

C6225409

MODEL 700™ M24

Model **SWS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

Sweet®
No. 2.142.51

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6225409.___0

FILE DATE AND TIME: 11/12/2003 12:01

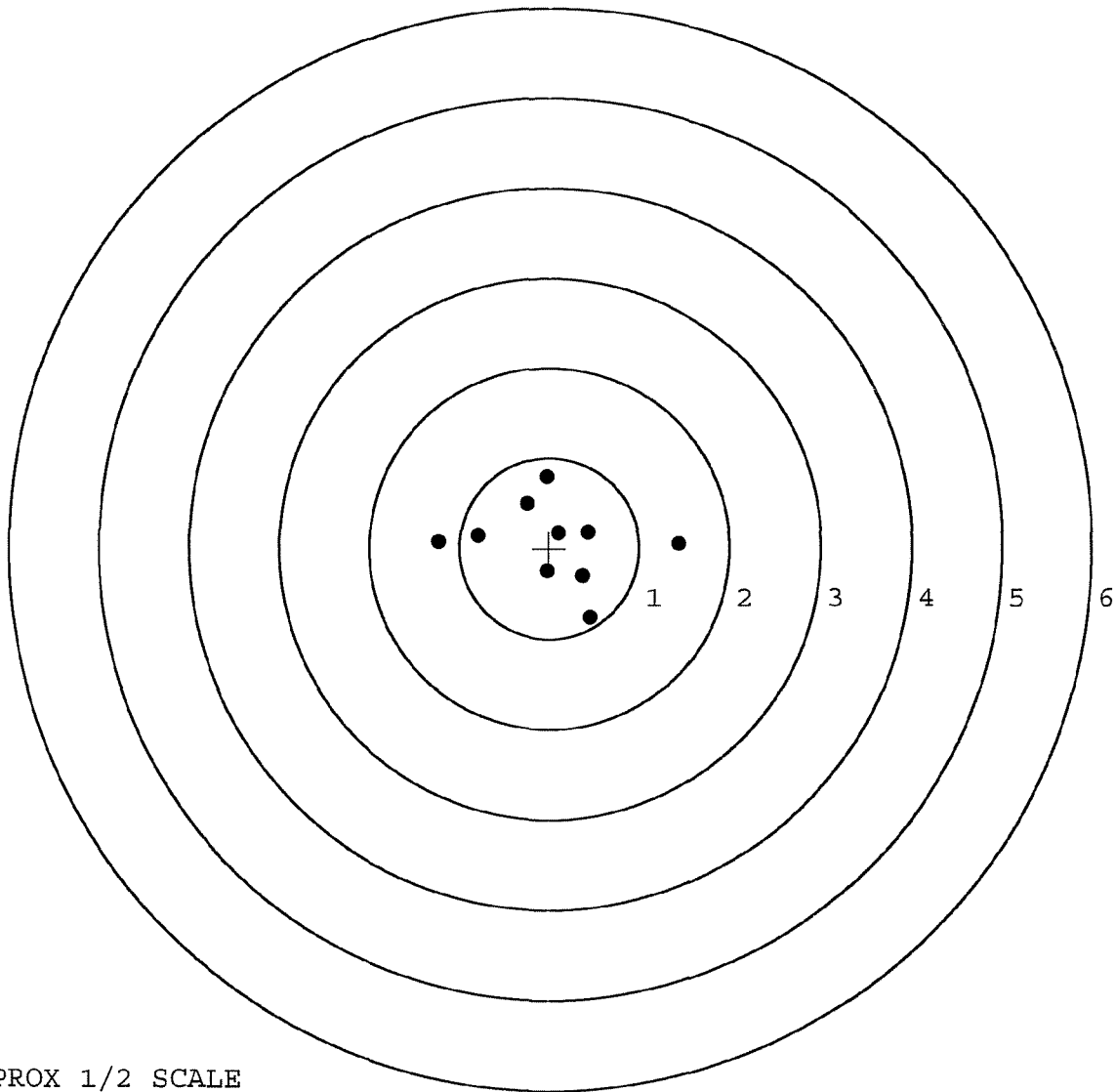
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.073
The Average Y Centroid of the Five Target Set:	-0.028
The Average Point of Impact of the Five Target Set:	0.078
The Average Mean Radius of the Five Target Set:	0.601
The Distance from POA to Centroid Target #1:	0.074
The Distance from Centroid Target #2 to Centroid Target #1:	0.244
The Distance from Centroid Target #3 to Centroid Target #1:	0.284
The Distance from Centroid Target #4 to Centroid Target #1:	0.186
The Distance from Centroid Target #5 to Centroid Target #1:	0.075

SERIAL NUMBER: C6225409. __0
TARGET NUMBER: 1
FILE DATE: 11/12/2003
FILE TIME: 12:01

POINT#	X	Y
1:	1.440	0.049
2:	0.458	-0.769
3:	-0.031	0.792
4:	-0.251	0.487
5:	-0.792	0.140
6:	-1.228	0.068
7:	0.379	-0.309
8:	-0.026	-0.254
9:	0.435	0.178
10:	0.109	0.171

X CENTROID: 0.049
Y CENTROID: 0.055
POA TO CENTROID: 0.074
HORZ SPREAD: 2.668
VERT SPREAD: 1.561
GROUP SPREAD: 2.668
MIN RADIUS: 0.130
MAX RADIUS: 1.391
MEAN RADIUS: 0.705
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10

