

C6348954

MODEL 700™ M24

Model SMS™

Action

Barrel Length

Capacity

Order No. 5716

*Includes 1 in chamber.

Remington

Repair Inquiry

Repair Number: RE00071777

Serial: C6348954 Model 700 Center Fire Caliber: 7
62 NATO M24 SWS

Repairman:

Status:

Closed 10/21/2003 11:52:13 AM

Verify Repair

Address Information

Customer:

☒ Received From

Return To:

☐ Received From

Name: MATERIAL MOVEMENT SECTION

MATERIAL MOVEMENT SECTION

Address 1: BLDG 9630

BLDG 9630

Address 2: PRESCOTT AVE

PO Box:

PRESCOTT AVE

PO Box:

City: FORT LEWIS

FORT LEWIS

State: WA

Zip Code: 98433

Country: US

State: WA

Zip Code: 98433

Country: US

FPL:

Contact / Condition

Problems

Estimate

History / Status

Shipping / Billing

Contact Information

Phone:

Fax:

Email:

Comments:

Received Condition

Fair

Condition
Notes:CSR
Notes:

Accessories Received

Code	Desc	Qty
A007	With Studs	3

Repair Search

Refresh

Close

naglelj

10/21/2003

12:43 PM

CAPS

NUM

INS

SCRL



12:40 PM

Serial Number: C6348954
Model: 700
RE00071777

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6348954.__0
FILE DATE AND TIME: 11/13/2003 11:49

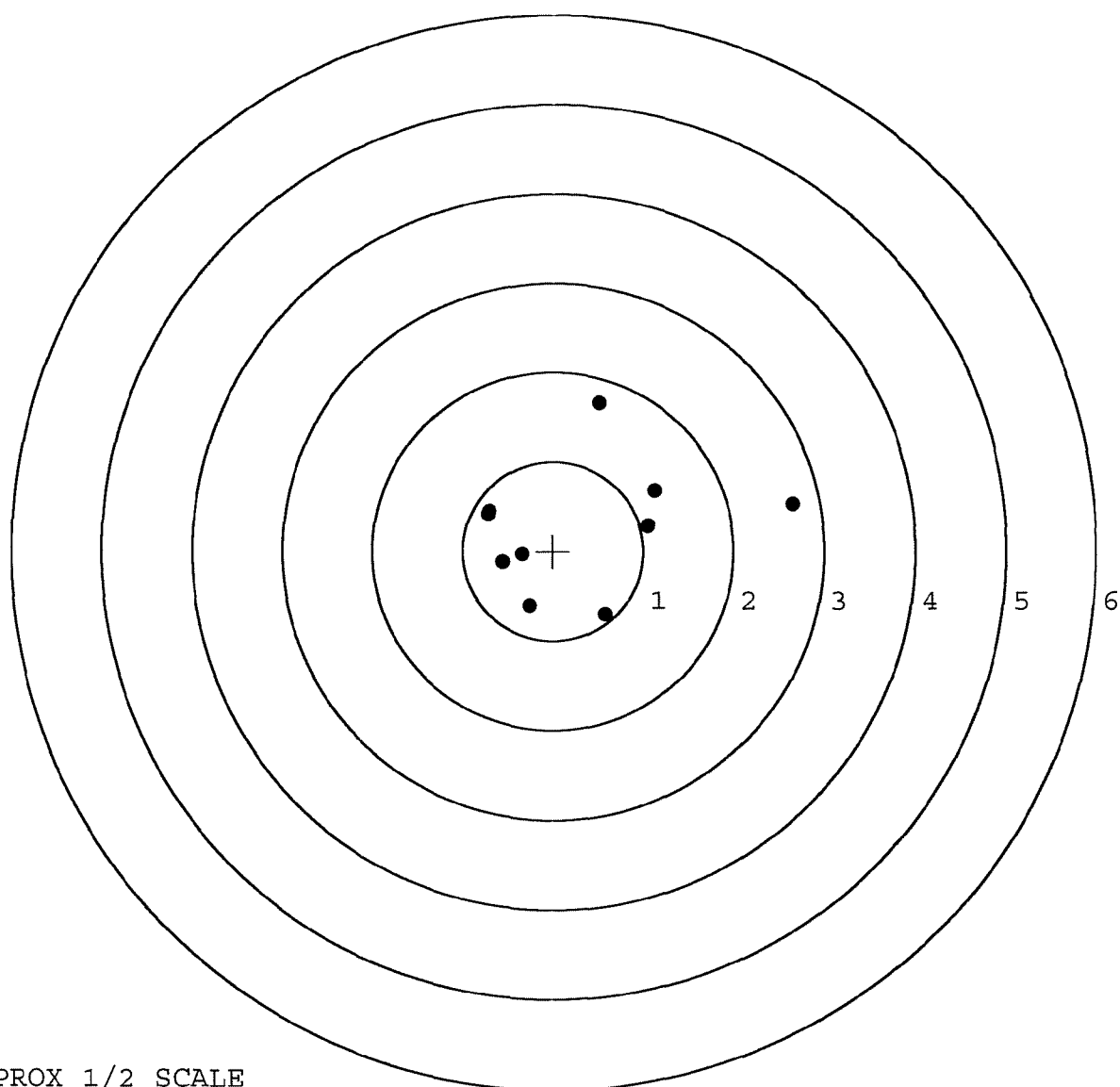
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.106
The Average Y Centroid of the Five Target Set:	0.077
The Average Point of Impact of the Five Target Set:	0.132
The Average Mean Radius of the Five Target Set:	0.820
The Distance from POA to Centroid Target #1:	0.416
The Distance from Centroid Target #2 to Centroid Target #1:	0.341
The Distance from Centroid Target #3 to Centroid Target #1:	0.364
The Distance from Centroid Target #4 to Centroid Target #1:	0.599
The Distance from Centroid Target #5 to Centroid Target #1:	0.284

SERIAL NUMBER: C6348954. __0
TARGET NUMBER: 1
FILE DATE: 11/13/2003
FILE TIME: 11:49

POINT#	X	Y
1:	0.513	1.655
2:	2.650	0.533
3:	1.120	0.678
4:	1.051	0.286
5:	-0.711	0.441
6:	-0.345	-0.040
7:	-0.558	-0.130
8:	-0.255	-0.620
9:	0.580	-0.707
10:	-0.723	0.413

X CENTROID: 0.332
Y CENTROID: 0.251
POA TO CENTROID: 0.416
HORZ SPREAD: 3.373
VERT SPREAD: 2.362
GROUP SPREAD: 3.375
MIN RADIUS: 0.720
MAX RADIUS: 2.335
MEAN RADIUS: 1.124
IN 1 IN DIAMETER: 0
IN 2 IN DIAMETER: 5
in 3 IN DIAMETER: 9

