

C6523372

MODEL 700™ M24

Model **SWS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

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: RE00151963

Serial: C6523372 Model M24 SWS Center Fire
Caliber: 7.62 NATO Produced: 12/19/1990

Repairman:

Status:

Closed 9/26/2008 9:49:35 AM

Verify Repair

Address Information

Customer:

☒ Received From

Return To:

☐ Received From

Name: DEF DIST DEPOT ANNISTON AL

DEF DIST DEPOT ANNISTON AL

Address 1: 7 FRANKFORD AVE BLDG 362

7 FRANKFORD AVE BLDG 362

Address 2: PO Box:

PO Box:

City: ANNISTON

ANNISTON

State: AL

Zip Code: 36201-4199

Country: US

State: AL

Zip Code: 36201-4199

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	2
A008	With Swivel	2
A017	Scope Base	1
A026	Scope	1
A057	Front and Rear Sgt Base	1

Repair Search

Refresh

Close

nagletj

9/29/2008

2:39 PM

CAPS

NUM

INS

SCRL

start

13 M...

4 M...

HR Ba...

2 Int...

Arms...

Part S...

2:39 PM

Serial Number:

C6523372

Model M24 SWS



RE00151963

M-24
INSPECTION CHECKLIST - REPAIRS
CONTRACT #: W52H09-07-C-0207
ISSUED 10/1/2007

R & E NUMBER <u>151963</u>				
SERIAL NUMBER <u>C6523372</u>				
LOG-IN DATE <u>9-26-08</u>				

OPERATION #	OPERATION NAME	DATE	INITIAL	
500	DIS-ASSEMBLE GUN	3-25-09	RTZ	
505	RE-BARREL	3-27-09	RTZ	
420	ASSEMBLE	3-27-09	RTZ	
440	PROOF	3-27-09	TL	MAGNA - FLUX
460	CHECK HEADSPACE	3-27-09	TL	
470	DIS-ASSEMBLE GUN			
480	MAGNAFLUX	4/2/09	(P)	OPERATOR (P)
510	DRILL AND TAP	3-28-09	SP	
500	ROLLMARK CALIBER	4/2/09		
520	GOFF BLAST BBL / REC	4-2	RA	
530 & 540	APPLY COATINGS	4-3		
560	FINAL ASSEMBLY	4-8-09	RTZ	
640	FUNCTION TEST AND	4-8-09	(PASS)	FAIL
650	TARGET	4-8-09	(PASS)	FAIL
	MALFUNCTION			CORRECTION
	MALFUNCTION			CORRECTION
	MALFUNCTION			CORRECTION
	MALFUNCTION			CORRECTION
670	FINAL INSPECTION	4-8-09	RP	
	A) HEADSPACE	4-15-09	(PASS)	FAIL
	B) TRIGGER PULL	2.31 2.34 2.18 2.19 3.19 4-9-09	W W	
680	F) SAFETY ON FORCE	5 5 5 4-15-09	W W	
	G) SAFETY OFF FORCE	3 3 3 4-15-09	W W	
	I) FIRING PIN INDENT	.023 .023 .024 4-15-09	W W	
690	PACK	6/2/09	Fm	

F006 REV 1/2009

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6523372.___0
FILE DATE AND TIME: 04/09/2009 05:26

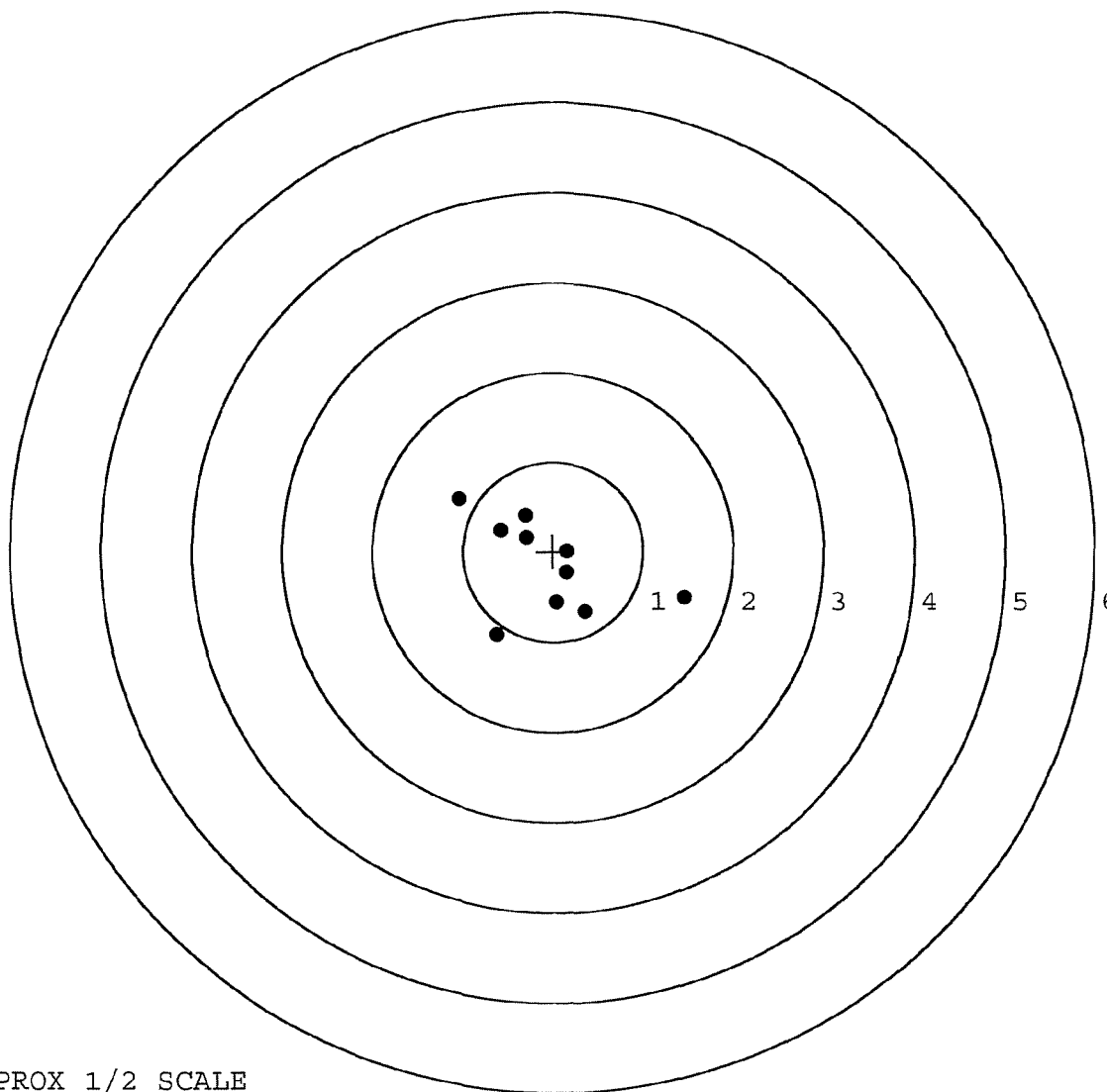
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.013
The Average Y Centroid of the Five Target Set:	-0.046
The Average Point of Impact of the Five Target Set:	0.047
The Average Mean Radius of the Five Target Set:	0.565
The Distance from POA to Centroid Target #1:	0.169
The Distance from Centroid Target #2 to Centroid Target #1:	0.045
The Distance from Centroid Target #3 to Centroid Target #1:	0.226
The Distance from Centroid Target #4 to Centroid Target #1:	0.216
The Distance from Centroid Target #5 to Centroid Target #1:	0.229

SERIAL NUMBER: C6523372.___0
TARGET NUMBER: 1
FILE DATE: 04/09/2009
FILE TIME: 05:26

X CENTROID: -0.071
Y CENTROID: -0.153
POA TO CENTROID: 0.169
HORZ SPREAD: 2.497
VERT SPREAD: 1.507
GROUP SPREAD: 2.726
MIN RADIUS: 0.235
MAX RADIUS: 1.569
MEAN RADIUS: 0.698
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 9

POINT#	X	Y
1:	-1.040	0.584
2:	-0.580	0.240
3:	-0.308	0.401
4:	-0.300	0.154
5:	1.457	-0.510
6:	-0.630	-0.923
7:	0.351	-0.670
8:	0.034	-0.573
9:	0.149	-0.235
10:	0.159	0.000

