

G 6590230
Repiece
C-6611496

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: RE00131867

Serial: C6611496 Model M24 SWS Center Fire
Caliber: 7.62 NATO Produced: 06/19/1991

Repairman:

Verify Repair

Status:

Closed 7/30/2007 9:46:53 AM

Address Information

Customer: ☒ Received From
 Name: 0002 AR RGT 03 B CO INF BN BCT (WDA6B0)
 Address 1: ROSE BARRACKS
 Address 2: SOUTH CAMP BLDG 728 PO Box:
 City: MILSECK
 State: DE Zip Code: 92249 Country: US

Return To: ☒ Received From
 Name: 0002 AR RGT 03 B CO INF BN BCT (WDA6B0)
 Address 1: ROSE BARRACKS
 Address 2: SOUTH CAMP BLDG 728 PO Box:
 City: MILSECK
 State: DE Zip Code: 92249 Country: US

FFL:

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
A026	Scope	1
A055	Deployment Kit	1
A057	Fit and Rear Sgt Base	1

Repair Search

Refresh

Close

naglelj

7/31/2007

9:06 AM

CAPS

NUM

INS

SCRL

start

2 M.

6 I.

3 M.

Par...

SA...

Ar...

Re...

9:06 AM

Serial
Number:

C6611496

Model: M24 SWS



RE00131867

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6590230.___0
FILE DATE AND TIME: 08/21/2007 00:55

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.126
The Average Y Centroid of the Five Target Set:	-0.004
The Average Point of Impact of the Five Target Set:	0.126
The Average Mean Radius of the Five Target Set:	0.620
The Distance from POA to Centroid Target #1:	0.140
The Distance from Centroid Target #2 to Centroid Target #1:	0.346
The Distance from Centroid Target #3 to Centroid Target #1:	0.258
The Distance from Centroid Target #4 to Centroid Target #1:	0.165
The Distance from Centroid Target #5 to Centroid Target #1:	0.432

BARBER - M24 0167115

SERIAL NUMBER: G6590230. __0

TARGET NUMBER: 1

FILE DATE: 08/21/2007

FILE TIME: 00:55

X CENTROID: -0.071

Y CENTROID: -0.121

POA TO CENTROID: 0.140

HORZ SPREAD: 2.497

VERT SPREAD: 1.984

GROUP SPREAD: 2.851

MIN RADIUS: 0.270

MAX RADIUS: 1.849

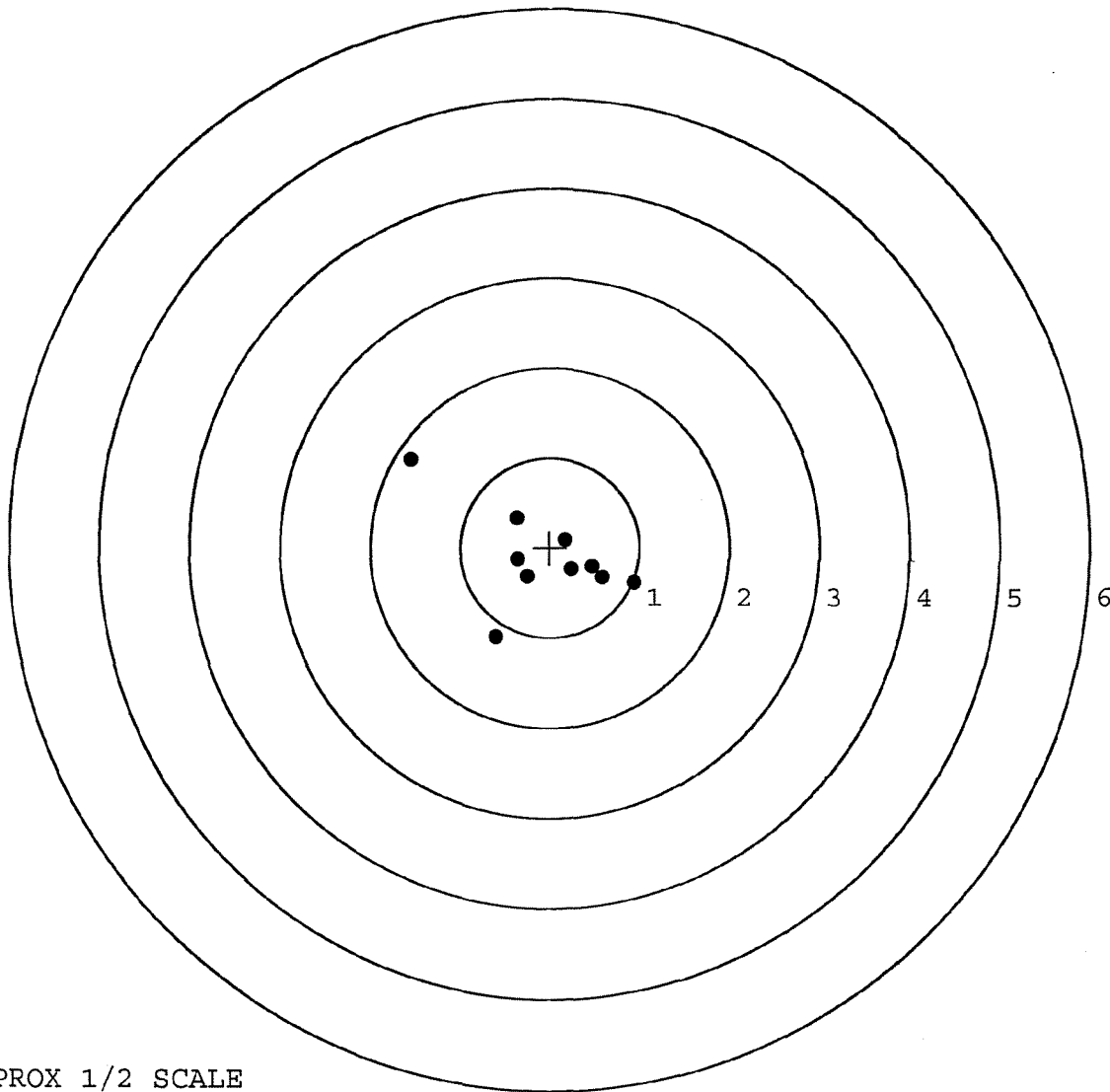
MEAN RADIUS: 0.694

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 9

POINT#	X	Y
1:	-0.370	0.340
2:	-0.359	-0.131
3:	-0.253	-0.320
4:	-0.603	-0.998
5:	0.172	0.093
6:	0.244	-0.241
7:	0.588	-0.333
8:	0.945	-0.390
9:	0.479	-0.213
10:	-1.552	0.986



TARGET APPROX 1/2 SCALE

BARBER - M24 0167116

SERIAL NUMBER: G6590230. __0

TARGET NUMBER: 2

FILE DATE: 08/21/2007

FILE TIME: 00:55

POINT#	X	Y
1:	0.611	0.859
2:	1.290	-0.381
3:	0.382	-1.242
4:	0.010	-0.633
5:	-0.431	0.127
6:	-0.166	0.128
7:	0.082	0.142
8:	0.011	0.572
9:	0.299	0.032
10:	0.578	-0.049

