C6225269

MODEL 700™ M24

Model 700 M24™

Action

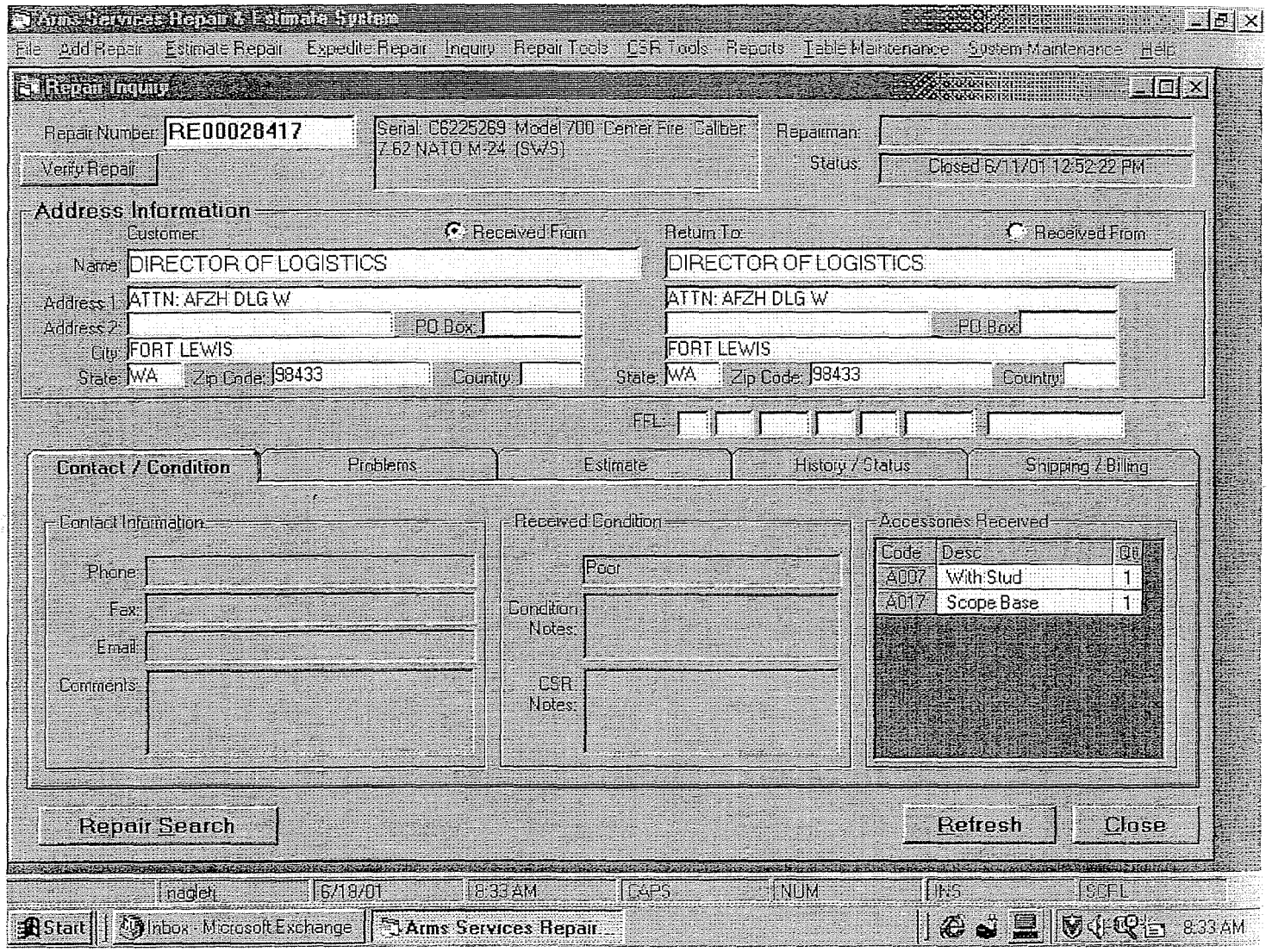
Barrel Length

Capacity

Order No. 5716

*Includes 1 in chamber.

Remington



Number: C6225269

Model: 700

RE00028417

Remington Test Lab, Ilion, N.Y.

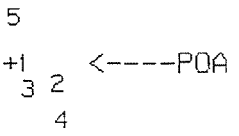
Centroidal distance calculations for Rifle # c6225269
28 Jun 2001

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1772
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0786
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .19385

THE AMR FOR THIS RIFLE IS: .9968

CENTROIDAL DISTANCES

0	TO	1	.0871436
1	TO	2	.271582
1	TO	3	.186271
1	TO	4	.46513
1	TO	5	.307319



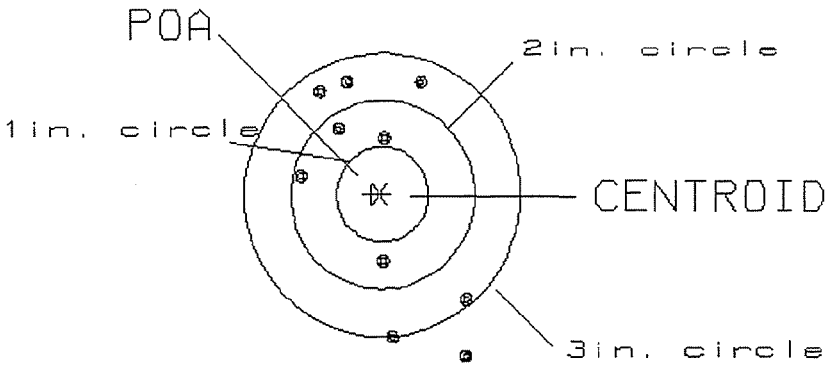
REMINGTON CENTERFIRE ACCURACY TEST REMINGTON TEST LAB, ILION, N.Y.

PATTERN #: □ 1 □

POA TO CENTROID:		.087
MIN RADIUS	:	.591
MEAN RADIUS	:	1.175
MAX RADIUS	:	1.949
CENTROID X	:	.087
CENTROID Y	:	.005

28 Jun 2001 FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6225269

CENTERFIRE PATTERN # 1



# OF SHOTS= 10	# IN CIRCLE
HS= 1.81	0
VS= 2.95	4
GS= 3.24	9

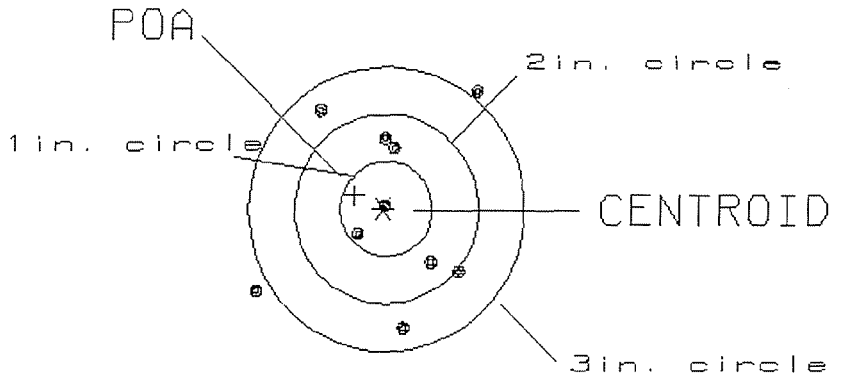
REMINGTON CENTERFIRE ACCURACY TEST REMINGTON TEST LAB, ILION, N.Y.