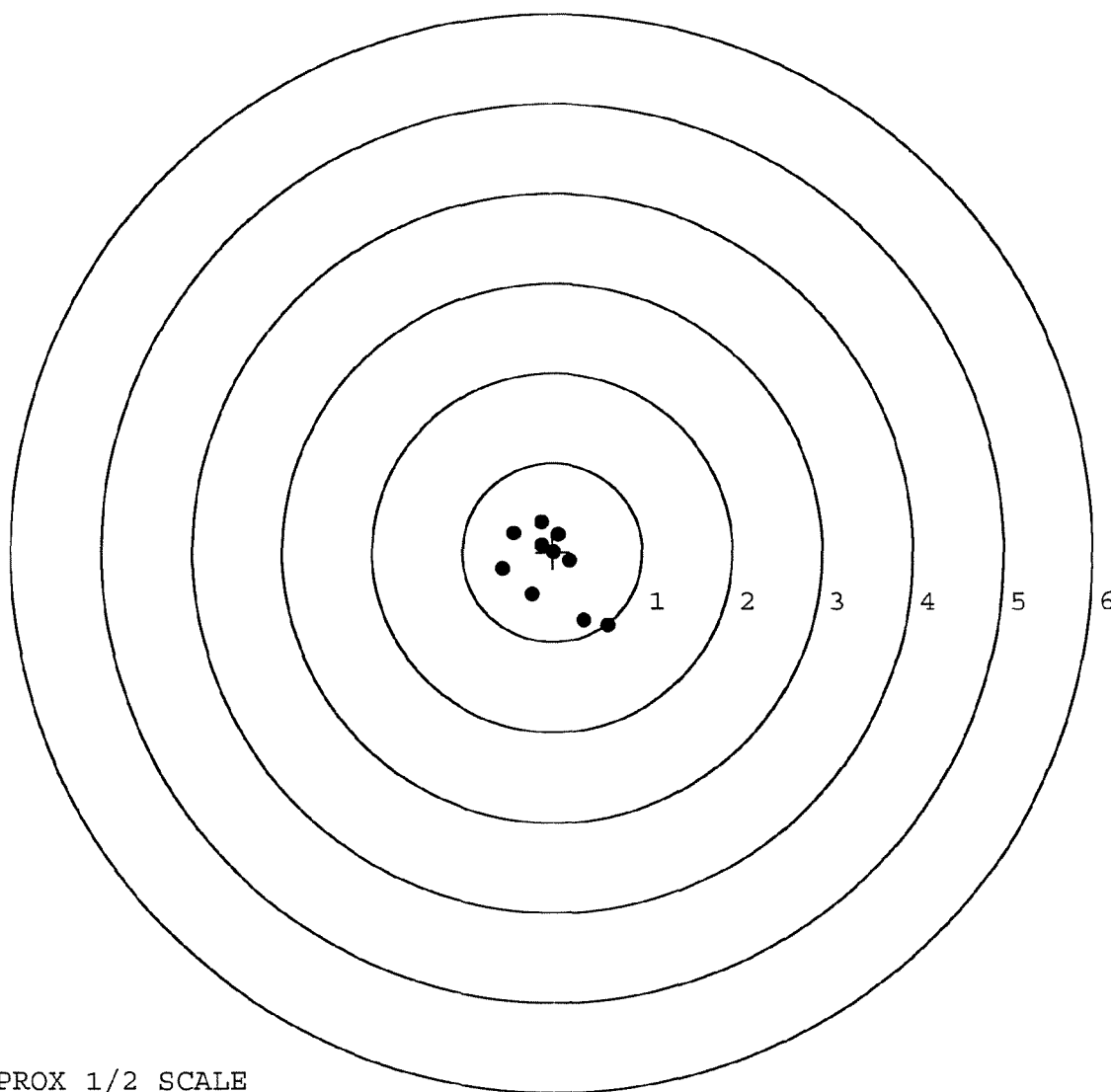


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6523372. 0
TARGET NUMBER: 2
FILE DATE: 04/09/2009
FILE TIME: 05:26

X CENTROID: -0.026
Y CENTROID: -0.153
POA TO CENTROID: 0.155
HORZ SPREAD: 1.169
VERT SPREAD: 1.158
GROUP SPREAD: 1.474
MIN RADIUS: 0.158
MAX RADIUS: 0.924
MEAN RADIUS: 0.458
IN 1 IN DIAMETER: 6
IN 2 IN DIAMETER: 10
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.007	0.001
2:	0.612	-0.822
3:	0.345	-0.764
4:	-0.229	-0.474
5:	-0.557	-0.191
6:	-0.437	0.214
7:	-0.120	0.336
8:	0.064	0.197
9:	-0.123	0.078
10:	0.181	-0.106

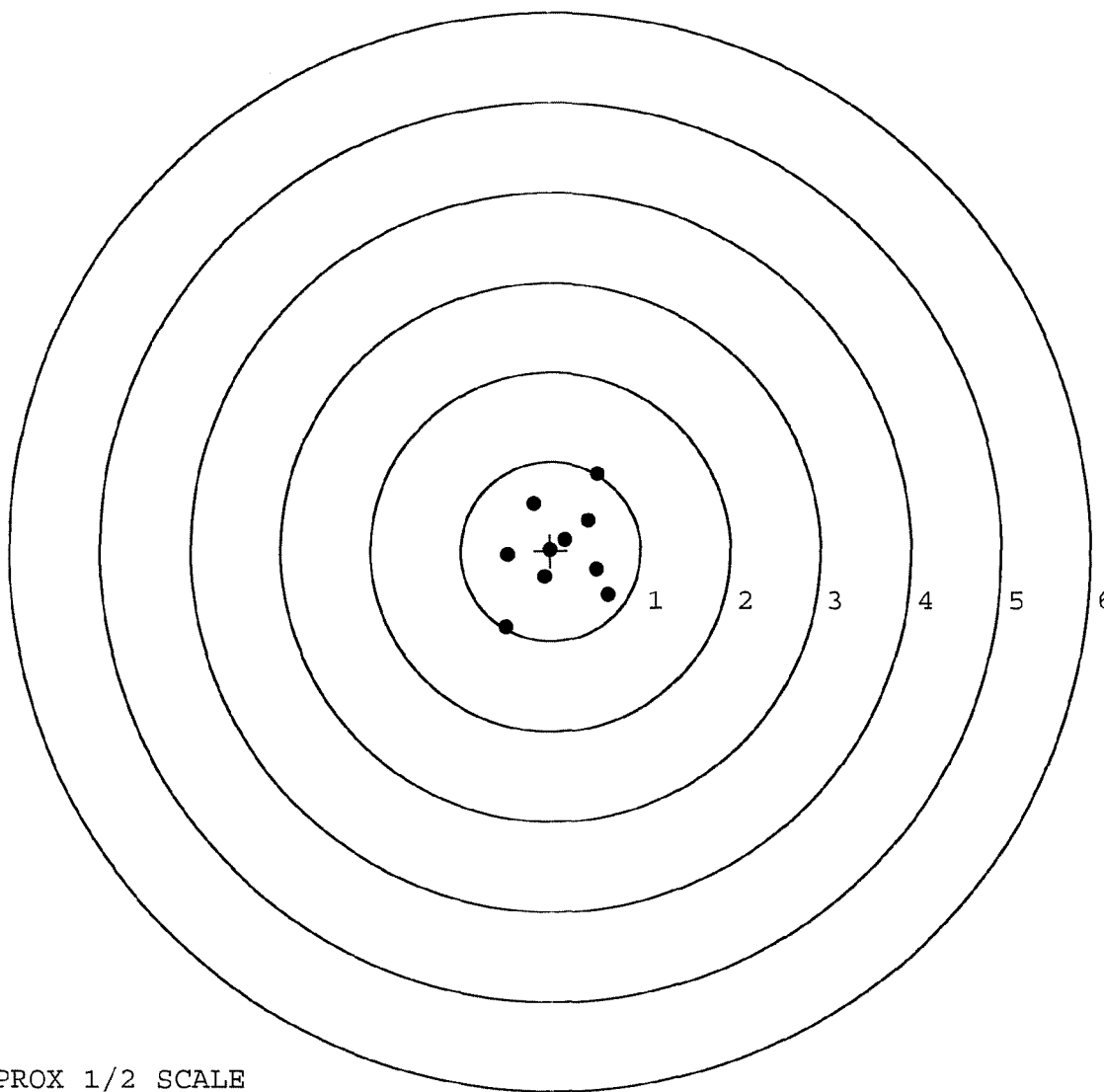


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6523372. 0
TARGET NUMBER: 3
FILE DATE: 04/09/2009
FILE TIME: 05:26

X CENTROID: 0.099
Y CENTROID: -0.004
POA TO CENTROID: 0.099
HORZ SPREAD: 1.144
VERT SPREAD: 1.714
GROUP SPREAD: 1.998
MIN RADIUS: 0.112
MAX RADIUS: 1.042
MEAN RADIUS: 0.544
IN 1 IN DIAMETER: 5
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.522	0.861
2:	-0.188	0.528
3:	0.417	0.345
4:	0.639	-0.493
5:	0.511	-0.212
6:	-0.505	-0.853
7:	-0.477	-0.052
8:	-0.071	-0.298
9:	-0.012	0.011
10:	0.155	0.124