X CENTROID: 0.267

Y CENTROID: -0.045

POA TO CENTROID: 0.270

HORZ SPREAD: 1.721

VERT SPREAD: 2.101

GROUP SPREAD: 2.113

MIN RADIUS: 0.083

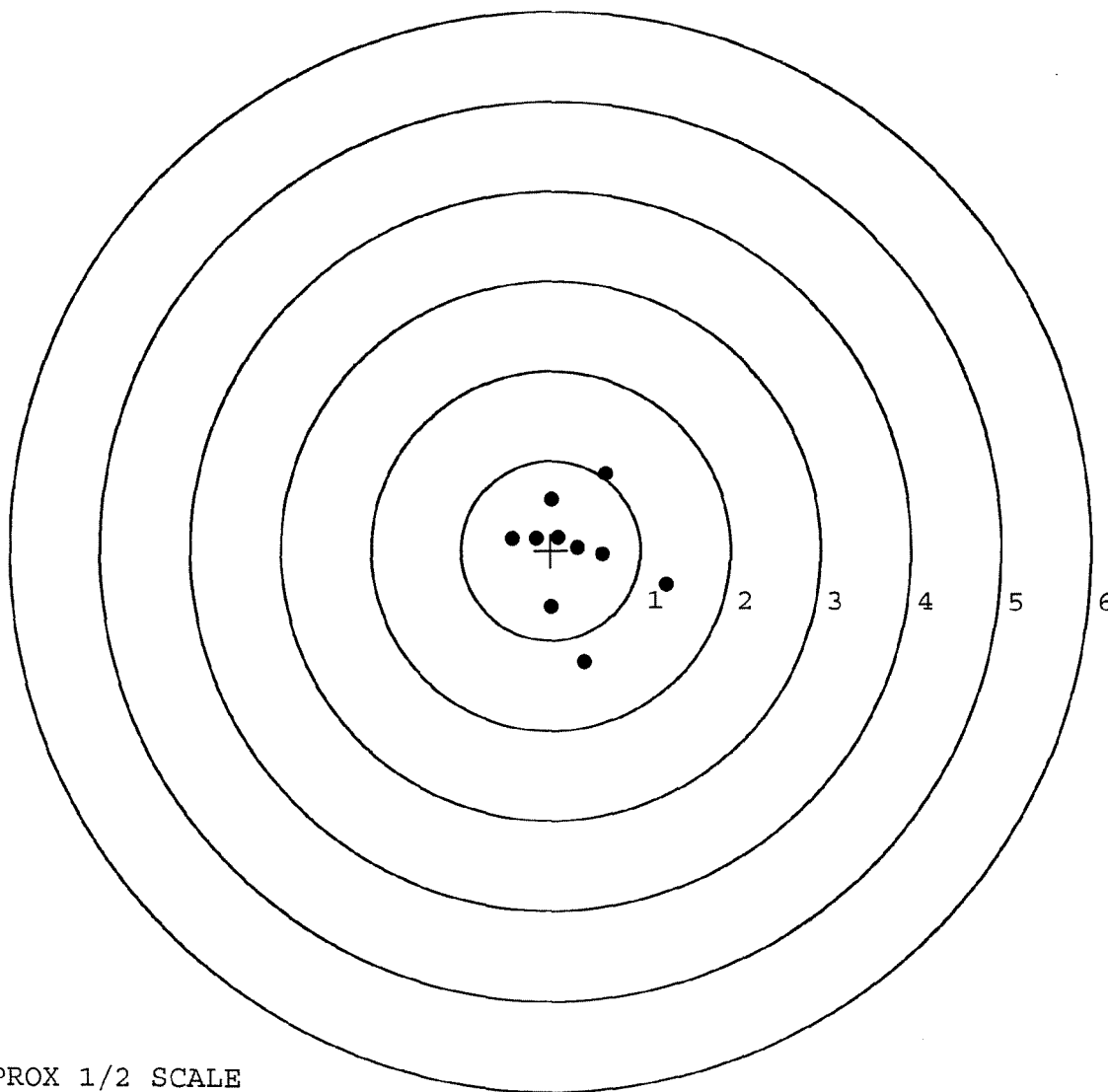
MAX RADIUS: 1.203

MEAN RADIUS: 0.640

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10



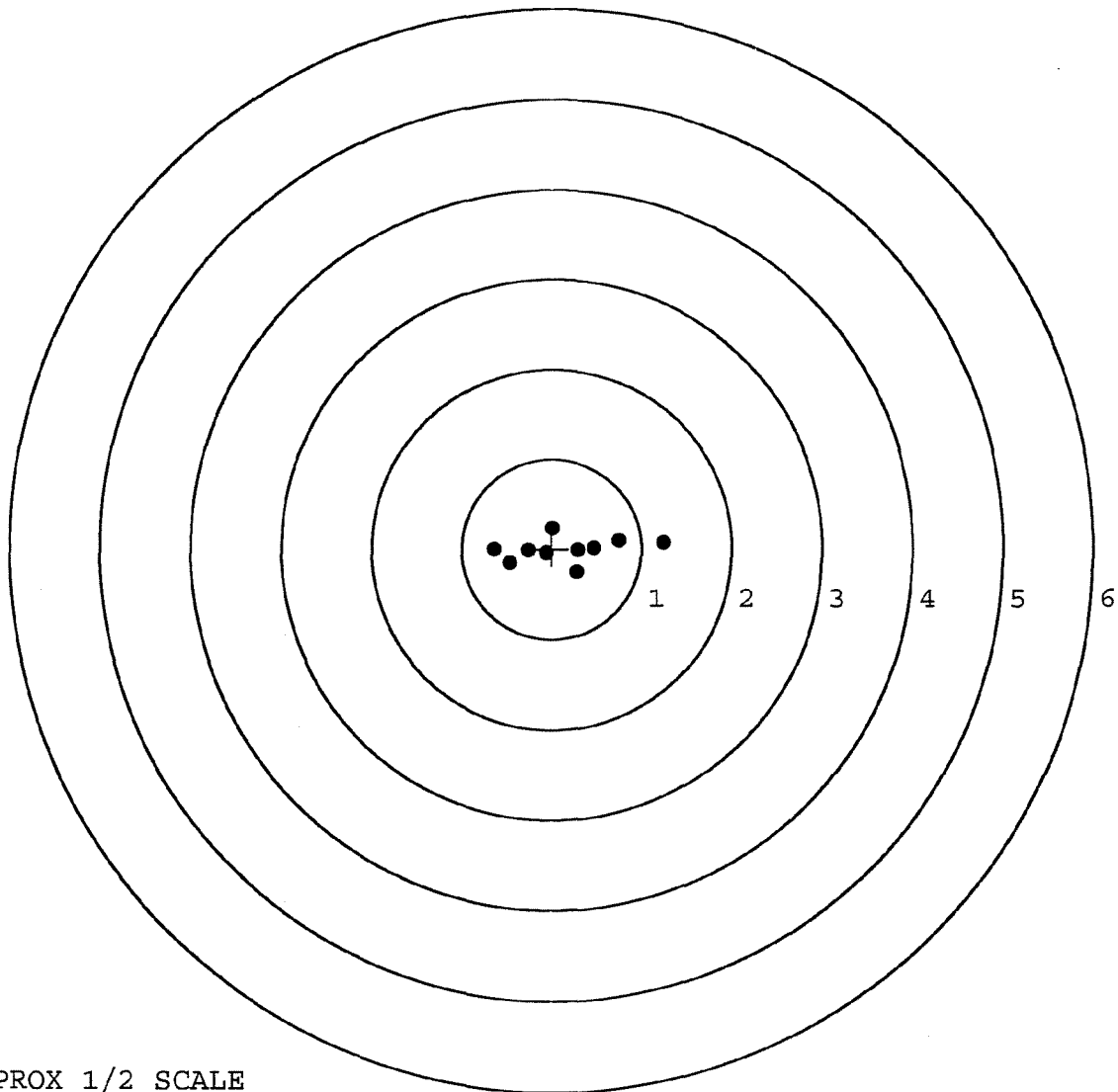
TARGET APPROX 1/2 SCALE

BARBER - M24 0167117

SERIAL NUMBER: G6590230. __ 0
 TARGET NUMBER: 3
 FILE DATE: 08/21/2007
 FILE TIME: 00:55

POINT#	X	Y
1:	1.245	0.068
2:	0.752	0.097
3:	0.468	0.017
4:	0.012	0.232
5:	0.289	-0.010
6:	0.281	-0.257
7:	-0.066	-0.052
8:	-0.266	-0.019
9:	-0.465	-0.159
10:	-0.641	0.001

X CENTROID: 0.161
 Y CENTROID: -0.008
 POA TO CENTROID: 0.161
 HORZ SPREAD: 1.886
 VERT SPREAD: 0.489
 GROUP SPREAD: 1.887
 MIN RADIUS: 0.128
 MAX RADIUS: 1.087
 MEAN RADIUS: 0.479
 # IN 1 IN DIAMETER: 6
 # IN 2 IN DIAMETER: 9
 # in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

BARBER - M24 0167118

SERIAL NUMBER: G6590230. __0

TARGET NUMBER: 4

FILE DATE: 08/21/2007

FILE TIME: 00:55

POINT#	X	Y
1:	-0.307	0.552
2:	0.023	0.767
3:	0.213	0.271
4:	0.748	0.071
5:	0.617	-0.112
6:	0.145	-0.369
7:	0.202	-0.743
8:	-0.243	-0.369
9:	-0.597	-0.065
10:	0.058	-0.702

