

C6523505

MODEL 700TM N24

Model **SMS** TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



Repair Inquiry

Repair Number: RE00123911

Serial: C6523505 Model M24 SWS Center Fire
Produced: 12/19/1990

Repairman:

Status:

New 1/18/2007 11:47:02 AM

Verify Repair

Address Information

Customer:

☒ Received From

Return To:

☐ Received From

Name: DEPT OF ARMY

DEPT OF ARMY

Address 1: HHC 1-87

HHC 1-87

Address 2: 10TH MTN DIV

PO Box:

10TH MTN DIV

PO Box:

City: FORT DRUM

FORT DRUM

State: NY

Zip Code: 13602

Country: US

State: NY

Zip Code: 13602

Country: US

FFL:

Contact / Condition

Problems

Estimate

History / Status

Shipping / Billing

Contact Information

Phone: NA

Fax:

Email:

Comments:

Received Condition

Fair

Condition
Notes:CSR
Notes:

Accessories Received

Code	Desc	Qty
A007	With Stud	3
A010	Hard Case	1
A017	Scope Base	2
A045	Bi Pod	1
D000	SCOPE CASE	1

Repair Search

Refresh

Close

naglej

1/19/2007

9:45 AM

CAPS

NUM

INS

SCRL



Inbox - Microsoft Ou...

Calendar - Microsoft ...

Arms Services Repair...

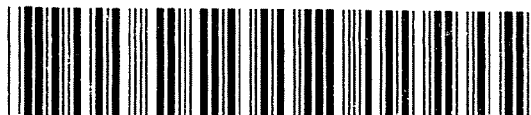


9:45 AM

Serial Number:

C6523505

Model: M24 SWS



RE00123911

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6523505.__0

FILE DATE AND TIME: 01/31/2007 23:19

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.009
The Average Y Centroid of the Five Target Set:	0.062
The Average Point of Impact of the Five Target Set:	0.063
The Average Mean Radius of the Five Target Set:	0.629
The Distance from POA to Centroid Target #1:	0.127
The Distance from Centroid Target #2 to Centroid Target #1:	0.340
The Distance from Centroid Target #3 to Centroid Target #1:	0.105
The Distance from Centroid Target #4 to Centroid Target #1:	0.434
The Distance from Centroid Target #5 to Centroid Target #1:	0.078

SERIAL NUMBER: C6523505. __0

TARGET NUMBER: 1

FILE DATE: 01/31/2007

FILE TIME: 23:19

POINT#	X	Y
1:	-0.594	0.781
2:	-0.221	0.288
3:	-0.516	-0.247
4:	-0.057	-0.243
5:	0.680	0.836
6:	0.403	0.165
7:	0.776	-0.431
8:	0.173	-0.944
9:	-0.538	-1.234
10:	-0.373	-0.211

X CENTROID: -0.027

Y CENTROID: -0.124

POA TO CENTROID: 0.127

HORZ SPREAD: 1.370

VERT SPREAD: 2.070

GROUP SPREAD: 2.402

MIN RADIUS: 0.123

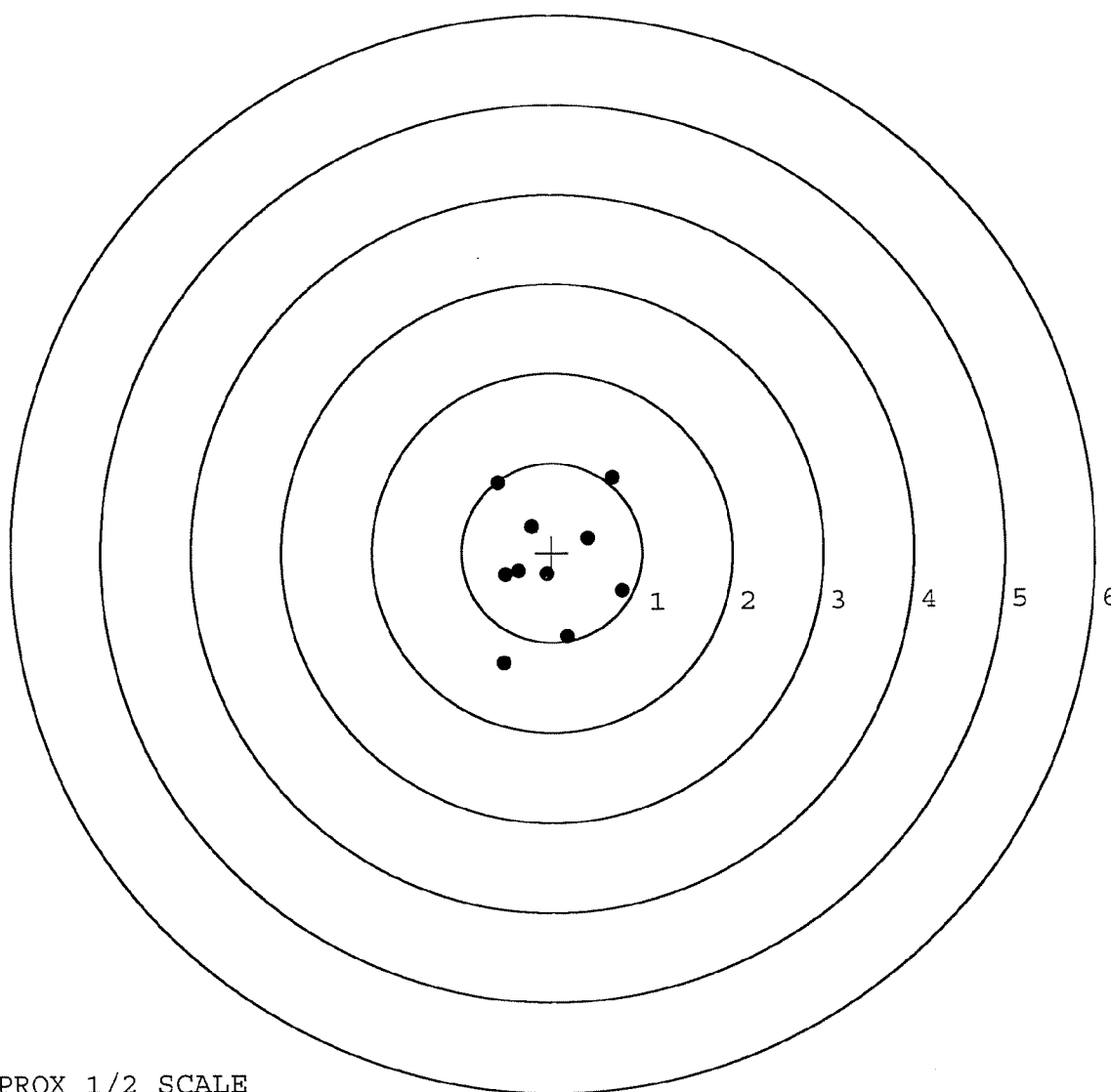
MAX RADIUS: 1.222

MEAN RADIUS: 0.714

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6523505. 0

TARGET NUMBER: 2

FILE DATE: 01/31/2007

FILE TIME: 23:19

POINT#	X	Y
1:	-0.882	1.058
2:	-0.607	0.569
3:	-0.201	0.699
4:	0.183	1.054
5:	-0.040	0.439
6:	0.552	0.197
7:	0.739	-0.441
8:	0.166	-0.471
9:	-0.182	-0.775
10:	-0.502	-0.204

