

4

C6498843

77

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

File

Add Repair

Estimate Repair

Expedite Repair

Inquiry

Repair Tools

CSR Tools

Reports

Table Maintenance

System Maintenance

Help

Repair Number: RE00074630

Serial: C6498843 Model 700 Center Fire Caliber: 7

62 NATO M24 SWS Produced: 06/19/1990

Repairman:

Status: Closed 12/29/2003 10:37:53 AM

Verify Repair

Address Information

Customer:

Received From:

Return To:

Received From:

Name: HHC 3/327

HHC 3/327

Address 1:

Address 2:

PO Box:

PO Box:

City: FORT CAMPBELL

FORT CAMPBELL

State: KY Zip Code: 42223 Country: US

State: KY Zip Code: 42223 Country: US

FFL

Contact / Condition

Problems

Estimate

History / Status

Shipping / Billing

Contact Information

Received Condition

Accessories Received

Phone:

Fax:

Email:

Comments:

Fair

Condition Notes:

CSR Notes:

Code	Desc	Qty
A007	With Studs	3
A010	Hard Case	1
A017	Scope Bases	3
A026	Scope	1

Repair Search

Refresh

Close

negleij

1/5/2004

9:08 AM

CAPS

NUM

INS

3

start

Serial Number:

C6498843

Model:

700

RE00074630

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6498843.___0
FILE DATE AND TIME: 01/23/2004 09:00

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.090
The Average Y Centroid of the Five Target Set:	0.139
The Average Point of Impact of the Five Target Set:	0.166
The Average Mean Radius of the Five Target Set:	0.495
The Distance from POA to Centroid Target #1:	0.260
The Distance from Centroid Target #2 to Centroid Target #1:	0.186
The Distance from Centroid Target #3 to Centroid Target #1:	0.183
The Distance from Centroid Target #4 to Centroid Target #1:	0.077
The Distance from Centroid Target #5 to Centroid Target #1:	0.269

SERIAL NUMBER: C6498843. __0

TARGET NUMBER: 1

FILE DATE: 01/23/2004

FILE TIME: 09:00

POINT#	X	Y
1:	1.044	0.754
2:	0.950	0.443
3:	0.452	-0.007
4:	0.648	-0.178
5:	0.270	-0.333
6:	-0.315	-0.787
7:	-0.713	-0.509
8:	0.055	0.419
9:	-0.025	0.747
10:	-0.192	0.886

X CENTROID: 0.217

Y CENTROID: 0.143

POA TO CENTROID: 0.260

HORZ SPREAD: 1.757

VERT SPREAD: 1.673

GROUP SPREAD: 2.164

MIN RADIUS: 0.279

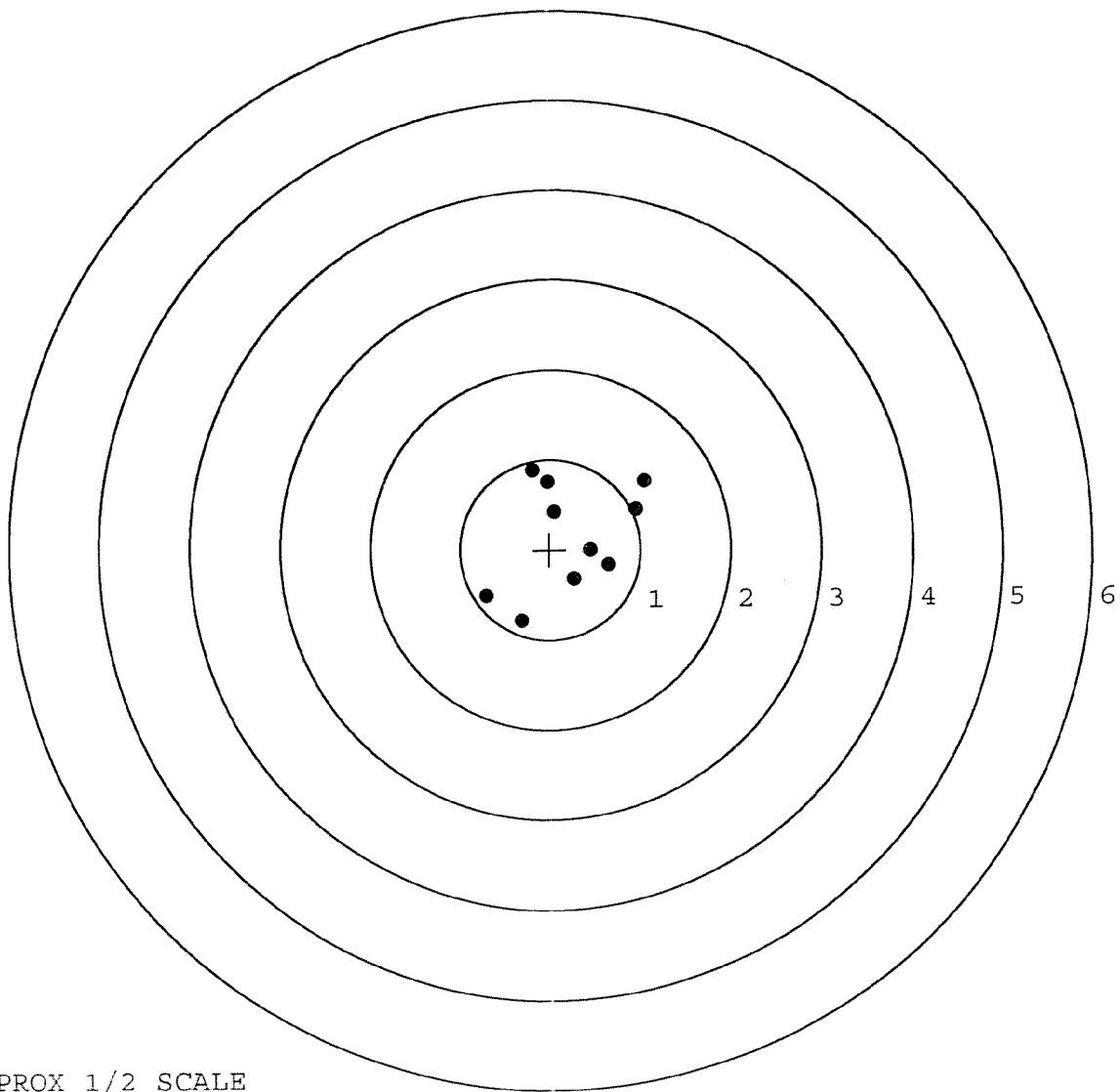
MAX RADIUS: 1.136

MEAN RADIUS: 0.714

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6498843. __ 0

TARGET NUMBER: 2

FILE DATE: 01/23/2004

FILE TIME: 09:00

POINT#	X	Y
1:	-0.558	0.294
2:	-0.292	-0.243
3:	-0.107	0.189
4:	0.261	-0.344
5:	0.252	-0.067
6:	0.395	0.103
7:	0.184	0.089
8:	0.274	-0.027
9:	0.075	0.163
10:	0.234	0.118

