C6348927

MODEL 700™ M24

Model SWS ™

Action

Barrel Length

Capacity

Order No. 5716

*Includes 1 in chamber.

Remington

Arms Services Repair & Estimate System

File Add Repair Estimate Repair Expedite Repair Inquiry Repair Tools CSR Tools Reports Table Maintenance System Maintenance Help

Repair Inquiry

Repair Number: RE00128645

Verify Repair

Serial: C6348927 Model M24 SWS Center Fire
Caliber: 7.62 NATO

Repairman:

Status: New 4/27/2007 7:21:29 AM

Address Information

Customer: (Received From)		Return To: (Received From)	
Name:	25TH ID 2ND STRYKER BDE COMBAT TEAM		25TH ID 2ND STRYKER BDE COMBAT TEAM
Address 1:	CHRISTOPHER LEEE NEWLIN		CHRISTOPHER LEEE NEWLIN
Address 2:	BLDG 500 FOOTE AVE S4 PO Box:		BLDG 500 FOOTE AVE S4 PO Box:
City:	SCHOFIELD BARRACKS		SCHOFIELD BARRACKS
State:	HI Zip Code: 96857 Country: US	State:	HI Zip Code: 96857 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
A008	With Swivel	2
A010	Hard Case	1
A017	Scope Base	1
A057	Frt and Rear Sgt Base	1

Repair Search | Refresh | Close

nagletj | 4/27/2007 | 7:43 AM | CAPS | NUM | INS | SCRL

start | 5 [| R... | 5] | M... | S... | B... | P... | A... | 7:43 AM

Serial Number: C6348927

Model: M24 SWS

RE00128645

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFOMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6348927.__0
FILE DATE AND TIME: 08/15/2007 14:11

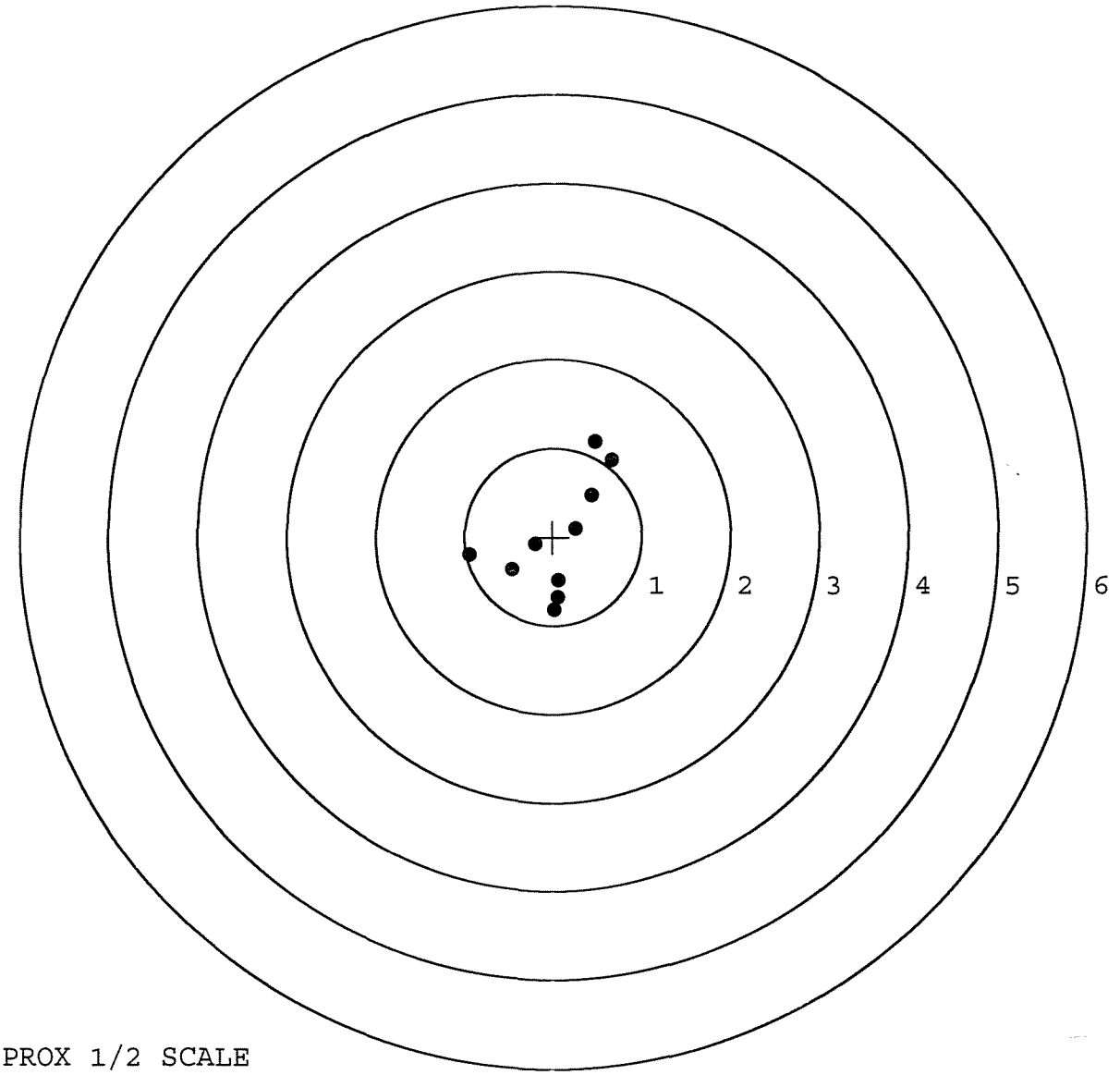
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.068
The Average Y Centroid of the Five Target Set:	0.005
The Average Point of Impact of the Five Target Set:	0.068
The Average Mean Radius of the Five Target Set:	0.783
The Distance from POA to Centroid Target #1:	0.038
The Distance from Centroid Target #2 to Centroid Target #1:	0.111
The Distance from Centroid Target #3 to Centroid Target #1:	0.110
The Distance from Centroid Target #4 to Centroid Target #1:	0.107
The Distance from Centroid Target #5 to Centroid Target #1:	0.394

SERIAL NUMBER: C6348927.__0
TARGET NUMBER: 1
FILE DATE: 08/15/2007
FILE TIME: 14:11

X CENTROID:	0.033
Y CENTROID:	-0.018
POA TO CENTROID:	0.038
HORZ SPREAD:	1.599
VERT SPREAD:	1.902
GROUP SPREAD:	1.955
MIN RADIUS:	0.244
MAX RADIUS:	1.172
MEAN RADIUS:	0.695
# IN 1 IN DIAMETER:	3
# IN 2 IN DIAMETER:	8
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	0.017	-0.832
2:	0.056	-0.692
3:	0.066	-0.495
4:	-0.462	-0.379
5:	-0.202	-0.081
6:	-0.945	-0.209
7:	0.252	0.096
8:	0.430	0.472
9:	0.654	0.866
10:	0.468	1.070

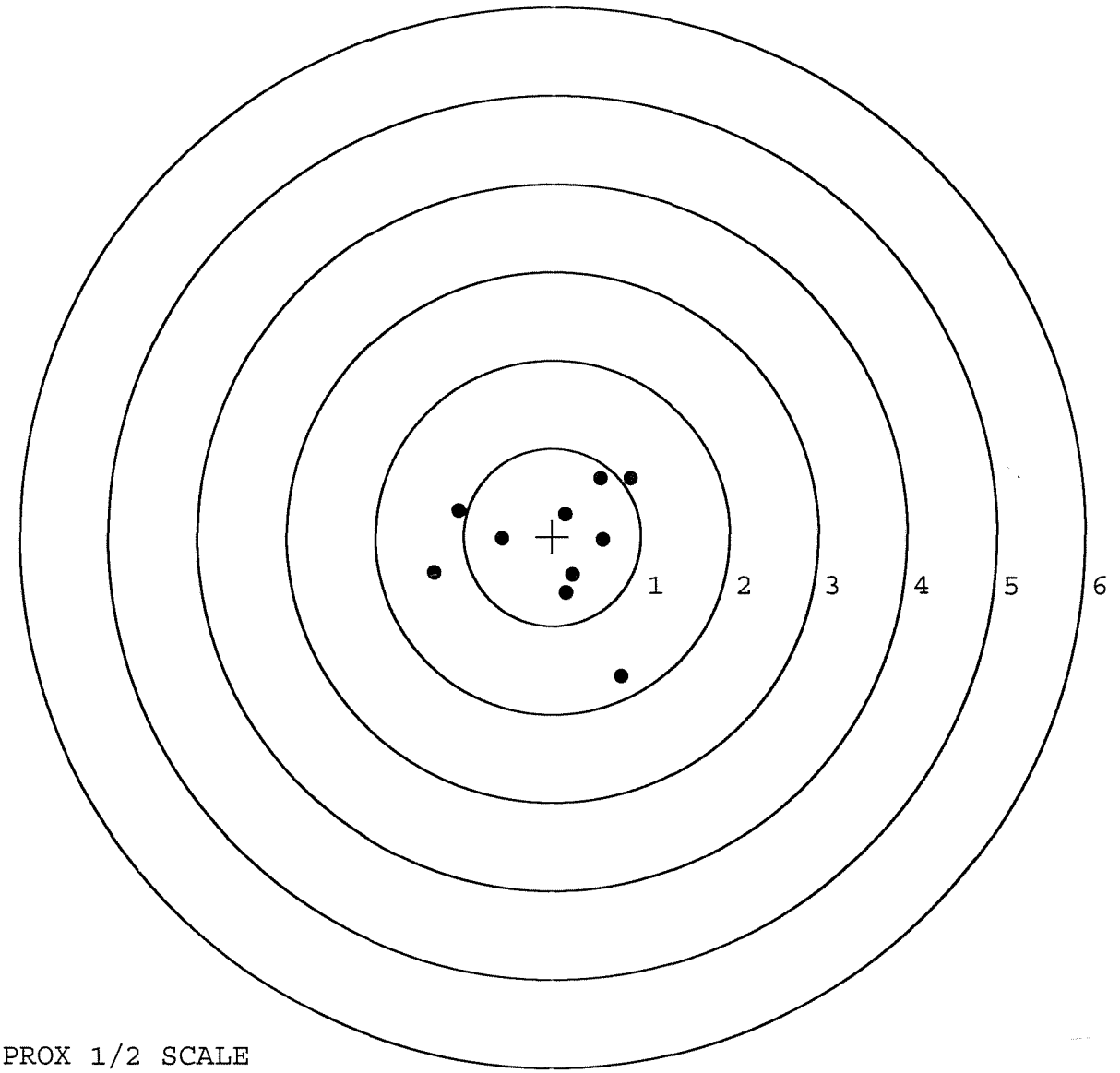


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6348927.__0
TARGET NUMBER: 2
FILE DATE: 08/15/2007
FILE TIME: 14:11

X CENTROID:	0.033
Y CENTROID:	-0.129
POA TO CENTROID:	0.133
HORZ SPREAD:	2.218
VERT SPREAD:	2.233
GROUP SPREAD:	2.618
MIN RADIUS:	0.366
MAX RADIUS:	1.627
MEAN RADIUS:	0.872
# IN 1 IN DIAMETER:	2
# IN 2 IN DIAMETER:	6
# in 3 IN DIAMETER:	9

POINT#	X	Y
1:	0.776	-1.577
2:	0.160	-0.634
3:	0.228	-0.439
4:	0.569	-0.040
5:	0.145	0.248
6:	0.884	0.655
7:	0.537	0.656
8:	-0.572	-0.032
9:	-1.058	0.291
10:	-1.334	-0.419

