

G673 8628

Replaces

C6225530



No. 2-153L-3
UPC 10337

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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: **RE00143247** Serial: C6225530 Model M24 SWS Center Fire
 Verity Repair Caliber: 7.62 NATO Produced: 06/21/1989 Repairman: Status: Closed 3/18/2008 6:12:02 AM

Address Information

Customer: Received From Return To: Received From

Name: **COMMANDER DIR OF LOGISTICS SUPPLY DIV** **COMMANDER DIR OF LOGISTICS SUPPLY DIV**

Address 1: **ATTN: WEAPONS WAREHOUSE** **ATTN: WEAPONS WAREHOUSE**

Address 2: **BLDG 89010 CLARKE ROAD** **BLDG 89010 CLARKE ROAD** PO Box: **PO Box:**

City: **FORT HOOD** **FORT HOOD**

State: **TX** Zip Code: **76544** Country: **US** State: **TX** Zip Code: **76544** Country: **US**

FFL: **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 <table border="1"> <thead> <tr> <th>Code</th> <th>Desc</th> <th>Qty</th> </tr> </thead> <tbody> <tr> <td>A007</td> <td>With Stud</td> <td>3</td> </tr> <tr> <td>A017</td> <td>Scope Base</td> <td>1</td> </tr> <tr> <td>A057</td> <td>Fit and Rear Sgt Base</td> <td>1</td> </tr> </tbody> </table>		Code	Desc	Qty	A007	With Stud	3	A017	Scope Base	1	A057	Fit and Rear Sgt Base	1
Code	Desc	Qty														
A007	With Stud	3														
A017	Scope Base	1														
A057	Fit and Rear Sgt Base	1														

nagletj 3/26/2008 10:37 AM CAPS NUM

start 10 Micro... 16 Micros... Part Search... https://aai... Arms Servi... 03/27/08

G6738628

Serial Number: **C6225530**

Model: **M24 SWS**



RE00143247

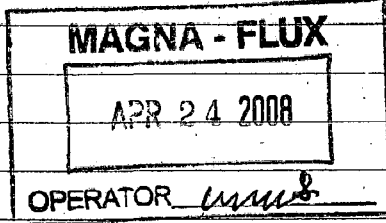
M-24 INSPECTION CHECKLIST
CONTRACT #: DAAE-20-02-C-0149

R & E NUMBER 143247

SERIAL NUMBER G6738628

LOG-IN DATE 3-18-08

OPERATION #	OPERATION NAME	DATE	INITIAL
500	DIS-ASSEMBLE GUN	4-18-08	RZ
505	RE-BARREL	4-22-08	RZ
560	ASSEMBLE	4-22-08	RZ
600	PROOF	4-22-08	TRW
605	CHECK HEADSPACE	4-22-08	TRW
610	DIS-ASSEMBLE GUN	4-22-08	RZ
612	MAGNAFLUX	4/24/08	mmg
510	DRILL AND TAP	4-22-08	TRW
615	ROLLMARK CALIBER	4-23-08	CW
618	ROTO-BLAST	4-24-08	DA
620	APPLY COATINGS	4-28-08	WJ
625	FINAL ASSEMBLY	4-29-08	TRW
640	FUNCTION TEST AND	5-2-08	TRW
650	TARGET	5-2-08	TRW
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
670	FINAL INSPECTION	5-2-08	FM
	A) HEADSPACE	5-2-08	TRW
	B) TRIGGER PULL	2.20 2.21 2.22 2.22 2.22 5-2-08	TRW
680	F) SAFETY ON FORCE	6.25 6.75 6.75 5-2-08	TRW
	G) SAFETY OFF FORCE	2.5 2.75 2.75 5-2-08	TRW
	I) FIRING PIN INDENT	.020 ⁵ .020 ⁵ .020 5-2-08	TRW
690	PACK	5-2-08	FM



N/A

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50 LBS (plus or minus 0.50 LBS)
3.00 LBS (plus or minus 0.75 LBS)
4.00 LBS (plus or minus 1.00 LBS)

DATE 1-9-08

TESTER TRW

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.72	2.29		2.26	
PULL #2	2.71	2.26		2.27	
PULL #3	2.75	2.14		2.29	
PULL #4	2.79	2.03		2.28	
PULL #5	2.78	2.02		2.30	
TOTAL	13.75	10.74		11.40	
AVERAGE	2.75	2.14		2.28	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.26	3.06		
PULL #2	3.20	3.04		
PULL #3	3.05	3.08		
PULL #4	3.01	3.09		
PULL #5	3.12	3.08		
TOTAL	15.64	15.35		
AVERAGE	3.12	3.07		

	4.00 LBS INITIAL	4.00 LBS AFTER 20 CYCLES	MAX SETTING GREATER THAN 4 LBS	RESET TO 4 LBS FOR TARGET & ACCURACY
PULL #1	4.10	4.05		4.48
PULL #2	4.11	4.07		4.45
PULL #3	4.03	4.05		4.44
PULL #4	4.22	4.08		4.47
PULL #5	4.29	4.09		4.46
TOTAL	20.75	20.34		22.30
AVERAGE	4.15	4.06		4.46

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6738628.__0

FILE DATE AND TIME: 05/02/2008 08:45

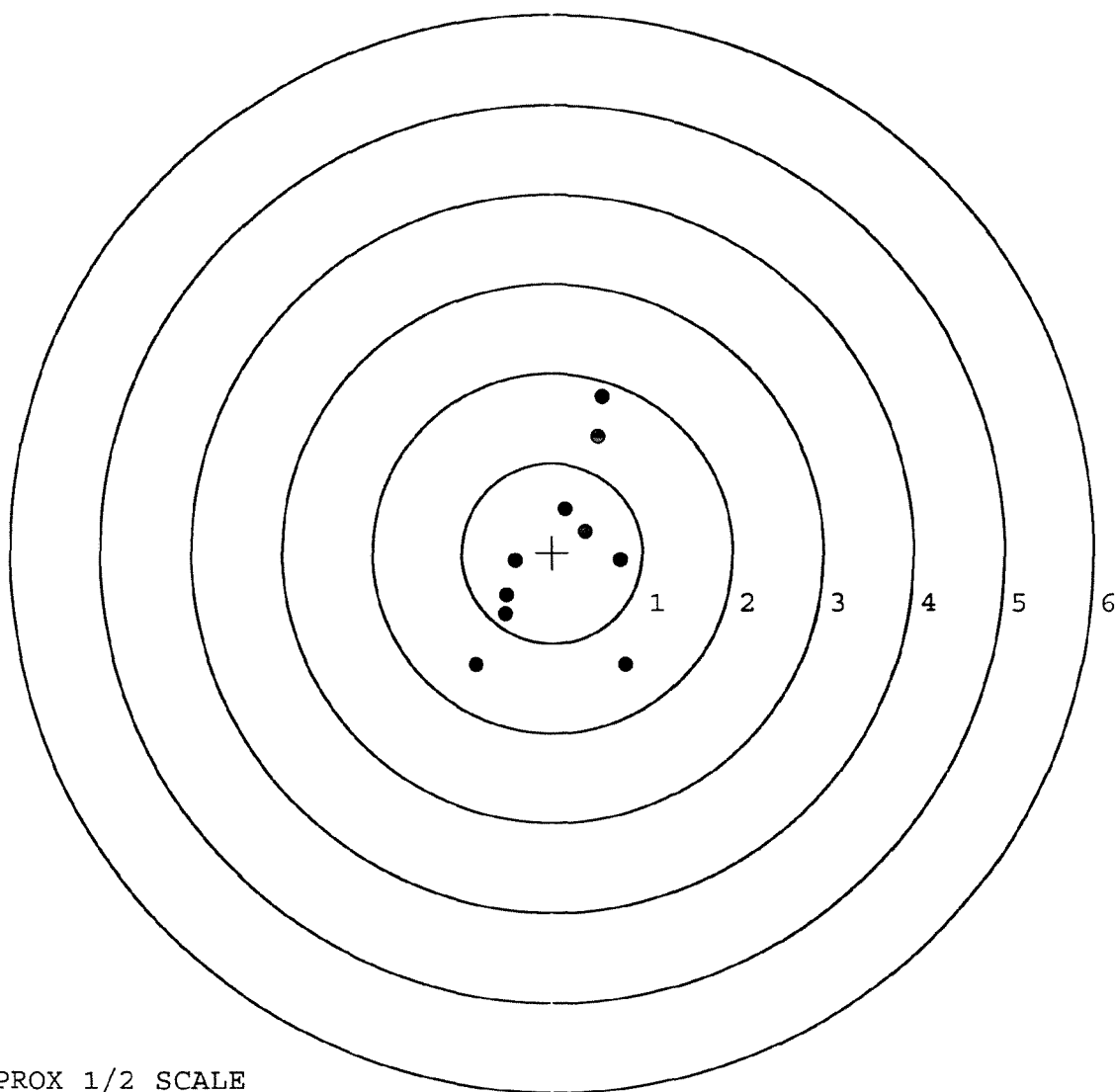
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.072
The Average Y Centroid of the Five Target Set:	0.004
The Average Point of Impact of the Five Target Set:	0.072
The Average Mean Radius of the Five Target Set:	0.768
The Distance from POA to Centroid Target #1:	0.091
The Distance from Centroid Target #2 to Centroid Target #1:	0.129
The Distance from Centroid Target #3 to Centroid Target #1:	0.135
The Distance from Centroid Target #4 to Centroid Target #1:	0.090
The Distance from Centroid Target #5 to Centroid Target #1:	0.089

