X SCOPE SNIPER W/DEPLOYMENT KIT
ATTN: FRED MARTIN *Scope # 89-0578*

DATE RECEIVED	DATE OPENED	DATE CODE	SERIAL NUMBER	NEW SERIAL NUMBER	MODEL AND GRADE
03/30/95	03/31/95	DJ 9-89	C6348899		700 7.62 NATO
ACCESSORIES SLING STRAP SCOPE MNTS SCOPE BASE HARD CASE					

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.

ACCOUNT NUMBER

ACCOUNT NUMBER N/C

WRITE ☐

PROM. DATE

ESTIMATED

VIA

6-27-96 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

*NEW BARREL
STOCK
TRIGGER ASSY
FIRING PIN ASSY
FRONT LENS COVER
REAR LENS COVER*

REPAIRMAN

PROOF

CLEAN

TEST

TARGET

PATTERN

GALLERY TESTER

DATE

DATE

DATE

DATE

DATE

7/9/96 7/9/96

OFFICE COPY

RD6925 REV. 1/94

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

BARBER - M24 0041074 1113

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

SERIAL NO. C6348899
DATE 6-24-96
TESTER DA

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#	COMMENTS
PULL #1	2.39	2.43	2.52	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.28	2.50	2.42	
PULL #3	2.27	2.48	2.46	
PULL #4	2.23	2.48	2.55	
PULL #5	2.32	2.35	2.57	
TOTAL	11.49	12.24	12.52	
AVG.	2.29	2.44	2.50	

	3.00# INITIAL	3.00# AFTER 20 CYCLES	COMMENTS
PULL #1	3.13	3.20	
PULL #2	3.10	3.19	
PULL #3	2.93	3.21	
PULL #4	3.14	3.19	
PULL #5	3.20	3.28	
TOTAL	15.50	16.07	
AVG.	3.10	3.21	

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.09	4.06		4.18
PULL #2	4.14	4.01		4.10
PULL #3	4.16	4.16		4.25
PULL #4	4.15	4.20		4.27
PULL #5	4.17	4.15		4.22
TOTAL	20.71	20.58		21.02
AVG.	4.14	4.11		4.20

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

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		6-27	REP
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		6-27	REP
	C) Inspect Ejector Hole for Chamfer		6-27	REP
	D) Oil Firing Pin Ass'y		6-27	REP
	E) Adjust Trigger Pull to Min Setting and Stake			

op. #	BARBER - M24 0041077 OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	8	8.5	7			6-27	REP
	G) Safety Off Force	4	4	4			6-27	REP
	H) Trigger Pull Test & Retainability							
	I) Firing Pin Indent	.023	.024	.0235			6-27	REP
	J) Assemble Stock						6-27	REP
	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						6-27	REP
	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	1.29	2.18	2.15	2.20	2.20	7/14	SF
	C) Function							
660	Pack							

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6348899
12 JAN 1900

CENTROIDAL DISTANCES

0 TO	1	.139119
1 TO	2	.298412
1 TO	3	.345636
1 TO	4	.284192
1 TO	5	.487997

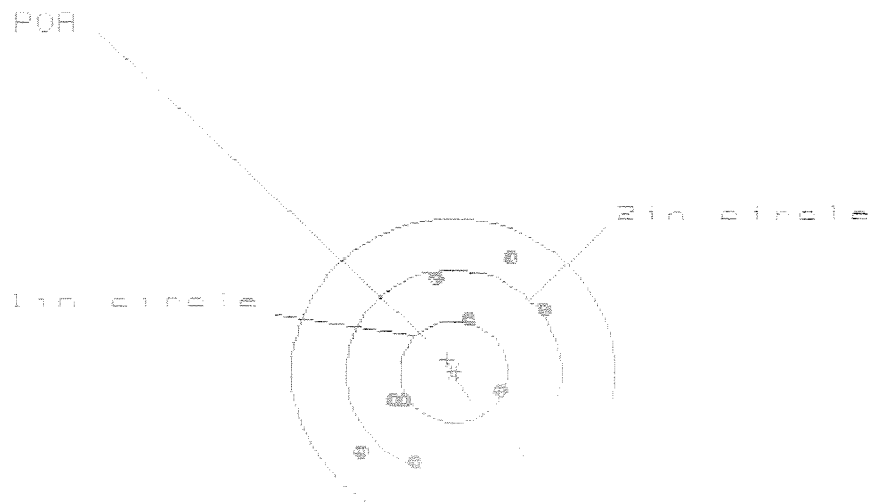
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .03
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .158
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .160823

