

C6587646

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

RIFLE REPAIR
+ D-KIT & SLING
ONLY

FN

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: RE00146679

Serial: C6587646 Model M24 SWS Center Fire
Caliber: 7.62 NATO

Repairman:

Status:

Closed 6/20/2008 8:51:19 AM

Verify Repair

Address Information

Customer:

☒ Received From

Return To:

☐ Received From

Name: DEPT OF THE ARMY

DEPT OF THE ARMY

Address 1: HEADQUARTERS AND HEADQUARTERS CO

HEADQUARTERS AND HEADQUARTERS CO

Address 2: 1ST BN 5TH INFANTRY

PO Box:

1ST BN 5TH INFANTRY

PO Box:

City: FORT WRAINWRIGHT

FORT WRAINWRIGHT

State: AK

Zip Code: 99703

Country: US

State: AK

Zip Code: 99703

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
A010	Hard Case	1
D000	SCOPE & SCOPE BAS	1

Repair Search

Refresh

Close

nagletj

6/20/2008

9:09 AM

CAPS

NUM

INS

SCPL

Number: C6587646

Model: M24 SWS



RE00146679

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6587646.___0
FILE DATE AND TIME: 07/18/2008 12:30

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.032
The Average Y Centroid of the Five Target Set:	-0.066
The Average Point of Impact of the Five Target Set:	0.073
The Average Mean Radius of the Five Target Set:	0.694
The Distance from POA to Centroid Target #1:	0.232
The Distance from Centroid Target #2 to Centroid Target #1:	0.367
The Distance from Centroid Target #3 to Centroid Target #1:	0.141
The Distance from Centroid Target #4 to Centroid Target #1:	0.221
The Distance from Centroid Target #5 to Centroid Target #1:	0.249

SERIAL NUMBER: C6587646. __0

TARGET NUMBER: 1

FILE DATE: 07/18/2008

FILE TIME: 12:30

POINT#	X	Y
1:	0.698	0.315
2:	0.287	0.330
3:	-0.549	0.501
4:	0.705	-0.520
5:	0.331	-0.908
6:	0.289	-0.293
7:	0.354	-0.202
8:	0.216	-0.026
9:	-0.210	-0.463
10:	-0.387	-0.277

X CENTROID: 0.173

Y CENTROID: -0.154

POA TO CENTROID: 0.232

HORZ SPREAD: 1.254

VERT SPREAD: 1.409

GROUP SPREAD: 1.661

MIN RADIUS: 0.135

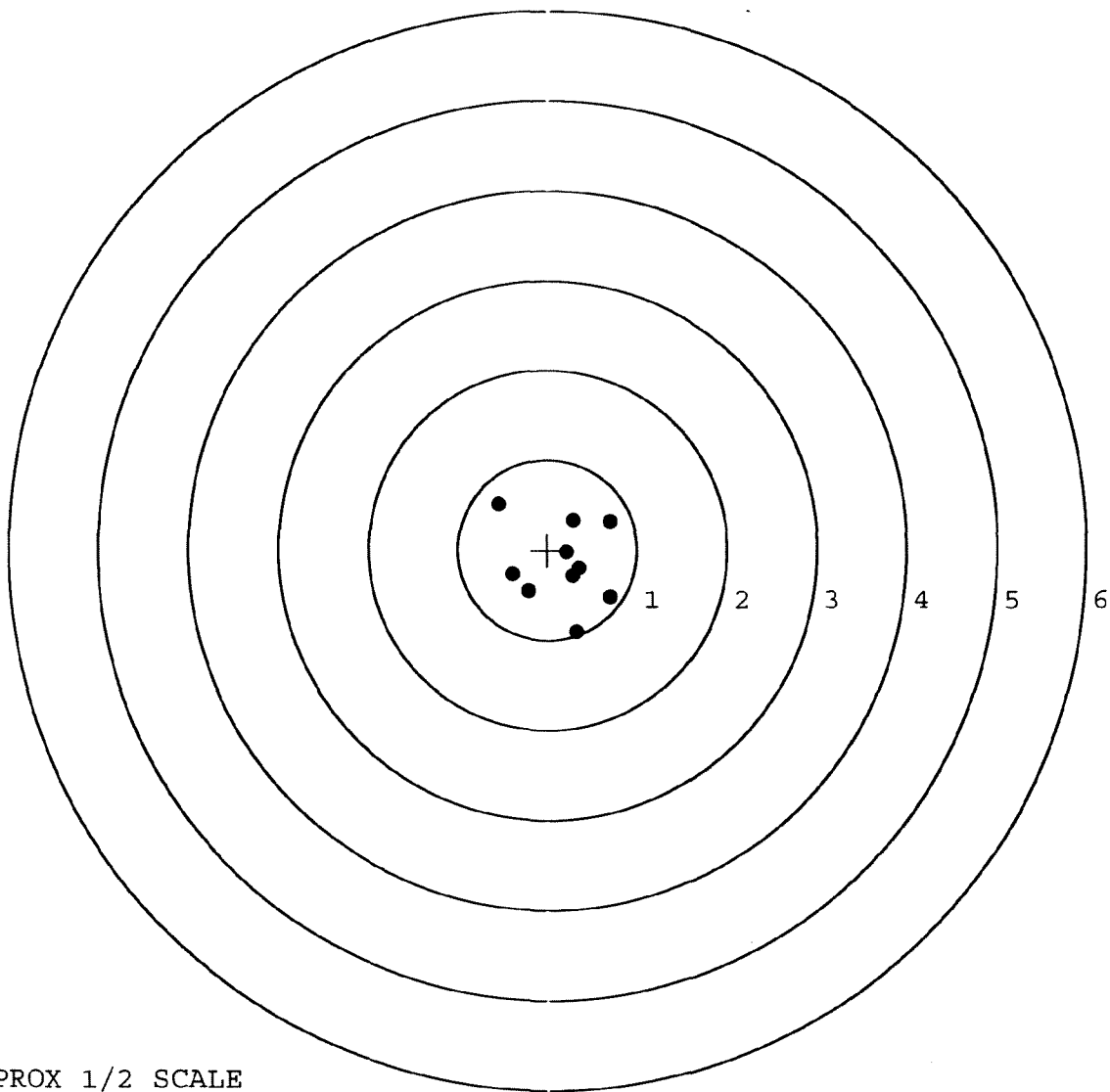
MAX RADIUS: 0.975

MEAN RADIUS: 0.516

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6587646. 0

TARGET NUMBER: 2

FILE DATE: 07/18/2008

FILE TIME: 12:30

POINT#	X	Y
1:	1.002	-0.166
2:	0.735	-0.401
3:	-0.137	-0.542
4:	-0.272	-0.675
5:	0.148	0.200
6:	-0.276	0.107
7:	-0.176	0.588
8:	-0.402	0.746
9:	-0.033	0.248
10:	0.106	1.876

X CENTROID: 0.070

Y CENTROID: 0.198

POA TO CENTROID: 0.210

HORZ SPREAD: 1.404

VERT SPREAD: 2.551

GROUP SPREAD: 2.579

MIN RADIUS: 0.079

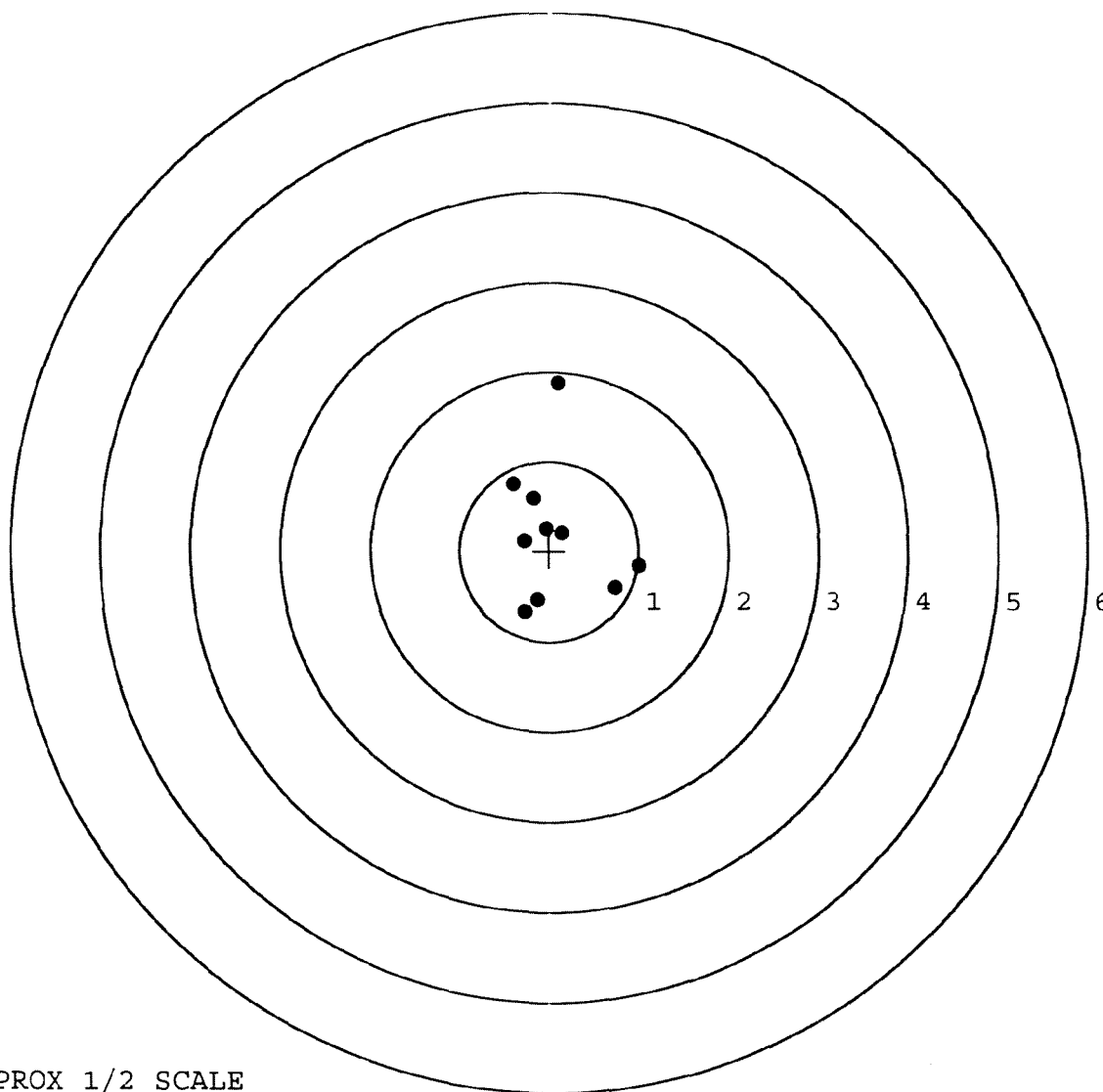
MAX RADIUS: 1.678

MEAN RADIUS: 0.701

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6587646. __0

TARGET NUMBER: 3

FILE DATE: 07/18/2008

FILE TIME: 12:30

POINT#	X	Y
1:	0.517	0.555
2:	0.620	0.388
3:	0.515	1.178
4:	-0.132	0.361
5:	-0.585	0.065
6:	-0.287	-0.044
7:	-0.521	-0.296
8:	0.306	-0.699
9:	0.112	-1.198
10:	-0.208	-1.649