X CENTROID: 0.086

Y CENTROID: -0.070

POA TO CENTROID: 0.111

HORZ SPREAD: 1.345

VERT SPREAD: 1.510

GROUP SPREAD: 1.521

MIN RADIUS: 0.305

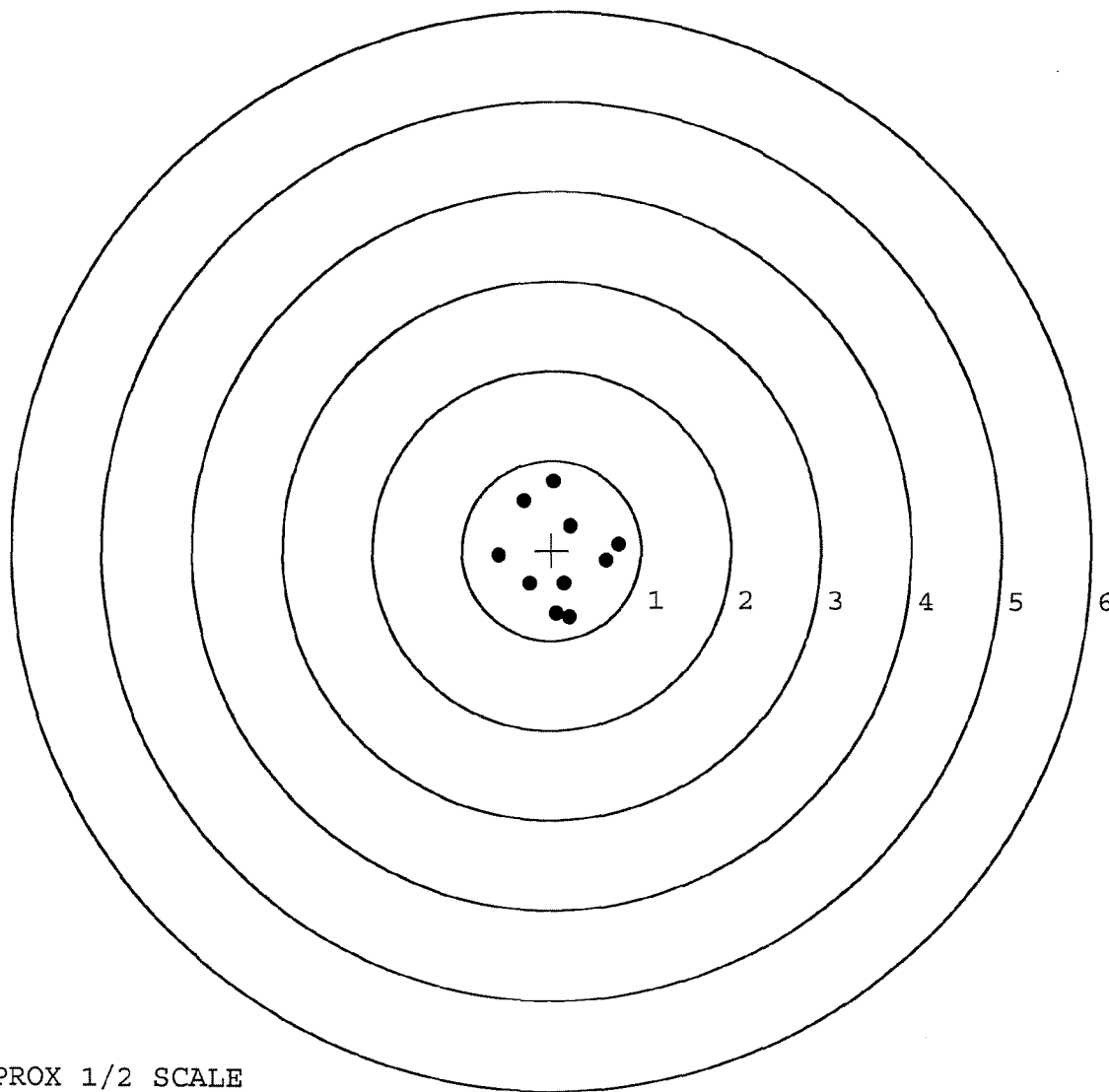
MAX RADIUS: 0.839

MEAN RADIUS: 0.590

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10



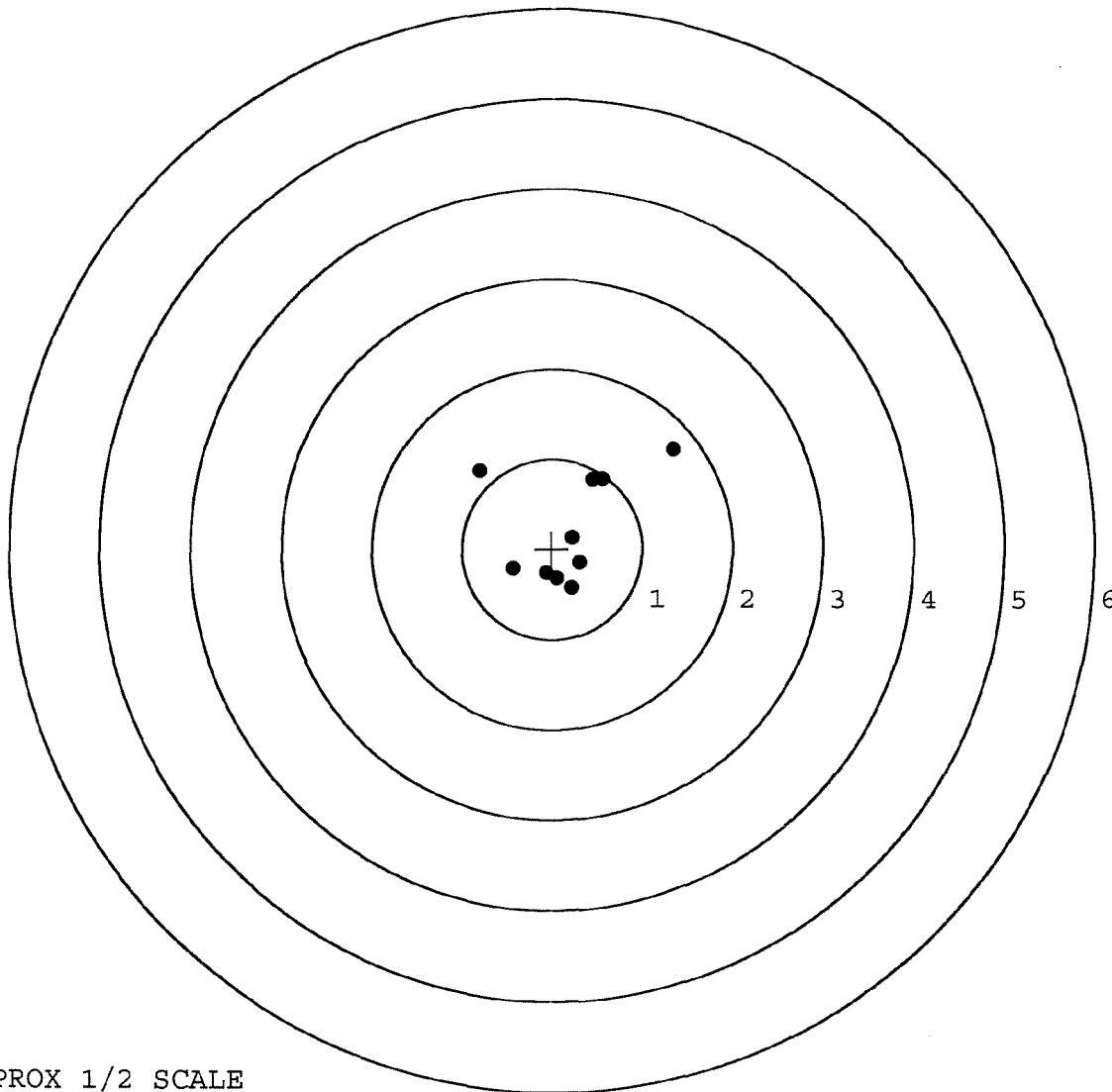
TARGET APPROX 1/2 SCALE

BARBER - M24 0167119

SERIAL NUMBER: G6590230. 0
 TARGET NUMBER: 5
 FILE DATE: 08/21/2007
 FILE TIME: 00:55

POINT#	X	Y
1:	-0.806	0.872
2:	0.451	0.776
3:	0.564	0.784
4:	1.341	1.106
5:	0.224	-0.436
6:	0.311	-0.153
7:	0.221	0.126
8:	0.054	-0.332
9:	-0.061	-0.268
10:	-0.433	-0.218

X CENTROID: 0.187
 Y CENTROID: 0.226
 POA TO CENTROID: 0.293
 HORZ SPREAD: 2.147
 VERT SPREAD: 1.542
 GROUP SPREAD: 2.214
 MIN RADIUS: 0.105
 MAX RADIUS: 1.452
 MEAN RADIUS: 0.698
 # IN 1 IN DIAMETER: 2
 # IN 2 IN DIAMETER: 8
 # in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

R & E NUMBER

131 867

SERIAL NUMBER

C6611496

G6590230 (New)