X CENTROID: -0.077

Y CENTROID: 0.212

POA TO CENTROID: 0.226

HORZ SPREAD: 1.621

VERT SPREAD: 1.833

GROUP SPREAD: 2.208

MIN RADIUS: 0.230

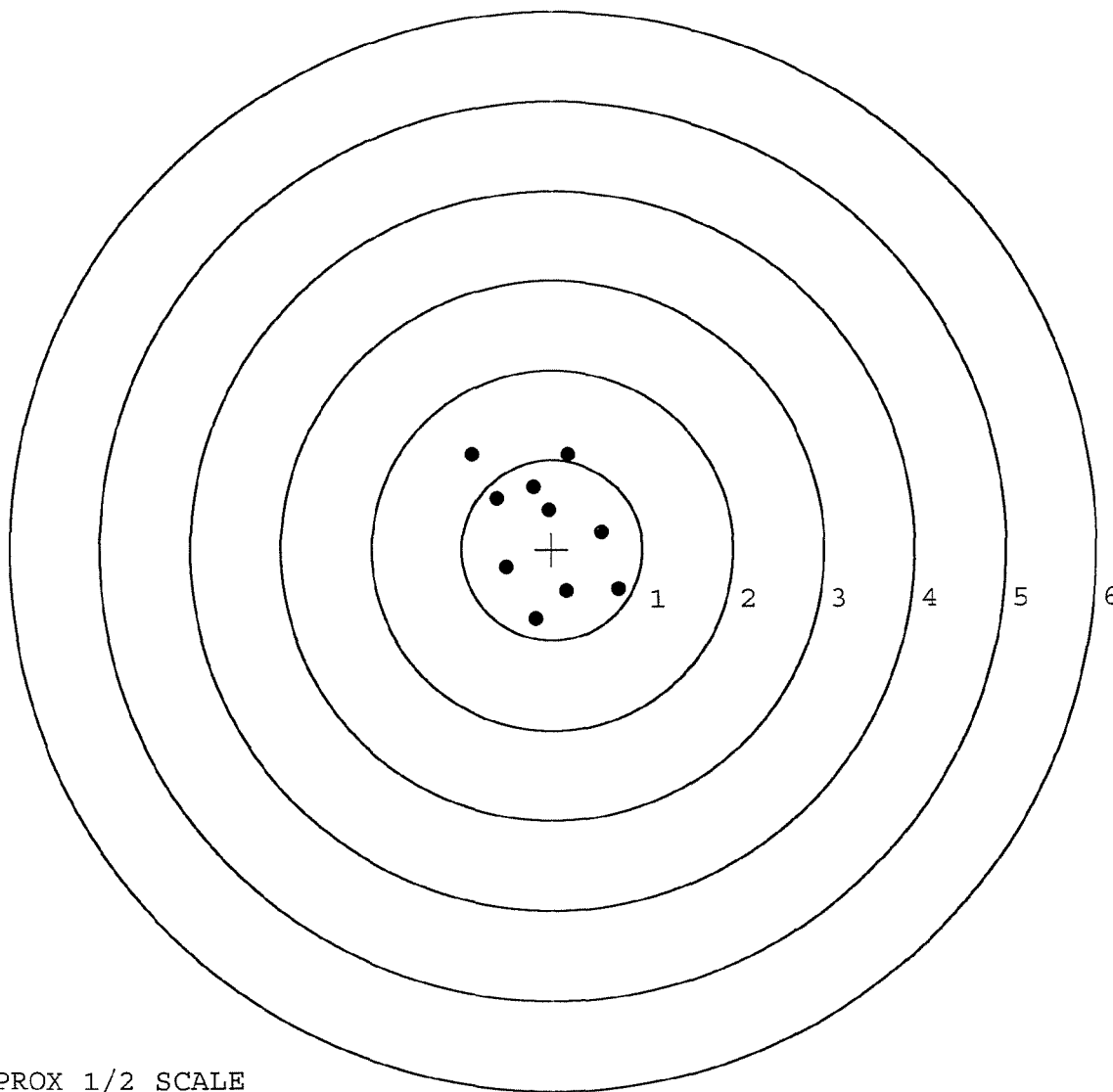
MAX RADIUS: 1.167

MEAN RADIUS: 0.741

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6523505. __0

TARGET NUMBER: 3

FILE DATE: 01/31/2007

FILE TIME: 23:19

POINT#	X	Y
1:	-0.559	0.959
2:	-0.049	0.781
3:	0.234	0.289
4:	-0.069	0.476
5:	-0.204	0.308
6:	-0.231	-0.365
7:	-0.011	-0.643
8:	0.285	-0.543
9:	0.510	-0.400
10:	-0.175	-1.055

X CENTROID: -0.027

Y CENTROID: -0.019

POA TO CENTROID: 0.033

HORZ SPREAD: 1.069

VERT SPREAD: 2.014

GROUP SPREAD: 2.050

MIN RADIUS: 0.372

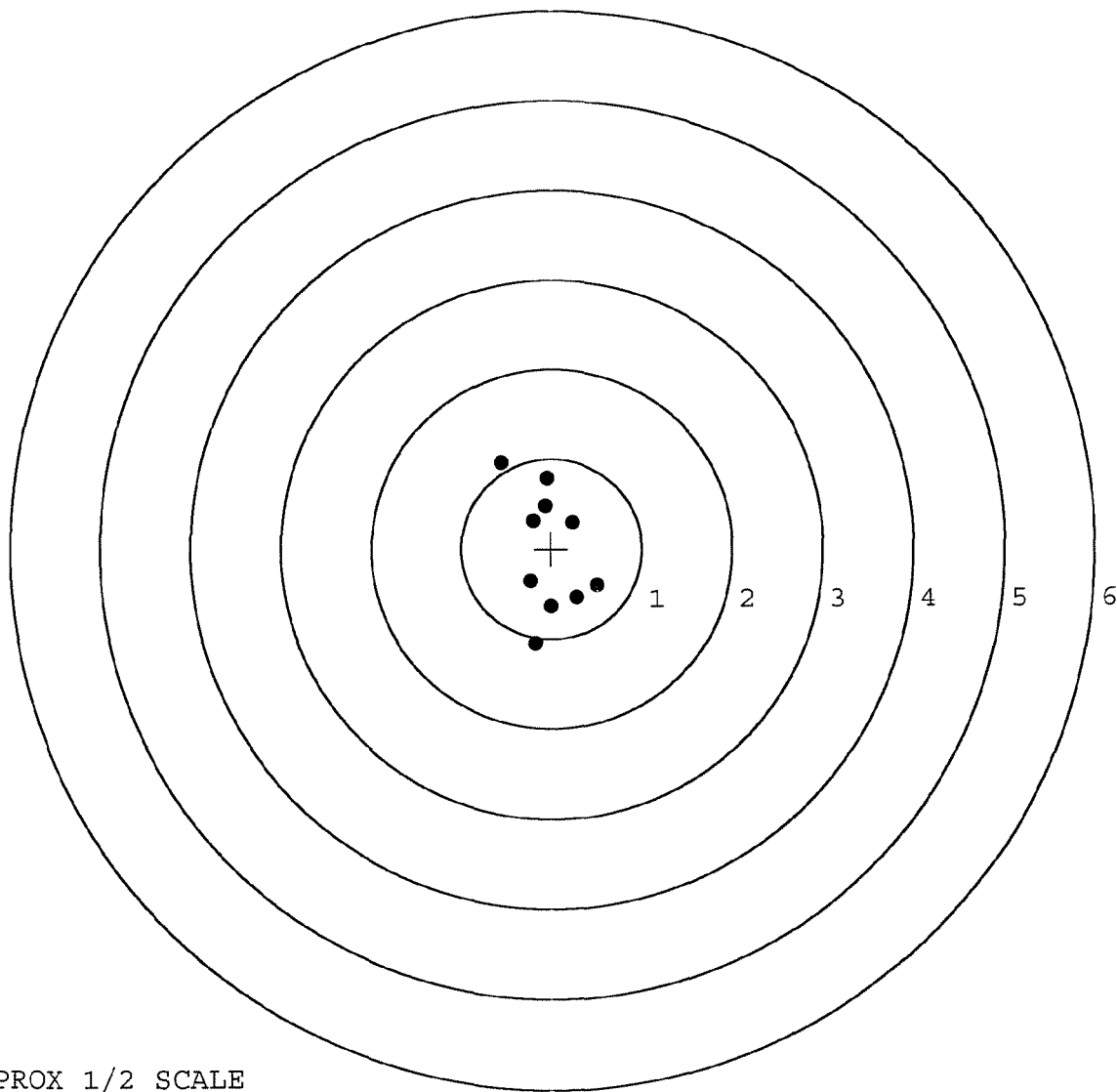
MAX RADIUS: 1.114

MEAN RADIUS: 0.653

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6523505. __0

TARGET NUMBER: 4

FILE DATE: 01/31/2007

FILE TIME: 23:19

POINT#	X	Y
1:	0.043	1.230
2:	-0.027	0.830
3:	0.184	0.602
4:	0.357	0.244
5:	0.830	0.581
6:	1.064	0.090
7:	-0.340	0.137
8:	-0.508	0.190
9:	-0.459	-0.605
10:	0.012	-0.434

