

G 636 0890
Replace
C. 652 3549

Repair Inquiry

Repair Number: **RE00085667**Serial: C8523349 Model M24 SWS CenterFire
Caliber: 7.62 NATO

Repairman:

Verify Repair

Status:

Closed 9/28/2004 2:36:28 PM

Address Information

Customer

☒ Received From

Return To

☐ Received FromName: **C CO SPT BN 1ST SWTG A****C CO SPT BN 1ST SWTG A**Address 1: **AHN ARMAMENT FACILITY****AHN ARMAMENT FACILITY**Address 2: **PO Box:****PO Box:**City: **FT BRAGG****FT 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

Fair

Condition
Notes:CSR
Notes:

Accessories Received

Code	Desc	Qty
A007	With Studs	3
A010	Hard Case	1
A017	Scope Bases	3

Repair Search

Refresh

Close

hagletj

9/28/2004

3:05 PM

CAPS

NUM

INS

SCPL

start

2

3

Arms Services R...

4

C 636 08 90 (New)

Serial Number: **C6523349**Model: **M24 SWS****RE00085667**

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6360890.___0
FILE DATE AND TIME: 10/28/2004 08:12

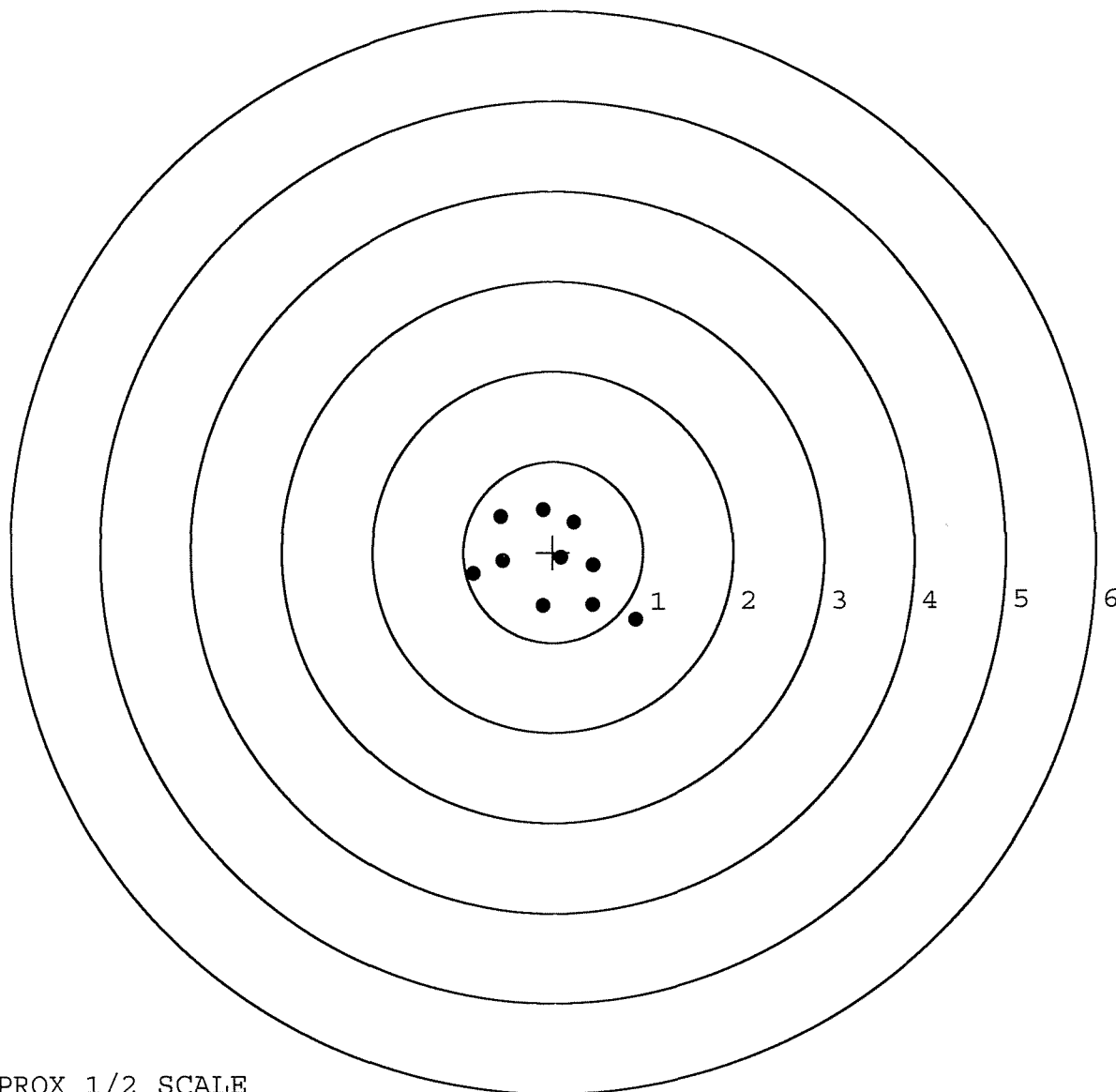
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.040
The Average Y Centroid of the Five Target Set:	-0.154
The Average Point of Impact of the Five Target Set:	0.159
The Average Mean Radius of the Five Target Set:	0.682
The Distance from POA to Centroid Target #1:	0.130
The Distance from Centroid Target #2 to Centroid Target #1:	0.095
The Distance from Centroid Target #3 to Centroid Target #1:	0.157
The Distance from Centroid Target #4 to Centroid Target #1:	0.136
The Distance from Centroid Target #5 to Centroid Target #1:	0.150

SERIAL NUMBER: G6360890. __0
 TARGET NUMBER: 1
 FILE DATE: 10/28/2004
 FILE TIME: 08:12

X CENTROID: -0.010
 Y CENTROID: -0.130
 POA TO CENTROID: 0.130
 HORZ SPREAD: 1.803
 VERT SPREAD: 1.222
 GROUP SPREAD: 1.885
 MIN RADIUS: 0.124
 MAX RADIUS: 1.117
 MEAN RADIUS: 0.617
 # IN 1 IN DIAMETER: 3
 # IN 2 IN DIAMETER: 9
 # in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.915	-0.755
2:	0.446	-0.590
3:	-0.118	-0.599
4:	0.448	-0.152
5:	0.093	-0.061
6:	-0.565	-0.095
7:	-0.888	-0.239
8:	-0.578	0.396
9:	-0.101	0.467
10:	0.243	0.330

