

C6522294

MODEL 700™ M24

Model **SWS**™

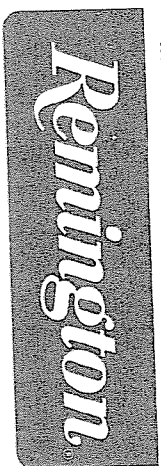
Action

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: RE00158819

Serial: C6522294 Model M24 SWS Center Fire
Caliber: 7.62 NATO Produced: 09/19/1990

Repairman:

Status:

Closed 1/14/2009 9:44:42 AM

Address Information

Customer: ☐ Received From: ☒

Name: DEPARTMENT OF THE ARMY SUPPLY

Address 1: B CO 2ND BN 3RD INFANTRY REGIMENT

Address 2: 3RD BRIGADE 2ND INFANTRY PO Box:

City: FORT LEWIS

State: WA Zip Code: 98433 Country: US

Return To: ☐ Received From: ☐

Name: DEPARTMENT OF THE ARMY SUPPLY

Address 1: B CO 2ND BN 3RD INFANTRY REGIMENT

Address 2: 3RD BRIGADE 2ND INFANTRY PO Box:

City: FORT LEWIS

State: WA Zip Code: 98433 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
A026	Scope	1
A057	Frt and Rear Sgt Base	1
D000	MARS RAIL	1

Repair Search

Refresh

Close

naglej

1/26/2009

11:33 AM

EAPS

NUM

INE

SERL

start

Inbox - Micros...

FW: Request f...

Ilion 19 Feb...

(UNCLASSIFIE...

Microsoft Excel...

Arms Services...

Microsoft Word...

Serial Number:

C6522294

Model: M24 SWS



RE00158819

B: Poof

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

R & E NUMBER		158829	
SERIAL NUMBER		C6522294	
LOG-IN DATE		1-14-09	

OPERATION #	OPERATION NAME	DATE	INITIAL
500	DIS-ASSEMBLE GUN	1-27-09	RTL
505	RE-BARREL	1-29-09	RTL
560	ASSEMBLE	1-29-09	RTL
600	PROOF	1-29-09	S.P.D.
605	CHECK HEADSPACE	1-29-09	S.P.D.
610	DIS-ASSEMBLE GUN	1-29-09	S.P.D.
612	MAGNAFLUX	1-29-09	S.P.D. ?
510	DRILL AND TAP	1-30-09	SP
615	ROLLMARK CALIBER	2/2/09	RT
618	ROTO-BLAST	2/2/09	RT
620	APPLY COATINGS	2-5	
625	FINAL ASSEMBLY	2-9-09	RTL
640	FUNCTION TEST AND	2-10-09	TL
650	TARGET	2-10-09	TL
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
670	FINAL INSPECTION	2-10-09	W N
	A) HEADSPACE	PASS FAIL	2-10-09
	B) TRIGGER PULL	2.61 2.46 2.51 2.55 2.58	2-10-09 W N
680	F) SAFETY ON FORCE	3.0 3.0 4.0	2-10-09 W N
	G) SAFETY OFF FORCE	4.0 4.0 4.0	2-10-09 W N
	I) FIRING PIN INDENT	.023 .023 -.023	2-10-09 W N
690	PACK		13/28/09 FIN

APD PE v1.10

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6522294.__0
FILE DATE AND TIME: 02/10/2009 11:32

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.023
The Average Y Centroid of the Five Target Set:	-0.018
The Average Point of Impact of the Five Target Set:	0.030
The Average Mean Radius of the Five Target Set:	0.753
The Distance from POA to Centroid Target #1:	0.087
The Distance from Centroid Target #2 to Centroid Target #1:	0.162
The Distance from Centroid Target #3 to Centroid Target #1:	0.054
The Distance from Centroid Target #4 to Centroid Target #1:	0.176
The Distance from Centroid Target #5 to Centroid Target #1:	0.108

SERIAL NUMBER: C6522294. 0

TARGET NUMBER: 1

FILE DATE: 02/10/2009

FILE TIME: 11:32

POINT#	X	Y
1:	-0.509	1.246
2:	0.752	0.491
3:	0.618	0.307
4:	-0.405	0.530
5:	-0.688	0.358
6:	-0.554	-0.929
7:	0.405	-0.910
8:	0.220	-0.815
9:	0.135	-0.649
10:	-0.361	-0.406

