

G 641 4431
Rapha
C. 622 5246

Repair Inquiry

Repair Number: RE00085920

Serial: C6225246 Model: M24 SWS Center Fire
Caliber: 7.62 NATO

Repairman:

Status:

Closed 10/4/2004 10:52:09 AM

Address Information

Customer:

☒ Received From

Return To:

☐ Received From

Name: TRANSPORTATION OFFICER

TRANSPORTATION OFFICER

Address 1: SENSITIVE STORAGE

SENSITIVE STORAGE

Address 2: BLDG 9660

PO Box:

BLDG 9660

PO Box:

City: FORT LEWIS

FORT LEWIS

State: WA

Zip Code: 98433

Country: US

State: WA

Zip Code: 98433

Country: US

FFL:

Contact / Condition

Problems

Estimate

History / Status

Shipping / Billing

Contact Information

Phone: 253-967-5516

Fax:

Email:

Comments:

Received Condition

Fair

Condition

Notes:

CSR

Notes:

Accessories Received

Code	Desc	Qty
A007	With Studs	3
A017	Scope Bases	3

Repair Search

Refresh

Close

naglej

10/4/2004

11:26 AM

CAPS

NUM

INS

SCPL

start

3

4

Arms Services

M24

M24

G 6414431 DA 9-1405

~~C6360985~~ (New)~~C6225246~~

Model: M24 SWS



RE00085920

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6414431.____0

FILE DATE AND TIME: 11/10/2004 08:52

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.163
The Average Y Centroid of the Five Target Set:	0.129
The Average Point of Impact of the Five Target Set:	0.208
The Average Mean Radius of the Five Target Set:	0.682
The Distance from POA to Centroid Target #1:	0.155
The Distance from Centroid Target #2 to Centroid Target #1:	0.186
The Distance from Centroid Target #3 to Centroid Target #1:	0.240
The Distance from Centroid Target #4 to Centroid Target #1:	0.173
The Distance from Centroid Target #5 to Centroid Target #1:	0.118

BARBER - M24 0152370

SERIAL NUMBER: G6414431.____0

TARGET NUMBER: 1

FILE DATE: 11/10/2004

FILE TIME: 08:52

POINT#	X	Y
1:	2.045	1.168
2:	0.451	0.628
3:	0.587	0.223
4:	0.449	0.075
5:	0.722	-0.015
6:	-0.194	-1.463
7:	-0.058	-0.606
8:	-0.377	0.250
9:	-0.534	0.730
10:	-1.737	-0.243

X CENTROID: 0.135

Y CENTROID: 0.075

POA TO CENTROID: 0.155

HORZ SPREAD: 3.782

VERT SPREAD: 2.631

GROUP SPREAD: 4.037

MIN RADIUS: 0.314

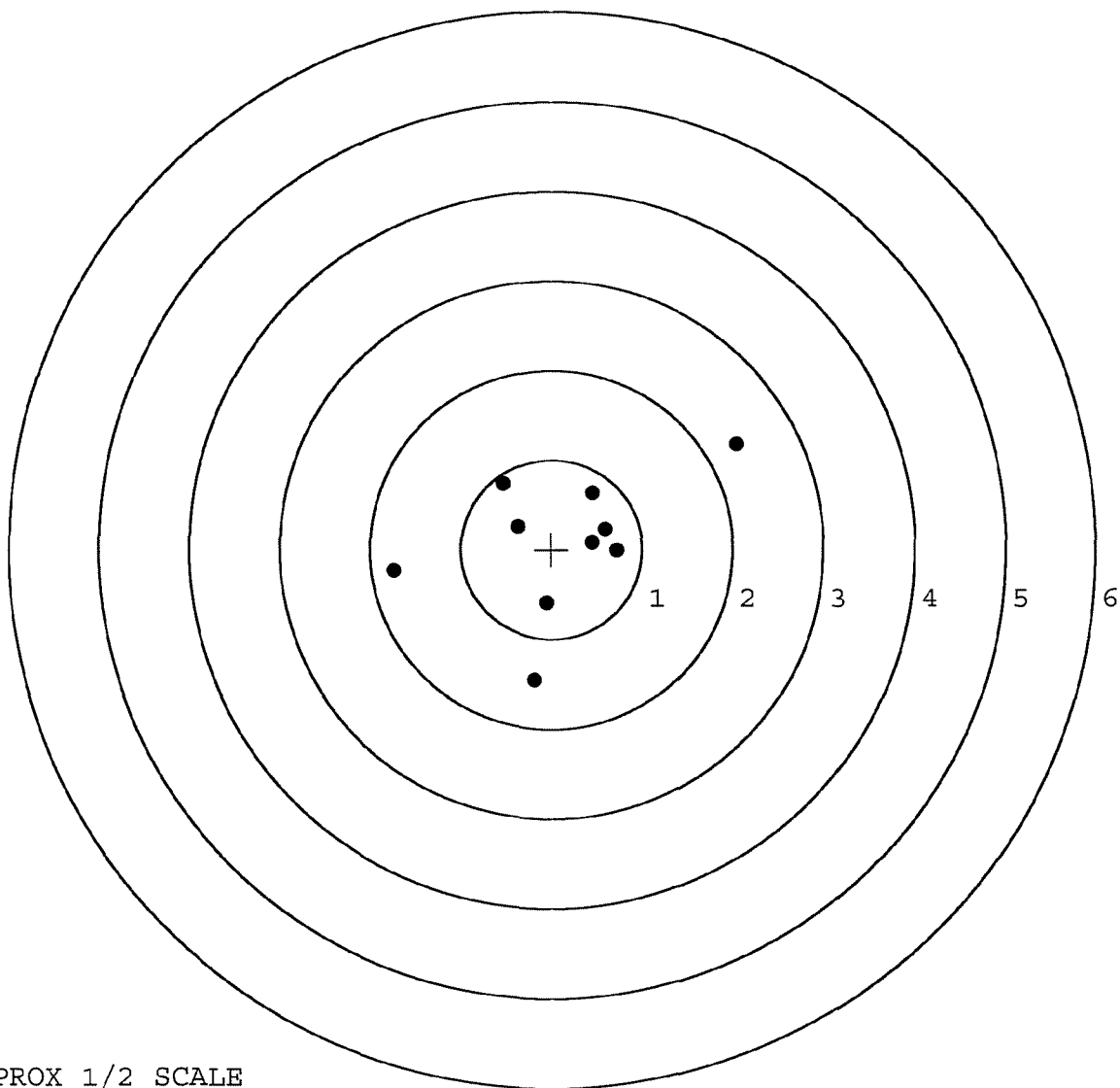
MAX RADIUS: 2.200

MEAN RADIUS: 0.988

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 7



TARGET APPROX 1/2 SCALE

BARBER - M24 0152371

SERIAL NUMBER: G6414431. __0

TARGET NUMBER: 2

FILE DATE: 11/10/2004

FILE TIME: 08:52

POINT#	X	Y
1:	0.065	0.904
2:	0.540	0.685
3:	0.851	0.685
4:	1.561	0.194
5:	0.557	-0.351
6:	0.330	0.276
7:	0.158	-0.086
8:	-0.202	-0.122
9:	-0.509	-0.309
10:	-0.280	-0.418

