

C6587577

MODEL 700™ N24

Model SMS™

Action

Barrel Length

Capacity

Order No. 5716

\*Includes 1 in chamber.

*Remington*

## Repair Inquiry

Repair Number: RE00146507

Serial: C6587577 Model M24 SWS Center Fire  
Caliber: 7.62 NATO

Repairman:

Verify Repair

Status:

Closed 6/17/2008 9:50:25 AM

## Address Information

Customer:

☒ Received From

Return To:

☐ Received From

Name: DEF DIST DEPOT

DEF DIST DEPOT

Address 1: 7 FRANKFORD AVE BLDG 362

7 FRANKFORD AVE BLDG 362

Address 2: PO Box:

PO Box:

City: ANNISTON

ANNISTON

State: AL Zip Code: 36201

Country: US

State: AL Zip Code: 36201

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   |
| A057 | Fit and Rear Sgt Base | 1   |

Repair Search

Refresh

Close

nagletj

6/17/2008

10:48 AM

CAPS

NUM

INS

SCRL



Number: C6587577

Model: M24 SWS



RE00146507

INSPECTION CHECKLIST - REPAIRS  
CONTRACT #: W52H09-07-C-0207  
ISSUED 10/1/2007

|               |                 |  |  |  |  |
|---------------|-----------------|--|--|--|--|
| R & E NUMBER  | <u>146507</u>   |  |  |  |  |
| SERIAL NUMBER | <u>C6587577</u> |  |  |  |  |
| LOG-IN DATE   | <u>6-17-08</u>  |  |  |  |  |

| OPERATION # | OPERATION NAME       | DATE                     | INITIAL |            |
|-------------|----------------------|--------------------------|---------|------------|
| 500         | DIS-ASSEMBLE GUN     | 9-8-09                   | RTZ     |            |
| 505         | RE-BARREL            | 9-11-09                  | RTZ     |            |
| 420         | ASSEMBLE             | 9-11-09                  | RTZ     |            |
| 440         | PROOF                | 9-11-09                  | RPD     |            |
| 460         | CHECK HEADSPACE      | 9-11-09                  | RPD     |            |
| 470         | DIS-ASSEMBLE GUN     | 9-11-09                  | RPD     |            |
| 480         | MAGNAFLUX            | 9/11/09                  | RPD     |            |
| 510         | DRILL AND TAP        | 9-14-09                  | SP      |            |
| 500         | ROLLMARK CALIBER     | 9/17/09                  | SP      |            |
| 520         | GOFF BLAST BBL / REC | 9/17/09                  | RPD     |            |
| 530 & 540   | APPLY COATINGS       | 9/18                     |         |            |
| 560         | FINAL ASSEMBLY       | 9-29-09                  | RTZ     |            |
| 640         | FUNCTION TEST AND    | 9-29-09                  | RPD     | PASS FAIL  |
| 650         | TARGET               | 9-29-09                  | RPD     | PASS FAIL  |
|             | MALFUNCTION          |                          |         | CORRECTION |
|             | MALFUNCTION          |                          |         | CORRECTION |
|             | MALFUNCTION          |                          |         | CORRECTION |
|             | MALFUNCTION          |                          |         | CORRECTION |
| 670         | FINAL INSPECTION     | 9-29-09                  | RP      |            |
|             | A) HEADSPACE         | 9/30/09                  | RP      | PASS FAIL  |
|             | B) TRIGGER PULL      | 2.74 2.85 2.77 2.81 2.80 | 9-30-09 | TC         |
| 680         | F) SAFETY ON FORCE   | 4.9 4.9 4.9              | 9/30/09 | RP         |
|             | G) SAFETY OFF FORCE  | 6.9 6.9 6.9              |         |            |
|             | I) FIRING PIN INDENT | .023 .023 .023           |         |            |
| 690         | PACK                 | 10/9/09                  | Fm      |            |

F006 REV 1/2009

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6587577.\_\_\_0

FILE DATE AND TIME: 09/30/2009 07:07

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

|                                                             |        |
|-------------------------------------------------------------|--------|
| The Average X Centroid of the Five Target Set:              | -0.073 |
| The Average Y Centroid of the Five Target Set:              | 0.070  |
| The Average Point of Impact of the Five Target Set:         | 0.101  |
| The Average Mean Radius of the Five Target Set:             | 0.593  |
| The Distance from POA to Centroid Target #1:                | 0.144  |
| The Distance from Centroid Target #2 to Centroid Target #1: | 0.111  |
| The Distance from Centroid Target #3 to Centroid Target #1: | 0.153  |
| The Distance from Centroid Target #4 to Centroid Target #1: | 0.197  |
| The Distance from Centroid Target #5 to Centroid Target #1: | 0.194  |

SERIAL NUMBER: C6587577. \_\_0

TARGET NUMBER: 1

FILE DATE: 09/30/2009

FILE TIME: 07:07

X CENTROID: -0.054

Y CENTROID: 0.133

POA TO CENTROID: 0.144

HORZ SPREAD: 1.200

VERT SPREAD: 1.271

GROUP SPREAD: 1.593

MIN RADIUS: 0.316

MAX RADIUS: 0.917

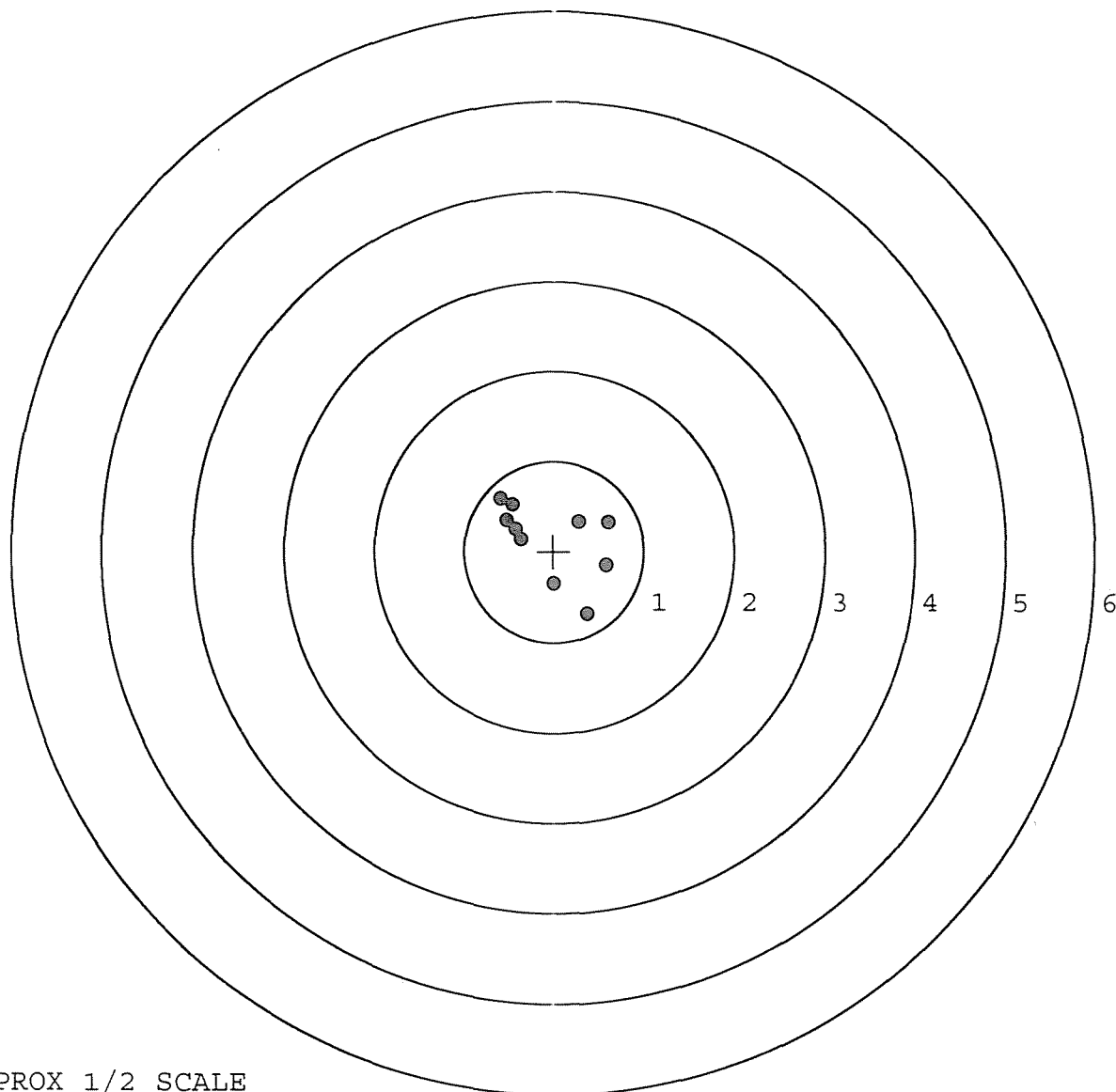
MEAN RADIUS: 0.568

# IN 1 IN DIAMETER: 4

# IN 2 IN DIAMETER: 10

# in 3 IN DIAMETER: 10

| POINT# | X      | Y      |
|--------|--------|--------|
| 1:     | 0.367  | -0.682 |
| 2:     | 0.606  | 0.333  |
| 3:     | 0.581  | -0.148 |
| 4:     | 0.006  | -0.355 |
| 5:     | 0.279  | 0.338  |
| 6:     | -0.370 | 0.134  |
| 7:     | -0.594 | 0.589  |
| 8:     | -0.460 | 0.521  |
| 9:     | -0.527 | 0.352  |
| 10:    | -0.432 | 0.247  |



