

C6522215

MODEL 700TM M24

Model **SWS** TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



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: **RE00107914** Serial: C6522215 Model M24 SWS Center Fire
 Verify Repair Caliber: 7.62 NATO Repairman: Status: Closed 2/6/2006 8:16:54 AM

Address Information

Customer: ☒ Received From Return To: ☐ Received From

Name: **HSC 3RD BN, 3RD SFG (A)** **HSC 3RD BN, 3RD SFG (A)**

Address 1: Address 2: PO Box: PO Box:

City: **FORT BRAGG** **FORT BRAGG**

State: **NC** Zip Code: **28310** Country: **US** State: **NC** Zip Code: **28310** Country: **US**

FFL: ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐

Contact / Condition	Problems	Estimate	History / Status	Shipping / Billing															
Contact Information Phone: NA 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>A010</td> <td>Hard Case</td> <td>1</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	A010	Hard Case	1	A017	Scope Base	1	A057	Fit and Rear Sgt Base	1
Code	Desc	Qty																	
A007	With Stud	3																	
A010	Hard Case	1																	
A017	Scope Base	1																	
A057	Fit and Rear Sgt Base	1																	

Repair Search Refresh Close

naglet 2/6/2006 8:40 AM CAPS NUM INS SCRL

start Inbox - Microsoft Out... updated turn in proce... Arms Services Repair ... 8:40 AM

Serial Number: **C6522215**

Model: **M24 SWS**



RE00107914

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

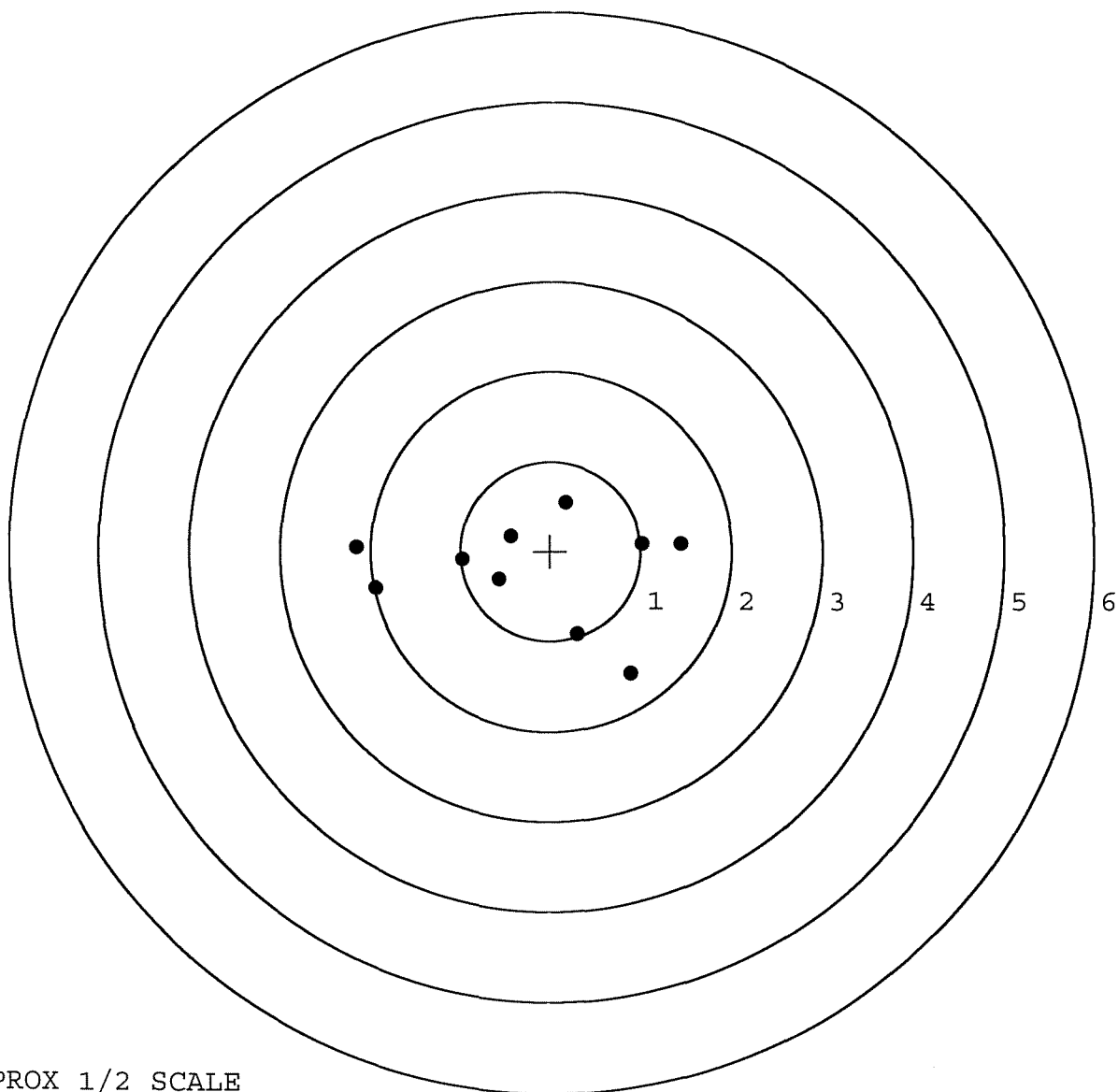
FIREARM SERIAL NUMBER / DATASET NAME: C6522215.___0
FILE DATE AND TIME: 02/15/2006 05:12

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.081
The Average Y Centroid of the Five Target Set:	-0.047
The Average Point of Impact of the Five Target Set:	0.093
The Average Mean Radius of the Five Target Set:	0.837
The Distance from POA to Centroid Target #1:	0.314
The Distance from Centroid Target #2 to Centroid Target #1:	0.195
The Distance from Centroid Target #3 to Centroid Target #1:	0.393
The Distance from Centroid Target #4 to Centroid Target #1:	0.215
The Distance from Centroid Target #5 to Centroid Target #1:	0.379

SERIAL NUMBER: C6522215. __0
 TARGET NUMBER: 1
 FILE DATE: 02/15/2006
 FILE TIME: 05:12

	POINT#	X	Y
X CENTROID:	1:	0.896	-1.358
Y CENTROID:	2:	0.309	-0.933
POA TO CENTROID:	3:	1.442	0.093
HORZ SPREAD:	4:	1.014	0.088
VERT SPREAD:	5:	0.169	0.544
GROUP SPREAD:	6:	-0.437	0.167
MIN RADIUS:	7:	-0.569	-0.318
MAX RADIUS:	8:	-0.979	-0.094
MEAN RADIUS:	9:	-1.943	-0.418
# IN 1 IN DIAMETER:	10:	-2.155	0.046
# IN 2 IN DIAMETER:			
# in 3 IN DIAMETER:			

