

C6587601

MODEL 700TM M24

Model **SMS**TM

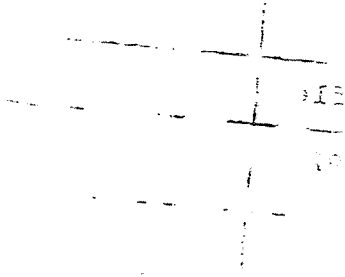
Action

Barrel Length

Capacity

Order No. **5716**

* Includes 1 in chamber.



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: **RE00089024** Serial: C6587601 Model M24 SWS Center Fire Caliber: 7.62 NATO Repairman: Status: Closed 12/6/2004 7:41:15 AM

Verify Repair

Address Information

Customer: ☒ Received From Return To: ☐ Received From

Name: **TRANSPORTATION OFFICER** **TRANSPORTATION OFFICER**

Address 1: **DEF DIST DEPOT ANNISTON AL** **DEF DIST DEPOT ANNISTON AL**

Address 2: PO Box: PO Box:

City: **ANNISTON** **ANNISTON**

State: **AL** Zip Code: **36201** Country: **US** State: **AL** Zip Code: **36201** Country: **US**

FPL: ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐

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
A006	Sling Strap	1
A007	With Stud	3
A010	Hard Case	1
A017	Scope Base	1
A026	Scope	1
A055	Deployment Kit	1
C000	FRT AND REAR SGT	1
C001	SCOPE CASE	1

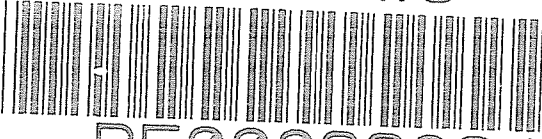
Repair Search Refresh Close

next 12/6/2004 8:52 AM CAPS NUM JNE SCRL

start 2 2 2 2

Serial Number: **C6587601**

Model: **M24 SWS**



RE00089024

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6587601.___0
FILE DATE AND TIME: 01/05/2005 11:28

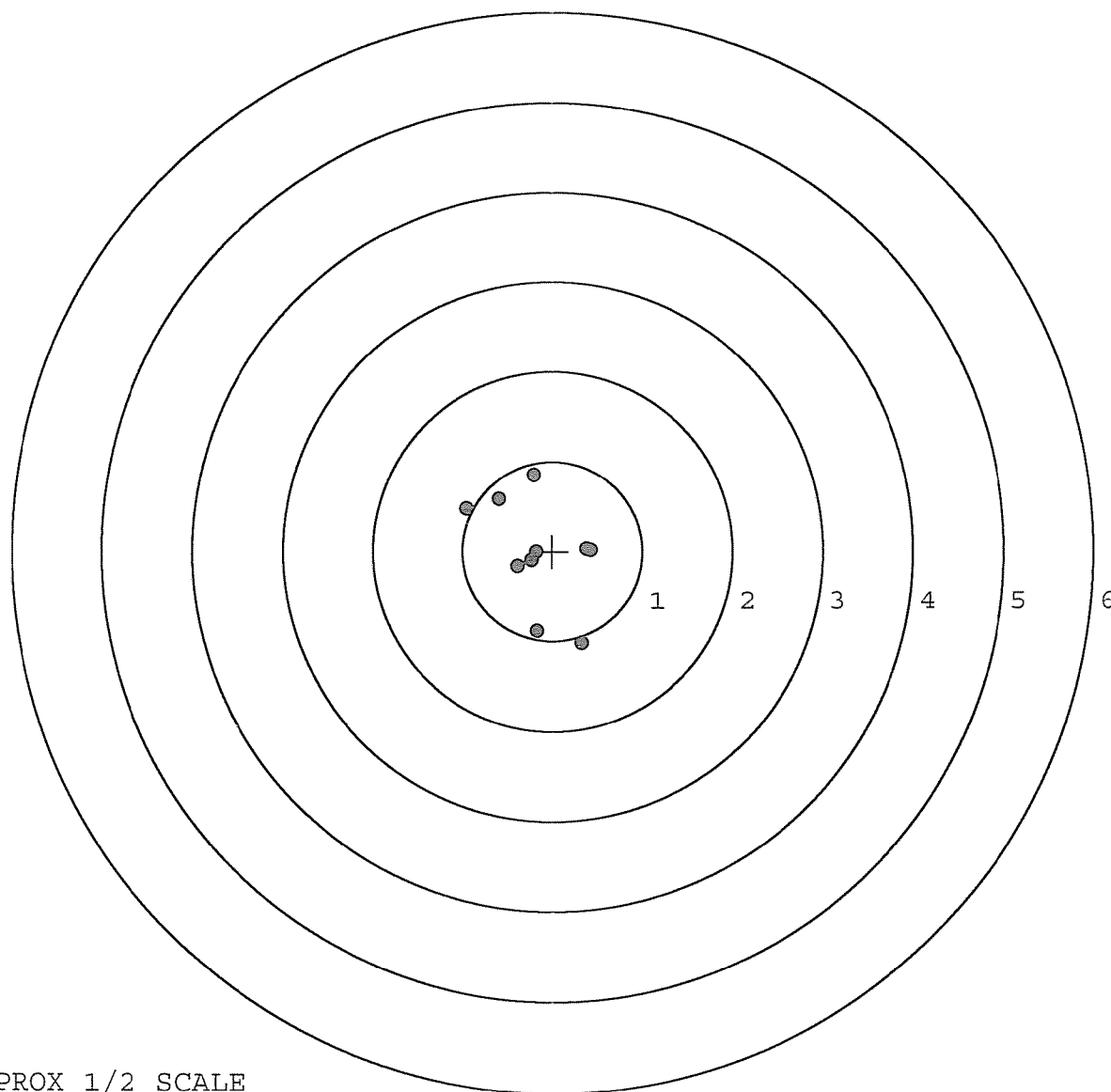
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.123
The Average Y Centroid of the Five Target Set:	-0.090
The Average Point of Impact of the Five Target Set:	0.153
The Average Mean Radius of the Five Target Set:	0.618
The Distance from POA to Centroid Target #1:	0.163
The Distance from Centroid Target #2 to Centroid Target #1:	0.021
The Distance from Centroid Target #3 to Centroid Target #1:	0.084
The Distance from Centroid Target #4 to Centroid Target #1:	0.203
The Distance from Centroid Target #5 to Centroid Target #1:	0.176

SERIAL NUMBER: C6587601. __0
TARGET NUMBER: 1
FILE DATE: 01/05/2005
FILE TIME: 11:28

X CENTROID: -0.161
Y CENTROID: -0.026
POA TO CENTROID: 0.163
HORZ SPREAD: 1.387
VERT SPREAD: 1.881
GROUP SPREAD: 1.985
MIN RADIUS: 0.028
MAX RADIUS: 1.120
MEAN RADIUS: 0.609
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.332	-1.032
2:	-0.177	-0.895
3:	0.430	0.014
4:	-0.213	0.849
5:	-0.595	0.583
6:	-0.957	0.478
7:	-0.388	-0.167
8:	-0.186	-0.013
9:	0.380	0.029
10:	-0.234	-0.104



