C6348875

MODEL 700™ M24

Model SWS ™

Action

Barrel Length

Capacity

Order No. 5716

*Includes 1 in chamber.

Remington

Armory Office 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: RE00089020

Verify Repair

Serial: C63488875 Model: M24 SWS Center Fire Caliber: 7.62 NATO

Repairman:

Status: Closed 12/6/2004 7:41:06 AM

Address Information

| Customer | Received From | Return To | Received From |
|---|---|---|---|
| Name: | TRANSPORTATION OFFICER | TRANSPORTATION OFFICER | |
| Address 1: | DEF DIST DEPOT ANNISTON AL | DEF DIST DEPOT ANNISTON AL | |
| Address 2: | PO Box: | PO Box: | |
| City: | ANNISTON | ANNISTON | |
| State: | AL Zip Code: 36201 Country: US | State: AL Zip Code: 36201 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 |
|---|---|---|
| A006 | Sling Strap | 1 |
| A007 | With Stud | 3 |
| A010 | Hard Case | 1 |
| A017 | Scope Base | 1 |
| A026 | Scope | 1 |
| A055 | Deployment Kit | 1 |
| C000 | FRT AND REAR SGT | 1 |
| C001 | SCOPE CASE | 1 |

Repair Search Refresh Close

naglelj 12/6/2004 8:51 AM CAPS NUM INS SCRL

start

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFOMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6348875.__0
FILE DATE AND TIME: 01/07/2005 11:45

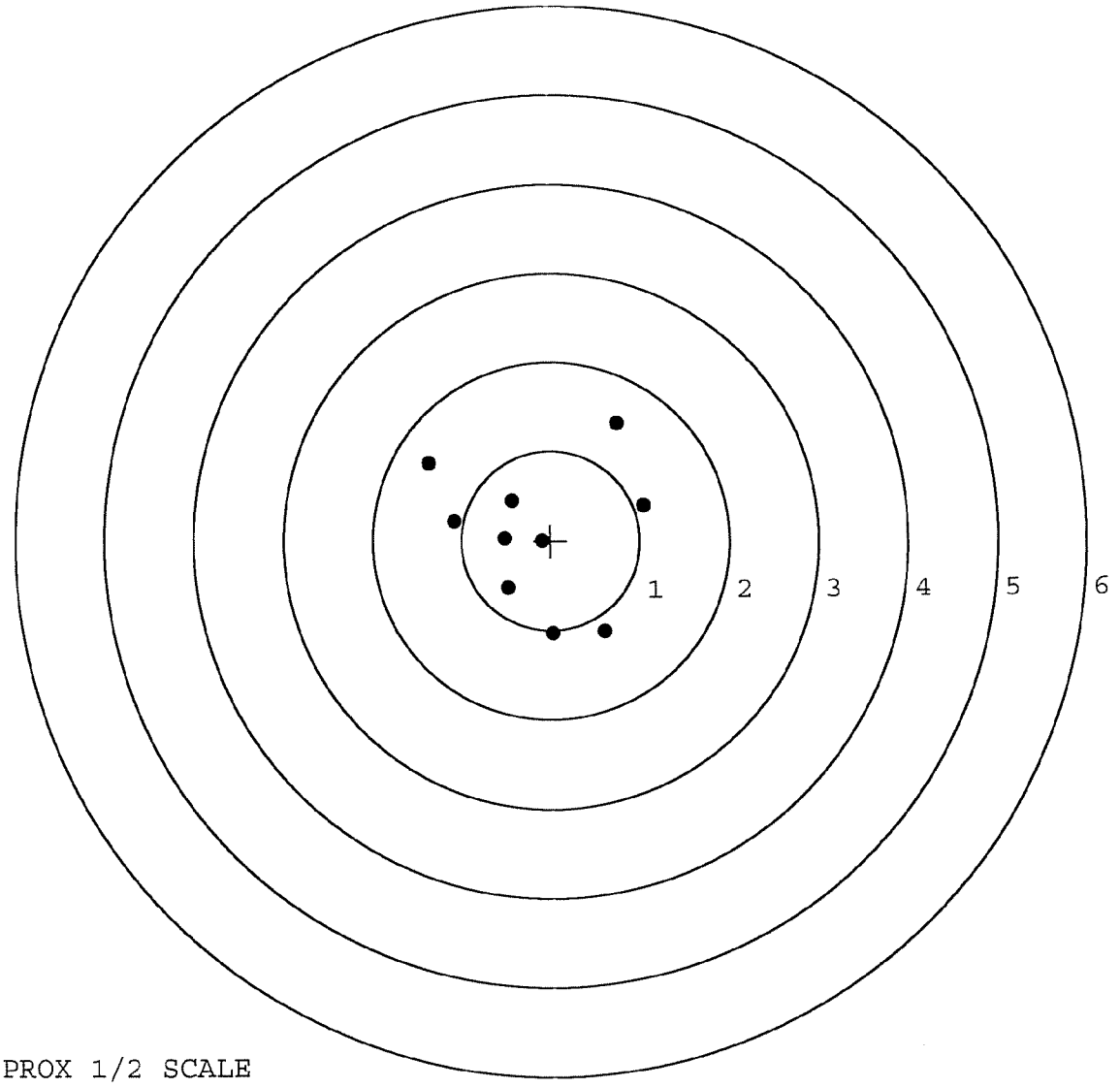
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

| | |
|---|---|
| The Average X Centroid of the Five Target Set: | 0.045 |
| The Average Y Centroid of the Five Target Set: | 0.087 |
| The Average Point of Impact of the Five Target Set: | 0.098 |
| The Average Mean Radius of the Five Target Set: | 0.743 |
| The Distance from POA to Centroid Target #1: | 0.170 |
| The Distance from Centroid Target #2 to Centroid Target #1: | 0.265 |
| The Distance from Centroid Target #3 to Centroid Target #1: | 0.447 |
| The Distance from Centroid Target #4 to Centroid Target #1: | 0.294 |
| The Distance from Centroid Target #5 to Centroid Target #1: | 0.066 |

SERIAL NUMBER: C6348875.__0
TARGET NUMBER: 1
FILE DATE: 01/07/2005
FILE TIME: 11:45

| | |
|---|---|
| X CENTROID: | -0.156 |
| Y CENTROID: | 0.068 |
| POA TO CENTROID: | 0.170 |
| HORZ SPREAD: | 2.408 |
| VERT SPREAD: | 2.347 |
| GROUP SPREAD: | 2.459 |
| MIN RADIUS: | 0.087 |
| MAX RADIUS: | 1.535 |
| MEAN RADIUS: | 0.923 |
| # IN 1 IN DIAMETER: | 3 |
| # IN 2 IN DIAMETER: | 5 |
| # in 3 IN DIAMETER: | 9 |

| POINT# | X | Y |
|---|---|---|
| 1: | 0.601 | -1.020 |
| 2: | 0.021 | -1.043 |
| 3: | 1.043 | 0.392 |
| 4: | 0.753 | 1.304 |
| 5: | -0.096 | 0.005 |
| 6: | -0.486 | -0.533 |
| 7: | -0.428 | 0.447 |
| 8: | -1.086 | 0.226 |
| 9: | -1.365 | 0.872 |
| 10: | -0.519 | 0.028 |

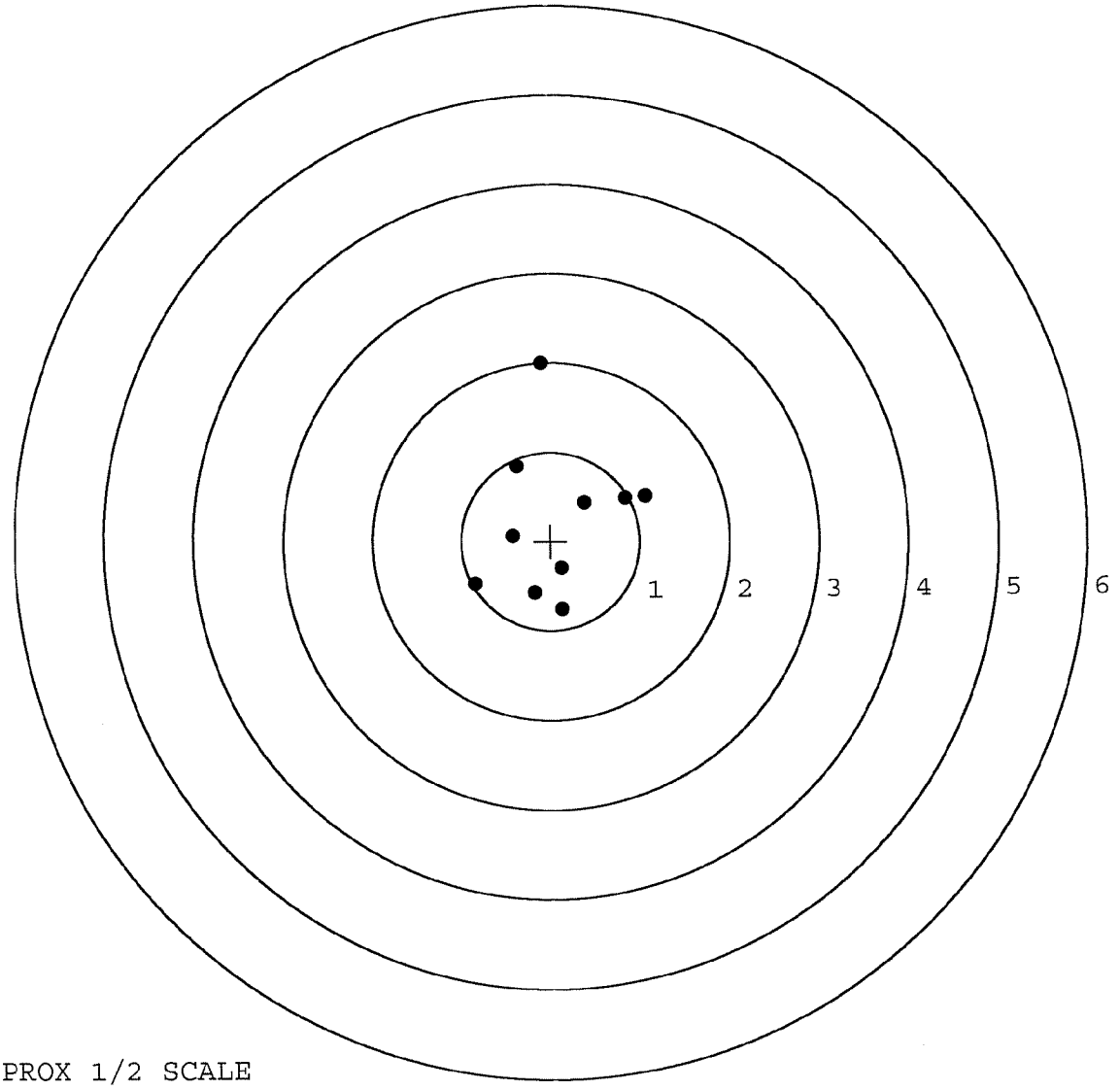



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6348875.__0
TARGET NUMBER: 2
FILE DATE: 01/07/2005
FILE TIME: 11:45