LOG-IN DATE

7-30-07

OPERATION #	OPERATION NAME	DATE	INITIAL
500	DIS-ASSEMBLE GUN	8-8-07	RTZ
505	RE-BARREL	8-9-07	RTZ
560	ASSEMBLE	8-9-07	RTZ
600	PROOF	8-9-07	mm
605	CHECK HEADSPACE	8-9-07	mm
610	DIS-ASSEMBLE GUN	8-9-07	SD
612	MAGNAFLUX	8-14-07	URS
510	DRILL AND TAP	8-10-07	TRW
615	ROLLMARK CALIBER	8-10-07	CW
618	ROTO-BLAST	8-14-07	LY
620	APPLY COATINGS	8-15-07	TRB
625	FINAL ASSEMBLY	8-20-07	RTZ
640	FUNCTION TEST AND	8-20-07	mm
650	TARGET	8-20-07	mm
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
670	FINAL INSPECTION	8-20-07	SD
	A) HEADSPACE	PASS FAIL	
	B) TRIGGER PULL	2.36 2.64 2.68 2.73 2.52	8-21-07 TRW
680	F) SAFETY ON FORCE	4.0 4.25 4.25	8-21-07 TRW
	G) SAFETY OFF FORCE	2.0 2.25 2.5	8-21-07 TRW
	I) FIRING PIN INDENT	.0225 .0225 .0225	8-21-07 TRW
690	PACK	8-23-07	RTZ

Repair Number: RE00076767	Serial: C6611496 Model: 700 Center Fire Caliber: 7 62 NATO M/24 SWS	Repairman:	Status: Closed 2/4/2004 5:37:13 AM																											
Address Information Customer: ☒ Received From ☐ Return To ☐ Received From Name: DOL DOL Address 1: WEAPONS CAGE WEAPONS CAGE 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:																														
<table border="1"> <tr> <td>Contact / Condition</td> <td>Problems</td> <td>Estimate</td> <td>History / Status</td> <td>Shipping / Billing</td> </tr> </table>				Contact / Condition	Problems	Estimate	History / Status	Shipping / Billing																						
Contact / Condition	Problems	Estimate	History / Status	Shipping / Billing																										
Contact Information Phone: Fax: Email: Comments:		Received Condition Fair Condition Notes: CSR Notes:																												
		Accessories Received <table border="1"> <thead> <tr> <th>Code</th> <th>Desc</th> <th>Qty</th> </tr> </thead> <tbody> <tr> <td>A006</td> <td>Sling Strap</td> <td>1</td> </tr> <tr> <td>A007</td> <td>With Stud</td> <td>2</td> </tr> <tr> <td>A008</td> <td>With Swivel</td> <td>2</td> </tr> <tr> <td>A010</td> <td>Hard Case</td> <td>1</td> </tr> <tr> <td>A016</td> <td>Scope Rings</td> <td>2</td> </tr> <tr> <td>A017</td> <td>Scope Base</td> <td>1</td> </tr> <tr> <td>A026</td> <td>Scope</td> <td>1</td> </tr> <tr> <td>C000</td> <td>Fit and Rear Sights</td> <td>1</td> </tr> </tbody> </table>		Code	Desc	Qty	A006	Sling Strap	1	A007	With Stud	2	A008	With Swivel	2	A010	Hard Case	1	A016	Scope Rings	2	A017	Scope Base	1	A026	Scope	1	C000	Fit and Rear Sights	1
Code	Desc	Qty																												
A006	Sling Strap	1																												
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A010	Hard Case	1																												
A016	Scope Rings	2																												
A017	Scope Base	1																												
A026	Scope	1																												
C000	Fit and Rear Sights	1																												
Repair Search		Refresh Close																												

neglej 2/4/2004 7:12 AM C66 NUM INS

start 3 2

Serial Number: **C6611496**Model: **700****RE00076767**

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6611496. __0

FILE DATE AND TIME: 02/17/2004 07:19

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:	-0.098
The Average Point of Impact of the Five Target Set:	0.101
The Average Mean Radius of the Five Target Set:	1.033
The Distance from POA to Centroid Target #1:	0.331
The Distance from Centroid Target #2 to Centroid Target #1:	0.246
The Distance from Centroid Target #3 to Centroid Target #1:	0.440
The Distance from Centroid Target #4 to Centroid Target #1:	0.332
The Distance from Centroid Target #5 to Centroid Target #1:	0.527

SERIAL NUMBER: C6611496. __0

TARGET NUMBER: 1

FILE DATE: 02/17/2004

FILE TIME: 07:19

POINT#	X	Y
1:	-0.012	-1.690
2:	-0.543	-1.517
3:	-0.455	-1.808
4:	-0.533	-0.662
5:	0.287	-0.468
6:	0.081	0.020
7:	-0.325	0.343
8:	-0.766	0.370
9:	0.288	1.194
10:	-0.272	1.795