X CENTROID: 0.034

Y CENTROID: -0.134

POA TO CENTROID: 0.138

HORZ SPREAD: 1.205

VERT SPREAD: 2.827

GROUP SPREAD: 2.918

MIN RADIUS: 0.333

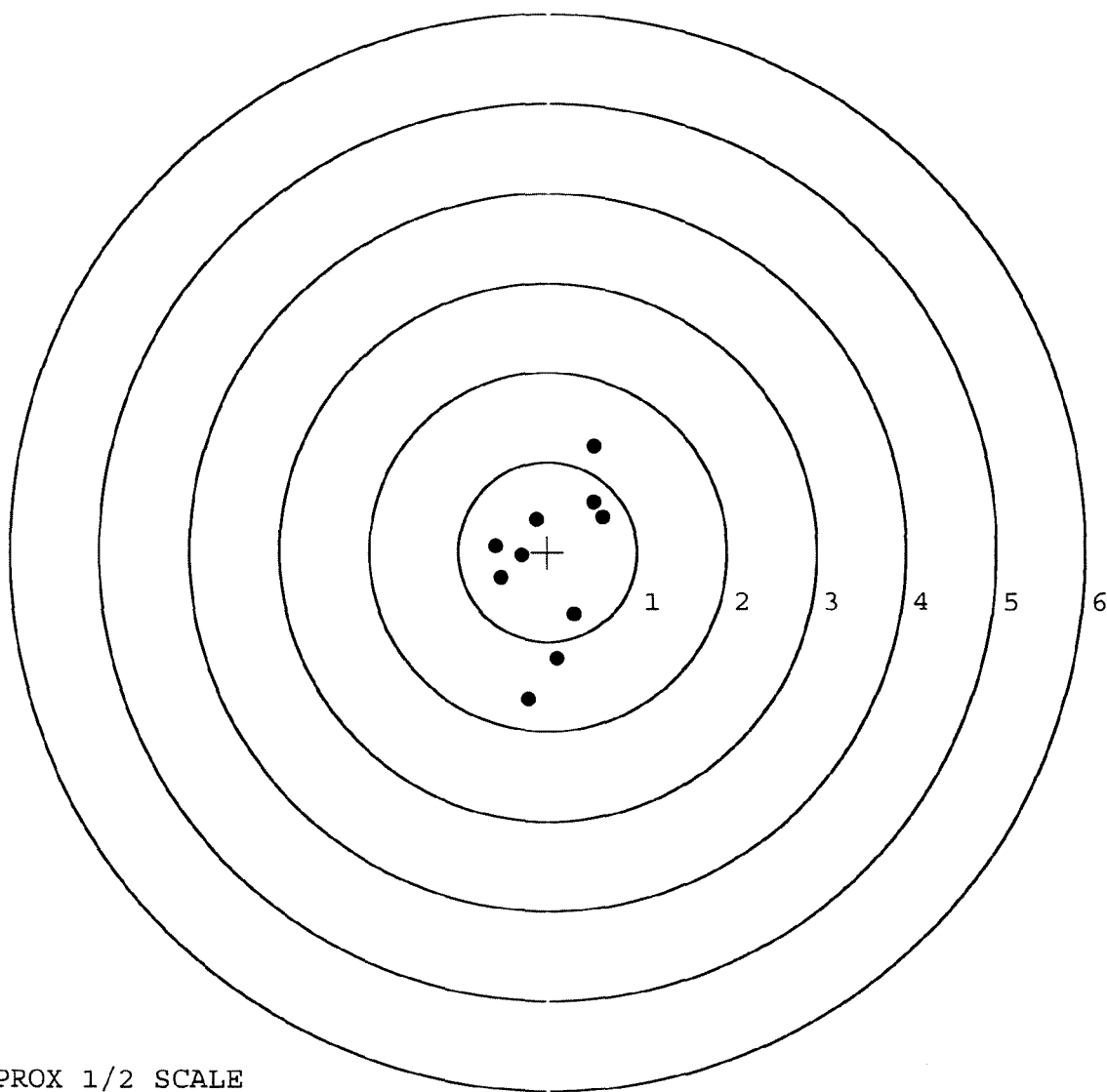
MAX RADIUS: 1.534

MEAN RADIUS: 0.834

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6587646. 0

TARGET NUMBER: 4

FILE DATE: 07/18/2008

FILE TIME: 12:30

POINT#	X	Y
1:	1.068	-0.055
2:	0.663	0.106
3:	0.192	-0.391
4:	0.302	-0.765
5:	0.106	0.335
6:	-0.164	0.364
7:	-0.280	0.666
8:	-0.604	-0.180
9:	-0.773	-0.595
10:	-0.933	-0.528