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6523372. __0

TARGET NUMBER: 4

FILE DATE: 04/09/2009

FILE TIME: 05:26

X CENTROID: -0.006

Y CENTROID: 0.053

POA TO CENTROID: 0.054

HORZ SPREAD: 1.875

VERT SPREAD: 2.131

GROUP SPREAD: 2.282

MIN RADIUS: 0.167

MAX RADIUS: 1.442

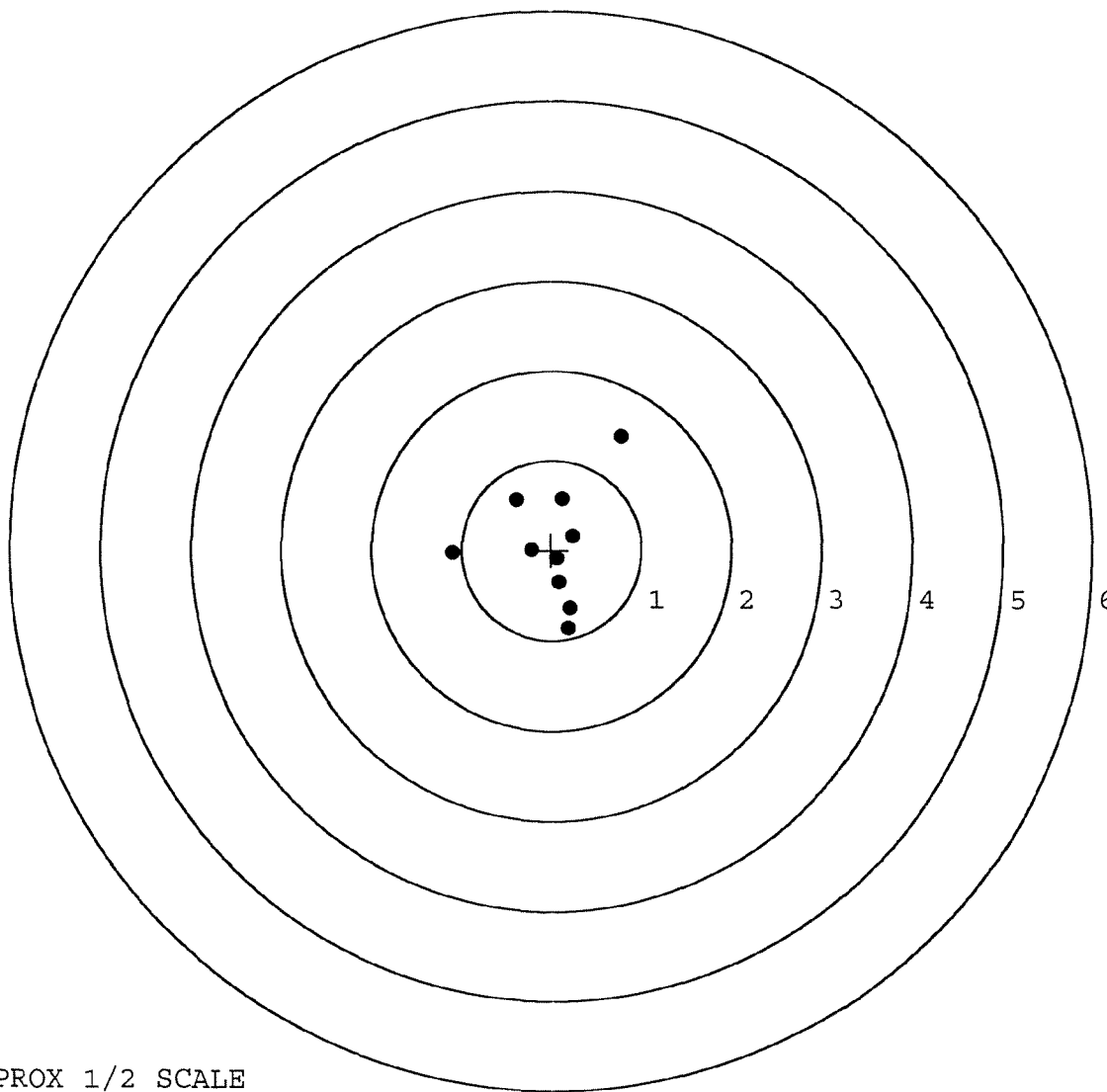
MEAN RADIUS: 0.645

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.777	1.264
2:	-0.396	0.555
3:	0.117	0.572
4:	-1.098	-0.037
5:	0.230	0.156
6:	-0.222	0.003
7:	0.182	-0.867
8:	0.202	-0.653
9:	0.084	-0.361
10:	0.062	-0.099



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6523372. 0

TARGET NUMBER: 5

FILE DATE: 04/09/2009

FILE TIME: 05:26

X CENTROID: 0.069

Y CENTROID: 0.029

POA TO CENTROID: 0.075

HORZ SPREAD: 1.473

VERT SPREAD: 1.144

GROUP SPREAD: 1.644

MIN RADIUS: 0.041

MAX RADIUS: 0.956

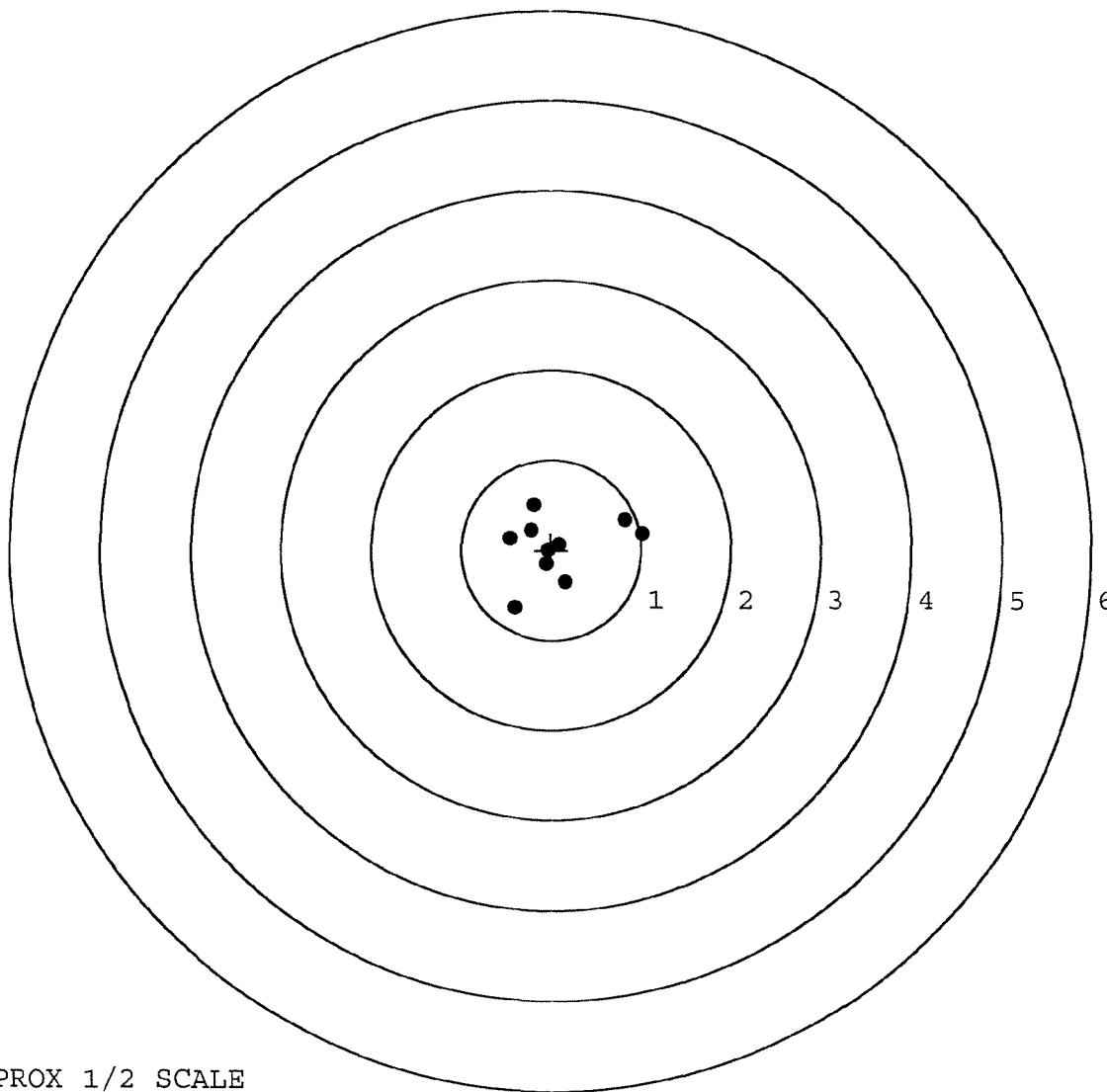
MEAN RADIUS: 0.480

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	1.012	0.183
2:	0.817	0.339
3:	-0.411	-0.641
4:	0.156	-0.354
5:	-0.054	-0.160
6:	0.090	0.064
7:	-0.195	0.503
8:	-0.461	0.129
9:	-0.034	0.000
10:	-0.232	0.224



