

C6594647

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

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: **RE00083173**

Serial: C6594647 Model M24 SWS Center Fire
Caliber: 7.62 NATO Produced: 06/18/1991

Repairman:

Verify Repair

High Priority

Status:

Closed 7/28/2004 1:56:48 PM

Address Information

Customer:

☒ Received From

Return To:

☐ Received From

Name: **BRIAN CROWLEY MSG**

BRIAN CROWLEY MSG

Address 1: **USPFO VT WHSE**

USPFO VT WHSE

Address 2:

PO Box:

COLCHESTER

PO Box:

City: **COLCHESTER**

COLCHESTER

State: **VT**

Zip Code: **05446**

Country: **US**

State: **VT**

Zip Code: **05446**

Country: **US**

FFL:

Contact / Condition

Problems

Estimate

History / Status

Shipping / Billing

Date	Code	User ID	Desc1
7/26/2004 2:18:1	New	franzj	Repair Added
7/28/2004 1:43:3	Update	urtzgj	Repair information change
7/28/2004 1:48:3	Closed	urtzgj	
7/28/2004 1:56:1	ReOpened	urtzgj	
7/28/2004 1:56:3	Expedite	urtzgj	From: Check In
7/28/2004 1:56:4	Closed	urtzgj	

- ☐ Shipping Hold
- ☐ InterFace Hold
- ☐ Estimate Sent
- ☐ Parts Received
- ☐ Passed Inspection
- ☐ Return As Received
- ☐ Has been Approved
- ☐ Internal Repair

Current Status

Closed

7/28/2004 1:56:48 PM

urtzgj

Sniper Systems

Repair Location

ILN

Current Location

ILN

Transfer Number

Repair Search

Refresh

Close

eglandit

8/2/2004

7:17 AM

CAPS

NUM

INS

SCRL

U start

Inbox - Microsoft...

2 Windows Exp...

2 ArmRE

SNAdmin - Serial ...

7:17 AM

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50 LBS (plus or minus 0.50 LBS)
3.00 LBS (plus or minus 0.75 LBS)
4.00 LBS (plus or minus 1.00 LBS)

SERIAL NO. _____

DATE 7-23-04

TESTER TRW

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.37	2.71		2.47	
PULL #2	2.41	2.62		2.51	
PULL #3	2.86	2.29		2.37	
PULL #4	2.71	2.55		2.41	
PULL #5	2.73	2.56		2.44	
TOTAL	13.08	12.73		12.20	
AVERAGE	2.61	2.54		2.44	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.43	3.16		
PULL #2	3.42	3.43		
PULL #3	3.23	3.51		
PULL #4	3.11	3.33		
PULL #5	3.12	3.33		
TOTAL	16.31	16.76		
AVERAGE	3.26	3.35		

	4.00 LBS INITIAL	4.00 LBS AFTER 20 CYCLES	MAX SETTING GREATER THAN 4 LBS	RESET TO 4 LBS FOR TARGET & ACCURACY
PULL #1	4.20	4.18		4.05
PULL #2	4.27	4.29		3.95
PULL #3	4.46	4.15		4.47
PULL #4	4.10	4.19		4.46
PULL #5	4.29	4.19		4.33
TOTAL	21.32	21.00		21.26
AVERAGE	4.26	4.20		4.25

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6594647.__0

FILE DATE AND TIME: 08/18/2004 06:30

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.080
The Average Y Centroid of the Five Target Set:	0.052
The Average Point of Impact of the Five Target Set:	0.095
The Average Mean Radius of the Five Target Set:	0.674
The Distance from POA to Centroid Target #1:	0.364
The Distance from Centroid Target #2 to Centroid Target #1:	0.316
The Distance from Centroid Target #3 to Centroid Target #1:	0.285
The Distance from Centroid Target #4 to Centroid Target #1:	0.529
The Distance from Centroid Target #5 to Centroid Target #1:	0.339