X CENTROID: -0.039

Y CENTROID: -0.078

POA TO CENTROID: 0.087

HORZ SPREAD: 1.440

VERT SPREAD: 2.175

GROUP SPREAD: 2.342

MIN RADIUS: 0.460

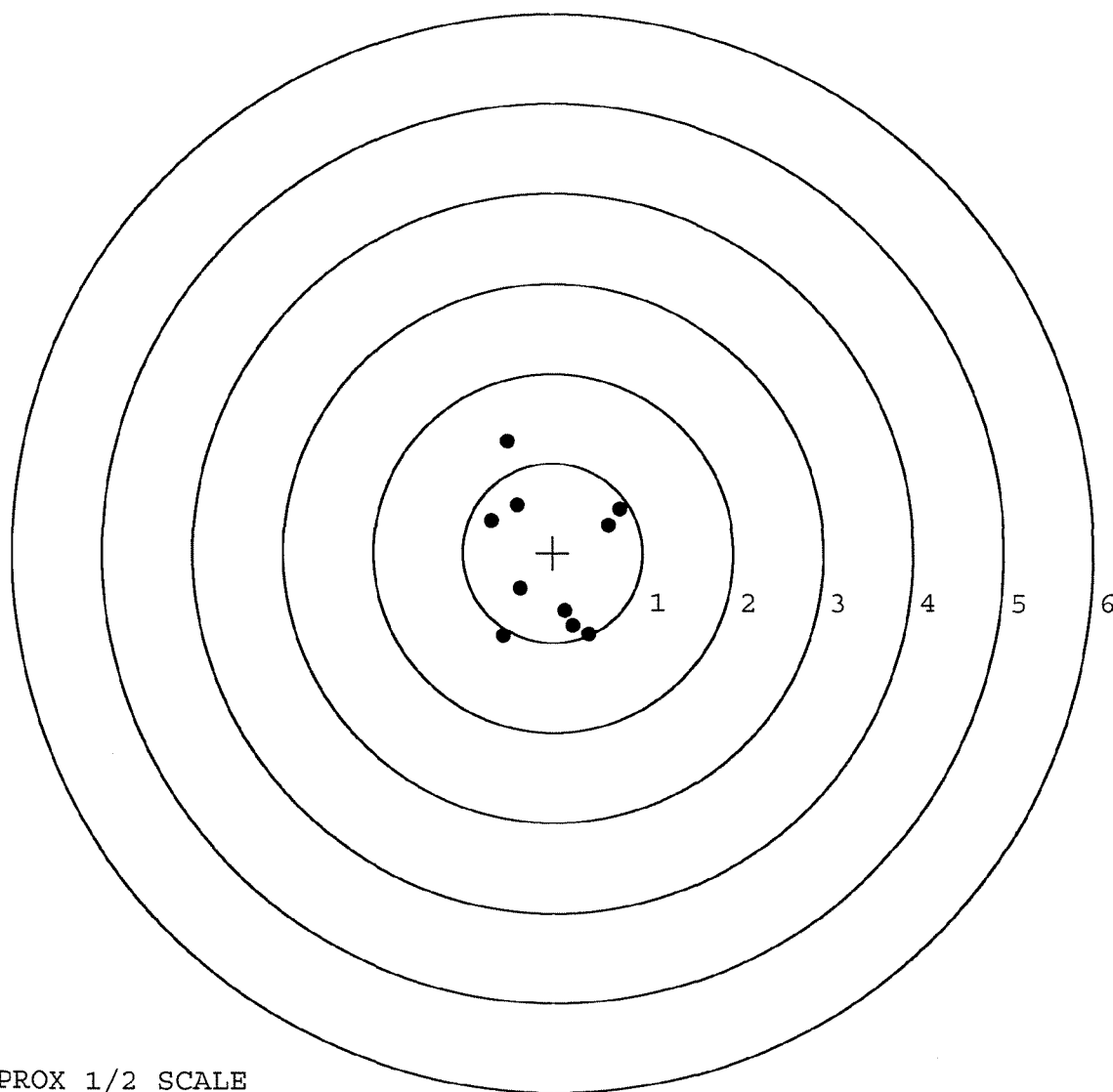
MAX RADIUS: 1.405

MEAN RADIUS: 0.841

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10

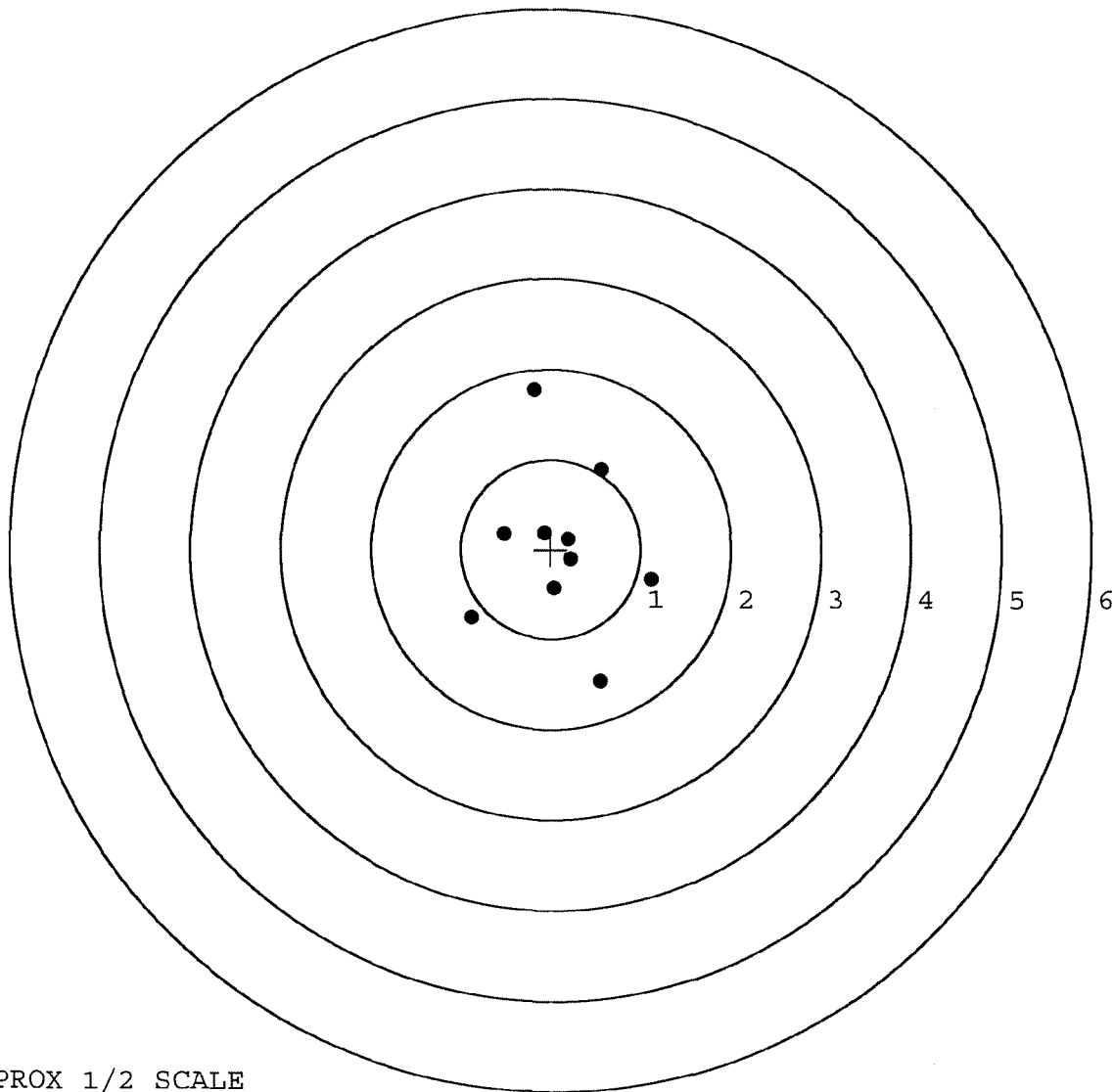


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6522294. __0
 TARGET NUMBER: 2
 FILE DATE: 02/10/2009
 FILE TIME: 11:32

X CENTROID: 0.103
 Y CENTROID: 0.002
 POA TO CENTROID: 0.103
 HORZ SPREAD: 1.999
 VERT SPREAD: 3.246
 GROUP SPREAD: 3.328
 MIN RADIUS: 0.147
 MAX RADIUS: 1.799
 MEAN RADIUS: 0.830
 # IN 1 IN DIAMETER: 4
 # IN 2 IN DIAMETER: 5
 # in 3 IN DIAMETER: 8

POINT#	X	Y
1:	0.549	-1.468
2:	-0.885	-0.771
3:	0.565	0.891
4:	-0.185	1.778
5:	1.114	-0.335
6:	-0.515	0.167
7:	0.039	-0.436
8:	0.221	-0.107
9:	0.196	0.116
10:	-0.072	0.186

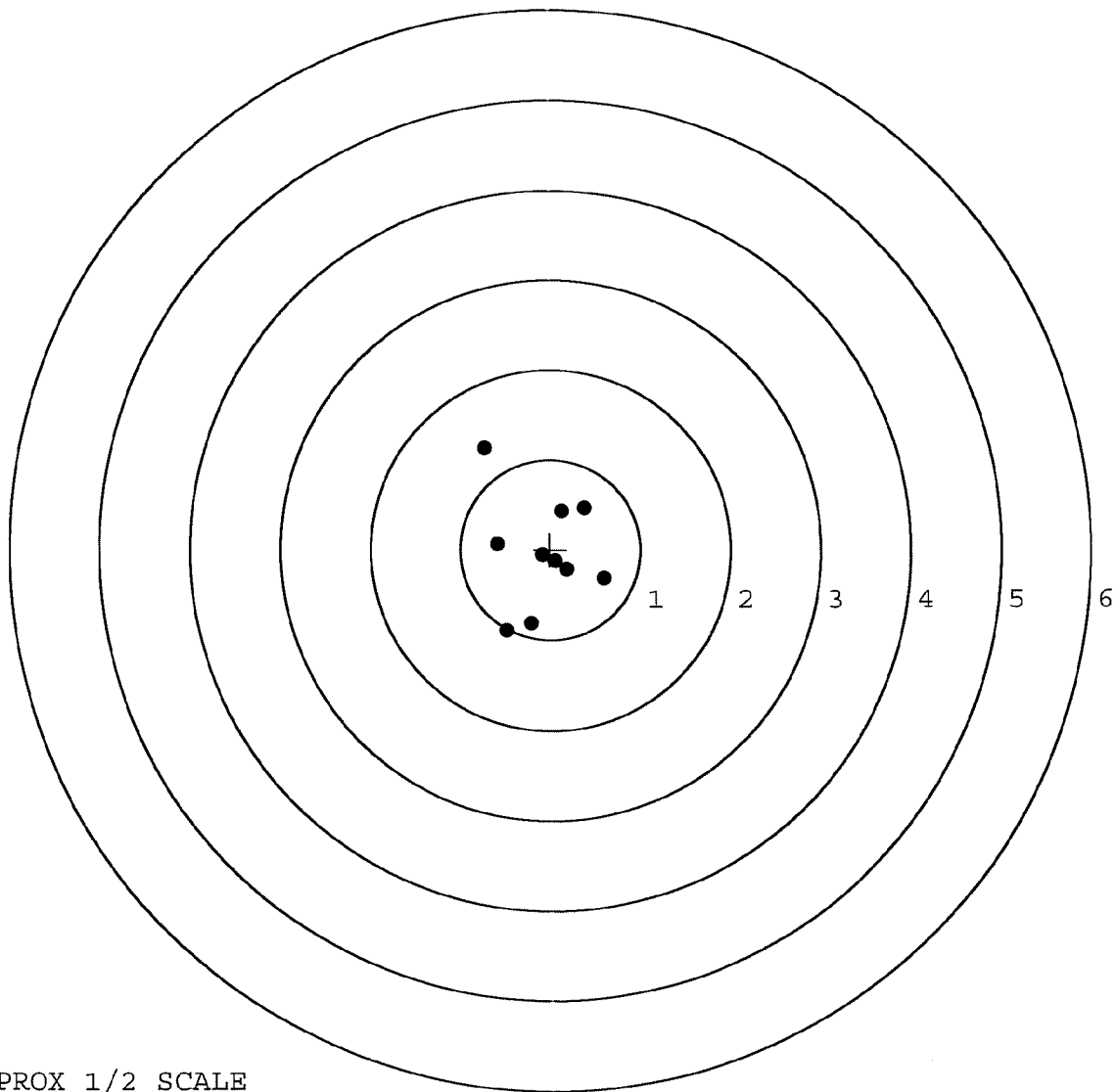


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6522294. 0
TARGET NUMBER: 3
FILE DATE: 02/10/2009
FILE TIME: 11:32

X CENTROID: -0.076
Y CENTROID: -0.038
POA TO CENTROID: 0.085
HORZ SPREAD: 1.330
VERT SPREAD: 2.039
GROUP SPREAD: 2.053
MIN RADIUS: 0.031
MAX RADIUS: 1.342
MEAN RADIUS: 0.606
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.731	1.133
2:	-0.489	-0.906
3:	-0.219	-0.822
4:	0.599	-0.325
5:	0.384	0.464
6:	0.133	0.427
7:	-0.591	0.064
8:	-0.093	-0.064
9:	0.058	-0.132
10:	0.186	-0.222



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6522294. __0

TARGET NUMBER: 4

FILE DATE: 02/10/2009

FILE TIME: 11:32

POINT#	X	Y
1:	0.757	1.757
2:	0.599	0.738
3:	-0.770	0.165
4:	0.451	0.570
5:	0.686	-0.523
6:	0.055	-0.882
7:	0.178	-0.876
8:	-0.824	-0.576
9:	-0.172	-0.252
10:	0.197	-0.062

