

C6611511

MODEL 700™ M24

Model **SWS**™

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.



Arms Services Repair & Estimate System

File Add Repair Estimate Repair Expedite Repair Inquiry Repair Tools CSR Tools Reports Table Maintenance System Maintenance Help

Evaluate History

Repair Inquiry

Repair Number: **RE00163627** Serial: C6611511 Model M24 SWS Center Fire Caliber: 7.62 NATO Produced: 06/19/1991 Repairman: Status: Closed 3/3/2009 11:25:56 AM

Verify Repair

Address Information

Customer: ☐ Received From Return To: ☐ Received From

Name: **ISD ARMSROOM**

Address 1: **8TH DESERT STORM**

Address 2: **BLDG 5210 BAY DOOR #30** PO Box:

City: **FORT CAMPBELL**

State: **KY** Zip Code: **42223** Country: **US**

State: **KY** Zip Code: **42223** Country: **US**

FFL:

Contact / Condition Problems Estimate History / Status Shipping / Billing

Contact Information

Phone: **NN**

Fax:

Email:

Comments:

Received Condition

Condition: **Fair**

Condition Notes:

CSR Notes:

Accessories Received

Code	Desc	Qty
A007	With Stud	3
A010	Hard Case	1
A017	Scope Base	1
A026	Scope	1
A045	Bi Pod	1
A057	Fit and Rear Sgt Base	1

Repair Search **Refresh** **Close**

Repair

naglet 3/4/2009 12:39 PM CAPS NUM INS SCRL

H start 10 Micro... 8 Micro... My Docum... Arms Servi... DMS - Glob... Google Ne... Part Searc... 12:39 PM

Serial Number: **C6611511**

Model: **M24 SWS**



RE00163627

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

R & E NUMBER <u>163627</u>				
SERIAL NUMBER <u>06611511</u>				
LOG-IN DATE <u>3-3-09</u>				

OPERATION #	OPERATION NAME	DATE	INITIAL
500	DIS-ASSEMBLE GUN	3-10-09	RTZ
505	RE-BARREL	3-16-09	RTZ
420	ASSEMBLE	3-16-09	RTZ
440	PROOF	MAGNA - FLUX 3-17-09	TC
460	CHECK HEADSPACE	3-17-09	TC
470	DIS-ASSEMBLE GUN	3-17-09	RTZ
480	MAGNAFLUX	3-20-09	(D)
510	DRILL AND TAP	3-17-09	JP
500	ROLLMARK CALIBER	3/24/09	RT
520	GOFF BLAST BBL / REC	3-24	BZ
530 & 540	APPLY COATINGS	3-31	C
560	FINAL ASSEMBLY	4-3-09	RTZ
640	FUNCTION TEST AND	(PASS) FAIL	4-3-09 TC
650	TARGET	(PASS) FAIL	4-3-09 TC
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
670	FINAL INSPECTION	4-3-09	W/Z
	A) HEADSPACE	(PASS) FAIL	4-4-09
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	2.78 2.77 2.73 2.72 2.79 4-3-09 TC
680	F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX	4.0 4.0 3.0 4-4-09
	G) SAFETY OFF FORCE	2 LBS MIN	4.0 5.0 5.0 4-4-09
	I) FIRING PIN INDENT	.020	.032 .032 .032 4-4-09
690	PACK		4-4-09

F006 REV 1/2009

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6611511.___0
FILE DATE AND TIME: 04/04/2009 04:46

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.086
The Average Y Centroid of the Five Target Set:	0.029
The Average Point of Impact of the Five Target Set:	0.090
The Average Mean Radius of the Five Target Set:	0.540
The Distance from POA to Centroid Target #1:	0.074
The Distance from Centroid Target #2 to Centroid Target #1:	0.068
The Distance from Centroid Target #3 to Centroid Target #1:	0.216
The Distance from Centroid Target #4 to Centroid Target #1:	0.346
The Distance from Centroid Target #5 to Centroid Target #1:	0.282

SERIAL NUMBER: C6611511.___0

TARGET NUMBER: 1

FILE DATE: 04/04/2009

FILE TIME: 04:46

POINT#	X	Y
1:	0.246	0.779
2:	0.420	0.497
3:	0.376	-0.061
4:	0.329	0.113
5:	-0.115	0.370
6:	-0.477	-0.051
7:	0.045	-0.176
8:	-0.289	-0.442
9:	-0.457	-0.681
10:	0.505	0.100

X CENTROID: 0.058

Y CENTROID: 0.045

POA TO CENTROID: 0.074

HORZ SPREAD: 0.982

VERT SPREAD: 1.460

GROUP SPREAD: 1.620

MIN RADIUS: 0.221

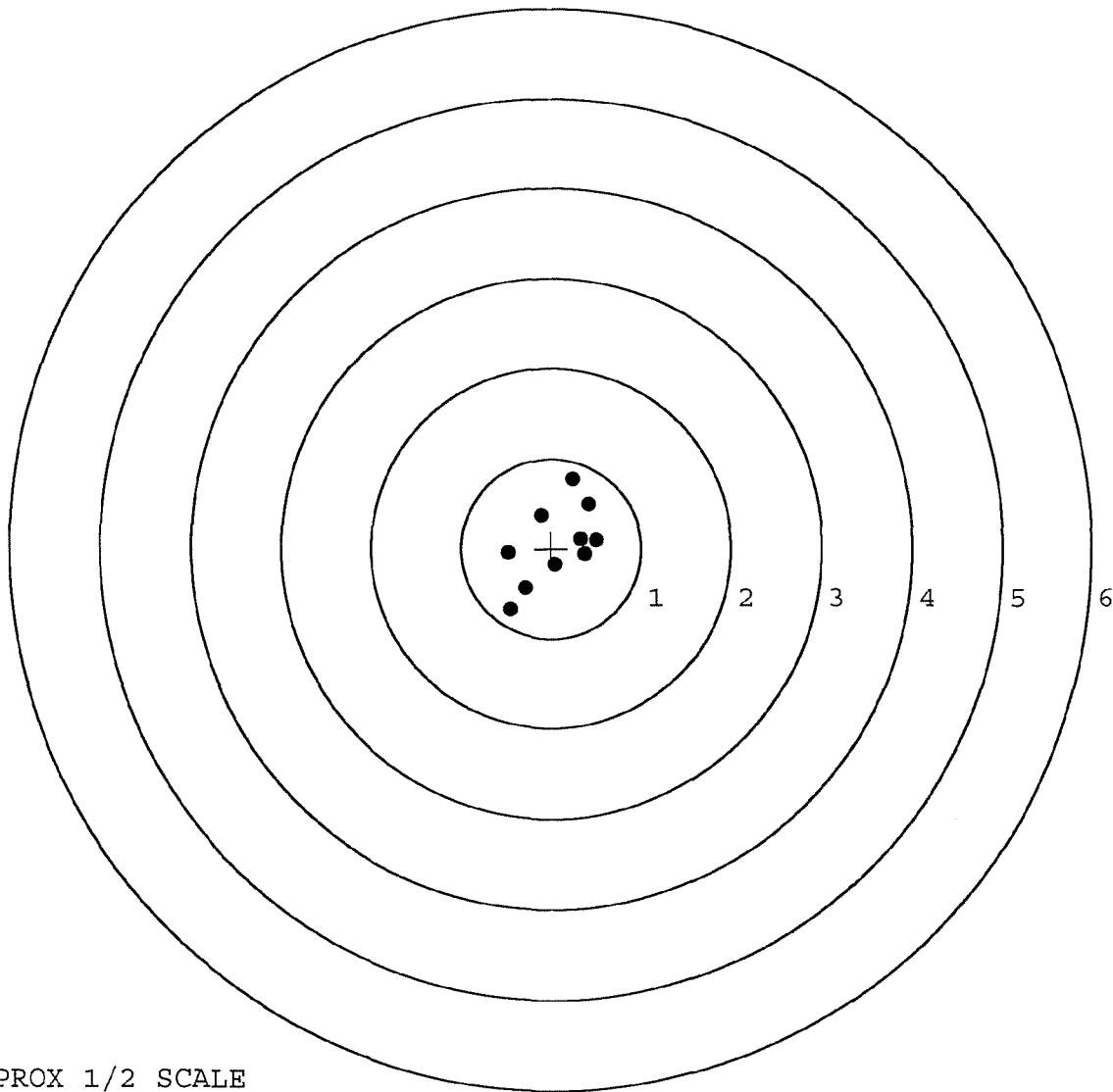
MAX RADIUS: 0.890

MEAN RADIUS: 0.502

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6611511.___0

TARGET NUMBER: 2

FILE DATE: 04/04/2009

FILE TIME: 04:46

POINT#	X	Y
1:	0.036	-0.734
2:	-0.393	-0.396
3:	-0.232	-0.234
4:	0.334	-0.255
5:	0.622	0.116
6:	-0.311	0.068
7:	-0.007	0.058
8:	0.035	0.267
9:	-0.287	0.552
10:	0.556	0.370

