

C6348945

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5716**

\*Includes 1 ln chamber.

*Remington*



## RECORDS CONTROL SCHEDULE

RECORDS CATEGORY OR TITLE:

872 - SUBSTANTIATION OF ENTERTAINMENT

EXPENSES

COPY "O" (OFFICIAL) ☒ "X" (EXTRA) ☐

TOTAL RETENTION: UNTIL SUPERSEDED

OR OBSOLETE

GS-11050 Rev. 8/78

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER  
KINZER V. REMINGTON

M2400042305

10/30/08 12:42:31

## Arms Services Repair &amp; Estimate System

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

## Repair Inquiry

Repair Number: RE00154256

Serial: C6348945 Model M24 SWS Center Fire  
Caliber: 7.62 NATO

Repairman:

Status: Closed 10/30/2008 8:24:25 AM

Verify Repair

## Address Information

Customer:

☒ Received From

Return To:

☐ Received From

Name: ISD ARMSROOM

ISD ARMSROOM

Address 1: 8TH DESERT STORM

8TH DESERT STORM

Address 2: BLDG 5210 BAY DOOR #30

PO Box:

BLDG 5210 BAY DOOR #30

PO Box:

City: FORT CAMPBELL

FORT CAMPBELL

State: KY

Zip Code: 42223

Country: US

State: KY

Zip Code: 42223

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   |
| A026 | Scope                 | 1   |
| A045 | Bi Pod                | 1   |
| A057 | Fit and Rear Sgt Base | 1   |
| D000 | MARS RAIL             | 1   |

## Repair Search

Refresh

Close

[naglet]

10/30/2008

12:42 PM

CAPS

NUM

INS

SCRL



Serial Number: C6348945

Model: M24 SWS



RE00154256

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

R & E NUMBER

154256

SERIAL NUMBER

C6348945

LOG-IN DATE

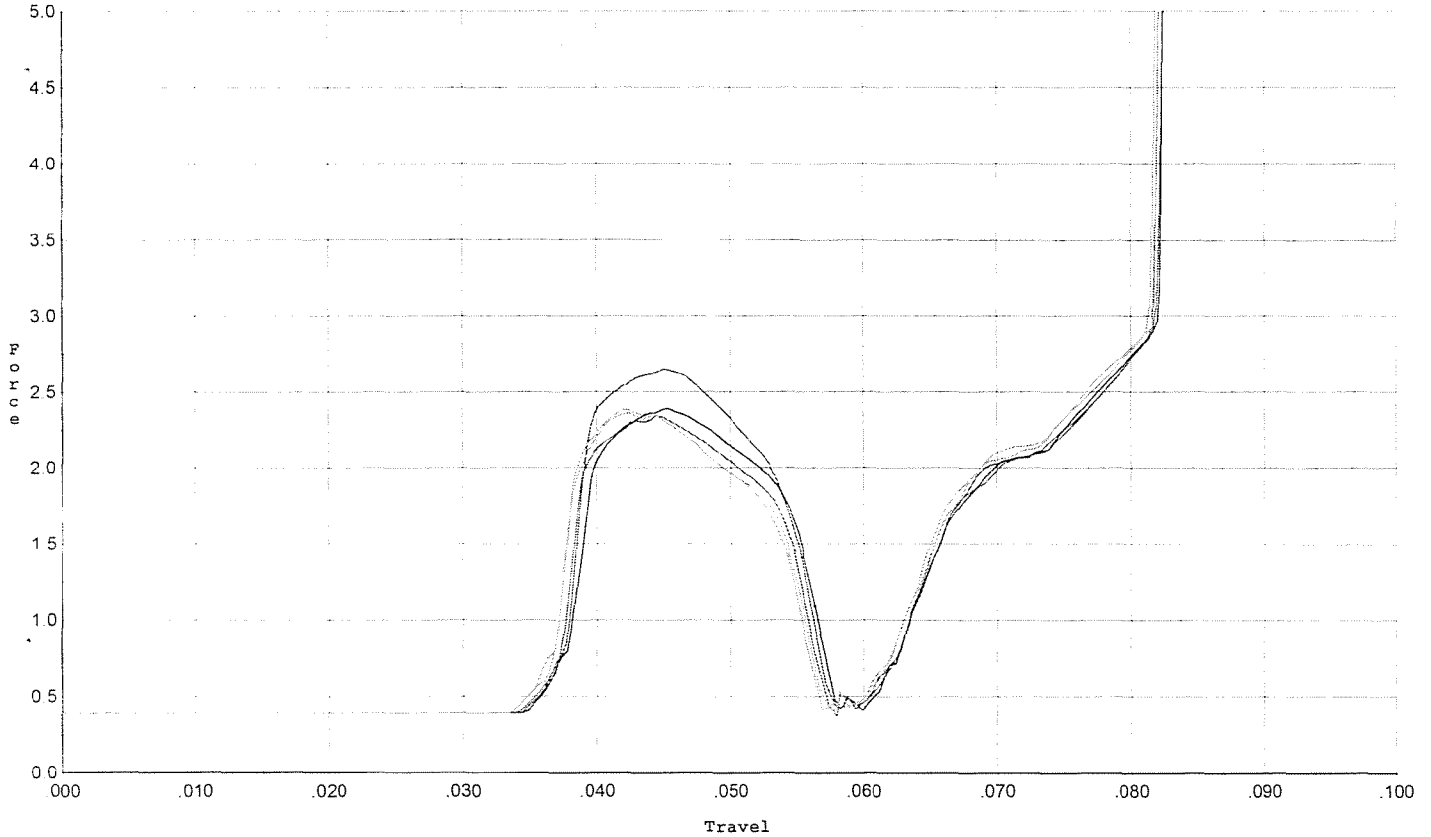
10-30-08

| OPERATION # | OPERATION NAME       | DATE                | INITIAL    |
|-------------|----------------------|---------------------|------------|
| 500         | DIS-ASSEMBLE GUN     | 11-5-08             | RTZ        |
| 505         | RE-BARREL            | 11-12-08            | RTZ        |
| 560         | ASSEMBLE             | 11-12-08            | RTZ        |
| 600         | PROOF                | 11-11-08            | SPD        |
| 605         | CHECK HEADSPACE      | 11-11-08            | SPD        |
| 610         | DIS-ASSEMBLE GUN     | 11-11-08            | SPD        |
| 612         | MAGNAFLUX            | 11-17-08            | SP         |
| 510         | DRILL AND TAP        | 11-12-08            | SP         |
| 615         | ROLLMARK CALIBER     | 11/17/08            | RT         |
| 618         | ROTO-BLAST           |                     |            |
| 620         | APPLY COATINGS       | 11-21               |            |
| 625         | FINAL ASSEMBLY       | 12-2-08             | RTZ        |
| 640         | FUNCTION TEST AND    | 12-4-08             | SPD        |
| 650         | TARGET               | 12-4-08             | SPD        |
|             | MALFUNCTION          | CORRECTION          |            |
|             | MALFUNCTION          | CORRECTION          |            |
|             | MALFUNCTION          | CORRECTION          |            |
|             | MALFUNCTION          | CORRECTION          |            |
| 670         | FINAL INSPECTION     | 12-5-08             | SP         |
|             | A) HEADSPACE         | PASS                | FAIL       |
|             | B) TRIGGER PULL      | 264 271 271 265 268 | 12-5-08 SP |
| 680         | F) SAFETY ON FORCE   | 3.0 4.0 4.0         | 12-5-08 SP |
|             | G) SAFETY OFF FORCE  | 4.0 5.0 5.0         | 12-5-08 SP |
|             | I) FIRING PIN INDENT | .021 .021 .021      | 12-5-08 SP |
| 690         | PACK                 |                     | 4/3/09 Fm  |

# Trigger Profile [ lbs,inch ]

Profile: SWS  
 GunType: Rifle  
 Make: Remington  
 Note: C Schults 10/30/2008

Model: M/24  
 Serial No: Form #F005  
 Trigger: 2.5 lbs ini +/- .50 lbs



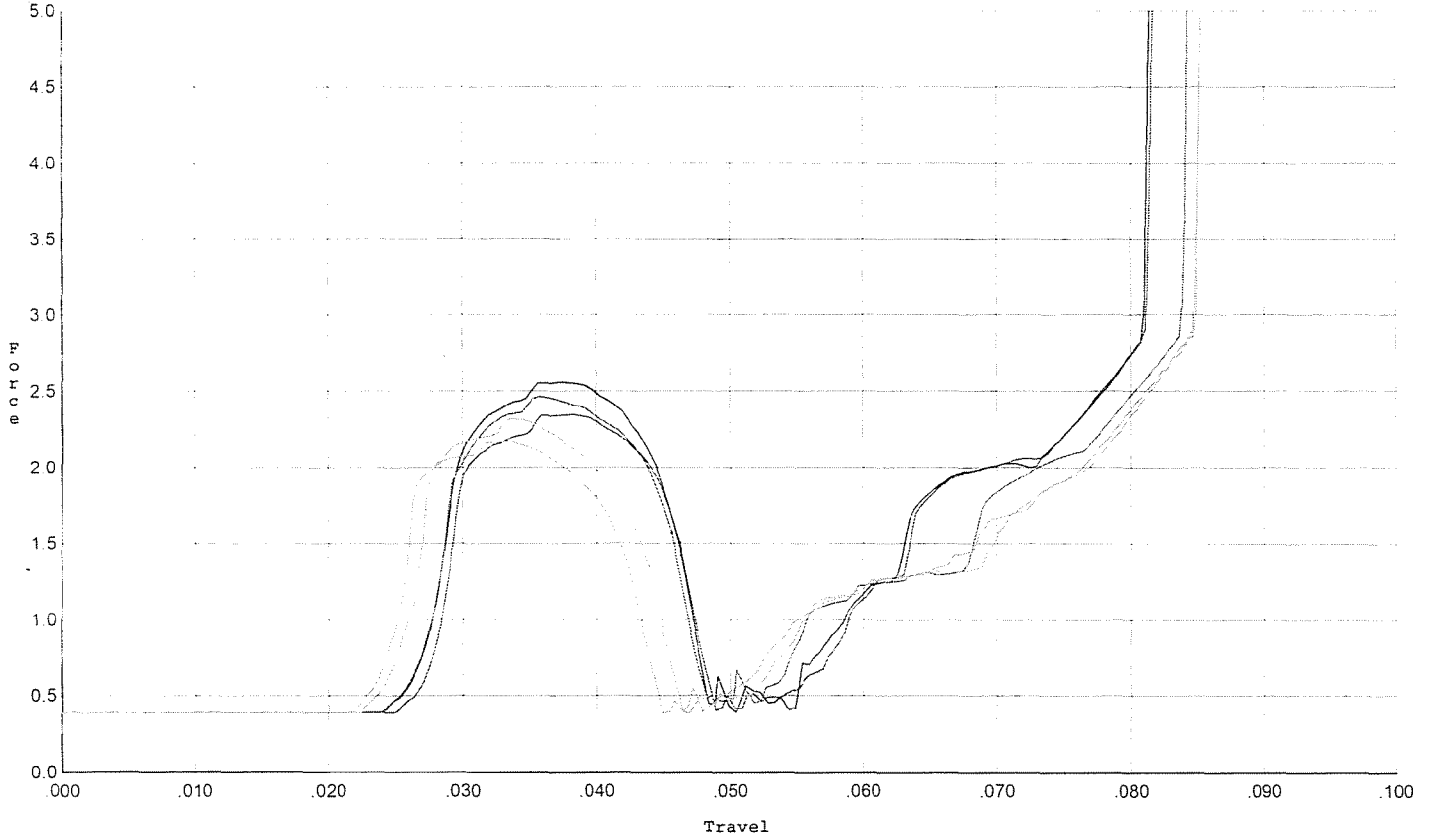
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.650      | 0.055             | 0.036           | 0.034      | 0.055             |           | Set Trigger |
| 2 | 2.387      | 0.056             | 0.037           | 0.033      | 0.053             |           | Set Trigger |
| 3 | 2.342      | 0.055             | 0.037           | 0.034      | 0.051             |           | Set Trigger |
| 4 | 2.358      | 0.055             | 0.036           | 0.034      | 0.051             |           | Set Trigger |
| 5 | 2.380      | 0.054             | 0.036           | 0.034      | 0.051             |           | Set Trigger |

