C6611781

MODEL 700™ M24

Model SWS™

Action

Barrel Length

Capacity

Order No. 5716

*Includes 1 in chamber.

Remington

07/22/09 10:28:38

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: RE00171689
Verify Repair

Serial: C6611781 Model M24 SWS Center Fire
Caliber: 7.62 NATO

Repairman:
Status: Closed 7/22/2009 8:48:49 AM

Address Information

Customer:	Received From	Return To:	Received From
Name:	TRANSPORTATION OFFICER	TRANSPORTATION OFFICER	
Address 1:	USPFO FOR ARKANSAS BLDG 0318	USPFO FOR ARKANSAS BLDG 0318	
Address 2:	CAMP ROBINSON PO Box:	CAMP ROBINSON PO Box:	
City:	NORTH LITTLE ROCK	NORTH LITTLE ROCK	
State:	AR Zip Code: 72199 Country: US	State: AR Zip Code: 72199 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	3
A010	Hard Case	1
A017	Scope Base	1
A057	Frt and Rear Sgt Base	1

Repair Search | Refresh | Close

nagleti | 7/22/2009 | 10:28 AM | CAPS | NUM | INS | SCRL

start | Arms Services Repair ... | 10:28 AM

Serial Number: C6611781

Model: M24 SWS

RE00171689

M-24

INSPECTION CHECKLIST - REPAIRS

CONTRACT #: W52H09-07-C-0207

ISSUED 10/1/2007

R & E NUMBER 171689-

SERIAL NUMBER C6611781

LOG-IN DATE 7-22-09

OPERATION #	OPERATION NAME		DATE	INITIAL
500	DIS-ASSEMBLE GUN		7-27-09	RTC
505	RE-BARREL		7-28-09	RTC
420	ASSEMBLE		7-28-09	RTC
440	PROOF	MAGNA - FLUX 2009 OPERATOR RP	7-28-09	RTC
460	CHECK HEADSPACE		7-28-09	RTC
470	DIS-ASSEMBLE GUN		7-28-09	RTC
480	MAGNAFLUX		7/31/09	RP
510	DRILL AND TAP		7-29-09	SB
500	ROLLMARK CALIBER		7-31-09	DWD
520	GOFF BLAST BBL / REC		7/31/09	
530 & 540	APPLY COATINGS		8/4	
560	FINAL ASSEMBLY		8-7-09	RTC
640	FUNCTION TEST AND	(PASS) FAIL	8-18-09	RP
650	TARGET	(PASS) FAIL	8-18-09	RP
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION N/A		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION	8-18-09	RTC
670	FINAL INSPECTION A) HEADSPACE	(PASS) FAIL	8-19-09	RTC
	B) TRIGGER PULL (+/- .5 LBS, MIN 2.50 LBS, MAX 4.0 LBS)	2.7 2.7 2.7 2.7 2.8	8-19-09	RTC
680	F) SAFETY ON FORCE (2 LBS MIN, 10 LBS MAX)	6 6 6	8-19-09	RTC
	G) SAFETY OFF FORCE (2 LBS MIN)	4 4 4	8-19-09	RTC
	I) FIRING PIN INDENT (.020)	.024 .024 .024	8-19-09	RTC
690	PACK		8/19/09	FM

F006 REV 1/2009

EQUIPMENT INSPECTION AND MAINTENANCE WORKSHEET

For use of this form, see DA PAM 738-750 and 738-751; the proponent agency is DCSLOG

1. ORGANIZATION	2. NOMENCLATURE AND MODEL
NGMTU	7.62MM M24 SNIPER WEAPON SYSTEM (SWS)

3. REGISTRATION/SERIAL/NSN	4a. MILES	b. HOURS	c. ROUNDS FIRED	d. HOT STARTS	5. DATE	6. TYPE INSPECTION
C6611781						PMCS

7. APPLICABLE REFERENCE

TM NUMBER	TM DATE	TM NUMBER	TM DATE
9-1005-306-10	JUNE 1989		

COLUMN a – Enter TM item number.
COLUMN b – Enter the applicable condition status symbol.
COLUMN c – Enter deficiencies and shortcomings.
COLUMN d – Show corrective action for deficiency or shortcoming listed in Column c.
COLUMN e – Individual ascertaining completed corrective action initial in this column.

STATUS SYMBOLS

"X" – Indicates a deficiency in the equipment that places it in an inoperable status.

CIRCLED "X" – Indicates a deficiency, however, the equipment may be operated under specific limitations as directed by higher authority or as prescribed locally, until corrective action can be accomplished.

HORIZONTAL DASH "(-)" – Indicates that a required inspection, component replacement, maintenance operation check, or test flight is due but has not been accomplished, or an overdue MWO has not been accomplished.

DIAGONAL "(/)" – Indicates a material defect other than a deficiency which must be corrected to increase efficiency or to make the item completely serviceable.

LAST NAME INITIAL IN BLACK, BLUE-BLACK INK, OR PENCIL - Indicates that a completely satisfactory condition exists.

FOR AIRCRAFT - Status symbols will be recorded in red.

ALL INSPECTIONS AND EQUIPMENT CONDITIONS RECORDED ON THIS FORM HAVE BEEN DETERMINED IN ACCORDANCE WITH DIAGNOSTIC PROCEDURES AND STANDARDS IN THE TM CITED HEREON.

8a. SIGNATURE *(Person(s) performing inspection)*	8b. TIME	9a. SIGNATURE *(Maintenance Supervisor)*	9b. TIME	10. MANHOURS REQUIRED

TM ITEM NO. a	STATUS b	DEFICIENCIES AND SHORTCOMINGS c	CORRECTIVE ACTION d	INITIAL WHEN CORRECTED e
1		BARREL SHOT OUT		

DA FORM 2404, APR 1979 Replaces edition of 1 Jan 64, which will be used APD PE v1.10

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFOMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6611781.__0
FILE DATE AND TIME: 08/19/2009 05:59

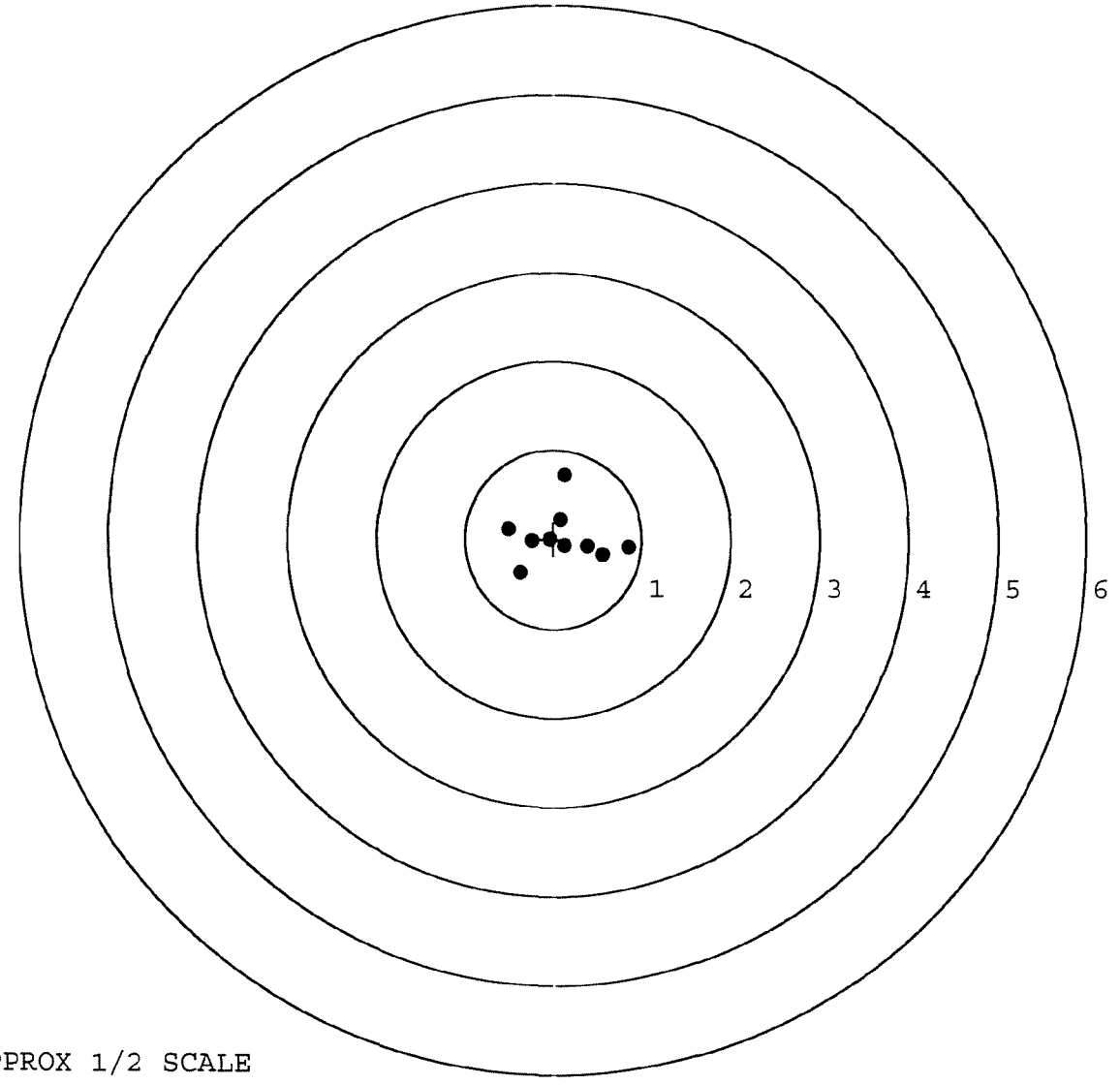
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.074
The Average Y Centroid of the Five Target Set:	-0.039
The Average Point of Impact of the Five Target Set:	0.084
The Average Mean Radius of the Five Target Set:	0.583
The Distance from POA to Centroid Target #1:	0.099
The Distance from Centroid Target #2 to Centroid Target #1:	0.081
The Distance from Centroid Target #3 to Centroid Target #1:	0.126
The Distance from Centroid Target #4 to Centroid Target #1:	0.132
The Distance from Centroid Target #5 to Centroid Target #1:	0.035