| | |
|---|---|
| X CENTROID: | 0.061 |
| Y CENTROID: | 0.219 |
| POA TO CENTROID: | 0.228 |
| HORZ SPREAD: | 1.909 |
| VERT SPREAD: | 2.766 |
| GROUP SPREAD: | 2.775 |
| MIN RADIUS: | 0.389 |
| MAX RADIUS: | 1.786 |
| MEAN RADIUS: | 0.881 |
| # IN 1 IN DIAMETER: | 1 |
| # IN 2 IN DIAMETER: | 7 |
| # in 3 IN DIAMETER: | 9 |

| POINT# | X | Y |
|---|---|---|
| 1: | 1.061 | 0.505 |
| 2: | 0.837 | 0.483 |
| 3: | 0.385 | 0.435 |
| 4: | -0.378 | 0.843 |
| 5: | -0.095 | 1.998 |
| 6: | -0.425 | 0.063 |
| 7: | -0.848 | -0.479 |
| 8: | 0.130 | -0.768 |
| 9: | -0.182 | -0.586 |
| 10: | 0.126 | -0.301 |

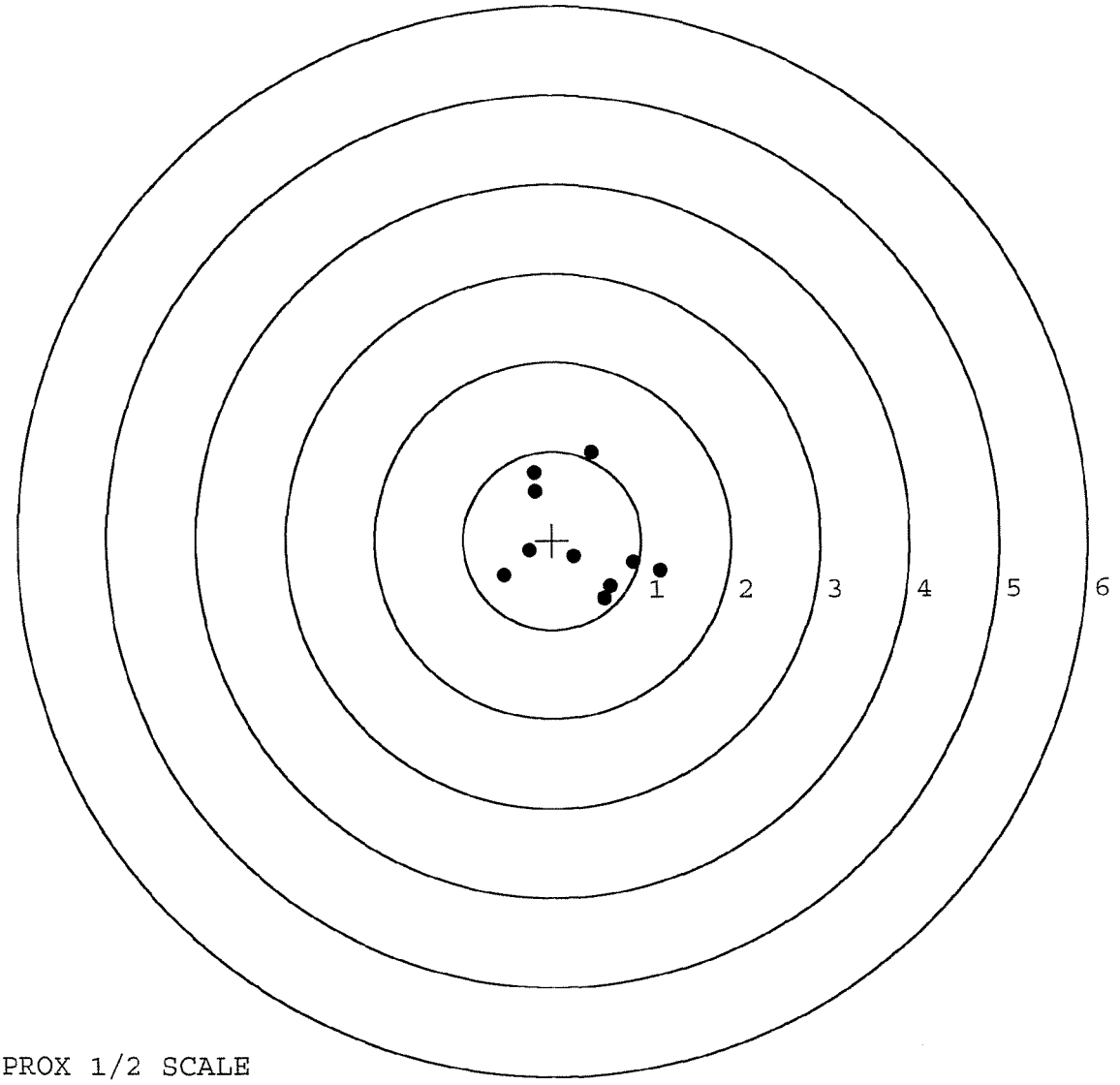



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6348875.__0
TARGET NUMBER: 3
FILE DATE: 01/07/2005
FILE TIME: 11:45

| | |
|---|---|
| X CENTROID: | 0.283 |
| Y CENTROID: | -0.014 |
| POA TO CENTROID: | 0.283 |
| HORZ SPREAD: | 1.752 |
| VERT SPREAD: | 1.641 |
| GROUP SPREAD: | 1.701 |
| MIN RADIUS: | 0.171 |
| MAX RADIUS: | 1.016 |
| MEAN RADIUS: | 0.729 |
| # IN 1 IN DIAMETER: | 1 |
| # IN 2 IN DIAMETER: | 9 |
| # in 3 IN DIAMETER: | 10 |

| POINT# | X | Y |
|---|---|---|
| 1: | 1.211 | -0.343 |
| 2: | 0.908 | -0.247 |
| 3: | 0.580 | -0.652 |
| 4: | 0.647 | -0.517 |
| 5: | 0.241 | -0.180 |
| 6: | -0.260 | -0.114 |
| 7: | -0.541 | -0.396 |
| 8: | -0.197 | 0.553 |
| 9: | -0.206 | 0.765 |
| 10: | 0.446 | 0.989 |

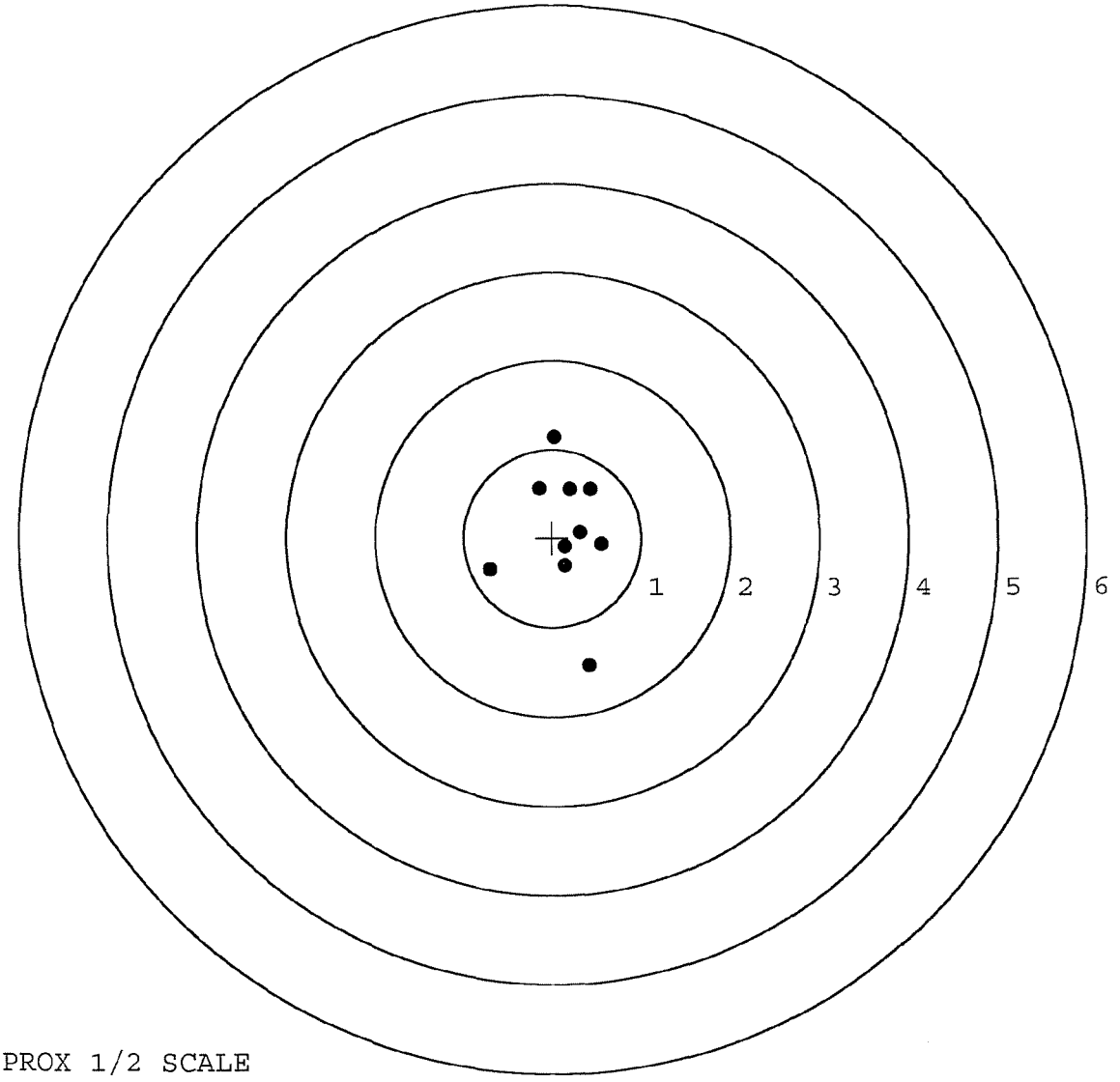



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6348875.__0
TARGET NUMBER: 4
FILE DATE: 01/07/2005
FILE TIME: 11:45