X CENTROID: 0.072

Y CENTROID: 0.028

POA TO CENTROID: 0.077

HORZ SPREAD: 0.953

VERT SPREAD: 0.638

GROUP SPREAD: 1.038

MIN RADIUS: 0.128

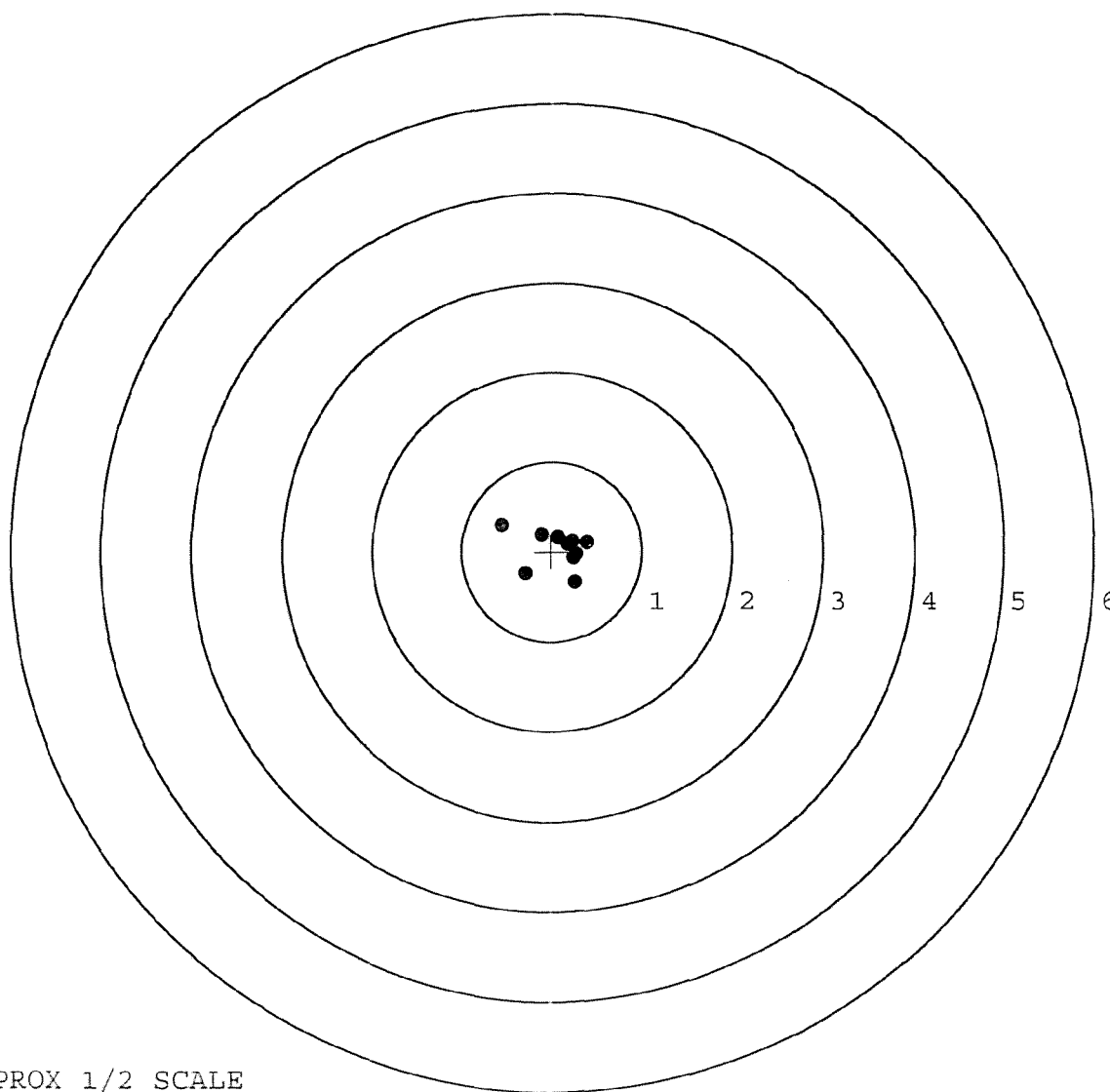
MAX RADIUS: 0.684

MEAN RADIUS: 0.299

IN 1 IN DIAMETER: 9

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10

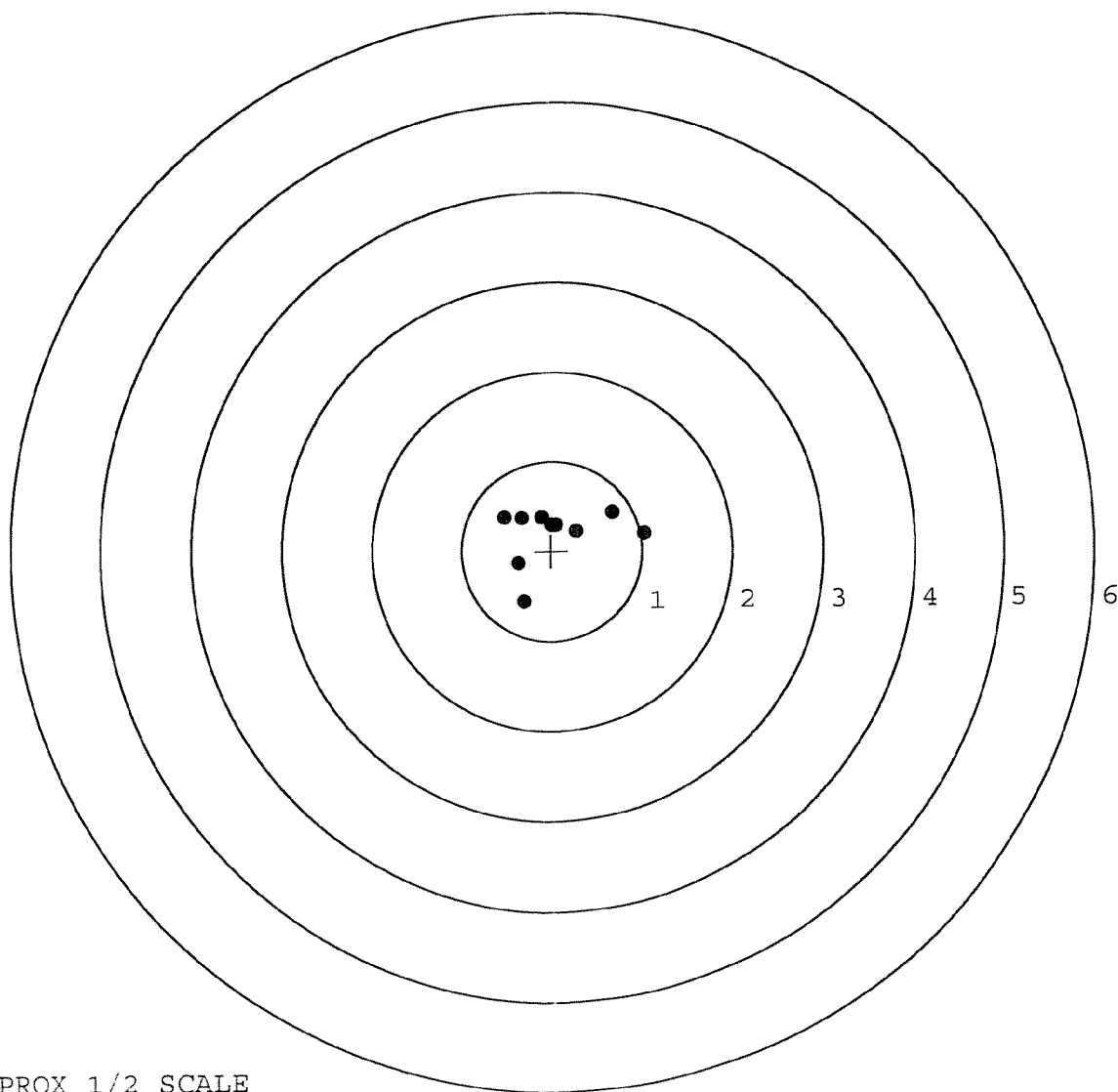


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6498843. __0
TARGET NUMBER: 3
FILE DATE: 01/23/2004
FILE TIME: 09:00

POINT#	X	Y
1:	0.675	0.424
2:	1.025	0.188
3:	-0.313	-0.565
4:	-0.368	-0.138
5:	-0.523	0.379
6:	-0.331	0.372
7:	-0.108	0.376
8:	-0.004	0.288
9:	0.278	0.217
10:	0.054	0.292

