

C6587532

MODEL 700TM M24

Model **SWS** TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER

M2400022193

Repair Inquiry

Repair Number: RE00136591

Serial: C6587532 Model M24 SWS Center Fire
Caliber: 7.62 NATO

Repairman:

Verify Repair

Status:

Closed 11/9/2007 8:17:13 AM

Address Information

Customer:

☒ Received From

Return To:

☐ Received From

Name: 1/1 ADA

1/1 ADA

Address 1: LONGKNIFE

LONGKNIFE

Address 2: PO Box:

PO Box:

City: FORT BLISS

FORT BLISS

State: TX Zip Code: 79916

Country: US

State: TX Zip Code: 79916

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
A026	Scope	1
A045	Bi Pod	1
A057	Fit and Rear Sgt Base	1
D000	SCOPE CASE	1

Repair Search

Refresh

Close

nagletj

11/9/2007

9:14 AM

CAPS

NUM

INS

SCRL

start

6M

7I

A...

3M

P...

M...

2E

M...

9:14 AM

Serial
Number:

C6587532

Model: M24 SWS



RE00136591

Reset

R & E NUMBER	00136591		
SERIAL NUMBER	C6587532		
LOG-IN DATE	11-9-07		
OPERATION #	OPERATION NAME	DATE	INITIAL
500	DIS-ASSEMBLE GUN	2-4-08	S.P.D.
505	RE-BARREL	2-5-08	S.P.D.
560	ASSEMBLE	2-5-08	S.P.D.
600	PROOF	2-6-08	TRW
605	CHECK HEADSPACE	2-6-08	TRW
610	DIS-ASSEMBLE GUN	2-6-08	S.P.D.
612	MAGNAFLUX	2/7/08	umg
510	DRILL AND TAP	2-6-08	TRW
615	ROLLMARK CALIBER	2-6-08	CW
618	ROTO-BLAST	2-7-08	Ob
620	APPLY COATINGS	2-11-08	CM
625	FINAL ASSEMBLY	2-13-08	S.P.D.
640	FUNCTION TEST AND	2-14-08	TRW
650	TARGET	2-14-08	TRW
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
670	FINAL INSPECTION	2-14-08	RP
	A) HEADSPACE	2-19-08	TRW
	B) TRIGGER PULL	2.52 2.51 2.57 2.48 2.55 2-19-08	TRW
680	F) SAFETY ON FORCE	4.75 4.75 4.5 2-19-08	TRW
	G) SAFETY OFF FORCE	2.5 2.5 2.0 2-19-08	TRW
	I) FIRING PIN INDENT	.021 ^s .021 ^s .021 2-19-08	TRW
690	PACK	10/17/08	FM

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6587532.0

FILE DATE AND TIME: 02/15/2008 10:55

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.022
The Average Y Centroid of the Five Target Set:	-0.066
The Average Point of Impact of the Five Target Set:	0.069
The Average Mean Radius of the Five Target Set:	0.717
The Distance from POA to Centroid Target #1:	0.232
The Distance from Centroid Target #2 to Centroid Target #1:	0.277
The Distance from Centroid Target #3 to Centroid Target #1:	0.133
The Distance from Centroid Target #4 to Centroid Target #1:	0.121
The Distance from Centroid Target #5 to Centroid Target #1:	0.302

SERIAL NUMBER: C6587532. __0

TARGET NUMBER: 1

FILE DATE: 02/15/2008

FILE TIME: 10:55

X CENTROID: 0.066

Y CENTROID: -0.223

POA TO CENTROID: 0.232

HORZ SPREAD: 2.077

VERT SPREAD: 2.158

GROUP SPREAD: 2.267

MIN RADIUS: 0.201

MAX RADIUS: 1.416

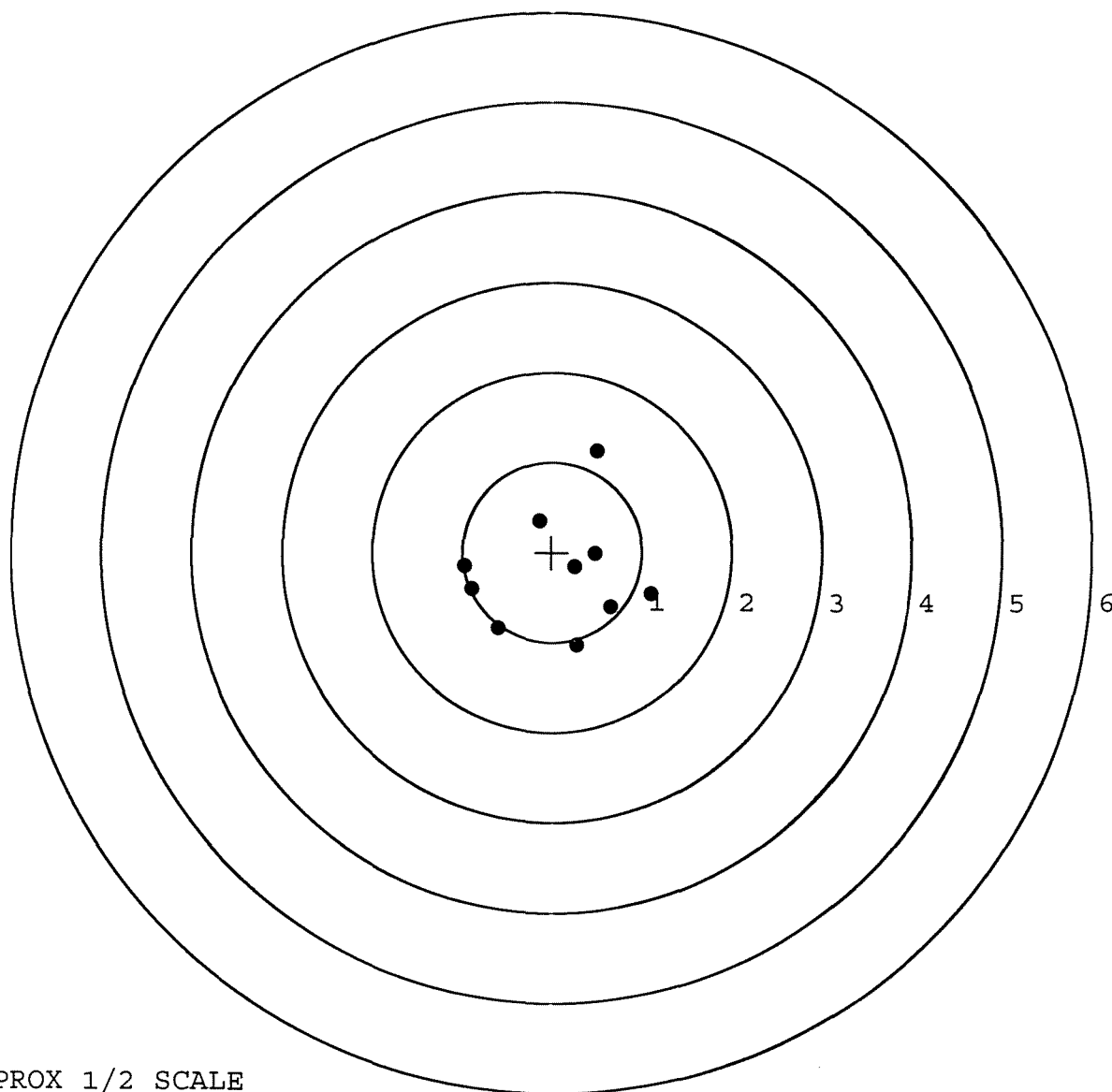
MEAN RADIUS: 0.825

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	1.103	-0.460
2:	0.660	-0.612
3:	0.276	-1.034
4:	0.481	-0.016
5:	0.258	-0.165
6:	-0.144	0.351
7:	0.503	1.124
8:	-0.974	-0.157
9:	-0.898	-0.407
10:	-0.606	-0.853



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6587532. __0

TARGET NUMBER: 2

FILE DATE: 02/15/2008

FILE TIME: 10:55

POINT#	X	Y
1:	0.284	-0.760
2:	0.621	-0.639
3:	0.398	-0.271
4:	0.652	-0.110
5:	0.489	0.209
6:	-0.376	0.866
7:	-0.901	0.527
8:	-0.443	0.150
9:	-0.590	0.155
10:	-0.845	0.054