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6587577. \_\_0

TARGET NUMBER: 2

FILE DATE: 09/30/2009

FILE TIME: 07:07

X CENTROID: 0.032

Y CENTROID: 0.202

POA TO CENTROID: 0.205

HORZ SPREAD: 1.699

VERT SPREAD: 1.712

GROUP SPREAD: 2.034

MIN RADIUS: 0.383

MAX RADIUS: 1.188

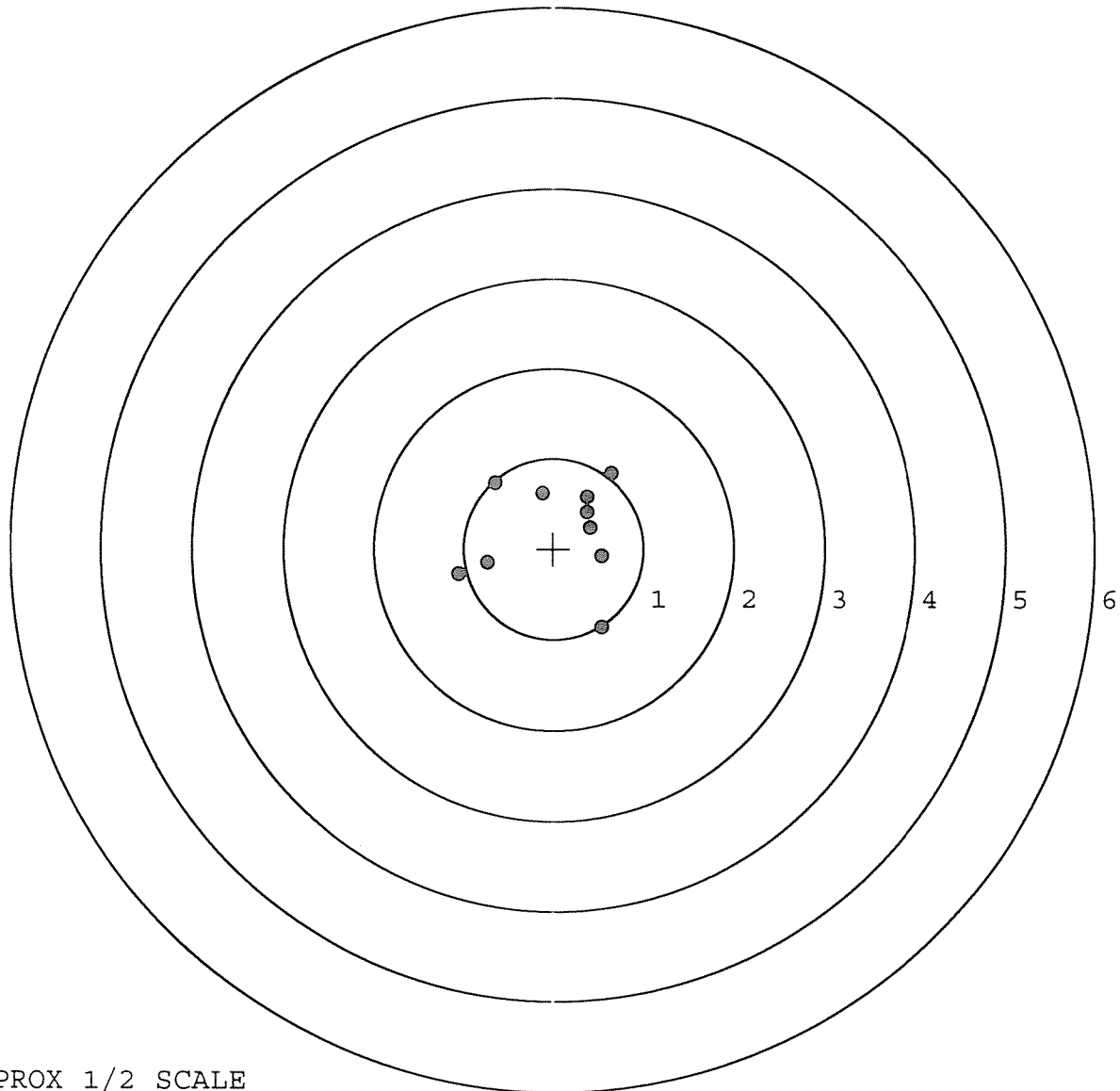
MEAN RADIUS: 0.728

# IN 1 IN DIAMETER: 3

# IN 2 IN DIAMETER: 8

# in 3 IN DIAMETER: 10

| POINT# | X      | Y      |
|--------|--------|--------|
| 1:     | 0.534  | -0.873 |
| 2:     | -1.054 | -0.280 |
| 3:     | -0.736 | -0.157 |
| 4:     | -0.648 | 0.730  |
| 5:     | 0.536  | -0.080 |
| 6:     | -0.124 | 0.615  |
| 7:     | 0.645  | 0.839  |
| 8:     | 0.413  | 0.239  |
| 9:     | 0.375  | 0.413  |
| 10:    | 0.377  | 0.575  |

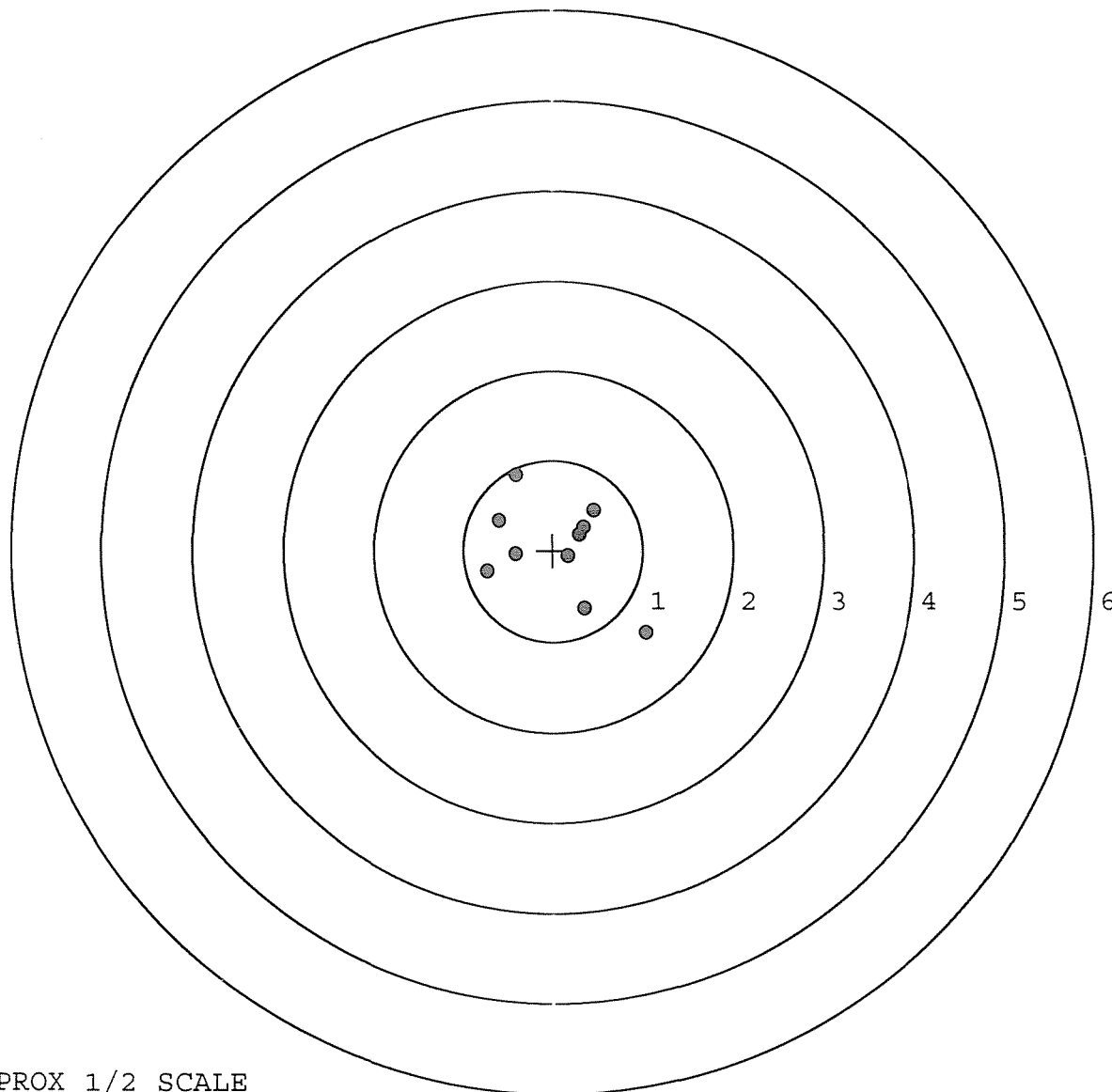


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6587577. \_\_0  
TARGET NUMBER: 3  
FILE DATE: 09/30/2009  
FILE TIME: 07:07

X CENTROID: 0.045  
Y CENTROID: 0.017  
POA TO CENTROID: 0.048  
HORZ SPREAD: 1.765  
VERT SPREAD: 1.740  
GROUP SPREAD: 2.257  
MIN RADIUS: 0.148  
MAX RADIUS: 1.347  
MEAN RADIUS: 0.642  
# IN 1 IN DIAMETER: 4  
# IN 2 IN DIAMETER: 9  
# in 3 IN DIAMETER: 10

| POINT# | X      | Y      |
|--------|--------|--------|
| 1:     | 1.030  | -0.903 |
| 2:     | 0.450  | 0.445  |
| 3:     | -0.408 | 0.837  |
| 4:     | 0.348  | -0.638 |
| 5:     | 0.172  | -0.060 |
| 6:     | -0.609 | 0.333  |
| 7:     | -0.419 | -0.043 |
| 8:     | -0.735 | -0.232 |
| 9:     | 0.287  | 0.174  |
| 10:    | 0.337  | 0.254  |



