

C6348915

MODEL 700™ M24

Model **SWS**™

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

Remington

Arm. 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: **RE00089035** Serial: C6348915 Model: M24 SWS Center Fire Caliber: 7.62 NATO Repairman: Status: Closed 12/6/2004 7:41:38 AM

Address Information

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

Name: **TRANSPORTATION OFFICER** **TRANSPORTATION OFFICER**

Address 1: **DEF DIST DEPOT ANNISTON AL** **DEF DIST DEPOT ANNISTON AL**

Address 2: PO Box: PO Box:

City: **ANNISTON** **ANNISTON**

State: **AL** Zip Code: **36201** Country: **US** State: **AL** Zip Code: **36201** 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
A006	Sling Strap	1
A007	With Stud	3
A010	Hard Case	1
A012	Scope Base	1
A026	Scope W/CASE	1
A055	Deployment Kit	1
A057	Front and Rear Sgl Base	1

Repair Search Refresh Close

negleij 12/6/2004 8:53 AM CAPS NUM INE SCPL

start 2 2 2 2 2 2 2 2 2 2

Serial Number: **C6348915**

Model: **M24 SWS**



RE00089035

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6348915.___0

FILE DATE AND TIME: 01/11/2005 11:31

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.004
The Average Y Centroid of the Five Target Set:	0.121
The Average Point of Impact of the Five Target Set:	0.121
The Average Mean Radius of the Five Target Set:	0.793
The Distance from POA to Centroid Target #1:	0.358
The Distance from Centroid Target #2 to Centroid Target #1:	0.273
The Distance from Centroid Target #3 to Centroid Target #1:	0.497
The Distance from Centroid Target #4 to Centroid Target #1:	0.214
The Distance from Centroid Target #5 to Centroid Target #1:	0.311

SERIAL NUMBER: C6348915. __0

TARGET NUMBER: 1

FILE DATE: 01/11/2005

FILE TIME: 11:31

X CENTROID: -0.145

Y CENTROID: 0.328

POA TO CENTROID: 0.358

HORZ SPREAD: 2.028

VERT SPREAD: 2.580

GROUP SPREAD: 2.873

MIN RADIUS: 0.156

MAX RADIUS: 1.583

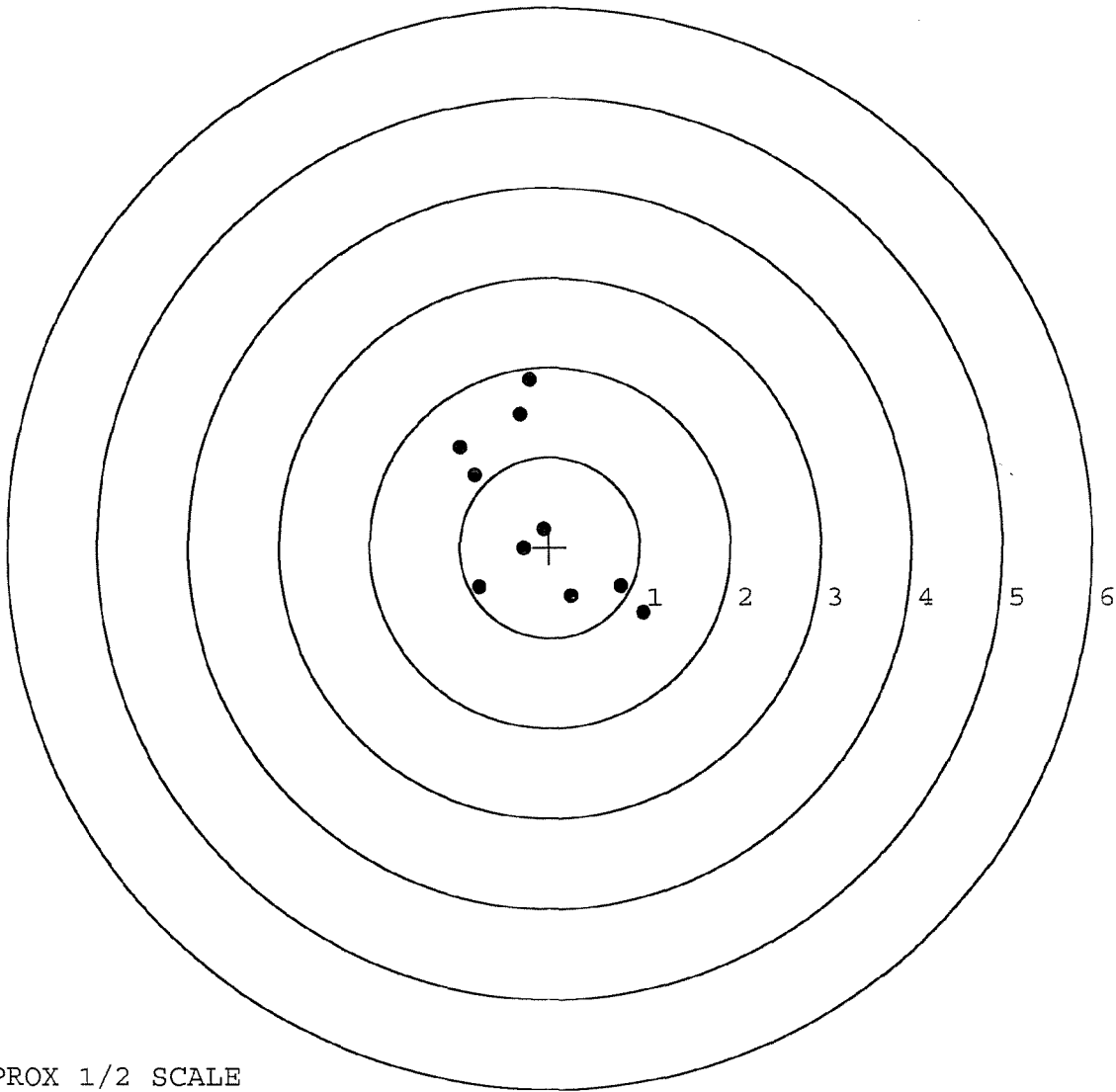
MEAN RADIUS: 0.993

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 5

in 3 IN DIAMETER: 8

POINT#	X	Y
1:	1.037	-0.725
2:	0.788	-0.427
3:	0.235	-0.535
4:	-0.061	0.196
5:	-0.292	-0.018
6:	-0.781	-0.443
7:	-0.832	0.796
8:	-0.991	1.104
9:	-0.329	1.473
10:	-0.226	1.855



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6348915. __0

TARGET NUMBER: 2

FILE DATE: 01/11/2005

FILE TIME: 11:31

POINT#	X	Y
1:	0.842	0.342
2:	0.644	1.234
3:	0.325	-0.938
4:	0.122	-0.489
5:	-0.348	-1.320
6:	-0.604	-0.211
7:	-0.374	1.072
8:	-0.183	0.706
9:	-0.129	0.362
10:	0.276	0.688

