

C6522236

MODEL 700™ 124

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5716**

* Includes 1 in chamber.

Remington

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: RE00136221

Serial: C6522236 Model M24 SWS Center Fire
Caliber: 7.62 NATO

Repairman:

Verify Repair

Status: Closed 11/2/2007 10:17:03 AM

Address Information

Customer:

Received From

Return To:

Received From

Name: BARRY MOBERLY

BARRY MOBERLY

Address 1: L-3 COMMUNICATIONS

L-3 COMMUNICATIONS

Address 2: 5749 BRIAR HILL RD BLDG 221

PO Box:

5749 BRIAR HILL RD BLDG 221

PO Box:

City: LEXINGTON

LEXINGTON

State: KY

Zip Code: 40516

Country: US

State: KY

Zip Code: 40516

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
A008	With Swivel	3
A010	Hard Case	1
A026	Scope	1
A055	Deployment Kit	1
D000	SCOPE CASE	1

Repair Search

Refresh

Close

nagletj

11/2/2007

1:12 PM

CAPS

NUM

INS

SCRL



2 Mi...

5 Int...

4 Mi...

Part S...

longo...

Arms ...

1:11 PM

Serial
Number:

C6522236

Model: M24 SWS



RE00136221

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

R&E NUMBER 136221
SERIAL NUMBER C6522236
LOG-IN DATE 11-7-07

OPERATION #	OPERATION NAME		DATE	INITIAL
500	DIS-ASSEMBLE GUN		7-10-08	RTZ
505	RE-BARREL		7-18-08	RTZ
560	ASSEMBLE	MAGNA - FLUX JUL 23 2008 OPERATOR <u>B/A</u>	7-15-08	RSN
600	PROOF		7-16-08	TRW
605	CHECK HEADSPACE		7-16-08	TRW
610	DIS-ASSEMBLE GUN		7-18-08	RTZ
612	MAGNAFLUX		7-25-08	B/A
510	DRILL AND TAP		7-19-08	SP
615	ROLLMARK CALIBER		7-25-08	RT
618	ROTO-BLAST		7-25-08	DR
620	APPLY COATINGS		8-1	C
625	FINAL ASSEMBLY		8-5-08	RTZ
640	FUNCTION TEST AND	PASS FAIL	8-28-08	FM
650	TARGET	PASS FAIL	8-28-08	FM
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION	8-28-08	TRW
670	FINAL INSPECTION		9-8-08	RTZ
	A) HEADSPACE	PASS FAIL	9-8-08	RTZ
	B) TRIGGER PULL	4.5 LBS MIN 2.50 LBS MAX 4.0 LBS	2.18 2.18 2.18 2.03 2.18 9-8-08	RSN
680	F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX	7.50 7.50 7.50 9-8-08	RTZ
	G) SAFETY OFF FORCE	2 LBS	4.0 4.0 4.0 9-8-08	RTZ
	I) FIRING PIN INDENT	.020	.023 .023 .023 9-8-08	RTZ
690	PACK		9-9-08	TE

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6522236.___0
FILE DATE AND TIME: 08/28/2008 10:20

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.056
The Average Y Centroid of the Five Target Set:	-0.103
The Average Point of Impact of the Five Target Set:	0.117
The Average Mean Radius of the Five Target Set:	0.604
The Distance from POA to Centroid Target #1:	0.136
The Distance from Centroid Target #2 to Centroid Target #1:	0.019
The Distance from Centroid Target #3 to Centroid Target #1:	0.150
The Distance from Centroid Target #4 to Centroid Target #1:	0.190
The Distance from Centroid Target #5 to Centroid Target #1:	0.075

SERIAL NUMBER: C6522236. __0

TARGET NUMBER: 1

FILE DATE: 08/28/2008

FILE TIME: 10:20

POINT#	X	Y
1:	-0.518	-0.203
2:	-0.444	-0.534
3:	-0.802	-0.946
4:	0.085	-1.217
5:	0.195	-0.439
6:	0.311	0.243
7:	0.913	0.369
8:	1.324	0.088
9:	0.409	1.215
10:	-0.321	0.702

X CENTROID: 0.115

Y CENTROID: -0.072

POA TO CENTROID: 0.136

HORZ SPREAD: 2.126

VERT SPREAD: 2.432

GROUP SPREAD: 2.477

MIN RADIUS: 0.371

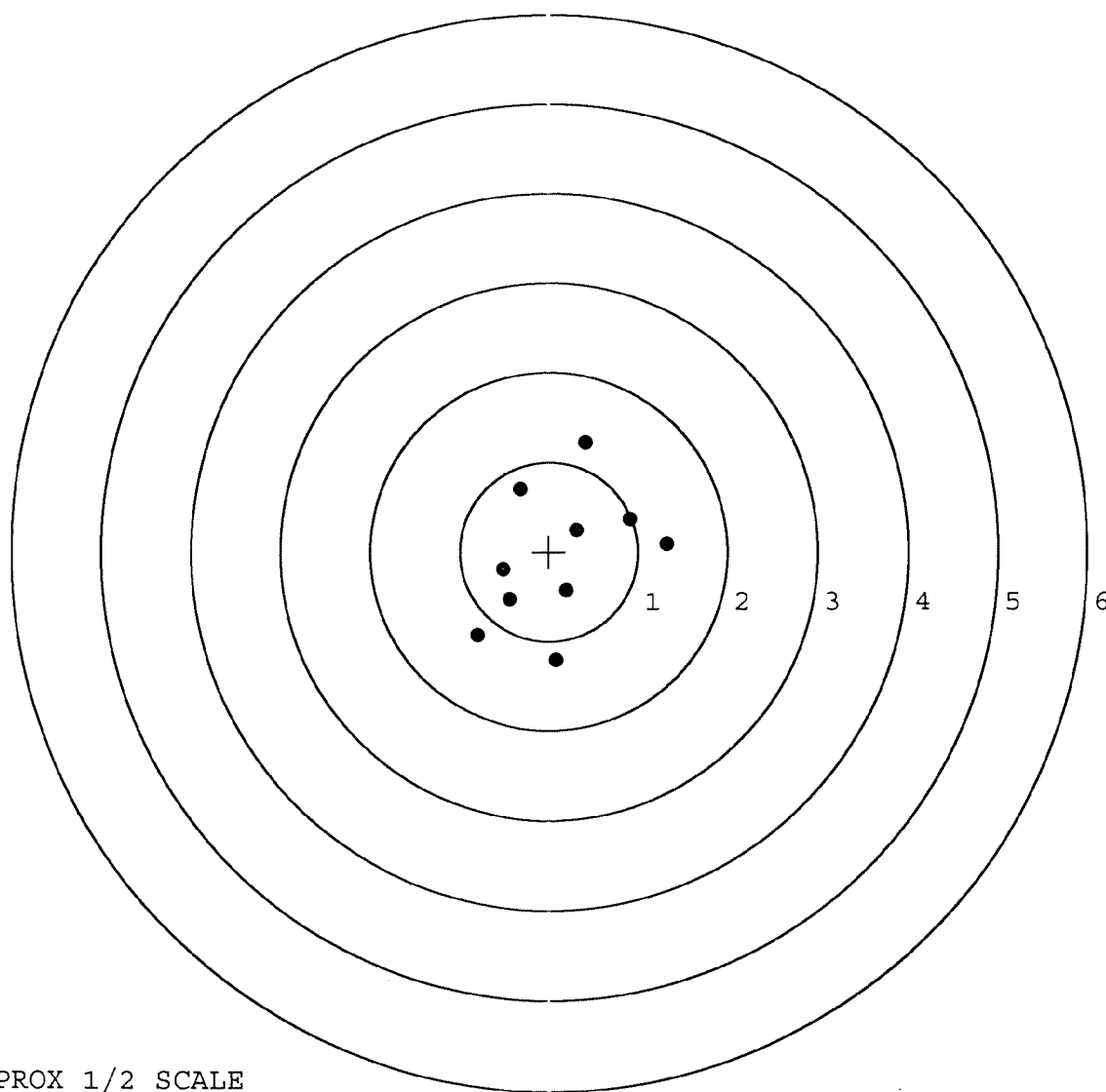
MAX RADIUS: 1.320

MEAN RADIUS: 0.887

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6522236. __0

TARGET NUMBER: 2

FILE DATE: 08/28/2008

FILE TIME: 10:20

POINT#	X	Y
1:	-0.475	-0.796
2:	-0.495	-0.188
3:	-0.187	-0.337
4:	0.042	-0.268
5:	0.274	-0.222
6:	0.655	-0.183
7:	0.259	0.188
8:	1.078	0.387
9:	-0.020	-0.280
10:	0.180	1.072