SERIAL NUMBER: C6594647. 0

TARGET NUMBER: 1

FILE DATE: 08/18/2004

FILE TIME: 06:30

X CENTROID: 0.364

Y CENTROID: -0.015

POA TO CENTROID: 0.364

HORZ SPREAD: 1.414

VERT SPREAD: 1.967

GROUP SPREAD: 2.072

MIN RADIUS: 0.186

MAX RADIUS: 1.202

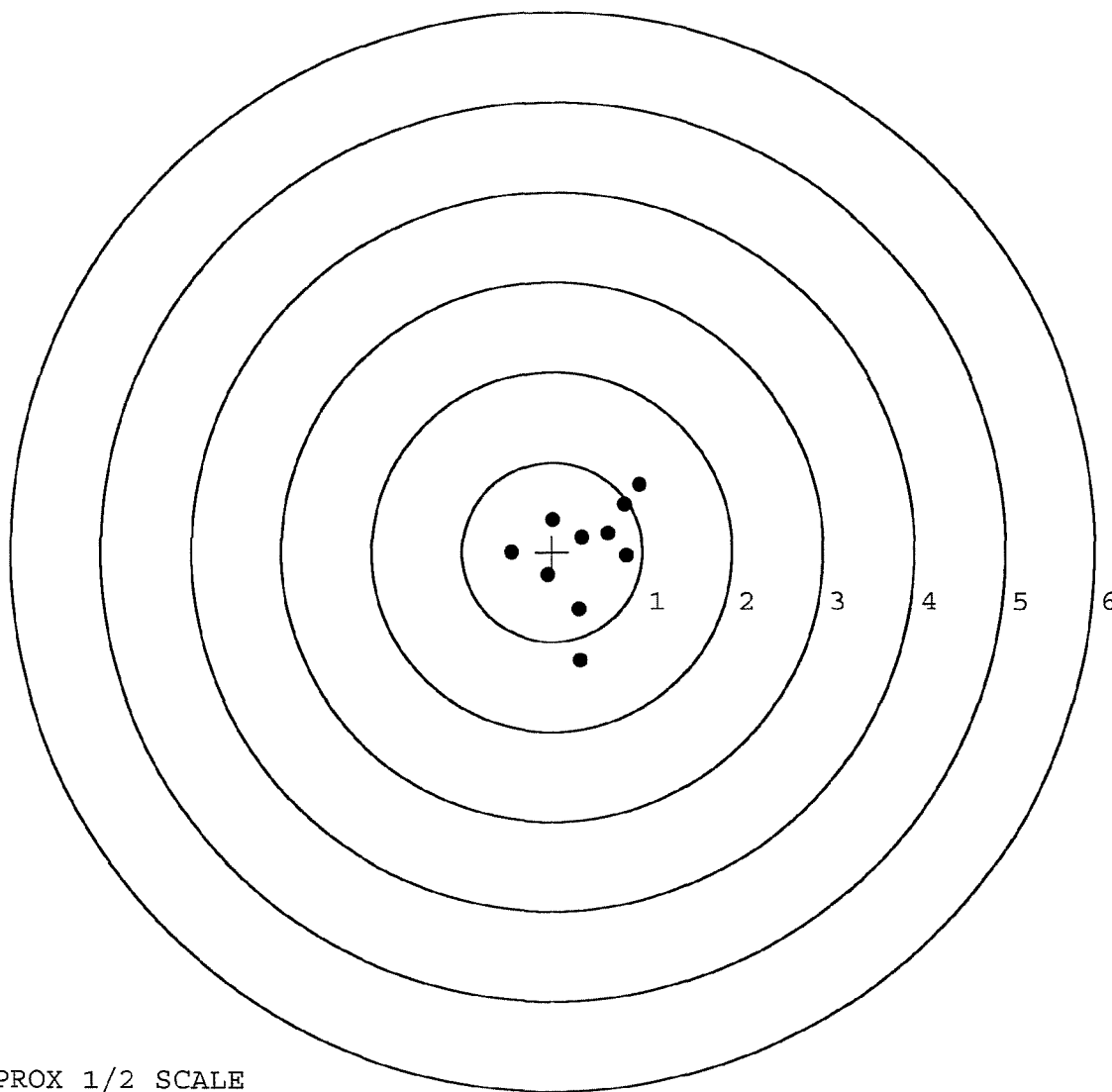
MEAN RADIUS: 0.631

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.310	-1.216
2:	0.294	-0.644
3:	-0.047	-0.257
4:	-0.452	-0.013
5:	0.004	0.365
6:	0.323	0.166
7:	0.962	0.751
8:	0.825	-0.042
9:	0.797	0.529
10:	0.620	0.210

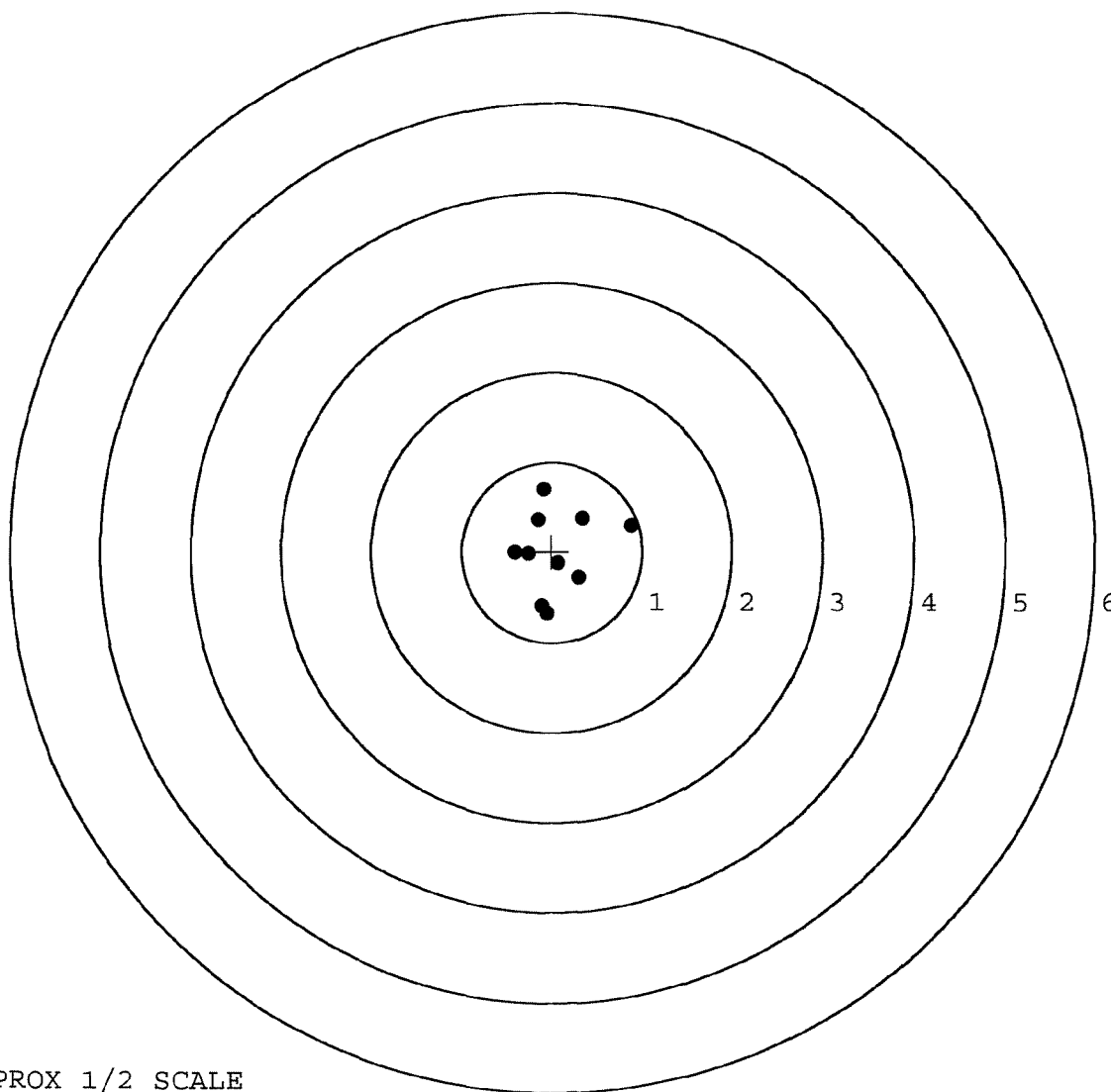


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6594647. __0
TARGET NUMBER: 2
FILE DATE: 08/18/2004
FILE TIME: 06:30

X CENTROID: 0.048
Y CENTROID: -0.001
POA TO CENTROID: 0.048
HORZ SPREAD: 1.286
VERT SPREAD: 1.385
GROUP SPREAD: 1.348
MIN RADIUS: 0.131
MAX RADIUS: 0.877
MEAN RADIUS: 0.507
IN 1 IN DIAMETER: 6
IN 2 IN DIAMETER: 10
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.875	0.290
2:	0.340	0.376
3:	-0.096	0.699
4:	-0.158	0.358
5:	-0.411	-0.013
6:	-0.266	-0.024
7:	-0.055	-0.686
8:	-0.115	-0.601
9:	0.294	-0.280
10:	0.068	-0.131