X CENTROID: 0.116

Y CENTROID: 0.286

POA TO CENTROID: 0.309

HORZ SPREAD: 1.572

VERT SPREAD: 1.835

GROUP SPREAD: 1.902

MIN RADIUS: 0.245

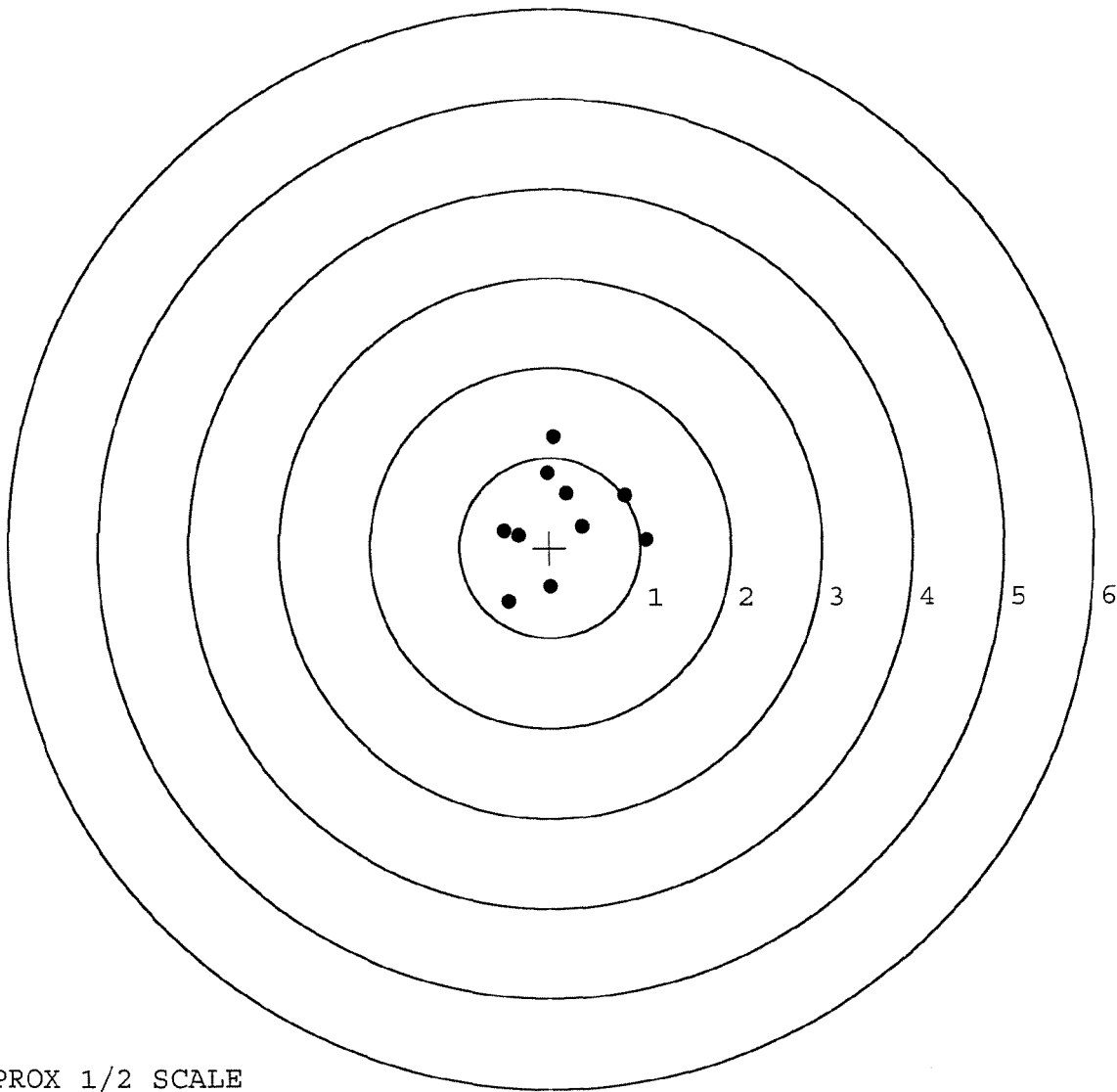
MAX RADIUS: 1.061

MEAN RADIUS: 0.672

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10

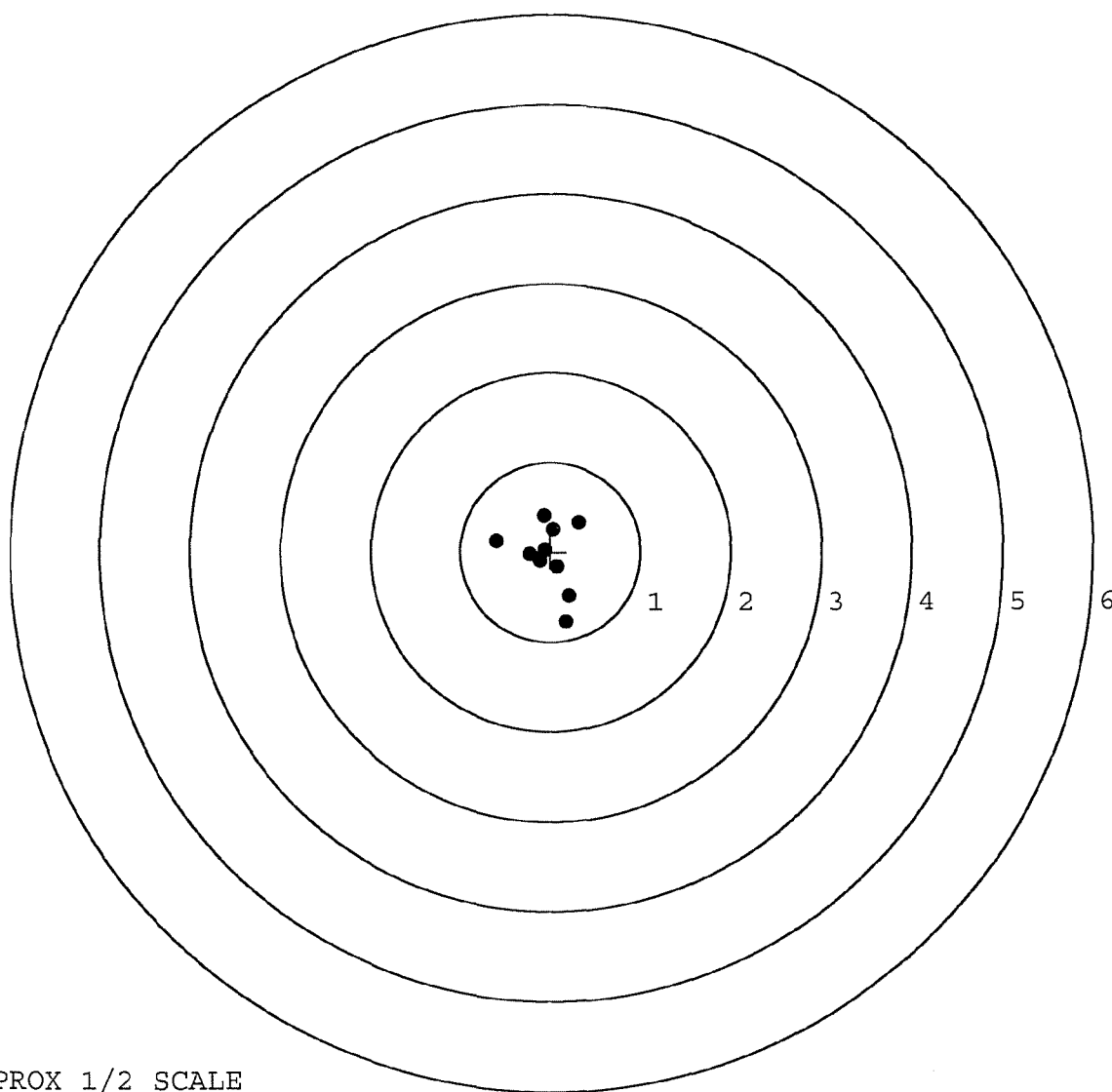


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6523505. __0
TARGET NUMBER: 5
FILE DATE: 01/31/2007
FILE TIME: 23:19

