

C6611548

MODEL 700™ M24

Model SWS™

Action

Barrel Length

Capacity

Order No. 5716

\*Includes 1 in chamber.

*Remington*

## Arms Services Repair &amp; Estimate System

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

## Repair Inquiry

Repair Number: RE00146515

Serial: C6611548 Model M24 SWS Center Fire  
Caliber: 7.62 NATO

Repairman:

Verify Repair

Status:

Closed 6/17/2008 9:53:27 AM

## Address Information

Customer:

Received From

Return To:

Received From

Name: DEF DIST DEPOT

DEF DIST DEPOT

Address 1: 7 FRANKFORD AVE BLDG 362

7 FRANKFORD AVE BLDG 362

Address 2: PO Box:

PO Box:

City: ANNISTON

ANNISTON

State: AL

Zip Code: 36201

Country: US

State: AL

Zip Code: 36201

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   |
| 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

naglej

6/17/2008

10:51 AM

CAPS

NUM

INS

SCRL

start

10 M

My ...

4 M

Par...

Ar...

Cre...

My...

10:51 AM

Number: C6611548

Model: M24 SWS



RE00146515

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

|               |                 |  |  |  |
|---------------|-----------------|--|--|--|
| R & E NUMBER  | <u>146515</u>   |  |  |  |
| SERIAL NUMBER | <u>06611548</u> |  |  |  |
| LOG-IN DATE   | <u>6-17-08</u>  |  |  |  |

| OPERATION # | OPERATION NAME       | DATE                                                                                                                        | INITIAL                                                                           |                                                                                                                                                                                                                      |
|-------------|----------------------|-----------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| 500         | DIS-ASSEMBLE GUN     | 7-14-09                                                                                                                     | KTZ                                                                               |                                                                                                                                                                                                                      |
| 505         | RE-BARREL            | 7-16-09                                                                                                                     | KTZ                                                                               |                                                                                                                                                                                                                      |
| 420         | ASSEMBLE             | 7-16-09                                                                                                                     | KTZ                                                                               |                                                                                                                                                                                                                      |
| 440         | PROOF                | 7-16-09                                                                                                                     | RP                                                                                | <div style="border: 1px solid black; padding: 5px; width: fit-content; margin: 0 auto;"> MAGNA-FLUX<br/> 2009<br/> OPERATOR <span style="border: 1px solid black; border-radius: 50%; padding: 2px;">P</span> </div> |
| 460         | CHECK HEADSPACE      | 7-16-09                                                                                                                     | RP                                                                                |                                                                                                                                                                                                                      |
| 470         | DIS-ASSEMBLE GUN     | 7-16-09                                                                                                                     | RP                                                                                |                                                                                                                                                                                                                      |
| 480         | MAGNAFLUX            | 7/18/09                                                                                                                     | <span style="border: 1px solid black; border-radius: 50%; padding: 2px;">P</span> |                                                                                                                                                                                                                      |
| 510         | DRILL AND TAP        | 7-17-09                                                                                                                     | SP                                                                                |                                                                                                                                                                                                                      |
| 500         | ROLLMARK CALIBER     | 7-21-09                                                                                                                     | DCD                                                                               |                                                                                                                                                                                                                      |
| 520         | GOFF BLAST BBL / REC | 7-21-09                                                                                                                     | SP                                                                                |                                                                                                                                                                                                                      |
| 530 & 540   | APPLY COATINGS       | 7-28                                                                                                                        | -                                                                                 |                                                                                                                                                                                                                      |
| 560         | FINAL ASSEMBLY       | 7-31-09                                                                                                                     | KTZ                                                                               |                                                                                                                                                                                                                      |
| 640         | FUNCTION TEST AND    | 8-4-09                                                                                                                      | RP                                                                                | (PASS) FAIL                                                                                                                                                                                                          |
| 650         | TARGET               | 8-4-09                                                                                                                      | RP                                                                                | (PASS) FAIL                                                                                                                                                                                                          |
|             | MALFUNCTION          | CORRECTION                                                                                                                  |                                                                                   |                                                                                                                                                                                                                      |
|             | MALFUNCTION          | CORRECTION                                                                                                                  |                                                                                   | N/A                                                                                                                                                                                                                  |
|             | MALFUNCTION          | CORRECTION                                                                                                                  |                                                                                   |                                                                                                                                                                                                                      |
|             | MALFUNCTION          | CORRECTION                                                                                                                  | 8-4-09                                                                            | RP                                                                                                                                                                                                                   |
| 670         | FINAL INSPECTION     | 8-17-09                                                                                                                     | RP                                                                                |                                                                                                                                                                                                                      |
|             | A) HEADSPACE         | (PASS)                                                                                                                      | FAIL                                                                              | 8-17-09 RP                                                                                                                                                                                                           |
|             | B) TRIGGER PULL      | <div style="border: 1px solid black; padding: 2px; font-size: small;"> +/- .5 LBS<br/> MIN 2.50 LBS<br/> MAX 4.0 LBS </div> |                                                                                   | 2.47 2.50 2.46 2.58 2.45 8-7-09 LRP                                                                                                                                                                                  |
| 680         | F) SAFETY ON FORCE   | <div style="border: 1px solid black; padding: 2px; font-size: small;"> 2 LBS MIN<br/> 10 LBS MAX </div>                     | 2.4 2.4 2.2 8-17-09                                                               | RP                                                                                                                                                                                                                   |
|             | G) SAFETY OFF FORCE  | <div style="border: 1px solid black; padding: 2px; font-size: small;"> 2 LBS </div>                                         | 3.6 3.8 3.8 8-17-09                                                               | RP                                                                                                                                                                                                                   |
|             | I) FIRING PIN INDENT | <div style="border: 1px solid black; padding: 2px; font-size: small;"> .020 </div>                                          | .027 .027 .027 8-17-09                                                            | LRP                                                                                                                                                                                                                  |
| 690         | PACK                 |                                                                                                                             | 7/16/09                                                                           | En                                                                                                                                                                                                                   |

F006 REV 1/2009

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6611548.\_\_0  
FILE DATE AND TIME: 08/05/2009 06:17

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

|                                                             |       |
|-------------------------------------------------------------|-------|
| The Average X Centroid of the Five Target Set:              | 0.062 |
| The Average Y Centroid of the Five Target Set:              | 0.040 |
| The Average Point of Impact of the Five Target Set:         | 0.074 |
| The Average Mean Radius of the Five Target Set:             | 0.629 |
| The Distance from POA to Centroid Target #1:                | 0.192 |
| The Distance from Centroid Target #2 to Centroid Target #1: | 0.196 |
| The Distance from Centroid Target #3 to Centroid Target #1: | 0.171 |
| The Distance from Centroid Target #4 to Centroid Target #1: | 0.159 |
| The Distance from Centroid Target #5 to Centroid Target #1: | 0.180 |

