

C6225376

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



Repair Inquiry

Repair Number: **RE00141564**

Serial: C6225376 Model M24 SWS Center Fire
Caliber: 7.62 NATO Produced: 06/21/1989

Repairman:

Status:

Closed 2/12/2008 7:33:34 AM

Verify Repair

Address Information

Customer:

☒ Received From

Return To:

☐ Received From

Name: **DEPARTMENT OF THE ARMY**
DEPARTMENT OF THE ARMY

Address 1: **B CO 3RD BN 1ST SP FORCES GROUP**
B CO 3RD BN 1ST SP FORCES GROUP

Address 2:

PO Box:

PO Box:

City: **FORT LEWIS**
FORT LEWIS

State: **WA** Zip Code: **98433**

Country: **US**

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
A017	Scope Base	1
A057	Frt and Rear Sgt Base	1

Repair Search

Refresh

Close

nagletj

2/13/2008

8:57 AM

CAPS

NUM


Serial Number: **C6225376**

Model: **M24 SWS**

RE00141564

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

R & E NUMBER 00141564

SERIAL NUMBER C6225376

LOG-IN DATE 2-12-08

OPERATION #	OPERATION NAME	DATE	INITIAL
500	DIS-ASSEMBLE GUN	2-20-08	RPD
505	RE-BARREL	2-20-08	RPD
560	ASSEMBLE	2-20-08	RPD
600	PROOF	2-20-08	TRW
605	CHECK HEADSPACE	2-20-08	TRW
610	DIS-ASSEMBLE GUN	3-12-08	KIZ
612	MAGNAFLUX	3/14/08	unm
510	DRILL AND TAP	3-12-08	Fm
615	ROLLMARK CALIBER	3-13-08	CW
618	ROTO-BLAST	3-14-08	DG
620	APPLY COATINGS	3-20-08	HP
625	FINAL ASSEMBLY	3-28-08	RPD
640	FUNCTION TEST AND	3-31-08	TRW
650	TARGET	3-31-08	TRW
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
670	FINAL INSPECTION	4-2-08	Fm
	A) HEADSPACE	4/2/08	Fm
	B) TRIGGER PULL	2.70 2.71 2.56 2.76 2.63 4/2/08	Fm
680	F) SAFETY ON FORCE	6.5 6.5 7- 4/2/08	Fm
	G) SAFETY OFF FORCE	4- 4.5 4.5 4/2/08	Fm
	I) FIRING PIN INDENT	.021 .022 .022 4/2/08	Fm
690	PACK		

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6225376.___0

FILE DATE AND TIME: 04/01/2008 06:10

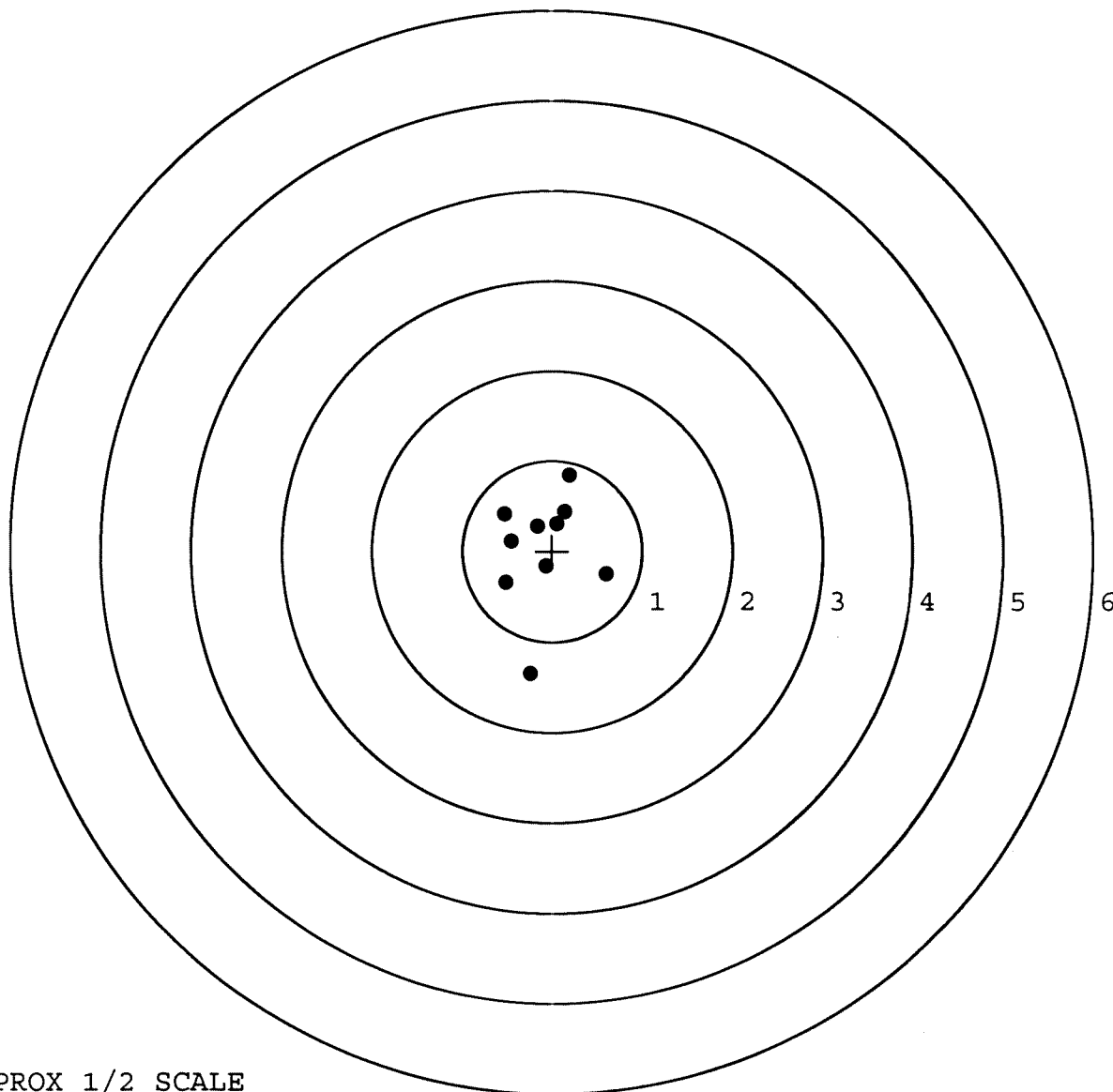
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.033
The Average Y Centroid of the Five Target Set:	-0.094
The Average Point of Impact of the Five Target Set:	0.100
The Average Mean Radius of the Five Target Set:	0.548
The Distance from POA to Centroid Target #1:	0.101
The Distance from Centroid Target #2 to Centroid Target #1:	0.217
The Distance from Centroid Target #3 to Centroid Target #1:	0.281
The Distance from Centroid Target #4 to Centroid Target #1:	0.166
The Distance from Centroid Target #5 to Centroid Target #1:	0.227

SERIAL NUMBER: C6225376. 0
TARGET NUMBER: 1
FILE DATE: 04/01/2008
FILE TIME: 06:10

X CENTROID: -0.098
Y CENTROID: 0.023
POA TO CENTROID: 0.101
HORZ SPREAD: 1.131
VERT SPREAD: 2.196
GROUP SPREAD: 2.239
MIN RADIUS: 0.196
MAX RADIUS: 1.390
MEAN RADIUS: 0.578
IN 1 IN DIAMETER: 5
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.240	-1.360
2:	0.602	-0.257
3:	-0.071	-0.171
4:	-0.517	-0.353
5:	-0.529	0.409
6:	-0.459	0.111
7:	-0.166	0.276
8:	0.054	0.302
9:	0.145	0.434
10:	0.198	0.836

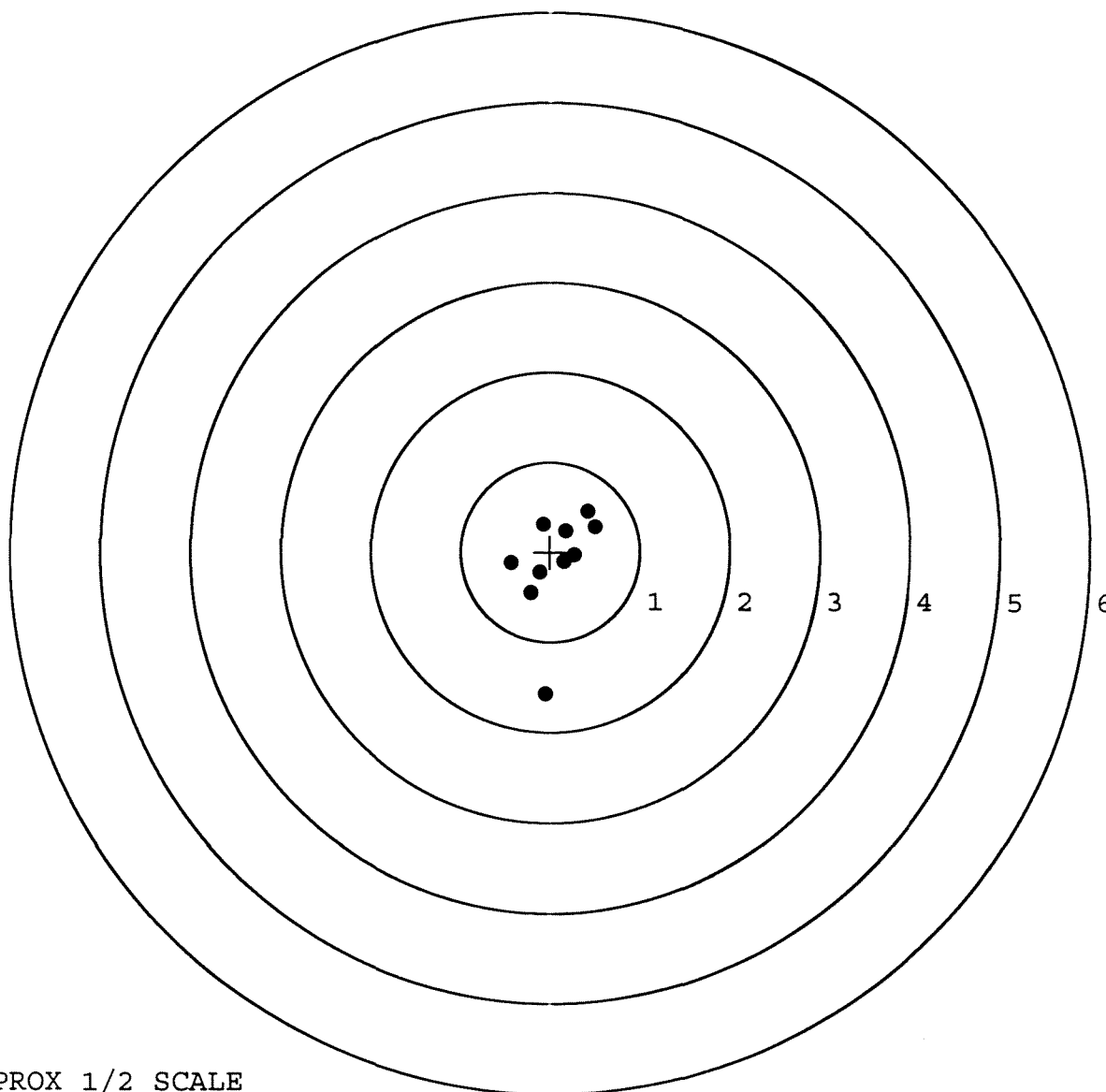


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6225376. __0
TARGET NUMBER: 2
FILE DATE: 04/01/2008
FILE TIME: 06:10