PATTERN #: □ 2 □

POA TO CENTROID:		.346
MIN RADIUS	:	.007
MEAN RADIUS	:	.936
MAX RADIUS	:	1.679
CENTROID X	:	.316
CENTROID Y	:	-.141

28 Jun 2001 FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6225269

CENTERFIRE PATTERN # 2



# OF SHOTS= 10	# IN CIRCLE
HS= 2.43	2
VS= 2.49	5
GS= 3.21	8

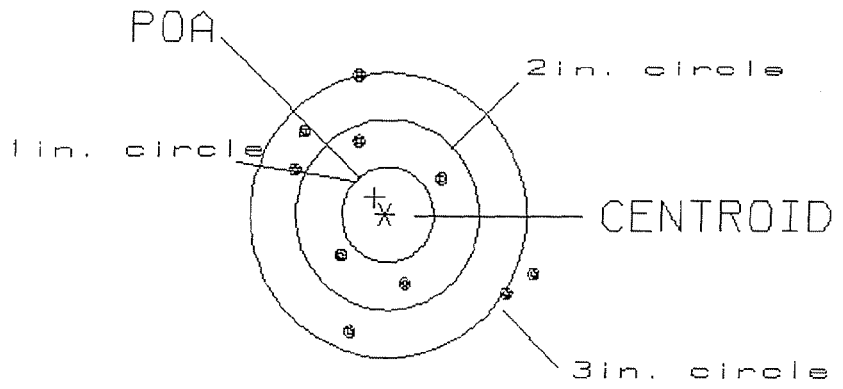
REMINGTON CENTERFIRE ACCURACY TEST REMINGTON TEST LAB, ILION, N.Y.

PATTERN #: ☐ 3 ☐

POA TO CENTROID:		.213
MIN RADIUS	:	.630
MEAN RADIUS	:	1.128
MAX RADIUS	:	1.678
CENTROID X	:	.116
CENTROID Y	:	-.179

28 Jun 2001 FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6225269

CENTERFIRE PATTERN # 3



# OF SHOTS= 10	# IN CIRCLE
HS= 2.59	0
VS= 2.70	4
GS= 2.87	7

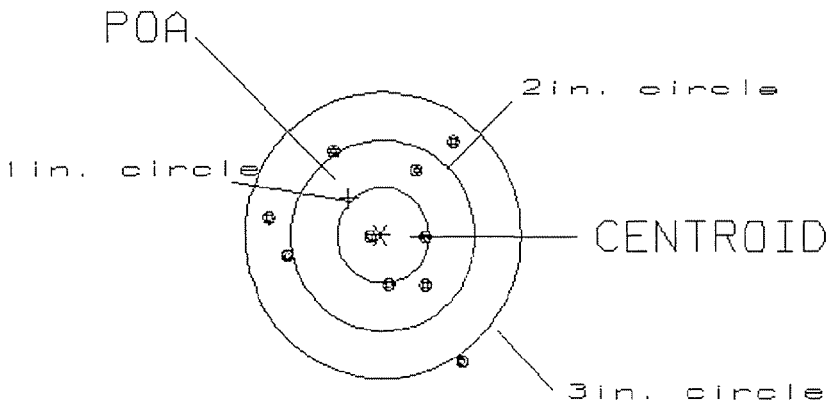
REMINGTON CENTERFIRE ACCURACY TEST REMINGTON TEST LAB, ILION, N.Y.

PATTERN #: □ 4 □

POA TO CENTROID:		.514
MIN RADIUS	:	.115
MEAN RADIUS	:	.848
MAX RADIUS	:	1.528
CENTROID X	:	.342
CENTROID Y	:	-.384

28 Jun 2001 FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6225269

CENTERFIRE PATTERN # 4



# OF SHOTS= 10	# IN CIRCLE
HS= 2.11	2
VS= 2.22	6
GS= 2.57	9

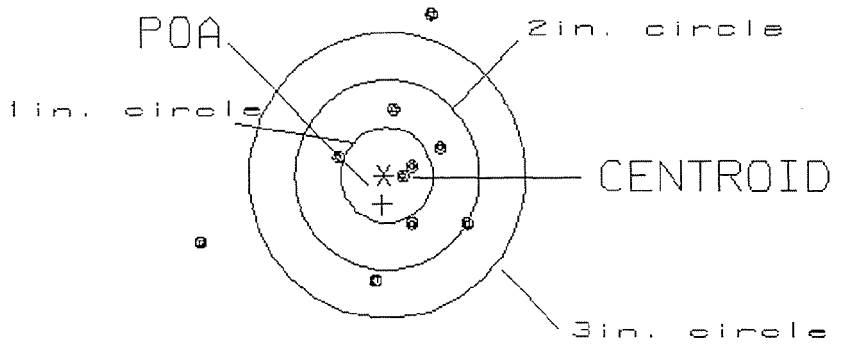
REMINGTON CENTERFIRE ACCURACY TEST REMINGTON TEST LAB, ILION, N.Y.

PATTERN #: □ 5 □

POA TO CENTROID:	.307
MIN RADIUS :	.157
MEAN RADIUS :	.897
MAX RADIUS :	2.144
CENTROID X :	.025
CENTROID Y :	.306

28 Jun 2001 FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6225269

CENTERFIRE PATTERN # 5



# OF SHOTS= 10	# IN CIRCLE
HS= 2.86	2
VS= 2.77	6
GS= 3.47	8

SCOPE #
1249

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6225269

OP.#	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and stock	8	9/88	FB
600	Proof	9	9/88	RW
607	Check Headspace	9	9/88	RW
610	Dis-assemble gun		9-8-88	RW
612	Magnaflux Barrel Action		9-14-88	pfc.
	Magnaflux Bolt		9-14-88	pfc.
615	Rollmark Caliber			
617	Drill & Tap Sight Holes			
618	Polish Barrel			
620	Apply Coatings (Barrel Action)		10-31-88	TJH
	Apply Coatings (Bolt)		10-31-88	TJH
625	Final Assembly A)Clean inside of Bolt Assembly		11/2/88	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		11/2/88	RW
	C) Inspect Ejector Hole for Chamfer		11/2/88	RW

OVER

OP.#		READINGS	DATE	INITIAL
625 cont.	D) Oil Firing Pin Ass'y		11/2/88	RW
	E) Adjust Trigger Pull to Min. Setting and Stake		2 NOV 88	GS
	F) Safety on Force	5 5 5	2 NOV 88	GS
	G) Safety off Force	3 3 3	2 NOV 88	GS
	H) Trigger Pull Test & Retainabilty		2 NOV 88	GS
	I) Firing Pin Indent	.0205 .020 .0205	2 NOV 88	GS
	J) Assemble Stock		11/2/88	RW
	K) Assemble Swivel Studs		29 NOV 88	GS
	L) Attach Front & Rear Sight Assemblies		11/2/88	RW
	M) Iron Sight Alignment		11/2/88	RW
	N) Detach Front & Rear Sights & place in numbered container		11/2/88	RW
	0) Attach Scope to Rifle		11/7/88	RW
	P) Detach & Attach Scope 20 times		11/7/88	W.B.
640	Gallery Target & Test	64 R 90 C	11-8-88	AC.
	A) Optical Clearity of Scope	OK	11-8-88	AC.
645	Inspect for Live Ammo	NONE	11-8-88	AC
655	Final Inspection A) Headspace		29 NOV 88	GS
	B) Trigger Pull		29 NOV 88	GS
	C) Function		29 NOV 88	GS
660	Pack		14 Dec 88	GS

SWS TRIGGER PULL TEST

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

SERIAL NO. C6225269
DATE 2 NOV 88
TESTER RJ-S

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.30	2.22	2.20	2.41	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT-ABLE LESS THAN 2#
PULL #2	2.25	2.21	2.20	2.41	
PULL #3	2.31	2.21	2.35	2.34	
PULL #4	2.29	2.23	2.35	2.36	
PULL #5	2.29	2.23	2.29	2.35	
TOTAL	11.34	11.10	11.39	11.87	
AVG.	2.268	2.22	2.278	2.374	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.26	3.12		
PULL #2	3.25	3.23		
PULL #3	3.22	3.28		
PULL #4	3.20	3.28		
PULL #5	3.27	3.25		
TOTAL	16.18	16.16		
AVG.	3.236	3.234		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.11	3.96		4.08
PULL #2	4.12	3.95		4.19
PULL #3	4.12	4.08		4.24
PULL #4	4.15	4.04		4.22
PULL #5	4.07	4.12		4.15
TOTAL	20.57	20.15		20.88
AVG.	4.114	4.03		4.176