X CENTROID: -0.225

Y CENTROID: -0.242

POA TO CENTROID: 0.331

HORZ SPREAD: 1.054

VERT SPREAD: 3.603

GROUP SPREAD: 3.608

MIN RADIUS: 0.403

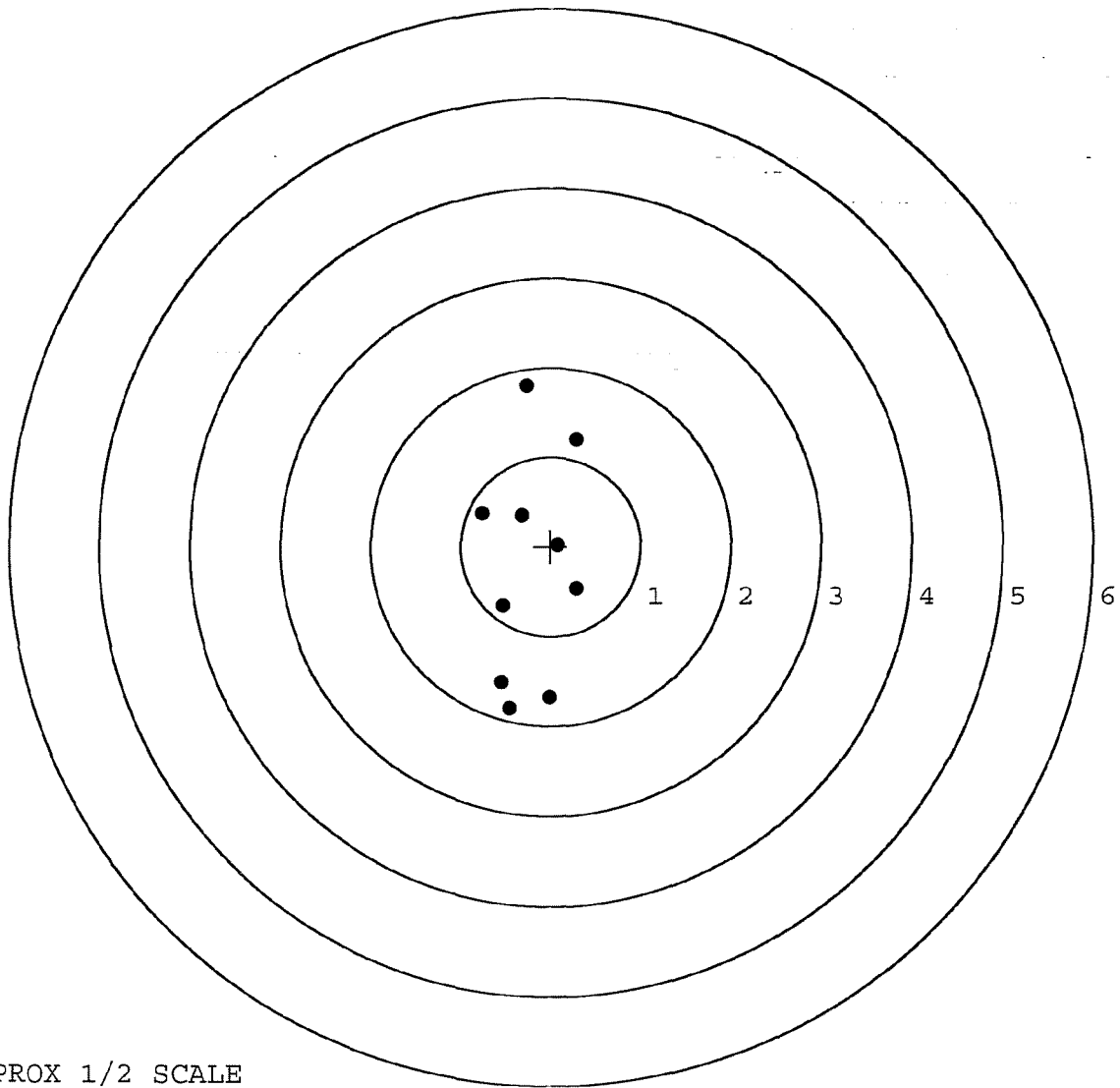
MAX RADIUS: 2.038

MEAN RADIUS: 1.082

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 5

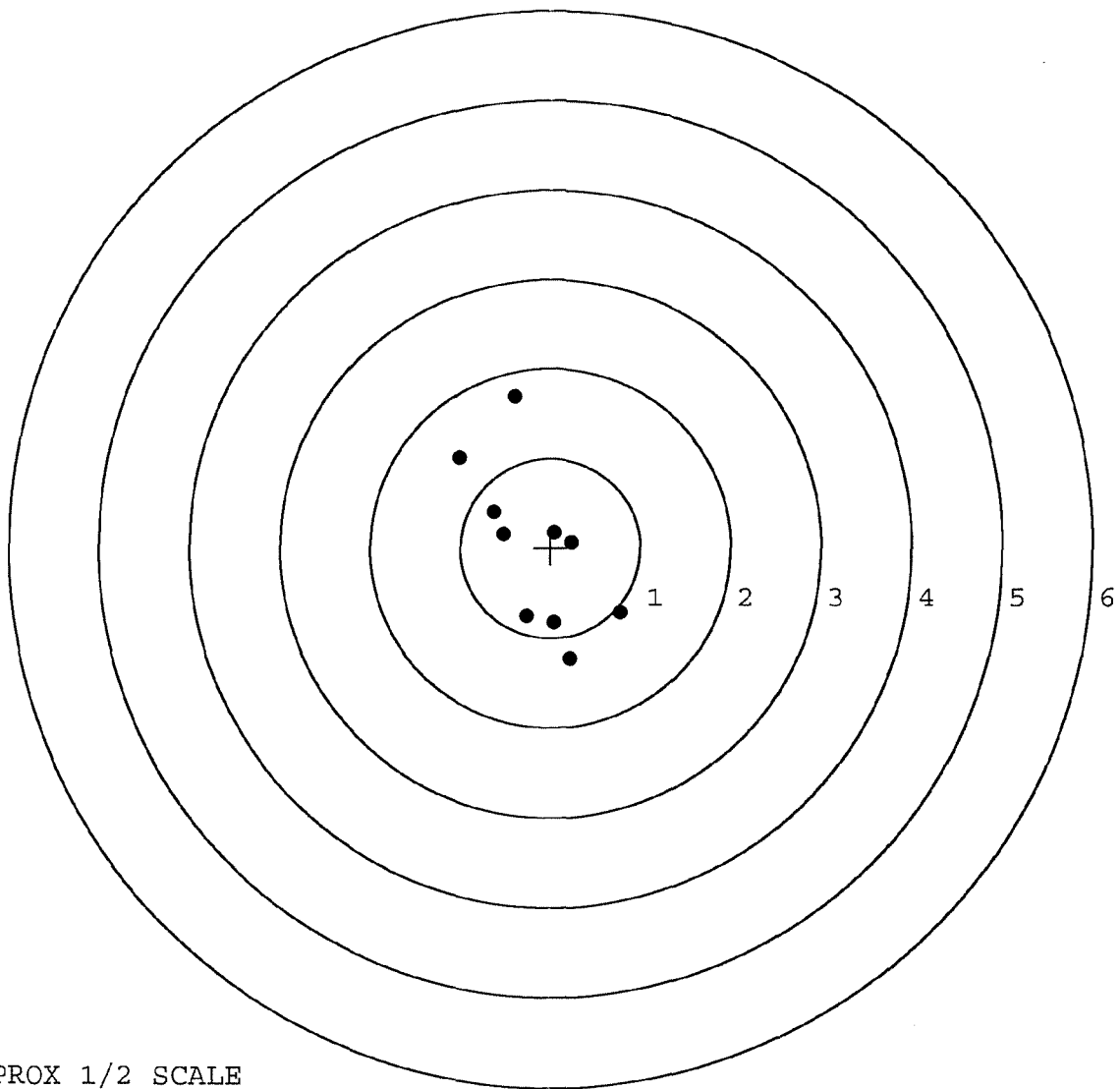
in 3 IN DIAMETER: 7



TARGET APPROX 1/2 SCALE

BARBER - M24 0167124

SERIAL NUMBER: C6611496. __0	POINT#	X	Y
TARGET NUMBER: 2	1:	0.781	-0.725
FILE DATE: 02/17/2004	2:	0.231	-1.238
FILE TIME: 07:19	3:	0.045	-0.837
	4:	-0.266	-0.766
X CENTROID: -0.149	5:	0.239	0.054
Y CENTROID: -0.008	6:	0.042	0.173
POA TO CENTROID: 0.149	7:	-0.524	0.160
HORZ SPREAD: 1.792	8:	-0.631	0.404
VERT SPREAD: 2.924	9:	-1.011	1.007
GROUP SPREAD: 2.990	10:	-0.394	1.686
MIN RADIUS: 0.263			
MAX RADIUS: 1.712			
MEAN RADIUS: 0.882			
# IN 1 IN DIAMETER: 3			
# IN 2 IN DIAMETER: 6			
# in 3 IN DIAMETER: 9			



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6611496. __0

TARGET NUMBER: 3

FILE DATE: 02/17/2004

FILE TIME: 07:19

POINT#	X	Y
1:	0.890	-1.854
2:	0.315	-1.056
3:	0.708	-0.983
4:	0.271	-0.303
5:	0.106	-0.469
6:	-0.095	-0.142
7:	0.633	0.775
8:	-0.463	0.753
9:	-0.359	1.095
10:	-0.334	1.749

