

C6348814

MODEL 700™ M24

Model SMS™

Action

Barrel Length

Capacity

Order No. 5716

*Includes 1 in chamber.

Remington.

Repair Inquiry

Repair Number: RE00169248

Serial: C6348814 Model 700 Center Fire Caliber:
7.62 NATO M-24 (SWS)

Repairman:

Status:

Closed 6/8/2009 11:24:10 AM

Verify Repair

Address Information

Customer:

☒ Received From

Return To:

☐ Received From

Name: B CO 2/7

B CO 2/7

Address 1: SFG (A)

SFG (A)

Address 2: PO Box:

PO Box:

City: FORT BRAGG

FORT BRAGG

State: NC

Zip Code: 28310

Country: US

State: NC

Zip Code: 28310

Country: US

FPL:

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
A007	With Stud	3
A010	Hard Case	1
A017	Scope Base	1
A057	Fit and Rear Sgt Base	1

Repair Search

Refresh

Close

nagletj

6/8/2009

12:04 PM

CAPS

NUM

INS

SCPIL

Serial:
Number:

C6348814

Model: 700



RE00169248

INSPECTION CHECKLIST - REPAIRS

CONTRACT #: W52H09-07-C-0207

ISSUED 10/1/2007

R & E NUMBER

169248

SERIAL NUMBER

C6348814

LOG-IN DATE

6-8-09

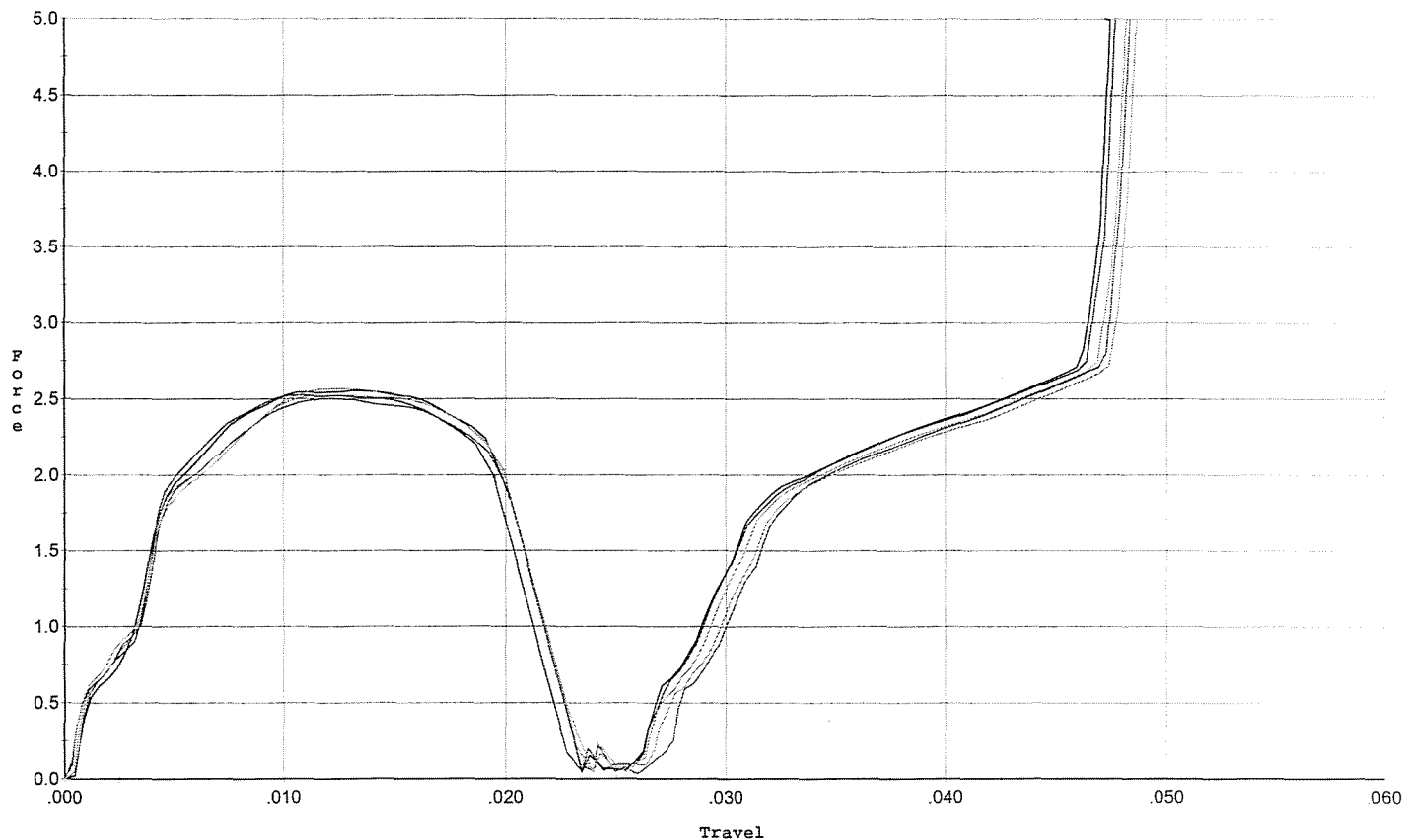
OPERATION #	OPERATION NAME	DATE	INITIAL
500	DIS-ASSEMBLE GUN	6-10-09	RTZ
505	RE-BARREL	6-11-09	RTZ
420	ASSEMBLE	6-11-09	RTZ
440	PROOF	6-11-09	RTZ
460	CHECK HEADSPACE	6-11-09	RTZ
470	DIS-ASSEMBLE GUN	6-11-09	RTZ
480	MAGNAFLUX	6/13/09	(N)
510	DRILL AND TAP	6-12-09	SP
500	ROLLMARK CALIBER	6/16/09	RTZ
520	GOFF BLAST BBL / REC	6/16	RTZ
530 & 540	APPLY COATINGS	6/17	RTZ
560	FINAL ASSEMBLY	6-19-09	RTZ
640	FUNCTION TEST AND	6-19-09	RTZ
650	TARGET	6-19-09	RTZ
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
670	FINAL INSPECTION	6-19-09	RP
	A) HEADSPACE	PASS	FAIL
	B) TRIGGER PULL	2.48 2.52 2.60 2.50 2.52	6-22-09
680	F) SAFETY ON FORCE	4.0 4.0 4.0	6-22-09
	G) SAFETY OFF FORCE	7.0 6.0 6.0	6-22-09
	I) FIRING PIN INDENT	.020 .022 .021	6-22-09
690	PACK	6/24/09	FM

F006 REV 1/2009

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R.P. 5/28/09

Model: M/24
Serial No: Form #F005
Trigger: 2.5 lbs. ini. +/- .50 lbs.



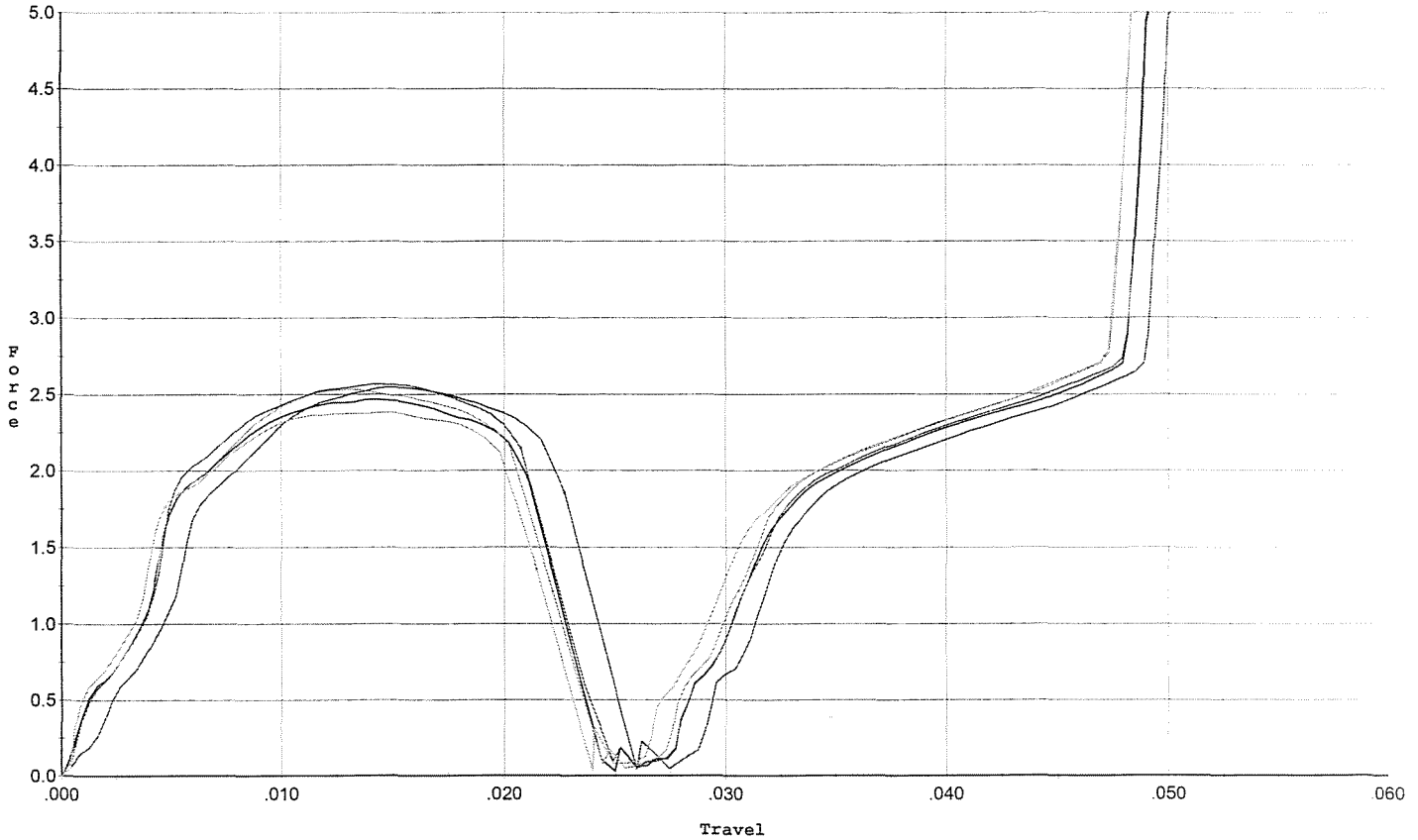
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.524	0.019	0.00	0.032	0.037		Set Trigger
2	2.555	0.020	0.00	0.031	0.038		Set Trigger
3	2.501	0.020	0.00	0.032	0.037		Set Trigger
4	2.569	0.020	0.00	0.032	0.038		Set Trigger
5	2.526	0.020	0.00	0.033	0.038		Set Trigger

Avg 2.53

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R.P. 5/28/09

Model: M/24
 Serial No: Form #F005
 Trigger: 2.5 lbs. after 50 cycles +/- .50 lbs.