A-242

# Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: C Schults 10/30/2008

Model: M/24  
Serial No: Form #F005  
Trigger: 2.5 lbs after 50 cycles+/- .50 lbs



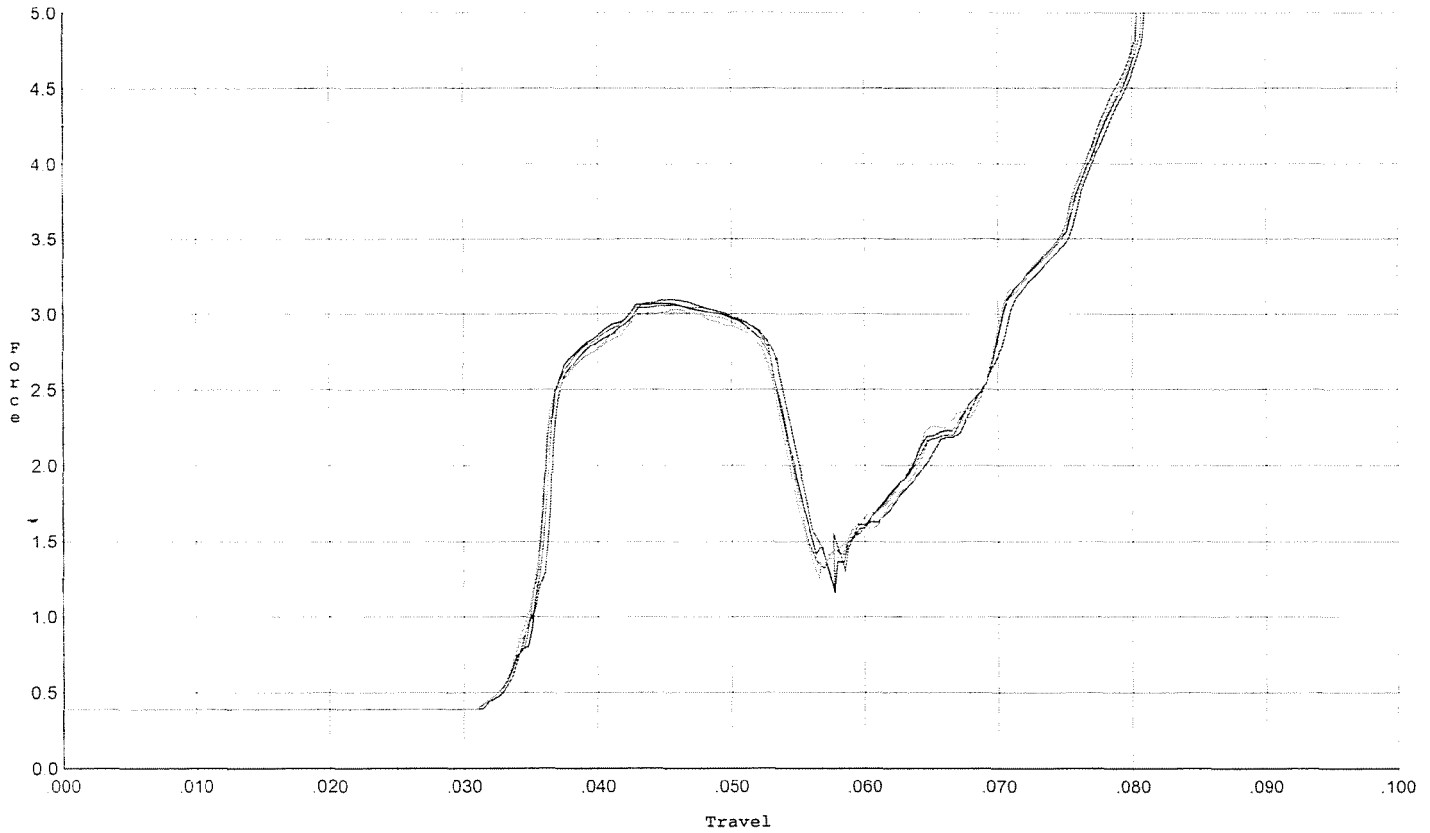
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.346      | 0.046             | 0.027           | 0.039      | 0.049             |           | Set Trigger |
| 2 | 2.558      | 0.046             | 0.026           | 0.039      | 0.053             |           | Set Trigger |
| 3 | 2.468      | 0.046             | 0.026           | 0.043      | 0.050             |           | Set Trigger |
| 4 | 2.320      | 0.044             | 0.025           | 0.048      | 0.047             |           | Set Trigger |
| 5 | 2.169      | 0.042             | 0.024           | 0.050      | 0.044             |           | Set Trigger |

A 2.37

# Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: C Schults 10/30/2008

Model: M/24  
Serial No: Form #F005  
Trigger: 3.0 lbs ini +/- .75 lbs



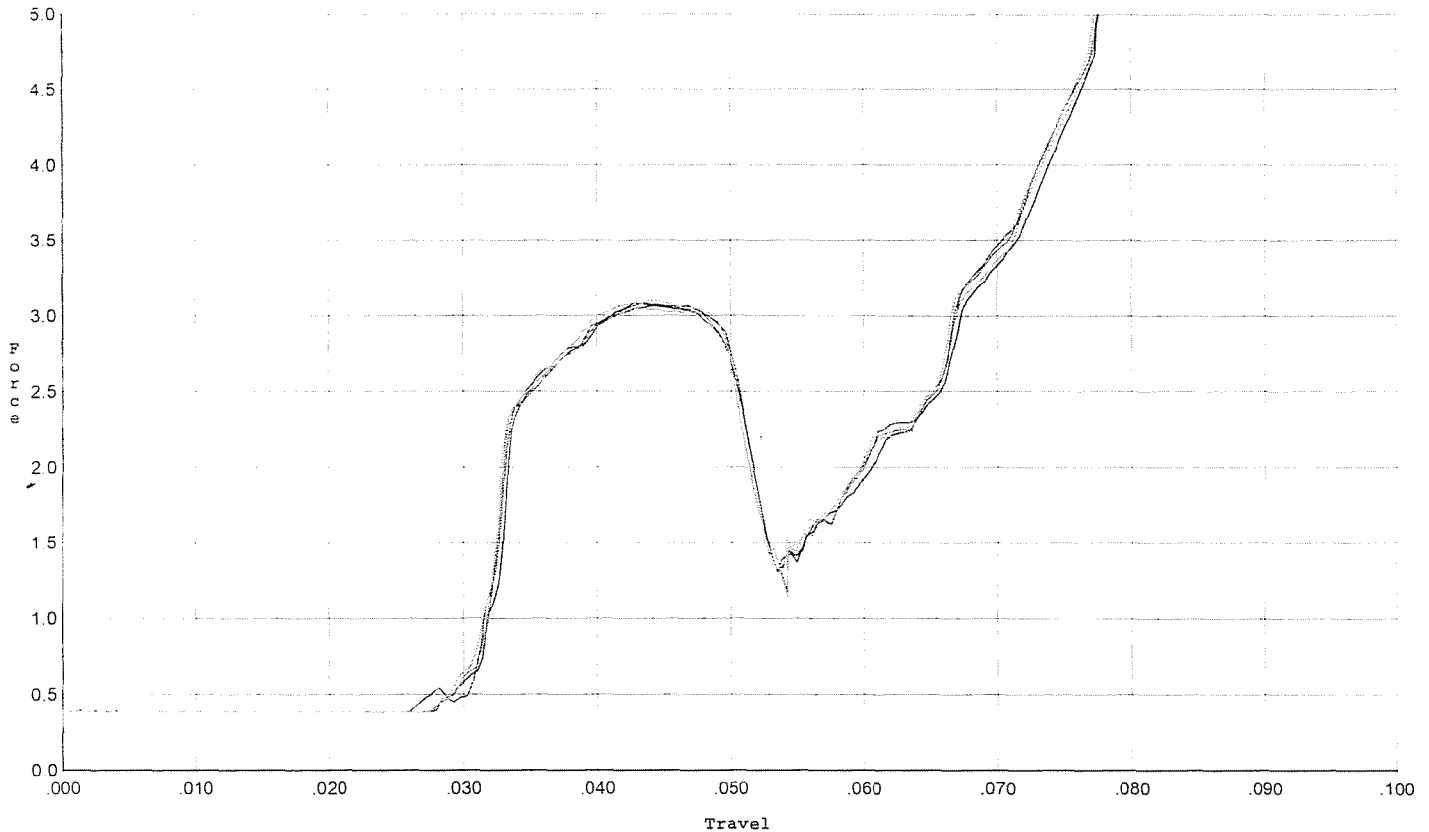
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 3.099      | 0.053             | 0.034           | 0.032      | 0.067             |           | Set Trigger |
| 2 | 3.073      | 0.054             | 0.034           | 0.032      | 0.068             |           | Set Trigger |
| 3 | 3.060      | 0.054             | 0.033           | 0.032      | 0.068             |           | Set Trigger |
| 4 | 3.016      | 0.054             | 0.033           | 0.032      | 0.067             |           | Set Trigger |
| 5 | 3.036      | 0.053             | 0.033           | 0.032      | 0.066             |           | Set Trigger |

A-3.05

# Trigger Profile [ lbs,inch ]

Profile SWS  
 GunType: Rifle  
 Make: Remington  
 Note: C Schults 10/30/2008

Model: M/24  
 Serial No: Form #F005  
 Trigger: 3.0 lbs after 20 cycles+/- .75 lbs