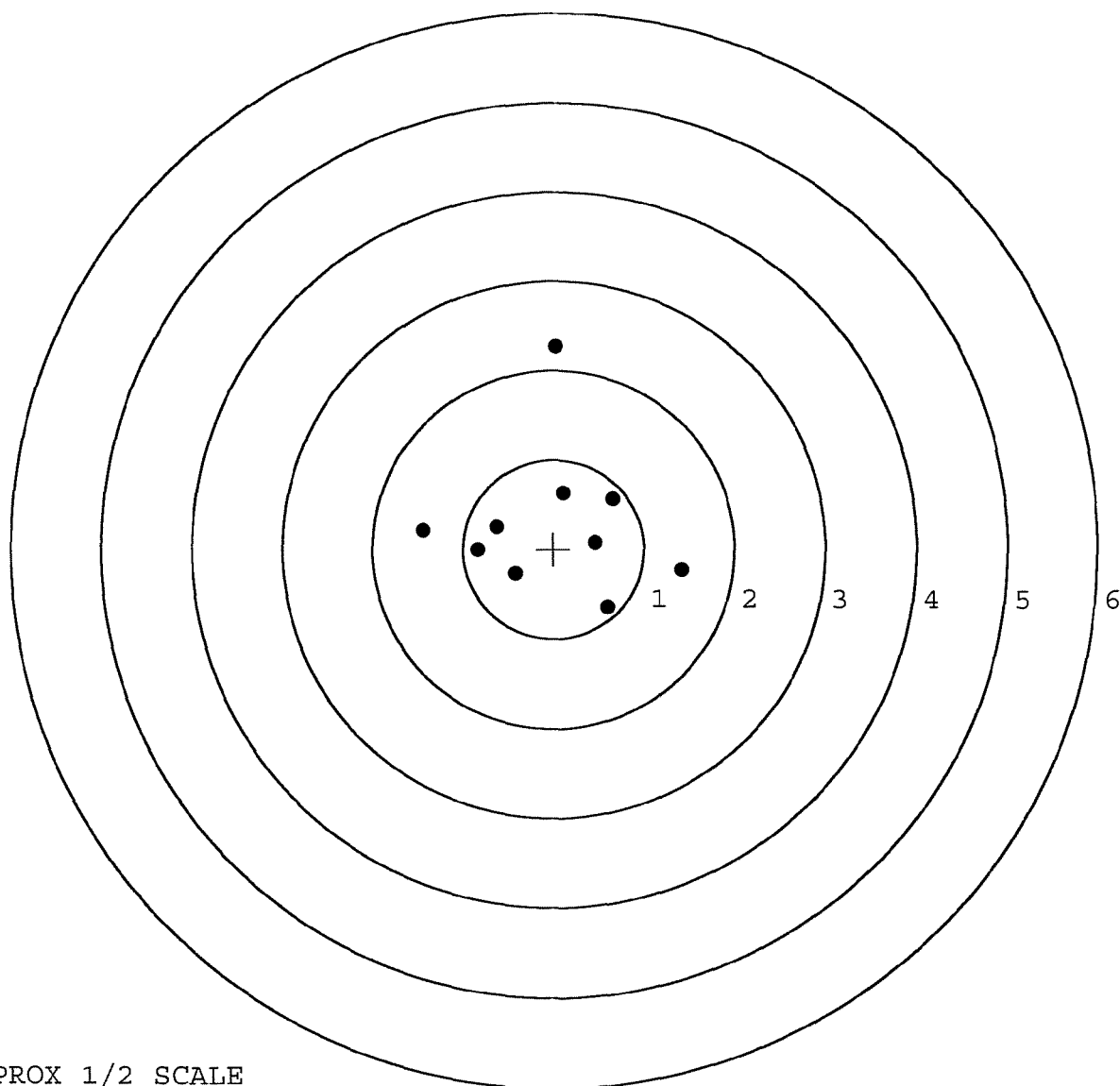


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6348954. __0
TARGET NUMBER: 2
FILE DATE: 11/13/2003
FILE TIME: 11:49

POINT#	X	Y
1:	0.104	0.631
2:	0.658	0.568
3:	0.455	0.075
4:	1.418	-0.227
5:	0.606	-0.659
6:	-0.628	0.245
7:	-1.446	0.202
8:	-0.836	-0.016
9:	-0.423	-0.274
10:	0.019	2.263

X CENTROID: -0.007
Y CENTROID: 0.281
POA TO CENTROID: 0.281
HORZ SPREAD: 2.864
VERT SPREAD: 2.922
GROUP SPREAD: 2.980
MIN RADIUS: 0.367
MAX RADIUS: 1.982
MEAN RADIUS: 0.985
IN 1 IN DIAMETER: 1
IN 2 IN DIAMETER: 6
in 3 IN DIAMETER: 8