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: **RE00092472** Serial: C6523372 Model: M24 SWS Center Fire Caliber: 7.62 NATO Produced: 12/19/1990 Repairman: Status: Closed 2/4/2005 9:38:05 AM

Verify Repair

Address Information

Customer: ☒ Received From Return To: ☐ Received From

Name: **DEF DIST DEPOT ANNISTON** **DEF DIST DEPOT ANNISTON**

Address 1: Address 2: PO Box: PO Box:

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

State: **AL** Zip Code: **362014199** Country: **US** State: **AL** Zip Code: **362014199** Country: **US**

FFL: ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐

Contact / Condition Problems Estimate History / Status Shipping / Billing

Contact Information: Phone: Fax: Email: Comments:

Received Condition: Good Condition Notes: CSR Notes:

Accessories Received:

Code	Desc	Qty
A007	With Stud	3
A010	Hard Case	1
A017	Scope Base	1
A026	Scope	1
A057	Fit and Rear Sgt Base	1

Repair Search Refresh Close

neglet 2/7/2005 11:28 AM CAPS NUM INS SCPL

start 3 3 M

Serial Number: **C6523372**

Model: **M24 SWS**



RE00092472

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6523372.__0
FILE DATE AND TIME: 05/03/2005 06:42

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.042
The Average Y Centroid of the Five Target Set:	0.104
The Average Point of Impact of the Five Target Set:	0.112
The Average Mean Radius of the Five Target Set:	0.993
The Distance from POA to Centroid Target #1:	0.837
The Distance from Centroid Target #2 to Centroid Target #1:	0.971
The Distance from Centroid Target #3 to Centroid Target #1:	1.080
The Distance from Centroid Target #4 to Centroid Target #1:	0.874
The Distance from Centroid Target #5 to Centroid Target #1:	0.884

SERIAL NUMBER: C6523372. 0

TARGET NUMBER: 1

FILE DATE: 05/03/2005

FILE TIME: 06:42

X CENTROID: -0.100

Y CENTROID: 0.831

POA TO CENTROID: 0.837

HORZ SPREAD: 2.146

VERT SPREAD: 2.924

GROUP SPREAD: 3.011

MIN RADIUS: 0.467

MAX RADIUS: 1.702

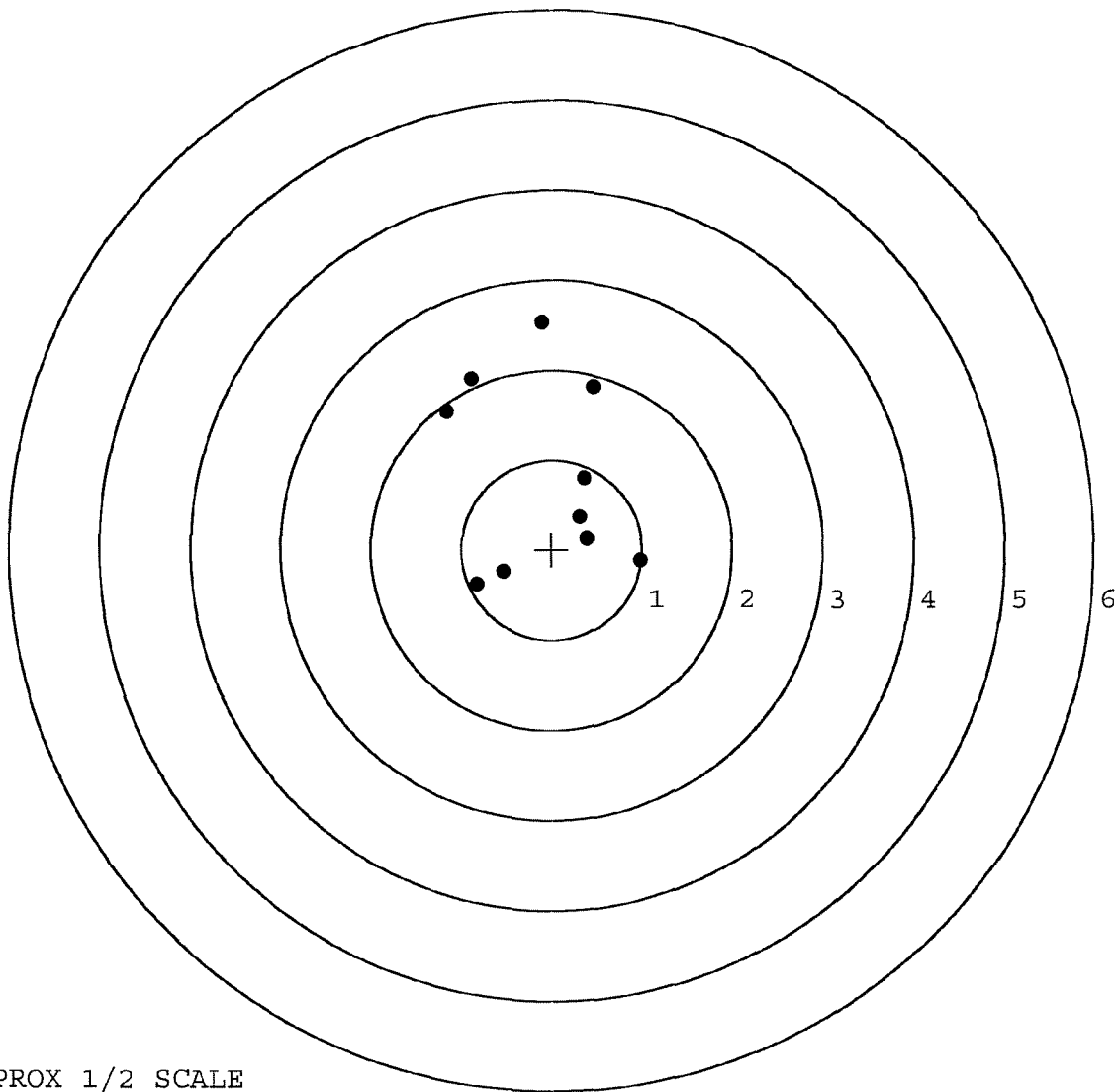
MEAN RADIUS: 1.142

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 3

in 3 IN DIAMETER: 9

POINT#	X	Y
1:	0.986	-0.123
2:	0.394	0.126
3:	0.310	0.365
4:	0.365	0.798
5:	-0.535	-0.253
6:	-0.830	-0.391
7:	-1.160	1.537
8:	-0.886	1.906
9:	-0.110	2.533
10:	0.462	1.808