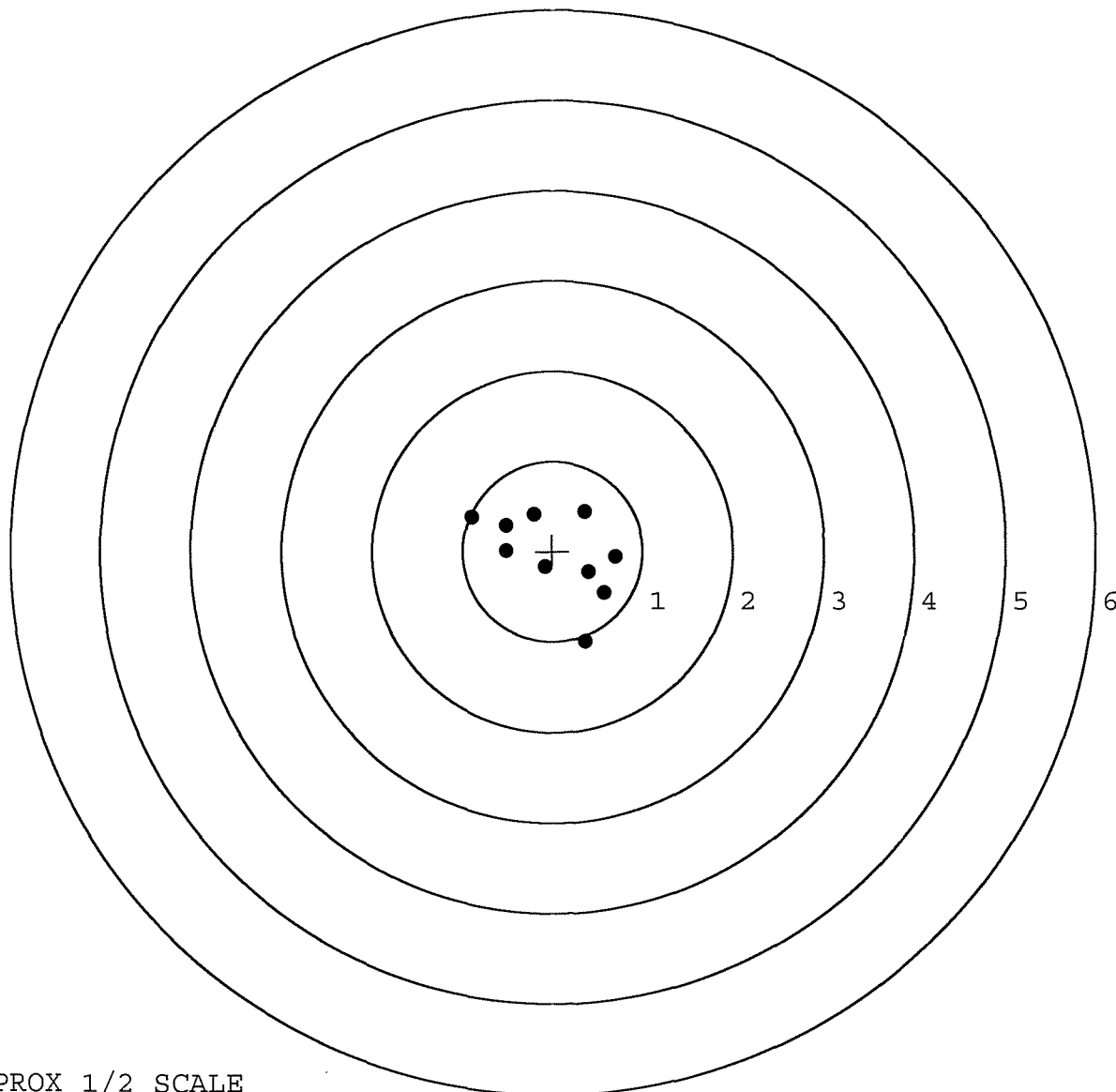


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6360890. __0
 TARGET NUMBER: 2
 FILE DATE: 10/28/2004
 FILE TIME: 08:12

X CENTROID: 0.017
 Y CENTROID: -0.039
 POA TO CENTROID: 0.043
 HORZ SPREAD: 1.605
 VERT SPREAD: 1.448
 GROUP SPREAD: 1.884
 MIN RADIUS: 0.168
 MAX RADIUS: 1.029
 MEAN RADIUS: 0.628
 # IN 1 IN DIAMETER: 2
 # IN 2 IN DIAMETER: 8
 # in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.371	-1.006
2:	0.702	-0.062
3:	0.576	-0.460
4:	0.401	-0.227
5:	-0.083	-0.174
6:	0.356	0.442
7:	-0.212	0.413
8:	-0.515	0.011
9:	-0.903	0.382
10:	-0.523	0.288

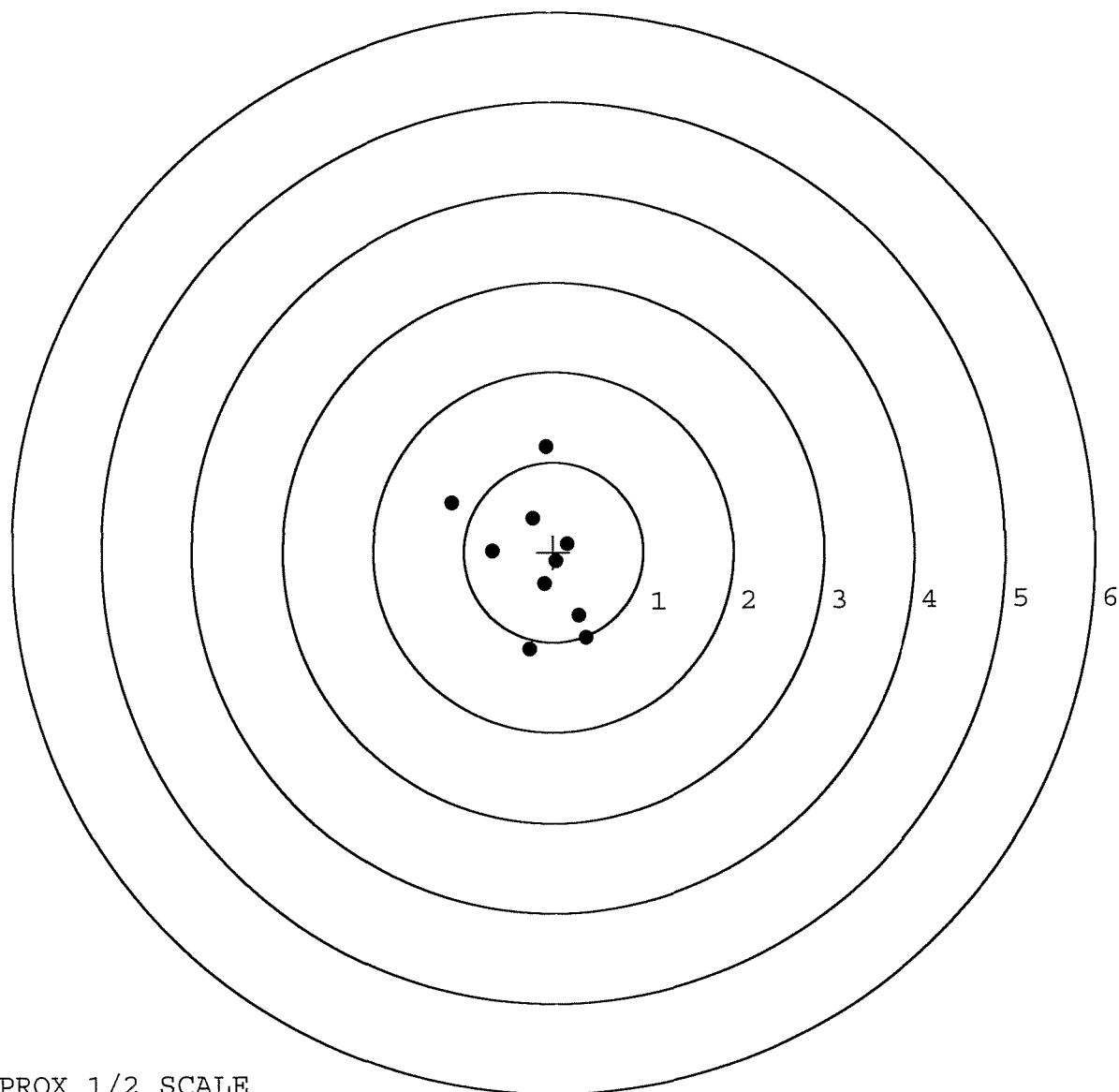


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6360890. __0
 TARGET NUMBER: 3
 FILE DATE: 10/28/2004
 FILE TIME: 08:12

X CENTROID: -0.165
 Y CENTROID: -0.100
 POA TO CENTROID: 0.193
 HORZ SPREAD: 1.487
 VERT SPREAD: 2.257
 GROUP SPREAD: 2.266
 MIN RADIUS: 0.192
 MAX RADIUS: 1.277
 MEAN RADIUS: 0.703
 # IN 1 IN DIAMETER: 4
 # IN 2 IN DIAMETER: 7
 # in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.365	-0.955
2:	0.281	-0.711
3:	-0.269	-1.084
4:	-0.686	0.014
5:	-1.122	0.556
6:	-0.069	1.173
7:	-0.224	0.377
8:	0.156	0.087
9:	0.027	-0.103
10:	-0.106	-0.354