SERIAL NUMBER: C6611548. \_\_0

TARGET NUMBER: 1

FILE DATE: 08/05/2009

FILE TIME: 06:17

X CENTROID: 0.192

Y CENTROID: -0.003

POA TO CENTROID: 0.192

HORZ SPREAD: 2.083

VERT SPREAD: 1.316

GROUP SPREAD: 2.461

MIN RADIUS: 0.137

MAX RADIUS: 1.592

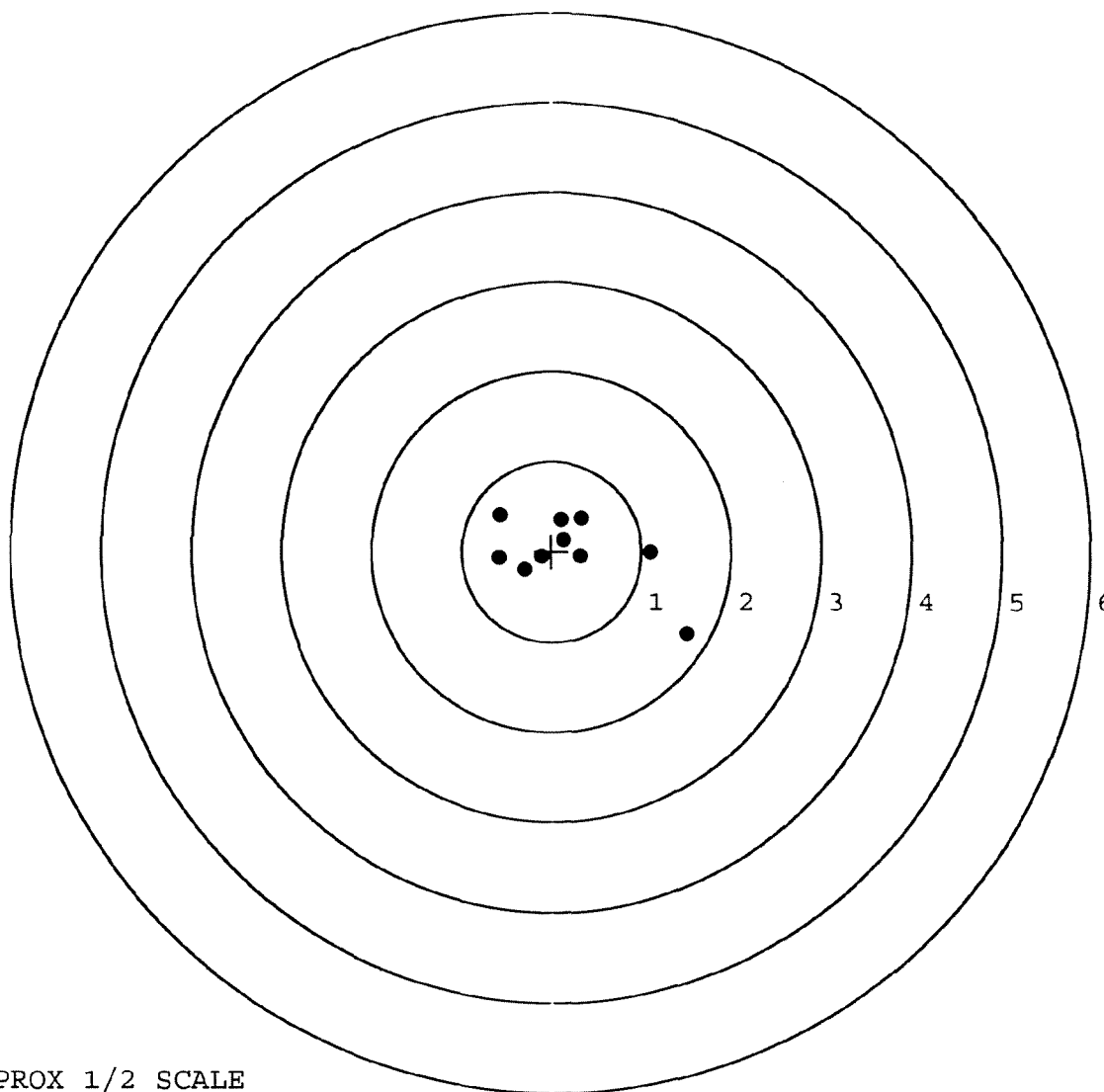
MEAN RADIUS: 0.605

# IN 1 IN DIAMETER: 5

# IN 2 IN DIAMETER: 9

# in 3 IN DIAMETER: 9

| POINT# | X      | Y      |
|--------|--------|--------|
| 1:     | -0.578 | 0.407  |
| 2:     | -0.582 | -0.072 |
| 3:     | -0.302 | -0.205 |
| 4:     | 1.501  | -0.909 |
| 5:     | 1.103  | -0.007 |
| 6:     | 0.330  | 0.377  |
| 7:     | 0.100  | 0.355  |
| 8:     | 0.322  | -0.048 |
| 9:     | 0.137  | 0.130  |
| 10:    | -0.108 | -0.057 |



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6611548. 0

TARGET NUMBER: 2

FILE DATE: 08/05/2009

FILE TIME: 06:17

X CENTROID: 0.001

Y CENTROID: 0.040

POA TO CENTROID: 0.040

HORZ SPREAD: 1.324

VERT SPREAD: 1.479

GROUP SPREAD: 1.780

MIN RADIUS: 0.166

MAX RADIUS: 1.022

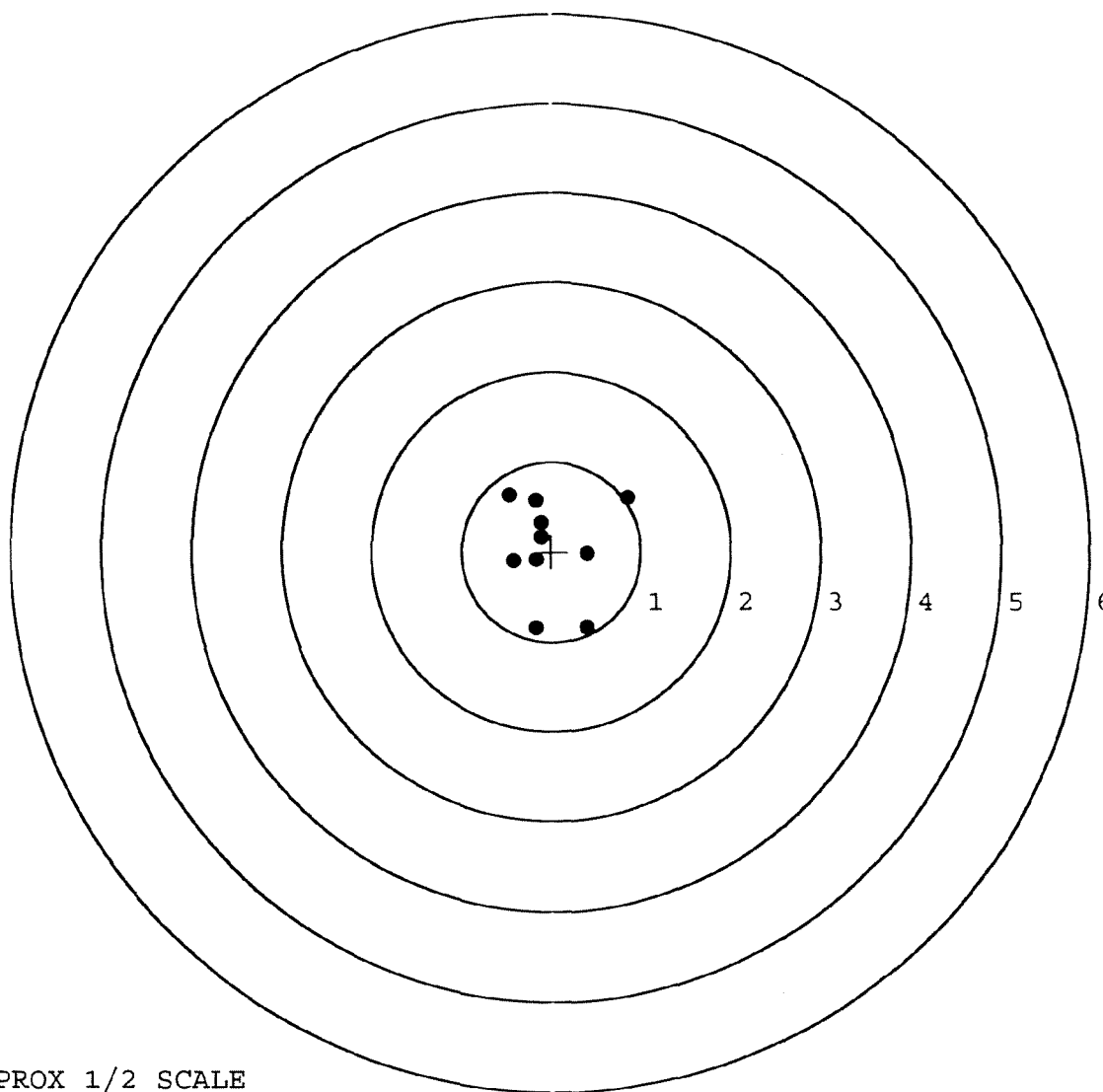
MEAN RADIUS: 0.574

# IN 1 IN DIAMETER: 5

# IN 2 IN DIAMETER: 9

# in 3 IN DIAMETER: 10

| POINT# | X      | Y      |
|--------|--------|--------|
| 1:     | 0.852  | 0.606  |
| 2:     | 0.402  | -0.014 |
| 3:     | 0.397  | -0.838 |
| 4:     | -0.176 | -0.847 |
| 5:     | -0.425 | -0.104 |
| 6:     | -0.169 | -0.087 |
| 7:     | -0.108 | 0.165  |
| 8:     | -0.472 | 0.632  |
| 9:     | -0.176 | 0.569  |
| 10:    | -0.113 | 0.320  |



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6611548. 0

TARGET NUMBER: 3

FILE DATE: 08/05/2009

FILE TIME: 06:17

X CENTROID: 0.062

Y CENTROID: 0.108

POA TO CENTROID: 0.124

HORZ SPREAD: 1.540

VERT SPREAD: 1.280

GROUP SPREAD: 1.815

MIN RADIUS: 0.128

MAX RADIUS: 1.098

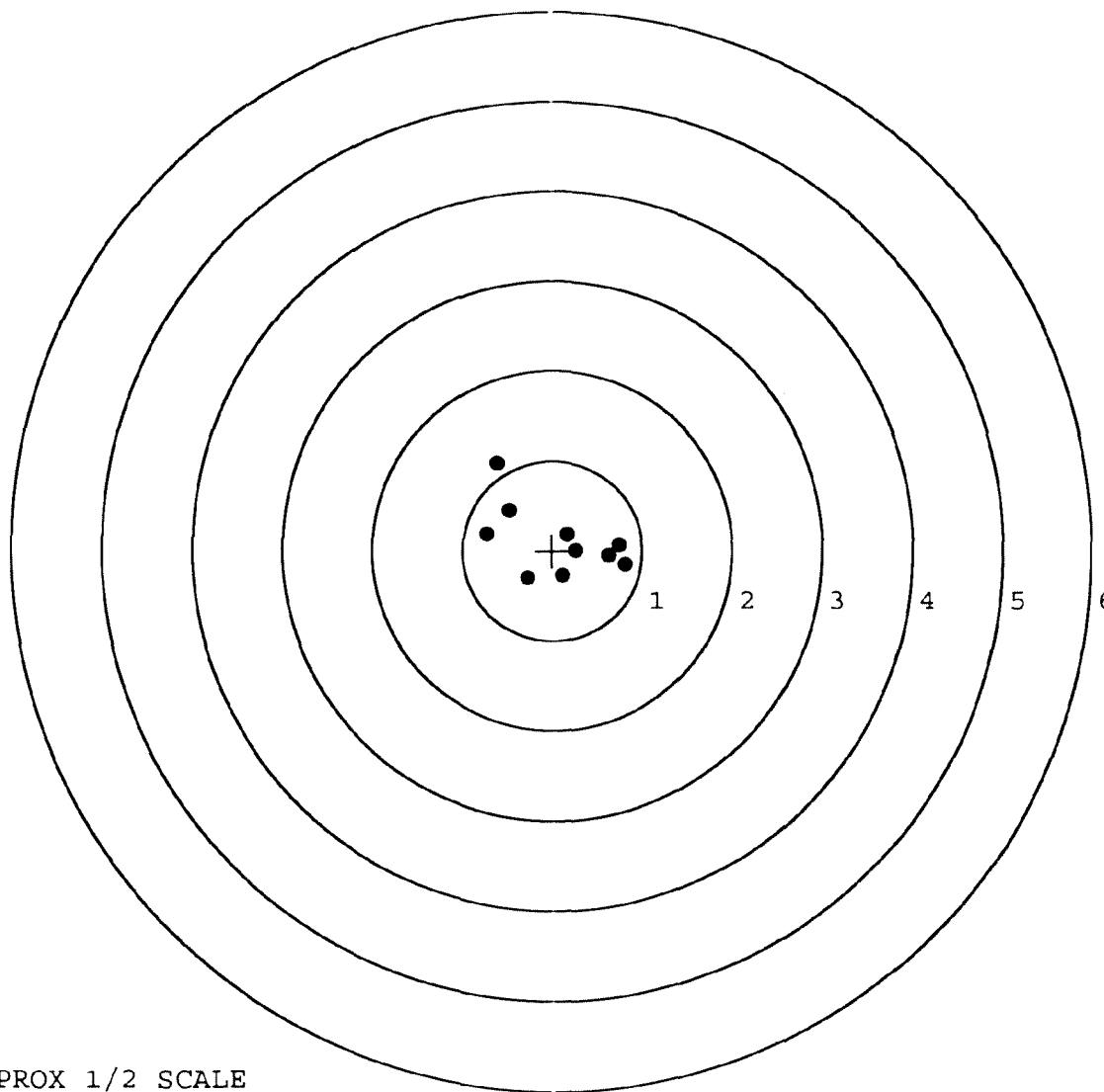
MEAN RADIUS: 0.587

# IN 1 IN DIAMETER: 3

# IN 2 IN DIAMETER: 9

# in 3 IN DIAMETER: 10

| POINT# | X      | Y      |
|--------|--------|--------|
| 1:     | -0.612 | 0.975  |
| 2:     | -0.482 | 0.450  |
| 3:     | -0.729 | 0.187  |
| 4:     | -0.279 | -0.305 |
| 5:     | 0.164  | 0.185  |
| 6:     | 0.114  | -0.275 |
| 7:     | 0.811  | -0.151 |
| 8:     | 0.627  | -0.050 |
| 9:     | 0.260  | -0.005 |
| 10:    | 0.741  | 0.068  |