POINT#	X	Y
1:	-0.077	0.402
2:	0.314	0.332
3:	-0.596	0.123
4:	-0.232	-0.032
5:	-0.116	-0.106
6:	0.076	-0.170
7:	0.207	-0.496
8:	0.176	-0.785
9:	-0.063	0.022
10:	0.036	0.251

X CENTROID: -0.027
Y CENTROID: -0.046
POA TO CENTROID: 0.054
HORZ SPREAD: 0.910
VERT SPREAD: 1.187
GROUP SPREAD: 1.214
MIN RADIUS: 0.077
MAX RADIUS: 0.767
MEAN RADIUS: 0.368
IN 1 IN DIAMETER: 6
IN 2 IN DIAMETER: 10
in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

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

R & E NUMBER	123911		
SERIAL NUMBER	06523505		
LOG-IN DATE	1-18-07		
OPERATION #	OPERATION NAME	DATE	INITIAL
500	DIS-ASSEMBLE GUN	1-22-07	RTZ
505	RE-BARREL	1-23-07	RTZ
420	ASSEMBLE	1-23-07	RTZ
440	PROOF	MAGNA-FLUX INSPECTED 1-24-07	TRW
460	CHECK HEADSPACE	1-24-07	RTZ
470	DIS-ASSEMBLE GUN	JAN 29 2007 1-24-07	RTZ
480	MAGNAFLUX	OPERATOR (APD)	1-29-07 APD
510	DRILL AND TAP	1-26-07	TRW
500	ROLLMARK CALIBER	1-29-07	CW
520	GOFF BLAST BBL / REC	1-29-07	UB
530 & 540	APPLY COATINGS	1-29-07	W
560	FINAL ASSEMBLY	1-31-07	RTZ
640	FUNCTION TEST AND	(PASS) FAIL 1/31/07	non
650	TARGET	(PASS) FAIL 1/31/07	non
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
670	FINAL INSPECTION	2-2-07	RTZ
	A) HEADSPACE	(PASS) FAIL 2-2-07	RTZ
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS 2.40 2.46 2.54 2.57 2.48 2-1-07	TRW
680	F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX 6.25 6.0 6.0 2-1-07	TRW
	G) SAFETY OFF FORCE	2 LBS MIN 2.75 2.5 2.5 2-1-07	TRW
	I) FIRING PIN INDENT	.020 .025 .0245 .0245 2-1-07	TRW
690	PACK	2-16-07	DA

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

ORDER

R 94-18821

INITIAL CUSTOMER ORDER NO.

JUM DAAA09-92-C-0834

W/10X SCOPE M-24 SNIPER W/DEPLOYMENT KIT

ATTN FRED MARTIN Scope S/N 90-0834

DATE RECEIVED

DATE OPENED

DATE CODE

SERIAL NUMBER

NEW SERIAL NUMBER

MODEL AND GRADE

06/14/94

06/15/94

C6523505

700 7.62

NATO

ACCESSORIES

HARD CASE

SCOPE MNTS

SCOPE BASE

SLING STRAP

FROM:

SHIP TO:

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

AL 36201-5025

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

AL

36201-5025

ACCOUNT NUMBER

ACCOUNT NUMBER N/C

WRITE ☐

PROM. DATE

ESTIMATED

VIA

UPS

GUN CONDITION

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

REPAIR CHARGE

EXCISE

TAX

INSURANCE

UPS

PARCEL POST

TOTAL

CUSTOMER CONCERN

AMMO

FUNCTION

FINISH

ACCURACY

FIT

INSPECT

CYCLE

A1

B1

TRIGGER GROUP

B2

E1

F1

BOLT ASSY.

B3

E2

F2

BARREL ASSY.

B4

D1

E3

F3

REC. ASSY.

B5

D2

E4

F4

WOOD

C1

D3

E5

F5

METAL

C2

MAIN FAULT

PARTS

COMMENTS

REPAIRMAN

PROOF

CLEAN

TEST

TARGET

PATTERN

GALLERY TESTER

DATE

DATE

DATE

DATE

DATE

OFFICE COPY

RD6925 REV. 1/94

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

M2400029286

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#
3.00# + .75#
4.00# + 1.00#

SERIAL NO. C6523505

DATE 7-17-96

TESTER DA

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.33	2.57	2.60		MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.42	2.58	2.60		
PULL #3	2.23	2.69	2.40		
PULL #4	2.50	2.59	2.62		
PULL #5	2.28	2.39	2.32		
TOTAL	11.76	12.82	12.54		
AVG.	2.35	2.56	2.50		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.09	3.08		
PULL #2	3.18	3.15		
PULL #3	3.11	3.32		
PULL #4	3.27	3.29		
PULL #5	3.06	3.12		
TOTAL	15.71	15.94		
AVG.	3.14	3.19		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.04	4.05		4.05
PULL #2	4.16	4.04		4.15
PULL #3	4.06	4.00		4.20
PULL #4	4.01	3.93		4.00
PULL #5	4.07	4.16		4.00
TOTAL	20.34	20.18		20.40
AVG.	4.06	4.03		4.08

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	7	7	7.25			8/2	SF
	G) Safety Off Force	4	5	5			8/2	SF
	H) Trigger Pull Test & Retainability							
	I) Firing Pin Indent	.024	.024	.0245			8/2	SF
	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 Clarity of Scope							
645	Inspect for Live Ammo							
655	Final Inspection A) Headspace							
	B) Trigger Pull	2.38	2.41	2.42	2.40	2.40	8/2	SF
	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			
	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			