X CENTROID: -0.042

Y CENTROID: -0.104

POA TO CENTROID: 0.113

HORZ SPREAD: 2.001

VERT SPREAD: 1.431

GROUP SPREAD: 2.056

MIN RADIUS: 0.370

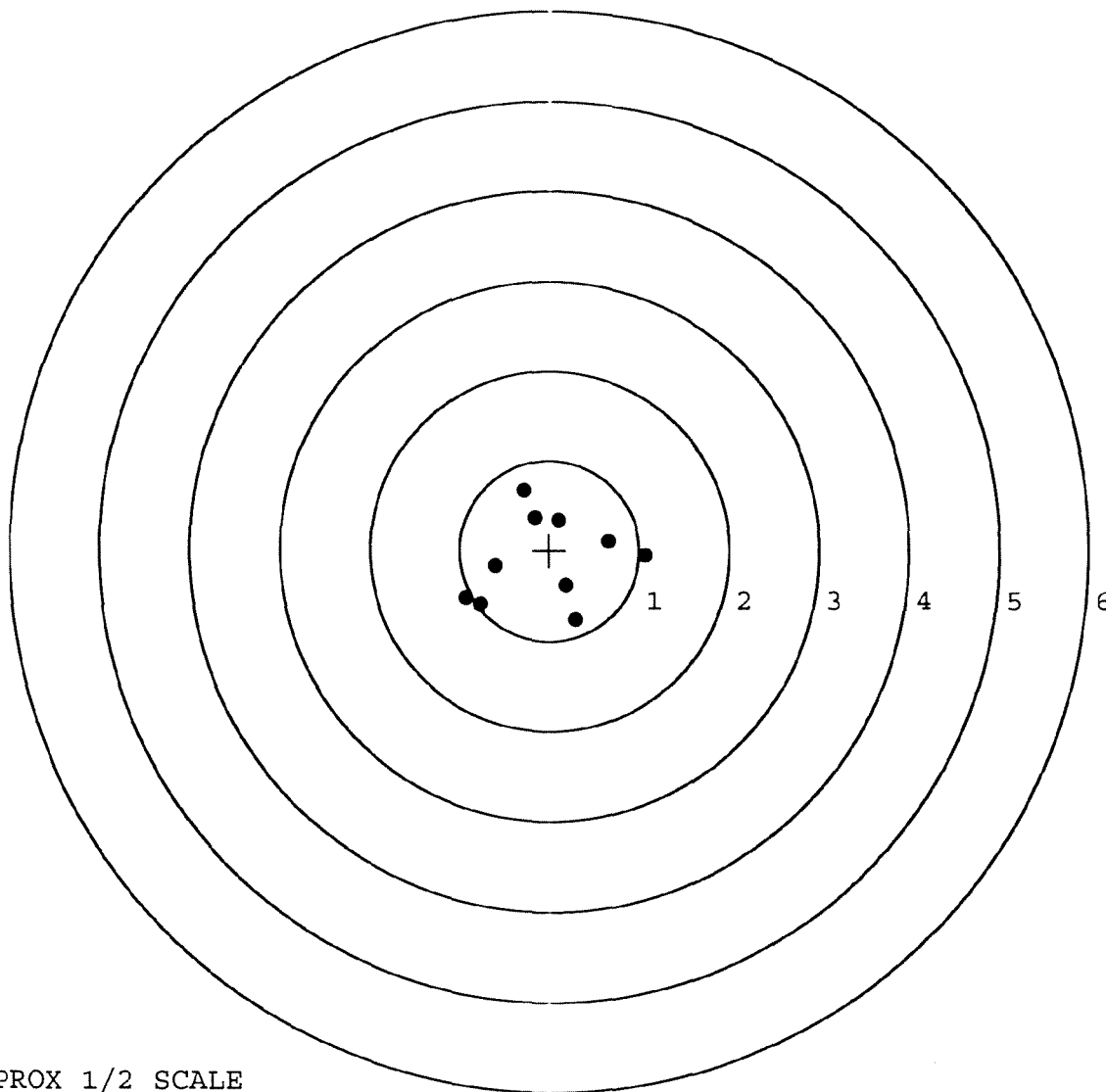
MAX RADIUS: 1.111

MEAN RADIUS: 0.715

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6587646. 0

TARGET NUMBER: 5

FILE DATE: 07/18/2008

FILE TIME: 12:30

X CENTROID: -0.075

Y CENTROID: -0.134

POA TO CENTROID: 0.153

HORZ SPREAD: 2.553

VERT SPREAD: 1.118

GROUP SPREAD: 2.560

MIN RADIUS: 0.313

MAX RADIUS: 1.411

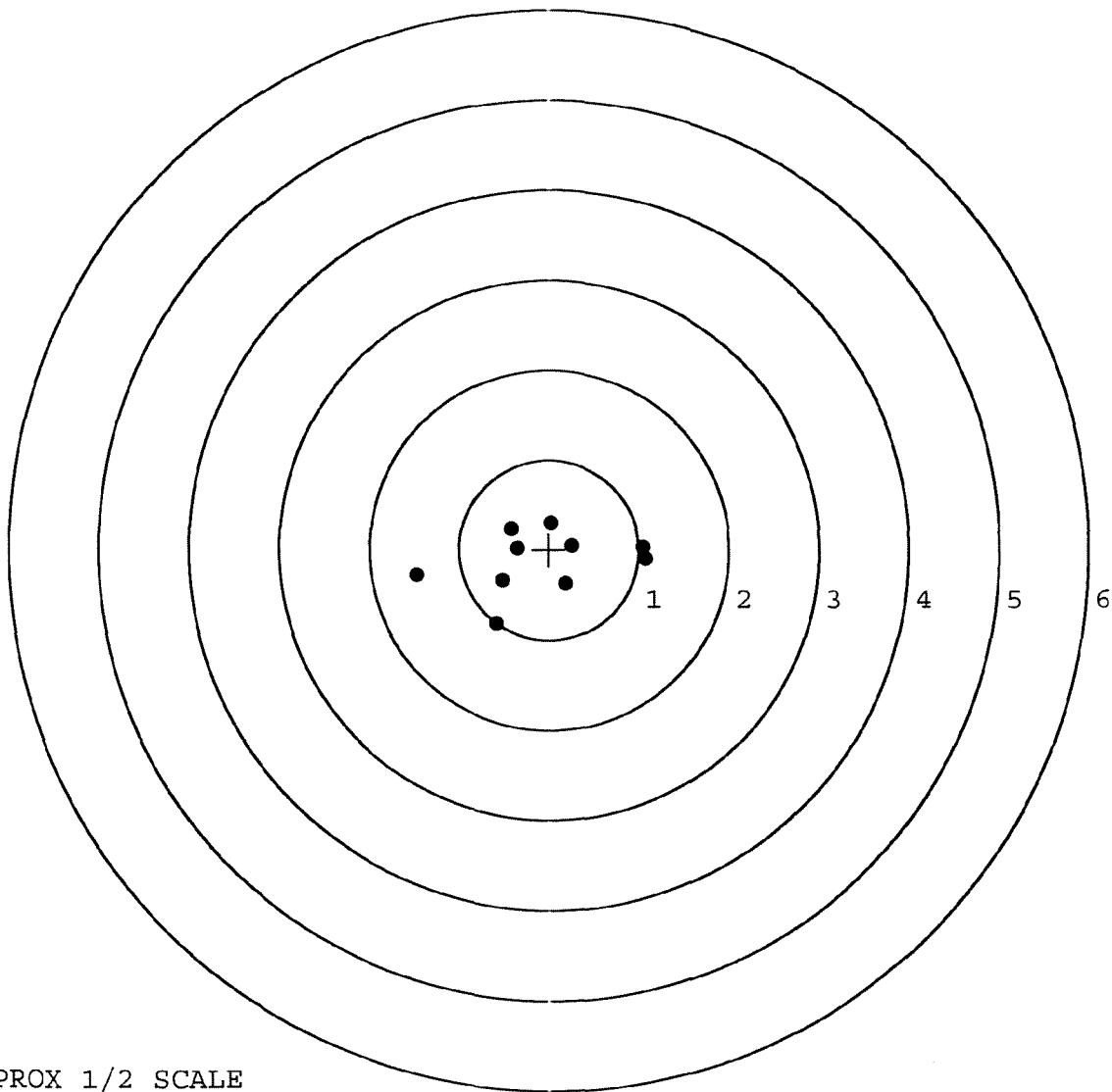
MEAN RADIUS: 0.704

IN 1 IN DIAMETER: 6

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	1.076	-0.102
2:	1.047	0.031
3:	0.188	-0.385
4:	0.264	0.041
5:	0.023	0.294
6:	-0.416	0.227
7:	-0.349	0.018
8:	-0.516	-0.343
9:	-0.592	-0.824
10:	-1.477	-0.293



TARGET APPROX 1/2 SCALE

INSPECTION CHECKLIST - REPAIRS
CONTRACT #: W52H09-07-C-0207

R & E NUMBER	146679		
SERIAL NUMBER	C6587646		
LOG-IN DATE	6-25-08 6-20-08		

OPERATION #	OPERATION NAME	DATE	INITIAL
500	DIS-ASSEMBLE GUN	6-25-08	RSW
505	RE-BARREL	6-25-08	RSW
420	ASSEMBLE	6-25-08	RSW
440	PROOF	6-25-08	SD
460	CHECK HEADSPACE	6-25-08	SD
470	DIS-ASSEMBLE GUN	6-25-08	RP
480	MAGNAFLUX	7-10-08	BA
510	DRILL AND TAP	7-7-08	TRW
500	ROLLMARK CALIBER	7/9/08	RT
520	GOFF BLAST BBL / REC	7/11/08	DG
530 & 540	APPLY COATINGS	7-15	CV
560	FINAL ASSEMBLY	7-17-08	RTZ
640	FUNCTION TEST AND	7-18-08	TRW
650	TARGET	7-18-08	TRW
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
670	FINAL INSPECTION	7/18/08	MEH
	A) HEADSPACE	7-21-08	RTZ
	B) TRIGGER PULL	7-21-08	RTZ
		280 291 283 261 270	
680	F) SAFETY ON FORCE	7-21-08	RTZ
		425 425 425	
	G) SAFETY OFF FORCE	7-21-08	RTZ
		2 2 2	
	I) FIRING PIN INDENT	7-21-08	RTZ
		.023 .023 .023	
690	PACK	7/23/08	EM

F006 REV 5/2006

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: **RE00092887** Serial: C6587646 Model: M24SWS Center Fire
 Caliber: 7.62 NATO Produced: 12/13/1990

Repairman: Status: Closed 2/10/2005 11:38:37 AM

Verify Repair: [REDACTED]

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: 36201 4199 Country: US State: AL Zip Code: 36201 4199 Country: US

FBI: [REDACTED]

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
A037	With Stud	3
A010	Hard Case	1
A017	Scope Base	1
A028	Scope	1
A037	Fit and Rear Sgt Base	1

Repair Search Refresh Close

regal 2/14/2005 9:21 AM CAPS INUM INS SCPL

start 5 2 4 Arms Services

Serial Number: **C6587646**

Model: **M24 SWS**



RE00092887

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6587646.__0
FILE DATE AND TIME: 06/22/2005 08:33

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.023
The Average Y Centroid of the Five Target Set:	-0.026
The Average Point of Impact of the Five Target Set:	0.035
The Average Mean Radius of the Five Target Set:	0.860
The Distance from POA to Centroid Target #1:	0.137
The Distance from Centroid Target #2 to Centroid Target #1:	0.158
The Distance from Centroid Target #3 to Centroid Target #1:	0.288
The Distance from Centroid Target #4 to Centroid Target #1:	0.169
The Distance from Centroid Target #5 to Centroid Target #1:	0.409

SERIAL NUMBER: C6587646. 0

TARGET NUMBER: 1

FILE DATE: 06/22/2005

FILE TIME: 08:33

POINT#	X	Y
1:	0.927	-0.461
2:	0.485	-0.510
3:	0.082	-0.559
4:	0.356	0.758
5:	0.095	0.702
6:	0.260	0.487
7:	-0.044	0.077
8:	-0.268	0.232
9:	-0.455	0.048
10:	-0.278	-0.045

X CENTROID: 0.116

Y CENTROID: 0.073

POA TO CENTROID: 0.137

HORZ SPREAD: 1.382

VERT SPREAD: 1.317

GROUP SPREAD: 1.473

MIN RADIUS: 0.160

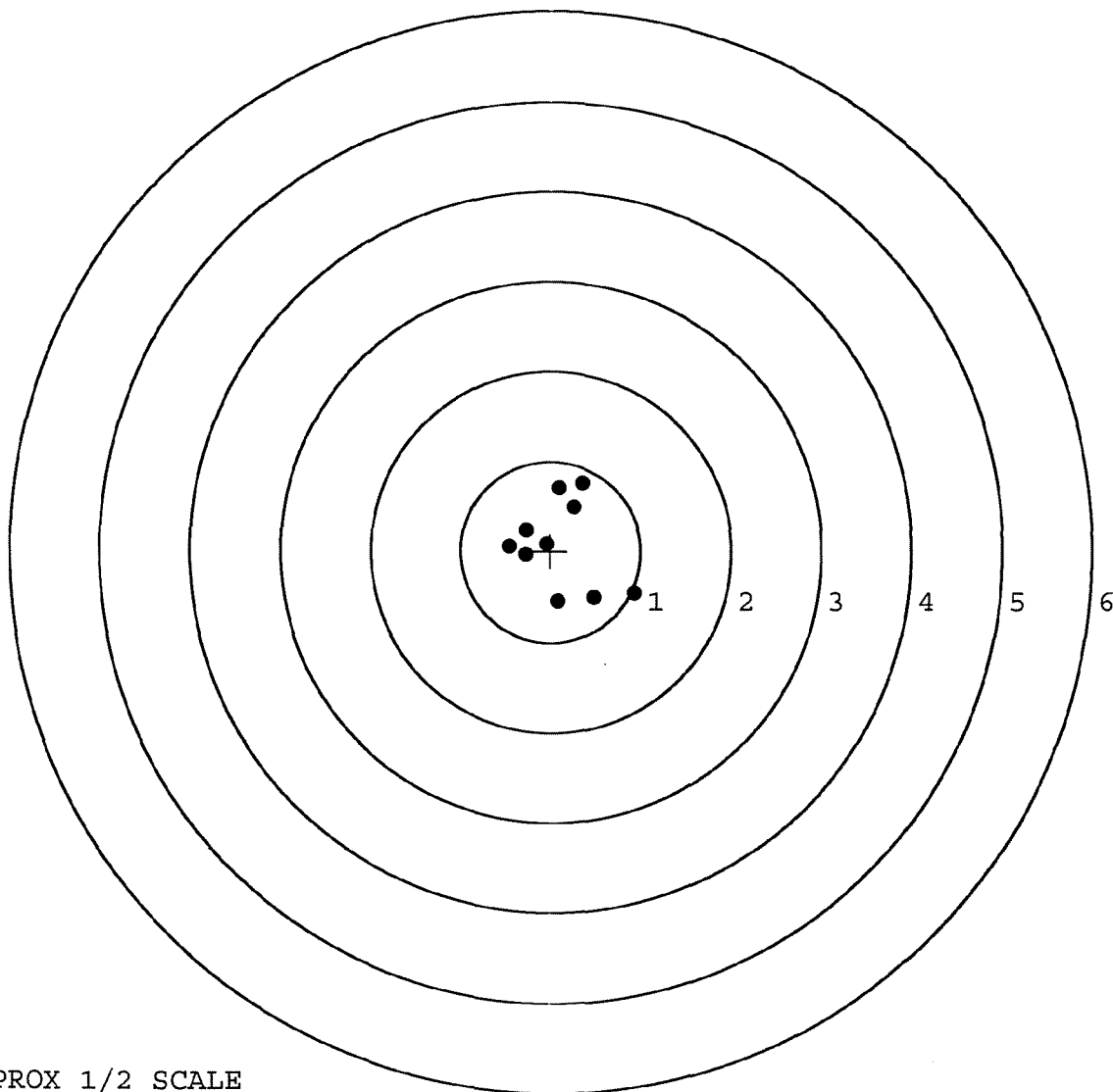
MAX RADIUS: 0.971

MEAN RADIUS: 0.565

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6587646. __0

TARGET NUMBER: 2

FILE DATE: 06/22/2005

FILE TIME: 08:33

POINT#	X	Y
1:	1.262	-1.130
2:	1.132	0.489
3:	0.983	1.612
4:	0.261	1.352
5:	0.474	0.256
6:	-0.006	0.259
7:	-0.530	-0.017
8:	-0.304	-0.186
9:	0.007	-0.656
10:	-0.650	-0.657

