C6587645

MODEL 700™ M24

Model SWS™

Action

Barrel Length

Capacity

Order No. 5716

*Includes 1 in chamber.

Remington

04/24/08 12:26:14

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: RE00144839
Verify Repair

Serial: C6587645 Model M24 SWS Center Fire
Caliber: 7.62 NATO

Repairman:
Status: Closed 4/24/2008 10:56:21 AM

Address Information

Customer:	Received From	Return To:	Received From
Name:	B/210TH BSB	B/210TH BSB	
Address 1:	2 BCT	2 BCT	
Address 2:	10 TH MTN DIV PO Box:	10 TH MTN DIV PO Box:	
City:	FORT DRUM	FORT DRUM	
State:	NY Zip Code: 13602 Country: US	State: NY Zip Code: 13602 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
A008	With Swivel	2
A010	Hard Case	1
A026	Scope	1
A057	Frt and Rear Sgt Base	1

naglelj 4/24/2008 12:26 PM NUM

Start | 4 Micros... | The Asso... | 2 Micros... | SSP Logo... | Arms Ser...

Serial Number: C6587645
Model: M24 SWS
RE00144839

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

R & E NUMBER 144839
SERIAL NUMBER C6587645
LOG-IN DATE 4-24-08

OPERATION #	OPERATION NAME		DATE	INITIAL
500	DIS-ASSEMBLE GUN		5-5-08	RTZ
505	RE-BARREL		5-6-08	RTZ
560	ASSEMBLE		5-6-08	RTZ
600	PROOF	MAGNA - FLUX	5-7-08	TRW
605	CHECK HEADSPACE	2008	5-7-08	TRW
610	DIS-ASSEMBLE GUN		5-7-08	RTZ
612	MAGNAFLUX	OPERATOR	5/9/08	
510	DRILL AND TAP		5-7-08	TRW
615	ROLLMARK CALIBER		5-7-08	CW
618	ROTO-BLAST		5-9-08	DG
620	APPLY COATINGS		5/19/08	
625	FINAL ASSEMBLY		5-22-08	RTZ
640	FUNCTION TEST AND	(PASS) FAIL	5-22-08	SD
650	TARGET	(PASS) FAIL	5-22-08	SD
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION N/A		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION	5-22-08	RP
670	FINAL INSPECTION		5/27/08	FM
	A) HEADSPACE	(PASS) FAIL	5/27/08	FM
	B) TRIGGER PULL (+/- .5 LBS, MIN 2.50 LBS, MAX 4.0 LBS)	2.52 2.36 2.28 2.32 2.37	5/27/08	FM
680	F) SAFETY ON FORCE (2 LBS MIN, 10 LBS MAX)	4 4 4	5/27/08	FM
	G) SAFETY OFF FORCE (2 LBS MIN)	3 3 3	5/27/08	FM
	I) FIRING PIN INDENT .020	.021 .021 .021	5/27/08	FM
690	PACK		5/29/08	FM

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFOMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6587645.__0
FILE DATE AND TIME: 05/23/2008 05:31

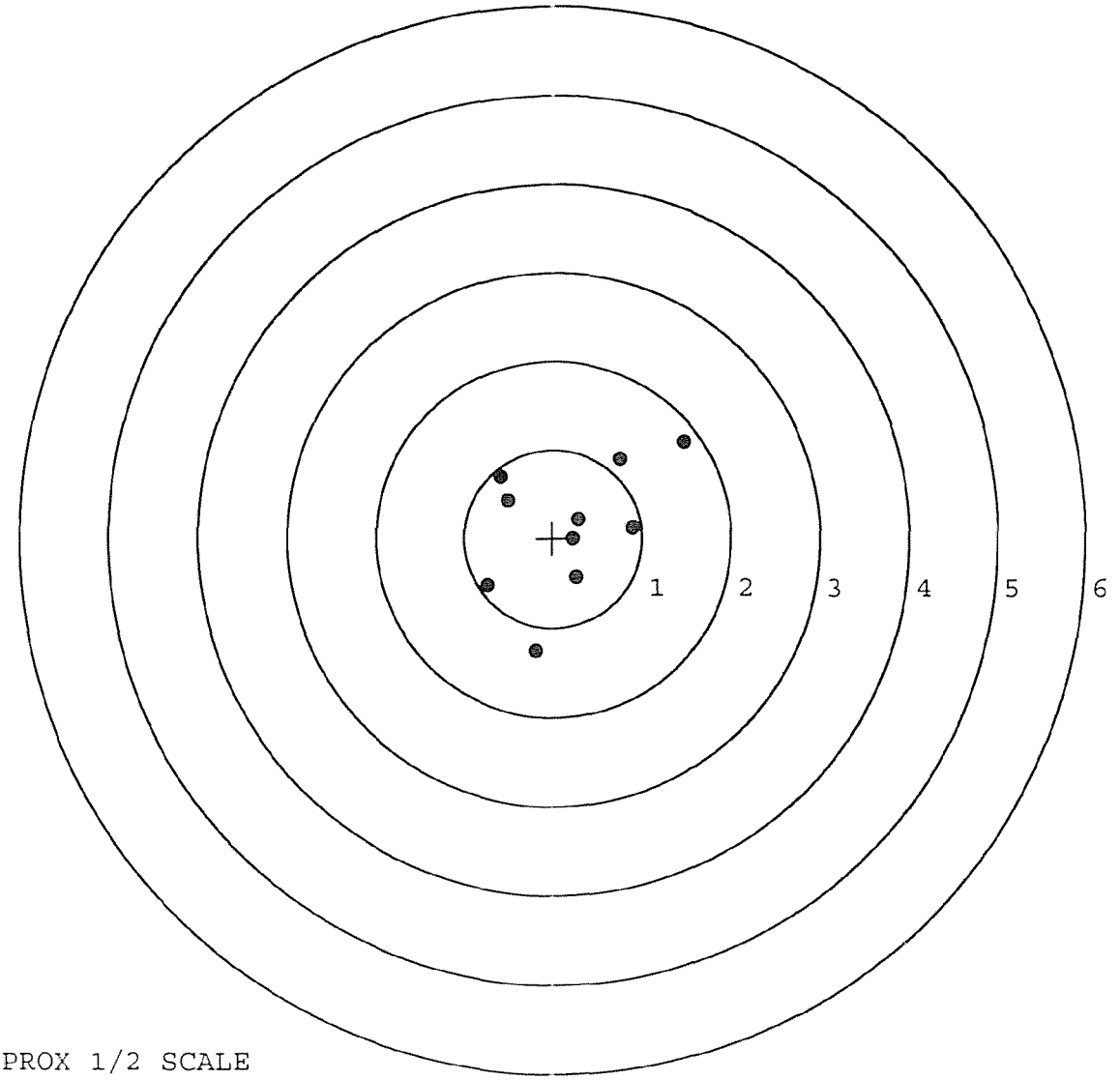
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.025
The Average Y Centroid of the Five Target Set:	-0.078
The Average Point of Impact of the Five Target Set:	0.082
The Average Mean Radius of the Five Target Set:	0.757
The Distance from POA to Centroid Target #1:	0.223
The Distance from Centroid Target #2 to Centroid Target #1:	0.515
The Distance from Centroid Target #3 to Centroid Target #1:	0.336
The Distance from Centroid Target #4 to Centroid Target #1:	0.251
The Distance from Centroid Target #5 to Centroid Target #1:	0.224

SERIAL NUMBER: C6587645.__0
TARGET NUMBER: 1
FILE DATE: 05/23/2008
FILE TIME: 05:31

X CENTROID:	0.188
Y CENTROID:	0.119
POA TO CENTROID:	0.223
HORZ SPREAD:	2.209
VERT SPREAD:	2.348
GROUP SPREAD:	2.877
MIN RADIUS:	0.133
MAX RADIUS:	1.605
MEAN RADIUS:	0.842
# IN 1 IN DIAMETER:	2
# IN 2 IN DIAMETER:	7
# in 3 IN DIAMETER:	9

POINT#	X	Y
1:	1.472	1.083
2:	0.756	0.894
3:	0.898	0.126
4:	0.290	0.210
5:	0.229	-0.007
6:	0.268	-0.446
7:	-0.190	-1.265
8:	-0.737	-0.531
9:	-0.512	0.429
10:	-0.590	0.699

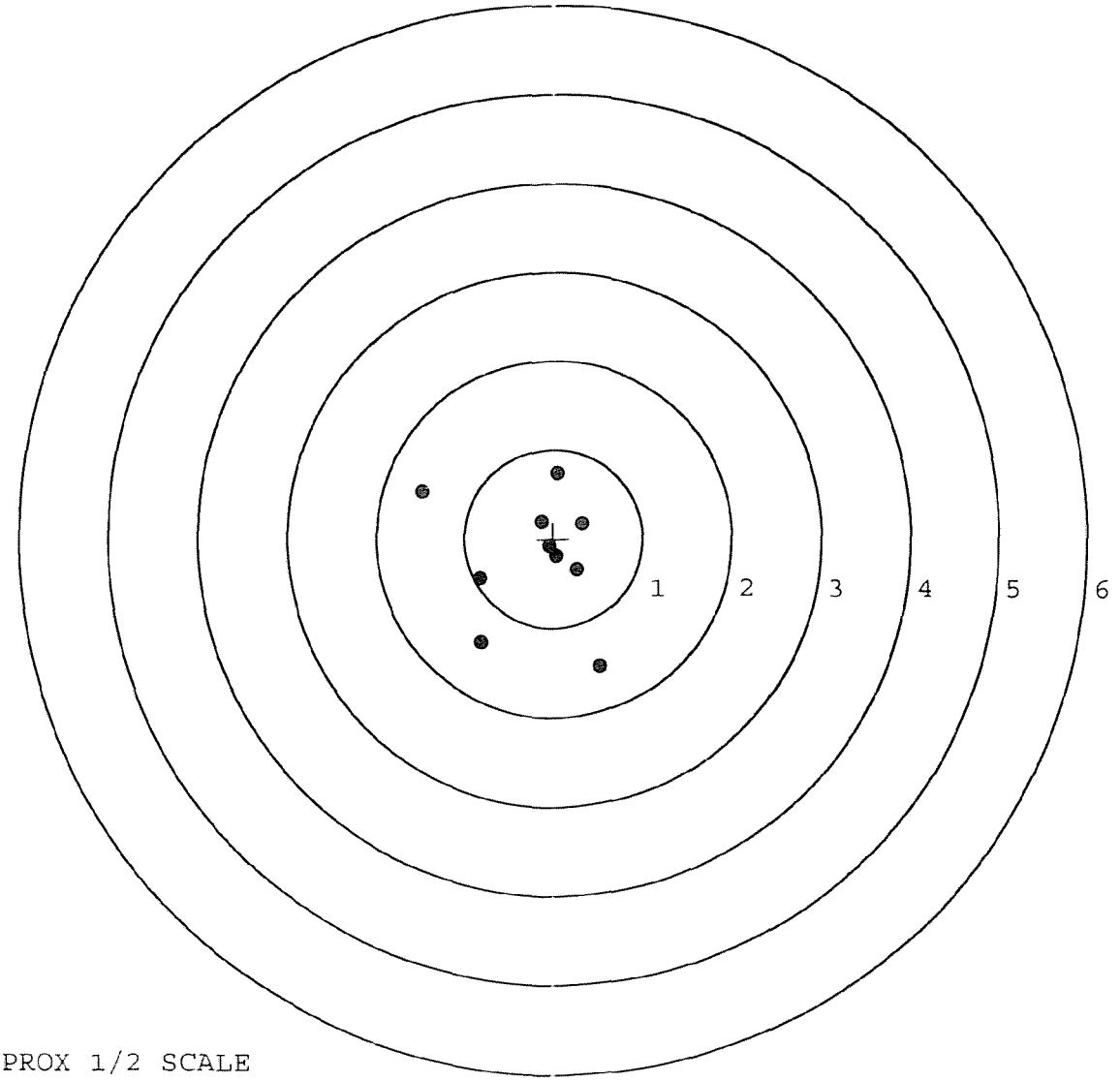


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6587645.__0
TARGET NUMBER: 2
FILE DATE: 05/23/2008
FILE TIME: 05:31

X CENTROID:	-0.209
Y CENTROID:	-0.208
POA TO CENTROID:	0.295
HORZ SPREAD:	2.003
VERT SPREAD:	2.175
GROUP SPREAD:	2.800
MIN RADIUS:	0.205
MAX RADIUS:	1.464
MEAN RADIUS:	0.767
# IN 1 IN DIAMETER:	4
# IN 2 IN DIAMETER:	7
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	0.522	-1.440
2:	-0.807	-1.167
3:	-0.824	-0.452
4:	-1.481	0.517
5:	0.047	0.735
6:	0.322	0.165
7:	-0.135	0.189
8:	-0.046	-0.085
9:	0.039	-0.198
10:	0.270	-0.349