X CENTROID: 0.307

Y CENTROID: 0.146

POA TO CENTROID: 0.340

HORZ SPREAD: 2.070

VERT SPREAD: 1.322

GROUP SPREAD: 2.130

MIN RADIUS: 0.132

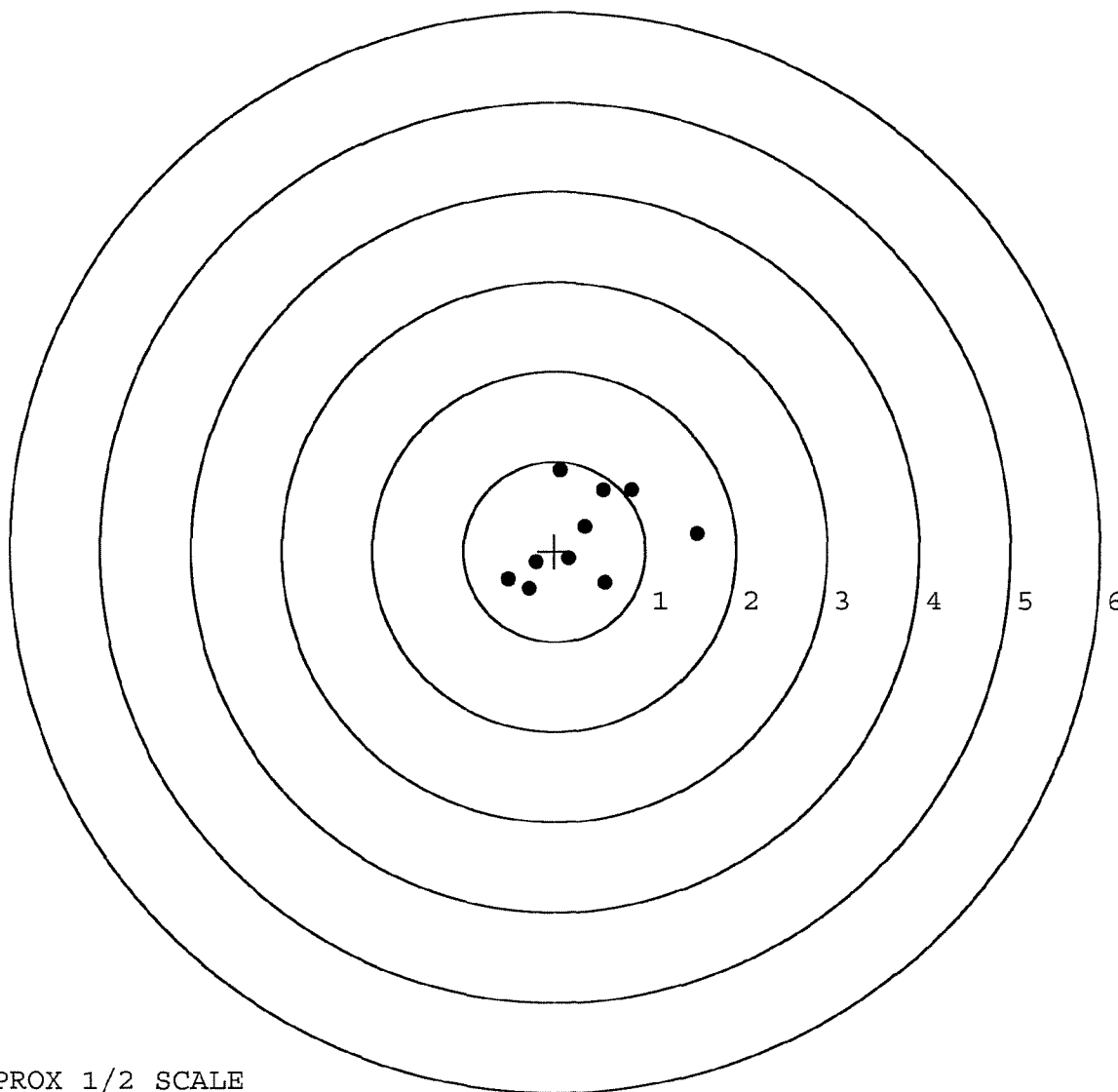
MAX RADIUS: 1.255

MEAN RADIUS: 0.669

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

BARBER - M24 0152372

SERIAL NUMBER: G6414431. __0

TARGET NUMBER: 3

FILE DATE: 11/10/2004

FILE TIME: 08:52

POINT#	X	Y
1:	1.782	0.856
2:	0.025	1.362
3:	-0.261	0.502
4:	-1.434	0.312
5:	0.349	0.051
6:	0.199	0.360
7:	-0.154	-0.385
8:	0.024	-0.122
9:	-0.045	0.070
10:	-0.120	-0.072

