

C6225412

MODEL 700™ M24

Model **SWS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

M2400060337

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

Sweed®

No. 2-152-51

02/07/08 16:18:28

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: RE00141238

Serial: C6225412 Model M24 SWS Center Fire
Caliber: 7.62 NATO Produced: 03/21/1989

Repairman:

Verify Repair

Status:

Closed 2/5/2008 6:28:37 AM

Address Information

Customer:

☒ Received From

Return To:

☐ Received From

Name: 1 SF

1 SF

Address 1: DEPARTMENT OF THE ARMY

DEPARTMENT OF THE ARMY

Address 2: BOX 339500 MS 78

PO Box:

BOX 339500 MS 78

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: NN

Fax:

Email:

Comments:

Received Condition

Fair

Condition
Notes:CSR
Notes:

Accessories Received

Code	Desc	Qty
A007	With Stud	3
A057	Frt and Rear Sgt Base	1

Repair Search

Refresh

Close

nagletj

2/7/2008

4:18 PM

CAPS

NUM

INS

SCRL

start

11 PM

My ...

Ar...

2 A...

Go...

Ad...

SA...

4:18 PM

Serial Number:

C6225412

Model: M24 SWS



RE00141238

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

2. NOMENCLATURE AND MODEL

3. REGISTRATION/SERIAL/NSN

4a. MILES

b. HOURS

c. ROUNDS
FIREDd. HOT
STARTS

5. DATE

6. TYPE INSPECTION

TECHNICAL INSP

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 material 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

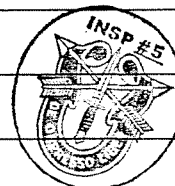
9a. SIGNATURE

(Maintenance Supervisor)

9b. TIME

10. MANHOURS
REQUIREDTM
ITEM
NO.
aSTATUS
bDEFICIENCIES AND SHORTCOMINGS
cCORRECTIVE ACTION
dINITIAL
WHEN
CORRECTED
e

Round count loss

Return to Remington
due to "LOSS" of
Round count1ST SFG (A)
DS/GS ARMS SHOP
FT. LEWIS, WA

DEPARTMENT OF THE ARMY
3RD BATTALION 1ST SPECIAL FORCES GROUP (AIRBORNE)
FORT LEWIS, WASHINGTON 98433

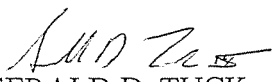
AOSO-SFI-TB

13 December 2007

MEMORANDUM FOR RECORD

SUBJECT: M-24 SWS, turn in for new barrel.

1. SFODA 1311 request M-24 SWS, serial number C6225412 be returned to Remington for new barrel due to existing barrel exceeding 10,000 rounds.


GERALD D. TUCK
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

USAPPC V1.10

M2400060341

**DEPARTMENT OF THE ARMY
3RD BATTALION 1ST SPECIAL FORCES GROUP (AIRBORNE)
FORT LEWIS, WASHINGTON 98433**

AOSO-SFI-TB

13 December 2007

MEMORANDUM FOR RECORD

SUBJECT: M-24 SWS, turn in for new barrel.

1. SFODA 1311 request M-24 SWS, serial number C6348939 be returned to Remington for new barrel due to existing barrel exceeding 10,000 rounds.



GERALD D. TUCK
CPT, SF
Detachment commander

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6225412.___0
FILE DATE AND TIME: 02/26/2008 09:01

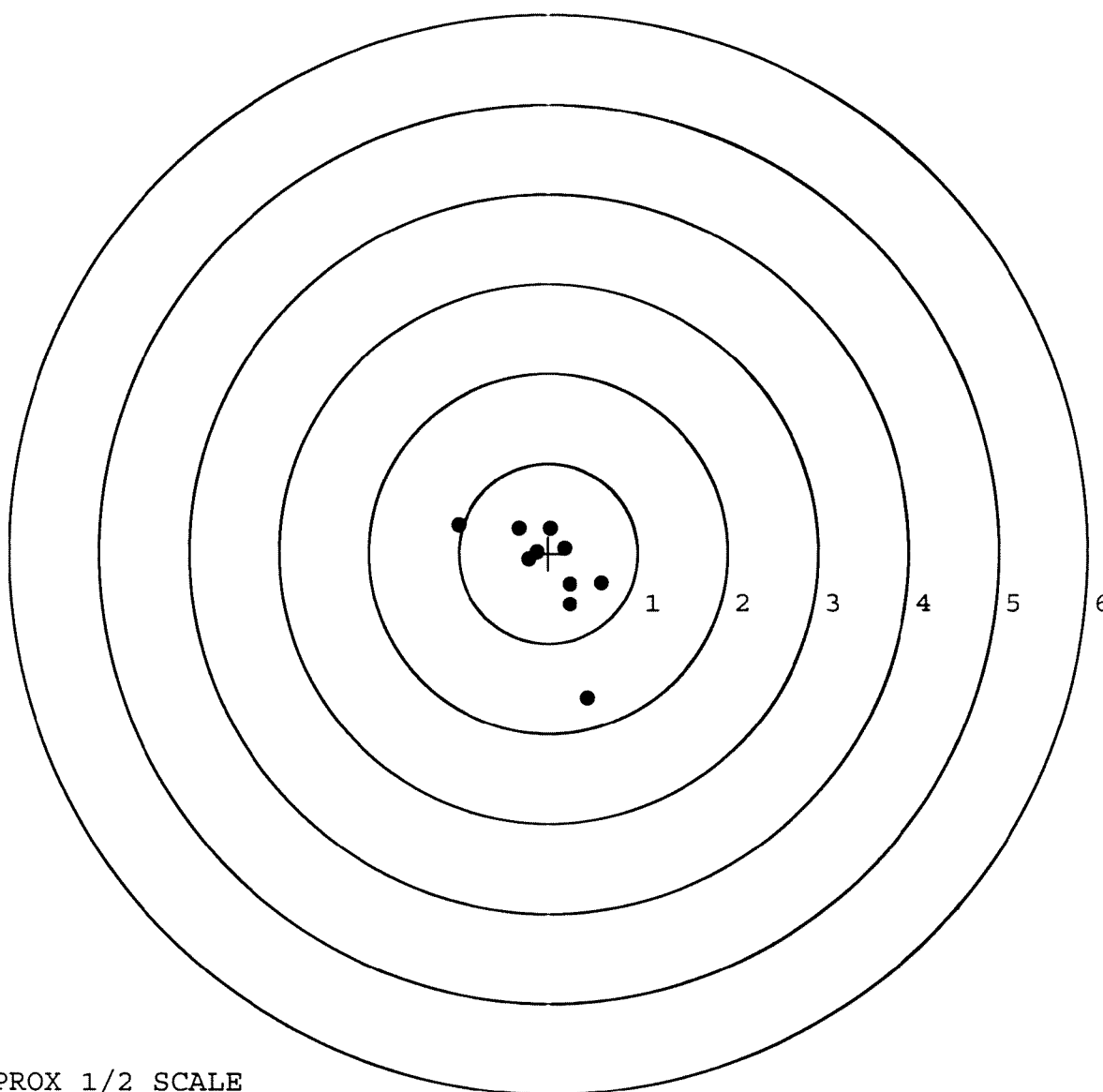
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.022
The Average Y Centroid of the Five Target Set:	-0.047
The Average Point of Impact of the Five Target Set:	0.052
The Average Mean Radius of the Five Target Set:	0.609
The Distance from POA to Centroid Target #1:	0.198
The Distance from Centroid Target #2 to Centroid Target #1:	0.191
The Distance from Centroid Target #3 to Centroid Target #1:	0.186
The Distance from Centroid Target #4 to Centroid Target #1:	0.125
The Distance from Centroid Target #5 to Centroid Target #1:	0.295

SERIAL NUMBER: C6225412.___0
TARGET NUMBER: 1
FILE DATE: 02/26/2008
FILE TIME: 09:01

X CENTROID: 0.004
Y CENTROID: -0.198
POA TO CENTROID: 0.198
HORZ SPREAD: 1.602
VERT SPREAD: 1.919
GROUP SPREAD: 2.403
MIN RADIUS: 0.254
MAX RADIUS: 1.477
MEAN RADIUS: 0.581
IN 1 IN DIAMETER: 6
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.441	-1.609
2:	0.241	-0.570
3:	0.596	-0.331
4:	-1.006	0.310
5:	-0.327	0.278
6:	-0.223	-0.068
7:	0.026	0.276
8:	0.241	-0.343
9:	0.182	0.056
10:	-0.127	0.019

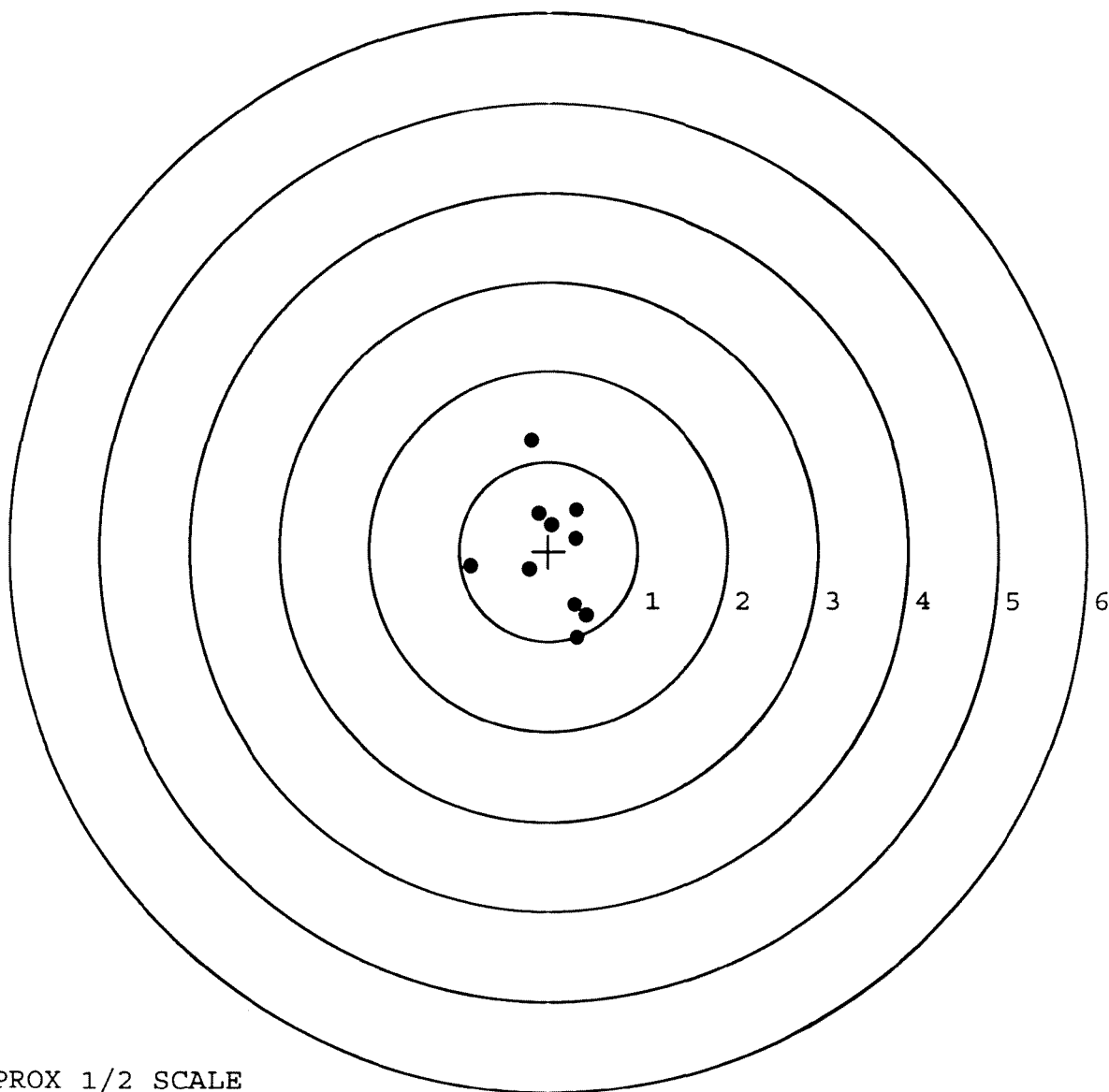


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6225412.___0
TARGET NUMBER: 2
FILE DATE: 02/26/2008
FILE TIME: 09:01