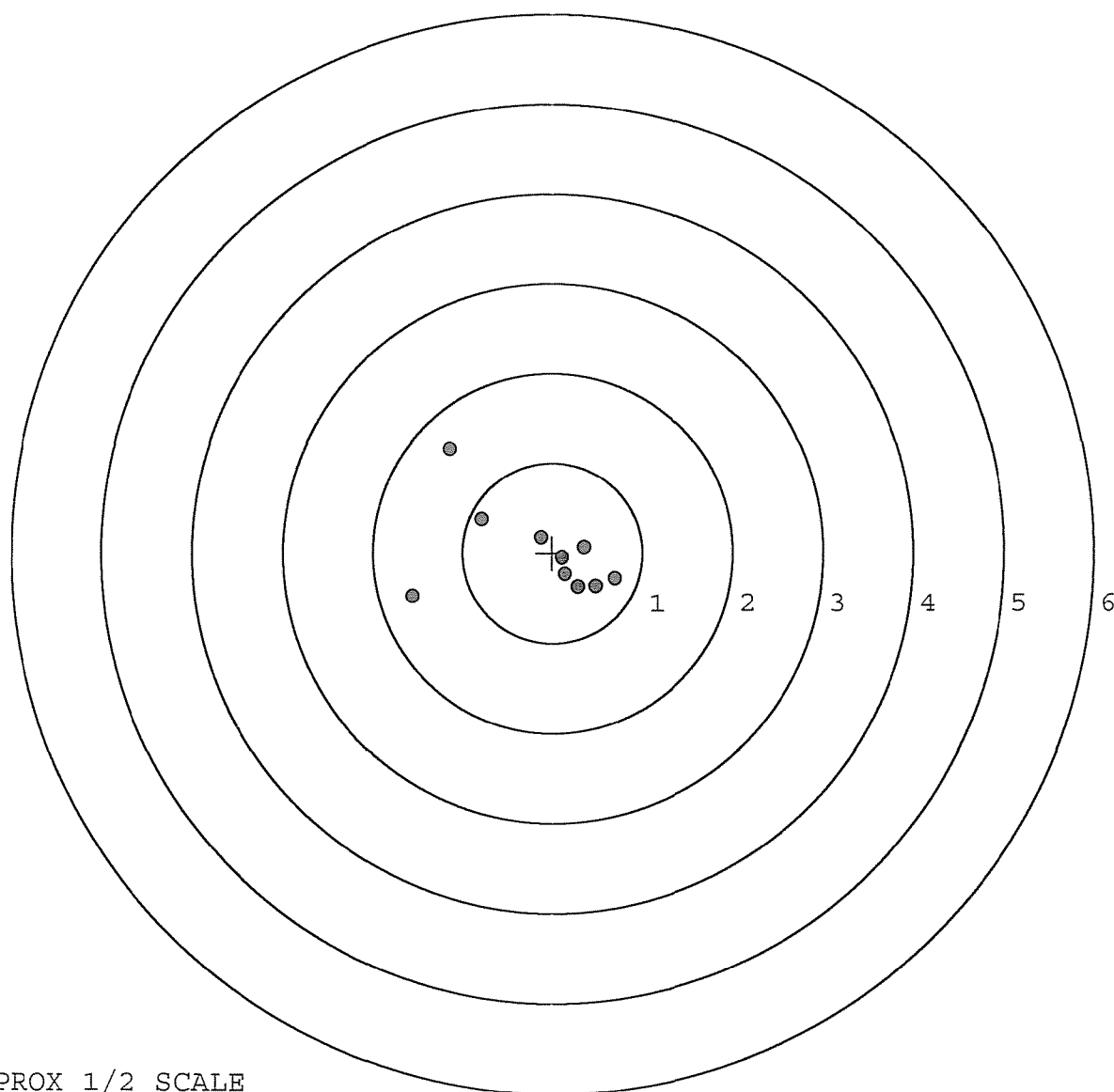
TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6587601. __0
TARGET NUMBER: 2
FILE DATE: 01/05/2005
FILE TIME: 11:28

X CENTROID: -0.155
Y CENTROID: -0.006
POA TO CENTROID: 0.155
HORZ SPREAD: 2.260
VERT SPREAD: 1.643
GROUP SPREAD: 2.337
MIN RADIUS: 0.177
MAX RADIUS: 1.525
MEAN RADIUS: 0.731

IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 9

POINT#	X	Y
1:	-0.793	0.370
2:	-1.564	-0.491
3:	-1.147	1.152
4:	-0.129	0.169
5:	0.356	0.064
6:	0.696	-0.285
7:	0.482	-0.368
8:	0.292	-0.377
9:	0.143	-0.236
10:	0.112	-0.056

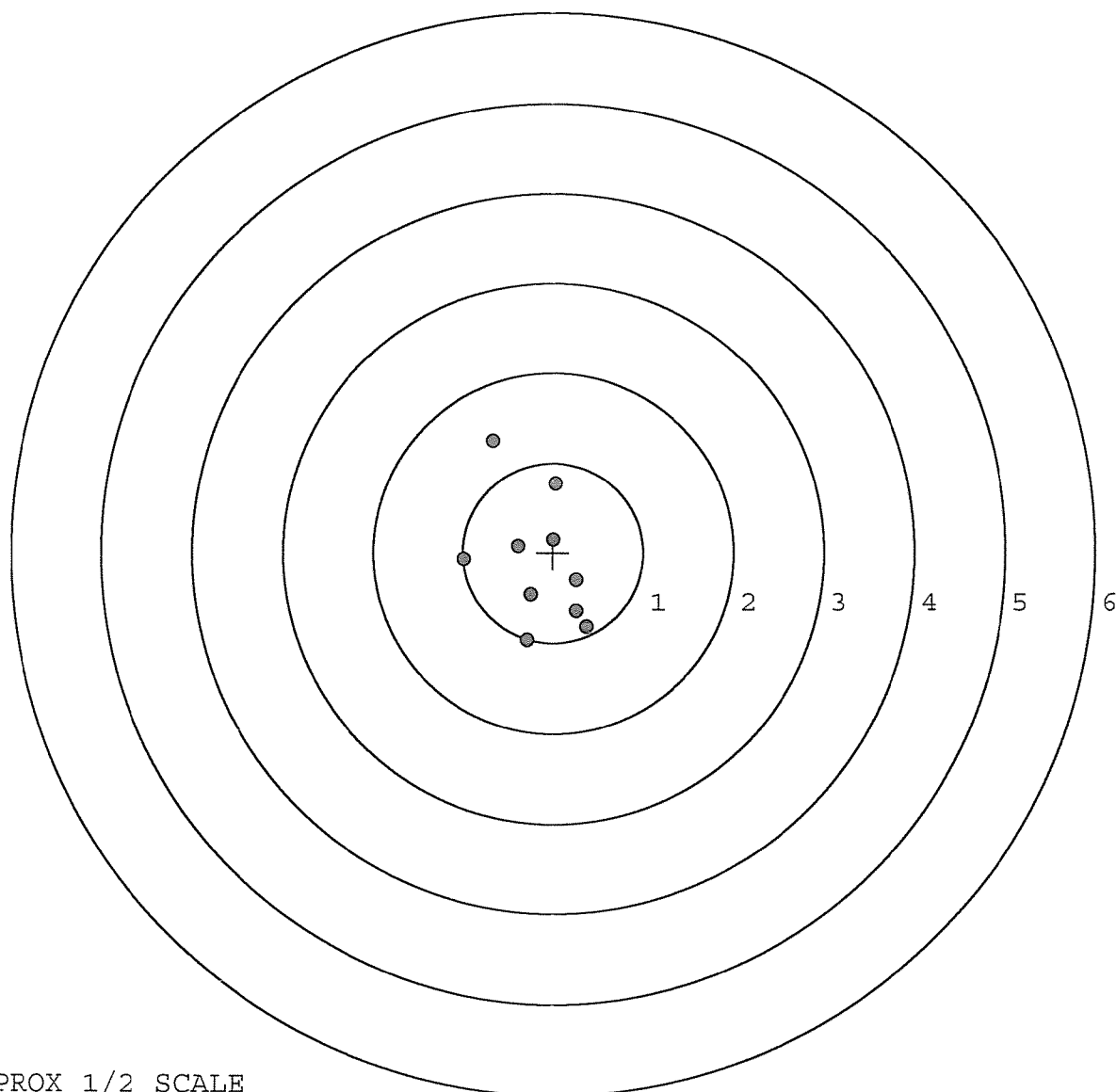


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6587601. __0
TARGET NUMBER: 3
FILE DATE: 01/05/2005
FILE TIME: 11:28

