

G684 8384

Replaces

E 6703525

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: **RE00168587** Serial: **E6703525** Model: **M24 SWS** Center Fire
 Verify Repair Caliber: **7.62 NATO** Repairman: Status: **Closed 5/26/2009 1:19:03 PM**

Address Information

Customer: ☒ Received From Return To: ☐ Received From
 Name: **JSSA** **JSSA**
 Address 1: **BLDG 934** **BLDG 934**
 Address 2: **PO Box:** **PO Box:**
 City: **FORT IRWIN** **FORT IRWIN**
 State: **CA** Zip Code: **92310** Country: **US** State: **CA** Zip Code: **92310** Country: **US**
 FFL: ☐ ☐ ☐ ☐ ☐ ☐

Contact / Condition Problems Estimate History / Status Shipping / Billing

Contact Information: Phone: **NN** Received Condition: **Fair** Accessories Received:

Code	Desc	Qty
A007	With Stud	3
A010	Hard Case	1
A017	Scoope Base	1
A045	Bi Pod	1
D000	REAR SGT BASE	1

Fax: Condition Notes: CSR Notes:
 Email:
 Comments:

Repair Search Refresh Close

Refresh Close

Start | 5/26/2009 | 1:41 PM | CAP | NUM | BPS | SCRL

Start | Microsoft | Microsoft | Google News | Part Search by | Arms Services | Material Whter |

G 684 8384

Serial Number: **E6703525**

Model: **M24 SWS**



RE00168587

M-24
INSPECTION CHECKLIST - REPAIRS
CONTRACT #: W52H09-07-C-0207
ISSUED 10/1/2007

R & E NUMBER 168587
SERIAL NUMBER ~~16203525~~ C6848384
LOG-IN DATE 5-26-09

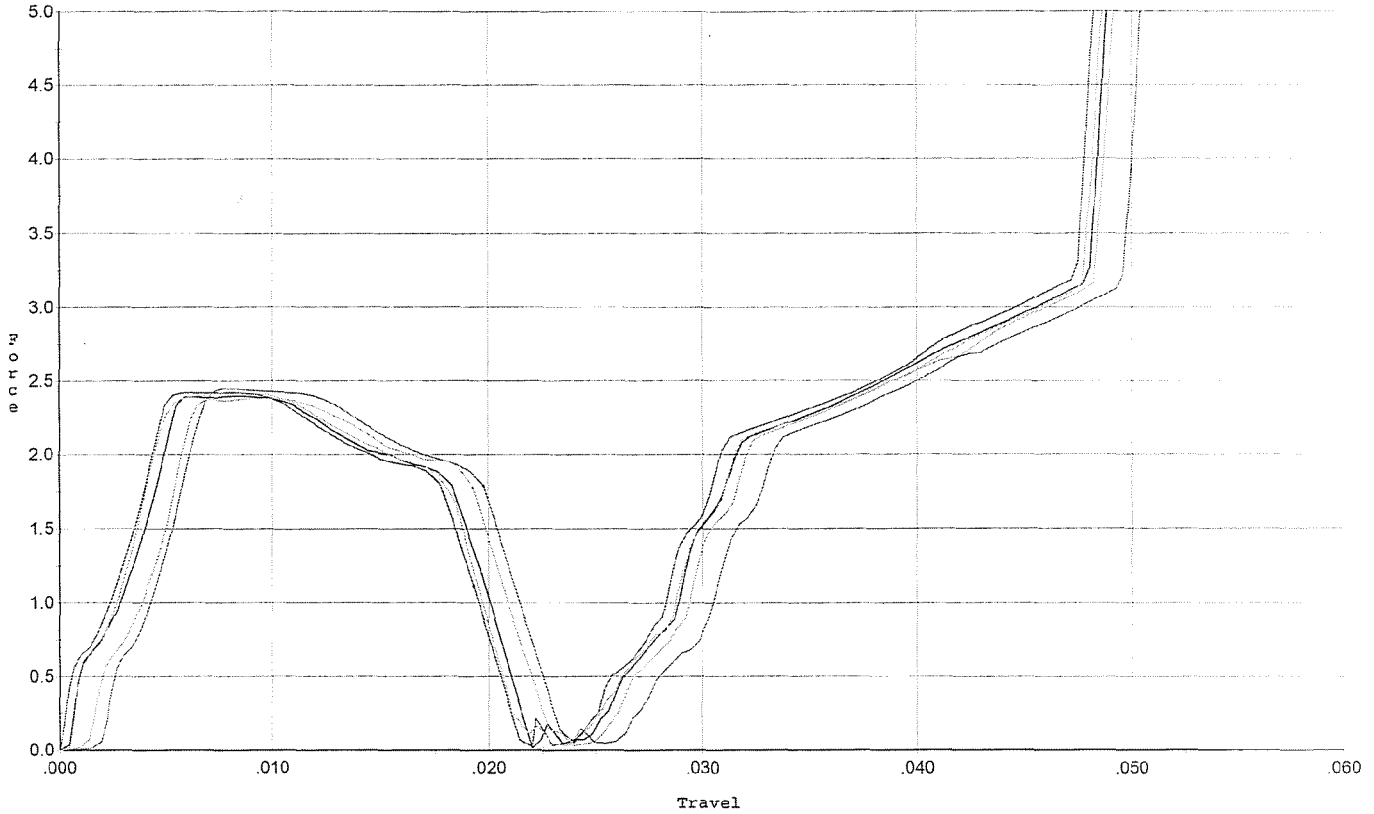
OPERATION #	OPERATION NAME	DATE	INITIAL
500	DIS-ASSEMBLE GUN	5-26-09	RTZ
505	RE-BARREL	5-28-09	RTZ
420	ASSEMBLE	5-28-09	RTZ
440	PROOF	5-28-09	SPD
460	CHECK HEADSPACE	5-28-09	SPD
470	DIS-ASSEMBLE GUN	5-28-09	SPD
480	MAGNAFLUX	5/30/09	SPD
510	DRILL AND TAP	5-29-09	SP
500	ROLLMARK CALIBER	6-1-09	RT
520	GOFF BLAST BBL / REC	6-1-09	ALWD
530 & 540	APPLY COATINGS	6/3	
560	FINAL ASSEMBLY	6-5-09	RTZ
640	FUNCTION TEST AND	6-9-09	RB
650	TARGET	6-9-09	RB
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
670	FINAL INSPECTION	6/9/09	TGR
	A) HEADSPACE	6-15-09	RTZ
	B) TRIGGER PULL	256 270 273 261 260 6/15/09	RTZ
680	F) SAFETY ON FORCE	5.0 5.0 4.0 6-15-09	RTZ
	G) SAFETY OFF FORCE	6.0 6.0 6.0 6-15-09	RTZ
	I) FIRING PIN INDENT	.023 .023 .023 6-15-09	RTZ
690	PACK	7/15/09	RTZ

F006 REV 1/2009

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: R.P. 5/18/09

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



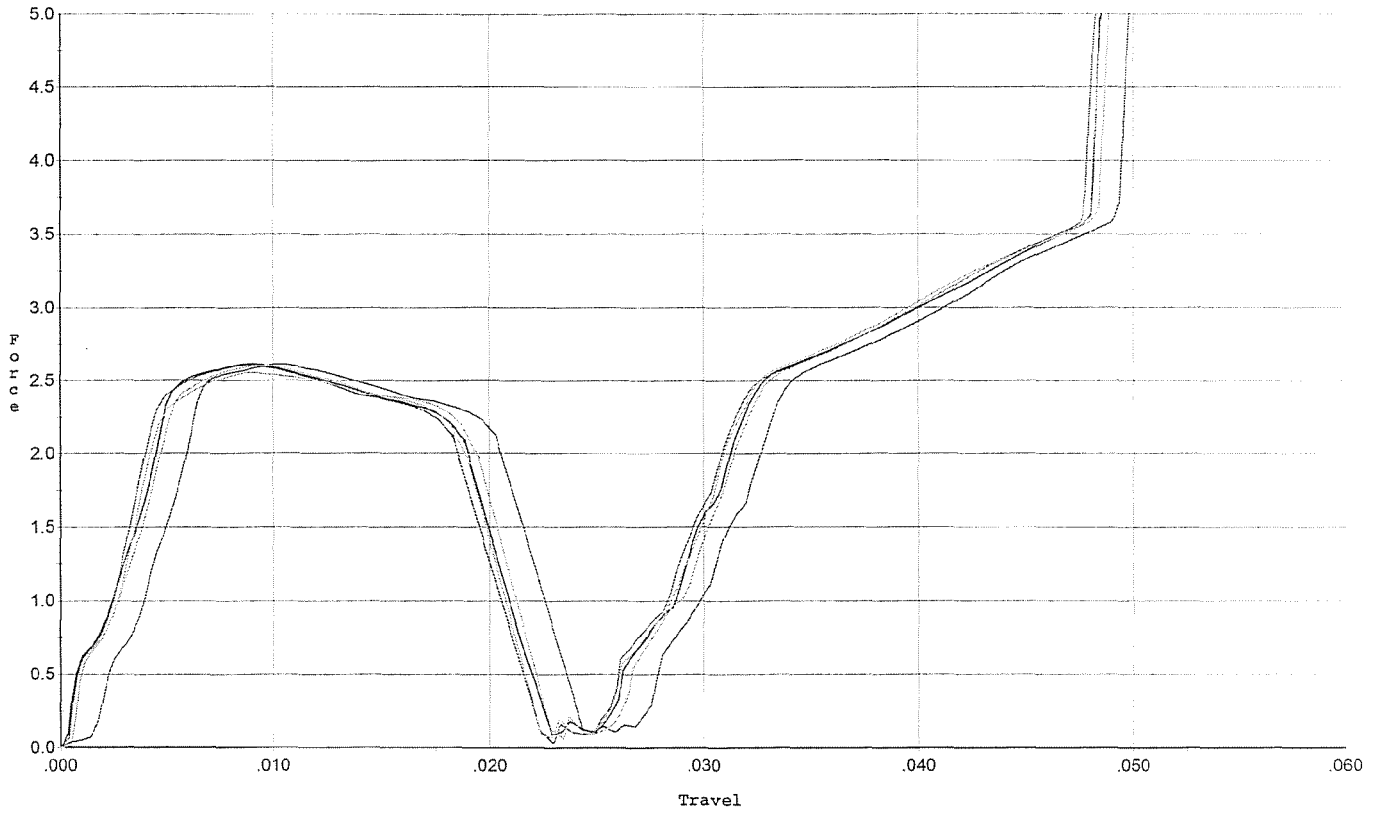
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.418	0.019	0.00	0.034	0.034		Set Trigger
2	2.397	0.020	0.00	0.034	0.034		Set Trigger
3	2.446	0.020	0.002	0.035	0.033		Set Trigger
4	2.420	0.018	0.00	0.034	0.033		Set Trigger
5	2.380	0.019	0.00	0.034	0.032		Set Trigger