X CENTROID: 0.032
Y CENTROID: -0.009
POA TO CENTROID: 0.033
HORZ SPREAD: 1.304
VERT SPREAD: 2.200
GROUP SPREAD: 2.261
MIN RADIUS: 0.309
MAX RADIUS: 1.267
MEAN RADIUS: 0.659
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.195	1.238
2:	-0.873	-0.170
3:	-0.217	-0.206
4:	0.325	-0.962
5:	0.431	-0.719
6:	0.297	-0.598
7:	0.316	0.463
8:	0.309	0.141
9:	0.038	0.300
10:	-0.112	0.423

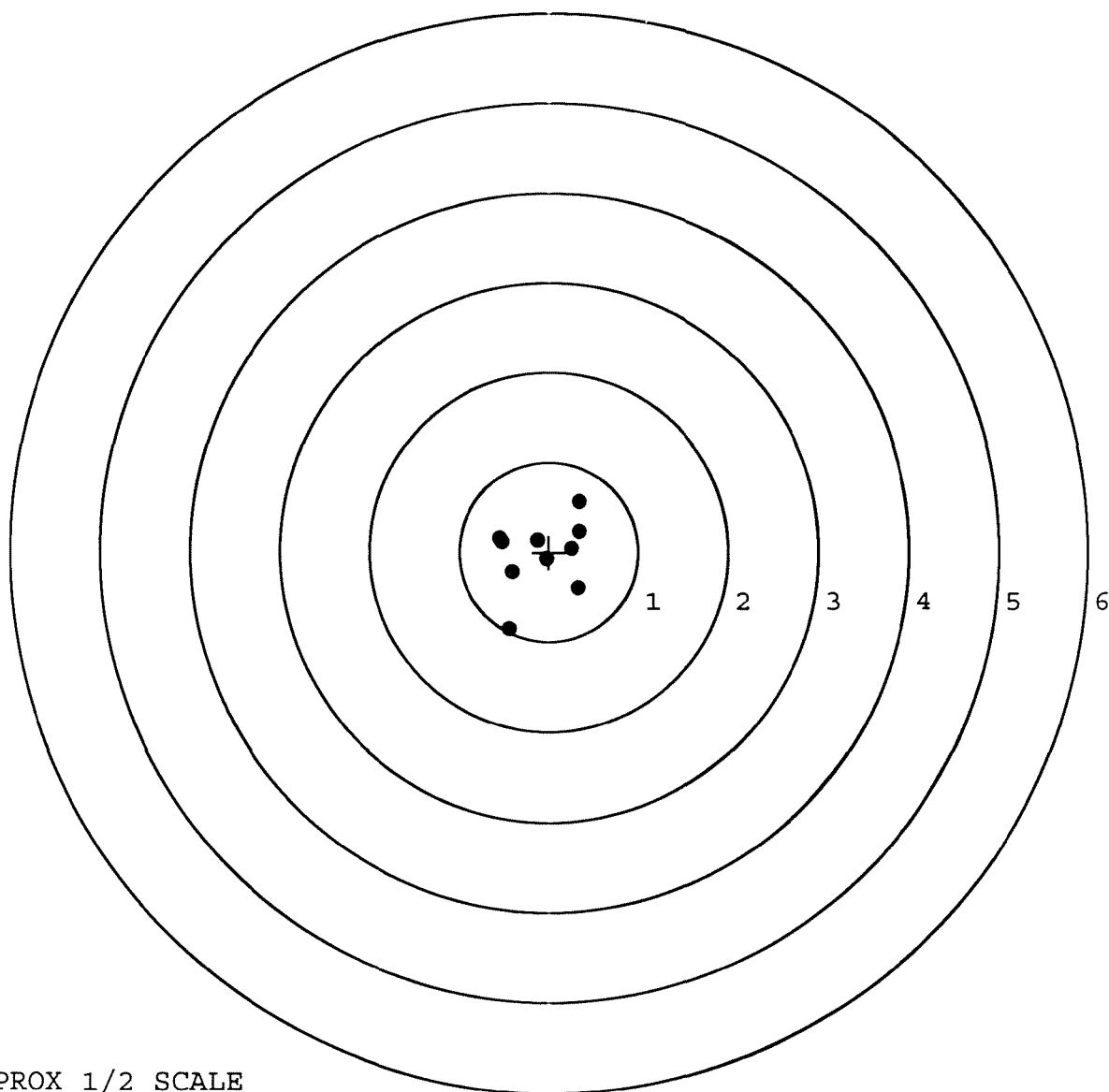


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6225412.___0
TARGET NUMBER: 3
FILE DATE: 02/26/2008
FILE TIME: 09:01

X CENTROID: -0.081
Y CENTROID: -0.032
POA TO CENTROID: 0.087
HORZ SPREAD: 0.893
VERT SPREAD: 1.423
GROUP SPREAD: 1.626
MIN RADIUS: 0.065
MAX RADIUS: 0.905
MEAN RADIUS: 0.463
IN 1 IN DIAMETER: 6
IN 2 IN DIAMETER: 10
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.441	-0.863
2:	0.345	0.560
3:	0.343	0.229
4:	0.332	-0.406
5:	-0.522	0.118
6:	-0.412	-0.226
7:	-0.128	0.139
8:	-0.032	-0.075
9:	0.257	0.041
10:	-0.548	0.159



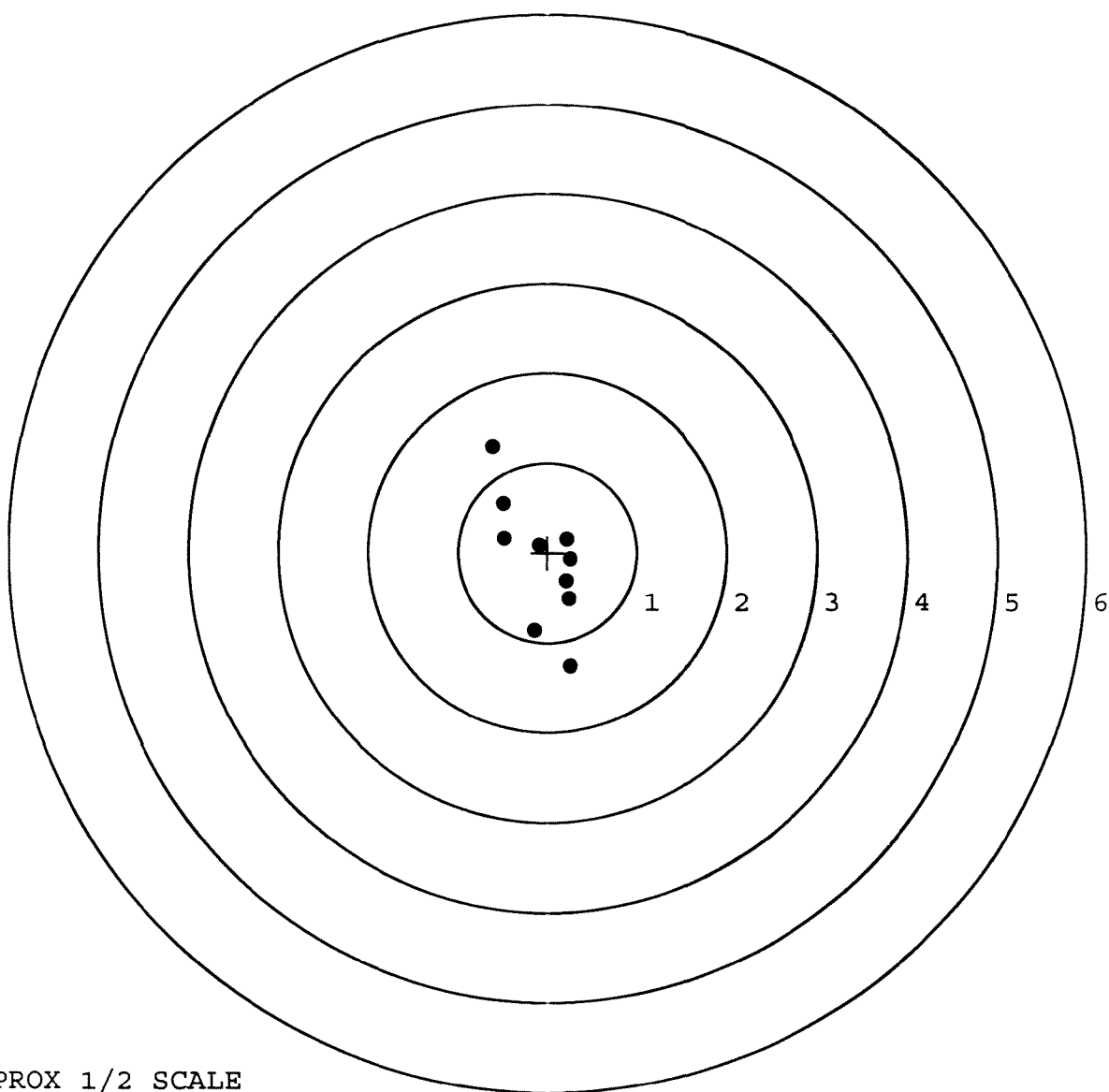
TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6225412. __0
TARGET NUMBER: 4
FILE DATE: 02/26/2008
FILE TIME: 09:01

X CENTROID: -0.065
Y CENTROID: -0.094
POA TO CENTROID: 0.115
HORZ SPREAD: 0.868
VERT SPREAD: 2.439
GROUP SPREAD: 2.589
MIN RADIUS: 0.179
MAX RADIUS: 1.381
MEAN RADIUS: 0.638

IN 1 IN DIAMETER: 5
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.613	1.174
2:	-0.491	0.542
3:	-0.482	0.155
4:	0.254	-1.265
5:	-0.147	-0.872
6:	0.244	-0.514
7:	0.208	-0.318
8:	0.255	-0.078
9:	0.214	0.152
10:	-0.097	0.082