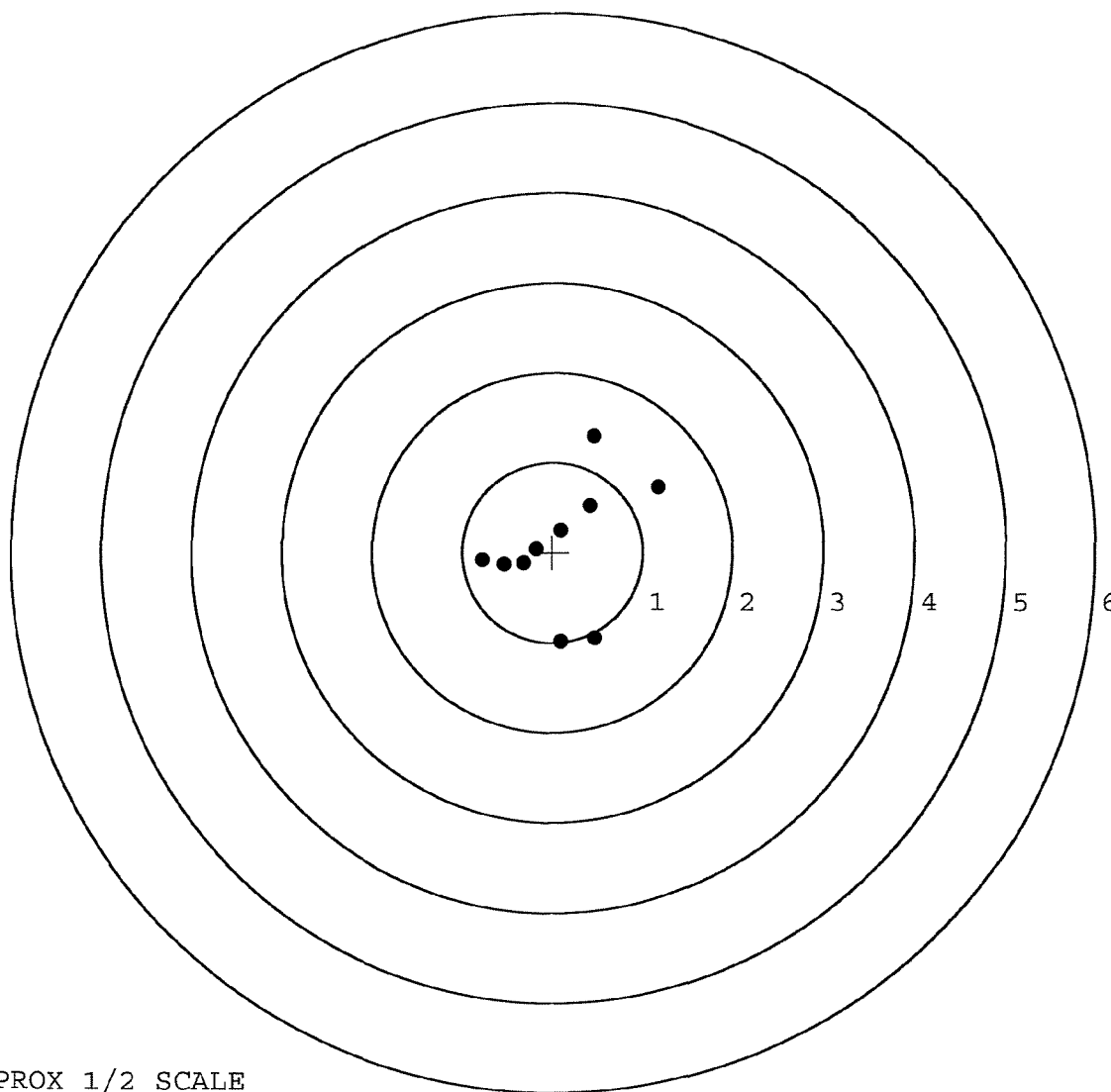


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6594647. 0
TARGET NUMBER: 3
FILE DATE: 08/18/2004
FILE TIME: 06:30

X CENTROID: 0.087
Y CENTROID: 0.051
POA TO CENTROID: 0.101
HORZ SPREAD: 1.943
VERT SPREAD: 2.287
GROUP SPREAD: 2.315
MIN RADIUS: 0.194
MAX RADIUS: 1.295
MEAN RADIUS: 0.769
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 6
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.469	-0.957
2:	0.097	-0.996
3:	1.167	0.726
4:	0.458	1.291
5:	-0.776	-0.093
6:	0.407	0.514
7:	0.091	0.245
8:	-0.539	-0.139
9:	-0.322	-0.124
10:	-0.184	0.040