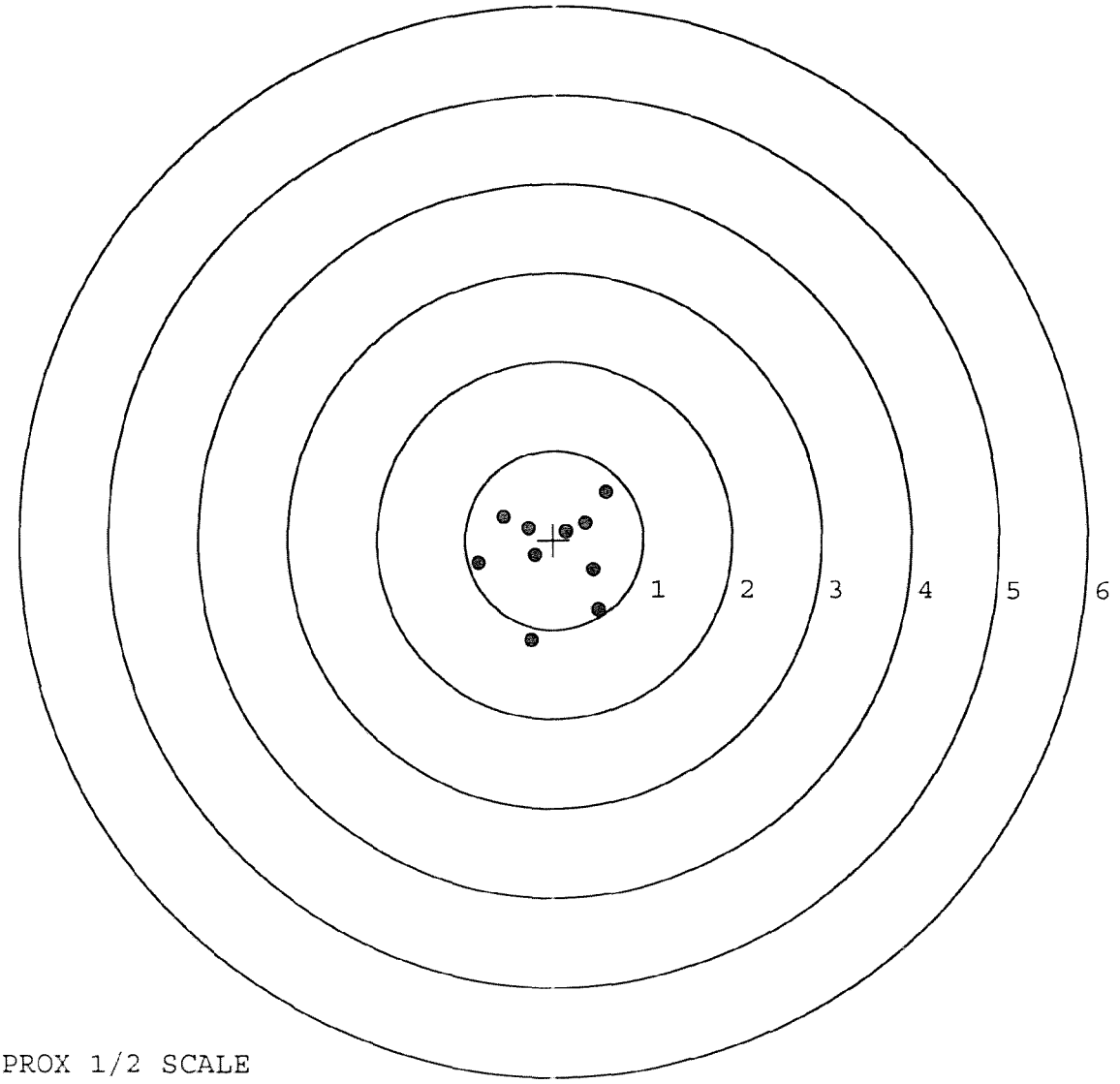


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6587645.__0
TARGET NUMBER: 3
FILE DATE: 05/23/2008
FILE TIME: 05:31

X CENTROID:	-0.015
Y CENTROID:	-0.149
POA TO CENTROID:	0.150
HORZ SPREAD:	1.434
VERT SPREAD:	1.658
GROUP SPREAD:	1.858
MIN RADIUS:	0.199
MAX RADIUS:	1.008
MEAN RADIUS:	0.614
# IN 1 IN DIAMETER:	5
# IN 2 IN DIAMETER:	9
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	0.500	-0.786
2:	0.442	-0.340
3:	-0.252	-1.129
4:	0.586	0.529
5:	0.353	0.188
6:	0.144	0.096
7:	-0.291	0.131
8:	-0.212	-0.171
9:	-0.568	0.255
10:	-0.848	-0.264

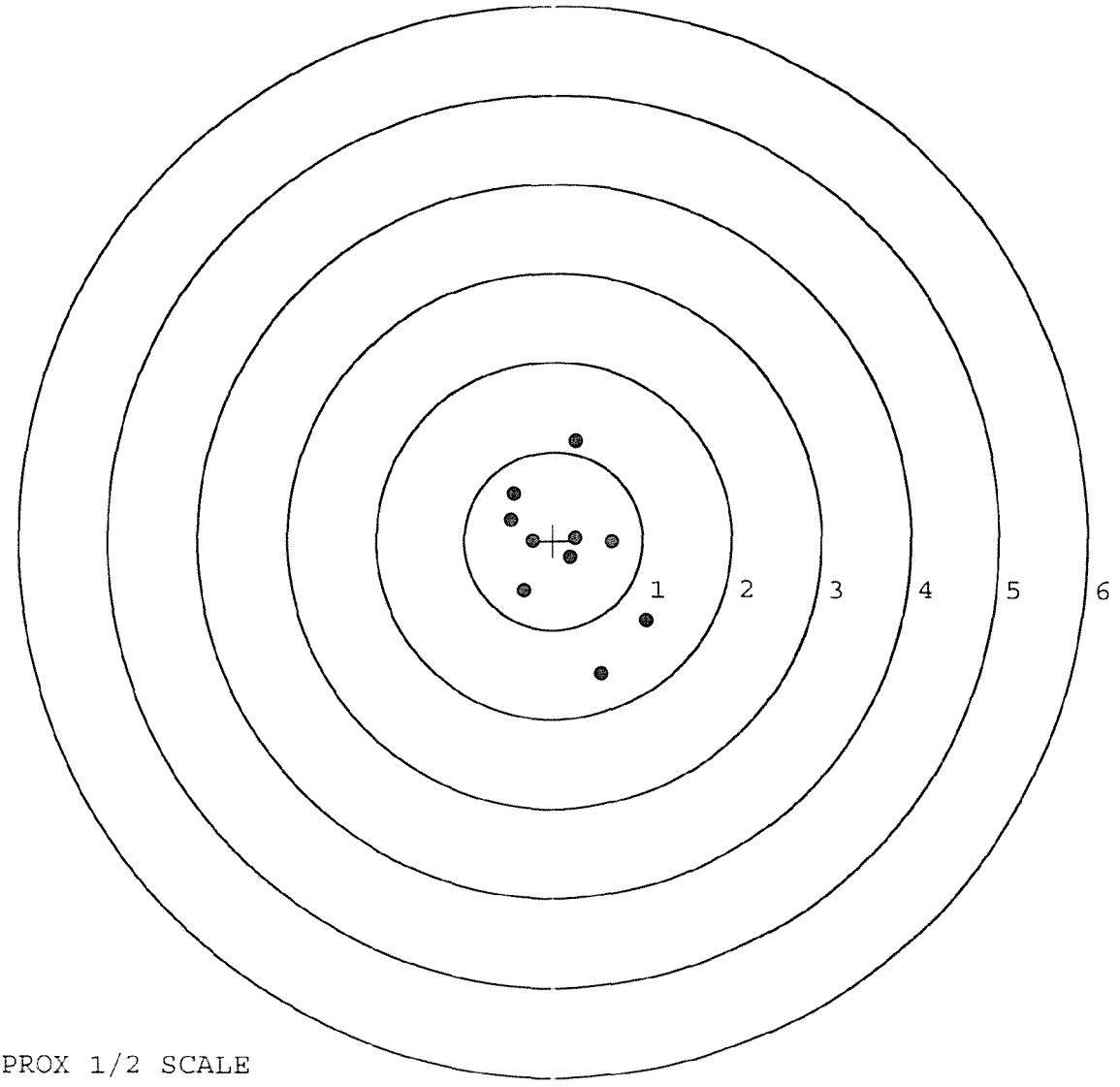


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6587645.__0
TARGET NUMBER: 4
FILE DATE: 05/23/2008
FILE TIME: 05:31

X CENTROID:	0.145
Y CENTROID:	-0.128
POA TO CENTROID:	0.194
HORZ SPREAD:	1.519
VERT SPREAD:	2.632
GROUP SPREAD:	2.647
MIN RADIUS:	0.073
MAX RADIUS:	1.440
MEAN RADIUS:	0.731
# IN 1 IN DIAMETER:	3
# IN 2 IN DIAMETER:	7
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	1.041	-0.903
2:	0.539	-1.513
3:	0.660	-0.016
4:	0.251	0.030
5:	0.188	-0.188
6:	-0.229	0.003
7:	-0.329	-0.571
8:	-0.478	0.230
9:	-0.443	0.526
10:	0.253	1.119

