

C6348966

MODEL 700TM M24

Model **SMS** TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington



RECORDS CONTROL SCHEDULE

RECORDS CATEGORY OR TITLE:

120 - AUTHORIZATION SCHEDULE

ILION PLANT

COPY "O" (OFFICIAL) ☐ "X" (EXTRA) ☒

TOTAL RETENTION: MAX. UNTIL SUPERSEDED
OR OBSOLETE

GS-11050 Rev. 8/78

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

M2400042813

SCHEDULE
ANT

Repair Inquiry

Repair Number: **RE00071773**

Serial: C6348966 Model 700 Center Fire Caliber: 7
62 NATO M24 SWS

Repairman:

Verify Repair

Status:

Closed 10/21/2003 11:51:41 AM

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

FFL:

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
A016	Scope Mounts	2
A017	Scope Base	1

Repair Search

Refresh

Close

naglej

10/21/2003

12:42 PM

CAPS

NUM

INS

SCFL

start

2 Mic

5 Mic

Trap Dr

Arms S

Part 66

Adapt

RE 07

12:42 PM

Serial Number:

C6348966

Model: **700**



RE00071773

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50 LBS (plus or minus 0.50 LBS)
3.00 LBS (plus or minus 0.75 LBS)
4.00 LBS (plus or minus 1.00 LBS)

SERIAL NO. _____

DATE 10-27-03

TESTER TRW

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.03	2.25		2.04	
PULL #2	2.30	2.45		2.14	
PULL #3	2.27	2.42		2.11	
PULL #4	2.39	2.06		2.17	
PULL #5	2.12	2.45		2.15	
TOTAL	11.11	11.63		10.61	
AVERAGE	2.22	2.32		2.12	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.22	3.00		
PULL #2	3.09	3.16		
PULL #3	3.16	3.02		
PULL #4	3.12	2.79		
PULL #5	3.06	3.01		
TOTAL	15.65	14.98		
AVERAGE	3.13	2.99		

	4.00 LBS INITIAL	4.00 LBS AFTER 20 CYCLES	MAX SETTING GREATER THAN 4 LBS	RESET TO 4 LBS FOR TARGET & ACCURACY
PULL #1	4.23	4.15		4.13
PULL #2	4.32	4.04		4.18
PULL #3	4.43	4.09		4.13
PULL #4	4.33	4.20		4.11
PULL #5	4.35	3.84		4.24
TOTAL	21.66	20.32		20.79
AVERAGE	4.33	4.06		4.15

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6348966.__0

FILE DATE AND TIME: 11/14/2003 13:20

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.112
The Average Y Centroid of the Five Target Set:	-0.042
The Average Point of Impact of the Five Target Set:	0.119
The Average Mean Radius of the Five Target Set:	0.553
The Distance from POA to Centroid Target #1:	0.539
The Distance from Centroid Target #2 to Centroid Target #1:	0.481
The Distance from Centroid Target #3 to Centroid Target #1:	0.657
The Distance from Centroid Target #4 to Centroid Target #1:	0.385
The Distance from Centroid Target #5 to Centroid Target #1:	0.580

SERIAL NUMBER: C6348966. __0

TARGET NUMBER: 1

FILE DATE: 11/14/2003

FILE TIME: 13:20

POINT#	X	Y
1:	-1.818	-0.519
2:	-1.011	-0.432
3:	-0.519	-1.228
4:	-0.569	-0.515
5:	-0.501	-0.082
6:	-0.657	0.060
7:	-0.377	0.602
8:	-0.005	0.400
9:	0.350	-0.010
10:	0.002	-0.003

X CENTROID: -0.511

Y CENTROID: -0.173

POA TO CENTROID: 0.539

HORZ SPREAD: 2.168

VERT SPREAD: 1.830

GROUP SPREAD: 2.227

MIN RADIUS: 0.091

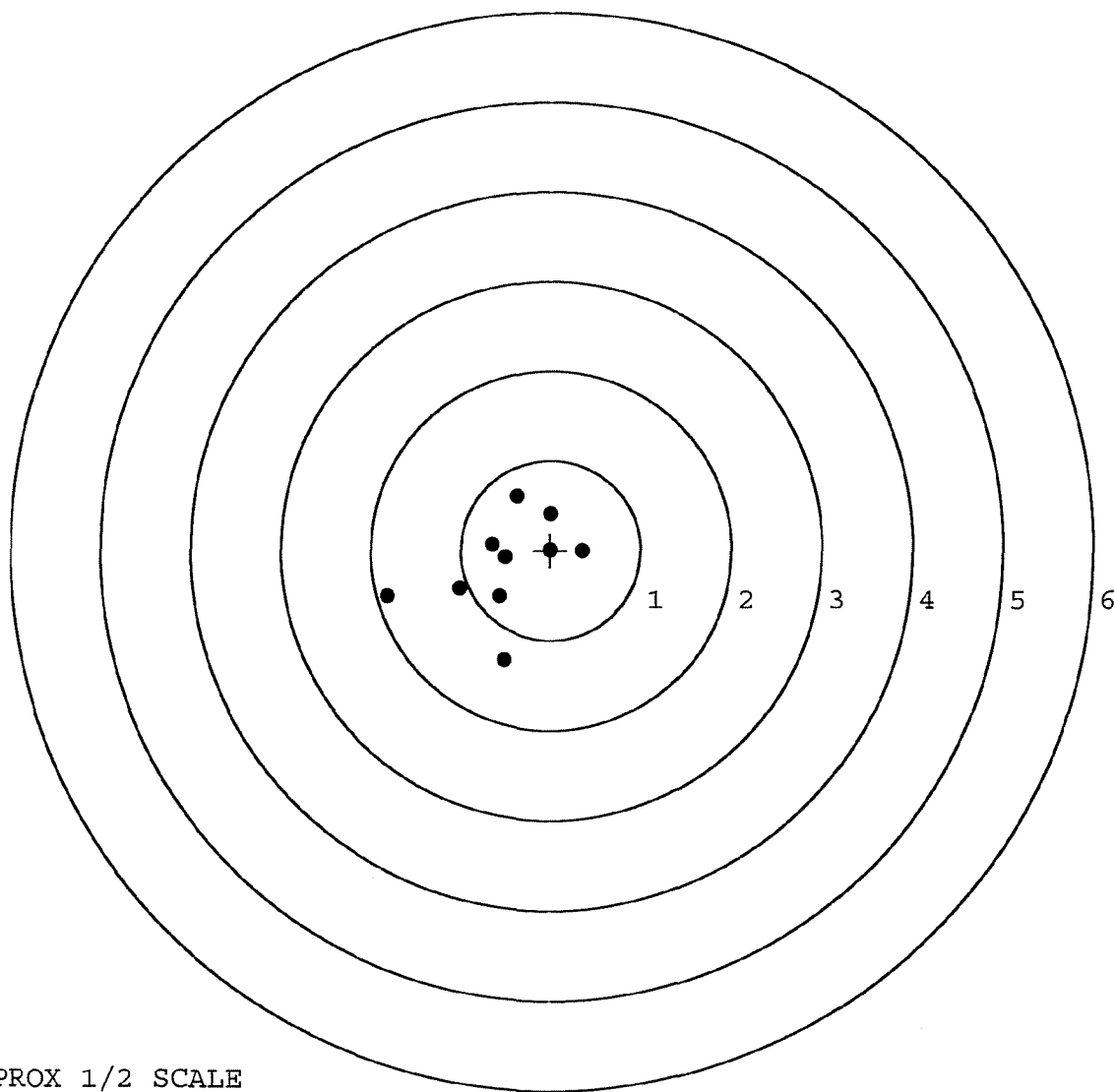
MAX RADIUS: 1.353

MEAN RADIUS: 0.665

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6348966. __0

TARGET NUMBER: 2

FILE DATE: 11/14/2003

FILE TIME: 13:20

POINT#	X	Y
1:	0.251	0.848
2:	0.440	0.034
3:	0.025	-0.765
4:	-0.068	-0.510
5:	-0.094	-0.297
6:	-0.687	0.235
7:	-0.387	0.338
8:	-0.187	0.195
9:	0.004	-0.137
10:	0.065	0.112