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6594647. 0

TARGET NUMBER: 4

FILE DATE: 08/18/2004

FILE TIME: 06:30

X CENTROID: -0.129

Y CENTROID: 0.178

POA TO CENTROID: 0.220

HORZ SPREAD: 1.385

VERT SPREAD: 1.279

GROUP SPREAD: 1.602

MIN RADIUS: 0.376

MAX RADIUS: 0.838

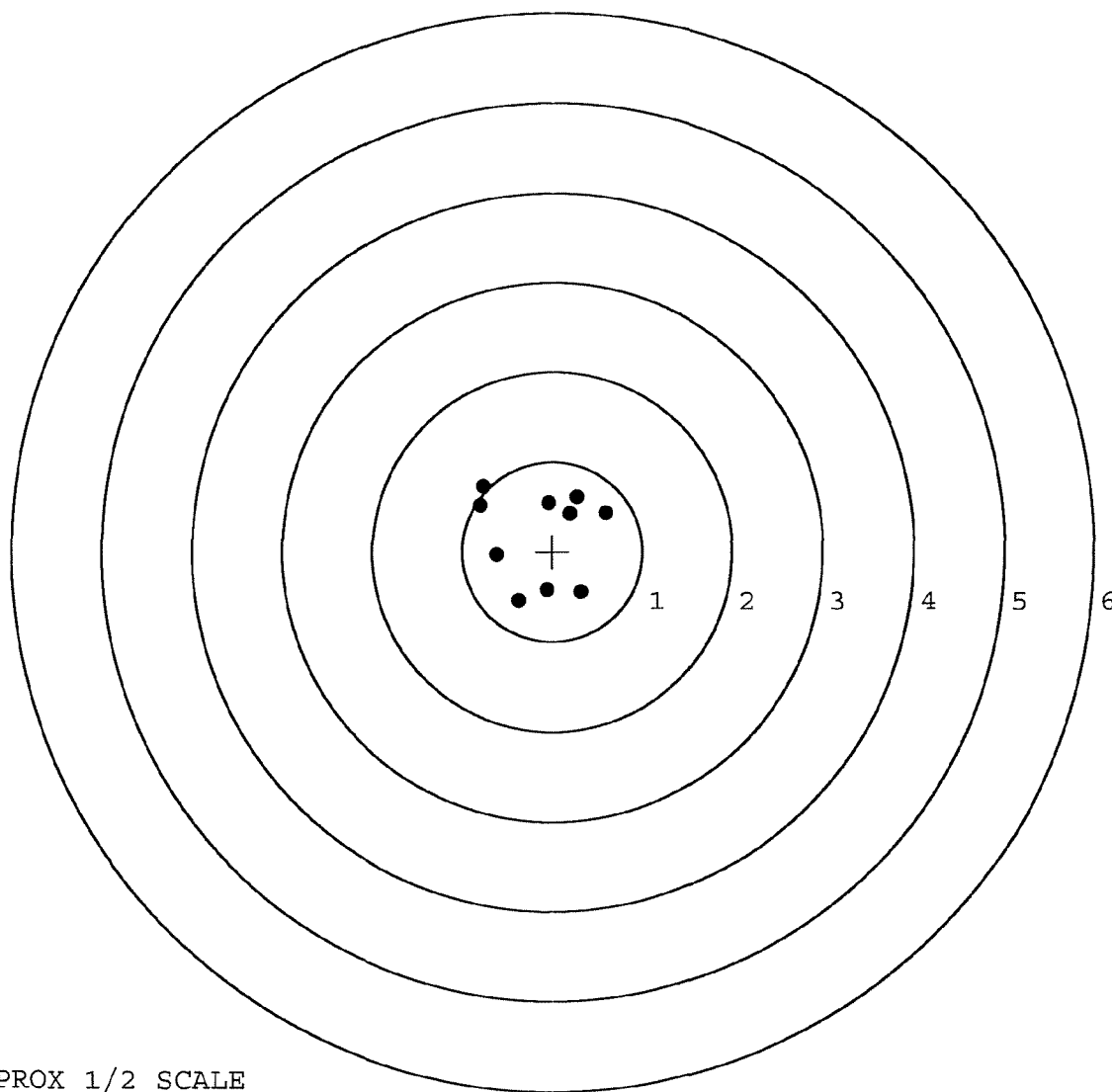
MEAN RADIUS: 0.640

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.591	0.428
2:	0.193	0.425
3:	-0.050	0.546
4:	-0.794	0.515
5:	-0.616	-0.035
6:	-0.377	-0.551
7:	-0.066	-0.431
8:	0.320	-0.454
9:	0.269	0.611
10:	-0.761	0.728



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6594647. 0

TARGET NUMBER: 5

FILE DATE: 08/18/2004

FILE TIME: 06:30

X CENTROID: 0.030

Y CENTROID: 0.045

POA TO CENTROID: 0.054

HORZ SPREAD: 1.938

VERT SPREAD: 2.068

GROUP SPREAD: 2.307

MIN RADIUS: 0.192

MAX RADIUS: 1.295

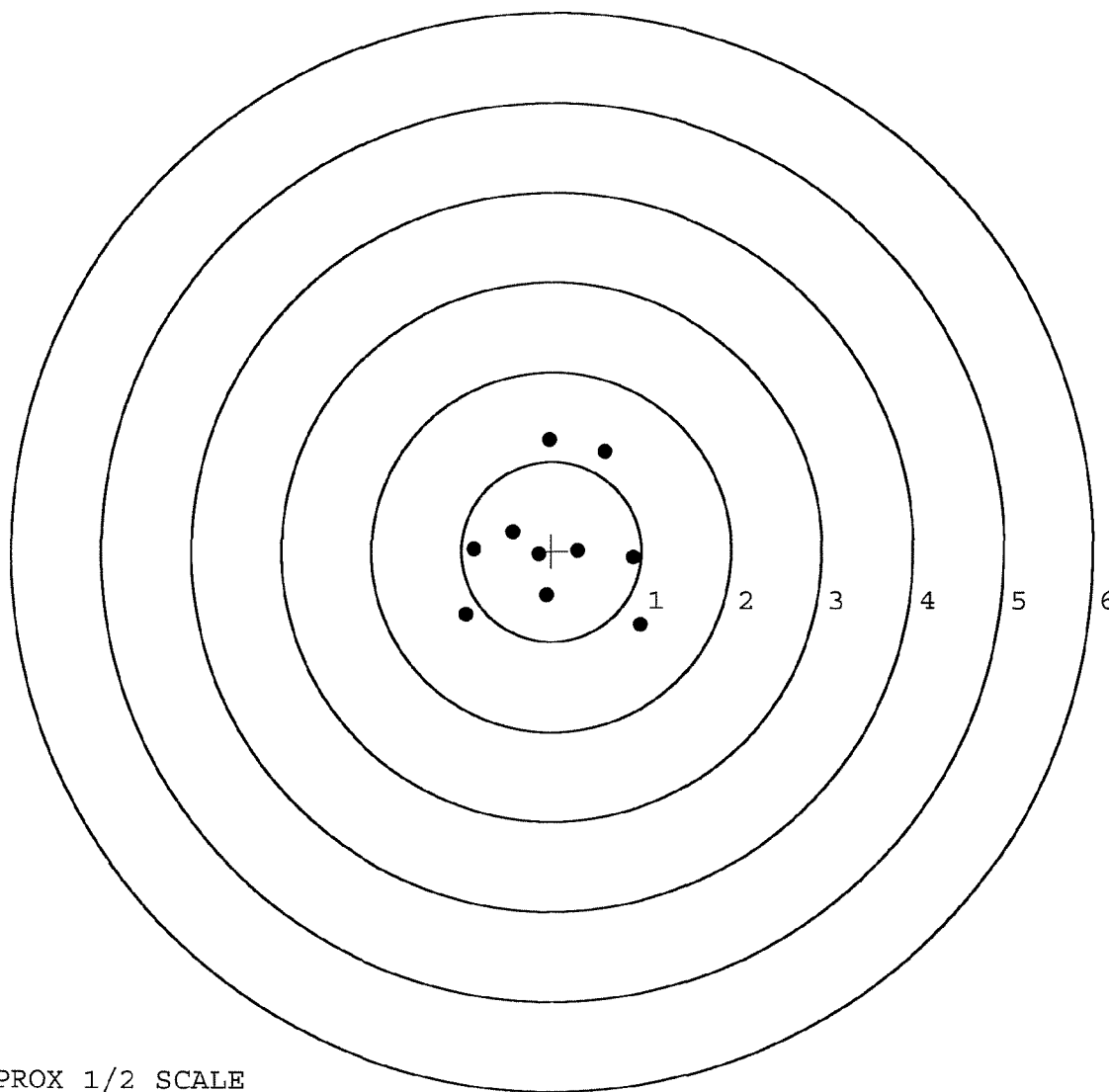
MEAN RADIUS: 0.822

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.593	1.107
2:	-0.033	1.244
3:	0.907	-0.079
4:	0.990	-0.824
5:	-0.055	-0.500
6:	0.290	0.004
7:	-0.948	-0.710
8:	-0.864	0.026
9:	-0.436	0.218
10:	-0.144	-0.036