X CENTROID: -0.165
Y CENTROID: -0.109
POA TO CENTROID: 0.198
HORZ SPREAD: 1.368
VERT SPREAD: 2.221
GROUP SPREAD: 2.327
MIN RADIUS: 0.288
MAX RADIUS: 1.445
MEAN RADIUS: 0.708
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.378	-0.833
2:	0.266	-0.655
3:	0.260	-0.310
4:	-0.248	-0.471
5:	-0.289	-0.975
6:	-0.990	-0.084
7:	-0.667	1.246
8:	0.032	0.770
9:	-0.006	0.146
10:	-0.388	0.073

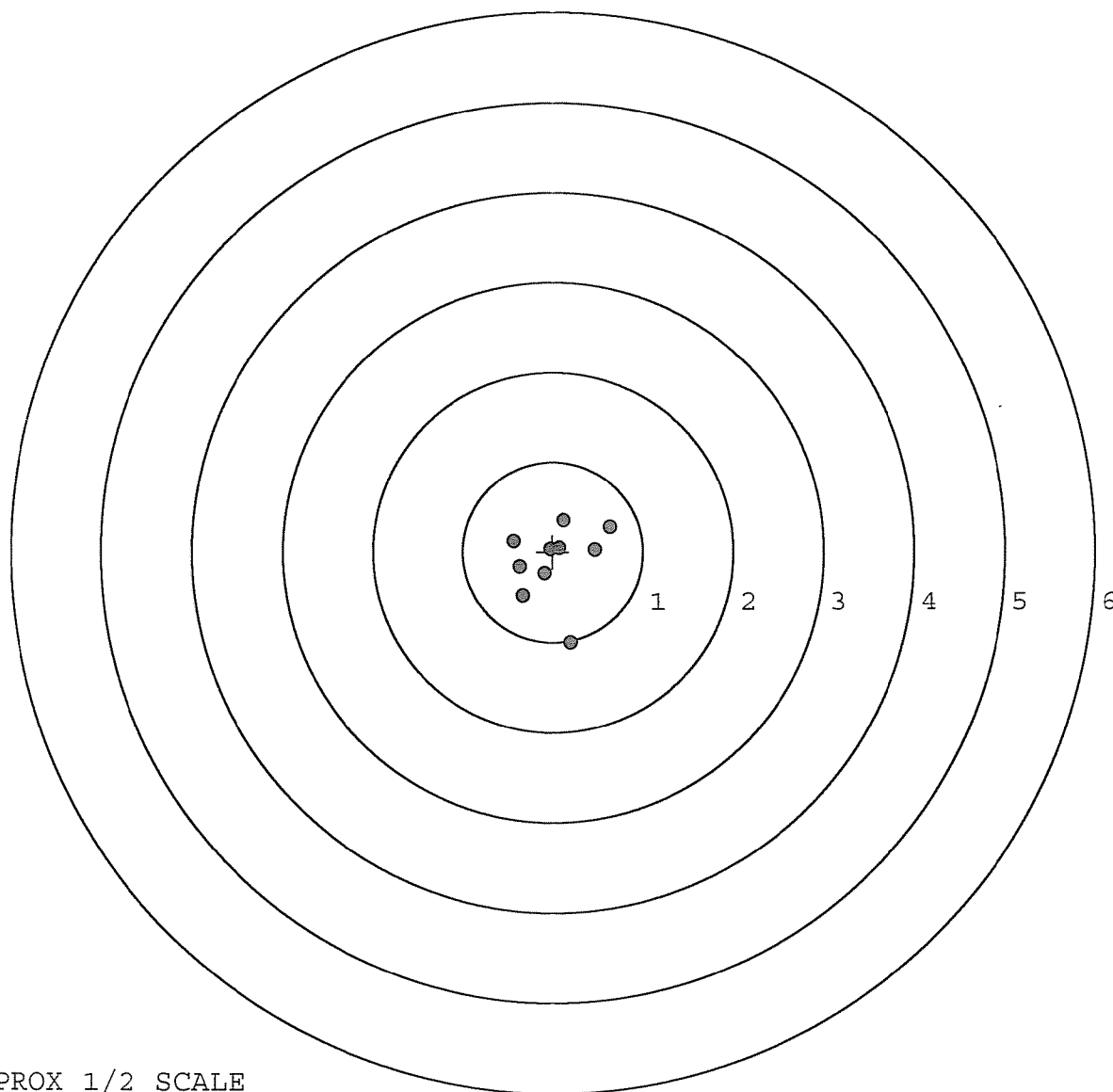


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6587601. __ 0
TARGET NUMBER: 4
FILE DATE: 01/05/2005
FILE TIME: 11:28

POINT#	X	Y
1:	0.205	-1.010
2:	0.637	0.277
3:	0.473	0.022
4:	0.121	0.352
5:	0.080	0.041
6:	-0.439	0.114
7:	-0.368	-0.168
8:	-0.336	-0.491
9:	-0.094	-0.245
10:	-0.029	0.031

X CENTROID: 0.025
Y CENTROID: -0.108
POA TO CENTROID: 0.111
HORZ SPREAD: 1.076
VERT SPREAD: 1.362
GROUP SPREAD: 1.365
MIN RADIUS: 0.149
MAX RADIUS: 0.920
MEAN RADIUS: 0.451
IN 1 IN DIAMETER: 6
IN 2 IN DIAMETER: 10
in 3 IN DIAMETER: 10