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6587577. 0

TARGET NUMBER: 4

FILE DATE: 09/30/2009

FILE TIME: 07:07

X CENTROID: -0.172

Y CENTROID: -0.026

POA TO CENTROID: 0.174

HORZ SPREAD: 1.365

VERT SPREAD: 1.164

GROUP SPREAD: 1.372

MIN RADIUS: 0.080

MAX RADIUS: 0.833

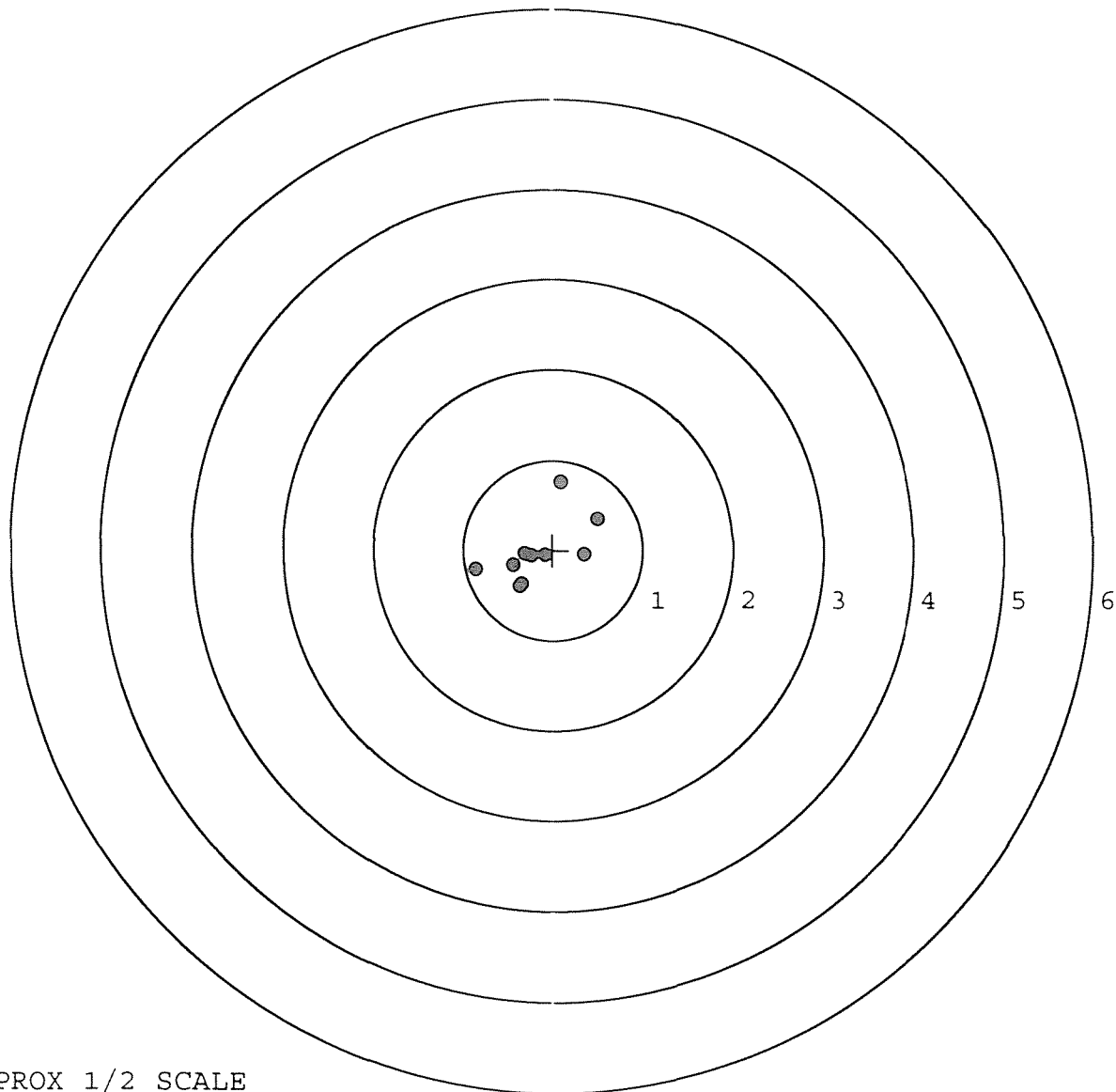
MEAN RADIUS: 0.428

# IN 1 IN DIAMETER: 6

# IN 2 IN DIAMETER: 10

# in 3 IN DIAMETER: 10

| POINT# | X      | Y      |
|--------|--------|--------|
| 1:     | -0.863 | -0.217 |
| 2:     | 0.098  | 0.762  |
| 3:     | 0.502  | 0.353  |
| 4:     | 0.350  | -0.047 |
| 5:     | -0.092 | -0.057 |
| 6:     | -0.348 | -0.375 |
| 7:     | -0.315 | -0.041 |
| 8:     | -0.441 | -0.167 |
| 9:     | -0.242 | -0.065 |
| 10:    | -0.370 | -0.402 |



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6587577. 0

TARGET NUMBER: 5

FILE DATE: 09/30/2009

FILE TIME: 07:07

X CENTROID: -0.214

Y CENTROID: 0.023

POA TO CENTROID: 0.216

HORZ SPREAD: 1.165

VERT SPREAD: 2.208

GROUP SPREAD: 2.302

MIN RADIUS: 0.167

MAX RADIUS: 1.309

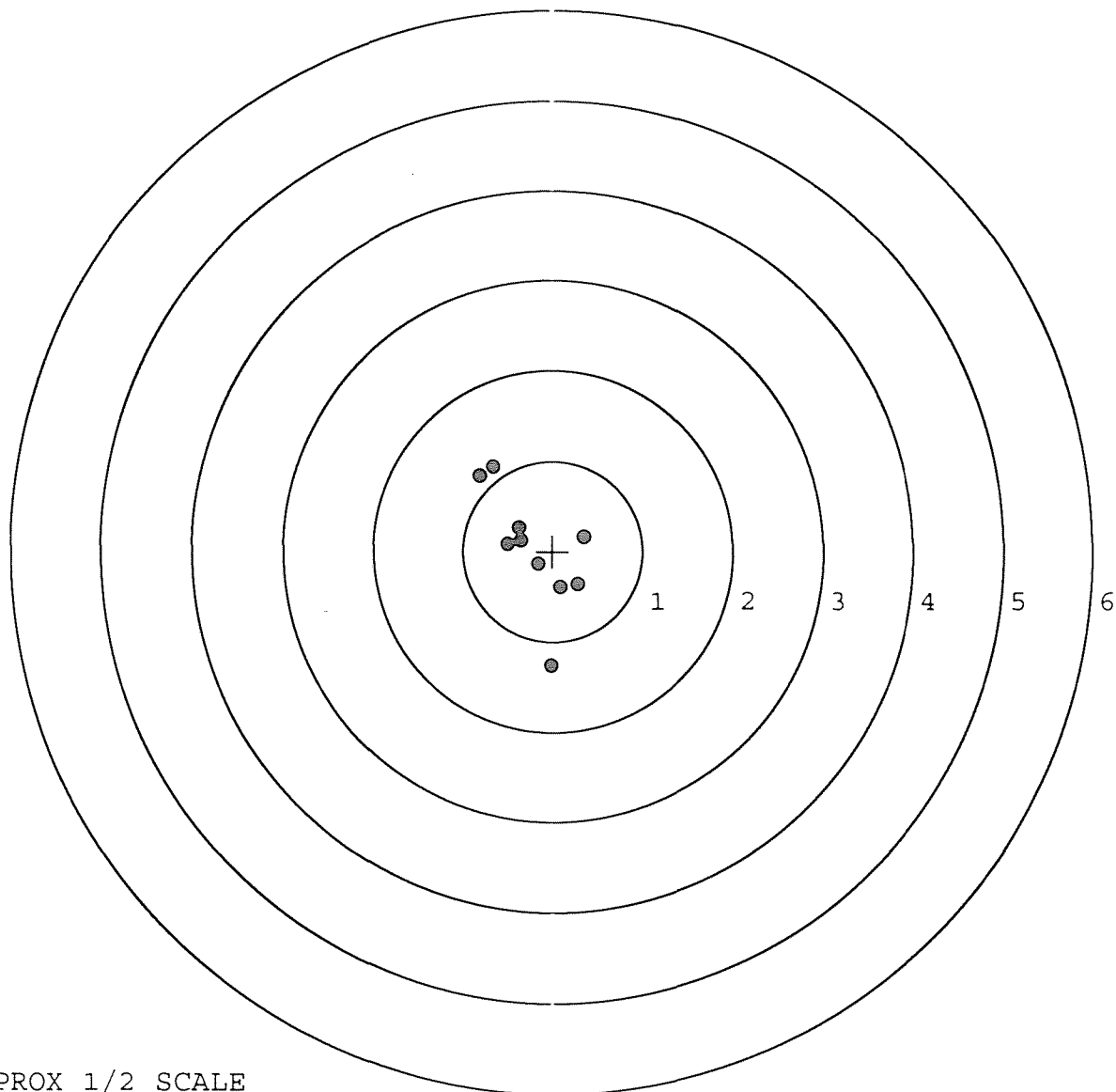
MEAN RADIUS: 0.599

# IN 1 IN DIAMETER: 4

# IN 2 IN DIAMETER: 7

# in 3 IN DIAMETER: 10

| POINT# | X      | Y      |
|--------|--------|--------|
| 1:     | -0.014 | -1.271 |
| 2:     | 0.354  | 0.163  |
| 3:     | -0.666 | 0.937  |
| 4:     | -0.811 | 0.840  |
| 5:     | -0.372 | 0.262  |
| 6:     | -0.495 | 0.082  |
| 7:     | -0.348 | 0.123  |
| 8:     | -0.161 | -0.142 |
| 9:     | 0.087  | -0.400 |
| 10:    | 0.281  | -0.367 |



TARGET APPROX 1/2 SCALE

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: RE00092663 Serial: C6587577 Model: M24 SWS Center Fire Caliber: 7.62 NATO Repairman: Status: Closed 2/8/2005 7:41:23 AM

Verify Repair

**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   |

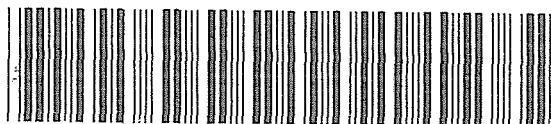
Repair Search Refresh Close

magletj 2/8/2005 9:40 AM CAPS NUM INS SCPL

start 3 4

Serial Number: C6587577

Model: M24 SWS



RE00092663

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6587577.\_\_\_0

FILE DATE AND TIME: 03/08/2005 07:46

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

|                                                             |        |
|-------------------------------------------------------------|--------|
| The Average X Centroid of the Five Target Set:              | 0.009  |
| The Average Y Centroid of the Five Target Set:              | -0.061 |
| The Average Point of Impact of the Five Target Set:         | 0.062  |
| The Average Mean Radius of the Five Target Set:             | 0.874  |
| The Distance from POA to Centroid Target #1:                | 0.079  |
| The Distance from Centroid Target #2 to Centroid Target #1: | 0.189  |
| The Distance from Centroid Target #3 to Centroid Target #1: | 0.186  |
| The Distance from Centroid Target #4 to Centroid Target #1: | 0.193  |
| The Distance from Centroid Target #5 to Centroid Target #1: | 0.191  |

