C6587687

MODEL 700™ M24

Model SWS ™

Action

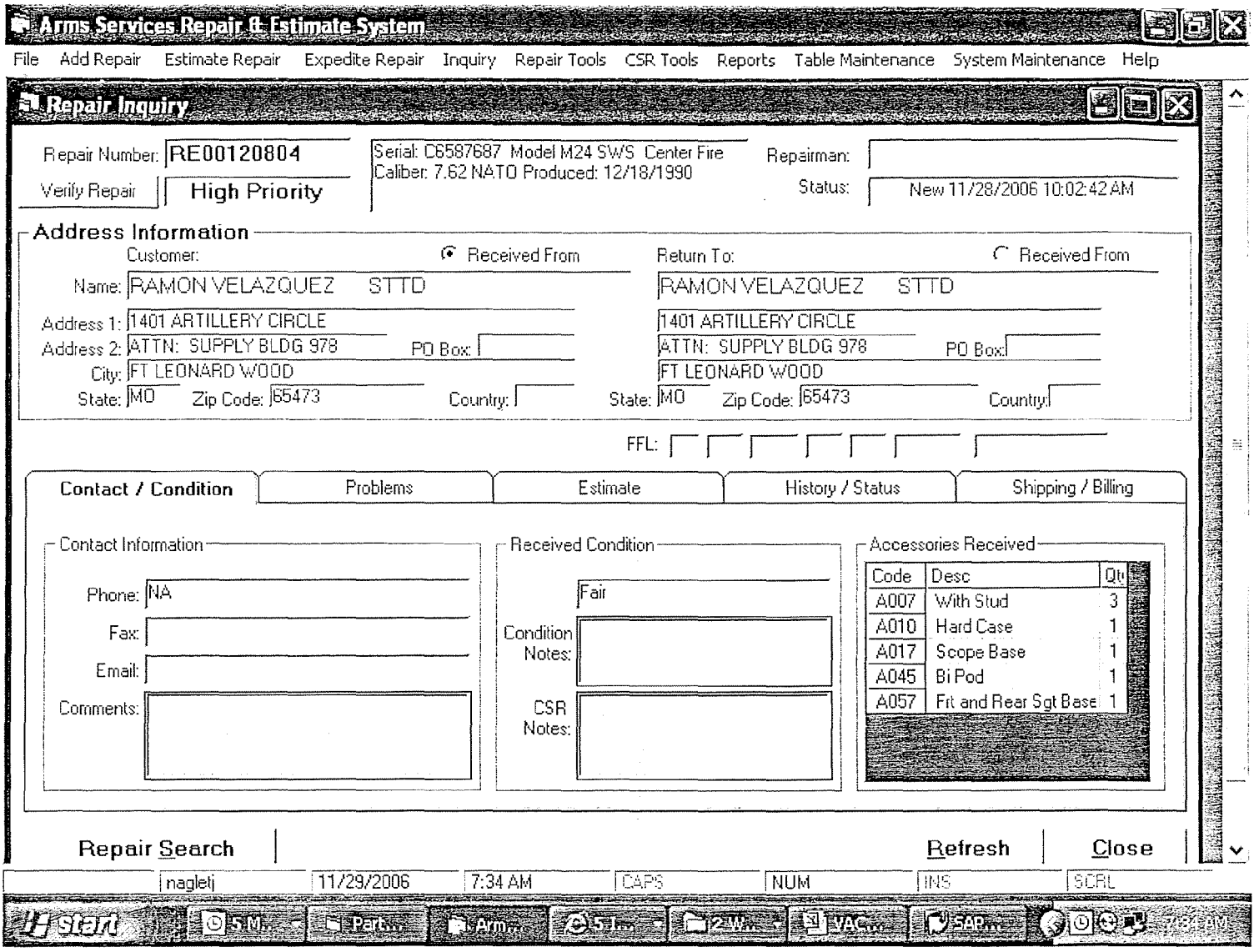
Barrel Length

Capacity

Order No. 5716

*Includes 1 in chamber.

Remington



Serial Number: C6587687

Model: M24 SWS

RE00120804

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFOMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6587687.__0
FILE DATE AND TIME: 12/16/2006 06:12

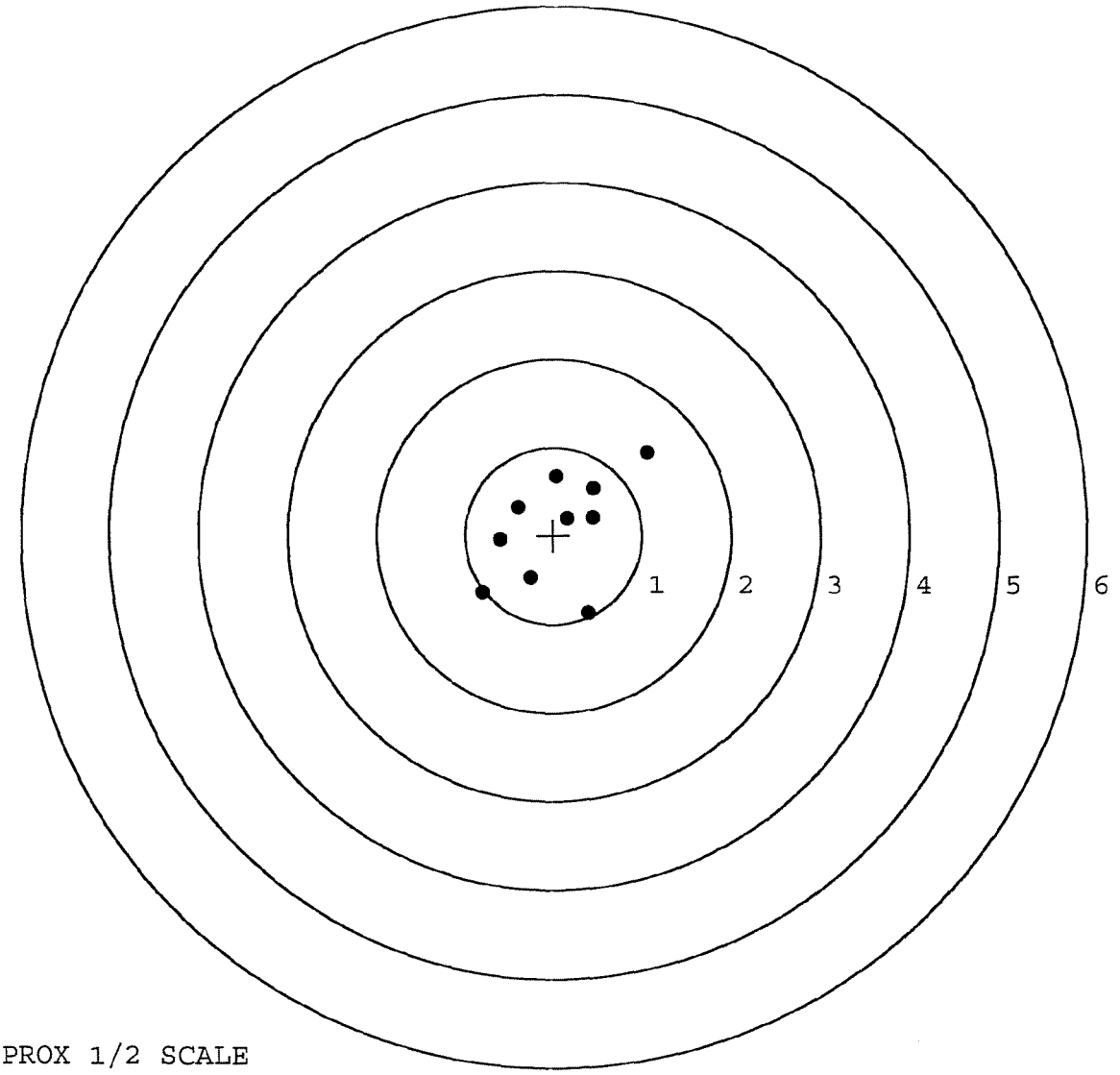
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.080
The Average Y Centroid of the Five Target Set:	0.043
The Average Point of Impact of the Five Target Set:	0.091
The Average Mean Radius of the Five Target Set:	0.725
The Distance from POA to Centroid Target #1:	0.093
The Distance from Centroid Target #2 to Centroid Target #1:	0.131
The Distance from Centroid Target #3 to Centroid Target #1:	0.107
The Distance from Centroid Target #4 to Centroid Target #1:	0.102
The Distance from Centroid Target #5 to Centroid Target #1:	0.027

SERIAL NUMBER: C6587687.__0
TARGET NUMBER: 1
FILE DATE: 12/16/2006
FILE TIME: 06:12

X CENTROID:	0.049
Y CENTROID:	0.080
POA TO CENTROID:	0.093
HORZ SPREAD:	1.849
VERT SPREAD:	1.818
GROUP SPREAD:	2.441
MIN RADIUS:	0.157
MAX RADIUS:	1.319
MEAN RADIUS:	0.706
# IN 1 IN DIAMETER:	2
# IN 2 IN DIAMETER:	7
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	1.047	0.942
2:	0.038	0.673
3:	0.450	0.540
4:	0.452	0.203
5:	0.163	0.187
6:	-0.402	0.314
7:	-0.605	-0.052
8:	-0.802	-0.652
9:	-0.254	-0.484
10:	0.404	-0.876