X CENTROID: 0.060
Y CENTROID: -0.125
POA TO CENTROID: 0.139
HORZ SPREAD: 0.935
VERT SPREAD: 2.041
GROUP SPREAD: 2.096
MIN RADIUS: 0.095
MAX RADIUS: 1.466
MEAN RADIUS: 0.504
IN 1 IN DIAMETER: 7
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.419	0.455
2:	0.500	0.286
3:	0.271	-0.036
4:	0.154	-0.108
5:	-0.216	-0.454
6:	-0.435	-0.121
7:	-0.085	0.308
8:	0.172	0.237
9:	-0.057	-1.586
10:	-0.118	-0.232



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6225376. __0

TARGET NUMBER: 3

FILE DATE: 04/01/2008

FILE TIME: 06:10

X CENTROID: 0.097

Y CENTROID: -0.180

POA TO CENTROID: 0.204

HORZ SPREAD: 1.529

VERT SPREAD: 1.272

GROUP SPREAD: 1.660

MIN RADIUS: 0.131

MAX RADIUS: 1.047

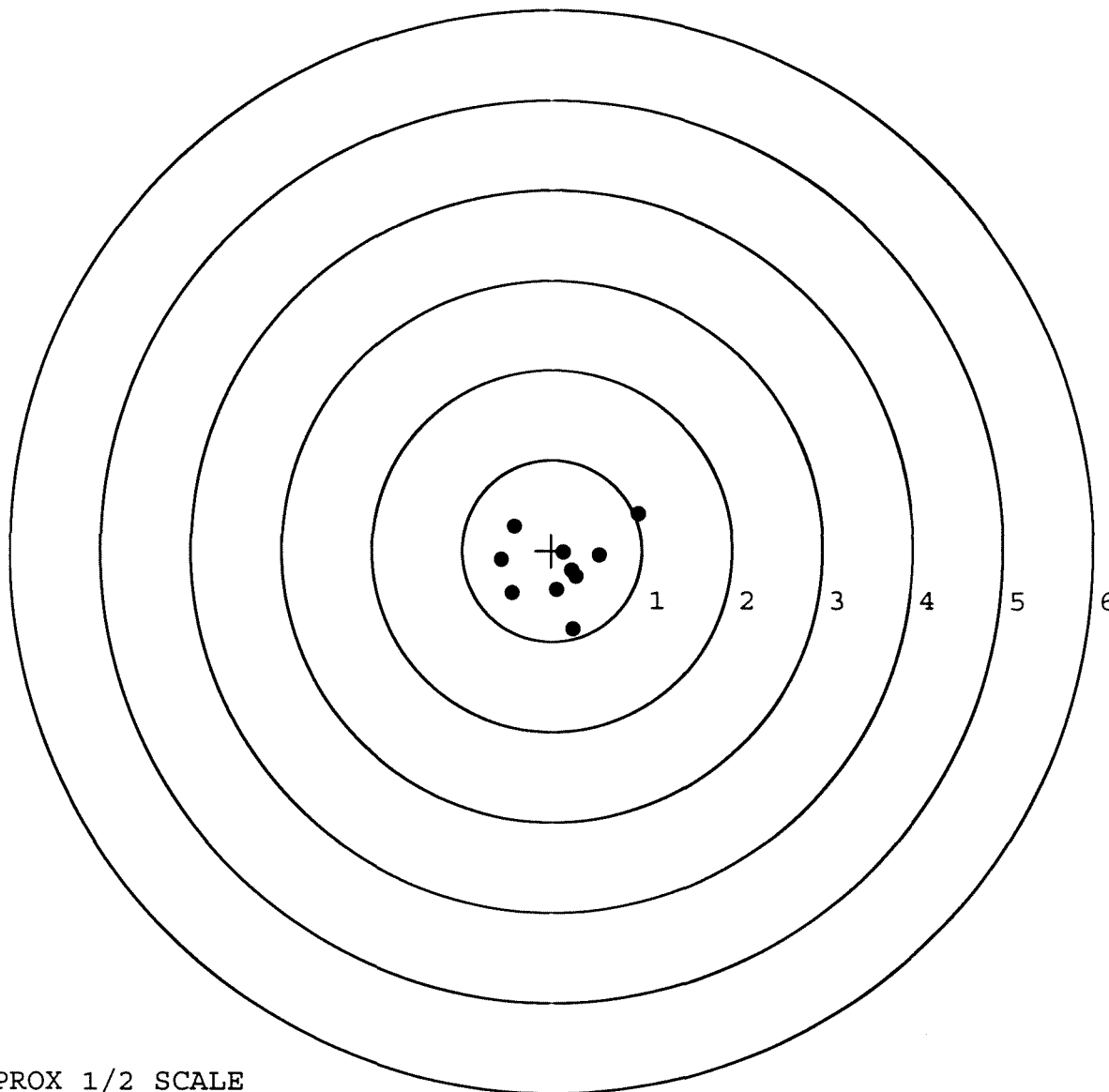
MEAN RADIUS: 0.492

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.424	0.269
2:	-0.563	-0.104
3:	-0.444	-0.472
4:	0.234	-0.868
5:	0.966	0.404
6:	0.528	-0.057
7:	0.267	-0.289
8:	0.055	-0.438
9:	0.221	-0.220
10:	0.128	-0.024



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6225376. __0

TARGET NUMBER: 4

FILE DATE: 04/01/2008

FILE TIME: 06:10

X CENTROID: 0.004

Y CENTROID: -0.108

POA TO CENTROID: 0.108

HORZ SPREAD: 1.790

VERT SPREAD: 1.990

GROUP SPREAD: 1.993

MIN RADIUS: 0.262

MAX RADIUS: 1.097

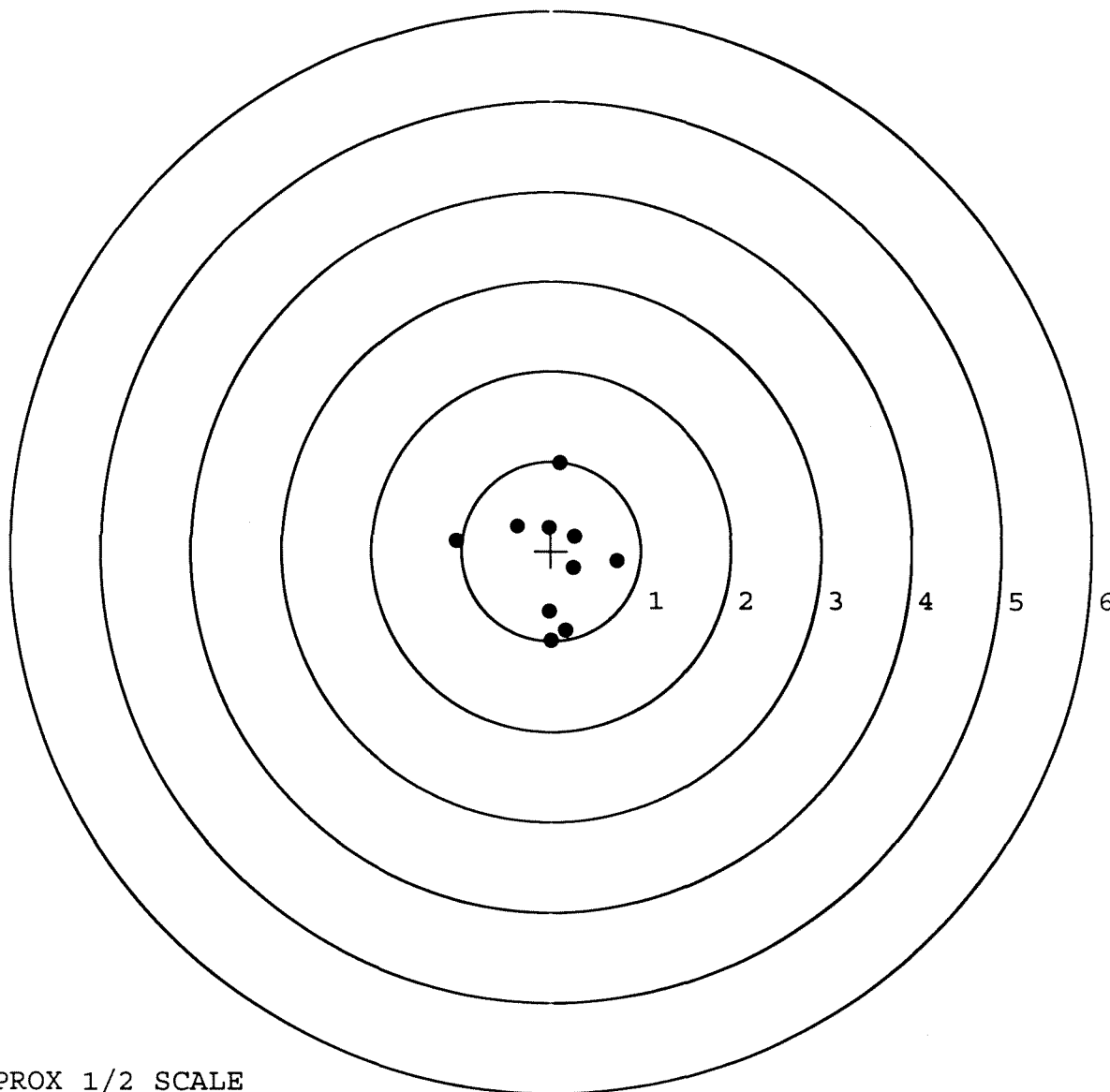
MEAN RADIUS: 0.673

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.003	-1.006
2:	-0.023	-0.680
3:	-1.054	0.116
4:	-0.381	0.274
5:	-0.020	0.265
6:	0.103	0.984
7:	0.264	0.160
8:	0.736	-0.116
9:	0.253	-0.188
10:	0.163	-0.890