Avg 2.41

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: R.P. 5/18/09

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



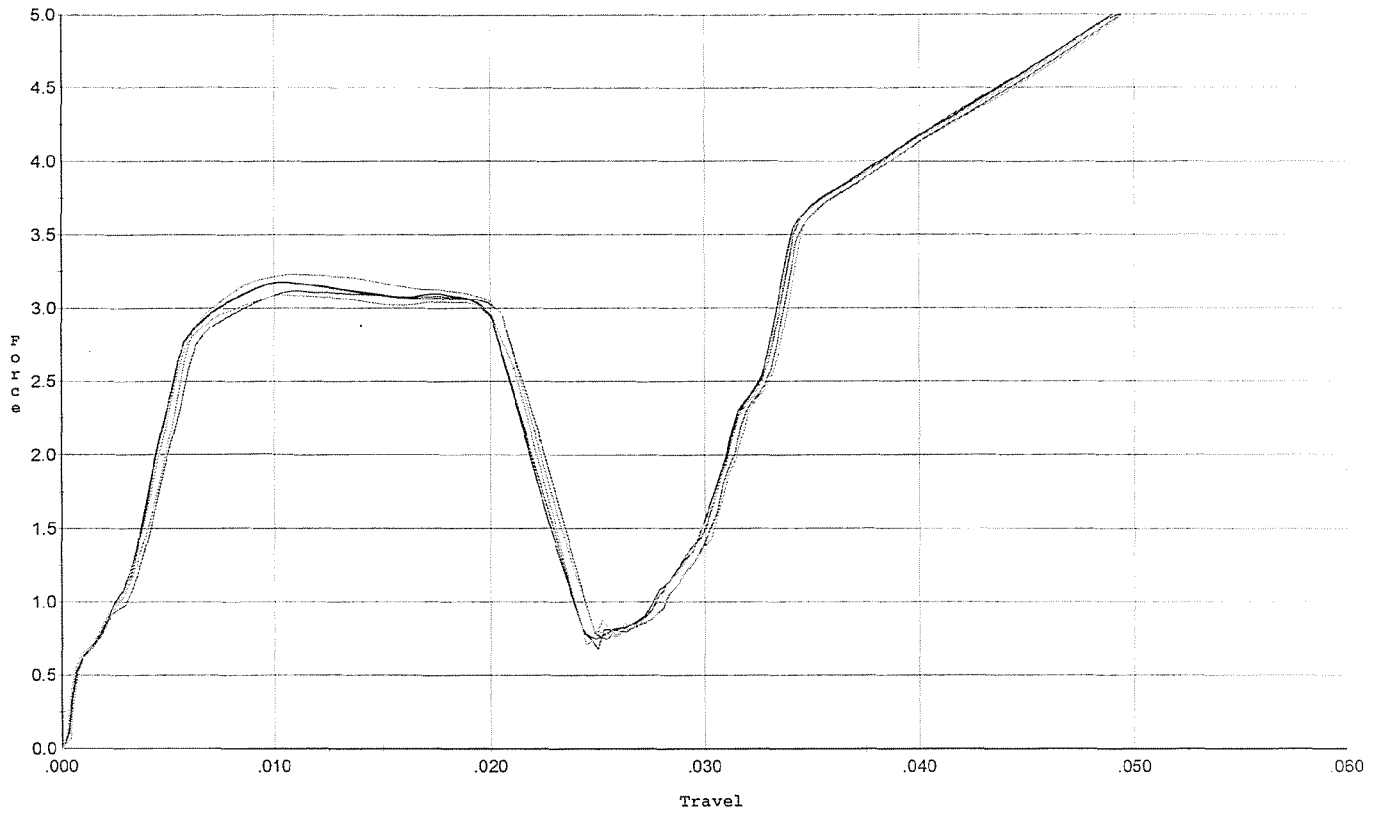
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.612	0.022	0.00	0.033	0.041		Set Trigger
2	2.615	0.019	0.00	0.033	0.037		Set Trigger
3	2.605	0.018	0.00	0.033	0.036		Set Trigger
4	2.555	0.019	0.00	0.033	0.037		Set Trigger
5	2.604	0.020	0.00	0.032	0.038		Set Trigger

Aug 2.59

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R.P. 5/18/09

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



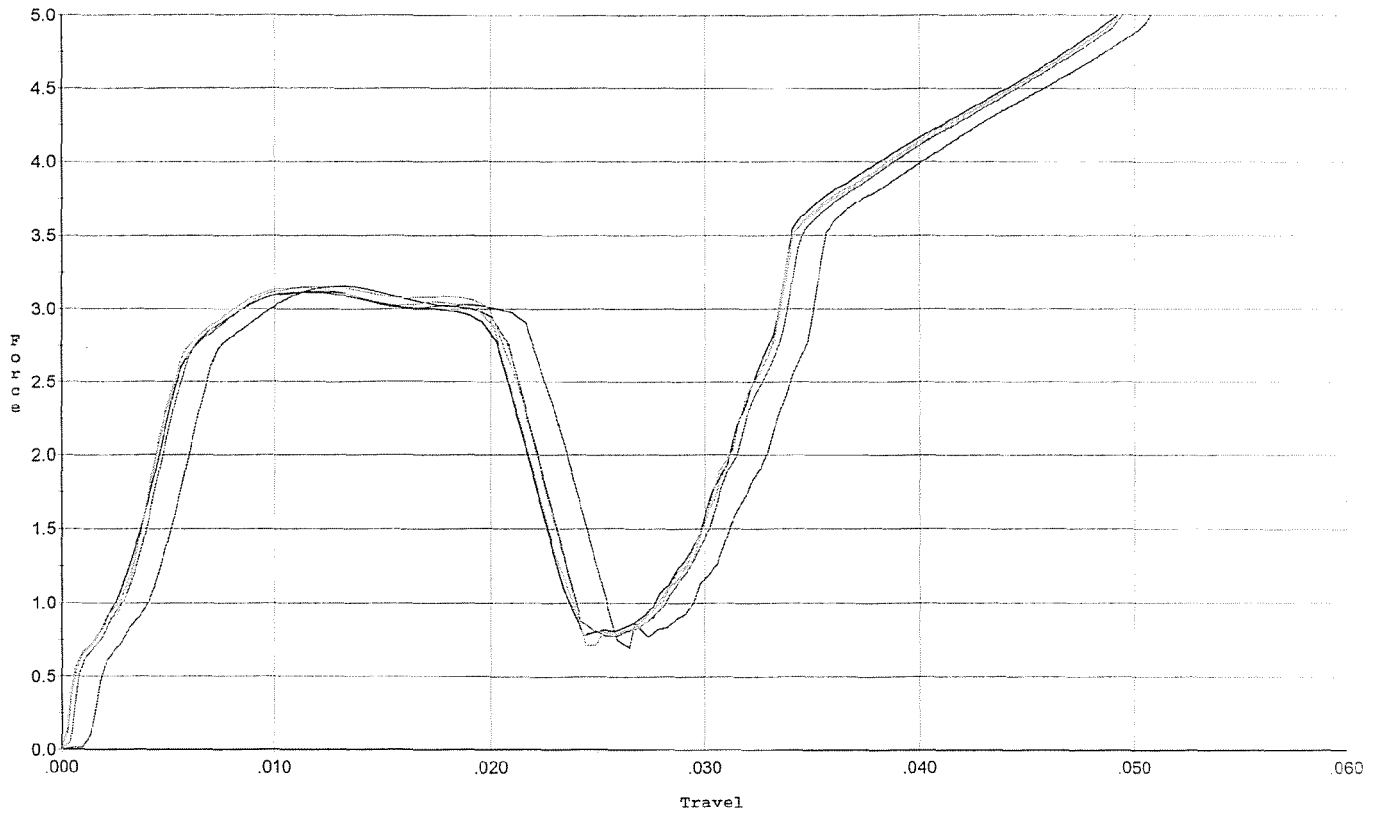
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.174	0.020	0.00	0.031	0.048		Set Trigger
2	3.178	0.020	0.00	0.031	0.048		Set Trigger
3	3.115	0.022	0.00	0.031	0.052		Set Trigger
4	3.089	0.021	0.00	0.031	0.050		Set Trigger
5	3.228	0.020	0.00	0.031	0.049		Set Trigger

Avg 3.15

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: R.P. 5/18/09

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



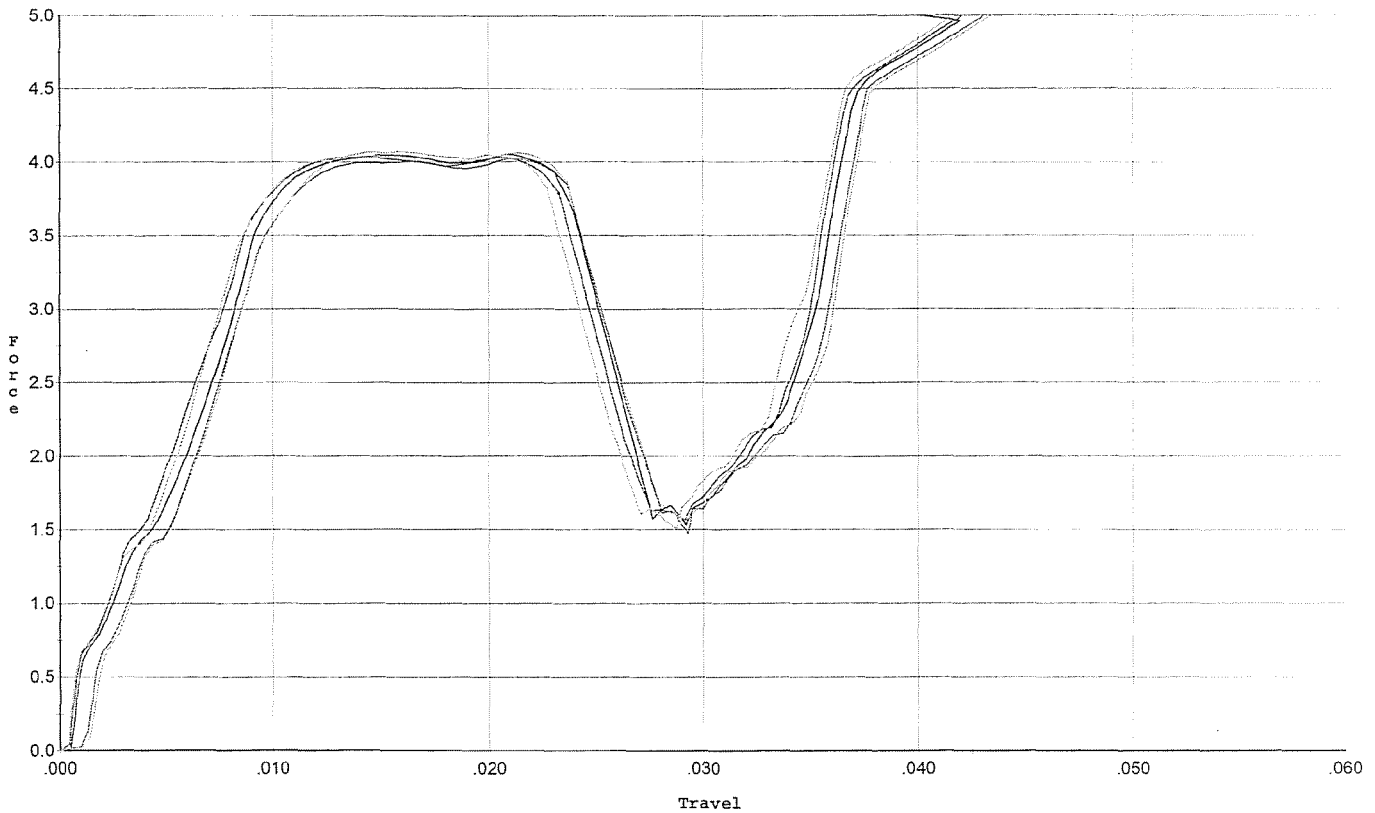
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.155	0.023	0.00	0.032	0.052		Set Trigger
2	3.116	0.020	0.00	0.031	0.048		Set Trigger
3	3.112	0.021	0.00	0.031	0.049		Set Trigger
4	3.144	0.020	0.00	0.031	0.048		Set Trigger
5	3.152	0.021	0.00	0.031	0.050		Set Trigger