SERIAL NUMBER: C6611781.__0
TARGET NUMBER: 1
FILE DATE: 08/19/2009
FILE TIME: 05:59

X CENTROID:	0.096
Y CENTROID:	0.022
POA TO CENTROID:	0.099
HORZ SPREAD:	1.358
VERT SPREAD:	1.090
GROUP SPREAD:	1.374
MIN RADIUS:	0.107
MAX RADIUS:	0.762
MEAN RADIUS:	0.429
# IN 1 IN DIAMETER:	6
# IN 2 IN DIAMETER:	10
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	0.130	0.715
2:	0.849	-0.096
3:	0.556	-0.174
4:	0.389	-0.081
5:	0.083	0.219
6:	0.133	-0.079
7:	-0.045	-0.005
8:	-0.379	-0.375
9:	-0.245	-0.020
10:	-0.509	0.113

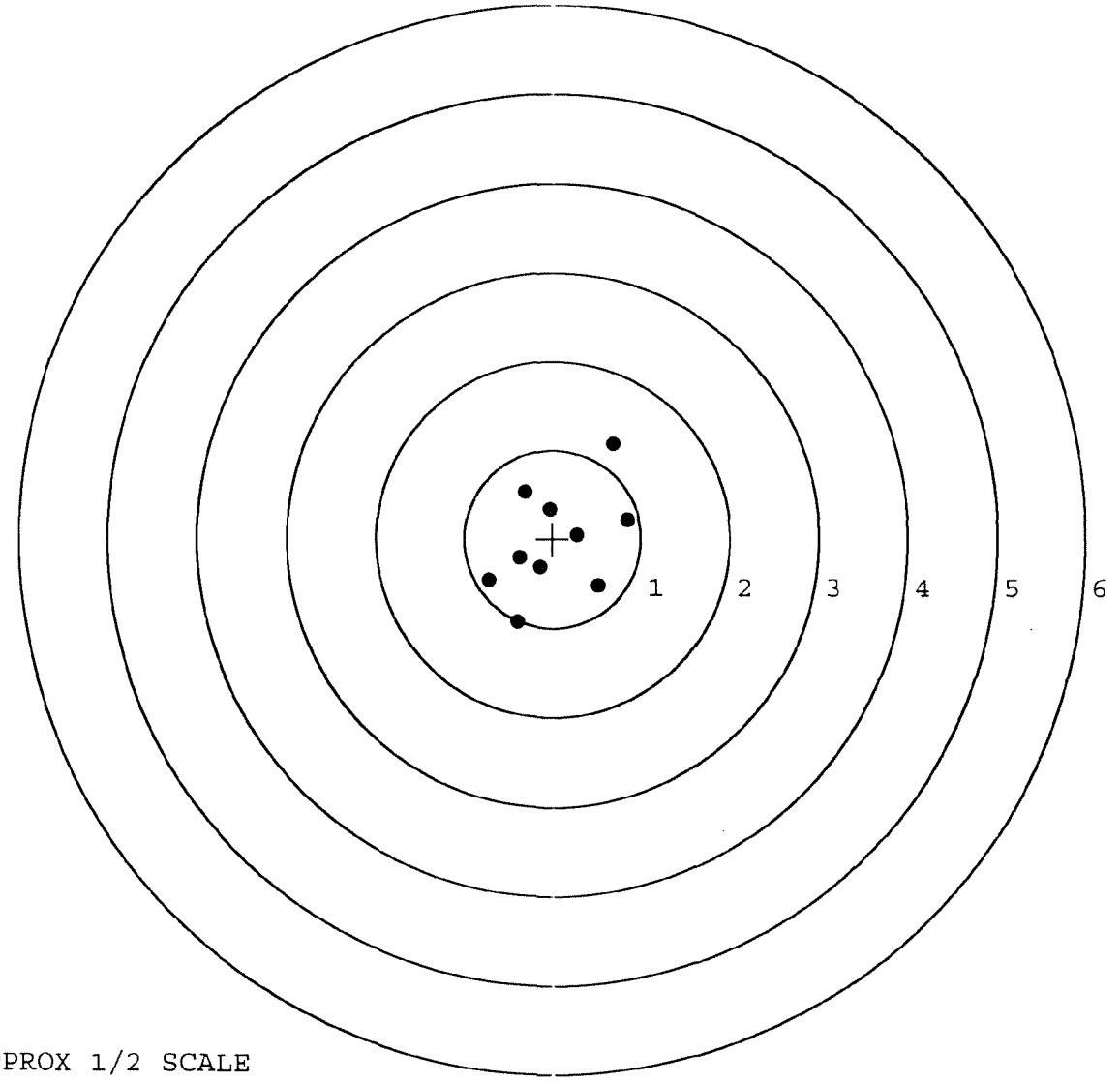


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6611781.__0
TARGET NUMBER: 2
FILE DATE: 08/19/2009
FILE TIME: 05:59

X CENTROID:	0.034
Y CENTROID:	-0.030
POA TO CENTROID:	0.045
HORZ SPREAD:	1.577
VERT SPREAD:	2.006
GROUP SPREAD:	2.281
MIN RADIUS:	0.258
MAX RADIUS:	1.275
MEAN RADIUS:	0.678
# IN 1 IN DIAMETER:	4
# IN 2 IN DIAMETER:	8
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	0.681	1.068
2:	0.852	0.213
3:	0.517	-0.528
4:	-0.404	-0.938
5:	-0.725	-0.469
6:	-0.142	-0.326
7:	-0.375	-0.219
8:	0.281	0.043
9:	-0.034	0.327
10:	-0.314	0.526

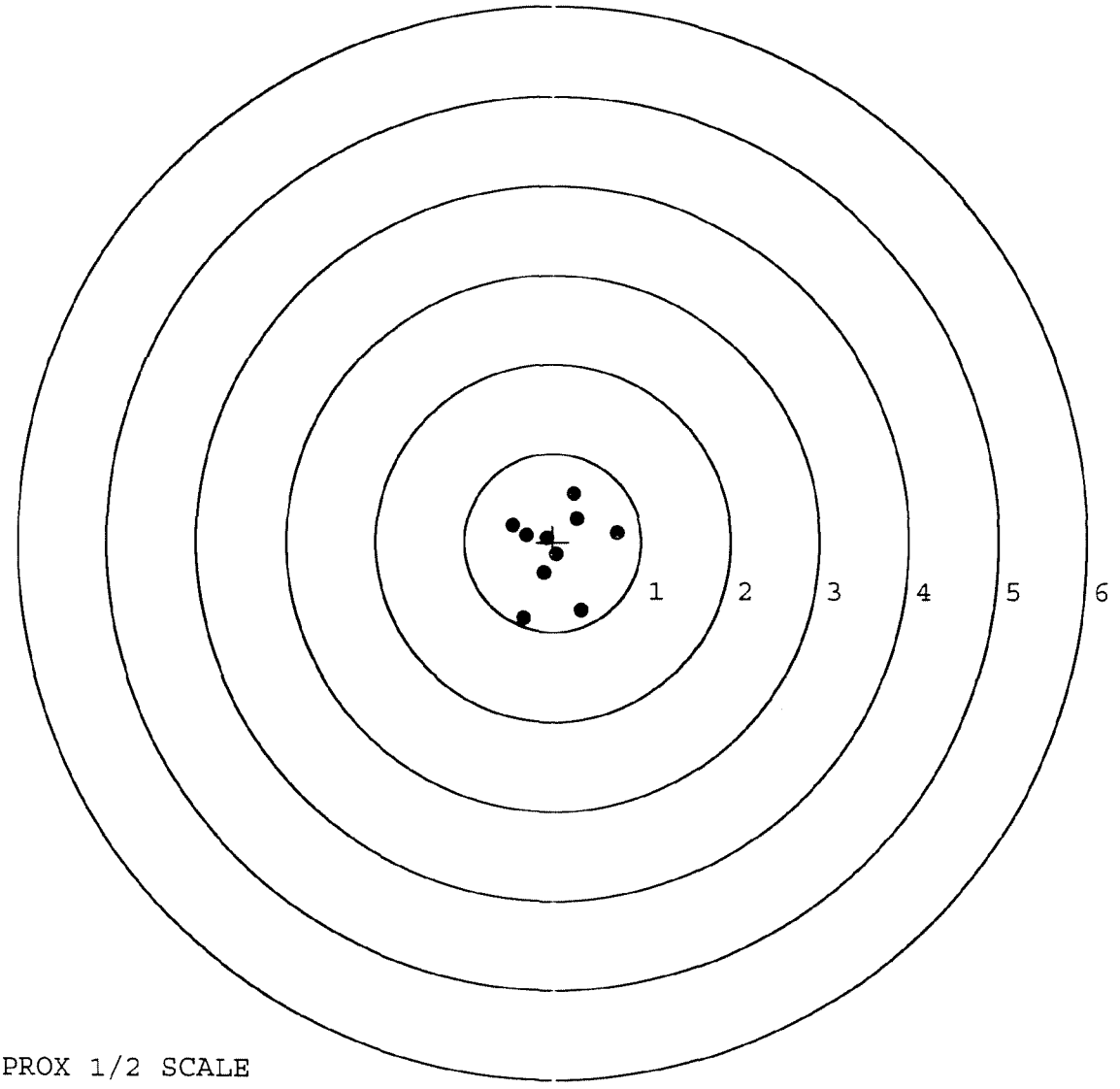


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6611781.__0
TARGET NUMBER: 3
FILE DATE: 08/19/2009
FILE TIME: 05:59

