

G 636 0883

Replace

C-6225320

RECEIVING AND ESTIMATING REPORT

COMMENTS

ORDER
R 94-24909

INITIAL
JJM

CUSTOMER ORDER NO.

M-24 SNIPER

DATE RECEIVED 08/29/94	DATE OPENED 08/30/94	DATE CODE DI 9-88	SERIAL NUMBER C6225320	NEW SERIAL NUMBER	MODEL AND GRADE 700 7.62	NATO
ACCESSORIES SCOPE MNTS SCOPE BASE						

FROM:

DEPT OF THE ARMY
B CO ARMS
2/75 RANGER BATTALION
FT LEWIS

WA 98433

SHIP TO:

DEPT OF THE ARMY
B CO ARMS
2/75 RANGER BATTALION
FT LEWIS

WA

98433

CUST NO:062072 C.D.D.L

ACCOUNT NUMBER

ACCOUNT NUMBER N/C

WRITE ☐

PROM. DATE

ESTIMATED

VIA

UPS

GUN CONDITION

- ☐ NEW
- ☐ LIGHTLY WORN
- ☐ WORN
- ☐ VERY WORN
- ☐ UNREPAIRABLE
- ☐ MARRED

REPAIR CHARGE

EXCISE

TAX

INSURANCE

UPS

PARCEL POST

TOTAL

CUSTOMER CONCERN	AMMO	FUNCTION	FINISH	ACCURACY	FIT	INSPECT
CYCLE	A1	B1				
TRIGGER GROUP		B2			E1	F1
BOLT ASSY.		B3			E2	F2
BARREL ASSY.		B4		D1	E3	F3
REC. ASSY.		B5		D2	E4	F4
WOOD			C1	D3	E5	F5
METAL			C2			

MAIN FAULT

New Barrel

PARTS

COMMENTS

Barrel - 96003

*Repower Coat Trigger Guard
Assy Front & Rear Sight
base/s!
Rezinc Scope Base, Rings &
Swivel Studs*

REPAIRMAN	PROOF	CLEAN	TEST	TARGET	PATTERN
-----------	-------	-------	------	--------	---------

GALLERY TESTER	DATE	DATE	DATE	DATE	DATE
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OFFICE COPY

RD6925 REV. 1/84

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

M2400083272

23 August 94

To: Mr. Fred Martin,

Sir, first off I want to thank you for the excellent service your firm provided us in the Re-barreling and Re-conditioning the 12 M24 SWS we sent you. I mailed them out from here on 28 July and we received them back on 22 August. That's a total of 26 days of which 10 or 11 were days in shipment to and from. My shooters are a very happy group.

This shipment includes the remaining 12 weapons of our total of 24. Same problem as the first 12 you reworked.

1st Lt Rette who you have been in contact with numerous times is now TDY for a week or so. If you need to contact us please call myself. I'm the Battalion's Civilian Armorer. Same prefix as Lt Rette but the last 4 digits change to 8055. We met in Oct 89 when you came to our unit to present a class to the Battalion Snipers.

Two minor problems occurred during this last rework.

The Receiving and Estimating Reports your firm mailed us and the weapons themselves were sent to the wrong address. Both went to B Co Arms, 3/5 Rangers.

So there was a minor delay routing them to my shop.

Please send all correspondence and completed weapons to the address at end of this letter. I'd greatly appreciate it.

In the shipment of my 12 SWS I just received I also received one weapon S/N C6225360 marked for 3-9 Inf Bgt. Fort Lewis, c/o 1st Lt CF Schmitt. I have contacted his unit to deliver that weapon to him.

We are now the 1st unit of Rangers to go to war if called. We are on RRF-1 until mid October. We also deploy 28 Sept 94 on a training exercise from Fort Lewis. We will be gone close to 4 weeks.

Hopefully you will be able to provide us with the same rapid response as you did the first 12 weapons so that we have them before leaving on the 28th of Sept. If that is not possible and we get alerted while on deployment we will contact you with an address change to send the weapons.

The good Lord willing that won't be necessary. Again Thanks a million for the splendid service.

Respectfully

Ray Fuller
Bn Division Armorer

Please send all correspondence to completed weapons to.

Commander

2d Bn. 75th Rgr. Rgt.

Attn: (Bn Arms Shop, Bldg 3474, Mr Fuller)

Fort Lewis, Wa 98433-5700

PACKING LIST		PACKED BY <i>Mr. Ray Fuller</i> <i>WG-10 Bn. Armorer.</i>	1. NO. BOXES <i>1</i>	2a. REQUISITION NO. <i>94244</i>	
				2b. ORDER NO.	
3. END ITEM <i>7.62mm 1724 Sniper Weapons System (SW5)</i>			4. DATE <i>26 July 1994</i>		
			5. PAGE <i>1</i> OF <i>1</i> PAGES		
BOX NO. (a)	CONTENTS - STOCK NUMBER AND NOMENCLATURE (b)	UNIT OF ISSUE (c)	QUANTITIES REQUIRED		
			INITIAL OPERATION (d)	RUNNING SPARES (e)	TOTAL (f)
<i>1</i>	<i>7.62mm 1724 Sniper Weapon System (SW5) Serial No. C6225320</i> <i>NSN: 1005-01-240-2136</i>	<i>Fa</i>			<i>1</i>
<i>Note: All Optic Scope Ring mounts Packed</i>					
6. THIS CERTIFIES THAT ITEMS LISTED HEREON ARE WITHIN THE SPECIFIED BOXES					
TYPED NAME AND TITLE <i>Ray Fuller WG-10 Bn Armorer</i>			SIGNATURE <i>Ray Fuller</i>		

DD FORM 1 SEP 70 1750

Final Inspection

Sn: C6225320

DATE REC'D: 8/29/94

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 # 06225320
15 Sep 1994

CENTROIDAL DISTANCES

0 TO	1	.276872
1 TO	2	.418632
1 TO	3	.695083
1 TO	4	.733311
1 TO	5	.190707

$\bar{x}$
 $\bar{y}$ <----POA

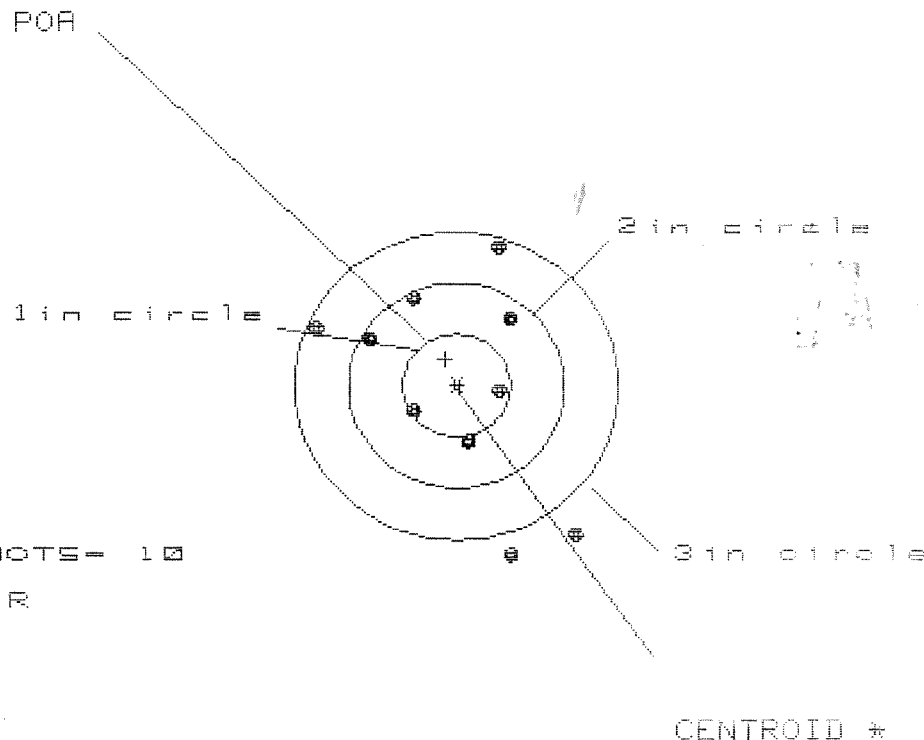
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1162
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0568
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .129339