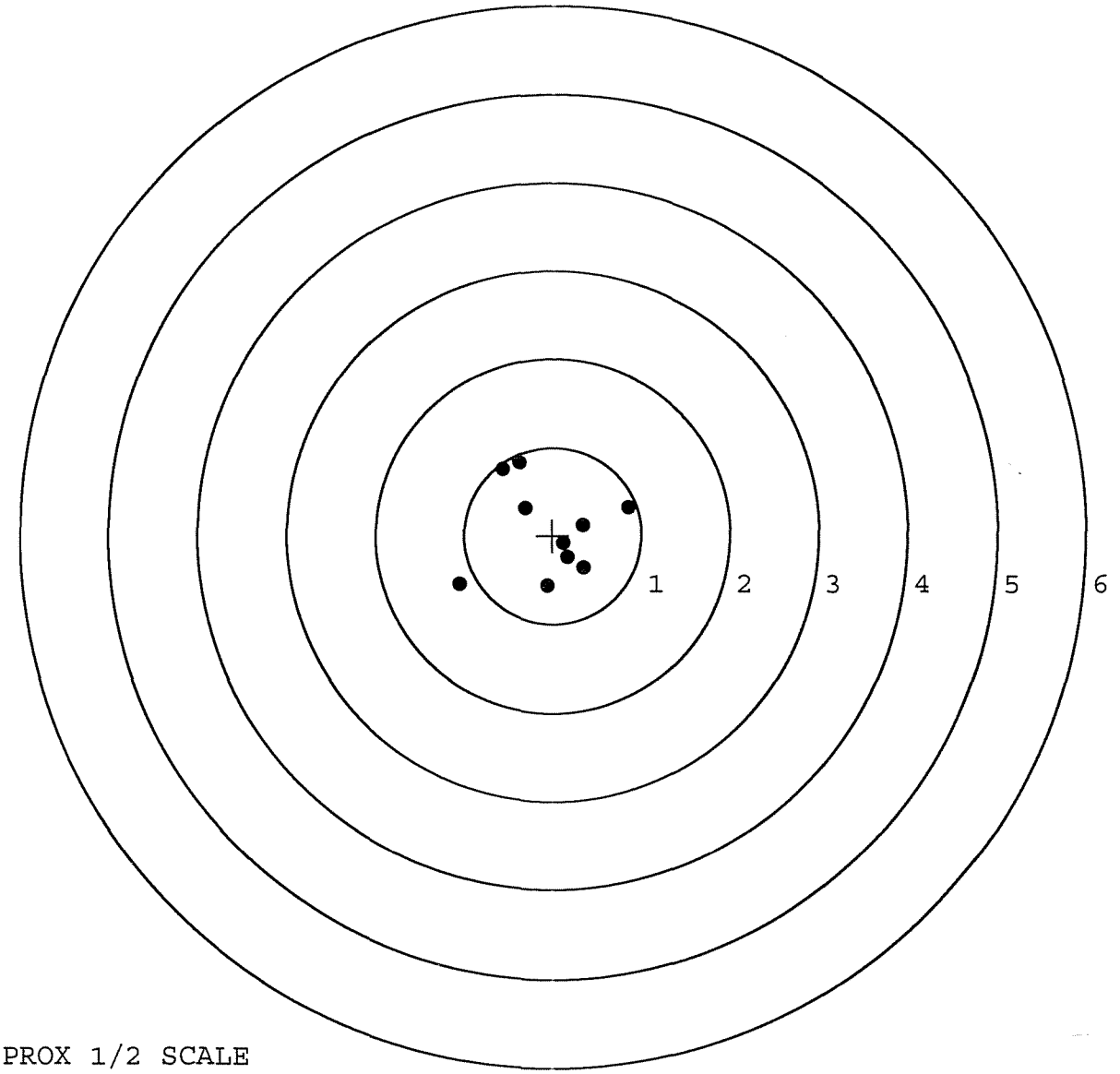


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6348927.__0
TARGET NUMBER: 3
FILE DATE: 08/15/2007
FILE TIME: 14:11

X CENTROID:	-0.055
Y CENTROID:	0.047
POA TO CENTROID:	0.073
HORZ SPREAD:	1.905
VERT SPREAD:	1.411
GROUP SPREAD:	2.100
MIN RADIUS:	0.222
MAX RADIUS:	1.170
MEAN RADIUS:	0.641
# IN 1 IN DIAMETER:	4
# IN 2 IN DIAMETER:	9
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	0.853	0.318
2:	-1.052	-0.565
3:	-0.316	0.309
4:	-0.573	0.751
5:	-0.384	0.832
6:	0.336	0.115
7:	0.350	-0.373
8:	0.122	-0.087
9:	0.171	-0.250
10:	-0.061	-0.579

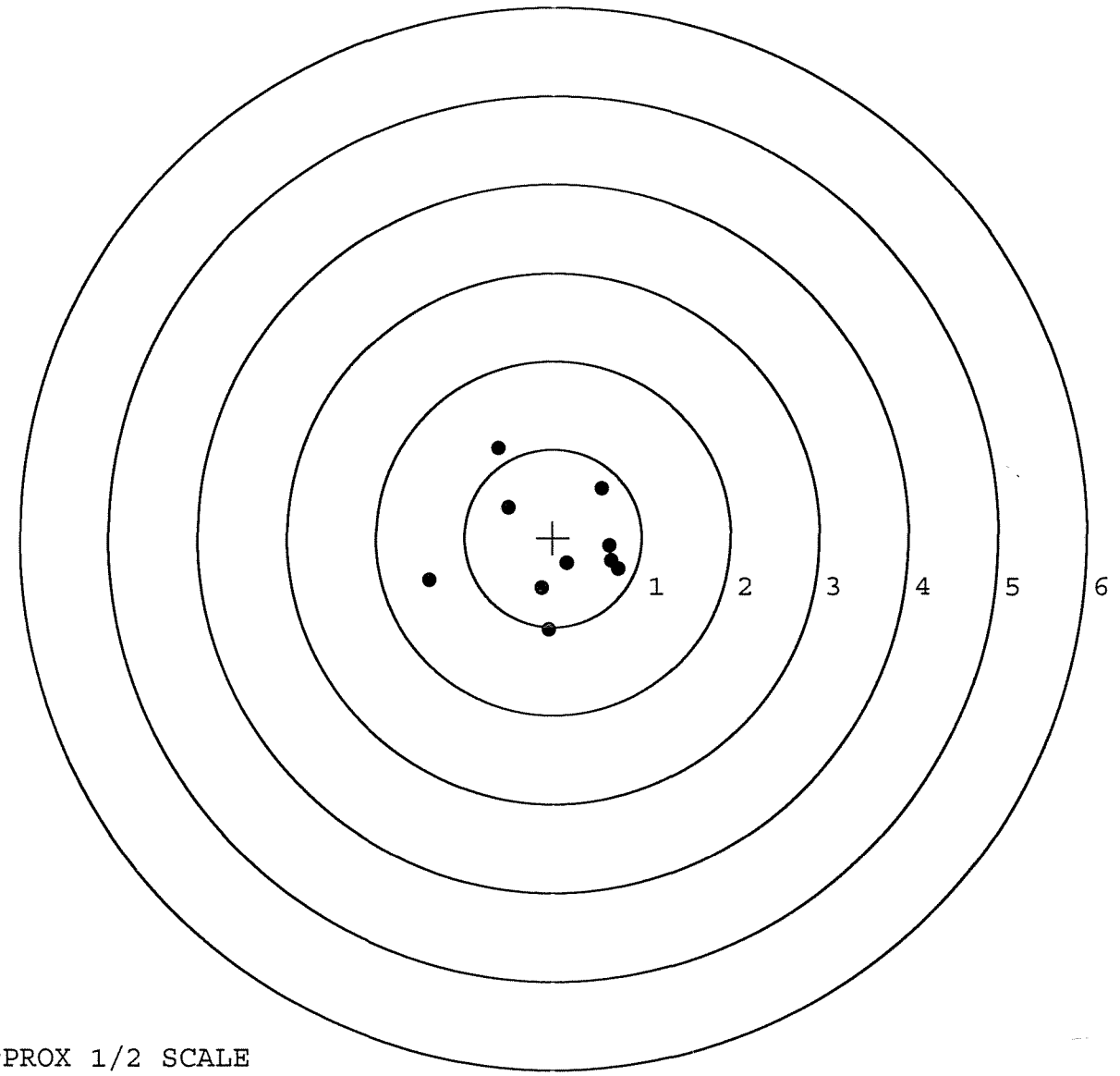


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6348927.__0
TARGET NUMBER: 4
FILE DATE: 08/15/2007
FILE TIME: 14:11

X CENTROID:	0.002
Y CENTROID:	-0.121
POA TO CENTROID:	0.121
HORZ SPREAD:	2.137
VERT SPREAD:	2.045
GROUP SPREAD:	2.205
MIN RADIUS:	0.230
MAX RADIUS:	1.448
MEAN RADIUS:	0.798
# IN 1 IN DIAMETER:	2
# IN 2 IN DIAMETER:	8
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	0.737	-0.357
2:	0.639	-0.099
3:	0.157	-0.291
4:	-0.128	-0.567
5:	-0.051	-1.037
6:	0.546	0.551
7:	-0.513	0.336
8:	-0.622	1.008
9:	-1.400	-0.485
10:	0.654	-0.266

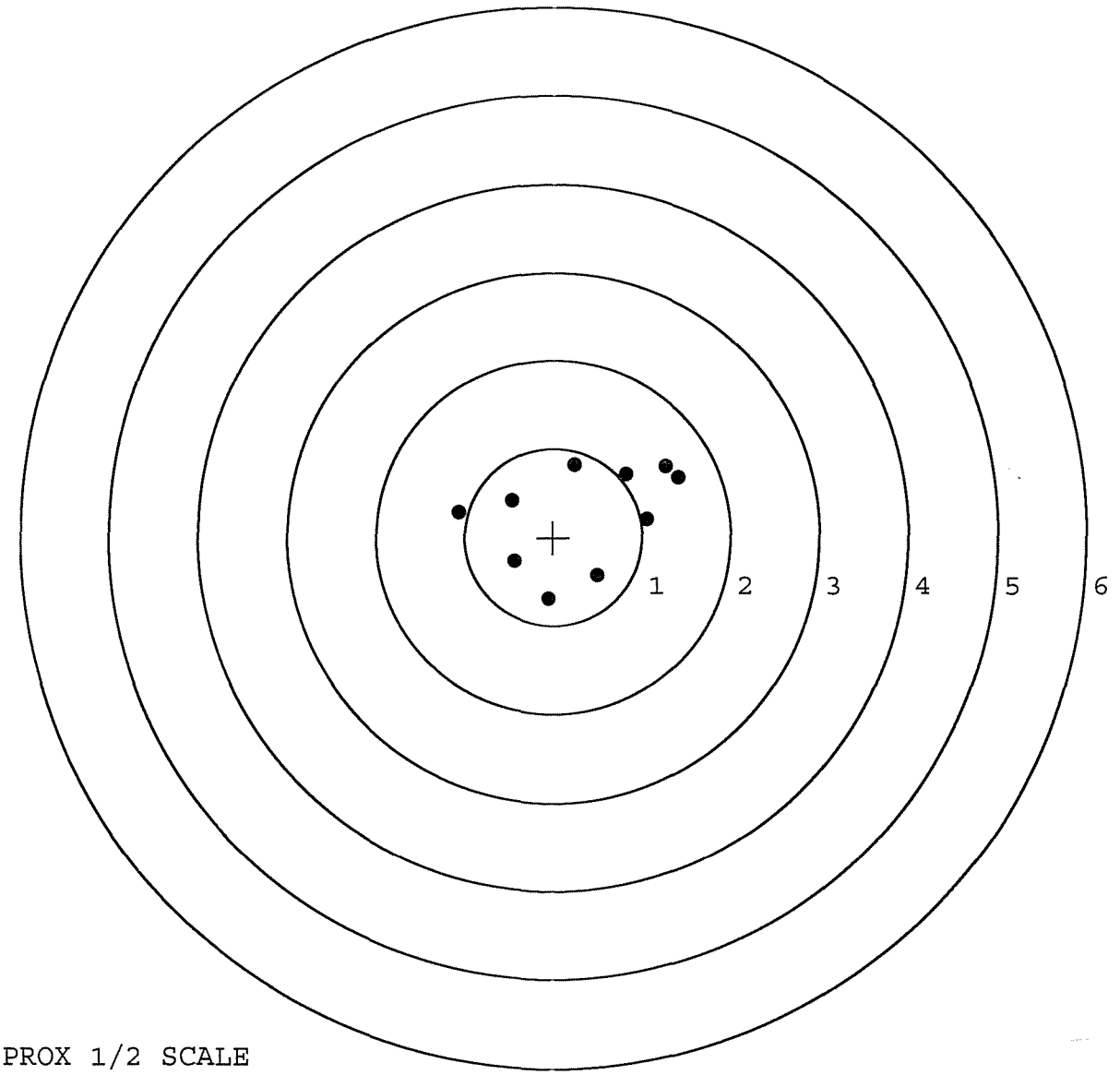


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6348927.__0
TARGET NUMBER: 5
FILE DATE: 08/15/2007
FILE TIME: 14:11