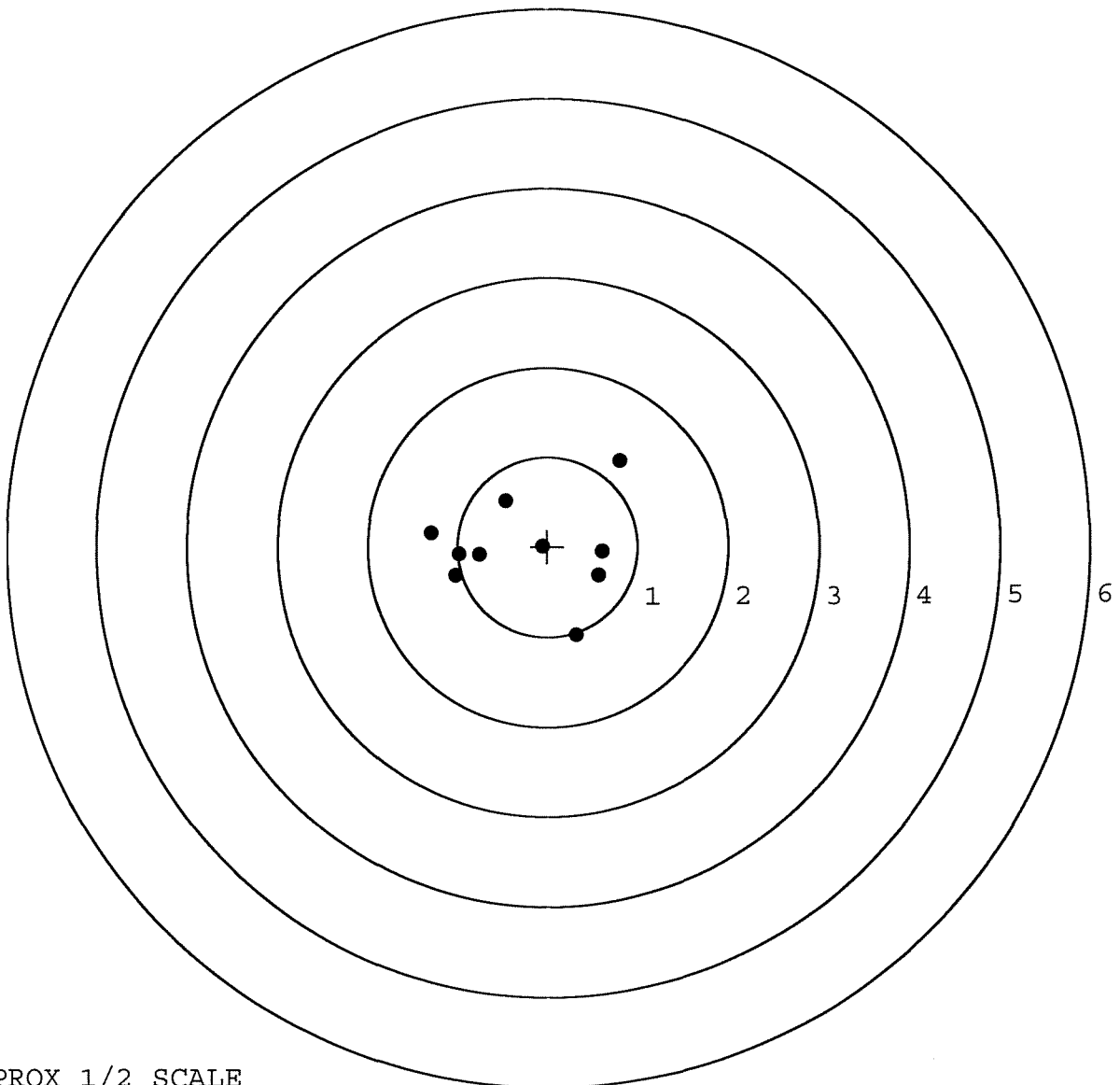


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6522215. 0
TARGET NUMBER: 2
FILE DATE: 02/15/2006
FILE TIME: 05:12

X CENTROID: -0.226
Y CENTROID: -0.024
POA TO CENTROID: 0.227
HORZ SPREAD: 2.112
VERT SPREAD: 1.943
GROUP SPREAD: 2.259
MIN RADIUS: 0.168
MAX RADIUS: 1.430
MEAN RADIUS: 0.821
IN 1 IN DIAMETER: 1
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.326	-0.984
2:	0.570	-0.325
3:	0.612	-0.055
4:	0.813	0.959
5:	-0.060	0.001
6:	-0.459	0.511
7:	-0.755	-0.093
8:	-0.984	-0.084
9:	-1.023	-0.325
10:	-1.299	0.157

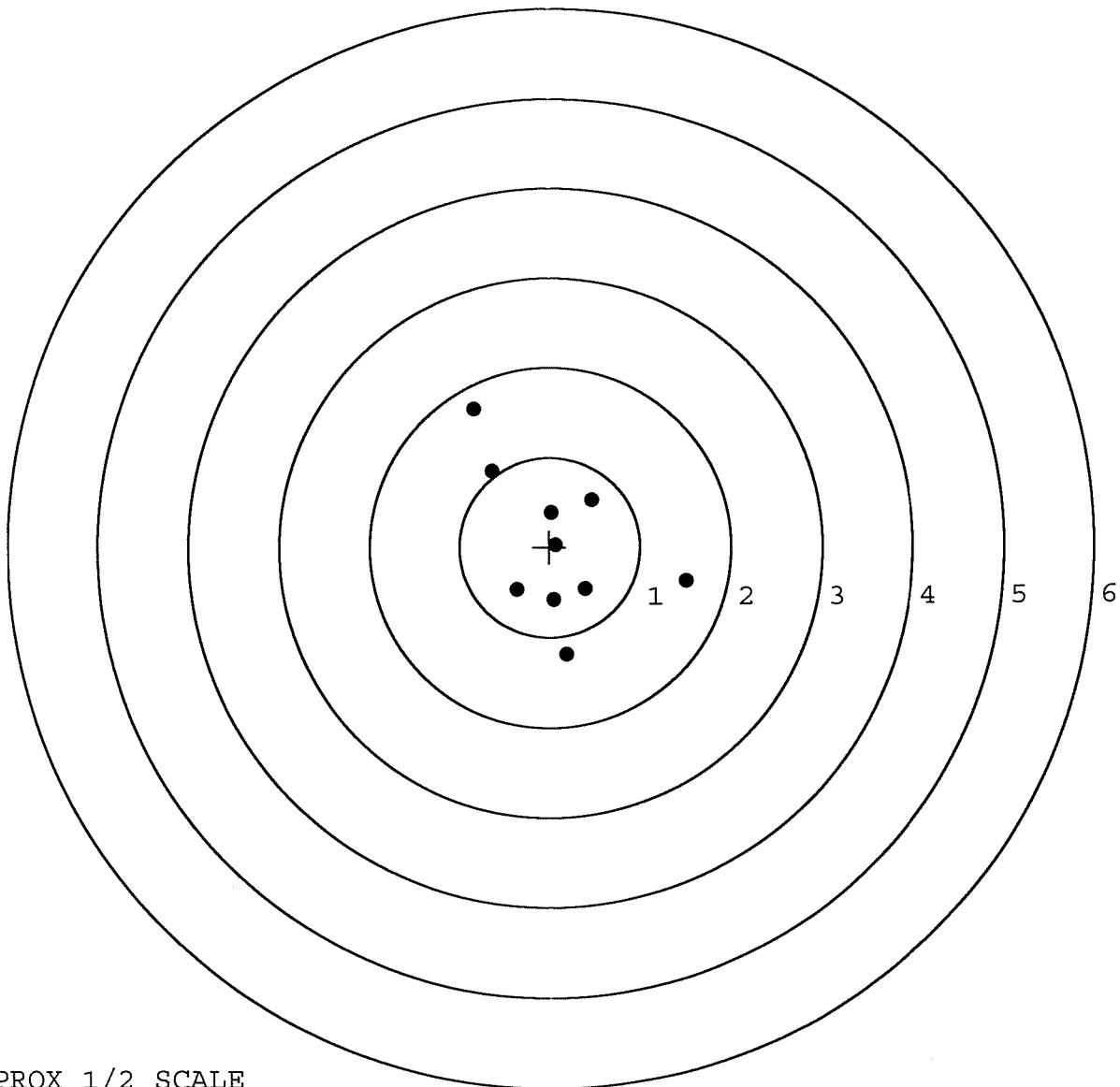


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6522215.___0
TARGET NUMBER: 3
FILE DATE: 02/15/2006
FILE TIME: 05:12