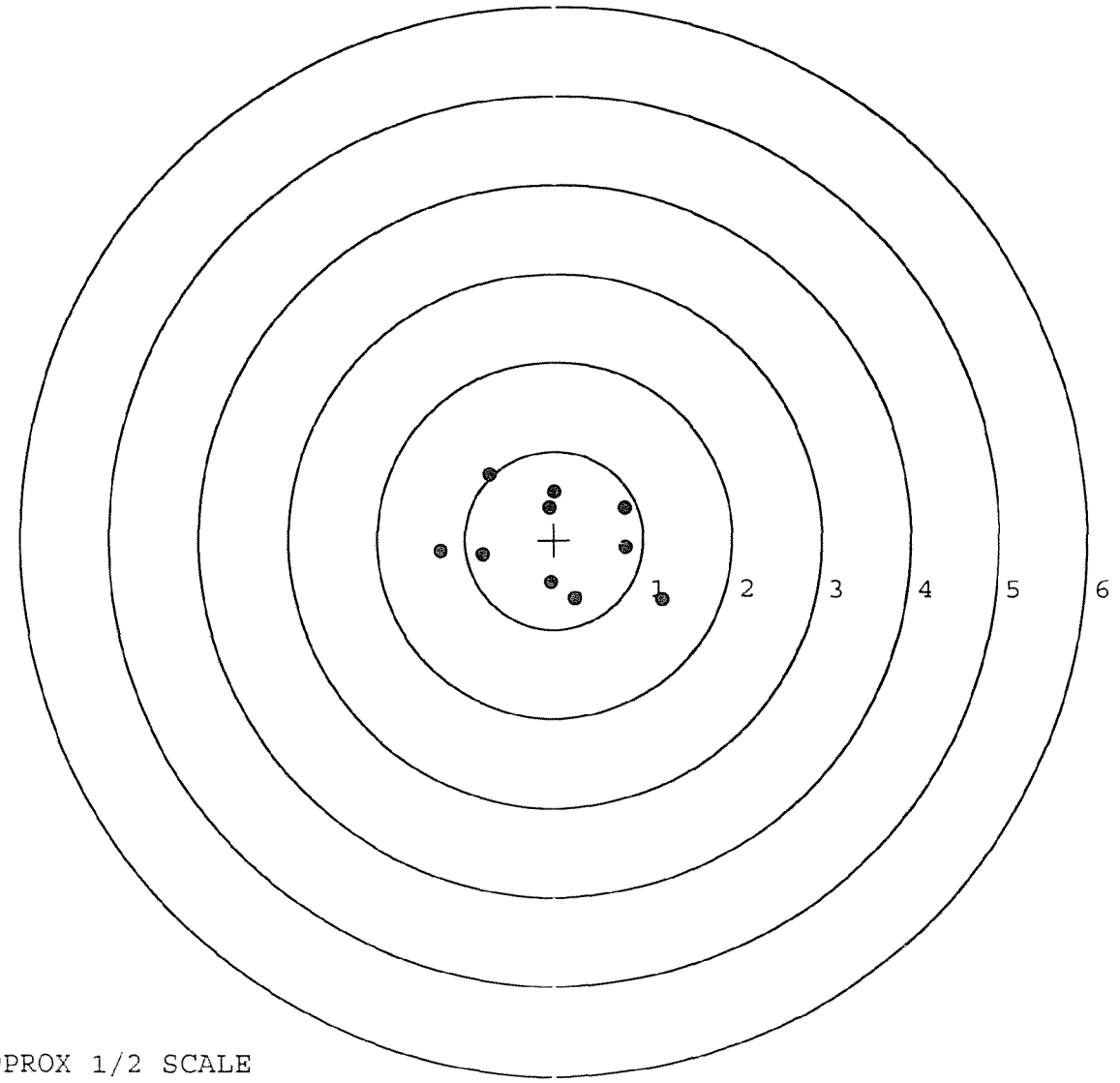


TARGET APPROX 1/2 SCALE

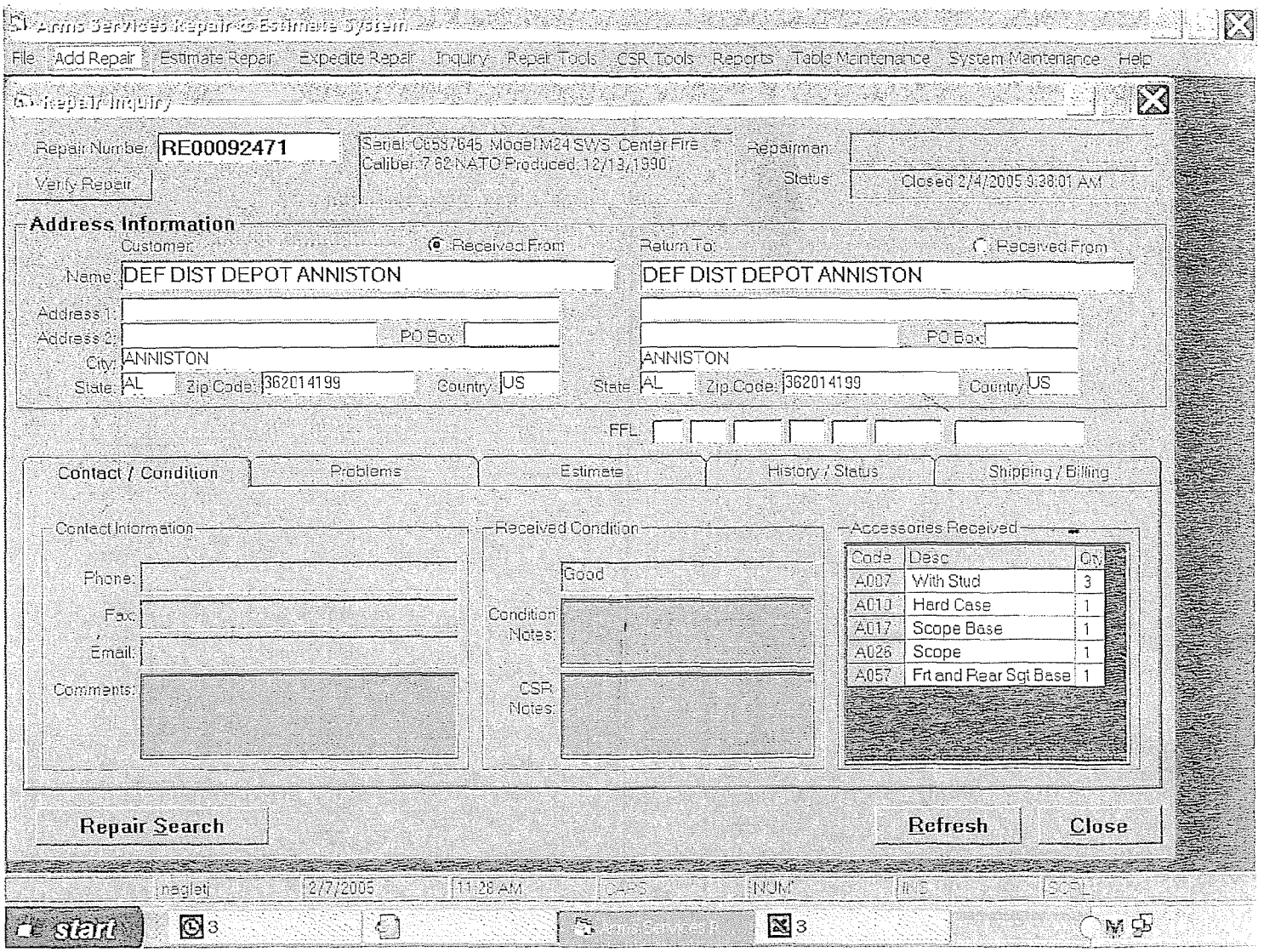
SERIAL NUMBER: C6587645.__0
TARGET NUMBER: 5
FILE DATE: 05/23/2008
FILE TIME: 05:31

X CENTROID:	0.015
Y CENTROID:	-0.023
POA TO CENTROID:	0.028
HORZ SPREAD:	2.487
VERT SPREAD:	1.414
GROUP SPREAD:	2.546
MIN RADIUS:	0.392
MAX RADIUS:	1.361
MEAN RADIUS:	0.829
# IN 1 IN DIAMETER:	2
# IN 2 IN DIAMETER:	7
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	1.208	-0.679
2:	0.804	-0.098
3:	0.793	0.351
4:	0.235	-0.662
5:	-0.037	-0.478
6:	-0.060	0.362
7:	0.004	0.543
8:	-0.725	0.735
9:	-0.794	-0.172
10:	-1.279	-0.134



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: RE00092471
Verify Repair
Serial: C6587645 Model: M24 SWS Center Fire Caliber: 7.62 NATO Produced: 12/13/1990
Repairman
Status: Closed 2/4/2005 9:38:01 AM
Address Information
Customer
Received From
Name: DEF DIST DEPOT ANNISTON
Address 1:
Address 2:
PO Box:
City: ANNISTON
State: AL Zip Code: 362014199 Country: US
Return To:
Received From
DEF DIST DEPOT ANNISTON
PO Box:
ANNISTON
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 Frt and Rear Sgt Base 1
Repair Search
Refresh
Close
2/7/2005
11:28 AM
start


Serial Number: C65587645
Model: M24 SWS
RE00092471

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFOMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6587645.__0
FILE DATE AND TIME: 04/29/2005 06:43

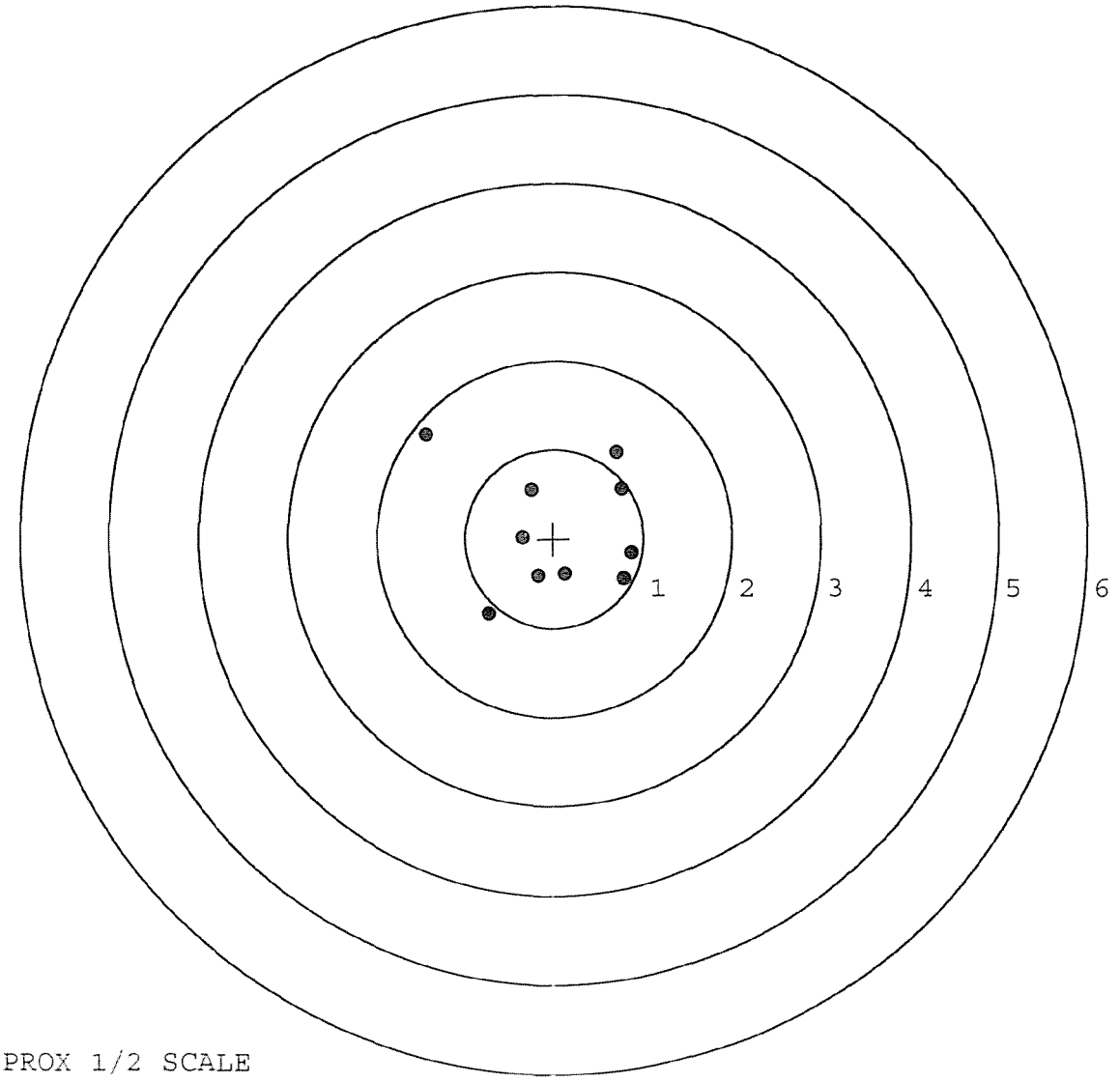
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.047
The Average Y Centroid of the Five Target Set:	0.049
The Average Point of Impact of the Five Target Set:	0.067
The Average Mean Radius of the Five Target Set:	0.709
The Distance from POA to Centroid Target #1:	0.101
The Distance from Centroid Target #2 to Centroid Target #1:	0.083
The Distance from Centroid Target #3 to Centroid Target #1:	0.066
The Distance from Centroid Target #4 to Centroid Target #1:	0.161
The Distance from Centroid Target #5 to Centroid Target #1:	0.327

SERIAL NUMBER: C6587645.__0
TARGET NUMBER: 1
FILE DATE: 04/29/2005
FILE TIME: 06:43

X CENTROID:	0.029
Y CENTROID:	0.097
POA TO CENTROID:	0.101
HORZ SPREAD:	2.312
VERT SPREAD:	2.007
GROUP SPREAD:	2.751
MIN RADIUS:	0.387
MAX RADIUS:	1.817
MEAN RADIUS:	0.878
# IN 1 IN DIAMETER:	1
# IN 2 IN DIAMETER:	7
# in 3 IN DIAMETER:	9

POINT#	X	Y
1:	-1.441	1.164
2:	-0.255	0.542
3:	-0.347	0.007
4:	0.131	-0.398
5:	-0.178	-0.417
6:	-0.735	-0.843
7:	0.786	-0.451
8:	0.871	-0.166
9:	0.757	0.557
10:	0.702	0.971