TARGET APPROX 1/2 SCALE

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

R & E NUMBER	83173		
SERIAL NUMBER	C6594647		
LOG-IN DATE	7-28-04		
INSPECT AND VERIFY:			
OPERATION #	OPERATION NAME	DATE	INITIAL
550	DIS-ASSEMBLE GUN	8-9-04	RTL
560 A	RE-BARREL	8-9-04	RTL
B	DRILL AND TAP		
575	ASSEMBLE	8-10-04	RTL
600	PROOF	8-10-04	RTL
605	CHECK HEADSPACE	8-10-04	RTL
610	DIS-ASSEMBLE GUN	8-10-04	RTL
612	MAGNAFLUX		
615	ROLLMARK CALIBER	8/11/04	ls
618	ROTO-BLAST	8/12/04	DG
620	APPLY COATINGS	8/12	HP
625 A	FINAL ASSEMBLY	8-16-04	RW
B	TRIGGER PULL TEST	8-23-04	RTL
C	SAFETY "ON" FORCE	8-23-04	RTL
D	SAFETY "OFF" FORCE	8-23-04	RTL
E	FIRING PIN INDENT		
640	TARGET	8-18-04	AC
655	FINAL INSPECT	8-23-04	
660	PACK	8-30-04	DA
		SHIP DATE	
	QAR INSPECTION DATE		

RECEIVING AND ESTIMATING REPORT

COMMENTS

ORDER
R 97-00570

INITIAL CUSTOMER ORDER NO.

JJM

DATE RECEIVED

DATE OPENED

DATE CODE

SERIAL NUMBER

NEW SERIAL NUMBER

MODEL AND GRADE

01/09/97

01/09/97

AL 3-91

C6594647

700 7.62

NATO

ACCESSORIES

SCOPE BASE

HARD CASE

W/STUDS

FROM:

SHIP TO:

USPFO VT
BLDG 3 CP JOHNSON
DODAAC-W81KBL
COLCHESTER

VT 05446

USPFO VT
BLDG 3 CP JOHNSON
DODAAC-W81KBL
COLCHESTERVT
05446

CUST NO: 159136 C.D.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

BOLT ASSY.

B3

BARREL ASSY.

B4

REC. ASSY.

B5

WOOD

C1

D3

METAL

C2

MAIN FAULT

PARTS W52H097009H242

COMMENTS

Rear Guard Screw 96015

Repaired Cracked Stock 96018

Bench Check

REPAIRMAN

PROOF

CLEAN

TEST

TARGET

PATTERN

GALLERY TESTER

DATE

DATE

DATE

DATE

DATE

OFFICE COPY

RD6925 REV. 11/96

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

M2400021069

M2400021070

Return Address

DD Form 1348-1, SEP 87

Jun 86 edition may be used.

FORM APPROVED, OMB NO. 0704-0188

DOD SINGLE LINE ITEM RELEASE/RECEIPT DOCUMENT

1005-01-240-2136																								1EA		W18670 6362-3000																							
USPFO VT Bldg #3, Cp Johnson Colchester, VT 05446																								Remington Arms Co. Inc Attn: Fabricate Product Dept. 14 Hoefler Ave. Ilion, N.Y. 13357-1816																								UNIT PRICE DOLLARS CTS.	
DODAAC - W81KBL																																																	
WAREHOUSE LOCATION												TYPE OF CARGO		UNIT PACK		UNIT WEIGHT		UNIT CUBE		UNIT DATE		UNIT PRICE		UNIT PRICE		UNIT PRICE																							
BOR # DAR09-92-C-0694																																																	
SUBSTITUTE DATA (ITEM ORIGINALLY REQUESTED)												FREIGHT CLASSIFICATION NOMENCLATURE												TOTAL PRICE DOLLARS CTS.																									
T												U																																					
W												X												Y																									
SELECTED BY AND DATE												TYPE OF CONTAINER(S)				TOTAL WEIGHT				RECEIVED BY AND DATE				INSPECTED BY AND DATE																									
1												2				3				7				8																									
PACKED BY AND DATE												NO. OF CONTAINER(S)				TOTAL CUBE				WAREHOUSED BY AND DATE				WAREHOUSE LOCATION																									
4												5				6				9				10																									
REMARKS: RETURN REQUISITION NO.												W18670-6362-3009												2																									
AA												BB												CC				DD																					
FIRST DESTINATION ADDRESS												DATE SHIPPED												EE				FF																					
11												12												13				14																					
TRANSPORTATION CHARGEABLE TO												15												16				17																					