| | |
|---|---|
| X CENTROID: | 0.138 |
| Y CENTROID: | 0.059 |
| POA TO CENTROID: | 0.150 |
| HORZ SPREAD: | 1.259 |
| VERT SPREAD: | 2.561 |
| GROUP SPREAD: | 2.591 |
| MIN RADIUS: | 0.162 |
| MAX RADIUS: | 1.509 |
| MEAN RADIUS: | 0.633 |
| # IN 1 IN DIAMETER: | 5 |
| # IN 2 IN DIAMETER: | 8 |
| # in 3 IN DIAMETER: | 9 |

| POINT# | X | Y |
|---|---|---|
| 1: | 0.415 | -1.424 |
| 2: | -0.703 | -0.355 |
| 3: | 0.431 | 0.556 |
| 4: | 0.199 | 0.548 |
| 5: | -0.152 | 0.554 |
| 6: | 0.021 | 1.137 |
| 7: | 0.556 | -0.069 |
| 8: | 0.319 | 0.061 |
| 9: | 0.146 | -0.103 |
| 10: | 0.146 | -0.316 |

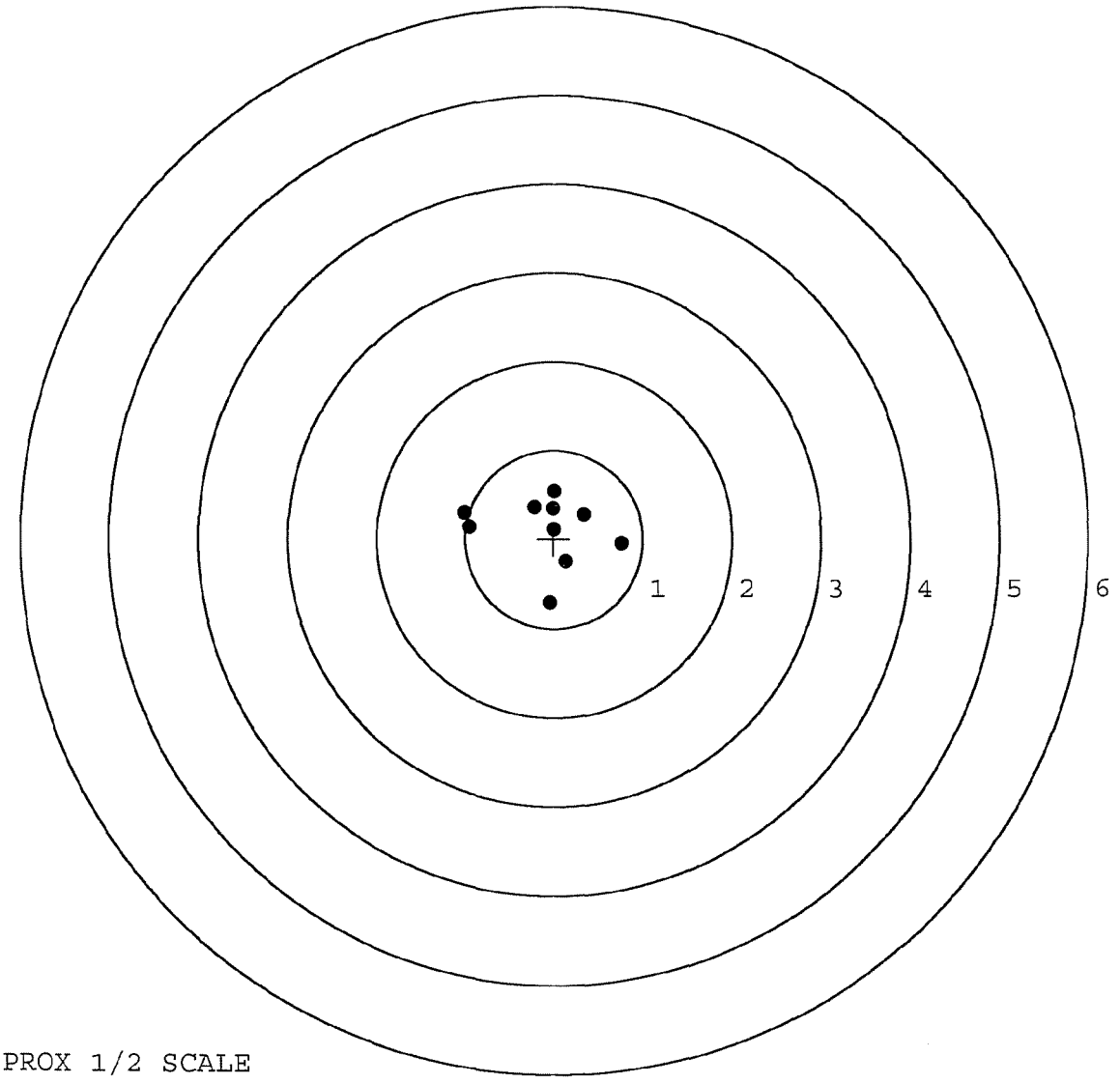



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6348875.__0
TARGET NUMBER: 5
FILE DATE: 01/07/2005
FILE TIME: 11:45

| | |
|---|---|
| X CENTROID: | -0.101 |
| Y CENTROID: | 0.104 |
| POA TO CENTROID: | 0.145 |
| HORZ SPREAD: | 1.773 |
| VERT SPREAD: | 1.259 |
| GROUP SPREAD: | 1.806 |
| MIN RADIUS: | 0.107 |
| MAX RADIUS: | 0.930 |
| MEAN RADIUS: | 0.548 |
| # IN 1 IN DIAMETER: | 6 |
| # IN 2 IN DIAMETER: | 10 |
| # in 3 IN DIAMETER: | 10 |

| POINT# | X | Y |
|---|---|---|
| 1: | 0.762 | -0.050 |
| 2: | 0.340 | 0.283 |
| 3: | -0.003 | 0.540 |
| 4: | -0.019 | 0.346 |
| 5: | 0.006 | 0.107 |
| 6: | 0.135 | -0.256 |
| 7: | -0.047 | -0.719 |
| 8: | -0.223 | 0.358 |
| 9: | -0.950 | 0.139 |
| 10: | -1.011 | 0.296 |




TARGET APPROX 1/2 SCALE

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

| | | | |
|---|---|---|---|
| R & E NUMBER | 89020 | | |
| SERIAL NUMBER | C6348875 | | |
| LOG-IN DATE | 12-6-04 | | |
| INSPECT AND VERIFY: | | | |
| OPERATION # | OPERATION NAME | DATE | INITIAL |
| 550 | DIS-ASSEMBLE GUN | 12-7-04 | RTL |
| 560 A | RE-BARREL | 12-15-04 | RTL |
| B | DRILL AND TAP | 12-27-04 | TKW |
| 575 | ASSEMBLE | 12-16-04 | RTL |
| 600 | PROOF | 12-16-04 | RTL |
| 605 | CHECK HEADSPACE | 12-16-04 | RTL |
| 610 | DIS-ASSEMBLE GUN | 12-27-04 | RTL |
| 612 | MAGNAFLUX | OPERATOR | |
| 615 | ROLLMARK CALIBER | 12-27-04 | CW |
| 618 | ROTO-BLAST | 12/28/04 | DG |
| 620 | APPLY COATINGS | 1/3/05 | HP |
| 625 A | FINAL ASSEMBLY | 1-05-05 | RTL |
| B | TRIGGER PULL TEST | N/A | |
| C | SAFETY "ON" FORCE | | |
| D | SAFETY "OFF" FORCE | | |
| E | FIRING PIN INDENT | | |
| 640 | TARGET | 1-7-05 | |
| 655 | FINAL INSPECT | 1-11-05 | |
| 660 | PACK | 3-1-05 | |
| | | SHIP DATE | |
| | QAR INSPECTION DATE | | |

IMASM-FLDA INSPECTED DEC 27 2004

# RECEIVING AND ESTIMATING REPORT

COMMENTS: W/1~~0X~~ SCOPE SNIPER W/DEPLOYMENT KIT
ATTN: FRED MARTIN Scope # 89-0250

ORDER: R 95-10960

| INITIAL | CUSTOMER ORDER NO. |
|---|---|
| FJB | |

| DATE RECEIVED | DATE OPENED | DATE CODE | SERIAL NUMBER | NEW SERIAL NUMBER | MODEL AND GRADE |
|---|---|---|---|---|---|
| 03/30/95 | 03/31/95 | DJ 9-89 | C6348875 | | 700 7.62 NATO |

ACCESSORIES: SLING STRAP SCOPE MNTS SCOPE BASE HARD CASE

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 |
|---|---|---|---|---|---|
| | | ☐ | | 7-9-96 | 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

NEW STOCK
TRIGGER ASSY
FIRING PIN ASSY
FRONT LENS COVER
REAR LENS COVER

COMMENTS

| REPAIRMAN | PROOF | CLEAN | TEST | TARGET | PATTERN |
|---|---|---|---|---|---|
| TCEP | | | A | A | |
| **GALLERY TESTER** | **DATE** | **DATE** | **DATE** | **DATE** | **DATE** |
| | | | 7/10/96 | 7/10/96 | |