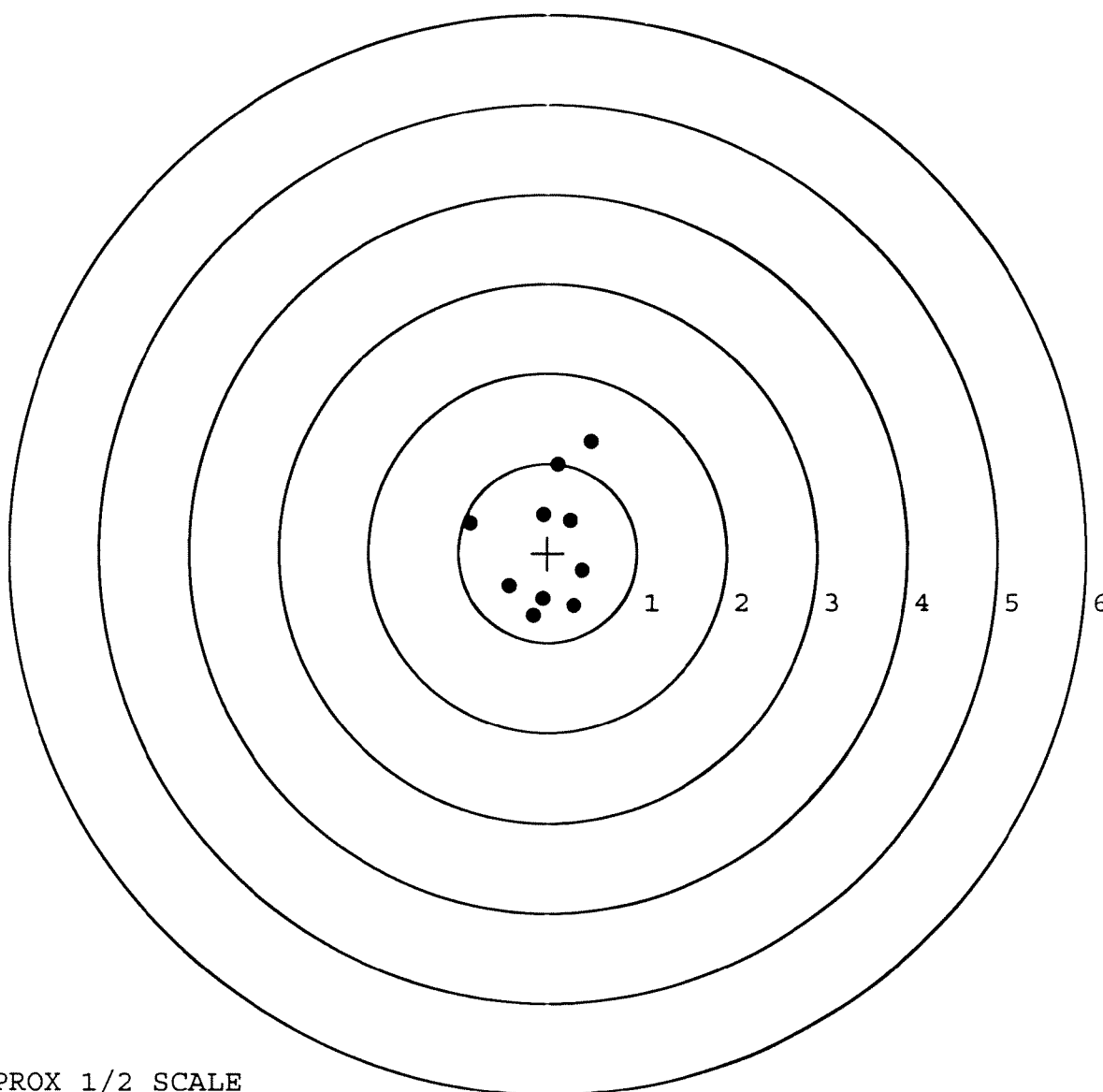


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6225412.___0
TARGET NUMBER: 5
FILE DATE: 02/26/2008
FILE TIME: 09:01

X CENTROID: 0.000
Y CENTROID: 0.097
POA TO CENTROID: 0.097
HORZ SPREAD: 1.357
VERT SPREAD: 1.942
GROUP SPREAD: 2.049
MIN RADIUS: 0.335
MAX RADIUS: 1.245
MEAN RADIUS: 0.705
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.492	1.240
2:	0.116	0.989
3:	-0.048	0.428
4:	0.259	0.361
5:	-0.865	0.330
6:	0.388	-0.200
7:	0.300	-0.591
8:	-0.162	-0.702
9:	-0.430	-0.373
10:	-0.054	-0.513



TARGET APPROX 1/2 SCALE

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

R & E NUMBER		<u>00141238</u>	
SERIAL NUMBER		<u>C6225412</u>	
LOG-IN DATE		<u>2-5-08</u>	
OPERATION #	OPERATION NAME	DATE	INITIAL
500	DIS-ASSEMBLE GUN	2-11-08	L.P.D.
505	RE-BARREL	2-11-08	L.P.D.
560	ASSEMBLE	2-12-08	L.P.D.
600	PROOF	2-12-08	TRW
605	CHECK HEADSPACE	2-12-08	TRW
610	DIS-ASSEMBLE GUN	2-12-08	L.P.D.
612	MAGNAFLUX	2/13/08	mmk
510	DRILL AND TAP	2-12-08	TRW
615	ROLLMARK CALIBER	2-12-08	CW
618	ROTO-BLAST	2-14-08	DG
620	APPLY COATINGS	2-19-08	cm
625	FINAL ASSEMBLY	2-21-08	L.P.D.
640	FUNCTION TEST AND	PASS FAIL 2-21-08	TRW
650	TARGET	PASS FAIL 2-21-08	TRW
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	2-21-08 RP
670	FINAL INSPECTION		
	A) HEADSPACE	PASS FAIL	
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS 287 2.76 285 2.84 290 2-25-08	DA
680	F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX 3.75 3.75 3.5 2-25-08	DA
	G) SAFETY OFF FORCE	2 LBS MAX 2.0 2.0 2.0 2-25-08	DA
	I) FIRING PIN INDENT	.020 .020 .020 .020 2-25-08	DA
690	PACK	2-25-08	DA

C 634 8939

Front + Rear Base

STUD

C 6225412

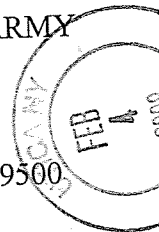
DEPARTMENT OF THE ARMY

ISF

BOX 339500 MS 78

FORT LEWIS WA 98433-9500

OFFICIAL BUSINESS



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: **RE00052615** Serial: C6225412 Model 700 Center Fire Caliber 7.62 NATO M-24 (SWS) Repairman: Status: Closed: 9/19/02 2:47:57 PM

Verify Repair

Address Information

Customer: Received From: Return To: Received From:

Name: A CO A CO

Address 1: 3/1 SFG (A) 3/1 SFG (A)

Address 2: PO Box: PO Box:

City: FORT BRAGG FORT BRAGG

State: NC Zip Code: 28310 Country: US State: NC Zip Code: 28310 Country: US

FFL: ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐

Contact / Condition Problems Estimate History / Status Shipping / Billing

Contact Information: Phone: Fax: Email: Comments:

Received Condition: Poor Condition Notes: CSR Notes:

Accessories Received:

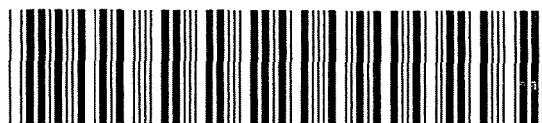
Code	Desc	Qt
A007	With Stud	1
X	FRT & REAR SGT BA	1

Repair Search Refresh Close

maglet 9/19/02 3:24 PM CAPS NUM INS SCFL

Start L A P U S S B S N G R S 3:24 PM

Serial Number: **C6225412**
Model: **700**



RE00052615

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6225412.___0

FILE DATE AND TIME: 10/09/2002 14:04

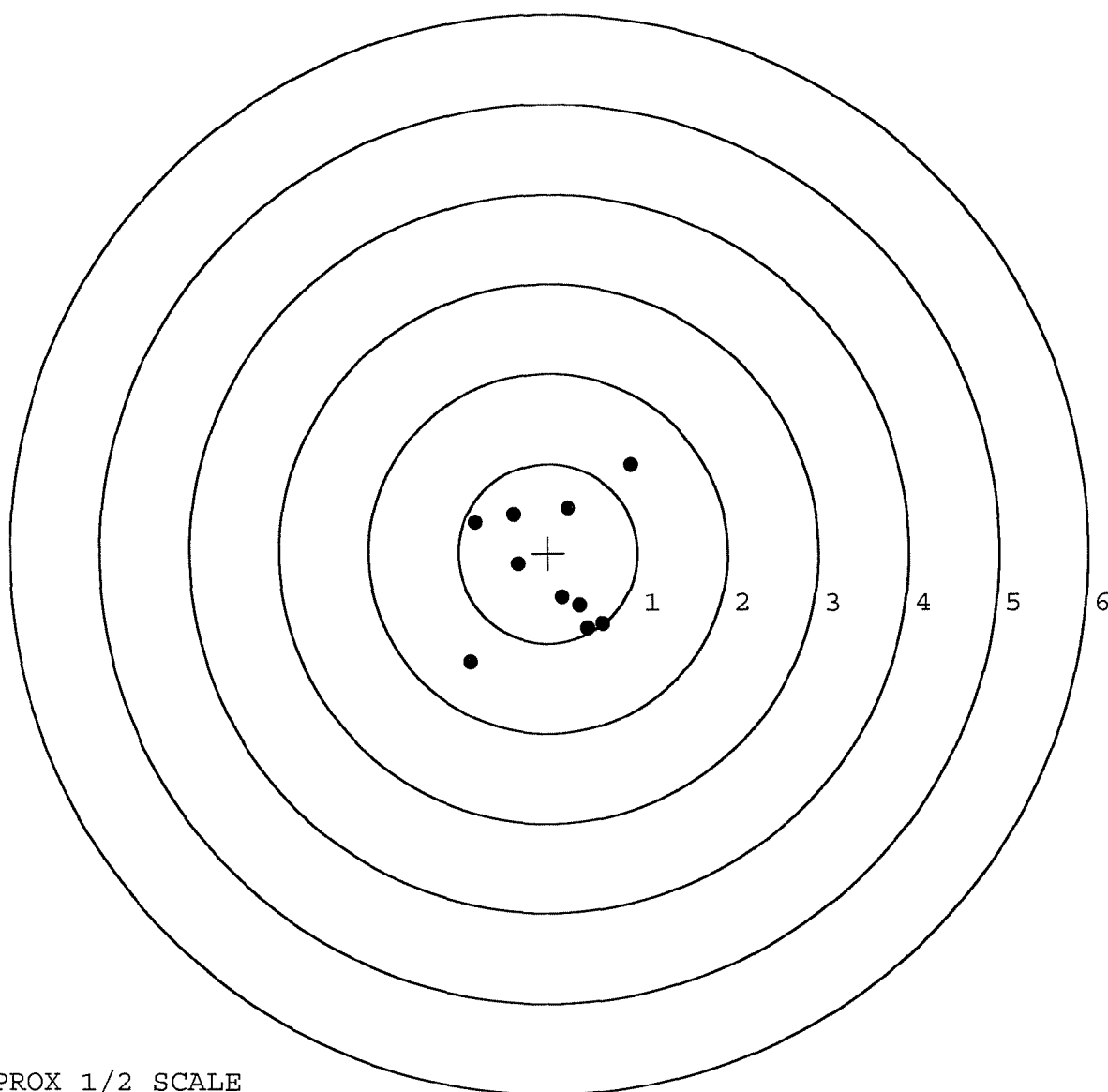
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.067
The Average Y Centroid of the Five Target Set:	-0.088
The Average Point of Impact of the Five Target Set:	0.110
The Average Mean Radius of the Five Target Set:	0.597
The Distance from POA to Centroid Target #1:	0.186
The Distance from Centroid Target #2 to Centroid Target #1:	0.202
The Distance from Centroid Target #3 to Centroid Target #1:	0.086
The Distance from Centroid Target #4 to Centroid Target #1:	0.347
The Distance from Centroid Target #5 to Centroid Target #1:	0.094