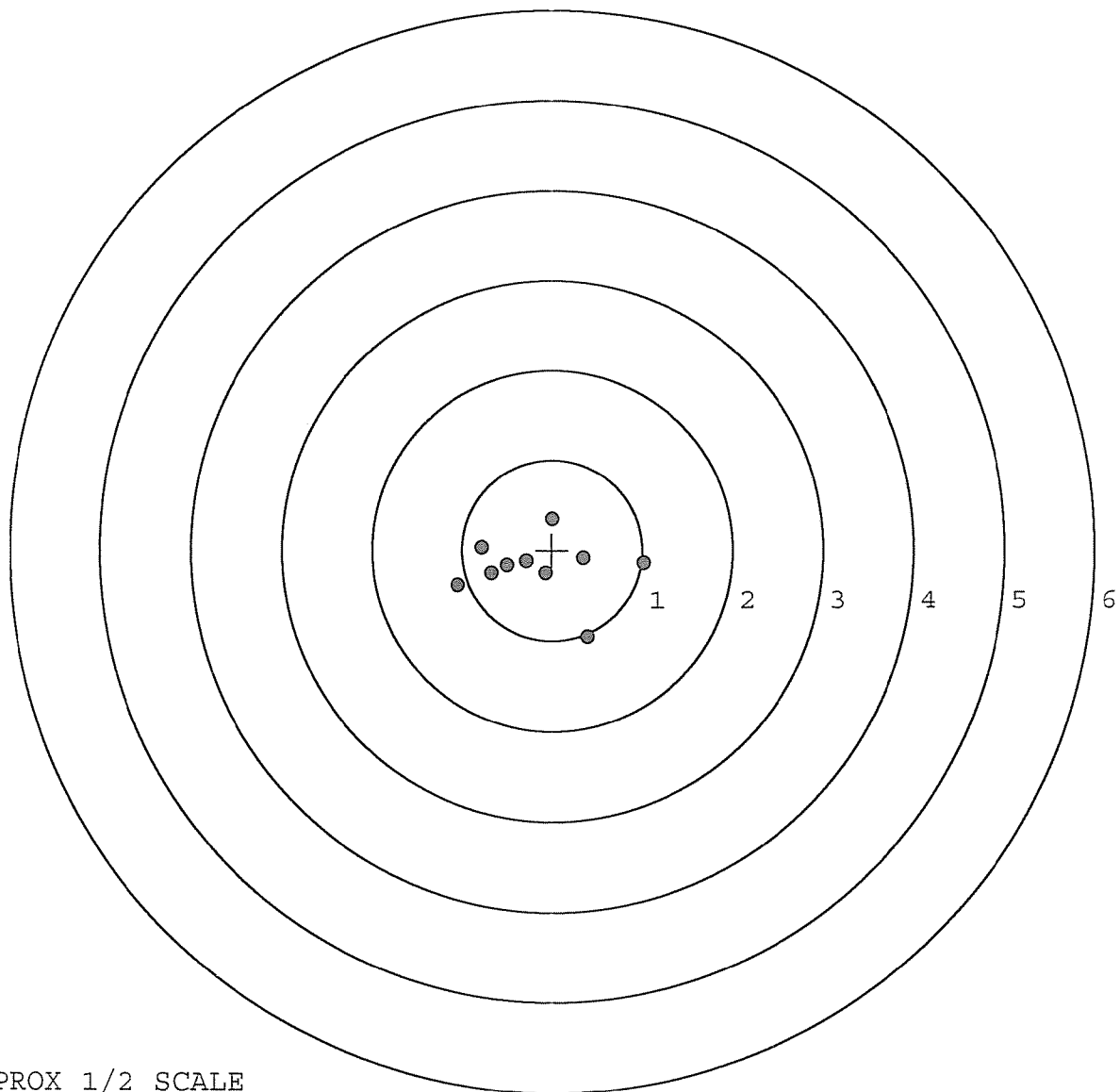
TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6587601. __0
TARGET NUMBER: 5
FILE DATE: 01/05/2005
FILE TIME: 11:28

POINT#	X	Y
1:	0.399	-0.965
2:	1.017	-0.141
3:	0.347	-0.088
4:	0.004	0.344
5:	-0.785	0.032
6:	-1.050	-0.387
7:	-0.674	-0.257
8:	-0.501	-0.170
9:	-0.080	-0.259
10:	-0.289	-0.124

X CENTROID: -0.161
Y CENTROID: -0.202
POA TO CENTROID: 0.258
HORZ SPREAD: 2.067
VERT SPREAD: 1.309
GROUP SPREAD: 2.082
MIN RADIUS: 0.099
MAX RADIUS: 1.180
MEAN RADIUS: 0.590

IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

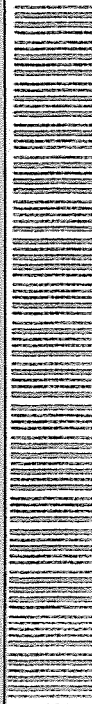


TARGET APPROX 1/2 SCALE

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

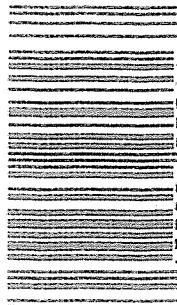
R & E NUMBER	89024		
SERIAL NUMBER	06587601		
LOG-IN DATE	12-6-04		
INSPECT AND VERIFY:			
OPERATION #	OPERATION NAME	DATE	INITIAL
550	DIS-ASSEMBLE GUN	12-7-04	RTL
560 A	RE-BARREL	12-15-04	RTL
B	DRILL AND TAP	12-27-04	TRL
575	ASSEMBLE	12-16-04	RTL
600	PROOF	12-16-04	RTL
605	CHECK HEADSPACE	12-16-04	RTL
610	DIS-ASSEMBLE GUN	12-27-04	RTL
612	MAGNAFLUX	OPERATOR	
615	ROLLMARK CALIBER	12-27-04	CW
618	ROTO-BLAST	12/28/04	DG
620	APPLY COATINGS	1/3/05	HP
625 A	FINAL ASSEMBLY	1-5-05	RTL
B	TRIGGER PULL TEST	N/A	
C	SAFETY "ON" FORCE		
D	SAFETY "OFF" FORCE		
E	FIRING PIN INDENT		
640	TARGET	1-5-05	TRL
655	FINAL INSPECT	1-11-05	AC
660	PACK	3-1-05	RA
		SHIP DATE	
		QAR INSPECTION DATE	

Remington [®]		DUPONT REG. U.S. PAT. & TM. OFF.	VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.
MODEL 700 [™] H24			SERIAL NO. C6587601
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.			ORDER NO. 5716



5716 C6587601

UPC



0 47700 25716

7

INTERCHANGEABILITY

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C 6587601

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		10/22/90	KS
600	Proof		10/22/90	KS
607	Check Headspace		10/22/90	KS
610	Dis-assemble Gun		10/22/90	KS
612	Magnaflux Barrel Action		10/24/90	KR
	Magnaflux Bolt		10/24/90	KR
615	Rollmark Caliber		10/24/90	KS
617	Drill and Tap Sight Holes		10/25/90	KS
618	Polish Barrel <i>KS</i>		10/26/90	KS
620	Apply Coatings (Barrel Action)		11-7-90	KS
	Apply Coating (Bolt)			
625	Final Assembly		11/8/90	KS
	A) Clean inside of Bolt Assembly		11/8/90	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		11/8/90	KS
	C) Inspect Ejector Hole for Chamfer		11/8/90	KS
	D) Oil Firing Pin Ass'y		11/8/90	KS
	E) Adjust Trigger Pull to Min Setting and Stake		11-14-90	KS

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5 1/4	5 1/4	5 1/2			11/14/90	WB
	G) Safety Off Force	2 1/2	2 1/2	2 1/2			11/14/90	WB
	H) Trigger Pull Test & Retainability						11-14-90	DH
	I) Firing Pin Indent	.024	.023	.0235			11/14/90	WB
	J) Assemble Stock						11/14/90	KS
	K) Assemble Swivel Studs						11-19-90	DH
	L) Attach Front and Rear Sight Assemblies						11/14/90	KS
	M) Iron Sight Alignment						11/14/90	KS
	N) Detach Front & Rear Sights & place in numbered container						11/14/90	KS
	O) Attach Scope to Rifle						11/14/90	KS
	P) Detach & Attach Scope 20 Times						11/14/90	KS
640	Gallery Target & Test						11-15-90	DH
	A) Time						11-15-90	DH
	B) Malfunctions						11-15-90	DH
	C) Pierced Primers						11-15-90	DH
	D) Optical Clarity of Scope						11-15-90	DH
645	Inspect for Live Ammo						11-15-90	DH
655	Final Inspection							
	A) Headspace						11-19-90	DH
	B) Trigger Pull	2.30	2.29	2.39	2.32	2.31	11-19-90	DH
	C) Function						11-19-90	DH
660	Pack						12-19-90	DH

SWS TRIGGER PULL TEST

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

SERIAL NO. C 6587601
DATE 11-14-90
TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.25	2.32	2.30	2.41	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.23	2.28	2.29	2.38	
PULL #3	2.23	2.33	2.39	2.42	
PULL #4	2.25	2.31	2.32	2.38	
PULL #5	2.35	2.33	2.31	2.28	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.43	3.29		
PULL #2	3.36	3.26		
PULL #3	3.38	3.34		
PULL #4	3.33	3.33		
PULL #5	3.28	3.25		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.25	4.26		4.16
PULL #2	4.24	4.28		4.18
PULL #3	4.26	4.26		4.17
PULL #4	4.25	4.25		4.18
PULL #5	4.18	4.20		4.19
TOTAL				
AVG.				