X CENTROID: 0.035

Y CENTROID: -0.019

POA TO CENTROID: 0.040

HORZ SPREAD: 1.015

VERT SPREAD: 1.286

GROUP SPREAD: 1.326

MIN RADIUS: 0.088

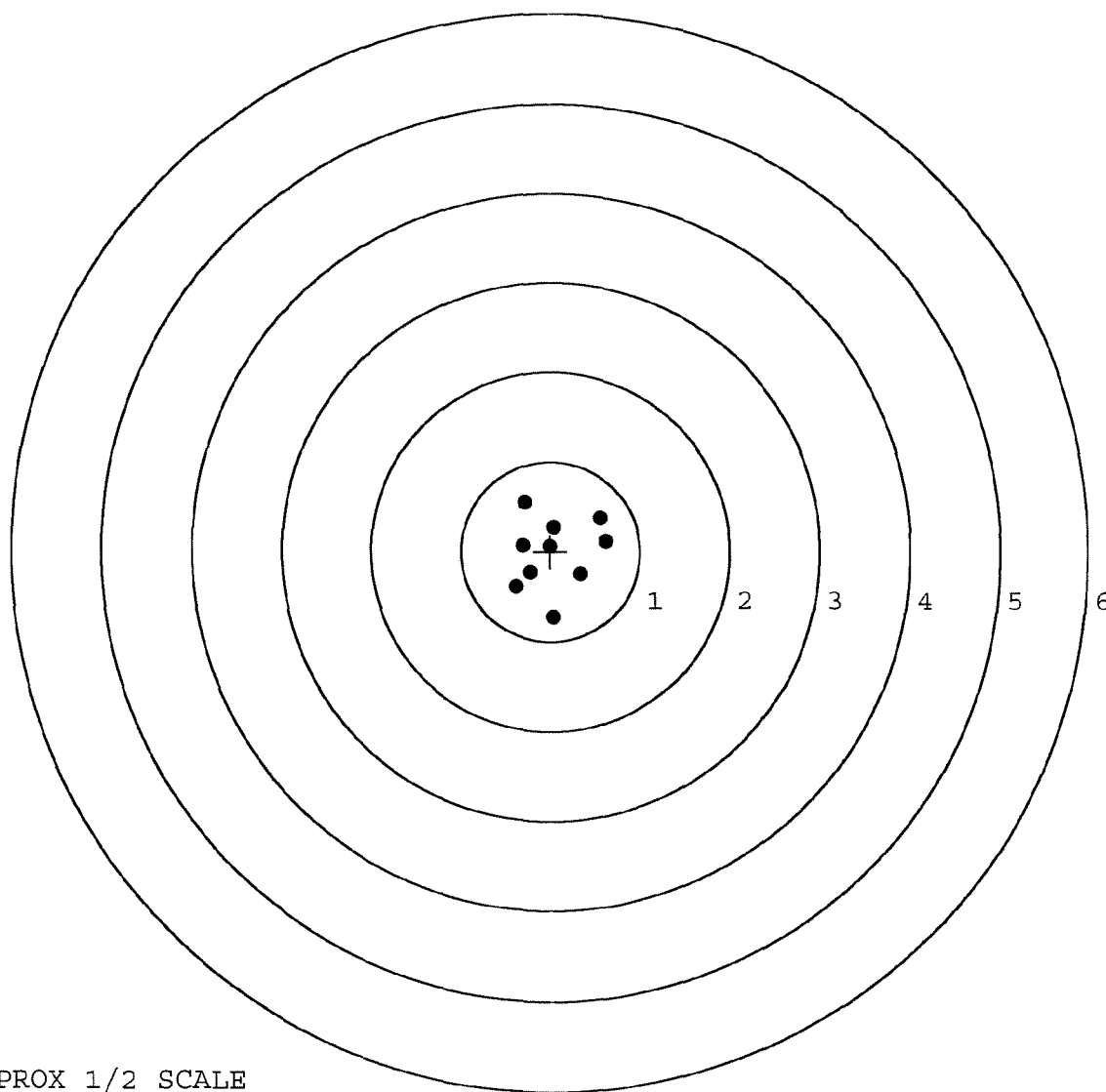
MAX RADIUS: 0.715

MEAN RADIUS: 0.465

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C66115111. 0

TARGET NUMBER: 3

FILE DATE: 04/04/2009

FILE TIME: 04:46

POINT#	X	Y
1:	-0.391	-0.621
2:	0.227	-0.944
3:	1.067	0.199
4:	0.143	0.155
5:	0.138	-0.191
6:	-0.185	0.325
7:	-0.476	0.130
8:	-0.047	0.055
9:	-0.298	0.051
10:	-0.591	-0.625

X CENTROID: -0.041

Y CENTROID: -0.147

POA TO CENTROID: 0.152

HORZ SPREAD: 1.658

VERT SPREAD: 1.269

GROUP SPREAD: 1.851

MIN RADIUS: 0.185

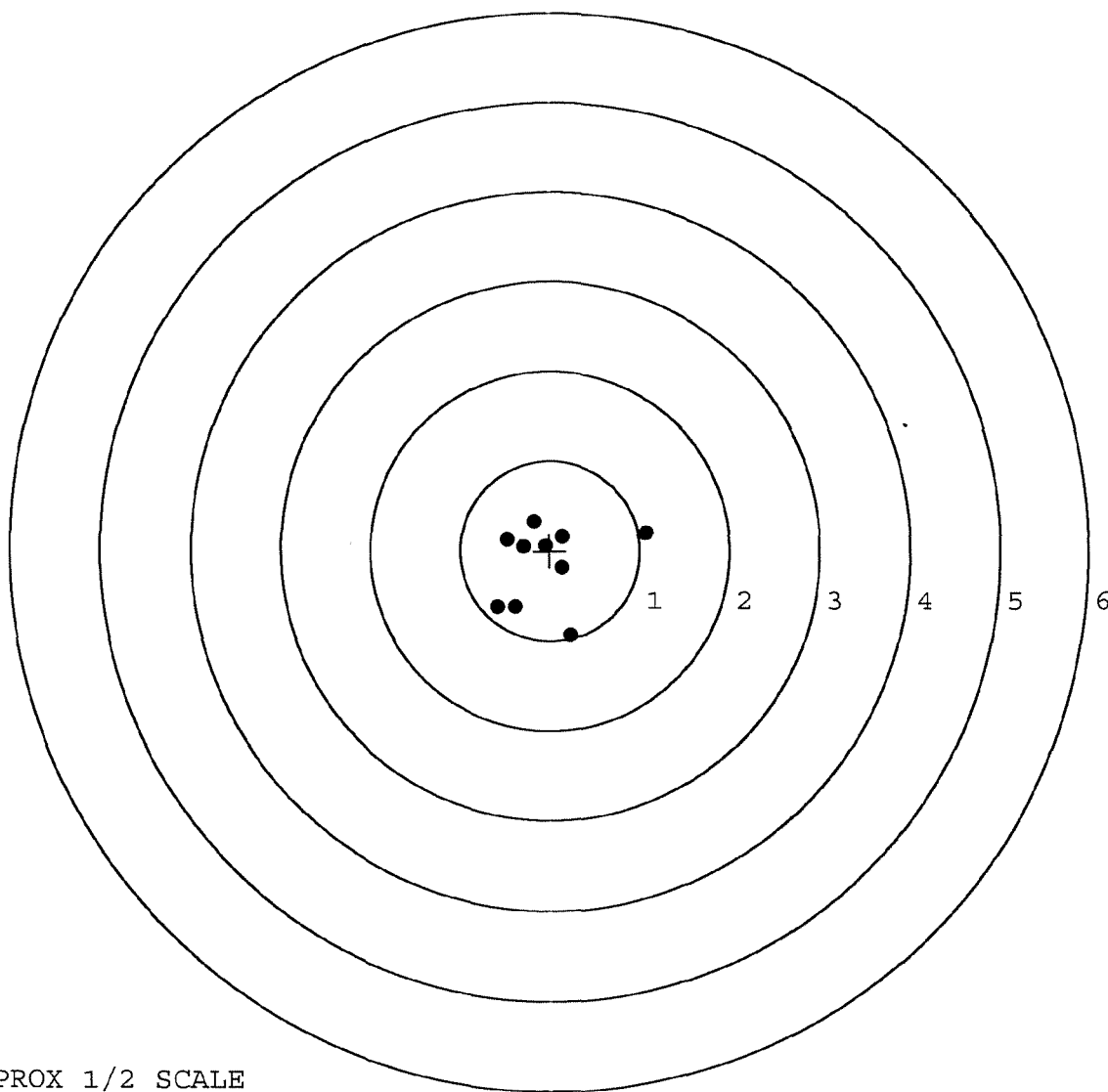
MAX RADIUS: 1.161

MEAN RADIUS: 0.539

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6611511. __0

TARGET NUMBER: 4

FILE DATE: 04/04/2009

FILE TIME: 04:46

POINT#	X	Y
1:	-1.302	0.552
2:	-1.417	-0.107
3:	0.193	0.892
4:	-0.242	0.530
5:	-0.220	0.346
6:	0.491	-0.147
7:	-0.372	-0.525
8:	-0.132	-0.286
9:	0.141	-0.172
10:	0.035	-0.051