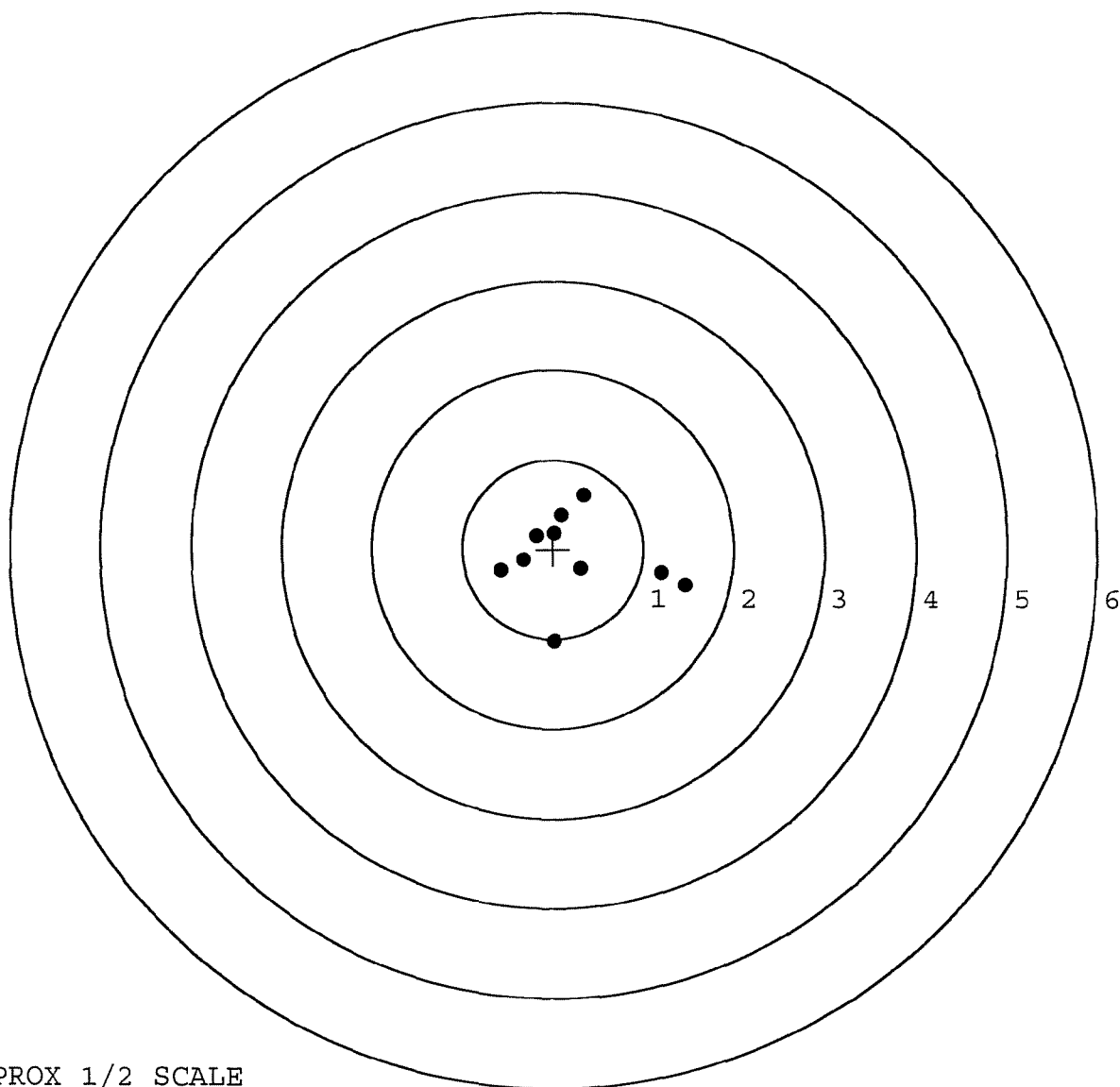


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6348954. __0
TARGET NUMBER: 3
FILE DATE: 11/13/2003
FILE TIME: 11:49

POINT#	X	Y
1:	1.196	-0.271
2:	1.466	-0.403
3:	0.305	-0.226
4:	0.024	-1.032
5:	-0.578	-0.243
6:	-0.330	-0.129
7:	0.337	0.604
8:	0.099	0.383
9:	0.015	0.174
10:	-0.183	0.145

X CENTROID: 0.235
Y CENTROID: -0.100
POA TO CENTROID: 0.255
HORZ SPREAD: 2.044
VERT SPREAD: 1.636
GROUP SPREAD: 2.050
MIN RADIUS: 0.144
MAX RADIUS: 1.268
MEAN RADIUS: 0.678
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

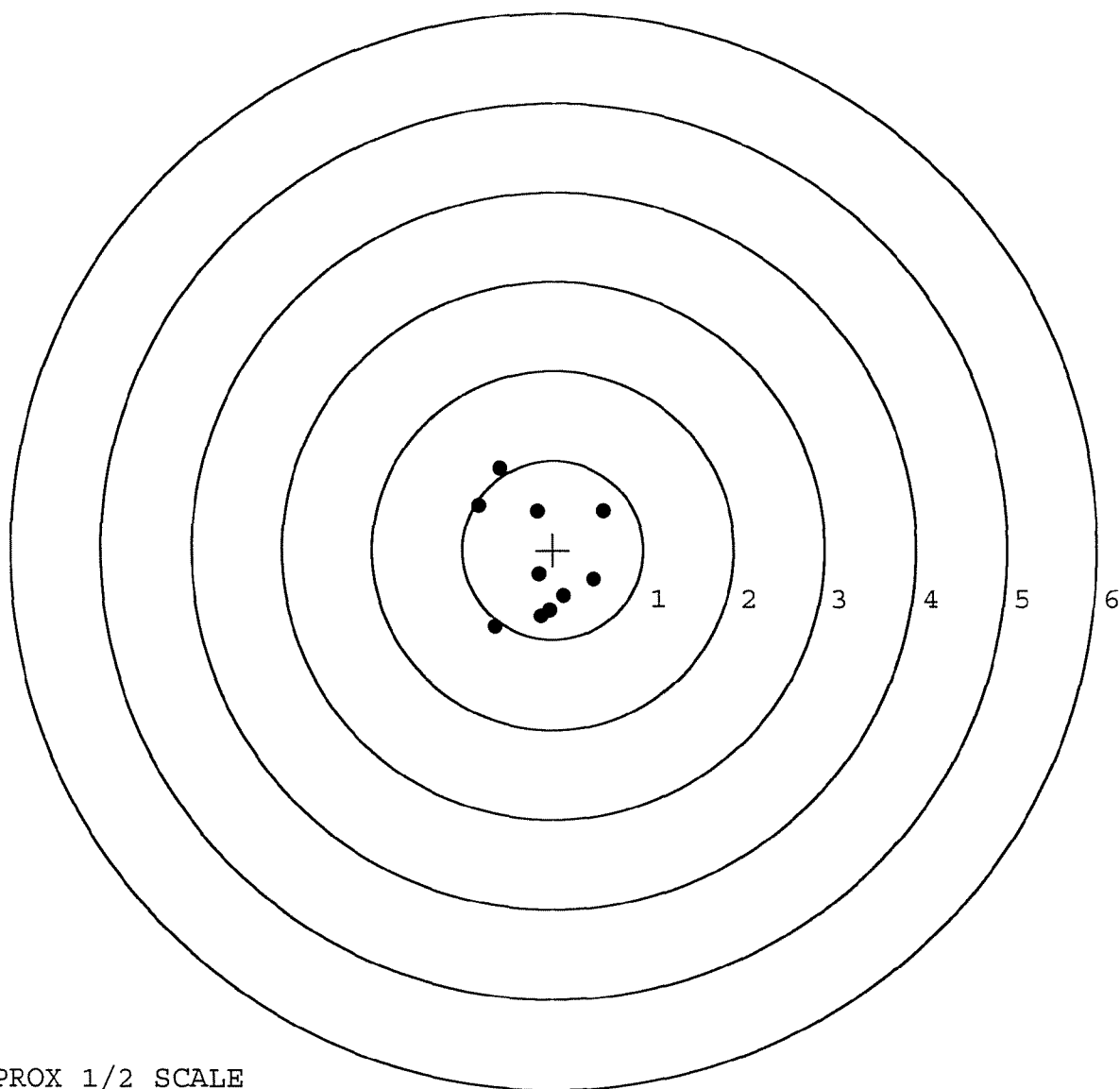


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6348954.___0
TARGET NUMBER: 4
FILE DATE: 11/13/2003
FILE TIME: 11:49

POINT#	X	Y
1:	-0.589	0.909
2:	-0.822	0.499
3:	-0.176	0.435
4:	0.554	0.446
5:	-0.158	-0.277
6:	0.451	-0.329
7:	0.114	-0.521
8:	-0.132	-0.748
9:	-0.634	-0.873
10:	-0.039	-0.680

X CENTROID: -0.143
Y CENTROID: -0.114
POA TO CENTROID: 0.183
HORZ SPREAD: 1.376
VERT SPREAD: 1.782
GROUP SPREAD: 1.783
MIN RADIUS: 0.164
MAX RADIUS: 1.116
MEAN RADIUS: 0.687
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

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

R & E NUMBER	71727		
SERIAL NUMBER	C6348954		
LOG-IN DATE	10-21-03		
INSPECT AND VERIFY:			
OPERATION #	OPERATION NAME	DATE	INITIAL
550	DIS-ASSEMBLE GUN	10-28-03	RTL
560 A	RE-BARREL	10-29-03	RTL
B	DRILL AND TAP	11-4-03	TRW
575	ASSEMBLE	11-03-03	RTL
600	PROOF	11-03-03	AC
605	CHECK HEADSPACE	11-03-03	AC
610	DIS-ASSEMBLE GUN	11-3-03	RTL
612	MAGNAFLUX		
615	ROLLMARK CALIBER	11-5-03	lo
618	ROTO-BLAST		
620	APPLY COATINGS	11-8	TA
625 A	FINAL ASSEMBLY	11-12-03	RTL
B	TRIGGER PULL TEST		
C	SAFETY "ON" FORCE		
D	SAFETY "OFF" FORCE		
E	FIRING PIN INDENT		
640	TARGET	11-13-03	AC
655	FINAL INSPECT	12-15-03	RTL
660	PACK	12/16/03	RA
		SHIP DATE	
QAR INSPECTION DATE			

DA Label 18-1, Sep 83
Edition of Oct 74 will be used until exhausted.