X CENTROID: 0.057

Y CENTROID: 0.145

POA TO CENTROID: 0.155

HORZ SPREAD: 1.446

VERT SPREAD: 2.554

GROUP SPREAD: 2.740

MIN RADIUS: 0.286

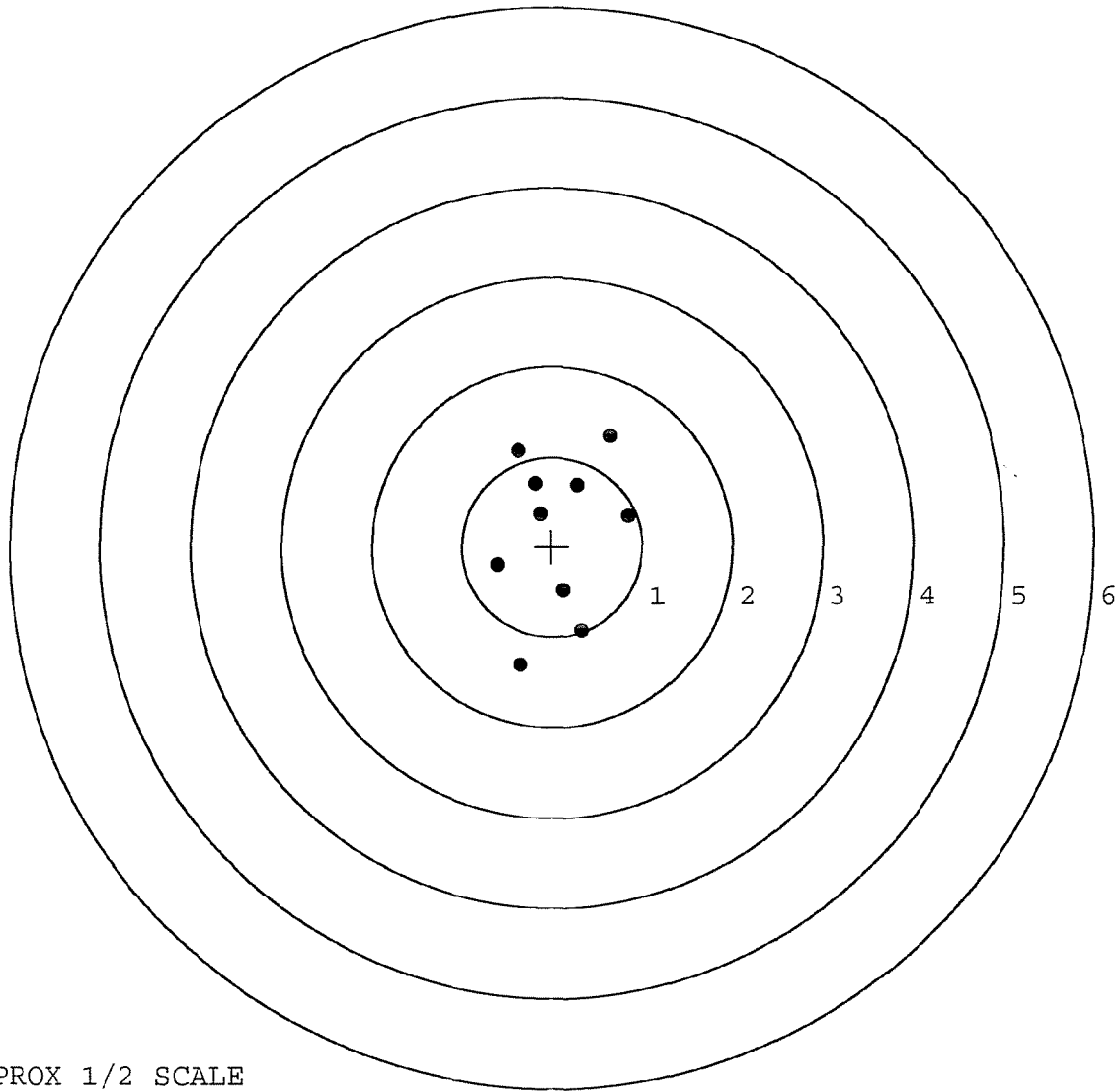
MAX RADIUS: 1.520

MEAN RADIUS: 0.857

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 9



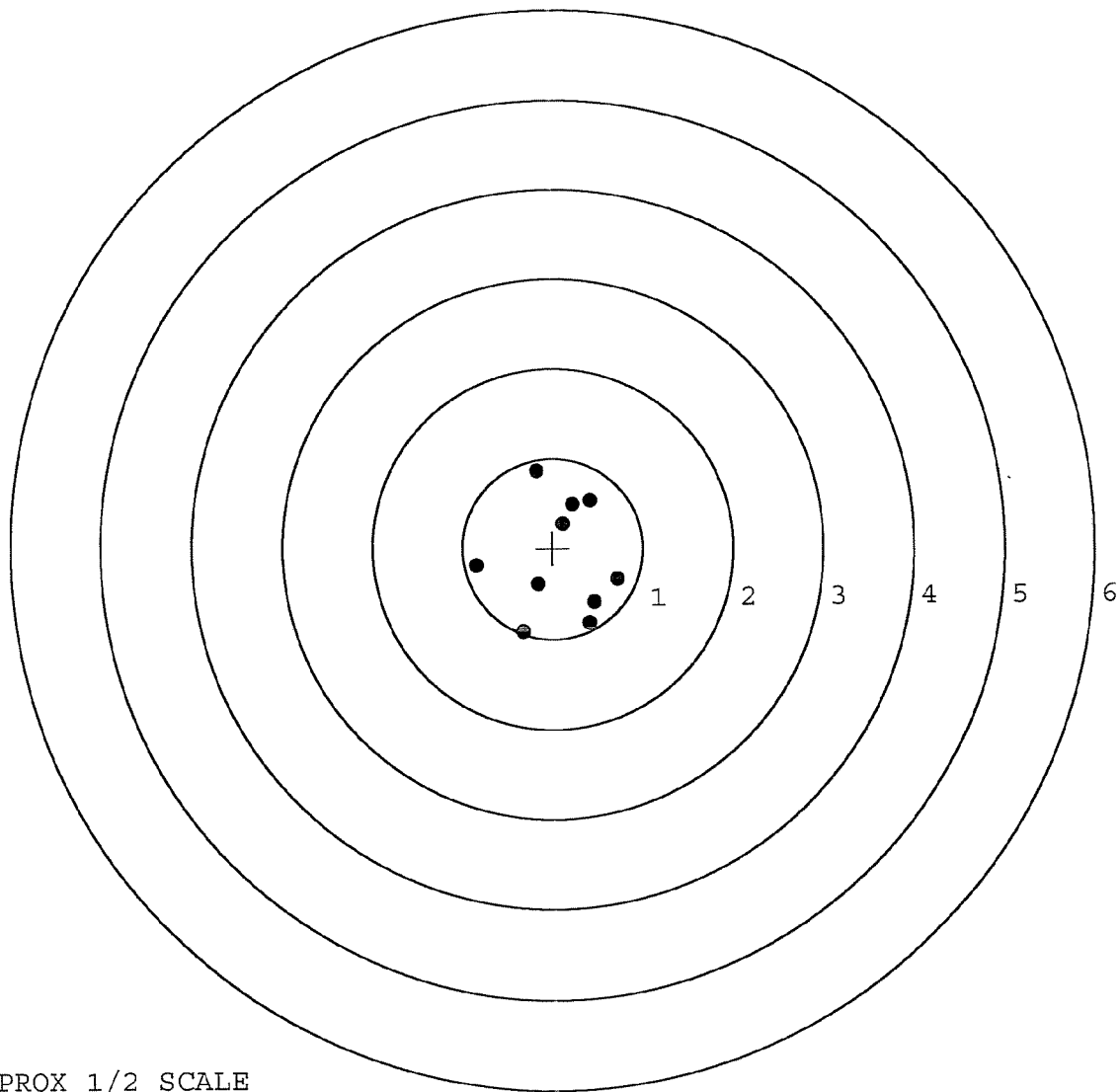
TARGET APPROX 1/2 SCALE

BARBER - M24 0041492

SERIAL NUMBER: C6348915. __0
 TARGET NUMBER: 3
 FILE DATE: 01/11/2005
 FILE TIME: 11:31

X CENTROID: 0.082
 Y CENTROID: -0.115
 POA TO CENTROID: 0.141
 HORZ SPREAD: 1.573
 VERT SPREAD: 1.785
 GROUP SPREAD: 1.792
 MIN RADIUS: 0.378
 MAX RADIUS: 1.011
 MEAN RADIUS: 0.705
 # IN 1 IN DIAMETER: 2
 # IN 2 IN DIAMETER: 9
 # in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.720	-0.350
2:	0.459	-0.602