THE AMR FOR THIS RIFLE IS: 1.026

15 Sep 1994

FILE:/PATTERNING/CENTERFIRE_PATT/C8225320

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1 in = 2

2 in = 6

3 in = 8

HS= 2.410

VS= 2.918

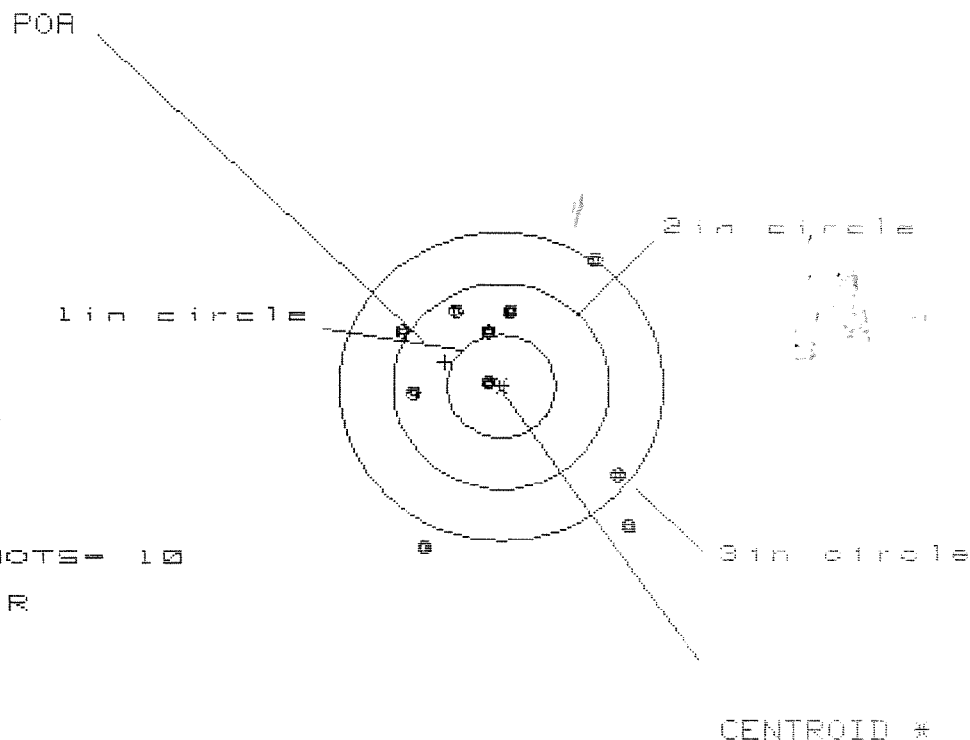
GS= 3.159

PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.079	.631	.661
MINIMUM X	:	-1.331	-1.211	-1.132
MAXIMUM Y	:	1.322	1.159	.939
MINIMUM Y	:	-1.596	-1.759	-.925
CENTROID X	:	.103	-.017	-.096
CENTROID Y	:	-.257	-.094	.126
POA TO CENTROID in.	:	.277	.095	.158
MIN RADIUS	:	.357	.480	.519
MEAN RADIUS	:	1.041	.940	.808
MAX RADIUS	:	1.820	1.869	1.149
HORIZONTAL SPREAD	:	2.410	1.842	1.793
VERTICAL SPREAD	:	2.918	2.918	1.864
EXTREME SPREAD	:	3.159	2.920	1.900
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	6		
NUMBER IN THREE INCH CIRCLE	=	8		

15 Sep 1994

FILE:/PATTERNING/CENTERFIRE_PATT/C6225320

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in - 1

2 in - 5

3 in - 8

HS= 2.183

VS= 2.741

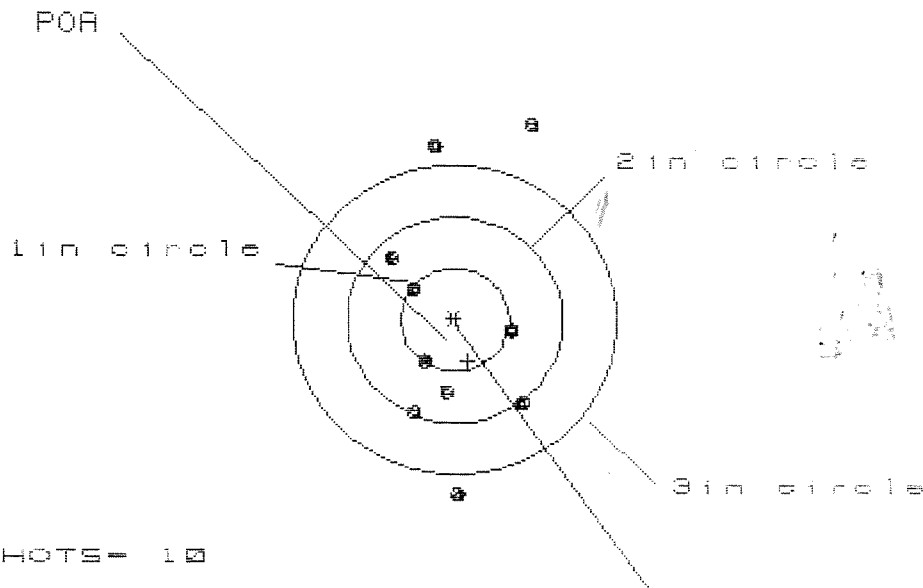
GS= 3.196

PATTERN #	:	2	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.226	1.235	1.156
MINIMUM X	:	-.957	-.821	-.900
MAXIMUM Y	:	1.194	1.047	.835
MINIMUM Y	:	-1.547	-1.694	-1.190
CENTROID X	:	.521	.385	.464
CENTROID Y	:	-.234	-.087	.125
POA TO CENTROID in.	:	.571	.394	.480
MIN RADIUS	:	.137	.118	.177
MEAN RADIUS	:	1.061	.919	.772
MAX RADIUS	:	1.804	1.800	1.659
HORIZONTAL SPREAD	:	2.183	2.056	2.056
VERTICAL SPREAD	:	2.741	2.741	2.025
EXTREME SPREAD	:	3.196	3.196	2.460
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	5		
NUMBER IN THREE INCH CIRCLE	=	8		

15 Sep 1994

FILE:/PATTERNING/CENTERFIRE_PATT/08225320

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1in = 2

2in = 5

3in = 7

HS= 1.354

VS= 3.605

GS= 3.679

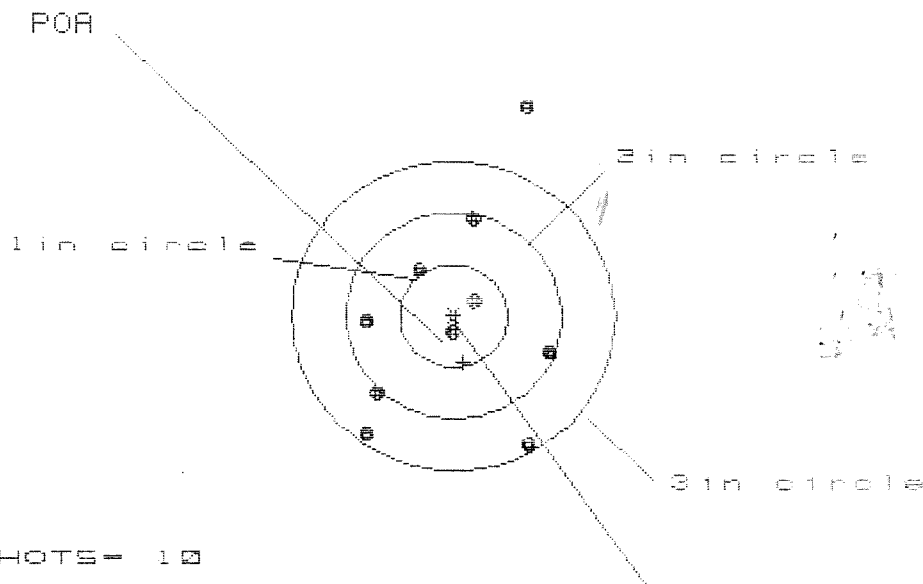
CENTROID *

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.737	.743	.729
MINIMUM X	:	-.617	-.535	-.549
MAXIMUM Y	:	1.944	1.944	1.954
MINIMUM Y	:	-1.661	-1.445	-1.202
CENTROID X	:	-.121	-.203	-.189
CENTROID Y	:	.401	.185	-.058
POA TO CENTROID in.	:	.419	.274	.197
MIN RADIUS	:	.485	.278	.238
MEAN RADIUS	:	1.058	.895	.719
MAX RADIUS	:	2.079	1.947	1.204
HORIZONTAL SPREAD	:	1.354	1.278	1.278
VERTICAL SPREAD	:	3.605	3.389	2.256
EXTREME SPREAD	:	3.679	3.395	2.339
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		7	