DEPARTMENT OF THE ARMY
C Co 3/1 SFG(A)
Bldg. 9177
Fort Lewis, WA 98433
OFFICIAL BUSINESS



Remington Arms Co., Inc.
ATTN: Fabricated Products Dept.
14 Hoefler Avenue
Ilion, NY 13357-1816

Contract No. DAAE20-97-0242

RECEIVING AND ESTIMATING REPORT

COMMENTS

ORDER
R 99-16107

INITIAL CUSTOMER ORDER NO.

SWS

WOG 1 OF 2
ARMY CAMO

DATE RECEIVED

DATE OPENED

DATE CODE

SERIAL NUMBER

NEW SERIAL NUMBER

MODEL AND GRADE

08/10/99

08/19/99

C6348954

700

7.62NAT

SWS/M24

ACCESSORIES

W/STUDS

SCOPE BASE

ADJ BUTT PLT - PEEP SGT MT

FROM:

SHIP TO:

DEPT. OF THE ARMY
A CO. 3RD BATT. 1ST SP. FORCES
BLDG 9177, BOX 339502
FT LEWIS WA 98433DEPT. OF THE ARMY
A CO. 3RD BATT. 1ST SP. FORCES
BLDG 9177, BOX 339502
FT LEWIS WA 98433

CUST NO: 138744 C.O.D.L

ACCOUNT NUMBER

ACCOUNT NUMBER N/C

WRITE ☐

PROM. DATE

ESTIMATED

VIA

UPS

GUN CONDITION

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

REPAIR CHARGE

EXCISE

TAX

INSURANCE

UPS

PARCEL POST

TOTAL

CUSTOMER CONCERN

AMMO

FUNCTION

FINISH

ACCURACY

FIT

INSPECT

CYCLE

A1

B1

TRIGGER GROUP

B2

E1

F1

BOLT ASSY.

B3

E2

F2

BARREL ASSY.

B4

D1

E3

F3

REC. ASSY.

B5

D2

E4

F4

WOOD

C1

D3

E5

F5

METAL

C2

MAIN FAULT

PARTS

COMMENTS

Trigger Assy 96024

REPAIRMAN

PROOF

CLEAN

TEST

TARGET

PATTERN

GALLERY TESTER

DATE

DATE

DATE

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DATE

OFFICE COPY

RD6925 REV. 7/97

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

M2400042533

DA FORM 2708-1, APR 78 PREVIOUS EDITION WILL BE USED

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

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

USAFPC V1.10

M2400042535

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

USAPPG VI-10

M2400042536

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

DA FORM 2404, APR 79

Replaces edition of 1 Jan 64, which will be used

USAPPC Y1.10

M2400042537

DEPARTMENT OF THE ARMY
COMPANY C, 3D BATTALION, 1st SPECIAL FORCES GROUP (AIRBORNE)
FORT LEWIS, WASHINGTON 98433-7034

AOSO-SFI-TB-C

02 Jun 99

MEMORANDUM FOR: Commander, 542nd Maintenance Company, ATTN: Maintenance Control
Officer, Fort Lewis, WA 98433

SUBJECT: Damage Statement

1. The trigger of the M-24 SWS was observed to be broken after ODA 193 deployed to Cobra Current. The damage occurred during the shipment of the weapons from Ft. Lewis, WA. To San Clemente Island. I have reviewed the damage to the item below, and find no evidence of negligence or misconduct.

NSN	Nomenclature	Serial Number
1005-01-240-2136	M-24 SWS	C6348954

1. I release the item for repair.
2. POC this memorandum is SSG Thacker @ 967-8833


RYAN M. TRITSCHLER
CPT, SF
Detachment Commander

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

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

DA FORM 2404, APR 79

Replaces edition of 1 Jan 64, which will be used

USAPPC V1.10

M2400042539

DATE: 19990723

MAINTENANCE REQUEST

DA FORM 5990-E

CUSTOMER DATA

UIC: WH56AA
UTIL CODE: 0

3/1 SFG(A)

PHONE: (206)967-8970

ACTIVITY DATA

SUP WON:
SUP UIC: WEXQAA

542ND MAINT CO

PHONE: 967-7902
SHOP SEC:

EQUIPMENT DATA

TYPE MNT REQ: 1

ID: A NSN: 1005012402136

MODEL: M24

NOUN: SNIPER RIFLE

SER NUM: ~~C348954~~ *C6348954 JAS*

QTY: 00001

ORG WON: H56AA1905187 PRIORITY: 02

FAILURE DETECTED: D

MI/KM: -----

HOURS: -----

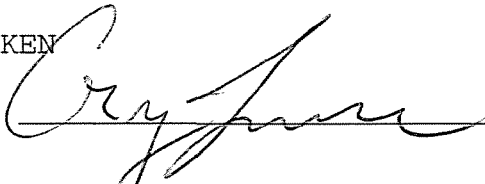
ROUNDS:

IN WARRANTY:

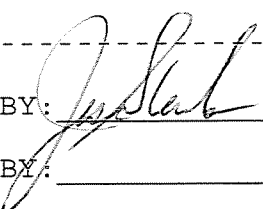
LEVEL OF WORK: F

ADMIN NUM:

DEFICIENCY: TRIGGER BROKEN

PD AUTHENTICATING SIGNATURE: 

SIGNATURE DATA

SUBMITTED BY: 

ORD DATE: _____ MIL TIME: _____

ACCEPTED BY: _____

STATUS: _____ ORD DATE: _____ MIL TIME: _____

ACTION DATA

WORK STARTED BY: _____ STATUS: _____ ORD DATE: _____ MIL TIME: _____

INSPECTED BY: _____ STATUS: _____ ORD DATE: _____ MIL TIME: _____

PICKED UP BY: _____ STATUS: _____ ORD DATE: _____ MIL TIME: _____

COMPLETION DATA

QTY RPR: _____ QTY CONDEMNED: _____ NRTS: _____

EVAC WON: _____ EVAC UNIT NAME: _____

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

SERIAL NO. C6348954
DATE 9-22-99
TESTER RW

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.66	2.81		2.76	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.80	2.69		2.50	
PULL #3	2.73	2.70		2.70	
PULL #4	2.48	2.68		2.71	
PULL #5	2.81	2.80		2.54	
TOTAL	13.48	13.68		13.21	
AVG.	2.70	2.74		2.64	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.36	3.41		
PULL #2	3.31	3.34		
PULL #3	3.28	3.35		
PULL #4	3.33	3.30		
PULL #5	3.36	3.32		
TOTAL	16.64	16.72		
AVG.	3.33	3.34		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.13	4.17		4.10
PULL #2	4.10	4.01		4.07
PULL #3	4.15	4.11		4.11
PULL #4	4.11	4.12		4.18
PULL #5	4.01	4.12		4.19
TOTAL	20.50	20.53		20.65
AVG.	4.10	4.11		4.13

Final Inspection

Sni: C6348 954

DATE REC'D: 8/10/99

DATE RET'D:

AUDITOR:

RW

Item:

BARREL ASSY.

