

C6522230

MODEL 700™ M24

Model **SWS**™

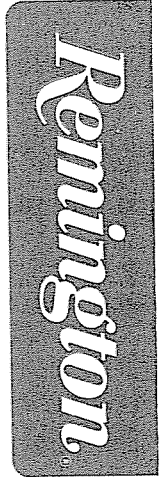
Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



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)

SERIAL NO. _____

DATE 10-25-04

TESTER TRU

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.64	2.33		2.04	
PULL #2	2.58	2.44		2.05	
PULL #3	2.45	2.43		2.01	
PULL #4	2.44	2.31		2.04	
PULL #5	2.38	2.32		2.00	
TOTAL	12.49	11.83		10.14	
AVERAGE	2.49	2.36		2.02	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.17	3.19		
PULL #2	3.23	3.13		
PULL #3	3.16	3.08		
PULL #4	3.13	3.00		
PULL #5	3.16	3.07		
TOTAL	15.85	15.47		
AVERAGE	3.17	3.09		

	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	4.28	4.20		4.11
PULL #2	4.23	4.16		4.09
PULL #3	4.24	4.11		4.06
PULL #4	4.28	4.15		4.08
PULL #5	4.26	4.15		4.05
TOTAL	21.29	20.77		20.39
AVERAGE	4.25	4.15		4.07

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6522230.___0

FILE DATE AND TIME: 11/04/2004 08:59

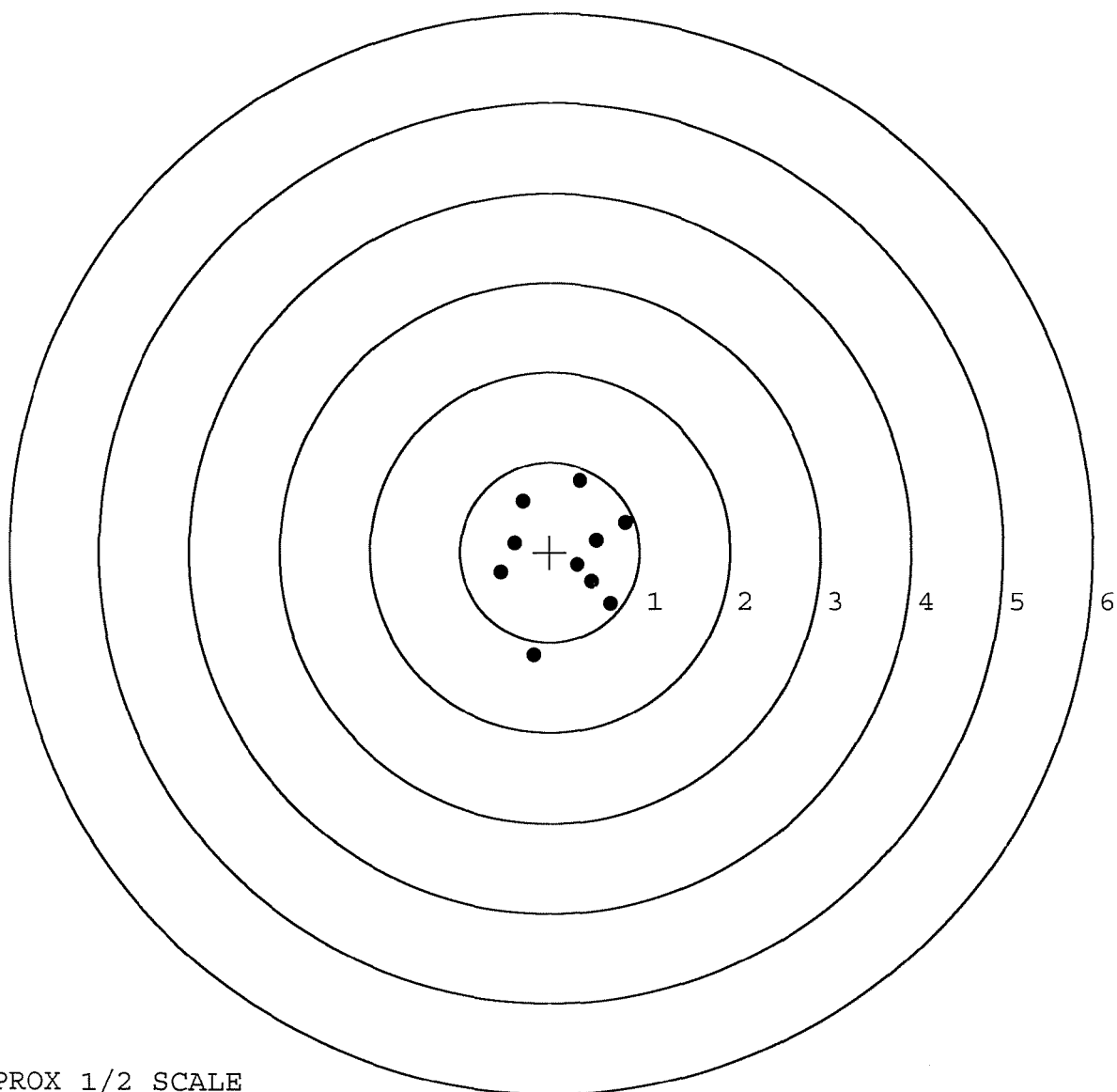
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.011
The Average Y Centroid of the Five Target Set:	-0.107
The Average Point of Impact of the Five Target Set:	0.108
The Average Mean Radius of the Five Target Set:	0.677
The Distance from POA to Centroid Target #1:	0.181
The Distance from Centroid Target #2 to Centroid Target #1:	0.328
The Distance from Centroid Target #3 to Centroid Target #1:	0.253
The Distance from Centroid Target #4 to Centroid Target #1:	0.265
The Distance from Centroid Target #5 to Centroid Target #1:	0.176

SERIAL NUMBER: C6522230. __0
TARGET NUMBER: 1
FILE DATE: 11/04/2004
FILE TIME: 08:59

POINT#	X	Y
1:	-0.176	-1.152
2:	0.677	-0.574
3:	0.473	-0.322
4:	0.310	-0.141
5:	0.521	0.137
6:	0.838	0.333
7:	0.339	0.796
8:	-0.306	0.562
9:	-0.389	0.102
10:	-0.541	-0.225

X CENTROID: 0.175
Y CENTROID: -0.048
POA TO CENTROID: 0.181
HORZ SPREAD: 1.379
VERT SPREAD: 1.948
GROUP SPREAD: 2.015
MIN RADIUS: 0.164
MAX RADIUS: 1.158
MEAN RADIUS: 0.657
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