X CENTROID: 0.037

Y CENTROID: 0.293

POA TO CENTROID: 0.296

HORZ SPREAD: 3.216

VERT SPREAD: 1.747

GROUP SPREAD: 3.262

MIN RADIUS: 0.176

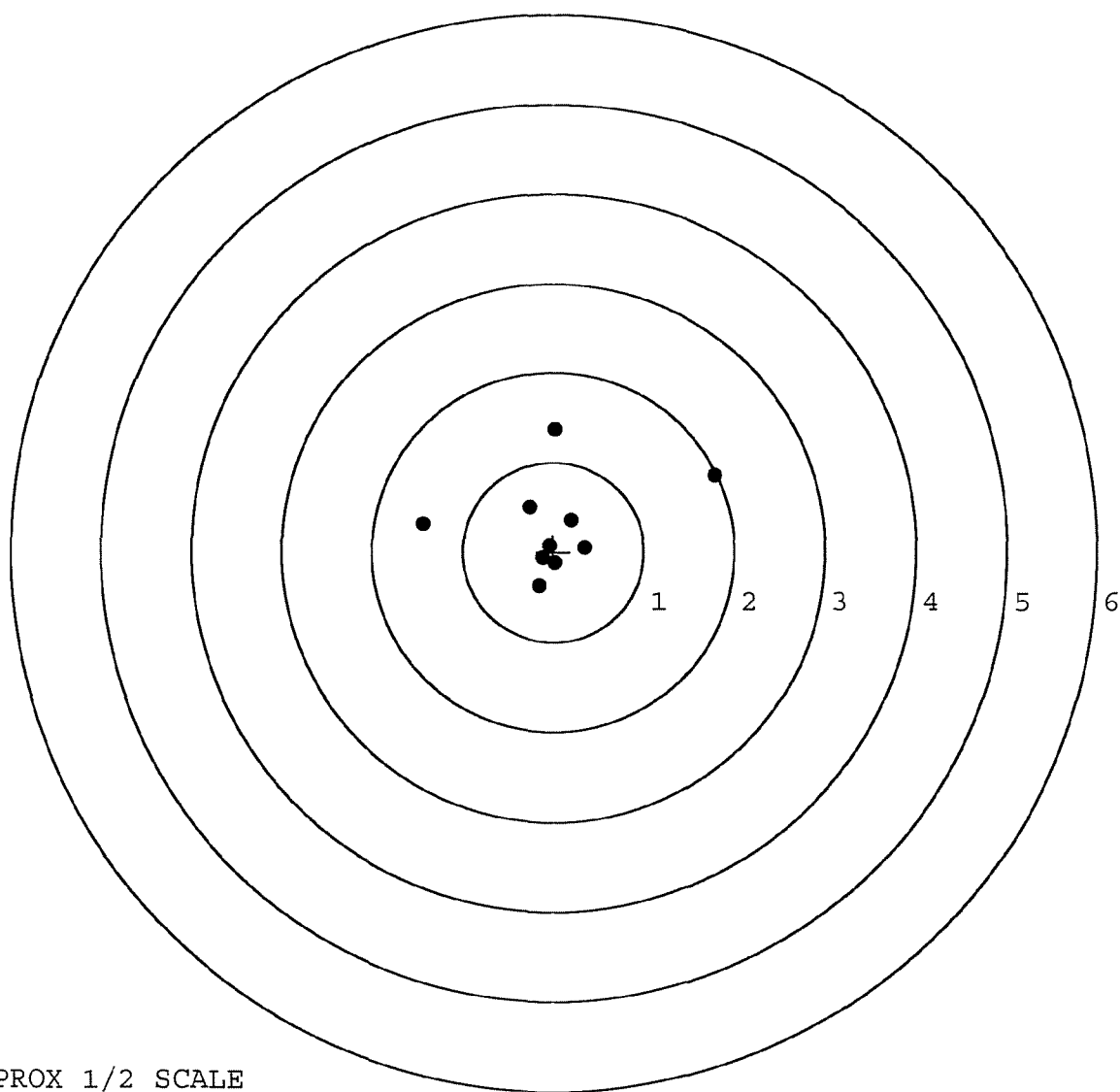
MAX RADIUS: 1.834

MEAN RADIUS: 0.706

IN 1 IN DIAMETER: 6

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

BARBER - M24 0152373

SERIAL NUMBER: G6414431. __0

TARGET NUMBER: 4

FILE DATE: 11/10/2004

FILE TIME: 08:52

POINT#	X	Y
1:	1.191	0.126
2:	0.686	0.061
3:	0.625	0.325
4:	0.547	0.635
5:	0.070	1.273
6:	0.136	-0.879
7:	-0.197	-0.521
8:	-0.174	-0.191
9:	0.120	0.290
10:	0.037	-0.009

X CENTROID: 0.304

Y CENTROID: 0.111

POA TO CENTROID: 0.324

HORZ SPREAD: 1.388

VERT SPREAD: 2.152

GROUP SPREAD: 2.153

MIN RADIUS: 0.257

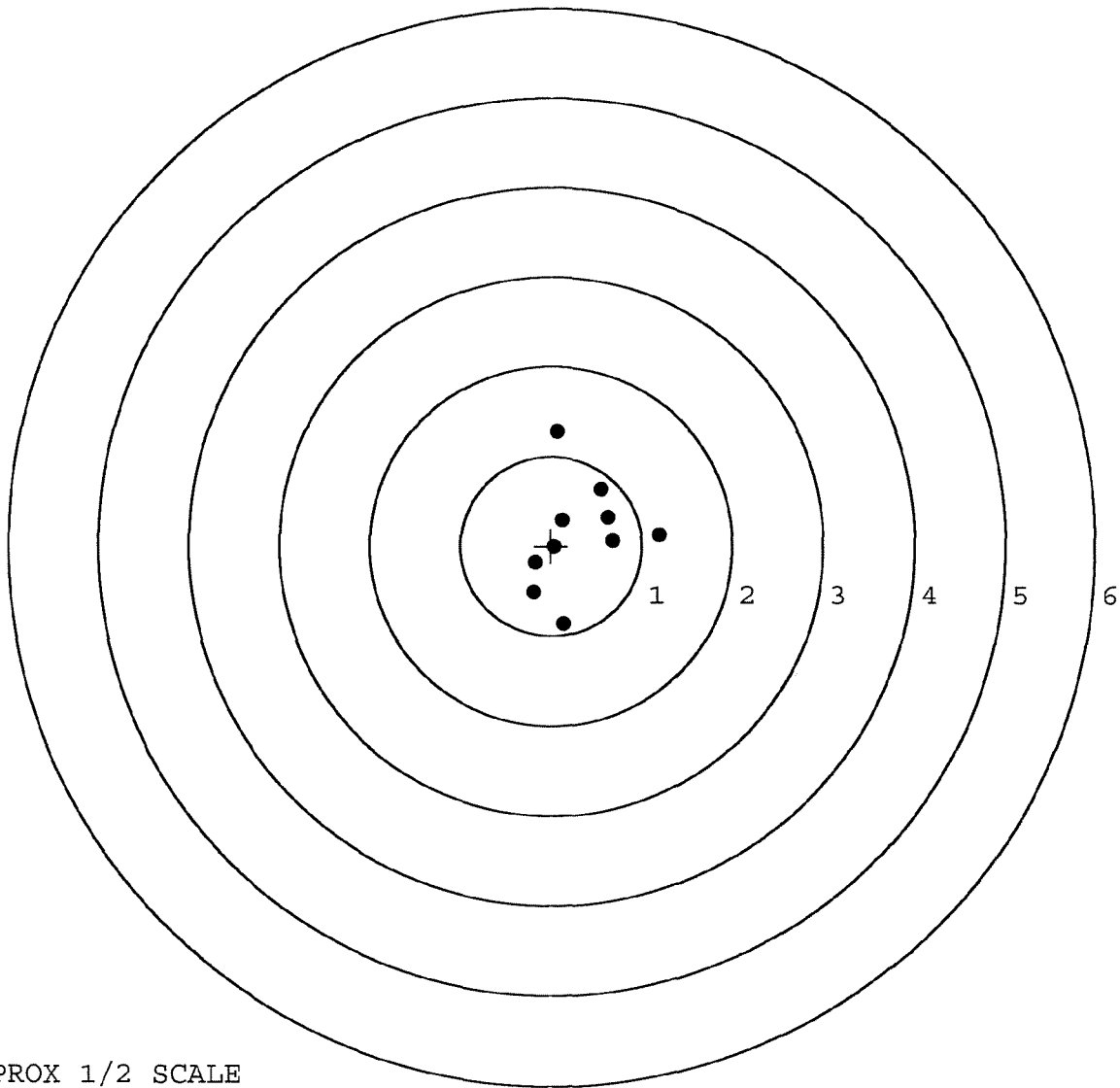
MAX RADIUS: 1.185

MEAN RADIUS: 0.635

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

BARBER - M24 0152374

SERIAL NUMBER: G6414431.____0

TARGET NUMBER: 5

FILE DATE: 11/10/2004

FILE TIME: 08:52

POINT#	X	Y
1:	-0.214	0.394
2:	-0.642	0.100
3:	0.539	0.673
4:	0.353	-0.324
5:	0.263	-0.076
6:	0.025	-0.651
7:	-0.044	0.059
8:	0.092	-0.033
9:	-0.266	0.235
10:	0.191	-0.159