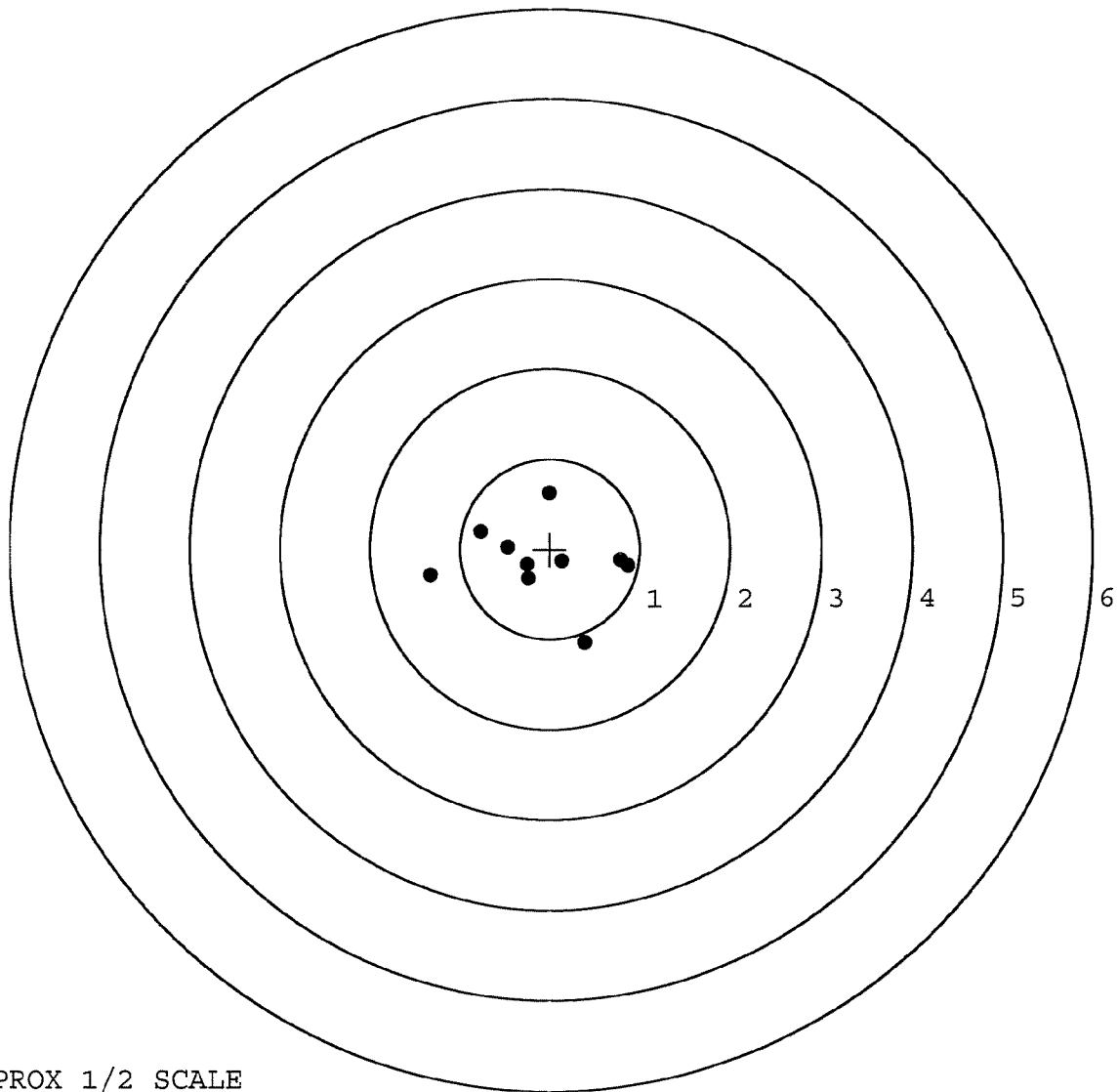


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6225409. __0
TARGET NUMBER: 2
FILE DATE: 11/12/2003
FILE TIME: 12:01

POINT#	X	Y
1:	-0.007	0.626
2:	0.781	-0.121
3:	0.869	-0.191
4:	0.392	-1.041
5:	0.136	-0.138
6:	-0.245	-0.330
7:	-0.772	0.195
8:	-0.468	0.020
9:	-1.327	-0.297
10:	-0.257	-0.177

X CENTROID: -0.090
Y CENTROID: -0.145
POA TO CENTROID: 0.171
HORZ SPREAD: 2.196
VERT SPREAD: 1.667
GROUP SPREAD: 2.199
MIN RADIUS: 0.170
MAX RADIUS: 1.246
MEAN RADIUS: 0.668
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10