OFFICE COPY

RD6925 REV. 1/94

| op. # | OP. NAME | READINGS | | | | | DATE | INIT |
|---|---|---|---|---|---|---|---|---|
| 625 cont. | F) Safety On Force | 8 | 9 | 8 | | | 7-9 | REP |
| | G) Safety Off Force | 4 | 4.5 | 5 | | | 7-9 | REP |
| | H) Trigger Pull Test & Retainability | | | | | | | |
| | I) Firing Pin Indent | .022 | .024 | .0245 | | | 7-9 | REP |
| | J) Assemble Stock | | | | | | 7-9 | REP |
| | 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 | | | | | | 7-9 | REP |
| | 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 | 2.91 | 2.89 | 2.82 | 2.79 | 2.80 | 7/14 | 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<br>A) Clean inside of Bolt Assembly | | 7-9 | REP |
| | B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head | | 7-9 | REP |
| | C) Inspect Ejector Hole for Chamfer | | 7-9 | REP |
| | D) Oil Firing Pin Ass'y | | 7-9 | REP |
| | E) Adjust Trigger Pull to Min Setting and Stake | | | |

# SWS TRIGGER PULL TEST

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

SERIAL NO. C6348875

DATE 6-22-96

TESTER DA

| | 2.50# INITIAL | 2.50# AFTER 50 CYCLES | FINAL TEST & TO RESET 2.50# | | COMMENTS |
|---|---|---|---|---|---|
| PULL #1 | 2.34 | 2.41 | 2.36 | | MIN. SETTING, |
| PULL #2 | 2.21 | 2.26 | 2.44 | | NO AVG. OF 5 |
| PULL #3 | 2.35 | 2.57 | 2.66 | | READINGS ACCEPT- |
| PULL #4 | 2.30 | 2.45 | 2.45 | | ABLE LESS THAN 2# |
| PULL #5 | 2.29 | 2.31 | 2.54 | | |
| TOTAL | 11.49 | 11.94 | 12.45 | | |
| AVG. | 2.29 | 2.38 | 2.49 | | |

| | 3.00# INITIAL | 3.00# AFTER 20 CYCLES | | COMMENTS |
|---|---|---|---|---|
| PULL #1 | 3.18 | 3.05 | | |
| PULL #2 | 3.08 | 3.07 | | |
| PULL #3 | 3.08 | 2.93 | | |
| PULL #4 | 3.00 | 3.13 | | |
| PULL #5 | 2.93 | 3.07 | | |
| TOTAL | 15.27 | 15.27 | | |
| AVG. | 3.05 | 3.05 | | |

| | 4.00# INITIAL | 4.00# AFTER 20 CYCLES | MAX SETTING GREATER THAN 4# | RESET TO 4# FOR TARGET & ACCURACY |
|---|---|---|---|---|
| PULL #1 | 4.20 | 4.05 | | 4.11 |
| PULL #2 | 4.21 | 4.00 | | 4.07 |
| PULL #3 | 4.05 | 4.05 | | 4.07 |
| PULL #4 | 4.11 | 4.19 | | 4.30 |
| PULL #5 | 4.11 | 4.00 | | 4.24 |
| TOTAL | 20.68 | 20.29 | | 20.79 |
| AVG. | 4.13 | 4.05 | | 4.15 |

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6348875
2 Jan 1900

CENTROIDAL DISTANCES

| | | | |
|---|---|---|---|
| 0 | TO | 1 | .116108 |
| 1 | TO | 2 | .239102 |
| 1 | TO | 3 | .189452 |
| 1 | TO | 4 | .187 |
| 1 | TO | 5 | .213[illegible]1 |

<-----POA

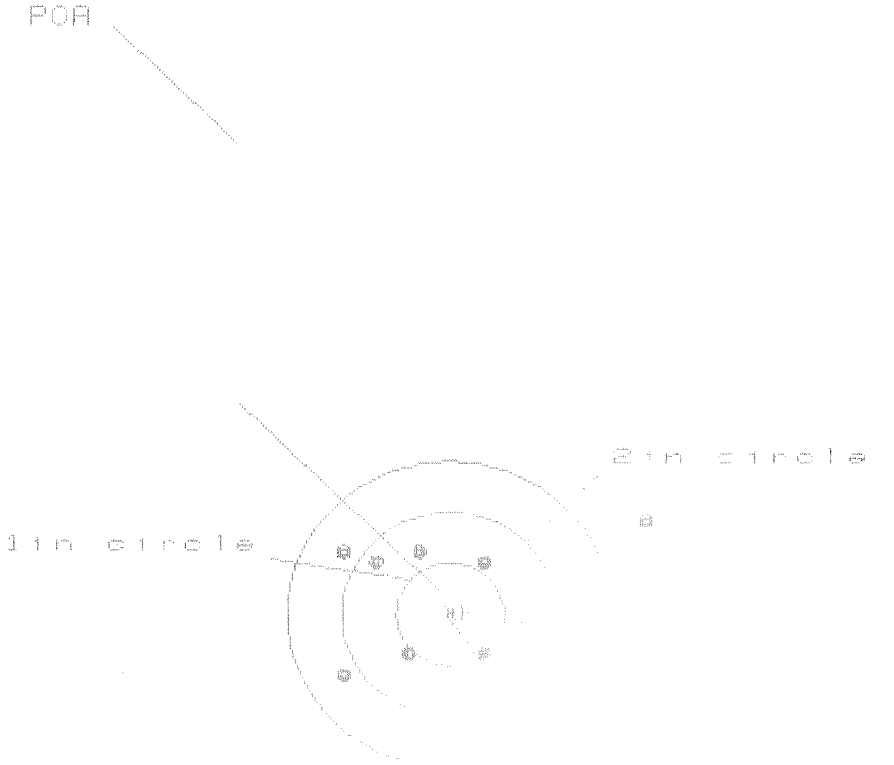
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0[illegible]

THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0516
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .051614

THE AMR FOR THIS RIFLE IS: .8358

1 Jan 1900 FILE:/PATTERNING/CENTERFIRE_PATT/C6340875

# CENTERFIRE PATTERNS # 1

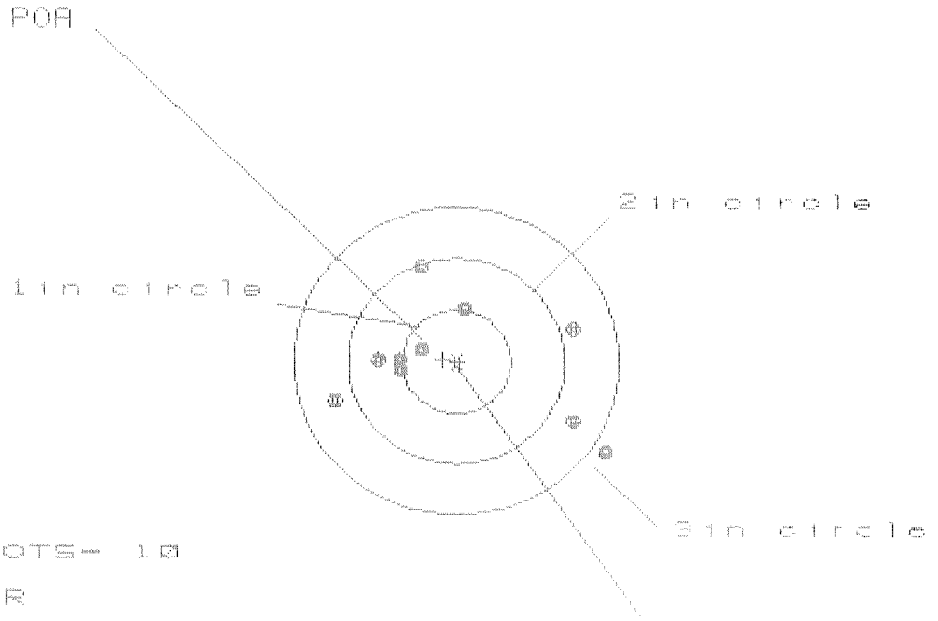



# OF SHOTS= 10
# IN CIR
1in = 0
2in = 6
3in = 8
HS= 2.765
VS= 2.687
GS= 3.166

| | | | | |
|---|---|---|---|---|
| PATTERN # | : | 1 | | |
| SHOTS (BEST OF) | : | 10 | 9 | 8 |
| MAXIMUM X | : | 1.786 | .922 | .961 |
| MINIMUM X | : | -.979 | -.780 | -.742 |
| MAXIMUM Y | : | .927 | .723 | .516 |
| MINIMUM Y | : | -1.760 | -1.657 | -.651 |
| CENTROID X | : | -.115 | -.314 | -.353 |
| CENTROID Y | : | -.016 | -.119 | .086 |
| POA TO CENTROID in. | : | .116 | .336 | .363 |
| MIN RADIUS | : | .554 | .349 | .517 |
| MEAN RADIUS | : | 1.007 | .879 | .755 |
| MAX RADIUS | : | 2.013 | 1.686 | .983 |
| HORIZONTAL SPREAD | : | 2.765 | 1.702 | 1.702 |
| VERTICAL SPREAD | : | 2.687 | 2.300 | 1.167 |
| EXTREME SPREAD | : | 3.166 | 2.617 | 1.775 |
| NUMBER IN ONE INCH CIRCLE | = | 0 | | |
| NUMBER IN TWO INCH CIRCLE | = | 6 | | |
| NUMBER IN THREE INCH CIRCLE | = | 8 | | |