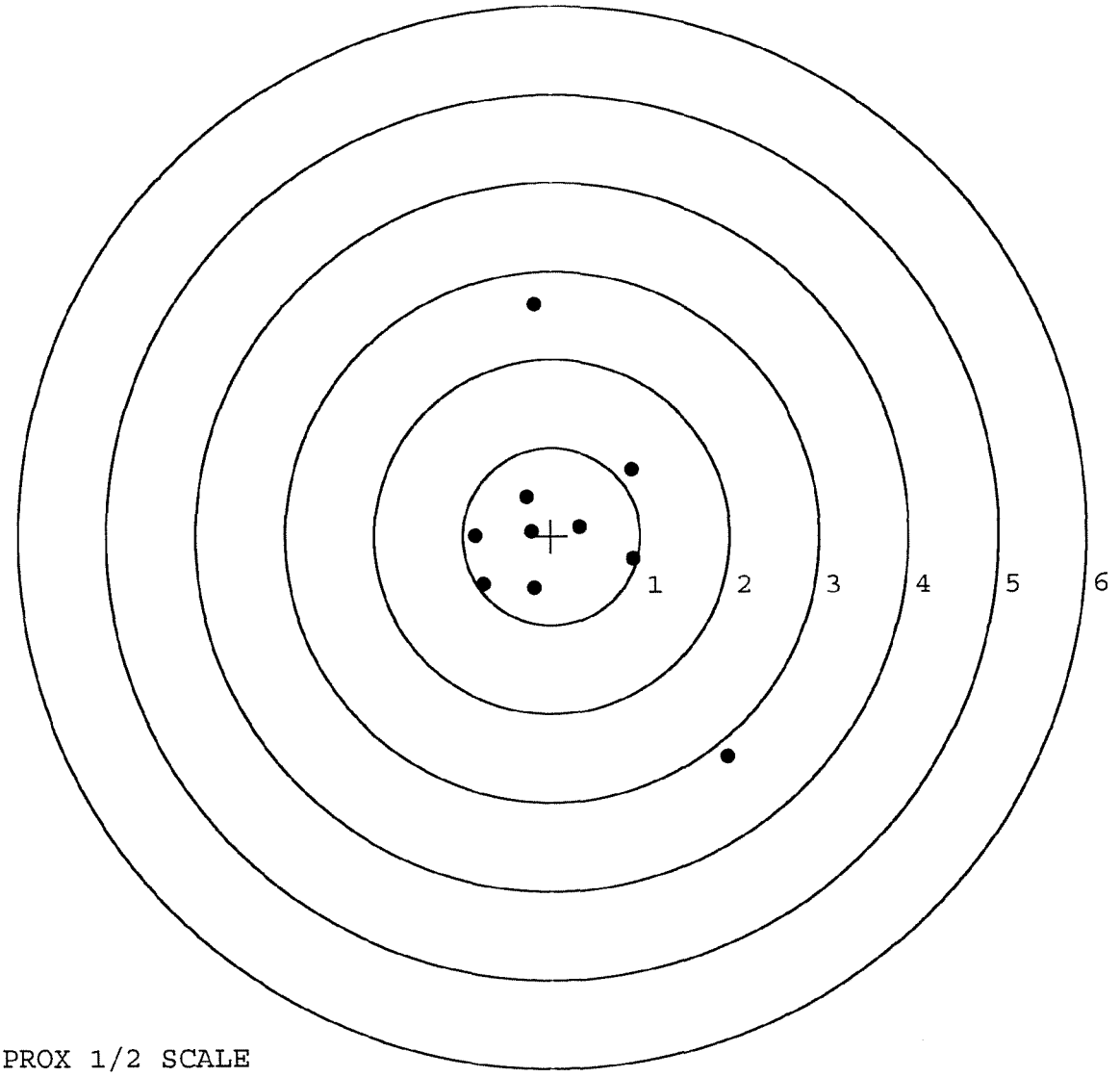


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6587687.__0
TARGET NUMBER: 2
FILE DATE: 12/16/2006
FILE TIME: 06:12

X CENTROID:	0.160
Y CENTROID:	0.010
POA TO CENTROID:	0.161
HORZ SPREAD:	2.828
VERT SPREAD:	5.120
GROUP SPREAD:	5.560
MIN RADIUS:	0.192
MAX RADIUS:	3.093
MEAN RADIUS:	1.158
# IN 1 IN DIAMETER:	2
# IN 2 IN DIAMETER:	5
# in 3 IN DIAMETER:	8

POINT#	X	Y
1:	0.902	0.747
2:	0.926	-0.260
3:	0.325	0.108
4:	-0.194	-0.589
5:	-0.771	-0.540
6:	-0.224	0.051
7:	-0.285	0.443
8:	-0.854	0.009
9:	1.974	-2.496
10:	-0.195	2.624

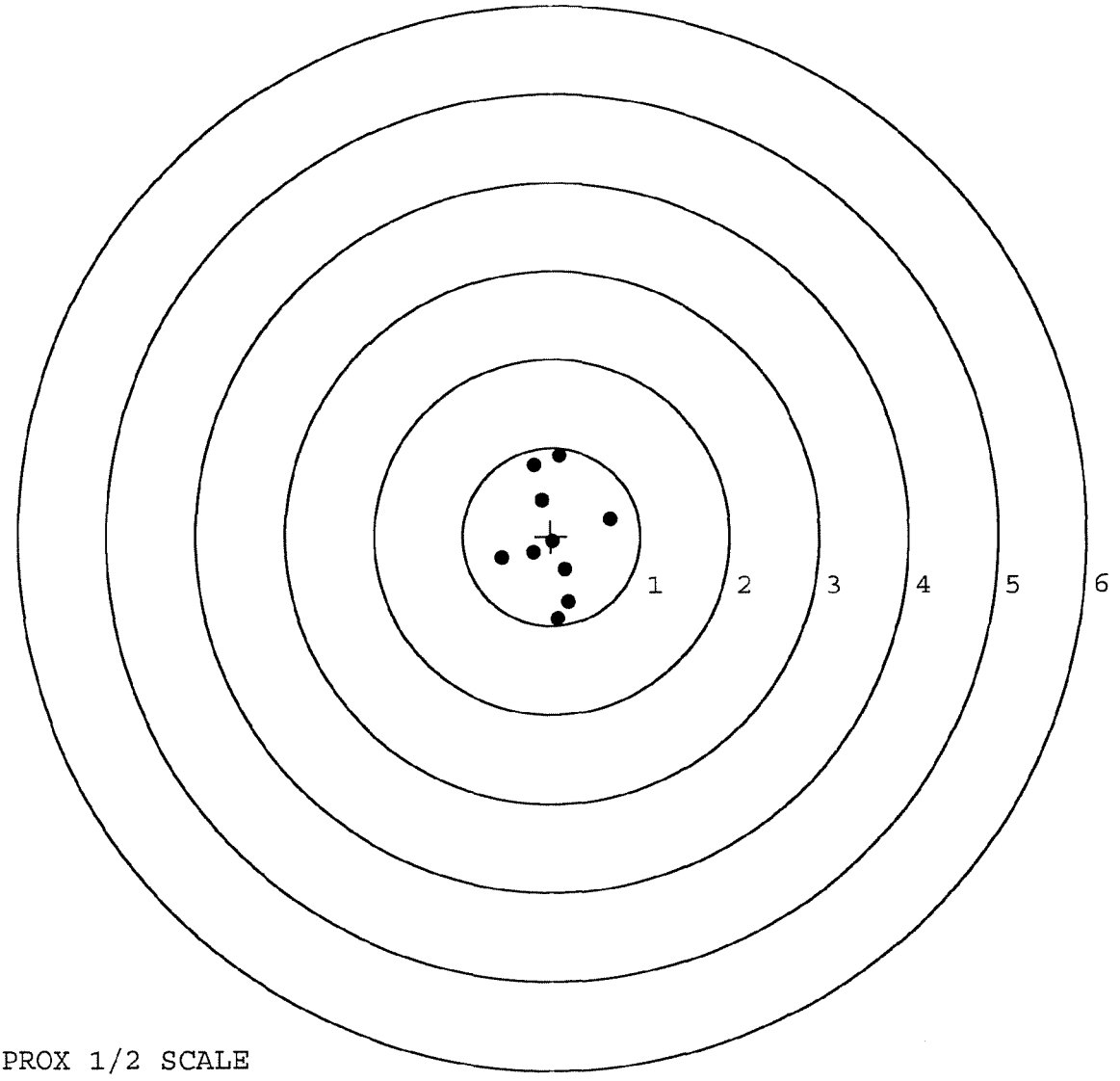


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6587687.__0
TARGET NUMBER: 3
FILE DATE: 12/16/2006
FILE TIME: 06:12