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6225376. __0

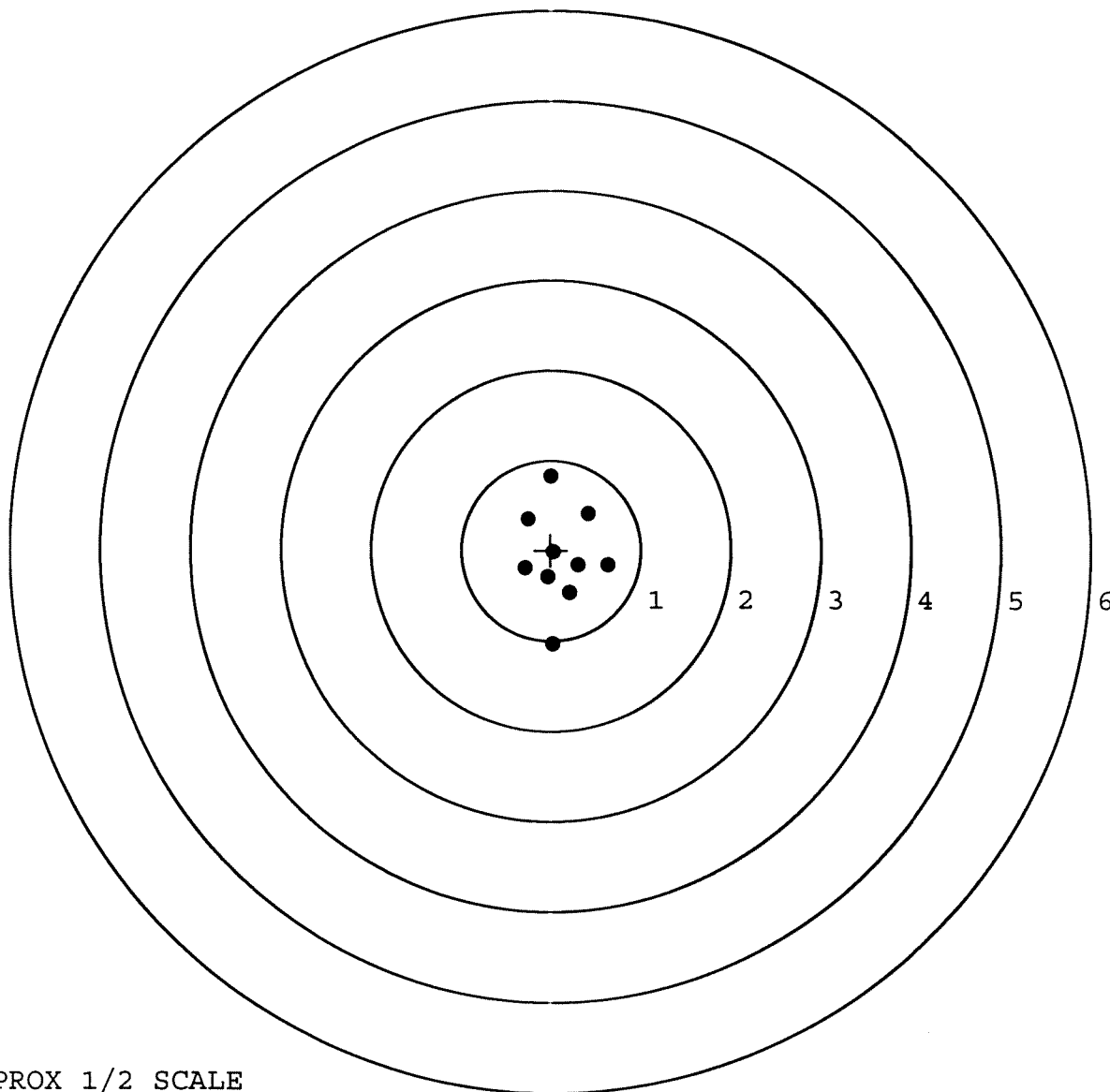
TARGET NUMBER: 5

FILE DATE: 04/01/2008

FILE TIME: 06:10

X CENTROID: 0.104
Y CENTROID: -0.081
POA TO CENTROID: 0.132
HORZ SPREAD: 0.930
VERT SPREAD: 1.863
GROUP SPREAD: 1.863
MIN RADIUS: 0.093
MAX RADIUS: 0.963
MEAN RADIUS: 0.496
IN 1 IN DIAMETER: 5
IN 2 IN DIAMETER: 10
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.420	0.409
2:	-0.005	0.823
3:	-0.259	0.347
4:	0.640	-0.171
5:	0.024	-1.040
6:	0.213	-0.476
7:	0.302	-0.168
8:	0.033	-0.020
9:	-0.290	-0.204
10:	-0.037	-0.306



TARGET APPROX 1/2 SCALE

Repair Inquiry

Repair Number: **RE00062255**Serial: C6225376 Model 700 Center Fire Caliber:
7.62 NATO M-24 (SWS)

Repairman:

Verify Repair

Status:

Closed 2/26/2003 11:49:39 AM

Address Information

Customer:

☒ Received From

Return To:

☐ Received FromName: **JOINT TRANS DIRECTORATE****JOINT TRANS DIRECTORATE**Address 1: **ATTN AFZH JTM M****ATTN AFZH JTM M**Address 2: **BOX 339500 MS 53**

PO Box:

BOX 339500 MS 53

PO Box:

City: **FORT LEWIS****FORT LEWIS**State: **WA**Zip Code: **98433**Country: **US**State: **WA**Zip Code: **98433**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	1
A017	Scope Base	1
X	FRT & REAR SGT BA	1

Repair Search

Refresh

Close

nagletj

2/26/2003

1:09 PM

CAPS

NUM

INS

SCPL

start

Inbox - Micros...

Calendar - Micro...

Arms Services R...

1:09 PM

Serial
Number:**C6225376**Model: **700****RE00062255**

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6225376.___0
FILE DATE AND TIME: 03/21/2003 15:26

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.086
The Average Y Centroid of the Five Target Set:	-0.132
The Average Point of Impact of the Five Target Set:	0.157
The Average Mean Radius of the Five Target Set:	0.563
The Distance from POA to Centroid Target #1:	0.120
The Distance from Centroid Target #2 to Centroid Target #1:	0.243
The Distance from Centroid Target #3 to Centroid Target #1:	0.248
The Distance from Centroid Target #4 to Centroid Target #1:	0.113
The Distance from Centroid Target #5 to Centroid Target #1:	0.182

SERIAL NUMBER: C6225376. 0

TARGET NUMBER: 1

FILE DATE: 03/21/2003

FILE TIME: 15:26

X CENTROID: 0.043

Y CENTROID: -0.112

POA TO CENTROID: 0.120

HORZ SPREAD: 2.041

VERT SPREAD: 1.660

GROUP SPREAD: 2.135

MIN RADIUS: 0.045

MAX RADIUS: 1.134

MEAN RADIUS: 0.669

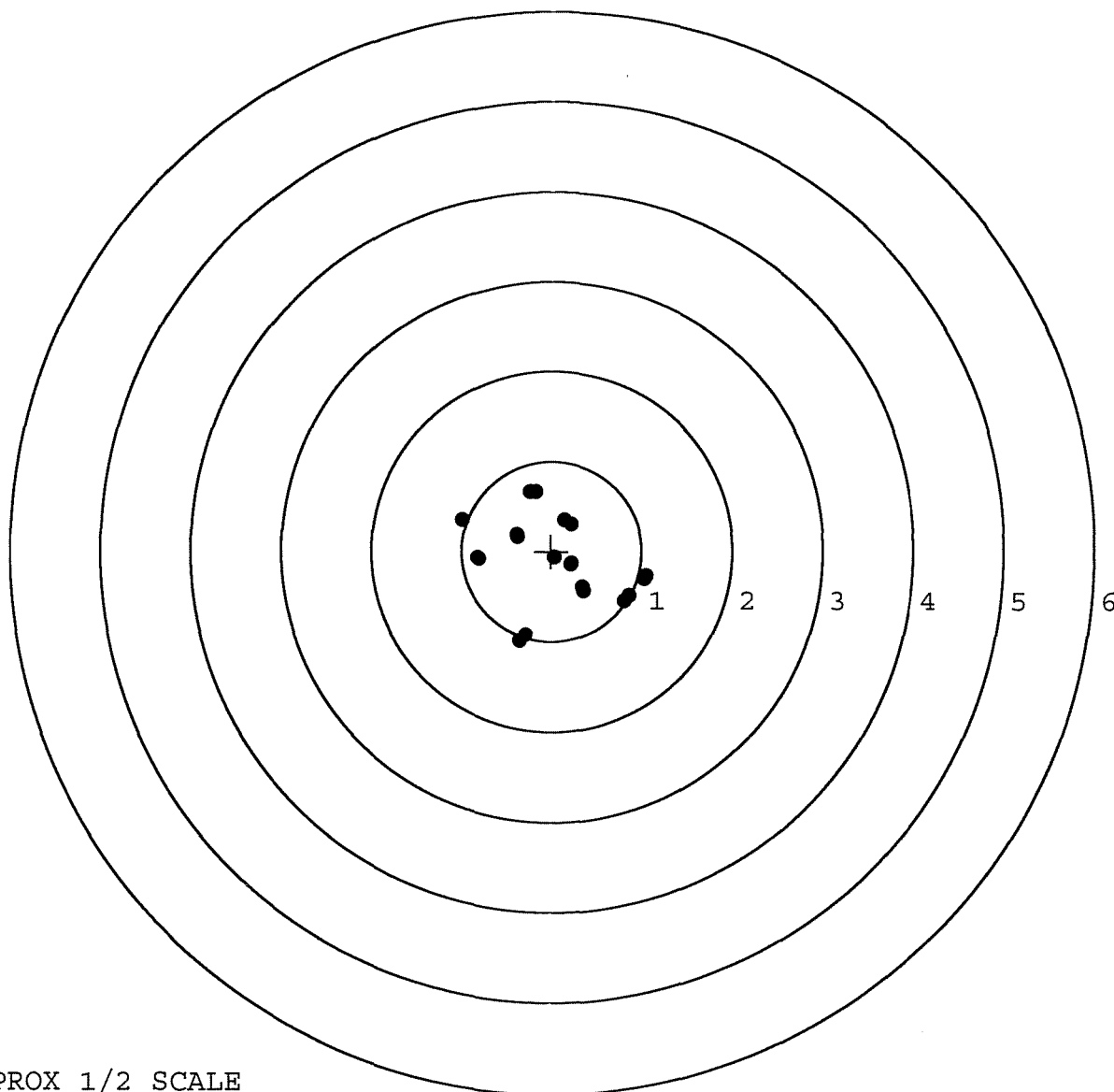
IN 1 IN DIAMETER: 7

IN 2 IN DIAMETER: 17

in 3 IN DIAMETER: 20

POINT#	X	Y
1:	1.028	-0.312
2:	0.863	-0.495
3:	0.343	-0.399
4:	0.215	-0.150
5:	-0.347	-0.994
6:	0.219	0.304
7:	-0.178	0.666
8:	-0.385	0.187
9:	-0.820	-0.067
10:	0.037	-0.067
11:	1.047	-0.279
12:	0.813	-0.556
13:	0.360	-0.444
14:	0.226	-0.135