THE AMR FOR THIS RIFLE IS: .9116

18 Jan 1988

FILE:/PATTERNING/CENTERFIRE_PAT/06345889

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 7

3 in = 10

HS= 1.682

VS= 1.965

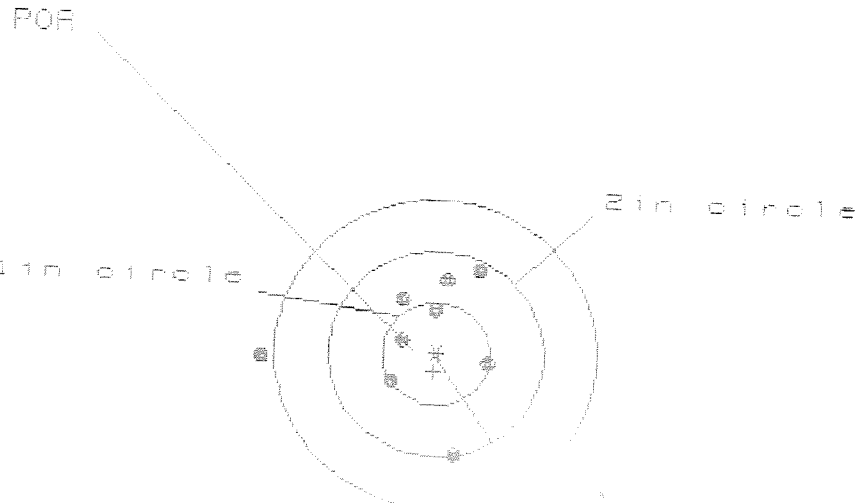
GS= 2.339

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.795	.850	.745
MINIMUM X	-.887	-.832	-.654
MAXIMUM Y	1.102	1.030	.946
MINIMUM Y	-.868	-.740	-.824
CENTROID X	.065	.010	.115
CENTROID Y	-.123	-.246	-.162
POA TO CENTROID in.	.139	.246	.198
MIN RADIUS	.458	.466	.398
MEAN RADIUS	.846	.796	.757
MAX RADIUS	1.205	1.117	.983
HORIZONTAL SPREAD	1.682	1.682	1.399
VERTICAL SPREAD	1.965	1.770	1.770
EXTREME SPREAD	2.339	2.184	1.874
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	10		