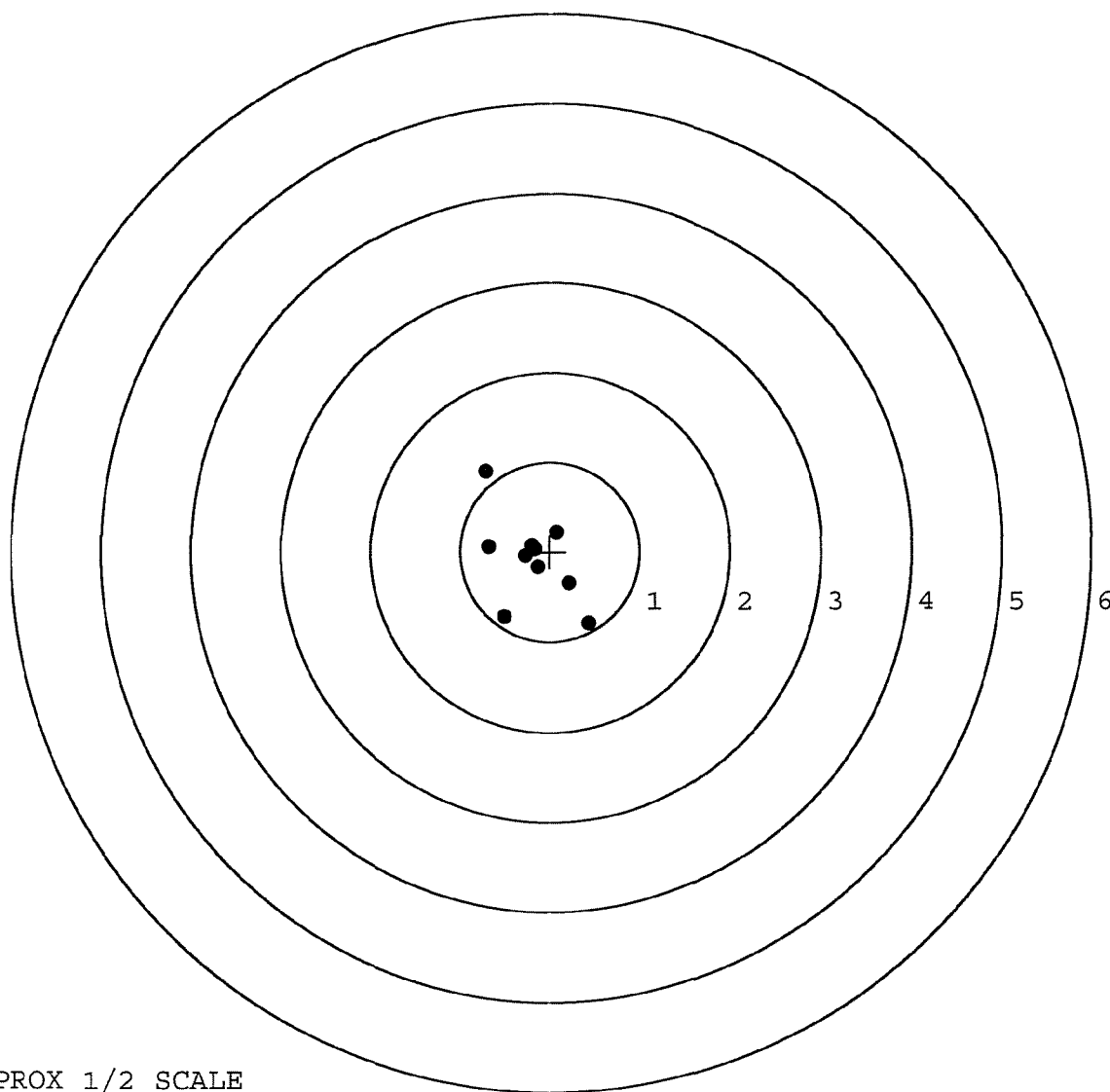


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6225409.___0
TARGET NUMBER: 3
FILE DATE: 11/12/2003
FILE TIME: 12:01

POINT#	X	Y
1:	-0.722	0.896
2:	-0.683	0.054
3:	-0.510	-0.732
4:	0.439	-0.805
5:	0.218	-0.355
6:	0.079	0.216
7:	-0.202	0.069
8:	-0.279	-0.049
9:	-0.138	-0.177
10:	-0.171	0.028

X CENTROID: -0.197
Y CENTROID: -0.085
POA TO CENTROID: 0.215
HORZ SPREAD: 1.161
VERT SPREAD: 1.701
GROUP SPREAD: 2.059
MIN RADIUS: 0.090
MAX RADIUS: 1.113
MEAN RADIUS: 0.467
IN 1 IN DIAMETER: 6
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

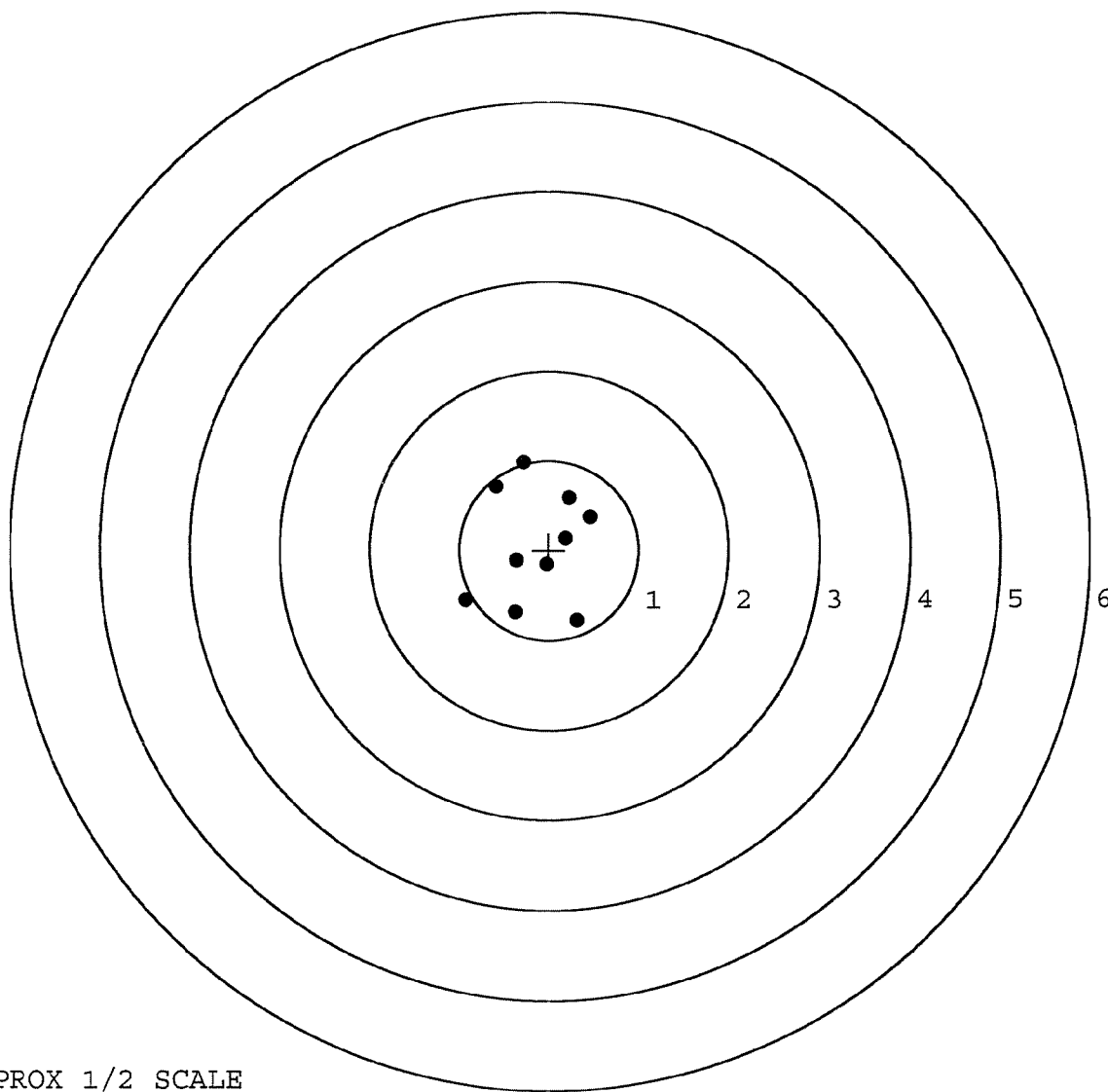


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6225409.___0
TARGET NUMBER: 4
FILE DATE: 11/12/2003
FILE TIME: 12:01