SERIAL NUMBER: C6587577.\_\_\_0

TARGET NUMBER: 1

FILE DATE: 03/08/2005

FILE TIME: 07:46

X CENTROID: -0.053

Y CENTROID: -0.058

POA TO CENTROID: 0.079

HORZ SPREAD: 2.031

VERT SPREAD: 1.549

GROUP SPREAD: 2.453

MIN RADIUS: 0.067

MAX RADIUS: 1.360

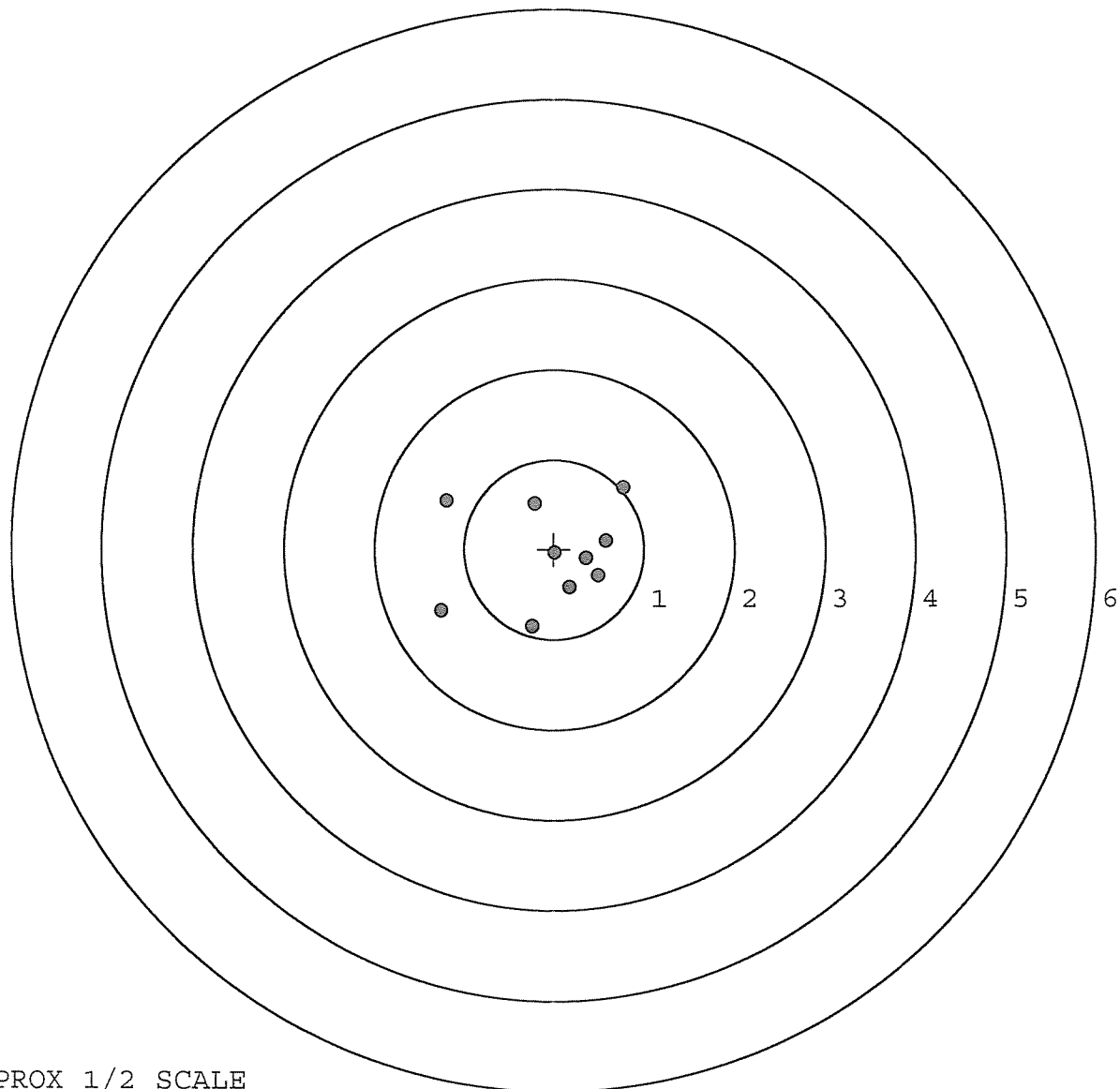
MEAN RADIUS: 0.734

# IN 1 IN DIAMETER: 3

# IN 2 IN DIAMETER: 7

# in 3 IN DIAMETER: 10

| POINT# | X      | Y      |
|--------|--------|--------|
| 1:     | -0.244 | -0.861 |
| 2:     | -1.259 | -0.688 |
| 3:     | -1.199 | 0.544  |
| 4:     | -0.214 | 0.512  |
| 5:     | 0.772  | 0.688  |
| 6:     | 0.574  | 0.098  |
| 7:     | 0.489  | -0.294 |
| 8:     | 0.177  | -0.432 |
| 9:     | 0.012  | -0.042 |
| 10:    | 0.357  | -0.102 |



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6587577. \_\_0

TARGET NUMBER: 2

FILE DATE: 03/08/2005

FILE TIME: 07:46

X CENTROID: 0.130

Y CENTROID: -0.012

POA TO CENTROID: 0.130

HORZ SPREAD: 2.806

VERT SPREAD: 2.192

GROUP SPREAD: 3.183

MIN RADIUS: 0.483

MAX RADIUS: 1.694

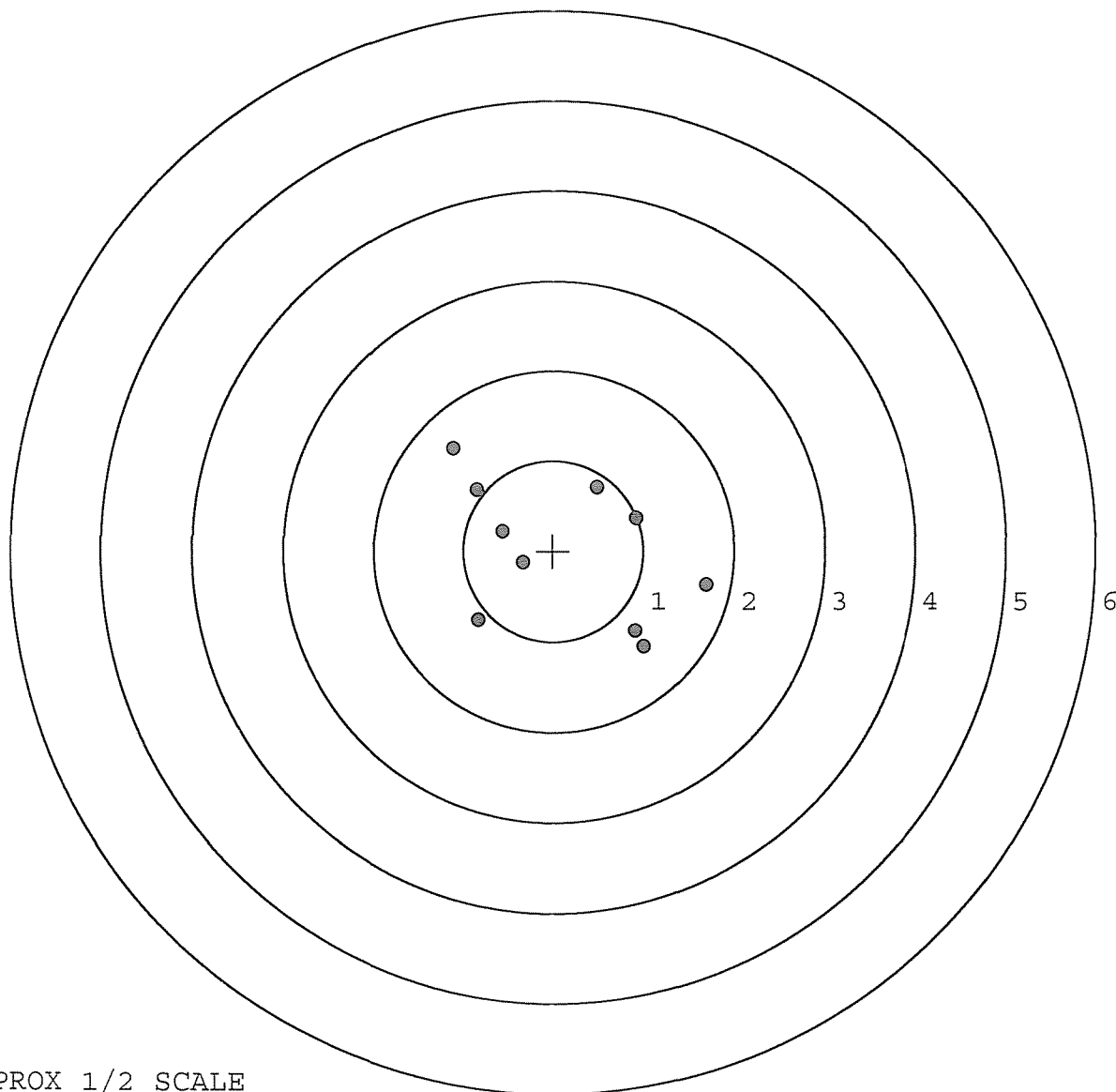
MEAN RADIUS: 1.114

# IN 1 IN DIAMETER: 1

# IN 2 IN DIAMETER: 4

# in 3 IN DIAMETER: 8

| POINT# | X      | Y      |
|--------|--------|--------|
| 1:     | 1.004  | -1.058 |
| 2:     | 0.911  | -0.886 |
| 3:     | 1.688  | -0.368 |
| 4:     | 0.920  | 0.364  |
| 5:     | 0.486  | 0.701  |
| 6:     | -0.338 | -0.133 |
| 7:     | -0.567 | 0.214  |
| 8:     | -0.839 | -0.762 |
| 9:     | -0.849 | 0.674  |
| 10:    | -1.118 | 1.134  |