X CENTROID: 0.038
Y CENTROID: 0.183
POA TO CENTROID: 0.187
HORZ SPREAD: 1.548
VERT SPREAD: 0.989
GROUP SPREAD: 1.560
MIN RADIUS: 0.110
MAX RADIUS: 0.987
MEAN RADIUS: 0.473
IN 1 IN DIAMETER: 5
IN 2 IN DIAMETER: 10
in 3 IN DIAMETER: 10

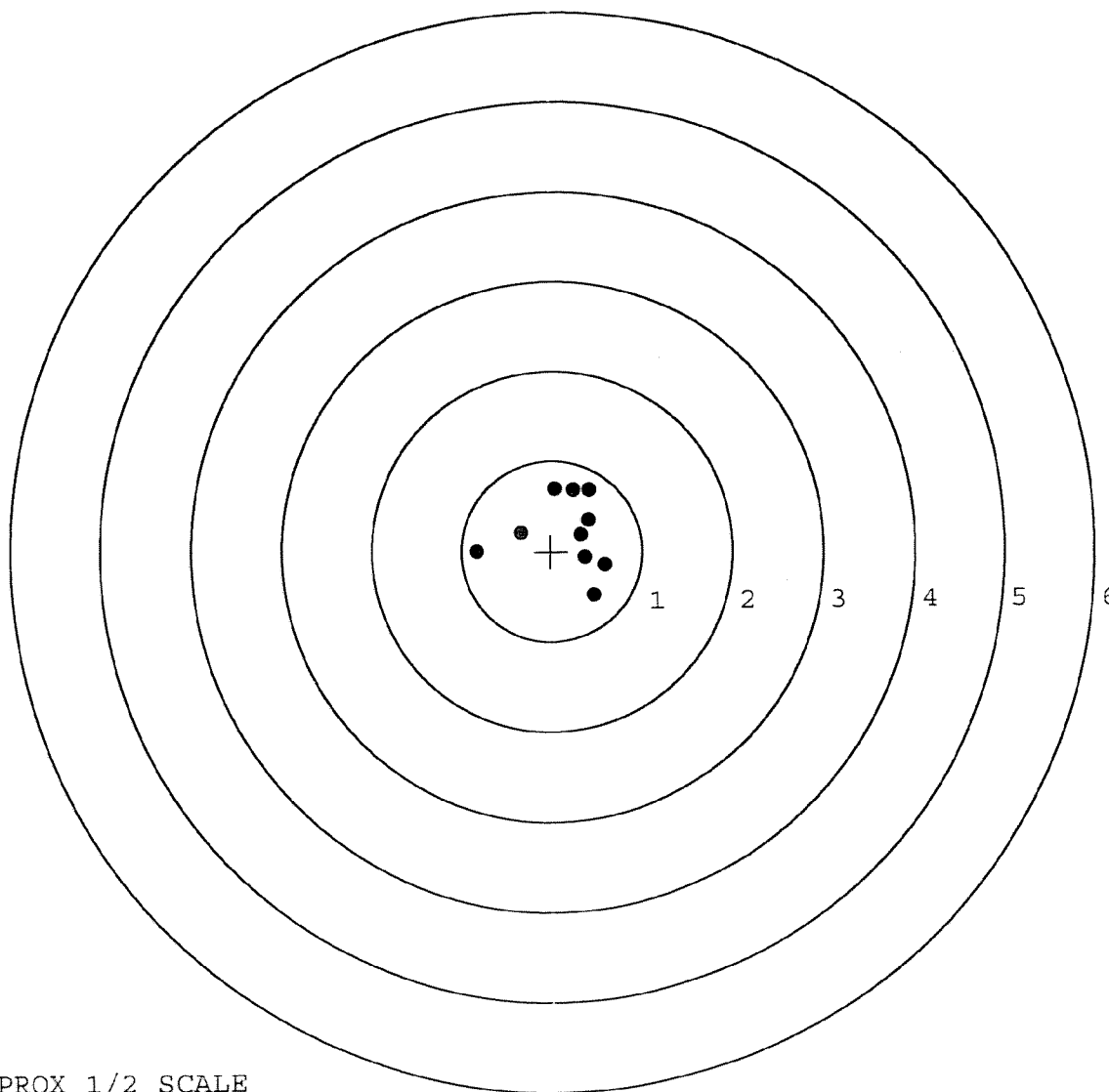


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6498843. __0
TARGET NUMBER: 4
FILE DATE: 01/23/2004
FILE TIME: 09:00

X CENTROID: 0.173
Y CENTROID: 0.207
POA TO CENTROID: 0.270
HORZ SPREAD: 1.420
VERT SPREAD: 1.179
GROUP SPREAD: 1.429
MIN RADIUS: 0.160
MAX RADIUS: 1.025
MEAN RADIUS: 0.513
IN 1 IN DIAMETER: 5
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.334	0.212
2:	-0.832	0.006
3:	0.470	-0.491
4:	0.588	-0.158
5:	0.376	-0.071
6:	0.331	0.182
7:	0.415	0.344
8:	0.421	0.676
9:	0.253	0.679
10:	0.046	0.688

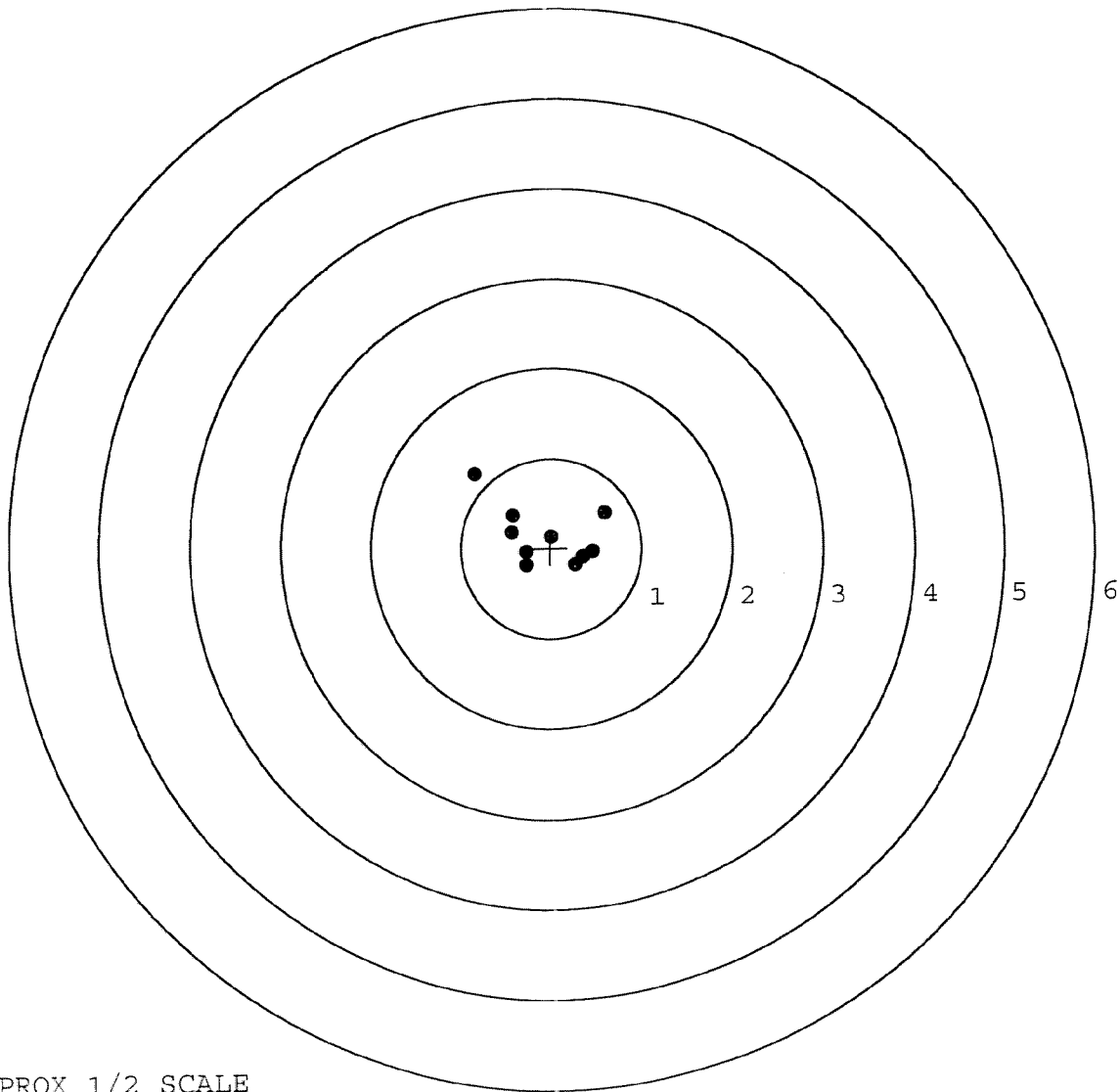


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6498843. __0
TARGET NUMBER: 5
FILE DATE: 01/23/2004
FILE TIME: 09:00