15 Sep 1994

FILE:/PATTERNING/CENTERFIRE_PATT/08225320

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 6

3 in = 9

HS= 1.746

VS= 3.256

GS= 3.481

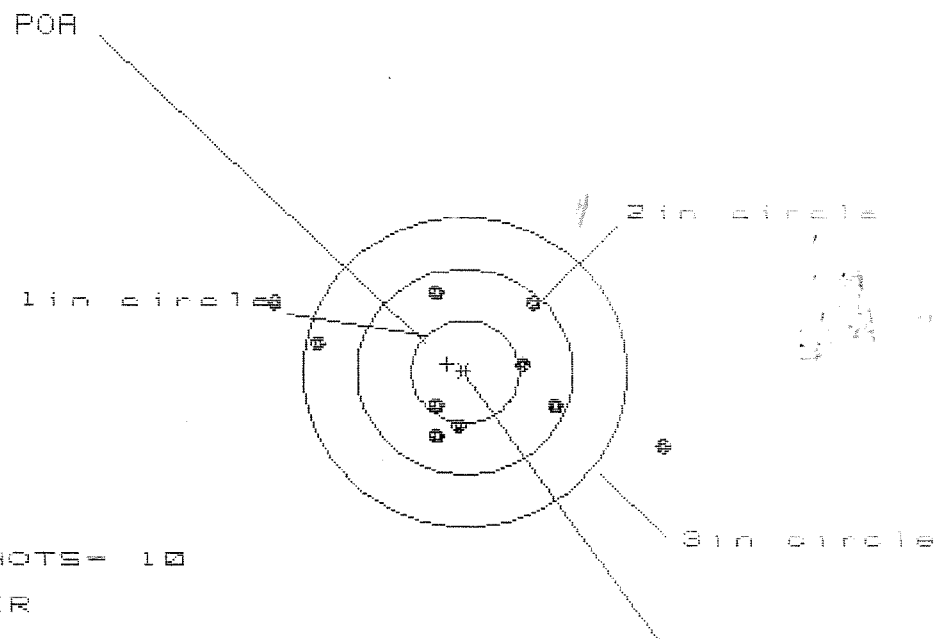
CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.890	.963	1.062
MINIMUM X	:	-.856	-.783	-.684
MAXIMUM Y	:	2.034	1.160	1.036
MINIMUM Y	:	-1.222	-.997	-1.002
CENTROID X	:	-.088	-.161	-.260
CENTROID Y	:	.451	.226	.350
POA TO CENTROID in.	:	.460	.277	.436
MIN RADIUS	:	.166	.102	.193
MEAN RADIUS	:	.964	.828	.757
MAX RADIUS	:	2.136	1.275	1.213
HORIZONTAL SPREAD	:	1.746	1.746	1.746
VERTICAL SPREAD	:	3.256	2.157	2.038
EXTREME SPREAD	:	3.481	2.305	2.305
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

15 Sep 1994

FILE:/PATTERNING/CENTERFIRE_PATT/C8225320

CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1in = 1

2in = 7

3in = 8

HS= 3.667

VS= 1.544

GS= 3.939

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.857	1.089	.808
MINIMUM X	-1.810	-1.604	-1.320
MAXIMUM Y	.800	.717	.794
MINIMUM Y	-.744	-.669	-.592
CENTROID X	.166	-.040	.161
CENTROID Y	-.077	.006	-.071
POB TO CENTROID in.	.183	.040	.176
MIN RADIUS	.400	.389	.401
MEAN RADIUS	1.006	.907	.766
MAX RADIUS	2.000	1.717	1.341
HORIZONTAL SPREAD	3.667	2.693	2.288
VERTICAL SPREAD	1.544	1.386	1.386
EXTREME SPREAD	3.939	2.882	2.282
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	8		

CONTRACT # DAAA21-87-C-0086

New Barrel

GUN SERIAL # C6225320

OP. #	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and Stock		9/1/94	RW
600	Proof		9/1/94	RW
607	Check Headspace		9/1/94	RW
610	Dis-assemble Gun		9/1/94	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		9/12/94	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		9/12/94	RW
	C) Inspect Ejector Hole for Chamfer		9/12/94	RW
	D) Oil Firing Pin Ass'y		9/12/94	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						9/12 OK	WB
	A) Time						9/12	WB
	B) Malfunctions						9/12	WB
	C) Pierced Primers						9/12 OK	WB
	D) Optical Clarity of Scope						9/12 OK	WB
645	Inspect for Live Ammo						9/12/94	RW
655	Final Inspection							
	A) Headspace						9/14/94	RW
	B) Trigger Pull	2.39	2.46	2.44	2.51	2.54	9/14/94	RW
	C) Function						9/14/94	RW
660	Pack							

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6360883.___0
FILE DATE AND TIME: 11/09/2004 07:55

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

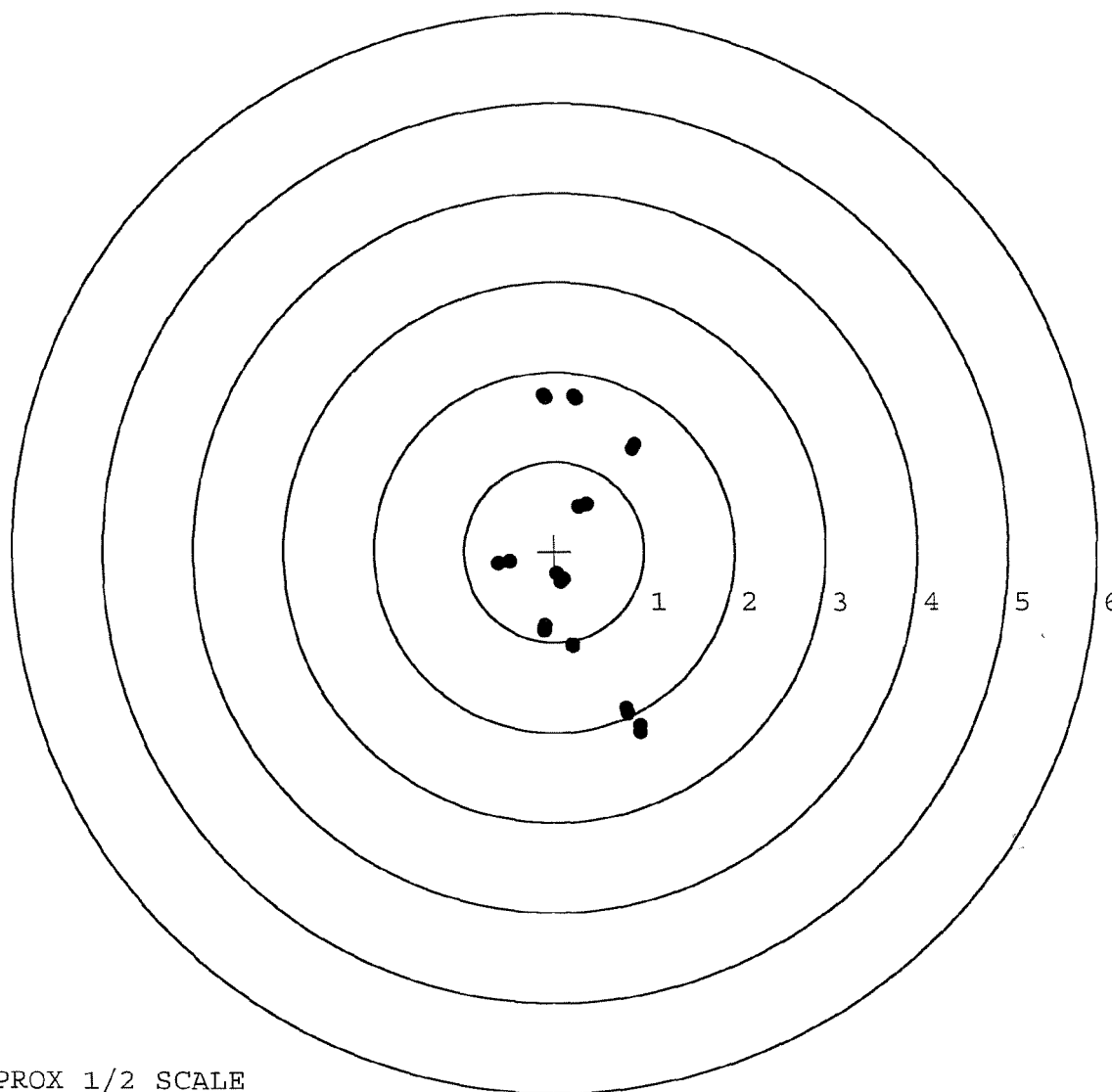
The Average X Centroid of the Five Target Set:	0.047
The Average Y Centroid of the Five Target Set:	0.027
The Average Point of Impact of the Five Target Set:	0.055
The Average Mean Radius of the Five Target Set:	0.766
The Distance from POA to Centroid Target #1:	0.276
The Distance from Centroid Target #2 to Centroid Target #1:	0.253
The Distance from Centroid Target #3 to Centroid Target #1:	0.177
The Distance from Centroid Target #4 to Centroid Target #1:	0.457
The Distance from Centroid Target #5 to Centroid Target #1:	0.384