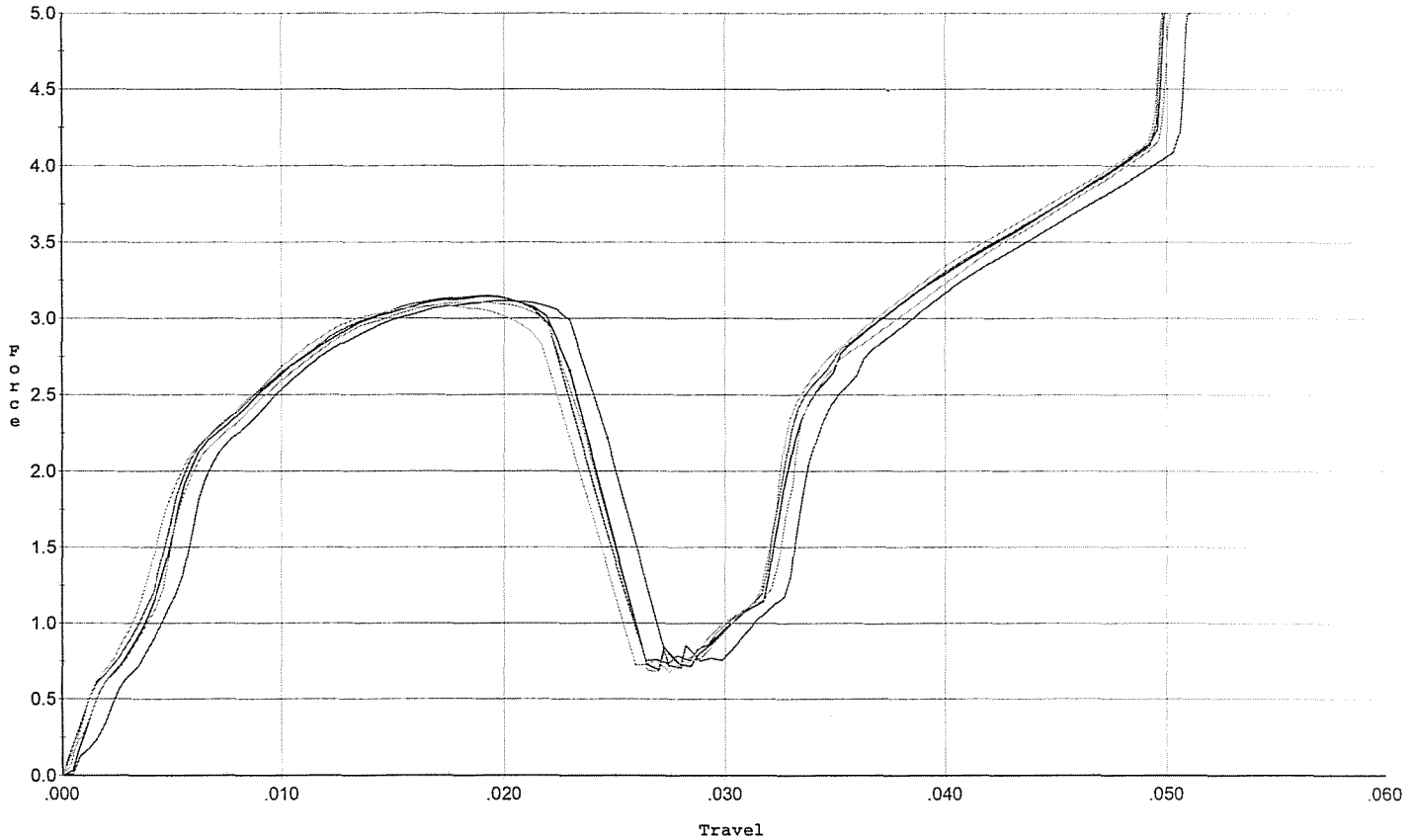
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.546	0.023	0.00	0.032	0.041		Set Trigger
2	2.466	0.021	0.00	0.032	0.038		Set Trigger
3	2.566	0.021	0.00	0.032	0.039		Set Trigger
4	2.384	0.021	0.00	0.032	0.039		Set Trigger
5	2.534	0.022	0.00	0.032	0.041		Set Trigger

Avg 2.49

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R.P. 5/28/09

Model: M/24
Serial No: Form #F005
Trigger: 3.0 lbs. ini. +/- .75 lbs.



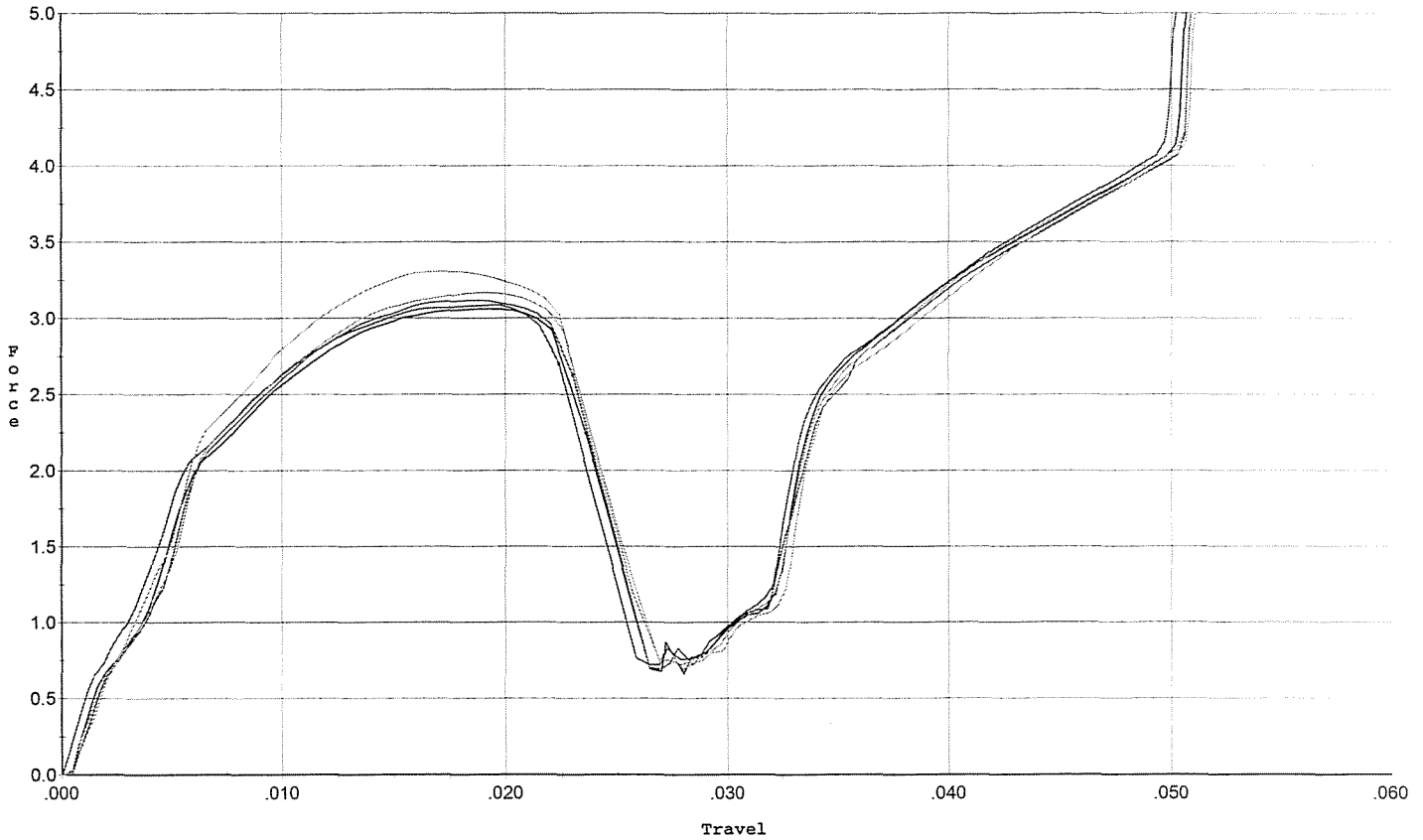
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.114	0.025	0.00	0.031	0.053		Set Trigger
2	3.145	0.023	0.00	0.031	0.051		Set Trigger
3	3.151	0.022	0.00	0.031	0.049		Set Trigger
4	3.089	0.024	0.00	0.031	0.052		Set Trigger
5	3.106	0.023	0.00	0.031	0.051		Set Trigger

Avg 3.12

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R.P. 5/28/09

Model: M/24
 Serial No: Form #F005
 Trigger: 3.0 lbs. after 20 cycles +/- .75 lbs.



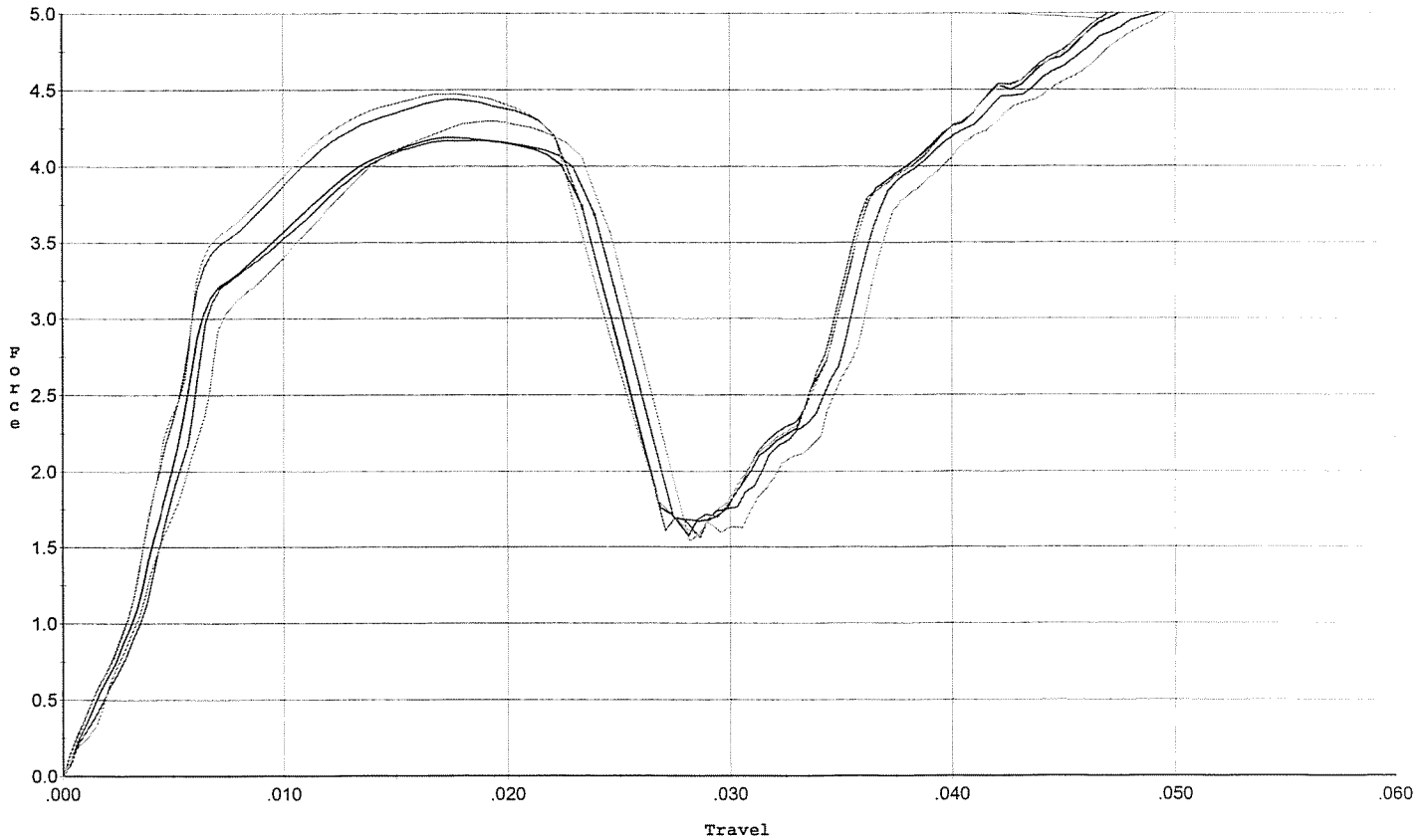
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.085	0.022	0.00	0.032	0.050		Set Trigger
2	3.060	0.024	0.00	0.032	0.051		Set Trigger
3	3.117	0.023	0.00	0.032	0.050		Set Trigger
4	3.309	0.022	0.00	0.032	0.052		Set Trigger
5	3.169	0.023	0.00	0.032	0.050		Set Trigger

Avg 3.14

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R.P. 5/28/09

Model: M/24
Serial No: Form #F005
Trigger: 4.0 lbs. ini. +/- 1.0 lbs.