18 Jan 1988

FILE: PATTERNING/CENTERFIRE_PATT/C8348899

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 4

2in = 3

3in = 3

HS= 2.186

VS= 2.049

GS= 3.399

Circles

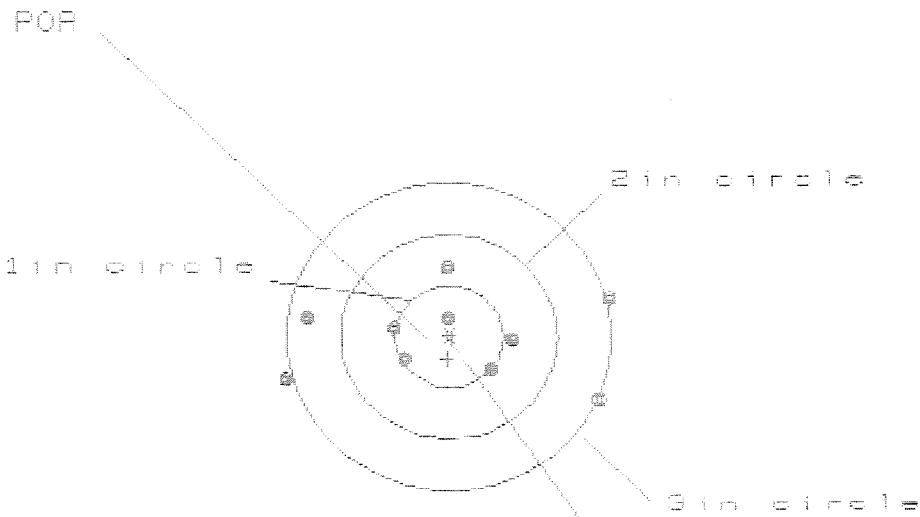
LD #

PATTERN #	2		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.692	.629	.453
MINIMUM X	-1.584	-1.406	-.372
MAXIMUM Y	.796	.657	.631
MINIMUM Y	-1.252	-1.075	-1.101
CENTROID X	.020	-.158	.018
CENTROID Y	.172	.312	.338
POA TO CENTROID in.	.174	.349	.338
MIN RADIUS	.327	.149	.243
MEAN RADIUS	.851	.677	.577
MAX RADIUS	2.033	1.422	1.115
HORIZONTAL SPREAD	3.186	2.035	.825
VERTICAL SPREAD	2.049	1.732	1.732
EXTREME SPREAD	3.399	2.127	1.742
NUMBER IN ONE INCH CIRCLE	=	4	
NUMBER IN TWO INCH CIRCLE	=	8	
NUMBER IN THREE INCH CIRCLE	=	8	

10 Jan 1968

FILE:/PATTERNING/CENTERFIRE_PATT/0634B889

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 6

3 in = 8

HE= 3.042

VS= 1.282

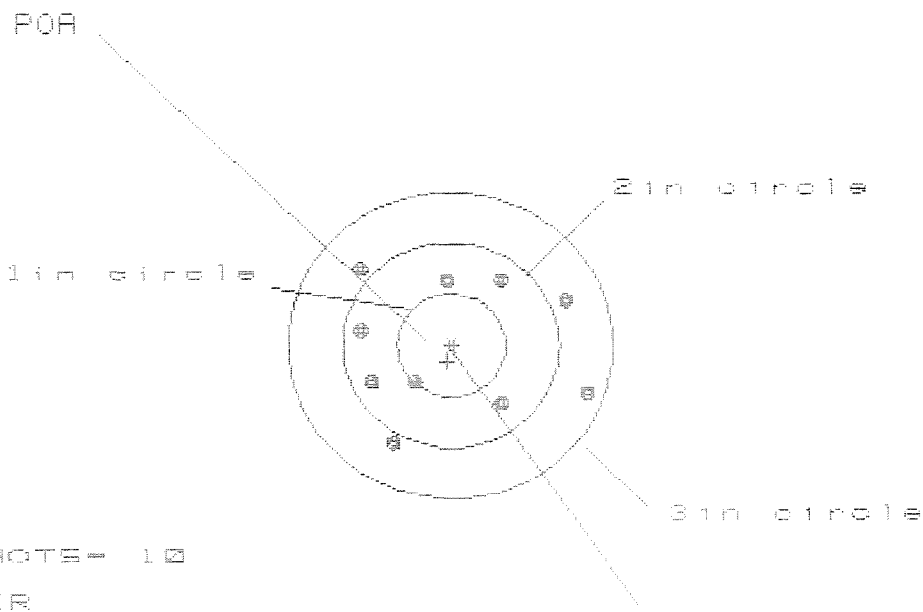
GS= 3.133

PATTERN #	1	2	3
SHOTS (BEST OF)	10		
MAXIMUM X	1.496		1.337
MINIMUM X	-1.548		-1.282
MAXIMUM Y	.673		.665
MINIMUM Y	-.609		-.617
CENTROID X	.015	.127	.022
CENTROID Y	.219	.264	.227
POB TO CENTROID in.	.219	.324	.228
MIN RADIUS	.188	.226	.180
MEAN RADIUS	.881	.796	.708
MAX RADIUS	1.599	1.455	1.473
HORIZONTAL SPREAD	3.042	2.772	2.619
VERTICAL SPREAD	1.282	1.282	1.282
EXTREME SPREAD	3.133	2.776	2.741
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	8		

