

G-636 0870

Replace

C-622-5670

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: **RE00085926** Serial: C6225070 Model: M24 SWS Center Fire Caliber: 7.62 NATO Repairman: Status: Closed 10/4/2004 10:53:57 AM

Verify Repair

Address Information

Customer: Received From: Return To: Received From:

Name: **TRANSPORTATION OFFICER** **TRANSPORTATION OFFICER**

Address 1: **SENSITIVE STORAGE** **SENSITIVE STORAGE**

Address 2: **BLDG 9660** PO Box: **BLDG 9660** PO Box:

City: **FORT LEWIS** **FORT LEWIS**

State: **WA** Zip Code: **98433** Country: **US** State: **WA** Zip Code: **98433** Country: **US**

FFL: ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐

Contact / Condition Problems Estimate History / Status Shipping / Billing

Contact Information: Phone: **253 967 5516** Fax: Email: Comments:

Received Condition: Poor Condition Notes: CSR Notes:

Accessories Received:

Code	Desc	Qty
A007	With Studs	3
A017	Scope Bases	3

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

naqltj 10/4/2004 11:25 AM CAPS NUM INS SCPL

start 3 4 Arms Services

C6360870 (New)

Serial Number: ~~C6225070~~

Model: M24 SWS



RE00085926

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6360870.___0

FILE DATE AND TIME: 11/09/2004 08:00

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.090
The Average Y Centroid of the Five Target Set:	-0.020
The Average Point of Impact of the Five Target Set:	0.092
The Average Mean Radius of the Five Target Set:	0.915
The Distance from POA to Centroid Target #1:	0.138
The Distance from Centroid Target #2 to Centroid Target #1:	0.083
The Distance from Centroid Target #3 to Centroid Target #1:	0.201
The Distance from Centroid Target #4 to Centroid Target #1:	0.209
The Distance from Centroid Target #5 to Centroid Target #1:	0.188