SERIAL NUMBER: C6225412.___0
TARGET NUMBER: 1
FILE DATE: 10/09/2002
FILE TIME: 14:04

X CENTROID: 0.034
Y CENTROID: -0.183
POA TO CENTROID: 0.186
HORZ SPREAD: 1.785
VERT SPREAD: 2.207
GROUP SPREAD: 2.838
MIN RADIUS: 0.338
MAX RADIUS: 1.470
MEAN RADIUS: 0.813
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.862	-1.219
2:	-0.810	0.335
3:	-0.337	-0.130
4:	-0.386	0.423
5:	0.221	0.494
6:	0.923	0.988
7:	0.618	-0.793
8:	0.448	-0.840
9:	0.362	-0.593
10:	0.163	-0.496

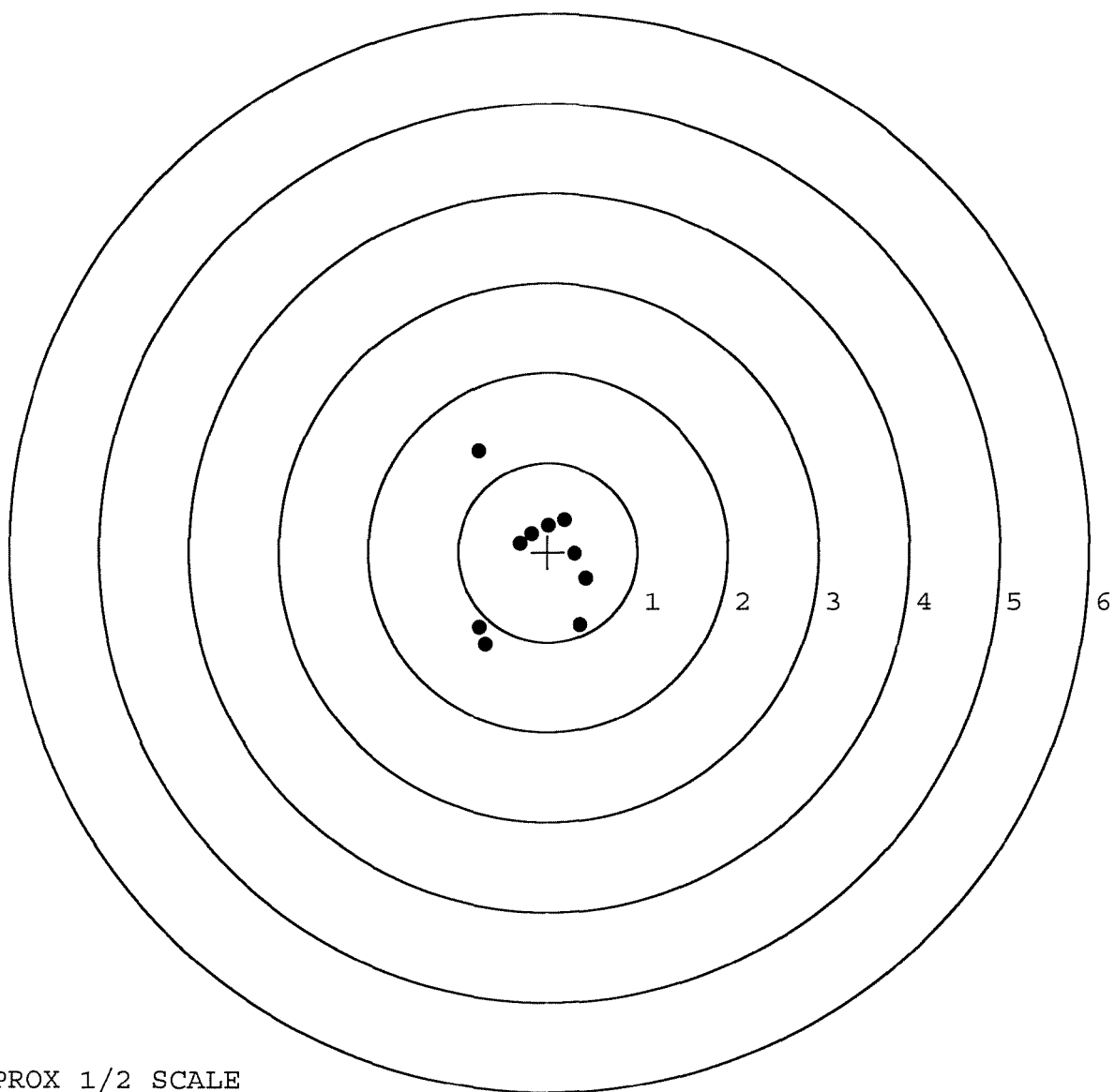


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6225412.___0
TARGET NUMBER: 2
FILE DATE: 10/09/2002
FILE TIME: 14:04

X CENTROID: -0.145
Y CENTROID: -0.091
POA TO CENTROID: 0.171
HORZ SPREAD: 1.198
VERT SPREAD: 2.165
GROUP SPREAD: 2.251
MIN RADIUS: 0.254
MAX RADIUS: 1.374
MEAN RADIUS: 0.689
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.365	-0.810
2:	-0.687	-1.032
3:	-0.763	-0.841
4:	0.427	-0.287
5:	0.305	-0.022
6:	0.184	0.354
7:	-0.006	0.294
8:	-0.191	0.206
9:	-0.315	0.098
10:	-0.771	1.133



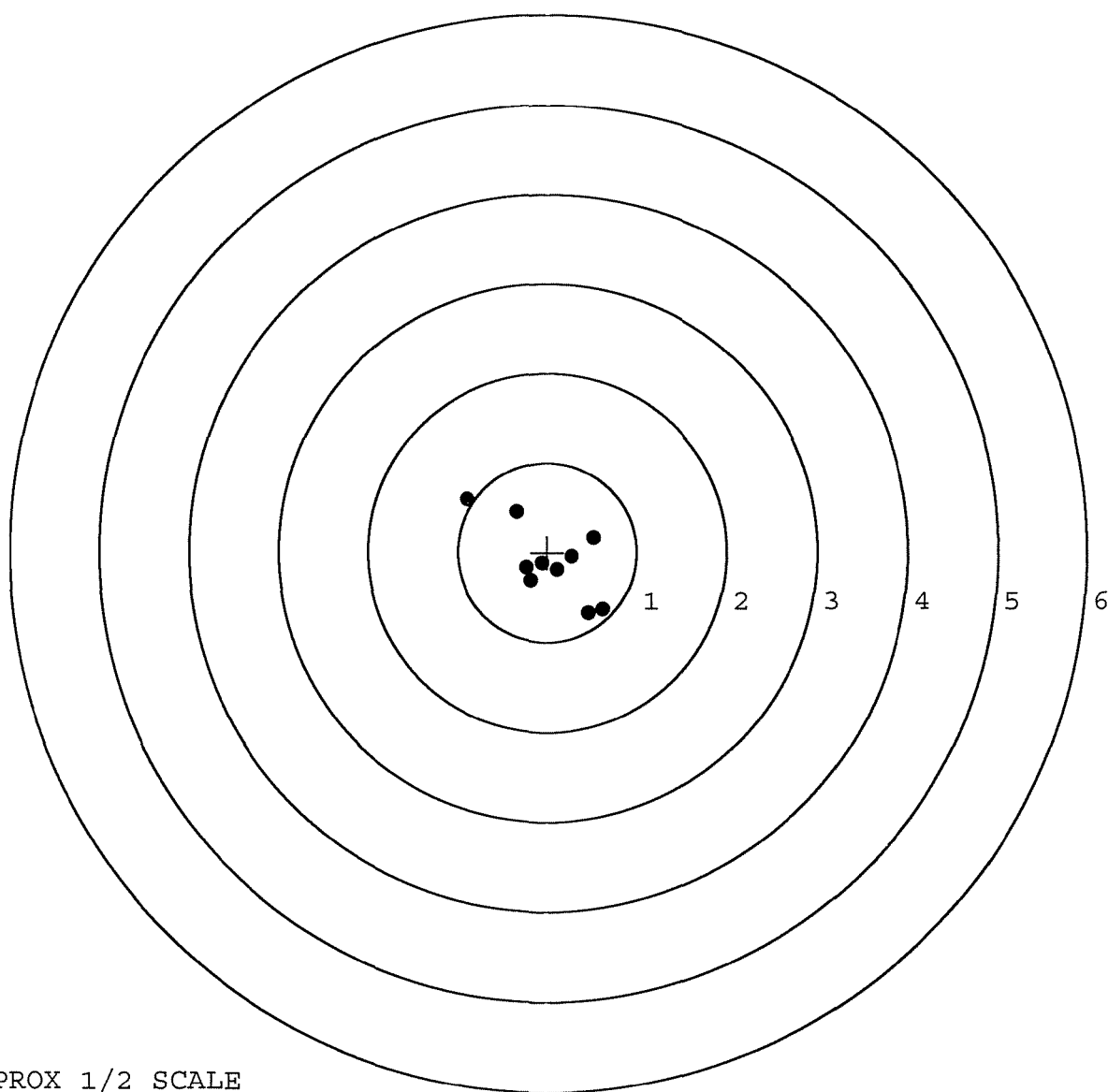
TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6225412.___0
TARGET NUMBER: 3
FILE DATE: 10/09/2002
FILE TIME: 14:04

X CENTROID: 0.027
Y CENTROID: -0.098
POA TO CENTROID: 0.102
HORZ SPREAD: 1.526
VERT SPREAD: 1.273
GROUP SPREAD: 1.961
MIN RADIUS: 0.096
MAX RADIUS: 1.151
MEAN RADIUS: 0.497

IN 1 IN DIAMETER: 5
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.628	-0.643
2:	0.467	-0.685
3:	0.522	0.165
4:	-0.344	0.447
5:	-0.898	0.588
6:	0.276	-0.049
7:	0.110	-0.194
8:	-0.066	-0.122
9:	-0.239	-0.170
10:	-0.188	-0.316