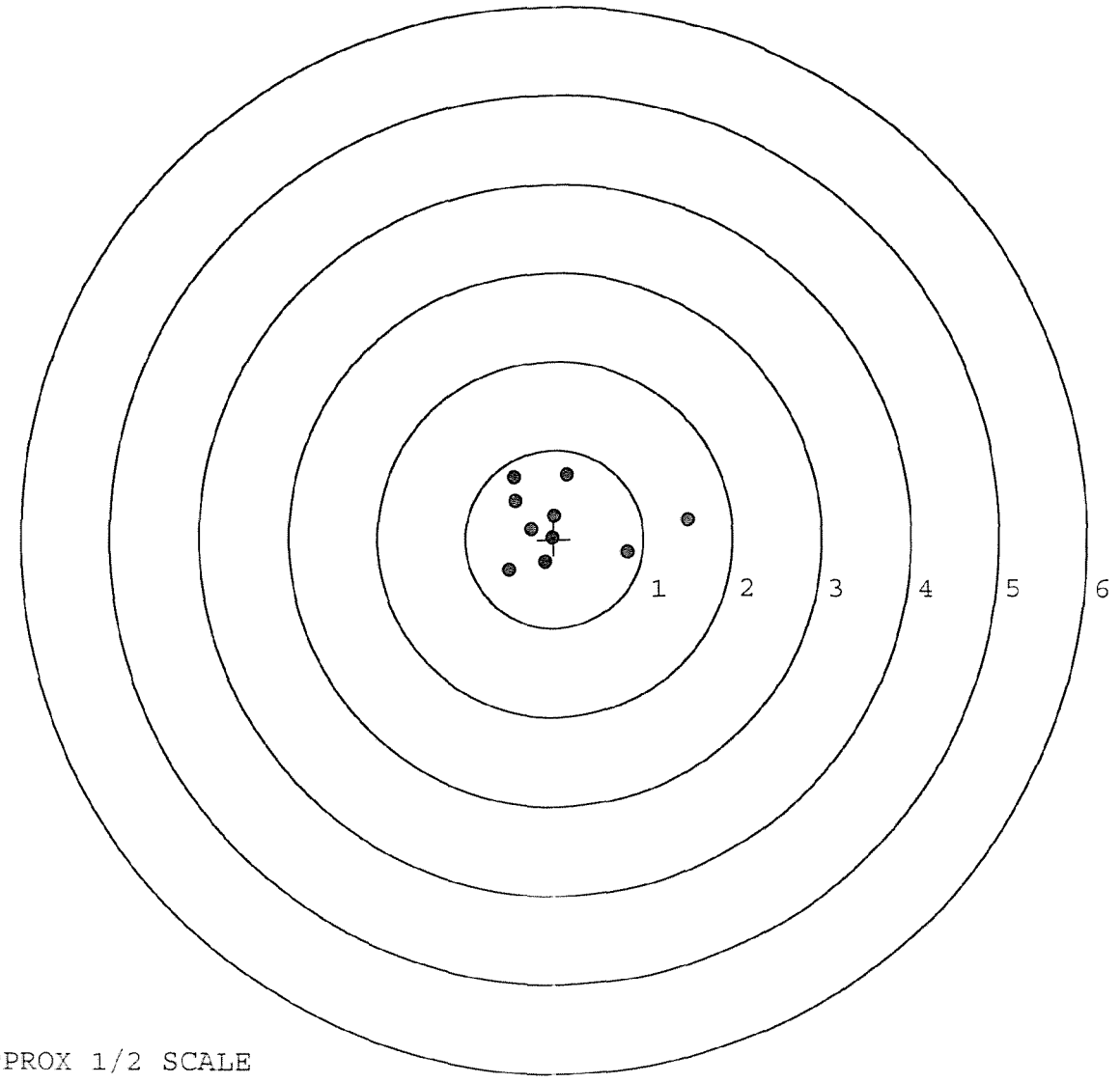


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6587645.__0
TARGET NUMBER: 2
FILE DATE: 04/29/2005
FILE TIME: 06:43

X CENTROID:	0.066
Y CENTROID:	0.171
POA TO CENTROID:	0.184
HORZ SPREAD:	2.002
VERT SPREAD:	1.071
GROUP SPREAD:	2.083
MIN RADIUS:	0.115
MAX RADIUS:	1.425
MEAN RADIUS:	0.598
# IN 1 IN DIAMETER:	4
# IN 2 IN DIAMETER:	9
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	0.142	0.720
2:	-0.459	0.695
3:	-0.443	0.432
4:	0.001	0.266
5:	-0.259	0.119
6:	-0.024	0.014
7:	-0.103	-0.257
8:	-0.512	-0.351
9:	0.825	-0.149
10:	1.490	0.224

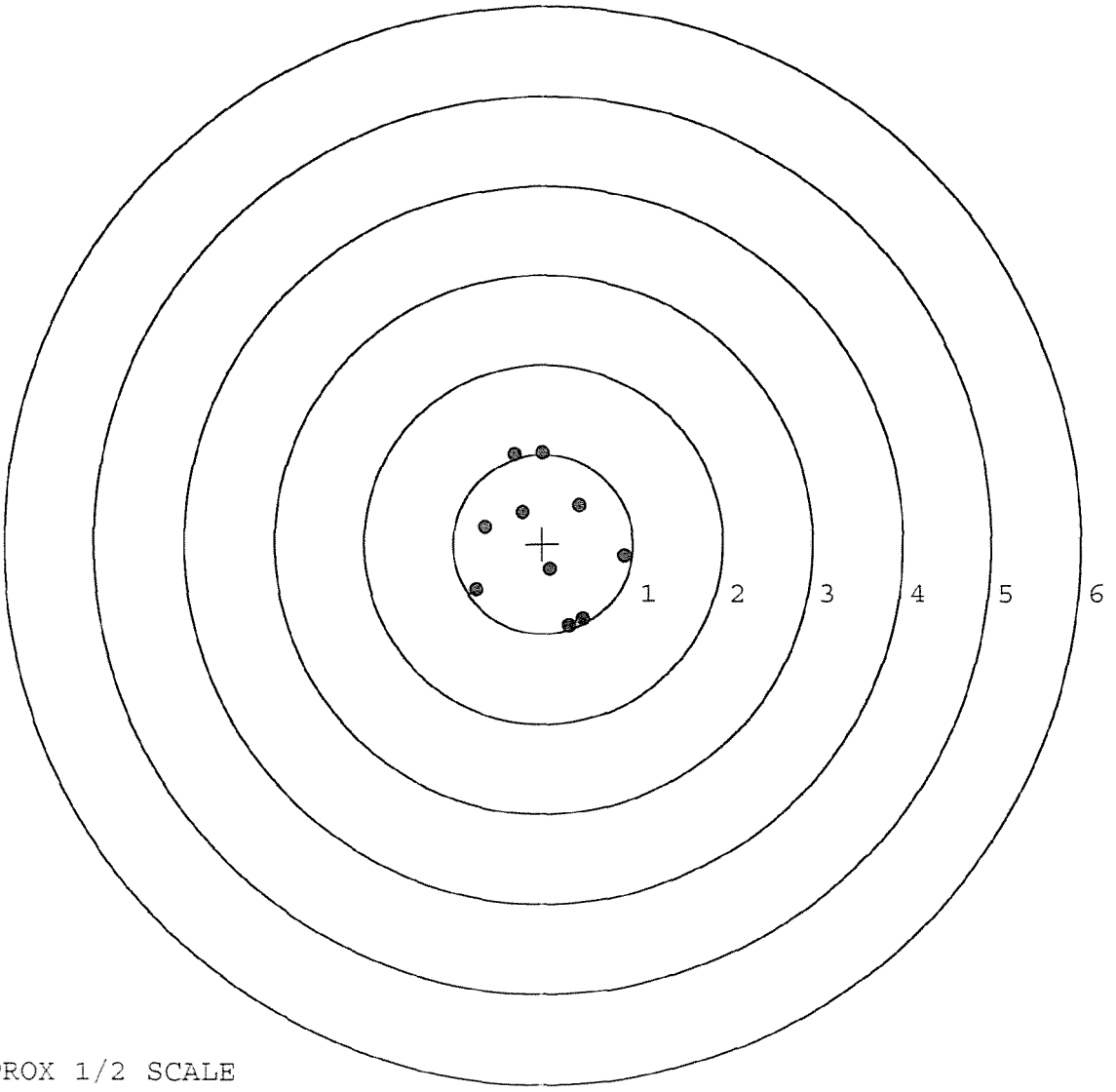


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6587645.__0
TARGET NUMBER: 3
FILE DATE: 04/29/2005
FILE TIME: 06:43

X CENTROID:	0.018
Y CENTROID:	0.032
POA TO CENTROID:	0.037
HORZ SPREAD:	1.648
VERT SPREAD:	1.930
GROUP SPREAD:	2.017
MIN RADIUS:	0.320
MAX RADIUS:	1.031
MEAN RADIUS:	0.779
# IN 1 IN DIAMETER:	2
# IN 2 IN DIAMETER:	9
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	-0.321	1.005
2:	-0.012	1.015
3:	-0.229	0.359
4:	-0.647	0.197
5:	-0.743	-0.518
6:	0.082	-0.282
7:	0.447	-0.846
8:	0.296	-0.915
9:	0.905	-0.131
10:	0.406	0.432

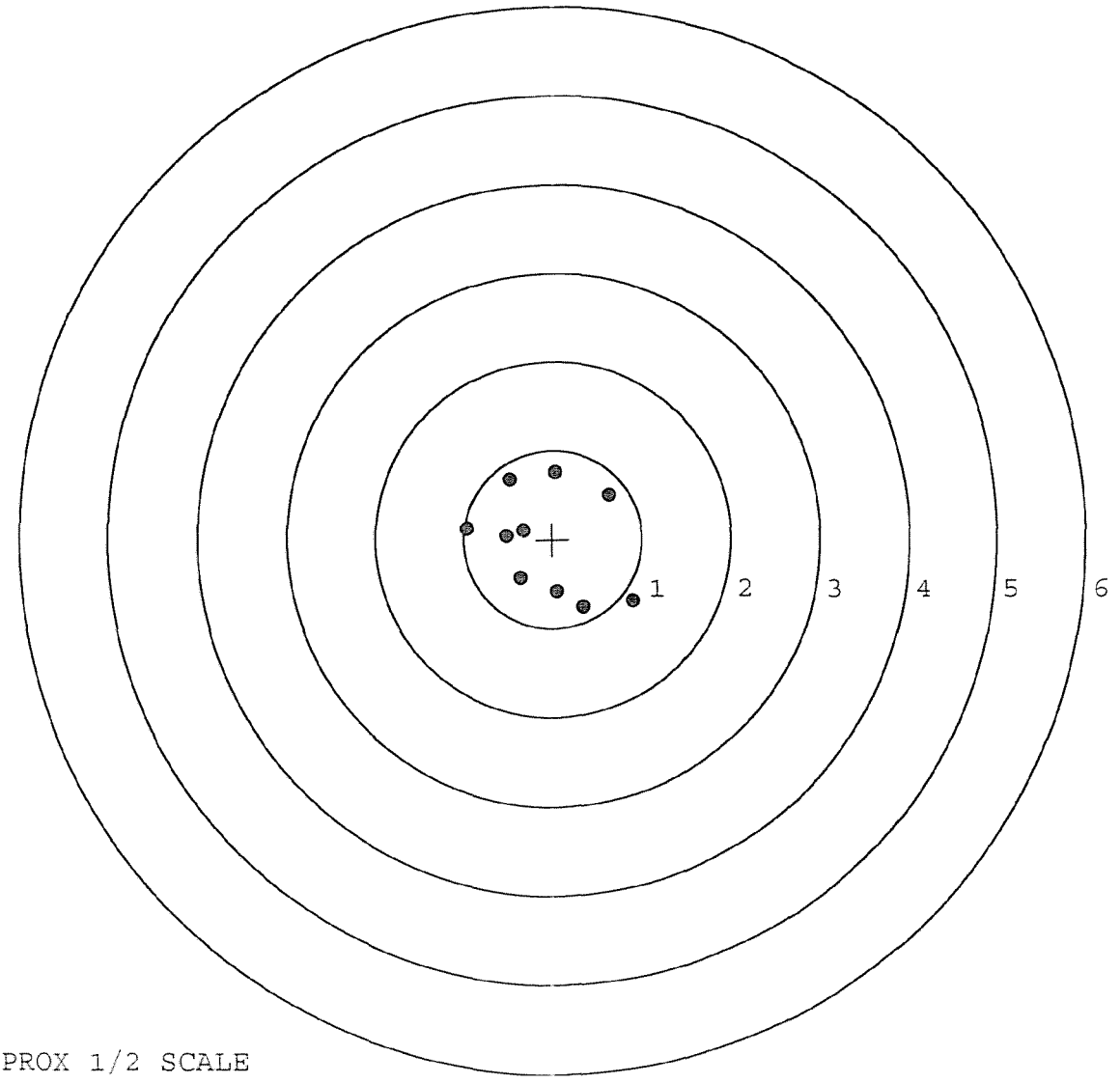


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6587645.__0
TARGET NUMBER: 4
FILE DATE: 04/29/2005
FILE TIME: 06:43

X CENTROID:	-0.072
Y CENTROID:	-0.030
POA TO CENTROID:	0.077
HORZ SPREAD:	1.861
VERT SPREAD:	1.524
GROUP SPREAD:	2.030
MIN RADIUS:	0.291
MAX RADIUS:	1.175
MEAN RADIUS:	0.723
# IN 1 IN DIAMETER:	2
# IN 2 IN DIAMETER:	9
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	0.033	0.758
2:	-0.485	0.674
3:	-0.965	0.115
4:	-0.330	0.103
5:	-0.518	0.043
6:	-0.366	-0.436
7:	0.048	-0.588
8:	0.344	-0.766
9:	0.896	-0.697
10:	0.628	0.497