X CENTROID:	0.014
Y CENTROID:	-0.021
POA TO CENTROID:	0.026
HORZ SPREAD:	1.226
VERT SPREAD:	1.843
GROUP SPREAD:	1.843
MIN RADIUS:	0.035
MAX RADIUS:	0.936
MEAN RADIUS:	0.589
# IN 1 IN DIAMETER:	4
# IN 2 IN DIAMETER:	10
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	0.100	0.911
2:	-0.199	0.805
3:	0.669	0.194
4:	-0.113	0.410
5:	0.076	-0.932
6:	0.194	-0.742
7:	0.159	-0.374
8:	-0.557	-0.243
9:	-0.203	-0.186
10:	0.019	-0.056

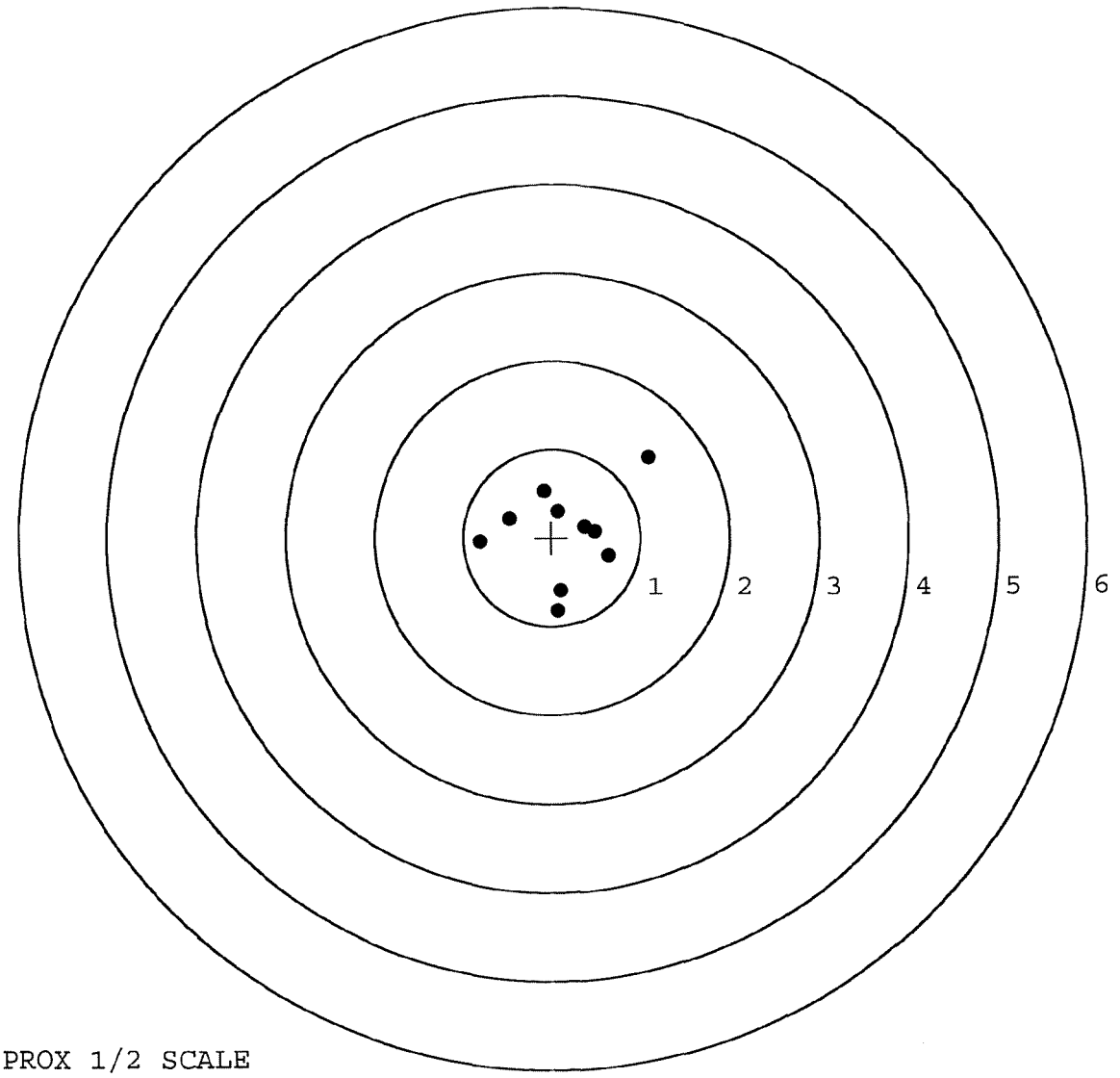


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6587687.__0
TARGET NUMBER: 4
FILE DATE: 12/16/2006
FILE TIME: 06:12

X CENTROID:	0.146
Y CENTROID:	0.048
POA TO CENTROID:	0.154
HORZ SPREAD:	1.902
VERT SPREAD:	1.733
GROUP SPREAD:	2.123
MIN RADIUS:	0.246
MAX RADIUS:	1.274
MEAN RADIUS:	0.636
# IN 1 IN DIAMETER:	3
# IN 2 IN DIAMETER:	9
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	1.090	0.903
2:	0.070	-0.830
3:	0.101	-0.601
4:	0.646	-0.202
5:	0.492	0.079
6:	0.067	0.299
7:	-0.087	0.521
8:	-0.484	0.218
9:	-0.812	-0.041
10:	0.377	0.131

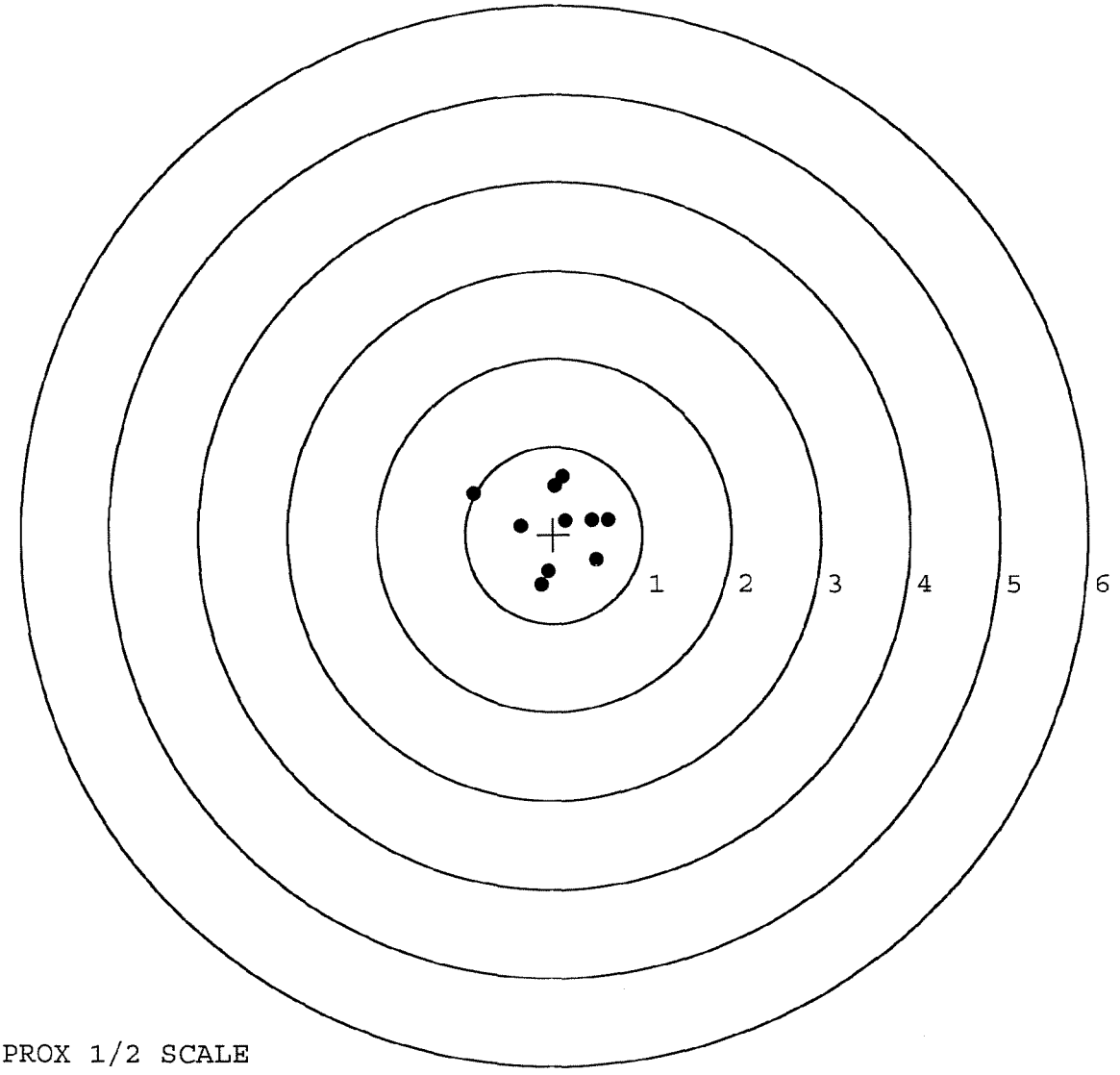


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6587687.__0
TARGET NUMBER: 5
FILE DATE: 12/16/2006
FILE TIME: 06:12