X CENTROID: -0.071

Y CENTROID: 0.018

POA TO CENTROID: 0.073

HORZ SPREAD: 1.553

VERT SPREAD: 1.626

GROUP SPREAD: 1.917

MIN RADIUS: 0.395

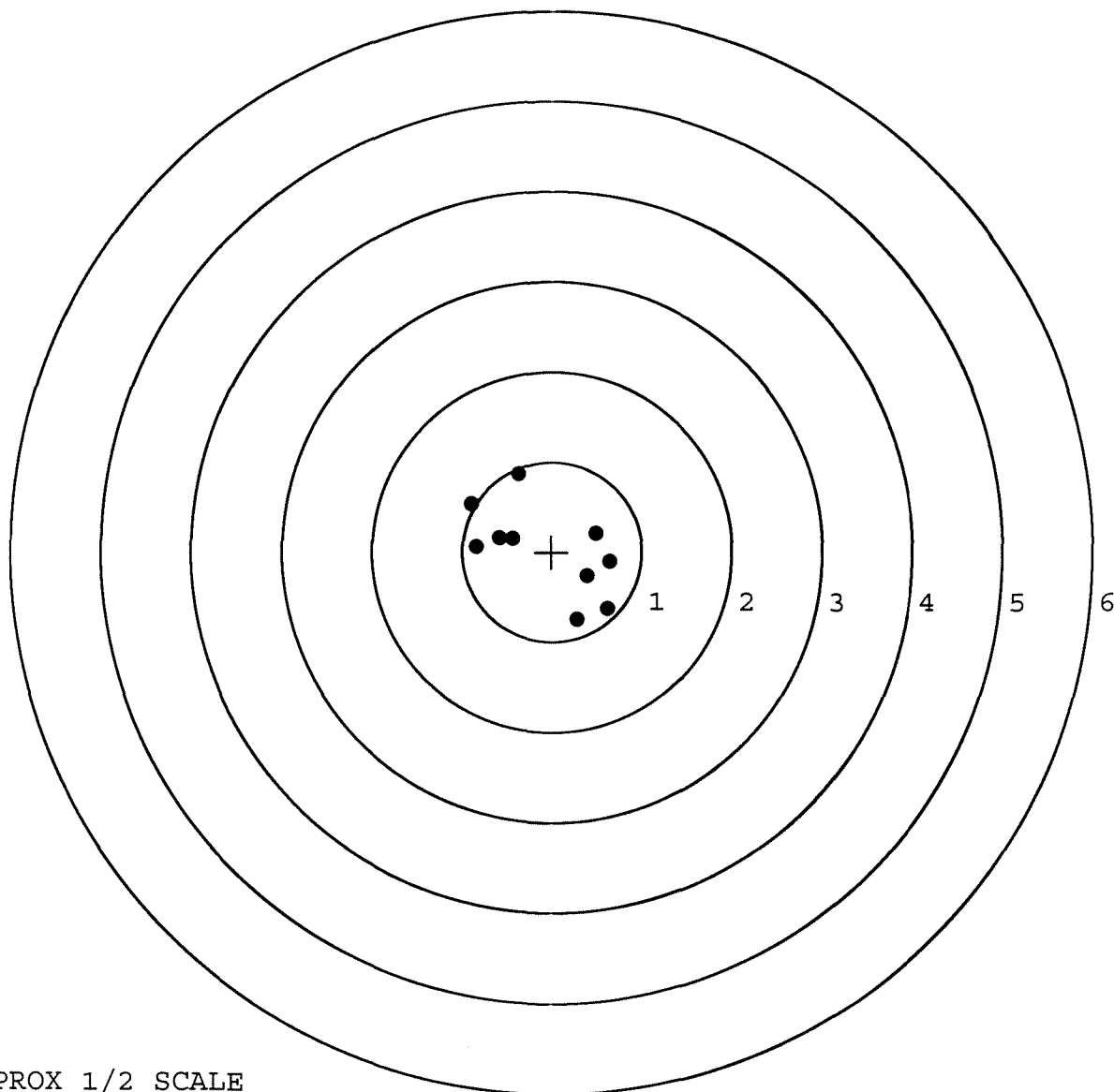
MAX RADIUS: 0.974

MEAN RADIUS: 0.727

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6587532. 0

TARGET NUMBER: 3

FILE DATE: 02/15/2008

FILE TIME: 10:55

X CENTROID: 0.040

Y CENTROID: -0.093

POA TO CENTROID: 0.101

HORZ SPREAD: 1.595

VERT SPREAD: 1.716

GROUP SPREAD: 1.884

MIN RADIUS: 0.435

MAX RADIUS: 1.087

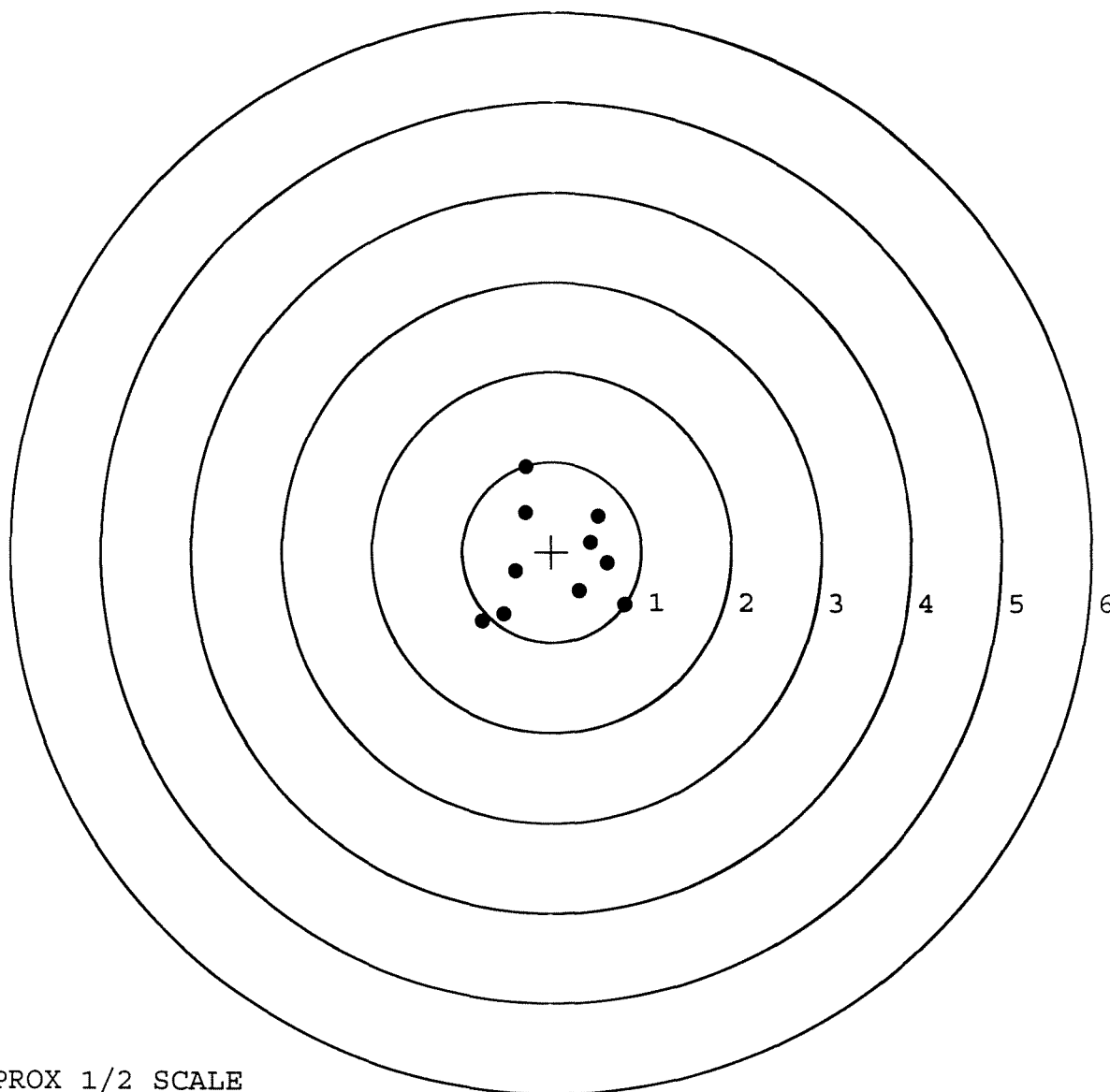
MEAN RADIUS: 0.714

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.815	-0.584
2:	0.311	-0.433
3:	0.620	-0.123
4:	0.439	0.112
5:	0.517	0.402
6:	-0.294	0.435
7:	-0.289	0.943
8:	-0.406	-0.217
9:	-0.537	-0.691
10:	-0.780	-0.773



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6587532. __0

TARGET NUMBER: 4

FILE DATE: 02/15/2008

FILE TIME: 10:55

POINT#	X	Y
1:	1.329	-0.542
2:	0.737	-0.406
3:	0.193	-0.605
4:	-0.241	1.021
5:	0.076	-0.080
6:	-0.095	0.118
7:	-0.273	-0.158
8:	-0.708	-0.386
9:	-0.658	-0.051
10:	-0.139	-0.017