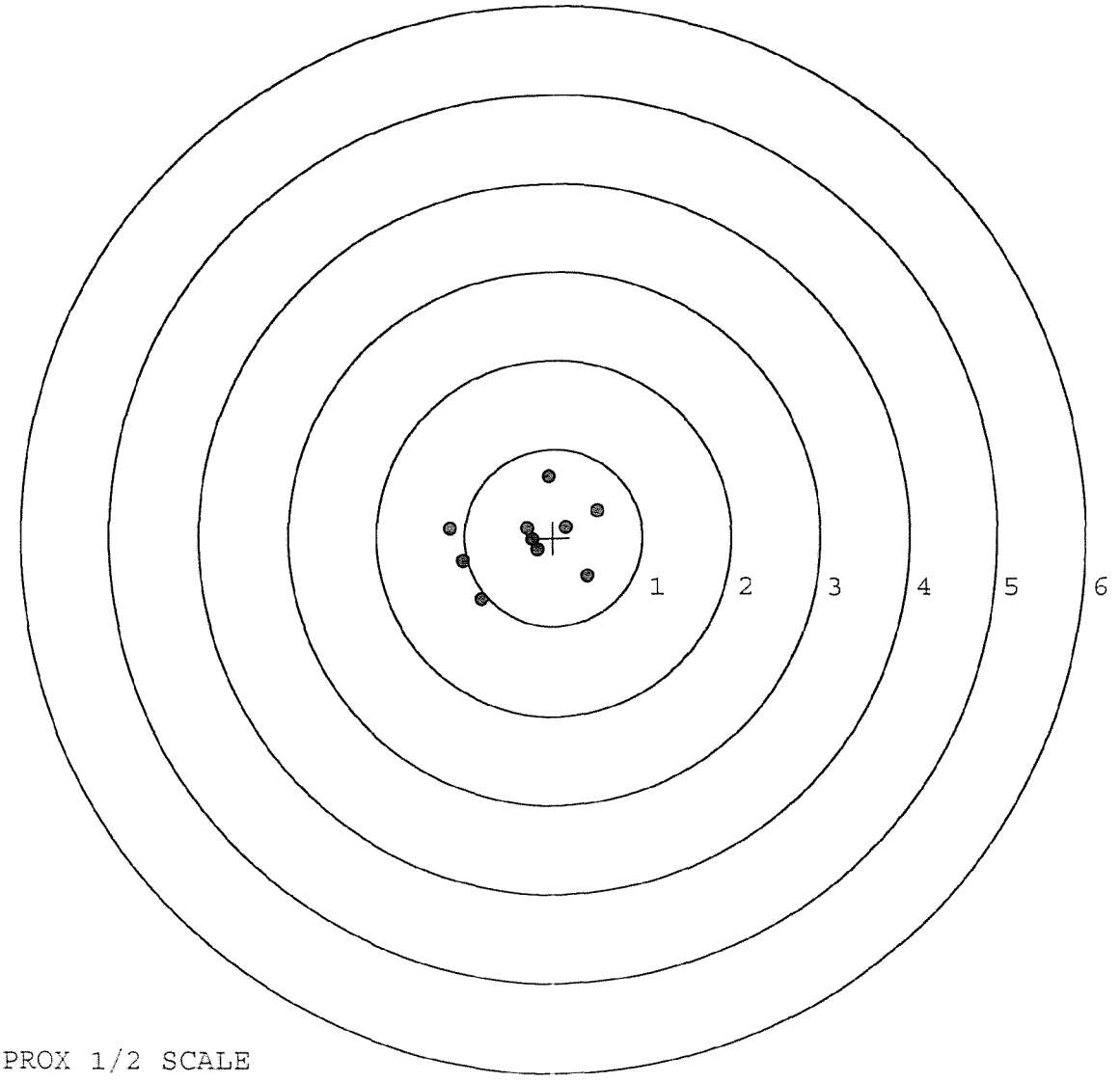


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6587645.__0
TARGET NUMBER: 5
FILE DATE: 04/29/2005
FILE TIME: 06:43

X CENTROID:	-0.275
Y CENTROID:	-0.025
POA TO CENTROID:	0.276
HORZ SPREAD:	1.653
VERT SPREAD:	1.401
GROUP SPREAD:	1.666
MIN RADIUS:	0.038
MAX RADIUS:	0.894
MEAN RADIUS:	0.567
# IN 1 IN DIAMETER:	4
# IN 2 IN DIAMETER:	10
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	-1.160	0.095
2:	-1.019	-0.277
3:	-0.812	-0.702
4:	0.381	-0.435
5:	-0.058	0.699
6:	0.493	0.305
7:	0.143	0.116
8:	-0.295	0.110
9:	-0.237	-0.026
10:	-0.181	-0.139



TARGET APPROX 1/2 SCALE

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 4-4-05

TESTER TRW

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.23	2.62		2.47	
PULL #2	2.42	2.47		2.41	
PULL #3	2.60	2.53		2.58	
PULL #4	2.38	2.43		2.29	
PULL #5	2.80	2.41		2.51	
TOTAL	12.43	12.46		12.26	
AVERAGE	2.48	2.49		2.45	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.19	3.60		
PULL #2	3.36	3.36		
PULL #3	3.07	3.36		
PULL #4	3.42	3.11		
PULL #5	3.03	3.47		
TOTAL	16.07	16.90		
AVERAGE	3.21	3.38		

	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	4.04	4.37		4.38
PULL #2	4.54	4.16		4.25
PULL #3	4.48	4.31		4.36
PULL #4	4.15	4.28		4.31
PULL #5	4.29	3.85		4.35
TOTAL	21.50	20.97		21.65
AVERAGE	4.30	4.19		4.33

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

R & E NUMBER	92471		
SERIAL NUMBER	C6587645		
LOG-IN DATE	2-4-05		
INSPECT AND VERIFY:			
OPERATION #	OPERATION NAME	DATE	INITIAL
550	DIS-ASSEMBLE GUN	4-4-05	RTL
560 A	RE-BARREL	4-7-05	RTL
B	DRILL AND TAP	4-11-05	TRW
575	ASSEMBLE	4-7-05	RTL
600	PROOF	4-8-05	AC
605	CHECK HEADSPACE	4-8-05	AC
610	DIS-ASSEMBLE GUN	4-11-05	RTL
612	MAGNAFLUX		
615	ROLLMARK CALIBER	4-12-05	CW
618	ROTO-BLAST	4-18-05	LB
620	APPLY COATINGS	9-24-05	wl
625 A	FINAL ASSEMBLY	4-28-05	RTL
B	TRIGGER PULL TEST		
C	SAFETY "ON" FORCE	4-29-05	AC
D	SAFETY "OFF" FORCE	4-29-05	AC
E	FIRING PIN INDENT	4-29-05	AC
640	TARGET	4-29-05	AC
655	FINAL INSPECT	4-29-05	AC
660	PACK	4-30-05	QA
		SHIP DATE	
	QAR INSPECTION DATE		

GFM

CONTRACT # DAAA21-87-C-0086 Repair

GUN SERIAL # C6587645 New Barrel

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		2/4/93	RW
600	Proof		2/4/93	RW
607	Check Headspace		2/4/93	RW
610	Dis-assemble Gun		2/4/93	RW
612	Magnaflux Barrel Action		2/5/93	
	Magnaflux Bolt			
615	Rollmark Caliber		2/5/93	
617	Drill and Tap Sight Holes		2/5/93	
618	Polish Barrel		2/5/93	
620	Apply Coatings (Barrel Action)			
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		2/11/93	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		2/11/93	RW
	C) Inspect Ejector Hole for Chamfer		2/11/93	RW
	D) Oil Firing Pin Ass'y		2/11/93	RW
	E) Adjust Trigger Pull to Min Setting and Stake		2/11/93	RW

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			2/11/93	RW
	G) Safety Off Force	3	3	3			2/11/93	RW
	H) Trigger Pull Test & Retainability						2/11/93	RW
	I) Firing Pin Indent	.020	.020	.0205			2/11/93	RW
	J) Assemble Stock							
	K) Assemble Swivel Studs							
	L) Attach Front and Rear Sight Assemblies						2/11/93	RW
	M) Iron Sight Alignment						2/11/93	RW
	N) Detach Front & Rear Sights & place in numbered container						2/11/93	RW
	O) Attach Scope to Rifle						2/11/93	RW
	P) Detach & Attach Scope 20 Times							
640	Gallery Target & Test						3/1/93	RW
	A) Time							
	B) Malfunctions							
	C) Pierced Primers							
	D) Optical Clearity of Scope							
645	Inspect for Live Ammo						3/1/93	RW
655	Final Inspection A) Headspace						3/4/93	RW
	B) Trigger Pull	2.32	2.53	2.56	2.63	2.63	3/4/93	RW
	C) Function						3/4/93	RW
660	Pack							

SWS TRIGGER PULL TEST

New Trigger Assy

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

SERIAL NO. C6587645

DATE 2/4/93

TESTER RW

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.50	2.80	2.60		MIN. SETTING,
PULL #2	2.72	2.69	2.51		NO AVG. OF 5
PULL #3	2.68	2.87	2.44		READINGS ACCEPT-
PULL #4	2.69	2.62	2.34		ABLE LESS THAN 2#
PULL #5	2.68	2.63	2.47		
TOTAL	13.27	13.61	12.36		
AVG.	2.65	2.72	2.47		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.23	3.26		
PULL #2	3.31	3.20		
PULL #3	3.22	3.26		
PULL #4	3.27	3.34		
PULL #5	3.29	3.26		
TOTAL	16.32	16.32		
AVG.	3.26	3.26		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.21	4.00		4.31
PULL #2	4.18	4.07		4.25
PULL #3	4.23	4.08		4.23
PULL #4	4.20	4.02		4.23
PULL #5	4.17	4.08		4.26
TOTAL	20.99	20.25		21.28
AVG.	4.20	4.05		4.26

RECEIVING AND ESTIMATING REPORT

COMMENTS: WOC 15 OF 30 W/10X SCOPE & DEPLOYMENT KIT M-24

ORDER: R 93-02466

INITIAL	CUSTOMER ORDER NO.
FPS	

DATE RECEIVED	DATE OPENED	DATE CODE	SERIAL NUMBER	NEW SERIAL NUMBER	MODEL AND GRADE
01/25/93	01/25/93	RK 11-90	C6587645		700 7-62 NATO

ACCESSORIES: W/STUDS W/SWIVELS SOFT CASE SCOPE BASE

FROM:

MCHALE, EDWARD J CPT,SF
HSC 3RD BN 3RD SFG (A)
FT BRAGG NC 28307

SHIP TO:

MCHALE, EDWARD J CPT,SF
HSC 3RD BN 3RD SFG (A)
FT BRAGG NC 28307

CUST NO:673985 C.S.D

ACCOUNT NUMBER	ACCOUNT NUMBER N/C	WRITE ☐ CLEAN/TEST	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			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

PARTS	COMMENTS

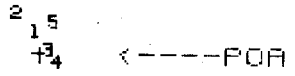
REPAIRMAN	PROOF	CLEAN	TEST	TARGET	PATTERN
GALLERY TESTER	DATE	DATE	DATE	DATE	DATE

RD6925 REV. 1/92

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6587645
3 Mar 1993

CENTROIDAL DISTANCES

Ø	TO	1	.471839
1	TO	2	.468139
1	TO	3	.438631
1	TO	4	.726187
1	TO	5	.383377

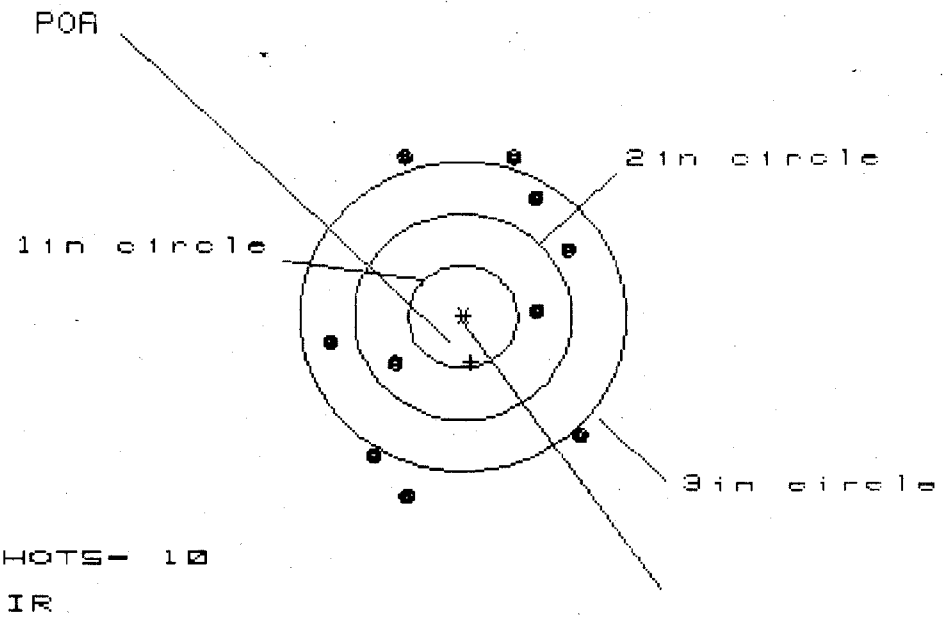


THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0626
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .3736
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .378808