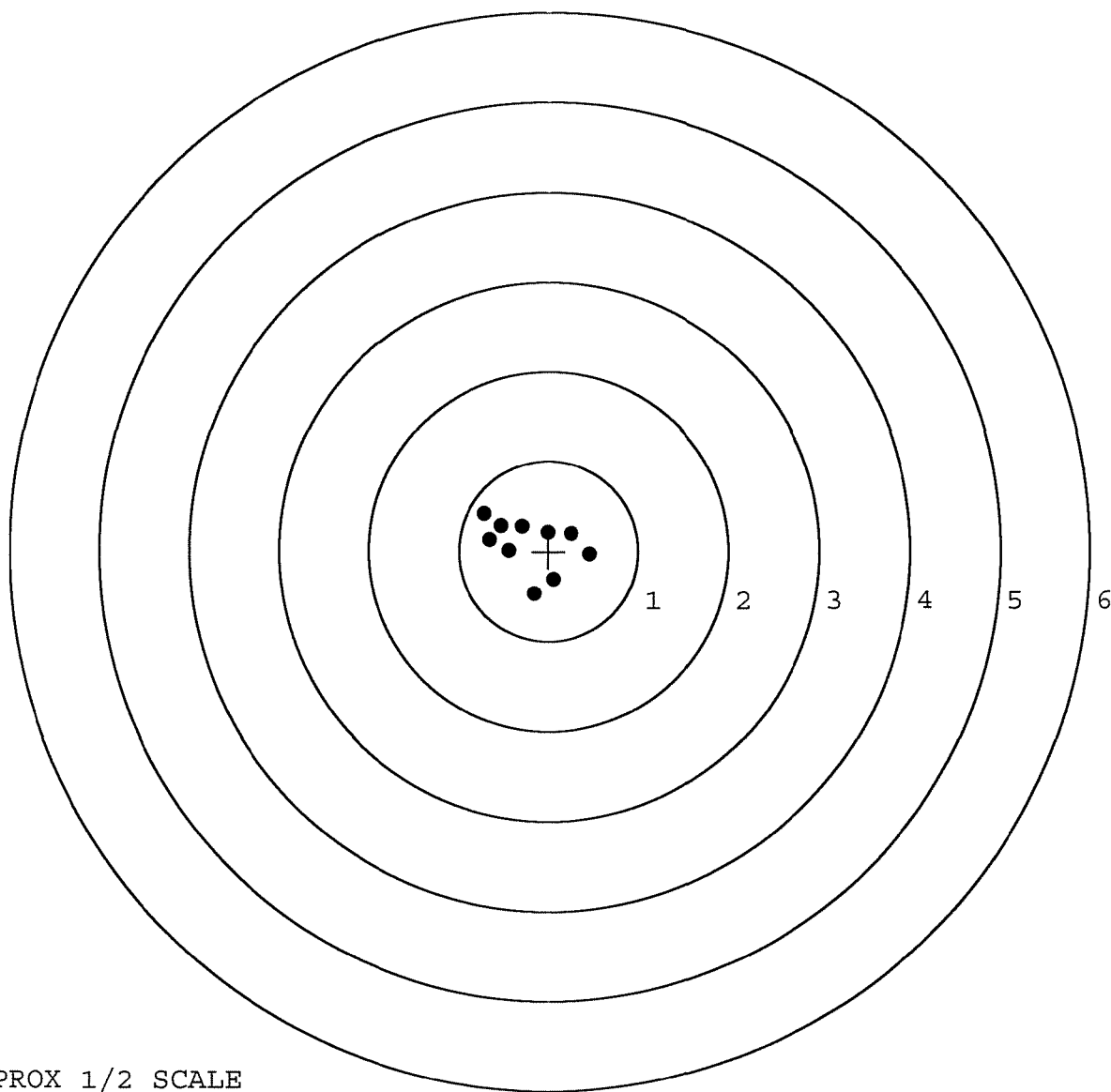


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6225412. __0
TARGET NUMBER: 4
FILE DATE: 10/09/2002
FILE TIME: 14:04

X CENTROID: -0.203
Y CENTROID: 0.070
POA TO CENTROID: 0.215
HORZ SPREAD: 1.180
VERT SPREAD: 0.894
GROUP SPREAD: 1.265
MIN RADIUS: 0.229
MAX RADIUS: 0.677
MEAN RADIUS: 0.435
IN 1 IN DIAMETER: 7
IN 2 IN DIAMETER: 10
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.166	-0.476
2:	0.056	-0.317
3:	-0.715	0.418
4:	-0.529	0.286
5:	-0.654	0.128
6:	-0.441	0.007
7:	-0.294	0.280
8:	-0.009	0.211
9:	0.256	0.198
10:	0.465	-0.038



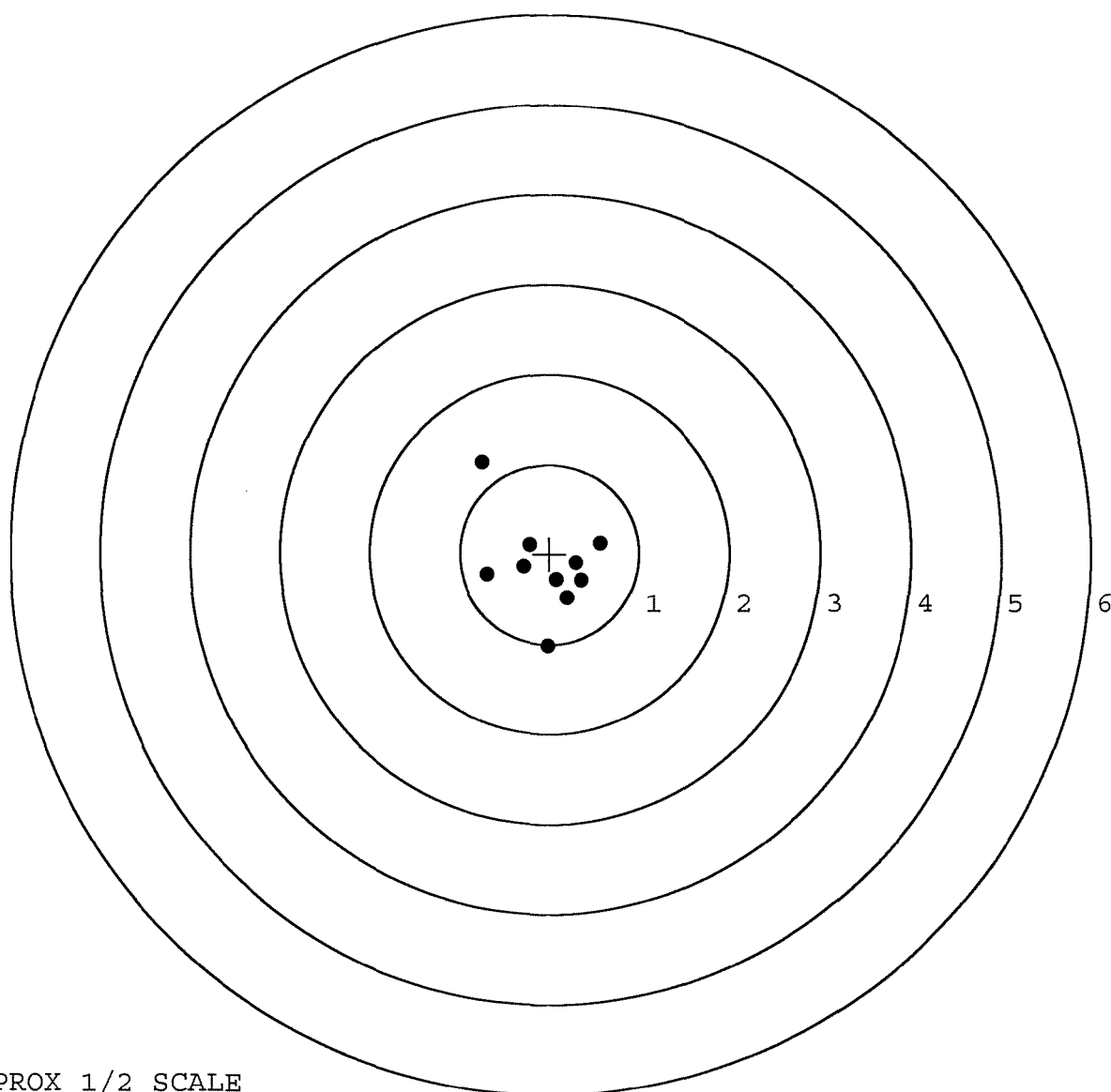
TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6225412.___0
TARGET NUMBER: 5
FILE DATE: 10/09/2002
FILE TIME: 14:04

X CENTROID: -0.048
Y CENTROID: -0.136
POA TO CENTROID: 0.144
HORZ SPREAD: 1.320
VERT SPREAD: 2.051
GROUP SPREAD: 2.177
MIN RADIUS: 0.199
MAX RADIUS: 1.357
MEAN RADIUS: 0.553

IN 1 IN DIAMETER: 6
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.018	-1.025
2:	-0.699	-0.235
3:	-0.748	1.026
4:	0.572	0.114
5:	-0.221	0.098
6:	-0.293	-0.153
7:	0.075	-0.293
8:	0.201	-0.493
9:	0.358	-0.295
10:	0.296	-0.104



TARGET APPROX 1/2 SCALE

Final Inspection

In: 0225412

DATE REC'D: 9/19/02

DATE RET'D: 10/11/02

EDITOR: RL

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 INSPECTION CHECKLIST
CONTRACT #: DAAE-20-97-C-242

R & E NUMBER	52615		
SERIAL NUMBER	C6225412		
LOG-IN DATE	9/19/02		
INSPECT AND VERIFY:			
OPERATION #	OPERATION NAME	DATE	INITIAL
550	DIS-ASSEMBLE GUN	9/23/02	RL
560 A	RE-BARREL	9/23/02	RL
B	DRILL AND TAP	9-23-02	RL
575	ASSEMBLE	9/24/02	RL
600	PROOF	9-25-02	AC
605	CHECK HEADSPACE	9-25-02	AC
610	DIS-ASSEMBLE GUN	9/24/02	RL
612	MAGNAFLUX	RL	
615	ROLLMARK CALIBER	9/27/02	RL
618	ROTO-BLAST	9/30/02	AC
620	APPLY COATINGS	10-5	TA
625 A	FINAL ASSEMBLY	10/8/02	RL
B	TRIGGER PULL TEST		
C	SAFETY "ON" FORCE		
D	SAFETY "OFF" FORCE		
E	FIRING PIN INDENT		
640	TARGET	10-8-02	AC
655	FINAL INSPECT	10/11/02	RL
660	PACK	10-15-02	RA
		SHIP DATE	
	QAR INSPECTION DATE		

Remington®



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

MODEL 700™ M24

SERIAL NO.
C6225412

ORDER NO.
5716

Ø1

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



5716 C6225412

UPC



0 47700 25716 7

M-24

SCOPE 0039

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6225412

OP. #	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and Stock	1 25	89	RW
600	Proof	1 25	89	RW
607	Check Headspace	1 25	89	RW
610	Dis-assemble Gun	1 25	89	RW
612	Magnaflux Barrel Action		1-27-89	AK.
	Magnaflux Bolt		1-27-89	KCR
615	Rollmark Caliber		1/30	G.S.
617	Drill and Tap Sight Holes	2 1	89	FB
618	Polish Barrel	2 1	89	BT
620	Apply Coatings (Barrel Action)		2-10-89	TSA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		2/23/89	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		2/23/89	RW
	C) Inspect Ejector Hole for Chamfer		2/23/89	RW
	D) Oil Firing Pin Ass'y		2/23/89	RW
	E) Adjust Trigger Pull to Min Setting and Stake		2/23/89	JS

op. #	OP. NAME	READINGS			DATE	INITIAL
625 cont.	F) Safety On Force	4	5	5	27 Feb 89	JS
	G) Safety Off Force	3	3	3	27 Feb 89	JS
	H) Trigger Pull Test & Retainability				27 Feb 89	JS
	I) Firing Pin Indent	0205	0205	0205	27 Feb 89	JS
	J) Assemble Stock				3/1/89	RW
	K) Assemble Swivel Studs				7 Mar 89	JS
	L) Attach Front and Rear Sight Assemblies				3/1/89	RW
	M) Iron Sight Alignment				3/1/89	RW
	N) Detach Front & Rear Sights & place in numbered container				3/1/89	RW
	O) Attach Scope to Rifle				3/3/89	RW
	P) Detach & Attach Scope 20 Times				3/3/89	WB
640	Gallery Target & Test	50 R	108 L		3/6/89	DH
	A) Time				3/6/89	DH
	B) Malfunctions				3/6/89	DH
	C) Pierced Primers				3/6/89	DH
	D) Optical Clarity of Scope				3/6/89	DH
645	Inspect for Live Ammo				3/6/89	DH
655	Final Inspection					
	A) Headspace				7 Mar 89	JS
	B) Trigger Pull	2.37	2.63	2.62	7 Mar 89	JS
	C) Function				7 Mar 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. C6225412