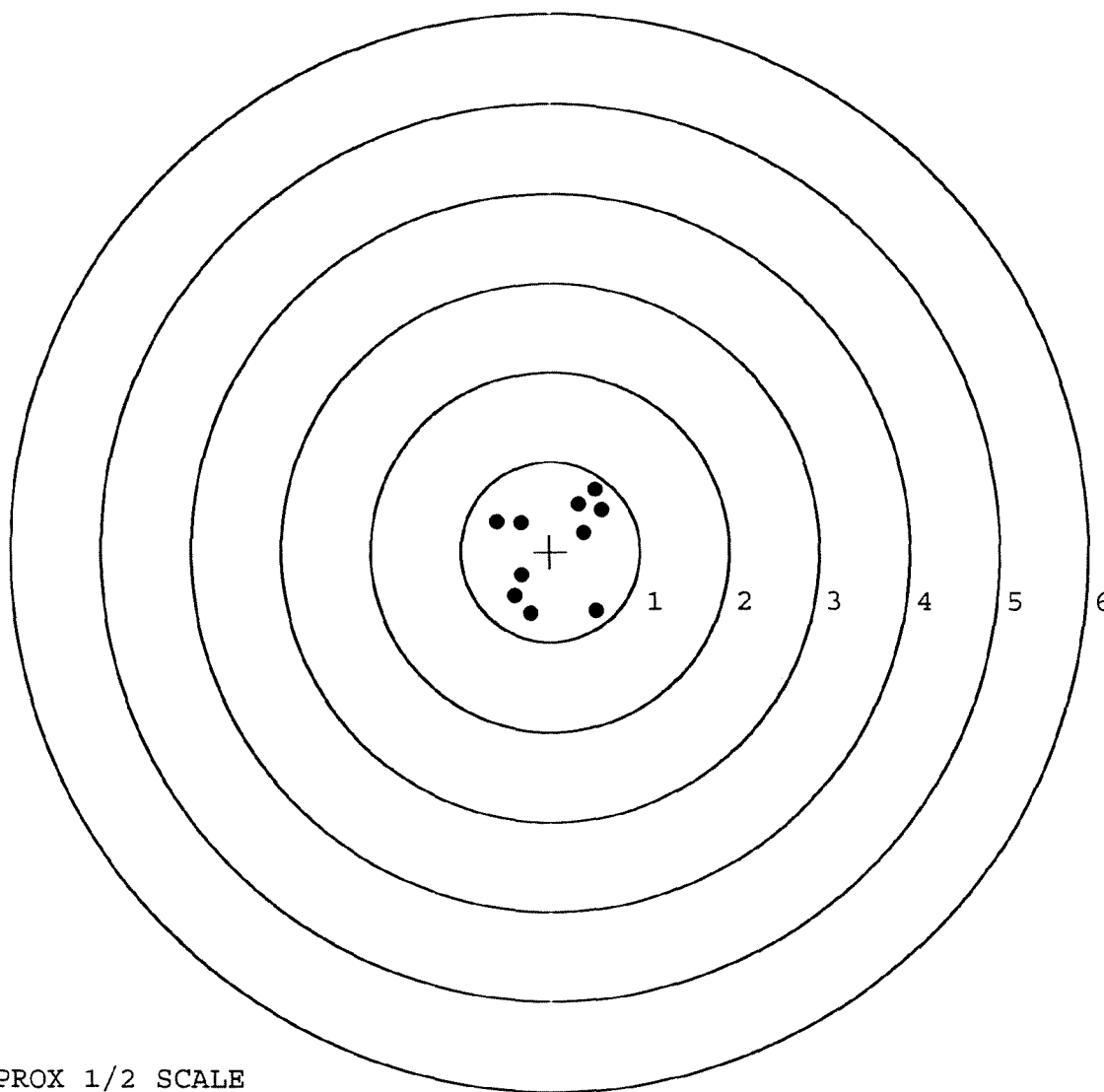


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6611548. \_\_0  
TARGET NUMBER: 4  
FILE DATE: 08/05/2009  
FILE TIME: 06:17

X CENTROID: 0.040  
Y CENTROID: 0.043  
POA TO CENTROID: 0.059  
HORZ SPREAD: 1.170  
VERT SPREAD: 1.383  
GROUP SPREAD: 1.477  
MIN RADIUS: 0.370  
MAX RADIUS: 0.841  
MEAN RADIUS: 0.635  
# IN 1 IN DIAMETER: 3  
# IN 2 IN DIAMETER: 10  
# in 3 IN DIAMETER: 10

| POINT# | X      | Y      |
|--------|--------|--------|
| 1:     | 0.508  | -0.655 |
| 2:     | -0.223 | -0.691 |
| 3:     | -0.401 | -0.503 |
| 4:     | -0.321 | -0.262 |
| 5:     | -0.595 | 0.328  |
| 6:     | -0.329 | 0.321  |
| 7:     | 0.500  | 0.692  |
| 8:     | 0.575  | 0.468  |
| 9:     | 0.314  | 0.522  |
| 10:    | 0.370  | 0.211  |

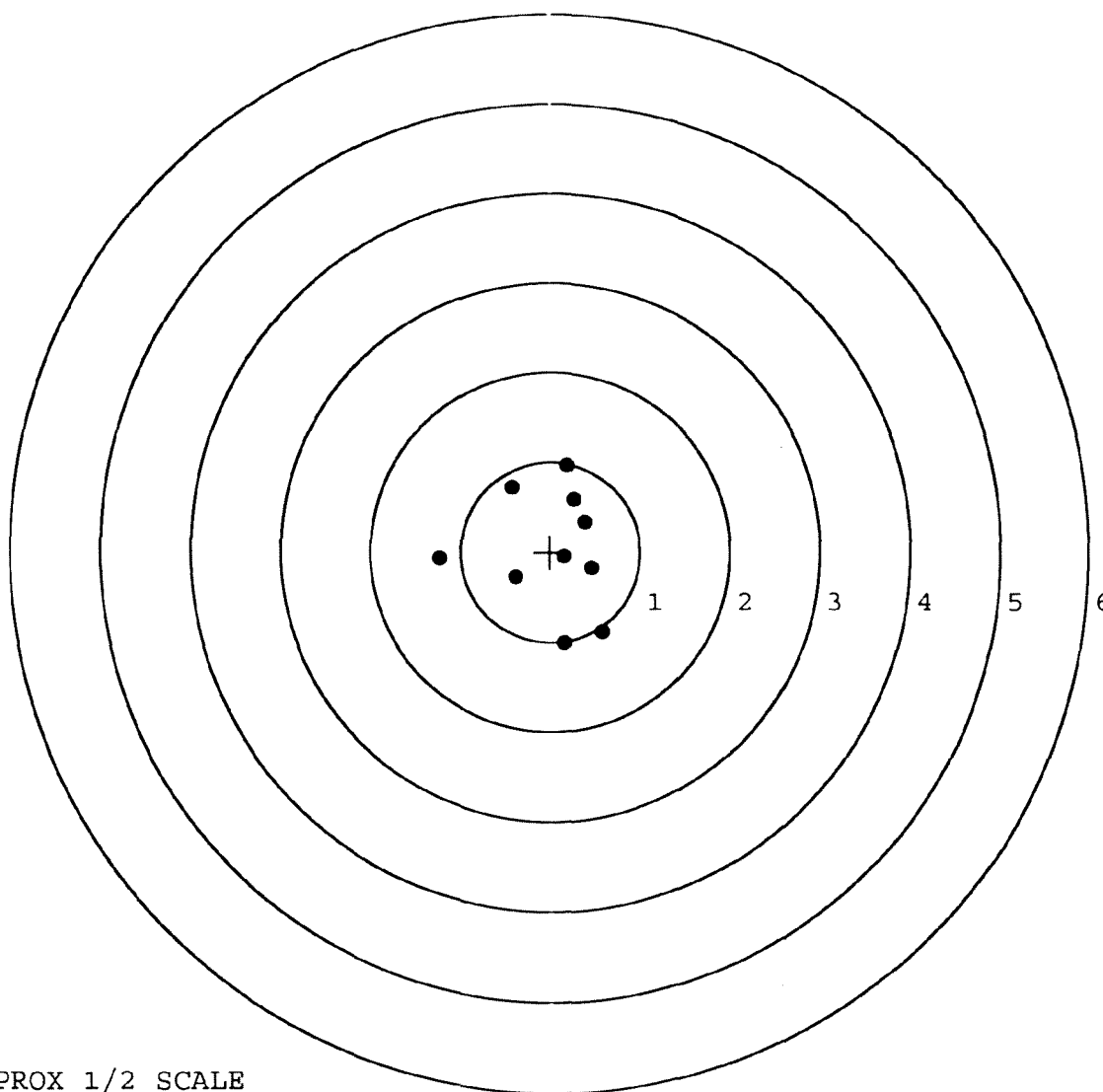


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6611548. 0  
TARGET NUMBER: 5  
FILE DATE: 08/05/2009  
FILE TIME: 06:17