X CENTROID: 0.022

Y CENTROID: -0.111

POA TO CENTROID: 0.113

HORZ SPREAD: 2.037

VERT SPREAD: 1.626

GROUP SPREAD: 2.215

MIN RADIUS: 0.062

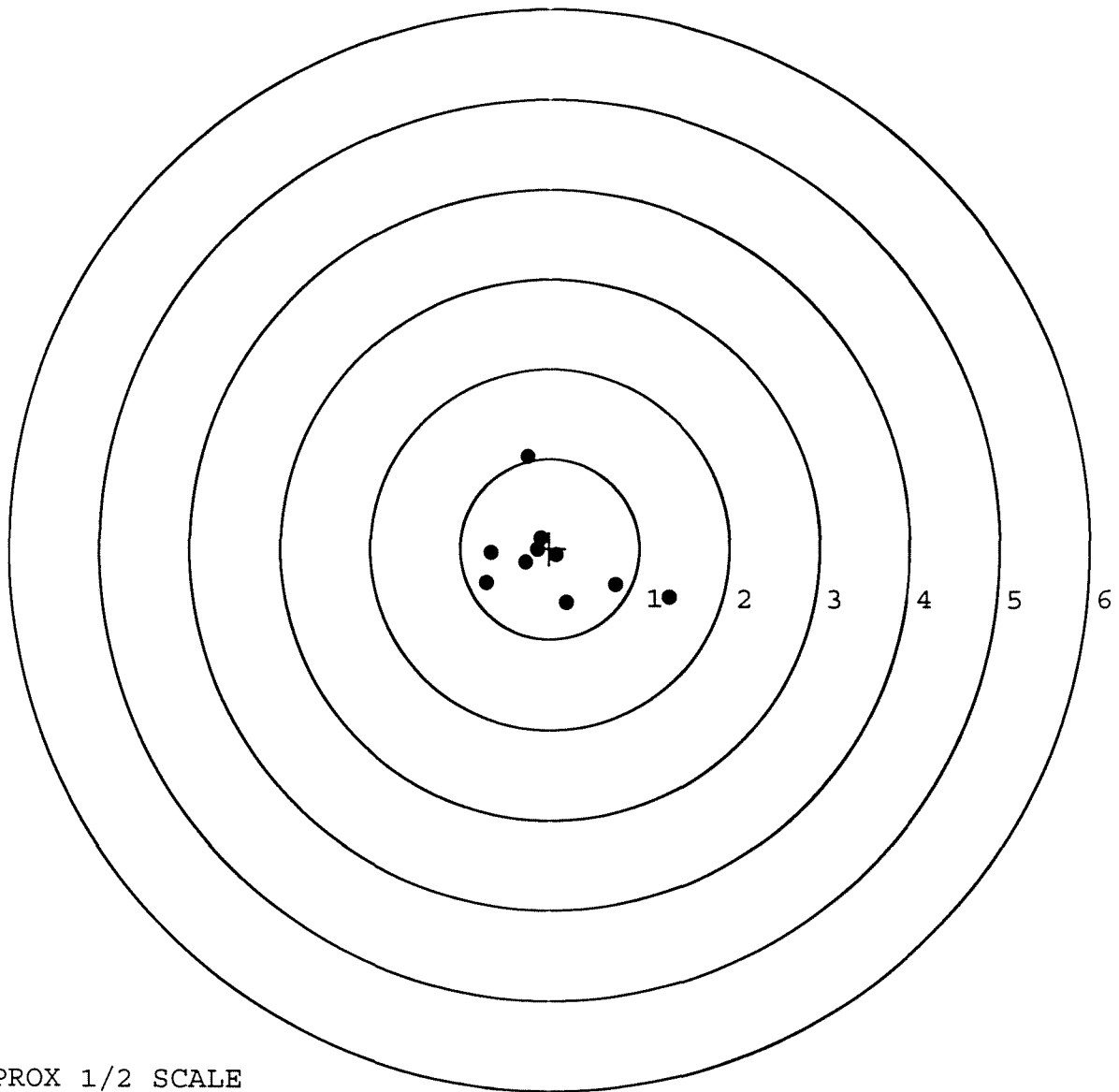
MAX RADIUS: 1.376

MEAN RADIUS: 0.610

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6587532. __0

TARGET NUMBER: 5

FILE DATE: 02/15/2008

FILE TIME: 10:55

POINT#	X	Y
1:	0.449	-0.966
2:	-0.159	-1.187
3:	0.617	-0.160
4:	0.491	0.529
5:	0.117	0.771
6:	-0.213	1.264
7:	0.068	0.385
8:	-0.160	0.352
9:	-0.196	0.002
10:	-0.481	-0.203

X CENTROID: 0.053

Y CENTROID: 0.079

POA TO CENTROID: 0.095

HORZ SPREAD: 1.098

VERT SPREAD: 2.451

GROUP SPREAD: 2.452

MIN RADIUS: 0.261

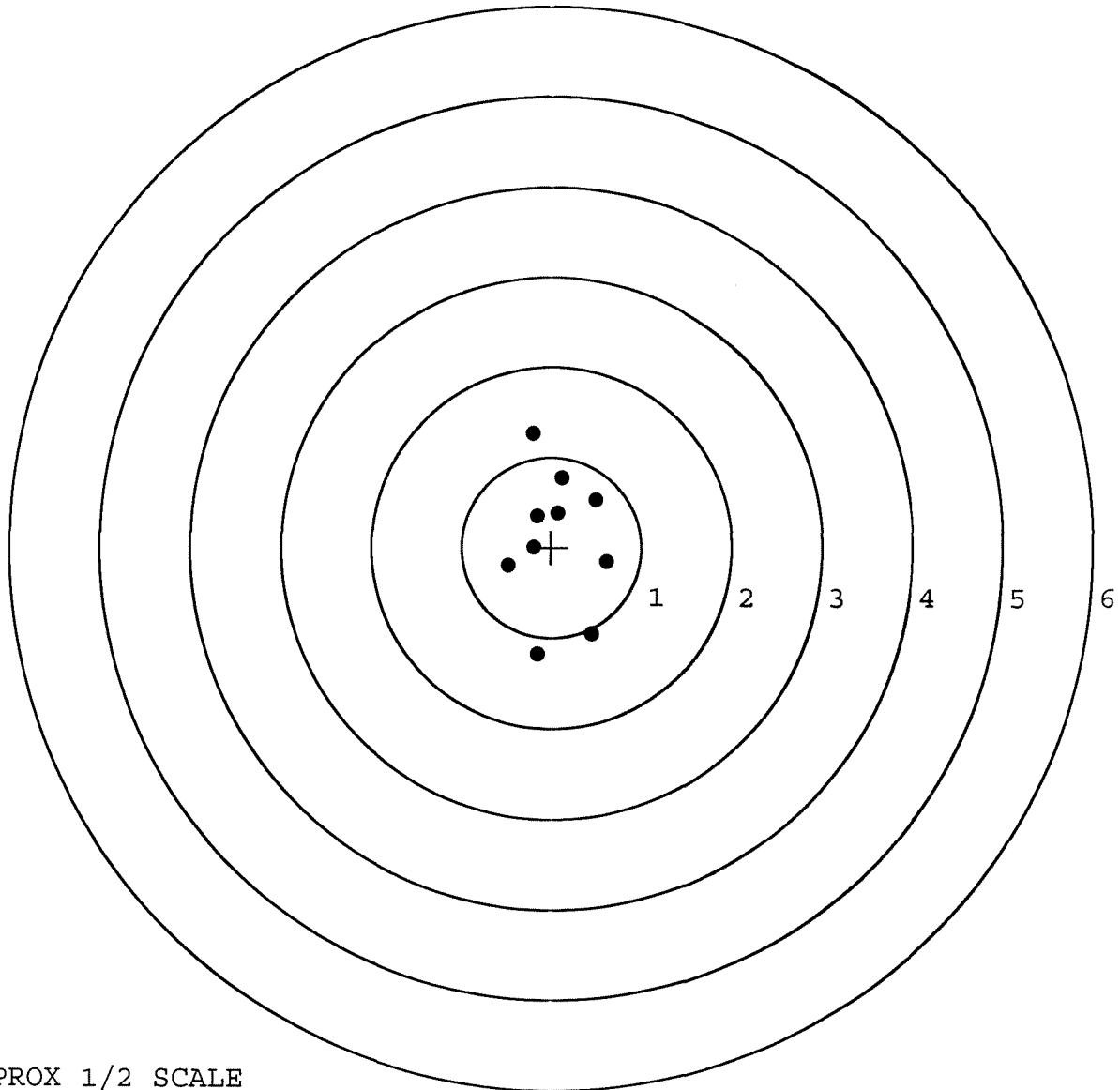
MAX RADIUS: 1.283

MEAN RADIUS: 0.707

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

Repair Inquiry

Repair Number **RE00092951**

Serial: C6587532 Model: M24 SWS Center Fire
Caliber: 7.62 NATO Produced: 12/10/1990

Repairman

Status

Closed: 2/10/2005 1:14:46 PM

Address Information

Customer

☒ Received From

Return To

☐ Received From

Name: DEF DIST DEPOT ANNISTON

DEF DIST DEPOT ANNISTON

Address 1

Address 2

PO Box

PO Box

City: ANNISTON

ANNISTON

State: AL

Zip Code: 362014199

Country: US

State: AL

Zip Code: 362014199

Country: US

FFL

Contact / Condition

Problems

Estimate

History / Status

Shipping / Billing

Contact Information

Phone

Fax

Email

Comments

Received Condition

Good

Condition

Notes

CSR

Notes

Accessories Received

Code	Desc	Qty
A007	With Stud	3
A010	Hard Case	1
A017	Scope Base	1
A026	Scope	1
A057	Fit and Rear Sgt Base	1

Repair Search

Refresh

Close

raglerj

2/14/2005

9:18 AM

CAPS

NUM

INS

SCPL

start

5

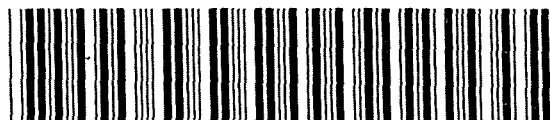
2

4

Arms Service

Serial Number: **C6587532**

Model: **M24 SWS**



RE00092951

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6587532.___0
FILE DATE AND TIME: 06/17/2005 09:14

