C6523467
MODEL 700 TH H24
Model 5HS TH
Action
Barrel Length
Capacity
Order No. 57156
*Includes 1 in chamber.
Remington

10/25/07 09:04:21

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: RE00135765

Verify Repair

Serial: C6523467 Model M24 SWS Center Fire
Caliber: 7.62 NATO Produced: 12/18/1990

Repairman:

Status: Closed 10/24/2007 8:43:25 AM

Address Information

Customer:	Received From	Return To:	Received From
Name:	NEW MEXICO NATIONAL GUARD	NEW MEXICO NATIONAL GUARD	
Address 1:	BRENDA MALLARY	BRENDA MALLARY	
Address 2:	10 BATAAN BLVD PO Box:	10 BATAAN BLVD PO Box:	
City:	SANTA FE	SANTA FE	
State:	NM Zip Code: 87508 Country: US	State: NM Zip Code: 87508 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
A006	Sling Strap	1
A007	With Stud	3
A017	Scope Base	1
A026	Scope	1
A057	Frt and Rear Sgt Base	1

Repair Search | Refresh | Close

nagletj | 10/25/2007 | 9:04 AM | CAPS | NUM | INS | SCRL

start | 4 Mic... | 7 Int... | RACOI... | Arms S... | SAP Lo... | Part S... | 9:04 AM

Serial Number: C6523467

Model: M24 SWS

RE00135765

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFOMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6523467.__0
FILE DATE AND TIME: 12/07/2007 09:08

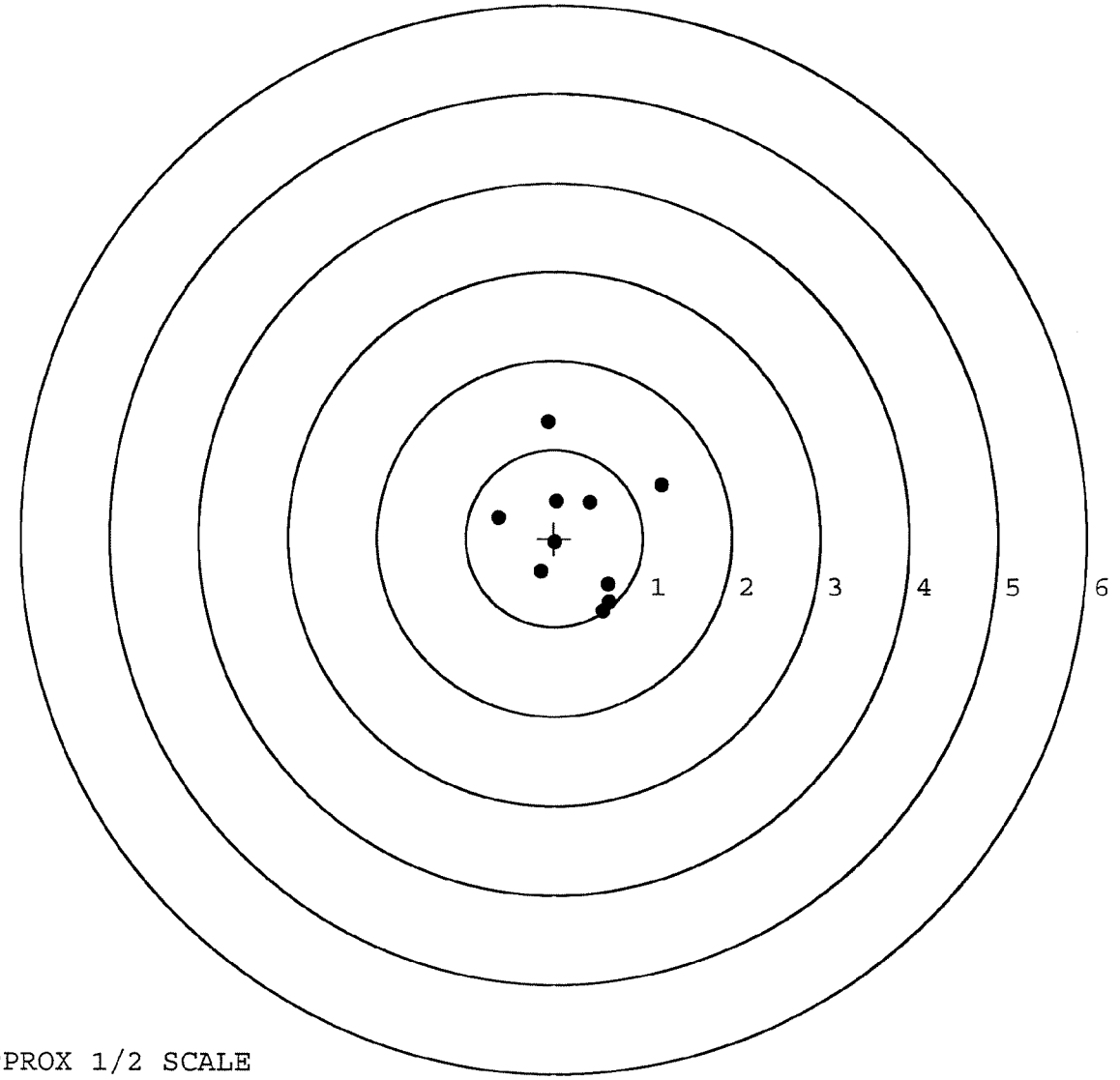
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.072
The Average Y Centroid of the Five Target Set:	-0.064
The Average Point of Impact of the Five Target Set:	0.096
The Average Mean Radius of the Five Target Set:	0.766
The Distance from POA to Centroid Target #1:	0.264
The Distance from Centroid Target #2 to Centroid Target #1:	0.076
The Distance from Centroid Target #3 to Centroid Target #1:	0.387
The Distance from Centroid Target #4 to Centroid Target #1:	0.272
The Distance from Centroid Target #5 to Centroid Target #1:	0.384

SERIAL NUMBER: C6523467.__0
TARGET NUMBER: 1
FILE DATE: 12/07/2007
FILE TIME: 09:08

X CENTROID:	0.260
Y CENTROID:	0.048
POA TO CENTROID:	0.264
HORZ SPREAD:	1.840
VERT SPREAD:	2.140
GROUP SPREAD:	2.230
MIN RADIUS:	0.264
MAX RADIUS:	1.305
MEAN RADIUS:	0.746
# IN 1 IN DIAMETER:	3
# IN 2 IN DIAMETER:	8
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	0.611	-0.525
2:	0.553	-0.830
3:	0.621	-0.733
4:	0.406	0.410
5:	0.032	0.422
6:	0.012	-0.041
7:	-0.147	-0.379
8:	-0.627	0.239
9:	1.213	0.605
10:	-0.073	1.310

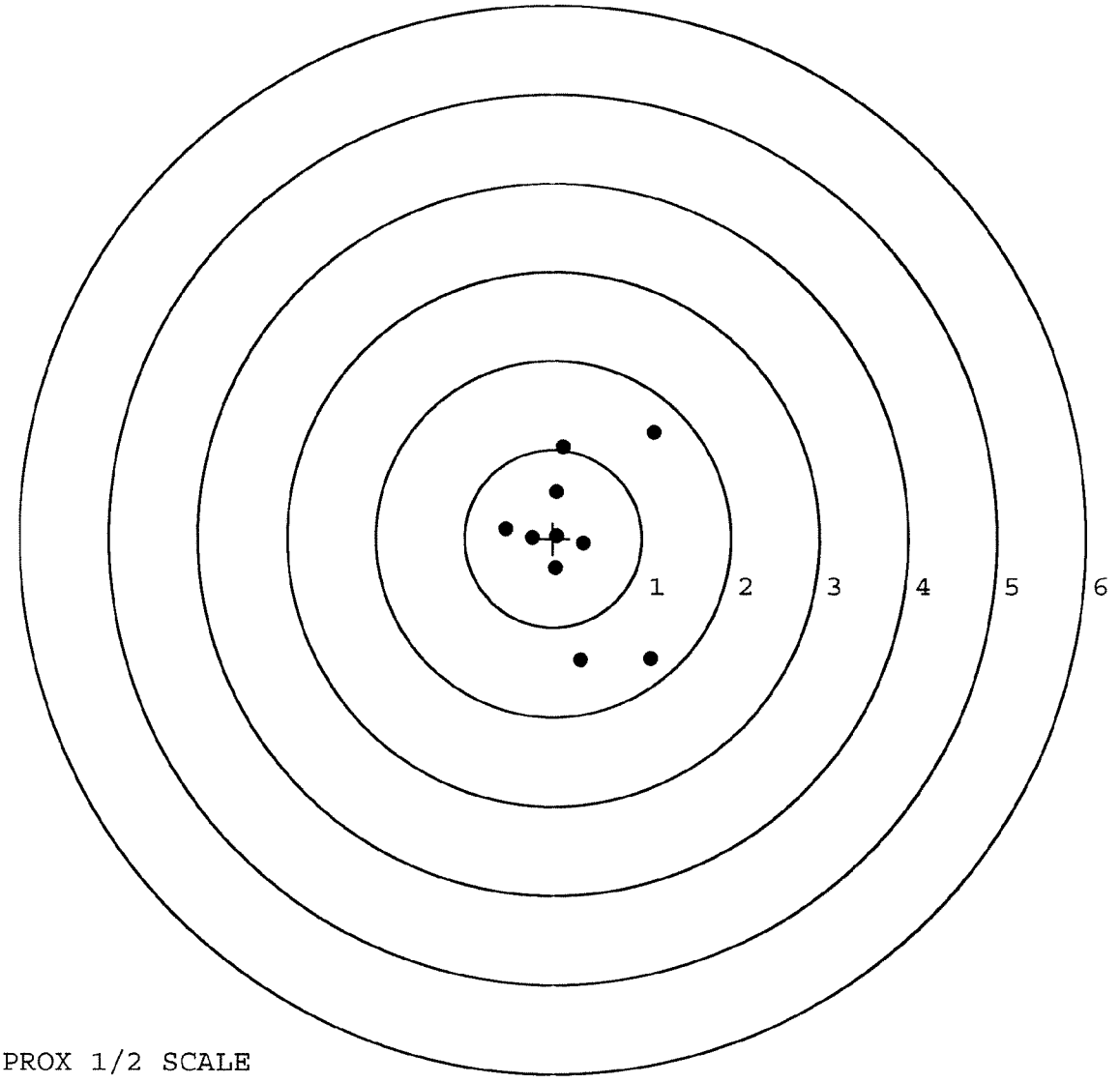


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6523467.__0
TARGET NUMBER: 2
FILE DATE: 12/07/2007
FILE TIME: 09:08