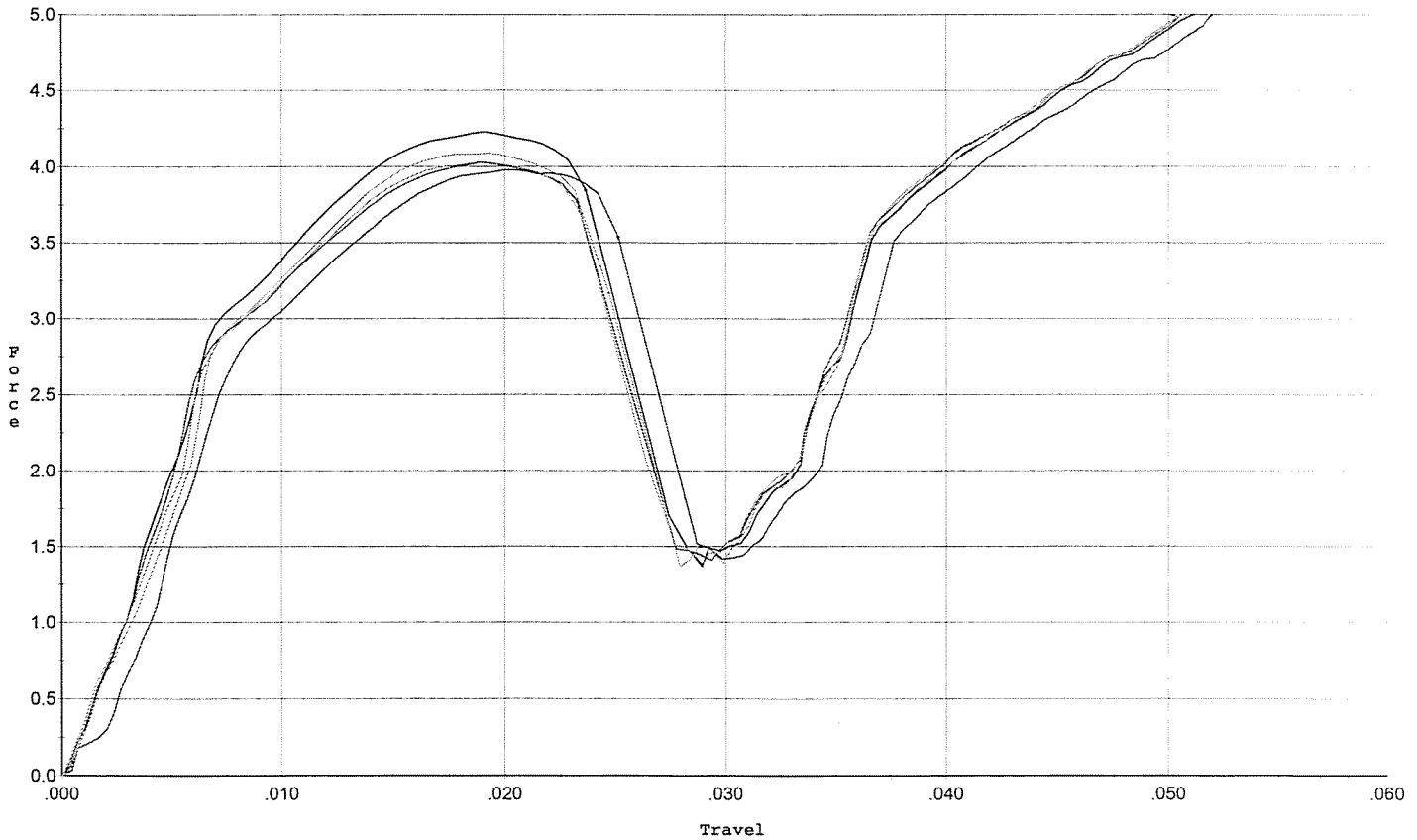
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.169	0.024	0.00	0.029	0.070		Set Trigger
2	4.187	0.023	0.00	0.029	0.068		Set Trigger
3	4.439	0.023	0.00	0.029	0.073		Set Trigger
4	4.473	0.022	0.00	0.029	0.069		Set Trigger
5	4.295	0.025	0.00	0.029	0.071		Set Trigger

Avg 4.31

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R.P. 5/28/09

Model: M/24
Serial No: Form #F005
Trigger: 4.0 lbs. after 20 cycles +/- 1.0 lbs.



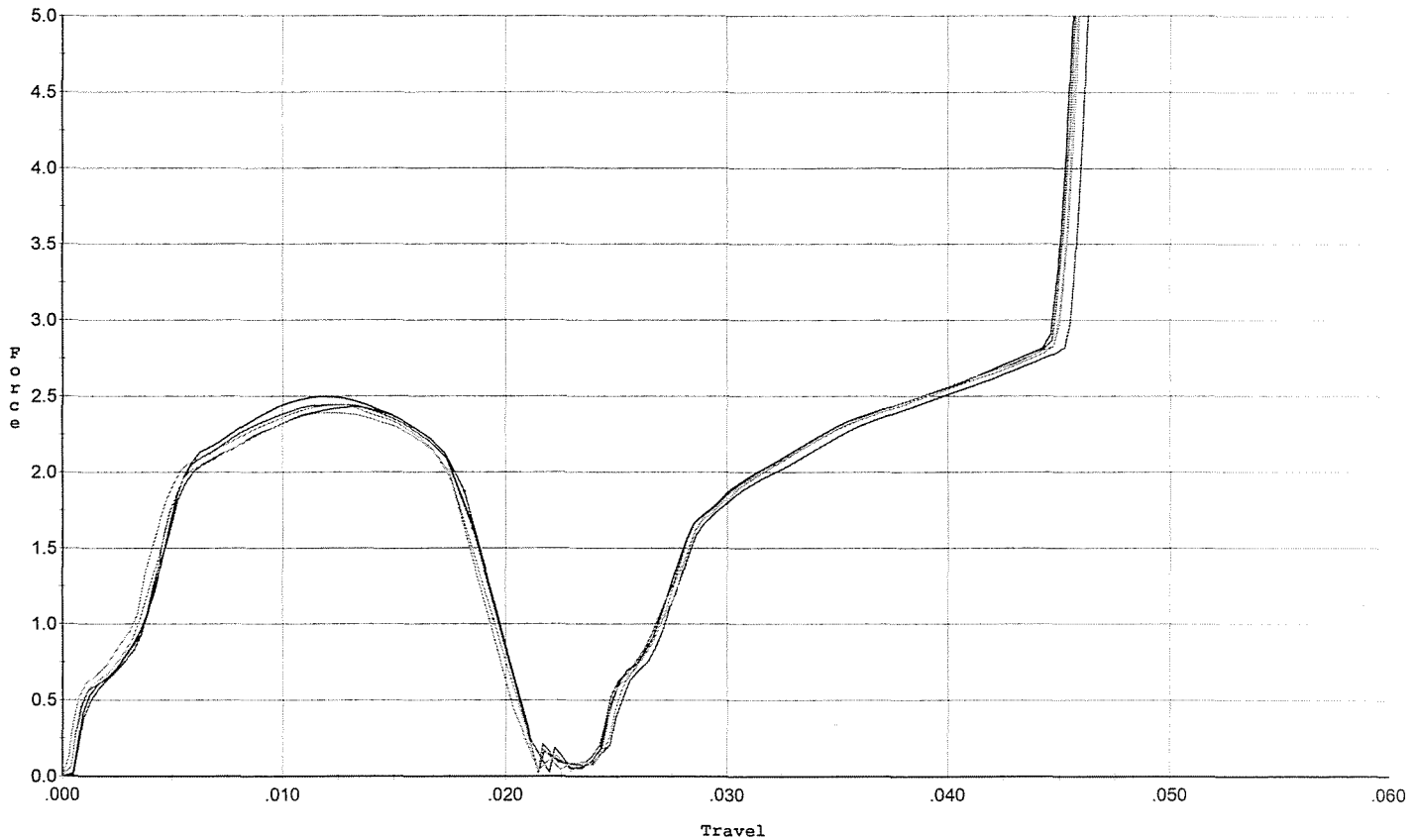
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.979	0.025	0.00	0.029	0.068		Set Trigger
2	4.226	0.024	0.00	0.029	0.069		Set Trigger
3	4.027	0.023	0.00	0.029	0.065		Set Trigger
4	4.031	0.023	0.00	0.029	0.065		Set Trigger
5	4.088	0.025	0.00	0.029	0.069		Set Trigger

Avg 4.07

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R.P. 5/28/09

Model: M/24
Serial No: Form #F005
Trigger: reset to 2.5 lbs. +/- .50 lbs. for final test



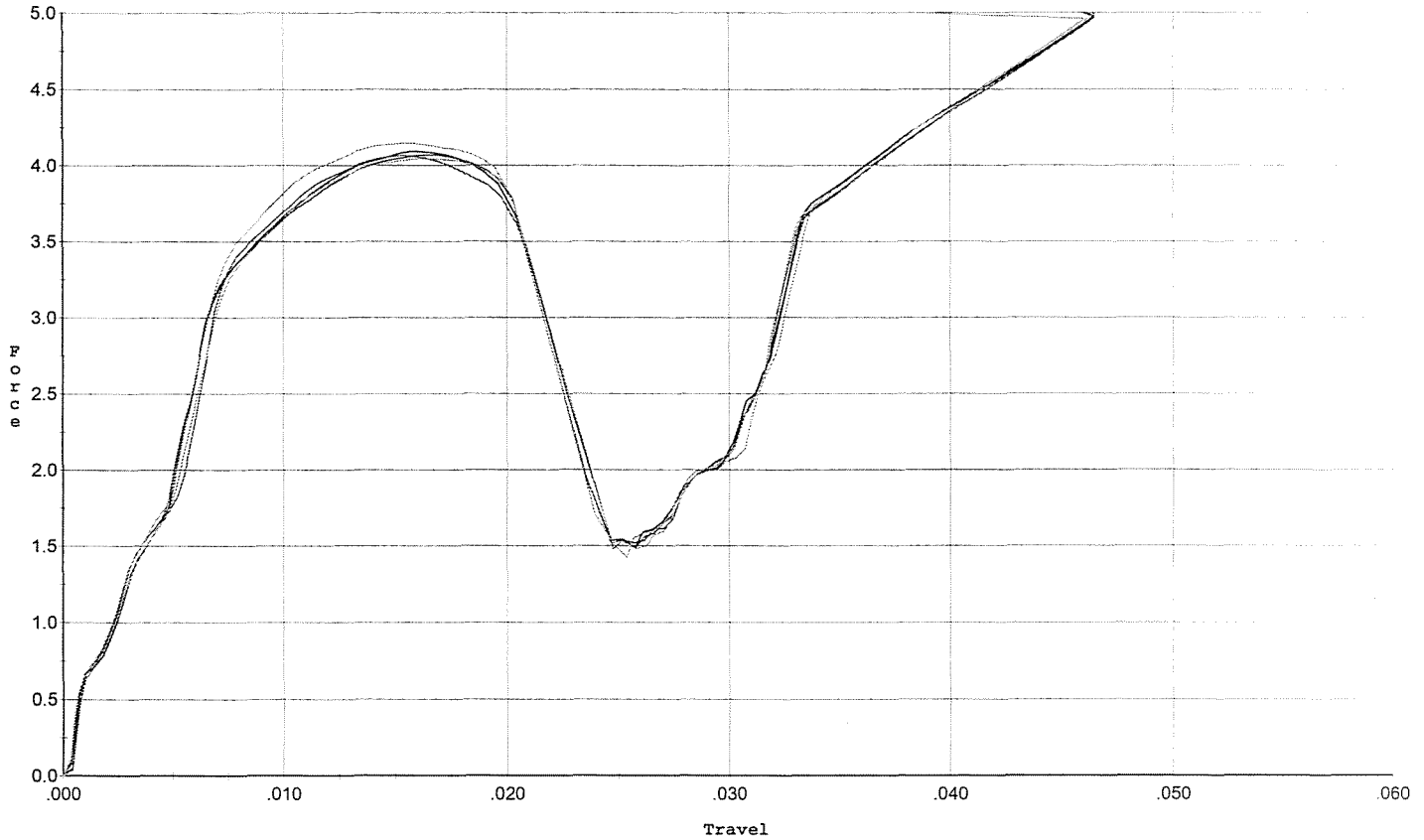
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.432	0.018	0.00	0.032	0.031		Set Trigger
2	2.497	0.018	0.00	0.031	0.033		Set Trigger
3	2.444	0.019	0.00	0.031	0.032		Set Trigger
4	2.392	0.019	0.00	0.031	0.033		Set Trigger
5	2.442	0.018	0.00	0.032	0.031		Set Trigger

Avg 2.44

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R.P. 5/28/09

Model: M/24
Serial No: Form #F005
Trigger: set to 4.0 lbs. +/- 1.0 lbs. for target & accuracy



#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.069	0.020	0.00	0.028	0.057		Set Trigger
2	4.093	0.020	0.00	0.028	0.057		Set Trigger
3	4.065	0.021	0.00	0.028	0.057		Set Trigger
4	4.045	0.022	0.00	0.028	0.063		Set Trigger
5	4.147	0.020	0.00	0.028	0.058		Set Trigger

Avg 4.08

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6348814.___0
FILE DATE AND TIME: 06/22/2009 07:41