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6587577.\_\_\_0

TARGET NUMBER: 3

FILE DATE: 03/08/2005

FILE TIME: 07:46

X CENTROID: 0.090

Y CENTROID: 0.062

POA TO CENTROID: 0.109

HORZ SPREAD: 1.940

VERT SPREAD: 2.348

GROUP SPREAD: 2.471

MIN RADIUS: 0.211

MAX RADIUS: 1.399

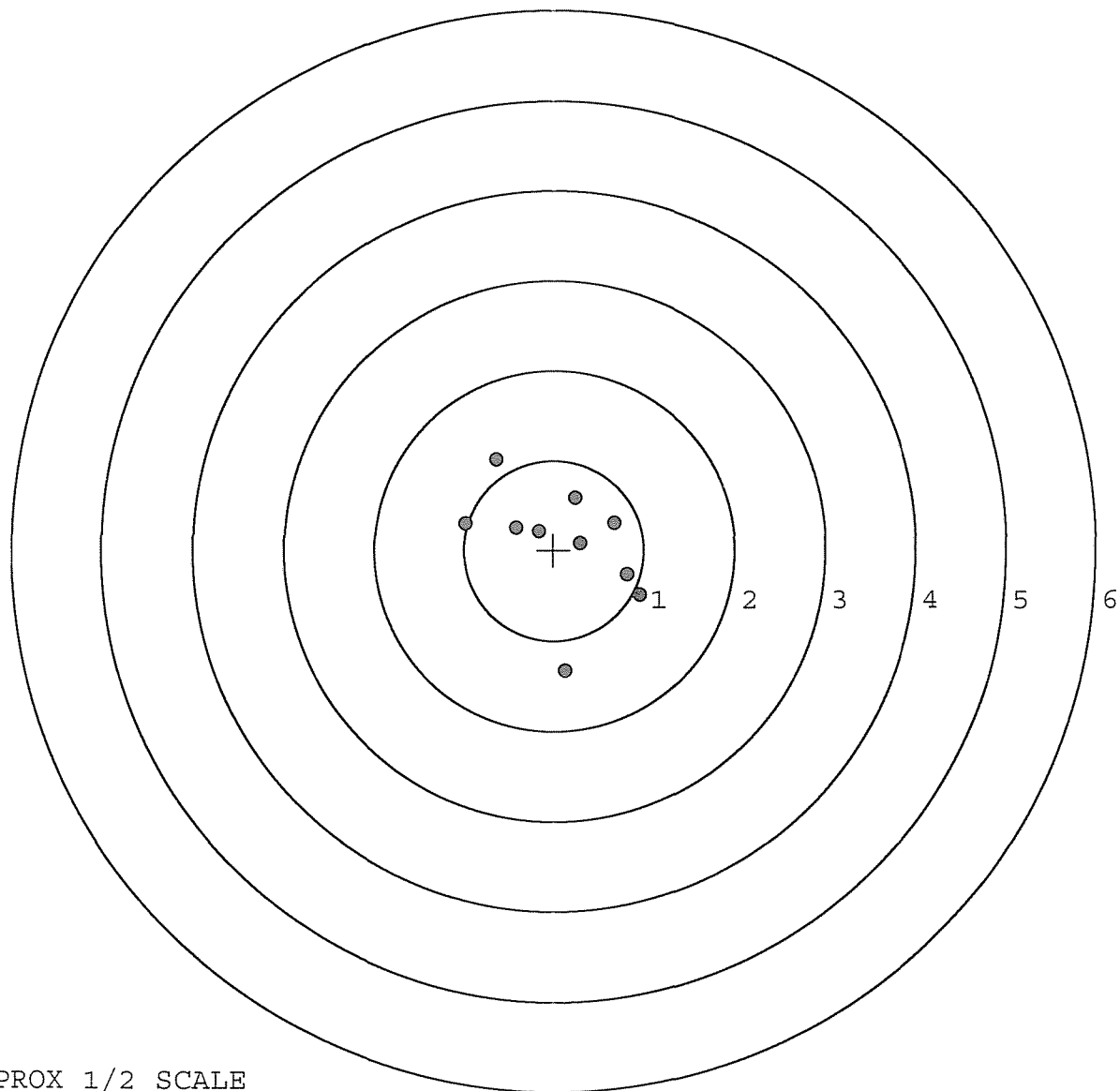
MEAN RADIUS: 0.776

# IN 1 IN DIAMETER: 2

# IN 2 IN DIAMETER: 6

# in 3 IN DIAMETER: 10

| POINT# | X      | Y      |
|--------|--------|--------|
| 1:     | 0.958  | -0.501 |
| 2:     | 0.820  | -0.274 |
| 3:     | 0.130  | -1.337 |
| 4:     | 0.671  | 0.303  |
| 5:     | 0.300  | 0.079  |
| 6:     | 0.238  | 0.581  |
| 7:     | -0.173 | 0.211  |
| 8:     | -0.425 | 0.248  |
| 9:     | -0.982 | 0.297  |
| 10:    | -0.641 | 1.011  |



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6587577. \_\_0

TARGET NUMBER: 4

FILE DATE: 03/08/2005

FILE TIME: 07:46

X CENTROID: 0.107

Y CENTROID: -0.164

POA TO CENTROID: 0.196

HORZ SPREAD: 2.262

VERT SPREAD: 1.865

GROUP SPREAD: 2.785

MIN RADIUS: 0.175

MAX RADIUS: 1.595

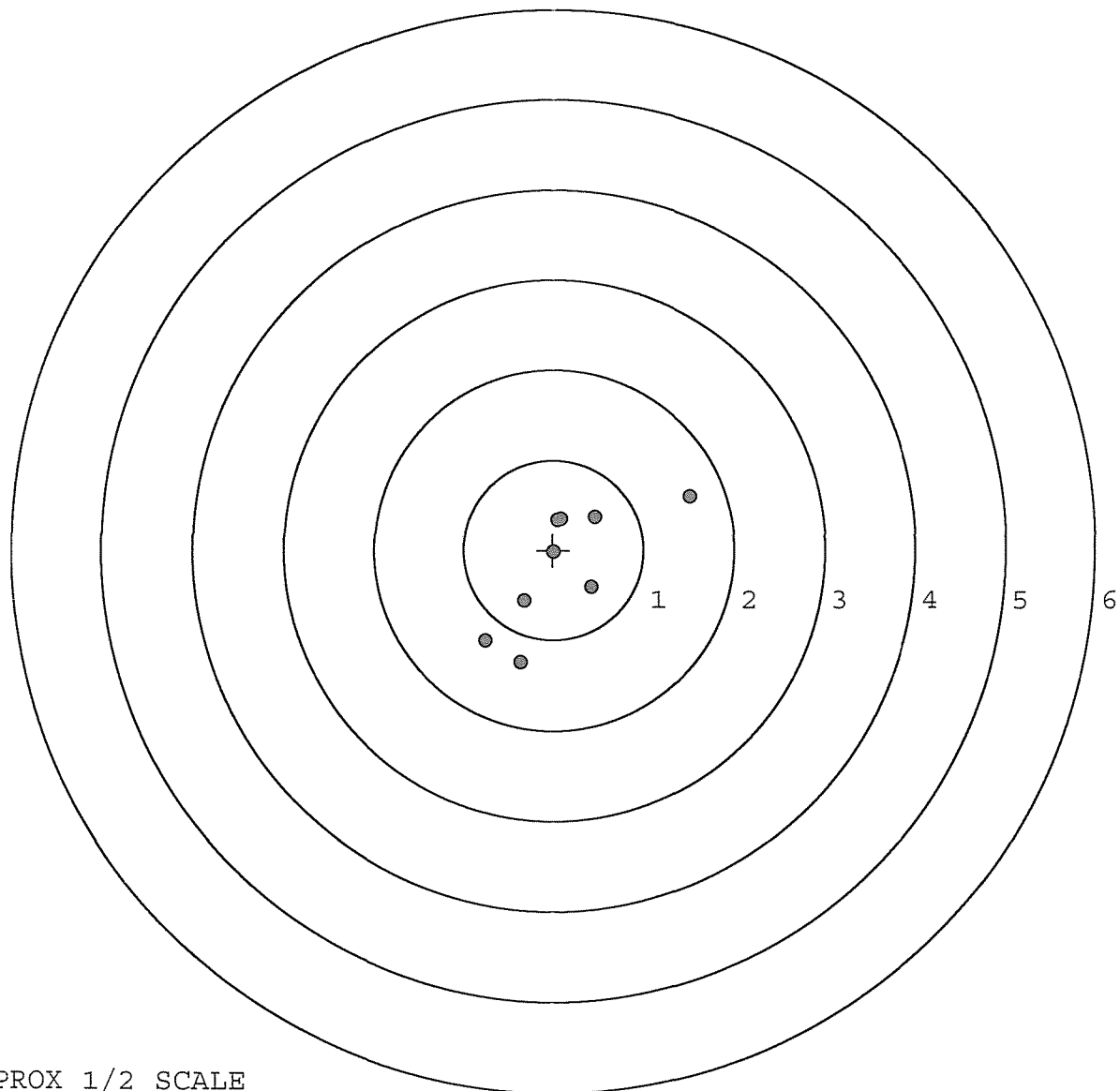
MEAN RADIUS: 0.701

# IN 1 IN DIAMETER: 3

# IN 2 IN DIAMETER: 7

# in 3 IN DIAMETER: 9

| POINT# | X      | Y      |
|--------|--------|--------|
| 1:     | 0.006  | -0.021 |
| 2:     | 0.009  | -0.020 |
| 3:     | -0.363 | -1.259 |
| 4:     | -0.758 | -1.018 |
| 5:     | -0.324 | -0.572 |
| 6:     | 0.420  | -0.419 |
| 7:     | 0.456  | 0.373  |
| 8:     | 0.080  | 0.353  |
| 9:     | 1.504  | 0.606  |
| 10:    | 0.043  | 0.335  |



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6587577. \_\_0

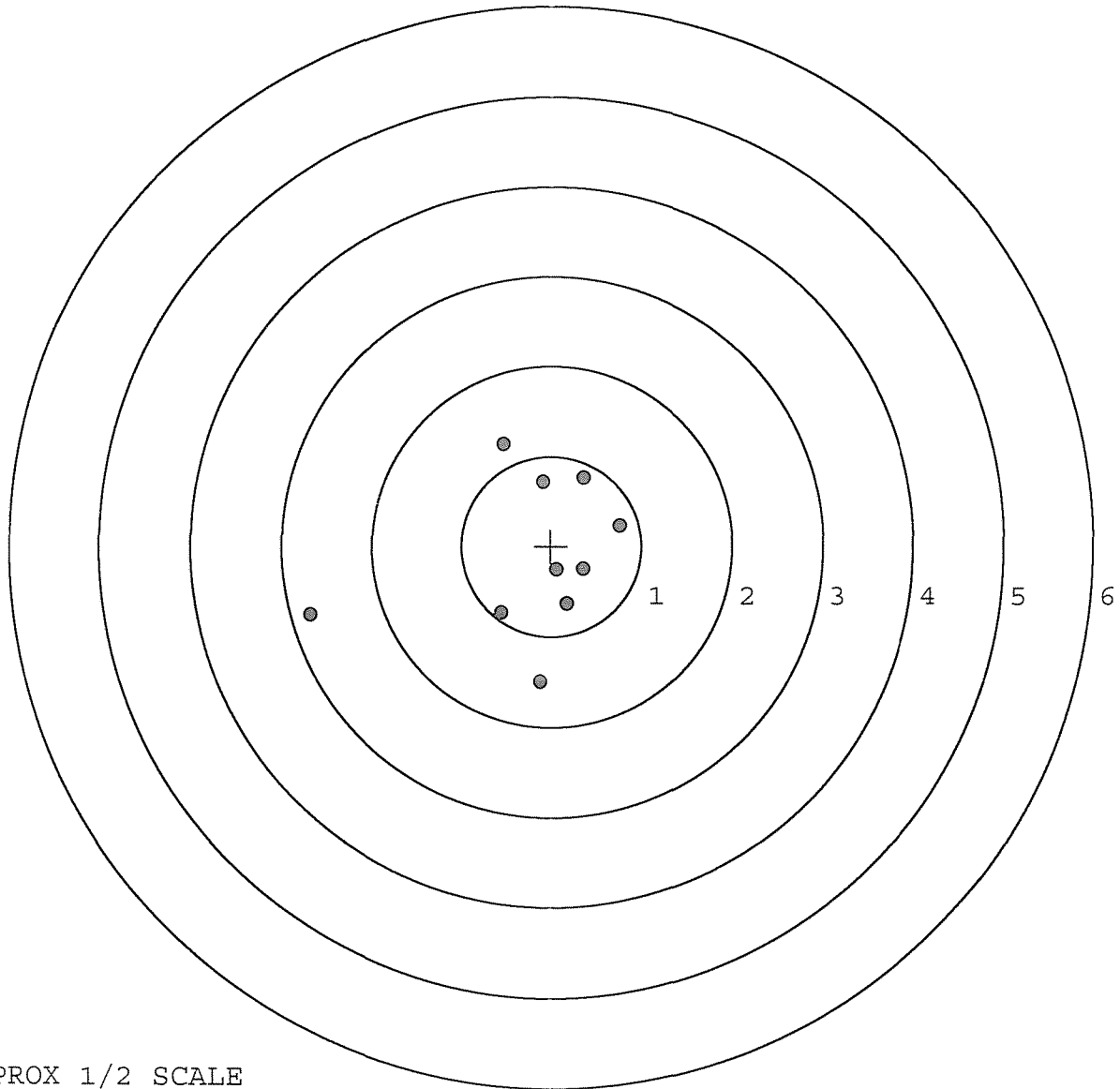
TARGET NUMBER: 5

FILE DATE: 03/08/2005

FILE TIME: 07:46

X CENTROID: -0.229  
Y CENTROID: -0.134  
POA TO CENTROID: 0.265  
HORZ SPREAD: 3.437  
VERT SPREAD: 2.644  
GROUP SPREAD: 3.578  
MIN RADIUS: 0.317  
MAX RADIUS: 2.533  
MEAN RADIUS: 1.045  
# IN 1 IN DIAMETER: 1  
# IN 2 IN DIAMETER: 5  
# in 3 IN DIAMETER: 9

| POINT# | X      | Y      |
|--------|--------|--------|
| 1:     | -0.122 | -1.505 |
| 2:     | -0.555 | -0.744 |
| 3:     | -2.681 | -0.768 |
| 4:     | 0.756  | 0.228  |
| 5:     | 0.356  | 0.761  |
| 6:     | -0.096 | 0.718  |
| 7:     | -0.538 | 1.139  |
| 8:     | 0.061  | -0.262 |
| 9:     | 0.355  | -0.260 |
| 10:    | 0.174  | -0.643 |