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6523505
7 Jan 1900

CENTROIDAL DISTANCES

0 TO 1	.192276
1 TO 2	.265036
1 TO 3	.267882
1 TO 4	.0816333
1 TO 5	.394183

5
4 <----POA

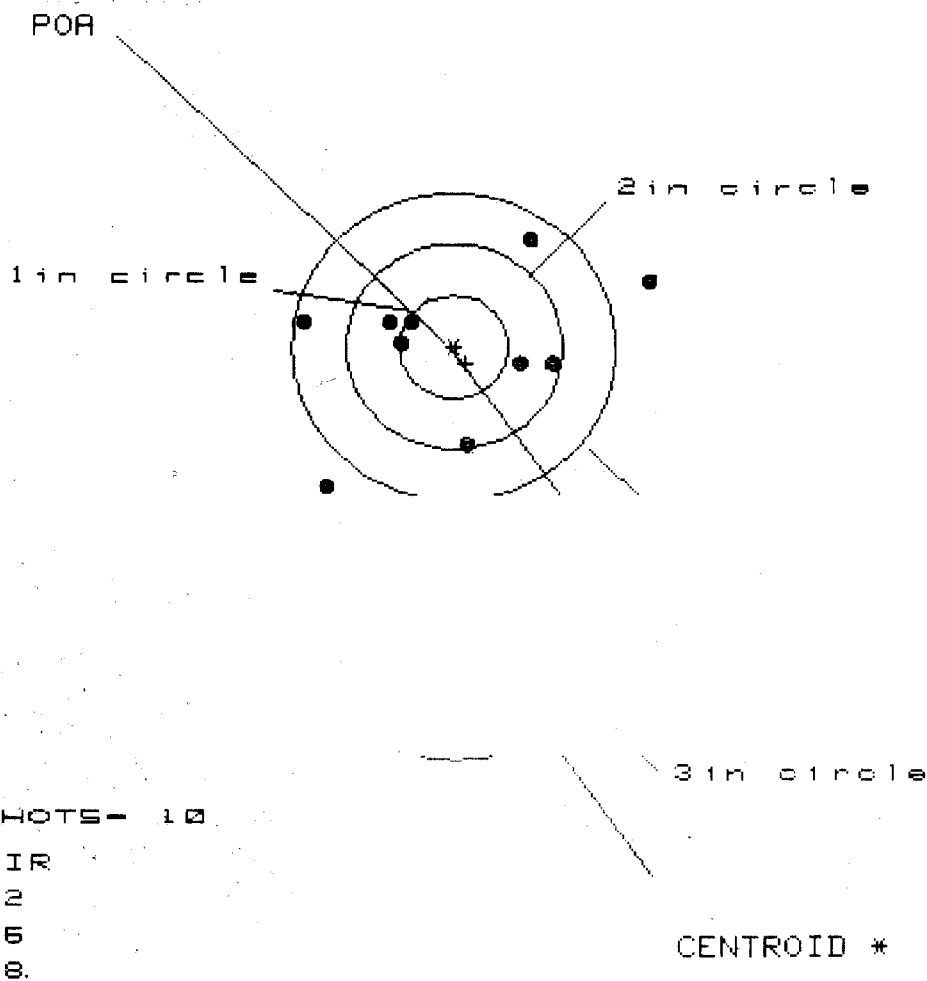
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.02
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1722
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .173358
THE AMR FOR THIS RIFLE IS: 1.05

7 Jan 1900

FILE:/PATTERNING/CENTERFIRE_PATT/C6523505

CENTERFIRE PATTERNS

1



* OF SHOTS - 10

* IN CIR

1in = 2

2in = 6

3in = 8

HS = 3.249

VS = 2.375

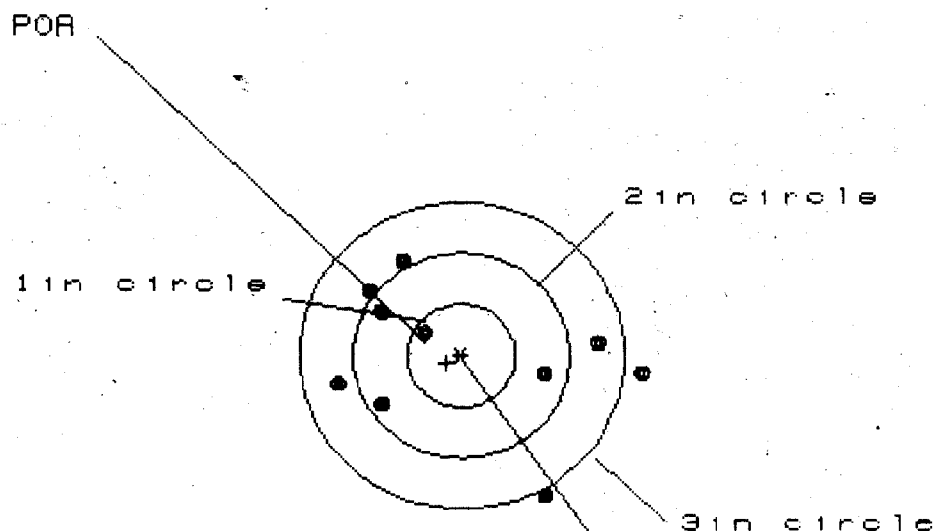
GS = 3.615

PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.821	1.148	1.026
MINIMUM X	:	-1.428	-1.226	-1.348
MAXIMUM Y	:	1.051	1.128	.972
MINIMUM Y	:	-1.324	-1.247	-.990
CENTROID X	:	-.111	-.313	-.191
CENTROID Y	:	.157	.080	.236
POA TO CENTROID in.	:	.192	.323	.303
MIN RADIUS	:	.469	.293	.363
MEAN RADIUS	:	1.050	.921	.833
MAX RADIUS	:	1.948	1.585	1.363
HORIZONTAL SPREAD	:	3.249	2.374	2.374
VERTICAL SPREAD	:	2.375	2.375	1.962
EXTREME SPREAD	:	3.615	3.006	2.415
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	6		
NUMBER IN THREE INCH CIRCLE	=	8		

7 Jan 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C6523505

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in - 1

2in - 4

3in = 8

HS- 2.756

VS- 2.295

GS- 2.758

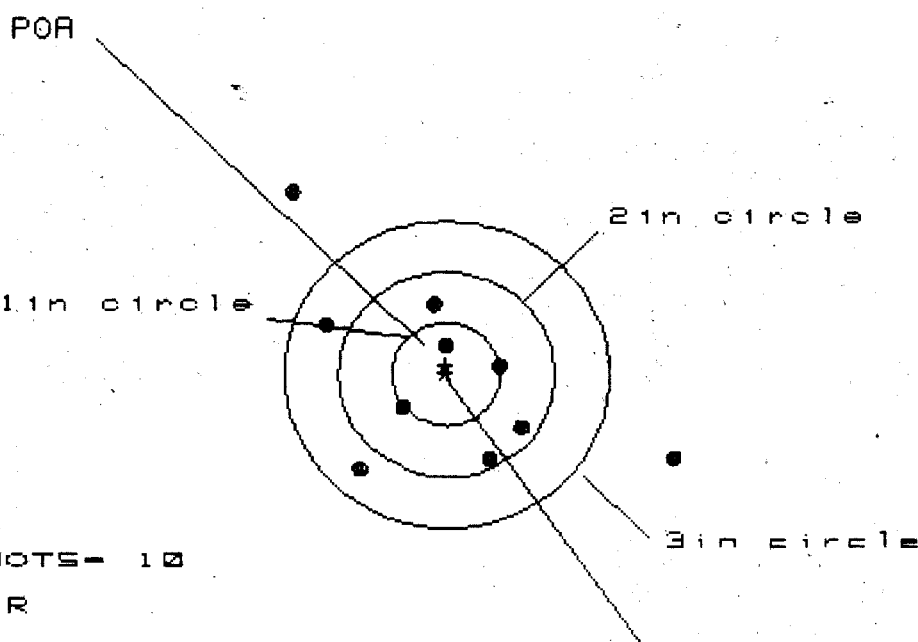
CENTROID *

PATTERN #	:			
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.645	1.419	1.535
MINIMUM X	:	-1.110	-.928	-.811
MAXIMUM Y	:	.912	.899	.724
MINIMUM Y	:	-1.383	-1.396	-.626
CENTROID X	:	.139	-.043	-.160
CENTROID Y	:	.069	.082	.257
POA TO CENTROID in.	:	.156	.093	.302
MIN RADIUS	:	.436	.291	.084
MEAN RADIUS	:	1.060	.950	.791
MAX RADIUS	:	1.650	1.677	1.536
HORIZONTAL SPREAD	:	2.756	2.347	2.347
VERTICAL SPREAD	:	2.295	2.295	1.350
EXTREME SPREAD	:	2.758	2.652	2.375
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	