X CENTROID: -0.283

Y CENTROID: 0.103

POA TO CENTROID: 0.301

HORZ SPREAD: 1.908

VERT SPREAD: 1.417

GROUP SPREAD: 1.908

MIN RADIUS: 0.251

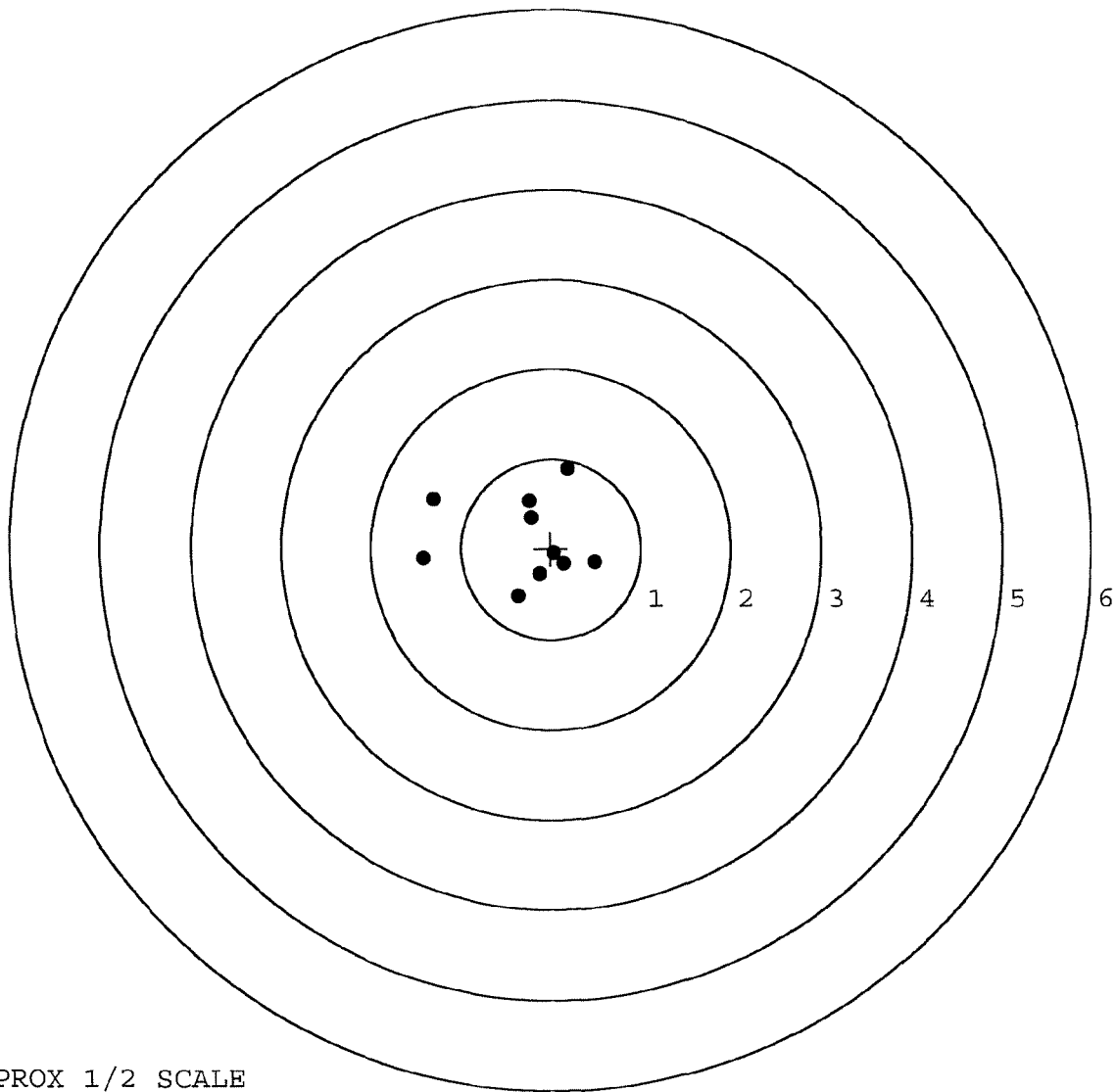
MAX RADIUS: 1.154

MEAN RADIUS: 0.659

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6611511. 0

TARGET NUMBER: 5

FILE DATE: 04/04/2009

FILE TIME: 04:46

POINT#	X	Y
1:	-0.774	0.757
2:	-0.555	0.354
3:	-1.285	-0.183
4:	0.320	0.672
5:	-0.278	0.184
6:	0.113	0.149
7:	0.453	0.068
8:	0.173	-0.214
9:	-0.182	-0.217
10:	0.029	0.031

X CENTROID: -0.199

Y CENTROID: 0.160

POA TO CENTROID: 0.255

HORZ SPREAD: 1.738

VERT SPREAD: 0.974

GROUP SPREAD: 1.819

MIN RADIUS: 0.083

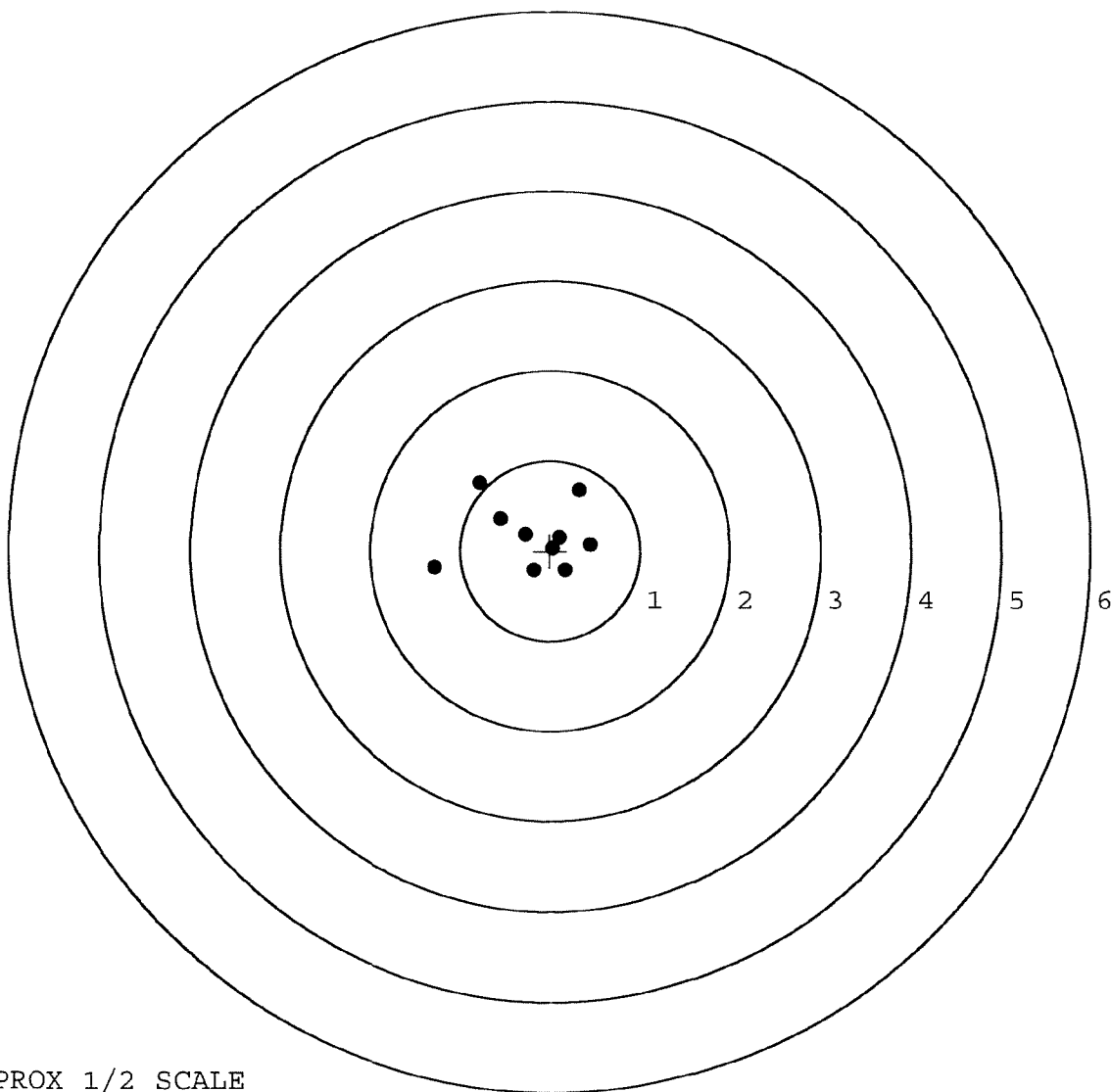
MAX RADIUS: 1.139

MEAN RADIUS: 0.532

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6611511.___0
FILE DATE AND TIME: 06/23/2005 10:09