SERIAL NUMBER: G6738628. __0
TARGET NUMBER: 1
FILE DATE: 05/02/2008
FILE TIME: 08:45

	POINT#	X	Y
	1:	0.766	-0.081
	2:	0.367	0.239
	3:	0.148	0.483
	4:	-0.404	-0.095
	5:	-0.502	-0.475
	6:	-0.516	-0.684
	7:	-0.842	-1.251
	8:	0.820	-1.245
	9:	0.508	1.295
	10:	0.558	1.741

X CENTROID: 0.090
Y CENTROID: -0.007
POA TO CENTROID: 0.091
HORZ SPREAD: 1.662
VERT SPREAD: 2.992
GROUP SPREAD: 3.303
MIN RADIUS: 0.370
MAX RADIUS: 1.810
MEAN RADIUS: 0.988
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 6
in 3 IN DIAMETER: 8

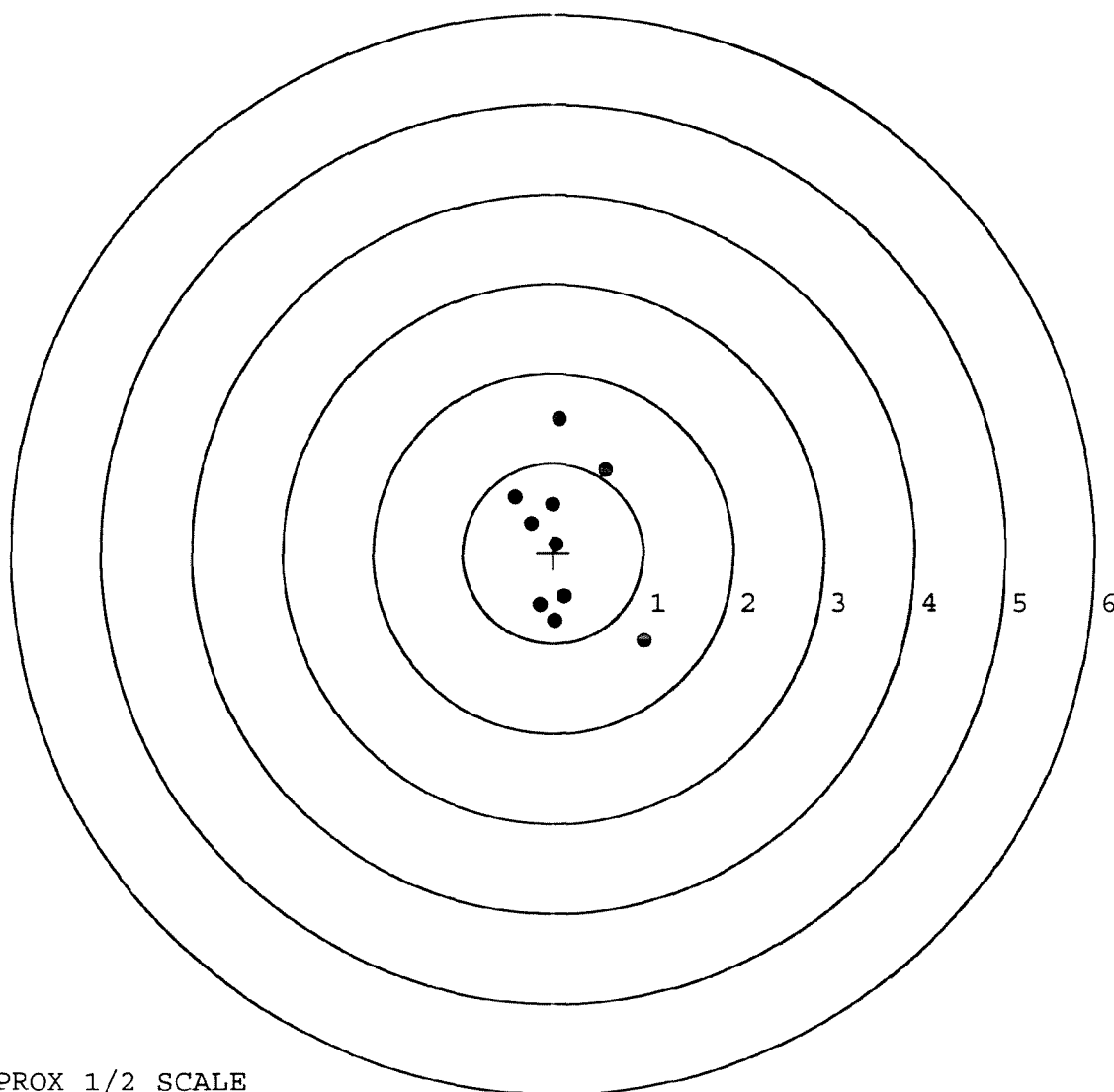


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6738628. __0
TARGET NUMBER: 2
FILE DATE: 05/02/2008
FILE TIME: 08:45

X CENTROID: 0.106
Y CENTROID: 0.121
POA TO CENTROID: 0.160
HORZ SPREAD: 1.430
VERT SPREAD: 2.465
GROUP SPREAD: 2.637
MIN RADIUS: 0.076
MAX RADIUS: 1.423
MEAN RADIUS: 0.760
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	1.011	-0.977
2:	0.588	0.928
3:	0.074	1.488
4:	0.023	-0.757
5:	-0.143	-0.578
6:	0.132	-0.486
7:	-0.419	0.620
8:	0.034	0.097
9:	-0.001	0.542
10:	-0.241	0.328