X CENTROID: 0.263

Y CENTROID: 0.132

POA TO CENTROID: 0.294

HORZ SPREAD: 1.912

VERT SPREAD: 2.742

GROUP SPREAD: 2.796

MIN RADIUS: 0.245

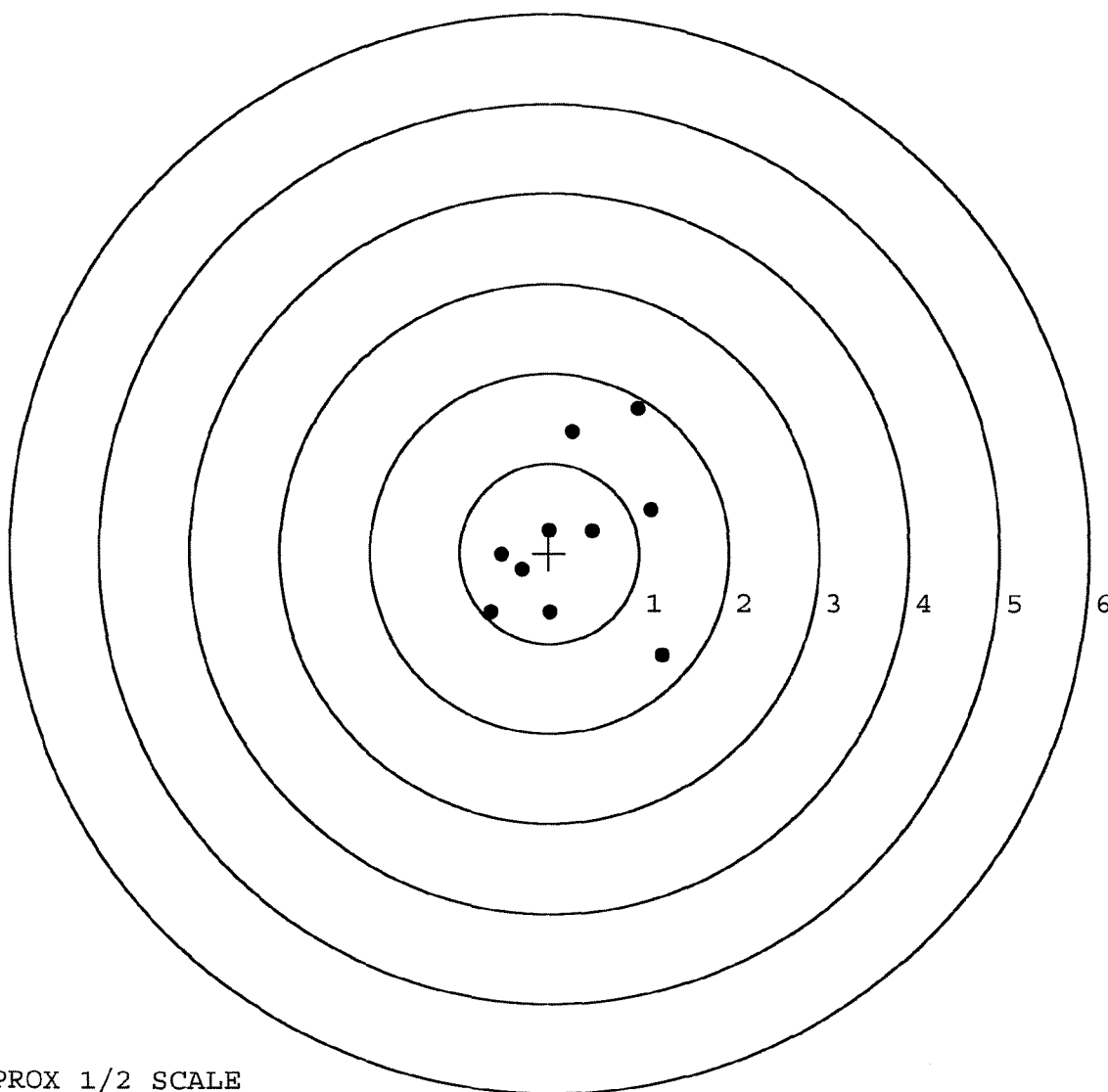
MAX RADIUS: 1.646

MEAN RADIUS: 0.945

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 8



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6587646.___0

TARGET NUMBER: 3

FILE DATE: 06/22/2005

FILE TIME: 08:33

POINT#	X	Y
1:	1.214	-0.966
2:	0.210	-0.400
3:	0.725	0.228
4:	0.126	0.667
5:	-0.218	0.283
6:	-0.905	-0.331
7:	-0.395	-1.291
8:	-0.024	-1.806
9:	-0.786	1.316
10:	-1.045	1.245

X CENTROID: -0.110

Y CENTROID: -0.106

POA TO CENTROID: 0.152

HORZ SPREAD: 2.259

VERT SPREAD: 3.122

GROUP SPREAD: 3.217

MIN RADIUS: 0.403

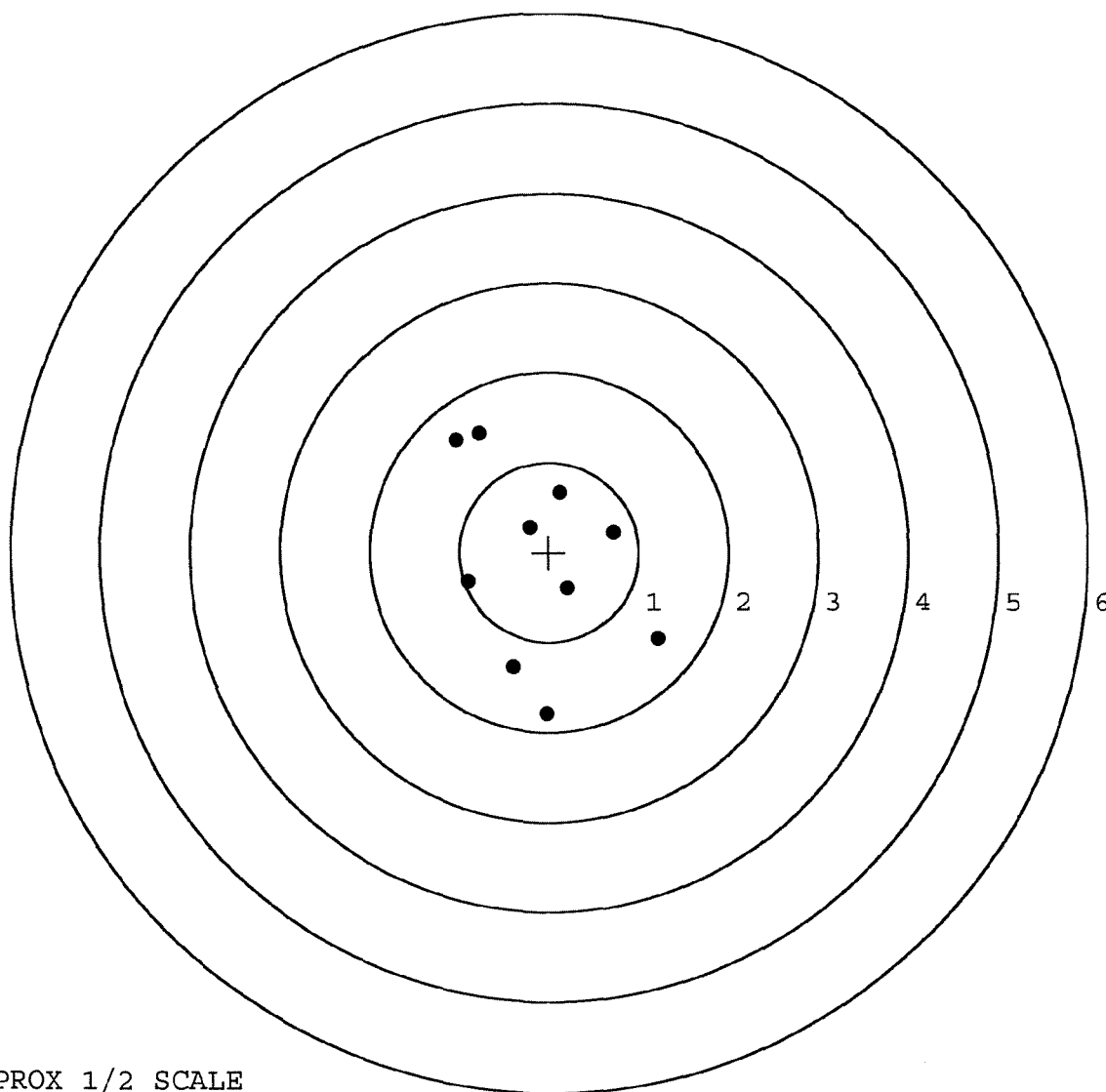
MAX RADIUS: 1.703

MEAN RADIUS: 1.109

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 5

in 3 IN DIAMETER: 6



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6587646. 0

TARGET NUMBER: 4

FILE DATE: 06/22/2005

FILE TIME: 08:33

POINT#	X	Y
1:	0.822	0.027
2:	0.446	-0.843
3:	0.061	0.854
4:	-0.043	0.695
5:	-0.518	0.477
6:	0.185	-0.103
7:	-0.396	-0.257
8:	0.184	-0.425
9:	-0.024	-0.565
10:	0.115	-0.784