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.095
The Average Y Centroid of the Five Target Set:	-0.255
The Average Point of Impact of the Five Target Set:	0.272
The Average Mean Radius of the Five Target Set:	1.007
The Distance from POA to Centroid Target #1:	0.227
The Distance from Centroid Target #2 to Centroid Target #1:	0.389
The Distance from Centroid Target #3 to Centroid Target #1:	0.368
The Distance from Centroid Target #4 to Centroid Target #1:	0.497
The Distance from Centroid Target #5 to Centroid Target #1:	0.191

SERIAL NUMBER: C6611511. __0

TARGET NUMBER: 1

FILE DATE: 06/23/2005

FILE TIME: 10:09

X CENTROID: -0.081

Y CENTROID: -0.212

POA TO CENTROID: 0.227

HORZ SPREAD: 1.976

VERT SPREAD: 2.536

GROUP SPREAD: 2.825

MIN RADIUS: 0.176

MAX RADIUS: 1.681

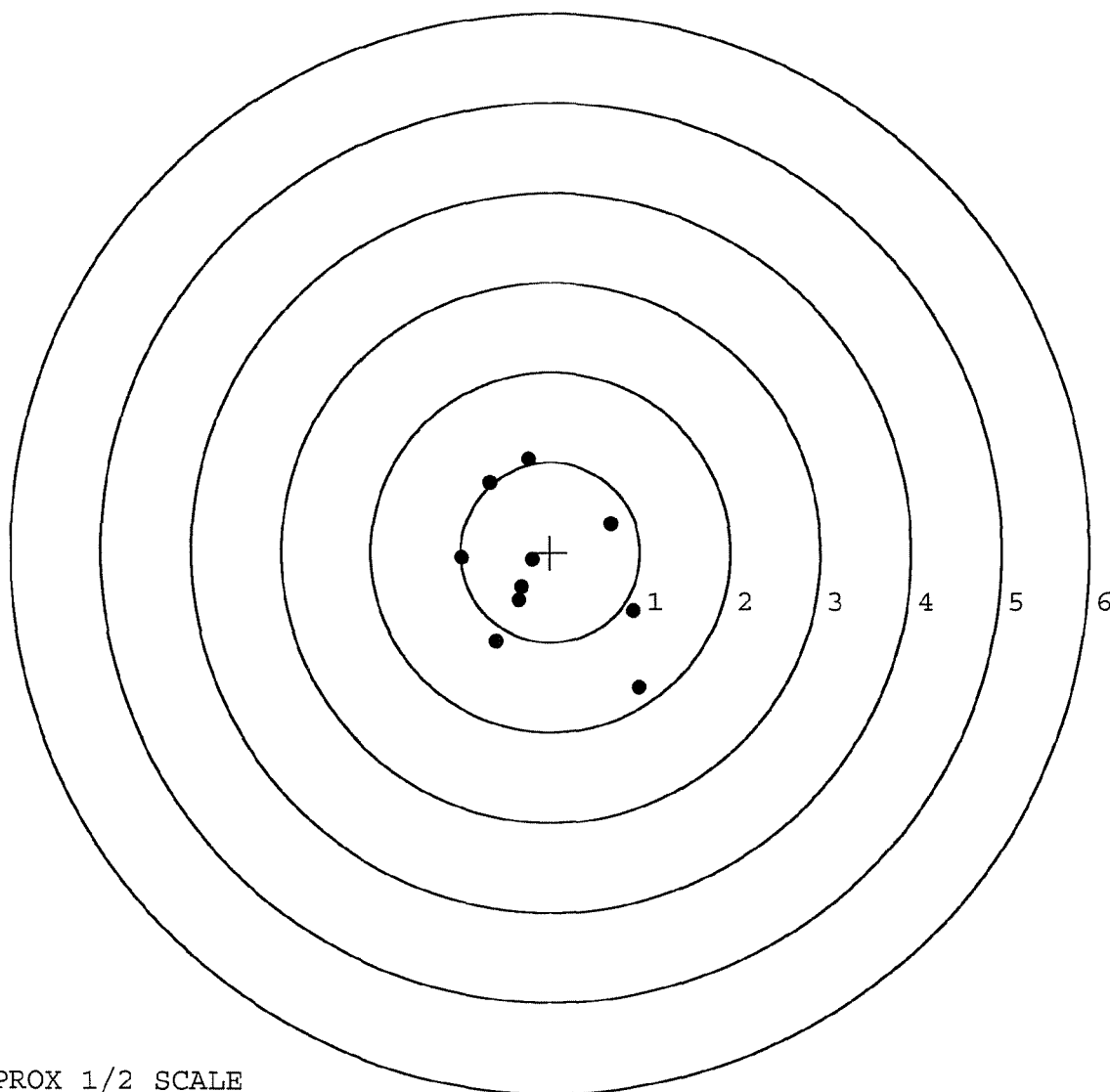
MEAN RADIUS: 0.887

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 9

POINT#	X	Y
1:	-0.241	1.028
2:	-0.677	0.774
3:	-0.987	-0.063
4:	-0.201	-0.083
5:	-0.324	-0.393
6:	-0.354	-0.534
7:	-0.606	-0.999
8:	0.989	-1.508
9:	0.922	-0.658
10:	0.671	0.320



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6611511. __0

TARGET NUMBER: 2

FILE DATE: 06/23/2005

FILE TIME: 10:09

X CENTROID: 0.276

Y CENTROID: -0.366

POA TO CENTROID: 0.458

HORZ SPREAD: 1.922

VERT SPREAD: 3.439

GROUP SPREAD: 3.483

MIN RADIUS: 0.190

MAX RADIUS: 2.083

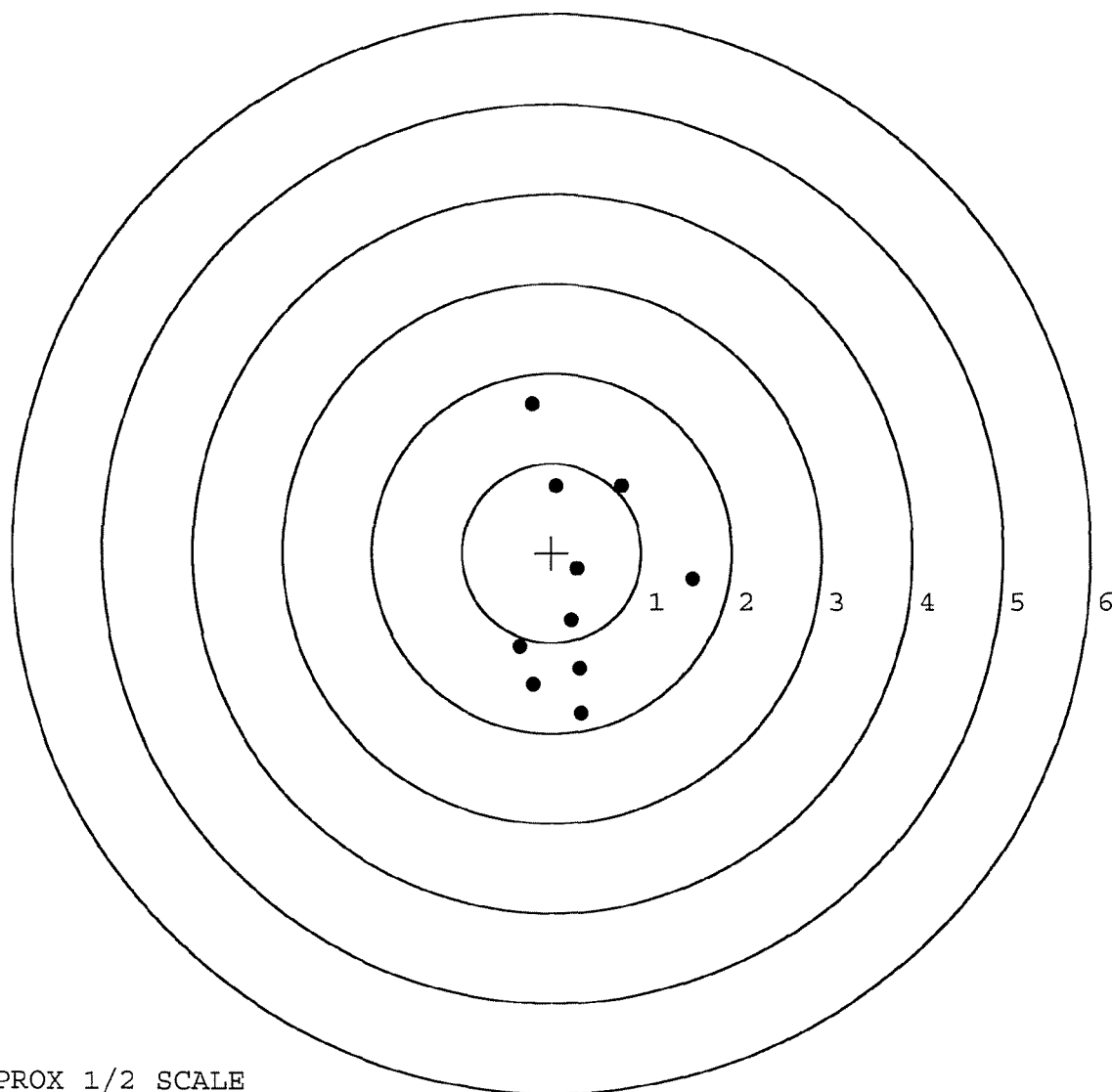
MEAN RADIUS: 1.080

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 4

in 3 IN DIAMETER: 9

POINT#	X	Y
1:	-0.223	1.656
2:	0.779	0.753
3:	0.050	0.745
4:	0.282	-0.177
5:	0.218	-0.754
6:	-0.354	-1.048
7:	-0.213	-1.472
8:	0.319	-1.290
9:	0.330	-1.783
10:	1.568	-0.294