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6738628. 0

TARGET NUMBER: 3

FILE DATE: 05/02/2008

FILE TIME: 08:45

POINT#	X	Y
--------	---	---

1:	0.600	-0.525
----	-------	--------

2:	0.386	-0.590
----	-------	--------

3:	0.483	-0.689
----	-------	--------

4:	-1.018	-0.603
----	--------	--------

5:	0.364	0.668
----	-------	-------

6:	-0.473	0.536
----	--------	-------

7:	0.292	-0.124
----	-------	--------

8:	0.095	-0.027
----	-------	--------

9:	-0.178	0.074
----	--------	-------

10:	-0.439	0.109
-----	--------	-------

X CENTROID: 0.011

Y CENTROID: -0.117

POA TO CENTROID: 0.118

HORZ SPREAD: 1.618

VERT SPREAD: 1.357

GROUP SPREAD: 1.878

MIN RADIUS: 0.123

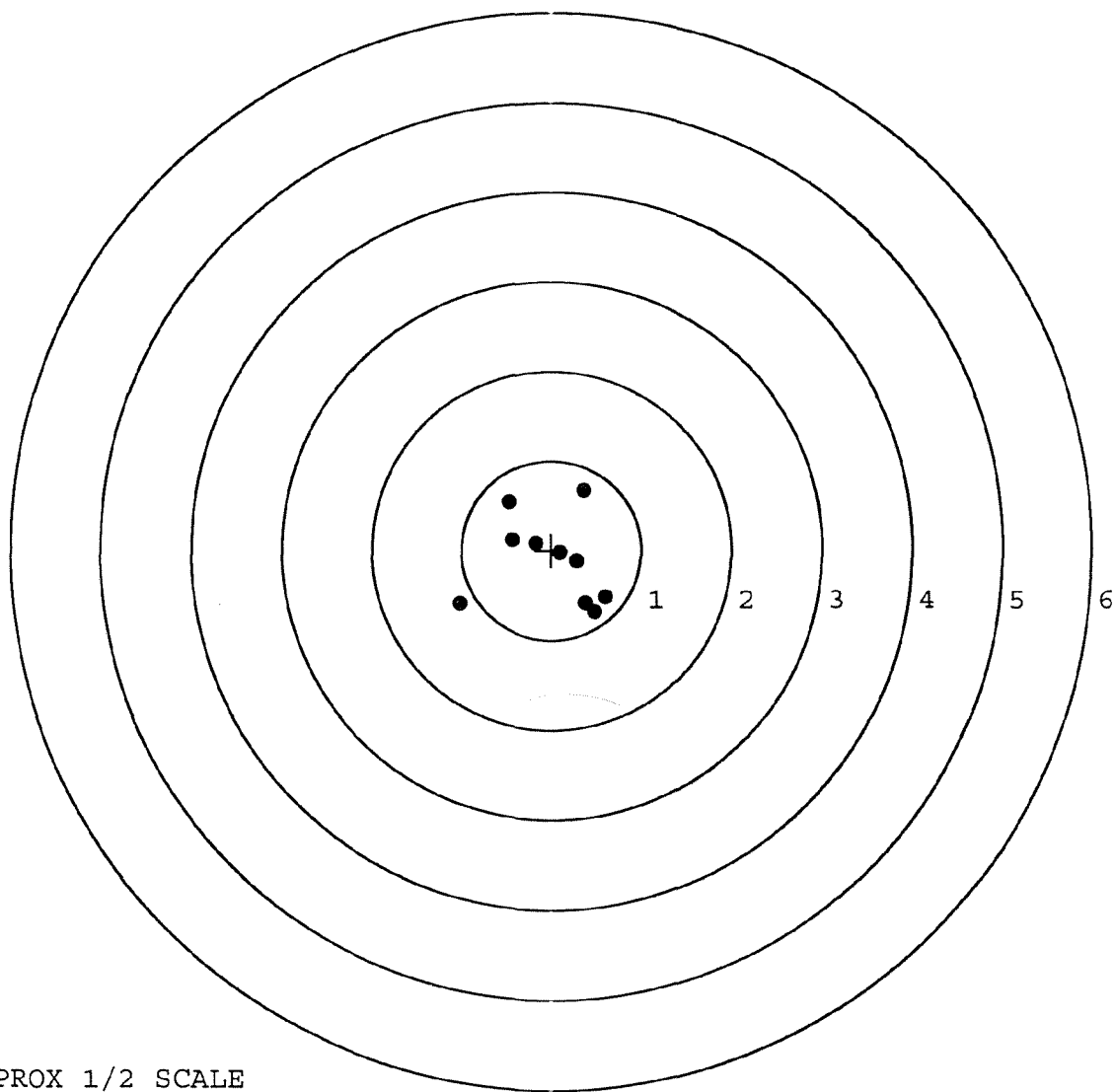
MAX RADIUS: 1.138

MEAN RADIUS: 0.605

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10

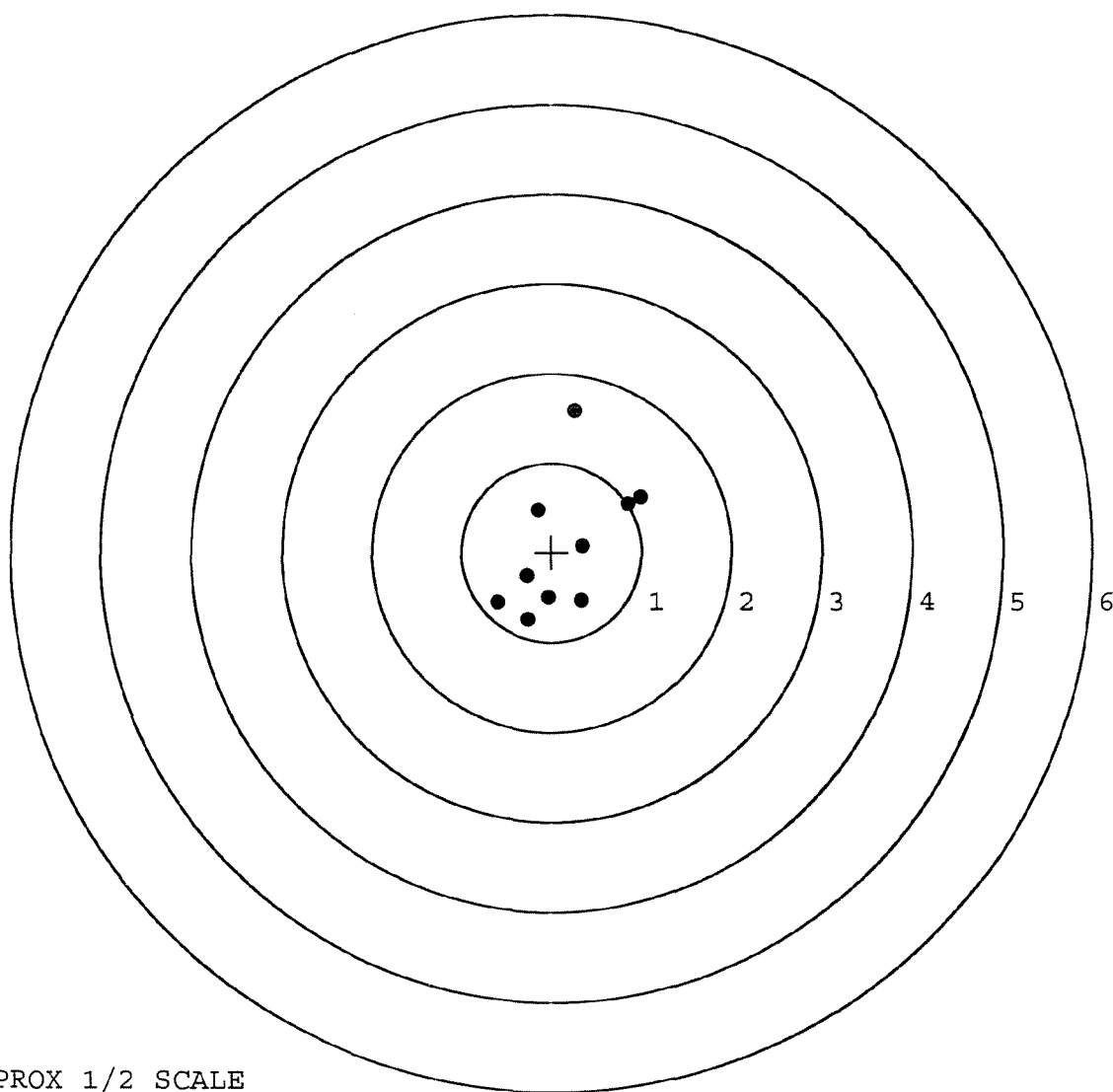


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6738628. __0
TARGET NUMBER: 4
FILE DATE: 05/02/2008
FILE TIME: 08:45