X CENTROID: 0.013  
Y CENTROID: 0.013  
POA TO CENTROID: 0.018  
HORZ SPREAD: 1.811  
VERT SPREAD: 1.984  
GROUP SPREAD: 1.985  
MIN RADIUS: 0.157  
MAX RADIUS: 1.248  
MEAN RADIUS: 0.742  
# IN 1 IN DIAMETER: 4  
# IN 2 IN DIAMETER: 7  
# in 3 IN DIAMETER: 10

| POINT# | X      | Y      |
|--------|--------|--------|
| 1:     | 0.187  | 0.965  |
| 2:     | -0.431 | 0.723  |
| 3:     | -1.232 | -0.076 |
| 4:     | -0.389 | -0.278 |
| 5:     | 0.154  | -1.019 |
| 6:     | 0.579  | -0.889 |
| 7:     | 0.462  | -0.178 |
| 8:     | 0.158  | -0.049 |
| 9:     | 0.261  | 0.591  |
| 10:    | 0.383  | 0.337  |



TARGET APPROX 1/2 SCALE

**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: **RE00092983** Serial: **C6611548** Model: **M24 SWS** Center Fire  
 Caliber: **7.62 NATO** Produced: **06/10/1991** Repairman: Status: **Closed 2/11/2005 7:30:48 AM**

**Address Information**

Customer: ☐ Received From: ☒ Return ID: ☐ Received From: ☐

Name: **DEF DIST DEPOT ANNISTON** **DEF DIST DEPOT ANNISTON**

Address 1: Address 2: PO Box: PO Box:

City: **ANNISTON** **ANNISTON**

State: **AL** Zip Code: **36201 4199** Country: **US** State: **AL** Zip Code: **36201 4199** Country: **US**

FPL:

**Contact / Condition** **Problems** **Estimate** **History / Status** **Shipping / Billing**

**Contact Information**

Phone: Fax: Email: Comments:

**Received Condition**

Code: Condition Notes: CSR Notes:

**Accessories Received**

| Code | Desc                    | Qty |
|------|-------------------------|-----|
| A067 | With Stud               | 3   |
| A010 | Hard Case               | 1   |
| A017 | Scope Base              | 1   |
| A026 | Scope                   | 1   |
| A057 | Front and Rear Sgt Base | 1   |

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

nasleq 2/11/2005 8:11 AM TCAPS INDV JIN3 SCRL

start 5 2 3 Arms Service

Serial Number: **C6611548**

Model: **M24 SWS**



**RE00092983**

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6611548.\_\_0  
FILE DATE AND TIME: 02/21/2005 09:13

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

|                                                             |        |
|-------------------------------------------------------------|--------|
| The Average X Centroid of the Five Target Set:              | -0.008 |
| The Average Y Centroid of the Five Target Set:              | -0.019 |
| The Average Point of Impact of the Five Target Set:         | 0.020  |
| The Average Mean Radius of the Five Target Set:             | 0.727  |
| The Distance from POA to Centroid Target #1:                | 0.064  |
| The Distance from Centroid Target #2 to Centroid Target #1: | 0.164  |
| The Distance from Centroid Target #3 to Centroid Target #1: | 0.036  |
| The Distance from Centroid Target #4 to Centroid Target #1: | 0.203  |
| The Distance from Centroid Target #5 to Centroid Target #1: | 0.170  |

SERIAL NUMBER: C6611548. 0

TARGET NUMBER: 1

FILE DATE: 02/21/2005

FILE TIME: 09:13

X CENTROID: 0.046

Y CENTROID: 0.044

POA TO CENTROID: 0.064

HORZ SPREAD: 1.182

VERT SPREAD: 3.115

GROUP SPREAD: 3.237

MIN RADIUS: 0.387

MAX RADIUS: 1.772

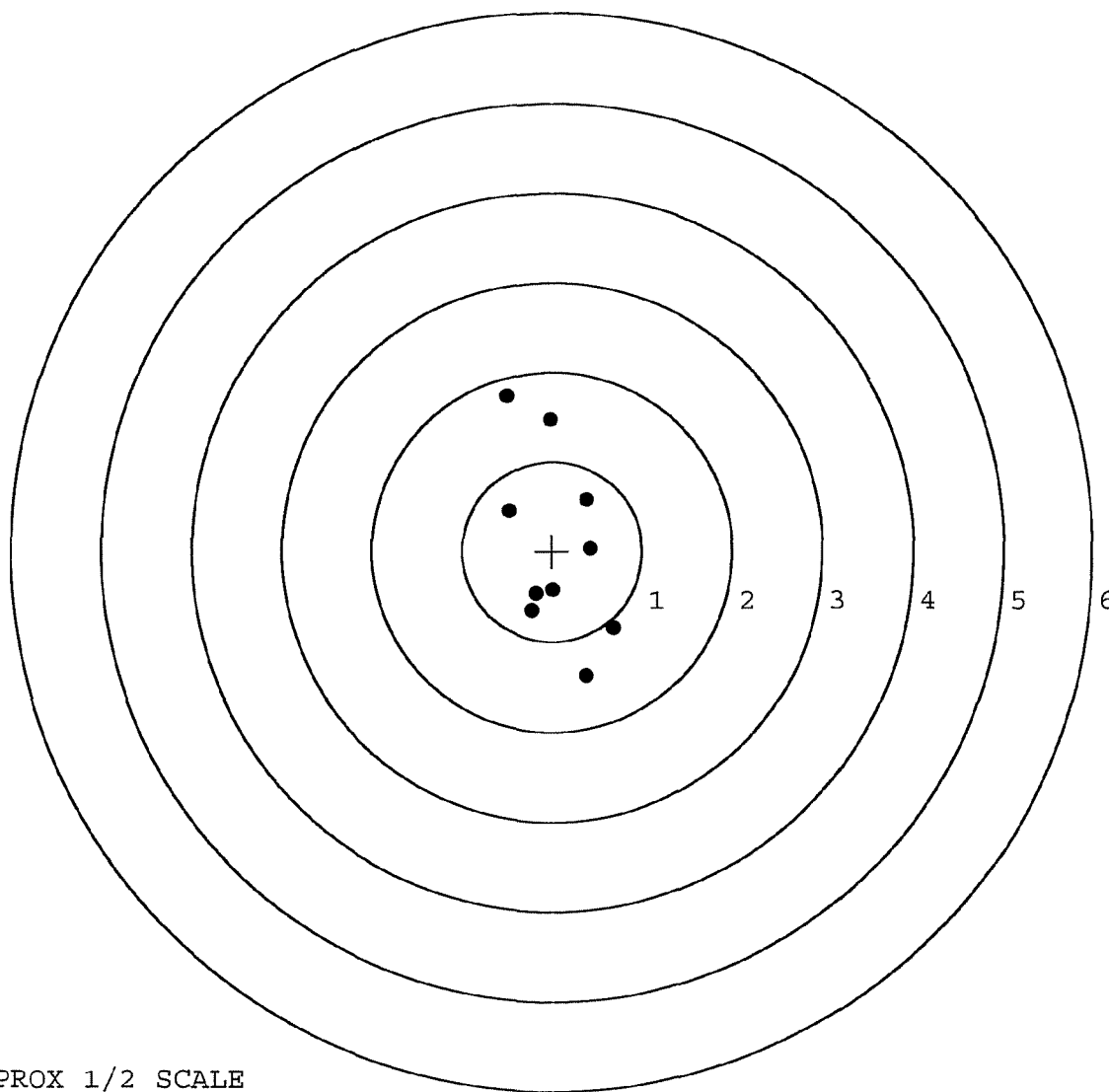
MEAN RADIUS: 0.926

# IN 1 IN DIAMETER: 2

# IN 2 IN DIAMETER: 6

# in 3 IN DIAMETER: 9

| POINT# | X      | Y      |
|--------|--------|--------|
| 1:     | 0.379  | -1.386 |
| 2:     | 0.679  | -0.857 |
| 3:     | 0.433  | 0.031  |
| 4:     | 0.385  | 0.577  |
| 5:     | -0.484 | 0.449  |
| 6:     | -0.023 | 1.472  |
| 7:     | -0.503 | 1.729  |
| 8:     | 0.009  | -0.434 |
| 9:     | -0.184 | -0.475 |
| 10:    | -0.228 | -0.661 |