POINT#	X	Y
15:	-0.288	-0.939
16:	0.144	0.347
17:	-0.246	0.666
18:	-0.376	0.163
19:	-0.807	-0.085
20:	-0.994	0.348

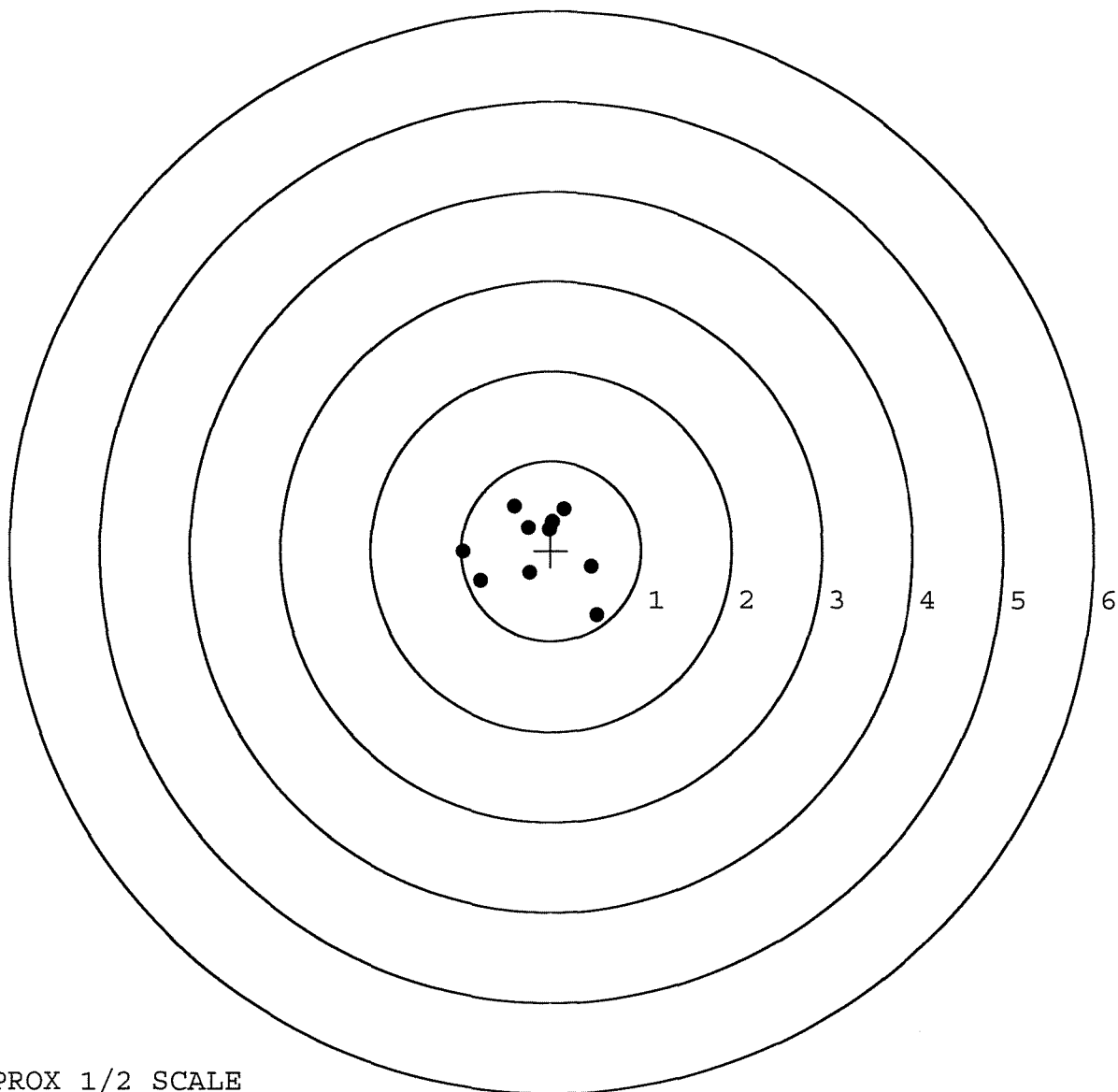


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6225376. __0
 TARGET NUMBER: 2
 FILE DATE: 03/21/2003
 FILE TIME: 15:26

X CENTROID: -0.155
 Y CENTROID: 0.028
 POA TO CENTROID: 0.158
 HORZ SPREAD: 1.487
 VERT SPREAD: 1.213
 GROUP SPREAD: 1.643
 MIN RADIUS: 0.251
 MAX RADIUS: 1.000
 MEAN RADIUS: 0.539
 # IN 1 IN DIAMETER: 4
 # IN 2 IN DIAMETER: 9
 # in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.512	-0.717
2:	0.452	-0.178
3:	-0.238	-0.247
4:	-0.786	-0.336
5:	-0.975	-0.018
6:	-0.407	0.496
7:	-0.260	0.258
8:	-0.018	0.239
9:	0.023	0.322
10:	0.146	0.465

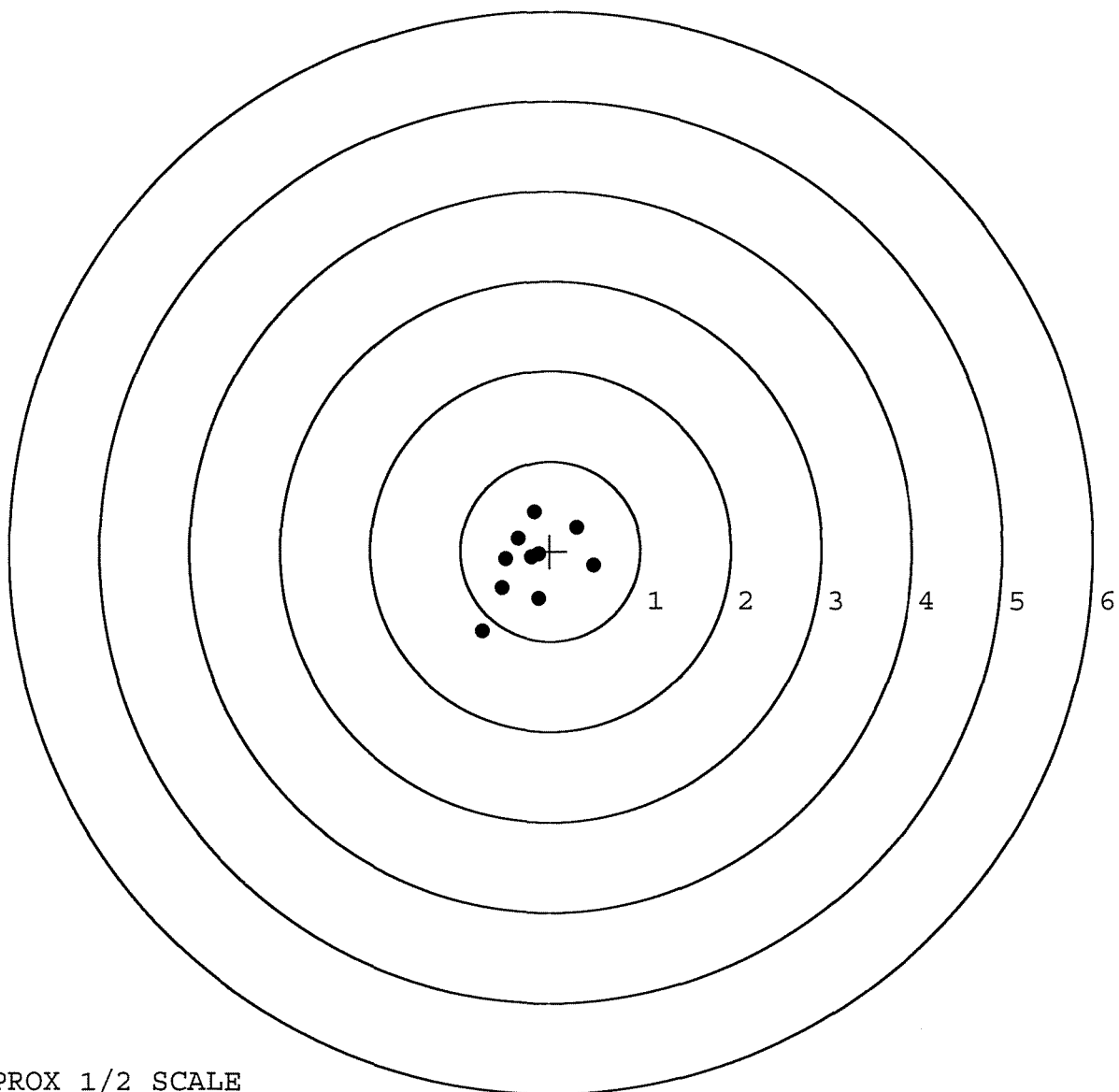


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6225376. __0
TARGET NUMBER: 3
FILE DATE: 03/21/2003
FILE TIME: 15:26

POINT#	X	Y
1:	0.484	-0.164
2:	0.288	0.261
3:	-0.185	0.435
4:	-0.131	-0.530
5:	-0.759	-0.896
6:	-0.537	-0.415
7:	-0.499	-0.098
8:	-0.133	-0.034
9:	-0.355	0.140
10:	-0.209	-0.072

X CENTROID: -0.204
Y CENTROID: -0.137
POA TO CENTROID: 0.246
HORZ SPREAD: 1.243
VERT SPREAD: 1.331
GROUP SPREAD: 1.560
MIN RADIUS: 0.066
MAX RADIUS: 0.940
MEAN RADIUS: 0.447
IN 1 IN DIAMETER: 6
IN 2 IN DIAMETER: 10
in 3 IN DIAMETER: 10