X CENTROID:	0.236
Y CENTROID:	-0.024
POA TO CENTROID:	0.237
HORZ SPREAD:	1.679
VERT SPREAD:	2.563
GROUP SPREAD:	2.582
MIN RADIUS:	0.115
MAX RADIUS:	1.591
MEAN RADIUS:	0.804
# IN 1 IN DIAMETER:	4
# IN 2 IN DIAMETER:	6
# in 3 IN DIAMETER:	8

POINT#	X	Y
1:	1.096	-1.362
2:	0.311	-1.374
3:	1.139	1.189
4:	0.118	1.028
5:	0.045	0.523
6:	0.345	-0.060
7:	0.032	-0.335
8:	0.045	0.031
9:	-0.235	0.013
10:	-0.540	0.108

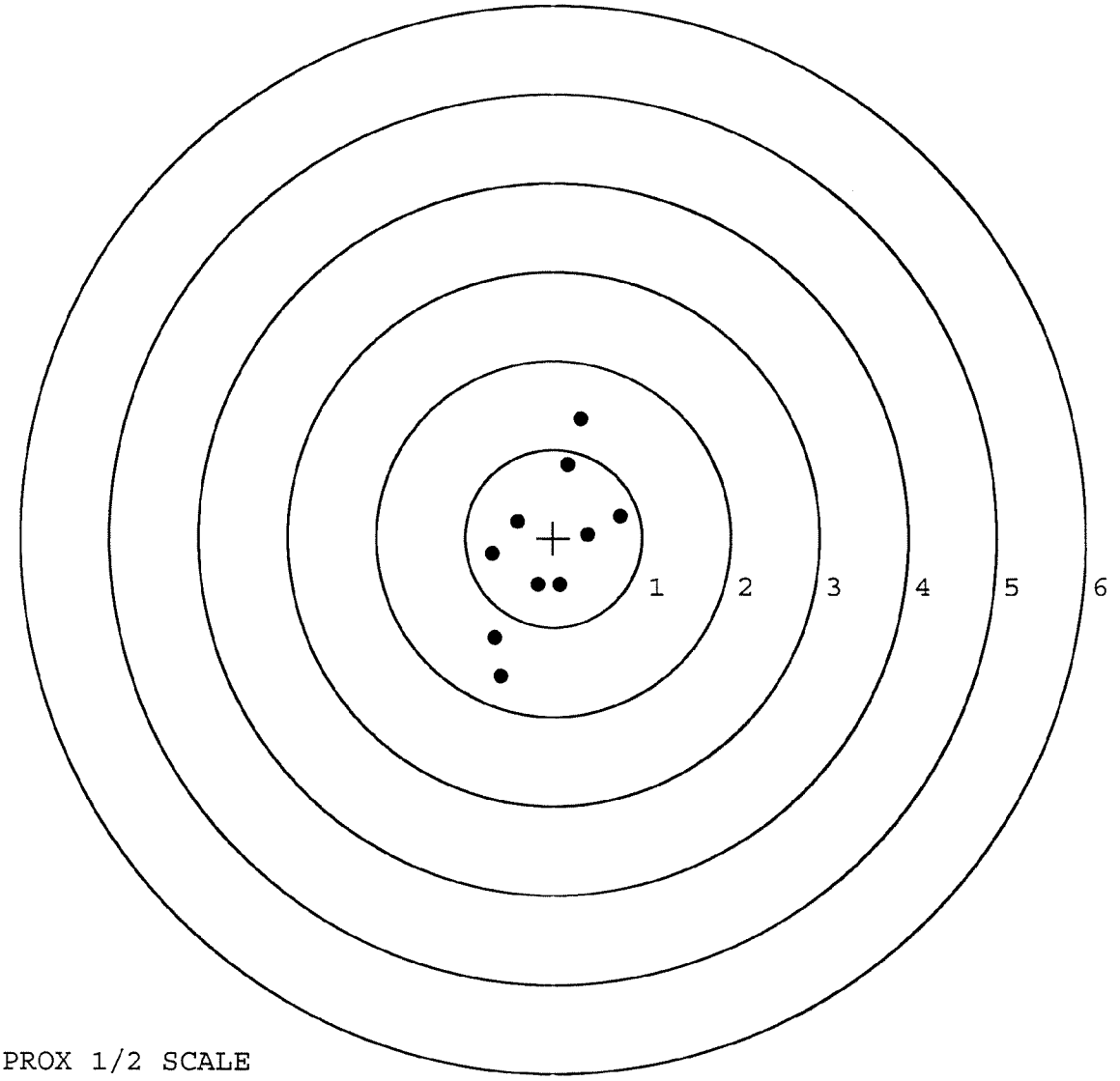


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6523467.__0
TARGET NUMBER: 3
FILE DATE: 12/07/2007
FILE TIME: 09:08

X CENTROID:	-0.084
Y CENTROID:	-0.129
POA TO CENTROID:	0.154
HORZ SPREAD:	1.447
VERT SPREAD:	2.903
GROUP SPREAD:	3.042
MIN RADIUS:	0.413
MAX RADIUS:	1.524
MEAN RADIUS:	0.851
# IN 1 IN DIAMETER:	3
# IN 2 IN DIAMETER:	7
# in 3 IN DIAMETER:	8

POINT#	X	Y
1:	0.309	1.344
2:	0.165	0.830
3:	0.757	0.245
4:	0.390	0.038
5:	-0.599	-1.559
6:	-0.665	-1.125
7:	0.076	-0.531
8:	-0.175	-0.531
9:	-0.406	0.183
10:	-0.690	-0.181

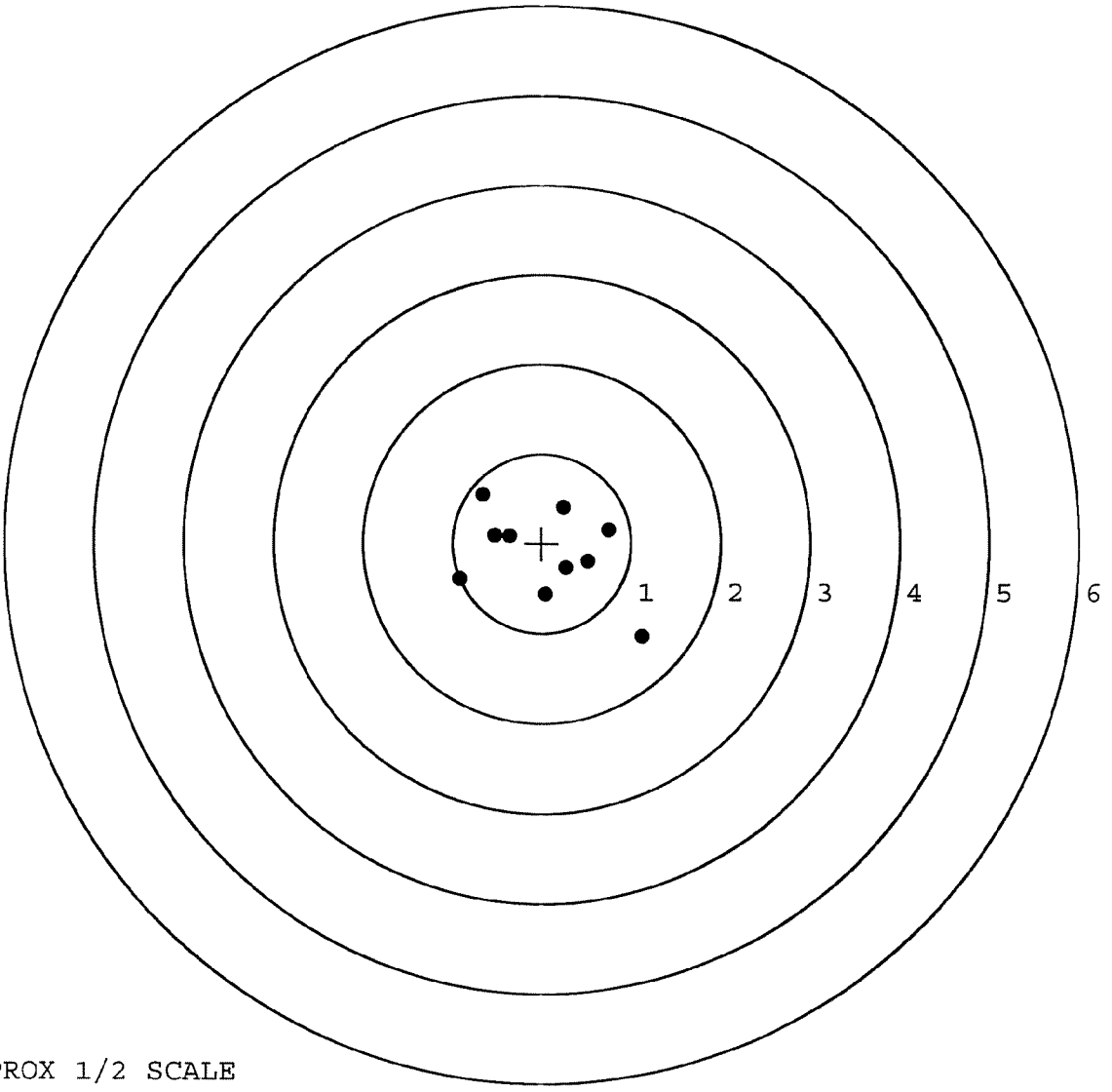


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6523467.__0
TARGET NUMBER: 4
FILE DATE: 12/07/2007
FILE TIME: 09:08