X CENTROID: 0.083

Y CENTROID: -0.092

POA TO CENTROID: 0.124

HORZ SPREAD: 1.340

VERT SPREAD: 1.697

GROUP SPREAD: 1.740

MIN RADIUS: 0.102

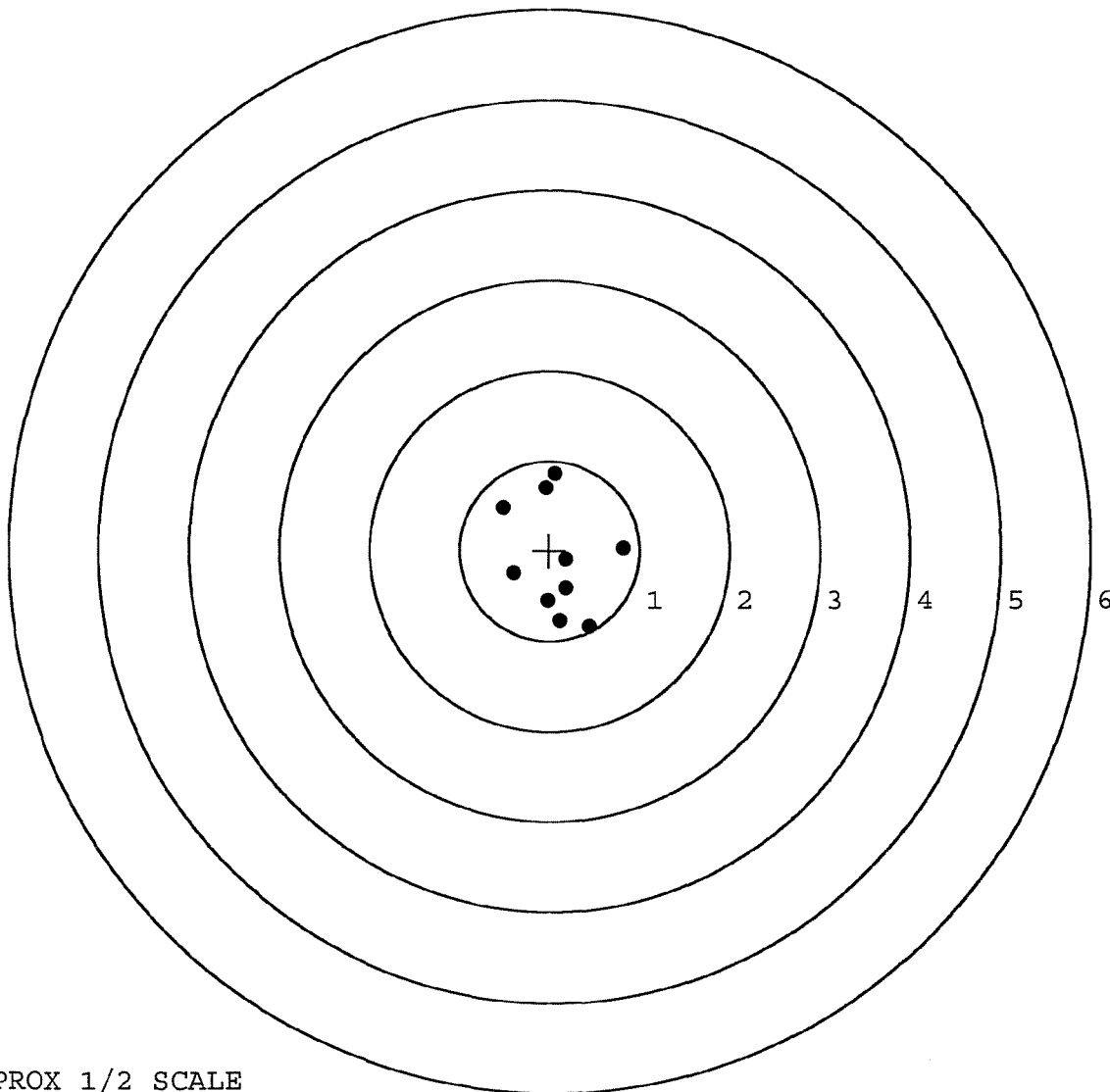
MAX RADIUS: 0.947

MEAN RADIUS: 0.629

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10

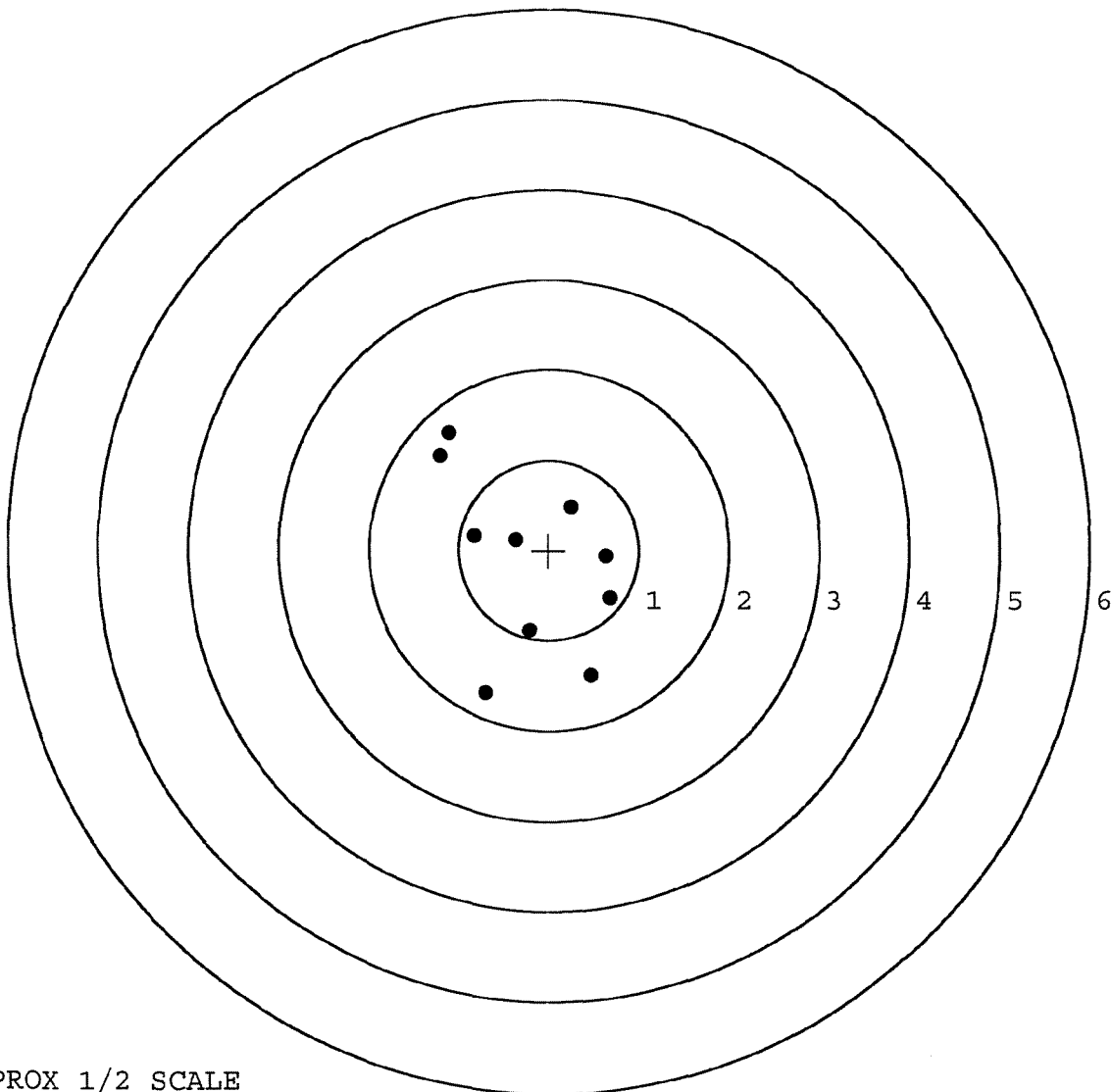


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6587646. __0
TARGET NUMBER: 5
FILE DATE: 06/22/2005
FILE TIME: 08:33

X CENTROID: -0.236
Y CENTROID: -0.136
POA TO CENTROID: 0.272
HORZ SPREAD: 1.894
VERT SPREAD: 2.883
GROUP SPREAD: 3.118
MIN RADIUS: 0.284
MAX RADIUS: 1.677
MEAN RADIUS: 1.054
IN 1 IN DIAMETER: 1
IN 2 IN DIAMETER: 5
in 3 IN DIAMETER: 7

POINT#	X	Y
1:	0.685	-0.528
2:	0.639	-0.066
3:	0.249	0.482
4:	-0.365	0.117
5:	0.477	-1.389
6:	-0.207	-0.895
7:	-0.695	-1.587
8:	-1.209	1.042
9:	-1.109	1.296
10:	-0.823	0.165



TARGET APPROX 1/2 SCALE

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

R & E NUMBER	92887				
SERIAL NUMBER	C6587646				
LOG-IN DATE	2-10-05				
INSPECT AND VERIFY:					
OPERATION #	OPERATION NAME	DATE	INITIAL		
550	DIS-ASSEMBLE GUN	X	X		
560 A	RE-BARREL				
B	DRILL AND TAP				
575	ASSEMBLE				
600	PROOF				
605	CHECK HEADSPACE				
610	DIS-ASSEMBLE GUN				
612	MAGNAFLUX				
615	ROLLMARK CALIBER				
618	ROTO-BLAST				
620	APPLY COATINGS				
625 A	FINAL ASSEMBLY				
B	TRIGGER PULL TEST				
C	SAFETY "ON" FORCE			8-9-05	AL
D	SAFETY "OFF" FORCE			8-9-05	AL
E	FIRING PIN INDENT	8-9-05	AL		
640	TARGET Test	6-22-05	TRW		
655	FINAL INSPECT	8-9-05	AL		
660	PACK	9-6-05	DA		
		SHIP DATE			
QAR INSPECTION DATE					

RECEIVING AND ESTIMATING REPORT

COMMENTS

ORDER
R 94-17159

INITIAL CUSTOMER ORDER NO.

JJM

W/10X SCOPE WOG 2 OF 2

Scope S/N 90 0644

DATE RECEIVED

DATE OPENED

DATE CODE

SERIAL NUMBER

NEW SERIAL NUMBER

MODEL AND GRADE

05/31/94

06/01/94

EK 10-90

C6587646

700 7.62

NATO

ACCESSORIES

FROM:

SHIP TO:

T O ROCK ISLAND ARESNAL
W52HIC
CMAH2W
ROCK ISLAND

IL 61299

T O ROCK ISLAND ARESNAL
W52HIC
CMAH2W
ROCK ISLANDIL
61299

CUST NO: 097998 C.O.D.

ACCOUNT NUMBER

ACCOUNT NUMBER N/C

WRITE ☐

PROM. DATE

ESTIMATED

VIA

7-23-96

UPS

GUN CONDITION

- ☐ NEW
☐ LIGHTLY WORN
☐ WORN
☐ VERY WORN
☐ UNREPAIRABLE
☐ MARRED

REPAIR CHARGE

EXCISE

TAX

INSURANCE

UPS

PARCEL POST

TOTAL

CUSTOMER CONCERN	AMMO	FUNCTION	FINISH	ACCURACY	FIT	INSPECT
------------------	------	----------	--------	----------	-----	---------

CYCLE

A1

B1

TRIGGER GROUP

B2

BOLT ASSY.