X CENTROID: 0.087
Y CENTROID: 0.021
POA TO CENTROID: 0.089
HORZ SPREAD: 2.337
VERT SPREAD: 2.739
GROUP SPREAD: 3.028
MIN RADIUS: 0.018
MAX RADIUS: 1.782
MEAN RADIUS: 0.845
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 6
in 3 IN DIAMETER: 9

POINT#	X	Y
1:	1.500	-0.381
2:	0.189	-1.195
3:	0.400	-0.471
4:	0.053	-0.589
5:	-0.362	-0.480
6:	0.069	0.024
7:	0.024	0.383
8:	0.470	0.522
9:	-0.638	0.848
10:	-0.837	1.544

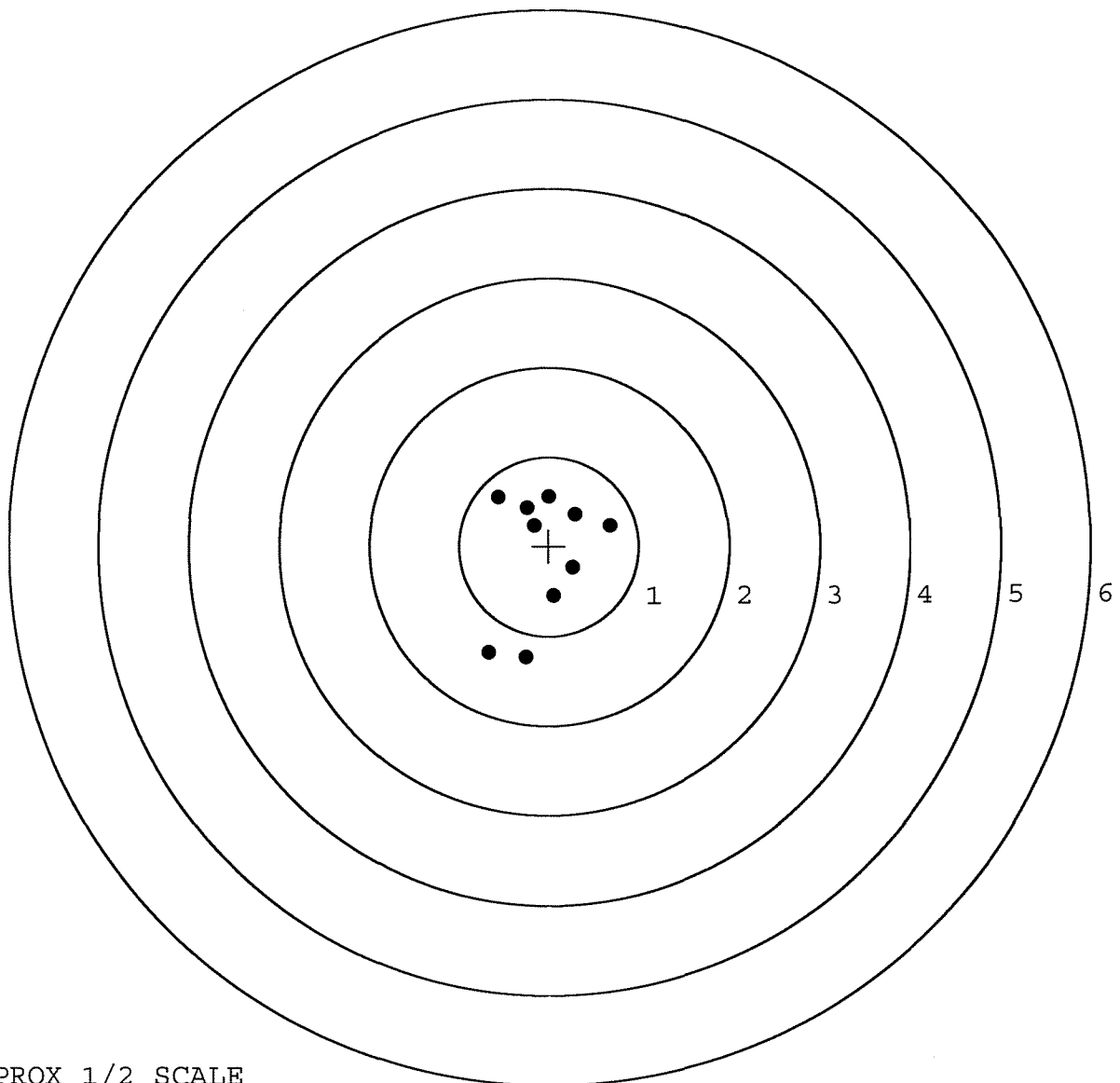


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6522215. __0
TARGET NUMBER: 4
FILE DATE: 02/15/2006
FILE TIME: 05:12

X CENTROID: -0.056
Y CENTROID: -0.087
POA TO CENTROID: 0.103
HORZ SPREAD: 1.354
VERT SPREAD: 1.796
GROUP SPREAD: 1.958
MIN RADIUS: 0.334
MAX RADIUS: 1.259
MEAN RADIUS: 0.699
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.256	-1.238
2:	-0.671	-1.185
3:	0.059	-0.554
4:	0.272	-0.246
5:	0.683	0.230
6:	0.303	0.357
7:	0.008	0.558
8:	-0.160	0.231
9:	-0.556	0.547
10:	-0.238	0.433



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6522215. __0

TARGET NUMBER: 5

FILE DATE: 02/15/2006

FILE TIME: 05:12

POINT#	X	Y
1:	0.834	1.383
2:	0.170	0.935
3:	-0.054	0.513
4:	-0.342	0.232
5:	-0.051	0.167
6:	0.035	-0.037
7:	0.432	-0.243
8:	-0.208	-0.321
9:	-0.303	-0.829
10:	-0.341	-1.070