X CENTROID:	0.324
Y CENTROID:	0.247
POA TO CENTROID:	0.408
HORZ SPREAD:	2.474
VERT SPREAD:	1.519
GROUP SPREAD:	2.505
MIN RADIUS:	0.574
MAX RADIUS:	1.394
MEAN RADIUS:	0.909
# IN 1 IN DIAMETER:	0
# IN 2 IN DIAMETER:	6
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	1.405	0.674
2:	1.262	0.800
3:	1.051	0.204
4:	0.819	0.712
5:	0.237	0.815
6:	0.500	-0.438
7:	-0.055	-0.704
8:	-0.436	-0.279
9:	-0.472	0.410
10:	-1.069	0.279

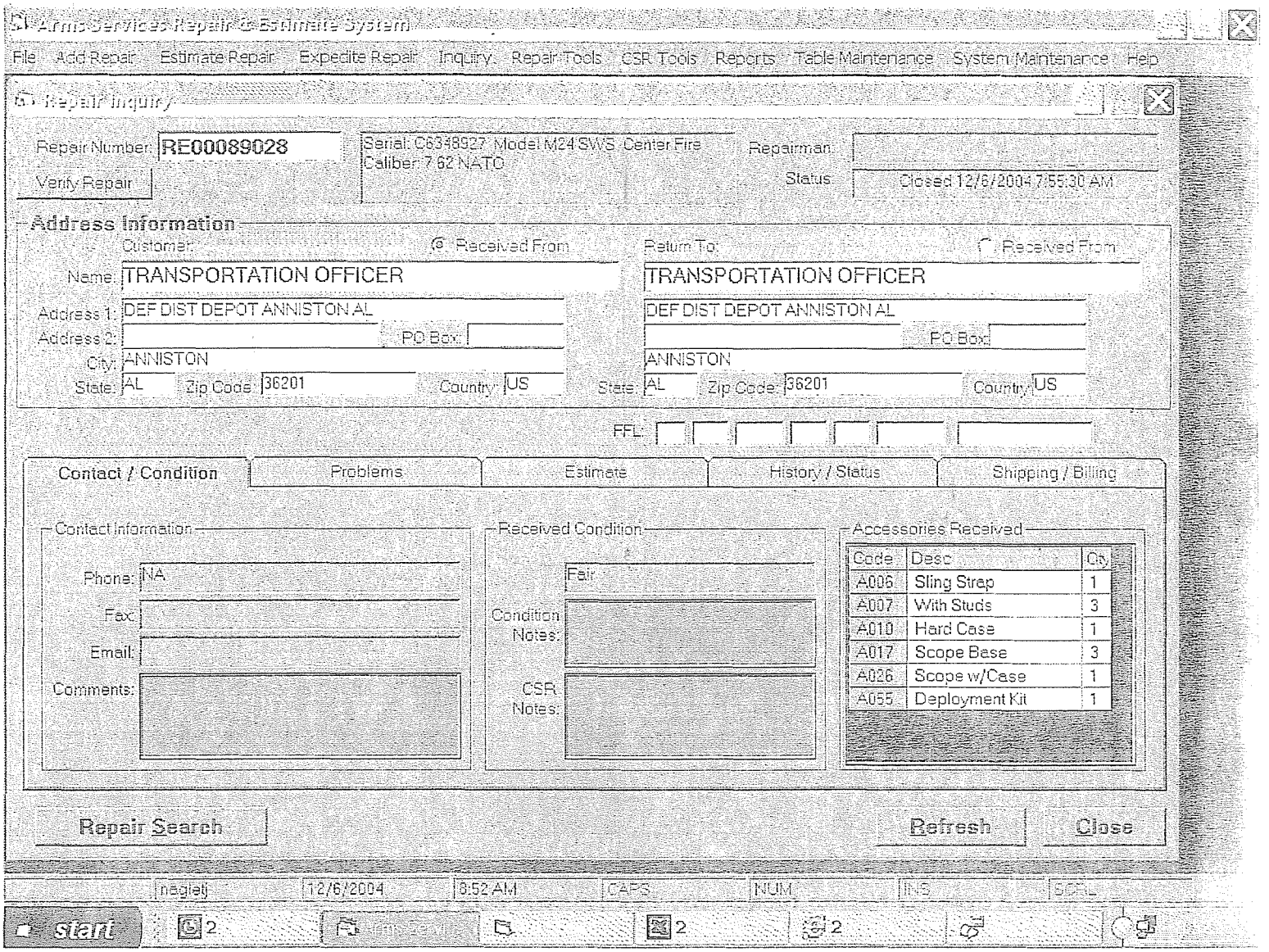


TARGET APPROX 1/2 SCALE

M-24 INSPECTION CHECKLIST
CONTRACT #: DAAE-20-02-C-0149 5218

R & E NUMBER 128645
SERIAL NUMBER C6848927
LOG-IN DATE 4-27-07

OPERATION #	OPERATION NAME		DATE	INITIAL
500	DIS-ASSEMBLE GUN		7-26-07	RTC
505	RE-BARREL		7-31-07	RTC
560	ASSEMBLE		7-31-07	RTC
600	PROOF		8/1/07	[illegible]
605	CHECK HEADSPACE		8/1/07	[illegible]
610	DIS-ASSEMBLE GUN		8-2-07	RTC
612	MAGNAFLUX			
510	DRILL AND TAP	N/A	8-2-07	TRW
615	ROLLMARK CALIBER		8-2-07	GW
618	ROTO-BLAST		8-3-07	LV
620	APPLY COATINGS		8-10-07	CM
625	FINAL ASSEMBLY		8-13-07	RTC
640	FUNCTION TEST AND	(PASS) FAIL	8-15-07	TRW
650	TARGET	(PASS) FAIL	8-15-07	TRW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION	8-15-07	Fuy
670	FINAL INSPECTION		8/17/07	[illegible]
	A) HEADSPACE	~~PASS~~ FAIL	8/17/07	[illegible]
	B) TRIGGER PULL (+/- .5 LBS, MIN 2.50 LBS, MAX 4.0 LBS)	2.50 2.40 2.30 2.60 2.50	8/17/07	[illegible]
680	F) SAFETY ON FORCE (2 LBS MIN, 10 LBS MAX)	5.50 5.75 5.0	8/17/07	[illegible]
	G) SAFETY OFF FORCE (2 LBS MIN)	3.5 3.0 2.75	8/17/07	[illegible]
	I) FIRING PIN INDENT (.020)	.025 .025 .025	8/17/07	[illegible]
690	PACK		8-23-07	DA


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: RE00089028
Verify Repair
Serial: C6348927 Model M24 SWS Center Fire
Caliber: 7.62 NATO
Repairman:
Status: Closed 12/6/2004 7:55:30 AM
Address Information
Customer: Received From
Name: TRANSPORTATION OFFICER
Address 1: DEF DIST DEPOT ANNISTON AL
Address 2: PO Box:
City: ANNISTON
State: AL Zip Code: 36201 Country: US
Return To: Received From
TRANSPORTATION OFFICER
DEF DIST DEPOT ANNISTON AL
PO Box:
ANNISTON
State: AL Zip Code: 36201 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
A006 Sling Strap 1
A007 With Studs 3
A010 Hard Case 1
A017 Scope Base 3
A026 Scope w/Case 1
A055 Deployment Kit 1
Repair Search
Refresh
Close
12/6/2004
8:52 AM
CAPS
NUM
INS
SCRL
start


Serial Number: C6348927
Model: M24 SWS
RE00089028

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFOMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6348927.__0
FILE DATE AND TIME: 01/10/2005 11:09

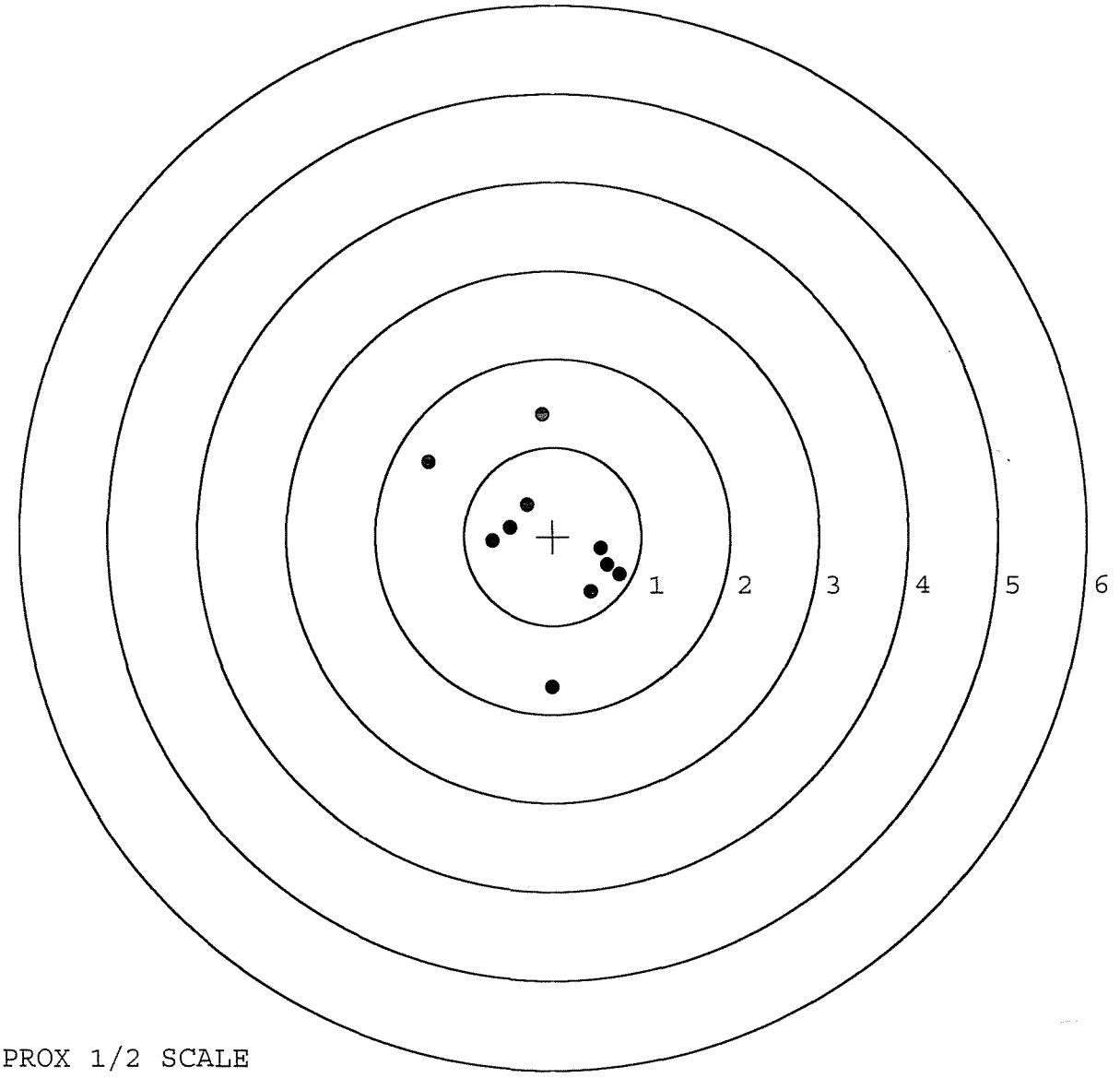
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.011
The Average Y Centroid of the Five Target Set:	-0.075
The Average Point of Impact of the Five Target Set:	0.076
The Average Mean Radius of the Five Target Set:	0.781
The Distance from POA to Centroid Target #1:	0.091
The Distance from Centroid Target #2 to Centroid Target #1:	0.145
The Distance from Centroid Target #3 to Centroid Target #1:	0.134
The Distance from Centroid Target #4 to Centroid Target #1:	0.267
The Distance from Centroid Target #5 to Centroid Target #1:	0.205

SERIAL NUMBER: C6348927.__0
TARGET NUMBER: 1
FILE DATE: 01/10/2005
FILE TIME: 11:09

X CENTROID:	-0.068
Y CENTROID:	-0.061
POA TO CENTROID:	0.091
HORZ SPREAD:	2.149
VERT SPREAD:	3.067
GROUP SPREAD:	3.069
MIN RADIUS:	0.447
MAX RADIUS:	1.636
MEAN RADIUS:	0.919
# IN 1 IN DIAMETER:	2
# IN 2 IN DIAMETER:	7
# in 3 IN DIAMETER:	8