☒ BARREL

☒ RECEIVER

☒ FRONT SIGHT BLOCK

☒ REAR SIGHT BLOCK

☒ SCREWS

☒ FINISH

SCOPE ASSY.

☐ SCOPE

☐ SCOPE RINGS

☐ MOUNTING SCREWS

☒ MOUNTING BASE

☒ SCREWS

☐ FINISH

☐ LOOSENESS

☐ CLARITY

Item:

STOCK ASSY.

☒ STOCK

☒ SLING SWIVEL STUDS

☒ ADJUSTABLE BUTT PLATE

☒ LOCK NUTS

☒ BARREL CLEARANCE

☒ COLOR/FINISH

SYSTEMS CASE

☐ SCOPE CASE

☐ INON SIGHTS

☐ DEPLOYMENT KIT

TRIGGER

☒ SAFETY OPERATION

☒ SET

Comments:

MISC.

☐ DD-250

☐ BAR CODE

☐ PACKAGING

RECEIVING AND ESTIMATING REPORT

COMMENTS

ORDER

R 96-16366

INITIAL
JJM

CUSTOMER ORDER NO.

M-24 SNIPER

DATE RECEIVED
07/15/96DATE OPENED
07/15/96DATE CODE
EJ 10-89SERIAL NUMBER
C6348954

NEW SERIAL NUMBER

MODEL AND GRADE
700 7.62

NATO

ACCESSORIES

W/STUDS

SCOPE BASE

FROM:

DEPT OF THE ARMY
C CO 3RD BN 1ST SFG (A)
FORT LEWIS

WA 98433

SHIP TO:

DEPT OF THE ARMY
C CO 3RD BN 1ST SFG (A)
FORT LEWIS

WA

98433

CUST NO: 145454 C.O.D L

ACCOUNT NUMBER

ACCOUNT NUMBER N/C

WRITE ☐

PROM. DATE

ESTIMATED

VIA

UPS

GUN CONDITION

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

REPAIR CHARGE

EXCISE

TAX

INSURANCE

UPS

PARCEL POST

TOTAL

CUSTOMER CONCERN

AMMO

FUNCTION

FINISH

ACCURACY

FIT

INSPECT

CYCLE

A1

B1

TRIGGER GROUP

B2

E1

F1

BOLT ASSY.

B3

E2

F2

BARREL ASSY.

B4

D1

E3

F3

REC. ASSY.

B5

D2

E4

F4

WOOD

C1

D3

E5

F5

METAL

C2

MAIN FAULT

PARTS

COMMENTS

Barrel 1 96003

Repowder Coat Trigger Guard
Assy. Front & Rear Sight Bases
Rezinc Scope Base & Swivel
Studs

REPAIRMAN

PROOF

CLEAN

TEST

TARGET

PATTERN

GALLERY TESTER

DATE

DATE

DATE

DATE

DATE

OFFICE COPY

RD6925 REV. 1/94

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

M2400042543

EQUIPMENT INSPECTION AND MAINTENANCE WORKSHEET									
For use of this form, see DA PAM 738-750 and 738-751; the proponent agency is DCSLOG									
1. ORGANIZATION C 3RD BN 1ST SFG(A)					2. NOMENCLATURE AND MODEL M24 SWS				
3. REGISTRATION/SERIAL/NSN		4a. MILES	b. HOURS	c. ROUNDS FIRED	d. HOT STARTS	5. DATE		6. TYPE INSPECTION	
7. APPLICABLE REFERENCE									
TM NUMBER			TM DATE		TM NUMBER			TM DATE	
COLUMN a — Enter TM item number. COLUMN b — Enter the applicable condition status symbol. COLUMN c — Enter deficiencies and shortcomings.					COLUMN d — Show corrective action for deficiency or shortcoming listed in Column c. COLUMN e — Individual ascertaining completed corrective action initial in this column.				
STATUS SYMBOLS									
"X"—Indicates a deficiency in the equipment that places it in an inoperable status. CIRCLED "X"—Indicates a deficiency, however, the equipment may be operated under specific limitations as directed by higher authority or as prescribed locally, until corrective action can be accomplished. HORIZONTAL DASH "(—)"—Indicates that a required inspection, component replacement, maintenance operation check, or test flight is due but has not been accomplished, or an overdue MWO has not been accomplished.					DIAGONAL "(/)"—Indicates a materiel defect other than a deficiency which must be corrected to increase efficiency or to make the item completely serviceable. LAST NAME INITIAL IN BLACK, BLUE-BLACK INK, OR PENCIL—Indicates that a completely satisfactory condition exists. FOR AIRCRAFT—Status symbols will be recorded in red.				
ALL INSPECTIONS AND EQUIPMENT CONDITIONS RECORDED ON THIS FORM HAVE BEEN DETERMINED IN ACCORDANCE WITH DIAGNOSTIC PROCEDURES AND STANDARDS IN THE TM CITED HEREON.									
8a. SIGNATURE (Person (s) performing inspection)			8b. TIME		9a. SIGNATURE (Maintenance Supervisor)			9b. TIME	
								10. MANHOURS REQUIRED	
TM ITEM NO. a	STATUS b	DEFICIENCIES AND SHORTCOMINGS c			CORRECTIVE ACTION d			INITIAL WHEN CORRECTED e	
		C6348730			EXCESS OF 10,000 RDS				
		C6225181			PER GUN, EACH NEEDS				
		C6225524			RE-BARRILING				
		C6348969			T/E TRIGGERS/STOCKS				
		C63489154			Repowder (coat				
		C6225270			THESE WEAPONS USED			Trigger Sight	
		C6225467			Rezing Scope Base			5	
		C6348907			SNIPER CLASS, SNIPER				
		C6225409			COMMITTEE SAID THEY				
		C6348868			NEED RE-BARRILING				
		C6225174			DUE TO POOR SHOT PERFORMANCE				
		C6348981			AND EXCESS RDS.				
					7/24/66				
					EACH WEAPON HAS A				
					SCOPE MOUNT				
		P.O.C. SSG DELK							
		3RD BN 1ST SFG(A)							
					(206) 967-8813/8896				

DA FORM 2404
1 APR 79

Replaces edition of 1 Jan 64, which will be used

Final Inspection

Sn: C6348954

DATE REC'D: 7/15/96

DATE RET'D:

Auditor: RW

Item:

Barrel Assy.

☒ BARREL☒ RECEIVER☒ FRONT SIGHT BLOCK☒ REAR SIGHT BLOCK☒ SCREWS☒ FINISH

Scope Assy.