DA FORM 2404
1 APR 79

M2400021072

MAINTENANCE REQUEST										PAGE NO.		NO. OF PAGES		REQUIREMENT CONTROL SYMBOL		CONTROL NUMBER	
For use of this form, see PAM 738-750; the proponent agency is DC/SLOG																	
SECTION I - CUSTOMER DATA										SECTION II - MAINTENANCE ACTIVITY DATA							
1a. CUSTOMER		1b. CUSTOMER UNIT NAME				1c. PHONE NO.				3a. WORK ORDER NUMBER (WON)		3b. SHOT		3c. PHONE NO.			
7 1 W 1 5 1 A 1 A		MWS				899-7253				4 1 5 3 9 7 A		601849		B 238			
INTRANSIT CUSTOMER		2b. SAMS 2 UIC				2c. UTILIZATION CODE				4a. UIC SUPPORT		4b. SUPPORT UNIT NAME					
ENTER DATA IN BLOCKS		W 1 8 1 B 1 F 1 0 1 4				07				W 1 5 3 9 7		CSMS-VT					
2. AND 2c.																	
SECTION III - EQUIPMENT DATA																	
EMNT		6. ID		7. NSN		15. FAILURE DETECTED DURING (Select one - use ☒ or X)											
01 A		11		10 15 10 11 12 14 10 21 13 16 1		15a. Scheduled Maintenance ☐ 15b. Fatigue ☐ 15c. Storage ☐ 15d. Flight ☐ 15e. Calibration ☐											
01 A		11		10 15 10 11 12 14 10 21 13 16 1		15f. Handling ☐ 15g. Normal Use ☐ 15h. Inspection ☐ 15i. Other ☐											
01 A		11		10 15 10 11 12 14 10 21 13 16 1		16a. MILES/KILOMETERS (enter ☒ or X)											
01 A		11		10 15 10 11 12 14 10 21 13 16 1		16b. HOURS											
01 A		11		10 15 10 11 12 14 10 21 13 16 1		16c. ROUNDS											
01 A		11		10 15 10 11 12 14 10 21 13 16 1		16d. LANDINGS											
01 A		11		10 15 10 11 12 14 10 21 13 16 1		16e. AUTO. ROTATIONS											
01 A		11		10 15 10 11 12 14 10 21 13 16 1		17. PROJECT CODE (If assigned)											
01 A		11		10 15 10 11 12 14 10 21 13 16 1		18. ACCOUNT PROCESSING CODE											
01 A		11		10 15 10 11 12 14 10 21 13 16 1		19. IN WARRANTY? (enter Y or N)											
01 A		11		10 15 10 11 12 14 10 21 13 16 1		20. LEVEL OF WORK (Select one - use ☒ or X)											
01 A		11		10 15 10 11 12 14 10 21 13 16 1		20a. Unit Level ☐ 20b. Intermediate ☐ 20c. General Spt ☐ 20d. Special Repair ☐ 20e. Direct Spt ☐ 20f. Depot ☐											
01 A		11		10 15 10 11 12 14 10 21 13 16 1		21. BUMPER NO./TAIL NO.											
01 A		11		10 15 10 11 12 14 10 21 13 16 1		22. REIMBURSABLE CUSTOMER? (If Intransit Customer, enter Y or N)											
01 A		11		10 15 10 11 12 14 10 21 13 16 1		23. AUTHENTICATING SIGNATURE (Payroll Signature)											
01 A		11		10 15 10 11 12 14 10 21 13 16 1		23a. SIGNATURE											
01 A		11		10 15 10 11 12 14 10 21 13 16 1		23b. GRADE											
01 A		11		10 15 10 11 12 14 10 21 13 16 1		23c. NAME											
01 A		11		10 15 10 11 12 14 10 21 13 16 1		23d. ADDRESS											
01 A		11		10 15 10 11 12 14 10 21 13 16 1		23e. PHONE NO.											
01 A		11		10 15 10 11 12 14 10 21 13 16 1		23f. FAX NO.											
01 A		11		10 15 10 11 12 14 10 21 13 16 1		23g. E-MAIL ADDRESS											
01 A		11		10 15 10 11 12 14 10 21 13 16 1		23h. OTHER CONTACT INFORMATION											
01 A		11		10 15 10 11 12 14 10 21 13 16 1		23i. COMMENTS											
01 A		11		10 15 10 11 12 14 10 21 13 16 1		23j. SIGNATURE											
01 A		11		10 15 10 11 12 14 10 21 13 16 1		23k. GRADE											
01 A		11		10 15 10 11 12 14 10 21 13 16 1		23l. NAME											
01 A		11		10 15 10 11 12 14 10 21 13 16 1		23m. ADDRESS											
01 A		11		10 15 10 11 12 14 10 21 13 16 1		23n. PHONE NO.											
01 A		11		10 15 10 11 12 14 10 21 13 16 1		23o. FAX NO.											
01 A		11		10 15 10 11 12 14 10 21 13 16 1		23p. E-MAIL ADDRESS											
01 A		11		10 15 10 11 12 14 10 21 13 16 1		23q. OTHER CONTACT INFORMATION											
01 A		11		10 15 10 11 12 14 10 21 13 16 1		23r. COMMENTS											
01 A		11		10 15 10 11 12 14 10 21 13 16 1		23s. SIGNATURE											
01 A		11		10 15 10 11 12 14 10 21 13 16 1		23t. GRADE											
01 A		11		10 15 10 11 12 14 10 21 13 16 1		23u. NAME											
01 A		11		10 15 10 11 12 14 10 21 13 16 1		23v. ADDRESS											
01 A		11		10 15 10 11 12 14 10 21 13 16 1		23w. PHONE NO.											
01 A		11		10 15 10 11 12 14 10 21 13 16 1		23x. FAX NO.											
01 A		11		10 15 10 11 12 14 10 21 13 16 1		23y. E-MAIL ADDRESS											
01 A		11		10 15 10 11 12 14 10 21 13 1													

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C-6594647

DATE 5-13-91

TESTER JU

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.44	2.52	2.50	2.40	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.58	2.38	2.54	2.60	
PULL #3	2.42	2.54	2.53	2.57	
PULL #4	2.43	2.54	2.51	2.69	
PULL #5	2.45	2.59	2.58	2.65	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.42	3.37		
PULL #2	3.37	3.36		
PULL #3	3.35	3.43		
PULL #4	3.43	3.42		
PULL #5	3.34	3.35		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.54	4.59		4.55
PULL #2	4.50	4.47		4.53
PULL #3	4.57	4.37		4.52
PULL #4	4.60	4.37		4.50
PULL #5	4.49	4.49		4.56
TOTAL				
AVG.				

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

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

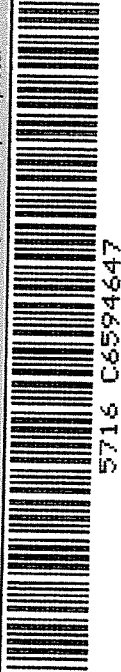
MODEL 700™ M24

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

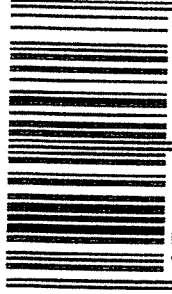
SERIAL NO.
C6594647

ORDER NO.
5716

20



UPC



0 47700 25716 7

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6594647
15 May 1991

CENTROIDAL DISTANCES

0 TO	1	.273383
1 TO	2	.275572
1 TO	3	.458495
1 TO	4	.098732
1 TO	5	.264322

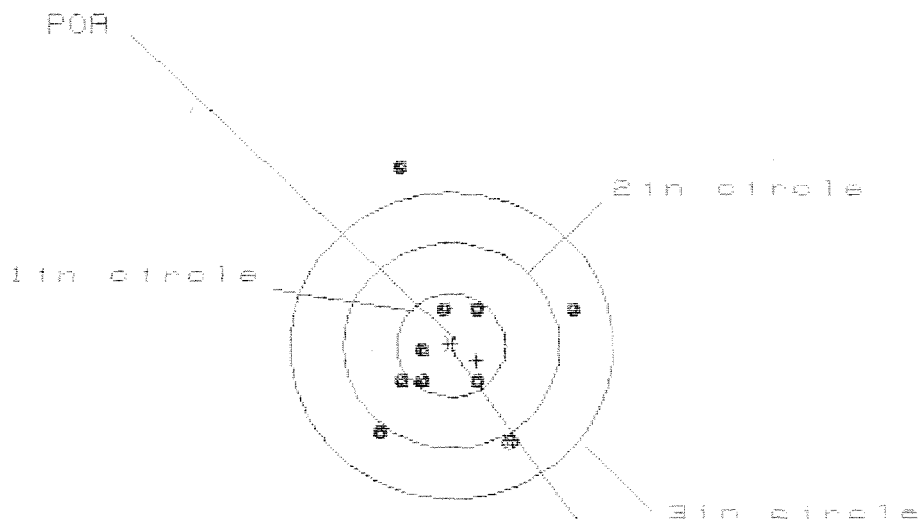
123 <----FOR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0466
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1488
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .148121
THE AMR FOR THIS RIFLE IS: .7788