POINT#	X	Y
1:	0.598	0.392
2:	0.462	-0.043
3:	0.272	-0.187
4:	0.009	0.130
5:	-0.834	0.836
6:	-0.273	-0.189
7:	-0.268	-0.044
8:	-0.429	0.184
9:	-0.414	0.368
10:	0.359	-0.102

X CENTROID: -0.052
Y CENTROID: 0.135
POA TO CENTROID: 0.144
HORZ SPREAD: 1.432
VERT SPREAD: 1.025
GROUP SPREAD: 1.566
MIN RADIUS: 0.061
MAX RADIUS: 1.051
MEAN RADIUS: 0.477
IN 1 IN DIAMETER: 7
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

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

R & E NUMBER	074630		
SERIAL NUMBER	C6498843		
LOG-IN DATE	12-29-03		
INSPECT AND VERIFY:			
OPERATION #	OPERATION NAME	DATE	INITIAL
550	DIS-ASSEMBLE GUN	1-5-04	RW
560 A	RE-BARREL	1-7-04	RTL
B	DRILL AND TAP	1-9-04	TRW
575	ASSEMBLE	1-8-04	RTL
600	PROOF	1-8-04	RW
605	CHECK HEADSPACE	1-8-04	RW
610	DIS-ASSEMBLE GUN	1-8-04	RW
612	MAGNAFLUX	1-8-04	RW
615	ROLLMARK CALIBER	1-13-04	RB
618	ROTO-BLAST	1/13/2004	Don S.
620	APPLY COATINGS	1-15	TA
625 A	FINAL ASSEMBLY	1-17-04	RW
B	TRIGGER PULL TEST		
C	SAFETY "ON" FORCE		
D	SAFETY "OFF" FORCE		
E	FIRING PIN INDENT		
640	TARGET	1-23-04	AC
655	FINAL INSPECT	1-27-04	RTL
660	PACK	1-27-04	RW
		SHIP DATE	
	QAR INSPECTION DATE		

Remington
 MODEL 700™ H24

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

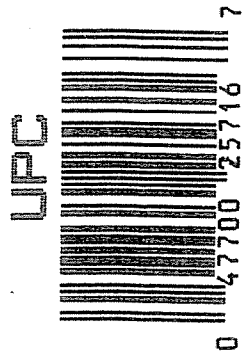
REG. U.S. PAT. & TM. OFF.

SERIAL NO. C6498843

ORDER NO. 5716

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

01



Bco

81B

MAINTENANCE REQUEST				PAGE NO. 1	NO. OF PAGES 1	REQUIREMENTS CONTROL SYMBOL CSGLD - 1047(R1)			
For use of this form, see DA PAM 738-750; the proponent agency is DCSLOG									
SECTION I - EQUIPMENT DATA									
CONTROL NUMBER		WORK ORDER NO.		WESDC		ORG. PD		PD AUTHENTICATION X	
☐ Work Request ☐ MWO ☒ Warranty Claim		1A. ORGANIZATION Dco 3/5		B. LOCATION Ft. Campbell KY 42223			C. UNIT IDENT CODE WHOGPO		
2. SERIAL NO. C6498843		3. NOUN NOMENCLATURE 7.62 mm Sniper Weapon M24		4. LINE NO.		5. MODEL		6. NATIONAL STOCK NUMBER 1005-01-240-2136	
7A. MAINTENANCE ACTIVITY IMG		B. LEVEL O		8. UTILIZATION CODE O		9A. MCSR ITEM		9B. ERC	
						9C. PACING ITEM		10. HOURS	
								11. MIKES	
								12. ROUNDS	
								13. STARTS	
14. FAILURE DETECTED DURING (Select one - use ✓ or X)					15. FIRST INDICATION OF TROUBLE (Select one - use ✓ or X)				
☐ A Sch. Main. ☐ C Test ☐ E Storage ☐ G Flight ☐ B Handling ☐ D Normal Op. ☐ F Inspection ☒ H Other					☐ 058 Inoperative ☐ 258 Overheating ☐ 799 Out of Adjustment ☐ 008 Noisy ☐ 387 Low Performance ☒ Other				
16A. DESCRIBE DEFICIENCIES OR SYMPTOMS ON THE BASIS OF COMPLETE CHECKOUT AND DIAGNOSTIC PROCEDURE IN EQUIPMENT TM (Do not prescribe repairs) 5,100 Rnds Fired									
B. REMARKS W 554095345 H246									
PREPARATION INSTRUCTIONS (Prior to using this form, read DA PAM 738-750 for detailed preparation instructions)									
1. Place a "✓" or an "X" in the box for the type of action required. 2. Enter the WESDC if the item is Materiel Condition Status Reportable. 3. Enter the priority designator as determined from the urgency of need and force activity designator. 4. The Unit Commander, Chief of TDA activity or their designated representative will authenticate, by signature, a priority of 01 through 08. 5. Block 1A. Enter the name of the organization submitting the request. 6. Block 1B. Enter the unit submitting the request; units overseas enter APO only. 7. Block 1C. Enter the unit identification code of the unit in block 1A. 8. Block 2. Enter the equipment serial number. For ammunition, enter the lot number. For administrative-use vehicles, enter the USA registration number. 9. Block 3. Enter the noun abbreviation of the item. 10. Block 4. Enter the item line number, if applicable. 11. Block 5. Enter the model number. 12. Block 6. Enter the National Stock Number of the item listed in Block 3.					13. Block 7. Enter the name of the support activity. 14. Block 7A. Enter the symbol of the maintenance category (O, F, H, D, or L). 15. Block 8. Enter the utilization code. 16. Block 9A. Enter the word "yes" if the item is Materiel Condition Status Reportable. 17. Block 9B. Enter the equipment readiness code, if applicable. 18. Block 9C. Enter the word "yes" if the item is a pacing item. 19. Block 10. Enter the hour reading, if applicable. 20. Block 11. Enter the mileage from the odometer, if applicable. 21. Block 12. Enter the total rounds fired, if applicable. 22. Block 13. For turbine engines, enter the number of hot starts. 23. Block 14. Enter a "✓" or "X" in the proper block. 24. Block 15. Enter a "✓" or "X" in the proper block. 25. Block 16. Describe briefly the fault or symptoms needing correction.				
23. SUBMITTED BY [Signature]		24. RECEIVED BY							
JULIAN DATE		JULIAN DATE							