X CENTROID:	0.048
Y CENTROID:	-0.123
POA TO CENTROID:	0.132
HORZ SPREAD:	2.045
VERT SPREAD:	1.584
GROUP SPREAD:	2.388
MIN RADIUS:	0.267
MAX RADIUS:	1.415
MEAN RADIUS:	0.699
# IN 1 IN DIAMETER:	4
# IN 2 IN DIAMETER:	8
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	1.125	-1.041
2:	0.749	0.149
3:	0.246	0.406
4:	0.516	-0.203
5:	0.268	-0.274
6:	0.046	-0.580
7:	-0.527	0.093
8:	-0.920	-0.405
9:	-0.662	0.543
10:	-0.362	0.083

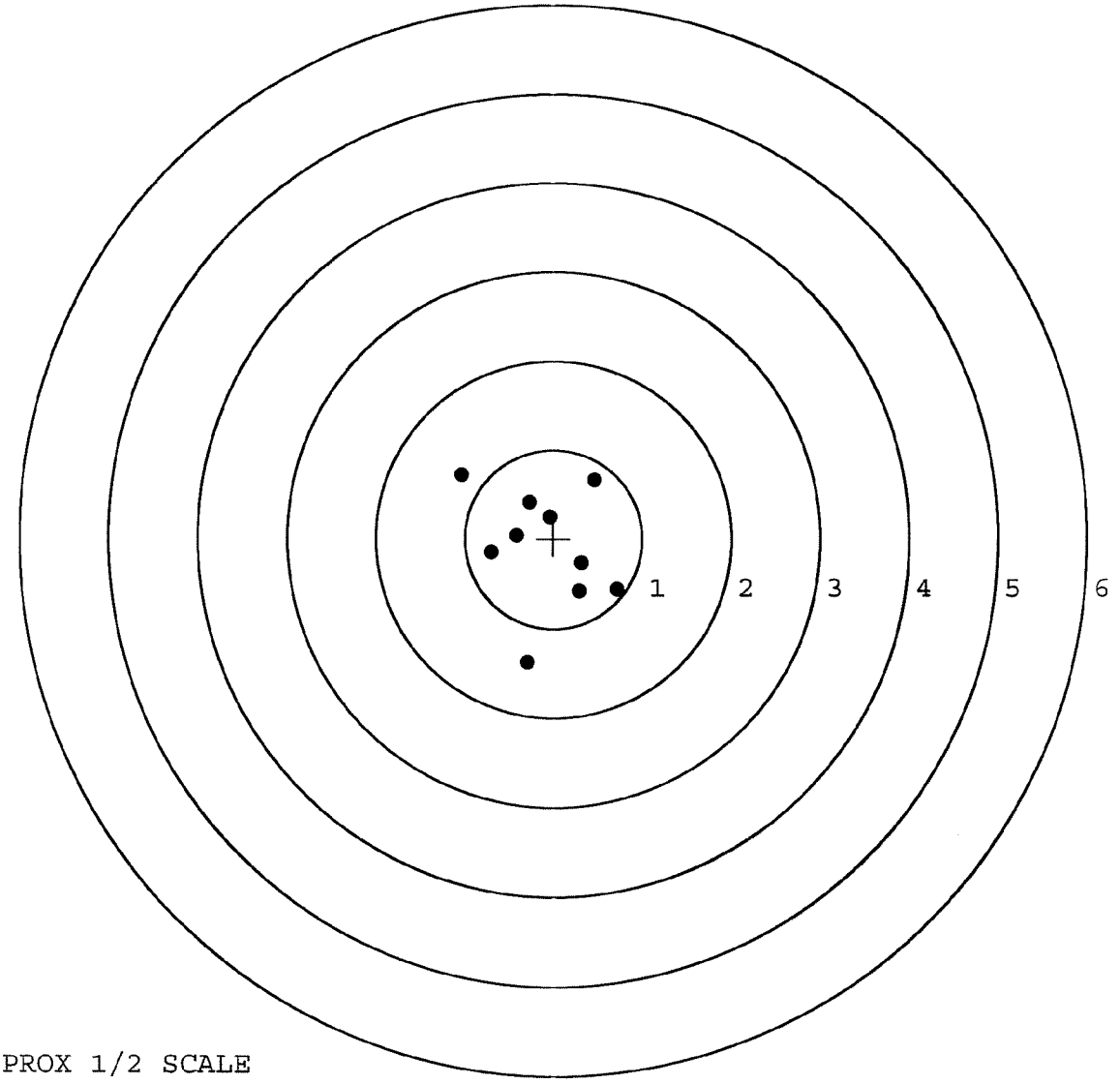


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6523467.__0
TARGET NUMBER: 5
FILE DATE: 12/07/2007
FILE TIME: 09:08

X CENTROID:	-0.098
Y CENTROID:	-0.091
POA TO CENTROID:	0.133
HORZ SPREAD:	1.754
VERT SPREAD:	2.099
GROUP SPREAD:	2.225
MIN RADIUS:	0.337
MAX RADIUS:	1.304
MEAN RADIUS:	0.733
# IN 1 IN DIAMETER:	3
# IN 2 IN DIAMETER:	8
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	-0.296	-1.380
2:	0.460	0.657
3:	-1.035	0.719
4:	-0.267	0.413
5:	-0.045	0.242
6:	-0.417	0.036
7:	-0.704	-0.156
8:	0.316	-0.278
9:	0.719	-0.568
10:	0.292	-0.592



TARGET APPROX 1/2 SCALE

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

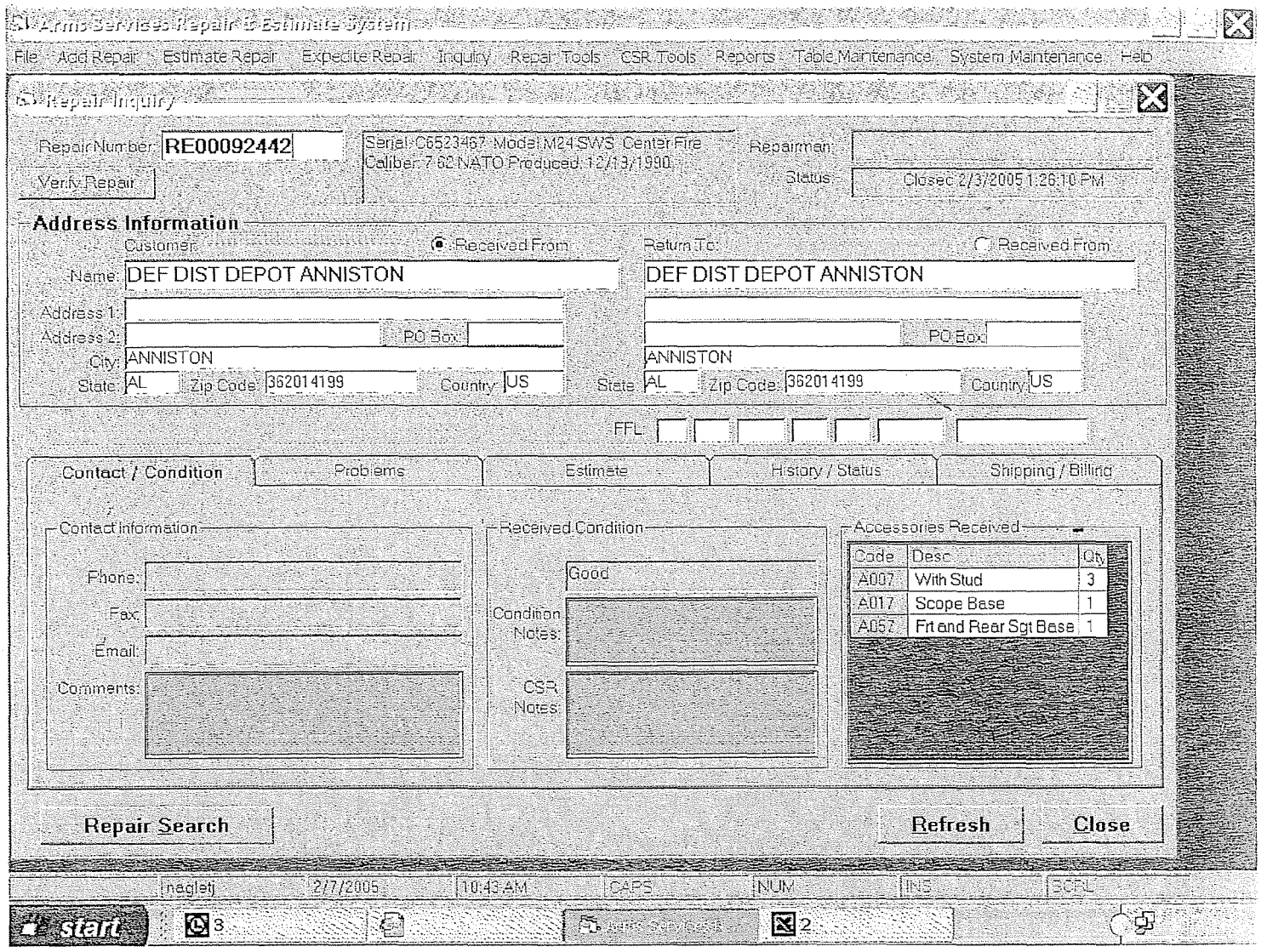
R & E NUMBER 135765

SERIAL NUMBER C6523467

LOG-IN DATE 10/25/07

OPERATION #	OPERATION NAME		DATE	INITIAL
500	DIS-ASSEMBLE GUN		11-7/07	
505	RE-BARREL		11-8/07	
560	ASSEMBLE		11-8-07	RTZ
600	PROOF		11-12-07	TRW
605	CHECK HEADSPACE		11-12-07	TRW
610	DIS-ASSEMBLE GUN		11-13-07	RTZ
612	MAGNAFLUX		11-14-07	JB
510	DRILL AND TAP		11-13-07	TRW
615	ROLLMARK CALIBER		11-13-07	CW
618	ROTO-BLAST		11-14-07	
620	APPLY COATINGS		11/27/07	
625	FINAL ASSEMBLY		12-5-07	RTZ
640	FUNCTION TEST AND	(PASS) FAIL	12-5-07	TRW
650	TARGET	(PASS) FAIL	12-5-07	TRW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION	12-5-07	FM
670	FINAL INSPECTION		12-10-07	DA
	A) HEADSPACE	(PASS) FAIL	12-10-07	DA
	B) TRIGGER PULL (+/- .5 LBS, MIN 2.50 LBS, MAX 4.0 LBS)	2.78 2.74 2.75 2.77 2.75	121007	DA
680	F) SAFETY ON FORCE (2 LBS MIN, 10 LBS MAX)	4.5 4.5 4.5	121007	DA
	G) SAFETY OFF FORCE (2 LBS MIN)	3.0 3.0 3.0	121007	DA
	I) FIRING PIN INDENT (.020)	.0220 .02175 .02150	121007	DA
690	PACK		12/10/07	DA