INTERCHANGEABILITY

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6587601
12 Dec 1990

CENTROIDAL DISTANCES

0 TO	1	.0470106
1 TO	2	.179067
1 TO	3	.0750067
1 TO	4	.300416
1 TO	5	.247588

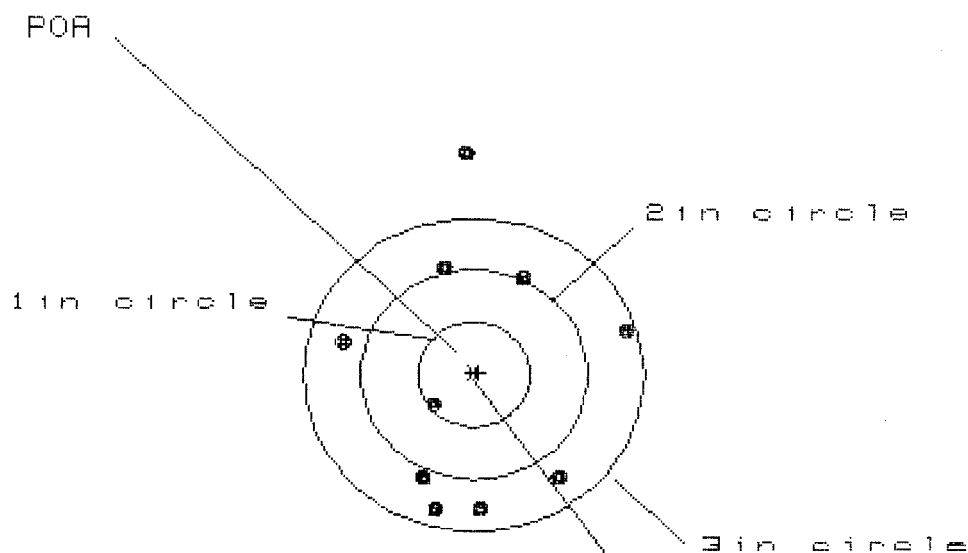
24 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0082
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1164
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .116688
THE AMR FOR THIS RIFLE IS: 1.059

12 Dec 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C8587681

CENTERFIRE PATTERNS # 1



OF SHOTS - 10

IN CIR

1 in - 0

2 in - 1

3 in - 9

HS - 2.499

VS - 3.459

GS - 3.478

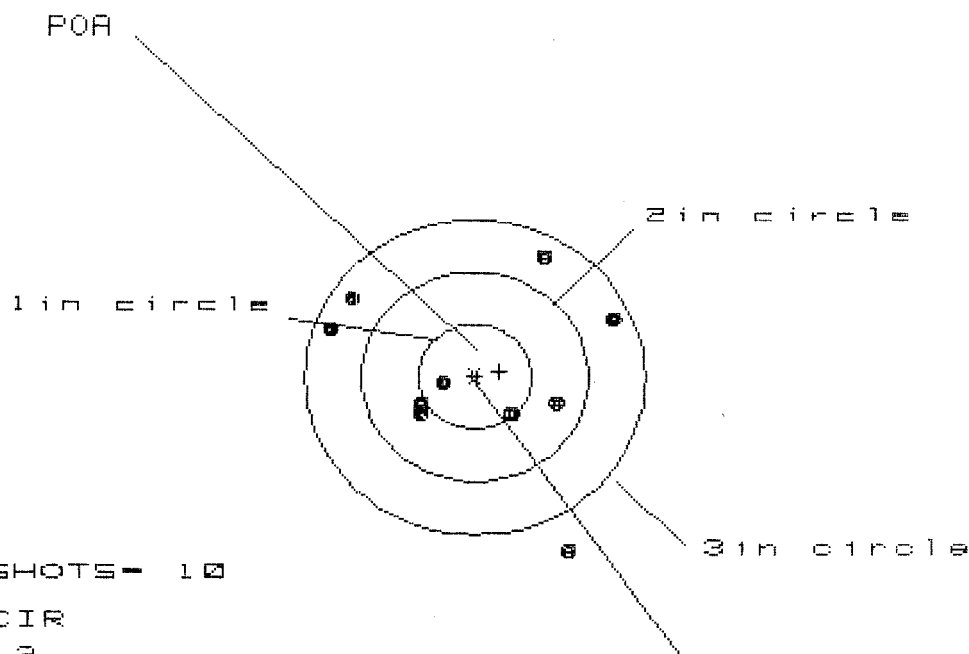
CENTROID *

PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.390	1.389	.870
MINIMUM X	:	-1.109	-1.110	-.936
MAXIMUM Y	:	2.147	1.288	1.365
MINIMUM Y	:	-1.312	-1.073	-.996
CENTROID X	:	-.043	-.042	-.216
CENTROID Y	:	-.019	-.258	-.335
POR TO CENTROID in.	:	.047	.261	.399
MIN RADIUS	:	.513	.407	.225
MEAN RADIUS	:	1.233	1.094	.998
MAX RADIUS	:	2.147	1.521	1.412
HORIZONTAL SPREAD	:	2.499	2.499	1.806
VERTICAL SPREAD	:	3.459	2.361	2.361
EXTREME SPREAD	:	3.478	2.499	2.408
NUMBER IN ONE INCH CIRCLE	=	0		
NUMBER IN TWO INCH CIRCLE	=	1		
NUMBER IN THREE INCH CIRCLE	=	9		

12 Dec 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6587601

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 5

3 in = 8

HS= 2.558

VS= 2.764

GS= 3.096

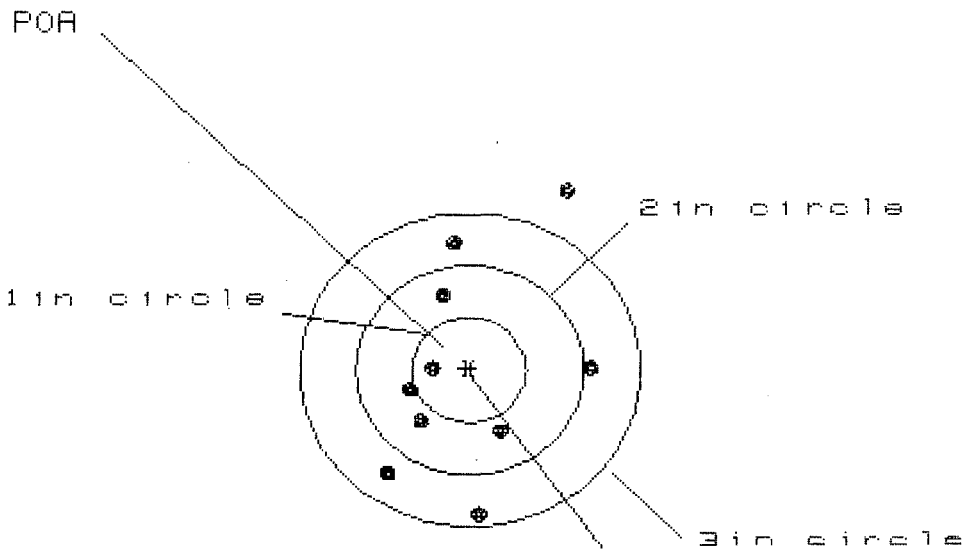
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.259	1.348	.985
MINIMUM X	:	-1.299	-1.210	-1.042
MAXIMUM Y	:	1.103	.919	.970
MINIMUM Y	:	-1.661	-.561	-.510
CENTROID X	:	-.219	-.308	-.476
CENTROID Y	:	-.052	.132	.081
POA TO CENTROID in.	:	.225	.335	.483
MIN RADIUS	:	.280	.291	.172
MEAN RADIUS	:	1.001	.916	.816
MAX RADIUS	:	1.843	1.409	1.323
HORIZONTAL SPREAD	:	2.558	2.558	2.027
VERTICAL SPREAD	:	2.764	1.480	1.480
EXTREME SPREAD	:	3.096	2.561	2.142
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