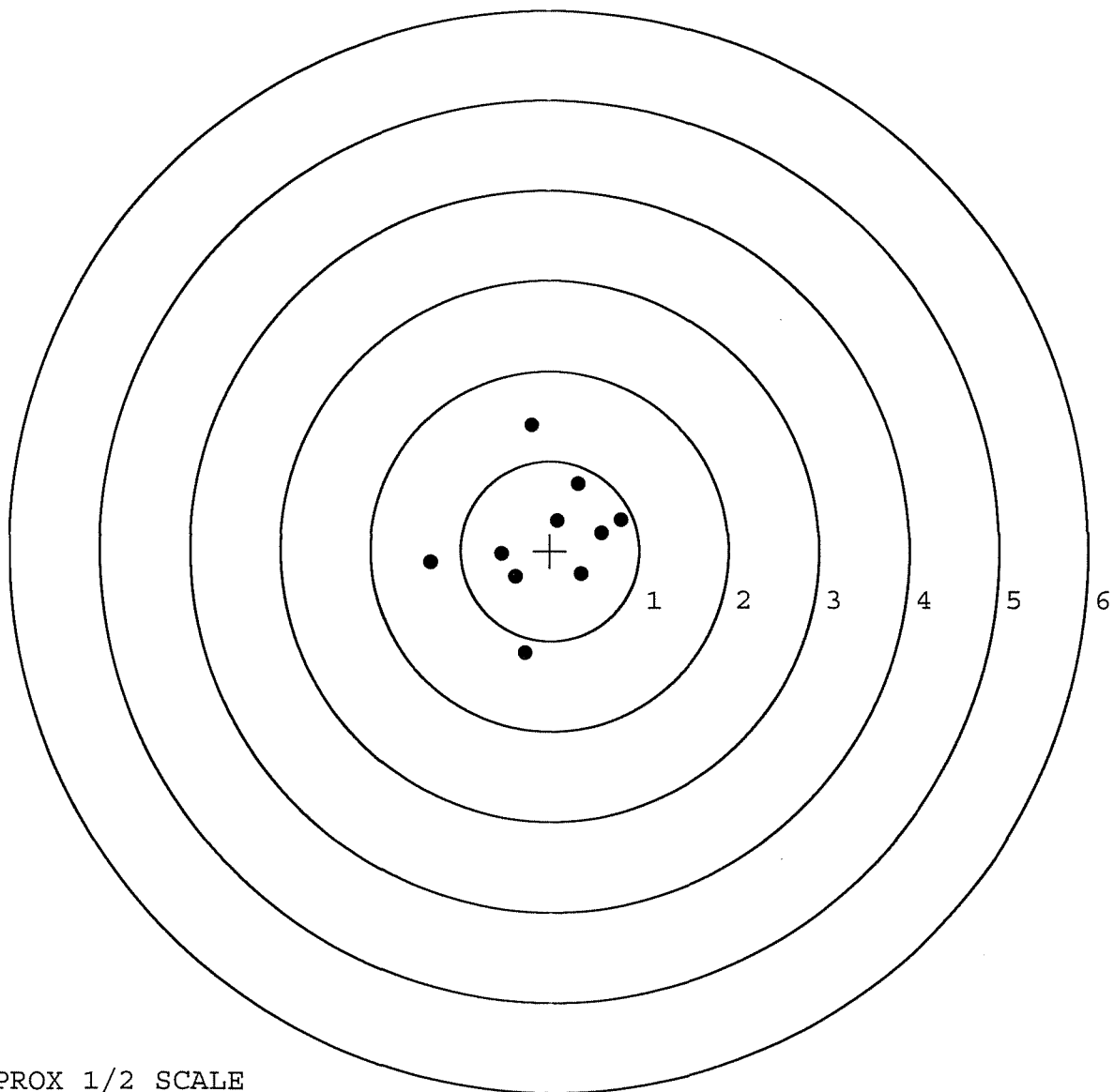
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.024
The Average Y Centroid of the Five Target Set:	-0.031
The Average Point of Impact of the Five Target Set:	0.039
The Average Mean Radius of the Five Target Set:	0.604
The Distance from POA to Centroid Target #1:	0.133
The Distance from Centroid Target #2 to Centroid Target #1:	0.066
The Distance from Centroid Target #3 to Centroid Target #1:	0.121
The Distance from Centroid Target #4 to Centroid Target #1:	0.215
The Distance from Centroid Target #5 to Centroid Target #1:	0.382

SERIAL NUMBER: C6348814. 0
 TARGET NUMBER: 1
 FILE DATE: 06/22/2009
 FILE TIME: 07:41

X CENTROID: -0.061
 Y CENTROID: 0.118
 POA TO CENTROID: 0.133
 HORZ SPREAD: 2.140
 VERT SPREAD: 2.531
 GROUP SPREAD: 2.195
 MIN RADIUS: 0.263
 MAX RADIUS: 1.301
 MEAN RADIUS: 0.799
 # IN 1 IN DIAMETER: 1
 # IN 2 IN DIAMETER: 7
 # in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.202	1.394
2:	0.326	0.752
3:	0.088	0.335
4:	0.803	0.353
5:	0.581	0.201
6:	0.347	-0.257
7:	-0.282	-1.137
8:	-0.387	-0.292
9:	-0.546	-0.035
10:	-1.337	-0.134

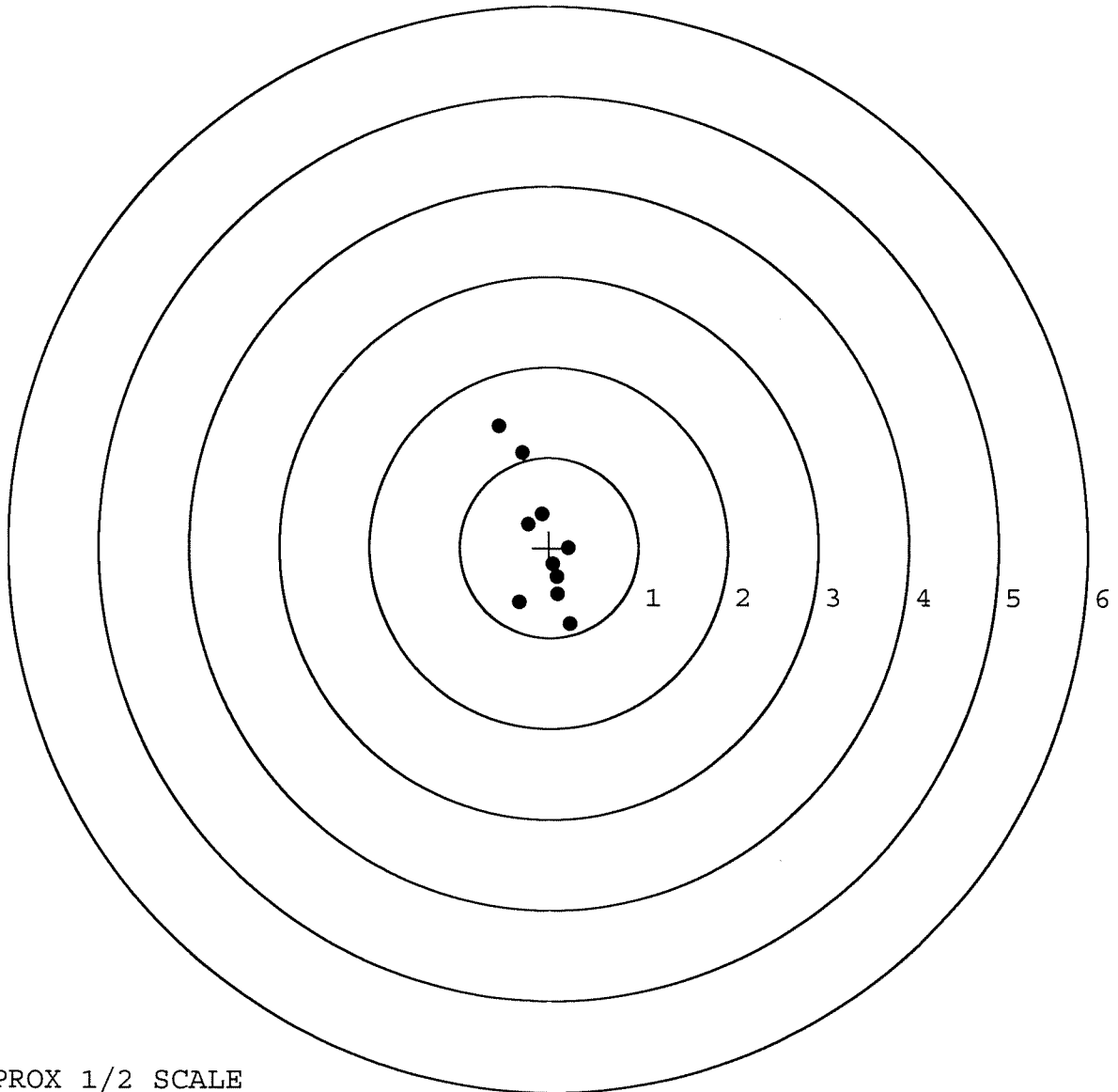


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6348814.____0
 TARGET NUMBER: 2
 FILE DATE: 06/22/2009
 FILE TIME: 07:41

X CENTROID: -0.084
 Y CENTROID: 0.056
 POA TO CENTROID: 0.100
 HORZ SPREAD: 0.796
 VERT SPREAD: 2.193
 GROUP SPREAD: 2.333
 MIN RADIUS: 0.257
 MAX RADIUS: 1.372
 MEAN RADIUS: 0.623
 # IN 1 IN DIAMETER: 5
 # IN 2 IN DIAMETER: 8
 # in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.560	1.342
2:	-0.300	1.049
3:	-0.335	-0.610
4:	0.236	-0.851
5:	0.094	-0.514
6:	0.043	-0.181
7:	0.215	0.000
8:	-0.081	0.380
9:	-0.237	0.262
10:	0.089	-0.321



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6348814. 0

TARGET NUMBER: 3

FILE DATE: 06/22/2009

FILE TIME: 07:41

X CENTROID: -0.051

Y CENTROID: -0.003

POA TO CENTROID: 0.051

HORZ SPREAD: 1.539

VERT SPREAD: 1.668

GROUP SPREAD: 2.049

MIN RADIUS: 0.249

MAX RADIUS: 1.293

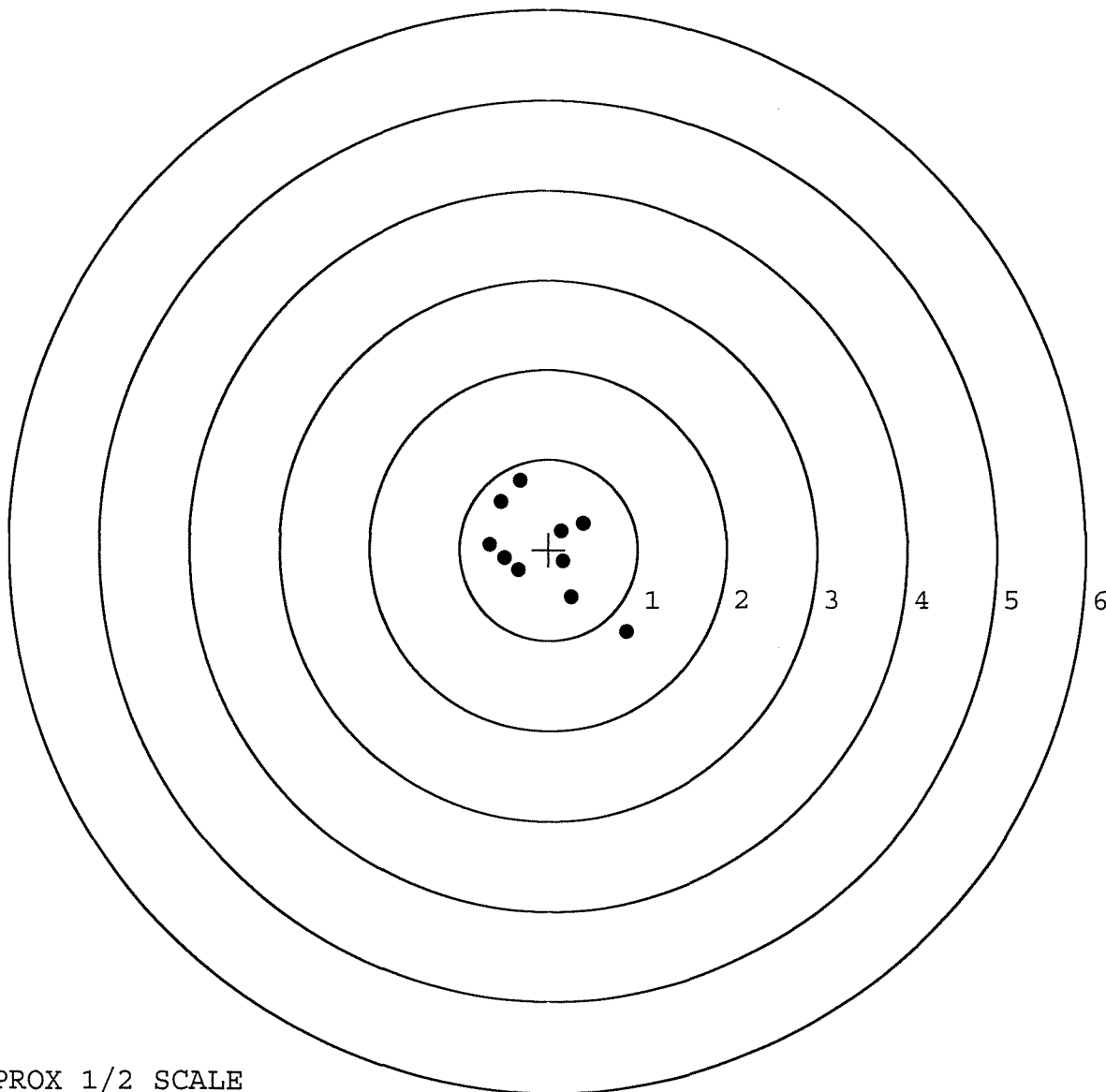
MEAN RADIUS: 0.595

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.314	0.764
2:	-0.529	0.528
3:	-0.663	0.055
4:	-0.500	-0.094
5:	0.396	0.298
6:	0.147	0.210
7:	0.164	-0.128
8:	0.257	-0.526
9:	0.876	-0.904
10:	-0.343	-0.229