☐ Scope☐ Scope Rings☐ Mounting Screws☐ Mounting Base☐ Screws☐ Finish☐ Looseness☐ CLARITY

Misc.

☐ DD-250☐ BAR CODE☐ PACKAGING

Item:

Stock Assy.

☒ Stock☒ SLING SWIVEL STUDS☒ ADJUSTABLE BUTT PLATE☒ LOCK NUTS☒ BARREL CLEARANCE☒ COLOR/FINISH

Systems Case

☐ Scope Case☐ IRON SIGHTS☐ Deployment Kit

Trigger

☒ SAFETY OPERATION☒ SET

Comments:

M-24

CONTRACT # DAAA21-87-C-0086

Barrel

GUN SERIAL #

C6348954

OP. #	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and Stock		7/24/96	RW
600	Proof		7/24/96	RW
607	Check Headspace		7/24/96	RW
610	Dis-assemble Gun		7/24/96	RW
612	Magnaflux Barrel Action			
	Magnaflux Bolt			
615	Rollmark Caliber			
617	Drill and Tap Sight Holes			
618	Polish Barrel			
620	Apply Coatings (Barrel Action)			
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly			
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head			
	C) Inspect Ejector Hole for Chamfer			
	D) Oil Firing Pin Ass'y			
	E) Adjust Trigger Pull to Min Setting and Stake			

op. #	OP. NAME	READINGS				DATE	INIT
625 cont.	F) Safety On Force						
	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 Clarity of Scope						
645	Inspect for Live Ammo						
655	Final Inspection A) Headspace						
	B) Trigger Pull						
	C) Function						
660	Pack						




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

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

MODEL 700™ H24

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

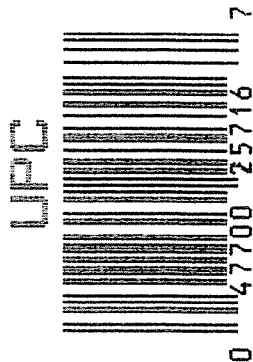
01

SERIAL NO.
C6348954

ORDER NO.
5716



5716 C6348954



0 47700 25716 7



CONTRACT # DAAA21-87-C-0086

Scope
0564

GUN SERIAL # C6348954

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	10-9	89	RW
600	Proof	10-9	89	AC
607	Check Headspace	10-9	89	RW
610	Dis-assemble Gun	10-9	89	RW
612	Magnaflux Barrel Action		10/13/89	KER
	Magnaflux Bolt		10/13/89	KER
615	Rollmark Caliber		10/13/89	G.S.
7	Drill and Tap Sight Holes	10 1689		FB
618	Polish Barrel RB	10 1689		BT
620	Apply Coatings (Barrel Action)		10-27-89	TJA
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		10/30/89	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/30/89	RW
	C) Inspect Ejector Hole for Chamfer		10/30/89	RW
	D) Oil Firing Pin Ass'y		10/30/89	RW
	E) Adjust Trigger Pull to Min Setting and Stake		11/6/89	JU

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			11/7/89	GH
	G) Safety Off Force	2	2	2			11/7/89	GH
	H) Trigger Pull Test & Retainability						11/6/89	JU
	I) Firing Pin Indent	.0205	.0205	.0205			11/7/89	GH
	J) Assemble Stock						11/9/89	RW
	K) Assemble Swivel Studs						11/9/89	RW
	L) Attach Front and Rear Sight Assemblies						11/9/89	RW
	M) Iron Sight Alignment						11/9/89	RW
	N) Detach Front & Rear Sights & place in numbered container						11/9/89	RW
	O) Attach Scope to Rifle						11-9-89	GH
	P) Detach & Attach Scope 20 Times						11-9-89	GH
640	Gallery Target & Test						11-13-89	DH
	A) Time						11-13-89	DH
	B) Malfunctions						11-13-89	DH
	C) Pierced Primers						11-13-89	DH
	D) Optical Clarity of Scope						11-13-89	DH
645	Inspect for Live Ammo						11-13-89	DH
655	Final Inspection							
	A) Headspace						14 NOV 89	JS
	B) Trigger Pull	258	274	222	264	232	14 NOV 89	JS
	C) Function						14 NOV 89	JS
660	Pack						14 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. CG348954

DATE 3/29/90

TESTER DH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#	COMMENTS
PULL #1	2.54	2.35	2.52	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.52	2.35	2.42	
PULL #3	2.53	2.34	2.30	
PULL #4	2.54	2.34	2.44	
PULL #5	2.52	2.36	2.41	
TOTAL	12.65	11.74	12.09	
AVG.	2.53	2.34	2.41	

	3.00# INITIAL	3.00# AFTER 20 CYCLES	COMMENTS
PULL #1	3.13	3.33	
PULL #2	3.03	3.28	
PULL #3	3.02	3.24	
PULL #4	3.05	3.22	
PULL #5	3.06	3.20	
TOTAL	15.29	16.27	
AVG.	3.05	3.25	

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.19	4.13		
PULL #2	4.16	4.06		
PULL #3	4.15	4.10		
PULL #4	4.12	4.10		
PULL #5	4.13	4.07		
TOTAL	20.75	20.46		
AVG.	4.13	4.09		

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6348954
13 Nov 1989

CENTROIDAL DISTANCES

0	TO	1	.552496
1	TO	2	.362012
1	TO	3	.628761
1	TO	4	.425484
1	TO	5	.799918

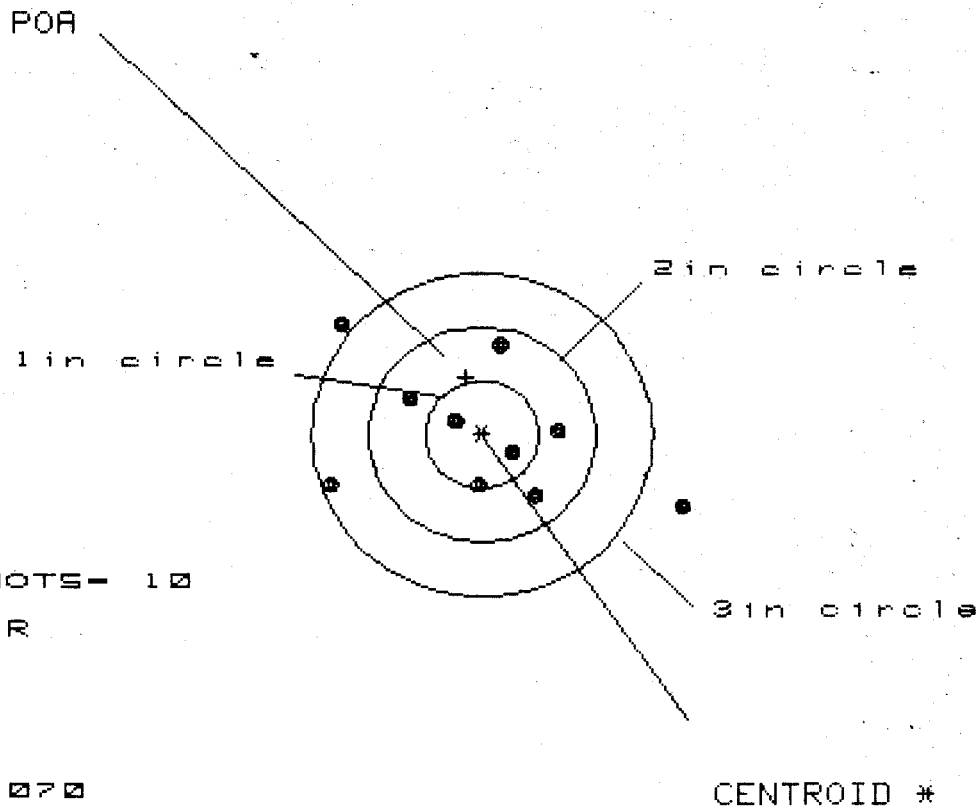
$\frac{3+5}{4+2}$ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1104
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.2656
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .287631
THE AMR FOR THIS RIFLE IS: .9106