X CENTROID: -0.064

Y CENTROID: 0.005

POA TO CENTROID: 0.064

HORZ SPREAD: 1.127

VERT SPREAD: 1.613

GROUP SPREAD: 1.629

MIN RADIUS: 0.158

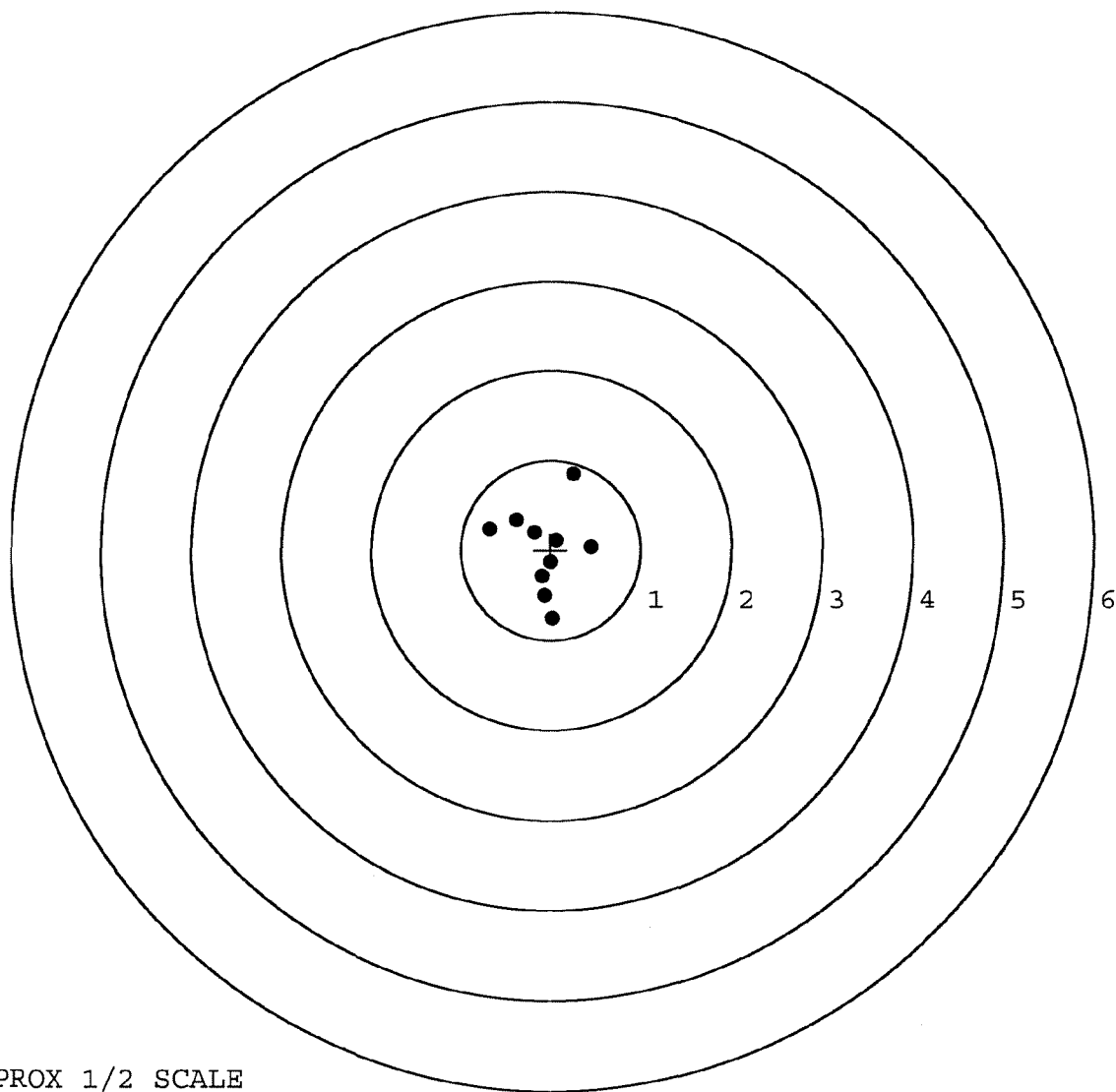
MAX RADIUS: 0.900

MEAN RADIUS: 0.468

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6348966. __0

TARGET NUMBER: 3

FILE DATE: 11/14/2003

FILE TIME: 13:20

POINT#	X	Y
1:	1.155	0.281
2:	0.827	-0.614
3:	0.180	-0.384
4:	-0.355	-0.390
5:	-0.592	0.282
6:	-0.066	0.328
7:	-0.208	0.072
8:	0.284	0.135
9:	0.080	-0.006
10:	-0.026	0.128