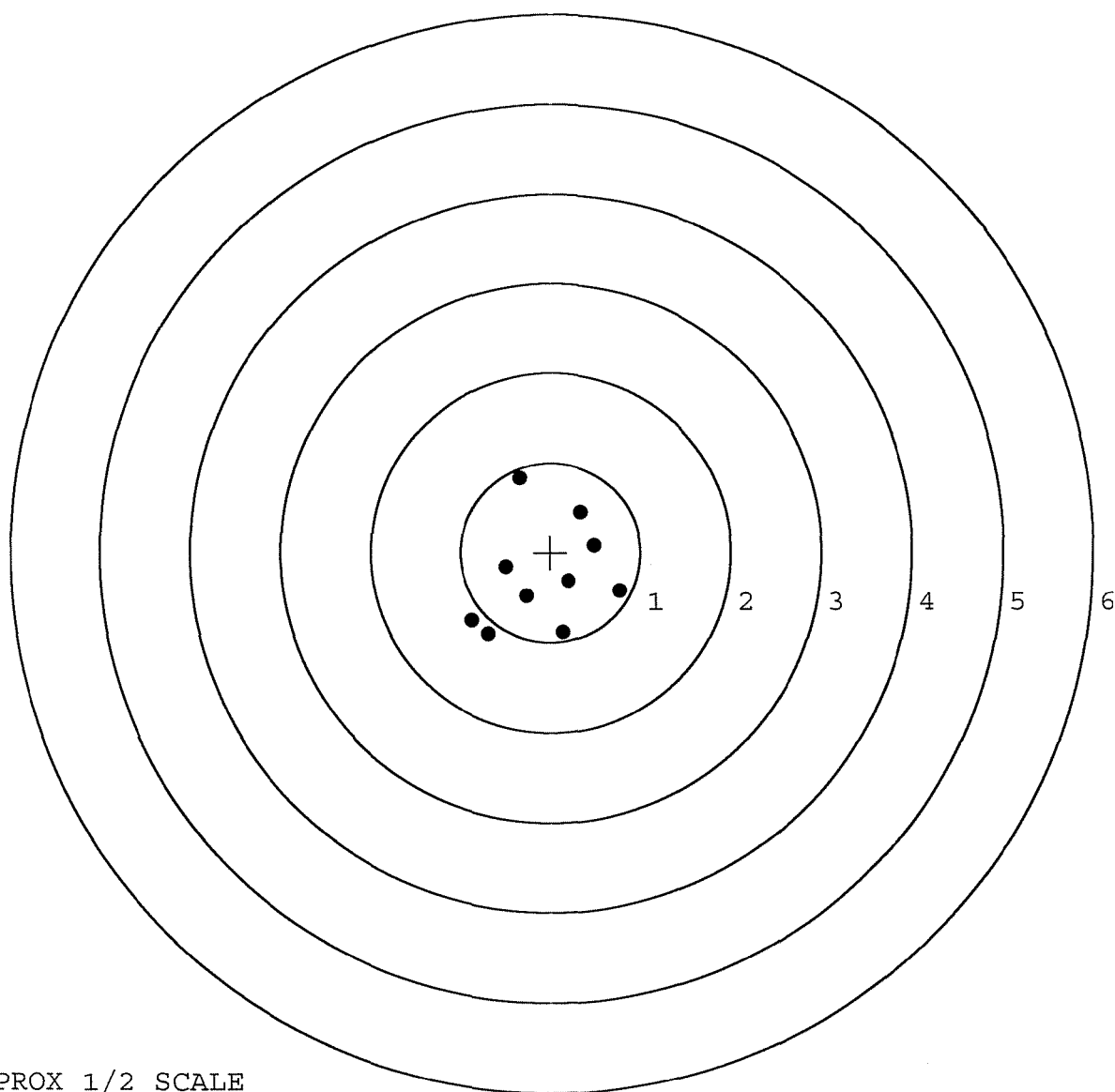


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6522230. __0
 TARGET NUMBER: 2
 FILE DATE: 11/04/2004
 FILE TIME: 08:59

X CENTROID: -0.075
 Y CENTROID: -0.262
 POA TO CENTROID: 0.272
 HORZ SPREAD: 1.645
 VERT SPREAD: 1.742
 GROUP SPREAD: 1.791
 MIN RADIUS: 0.287
 MAX RADIUS: 1.124
 MEAN RADIUS: 0.700
 # IN 1 IN DIAMETER: 3
 # IN 2 IN DIAMETER: 9
 # in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.136	-0.896
2:	0.769	-0.432
3:	0.205	-0.325
4:	0.488	0.083
5:	0.335	0.450
6:	-0.267	-0.493
7:	-0.499	-0.165
8:	-0.697	-0.912
9:	-0.876	-0.760
10:	-0.343	0.830

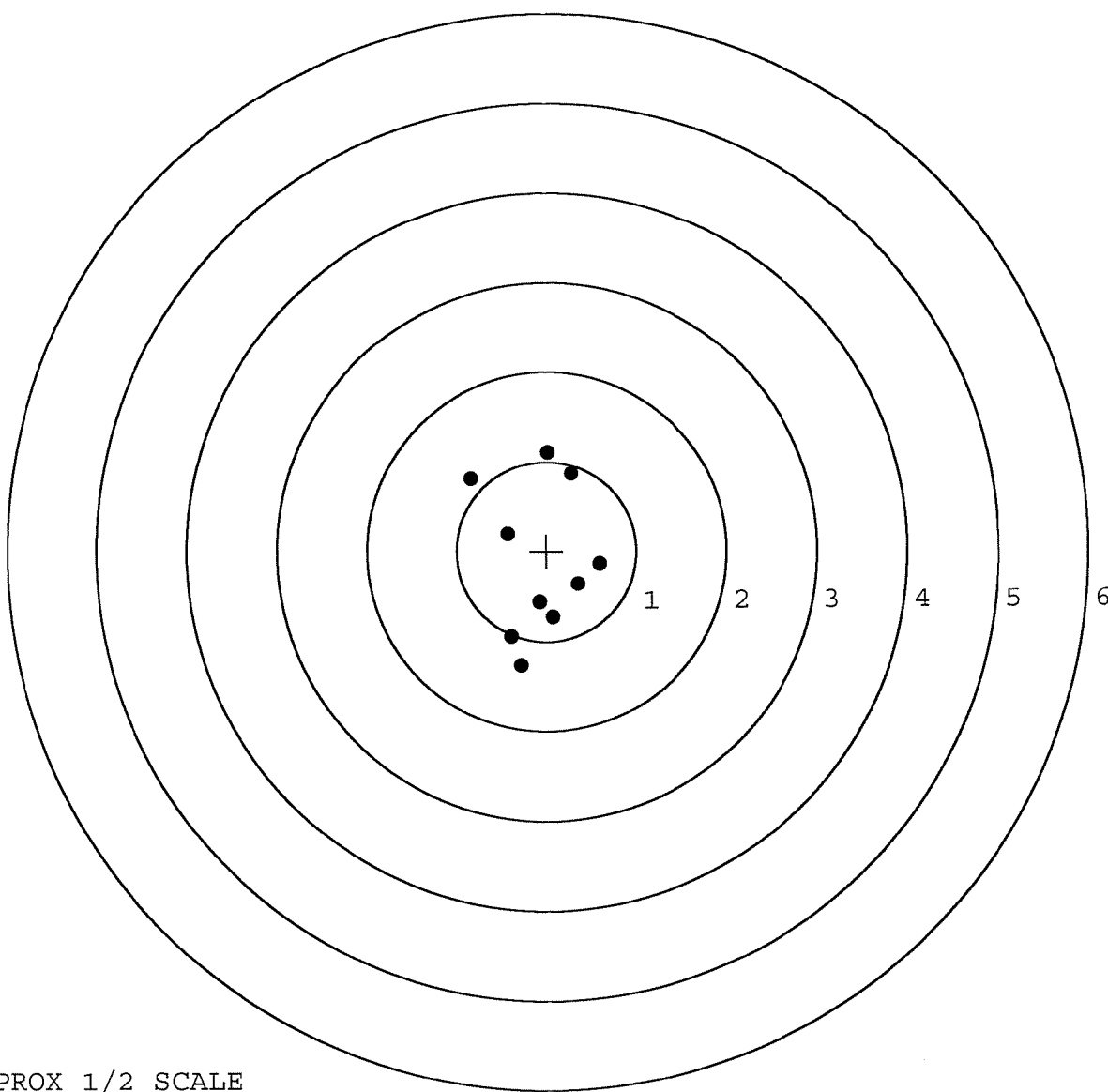


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6522230. __0
TARGET NUMBER: 3
FILE DATE: 11/04/2004
FILE TIME: 08:59

X CENTROID: -0.072
Y CENTROID: -0.108
POA TO CENTROID: 0.129
HORZ SPREAD: 1.435
VERT SPREAD: 2.368
GROUP SPREAD: 2.388
MIN RADIUS: 0.463
MAX RADIUS: 1.212
MEAN RADIUS: 0.826
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 6
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.293	-1.267
2:	-0.394	-0.949
3:	-0.084	-0.573
4:	0.360	-0.367
5:	0.596	-0.151
6:	0.281	0.861
7:	0.017	1.101
8:	-0.427	0.189
9:	-0.839	0.812
10:	0.067	-0.734