TARGET APPROX 1/2 SCALE



**Remington**<sup>®</sup>

MODEL 700<sup>™</sup> M24

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

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

**DUPONT**  
REG. U.S. PAT. & T.M. OFF.

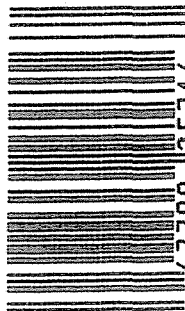
SERIAL NO.  
C6587577

ORDER NO.  
5716



5716 C6587577

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C 6587577

| OP. #        | OP. NAME                                                       | READINGS | DATE     | INIT |
|--------------|----------------------------------------------------------------|----------|----------|------|
| 575 &<br>580 | Assemble Action<br>and Stock                                   |          | 10/22/90 | KH   |
| 600          | Proof                                                          |          | 10/22/90 | KH   |
| 607          | Check Headspace                                                |          | 10/22/90 | KH   |
| 610          | Dis-assemble Gun                                               |          | 10/22/90 | KH   |
| 612          | Magnaflux Barrel<br>Action                                     |          | 10/24/90 | KH   |
|              | Magnaflux Bolt                                                 |          | 10/24/90 | KH   |
| 615          | Rollmark Caliber                                               |          | 10/24/90 | DL   |
| 617          | Drill and Tap Sight Holes                                      |          | 10/25/90 | KH   |
| 618          | Polish Barrel <i>RB</i>                                        |          | 10/26/90 | WH   |
| 620          | Apply Coatings<br>(Barrel Action)                              |          | 11-7-90  | TS   |
|              | Apply Coating (Bolt)                                           |          |          |      |
| 625          | Final Assembly<br>A) Clean inside of<br>Bolt Assembly          |          | 11/8/90  | KH   |
|              | B) Inspect Rear Firing<br>Pin Hole for Chamfer<br>in Bolt Head |          | 11/8/90  | KH   |
|              | C) Inspect Ejector Hole<br>for Chamfer                         |          | 11/8/90  | KH   |
|              | D) Oil Firing Pin Ass'y                                        |          | 11/8/90  | KH   |
|              | E) Adjust Trigger Pull to<br>Min Setting and Stake             |          | 11-10-90 | DL   |

| op. #        | OP. NAME                                                    | READINGS |      |      |     |     | DATE     | INIT |
|--------------|-------------------------------------------------------------|----------|------|------|-----|-----|----------|------|
| 625<br>cont. | F) Safety On Force                                          | 4.50     | 4.50 | 4.25 |     |     | 11-9-90  | K    |
|              | G) Safety Off Force                                         | 2.50     | 2.50 | 2.50 |     |     | 11-9-90  | K    |
|              | H) Trigger Pull Test & Retainability                        |          |      |      |     |     | 11-10-90 | JL   |
|              | I) Firing Pin Indent                                        | 0.22     | 0.23 | 0.22 |     |     | 11-9-90  | K    |
|              | J) Assemble Stock                                           |          |      |      |     |     | 11/10/90 | KS   |
|              | K) Assemble Swivel Studs                                    |          |      |      |     |     | 11-20-90 | JS   |
|              | L) Attach Front and Rear Sight Assemblies                   |          |      |      |     |     | 11/19/90 | KS   |
|              | M) Iron Sight Alignment                                     |          |      |      |     |     | 11/10/90 | KS   |
|              | N) Detach Front & Rear Sights & place in numbered container |          |      |      |     |     | 11/14/90 | KS   |
|              | O) Attach Scope to Rifle                                    |          |      |      |     |     | 11/10/90 | KS   |
|              | P) Detach & Attach Scope 20 Times                           |          |      |      |     |     | 11/10/90 | KS   |
| 640          | Gallery Target & Test                                       |          |      |      |     |     | 11/13/90 | AF   |
|              | A) Time                                                     |          |      |      |     |     | "        | AF   |
|              | B) Malfunctions                                             |          |      |      |     |     | "        | AF   |
|              | C) Pierced Primers                                          |          |      |      |     |     | "        | AF   |
|              | D) Optical Clarity of Scope                                 |          |      |      |     |     | "        | AF   |
| 645          | Inspect for Live Ammo                                       |          |      |      |     |     | 11/13/90 | AF   |
| 655          | Final Inspection                                            |          |      |      |     |     |          |      |
|              | A) Headspace                                                |          |      |      |     |     | 11-20-90 | JS   |
|              | B) Trigger Pull                                             | 264      | 285  | 255  | 287 | 283 | 11-20-90 | JS   |
|              | C) Function                                                 |          |      |      |     |     | 11-20-90 | JS   |
| 660          | Pack                                                        |          |      |      |     |     | 12-17-90 | DL   |

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN  
INITIAL & CYCLE TESTS

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

SERIAL NO. C6587577

DATE 11-10-90

TESTER JH

|         | 2.50#<br>INITIAL | 2.50# AFTER<br>50 CYCLES | FINAL TEST &<br>TO RESET 2.50# |     | COMMENTS                                                               |
|---------|------------------|--------------------------|--------------------------------|-----|------------------------------------------------------------------------|
| PULL #1 | 2.28             | 2.26                     | 2.18                           | 264 | MIN. SETTING,<br>NO AVG. OF 5<br>READINGS ACCEPT-<br>ABLE LESS THAN 2# |
| PULL #2 | 2.48             | 2.44                     | 2.42                           | 285 |                                                                        |
| PULL #3 | 2.37             | 2.43                     | 2.48                           | 255 |                                                                        |
| PULL #4 | 2.19             | 2.47                     | 2.60                           | 287 |                                                                        |
| PULL #5 | 2.21             | 2.36                     | 2.48                           | 283 |                                                                        |
| TOTAL   | 11.53            | 11.96                    | 12.06                          |     |                                                                        |
| AVG.    | 2.306            | 2.392                    | 2.412                          |     |                                                                        |

|         | 3.00#<br>INITIAL | 3.00# AFTER<br>20 CYCLES |  | COMMENTS |
|---------|------------------|--------------------------|--|----------|
| PULL #1 | 3.18             | 3.41                     |  |          |
| PULL #2 | 3.29             | 3.35                     |  |          |
| PULL #3 | 3.34             | 3.23                     |  |          |
| PULL #4 | 3.30             | 3.26                     |  |          |
| PULL #5 | 3.31             | 3.33                     |  |          |
| TOTAL   | 16.42            | 16.58                    |  |          |
| AVG.    | 3.284            | 3.316                    |  |          |

|         | 4.00#<br>INITIAL | 4.00# AFTER<br>20 CYCLES | MAX SETTING<br>GREATER THAN 4# | RESET TO 4# FOR<br>TARGET & ACCURACY |
|---------|------------------|--------------------------|--------------------------------|--------------------------------------|
| PULL #1 | 4.34             | 4.36                     |                                | 4.43                                 |
| PULL #2 | 4.38             | 4.15                     |                                | 4.16                                 |
| PULL #3 | 4.30             | 4.16                     |                                | 4.23                                 |
| PULL #4 | 4.36             | 4.24                     |                                | 4.17                                 |
| PULL #5 | 4.38             | 4.34                     |                                | 4.21                                 |
| TOTAL   | 21.76            | 21.25                    |                                | 21.30                                |
| AVG.    | 4.352            | 4.25                     |                                | 4.26                                 |

CENTROIDAL DISTANCE CALCULATIONS  
FOR RIFLE # 06587577  
14 Nov 1990

CENTROIDAL DISTANCES

|      |   |          |
|------|---|----------|
| 0 TO | 1 | .211729  |
| 1 TO | 2 | .0529528 |
| 1 TO | 3 | .145908  |
| 1 TO | 4 | .393154  |
| 1 TO | 5 | .204365  |

4 <----POA

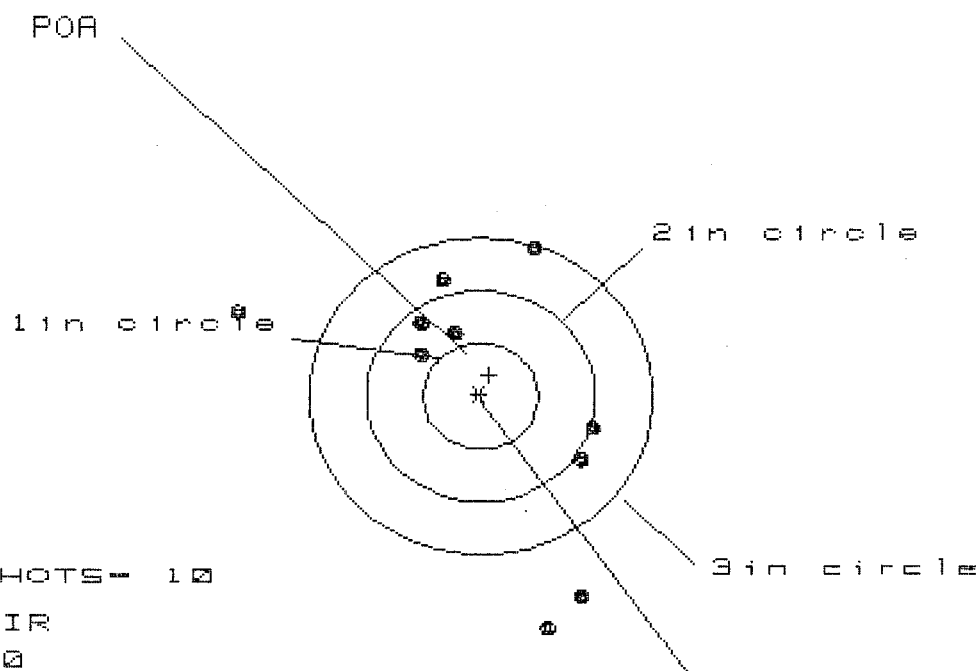
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .033  
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.146  
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .149683  
THE AMR FOR THIS RIFLE IS: 1.153