3:	0.404	-0.827
4:	-0.336	-0.922
5:	-0.160	-0.405
6:	-0.853	-0.195
7:	0.419	0.531
8:	0.225	0.489
9:	0.118	0.271
10:	-0.175	0.863

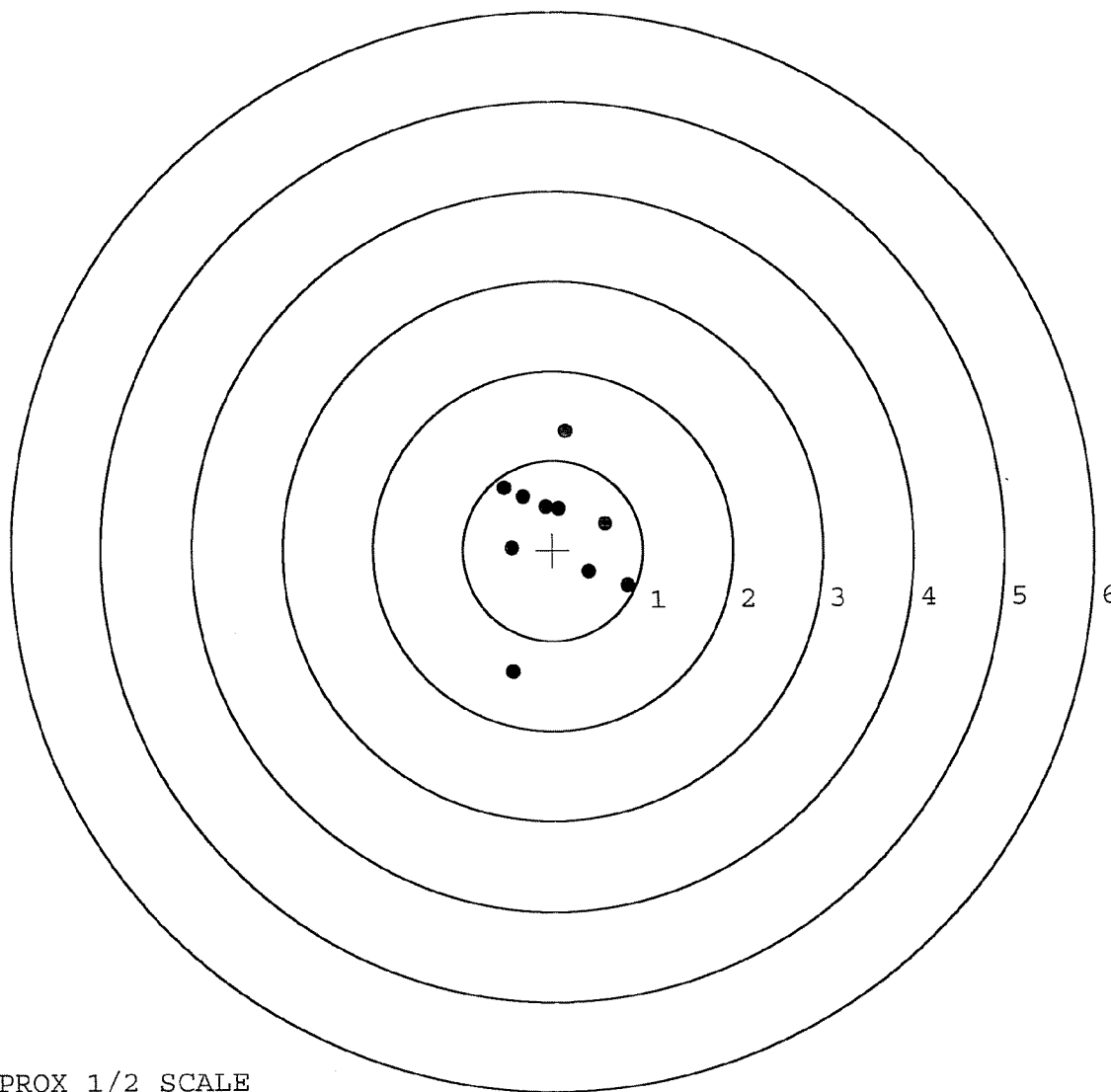


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6348915. __0
 TARGET NUMBER: 4
 FILE DATE: 01/11/2005
 FILE TIME: 11:31

X CENTROID: 0.018
 Y CENTROID: 0.189
 POA TO CENTROID: 0.190
 HORZ SPREAD: 1.361
 VERT SPREAD: 2.678
 GROUP SPREAD: 2.744
 MIN RADIUS: 0.278
 MAX RADIUS: 1.608
 MEAN RADIUS: 0.728
 # IN 1 IN DIAMETER: 2
 # IN 2 IN DIAMETER: 8
 # in 3 IN DIAMETER: 9

POINT#	X	Y
1:	0.827	-0.394
2:	0.399	-0.244
3:	0.581	0.287
4:	0.149	1.328
5:	-0.534	0.698
6:	-0.331	0.598
7:	-0.076	0.485
8:	0.069	0.463
9:	-0.457	0.022
10:	-0.448	-1.350