X CENTROID:	0.035
Y CENTROID:	-0.088
POA TO CENTROID:	0.095
HORZ SPREAD:	1.181
VERT SPREAD:	1.403
GROUP SPREAD:	1.516
MIN RADIUS:	0.047
MAX RADIUS:	0.855
MEAN RADIUS:	0.485
# IN 1 IN DIAMETER:	5
# IN 2 IN DIAMETER:	10
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	-0.336	-0.859
2:	0.322	-0.766
3:	0.730	0.104
4:	0.238	0.544
5:	0.276	0.261
6:	-0.105	-0.351
7:	0.043	-0.135
8:	-0.073	0.049
9:	-0.297	0.076
10:	-0.451	0.192

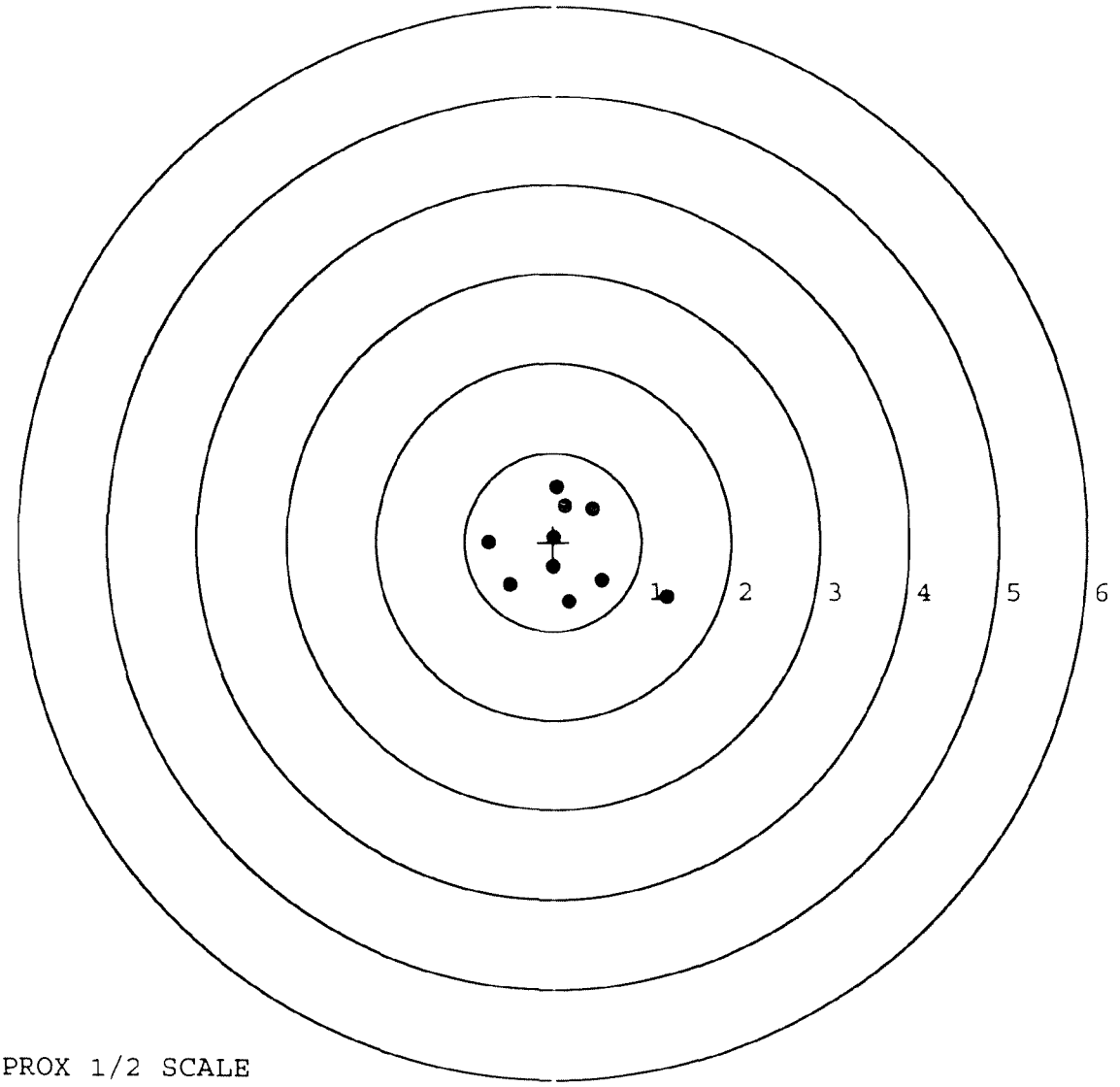


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6611781.__0
TARGET NUMBER: 4
FILE DATE: 08/19/2009
FILE TIME: 05:59

X CENTROID:	0.141
Y CENTROID:	-0.103
POA TO CENTROID:	0.175
HORZ SPREAD:	2.010
VERT SPREAD:	1.288
GROUP SPREAD:	2.101
MIN RADIUS:	0.205
MAX RADIUS:	1.253
MEAN RADIUS:	0.619
# IN 1 IN DIAMETER:	2
# IN 2 IN DIAMETER:	9
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	1.283	-0.620
2:	0.547	-0.429
3:	0.185	-0.667
4:	-0.492	-0.482
5:	-0.727	-0.010
6:	0.000	-0.278
7:	0.011	0.055
8:	0.444	0.375
9:	0.035	0.621
10:	0.128	0.409

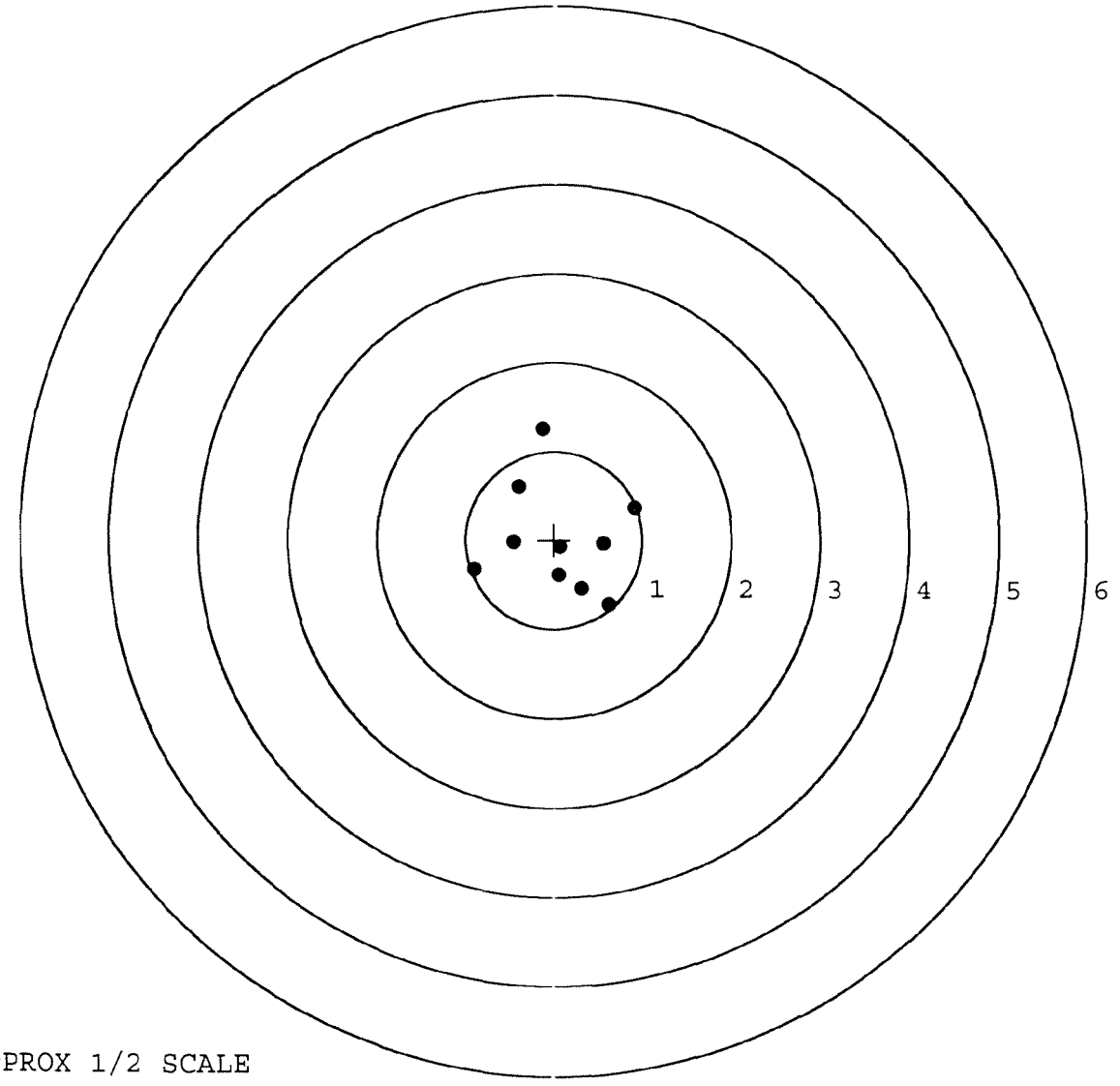


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6611781.__0
TARGET NUMBER: 5
FILE DATE: 08/19/2009
FILE TIME: 05:59