N/A


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: RE00092442
Verify Repair
Serial: C6523467 Model: M24 SWS Center Fire
Caliber: 7.62 NATO Produced: 12/13/1990
Repairman:
Status: Closed 2/3/2005 1:26:10 PM
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
A017 Scope Base 1
A052 Frt and Rear Sgt Base 1
Repair Search
Refresh
Close
neglet 2/7/2005 10:43 AM CAPS NUM INS SCRL
start


Serial Number: C6523467
Model: M24 SWS
RE00092442

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFOMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6523467.__0
FILE DATE AND TIME: 09/02/2005 11:01

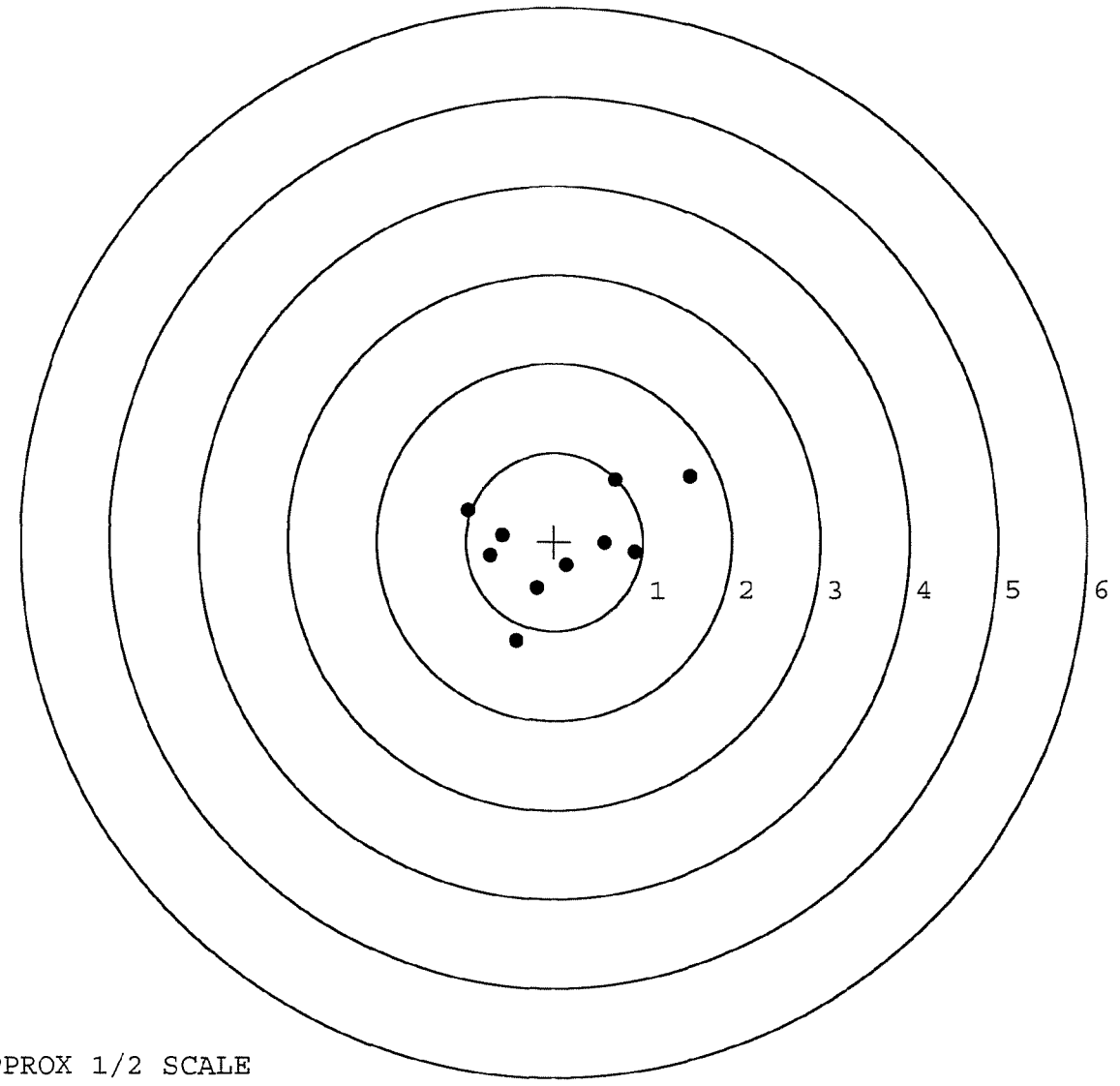
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.030
The Average Y Centroid of the Five Target Set:	-0.096
The Average Point of Impact of the Five Target Set:	0.101
The Average Mean Radius of the Five Target Set:	0.862
The Distance from POA to Centroid Target #1:	0.100
The Distance from Centroid Target #2 to Centroid Target #1:	0.344
The Distance from Centroid Target #3 to Centroid Target #1:	0.088
The Distance from Centroid Target #4 to Centroid Target #1:	0.079
The Distance from Centroid Target #5 to Centroid Target #1:	0.048

SERIAL NUMBER: C6523467.__0
TARGET NUMBER: 1
FILE DATE: 09/02/2005
FILE TIME: 11:01

X CENTROID:	0.094
Y CENTROID:	-0.034
POA TO CENTROID:	0.100
HORZ SPREAD:	2.496
VERT SPREAD:	1.840
GROUP SPREAD:	2.686
MIN RADIUS:	0.242
MAX RADIUS:	1.626
MEAN RADIUS:	0.853
# IN 1 IN DIAMETER:	2
# IN 2 IN DIAMETER:	7
# in 3 IN DIAMETER:	9

POINT#	X	Y
1:	1.528	0.731
2:	0.700	0.699
3:	0.910	-0.126
4:	0.568	-0.019
5:	0.134	-0.273
6:	-0.194	-0.526
7:	-0.429	-1.109
8:	-0.721	-0.159
9:	-0.592	0.079
10:	-0.968	0.359

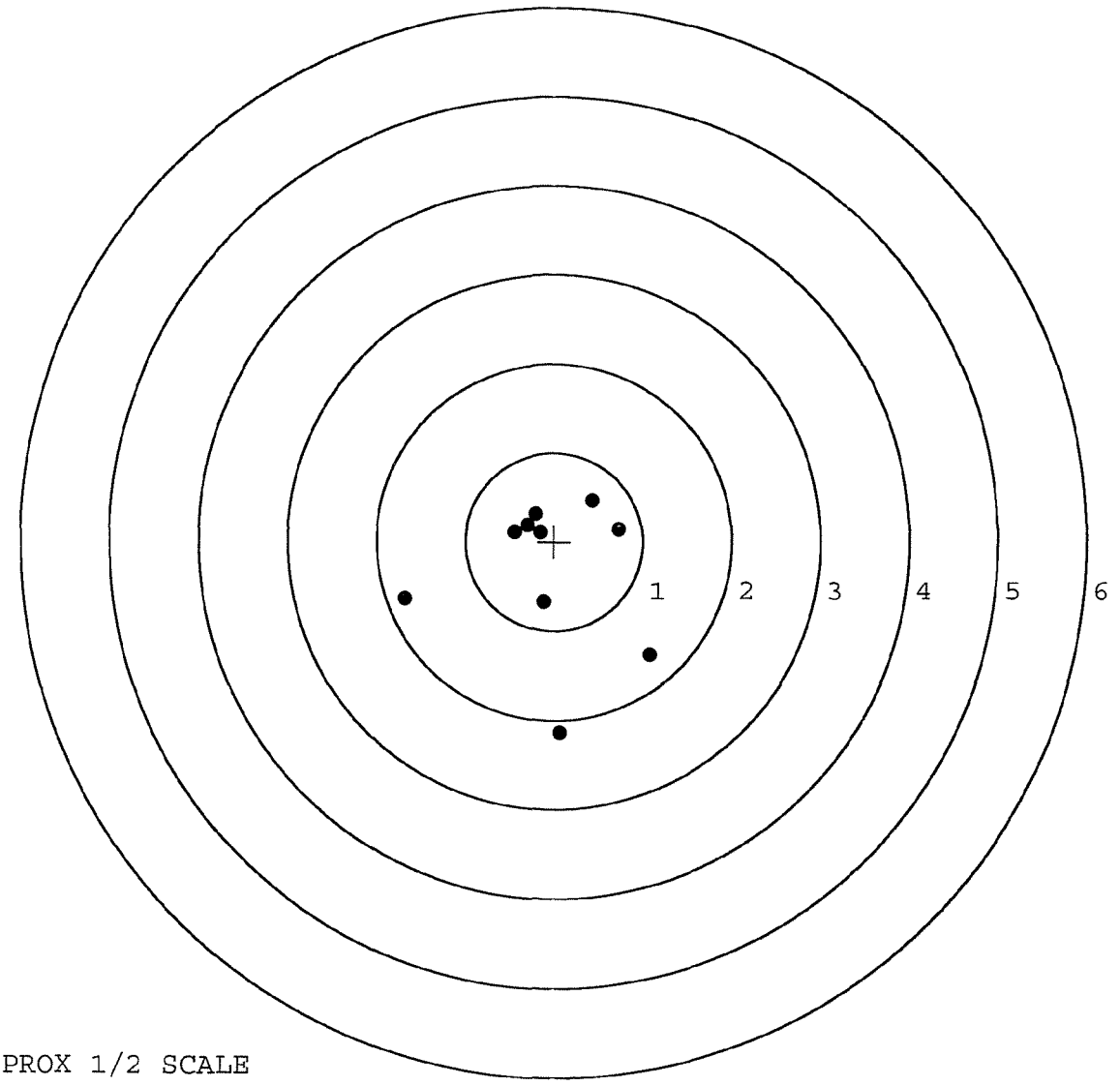


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6523467.__0
TARGET NUMBER: 2
FILE DATE: 09/02/2005
FILE TIME: 11:01