DATE 3-29-90

TESTER J. 21

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.55	2.45		2.43	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.49	2.46		2.39	
PULL #3	2.49	2.52		2.40	
PULL #4	2.46	2.53		2.40	
PULL #5	2.47	2.42		2.35	
TOTAL	12.46	12.38		11.97	
AVG.	2.492	2.476		2.394	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.48	3.60		
PULL #2	3.54	3.56		
PULL #3	3.50	3.53		
PULL #4	3.61	3.50		
PULL #5	3.55	3.55		
TOTAL	17.58	17.74		
AVG.	3.516	3.548		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.31	4.21		
PULL #2	4.26	4.20		
PULL #3	4.27	4.28		
PULL #4	4.18	4.19		
PULL #5	4.16	4.17		
TOTAL	21.18	21.05		
AVG.	4.236	4.21		

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06225412
8 Mar 1989

CENTROIDAL DISTANCES

0 TO	1	.0895545
1 TO	2	.14654
1 TO	3	.300323
1 TO	4	.304401
1 TO	5	.151822

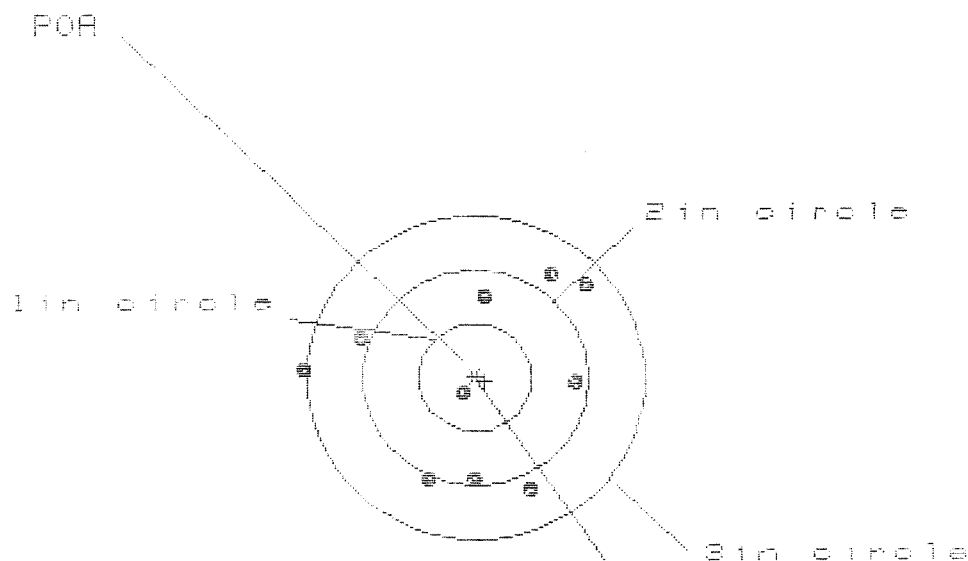
$\frac{53}{21}$ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0114
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1118
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .11238
THE AMR FOR THIS RIFLE IS: .9674

8 Mar 1989

FILE:/PATTERNING/CENTERFIRE_PATT/06225412

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1in = 1

2in = 4

3in = 5

HE= 2.538

VS= 1.920

GS= 2.653

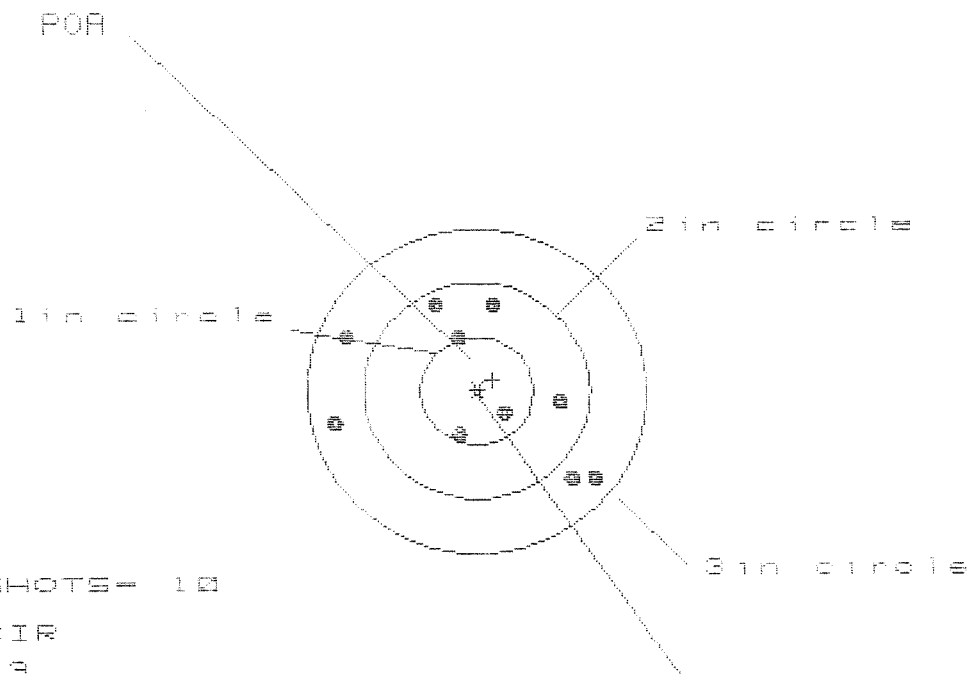
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.027	.859	.780
MINIMUM X	-1.511	-1.181	-1.074
MAXIMUM Y	.914	.921	1.027
MINIMUM Y	-1.006	-.999	-.893
CENTROID X	-.082	.086	-.021
CENTROID Y	.036	.029	-.077
POA TO CENTROID in.	.089	.091	.080
MIN RADIUS	.180	.331	.210
MEAN RADIUS	.989	.926	.874
MAX RADIUS	1.513	1.252	1.193
HORIZONTAL SPREAD	2.538	2.040	1.854
VERTICAL SPREAD	1.920	1.920	1.920
EXTREME SPREAD	2.653	2.260	2.116
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =		4	
NUMBER IN THREE INCH CIRCLE =			9

8 Mar 1988

FILE:/PATTERNING/CENTERFIRE_PATT/08225412

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1 in = 3

2 in = 6

3 in = 10

HS= 2.348

VS= 1.659

GS= 2.630

CENTROID *

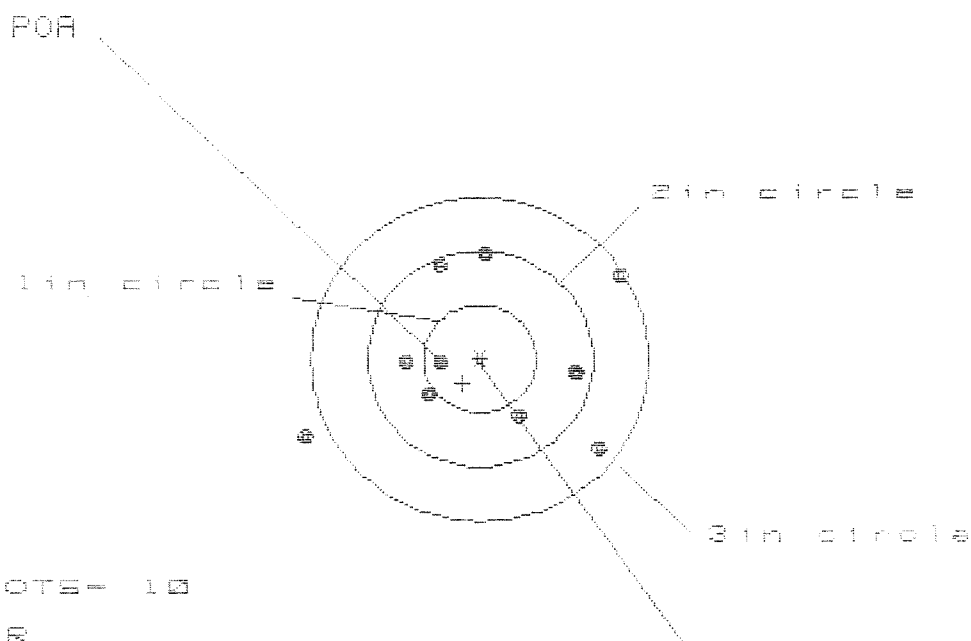
PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.062	.987	.840
MINIMUM X	:	-1.286	-1.168	-1.198
MAXIMUM Y	:	.813	.719	.673
MINIMUM Y	:	-.846	-.860	-.906
CENTROID X	:	-.139	-.257	-.110
CENTROID Y	:	-.099	-.005	.041
POA TO CENTROID in.	:	.170	.257	.118
MIN RADIUS	:	.334	.362	.364
MEAN RADIUS	:	.883	.826	.757
MAX RADIUS	:	1.358	1.309	1.265
HORIZONTAL SPREAD	:	2.348	2.155	2.039
VERTICAL SPREAD	:	1.659	1.579	1.579
EXTREME SPREAD	:	2.630	2.424	2.424
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	

8 Mar 1989

FILE:/PATTERNING/CENTERFIRE_PATT/06225412

CENTERFIRE PATTERNS

3



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 7

3 in = 9

HS= 2.767

VS= 1.786

GS= 3.124

CENTROID *

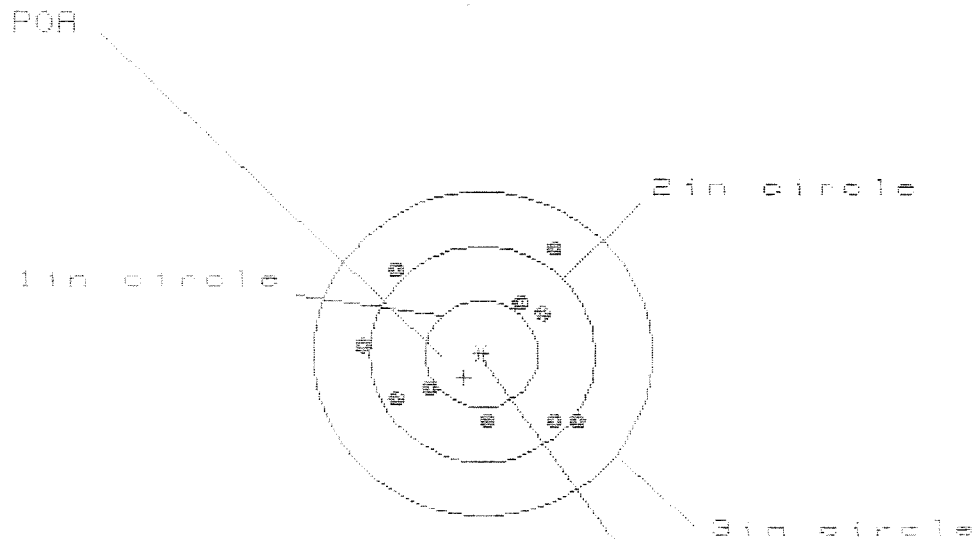
PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.234	1.063	.988
MINIMUM X	:	-1.533	-.839	-.786
MAXIMUM Y	:	.971	.891	.973
MINIMUM Y	:	-.815	-.895	-.813
CENTROID X	:	.153	.324	.191
CENTROID Y	:	.223	.303	.221
POA TO CENTROID in.	:	.271	.443	.292
MIN RADIUS	:	.335	.515	.372
MEAN RADIUS	:	.935	.861	.782
MAX RADIUS	:	1.692	1.249	1.280
HORIZONTAL SPREAD	:	2.767	1.902	1.694
VERTICAL SPREAD	:	1.786	1.786	1.786
EXTREME SPREAD	:	3.124	2.172	2.172
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