18 Jan. 1968

FILE:/PATTERNING/CENTERFIRE_PATT/06348899

CENTERFIRE PATTERNS # 4



OF SHOTS = 10

IN CIR

1 in = 0

2 in = 6

3 in = 10

HS = 2.125

VS = 1.701

GS = 2.424

CENTROID #

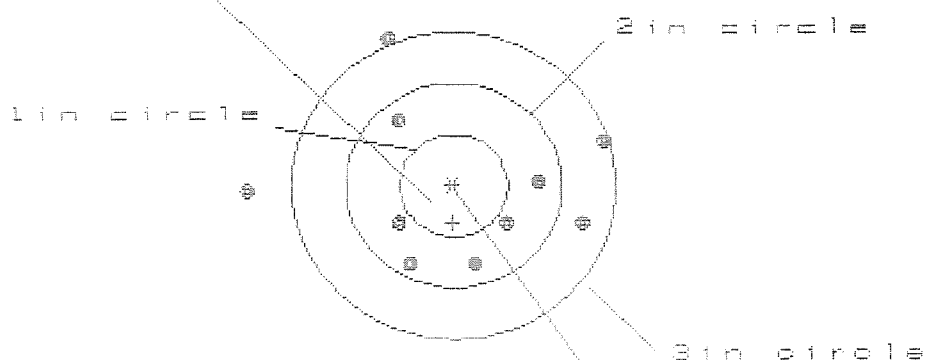
PATTERN #	1	2	3
SHOTS (BEST OF)	10		9
MAXIMUM X	1.267	1.267	1.790
MINIMUM X	-.858	-.858	-.563
MAXIMUM Y	.763	.712	.759
MINIMUM Y	-.938	-.989	-.943
CENTROID X	.039	-.102	-.256
CENTROID Y	.160	.211	.164
POA TO CENTROID in.	.165	.234	.304
MIN RADIUS	.510	.468	.372
MEAN RADIUS	.917	.849	.766
MAX RADIUS	1.348	1.283	1.038
HORIZONTAL SPREAD	2.125	1.945	1.353
VERTICAL SPREAD	1.701	1.701	1.701
EXTREME SPREAD	2.424	2.084	1.893
NUMBER IN ONE INCH CIRCLE =		0	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		10	

10 Jan 1900

FILE:/PATTERNING/CENTERFIRE_PATT/C834B889

CENTERFIRE PATTERNS # 5

POR



OF SHOTS - 10

IN CIR

1 in = 0

2 in = 0

3 in = 0

HS = 3.266

VS = 2.272

GS = 3.306

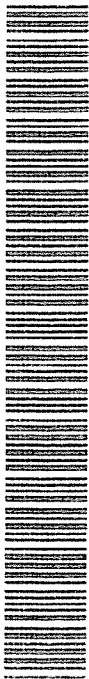
CENTROID #

PATTERN #

5

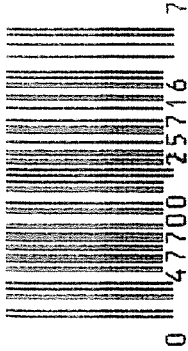
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.360	1.148	1.050
MINIMUM X	-1.906	-1.786	-1.854
MAXIMUM Y	1.475	1.471	.794
MINIMUM Y	-.797	-.801	-.617
CENTROID X	.011	.223	.322
CENTROID Y	.362	.366	.182
POR TO CENTROID in.	.362	.429	.369
MIN RADIUS	.614	.475	.268
MEAN RADIUS	1.063	.946	.808
MAX RADIUS	1.907	1.668	1.239
HORIZONTAL SPREAD	3.266	1.934	1.903
VERTICAL SPREAD	2.272	2.272	1.411
EXTREME SPREAD	3.306	2.531	2.149
NUMBER IN ONE INCH CIRCLE	=	0	
NUMBER IN TWO INCH CIRCLE	=	6	
NUMBER IN THREE INCH CIRCLE	=	8	

Remington® MODEL 700™ H24 MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat & Tm. Off, Marca Registrada Marque Deposee.		SERIAL NO. 06348899
01		ORDER NO. 5716



5716 06348899

LPC



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Sept 0159

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6348899

OP. #	OP. NAME	READINGS	DATE	INITIAL
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.
617	Drill & Tap Sight Holes	9 15	89	YB
618	Polish Barrel	9 15	89	BT
620	Apply Coatings (Barrel Action)		9-25-89	TJA
	Apply Coatings (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