X CENTROID: 0.116

Y CENTROID: 0.006

POA TO CENTROID: 0.116

HORZ SPREAD: 1.581

VERT SPREAD: 2.639

GROUP SPREAD: 2.818

MIN RADIUS: 0.106

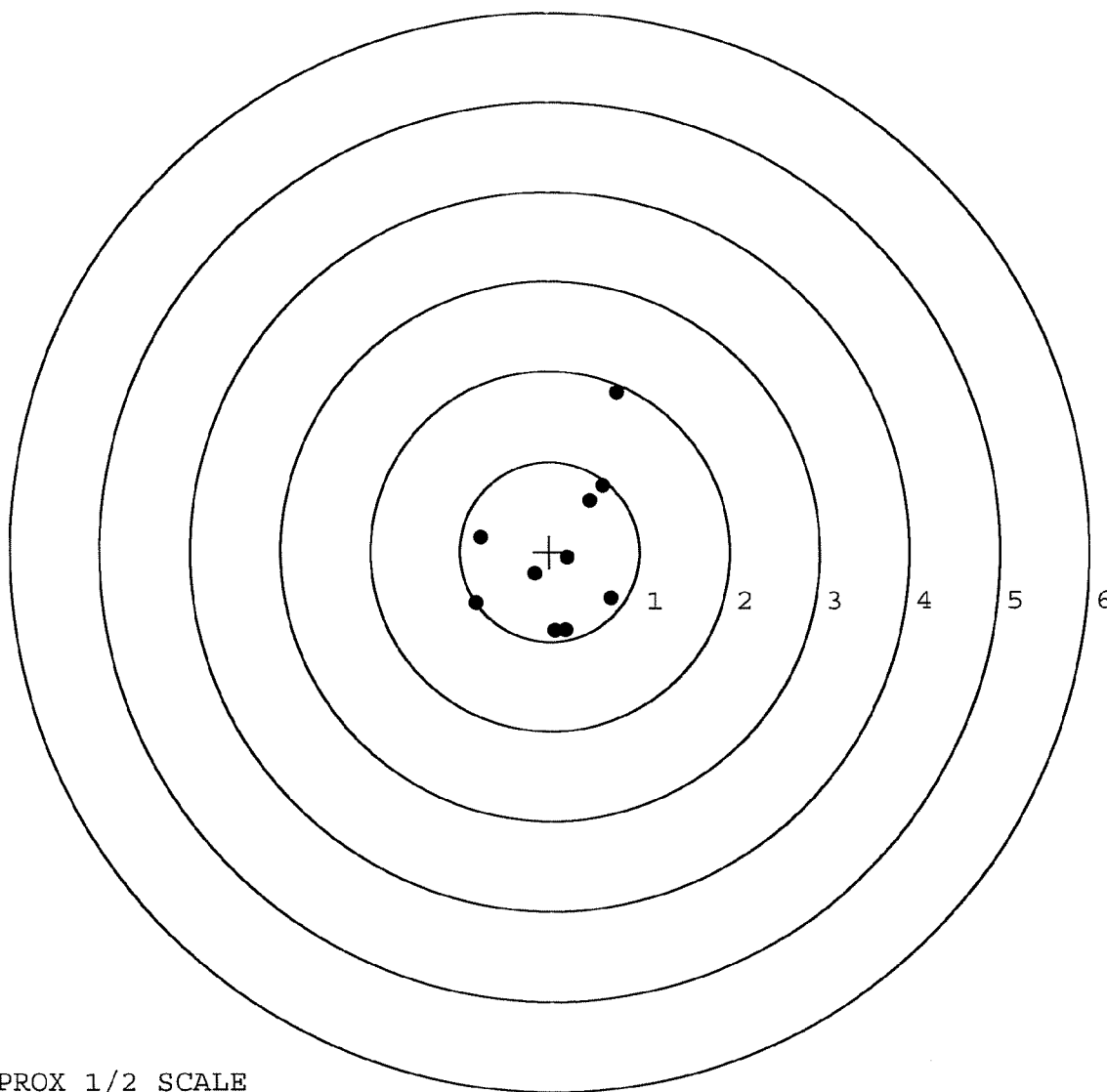
MAX RADIUS: 1.865

MEAN RADIUS: 0.845

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 9

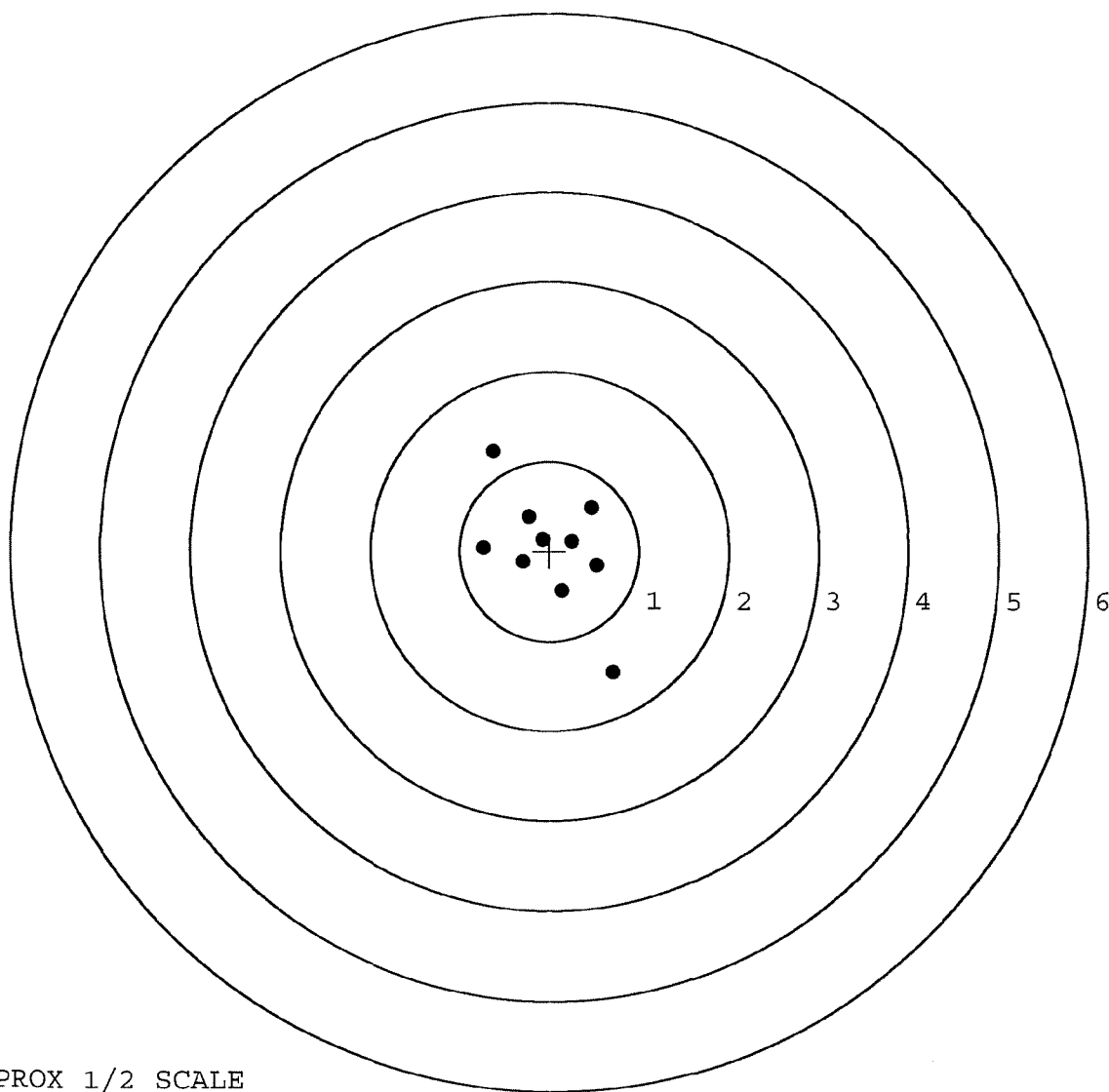


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6522294. __0
TARGET NUMBER: 5
FILE DATE: 02/10/2009
FILE TIME: 11:32

X CENTROID: 0.014
Y CENTROID: 0.016
POA TO CENTROID: 0.021
HORZ SPREAD: 1.447
VERT SPREAD: 2.463
GROUP SPREAD: 2.804
MIN RADIUS: 0.146
MAX RADIUS: 1.537
MEAN RADIUS: 0.643
IN 1 IN DIAMETER: 5
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 9

POINT#	X	Y
1:	0.711	-1.353
2:	0.528	-0.163
3:	0.472	0.484
4:	-0.630	1.110
5:	-0.736	0.037
6:	-0.295	-0.126
7:	-0.240	0.384
8:	-0.076	0.132
9:	0.143	-0.450
10:	0.258	0.110



TARGET APPROX 1/2 SCALE

Repair Inquiry

Repair Number: RE00069145

Serial: C6522294 Model 700 Center Fire Caliber: 7
62 NATO M/24 SWS

Repairman:

Verify Repair

Status:

New 8/25/2003 11:32:07 AM

Address Information

Customer:

Received From

Return To:

Received From

Name: 3RD BDE

3RD BDE

Address 1: BLDG 03213 FAITH AVE

BLDG 03213 FAITH AVE

Address 2: 1 LT MCCULLOUGH2539665588

PO Box:

1 LT MCCULLOUGH2539665588

PO Box:

City: FT LEWIS

FT LEWIS

State: WA

Zip Code: 98433

Country: US

State: WA

Zip Code: 98433

Country: US

FPL:

Contact / Condition

Problems

Estimate

History / Status

Shipping / Billing

Contact Information

Phone:

Fax:

Email:

Comments:

Received Condition

Good

Condition
Notes:CSR
Notes:

Accessories Received

Code	Desc	Qty
A006	Sling Strap	1
A007	With Stud	2
A010	Hard Case	1
A017	Scope Base	1
A026	Scope	1
A045	Bi Pod	1
C000	FRT AND REAR BASI	1
C001	DEPLOYMENT KIT	1

Repair Search

Refresh

Close

nagletj

8/25/2003

12:43 PM

CAPS

NUM

INS

SCPL

start

3 Micros...

Arms Servi...