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6523372. __0

TARGET NUMBER: 2

FILE DATE: 05/03/2005

FILE TIME: 06:42

X CENTROID: -0.106

Y CENTROID: -0.141

POA TO CENTROID: 0.176

HORZ SPREAD: 2.907

VERT SPREAD: 2.249

GROUP SPREAD: 2.925

MIN RADIUS: 0.380

MAX RADIUS: 1.942

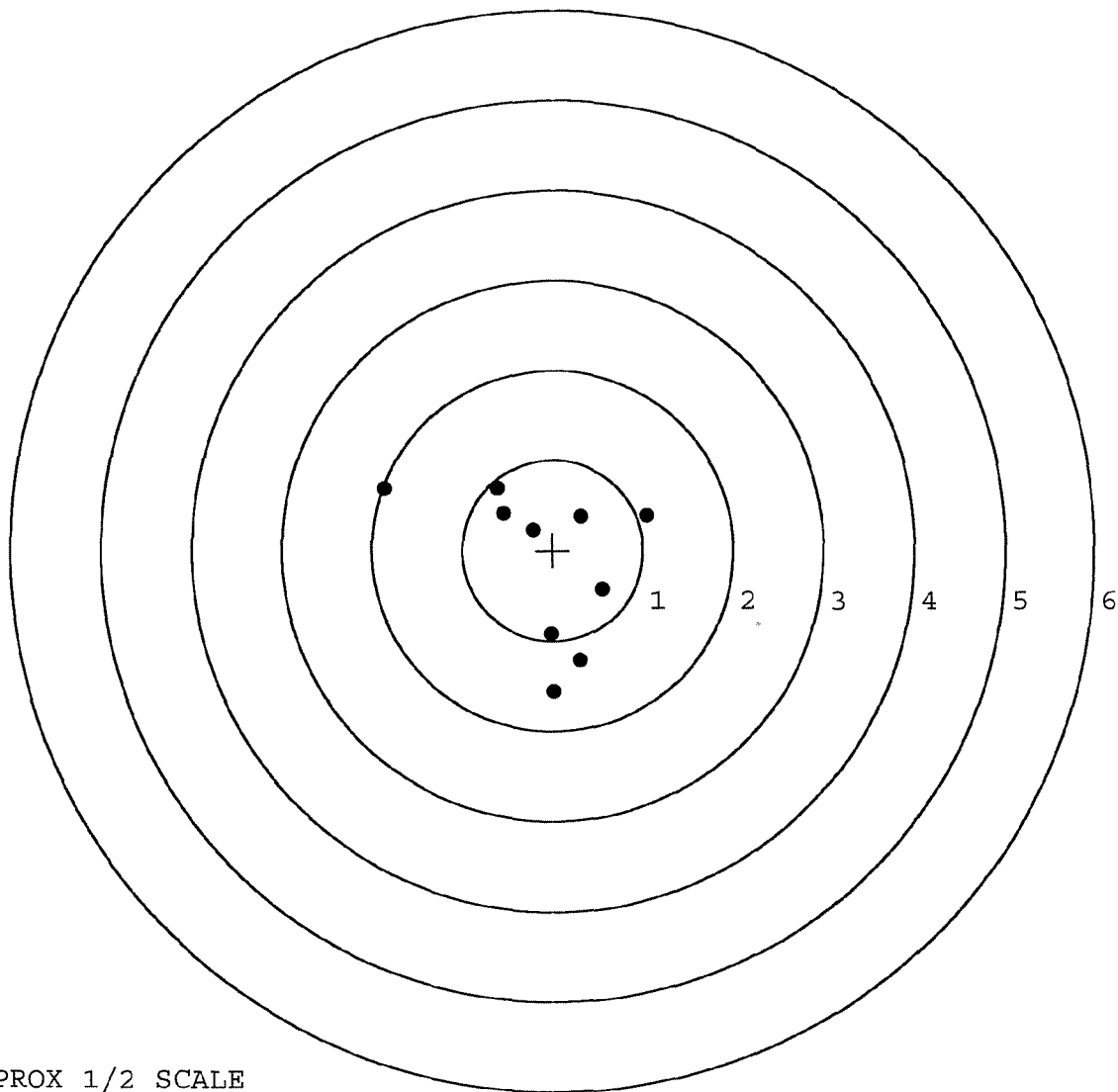
MEAN RADIUS: 1.001

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 9

POINT#	X	Y
1:	0.007	-1.568
2:	0.303	-1.223
3:	-0.014	-0.929
4:	0.548	-0.430
5:	1.041	0.385
6:	0.308	0.373
7:	-0.220	0.222
8:	-0.551	0.402
9:	-0.614	0.681
10:	-1.866	0.679

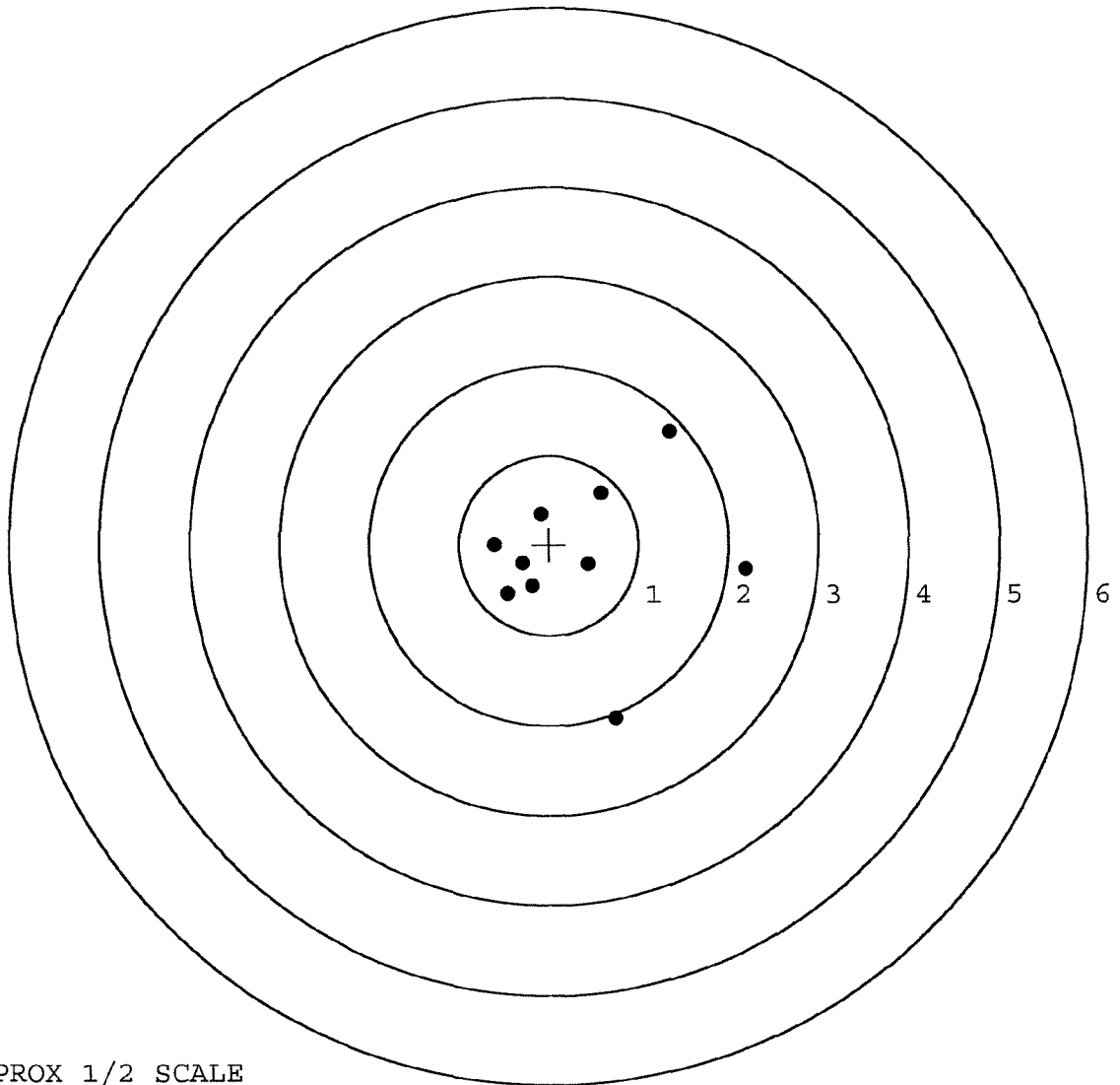


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6523372. __0
TARGET NUMBER: 3
FILE DATE: 05/03/2005
FILE TIME: 06:42

X CENTROID: 0.362
Y CENTROID: -0.145
POA TO CENTROID: 0.390
HORZ SPREAD: 2.803
VERT SPREAD: 3.188
GROUP SPREAD: 2.817
MIN RADIUS: 0.105
MAX RADIUS: 1.834
MEAN RADIUS: 1.011
IN 1 IN DIAMETER: 1
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 7

POINT#	X	Y
1:	2.191	-0.279
2:	0.734	-1.925
3:	1.343	1.263
4:	0.578	0.584
5:	0.437	-0.219
6:	-0.097	0.341
7:	-0.612	0.003
8:	-0.298	-0.212
9:	-0.190	-0.465
10:	-0.468	-0.543