POINT#	X	Y
1:	-0.008	-1.696
2:	-0.120	1.371
3:	-1.400	0.831
4:	-0.297	0.357
5:	-0.485	0.099
6:	-0.685	-0.057
7:	0.425	-0.625
8:	0.749	-0.430
9:	0.611	-0.326
10:	0.535	-0.134

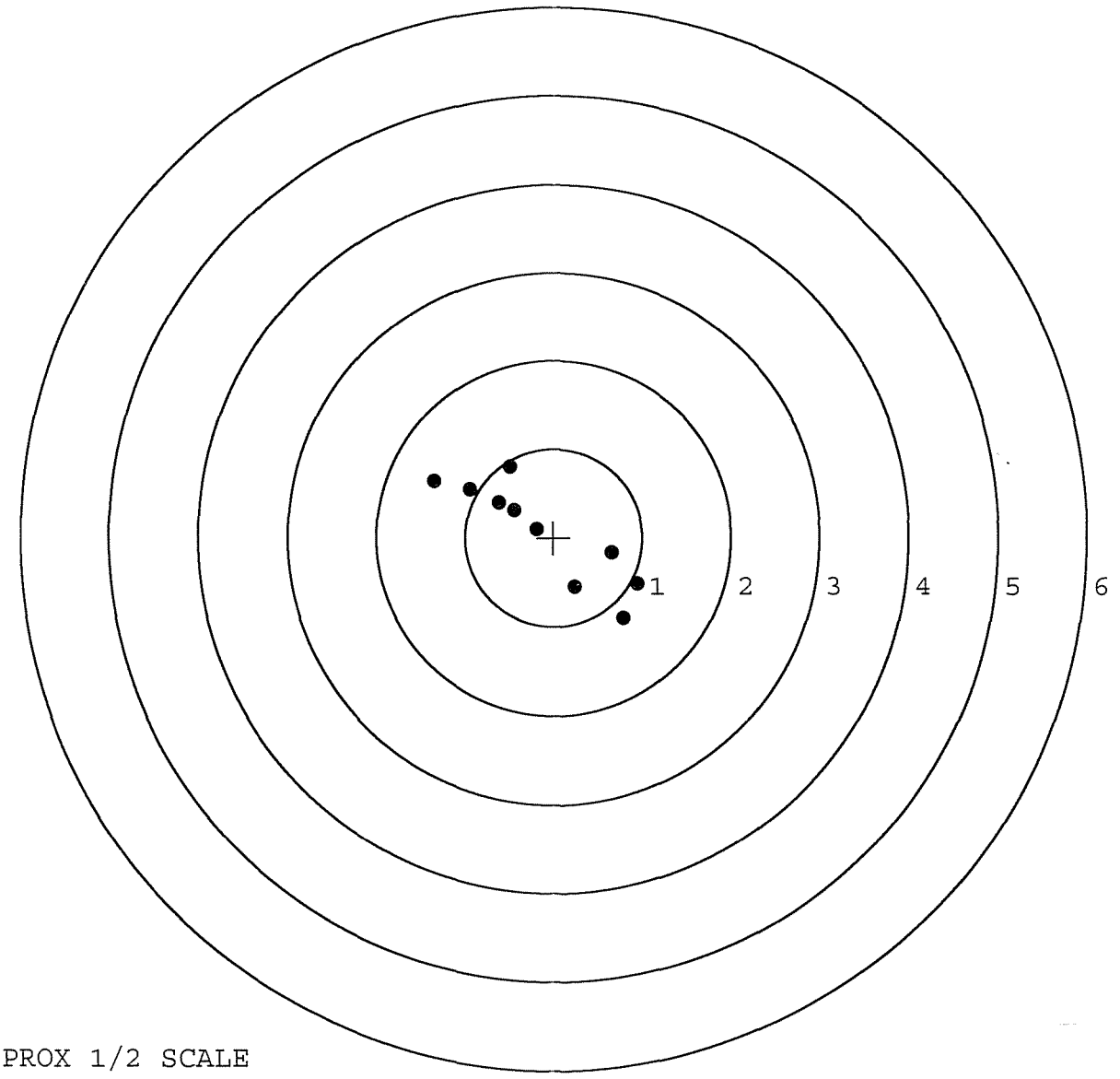


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6348927.__0
TARGET NUMBER: 2
FILE DATE: 01/10/2005
FILE TIME: 11:09

X CENTROID:	-0.144
Y CENTROID:	0.062
POA TO CENTROID:	0.157
HORZ SPREAD:	2.289
VERT SPREAD:	1.710
GROUP SPREAD:	2.629
MIN RADIUS:	0.059
MAX RADIUS:	1.343
MEAN RADIUS:	0.827
# IN 1 IN DIAMETER:	2
# IN 2 IN DIAMETER:	7
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	0.782	-0.910
2:	0.942	-0.521
3:	0.655	-0.172
4:	0.239	-0.558
5:	-0.190	0.099
6:	-0.451	0.312
7:	-0.621	0.400
8:	-0.953	0.543
9:	-1.347	0.632
10:	-0.495	0.800

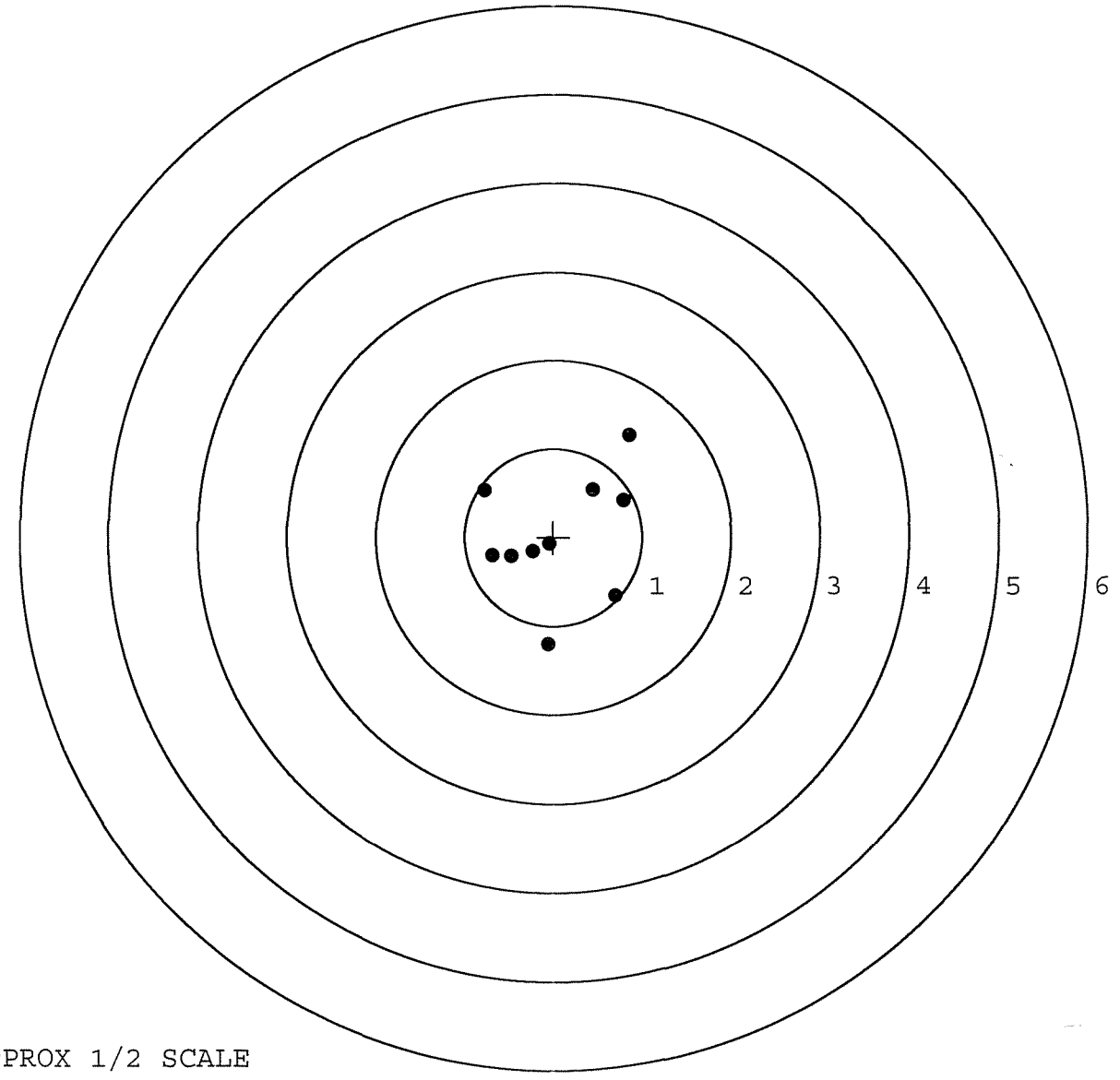


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6348927.__0
TARGET NUMBER: 3
FILE DATE: 01/10/2005
FILE TIME: 11:09

X CENTROID:	0.047
Y CENTROID:	0.009
POA TO CENTROID:	0.048
HORZ SPREAD:	1.630
VERT SPREAD:	2.359
GROUP SPREAD:	2.531
MIN RADIUS:	0.127
MAX RADIUS:	1.395
MEAN RADIUS:	0.783
# IN 1 IN DIAMETER:	2
# IN 2 IN DIAMETER:	8
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	-0.065	-1.210
2:	0.694	-0.664
3:	0.787	0.414
4:	0.435	0.535
5:	0.851	1.149
6:	-0.779	0.532
7:	-0.048	-0.075
8:	-0.239	-0.161
9:	-0.476	-0.214
10:	-0.693	-0.211

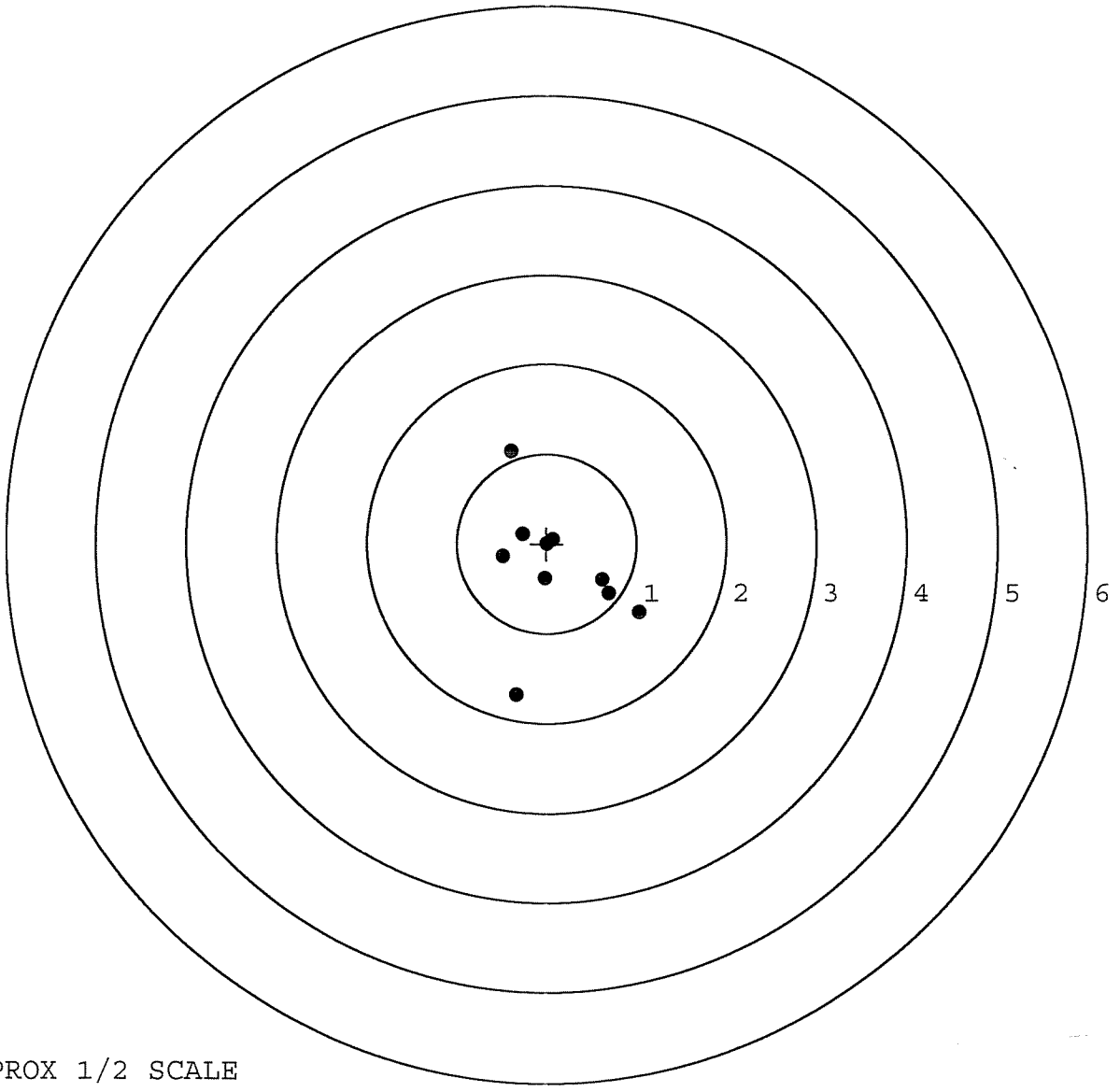


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6348927.__0
TARGET NUMBER: 4
FILE DATE: 01/10/2005
FILE TIME: 11:09