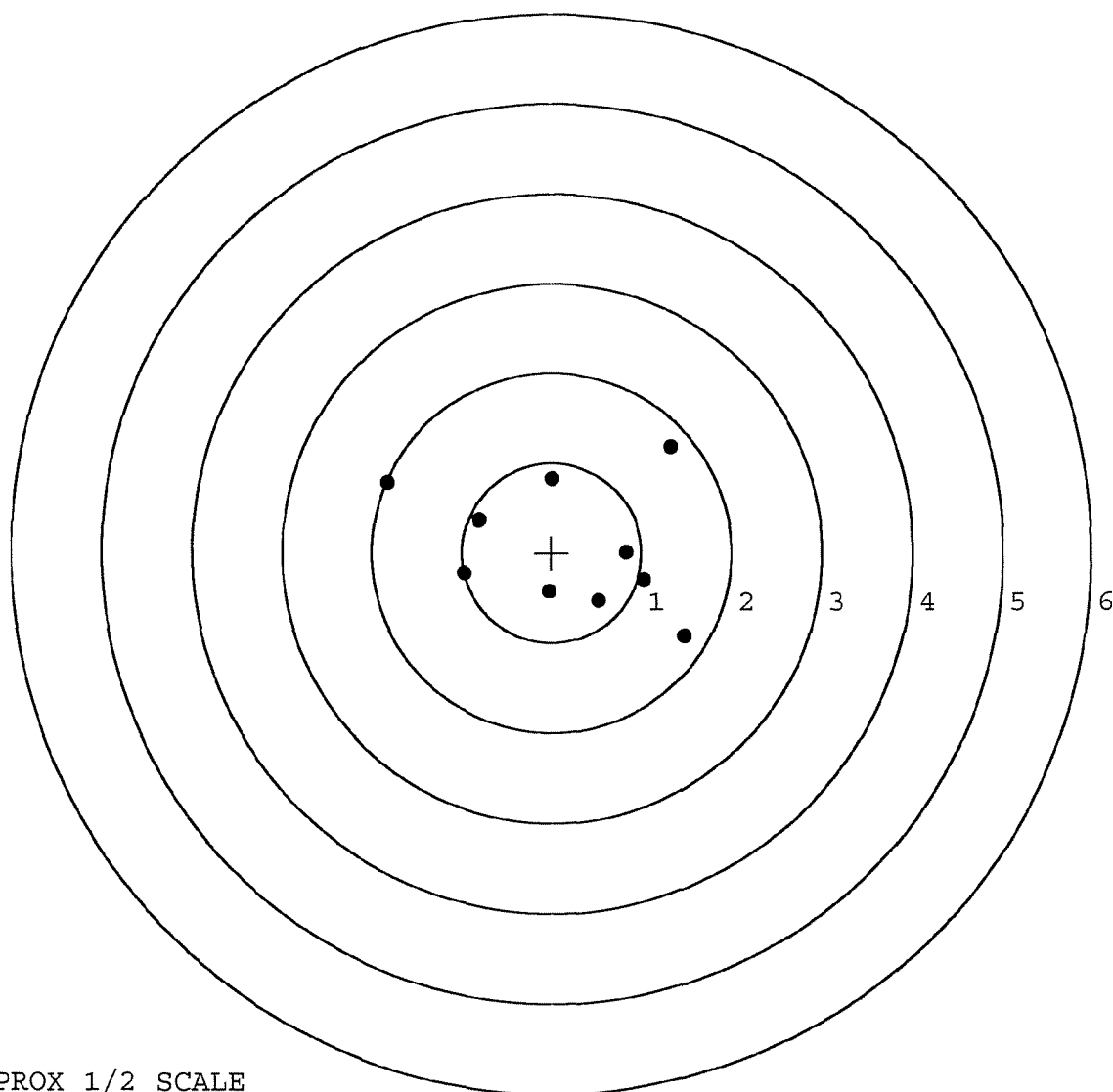


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6611511. __ 0
TARGET NUMBER: 3
FILE DATE: 06/23/2005
FILE TIME: 10:09

X CENTROID: 0.157
Y CENTROID: 0.070
POA TO CENTROID: 0.172
HORZ SPREAD: 3.311
VERT SPREAD: 2.102
GROUP SPREAD: 3.731
MIN RADIUS: 0.539
MAX RADIUS: 2.108
MEAN RADIUS: 1.122
IN 1 IN DIAMETER: 0
IN 2 IN DIAMETER: 5
in 3 IN DIAMETER: 7

POINT#	X	Y
1:	1.333	1.167
2:	0.012	0.825
3:	-0.810	0.369
4:	-1.826	0.785
5:	-0.977	-0.230
6:	-0.033	-0.435
7:	0.526	-0.540
8:	1.030	-0.310
9:	1.485	-0.935
10:	0.833	-0.001

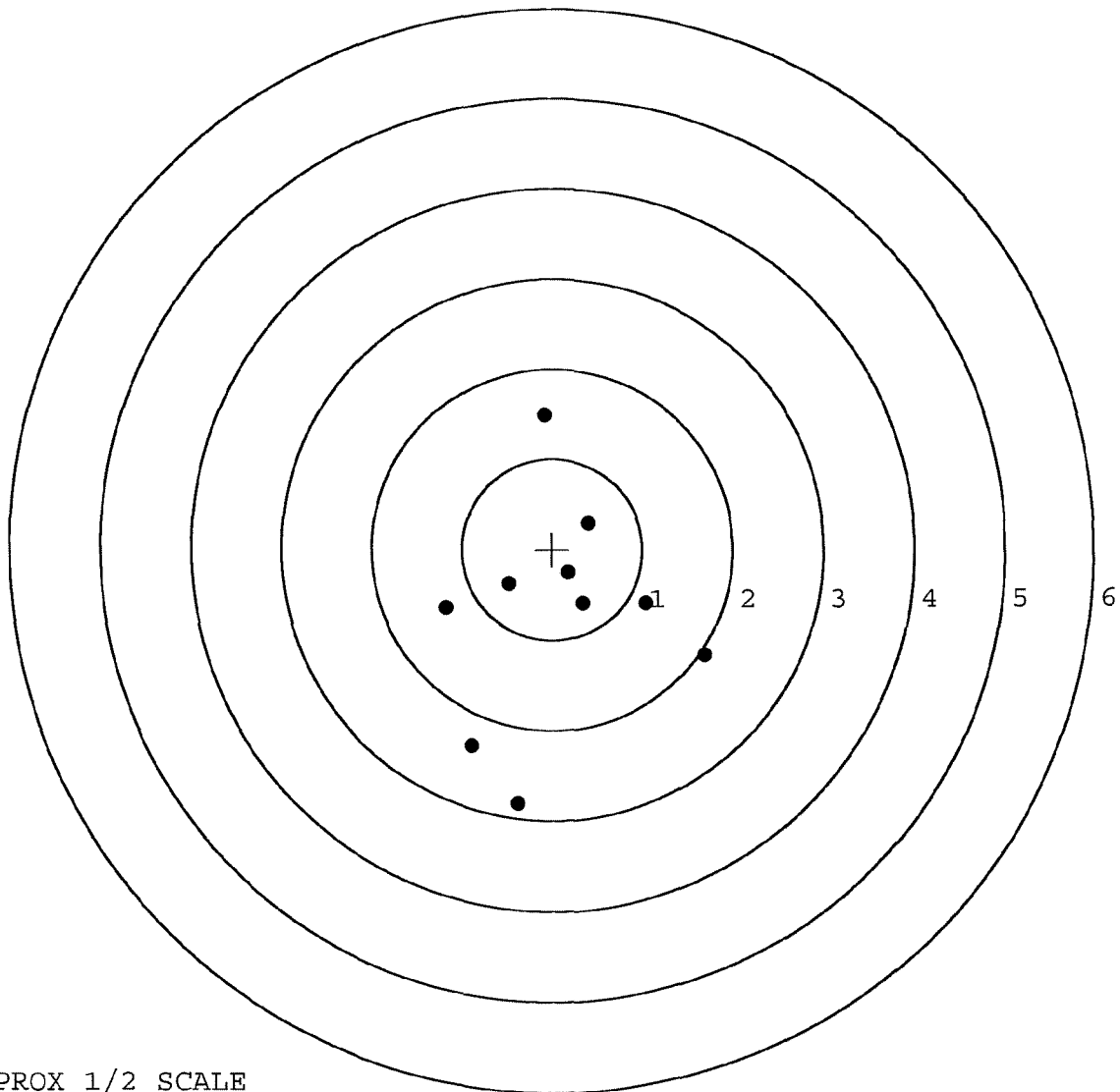


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6611511. __0
TARGET NUMBER: 4
FILE DATE: 06/23/2005
FILE TIME: 10:09