X CENTROID: 0.167

Y CENTROID: -0.043

POA TO CENTROID: 0.173

HORZ SPREAD: 1.353

VERT SPREAD: 3.603

GROUP SPREAD: 3.805

MIN RADIUS: 0.279

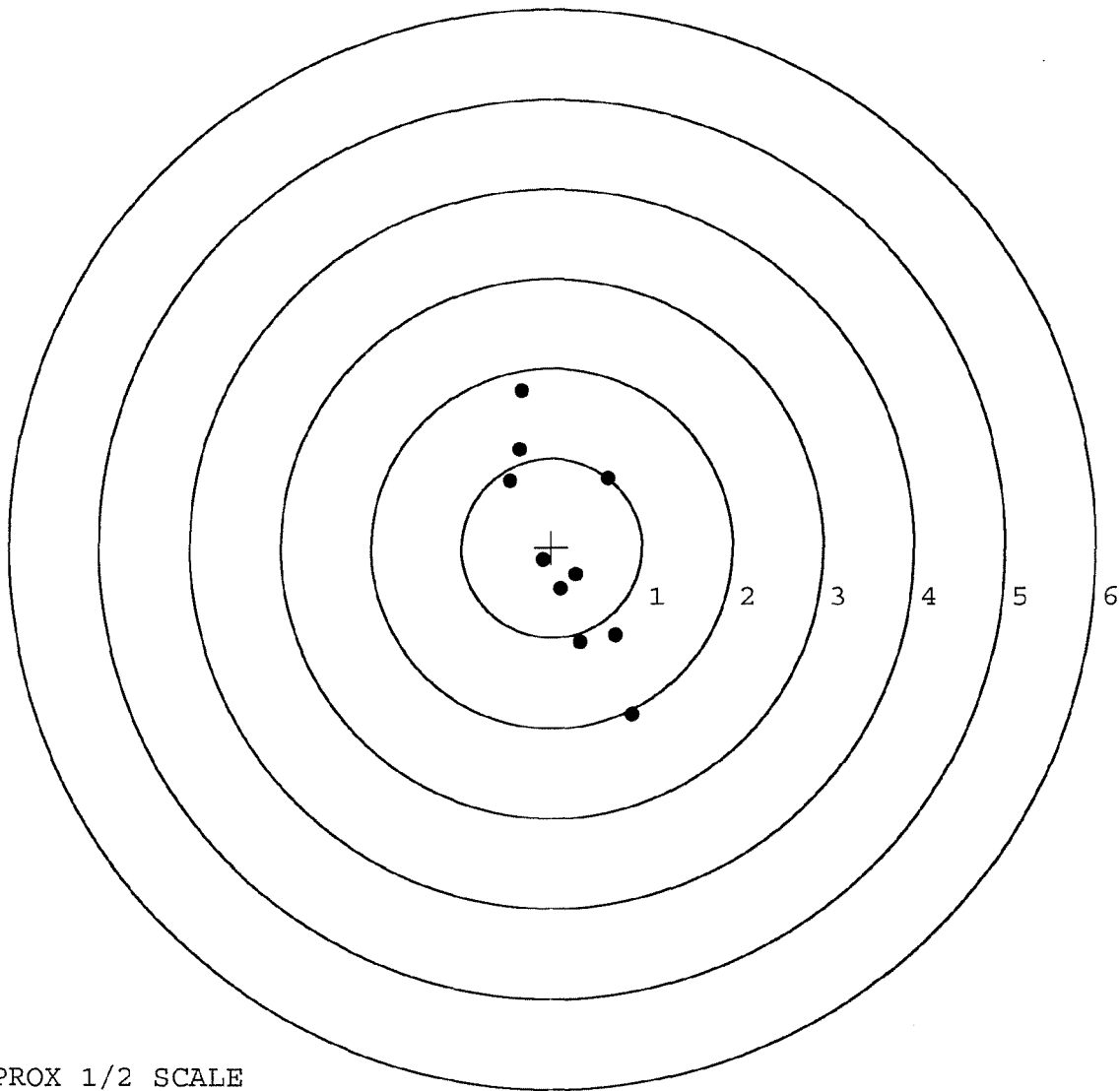
MAX RADIUS: 1.949

MEAN RADIUS: 1.012

IN 1 IN DIAMETER: 3

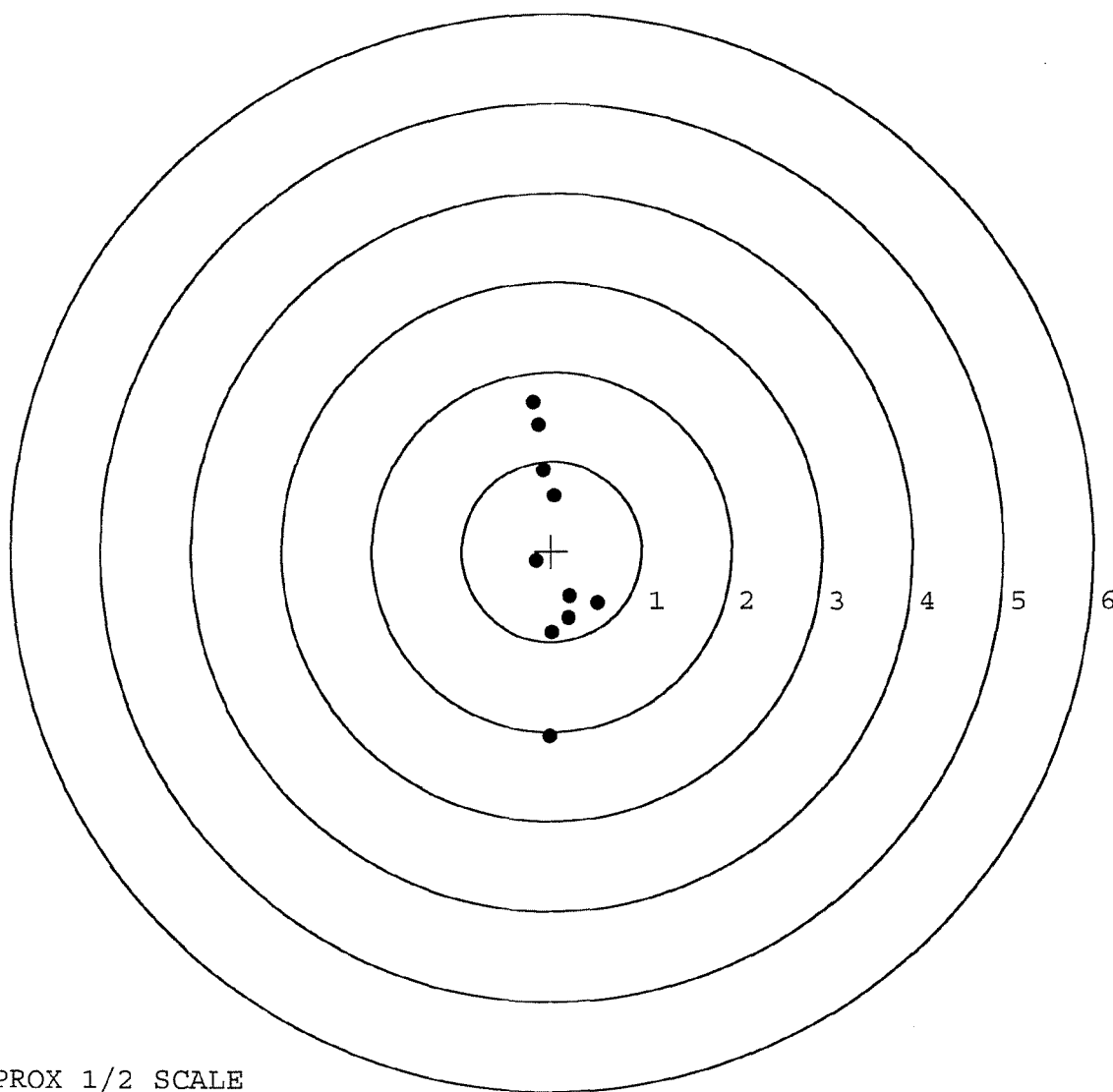
IN 2 IN DIAMETER: 4

in 3 IN DIAMETER: 8



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6611496. __0	POINT#	X	Y
TARGET NUMBER: 4	1:	-0.019	-2.054
FILE DATE: 02/17/2004	2:	-0.211	1.665
FILE TIME: 07:19	3:	-0.150	1.411
	4:	-0.094	0.903
X CENTROID: 0.030	5:	0.027	0.619
Y CENTROID: -0.030	6:	-0.173	-0.113
POA TO CENTROID: 0.042	7:	0.516	-0.578
HORZ SPREAD: 0.727	8:	0.202	-0.505
VERT SPREAD: 3.719	9:	0.188	-0.741
GROUP SPREAD: 3.724	10:	0.013	-0.906
MIN RADIUS: 0.219			
MAX RADIUS: 2.025			
MEAN RADIUS: 0.984			
# IN 1 IN DIAMETER: 1			
# IN 2 IN DIAMETER: 7			
# in 3 IN DIAMETER: 8			

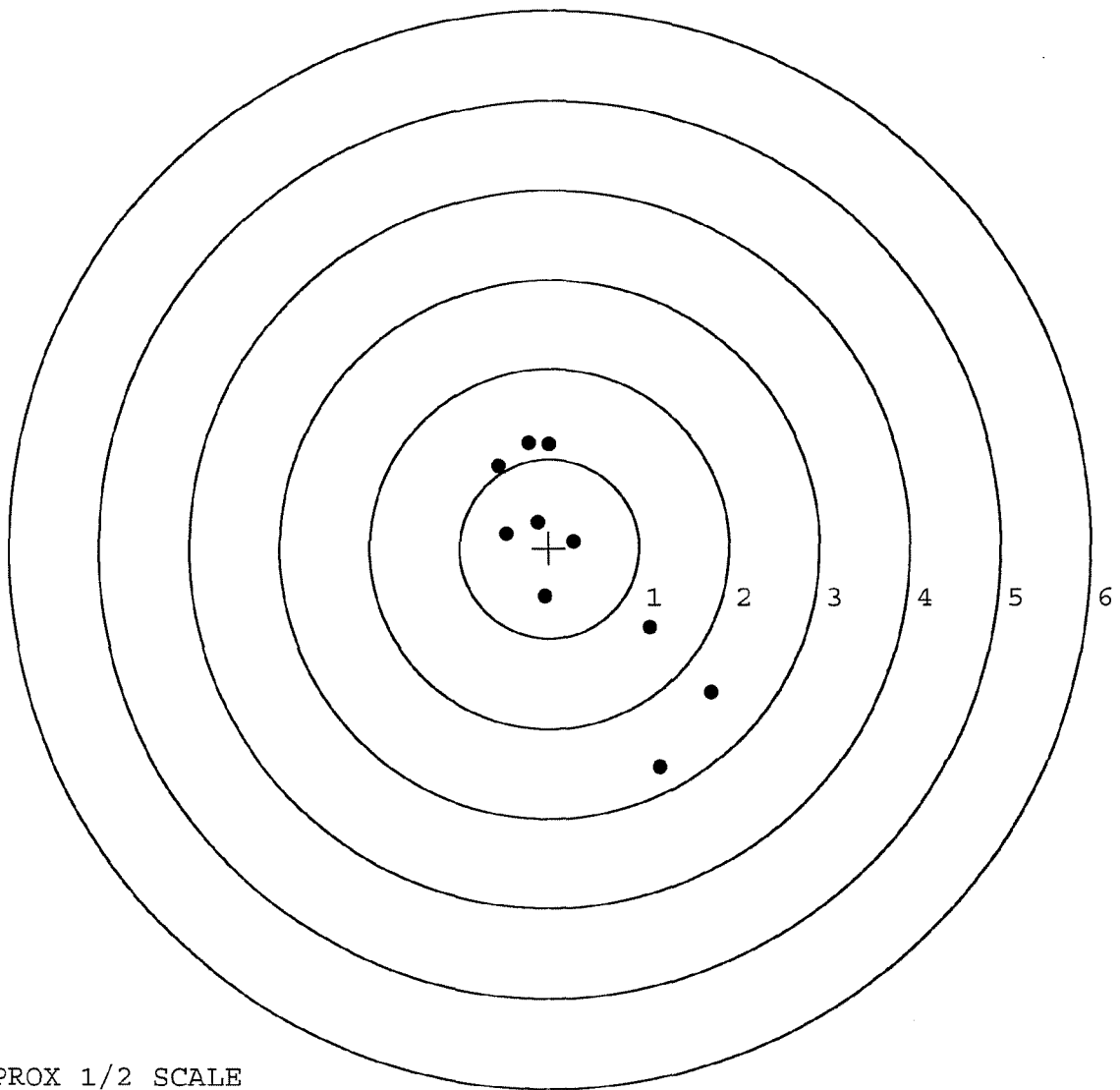


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6611496. __0
 TARGET NUMBER: 5
 FILE DATE: 02/17/2004
 FILE TIME: 07:19