OVER

OP.#		READINGS	DATE	INITIAL
625 cont.	D) Oil Firing Pin Ass'y		9/26/89	RW
	E) Adjust Trigger Pull to Min. Setting and Stake		3 Oct 89	918
	F) Safety on Force	5 5 5	10/4/89	94
	G) Safety off Force	4 4 4	10/4/89	94
	H) Trigger Pull Test & Retainability		3 Oct 89	918
	I) Firing Pin Indent	.020 .021 .0205	10/4/89	94
	J) Assemble Stock		10/6/89	RW
	K) Assemble Swivel Studs		16 Oct 89	918
	L) Attach Front & Rear Sight Assemblies		10/6/89	RW
	M) Iron Sight Alignment		10/6/89	RW
	N) Detach Front & Rear Sights & place in numbered container		10/6/89	RW
	O) Attach Scope to Rifle		10/4/89	94
	P) Detach & Attach Scope 20 times		10/9/89	84
640	Gallery Target & Test		10-9-89	4
	A) Optical Clarity of Scope		10-9-89	4
645	Inspect for Live Ammo		10-9-89	4
655	Final Inspection A) Headspace		16 Oct 89	918
	B) Trigger Pull	204206, 219203, 221	16 Oct 89	918
	C) Function		16 Oct 89	918
660	Pack		15 Oct 89	918

C6348899

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C6349046

DATE 2-6-90

TESTER JRL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#	COMMENTS
PULL #1	2.47	2.34	2.38	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.16	2.41	2.50	
PULL #3	2.44	2.55	2.52	
PULL #4	2.45	2.56	2.40	
PULL #5	2.29	2.52	2.43	
TOTAL	11.81	12.38	12.23	
AVG.	2.362	2.476	2.446	

	3.00# INITIAL	3.00# AFTER 20 CYCLES	COMMENTS
PULL #1	3.37	3.50	
PULL #2	3.52	3.47	
PULL #3	3.10	3.56	
PULL #4	3.15	3.52	
PULL #5	3.37	3.51	
TOTAL	16.51	17.56	
AVG.	3.302	3.512	

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.27	4.40		4.08
PULL #2	4.37	4.48		4.45
PULL #3	4.47	4.51		4.53
PULL #4	4.35	4.53		4.11
PULL #5	4.47	4.48		4.08
TOTAL	21.93	22.40		21.25
AVG.	4.386	4.48		4.25

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06348899
9 Oct 1989

CENTROIDAL DISTANCES

0 TO	1	.154029
1 TO	2	1.26409
1 TO	3	.573778
1 TO	4	.30477
1 TO	5	.344803

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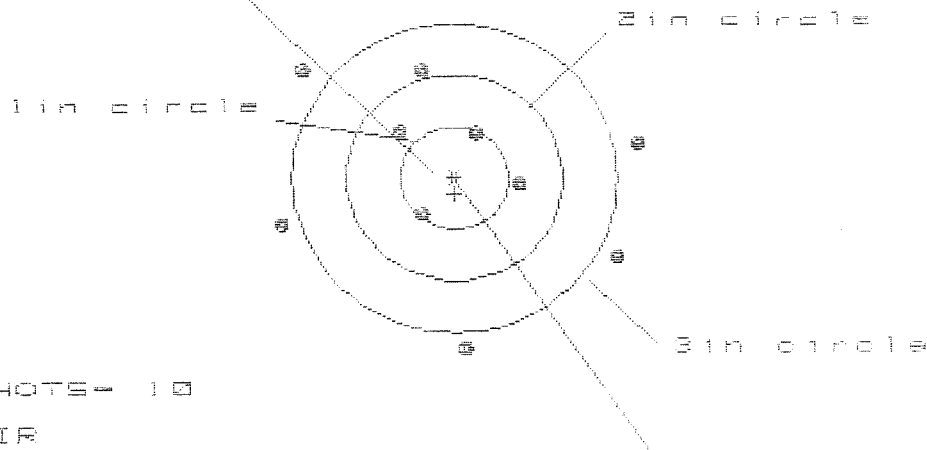
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .183
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.3028
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .353800
THE AMR FOR THIS RIFLE IS: 1.162