X CENTROID: 0.030

Y CENTROID: 0.022

POA TO CENTROID: 0.037

HORZ SPREAD: 1.181

VERT SPREAD: 1.324

GROUP SPREAD: 1.420

MIN RADIUS: 0.083

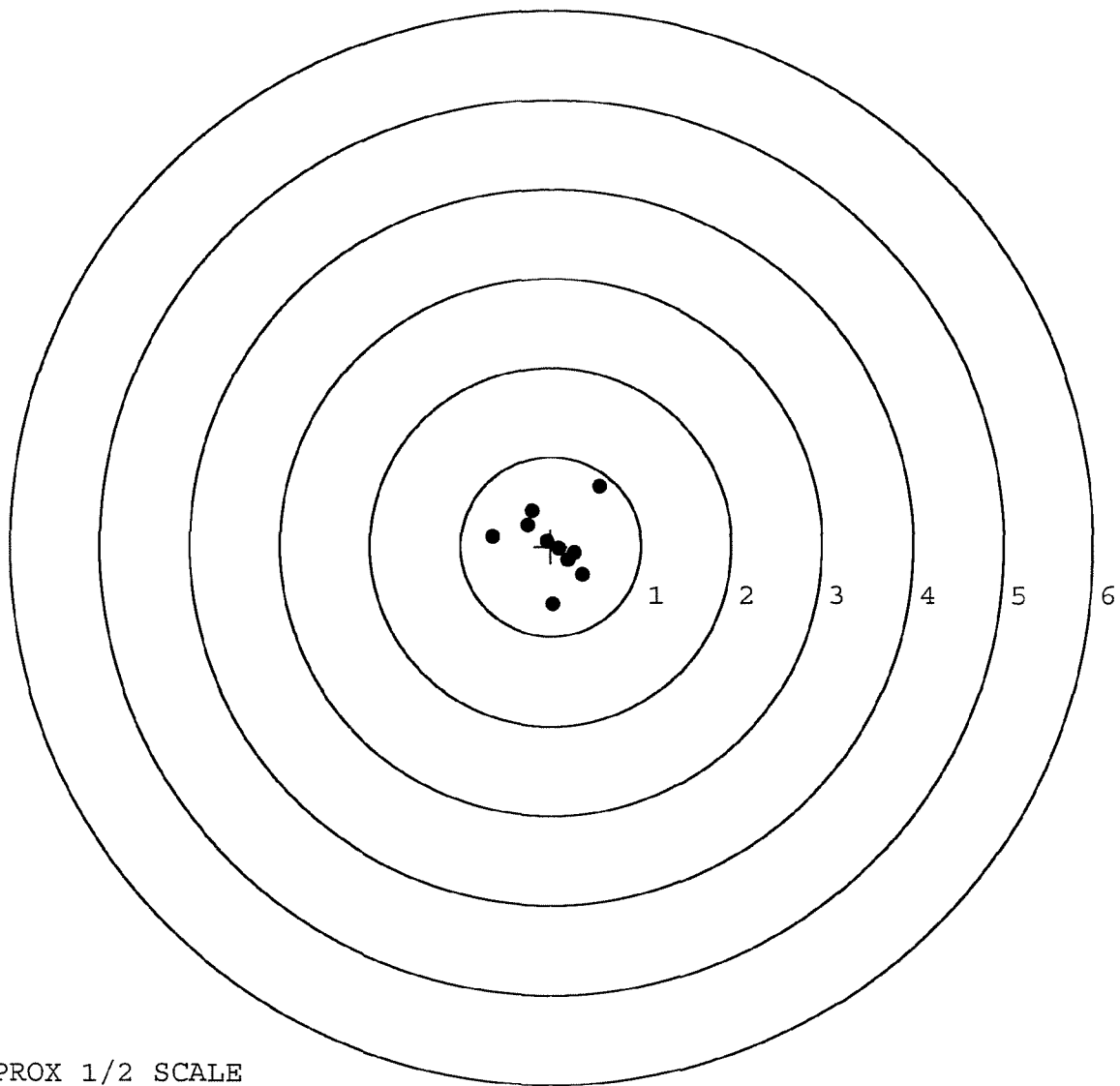
MAX RADIUS: 0.827

MEAN RADIUS: 0.412

IN 1 IN DIAMETER: 7

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL # G6411443INSPECTED BY: RTZDATE REC'D: 10-4-04DATE RET'D: 11-10-04

ITEM

BARREL ASSEMBLY

☒ BARREL
☒ RECEIVER
☒ FRONT SIGHT BASE
☒ REAR SIGHT BASE
☒ SCREWS
☒ FINISH

SCOPE ASSEMBLY

☒ SCOPE
☒ SCOPE RINGS
☒ MOUNTING SCREWS
☒ MOUNTING BASE
☒ SCREWS
☒ FINISH
☒ CLARITY

ITEM

STOCK ASSEMBLY

☒ STOCK
☒ SLING AWIVEL STUDS
☒ ADJUSTABLE
☒ BUTT PLATE
☒ LOCK NUTS
☒ BARREL CLEARANCE
☒ COLOR / FINISH

SYSTEMS CASE

☒ SCOPE CASE
☒ IRON SIGHTS
☒ DEPLOYMENT KIT

TRIGGER ASSEMBLY

☒ SAFETY OPERATION
☒ RE-SET TO FACTORY SPECS

COMMENTS:

**CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON**

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6225246

OP. #	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and stock	8	9/88	FB
600	Proof	9	7/88	RW
607	Check Headspace	9	7/88	RW
610	Dis-assemble gun	8	7/88	RW
612	Magnaflux Barrel Action		9-14-88	pfe.
	Magnaflux Bolt		9-14-88	pfe
615	Rollmark Caliber			
617	Drill & Tap Sight Holes			
618	Polish Barrel			
620	Apply Coatings (Barrel Action)		10-31-88	TJA
	Apply Coatings (Bolt)		10-31-88	TJA
625	Final Assembly A) Clean inside of Bolt Assembly		11/2/88	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		11/2/88	RW
	C) Inspect Ejector Hole for Chamfer		11/2/88	RW

OVER

OP.#		READINGS	DATE	INITIAL
625	D) Oil Firing Pin Ass'y		11/2/88	RW
cont.	E) Adjust Trigger Pull to Min. Setting and Stake		2 NOV 88	JS
	F) Safety on Force	5 5 5	2 NOV 88	JS
	G) Safety off Force	3 3 3	2 NOV 88	JS
	H) Trigger Pull Test & Retainability		2 NOV 88	JS
	I) Firing Pin Indent	.020 .020 .0205	2 NOV 88	JS
	J) Assemble Stock		11/9/88	RW
	K) Attach Front & Rear Sight Assemblies		11/9/88	RW
	L) Iron Sight Alignment		11/9/88	RW
	M) Detach Front & Rear Sights & place in numbered container		11/9/88	RW
	N) Attach Scope to Rifle		11/9/88	JS
	O) Detach & Attach Scope 20 times			
640	Gallery Target & Test	68R 82L	11/14/88	DH
	A) Optical Clarity of Scope		11/14/88	DH
645	Inspect for Live Ammo		11/14/88	DH
655	Final Inspection			
	A) Headspace		30 NOV 88	JS
	B) Trigger Pull	2.74 2.77 2.77	2.80 2.78	JS
	C) Function		30 NOV 88	JS
	D) Assemble Swivel Studs		30 NOV 88	JS
660	Pack		14 DEC 88	JS

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6225246

DATE 31 Oct 88

TESTER J. G. + M. S.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.39	2.44	2.57	2.74	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.53	2.44	2.58	2.77	
PULL #3	2.43	2.42	2.55	2.77	
PULL #4	2.54	2.44	2.55	2.80	
PULL #5	2.43	2.45	2.55	2.78	
TOTAL	12.32	12.19	12.80	13.86	
AVG.	2.464	2.438	2.56	2.772	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.07	2.90		
PULL #2	2.98	2.88		
PULL #3	3.00	2.97		
PULL #4	2.99	2.94		
PULL #5	2.99	2.99		
TOTAL	15.03	14.68		
AVG.	3.006	2.936		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.19	4.12		4.25
PULL #2	4.20	4.19		4.23
PULL #3	4.25	4.21		4.27
PULL #4	4.26	4.25		4.26
PULL #5	4.30	4.23		4.25
TOTAL	21.20	21.06		21.26
AVG.	4.24	4.20		4.252