Aug 3.13

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R.P. 5/18/09

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



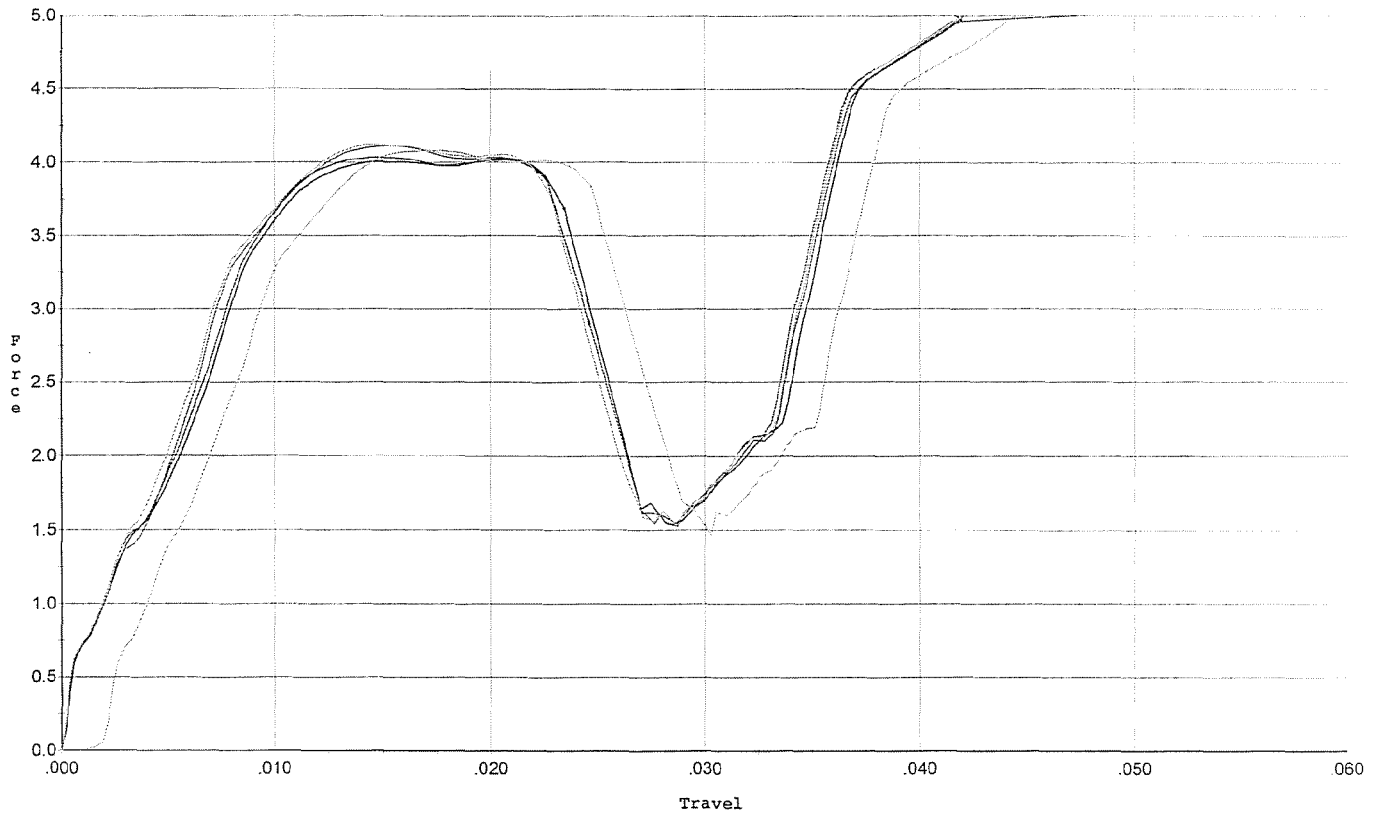
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.034	0.023	0.00	0.029	0.068		Set Trigger
2	4.054	0.024	0.00	0.029	0.069		Set Trigger
3	4.021	0.024	0.00	0.030	0.066		Set Trigger
4	4.046	0.023	0.00	0.030	0.066		Set Trigger
5	4.070	0.024	0.00	0.030	0.066		Set Trigger

Aug 4.04

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R.P. 5/18/09

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



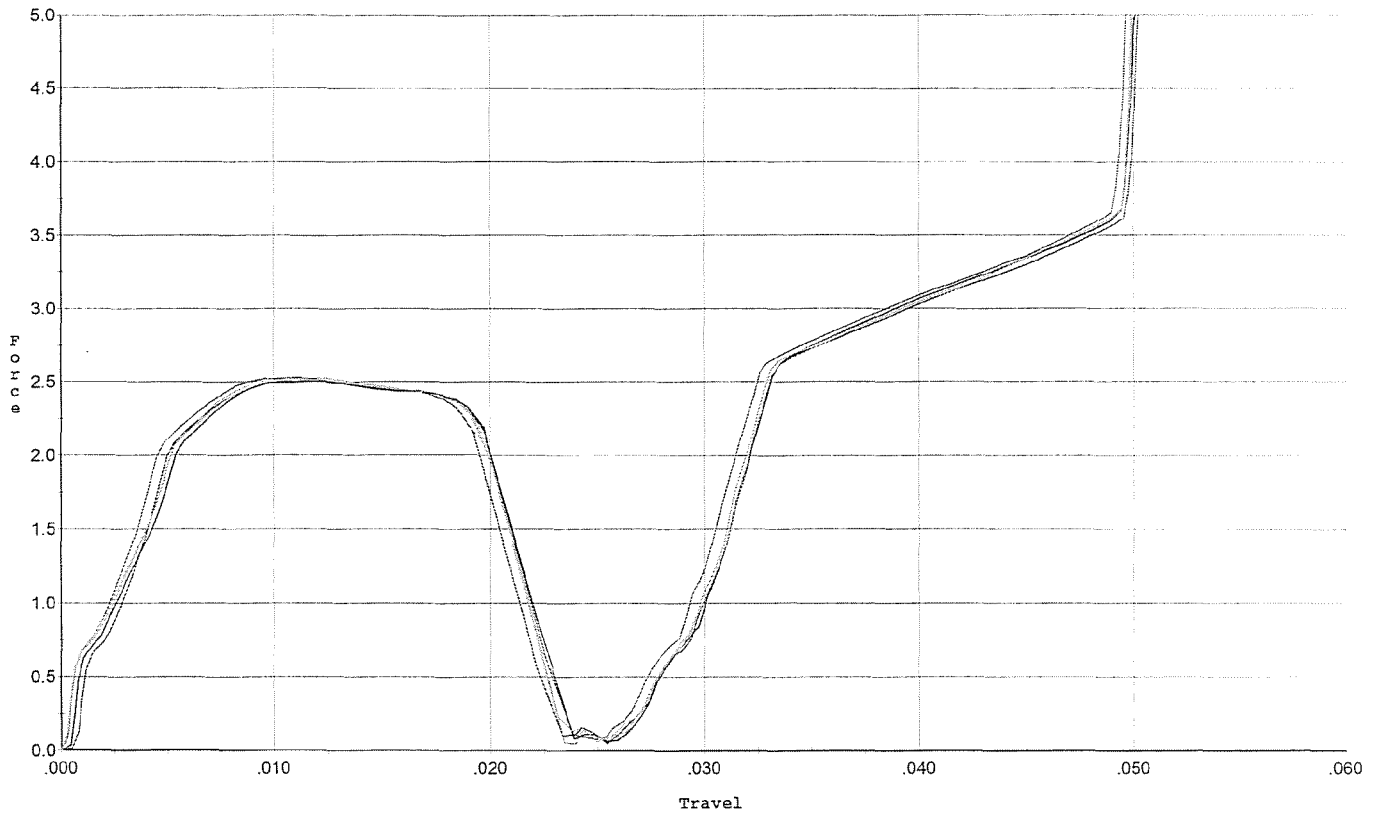
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.036	0.025	0.00	0.029	0.071		Set Trigger
2	4.026	0.023	0.00	0.029	0.067		Set Trigger
3	4.112	0.025	0.00	0.029	0.072		Set Trigger
4	4.080	0.025	0.00	0.030	0.067		Set Trigger
5	4.123	0.023	0.00	0.030	0.067		Set Trigger

Aug 4.07

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: R.P. 5/18/09

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



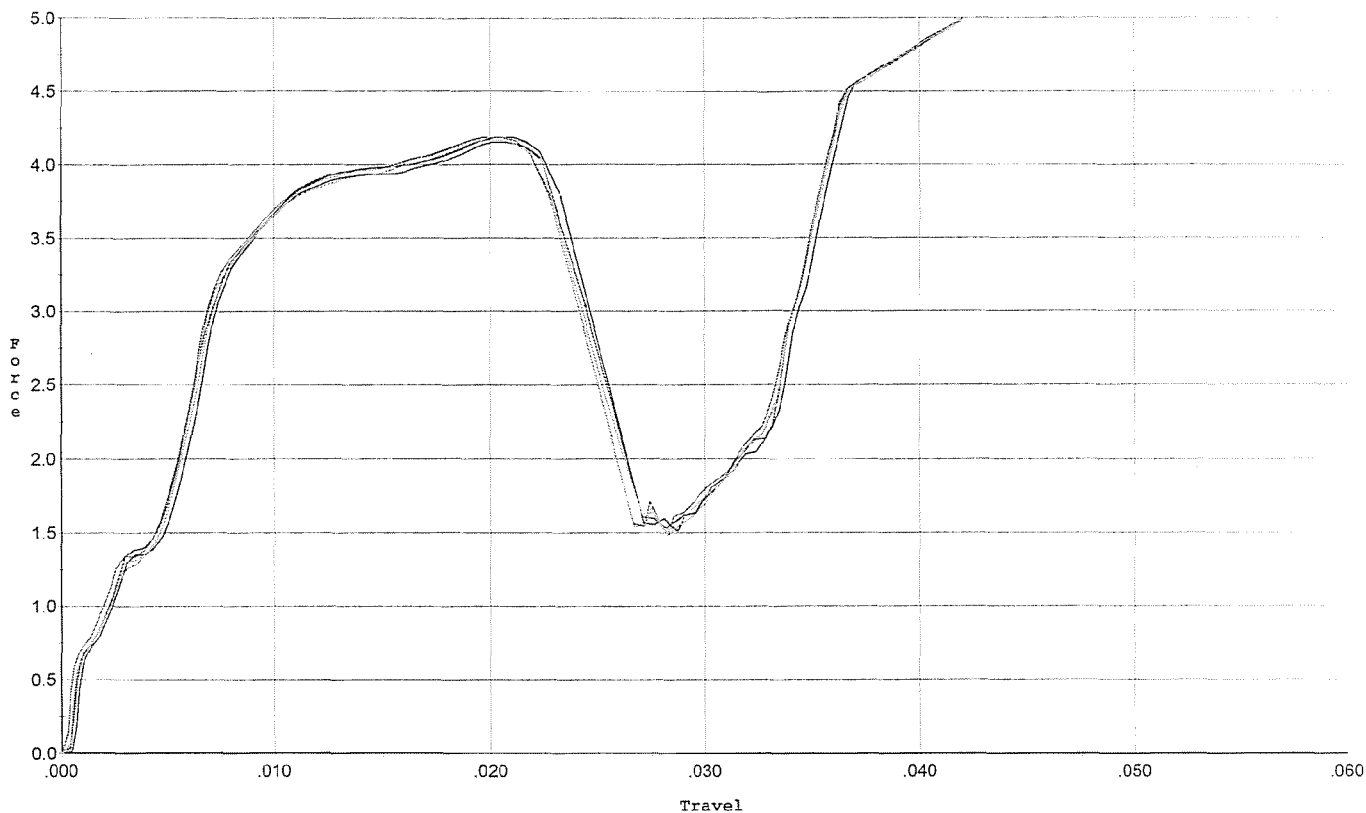
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.512	0.020	0.00	0.033	0.038		Set Trigger
2	2.503	0.020	0.00	0.033	0.038		Set Trigger
3	2.523	0.019	0.00	0.033	0.038		Set Trigger
4	2.511	0.020	0.00	0.033	0.039		Set Trigger
5	2.531	0.020	0.00	0.033	0.039		Set Trigger

Avg 2.51

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: R.P. 5/18/09

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	4.153	0.024	0.00	0.030	0.071		Set Trigger
2	4.188	0.023	0.00	0.030	0.067		Set Trigger
3	4.185	0.023	0.00	0.030	0.067		Set Trigger
4	4.187	0.022	0.00	0.030	0.065		Set Trigger
5	4.169	0.023	0.00	0.030	0.066		Set Trigger

Avg 4.17

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6848384.___0

FILE DATE AND TIME: 06/09/2009 14:32

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.063
The Average Y Centroid of the Five Target Set:	0.077
The Average Point of Impact of the Five Target Set:	0.099
The Average Mean Radius of the Five Target Set:	0.763
The Distance from POA to Centroid Target #1:	0.272
The Distance from Centroid Target #2 to Centroid Target #1:	0.277
The Distance from Centroid Target #3 to Centroid Target #1:	0.335
The Distance from Centroid Target #4 to Centroid Target #1:	0.158
The Distance from Centroid Target #5 to Centroid Target #1:	0.314

SERIAL NUMBER: C6848384. __0

TARGET NUMBER: 1

FILE DATE: 06/09/2009

FILE TIME: 14:32

POINT#	X	Y
1:	0.351	0.625
2:	0.105	0.578
3:	-0.064	0.565
4:	0.168	0.334
5:	-0.512	0.675
6:	-0.742	0.803
7:	-0.257	0.242
8:	-0.081	-0.743
9:	0.460	-0.254
10:	0.455	-0.109