X CENTROID: 0.128

Y CENTROID: -0.017

POA TO CENTROID: 0.129

HORZ SPREAD: 1.747

VERT SPREAD: 0.942

GROUP SPREAD: 1.747

MIN RADIUS: 0.049

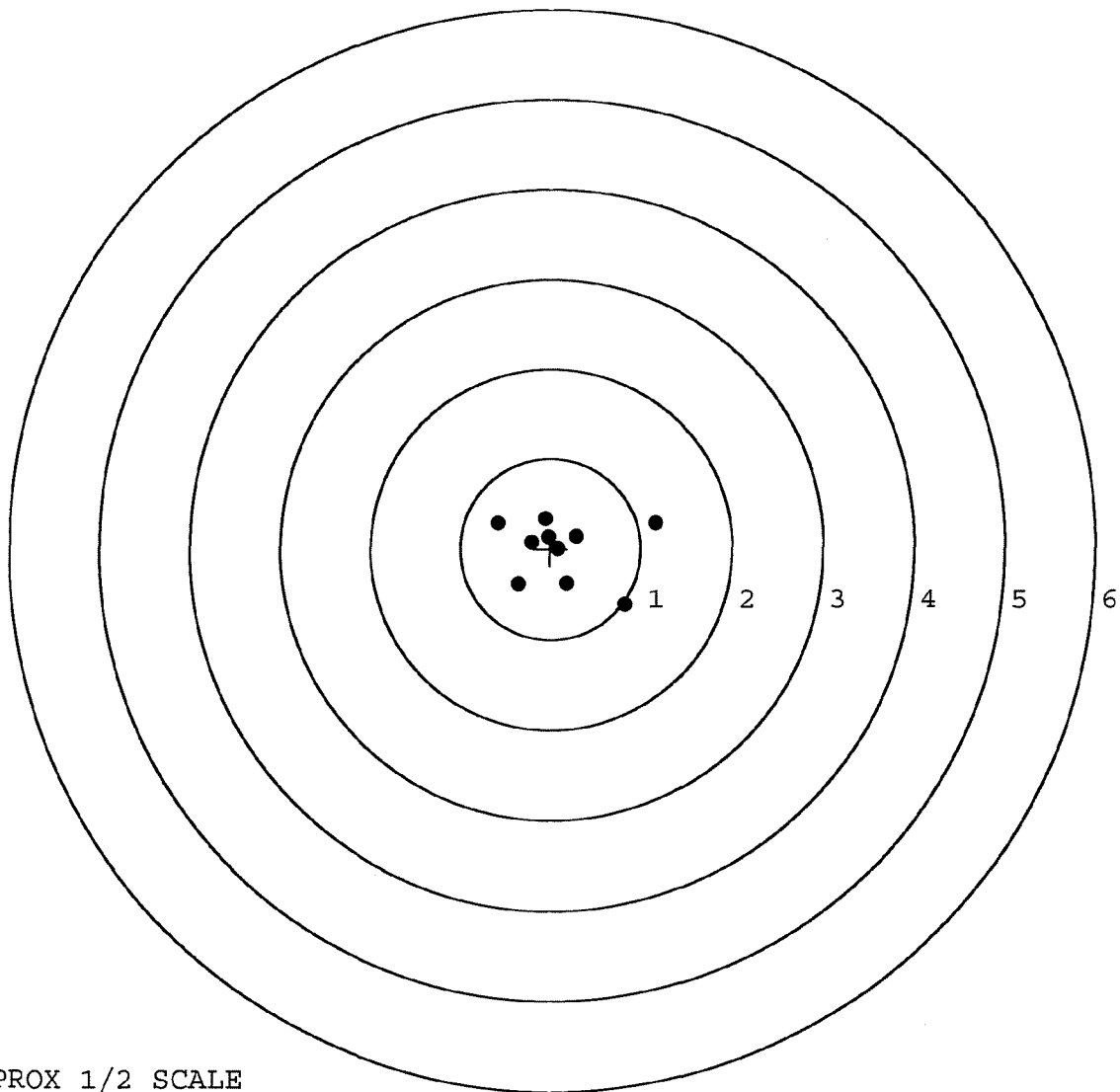
MAX RADIUS: 1.069

MEAN RADIUS: 0.497

IN 1 IN DIAMETER: 6

IN 2 IN DIAMETER: 9

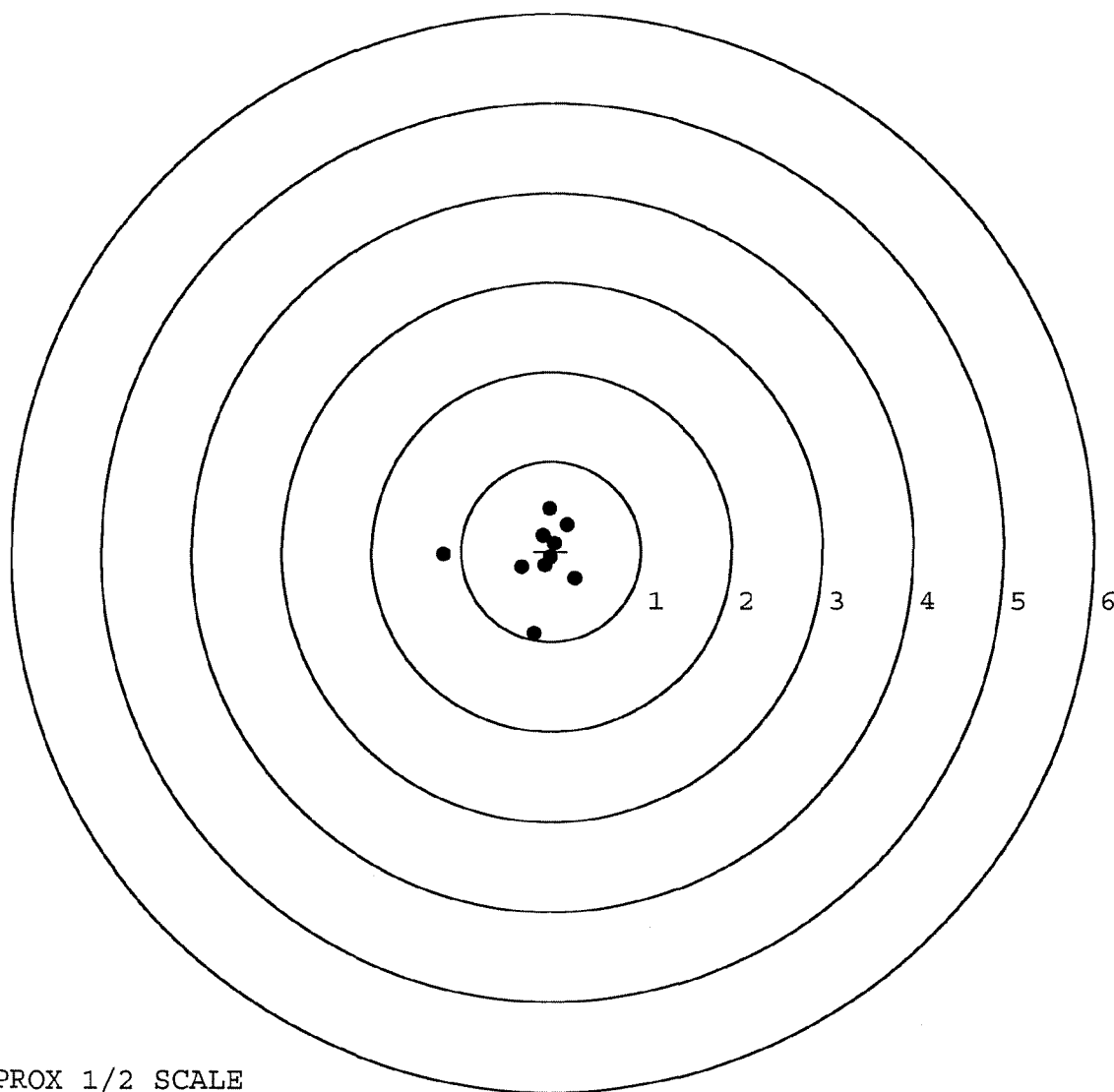
in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6348966. __0
TARGET NUMBER: 4
FILE DATE: 11/14/2003
FILE TIME: 13:20

	POINT#	X	Y
	1:	-1.194	-0.038
	2:	-0.193	-0.919
	3:	0.270	-0.303
	4:	-0.331	-0.179
X CENTROID:	5:	-0.021	0.478
Y CENTROID:	6:	0.176	0.299
POA TO CENTROID:	7:	0.044	0.090
HORZ SPREAD:	8:	-0.092	0.175
VERT SPREAD:	9:	-0.010	-0.072
GROUP SPREAD:	10:	-0.070	-0.156
MIN RADIUS:		0.118	
MAX RADIUS:		1.052	
MEAN RADIUS:		0.438	
# IN 1 IN DIAMETER:		7	
# IN 2 IN DIAMETER:		9	
# in 3 IN DIAMETER:		10	