SERIAL NUMBER: G6360883. 0
TARGET NUMBER: 1
FILE DATE: 11/09/2004
FILE TIME: 07:55

X CENTROID: 0.257
Y CENTROID: -0.100
POA TO CENTROID: 0.276
HORZ SPREAD: 1.591
VERT SPREAD: 3.743
GROUP SPREAD: 3.900
MIN RADIUS: 0.265
MAX RADIUS: 2.026
MEAN RADIUS: 1.189
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 11
in 3 IN DIAMETER: 13

POINT#	X	Y
1:	0.966	-1.923
2:	0.800	-1.733
3:	0.208	-1.041
4:	-0.116	-0.878
5:	0.070	-0.344
6:	-0.625	-0.141
7:	0.359	0.533
8:	0.889	1.200
9:	0.235	1.705
10:	-0.132	1.744
11:	0.024	-0.249
12:	0.963	-1.999
13:	0.824	-1.783
14:	0.205	-1.035

POINT#	X	Y
15:	-0.110	-0.820
16:	0.101	-0.314
17:	-0.496	-0.123
18:	0.267	0.503
19:	0.861	1.148
20:	0.210	1.736
21:	-0.111	1.712



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6360883. __0

TARGET NUMBER: 2

FILE DATE: 11/09/2004

FILE TIME: 07:55

POINT#	X	Y
1:	0.408	-0.560
2:	0.562	0.263
3:	-0.297	-0.392
4:	-0.676	0.568
5:	-0.223	0.078
6:	-0.024	-0.290
7:	0.019	0.163
8:	0.326	0.178
9:	0.170	-0.117
10:	-0.100	-0.088