POINT#	X	Y
1:	-0.282	0.984
2:	-0.587	0.707
3:	0.230	0.585
4:	0.460	0.368
5:	0.192	0.130
6:	-0.026	-0.165
7:	-0.364	-0.116
8:	-0.378	-0.692
9:	-0.927	-0.556
10:	0.318	-0.782

X CENTROID: -0.136
Y CENTROID: 0.046
POA TO CENTROID: 0.144
HORZ SPREAD: 1.387
VERT SPREAD: 1.766
GROUP SPREAD: 1.670
MIN RADIUS: 0.238
MAX RADIUS: 0.994
MEAN RADIUS: 0.665
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 10
in 3 IN DIAMETER: 10

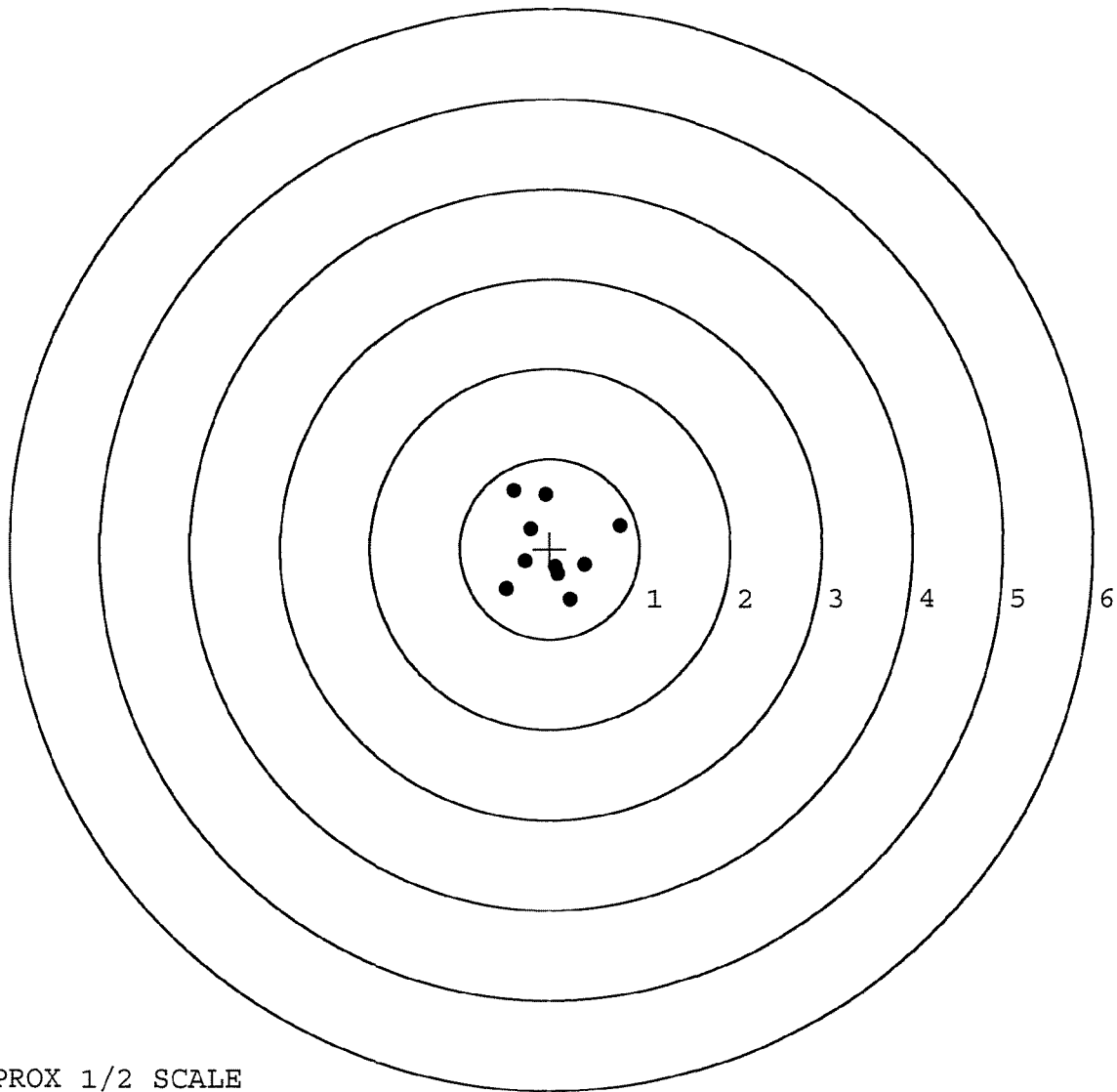


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6225409.___0
TARGET NUMBER: 5
FILE DATE: 11/12/2003
FILE TIME: 12:01

POINT#	X	Y
1:	-0.054	0.606
2:	-0.408	0.651
3:	-0.221	0.221
4:	0.779	0.256
5:	0.388	-0.183
6:	-0.278	-0.140
7:	-0.482	-0.452
8:	0.230	-0.563
9:	0.087	-0.280
10:	0.066	-0.204

X CENTROID: 0.011
Y CENTROID: -0.009
POA TO CENTROID: 0.014
HORZ SPREAD: 1.261
VERT SPREAD: 1.214
GROUP SPREAD: 1.446
MIN RADIUS: 0.203
MAX RADIUS: 0.813
MEAN RADIUS: 0.501
IN 1 IN DIAMETER: 5
IN 2 IN DIAMETER: 10
in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