X CENTROID: 0.131

Y CENTROID: -0.063

POA TO CENTROID: 0.145

HORZ SPREAD: 1.573

VERT SPREAD: 1.868

GROUP SPREAD: 1.980

MIN RADIUS: 0.214

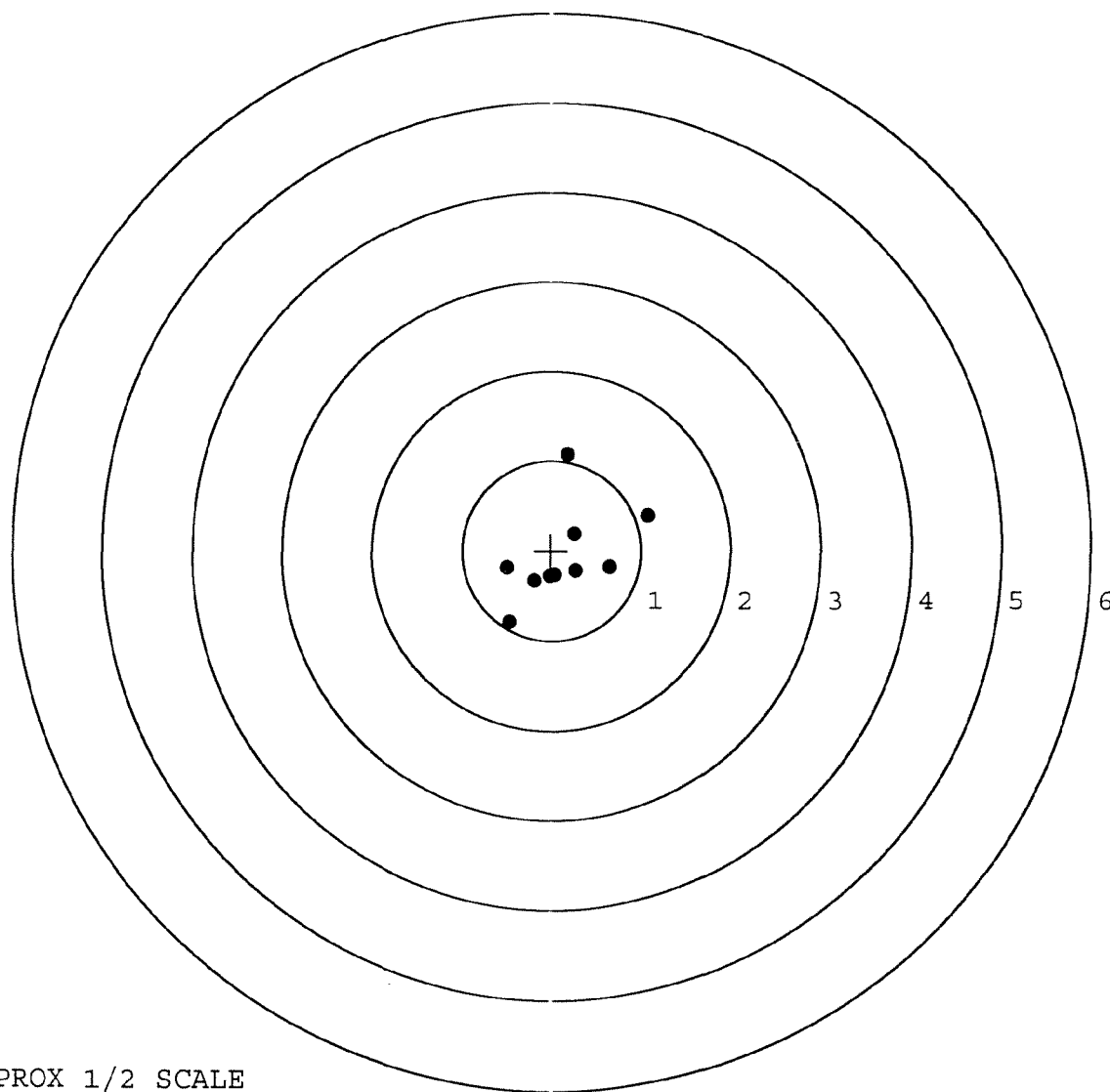
MAX RADIUS: 1.136

MEAN RADIUS: 0.572

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6522236. __0

TARGET NUMBER: 3

FILE DATE: 08/28/2008

FILE TIME: 10:20

POINT#	X	Y
1:	0.005	0.000
2:	-0.708	-0.745
3:	-0.040	-0.510
4:	-0.388	-0.238
5:	0.049	-0.196
6:	0.304	-0.129
7:	0.315	-0.017
8:	0.493	0.210
9:	0.165	0.236
10:	-0.516	0.382