X CENTROID:	0.030
Y CENTROID:	0.099
POA TO CENTROID:	0.104
HORZ SPREAD:	1.530
VERT SPREAD:	1.223
GROUP SPREAD:	1.582
MIN RADIUS:	0.124
MAX RADIUS:	1.010
MEAN RADIUS:	0.535
# IN 1 IN DIAMETER:	4
# IN 2 IN DIAMETER:	9
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	-0.913	0.460
2:	-0.139	-0.569
3:	-0.055	-0.420
4:	-0.371	0.099
5:	0.483	-0.285
6:	0.617	0.168
7:	0.135	0.165
8:	0.102	0.654
9:	0.010	0.548
10:	0.435	0.173



TARGET APPROX 1/2 SCALE

US ARMY & FLW

REMINGTON ARMS CO.,INC.
ATTN: SERVICE DEPT
14 HOEFLER AVE
ILION, NY 13357-1816
CONTRACT NO. DAAE20-02-C-0149
PH. 800-243-9700

STTD

RAMON VELAZQUEZ
STTD
1401 ARTILLERY CIRCLE
ATTN: SUPPLY, BLDG 978
FT. LEONARD WOOD, MO. 65473
(573)596-3420

US ARMY & FLW

REMINGTON ARMS CO.,INC.
ATTN: SERVICE DEPT
14 HOEFLER AVE
ILION, NY 13357-1816
CONTRACT NO. DAAE20-02-C-0149
PH. 800-243-9700

STTD

RAMON VELAZQUEZ
STTD
1401 ARTILLERY CIRCLE
ATTN: SUPPLY, BLDG 978
FT. LEONARD WOOD, MO. 65473
(573)596-3420

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

R & E NUMBER	120804
SERIAL NUMBER	C6587687
LOG-IN DATE	11-28-06

OPERATION #	OPERATION NAME		DATE	INITIAL
500	DIS-ASSEMBLE GUN	11-29-06		RTC
505	RE-BARREL	11-30-06		RTC
420	ASSEMBLE	12-4-06		RTC
440	PROOF	MAGNA-FLUX INSPECTED DEC 05 2006	12-4-06	TRW
460	CHECK HEADSPACE		12-4-06	TRW
470	DIS-ASSEMBLE GUN		12-4-06	BLG
480	MAGNAFLUX	OPERATOR APD	12-3-06	APD
510	DRILL AND TAP		12-4-06	SD
500	ROLLMARK CALIBER		12506	CW
520	GOFF BLAST BBL / REC		12/5/06	JC
530 & 540	APPLY COATINGS		12/7/06	TB
560	FINAL ASSEMBLY		12-13-06	RTC
640	FUNCTION TEST AND	(PASS) FAIL	12-15-06	TRW
650	TARGET	(PASS) FAIL	12-15-06	TRW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION	13-15-06	WR
670	FINAL INSPECTION			
	A) HEADSPACE	(PASS) FAIL	12-18-06	BLG
	B) TRIGGER PULL (+/- .5 LBS, MIN 2.50 LBS, MAX 4.0 LBS)	2.44 2.42 2.48 2.54 2.36	12-16-06	DA
680	F) SAFETY ON FORCE (2 LBS MIN, 10 LBS MAX)	4.0 4.0 4.0	12-16-06	DA
	G) SAFETY OFF FORCE (2 LBS)	2.0 2.0 2.0	12-16-06	DA
	I) FIRING PIN INDENT (.020)	.022 .021 .022	12-16-06	DA
690	PACK		12-18-06	DA

N/A

F006 REV 5/2006

FINAL INSPECTION CHECKLIST

BARREL ASSEMBLY

_____ BARREL

_____ RECEIVER

_____ FRONT SIGHT BASE

_____ REAR SIGHT BASE

_____ SCREWS

_____ FINISH

SCOPE ASSEMBLY

_____ SCOPE

_____ SCOPE RINGS

_____ MOUNTING SCREWS

_____ MOUNTING BASE

_____ SCREWS

_____ FINISH

_____ CLARITY

STOCK ASSEMBLY

_____ STOCK

_____ SLING SWIVEL STUDS

_____

_____ BUTT PATE

_____ LOCK NUTS

_____ BARREL CLEARANCE

_____ COLOR / FINISH

SYSTEM CASE

_____ SCOPE CASE

_____ IRON SIGHTS

_____ DEPLOYMENT KIT

TRIGGER ASSEMBLY

_____ SAFETY OPERATION

_____ RE-SET TO FACTORY SPECS

COMMENTS: _____

F006 REV 5/2006

RECEIVING AND ESTIMATING REPORT

COMMENTS: W/10X SCOPE M-24 SNIPER, W/DEPLOYMENT KIT
ATTN: FRED MARTIN Scope # 96-0723

ORDER: R 94-18097

INITIAL	CUSTOMER ORDER NO.
FDC	DAAA09-92-C-0834

DATE RECEIVED	DATE OPENED	DATE CODE	SERIAL NUMBER	NEW SERIAL NUMBER	MODEL AND GRADE
06/09/94	06/09/94		C6587688		700 7-62 NATO

ACCESSORIES: SLING STRAP HARD CASE SCOPE MNTS SCOPE BASE

FROM:

COMMANDER (W52H094138H226)
DEFENSE DIST DEPOT ANNISTON
ATTN DDAA-UR BLDG 112
ANNISTON AL 36201-5025

SHIP TO:

COMMANDER (W52H094138H226)
DEFENSE DIST DEPOT ANNISTON
ATTN DDAA-UR BLDG 112
ANNISTON AL 36201-5025

CUST NO: 098397 C.O.D.

ACCOUNT NUMBER	ACCOUNT NUMBER N/C	WRITE	PROM. DATE	ESTIMATED	VIA
		☐			FRT

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
- ✓ Barrel
- ✓ Trigger Assy
- ✓ Front Sight Assy
- ✓ Rear Sight Assy

COMMENTS

REPAIRMAN	PROOF	CLEAN	TEST	TARGET	PATTERN
			[illegible]	[illegible]	
GALLERY TESTER	DATE	DATE	DATE 3/21	DATE 3/21	DATE

OFFICE COPY

RD6925 REV. 1/94

SWS TRIGGER PULL TEST

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

SERIAL NO. C6587688
DATE 2-29-96
TESTER DA

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.60	2.53	2.52		MIN. SETTING,
PULL #2	2.53	2.60	2.52		NO AVG. OF 5
PULL #3	2.33	2.58	2.54		READINGS ACCEPT-
PULL #4	2.45	2.56	2.52		ABLE LESS THAN 2#
PULL #5	2.45	2.39	2.53		
TOTAL	1236	1266	1263		
AVG.	2.47	2.53	2.52		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.34	3.10		
PULL #2	3.21	3.04		
PULL #3	3.25	3.04		
PULL #4	3.27	3.04		
PULL #5	3.25	3.05		
TOTAL	1732	1527		
AVG.	3.26	3.05		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.13	4.11		4.16
PULL #2	4.12	4.17		4.24
PULL #3	4.14	4.20		4.22
PULL #4	4.16	4.19		4.03
PULL #5	4.06	4.10		4.22
TOTAL	2061	2077		2087
AVG.	4.12	4.15		4.17

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6587688
22 Jan 1900

CENTROIDAL DISTANCES

0	TO	1	1.06604
1	TO	2	.211436
1	TO	3	.0944299
1	TO	4	.51782
1	TO	5	.302576

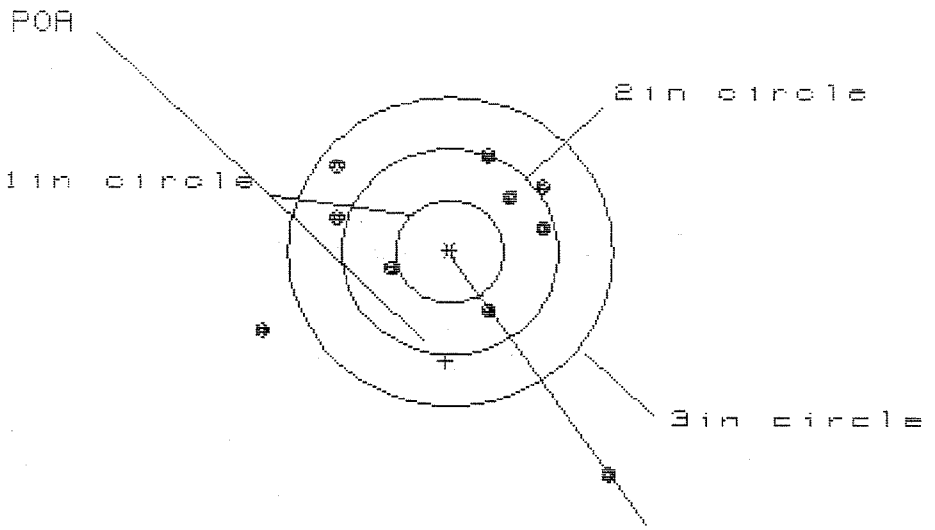
+ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1168
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .9188
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .926194