B3

BARREL ASSY.

B4

REC. ASSY.

B5

WOOD

C1

D3

METAL

C2

MAIN FAULT

PARTS

COMMENTS

NEW BARREL ✓
STOCK ✓
TRIGGER ASSY ✓
FIRING PIN ASSY ✓
MAG BOX, SPRING ✓
AND FOLLOWER ✓
Front & Rear Sight Assy

REPAIRMAN

PROOF

CLEAN

TEST

TARGET

PATTERN

GALLERY TESTER

DATE

DATE

DATE

DATE

DATE

W52H09 4138 #227

7/24/96

7/24/96

OFFICE COPY

RD6925 REV. 1/94

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

M2400024456

op. #	OP. NAME	READINGS			DATE	INIT
625 cont.	F) Safety On Force	5.5	6	5.5	7-23	REP
	G) Safety Off Force	4	3.5	3.5	7-23	REP
	H) Trigger Pull Test & Retainability					
	I) Firing Pin Indent	.023	.0235	.024	7-23	REP
	J) Assemble Stock				7-23	REP
	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				7-23	REP
	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	2.28	2.22	2.29	2.29	2.38
	C) Function					
660	Pack					

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

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	RETURN TO SHIP	7-23	REP
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		7-23	REP
	C) Inspect Ejector Hole for Chamfer		7-23	REP
	D) Oil Firing Pin Ass'y		7-23	REP
	E) Adjust Trigger Pull to Min Setting and Stake			

SWS TRIGGER PULL TEST

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

SERIAL NO. C6587646
DATE 7-23-96
TESTER DA

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#	COMMENTS
PULL #1	2.67	2.28	2.44	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.66	2.24	2.69	
PULL #3	2.76	2.54	2.63	
PULL #4	2.75	2.63	2.47	
PULL #5	2.58	2.65	2.43	
TOTAL	13.42	12.34	12.66	
AVG.	2.68	2.46	2.53	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.13	3.01		
PULL #2	3.18	2.90		
PULL #3	3.10	3.00		
PULL #4	3.30	2.90		
PULL #5	3.19	3.10		
TOTAL	15.90	14.91		
AVG.	3.18	2.98		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.07	4.13		4.23
PULL #2	4.31	4.00		4.20
PULL #3	4.29	4.19		4.16
PULL #4	4.11	4.16		4.32
PULL #5	4.06	4.00		4.25
TOTAL	20.84	20.48		21.16
AVG.	4.16	4.09		4.23

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06587646
7 Jan 1988

CENTROIDAL DISTANCES

0 TO	1	.295381
1 TO	2	.0395801
1 TO	3	.0629682
1 TO	4	.195
1 TO	5	.328299

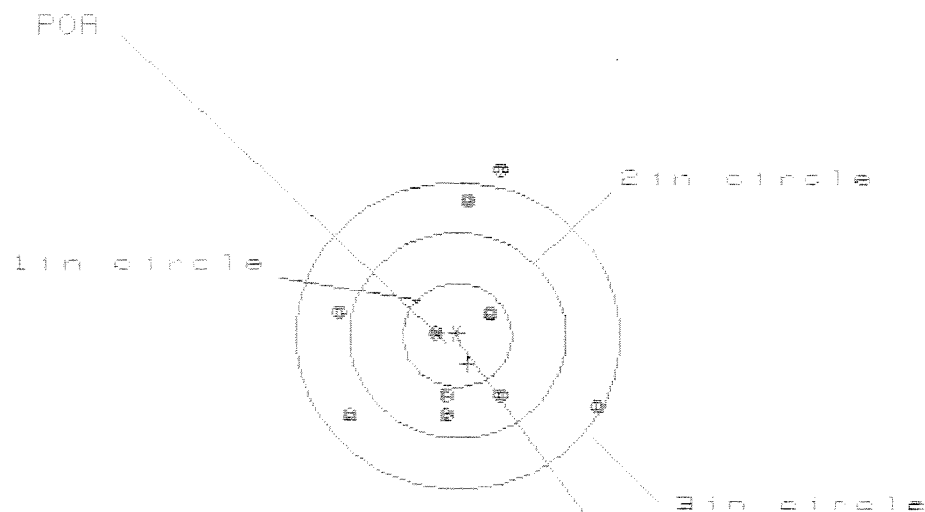
4 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0866
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1576
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .179826
THE AMR FOR THIS RIFLE IS: .8794

2 Jan 1968

FILE: PATTERNING/CENTERFIRE_PATT/08582646

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 3

HE= 2.476

VS= 2.486

GS= 2.776

CENTROID *

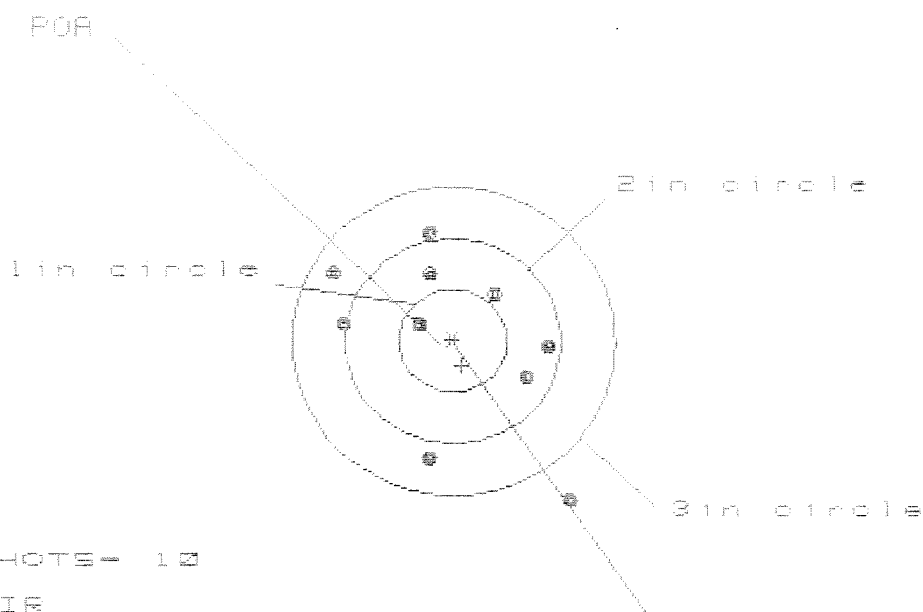
PATTERN #			
SHOTS (BEST OF)	10		
MAXIMUM X	1.331		1.634
MINIMUM X	-1.144		-0.930
MAXIMUM Y	1.638		1.420
MINIMUM Y	-0.788		-0.666
CENTROID X	-0.097	-0.133	-0.311
CENTROID Y	0.279	0.098	0.157
POA TO CENTROID in.	0.296	0.170	0.349
MIN RADIUS	0.240	0.290	0.157

MEAN RADIUS	0.949	0.838	0.758
MAX RADIUS	1.681	1.483	1.445
HORIZONTAL SPREAD	2.476	2.476	1.564
VERTICAL SPREAD	2.426	2.086	2.086
EXTREME SPREAD	2.776	2.615	2.322
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		9	

7 Jan 1988

FILE:/PATTERNING/CENTERFIRE_PATT/06587846

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 1

2in = 6

3in = 9

HS= 2.206

VS= 2.648

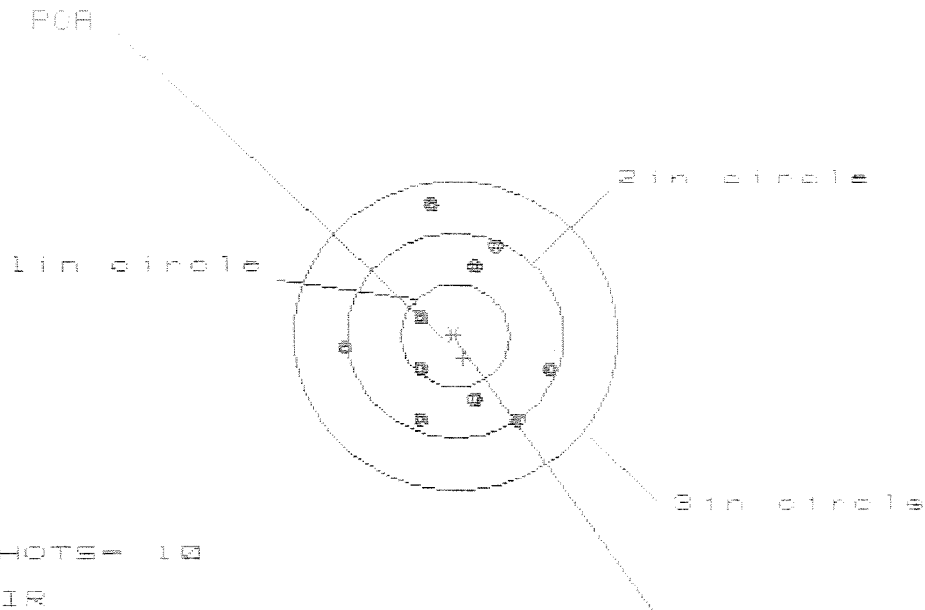
GS= 3.111

PATTERN #	1	2	3
SHOTS (BEST OF)	10	8	
MAXIMUM X	1.00	1.092	
MINIMUM X	-1.00	-1.995	
MAXIMUM Y	1.00	1.947	
MINIMUM Y	-1.50	1.280	
CENTROID X	-1.00	1.079	
CENTROID Y	1.24	1.363	
POA TO CENTROID in.	1.250	1.372	
MIN RADIUS	1.381	1.276	
MEAN RADIUS	1.973	1.796	
MAX RADIUS	1.918	1.382	
HORIZONTAL SPREAD	2.206	1.816	1.887
VERTICAL SPREAD	2.648	2.227	2.227
EXTREME SPREAD	3.111	2.228	2.228
NUMBER IN ONE INCH CIRCLE	=	1	
NUMBER IN TWO INCH CIRCLE	=	6	
NUMBER IN THREE INCH CIRCLE	=	9	