SERIAL NUMBER: G6360870. __0

TARGET NUMBER: 1

FILE DATE: 11/09/2004

FILE TIME: 08:00

X CENTROID: 0.128

Y CENTROID: -0.054

POA TO CENTROID: 0.138

HORZ SPREAD: 3.392

VERT SPREAD: 1.740

GROUP SPREAD: 3.414

MIN RADIUS: 0.245

MAX RADIUS: 2.124

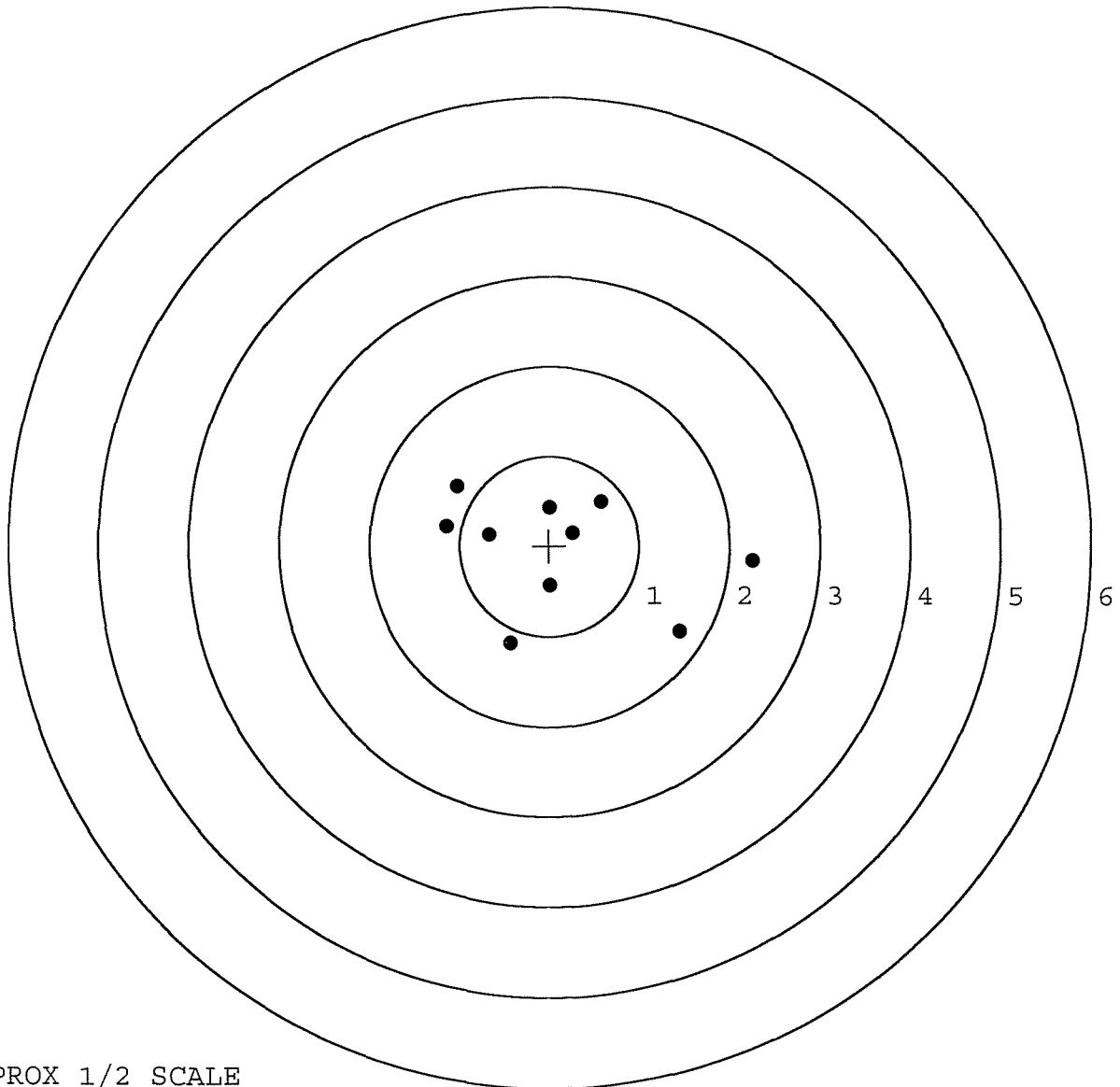
MEAN RADIUS: 1.022

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 5

in 3 IN DIAMETER: 8

POINT#	X	Y
1:	0.579	0.498
2:	0.261	0.151
3:	0.003	0.427
4:	-0.667	0.130
5:	-1.144	0.217
6:	-1.033	0.666
7:	0.010	-0.442
8:	1.451	-0.944
9:	-0.433	-1.074
10:	2.248	-0.169



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6360870. 0

TARGET NUMBER: 2

FILE DATE: 11/09/2004

FILE TIME: 08:00

X CENTROID: 0.124

Y CENTROID: 0.029

POA TO CENTROID: 0.127

HORZ SPREAD: 3.373

VERT SPREAD: 1.626

GROUP SPREAD: 3.637

MIN RADIUS: 0.318

MAX RADIUS: 1.877

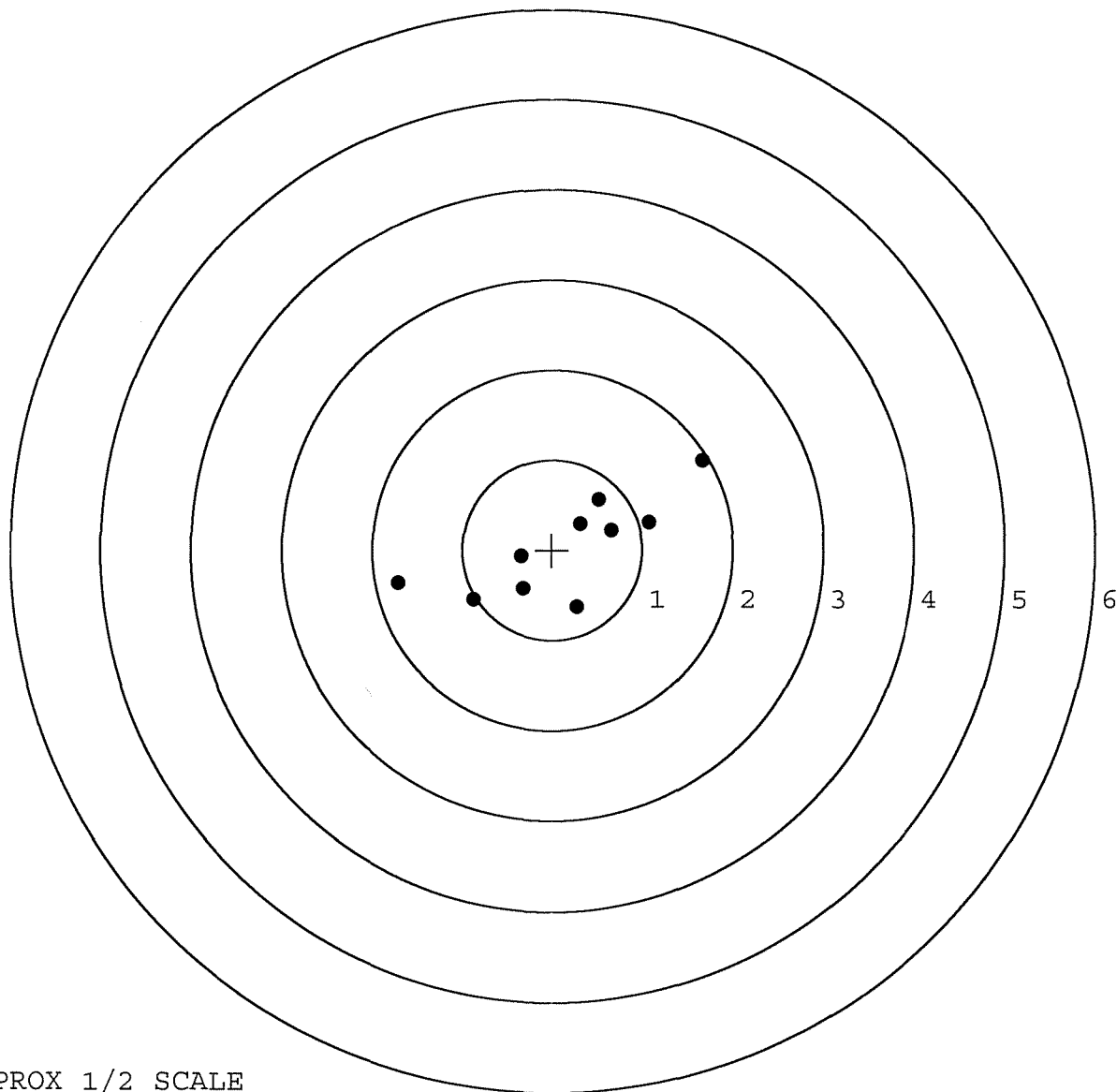
MEAN RADIUS: 0.918

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 8

POINT#	X	Y
1:	1.662	0.992
2:	1.072	0.305
3:	0.277	-0.634
4:	-0.878	-0.554
5:	-1.711	-0.368
6:	-0.323	-0.435
7:	0.656	0.215
8:	0.307	0.288
9:	0.516	0.556
10:	-0.341	-0.078