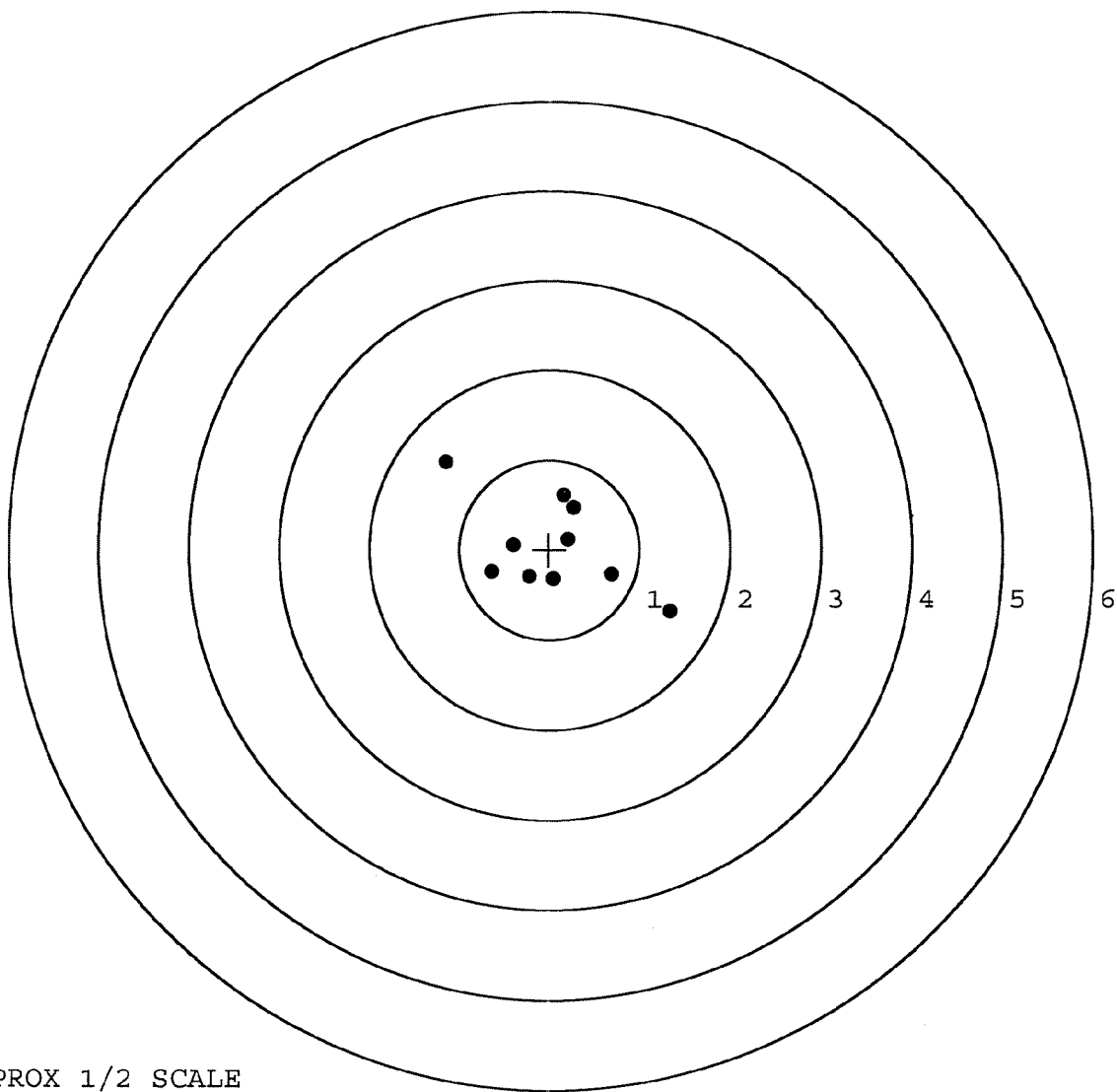


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6348966.____0
TARGET NUMBER: 5
FILE DATE: 11/14/2003
FILE TIME: 13:20

POINT#	X	Y
1:	-1.151	0.974
2:	-0.646	-0.252
3:	-0.406	0.052
4:	-0.221	-0.301
5:	0.051	-0.327
6:	0.699	-0.277
7:	1.334	-0.690
8:	0.164	0.612
9:	0.272	0.468
10:	0.208	0.116

X CENTROID: 0.030
Y CENTROID: 0.037
POA TO CENTROID: 0.048
HORZ SPREAD: 2.485
VERT SPREAD: 1.664
GROUP SPREAD: 2.991
MIN RADIUS: 0.194
MAX RADIUS: 1.508
MEAN RADIUS: 0.698
IN 1 IN DIAMETER: 5
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

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

R & E NUMBER	71773		
SERIAL NUMBER	C6348966		
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	11-3-03	RTL
600	PROOF	11-3-03	AC
605	CHECK HEADSPACE	11-3-03	AC
610	DIS-ASSEMBLE GUN	11-3-03	RTL
612	MAGNAFLUX	11-3-03	RTL
615	ROLLMARK CALIBER	11-5-03	AS
618	ROTO-BLAST		
620	APPLY COATINGS	11-8	TA
625 A	FINAL ASSEMBLY	11-12-03	RTL
B	TRIGGER PULL TEST	12-15-03	RTL
C	SAFETY "ON" FORCE	12-15-03	RTL
D	SAFETY "OFF" FORCE	12-15-03	RTL
E	FIRING PIN INDENT		
640	TARGET	11-14-03	AC
655	FINAL INSPECT	12-15-03	RTL
660	PACK	12/16/03	RAA
		SHIP DATE	
		QAR INSPECTION DATE	




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

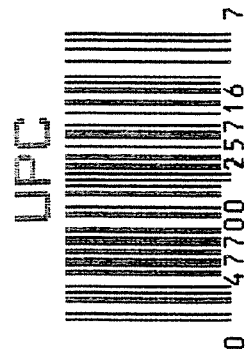
REG. U.S. PAT. & TM. OFF.

MODEL 700TM H24

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

SERIAL NO.
C6348966

ORDER NO.
5716



GUN SERIAL #

C6348966

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	9 26	89	RW
600	Proof	9 26	89	RW
607	Check Headspace	9 26	89	RW
610	Dis-assemble Gun	9 26	89	RW
612	Magnaflux Barrel Action	9/29/89		KCR
	Magnaflux Bolt	9/29/89		KCR
615	Rollmark Caliber	9/29/89		LB
7	Drill and Tap Sight Holes	9 29	89	LB
618	Polish Barrel RB	9 29	89	BT
620	Apply Coatings (Barrel Action)		10-11-89	TJA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		10/12/89	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/12/89	RW
	C) Inspect Ejector Hole for Chamfer		10/12/89	RW
	D) Oil Firing Pin Ass'y		10/12/89	RW
	E) Adjust Trigger Pull to Min Setting and Stake		26 Oct 89	LB

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			10/26/89	JS
	G) Safety Off Force	4	4	4			10/26/89	JS
	H) Trigger Pull Test & Retainability						26 Oct 89	JS
	I) Firing Pin Indent	.0225	.0225	.022			10/26/89	JS
	J) Assemble Stock						10/26/89	JS
	K) Assemble Swivel Studs						30 Oct 89	JS
	L) Attach Front and Rear Sight Assemblies						10/26/89	JS
	M) Iron Sight Alignment						10/26/89	JS
	N) Detach Front & Rear Sights & place in numbered container						10/26/89	JS
	O) Attach Scope to Rifle						10/26/89	JS
	P) Detach & Attach Scope 20 Times						10/26/89	JS
640	Gallery Target & Test						10-27-89	AC
	A) Time						10-27-89	AC
	B) Malfunctions						10-27-89	AC
	C) Pierced Primers						10-27-89	AC
	D) Optical Clarity of Scope						10-27-89	AC
	645	Inspect for Live Ammo						10-27-89
655	Final Inspection							
	A) Headspace						30 Oct 89	JS
	B) Trigger Pull	264	266	270	275	270	30 Oct 89	JS
	C) Function						30 Oct 89	JS
660	Pack						18 Dec 89	JS

SWS TRIGGER PULL TEST

TIME

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#
3.00# ± .75#
4.00# ± 1.00#