X CENTROID: -0.032

Y CENTROID: -0.101

POA TO CENTROID: 0.106

HORZ SPREAD: 1.201

VERT SPREAD: 1.127

GROUP SPREAD: 1.534

MIN RADIUS: 0.107

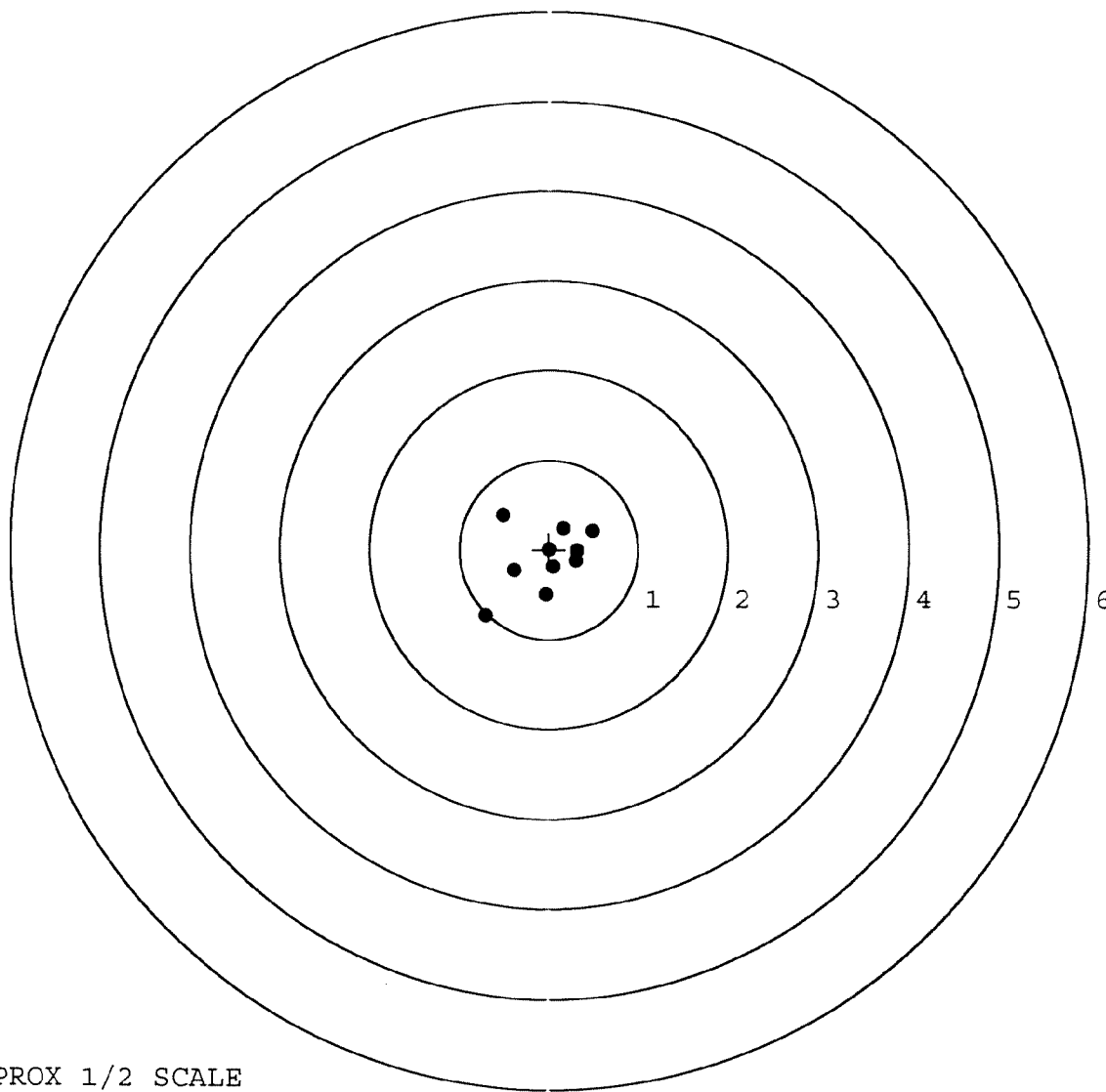
MAX RADIUS: 0.934

MEAN RADIUS: 0.434

IN 1 IN DIAMETER: 7

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6522236. __0

TARGET NUMBER: 4

FILE DATE: 08/28/2008

FILE TIME: 10:20

POINT#	X	Y
1:	-0.709	-0.491
2:	-0.621	-0.939
3:	-0.080	-0.476
4:	-0.115	-0.260
5:	0.336	-0.082
6:	0.467	-0.018
7:	0.530	0.316
8:	0.017	0.448
9:	-0.317	0.448
10:	-0.153	-0.288

X CENTROID: -0.064

Y CENTROID: -0.134

POA TO CENTROID: 0.149

HORZ SPREAD: 1.239

VERT SPREAD: 1.387

GROUP SPREAD: 1.703

MIN RADIUS: 0.136

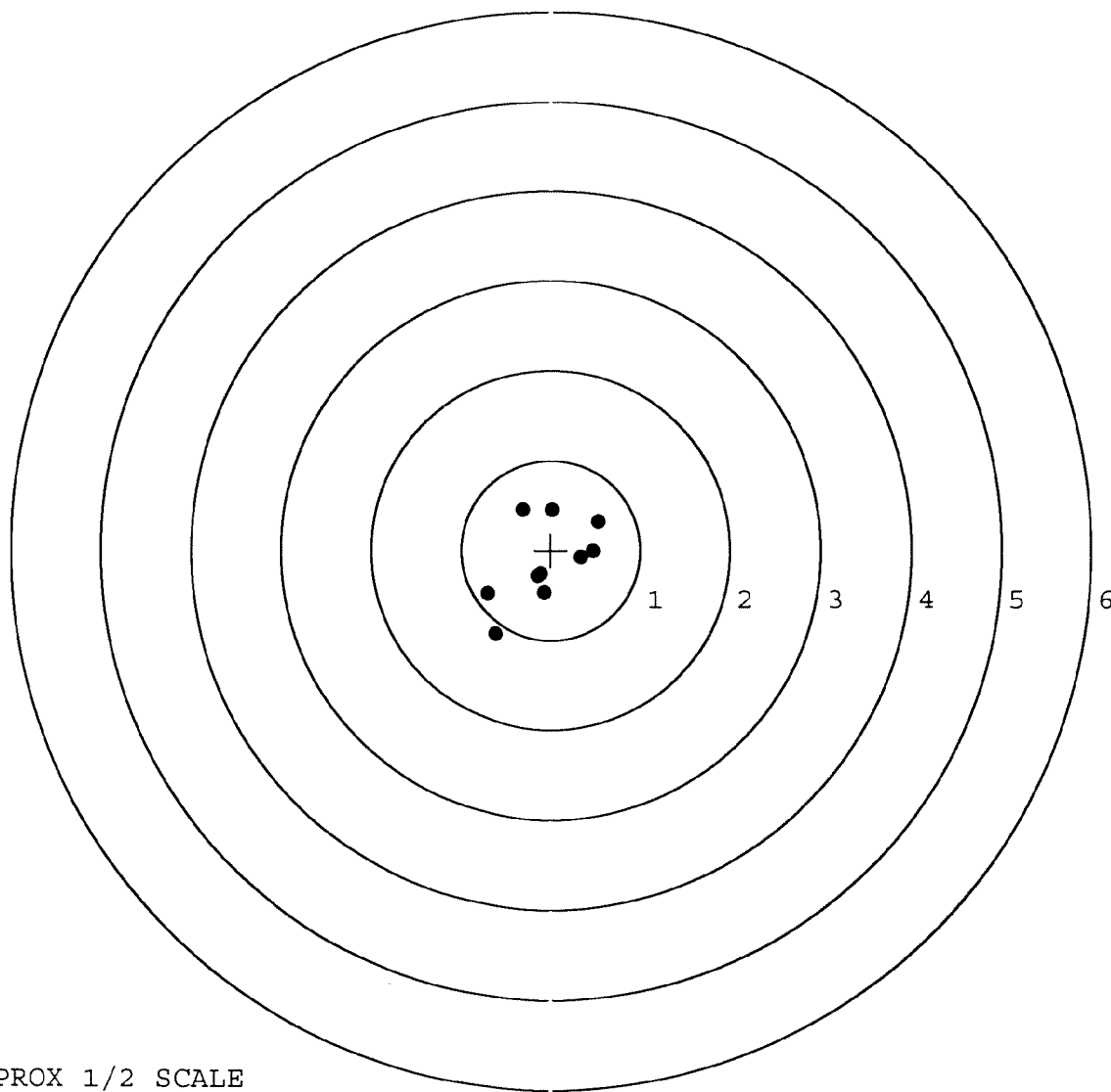
MAX RADIUS: 0.978

MEAN RADIUS: 0.529

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6522236. __0

TARGET NUMBER: 5

FILE DATE: 08/28/2008

FILE TIME: 10:20

POINT#	X	Y
1:	-0.300	-0.557
2:	-0.201	-0.408
3:	-0.144	-0.274
4:	1.058	-0.029
5:	0.852	0.038
6:	0.256	0.029
7:	0.222	0.253
8:	0.187	0.354
9:	-0.205	0.399
10:	-0.405	-1.253