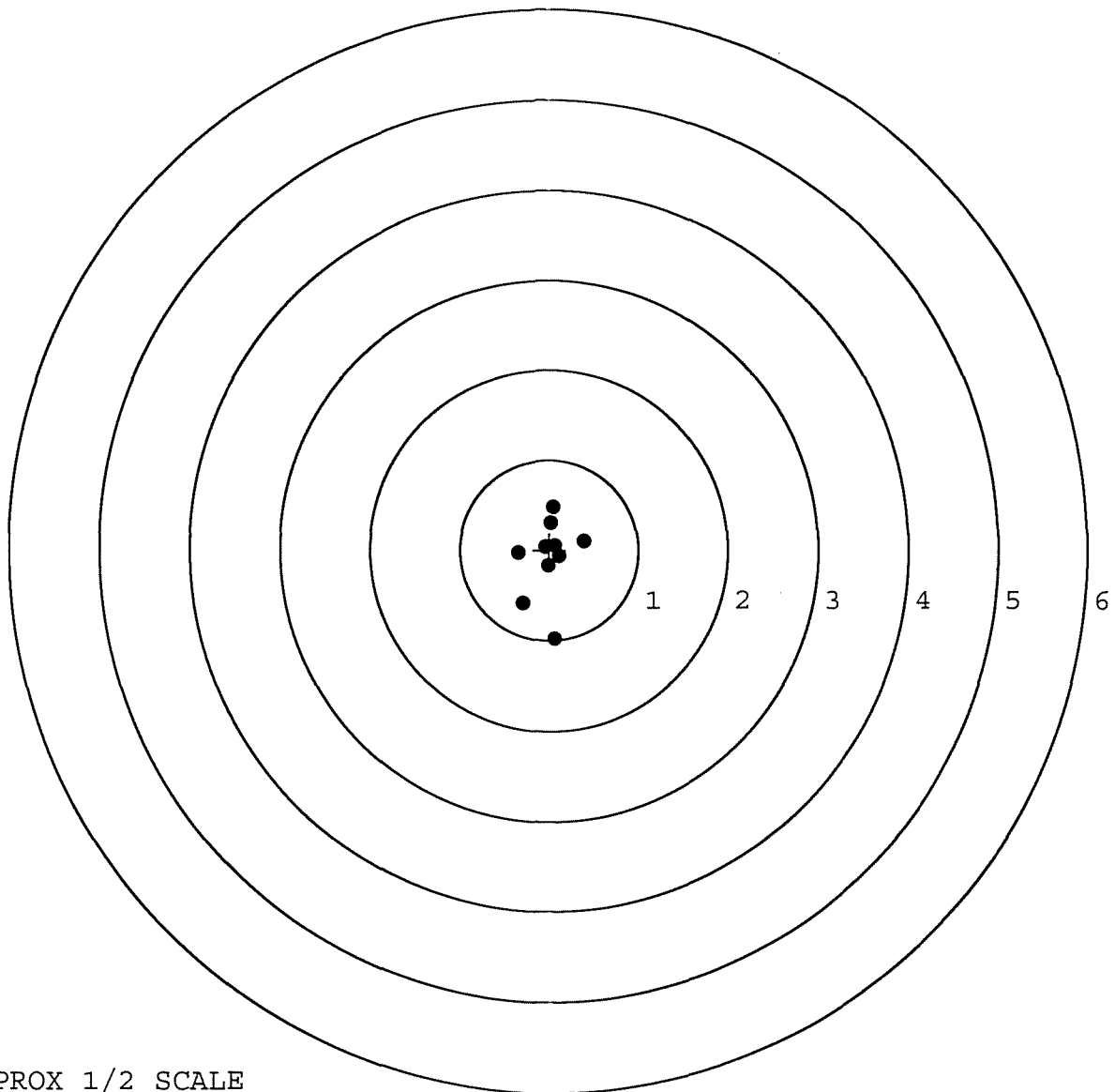


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6348814. 0
 TARGET NUMBER: 4
 FILE DATE: 06/22/2009
 FILE TIME: 07:41

X CENTROID: -0.002
 Y CENTROID: -0.089
 POA TO CENTROID: 0.089
 HORZ SPREAD: 0.744
 VERT SPREAD: 1.470
 GROUP SPREAD: 1.470
 MIN RADIUS: 0.091
 MAX RADIUS: 0.904
 MEAN RADIUS: 0.373
 # IN 1 IN DIAMETER: 7
 # IN 2 IN DIAMETER: 10
 # in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.061	-0.991
2:	-0.297	-0.588
3:	-0.351	-0.032
4:	-0.016	-0.179
5:	0.112	-0.068
6:	0.393	0.106
7:	0.051	0.479
8:	-0.051	0.038
9:	0.021	0.300
10:	0.061	0.047

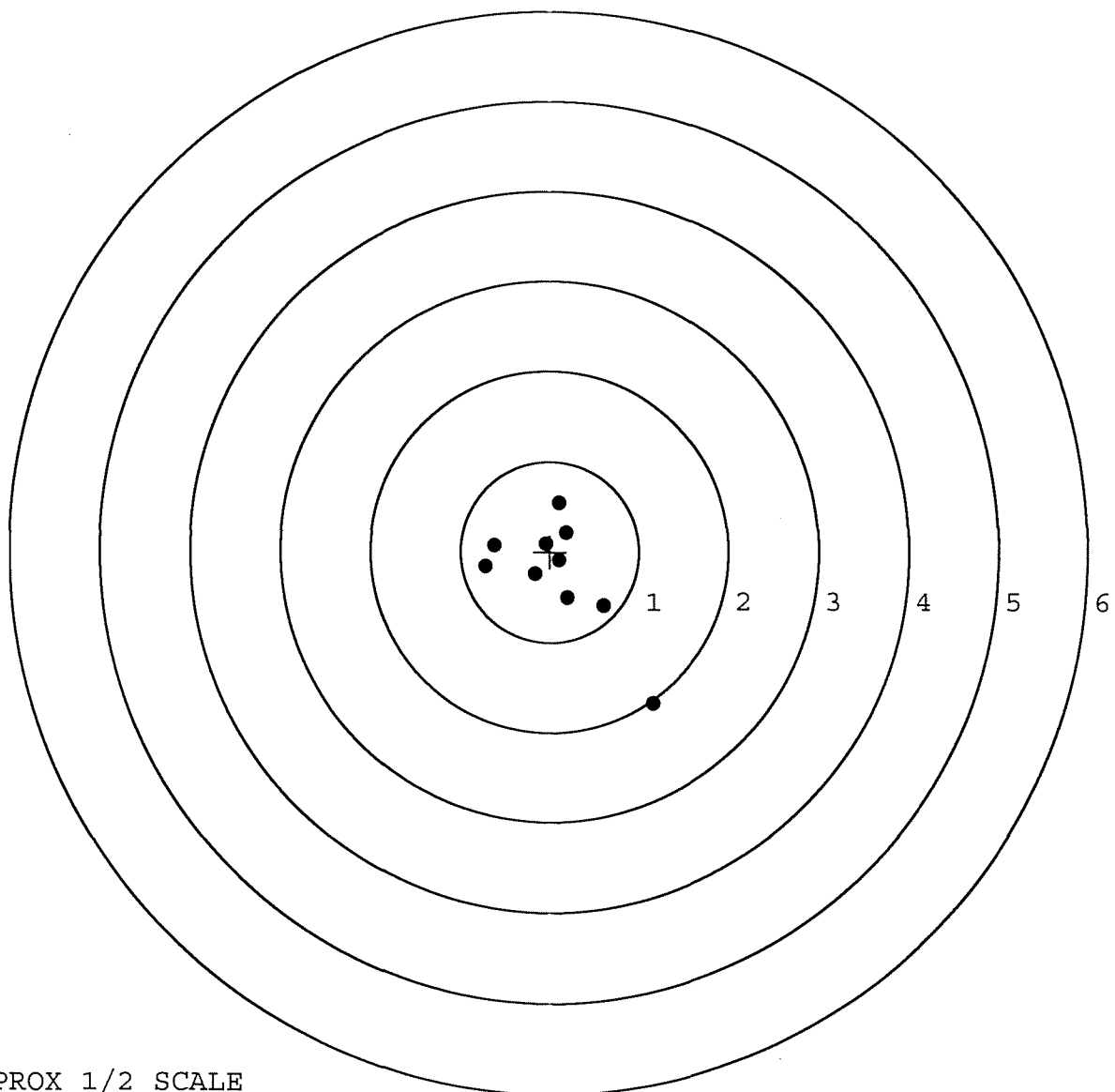


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6348814. 0
 TARGET NUMBER: 5
 FILE DATE: 06/22/2009
 FILE TIME: 07:41

X CENTROID: 0.079
 Y CENTROID: -0.238
 POA TO CENTROID: 0.251
 HORZ SPREAD: 1.882
 VERT SPREAD: 2.219
 GROUP SPREAD: 2.496
 MIN RADIUS: 0.141
 MAX RADIUS: 1.798
 MEAN RADIUS: 0.630
 # IN 1 IN DIAMETER: 5
 # IN 2 IN DIAMETER: 9
 # in 3 IN DIAMETER: 9

POINT#	X	Y
1:	1.161	-1.674
2:	0.606	-0.595
3:	0.197	-0.512
4:	-0.721	-0.173
5:	-0.621	0.073
6:	0.111	0.545
7:	0.181	0.216
8:	-0.049	0.091
9:	-0.172	-0.249
10:	0.101	-0.098



TARGET APPROX 1/2 SCALE

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: **RE00042736** Serial: C6348814 Model 700 Center Fire Caliber: 7.62 NATO M-24 (SWS) Repairman: Status: Closed 3/4/02 4:39:55 PM

Verify Repair

Address Information

Customer: ☒ Received From Return To: ☐ Received From

Name: **COMMANDER** **COMMANDER**

Address 1: **HSC 2/7 SFG (A)** **HSC 2/7 SFG (A)**

Address 2: PO Box: PO Box:

City: **FORT BRAGG** **FORT BRAGG**

State: **NC** Zip Code: **28310** Country: **US** State: **NC** Zip Code: **28310** Country: **US**

FFL: ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐

Contact / Condition Problems Estimate History / Status Shipping / Billing

Contact Information

Phone:

Fax:

Email:

Comments:

Received Condition

Pool:

Condition Notes:

CSR Notes:

Accessories Received

Code	Desc	Qty
A007	With Stud	1
A010	Hard Case	1
A017	Scope Base	1
A026	Scope	1

Repair Search Refresh Close

raglet 3/11/02 6:48 AM CAPS NUM NS SCFL

Start Inbox - Microsoft Outlook Arms Services Repair 6:48 AM

Serial Number: **C6348814**

Model: **700**



RE00042736

M-24 INSPECTION CHECKLIST CONTRACT #: DAAE-20-97-C-242

R & E NUMBER 42736

SERIAL NUMBER C6348814

LOG-IN DATE 3/4/02

INSPECT AND VERIFY:			
OPERATION #	OPERATION NAME	DATE	INITIAL
550	DIS-ASSEMBLE GUN	3/16/02	RK
560 A	RE-BARREL AT CUSTOM SHOP	3/18/02	BWT
B	DRILL AND TAP	3/18/02	BWT
C	POLISH		
575	ASSEMBLE	3/18/02	RK
600	PROOF	3/18/02	RW
605	CHECK HEADSPACE	3/18/02	RW
610	DIS-ASSEMBLE GUN	3/18/02	RW
612	MAGNAFLUX		OPERATOR
615	ROLLMARK CALIBER	3/19/02	TCD
618	ROTO-BLAST		
620	APPLY COATINGS	3-21	TA
625 A	FINAL ASSEMBLY	3-22-02	RW
B	TRIGGER PULL TEST		
C	SAFETY "ON" FORCE		
D	SAFETY "OFF" FORCE		
E	FIRING PIN INDENT		
640	TARGET	3-25-02	AC
655	FINAL INSPECT	3-26-02	RK
660	PACK	3/26/02	DA
		SHIP DATE	
		QAR INSPECTION DATE	