X CENTROID:	0.065
Y CENTROID:	0.005
POA TO CENTROID:	0.066
HORZ SPREAD:	1.811
VERT SPREAD:	1.983
GROUP SPREAD:	2.122
MIN RADIUS:	0.090
MAX RADIUS:	1.260
MEAN RADIUS:	0.702
# IN 1 IN DIAMETER:	3
# IN 2 IN DIAMETER:	8
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	-0.131	1.250
2:	-0.404	0.604
3:	-0.454	-0.020
4:	-0.900	-0.335
5:	0.911	0.366
6:	0.561	-0.036
7:	0.624	-0.733
8:	0.317	-0.556
9:	0.060	-0.405
10:	0.070	-0.085



TARGET APPROX 1/2 SCALE

RECEIVING AND ESTIMATING REPORT

COMMENTS: W/10X SCOPE M-24 SNIPER W/DEPLOYMENT KIT
ATTN FRED MARTIN Scope S/N 90 0349

ORDER: R 94-18851

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

DATE RECEIVED	DATE OPENED	DATE CODE	SERIAL NUMBER	NEW SERIAL NUMBER	MODEL AND GRADE
06/14/94	06/15/94		C6611781		700 7.62 NATO

ACCESSORIES: HARD CASE SCOPE MNTS SCOPE BASE SLING STRAP

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
					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

✓ Barrel
Trigger ASSY
✓ Scope Base

COMMENTS

REPAIRMAN	PROOF	CLEAN	TEST	TARGET	PATTERN
			AC	AC	
GALLERY TESTER	DATE	DATE	DATE	DATE	DATE
			6/13/96	6/13/96	

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. C6611781
DATE 6-10-96
TESTER DA

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.55	2.34	2.56		MIN. SETTING, NO AVG. OF 5 READINGS ACCEPTABLE LESS THAN 2#
PULL #2	2.59	2.36	2.59		
PULL #3	2.70	2.40	2.51		
PULL #4	2.44	2.40	2.48		
PULL #5	2.37	2.27	2.52		
TOTAL	12.65	11.77	12.66		
AVG.	2.53	2.35	2.53		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.20	3.03		
PULL #2	3.13	3.12		
PULL #3	3.20	3.00		
PULL #4	3.25	3.15		
PULL #5	3.24	3.13		
TOTAL	16.02	15.43		
AVG.	3.20	3.08		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.02	3.89		4.16
PULL #2	4.09	3.89		4.00
PULL #3	4.03	4.02		4.16
PULL #4	4.05	4.00		4.08
PULL #5	4.13	4.05		4.00
TOTAL	20.32	19.85		20.40
AVG.	4.06	3.97		4.08

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611781
15 Apr 1900

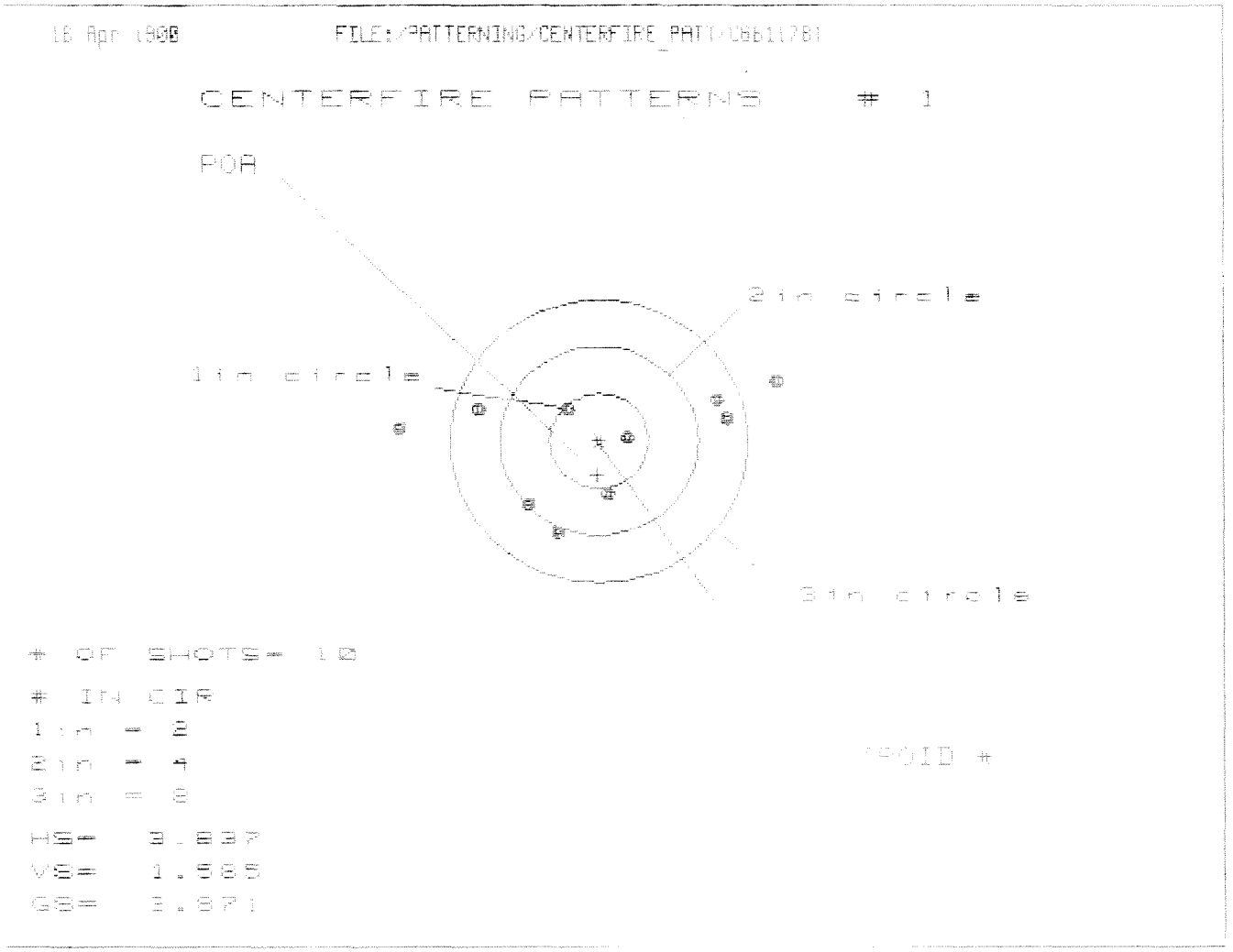
CENTROIDAL DISTANCES

0	TO	1	.363352
1	TO	2	.302035
1	TO	3	.219545
1	TO	4	.331217
1	TO	5	.216689

<----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1004
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .3461
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .360464

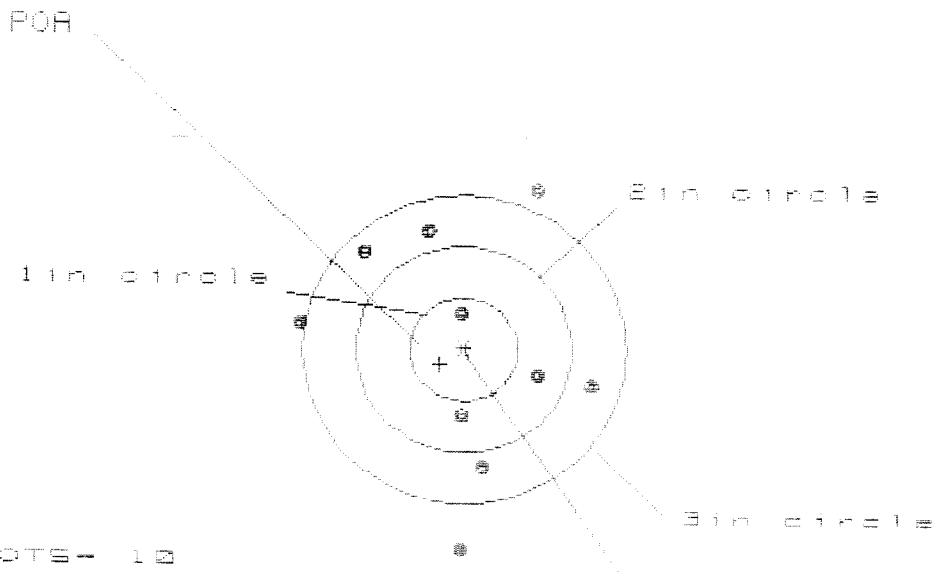
THE AMR FOR THIS RIFLE IS: 1.034



PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.820	1.596	1.231
MINIMUM X	:	-2.017	-1.425	-1.236
MAXIMUM Y	:	.652	.668	.589
MINIMUM Y	:	-.933	-.917	-.834
CENTROID X	:	.016	.240	.041
CENTROID Y	:	.363	.347	.264
POA TO CENTROID in.	:	.363	.422	.267
MIN RADIUS	:	.329	.121	.336
MEAN RADIUS	:	1.114	.996	.891
MAX RADIUS	:	2.022	1.730	1.308
HORIZONTAL SPREAD	:	3.837	3.021	2.457
VERTICAL SPREAD	:	1.585	1.585	1.373
EXTREME SPREAD	:	3.871	3.037	2.460
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	