13 Nov 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C6348954

CENTERFIRE PATTERNS # 1



OF SHOTS- 10
 # IN CIR
 1in = 3
 2in = 7
 3in = 8
 HS= 3.070
 VS= 1.727
 GS= 3.459

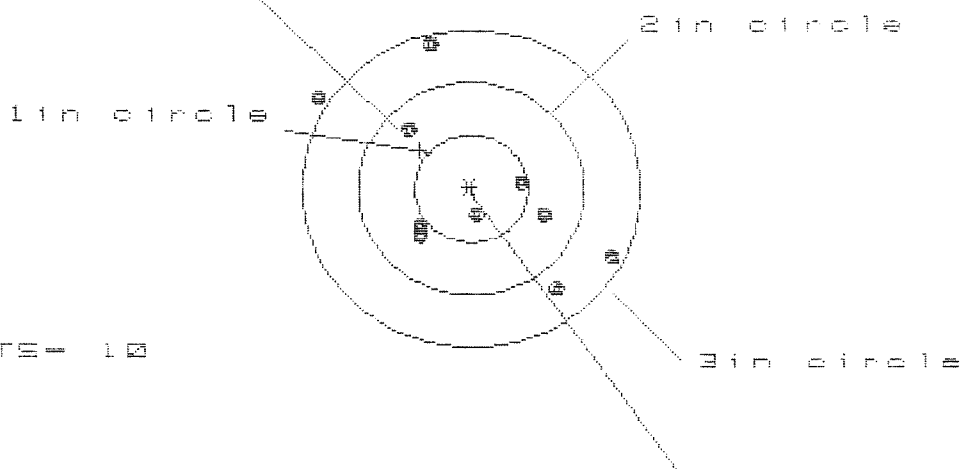
PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.781	.912	.784
MINIMUM X	:	-1.289	-1.091	-1.219
MAXIMUM Y	:	1.030	.952	.896
MINIMUM Y	:	-.697	-.676	-.556
CENTROID X	:	.134	-.064	.064
CENTROID Y	:	-.536	-.458	-.577
POA TO CENTROID in.	:	.552	.463	.581
MIN RADIUS	:	.291	.079	.250
MEAN RADIUS	:	.903	.783	.690
MAX RADIUS	:	1.912	1.394	1.300
HORIZONTAL SPREAD	:	3.070	2.003	2.003
VERTICAL SPREAD	:	1.727	1.628	1.453
EXTREME SPREAD	:	3.459	2.360	2.061
NUMBER IN ONE INCH CIRCLE =			3	
NUMBER IN TWO INCH CIRCLE =			7	
NUMBER IN THREE INCH CIRCLE =			8	

13 Nov 1985

FILE:/PATTERNING/CENTERFIRE_PATT/C8348954

CENTERFIRE PATTERNS # 2

POA



OF SHOTS = 10

IN CIR

1in = 2

2in = 6

3in = 8

HS = 2.639

VS = 2.299

GS = 3.036

CENTROID *

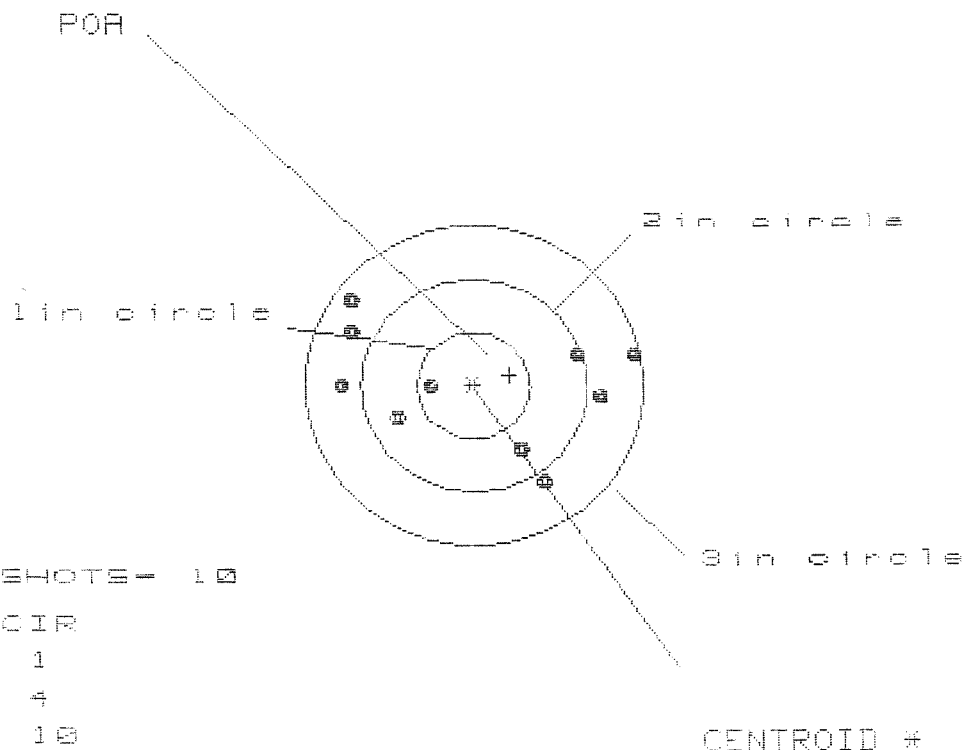
PATTERN # : 2

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.292	1.142	.699
MINIMUM X	-1.347	-.718	-.575
MAXIMUM Y	1.378	1.470	1.396
MINIMUM Y	-.921	-.829	-.903
CENTROID X	.452	.602	.459
CENTROID Y	-.363	-.455	-.382
POA TO CENTROID in.	.580	.754	.597
MIN RADIUS	.216	.152	.196
MEAN RADIUS	.902	.800	.743
MAX RADIUS	1.579	1.544	1.436
HORIZONTAL SPREAD	2.639	1.860	1.274
VERTICAL SPREAD	2.299	2.299	2.299
EXTREME SPREAD	3.036	2.614	2.520
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	9		