X CENTROID: 0.132

Y CENTROID: -0.145

POA TO CENTROID: 0.196

HORZ SPREAD: 1.463

VERT SPREAD: 1.652

GROUP SPREAD: 1.907

MIN RADIUS: 0.214

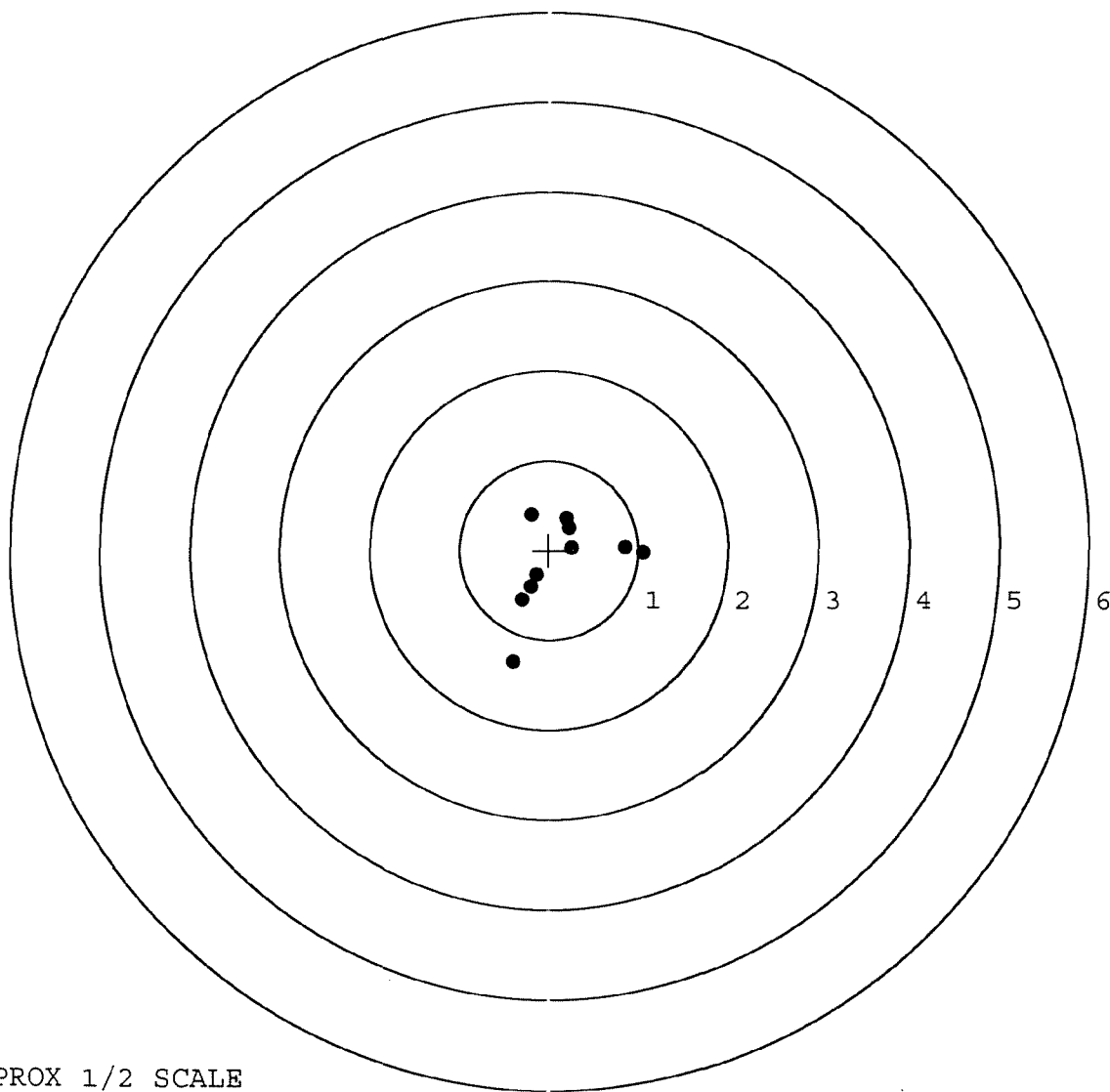
MAX RADIUS: 1.231

MEAN RADIUS: 0.600

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE




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

MODEL 700TM M24

SERIAL NO. C6522236

ORDER NO. 5716

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

UPC

0 47700 25716 7

5716 C6522236

0 47700 25716 7

CAD-767

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C 6522236

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		8/20/90	DB
600	Proof		8/20/90	DB
607	Check Headspace		8/20/90	DB
610	Dis-assemble Gun		8/20/90	DB
612	Magnaflux Barrel Action		8/23/90	KCD
	Magnaflux Bolt	8/22 New BM	8/21/90	KCD
615	Rollmark Caliber		8/21/90	GS
617	Drill and Tap Sight Holes		8/23/90	ESB
618	Polish Barrel RB		8/23/90	WB
620	Apply Coatings (Barrel Action)		8/20/90	JA
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		10/3/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/3/90	RW
	C) Inspect Ejector Hole for Chamfer		10/3/90	RW
	D) Oil Firing Pin Ass'y		10/3/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		10/3/90	RW

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4.5			10/4/90	RW
	G) Safety Off Force	2.5	3	3			10/4/90	RW
	H) Trigger Pull Test & Retainability						10/3/90	RW
	I) Firing Pin Indent	.0215	.022	.0225			10/4/90	RW
	J) Assemble Stock						10/4/90	RW
	K) Assemble Swivel Studs						10/30/90	QJL
	L) Attach Front and Rear Sight Assemblies						10/4/90	RW
	M) Iron Sight Alignment						10/4/90	RW
	N) Detach Front & Rear Sights & place in numbered container						10/4/90	RW
	O) Attach Scope to Rifle						10/4/90	RW
	P) Detach & Attach Scope 20 Times						10/4/90	RW
640	Gallery Target & Test						10-8-90	DA
	A) Time						10-8-90	DA
	B) Malfunctions						10-8-90	DA
	C) Pierced Primers						10-8-90	DA
	D) Optical Clarity of Scope						10-8-90	DA
645	Inspect for Live Ammo						10-8-90	DA
655	Final Inspection							
	A) Headspace						10/30/90	QJL
	B) Trigger Pull	268	263	271	273	274	10/30/90	QJL
	C) Function						10/30/90	QJL
660	Pack						12-18-90	DA

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6522236

DATE 10/3/90

TESTER AW

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.22	2.17	2.28	268	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.36	2.30	2.19	263	
PULL #3	2.31	2.53	2.20	271	
PULL #4	2.36	2.40	2.19	273	
PULL #5	2.50	2.34	2.20	274	
TOTAL	11.75	11.74	11.06		
AVG.	2.35	2.35	2.21		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.20	3.03		
PULL #2	3.20	3.06		
PULL #3	3.16	3.05		
PULL #4	3.14	3.03		
PULL #5	3.04	3.04		
TOTAL	15.74	15.21		
AVG.	3.15	3.04		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.28	4.72		4.03
PULL #2	4.48	4.46		4.15
PULL #3	4.62	4.58		4.00
PULL #4	4.63	4.46		4.12
PULL #5	4.67	4.65		4.02
TOTAL	22.68	22.87		20.32
AVG.	4.54	4.57		4.06