Part Search...

2 Intern...

2 Micros...

CERTIFIC...

12:43 PM

Serial
Number:

C6522294

Model: 700



RE00069145

HHC 2-3 Inf
Ft. Lewis Washington

M24 SWS
SN:C6522294

Included:

M24 SWS
Leupold M3A Rifle Scope
Deployment Kit
Sling

Please refurbish M24 SWS and include complete Deployment Kit, New Rifle Sling and Harris Bipods.

PACKING LIST		PACKED BY	1. NO. BOXES	2a. REQUISITION NO.		
		SSG, LEIGH, WILLIAM	1	2b. ORDER NO.		
3. END ITEM M24SWS				4. DATE		
				5. PAGE ____ OF ____ PAGES		
BOX NO. (a)	CONTENTS - STOCK NUMBER AND NOMENCLATURE (b)	UNIT OF ISSUE (c)	QUANTITIES REQUIRED			
			INITIAL OPERATION (d)	RUNNING SPARES (e)	TOTAL (f)	
1	M24 SWS SN: C6522294	1	1		1	
	LEUPOLD M3A RIFLE SCOPE SN:90-0499	1	1		1	
	DEPLOYMENT KIT	1	1		1	
	SLING	1	1		1	
6. THIS CERTIFIES THAT ITEMS LISTED HEREON ARE WITHIN THE SPECIFIED BOXES						
TYPED NAME AND TITLE SSG LEIGH, WILLIAM HHC 2-3 INF SNIPER SECTION LEADER		SIGNATURE 				

PACKING LIST		PACKED BY	1. NO. BOXES	2a. REQUISITION NO.		
		SSG, LEIGH, WILLIAM	1	2b. ORDER NO.		
3. END ITEM M24SWS				4. DATE		
				5. PAGE ____ OF ____ PAGES		
BOX NO. (a)	CONTENTS - STOCK NUMBER AND NOMENCLATURE (b)	UNIT OF ISSUE (c)	QUANTITIES REQUIRED			
			INITIAL OPERATION (d)	RUNNING SPARES (e)	TOTAL (f)	
1	M24 SWS SN: C6522294	1	1		1	
	LEUPOLD M3A RIFLE SCOPE SN:90-0499	1	1		1	
	DEPLOYMENT KIT	1	1		1	
	SLING	1	1		1	
6. THIS CERTIFIES THAT ITEMS LISTED HEREON ARE WITHIN THE SPECIFIED BOXES						
TYPED NAME AND TITLE SSG LEIGH, WILLIAM HHC 2-3 INF SNIPER SECTION LEADER			SIGNATURE			

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

SERIAL # 0652 2294 INSPECTED BY: RTL

DATE REC'D: 8-25-03 DATE RET'D: 9-16-03

ITEM

BARREL ASSEMBLY

☒ BARREL
☒ RECEIVER
☒ FRONT SIGHT BASE
☒ REAR SIGHT BASE
☒ SCREWS
☒ FINISH

SCOPE ASSEMBLY

☒ SCOPE
☒ SCOPE RINGS
☒ MOUNTING SCREWS
☒ MOUNTING BASE
☒ SCREWS
☒ FINISH
☒ CLARITY

ITEM

STOCK ASSEMBLY

☒ STOCK
☒ SLING AWIVEL STUDS
☒ ADJUSTABLE
☒ BUTT PLATE
☒ LOCK NUTS
☒ BARREL CLEARANCE
☒ COLOR / FINISH

SYSTEMS CASE

☒ SCOPE CASE
☒ IRON SIGHTS
☒ DEPLOYMENT KIT

TRIGGER ASSEMBLY

☒ SAFETY OPERATION
☒ RE-SET TO FACTORY SPECS

COMMENTS: New Sling, B. Pod
and Deployment Kit

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

R & E NUMBER	69145		
SERIAL NUMBER	C6522294		
LOG-IN DATE	8-25-03		
INSPECT AND VERIFY:			
OPERATION #	OPERATION NAME	DATE	INITIAL
550	DIS-ASSEMBLE GUN	8-26-03	RTL
560 A	RE-BARREL	8-27-03	RTL
B	DRILL AND TAP	8-27-03	TRW
575	ASSEMBLE	8-27-03	RTL
600	PROOF	8-27-03	AC
605	CHECK HEADSPACE	8-27-03	AC
610	DIS-ASSEMBLE GUN	8-27-03	RTL
612	MAGNAFLUX		
615	ROLLMARK CALIBER	8-28-03	JB
618	ROTO-BLAST	8-29-03	JB
620	APPLY COATINGS	9-12	TA
625 A	FINAL ASSEMBLY	9-15-03	RTL
B	TRIGGER PULL TEST		
C	SAFETY "ON" FORCE		
D	SAFETY "OFF" FORCE		
E	FIRING PIN INDENT		
640	TARGET	9-16-03	TRW
655	FINAL INSPECT	9-16-03	RTL
660	PACK	9-16-03	DA
		SHIP DATE	
	QAR INSPECTION DATE		

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6522294.___0

FILE DATE AND TIME: 09/16/2003 09:55

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.051
The Average Y Centroid of the Five Target Set:	-0.033
The Average Point of Impact of the Five Target Set:	0.061
The Average Mean Radius of the Five Target Set:	0.795
The Distance from POA to Centroid Target #1:	0.230
The Distance from Centroid Target #2 to Centroid Target #1:	0.175
The Distance from Centroid Target #3 to Centroid Target #1:	0.408
The Distance from Centroid Target #4 to Centroid Target #1:	0.371
The Distance from Centroid Target #5 to Centroid Target #1:	0.371