THE AMR FOR THIS RIFLE IS: 1.055

3 Mar 1993 FILE:/PATTERNING/CENTERFIRE_PATT/C6507645

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

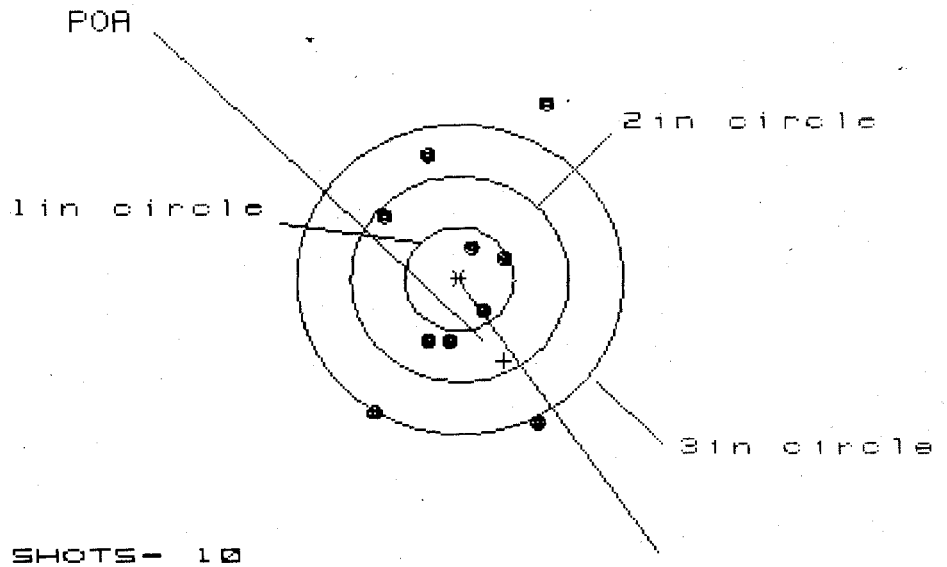
# IN CIR
1in = 0
2in = 2
3in = 5

HS= 2.347
VS= 3.314
GS= 3.480

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.093	1.031	1.087
MINIMUM X	:	-1.254	-1.316	-1.260
MAXIMUM Y	:	1.585	1.393	1.501
MINIMUM Y	:	-1.729	-1.523	-1.349
CENTROID X	:	-.074	-.012	-.068
CENTROID Y	:	.446	.638	.464
POA TO CENTROID in.	:	.452	.639	.469
MIN RADIUS	:	.626	.591	.620
MEAN RADIUS	:	1.337	1.267	1.236
MAX RADIUS	:	1.815	1.762	1.620
HORIZONTAL SPREAD	:	2.347	2.347	2.347
VERTICAL SPREAD	:	3.314	2.916	2.850
EXTREME SPREAD	:	3.480	3.207	3.165
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		2	
NUMBER IN THREE INCH CIRCLE	=		5	

3 Mar 1993 FILE:/PATTERNING/CENTERFIRE_PATT/C6507645

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

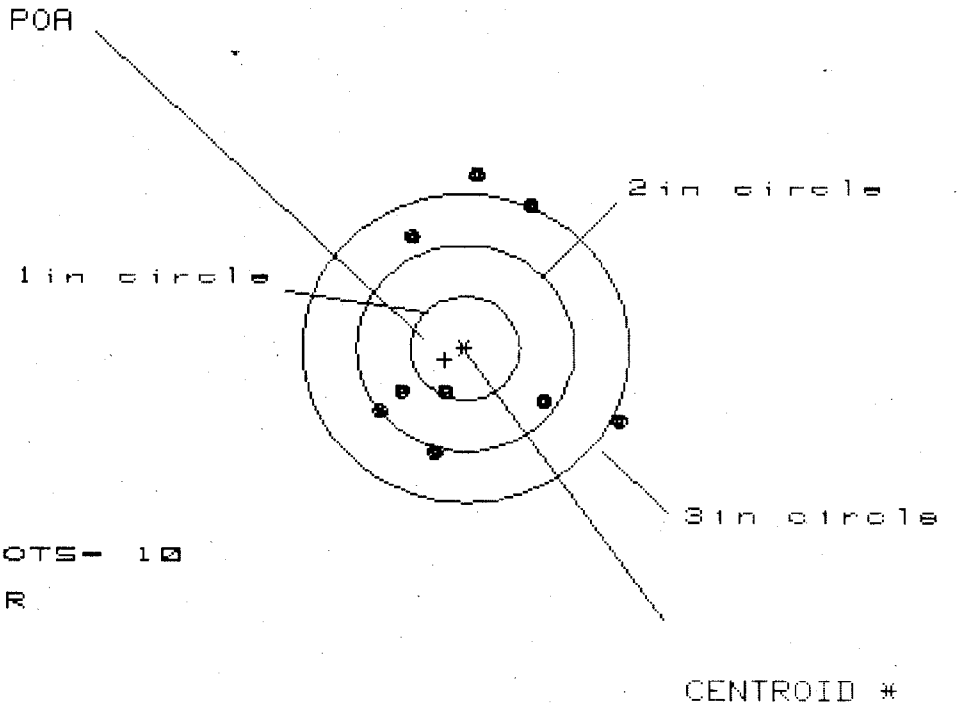
# IN CIR
1in = 3
2in = 6
3in = 8

HS= 1.528
VS= 3.104
GS= 3.321

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.775	.805	.560
MINIMUM X	:	-.752	-.666	-.566
MAXIMUM Y	:	1.702	1.412	1.260
MINIMUM Y	:	-1.402	-1.213	-1.210
CENTROID X	:	-.409	-.496	-.596
CENTROID Y	:	.793	.604	.756
POA TO CENTROID in.	:	.893	.781	.963
MIN RADIUS	:	.304	.259	.417
MEAN RADIUS	:	.945	.828	.760
MAX RADIUS	:	1.870	1.456	1.335
HORIZONTAL SPREAD	:	1.528	1.471	1.126
VERTICAL SPREAD	:	3.104	2.625	2.470
EXTREME SPREAD	:	3.321	2.800	2.520
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

3 Mar 1993 FILE:/PATTERNING/CENTERFIRE_PATT/C6587645

CENTERFIRE PATTERNS # 3

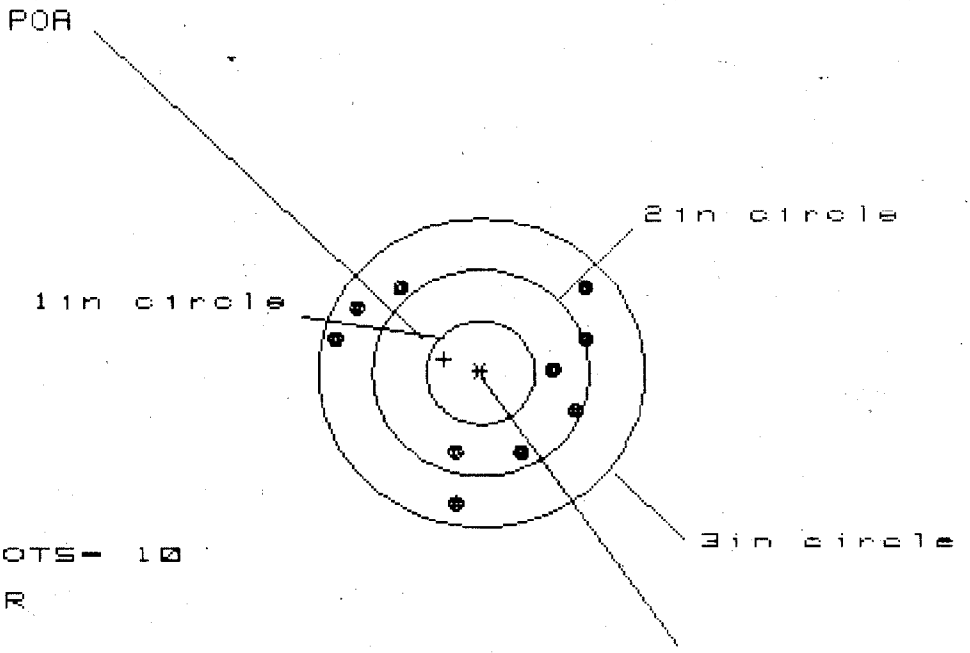


# OF SHOTS= 10
# IN CIR
1in = 1
2in = 5
3in = 7
HS= 2.195
VS= 2.752
GS= 2.786

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.455	1.465	.909
MINIMUM X	:	-.740	-.730	-.547
MAXIMUM Y	:	1.715	1.571	1.506
MINIMUM Y	:	-1.037	-.847	-.913
CENTROID X	:	.185	.175	-.008
CENTROID Y	:	.112	-.078	-.012
POA TO CENTROID in.	:	.217	.191	.015
MIN RADIUS	:	.461	.301	.281
MEAN RADIUS	:	1.081	.958	.850
MAX RADIUS	:	1.717	1.684	1.699
HORIZONTAL SPREAD	:	2.195	2.195	1.456
VERTICAL SPREAD	:	2.752	2.418	2.418
EXTREME SPREAD	:	2.786	2.603	2.572
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		7	

3 Mar 1993 FILE:/PATTERNING/CENTERFIRE_PATT/C6507645

CENTERFIRE PATTERNS # 4

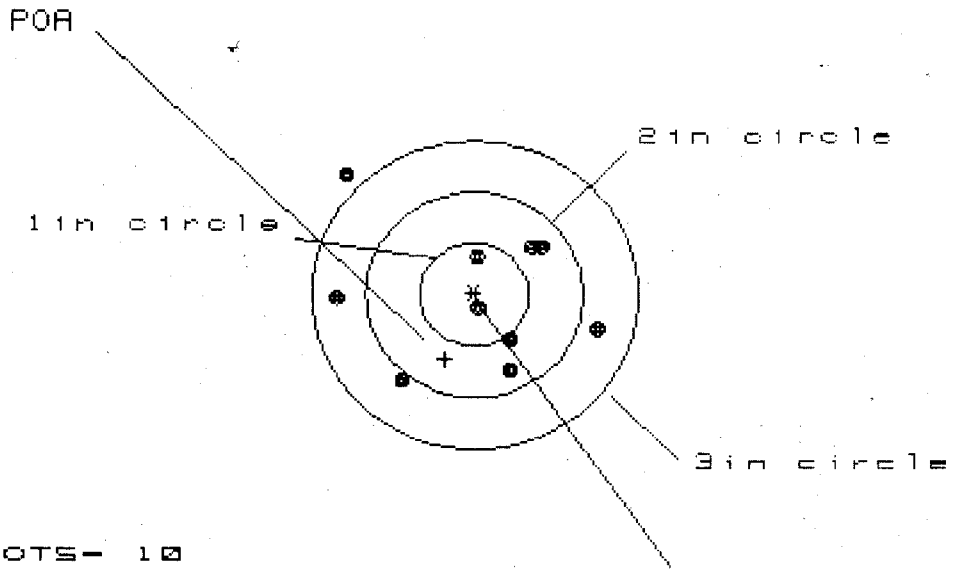


# OF SHOTS= 10
# IN CIR
1in = 0
2in = 4
3in = 10
HS= 2.348
VS= 2.098
GS= 2.366

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.004	.855	.803
MINIMUM X	:	-1.344	-1.237	-1.289
MAXIMUM Y	:	.837	.878	.726
MINIMUM Y	:	-1.261	-1.220	-.873
CENTROID X	:	.338	.487	.539
CENTROID Y	:	-.132	-.173	-.021
POA TO CENTROID in.	:	.363	.517	.539
MIN RADIUS	:	.621	.481	.418
MEAN RADIUS	:	1.049	.980	.934
MAX RADIUS	:	1.393	1.429	1.406
HORIZONTAL SPREAD	:	2.348	2.092	2.092
VERTICAL SPREAD	:	2.098	2.098	1.599
EXTREME SPREAD	:	2.366	2.366	2.182
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		10	

3 Mar 1993 FILE:/PATTERNING/CENTERFIRE_PATT/C6587645

CENTERFIRE PATTERNS # 5

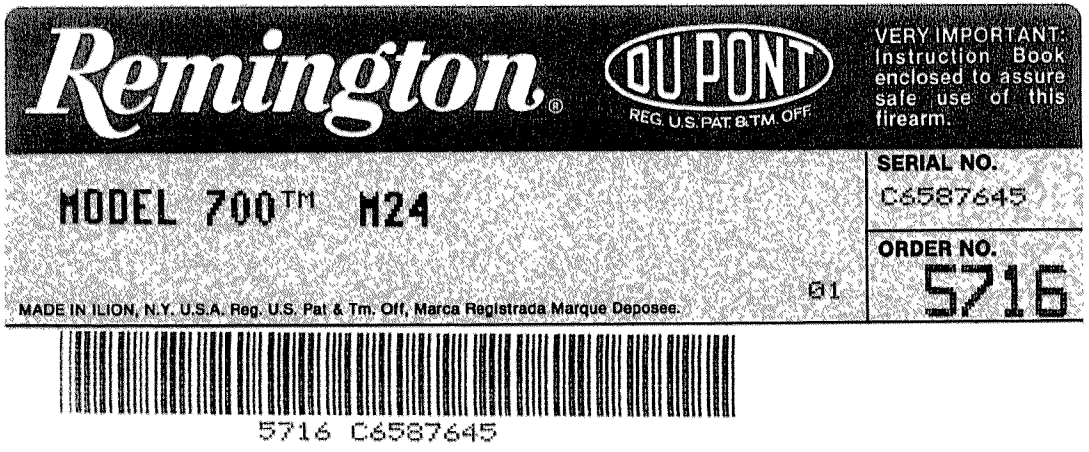


OF SHOTS= 10

# IN CIR
1in = 2
2in = 6
3in = 9

HS= 2.357
VS= 2.082
GS= 2.787

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.103	.970	.796
MINIMUM X	:	-1.254	-1.387	-.969
MAXIMUM Y	:	1.206	.622	.632
MINIMUM Y	:	-.876	-.742	-.732
CENTROID X	:	.273	.406	.580
CENTROID Y	:	.629	.495	.485
POA TO CENTROID in.	:	.686	.641	.756
MIN RADIUS	:	.136	.128	.248
MEAN RADIUS	:	.865	.741	.646
MAX RADIUS	:	1.704	1.390	1.214
HORIZONTAL SPREAD	:	2.357	2.357	1.765
VERTICAL SPREAD	:	2.082	1.364	1.364
EXTREME SPREAD	:	2.787	2.377	1.900
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	