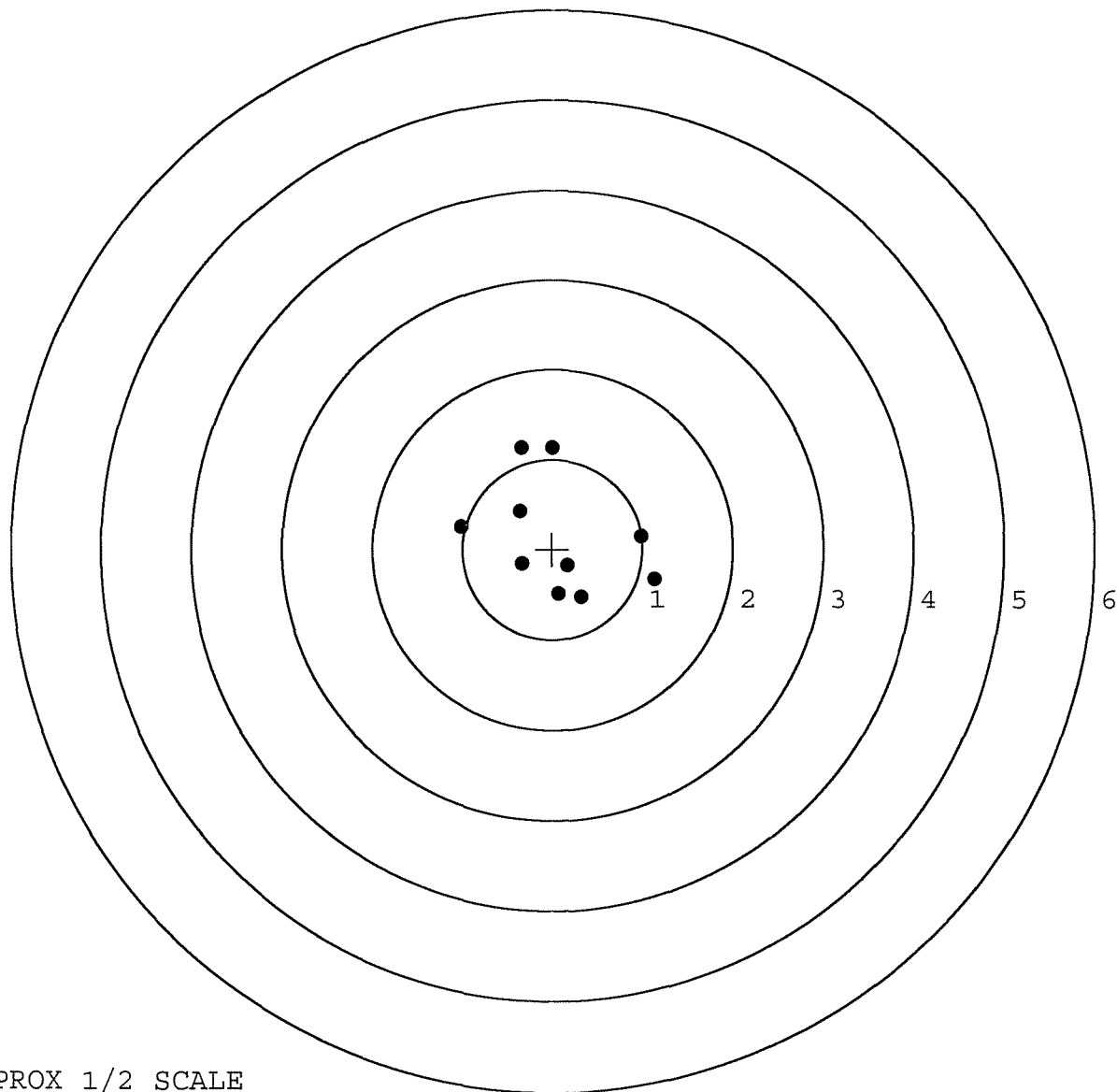


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6360870. __0
TARGET NUMBER: 3
FILE DATE: 11/09/2004
FILE TIME: 08:00

X CENTROID: 0.064
Y CENTROID: 0.137
POA TO CENTROID: 0.151
HORZ SPREAD: 2.149
VERT SPREAD: 1.661
GROUP SPREAD: 2.227
MIN RADIUS: 0.331
MAX RADIUS: 1.170
MEAN RADIUS: 0.794
IN 1 IN DIAMETER: 1
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	1.134	-0.335
2:	0.987	0.143
3:	0.005	1.129
4:	-0.343	1.133
5:	-1.015	0.248
6:	-0.360	0.424
7:	-0.335	-0.166
8:	0.172	-0.176
9:	0.070	-0.500
10:	0.325	-0.528