X CENTROID: 0.017

Y CENTROID: -0.020

POA TO CENTROID: 0.026

HORZ SPREAD: 1.238

VERT SPREAD: 1.128

GROUP SPREAD: 1.564

MIN RADIUS: 0.135

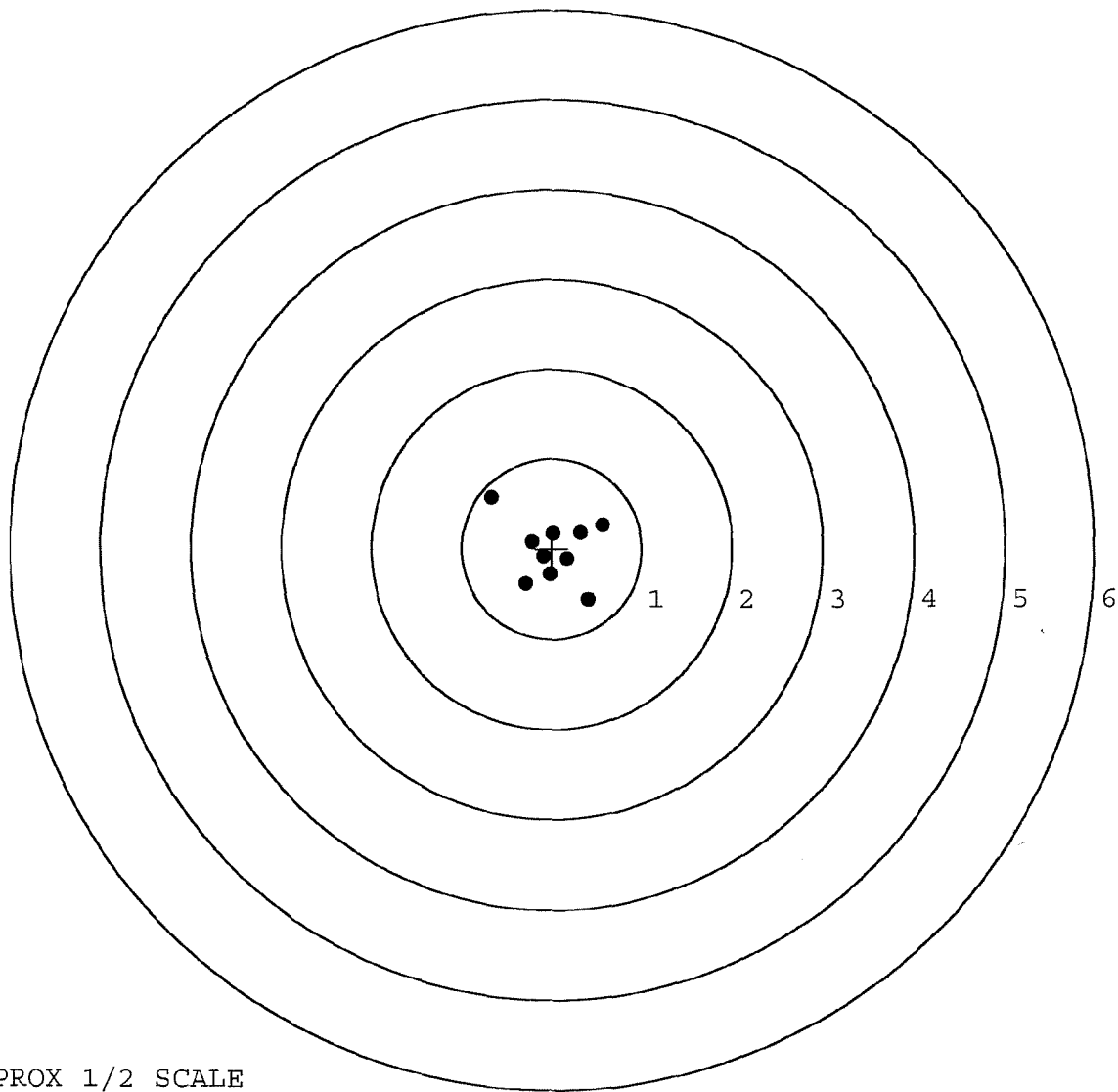
MAX RADIUS: 0.908

MEAN RADIUS: 0.408

IN 1 IN DIAMETER: 7

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10

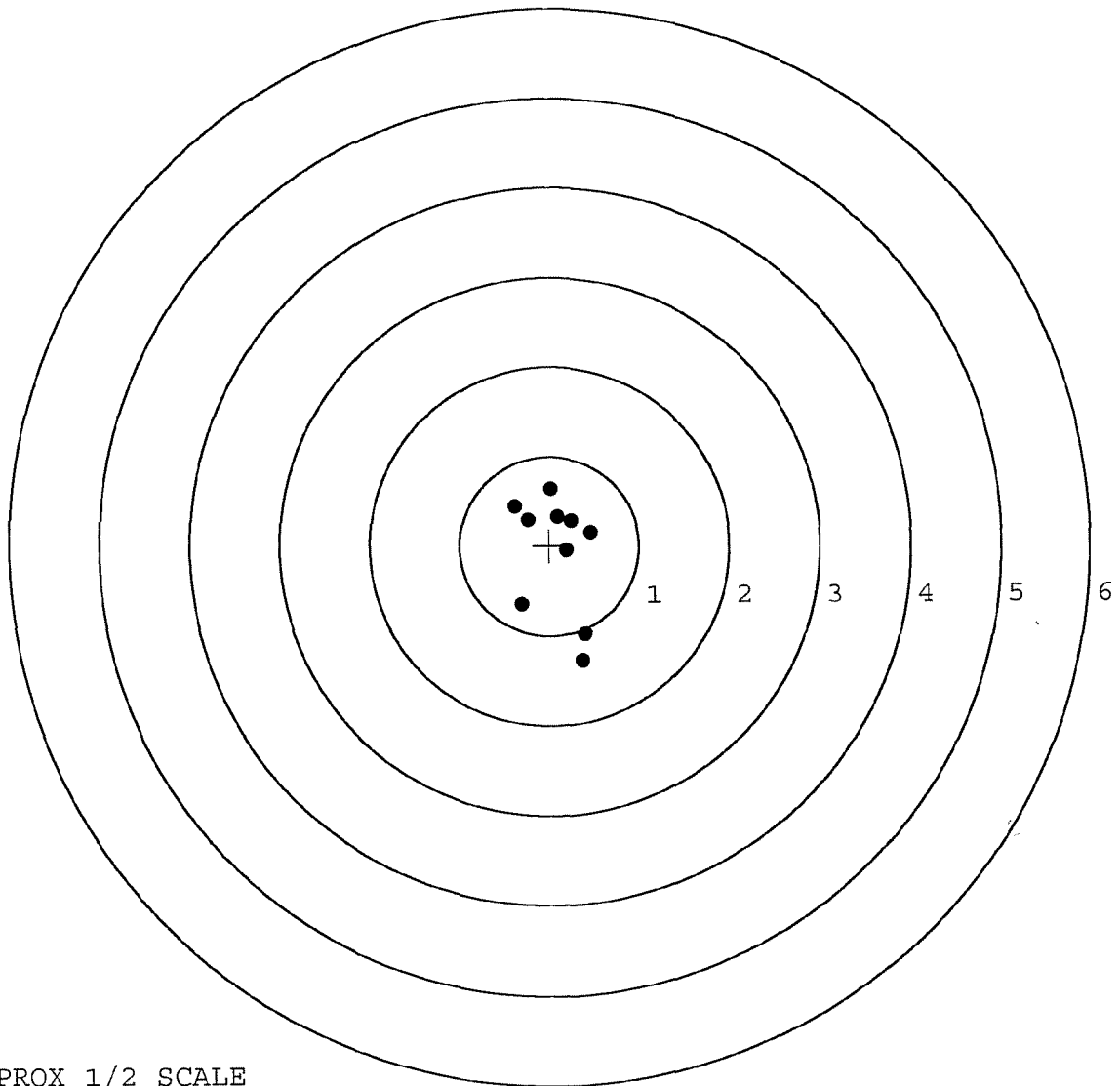


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6360883. __0
TARGET NUMBER: 3
FILE DATE: 11/09/2004
FILE TIME: 07:55

X CENTROID: 0.081
Y CENTROID: -0.085
POA TO CENTROID: 0.117
HORZ SPREAD: 0.854
VERT SPREAD: 1.914
GROUP SPREAD: 1.946
MIN RADIUS: 0.112
MAX RADIUS: 1.228
MEAN RADIUS: 0.617
IN 1 IN DIAMETER: 5
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.367	-1.279
2:	0.395	-0.981
3:	-0.320	-0.657
4:	-0.391	0.443
5:	-0.243	0.290
6:	0.016	0.635
7:	0.087	0.326
8:	0.463	0.153
9:	0.189	-0.055
10:	0.246	0.278



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6360883. __0

TARGET NUMBER: 4

FILE DATE: 11/09/2004

FILE TIME: 07:55

POINT#	X	Y
1:	0.215	-1.276
2:	0.269	-0.545
3:	0.604	-0.303
4:	0.875	1.526
5:	-0.217	0.697
6:	-0.080	-0.045
7:	-0.357	-0.023
8:	-1.313	-0.403
9:	-0.549	0.803
10:	-0.757	0.982