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

R & E NUMBER	71767		
SERIAL NUMBER	C6225409		
LOG-IN DATE	10-21-03		
INSPECT AND VERIFY:			
OPERATION #	OPERATION NAME	DATE	INITIAL
550	DIS-ASSEMBLE GUN	10-27-03	RTL
560 A	RE-BARREL	10-29-03	RTL
B	DRILL AND TAP	11-4-03	TRL
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 OPERATOR		
615	ROLLMARK CALIBER	11-5-03	AB
618	ROTO-BLAST		
620	APPLY COATINGS	11-8	TA
625 A	FINAL ASSEMBLY	11-11-03	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	11-12-03	AC
655	FINAL INSPECT	12-15-03	RR
660	PACK	12-16-03	QTA
		SHIP DATE	
QAR INSPECTION DATE			

VERAGE PULL FORCE BETWEEN
L & CYCLE TESTS

SERIAL NO. _____

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)

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	2.32	2.21		2.27	
PULL #2	2.43	2.28		2.30	
PULL #3	2.38	2.22		2.37	
PULL #4	2.19	2.27		2.52	
PULL #5	2.27	2.19		2.31	
TOTAL	11.59	11.17		11.77	
AVERAGE	2.31	2.23		2.35	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.15	3.29		
PULL #2	3.16	3.26		
PULL #3	3.11	3.40		
PULL #4	3.18	3.28		
PULL #5	3.09	3.27		
TOTAL	15.69	16.50		
AVERAGE	3.13	3.30		

	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	4.18	4.22		4.21
PULL #2	4.13	4.46		4.08
PULL #3	4.25	4.41		4.36
PULL #4	4.18	4.36		4.35
PULL #5	4.31	4.38		4.35
TOTAL	21.05	21.83		21.35
AVERAGE	4.21	4.36		4.27

RECEIVING AND ESTIMATING REPORT

COMMENTS

ORDER
R 96-16373

M-24 SNIPER

INITIAL
JJM

CUSTOMER ORDER NO.

DATE RECEIVED

07/15/96

DATE OPENED

07/15/96

DATE CODE

CJ 4-89

SERIAL NUMBER

C6225409

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 96003

Repowder Coat Trigger Guard
Assy Front & Rear Sight Bases
Rezind 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

M2400060278

~~622 5311~~ (206) 967-8801
Lee

C 622 5409

Reppa. Gun REMAINING
DECK

Need Swivels
(206) 967-8813

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 (a) 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	X EXCESS OF 10,000 RDS							
		C6225181	PER GUN, EACH NEEDS							
		C6225524	RE-BARRELING							
		C6348969	T/I TRIGGERS/STOCKS							
		C6348954	Repowder Cont Trigger							
		C6225270	X THESE WEAPONS WERE CASE							
		C6225467	SHOT IN THE LAST							
		C6348907	SNIPER CLASS, SNIPER							
		C6225409	Committee said they							
		C6348868	NEED RE-BARRELING							
		C6225174	DUE TO POOR SHOT PERFORMANCE							
		C6348981	AND EXCESS RDS.							
			7/24/96							
			* 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: C6225409

DATE REC'D: 7/15/96

DATE RET'D:

AUDITOR: AW

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:

CONTRACT # DAAA21-87-C-0086

Barrel

GUN SERIAL #

C6225409

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						

RECEIVING AND ESTIMATING REPORT

COMMENTS

ORDER
R 96-16373

INITIAL
JJM

CUSTOMER ORDER NO.

M-24 SNIPER

DATE RECEIVED

07/15/96

DATE OPENED

07/15/96

DATE CODE

CJ 4-89

SERIAL NUMBER

C6225409

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

BOLT ASSY.

B3

BARREL ASSY.

B4

D1

REC. ASSY.

B5

D2

WOOD

C1

D3

METAL

C2

MAIN FAULT

PARTS

COMMENTS

Barrel 96003

Repowder Coat Trigger Guard
Assy Front & Rear Sight Bases
Rezind 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

M2400060284

RECEIVING AND ESTIMATING REPORT

COMMENTS

ORDER
R 96-16380

M-24 SNIPER

INITIAL
JJM

CUSTOMER ORDER NO.

DATE RECEIVED
07/15/96

DATE OPENED
07/15/96

DATE CODE
DJ 9-89

SERIAL NUMBER
C6348868

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

BOLT ASSY.

B3

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
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

M2400060285

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

DA FORM 2404
1 APR 79

Replaces edition of 1 Jan 64, which will be used

Final Inspection

Sn: C6348868

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: _____

CONTRACT # DAAA21-87-C-0086

Barrel

GUN SERIAL #

C6348868

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.

MODEL 700™ H24

SERIAL NO.
C6225409

ORDER NO.
5716

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

01



5716 C6225409

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6225409

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	4 21	89	RW
600	Proof	4 21	89	RW
607	Check Headspace	4 21	89	RW
610	Dis-assemble Gun	4 21	89	RW
612	Magnaflux Barrel Action		4/26	KCR
	Magnaflux Bolt		4/27	KCR
615	Rollmark Caliber		4/27	BT
617	Drill and Tap Sight Holes	4 27	89	LB
618	Polish Barrel RB	4 27	09	BT
620	Apply Coatings (Barrel Action)		5/15/89	TJH
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		5/17/89	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/17/89	RW
	C) Inspect Ejector Hole for Chamfer		5/17/89	RW
	D) Oil Firing Pin Ass'y		5/17/89	RW
	E) Adjust Trigger Pull to Min Setting and Stake		5/23/89	J.u.