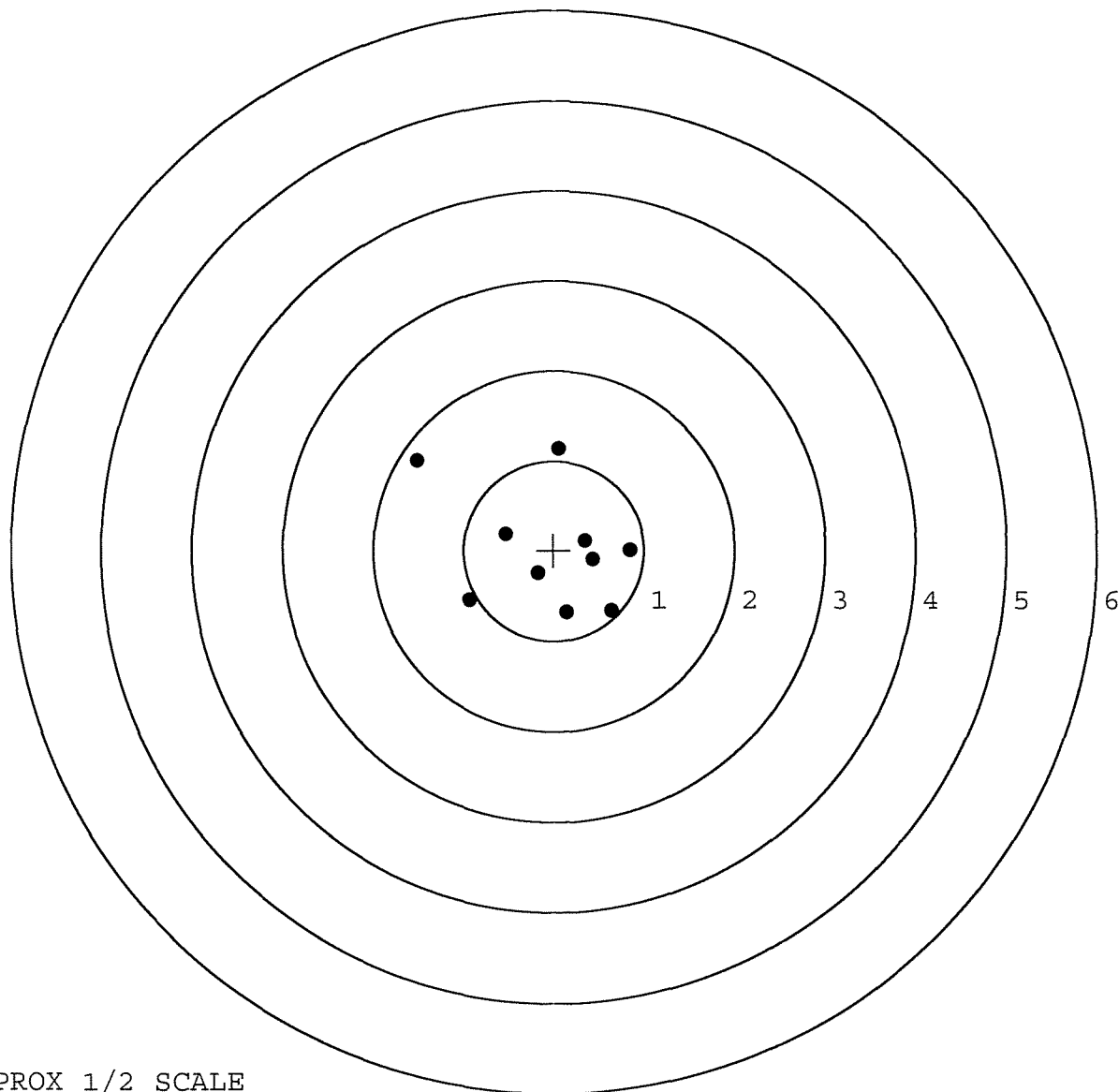


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6360870. __0
TARGET NUMBER: 4
FILE DATE: 11/09/2004
FILE TIME: 08:00

X CENTROID: -0.069
Y CENTROID: 0.016
POA TO CENTROID: 0.071
HORZ SPREAD: 2.361
VERT SPREAD: 1.825
GROUP SPREAD: 2.730
MIN RADIUS: 0.296
MAX RADIUS: 1.750
MEAN RADIUS: 0.829
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 9

POINT#	X	Y
1:	0.642	-0.672
2:	0.847	0.006
3:	0.349	0.110
4:	0.435	-0.105
5:	0.140	-0.691
6:	-0.179	-0.259
7:	-0.533	0.183
8:	-0.938	-0.551
9:	-1.514	1.003
10:	0.059	1.134