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6523372. __0

TARGET NUMBER: 4

FILE DATE: 05/03/2005

FILE TIME: 06:42

X CENTROID: 0.233

Y CENTROID: 0.023

POA TO CENTROID: 0.234

HORZ SPREAD: 2.193

VERT SPREAD: 2.200

GROUP SPREAD: 2.397

MIN RADIUS: 0.308

MAX RADIUS: 1.442

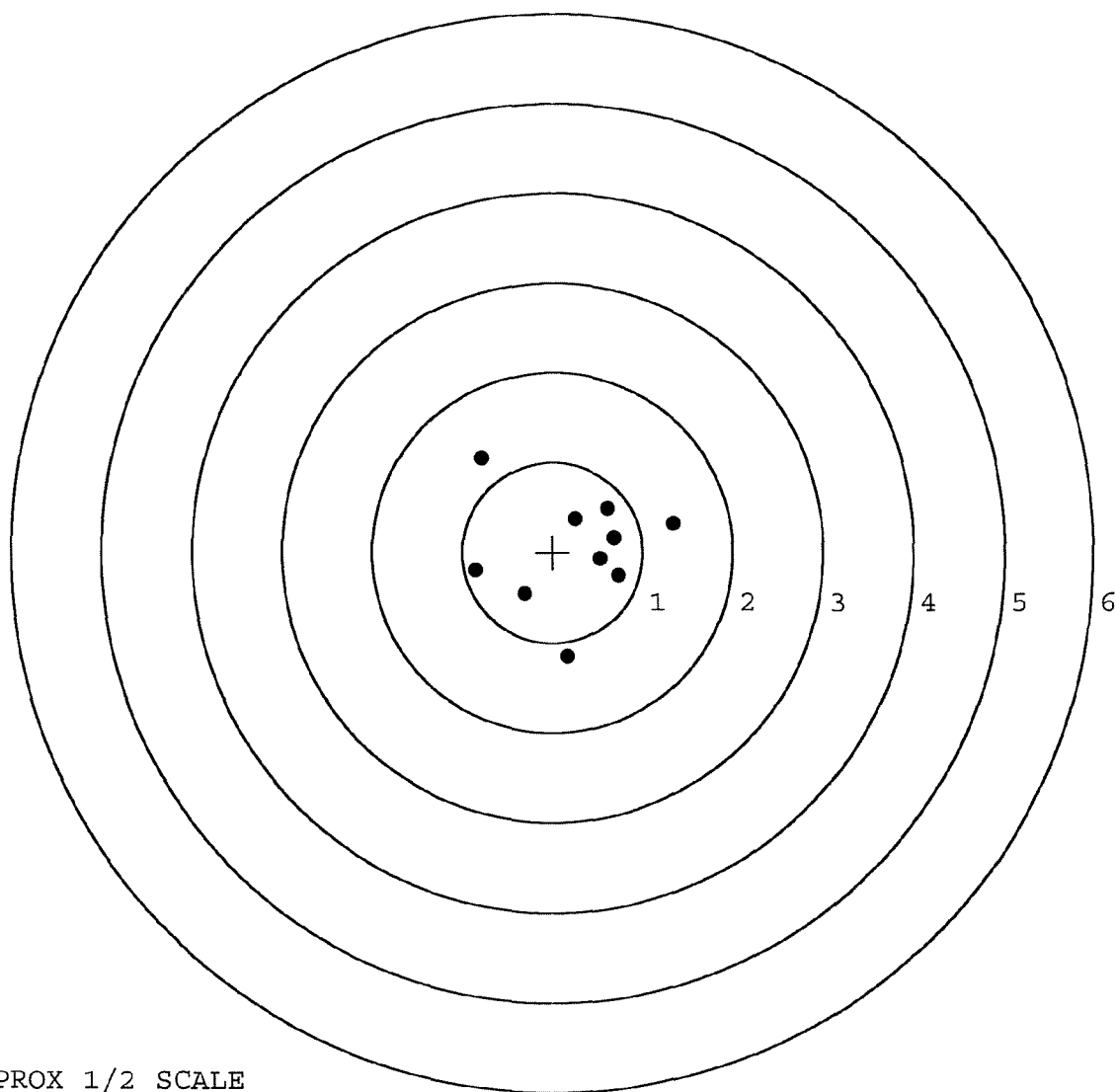
MEAN RADIUS: 0.791

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	1.335	0.314
2:	-0.787	1.042
3:	0.610	0.488
4:	0.250	0.371
5:	0.527	-0.070
6:	0.732	-0.257
7:	0.164	-1.158
8:	-0.319	-0.465
9:	-0.858	-0.200
10:	0.676	0.163

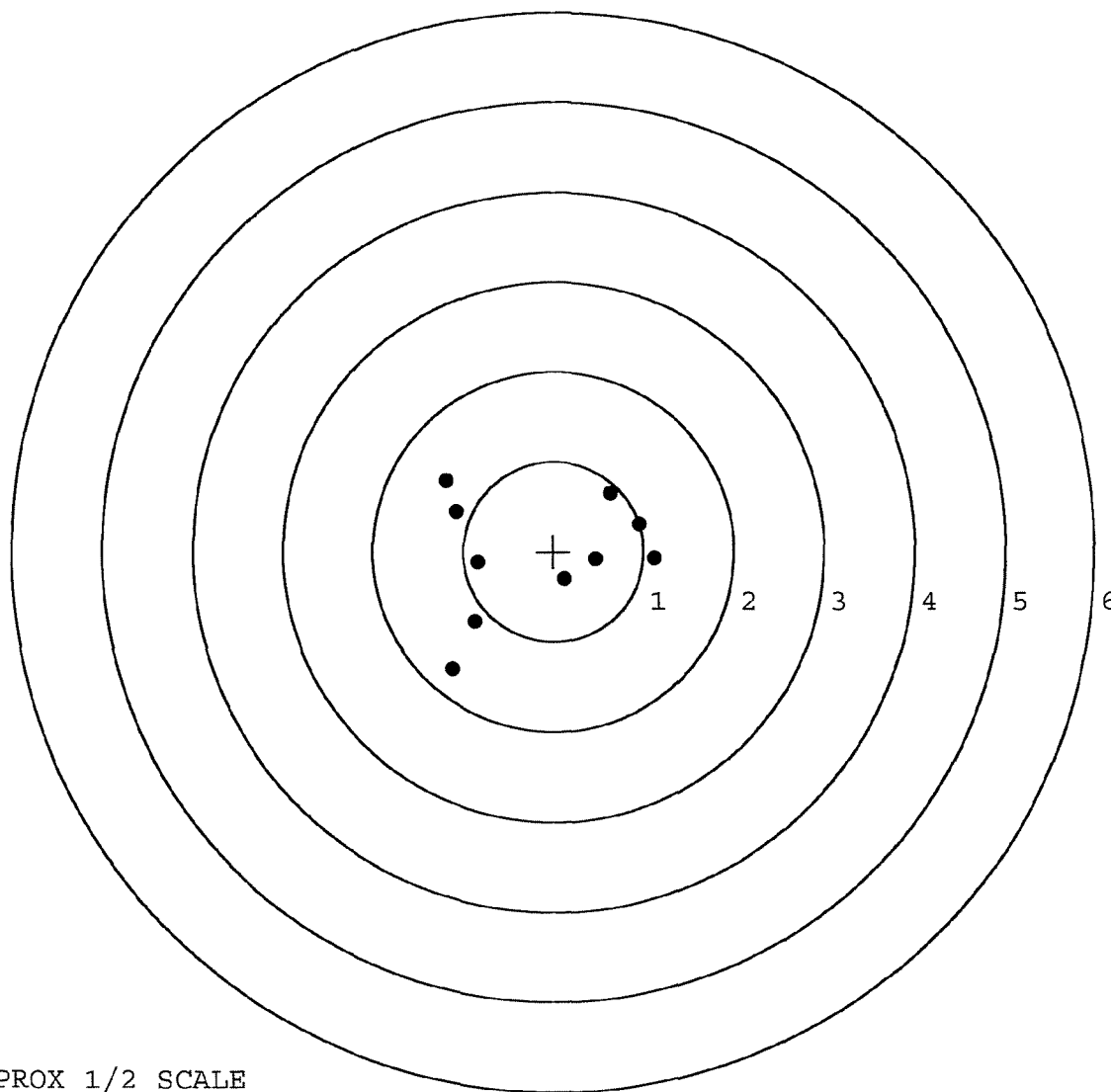


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6523372. __0
TARGET NUMBER: 5
FILE DATE: 05/03/2005
FILE TIME: 06:42

X CENTROID: -0.179
Y CENTROID: -0.050
POA TO CENTROID: 0.186
HORZ SPREAD: 2.313
VERT SPREAD: 2.105
GROUP SPREAD: 2.635
MIN RADIUS: 0.398
MAX RADIUS: 1.578
MEAN RADIUS: 1.019
IN 1 IN DIAMETER: 1
IN 2 IN DIAMETER: 3
in 3 IN DIAMETER: 9

POINT#	X	Y
1:	1.124	-0.076
2:	0.473	-0.083
3:	0.948	0.312
4:	0.631	0.653
5:	0.124	-0.307
6:	-0.834	-0.126
7:	-0.867	-0.781
8:	-1.116	-1.319
9:	-1.085	0.444
10:	-1.189	0.786



TARGET APPROX 1/2 SCALE

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

R & E NUMBER	92477		
SERIAL NUMBER	C6523372		
LOG-IN DATE	2-4-05		
INSPECT AND VERIFY:			
OPERATION #	OPERATION NAME	DATE	INITIAL
550	DIS-ASSEMBLE GUN	4-4-05	RTZ
560 A	RE-BARREL	4-7-05	RTZ
B	DRILL AND TAP	4-7-05	RTZ
575	ASSEMBLE	4-11-05	TRW
600	PROOF	4-8-05	AC
605	CHECK HEADSPACE	4-8-05	AC
610	DIS-ASSEMBLE GUN	4-11-05	RTZ
612	MAGNAFLUX	OPERATOR	BS
615	ROLLMARK CALIBER	4-12-05	CW
618	ROTO-BLAST	4-18-05	MB
620	APPLY COATINGS	4-25-05	WJ
625 A	FINAL ASSEMBLY	4-29-05	RTZ
B	TRIGGER PULL TEST		
C	SAFETY "ON" FORCE	5-10-05	AC
D	SAFETY "OFF" FORCE	5-10-05	AC
E	FIRING PIN INDENT	5-10-05	AC
640	TARGET	5-3-05	TRW
655	FINAL INSPECT	5-10-05	AC
660	PACK	5-11-05	RA
		SHIP DATE	
		QAR INSPECTION DATE	