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6611548. \_\_0

TARGET NUMBER: 2

FILE DATE: 02/21/2005

FILE TIME: 09:13

X CENTROID: -0.020

Y CENTROID: -0.105

POA TO CENTROID: 0.107

HORZ SPREAD: 1.246

VERT SPREAD: 1.720

GROUP SPREAD: 1.756

MIN RADIUS: 0.309

MAX RADIUS: 1.042

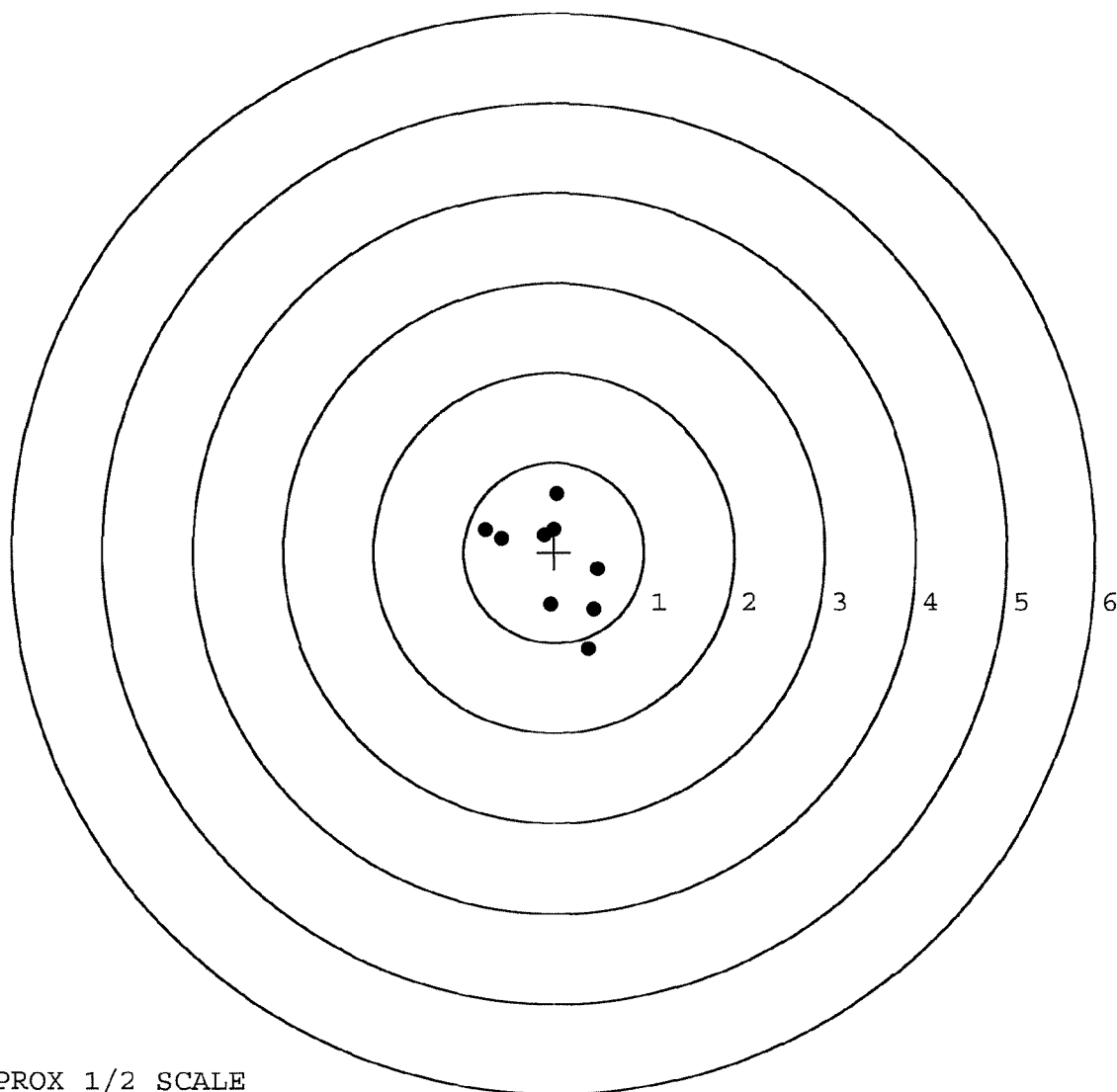
MEAN RADIUS: 0.623

# IN 1 IN DIAMETER: 3

# IN 2 IN DIAMETER: 8

# in 3 IN DIAMETER: 9

| POINT# | X      | Y      |
|--------|--------|--------|
| 1:     | 0.028  | 0.653  |
| 2:     | -0.004 | 0.259  |
| 3:     | -0.110 | 0.190  |
| 4:     | -0.591 | 0.155  |
| 5:     | -0.761 | 0.254  |
| 6:     | -0.043 | -0.583 |
| 7:     | 0.382  | -1.067 |
| 8:     | 0.435  | -0.628 |
| 9:     | 0.485  | -0.180 |



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6611548. \_\_0

TARGET NUMBER: 3

FILE DATE: 02/21/2005

FILE TIME: 09:13

X CENTROID: 0.044

Y CENTROID: 0.080

POA TO CENTROID: 0.092

HORZ SPREAD: 2.421

VERT SPREAD: 1.437

GROUP SPREAD: 2.450

MIN RADIUS: 0.200

MAX RADIUS: 1.573

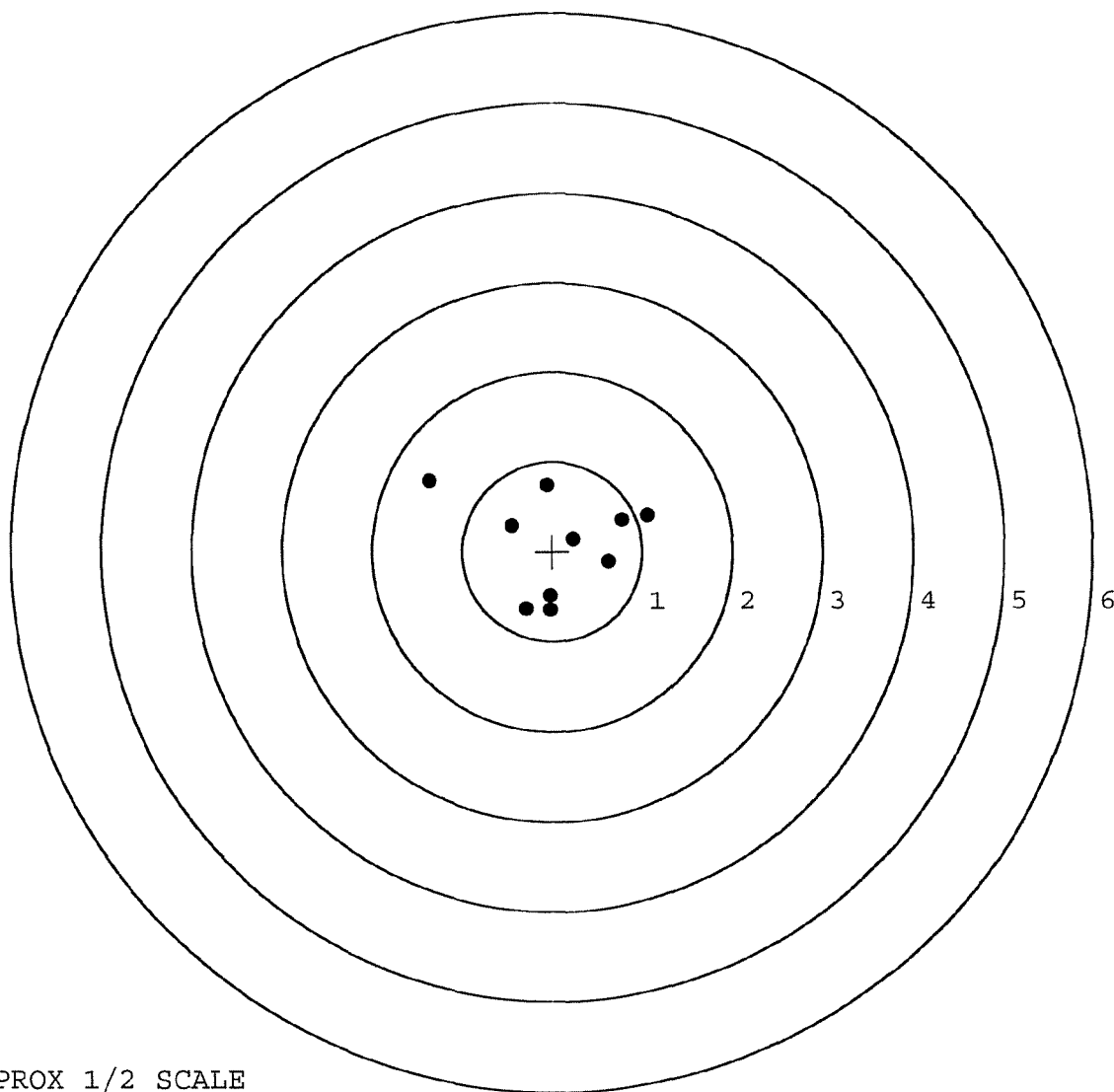
MEAN RADIUS: 0.755

# IN 1 IN DIAMETER: 1

# IN 2 IN DIAMETER: 8

# in 3 IN DIAMETER: 9

| POINT# | X      | Y      |
|--------|--------|--------|
| 1:     | 1.057  | 0.405  |
| 2:     | 0.625  | -0.110 |
| 3:     | 0.234  | 0.143  |
| 4:     | -0.063 | 0.738  |
| 5:     | -0.454 | 0.287  |
| 6:     | -1.364 | 0.780  |
| 7:     | -0.028 | -0.497 |
| 8:     | -0.033 | -0.657 |
| 9:     | -0.298 | -0.642 |
| 10:    | 0.768  | 0.356  |