X CENTROID: -0.131

Y CENTROID: 0.141

POA TO CENTROID: 0.193

HORZ SPREAD: 2.188

VERT SPREAD: 2.802

GROUP SPREAD: 2.917

MIN RADIUS: 0.193

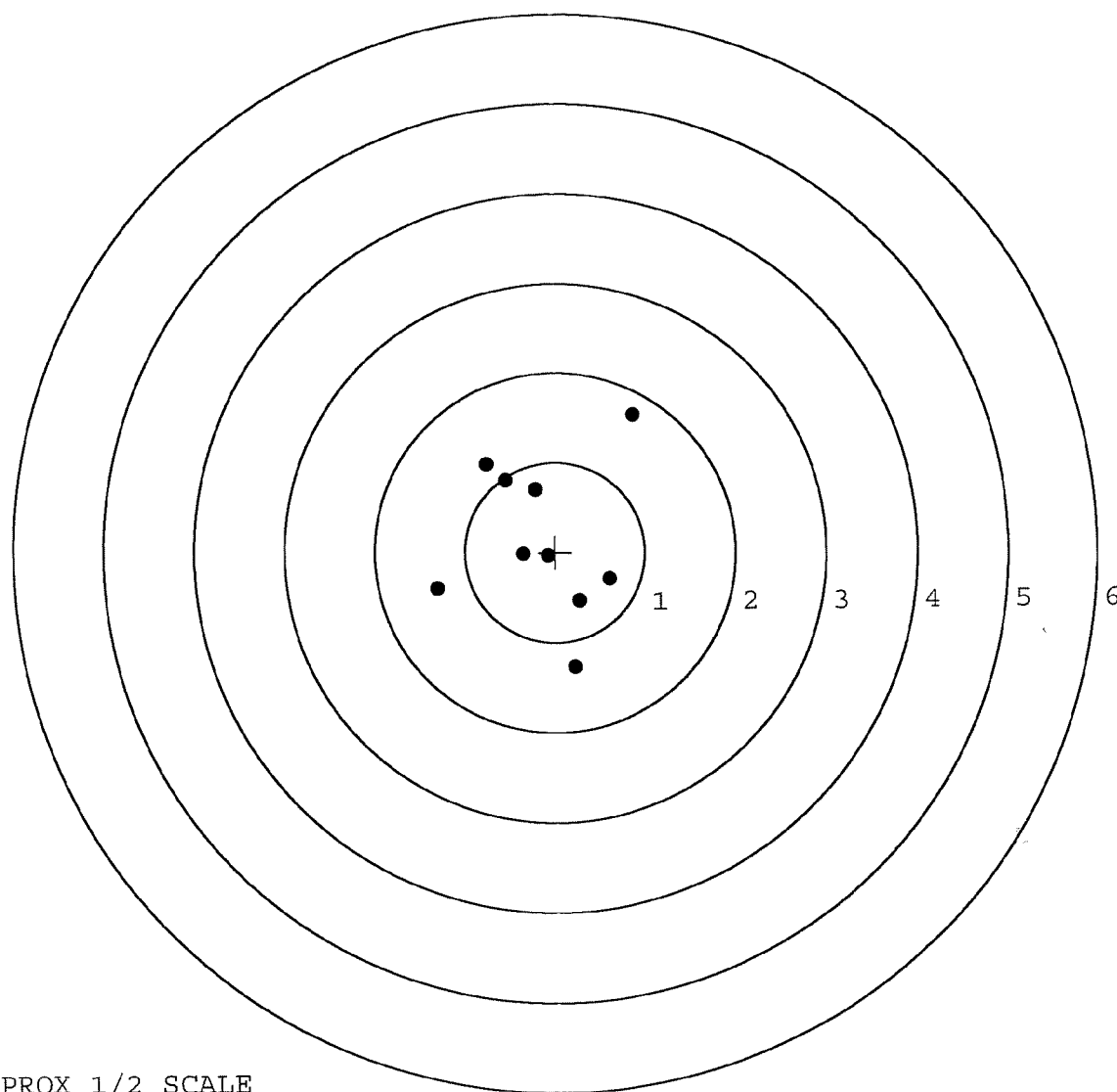
MAX RADIUS: 1.712

MEAN RADIUS: 0.899

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6360883. 0

TARGET NUMBER: 5

FILE DATE: 11/09/2004

FILE TIME: 07:55

POINT#	X	Y
1:	1.187	-1.295
2:	0.446	1.231
3:	0.191	0.474
4:	-0.322	0.403
5:	-0.363	0.116
6:	-0.890	-0.064
7:	-0.236	-0.533
8:	0.170	-0.512
9:	0.147	-0.239
10:	-0.190	-0.195

X CENTROID: 0.014

Y CENTROID: 0.198

POA TO CENTROID: 0.198

HORZ SPREAD: 2.077

VERT SPREAD: 1.828

GROUP SPREAD: 2.482

MIN RADIUS: 0.328

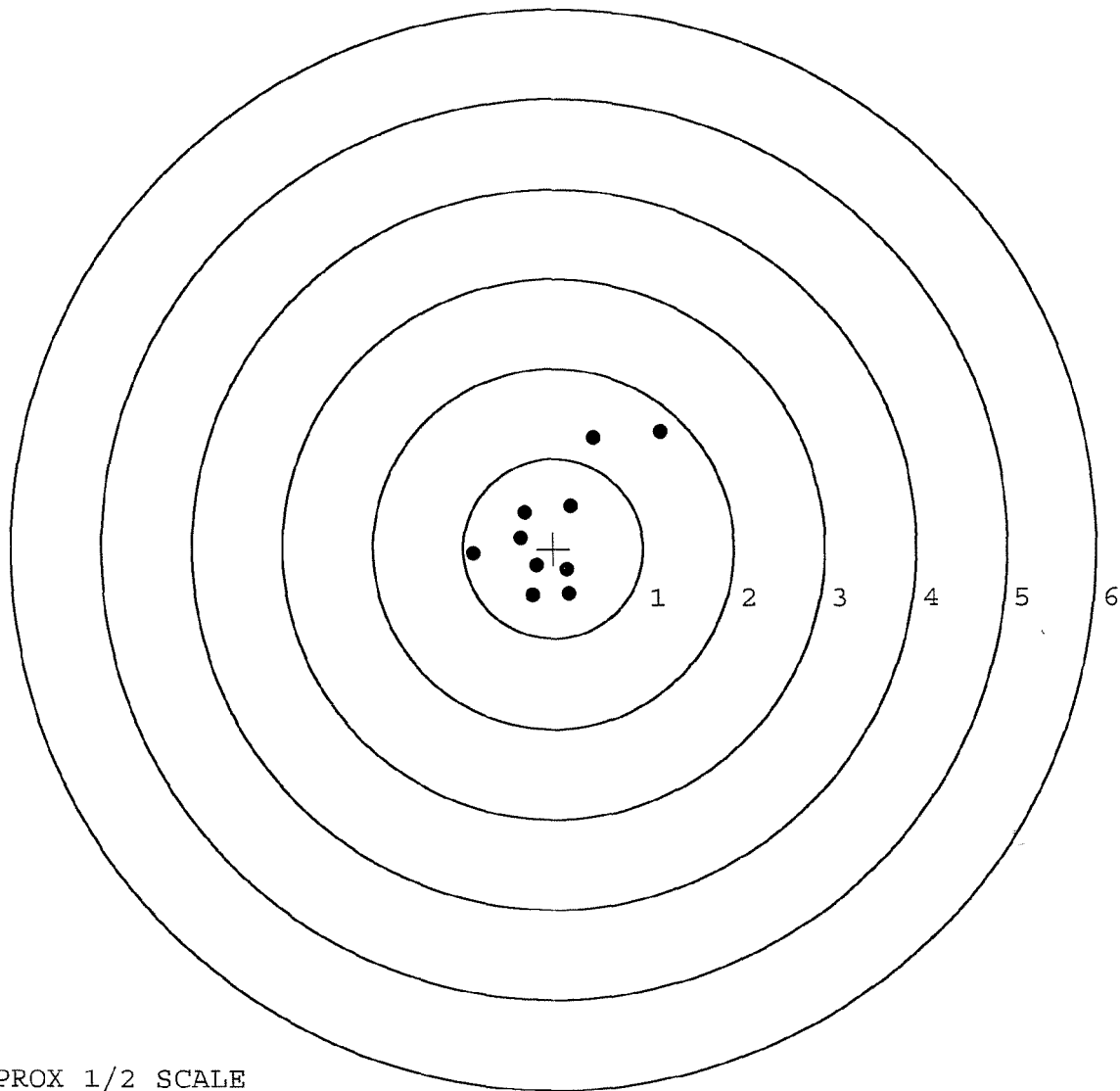
MAX RADIUS: 1.606

MEAN RADIUS: 0.717

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

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

SERIAL # C6360883

INSPECTED BY: RT

DATE REC'D: 10-4-04

DATE RET'D: 11-10-04

ITEM

BARREL ASSEMBLY

☒ BARREL
☒ RECEIVER
☒ FRONT SIGHT BASE
☒ REAR SIGHT BASE
☒ SCREWS
☒ FINISH

SCOPE ASSEMBLY

☐ SCOPE
☐ SCOPE RINGS
☐ MOUNTING SCREWS
☐ MOUNTING BASE
☐ SCREWS
☐ FINISH
☐ CLARITY

ITEM

STOCK ASSEMBLY

☒ STOCK
☒ SLING AWIVEL STUDS
☒ ADJUSTABLE
☒ BUTT PLATE
☒ LOCK NUTS
☒ BARREL CLEARANCE
☒ COLOR / FINISH

SYSTEMS CASE

☐ SCOPE CASE
☐ IRON SIGHTS
☐ DEPLOYMENT KIT

TRIGGER ASSEMBLY

☒ SAFETY OPERATION
☒ RE-SET TO FACTORY SPECS

COMMENTS:

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

R & E NUMBER	85933		
SERIAL NUMBER	C6225320	G6360883 (New)	
LOG-IN DATE	10-4-04		
INSPECT AND VERIFY:			
OPERATION #	OPERATION NAME	DATE	INITIAL
550	DIS-ASSEMBLE GUN	10-13-04	RTL
560 A	RE-BARREL	10-14-04	RTL
B	DRILL AND TAP	10-19-04 10-15-04	TRW
575	ASSEMBLE	10-15-04	RTL
600	PROOF	10-18-04	RTL
605	CHECK HEADSPACE	10-18-04	RTL
610	DIS-ASSEMBLE GUN	10-19-04	RTL
612	MAGNAFLUX	OPERATOR	
615	ROLLMARK CALIBER	10/20/04	AB
618	ROTO-BLAST	10-22-04	LB
620	APPLY COATINGS	10/26/04	HP
625 A	FINAL ASSEMBLY	11-3-04	RTL
B	TRIGGER PULL TEST		
C	SAFETY "ON" FORCE		
D	SAFETY "OFF" FORCE		
E	FIRING PIN INDENT		
640	TARGET	11-9-04	TRW
655	FINAL INSPECT	11-10-04	RTL
660	PACK	11-10-04	DA
		SHIP DATE	
		QAR INSPECTION DATE	