16 Apr 1800 FILE:/PATTERNING/CENTERFIRE_PATT/C0611781

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 3

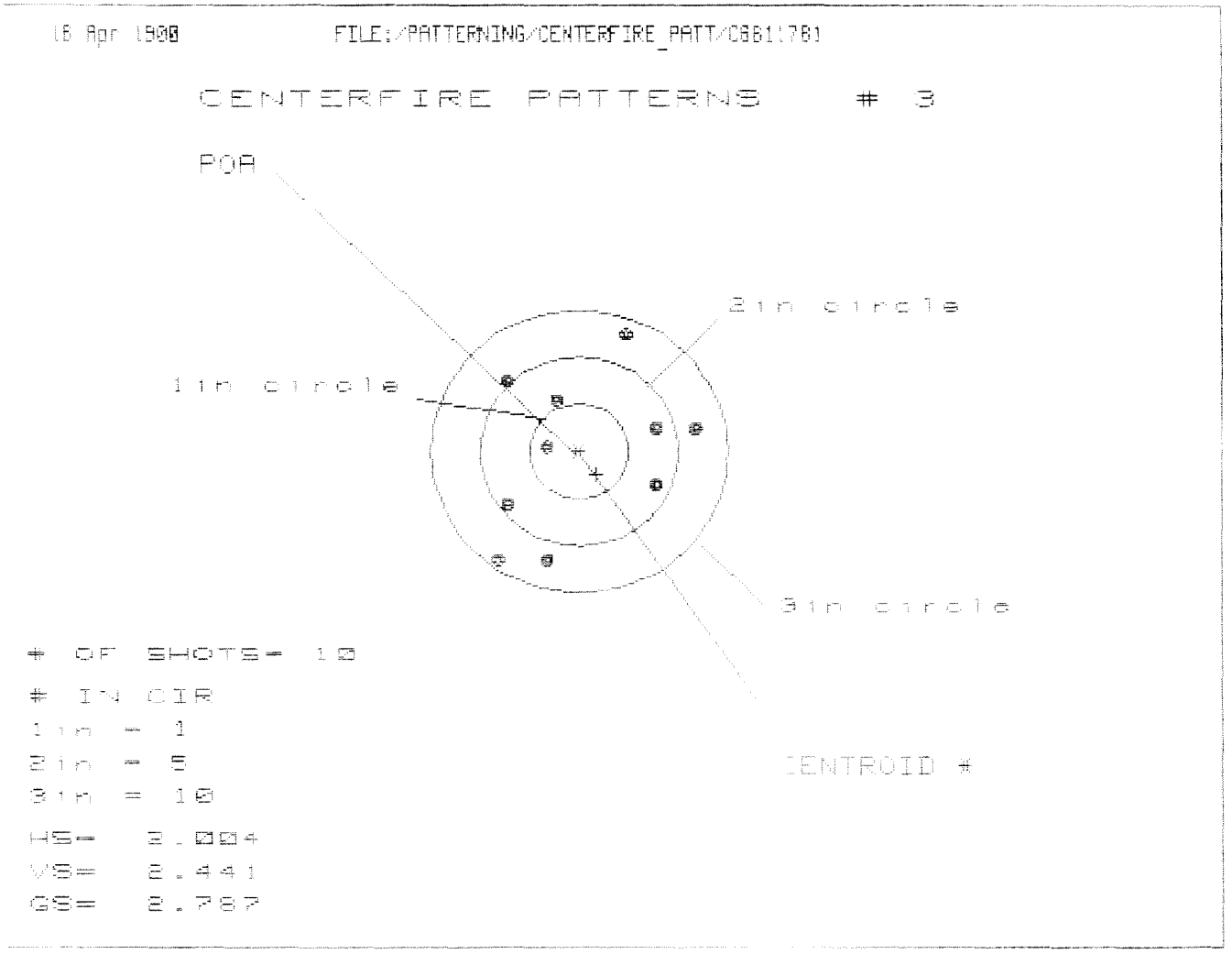
3 in = 7

HS= 2.697

VS= 3.473

GS= 3.541

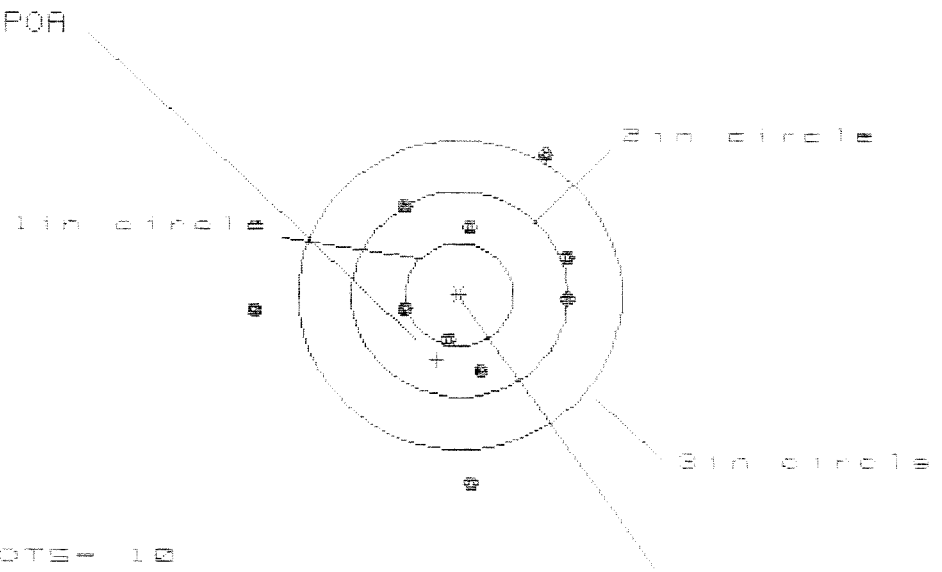
PATTERN #	2		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.197	1.197	1.283
MINIMUM X	-1.500	-1.500	-1.414
MAXIMUM Y	1.530	1.314	1.071
MINIMUM Y	-1.943	-1.317	-1.153
CENTROID X	.224	.224	.138
CENTROID Y	.144	.360	.196
POA TO CENTROID in.	.267	.424	.240
MIN RADIUS	.335	.120	.301
MEAN RADIUS	1.165	1.058	1.007
MAX RADIUS	1.943	1.501	1.426
HORIZONTAL SPREAD	2.697	2.697	2.697
VERTICAL SPREAD	3.473	2.631	2.224
EXTREME SPREAD	3.541	2.750	2.750
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		3	
NUMBER IN THREE INCH CIRCLE =		7	



PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.161	1.067	1.118
MINIMUM X	:	-.843	-.809	-.758
MAXIMUM Y	:	1.293	1.165	.739
MINIMUM Y	:	-1.148	-1.242	-1.096
CENTROID X	:	-.174	-.080	-.131
CENTROID Y	:	.253	.381	.235
POA TO CENTROID in.	:	.307	.389	.269
MIN RADIUS	:	.362	.461	.406
MEAN RADIUS	:	.969	.910	.863
MAX RADIUS	:	1.425	1.317	1.163
HORIZONTAL SPREAD	:	2.004	1.876	1.876
VERTICAL SPREAD	:	2.441	2.407	1.835
EXTREME SPREAD	:	2.787	2.552	2.014
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		10	

18 Apr 1900 FILE:/PATTERNING/CENTERFIRE_PATT/06811781

CENTERFIRE PATTERNS # 4



OF SHOTS= 10

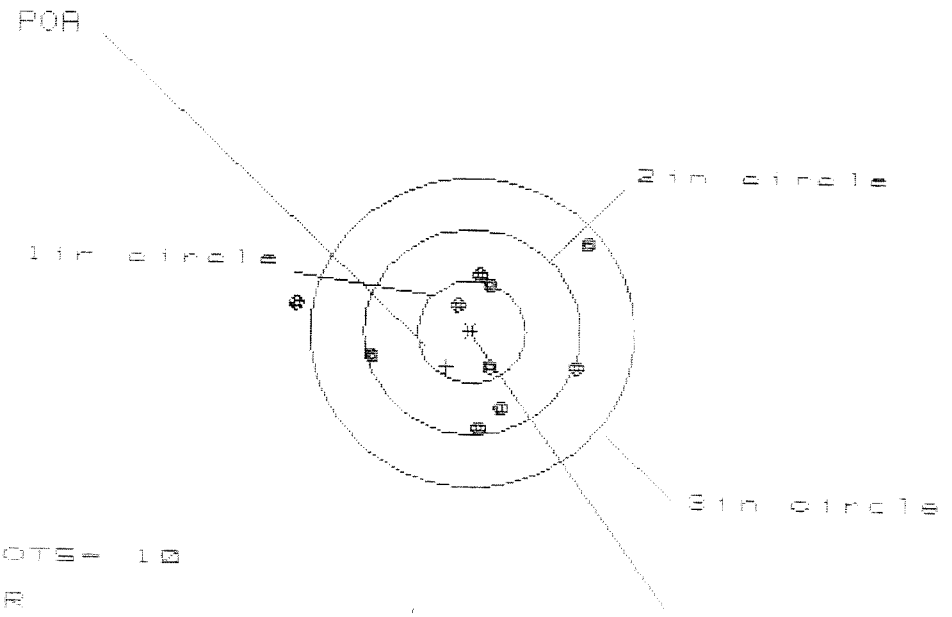
# IN CIR	
1in =	1
2in =	6
3in =	7

HS= 2.877
VS= 3.174
GS= 3.263

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.993	.784	.783
MINIMUM X	:	-1.884	-.755	-.776
MAXIMUM Y	:	1.366	1.351	1.123
MINIMUM Y	:	-1.808	-1.823	
CENTROID X	:	.205	.414	
CENTROID Y	:	.635	.65	
POA TO CENTROID in.	:	.668	.771	.900
MIN RADIUS	:	.402	.512	.463
MEAN RADIUS	:	1.070	.972	.851
MAX RADIUS	:	1.889	1.831	1.261
HORIZONTAL SPREAD	:	2.877	1.539	1.539
VERTICAL SPREAD	:	3.174	3.174	2.140
EXTREME SPREAD	:	3.263	3.263	2.237
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		7	