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6522236
8 Oct 1996

CENTROIDAL DISTANCES

0 TO	1	.193383
1 TO	2	.156003
1 TO	3	.376294
1 TO	4	.633834
1 TO	5	.104623

$\bar{x}^2$ -----POA

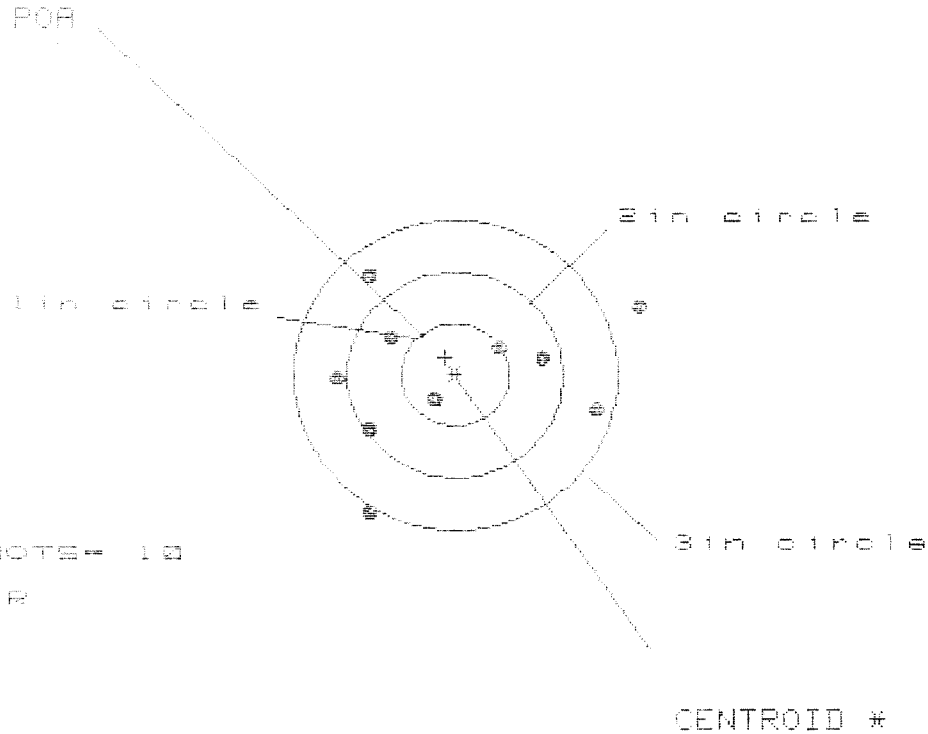
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1932
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0218
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .194426
THE AMR FOR THIS RIFLE IS: .9156

8 Oct 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C8522236

CENTERFIRE PATTERNS

1



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 5

3 in = 8

HS = 2.818

VS = 2.381

GS = 2.235

CENTROID #

PATTERN #	:	1	2	3
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.754	1.496	1.416
MINIMUM X	:	-1.064	-0.870	-0.950
MAXIMUM Y	:	.990	1.060	.905
MINIMUM Y	:	-1.310	-1.241	-1.574
CENTROID X	:	.094	-.100	-.020
CENTROID Y	:	-.169	-.238	-.083
POA TO CENTROID IN.	:	.193	.258	.085
MIN RADIUS	:	.309	.179	.341
MEAN RADIUS	:	1.044	.925	.867
MAX RADIUS	:	1.862	1.520	1.477
HORIZONTAL SPREAD	:	2.818	2.366	2.366
VERTICAL SPREAD	:	2.381	2.381	1.479
EXTREME SPREAD	:	3.235	2.487	2.487
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	5		
NUMBER IN THREE INCH CIRCLE	=	8		

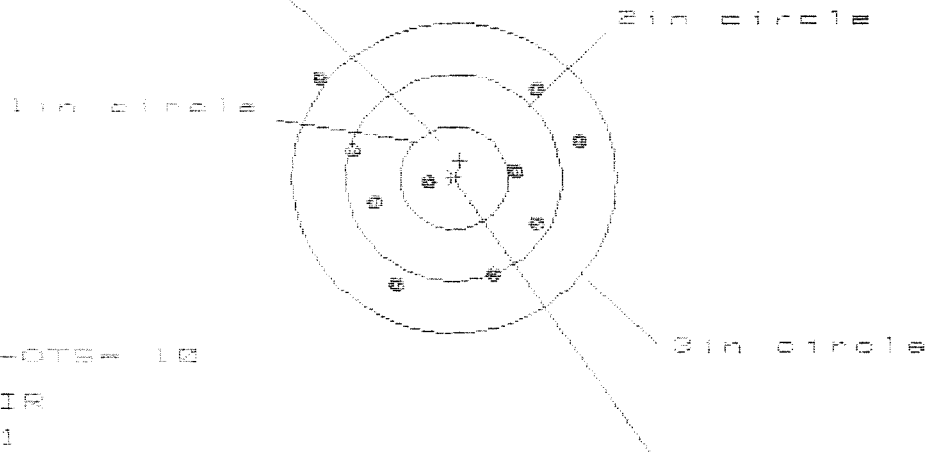
6 Oct 1998

FILE:/PATTERNING/CENTERFIRE_PATT/08582236

CENTERFIRE PATTERNS

2

POB



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 6

3 in = 9

HS= 2.272

VS= 2.614

GS= 2.471

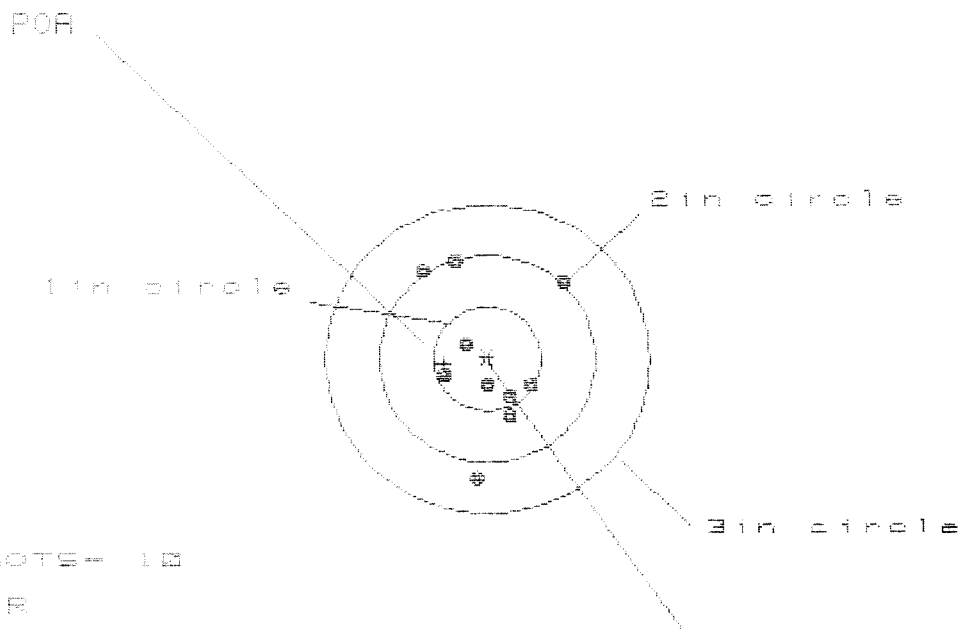
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.148	1.012	.780
MINIMUM X	-1.224	-1.033	-.906
MAXIMUM Y	.961	.998	1.055
MINIMUM Y	-1.053	-.946	-.889
CENTROID X	-.062	.074	-.053
CENTROID Y	-.168	-.275	-.332
POB TO CENTROID in.	.179	.285	.336
MIN RADIUS	.194	.345	.258
MEAN RADII	.940	.862	.821
MAX RADIUS	1.556	1.193	1.312
HORIZONTAL SPREAD	2.372	2.045	1.686
VERTICAL SPREAD	2.014	1.944	1.944
EXTREME SPREAD	2.471	2.352	2.352
NUMBER IN ONE INCH CIRCLE	=	1	
NUMBER IN TWO INCH CIRCLE	=	6	
NUMBER IN THREE INCH CIRCLE	=	9	