SERIAL NUMBER: C6522294. 0

TARGET NUMBER: 1

FILE DATE: 09/16/2003

FILE TIME: 09:55

X CENTROID: -0.128

Y CENTROID: -0.191

POA TO CENTROID: 0.230

HORZ SPREAD: 2.396

VERT SPREAD: 2.010

GROUP SPREAD: 2.449

MIN RADIUS: 0.226

MAX RADIUS: 1.421

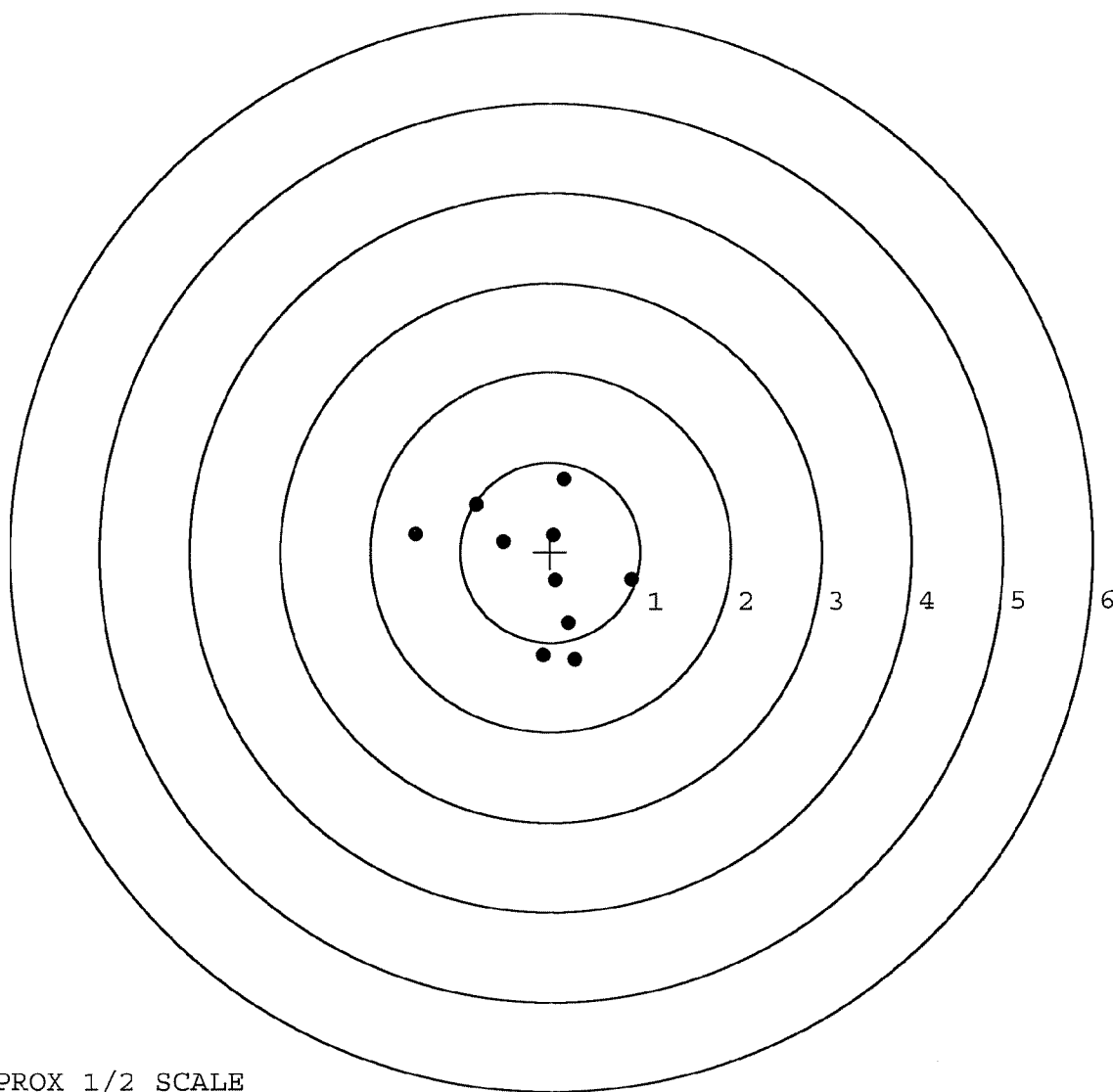
MEAN RADIUS: 0.837

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 5

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.902	-0.308
2:	0.276	-1.197
3:	-0.081	-1.153
4:	0.205	-0.787
5:	0.060	-0.318
6:	0.040	0.188
7:	0.156	0.813
8:	-0.520	0.116
9:	-0.820	0.533
10:	-1.494	0.200

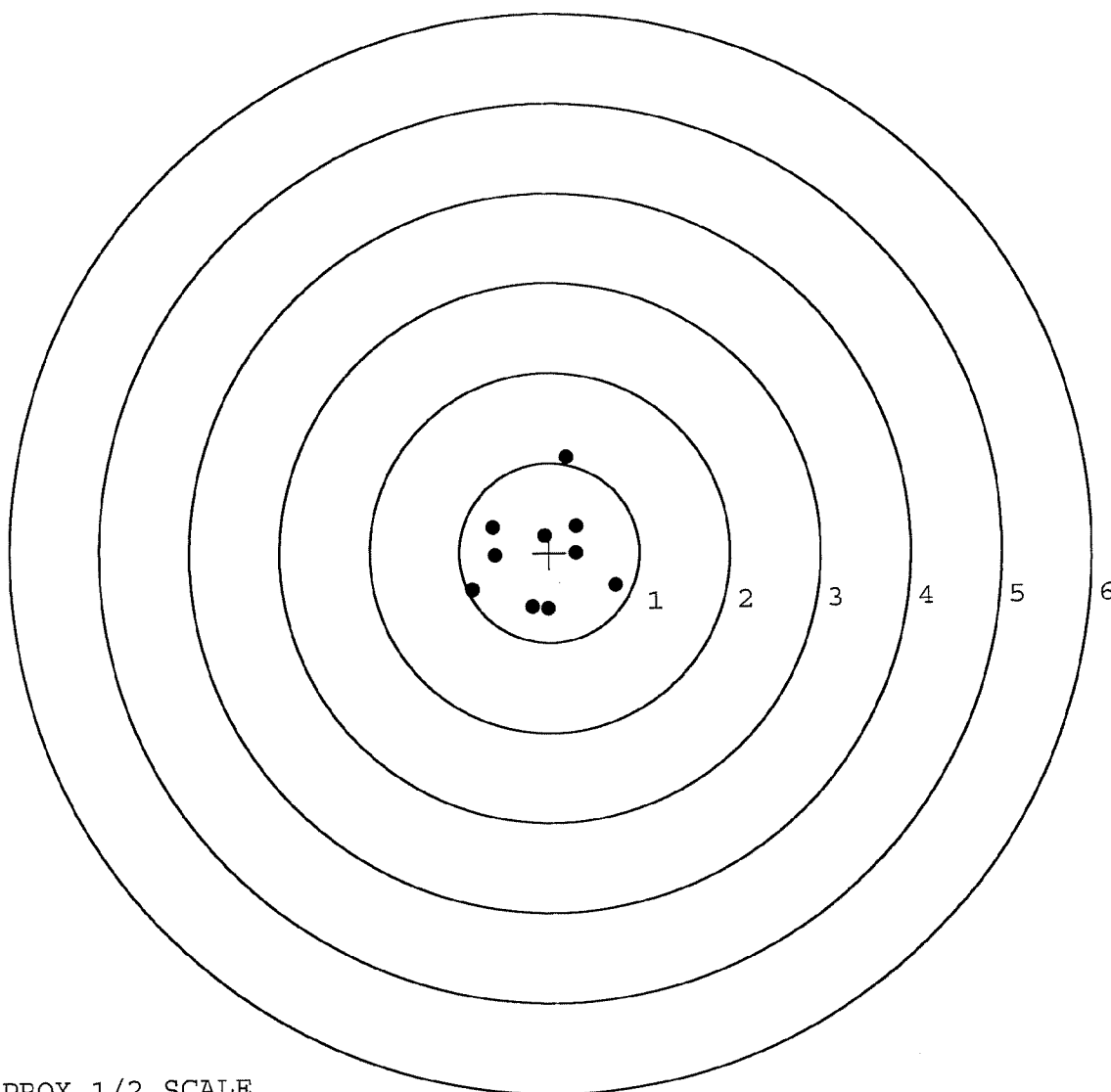


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6522294.___0
TARGET NUMBER: 2
FILE DATE: 09/16/2003
FILE TIME: 09:55

X CENTROID: -0.083
Y CENTROID: -0.023
POA TO CENTROID: 0.086
HORZ SPREAD: 1.587
VERT SPREAD: 1.688
GROUP SPREAD: 1.813
MIN RADIUS: 0.216
MAX RADIUS: 1.119
MEAN RADIUS: 0.631
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.727	-0.378
2:	-0.023	-0.628
3:	-0.196	-0.610
4:	-0.860	-0.409
5:	-0.601	-0.030
6:	-0.621	0.292
7:	0.202	1.060
8:	0.302	0.296
9:	-0.052	0.191
10:	0.296	-0.011



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6522294. __0

TARGET NUMBER: 3

FILE DATE: 09/16/2003

FILE TIME: 09:55

POINT#	X	Y
1:	1.636	-0.394
2:	1.071	-0.135
3:	0.673	0.100
4:	0.454	-0.048
5:	0.137	-0.629
6:	-0.856	0.182
7:	-0.295	0.040
8:	-0.233	0.366
9:	0.032	0.823
10:	-1.573	1.142