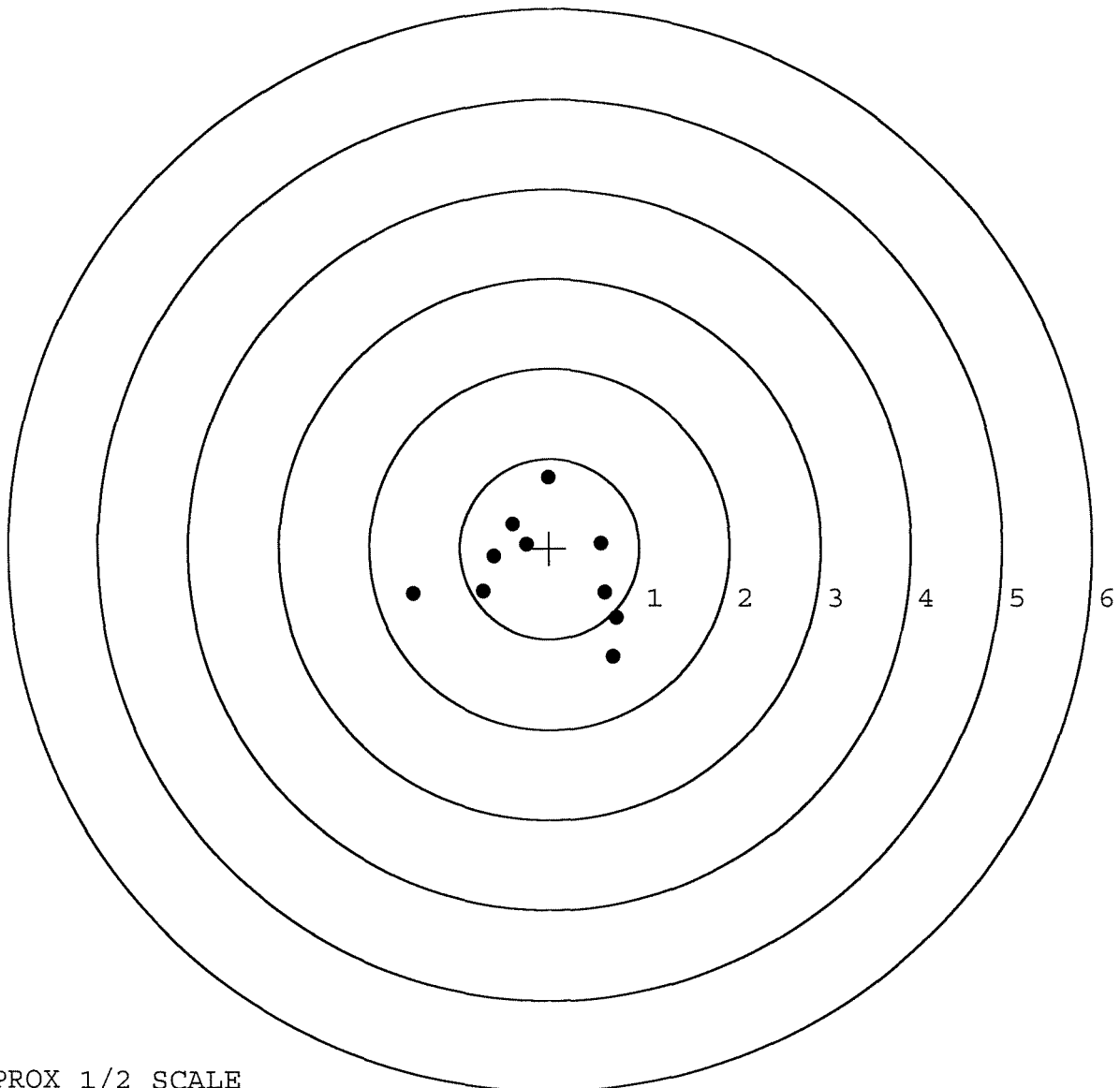


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6360890. 0
 TARGET NUMBER: 4
 FILE DATE: 10/28/2004
 FILE TIME: 08:12

X CENTROID: -0.094
 Y CENTROID: -0.237
 POA TO CENTROID: 0.255
 HORZ SPREAD: 2.262
 VERT SPREAD: 1.985
 GROUP SPREAD: 2.332
 MIN RADIUS: 0.325
 MAX RADIUS: 1.449
 MEAN RADIUS: 0.837
 # IN 1 IN DIAMETER: 1
 # IN 2 IN DIAMETER: 7
 # in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.707	-1.196
2:	0.743	-0.773
3:	0.614	-0.491
4:	0.574	0.059
5:	-0.014	0.789
6:	-0.416	0.269
7:	-0.258	0.043
8:	-0.621	-0.093
9:	-0.746	-0.477
10:	-1.519	-0.500

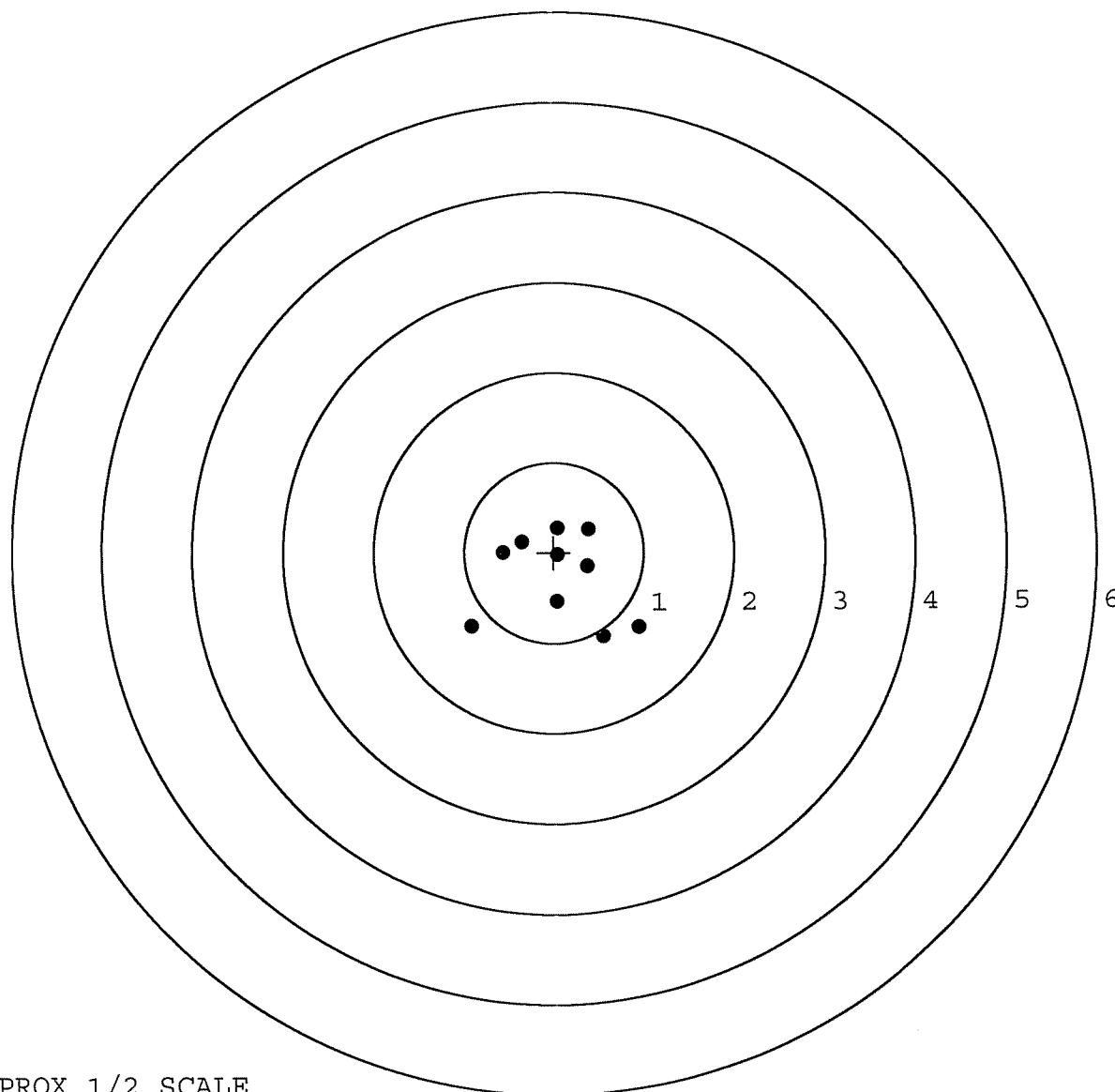


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6360890. __0
 TARGET NUMBER: 5
 FILE DATE: 10/28/2004
 FILE TIME: 08:12

X CENTROID: 0.053
 Y CENTROID: -0.266
 POA TO CENTROID: 0.271
 HORZ SPREAD: 1.866
 VERT SPREAD: 1.201
 GROUP SPREAD: 1.866
 MIN RADIUS: 0.233
 MAX RADIUS: 1.118
 MEAN RADIUS: 0.626
 # IN 1 IN DIAMETER: 3
 # IN 2 IN DIAMETER: 8
 # in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.942	-0.832
2:	0.551	-0.930
3:	0.039	-0.544
4:	-0.924	-0.810
5:	-0.573	0.002
6:	-0.356	0.118
7:	0.390	0.260
8:	0.043	0.271
9:	0.375	-0.157
10:	0.041	-0.033



TARGET APPROX 1/2 SCALE

USAPPC V1.10

R & E NUMBER	85667		
SERIAL NUMBER	C6523349 C6360890 (New)		
LOG-IN DATE	9-28-04		
INSPECT AND VERIFY:			
OPERATION #	OPERATION NAME	DATE	INITIAL
550	DIS-ASSEMBLE GUN	10-6-04	RTL
560 A	RE-BARREL	10-7-04	AC
B	DRILL AND TAP	10-12-04	TRW
575	ASSEMBLE	10-8-04	RTL
600	PROOF	10-11-04	AC
605	CHECK HEADSPACE	10-12-04	RTL
610	DIS-ASSEMBLE GUN	10-12-04	RTL
612	MAGNAFLUX	OPERATOR	
615	ROLLMARK CALIBER	10/13/04	CD
618	ROTO-BLAST	10/14/04	LB
620	APPLY COATINGS	10/25/04	HP
625 A	FINAL ASSEMBLY	10-27-04	RTL
B	TRIGGER PULL TEST		
C	SAFETY "ON" FORCE		
D	SAFETY "OFF" FORCE		
E	FIRING PIN INDENT		
640	TARGET	10-28-04	TRW
655	FINAL INSPECT	11-3-04	AC
660	PACK	11-4-04	RA
		SHIP DATE	
	QAR INSPECTION DATE		