14 May 1998

FILE:/PATTERNING/CENTERFIRE\_PATT/C6587577

# CENTERFIRE PATTERNS

# 1



# OF SHOTS - 10

# IN CIR

1 in = 1

2 in = 3

3 in = 7

HS = 3.141

VS = 3.563

GS = 4.034

CENTROID #

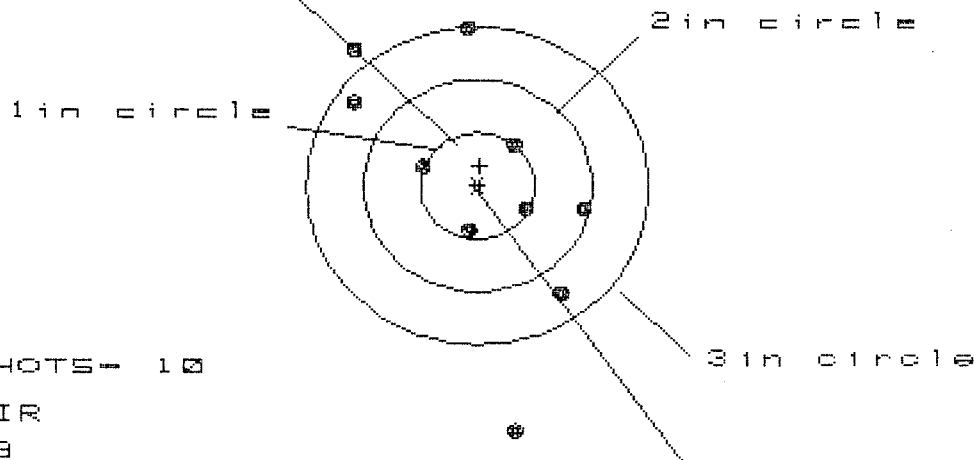
| PATTERN #                   | : | 1      | 9      | 8      |
|-----------------------------|---|--------|--------|--------|
| SHOTS (BEST OF)             | : | 10     | 9      | 8      |
| MAXIMUM X                   | : | 1.021  | .786   | .826   |
| MINIMUM X                   | : | -2.120 | -.803  | -.763  |
| MAXIMUM Y                   | : | 1.377  | 1.469  | 1.207  |
| MINIMUM Y                   | : | -2.186 | -2.094 | -2.022 |
| CENTROID X                  | : | -.075  | .160   | .120   |
| CENTROID Y                  | : | -.198  | -.290  | -.028  |
| POA TO CENTROID in.         | : | .211   | .331   | .123   |
| MIN RADIUS                  | : | .608   | .795   | .563   |
| MEAN RADIUS                 | : | 1.352  | 1.257  | 1.091  |
| MAX RADIUS                  | : | 2.276  | 2.120  | 2.130  |
| HORIZONTAL SPREAD           | : | 3.141  | 1.589  | 1.589  |
| VERTICAL SPREAD             | : | 3.563  | 3.563  | 3.229  |
| EXTREME SPREAD              | : | 4.034  | 3.565  | 3.257  |
| NUMBER IN ONE INCH CIRCLE   | = |        | 0      |        |
| NUMBER IN TWO INCH CIRCLE   | = |        | 3      |        |
| NUMBER IN THREE INCH CIRCLE | = |        | 7      |        |

14 Nov 1998

FILE:/PATTERNING/CENTERFIRE\_PATT/C6587577

# CENTERFIRE PATTERNS # 2

POA



# OF SHOTS- 10

# IN CIR

1 in = 3

2 in = 5

3 in = 8

HS= 2.054

VS= 3.763

GS= 3.788

CENTROID \*

|                               |   |        |        |        |
|-------------------------------|---|--------|--------|--------|
| PATTERN #                     | : | 2      |        |        |
| SHOTS (BEST OF)               | : | 10     | 9      | 8      |
| MAXIMUM X                     | : | .946   | .984   | .859   |
| MINIMUM X                     | : | -1.108 | -1.070 | -1.195 |
| MAXIMUM Y                     | : | 1.492  | 1.239  | 1.364  |
| MINIMUM Y                     | : | -2.271 | -1.252 | -1.127 |
| CENTROID X                    | : | -.023  | -.061  | .064   |
| CENTROID Y                    | : | -.188  | .065   | -.060  |
| POA TO CENTROID in.           | : | .189   | .089   | .088   |
| MIN RADIUS                    | : | .379   | .372   | .328   |
| MEAN RADIUS                   | : | 1.080  | .942   | .854   |
| MAX RADIUS                    | : | 2.297  | 1.476  | 1.375  |
| HORIZONTAL SPREAD             | : | 2.054  | 2.054  | 2.054  |
| VERTICAL SPREAD               | : | 3.763  | 2.491  | 2.491  |
| EXTREME SPREAD                | : | 3.788  | 2.867  | 2.626  |
| NUMBER IN ONE INCH CIRCLE =   |   |        | 3      |        |
| NUMBER IN TWO INCH CIRCLE =   |   |        | 5      |        |
| NUMBER IN THREE INCH CIRCLE = |   |        | 8      |        |

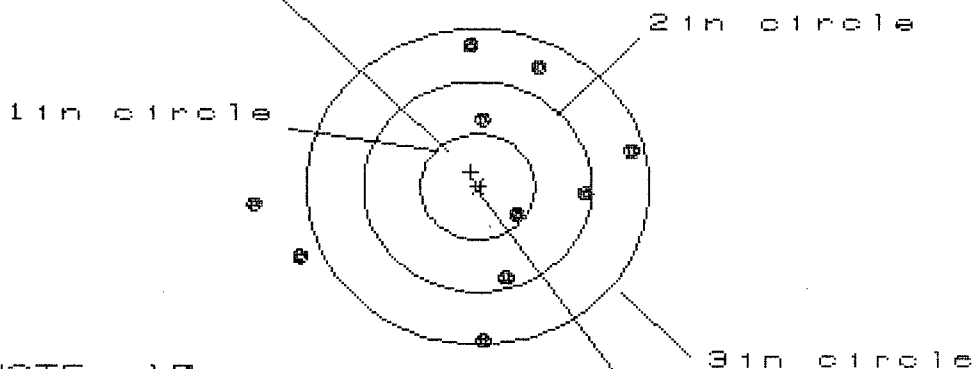
14 Nov 1998

FILE:/PATTERNING/CENTERFIRE\_PATT/C6587577

# CENTERFIRE PATTERNS

# 3

POA



# OF SHOTS= 10

# IN CIR

1in = 1

2in = 4

3in = 8

HS= 3.347

VS= 2.789

GS= 3.376

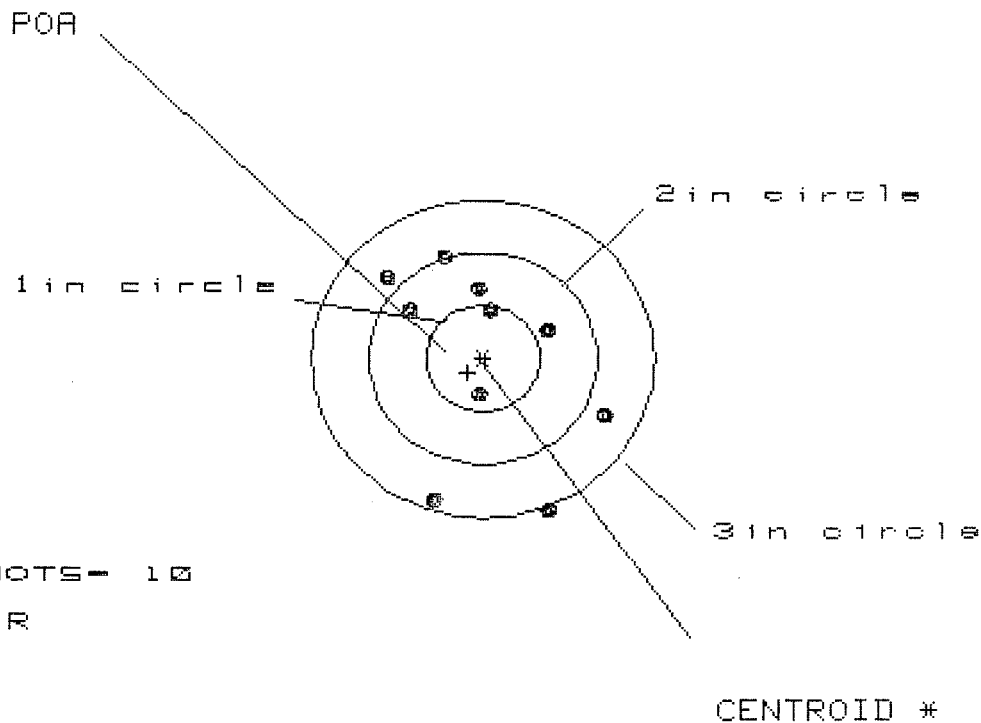
CENTROID #

| PATTERN #                   | : | 3      |        |        |
|-----------------------------|---|--------|--------|--------|
| SHOTS (BEST OF)             | : | 10     | 9      | 8      |
| MAXIMUM X                   | : | 1.382  | 1.163  | .942   |
| MINIMUM X                   | : | -1.965 | -1.769 | -.519  |
| MAXIMUM Y                   | : | 1.359  | 1.344  | 1.255  |
| MINIMUM Y                   | : | -1.430 | -1.445 | -1.534 |
| CENTROID X                  | : | .058   | .277   | .498   |
| CENTROID Y                  | : | -.138  | -.123  | -.034  |
| POA TO CENTROID in.         | : | .150   | .303   | .499   |
| MIN RADIUS                  | : | .434   | .307   | .382   |
| MEAN RADIUS                 | : | 1.200  | 1.067  | .930   |
| MAX RADIUS                  | : | 1.970  | 1.906  | 1.573  |
| HORIZONTAL SPREAD           | : | 3.347  | 2.932  | 1.461  |
| VERTICAL SPREAD             | : | 2.789  | 2.789  | 2.789  |
| EXTREME SPREAD              | : | 3.376  | 3.098  | 2.794  |
| NUMBER IN ONE INCH CIRCLE   | = |        | 1      |        |
| NUMBER IN TWO INCH CIRCLE   | = |        | 4      |        |
| NUMBER IN THREE INCH CIRCLE | = |        | 8      |        |