Bco 81B

MAINTENANCE REQUEST					PAGE NO 1	NO OF PAGES 1	REQUIREMENTS CONTROL SYMBOL CSGLD - 1047(R1)	
For use of this form, see DA PAM 738-750; the proponent agency is DCSLOG								
SECTION I - EQUIPMENT DATA								
CONTROL NUMBER		WORK ORDER NO.		WESDC		ORG PD		PD AUTHENTICATION X
☐ Work Request ☐ MWO ☒ Warranty Claim		1A. ORGANIZATION Dco 3/5		B. LOCATION Ft. Campbell KY 42223			C. UNIT IDENT CODE WH06PO	
2. SERIAL NO. 66498843		3. NOUN NOMENCLATURE 7.62 mm Sniper Weapon M24		4. LINE NO.		5. MODEL		6. NATIONAL STOCK NUMBER 1005-01-240-2136
7A. MAINTENANCE ACTIVITY IMO		B. LEVEL 0	8. UTILIZATION CODE 0	9A. MCSR ITEM	9B. ERC	9C. PACING ITEM	10. HOURS	11. MILES
								12. ROUNDS
								13. STARTS
14. FAILURE DETECTED DURING (Select one - use ☒ or X)					15. FIRST INDICATION OF TROUBLE (Select one - use ☒ or X)			
☐ A Sch. Main. ☐ C Test ☐ E Storage ☐ G Flight ☐ B Handling ☐ D Normal Op ☐ F Inspection ☒ H Other					☐ 068 Inoperative ☐ 258 Overheating ☐ 799 Out of Adjustment ☐ 008 Noisy ☐ 387 Low Performance ☒ Other			
16A. DESCRIBE DEFICIENCIES OR SYMPTOMS ON THE BASIS OF COMPLETE CHECKOUT AND DIAGNOSTIC PROCEDURE IN EQUIPMENT TM (Do not prescribe repairs). S, 100 RUDS FIRED								
B. REMARKS W 564095345 H 246								
SECTION II - WORK ACCOMPLISHED								
17A. REPAIR ORGANIZATION/ACTIVITY				C. UNIT IDENT. CODE		18. TYPE ORGANIZATION/ACTIVITY ACCOMPLISHING WORK (Select one - use ☒ or X)		19. AMS ACCT. CODE
B. LOCATION						☐ 1 TOE ☐ 2 TD ☐ 3 Contractor		
20A. ACT. CODE	B. FAILURE CODE	C. COMPONENT/PART NOUN, SVC, OR MWO NO.			D. MANHOURS (Hrs. & tenths)	E. NATIONAL STOCK NUMBER	F. PART SOURCE CODE	G. QTY.
		(1) CB CODE	(2) REF DESIGN	(3) MFR. CODE				
					.			\$
					.			\$
					.			\$
					.			\$
					.			\$
					.			\$
					.			\$
					.			\$
					.			\$
					.			\$
					.			\$
					I. TOTAL MANHOURS	J. TOTAL MANHOURS COST \$	K. TOTAL PARTS COST \$	
21. DELAY (Select One)					22. Data Transcribed			
☐ 1 Parts ☐ 2 Manpower ☐ 3 Facilities ☐ 4 Funds ☐ 5 Tools								
23. SUBMITTED BY <i>Joseph H. Hant</i>		24. RECEIVED BY		25. WORK STARTED BY		26. INSPECTED BY		27. ACCEPTED BY
JULIAN DATE		JULIAN DATE		JULIAN DATE		JULIAN DATE		JULIAN DATE
					28. DISPOSITION (Select One)			
					☐ A To User ☐ D Evacuated ☐ B To Stock ☐ E Cannibalization ☐ C Salvaged			

RECEIVING AND ESTIMATING REPORT

COMMENTS

ORDER
R 95-30890

INITIAL CUSTOMER ORDER NO.

W/LEUPOLD 10X SCOPE

Scope #89-0996

DATE RECEIVED
12/01/95DATE OPENED
12/05/95

DATE CODE

SERIAL NUMBER
C6498843

NEW SERIAL NUMBER

MODEL AND GRADE
700 7.62

NATO

ACCESSORIES HARD CASE SCOPE MNTS SCOPE BASE

FROM:

SHIP TO:

TRANSPORTATION OFFICE
FT CAMPBELL

KY 42223

TRANSPORTATION OFFICE
FT CAMPBELLKY
42223

CUST NO: 087942 C.O.D.L.

ACCOUNT NUMBER

ACCOUNT NUMBER N/C

WRITE ☐

PROM. DATE

ESTIMATED

VIA

UPS

GUN CONDITION

- ☐ NEW
☐ LIGHTLY WORN
☐ WORN
☐ VERY WORN
☐ UNREPAIRABLE
☐ MARRED

REPAIR CHARGE

EXCISE

TAX

INSURANCE

UPS

PARCEL POST

TOTAL

CUSTOMER CONCERN

AMMO

FUNCTION

FINISH

ACCURACY

FIT

INSPECT

CYCLE

A1

B1

TRIGGER GROUP

B2

E1

F1

BOLT ASSY.

B3

E2

F2

BARREL ASSY.

B4

D1

E3

F3

REC. ASSY.

B5

D2

E4

F4

WOOD

C1

D3

E5

F5

METAL

C2

MAIN FAULT

PARTS

COMMENTS

Barrel - 96003
Stock - 96018Repauder Coat Trigger Guard
Assy, front & rear sight bases
Re-zinc Scope Base, Rings &
Swivel StudsScope sent back to Vendor
to be checked

REPAIRMAN

PROOF

CLEAN

TEST

TARGET

PATTERN

GALLERY TESTER

DATE

DATE

DATE

DATE

DATE

OFFICE COPY

RD9925 REV. 1/84

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

M2400008817

Transportation Office

Fort Campbell, Ky 42223-5129

Gun Serial #	Scope Serial #	Rings & Base	Iron Sights	Deployment Kit	Soft Carrying Case	Sling	Hard Case	☒
C6498843	0996	✓					✓	
C6349024	0934	✓					✓	
C6498732	0992	✓					✓	
C6498729	0882	Scope Rings No Base					✓	
C6498878	0671	✓					✓	
C6498766	0989	✓					✓	
C6498734	0702	✓					✓	
C6349121	0655	✓					✓	
C6349106	0951	✓					✓	
C6498786	0872	✓					✓	
C6498848	0986	✓					✓	
C6498872	0899	✓					✓	
C6349184	0991	✓					✓	
C6498862	0987	✓					✓	
C6498757	0953	✓					✓	
C6349073	0556	✓					✓	
C6349005	0653	✓					✓	
C6348995	1362	✓					✓	

Final Inspection

Sn: C1498843

DATE REC'D: 12/04/95

DATE RET'D:

AUDITOR: *AW*

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:

CONTRACT # DAAA21-87-C-0086

New Barrel
Stock

GUN SERIAL # C6498843

OP. #	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and Stock		12/21/95	RW
600	Proof		12/21/95	RW
607	Check Headspace		12/21/95	RW
610	Dis-assemble Gun		12/21/95	RW
612	Magnaflux Barrel Action			
	Magnaflux Bolt			
615	Rollmark Caliber			
617	Drill and Tap Sight Holes			
618	Polish Barrel			
620	Apply Coatings (Barrel Action)			
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		1/5/96	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		1/5/96	RW
	C) Inspect Ejector Hole for Chamfer		1/5/96	RW
	D) Oil Firing Pin Ass'y		1/5/96	RW
	E) Adjust Trigger Pull to Min Setting and Stake			

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force							
	G) Safety Off Force							
	H) Trigger Pull Test & Retainability							
	I) Firing Pin Indent							
	J) Assemble Stock						1/5/96	RW
	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						1/9/96	RW
	A) Time							
	B) Malfunctions							
	C) Pierced Primers							
	D) Optical Clarity of Scope							
645	Inspect for Live Ammo						1/9/96	RW
655	Final Inspection						1/10/96	RW
	A) Headspace						1/10/96	RW
	B) Trigger Pull	2.90	2.62	2.69	2.61	2.68	1/10/96	RW
	C) Function						1/10/96	RW
660	Pack							