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	8	7	7			5/23/89	RW
	G) Safety Off Force	3	3	3			5/23/89	RW
	H) Trigger Pull Test & Retainability						5/23/89	G. U.
	I) Firing Pin Indent	.022	.021	.0215			5/23/89	RW
	J) Assemble Stock						5/23/89	RW
	K) Assemble Swivel Studs						25 May 89	JS
	L) Attach Front and Rear Sight Assemblies						5/23/89	RW
	M) Iron Sight Alignment						5/23/89	RW
	N) Detach Front & Rear Sights & place in numbered container						5/23/89	RW
	O) Attach Scope to Rifle						5/23/89	WLB
	P) Detach & Attach Scope 20 Times						5/23/89	WLB
640	Gallery Target & Test	61R	91L				5/24/89	DH
	A) Time						5/24/89	DH
	B) Malfunctions						5/24/89	DH
	C) Pierced Primers						5/24/89	DH
	D) Optical Clarity of Scope						5/24/89	DH
645	Inspect for Live Ammo						5/24/89	DH
655	Final Inspection							
	A) Headspace						25 May 89	JS
	B) Trigger Pull	2.43	2.46	2.57	2.66	2.55	25 May 89	JS
	C) Function						25 May 89	JS
660	Pack						27 June 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. C6225409

DATE 3-29-90

TESTER 221

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.43	2.56		2.32	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.47	2.52		2.37	
PULL #3	2.53	2.50		2.34	
PULL #4	2.53	2.52		2.33	
PULL #5	2.52	2.51		2.32	
TOTAL	12.48	12.61		11.68	
AVG.	2.496	2.522		2.336	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.46	3.13		
PULL #2	3.32	3.43		
PULL #3	3.32	3.41		
PULL #4	3.15	3.37		
PULL #5	3.15	3.34		
TOTAL	16.40	16.68		
AVG.	3.28	3.336		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.19	4.18		
PULL #2	4.42	4.25		
PULL #3	4.28	4.23		
PULL #4	4.29	4.28		
PULL #5	4.26	4.33		
TOTAL	21.44	21.27		
AVG.	4.288	4.254		

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06225409
30 May 1989

CENTROIDAL DISTANCES

0 TO	1	.592724
1 TO	2	.216622
1 TO	3	.481121
1 TO	4	.591697
1 TO	5	.967397

$\frac{4}{12} S$ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.9434
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.2518
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .255513