9 Oct 1989

FILE:/PATTERNING/CENTERFIRE_PATT/08948899

CENTERFIRE PATTERNS # 1

POB



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 4

3 in = 5

HS= 3.245

VS= 2.755

GS= 3.409

CENTROID *

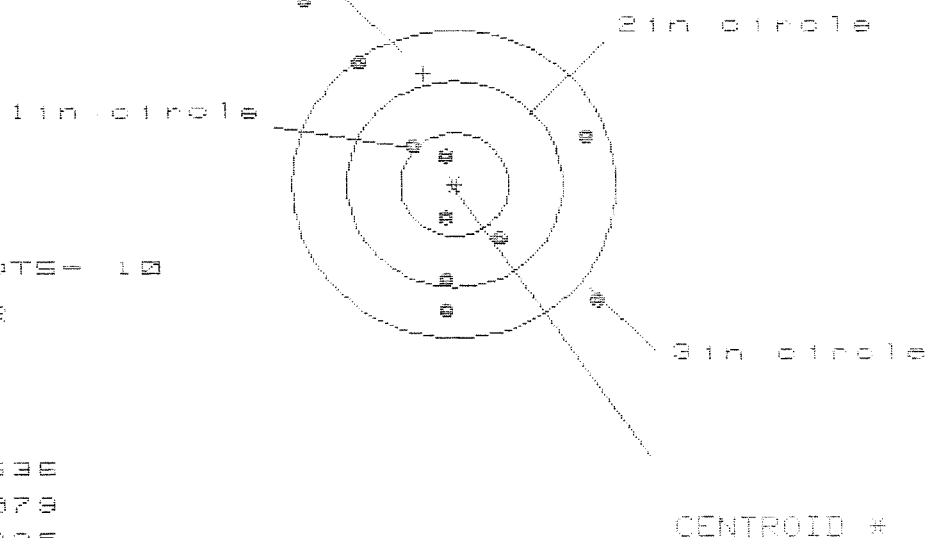
PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.664	1.509	1.510
MINIMUM X	-1.581	-1.736	-1.547
MAXIMUM Y	1.090	1.118	1.172
MINIMUM Y	-1.665	-1.544	-1.490
CENTROID X	.003	.158	-.031
CENTROID Y	.154	.033	-.021
POB TO CENTROID in.	.154	.161	.037
MIN RADIUS	.482	.472	.359
MEAN RADIUS	1.181	1.116	1.050
MAX RADIUS	1.767	1.761	1.618
HORIZONTAL SPREAD	3.245	3.245	3.057
VERTICAL SPREAD	2.755	2.662	2.662
EXTREME SPREAD	3.409	3.325	3.076
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	5		

9 Oct 1989

FILE:/PATTERNING/CENTERFIRE_PATT/08348899

CENTERFIRE PATTERNS # 2

POR



OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 8

HS = 2.636

VS = 3.079

GS = 3.925

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.275	1.124	1.205
MINIMUM X	:	-1.361	-.990	-.850
MAXIMUM Y	:	1.808	1.392	1.280
MINIMUM Y	:	-1.271	-1.070	-1.182
CENTROID X	:	.286	.437	.297
CENTROID Y	:	-1.078	-1.279	-1.167
POR TO CENTROID in.	:	1.115	1.352	1.204
MIN RADIUS	:	.274	.232	.330
MEAN RADIUS	:	1.068	.910	.833
MAX RADIUS	:	2.263	1.708	1.536
HORIZONTAL SPREAD	:	2.636	2.114	2.055
VERTICAL SPREAD	:	3.079	2.462	2.462
EXTREME SPREAD	:	3.925	3.117	2.587
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