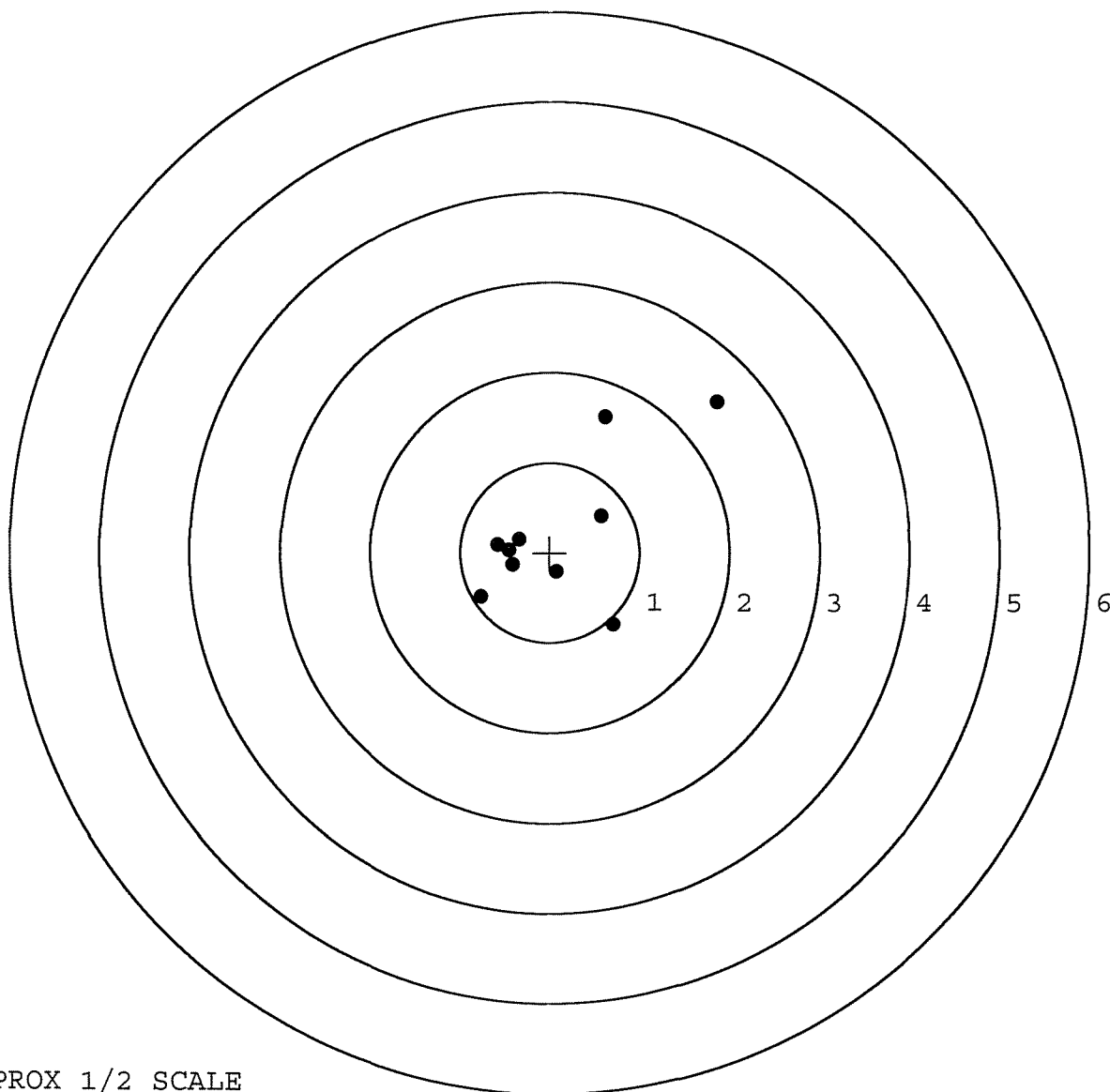
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.007
The Average Y Centroid of the Five Target Set:	0.228
The Average Point of Impact of the Five Target Set:	0.228
The Average Mean Radius of the Five Target Set:	0.813
The Distance from POA to Centroid Target #1:	0.254
The Distance from Centroid Target #2 to Centroid Target #1:	0.081
The Distance from Centroid Target #3 to Centroid Target #1:	0.411
The Distance from Centroid Target #4 to Centroid Target #1:	0.219
The Distance from Centroid Target #5 to Centroid Target #1:	0.508

SERIAL NUMBER: C6587532. 0
TARGET NUMBER: 1
FILE DATE: 06/17/2005
FILE TIME: 09:14

X CENTROID: 0.126
Y CENTROID: 0.221
POA TO CENTROID: 0.254
HORZ SPREAD: 2.621
VERT SPREAD: 2.476
GROUP SPREAD: 3.403
MIN RADIUS: 0.438
MAX RADIUS: 2.258
MEAN RADIUS: 0.933
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 6
in 3 IN DIAMETER: 9

POINT#	X	Y
1:	0.571	0.407
2:	0.075	-0.214
3:	0.710	-0.802
4:	-0.343	0.153
5:	-0.586	0.091
6:	-0.419	-0.138
7:	-0.767	-0.496
8:	1.854	1.674
9:	0.616	1.502
10:	-0.454	0.030

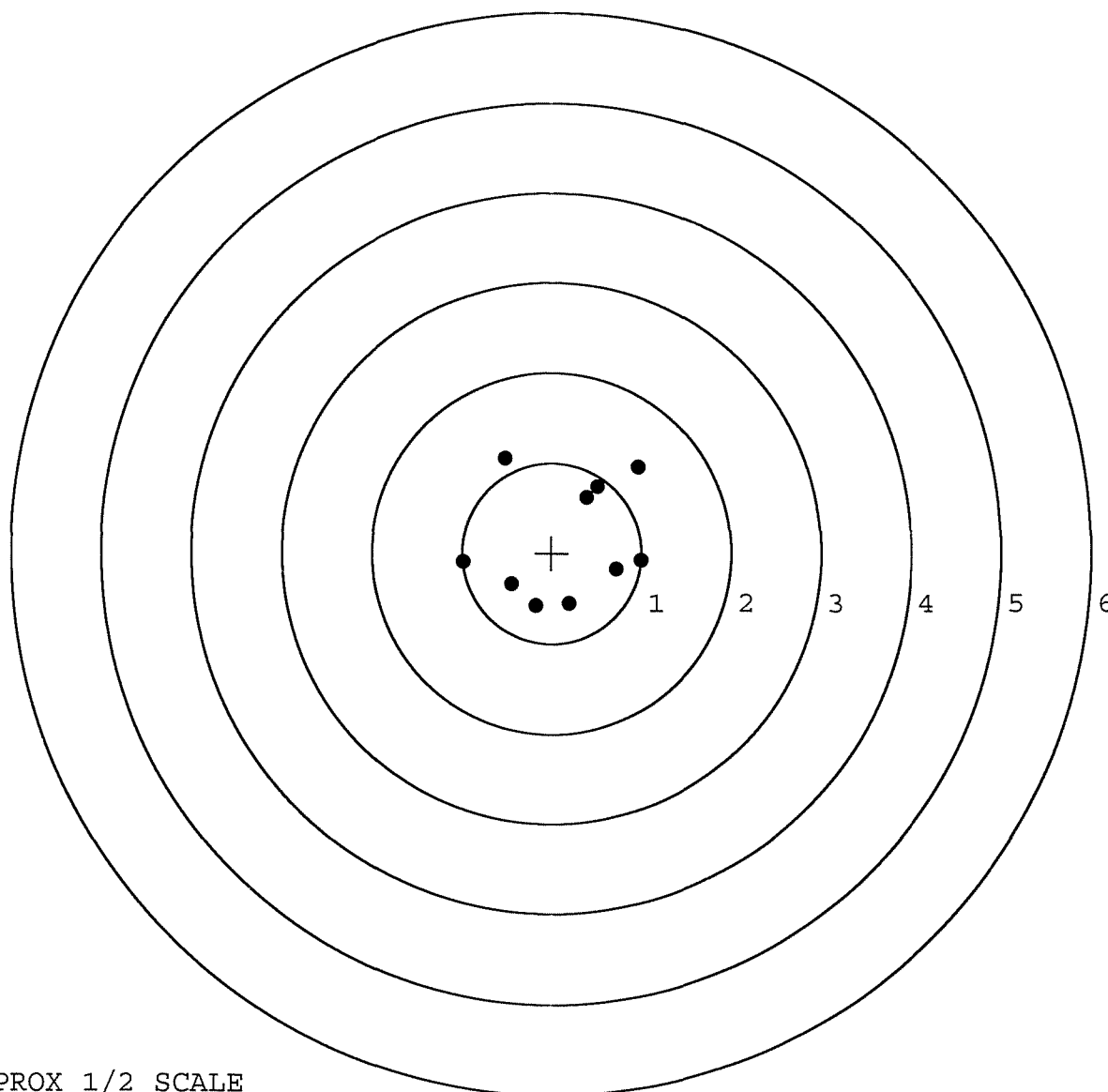


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6587532. __0
TARGET NUMBER: 2
FILE DATE: 06/17/2005
FILE TIME: 09:14