8 Mar 1989

FILE:/PATTERNING/CENTERFIRE_PATT/08225412

CENTERFIRE PATTERNS

4



OF SHOTS- 10

IN CIR

1 in = 0

2 in = 6

3 in = 10

HS= 1.954

VS= 1.612

GS= 2.094

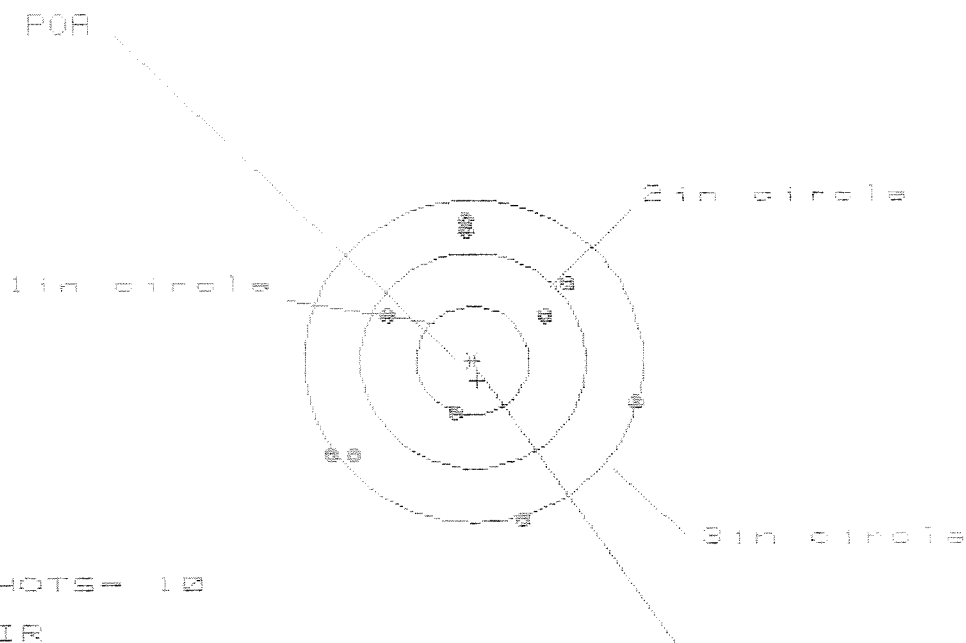
CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.877	.946	.820
MINIMUM X	:	-1.077	-1.008	-.835
MAXIMUM Y	:	.963	.844	.867
MINIMUM Y	:	-.649	-.542	-.519
CENTROID X	:	.162	.093	.219
CENTROID Y	:	.218	.111	.088
POA TO CENTROID in.	:	.271	.144	.236
MIN RADIUS	:	.563	.475	.522
MEAN RADIUS	:	.860	.816	.791
MAX RADIUS	:	1.146	1.080	1.180
HORIZONTAL SPREAD	:	1.954	1.954	1.655
VERTICAL SPREAD	:	1.612	1.386	1.386
EXTREME SPREAD	:	2.094	2.094	2.094
NUMBER IN ONE INCH CIRCLE	=		8	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	

8 Mar 1989

FILE:/PATTERNING/CENTERFIRE_PATT/06225412

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in = 0

2 in = 3

3 in = 8

HS= 2.687

VS= 2.818

GS= 2.861

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.471	1.515	1.186
MINIMUM X	:	-1.216	-1.172	-.982
MAXIMUM Y	:	1.328	1.162	1.097
MINIMUM Y	:	-1.490	-1.052	-1.117
CENTROID X	:	-.037	-.082	-.272
CENTROID Y	:	.181	.347	.412
POA TO CENTROID in.	:	.185	.357	.494
MIN RADIUS	:	.517	.664	.589
MEAN RADIUS	:	1.170	1.112	1.037
MAX RADIUS	:	1.544	1.603	1.453
HORIZONTAL SPREAD	:	2.687	2.687	2.088
VERTICAL SPREAD	:	2.818	2.214	2.214
EXTREME SPREAD	:	2.861	2.730	2.626
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		8	

M-24

New Barrel

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6225412

OP. #	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and Stock		3/20/96	RW
600	Proof		3/20/96	RW
607	Check Headspace		3/20/96	RW
610	Dis-assemble Gun		3/20/96	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		4/2/96	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		4/2/96	RW
	C) Inspect Ejector Hole for Chamfer		4/2/96	RW
	D) Oil Firing Pin Ass'y		4/2/96	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		4/3/96	AR
	A) Time			
	B) Malfunctions			
	C) Pierced Primers			
	D) Optical Clarity of Scope			
645	Inspect for Live Ammo		4/3/96	AC
655	Final Inspection		4/4/96	RW
	A) Headspace			
	B) Trigger Pull			
	C) Function		4/4/96	RW
660	Pack			

Final Inspection

Sn: C6225412

DATE REC'D: 2/26/96

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

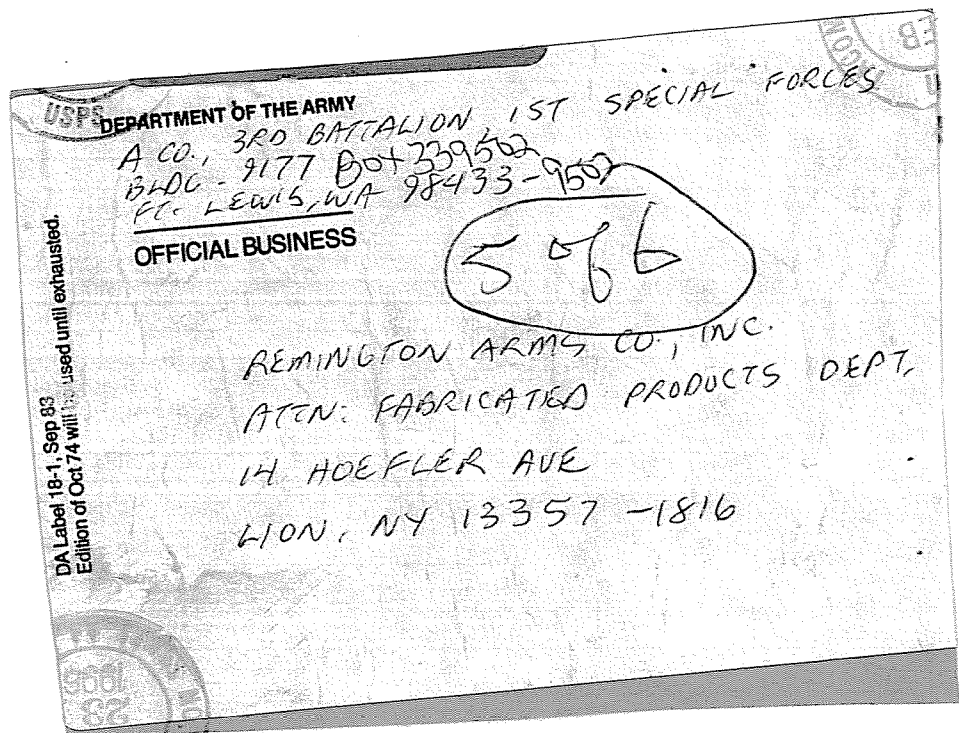
Systems Case

☐ Scope Case☐ IRON SIGHTS☐ Deployment Kit

Trigger

☒ SAFETY OPERATION☒ SET

Comments:



CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6225412
5 Feb 1900

CENTROIDAL DISTANCES

0 TO 1	.984921
1 TO 2	.436029
1 TO 3	.431376
1 TO 4	.778257
1 TO 5	.486129

1
5
+ 4 -----POA

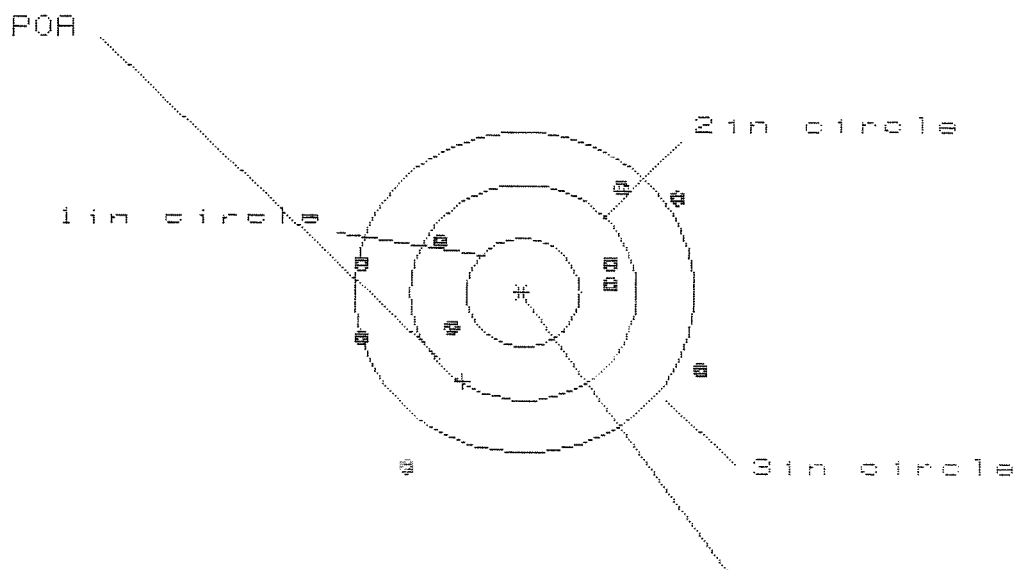
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .5104
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .4002
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .650445
THE AMP FOR THIS RIFLE IS: 1.191

5 Feb 1968

FILE:/PATTERNING/CENTERFIRE_PATT/06225412

CENTERFIRE PATTERNS

1



OF SHOTS- 10

IN CIR

1 in = 0

2 in = 4

3 in = 6

HS= 3.012

VS= 2.637

GS= 3.423

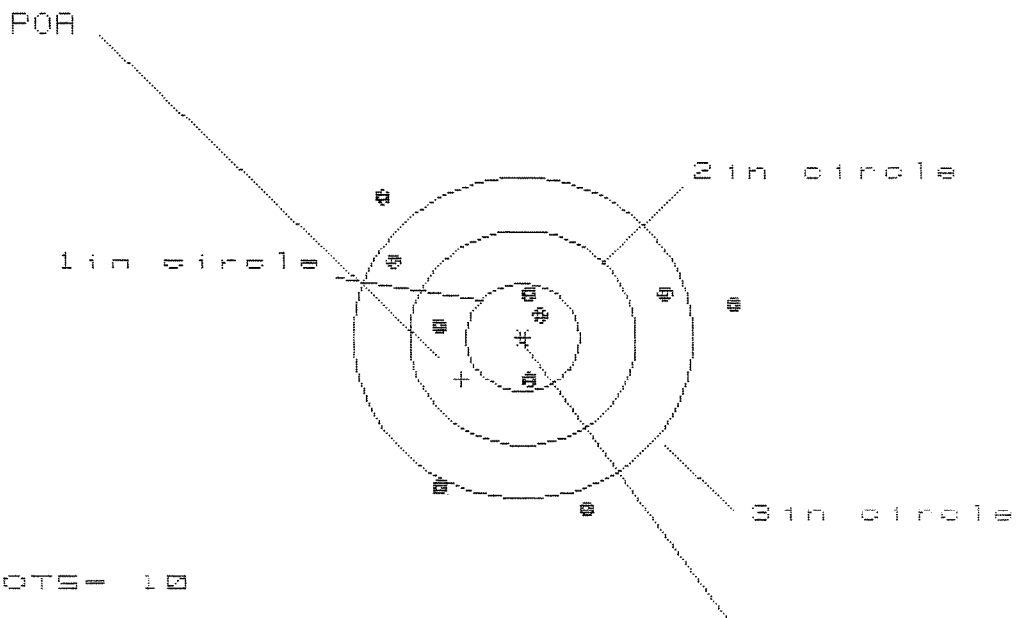
CENTROID *

PATTERN #	:	1	2	3
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.554	1.442	1.389
MINIMUM X	:	-1.458	-1.570	-1.389
MAXIMUM Y	:	.998	.816	.704
MINIMUM Y	:	-1.639	-.897	-.673
CENTROID X	:	.538	.650	.469
CENTROID Y	:	.825	1.007	1.119
POA TO CENTROID in.	:	.985	1.199	1.214
MIN RADIUS	:	.716	.622	.683
MEAN RADIUS	:	1.272	1.173	1.103
MAX RADIUS	:	1.922	1.699	1.543
HORIZONTAL SPREAD	:	3.012	3.012	2.778
VERTICAL SPREAD	:	2.637	1.713	1.377
EXTREME SPREAD	:	3.423	3.166	3.047
NUMBER IN ONE INCH CIRCLE	=	0		
NUMBER IN TWO INCH CIRCLE	=	4		
NUMBER IN THREE INCH CIRCLE	=	6		