12 Dec 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6587601

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 9

HS= 1.805

VS= 3.048

GS= 3.142

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.093	1.187	1.208
MINIMUM X	:	-.712	-.618	-.597
MAXIMUM Y	:	1.674	1.397	1.249
MINIMUM Y	:	-1.374	-1.188	-.911
CENTROID X	:	.032	-.062	-.083
CENTROID Y	:	-.018	-.204	-.056
POA TO CENTROID in.	:	.037	.213	.100
MIN RADIUS	:	.286	.263	.174
MEAN RADIUS	:	.964	.819	.767
MAX RADIUS	:	1.874	1.397	1.249
HORIZONTAL SPREAD	:	1.805	1.805	1.805
VERTICAL SPREAD	:	3.048	2.585	2.160
EXTREME SPREAD	:	3.142	2.591	2.247
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

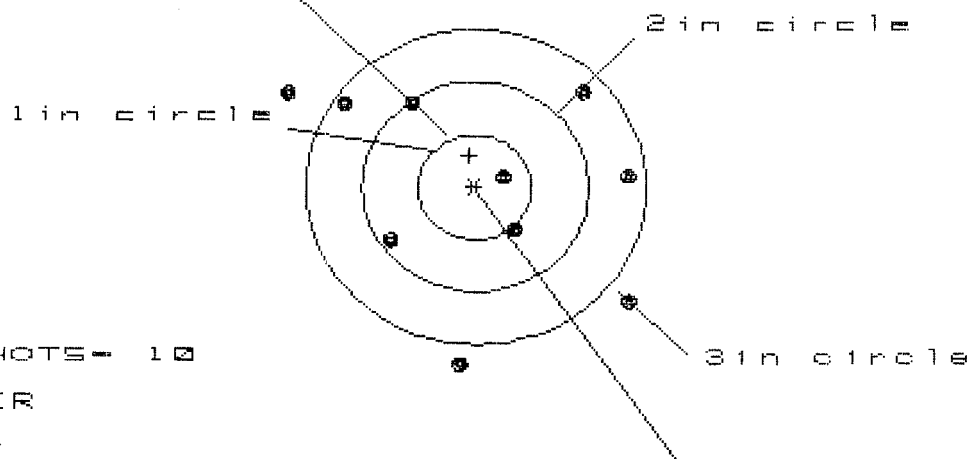
12 Dec 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6587681

CENTERFIRE PATTERNS

4

POA



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 4

3 in = 7

HS= 2.949

VS= 2.588

GS= 3.545

CENTROID *

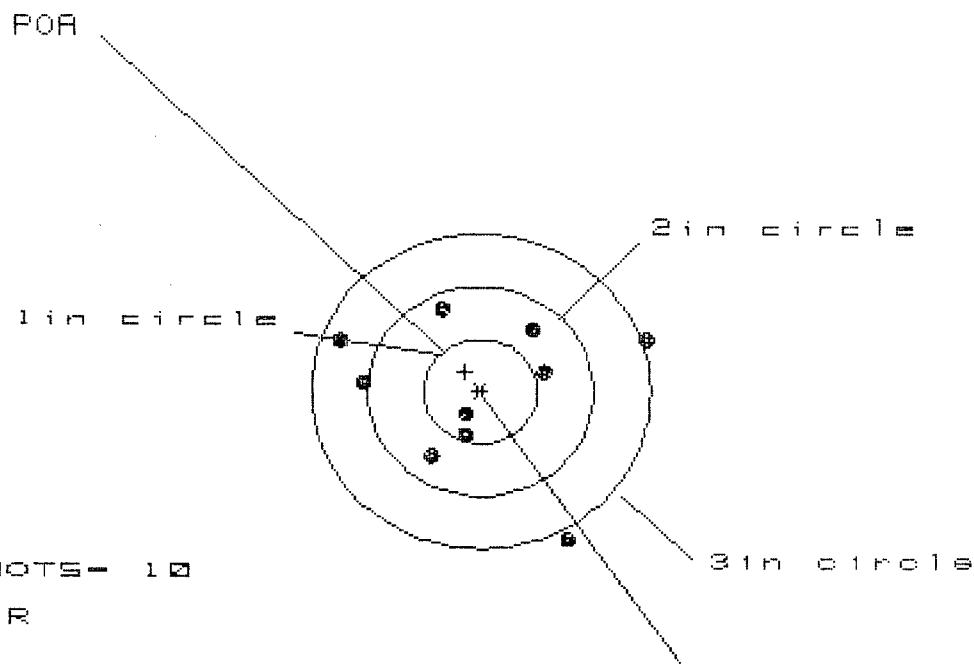
PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.347	1.169	1.298
MINIMUM X	:	-1.602	-1.293	-1.147
MAXIMUM Y	:	.901	.959	.838
MINIMUM Y	:	-1.687	-1.587	-1.708
CENTROID X	:	.052	.230	.084
CENTROID Y	:	-.304	-.404	-.283
POA TO CENTROID in.	:	.308	.465	.296
MIN RADIUS	:	.254	.250	.216
MEAN RADIUS	:	1.185	1.094	1.032
MAX RADIUS	:	1.838	1.618	1.716
HORIZONTAL SPREAD	:	2.949	2.462	2.445
VERTICAL SPREAD	:	2.588	2.546	2.546
EXTREME SPREAD	:	3.545	3.107	2.756
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		7	

12 Dec 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6587681

CENTERFIRE PATTERNS

5



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 6

3 in = 8

HS= 2.699

VS= 2.175

GS= 2.699

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.508	1.594	.804
MINIMUM X	:	-1.191	-1.105	-.906
MAXIMUM Y	:	.800	.647	.685
MINIMUM Y	:	-1.375	-.744	-.706
CENTROID X	:	.137	.051	-.148
CENTROID Y	:	-.189	-.036	-.074
POA TO CENTROID in.	:	.233	.062	.166
MIN RADIUS	:	.256	.385	.389
MEAN RADIUS	:	.911	.838	.724
MAX RADIUS	:	1.579	1.623	.966
HORIZONTAL SPREAD	:	2.699	2.699	1.710
VERTICAL SPREAD	:	2.175	1.391	1.391
EXTREME SPREAD	:	2.699	2.699	1.727
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6587601
16 Nov 1990