X CENTROID: 0.105

Y CENTROID: 0.145

POA TO CENTROID: 0.179

HORZ SPREAD: 3.209

VERT SPREAD: 1.771

GROUP SPREAD: 3.558

MIN RADIUS: 0.399

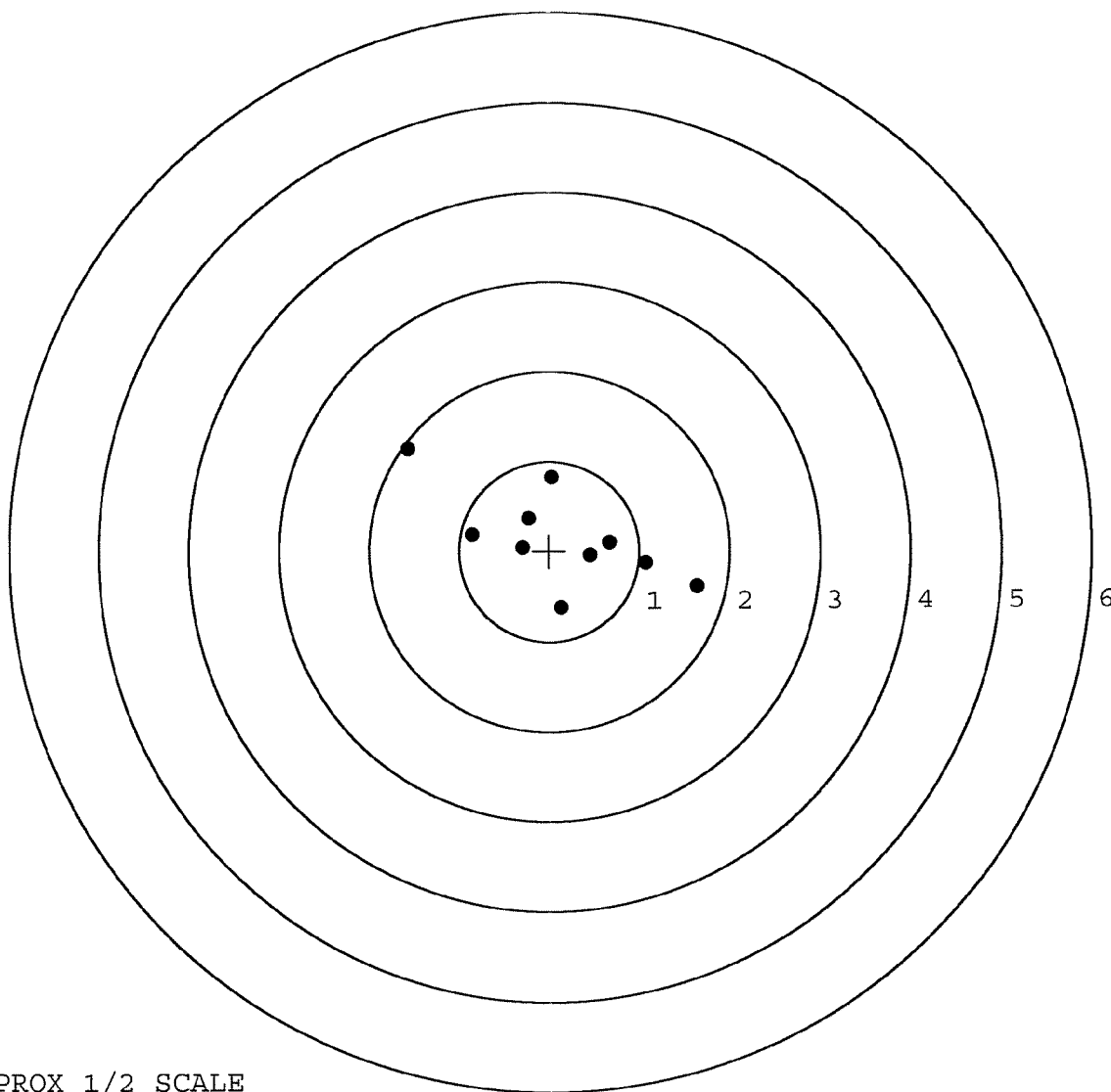
MAX RADIUS: 1.952

MEAN RADIUS: 0.878

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 8



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6522294. 0

TARGET NUMBER: 4

FILE DATE: 09/16/2003

FILE TIME: 09:55

POINT#	X	Y
1:	-1.226	-1.844
2:	0.839	-0.672
3:	0.911	0.657
4:	0.603	1.355
5:	0.214	1.567
6:	0.253	0.186
7:	0.379	-0.189
8:	-0.276	0.173
9:	-0.361	-0.041
10:	-0.181	-0.309

X CENTROID: 0.116

Y CENTROID: 0.088

POA TO CENTROID: 0.145

HORZ SPREAD: 2.137

VERT SPREAD: 3.411

GROUP SPREAD: 3.703

MIN RADIUS: 0.169

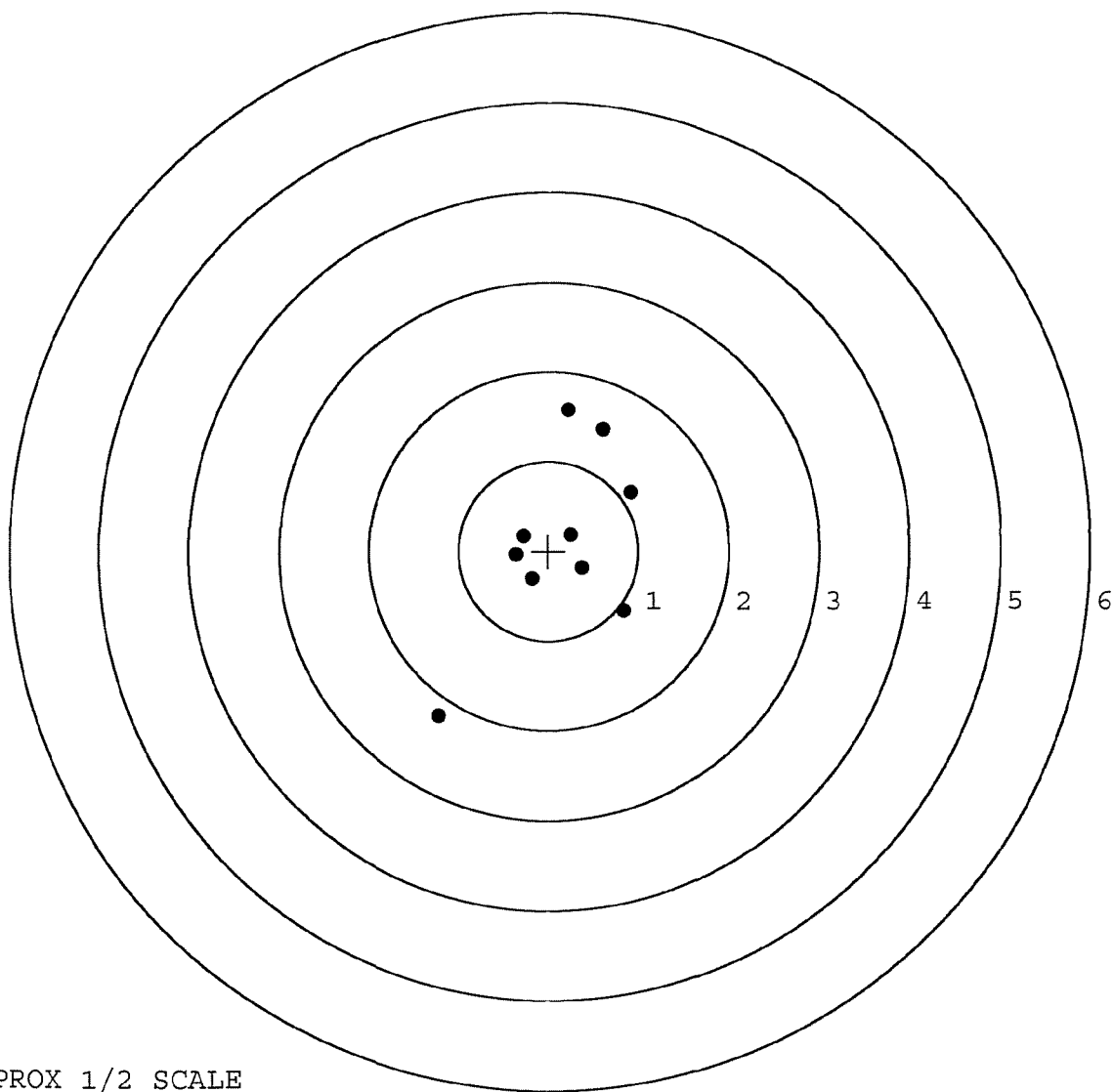
MAX RADIUS: 2.352

MEAN RADIUS: 0.916

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 9

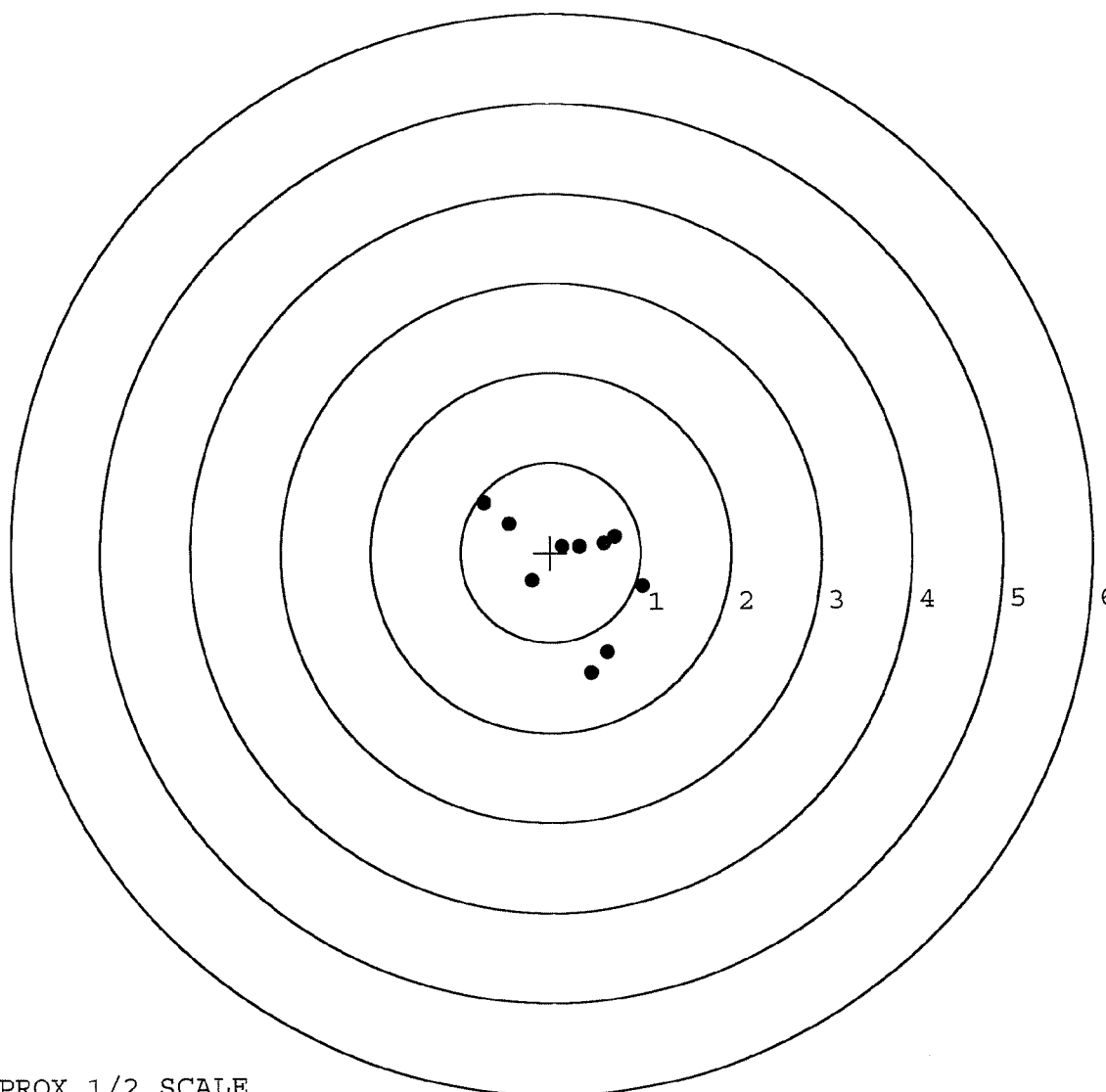


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6522294. __0
TARGET NUMBER: 5
FILE DATE: 09/16/2003
FILE TIME: 09:55