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6360870. __0

TARGET NUMBER: 5

FILE DATE: 11/09/2004

FILE TIME: 08:00

X CENTROID: 0.204

Y CENTROID: -0.226

POA TO CENTROID: 0.304

HORZ SPREAD: 2.323

VERT SPREAD: 2.316

GROUP SPREAD: 2.736

MIN RADIUS: 0.318

MAX RADIUS: 1.483

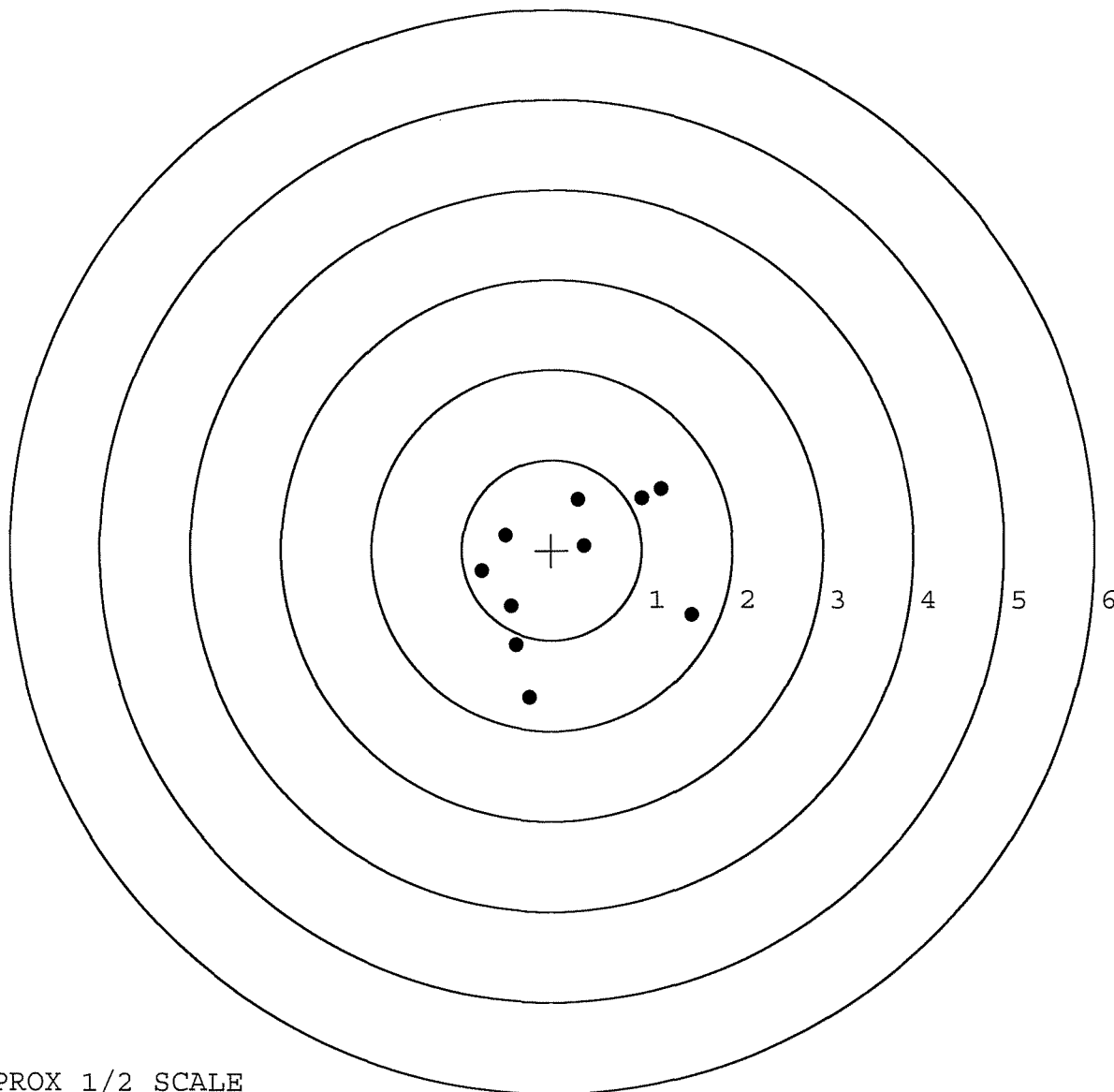
MEAN RADIUS: 1.011

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 5

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	1.549	-0.726
2:	1.211	0.677
3:	0.999	0.580
4:	0.291	0.566
5:	0.365	0.049
6:	-0.509	0.165
7:	-0.774	-0.236
8:	-0.448	-0.627
9:	-0.399	-1.065
10:	-0.246	-1.639



TARGET APPROX 1/2 SCALE

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

SERIAL # C6360870

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	85926		
SERIAL NUMBER	C6225070	G6360870	(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	TRL
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		
615	ROLLMARK CALIBER	10/20/04	LB
618	ROTO-BLAST	10-22-04	LB
620	APPLY COATINGS	10/24/04	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	TRL
655	FINAL INSPECT	11-10-04	
660	PACK	11-10-04	RA
		SHIP DATE	
QAR INSPECTION DATE			

RECEIVING AND ESTIMATING REPORT

ORDER NO. R 96-16430

INITIAL FPS	CUSTOMER ORDER NO.		M24 SNIPER			
DATE RECEIVED 07/12/96	DATE OPENED 07/15/96	DATE CODE	SERIAL NUMBER C6225070	NEW SERIAL NUMBER	MODEL AND GRADE 700 7.62 NATO	
ACCESSORIES W/STUDS		SCOPE BASE				

FROM:

HHC BN ARMS SHOP
2ND BN 75TH RGR RGT
FORT LEWIS

WA 98433

SHIP TO:

HHC BN ARMS SHOP
2ND BN 75TH RGR RGT
FORT LEWIS

WA 98433

CUST NO: 126790 C.O.D.L

ACCOUNT NUMBER	ACCOUNT NUMBER N/C	WRITE ☐	PROM. DATE	ESTIMATED	VIA R83250589
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- 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

WSS#0 96241 #543

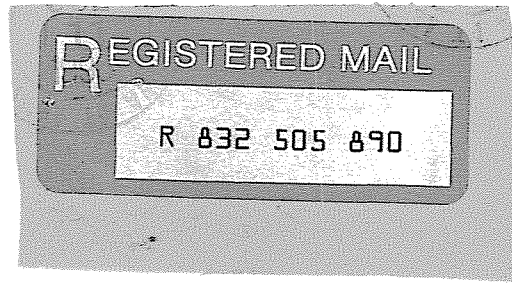
PARTS		COMMENTS					
Barrel	96003	Repowder Coat Trigger Guard Assy Front & Rear Sight Bases ReZinc Scope Base & Swivel Studs					
Stock	96018						
		REPAIRMAN	PROOF	CLEAN	TEST	TARGET	PATTERN
		GALLERY TESTER	DATE	DATE	DATE	DATE	DATE
			7/24/96				

OFFICE COPY

RD6925 REV. 1/94

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER

M2400084217



DA FORM 2785-1, APR 76

SEND TO: ISSD
FT. LEWIS, WA 98433

REQUEST IS FROM: HHC, 475 RGR BN
ATTN: PBO
FT. LEWIS, WA 98433

REF: AVE
W68PXK

1005012402136 EA00001

W68PXK61680001 W81UTH

RIFLE 7.62mm M724
SNIPER WEAPONS SYSTEM (SNS)
SN: C622-5470

1005012402136 EA00001

R45387 8

DATE POSTED: T
DATE AVAILABLE: T
DATE RECEIVED: U
SIGNATURE: S

PREVIOUS EDITION WILL BE USED

REQUEST FOR ISSUE OR TURN-IN (DA Pam 710-2-1)

DA FORM 2785-1, APR 76

SEND TO: ISSD
FT. LEWIS, WA 98433

REQUEST IS FROM: HHC, 475 RGR BN
ATTN: PBO
FT. LEWIS, WA 98433

REF: D65
W68PXK

1005012402136 EA00001

W68PXK61680003 W81UTH

RIFLE 7.62mm M724
SNIPER WEAPONS SYSTEM (SNS)
SN: C622-5470

1005012402136 EA00001

R45387 8

DATE POSTED: T
DATE AVAILABLE: T
DATE RECEIVED: U
SIGNATURE: S

PREVIOUS EDITION WILL BE USED

REQUEST FOR ISSUE OR TURN-IN (DA Pam 710-2-1)

PACKING LIST		PACKED BY <i>Mr Ray Fuller WG-10</i> <i>275 Ranger AS/ES</i> <i>Armorer</i>	1. NO. BOXES /	2a. REQUISITION NO. <i>W68PXX-6168-0003</i>	
3. END ITEM <i>Rifle 7.62mm M24</i> <i>Shipair Weapon System (SWS)</i>		4. DATE 8 July 96			
		5. PAGE <u>1</u> OF <u>1</u> PAGES			
BOX NO. (a)	CONTENTS - STOCK NUMBER AND NOMENCLATURE (b)	UNIT OF ISSUE (c)	QUANTITIES REQUIRED		
			INITIAL OPERATION (d)	RUNNING SPARES (e)	TOTAL (f)
1	<i>1005-01-240-2136 7.62mm M24</i> <i>Shipair Weapon System (SWS)</i>	<i>EA</i>			1
6. THIS CERTIFIES THAT ITEMS LISTED HEREON ARE WITHIN THE SPECIFIED BOXES					
TYPED NAME AND TITLE <i>Ray Fuller WG-10</i> <i>275 Ranger</i> <i>Bn Armorer</i>		SIGNATURE 			

DD FORM 1 SEP 70 **1750**

CONTROL NUMBER		WORK ORDER NUMBER <i>BAR 0001</i>		WESDC		ORG PD <i>02</i>		PD AUTHENTICATION <i>[Signature]</i> LT, Assistant S-4				
☒ WORK REQUEST ☐ MWO ☐ WARRANTY CLAIM		1a. ORGANIZATION <i>1st Bn 75th RGR. RGT</i>				b. LOCATION <i>Fort Lewis, Wa</i>			c. UNIT IDENT CODE <i>WH3MAA</i>			
2. SERIAL NO. <i>C622-5070</i>		3. NOUN NOMENCLATURE <i>762mm SWS</i>		4. LINE NO. <i>R25387</i>		5. MODEL <i>M24</i>		6. NATIONAL STOCK NUMBER <i>1045-01-240-2136</i>				
7. MAINTENANCE ACTIVITY <i>Remington Army</i>		a. LEVEL	8. UTILIZATION CODE	9. MCSR ITEM	a. ERC	b. PACING ITEM	10. HOURS	11. MILES	12. ROUNDS	13. STARTS		
14. FAILURE DETECTED DURING (Select one - use ✓ or X)					15. FIRST INDICATION OF TROUBLE (Select one - use ✓ or X)							
☐ A Scheduled Maintenance ☐ B Handling		☐ C Test ☒ D Normal Op		☐ E Storage ☐ F Inspection		☐ G Flight ☐ H Other		☐ 068 Inoperative ☐ 008 Noisy		☐ 258 Overheating ☒ 387 Low Performance		☒ 790 Out of Adjustment ☐ Other
16. DESCRIBE DEFICIENCIES OR SYMPTOMS ON THE BASIS OF COMPLETE CHECKOUT AND DIAGNOSTIC PROCEDURE IN EQUIPMENT TM (Do not prescribe repairs) <i>Stock Cracked. Weapon Group At 300 Yds is Approx 7.5 inches from bench Rest. Possibly Requires Barrel Change.</i>												
16a. REMARKS <i>Optic Scope Ring Mount sent w/ Weapon</i> <i>POC: Mr Ray Fuller WG-10</i> <i>Bn. Civ. Dr/Gr Armorer 206-967-8055</i> <i>APN-367-8055</i>												