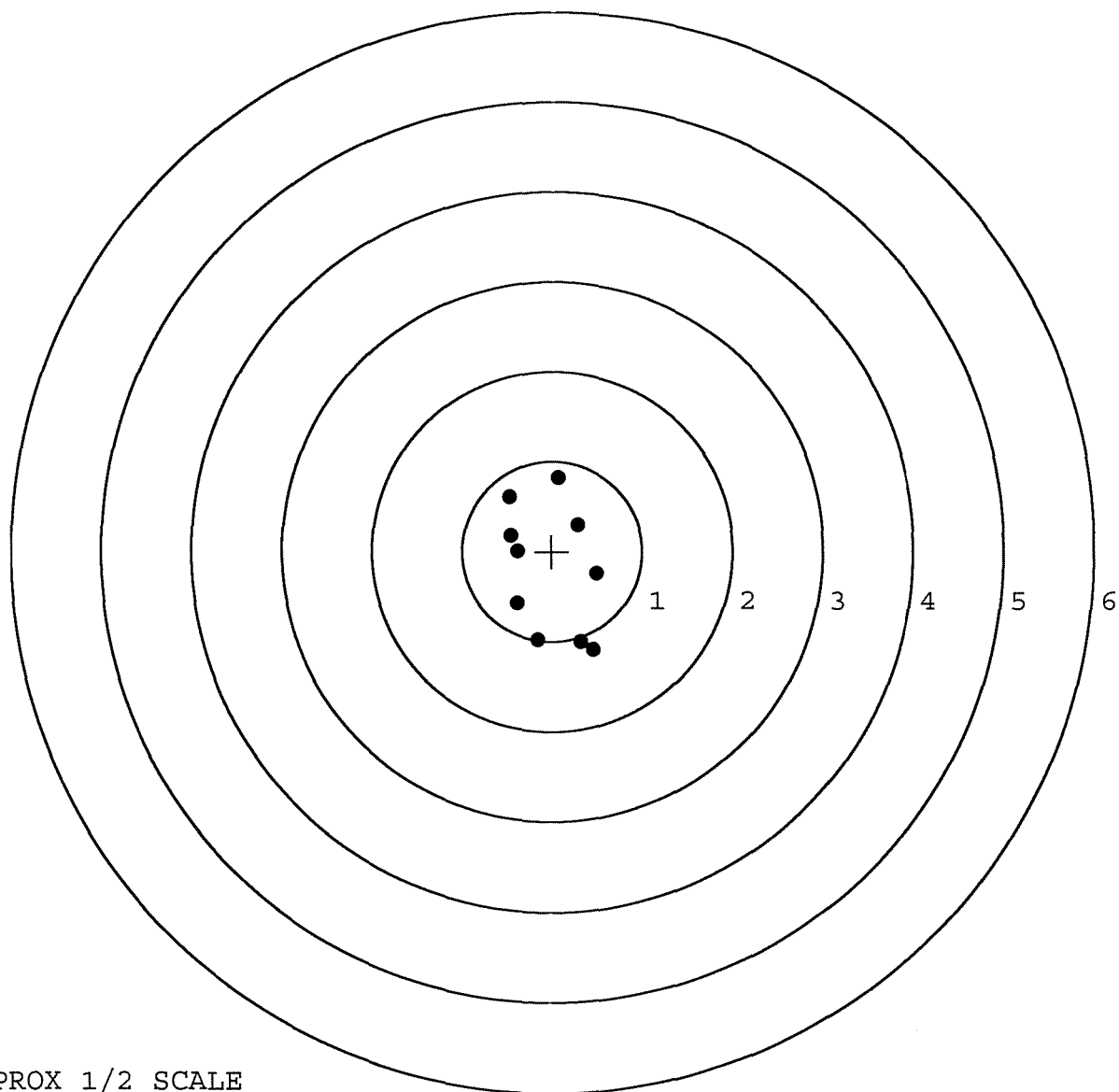


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6225376. __0
 TARGET NUMBER: 4
 FILE DATE: 03/21/2003
 FILE TIME: 15:26

X CENTROID: -0.023
 Y CENTROID: -0.204
 POA TO CENTROID: 0.205
 HORZ SPREAD: 0.970
 VERT SPREAD: 1.913
 GROUP SPREAD: 1.952
 MIN RADIUS: 0.414
 MAX RADIUS: 1.024
 MEAN RADIUS: 0.727
 # IN 1 IN DIAMETER: 1
 # IN 2 IN DIAMETER: 8
 # in 3 IN DIAMETER: 10

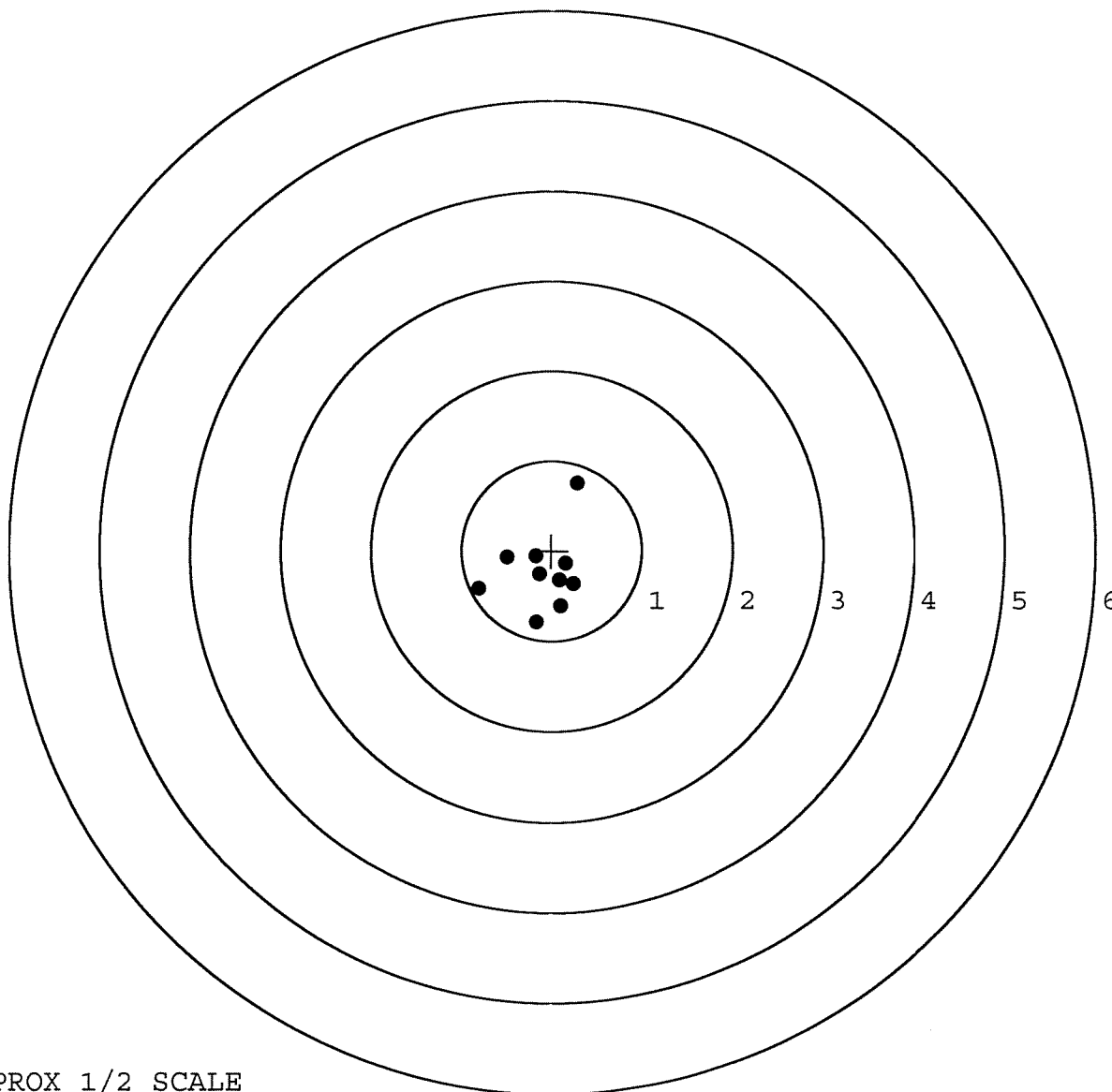
POINT#	X	Y
1:	0.463	-1.097
2:	0.323	-1.010
3:	0.494	-0.251
4:	0.283	0.296
5:	0.073	0.816
6:	-0.476	0.602
7:	-0.456	0.177
8:	-0.382	0.002
9:	-0.392	-0.580
10:	-0.157	-0.993



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6225376. __0
TARGET NUMBER: 5
FILE DATE: 03/21/2003
FILE TIME: 15:26

	POINT#	X	Y
	1:	0.280	0.749
	2:	-0.500	-0.075
	3:	-0.812	-0.426
	4:	-0.171	-0.798
	5:	-0.180	-0.064
	6:	-0.140	-0.261
	7:	0.154	-0.142
	8:	0.241	-0.370
	9:	0.100	-0.617
	10:	0.091	-0.328
X CENTROID:		-0.094	
Y CENTROID:		-0.233	
POA TO CENTROID:		0.251	
HORZ SPREAD:		1.092	
VERT SPREAD:		1.547	
GROUP SPREAD:		1.611	
MIN RADIUS:		0.054	
MAX RADIUS:		1.051	
MEAN RADIUS:		0.431	
# IN 1 IN DIAMETER:		7	
# IN 2 IN DIAMETER:		9	
# in 3 IN DIAMETER:		10	



TARGET APPROX 1/2 SCALE

2.50#
3.00#
4.00#

TESTER

TRC

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#	COMMENTS
PULL #1	2.51	2.62	2.68	MIN. SETTING,
PULL #2	2.67	2.36	2.55	NO AVG. OF 5
PULL #3	2.50	2.51	2.69	READINGS ACCEPT
PULL #4	2.61	2.55	2.71	ABLE LESS THAN
PULL #5	2.62	2.45	2.65	
TOTAL	12.91	12.49	13.28	
AVG.	2.58	2.49	2.65	

	3.00# INITIAL	3.00# AFTER 20 CYCLES	COMMENTS
PULL #1	3.24	3.47	
PULL #2	3.09	3.03	
PULL #3	3.16	3.39	
PULL #4	3.17	3.37	
PULL #5	3.11	3.35	
TOTAL	15.77	16.61	
AVG.	3.15	3.32	

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# & TARGET & ACCU
PULL #1	4.21	4.44		4.33
PULL #2	4.24	4.22		4.31
PULL #3	4.45	4.24		4.24
PULL #4	4.39	4.29		4.26
PULL #5	4.14	4.22		4.19
TOTAL	21.43	21.41		21.33
AVG.	4.28	4.28		4.26