X CENTROID: 0.243
Y CENTROID: -0.185
POA TO CENTROID: 0.306
HORZ SPREAD: 1.753
VERT SPREAD: 1.896
GROUP SPREAD: 2.232
MIN RADIUS: 0.268
MAX RADIUS: 1.228
MEAN RADIUS: 0.713
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.441	-1.341
2:	0.621	-1.114
3:	1.017	-0.381
4:	0.708	0.178
5:	0.593	0.104
6:	0.326	0.069
7:	0.128	0.068
8:	-0.207	-0.317
9:	-0.460	0.325
10:	-0.736	0.555



TARGET APPROX 1/2 SCALE

Remington®

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

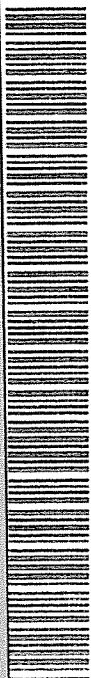
VERY IMPORTANT:
Instruction Book
enclosed to assure
safe use of this
firearm.

MODEL 700™ **N24**

SERIAL NO.
C6522294

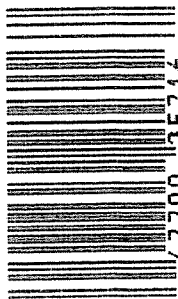
ORDER NO.
5716

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



5716 C6522294

LPC



0 47700 25716 7

MOD. _____ GA. CAL. _____ GUN # _____

#	TEST	DATE	MALFUNCTION/DEFECT	ASSEM. #
	1st		FLoor P Litch	
			Loose	
			Teak - mag Box	
	2nd		Repaired	9/10/90
				125
	3rd			
	4th			

FUNCTION _____ RD 6654 Rev 1

TEST INIT. ACTION TO CORRECT		ASSEM. #
PROOF		
TEST		
TGT		
PROOF		
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		

SWS TRIGGER PULL TEST

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

SERIAL NO. 06522294

DATE 9-19-95

TESTER DA

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#	COMMENTS
PULL #1	2.43	2.43	2.50	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.39	2.37	2.58	
PULL #3	2.55	2.35	2.67	
PULL #4	2.43	2.47	2.75	
PULL #5	2.48	2.39	2.66	
TOTAL	12.28	12.01	13.16	
AVG.	2.45	2.40	2.63	

	3.00# INITIAL	3.00# AFTER 20 CYCLES	COMMENTS
PULL #1	3.09	3.11	
PULL #2	3.04	3.11	
PULL #3	3.07	3.13	
PULL #4	3.10	3.17	
PULL #5	3.06	3.16	
TOTAL	15.36	15.68	
AVG.	3.07	3.13	

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.13	4.07	4.07	
PULL #2	4.08	4.09	4.04	
PULL #3	4.14	4.10	4.02	
PULL #4	4.16	4.02	4.06	
PULL #5	4.11	4.05	4.14	
TOTAL	20.62	20.33	20.33	
AVG.	4.12	4.06	4.06	

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6527794

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	6	5 ³ / ₄			11/27	WLB
	G) Safety Off Force	3 1/2	3 1/2	3 1/2			11/27	WLB
	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	2.47	2.48	2.48	2.47	2.47	11/27	WLB
	C) Function							
660	Pack							

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6522294

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		8/1/90	KS
600	Proof		8/1/90	KS
607	Check Headspace		8/1/90	KS
610	Dis-assemble Gun		8/1/90	KS
612	Magnaflux Barrel Action		8/6/90	KR
	Magnaflux Bolt		8/6/90	KR
615	Rollmark Caliber		8/6/90	Y.B.
617	Drill and Tap Sight Holes		8/10/90	FB
618	Polish Barrel RB		8/14/90	WB
620	Apply Coatings (Barrel Action)		8-22-90	JA
	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		9/7/90	WB

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	3 1/2	3 1/2	3 1/2			9/7/90	WB
	G) Safety Off Force	2	2	2			9/7/90	WB
	H) Trigger Pull Test & Retainability						9/7/90	WB
	I) Firing Pin Indent	.023	.023	.023			9/7/90	WB
	J) Assemble Stock						9/7/90	KS
	K) Assemble Swivel Studs						9/13/90	928
	L) Attach Front and Rear Sight Assemblies						9/7/90	KS
	M) Iron Sight Alignment						9/7/90	KS
	N) Detach Front & Rear Sights & place in numbered container						9/7/90	KS
	O) Attach Scope to Rifle						9/7/90	KS
	P) Detach & Attach Scope 20 Times						9/7/90	KS
640	Gallery Target & Test						9/10/90	KS
	A) Time						9/10/90	KS
	B) Malfunctions						9/10/90	KS
	C) Pierced Primers						9/90/90	KS
	D) Optical Clarity of Scope						9/10/90	KS
645	Inspect for Live Ammo						9/10/90	KS
655	Final Inspection							
	A) Headspace						9/13/90	928
	B) Trigger Pull	2.39	2.30	2.28	2.30	2.29	9-12-90	SM
	C) Function						9/13/90	928
660	Pack						9-18-90	SM

SWS TRIGGER PULL TEST

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

SERIAL NO. C6527294
DATE 9/7/90
TESTER WLB

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.47	2.42	2.43	2.39	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.55	2.34	2.53	2.30	
PULL #3	2.50	2.40	2.59	2.28	
PULL #4	2.30	2.32	2.53	2.30	
PULL #5	2.38	2.36	2.65	2.29	
TOTAL	12.20	11.84	12.73	11.56	
AVG.	2.40	2.37	2.54	2.312	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.07	3.11		
PULL #2	3.26	3.14		
PULL #3	3.21	3.24		
PULL #4	3.22	3.07		
PULL #5	3.13	3.23		
TOTAL	15.89	15.79		
AVG.	3.18	3.16		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.13	4.00		4.17
PULL #2	4.00	4.02		4.28
PULL #3	4.06	4.02		4.27
PULL #4	4.01	4.05		4.21
PULL #5	4.09	4.03		4.10
TOTAL	20.29	20.12		21.03
AVG.	4.06	4.02		4.21

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06522294
11 Sep 1990

CENTROIDAL DISTANCES

0 TO 1	.125419
1 TO 2	.151093
1 TO 3	.105546
1 TO 4	.0107703
1 TO 5	.345654

95 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1878
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1438
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .236532
THE AMR FOR THIS RIFLE IS: 1.273

18 Sep 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6522294

CENTERFIRE PATTERNS

1

POA

1 in circle

2 in circle

3 in circle

OF SHOTS = 10

IN CIR

1 in = 1

2 in = 4

3 in = 9

HS = 2.803

VS = 2.344

GS = 2.885

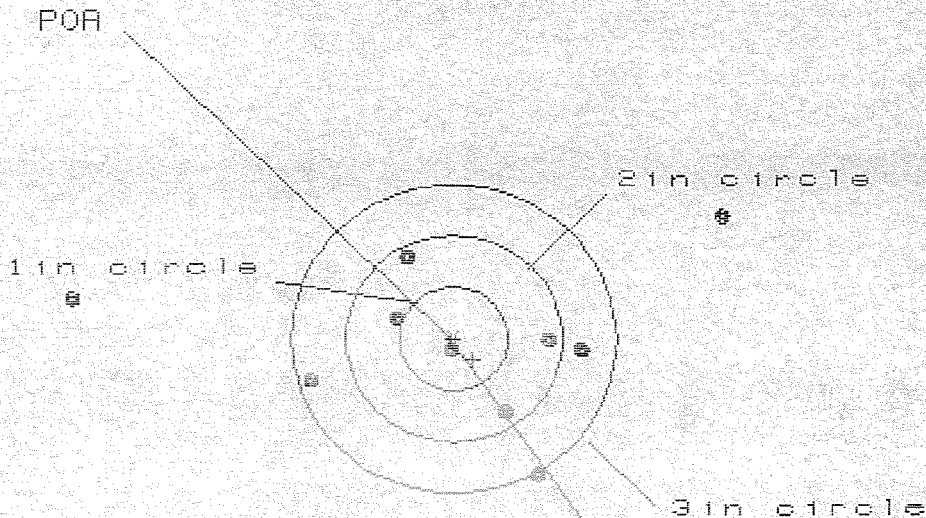
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.169	.987	.793
MINIMUM X	-1.634	-1.556	-.726
MAXIMUM Y	1.396	1.454	1.406
MINIMUM Y	-.948	-.890	-.938
CENTROID X	-.099	.083	.277
CENTROID Y	.077	.019	.067
POA TO CENTROID in.	.125	.085	.285
MIN RADIUS	.195	.383	.348
MEAN RADIUS	1.035	.943	.842
MAX RADIUS	1.714	1.603	1.413
HORIZONTAL SPREAD	2.803	2.543	1.519
VERTICAL SPREAD	2.344	2.344	2.344
EXTREME SPREAD	2.885	2.635	2.414
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	9		