1 Jan 1900 FILE:/PATTERNING/CENTERFIRE PATT/C6348675

# CENTERFIRE PATTERNS # 2




# OF SHOTS= 10

# IN CIR

1in = 3

2in = 5

3in = 9

HS= 2.523

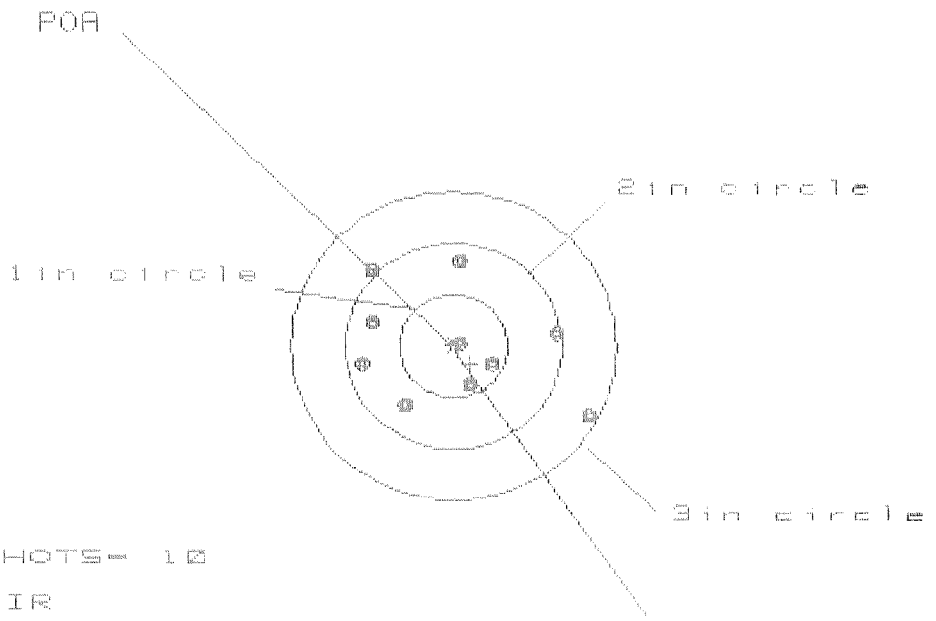
VS= 1.760

GS= 2.559

| | | | | |
|---|---|---|---|---|
| PATTERN # | : | 2 | | |
| SHOTS (BEST OF) | : | 10 | 9 | |
| MAXIMUM X | : | 1.350 | 1.271 | 1.404 |
| MINIMUM X | : | -1.173 | -1.023 | -.864 |
| MAXIMUM Y | : | .920 | .826 | .738 |
| MINIMUM Y | : | -.840 | -.708 | -.592 |
| CENTROID X | : | .124 | -.026 | -.184 |
| CENTROID Y | : | -.023 | .071 | .159 |
| POA TO CENTROID in. | : | .126 | .075 | .244 |
| MIN RADIUS | : | .371 | .197 | .041 |
| MEAN RADIUS | : | .886 | .745 | .591 |
| MAX RADIUS | : | 1.590 | 1.454 | 1.409 |
| HORIZONTAL SPREAD | : | 2.523 | 2.294 | 2.269 |
| VERTICAL SPREAD | : | 1.760 | 1.534 | 1.330 |
| EXTREME SPREAD | : | 2.559 | 2.375 | 2.375 |
| NUMBER IN ONE INCH CIRCLE | = | | 2 | |
| NUMBER IN TWO INCH CIRCLE | = | | 6 | |
| NUMBER IN THREE INCH CIRCLE | = | | 9 | |

1 Jan 1900 FILE:/PATTERNING/CENTERFIRE_PATT/C634B875

# CENTERFIRE PATTERNS # 3




# OF SHOTS= 10

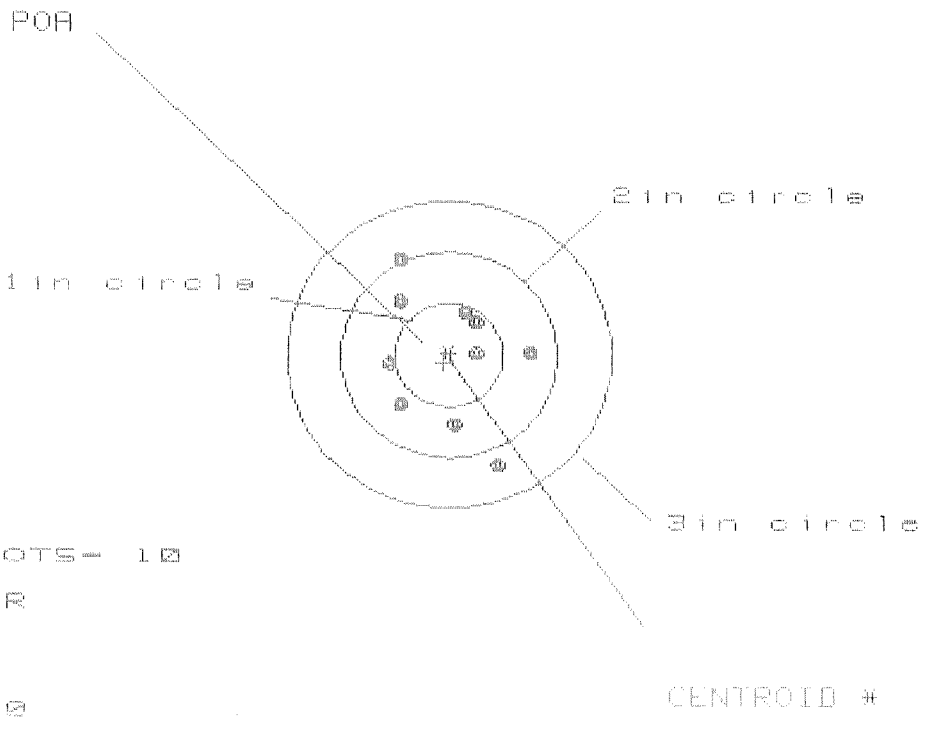
# IN CIR
1in = 3
2in = 8
3in = 10

HS= 2.179
VS= 1.505
GS= 2.473

| | | | | |
|---|---|---|---|---|
| PATTERN # | : | [illegible] | | |
| SHOTS (BEST OF) | : | 10 | 9 | 8 |
| MAXIMUM X | : | 1.286 | 1.068 | .992 |
| MINIMUM X | : | -.893 | -.750 | -.826 |
| MAXIMUM Y | : | .850 | .777 | .861 |
| MINIMUM Y | : | -.655 | -.663 | -.579 |
| CENTROID X | : | -.151 | -.294 | -.218 |
| CENTROID Y | : | .170 | .243 | .159 |
| POA TO CENTROID in. | : | .228 | .381 | .270 |
| MIN RADIUS | : | .099 | .254 | .166 |
| MEAN RADIUS | : | .755 | .688 | .637 |
| MAX RADIUS | : | 1.443 | 1.068 | .997 |
| HORIZONTAL SPREAD | : | 2.179 | 1.818 | 1.818 |
| VERTICAL SPREAD | : | 1.505 | 1.440 | 1.440 |
| EXTREME SPREAD | : | 2.473 | 1.833 | 1.833 |
| NUMBER IN ONE INCH CIRCLE | = | | 3 | |
| NUMBER IN TWO INCH CIRCLE | = | | 8 | |
| NUMBER IN THREE INCH CIRCLE | = | | 10 | |

1 Jan 1900 FILE:/PATTERNING/CENTERFIRE_PATT/C6346875

# CENTERFIRE PATTERNS # 4




# OF SHOTS= 10

# IN CIR
1in = 3
2in = 9
3in = 10

HS= 1.283
VS= 1.969
CS= 2.152

| | | | | |
|---|---|---|---|---|
| PATTERN # | : | 4 | | |
| SHOTS (BEST OF) | : | 10 | 9 | 8 |
| MAXIMUM X | : | .703 | .754 | .709 |
| MINIMUM X | : | -.580 | -.529 | -.574 |
| MAXIMUM Y | : | .888 | .768 | .511 |
| MINIMUM Y | : | -1.081 | -.802 | -.706 |
| CENTROID X | : | .050 | -.001 | .044 |
| CENTROID Y | : | .072 | .192 | .096 |
| POA TO CENTROID in. | : | .088 | .192 | .106 |
| MIN RADIUS | : | .265 | .340 | .273 |
| MEAN RADIUS | : | .661 | .593 | .556 |
| MAX RADIUS | : | 1.174 | .848 | .710 |
| HORIZONTAL SPREAD | : | 1.283 | 1.283 | 1.283 |
| VERTICAL SPREAD | : | 1.969 | 1.570 | 1.217 |
| EXTREME SPREAD | : | 2.152 | 1.640 | 1.330 |
| NUMBER IN ONE INCH CIRCLE | = | | 3 | |
| NUMBER IN TWO INCH CIRCLE | = | | 9 | |
| NUMBER IN THREE INCH CIRCLE | = | | 10 | |

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6348875

| OP. # | OP. NAME | READINGS | DATE | INIT |
|---|---|---|---|---|
| 575 & 580 | Assemble Action and Stock | 9 14 | 89 | RW |
| 600 | Proof | 9 14 | 89 | RW |
| 607 | Check Headspace | | | RW |
| 610 | Dis-assemble Gun | | | RW |
| 612 | Magnaflux Barrel Action | 9-14-89 | | KCR |
| | Magnaflux Bolt | 9-14-89 | | KCR |
| 615 | Rollmark Caliber | | 9-15-89 | GS |
| 7 | Drill and Tap Sight Holes | 9 15 | 89 | |
| 618 | Polish Barrel | 9 15 | 89 | |
| 620 | Apply Coatings (Barrel Action) | | 9/25/89 | TJF |
| | Apply Coating (Bolt) | | | TJF |
| 625 | Final Assembly A) Clean inside of Bolt Assembly | | 9/26/89 | RW |
| | B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head | | 9/26/89 | RW |
| | C) Inspect Ejector Hole for Chamfer | | 9/26/89 | RW |
| | D) Oil Firing Pin Ass'y | | 9/26/89 | RW |
| | E) Adjust Trigger Pull to Min Setting and Stake | | 9/26/89 | GS |

| op. # | OP. NAME | READINGS | | | | | DATE | INIT |
|---|---|---|---|---|---|---|---|---|
| 625 cont. | F) Safety On Force | 6 | 6 | 6 | | | 10/4/89 | JH |
| | G) Safety Off Force | 4 | 4 | 4 | | | 10/4/89 | JH |
| | H) Trigger Pull Test & Retainability | | | | | | 20Oct89 | GD |
| | I) Firing Pin Indent | .0205 | .0205 | .0205 | | | 10/4/89 | JH |
| | J) Assemble Stock | | | | | | 10/5/89 | RW |
| | K) Assemble Swivel Studs | | | | | | | |
| | L) Attach Front and Rear Sight Assemblies | | | | | | 10/5/89 | RW |
| | M) Iron Sight Alignment | | | | | | 10/5/89 | RW |
| | N) Detach Front & Rear Sights & place in numbered container | | | | | | 10/5/89 | RW |
| | O) Attach Scope to Rifle | | | | | | 10/5/89 | JH |
| | P) Detach & Attach Scope 20 Times | | | | | | 10/5/89 | JH |
| 640 | Gallery Target & Test | | | | | | 10-5-89 | AC |
| | A) Time | | | | | | 10-5-89 | AC |
| | B) Malfunctions | | | | | | 10-5-89 | AC |
| | C) Pierced Primers | | | | | | 10-5-89 | AC |
| | D) Optical Clearity of Scope | | | | | | 10-5-89 | AC |
| 645 | Inspect for Live Ammo | | | | | | 10-5-89 | AC |
| 655 | Final Inspection A) Headspace | | | | | | 6Dec89 | RB |
| | B) Trigger Pull | 242 | 253 | 237 | 248 | 254 | 6Dec89 | RB |
| | C) Function | | | | | | 6Dec89 | RB |
| 660 | Pack | | | | | | 15Dec89 | GD |