X CENTROID: 0.147
Y CENTROID: 0.063
POA TO CENTROID: 0.160
HORZ SPREAD: 1.591
VERT SPREAD: 2.334
GROUP SPREAD: 2.392
MIN RADIUS: 0.194
MAX RADIUS: 1.522
MEAN RADIUS: 0.775
IN 1 IN DIAMETER: 1
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 9

POINT#	X	Y
1:	0.992	0.616
2:	0.850	0.544
3:	-0.151	0.473
4:	0.264	1.580
5:	0.340	0.072
6:	0.335	-0.546
7:	-0.271	-0.271
8:	-0.033	-0.512
9:	-0.261	-0.754
10:	-0.599	-0.572



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6738628. 0

TARGET NUMBER: 5

FILE DATE: 05/02/2008

FILE TIME: 08:45

POINT#	X	Y
1:	1.231	-0.088
2:	0.173	1.340
3:	-1.034	-0.257
4:	-0.961	-0.493
5:	-0.451	-0.769
6:	0.441	-0.332
7:	0.458	0.109
8:	0.142	0.209
9:	-0.069	-0.095
10:	0.151	-0.028

X CENTROID: 0.008

Y CENTROID: -0.040

POA TO CENTROID: 0.041

HORZ SPREAD: 2.265

VERT SPREAD: 2.109

GROUP SPREAD: 2.199

MIN RADIUS: 0.094

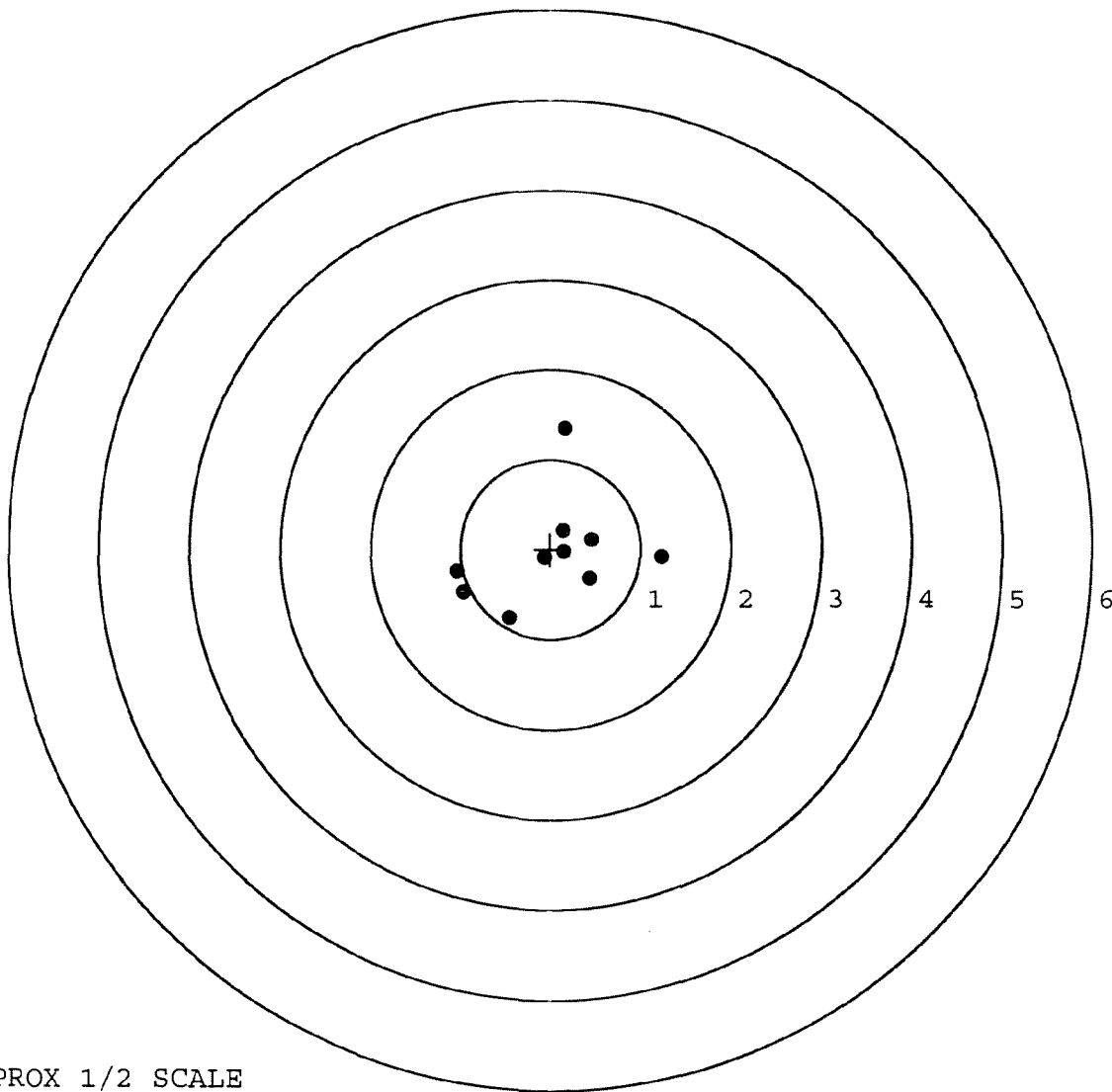
MAX RADIUS: 1.390

MEAN RADIUS: 0.713

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6225530

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	4 12	89	RW
600	Proof	4 12	89	RW
607	Check Headspace	4 12	89	RW
610	Dis-assemble Gun	4 12	89	RW
612	Magnaflux Barrel Action		4/13/89	KCR
	Magnaflux Bolt		4/14/89	KCR
615	Rollmark Caliber		4/15/89	GS
617	Drill and Tap Sight Holes	4 14	89	LB
618	Polish Barrel RB	4 14	89	BT
620	Apply Coatings (Barrel Action)		4-20-89	TJA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		5/1/89	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/1/89	RW
	C) Inspect Ejector Hole for Chamfer		5/1/89	RW
	D) Oil Firing Pin Ass'y		5/1/89	RW
	E) Adjust Trigger Pull to Min Setting and Stake		5/1/89	WB

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	5.75			5/1/89	WB
	G) Safety Off Force	3.5	3.5	3.25			5/1/89	WB
	H) Trigger Pull Test & Retainability						5/1/89	WB
	I) Firing Pin Indent	.0205	.020	.021			5/1/89	WB
	J) Assemble Stock						5/5/89	RW
	K) Assemble Swivel Studs						15 May 89	LS
	L) Attach Front and Rear Sight Assemblies						5/5/89	RW
	M) Iron Sight Alignment						5/5/89	RW
	N) Detach Front & Rear Sights & place in numbered container						5/5/89	RW
	O) Attach Scope to Rifle						5/5/89	RW
	P) Detach & Attach Scope 20 Times						5/8/89	RW
640	Gallery Target & Test	76 R	75 L				5/9/89	DH
	A) Time						5/9/89	DH
	B) Malfunctions						5/9/89	DH
	C) Pierced Primers						5/9/89	DH
	D) Optical Clarity of Scope						5/9/89	DH
645	Inspect for Live Ammo						5/9/89	DH
655	Final Inspection							
	A) Headspace						15 May 89	LS
	B) Trigger Pull	2.52	2.70	2.72	2.70	2.51	15 May 89	LS
	C) Function						15 May 89	LS
660	Pack						26 June 89	LS

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

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

SERIAL NO. 6725530

DATE 4-6-90

TESTER JL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.45	2.41		2.46	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.39	2.46		2.49	
PULL #3	2.32	2.41		2.53	
PULL #4	2.54	2.51		2.54	
PULL #5	2.36	2.41		2.48	
TOTAL	12.06	12.20		12.50	
AVG.	2.412	2.44		2.5	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.59	3.30		
PULL #2	3.30	3.38		
PULL #3	3.40	3.41		
PULL #4	3.33	3.40		
PULL #5	3.33	3.41		
TOTAL	16.95	16.90		
AVG.	3.39	3.38		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.29	4.37		
PULL #2	4.38	4.35		
PULL #3	4.28	4.37		
PULL #4	4.36	4.38		
PULL #5	4.37	4.36		
TOTAL	21.67	21.83		
AVG.	4.334	4.366		