X CENTROID: -0.012

Y CENTROID: 0.272

POA TO CENTROID: 0.272

HORZ SPREAD: 1.202

VERT SPREAD: 1.546

GROUP SPREAD: 1.681

MIN RADIUS: 0.190

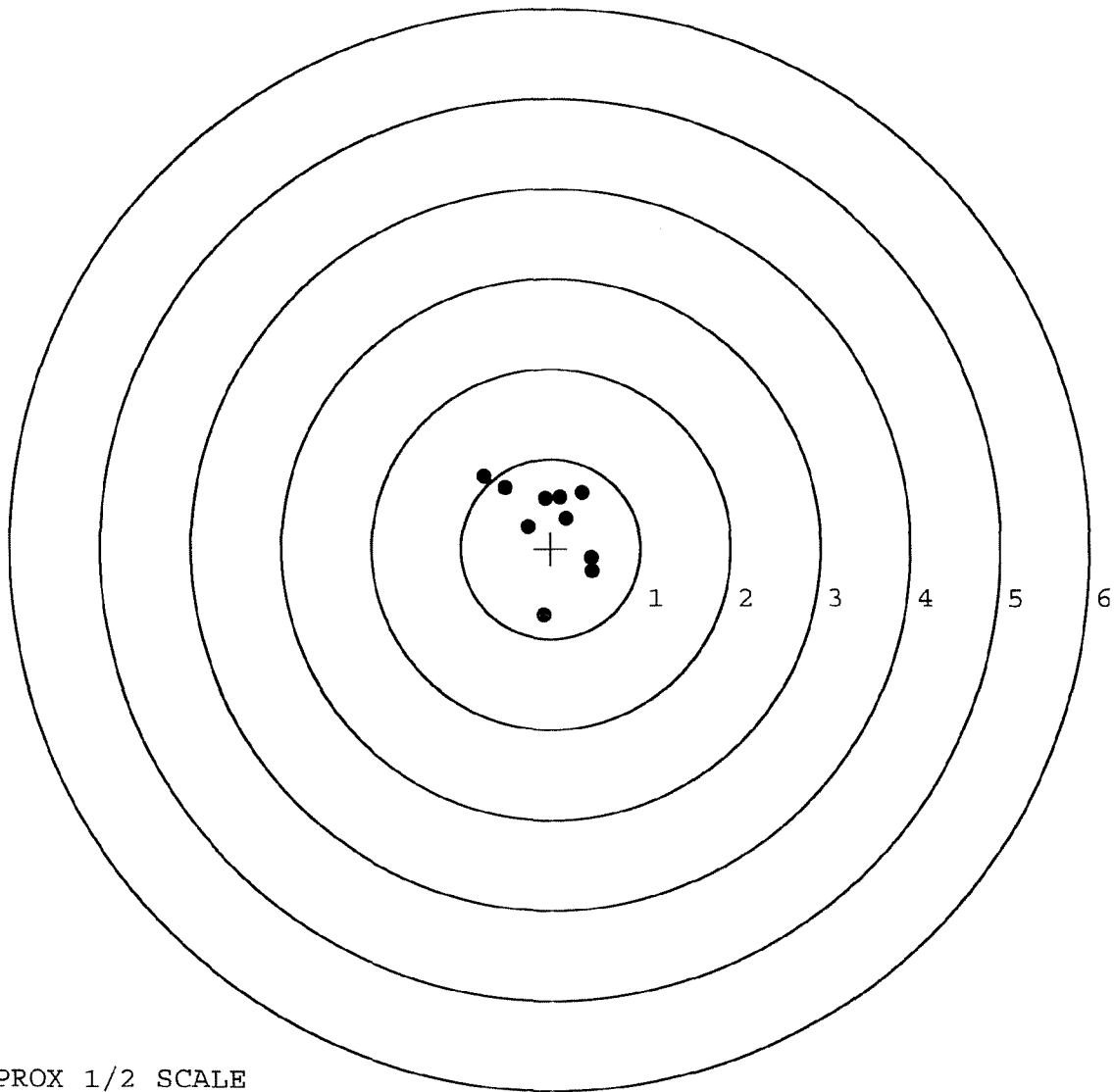
MAX RADIUS: 1.017

MEAN RADIUS: 0.544

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6848384. 0

TARGET NUMBER: 2

FILE DATE: 06/09/2009

FILE TIME: 14:32

POINT#	X	Y
1:	-0.031	1.465
2:	-0.244	0.950
3:	-0.041	0.967
4:	0.453	0.588
5:	-0.678	-0.033
6:	-0.709	-0.535
7:	-0.592	-0.924
8:	-0.243	-0.926
9:	0.396	-0.752
10:	1.032	-0.801

X CENTROID: -0.066

Y CENTROID: 0.000

POA TO CENTROID: 0.066

HORZ SPREAD: 1.741

VERT SPREAD: 2.391

GROUP SPREAD: 2.503

MIN RADIUS: 0.613

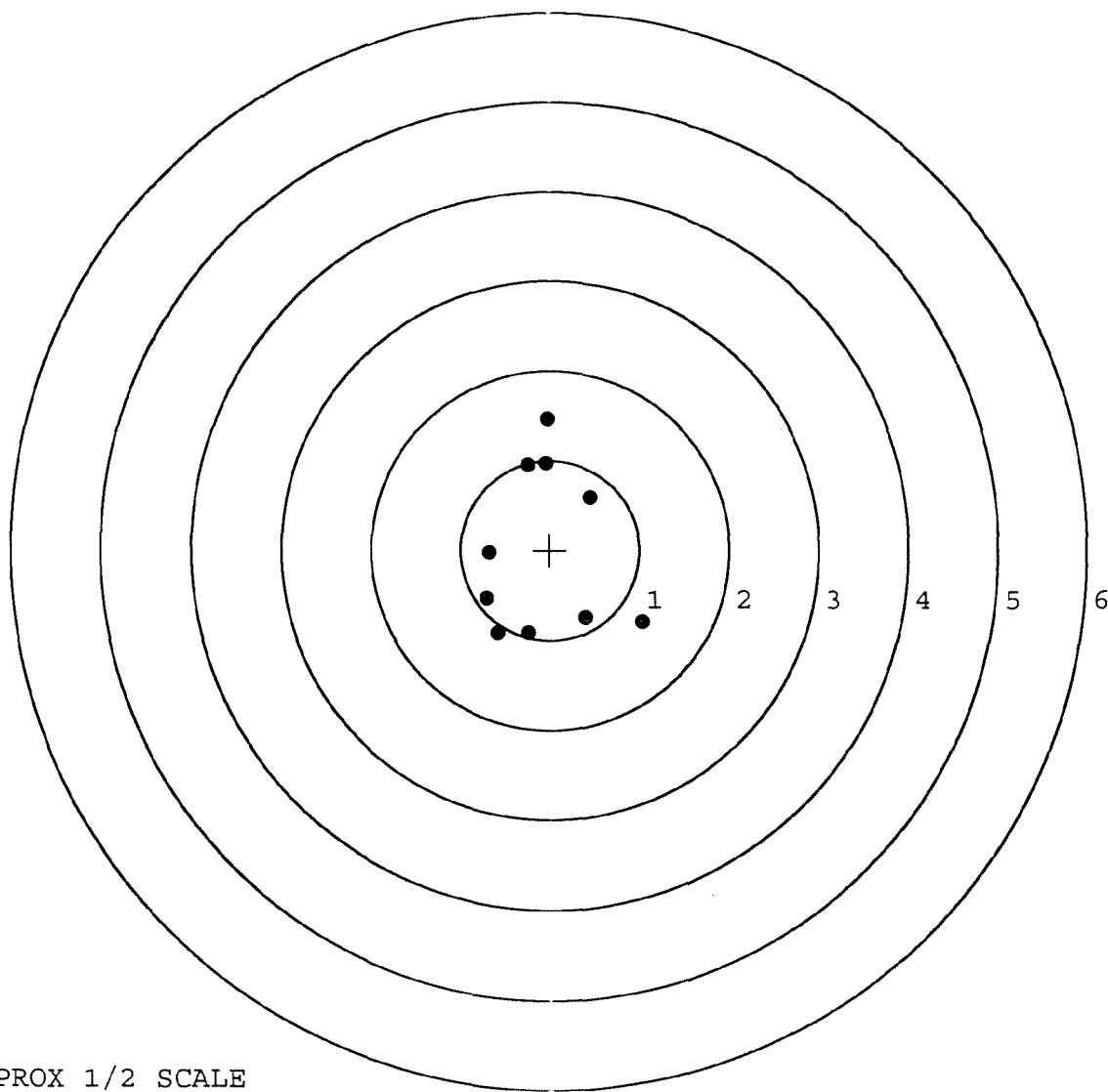
MAX RADIUS: 1.466

MEAN RADIUS: 0.988

IN 1 IN DIAMETER: 0

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10

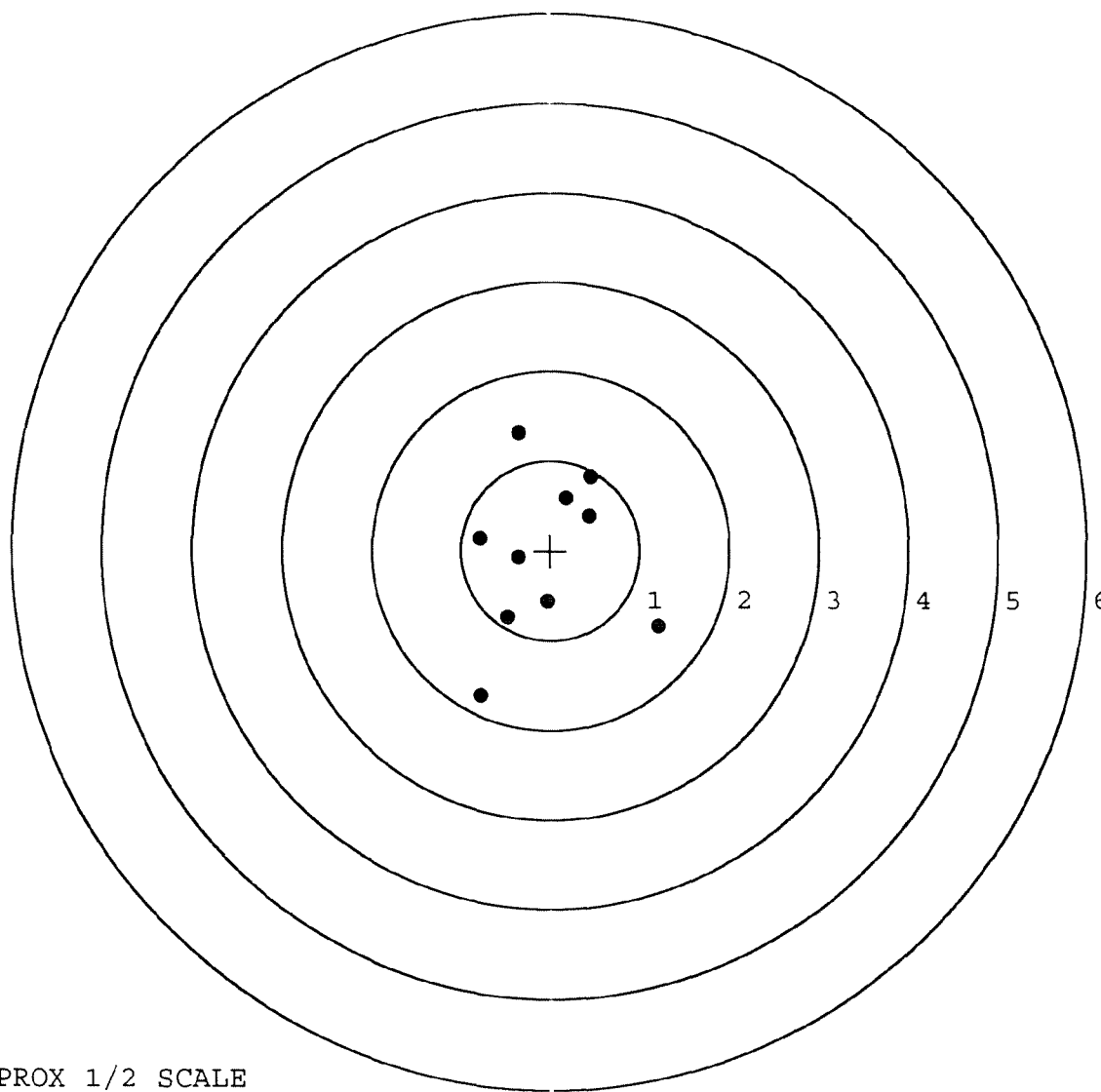


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6848384. __0
TARGET NUMBER: 3
FILE DATE: 06/09/2009
FILE TIME: 14:32

POINT#	X	Y
1:	-0.347	1.313
2:	0.179	0.580
3:	0.459	0.820
4:	0.437	0.390
5:	-0.785	0.144
6:	-0.354	-0.077
7:	-0.482	-0.741
8:	-0.035	-0.572
9:	1.205	-0.848
10:	-0.780	-1.619