X CENTROID: 0.164
Y CENTROID: 0.150
POA TO CENTROID: 0.222
HORZ SPREAD: 1.987
VERT SPREAD: 1.642
GROUP SPREAD: 2.230
MIN RADIUS: 0.521
MAX RADIUS: 1.184
MEAN RADIUS: 0.849
IN 1 IN DIAMETER: 0
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.199	-0.566
2:	-0.178	-0.591
3:	-0.450	-0.348
4:	-0.993	-0.100
5:	-0.517	1.051
6:	0.970	0.959
7:	0.508	0.740
8:	0.389	0.620
9:	0.994	-0.084
10:	0.722	-0.182

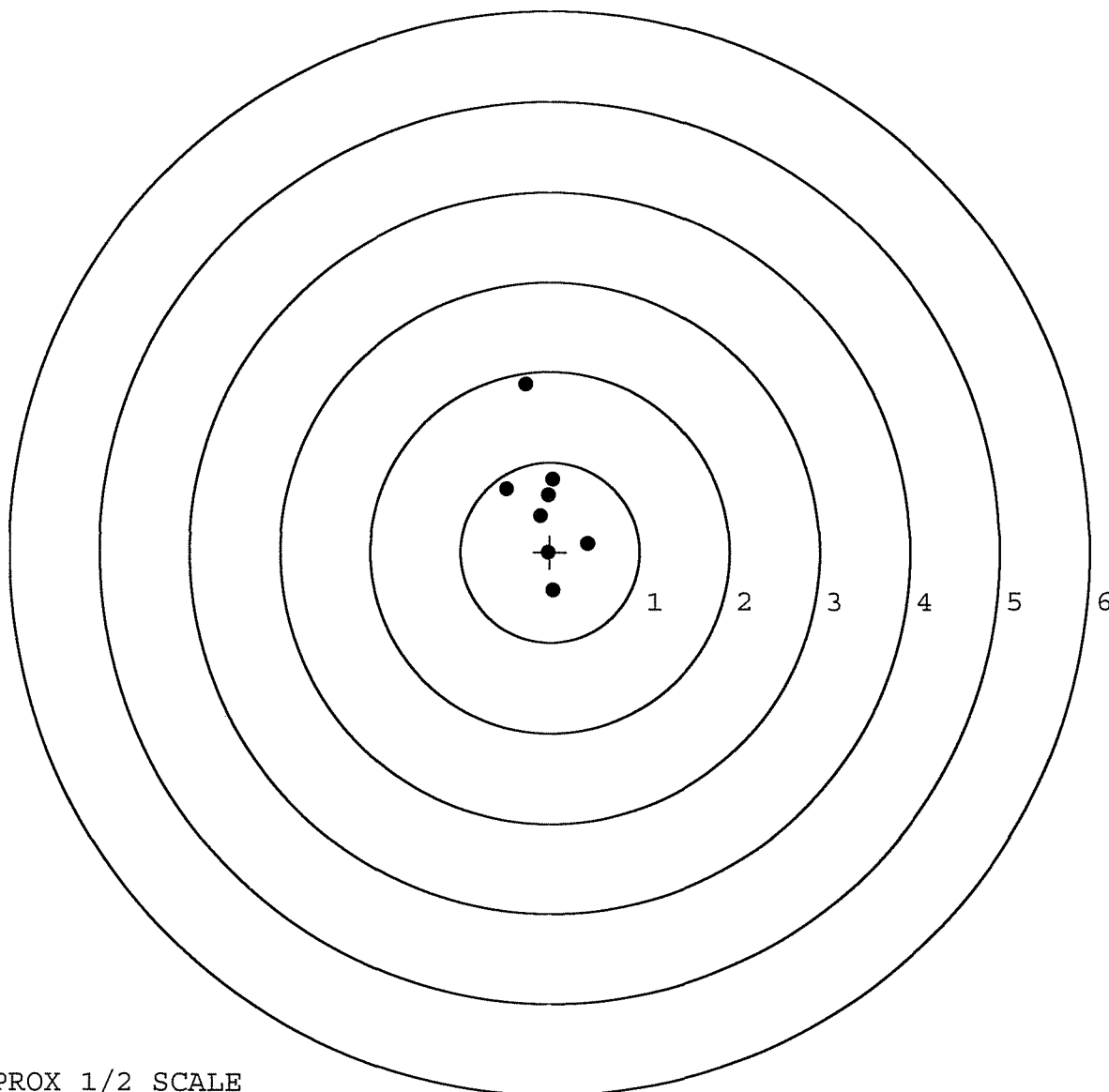


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6587532. __0
TARGET NUMBER: 3
FILE DATE: 06/17/2005
FILE TIME: 09:14

POINT#	X	Y
1:	-0.025	-0.012
2:	0.034	-0.429
3:	0.419	0.098
4:	0.421	0.098
5:	-0.105	0.405
6:	-0.019	0.637
7:	0.040	0.811
8:	-0.483	0.706
9:	-0.271	1.855
10:	-0.275	1.855

X CENTROID: -0.026
Y CENTROID: 0.602
POA TO CENTROID: 0.603
HORZ SPREAD: 0.904
VERT SPREAD: 2.284
GROUP SPREAD: 2.305
MIN RADIUS: 0.035
MAX RADIUS: 1.277
MEAN RADIUS: 0.648
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 10

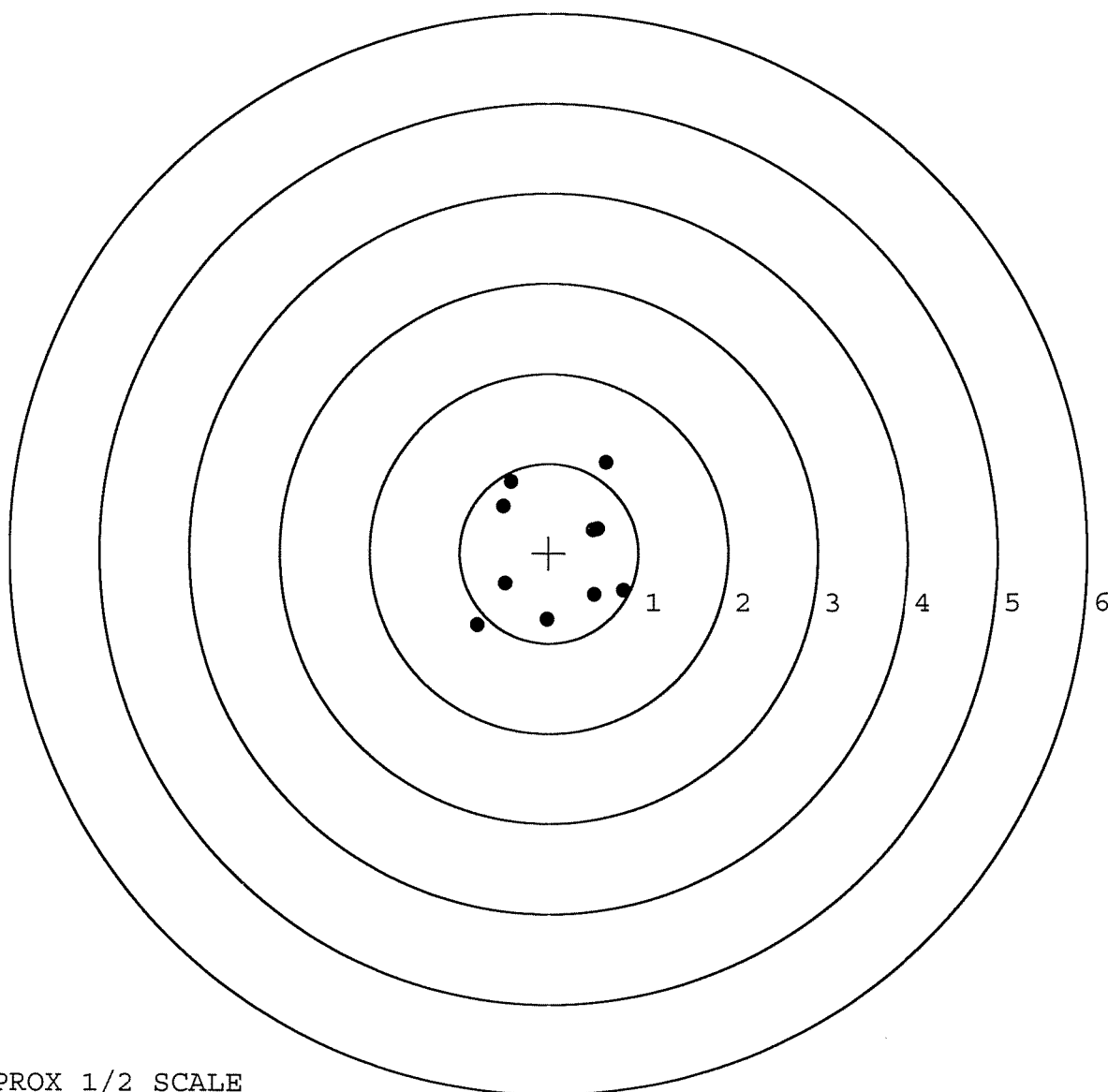


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6587532.___0
TARGET NUMBER: 4
FILE DATE: 06/17/2005
FILE TIME: 09:14