X CENTROID: 0.017

Y CENTROID: 0.073

POA TO CENTROID: 0.075

HORZ SPREAD: 1.176

VERT SPREAD: 2.453

GROUP SPREAD: 2.720

MIN RADIUS: 0.111

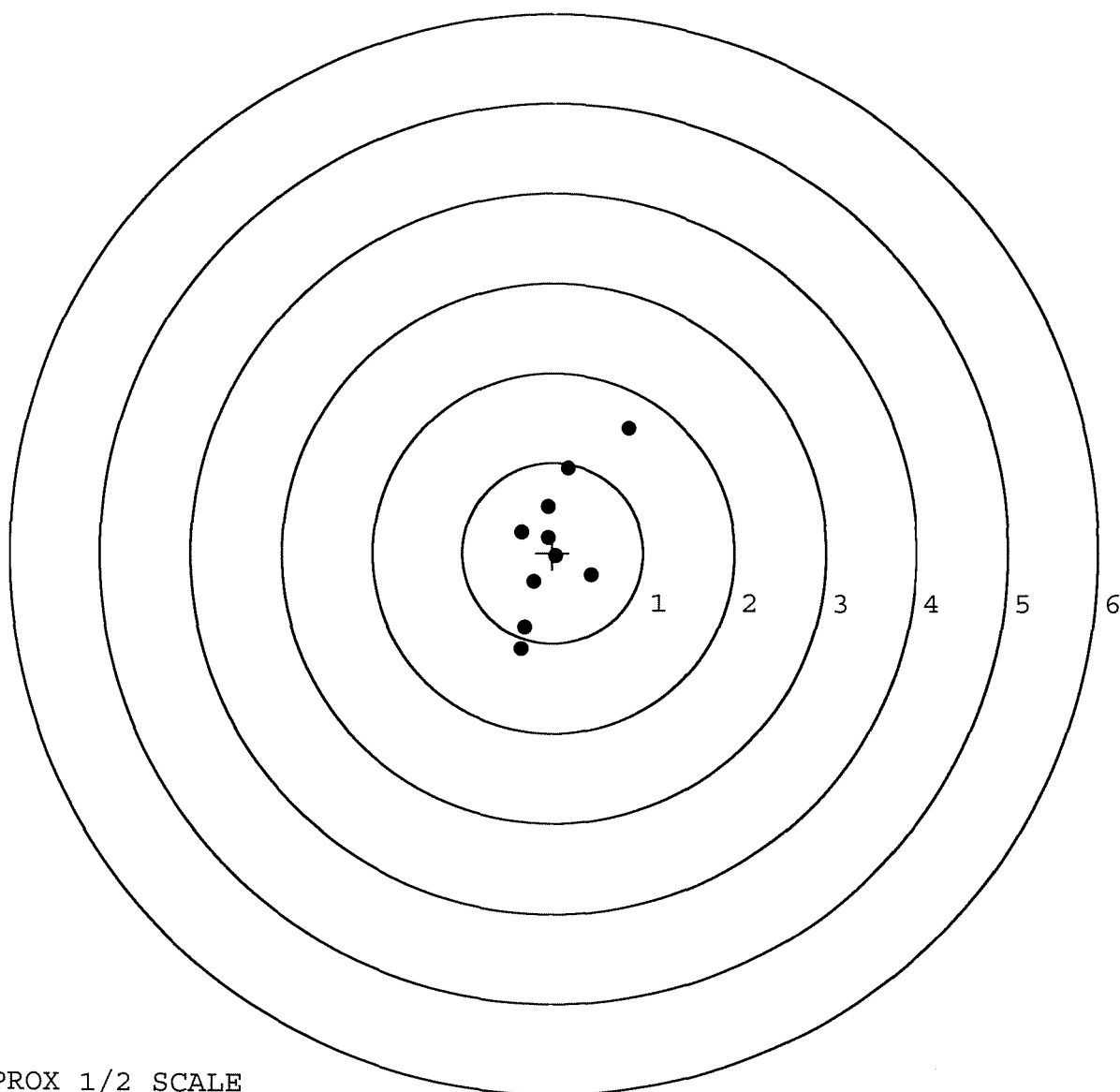
MAX RADIUS: 1.544

MEAN RADIUS: 0.662

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

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

R & E NUMBER	107914			
SERIAL NUMBER	06522215			
LOG-IN DATE	2-6-06			
OPERATION #	OPERATION NAME		DATE	INITIAL
500	DIS-ASSEMBLE GUN		2-6-06	RTZ
505	RE-BARREL		2-8-06	RTZ
560	ASSEMBLE		2-8-06	RTZ
600	PROOF	MAGNA-FLUX	2-8-06	RTZ
605	CHECK HEADSPACE	INSPECTED	2-8-06	RTZ
610	DIS-ASSEMBLE GUN	FEB 9 2006	2-8-06	RTZ
612	MAGNAFLUX	OPERATOR <i>unab</i>	2/9/06	<i>unab</i>
510	DRILL AND TAP		2-9-06	TRW
615	ROLLMARK CALIBER		2-10-06	CW
618	ROTO-BLAST		2-10	L B
620	APPLY COATINGS		2/14/06	<i>RB</i>
625	FINAL ASSEMBLY		2-14-06	<i>A</i>
640	FUNCTION TEST AND	PASS FAIL	2-15-06	TRW
650	TARGET	PASS FAIL		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION	2/15/06	RD
670	FINAL INSPECTION		2-15-06	AC
	A) HEADSPACE	PASS FAIL	2-15-06	AC
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS		N/A
680	F) SAFETY ON FORCE	2 LBS MIN 10 LBS	4/16s 4/16s 4/16s	AC
	G) SAFETY OFF FORCE	2 LBS MIN	4/16s 4/16s 4/16s	AC
	I) FIRING PIN INDENT	.020	.023 .023 .023	AC
690	PACK		2/24/06	RD

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: RE00009448

Serial: C6522215 Model 700 Center Fire Caliber: 7.62 NATO M-24 (SWS)

Repairman:

Status:

New 5/18/00 2:38:19 PM

Verify Repair

Address Information

Customer:

Received From

Return To:

Received From

Name: HSC 3RD BN, 3RD SFG (A)

HSC 3RD BN, 3RD SFG (A)

Address 1:

Address 2:

PO Box:

PO Box:

City: FORT BRAGG

FORT BRAGG

State: NC

Zip Code: 28310

Country: US

State: NC

Zip Code: 28310

Country: US

FFL:

Contact / Condition

Problems

Estimate

History / Status

Shipping / Billing

Contact Information

Phone:

Fax:

Email:

Comments:

Received Condition

Poor

Condition

Notes:

CSR

Notes:

Accessories Received

Code	Desc	Qty
A007	With Stud	2
A008	With Swivel	2
A010	Hard Case	1
A017	Scope Base	1

Repair Search

Refresh

Close

naglet

5/18/00

3:03 PM

CAPS

NUM

INS

SCRL

Start

Inb...

Micr...

SA...

Nag...

Audit

Rt...

Ar...

RE...

Prin...

3:03 PM

3:03 PM

Serial Number:

C6522215

Model: 700



RE00009448

96003-BBL

Remington Test Lab, Ilion, N.Y.

Centroidal distance calculations for Rifle # c6522215
8 Sep 2000

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: $-.0062$
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: $.2552$
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: $.255275$

THE AMR FOR THIS RIFLE IS: $.964$

CENTROIDAL DISTANCES

0	TO	1	.294593
1	TO	2	.251024
1	TO	3	.462871
1	TO	4	.289171
1	TO	5	.139603

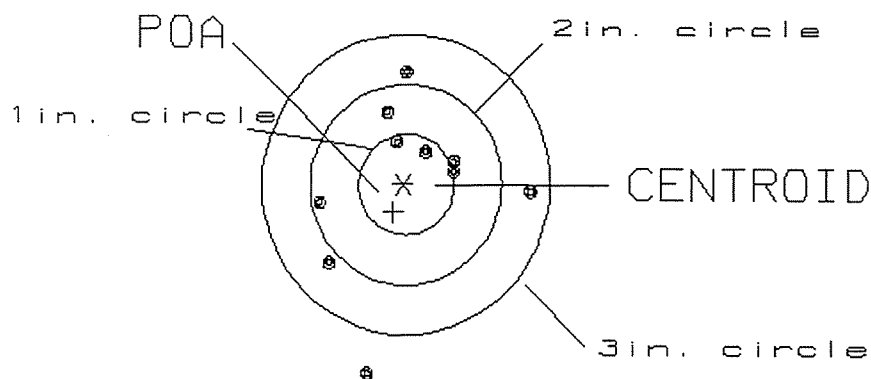
4
5₁
3²+ <----POA

PATTERN #: ☐ 1 ☐
 POA TO CENTROID: .294
 MIN RADIUS : .382
 MEAN RADIUS : .909
 MAX RADIUS : 1.951
 CENTROID X : .103
 CENTROID Y : .276