X CENTROID: -0.050
Y CENTROID: -0.061
POA TO CENTROID: 0.079
HORZ SPREAD: 1.990
VERT SPREAD: 2.932
GROUP SPREAD: 2.964
MIN RADIUS: 0.304
MAX RADIUS: 1.720
MEAN RADIUS: 0.935
IN 1 IN DIAMETER: 1
IN 2 IN DIAMETER: 6
in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6848384. __0

TARGET NUMBER: 4

FILE DATE: 06/09/2009

FILE TIME: 14:32

POINT#	X	Y
1:	0.032	1.414
2:	-1.214	0.929
3:	-0.322	0.736
4:	-0.580	-0.014
5:	-0.271	0.171
6:	0.297	0.326
7:	0.508	-0.107
8:	-0.334	-0.458
9:	-0.042	-1.151
10:	0.325	0.320

X CENTROID: -0.160

Y CENTROID: 0.217

POA TO CENTROID: 0.269

HORZ SPREAD: 1.722

VERT SPREAD: 2.565

GROUP SPREAD: 2.566

MIN RADIUS: 0.120

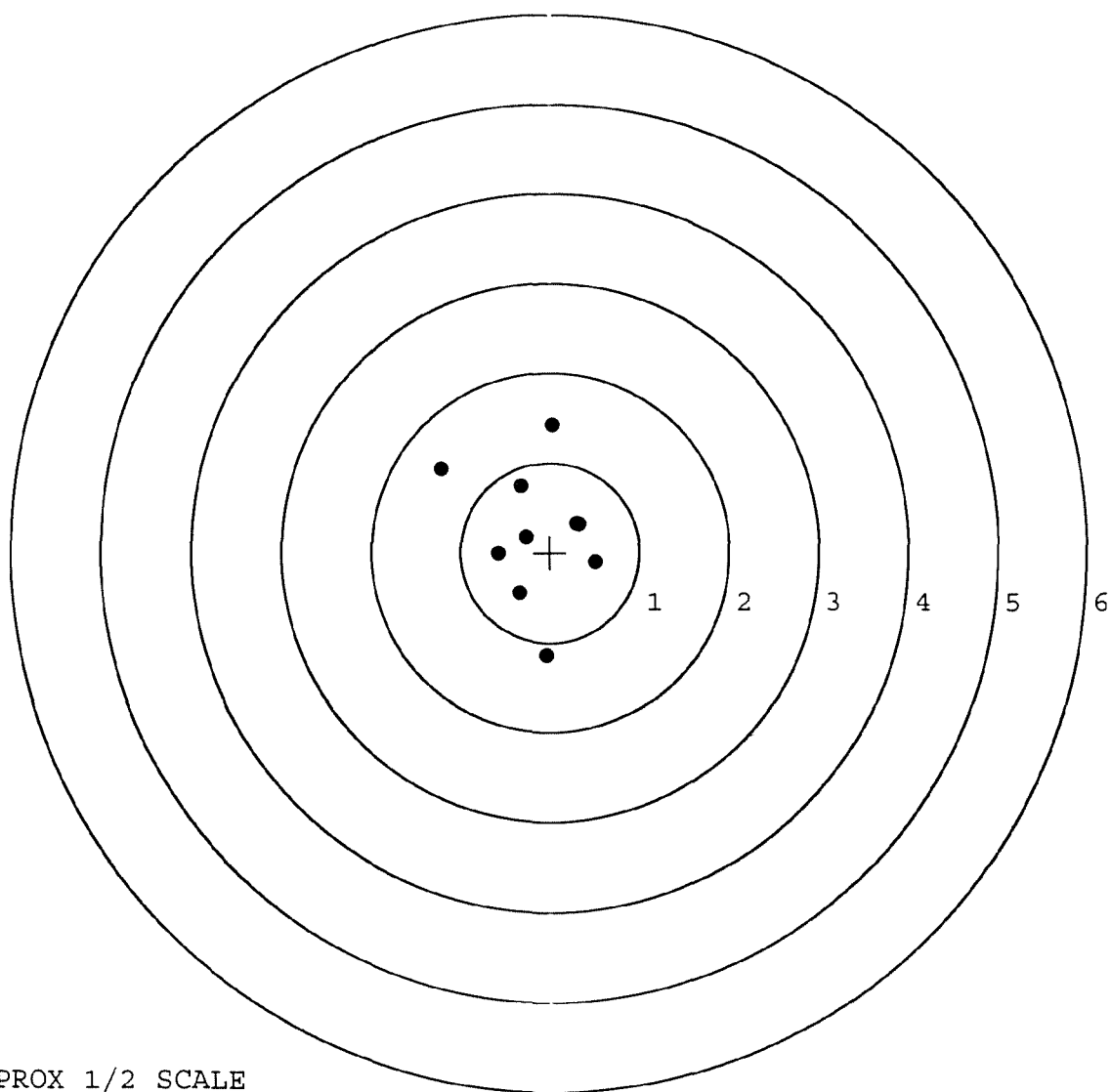
MAX RADIUS: 1.373

MEAN RADIUS: 0.741

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10

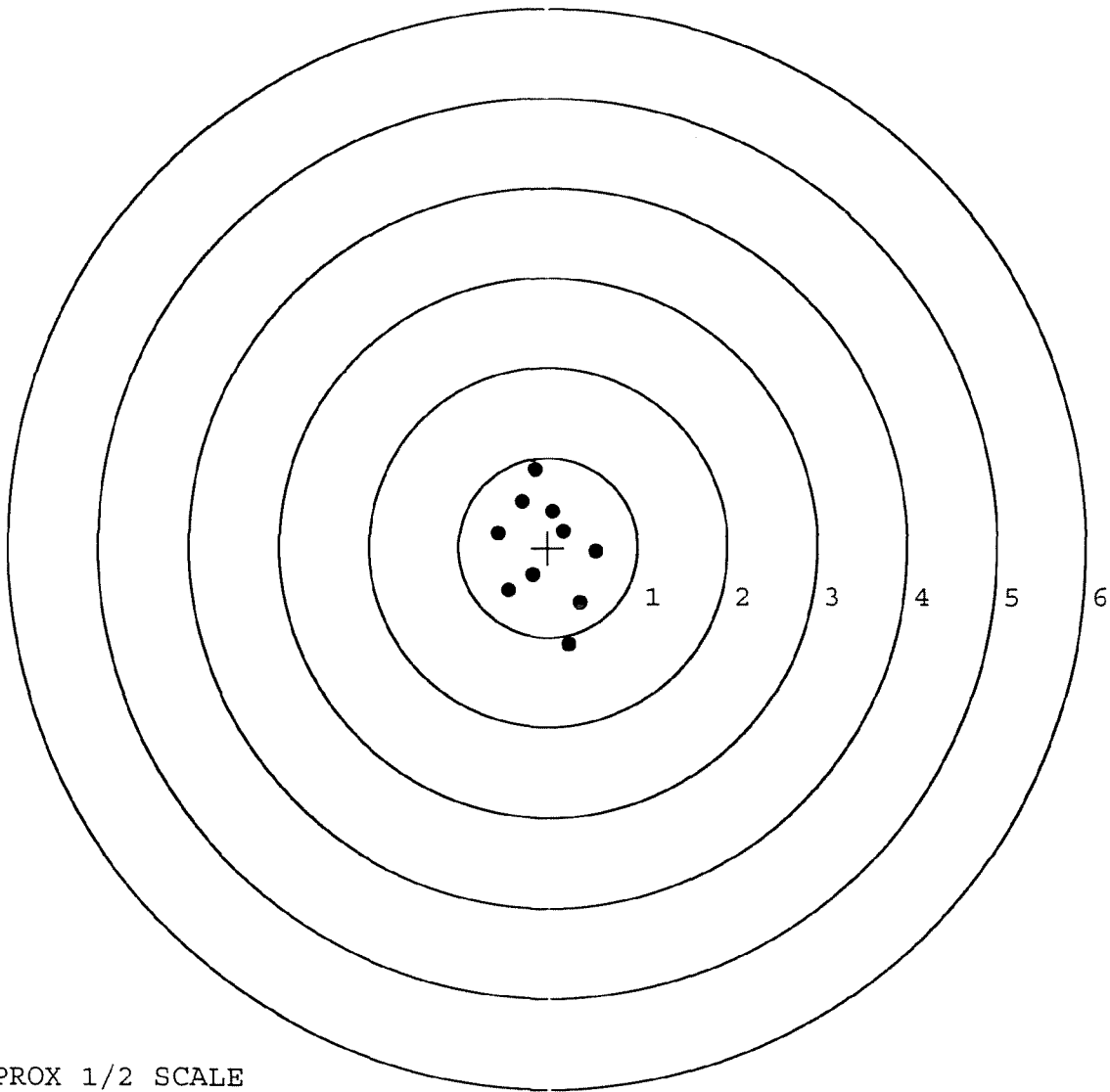


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6848384. __0
TARGET NUMBER: 5
FILE DATE: 06/09/2009
FILE TIME: 14:32

POINT#	X	Y
1:	-0.141	0.868
2:	-0.288	0.507
3:	-0.563	0.156
4:	0.047	0.406
5:	0.170	0.185
6:	0.537	-0.053
7:	0.357	-0.616
8:	0.231	-1.080
9:	-0.444	-0.485
10:	-0.169	-0.306

X CENTROID: -0.026
Y CENTROID: -0.042
POA TO CENTROID: 0.049
HORZ SPREAD: 1.100
VERT SPREAD: 1.948
GROUP SPREAD: 1.983
MIN RADIUS: 0.300
MAX RADIUS: 1.070
MEAN RADIUS: 0.608
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10



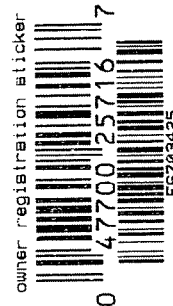
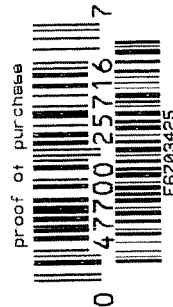
TARGET APPROX 1/2 SCALE

MODEL 700™ M24
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO

DOCUMENT ENVELOPE ASSEMBLY:

- INSTRUCTION BOOK
- PRODUCT OWNER'S CARD
- SAFETY BOOKLET

46 FORM 1444

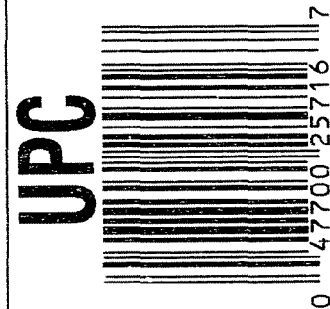


ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

E6703425



Remington®

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

MODEL 700TM M24
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO

SERIAL NO. J
E6703425

46

ORDER NO.
25716

Made in Ilion, NY Rec. U.S. Pat & tm. Off. Marca Registrada Marque Deposee.



5716 E6703425

29EV

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

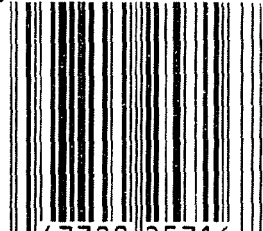
M2400054760

ORDER

25716

MODEL 700TH M24

UPC



0 47700 25716 7

ORDER

25716

MODEL 700TH M24

UPC



0 47700 25716 7

SERIAL NO.



E6703425

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

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

SERIAL NO. E 6703425

DATE 4/10/01

TESTER DA

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.24	2.38		2.25	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.35	2.24		2.22	
PULL #3	2.21	2.16		2.13	
PULL #4	2.34	2.26		2.15	
PULL #5	2.30	2.31		2.24	
TOTAL	1144	1135		1099	
AVG.	2.28	2.27		2.19	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.09	3.00		
PULL #2	3.13	2.97		
PULL #3	3.03	2.95		
PULL #4	3.14	2.97		
PULL #5	3.08	2.94		
TOTAL	1547	1483		
AVG.	3.09	2.96		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.01	4.00		4.17
PULL #2	4.08	4.08		4.06
PULL #3	4.12	4.00		4.09
PULL #4	4.15	4.06		4.11
PULL #5	4.08	4.05		4.06
TOTAL	2044	2019		2049
AVG.	4.08	4.03		4.09

Remington Test Lab, Ilion, N.Y.