X CENTROID: 0.078
Y CENTROID: 0.007
POA TO CENTROID: 0.079
HORZ SPREAD: 1.638
VERT SPREAD: 1.810
GROUP SPREAD: 2.316
MIN RADIUS: 0.490
MAX RADIUS: 1.196
MEAN RADIUS: 0.803
IN 1 IN DIAMETER: 1
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.835	-0.421
2:	0.512	-0.472
3:	-0.023	-0.743
4:	-0.803	-0.802
5:	-0.493	-0.343
6:	-0.424	0.794
7:	-0.512	0.522
8:	0.500	0.256
9:	0.642	1.008
10:	0.548	0.273

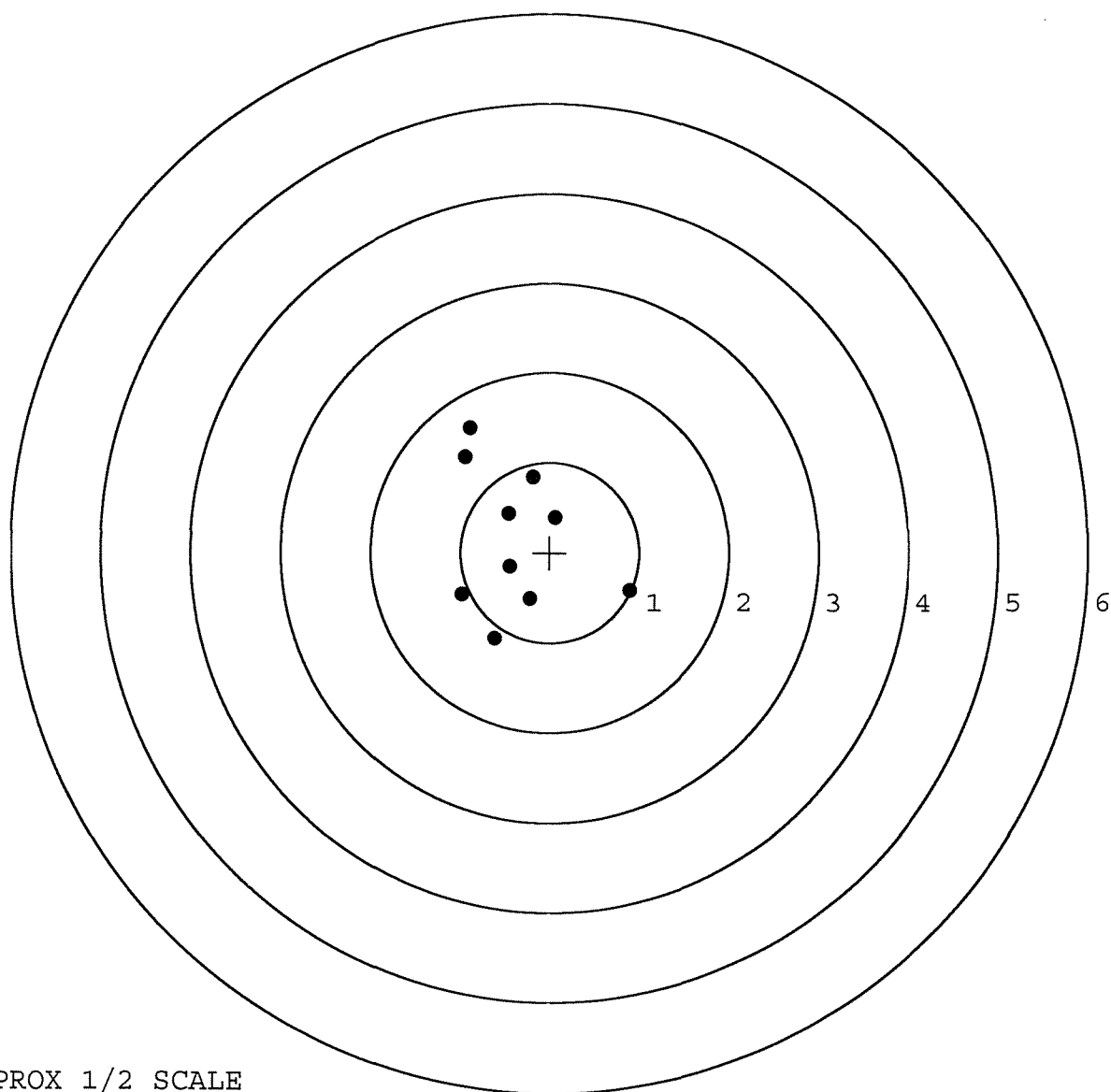


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6587532.___0
TARGET NUMBER: 5
FILE DATE: 06/17/2005
FILE TIME: 09:14

X CENTROID: -0.378
Y CENTROID: 0.158
POA TO CENTROID: 0.410
HORZ SPREAD: 1.876
VERT SPREAD: 2.329
GROUP SPREAD: 2.534
MIN RADIUS: 0.289
MAX RADIUS: 1.398
MEAN RADIUS: 0.830
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 6
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.070	0.390
2:	-0.181	0.837
3:	-0.460	0.435
4:	-0.448	-0.156
5:	-0.982	-0.467
6:	-0.221	-0.517
7:	-0.620	-0.955
8:	0.894	-0.422
9:	-0.893	1.374
10:	-0.944	1.057



TARGET APPROX 1/2 SCALE

R & E NUMBER	92951		
SERIAL NUMBER	C6587532		
LOG-IN DATE	2-10-05		
INSPECT AND VERIFY:			
OPERATION #	OPERATION NAME	DATE	INITIAL
550	DIS-ASSEMBLE GUN	4-26-05	RTZ
560 A	RE-BARREL	5-3-05	RTZ
B	DRILL AND TAP	5-5-05	TRW
575	ASSEMBLE	5-3-05	RTZ
600	PROOF	5-4-05	AC
605	CHECK HEADSPACE	5-4-05	AC
610	DIS-ASSEMBLE GUN	5-3-05	RTZ
612	MAGNAFLUX		
615	ROLLMARK CALIBER	5-9-05	CW
618	ROTO-BLAST	5-9-05	LB
620	APPLY COATINGS	5-16-05	WJ
625 A	FINAL ASSEMBLY	6-16-05	RTZ
B	TRIGGER PULL TEST		
C	SAFETY "ON" FORCE	6-27-05	AC
D	SAFETY "OFF" FORCE	6-27-05	AC
E	FIRING PIN INDENT	6-27-05	AC
640	TARGET	6-17-05	AC
655	FINAL INSPECT	6-27-05	AC
660	PACK	7-6-05	DA
		SHIP DATE	
QAR INSPECTION DATE			



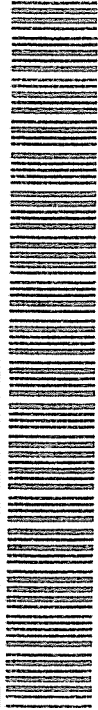

VERY IMPORTANT-
Instruction Book
enclosed to assure
safe use of this
firearm.

MODEL 700™ H24

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

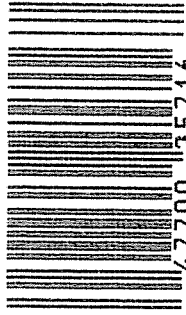
SERIAL NO.
C6587532

ORDER NO.
5716



5716 C6587532

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C 6587532

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		10/31/90	Kd
600	Proof		10/31/90	Kd
607	Check Headspace		10/31/90	Kd
610	Dis-assemble Gun		10/31/90	Kd
612	Magnaflux Barrel Action		11/1/90	KCR
	Magnaflux Bolt		11/1/90	KCR
615	Rollmark Caliber		11/1/90	KCR
617	Drill and Tap Sight Holes		11/5/90	KCB
618	Polish Barrel RB		11/6/90	WCB
620	Apply Coatings (Barrel Action)		11/26/90	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		11/27/90	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		11/27/90	KS
	C) Inspect Ejector Hole for Chamfer		11/27/90	KS
	D) Oil Firing Pin Ass'y		11/27/90	KS
	E) Adjust Trigger Pull to Min Setting and Stake		12/8/90	JA

op. #	OP. NAME	READINGS			DATE	INIT		
625 cont.	F) Safety On Force	4	4	4	12/8/90	RW		
	G) Safety Off Force	3	3	2.5	12/8/90	RW		
	H) Trigger Pull Test & Retainability				12/8/90	JH		
	I) Firing Pin Indent	.0205	.0205	.0205	12/8/90	RW		
	J) Assemble Stock				12/8/90	KS		
	K) Assemble Swivel Studs				12-12-90	QJ		
	L) Attach Front and Rear Sight Assemblies				12/8/90	KS		
	M) Iron Sight Alignment				12/8/90	KS		
	N) Detach Front & Rear Sights & place in numbered container				12/8/90	KS		
	O) Attach Scope to Rifle				12/8/90	KS		
	P) Detach & Attach Scope 20 Times				12/8/90	KS		
640	Gallery Target & Test				12/10/90	KJ		
	A) Time					KJ		
	B) Malfunctions					KJ		
	C) Pierced Primers					KJ		
	D) Optical Clarity of Scope					KJ		
645	Inspect for Live Ammo				12/10/90	KJ		
655	Final Inspection							
	A) Headspace				12-12-90	QJ		
	B) Trigger Pull	2.49	2.53	2.46	2.50	2.52	12-12-90	QJ
	C) Function						12-12-90	QJ
660	Pack						12/14/90	NF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C6587532DATE 12/8/90TESTER JL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.42	2.44	2.15	249	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.47	2.50	2.10	253	
PULL #3	2.48	2.16	2.48	246	
PULL #4	2.45	2.48	2.44	250	
PULL #5	2.43	2.20	2.43	252	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.38	3.17		
PULL #2	3.26	3.24		
PULL #3	3.26	3.15		
PULL #4	3.18	3.29		
PULL #5	3.18	3.28		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.29	4.33		4.16
PULL #2	4.28	4.18		4.17
PULL #3	4.34	4.21		4.23
PULL #4	4.30	4.17		4.22
PULL #5	4.26	4.16		4.21
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6587532
11 Dec 1990