THE AMR FOR THIS RIFLE IS: 1.005

22 Jan 1900 FILE:/PATTERNING/CENTERFIRE_PATT/C6587680

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

# IN CIR
1in = 0
2in = 4
3in = 8

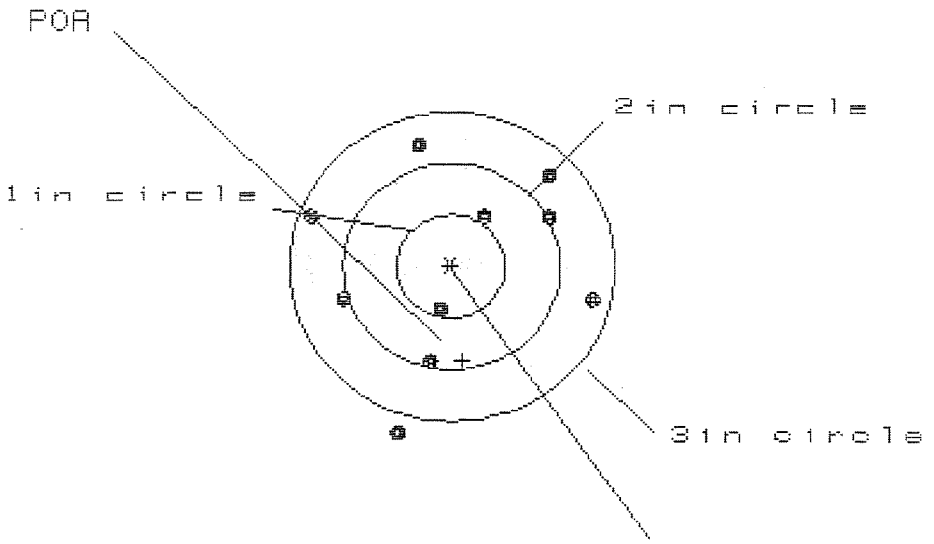
HS= 3.127
VS= 3.070
GS= 3.883

CENTROID *

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.410	1.008	.813
MINIMUM X	:	-1.717	-1.560	-1.119
MAXIMUM Y	:	.948	.712	.590
MINIMUM Y	:	-2.122	-.982	-.909
CENTROID X	:	.047	-.110	.085
CENTROID Y	:	1.065	1.301	1.423
POA TO CENTROID in.	:	1.066	1.305	1.426
MIN RADIUS	:	.560	.551	.541
MEAN RADIUS	:	1.183	1.008	.866
MAX RADIUS	:	2.548	1.843	1.225
HORIZONTAL SPREAD	:	3.127	2.568	1.932
VERTICAL SPREAD	:	3.070	1.694	1.499
EXTREME SPREAD	:	3.883	2.932	2.013
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	

22 Jan 1900 FILE:/PATTERNING/CENTERFIRE_PATT/C6587688

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

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

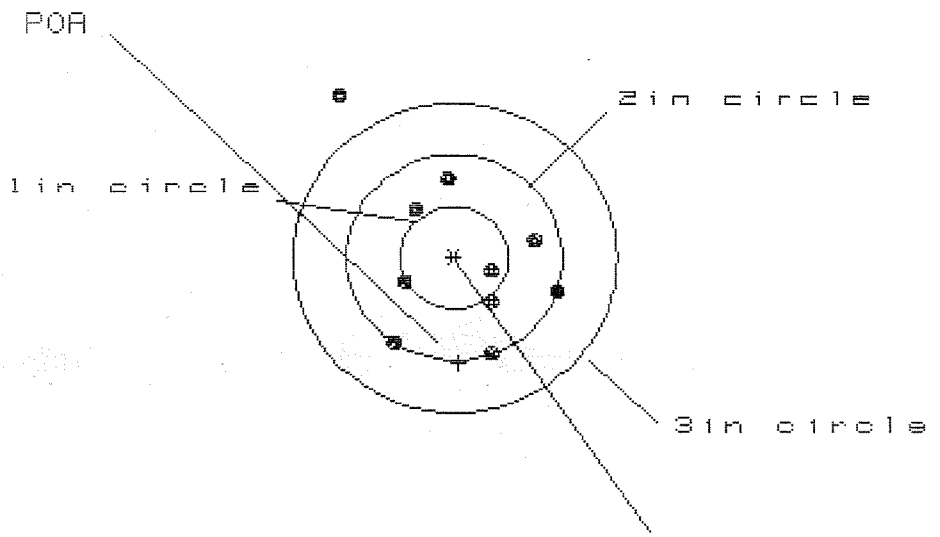
HS= 2.644
VS= 2.842
CS= 2.855

CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.339	1.284	1.114
MINIMUM X	:	-1.304	-1.360	-1.266
MAXIMUM Y	:	1.216	1.036	1.071
MINIMUM Y	:	-1.626	-1.076	-1.041
CENTROID X	:	-.101	-.046	.124
CENTROID Y	:	.914	1.094	1.059
POA TO CENTROID in.	:	.919	1.095	1.066
MIN RADIUS	:	.450	.424	.370
MEAN RADIUS	:	1.105	1.024	.957
MAX RADIUS	:	1.701	1.390	1.348
HORIZONTAL SPREAD	:	2.644	2.644	2.380
VERTICAL SPREAD	:	2.842	2.112	2.112
EXTREME SPREAD	:	2.855	2.751	2.380
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		9	

22-Jan 1900 FILE:/PATTERNING/CENTERFIRE_PATT/C65876B8

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1in = 1

2in = 8

3in = 9

CENTROID #

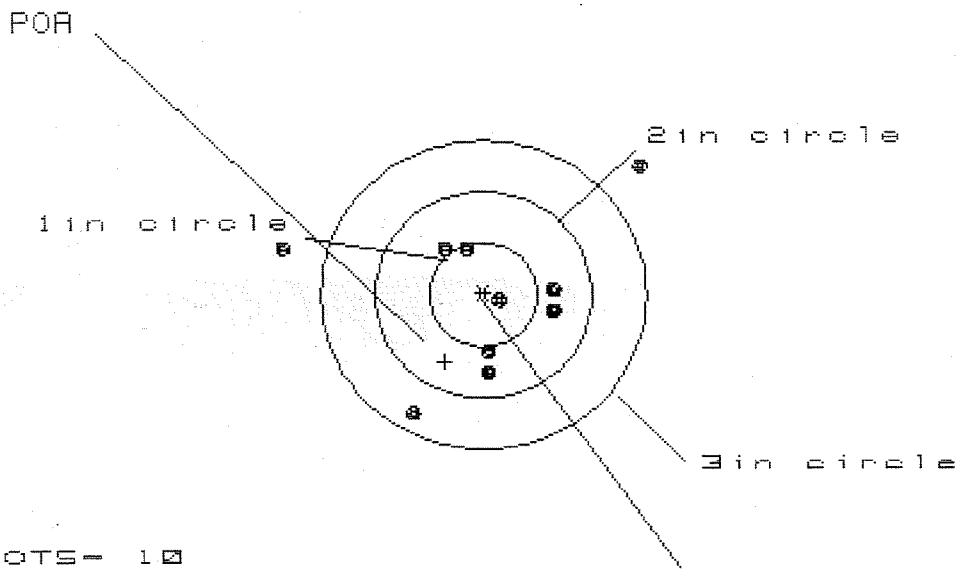
VS= 2.520

GS= 2.885

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.920	.801	.714
MINIMUM X	:	-1.066	-.697	-.683
MAXIMUM Y	:	1.617	.957	.873
MINIMUM Y	:	-.903	-.723	-.807
CENTROID X	:	-.039	.080	.167
CENTROID Y	:	1.026	.846	.930
POA TO CENTROID in.	:	1.026	.850	.945
MIN RADIUS	:	.362	.208	.136
MEAN RADIUS	:	.848	.684	.635
MAX RADIUS	:	1.937	.982	.925
HORIZONTAL SPREAD	:	1.986	1.498	1.397
VERTICAL SPREAD	:	2.520	1.680	1.680
EXTREME SPREAD	:	2.885	1.736	1.736
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	

22 Jan 1900 FILE:/PATTERNING/CENTERFIRE_PATT/CG5876B8

CENTERFIRE PATTERNS # 4



OF SHOTS= 10

# IN CIR
1in = 2
2in = 7
3in = 8

HS= 3.378
VS= 2.371
GS= 3.472

CENTROID #

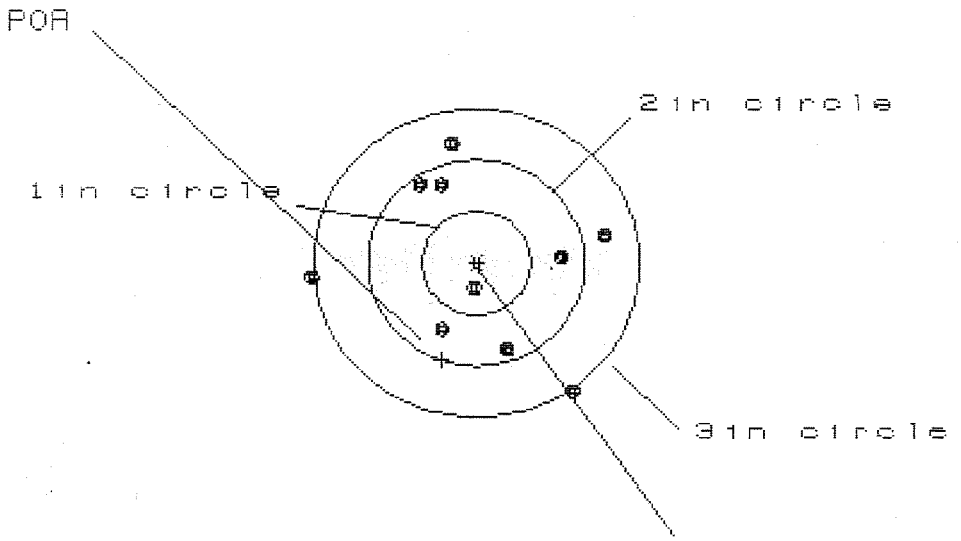
PATTERN # : 4

SHOTS (BEST OF) :	10	9	8
MAXIMUM X :	1.475	1.264	.589
MINIMUM X :	-1.903	-.881	-.723
MAXIMUM Y :	1.263	1.315	.662
MINIMUM Y :	-1.108	-1.056	-.892
CENTROID X :	.354	.565	.407
CENTROID Y :	.648	.596	.432
POA TO CENTROID in.:	.738	.822	.594
MIN RADIUS :	.202	.016	.215
MEAN RADIUS :	.905	.745	.618
MAX RADIUS :	1.958	1.824	1.148
HORIZONTAL SPREAD :	3.378	2.145	1.312
VERTICAL SPREAD :	2.371	2.371	1.554
EXTREME SPREAD :	3.472	3.197	1.736