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6348915. __0

TARGET NUMBER: 5

FILE DATE: 01/11/2005

FILE TIME: 11:31

X CENTROID: 0.008

Y CENTROID: 0.056

POA TO CENTROID: 0.057

HORZ SPREAD: 1.516

VERT SPREAD: 1.951

GROUP SPREAD: 2.112

MIN RADIUS: 0.327

MAX RADIUS: 1.099

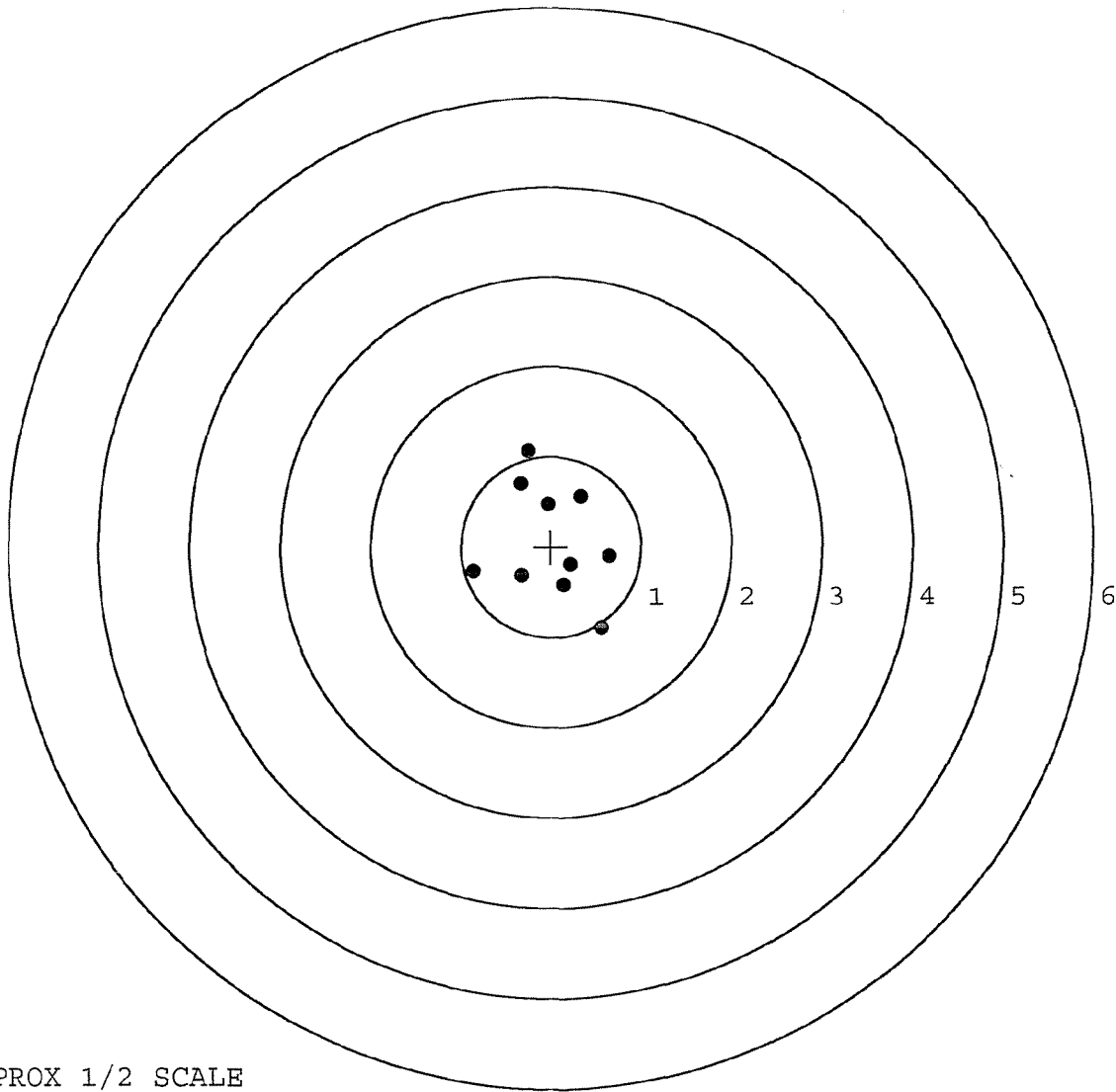
MEAN RADIUS: 0.680

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.556	-0.896
2:	0.651	-0.102
3:	0.215	-0.196
4:	0.145	-0.423
5:	-0.331	-0.324
6:	-0.865	-0.273
7:	0.333	0.558
8:	-0.036	0.472
9:	-0.338	0.694
10:	-0.253	1.055



TARGET APPROX 1/2 SCALE

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

R & E NUMBER	89035		
SERIAL NUMBER	C6348915		
LOG-IN DATE	12-6-04		
INSPECT AND VERIFY:			
OPERATION #	OPERATION NAME	DATE	INITIAL
550	DIS-ASSEMBLE GUN	12-7-04	RTZ
560 A	RE-BARREL	12-15-04	RTZ
B	DRILL AND TAP	12-27-04	TRW
575	ASSEMBLE	12-16-04	RTZ
600	PROOF	12-16-04	RTZ
605	CHECK HEADSPACE	12-16-04	RTZ
610	DIS-ASSEMBLE GUN	12-27-04	RTZ
612	MAGNAFLUX	OPERATOR	FD
615	ROLLMARK CALIBER	12-27-04	CW
618	ROTO-BLAST	12/28/04	DG
620	APPLY COATINGS	1/3/05	HP
625 A	FINAL ASSEMBLY	1-7-05	RTZ
B	TRIGGER PULL TEST	N/A	
C	SAFETY "ON" FORCE		
D	SAFETY "OFF" FORCE		
E	FIRING PIN INDENT		
640	TARGET	1-11-05	TRW
655	FINAL INSPECT	1-12-05	AC
660	PACK	3-1-05	BA
		SHIP DATE	
QAR INSPECTION DATE			

RECEIVED BARBER - M24 0041498 PORT

COMMENTS

ORDER

R 95-10946

INITIAL CUSTOMER ORDER NO

FJB

W/10X SCOPE SNIPER W/DEPLOYMENT KIT

ATTN: FRED MARTIN

Scope S/N 90 0658

DATE RECEIVED

DATE OPENED

DATE CODE

SERIAL NUMBER

NEW SERIAL NUMBER

MODEL AND GRADE

03/30/95

03/31/95

DJ 9-89

C6348915

700

7.62

NATO

ACCESSORIES

SCOPE MNTS

SCOPE BASE

HARD CASE

SOFT 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.L

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

New Barrel
Stock, Trigger Assy,
Firing Pin Assy.
Front & Rear Sight Assy

REPAIRMAN

PROOF

CLEAN

TEST

TARGET

PATTERN

GALLERY TESTER

DATE

DATE

DATE

DATE

DATE

OFFICE COPY

RD6925 REV. 1/94

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

BARBER - M24 0041498 41535

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

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

SERIAL NO. C 6348915DATE 7-9-96TESTER DA

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#	COMMENTS
PULL #1	2.62	2.35	2.50	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.79	2.41	2.65	
PULL #3	2.54	2.47	2.47	
PULL #4	2.70	2.64	2.76	
PULL #5	2.71	2.36	2.80	
TOTAL	13.36	12.23	13.18	
AVG.	2.67	2.44	2.63	

	3.00# INITIAL	3.00# AFTER 20 CYCLES	COMMENTS
PULL #1	3.17	3.06	
PULL #2	2.94	2.92	
PULL #3	3.13	3.24	
PULL #4	3.13	3.11	
PULL #5	2.97	3.00	
TOTAL	15.34	15.33	
AVG.	3.06	3.06	

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.12	4.25		4.08
PULL #2	4.19	4.38		4.09
PULL #3	4.28	4.32		4.13
PULL #4	4.35	4.48		4.01
PULL #5	4.25	4.52		4.13
TOTAL	21.19	21.87		20.44
AVG.	4.23	4.38		4.08

op. #	OP. NAME	READINGS	DATE	INIT
625 cont.	F) Safety On Force	28 7 7	8/2	SF
	G) Safety Off Force	4 4 4	8/2	SF
	H) Trigger Pull Test & Retainability			
	I) Firing Pin Indent	.023 .023 .022	8/2	SF
	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	2.20 2.41 2.39 2.49 2.43	8/1/96	SF
	C) Function			
660	Pack			