R & E NUMBER	62255		
SERIAL NUMBER	C6225376		
LOG-IN DATE	2-26-03		
INSPECT AND VERIFY:			
OPERATION #	OPERATION NAME	DATE	INITIAL
550	DIS-ASSEMBLE GUN	2-27-03	RTL
560 A	RE-BARREL	3-4-03	RTL
B	DRILL AND TAP	3-6-03	TRW
575	ASSEMBLE	3-5-03	RTL
600	PROOF	3-5-03	AC
605	CHECK HEADSPACE	3-5-03	AC
610	DIS-ASSEMBLE GUN	3-5-03	AC
612	MAGNAFLUX OPERATOR	2-7-03	JO
615	ROLLMARK CALIBER	3-7-03	JB
618	ROTO-BLAST	3/10/03	SO
620	APPLY COATINGS	3-18	TA
625 A	FINAL ASSEMBLY	3-19-03	RW
B	TRIGGER PULL TEST		
C	SAFETY "ON" FORCE		
D	SAFETY "OFF" FORCE		
E	FIRING PIN INDENT		
640	TARGET	3-20-03	TRW
655	FINAL INSPECT	3-21-03	RTL
660	PACK	3-21-03	NA
		SHIP DATE	
	QAR INSPECTION DATE		

C6225376

MOD. _____ GA. CAL. _____ GUN # _____

# TEST	DATE	MALFUNCTION/DEFECT	ASSEM. #
	1st	SHROUD OF BOLT FACE DISTORTED	
	2nd	4/21/89 100 Rds OK - DH	
	3rd		
	4th		
		FUNCTION	

RD 6654

Rev 1

TEST INIT. ACTION TO CORRECT		ASSEM. #
PROOF	NEW BOLT ASSEMBLED 100 SHOT FUNCTION TEST.	
TEST		
TGT		
PROOF		
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		

Remington



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

MODEL 700™ H24

SERIAL NO.
C6225376

ORDER NO.
5716

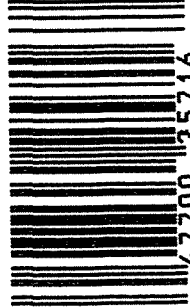
Ø1

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



5716 C6225376

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6225376

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	3 17	89	RW
600	Proof	3 17	89	RW
607	Check Headspace	3 17	89	RW
610	Dis-assemble Gun	3 17	89	RW
612	Magnaflux Barrel Action		3/21	KCR
	Magnaflux Bolt		3/21	KCR
615	Rollmark Caliber		3/21	GL
617	Drill and Tap Sight Holes	3 22	89	FB
618	Polish Barrel	3 22	89	BT.
620	Apply Coatings (Barrel Action)		3/21/89	TSA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		4/6/89	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		4/6/89	RW
	C) Inspect Ejector Hole for Chamfer		4/6/89	RW
	D) Oil Firing Pin Ass'y		4/6/89	RW
	E) Adjust Trigger Pull to Min Setting and Stake		4/7/89	LS

Op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	7	7	7			4/7/89	94
	G) Safety Off Force	4	4	4			4/7/89	94
	H) Trigger Pull Test & Retainability						4/7/89	B.S
	I) Firing Pin Indent	.020	.020	.021			4/7/89	94
	J) Assemble Stock						4/10/89	RW
	K) Assemble Swivel Studs						25 April 89	JD
	L) Attach Front and Rear Sight Assemblies						4/10/89	RW
	M) Iron Sight Alignment						4/10/89	RW
	N) Detach Front & Rear Sights & place in numbered container						4/10/89	RW
	O) Attach Scope to Rifle						4/10/89	JLE
	P) Detach & Attach Scope 20 Times						4/10/89	JLE
640	Gallery Target & Test	65 R	87 L				4-12-89	K
	A) Time						"	AC
	B) Malfunctions			NONE			"	AC
	C) Pierced Primers			NONE			"	AC
	D) Optical Clarity of Scope			OK			"	AC
645	Inspect for Live Ammo			NONE			4-12-89	AC
655	Final Inspection A) Headspace						25 April 89	JD
	B) Trigger Pull	2.76	2.82	2.80	2.75	2.80	25 April 89	JD
	C) Function						25 April 89	JD
660	Pack						27 June 89	JD

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6225376DATE 3-30-90TESTER JD

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.38	2.46		2.21	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.47	2.45		2.25	
PULL #3	2.28	2.28		2.14	
PULL #4	2.37	2.33		2.36	
PULL #5	2.42	2.26		2.34	
TOTAL	11.92	11.78		11.30	
AVG.	2.384	2.356		2.26	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.44	3.52		
PULL #2	3.37	3.50		
PULL #3	3.34	3.35		
PULL #4	3.37	3.60		
PULL #5	3.45	3.56		
TOTAL	16.97	17.53		
AVG.	3.394	3.506		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.23	4.42		
PULL #2	4.11	4.46		
PULL #3	4.56	4.42		
PULL #4	4.29	4.44		
PULL #5	4.37	4.45		
TOTAL	21.56	22.19		
AVG.	4.312	4.438		

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6225376
12 Apr 1989

CENTROIDAL DISTANCES

0 TO	1	.390083
1 TO	2	.588982
1 TO	3	.618066
1 TO	4	.755747
1 TO	5	.57771

1 <----FOR

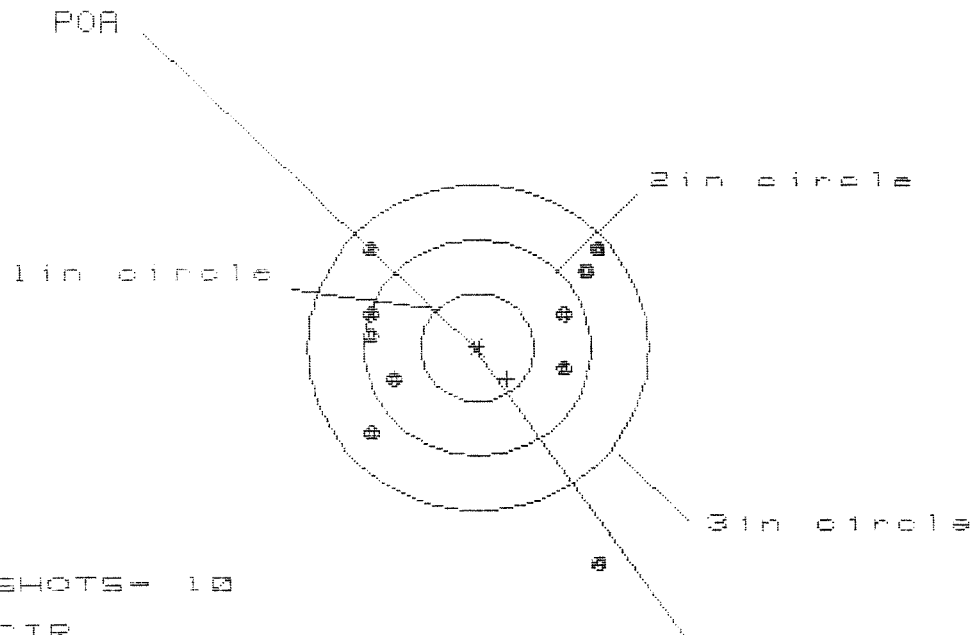
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .032
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1214
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .125547
THE AMR FOR THIS RIFLE IS: 1.141

12 Apr 1989

FILE:/PATTERNING/CENTERFIRE_PATT/08225378

CENTERFIRE PATTERNS

1



OF SHOTS- 10

IN CIR

1 in = 0

2 in = 5

3 in = 9

HS= 2.086

VS= 2.928

GS= 3.553

PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.103	1.221	1.193
MINIMUM X	:	-.984	-.865	-.712
MAXIMUM Y	:	.927	.705	.776
MINIMUM Y	:	-2.001	-.991	-.903
CENTROID X	:	-.262	-.381	-.534
CENTROID Y	:	.289	.511	.423
POA TO CENTROID in.	:	.390	.638	.681
MIN RADIUS	:	.743	.791	.618
MEAN RADIUS	:	1.168	1.022	.943
MAX RADIUS	:	2.269	1.410	1.323
HORIZONTAL SPREAD	:	2.086	2.086	1.985
VERTICAL SPREAD	:	2.928	1.696	1.679
EXTREME SPREAD	:	3.553	2.652	2.373
NUMBER IN ONE INCH CIRCLE	=	0		
NUMBER IN TWO INCH CIRCLE	=	5		
NUMBER IN THREE INCH CIRCLE	=	9		

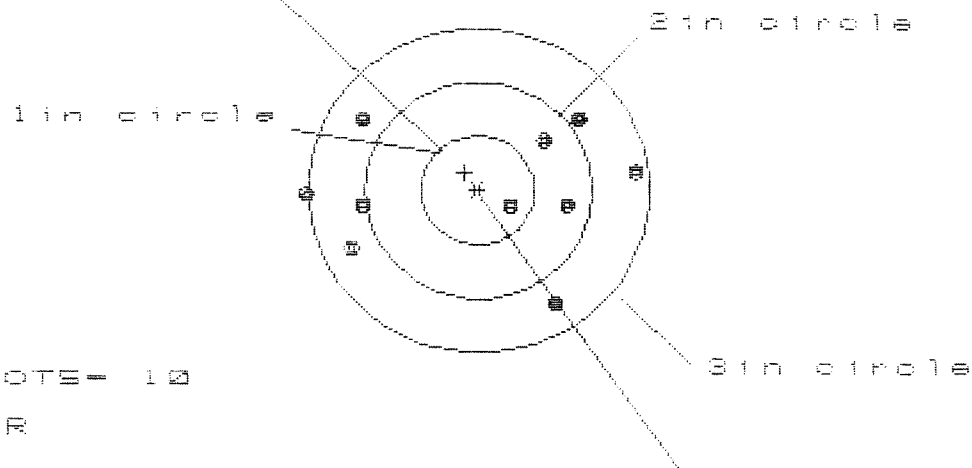
12 Apr 1989

FILE:/PATTERNING/CENTERFIRE_PATT/08225376

CENTERFIRE PATTERNS

2

POA



OF SHOTS = 10

IN CIR

1in = 1

2in = 3

3in = 6

HS = 2.962

VS = 1.716

GS = 2.968

CENTROID #

PATTERN # : 2

SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.423	1.252	.987
MINIMUM X	:	-1.539	-1.278	-1.121
MAXIMUM Y	:	.674	.676	.702
MINIMUM Y	:	-1.042	-1.040	-1.014
CENTROID X	:	.118	.289	.132
CENTROID Y	:	-.161	-.163	-.189
POA TO CENTROID in.	:	.200	.331	.230
MIN RADIUS	:	.303	.190	.276
MEAN RADIUS	:	1.069	.980	.960
MAX RADIUS	:	1.539	1.388	1.235
HORIZONTAL SPREAD	:	2.962	2.530	2.088
VERTICAL SPREAD	:	1.716	1.716	1.716
EXTREME SPREAD	:	2.968	2.639	2.426
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	3		
NUMBER IN THREE INCH CIRCLE	=	9		