SERIAL NO. C6348966

DATE 3-29-90

TESTER JU

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.44	2.35		2.45	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.30	2.29		2.32	
PULL #3	2.36	2.26		2.25	
PULL #4	2.37	2.20		2.35	
PULL #5	2.47	2.40		2.23	
TOTAL	11.94	11.30		11.60	
AVG.	2.388	2.26		2.32	

	3.00# INITIAL	3.00# AFTER 20 CYCLES			COMMENTS
PULL #1	3.21	3.35			
PULL #2	3.40	3.31			
PULL #3	3.37	3.37			
PULL #4	3.34	3.33			
PULL #5	3.41	3.40			
TOTAL	16.73	16.76			
AVG.	3.346	3.352			

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.29	4.39		
PULL #2	4.56	4.38		
PULL #3	4.38	4.32		
PULL #4	4.45	4.44		
PULL #5	4.47	4.44		
TOTAL	22.15	21.97		
AVG.	4.43	4.394		

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6348966
27 Oct 1989

CENTROIDAL DISTANCES

0 TO	1	.218277
1 TO	2	.0475184
1 TO	3	.918976
1 TO	4	.881944
1 TO	5	.489965

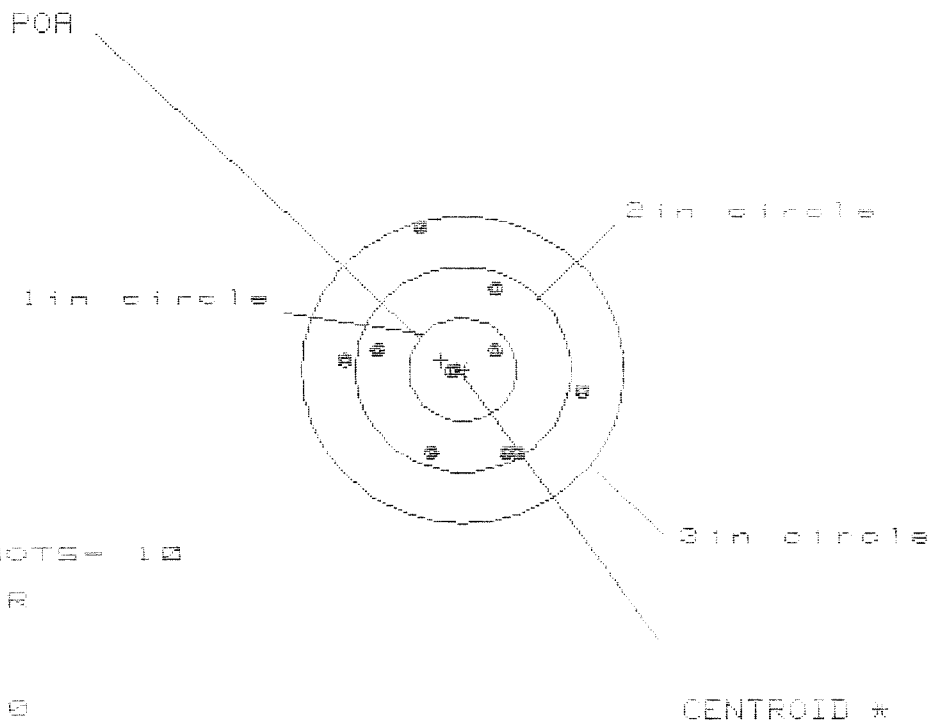
4
+-----POB
3 5

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1182
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1474
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .188939
THE AMR FOR THIS RIFLE IS: .9356

27 Oct 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C8348366

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 2

2in = 7

3in = 10

HS= 2.117

VS= 2.237

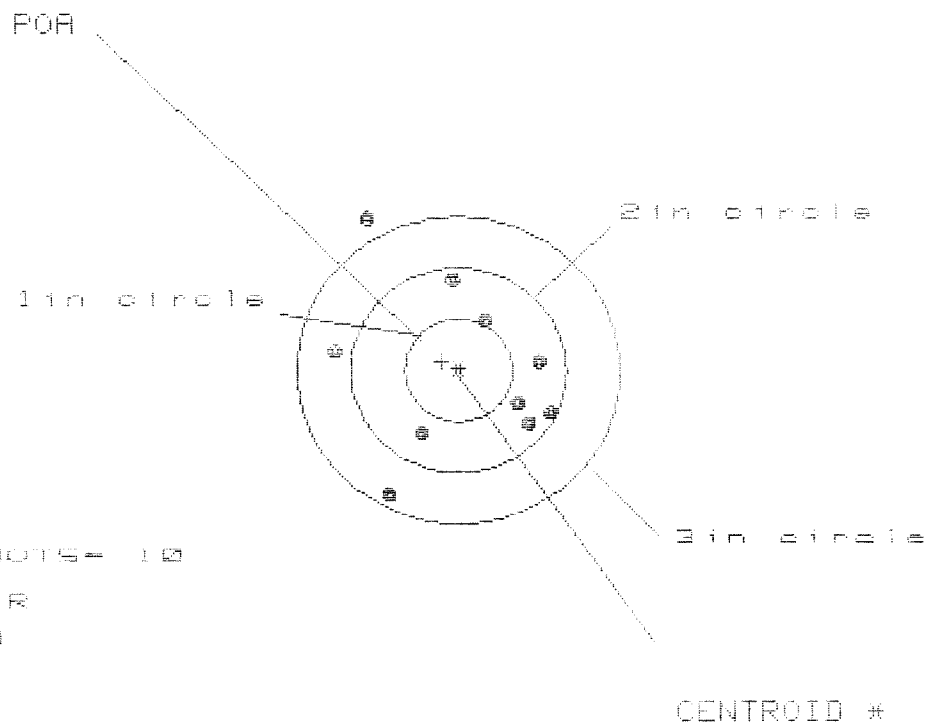
GS= 2.415

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.060	1.017	.635
MINIMUM X	:	-1.057	-1.100	-.973
MAXIMUM Y	:	1.413	.906	.894
MINIMUM Y	:	-.824	-.667	-.679
CENTROID X	:	.197	.240	.113
CENTROID Y	:	-.094	-.251	-.239
POA TO CENTROID in.	:	.218	.347	.264
MIN RADIUS	:	.056	.186	.149
MEAN RADIUS	:	.839	.771	.732
MAX RADIUS	:	1.464	1.125	.999
HORIZONTAL SPREAD	:	2.117	2.117	1.608
VERTICAL SPREAD	:	2.237	1.573	1.573
EXTREME SPREAD	:	2.415	2.143	1.840
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