Centroidal distance calculations for Rifle # e6703425
17 Apr 2001

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0018
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1894
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .189409

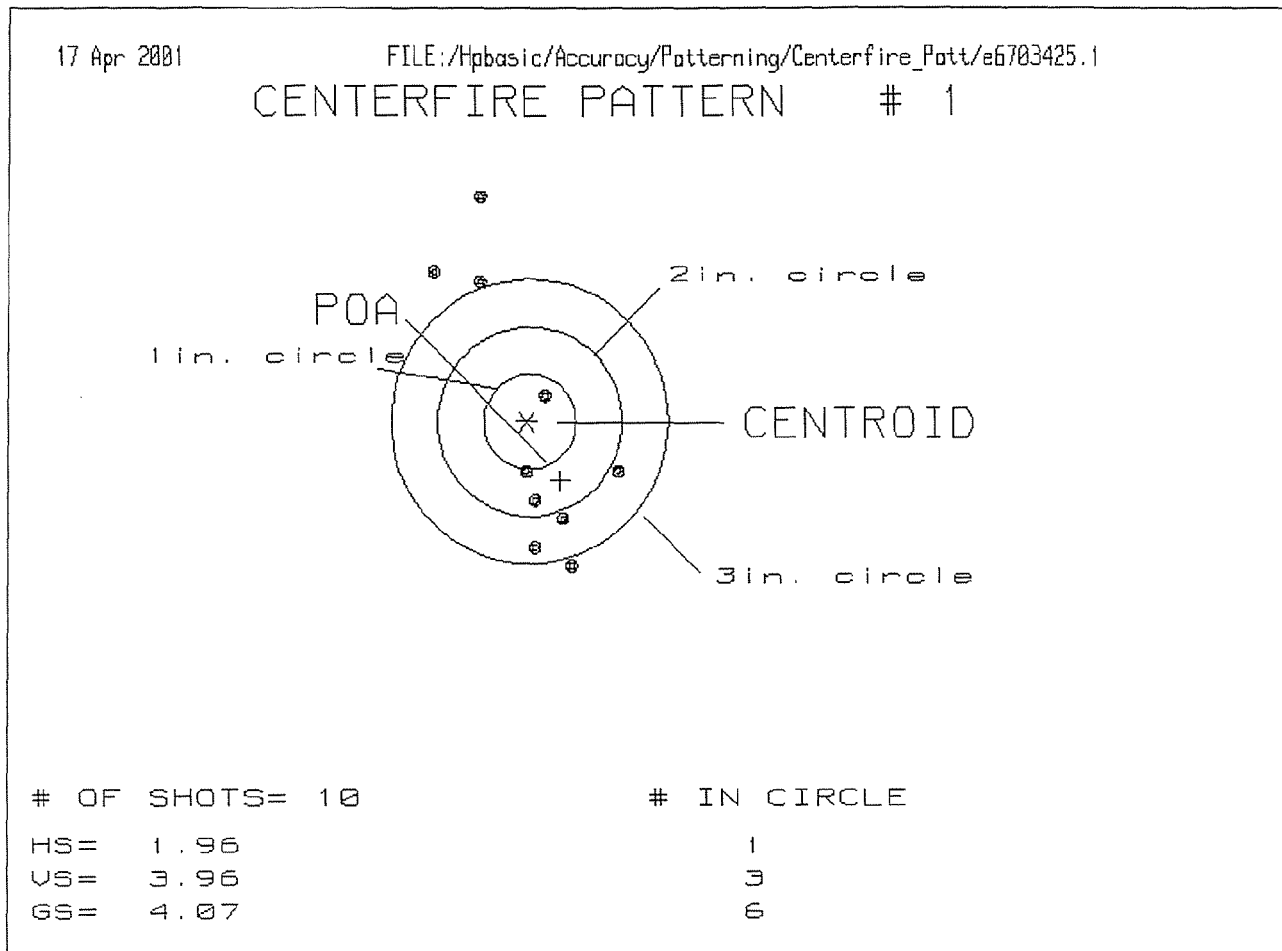
THE AMR FOR THIS RIFLE IS: 1.099

CENTROIDAL DISTANCES

0 TO	1	.722133
1 TO	2	.46322
1 TO	3	.964997
1 TO	4	.721388
1 TO	5	.858094

1
2 5
4 + 3 <----POA

PATTERN #: ☐ 1 ☐
 POA TO CENTROID: .722
 MIN RADIUS : .327
 MEAN RADIUS : 1.263
 MAX RADIUS : 2.463
 CENTROID X : -.360
 CENTROID Y : .626

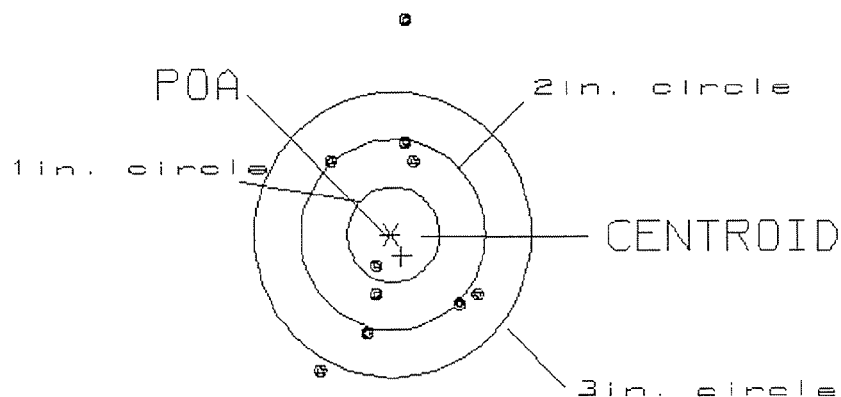


PATTERN #: L 2 □
 POA TO CENTROID: .259
 MIN RADIUS : .328
 MEAN RADIUS : 1.082
 MAX RADIUS : 2.245
 CENTROID X : -.123
 CENTROID Y : .228

17 Apr 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/e6703425.1

CENTERFIRE PATTERN # 2



OF SHOTS= 10

IN CIRCLE

HS= 1.67
 VS= 3.71
 GS= 3.80

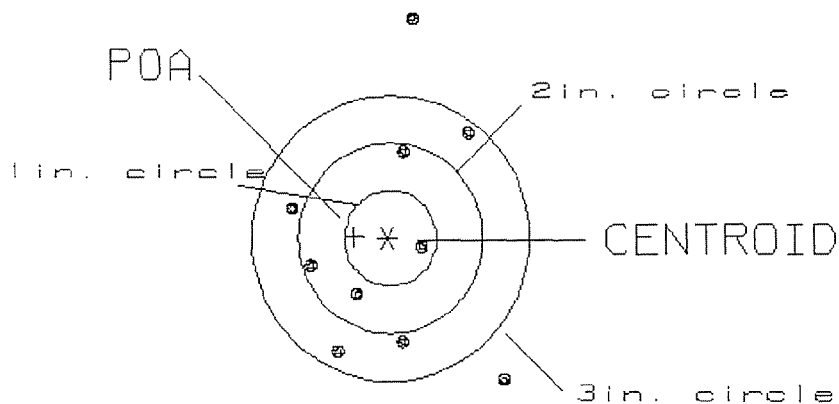
1
 5
 0

PATTERN #: ☐ 3 ☐
 POA TO CENTROID: .365
 MIN RADIUS : .305
 MEAN RADIUS : 1.199
 MAX RADIUS : 2.307
 CENTROID X : .364
 CENTROID Y : -.012

17 Apr 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/e6703425.1

CENTERFIRE PATTERN # 3



OF SHOTS= 10

IN CIRCLE

HS= 2.30

1

VS= 3.75

4

GS= 3.87

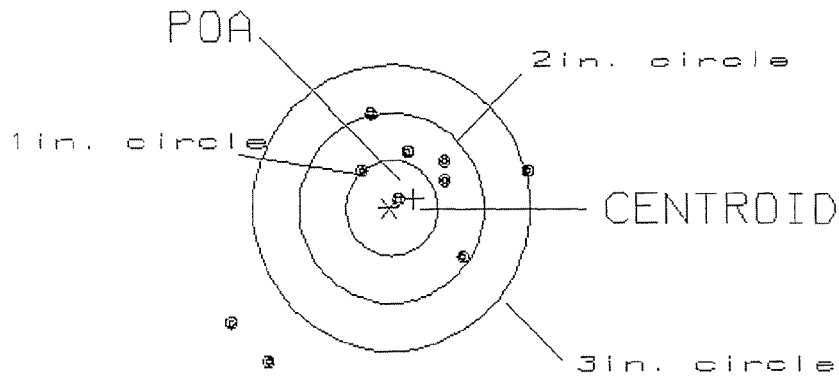
8

PATTERN #: 4
 POA TO CENTROID: .287
 MIN RADIUS : .097
 MEAN RADIUS : 1.016
 MAX RADIUS : 2.059
 CENTROID X : -.272
 CENTROID Y : -.090

17 Apr 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/e6703425.1

CENTERFIRE PATTERN # 4



OF SHOTS= 10

IN CIRCLE

HS= 3.16
 VS= 2.59
 GS= 3.53

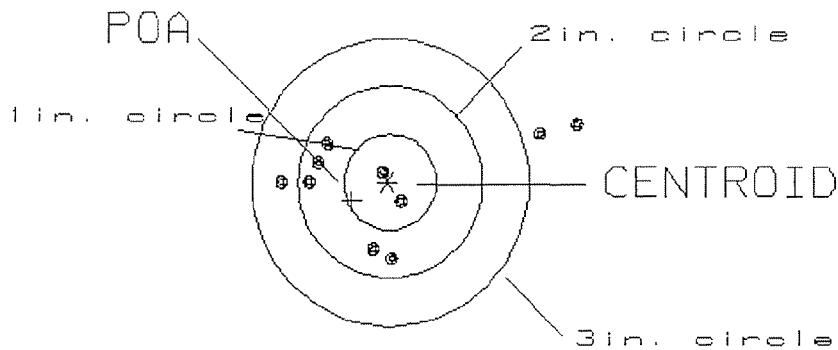
1
 6
 7

PATTERN #: C 5 L
 POA TO CENTROID: .429
 MIN RADIUS : .105
 MEAN RADIUS : .935
 MAX RADIUS : 2.120
 CENTROID X : .382
 CENTROID Y : .195

17 Apr 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/e6703425.1

CENTERFIRE PATTERN # 5



OF SHOTS= 10

IN CIRCLE

HS= 3.20
 VS= 1.44
 GS= 3.27

2
 7
 8

Remington Test Lab, Ilion, N.Y.

Centroidal distance calculations for Rifle # e6703425

3 May 2001

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0422

THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0678

THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0798604

THE AMR FOR THIS RIFLE IS: 1.078

CENTROIDAL DISTANCES

0 TO	1	.346706
1 TO	2	.693057
1 TO	3	.409939
1 TO	4	.469666
1 TO	5	.222991

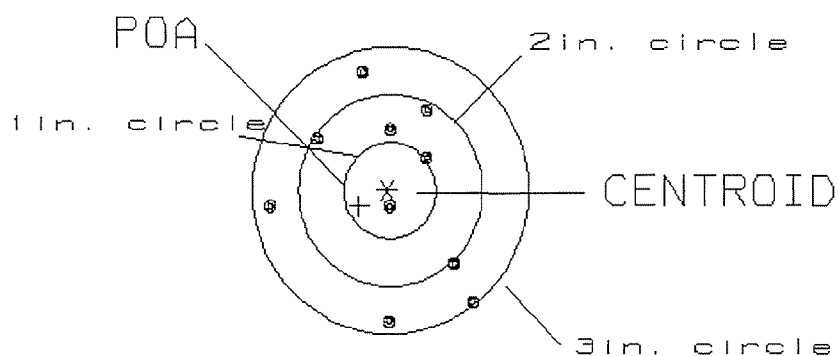
5 1
3 4 <----POA
2

PATTERN #: ☐ 1 ☐
 POA TO CENTROID: .347
 MIN RADIUS : .142
 MEAN RADIUS : .964
 MAX RADIUS : 1.459
 CENTROID X : .306
 CENTROID Y : .163