8 Sep 2000

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/cc6522215

CENTERFIRE PATTERN # 1



OF SHOTS= 10

IN CIRCLE

HS= 2.24

3

VS= 3.07

6

GS= 3.10

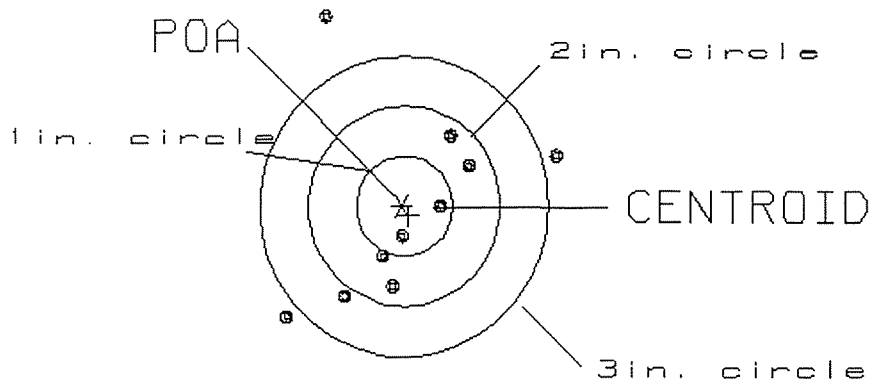
9

PATTERN #: 2
 POA TO CENTROID: .123
 MIN RADIUS : .340
 MEAN RADIUS : 1.009
 MAX RADIUS : 2.064
 CENTROID X : -.074
 CENTROID Y : .098

8 Sep 2000

FILE:/Hqbasic/Accuracy/Patterning/Centerfire_Patt/cc6522215

CENTERFIRE PATTERN # 2



OF SHOTS= 10

IN CIRCLE

HS= 2.76
 VS= 3.04
 GS= 3.22

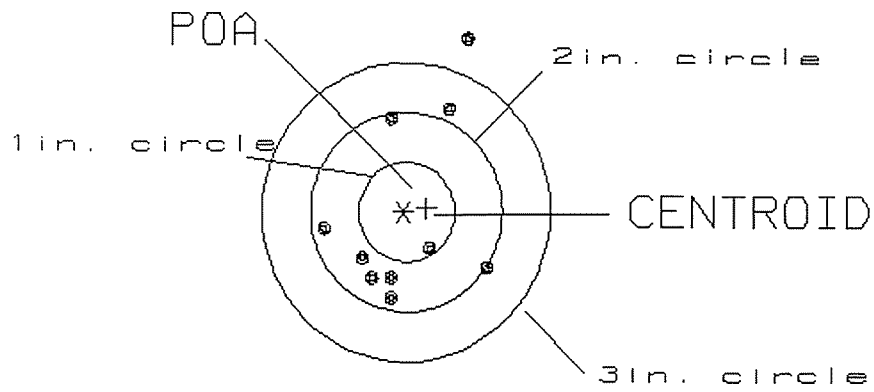
2
 6
 7

PATTERN #: ☐ 3 ☐
 POA TO CENTROID: .240
 MIN RADIUS : .419
 MEAN RADIUS : .924
 MAX RADIUS : 1.881
 CENTROID X : -.238
 CENTROID Y : -.037

8 Sep 2000

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/cc6522215

CENTERFIRE PATTERN # 3



OF SHOTS= 10

IN CIRCLE

HS= 1.68

1

VS= 2.67

7

GS= 2.79

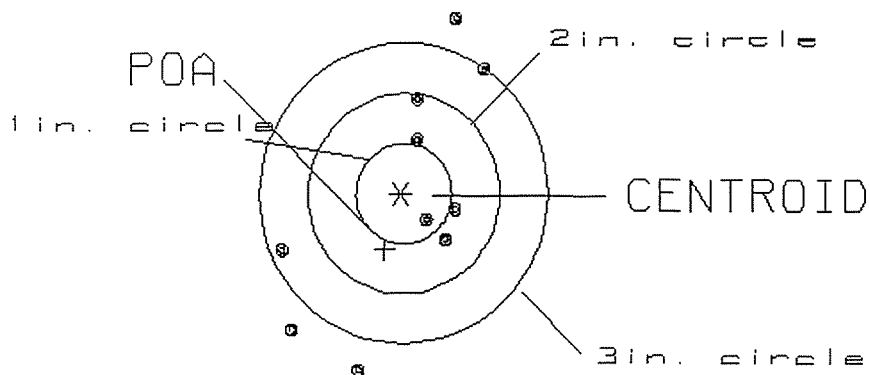
9

PATTERN #: 4
 POA TO CENTROID: .582
 MIN RADIUS : .329
 MEAN RADIUS : 1.121
 MAX RADIUS : 1.793
 CENTROID X : .167
 CENTROID Y : .558

8 Sep 2000

FILE:/Hqbasic/Accuracy/Patterning/Centerfire_Patt/cc6522215

CENTERFIRE PATTERN # 4



OF SHOTS= 10

IN CIRCLE

HS= 2.09

1

VS= 3.41

5

GS= 3.53

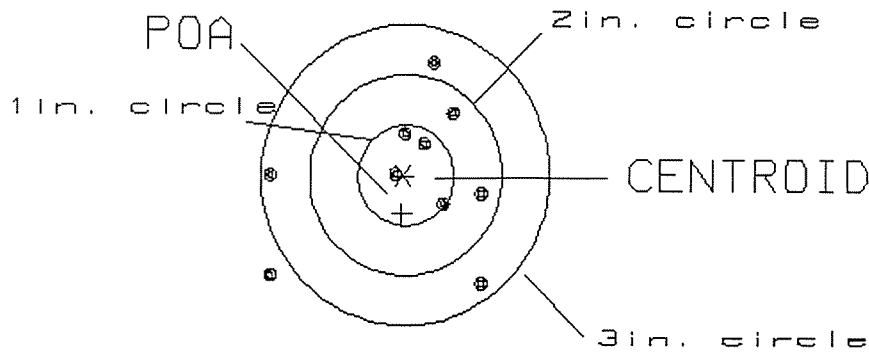
7

PATTERN #: 5
 POA TO CENTROID: .382
 MIN RADIUS : .084
 MEAN RADIUS : .857
 MAX RADIUS : 1.717
 CENTROID X : .011
 CENTROID Y : .381

8 Sep 2000

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/cc6522215

CENTERFIRE PATTERN # 5



OF SHOTS= 10

IN CIRCLE

HS= 2.18

4

VS= 2.24

6

GS= 2.71

9

Final Inspection

Sn: C6522215

DATE REC'D: 5-12-00

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:

M-24 INSPECTION CHECKLIST
CONTRACT #: DAAE-20-97-C-242

[illegible]