Arms Services Repair & Estimate System

File Add Repair Estimate Repair Expedite Repair Inquiry Repair Tools CSB Tools Reports Table Maintenance System Maintenance Help

Repair Inquiry

Repair Number: **RE00042314** Serial: **C6523349** Model: **700** Center Fire Caliber: **7.62 NATO M-24 (SWS)** Repairman: Status: **Closed 2/26/02 7:40:51 AM**

Address Information

Customer: ☒ Received From Return To: ☒ Received From

Name: **C CO SPT BN** **C CO SPT BN**

Address 1: **1ST SWTG(A)** **1ST SWTG(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

Poor

Condition Notes:

CSB Notes:

Accessories Received

Code	Desc	Qty
A007	With Stud	3
A017	Scope Base	1
A026	Scope	1

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

maglet 2/26/02 9:10 AM CAPS NUM INS SCFL

Start S F S C S C S E A 9:10 AM

Serial Number: **C6523349**

Model: **700**



RE00042314

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6523349.___0
FILE DATE AND TIME: 03/13/2002 10:52

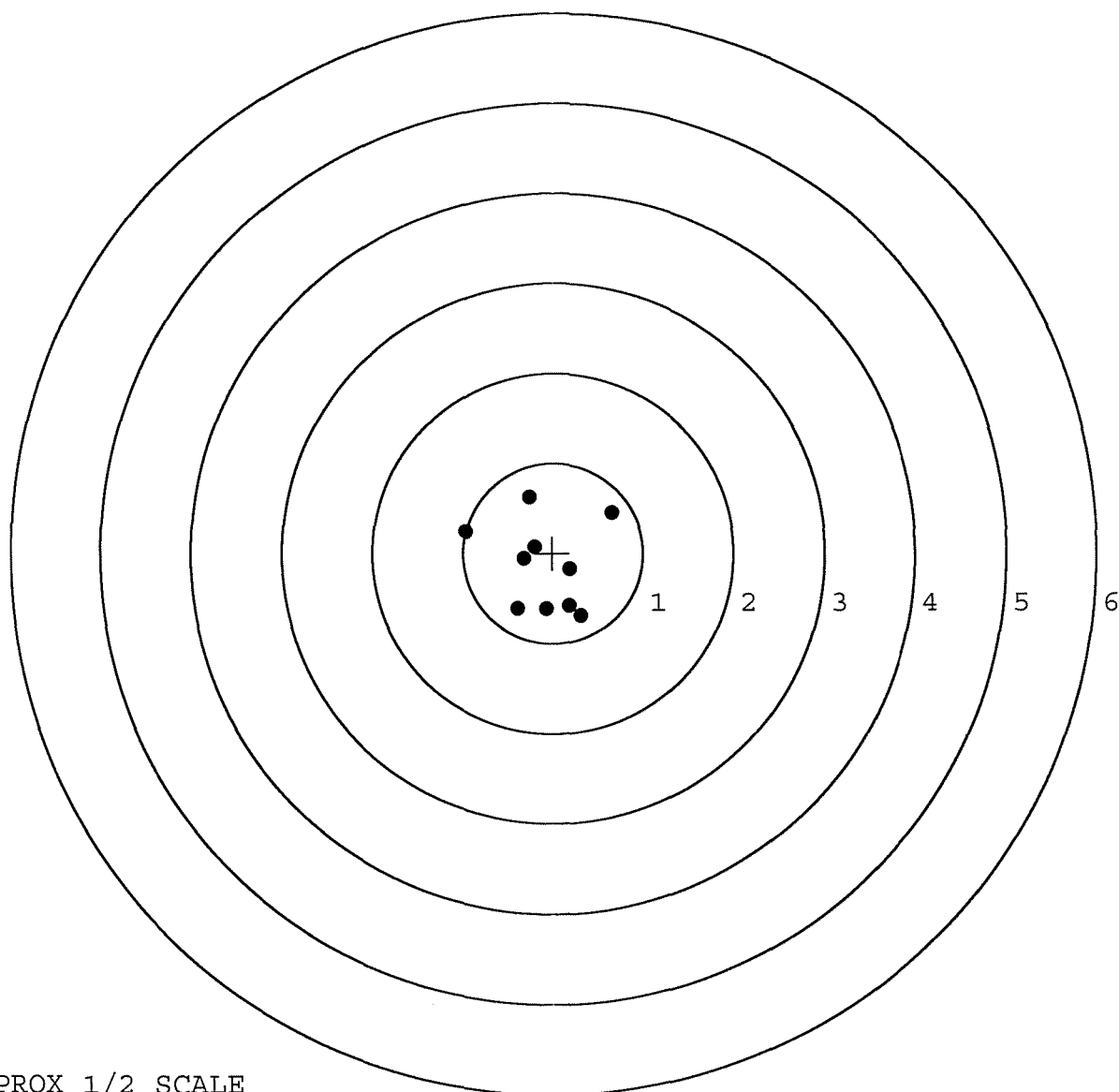
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.125
The Average Y Centroid of the Five Target Set:	-0.110
The Average Point of Impact of the Five Target Set:	0.167
The Average Mean Radius of the Five Target Set:	0.593
The Distance from POA to Centroid Target #1:	0.164
The Distance from Centroid Target #2 to Centroid Target #1:	0.147
The Distance from Centroid Target #3 to Centroid Target #1:	0.207
The Distance from Centroid Target #4 to Centroid Target #1:	0.126
The Distance from Centroid Target #5 to Centroid Target #1:	0.118

SERIAL NUMBER: C6523349. 0
 TARGET NUMBER: 1
 FILE DATE: 03/13/2002
 FILE TIME: 10:52

X CENTROID: -0.089
 Y CENTROID: -0.138
 POA TO CENTROID: 0.164
 HORZ SPREAD: 1.628
 VERT SPREAD: 1.320
 GROUP SPREAD: 1.641
 MIN RADIUS: 0.237
 MAX RADIUS: 0.959
 MEAN RADIUS: 0.572
 # IN 1 IN DIAMETER: 4
 # IN 2 IN DIAMETER: 10
 # in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.658	0.448
2:	-0.262	0.622
3:	-0.970	0.243
4:	-0.323	-0.064
5:	-0.206	0.069
6:	0.191	-0.176
7:	0.309	-0.698
8:	0.185	-0.584
9:	-0.078	-0.621
10:	-0.398	-0.618