X CENTROID:	-0.057
Y CENTROID:	-0.343
POA TO CENTROID:	0.348
HORZ SPREAD:	2.765
VERT SPREAD:	2.614
GROUP SPREAD:	2.640
MIN RADIUS:	0.343
MAX RADIUS:	1.810
MEAN RADIUS:	0.946
# IN 1 IN DIAMETER:	2
# IN 2 IN DIAMETER:	7
# in 3 IN DIAMETER:	8

POINT#	X	Y
1:	1.081	-1.270
2:	0.067	-2.149
3:	-0.114	-0.682
4:	0.731	0.138
5:	0.439	0.465
6:	-0.147	0.107
7:	-0.201	0.314
8:	-0.441	0.110
9:	-0.299	0.187
10:	-1.684	-0.653

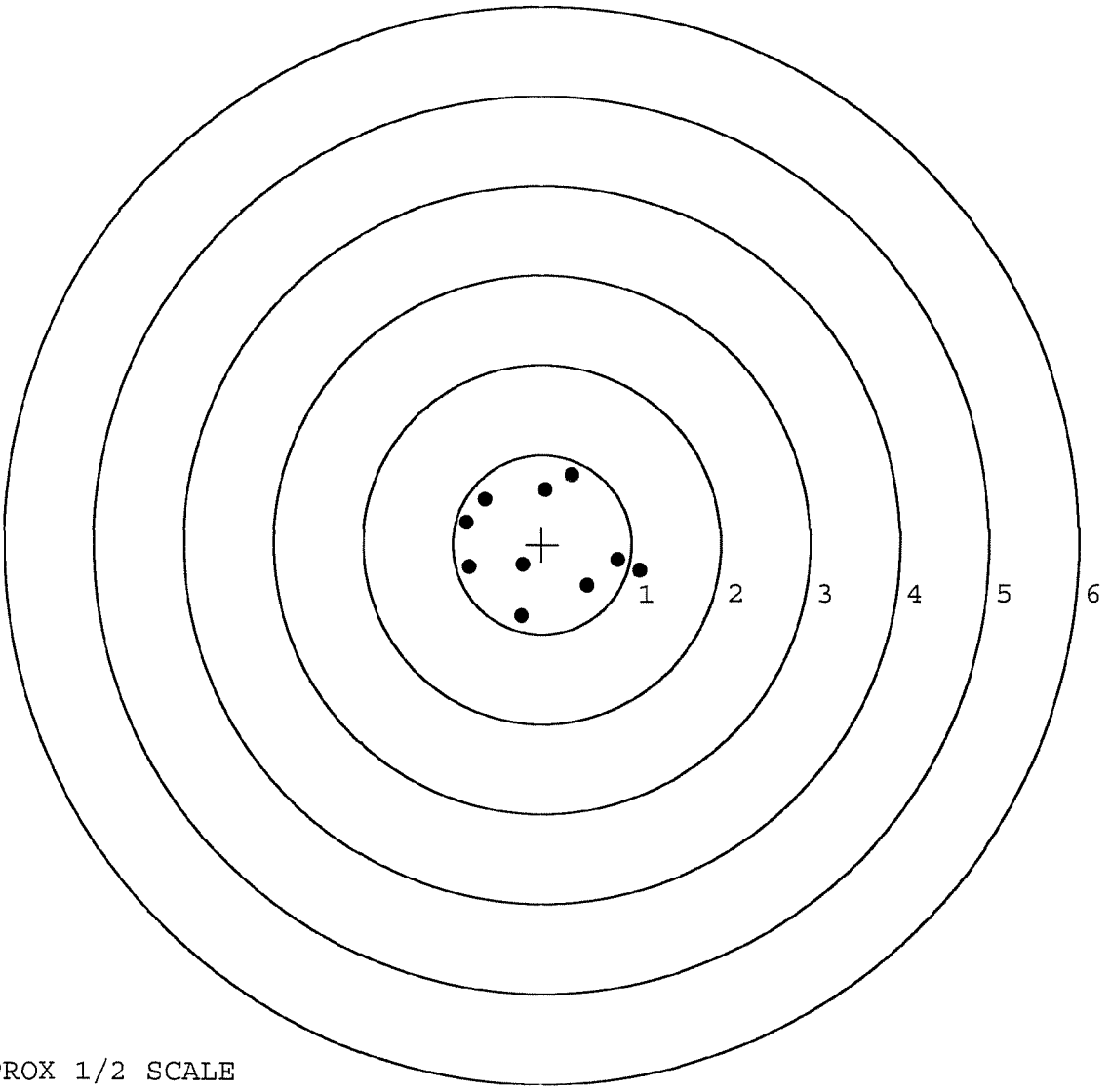


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6523467.__0
TARGET NUMBER: 3
FILE DATE: 09/02/2005
FILE TIME: 11:01

X CENTROID:	0.009
Y CENTROID:	-0.009
POA TO CENTROID:	0.013
HORZ SPREAD:	1.939
VERT SPREAD:	1.582
GROUP SPREAD:	2.013
MIN RADIUS:	0.314
MAX RADIUS:	1.122
MEAN RADIUS:	0.784
# IN 1 IN DIAMETER:	1
# IN 2 IN DIAMETER:	9
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	1.093	-0.299
2:	0.849	-0.178
3:	0.510	-0.462
4:	-0.228	-0.804
5:	-0.214	-0.230
6:	-0.814	-0.255
7:	-0.846	0.242
8:	-0.635	0.504
9:	0.041	0.610
10:	0.338	0.778

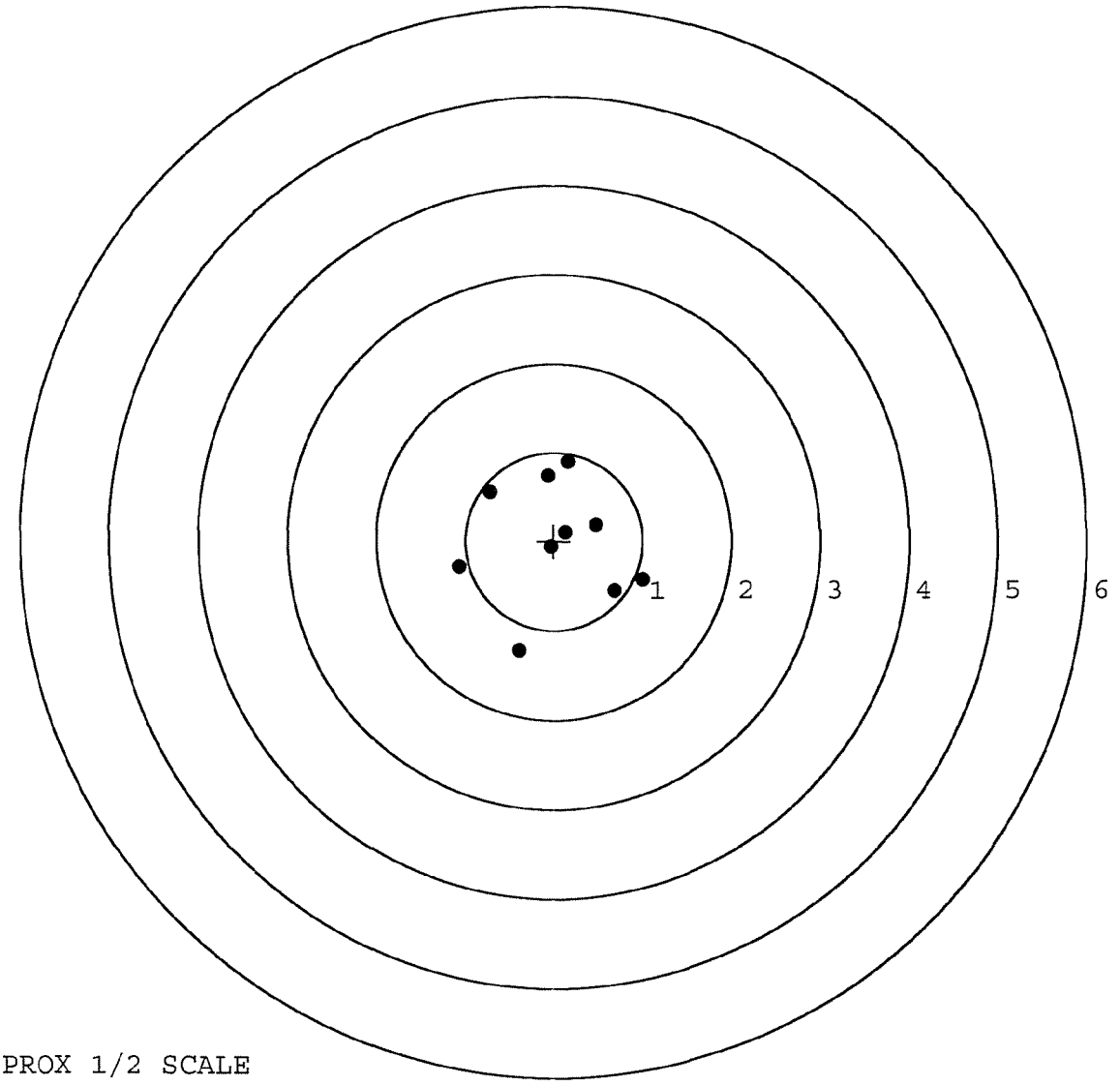


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6523467.__0
TARGET NUMBER: 4
FILE DATE: 09/02/2005
FILE TIME: 11:01