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6225269

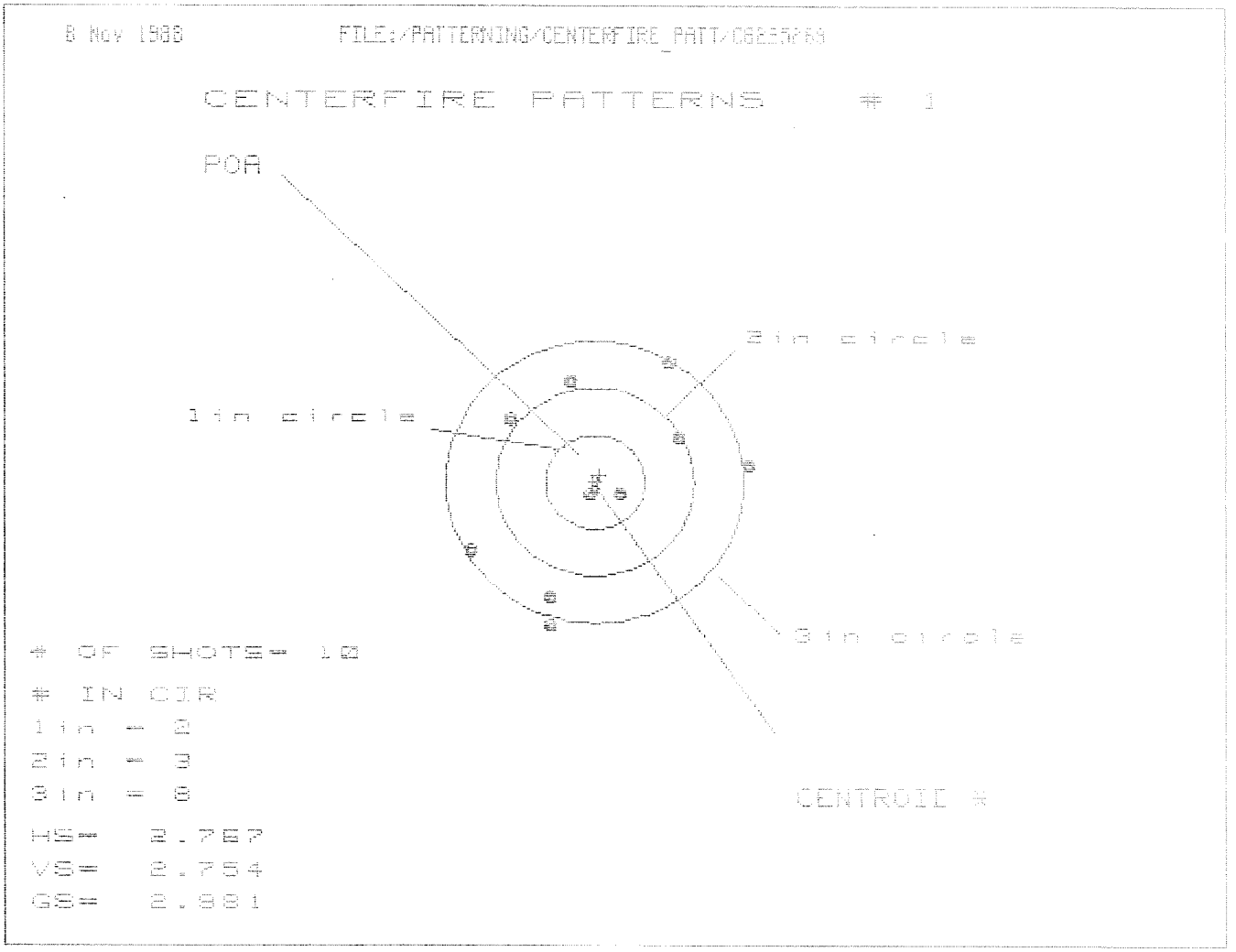
CENTROIDAL DISTANCES

0	TO	1	.0885099
1	TO	2	.351369
1	TO	3	.410278
1	TO	4	.0681836
1	TO	5	.235296

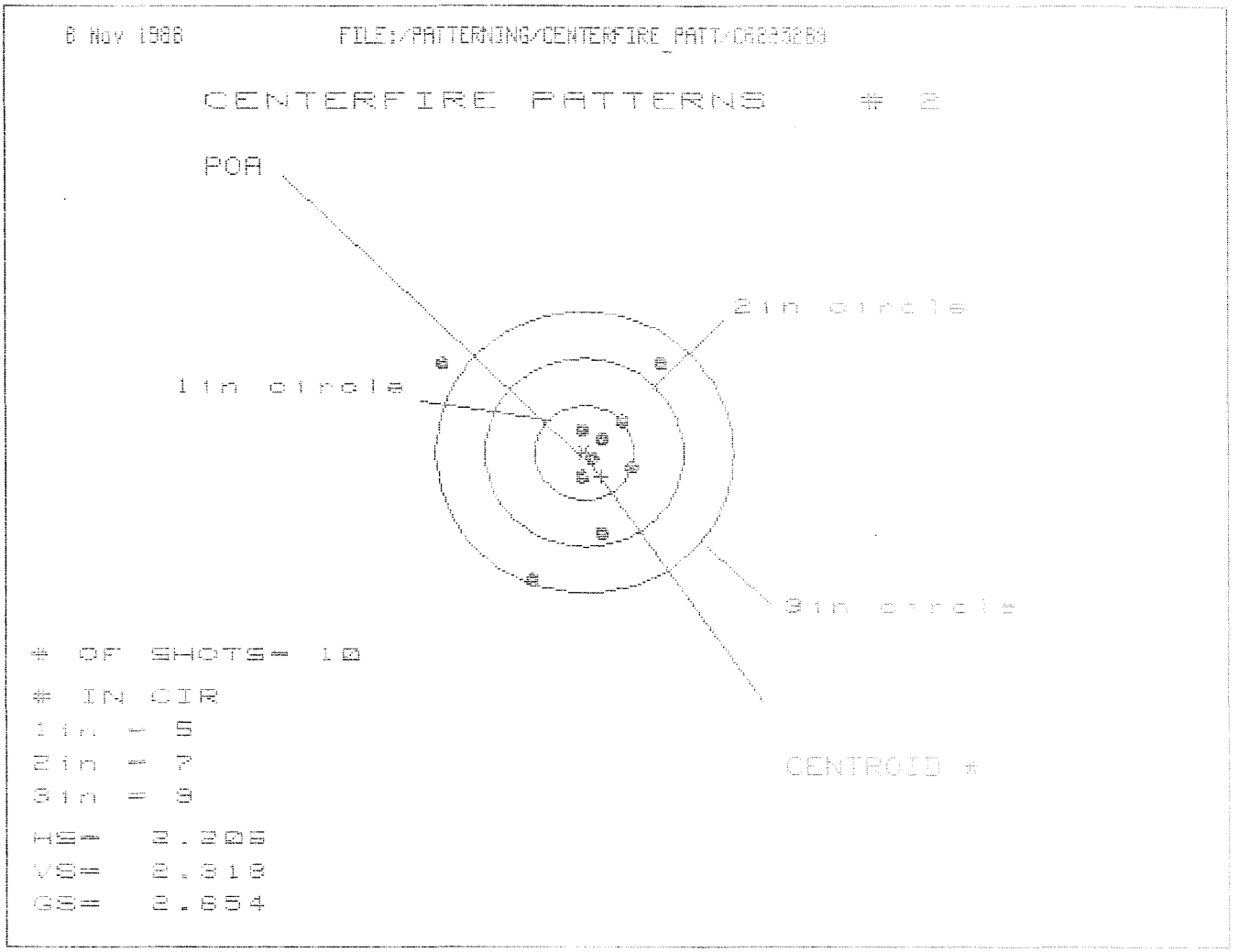
<----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0052
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0782
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0783727