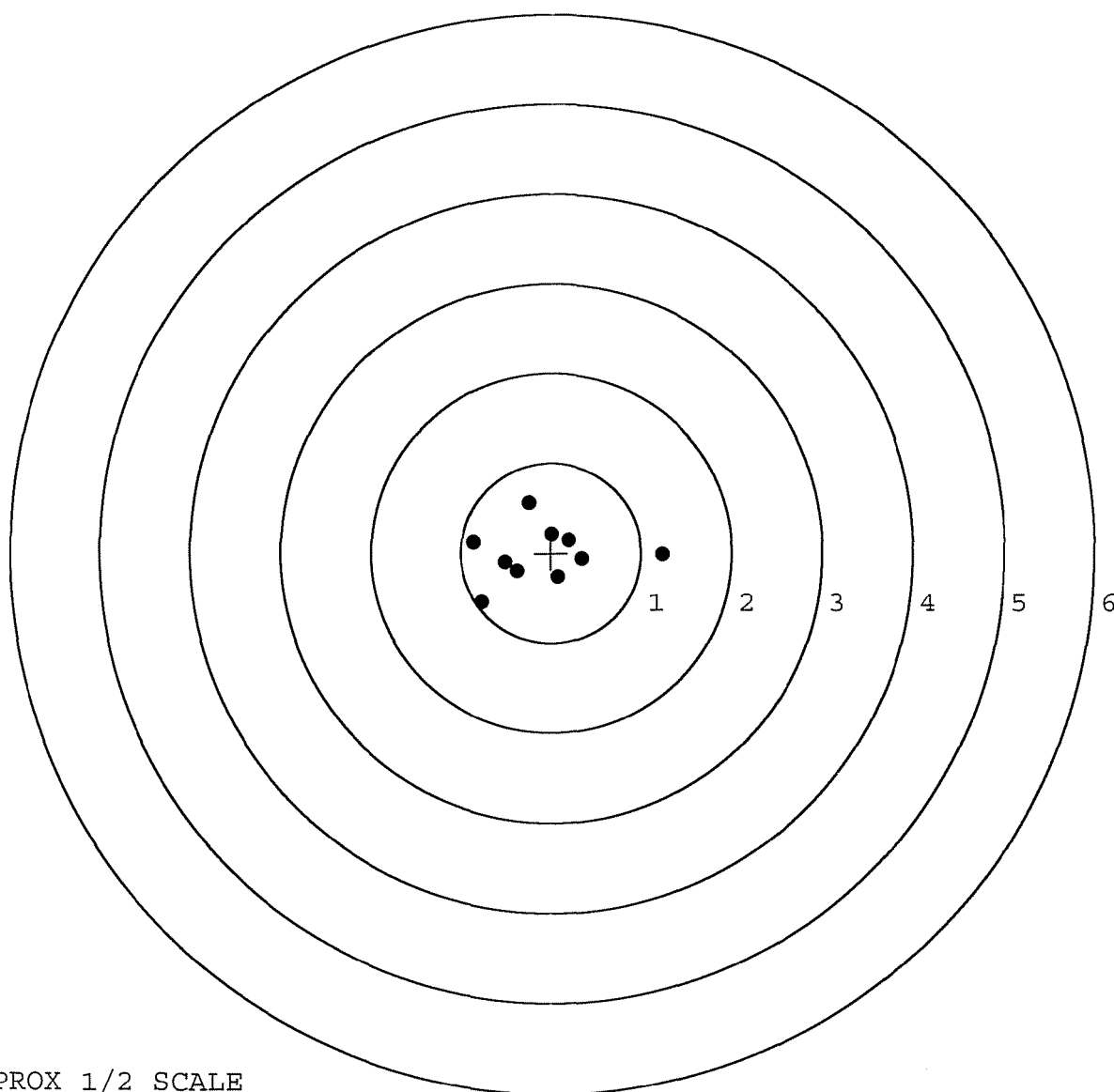
TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6522230. __0
TARGET NUMBER: 4
FILE DATE: 11/04/2004
FILE TIME: 08:59

X CENTROID: -0.088
Y CENTROID: -0.018
POA TO CENTROID: 0.090
HORZ SPREAD: 2.092
VERT SPREAD: 1.109
GROUP SPREAD: 2.097
MIN RADIUS: 0.244
MAX RADIUS: 1.324
MEAN RADIUS: 0.566

IN 1 IN DIAMETER: 6
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	1.236	-0.018
2:	-0.247	0.556
3:	-0.856	0.122
4:	-0.768	-0.553
5:	-0.511	-0.101
6:	-0.377	-0.206
7:	0.077	-0.270
8:	0.349	-0.060
9:	0.206	0.142
10:	0.007	0.207

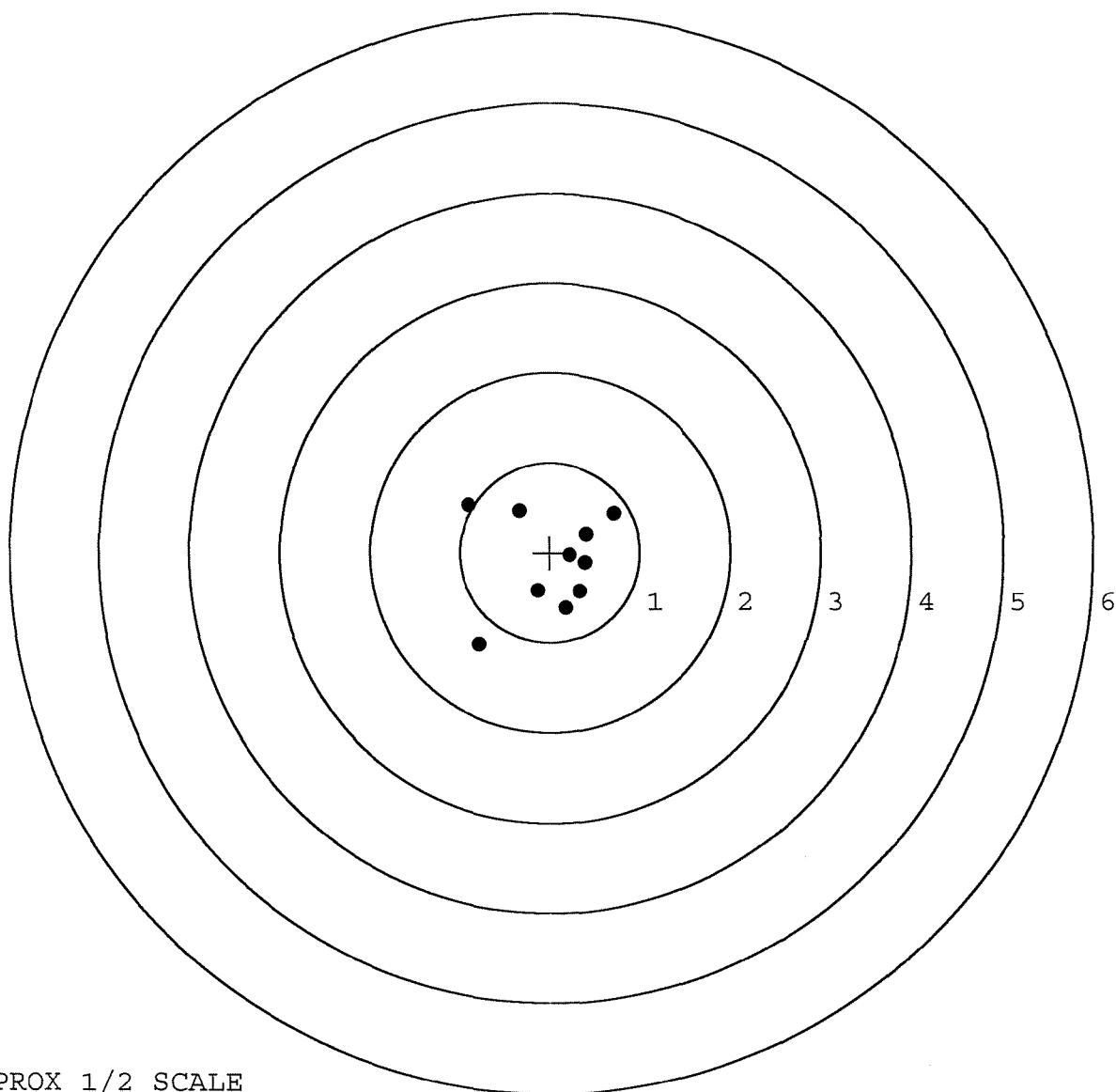


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6522230. __0
TARGET NUMBER: 5
FILE DATE: 11/04/2004
FILE TIME: 08:59