X CENTROID:	0.018
Y CENTROID:	-0.013
POA TO CENTROID:	0.022
HORZ SPREAD:	2.075
VERT SPREAD:	2.126
GROUP SPREAD:	2.194
MIN RADIUS:	0.082
MAX RADIUS:	1.281
MEAN RADIUS:	0.770
# IN 1 IN DIAMETER:	2
# IN 2 IN DIAMETER:	7
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	1.002	-0.436
2:	0.692	-0.562
3:	-0.387	-1.229
4:	0.482	0.185
5:	0.131	0.094
6:	-0.038	-0.073
7:	0.156	0.897
8:	-0.065	0.738
9:	-0.721	0.548
10:	-1.073	-0.295

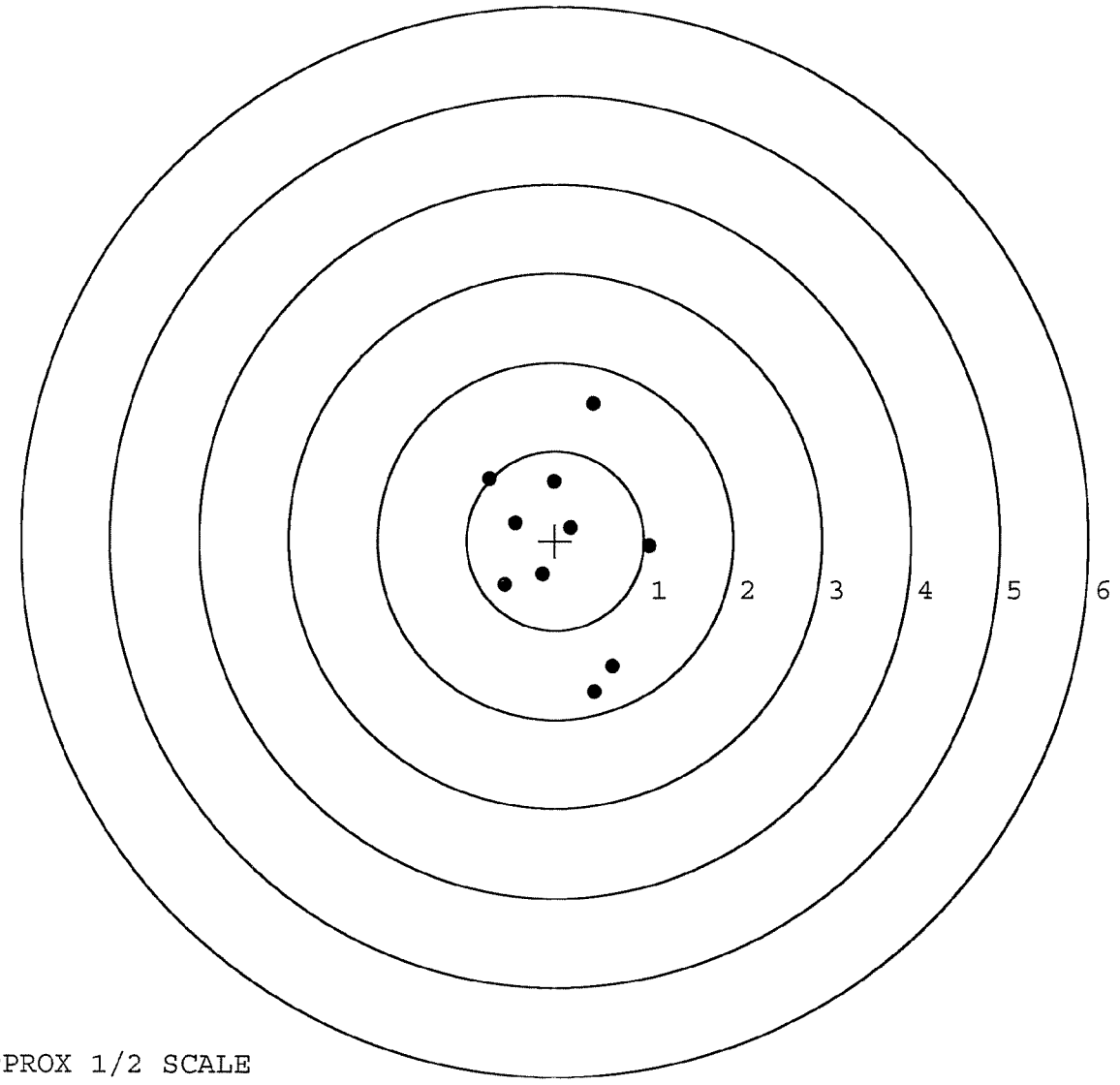


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6523467.__0
TARGET NUMBER: 5
FILE DATE: 09/02/2005
FILE TIME: 11:01

X CENTROID:	0.084
Y CENTROID:	-0.082
POA TO CENTROID:	0.117
HORZ SPREAD:	1.801
VERT SPREAD:	3.224
GROUP SPREAD:	3.224
MIN RADIUS:	0.246
MAX RADIUS:	1.654
MEAN RADIUS:	0.960
# IN 1 IN DIAMETER:	2
# IN 2 IN DIAMETER:	6
# in 3 IN DIAMETER:	8

POINT#	X	Y
1:	1.056	-0.066
2:	0.431	1.528
3:	-0.014	0.663
4:	0.178	0.146
5:	-0.450	0.197
6:	-0.745	0.692
7:	-0.142	-0.374
8:	-0.569	-0.494
9:	0.652	-1.412
10:	0.446	-1.696



TARGET APPROX 1/2 SCALE

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

R & E NUMBER	92442		
SERIAL NUMBER	CL523467		
LOG-IN DATE	2-3-05		
INSPECT AND VERIFY:			
OPERATION #	OPERATION NAME	DATE	INITIAL
550	DIS-ASSEMBLE GUN	8-16-05	RTL
560 A	RE-BARREL	8-23-05	RTL
B	DRILL AND TAP	8-25-05	TRW
575	ASSEMBLE	8-24-05	RTL
600	PROOF	8-24-05	AE
605	CHECK HEADSPACE	8-24-05	AE
610	DIS-ASSEMBLE GUN	8-25-05	RTL
612	MAGNAFLUX OPERATOR	8-25-05	
615	ROLLMARK CALIBER	8-25-05	CW
618	ROTO-BLAST	8-26-05	LB
620	APPLY COATINGS	8/29/05	RB
625 A	FINAL ASSEMBLY	9-1-05	RTL
B	TRIGGER PULL TEST		
C	SAFETY "ON" FORCE	9-6-05	AE
D	SAFETY "OFF" FORCE	9-6-05	AE
E	FIRING PIN INDENT	9-6-05	AE
640	TARGET	9-2-05	TRW
655	FINAL INSPECT	9-6-05	AE
660	PACK	9-12-05	RTL
		SHIP DATE	
	QAR INSPECTION DATE		

RECEIVING AND ESTIMATING REPORT

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

ORDER: R 94-18277

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

DATE RECEIVED	DATE OPENED	DATE CODE	SERIAL NUMBER	NEW SERIAL NUMBER	MODEL AND GRADE
06/10/94	06/10/94		C6523467		700 7-62 NATO

ACCESSORIES: SLING STRAP HARD CASE SCOPE MNTS SCOPE BASE

90-0797

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		COMMENTS
Trigger Assy	173.71	
Scope Repair	119.43	
Clean/Insp/Prep	50.00	
	343.14	

REPAIRMAN	PROOF	CLEAN	TEST	TARGET	PATTERN
			AC		
GALLERY TESTER	DATE	DATE	DATE	DATE	DATE
			11/1/95		

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. C6523467
DATE 10-18-95
TESTER DA

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.41	2.44	2.64		MIN. SETTING,
PULL #2	2.32	2.60	2.58		NO AVG. OF 5
PULL #3	2.49	2.75	2.62		READINGS ACCEPT-
PULL #4	2.48	2.62	2.44		ABLE LESS THAN 2#
PULL #5	2.46	2.58	2.53		
TOTAL	12.16	12.99	12.81		
AVG.	2.43	2.59	2.56		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.17	2.95		
PULL #2	3.10	3.04		
PULL #3	3.01	2.99		
PULL #4	2.97	2.95		
PULL #5	3.01	3.03		
TOTAL	15.26	14.96		
AVG.	3.05	2.99		

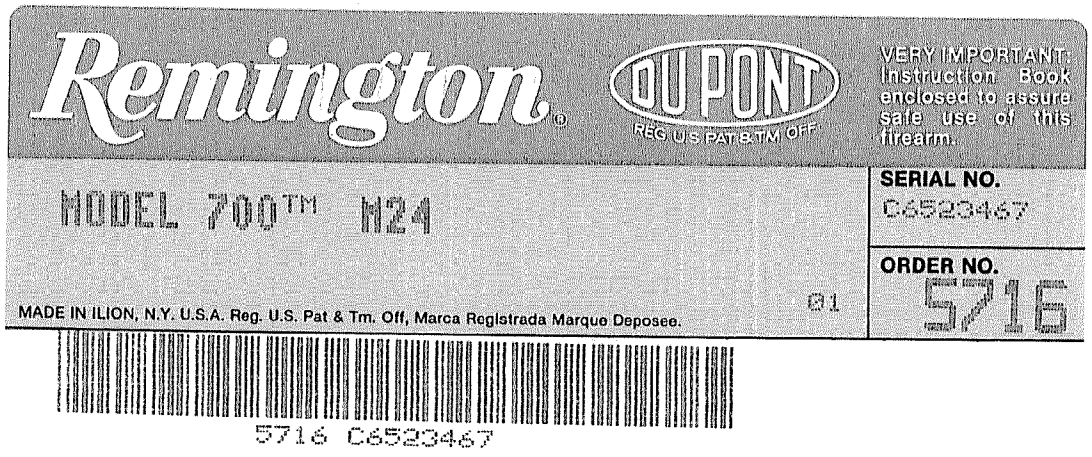
	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.22	3.90	4.13	
PULL #2	4.00	3.95	3.95	
PULL #3	3.96	4.05	4.00	
PULL #4	4.03	385	3.92	
PULL #5	4.04	3.97	3.90	
TOTAL	20.25	19.72	19.90	
AVG.	4.05	3.94	3.98	