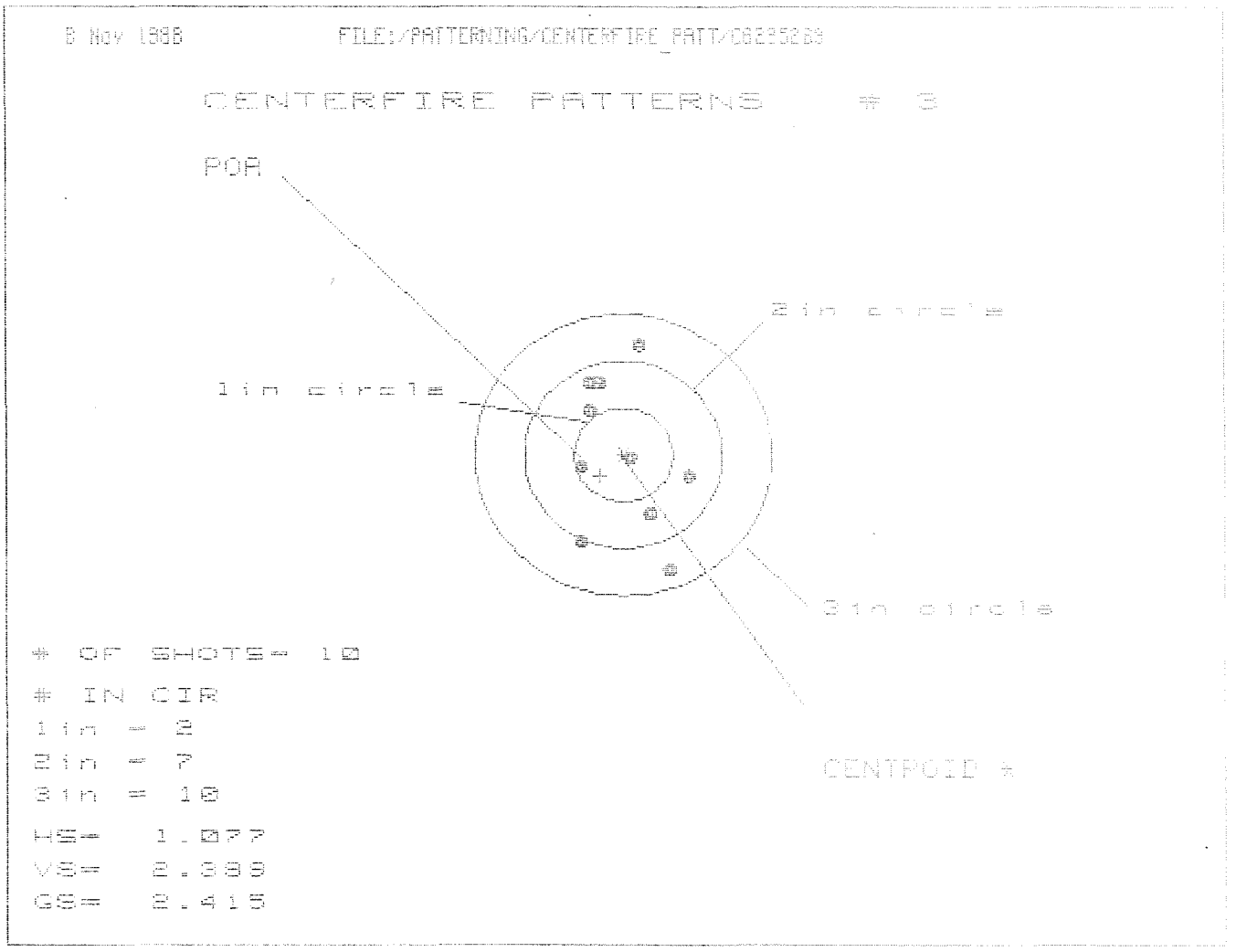
THE AMR FOR THIS RIFLE IS: .8974



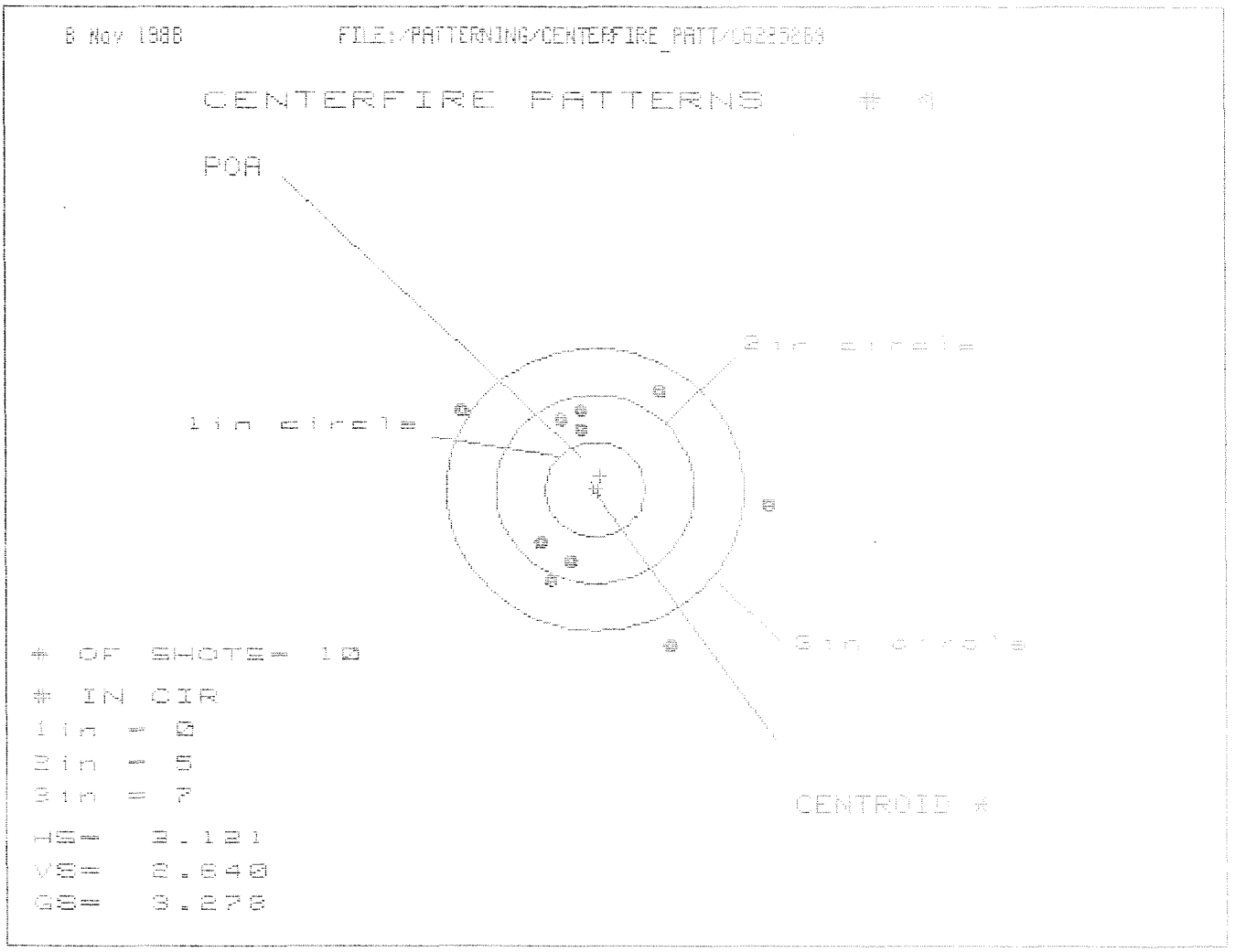
PATTERN #	:	[redacted]		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.503	1.456	.998
MINIMUM X	:	-1.264	-1.311	-1.129
MAXIMUM Y	:	1.264	1.098	1.098
MINIMUM Y	:	-1.490	-1.396	-1.398
CENTROID X	:	-.047	.000	-.182
CENTROID Y	:	-.075	.091	.061
POA TO CENTROID in.	:	.088	.091	.204
MIN RADIUS	:	.176	.314	.339
MEAN RADIUS	:	1.088	1.036	.984
MAX RADIUS	:	1.549	1.560	1.491
HORIZONTAL SPREAD	:	2.767	2.767	2.127
VERTICAL SPREAD	:	2.754	2.496	2.496
EXTREME SPREAD	:	2.981	2.891	2.776
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		8	