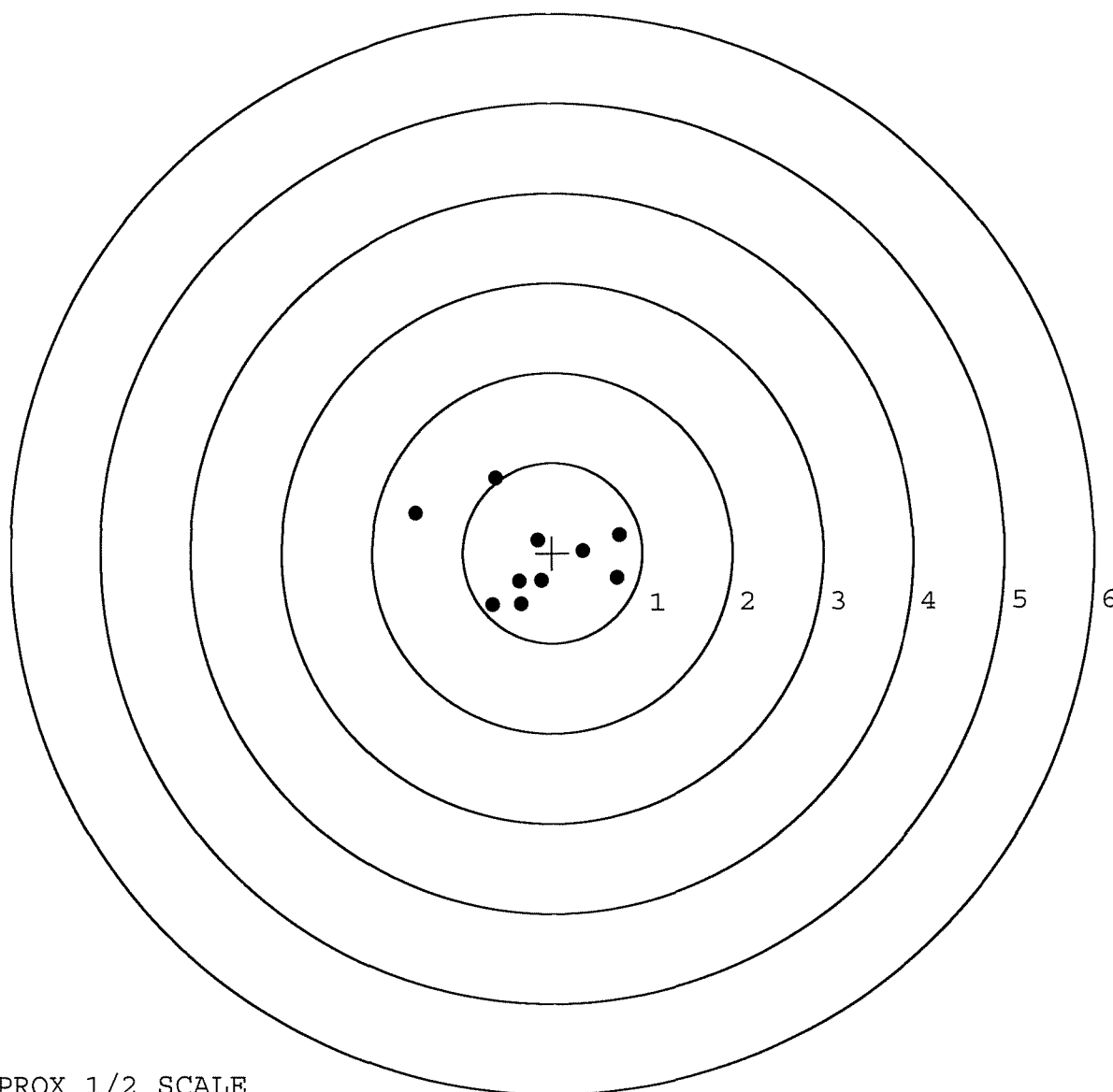


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6523349. __ 0
 TARGET NUMBER: 2
 FILE DATE: 03/13/2002
 FILE TIME: 10:52

X CENTROID: -0.200
 Y CENTROID: -0.041
 POA TO CENTROID: 0.204
 HORZ SPREAD: 2.260
 VERT SPREAD: 1.408
 GROUP SPREAD: 2.349
 MIN RADIUS: 0.190
 MAX RADIUS: 1.398
 MEAN RADIUS: 0.691
 # IN 1 IN DIAMETER: 3
 # IN 2 IN DIAMETER: 9
 # in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.752	0.196
2:	0.722	-0.286
3:	0.346	0.022
4:	-0.166	0.146
5:	-0.122	-0.310
6:	-0.373	-0.314
7:	-0.347	-0.571
8:	-0.671	-0.577
9:	-0.632	0.831
10:	-1.508	0.451

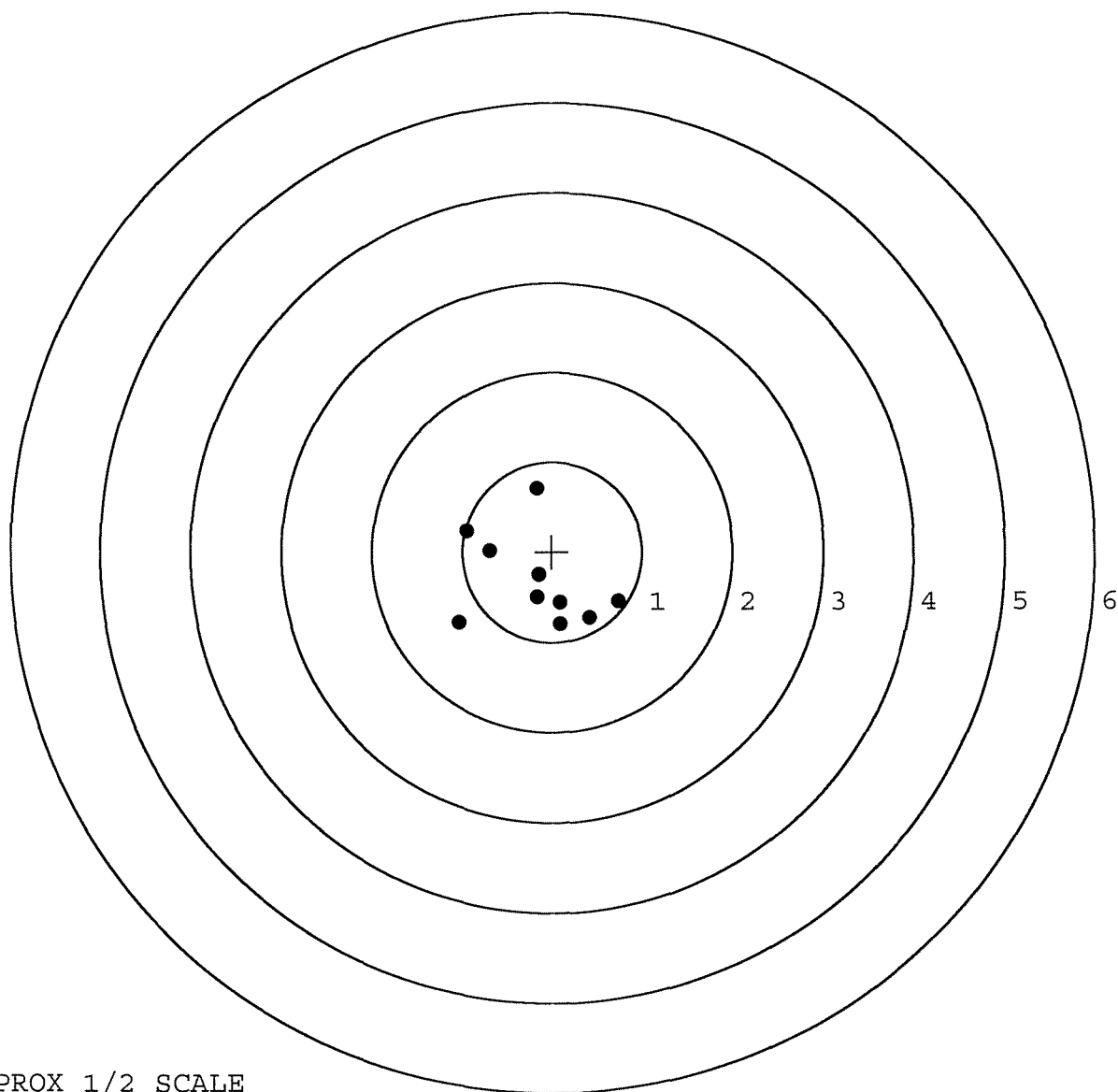


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6523349. 0
 TARGET NUMBER: 3
 FILE DATE: 03/13/2002
 FILE TIME: 10:52

X CENTROID: -0.185
 Y CENTROID: -0.322
 POA TO CENTROID: 0.371
 HORZ SPREAD: 1.782
 VERT SPREAD: 1.508
 GROUP SPREAD: 1.725
 MIN RADIUS: 0.076
 MAX RADIUS: 1.027
 MEAN RADIUS: 0.642
 # IN 1 IN DIAMETER: 3
 # IN 2 IN DIAMETER: 9
 # in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.739	-0.550
2:	0.416	-0.727
3:	0.091	-0.803
4:	0.087	-0.563
5:	-0.149	-0.255
6:	-0.171	-0.505
7:	-0.953	0.239
8:	-0.698	0.019
9:	-1.043	-0.781
10:	-0.167	0.705