10 Sep 1990

FILE:/PATTERNING/CENTERFIRE_PATT/C6522294

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 7

HS= 5.924

VS= 2.546

GS= 5.980

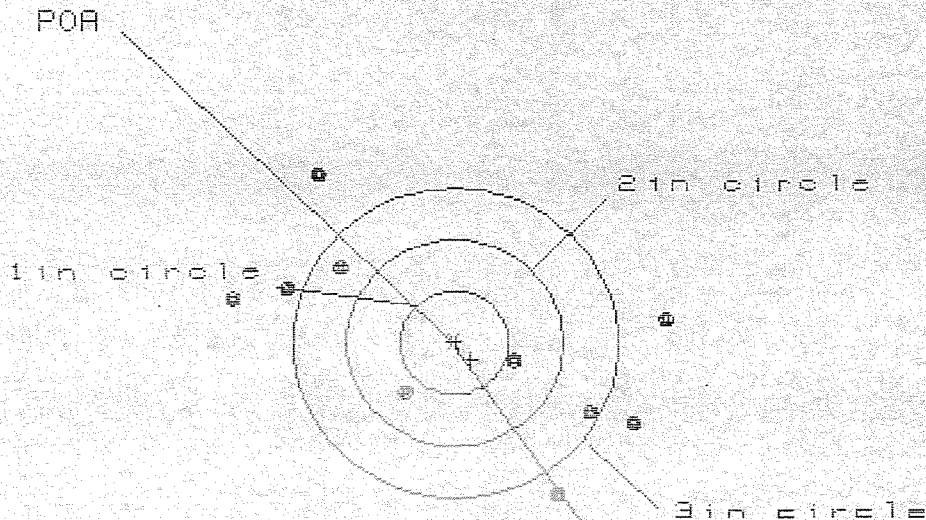
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.447	2.061	1.040
MINIMUM X	:	-3.477	-1.723	-1.466
MAXIMUM Y	:	1.211	1.255	1.025
MINIMUM Y	:	-1.335	-1.291	-1.134
CENTROID X	:	-.176	.210	-.047
CENTROID Y	:	.207	.163	.006
POA TO CENTROID in.	:	.272	.266	.048
MIN RADIUS	:	.152	.404	.141
MEAN RADIUS	:	1.369	1.109	.910
MAX RADIUS	:	3.500	2.413	1.480
HORIZONTAL SPREAD	:	5.924	3.784	2.506
VERTICAL SPREAD	:	2.546	2.546	2.159
EXTREME SPREAD	:	5.980	4.113	2.528
NUMBER IN ONE INCH CIRCLE =			1	
NUMBER IN TWO INCH CIRCLE =			5	
NUMBER IN THREE INCH CIRCLE =			7	

18 Sep 1998

FILE:/PATTERNING/CENTERFIRE_PATT/06522294

CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1 in = 0

2 in = 2

3 in = 4

HS = 3.982

VS = 3.162

GS = 3.990

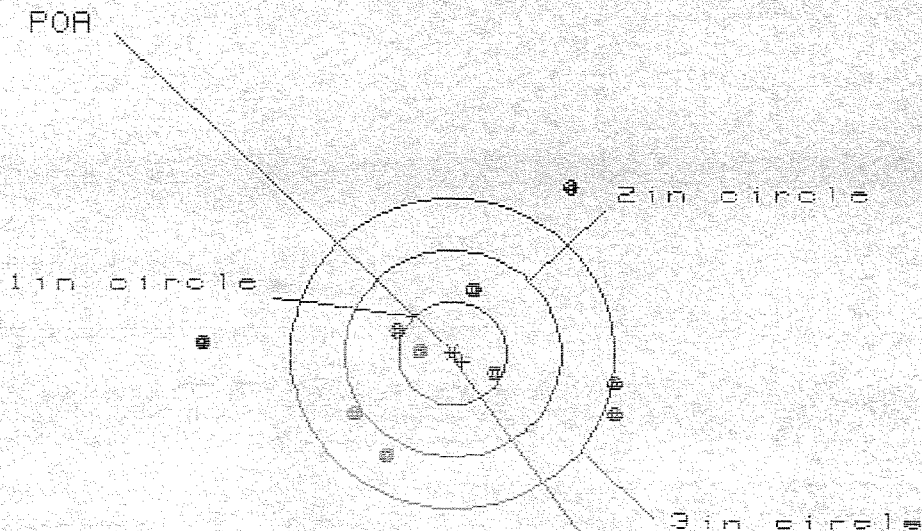
CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.920	1.691	1.589
MINIMUM X	:	-2.062	-1.739	-1.921
MAXIMUM Y	:	1.642	1.692	.983
MINIMUM Y	:	-1.520	-1.470	-1.258
CENTROID X	:	-.147	.082	.264
CENTROID Y	:	.171	.121	-.091
POA TO CENTROID in.	:	.225	.146	.280
MIN RADIUS	:	.551	.317	.183
MEAN RADIUS	:	1.522	1.427	1.271
MAX RADIUS	:	2.110	2.234	2.071
HORIZONTAL SPREAD	:	3.982	3.430	3.430
VERTICAL SPREAD	:	3.162	3.162	2.241
EXTREME SPREAD	:	3.990	3.851	3.445
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		2	
NUMBER IN THREE INCH CIRCLE	=		4	

10 Sep 1990

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CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1in = 2

2in = 4

3in = 6

HS= 3.832

VS= 2.614

GS= 3.860

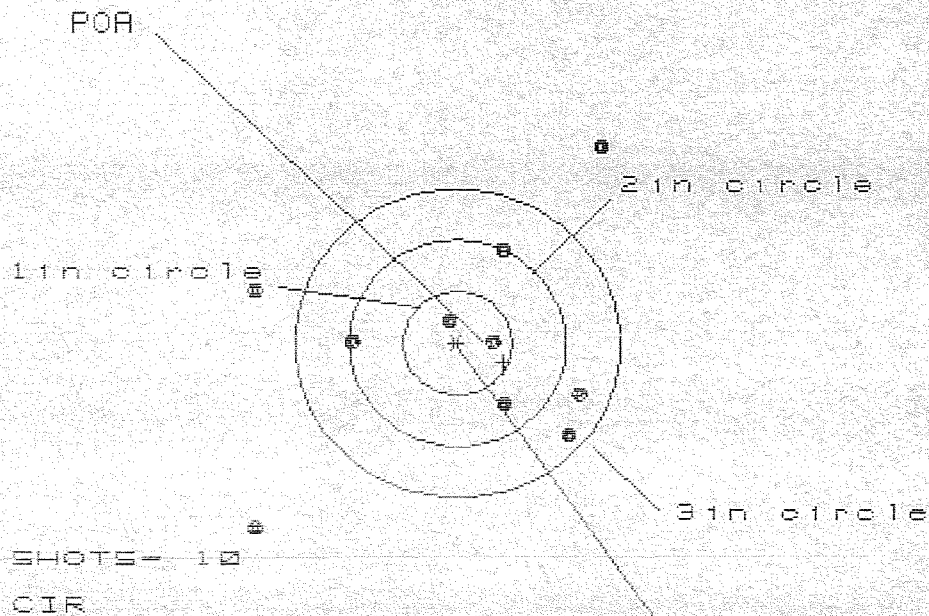
CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.538	1.284	1.392
MINIMUM X	:	-2.293	-1.153	-1.045
MAXIMUM Y	:	1.605	1.623	.817
MINIMUM Y	:	-1.009	-.991	-.788
CENTROID X	:	-.089	.165	.057
CENTROID Y	:	.081	.063	-.140
POA TO CENTROID in.	:	.121	.177	.151
MIN RADIUS	:	.334	.237	.253
MEAN RADIUS	:	1.161	1.038	.922
MAX RADIUS	:	2.299	1.841	1.395
HORIZONTAL SPREAD	:	3.832	2.437	2.437
VERTICAL SPREAD	:	2.614	2.614	1.605
EXTREME SPREAD	:	3.860	3.162	2.449
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		6	

10 Sep 1990

FILE:/PATTERNING/CENTERFIRE_PATT/C6522294

CENTERFIRE PATTERNS # 5



OF SHOTS - 10

IN CIR

1 in = 2

2 in = 4

3 in = 7

HS = 3.241

VS = 3.640

GS = 4.874

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.337	1.125	1.071
MINIMUM X	:	-1.904	-2.086	-1.945
MAXIMUM Y	:	1.892	1.697	.960
MINIMUM Y	:	-1.748	-1.066	-.853
CENTROID X	:	-.428	-.216	-.357
CENTROID Y	:	.183	.378	.166
POA TO CENTROID in.	:	.466	.435	.393
MIN RADIUS	:	.259	.205	.297
MEAN RADIUS	:	1.276	1.094	.971
MAX RADIUS	:	2.585	2.111	2.019
HORIZONTAL SPREAD	:	3.241	3.211	3.016
VERTICAL SPREAD	:	3.640	2.763	1.813
EXTREME SPREAD	:	4.874	3.491	3.238
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		7	