X CENTROID: 0.062
Y CENTROID: -0.687
POA TO CENTROID: 0.690
HORZ SPREAD: 2.871
VERT SPREAD: 4.299
GROUP SPREAD: 4.310
MIN RADIUS: 0.289
MAX RADIUS: 2.179
MEAN RADIUS: 1.244
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 4
in 3 IN DIAMETER: 6

POINT#	X	Y
1:	-0.077	1.480
2:	0.407	0.290
3:	0.178	-0.257
4:	0.337	-0.598
5:	1.037	-0.603
6:	1.689	-1.179
7:	-0.486	-0.379
8:	-1.182	-0.641
9:	-0.896	-2.168
10:	-0.388	-2.819



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6611511. __0

TARGET NUMBER: 5

FILE DATE: 06/23/2005

FILE TIME: 10:09

X CENTROID: 0.059

Y CENTROID: -0.081

POA TO CENTROID: 0.100

HORZ SPREAD: 1.987

VERT SPREAD: 1.880

GROUP SPREAD: 2.451

MIN RADIUS: 0.055

MAX RADIUS: 1.448

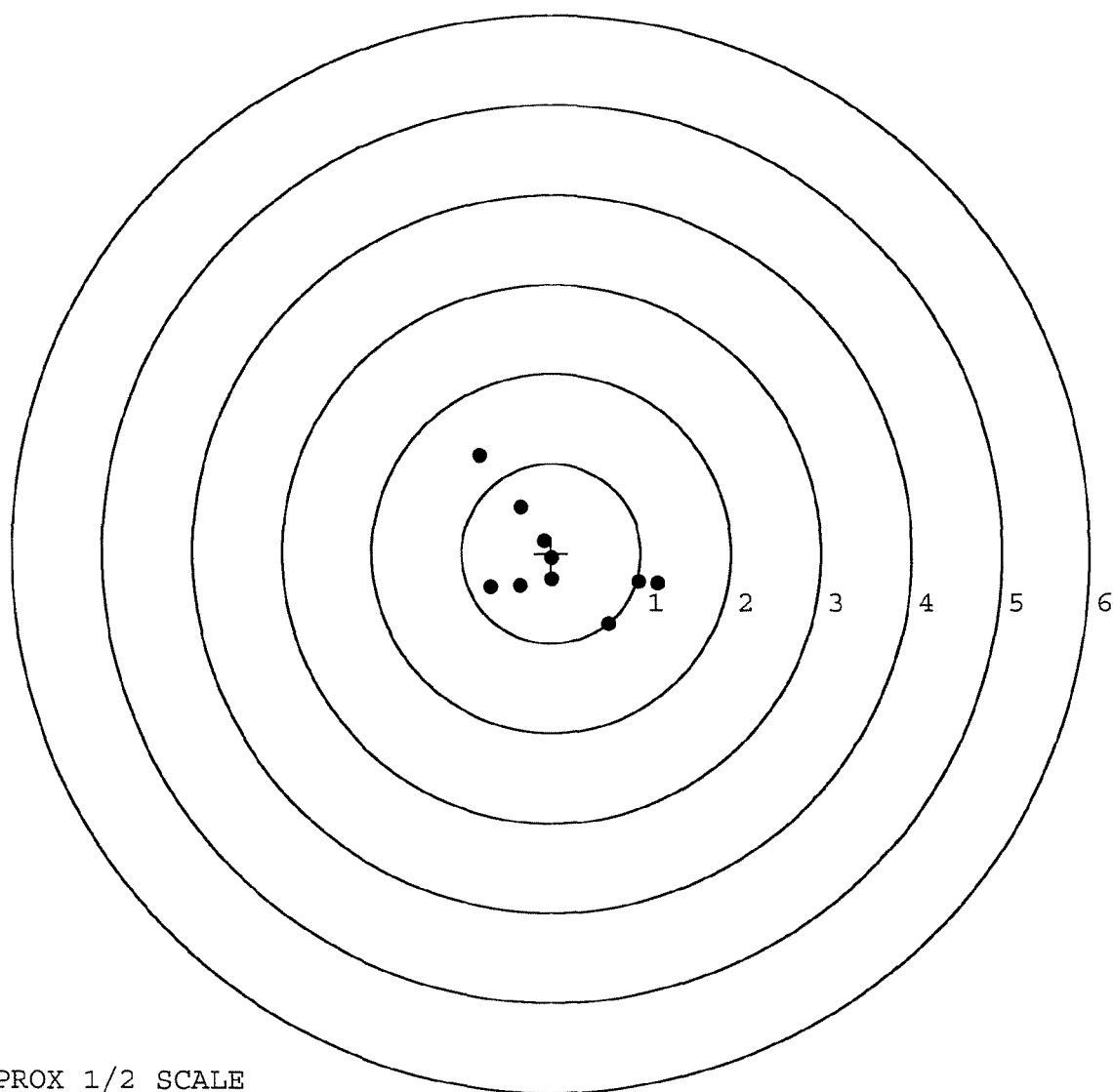
MEAN RADIUS: 0.700

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.796	1.089
2:	-0.344	0.514
3:	-0.076	0.135
4:	-0.674	-0.375
5:	-0.347	-0.362
6:	0.009	-0.293
7:	0.974	-0.322
8:	1.191	-0.346
9:	0.639	-0.791
10:	0.010	-0.054



TARGET APPROX 1/2 SCALE

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

R. & E NUMBER	97848		
SERIAL NUMBER	C60011511		
LOG-IN DATE	6-14-05		
INSPECT AND VERIFY:			
OPERATION #	OPERATION NAME	DATE	INITIAL
550	DIS-ASSEMBLE GUN	6-14-05	RTZ
560 A	RE-BARREL	6-16-05	RTZ
B	DRILL AND TAP	6-16-05	TRW
575	ASSEMBLE	6-16-05	RTZ
600	PROOF	6-16-05	AK
605	CHECK HEADSPACE	6-16-05	AK
610	DIS-ASSEMBLE GUN	6-16-05	RTZ
612	MAGNAFLUX	6/16/05	WML
615	ROLLMARK CALIBER	6-16-05	CW
618	ROTO-BLAST	6-17-05	LB
620	APPLY COATINGS	6-21-05	WP
625 A	FINAL ASSEMBLY	6-22-05	RTZ
B	TRIGGER PULL TEST		
C	SAFETY "ON" FORCE	8-8-05	AC
D	SAFETY "OFF" FORCE	8-8-05	AC
E	FIRING PIN INDENT	8-8-05	AC
640	TARGET	6-23-05	TRW
655	FINAL INSPECT	8-8-05	AC
660	PACK	8-10-05	DA
		SHIP DATE	
		QAR INSPECTION DATE	

[illegible]