GFM

CONTRACT # DAAA21-87-C-0086

Repair

GUN SERIAL # C6523372

OP. #	OP. NAME	READINGS	DATE	INIT
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		2/23/93	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		2/23/93	RW
	C) Inspect Ejector Hole for Chamfer		2/23/93	RW
	D) Oil Firing Pin Ass'y		2/23/93	RW
	E) Adjust Trigger Pull to Min Setting and Stake		2/23/93	RW

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			2/23/93	RW
	G) Safety Off Force	2	2	2			2/23/93	RW
	H) Trigger Pull Test & Retainability						2/23/93	RW
	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						2/23/93	RW
	P) Detach & Attach Scope 20 Times							
640	Gallery Target & Test						2/26/93	RW
	A) Time							
	B) Malfunctions							
	C) Pierced Primers							
	D) Optical Clarity of Scope							
645	Inspect for Live Ammo						2/26/93	RW
655	Final Inspection							
	A) Headspace						3/4/93	RW
	B) Trigger Pull	2.49	2.53	2.47	2.50	2.49	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. C6523372

DATE 2/23/93

TESTER RW

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#	COMMENTS
PULL #1	2.66	2.70	2.76	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.63	2.61	2.72	
PULL #3	2.59	2.66	2.77	
PULL #4	2.57	2.60	2.77	
PULL #5	2.59	2.64	2.72	
TOTAL	13.04	13.21	13.74	
AVG.	2.61	2.64	2.75	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.23	3.14		
PULL #2	3.10	3.17		
PULL #3	3.15	3.20		
PULL #4	3.17	3.20		
PULL #5	3.08	3.20		
TOTAL	15.73	15.91		
AVG.	3.15	3.18		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.04	4.00		4.27
PULL #2	4.04	4.07		4.27
PULL #3	4.05	4.05		4.29
PULL #4	4.06	4.02		4.29
PULL #5	4.05	4.00		4.31
TOTAL	20.24	20.14		21.43
AVG.	4.05	4.03		4.29

RECEIVING AND ESTIMATING REPORT

COMMENTS

ORDER

R 93-02441

INITIAL
FPS

CUSTOMER ORDER NO.

MOG 11 OF 30 W/10X SCOPE & DEPLOYMENT KIT
M24

DATE RECEIVED

DATE OPENED

DATE CODE

SERIAL NUMBER

NEW SERIAL NUMBER

MODEL AND GRADE

-1/25/93

01/25/93

DK 9-90

06523372

700 7-62

NATO

ACCESSORIES

W/STUDS

W/SWIVELS

SOFT CASE

SCOPE BASE

FROM:

SHIP TO:

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

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

BOLT ASSY.

B3

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

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

M2400026934

Remington[®] **DUPONT**
REG. U.S. PAT. & TM. OFF.

MODEL 700TM H24

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

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

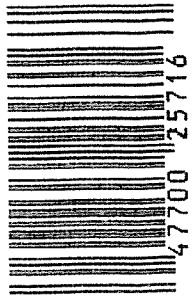
SERIAL NO. C6523372	ORDER NO. 5716
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01



5716 C6523372

UPC



0 47700 125716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6523372

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	9 24	90	RW
600	Proof	9 24	90	RW
607	Check Headspace	9 24	90	RW
610	Dis-assemble Gun	9 24	90	RW
612	Magnaflux Barrel Action		9-25-90	KR
	Magnaflux Bolt		9-25-90	KR
615	Rollmark Caliber		9-25-90	SS
617	Drill and Tap Sight Holes		9-25-90	FB
618	Polish Barrel RB		9/28/90	WB
620	Apply Coatings (Barrel Action)		10-2-90	TS
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		10/9/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/9/90	RW
	C) Inspect Ejector Hole for Chamfer		10/9/90	RW
	D) Oil Firing Pin Ass'y		10/9/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		10/31/90	JH

op. #	OP. NAME	READINGS					DATE	INIT
625 nt.	F) Safety On Force	4 1/2	4 1/2	4 1/2			10/31/90	WB
	G) Safety Off Force	2	2	2			10/31/90	WB
	H) Trigger Pull Test & Retainability						10/31/90	W
	I) Firing Pin Indent	.0225	.0225	.023			10/31/90	WB
	J) Assemble Stock						10/31/90	RW
	K) Assemble Swivel Studs						11/19/90	928
	L) Attach Front and Rear Sight Assemblies						10/31/90	RW
	M) Iron Sight Alignment						10/31/90	RW
	N) Detach Front & Rear Sights & place in numbered container						10/31/90	RW
	O) Attach Scope to Rifle						10/31/90	RW
	P) Detach & Attach Scope 20 Times						10/31/90	RW
640	Gallery Target & Test						10/31/90	NF
	A) Time						"	NF
	B) Malfunctions						"	NF
	C) Pierced Primers						"	NF
	D) Optical Clarity of Scope						"	NF
645	Inspect for Live Ammo						10/31/90	NF
655	Final Inspection							
	A) Headspace						11/19/90	928
	B) Trigger Pull	216	223	218	219	223	11/19/90	928
	C) Function						11/19/90	928
660	Pack						12/18/90	NF

SWS TRIGGER PULL TEST

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

SERIAL NO. C6523372

DATE 10/31/90

TESTER JPL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.37	2.48	2.51	2.16	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.45	2.43	2.46	2.23	
PULL #3	2.43	2.40	2.43	2.18	
PULL #4	2.44	2.30	2.48	2.19	
PULL #5	2.44	2.46	2.40	2.23	
TOTAL	12.13	12.07	12.28		
AVG.	2.426	2.414	2.456		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.29	3.18		
PULL #2	3.12	3.20		
PULL #3	3.31	3.22		
PULL #4	3.11	3.26		
PULL #5	3.25	3.15		
TOTAL	16.08	16.01		
AVG.	3.216	3.202		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.29	4.34		4.21
PULL #2	4.29	4.20		4.33
PULL #3	4.20	4.50		4.32
PULL #4	4.30	4.45		4.28
PULL #5	4.33	4.41		4.43
TOTAL	21.41	21.90		21.57
AVG.	4.282	4.38		4.314

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6523372
1 Nov 1990

CENTROIDAL DISTANCES

0 TO	1	.143422
1 TO	2	.126436
1 TO	3	.353244
1 TO	4	.113759
1 TO	5	.400824

#3 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0362
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1014
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .107668
THE AMR FOR THIS RIFLE IS: 1.344

1 Nov 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6523372

CENTERFIRE PATTERNS

1

POA

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 0

2 in = 6

3 in = 9

HS= 1.735

VS= 2.603

GS= 2.808

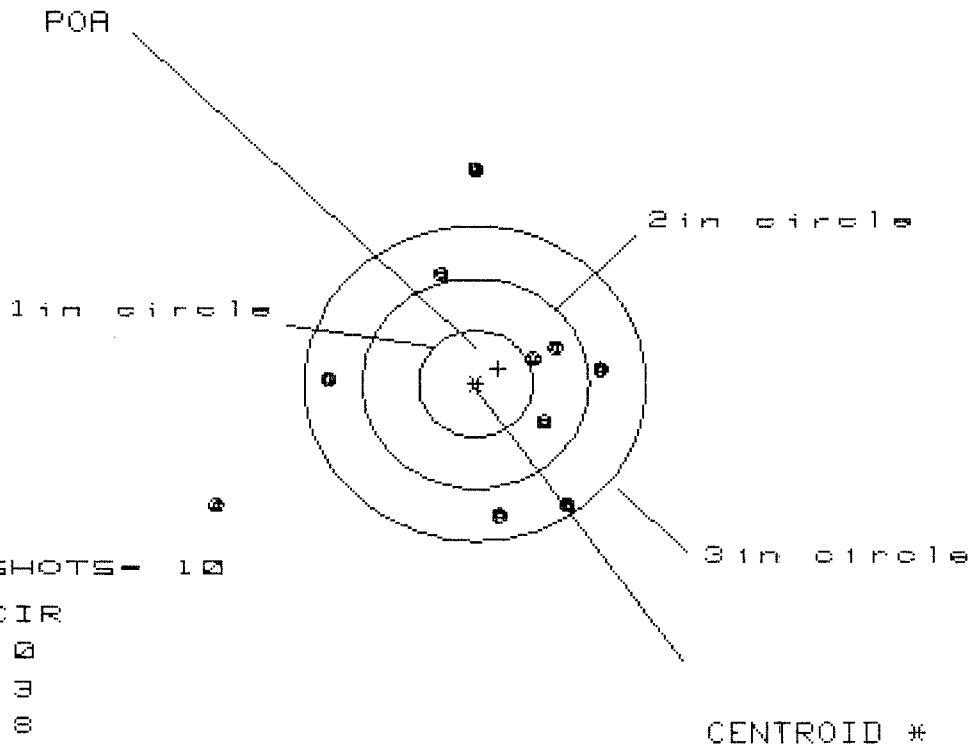
CENTROID #

PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.777	.854	.743
MINIMUM X	:	-.958	-.881	-.931
MAXIMUM Y	:	1.202	1.046	1.136
MINIMUM Y	:	-1.401	-1.119	-1.029
CENTROID X	:	-.077	-.154	-.043
CENTROID Y	:	-.121	.035	-.055
POA TO CENTROID in.	:	.143	.158	.070
MIN RADIUS	:	.589	.452	.588
MEAN RADIUS	:	.988	.907	.875
MAX RADIUS	:	1.560	1.182	1.154
HORIZONTAL SPREAD	:	1.735	1.735	1.674
VERTICAL SPREAD	:	2.603	2.165	2.165
EXTREME SPREAD	:	2.808	2.318	2.168
NUMBER IN ONE INCH CIRCLE	=	0		
NUMBER IN TWO INCH CIRCLE	=	6		
NUMBER IN THREE INCH CIRCLE	=	9		