RECEIVING AND ESTIMATING REPORT

R 93-02454

INITIAL PS	CUSTOMER ORDER NO.	WOG 6 OF 30 W/10X SCOPE & DEPLOYMENT KIT M24				
DATE RECEIVED 1/25/93	DATE OPENED 01/25/93	DATE CODE DK 9-90	SERIAL NUMBER C6522215	NEW SERIAL NUMBER	MODEL AND GRADE 700 7-62	NATO
ACCESSORIES W/STUDS	W/SWIVELS		SOFT CASE		SCOPE BASE	

FROM:

MCHALE; EDWARD J CPT;SF
HSC 3RD BN 3RD SFG (A)
FT BRAGG NC 28307

SHIP TO:

MCHALE; EDWARD J CPT;SF
HSC 3RD BN 3RD SFG (A)
FT BRAGG NC 28307

ACCOUNT NUMBER		ACCOUNT NUMBER N/C	CUST NO: 073985 C.O.D	PROM. DATE	ESTIMATED	VIA UPS
GUN CONDITION			WRITE ☐ CLEAN/TEST			
☐ NEW						REPAIR CHARGE
☐ LIGHTLY WORN						EXCISE
☐ WORN						TAX
☐ VERY WORN						INSURANCE
☐ UNREPAIRABLE						UPS
☐ MARRED						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

Rust on Gun

PARTS	COMMENTS					
Trigger Assy - 96024	Zinc phosphate Scope Rings, Swivels & Swivel Studs Re-powder Coat Barrel Assy - 96001					
	REPAIRMAN <i>RW</i>	PROOF	CLEAN ☒	TEST ☒	TARGET	PATTERN
	GALLERY TESTER <i>RW</i>	DATE	DATE 2/17/93	DATE 2/26/93	DATE	DATE

OFFICE COPY

RD6925 REV. 1/92

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER

M2400002930

GFM

CONTRACT # DAAA21-87-C-0086

*Repair*GUN SERIAL # *C 6522215*

OP. #	OP. NAME	READINGS	DATE	INIT
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		<i>2/17/93</i>	<i>RW</i>
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		<i>2/17/93</i>	<i>RW</i>
	C) Inspect Ejector Hole for Chamfer		<i>2/17/93</i>	<i>RW</i>
	D) Oil Firing Pin Ass'y		<i>2/17/93</i>	<i>RW</i>
	E) Adjust Trigger Pull to Min Setting and Stake		<i>2/17/93</i>	<i>RW</i>

Op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			2/17/93	RW
	G) Safety Off Force	3.5	3	3			2/17/93	RW
	H) Trigger Pull Test & Retainability						2/17/93	RW
	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						2/17/93	RW
	P) Detach & Attach Scope 20 Times							
640	Gallery Target & Test						2/26/93	RW
	A) Time							
	B) Malfunctions							
	C) Pierced Primers							
	D) Optical Clarity of Scope							
645	Inspect for Live Ammo						2/26/93	RW
655	Final Inspection							
	A) Headspace						3/4/93	RW
	B) Trigger Pull	2.40	2.34	2.38	2.38	2.34	3/4/93	RW
	C) Function						3/4/93	RW
660	Pack							

SWS TRIGGER PULL TEST

New Trigger Assy

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C65222/5DATE 2/17/93TESTER RW

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#	COMMENTS
PULL #1	2.42	2.30	2.55	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.37	2.25	2.46	
PULL #3	2.32	2.24	2.44	
PULL #4	2.31	2.26	2.47	
PULL #5	2.36	2.20	2.26	
TOTAL	11.78	11.25	12.18	
AVG.	2.36	2.25	2.44	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.19	3.21		
PULL #2	3.17	3.13		
PULL #3	3.17	3.27		
PULL #4	3.14	3.15		
PULL #5	3.11	3.23		
TOTAL	15.78	15.99		
AVG.	3.16	3.20		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.07	4.07		4.28
PULL #2	4.09	4.05		4.26
PULL #3	4.05	4.09		4.28
PULL #4	4.01	4.05		4.32
PULL #5	4.02	4.09		4.23
TOTAL	20.24	20.35		21.37
AVG.	4.05	4.07		4.27




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

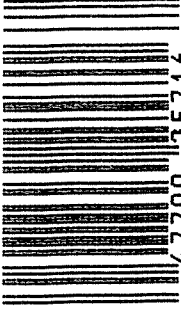
MODEL 700™ H24

SERIAL NO.
C6522215

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 C6522215

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06522215
1 Nov 1990

CENTROIDAL DISTANCES

0 TO	1	.315628
1 TO	2	.497403
1 TO	3	.45771
1 TO	4	.209476
1 TO	5	.303488

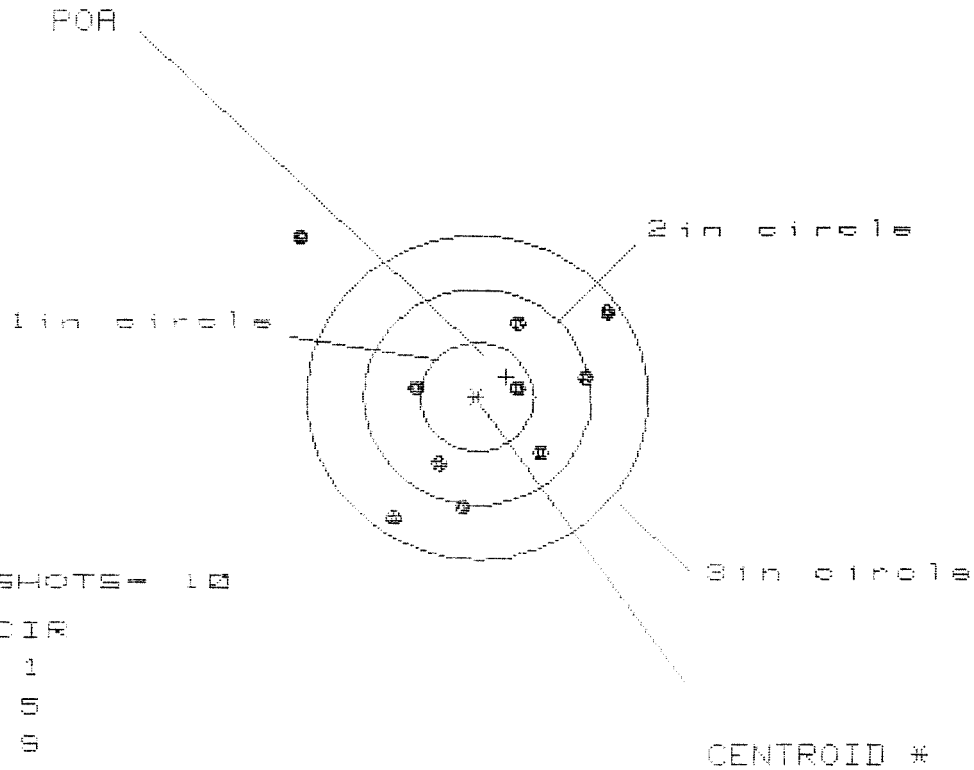
 (----POI

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0286
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.033
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0436688
THE ABR FOR THIS RIFLE IS: .9374