NUMBER IN ONE INCH CIRCLE = 2
NUMBER IN TWO INCH CIRCLE = 7
NUMBER IN THREE INCH CIRCLE = 8

22 Jan 1900 FILE:/PATTERNING/CENTERFIRE_PATT/C6587688

CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1in = 1
2in = 6
3in = 8

HS= 2.744
VS= 2.425
GS= 2.772

CENTROID X

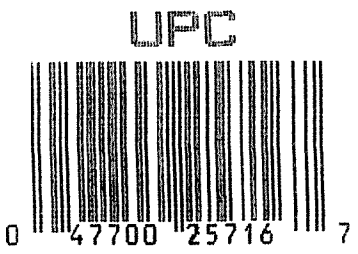
PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.178	1.004	1.092
MINIMUM X	:	-1.566	-.741	-.653
MAXIMUM Y	:	1.201	1.191	1.036
MINIMUM Y	:	-1.224	-1.234	-1.023
CENTROID X	:	.323	.497	.409
CENTROID Y	:	.941	.951	1.105
POA TO CENTROID in.	:	.995	1.073	1.179
MIN RADIUS	:	.225	.303	.403
MEAN RADIUS	:	.983	.913	.847
MAX RADIUS	:	1.569	1.421	1.100
HORIZONTAL SPREAD	:	2.744	1.745	1.745
VERTICAL SPREAD	:	2.425	2.425	2.060
EXTREME SPREAD	:	2.772	2.673	2.116
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6587688

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	6 1/2	6 1/2	6 1/4			5/3/96	WB
	G) Safety Off Force	3	3	3			5/3/96	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 Clearity of Scope							
645	Inspect for Live Ammo							
655	Final Inspection A) Headspace							
	B) Trigger Pull	2.27	2.27	2.29	2.29	2.24	4/18/96	WB
	C) Function							
660	Pack							



op. #	OP. NAME	READINGS	DATE	INIT
625 cont.	F) Safety On Force	4 | 4 | 4	11/15/90	WB
	G) Safety Off Force	2 | 2 | 2	11/15/90	WB
	H) Trigger Pull Test & Retainability		11-15-90	
	I) Firing Pin Indent	.0205 | .020 | .020	11/15/90	WB
	J) Assemble Stock		11-15-90	RW
	K) Assemble Swivel Studs		11-26-90	DS
	L) Attach Front and Rear Sight Assemblies		11/15/90	RW
	M) Iron Sight Alignment		11/15/90	RW
	N) Detach Front & Rear Sights & place in numbered container		11/15/90	RW
	O) Attach Scope to Rifle		11/15/90	RW
	P) Detach & Attach Scope 20 Times		11/15/90	RW
640	Gallery Target & Test		11-21-90	DH
	A) Time		11-21-90	DH
	B) Malfunctions		11-21-90	DH
	C) Pierced Primers		11-21-90	DH
	D) Optical Clearity of Scope		11-21-90	DH
645	Inspect for Live Ammo		11-21-90	DH
655	Final Inspection A) Headspace		11-26-90	DS
	B) Trigger Pull	243 | 241 | 238 | 241 | 241	11-26-90	DS
	C) Function		11-26-90	DS
660	Pack		12-17-90	RH

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6587687

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		10 9 90	RW
600	Proof		10 9 90	RW
607	Check Headspace		10 9 90	RW
610	Dis-assemble Gun		10 9 90	RW
612	Magnaflux Barrel Action		10/17/90	KR
	Magnaflux Bolt		"	KR
615	Rollmark Caliber		"	LL
617	Drill and Tap Sight Holes		10/18/90	FB
618	Polish Barrel RB		10/19/90	WB
620	Apply Coatings (Barrel Action)		11-5-90	
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		11/7/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		11/7/90	RW
	C) Inspect Ejector Hole for Chamfer		11/7/90	RW
	D) Oil Firing Pin Ass'y		11/7/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		11/16/90	

SWS TRIGGER PULL TEST

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

SERIAL NO. C658768J

DATE 11-15-90

TESTER JL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.28	2.46	2.36	2.43	MIN. SETTING,
PULL #2	2.15	2.37	2.39	2.41	NO AVG. OF 5
PULL #3	2.19	2.37	2.39	2.38	READINGS ACCEPT-
PULL #4	2.45	2.31	2.45	2.41	ABLE LESS THAN 2#
PULL #5	2.50	2.40	2.46	2.41	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.50	3.35		
PULL #2	3.38	3.45		
PULL #3	3.46	3.45		
PULL #4	3.44	3.50		
PULL #5	3.47	3.49		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.28	4.26		4.27
PULL #2	4.26	4.26		4.26
PULL #3	4.26	4.30		4.30
PULL #4	4.27	4.29		4.27
PULL #5	4.27	4.26		4.28
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6587687
26 Nov 1990