15 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08594647

CENTERFIRE PATTERNS # 1



OF SHOTS - 10

IN CIR

1in = 5

2in = 6

3in = 9

HS = 1.752

VS = 2.661

GS = 2.854

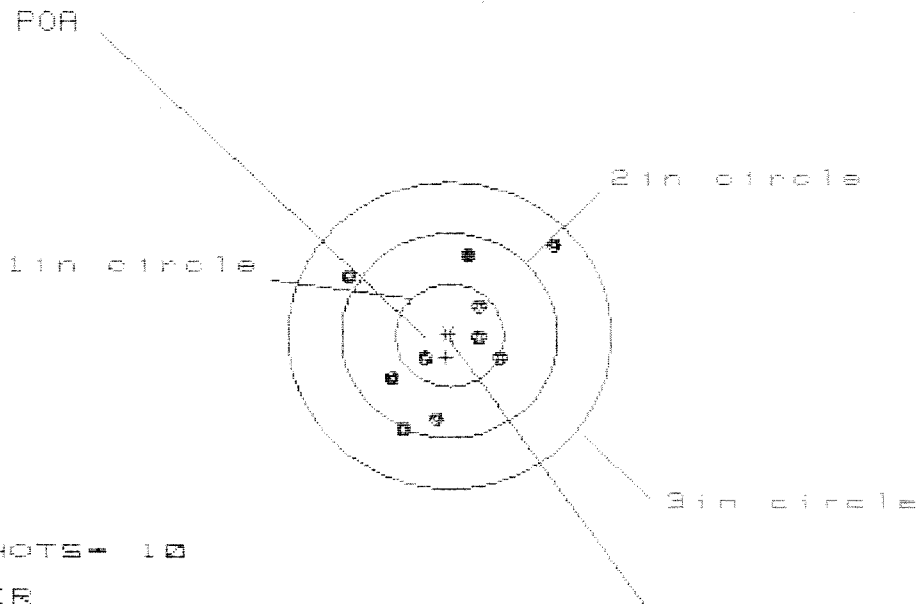
CENTROID +

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.101	1.049	.635
MINIMUM X	-.651	-.703	-.572
MAXIMUM Y	1.752	.598	.663
MINIMUM Y	-.909	-.714	-.639
CENTROID X	-.233	-.181	-.312
CENTROID Y	.143	-.052	-.127
POA TO CENTROID in.	.273	.188	.336
MIN RADIUS	.268	.253	.188
MEAN RADIUS	.762	.625	.525
MAX RADIUS	1.815	1.207	.901
HORIZONTAL SPREAD	1.752	1.752	1.207
VERTICAL SPREAD	2.661	1.312	1.302
EXTREME SPREAD	2.854	2.121	1.426
NUMBER IN ONE INCH CIRCLE =	5		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	9		

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CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1in = 4

2in = 7

3in = 10

HS = 1.948

VS = 1.777

GS = 2.273

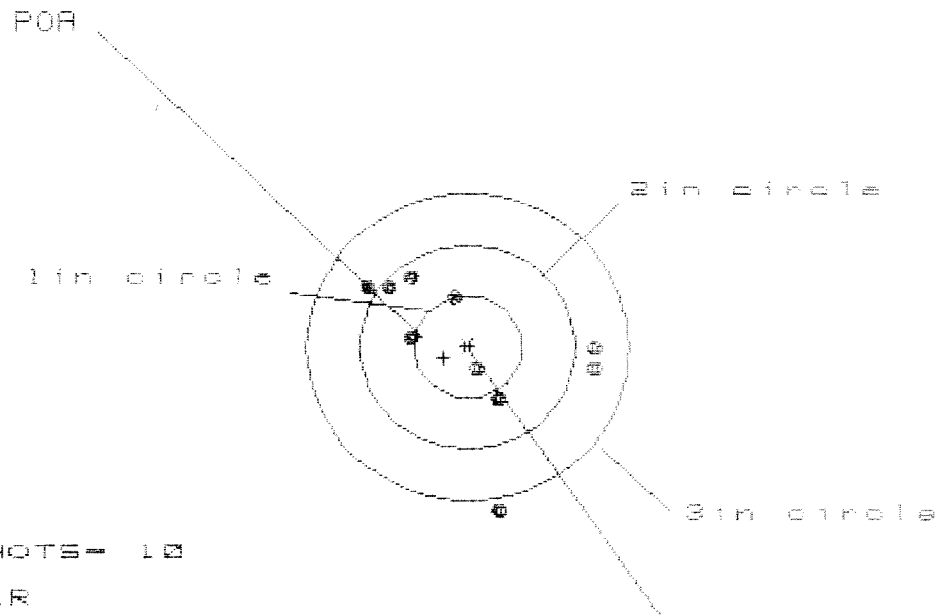
CENTROID #

PATTERN #	2	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.995	.554	.449
MINIMUM X	-.953	-.842	-.528
MAXIMUM Y	.842	.965	.986
MINIMUM Y	-.935	-.841	-.760
CENTROID X	.033	-.077	.028
CENTROID Y	.215	.121	.040
POA TO CENTROID in.	.217	.144	.049
MIN RADIUS	.314	.189	.272
MEAN RADIUS	.728	.655	.590
MAX RADIUS	1.304	1.063	1.010
HORIZONTAL SPREAD	1.948	1.396	.977
VERTICAL SPREAD	1.777	1.746	1.746
EXTREME SPREAD	2.273	1.859	1.859
NUMBER IN ONE INCH CIRCLE =		4	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		10	