7 Jan 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C8587646

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1in = 2

2in = 8

3in = 10

HS= 1.927

VS= 2.086

GS= 2.214

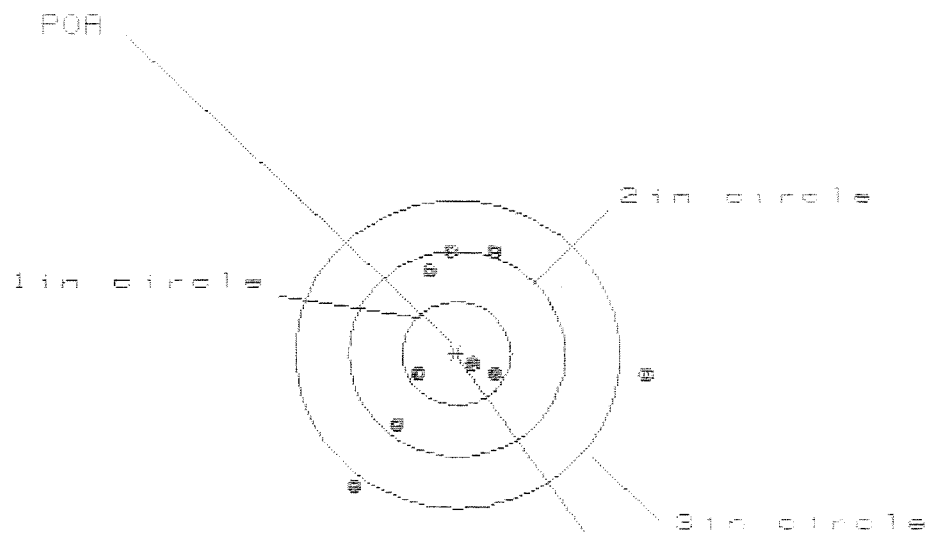
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10		3
MAXIMUM X	1.888		.745
MINIMUM X	-1.331		.471
MAXIMUM Y	1.259		1.028
MINIMUM Y	-.827		-.698
CENTROID X	-.075		.076
CENTROID Y	.226	.001	.082
POA TO CENTROID in.	.232	.097	.112
MIN RADIUS	.347	.382	.481
MEAN RADIUS	.818	.752	.718
MAX RADIUS	1.273	1.085	1.049
HORIZONTAL SPREAD	1.927	1.927	1.216
VERTICAL SPREAD	2.086	1.718	1.718
EXTREME SPREAD	2.214	1.933	1.798
NUMBER IN ONE INCH CIRCLE	=	2	
NUMBER IN TWO INCH CIRCLE	=	8	
NUMBER IN THREE INCH CIRCLE	=	10	

7 Jan 1988

FILE:/PATTERNING/CENTERFIRE_PATT/08587846

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1 in = 4

2 in = 6

3 in = 8

HS= 2.887

VS= 2.341

GS= 2.883

CENTROID *

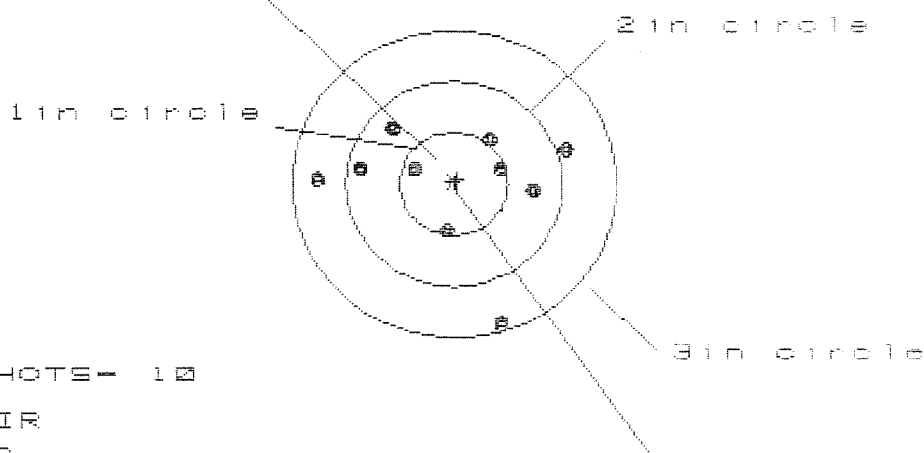
PATTERN #	:	4		
SHOTS (BEST OF)	:	10	6	8
MAXIMUM X	:	1.708	.873	.471
MINIMUM X	:	-.979	-.707	-.438
MAXIMUM Y	:	1.053	1.029	.865
MINIMUM Y	:	-1.288	-1.312	-.874
CENTROID X	:	-.145	-.335	-.236
CENTROID Y	:	.090	.114	.278
POA TO CENTROID in.	:	.171	.354	.365
MIN RADIUS	:	.130	.269	.321
MEAN RADIUS	:	.846	.741	.650
MAX RADIUS	:	1.722	1.531	.978
HORIZONTAL SPREAD	:	2.687	1.359	.909
VERTICAL SPREAD	:	2.341	2.341	1.739
EXTREME SPREAD	:	2.893	2.656	1.910
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

7 Jan 1988

FILE: /PATTERNING/CENTERFIRE_PATT/C8587846

CENTERFIRE PATTERNS # 5

POA



OF SHOTS- 10

IN CIR

1in = 3

2in = 7

3in = 10

HS= 2.226

VS= 1.824

GS= 2.345

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.074	1.126	.976
MINIMUM X	:	-1.252	-1.200	-1.002
MAXIMUM Y	:	.511	.365	.358
MINIMUM Y	:	-1.313	-.578	-.585
CENTROID X	:	-.033	-.085	.065
CENTROID Y	:	-.043	.103	.110
POA TO CENTROID in.	:	.055	.133	.128
MIN RADIUS	:	.382	.318	.376
MEAN RADIUS	:	.811	.734	.661
MAX RADIUS	:	1.394	1.201	1.003
HORIZONTAL SPREAD	:	2.326	2.326	1.979
VERTICAL SPREAD	:	1.824	.943	.943
EXTREME SPREAD	:	2.345	2.345	1.989
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	




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

MODEL 700™

H24

SERIAL NO.

C6587646

ORDER NO.

5716

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

01

UPC



0 47700 25716 7



5716 C6587646

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C 6587646

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		10/24/90	KS
610	Dis-assemble Gun		10/24/90	KS
612	Magnaflux Barrel Action		10/24/90	KR
	Magnaflux Bolt		10/24/90	KR
615	Rollmark Caliber		10/24/90	GS
617	Drill and Tap Sight Holes		10/25/90	LB
618	Polish Barrel <i>LB</i>		10/26/90	WB
620	Apply Coatings (Barrel Action)		11-7-90	JA
	Apply Coating (Bolt)			
625	Final Assembly			
	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		11-15/90	JA

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5 1/2	5 1/2	5 1/2			11/14/90	WB
	G) Safety Off Force	2 1/2	2 1/2	2 1/2			11/15/90	WB
	H) Trigger Pull Test & Retainability						11/15/90	JH
	I) Firing Pin Indent	10215	10225	1022			11/15/90	WB
	J) Assemble Stock						11/15/90	KS
	K) Assemble Swivel Studs						11-20-90	DH
	L) Attach Front and Rear Sight Assemblies						11/15/90	KS
	M) Iron Sight Alignment						11/15/90	KS
	N) Detach Front & Rear Sights & place in numbered container						11/15/90	KS
	O) Attach Scope to Rifle						11/15/90	KS
	P) Detach & Attach Scope 20 Times						11/15/90	KS
640	Gallery Target & Test						11/16/90	AF
	A) Time						"	AF
	B) Malfunctions						"	AF
	C) Pierced Primers						"	AF
	D) Optical Clarity of Scope						"	AF
645	Inspect for Live Ammo						11/16/90	AF
655	Final Inspection							
	A) Headspace						11-20-90	DH
	B) Trigger Pull	250	239	231	231	228	11-20-90	DH
	C) Function						11-20-90	DH
660	Pack						12/8/90	DH

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO 26587646

DATE 11-15-90

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.23	2.26	2.20	250	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.26	2.50	2.24	239	
PULL #3	2.37	2.35	2.30	231	
PULL #4	2.17	2.30	2.30	231	
PULL #5	2.37	2.34	2.34	228	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.29	3.24		
PULL #2	3.25	3.27		
PULL #3	3.33	3.23		
PULL #4	3.29	3.25		
PULL #5	3.35	3.28		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.35	4.24		4.37
PULL #2	4.20	4.39		4.45
PULL #3	4.38	4.45		4.31
PULL #4	4.30	4.42		4.42
PULL #5	4.20	4.40		4.42
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6587646
17 Nov 1990

CENTROIDAL DISTANCES

0 TO	1	.466669
1 TO	2	.288531
1 TO	3	.416646
1 TO	4	.427376
1 TO	5	.168576

←----POA

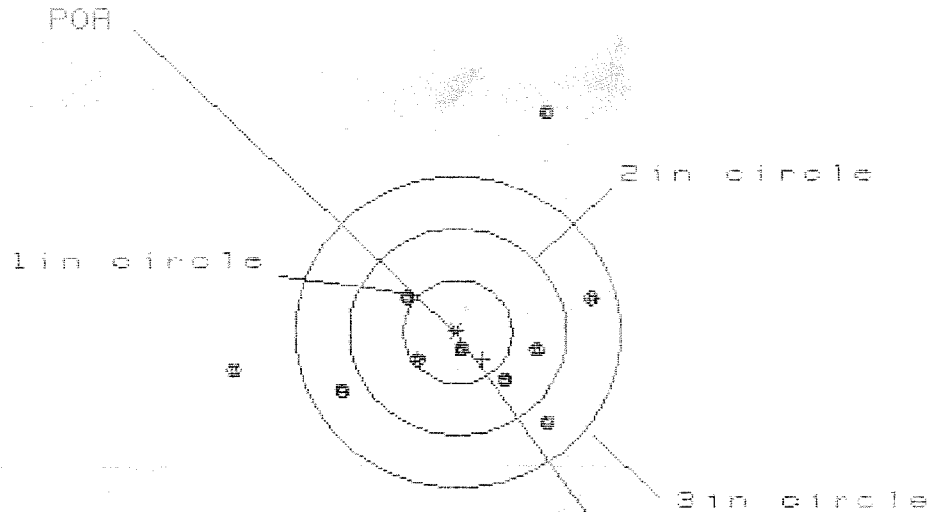
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0868
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .2024
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .220227
THE AMR FOR THIS RIFLE IS: .0044