13 Nov 1989

FILE:/PATTERNING/CENTERFIRE_PATT/06348954

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 1

2in = 4

3in = 10

HS= 2.561

VS= 1.777

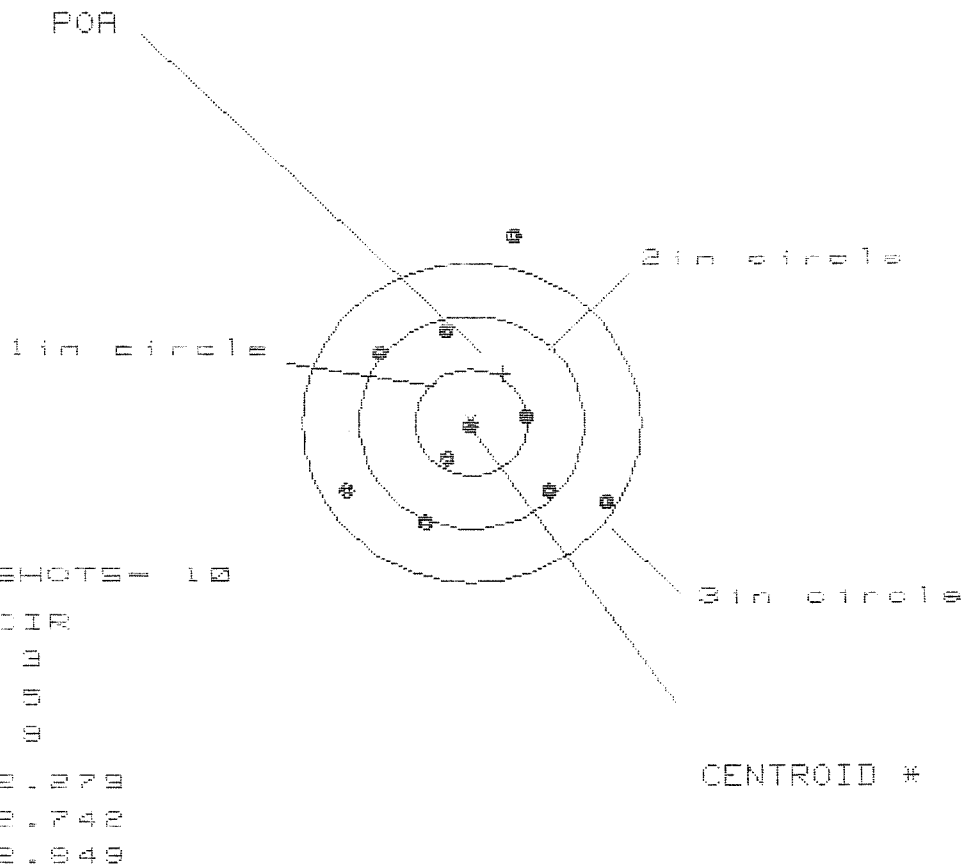
GS= 2.575

PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	1.375
MINIMUM X	-1.186
MAXIMUM Y	.844
MINIMUM Y	-.933
CENTROID X	-.320
CENTROID Y	-.101
POA TO CENTROID in.	.336
MIN RADIUS	.400
MEAN RADIUS	1.016
MAX RADIUS	1.399
HORIZONTAL SPREAD	2.561
VERTICAL SPREAD	1.777
EXTREME SPREAD	2.575
NUMBER IN ONE INCH CIRCLE =	1
NUMBER IN TWO INCH CIRCLE =	4
NUMBER IN THREE INCH CIRCLE =	10

13 Nov 1989

FILE:/PATTERNING/CENTERFIRE_PATT/06348954

CENTERFIRE PATTERNS # 4

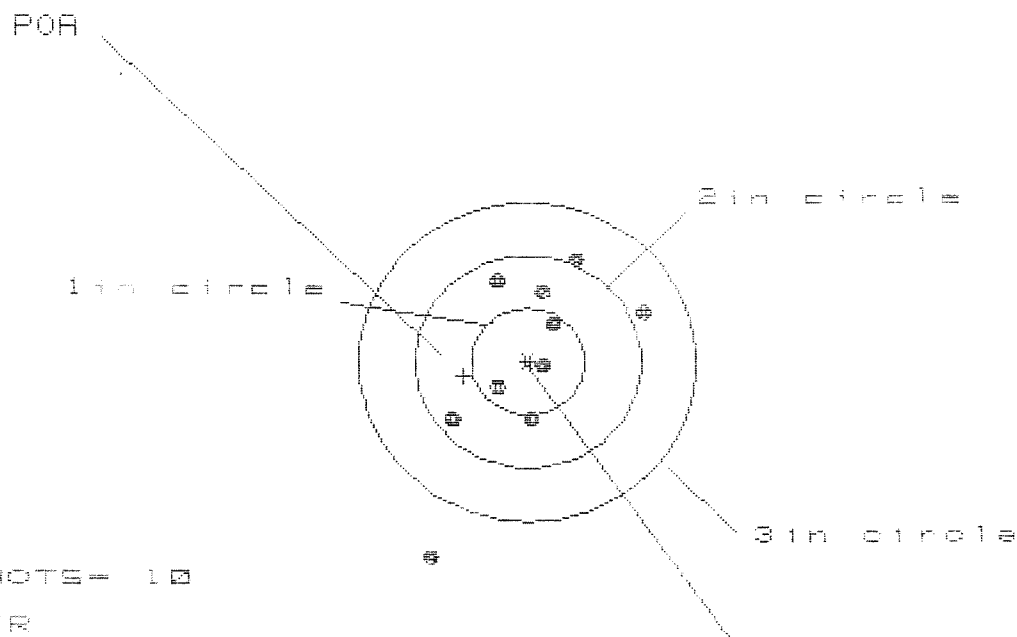


PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.207	1.246	.901
MINIMUM X	:	-1.072	-1.033	-.877
MAXIMUM Y	:	1.768	1.018	.950
MINIMUM Y	:	-.974	-.773	-.846
CENTROID X	:	-.285	-.324	-.480
CENTROID Y	:	-.462	-.658	-.590
POA TO CENTROID in.	:	.543	.734	.761
MIN RADIUS	:	.033	.167	.212
MEAN RADIUS	:	.932	.825	.754
MAX RADIUS	:	1.802	1.360	1.016
HORIZONTAL SPREAD	:	2.279	2.279	1.778
VERTICAL SPREAD	:	2.742	1.796	1.796
EXTREME SPREAD	:	2.849	2.453	1.953
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

13 Nov 1985

FILE:/PATTERNING/CENTERFIRE_PATT/0834B354

CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1 in = 3

2 in = 7

3 in = 9

HS= 1.931

VS= 2.889

GS= 3.107

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	1.042
MINIMUM X	-.889
MAXIMUM Y	.929
MINIMUM Y	-1.880
CENTROID X	.571
CENTROID Y	.134
POA TO CENTROID in.	.587
MIN RADIUS	.114
MEAN RADIUS	.800
MAX RADIUS	2.880
HORIZONTAL SPREAD	1.931
VERTICAL SPREAD	2.889
EXTREME SPREAD	3.107
NUMBER IN ONE INCH CIRCLE =	3
NUMBER IN TWO INCH CIRCLE =	7
NUMBER IN THREE INCH CIRCLE =	9