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06498843
7 Jan 1988

CENTROIDAL DISTANCES

0 TO	1	1.15154
1 TO	2	.395373
1 TO	3	.426414
1 TO	4	.588743
1 TO	5	.153013

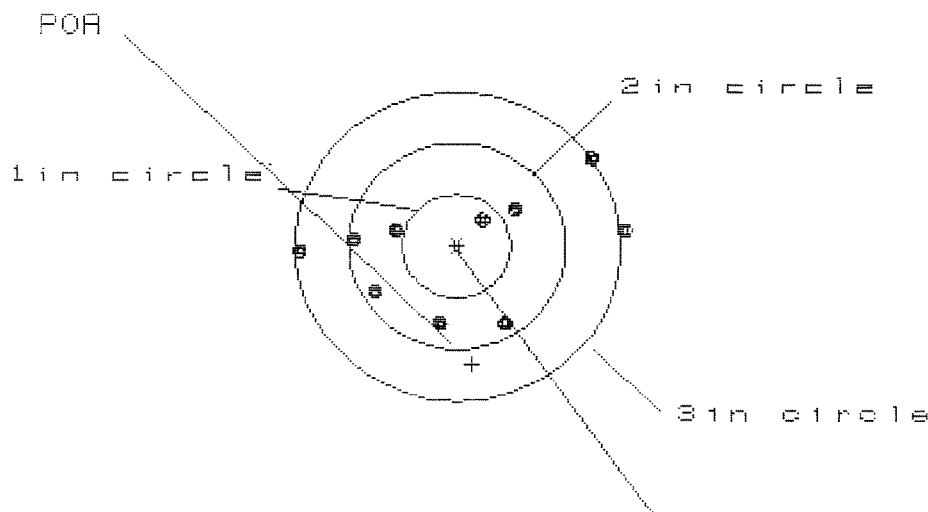
S₁ 2
+ 3
+ C----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0946
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .9408
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .945544
THE AMP FOR THIS RIFLE IS: 1.083

7 Jan 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C6498843

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 7

3 in = 9

HS= 2.917

VS= 1.639

GS= 2.926

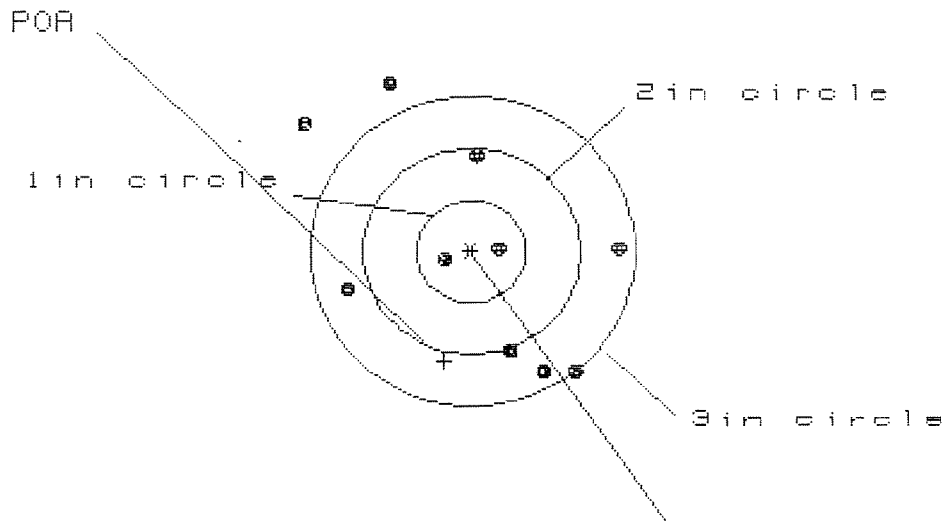
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.506	1.367	.887
MINIMUM X	-1.411	-1.244	-1.073
MAXIMUM Y	.893	.916	.505
MINIMUM Y	-.745	-.723	-.609
CENTROID X	-.140	-.307	-.478
CENTROID Y	1.143	1.121	1.007
POA TO CENTROID in.	1.152	1.163	1.115
MIN RADIUS	.362	.466	.385
MEAN RADIUS	.954	.879	.752
MAX RADIUS	1.519	1.646	1.078
HORIZONTAL SPREAD	2.917	2.611	1.960
VERTICAL SPREAD	1.639	1.639	1.114
EXTREME SPREAD	2.926	2.771	2.001
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	9		

7 Jan 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C649B843

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 2

2in = 3

3in = 7

HS= 2.810

VS= 2.820

GS= 3.476

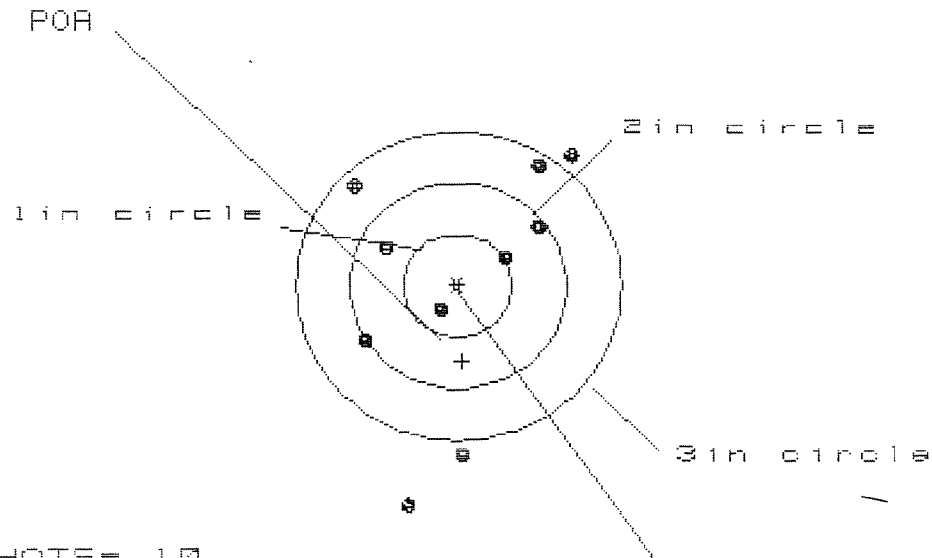
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.308	1.141	1.029
MINIMUM X	:	-1.502	-1.291	-1.403
MAXIMUM Y	:	1.620	1.756	1.262
MINIMUM Y	:	-1.200	-1.064	-1.845
CENTROID X	:	.248	.415	.527
CENTROID Y	:	1.067	.931	.712
POA TO CENTROID in.	:	1.096	1.020	.886
MIN RADIUS	:	.266	.174	.363
MEAN RADIUS	:	1.159	1.049	.922
MAX RADIUS	:	1.938	1.970	1.403
HORIZONTAL SPREAD	:	2.810	2.432	2.432
VERTICAL SPREAD	:	2.820	2.820	2.107
EXTREME SPREAD	:	3.476	3.300	2.463
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	3		
NUMBER IN THREE INCH CIRCLE	=	7		