X CENTROID:	0.089
Y CENTROID:	-0.277
POA TO CENTROID:	0.291
HORZ SPREAD:	1.516
VERT SPREAD:	2.725
GROUP SPREAD:	2.726
MIN RADIUS:	0.159
MAX RADIUS:	1.478
MEAN RADIUS:	0.703
# IN 1 IN DIAMETER:	3
# IN 2 IN DIAMETER:	7
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	0.004	-0.003
2:	-0.334	-1.693
3:	1.028	-0.772
4:	0.688	-0.557
5:	0.616	-0.403
6:	-0.395	1.032
7:	-0.488	-0.145
8:	-0.268	0.109
9:	-0.025	-0.388
10:	0.068	0.048

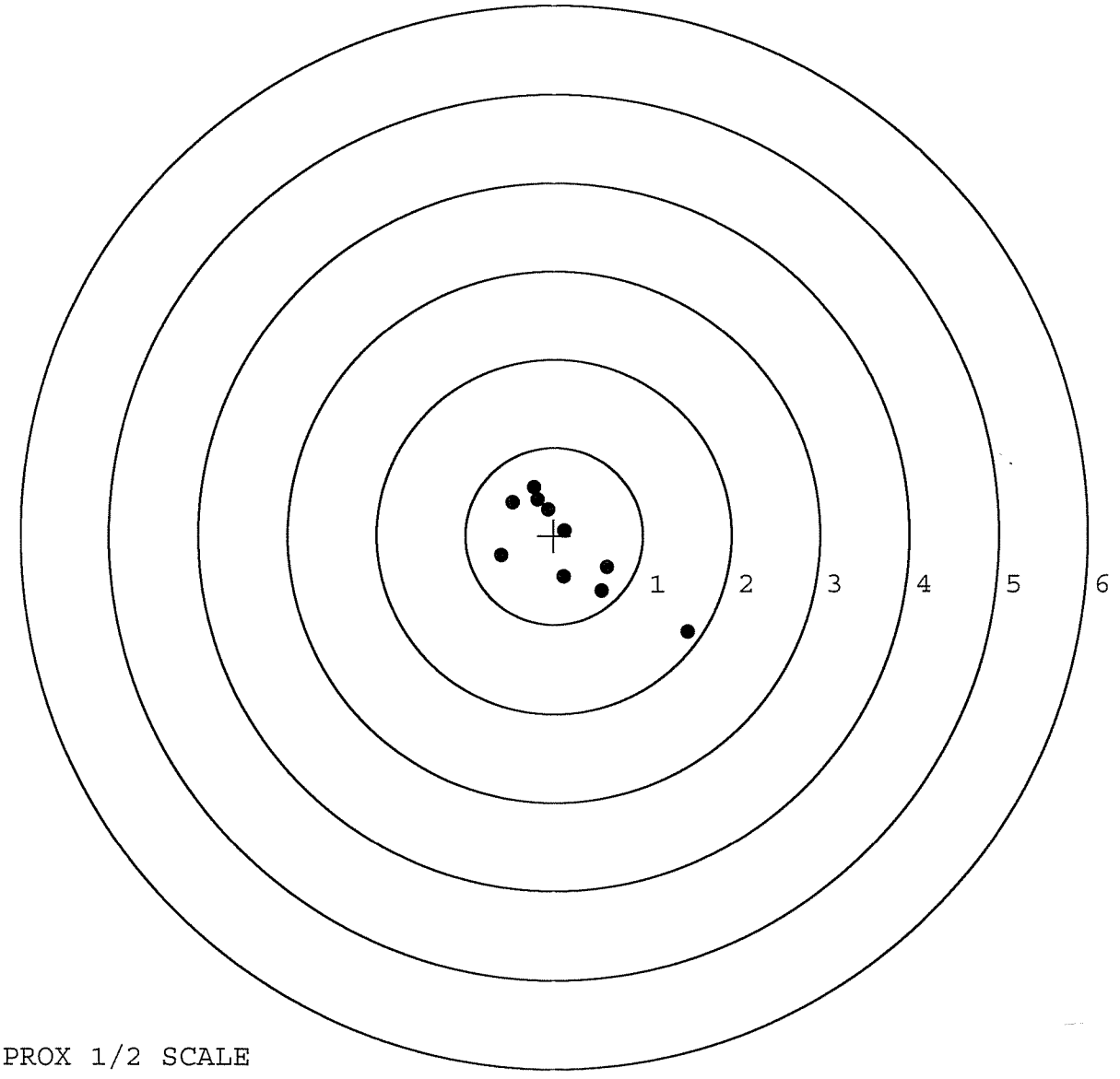


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6348927.__0
TARGET NUMBER: 5
FILE DATE: 01/10/2005
FILE TIME: 11:09

X CENTROID:	0.131
Y CENTROID:	-0.109
POA TO CENTROID:	0.171
HORZ SPREAD:	2.104
VERT SPREAD:	1.638
GROUP SPREAD:	2.457
MIN RADIUS:	0.165
MAX RADIUS:	1.687
MEAN RADIUS:	0.674
# IN 1 IN DIAMETER:	3
# IN 2 IN DIAMETER:	9
# in 3 IN DIAMETER:	9

POINT#	X	Y
1:	1.505	-1.088
2:	0.600	-0.362
3:	0.537	-0.633
4:	0.111	-0.470
5:	-0.599	-0.230
6:	0.115	0.055
7:	-0.069	0.296
8:	-0.468	0.377
9:	-0.229	0.550
10:	-0.189	0.412



TARGET APPROX 1/2 SCALE

M-2 INSPECTION CHECKLIST
CONTRACT #: DAAE-20-02-D-0127

R & E NUMBER	89028		
SERIAL NUMBER	C6348927		
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	TRW
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	1-06-05	RTL
B	TRIGGER PULL TEST	N/A	
C	SAFETY "ON" FORCE		
D	SAFETY "OFF" FORCE		
E	FIRING PIN INDENT		
640	TARGET	1-10-05	AC
655	FINAL INSPECT	1-11-05	AC
660	PACK	3-1-05	N/A
		SHIP DATE	
	QAR INSPECTION DATE		

RECEIVING AND ESTIMATING REPORT

R 94-18089

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

W/10X SCOPE M-24 SNIPER, W/DEPLOYMENT KIT
ATTN: FRED MARTIN scope S/N 90 0638

DATE RECEIVED	DATE OPENED	DATE CODE	SERIAL NUMBER	NEW SERIAL NUMBER	MODEL AND GRADE
06/09/94	06/09/94		C6348927		700 7-62 NATO

ACCESSORIES: SLING STRAP HARD CASE SCOPE MNTS SCOPE BASE

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
		☐		7-23-96	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
✓NEW BARREL	
Stock	
TRIGGER ASSY	
Front & Rear Sight ASSY	

REPAIRMAN	PROOF	CLEAN	TEST	TARGET	PATTERN
TCP			A	A	
GALLERY TESTER	**DATE**	**DATE**	**DATE**	**DATE**	**DATE**
			7/23/96	7/23/96	

OFFICE COPY

RD6925 REV. 1/94

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

SERIAL NO. C6348927
DATE 7-22-96
TESTER DA

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.27	2.49	2.58		MIN. SETTING,
PULL #2	2.17	2.49	2.87		NO AVG. OF 5
PULL #3	2.28	2.46	2.79		READINGS ACCEPT-
PULL #4	2.11	2.56	2.88		ABLE LESS THAN 2#
PULL #5	2.25	2.64	2.77		
TOTAL	11.08	12.64	13.89		
AVG.	2.21	2.52	2.77		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.23	3.24		
PULL #2	3.17	3.09		
PULL #3	3.33	3.14		
PULL #4	3.32	3.24		
PULL #5	3.11	3.23		
TOTAL	16.16	15.94		
AVG.	3.23	3.18		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.15	4.25		4.09
PULL #2	4.05	4.27		4.27
PULL #3	4.21	4.15		4.20
PULL #4	4.19	4.26		4.14
PULL #5	4.16	4.22		4.33
TOTAL	20.76	21.15		21.03
AVG.	4.15	4.23		4.20

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	5.5			8/2	SF
	G) Safety Off Force	4	4.5	4.5			8/2	SF
	H) Trigger Pull Test & Retainability							
	I) Firing Pin Indent	.0235	.023	.023			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 Clearity of Scope							
645	Inspect for Live Ammo							
655	Final Inspection A) Headspace							
	B) Trigger Pull	2.76	2.79	2.80	2.74	2.72	8/1	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 # C6348927
11 Jan 1900

CENTROIDAL DISTANCES

0	TO	1	.207393
1	TO	2	.107815
1	TO	3	.122319
1	TO	4	.175414
1	TO	5	.365378

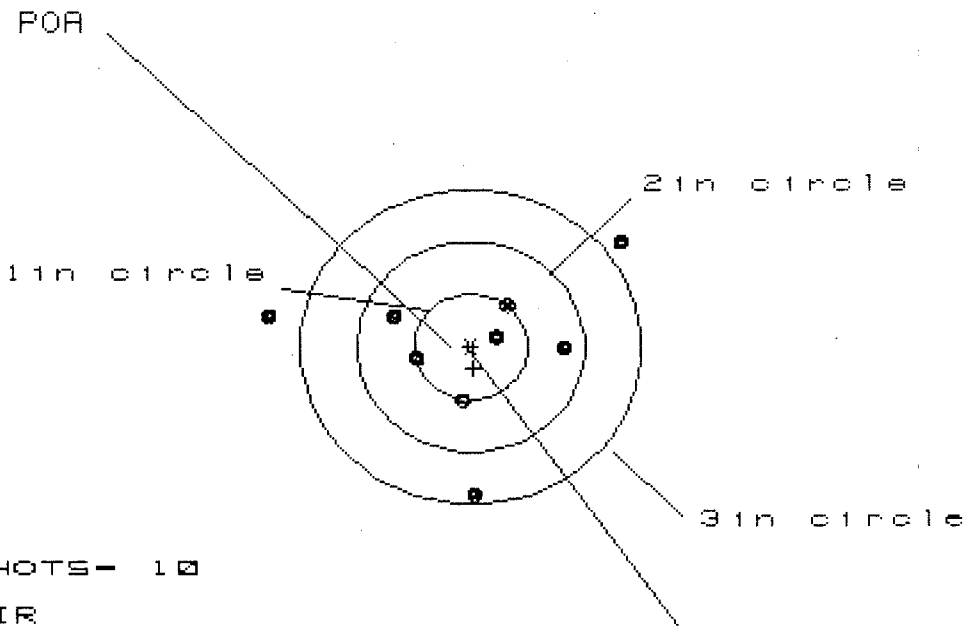
<----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0356
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .139
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .143486