X CENTROID: 0.007
Y CENTROID: -0.101
POA TO CENTROID: 0.101
HORZ SPREAD: 1.624
VERT SPREAD: 1.553
GROUP SPREAD: 2.090
MIN RADIUS: 0.225
MAX RADIUS: 1.215
MEAN RADIUS: 0.636
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.781	-1.026
2:	-0.345	0.462
3:	-0.911	0.527
4:	0.713	0.436
5:	0.402	0.208
6:	0.220	-0.031
7:	0.395	-0.107
8:	0.334	-0.430
9:	0.174	-0.622
10:	-0.135	-0.428



TARGET APPROX 1/2 SCALE

For use of this form, see DA PAM 738-750 and 738-751; the proponent agency is DCSLOG

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DA FORM 2404, APR 79 Replaces edition of 1 Jan 64, which will be used USAPPC V1.10

M-24 INSPECTION CHECKLIST
CONTRACT #: DAAE-20-02-D-0127

R & E NUMBER	85664		
SERIAL NUMBER	C 6522230		
LOG-IN DATE	9-28-04		
INSPECT AND VERIFY:			
OPERATION #	OPERATION NAME	DATE	INITIAL
550	DIS-ASSEMBLE GUN	10-6-04	AC
560 A	RE-BARREL	10-7-04	AC
B	DRILL AND TAP	10-12-04	TRW
575	ASSEMBLE	10-8-04	RTL
600	PROOF	10-11-04	AC
605	CHECK HEADSPACE	10-12-04	RTL
610	DIS-ASSEMBLE GUN	10-12-04	RTL
612	MAGNAFLUX		
615	ROLLMARK CALIBER	10/13/04	CW
618	ROTO-BLAST	10/14/04	LB
620	APPLY COATINGS	10/25/04	HP
625 A	FINAL ASSEMBLY	10-27-04	RTL
B	TRIGGER PULL TEST		
C	SAFETY "ON" FORCE		
D	SAFETY "OFF" FORCE		
E	FIRING PIN INDENT		
640	TARGET	11-04-04	TRW
655	FINAL INSPECT	11-5-04	AC
660	PACK	11-6-04	DA
		SHIP DATE	
QAR INSPECTION DATE			




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

MODEL 700TM H24

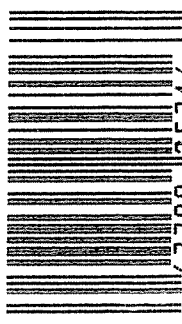
SERIAL NO.
06522230

ORDER NO.
5716

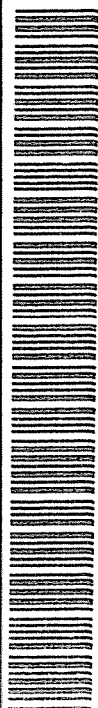
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat & Tm. Off. Marca Registrada Marque Deposee.

01

UPC



0 47700 25716 7



5716 06522230

INTERCHANGEABILITY

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6522230
17 Sep 1990

CENTROIDAL DISTANCES

0 TO	1	.162049
1 TO	2	.147411
1 TO	3	.698193
1 TO	4	.453998
1 TO	5	.498262

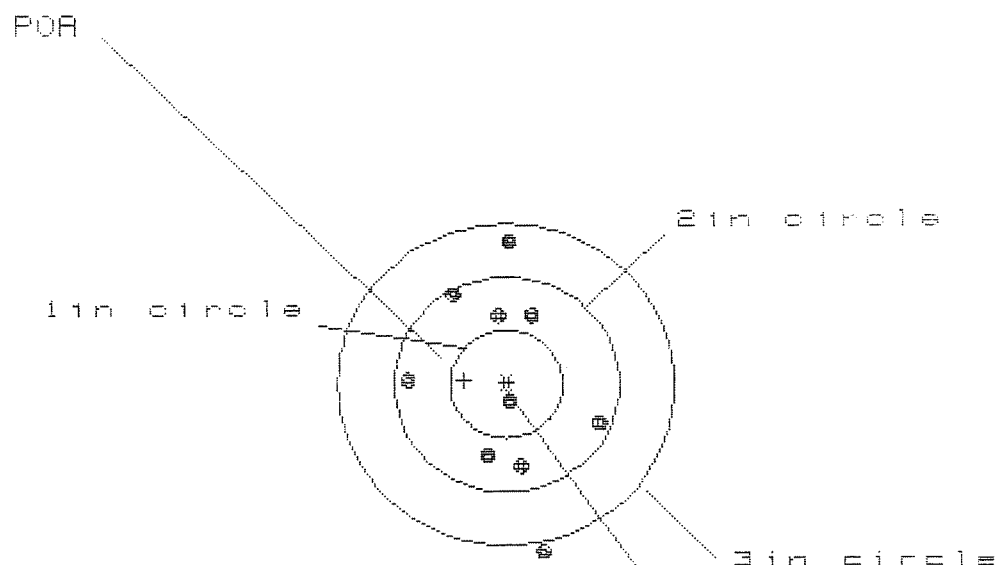
$\bar{x}$ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .207
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0052
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .207065
THE AMR FOR THIS RIFLE IS: .8292