1 NOV 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6522215

CENTERFIRE PATTERNS # 1



OF SHOTS - 10

IN CIR

1in = 1

2in = 5

3in = 5

HS = 2.743

VS = 2.568

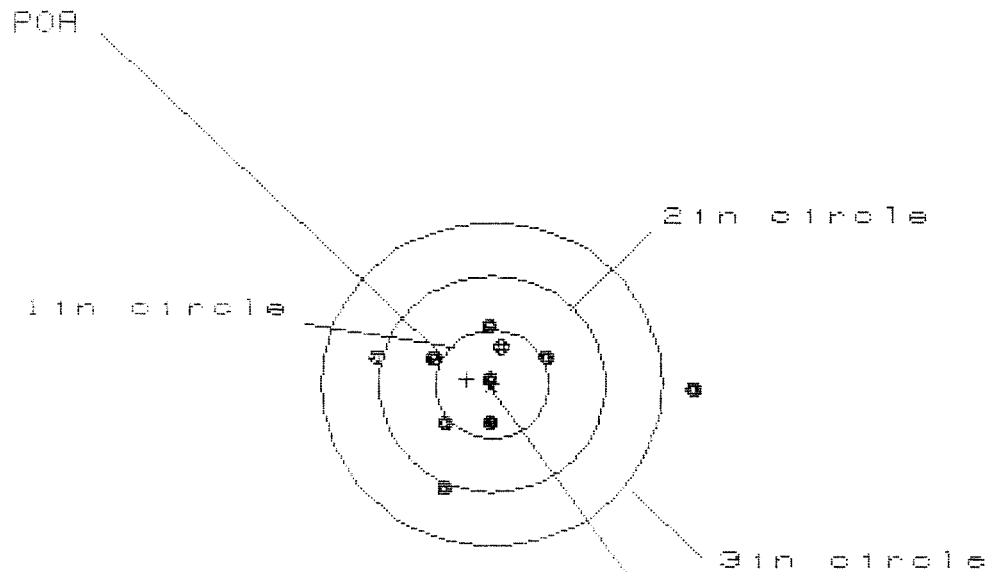
GS = 2.868

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.177	1.003	.954
MINIMUM X	-1.566	-.929	-.303
MAXIMUM Y	1.459	.953	1.010
MINIMUM Y	-1.110	-.948	-.829
CENTROID X	-.255	-.081	-.206
CENTROID Y	-.186	-.348	-.467
POA TO CENTROID in.	.316	.357	.511
MIN RADIUS	.348	.270	.442
MEAN RADIUS	1.019	.859	.788
MAX RADIUS	2.140	1.384	1.154
HORIZONTAL SPREAD	2.743	1.932	1.757
VERTICAL SPREAD	2.569	1.901	1.839
EXTREME SPREAD	2.868	2.710	2.181
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	9		

1 Nov 1930

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 3

2in = 7

3in = 8

HS= 2.781

VS= 1.548

GS= 2.885

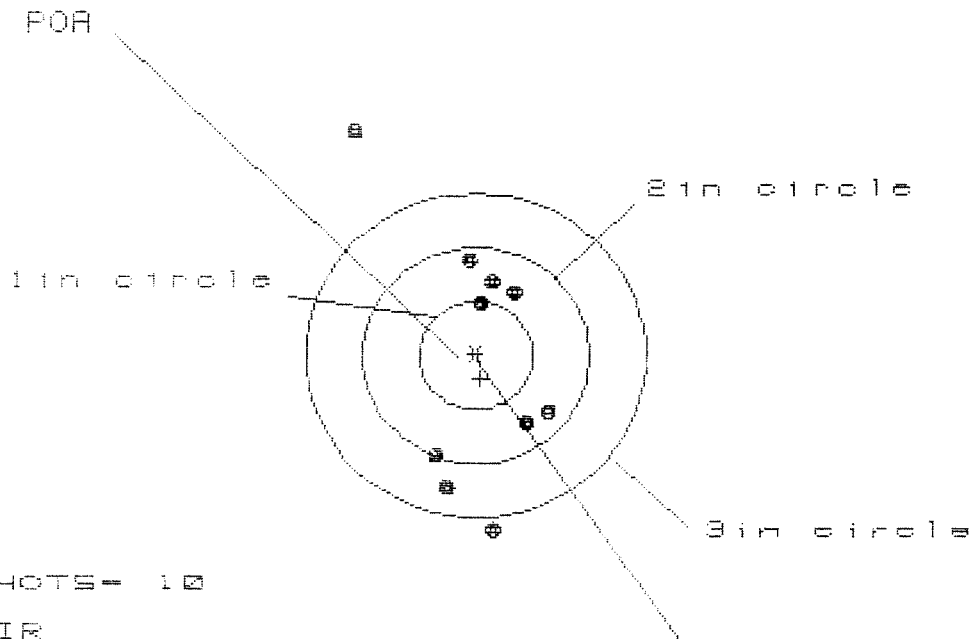
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.762	.711	.689
MINIMUM X	:	-1.019	-.823	-.845
MAXIMUM Y	:	.547	.539	.413
MINIMUM Y	:	-1.001	-1.009	-.478
CENTROID X	:	.222	.026	.048
CENTROID Y	:	-.045	-.037	.089
POA TO CENTROID in.	:	.227	.045	.102
MIN RADIUS	:	.085	.208	.179
MEAN RADIUS	:	.687	.557	.483
MAX RADIUS	:	1.764	1.025	.859
HORIZONTAL SPREAD	:	2.781	1.534	1.534
VERTICAL SPREAD	:	1.548	1.548	.891
EXTREME SPREAD	:	2.885	1.583	1.534
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

1 Nov 1990

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 0

2in = 6

3in = 8

HS= 1.695

VS= 3.718

GS= 3.909

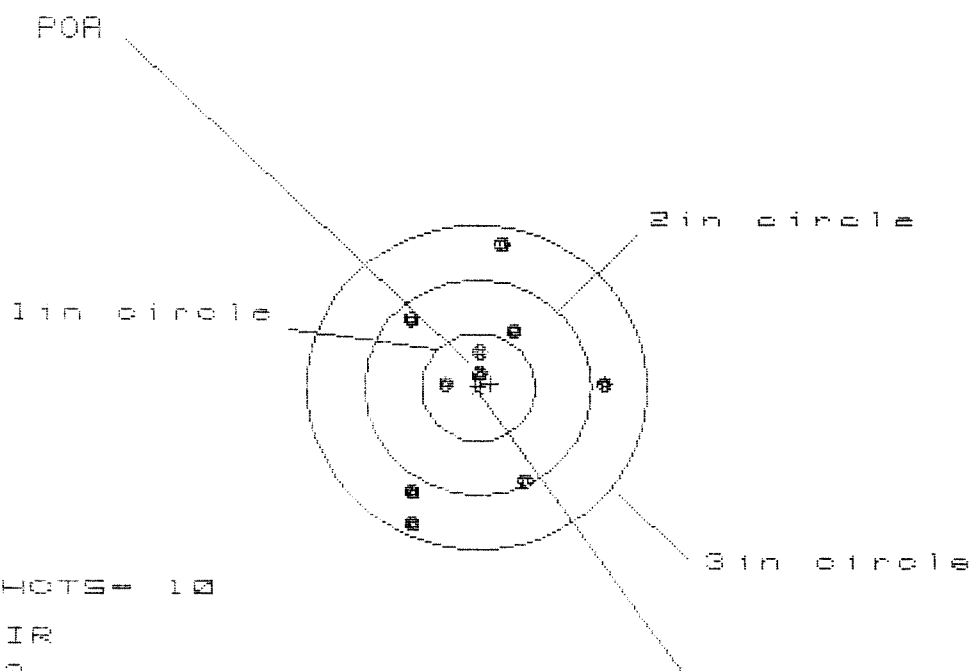
CENTROID *

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.649	.533	.539
MINIMUM X	:	-1.046	-.457	-.451
MAXIMUM Y	:	2.100	1.132	.959
MINIMUM Y	:	-1.618	-1.384	-1.124
CENTROID X	:	-.038	.078	.072
CENTROID Y	:	.217	-.017	.156
POA TO CENTROID in.	:	.220	.080	.172
MIN RADIUS	:	.504	.497	.576
MEAN RADIUS	:	1.056	.893	.815
MAX RADIUS	:	2.346	1.385	1.196
HORIZONTAL SPREAD	:	1.695	.990	.990
VERTICAL SPREAD	:	3.718	2.516	2.083
EXTREME SPREAD	:	3.909	2.525	2.098
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