16 Apr 1900 FILE:/PATTERNING/CENTERFIRE_PATT/C6611761

CENTERFIRE PATTERNS # 5



OF SHOTS= 10

# IN CIR	
1in =	3
2in =	7
3in =	9
HS=	2.703
VS=	1.823
GS=	2.771

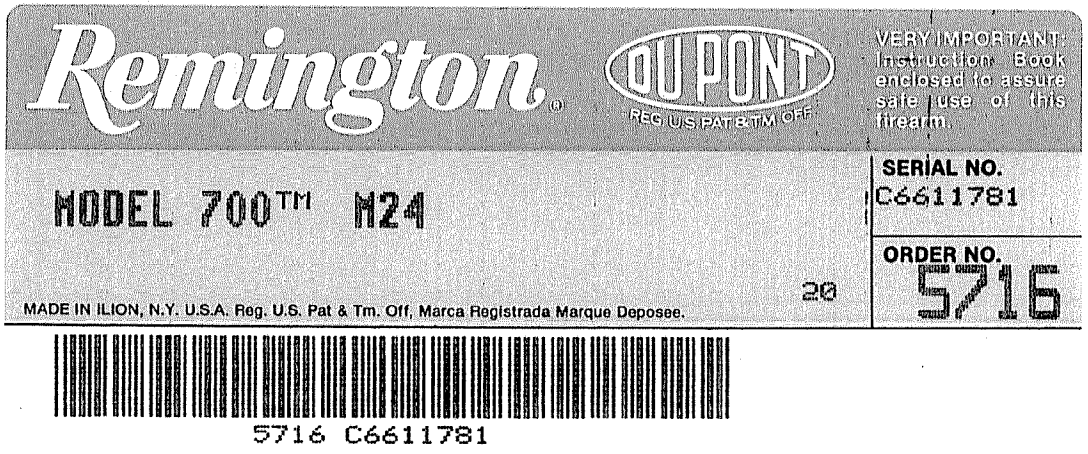
PATTERN # :	5		
SHOTS (BEST OF) :	10	9	8
MAXIMUM X :	1.030	.845	.995
MINIMUM X :	-1.672	-1.157	[illegible]
MAXIMUM Y :	.908	.941	[illegible]
MINIMUM Y :	-.915	-.882	[illegible]
CENTROID X :	.231	.415	[illegible]
CENTROID Y :	.336	.308	.165
POA TO CENTROID in.:	.407	.515	.362
MIN RADIUS :	.323	.274	.163
MEAN RADIUS :	.850	.742	.664
MAX RADIUS :	1.699	1.265	1.055
HORIZONTAL SPREAD :	2.703	2.002	1.957
VERTICAL SPREAD :	1.823	1.823	1.492
EXTREME SPREAD :	2.771	2.302	1.963
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		9	

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6611781

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	6	6			6/24/96	WB
	G) Safety Off Force	3	3	3			6/24/96	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	2.63	2.74	2.67	2.62	2.69	6/20/96	WB
	C) Function							
660	Pack							



CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6611781

CKM RC

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		1/22/91	KS
600	Proof		1/22/91	KS
607	Check Headspace		1/22/91	KS
610	Dis-assemble Gun		1/22/91	KS
612	Magnaflux Barrel Action		1/29/91	KR
	Magnaflux Bolt		"	KR
615	Rollmark Caliber		"	GS
617	Drill and Tap Sight Holes	2 2 91		CB
618	Polish Barrel RBB	2 2 91		WB
620	Apply Coatings (Barrel Action)		2-11-91	
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		2/18/91	KA
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		2/18/91	KA
	C) Inspect Ejector Hole for Chamfer		2/18/91	KA
	D) Oil Firing Pin Ass'y		2/18/91	KA
	E) Adjust Trigger Pull to Min Setting and Stake		2/20/91	

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4 1/4	4	4			2-21-91	DH
	G) Safety Off Force	3	2 1/2	2 1/2			2-21-91	DH
	H) Trigger Pull Test & Retainability						2/19/91	[illegible]
	I) Firing Pin Indent	.021	.0215	.0215			2-21-91	DH
	J) Assemble Stock						2/26/91	[illegible]
	K) Assemble Swivel Studs						3/2/91	WB
	L) Attach Front and Rear Sight Assemblies						2/26/91	[illegible]
	M) Iron Sight Alignment						2/26/91	[illegible]
	N) Detach Front & Rear Sights & place in numbered container						2/26/91	[illegible]
	O) Attach Scope to Rifle						2/26/91	[illegible]
	P) Detach & Attach Scope 20 Times						2/26/91	[illegible]
640	Gallery Target & Test						2/26/91	AC
	A) Time						"	AC
	B) Malfunctions	ROUGH CHAMBER - REMARKED					"	AC
	C) Pierced Primers						"	AC
	D) Optical Clearity of Scope						"	AC
645	Inspect for Live Ammo						2/26/91	AC
655	Final Inspection A) Headspace						3/8/91	WB
	B) Trigger Pull	2.25	2.27	2.44	2.39	2.39	3-2-91	[illegible]
	C) Function						3/2/91	WB
660	Pack						3-15-91	DH

SWS TRIGGER PULL TEST

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

SERIAL NO. C6611781

DATE 2/20/91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.39	2.37	2.30	2.25	MIN. SETTING,
PULL #2	2.51	2.32	2.27	2.27	NO AVG. OF 5
PULL #3	2.53	2.31	2.30	2.44	READINGS ACCEPT-
PULL #4	2.38	2.38	2.29	2.39	ABLE LESS THAN 2#
PULL #5	2.24	2.28	2.30	2.39	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.23	3.49		
PULL #2	3.28	3.39		
PULL #3	3.19	3.29		
PULL #4	3.50	3.14		
PULL #5	3.52	3.24		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.33	4.47		4.39
PULL #2	4.39	4.50		4.43
PULL #3	4.38	4.38		4.21
PULL #4	4.20	4.54		4.49
PULL #5	4.48	4.39		4.42
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611781
1 Mar 1991