[illegible]

Department of The Army

Commander

2d Bn. 75th Ranger Rgt.

Attn: Mr. Ray Fuller, Bn Arms, Bldg 3474

Box 339510
Fort Lewis,

Wa 98433-9510

OFFICIAL BUSINESS

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6225070

Barrel
Stock

OP. #	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and Stock		7/24/96	RW
600	Proof		7/24/96	RW
607	Check Headspace		7/24/96	RW
610	Dis-assemble Gun		7/24/96	RW
612	Magnaflux Barrel Action			
	Magnaflux Bolt			
615	Rollmark Caliber			
617	Drill and Tap Sight Holes			
618	Polish Barrel			
620	Apply Coatings (Barrel Action)			
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly			
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head			
	C) Inspect Ejector Hole for Chamfer			
	D) Oil Firing Pin Ass'y			
	E) Adjust Trigger Pull to Min Setting and Stake			

op. #	OP. NAME	READINGS	DATE	INIT
625 cont.	F) Safety On Force			
	G) Safety Off Force			
	H) Trigger Pull Test & Retainability			
	I) Firing Pin Indent			
	J) Assemble Stock			
	K) Assemble Swivel Studs			
	L) Attach Front and Rear Sight Assemblies			
	M) Iron Sight Alignment			
	N) Detach Front & Rear Sights & place in numbered container			
	O) Attach Scope to Rifle			
	P) Detach & Attach Scope 20 Times			
640	Gallery Target & Test			
	A) Time			
	B) Malfunctions			
	C) Pierced Primers			
	D) Optical Clarity of Scope			
645	Inspect for Live Ammo			
655	Final Inspection A) Headspace			
	B) Trigger Pull			
	C) Function			
660	Pack			

Final Inspection

Sr: C6273070

DATE REC'D: 7/15/96

DATE RET'D:

AUDITOR: RW

Item:

BARREL ASSY.

☒ BARREL

☒ RECEIVER

☒ FRONT SIGHT BLOCK

☒ REAR SIGHT BLOCK

☒ SCREWS

☒ FINISH

SCOPE ASSY.

☐ SCOPE

☐ SCOPE RINGS

☐ MOUNTING SCREWS

☐ MOUNTING BASE

☐ SCREWS

☐ FINISH

☐ LOOSENESS

☐ CLARITY

MISC.

☐ DD-250

☐ BAR CODE

☐ PACKAGING

Item:

STOCK ASSY.

☒ STOCK

☒ SLING SWIVEL STUDS

☒ ADJUSTABLE BUTT PLATE

☒ LOCK NUTS

☒ BARREL CLEARANCE

☒ COLOR/FINISH

SYSTEMS CASE

☐ SCOPE CASE

☐ IRON SIGHTS

☐ DEPLOYMENT KIT

TRIGGER

☒ SAFETY OPERATION

☒ SET

Comments:

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6225070

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

Op. #	Op. NAME	READINGS				DATE	INIT
625 cont.	F) Safety On Force						
	G) Safety Off Force						
	H) Trigger Pull Test & Retainability						
	I) Firing Pin Indent						
	J) Assemble Stock					7/27/92	EW
	K) Assemble Swivel Studs						
	L) Attach Front and Rear Sight Assemblies						
	M) Iron Sight Alignment						
	N) Detach Front & Rear Sights & place in numbered container						
	O) Attach Scope to Rifle						
	P) Detach & Attach Scope 20 Times						
640	Gallery Target & Test						
	A) Time						
	B) Malfunctions						
	C) Pierced Primers						
	D) Optical Clarity of Scope						
645	Inspect for Live Ammo						
655	Final Inspection						
	A) Headspace						
	B) Trigger Pull						
	C) Function						
660	Pack						

RECEIVING AND ESTIMATING REPORT

ORDER
R92-11755

INITIAL FPS		CUSTOMER ORDER NO.		M-24 SWS W/SCOPE PAINTED CAMO	
DATE RECEIVED 05/11/92	DATE OPENED 05/20/92	DATE CODE	SERIAL NUMBER C6225070	NEW SERIAL NUMBER	MODEL AND GRADE 700 7.62 NATO
ACCESSORIES W/STUDS		SCOPE BASE SOFT CASE L/FRONT SIGHT			