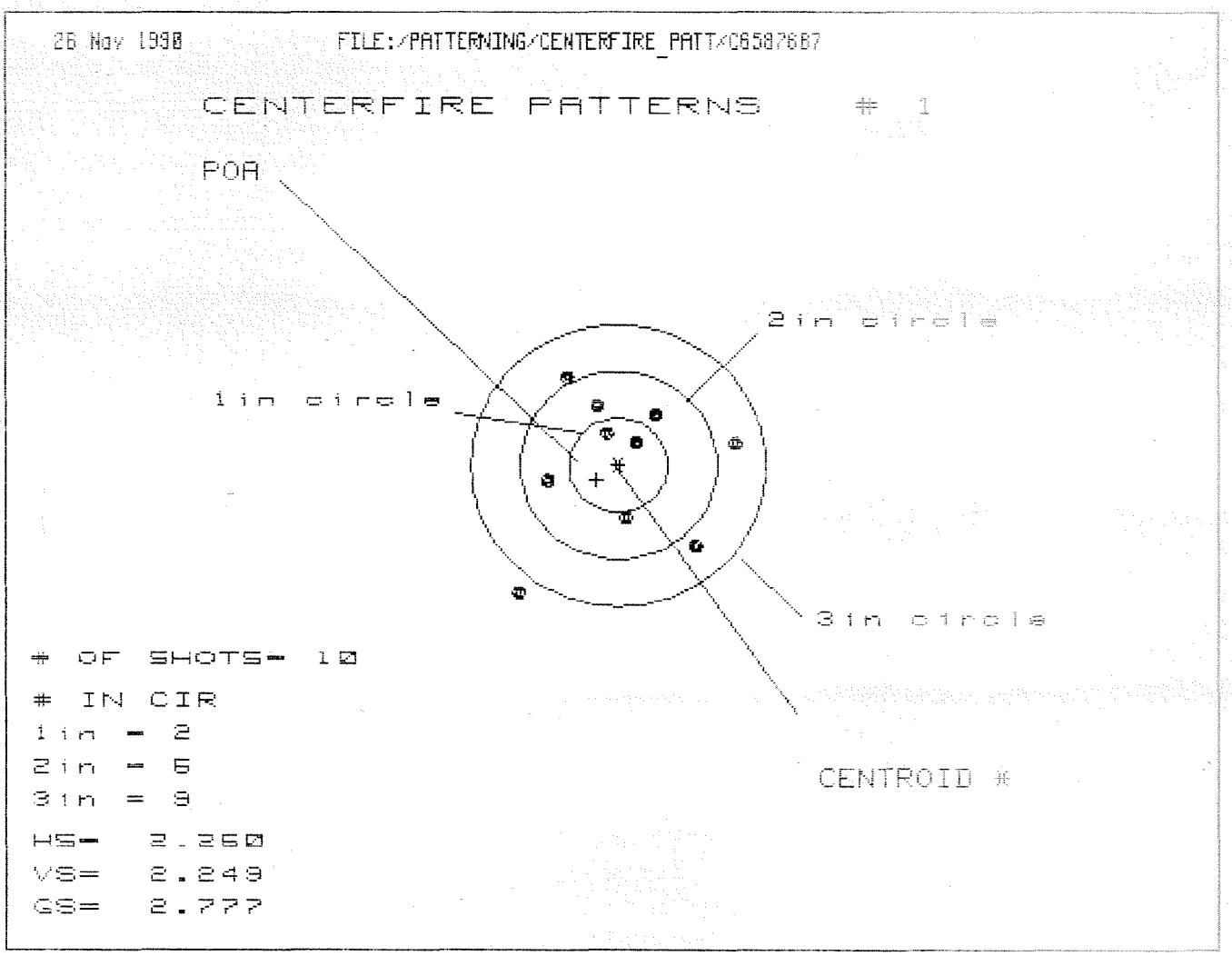
CENTROIDAL DISTANCES

0	TO	1	.271442
1	TO	2	.0904268
1	TO	3	.250785
1	TO	4	.273031
1	TO	5	.37727

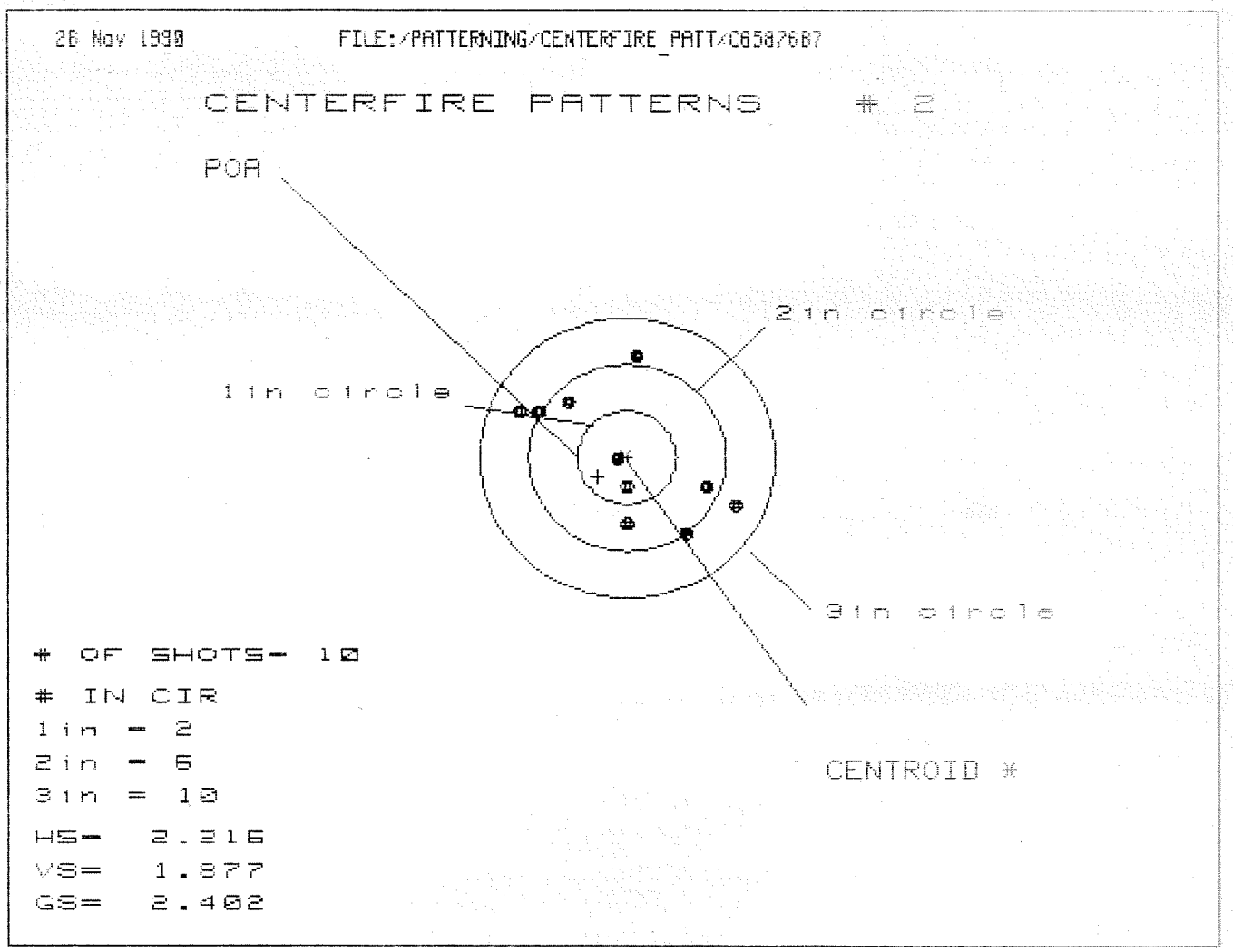
<----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1942
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .061
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .203555