17 Sep 1998

FILE:/PATTERNING/CENTERFIRE_PATT/ C6522230.1

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 1

2in = 8

3in = 9

HS= 1.706

VS= 2.866

GS= 2.885

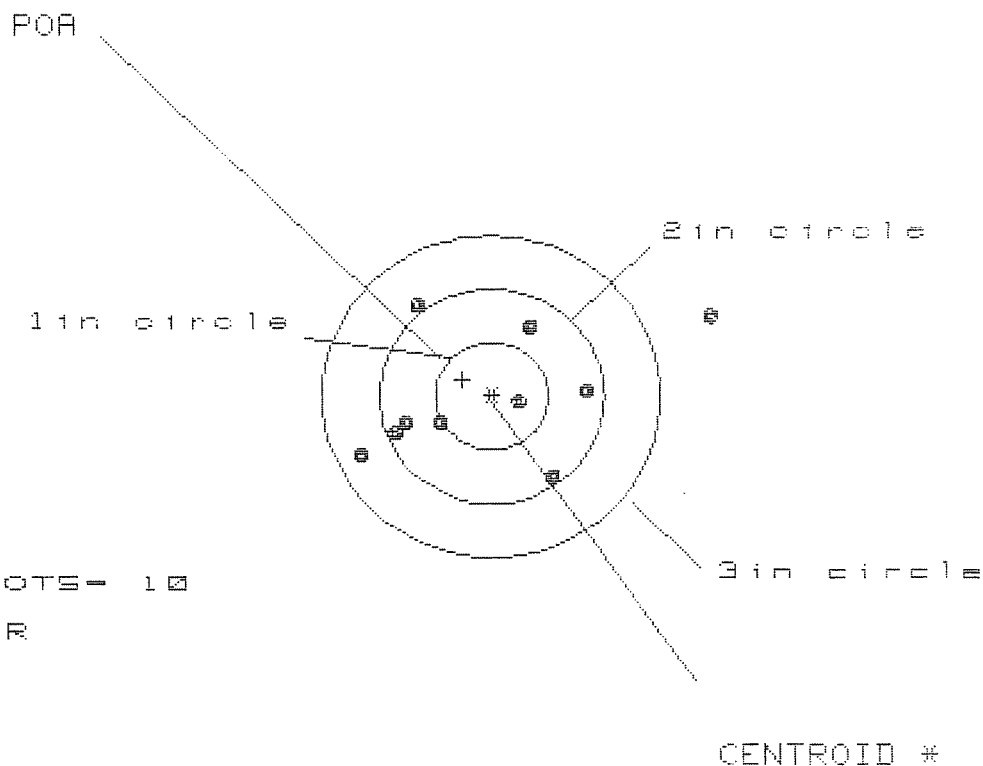
CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.820	.857	.863
MINIMUM X	:	-.887	-.849	-.843
MAXIMUM Y	:	1.318	1.146	.856
MINIMUM Y	:	-1.548	-.910	-.767
CENTROID X	:	.374	.336	.330
CENTROID Y	:	-.039	.133	-.010
PDR TO CENTROID in.	:	.375	.361	.330
MIN RADIUS	:	.135	.309	.168
MEAN RADIUS	:	.861	.775	.715
MAX RADIUS	:	1.585	1.147	.950
HORIZONTAL SPREAD	:	1.706	1.706	1.706
VERTICAL SPREAD	:	2.866	2.056	1.623
EXTREME SPREAD	:	2.885	2.059	1.773
NUMBER IN ONE INCH CIRCLE =			1	
NUMBER IN TWO INCH CIRCLE =			8	
NUMBER IN THREE INCH CIRCLE =			9	

17 Sep 1998

FILE:/PATTERNING/CENTERFIRE_PATT/ CB522230.1

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 2

2in = 7

3in = 9

HS= 3.083

VS= 1.669

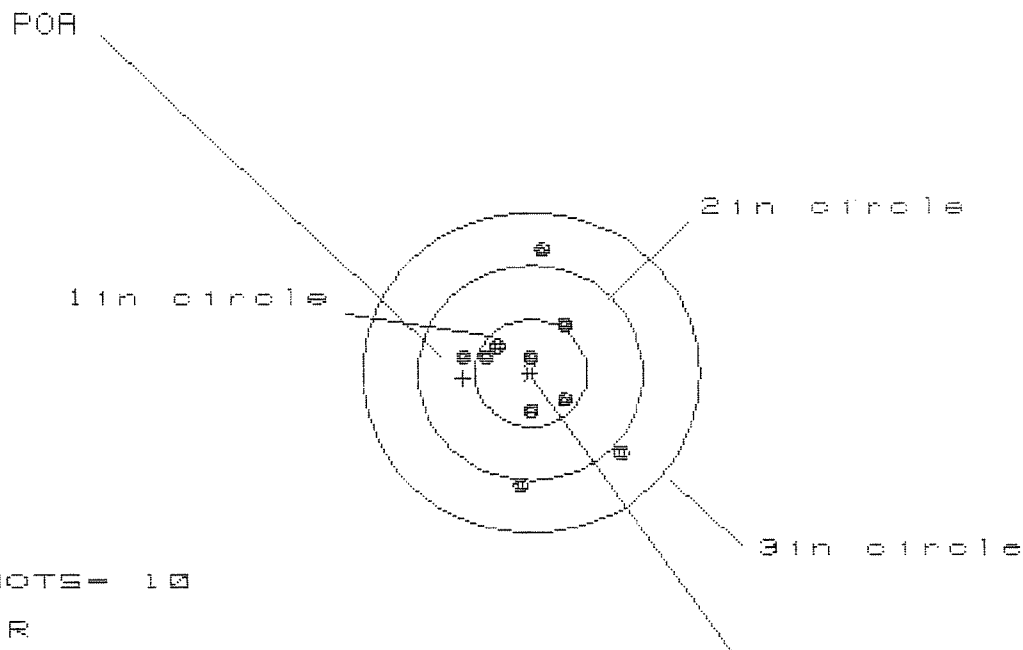
GS= 3.340

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.966	1.071	.959
MINIMUM X	:	-1.117	-.899	-.785
MAXIMUM Y	:	.877	.960	.903
MINIMUM Y	:	-.791	-.709	-.766
CENTROID X	:	.261	.043	.155
CENTROID Y	:	-.151	-.234	-.177
POA TO CENTROID in.	:	.302	.238	.235
MIN RADIUS	:	.213	.269	.313
MEAN RADIUS	:	.938	.778	.750
MAX RADIUS	:	2.102	1.076	1.062
HORIZONTAL SPREAD	:	3.083	1.970	1.744
VERTICAL SPREAD	:	1.669	1.669	1.669
EXTREME SPREAD	:	3.340	2.050	2.050
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

17 Sep 1998

FILE:/PATTERNING/CENTERFIRE_PATT/ 06522230.1

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 5

2 in = 7

3 in = 10

HS= 1.410

VS= 2.221

GS= 2.233

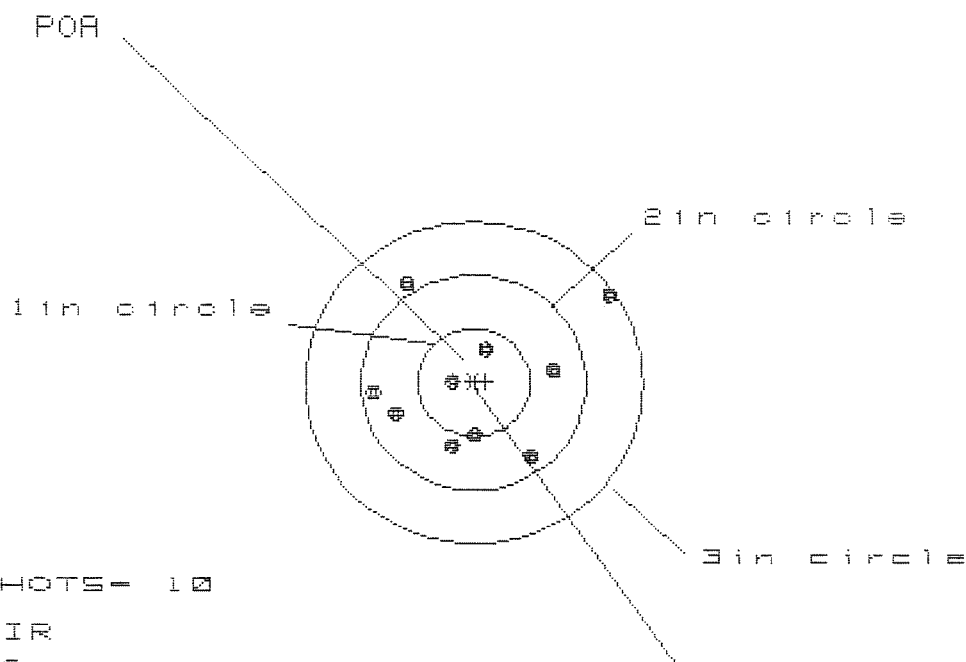
CENTROID #

PATTERN #	:	3	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.829	.842	.401
MINIMUM X	:	-.581	-.568	-.463
MAXIMUM Y	:	1.163	.597	.515
MINIMUM Y	:	-1.058	-.929	-1.011
CENTROID X	:	.599	.586	.481
CENTROID Y	:	.047	-.082	.000
POA TO CENTROID in.	:	.601	.592	.481
MIN RADIUS	:	.146	.181	.224
MEAN RADIUS	:	.623	.566	.483
MAX RADIUS	:	1.169	1.071	1.011
HORIZONTAL SPREAD	:	1.410	1.410	.864
VERTICAL SPREAD	:	2.221	1.526	1.526
EXTREME SPREAD	:	2.233	1.710	1.569
NUMBER IN ONE INCH CIRCLE =	:	5		
NUMBER IN TWO INCH CIRCLE =	:	7		
NUMBER IN THREE INCH CIRCLE =	:	10		