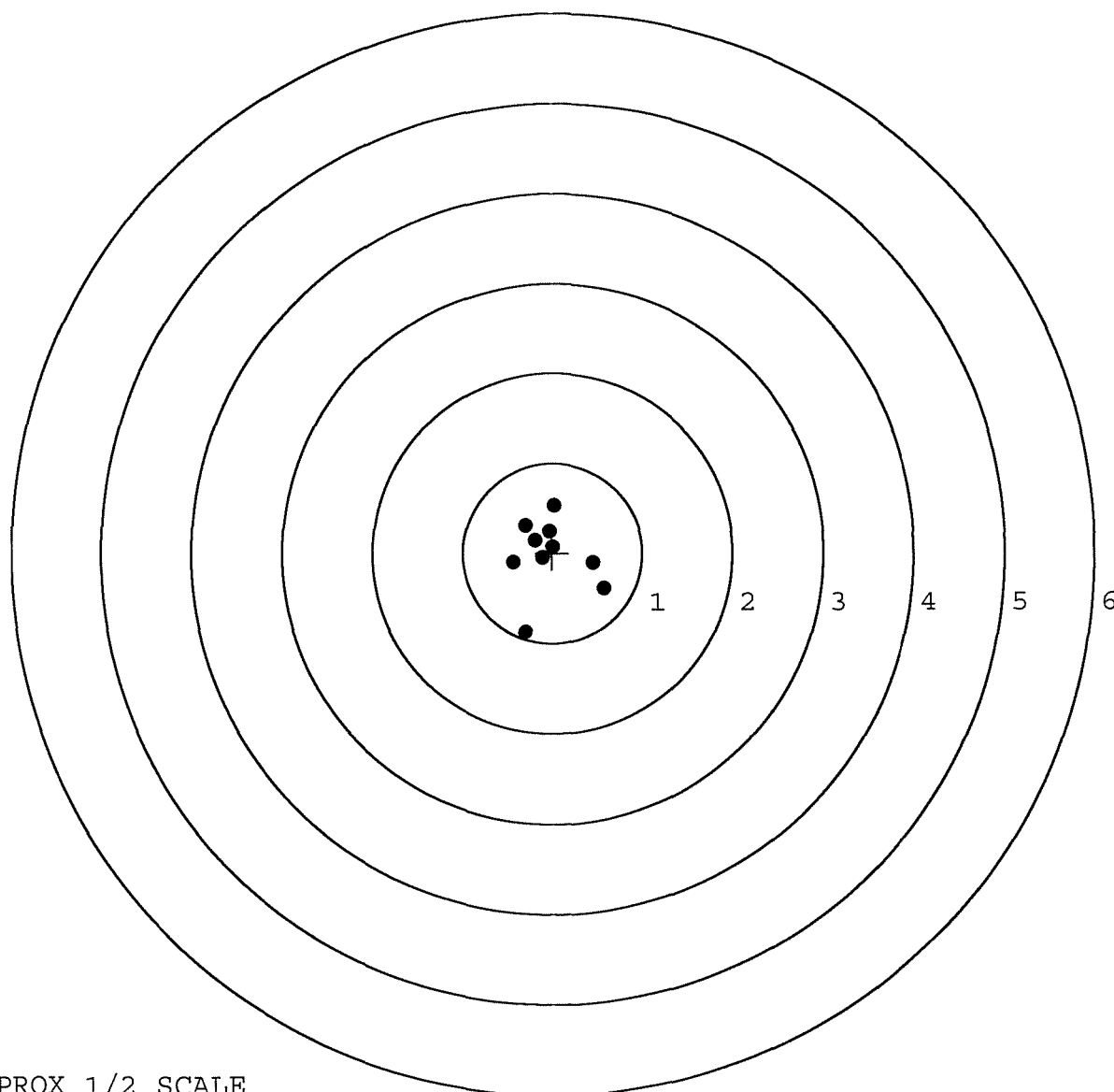


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6523349. 0
 TARGET NUMBER: 4
 FILE DATE: 03/13/2002
 FILE TIME: 10:52

X CENTROID: -0.031
 Y CENTROID: -0.026
 POA TO CENTROID: 0.040
 HORZ SPREAD: 1.013
 VERT SPREAD: 1.414
 GROUP SPREAD: 1.452
 MIN RADIUS: 0.083
 MAX RADIUS: 0.903
 MEAN RADIUS: 0.420
 # IN 1 IN DIAMETER: 7
 # IN 2 IN DIAMETER: 10
 # in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.577	-0.394
2:	0.456	-0.111
3:	-0.306	-0.886
4:	0.022	0.528
5:	-0.305	0.310
6:	-0.030	0.243
7:	0.008	0.072
8:	-0.108	-0.058
9:	-0.436	-0.103
10:	-0.188	0.141

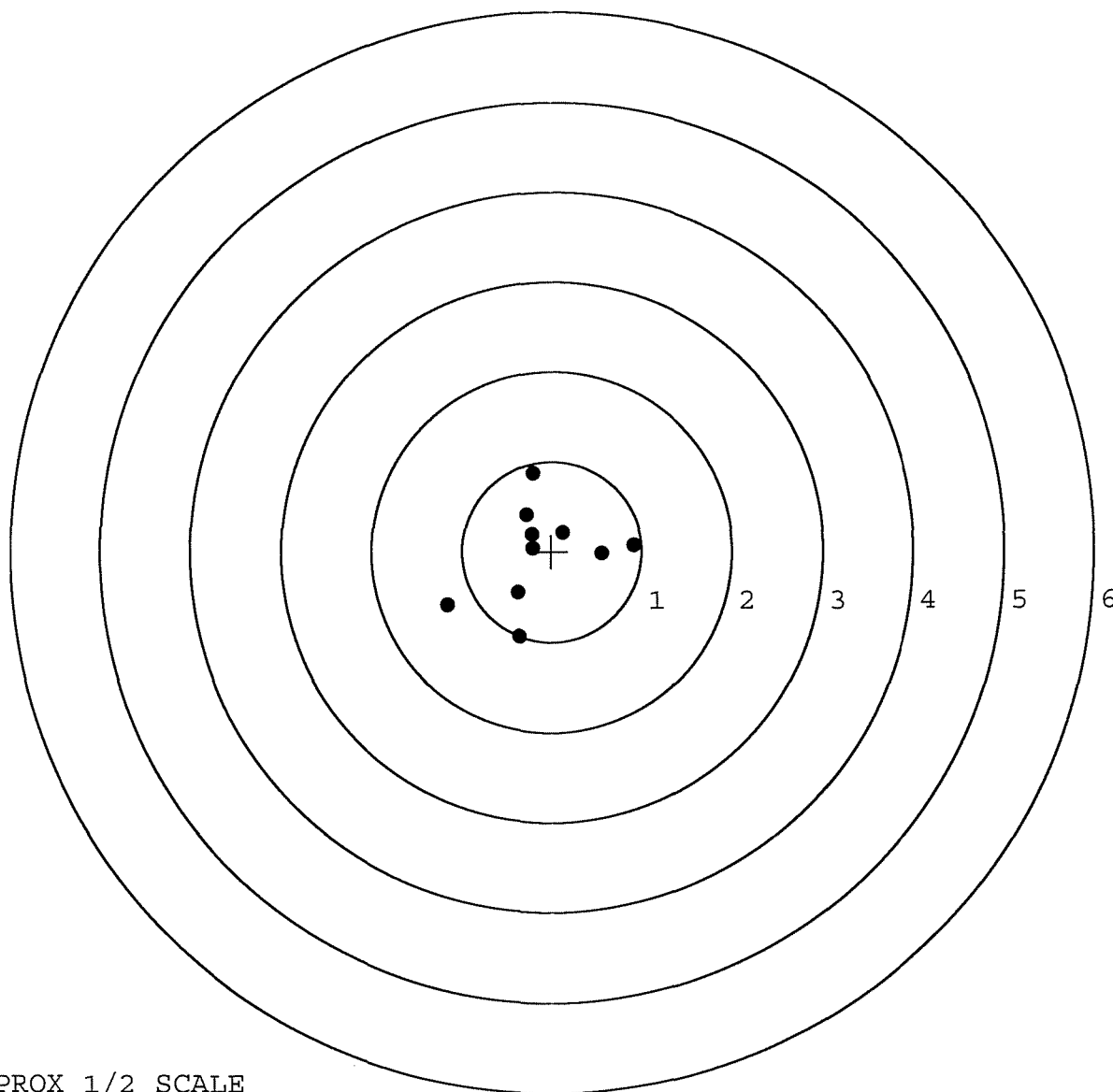


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6523349. __0
 TARGET NUMBER: 5
 FILE DATE: 03/13/2002
 FILE TIME: 10:52

X CENTROID: -0.120
 Y CENTROID: -0.024
 POA TO CENTROID: 0.123
 HORZ SPREAD: 2.081
 VERT SPREAD: 1.809
 GROUP SPREAD: 2.185
 MIN RADIUS: 0.107
 MAX RADIUS: 1.191
 MEAN RADIUS: 0.641
 # IN 1 IN DIAMETER: 4
 # IN 2 IN DIAMETER: 8
 # in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.917	0.066
2:	0.561	-0.027
3:	-0.361	-0.941
4:	-0.375	-0.460
5:	-1.164	-0.599
6:	-0.208	0.038
7:	0.131	0.213
8:	-0.281	0.408
9:	-0.214	0.191
10:	-0.211	0.868



TARGET APPROX 1/2 SCALE

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

R & E NUMBER 42314

SERIAL NUMBER C 658 3349

LOG-IN DATE 2/26/02

INSPECT AND VERIFY:			
OPERATION #	OPERATION NAME	DATE	INITIAL
550	DIS-ASSEMBLE GUN	3/1/02	RH
560 A	RE-BARREL AT CUSTOM SHOP	3/5/02	RH
B	DRILL AND TAP	3/5/02	RH
C	POLISH		
575	ASSEMBLE	3/6/02	RH
600	PROOF	3-6-02	MAGNA-FLUX INSPECTED
605	CHECK HEADSPACE	3-6-02	MAR 2002
610	DIS-ASSEMBLE GUN	3/6/02	RH
612	MAGNAFLUX		OPERATOR RH
615	ROLLMARK CALIBER	3/7/02	TLD
618	ROTO-BLAST	3/8	JW
620	APPLY COATINGS	3-8	TA
625 A	FINAL ASSEMBLY	3/13/02	RH
B	TRIGGER PULL TEST		
C	SAFETY "ON" FORCE		
D	SAFETY "OFF" FORCE		
E	FIRING PIN INDENT		
640	TARGET	3-14-02	RW
655	FINAL INSPECT	3-14-02	RW
660	PACK	3-15-02	RH
		3-15-02	DA
		SHIP DATE	
		QAR INSPECTION DATE	

Remington®

MODEL 700™ M24

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

DUPONT
REG. U.S. PAT. & T.M. OFF.