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6225246

CENTROIDAL DISTANCES

0 TO	1	.506004
1 TO	2	.785576
1 TO	3	.6404
1 TO	4	.205779
1 TO	5	.372828

$\frac{1}{5} \bar{x}_c$ <----POB

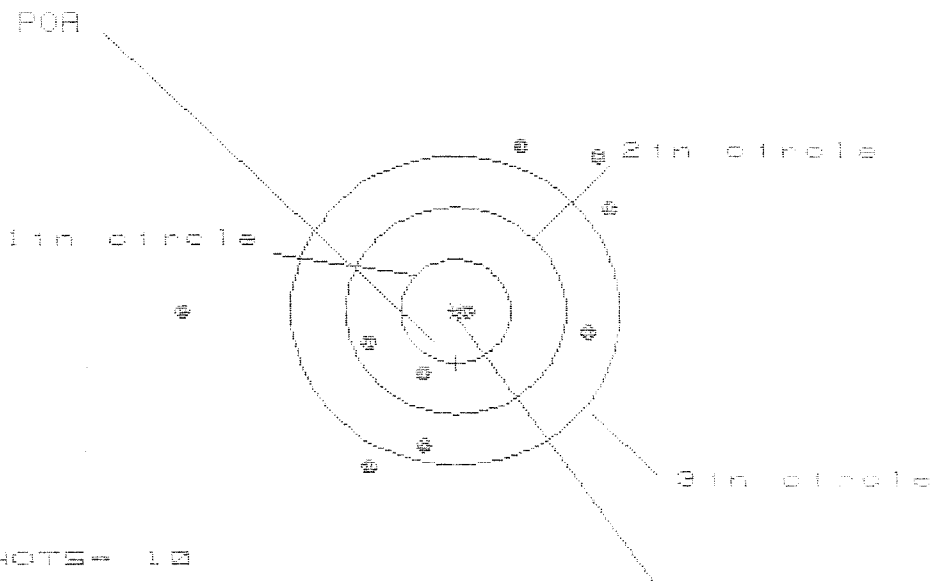
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1008
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .124
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .159802

THE AMR FOR THIS RIFLE IS: 1.171

14 Nov 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C6225246

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 3

3 in = 5

HS = 3.893

VS = 3.094

GS = 4.100

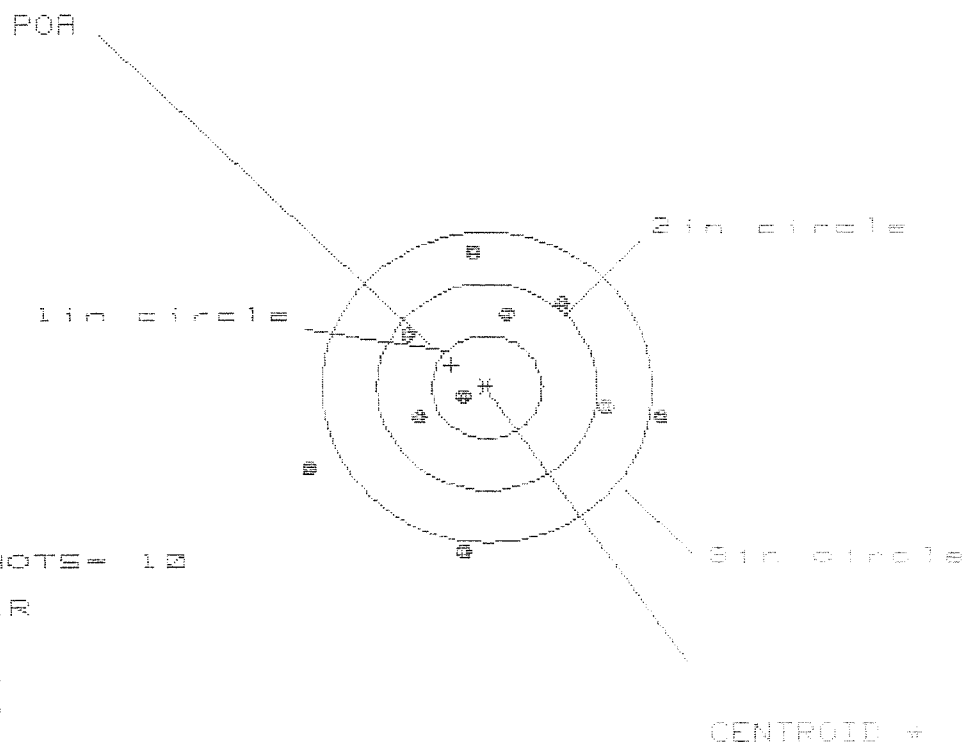
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.489	1.133	1.266
MINIMUM X	-2.484	-1.093	-0.960
MAXIMUM Y	1.618	1.613	1.794
MINIMUM Y	-1.476	-1.481	-1.300
CENTROID X	-0.002	.274	.141
CENTROID Y	.506	.511	.330
POI TO CENTROID in.	.506	.580	.358
MIN RADIUS	.159	.140	.122
MEAN RADIUS	1.385	1.251	1.143
MAX RADIUS	2.485	1.841	1.860
HORIZONTAL SPREAD	3.893	2.226	2.226
VERTICAL SPREAD	3.094	3.094	3.094
EXTREME SPREAD	4.100	3.640	3.417
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	3		
NUMBER IN THREE INCH CIRCLE =	5		

14 Nov 1988

FILE:/PATTERNING/CENTERFIRE_PATT/08285245

CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 4

3 in = 7

HS = 3.277

VS = 2.963

GS = 3.318

CENTROID +

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.626	1.443	1.040
MINIMUM X	-1.651	-0.937	-0.757
MAXIMUM Y	1.333	1.242	1.193
MINIMUM Y	-1.630	-1.721	-1.770
CENTROID X	.319	.502	.322
CENTROID Y	-.211	-.120	-.071
POA TO CENTROID in.	.383	.517	.330
MIN RADIUS	.265	.469	.360
MEAN RADIUS	1.115	1.030	.942
MAX RADIUS	1.844	1.757	1.778
HORIZONTAL SPREAD	3.277	2.380	1.797
VERTICAL SPREAD	2.963	2.963	2.963
EXTREME SPREAD	3.318	2.963	2.963
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		4	
NUMBER IN THREE INCH CIRCLE =		7	