3 May 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/e6703425.1.1.1

CENTERFIRE PATTERN # 1



OF SHOTS= 10

IN CIRCLE

HS= 2.28

1

VS= 2.59

5

GS= 2.62

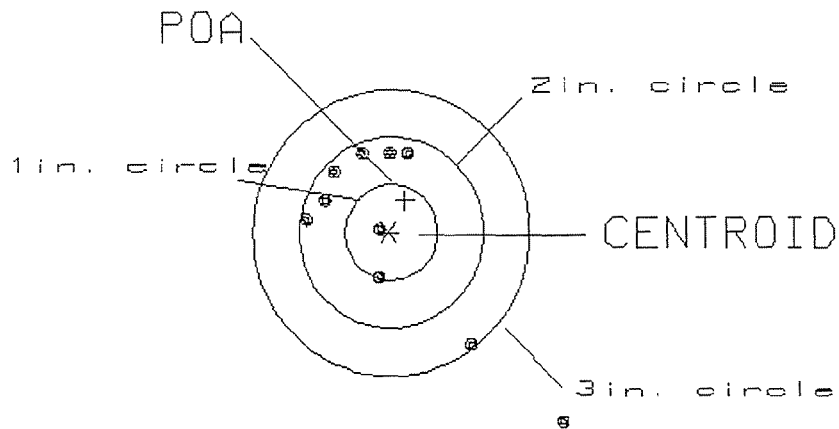
10

PATTERN #: ☐ 2 ☐
 POA TO CENTROID: .378
 MIN RADIUS : .175
 MEAN RADIUS : 1.005
 MAX RADIUS : 2.732
 CENTROID X : -.176
 CENTROID Y : -.335

3 May 2001

FILE:/Hqbasic/Accuracy/Patterning/Centerfire_Patt/e6703425.1.1.1

CENTERFIRE PATTERN # 2



OF SHOTS= 10

IN CIRCLE

HS= 2.83

2

VS= 2.85

6

GS= 3.59

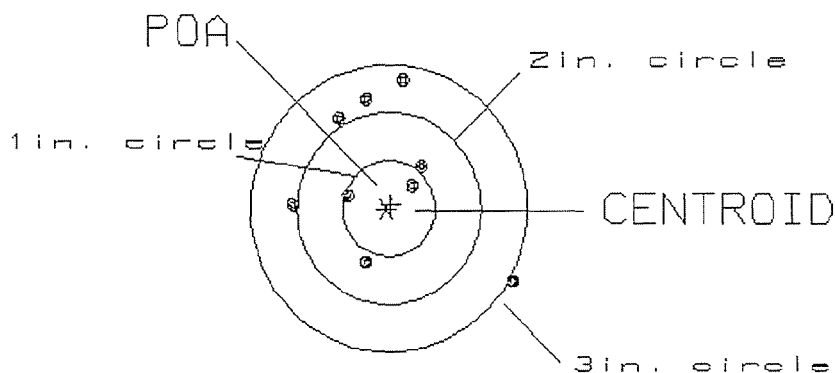
9

PATTERN #: 3
 POA TO CENTROID: .065
 MIN RADIUS : .337
 MEAN RADIUS : 1.135
 MAX RADIUS : 3.052
 CENTROID X : -.049
 CENTROID Y : -.042

3 May 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/e6703425.1.1.1

CENTERFIRE PATTERN # 3



OF SHOTS= 10

IN CIRCLE

HS= 2.42

1

VS= 4.37

4

GS= 4.38

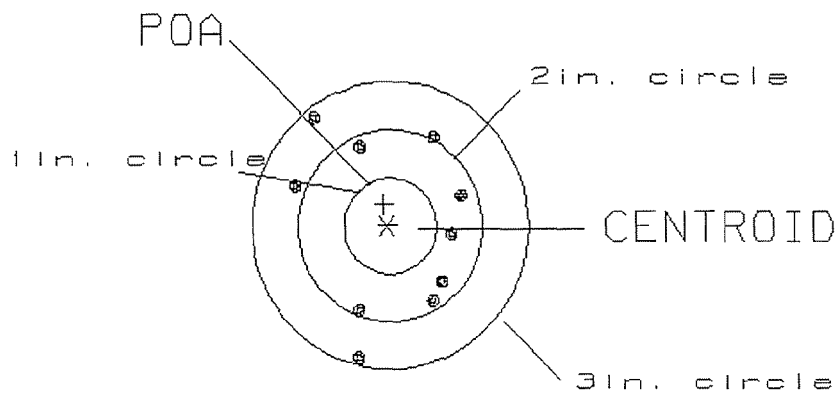
8

PATTERN #: 4
 POA TO CENTROID: .225
 MIN RADIUS : .619
 MEAN RADIUS : .988
 MAX RADIUS : 1.379
 CENTROID X : .037
 CENTROID Y : -.222

3 May 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/e6703425.1.1.1

CENTERFIRE PATTERN # 4



OF SHOTS= 10

IN CIRCLE

H3= 1.83

0

V5= 2.42

6

G5= 2.46

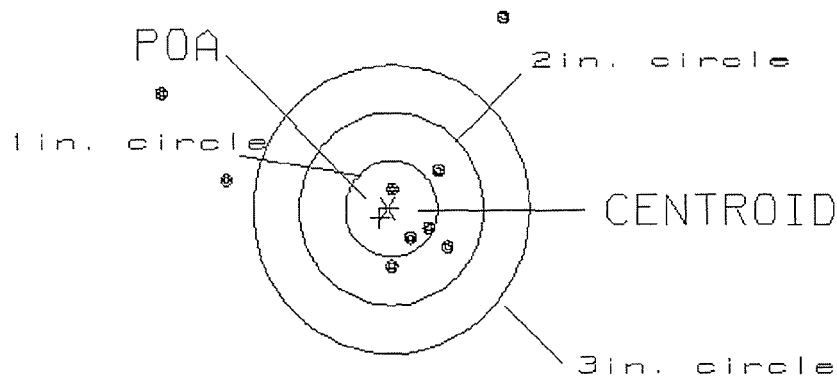
10

PATTERN #: ☐ 5 ☐
 POA TO CENTROID: .135
 MIN RADIUS : .246
 MEAN RADIUS : 1.297
 MAX RADIUS : 2.922
 CENTROID X : .093
 CENTROID Y : .097

3 May 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/e6703425.1.1.1

CENTERFIRE PATTERN # 5



OF SHOTS= 10

IN CIRCLE

HS= 3.81
 VS= 4.59
 GS= 5.40

3
 6
 6

Remington Test Lab, Ilion, N.Y.

Centroidal distance calculations for Rifle # E6703425
16 Apr 2001

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0818
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.08
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .114417

THE AMR FOR THIS RIFLE IS: 1.45

CENTROIDAL DISTANCES

Ø TO	1	.375133
1 TO	2	.82716
1 TO	3	.503672
1 TO	4	.45736
1 TO	5	.559671

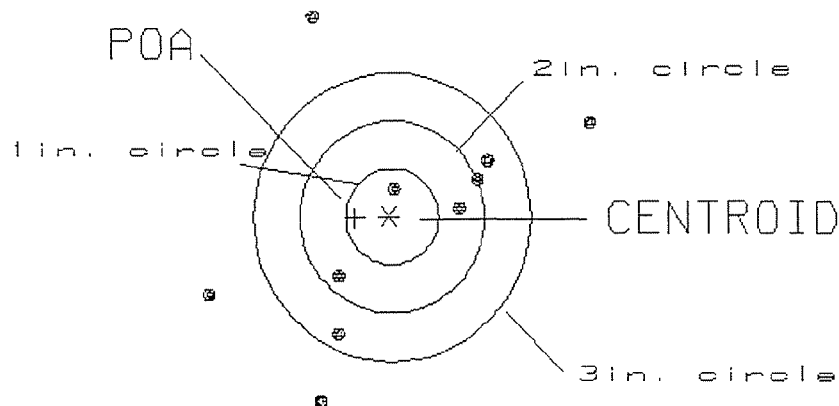
54+ 1 <----POA
2

PATTERN #: L 1 L
 POA TO CENTROID: .375
 MIN RADIUS : .328
 MEAN RADIUS : 1.432
 MAX RADIUS : 2.309
 CENTROID X : .375
 CENTROID Y : .010

16 Apr 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/E6703425

CENTERFIRE PATTERN # 1



OF SHOTS= 10

IN CIRCLE

HS= 4.07

1

VS= 4.02

3

GS= 4.44

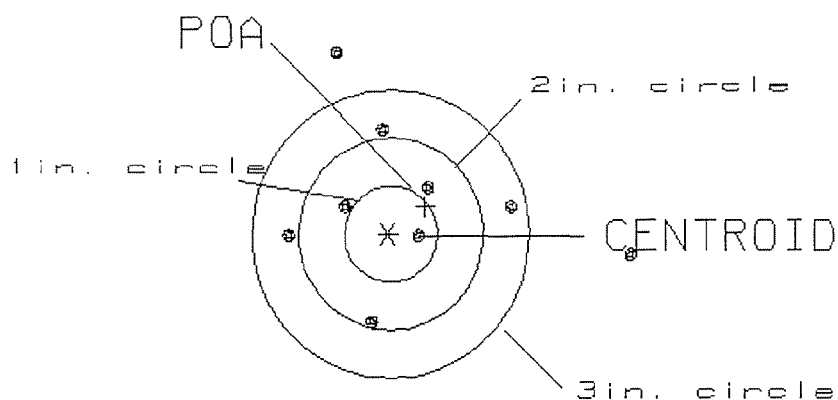
6

PATTERN #: ☐ 2 ☐
 POA TO CENTROID: .490
 MIN RADIUS : .296
 MEAN RADIUS : 1.413
 MAX RADIUS : 3.516
 CENTROID X : -.397
 CENTROID Y : -.287

16 Apr 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/E6703425

CENTERFIRE PATTERN # 2



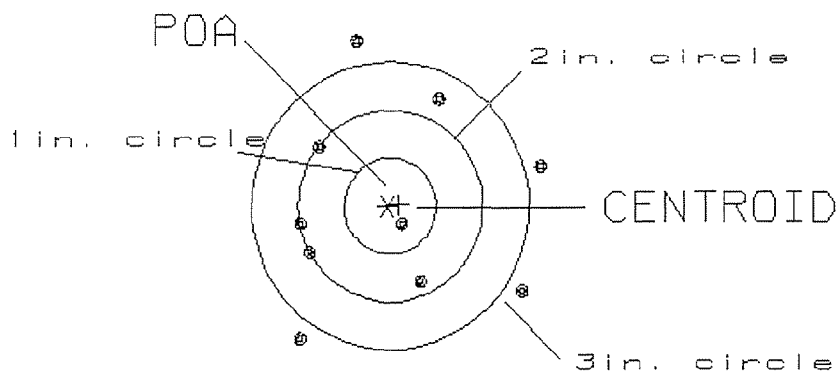
# OF SHOTS=	10	# IN CIRCLE
HS=	4.67	1
VS=	4.71	4
GS=	5.38	7

PATTERN #: 3
 POA TO CENTROID: .129
 MIN RADIUS : .218
 MEAN RADIUS : 1.210
 MAX RADIUS : 1.728
 CENTROID X : -.128
 CENTROID Y : -.016

16 Apr 2001

FILE:/Hqbasic/Accuracy/Patterning/Centerfire_Patt/E6703425

CENTERFIRE PATTERN # 3



OF SHOTS= 10

IN CIRCLE

HS= 2.68
 US= 3.02
 GS= 3.24

1
 4
 6

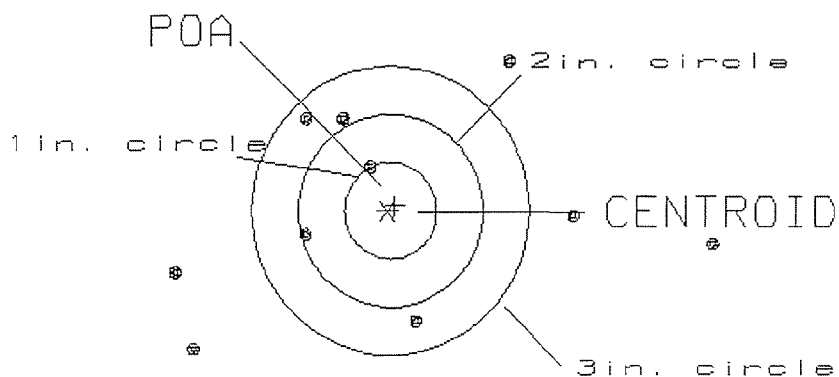
PATTERN #: 4

POA TO CENTROID: .095
 MIN RADIUS : .479
 MEAN RADIUS : 1.758
 MAX RADIUS : 3.531
 CENTROID X : -.078
 CENTROID Y : -.053

16 Apr 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/E6703425

CENTERFIRE PATTERN # 4



OF SHOTS= 10

IN CIRCLE

H3= 5.84
 V3= 3.02
 G3= 5.85

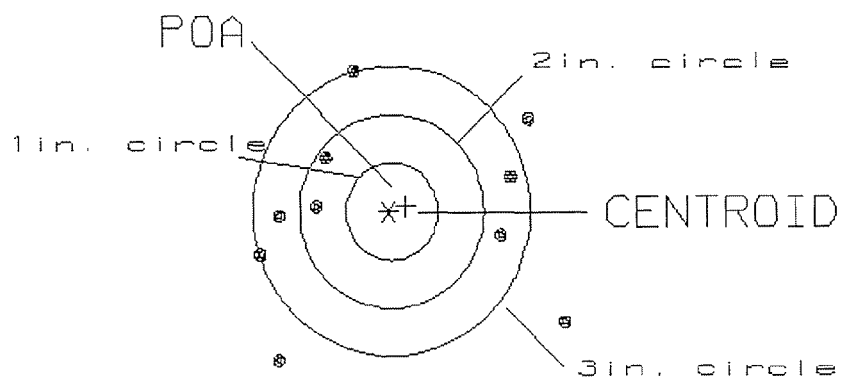
1
 2
 5

PATTERN #: 5
 POA TO CENTROID: .189
 MIN RADIUS : .866
 MEAN RADIUS : 1.436
 MAX RADIUS : 2.187
 CENTROID X : -.181
 CENTROID Y : -.054

16 Apr 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/E6703425

CENTERFIRE PATTERN # 5



OF SHOTS= 10

IN CIRCLE

HS= 3.25

0

VS= 2.96

2

GS= 3.72

7

Remington Test Lab, Ilion, N.Y.