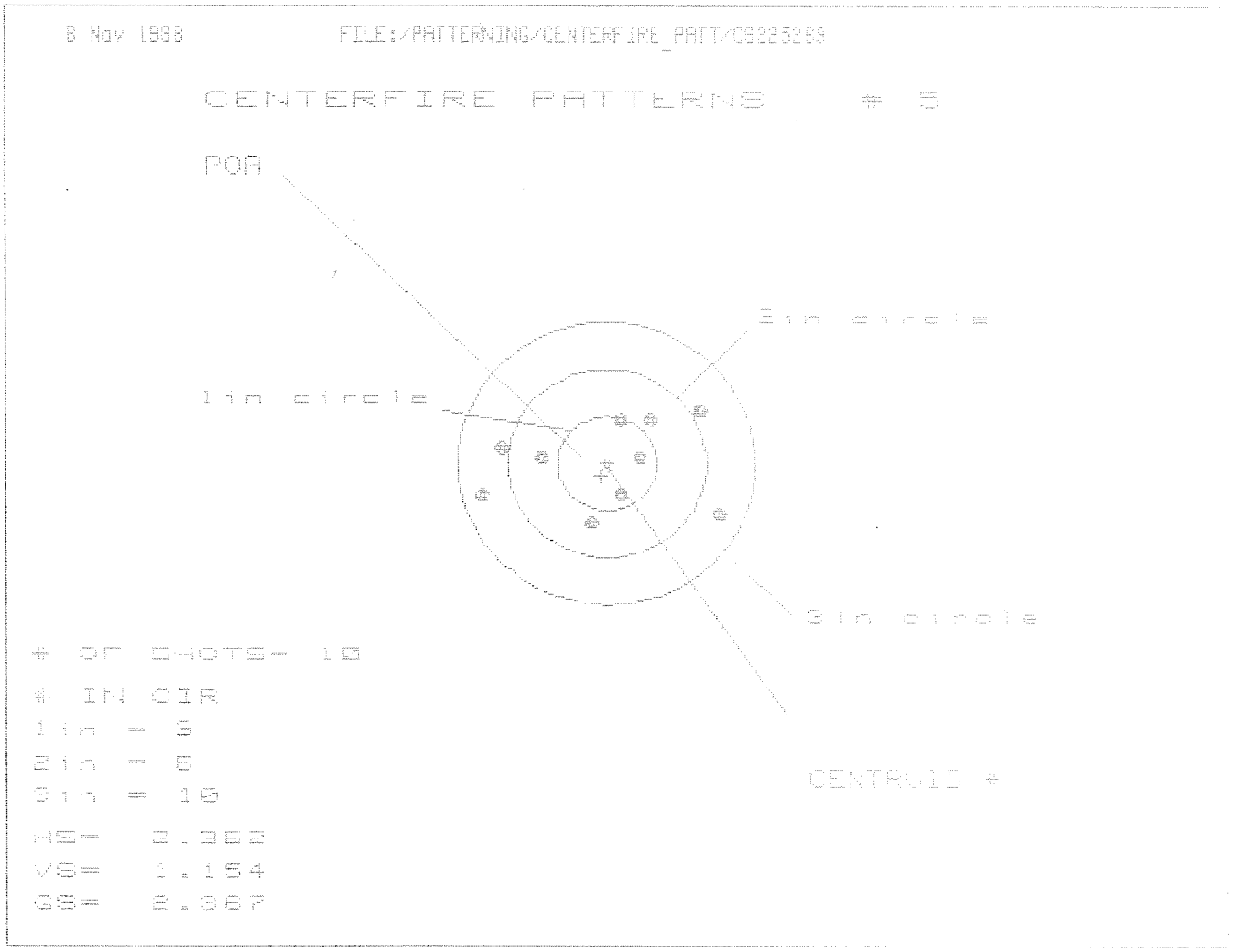
PATTERN #	:	[redacted]		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.795	.638	.556
MINIMUM X	:	-1.411	-.655	-.260
MAXIMUM Y	:	.958	1.064	.907
MINIMUM Y	:	-1.360	-1.254	-.884
CENTROID X	:	-.173	-.016	.086
CENTROID Y	:	.253	.147	.304
POA TO CENTROID in.	:	.306	.148	.311
MIN RADIUS	:	.107	.088	.149
MEAN RADIUS	:	.713	.583	.464
MAX RADIUS	:	1.702	1.415	1.064
HORIZONTAL SPREAD	:	2.206	1.293	.836
VERTICAL SPREAD	:	2.318	2.318	1.791
EXTREME SPREAD	:	2.654	2.654	1.985
NUMBER IN ONE INCH CIRCLE	=		5	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	



PATTERN #	:	[redacted]		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.629	.682	.714
MINIMUM X	:	-.448	-.395	-.363
MAXIMUM Y	:	1.153	1.014	.809
MINIMUM Y	:	-1.246	-1.033	-.906
CENTROID X	:	.235	.182	.150
CENTROID Y	:	.223	.362	.239
POA TO CENTROID in.	:	.324	.405	.279
MIN RADIUS	:	.120	.258	.200
MEAN RADIUS	:	.767	.697	.644
MAX RADIUS	:	1.336	1.106	.976
HORIZONTAL SPREAD	:	1.077	1.077	1.077
VERTICAL SPREAD	:	2.399	2.047	1.715
EXTREME SPREAD	:	2.415	2.148	1.731
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	



PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.783	.968	.943
MINIMUM X	:	-1.338	-1.140	-1.019
MAXIMUM Y	:	1.026	1.006	.801
MINIMUM Y	:	-1.614	-1.634	-1.219
CENTROID X	:	-.052	-.250	-.378
CENTROID Y	:	-.143	-.123	.082
POA TO CENTROID in.	:	.152	.278	.379
MIN RADIUS	:	.713	.670	.486
MEAN RADIUS	:	1.144	1.042	.895
MAX RADIUS	:	1.792	1.899	1.238
HORIZONTAL SPREAD	:	3.121	2.108	1.963
VERTICAL SPREAD	:	2.640	2.640	2.020
EXTREME SPREAD	:	3.278	3.210	2.267
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		7	



PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.139	.992	.880
MINIMUM X	:	-1.233	-1.160	-1.086
MAXIMUM Y	:	.543	.501	.429
MINIMUM Y	:	-.611	-.653	-.725
CENTROID X	:	.063	.200	.076
CENTROID Y	:	.133	.175	.247
POA TO CENTROID in.	:	.147	.266	.258
MIN RADIUS	:	.303	.160	.279
MEAN RADIUS	:	.775	.692	.643
MAX RADIUS	:	1.289	1.170	1.039
HORIZONTAL SPREAD	:	2.362	2.152	1.916
VERTICAL SPREAD	:	1.154	1.154	1.154
EXTREME SPREAD	:	2.367	2.272	1.948
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	

CEIVING AND ESTIMATING REPORT

COMMENTS: M-24 SNIPER

ORDER R 94-24902

CUSTOMER ORDER NO.:

RECEIVED	DATE OPENED	DATE CODE	SERIAL NUMBER	NEW SERIAL NUMBER	MODEL AND GRADE
/29/94	08/30/94	DI 9-88	C6225269		700 7.62 NATO

SORIES: SCOPE MNTS SCOPE BASE

SHIP TO:

DEPT OF THE ARMY
B CO ARMS
2/75 RANGER BATTALION
FT LEWIS WA 98433

DEPT OF THE ARMY
B CO ARMS
2/75 RANGER BATTALION
FT LEWIS WA 98433

CUST NO: 062072 C.O.D.