17 Sep 1998

FILE:/PATTERNING/CENTERFIRE_PATT/ C6522230.1

CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1in = 3

2in = 8

3in = 10

HS = 2.012

VS = 1.574

GS = 2.212

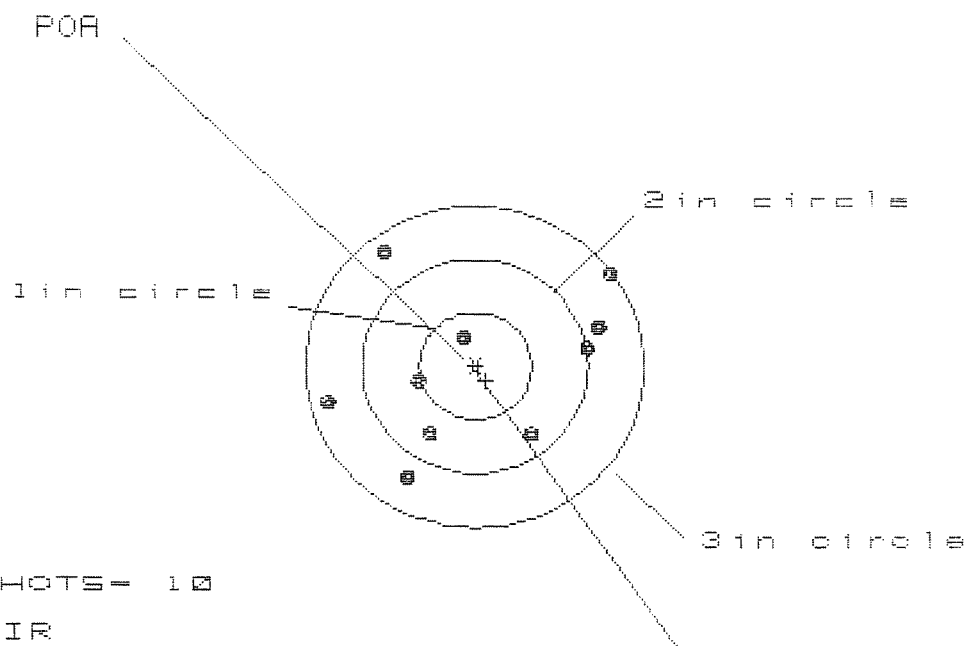
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.161	.841	.788
MINIMUM X	:	-.851	-.722	-.775
MAXIMUM Y	:	.880	.972	.568
MINIMUM Y	:	-.694	-.602	-.481
CENTROID X	:	-.105	-.234	-.181
CENTROID Y	:	-.015	-.107	-.228
POA TO CENTROID in.	:	.106	.257	.292
MIN RADIUS	:	.218	.125	.253
MEAN RADIUS	:	.737	.631	.569
MAX RADIUS	:	1.424	1.059	.858
HORIZONTAL SPREAD	:	2.012	1.563	1.563
VERTICAL SPREAD	:	1.574	1.574	1.049
EXTREME SPREAD	:	2.212	1.903	1.578
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	

17 Sep 1998

FILE:/PATTERNING/CENTERFIRE_PATT/ C8522230.1

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 4

3 in = 10

HS= 2.400

VS= 2.066

GS= 2.764

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.183	1.215	1.070
MINIMUM X	:	-1.297	-1.166	-.867
MAXIMUM Y	:	1.028	1.126	1.096
MINIMUM Y	:	-1.038	-.940	-.970
CENTROID X	:	-.094	-.225	-.080
CENTROID Y	:	.132	.034	.064
POA TO CENTROID in.	:	.162	.228	.102
MIN RADIUS	:	.325	.377	.393
MEAN RADIUS	:	.987	.910	.879
MAX RADIUS	:	1.477	1.337	1.398
HORIZONTAL SPREAD	:	2.480	2.381	1.937
VERTICAL SPREAD	:	2.066	2.066	2.066
EXTREME SPREAD	:	2.764	2.497	2.221
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		10	

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6522230
5 Sep 1990

CENTROIDAL DISTANCES

0 TO	1	.0935201
1 TO	2	.294822
1 TO	3	.235342
1 TO	4	.150013
1 TO	5	.0445982

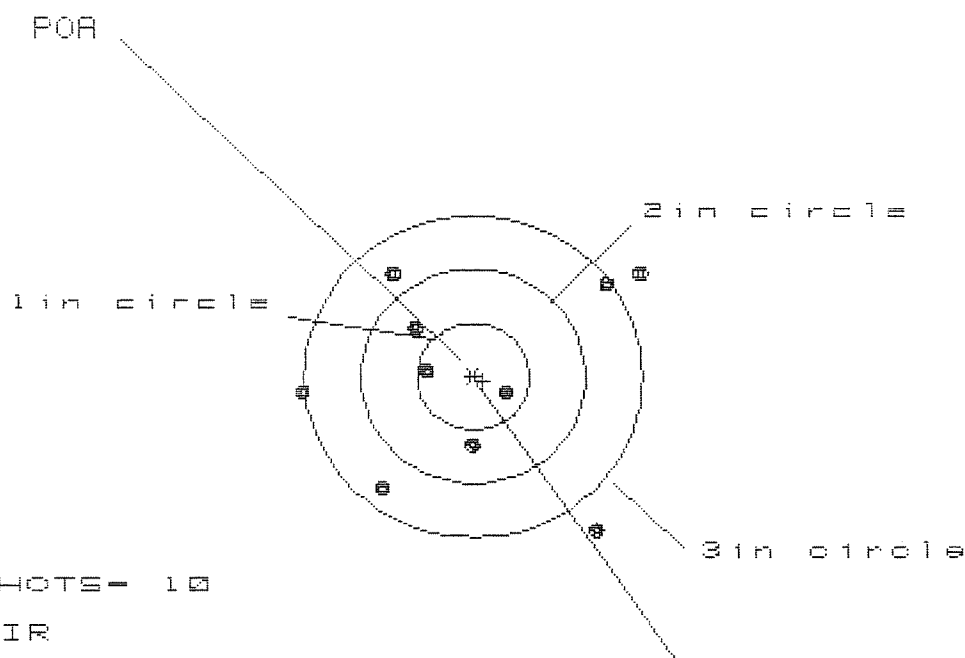
2# <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1924
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0282
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .194456
THE AMR FOR THIS RIFLE IS: .8052