# SWS TRIGGER PULL TEST

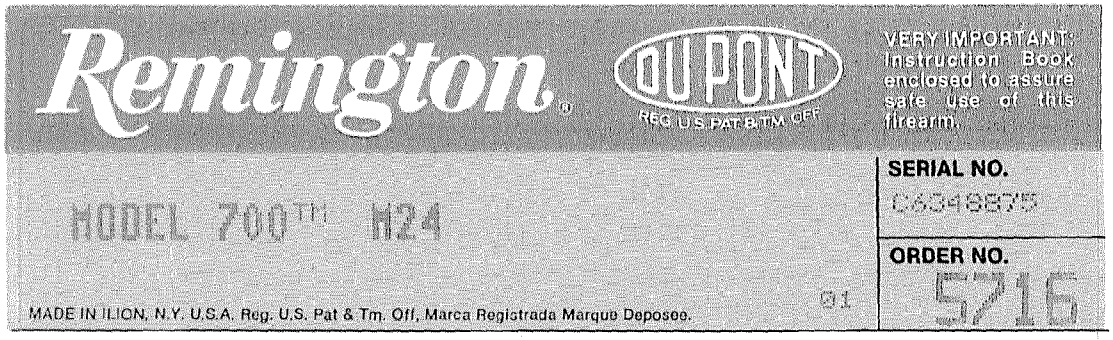
AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS
2.50# ± .50#
3.00# ± .75#
4.00# ± 1.00#

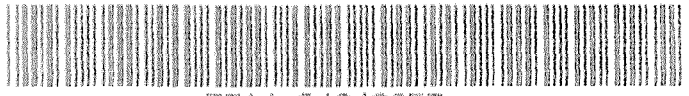
SERIAL NO. C6348875
DATE 3-13-90
TESTER JL

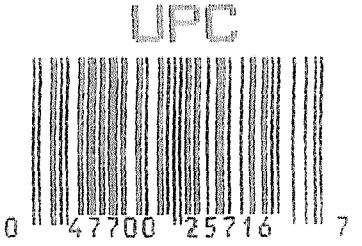
| | 2.50# INITIAL | 2.50# AFTER 50 CYCLES | FINAL TEST & TO RESET 2.50# | | COMMENTS |
|---|---|---|---|---|---|
| PULL #1 | 2.42 | 2.41 | 2.38 | | MIN. SETTING, |
| PULL #2 | 2.34 | 2.33 | 2.44 | | NO AVG. OF 5 |
| PULL #3 | 2.51 | 2.47 | 2.44 | | READINGS ACCEPT- |
| PULL #4 | 2.45 | 2.40 | 2.39 | | ABLE LESS THAN 2# |
| PULL #5 | 2.38 | 2.31 | 2.56 | | |
| TOTAL | 12.10 | 11.92 | 12.11 | | |
| AVG. | 2.42 | 2.384 | 2.422 | | |

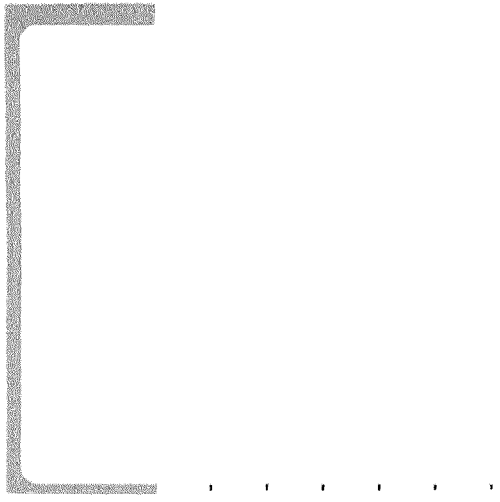
| | 3.00# INITIAL | 3.00# AFTER 20 CYCLES | | COMMENTS |
|---|---|---|---|---|
| PULL #1 | 3.27 | 3.19 | | |
| PULL #2 | 3.21 | 3.43 | | |
| PULL #3 | 3.57 | 3.44 | | |
| PULL #4 | 3.40 | 3.13 | | |
| PULL #5 | 3.47 | 3.34 | | |
| TOTAL | 16.92 | 16.53 | | |
| AVG. | 3.384 | 3.306 | | |

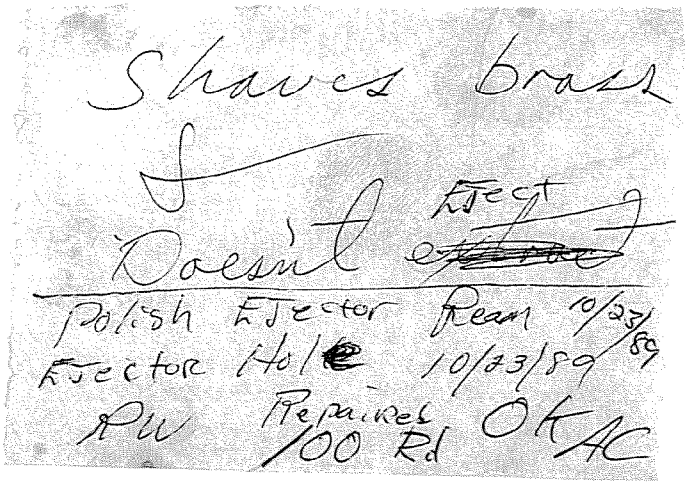
| | 4.00# INITIAL | 4.00# AFTER 20 CYCLES | MAX SETTING GREATER THAN 4# | RESET TO 4# FOR TARGET & ACCURACY |
|---|---|---|---|---|
| PULL #1 | 4.03 | 4.21 | | |
| PULL #2 | 4.12 | 4.28 | | |
| PULL #3 | 4.14 | 4.30 | | |
| PULL #4 | 4.37 | 4.33 | | |
| PULL #5 | 4.05 | 4.04 | | |
| TOTAL | 20.71 | 21.16 | | |
| AVG. | 4.142 | 4.232 | | |




Shaws brass
Doesn't Eject
Polish Ejector Ream 10/23/89
Ejector Hole 10/23/89
Repaired
100 Rd OKAC

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6348875
5 Oct 1989

CENTROIDAL DISTANCES

| | | | |
|---|---|---|---|
| 0 | TO | 1 | .596858 |
| 1 | TO | 2 | .587872 |
| 1 | TO | 3 | .760293 |
| 1 | TO | 4 | .833228 |
| 1 | TO | 5 | .720703 |

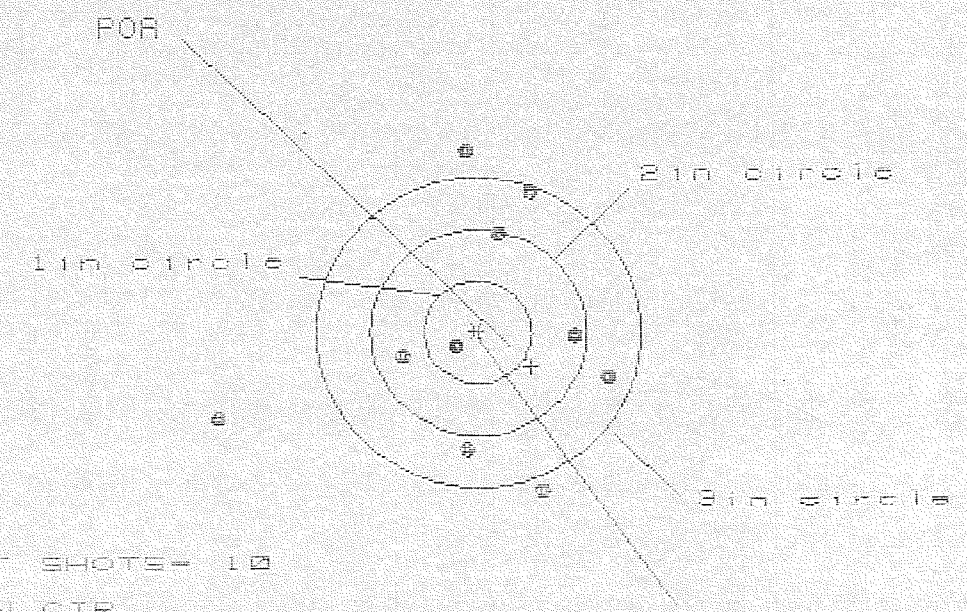
<----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0598
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0082
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0603598