UNT NUMBER	ACCOUNT NUMBER N/C	WRITE ☐	PROM. DATE	ESTIMATED	VIA
					UPS

ONDITION		REPAIR CHARGE	
EW		EXCISE	
GHTLY WORN		TAX	
ORN		INSURANCE	
ERY WORN		UPS	
NREPAIRABLE		PARCEL POST	
ARRED		TOTAL	

TOMER CONCERN	AMMO	FUNCTION	FINISH	ACCURACY	FIT	INSPECT
E	A1	B1				
GER GROUP		B2			E1	F1
ASSY.		B3			E2	F2
EL ASSY.		B4		D1	E3	F3
ASSY.		B5		D2	E4	F4
D			C1	D3	E5	F5
L			C2			

FAULT: New Barrel

Barrel 96003

COMMENTS: Repowder Coat Trigger Guard Assy, Front & Rear Sight Bases Reztic Scope Base, Rings & Swivel Studs

REPAIRMAN	PROOF	CLEAN	TEST	TARGET	PATTERN
RW	✓	✓	✓	✓	
GALLERY TESTER	**DATE**	**DATE**	**DATE**	**DATE**	**DATE**
RW	9/1/94	9/13/94	9/13/94	9/13/94	

OFFICE COPY

RD6925 REV. 1/94

PACKING LIST	PACKED BY Mr. Ray Fuller WG-10 Bn. Armorer.	1. NO. BOXES 1	2a. REQUISITION NO. 94235 2b. ORDER NO.

3. END ITEM: 7.62mm M24 Sniper Weapons System (SWS)

4. DATE: 26 July 1994

5. PAGE 1 OF 1 PAGES

BOX NO. (a)	CONTENTS - STOCK NUMBER AND NOMENCLATURE (b)	UNIT OF ISSUE (c)	QUANTITIES REQUIRED: INITIAL OPERATION (d)	QUANTITIES REQUIRED: RUNNING SPARES (e)	QUANTITIES REQUIRED: TOTAL (f)
	7.62mm M24 Sniper Weapon System (SWS) Serial No. C6225269 NSN: 1005-01-240-2136	Ea			1
	Note: All Optic Scope Ring Mounts Packed				

6. THIS CERTIFIES THAT ITEMS LISTED HEREON ARE WITHIN THE SPECIFIED BOXES

TYPED NAME AND TITLE	SIGNATURE
Ray Fuller WG-10 Bn Armorer	Ray Fuller

DD FORM 1 SEP 70 1750

MAINTENANCE REQUEST

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

PAGE NO.	NO OF PAGES	REQUIREMENTS CONTROL SYMBOL
1		CSGLD - 1047(R1)

SECTION I - EQUIPMENT DATA

CONTROL NUMBER	WORK ORDER NO.	WESDC	ORG. PD	PD AUTHENTICATION
	94235		02	CPT IN

	1A. ORGANIZATION	B. LOCATION	C. UNIT IDENT CODE
☒ Work Request ☐ MWO ☐ Warranty Claim	Bn Arms HHC 2/75 Rgr Rgt.	Fort Lewis Wa.	WH3MAA

2. SERIAL NO.	3. NOUN NOMENCLATURE	4. LINE NO.	5. MODEL	6. NATIONAL STOCK NUMBER
C6225269	M24 SWS		M24	1005-01-240-2136

7A. MAINTENANCE ACTIVITY	B. LEVEL	8. UTILIZATION CODE	9A. MCSR ITEM	9B. ERC	9C. PACING ITEM	10. HOURS	11. MILES	12. ROUNDS	13. STARTS
Remington Arms Co. Custom Shop									

14. FAILURE DETECTED DURING *(Select one - use ✓ or X)*

☐ A Sch. Main. ☒ C Test ☐ E Storage ☐ G Flight
☐ B Handling ☐ D Normal Op ☐ F Inspection ☐ H Other

15. FIRST INDICATION OF TROUBLE *(Select one - use ✓ or X)*

☐ 068 Inoperative ☐ 258 Overheating ☐ 790 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).*

This Weapon Has Fired over 19,000 Rds. During Bench Rest Test Five at 200/300 Yds groups were shot exceeding the criteria of 2.6" at 200 & 3.8" at 300 Yds (5-10 Shot Groups) This criteria was provided us by Mr Jim Glenn ARDEC DSN 880-7071

B. REMARKS

Request ReBarreling and Complete Weapon Reconditioning

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. (1) CB CODE	(2) REF DESIGN.	(3) MFR. CODE	D. MANHOURS *(Hrs. & tenths)*	E. NATIONAL STOCK NUMBER	F. PART SOURCE CODE	G. QTY.	H. PARTS COST
					.				$
					.				$
					.				$
					.				$
					.				$
					.				$
					.				$
					.				$
					.				$

I. TOTAL MANHOURS	J. TOTAL MANHOURS COST	K. TOTAL PARTS COST
	$	$

21. DELAY *(Select One)* ☐ 1 Parts ☐ 2 Manpower ☐ 3 Facilities ☐ 4 Funds ☐ 5 Tools

22. ☐ Data Transcribed

23. SUBMITTED BY	24. RECEIVED BY	25. WORK STARTED BY	26. INSPECTED BY	27. ACCEPTED BY	28. DISPOSITION *(Select One)*
Ray Fulle					☐ A To User ☐ B To Stock ☐ C Salvaged ☐ D Evacuated ☐ E Cannibalization
JULIAN DATE 4235	JULIAN DATE	JULIAN DATE	JULIAN DATE	JULIAN DATE	

DA FORM 2407, AUG 88 — EDITION OF MAY 81 MAY BE USED — NMP COPY 2

SWS/Repair

Final Inspection

S/N: C6225269 | DATE REC'D: 8/29/94 | DATE RET'D:

AUDITOR: AW

Item:
Barrel Assy.
- ✓ Barrel
- ✓ Receiver
- ✓ Front Sight Block
- ✓ Rear Sight Block
- ✓ Screws
- ✓ Finish

Item:
Stock Assy.
- ✓ Stock
- ✓ Sling Swivel Studs
- ✓ Adjustable Butt Plate
- ✓ Lock Nuts
- ✓ Barrel Clearance
- ✓ Color/Finish

Scope Assy.
- ___ Scope
- ✓ Scope Rings
- ✓ Mounting Screws
- ✓ Mounting Base
- ✓ Screws
- ✓ Finish
- ___ Looseness
- ___ Clarity