1 May 1998

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 3

2in = 5

3in = 10

HS= 1.691

VS= 2.630

GS= 2.739

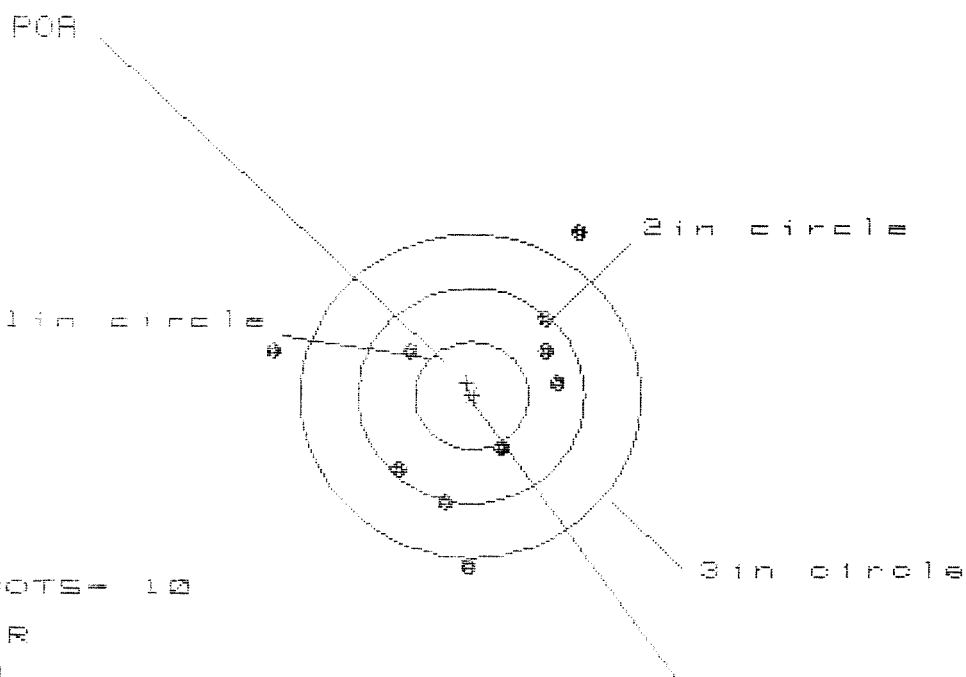
CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.076	1.010	1.022
MINIMUM X	:	-.615	-.681	-.668
MAXIMUM Y	:	1.346	1.204	.669
MINIMUM Y	:	-1.284	-1.147	-.997
CENTROID X	:	-.113	-.047	-.060
CENTROID Y	:	-.032	.110	-.040
POA TO CENTROID in.	:	.118	.120	.072
MIN RADIUS	:	.165	.043	.172
MEAN RADIUS	:	.841	.737	.708
MAX RADIUS	:	1.416	1.322	1.187
HORIZONTAL SPREAD	:	1.691	1.691	1.691
VERTICAL SPREAD	:	2.630	2.351	1.666
EXTREME SPREAD	:	2.739	2.470	1.966
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		10	

NOV 1990

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CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1in = 0

2in = 7

3in = 7

HS= 2.712

VS= 3.114

GS= 3.271

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.970	.867	.663
MINIMUM X	:	-1.742	-1.635	-.774
MAXIMUM Y	:	1.543	.893	.965
MINIMUM Y	:	-1.571	-1.400	-1.328
CENTROID X	:	.041	-.066	.138
CENTROID Y	:	-.119	-.290	-.362
POR TO CENTROID in.	:	.126	.298	.387
MIN RADIUS	:	.528	.454	.268
MEAN RADIUS	:	1.084	.992	.867
MAX RADIUS	:	1.822	1.732	1.334
HORIZONTAL SPREAD	:	2.712	2.582	1.437
VERTICAL SPREAD	:	3.114	2.293	2.293
EXTREME SPREAD	:	3.271	2.611	2.385
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		7	

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6522215

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	9 24	90	RW
600	Proof	9 24	90	RW
607	Check Headspace	9 24	90	RW
610	Dis-assemble Gun	9 24	90	RW
612	Magnaflux Barrel Action		9-25-90	KR
	Magnaflux Bolt		9-25-90	KR
615	Rollmark Caliber		9-25-90	B S
617	Drill and Tap Sight Holes		9-25-90	F.B
618	Polish Barrel RB		9/18/90	WB
620	Apply Coatings (Barrel Action)		10-2-90	TH
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		10/9/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/9/90	RW
	C) Inspect Ejector Hole for Chamfer		11/9/90	RW
	D) Oil Firing Pin Ass'y		10/9/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		10/30/90	TH

op. #	OP. NAME	READINGS					DATE	INIT
625 ont.	F) Safety On Force	5	5	5			10/31/90	WB
	G) Safety Off Force	3	3	3			10/31/90	WB
	H) Trigger Pull Test & Retainability						10/30/90	JH
	I) Firing Pin Indent	1021	020	021			10/31/90	WB
	J) Assemble Stock						10/31/90	RW
	K) Assemble Swivel Studs						3/10/90	JS
	L) Attach Front and Rear Sight Assemblies						10/31/90	RW
	M) Iron Sight Alignment						10/31/90	RW
	N) Detach Front & Rear Sights & place in numbered container						10/31/90	RW
	O) Attach Scope to Rifle						10/31/90	RW
	P) Detach & Attach Scope 20 Times						10/31/90	RW
640	Gallery Target & Test						10/31/90	AF
	A) Time						"	AF
	B) Malfunctions						"	AF
	C) Pierced Primers						"	AF
	D) Optical Clarity of Scope						"	AF
645	Inspect for Live Ammo						10/31/90	AF
655	Final Inspection							
	A) Headspace						3/10/90	JS
	B) Trigger Pull	272	264	256	241	212	3/10/90	JS
	C) Function						3/10/90	JS
660	Pack						12-1790	DH

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN

INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. 06522215DATE 10/30/90TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.20	2.47	2.44	2.72	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.45	2.39	2.40	2.64	
PULL #3	2.50	2.43	2.38	2.56	
PULL #4	2.48	2.45	2.43	2.41	
PULL #5	2.43	2.43	2.40	2.12	
TOTAL	12.06	12.17	12.05		
AVG.	2.412	2.434	2.41		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.20	3.30		
PULL #2	3.23	3.39		
PULL #3	3.31	3.28		
PULL #4	3.32	3.33		
PULL #5	3.34	3.19		
TOTAL	16.4	16.55		
AVG.	3.28	3.31		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.24	4.34		4.13
PULL #2	4.19	4.32		4.43
PULL #3	4.20	4.41		4.33
PULL #4	4.46	4.40		4.33
PULL #5	4.29	4.35		4.10
TOTAL	21.38	21.82		21.32
AVG.	4.276	4.364		4.264