M-24

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5320

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6225320

OP. #	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and stock	8	9/88	FB
600	Proof	9	7/88	RW
607	Check Headspace	9	7/88	RW
610	Dis-assemble gun	5	7/88	RW
612	Magnaflux Barrel Action		9-14-88	RJC.
	Magnaflux Bolt		9-14-88	RJC.
615	Rollmark Caliber			
617	Drill & Tap Sight Holes			
618	Polish Barrel			
620	Apply Coatings (Barrel Action)		10-31-88	TJA
	Apply Coatings (Bolt)		10-31-88	TJA
625	Final Assembly A) Clean inside of Bolt Assembly		11/2/88	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		11/2/88	RW
	C) Inspect Ejector Hole for Chamfer		11/2/88	RW

OVER

OP.#		READINGS	DATE	INITIAL
625 cont.	D) Oil Firing Pin Ass'y		11/2/88	RW
	E) Adjust Trigger Pull to Min. Setting and Stake		4 NOV 88	JS
	F) Safety on Force	5 5 5	8 NOV 88	JS
	G) Safety off Force	4 4 4	8 NOV 88	JS
	H) Trigger Pull Test & Retainability		4 NOV 88	JS
	I) Firing Pin Indent	.020 .0205 .020	8 NOV 88	JS
	J) Assemble Stock		11/9/88	RW
	K) Assemble Swivel Studs		30 NOV 88	JS
	L) Attach Front & Rear Sight Assemblies		11/9/88	RW
	M) Iron Sight Alignment		11/9/88	RW
	N) Detach Front & Rear Sights & place in numbered container		11/9/88	RW
	O) Attach Scope to Rifle		1 NOV 88	JS
	P) Detach & Attach Scope 20 times			
640	Gallery Target & Test	74 R 79 L	11/14/88	DH
	A) Optical Clarity of Scope		11/14/88	DH
645	Inspect for Live Ammo		11/14/88	DH
655	Final Inspection			
	A) Headspace		30 NOV 88	JS
	B) Trigger Pull		30 NOV 88	JS
	C) Function		30 NOV 88	JS
660	Pack		15 Dec 88	JS

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

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

SERIAL NO. C6225320

DATE 4/NOV 88

TESTER JS

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.53	2.56	2.54	2.38	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.50	2.49	2.48	2.38	
PULL #3	2.47	2.54	2.46	2.39	
PULL #4	2.45	2.58	2.57	2.40	
PULL #5	2.45	2.55	2.47	2.42	
TOTAL	12.40	12.72	12.52	11.97	
AVG.	2.48	2.544	2.504	2.394	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.32	3.22		
PULL #2	3.27	3.23		
PULL #3	3.22	3.22		
PULL #4	3.21	3.24		
PULL #5	3.21	3.23		
TOTAL	16.23	16.14		
AVG.	3.246	3.228		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.08	3.97		4.12
PULL #2	4.08	3.99		4.13
PULL #3	4.07	3.99		4.05
PULL #4	4.04	3.87		4.10
PULL #5	4.01	3.96		4.09
TOTAL	20.28	19.78		20.49
AVG.	4.056	3.956		4.098

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6225320

CENTROIDAL DISTANCES

0 TO	1	.11407
1 TO	2	.450362
1 TO	3	.203924
1 TO	4	.617645
1 TO	5	.880014

5
4231 (----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.2644
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1774
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .318399
THE AMR FOR THIS RIFLE IS: 1.082

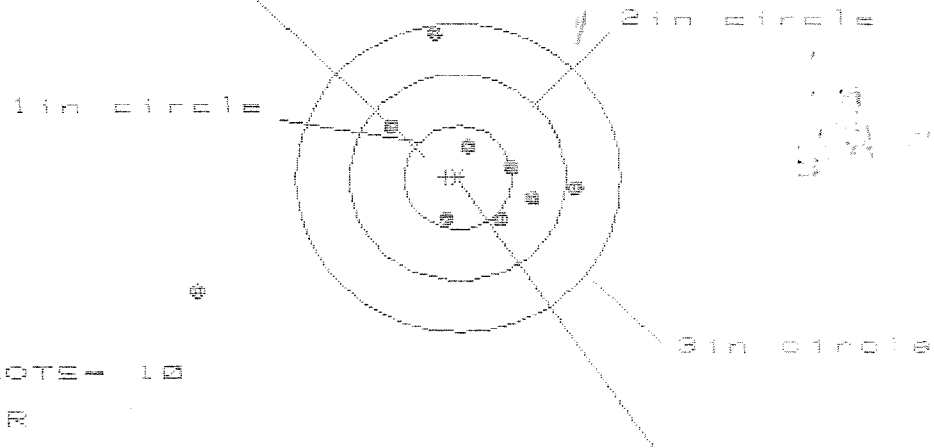
14 May 1988

FILE:/PATTERNING/CENTERFIRE_PATT/08225320

CENTERFIRE PATTERNS

1

FOR



OF SHOTS - 10

IN CIR

1in = 2

2in = 7

3in = 9

HS= 3.497

VS= 2.472

GS= 3.625

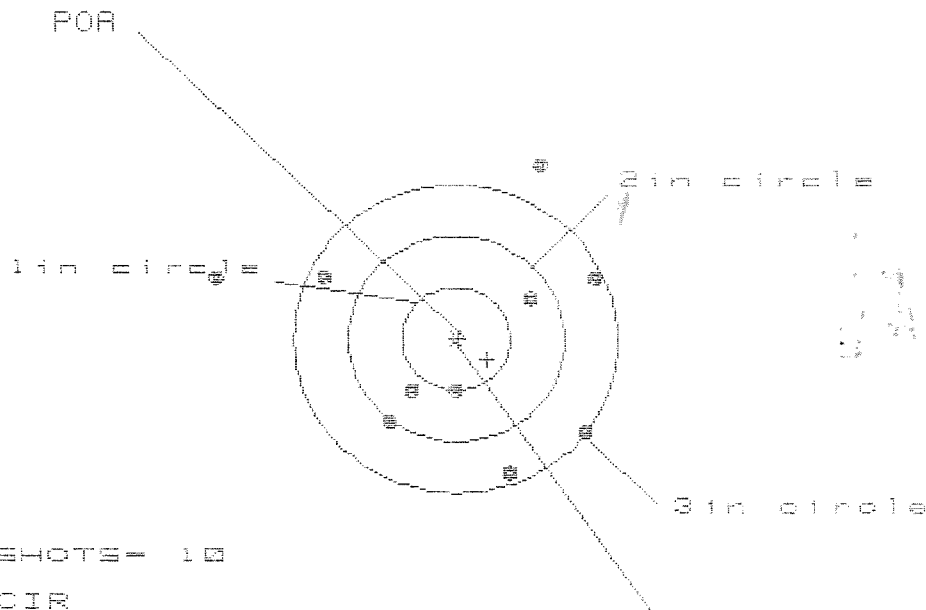
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.076	.807	.743
MINIMUM X	-2.421	-.834	-.898
MAXIMUM Y	1.409	1.291	.563
MINIMUM Y	-1.063	-.534	-.373
CENTROID X	.114	.383	.447
CENTROID Y	-.004	.114	-.047
FOR TO CENTROID in.	.114	.399	.449
MIN RADIUS	.328	.245	.198
MEAN RADIUS	.915	.654	.518
MAX RADIUS	2.644	1.388	1.070
HORIZONTAL SPREAD	3.497	1.641	1.641
VERTICAL SPREAD	2.472	1.825	.956
EXTREME SPREAD	3.625	2.011	1.755
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	9		