17 Nov 1990

FILE:/PATTERNING/CENTERFIRE_PATT/C8587646

CENTERFIRE PATTERNS

1



OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 8

HS= 3.312

VS= 2.988

GS= 3.857

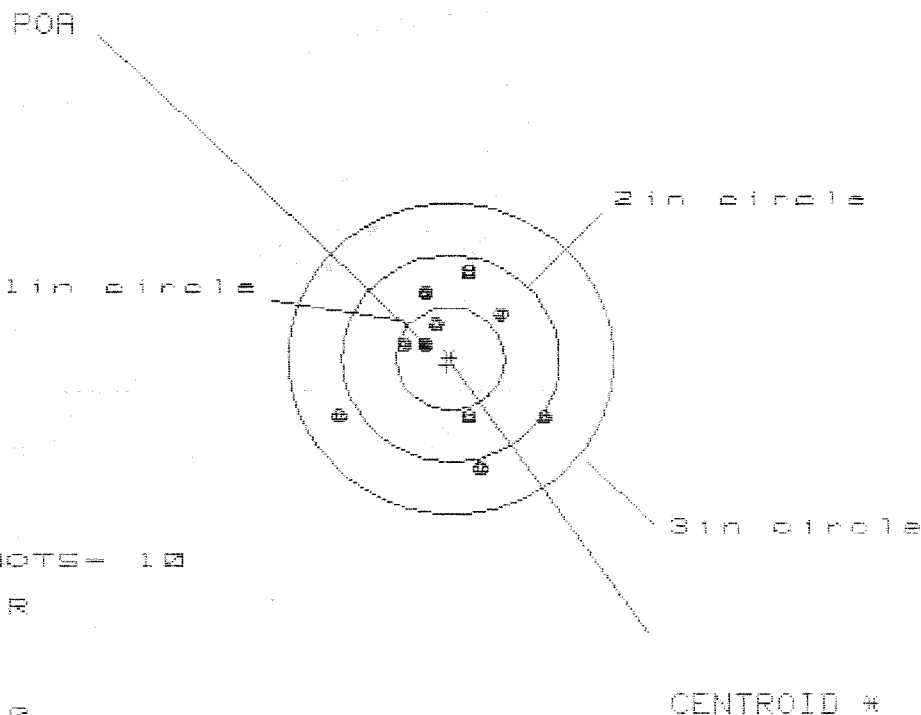
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.268	1.388	1.049
MINIMUM X	-2.104	-2.012	-1.253
MAXIMUM Y	2.136	.618	.601
MINIMUM Y	-.844	-.607	-.624
CENTROID X	-.229	-.321	-.070
CENTROID Y	.265	.028	.045
POA TO CENTROID in.	.351	.322	.088
MIN RADIUS	.189	.114	.152
MEAN RADIUS	1.084	.912	.750
MAX RADIUS	2.290	2.016	1.293
HORIZONTAL SPREAD	3.312	3.312	2.302
VERTICAL SPREAD	2.988	1.225	1.225
EXTREME SPREAD	3.857	3.397	2.478
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	8		

17 Nov 1990

FILE:/PATTERNING/CENTERFIRE_PATT/08587646

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 3

2in = 5

3in = 10

HS= 1.844

VS= 1.892

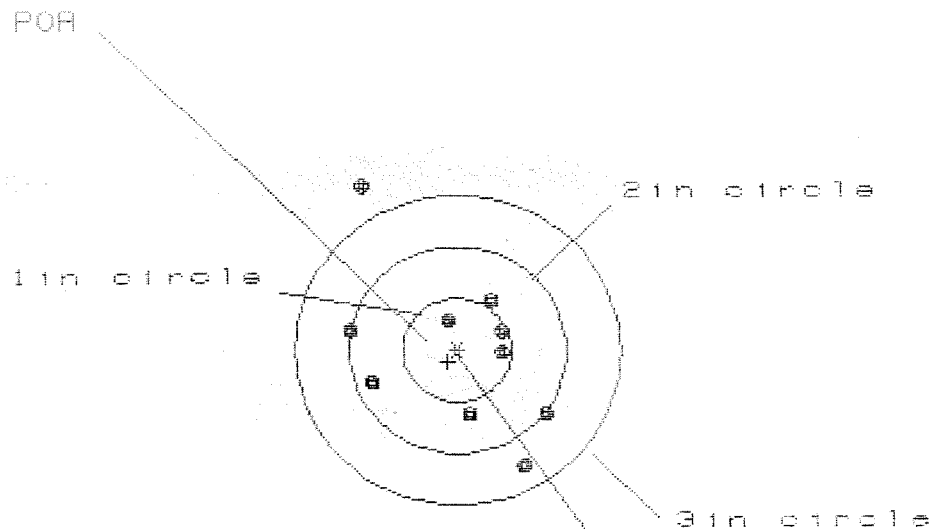
GS= 1.892

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.828	.715	.731
MINIMUM X	:	-1.016	-.513	-.497
MAXIMUM Y	:	.877	.819	.685
MINIMUM Y	:	-1.016	-1.073	-.725
CENTROID X	:	.033	.146	.130
CENTROID Y	:	.061	.118	.252
POA TO CENTROID in.	:	.069	.188	.284
MIN RADIUS	:	.250	.344	.245
MEAN RADIUS	:	.699	.648	.564
MAX RADIUS	:	1.141	1.080	1.022
HORIZONTAL SPREAD	:	1.844	1.228	1.228
VERTICAL SPREAD	:	1.892	1.892	1.410
EXTREME SPREAD	:	1.892	1.892	1.535
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		8	

17 May 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6587646

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 3

2in = 7

3in = 9

HS= 1.778

VS= 2.669

GS= 3.024

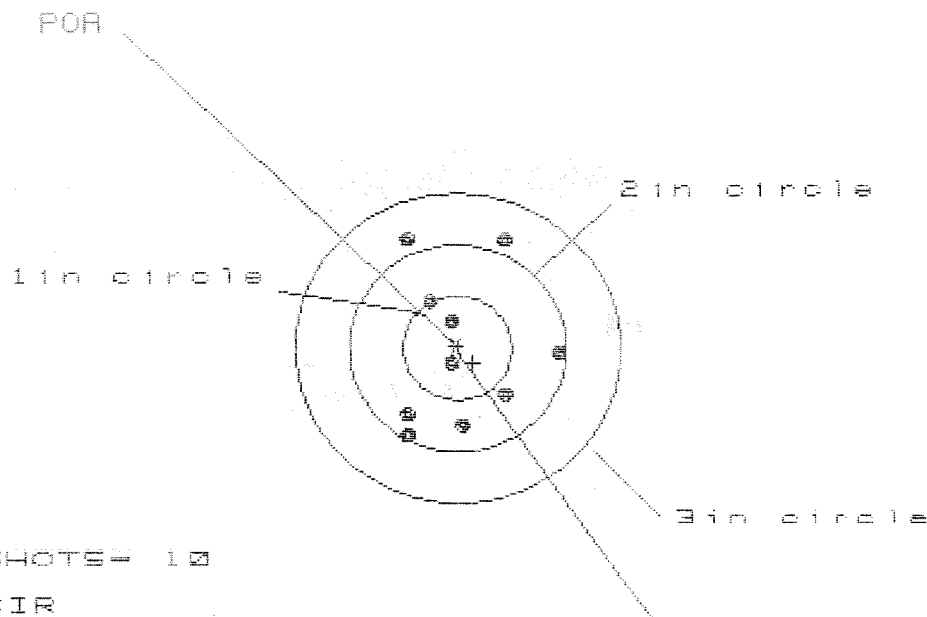
CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.822	.728	.787
MINIMUM X	:	-.956	-1.050	-.991
MAXIMUM Y	:	1.581	.621	.507
MINIMUM Y	:	-1.088	-.912	-.557
CENTROID X	:	.089	.183	.124
CENTROID Y	:	.115	-.061	.053
POA TO CENTROID in.	:	.145	.193	.135
MIN RADIUS	:	.303	.395	.371
MEAN RADIUS	:	.824	.703	.651
MAX RADIUS	:	1.796	1.106	1.018
HORIZONTAL SPREAD	:	1.778	1.778	1.778
VERTICAL SPREAD	:	2.669	1.533	1.064
EXTREME SPREAD	:	3.024	1.978	1.927
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

17 Nov 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6587646

CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1in = 2

2in = 8

3in = 10

HE= 1.403

VS= 1.849

GS= 2.049

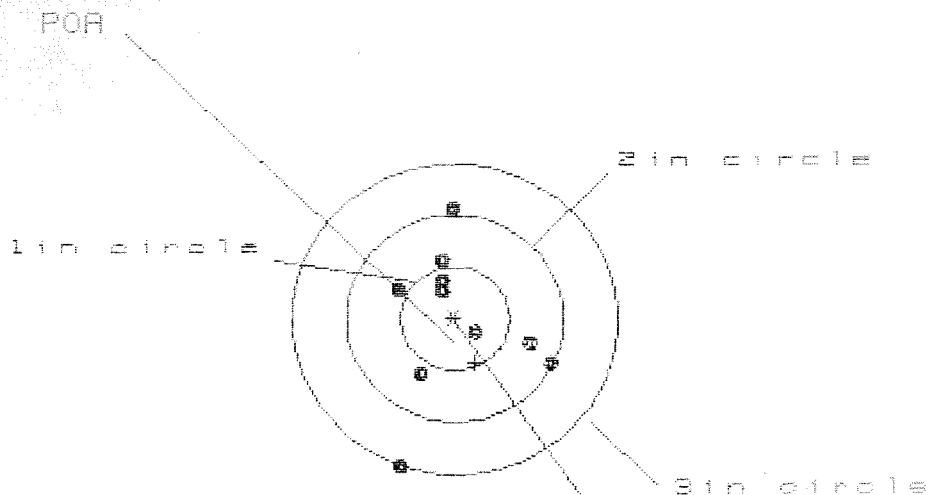
CENTROID *

PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.914	.860	.907
MINIMUM X	-.489	-.512	-.465
MAXIMUM Y	1.036	1.148	.735
MINIMUM Y	-.813	-.701	-.557
CENTROID X	-.141	-.087	-.134
CENTROID Y	.143	.031	-.113
POA TO CENTROID in.	.201	.092	.176
MIN RADIUS	.150	.149	.173
MEAN RADIUS	.715	.663	.579
MAX RADIUS	1.123	1.209	.938
HORIZONTAL SPREAD	1.403	1.372	1.372
VERTICAL SPREAD	1.849	1.849	1.292
EXTREME SPREAD	2.049	2.049	1.578
NUMBER IN ONE INCH CIRCLE	=	2	
NUMBER IN TWO INCH CIRCLE	=	8	
NUMBER IN THREE INCH CIRCLE	=	10	

17 Nov 1998

FILE:/PATTERNING/CENTERFIRE_PATT/06587648

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 6

3 in = 9

HS= 1.430

VS= 2.520

GS= 2.569

CENTROID *

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.892	.832	.820
MINIMUM X	-.538	-.534	-.546
MAXIMUM Y	1.092	.933	.520
MINIMUM Y	-1.428	-.648	-.531
CENTROID X	-.186	-.126	-.114
CENTROID Y	.428	.587	.470
POA TO CENTROID in.	.467	.600	.484
MIN RADIUS	.223	.235	.190
MEAN RADIUS	.700	.583	.543
MAX RADIUS	1.526	1.000	.929
HORIZONTAL SPREAD	1.430	1.366	1.366
VERTICAL SPREAD	2.520	1.581	1.051
EXTREME SPREAD	2.569	1.755	1.532
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		8	
NUMBER IN THREE INCH CIRCLE =		9	