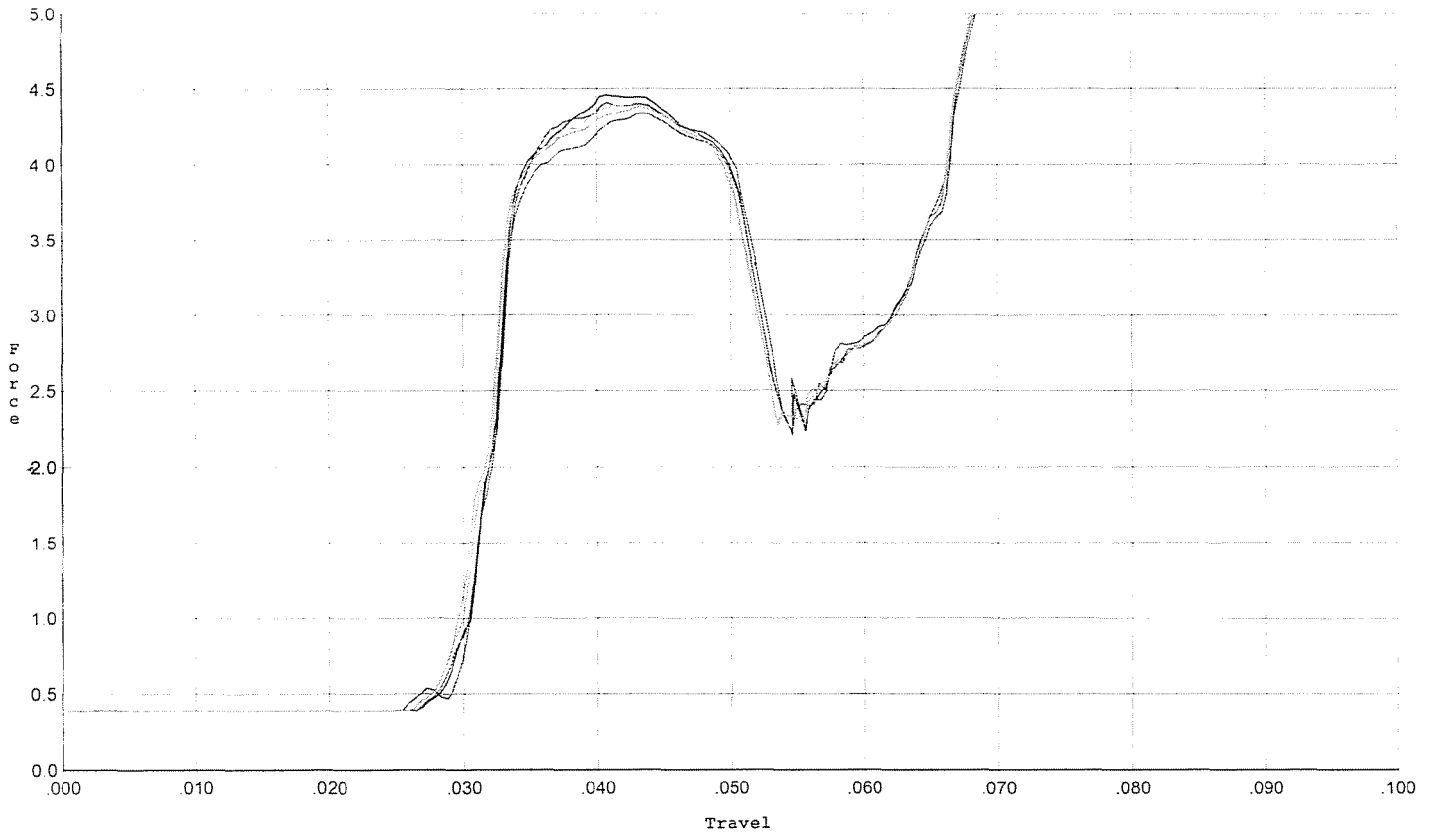
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 3.071      | 0.051             | 0.031           | 0.031      | 0.066             |           | Set Trigger |
| 2 | 3.085      | 0.051             | 0.031           | 0.031      | 0.065             |           | Set Trigger |
| 3 | 3.083      | 0.050             | 0.030           | 0.032      | 0.064             |           | Set Trigger |
| 4 | 3.104      | 0.050             | 0.030           | 0.031      | 0.065             |           | Set Trigger |
| 5 | 3.057      | 0.050             | 0.030           | 0.032      | 0.064             |           | Set Trigger |

A 3.08

## Trigger Profile [ lbs,inch ]

**Profile:** SWS  
**GunType:** Rifle  
**Make:** Remington  
**Note:** C Schults 10/30/2008

**Model:** M/24  
**Serial No:** Form #F005  
**Trigger:** 4.0 lbs ini +/- 1.0 lb



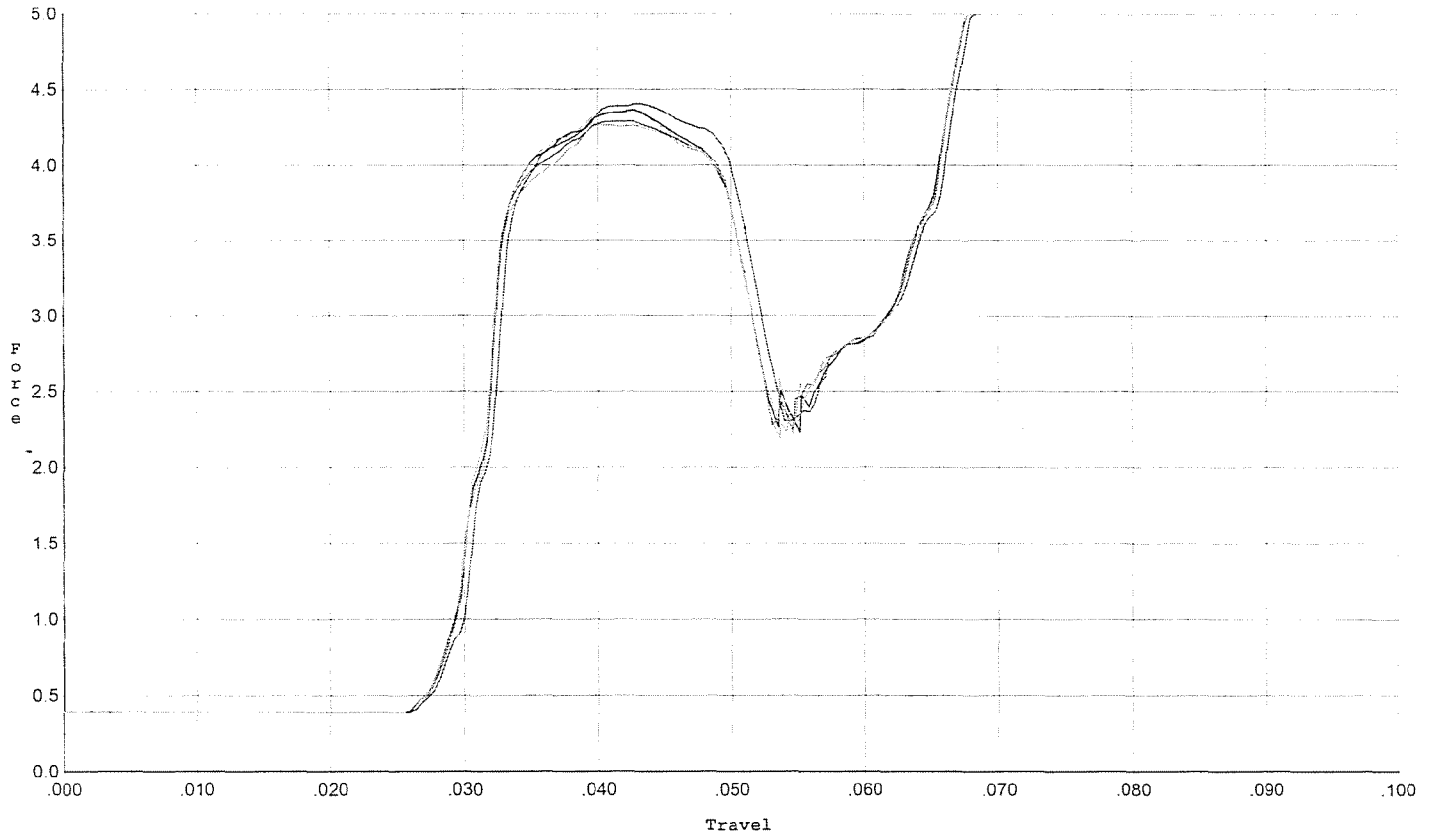
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 4.411      | 0.052             | 0.029           | 0.022      | 0.096             |           | Set Trigger |
| 2 | 4.459      | 0.051             | 0.029           | 0.022      | 0.094             |           | Set Trigger |
| 3 | 4.340      | 0.051             | 0.029           | 0.023      | 0.092             |           | Set Trigger |
| 4 | 4.411      | 0.051             | 0.028           | 0.022      | 0.095             |           | Set Trigger |
| 5 | 4.382      | 0.052             | 0.028           | 0.022      | 0.096             |           | Set Trigger |

A-4.40

# Trigger Profile [ lbs,inch ]

Profile SWS  
 GunType: Rifle  
 Make: Remington  
 Note: C Schults 10/30/2008

Model: M/24  
 Serial No: Form #F005  
 Trigger: 4.0 lbs after 20 cycles+/- 1.0 lb



| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 4.406      | 0.051             | 0.028           | 0.022      | 0.095             |           | Set Trigger |
| 2 | 4.364      | 0.051             | 0.028           | 0.022      | 0.094             |           | Set Trigger |
| 3 | 4.293      | 0.051             | 0.028           | 0.022      | 0.094             |           | Set Trigger |
| 4 | 4.359      | 0.051             | 0.028           | 0.022      | 0.095             |           | Set Trigger |
| 5 | 4.268      | 0.051             | 0.028           | 0.022      | 0.093             |           | Set Trigger |

14-4.33

Trigger Scan 2.01 ,SN 10337, printed by Remington Arms Co., Inc.. 10/30/2008 2:03:01 PM

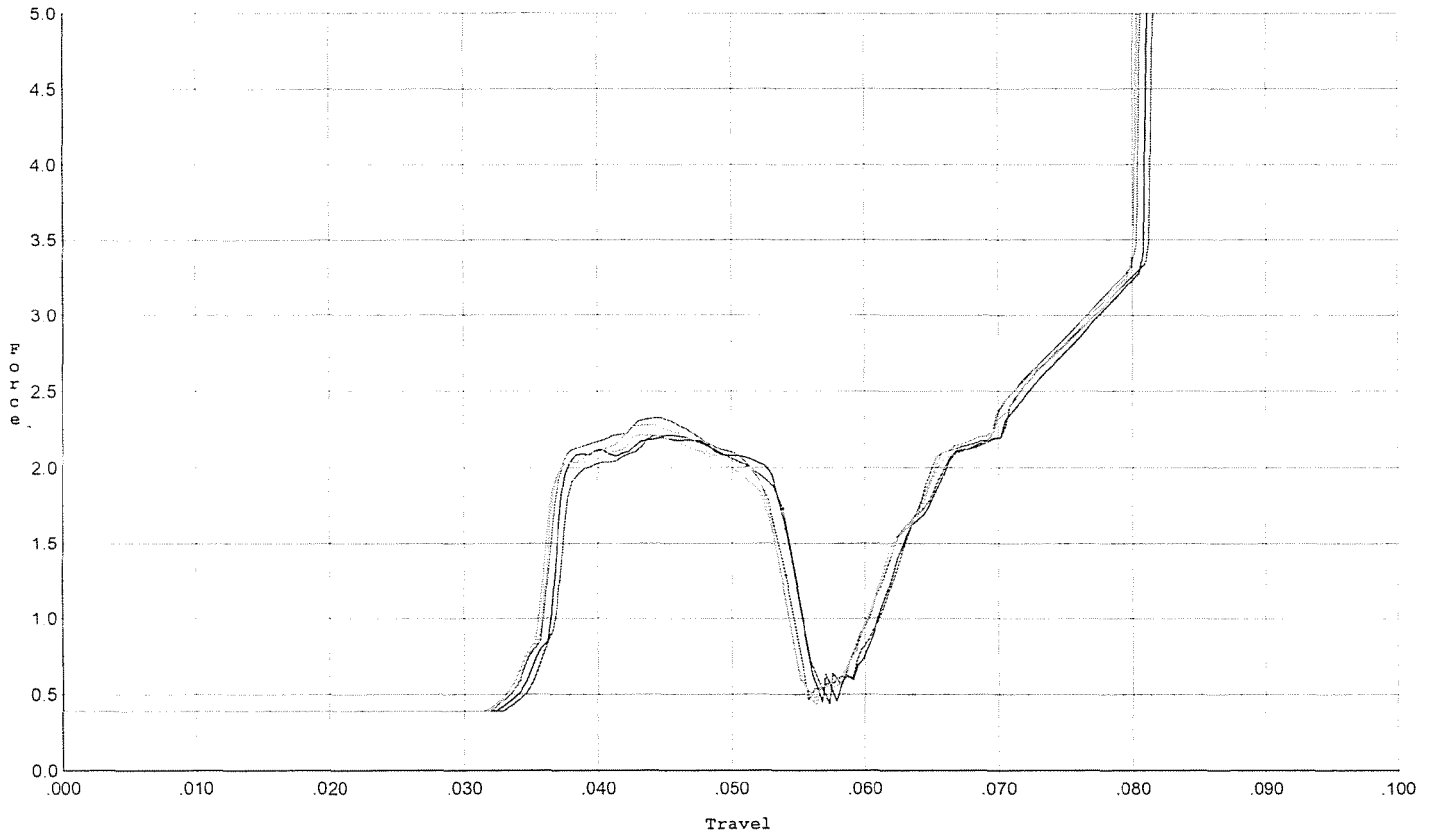
**CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER  
 KINZER V. REMINGTON**