THE AMR FOR THIS RIFLE IS: .969

11 Jan 1900 FILE:/PATTERNING/CENTERFIRE_PATT/C634B927

CENTERFIRE PATTERNS # 1

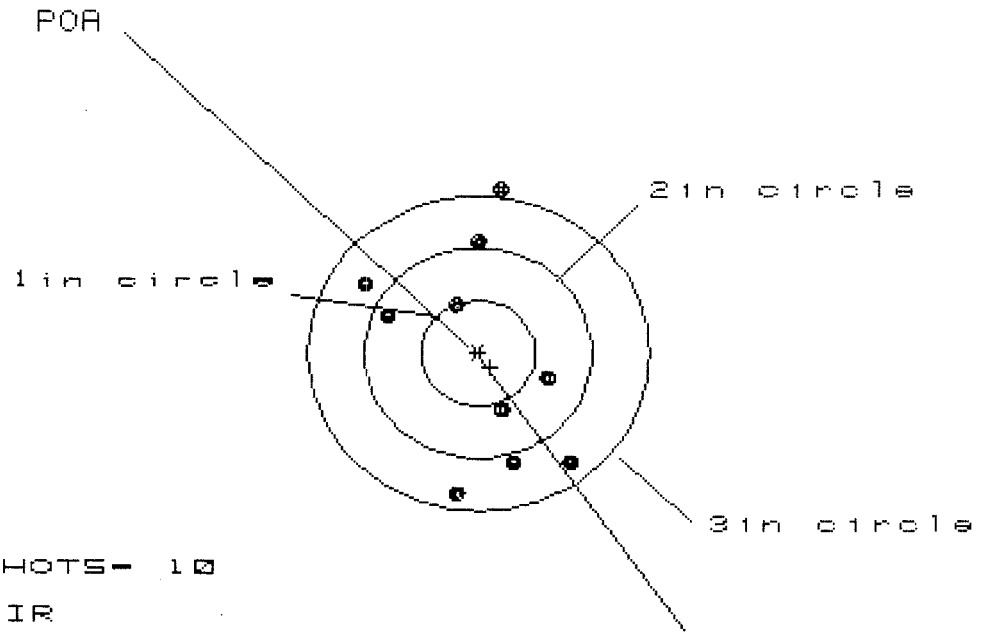


# OF SHOTS= 10
# IN CIR
1in = 2
2in = 7
3in = 8
HS= 3.075
VS= 2.445
GS= 3.165

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.333	1.139	.725
MINIMUM X	:	-1.742	-.902	-.760
MAXIMUM Y	:	1.004	1.032	.552
MINIMUM Y	:	-1.441	-1.413	-1.284
CENTROID X	:	-.024	.170	.028
CENTROID Y	:	.206	.178	.049
POA TO CENTROID in.	:	.208	.246	.056
MIN RADIUS	:	.234	.104	.286
MEAN RADIUS	:	.852	.718	.638
MAX RADIUS	:	1.761	1.537	1.284
HORIZONTAL SPREAD	:	3.075	2.041	1.485
VERTICAL SPREAD	:	2.445	2.445	1.836
EXTREME SPREAD	:	3.165	2.771	1.868
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	7		
NUMBER IN THREE INCH CIRCLE	=	8		

11 Jan 1900 FILE:/PATTERNING/CENTERFIRE_PATT/C634B927

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

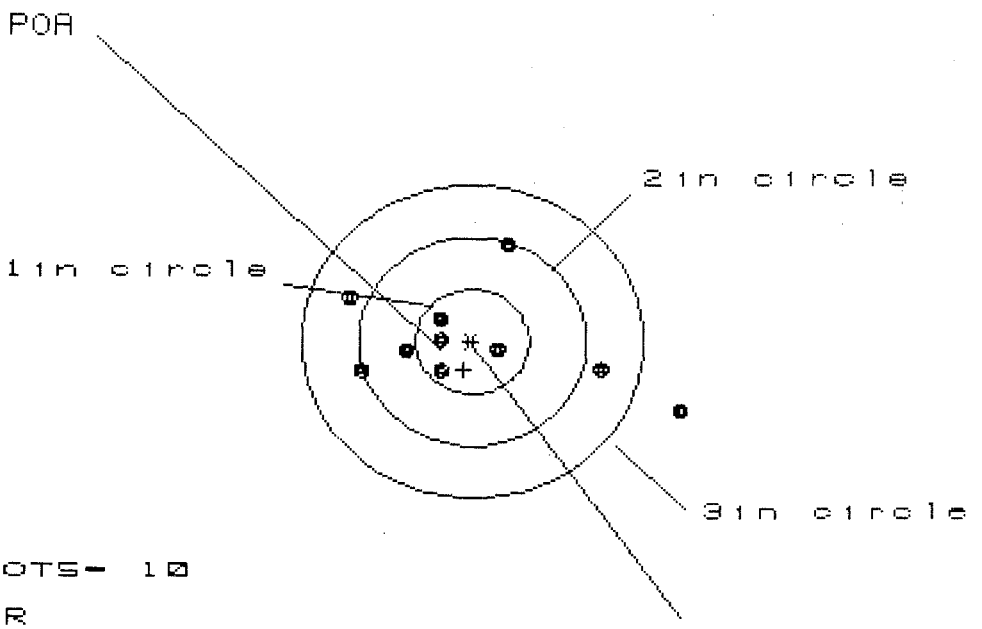
# IN CIR
1in = 1
2in = 4
3in = 9

HS= 1.872
VS= 2.839
GS= 2.869

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.855	.875	.848
MINIMUM X	:	-1.017	-.997	-1.024
MAXIMUM Y	:	1.515	1.279	1.135
MINIMUM Y	:	-1.324	-1.155	-.983
CENTROID X	:	-.106	-.126	-.099
CENTROID Y	:	.136	-.032	.113
POA TO CENTROID in.	:	.173	.130	.150
MIN RADIUS	:	.480	.398	.505
MEAN RADIUS	:	1.009	.939	.903
MAX RADIUS	:	1.526	1.279	1.286
HORIZONTAL SPREAD	:	1.872	1.872	1.872
VERTICAL SPREAD	:	2.839	2.434	2.117
EXTREME SPREAD	:	2.869	2.466	2.466
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		9	

11 Jan 1900 FILE:/PATTERNING/CENTERFIRE_PATT/C634B927

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

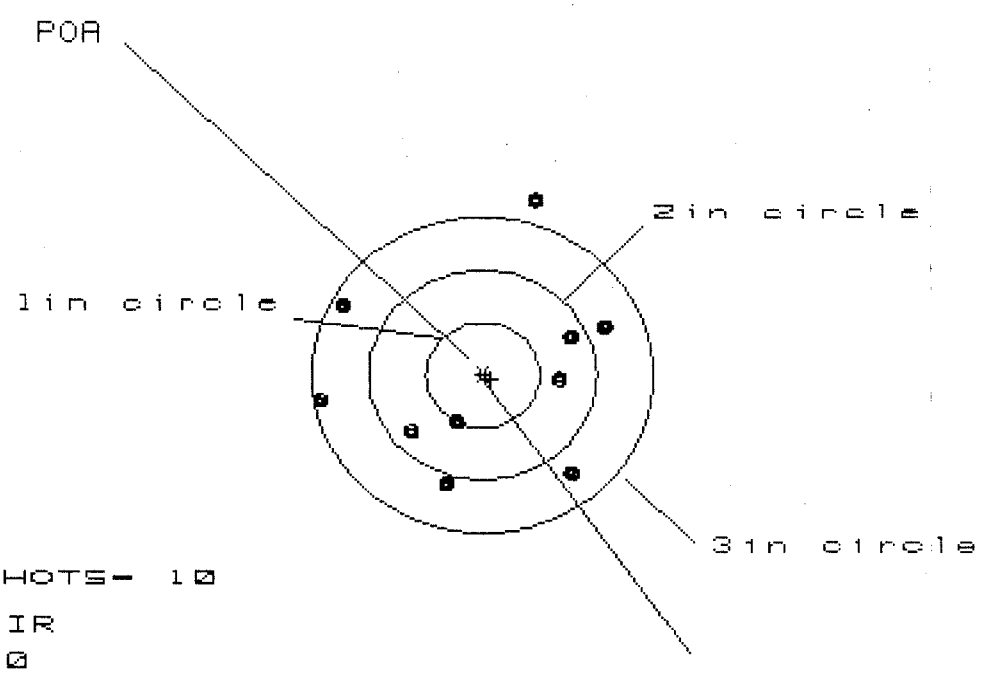
# IN CIR
1in = 4
2in = 6
3in = 9

HS= 2.827
VS= 1.606
GS= 3.040

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.781	1.355	.705
MINIMUM X	:	-1.046	-.848	-.679
MAXIMUM Y	:	.916	.839	.799
MINIMUM Y	:	-.690	-.373	-.413
CENTROID X	:	.077	-.121	-.290
CENTROID Y	:	.275	.352	.392
POA TO CENTROID in.	:	.286	.372	.487
MIN RADIUS	:	.244	.118	.077
MEAN RADIUS	:	.810	.626	.499
MAX RADIUS	:	1.910	1.392	1.066
HORIZONTAL SPREAD	:	2.827	2.203	1.384
VERTICAL SPREAD	:	1.606	1.212	1.212
EXTREME SPREAD	:	3.040	2.302	1.805
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

01 Jan 1900 FILE:/PATTERNING/CENTERFIRE_PATT/C6348927

CENTERFIRE PATTERNS # 4



OF SHOTS= 10

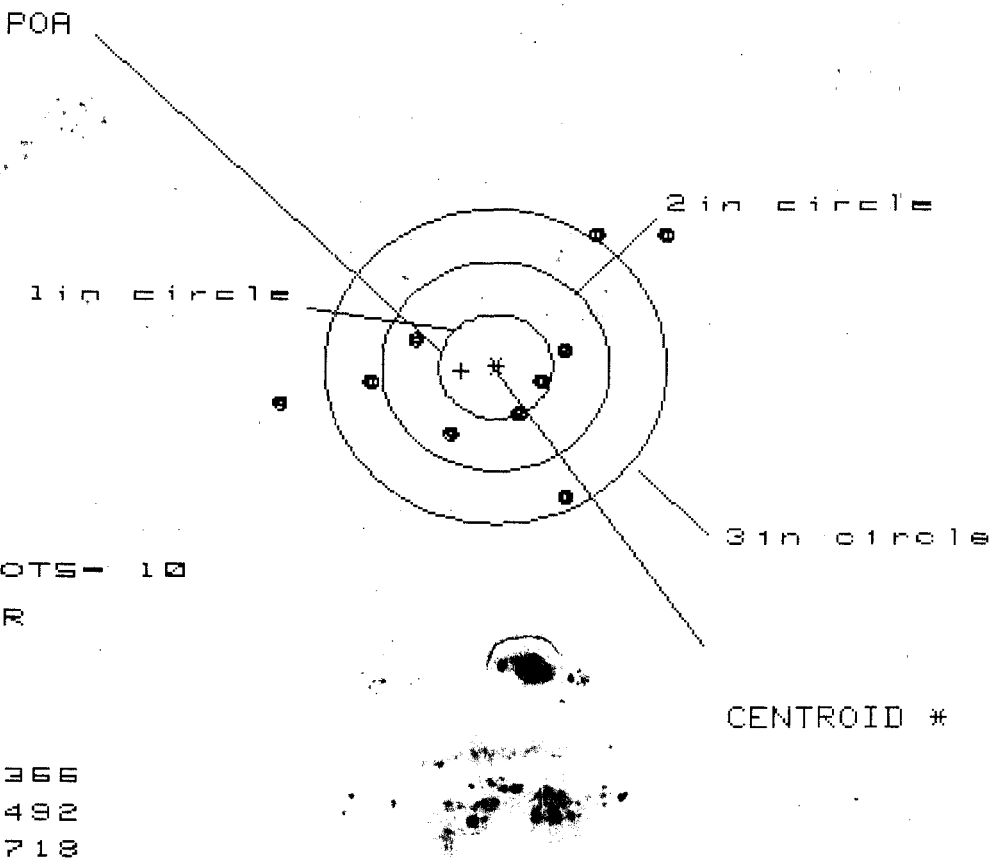
# IN CIR
1in = 0
2in = 4
3in = 9

HS= 2.430
VS= 2.693
GS= 2.798

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.023	1.072	.902
MINIMUM X	:	-1.407	-1.358	-1.301
MAXIMUM Y	:	1.659	.876	.869
MINIMUM Y	:	-1.034	-.849	-.856
CENTROID X	:	-.071	-.120	.050
CENTROID Y	:	.037	-.148	-.141
POA TO CENTROID in.	:	.080	.190	.149
MIN RADIUS	:	.517	.329	.439
MEAN RADIUS	:	1.074	.969	.908
MAX RADIUS	:	1.717	1.430	1.564
HORIZONTAL SPREAD	:	2.430	2.430	2.203
VERTICAL SPREAD	:	2.693	1.725	1.725
EXTREME SPREAD	:	2.798	2.552	2.552
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		9	