CENTROIDAL DISTANCES

0 TO 1	.153379
1 TO 2	.157407
1 TO 3	.173971
1 TO 4	.326173
1 TO 5	.0394462

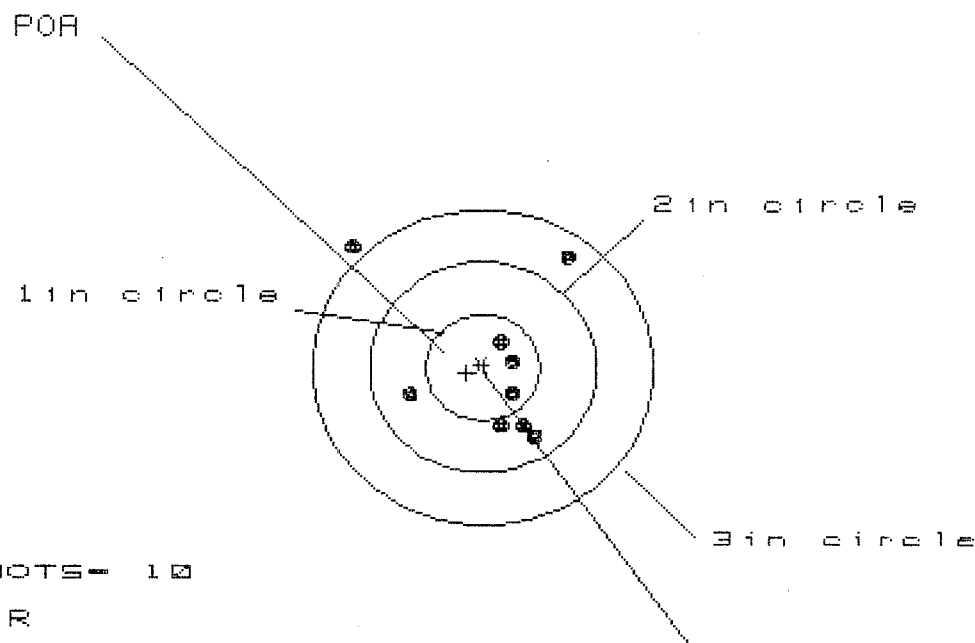
42 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1078
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1004
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .147313
THE AMR FOR THIS RIFLE IS: .9354

16 Nov 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6587601

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in - 3

2in - 8

3in - 9

HS- 1.910

VS- 1.821

GS- 2.448

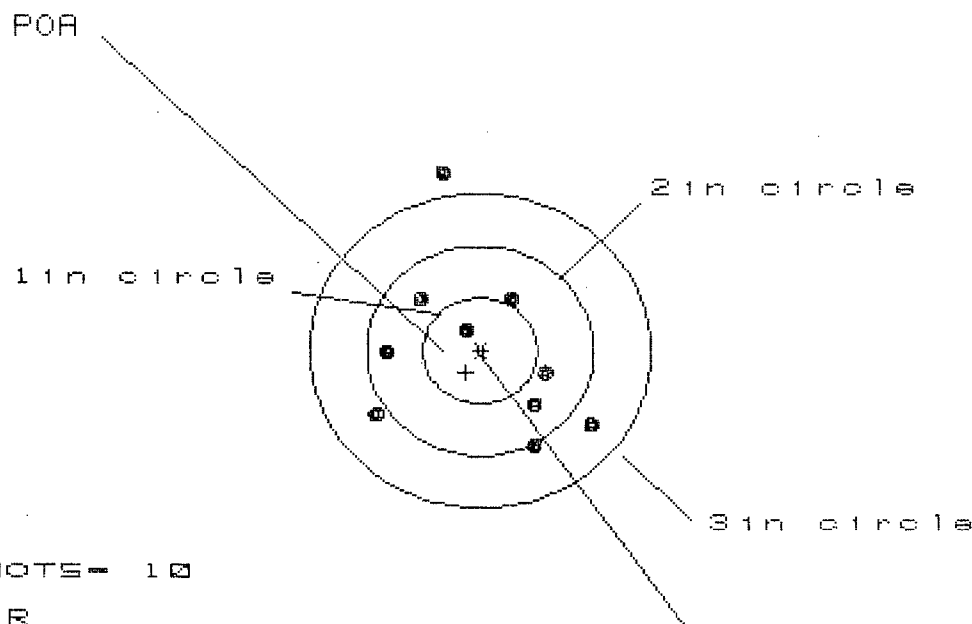
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.766	.639	.445
MINIMUM X	-1.143	-.796	-.716
MAXIMUM Y	1.183	1.228	.504
MINIMUM Y	-.638	-.507	-.353
CENTROID X	.145	.272	.192
CENTROID Y	.050	-.081	-.235
POA TO CENTROID in.	.153	.283	.303
MIN RADIUS	.220	.185	.214
MEAN RADIUS	.735	.587	.480
MAX RADIUS	1.645	1.385	.716
HORIZONTAL SPREAD	1.910	1.435	1.161
VERTICAL SPREAD	1.821	1.735	.857
EXTREME SPREAD	2.448	1.976	1.220
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	8		
NUMBER IN THREE INCH CIRCLE =	9		

16 May 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6587601

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 1

2in = 7

3in = 9

HS= 1.973

VS= 2.593

GS= 2.773

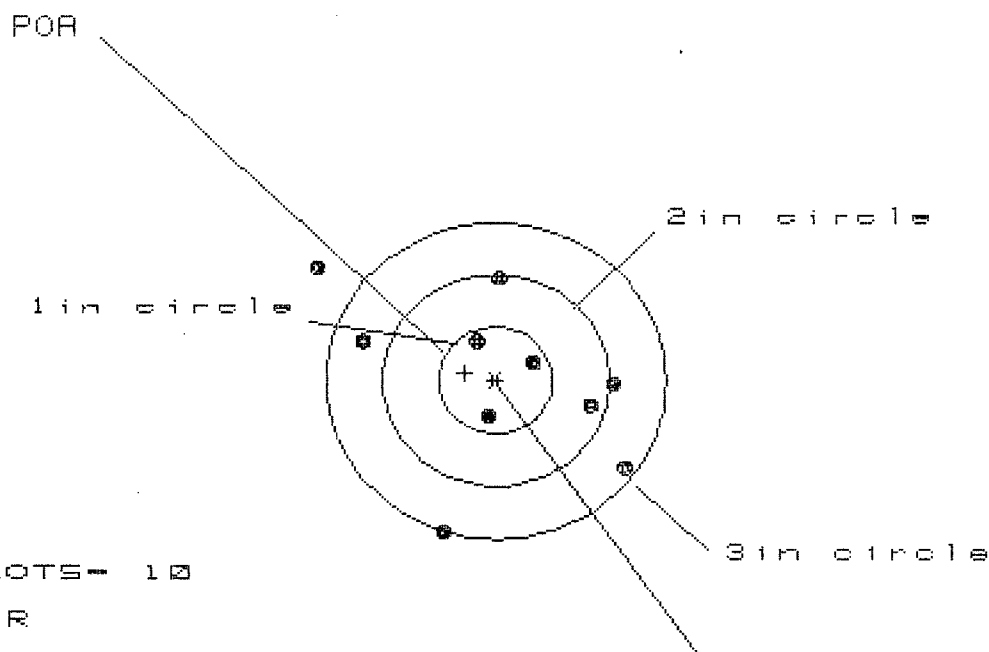
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.000	.959	.692
MINIMUM X	:	-.973	-1.014	-.894
MAXIMUM Y	:	1.729	.726	.665
MINIMUM Y	:	-.864	-.672	-.733
CENTROID X	:	.124	.165	.045
CENTROID Y	:	.206	.014	.075
POA TO CENTROID in.	:	.240	.165	.088
MIN RADIUS	:	.267	.456	.360
MEAN RADIUS	:	.889	.787	.744
MAX RADIUS	:	1.768	1.106	1.026
HORIZONTAL SPREAD	:	1.973	1.973	1.586
VERTICAL SPREAD	:	2.593	1.398	1.398
EXTREME SPREAD	:	2.773	1.974	1.687
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