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 1

2in = 6

3in = 9

HS= 2.161

VS= 2.364

GS= 2.492

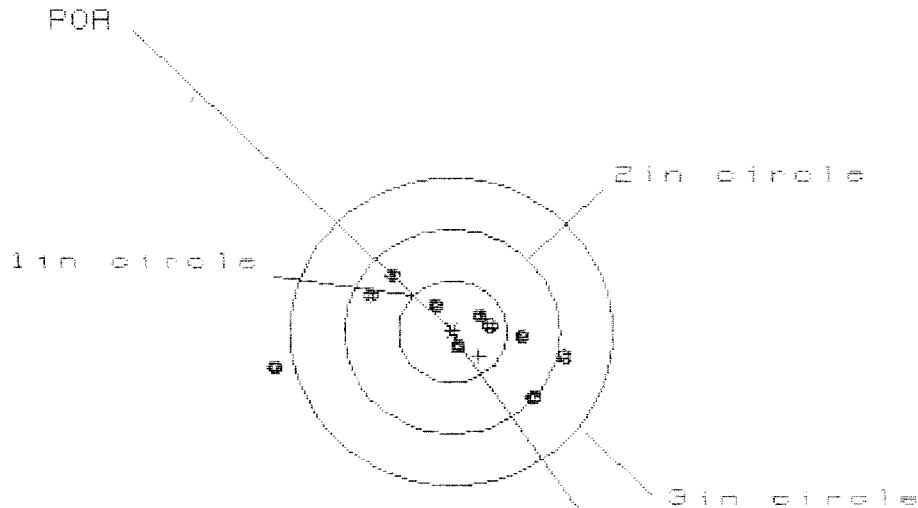
CENTROID #

PATTERN #	3	3	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.195	1.221	1.374
MINIMUM X	-.966	-.940	-.787
MAXIMUM Y	.730	.549	.504
MINIMUM Y	-1.634	-.642	-.687
CENTROID X	.224	.198	.045
CENTROID Y	.106	.287	.332
POA TO CENTROID in.	.248	.349	.335
MIN RADIUS	.264	.364	.292
MEAN RADIUS	.892	.793	.698
MAX RADIUS	1.651	1.269	1.388
HORIZONTAL SPREAD	2.161	2.161	2.161
VERTICAL SPREAD	2.364	1.191	1.191
EXTREME SPREAD	2.492	2.276	2.223
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	9		

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 4

2in = 8

3in = 9

HS= 2.679

VS= 1.286

GS= 2.681

CENTROID #

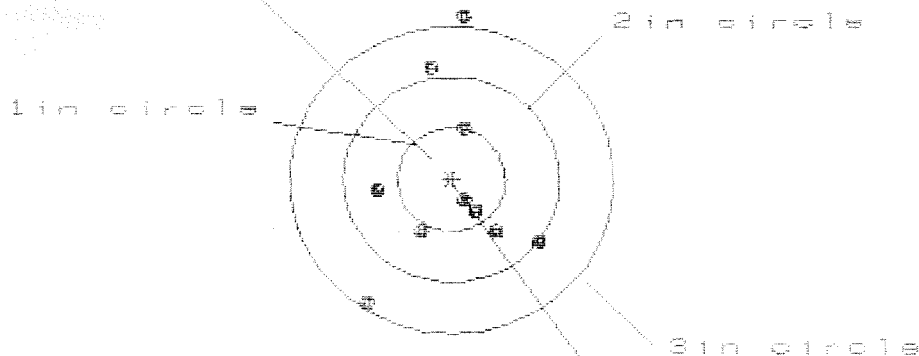
PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.058	.877	.631
MINIMUM X	-1.621	-.933	-.823
MAXIMUM Y	.607	.571	.540
MINIMUM Y	-.679	-.715	-.746
CENTROID X	-.245	-.065	-.175
CENTROID Y	.241	.277	.308
POA TO CENTROID in.	.344	.285	.354
MIN RADIUS	.148	.103	.151
MEAN RADIUS	.703	.556	.518
MAX RADIUS	1.654	.983	.977
HORIZONTAL SPREAD	2.679	1.810	1.454
VERTICAL SPREAD	1.286	1.286	1.286
EXTREME SPREAD	2.681	1.894	1.796
NUMBER IN ONE INCH CIRCLE =	4		
NUMBER IN TWO INCH CIRCLE =	8		
NUMBER IN THREE INCH CIRCLE =	9		

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CENTERFIRE PATTERNS # 5

POA



OF SHOTS- 10

IN CIR

1in = 2

2in = 7

3in = 9

HS= 1.557

VS= 2.784

GS= 2.920

CENTROID #

PATTERN #	:	5	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.782	.793	.698
MINIMUM X	:	-.775	-.764	-.724
MAXIMUM Y	:	1.622	1.303	1.186
MINIMUM Y	:	-1.162	-.981	-.510
CENTROID X	:	-.012	-.023	.072
CENTROID Y	:	-.002	-.183	-.060
POA TO CENTROID in.	:	.012	.184	.094
MIN RADIUS	:	.212	.134	.121
MEAN RADIUS	:	.809	.680	.609
MAX RADIUS	:	1.626	1.313	1.208
HORIZONTAL SPREAD	:	1.557	1.557	1.422
VERTICAL SPREAD	:	2.784	2.284	1.690
EXTREME SPREAD	:	2.920	2.362	1.941
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6594647

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	3 25	91	RW
600	Proof	3 25	91	RW
607	Check Headspace	3 25	91	RW
610	Dis-assemble Gun	3 25	91	RW
612	Magnaflux Barrel Action	3 28	91	KR
	Magnaflux Bolt	3 28	91	U
615	Rollmark Caliber	3 28	91	LS
617	Drill and Tap Sight Holes		APR 3 1991	LB
618	Polish Barrel		APR 3 1991	WB
620	Apply Coatings (Barrel Action)		4-11-91	TS
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		4/16/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		4/16/91	RW
	C) Inspect Ejector Hole for Chamfer		4/16/91	RW
	D) Oil Firing Pin Ass'y		4/16/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		5-13-91	RU

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			5/12/91	WB
	G) Safety Off Force	2 1/2	2 1/2	2 1/2			5/13/91	WB
	H) Trigger Pull Test & Retainability						5-13-91	JF
	I) Firing Pin Indent	.021	.021	.021			5/13/91	WB
	J) Assemble Stock						5/14/91	RW
	K) Assemble Swivel Studs						5-20-91	L
	L) Attach Front and Rear Sight Assemblies						5/14/91	RW
	M) Iron Sight Alignment						5/14/91	RW
	N) Detach Front & Rear Sights & place in numbered container						5/14/91	RW
	O) Attach Scope to Rifle						5/14/91	RW
	P) Detach & Attach Scope 20 Times						5/14/91	RW
640	Gallery Target & Test						5-15-91	DH
	A) Time						5-15-91	DH
	B) Malfunctions						5-15-91	DH
	C) Pierced Primers						5-15-91	DH
	D) Optical Clarity of Scope						5-15-91	DH
645	Inspect for Live Ammo						5-15-91	DH
655	Final Inspection							
	A) Headspace						5-20-91	K
	B) Trigger Pull	2.40	2.60	2.51	2.69	2.65	5-20-91	JF
	C) Function						5-20-91	L
660	Pack						6-17-91	RF