POINT#	X	Y
1:	1.805	-1.603
2:	1.240	-2.436
3:	1.116	-0.893
4:	0.269	0.074
5:	-0.050	-0.546
6:	-0.482	0.165
7:	-0.133	0.290
8:	-0.572	0.925
9:	-0.229	1.175
10:	0.002	1.166

X CENTROID: 0.297
 Y CENTROID: -0.168
 POA TO CENTROID: 0.341
 HORZ SPREAD: 2.377
 VERT SPREAD: 3.611
 GROUP SPREAD: 3.898
 MIN RADIUS: 0.244
 MAX RADIUS: 2.456
 MEAN RADIUS: 1.207
 # IN 1 IN DIAMETER: 1
 # IN 2 IN DIAMETER: 4
 # in 3 IN DIAMETER: 8



TARGET APPROX 1/2 SCALE

BARBER - M24 **M2400167167**

BARBER - M24 0167129

RECEIVING AND TESTING REPORT

COMMENTS

ORDER

R 94-18715

INITIAL CUSTOMER ORDER NO.

JJM

DAAA09-92-C-0834

W/10X SCOPE M-24 SNIPER W/DEPLOYMENT KIT

ATTN FRED MARTIN

DATE RECEIVED

DATE OPENED

DATE CODE

SERIAL NUMBER

NEW SERIAL NUMBER

MODEL AND GRADE

06/14/94

06/15/94

C6611496

700 7.62

NATO

ACCESSORIES

HARD CASE

SCOPE MNTS

SCOPE BASE

SLING STRAP

96-0499

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

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

Trigger Assy \$173.71

Scope Rep 119.43

Clean/Insp/Rep 50.00

343.14

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 0167129

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

SERIAL NO. C6611496DATE 10-27-95TESTER DA

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#	COMMENTS
PULL #1	2.41	2.57	2.41	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.30	2.46	2.57	
PULL #3	2.30	2.44	2.64	
PULL #4	2.37	2.49	2.20	
PULL #5	2.30	2.39	2.65	
TOTAL	11.68	12.35	12.97	
AVG.	2.33	2.47	2.59	

	3.00# INITIAL	3.00# AFTER 20 CYCLES	COMMENTS
PULL #1	3.07	3.04	
PULL #2	3.00	2.92	
PULL #3	3.01	3.15	
PULL #4	3.00	2.93	
PULL #5	3.00	2.98	
TOTAL	15.08	15.02	
AVG.	3.01	3.00	

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.09	4.05	4.07	
PULL #2	4.00	4.11	4.15	
PULL #3	4.00	4.12	4.14	
PULL #4	4.04	4.06	4.02	
PULL #5	4.00	4.11	4.09	
TOTAL	20.13	20.45	20.47	
AVG.	4.02	4.09	4.09	

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6611496

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			

BARBER - M24 0167132

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6 1/2	6 1/2	6 1/2			11/28	WB
	G) Safety Off Force	4	3 1/2	3 3/4			11/28	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	2.74	2.62	2.60	2.51	2.53	11/28	WB
	C) Function							
660	Pack							

Remington.		 REG. U.S. PAT. & TM. OFF.	VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.
MODEL 700™ M24		SERIAL NO. C6611496	UPC  0 47700 25716 7
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat & Tm. Off, Marca Registrada Marque Deposee.		ORDER NO. 5716	



5716 C6611496

repaired 8 weeks

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C 6611496

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		2/1/91	KJ
600	Proof		2/1/91	KJ
607	Check Headspace		2/1/91	KJ
610	Dis-assemble Gun		2/1/91	KJ
612	Magnaflux Barrel Action	2 11	2/1/91	Kcd
	Magnaflux Bolt	2 11	2/1/91	Kcd
615	Rollmark Caliber	2 11	2/1/91	GS
617	Drill and Tap Sight Holes	2 13	91	LB
618	Polish Barrel RBB	2 13	2/1/91	WB
620	Apply Coatings (Barrel Action)		3/2/91	JA
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		3/20/91	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		3/20/91	KS
	C) Inspect Ejector Hole for Chamfer		3/20/91	KS
	D) Oil Firing Pin Ass'y		3/20/91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		3/21/91	KJ

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	7 1/2	6	6			3/22/91	WB
	G) Safety Off Force	2 1/2	2 1/2	2 1/2			3/22/91	WB
	H) Trigger Pull Test & Retainability						3/21/91	DL
	I) Firing Pin Indent	.0225	.023	.023			3/22/91	WB
	J) Assemble Stock						3/22/91	KS
	K) Assemble Swivel Studs						4-8-91	DH
	L) Attach Front and Rear Sight Assemblies						3/22/91	KS
	M) Iron Sight Alignment						3/22/91	KS
	N) Detach Front & Rear Sights & place in numbered container						3/22/91	KS
	O) Attach Scope to Rifle						3/22/91	KS
	P) Detach & Attach Scope 20 Times						3/22/91	KS
640	Gallery Target & Test						4-3-91	AC
	A) Time						4-3-91	AC
	B) Malfunctions						4-3-91	AC
	C) Pierced Primers						4-3-91	AC
	D) Optical Clarity of Scope						4-3-91	AC
645	Inspect for Live Ammo						4-3-91	AC
655	Final Inspection							
	A) Headspace						4-8-91	DH
	B) Trigger Pull	2.27	2.57	2.51	2.47	2.48	4/5/91	DL
	C) Function						4-8-91	DH
660	Pack						6-19-91	VF

PIMI

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

SERIAL NO. C6611498
DATE 3-21-91
TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.25	2.52	2.40	2.27	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.29	2.43	2.31	2.57	
PULL #3	2.32	2.31	2.29	2.51	
PULL #4	2.32	2.33	2.48	2.47	
PULL #5	2.25	2.44	2.33	2.48	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.35	3.27		
PULL #2	3.29	3.25		
PULL #3	3.28	3.28		
PULL #4	3.27	3.29		
PULL #5	3.27	3.31		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.21	4.40	4.	4.44
PULL #2	4.14	4.45		4.49
PULL #3	4.41	4.43		4.48
PULL #4	4.41	4.43		4.41
PULL #5	4.38	4.43		4.45
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611496
3 Apr 1991

CENTROIDAL DISTANCES

Ø TO	1	.151433
1 TO	2	.480276
1 TO	3	.116662
1 TO	4	.18186
1 TO	5	.248214

2 ~~4~~ <----POA

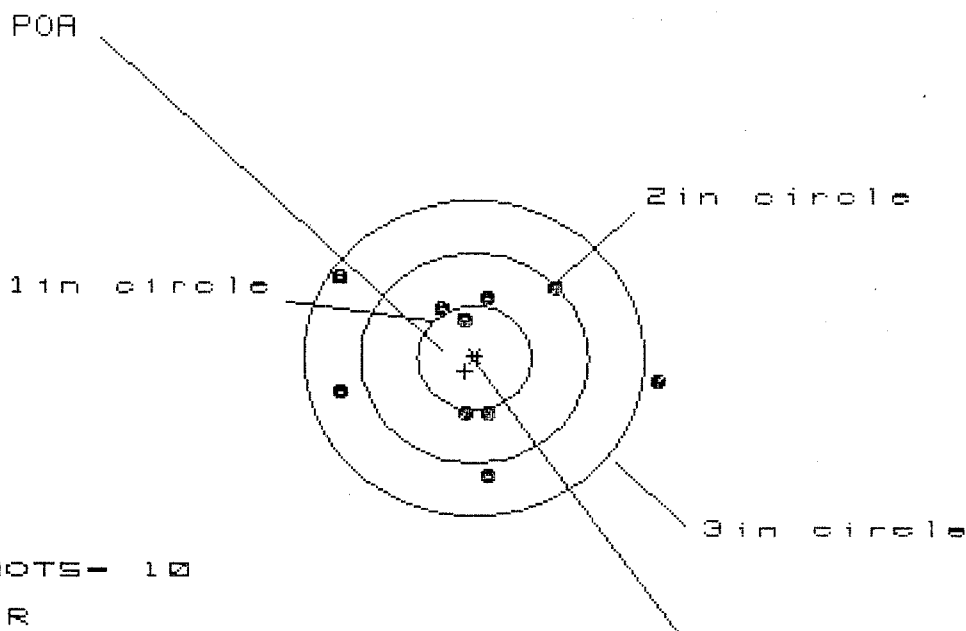
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0256
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0704
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0749101