7 Jan 1900

FILE:/PATTERNING/CENTERFIRE_PATT/C649B843

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1 in = 2

2 in = 4

3 in = 7

HS= 1.958

VS= 3.366

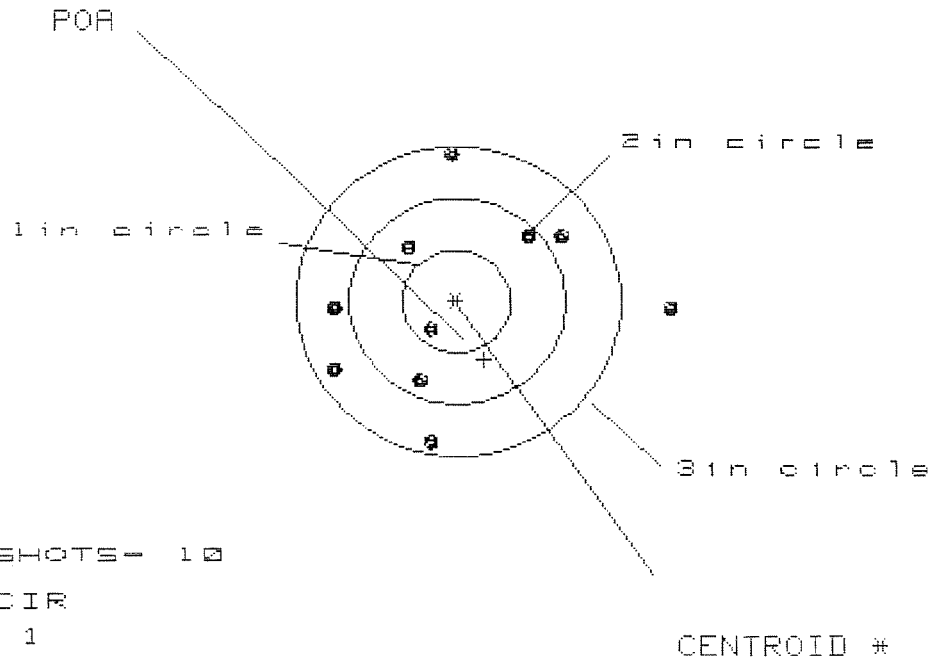
GS= 3.652

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.008	.963	.962
MINIMUM X	:	-.950	-.995	-.996
MAXIMUM Y	:	1.231	.993	.764
MINIMUM Y	:	-2.135	-1.839	-1.014
CENTROID X	:	-.042	.003	.004
CENTROID Y	:	.728	.966	1.196
POA TO CENTROID in.	:	.730	.966	1.196
MIN RADIUS	:	.277	.380	.436
MEAN RADIUS	:	1.156	1.018	.905
MAX RADIUS	:	2.174	1.839	1.367
HORIZONTAL SPREAD	:	1.958	1.958	1.958
VERTICAL SPREAD	:	3.366	2.832	1.777
EXTREME SPREAD	:	3.652	2.994	2.586
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	4		
NUMBER IN THREE INCH CIRCLE	=	7		

7 Jan 1988

FILE:/PATTERNING/CENTERFIRE_PATT/08498843

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 4

3 in = 9

HS= 3.076

VS= 2.828

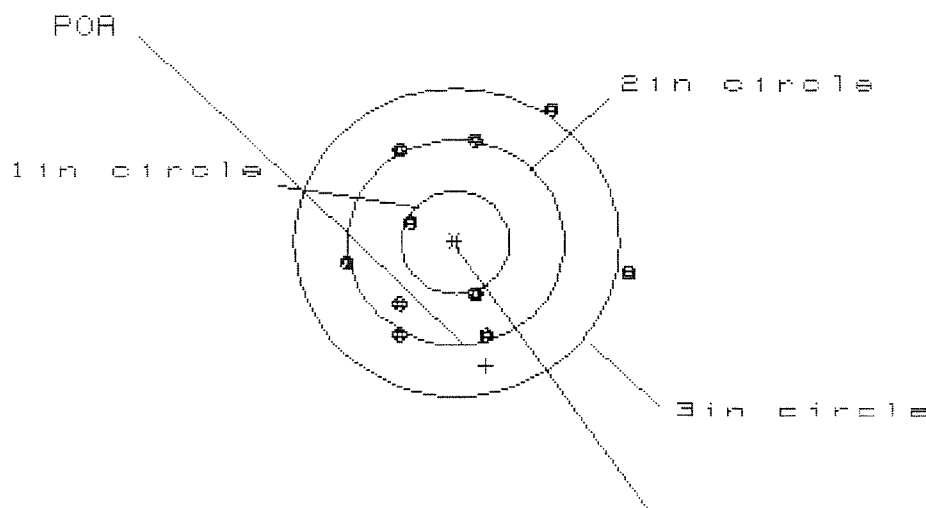
GS= 3.119

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.917	1.187	1.211
MINIMUM X	:	-1.159	-.945	-.921
MAXIMUM Y	:	1.467	1.460	.804
MINIMUM Y	:	-1.361	-1.368	-1.186
CENTROID X	:	-.257	-.471	-.495
CENTROID Y	:	.566	.573	.391
POA TO CENTROID in.	:	.622	.742	.631
MIN RADIUS	:	.353	.287	.188
MEAN RADIUS	:	1.127	1.006	.912
MAX RADIUS	:	1.919	1.473	1.454
HORIZONTAL SPREAD	:	3.076	2.132	2.132
VERTICAL SPREAD	:	2.828	2.828	1.990
EXTREME SPREAD	:	3.119	2.840	2.495
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		9	

7 Jan 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C6498843

CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1in = 1

2in = 4

3in = 8

HS= 2.611

VS= 2.221

GS= 2.611

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.570	1.046	.551
MINIMUM X	:	-1.041	-.866	-.735
MAXIMUM Y	:	1.288	1.259	1.148
MINIMUM Y	:	-.933	-.962	-.805
CENTROID X	:	-.282	-.457	-.588
CENTROID Y	:	1.200	1.229	1.072
POA TO CENTROID in.	:	1.233	1.312	1.223
MIN RADIUS	:	.427	.267	.343
MEAN RADIUS	:	1.015	.923	.801
MAX RADIUS	:	1.592	1.636	1.231
HORIZONTAL SPREAD	:	2.611	1.912	1.286
VERTICAL SPREAD	:	2.221	2.221	1.953
EXTREME SPREAD	:	2.611	2.604	2.041
NUMBER IN ONE INCH CIRCLE =	:		1	

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6498843

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	5 9	90	RW
600	Proof	5 9	90	RW
607	Check Headspace	5 9	90	RW
610	Dis-assemble Gun	5 9	90	RW
612	Magnaflux Barrel Action	5-15-90		HeR
	Magnaflux Bolt	5-15-90		HeR
615	Rollmark Caliber	5-15-90		GS
617	Drill and Tap Sight Holes		5/17/90	FB
618	Polish Barrel RB		5/17/90	WB
620	Apply Coatings (Barrel Action)		5-25-90	TA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		5/25/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/25/90	RW
	C) Inspect Ejector Hole for Chamfer		5/25/90	RW
	D) Oil Firing Pin Ass'y		5/25/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		4/7/90	RM

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5 1/2	5 1/2	5 1/2			6/8/90	WB
	G) Safety Off Force	2 1/4	2 1/4	2 1/4			6/8/90	WB
	H) Trigger Pull Test & Retainability						6/7/90	RL
	I) Firing Pin Indent	.0245	.0245	.0245			6/7/90	WB
	J) Assemble Stock						6/8/90	RW
	K) Assemble Swivel Studs						6/15/90	RL
	L) Attach Front and Rear Sight Assemblies						6/8/90	RW
	M) Iron Sight Alignment						6/8/90	RW
	N) Detach Front & Rear Sights & place in numbered container						6/8/90	RW
	O) Attach Scope to Rifle						6/8/90	WB
	P) Detach & Attach Scope 20 Times						6/8/90	WB
640	Gallery Target & Test						6-8-90	DA
	A) Time						6-8-90	DA
	B) Malfunctions						6-8-90	DA
	C) Pierced Primers						6-8-90	DA
	D) Optical Clarity of Scope						6-8-90	DA
645	Inspect for Live Ammo						6-8-90	DA
655	Final Inspection							
	A) Headspace						6/15/90	RL
	B) Trigger Pull	2.50	2.48	2.38	2.49	2.57	6/14/90	RL
	C) Function						6/15/90	RL
660	Pack						6-20-90	D/H

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

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

SERIAL NO. C6498843

DATE 6/7/90

TESTER gll

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.35	2.33	2.14	2.50	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.31	2.17	2.55	2.48	
PULL #3	2.34	2.50	2.37	2.38	
PULL #4	2.30	2.44	2.54	2.49	
PULL #5	2.14	2.29	2.26	2.51	
TOTAL	11.44	11.73	11.86		
AVG.	2.288	2.346	2.372		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.34	3.21		
PULL #2	3.25	3.36		
PULL #3	3.22	3.43		
PULL #4	3.18	3.28		
PULL #5	3.15	3.34		
TOTAL	16.14	16.62		
AVG.	3.228	3.324		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.38	4.31		4.37
PULL #2	4.39	4.10		4.52
PULL #3	4.30	4.24		4.30
PULL #4	4.36	4.32		4.20
PULL #5	4.32	4.50		4.50
TOTAL	21.75	21.47		21.89
AVG.	4.35	4.294		4.378