14 Nov 1988

FILE:/PATTERNING/CENTERFIRE_PATT/08225246

CENTERFIRE PATTERNS # 3

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS = 10

IN CIR

1 in = 0

2 in = 2

3 in = 8

HS = 2.048

VS = 3.313

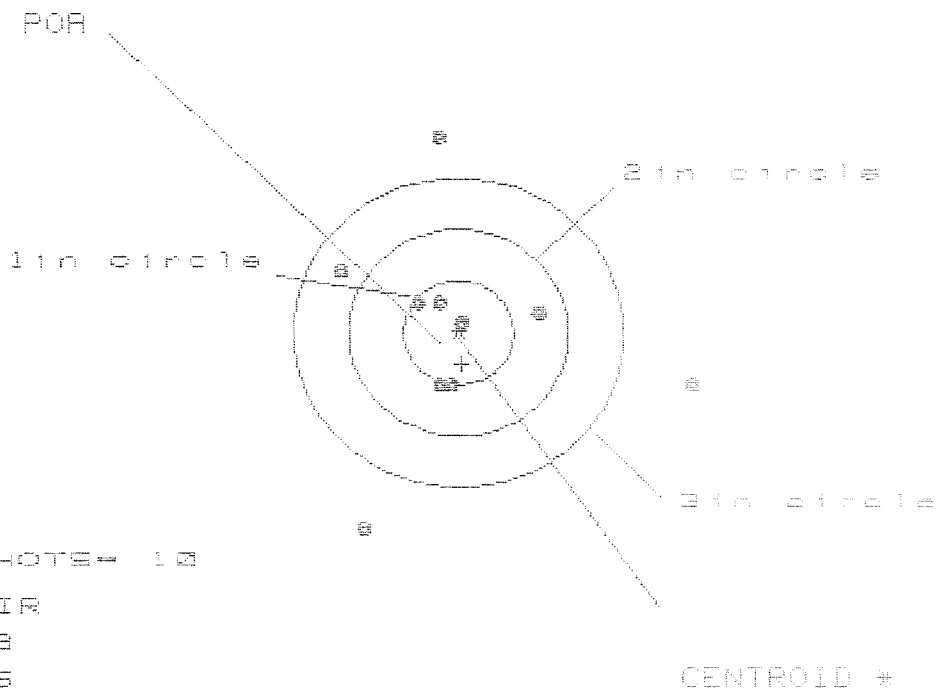
GS = 3.434

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.291	1.354	1.371
MINIMUM X	-.757	-.694	-.677
MAXIMUM Y	2.163	1.978	1.517
MINIMUM Y	-1.150	-.909	-.662
CENTROID X	.142	.079	.062
CENTROID Y	-.118	-.359	-.606
POA TO CENTROID in.	.185	.367	.609
MIN RADIUS	.646	.685	.520
MEAN RADIUS	1.240	1.069	.887
MAX RADIUS	2.238	1.982	1.519
HORIZONTAL SPREAD	2.048	2.048	2.048
VERTICAL SPREAD	3.313	2.887	2.174
EXTREME SPREAD	3.434	2.914	2.201
NUMBER IN ONE INCH CIRCLE	=	0	
NUMBER IN TWO INCH CIRCLE	=	2	
NUMBER IN THREE INCH CIRCLE	=	8	

14 NOV 1988

FILE:/PATTERNING/CENTERFIRE_PATT/08225248

CENTERFIRE PATTERNS # 4



PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	2.084	1.884	1.928
MINIMUM X	-1.022	-0.790	-0.874
MAXIMUM Y	1.922	1.863	1.615
MINIMUM Y	-1.925	-1.984	-0.805
CENTROID X	-0.029	-0.261	-0.177
CENTROID Y	0.302	0.361	0.609
POA TO CENTROID in.	0.304	0.445	0.634
MIN RADIUS	0.107	0.236	0.035
MEAN RADIUS	1.011	0.871	0.693
MAX RADIUS	2.149	2.094	1.616
HORIZONTAL SPREAD	3.106	1.794	1.794
VERTICAL SPREAD	3.847	3.847	2.420
EXTREME SPREAD	3.911	3.911	2.422
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	7		

14 Nov 1988

FILE:/PATTERNING/CENTERFIRE_PATT/08225246

CENTERFIRE PATTERNS

5

POA

1 in circle

2 in circle

3 in circle

OF SHOTS - 10

IN CIR

1 in = 2

2 in = 5

3 in = 7

HS = 2.458

VS = 1.747

GS = 3.473

CENTROID #

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	1.619
MINIMUM X	-1.839
MAXIMUM Y	1.062
MINIMUM Y	-1.685
CENTROID X	.074
CENTROID Y	.141
POA TO CENTROID in.	.160
MIN RADIUS	.360
MEAN RADIUS	1.106
MAX RADIUS	1.875
HORIZONTAL SPREAD	3.458
VERTICAL SPREAD	1.747
EXTREME SPREAD	3.473
NUMBER IN ONE INCH CIRCLE	2
NUMBER IN TWO INCH CIRCLE	5
NUMBER IN THREE INCH CIRCLE	7

RECEIVING AND ESTIMATING REPORT

BARBER - M24 0152386

COMMENTS

ORDER

R 94-22611

INITIAL
FPS

CUSTOMER ORDER NO.

M-24 ATTN: FRED MARTIN
PAINTED OUTSIDE SHOP

DATE RECEIVED

DATE OPENED

DATE CODE

SERIAL NUMBER

NEW SERIAL NUMBER

MODEL AND GRADE

08/01/94

08/02/94

DI 9-88

C6225246

700 7:32

NATO

ACCESSORIES

W/STUDS

SCOPE MNTS

SCOPE BASE

FROM:

SHIP TO:

DEPT OF THE ARMY
B CO ARMS
2/75 RANGER BATTALION
FT LEWIS

WA 98433

DEPT OF THE ARMY
B CO ARMS
2/75 RANGER BATTALION
FT LEWIS

WA

98433

CUST NO: 062072 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

New Barrel

PARTS

COMMENTS

Barrel - 96003

Repowder Coat Trigger Guard
Assy, Front & Rear Sight Bases
ReZinc Scope Base, Rings &
Swivel Studs

W52 H09 422 / #227

REPAIRMAN

PROOF

CLEAN

TEST

TARGET

PATTERN

GALLERY TESTER

DATE

DATE

DATE

DATE

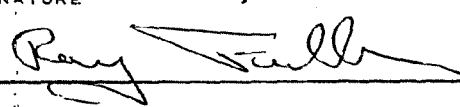
DATE

OFFICE COPY

RD6925 REV. 1/94

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

BARBER - M24 0152386 52425

BARBER - M24 0152387 PACKING LIST		PACKED BY <i>Ray Fuller</i> WG-10 Bn. Armorer	1. NO. BOXES /	2a. REQUISITION NO. 92067	
3. END ITEM 7.62mm M24 Sniper Weapons System (SW5)		4. DATE 26 July 1994		5. PAGE 1 OF 1 PAGES	
BOX NO. (a)	CONTENTS - STOCK NUMBER AND NOMENCLATURE (b)	UNIT OF ISSUE (c)	QUANTITIES REQUIRED		
			INITIAL OPERATION (d)	RUNNING SPARES (e)	TOTAL (f)
	7.62mm M24 Sniper Weapon System (SW5) Serial No. <u>C6225246</u> NSN: 1005-01-240-2136 <u>Note: All Optic Scope</u> <u>Ring mounts Packed</u>	EA			1
6. THIS CERTIFIES THAT ITEMS LISTED HEREON ARE WITHIN THE SPECIFIED BOXES					
TYPED NAME AND TITLE <i>Ray Fuller WG-10 Bn. Armorer</i>			SIGNATURE 		

DD FORM 1 SEP 70 1750

DA FORM 2407
MAY 81

Final Inspection

In: C6225246

DATE REC'D: 8/1/94

DATE RET'D:

AUDITOR: RW

Item:

BARREL ASSY.

☒ BARREL☒ RECEIVER☒ FRONT SIGHT BLOCK☒ REAR SIGHT BLOCK☒ SCREWS☒ FINISH

SCOPE ASSY.

☐ SCOPE☒ SCOPE RINGS☒ MOUNTING SCREWS☒ MOUNTING BASE☒ SCREWS☐ FINISH☐ LOOSENESS☐ CLARITY

MISC.

☐ DD-250☐ BAR CODE☐ PACKAGING

Item:

STOCK ASSY.