THE AMP FOR THIS RIFLE IS: .815

3 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611496

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in - 1

2in - 6

3in - 9

HS- 2.822

VS- 1.903

GS- 2.981

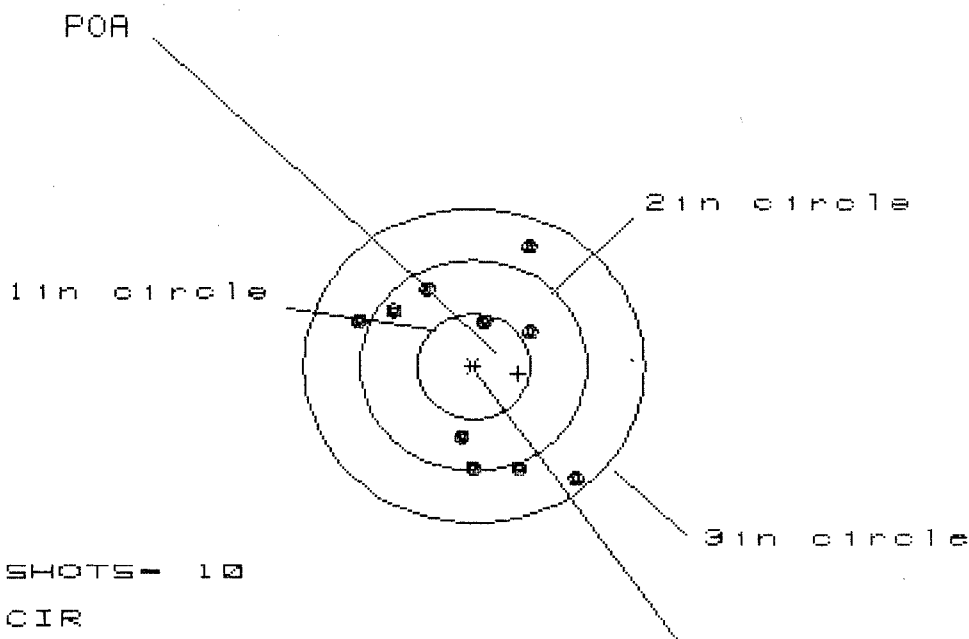
CENTROID #

PATTERN #	:	717	718	719
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.660	.925	.803
MINIMUM X	:	-1.162	-.977	-1.073
MAXIMUM Y	:	.735	.710	.698
MINIMUM Y	:	-1.168	-1.193	-1.105
CENTROID X	:	.084	-.101	.021
CENTROID Y	:	.126	.151	.063
POA TO CENTROID in.	:	.152	.182	.066
MIN RADIUS	:	.374	.356	.430
MEAN RADIUS	:	.894	.797	.738
MAX RADIUS	:	1.676	1.222	1.113
HORIZONTAL SPREAD	:	2.822	1.902	1.876
VERTICAL SPREAD	:	1.903	1.903	1.803
EXTREME SPREAD	:	2.981	2.270	2.088
NUMBER IN ONE INCH CIRCLE =	:	1		
NUMBER IN TWO INCH CIRCLE =	:	6		
NUMBER IN THREE INCH CIRCLE =	:	9		

3 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611496

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in - 1

2in - 6

3in = 10

HS= 1.931

VS= 2.141

GS= 2.438

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.942	.584	.653
MINIMUM X	:	-.989	-.884	-.815
MAXIMUM Y	:	1.107	.993	.782
MINIMUM Y	:	-1.034	-1.085	-.961
CENTROID X	:	-.393	-.498	-.567
CENTROID Y	:	.070	.184	.060
POA TO CENTROID in.	:	.400	.531	.570
MIN RADIUS	:	.427	.365	.506
MEAN RADIUS	:	.914	.844	.812
MAX RADIUS	:	1.399	1.172	1.092
HORIZONTAL SPREAD	:	1.931	1.468	1.468
VERTICAL SPREAD	:	2.141	2.078	1.743
EXTREME SPREAD	:	2.438	2.135	1.959
NUMBER IN ONE INCH CIRCLE =			1	
NUMBER IN TWO INCH CIRCLE =			6	
NUMBER IN THREE INCH CIRCLE =			10	

3 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6811496

CENTERFIRE PATTERNS # 3

POA

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in - 3

2 in - 8

3 in - 9

HS- 2.937

VS= 1.315

GS= 2.957

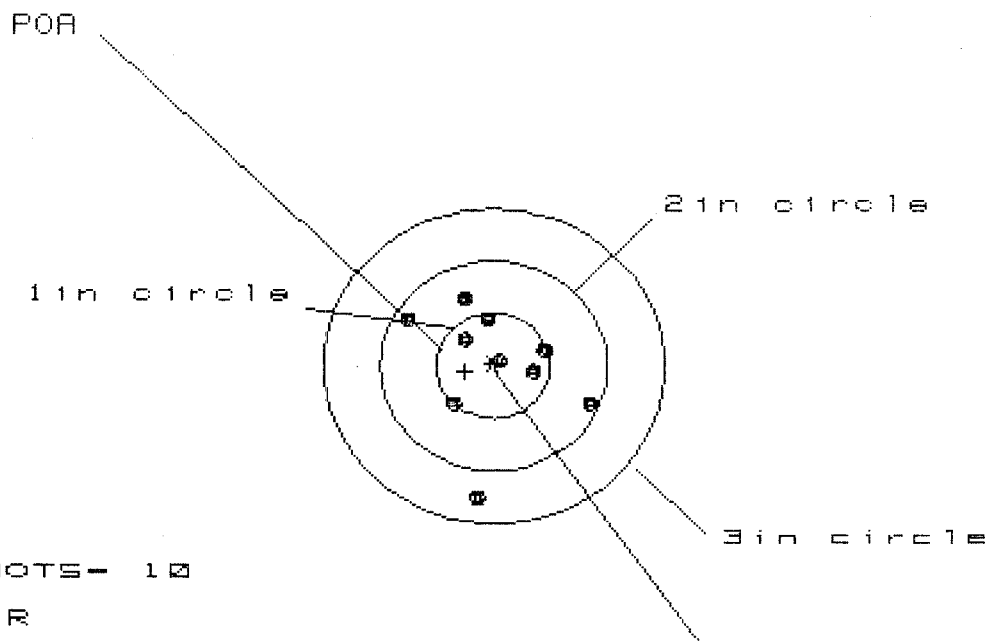
CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.748	1.050	.925
MINIMUM X	:	-1.189	-.995	-.868
MAXIMUM Y	:	.654	.423	.471
MINIMUM Y	:	-.660	-.588	-.540
CENTROID X	:	-.007	-.201	-.076
CENTROID Y	:	.199	.127	.079
POA TO CENTROID in.	:	.200	.237	.110
MIN RADIUS	:	.353	.185	.317
MEAN RADIUS	:	.854	.714	.665
MAX RADIUS	:	1.866	1.066	.971
HORIZONTAL SPREAD	:	2.937	2.045	1.793
VERTICAL SPREAD	:	1.315	1.011	1.011
EXTREME SPREAD	:	2.957	2.060	1.811
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	

3 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611496

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1 in = 6

2 in = 9

3 in = 10

HS= 1.523

VS= 1.934

GS= 1.934

CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.812	.791	.517
MINIMUM X	-.711	-.732	-.633
MAXIMUM Y	.688	.549	.487
MINIMUM Y	-1.247	-.495	-.547
CENTROID X	.251	.272	.173
CENTROID Y	.054	.192	.254
POA TO CENTROID in.	.257	.333	.307
MIN RADIUS	.053	.130	.180
MEAN RADIUS	.584	.491	.428
MAX RADIUS	1.260	.933	.673
HORIZONTAL SPREAD	1.523	1.523	1.150
VERTICAL SPREAD	1.934	1.044	1.034
EXTREME SPREAD	1.934	1.714	1.187
NUMBER IN ONE INCH CIRCLE =	6		
NUMBER IN TWO INCH CIRCLE =	9		
NUMBER IN THREE INCH CIRCLE =	10		

3 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611496

CENTERFIRE PATTERNS

5

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS- 10

IN CIR

1 in - 3

2 in - 8

3 in - 9

HS- 2.755

VS- 2.034

GS- 3.126

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.898	.724	.643
MINIMUM X	:	-.857	-.646	-.727
MAXIMUM Y	:	1.182	.805	.559
MINIMUM Y	:	-.852	-.721	-.620
CENTROID X	:	.193	-.018	.063
CENTROID Y	:	-.097	-.228	-.329
POA TO CENTROID in.	:	.216	.229	.335
MIN RADIUS	:	.330	.279	.311
MEAN RADIUS	:	.829	.653	.597
MAX RADIUS	:	2.236	1.033	.730
HORIZONTAL SPREAD	:	2.755	1.370	1.370
VERTICAL SPREAD	:	2.034	1.526	1.179
EXTREME SPREAD	:	3.126	1.749	1.375
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	