Systems Case
- ___ Scope Case
- ___ Iron Sights
- ___ Depoyment Kit

Trigger
- ✓ Safety Operation
- ✓ Set
- ___

Misc.
- ___ DD-250
- ___ Bar Code
- ___ Packaging

Comments: _____

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6225269
15 Sep 1994

CENTROIDAL DISTANCES

0	TO	1	.319226
1	TO	2	.211026
1	TO	3	.193373
1	TO	4	.362022
1	TO	5	.304109

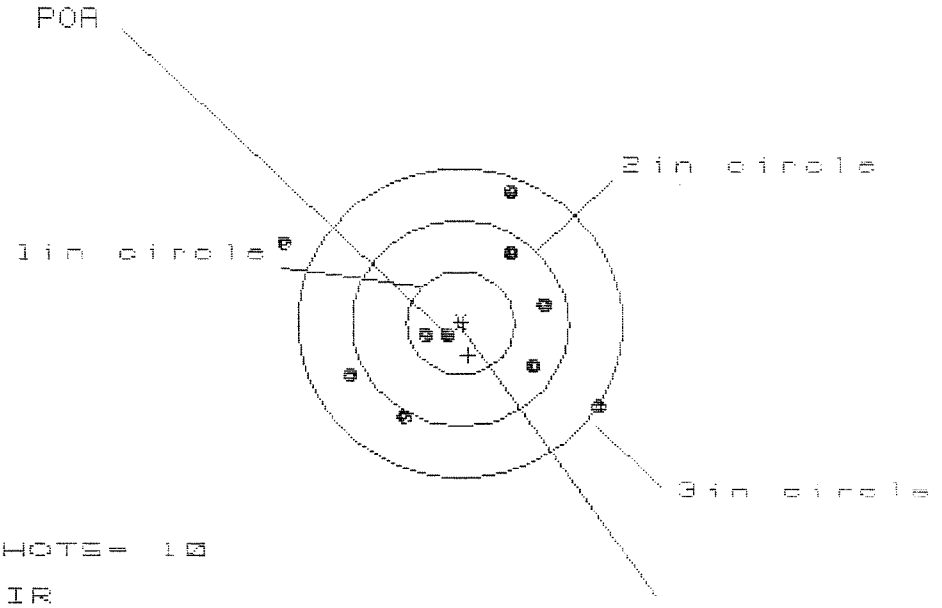
<----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0312
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1475
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .150862

THE AMR FOR THIS RIFLE IS: .9414

15 Sep 1994 FILE:/PATTERNING/CENTERFIRE_PATT/C8225269

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

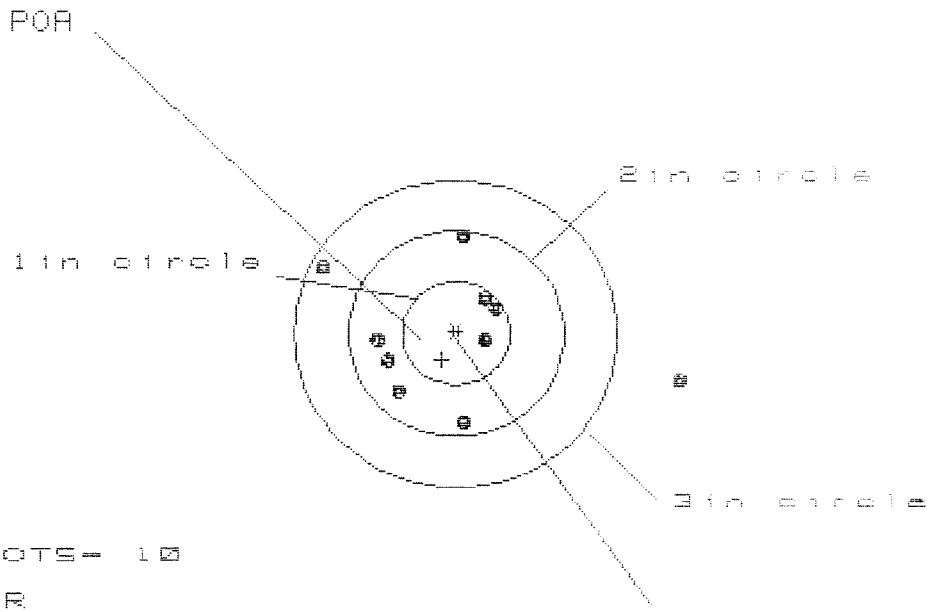
# IN CIR
1in = 2
2in = 5
3in = 8

HS= 2.921
VS= 2.153
GS= 3.327

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.274	1.091	.696
MINIMUM X	:	-1.647	-1.227	-1.091
MAXIMUM Y	:	1.243	1.326	1.230
MINIMUM Y	:	-.910	-.827	-.923
CENTROID X	:	-.072	.111	-.025
CENTROID Y	:	.311	.228	.324
POA TO CENTROID in.	:	.319	.254	.325
MIN RADIUS	:	.147	.314	.195
MEAN RADIUS	:	.980	.885	.811
MAX RADIUS	:	1.806	1.364	1.312
HORIZONTAL SPREAD	:	2.921	2.318	1.787
VERTICAL SPREAD	:	2.153	2.153	2.153
EXTREME SPREAD	:	3.327	2.398	2.398
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

15 Sep 1994 FILE:/PATTERNING/CENTERFIRE_PATT/G8223269

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

# IN CIR
1in = 3
2in = 8
3in = 8

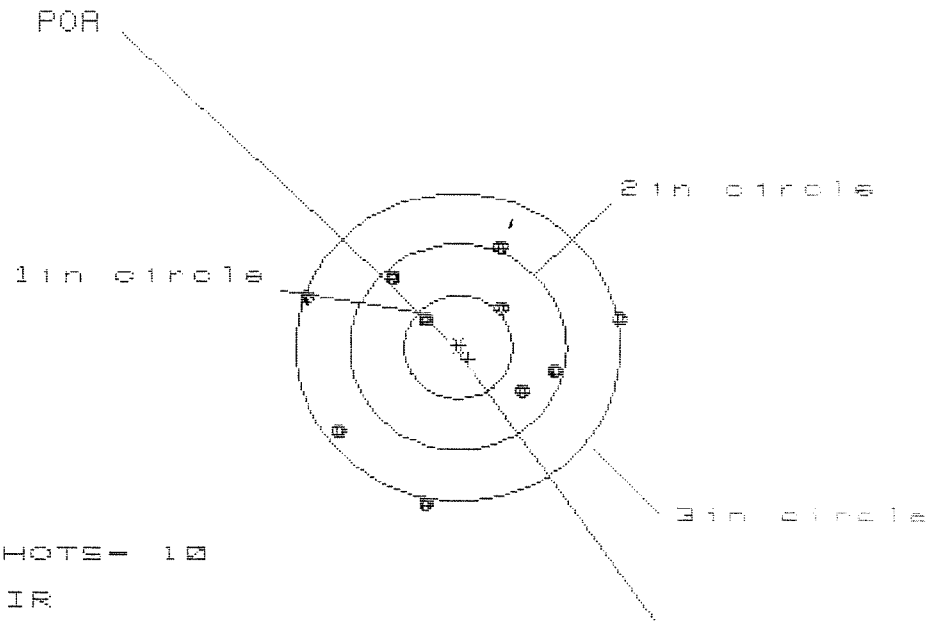
HS= 3.300
VS= 1.808
GS= 3.471

PATTERN # : 2

SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.082	.581	.457
MINIMUM X	:	-1.218	-.986	-.670
MAXIMUM Y	:	.981	.929	.998
MINIMUM Y	:	-.827	-.879	-.810
CENTROID X	:	.132	-.100	.024
CENTROID Y	:	.257	.309	.240
POA TO CENTROID in.	:	.288	.325	.241
MIN RADIUS	:	.309	.504	.415
MEAN RADIUS	:	.875	.727	.660
MAX RADIUS	:	2.135	1.131	1.022
HORIZONTAL SPREAD	:	3.300	1.567	1.127
VERTICAL SPREAD	:	1.808	1.808	1.808
EXTREME SPREAD	:	3.471	1.956	1.808
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	