**M2400042313**

# Trigger Profile [ lbs,inch ]

Profile: SWS  
 GunType: Rifle  
 Make: Remington  
 Note: C Schults 10/30/2008

Model: M/24  
 Serial No: Form #F005  
 Trigger: reset to 2.5 lbs +/- .50 lbs for final test



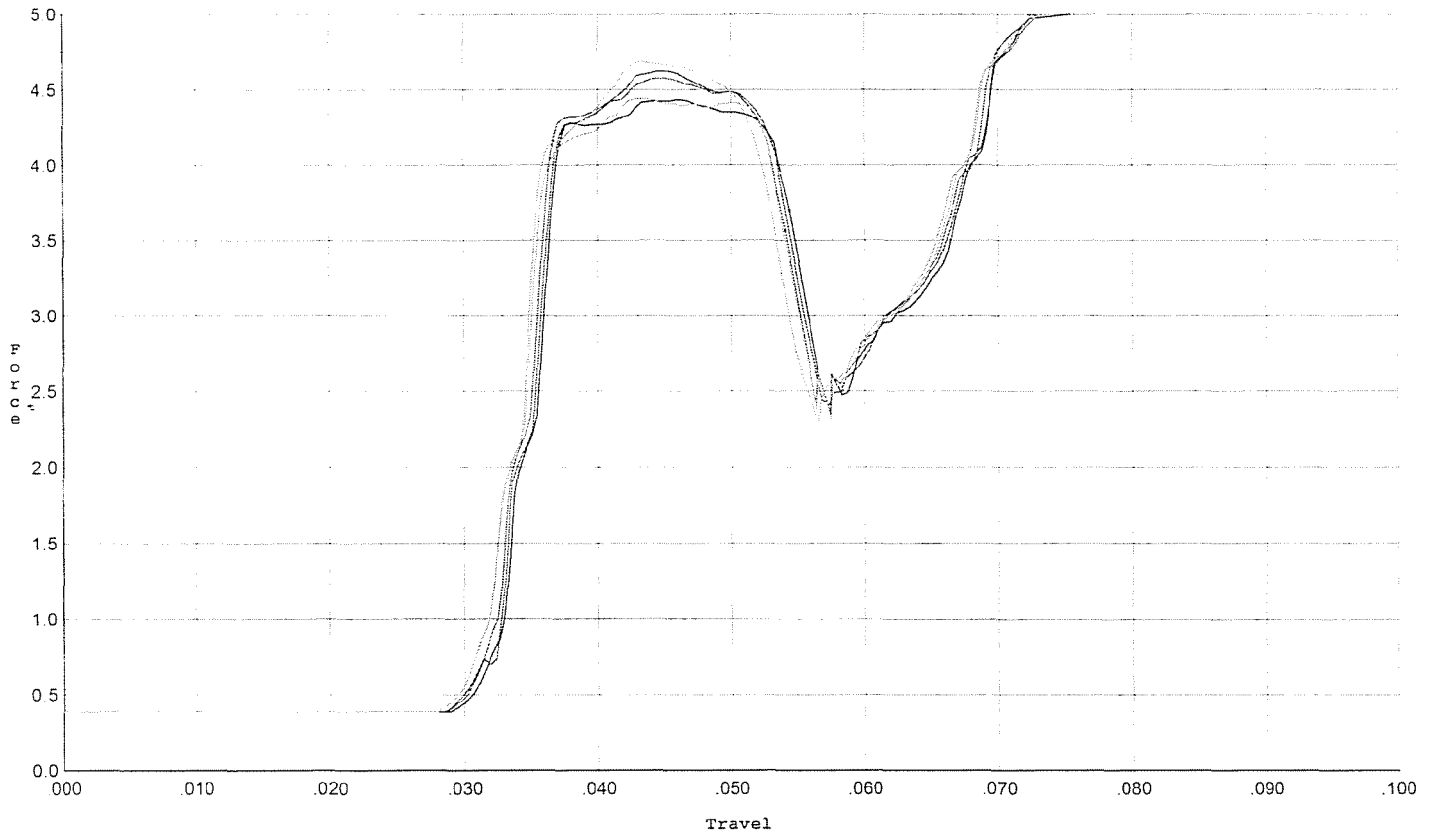
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.212      | 0.054             | 0.035           | 0.034      | 0.050             |           | Set Trigger |
| 2 | 2.197      | 0.054             | 0.035           | 0.033      | 0.051             |           | Set Trigger |
| 3 | 2.328      | 0.054             | 0.034           | 0.033      | 0.052             |           | Set Trigger |
| 4 | 2.215      | 0.053             | 0.034           | 0.034      | 0.050             |           | Set Trigger |
| 5 | 2.282      | 0.053             | 0.034           | 0.034      | 0.051             |           | Set Trigger |

A-2-24

## Trigger Profile [ lbs,inch ]

Profile: SWS  
 GunType: Rifle  
 Make: Remington  
 Note: C Schults 10/30/2008

Model: M/24  
 Serial No: Form #F005  
 Trigger: set to 4.0 lbs +/- 1.0 lbs for target & accuracy



| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 4.627      | 0.053             | 0.031           | 0.029      | 0.099             |           | Set Trigger |
| 2 | 4.433      | 0.054             | 0.031           | 0.028      | 0.099             |           | Set Trigger |
| 3 | 4.574      | 0.054             | 0.031           | 0.028      | 0.101             |           | Set Trigger |
| 4 | 4.440      | 0.053             | 0.030           | 0.029      | 0.098             |           | Set Trigger |
| 5 | 4.688      | 0.053             | 0.030           | 0.029      | 0.098             |           | Set Trigger |

A-4.55

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6348945.\_\_\_0  
FILE DATE AND TIME: 12/05/2008 07:55

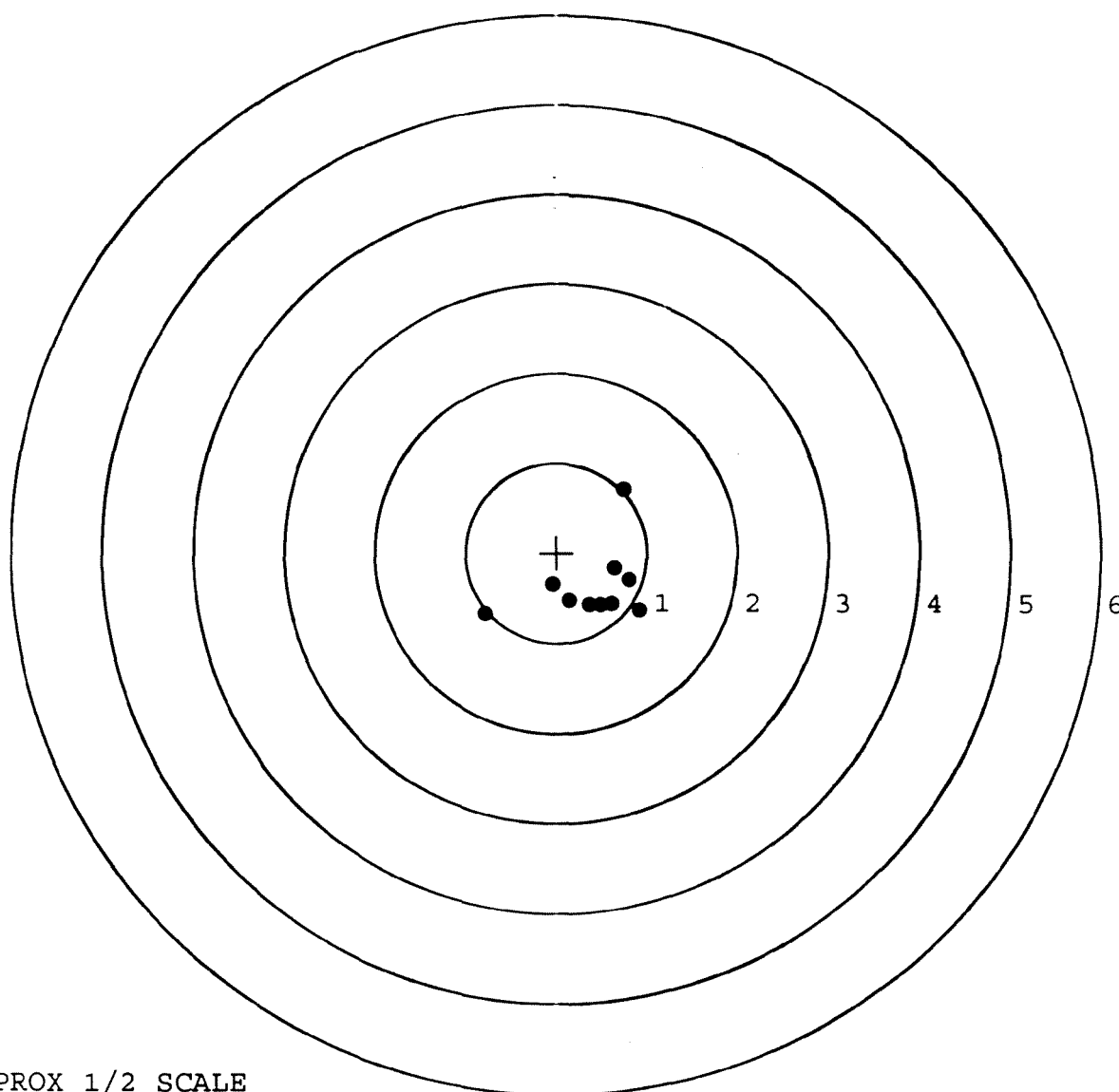
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

|                                                             |        |
|-------------------------------------------------------------|--------|
| The Average X Centroid of the Five Target Set:              | 0.146  |
| The Average Y Centroid of the Five Target Set:              | -0.173 |
| The Average Point of Impact of the Five Target Set:         | 0.226  |
| The Average Mean Radius of the Five Target Set:             | 0.650  |
| The Distance from POA to Centroid Target #1:                | 0.535  |
| The Distance from Centroid Target #2 to Centroid Target #1: | 0.348  |
| The Distance from Centroid Target #3 to Centroid Target #1: | 0.759  |
| The Distance from Centroid Target #4 to Centroid Target #1: | 0.088  |
| The Distance from Centroid Target #5 to Centroid Target #1: | 0.383  |

SERIAL NUMBER: C6348945.\_\_\_0  
TARGET NUMBER: 1  
FILE DATE: 12/05/2008  
FILE TIME: 07:55

| POINT# | X      | Y      |
|--------|--------|--------|
| 1:     | -0.790 | -0.679 |
| 2:     | -0.043 | -0.353 |
| 3:     | 0.142  | -0.532 |
| 4:     | 0.361  | -0.575 |
| 5:     | 0.487  | -0.578 |
| 6:     | 0.608  | -0.564 |
| 7:     | 0.917  | -0.639 |
| 8:     | 0.803  | -0.298 |
| 9:     | 0.645  | -0.173 |
| 10:    | 0.744  | 0.707  |

X CENTROID: 0.387  
Y CENTROID: -0.368  
POA TO CENTROID: 0.535  
HORZ SPREAD: 1.707  
VERT SPREAD: 1.386  
GROUP SPREAD: 2.067  
MIN RADIUS: 0.208  
MAX RADIUS: 1.218  
MEAN RADIUS: 0.515  
# IN 1 IN DIAMETER: 7  
# IN 2 IN DIAMETER: 8  
# in 3 IN DIAMETER: 10