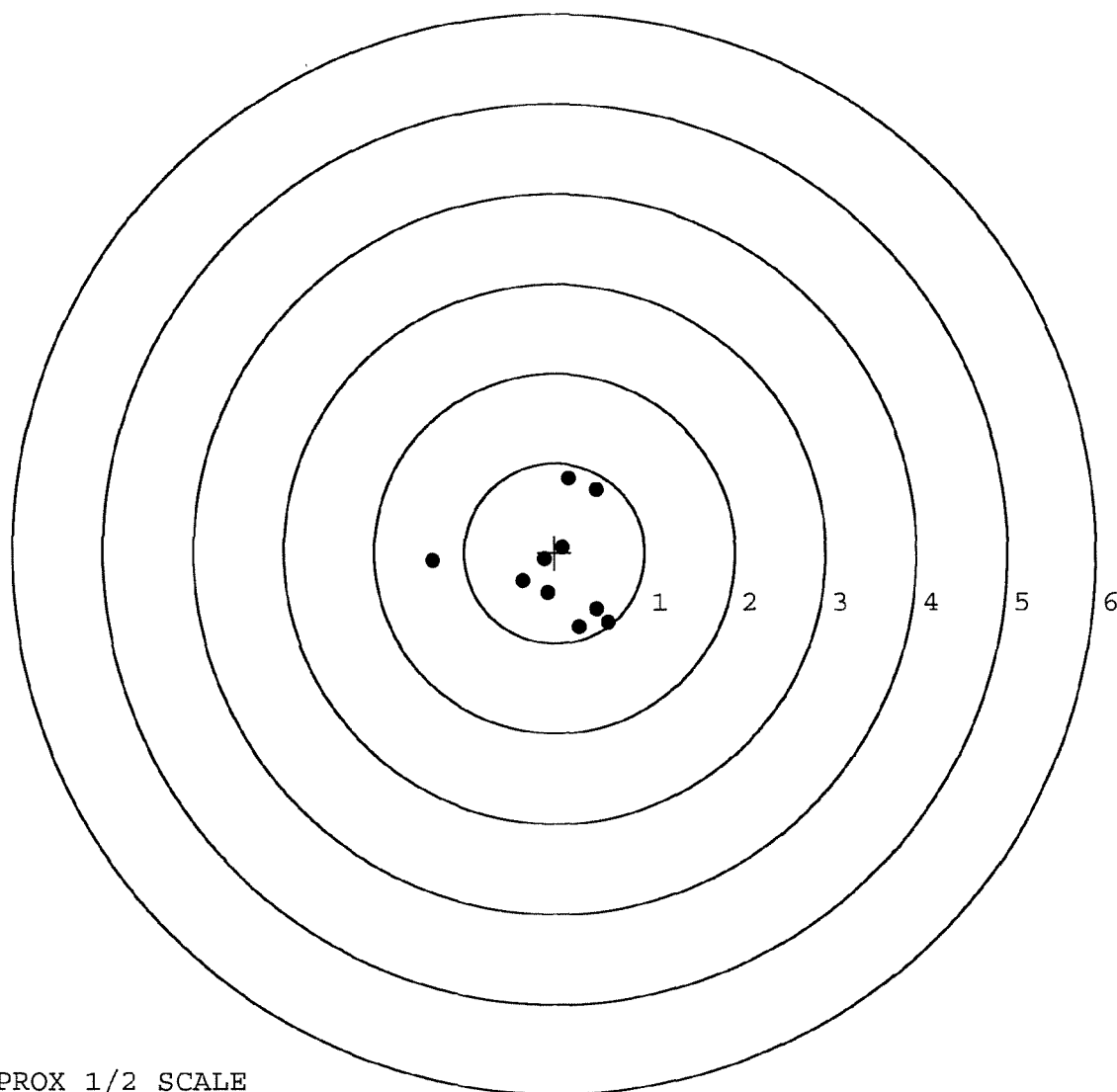


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6611548. \_\_0  
TARGET NUMBER: 4  
FILE DATE: 02/21/2005  
FILE TIME: 09:13

X CENTROID: 0.012  
Y CENTROID: -0.155  
POA TO CENTROID: 0.156  
HORZ SPREAD: 1.943  
VERT SPREAD: 1.653  
GROUP SPREAD: 2.058  
MIN RADIUS: 0.152  
MAX RADIUS: 1.366  
MEAN RADIUS: 0.664  
# IN 1 IN DIAMETER: 4  
# IN 2 IN DIAMETER: 9  
# in 3 IN DIAMETER: 10

| POINT# | X      | Y      |
|--------|--------|--------|
| 1:     | 0.465  | 0.706  |
| 2:     | 0.157  | 0.832  |
| 3:     | 0.089  | 0.059  |
| 4:     | -1.353 | -0.096 |
| 5:     | -0.118 | -0.077 |
| 6:     | -0.358 | -0.314 |
| 7:     | -0.085 | -0.449 |
| 8:     | 0.464  | -0.621 |
| 9:     | 0.590  | -0.773 |
| 10:    | 0.271  | -0.821 |



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6611548. 0

TARGET NUMBER: 5

FILE DATE: 02/21/2005

FILE TIME: 09:13

X CENTROID: -0.124

Y CENTROID: 0.042

POA TO CENTROID: 0.131

HORZ SPREAD: 2.244

VERT SPREAD: 1.825

GROUP SPREAD: 2.822

MIN RADIUS: 0.189

MAX RADIUS: 2.065

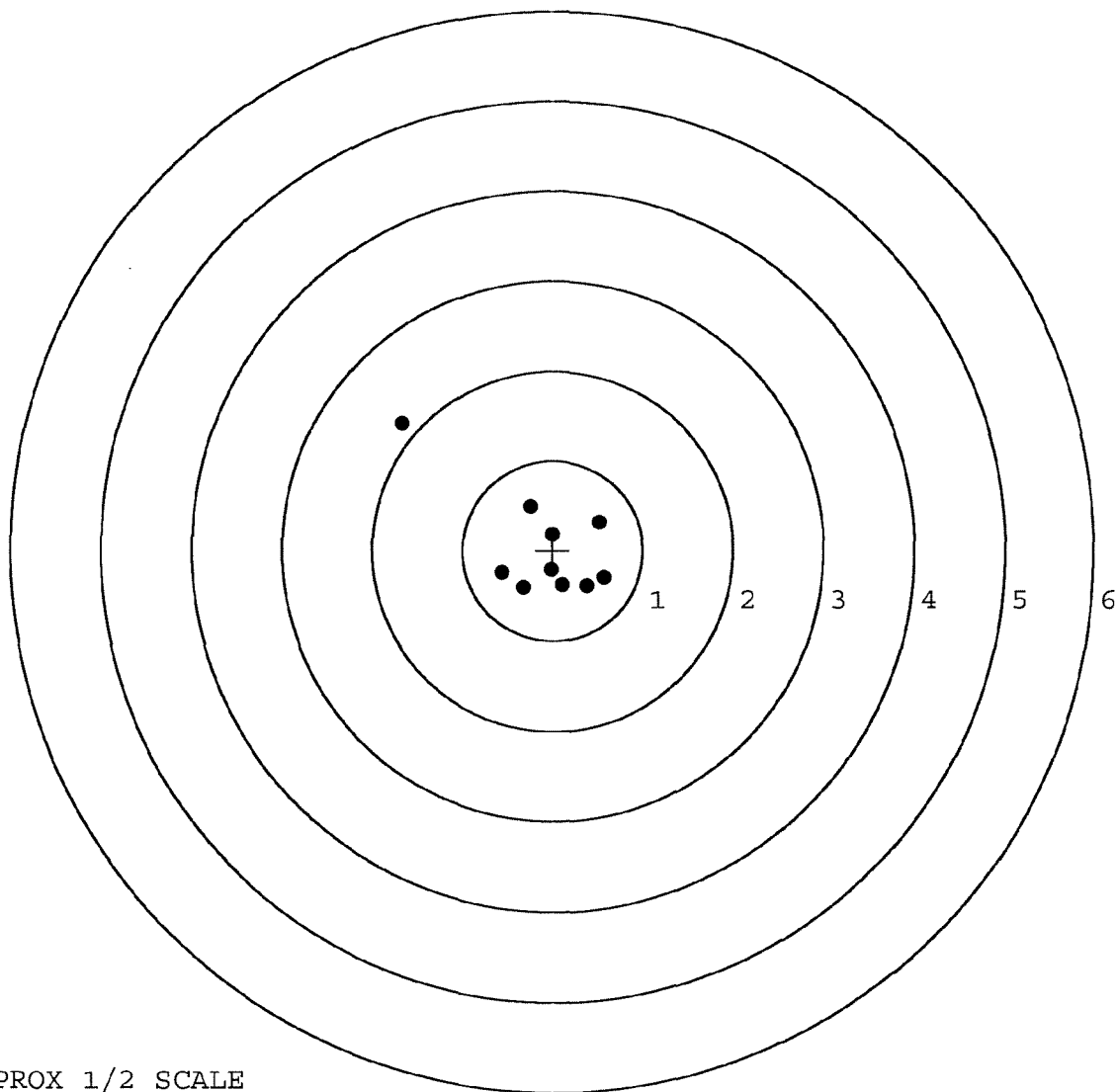
MEAN RADIUS: 0.666

# IN 1 IN DIAMETER: 4

# IN 2 IN DIAMETER: 9

# in 3 IN DIAMETER: 9

| POINT# | X      | Y      |
|--------|--------|--------|
| 1:     | 0.519  | 0.314  |
| 2:     | 0.006  | 0.179  |
| 3:     | -0.247 | 0.488  |
| 4:     | -1.671 | 1.411  |
| 5:     | 0.573  | -0.301 |
| 6:     | 0.380  | -0.394 |
| 7:     | 0.112  | -0.389 |
| 8:     | -0.329 | -0.414 |
| 9:     | -0.564 | -0.249 |
| 10:    | -0.020 | -0.220 |



TARGET APPROX 1/2 SCALE

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

|                            |                    |                     |         |
|----------------------------|--------------------|---------------------|---------|
| R & E NUMBER               | 92983              |                     |         |
| SERIAL NUMBER              | C6611548           |                     |         |
| LOG-IN DATE                | 2-11-05            |                     |         |
| <b>INSPECT AND VERIFY:</b> |                    |                     |         |
| OPERATION #                | OPERATION NAME     | DATE                | INITIAL |
| 550                        | DIS-ASSEMBLE GUN   |                     |         |
| 560 A                      | RE-BARREL          |                     |         |
| B                          | DRILL AND TAP      |                     |         |
| 575                        | ASSEMBLE           |                     |         |
| 600                        | PROOF              |                     |         |
| 605                        | CHECK HEADSPACE    |                     |         |
| 610                        | DIS-ASSEMBLE GUN   |                     |         |
| 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 | 3-9-05              | AC      |
| E                          | FIRING PIN INDENT  | 3-9-05              | 3-9-05  |
| 640                        | TARGET             | 2-21-05             | TRW     |
| 655                        | FINAL INSPECT      | 3-9-05              | AC      |
| 660                        | PACK               | 3-11-05             | DA      |
|                            |                    | SHIP DATE           |         |
|                            |                    | QAR INSPECTION DATE |         |

**Remington®**



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

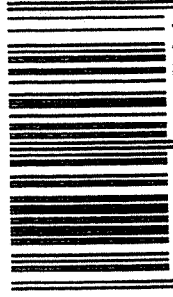
**MODEL 700™ H24**

|                                                                                       |          |
|---------------------------------------------------------------------------------------|----------|
| MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee. |          |
| 46                                                                                    |          |
| SERIAL NO.                                                                            | C6611548 |
| ORDER NO.                                                                             | 5716     |