8 Oct 1998

FILE:/PATTERNING/CENTERFIRE_PATT/06522236

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1in = 5

2in = 7

3in = 10

IS= 1.270

VS= 2.039

GS= 2.049

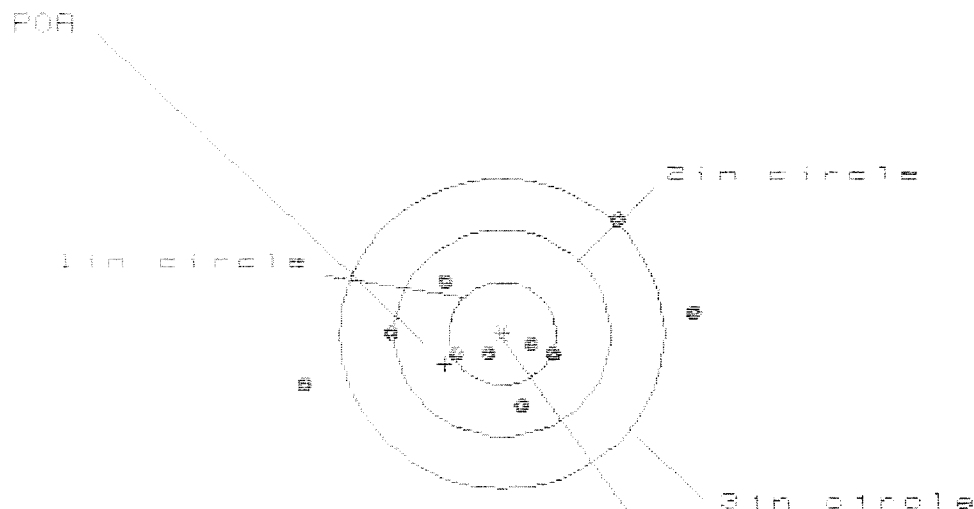
CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.658	.651	.437
MINIMUM X	:	-.612	-.619	-.538
MAXIMUM Y	:	.933	.810	.893
MINIMUM Y	:	-1.186	-.719	-.636
CENTROID X	:	.400	.407	.326
CENTROID Y	:	.050	.173	.090
POR TO CENTROID in.	:	.403	.442	.338
MIN RADIUS	:	.224	.170	.145
MEAN RADIUS	:	.646	.609	.544
MAX RADIUS	:	1.168	.931	.945
HORIZONTAL SPREAD	:	1.270	1.270	.975
VERTICAL SPREAD	:	2.039	1.529	1.529
EXTREME SPREAD	:	2.049	1.614	1.614
NUMBER IN ONE INCH CIRCLE	=		5	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

8 Oct 1998

FILE://PATTERNING/CENTERFIRE_PATT/08522236

CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1 in = 3

2 in = 5

3 in = 7

HS= 3.527

VS= 1.874

GS= 3.586

CENTROID #

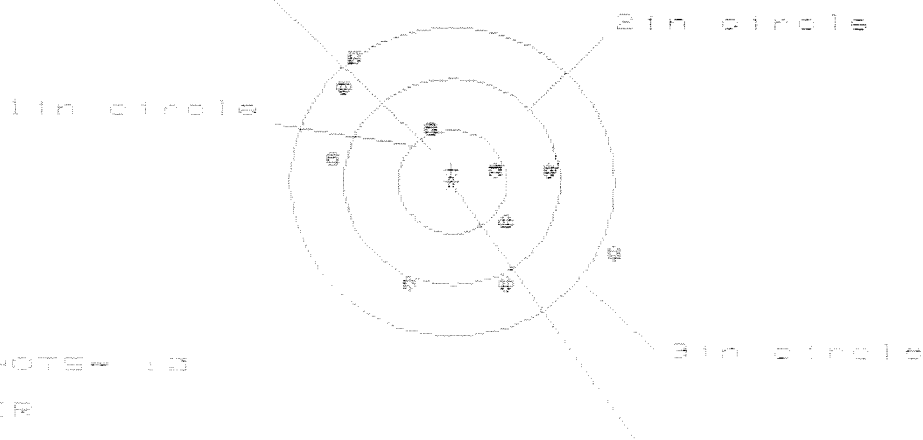
PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.725	1.527	1.109
MINIMUM X	-1.782	-1.219	-1.628
MAXIMUM Y	1.155	1.098	1.119
MINIMUM Y	-1.719	-1.776	-1.755
CENTROID X	.529	.727	.536
CENTROID Y	.292	.349	.328
FOR TO CENTROID in.	.684	.887	.629
MIN RADIUS	.223	.188	.256
MEAN RADIUS	.919	.826	.707
MAJ RADIUS	1.856	1.536	1.575
HORIZONTAL SPREAD	3.587	2.746	2.137
VERTICAL SPREAD	1.874	1.874	1.874
EXTREME SPREAD	3.586	2.752	2.405
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		7	

8 Oct 1998

FILE:/PATTERNING/CENTERFIRE_PATT/06526236

CENTERFIRE PATTERNS # 5

POB



* OF SHOTS = 13

IN CIR

1 in = 1

2 in = 4

3 in = 8

CENTROID #

1st = 2.600

2nd = 2.170

3rd = 3.110

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.506	1.035	1.937
MINIMUM X	-1.095	-0.927	-1.025
MAXIMUM Y	1.197	1.119	1.931
MINIMUM Y	-0.973	-1.051	-0.911
CENTROID X	0.605	0.163	-0.065
CENTROID Y	-0.114	0.036	-0.176
POB TO CENTROID (in)	0.114	0.167	0.187
MIN RADIUS	0.448	0.389	0.330
MEAN RADIUS	1.629	0.959	0.894
MS. RADIUS	1.064	1.366	1.354
HORIZONTAL SPREAD	2.600	1.962	1.962
VERTICAL SPREAD	2.170	2.170	1.843
EXTREME SPREAD	3.110	2.576	2.372
NUMBER IN ONE INCH CIRCLE	=	1	
NUMBER IN TWO INCH CIRCLE	=	4	
NUMBER IN THREE INCH CIRCLE	=	8	

RECEIVING AND ESTIMATING REPORT

COMMENTS

ORDER

R 94-10309

INITIAL	CUSTOMER ORDER NO.	W/10X SCOPE, M-24 SNIPER, W/DEPLOYMENT KIT			
FDC	DAAA09-92-C-0834	ATTN: FRED MARTIN			
DATE RECEIVED	DATE OPENED	DATE CODE	SERIAL NUMBER	NEW SERIAL NUMBER	MODEL AND GRADE
06/11/94	06/11/94		C6522236		700 7.62 NATO
ACCESSORIES	HARD CASE	SCOPE MNTS	SCOPE BASE		

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

CUST NO: 098397 C.I.D.L

ACCOUNT NUMBER	ACCOUNT NUMBER N/C	WRITE ☐	PROM. DATE	ESTIMATED	VIA
					FRT
GUN CONDITION					REPAIR CHARGE
☐ NEW					EXCISE
☐ LIGHTLY WORN					TAX
☐ WORN					INSURANCE
☐ VERY WORN					UPS
☐ UNREPAIRABLE					PARCEL POST
☐ MARRED					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				
✓ Barrel	643.45				
✓ Stock	471.11				
Trigger Assy	173.31				
✓ Firing Pin Assy	9.96				
✓ Mag. Follower	6.13				
✓ Mag. Spring	1.20				
CTI	50.00				
	\$1305.62				
REPAIRMAN	PROOF	CLEAN	TEST	TARGET	PATTERN
GALLERY TESTER	DATE	DATE	DATE	DATE	DATE
			1/20/96	1/20/96	