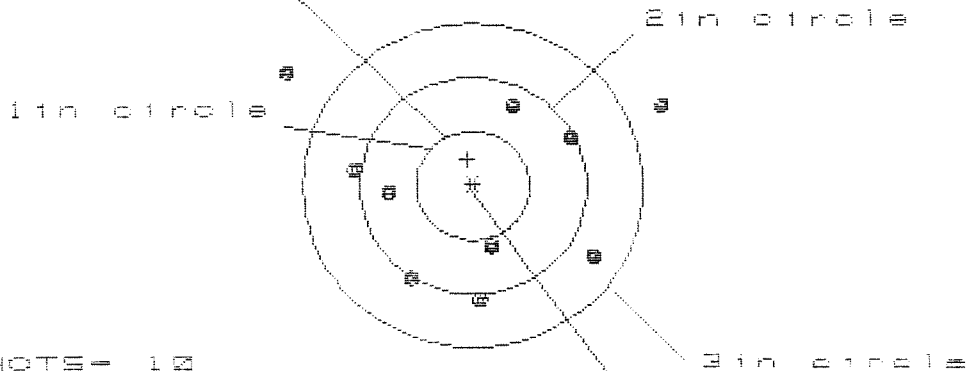
12 Apr 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C8225376

CENTERFIRE PATTERNS

3

POA



OF SHOTS= 10

IN CIR

1in = 0

2in = 4

3in = 6

HS= 3.251

VS= 2.098

GS= 3.263

CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.612	1.430	1.044
MINIMUM X	:	-1.639	-1.271	-1.092
MAXIMUM Y	:	1.062	.899	.957
MINIMUM Y	:	-1.036	-.918	-.806
CENTROID X	:	.044	.226	.047
CENTROID Y	:	-.248	-.366	-.478
POA TO CENTROID in.	:	.251	.430	.480
MIN RADIUS	:	.630	.482	.415
MEAN RADIUS	:	1.126	1.013	.902
MAX RADIUS	:	1.953	1.689	1.149
HORIZONTAL SPREAD	:	3.251	2.701	2.136
VERTICAL SPREAD	:	2.098	1.817	1.763
EXTREME SPREAD	:	3.263	2.779	2.266
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	

12 Apr 1989

FILE:/PATTERNING/CENTERFIRE_PATT/08225376

CENTERFIRE PATTERNS

4

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS= 10

IN CIR

1in = 1

2in = 5

3in = 7

HS= 3.0225

VS= 2.0666

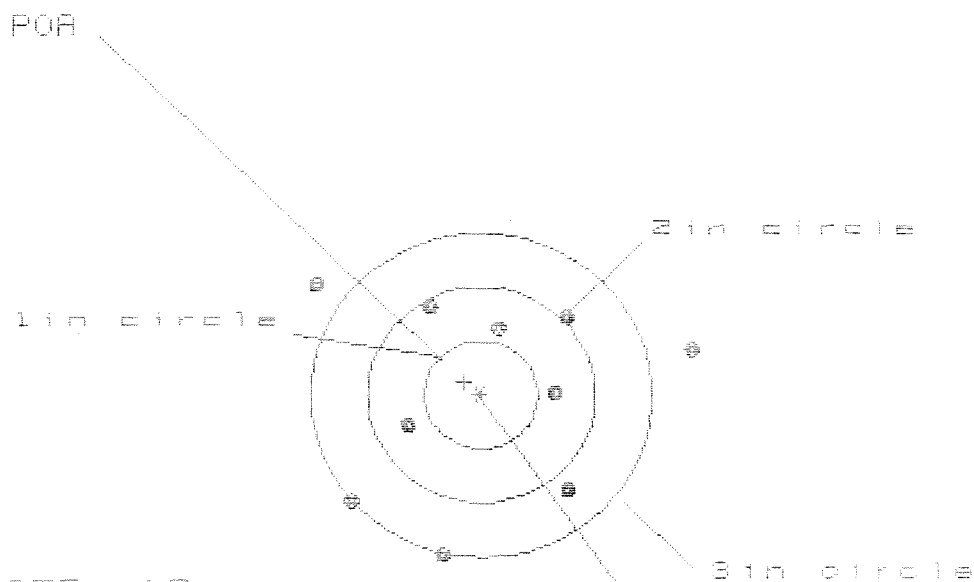
GS= 3.664

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.497	1.128	.957
MINIMUM X	:	-1.529	-1.362	-1.322
MAXIMUM Y	:	1.184	1.240	1.146
MINIMUM Y	:	-.882	-.750	-.824
CENTROID X	:	.115	-.052	.119
CENTROID Y	:	-.366	-.498	-.404
POA TO CENTROID in.	:	.384	.501	.421
MIN RADIUS	:	.452	.481	.419
MEAN RADIUS	:	1.169	1.090	.999
MAX RADIUS	:	1.909	1.692	1.750
HORIZONTAL SPREAD	:	3.026	2.490	2.279
VERTICAL SPREAD	:	2.066	1.990	1.570
EXTREME SPREAD	:	3.664	2.886	2.886
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		7	

12 Apr 1988

FILE:/PATTERNING/CENTERFIRE_PATT/06225376

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in = 0

2 in = 4

3 in = 7

HS = 3.2000

VS = 2.5000

GS = 3.343

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.807	1.003	.843
MINIMUM X	:	-1.481	-1.281	-1.099
MAXIMUM Y	:	1.013	1.059	1.014
MINIMUM Y	:	-1.493	-1.447	-1.315
CENTROID X	:	.145	-.055	.105
CENTROID Y	:	-.121	-.167	-.299
POR TO CENTROID in.	:	.189	.176	.317
MIN RADIUS	:	.588	.487	.605
MEAN RADIUS	:	1.174	1.095	1.015
MAX RADIUS	:	1.852	1.662	1.351
HORIZONTAL SPREAD	:	3.288	2.284	1.942
VERTICAL SPREAD	:	2.506	2.506	2.329
EXTREME SPREAD	:	3.343	2.988	2.567
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		7	

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6225376

OP. #	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and Stock		3/20/96	RW
600	Proof		3/20/96	RW
607	Check Headspace		3/20/96	RW
610	Dis-assemble Gun		3/20/96	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		4/3/96	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		4/3/96	RW
	C) Inspect Ejector Hole for Chamfer		4/3/96	RW
	D) Oil Firing Pin Ass'y		4/3/96	RW
	E) Adjust Trigger Pull to Min Setting and Stake			

Op. #	OP. NAME	READINGS			DATE	INITIALS
625 cont.	F) Safety On Force					
	G) Safety Off Force					
	H) Trigger Pull Test & Retainability					
	I) Firing Pin Indent					
	J) Assemble Stock				4/3/96	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				4/3/96	PH
	A) Time					
	B) Malfunctions					
	C) Pierced Primers					
	D) Optical Clarity of Scope					
645	Inspect for Live Ammo				4/3/96	PH
655	Final Inspection					
	A) Headspace				4/4/96	RW
	B) Trigger Pull					
	C) Function				4/4/96	RW
660	Pack					

Final Inspection

Sn: C6225376 DATE REC'D: 2/26/96 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:

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06225376
5 Feb 1988

CENTROIDAL DISTANCES

0 TO	1	1.09151
1 TO	2	.187427
1 TO	3	.562716
1 TO	4	.255055
1 TO	5	.341901

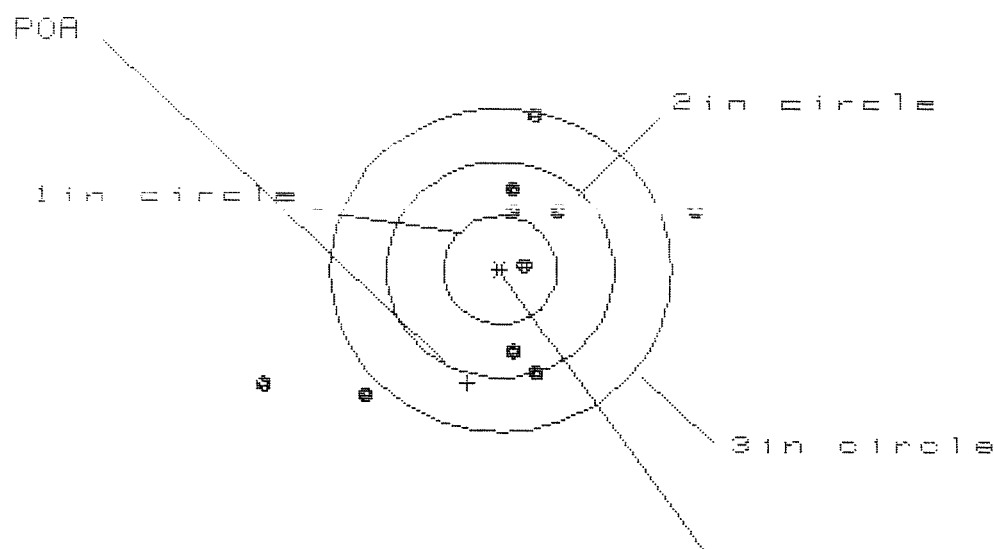
4^{le}
3
+ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .2644
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .8252
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .866523
THE AMR FOR THIS RIFLE IS: 1.124

5 Feb 1988

FILE:/PATTERNING/CENTERFIRE_PATT/06225376

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 5

3 in = 7

HS= 3.819

VS= 2.578

GS= 4.154

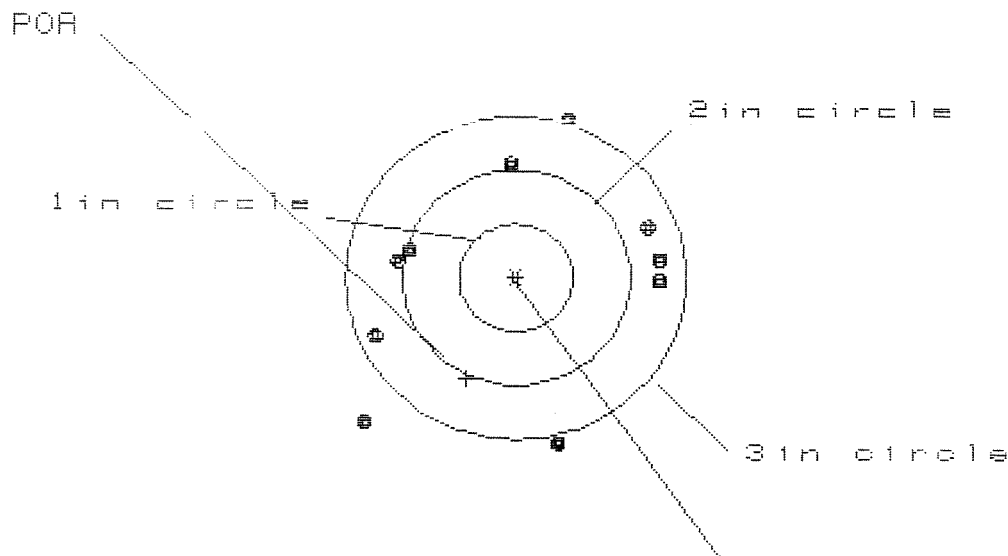
CENTROID #

PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.723	1.490	.447
MINIMUM X	:	-2.096	-1.427	-1.240
MAXIMUM Y	:	1.448	1.332	1.392
MINIMUM Y	:	-1.130	-1.246	-1.186
CENTROID X	:	.291	.524	.337
CENTROID Y	:	1.052	1.168	1.108
POA TO CENTROID in.	:	1.091	1.280	1.158
MIN RADIUS	:	.179	.114	.138
MEAN RADIUS	:	1.114	.927	.855
MAX RADIUS	:	2.341	1.894	1.716
HORIZONTAL SPREAD	:	3.819	2.917	1.687
VERTICAL SPREAD	:	2.578	2.578	2.578
EXTREME SPREAD	:	4.154	3.387	2.998
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	6		
NUMBER IN THREE INCH CIRCLE	=	7		