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

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

MODEL 700TM H24

SERIAL NO. C6225530

ORDER NO. 5716

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

Ø1



5716 C6225530

LPC



0 47700 25716 7

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06225530
10 May 1989

CENTROIDAL DISTANCES

0 TO	1	.538889
1 TO	2	.479634
1 TO	3	.682062
1 TO	4	.527087
1 TO	5	.472382

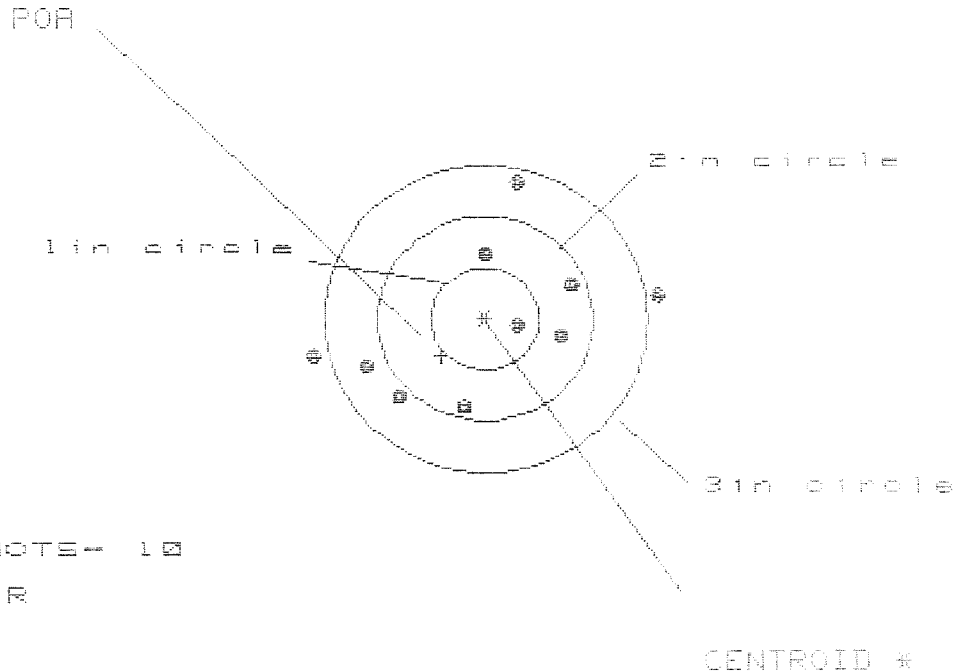
$\bar{x}_2$ <----POB

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .2918
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0296
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .293297
THE AMR FOR THIS RIFLE IS: .9098

18 May 1988

FILE:/PATTERNING/CENTERFIRE_PATT/06225530

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 5

3 in = 8

HS= 3.136

VS= 2.242

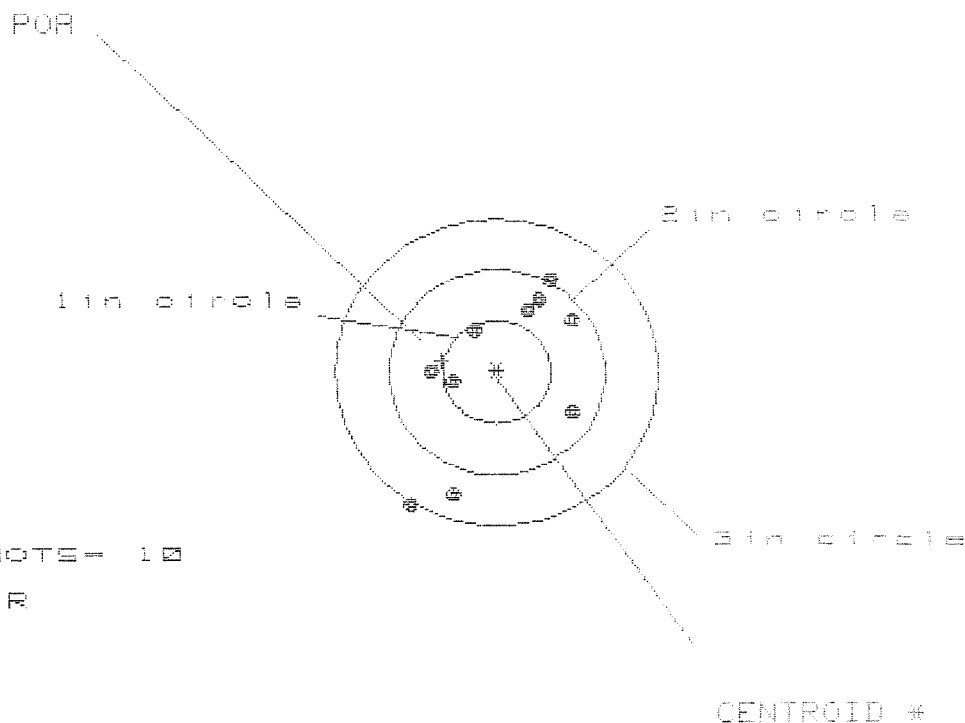
GS= 3.181

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.573	1.399	.778
MINIMUM X	:	-1.563	-1.284	-1.169
MAXIMUM Y	:	1.371	1.335	1.357
MINIMUM Y	:	-.871	-.907	-.885
CENTROID X	:	.401	.575	.400
CENTROID Y	:	.360	.396	.374
POA TO CENTROID in.	:	.539	.698	.548
MIN RADIUS	:	.280	.110	.282
MEAN RADIUS	:	1.023	.922	.881
MAX RADIUS	:	1.597	1.410	1.390
HORIZONTAL SPREAD	:	3.136	2.683	1.887
VERTICAL SPREAD	:	2.242	2.242	2.242
EXTREME SPREAD	:	3.181	2.756	2.421
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