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6348814.___0
FILE DATE AND TIME: 03/25/2002 02:31

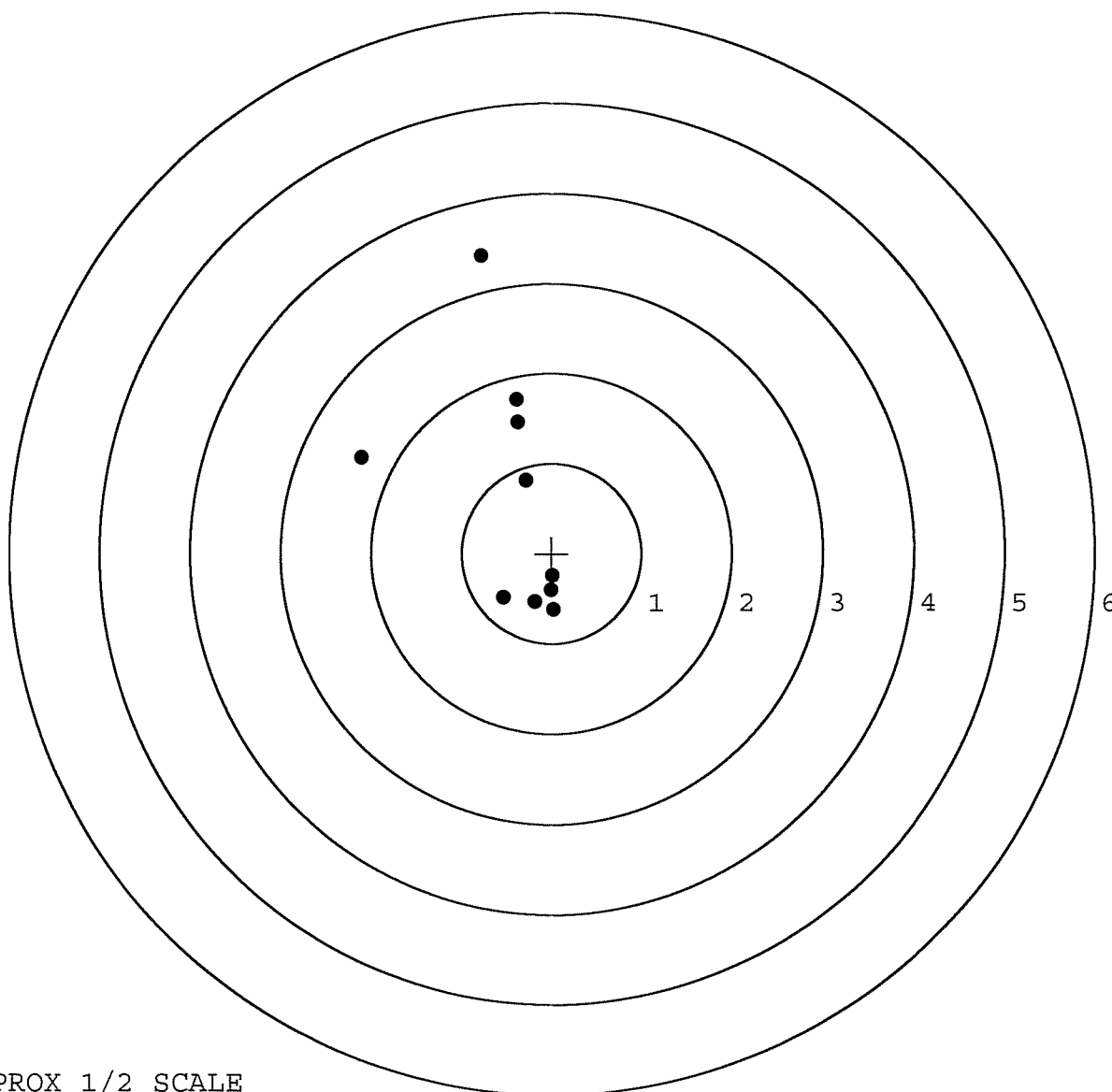
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.144
The Average Y Centroid of the Five Target Set:	0.115
The Average Point of Impact of the Five Target Set:	0.185
The Average Mean Radius of the Five Target Set:	0.713
The Distance from POA to Centroid Target #1:	0.762
The Distance from Centroid Target #2 to Centroid Target #1:	0.786
The Distance from Centroid Target #3 to Centroid Target #1:	0.798
The Distance from Centroid Target #4 to Centroid Target #1:	0.627
The Distance from Centroid Target #5 to Centroid Target #1:	0.728

SERIAL NUMBER: C6348814. 0
 TARGET NUMBER: 1
 FILE DATE: 03/25/2002
 FILE TIME: 02:31

X CENTROID: -0.468
 Y CENTROID: 0.601
 POA TO CENTROID: 0.762
 HORZ SPREAD: 2.131
 VERT SPREAD: 3.933
 GROUP SPREAD: 4.016
 MIN RADIUS: 0.277
 MAX RADIUS: 2.725
 MEAN RADIUS: 1.234
 # IN 1 IN DIAMETER: 1
 # IN 2 IN DIAMETER: 3
 # in 3 IN DIAMETER: 8

POINT#	X	Y
1:	-0.287	0.811
2:	-0.383	1.447
3:	-0.395	1.706
4:	-2.110	1.059
5:	-0.792	3.306
6:	0.008	-0.251
7:	-0.012	-0.408
8:	0.021	-0.627
9:	-0.192	-0.541
10:	-0.538	-0.494

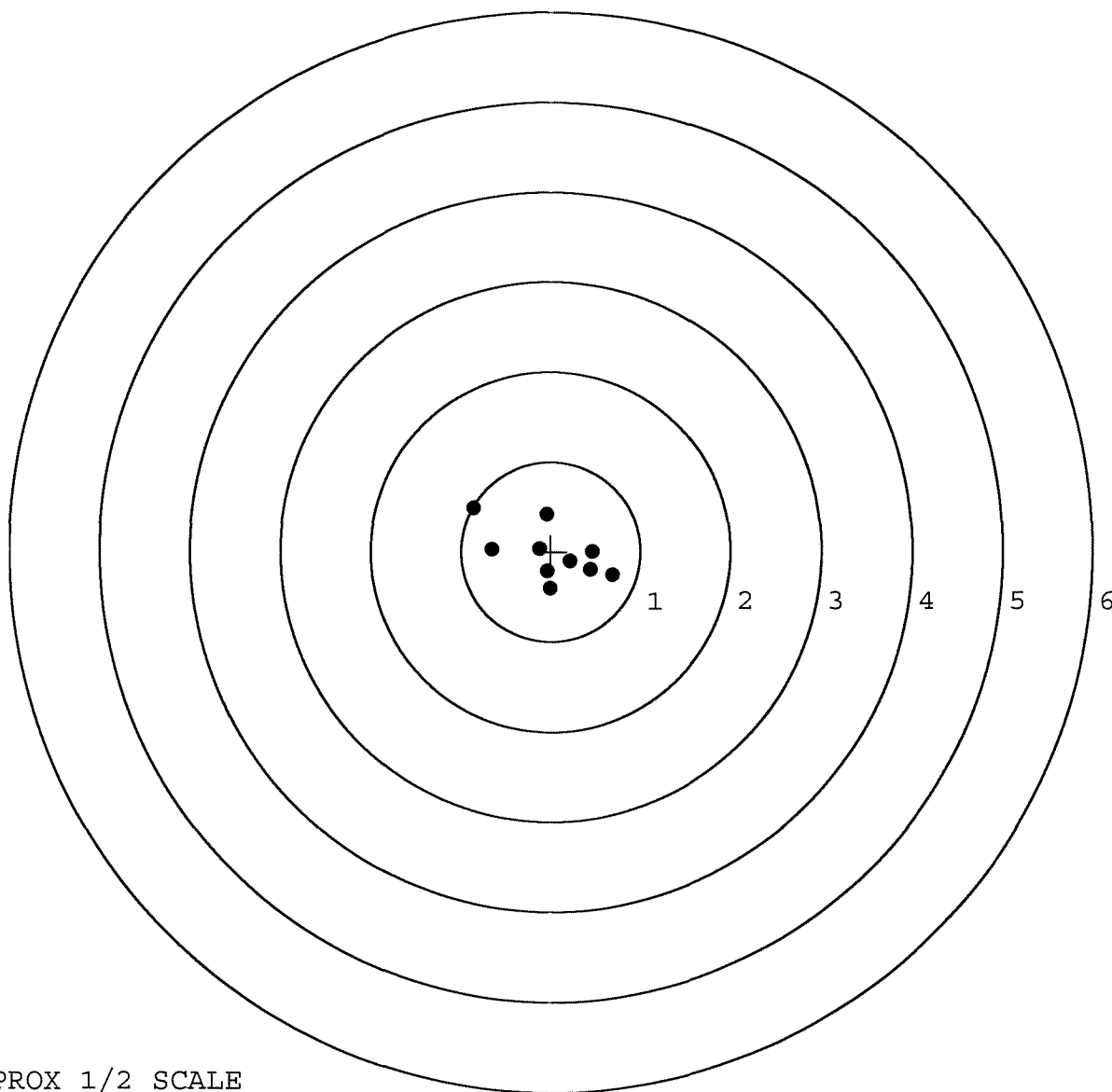


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6348814. 0
 TARGET NUMBER: 2
 FILE DATE: 03/25/2002
 FILE TIME: 02:31

X CENTROID: 0.007
 Y CENTROID: -0.025
 POA TO CENTROID: 0.026
 HORZ SPREAD: 1.555
 VERT SPREAD: 0.899
 GROUP SPREAD: 1.726
 MIN RADIUS: 0.146
 MAX RADIUS: 1.007
 MEAN RADIUS: 0.475
 # IN 1 IN DIAMETER: 7
 # IN 2 IN DIAMETER: 9
 # in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.693	-0.264
2:	0.466	0.004
3:	0.445	-0.203
4:	0.215	-0.109
5:	-0.013	-0.414
6:	-0.045	-0.225
7:	-0.128	0.032
8:	-0.046	0.417
9:	-0.660	0.024
10:	-0.862	0.485