CENTROIDAL DISTANCES

0 TO	1	.198977
1 TO	2	.342841
1 TO	3	.343796
1 TO	4	.190874
1 TO	5	.188809

2.0
518 <----POA

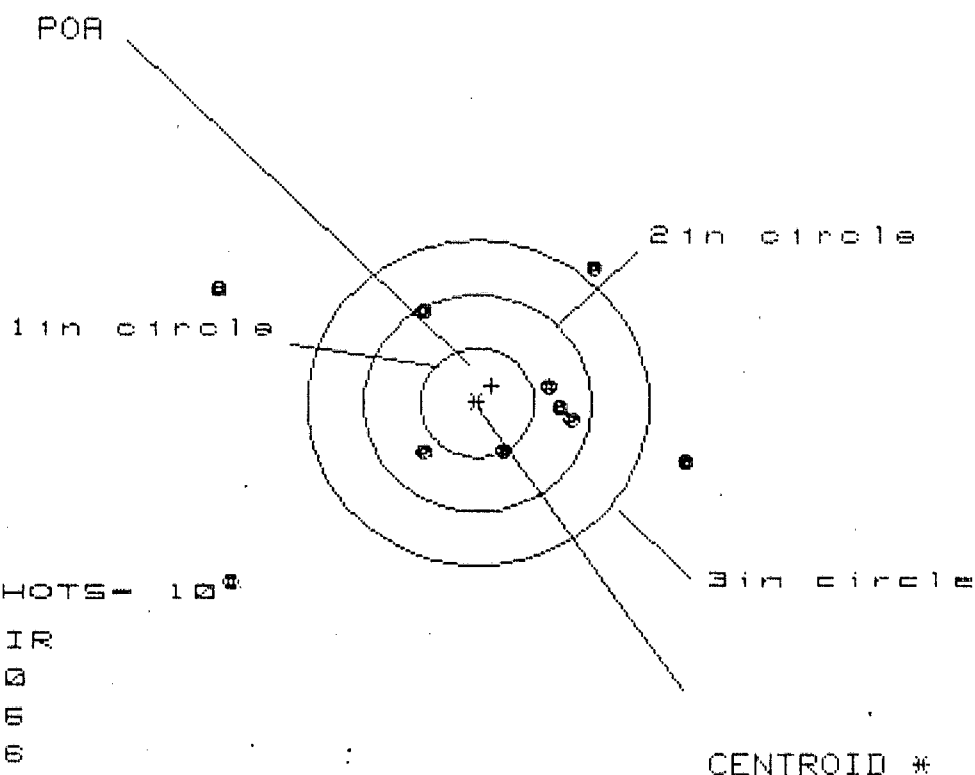
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1116
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0672
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .13027
THE AMR FOR THIS RIFLE IS: 1.172

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CENTERFIRE PATTERNS

1



OF SHOTS- 10⁰

IN CIR

1in = 0

2in = 6

3in = 6

HS= 4.073

VS= 2.821

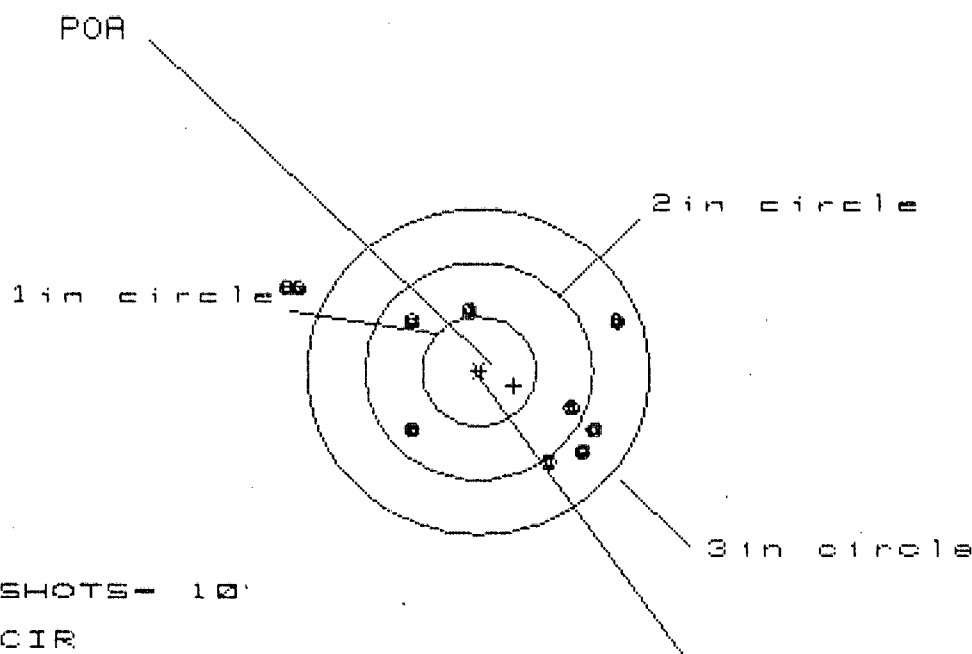
GS= 4.382

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.844	1.605	1.296
MINIMUM X	-2.229	-2.468	-1.059
MAXIMUM Y	1.224	1.046	1.153
MINIMUM Y	-1.597	-0.760	-0.653
CENTROID X	-0.126	0.113	0.422
CENTROID Y	-0.154	0.023	-0.084
POR TO CENTROID in.	0.200	0.116	0.430
MIN RADIUS	0.514	0.431	0.142
MEAN RADIUS	1.302	1.092	0.793
MAX RADIUS	2.685	2.612	1.451
HORIZONTAL SPREAD	4.073	4.073	2.355
VERTICAL SPREAD	2.821	1.806	1.806
EXTREME SPREAD	4.382	4.382	2.747
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	6		

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 0

2in = 4

3in = 8

HS= 2.902

VS= 1.589

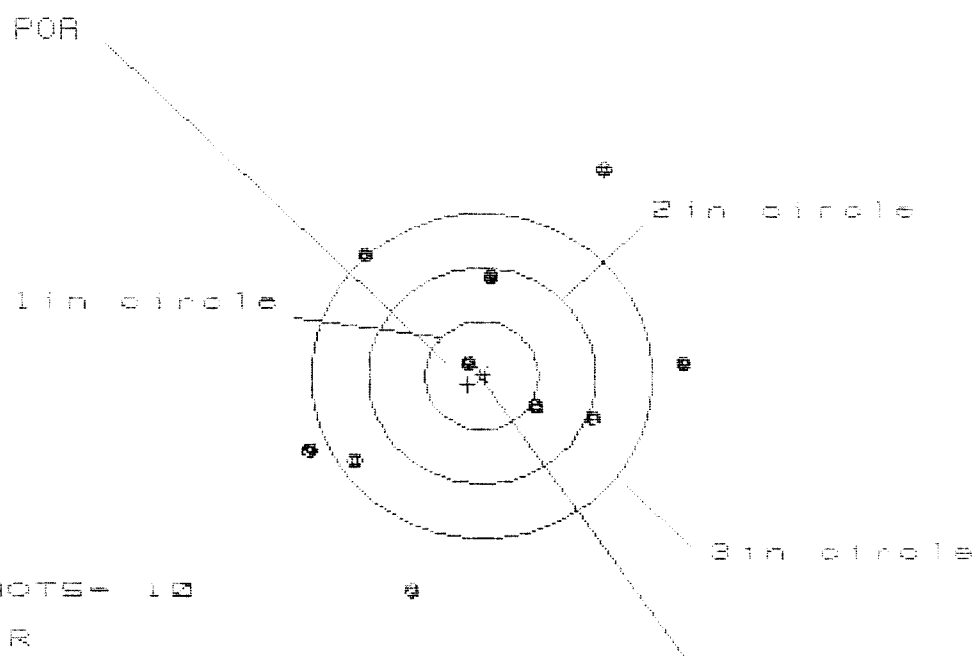
GS= 3.012

PATTERN #	2	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.172	.980	.761
MINIMUM X	-1.729	-1.756	-.996
MAXIMUM Y	.805	.886	.720
MINIMUM Y	-.784	-.703	-.592
CENTROID X	-.312	-.120	.099
CENTROID Y	.134	.053	-.058
POA TO CENTROID in.	.340	.131	.115
MIN RADIUS	.533	.664	.443
MEAN RADIUS	1.119	1.003	.827
MAX RADIUS	1.878	1.967	1.174
HORIZONTAL SPREAD	2.902	2.736	1.757
VERTICAL SPREAD	1.589	1.589	1.312
EXTREME SPREAD	3.012	2.907	2.055
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	8		