27 Oct 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C8346966

CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1in = 0

2in = 7

3in = 8

HE = 1.993

VS = 2.698

GS = 2.762

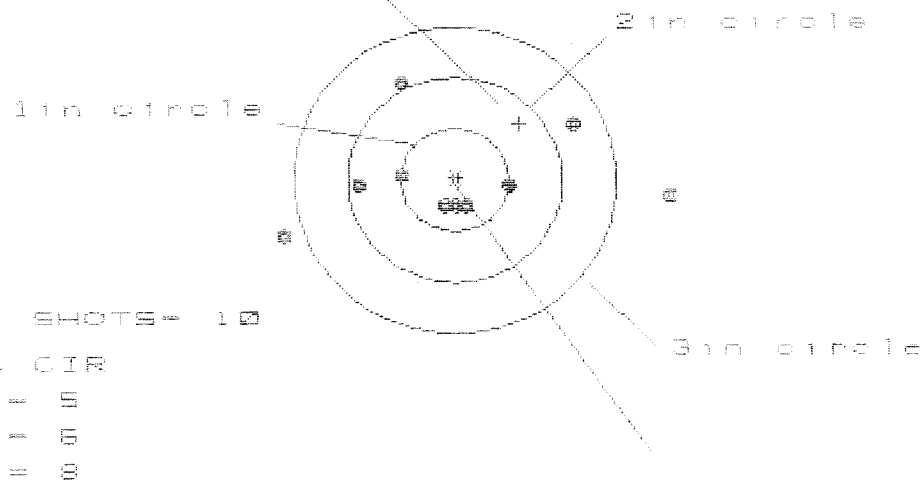
PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.881	.791	.698
MINIMUM X	:	-1.112	-1.202	-1.295
MAXIMUM Y	:	1.469	1.025	.892
MINIMUM Y	:	-1.229	-1.066	-.626
CENTROID X	:	.150	.240	.333
CENTROID Y	:	-.087	-.250	-.117
FOR TO CENTROID in.	:	.173	.347	.353
MIN RADIUS	:	.528	.450	.445
MEAN RADIUS	:	.948	.839	.756
MAX RADIUS	:	1.678	1.302	1.318
HORIZONTAL SPREAD	:	1.993	1.993	1.993
VERTICAL SPREAD	:	2.698	2.091	1.518
EXTREME SPREAD	:	2.762	2.176	2.078
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

27 Oct 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C8348368

CENTERFIRE PATTERNS # 3

FOR



OF SHOTS= 10

IN CIR

1in = 5

2in = 5

3in = 8

HS= 3.591

VS= 1.444

GS= 3.612

CENTROID #

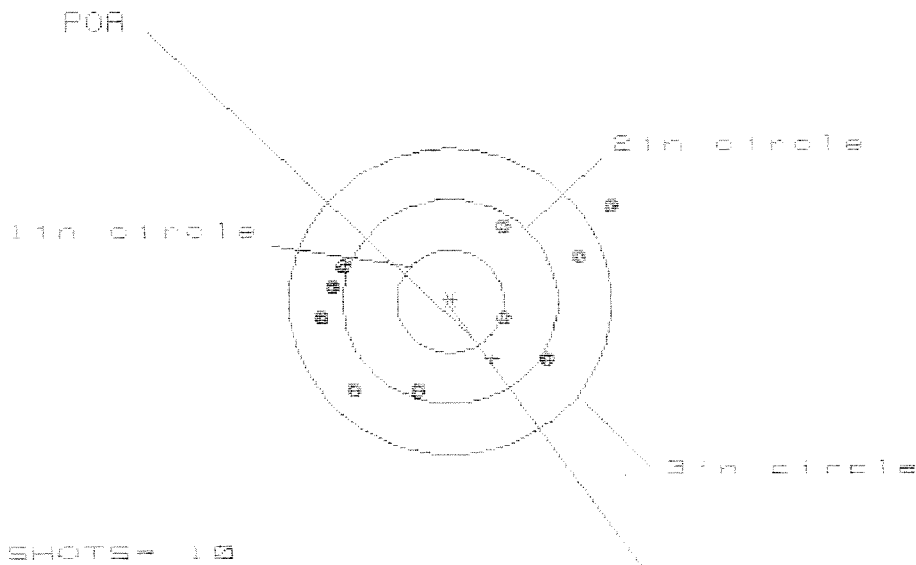
PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.968	1.334	1.158
MINIMUM X	-1.623	-1.404	-1.896
MAXIMUM Y	.929	.915	.849
MINIMUM Y	-.515	-.529	-.370
CENTROID X	-.602	-.821	-.645
CENTROID Y	-.548	-.534	-.468
FOR TO CENTROID in.	.814	.979	.797
MIN RADIUS	.218	.278	.304
MEAN RADIUS	.871	.743	.647
MAX RADIUS	1.972	1.501	1.261
HORIZONTAL SPREAD	3.591	2.738	2.054
VERTICAL SPREAD	1.444	1.444	1.219
EXTREME SPREAD	3.612	2.948	2.159
NUMBER IN ONE INCH CIRCLE =	5		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	8		

27 Oct 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C8348986

CENTERFIRE PATTERNS

4



OF SHOTS- 10

IN CIR

1 in = 0

2 in = 3

3 in = 0

ME = 2.610

VS = 1.810

ES = 2.990

CENTROID #

PATTERN #	4		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.453	1.342	1.245
MINIMUM X	-1.165	-1.004	-1.101
MAXIMUM Y	.929	.836	.739
MINIMUM Y	-.881	-.778	-.827
CENTROID X	-.398	-.559	-.462
CENTROID Y	.557	.454	.551
POB TO CENTROID IN.	.684	.720	.719
MIN RADIUS	.560	.700	.621
MEAN RADIUS	1.107	1.023	1.009
MAX RADIUS	1.724	1.446	1.321
HORIZONTAL SPREAD	2.610	2.346	2.346
VERTICAL SPREAD	1.810	1.614	1.566
EXTREME SPREAD	2.990	2.494	2.418
NUMBER IN ONE INCH CIRCLE	=	0	
NUMBER IN TWO INCH CIRCLE	=	3	
NUMBER IN THREE INCH CIRCLE	=	9	

27 Oct 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C6346366

CENTERFIRE PATTERNS # 5

POA

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 2

2 in = 6

3 in = 8

HS= 3.325

VS= 2.367

GS= 3.227

CENTROID #

PATTERN #	5	5	5
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.755	1.144	.987
MINIMUM X	-1.450	-1.255	-.777
MAXIMUM Y	1.013	1.031	1.005
MINIMUM Y	-1.354	-1.335	-1.361
CENTROID X	.062	-.133	.023
CENTROID Y	-.565	-.583	-.558
POA TO CENTROID in.	.569	.598	.558
MIN RADIUS	.050	.230	.074
MEAN RADIUS	.913	.808	.736
MAX RADIUS	1.753	1.339	1.363
HORIZONTAL SPREAD	3.205	2.399	1.765
VERTICAL SPREAD	2.367	2.367	2.367
EXTREME SPREAD	3.227	2.442	2.442
NUMBER IN ONE INCH CIRCLE	=	2	
NUMBER IN TWO INCH CIRCLE	=	6	
NUMBER IN THREE INCH CIRCLE	=	9	

RECEIVING AND ESTIMATING REPORT

COMMENTS

ORDER

R 96-09649

INITIAL
JJM

CUSTOMER ORDER NO.

M-24 SNIPER

DATE RECEIVED
04/08/96DATE OPENED
04/08/96DATE CODE
EJ 10-89SERIAL NUMBER
C6348966

NEW SERIAL NUMBER

MODEL AND GRADE

700 7.62

NATO

ACCESSORIES

W/STUDS

SCOPE BASE

FROM:

COMMANDER
B CO 1ST SPECIAL FORCES
COMMAND 3RD BN - BOX 339502
FT LEWIS WA 98433

SHIP TO:

COMMANDER
B CO 1ST SPECIAL FORCES
COMMAND 3RD BN - BOX 339502
FT LEWIS WA
98433

CUST NO: 141138 C.O.D L

ACCOUNT NUMBER

ACCOUNT NUMBER N/C

WRITE ☐

FROM 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 - 96003

Repowder Coat Trigger Guard
Assy Front & Rear Sight Bases
Re-zinc Scope Base & Swivel
Studs