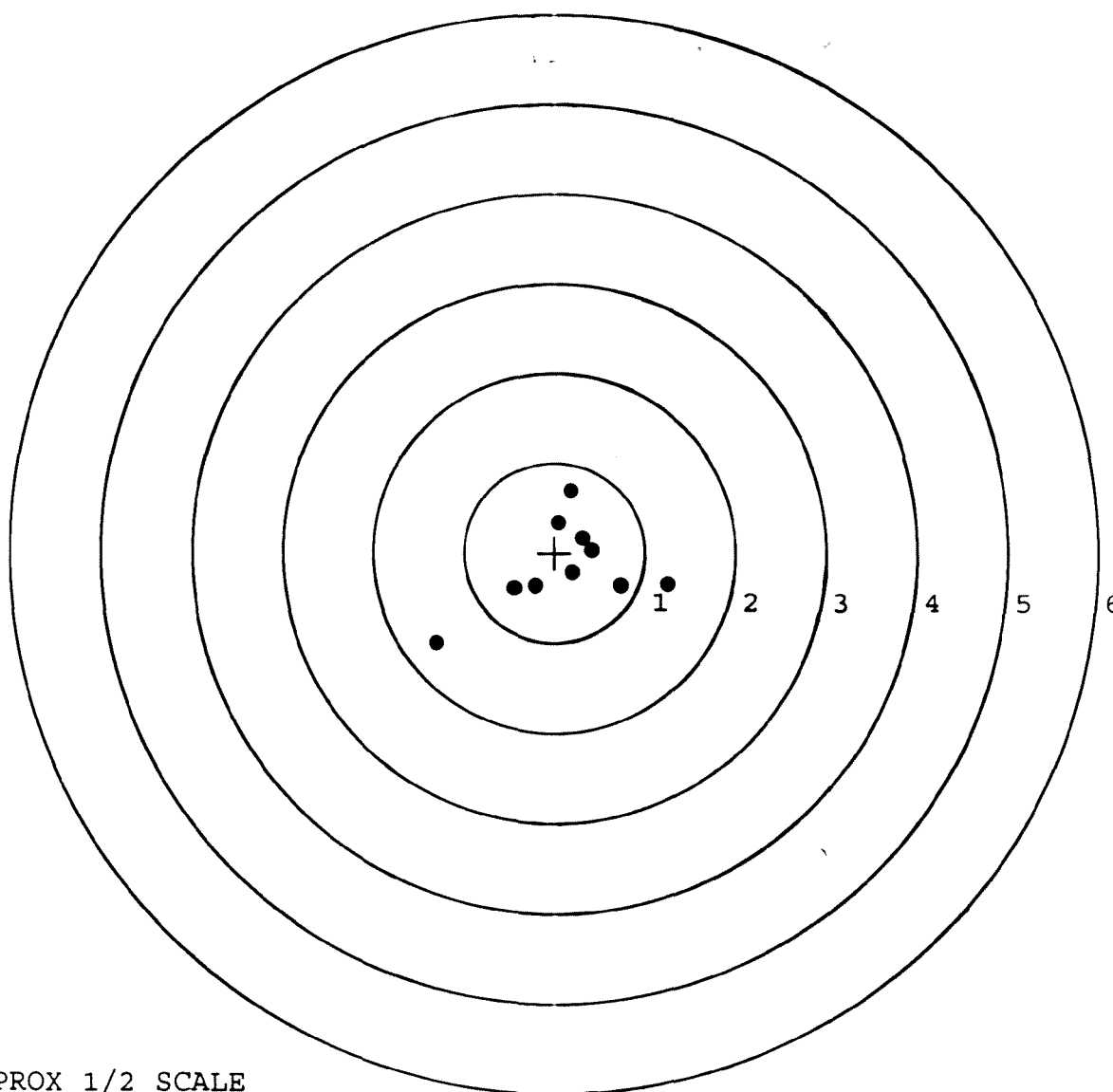


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6348945. \_\_0  
TARGET NUMBER: 2  
FILE DATE: 12/05/2008  
FILE TIME: 07:55

| POINT# | X      | Y      |
|--------|--------|--------|
| 1:     | -1.303 | -1.008 |
| 2:     | -0.451 | -0.401 |
| 3:     | -0.215 | -0.372 |
| 4:     | 0.199  | -0.220 |
| 5:     | 0.412  | 0.032  |
| 6:     | 0.311  | 0.161  |
| 7:     | 0.042  | 0.338  |
| 8:     | 0.733  | -0.370 |
| 9:     | 1.251  | -0.358 |
| 10:    | 0.180  | 0.692  |

X CENTROID: 0.116  
Y CENTROID: -0.151  
POA TO CENTROID: 0.190  
HORZ SPREAD: 2.554  
VERT SPREAD: 1.700  
GROUP SPREAD: 2.635  
MIN RADIUS: 0.108  
MAX RADIUS: 1.658  
MEAN RADIUS: 0.665  
# IN 1 IN DIAMETER: 5  
# IN 2 IN DIAMETER: 8  
# in 3 IN DIAMETER: 9

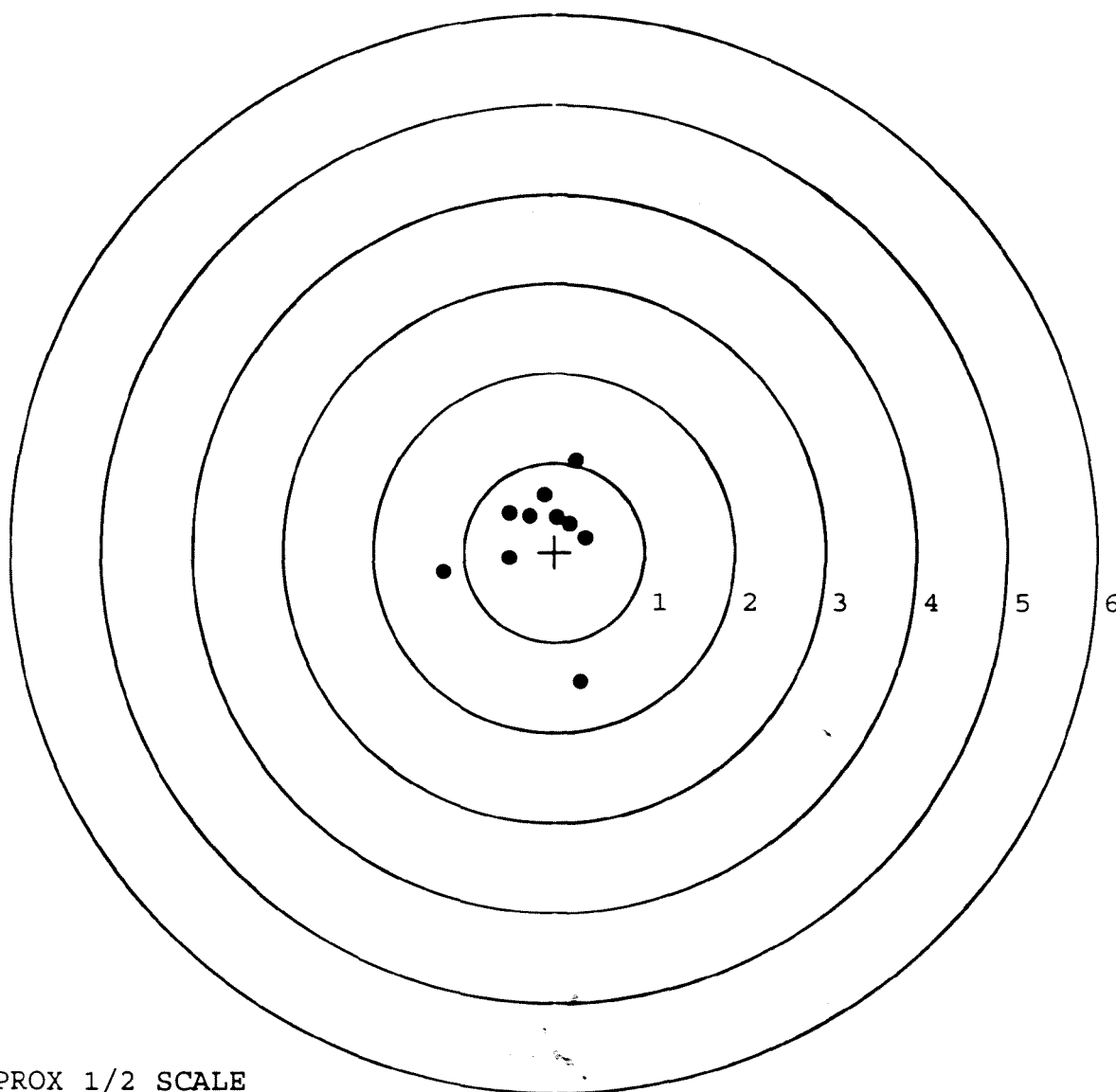


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6348945. \_\_0  
TARGET NUMBER: 3  
FILE DATE: 12/05/2008  
FILE TIME: 07:55

| POINT# | X      | Y      |
|--------|--------|--------|
| 1:     | 0.288  | -1.437 |
| 2:     | -1.220 | -0.232 |
| 3:     | -0.505 | -0.071 |
| 4:     | -0.494 | 0.438  |
| 5:     | -0.277 | 0.401  |
| 6:     | -0.108 | 0.640  |
| 7:     | 0.028  | 0.393  |
| 8:     | 0.172  | 0.318  |
| 9:     | 0.343  | 0.166  |
| 10:    | 0.245  | 1.028  |

X CENTROID: -0.153  
Y CENTROID: 0.164  
POA TO CENTROID: 0.224  
HORZ SPREAD: 1.563  
VERT SPREAD: 2.465  
GROUP SPREAD: 2.465  
MIN RADIUS: 0.267  
MAX RADIUS: 1.661  
MEAN RADIUS: 0.650  
# IN 1 IN DIAMETER: 7  
# IN 2 IN DIAMETER: 8  
# in 3 IN DIAMETER: 9

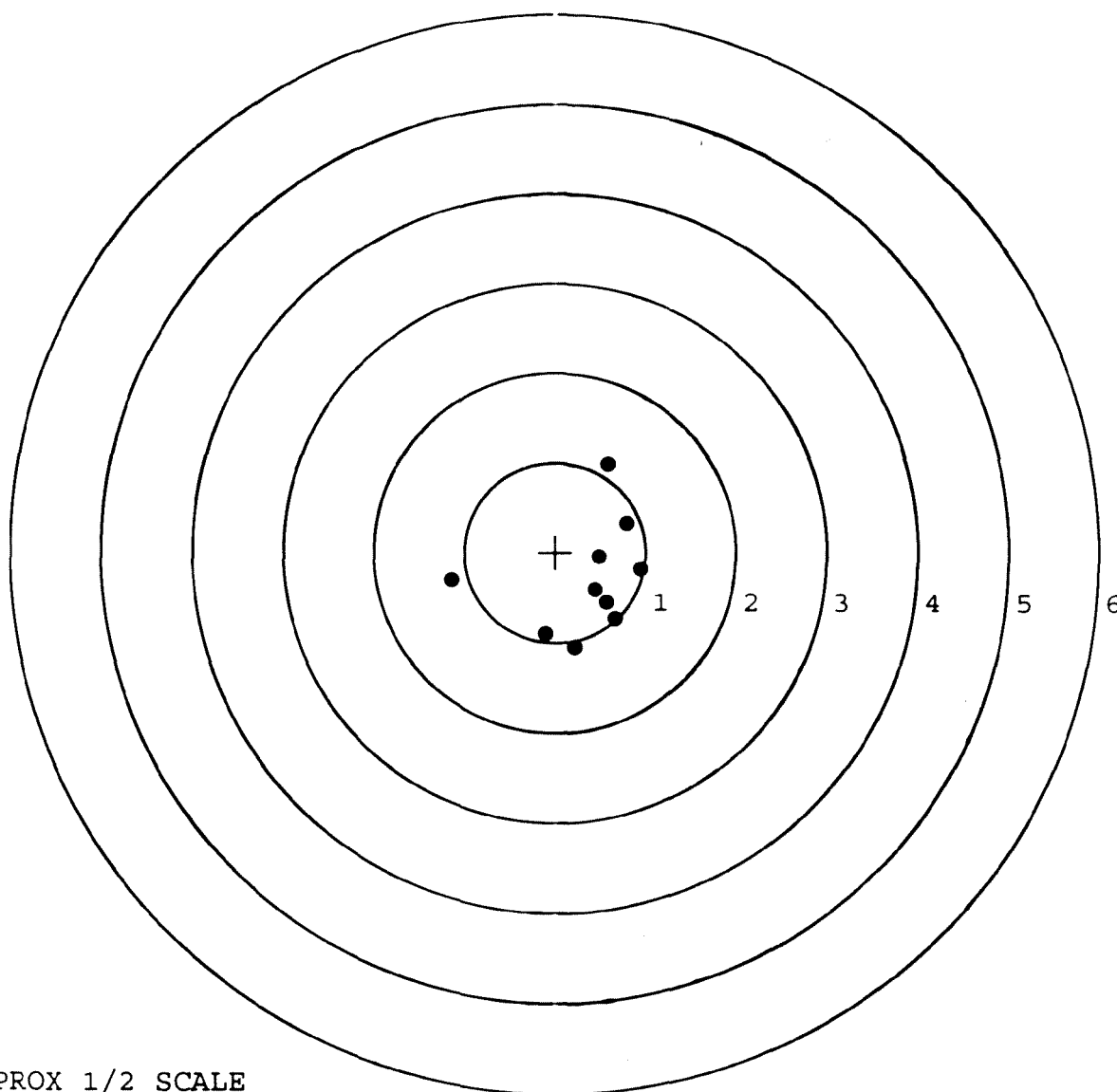


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6348945. \_\_0  
TARGET NUMBER: 4  
FILE DATE: 12/05/2008  
FILE TIME: 07:55