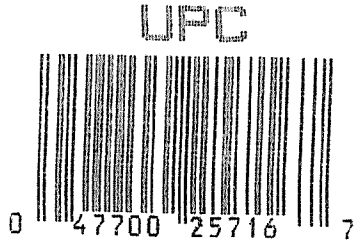
CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6523467

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			11/28	WB
	G) Safety Off Force	3 1/2	3 1/2	3 1/2			11/28	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	2.32	2.40	2.30	2.36	2.37	11/29	WB
	C) Function							
660	Pack							





M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6523467

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	DB
617	Drill and Tap Sight Holes		9-25-90	RB
618	Polish Barrel RB		9/28/90	WB
620	Apply Coatings (Barrel Action)		10-2-90	DA
	Apply Coating (Bolt)		10-2-90	DA
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		10/18/90	DA

op. #	OP. NAME	READINGS			DATE	INIT
625 nt.	F) Safety On Force	4 1/2	4 1/2	4 1/2	10/24/90	WB
	G) Safety Off Force	2 1/2	2 1/2	2 1/2	10/24/90	WB
	H) Trigger Pull Test & Retainability				10/18/90	RJ
	I) Firing Pin Indent	.021	.0205	.0205	10/24/90	WB
	J) Assemble Stock				10/29/90	RW
	K) Assemble Swivel Studs				3/1/090	RJ
	L) Attach Front and Rear Sight Assemblies				10/29/90	RW
	M) Iron Sight Alignment				10/29/90	RW
	N) Detach Front & Rear Sights & place in numbered container				10/29/90	RW
	O) Attach Scope to Rifle				10/29/90	RW
	P) Detach & Attach Scope 20 Times				10/29/90	RW
640	Gallery Target & Test				10-30-90	AF
	A) Time				10-30-90	AF
	B) Malfunctions				10-30-90	AF
	C) Pierced Primers				10-30-90	AF
	D) Optical Clearity of Scope				10-30-90	AF
645	Inspect for Live Ammo				10-30-90	AF
655	Final Inspection A) Headspace				3/1/090	RJ
	B) Trigger Pull	259	262	268	269	290	3/8/90	RJ
	C) Function				3/1/090	RJ
660	Pack				12-17-90	DH

SWS TRIGGER PULL TEST

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

SERIAL NO C6523467
DATE 10-18-90
TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.27	2.43	2.43	2.59	MIN. SETTING,
PULL #2	2.39	2.46	2.43	2.62	NO AVG. OF 5
PULL #3	2.41	2.46	2.50	2.68	READINGS ACCEPT-
PULL #4	2.42	2.46	2.48	2.69	ABLE LESS THAN 2#
PULL #5	2.47	2.48	2.48	2.90	
TOTAL	11.96	12.29	12.32		
AVG.	2.392	2.458	2.464		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.26	3.36		
PULL #2	3.34	3.40		
PULL #3	3.22	3.39		
PULL #4	3.33	3.38		
PULL #5	3.36	3.44		
TOTAL	16.51	16.97		
AVG.	3.302	3.394		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.45	4.15		4.44
PULL #2	4.45	4.44		4.43
PULL #3	4.17	4.43		4.40
PULL #4	4.32	4.44		4.38
PULL #5	4.47	4.36		4.40
TOTAL	21.81	21.82		22.05
AVG.	3.362	4.364		4.41

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6523467
31 Oct 1990

CENTROIDAL DISTANCES

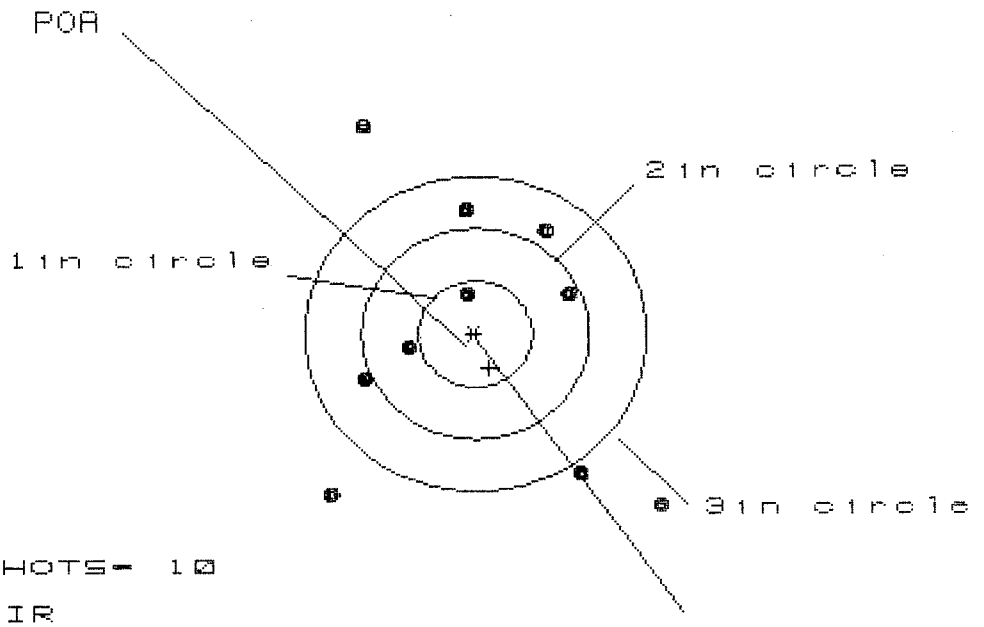
0	TO	1	.343984
1	TO	2	.537261
1	TO	3	.219002
1	TO	4	.449003
1	TO	5	.450281

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0868
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0042
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0869016

THE AMR FOR THIS RIFLE IS: .9594

31 Oct 1998 FILE:/PATTERNING/CENTERFIRE_PATT/ CB523467

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1in = 1

2in = 3

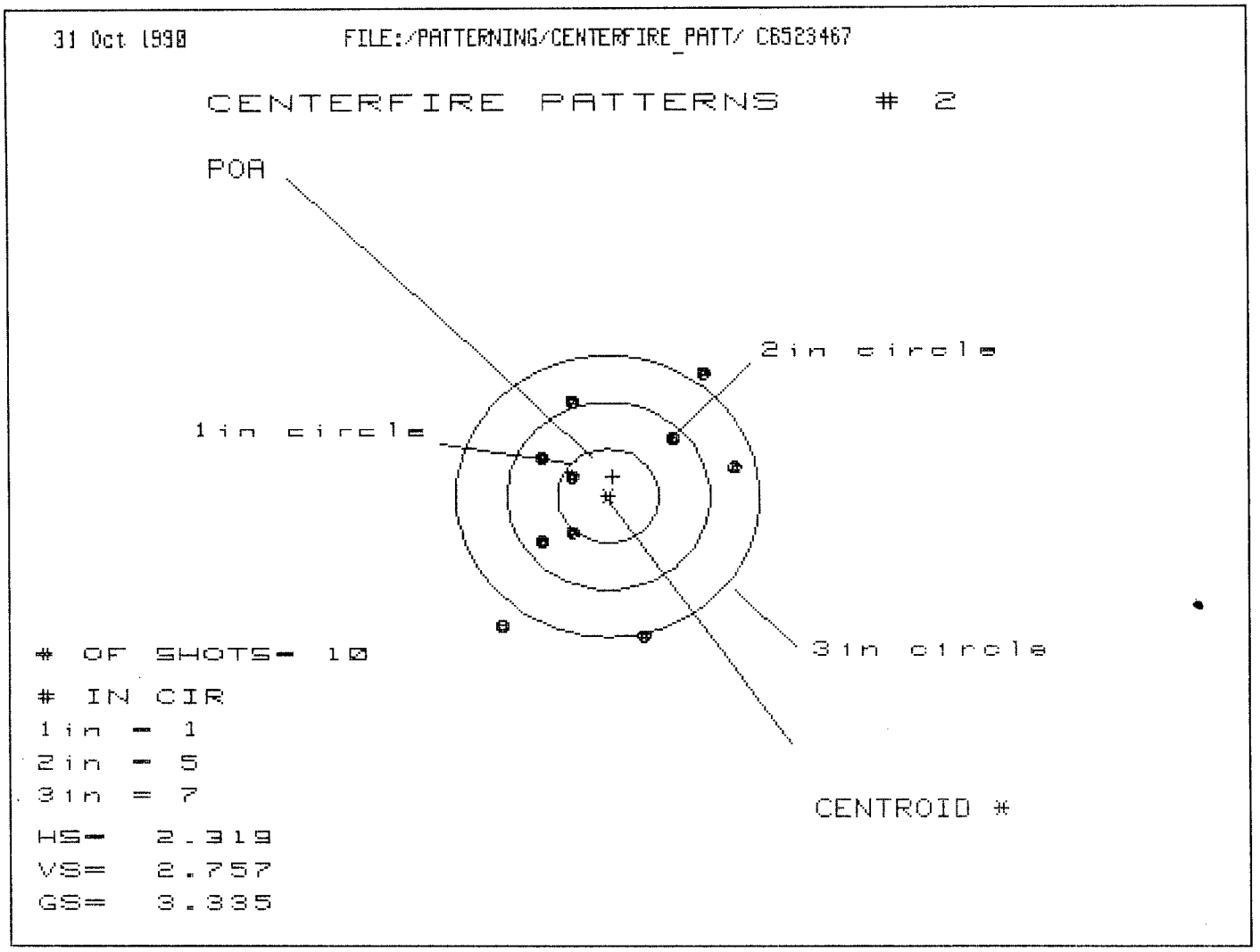
3in = 6

HS= 2.818

VS= 3.616

GS= 4.443

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.589	1.063	.961
MINIMUM X	:	-1.229	-1.052	-1.154
MAXIMUM Y	:	1.967	1.784	1.247
MINIMUM Y	:	-1.649	-1.703	-1.480
CENTROID X	:	-.121	-.298	-.196
CENTROID Y	:	.322	.505	.282
POA TO CENTROID in.	:	.344	.586	.343
MIN RADIUS	:	.386	.231	.421
MEAN RADIUS	:	1.339	1.194	1.113
MAX RADIUS	:	2.290	2.002	1.877
HORIZONTAL SPREAD	:	2.818	2.115	2.115
VERTICAL SPREAD	:	3.616	3.487	2.727
EXTREME SPREAD	:	4.443	3.745	3.108
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		6	



PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.291	1.176	1.283
MINIMUM X	:	-1.028	-.801	-.694
MAXIMUM Y	:	1.285	1.131	.958
MINIMUM Y	:	-1.472	-1.626	-1.484
CENTROID X	:	-.046	.069	-.038
CENTROID Y	:	-.210	-.056	-.197
POA TO CENTROID in.	:	.215	.089	.201
MIN RADIUS	:	.406	.450	.404
MEAN RADIUS	:	1.063	.988	.913
MAX RADIUS	:	1.726	1.648	1.531
HORIZONTAL SPREAD	:	2.319	1.977	1.977
VERTICAL SPREAD	:	2.757	2.757	2.442
EXTREME SPREAD	:	3.335	2.819	2.541
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		7	

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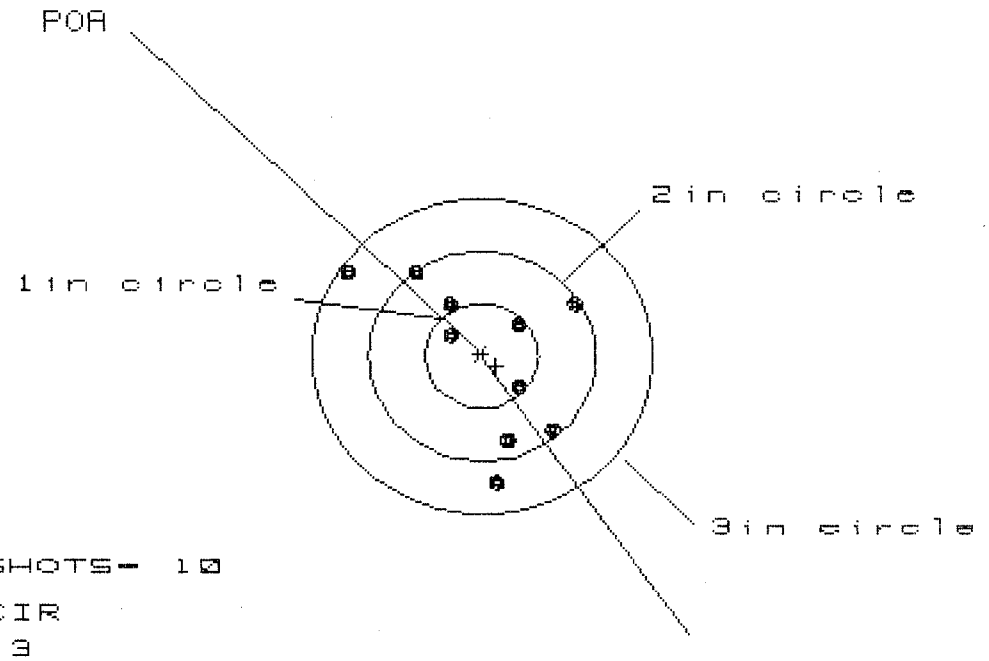
CENTERFIRE PATTERNS # 3



OF SHOTS= 10

# IN CIR	
1in	= 3
2in	= 8
3in	= 10

HS= 2.048
VS= 2.083
GS= 2.440

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.854	.721	.714
MINIMUM X	:	-1.194	-.756	-.763
MAXIMUM Y	:	.833	.854	.709
MINIMUM Y	:	-1.250	-1.158	-.806
CENTROID X	:	-.122	.011	.018
CENTROID Y	:	.103	.011	.156
POA TO CENTROID in.	:	.160	.015	.157
MIN RADIUS	:	.376	.280	.295
MEAN RADIUS	:	.819	.732	.668
MAX RADIUS	:	1.456	1.159	1.042
HORIZONTAL SPREAD	:	2.048	1.477	1.477
VERTICAL SPREAD	:	2.083	2.012	1.515
EXTREME SPREAD	:	2.440	2.130	1.896
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	

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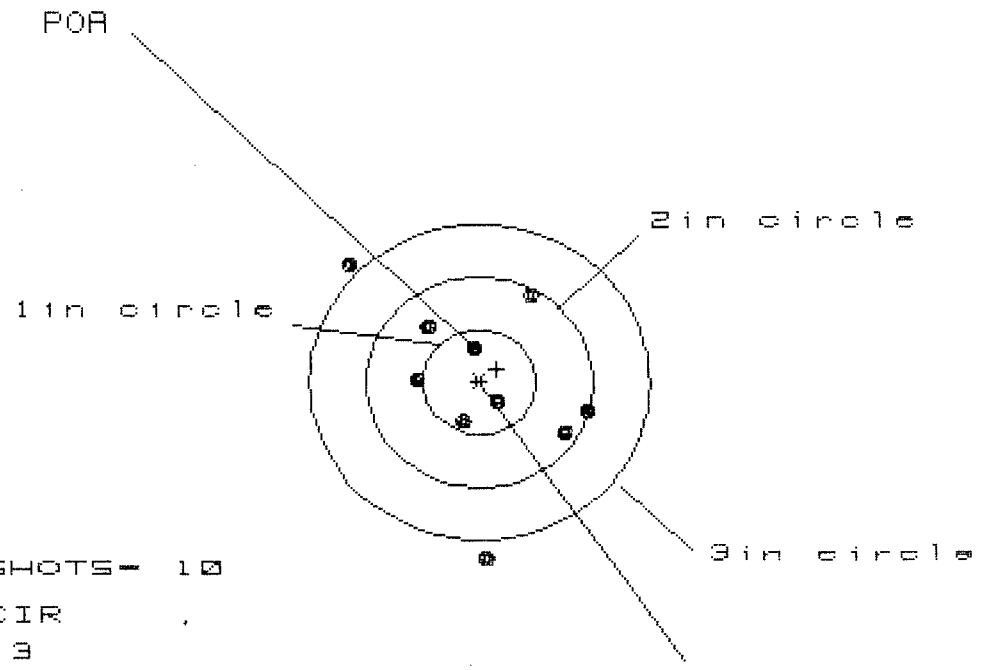
CENTERFIRE PATTERNS' # 4



# OF SHOTS= 10
# IN CIR
1in = 3
2in = 8
3in = 8
HS= 2.035
VS= 2.713
GS= 2.962

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.917	.924	.785
MINIMUM X	:	-1.118	-1.111	-.701
MAXIMUM Y	:	1.086	.905	.801
MINIMUM Y	:	-1.627	-.625	-.512
CENTROID X	:	-.151	-.158	-.020
CENTROID Y	:	-.126	.055	-.058
POA TO CENTROID in.	:	.196	.168	.062
MIN RADIUS	:	.181	.112	.197
MEAN RADIUS	:	.808	.708	.612
MAX RADIUS	:	1.628	1.433	.857
HORIZONTAL SPREAD	:	2.035	2.035	1.486
VERTICAL SPREAD	:	2.713	1.530	1.313
EXTREME SPREAD	:	2.962	2.426	1.550
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		8	

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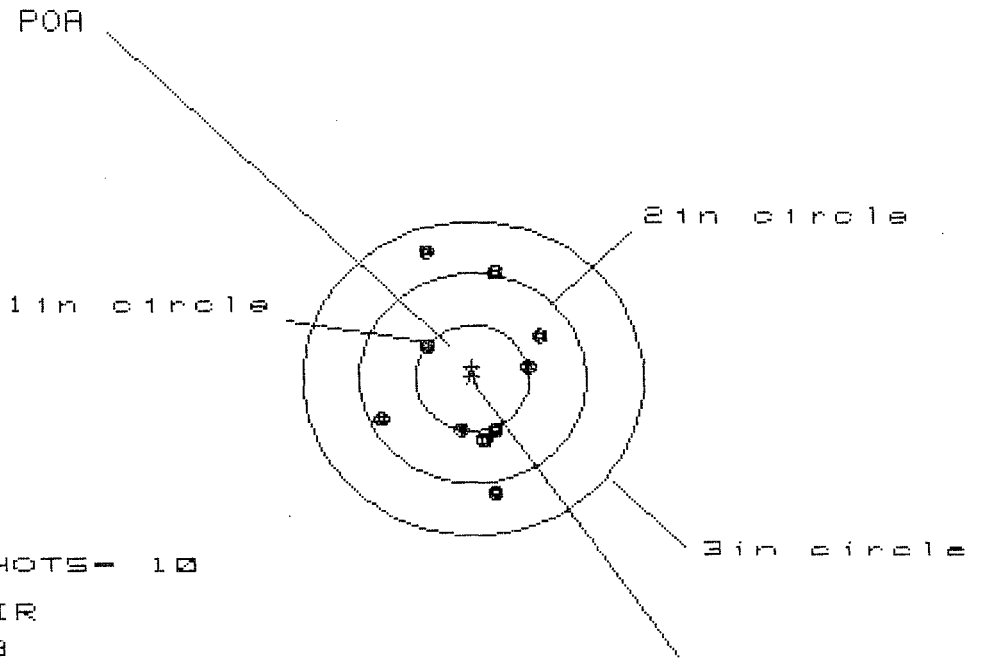
CENTERFIRE PATTERNS # 5



OF SHOTS= 10

# IN CIR
1in = 3
2in = 7
3in = 10

HS= 1.424
VS= 2.361
GS= 2.419

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.571	.529	.542
MINIMUM X	:	-.853	-.895	-.882
MAXIMUM Y	:	1.225	1.149	1.024
MINIMUM Y	:	-1.136	-1.000	-.617
CENTROID X	:	.006	.048	.035
CENTROID Y	:	-.110	-.246	-.121
POA TO CENTROID in.	:	.110	.251	.127
MIN RADIUS	:	.473	.331	.454
MEAN RADIUS	:	.768	.685	.653
MAX RADIUS	:	1.282	1.159	1.037
HORIZONTAL SPREAD	:	1.424	1.424	1.424
VERTICAL SPREAD	:	2.361	2.149	1.641
EXTREME SPREAD	:	2.419	2.149	1.716
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	