14 Nov 1998

FILE:/PATTERNING/CENTERFIRE\_PATT/C8587577

# CENTERFIRE PATTERNS # 4



# OF SHOTS- 10

# IN CIR

1 in = 2

2 in = 5

3 in = 9

HS= 1.888

VS= 2.392

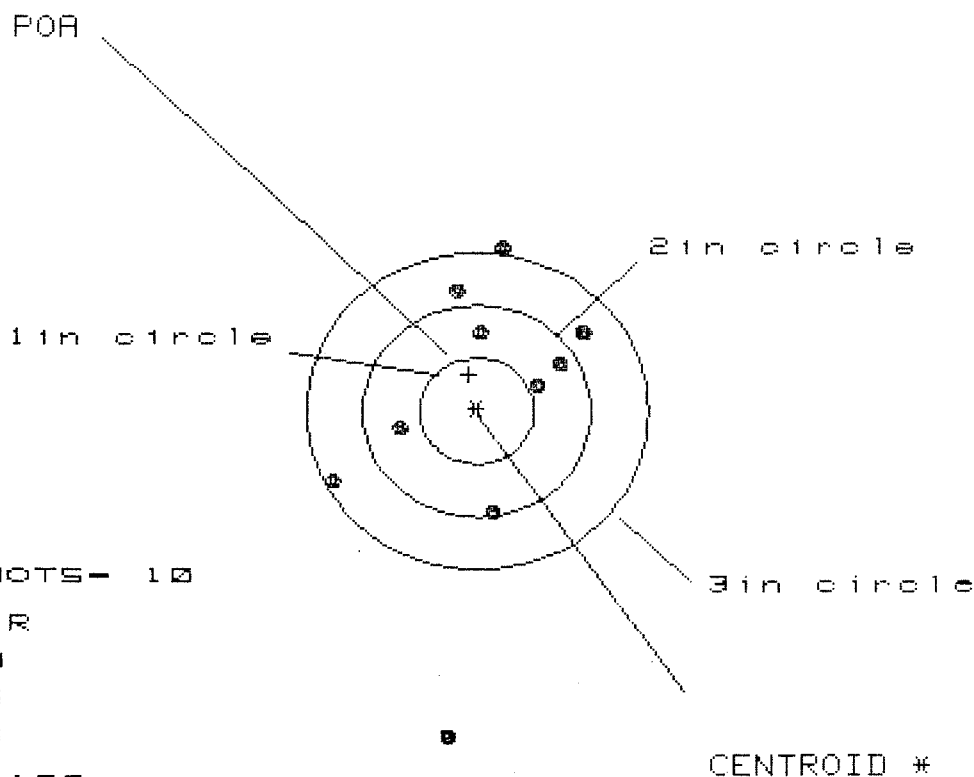
GS= 2.579

| PATTERN #                   | : | 4      |        |       |
|-----------------------------|---|--------|--------|-------|
| SHOTS (BEST OF)             | : | 10     | 9      | 8     |
| MAXIMUM X                   | : | 1.068  | 1.134  | 1.093 |
| MINIMUM X                   | : | -.820  | -.754  | -.794 |
| MAXIMUM Y                   | : | 1.005  | .851   | .670  |
| MINIMUM Y                   | : | -1.387 | -1.446 | -.915 |
| CENTROID X                  | : | .134   | .068   | .108  |
| CENTROID Y                  | : | .135   | .289   | .470  |
| POA TO CENTROID in.         | : | .190   | .297   | .482  |
| MIN RADIUS                  | : | .295   | .303   | .119  |
| MEAN RADIUS                 | : | .903   | .801   | .666  |
| MAX RADIUS                  | : | 1.506  | 1.481  | 1.426 |
| HORIZONTAL SPREAD           | : | 1.888  | 1.888  | 1.888 |
| VERTICAL SPREAD             | : | 2.392  | 2.297  | 1.585 |
| EXTREME SPREAD              | : | 2.579  | 2.297  | 2.293 |
| NUMBER IN ONE INCH CIRCLE   | = |        | 2      |       |
| NUMBER IN TWO INCH CIRCLE   | = |        | 5      |       |
| NUMBER IN THREE INCH CIRCLE | = |        | 9      |       |

14 Nov 1998

FILE:/PATTERNING/CENTERFIRE\_PATT/0658.527

# CENTERFIRE PATTERNS # 5



# OF SHOTS- 10

# IN CIR

1in = 0

2in = 5

3in = 8

HS= 2.162

VS= 4.673

GS= 4.698

| PATTERN #                   | : | 5      | 9      | 8      |
|-----------------------------|---|--------|--------|--------|
| SHOTS (BEST OF)             | : | 10     | 9      | 8      |
| MAXIMUM X                   | : | .886   | .853   | .872   |
| MINIMUM X                   | : | -1.276 | -1.309 | -1.290 |
| MAXIMUM Y                   | : | 1.567  | 1.222  | .969   |
| MINIMUM Y                   | : | -3.106 | -1.289 | -1.136 |
| CENTROID X                  | : | .071   | .104   | .085   |
| CENTROID Y                  | : | -.341  | .004   | -.149  |
| POA TO CENTROID in.         | : | .349   | .105   | .172   |
| MIN RADIUS                  | : | .588   | .377   | .513   |
| MEAN RADIUS                 | : | 1.228  | .935   | .911   |
| MAX RADIUS                  | : | 3.120  | 1.532  | 1.530  |
| HORIZONTAL SPREAD           | : | 2.162  | 2.162  | 2.162  |
| VERTICAL SPREAD             | : | 4.673  | 2.511  | 2.105  |
| EXTREME SPREAD              | : | 4.698  | 2.641  | 2.545  |
| NUMBER IN ONE INCH CIRCLE   | = |        | 0      |        |
| NUMBER IN TWO INCH CIRCLE   | = |        | 5      |        |
| NUMBER IN THREE INCH CIRCLE | = |        | 8      |        |

R 94-18717

FROM:

SHIP TO:

COMMANDER (W52H094138H226)  
DEFENSE DIST DEPOT ANNISTON  
ATTN DDAA-UR BLDG 112  
ANNISTON AL  
36201-5021

CUST NO:098397 C.D.D

| CUSTOMER CONCERN | AMMO | FUNCTION | FINISH | ACCURACY | FIT | INSPECT |
|------------------|------|----------|--------|----------|-----|---------|
| CYCLE            | A1   | B1       |        | P        |     |         |
| TRIGGER GROUP    |      | B2       |        |          | E1  | F1      |
| BOLT ASSY.       |      | B3       |        |          | E2  | F2      |
| BARREL ASSY.     |      | B4       |        | D1       | E3  | F3      |
| REC. ASSY.       |      | B5       |        | D2       | E4  | F4      |
| WOOD             |      |          | C1     | D3       | E5  | F5      |
| METAL            |      |          | C2     |          |     |         |
| MAIN FAULT       |      |          |        |          |     |         |

[illegible]

OFFICE COPY

RD6925 REV. 1/94

**CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER**

**M2400023103**

AVERAGE PULL FORCE BETWEEN  
INITIAL & CYCLE TESTS

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

SERIAL NO. C6587577

DATE 10-28-95

TESTER DA

|         | 2.50#<br>INITIAL | 2.50# AFTER<br>50 CYCLES | FINAL TEST &<br>TO RESET 2.50# | COMMENTS                                                               |
|---------|------------------|--------------------------|--------------------------------|------------------------------------------------------------------------|
| PULL #1 | 2.51             | 2.48                     | 2.41                           | MIN. SETTING,<br>NO AVG. OF 5<br>READINGS ACCEPT-<br>ABLE LESS THAN 2# |
| PULL #2 | 2.52             | 2.40                     | 2.47                           |                                                                        |
| PULL #3 | 2.58             | 2.40                     | 2.46                           |                                                                        |
| PULL #4 | 2.59             | 2.46                     | 2.41                           |                                                                        |
| PULL #5 | 2.64             | 2.37                     | 2.47                           |                                                                        |
| TOTAL   | 12.84            | 12.11                    | 12.22                          |                                                                        |
| AVG.    | 2.56             | 2.42                     | 2.44                           |                                                                        |

|         | 3.00#<br>INITIAL | 3.00# AFTER<br>20 CYCLES | COMMENTS |
|---------|------------------|--------------------------|----------|
| PULL #1 | 3.06             | 2.97                     |          |
| PULL #2 | 3.00             | 2.98                     |          |
| PULL #3 | 3.02             | 3.01                     |          |
| PULL #4 | 3.08             | 2.91                     |          |
| PULL #5 | 3.07             | 3.03                     |          |
| TOTAL   | 15.23            | 14.90                    |          |
| AVG.    | 3.04             | 2.98                     |          |

|         | 4.00#<br>INITIAL | 4.00# AFTER<br>20 CYCLES | MAX SETTING<br>GREATER THAN 4# | RESET TO 4# FOR<br>TARGET & ACCURACY |
|---------|------------------|--------------------------|--------------------------------|--------------------------------------|
| PULL #1 | 4.15             | 4.00                     | 4.20                           |                                      |
| PULL #2 | 4.06             | 3.90                     | 4.15                           |                                      |
| PULL #3 | 4.07             | 3.94                     | 4.15                           |                                      |
| PULL #4 | 4.09             | 4.04                     | 4.20                           |                                      |
| PULL #5 | 4.07             | 4.02                     | 4.28                           |                                      |
| TOTAL   | 20.44            | 19.90                    | 20.98                          |                                      |
| AVG.    | 4.08             | 3.98                     | 4.19                           |                                      |

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6587577

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

| op. #        | OP. NAME                                                    | READINGS |      |      |      |      | DATE  | INIT |
|--------------|-------------------------------------------------------------|----------|------|------|------|------|-------|------|
| 625<br>cont. | F) Safety On Force                                          | 6        | 6    | 6    |      |      | 12/14 | WB   |
|              | G) Safety Off Force                                         | 3        | 3    | 3    |      |      | 12/14 | WB   |
|              | 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                                       |          |      |      |      |      |       |      |
|              | A) Time                                                     |          |      |      |      |      |       |      |
|              | B) Malfunctions                                             |          |      |      |      |      |       |      |
|              | C) Pierced Primers                                          |          |      |      |      |      |       |      |
|              | D) Optical Clarity of Scope                                 |          |      |      |      |      |       |      |
| 645          | Inspect for Live Ammo                                       |          |      |      |      |      |       |      |
| 655          | Final Inspection<br>A) Headspace                            |          |      |      |      |      |       |      |
|              | B) Trigger Pull                                             | 2.25     | 2.23 | 2.22 | 2.27 | 2.25 | 12/14 | WB   |
|              | C) Function                                                 |          |      |      |      |      |       |      |
| 660          | Pack                                                        |          |      |      |      |      |       |      |