18 May 1989

FILE:/PATTERNING/CENTERFIRE_PATT/06225530

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1 in = 2

2 in = 8

3 in = 8

HS= 1.556

VS= 2.192

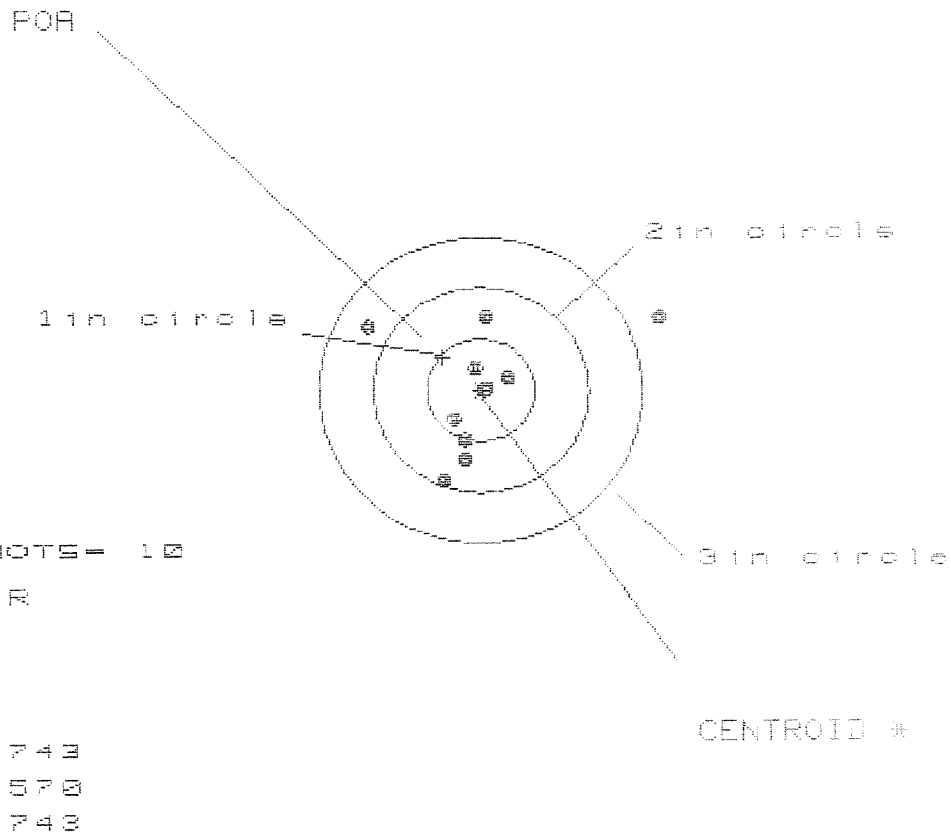
GS= 2.541

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.723	.630	.565
MINIMUM X	:	-.833	-.734	-.799
MAXIMUM Y	:	.872	.725	.553
MINIMUM Y	:	-1.320	-1.332	-1.709
CENTROID X	:	.506	.599	.664
CENTROID Y	:	-.108	.039	.206
POR TO CENTROID in.	:	.517	.600	.696
MIN RADIUS	:	.455	.419	.296
MEAN RADIUS	:	.854	.744	.616
MAX RADIUS	:	1.561	1.432	.906
HORIZONTAL SPREAD	:	1.556	1.364	1.364
VERTICAL SPREAD	:	2.192	2.057	1.267
EXTREME SPREAD	:	2.541	2.240	1.429
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	

18 May 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C6225538

CENTERFIRE PATTERNS # 3



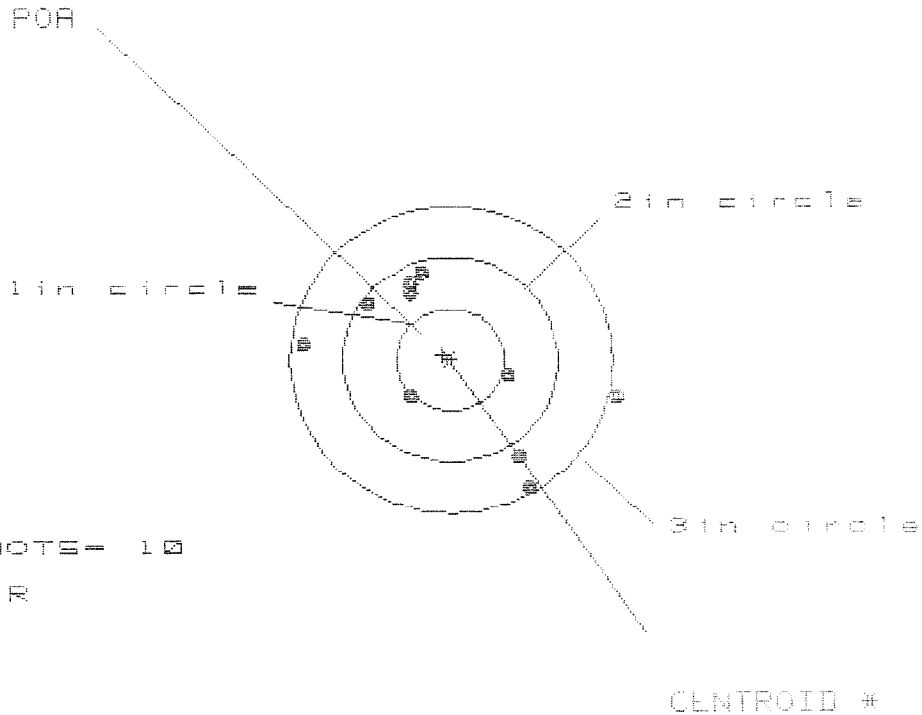
PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.673	.479	.369
MINIMUM X	:	-1.070	-.685	-.230
MAXIMUM Y	:	.728	.802	.889
MINIMUM Y	:	-.842	-.768	-.681
CENTROID X	:	.348	.163	.273
CENTROID Y	:	-.320	-.394	-.481
FOR TO CENTROID in.	:	.473	.426	.553
MIN RADIUS	:	.007	.199	.173
MEAN RADIUS	:	.681	.556	.460
MAX RADIUS	:	1.803	1.126	.897
HORIZONTAL SPREAD	:	2.743	1.364	.599
VERTICAL SPREAD	:	1.570	1.570	1.570
EXTREME SPREAD	:	2.743	1.652	1.607
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	

10 May 1989

FILE:/PATTERNING/CENTERFIRE_PATT/06225530

CENTERFIRE PATTERNS

4



OF SHOTS = 10

IN CIR

1in = 1

2in = 6

3in = 9

HS = 2.937

VS = 2.159

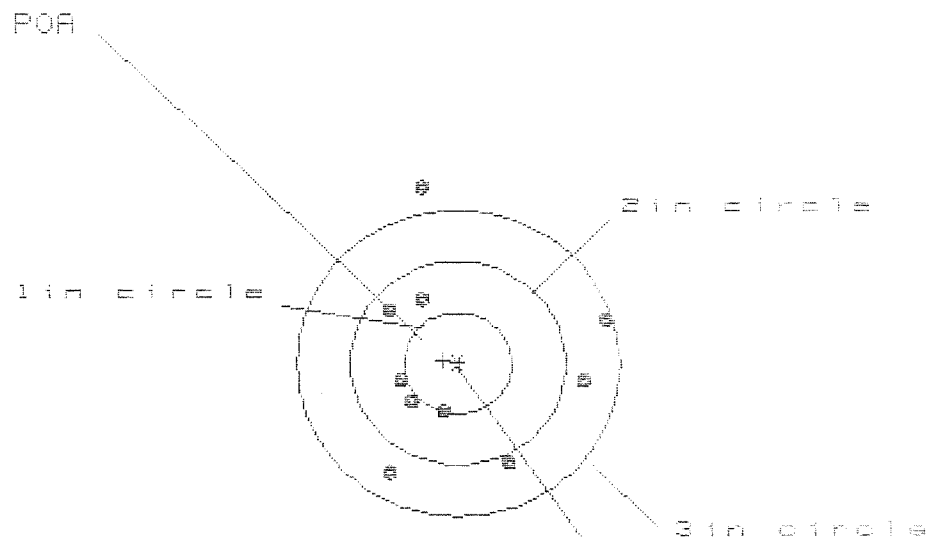
GS = 2.981

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.532	.910	.922
MINIMUM X	:	-1.405	-1.234	-1.121
MAXIMUM Y	:	.897	.861	.698
MINIMUM Y	:	-1.262	-1.298	-1.197
CENTROID X	:	.071	-.100	-.213
CENTROID Y	:	-.051	-.015	.148
POA TO CENTROID in.	:	.087	.101	.259
MIN RADIUS	:	.452	.385	.472
MEAN RADIUS	:	1.012	.924	.797
MAX RADIUS	:	1.567	1.585	1.511
HORIZONTAL SPREAD	:	2.937	2.144	2.043
VERTICAL SPREAD	:	2.159	2.159	1.895
EXTREME SPREAD	:	2.981	2.587	2.361
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

18 May 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C8225530

CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1 in = 0

2 in = 5

3 in = 9

HS= 1.984

VS= 2.753

GS= 2.776

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.340	1.299	1.246
MINIMUM X	:	-.644	-.685	-.522
MAXIMUM Y	:	1.685	.858	.935
MINIMUM Y	:	-1.068	-.880	-.803
CENTROID X	:	.133	.174	.011
CENTROID Y	:	-.029	-.216	-.293
POA TO CENTROID in.	:	.136	.277	.293
MIN RADIUS	:	.512	.360	.256
MEAN RADIUS	:	.979	.871	.749
MAX RADIUS	:	1.725	1.439	1.247
HORIZONTAL SPREAD	:	1.984	1.984	1.768
VERTICAL SPREAD	:	2.753	1.738	1.738
EXTREME SPREAD	:	2.776	2.468	1.942
NUMBER IN ONE INCH CIRCLE =			0	
NUMBER IN TWO INCH CIRCLE =			5	
NUMBER IN THREE INCH CIRCLE =			9	

RECEIVING AND ESTIMATING REPORT

COMMENTS

ORDER
R 95-14841

INITIAL
JJM

CUSTOMER ORDER NO.