THE AMR FOR THIS RIFLE IS: 1.118

5 Oct 1999 FILE:/PATTERNING/CENTERFIRE_PATT/C9348075

# CENTERFIRE PATTERNS # 1




# OF SHOTS= 10

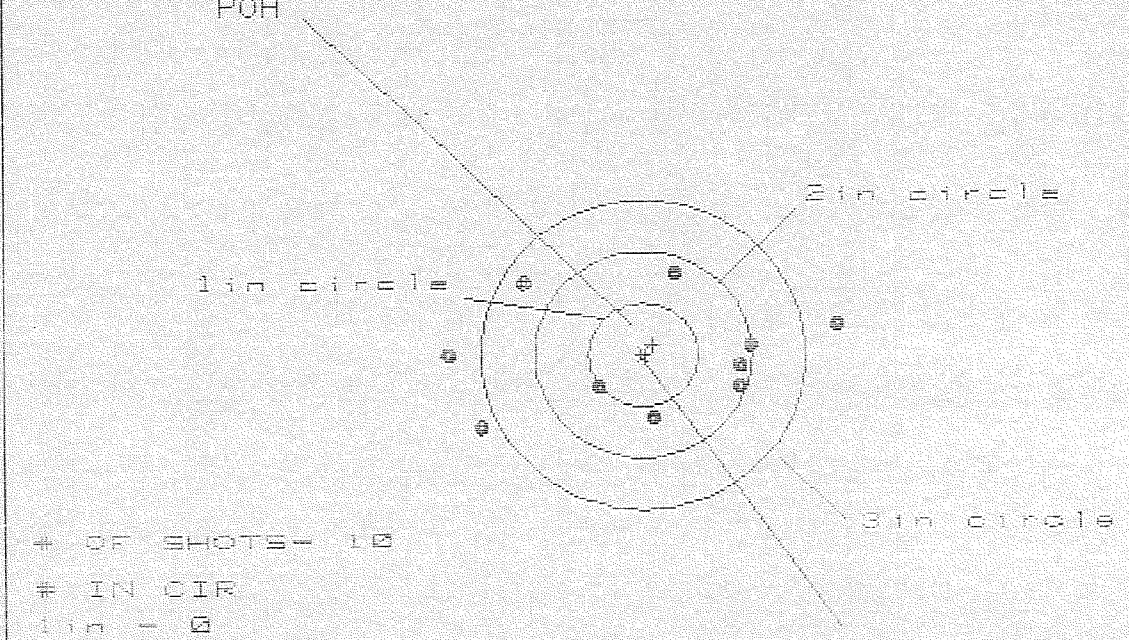
# IN CIR
1in = 1
2in = 3
3in = 7

HS= 3.601
VS= 3.266
GS= 3.618

| | | | | |
|---|---|---|---|---|
| PATTERN # | : | 1 | | |
| SHOTS (BEST OF) | : | 10 | 9 | 8 |
| MAXIMUM X | : | 1.236 | .973 | .902 |
| MINIMUM X | : | -2.365 | -.989 | -1.030 |
| MAXIMUM Y | : | 1.765 | 1.678 | 1.480 |
| MINIMUM Y | : | -1.501 | -1.589 | -1.379 |
| CENTROID X | : | -.496 | -.233 | -.192 |
| CENTROID Y | : | .332 | .419 | .210 |
| POA TO CENTROID in. | : | .597 | .480 | .284 |
| MIN RADIUS | : | .232 | .506 | .504 |
| MEAN RADIUS | : | 1.257 | 1.108 | 1.016 |
| MAX RADIUS | : | 2.492 | 1.700 | 1.498 |
| HORIZONTAL SPREAD | : | 3.601 | 1.902 | 1.982 |
| VERTICAL SPREAD | : | 3.266 | 3.266 | 2.058 |
| EXTREME SPREAD | : | 3.618 | 3.337 | 2.062 |
| NUMBER IN ONE INCH CIRCLE | = | | 1 | |
| NUMBER IN TWO INCH CIRCLE | = | | 3 | |
| NUMBER IN THREE INCH CIRCLE | = | | 7 | |

5 Oct 1999 FILE:/PATTERNING/CENTERFIRE_PATT/05348075

# CENTERFIRE PATTERNS # 2




# OF SHOTS= 10

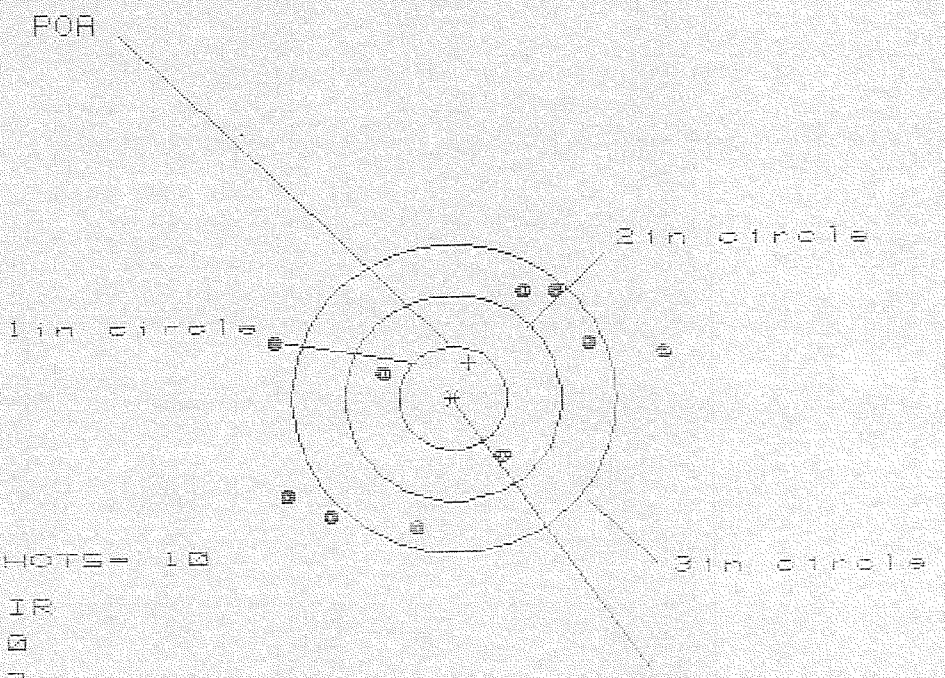
# IN CIR
1in = 0
2in = 6
3in = 7

HS= 3.603
VS= 1.551
GS= 3.617

| | | | |
|---|---|---|---|
| PATTERN # | : | 2 | |
| SHOTS (BEST OF) | : | 10 | 9 | 8 |
| MAXIMUM X | : | 1.756 | 1.551 | .949 |
| MINIMUM X | : | -1.846 | -1.728 | -1.534 |
| MAXIMUM Y | : | .835 | .834 | .876 |
| MINIMUM Y | : | -.716 | -.717 | -.675 |
| CENTROID X | : | -.093 | .112 | -.082 |
| CENTROID Y | : | -.096 | -.095 | -.137 |
| POA TO CENTROID in. | : | .134 | .147 | .159 |
| MIN RADIUS | : | .517 | .573 | .506 |
| MEAN RADIUS | : | 1.147 | 1.035 | .975 |
| MAX RADIUS | : | 1.846 | 1.871 | 1.676 |
| HORIZONTAL SPREAD | : | 3.602 | 3.279 | 2.479 |
| VERTICAL SPREAD | : | 1.551 | 1.551 | 1.551 |
| EXTREME SPREAD | : | 3.617 | 3.442 | 2.682 |
| NUMBER IN ONE INCH CIRCLE | = | | 0 | |
| NUMBER IN TWO INCH CIRCLE | = | | 6 | |
| NUMBER IN THREE INCH CIRCLE | = | | 7 | |

5 Oct 1999 FILE:/PATTERNING/CENTERFIRE_PATT/06348875

# CENTERFIRE PATTERNS # 3




# OF SHOTS= 10

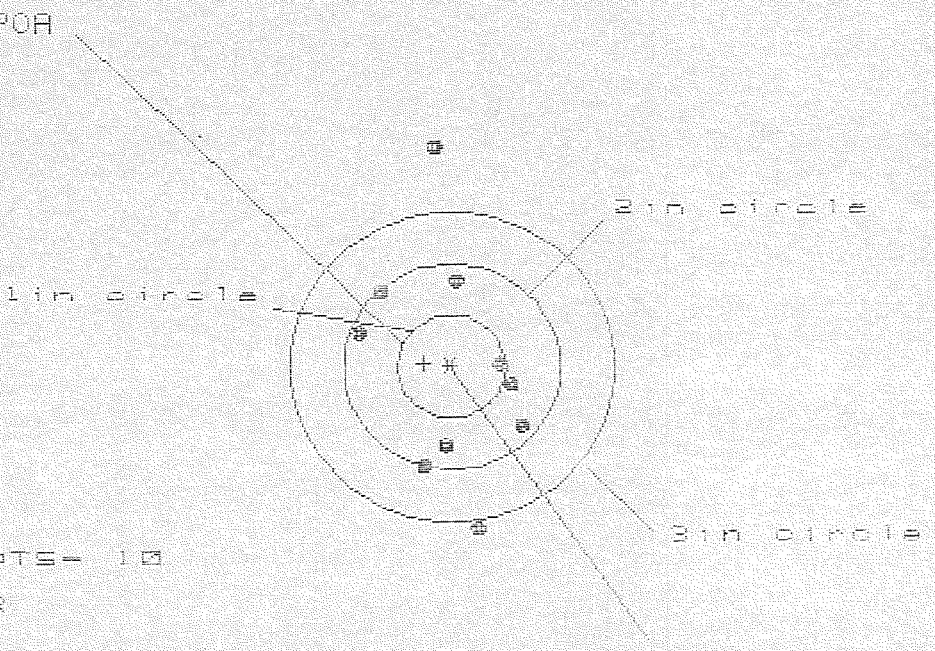
# IN CIR
1in = 5
2in = 2
3in = 3

HS= 3.518
VS= 2.264
GS= 3.735

| | | | | |
|---|---|---|---|---|
| PATTERN # | : | 3 | | |
| SHOTS (BEST OF) | : | 10 | 9 | 8 |
| MAXIMUM X | : | 1.953 | 1.477 | 1.316 |
| MINIMUM X | : | -1.665 | -1.448 | -1.609 |
| MAXIMUM Y | : | 1.022 | 1.072 | .958 |
| MINIMUM Y | : | -1.242 | -1.192 | -1.306 |
| CENTROID X | : | -.150 | -.367 | -.206 |
| CENTROID Y | : | -.345 | -.395 | -.281 |
| POA TO CENTROID in. | : | .377 | .539 | .348 |
| MIN RADIUS | : | .675 | .559 | .656 |
| MEAN RADIUS | : | 1.384 | 1.301 | 1.256 |
| MAX RADIUS | : | 2.003 | 1.610 | 1.684 |
| HORIZONTAL SPREAD | : | 3.618 | 2.925 | 2.925 |
| VERTICAL SPREAD | : | 2.264 | 2.264 | 2.264 |
| EXTREME SPREAD | : | 3.735 | 3.185 | 2.997 |
| NUMBER IN ONE INCH CIRCLE | = | | 0 | |
| NUMBER IN TWO INCH CIRCLE | = | | 2 | |
| NUMBER IN THREE INCH CIRCLE | = | | 6 | |