7 Jan 1900

FILE:/PATTERNING/CENTERFIRE_PATT/C6523505

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 2

2in = 6

3in = 8

HS= 3.544

VS= 2.695

GS= 4.381

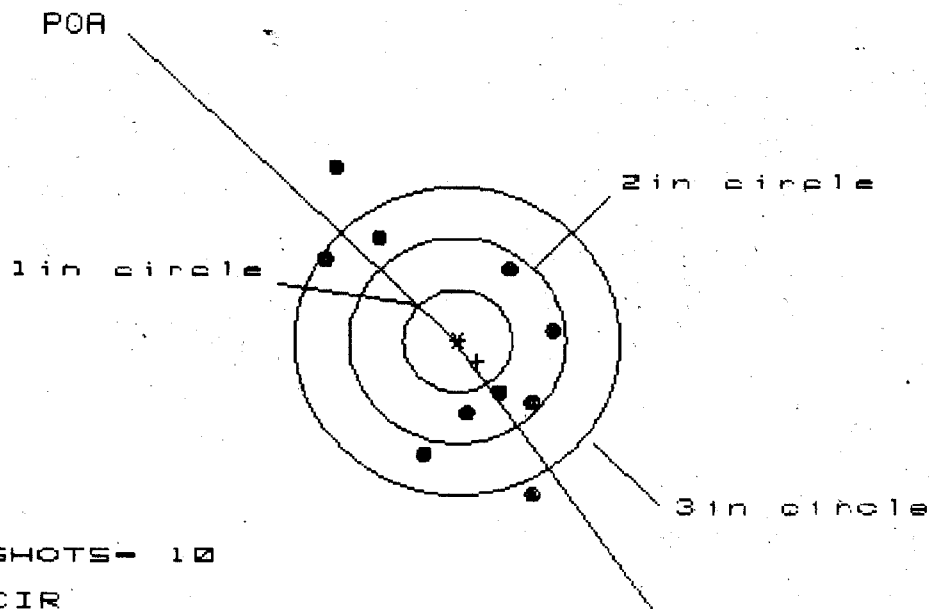
CENTROID *

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.129	1.972	.799
MINIMUM X	:	-1.415	-1.247	-1.001
MAXIMUM Y	:	1.795	.891	.818
MINIMUM Y	:	-.900	-.700	-.773
CENTROID X	:	.008	.165	-.081
CENTROID Y	:	-.083	-.283	-.210
POA TO CENTROID in.	:	.084	.327	.225
MIN RADIUS	:	.247	.463	.359
MEAN RADIUS	:	1.067	.927	.766
MAX RADIUS	:	2.286	2.055	1.151
HORIZONTAL SPREAD	:	3.544	3.219	1.800
VERTICAL SPREAD	:	2.695	1.591	1.591
EXTREME SPREAD	:	4.381	3.443	2.049
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

7 Jan 1900

FILE:/PATTERNING/CENTERFIRE_PATT/C6523505

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1 in - 0

2 in - 5

3 in = 8

HS- 2.105

VS= 3.227

GS= 3.708

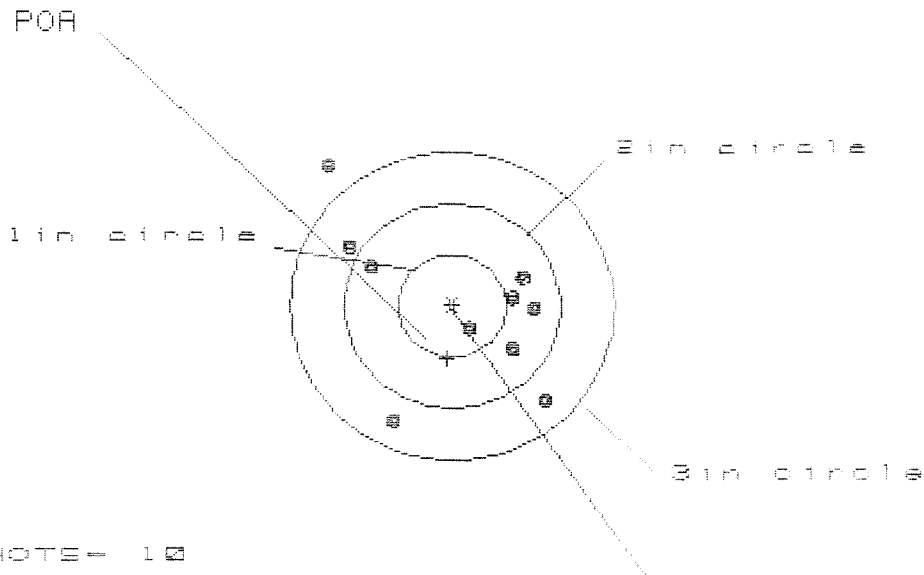
CENTROID *

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.922	.796	.866
MINIMUM X	:	-1.182	-1.309	-1.239
MAXIMUM Y	:	1.738	1.160	.998
MINIMUM Y	:	-1.489	-1.296	-1.022
CENTROID X	:	-.181	-.054	-.124
CENTROID Y	:	.199	.006	.168
POA TO CENTROID in.	:	.269	.054	.208
MIN RADIUS	:	.624	.396	.564
MEAN RADIUS	:	1.153	.992	.963
MAX RADIUS	:	2.078	1.665	1.512
HORIZONTAL SPREAD	:	2.105	2.105	2.105
VERTICAL SPREAD	:	3.227	2.456	2.020
EXTREME SPREAD	:	3.708	2.982	2.415
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

7 Jan 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C8523585

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 8

HS= 2.015

VS= 2.515

GS= 3.098

CENTROID #

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.823	.690	.735
MINIMUM X	-1.192	-1.035	-.949
MAXIMUM Y	1.395	.776	.675
MINIMUM Y	-1.120	-.965	-1.066
CENTROID X	.045	.178	.091
CENTROID Y	.519	.364	.465
POA TO CENTROID in.	.521	.405	.474
MIN RADIUS	.237	.055	.167
MEAN RADIUS	.921	.763	.747
MAX RADIUS	1.835	1.293	1.217
HORIZONTAL SPREAD	2.015	1.725	1.684
VERTICAL SPREAD	2.515	1.741	1.741
EXTREME SPREAD	3.098	2.339	1.806
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	9		

Remington



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

MODEL 700™ H24

SERIAL NO.
C6523505

ORDER NO.
5716

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

01



5716 C6523505

UPC



0 47700 25716 7

L 1.8
M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6523505

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		10/2/90	KJ
600	Proof		10/2/90	KJ
607	Check Headspace		10/2/90	KJ
610	Dis-assemble Gun		10/2/90	KJ
612	Magnaflux Barrel Action		10/5/90	KR
	Magnaflux Bolt		10/5/90	KR
615	Rollmark Caliber		10/5/90	SS
617	Drill and Tap Sight Holes		10/8/90	KB
618	Polish Barrel <i>KB</i>		10/9/90	WB
620	Apply Coatings (Barrel Action)		10-20-90	TJA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		10/2/90	KJ
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/2/90	KJ
	C) Inspect Ejector Hole for Chamfer		10/2/90	KJ
	D) Oil Firing Pin Ass'y		10/2/90	KJ
	E) Adjust Trigger Pull to Min Setting and Stake		11/2/90	KL

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			11/2/90	WB
	G) Safety Off Force	2	2	2			11/2/90	WB
	H) Trigger Pull Test & Retainability						11/2/90	JH
	I) Firing Pin Indent	.021	.0205	.021			11/2/90	WB
	J) Assemble Stock						11/2/90	KH
	K) Assemble Swivel Studs						11-20-90	JD
	L) Attach Front and Rear Sight Assemblies						11/2/90	KH
	M) Iron Sight Alignment						11/2/90	KH
	N) Detach Front & Rear Sights & place in numbered container						11/2/90	KH
	O) Attach Scope to Rifle						11/2/90	KH
	P) Detach & Attach Scope 20 Times						11/2/90	KH
640	Gallery Target & Test						11-6-90	DH
	A) Time						11-6-90	DH
	B) Malfunctions						11-6-90	DH
	C) Pierced Primers						11-6-90	DH
	D) Optical Clarity of Scope						11-6-90	DH
645	Inspect for Live Ammo						11-6-90	DH
655	Final Inspection							
	A) Headspace						11-20-90	JD
	B) Trigger Pull	242	236	237	236	237	11-20-90	JD
	C) Function						11-20-90	JD
660	Pack						12/18/90	AF