M-24 SNIPER W/10X-M3A SCOPE

DATE RECEIVED
05/16/95

DATE OPENED
05/17/95

DATE CODE
CJ 4-89

SERIAL NUMBER
C6225530

NEW SERIAL NUMBER

MODEL AND GRADE
700 7.62

NATO

ACCESSORIES

HARD CASE

SCOPE BASE

W/STUDS

FROM:TRANSPORTATION OFFICE
FT CAMPBELL KY 42223

SHIP TO:TRANSPORTATION OFFICE
FT CAMPBELL KY 42223

L

CUST NO:087942 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.	New	Barrel		D1	E3	F3
REC. ASSY.		B5		D2	E4	F4
WOOD			C1	D3	E5	F5
METAL			C2			
MAIN FAULT	Barrel Shot Out					

PARTS

Barrel - 96003

COMMENTS

Re powder Coat Trigger Guard
Assy, Front & Rear Sight
Bases.
Re zinc, Scope Base, Rings &
Swivel Studs

REPAIRMAN

PROOF

CLEAN

TEST

TARGET

PATTERN

GALLERY TESTER

DATE

DATE

DATE

DATE

DATE

RW

5/30/95

6/16/95

6/19/95

6/19/95

Final Inspection

Sn: C6225530

DATE REC'D: 5/16/95

DATE RET'D:

AUDITOR: MM

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: _____

New Barrel

CONTRACT # DAAA21-87-C-0086

C6225530

GUN SERIAL #

~~C677082~~

OP. #	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and Stock		5/30/95	RW
600	Proof		5/30/95	RW
607.	Check Headspace		5/30/95	RW
610	Dis-assemble Gun		5/30/95	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		6/16/95	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		6/16/95	RW
	C) Inspect Ejector Hole for Chamfer		6/16/95	RW
	D) Oil Firing Pin Ass'y		6/16/95	RW
	E) Adjust Trigger Pull to Min Setting and Stake			

op. #	OP. NAME	READINGS	DATE	INIT
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		6/19/95	RW
	A) Time			
	B) Malfunctions			
	C) Pierced Primers			
	D) Optical Clarity of Scope			
645	Inspect for Live Ammo		6/19/95	RW
655	Final Inspection			
	A) Headspace		6/20/95	RW
	B) Trigger Pull		6/20/95	RW
	C) Function		6/20/95	RW
660	Pack			

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6225530
11 JUL 1995

CENTROIDAL DISTANCES

0 TO	1	.161484
1 TO	2	.378021
1 TO	3	.107079
1 TO	4	.274729
1 TO	5	.381602

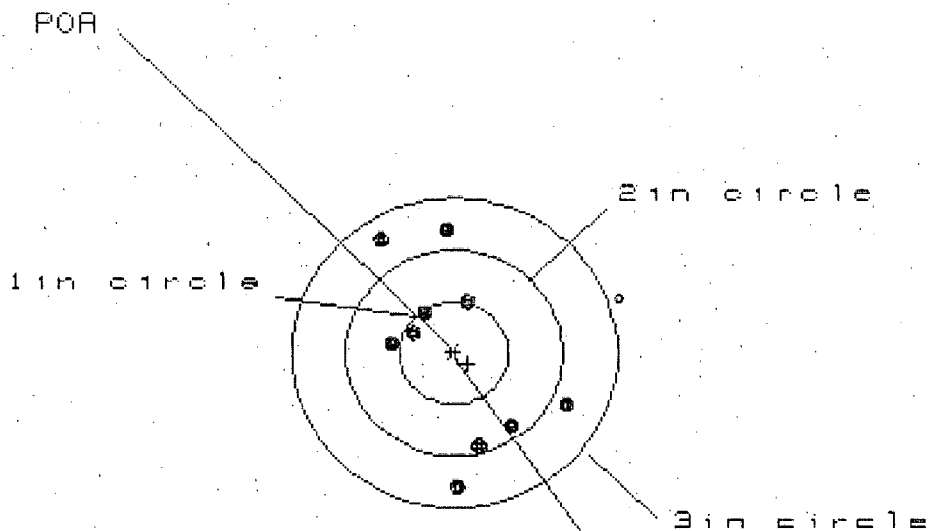
45 (----POB

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0818
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0552
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0986827
THE AMR FOR THIS RIFLE IS: 1.053

11 Jul 1995

FILE:/PATTERNING/CENTERFIRE_PATT/C6225530

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR.

1in - 3

2in - 6

3in - 10

HS= 1.749

VS= 2.529

GS= 2.547

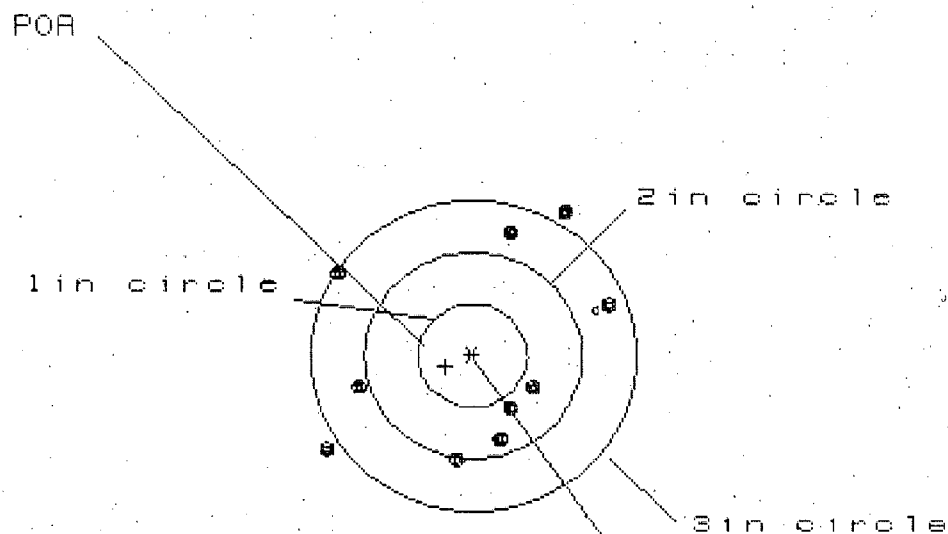
CENTROID #

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.050	.972	.966
MINIMUM X	-.699	-.604	-.610
MAXIMUM Y	1.214	1.339	1.190
MINIMUM Y	-1.315	-1.190	-.951
CENTROID X	-.126	-.048	-.042
CENTROID Y	.101	-.024	.125
POA TO CENTROID in.	.161	.054	.131
MIN RADIUS	.435	.562	.442
MEAN RADIUS	.877	.836	.772
MAX RADIUS	1.325	1.345	1.198
HORIZONTAL SPREAD	1.749	1.576	1.576
VERTICAL SPREAD	2.529	2.529	2.141
EXTREME SPREAD	2.547	2.530	2.155
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		10	