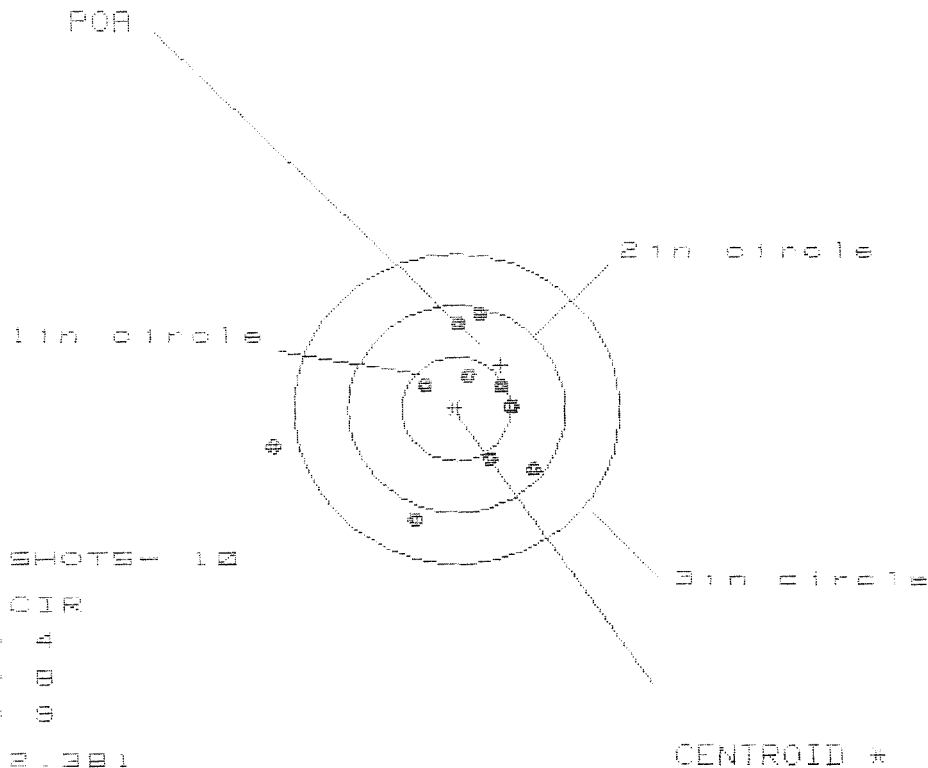
THE AMR FOR THIS RIFLE IS: .9426

24 May 1989

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CENTERFIRE PATTERNS

1



OF SHOTS- 10

IN CIR

1in = 4

2in = 8

3in = 9

HS= 2.381

VS= 1.999

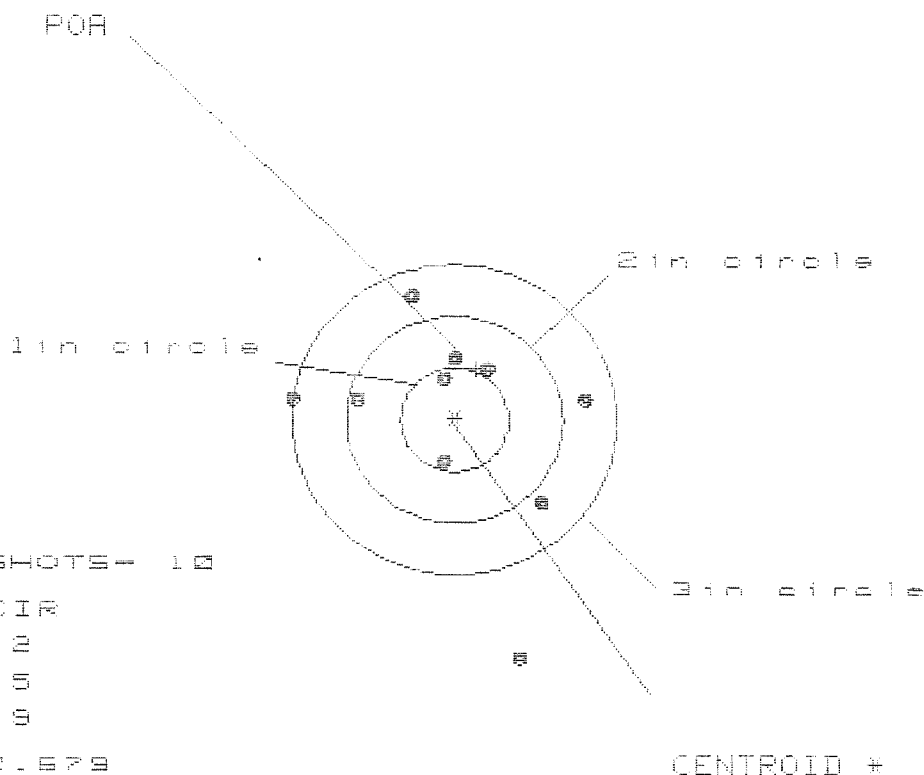
GS= 2.389

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.728	.545	.472
MINIMUM X	-1.653	-.580	-.539
MAXIMUM Y	.941	.896	.758
MINIMUM Y	-1.058	-1.103	-.783
CENTROID X	-.409	-.226	-.153
CENTROID Y	-.429	-.384	-.246
POR TO CENTROID in.	.593	.445	.290
MIN RADIUS	.357	.297	.172
MEAN RADIUS	.788	.643	.537
MAX RADIUS	1.701	1.246	.914
HORIZONTAL SPREAD	2.381	1.125	1.011
VERTICAL SPREAD	1.999	1.999	1.541
EXTREME SPREAD	2.389	2.093	1.622
NUMBER IN ONE INCH CIRCLE =	4		
NUMBER IN TWO INCH CIRCLE =	8		
NUMBER IN THREE INCH CIRCLE =	9		

24 May 1989

FILE:/PATTERNING/CENTERFIRE_PATT/08225409

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 9

HE= 2.679

VS= 3.457

GS= 3.605

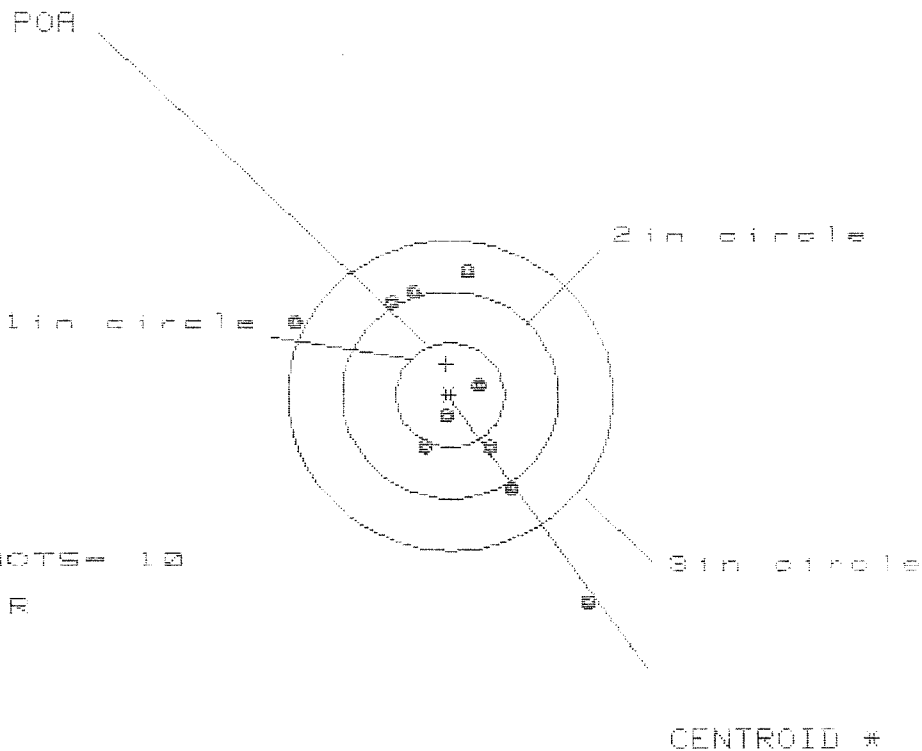
PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.232	1.298	1.136
MINIMUM X	:	-1.447	-1.381	-.996
MAXIMUM Y	:	1.193	.942	.940
MINIMUM Y	:	-2.264	-1.052	-1.054
CENTROID X	:	-.204	-.270	-.098
CENTROID Y	:	-.499	-.248	-.246
POA TO CENTROID in.	:	.539	.366	.265
MIN RADIUS	:	.372	.171	.253
MEAN RADIUS	:	1.036	.829	.753
MAX RADIUS	:	2.342	1.381	1.250
HORIZONTAL SPREAD	:	2.679	2.679	2.122
VERTICAL SPREAD	:	3.457	1.994	1.994
EXTREME SPREAD	:	3.605	2.679	2.328
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