SWS TRIGGER PULL TEST

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

SERIAL NO 06523505
DATE 11/2/90
TESTER JPL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.35	2.11	2.35	2.42	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.19	2.38	2.27	2.36	
PULL #3	2.30	2.21	2.32	2.37	
PULL #4	2.35	2.23	2.23	2.36	
PULL #5	2.19	2.37	2.25	2.37	
TOTAL	11.38	11.3	11.42		
AVG.	2.276	2.26	2.284		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.46	3.41		
PULL #2	3.32	3.38		
PULL #3	3.42	3.43		
PULL #4	3.41	3.40		
PULL #5	3.41	3.38		
TOTAL	17.02	17.00		
AVG.	3.404	3.4		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.31	4.32		4.36
PULL #2	4.34	4.21		4.34
PULL #3	4.30	4.36		4.28
PULL #4	4.27	4.28		4.34
PULL #5	4.17	4.16		4.19
TOTAL	21.39	21.33		21.51
AVG.	4.278	4.266		4.302

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6523505
6 Nov 1990

CENTROIDAL DISTANCES

0 TO 1	.145962
1 TO 2	.00360555
1 TO 3	.10002
1 TO 4	.222
1 TO 5	.0604401

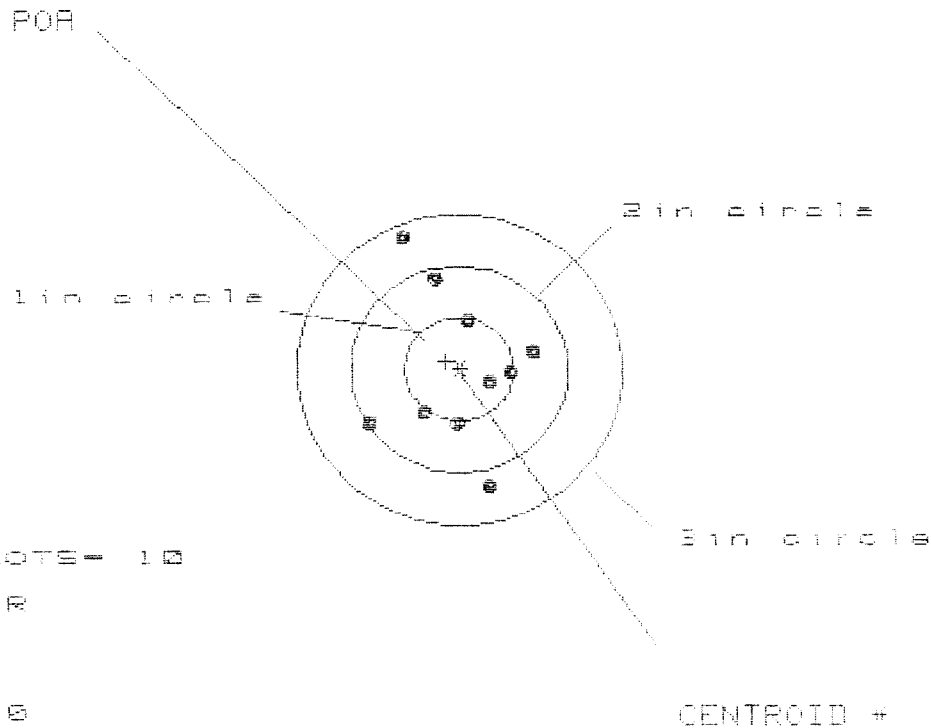
1 <----POB

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1524
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0914
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .177707
THE AMR FOR THIS RIFLE IS: .7776

8 May 1988

FILE:/PATTERNING/CENTERFIRE_PATT/06523585

CENTERFIRE PATTERNS # 1



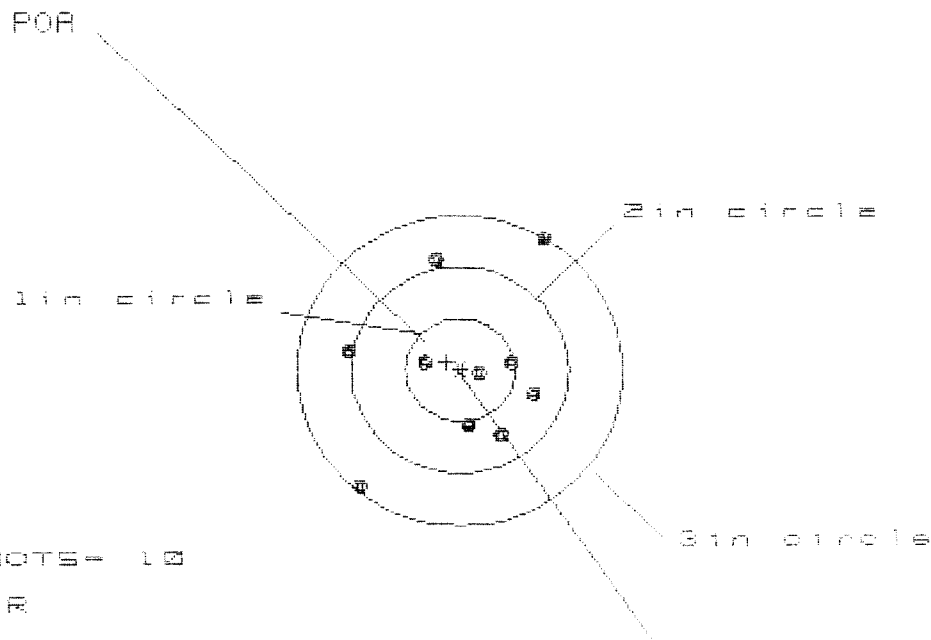
OF SHOTS = 10
 # IN CIR
 1 in = 4
 2 in = 6
 3 in = 10
 HS = 1.518
 VS = 2.363
 GS = 2.512

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.716	.656	.689
MINIMUM X	-.802	-.862	-.829
MAXIMUM Y	1.256	1.040	.919
MINIMUM Y	-1.107	-.968	-.541
CENTROID X	.124	.184	.151
CENTROID Y	-.077	-.216	-.095
POR TO CENTROID in.	.146	.284	.179
MIN RADIUS	.318	.222	.285
MEAN RADIUS	.747	.651	.613
MAX RADIUS	1.365	1.082	.990
HORIZONTAL SPREAD	1.518	1.518	1.518
VERTICAL SPREAD	2.363	2.008	1.460
EXTREME SPREAD	2.512	2.084	1.784
NUMBER IN ONE INCH CIRCLE =	4		
NUMBER IN TWO INCH CIRCLE =	8		
NUMBER IN THREE INCH CIRCLE =	10		