5 Feb 1968

FILE:/PATTERNING/CENTERFIRE_PATT/C6225412

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 3

2in = 4

3in = 6

HS= 3.034

VS= 2.944

GS= 3.423

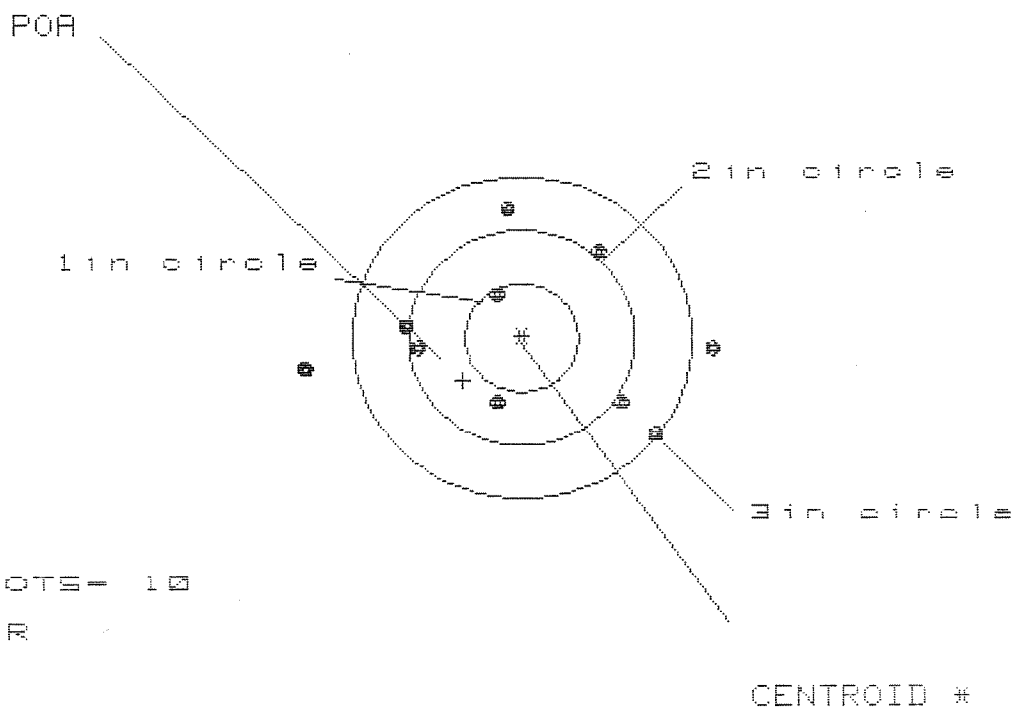
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.828	1.453	1.327
MINIMUM X	:	-1.206	-1.003	-1.099
MAXIMUM Y	:	1.360	1.393	.883
MINIMUM Y	:	-1.584	-1.551	-1.376
CENTROID X	:	.543	.340	.466
CENTROID Y	:	.389	.356	.181
POA TO CENTROID in.	:	.668	.492	.500
MIN RADIUS	:	.261	.443	.253
MEAN RADIUS	:	1.148	1.070	.983
MAX RADIUS	:	1.853	1.719	1.508
HORIZONTAL SPREAD	:	3.034	2.456	2.426
VERTICAL SPREAD	:	2.944	2.944	2.259
EXTREME SPREAD	:	3.423	3.423	2.837
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		6	

5 Feb 1988

FILE:/PATTERNING/CENTERFIRE_PATT/08225412

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 4

3 in = 7

HS= 3.605

VS= 2.106

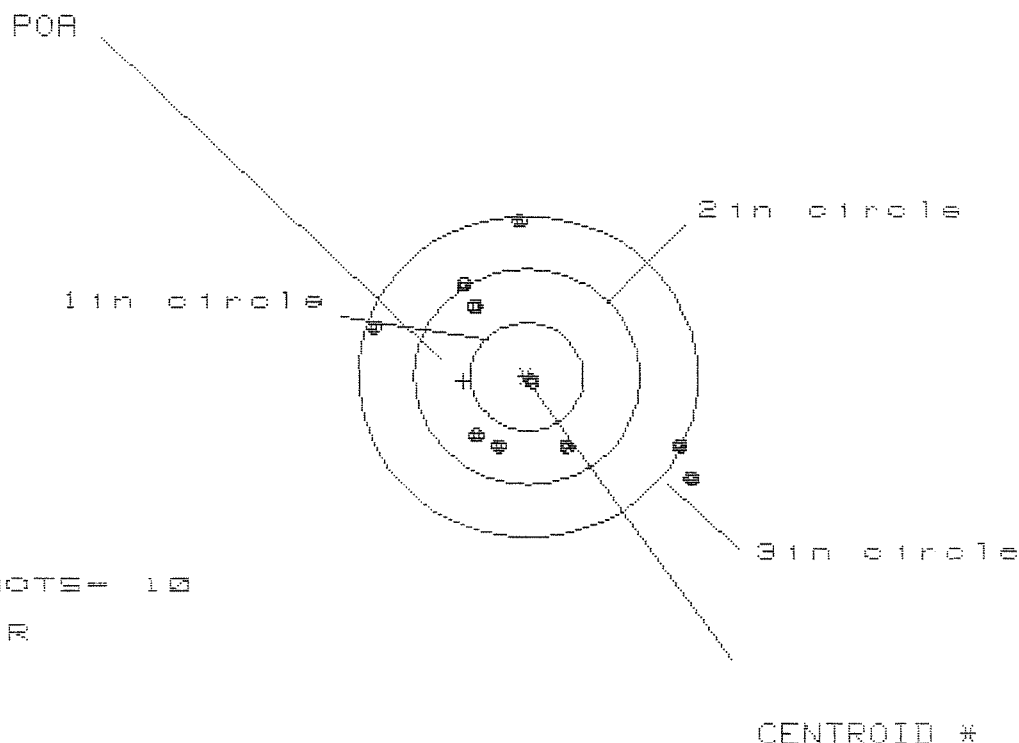
GS= 3.614

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.723	1.514	1.194
MINIMUM X	:	-1.882	-1.223	-1.034
MAXIMUM Y	:	1.205	1.170	1.158
MINIMUM Y	:	-.901	-.936	-.948
CENTROID X	:	.520	.729	.540
CENTROID Y	:	.394	.429	.441
POA TO CENTROID in.	:	.653	.846	.697
MIN RADIUS	:	.483	.587	.453
MEAN RADIUS	:	1.153	1.071	.986
MAX RADIUS	:	1.909	1.516	1.524
HORIZONTAL SPREAD	:	3.605	2.737	2.228
VERTICAL SPREAD	:	2.106	2.106	2.106
EXTREME SPREAD	:	3.614	2.744	2.505
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		7	

5 Feb 1988

FILE:/PATTERNING/CENTERFIRE_PATT/08225412

CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1in = 1

2in = 5

3in = 9

HS= 2.711

VS= 2.377

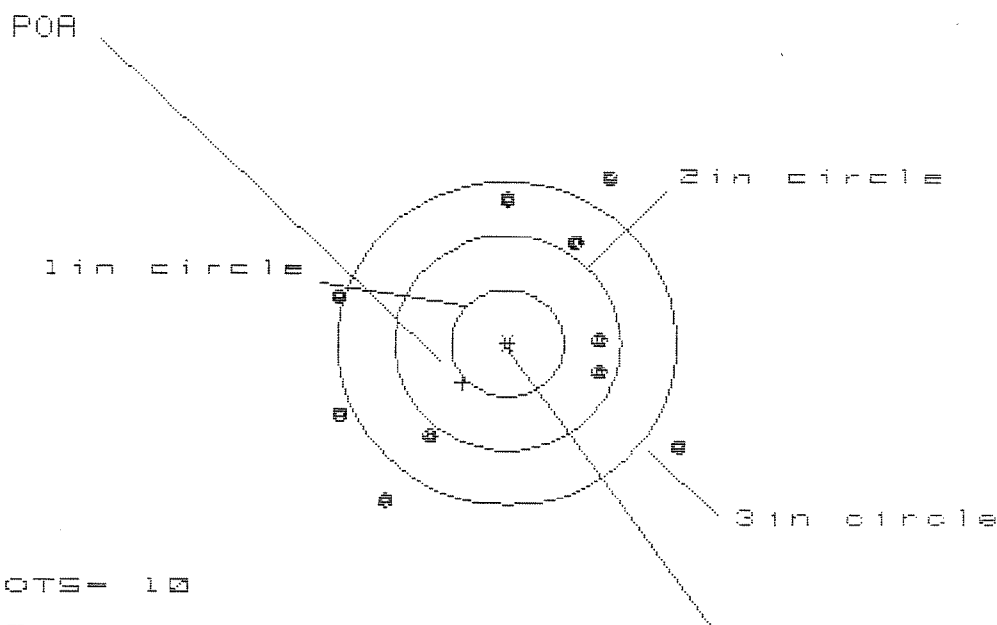
GS= 3.038

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.401	1.524	.693
MINIMUM X	:	-1.310	-1.155	-.964
MAXIMUM Y	:	1.433	1.329	1.241
MINIMUM Y	:	-.944	-.752	-.840
CENTROID X	:	.558	.403	.212
CENTROID Y	:	.047	.151	.239
POA TO CENTROID in.	:	.560	.430	.320
MIN RADIUS	:	.013	.197	.405
MEAN RADIUS	:	.996	.918	.815
MAX RADIUS	:	1.689	1.678	1.269
HORIZONTAL SPREAD	:	2.711	2.679	1.657
VERTICAL SPREAD	:	2.377	2.081	2.081
EXTREME SPREAD	:	3.038	2.868	2.086
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

5 Feb 1988

FILE:/PATTERNING/CENTERFIRE_PATT/06225412

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 2

3 in = 6

HS= 3.033

VS= 3.020

GS= 3.596

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.550	1.434	.964
MINIMUM X	:	-1.483	-1.599	-1.420
MAXIMUM Y	:	1.515	1.348	1.205
MINIMUM Y	:	-1.505	-1.143	-1.149
CENTROID X	:	.393	.509	.330
CENTROID Y	:	.361	.528	.671
POA TO CENTROID in.	:	.533	.733	.747
MIN RADIUS	:	.806	.701	.909
MEAN RADIUS	:	1.384	1.305	1.242
MAX RADIUS	:	1.835	1.833	1.744
HORIZONTAL SPREAD	:	3.033	3.033	2.384
VERTICAL SPREAD	:	3.020	2.491	2.354
EXTREME SPREAD	:	3.596	3.295	3.256
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		2	
NUMBER IN THREE INCH CIRCLE	=		6	