OFFICE COPY

RD6925 REV. 1/94

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

M2400002535

SWS TRIGGER PULL TEST

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

SERIAL NO. 06522236

DATE 11-8-95

TESTER DA

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#	COMMENTS
PULL #1	2.69	2.68	2.60	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.69	2.63	2.54	
PULL #3	2.72	2.56	2.53	
PULL #4	2.69	2.61	2.56	
PULL #5	2.69	2.43	2.54	
TOTAL	13.48	12.91	12.77	
AVG.	2.69	2.58	2.55	

	3.00# INITIAL	3.00# AFTER 20 CYCLES	COMMENTS
PULL #1	3.03	3.08	
PULL #2	3.03	3.14	
PULL #3	3.05	3.11	
PULL #4	3.05	3.07	
PULL #5	3.11	3.05	
TOTAL	15.27	15.45	
AVG.	3.05	3.09	

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.20	4.11		4.30
PULL #2	4.20	4.16		4.20
PULL #3	4.17	4.17		4.19
PULL #4	4.15	4.14		4.26
PULL #5	4.21	4.12		4.18
TOTAL	20.93	20.70		21.13
AVG.	4.18	4.14		4.22

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6522236

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	6 1/2	6 1/2	6 1/2			1/25/96	WB
	G) Safety Off Force	3	2 1/2	2 1/2			1/25/96	WB
	H) Trigger Pull Test & Retainability							
	I) Firing Pin Indent	.0245	.023	.023			1/25/96	WB
	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						1/22/96	WB
	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	2.39	2.38	2.37	2.36	2.33	1/25/96	WB
	C) Function							
660	Pack							

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06522236
1 Jan 1988

CENTROIDAL DISTANCES

0 TO 1	1.27103
1 TO 2	.750367
1 TO 3	.284965
1 TO 4	.513936
1 TO 5	.535374

3
2
+ <----PDR

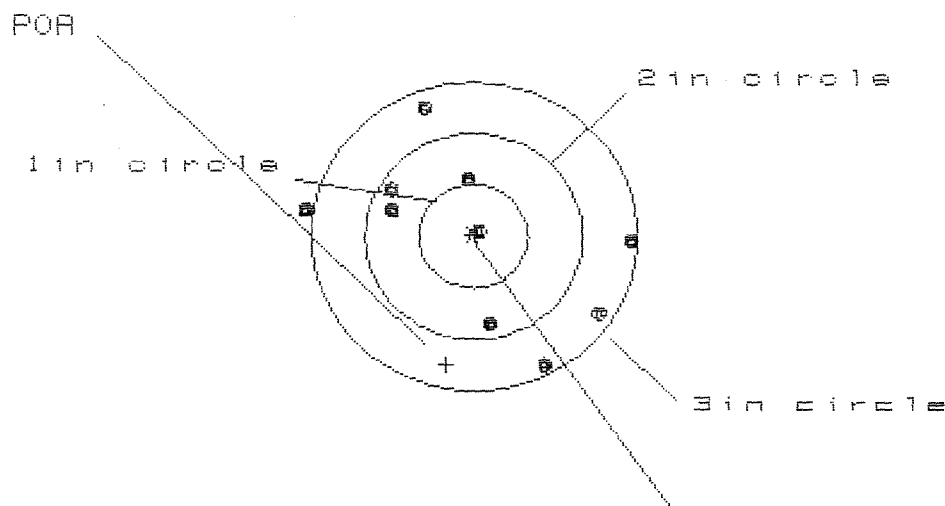
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0192
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .9878
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .987987
THE AMP FOR THIS RIFLE IS: .9742

1 Jan 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C6522236

CENTERFIRE PATTERNS

1



OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 9

HE = 2.046

VS = 2.476

CS = 3.058

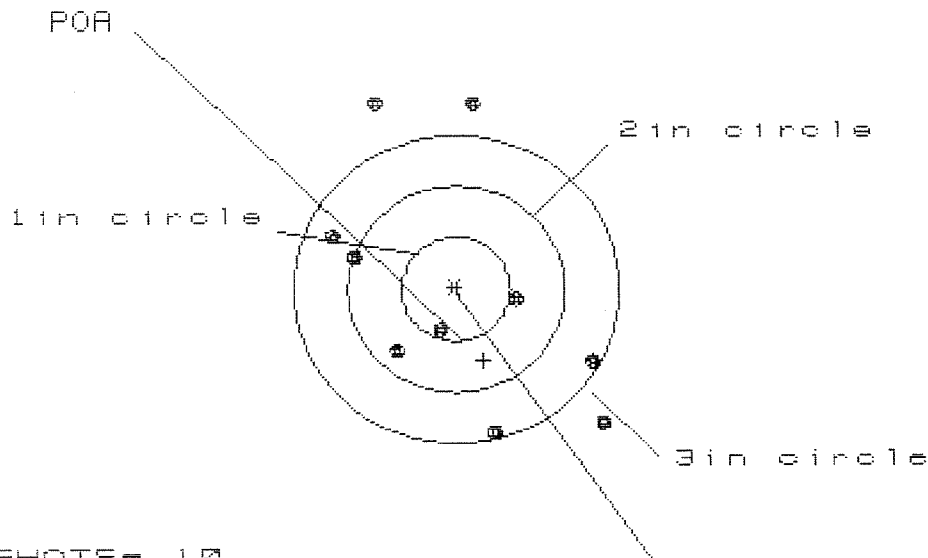
CENTROID *

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.479	1.304	1.165
MINIMUM X	:	-1.567	-.917	-.754
MAXIMUM Y	:	1.268	1.296	1.299
MINIMUM Y	:	-1.208	-1.180	-1.177
CENTROID X	:	.251	.426	.263
CENTROID Y	:	1.246	1.218	1.215
POA TO CENTROID in.	:	1.271	1.290	1.243
MIN RADIUS	:	.082	.184	.111
MEAN RADIUS	:	1.040	.993	.923
MAX RADIUS	:	1.588	1.444	1.385
HORIZONTAL SPREAD	:	3.046	2.221	1.918
VERTICAL SPREAD	:	2.476	2.476	2.476
EXTREME SPREAD	:	3.058	2.732	2.732
NUMBER IN ONE INCH CIRCLE =			1	
NUMBER IN TWO INCH CIRCLE =			5	
NUMBER IN THREE INCH CIRCLE =			9	