11 Jan 1900 FILE:/PATTERNING/CENTERFIRE_PATT/C634B927

CENTERFIRE PATTERNS # 5



OF SHOTS= 10

# IN CIR
1in = 2
2in = 5
3in = 7

HS= 3.366
VS= 2.492
GS= 3.718

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.459	1.247	.884
MINIMUM X	:	-1.907	-1.359	-1.203
MAXIMUM Y	:	1.267	1.231	1.383
MINIMUM Y	:	-1.225	-1.261	-1.109
CENTROID X	:	.302	.514	.358
CENTROID Y	:	.041	.077	-.075
POA TO CENTROID in.	:	.304	.519	.365
MIN RADIUS	:	.423	.268	.326
MEAN RADIUS	:	1.100	.985	.867
MAX RADIUS	:	1.934	1.744	1.642
HORIZONTAL SPREAD	:	3.366	2.606	2.087
VERTICAL SPREAD	:	2.492	2.492	2.492
EXTREME SPREAD	:	3.718	2.978	2.544
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		7	

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6348927

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	7 21	89	RW
600	Proof	7 21	89	RW
607	Check Headspace			RW
610	Dis-assemble Gun			RW
612	Magnaflux Barrel Action	REJECTED	8/15/89	KCK
	Magnaflux Bolt		8/15/89	KCK
615	Rollmark Caliber			
.7	Drill and Tap Sight Holes	8 16	89	
618	Polish Barrel	8 16	89	
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			
	G) Safety Off Force			
	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			
	C) Function			
660	Pack			

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6348927

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		8 24 89	RW
600	Proof		8 24 89	RW
607	Check Headspace		8 24 89	RW
610	Dis-assemble Gun			RW
612	Magnaflux Barrel Action		8/25/89	KCK
	Magnaflux Bolt		8/25/89	KCK
615	Rollmark Caliber			
7	Drill and Tap Sight Holes		8 29 89	JC
618	Polish Barrel RG		8 29 89	BT
620	Apply Coatings (Barrel Action)		9-7-89	TSA
	Apply Coating (Bolt)			TSA
625	Final Assembly A) Clean inside of Bolt Assembly		9/8/89	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		9/8/89	RW
	C) Inspect Ejector Hole for Chamfer		9/8/89	RW
	D) Oil Firing Pin Ass'y		9/8/89	RW
	E) Adjust Trigger Pull to Min Setting and Stake		9-8-89	JC

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5 3/4	6	5 3/4			9/8/89	WB
	G) Safety Off Force	3	3	3			9/8/89	WB
	H) Trigger Pull Test & Retainability						9-8-89	DH
	I) Firing Pin Indent	.021	.0217	.022			9/8/89	WB
	J) Assemble Stock						9/8/89	RW
	K) Assemble Swivel Studs						12 Sep 89	DS
	L) Attach Front and Rear Sight Assemblies						9/8/89	RW
	M) Iron Sight Alignment						9/8/89	RW
	N) Detach Front & Rear Sights & place in numbered container						9/8/89	RW
	O) Attach Scope to Rifle						9/11/89	WB
	P) Detach & Attach Scope 20 Times						9/11/89	WB
640	Gallery Target & Test	95R	56L				9-11-89	DH
	A) Time						9-11-89	DH
	B) Malfunctions						9-11-89	DH
	C) Pierced Primers						9-11-89	DH
	D) Optical Clearity of Scope						9-11-89	DH
645	Inspect for Live Ammo						9-11-89	DH
655	Final Inspection A) Headspace						12 Sep 89	DS
	B) Trigger Pull	2.33	2.30	2.35	2.32	2.22	12 Sep 89	DS
	C) Function						12 Sep 89	DS
660	Pack						18 Dec 89	DS

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

SERIAL NO. C6348927

DATE 3-14-90

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.36	2.26	2.44		MIN. SETTING,
PULL #2	2.54	2.32	2.14		NO AVG. OF 5
PULL #3	2.59	2.15	2.45		READINGS ACCEPT-
PULL #4	2.50	2.59	2.45		ABLE LESS THAN 2#
PULL #5	2.34	2.54	2.29		
TOTAL	12.33	11.86	11.77		
AVG.	2.466	2.372	2.354		

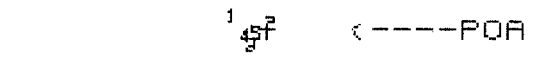
	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.56	3.30		
PULL #2	3.54	3.49		
PULL #3	3.48	3.31		
PULL #4	3.13	3.57		
PULL #5	3.40	3.41		
TOTAL	17.11	17.08		
AVG.	3.422	3.416		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.44	4.30		
PULL #2	4.46	4.46		
PULL #3	4.40	4.57		
PULL #4	4.32	4.45		
PULL #5	4.53	4.35		
TOTAL	22.15	22.13		
AVG.	4.43	4.426		

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6348927
12 Sep 1989

CENTROIDAL DISTANCES

Ø	TO	1	.676885
1	TO	2	.721391
1	TO	3	.635444
1	TO	4	.45062
1	TO	5	.542086

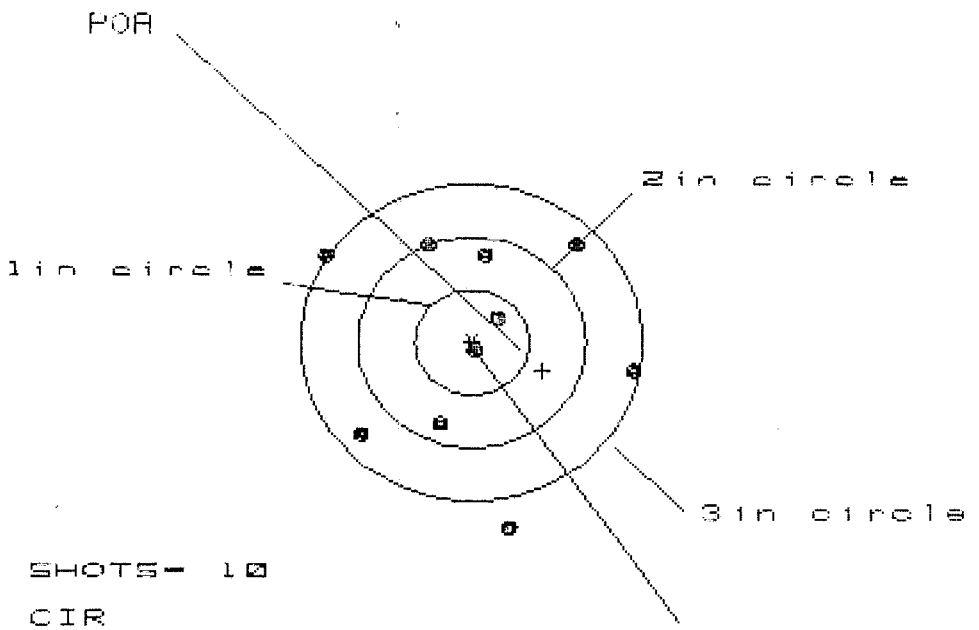


THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.266
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0028
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .266015