Replaces edition of 1 Jan 64, which will be used

MAINTENANCE REQUEST For use of this form, see DA PAM 738-750 and 738-751; the proponent agency is DCSLOG				PAGE NO. 1	NO OF PAGES 1	REQUIREMENT CONTROL SYMBOL CSGLD-1047(R7)
SECTION I - CUSTOMER DATA				SECTION II - MAINTENANCE ACTIVITY DATA		
1a. UIC CUSTOMER WO 4 Q 4	1b. CUSTOMER UNIT NAME Pt, Campbell MP CO	1c. PHONE NO 2922	3a. WORK ORDER NUMBER (WON)		3b. SHOP	3c. PHONE NO
2a. SAMS-2 UIC/SAMS-I/TDA	2b. UTILIZATION CODE	2c. MCSR	4a. UIC SUPPORT UNIT		4b. SUPPORT UNIT NAME	
SECTION III - EQUIPMENT DATA						
5. TYPE MNT REQ CODE	6. ID	7. NSN	15a. FAILURE DETECTED DURING/WHEN DISCOVERED CODE (Enter code) See DA Pamphlets 738-750 and 738-751		D	
8. MODEL M24		1, 0, 0, 5, 0, 1, 2, 4, 0, 2, 1, 3, 6	15b. FIRST INDICATION OF TROUBLE/HOW RECOGNIZED CODE (Enter Code) See DA Pamphlets 738-750 and 738-751		16. MILES/KILOMETERS/HOURS/ROUNDS M K	
9. NOUN Rifle Sniper 7.62MM Weapons Sys			068		H R	
10a. ORG WON/DOC NO	10b. EIC		17. PROJECT CODE (if assigned)		18. ACCOUNT PROCESSING CODE	19. IN WARRANTY? (enter Y or N)
11. SERIAL NUMBER C, 9, 6, 1, 4, 5, 1, 1	12. QTY 0, 1, 0, 1	13. PD 06	21. REIMBURSABLE CUSTOMER (if Intransit customer enter Y or N)		20. ADMIN NO	
14. MALFUNCTION DESCRIPTION (for DSU, GSU/AVIM, DEPOT use)			22. LEVEL OF WORK		23. SIGNATURE	
24. DESCRIBE DEFICIENCIES OR SYMPTOMS ON THE BASIS OF COMPLETE CHECKOUT AND DIAGNOSTIC PROCEDURES IN EQUIPMENT TM (Do not prescribe repairs) Unserviceable bolt mechanism, will not eject						
25. REMARKS POC: Mr. Doxtater, 798-2922, DSN: 635-798-2922						
PREPARATION INSTRUCTIONS FOR THIS PAGE						
SECTION I Block 1a. Enter UIC of submitting organization. Block 1b. Enter name of submitting organization. Block 1c. Enter number to be called when maint. is completed. Block 2a. Enter UIC of supporting SAMS-2/SAMS-I/TDA if work is requested while intransit and away from your support maintenance unit. Block 2b. Enter utilization code. See DA Pamphlets 738-750 and 738-751. Block 2c. Enter "Y" if reportable under AR 700-138. If not, leave blank.			SECTION III (Cont'd) Block 12. Enter the quantity of items being submitted. Block 13. Enter the maintenance priority designator determined from DA PAM 710-2-1. Block 14. For DSU, GSU/AVIM, DEPOT use. Block 15a. Enter the code that most accurately describes when the fault or deficiency was detected. See DA Pamphlets 738-750 and 738-751. Block 15b. Select one. Enter the code. See DA Pamphlets 738-750 and 738-751. Block 16. Enter the accumulated usage data in blocks, when equipment is subject to usage reporting. Block 17. Enter the project code if one has been assigned. If not, leave blank. Block 18. See DA Pamphlets 738-750 and 738-751. Block 19. Enter "Y" or "N" to indicate whether equipment is still under manufacturer's warranty. Block 20. Enter the admin number assigned for property control purposes for the equipment being submitted. Block 21. For DSU/GSU/AVIM/Depot use. Block 22. Enter level of work performed "O" for UNIT LEVEL/AVUM, "F" for DSU/AVIM, "H" for GSU, "D" for DEPOT, "K" for contractor or "L" for Spc Rpr Act. Block 23. Enter the signature of the CO or the CO's designated representative when the priority designator is 01-10. For priority designators 11-15, leave blank. Block 24. Enter a brief description of the deficiencies or symptoms that you feel require attention at this level of maint. Block 25. Self-explanatory.			
SECTION II Leave blank. To be completed by the support maintenance DSU/GSU/AVIM/DEPOT.						
SECTION III Block 5. Enter the Type Maintenance Request Code. See DA Pamphlets 738-750 and 738-751. Block 6. Enter ID associated with block 7. See DA Pamphlets 738-750 and 738-751. Block 7. Enter the NSN or stock number of the item being submitted. Block 8. Enter model of item being submitted. Block 9. Enter noun/nomenclature of item being submitted. Block 10a. Enter Work Order Number (WON)/DOC NO assigned when item is submitted. Otherwise, leave blank. Block 10b. Enter End Item Code. See AMDF. Block 11. Enter serial number of item being submitted.						
34a. SUBMITTED BY 	35a. ACCEPTED BY	35c. DATE	Block 34a. Enter first initial and last name of submitter. Block 34b. Enter ordinal date submitted (YYDDD). Block 35a. Enter first initial and last name of person accepting maint. request. Block 35b. Enter the initial status. See DA Pamphlets 738-750 and 738-751. Block 35c. Enter ordinal date accepted (YYDDD). Block 35d. Enter military time.			
34b. DATE 6 Jul 94	35b. STATUS	35d. TIME				

DA FORM 2407, JUL 94

PREVIOUS EDITIONS OF DA FORM 2407 AND DA FORM 5504 ARE OBSOLETE

RECEIPT COPY 1

NMP COPY 2

21 DAY TURN - AROUND

M-24

CONTRACT # DAAA09-92-C-0834

R&E NO.

SERIAL NO.

C6611511

LOG IN DATE: / /		DATE	INIT.
INSPECT & VERIFY:			
OP. #	OP. NAME		
550	DIS-ASSEMBLE GUN		
560 A	RE-BARREL AT CUSTOM SHOP		
B	DRILL & TAP		
C	POLISH		
575	ASSEMBLE		
600	PROOF		
605	CHECK HEADSPACE		
610	DIS-ASSEMBLE		
612	MAGNAFLUX		
615	ROLLMARK CALIBER		
618	ROTO-BLAST		
620	APPLY COATINGS		
625 A	FINAL ASSEMBLY		
B	TRIGGER PULL TEST		
C	SAFETY ON FORCE		
D	SAFETY OFF FORCE		
E	FIRING PIN INDENT		
640	TARGET TEST	10/15/96	AF
655	FINAL INSPECT	10/18/96	RW
660	PACK		

QAR INSPECTION

SHIP DATE

Final Inspection

Sn: _____

DATE REC'D: _____

DATE RET'D: _____

AUDITOR: _____

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: _____

Remington[®]

MODEL 700TM H24

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

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

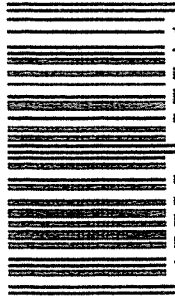
REG. U.S. PAT. & T.M. OFF.

SERIAL NO.
C6811511

ORDER NO.
5716



UPC



CONTRACT # DAAA21-87-C-0086

GUN SERIAL # **C6611511**

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		3/12/91	K.S.
600	Proof		3/12/91	K.S.
607	Check Headspace		3/12/91	K.S.
610	Dis-assemble Gun		3/12/91	K.S.
612	Magnaflux Barrel Action		3/27/91	KR
	Magnaflux Bolt		11	KR
615	Rollmark Caliber		3/27/91	LS
617	Drill and Tap Sight Holes		APR 3 1991	KB
618	Polish Barrel		APR 3 1991	WB
620	Apply Coatings (Barrel Action)		4-18-91	DA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		4/18/91	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		4/18/91	KS
	C) Inspect Ejector Hole for Chamfer		4/18/91	KS
	D) Oil Firing Pin Ass'y		4/18/91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		4/18/91	KS

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	6	6			4-22-91	DH
	G) Safety Off Force	3	3	3 1/4			4-22-91	DH
	H) Trigger Pull Test & Retainability						4/19/91	JD
	I) Firing Pin Indent	.022	.021	.022			4-22-91	DH
	J) Assemble Stock						4/22/91	KS
	K) Assemble Swivel Studs						5-2-91	DH
	L) Attach Front and Rear Sight Assemblies						4/22/91	KS
	M) Iron Sight Alignment						4/22/91	KS
	N) Detach Front & Rear Sights & place in numbered container						4/22/91	KS
	O) Attach Scope to Rifle						4/22/91	KS
	P) Detach & Attach Scope 20 Times						4/22/91	KS
640	Gallery Target & Test						4/23/91	KJ
	A) Time						"	KT
	B) Malfunctions						"	KT
	C) Pierced Primers						"	KT
	D) Optical Clarity of Scope						"	KT
645	Inspect for Live Ammo						4/23/91	KT
655	Final Inspection							
	A) Headspace						5-2-91	DH
	B) Trigger Pull	2.37	2.32	2.27	2.29	2.23	4/22/91	JD
	C) Function						5-2-91	DH
660	Pack						6-19-91	VF

SWS TRIGGER PULL TEST

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

SERIAL NO. C6611511

DATE 4/19/91

TESTER JRP

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.47	2.17	2.30	2.37	MIN. SETTING,
PULL #2	2.38	2.27	2.28	2.32	NO AVG. OF 5
PULL #3	2.49	2.22	2.26	2.27	READINGS ACCEPT-
PULL #4	2.47	2.15	2.20	2.29	ABLE LESS THAN 2#
PULL #5	2.56	2.33	2.22	2.23	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.39	3.39		
PULL #2	3.35	3.36		
PULL #3	3.31	3.34		
PULL #4	3.27	3.39		
PULL #5	3.29	3.29		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.46	4.41		4.46
PULL #2	4.43	4.18		4.34
PULL #3	4.50	4.46		4.55
PULL #4	4.45	4.45		4.13
PULL #5	4.44	4.23		4.52
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611511
23 Apr 1991

CENTROIDAL DISTANCES

0 TO	1	.153101
1 TO	2	.174256
1 TO	3	.304792
1 TO	4	.402141
1 TO	5	.0230217

85 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0859
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0786
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .11536
THE AMR FOR THIS RIFLE IS: 1.169