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			
	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			

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6348915
11 Jan 1980

TIME

CENTROIDAL DISTANCES

0 TO 1	.0212132
1 TO 2	.11114
1 TO 3	.179234
1 TO 4	.22608
1 TO 5	.0804984

POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0052
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0626
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0628156
THE AMR FOR THIS RIFLE IS: .9776

11 Jan 1900

FILE:/PATTERNING/CENTERFIRE_PATT/C634B915

CENTERFIRE PATTERNS # 1

POA

1 in circle

2 in circle

3 in circle

OF SHOTS = 10

IN CIR

1 in = 3

2 in = 6

3 in = 7

CENTROID #

HS = 4.110

VS = 1.161

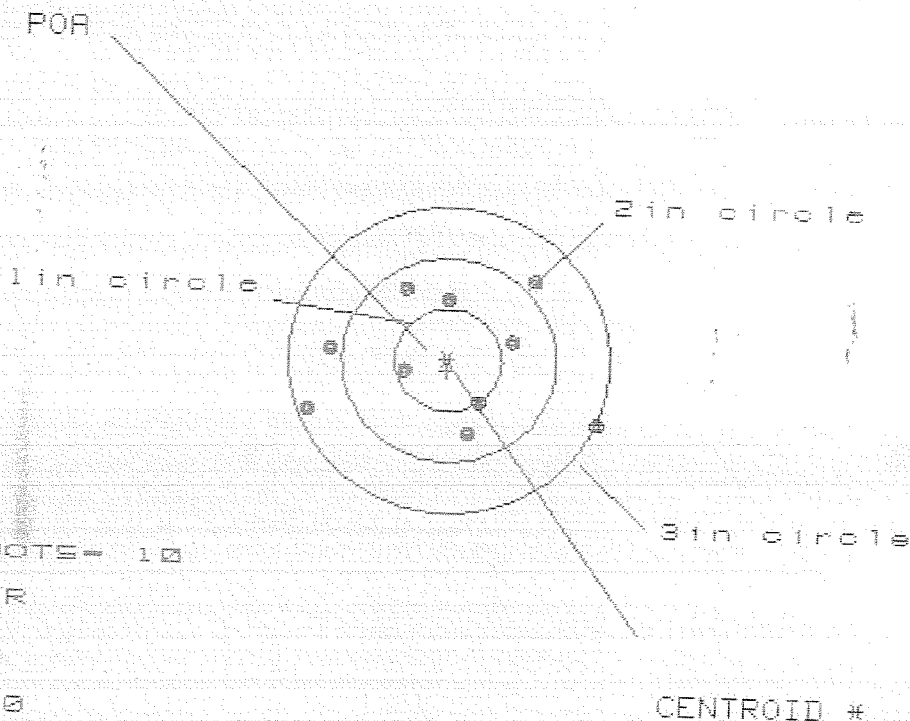
GS = 4.120

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.932	1.690	1.754
MINIMUM X	-2.178	-1.100	-0.969
MAXIMUM Y	.625	.574	.544
MINIMUM Y	-.536	-.587	-.617
CENTROID X	-.021	.221	.010
CENTROID Y	-.003	.043	.078
POA TO CENTROID in.	.021	.226	.078
MIN RADIUS	.252	.240	.229
MEAN RADIUS	1.058	.943	.800
MAX RADIUS	2.227	1.706	1.837
HORIZONTAL SPREAD	4.110	2.870	2.723
VERTICAL SPREAD	1.161	1.161	1.161
EXTREME SPREAD	4.120	2.960	2.960
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	7		

11 Jan 1968

FILE:/PATTERNING/CENTERFIRE_PATT/C6348915

CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1 in = 2

2 in = 6

3 in = 10

HS = 2.644

VS = 1.512

GS = 2.647

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.372	.923	.783
MINIMUM X	-1.272	-1.119	-1.083
MAXIMUM Y	.759	.693	.626
MINIMUM Y	-.753	-.819	-.886
CENTROID X	.010	-.143	-.003
CENTROID Y	.104	.170	.237
POA TO CENTROID in.	.105	.222	.237
MIN RADIUS	.460	.328	.483
MEAN RADIUS	.869	.790	.721
MAX RADIUS	1.493	1.241	1.086
HORIZONTAL SPREAD	2.644	2.042	1.866
VERTICAL SPREAD	1.512	1.512	1.512
EXTREME SPREAD	2.647	2.383	1.992
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		10	

11 Jan 1988

FILE: PATTERNING/CENTERFIRE_PATT/C8348315

CENTERFIRE PATTERNS

3

POA

1 in circle

2 in circle

3 in circle

OF SHOTS = 10

IN CIR

1 in = 2

2 in = 6

3 in = 8

HS = 2.599

VS = 3.080

GS = 3.150

CENTROID #

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.004	.934	.726
MINIMUM X	-1.595	-1.665	-.564
MAXIMUM Y	1.727	1.223	1.046
MINIMUM Y	-1.353	-1.161	-1.238
CENTROID X	-.111	-.041	.167
CENTROID Y	.152	-.040	.037
POA TO CENTROID in.	.188	.057	.171
MIN RADIUS	.251	.086	.303
MEAN RADIUS	.996	.874	.748
MAX RADIUS	1.037	1.775	1.262
HORIZONTAL SPREAD	2.599	2.599	1.290
VERTICAL SPREAD	3.080	2.284	2.284
EXTREME SPREAD	3.150	2.944	2.284
NUMBER IN ONE INCH CIRCLE	=	2	
NUMBER IN TWO INCH CIRCLE	=	6	
NUMBER IN THREE INCH CIRCLE	=	8	

11 Jan 1900

FILE:/PATTERNING/CENTERFIRE_PATT/C8348915

CENTERFIRE PATTERNS

4

POA

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 6

2 in = 7

3 in = 9

HS= 3.070

VS= 1.833

GS= 3.274

CENTROID *

PATTERN #

4

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.903

.524

.405

MINIMUM X

-1.167

-.956

-.249

MAXIMUM Y

1.196

1.129

1.187

MINIMUM Y

-.637

-.704

-.646

CENTROID X

.205

.006

.114

CENTROID Y

-.009

.053

.000

POA TO CENTROID in.