5 Oct 1989 FILE:/PATTERNING/CENTERFIRE_PATT/C634B875

# CENTERFIRE PATTERNS # 4




# OF SHOTS= 10

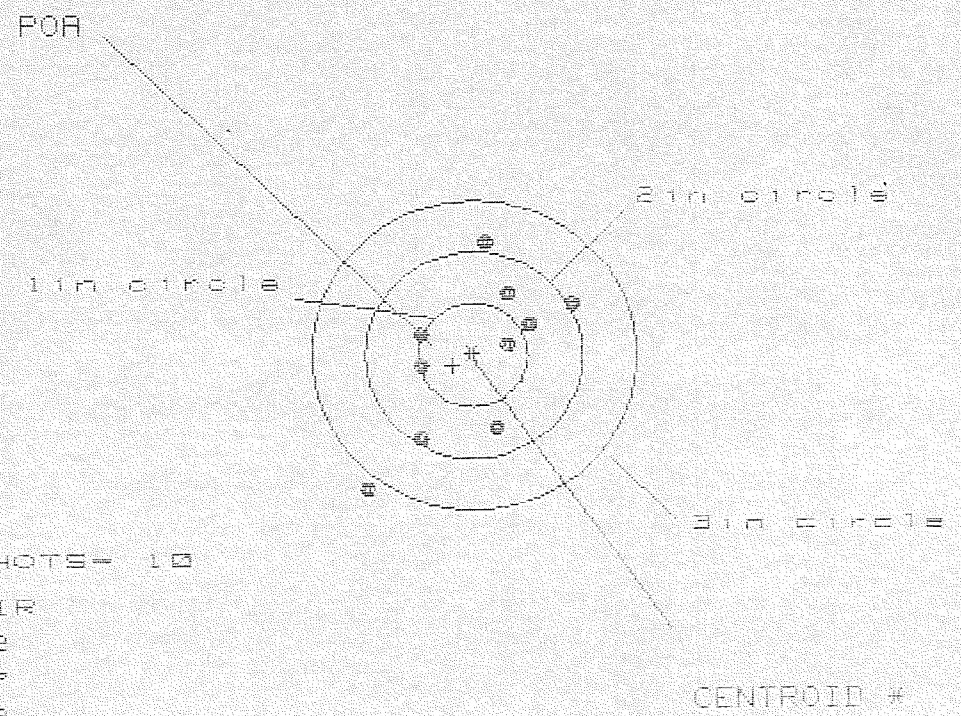
| # IN CIR | |
|---|---|
| 1in = | 1 |
| 2in = | 7 |
| 3in = | 8 |

| | |
|---|---|
| HS= | 1.507 |
| VS= | 3.656 |
| GS= | 3.683 |

| PATTERN # | : | 4 | | |
|---|---|---|---|---|
| SHOTS (BEST OF) | : | 10 | 9 | 8 |
| MAXIMUM X | : | .688 | .666 | .694 |
| MINIMUM X | : | -.819 | -.841 | -.813 |
| MAXIMUM Y | : | 2.129 | 1.031 | .870 |
| MINIMUM Y | : | -1.527 | -1.290 | -.920 |
| CENTROID X | : | .254 | .275 | .247 |
| CENTROID Y | : | -.031 | -.268 | -.107 |
| POA TO CENTROID in. | : | .255 | .384 | .269 |
| MIN RADIUS | : | .422 | .494 | .445 |
| MEAN RADIUS | : | .998 | .844 | .783 |
| MAX RADIUS | : | 2.138 | 1.309 | 1.000 |
| HORIZONTAL SPREAD | : | 1.507 | 1.507 | 1.507 |
| VERTICAL SPREAD | : | 3.656 | 2.321 | 1.790 |
| EXTREME SPREAD | : | 3.683 | 2.405 | 1.862 |
| NUMBER IN ONE INCH CIRCLE = | | | 1 | |
| NUMBER IN TWO INCH CIRCLE = | | | 7 | |
| NUMBER IN THREE INCH CIRCLE = | | | 8 | |

5 Oct 1989 FILE:/PATTERNING/CENTERFIRE_PATT/C0348075

# CENTERFIRE PATTERNS # 5




# OF SHOTS= 10

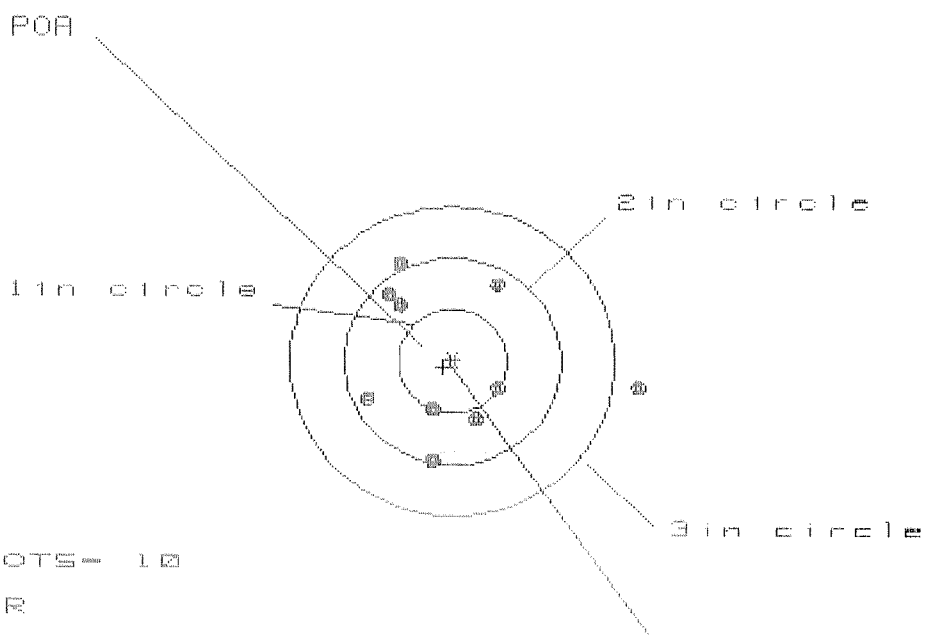
# IN CIR
1in = 2
2in = 7
3in = 9

HS= 1.952
VS= 2.385
GS= 2.642

| | | | | |
|---|---|---|---|---|
| PATTERN # | : | 5 | | |
| SHOTS (BEST OF) | : | 10 | 9 | 8 |
| MAXIMUM X | : | .947 | .835 | .838 |
| MINIMUM X | : | -1.005 | -.618 | -.615 |
| MAXIMUM Y | : | 1.122 | .981 | .536 |
| MINIMUM Y | : | -1.263 | -.908 | -.785 |
| CENTROID X | : | .186 | .298 | .295 |
| CENTROID Y | : | .099 | .240 | .117 |
| POA TO CENTROID in. | : | .211 | .382 | .318 |
| MIN RADIUS | : | .367 | .260 | .257 |
| MEAN RADIUS | : | .802 | .683 | .647 |
| MAX RADIUS | : | 1.614 | 1.096 | .995 |
| HORIZONTAL SPREAD | : | 1.952 | 1.453 | 1.453 |
| VERTICAL SPREAD | : | 2.385 | 1.889 | 1.921 |
| EXTREME SPREAD | : | 2.642 | 1.993 | 1.923 |
| NUMBER IN ONE INCH CIRCLE | = | | 2 | |
| NUMBER IN TWO INCH CIRCLE | = | | 7 | |
| NUMBER IN THREE INCH CIRCLE | = | | 9 | |

1 Jan 1900 FILE:/PATTERNING/CENTERFIRE_PATT/C6348875

# CENTERFIRE PATTERNS # 5




# OF SHOTS= 10

| # IN CIR | |
|---|---|
| 1in | = 1 |
| 2in | = 8 |
| 3in | = 9 |

HS= 2.512
VS= 1.866
GS= 2.515

PATTERN # : 5

| | | | |
|---|---|---|---|
| SHOTS (BEST OF) : | 10 | 9 | 8 |
| MAXIMUM X : | 1.689 | .629 | .588 |
| MINIMUM X : | -.823 | -.636 | -.677 |
| MAXIMUM Y : | .906 | .873 | .842 |
| MINIMUM Y : | -.960 | -.993 | -.884 |
| CENTROID X : | .086 | -.101 | -.060 |
| CENTROID Y : | .055 | .088 | -.021 |
| POA TO CENTROID in.: | .102 | .134 | .063 |
| MIN RADIUS : | .485 | .475 | .370 |
| MEAN RADIUS : | .870 | .759 | .722 |
| MAX RADIUS : | 1.714 | .994 | 1.006 |
| HORIZONTAL SPREAD : | 2.512 | 1.265 | 1.265 |
| VERTICAL SPREAD : | 1.866 | 1.866 | 1.726 |
| EXTREME SPREAD : | 2.515 | 1.903 | 1.813 |
| NUMBER IN ONE INCH CIRCLE = | | 1 | |
| NUMBER IN TWO INCH CIRCLE = | | 8 | |
| NUMBER IN THREE INCH CIRCLE = | | 9 | |