| POINT# | X      | Y      |
|--------|--------|--------|
| 1:     | -1.144 | -0.314 |
| 2:     | -0.113 | -0.913 |
| 3:     | 0.218  | -1.054 |
| 4:     | 0.663  | -0.734 |
| 5:     | 0.570  | -0.554 |
| 6:     | 0.441  | -0.420 |
| 7:     | 0.482  | -0.047 |
| 8:     | 0.952  | -0.191 |
| 9:     | 0.789  | 0.325  |
| 10:    | 0.590  | 0.983  |

X CENTROID: 0.345  
Y CENTROID: -0.292  
POA TO CENTROID: 0.452  
HORZ SPREAD: 2.096  
VERT SPREAD: 2.037  
GROUP SPREAD: 2.165  
MIN RADIUS: 0.160  
MAX RADIUS: 1.489  
MEAN RADIUS: 0.704  
# IN 1 IN DIAMETER: 3  
# IN 2 IN DIAMETER: 8  
# in 3 IN DIAMETER: 10

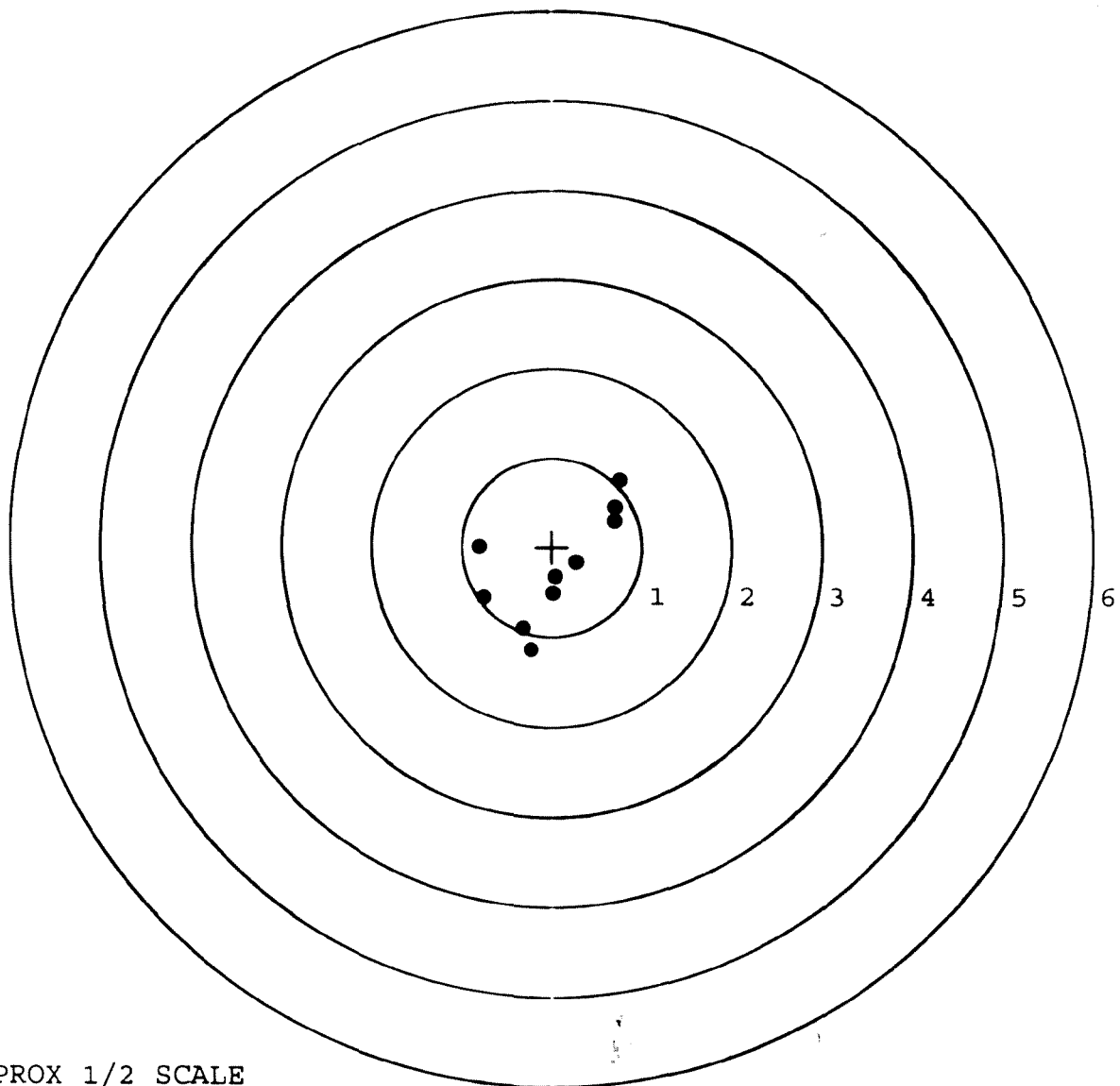


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6348945. \_\_0  
TARGET NUMBER: 5  
FILE DATE: 12/05/2008  
FILE TIME: 07:55

| POINT# | X      | Y      |
|--------|--------|--------|
| 1:     | -0.236 | -1.150 |
| 2:     | -0.322 | -0.909 |
| 3:     | -0.761 | -0.568 |
| 4:     | -0.812 | -0.001 |
| 5:     | 0.011  | -0.522 |
| 6:     | 0.038  | -0.338 |
| 7:     | 0.273  | -0.179 |
| 8:     | 0.700  | 0.291  |
| 9:     | 0.706  | 0.445  |
| 10:    | 0.758  | 0.749  |

X CENTROID: 0.035  
Y CENTROID: -0.218  
POA TO CENTROID: 0.221  
HORZ SPREAD: 1.570  
VERT SPREAD: 1.899  
GROUP SPREAD: 2.143  
MIN RADIUS: 0.120  
MAX RADIUS: 1.207  
MEAN RADIUS: 0.715  
# IN 1 IN DIAMETER: 3  
# IN 2 IN DIAMETER: 9  
# in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

**Remington®**

**MODEL 700™ H24**

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

**DUPONT**  
REG. U.S. PAT. & TM. OFF.

**SERIAL NO.**  
C6348945

**ORDER NO.**  
5716

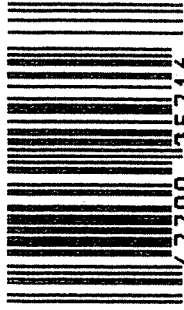
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.

Ø1



5716 C6348945

LPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6348945

| OP. #        | OP. NAME                                                       | READINGS | DATE     | INIT |
|--------------|----------------------------------------------------------------|----------|----------|------|
| 575 &<br>580 | Assemble Action<br>and Stock                                   | 10-9     | 89       | RW   |
| 600          | Proof                                                          | 10-9     | 89       | A.C. |
| 607          | Check Headspace                                                | 10-9     | 89       | RW   |
| 610          | Dis-assemble Gun                                               | 10-9     | 89       | RW   |
| 612          | NEW Barrel 10/30/89<br>Magnaflux Barrel<br>Action              | REJECT   | 10/13/89 | KCR  |
|              | Magnaflux Bolt                                                 |          | 10/13/89 | KCR  |
| 615          | Rollmark Caliber                                               |          |          |      |
| 7            | Drill and Tap Sight Holes                                      |          |          |      |
| 618          | Polish Barrel                                                  |          |          |      |
| 620          | Apply Coatings<br>(Barrel Action)                              |          |          |      |
|              | Apply Coating (Bolt)                                           |          |          |      |
| 625          | Final Assembly<br>A) Clean inside of<br>Bolt Assembly          |          |          |      |
|              | B) Inspect Rear Firing<br>Pin Hole for Chamfer<br>in Bolt Head |          |          |      |
|              | C) Inspect Ejector Hole<br>for Chamfer                         |          |          |      |
|              | D) Oil Firing Pin Ass'y                                        |          |          |      |
|              | E) Adjust Trigger Pull to<br>Min Setting and Stake             |          |          |      |

| op. #        | OP. NAME                                                          | READINGS |  |  | DATE | INIT |
|--------------|-------------------------------------------------------------------|----------|--|--|------|------|
| 625<br>cont. | F) Safety On Force                                                |          |  |  |      |      |
|              | G) Safety Off Force                                               |          |  |  |      |      |
|              | H) Trigger Pull Test &<br>Retainability                           |          |  |  |      |      |
|              | I) Firing Pin Indent                                              |          |  |  |      |      |
|              | J) Assemble Stock                                                 |          |  |  |      |      |
|              | K) Assemble Swivel Studs                                          |          |  |  |      |      |
|              | L) Attach Front and Rear<br>Sight Assemblies                      |          |  |  |      |      |
|              | M) Iron Sight Alignment                                           |          |  |  |      |      |
|              | N) Detach Front & Rear<br>Sights & place in<br>numbered container |          |  |  |      |      |
|              | O) Attach Scope to Rifle                                          |          |  |  |      |      |
|              | P) Detach & Attach Scope<br>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<br>A) Headspace                                  |          |  |  |      |      |
|              | B) Trigger Pull                                                   |          |  |  |      |      |
|              | C) Function                                                       |          |  |  |      |      |
| 660          | Pack                                                              |          |  |  |      |      |