REPAIRMAN

PROOF

CLEAN

TEST

TARGET

PATTERN

GALLERY TESTER

DATE

DATE

DATE

DATE

DATE

RW

✓

✓

✓

✓

RW

4/15/96

4/23/96

4/23/96

4/23/96

OFFICE COPY

RD5925 REV. 1/94

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

M2400042834

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6348966

OP. #	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and Stock		4/15/96	RW
600	Proof		4/15/96	RW
607	Check Headspace		4/15/96	RW
610	Dis-assemble Gun		4/15/96	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		4/22/96	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		4/22/96	RW
	C) Inspect Ejector Hole for Chamfer		4/22/96	RW
	D) Oil Firing Pin Ass'y		4/22/96	RW
	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		4/23/96	Ru
	A) Time			
	B) Malfunctions			
	C) Pierced Primers			
	D) Optical Clarity of Scope			
645	Inspect for Live Ammo		4/23/96	Ru
655	Final Inspection		4/24/96	Ru
	A) Headspace		4/24/96	Ru
	B) Trigger Pull		4/24/96	Ru
	C) Function		4/24/96	Ru
660	Pack			

Final Inspection

S.N: C6348966

DATE REC'D: 4/8/96

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: _____

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6348966
22 Feb 1900

CENTROIDAL DISTANCES

0 TO 1	.772131
1 TO 2	.269875
1 TO 3	.183992
1 TO 4	.515909
1 TO 5	.486966

+-----FOR

THE AVERAGE X-COORDINATE FOR THE RIFLE IS: .3058
THE AVERAGE Y-COORDINATE FOR THE RIFLE IS: .4962
THE RESULTING AVERAGE POI RAD: 5 FOR THE RIFLE IS: .582862

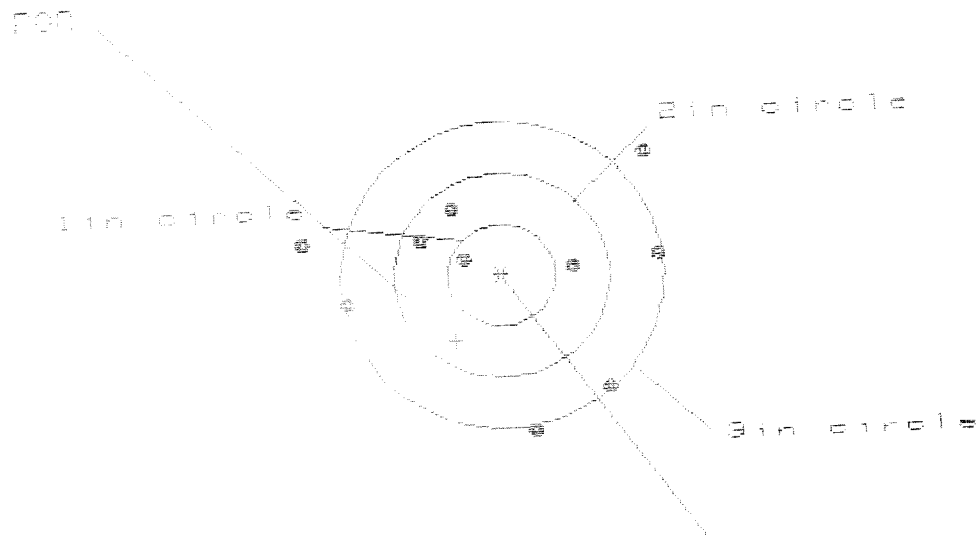
THE AMR FOR THIS RIFLE IS: 1.79

31 Feb 1968

FILE:/PATTERNING/CENTERFIRE_PATT/06348366.1

CENTERFIRE PATTERNS

1



OF SHOTS- 10

IN CIR

1in = 1

2in = 4

3in = 5

MS= 3.318

VS= 2.672

GS= 3.324

CENTROID #

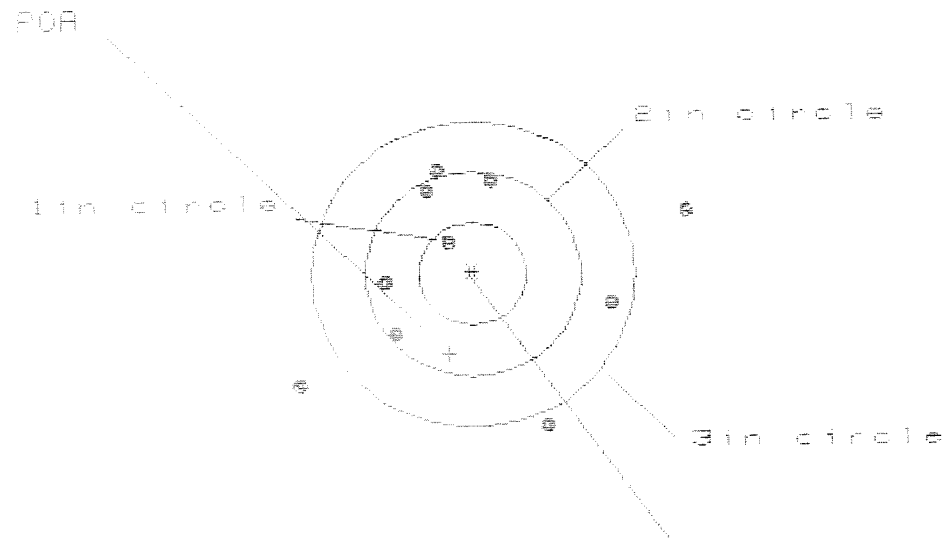
PATTERN #

	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.481	1.278	1.419
MINIMUM X	-1.834	-1.620	-1.478
MAXIMUM Y	1.177	1.222	.819
MINIMUM Y	-1.495	-1.450	-1.298
CENTROID X	.445	.648	.507
CENTROID Y	.63	.586	.434
POB TO CENTROID in.	.73	.874	.667
MIN RADIUS	.34	.411	.511
MEAN RADIUS	1.210	1.143	1.075
MAX RADIUS	1.870	1.667	1.479
HORIZONTAL SPREAD	3.318	2.998	2.898
VERTICAL SPREAD	2.67	2.672	2.117
EXTREME SPREAD	3.32	3.082	2.920
NUMBER IN ONE INCH CIRCLE	=	1	
NUMBER IN TWO INCH CIRCLE	=		
NUMBER IN THREE INCH CIRCLE	=		