.206

.114

.114

MIN RADIUS

.223

.257

.201

MEAN RADIUS

.725

.567

.482

MAX RADIUS

1.997

1.129

1.197

HORIZONTAL SPREAD

3.070

1.480

.654

VERTICAL SPREAD

1.833

1.833

1.833

EXTREME SPREAD

3.274

1.917

1.917

NUMBER IN ONE INCH CIRCLE =

6

NUMBER IN TWO INCH CIRCLE =

7

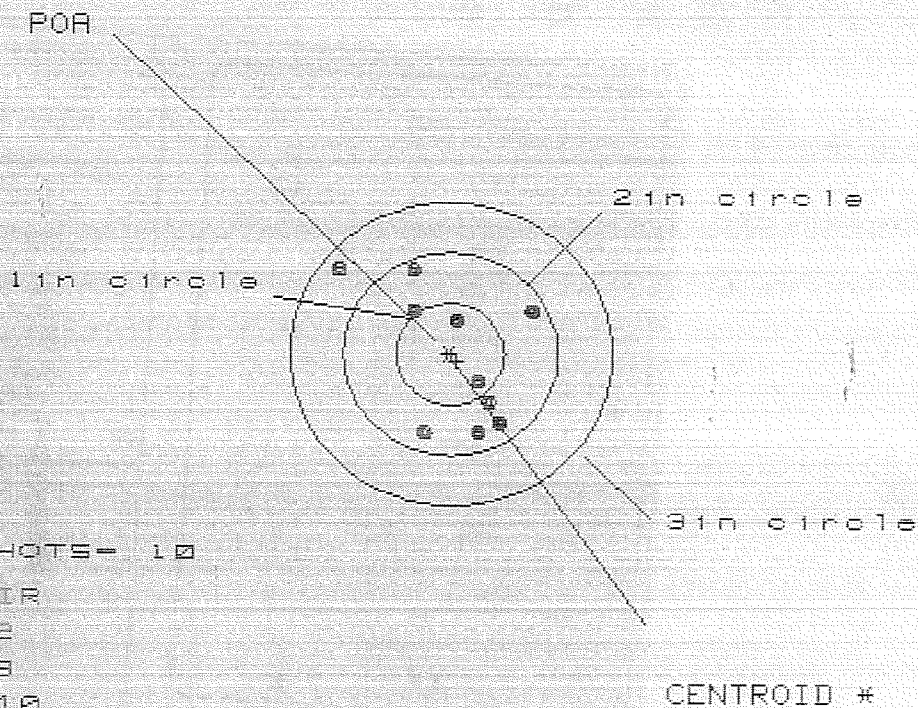
NUMBER IN THREE INCH CIRCLE =

9

11 Jan 1968

FILE:/PATTERNING/CENTERFIRE_PATT/C634B915

CENTERFIRE PATTERNS # 5



OF SHOTS = 10

IN CIR

1in = 2

2in = 9

3in = 10

HS = 1.814

VS = 1.641

GS = 2.115

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	.723
MINIMUM X	-1.091
MAXIMUM Y	.861
MINIMUM Y	-1.700
CENTROID X	-.057
CENTROID Y	.063
POA TO CENTROID in.	.090
MIN RADIUS	.354
MEAN RADIUS	.740
MAX RADIUS	1.349
HORIZONTAL SPREAD	1.814
VERTICAL SPREAD	1.641
EXTREME SPREAD	2.115
NUMBER IN ONE INCH CIRCLE	2
NUMBER IN TWO INCH CIRCLE	9
NUMBER IN THREE INCH CIRCLE	10

Remington
MODEL 700™ M24

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

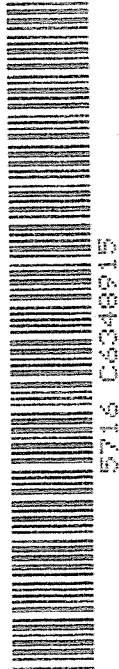
VERY IMPORTANT:
Instruction Book
enclosed to assure
safe use of this
firearm.

SERIAL NO.
C6348915

ORDER NO.
5716

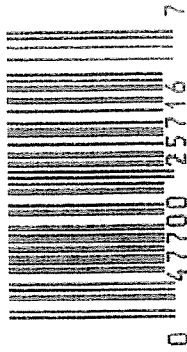
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat & Tm. Off. Marca Registrada Marque Deposee.

01



5716 C6348915

LPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6348915

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		300/89	928

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			10/3/89	RL
	G) Safety Off Force	3	3	3			10/3/89	RL
	H) Trigger Pull Test & Retainability						30/89	RL
	I) Firing Pin Indent	0.0205	0.0205	0.0205			10/3/89	RL
	J) Assemble Stock						10/3/89	RL
	K) Assemble Swivel Studs						14/89	RL
	L) Attach Front and Rear Sight Assemblies						10/12/89	RL
	M) Iron Sight Alignment						10/12/89	RL
	N) Detach Front & Rear Sights & place in numbered container						10/12/89	RL
	O) Attach Scope to Rifle						10/12/89	RL
	P) Detach & Attach Scope 20 Times						10/12/89	RL
640	Gallery Target & Test						10-13-89	DH
	A) Time						10-13-89	DH
	B) Malfunctions						10-13-89	DH
	C) Pierced Primers						10-13-89	DH
	D) Optical Clarity of Scope						10-13-89	DH
645	Inspect for Live Ammo						10-13-89	DH
655	Final Inspection						14/89	RL
	A) Headspace						14/89	RL
	B) Trigger Pull	2.37	2.39	2.50	2.48	2.31	14/89	RL
	C) Function						14/89	RL
660	Pack						15/89	RL

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. CG348915
66349039DATE 2-6-90TESTER JLL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.44	2.40	2.25		MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.24	2.23	2.30		
PULL #3	2.30	2.25	2.41		
PULL #4	2.28	2.18	2.23		
PULL #5	2.37	2.15	2.36		
TOTAL	11.63	11.21	11.55		
AVG.	2.326	2.242	2.31		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.30	3.25		
PULL #2	3.37	3.30		
PULL #3	3.36	3.34		
PULL #4	3.41	3.40		
PULL #5	3.30	3.32		
TOTAL	16.74	16.61		
AVG.	3.348	3.322		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.27	4.30		4.11
PULL #2	4.17	4.20		4.33
PULL #3	4.34	4.25		4.16
PULL #4	4.20	4.35		4.27
PULL #5	4.22	4.21		4.22
TOTAL	21.20	21.31		21.09
AVG.	4.24	4.262		4.218

MOD.		GA. CAL.	GUN #	ASSEM. #
#	TEST	DATE	MALFUNCTION/DEFECT	
	1st	10/13/89	shave Brass + don't eject	DW
	2nd	10/23/89	Ream Ejector Hole Polish Ejector	RW
	3rd	10/23/89	100 Rds OK	A
	4th			
FUNCTION			RD 6654	Rev 1

TEST INIT. ACTION TO CORRECT		ASSEM. #
PROOF		
TEST		
TGT		
PROOF		
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06348915
13 Oct 1989