5716 C6611548

**UPC**



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6611548

| OP. #        | OP. NAME                                                       | READINGS | DATE    | INIT          |
|--------------|----------------------------------------------------------------|----------|---------|---------------|
| 575 &<br>580 | Assemble Action<br>and Stock                                   | 2 1      | 5 1     | RW            |
| 600          | Proof                                                          | 2 1      | 9 1     | RW            |
| 607          | Check Headspace                                                | 2 1      | 9 1     | RW            |
| 610          | Dis-assemble Gun                                               | 2 1      | 9 1     | RW            |
| 612          | Magnaflux Barrel<br>Action                                     | 2 1 1    | 9 1     | Ked           |
|              | Magnaflux Bolt                                                 | 2 1 1    | 9 1     | Ked           |
| 615          | Rollmark Caliber                                               | 2 1 1    | 9 1     | ES            |
| 617          | Drill and Tap Sight Holes                                      | 2 1 3    | 9 1     | EB            |
| 618          | Polish Barrel <i>ABB</i>                                       | 2 1 3    | 9 1     | WB            |
| 620          | Apply Coatings<br>(Barrel Action)                              |          | 3/24/91 | <del>WB</del> |
|              | Apply Coating (Bolt)                                           |          |         | <del>WB</del> |
| 625          | Final Assembly<br>A) Clean inside of<br>Bolt Assembly          |          | 3/24/91 | WB            |
|              | B) Inspect Rear Firing<br>Pin Hole for Chamfer<br>in Bolt Head |          | 3/24/91 | WB            |
|              | C) Inspect Ejector Hole<br>for Chamfer                         |          | 3/25/91 | WB            |
|              | D) Oil Firing Pin Ass'y                                        |          | 3/25/91 | WB            |
|              | E) Adjust Trigger Pull to<br>Min Setting and Stake             |          | 4/8/91  | JL            |

| op. #        | OP. NAME                                                    | READINGS |                 |                 |      |      | DATE    | INIT |
|--------------|-------------------------------------------------------------|----------|-----------------|-----------------|------|------|---------|------|
| 625<br>cont. | F) Safety On Force                                          | 5        | 5 $\frac{1}{4}$ | 5               |      |      | 4-10-91 | DH   |
|              | G) Safety Off Force                                         | 3        | 3               | 2 $\frac{1}{4}$ |      |      | 4-10-91 | DH   |
|              | H) Trigger Pull Test & Retainability                        |          |                 |                 |      |      | 4/8/91  | JH   |
|              | I) Firing Pin Indent                                        | .021     | .022            | .023            |      |      | 4-10-91 | DH   |
|              | J) Assemble Stock                                           |          |                 |                 |      |      | 4/10/91 | RW   |
|              | K) Assemble Swivel Studs                                    |          |                 |                 |      |      | 4-16-91 | AC   |
|              | L) Attach Front and Rear Sight Assemblies                   |          |                 |                 |      |      | 4/10/91 | RW   |
|              | M) Iron Sight Alignment                                     |          |                 |                 |      |      | 4/10/91 | RW   |
|              | N) Detach Front & Rear Sights & place in numbered container |          |                 |                 |      |      | 4/10/91 | RW   |
|              | O) Attach Scope to Rifle                                    |          |                 |                 |      |      | 4/10/91 | RW   |
|              | P) Detach & Attach Scope 20 Times                           |          |                 |                 |      |      | 4/10/91 | RW   |
| 640          | Gallery Target & Test                                       |          |                 |                 |      |      | 4-11-91 | DH   |
|              | A) Time                                                     |          |                 |                 |      |      | 4-11-91 | DH   |
|              | B) Malfunctions                                             |          |                 |                 |      |      | 4-11-91 | DH   |
|              | C) Pierced Primers                                          |          |                 |                 |      |      | 4-11-91 | DH   |
|              | D) Optical Clarity of Scope                                 |          |                 |                 |      |      | 4-11-91 | DH   |
| 645          | Inspect for Live Ammo                                       |          |                 |                 |      |      | 4-11-91 | DH   |
| 655          | Final Inspection                                            |          |                 |                 |      |      |         |      |
|              | A) Headspace                                                |          |                 |                 |      |      | 4-16-91 | AC   |
|              | B) Trigger Pull                                             | 2.21     | 2.23            | 2.21            | 2.24 | 2.20 | 4/16/91 | JH   |
|              | C) Function                                                 |          |                 |                 |      |      | 4-16-91 | AC   |
| 660          | Pack                                                        |          |                 |                 |      |      | 6-17-91 | N    |

SWS TRIGGER PULL TEST

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

SERIAL NO. C-6611548DATE 4/8/91TESTER JH

|         | 2.50#<br>INITIAL | 2.50# AFTER<br>50 CYCLES | FINAL TEST &<br>TO RESET 2.50# |      | COMMENTS                                                               |
|---------|------------------|--------------------------|--------------------------------|------|------------------------------------------------------------------------|
| PULL #1 | 2.50             | 2.48                     | 2.43                           | 2.27 | MIN. SETTING,<br>NO AVG. OF 5<br>READINGS ACCEPT-<br>ABLE LESS THAN 2# |
| PULL #2 | 2.41             | 2.44                     | 2.38                           | 2.23 |                                                                        |
| PULL #3 | 2.34             | 2.47                     | 2.46                           | 2.21 |                                                                        |
| PULL #4 | 2.36             | 2.42                     | 2.32                           | 2.26 |                                                                        |
| PULL #5 | 2.37             | 2.39                     | 2.39                           | 2.20 |                                                                        |
| TOTAL   |                  |                          |                                |      |                                                                        |
| AVG.    |                  |                          |                                |      |                                                                        |

|         | 3.00#<br>INITIAL | 3.00# AFTER<br>20 CYCLES |  | COMMENTS |
|---------|------------------|--------------------------|--|----------|
| PULL #1 | 3.43             | 3.22                     |  |          |
| PULL #2 | 3.53             | 3.15                     |  |          |
| PULL #3 | 3.32             | 3.23                     |  |          |
| PULL #4 | 3.53             | 3.20                     |  |          |
| PULL #5 | 3.50             | 3.37                     |  |          |
| TOTAL   |                  |                          |  |          |
| AVG.    |                  |                          |  |          |

|         | 4.00#<br>INITIAL | 4.00# AFTER<br>20 CYCLES | MAX SETTING<br>GREATER THAN 4# | RESET TO 4# FOR<br>TARGET & ACCURACY |
|---------|------------------|--------------------------|--------------------------------|--------------------------------------|
| PULL #1 | 4.34             | 4.41                     |                                | 4.42                                 |
| PULL #2 | 4.23             | 4.37                     |                                | 4.43                                 |
| PULL #3 | 4.20             | 4.35                     |                                | 4.48                                 |
| PULL #4 | 4.42             | 4.35                     |                                | 4.48                                 |
| PULL #5 | 4.38             | 4.42                     |                                | 4.21                                 |
| TOTAL   |                  |                          |                                |                                      |
| AVG.    |                  |                          |                                |                                      |

CENTROIDAL DISTANCE CALCULATIONS  
FOR RIFLE # C6611548  
11 Apr 1991

CENTROIDAL DISTANCES

|        |         |
|--------|---------|
| 0 TO 1 | .511681 |
| 1 TO 2 | .684726 |
| 1 TO 3 | .316223 |
| 1 TO 4 | .428664 |
| 1 TO 5 | .264462 |

5.4  
2131 <----POA

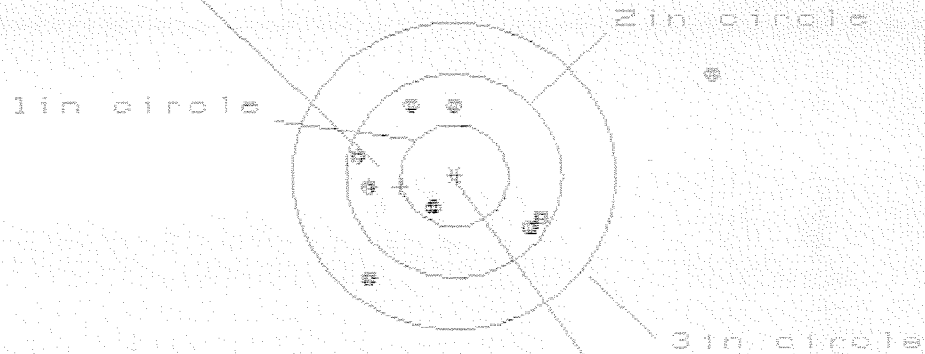
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .3208  
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1566  
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .356982  
THE AMR FOR THIS RIFLE IS: .9804

17 Apr 1991

FILE:/PATTERNING/CENTERFIRE\_PATT/C6B11548

# CENTERFIRE PATTERNS # 1

POA



# OF SHOTS= 10

# IN CIR

1in = 1

2in = 8

3in = 1

HS= 3.333

VS= 1.933

GS= 3.796

CENTROID #

PATTERN #

:



SHOTS (BEST OF)

:

10

9

8

MAXIMUM X

:

2.443

1.078

1.009

MINIMUM X

:

-.890

-.619

-.689

MAXIMUM Y

:

.949

.823

.714

MINIMUM Y

:

-.984

-.879

-.552

CENTROID X

:

.501

.230

.299

CENTROID Y

:

.104

-.001

.108

POA TO CENTROID in.

:

.512

.230

.318

MIN RADIUS

:

.430

.248

.359

MEAN RADIUS

:

1.024

.775

.748

MAX RADIUS

:

2.621

1.112

1.086

HORIZONTAL SPREAD

:

3.333

1.697

1.697

VERTICAL SPREAD

:

1.933

1.782

1.266

EXTREME SPREAD

:

3.796

1.907

1.788

NUMBER IN ONE INCH CIRCLE = 1

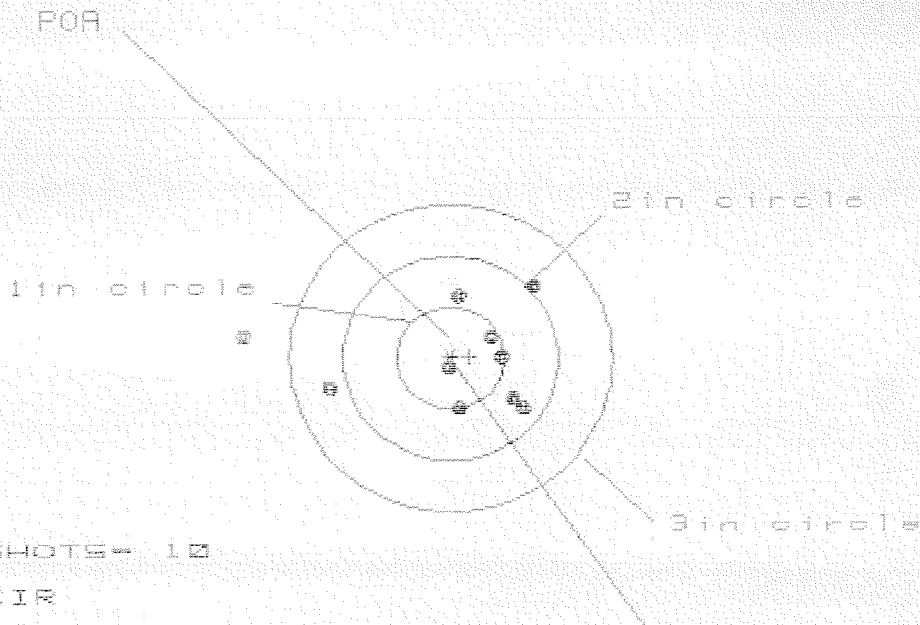
NUMBER IN TWO INCH CIRCLE = 8

NUMBER IN THREE INCH CIRCLE = 9

11 Apr 1991

FILE:/PATTERNING/CENTERFIRE\_PATT/C8611548

# CENTERFIRE PATTERNS # 2



# OF SHOTS = 10

# IN CIR

1in = 4

2in = 7

3in = 9

HS = 2.732

VS = 1.162

GS = 2.767

PATTERN #

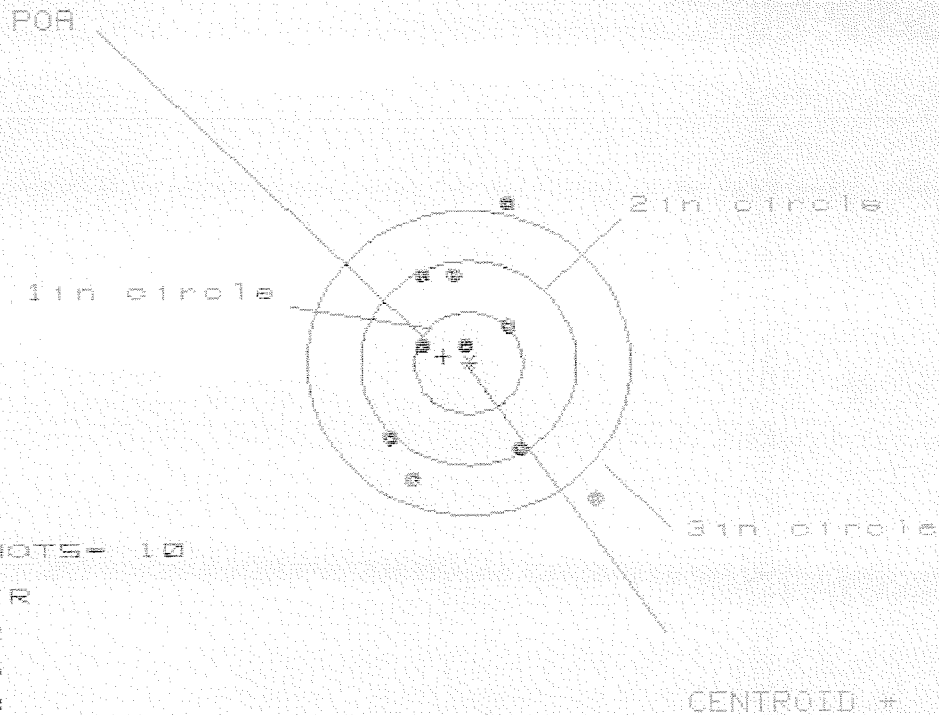
2

| SHOTS (BEST OF)             | 10     | 9      | 8     |
|-----------------------------|--------|--------|-------|
| MAXIMUM X                   | .773   | .555   | .390  |
| MINIMUM X                   | -1.959 | -1.319 | -.371 |
| MAXIMUM Y                   | .689   | .717   | .680  |
| MINIMUM Y                   | -.473  | -.445  | -.481 |
| CENTROID X                  | -.174  | .044   | .209  |
| CENTROID Y                  | -.011  | -.040  | -.003 |
| FOR TO CENTROID in.         | .174   | .059   | .209  |
| MIN RADIUS                  | .134   | .232   | .101  |
| MEAN RADIUS                 | .780   | .588   | .464  |
| MAX RADIUS                  | 1.976  | 1.350  | .784  |
| HORIZONTAL SPREAD           | 2.732  | 1.874  | .761  |
| VERTICAL SPREAD             | 1.162  | 1.162  | 1.162 |
| EXTREME SPREAD              | 2.767  | 2.126  | 1.346 |
| NUMBER IN ONE INCH CIRCLE   | =      | 4      |       |
| NUMBER IN TWO INCH CIRCLE   | =      | 7      |       |
| NUMBER IN THREE INCH CIRCLE | =      | 9      |       |

11 Apr 1991

FILE:/PATTERNING/CENTERFIRE\_PATT/C8611548

# CENTERFIRE PATTERNS # 3



# OF SHOTS = 10

# IN CIR

1in = 2

2in = 6

3in = 8

HS = 1.945

VS = 2.852

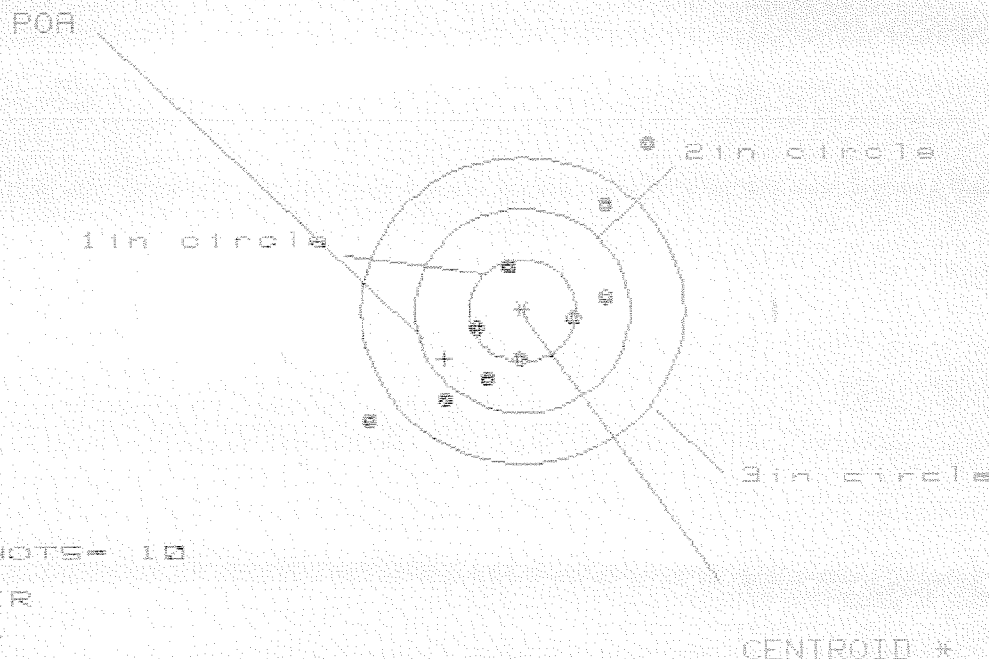
GS = 2.965

| PATTERN #                     | 3      |
|-------------------------------|--------|
| SHOTS (BEST OF)               | 10     |
| MAXIMUM X                     | 1.151  |
| MINIMUM X                     | -.694  |
| MAXIMUM Y                     | 1.540  |
| MINIMUM Y                     | -1.312 |
| CENTROID X                    | .235   |
| CENTROID Y                    | -.067  |
| POA TO CENTROID in.           | .245   |
| MIN RADIUS                    | .217   |
| MEAN RADIUS                   | .968   |
| MAX RADIUS                    | 1.745  |
| HORIZONTAL SPREAD             | 1.845  |
| VERTICAL SPREAD               | 2.852  |
| EXTREME SPREAD                | 2.965  |
| NUMBER IN ONE INCH CIRCLE =   | 2      |
| NUMBER IN TWO INCH CIRCLE =   | 6      |
| NUMBER IN THREE INCH CIRCLE = | 8      |

(1 Apr 1981)

FILE:/PATTERNING/CENTERFIRE\_PATT/08611548

# CENTERFIRE PATTERNS # 4



# OF SHOTS= 10

# IN CIR

1in = 4

2in = 6

3in = 8

HS= 2.658

VS= 2.657

GS= 3.758

PATTERN #

4

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.197

.902

.736

MINIMUM X

-1.461

-1.328

-1.762

MAXIMUM Y

1.632

1.193

1.088

MINIMUM Y

-1.025

-.844

-.600

CENTROID X

.729

.596

.762

CENTROID Y

.467

.286

.392

POA TO CENTROID in.

.866

.661

.857

MIN RADIUS

.423

.268

.392

MEAN RADIUS

.961

.812

.717

MAX RADIUS

2.023

1.574

1.306

HORIZONTAL SPREAD

2.658

2.230

1.498

VERTICAL SPREAD

2.657

2.037

1.888

EXTREME SPREAD

3.758

3.011

2.403

NUMBER IN ONE INCH CIRCLE =

4

NUMBER IN TWO INCH CIRCLE =

6

NUMBER IN THREE INCH CIRCLE =

8

(1 Apr 1993)

FILE:/PATTERNING/CENTERFIRE\_PATT/G6611548

# CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

# OF SHOTS= 10

# IN CIR

1in = 0

2in = 4

3in = 8

HS= 3.318

VS= 2.057

GS= 3.322

CENTROID +

PATTERN #

1

2

3

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.533

1.334

1.195

MINIMUM X

-1.785

-1.072

-.985

MAXIMUM Y

1.130

1.086

1.013

MINIMUM Y

-.927

-.971

-1.044

CENTROID X

.313

.512

.345

CENTROID Y

.290

.334

.407

POA TO CENTROID in.

.427

.611

.534

MIN RADIUS

.881

.845

.838

MEAN RADIUS

1.169

1.084

1.024

MAX RADIUS

1.828

1.458

1.216

HORIZONTAL SPREAD

3.318

2.406

2.100

VERTICAL SPREAD

2.057

2.057

2.057

EXTREME SPREAD

3.322

2.680

2.178

NUMBER IN ONE INCH CIRCLE =

0

NUMBER IN TWO INCH CIRCLE =

4

NUMBER IN THREE INCH CIRCLE =

8