5 Sep 1990

FILE:/PATTERNING/CENTERFIRE_PATT/ 06522230

CENTERFIRE PATTERNS # 1



OF SHOTS - 10

IN CIR

1 in = 2

2 in = 4

3 in = 7

HS = 3.015

VS = 2.420

GS = 3.222

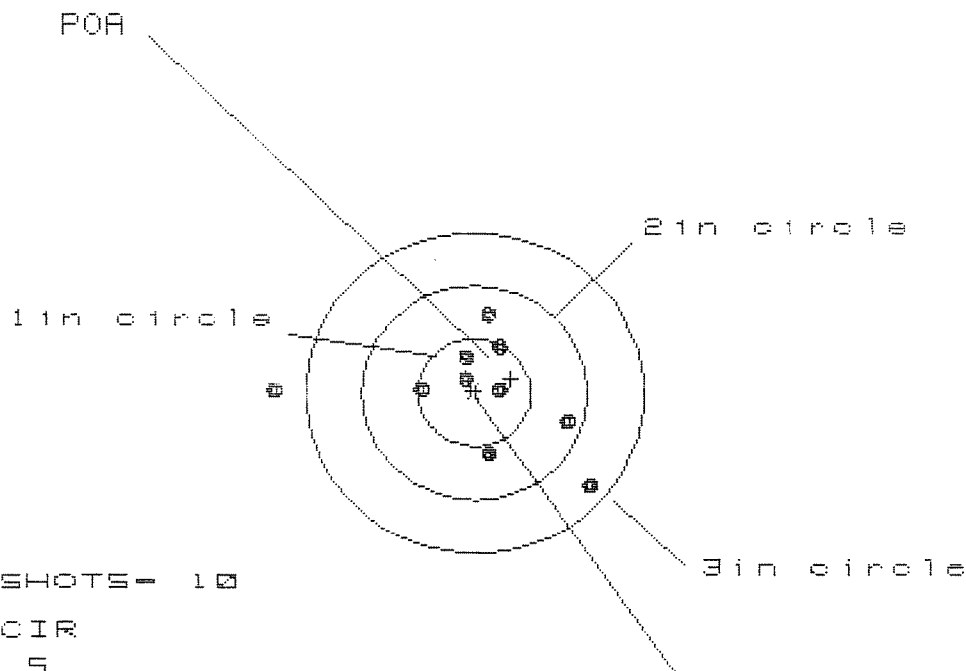
CENTROID #

PATTERN #	:	1	2	3
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.463	1.584	1.487
MINIMUM X	:	-1.552	-1.431	-1.233
MAXIMUM Y	:	.995	.836	.891
MINIMUM Y	:	-1.425	-1.154	-1.049
CENTROID X	:	-.085	-.206	-.404
CENTROID Y	:	.039	.198	.093
FOR TO CENTROID in.	:	.094	.285	.415
MIN RADIUS	:	.297	.301	.080
MEAN RADIUS	:	1.103	1.013	.868
MAX RADIUS	:	1.794	1.791	1.708
HORIZONTAL SPREAD	:	3.015	3.015	2.720
VERTICAL SPREAD	:	2.420	1.990	1.940
EXTREME SPREAD	:	3.222	3.222	2.910
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	4		
NUMBER IN THREE INCH CIRCLE	=	7		

5 Sep 1998

FILE:/PATTERNING/CENTERFIRE_PATT/ C6522230

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 5

2in = 8

3in = 9

HS= 2.726

VS= 1.609

GS= 2.867

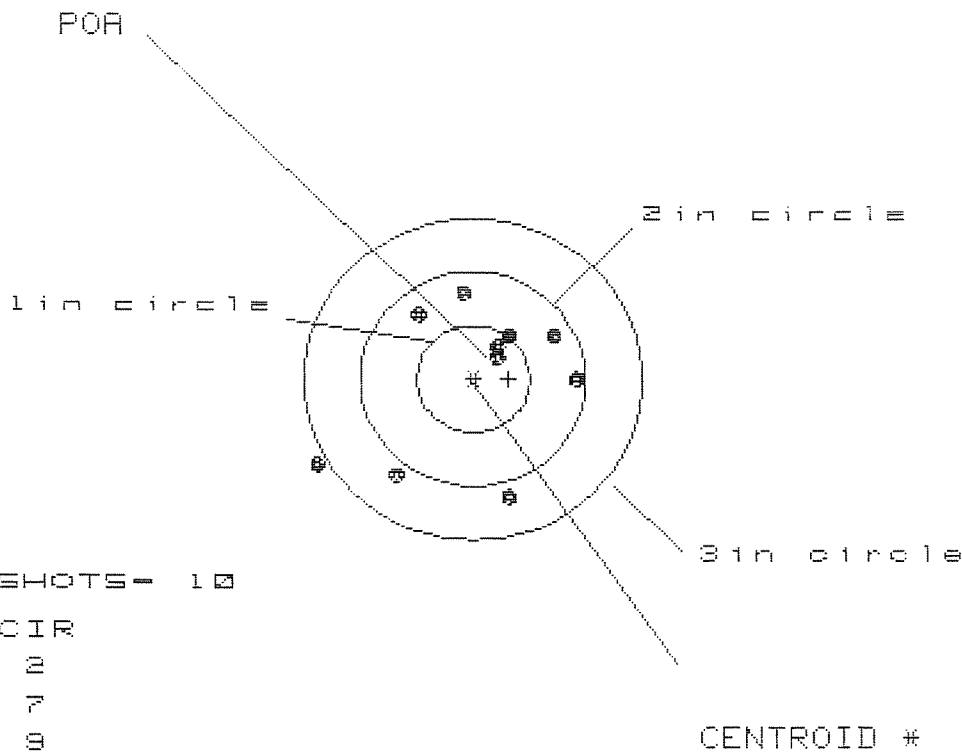
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.996	.803	.689
MINIMUM X	:	-1.730	-.685	-.584
MAXIMUM Y	:	.746	.749	.641
MINIMUM Y	:	-.863	-.860	-.698
CENTROID X	:	-.323	-.130	-.231
CENTROID Y	:	-.135	-.138	-.030
POA TO CENTROID in.	:	.350	.190	.233
MIN RADIUS	:	.179	.032	.122
MEAN RADIUS	:	.692	.567	.460
MAX RADIUS	:	1.730	1.177	.782
HORIZONTAL SPREAD	:	2.726	1.488	1.273
VERTICAL SPREAD	:	1.609	1.609	1.339
EXTREME SPREAD	:	2.867	1.827	1.339
NUMBER IN ONE INCH CIRCLE	=		5	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	

5 Sep 1990

FILE:/PATTERNING/CENTERFIRE_PATT/ C6522230

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 7

3 in = 9

HS= 2.343

VS= 1.895

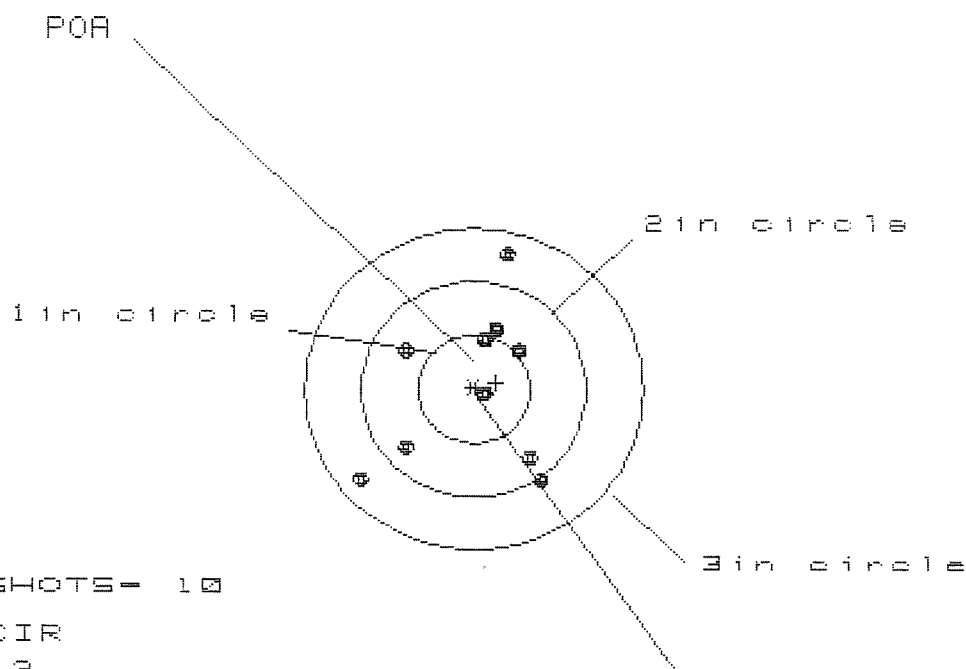
GS= 2.496

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.944	.789	.806
MINIMUM X	:	-1.399	-.841	-.824
MAXIMUM Y	:	.832	.740	.595
MINIMUM Y	:	-1.063	-1.155	-1.099
CENTROID X	:	-.316	-.161	-.178
CENTROID Y	:	-.006	.086	.231
POA TO CENTROID in.	:	.316	.182	.291
MIN RADIUS	:	.281	.115	.071
MEAN RADIUS	:	.838	.684	.577
MAX RADIUS	:	1.625	1.273	1.374
HORIZONTAL SPREAD	:	2.343	1.630	1.630
VERTICAL SPREAD	:	1.895	1.895	1.695
EXTREME SPREAD	:	2.496	1.942	1.902
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