THE AMR FOR THIS RIFLE IS: .9722

11 Sep 1989 FILE:/PATTERNING/CENTERFIRE_PATT/CS346927

CENTERFIRE PATTERNS # 1



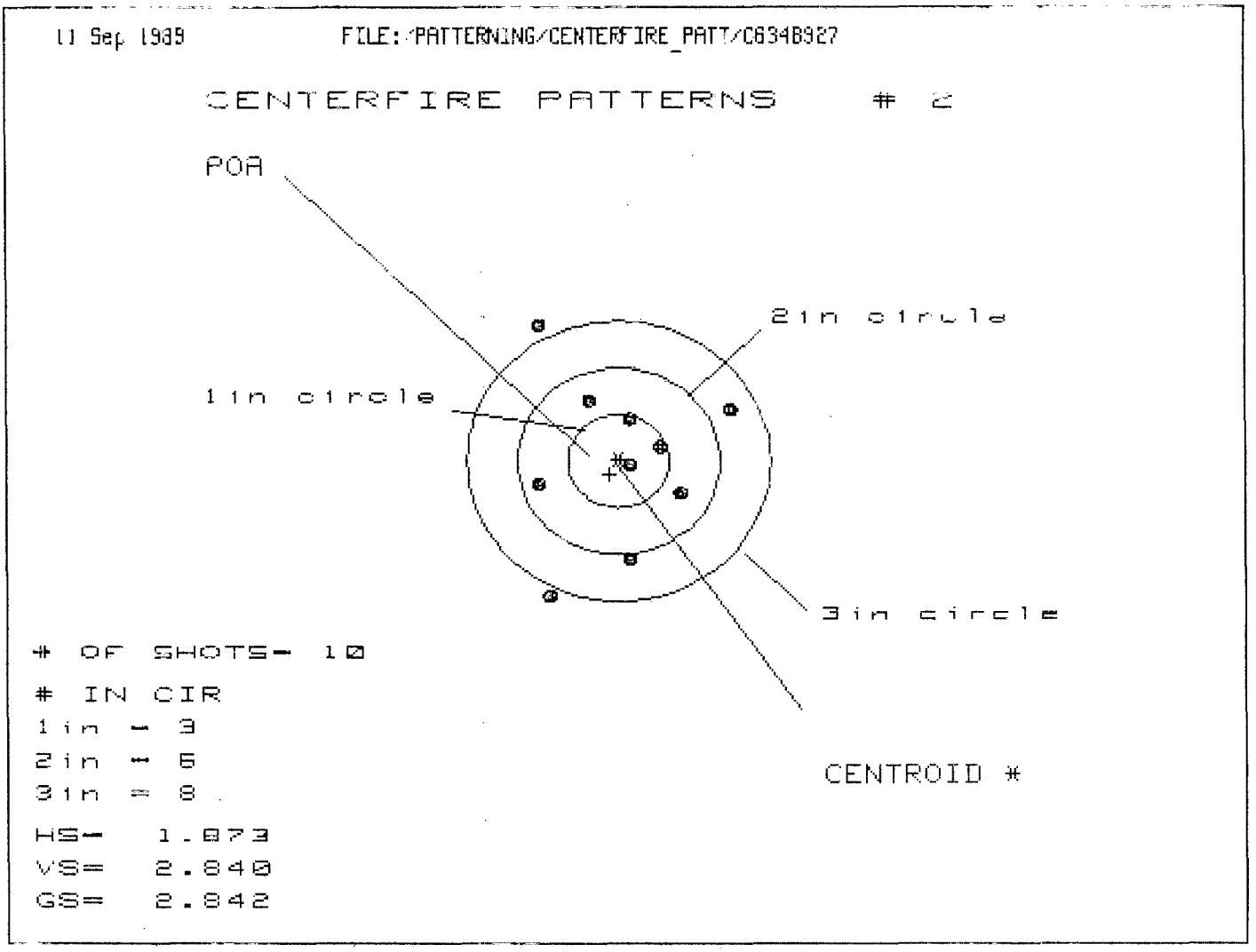
OF SHOTS= 10

# IN CIR
1in = 2
2in = 5
3in = 8

HS= 2.696
VS= 2.678
GS= 3.010

PATTERN # : 1

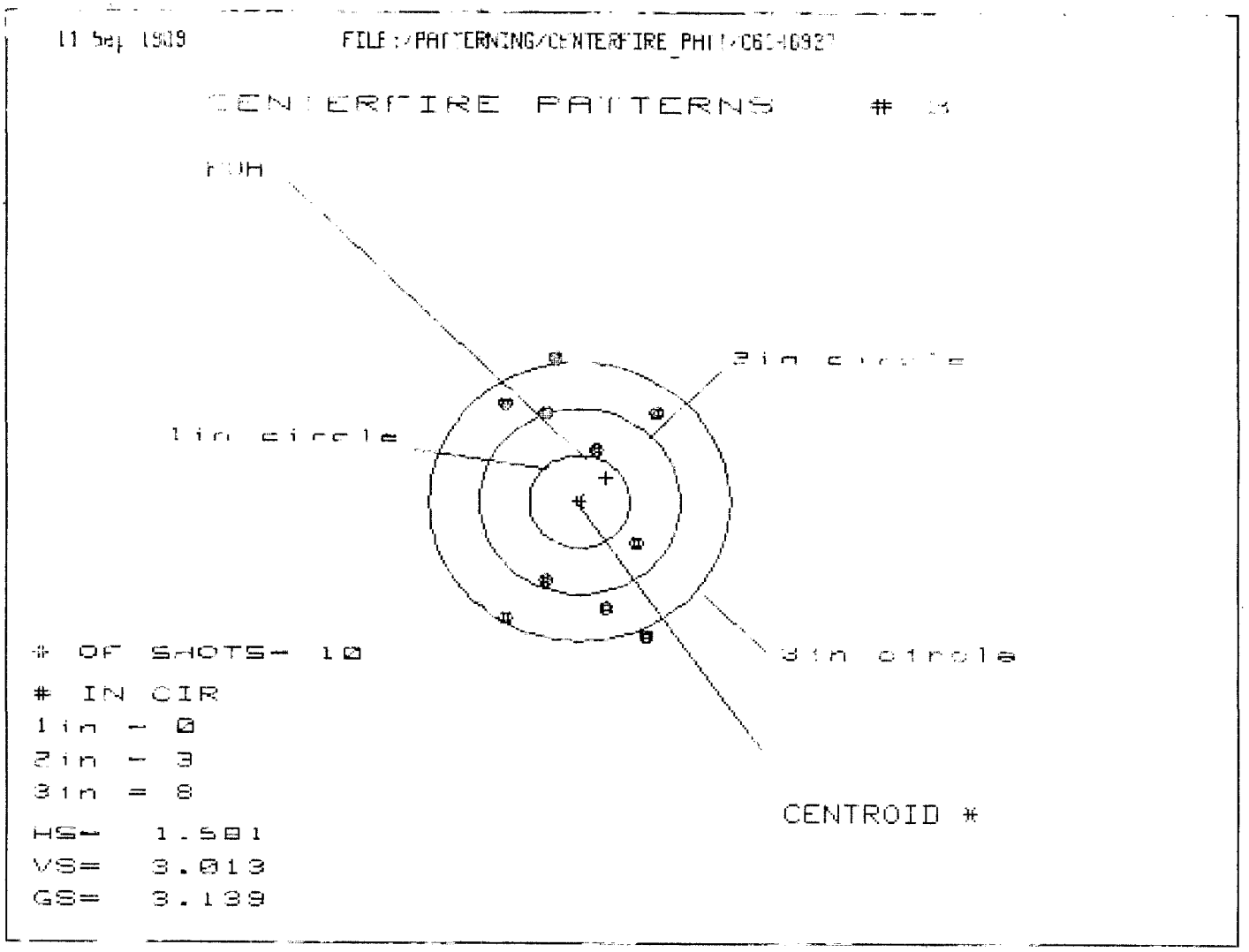
SHOTS (BEST OF) :	10	9	8
MAXIMUM X :	1.431	1.464	1.309
MINIMUM X :	-1.265	-1.232	-1.143
MAXIMUM Y :	.929	.734	.813
MINIMUM Y :	-1.749	-1.018	-.939
CENTROID X :	-.622	-.655	-.500
CENTROID Y :	.267	.462	.383
POA TO CENTROID in.:	.677	.801	.630
MIN RADIUS :	.100	.230	.142
MEAN RADIUS :	1.033	.936	.863
MAX RADIUS :	1.774	1.548	1.480
HORIZONTAL SPREAD :	2.696	2.696	2.453
VERTICAL SPREAD :	2.678	1.752	1.752
EXTREME SPREAD :	3.010	2.925	2.590
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		8	



PATTERN # : 2

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.104	1.020	.928
MINIMUM X	-.769	-.853	-.945
MAXIMUM Y	1.437	.785	.629
MINIMUM Y	-1.403	-1.243	-1.032
CENTROID X	.089	.173	.265
CENTROID Y	.145	-.015	.141
POA TO CENTROID in.	.170	.174	.300
MIN RADIUS	.098	.091	.127
MEAN RADIUS	.866	.778	.663
MAX RADIUS	1.626	1.445	1.081
HORIZONTAL SPREAD	1.873	1.873	1.873
VERTICAL SPREAD	2.840	2.028	1.661
EXTREME SPREAD	2.842	2.626	2.053

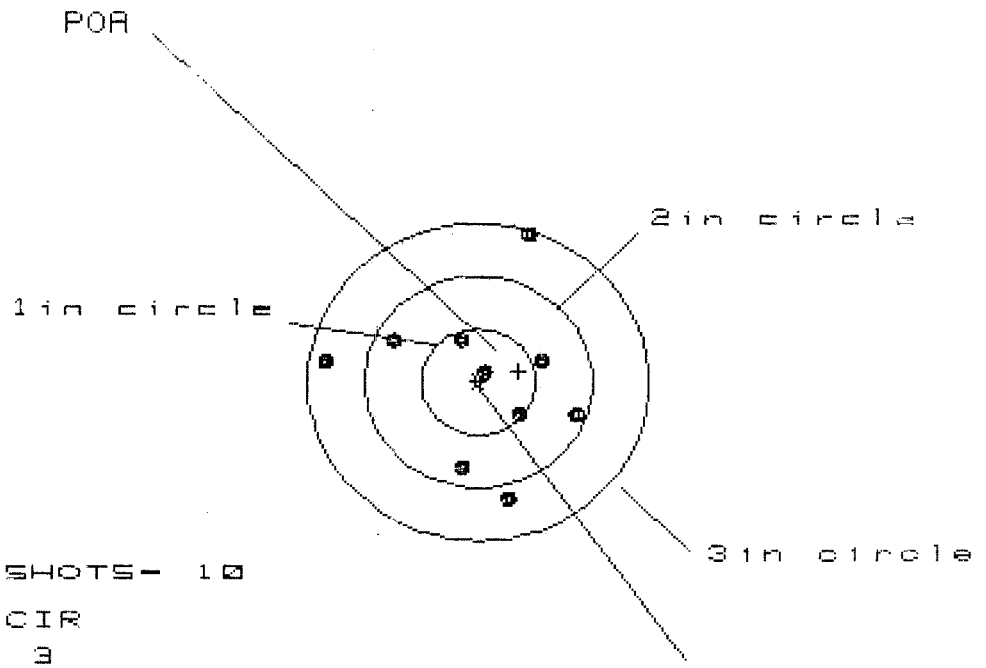
NUMBER IN ONE INCH CIRCLE = 3
NUMBER IN TWO INCH CIRCLE = 6
NUMBER IN THREE INCH CIRCLE = 8



PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.799	.870	.849
MINIMUM X	:	-.782	-.711	-.732
MAXIMUM Y	:	1.535	1.371	1.104
MINIMUM Y	:	-1.478	-1.397	-1.225
CENTROID X	:	-.264	-.335	-.314
CENTROID Y	:	-.258	-.094	-.266
POA TO CENTROID in.	:	.369	.348	.411
MIN RADIUS	:	.613	.482	.634
MEAN RADIUS	:	1.159	1.094	1.055
MAX RADIUS	:	1.610	1.529	1.383
HORIZONTAL SPREAD	:	1.581	1.581	1.581
VERTICAL SPREAD	:	3.013	2.768	2.329
EXTREME SPREAD	:	3.139	2.805	2.684
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		8	

11 Sep 1989 FILE:/PATTERNING/CENTERFIRE_PATT/C634B927

CENTERFIRE PATTERNS # 4

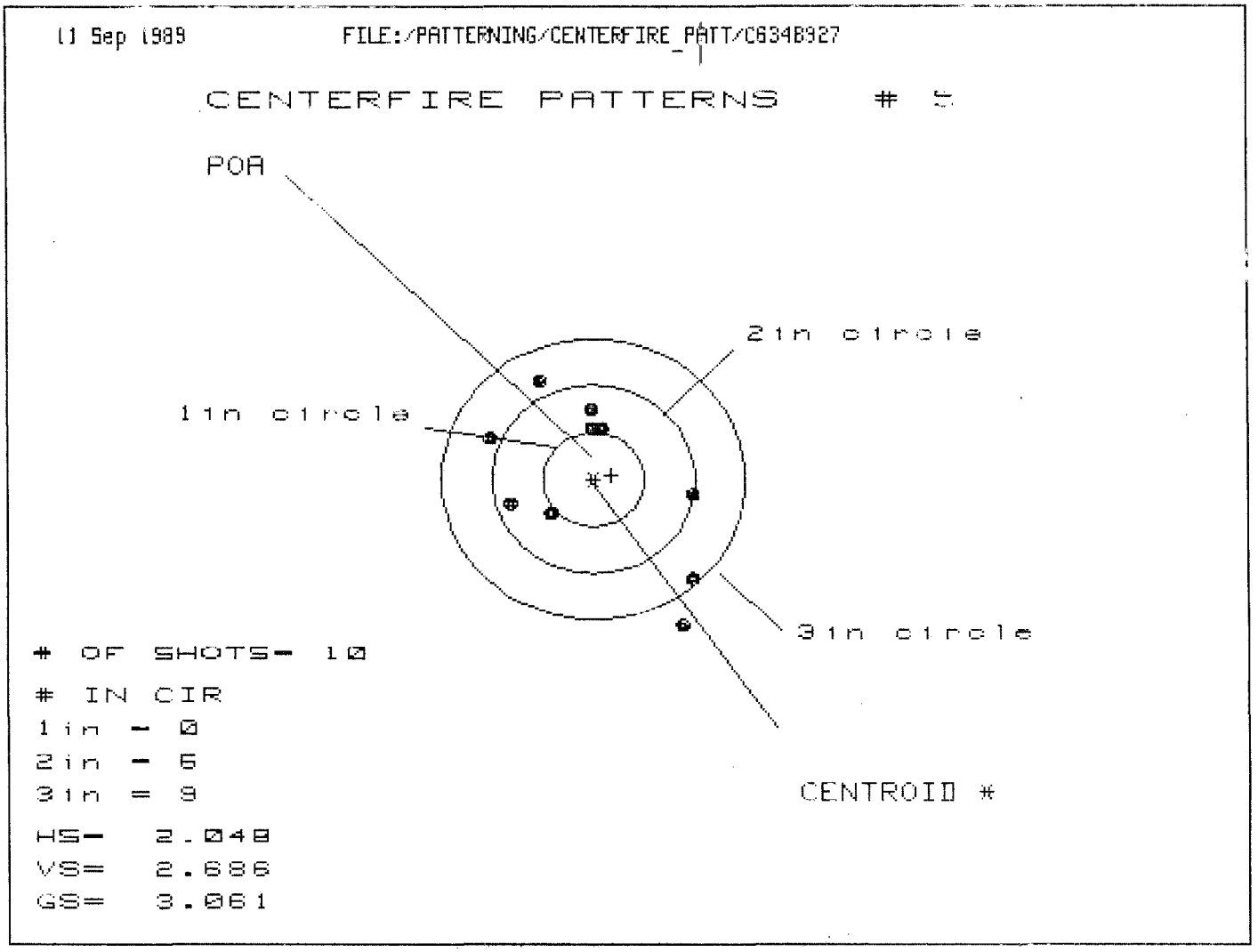


OF SHOTS= 10

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

HS= 2.230
VS= 2.470
GS= 2.478

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.884	.931	.768
MINIMUM X	:	-1.346	-1.299	-.899
MAXIMUM Y	:	1.376	.557	.596
MINIMUM Y	:	-1.094	-.941	-.901
CENTROID X	:	-.355	-.402	-.239
CENTROID Y	:	-.096	-.249	-.288
POA TO CENTROID in.	:	.368	.473	.375
MIN RADIUS	:	.124	.268	.250
MEAN RADIUS	:	.819	.756	.653
MAX RADIUS	:	1.439	1.338	1.079
HORIZONTAL SPREAD	:	2.230	2.230	1.667
VERTICAL SPREAD	:	2.470	1.498	1.498
EXTREME SPREAD	:	2.478	2.286	1.823
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	



PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.010	1.110	1.220
MINIMUM X	:	-1.038	-.938	-.799
MAXIMUM Y	:	1.087	.910	.754
MINIMUM Y	:	-1.599	-1.249	-.647
CENTROID X	:	-.178	-.278	-.417
CENTROID Y	:	-.044	.133	.289
POA TO CENTROID in.	:	.183	.308	.507
MIN RADIUS	:	.501	.323	.245
MEAN RADIUS	:	.984	.835	.686
MAX RADIUS	:	1.835	1.671	1.309
HORIZONTAL SPREAD	:	2.048	2.048	2.019
VERTICAL SPREAD	:	2.686	2.159	1.401
EXTREME SPREAD	:	3.061	2.673	2.109
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	