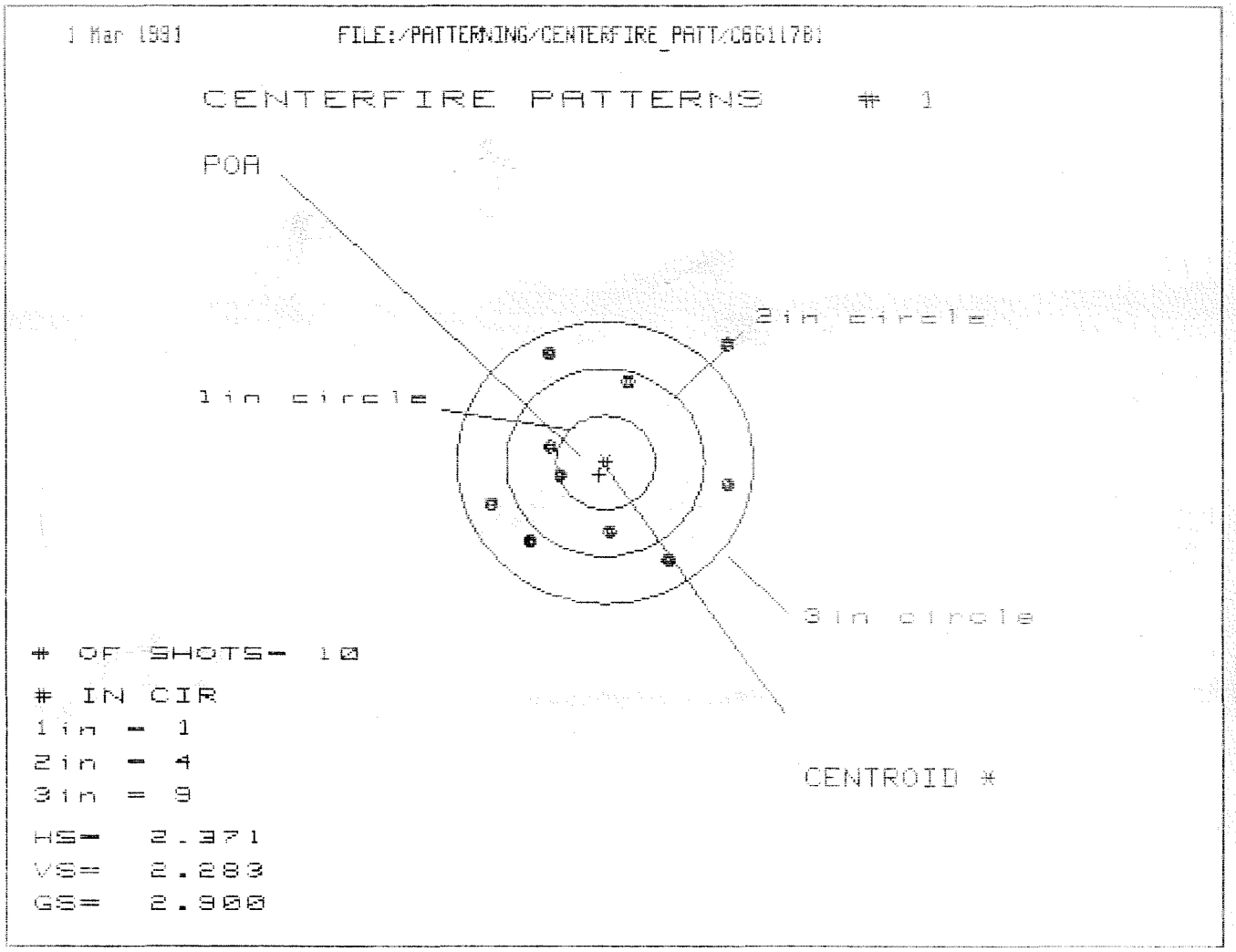
CENTROIDAL DISTANCES

Ø	TO	1	.146322
1	TO	2	.423001
1	TO	3	.50948
1	TO	4	.261354
1	TO	5	.313359

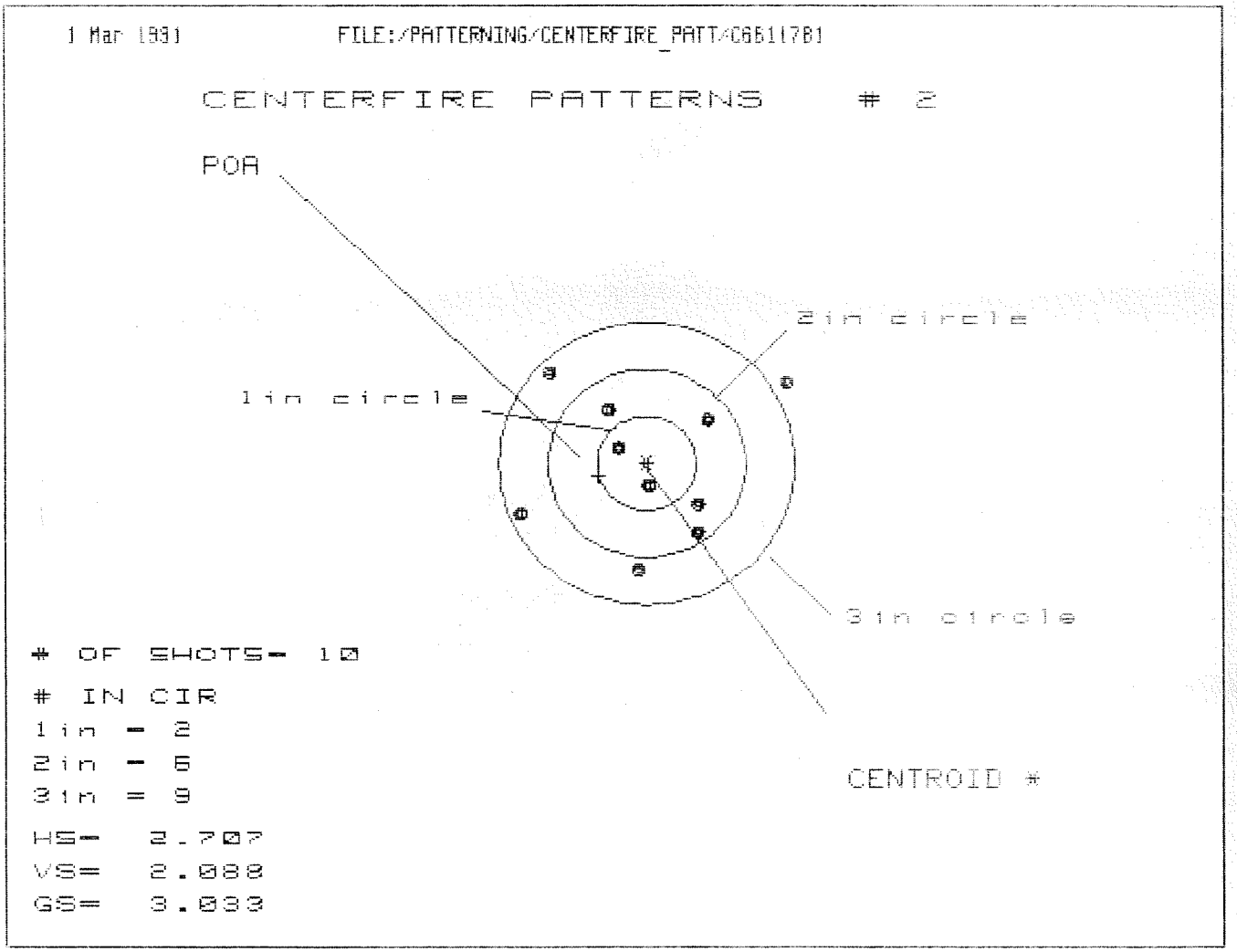
1/53 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .3286
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .031
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .330059