15 Sep 1994 FILE:/PATTERNING/CENTERFIRE_PATT/C8225283

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

# IN CIR
1in = 1
2in = 5
3in = 9

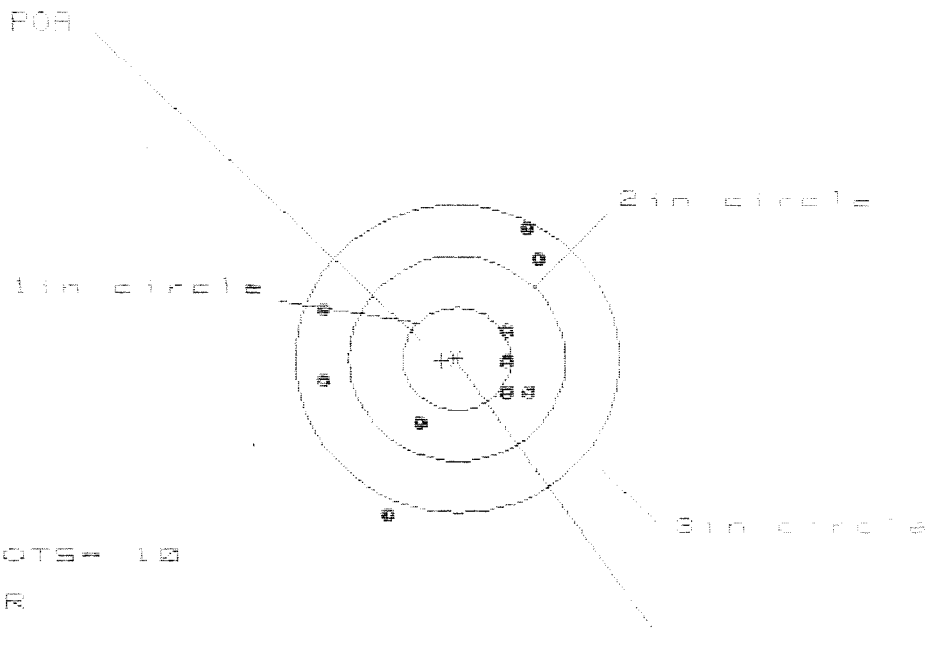
HS= 2.836
VS= 2.471
GS= 2.841

PATTERN # : 3

SHOTS (BEST OF) :	10	9	8
MAXIMUM X :	1.467	1.432	1.024
MINIMUM X :	-1.369	-1.404	-1.224
MAXIMUM Y :	.984	.819	.833
MINIMUM Y :	-1.487	-1.010	-.996
CENTROID X :	-.095	-.060	-.289
CENTROID Y :	.119	.284	.270
POA TO CENTROID in.:	.152	.290	.361
MIN RADIUS :	.358	.315	.152
MEAN RADIUS :	1.030	.949	.882
MAX RADIUS :	1.518	1.538	1.397
HORIZONTAL SPREAD :	2.836	2.836	2.248
VERTICAL SPREAD :	2.471	1.829	1.829
EXTREME SPREAD :	2.841	2.841	2.403
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		9	

15 Sep 1994 FILE:/PATTERNING/CENTERFIRE_PATT/C08285E8

CENTERFIRE PATTERNS # 4



OF SHOTS= 10

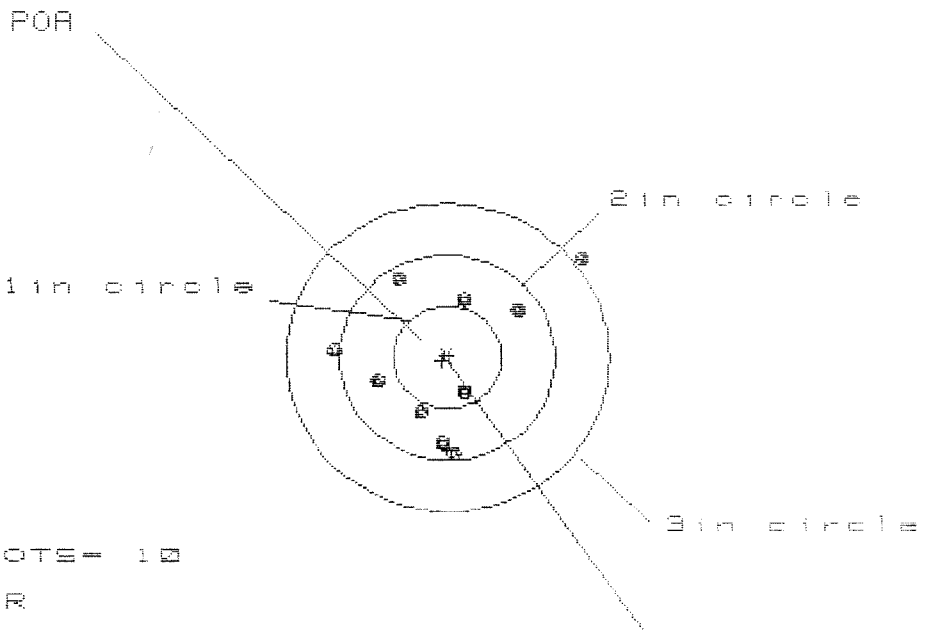
# IN CIR	
1in =	2
2in =	5
3in =	8

HS=	2.046
VS=	2.828
GS=	3.080

PATTERN #	:	4	
SHOTS (BEST OF)	:	10	9	0
MAXIMUM X	:	.787	.720	.790
MINIMUM X	:	-1.259	-1.326	-1.256
MAXIMUM Y	:	1.290	1.119	.928
MINIMUM Y	:	-1.538	-.785	-.645
CENTROID X	:	.142	.209	.139
CENTROID Y	:	.019	.190	.050
POA TO CENTROID in.	:	.143	.282	.148
MIN RADIUS	:	.464	.362	.470
MEAN RADIUS	:	.987	.902	.851
MAX RADIUS	:	1.652	1.369	1.344
HORIZONTAL SPREAD	:	2.046	2.046	2.046
VERTICAL SPREAD	:	2.828	1.904	1.573
EXTREME SPREAD	:	3.080	2.394	2.344
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

15 Sep 1994 FILE:/PATTERNING/CENTERFIRE_PATT/C8225283

CENTERFIRE PATTERNS # 5



OF SHOTS= 10

# IN CIR
1in = 1
2in = 8
3in = 9

HS= 2.386
VS= 1.923
GS= 2.562

PATTERN # : 5

SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.288	.815	.696
MINIMUM X	:	-1.098	-.955	-.583
MAXIMUM Y	:	.958	.923	.939
MINIMUM Y	:	-.965	-.858	-.842
CENTROID X	:	.049	-.094	.025
CENTROID Y	:	.032	-.075	-.091
POA TO CENTROID in.	:	.059	.120	.094
MIN RADIUS	:	.364	.362	.267
MEAN RADIUS	:	.835	.723	.682
MAX RADIUS	:	1.605	.986	1.015
HORIZONTAL SPREAD	:	2.386	1.770	1.279
VERTICAL SPREAD	:	1.923	1.781	1.781
EXTREME SPREAD	:	2.562	1.847	1.847
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	

CONTRACT # DAAA21-87-C-0086 New Barrel

GUN SERIAL # C6225769

OP. #	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and Stock		9/1/94	RW
600	Proof		9/1/94	RW
607	Check Headspace		9/1/94	RW
610	Dis-assemble Gun		9/1/94	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		9/13/94	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		9/13/94	RW
	C) Inspect Ejector Hole for Chamfer		9/13/94	RW
	D) Oil Firing Pin Ass'y		9/13/94	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			
	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		9/13 OK	WB
	A) Time		9/13	WB
	B) Malfunctions		9/13 OK	WB
	C) Pierced Primers		9/13 OK	WB
	D) Optical Clearity of Scope		9/13 OK	WB
645	Inspect for Live Ammo		9/13/94	Rw
655	Final Inspection A) Headspace		9/14/94	Rw
	B) Trigger Pull	2.83 2.77 2.80 2.85 2.85	9/14/94	Rw
	C) Function		9/14/94	Rw
660	Pack			