6 Nov 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6523585

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1in = 3

2in = 7

3in = 10

HS= 1.794

VS= 2.360

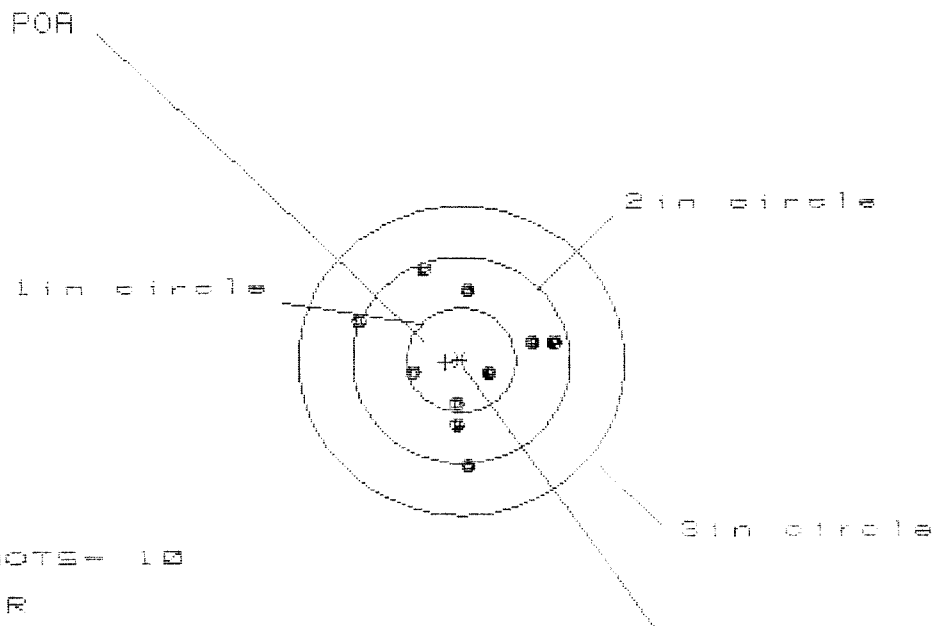
GS= 2.956

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.817	.775	.666
MINIMUM X	:	-.977	-.886	-.995
MAXIMUM Y	:	1.241	1.169	1.046
MINIMUM Y	:	-1.119	-.981	-.634
CENTROID X	:	.127	.036	.145
CENTROID Y	:	-.075	-.213	-.090
POA TO CENTROID in.	:	.148	.216	.171
MIN RADIUS	:	.126	.250	.107
MEAN RADIUS	:	.803	.727	.629
MAX RADIUS	:	1.486	1.313	1.078
HORIZONTAL SPREAD	:	1.794	1.661	1.661
VERTICAL SPREAD	:	2.360	2.150	1.681
EXTREME SPREAD	:	2.956	2.269	1.792
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

8 Nov 1998

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CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1in = 2

2in = 9

3in = 10

IS = 1.843

VS = 1.818

GS = 1.870

CENTROID #

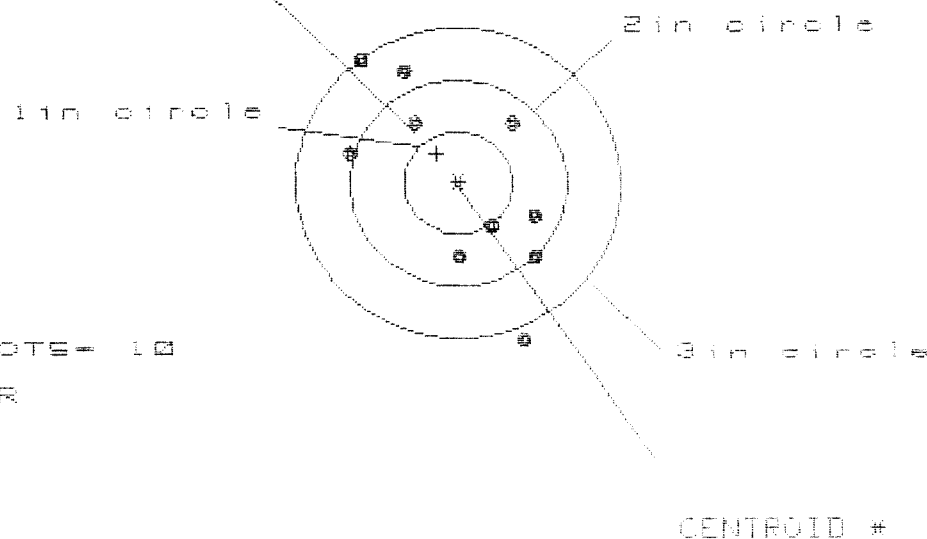
PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.900	.795	.788
MINIMUM X	:	-.943	-.588	-.595
MAXIMUM Y	:	.846	.886	.769
MINIMUM Y	:	-.972	-.932	-.744
CENTROID X	:	.144	.249	.256
CENTROID Y	:	.021	-.019	.098
POA TO CENTROID in.	:	.145	.249	.274
MIN RADIUS	:	.300	.189	.267
MEAN RADIUS	:	.706	.656	.628
MAX RADIUS	:	1.008	1.015	.919
HORIZONTAL SPREAD	:	1.843	1.383	1.383
VERTICAL SPREAD	:	1.818	1.818	1.513
EXTREME SPREAD	:	1.870	1.870	1.544
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		9	
NUMBER IN THREE INCH CIRCLE	=		10	

8 Nov 1998

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CENTERFIRE PATTERNS # 4

POA



OF SHOTS= 10

IN CIR

1in = 1

2in = 5

3in = 9

HS= 1.714

VS= 2.691

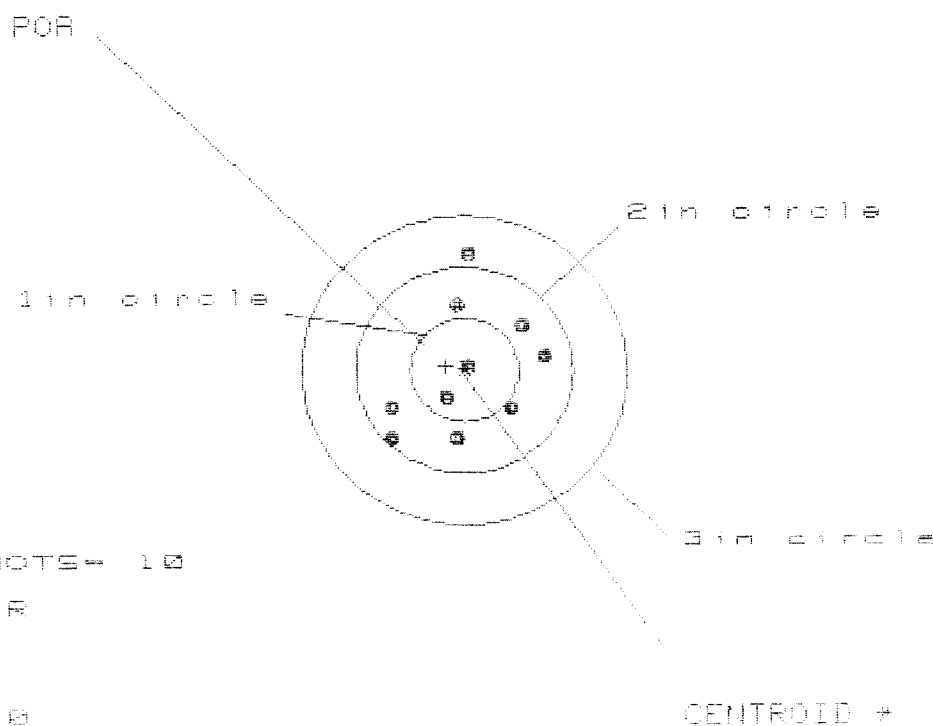
GS= 3.050

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.714	.776	.674
MINIMUM X	:	-1.000	-.938	-1.040
MAXIMUM Y	:	1.213	1.049	1.066
MINIMUM Y	:	-1.478	-.914	-.783
CENTROID X	:	.196	.134	.236
CENTROID Y	:	-.287	-.123	-.254
POA TO CENTROID in.	:	.348	.182	.347
MIN RADIUS	:	.486	.523	.492
MEAN RADIUS	:	.974	.903	.831
MAX RADIUS	:	1.579	1.330	1.130
HORIZONTAL SPREAD	:	1.714	1.714	1.714
VERTICAL SPREAD	:	2.691	1.963	1.789
EXTREME SPREAD	:	3.050	2.528	2.148
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

8 Nov 1998

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CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1in = 2

2in = 8

3in = 10

HS= 1.372

VS= 1.866

ES= 1.963

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.699	.705	.622
MINIMUM X	-.673	-.667	-.750
MAXIMUM Y	1.169	.799	.734
MINIMUM Y	-.697	-.568	-.633
CENTROID X	.171	.165	.248
CENTROID Y	-.039	-.168	-.103
POR TO CENTROID in.	.175	.236	.269
MIN RADIUS	.019	.140	.094
MEAN RADIUS	.658	.593	.556
MAX RADIUS	1.170	.847	.823
HORIZONTAL SPREAD	1.372	1.372	1.372
VERTICAL SPREAD	1.866	1.367	1.367
EXTREME SPREAD	1.963	1.599	1.487
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	9		
NUMBER IN THREE INCH CIRCLE =	10		