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

SERIAL NO.
C6523349

ORDER NO.
5716

01

5716 C6523349

UPC

0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6523349

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	9 25 90	90	RW
600	Proof	9 25 90	90	RW
607	Check Headspace	9 25 90	90	RW
610	Dis-assemble Gun	9 25 90	90	RW
612	Magnaflux Barrel Action		9-26-90	KR
	Magnaflux Bolt		9-26-90	KR
615	Rollmark Caliber		9-26-90	JL
617	Drill and Tap Sight Holes		9/28/90	LB
618	Polish Barrel AB		10/1/90	WB
620	Apply Coatings (Barrel Action)		10-5-90	TA
	Apply Coating (Bolt)		10-5-90	TA
625	Final Assembly			
	A) Clean inside of Bolt Assembly		10/8/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/8/90	RW
	C) Inspect Ejector Hole for Chamfer		10/8/90	RW
	D) Oil Firing Pin Ass'y		10/8/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		10/16/90	JL

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			10/17/90	WB
	G) Safety Off Force	2	2	2			10/17/90	WB
	H) Trigger Pull Test & Retainability						10/16/90	glt.
	I) Firing Pin Indent	0205	0205	0205			10/17/90	WB
	J) Assemble Stock						10/22/90	RW
	K) Assemble Swivel Studs						20/80/90	JSJ
	L) Attach Front and Rear Sight Assemblies						10/22/90	RW
	M) Iron Sight Alignment						10/24/90	RW
	N) Detach Front & Rear Sights & place in numbered container						10/22/90	RW
	O) Attach Scope to Rifle						10/23/90	RW
	P) Detach & Attach Scope 20 Times						10/23/90	RW
640	Gallery Target & Test						10-25-90	KT
	A) Time						10-25-90	KT
	B) Malfunctions						10-25-90	KT
	C) Pierced Primers						10-25-90	KT
	D) Optical Clarity of Scope						10-25-90	KT
645	Inspect for Live Ammo						10-25-90	KT
655	Final Inspection							
	A) Headspace						20/80/90	JSJ
	B) Trigger Pull	232	243	247	248	252	20/80/90	JSJ
	C) Function						20/80/90	JSJ
660	Pack						12-17-90	DH

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

SERIAL NO. C6523349DATE 10/16/98TESTER JL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.19	2.41	2.19	2.32	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.19	2.41	2.29	2.43	
PULL #3	2.50	2.28	2.36	2.47	
PULL #4	2.47	2.22	2.41	2.48	
PULL #5	2.32	2.30	2.27	2.52	
TOTAL	11.67	11.62	11.52		
AVG.	2.334	2.324	2.304		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.30	3.27		
PULL #2	3.27	3.36		
PULL #3	3.27	3.31		
PULL #4	3.27	3.37		
PULL #5	3.26	3.33		
TOTAL	16.32	16.64		
AVG.	3.264	3.328		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.33	4.32		4.29
PULL #2	4.26	4.30		4.30
PULL #3	4.29	4.28		4.26
PULL #4	4.18	4.31		4.23
PULL #5	4.30	4.30		4.29
TOTAL	21.36	21.51		21.37
AVG.	4.272	4.302		4.274

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06523349
26 Oct 1990

CENTROIDAL DISTANCES

0 TO 1	.0877838
1 TO 2	.268555
1 TO 3	.282846
1 TO 4	.428077
1 TO 5	.174642

4E (----FOR

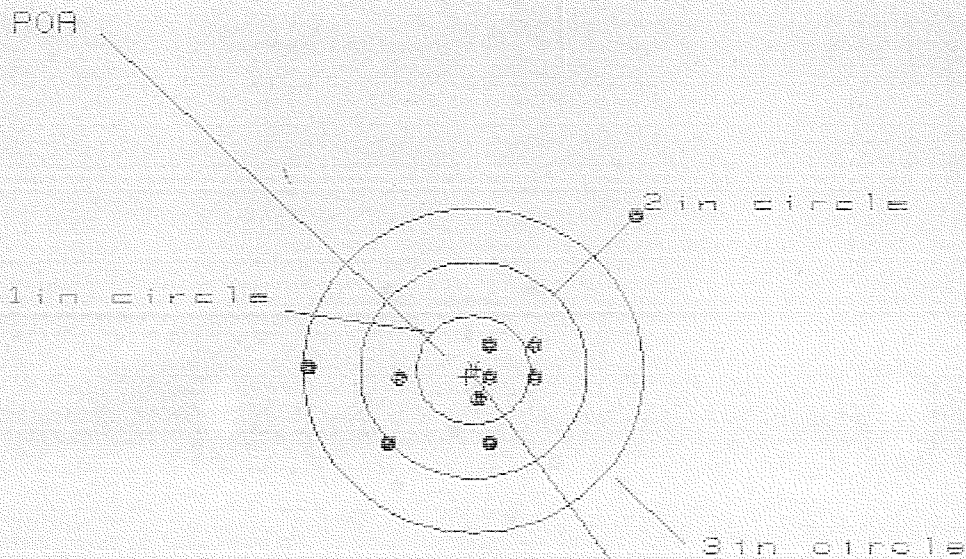
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0296
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0948
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0999136
THE AMR FOR THIS RIFLE IS: .863

26 Oct 1998

FILE:/PATTERNING/CENTERFIRE_PATT/06323349

CENTERFIRE PATTERNS

1



OF SHOTS- 10

IN CIR

1 in = 4

2 in = 8

3 in = 9

HS= 2.836

VS= 2.090

GS= 3.153

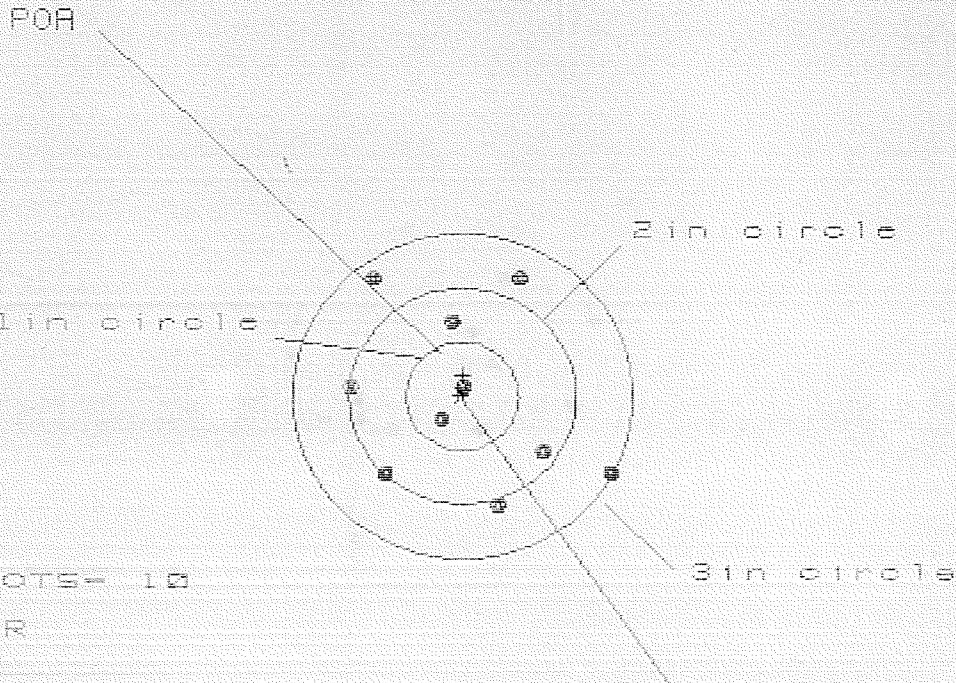
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.415	.730	.573
MINIMUM X	-1.421	-1.264	-.713
MAXIMUM Y	1.388	.389	.409
MINIMUM Y	-.702	-.547	-.527
CENTROID X	.059	-.098	.059
CENTROID Y	.065	-.090	-.110
POA TO CENTROID in.	.087	.133	.125
MIN RADIUS	.187	.197	.104
MEAN RADIUS	.759	.626	.500
MAX RADIUS	1.982	1.274	.971
HORIZONTAL SPREAD	2.836	1.994	1.285
VERTICAL SPREAD	2.090	.936	.936
EXTREME SPREAD	3.153	2.006	1.575
NUMBER IN ONE INCH CIRCLE =	4		
NUMBER IN TWO INCH CIRCLE =	8		
NUMBER IN THREE INCH CIRCLE =	9		

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CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1in = 2