21 Feb 1988

FILE:/PATTERNING/CENTERFIRE_PATT/08348366.1

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 7

HS= 3.878

VS= 2.553

GS= 4.066

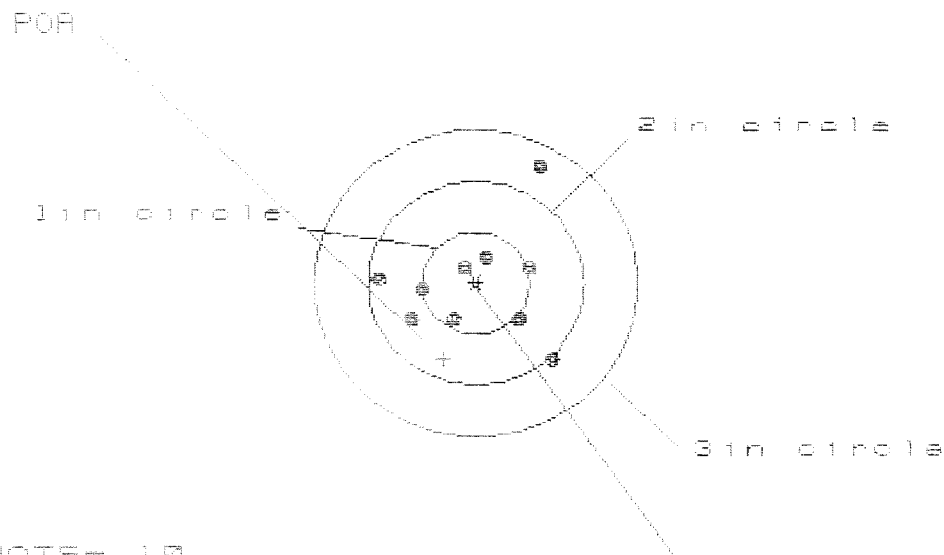
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	2.010	1.472	1.292
MINIMUM X	-1.666	-1.443	-1.775
MAXIMUM Y	1.023	1.092	.961
MINIMUM Y	-1.530	-1.461	-1.592
CENTROID X	.222	.001	.179
CENTROID Y	.783	.714	.845
POA TO CENTROID in.	.814	.714	.864
MIN RADIUS	.414	.433	.339
MEAN RADIUS	1.204	1.078	.971
MAX RADIUS	2.103	1.785	1.735
HORIZONTAL SPREAD	3.676	2.915	2.067
VERTICAL SPREAD	2.553	2.553	2.553
EXTREME SPREAD	4.066	3.024	2.720
NUMBER IN ONE INCH CIRCLE =	1	1	1
NUMBER IN TWO INCH CIRCLE =	5	5	5
NUMBER IN THREE INCH CIRCLE =	7	7	7

21 Feb 1968

FILE: PATTERNING/CENTERFIRE_PATT-08340950.1

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 5

2 in = 8

3 in = 10

HS= 1.533

VS= 1.909

GS= 1.940

PATTERN #	3	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.682	.751	.630
MINIMUM X	-.911	-.842	-.748
MAXIMUM Y	1.169	.416	.340
MINIMUM Y	-.740	-.610	-.294
CENTROID X	.300	.234	.140
CENTROID Y	.748	.618	.694
POA TO CENTROID in.	.807	.661	.708
MIN RADIUS	.136	.227	.178
MEAN RADIUS	.623	.538	.470
MAX RADIUS	1.322	.987	.762
HORIZONTAL SPREAD	1.593	1.593	1.378
VERTICAL SPREAD	1.909	1.026	.634
EXTREME SPREAD	1.940	1.795	1.379
NUMBER IN ONE INCH CIRCLE =	5		
NUMBER IN TWO INCH CIRCLE =	8		
NUMBER IN THREE INCH CIRCLE =	10		

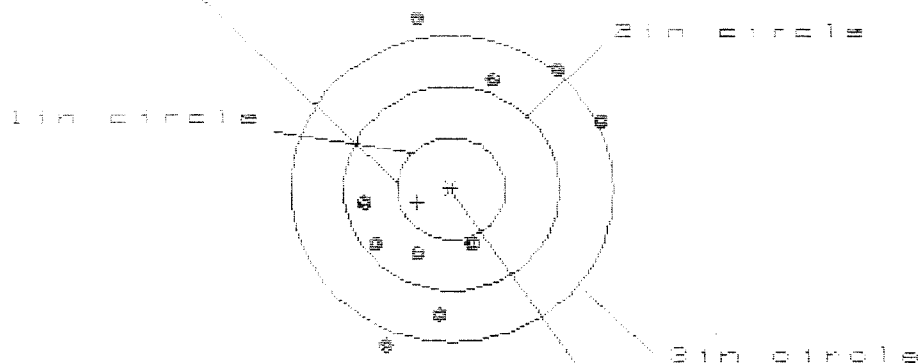
21 Feb 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C834B966.1

CENTERFIRE PATTERNS

4

POA



OF SHOTS= 10

IN CIR

1 in = 0

2 in = 4

3 in = 7

HS= 0.140

VS= 0.100

GS= 0.119

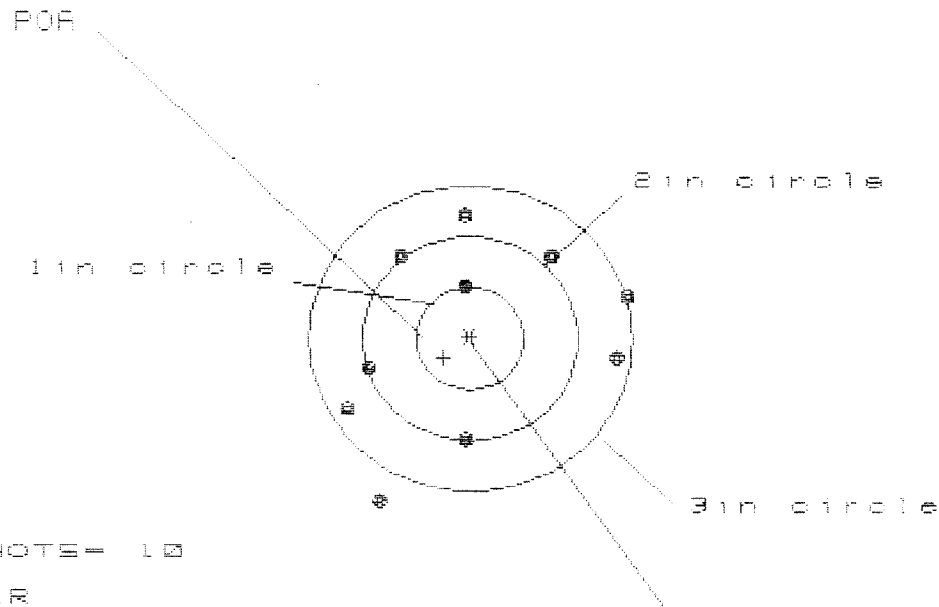
CENTROID *

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.338	1.304	1.229
MINIMUM X	-0.802	-0.836	-0.911
MAXIMUM Y	1.623	1.393	1.230
MINIMUM Y	-1.485	-1.305	-1.196
CENTROID X	.314	.348	.423
CENTROID Y	.132	-.048	.115
POA TO CENTROID in.	.341	.351	.438
MIN RADIUS	.608	.427	.564
MEAN RADIUS	1.168	1.077	1.058
MAX RADIUS	1.651	1.662	1.485
HORIZONTAL SPREAD	2.140	2.140	2.140
VERTICAL SPREAD	3.100	2.698	2.426
EXTREME SPREAD	3.119	3.090	2.664
NUMBER IN ONE INCH CIRCLE =	0	0	0
NUMBER IN TWO INCH CIRCLE =	0	4	4
NUMBER IN THREE INCH CIRCLE =	0	7	7

21 Feb 1988

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CENTERFIRE PATTERNS # 5



OF SHOTS = 10

IN CIR

1 in = 0

2 in = 2

3 in = 8

HE = 2.612

VE = 2.822

GE = 3.032

CENTROID #

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.485	1.397	1.440
MINIMUM X	-1.128	-1.216	-1.041
MAXIMUM Y	1.261	1.087	1.120
MINIMUM Y	-1.562	-1.187	-1.154
CENTROID X	.245	.333	.158
CENTROID Y	.187	.361	.328
POB TO CENTROID in.	.308	.491	.364
MIN RADIUS	.521	.372	.380
MEAN RADIUS	1.197	.998	1.042
MAX RADIUS	1.753	1.501	1.484
HORIZONTAL SPREAD	2.612	2.416	2.481
VERTICAL SPREAD	2.822	2.274	2.274
EXTREME SPREAD	3.032	2.528	2.528
NUMBER IN ONE INCH CIRCLE =	0	0	0
NUMBER IN TWO INCH CIRCLE =	2	2	2
NUMBER IN THREE INCH CIRCLE =	8	8	8