☒ STOCK☒ SLING SWIVEL STUDS☒ ADJUSTABLE BUTT PLATE☒ LOCK NUTS☒ BARREL CLEARANCE☒ COLOR/FINISH

SYSTEMS CASE

☐ SCOPE CASE☐ IRON SIGHTS☐ DEPLOYMENT KIT

TRIGGER

☒ SAFETY OPERATION☒ SET

Comments: _____

CONTRACT # DAAA21-87-C-0086

New Barrel

GUN SERIAL #

C6225246

OP. #	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and Stock		8/3/94	RW
600	Proof		8/3/94	RW
607	Check Headspace		8/3/94	RW
610	Dis-assemble Gun		8/3/94	RW
612	Magnaflux Barrel Action			
	Magnaflux Bolt			
615	Rollmark Caliber			
617	Drill and Tap Sight Holes			
618	Polish Barrel			
620	Apply Coatings (Barrel Action)			
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/13/94	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/13/94	RW
	C) Inspect Ejector Hole for Chamfer		8/13/94	RW
	D) Oil Firing Pin Ass'y		8/13/94	RW
	E) Adjust Trigger Pull to Min Setting and Stake			

op. #	BARBER - M24 0152391 OP. NAME	READINGS					DATE	INITIAL
625 cont.	F) Safety On Force							
	G) Safety Off Force							
	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						8/16/94	W.B
	B) Trigger Pull	2.70	2.71	2.66	2.66	2.68	8/16/94	W.B
	C) Function							
660	Pack							

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06225246
18 Aug 1994

CENTROIDAL DISTANCES

0 TO	1	.251796
1 TO	2	.330055
1 TO	3	.144589
1 TO	4	.258118
1 TO	5	.154932

4
3

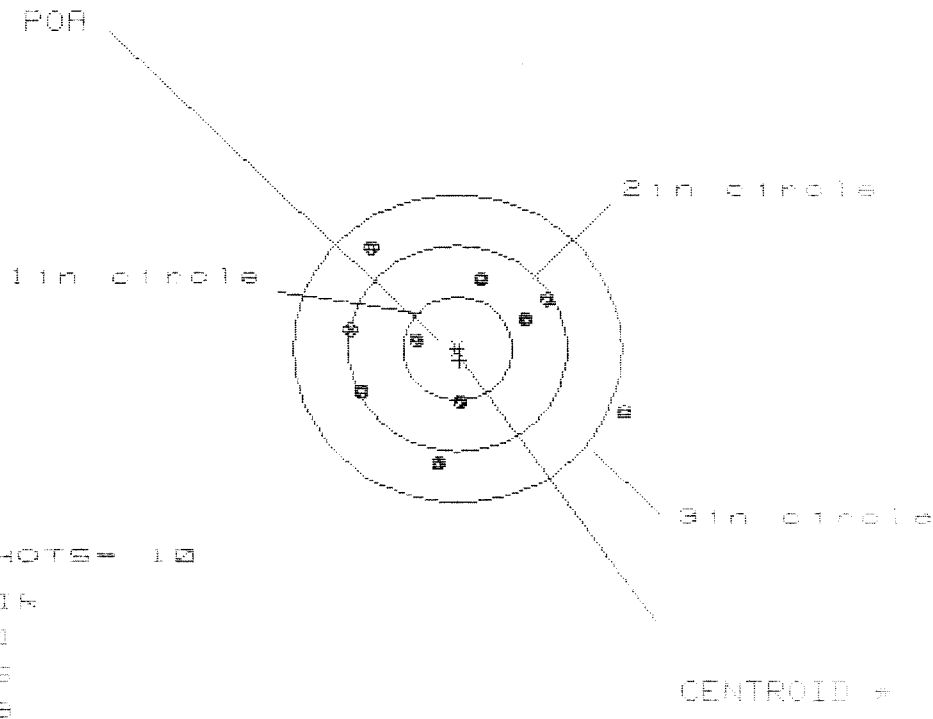
-----POA

THE AVERAGE X COORDINATE FOR THIS RIFLE IS: -.1472
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1328
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .193252
THE AMR FOR THIS RIFLE IS: .8356

16 Aug 1994

FILE:/PATTERNING/CENTERFIRE_PATT/06225246

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 6

3 in = 9

HS= 2.526

VS= 2.050

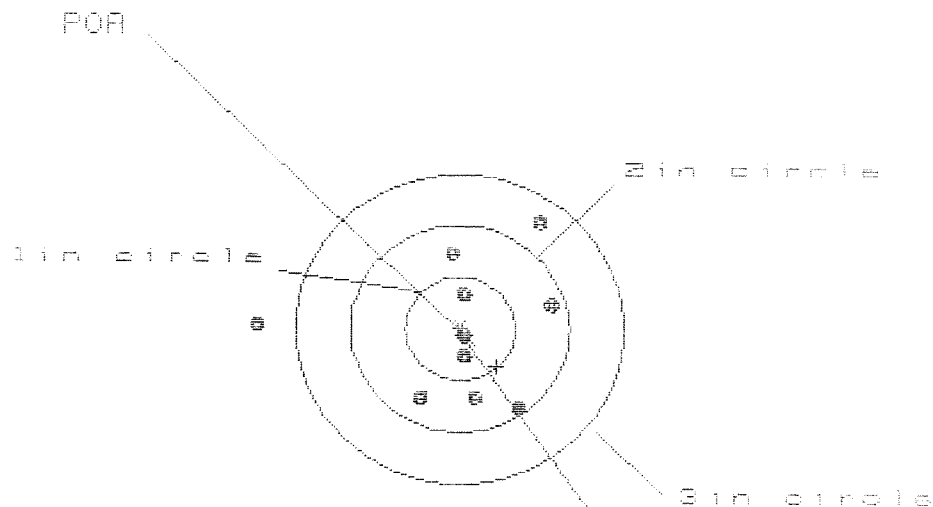
GS= 2.797

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.519	.959	.879
MINIMUM X	-1.007	-.838	-.918
MAXIMUM Y	.949	.881	.726
MINIMUM Y	-1.101	-1.169	-1.059
CENTROID X	-.020	-.189	-.109
CENTROID Y	.115	.183	.073
FOR TO CENTROID in.	.117	.263	.131
MIN RADIUS	.363	.187	.291
MEAN RADIUS	.929	.829	.795
MAX RADIUS	1.637	1.169	1.068
HORIZONTAL SPREAD	2.526	1.797	1.797
VERTICAL SPREAD	2.050	2.050	1.785
EXTREME SPREAD	2.797	2.141	1.917
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	9		