11 Jul 1995

FILE:/PATTERNING/CENTERFIRE_PATT/C6225530

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 0

2 in = 3

3 in = 0

HS= 2.599

VS= 2.389

GS= 3.180

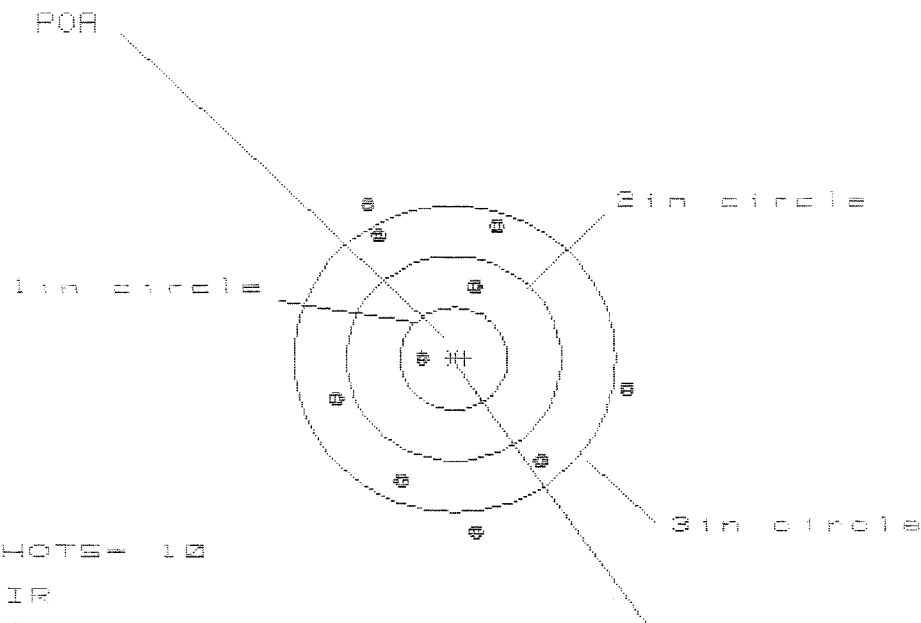
CENTROID #

PATTERN #	2	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.283	1.137	1.228
MINIMUM X	-1.316	-1.369	-1.278
MAXIMUM Y	1.364	1.259	1.281
MINIMUM Y	-1.025	-1.130	-0.972
CENTROID X	.252	.398	.307
CENTROID Y	.105	.210	.052
POA TO CENTROID in.	.273	.450	.312
MIN RADIUS	.622	.568	.549
MEAN RADIUS	1.161	1.103	1.030
MAX RADIUS	1.620	1.521	1.518
HORIZONTAL SPREAD	2.599	2.506	2.506
VERTICAL SPREAD	2.389	2.389	2.253
EXTREME SPREAD	3.180	2.593	2.516
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	3		
NUMBER IN THREE INCH CIRCLE =	0		

11 JUL 1995

FILE:/PATTERNING/CENTERFIRE_PATT/08225530

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 1

2in = 2

3in = 7

HS= 0.7000

VS= 3.234

GS= 3.370

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.633	1.654	1.563
MINIMUM X	:	-1.076	-1.055	-1.146
MAXIMUM Y	:	1.518	1.328	1.292
MINIMUM Y	:	-1.716	-1.420	-1.254
CENTROID X	:	-.105	-.126	-.035
CENTROID Y	:	-.004	.186	.020
POB TO CENTROID in.	:	.105	.225	.040
MIN RADIUS	:	.298	.336	.369
MEAN RADIUS	:	1.253	1.190	1.156
MAX RADIUS	:	1.726	1.738	1.605
HORIZONTAL SPREAD	:	2.709	2.709	2.709
VERTICAL SPREAD	:	3.234	2.748	2.546
EXTREME SPREAD	:	3.370	3.026	2.779
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		2	
NUMBER IN THREE INCH CIRCLE	=		7	

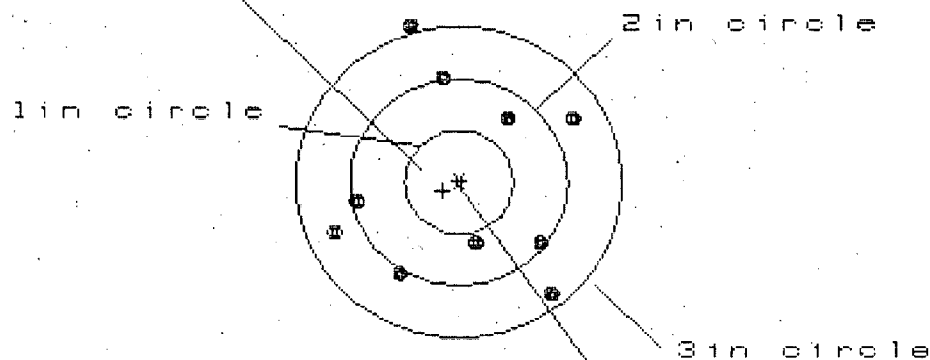
11 Jul 1995

FILE:/PATTERNING/CENTERFIRE_PATT/C6225530

CENTERFIRE PATTERNS

4

POA



OF SHOTS- 10

IN CIR

1in = 0

2in = 5

3in = 9

HS= 2.253

VS= 2.640

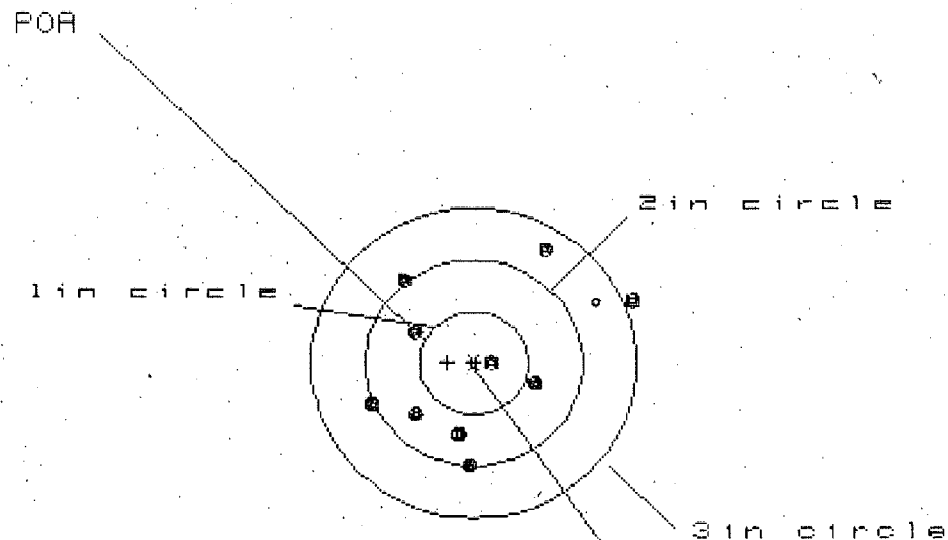
GS= 2.964

PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.079	1.025	1.125
MINIMUM X	-1.174	-1.228	-1.128
MAXIMUM Y	1.536	1.161	1.044
MINIMUM Y	-1.104	-.934	-.818
CENTROID X	.148	.202	.102
CENTROID Y	.081	-.089	.028
POA TO CENTROID in.	.169	.221	.105
MIN RADIUS	.643	.464	.604
MEAN RADIUS	1.094	1.016	.988
MAX RADIUS	1.611	1.318	1.332
HORIZONTAL SPREAD	2.253	2.253	2.253
VERTICAL SPREAD	2.640	2.095	1.862
EXTREME SPREAD	2.964	2.514	2.514
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	9		

11 Jul 1995

FILE:/PATTERNING/CENTERFIRE_PATT/C6225530

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 1

2in = 7

3in = 9

HS= 2.346

VS= 2.016

GS= 2.533

CENTROID *

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.434	.781	.849
MINIMUM X	-.912	-.753	-.655
MAXIMUM Y	1.068	1.130	1.050
MINIMUM Y	-.948	-.886	-.744
CENTROID X	.240	.081	-.017
CENTROID Y	-.007	-.069	-.211
POA TO CENTROID in.	.240	.107	.211
MIN RADIUS	.208	.367	.448
MEAN RADIUS	.868	.777	.678
MAX RADIUS	1.541	1.374	1.115
HORIZONTAL SPREAD	2.346	1.534	1.504
VERTICAL SPREAD	2.016	2.016	1.794
EXTREME SPREAD	2.533	2.131	1.881
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		9	