5 Feb 1968

FILE:/PATTERNING/CENTERFIRE_PATT/C6225376

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1 in = 0

2 in = 1

3 in = 7

HS= 2.547

VS= 3.046

GS= 3.356

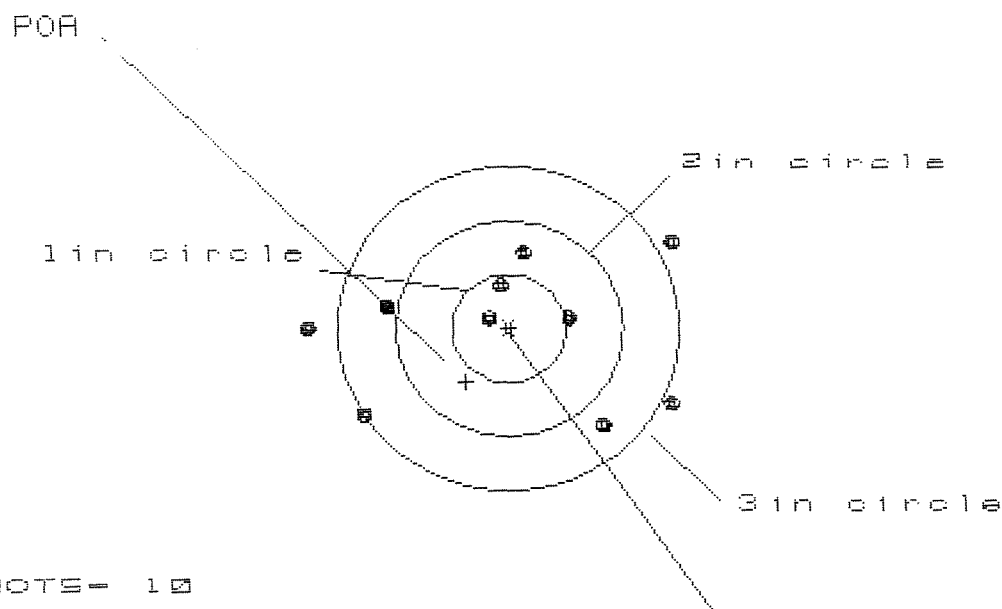
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.257	1.113	1.141
MINIMUM X	:	-1.290	-1.370	-1.342
MAXIMUM Y	:	1.491	1.342	1.129
MINIMUM Y	:	-1.555	-1.704	-0.949
CENTROID X	:	.439	.583	.555
CENTROID Y	:	.937	1.086	1.299
POA TO CENTROID in.	:	1.035	1.233	1.413
MIN RADIUS	:	.954	.921	.706
MEAN RADIUS	:	1.319	1.234	1.144
MAX RADIUS	:	1.864	1.718	1.644
HORIZONTAL SPREAD	:	2.547	2.483	2.483
VERTICAL SPREAD	:	3.046	3.046	2.078
EXTREME SPREAD	:	3.356	3.049	2.704
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		1	
NUMBER IN THREE INCH CIRCLE	=		7	

5 Feb 1988

FILE:/PATTERNING/CENTERFIRE_PATT/06225376

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1 in = 2

2 in = 4

3 in = 7

HS= 3.249

VS= 1.651

GS= 3.336

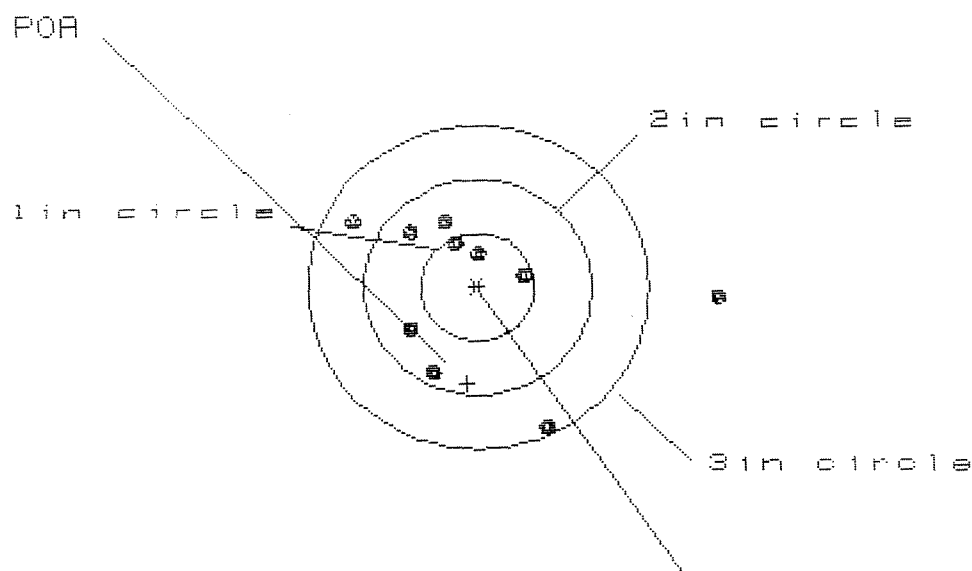
CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.446	1.245	1.382
MINIMUM X	:	-1.803	-1.477	-1.321
MAXIMUM Y	:	.800	.804	.856
MINIMUM Y	:	-.851	-.847	-.746
CENTROID X	:	.371	.572	.416
CENTROID Y	:	.495	.491	.390
POA TO CENTROID in.	:	.619	.753	.570
MIN RADIUS	:	.140	.332	.237
MEAN RADIUS	:	1.070	.985	.925
MAX RADIUS	:	1.804	1.670	1.521
HORIZONTAL SPREAD	:	3.249	2.722	2.703
VERTICAL SPREAD	:	1.651	1.651	1.602
EXTREME SPREAD	:	3.336	3.150	2.703
NUMBER IN ONE INCH CIRCLE =			2	
NUMBER IN TWO INCH CIRCLE =			4	
NUMBER IN THREE INCH CIRCLE =			7	

5 Feb 1988

FILE:/PATTERNING/CENTERFIRE_PATT/06225376

CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1 in = 3

2 in = 7

3 in = 9

HS= 3.228

VS= 1.939

GS= 3.300

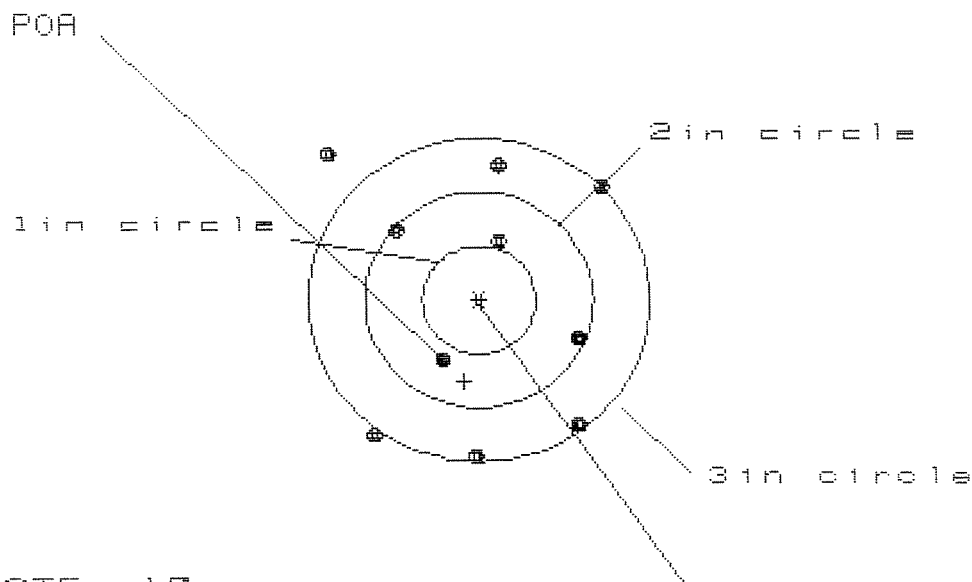
CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.139	.818	.794
MINIMUM X	:	-1.089	-.851	-.749
MAXIMUM Y	:	.652	.638	.476
MINIMUM Y	:	-1.287	-1.301	-.919
CENTROID X	:	.094	-.144	-.246
CENTROID Y	:	.890	.904	1.066
POA TO CENTROID in.	:	.895	.915	1.094
MIN RADIUS	:	.330	.372	.231
MEAN RADIUS	:	.906	.729	.582
MAX RADIUS	:	2.143	1.537	.920
HORIZONTAL SPREAD	:	3.228	1.669	1.543
VERTICAL SPREAD	:	1.939	1.939	1.395
EXTREME SPREAD	:	3.300	2.492	1.597
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

5 Feb 1968

FTIF:/PATTERNING/CENTERFIRE_PATT/CA225326

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 0

2in = 4

3in = 7

HS= 2.387

VS= 2.767

GS= 3.279

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.103	.961	.832
MINIMUM X	:	-1.284	-1.028	-.979
MAXIMUM Y	:	1.332	1.362	1.225
MINIMUM Y	:	-1.435	-1.287	-1.424
CENTROID X	:	.127	.269	.398
CENTROID Y	:	.752	.604	.741
POA TO CENTROID in.	:	.763	.661	.841
MIN RADIUS	:	.594	.628	.589
MEAN RADIUS	:	1.210	1.125	1.066
MAX RADIUS	:	1.850	1.524	1.447
HORIZONTAL SPREAD	:	2.387	1.989	1.811
VERTICAL SPREAD	:	2.767	2.649	2.649
EXTREME SPREAD	:	3.279	3.024	2.700
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		7	