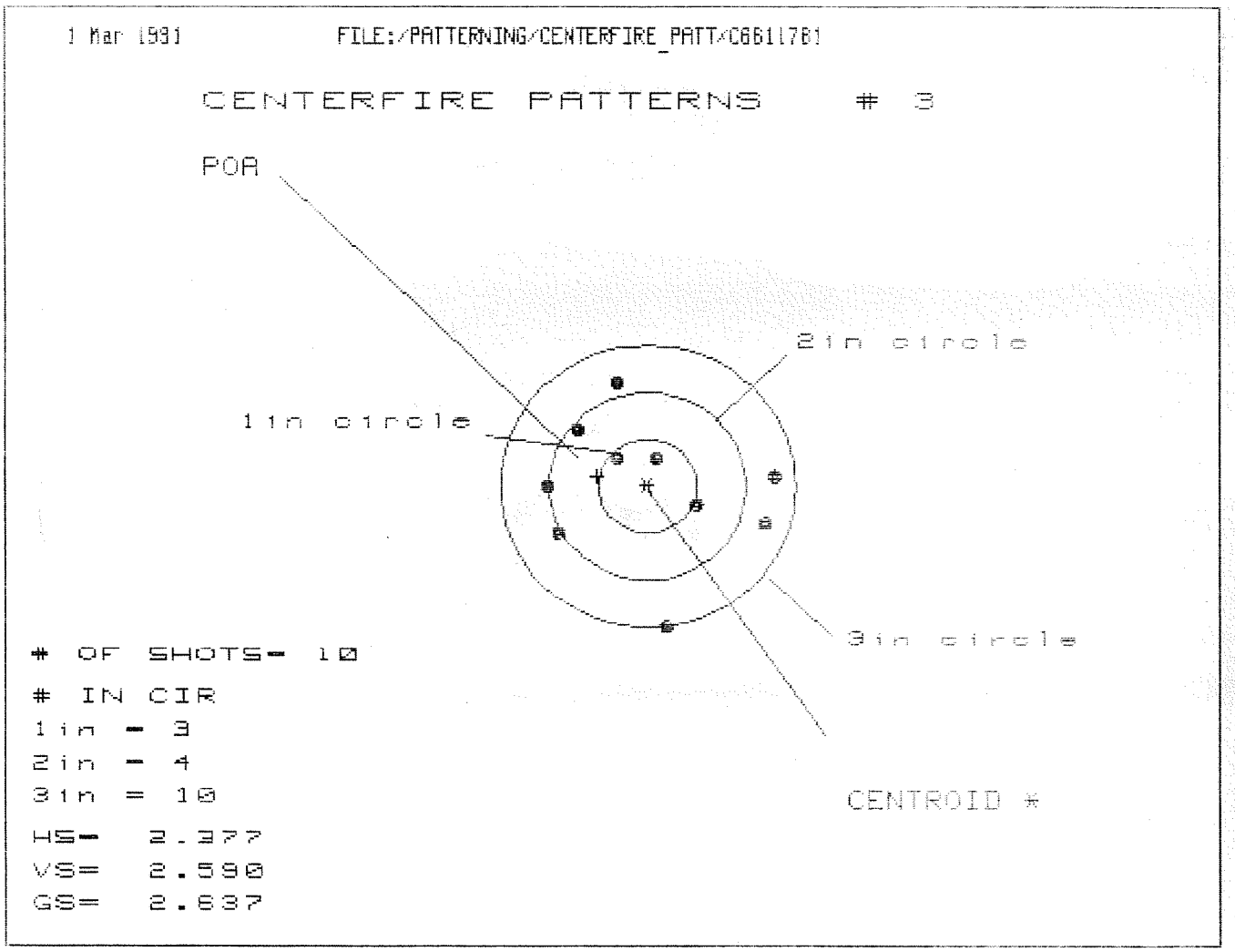
THE AMR FOR THIS RIFLE IS: .9658



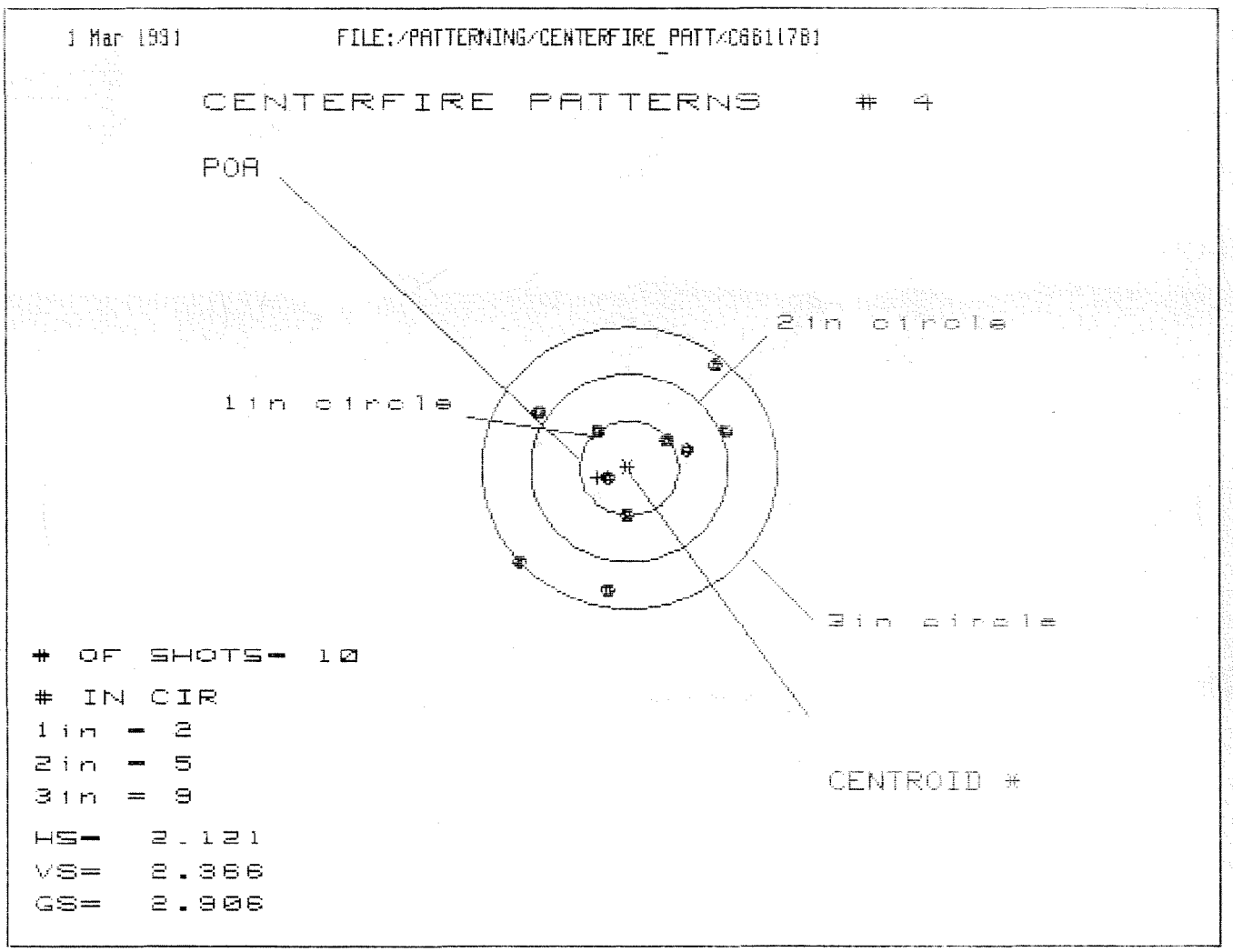
PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.242	1.355	1.307
MINIMUM X	:	-1.129	-.992	-1.040
MAXIMUM Y	:	1.221	1.320	1.150
MINIMUM Y	:	-1.062	-.926	-.761
CENTROID X	:	.061	-.076	-.028
CENTROID Y	:	.133	-.003	-.168
POA TO CENTROID in.	:	.147	.076	.170
MIN RADIUS	:	.482	.329	.415
MEAN RADIUS	:	1.052	.937	.872
MAX RADIUS	:	1.741	1.376	1.308
HORIZONTAL SPREAD	:	2.371	2.347	2.347
VERTICAL SPREAD	:	2.283	2.246	1.911
EXTREME SPREAD	:	2.900	2.526	2.355
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		9	



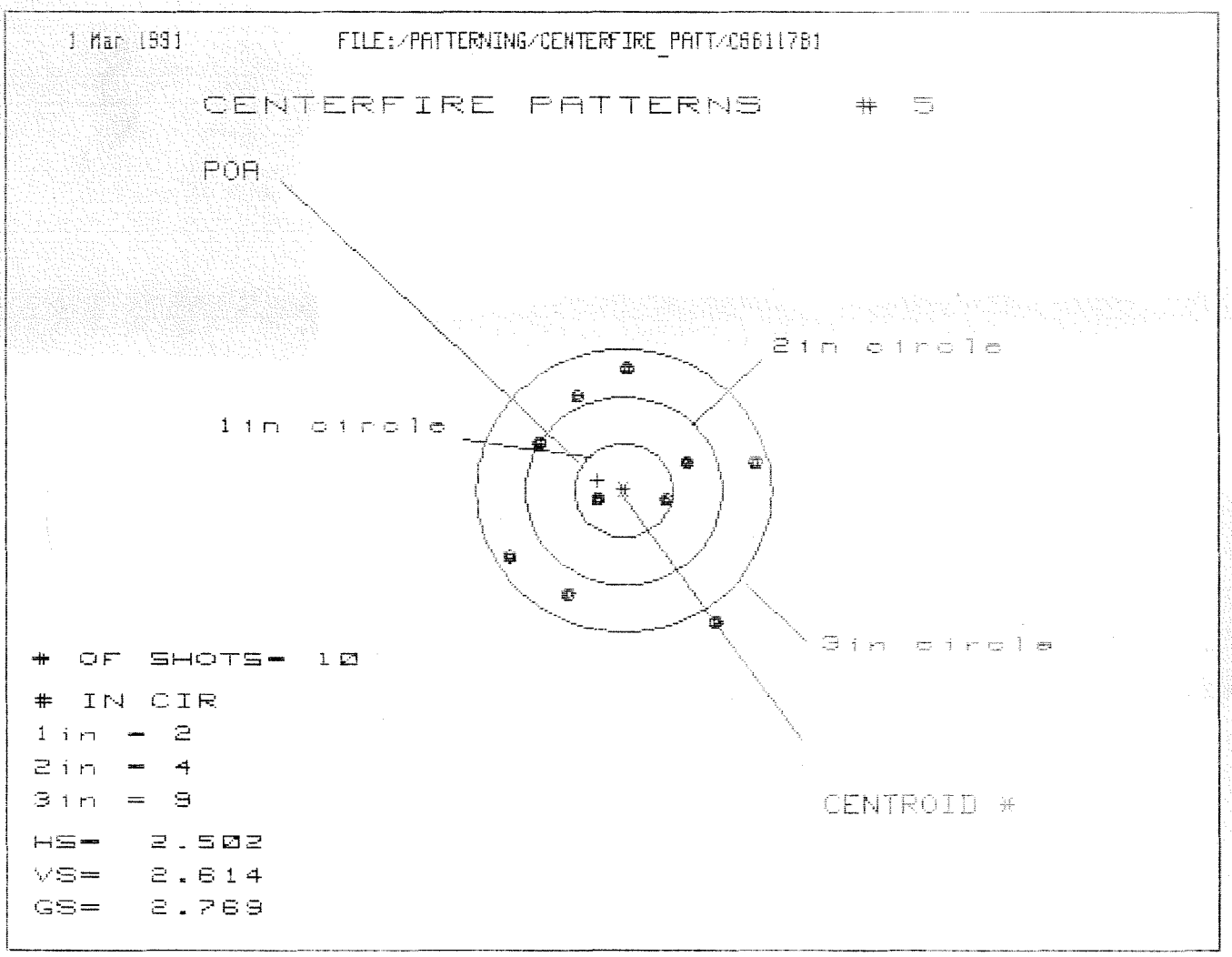
PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.408	.765	.656
MINIMUM X	:	-1.299	-1.142	-1.251
MAXIMUM Y	:	.974	1.069	.803
MINIMUM Y	:	-1.114	-1.019	-.885
CENTROID X	:	.484	.327	.436
CENTROID Y	:	.132	.037	-.097
POA TO CENTROID in.	:	.501	.329	.447
MIN RADIUS	:	.278	.234	.062
MEAN RADIUS	:	.915	.827	.729
MAX RADIUS	:	1.649	1.378	1.282
HORIZONTAL SPREAD	:	2.707	1.907	1.907
VERTICAL SPREAD	:	2.088	2.088	1.688
EXTREME SPREAD	:	3.033	2.306	2.133
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	



PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.331	1.356	1.423
MINIMUM X	:	-1.046	-1.021	-.851
MAXIMUM Y	:	1.137	.976	.973
MINIMUM Y	:	-1.453	-.645	-.648
CENTROID X	:	.512	.487	.317
CENTROID Y	:	-.104	.057	.060
POA TO CENTROID in.	:	.522	.490	.323
MIN RADIUS	:	.283	.135	.215
MEAN RADIUS	:	.956	.865	.782
MAX RADIUS	:	1.470	1.386	1.542
HORIZONTAL SPREAD	:	2.377	2.377	2.274
VERTICAL SPREAD	:	2.590	1.621	1.621
EXTREME SPREAD	:	2.637	2.381	2.316
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		10	



PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.987	.861	.953
MINIMUM X	:	-1.134	-1.051	-.959
MAXIMUM Y	:	1.076	.961	.573
MINIMUM Y	:	-1.290	-1.405	-1.285
CENTROID X	:	.320	.446	.354
CENTROID Y	:	.098	.212	.092
POA TO CENTROID in.	:	.335	.494	.366
MIN RADIUS	:	.219	.304	.250
MEAN RADIUS	:	.877	.789	.732
MAX RADIUS	:	1.535	1.442	1.306
HORIZONTAL SPREAD	:	2.121	1.912	1.912
VERTICAL SPREAD	:	2.366	2.366	1.858
EXTREME SPREAD	:	2.906	2.593	2.082
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	



PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.345	1.445	.912
MINIMUM X	:	-1.157	-1.057	-.877
MAXIMUM Y	:	1.268	1.118	1.134
MINIMUM Y	:	-1.346	-1.243	-1.227
CENTROID X	:	.266	.166	-.014
CENTROID Y	:	-.104	.046	.030
POA TO CENTROID in.	:	.285	.173	.034
MIN RADIUS	:	.295	.321	.259
MEAN RADIUS	:	1.029	.955	.884
MAX RADIUS	:	1.618	1.450	1.255
HORIZONTAL SPREAD	:	2.502	2.502	1.789
VERTICAL SPREAD	:	2.614	2.361	2.361
EXTREME SPREAD	:	2.769	2.677	2.419
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		9	