24 May 1985

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CENTERFIRE PATTERNS

3



OF SHOTS - 10

IN CIR

1 in = 2

2 in = 4

3 in = 8

HS = 2.574

VS = 3.222

GS = 3.794

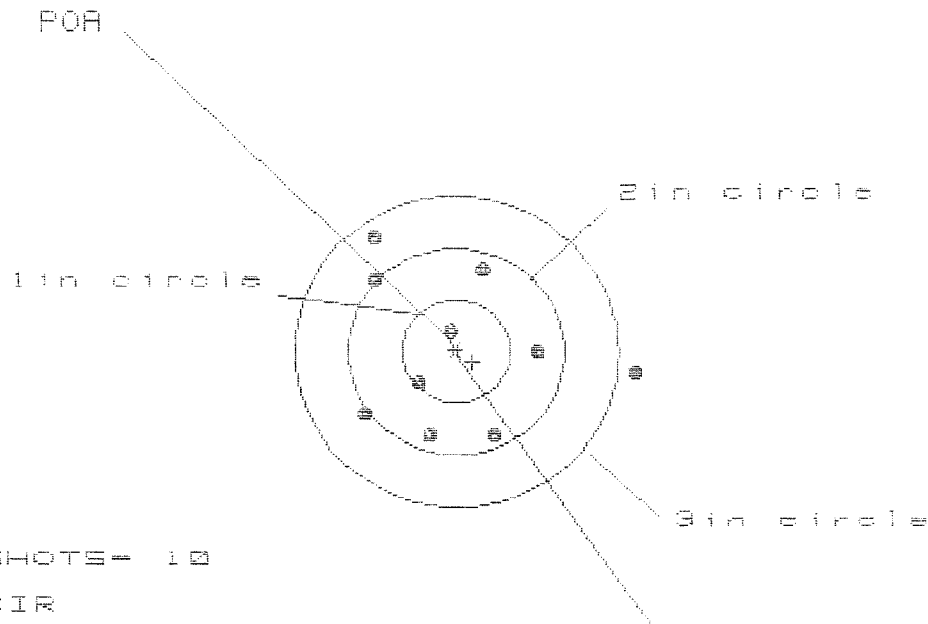
PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.232	.691	.528
MINIMUM X	:	-1.442	-1.305	-.564
MAXIMUM Y	:	1.245	1.025	1.087
MINIMUM Y	:	-1.977	-1.098	-1.036
CENTROID X	:	.034	-.103	.060
CENTROID Y	:	-.301	-.081	-.143
POA TO CENTROID in.	:	.303	.132	.155
MIN RADIUS	:	.209	.379	.209
MEAN RADIUS	:	.995	.858	.760
MAX RADIUS	:	2.330	1.396	1.163
HORIZONTAL SPREAD	:	2.674	1.996	1.092
VERTICAL SPREAD	:	3.222	2.123	2.123
EXTREME SPREAD	:	3.794	2.554	2.155
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	

24 May 1989

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CENTERFIRE PATTERNS

4



OF SHOTS= 10

IN CIR

1 in = 2

2 in = 6

3 in = 9

HE= 2.459

VE= 1.915

GE= 2.746

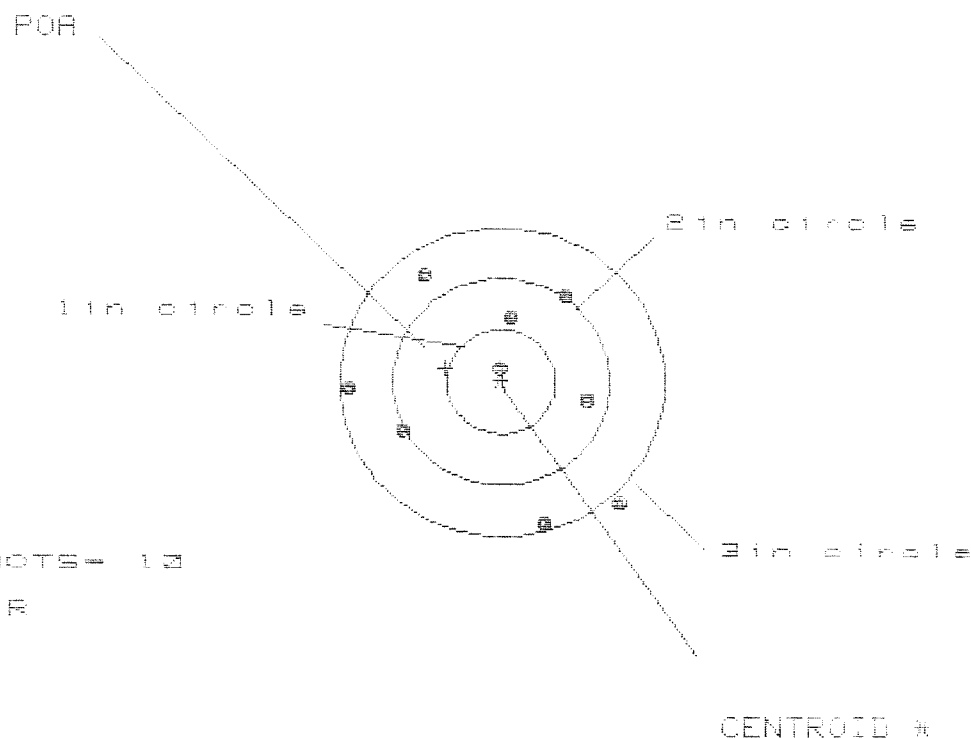
CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.657	.920	.843
MINIMUM X	:	-.802	-.618	-.695
MAXIMUM Y	:	1.068	1.050	.929
MINIMUM Y	:	-.847	-.865	-.733
CENTROID X	:	-.150	-.334	-.257
CENTROID Y	:	.103	.121	-.011
POA TO CENTROID in.	:	.182	.355	.257
MIN RADIUS	:	.166	.189	.275
MEAN RADIUS	:	.903	.805	.740
MAX RADIUS	:	1.665	1.217	1.052
HORIZONTAL SPREAD	:	2.459	1.538	1.538
VERTICAL SPREAD	:	1.915	1.915	1.662
EXTREME SPREAD	:	2.746	2.214	1.894
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

24 May 1989

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CENTERFIRE PATTERNS # 5



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 5

3 in = 9

HS = 2.499

VS = 2.470

GS = 2.868

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.101	.883	.942
MINIMUM X	:	-1.398	-1.276	-1.218
MAXIMUM Y	:	1.073	.942	.758
MINIMUM Y	:	-1.397	-1.528	-1.799
CENTROID X	:	.512	.390	.331
CENTROID Y	:	-.133	-.002	.190
FOR TO CENTROID in.	:	.530	.390	.382
MIN RADIUS	:	.104	.146	.299
MEAN RADIUS	:	.991	.901	.790
MAX RADIUS	:	1.616	1.599	1.289
HORIZONTAL SPREAD	:	2.499	2.159	2.159
VERTICAL SPREAD	:	2.470	2.470	1.550
EXTREME SPREAD	:	2.868	2.671	2.189
NUMBER IN ONE INCH CIRCLE =			1	
NUMBER IN TWO INCH CIRCLE =			5	
NUMBER IN THREE INCH CIRCLE =			9	