14 Nov 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C8225320

CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 4

3 in = 7

HS = 3.493

VS = 2.979

GS = 3.715

CENTROID *

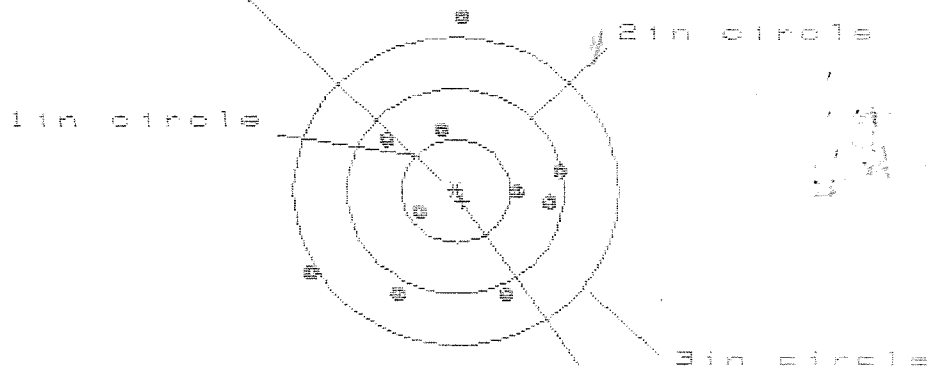
PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.314	1.072	1.138
MINIMUM X	:	-2.179	-1.437	-1.371
MAXIMUM Y	:	1.681	1.744	.925
MINIMUM Y	:	-1.298	-1.235	-1.017
CENTROID X	:	-.287	-.045	-.111
CENTROID Y	:	.281	.138	-.088
FOR TO CENTROID in.	:	.350	.145	.137
MIN RADIUS	:	.469	.504	.388
MEAN RADIUS	:	1.275	1.149	1.018
MAX RADIUS	:	2.252	1.823	1.654
HORIZONTAL SPREAD	:	3.493	2.509	2.509
VERTICAL SPREAD	:	2.979	2.979	1.942
EXTREME SPREAD	:	3.715	2.997	2.885
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		7	

14 Nov 1988

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CENTERFIRE PATTERNS # 3

FOR



OF SHOTS- 10

IN CIR

1in = 1

2in = 6

3in = 8

HS= 2.243

VS= 2.675

GS= 2.835

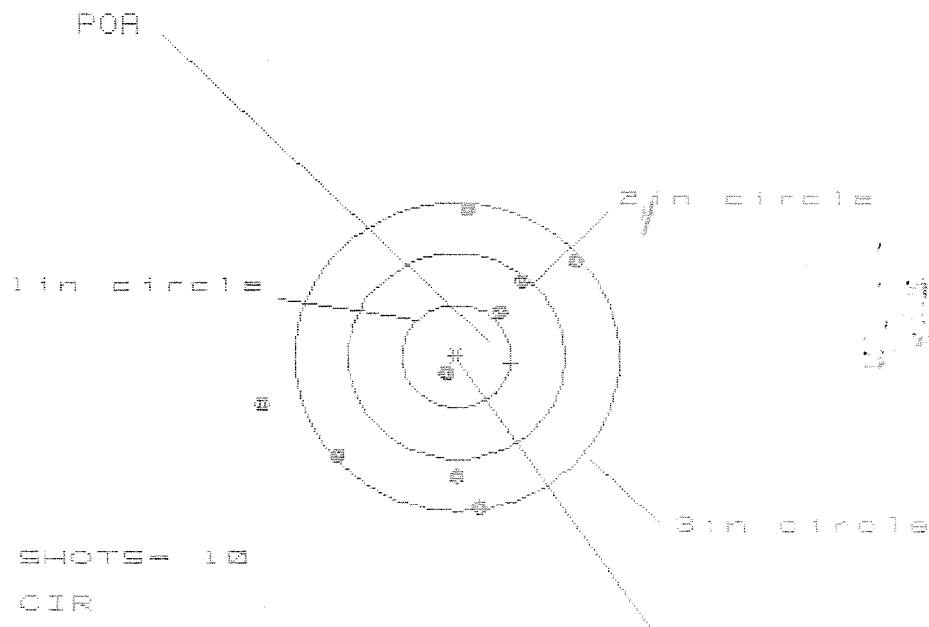
CENTROID #

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.937	.938	.775
MINIMUM X	-1.386	-1.305	-.810
MAXIMUM Y	1.669	.817	.735
MINIMUM Y	-1.006	-.821	-.903
CENTROID X	-.062	-.063	.100
CENTROID Y	.099	-.086	-.004
POA TO CENTROID in.	.117	.107	.100
MIN RADIUS	.358	.291	.448
MEAN RADIUS	.973	.888	.795
MAX RADIUS	1.669	1.460	1.151
HORIZONTAL SPREAD	2.243	2.243	1.585
VERTICAL SPREAD	2.675	1.638	1.638
EXTREME SPREAD	2.835	2.481	1.929
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	8		

14 Nov 1988

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CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 4

3 in = 9

HS= 2.877

VS= 2.881

GS= 3.183

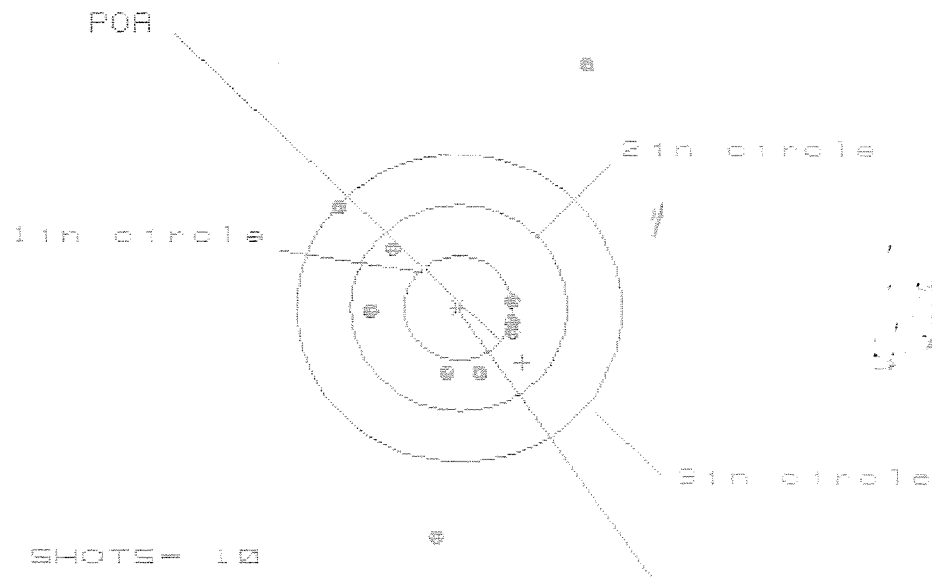
CENTROID #

PATTERN #	1	4	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.083	.884	.885
MINIMUM X	-1.794	-1.308	-1.307
MAXIMUM Y	1.412	1.363	1.173
MINIMUM Y	-1.469	-1.518	-1.451
CENTROID X	-.500	-.301	-.302
CENTROID Y	.063	.112	.302
POR TO CENTROID in.	.504	.321	.427
MIN RADIUS	.191	.358	.297
MEAN RADIUS	1.154	1.050	.952
MAX RADIUS	1.848	1.647	1.768
HORIZONTAL SPREAD	2.877	2.192	2.192
VERTICAL SPREAD	2.881	2.881	2.624
EXTREME SPREAD	3.183	2.883	2.881
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		4	
NUMBER IN THREE INCH CIRCLE =		9	

14 Nov 1988

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 1

2in = 7

3in = 8

HS= 2.364

VS= 4.625

GS= 4.851

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.206	.664	.649
MINIMUM X	-1.159	-1.025	-1.040
MAXIMUM Y	2.419	1.196	.954
MINIMUM Y	-2.206	-1.937	-.648
CENTROID X	-.587	-.720	-.705
CENTROID Y	.528	.259	.501
POA TO CENTROID in.	.789	.766	.865
MIN RADIUS	.448	.354	.569
MEAN RADIUS	1.095	.896	.762
MAX RADIUS	2.703	1.941	1.411
HORIZONTAL SPREAD	2.364	1.689	1.689
VERTICAL SPREAD	4.625	3.133	1.602
EXTREME SPREAD	4.851	3.260	2.112
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	8		