CENTROIDAL DISTANCES

0 TO	1	.13327
1 TO	2	.310474
1 TO	3	.163267
1 TO	4	.347816
1 TO	5	.407296

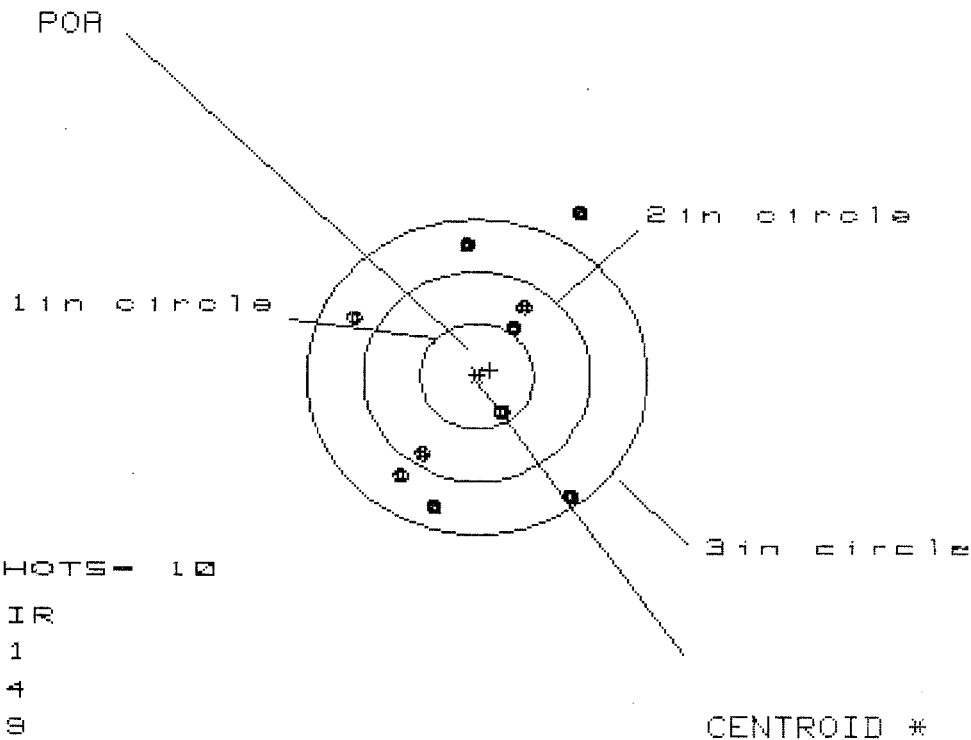
$\frac{8.4}{31}$ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.2022
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0936
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .222813
THE AMR FOR THIS RIFLE IS: 1.022

13 Oct 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C634B315

CENTERFIRE PATTERNS # 1



OF SHOTS - 10

IN CIR

1 in = 1

2 in = 4

3 in = 9

HS = 2.056

VS = 2.748

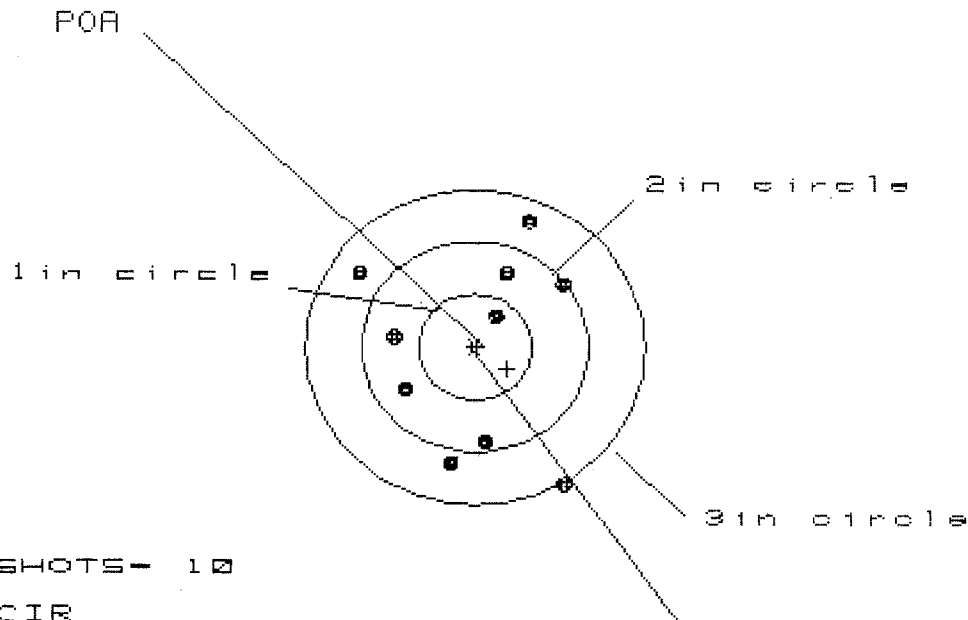
GS = 3.054

PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.960	.881	.586
MINIMUM X	:	-1.097	-.990	-.880
MAXIMUM Y	:	1.554	1.473	1.349
MINIMUM Y	:	-1.194	-1.021	-1.145
CENTROID X	:	-.119	-.225	-.335
CENTROID Y	:	-.060	-.233	-.109
POA TO CENTROID in.	:	.133	.324	.353
MIN RADIUS	:	.457	.417	.577
MEAN RADIUS	:	1.078	.979	.941
MAX RADIUS	:	1.827	1.474	1.360
HORIZONTAL SPREAD	:	2.056	1.871	1.466
VERTICAL SPREAD	:	2.748	2.494	2.494
EXTREME SPREAD	:	3.054	2.596	2.516
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	4		
NUMBER IN THREE INCH CIRCLE	=	9		

13 Oct 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C6348915

CENTERFIRE PATTERNS # 2



OF SHOTS - 10

IN CIR

1 in = 1

2 in = 6

3 in = 9

HS = 1.761

VS = 2.544

GS = 2.672

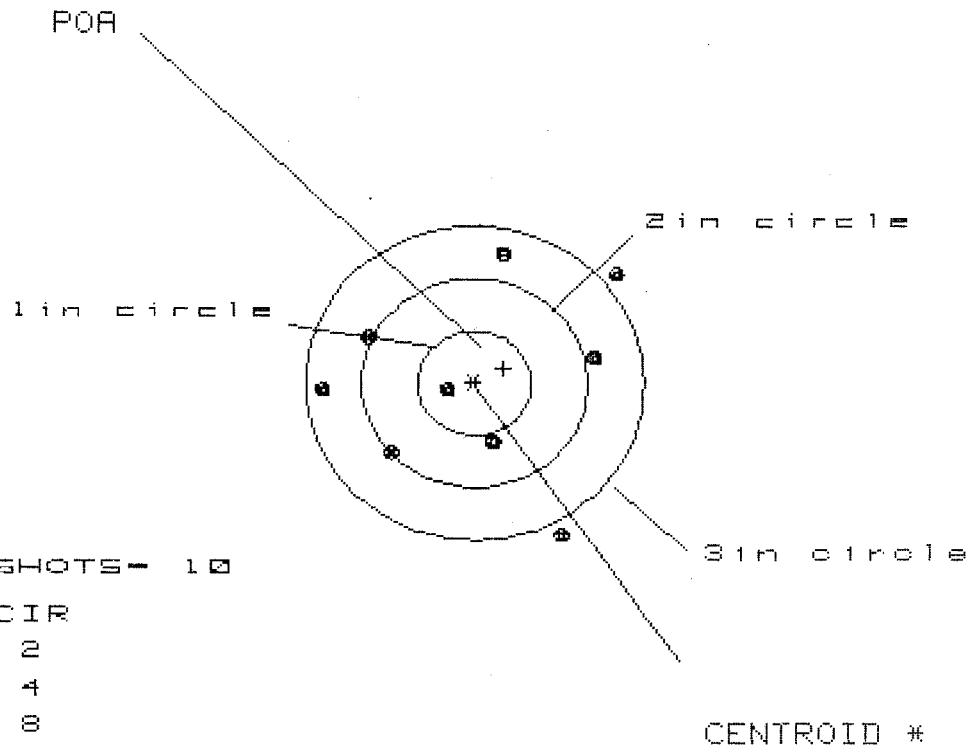
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.752	.818	.890
MINIMUM X	:	-1.009	-.925	-.853
MAXIMUM Y	:	1.224	1.077	.719
MINIMUM Y	:	-1.320	-1.201	-1.066
CENTROID X	:	-.284	-.368	-.440
CENTROID Y	:	.203	.350	.215
POA TO CENTROID in.	:	.349	.507	.490
MIN RADIUS	:	.366	.336	.469
MEAN RADIUS	:	.956	.874	.827
MAX RADIUS	:	1.519	1.223	1.089
HORIZONTAL SPREAD	:	1.761	1.743	1.743
VERTICAL SPREAD	:	2.544	2.278	1.785
EXTREME SPREAD	:	2.672	2.400	1.943
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 3