2in = 4

3in = 10

HS= 2.314

VS= 2.113

GS= 2.769

CENTROID #

PATTERN #	:	2	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.312	.862	.785
MINIMUM X	:	-1.002	-.857	-.934
MAXIMUM Y	:	1.116	1.036	1.165
MINIMUM Y	:	-.997	-1.077	-.948
CENTROID X	:	-.012	-.157	-.030
CENTROID Y	:	-.194	-.114	-.243
POA TO CENTROID in.	:	.194	.194	.256
MIN RADIUS	:	.100	.128	.155
MEAN RADIUS	:	.909	.832	.775
MAX RADIUS	:	1.496	1.207	1.285
HORIZONTAL SPREAD	:	2.314	1.719	1.719
VERTICAL SPREAD	:	2.113	2.113	2.113
EXTREME SPREAD	:	2.769	2.375	2.169
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 3

POA

1in circle

2in circle

3in circle

OF SHOTS = 10

IN CIR

1in = 3

2in = 6

3in = 10

HS = 2.394

VS = 1.424

GS = 2.560

CENTROID #

PATTERN #	3	3	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.234	1.201	1.073
MINIMUM X	-1.160	-1.023	-.854
MAXIMUM Y	.936	1.001	.968
MINIMUM Y	-.488	-.423	-.456
CENTROID X	-.140	-.277	-.149
CENTROID Y	-.136	-.201	-.168
POA TO CENTROID in.	.195	.342	.225
MIN RADIUS	.356	.501	.376
MEAN RADIUS	.844	.781	.734
MAX RADIUS	1.364	1.213	1.092
HORIZONTAL SPREAD	2.394	2.224	1.927
VERTICAL SPREAD	1.424	1.424	1.424
EXTREME SPREAD	2.560	2.226	1.928
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		10	

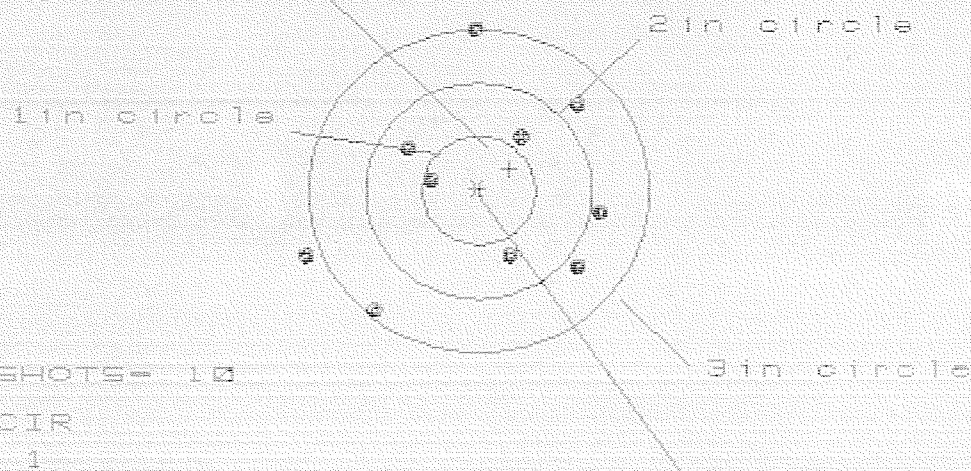
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CENTERFIRE PATTERNS

4

POR



OF SHOTS= 10

IN CIR

1in = 1

2in = 4

3in = 8

HS= 2.640

VS= 2.638

GS= 2.773

CENTROID *

PATTERN #

4

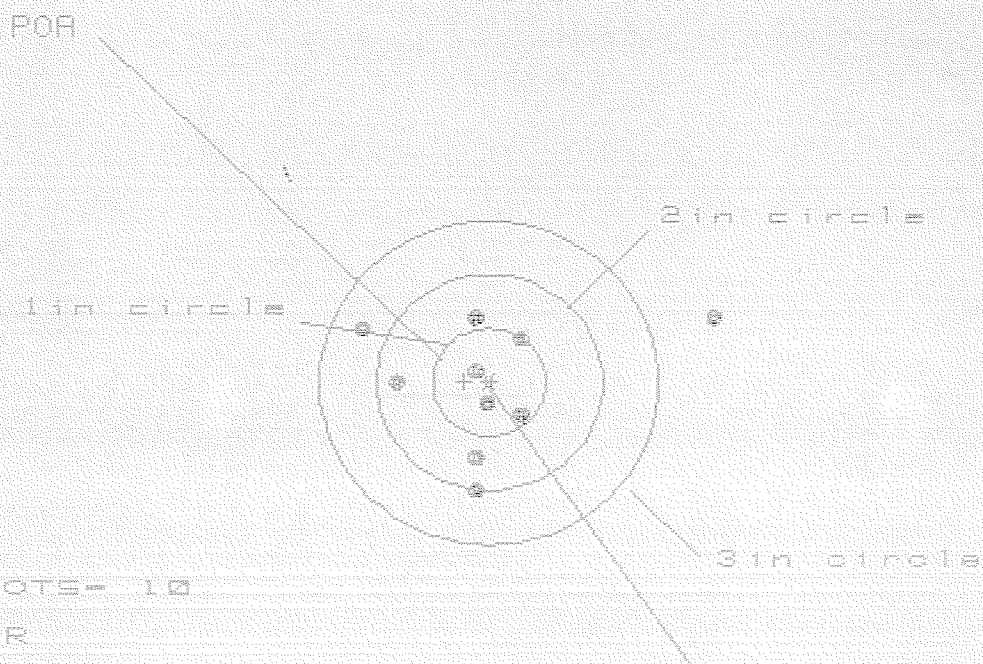
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.111	.941	.913
MINIMUM X	-1.529	-1.075	-1.103
MAXIMUM Y	1.503	1.431	.875
MINIMUM Y	-1.135	-1.207	-1.028
CENTROID X	-.274	-.104	-.076
CENTROID Y	-.204	-.132	-.311
POR TO CENTROID in.	.341	.168	.320
MIN RADIUS	.427	.505	.540
MEAN RADIUS	1.047	.963	.896
MAX RADIUS	1.658	1.616	1.507
HORIZONTAL SPREAD	2.640	2.016	2.016
VERTICAL SPREAD	2.638	2.638	1.903
EXTREME SPREAD	2.773	2.773	2.585
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		4	
NUMBER IN THREE INCH CIRCLE =		8	

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CENTERFIRE PATTERNS

5



OF SHOTS= 10

IN CIR

1 in = 4

2 in = 8

3 in = 9

HS= 3.111

VS= 1.582

GS= 3.114

CENTROID *

PATTERN

SHOTS (BEST OF)

	10	9	8
MAXIMUM X	1.943	.506	.387
MINIMUM X	-1.168	-.952	-.705
MAXIMUM Y	.598	.624	.689
MINIMUM Y	-.984	-.918	-.853
CENTROID X	.219	.003	.122
CENTROID Y	-.005	-.071	-.136
POA TO CENTROID in.	.219	.071	.183
MIN RADIUS	.136	.198	.066
MEAN RADIUS	.756	.610	.522
MAX RADIUS	2.033	1.086	.855
HORIZONTAL SPREAD	3.111	1.458	1.092
VERTICAL SPREAD	1.582	1.542	1.542
EXTREME SPREAD	3.114	1.756	1.543
NUMBER IN ONE INCH CIRCLE =		4	
NUMBER IN TWO INCH CIRCLE =		8	
NUMBER IN THREE INCH CIRCLE =		9	

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

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

SERIAL NO. C6523349DATE 12-19-94TESTER Bm

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.70	2.48	2.52		MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.66	2.58	2.46		
PULL #3	2.61	2.60	2.48		
PULL #4	2.55	2.65	2.46		
PULL #5	2.53	2.54	2.57		
TOTAL	13.05	12.85	12.49		
AVG.	2.61	2.57	2.49		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.09	2.99		
PULL #2	3.05	2.97		
PULL #3	3.06	2.98		
PULL #4	3.11	3.28		
PULL #5	3.06	3.19		
TOTAL	15.37	15.41		
AVG.	3.07	3.08		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.17	4.04		4.02
PULL #2	4.04	4.09		4.03
PULL #3	4.24	4.22		4.23
PULL #4	4.27	3.99		4.18
PULL #5	4.00	4.25		3.99
TOTAL	20.72	20.59		20.45
AVG.	4.14	4.11		4.09

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6523349

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			

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			12/1	WB
	G) Safety Off Force	2 1/4	2 1/4	2 1/4			12/1	WB
	H) Trigger Pull Test & Retainability							
	I) Firing Pin Indent							
	J) Assemble Stock							
	K) Assemble Swivel Studs							
	L) Attach Front and Rear Sight Assemblies							
	M) Iron Sight Alignment							
	N) Detach Front & Rear Sights & place in numbered container							
	O) Attach Scope to Rifle							
	P) Detach & Attach Scope 20 Times							
640	Gallery Target & Test							
	A) Time							
	B) Malfunctions							
	C) Pierced Primers							
	D) Optical Clarity of Scope							
645	Inspect for Live Ammo							
655	Final Inspection							
	A) Headspace							
	B) Trigger Pull	2.82	2.82	2.79	2.82	2.79	12/1	WB
	C) Function							
660	Pack							