18 Aug 1994

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 3

2in = 5

3in = 5

HS= 2.737

VS= 1.780

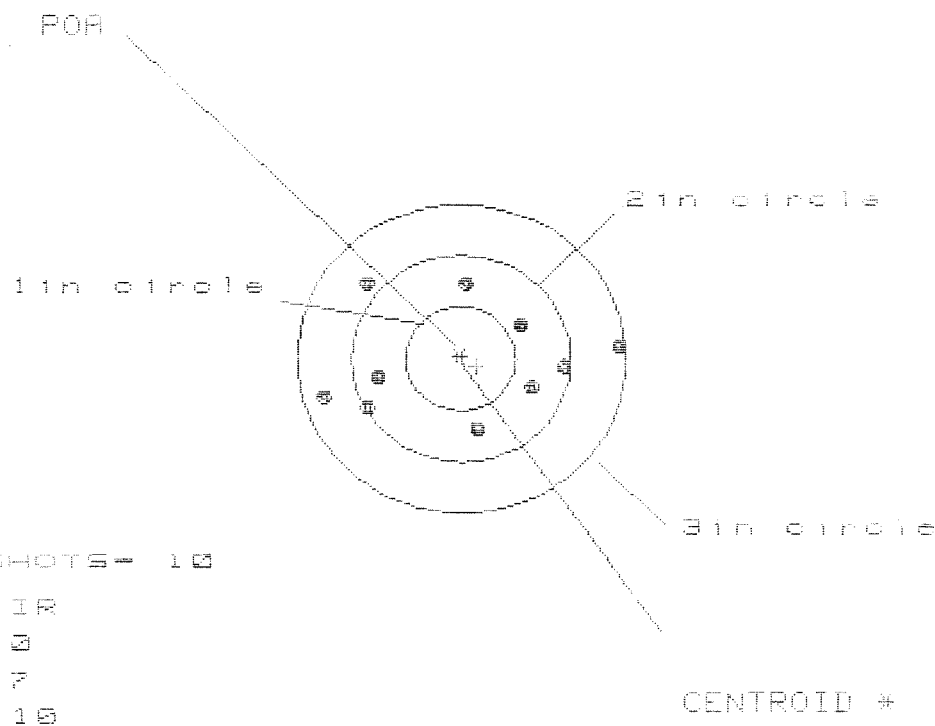
CS= 2.809

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.836	.619	.683
MINIMUM X	-1.907	-.557	-.493
MAXIMUM Y	1.040	1.048	.925
MINIMUM Y	-.740	-.732	-.601
CENTROID X	-.335	-.124	-.189
CENTROID Y	.359	.351	.220
POA TO CENTROID in.	.492	.372	.290
MIN RADIUS	.027	.189	.176
MEAN RADIUS	.782	.657	.568
MAX RADIUS	1.908	1.170	.941
HORIZONTAL SPREAD	2.737	1.176	1.176
VERTICAL SPREAD	1.780	1.780	1.526
EXTREME SPREAD	2.809	2.018	1.622
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		8	
NUMBER IN THREE INCH CIRCLE =		9	

18 Aug 1994

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CENTERFIRE PATTERNS # 3



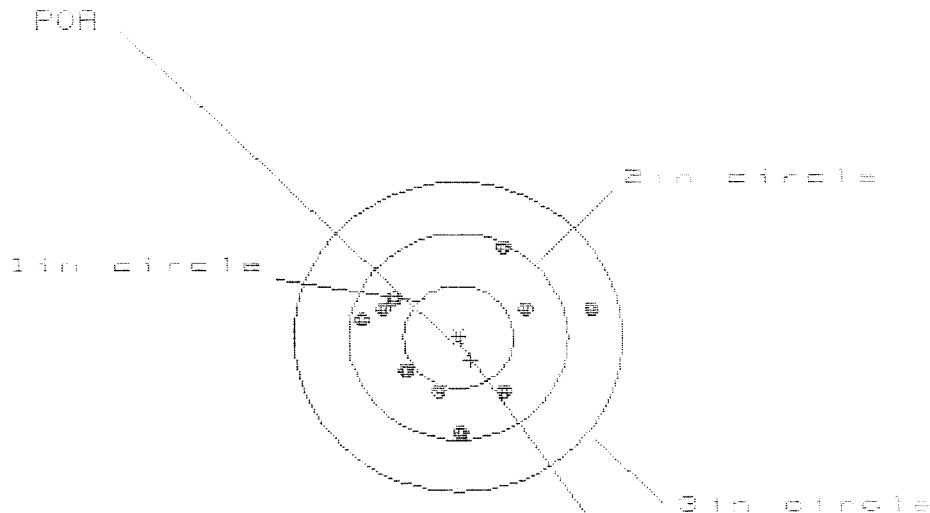
HSI = 2.733
 VS = 1.440
 GS = 2.787

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.461	1.086	.948
MINIMUM X	-1.272	-1.110	-.814
MAXIMUM Y	.756	.771	.722
MINIMUM Y	-.684	-.669	-.718
CENTROID X	-.145	-.307	-.169
CENTROID Y	.072	.057	.106
FOR TO CENTROID in.	.162	.312	.199
MIN RADIUS	.655	.609	.659
MEAN RADIUS	.932	.866	.815
MAX RADIUS	1.467	1.178	1.088
HORIZONTAL SPREAD	2.733	2.196	1.761
VERTICAL SPREAD	1.440	1.440	1.440
EXTREME SPREAD	2.787	2.225	1.936
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	10		

16 Aug 1984

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CENTERFIRE PATTERNS # 4



OF SHOTS = 10

IN CIR

1in = 0

2in = 9

3in = 10

HS = 2.117

VS = 1.710

GS = 2.120

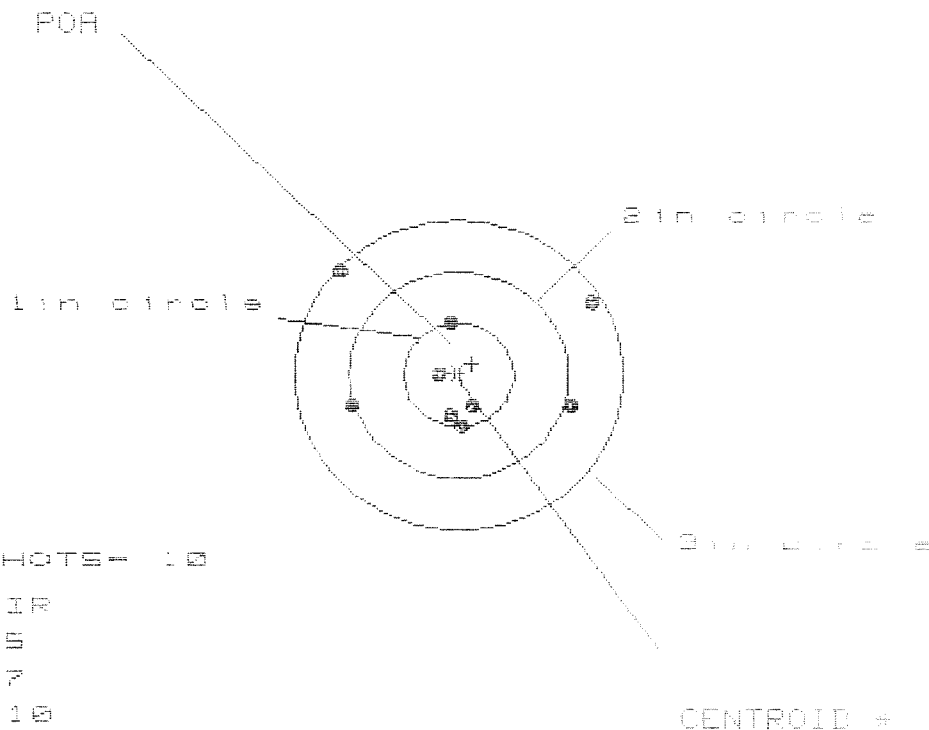
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.233	.795	.869
MINIMUM X	-.884	-.747	-.673
MAXIMUM Y	.831	.861	.540
MINIMUM Y	-.879	-.849	-.741
CENTROID X	-.115	-.252	-.326
CENTROID Y	.224	.194	.086
POA TO CENTROID in.	.251	.318	.337
MIN RADIUS	.542	.457	.335
MEAN RADIUS	.801	.727	.662
MAX RADIUS	1.261	1.045	.977
HORIZONTAL SPREAD	2.117	1.542	1.542
VERTICAL SPREAD	1.710	1.710	1.281
EXTREME SPREAD	2.120	1.760	1.540
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	9		
NUMBER IN THREE INCH CIRCLE =	10		

18 Aug 1984

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CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1 in = 5

2 in = 7

3 in = 10

HS= 2.326

VS= 1.511

GS= 2.502

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	1.226
MINIMUM X	-1.101
MAXIMUM Y	.981
MINIMUM Y	-.530
CENTROID X	-.121
CENTROID Y	-.106
POA TO CENTROID in.	.161
MIN RADIUS	.199
MEAN RADIUS	.734
MAX RADIUS	1.474
HORIZONTAL SPREAD	2.326
VERTICAL SPREAD	1.511
EXTREME SPREAD	2.502
NUMBER IN ONE INCH CIRCLE	5
NUMBER IN TWO INCH CIRCLE	7
NUMBER IN THREE INCH CIRCLE	10