16 Nov 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6587681

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 3

2in = 5

3in = 9

HS= 2.735

VS= 2.506

GS= 3.367

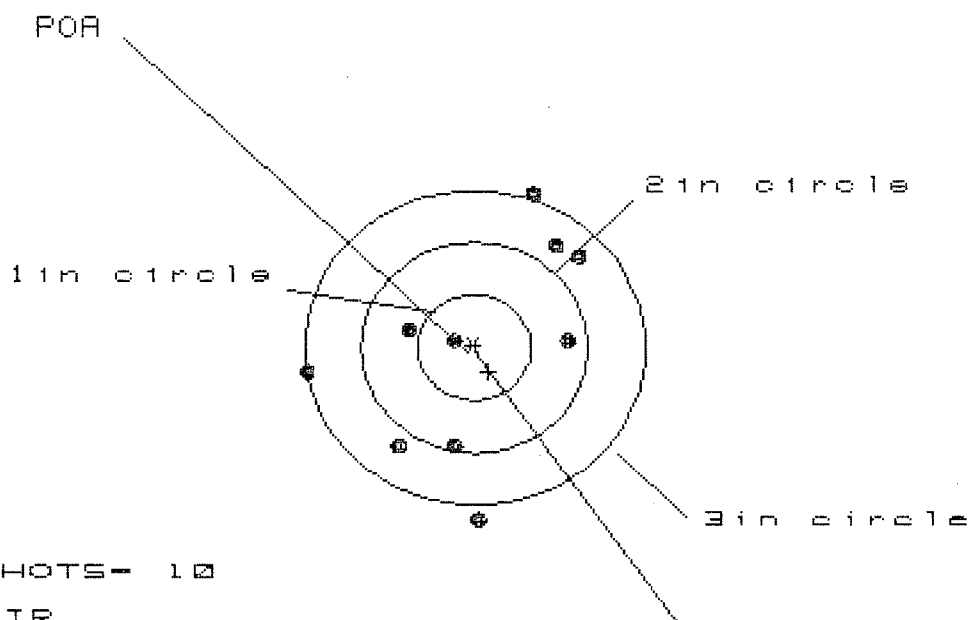
CENTROID *

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.158	.983	.908
MINIMUM X	:	-1.577	-1.306	-1.381
MAXIMUM Y	:	1.101	1.072	.911
MINIMUM Y	:	-1.405	-1.282	-.900
CENTROID X	:	.270	.445	.520
CENTROID Y	:	-.071	-.194	-.033
POA TO CENTROID in.	:	.279	.486	.521
MIN RADIUS	:	.353	.295	.121
MEAN RADIUS	:	.994	.871	.773
MAX RADIUS	:	1.923	1.415	1.414
HORIZONTAL SPREAD	:	2.735	2.289	2.289
VERTICAL SPREAD	:	2.506	2.354	1.811
EXTREME SPREAD	:	3.367	2.585	2.585
NUMBER IN ONE INCH CIRCLE =			3	
NUMBER IN TWO INCH CIRCLE =			5	
NUMBER IN THREE INCH CIRCLE =			9	

16 Nov 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C8587681

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1 in - 1

2 in - 4

3 in - 5

HS- 2.445

VS= 3.147

GS= 3.195

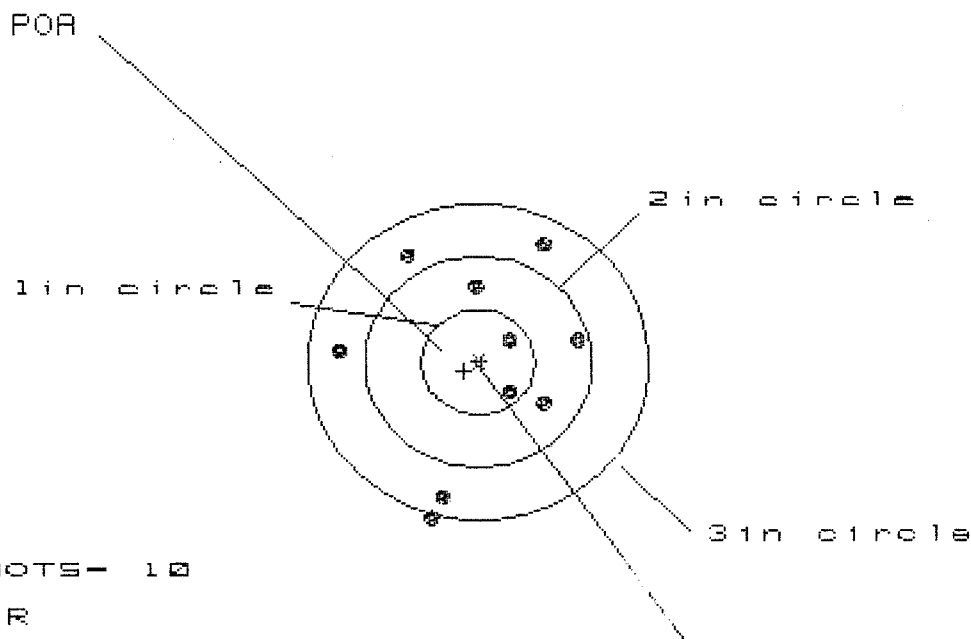
CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.962	.963	1.034
MINIMUM X	:	-1.484	-1.482	-1.411
MAXIMUM Y	:	1.497	1.313	.971
MINIMUM Y	:	-1.650	-1.112	-.947
CENTROID X	:	-.125	-.126	-.197
CENTROID Y	:	.233	.417	.252
POA TO CENTROID in.	:	.264	.435	.320
MIN RADIUS	:	.174	.177	.103
MEAN RADIUS	:	1.091	1.020	.947
MAX RADIUS	:	1.650	1.532	1.429
HORIZONTAL SPREAD	:	2.445	2.445	2.445
VERTICAL SPREAD	:	3.147	2.425	1.918
EXTREME SPREAD	:	3.195	2.715	2.671
NUMBER IN ONE INCH CIRCLE =			1	
NUMBER IN TWO INCH CIRCLE =			4	
NUMBER IN THREE INCH CIRCLE =			5	

16 Nov 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6587601

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 5

3 in = 3

HS= 2.113

VS= 2.560

GS= 2.764

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.894	.842	.792
MINIMUM X	:	-1.219	-1.271	-1.321
MAXIMUM Y	:	1.068	.902	.724
MINIMUM Y	:	-1.492	-1.430	-.751
CENTROID X	:	.125	.177	.227
CENTROID Y	:	.084	.250	.428
POA TO CENTROID in.	:	.151	.306	.485
MIN RADIUS	:	.339	.237	.251
MEAN RADIUS	:	.968	.875	.779
MAX RADIUS	:	1.563	1.484	1.343
HORIZONTAL SPREAD	:	2.113	2.113	2.113
VERTICAL SPREAD	:	2.560	2.332	1.475
EXTREME SPREAD	:	2.764	2.507	2.118
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

SWS TRIGGER PULL TEST

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

SERIAL NO. C6587601
DATE 10-18-95
TESTER DA

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.58	2.63	2.64		MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.67	2.60	2.64		
PULL #3	2.54	2.58	2.61		
PULL #4	2.50	2.60	2.66		
PULL #5	2.46	2.57	2.55		
TOTAL	12.75	12.98	13.10		
AVG.	2.55	2.59	2.62		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.10	3.23		
PULL #2	3.31	3.20		
PULL #3	3.21	3.19		
PULL #4	3.24	3.00		
PULL #5	3.24	3.10		
TOTAL	16.10 15.72	15.72		
AVG.	3.22	3.14		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.30	4.00	4.18	
PULL #2	4.10	4.09	4.19	
PULL #3	4.09	4.10	4.09	
PULL #4	4.08	4.06	4.28	
PULL #5	4.20	4.07	4.21	
TOTAL	20.77	20.32	20.95	
AVG.	4.15	4.06	4.19	

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6587601

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	5	5	5			11/27	WB
	G) Safety Off Force	3 1/2	4	3 3/4			11/27	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							
	A) Headspace							
	B) Trigger Pull	2.52	2.53	2.57	2.60	2.59	11/27	WB
	C) Function							
660	Pack							