5 Sep 1990

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CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1 in = 2

2 in = 7

3 in = 10

HS= 1.568

VS= 2.094

GS= 2.373

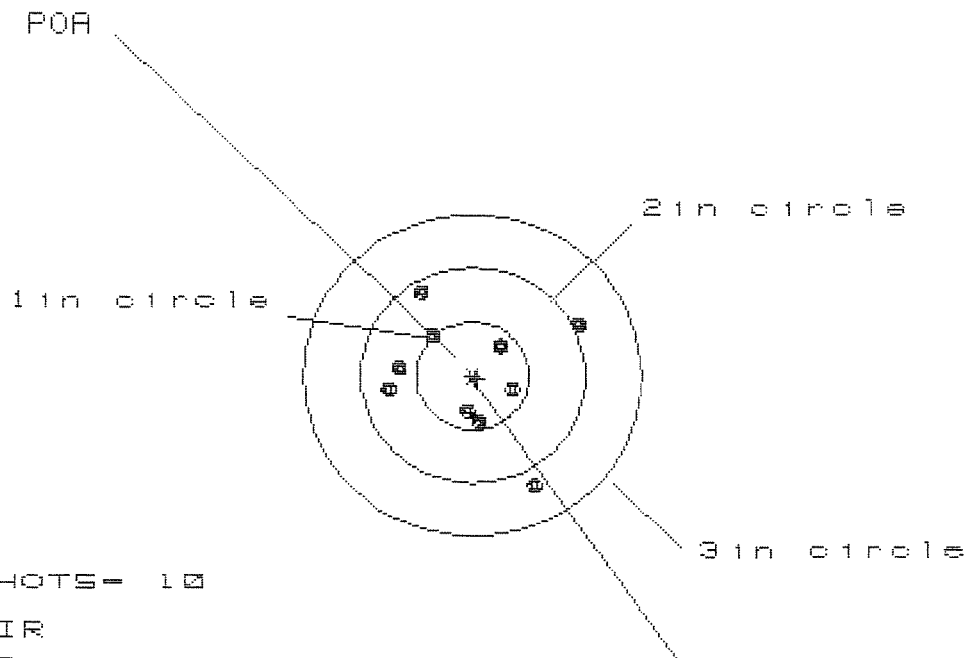
CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.601	.631	.514
MINIMUM X	:	-.967	-.937	-.715
MAXIMUM Y	:	1.227	.717	.635
MINIMUM Y	:	-.867	-.731	-.814
CENTROID X	:	-.195	-.225	-.108
CENTROID Y	:	-.063	-.199	-.117
POA TO CENTROID in.	:	.205	.300	.159
MIN RADIUS	:	.082	.113	.033
MEAN RADIUS	:	.755	.711	.624
MAX RADIUS	:	1.256	1.147	.962
HORIZONTAL SPREAD	:	1.568	1.568	1.229
VERTICAL SPREAD	:	2.094	1.448	1.448
EXTREME SPREAD	:	2.373	1.820	1.678
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1 in = 5

2 in = 8

3 in = 10

HS= 1.641

VS= 1.737

GS= 2.000

CENTROID *

PATTERN #	:	5	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.927	.989	.557
MINIMUM X	:	-.714	-.652	-.528
MAXIMUM Y	:	.737	.626	.672
MINIMUM Y	:	-1.000	-.511	-.465
CENTROID X	:	-.043	-.105	-.229
CENTROID Y	:	.024	.135	.089
POA TO CENTROID in.	:	.049	.171	.246
MIN RADIUS	:	.301	.354	.317
MEAN RADIUS	:	.638	.579	.506
MAX RADIUS	:	1.145	1.055	.717
HORIZONTAL SPREAD	:	1.641	1.641	1.085
VERTICAL SPREAD	:	1.737	1.137	1.137
EXTREME SPREAD	:	2.000	1.733	1.240
NUMBER IN ONE INCH CIRCLE	=	5		
NUMBER IN TWO INCH CIRCLE	=	8		
NUMBER IN THREE INCH CIRCLE	=	10		

SWS TRIGGER PULL TEST

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

SERIAL NO C6522230
DATE 8/28/90
TESTER JEP

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.21	2.51	2.42	2.32	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.19	2.40	2.35	2.20	
PULL #3	2.15	2.34	2.37	2.23	
PULL #4	2.49	2.37	2.30	2.29	
PULL #5	2.43	2.40	2.40	2.41	
TOTAL	11.47	12.02	11.84	11.45	
AVG.	2.294	2.404	2.368	2.29	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.21	3.23		
PULL #2	3.19	3.21		
PULL #3	3.25	3.17		
PULL #4	3.17	3.28		
PULL #5	3.23	3.15		
TOTAL	16.05	16.04		
AVG.	3.21	3.208		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.30	4.22		4.17
PULL #2	4.16	4.28		4.29
PULL #3	4.05	4.16		4.19
PULL #4	4.19	4.11		4.18
PULL #5	4.25	4.20		4.19
TOTAL	20.75	20.97		21.02
AVG.	4.15	4.194		4.204

INTERCHANGEABILITY

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6522230

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	8 2	90	RW
600	Proof	8 2	90	RW
607	Check Headspace	8 2	90	RW
610	Dis-assemble Gun	8 2	90	RW
612	Magnaflux Barrel Action		8/7/90	KR
	Magnaflux Bolt		8/7/90	KR
615	Rollmark Caliber		8/7/90	GL
617	Drill and Tap Sight Holes		8/10/90	WB
618	Polish Barrel RB		8/14/90	WB
620	Apply Coatings (Barrel Action)		8/22/90	TA
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		8/24/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/24/90	RW
	C) Inspect Ejector Hole for Chamfer		8/24/90	RW
	D) Oil Firing Pin Ass'y		8/24/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		8/27/90	GL

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			8/18/90	WB
	G) Safety Off Force	2 1/2	2 1/2	2 1/2			8/28/90	WB
	H) Trigger Pull Test & Retainability						8/28/90	JL
	I) Firing Pin Indent	022 023	022 0225	022 0225			8/18/90	WB
	J) Assemble Stock						8/29/90	RW
	K) Assemble Swivel Studs						9/6/90	JS
	L) Attach Front and Rear Sight Assemblies						8/29/90	RW
	M) Iron Sight Alignment						8/29/90	RW
	N) Detach Front & Rear Sights & place in numbered container						8/29/90	RW
	O) Attach Scope to Rifle						8/29/90	RW
	P) Detach & Attach Scope 20 Times						8/29/90	RW
640	Gallery Target & Test						9/4/90	RF
	A) Time						9/4/90	RF
	B) Malfunctions						9/4/90	RF
	C) Pierced Primers						9/4/90	RF
	D) Optical Clarity of Scope						9/4/90	RF
645	Inspect for Live Ammo						9/4/90	RF
655	Final Inspection							
	A) Headspace						9/6/90	JS
	B) Trigger Pull	2.32	2.20	2.23	2.29	2.41	9-5-90	JL
	C) Function						9/6/90	JS
660	Pack						9-18-90	JL

2.13
2.18
2.20
2.19
2.21