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6348945

| OP. #     | OP. NAME                                                 | READINGS | DATE     | INIT |
|-----------|----------------------------------------------------------|----------|----------|------|
| 575 & 580 | Assemble Action and Stock                                | 11-2     | 89       | RW   |
| 600       | Proof                                                    | 11-2     | 89       | A    |
| 607       | Check Headspace                                          | 11-2     | 89       | RW   |
| 610       | Dis-assemble Gun                                         | 11-2     | 89       | RW   |
| 612       | Magnaflux Barrel Action                                  | 11-9-89  |          | KER  |
|           | Magnaflux Bolt                                           | 11-9-89  |          | KER  |
| 615       | Rollmark Caliber                                         |          |          |      |
| 17        | Drill and Tap Sight Holes                                | 11 9     | 89       | YB   |
| 618       | Polish Barrel RB                                         | 11 9     | 89       | BT   |
| 620       | Apply Coatings (Barrel Action)                           |          | 11-17-89 | TJA  |
|           | Apply Coating (Bolt)                                     |          |          |      |
| 625       | Final Assembly                                           |          |          |      |
|           | A) Clean inside of Bolt Assembly                         |          | 11/27/89 | RW   |
|           | B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head |          | 11/27/89 | RW   |
|           | C) Inspect Ejector Hole for Chamfer                      |          | 11/27/89 | RW   |
|           | D) Oil Firing Pin Ass'y                                  |          | 11/27/89 | RW   |
|           | E) Adjust Trigger Pull to Min Setting and Stake          |          | 5 Dec 89 | JS   |

| op. #        | OP. NAME                                                    | READINGS |       |       | DATE      | INIT |
|--------------|-------------------------------------------------------------|----------|-------|-------|-----------|------|
| 625<br>cont. | F) Safety On Force                                          | 5        | 5     | 5     | 5 Dec 89  | JS   |
|              | G) Safety Off Force                                         | 3        | 3     | 3     | 5 Dec 89  | JS   |
|              | H) Trigger Pull Test & Retainability                        |          |       |       | 5 Dec 89  | JS   |
|              | I) Firing Pin Indent                                        | .021     | .0215 | .0215 | 5 Dec 89  | JS   |
|              | J) Assemble Stock                                           |          |       |       | 12/6/89   | RW   |
|              | K) Assemble Swivel Studs                                    |          |       |       | 17 Dec 89 | JS   |
|              | L) Attach Front and Rear Sight Assemblies                   |          |       |       | 12/6/89   | RW   |
|              | M) Iron Sight Alignment                                     |          |       |       | 12/6/89   | RW   |
|              | N) Detach Front & Rear Sights & place in numbered container |          |       |       | 12/6/89   | RW   |
|              | O) Attach Scope to Rifle                                    |          |       |       | 16 Dec 89 | JS   |
|              | P) Detach & Attach Scope 20 Times                           |          |       |       | 16 Dec 89 | JS   |
| 640          | Gallery Target & Test                                       |          |       |       | 12-6-89   | A    |
|              | A) Time                                                     |          |       |       | 12-6-89   | A    |
|              | B) Malfunctions                                             |          |       |       | 12-6-89   | A    |
|              | C) Pierced Primers                                          |          |       |       | 12-6-89   | A    |
|              | D) Optical Clarity of Scope                                 |          |       |       | 12-6-89   | A    |
| 645          | Inspect for Live Ammo                                       |          |       |       | 12-6-89   | A    |
| 655          | Final Inspection<br>A) Headspace                            |          |       |       | 7 Dec 89  | JS   |
|              | B) Trigger Pull                                             | 278      | 276   | 269   | 7 Dec 89  | JS   |
|              | C) Function                                                 |          |       |       | 7 Dec 89  | JS   |
| 660          | Pack                                                        |          |       |       | 15 Dec 89 | JS   |

## SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN  
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. 16348945DATE 4/9/90TESTER AW

|         | 2.50#<br>INITIAL | 2.50# AFTER<br>50 CYCLES | FINAL TEST &<br>TO RESET 2.50# | COMMENTS                                                               |
|---------|------------------|--------------------------|--------------------------------|------------------------------------------------------------------------|
| PULL #1 | 2.39             | 2.36                     | 2.31                           | MIN. SETTING,<br>NO AVG. OF 5<br>READINGS ACCEPT-<br>ABLE LESS THAN 2# |
| PULL #2 | 2.30             | 2.27                     | 2.26                           |                                                                        |
| PULL #3 | 2.42             | 2.35                     | 2.25                           |                                                                        |
| PULL #4 | 2.38             | 2.23                     | 2.27                           |                                                                        |
| PULL #5 | 2.43             | 2.36                     | 2.26                           |                                                                        |
| TOTAL   | 11.92            | 11.57                    | 11.35                          |                                                                        |
| AVG.    | 2.38             | 2.31                     | 2.27                           |                                                                        |

|         | 3.00#<br>INITIAL | 3.00# AFTER<br>20 CYCLES | COMMENTS |
|---------|------------------|--------------------------|----------|
| PULL #1 | 3.29             | 3.21                     |          |
| PULL #2 | 3.25             | 3.29                     |          |
| PULL #3 | 3.22             | 3.27                     |          |
| PULL #4 | 3.20             | 3.24                     |          |
| PULL #5 | 3.23             | 3.30                     |          |
| TOTAL   | 16.19            | 16.31                    |          |
| AVG.    | 3.24             | 3.26                     |          |

|         | 4.00#<br>INITIAL | 4.00# AFTER<br>20 CYCLES | MAX SETTING<br>GREATER THAN 4# | RESET TO 4# FOR<br>TARGET & ACCURACY |
|---------|------------------|--------------------------|--------------------------------|--------------------------------------|
| PULL #1 | 4.09             | 4.07                     |                                |                                      |
| PULL #2 | 4.13             | 4.06                     |                                |                                      |
| PULL #3 | 4.15             | 4.04                     |                                |                                      |
| PULL #4 | 4.06             | 4.03                     |                                |                                      |
| PULL #5 | 4.14             | 4.00                     |                                |                                      |
| TOTAL   | 20.57            | 20.20                    |                                |                                      |
| AVG.    | 4.12             | 4.04                     |                                |                                      |

CENTROIDAL DISTANCE CALCULATIONS  
FOR RIFLE # 06348945  
6 Dec 1989

CENTROIDAL DISTANCES

|      |   |         |
|------|---|---------|
| 0 TO | 1 | .191638 |
| 1 TO | 2 | .426104 |
| 1 TO | 3 | .357035 |
| 1 TO | 4 | .416625 |
| 1 TO | 5 | .745085 |

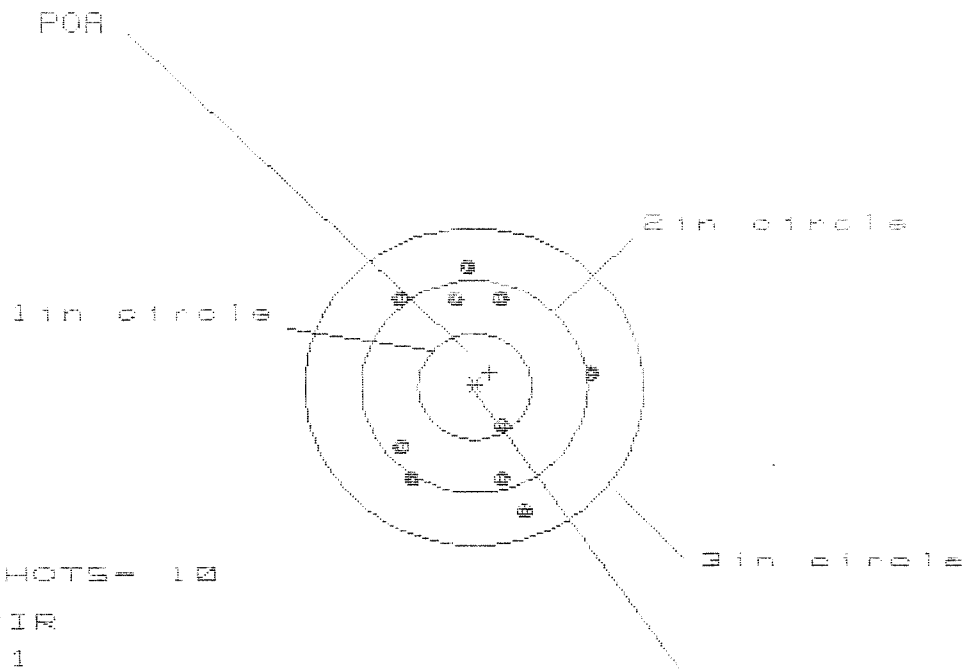
$\frac{49}{5} \sigma^2$  -----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.2376  
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0532  
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .243483  
THE AMR FOR THIS RIFLE IS: .914

8 Dec 1985

FILE:/PATTERNING/CENTERFIRE\_PATT/08348945

# CENTERFIRE PATTERNS # 1



# OF SHOTS= 10

# IN CIR

1in = 1

2in = 6

3in = 10

HS= 1.629

VS= 2.297

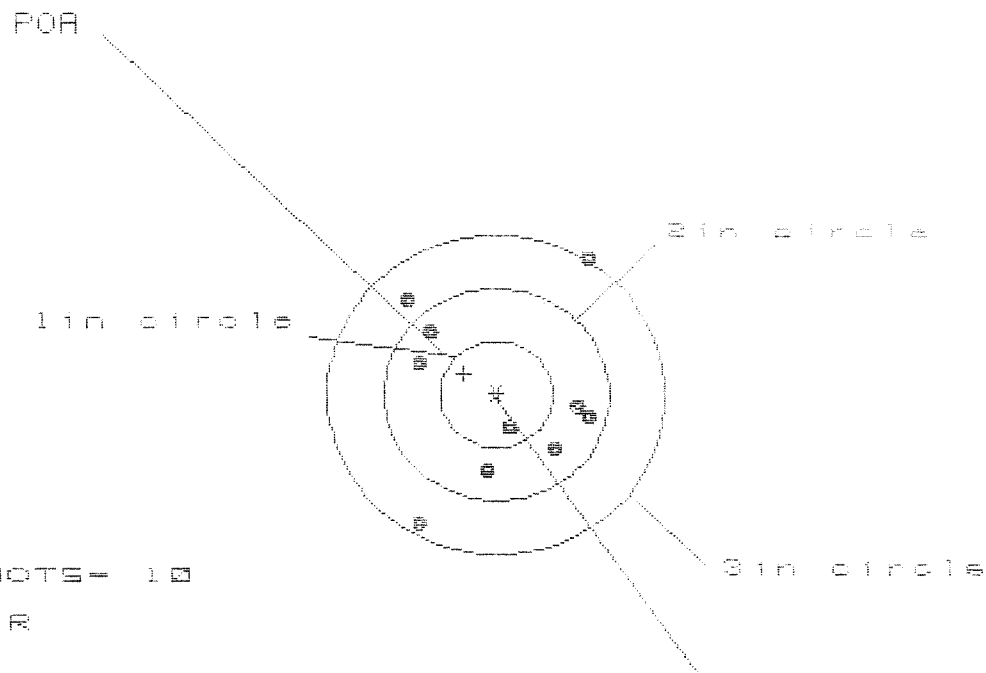
GS= 2.353

| PATTERN #                     | 1      | 2     | 3     |
|-------------------------------|--------|-------|-------|
| SHOTS (BEST OF)               | 10     | 9     | 8     |
| MAXIMUM X                     | .989   | 1.033 | 1.025 |
| MINIMUM X                     | -.640  | -.596 | -.604 |
| MAXIMUM Y                     | 1.156  | 1.029 | .816  |
| MINIMUM Y                     | -1.141 | -.986 | -.858 |
| CENTROID X                    | -.137  | -.181 | -.173 |
| CENTROID Y                    | -.134  | -.007 | -.135 |
| POA TO CENTROID in.           | .191   | .181  | .219  |
| MIN RADIUS                    | .439   | .567  | .462  |
| MEAN RADIUS                   | .923   | .885  | .858  |
| MAX RADIUS                    | 1.209  | 1.118 | 1.034 |
| HORIZONTAL SPREAD             | 1.629  | 1.629 | 1.629 |
| VERTICAL SPREAD               | 2.297  | 2.015 | 1.674 |
| EXTREME SPREAD                | 2.353  | 2.067 | 1.860 |
| NUMBER IN ONE INCH CIRCLE =   | 1      |       |       |
| NUMBER IN TWO INCH CIRCLE =   | 6      |       |       |
| NUMBER IN THREE INCH CIRCLE = | 10     |       |       |