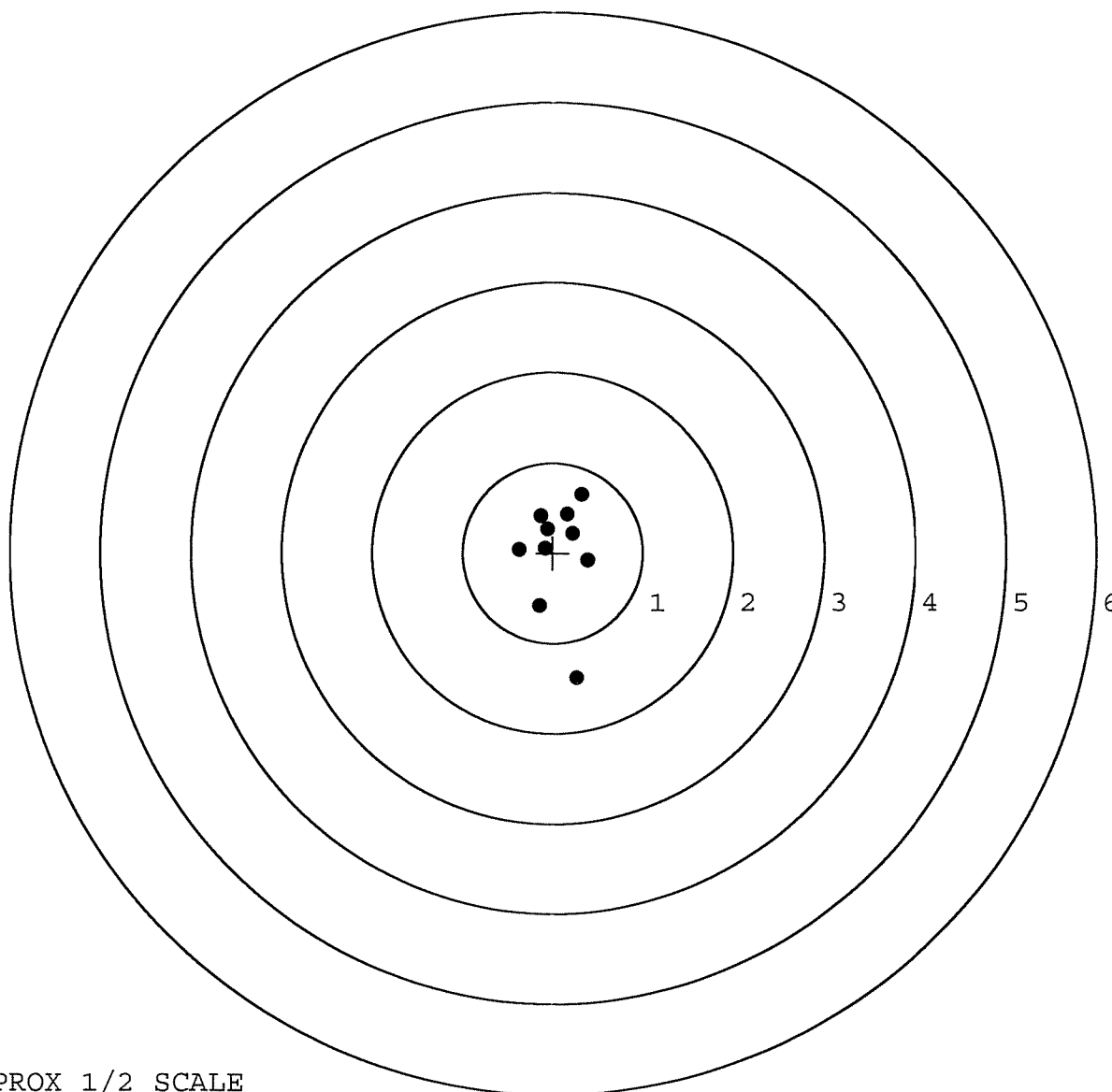


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6348814. __ 0
 TARGET NUMBER: 3
 FILE DATE: 03/25/2002
 FILE TIME: 02:31

X CENTROID: 0.056
 Y CENTROID: -0.001
 POA TO CENTROID: 0.056
 HORZ SPREAD: 0.766
 VERT SPREAD: 2.043
 GROUP SPREAD: 2.044
 MIN RADIUS: 0.153
 MAX RADIUS: 1.407
 MEAN RADIUS: 0.513
 # IN 1 IN DIAMETER: 7
 # IN 2 IN DIAMETER: 9
 # in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.268	-1.392
2:	-0.151	-0.587
3:	0.389	-0.085
4:	0.325	0.651
5:	-0.138	0.410
6:	-0.377	0.036
7:	-0.089	0.048
8:	0.224	0.215
9:	0.166	0.429
10:	-0.061	0.266

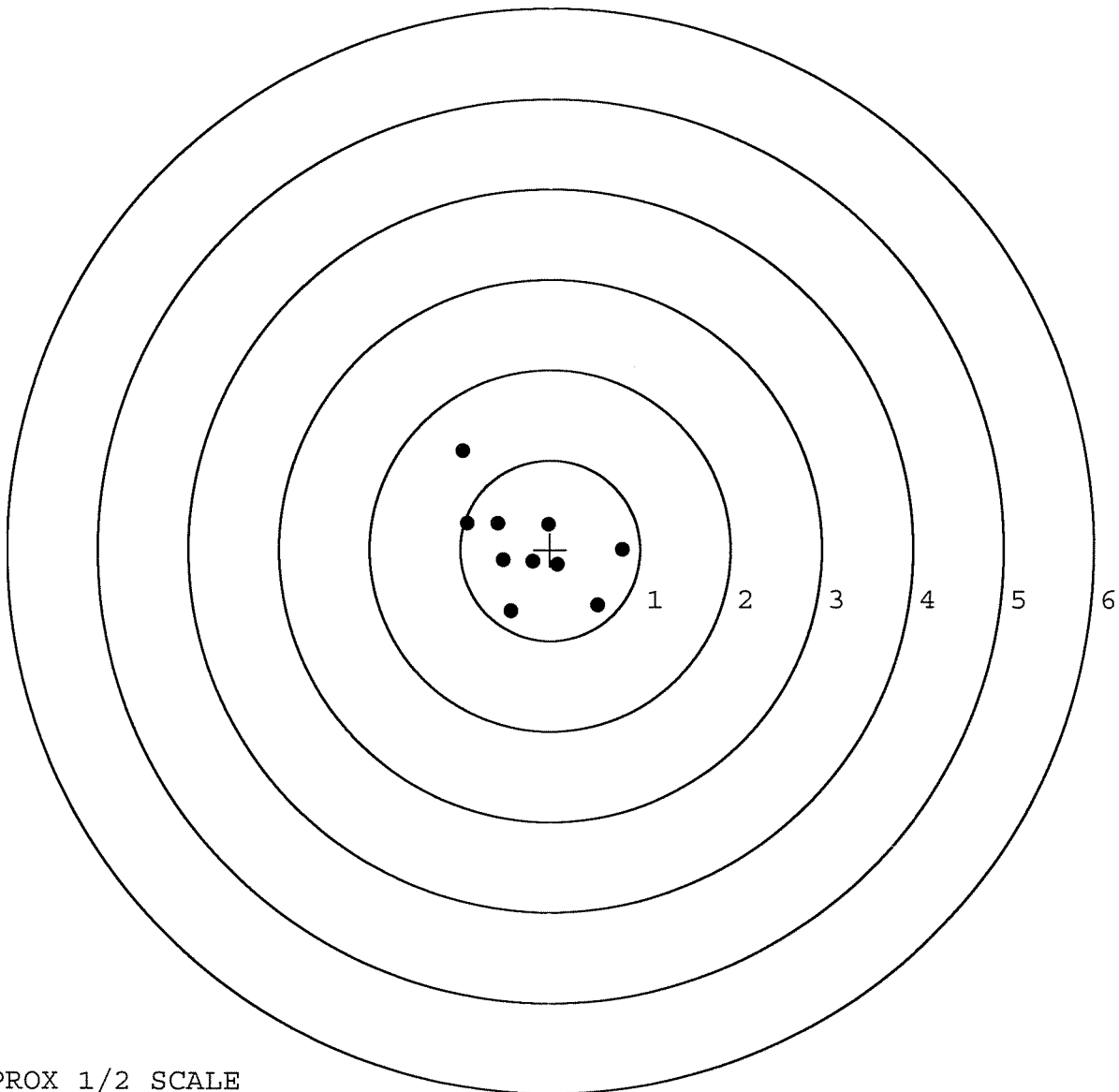


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6348814.____0
 TARGET NUMBER: 4
 FILE DATE: 03/25/2002
 FILE TIME: 02:31

X CENTROID: -0.225
 Y CENTROID: 0.023
 POA TO CENTROID: 0.226
 HORZ SPREAD: 1.784
 VERT SPREAD: 1.781
 GROUP SPREAD: 2.284
 MIN RADIUS: 0.164
 MAX RADIUS: 1.314
 MEAN RADIUS: 0.645
 # IN 1 IN DIAMETER: 5
 # IN 2 IN DIAMETER: 8
 # in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.805	-0.002
2:	0.527	-0.618
3:	-0.439	-0.682
4:	-0.921	0.293
5:	-0.580	0.291
6:	-0.979	1.099
7:	-0.526	-0.123
8:	-0.196	-0.138
9:	0.084	-0.170
10:	-0.024	0.281

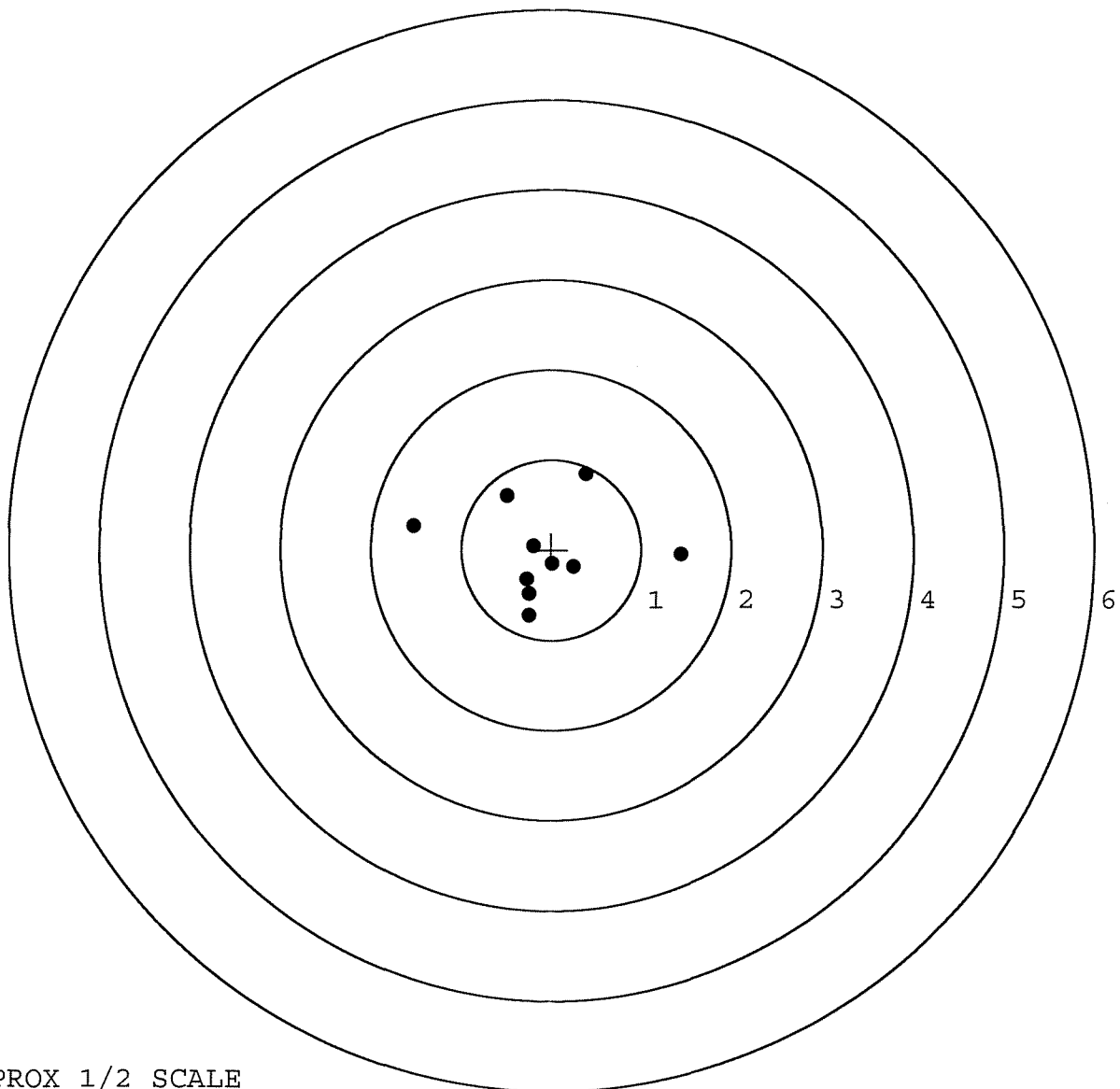


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6348814. __0
 TARGET NUMBER: 5
 FILE DATE: 03/25/2002
 FILE TIME: 02:31

X CENTROID: -0.091
 Y CENTROID: -0.022
 POA TO CENTROID: 0.094
 HORZ SPREAD: 2.967
 VERT SPREAD: 1.577
 GROUP SPREAD: 2.983
 MIN RADIUS: 0.130
 MAX RADIUS: 1.534
 MEAN RADIUS: 0.698
 # IN 1 IN DIAMETER: 5
 # IN 2 IN DIAMETER: 8
 # in 3 IN DIAMETER: 9

POINT#	X	Y
1:	1.443	-0.053
2:	0.383	0.845
3:	-0.491	0.595
4:	-1.524	0.256
5:	-0.251	-0.732
6:	-0.251	-0.492
7:	-0.276	-0.333
8:	0.252	-0.187
9:	0.010	-0.156
10:	-0.206	0.040