1 Jan 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C8522236

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 1

2in = 3

3in = 7

HS= 2.532

VS= 3.263

GS= 3.683

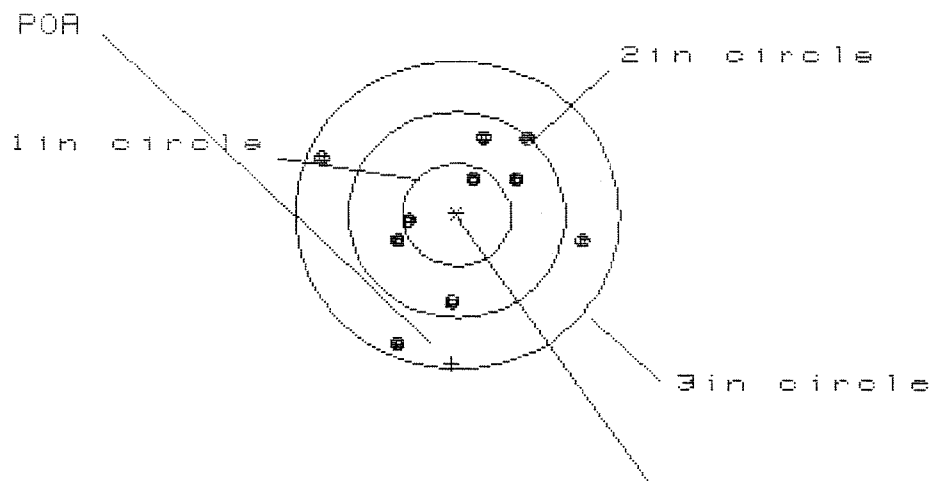
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.342	1.263	1.301
MINIMUM X	:	-1.190	-1.269	-1.111
MAXIMUM Y	:	1.824	2.024	1.892
MINIMUM Y	:	-1.439	-1.239	-1.371
CENTROID X	:	-.254	-.175	-.333
CENTROID Y	:	.691	.491	.623
POA TO CENTROID in.	:	.736	.521	.706
MIN RADIUS	:	.420	.308	.330
MEAN RADIUS	:	1.262	1.153	1.089
MAX RADIUS	:	1.938	2.025	1.906
HORIZONTAL SPREAD	:	2.532	2.532	2.412
VERTICAL SPREAD	:	3.263	3.263	3.263
EXTREME SPREAD	:	3.683	3.301	3.269
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		7	

1 Jan 1900

FILE:/PATTERNING/CENTERFIRE_PATT/C8522236

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

CENTROID #

IN CIR

1in = 2

2in = 7

3in = 10

HS= 2.433

VS= 1.987

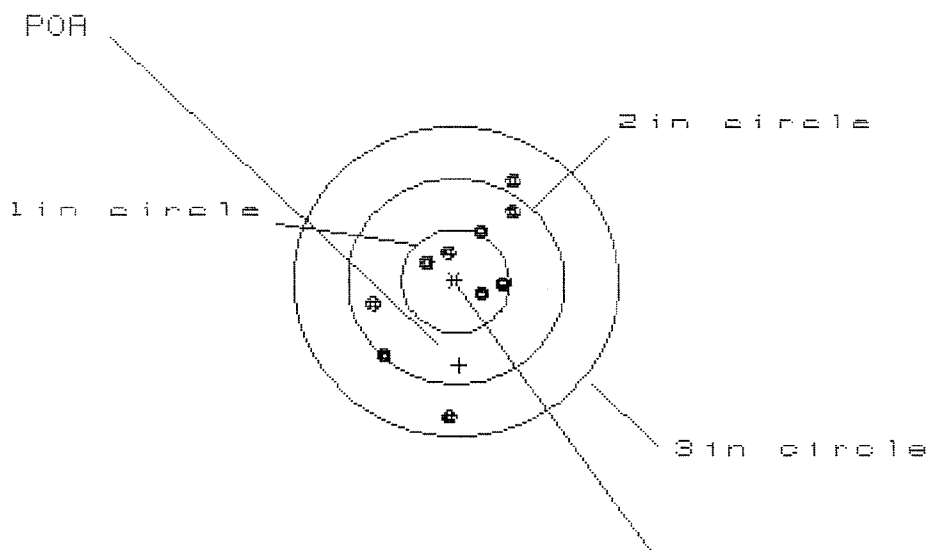
GS= 2.567

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.200	1.136	.974
MINIMUM X	:	-1.233	-1.297	-.792
MAXIMUM Y	:	.731	.591	.642
MINIMUM Y	:	-1.256	-.961	-.910
CENTROID X	:	.049	.113	.276
CENTROID Y	:	1.447	1.587	1.536
POA TO CENTROID in.	:	1.448	1.591	1.561
MIN RADIUS	:	.425	.271	.307
MEAN RADIUS	:	.871	.791	.711
MAX RADIUS	:	1.382	1.359	1.039
HORIZONTAL SPREAD	:	2.433	2.433	1.766
VERTICAL SPREAD	:	1.987	1.552	1.552
EXTREME SPREAD	:	2.567	2.567	1.766
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

1 Jan 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C6522236

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1 in = 4

2 in = 8

3 in = 10

HS= 1.244

VS= 2.296

GS= 2.358

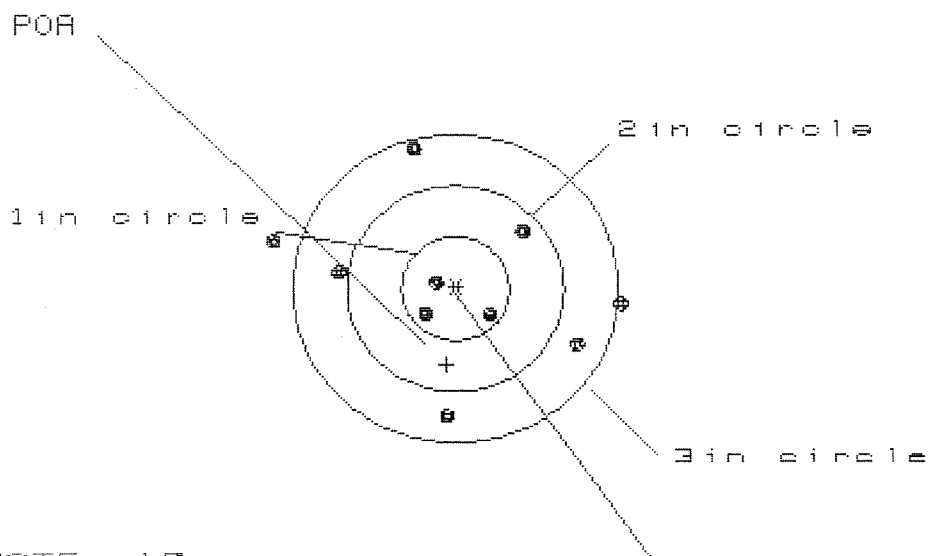
CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.523	.517	.576
MINIMUM X	:	-.721	-.727	-.668
MAXIMUM Y	:	.946	.796	.584
MINIMUM Y	:	-1.350	-.864	-.765
CENTROID X	:	-.032	-.026	-.085
CENTROID Y	:	.817	.967	.868
POA TO CENTROID in.	:	.818	.967	.872
MIN RADIUS	:	.237	.121	.185
MEAN RADIUS	:	.681	.581	.543
MAX RADIUS	:	1.351	1.110	.996
HORIZONTAL SPREAD	:	1.244	1.244	1.244
VERTICAL SPREAD	:	2.296	1.660	1.349
EXTREME SPREAD	:	2.358	2.034	1.815
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	

1 Jan 1908

FILE:/PATTERNING/CENTERFIRE_PATT/C8522236

CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1in = 3

2in = 4

3in = 8

HS= 3.257

VS= 2.615

GS= 3.318

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.546	1.356	1.101
MINIMUM X	:	-1.711	-1.227	-1.057
MAXIMUM Y	:	1.339	1.389	1.373
MINIMUM Y	:	-1.276	-1.226	-1.242
CENTROID X	:	.082	.272	.103
CENTROID Y	:	.738	.688	.704
POA TO CENTROID in.	:	.743	.740	.711
MIN RADIUS	:	.145	.278	.174
MEAN RADIUS	:	1.017	.929	.854
MAX RADIUS	:	1.770	1.516	1.441
HORIZONTAL SPREAD	:	3.257	2.583	2.158
VERTICAL SPREAD	:	2.615	2.615	2.615
EXTREME SPREAD	:	3.318	2.639	2.639
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	