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6498843
8 Jun 1990

CENTROIDAL DISTANCES

0 TO	1	2.14867
1 TO	2	1.94594
1 TO	3	1.89813
1 TO	4	2.57184
1 TO	5	2.06663

1

SP 9 4 <----FOR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .4032
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .432
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .590927
THE AMR FOR THIS RIFLE IS: .8262

8 Jun 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C8498843

CENTERFIRE PATTERNS

1

FOR

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS= 10

IN CIR

1 in = 2

2 in = 6

3 in = 9

HS= 2.665

VS= 2.194

ES= 2.872

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.474	.818	.690
MINIMUM X	:	-1.191	-1.028	-.939
MAXIMUM Y	:	.964	.904	.787
MINIMUM Y	:	-1.230	-1.290	-1.407
CENTROID X	:	.535	.372	.500
CENTROID Y	:	2.081	2.141	2.258
FOR TO CENTROID in.	:	2.149	2.173	2.312
MIN RADIUS	:	.130	.273	.309
MEAN RADIUS	:	.980	.923	.827
MAX RADIUS	:	1.568	1.389	1.412
HORIZONTAL SPREAD	:	2.665	1.846	1.629
VERTICAL SPREAD	:	2.194	2.194	2.194
EXTREME SPREAD	:	2.872	2.451	2.342
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

8 Jun 1998

FILE:/PATTERNING/CENTERFIRE_PATT/06498843

CENTERFIRE PATTERNS

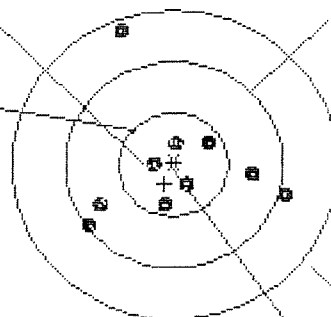
2

POA

1in circle

2in circle

3in circle



OF SHOTS- 10

IN CIR

1in = 5

2in = 8

3in = 10

HS= 1.885

VS= 1.902

GS= 2.201

CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.068	1.017	.834
MINIMUM X	:	-.817	-.868	-.741
MAXIMUM Y	:	1.340	.393	.381
MINIMUM Y	:	-.562	-.414	-.426
CENTROID X	:	.080	.131	.004
CENTROID Y	:	.189	.041	.053
POA TO CENTROID in.	:	.206	.137	.053
MIN RADIUS	:	.178	.042	.170
MEAN RADIUS	:	.642	.544	.477
MAX RADIUS	:	1.415	1.022	.855
HORIZONTAL SPREAD	:	1.885	1.885	1.575
VERTICAL SPREAD	:	1.902	.807	.807
EXTREME SPREAD	:	2.201	1.911	1.656
NUMBER IN ONE INCH CIRCLE	=		5	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	

8 Jun 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C649B843

CENTERFIRE PATTERNS

3

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 2

2in = 8

3in = 9

HS= 1.850

VS= 2.396

GS= 2.439

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.869	.852	.872
MINIMUM X	:	-.981	-.998	-.978
MAXIMUM Y	:	.613	.415	.244
MINIMUM Y	:	-1.783	-1.363	-.376
CENTROID X	:	.513	.530	.510
CENTROID Y	:	.183	.381	.552
POA TO CENTROID in.	:	.545	.653	.751
MIN RADIUS	:	.313	.313	.155
MEAN RADIUS	:	.868	.711	.593
MAX RADIUS	:	1.790	1.373	.995
HORIZONTAL SPREAD	:	1.850	1.850	1.850
VERTICAL SPREAD	:	2.396	1.778	.620
EXTREME SPREAD	:	2.439	1.996	1.865
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	

8 Jun 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6498843

CENTERFIRE PATTERNS

4

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS- 10

IN CIR

1 in = 3

2 in = 7

3 in = 10

HO = 2.185

VO = 1.590

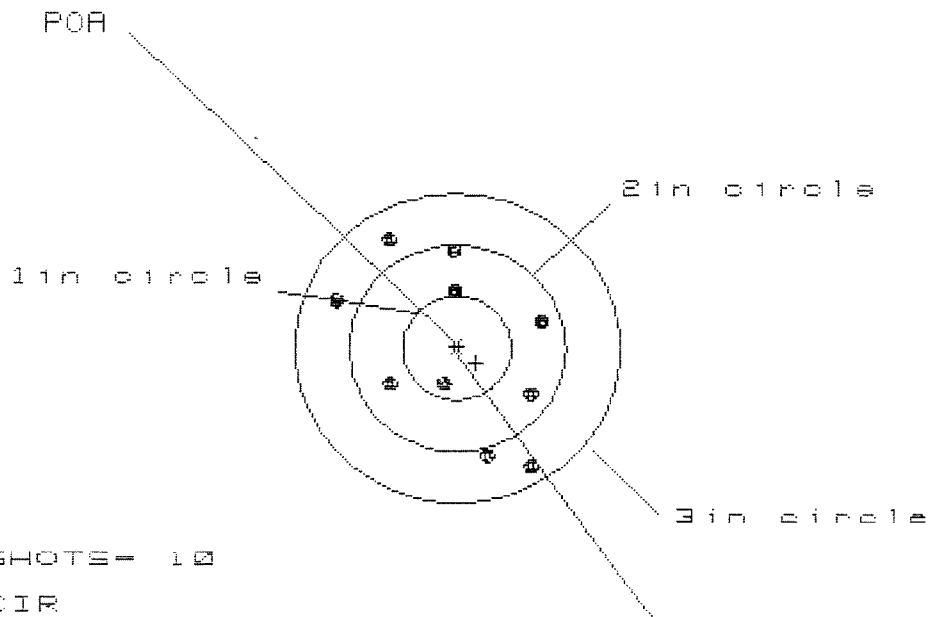
GO = 2.438

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.971	.836	.740
MINIMUM X	:	-1.214	-.768	-.464
MAXIMUM Y	:	1.037	1.103	1.044
MINIMUM Y	:	-.553	-.487	-.349
CENTROID X	:	1.068	1.203	1.299
CENTROID Y	:	-.435	-.501	-.639
POA TO CENTROID in.	:	1.153	1.303	1.448
MIN RADIUS	:	.045	.195	.170
MEAN RADIUS	:	.740	.662	.549
MAX RADIUS	:	1.354	1.344	1.112
HORIZONTAL SPREAD	:	2.185	1.604	1.284
VERTICAL SPREAD	:	1.590	1.590	1.393
EXTREME SPREAD	:	2.438	2.208	1.732
NUMBER IN ONE INCH CIRCLE =			3	
NUMBER IN TWO INCH CIRCLE =			7	
NUMBER IN THREE INCH CIRCLE =			10	

8 Jun 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6496843

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 1

2in = 6

3in = 10

HS= 1.879

VS= 2.245

GS= 2.594

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.809	.883	.813
MINIMUM X	:	-1.070	-.996	-1.066
MAXIMUM Y	:	1.063	.931	.895
MINIMUM Y	:	-1.182	-1.152	-1.035
CENTROID X	:	-.180	-.254	-.184
CENTROID Y	:	.142	.274	.157
POA TO CENTROID in.	:	.230	.373	.242
MIN RADIUS	:	.356	.475	.370
MEAN RADIUS	:	.901	.843	.862
MAX RADIUS	:	1.356	1.217	1.149
HORIZONTAL SPREAD	:	1.879	1.879	1.879
VERTICAL SPREAD	:	2.245	2.083	1.930
EXTREME SPREAD	:	2.594	2.291	2.017
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	