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# CENTERFIRE PATTERNS # 2



# OF SHOTS- 10

# IN CIR

1 in = 1

2 in = 7

3 in = 8

HS= 1.691

VS= 2.500

GS= 2.924

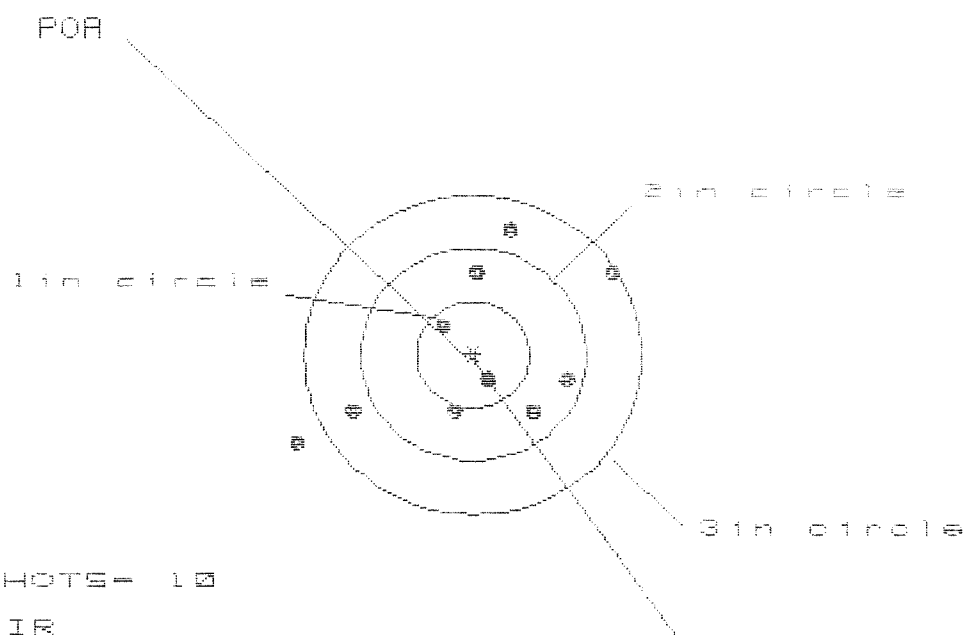
CENTROID #

|                               |   |        |        |       |
|-------------------------------|---|--------|--------|-------|
| PATTERN #                     | : | 2      |        |       |
| SHOTS (BEST OF)               | : | 10     | 9      | 8     |
| MAXIMUM X                     | : | .860   | .949   | .871  |
| MINIMUM X                     | : | -.831  | -.742  | -.820 |
| MAXIMUM Y                     | : | 1.277  | 1.067  | .932  |
| MINIMUM Y                     | : | -1.223 | -1.081 | -.731 |
| CENTROID X                    | : | .285   | .196   | .274  |
| CENTROID Y                    | : | -.193  | -.335  | -.200 |
| POA TO CENTROID in.           | : | .344   | .388   | .340  |
| MIN RADIUS                    | : | .325   | .278   | .324  |
| MEAN RADIUS                   | : | .912   | .830   | .774  |
| MAX RADIUS                    | : | 1.508  | 1.300  | 1.242 |
| HORIZONTAL SPREAD             | : | 1.691  | 1.691  | 1.691 |
| VERTICAL SPREAD               | : | 2.500  | 2.148  | 1.663 |
| EXTREME SPREAD                | : | 2.924  | 2.151  | 2.061 |
| NUMBER IN ONE INCH CIRCLE =   |   |        | 1      |       |
| NUMBER IN TWO INCH CIRCLE =   |   |        | 7      |       |
| NUMBER IN THREE INCH CIRCLE = |   |        | 9      |       |

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# CENTERFIRE PATTERNS # 3



# OF SHOTS= 10

# IN CIR

1 in = 2

2 in = 6

3 in = 8

HS= 2.774

VS= 2.000

GS= 3.227

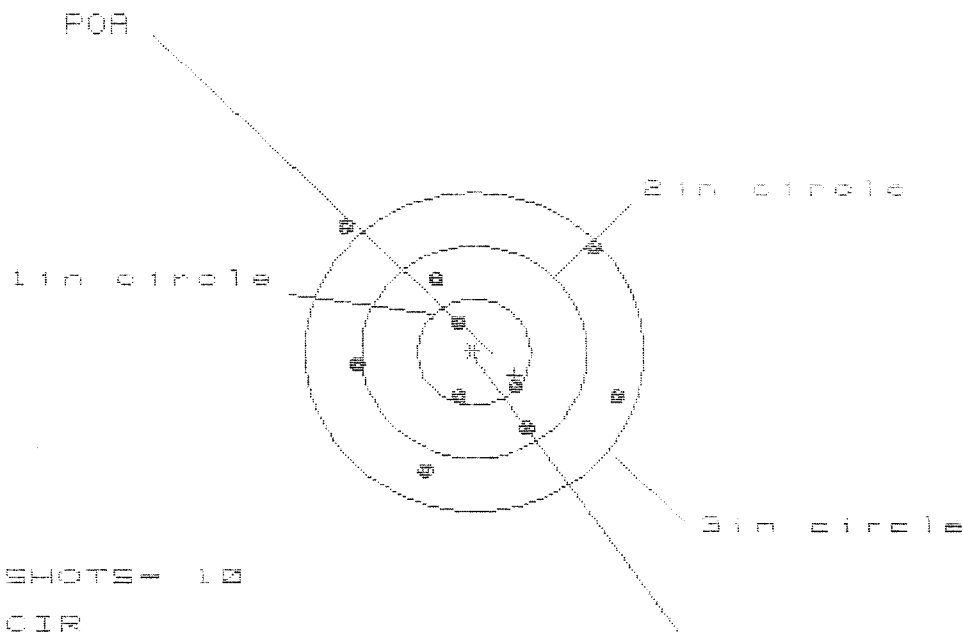
CENTROID #

| PATTERN #                   | : | 3      | 9      | 8      |
|-----------------------------|---|--------|--------|--------|
| SHOTS (BEST OF)             | : | 10     | 9      | 8      |
| MAXIMUM X                   | : | 1.219  | 1.047  | .772   |
| MINIMUM X                   | : | -1.555 | -1.197 | -1.067 |
| MAXIMUM Y                   | : | 1.140  | 1.044  | 1.131  |
| MINIMUM Y                   | : | -.862  | -.643  | -.556  |
| CENTROID X                  | : | -.132  | .040   | -.090  |
| CENTROID Y                  | : | .223   | .319   | .232   |
| POR TO CENTROID in.         | : | .259   | .321   | .249   |
| MIN RADIUS                  | : | .260   | .322   | .250   |
| MEAN RADIUS                 | : | .905   | .805   | .727   |
| MAX RADIUS                  | : | 1.773  | 1.359  | 1.203  |
| HORIZONTAL SPREAD           | : | 2.774  | 2.244  | 1.839  |
| VERTICAL SPREAD             | : | 2.002  | 1.687  | 1.687  |
| EXTREME SPREAD              | : | 3.227  | 2.610  | 2.143  |
| NUMBER IN ONE INCH CIRCLE   | = |        | 2      |        |
| NUMBER IN TWO INCH CIRCLE   | = |        | 6      |        |
| NUMBER IN THREE INCH CIRCLE | = |        | 9      |        |

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# CENTERFIRE PATTERNS # 4



# OF SHOTS= 10

# IN CIR

1 in = 2

2 in = 5

3 in = 8

HS= 2.326

VS= 2.215

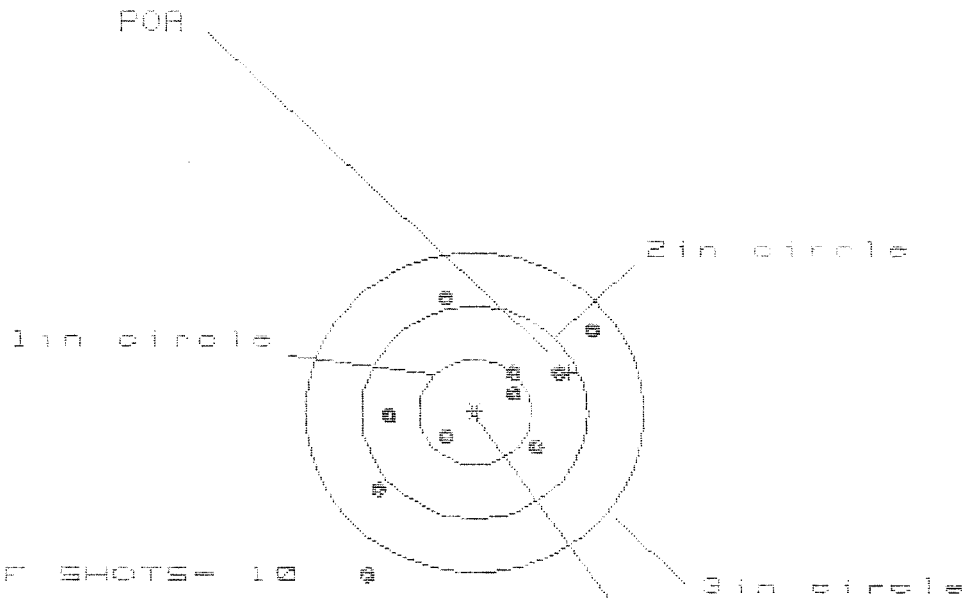
GS= 2.813

| PATTERN #                     | 4      |        |        |
|-------------------------------|--------|--------|--------|
| SHOTS (BEST OF)               | 10     | 9      | 8      |
| MAXIMUM X                     | 1.216  | 1.093  | 1.209  |
| MINIMUM X                     | -1.110 | -1.143 | -1.027 |
| MAXIMUM Y                     | 1.136  | 1.158  | .976   |
| MINIMUM Y                     | -1.079 | -.952  | -.808  |
| CENTROID X                    | -.363  | -.240  | -.356  |
| CENTROID Y                    | .216   | .089   | -.055  |
| POA TO CENTROID in.           | .422   | .256   | .361   |
| MIN RADIUS                    | .250   | .332   | .215   |
| MEAN RADIUS                   | .943   | .853   | .750   |
| MAX RADIUS                    | 1.589  | 1.487  | 1.222  |
| HORIZONTAL SPREAD             | 2.326  | 2.236  | 2.236  |
| VERTICAL SPREAD               | 2.215  | 2.110  | 1.784  |
| EXTREME SPREAD                | 2.813  | 2.610  | 2.265  |
| NUMBER IN ONE INCH CIRCLE =   |        | 2      |        |
| NUMBER IN TWO INCH CIRCLE =   |        | 5      |        |
| NUMBER IN THREE INCH CIRCLE = |        | 9      |        |

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# CENTERFIRE PATTERNS # 5



# OF SHOTS= 10

# IN CIR

1in = 2

2in = 6

3in = 9

HS= 2.018

VS= 2.626

GS= 3.104

CENTROID \*

|                             |   |        |       |       |
|-----------------------------|---|--------|-------|-------|
| PATTERN #                   | : | 5      |       |       |
| SHOTS (BEST OF)             | : | 10     | 9     | 8     |
| MAXIMUM X                   | : | 1.038  | .930  | .703  |
| MINIMUM X                   | : | -.980  | -.977 | -.861 |
| MAXIMUM Y                   | : | 1.091  | .920  | 1.002 |
| MINIMUM Y                   | : | -1.535 | -.926 | -.844 |
| CENTROID X                  | : | -.841  | -.733 | -.849 |
| CENTROID Y                  | : | -.378  | -.207 | -.289 |
| POR TO CENTROID in.         | : | .922   | .761  | .897  |
| MIN RADIUS                  | : | .329   | .261  | .392  |
| MEAN RADIUS                 | : | .687   | .750  | .712  |
| MAX RADIUS                  | : | 1.021  | 1.346 | 1.206 |
| HORIZONTAL SPREAD           | : | 2.018  | 1.907 | 1.564 |
| VERTICAL SPREAD             | : | 2.626  | 1.846 | 1.846 |
| EXTREME SPREAD              | : | 3.104  | 2.476 | 1.959 |
| NUMBER IN ONE INCH CIRCLE   | = |        | 2     |       |
| NUMBER IN TWO INCH CIRCLE   | = |        | 6     |       |
| NUMBER IN THREE INCH CIRCLE | = |        | 9     |       |