Centroidal distance calculations for Rifle # e6703425
30 Apr 2001

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .2722
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.4746
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .547118

THE AMR FOR THIS RIFLE IS: 1.303

CENTROIDAL DISTANCES

0 TO	1	.0822982
1 TO	2	.354799
1 TO	3	.398544
1 TO	4	.756606
1 TO	5	1.05167

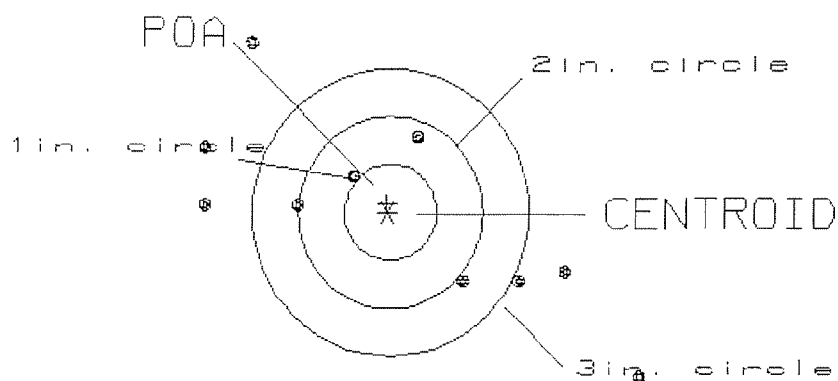
† <----POA
3
2
4
5

PATTERN #: C 1 C
 POA TO CENTROID: .082
 MIN RADIUS : .581
 MEAN RADIUS : 1.673
 MAX RADIUS : 3.196
 CENTROID X : .007
 CENTROID Y : -.082

30 Apr 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/e6703425.1.1

CENTERFIRE PATTERN # 1



OF SHOTS= 10

IN CIRCLE

HS= 4.72

0

VS= 3.57

2

GS= 5.52

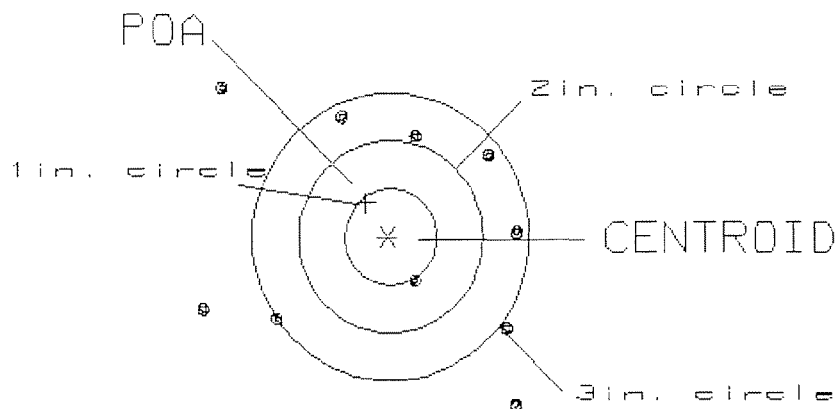
4

PATTERN #: 2
 POA TO CENTROID: .424
 MIN RADIUS : .542
 MEAN RADIUS : 1.566
 MAX RADIUS : 2.384
 CENTROID X : .236
 CENTROID Y : -.353

30 Apr 2001

FILE:/Hqbasic/Accuracy/Patterning/Centerfire_Patt/e6703425.1.1

CENTERFIRE PATTERN # 2



OF SHOTS= 10

IN CIRCLE

HS= 3.39

0

VS= 3.34

1

GS= 4.62

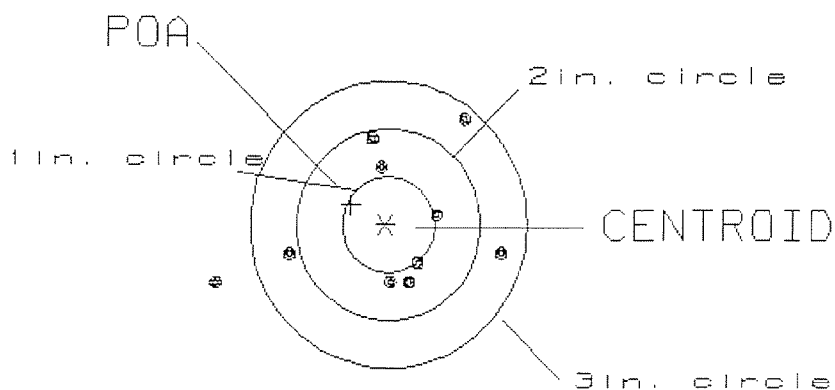
5

PATTERN #: E 3 E
 POA TO CENTROID: .429
 MIN RADIUS : .491
 MEAN RADIUS : .950
 MAX RADIUS : 1.981
 CENTROID X : .378
 CENTROID Y : -.204

30 Apr 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/e6703425.1.1

CENTERFIRE PATTERN # 3



OF SHOTS= 10

IN CIRCLE

HS= 3.15

1

VS= 1.68

6

GS= 3.16

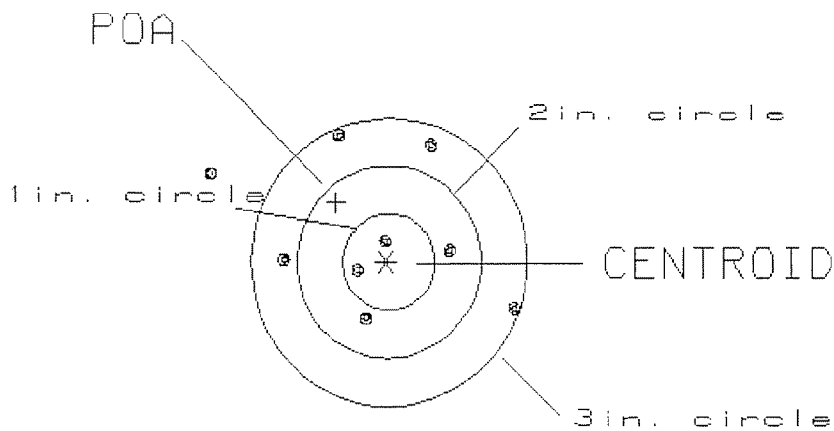
9

PATTERN #: 4
 POA TO CENTROID: .822
 MIN RADIUS : .222
 MEAN RADIUS : 1.238
 MAX RADIUS : 3.099
 CENTROID X : .541
 CENTROID Y : -.618

30 Apr 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/e6703425.1.1

CENTERFIRE PATTERN # 4



OF SHOTS= 10

IN CIRCLE

HS= 3.71
 VS= 3.67
 GS= 5.07

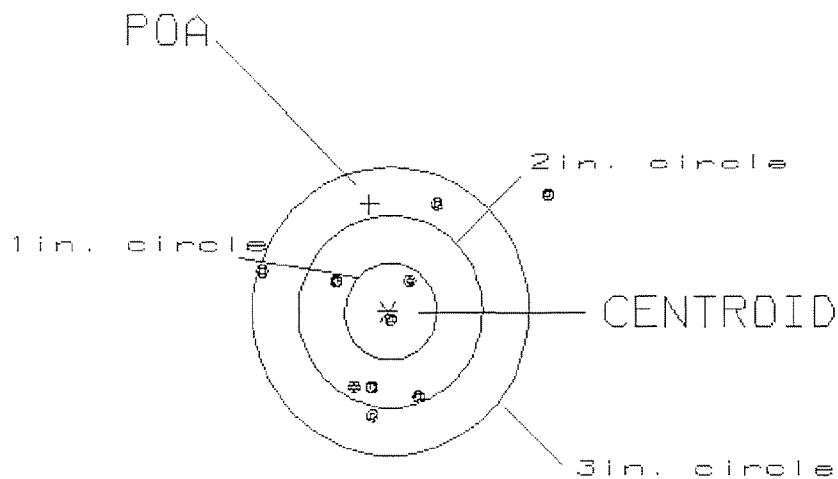
2
 4
 8

PATTERN #: 5
 POA TO CENTROID: 1.134
 MIN RADIUS : .079
 MEAN RADIUS : .946
 MAX RADIUS : 2.108
 CENTROID X : .199
 CENTROID Y : -1.116

30 Apr 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/e6703425.1.1

CENTERFIRE PATTERN # 5



OF SHOTS= 10

IN CIRCLE

HS= 3.04

2

VS= 2.30

6

GS= 3.16

9

OP. #	OPERATION NAME	READINGS	DATE	INITIAL
625	F) SAFETY ON FORCE	<u>7.5</u> <u>6.50</u> <u>7.0</u>	4-12	RHL
CONT.	G) SAFETY OFF FORCE	<u>2.75</u> <u>3.25</u> <u>3.25</u>	4-12	RHL
	H) TRIGGER PULL TEST AND RETAINABILITY		10/27/01	RHL
	I) FIRING PIN INDENT	<u>.024</u> <u>.025</u> <u>.023</u>	4-12	RHL
	J) ASSEMBLE STOCK		4-10	CC
	K) ASSEMBLE SWIVEL STUDS		10-27-01	RHL
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		10-27-01	RHL
	M) IRON SIGHT ALIGNMENT		10-27-01	RHL
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		10-27-01	RHL
640	GALLERY TEST AND TARGET		5/2/01 4-16-01	RHL
	A) MALFUNCTIONS	CLOSES HARD OVER LIVE RDS BAD CHAMBER 5/2/01	4/12/01 4-16-01	RHL
	B) PIERCED PRIMERS	5/2/01	4-16-01 4/12/01	RHL
645	INSPECT FOR LIVE AMMO	5/2/01	4-16-01 4/12/01	RHL
655	FINAL INSPECTION A) HEADSPACE		10/27/01	RHL
	B) TRIGGER PULL	<u>2.12</u> <u>2.41</u> <u>2.36</u> <u>2.29</u> <u>2.30</u>	4-12	RHL
	C) FUNCTION		10-27-01	RHL
660	PACK		10/30/01	RHL

ISRAELI GUNS

CONTRACT # DAAE20-97-C-0182

GUN SERIAL # E 670 3425

OP. #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		4-10	CC
600	PROOF		4-10	CC
607	CHECK HEADSPACE		4-10	CC
610	DIS-ASSEMBLE GUN		4-10	CC
612	MAGNAFLUX BARREL ACTION		4-11-01	AC
	MAGNAFLUX BOLT		4-11-01	AC
615	ROLLMARK CALIBER		4-11-01	RL
617	DRILL AND TAP SIGHT HOLES		4-7-01	DA
618	POLISH BARREL		4-11-01	GD
620	APPLY COATINGS (BARREL ACTION)		4-11-01	TH
	(BOLT)		4-11-01	JA
625	FINAL ASSEMBLY A) CLEAN INSIDE OF BOLT ASSEMBLY		4-15-01	RL
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		4-15-01	RL
	C) INSPECT EJECTOR HOLE FOR CHAMFER		4-15-01	RL
	D) OIL FIRING PIN ASSEMBLY		4-15-01	RL
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE		4-15-01	RL