TARGET APPROX 1/2 SCALE

Remington



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

MODEL 700™ M24

SERIAL NO.
C6348814

ORDER NO.
5716

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

Ø1



5716 C6348814

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6348814

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	7 25	89	RW
600	Proof	7 25	89	RW
607	Check Headspace			RW
610	Dis-assemble Gun			RW
612	Magnaflux Barrel Action			
	Magnaflux Bolt			
615	Rollmark Caliber			
7	Drill and Tap Sight Holes		7/27/89	WC
618	Polish Barrel <i>RB</i>		7/31/89	WB
620	Apply Coatings (Barrel Action)		8/2/89	TSA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/7/89	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/7/89	RW
	C) Inspect Ejector Hole for Chamfer		8/7/89	RW
	D) Oil Firing Pin Ass'y		8/7/89	RW
	E) Adjust Trigger Pull to Min Setting and Stake		8/7/89	JS

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			8 Aug 89	JS
	G) Safety Off Force	3	3	3			8 Aug 89	JS
	H) Trigger Pull Test & Retainability						8 Aug 89	JS
	I) Firing Pin Indent	.0205	.021	.021			8 Aug 89	JS
	J) Assemble Stock						8/10/89	RW
	K) Assemble Swivel Studs						16 Aug 89	JS
	L) Attach Front and Rear Sight Assemblies						8/10/89	RW
	M) Iron Sight Alignment						8/10/89	RW
	N) Detach Front & Rear Sights & place in numbered container						8/10/89	RW
	O) Attach Scope to Rifle						10 Aug 89	JS
	P) Detach & Attach Scope 20 Times						10 Aug 89	JS
640	Gallery Target & Test	69R	80L				8-14-89	AC
	A) Time						8-14-89	AC
	B) Malfunctions						8-14-89	AC
	C) Pierced Primers						8-14-89	AC
	D) Optical Clarity of Scope						8-14-89	AC
645	Inspect for Live Ammo						8-14-89	AC
655	Final Inspection							
	A) Headspace						16 Aug 89	JS
	B) Trigger Pull	2.75	2.74	2.69	2.81	2.77	16 Aug 89	JS
	C) Function						16 Aug 89	JS
660	Pack						20 Sep 89	JS

repaired stock at front Swivel 13 Sept 89

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. 8814

DATE _____

TESTER _____

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.28	2.23	2.29		MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.21	2.14	2.19		
PULL #3	2.21	2.13	2.33		
PULL #4	2.35	2.18	2.20		
PULL #5	2.25	2.14	2.23		
TOTAL	11.30	10.82	11.24		
AVG.	2.26	2.16	2.24		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.29	3.11		
PULL #2	3.11	3.10		
PULL #3	3.10	3.08		
PULL #4	3.11	3.11		
PULL #5	3.13	3.12		
TOTAL	15.74	15.52		
AVG.	3.14	3.10		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.09	4.13		
PULL #2	4.28	4.16		
PULL #3	4.17	4.12		
PULL #4	4.16	4.13		
PULL #5	4.16	4.14		
TOTAL	20.96	20.68		
AVG.	4.19	4.13		

CENTROIDAL DISTANCE CALCULATIONS
 FOR RIFLE # C6348814
 15 Aug 1989

CENTROIDAL DISTANCES

0 TO	1	.571522
1 TO	2	.268477
1 TO	3	.503245
1 TO	4	.612945
1 TO	5	.339308

$\frac{a_1}{\sum a_i}$ <----POA

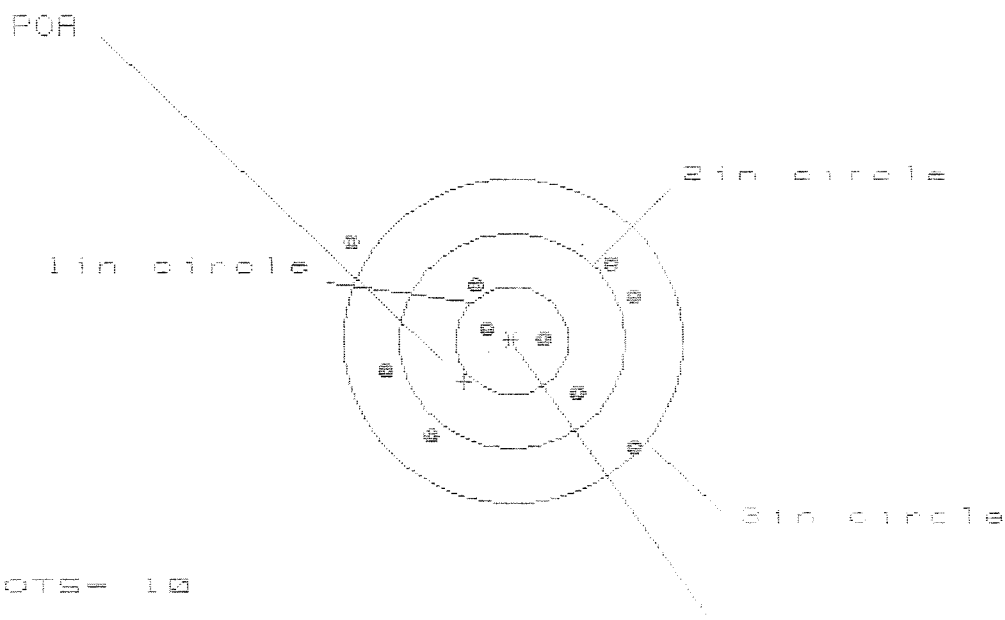
1. AVERAGE X-COORDINATE FOR THIS RIFLE IS: .3496
 2. AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .084
 3. RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .35955
 4. RMP FOR THIS RIFLE IS: .8758

15 Aug 1989

FILE:/PATTERNING/CENTERFIRE_PATT/08348814

CENTERFIRE PATTERNS

1



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 4

3 in = 8

HS= 2.551

VS= 1.905

GS= 3.184

CENTROID #

PATTERN #

1

SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.087	.925	1.003
MINIMUM X	:	-1.464	-1.300	-1.185
MAXIMUM Y	:	.909	.819	.787
MINIMUM Y	:	-.996	-.894	-.905
CENTROID X	:	.426	.588	.473
CENTROID Y	:	.381	.279	.391
PT TO CENTROID in.	:	.571	.651	.614
1 IN RADIUS	:	.271	.169	.266
2 IN RADIUS	:	.962	.864	.800
3 IN RADIUS	:	1.723	1.307	1.210
HORIZONTAL SPREAD	:	2.551	2.225	2.188
VERTICAL SPREAD	:	1.905	1.713	1.512
EXTREME SPREAD	:	3.184	2.352	2.287
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		9	

15 Aug 1988

FILE:/PATTERNING/CENTERFIRE_PATT/08848014

CENTERFIRE PATTERNS

2

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS= 10

IN CIR

1in = 2

2in = 8

3in = 9

HS= 2.529

VS= 1.943

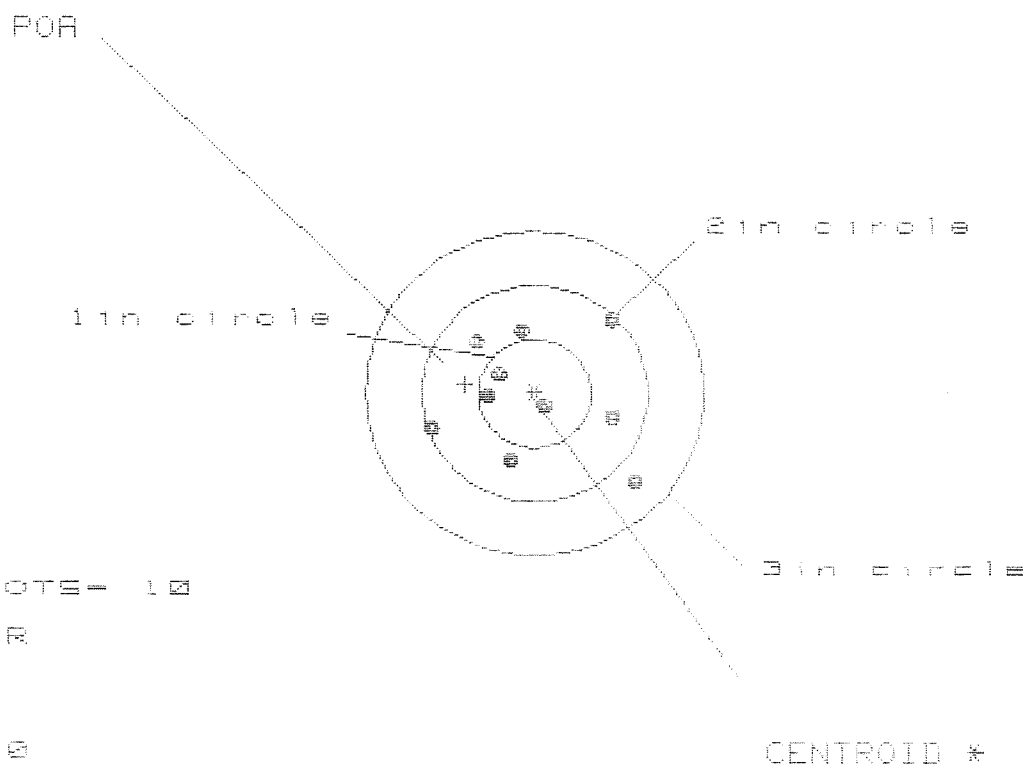
GS= 2.542

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.661	.883	.838
MINIMUM X	:	-.868	-.684	-.729
MAXIMUM Y	:	1.152	1.165	.683
MINIMUM Y	:	-.791	-.778	-.633
CENTROID X	:	.190	.006	.051
CENTROID Y	:	.253	.240	.095
POA TO CENTROID in.	:	.316	.240	.107
1IN RADIUS	:	.382	.225	.200
2IN RADIUS	:	.846	.726	.644
3IN RADIUS	:	1.665	1.230	1.033
HORIZONTAL SPREAD	:	2.529	1.567	1.567
VERTICAL SPREAD	:	1.943	1.943	1.236
EXTREME SPREAD	:	2.542	1.959	1.713
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	

12 Aug 1989

FILE:/PATTERNING/CENTERFIRE_PATT/08348814

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 3

2in = 8

3in = 10

HS= 1.798

VS= 1.488

GS= 1.913

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.906	.834	.937
MINIMUM X	:	-.892	-.791	-.688
MAXIMUM Y	:	.715	.629	.622
MINIMUM Y	:	-.773	-.713	-.634
CENTROID X	:	.616	.515	.412
CENTROID Y	:	-.085	.001	-.078
POA TO CENTROID in.	:	.622	.515	.420
MIN RADIUS	:	.129	.199	.176
MEAN RADIUS	:	.686	.610	.540
MAX RADIUS	:	1.191	1.035	.969
HORIZONTAL SPREAD	:	1.798	1.625	1.625
VERTICAL SPREAD	:	1.488	1.342	1.256
EXTREME SPREAD	:	1.913	1.913	1.627
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	

15 Aug 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C6348814

CENTERFIRE PATTERNS

4

POA

1 in circle

2 in circle

3 in circle

OF SHOTS= 10

IN CIR

1 in = 1

2 in = 6

3 in = 10

HS= 2.443

VS= 1.968

GS= 2.444

CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.361	.771	.654
MINIMUM X	:	-1.082	-.931	-.844
MAXIMUM Y	:	1.002	1.057	1.117
MINIMUM Y	:	-.966	-.911	-.851
CENTROID X	:	.211	.060	.177
CENTROID Y	:	-.193	-.248	-.308
POA TO CENTROID in.	:	.286	.255	.355
MIN RADIUS	:	.303	.374	.411
MEAN RADIUS	:	.876	.801	.765
MAX RADIUS	:	1.448	1.103	1.134
HORIZONTAL SPREAD	:	2.443	1.702	1.498
VERTICAL SPREAD	:	1.968	1.968	1.968
EXTREME SPREAD	:	2.444	2.022	1.981
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	

15 Aug 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C8348814

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 = 10

1 in = 2.378

2 in = 2.523

3 in = 2.526

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.170	1.121	1.068
MINIMUM X	:	-1.208	-1.257	-1.370
MAXIMUM Y	:	1.322	1.247	.890
MINIMUM Y	:	-1.201	-1.054	-.898
CENTROID X	:	.305	.354	.467
CENTROID Y	:	.064	-.083	-.239
POA TO CENTROID in.	:	.311	.364	.525
MIN RADIUS	:	.269	.418	.394
MEAN RADIUS	:	1.009	.956	.858
MAX RADIUS	:	1.395	1.539	1.377
HORIZONTAL SPREAD	:	2.378	2.378	2.378
VERTICAL SPREAD	:	2.523	2.301	1.788
EXTREME SPREAD	:	2.526	2.436	2.384
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		10	