CONTRACT # DAAA21-87-C-0086

NEW BBL

GUN SERIAL # C6587645

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		10/24/90	KL
600	Proof		10/24/90	KL
607	Check Headspace		10/24/90	KL
610	Dis-assemble Gun		10/24/90	KL
612	Magnaflux Barrel Action		10/30/90	KR
	Magnaflux Bolt		11	KR
615	Rollmark Caliber		11	KR
617	Drill and Tap Sight Holes		11/6/90	RB
618	Polish Barrel RB		11/7/90	RB
620	Apply Coatings (Barrel Action)		11-26-90	KL
	Apply Coating (Bolt)			KL
625	Final Assembly A) Clean inside of Bolt Assembly		11/30/90	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		11/30/90	KS
	C) Inspect Ejector Hole for Chamfer		11/30/90	KS
	D) Oil Firing Pin Ass'y		11/30/90	KS
	E) Adjust Trigger Pull to Min Setting and Stake		12/3/90	KL

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			12/3/90	WB
	G) Safety Off Force	2½	2½	2½			12/3/90	WB
	H) Trigger Pull Test & Retainability						12/3/90	
	I) Firing Pin Indent	.0215	.021	.021			12/3/90	WB
	J) Assemble Stock						12/3/90	KS
	K) Assemble Swivel Studs						12-5-90	
	L) Attach Front and Rear Sight Assemblies						12/3/90	KS
	M) Iron Sight Alignment						12/3/90	KS
	N) Detach Front & Rear Sights & place in numbered container						12/3/90	KS
	O) Attach Scope to Rifle						12/3/90	KS
	P) Detach & Attach Scope 20 Times						12/3/90	KS
640	Gallery Target & Test						12-4-90	AC
	A) Time						12-4-90	AC
	B) Malfunctions						12-4-90	AC
	C) Pierced Primers						12-4-90	AC
	D) Optical Clearity of Scope						12-4-90	AC
645	Inspect for Live Ammo						12-4-90	AC
655	Final Inspection A) Headspace						12-5-90	
	B) Trigger Pull	237	239	240	239	238	12-5-90	
	C) Function						12-5-90	
660	Pack						12/19/90	

SWS TRIGGER PULL TEST

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

SERIAL NO C6587K45

DATE 12-3-90

TESTER

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.42	2.32	2.31	2.37	MIN. SETTING,
PULL #2	2.41	2.40	2.34	2.39	NO AVG. OF 5
PULL #3	2.37	2.33	2.36	2.40	READINGS ACCEPT-
PULL #4	2.40	2.38	2.34	2.39	ABLE LESS THAN 2#
PULL #5	2.46	2.28	2.37	2.38	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.50	3.46		
PULL #2	3.46	3.43		
PULL #3	3.48	3.46		
PULL #4	3.35	3.46		
PULL #5	3.38	3.40		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.22	4.40		4.30
PULL #2	4.48	4.40		4.21
PULL #3	4.27	4.43		4.30
PULL #4	4.35	4.33		4.28
PULL #5	4.49	4.39		4.30
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6587645
4 Dec 1990

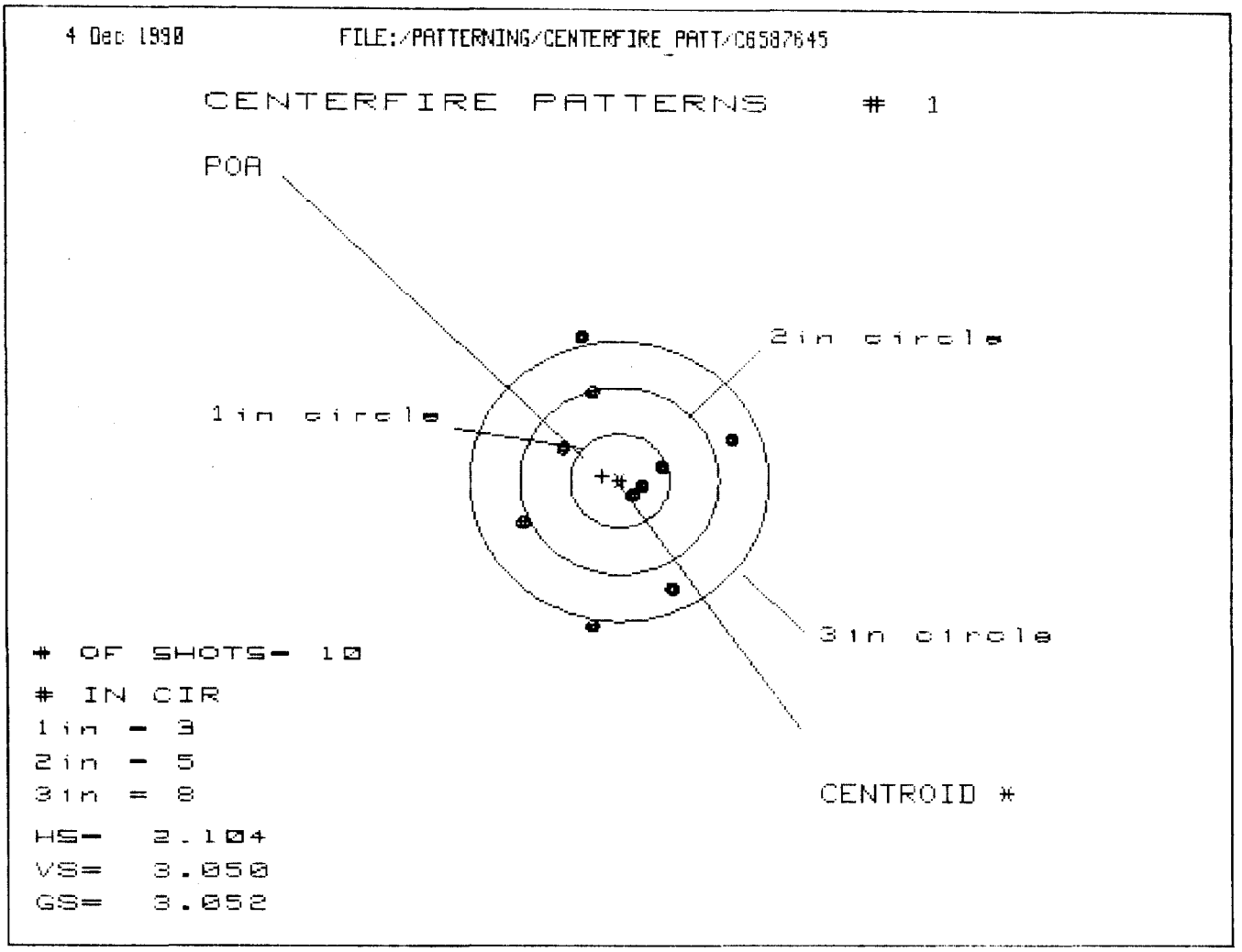
CENTROIDAL DISTANCES

0	TO	1	.178572
1	TO	2	.222767
1	TO	3	.0668506
1	TO	4	.193259
1	TO	5	.489477

5 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .04
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1122
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .119117

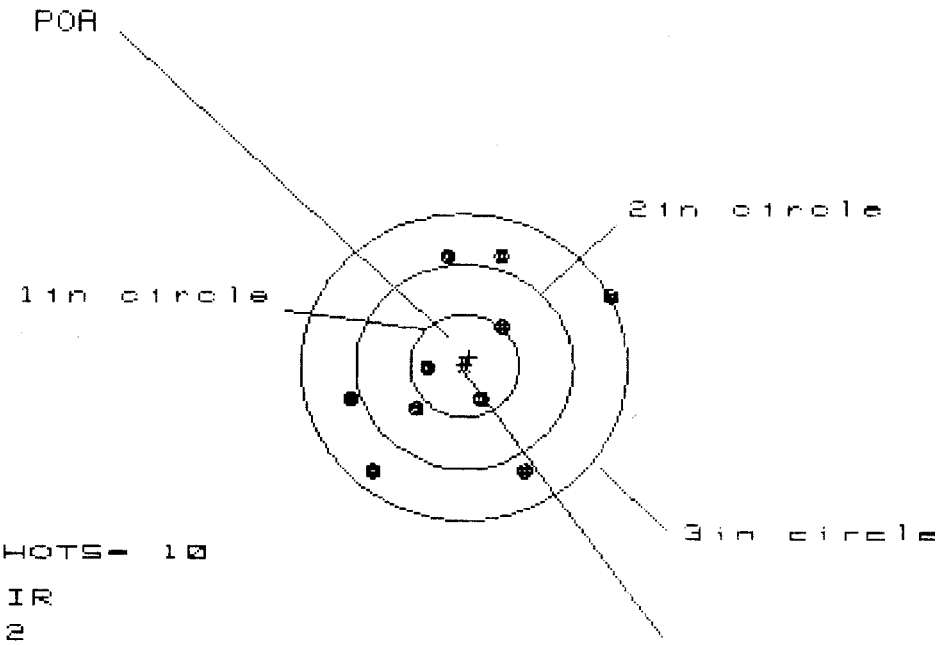
THE AMR FOR THIS RIFLE IS: .8782



PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.149	1.107	1.067
MINIMUM X	:	-.955	-.997	-1.037
MAXIMUM Y	:	1.524	1.071	.902
MINIMUM Y	:	-1.526	-1.357	-1.139
CENTROID X	:	.172	.214	.254
CENTROID Y	:	-.048	-.217	-.048
POA TO CENTROID in.	:	.178	.305	.259
MIN RADIUS	:	.240	.130	.159
MEAN RADIUS	:	.917	.835	.740
MAX RADIUS	:	1.571	1.394	1.210
HORIZONTAL SPREAD	:	2.104	2.104	2.104
VERTICAL SPREAD	:	3.050	2.428	2.041
EXTREME SPREAD	:	3.052	2.433	2.288
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