1 Nov 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6523372

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 0

2 in = 3

3 in = 8

HS= 3.350

VS= 3.231

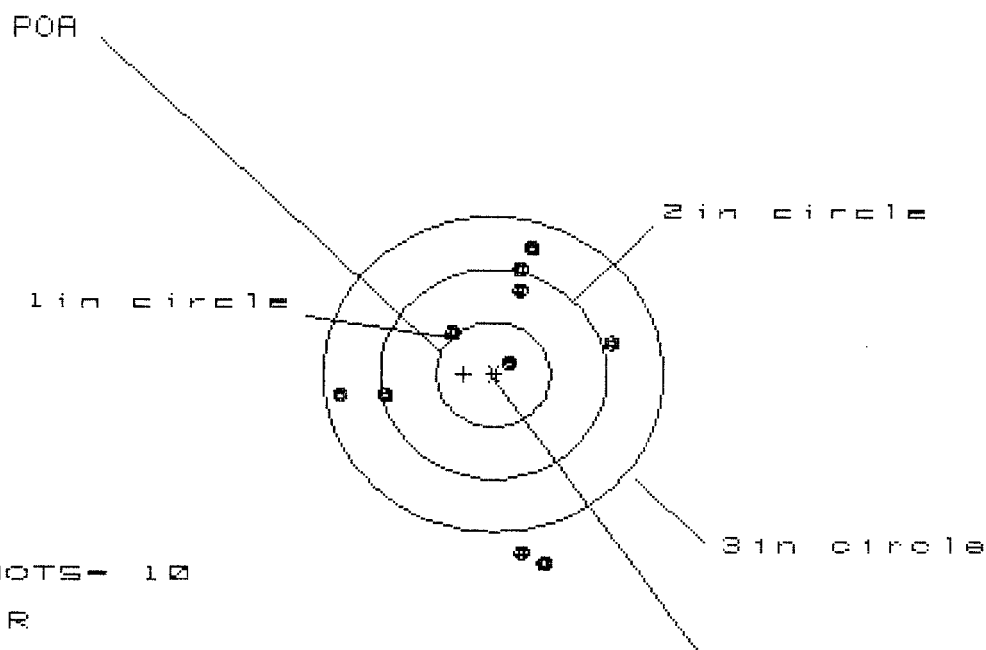
GS= 3.961

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.054	.798	.771
MINIMUM X	:	-2.296	-1.552	-1.579
MAXIMUM Y	:	2.011	1.879	1.125
MINIMUM Y	:	-1.220	-1.352	-1.118
CENTROID X	:	-.202	.054	.081
CENTROID Y	:	-.140	-.008	-.243
POA TO CENTROID in.	:	.245	.054	.256
MIN RADIUS	:	.523	.236	.392
MEAN RADIUS	:	1.271	1.044	.928
MAX RADIUS	:	2.587	1.892	1.591
HORIZONTAL SPREAD	:	3.350	2.350	2.350
VERTICAL SPREAD	:	3.231	3.231	2.243
EXTREME SPREAD	:	3.961	3.273	2.481
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		8	

1 Nov 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6523372

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in - 2

2 in - 4

3 in = 8

HS- 2.431

VS= 2.972

GS= 2.974

CENTROID *

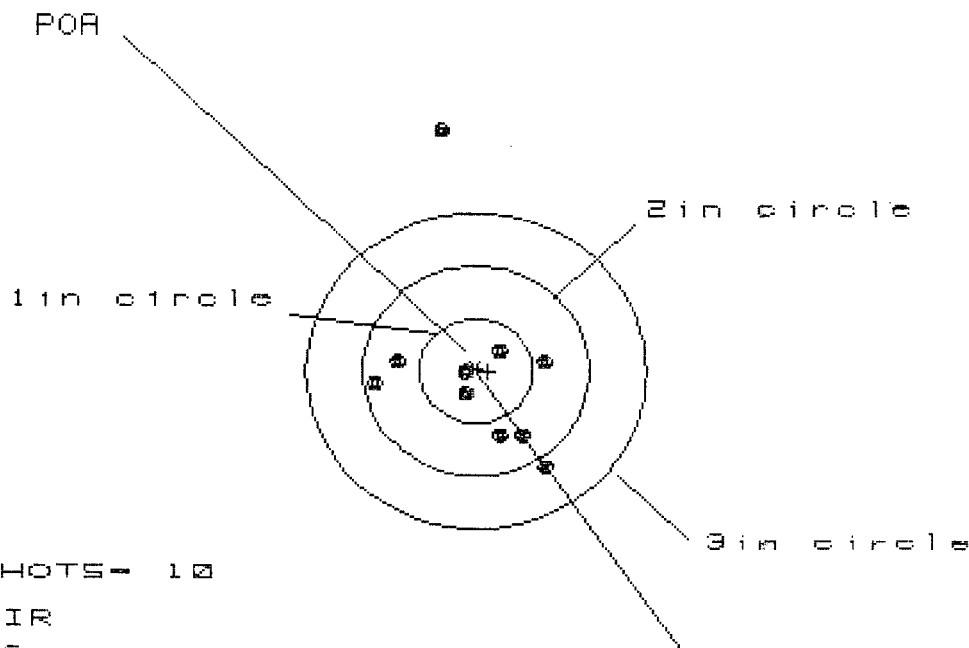
PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	1.089
MINIMUM X	-1.342
MAXIMUM Y	1.226
MINIMUM Y	-1.746
CENTROID X	.257
CENTROID Y	-.006
POA TO CENTROID in.	.257
MIN RADIUS	.189
MEAN RADIUS	1.082
MAX RADIUS	1.794
HORIZONTAL SPREAD	2.431
VERTICAL SPREAD	2.972
EXTREME SPREAD	2.974
NUMBER IN ONE INCH CIRCLE =	2
NUMBER IN TWO INCH CIRCLE =	4
NUMBER IN THREE INCH CIRCLE =	8

1 Nov 1990

FILE:/PATTERNING/CENTERFIRE_PATT/CG523372

CENTERFIRE PATTERNS

4



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 8

3 in = 9

HS= 1.501

VS= 3.179

GS= 3.315

CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.642	.609	.604
MINIMUM X	:	-.859	-.892	-.816
MAXIMUM Y	:	2.245	.422	.336
MINIMUM Y	:	-.934	-.685	-.494
CENTROID X	:	-.106	-.073	-.149
CENTROID Y	:	.011	-.238	-.152
POA TO CENTROID in.	:	.106	.249	.213
MIN RADIUS	:	.126	.089	.075
MEAN RADIUS	:	.762	.565	.509
MAX RADIUS	:	2.264	.916	.817
HORIZONTAL SPREAD	:	1.501	1.501	1.420
VERTICAL SPREAD	:	3.179	1.107	.830
EXTREME SPREAD	:	3.315	1.701	1.436
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	

1 Nov 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6523372

CENTERFIRE PATTERNS

5

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 1

2in = 4

3in = 8

HS= 3.172

VS= 2.807

GS= 3.635

PATTERN #	:	5	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.994	1.399	1.387
MINIMUM X	:	-1.178	-.956	-.968
MAXIMUM Y	:	1.263	1.226	1.050
MINIMUM Y	:	-1.544	-1.403	-.866
CENTROID X	:	.309	.087	.099
CENTROID Y	:	-.229	-.370	-.194
POA TO CENTROID in.	:	.385	.380	.218
MIN RADIUS	:	.458	.237	.412
MEAN RADIUS	:	1.115	.931	.870
MAX RADIUS	:	2.361	1.433	1.470
HORIZONTAL SPREAD	:	3.172	2.355	2.355
VERTICAL SPREAD	:	2.807	2.629	1.716
EXTREME SPREAD	:	3.635	2.673	2.374
NUMBER IN ONE INCH CIRCLE =	:	1		
NUMBER IN TWO INCH CIRCLE =	:	4		
NUMBER IN THREE INCH CIRCLE =	:	8		