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CENTERFIRE PATTERNS # 3



OF SHOTS - 10

IN CIR

1 in = 1

2 in = 3

3 in = 6

HS = 3.282

VS = 3.977

GS = 4.313

CENTROID *

PATTERN #	3	3	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.740	1.856	1.791
MINIMUM X	-1.542	-1.426	-1.491
MAXIMUM Y	1.953	1.364	1.139
MINIMUM Y	-2.024	-1.807	-1.839
CENTROID X	.124	.009	.074
CENTROID Y	.082	-.135	.090
POR TO CENTROID in.	.149	.136	.117
MIN RADIUS	.136	.318	.100
MEAN RADIUS	1.342	1.257	1.135
MAX RADIUS	2.212	1.879	1.793
HORIZONTAL SPREAD	3.282	3.282	3.282
VERTICAL SPREAD	3.977	3.171	1.978
EXTREME SPREAD	4.313	3.369	3.369
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	3		
NUMBER IN THREE INCH CIRCLE =	5		

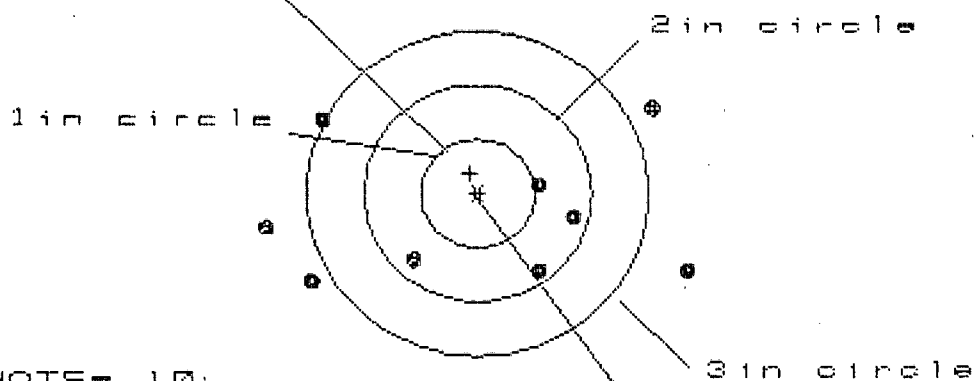
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CENTERFIRE PATTERNS

4

POA



OF SHOTS- 10

IN CIR

1in = 0

2in = 4

3in = 4

HS= 3.745

VS= 2.680

GS= 3.770

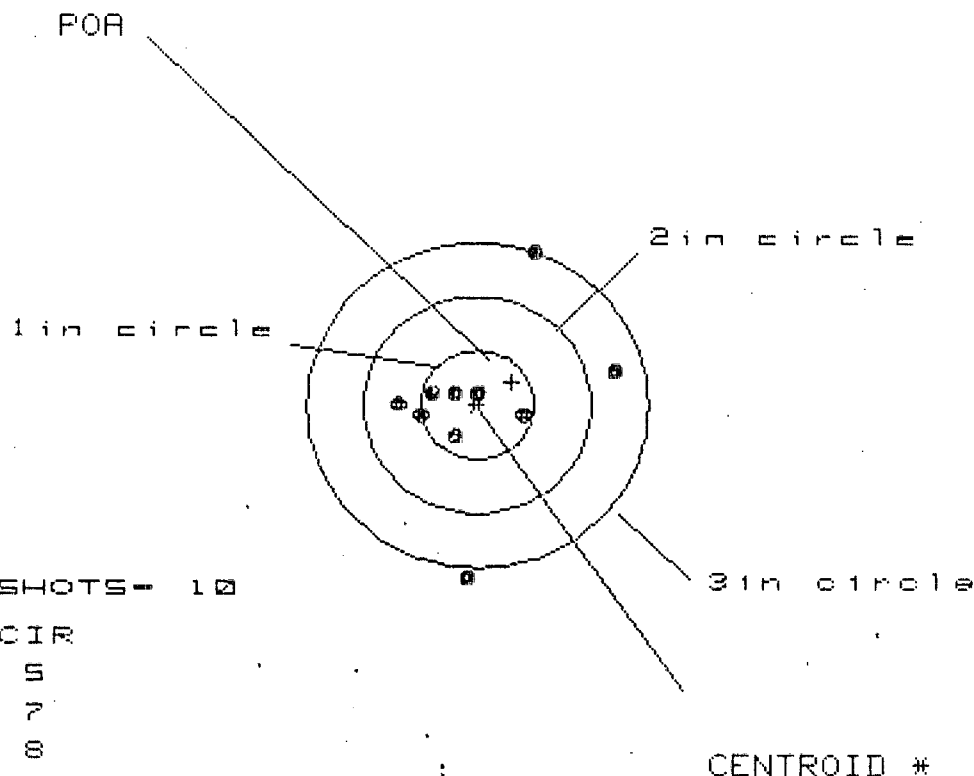
CENTROID *

PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.834	1.735	1.522
MINIMUM X	-1.911	-1.708	-1.508
MAXIMUM Y	1.848	1.768	1.722
MINIMUM Y	-.832	-.912	-.958
CENTROID X	.062	-.141	.072
CENTROID Y	-.187	-.107	-.061
POA TO CENTROID in.	.197	.177	.094
MIN RADIUS	.593	.776	.576
MEAN RADIUS	1.382	1.330	1.247
MAX RADIUS	1.970	1.861	1.787
HORIZONTAL SPREAD	3.745	3.443	3.030
VERTICAL SPREAD	2.680	2.680	2.680
EXTREME SPREAD	3.770	3.596	3.419
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	4		

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in = 5

2 in = 7

3 in = 8

HS= 1.961

VS= 3.056

GS= 3.112

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.222	1.209	1.266
MINIMUM X	-.739	-.752	-.695
MAXIMUM Y	1.430	1.249	.281
MINIMUM Y	-1.626	-.421	-.265
CENTROID X	-.306	-.293	-.350
CENTROID Y	-.211	-.030	-.186
POA TO CENTROID in.	.371	.294	.396
MIN RADIUS	.147	.034	.133
MEAN RADIUS	.717	.616	.490
MAX RADIUS	1.630	1.330	1.297
HORIZONTAL SPREAD	1.961	1.961	1.961
VERTICAL SPREAD	3.056	1.670	.546
EXTREME SPREAD	3.112	1.989	1.989
NUMBER IN ONE INCH CIRCLE =		5	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		8	

R 94-18074

SCOPE 91-0020

SHIP TO:

AL 36201-5025

AL
36201-5025

CUST NO:098397 C-D.D

WRITE ☐

MAIN FAULT

REPAIRMAN	PROOF	CLEAN	TEST <i>AC</i>	TARGET	PATTERN
GALLERY TESTER	DATE	DATE	DATE <i>11/1/95</i>	DATE	DATE

RD6925 REV. 1/94

M2400022220

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

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

SERIAL NO. C6587532

DATE 8-30-95

TESTER DA

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.59	2.58	2.65		MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.78	2.58	2.64		
PULL #3	2.73	2.54	2.62		
PULL #4	2.57	2.54	2.61		
PULL #5	2.63	2.56	2.61		
TOTAL	1330	1280	1313		
AVG.	266	256	262		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.37	3.34		
PULL #2	3.40	3.31		
PULL #3	3.15	3.26		
PULL #4	3.34	3.34		
PULL #5	3.28	3.33		
TOTAL	1654	1660		
AVG.	3.30	3.32		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.06	4.12	4.32	
PULL #2	4.17	4.07	4.28	
PULL #3	4.12	4.11	4.26	
PULL #4	4.17	4.06	4.24	
PULL #5	4.09	4.08	4.30	
TOTAL	2061	2044	2140	
AVG.	4.12	4.08	4.28	

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6587532

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

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4 1/2	4 3/4	5			11/22	WB
	G) Safety Off Force	3 1/4	3 1/4	3			11/22	WB
	H) Trigger Pull Test & Retainability							
	I) Firing Pin Indent	.021	.021	.021			11/22/95	WB
	J) Assemble Stock							
	K) Assemble Swivel Studs							
	L) Attach Front and Rear Sight Assemblies							
	M) Iron Sight Alignment							
	N) Detach Front & Rear Sights & place in numbered container							
	O) Attach Scope to Rifle							
	P) Detach & Attach Scope 20 Times							
640	Gallery Target & Test							
	A) Time							
	B) Malfunctions							
	C) Pierced Primers							
	D) Optical Clarity of Scope							
645	Inspect for Live Ammo							
655	Final Inspection							
	A) Headspace							
	B) Trigger Pull	2.81	2.79	2.65	2.73	2.69	11/22/95	WB
	C) Function							
660	Pack							