4 Dec 1990 FILE:/PATTERNING/CENTERFIRE_PATT/C6587645

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

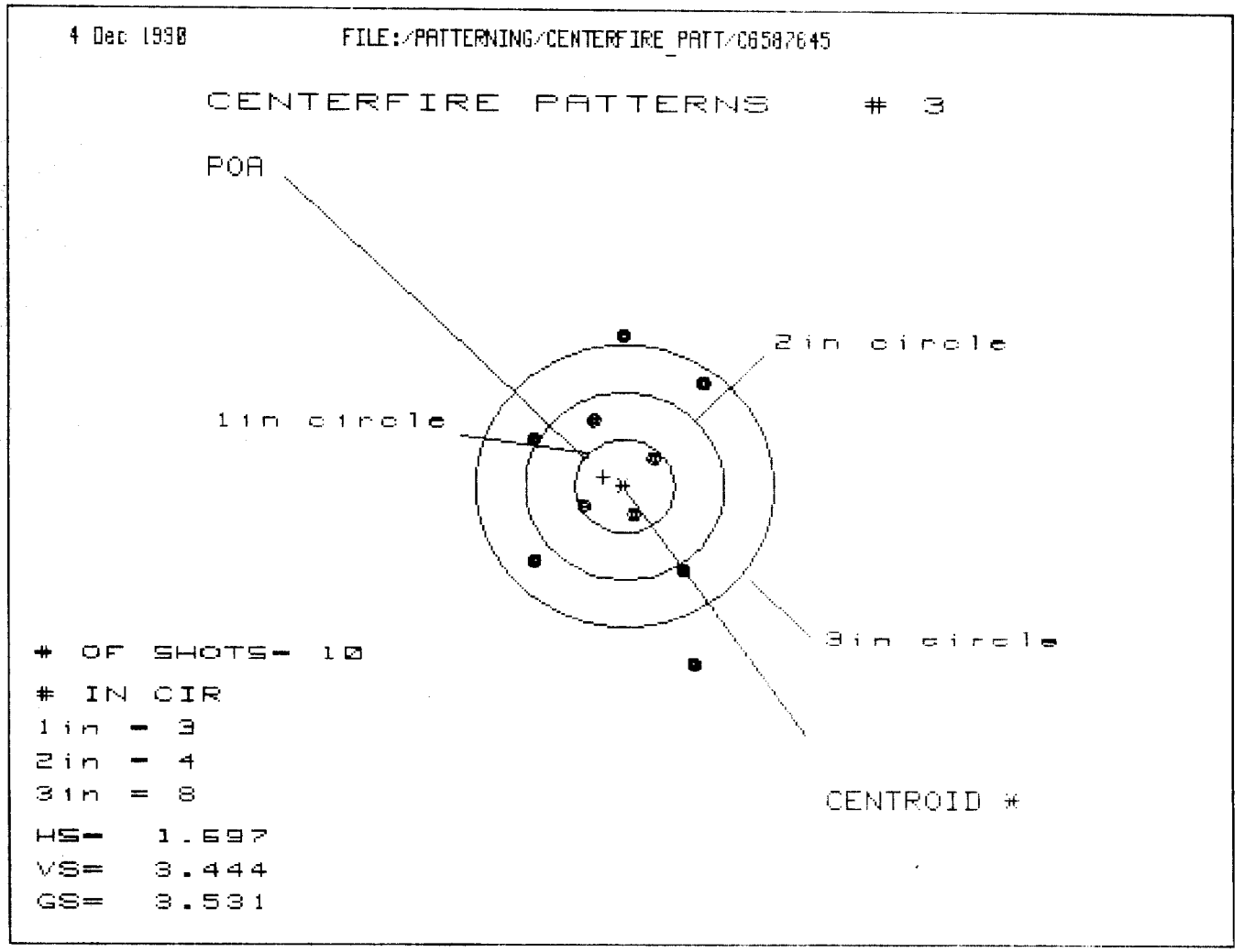
# IN CIR
1in = 2
2in = 4
3in = 9

HS= 2.399
VS= 2.150
GS= 2.719

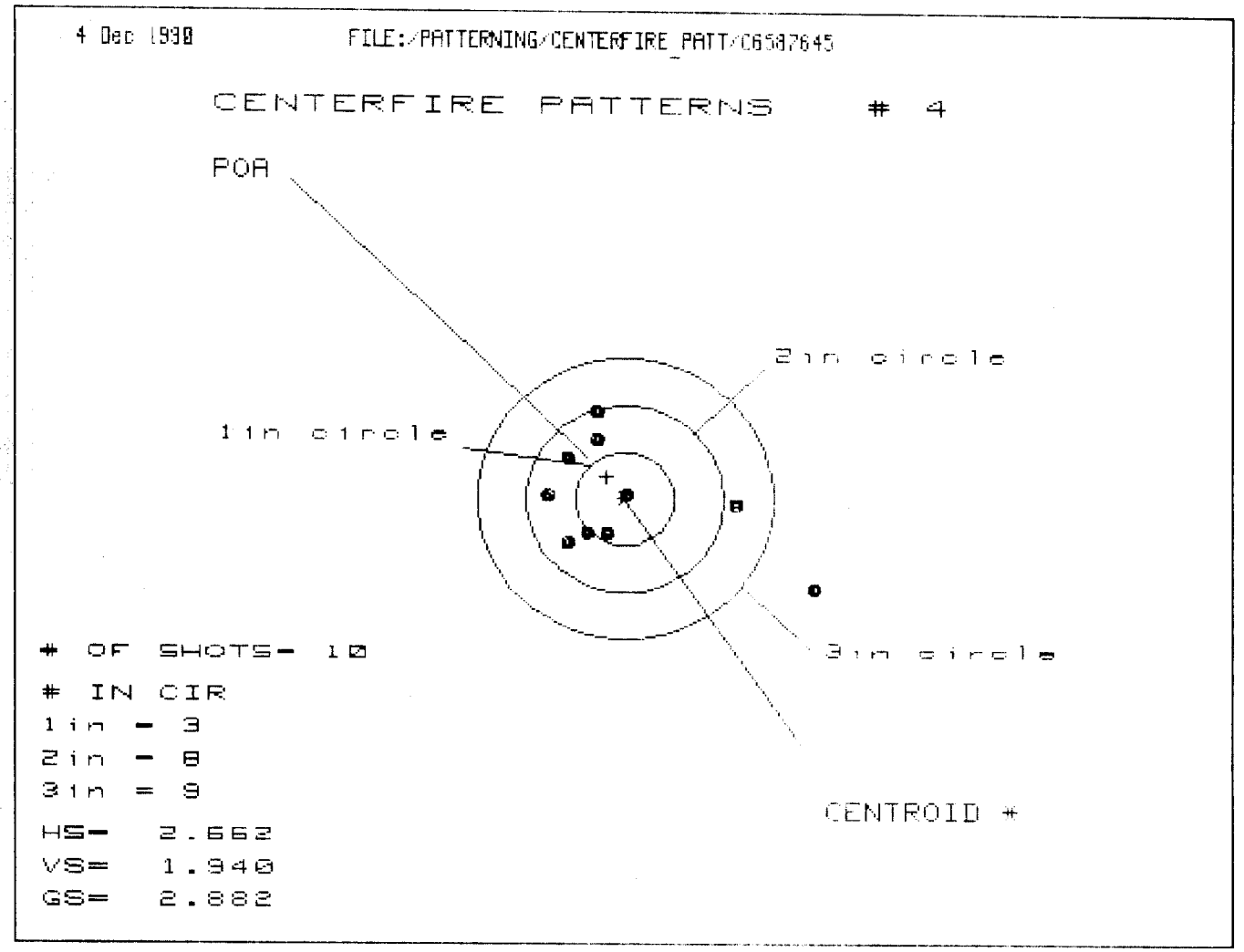
PATTERN # : [redacted]

SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.361	.658	.576
MINIMUM X	:	-1.038	-.886	-.968
MAXIMUM Y	:	1.100	1.174	1.062
MINIMUM Y	:	-1.050	-.976	-1.088
CENTROID X	:	-.048	-.200	-.118
CENTROID Y	:	-.083	-.157	-.045
POA TO CENTROID in.	:	.096	.254	.127
MIN RADIUS	:	.319	.163	.263
MEAN RADIUS	:	.916	.822	.794
MAX RADIUS	:	1.519	1.265	1.231
HORIZONTAL SPREAD	:	2.399	1.544	1.544
VERTICAL SPREAD	:	2.150	2.150	2.150
EXTREME SPREAD	:	2.719	2.360	2.244

NUMBER IN ONE INCH CIRCLE = 2
NUMBER IN TWO INCH CIRCLE = 4
NUMBER IN THREE INCH CIRCLE = 9



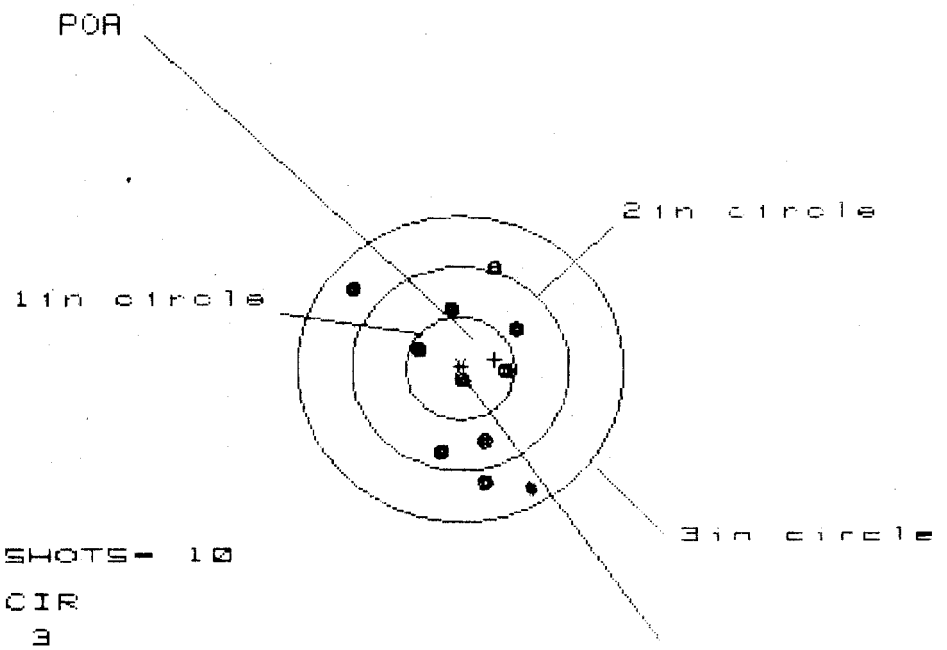
PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.786	.866	.869
MINIMUM X	:	-.911	-.831	-.828
MAXIMUM Y	:	1.581	1.374	1.098
MINIMUM Y	:	-1.863	-1.140	-.968
CENTROID X	:	.210	.130	.127
CENTROID Y	:	-.103	.104	-.068
POA TO CENTROID in.	:	.234	.166	.144
MIN RADIUS	:	.324	.422	.390
MEAN RADIUS	:	1.021	.903	.826
MAX RADIUS	:	1.998	1.374	1.400
HORIZONTAL SPREAD	:	1.697	1.697	1.697
VERTICAL SPREAD	:	3.444	2.514	2.066
EXTREME SPREAD	:	3.531	2.585	2.563
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	



PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.876	1.324	.393
MINIMUM X	:	-.786	-.578	-.412
MAXIMUM Y	:	.953	.844	.818
MINIMUM Y	:	-.987	-.555	-.581
CENTROID X	:	.182	-.026	-.192
CENTROID Y	:	-.241	-.132	-.106
POA TO CENTROID in.	:	.302	.134	.219
MIN RADIUS	:	.055	.234	.401
MEAN RADIUS	:	.815	.632	.526
MAX RADIUS	:	2.120	1.340	.827
HORIZONTAL SPREAD	:	2.662	1.902	.805
VERTICAL SPREAD	:	1.940	1.399	1.399
EXTREME SPREAD	:	2.882	1.906	1.432
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	

4 Dec 1990 FILE:/PATTERNING/CENTERFIRE_PATT/C6587645

CENTERFIRE PATTERNS # 5



# OF SHOTS= 10
# IN CIR
1in = 3
2in = 7
3in = 10
HS= 1.471
VS= 2.114
GS= 2.270

PATTERN # : [redacted]

SHOTS (BEST OF) :	10	9	8
MAXIMUM X :	.534	.430	.439
MINIMUM X :	-.937	-.514	-.505
MAXIMUM Y :	.963	1.055	.922
MINIMUM Y :	-1.151	-1.059	-.871
CENTROID X :	-.316	-.212	-.221
CENTROID Y :	-.086	-.178	-.045
POA TO CENTROID in.:	.328	.277	.226
MIN RADIUS :	.151	.100	.203
MEAN RADIUS :	.722	.648	.595
MAX RADIUS :	1.249	1.083	.956
HORIZONTAL SPREAD :	1.471	.944	.944
VERTICAL SPREAD :	2.114	2.114	1.793
EXTREME SPREAD :	2.270	2.121	1.884
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		10	

RECEIVING AND ESTIMATING REPORT

COMMENTS: WOG 15 OF 30 W/10X SCOPE & DEPLOYMENT KIT M-24

ORDER: R 93-02466

INITIAL	CUSTOMER ORDER NO.
FPS	

DATE RECEIVED	DATE OPENED	DATE CODE	SERIAL NUMBER	NEW SERIAL NUMBER	MODEL AND GRADE
01/25/93	01/25/93	RK 11-90	C6587645		700 7-62 NATO

ACCESSORIES: W/STUDS W/SWIVELS SOFT CASE SCOPE BASE

FROM:

MCHALE; EDWARD J CPT;SF
HSC 3RD BN 3RD SFG (A)
FT BRAGG NC 28307

SHIP TO:

MCHALE; EDWARD J CPT;SF
HSC 3RD BN 3RD SFG (A)
FT BRAGG NC 28307

CUST NO:073985 C.O.D

ACCOUNT NUMBER	ACCOUNT NUMBER N/C	WRITE ☐ CLEAN/TEST	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			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: Rust on Gun

PARTS

Magazine Spring - 15677
magazine - 96013
Firing pin Assy - 96007
Trigger Assy - 96024
Front Guard Screw - 96010
Rear Guard Screw - 96015
Barrel Assy Complete - 96001
Front Sight Assy - 96118
Rear Sight Assy - 96119

COMMENTS

Zinc Phosphate Scope Base, Scope Rings Swivels & Swivel Studs Re-powder Coat Floor plate & latch, Trigger Guard & Front & Rear Sight Bases

REPAIRMAN	PROOF	CLEAN	TEST	TARGET	PATTERN
RW	✓	✓	✓	✓	
GALLERY TESTER	**DATE**	**DATE**	**DATE**	**DATE**	**DATE**
RW	2/4/93	2/11/93	3/1/93	3/1/93	

OFFICE COPY

RD6925 REV. 1/92