9 Oct 1989

FILE:/PATTERNING/CENTERFIRE_PATT/0634B089

CENTERFIRE PATTERNS # 3

POB

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS= 10

IN CIR

1in = 0

2in = 6

3in = 8

HS= 2.791

VS= 1.986

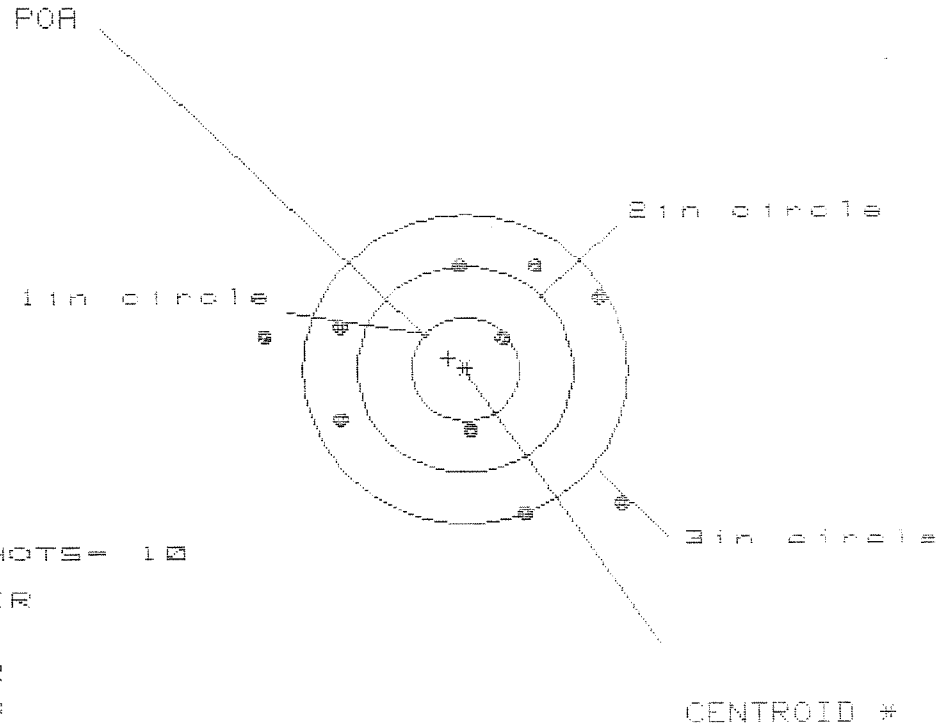
CS= 2.893

PATTERN #	:	3
SHOTS (BEST OF)	:	10
MAXIMUM X	:	1.039
MINIMUM X	:	-1.752
MAXIMUM Y	:	.591
MINIMUM Y	:	-1.395
CENTROID X	:	.258
CENTROID Y	:	-.388
POB TO CENTROID in.	:	.443
MIN RADIUS	:	.681
MEAN RADIUS	:	1.054
MAX RADIUS	:	1.765
HORIZONTAL SPREAD	:	2.791
VERTICAL SPREAD	:	1.986
EXTREME SPREAD	:	2.893
NUMBER IN ONE INCH CIRCLE	=	0
NUMBER IN TWO INCH CIRCLE	=	6
NUMBER IN THREE INCH CIRCLE	=	8

9 Oct 1989

FILE:/PATTERNING/CENTERFIRE_PATT/06348889

CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 2

3 in = 8

HS= 3.225

VS= 2.394

GS= 3.615

PATTERN #	:	4
SHOTS (BEST OF)	:	10
MAXIMUM X	:	1.399
MINIMUM X	:	-1.826
MAXIMUM Y	:	1.035
MINIMUM Y	:	-1.359
CENTROID X	:	.157
CENTROID Y	:	-.109
POA TO CENTROID in.	:	.191
MIN RADIUS	:	.460
MEAN RADIUS	:	1.242
MAX RADIUS	:	1.937
HORIZONTAL SPREAD	:	3.225
VERTICAL SPREAD	:	2.394
EXTREME SPREAD	:	3.615
NUMBER IN ONE INCH CIRCLE	=	1
NUMBER IN TWO INCH CIRCLE	=	2
NUMBER IN THREE INCH CIRCLE	=	8

9 Oct 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C6348899

CENTERFIRE PATTERNS # 5

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS - 10

IN CIR

1 in = 1

2 in = 4

3 in = 7

HS = 3.867

VS = 3.670

GS = 3.961

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.020	2.033	1.803
MINIMUM X	:	-1.847	-1.834	-1.883
MAXIMUM Y	:	1.323	1.063	1.167
MINIMUM Y	:	-2.347	-1.326	-1.222
CENTROID X	:	.211	.198	.428
CENTROID Y	:	-.121	.139	.035
POA TO CENTROID in.	:	.244	.242	.429
MIN RADIUS	:	.221	.421	.246
MEAN RADIUS	:	1.267	1.152	1.021
MAX RADIUS	:	2.350	2.035	1.814
HORIZONTAL SPREAD	:	3.867	3.867	2.686
VERTICAL SPREAD	:	3.670	2.389	2.389
EXTREME SPREAD	:	3.961	3.936	2.845
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		7	