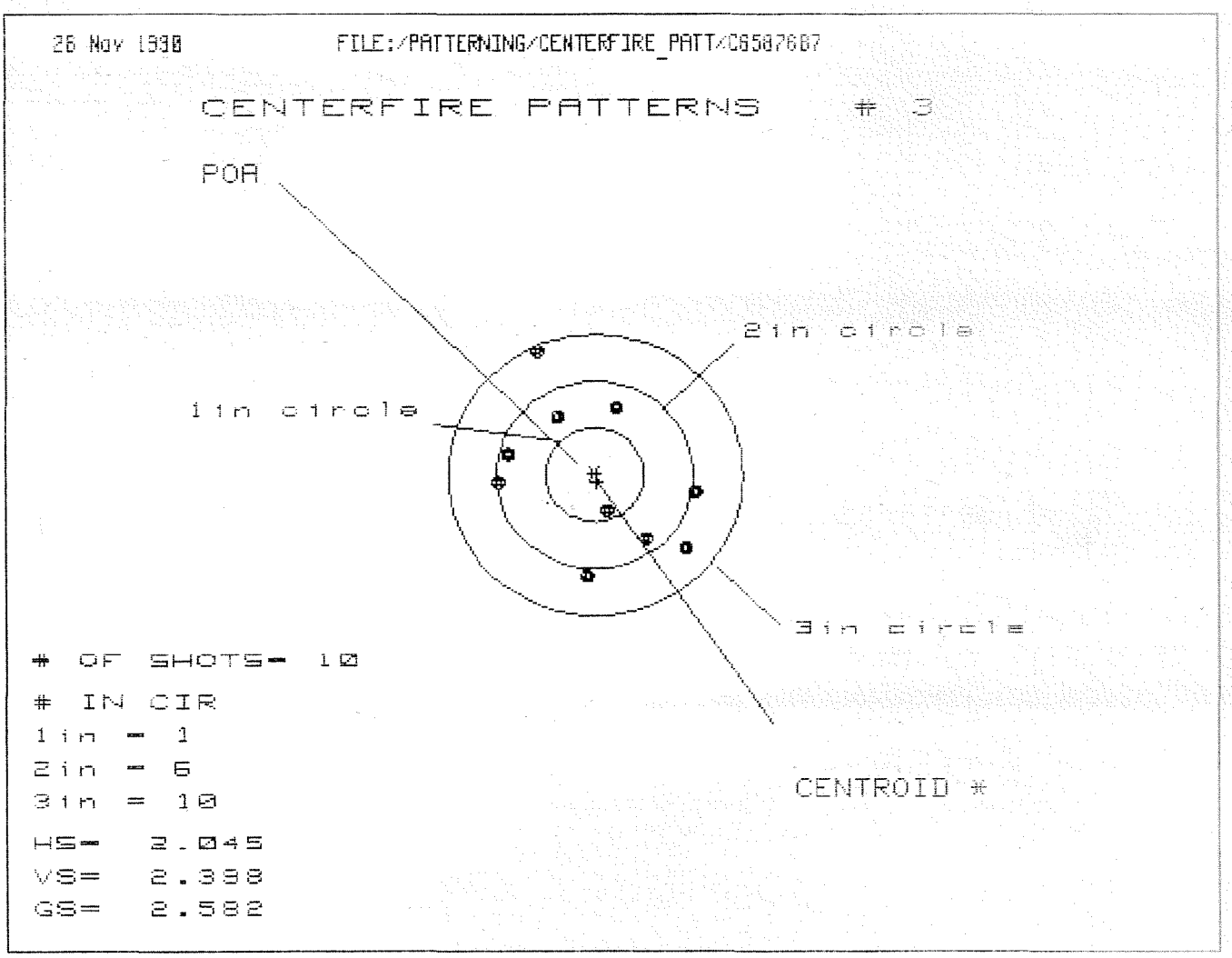
THE AMR FOR THIS RIFLE IS: .8332



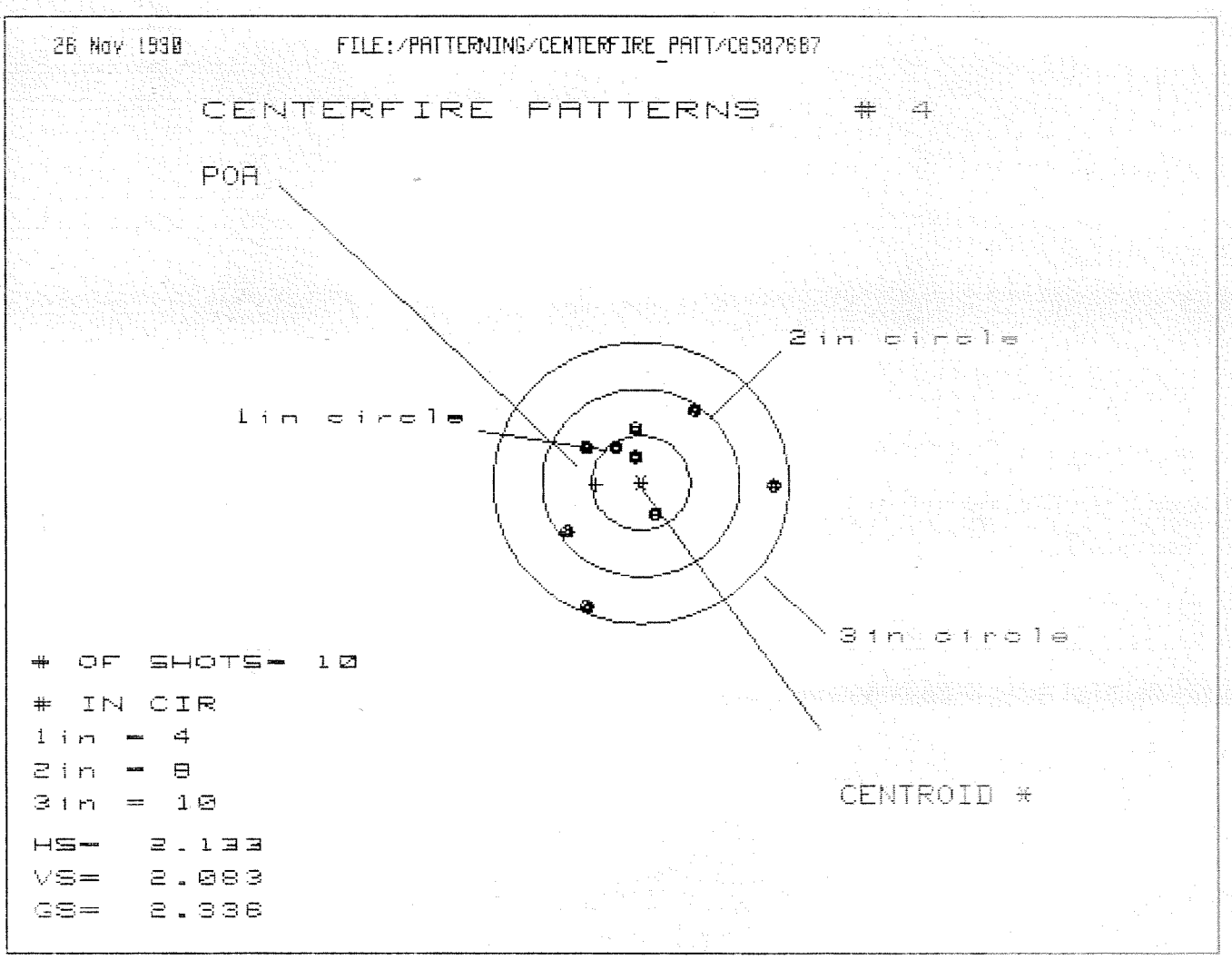
PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.205	1.088	.834
MINIMUM X	:	-1.055	-.811	-.675
MAXIMUM Y	:	.891	.740	.754
MINIMUM Y	:	-1.358	-.995	-.982
CENTROID X	:	.220	.337	.201
CENTROID Y	:	.159	.310	.296
POA TO CENTROID in.	:	.271	.458	.358
MIN RADIUS	:	.262	.073	.203
MEAN RADIUS	:	.833	.693	.637
MAX RADIUS	:	1.719	1.215	1.288
HORIZONTAL SPREAD	:	2.260	1.899	1.509
VERTICAL SPREAD	:	2.249	1.735	1.735
EXTREME SPREAD	:	2.777	2.201	2.201
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	



PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.148	.945	.828
MINIMUM X	:	-1.068	-.941	-.836
MAXIMUM Y	:	1.056	1.005	1.056
MINIMUM Y	:	-.821	-.872	-.821
CENTROID X	:	.296	.169	.286
CENTROID Y	:	.208	.259	.208
POA TO CENTROID in.	:	.362	.309	.354
MIN RADIUS	:	.138	.068	.128
MEAN RADIUS	:	.834	.777	.741
MAX RADIUS	:	1.237	1.154	1.058
HORIZONTAL SPREAD	:	2.216	1.886	1.664
VERTICAL SPREAD	:	1.877	1.877	1.877
EXTREME SPREAD	:	2.402	2.129	1.962
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	6		
NUMBER IN THREE INCH CIRCLE	=	10		



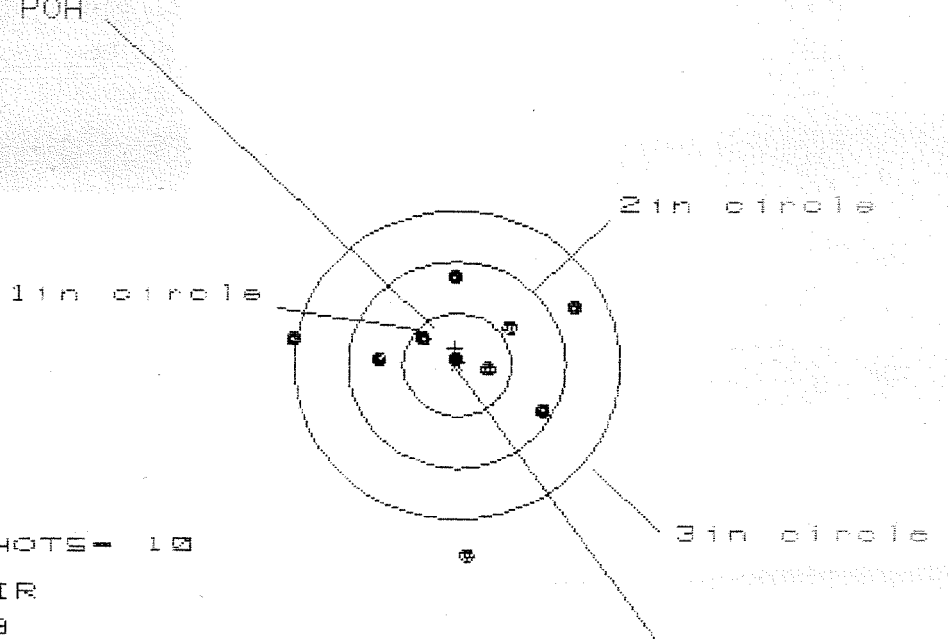
PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.047	.983	1.087
MINIMUM X	:	-.998	-1.062	-.958
MAXIMUM Y	:	1.366	.914	.840
MINIMUM Y	:	-1.032	-.880	-.954
CENTROID X	:	-.017	.047	-.057
CENTROID Y	:	.077	-.075	-.001
POA TO CENTROID in.	:	.079	.089	.057
MIN RADIUS	:	.358	.193	.306
MEAN RADIUS	:	.945	.861	.843
MAX RADIUS	:	1.486	1.069	1.093
HORIZONTAL SPREAD	:	2.045	2.045	2.045
VERTICAL SPREAD	:	2.398	1.794	1.794
EXTREME SPREAD	:	2.582	2.051	2.051
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	



PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.379	1.319	.619
MINIMUM X	:	-.754	-.814	-.649
MAXIMUM Y	:	.810	.669	.654
MINIMUM Y	:	-1.272	-.654	-.669
CENTROID X	:	.455	.515	.350
CENTROID Y	:	.020	.162	.177
POA TO CENTROID in.	:	.455	.540	.392
MIN RADIUS	:	.244	.158	.086
MEAN RADIUS	:	.718	.629	.513
MAX RADIUS	:	1.383	1.324	.932
HORIZONTAL SPREAD	:	2.133	2.133	1.268
VERTICAL SPREAD	:	2.083	1.323	1.323
EXTREME SPREAD	:	2.336	2.199	1.833
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	

28 Nov 1530 FILE:/PATTERNING/CENTERFIRE_PATT/C6507687

CENTERFIRE PATTERNS # 5



OF SHOTS= 10

# IN CIR
1in = 3
2in = 7
3in = 8

HS= 2.628
VS= 2.675
GS= 2.677

PATTERN # : 5

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.090	1.094	.902
MINIMUM X	-1.538	-1.534	-.864
MAXIMUM Y	.847	.644	.652
MINIMUM Y	-1.827	-.631	-.623
CENTROID X	.017	.013	.204
CENTROID Y	-.159	.045	.037
POA TO CENTROID in.	.159	.046	.208
MIN RADIUS	.045	.160	.251
MEAN RADIUS	.836	.715	.601
MAX RADIUS	1.828	1.535	.978
HORIZONTAL SPREAD	2.628	2.628	1.766
VERTICAL SPREAD	2.675	1.275	1.275
EXTREME SPREAD	2.677	2.646	1.838

NUMBER IN ONE INCH CIRCLE = 3
NUMBER IN TWO INCH CIRCLE = 7
NUMBER IN THREE INCH CIRCLE = 8