OF SHOTS - 10

IN CIR

1 in = 2

2 in = 4

3 in = 8

HS = 2.660

VS = 2.737

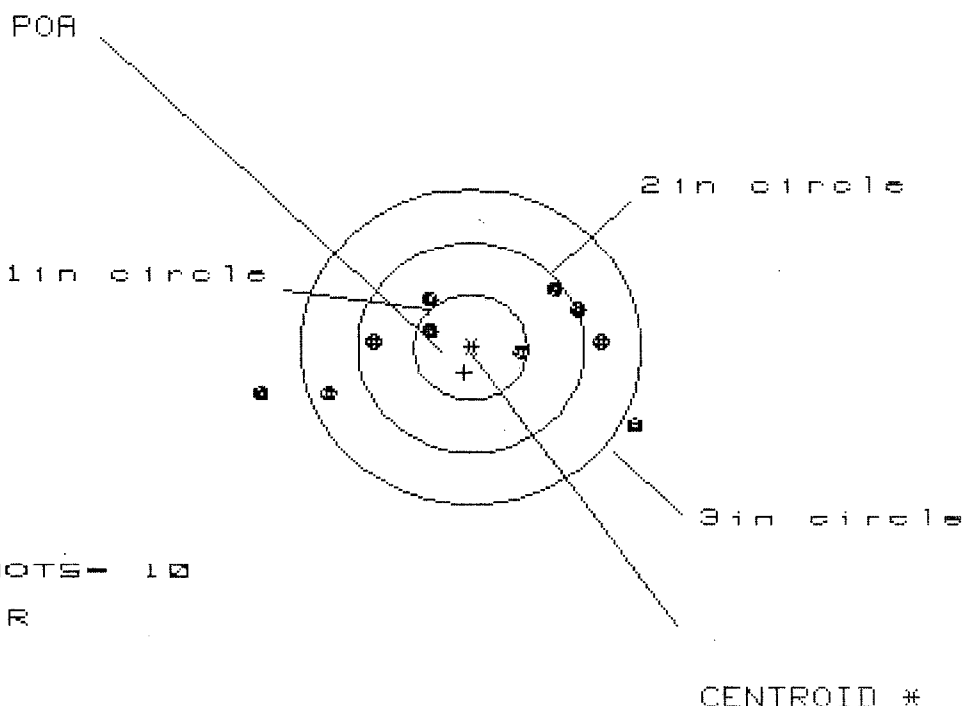
GS = 2.879

PATTERN #	:	3
SHOTS (BEST OF)	:	10
MAXIMUM X	:	1.296
MINIMUM X	:	-1.364
MAXIMUM Y	:	1.236
MINIMUM Y	:	-1.501
CENTROID X	:	-.259
CENTROID Y	:	-.144
POA TO CENTROID in.	:	.296
MIN RADIUS	:	.217
MEAN RADIUS	:	1.013
MAX RADIUS	:	1.677
HORIZONTAL SPREAD	:	2.660
VERTICAL SPREAD	:	2.737
EXTREME SPREAD	:	2.879
NUMBER IN ONE INCH CIRCLE =	:	2
NUMBER IN TWO INCH CIRCLE =	:	4
NUMBER IN THREE INCH CIRCLE =	:	8

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CENTERFIRE PATTERNS # 4



* OF SHOTS- 10

IN CIR

1 in = 2

2 in = 5

3 in = 8

HS= 3.324

VS= 1.281

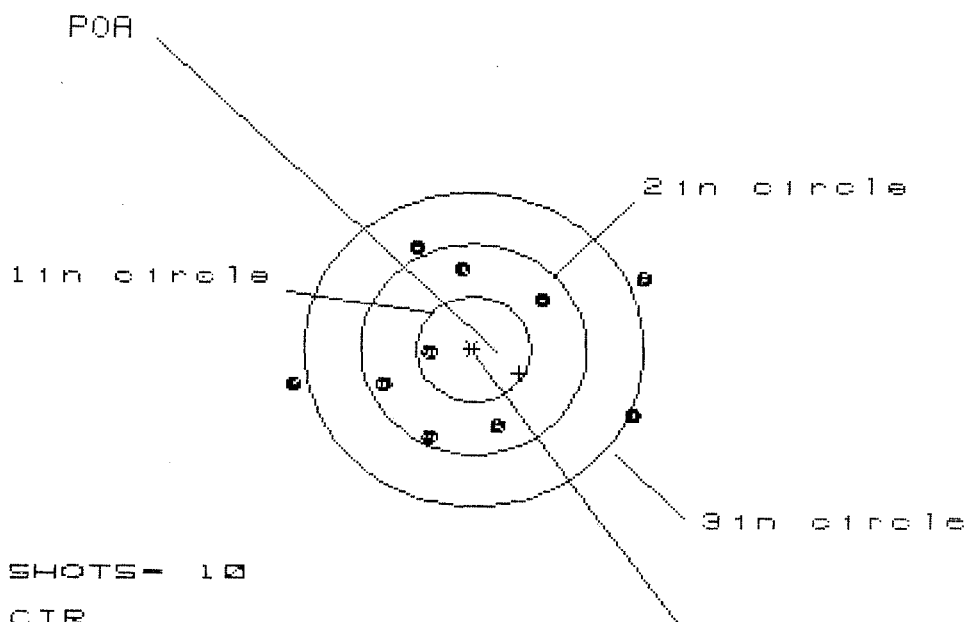
GS= 3.337

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.474	1.268	1.047
MINIMUM X	:	-1.850	-1.471	-1.313
MAXIMUM Y	:	.543	.494	.396
MINIMUM Y	:	-.738	-.787	-.550
CENTROID X	:	.057	.263	.105
CENTROID Y	:	.240	.289	.387
POA TO CENTROID in.	:	.247	.391	.401
MIN RADIUS	:	.428	.270	.439
MEAN RADIUS	:	1.018	.894	.808
MAX RADIUS	:	1.902	1.539	1.423
HORIZONTAL SPREAD	:	3.324	2.739	2.360
VERTICAL SPREAD	:	1.281	1.281	.946
EXTREME SPREAD	:	3.337	2.759	2.410
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in - 1

2in - 5

3in - 7

HS- 3.123

VS- 1.838

GS- 3.301

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.531	1.555	1.377
MINIMUM X	:	-1.592	-1.422	-.806
MAXIMUM Y	:	.996	1.075	1.039
MINIMUM Y	:	-.841	-.763	-.799
CENTROID X	:	-.406	-.576	-.399
CENTROID Y	:	.229	.151	.187
POA TO CENTROID in.	:	.466	.596	.440
MIN RADIUS	:	.381	.224	.390
MEAN RADIUS	:	1.043	.942	.889
MAX RADIUS	:	1.685	1.648	1.495
HORIZONTAL SPREAD	:	3.123	2.977	2.184
VERTICAL SPREAD	:	1.838	1.838	1.838
EXTREME SPREAD	:	3.301	2.988	2.457
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		7	