23 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8B11511

CENTERFIRE PATTERNS # 1

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 0

2in = 6

3in = 8

HS= 1.559

VS= 3.187

GS= 3.324

CENTROID #

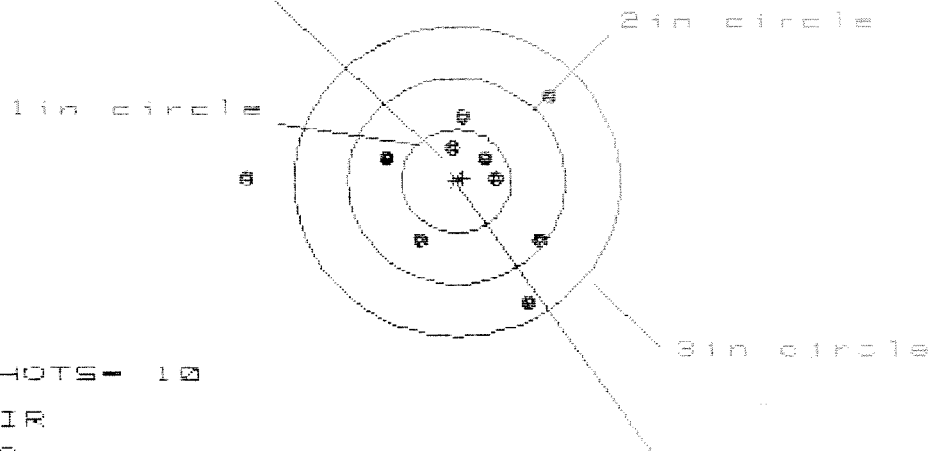
PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.772	.789	.690
MINIMUM X	-.787	-.770	-.720
MAXIMUM Y	1.460	1.268	.831
MINIMUM Y	-1.727	-1.061	-.900
CENTROID X	.084	.067	.163
CENTROID Y	-.128	.064	-.094
POA TO CENTROID in.	.153	.093	.188
MIN RADIUS	.569	.549	.654
MEAN RADIUS	.991	.908	.817
MAX RADIUS	1.734	1.483	.989
HORIZONTAL SPREAD	1.559	1.559	1.413
VERTICAL SPREAD	3.187	2.329	1.734
EXTREME SPREAD	3.324	2.470	1.810
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	8		

23 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611511

CENTERFIRE PATTERNS # 2

POA



OF SHOTS - 10

IN CIR

1in = 3

2in = 7

3in = 9

HS = 2.763

VS = 2.022

CS = 2.894

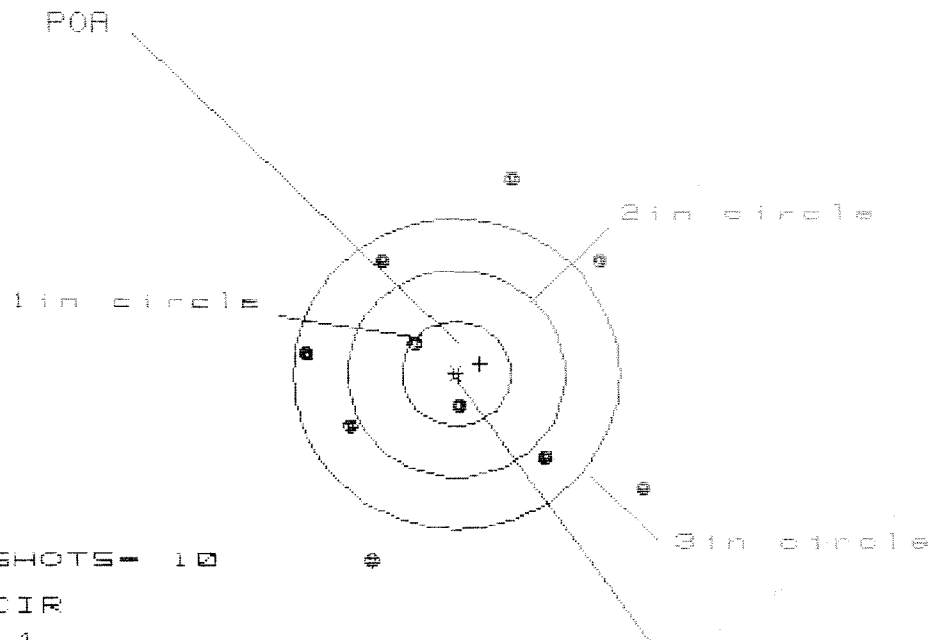
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.841	.628	.683
MINIMUM X	:	-1.922	-.861	-.805
MAXIMUM Y	:	.854	.853	.707
MINIMUM Y	:	-1.168	-1.169	-.721
CENTROID X	:	-.058	.155	.100
CENTROID Y	:	-.027	-.026	.120
POA TO CENTROID in.	:	.064	.158	.156
MIN RADIUS	:	.338	.172	.136
MEAN RADIUS	:	.852	.705	.604
MAX RADIUS	:	1.922	1.251	.984
HORIZONTAL SPREAD	:	2.763	1.489	1.489
VERTICAL SPREAD	:	2.022	2.022	1.428
EXTREME SPREAD	:	2.894	2.030	1.655
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

23 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8611511

CENTERFIRE PATTERNS # 3



OF SHOTS - 10

IN CIR

1 in = 1

2 in = 2

3 in = 6

HS = 3.098

VS = 3.724

GS = 3.967

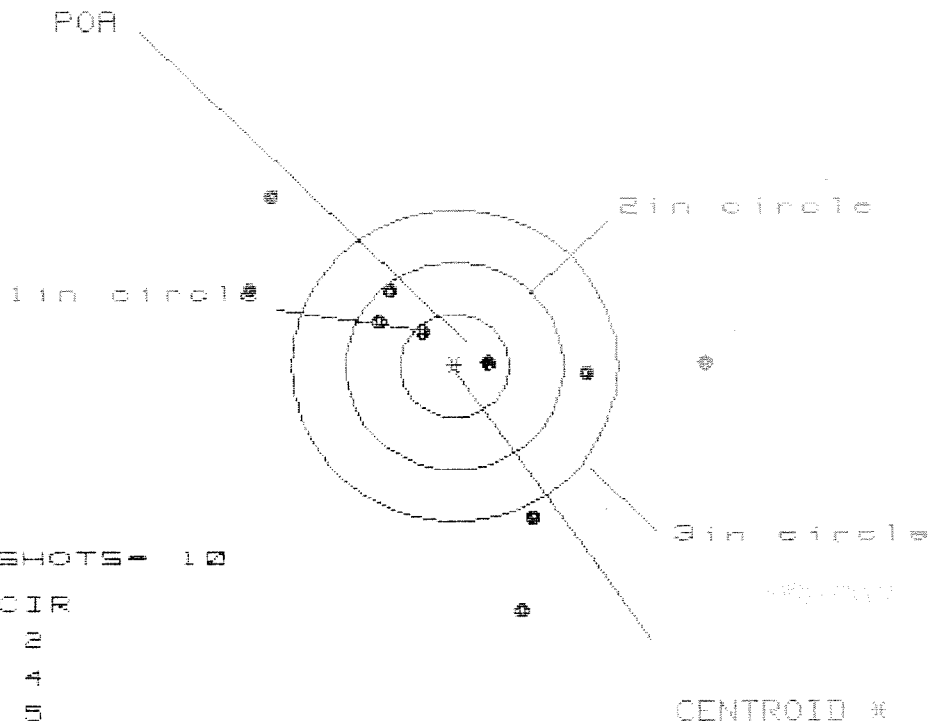
CENTROID #

PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	1.675
MINIMUM X	-1.423
MAXIMUM Y	1.908
MINIMUM Y	-1.816
CENTROID X	-0.219
CENTROID Y	-0.095
POA TO CENTROID in.	.238
MIN RADIUS	.353
MEAN RADIUS	1.355
MAX RADIUS	2.027
HORIZONTAL SPREAD	3.098
VERTICAL SPREAD	3.724
EXTREME SPREAD	3.967
NUMBER IN ONE INCH CIRCLE	1
NUMBER IN TWO INCH CIRCLE	2
NUMBER IN THREE INCH CIRCLE	6

23 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C661151J

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 2

2in = 4

3in = 5

HS= 4.261

VS= 3.988

GS= 4.579

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.355	2.420	1.613
MINIMUM X	:	-1.906	-1.841	-1.538
MAXIMUM Y	:	1.595	1.329	1.301
MINIMUM Y	:	-2.393	-1.734	-1.762
CENTROID X	:	-.307	-.372	-.675
CENTROID Y	:	-.034	.232	.260
POA TO CENTROID in.	:	.309	.438	.723
MIN RADIUS	:	.281	.263	.041
MEAN RADIUS	:	1.456	1.304	1.099
MAX RADIUS	:	2.464	2.431	2.060
HORIZONTAL SPREAD	:	4.261	4.261	3.151
VERTICAL SPREAD	:	3.988	3.063	3.063
EXTREME SPREAD	:	4.579	4.320	3.867
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		5	

23 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8611511

CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

OF SHOTS - 10

IN CIR

1in = 0

2in = 5

3in = 7

HS = 3.022

VS = 3.251

CS = 3.252

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.452	1.430	1.231
MINIMUM X	:	-1.570	-1.592	-.818
MAXIMUM Y	:	1.422	1.218	1.167
MINIMUM Y	:	-1.829	-1.064	-1.115
CENTROID X	:	.071	.093	.292
CENTROID Y	:	-.109	.095	.145
POA TO CENTROID in.	:	.130	.133	.326
MIN RADIUS	:	.568	.470	.588
MEAN RADIUS	:	1.190	1.076	1.003
MAX RADIUS	:	1.840	1.643	1.419
HORIZONTAL SPREAD	:	3.022	3.022	2.049
VERTICAL SPREAD	:	3.251	2.282	2.262
EXTREME SPREAD	:	3.252	3.030	2.588
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		7	