FROM:	SHIP TO:
DEPT OF THE ARMY B CO ARMS 2/75 RANGER BATTALION FT LEWIS WA 98433	DEPT OF THE ARMY B CO ARMS 2/75 RANGER BATTALION FT LEWIS WA 98433

see Below

ACCOUNT NUMBER	ACCOUNT NUMBER N/C	CUST NO: 062072 C.O.D	WRITE ☐ CLEAN/TEST	PROM. DATE	ESTIMATED	VIA R765480543
----------------	--------------------	-----------------------	---	------------	-----------	-------------------

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

*Refinish BBL - Re
Replace Stock Assy
Refinish Trig Guard*

PARTS	COMMENTS												
	<i>W68PXK21690</i>												
	<i>W68PXK</i>												
	<i>Acct. Prop Officer Mr. FLATBOW 357-4577</i>												
	<i>W52H092171#227</i>												
	<table border="1"> <tr> <td>REPAIRMAN</td> <td>PROOF</td> <td>CLEAN</td> <td>TEST</td> <td>TARGET</td> <td>PATTERN</td> </tr> <tr> <td>GALLERY TESTER</td> <td>DATE</td> <td>DATE</td> <td>DATE</td> <td>DATE</td> <td>DATE</td> </tr> </table>	REPAIRMAN	PROOF	CLEAN	TEST	TARGET	PATTERN	GALLERY TESTER	DATE	DATE	DATE	DATE	DATE
REPAIRMAN	PROOF	CLEAN	TEST	TARGET	PATTERN								
GALLERY TESTER	DATE	DATE	DATE	DATE	DATE								

DEPARTMENT OF THE ARMY

Commander 2/5 Ranger

Pt. Lewis, Wa 98433

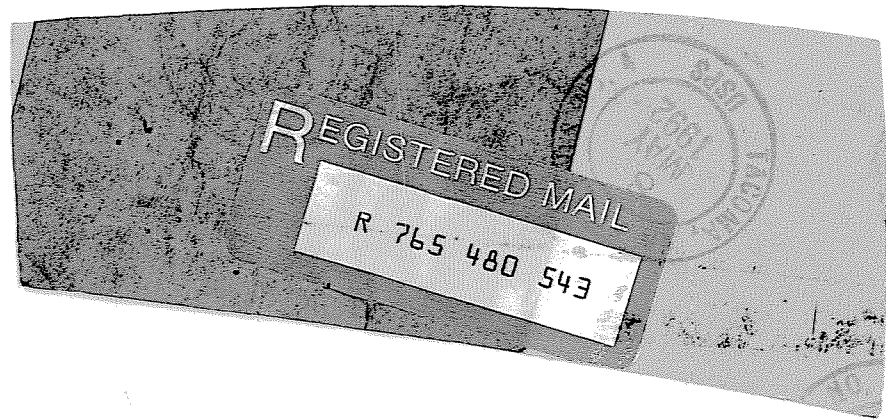
OFFICIAL BUSINESS

PENALTY FOR PRIVATE USE \$300

DA Label 18-1, Sep 83
Edition of Oct 74 will be used until exhausted.

Newington Arms Co.
Attn: Custom Shop
14 Hoefler, Ave.
Ilion, NY 13357





FROM
B CO ARIAS
2175 RANGER BATTALION
FT. LEWIS, WA 98433

6a. REMARKS

7a. REPAIR ORGANIZATION/ACTIVITY	c. UNIT IDENT CODE	18. TYPE ORGANIZATION/ACTIVITY ACCOMPLISHING WORK (Select one - use ☒ for X)	19. AMS ACCOUNT CODE
LOCATION		☐ 1 TOE ☐ 2 TD ☐ 3 CONTRACTOR	

FORM 9107 EDITION OF JUL 79 IS OBSOLETE.

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6225070

OP. #	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and Stock	9 12	8 8	FB
600	Proof	9 19	8 8	RW
607	Check Headspace	9 19	8 8	RW
610	Dis-assemble Gun	9 19	8 8	RW
612	Magnaflux Barrel Action		9-22-88	Pfe
	Magnaflux Bolt		9-22-88	Pfe
615	Rollmark Caliber			
617	Drill and Tap Sight Holes			
618	Polish Barrel			
620	Apply Coatings (Barrel Action)		10-31-88	TJA
	Apply Coating (Bolt)		10-31-88	TJA
625	Final Assembly A) Clean inside of Bolt Assembly		11/4/88	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		11/4/88	RW
	C) Inspect Ejector Hole for Chamfer		11/4/88	RW
	D) Oil Firing Pin Ass'y		11/4/88	RW
	E) Adjust Trigger Pull to Min Setting and Stake		9-00-88	JIS

op. #	OP. NAME	READINGS					DATE	INITIAL
625 cont.	F) Safety On Force	5	5	5			9/10/88	JS
	G) Safety Off Force	3	3	3			9/10/88	JS
	H) Trigger Pull Test & Retainability						9/10/88	JS
	I) Firing Pin Indent	0205	0205	0205			9/10/88	JS
	J) Assemble Stock						11/10/88	RW
	K) Assemble Swivel Studs						11/10/88	RW
	L) Attach Front and Rear Sight Assemblies						11/10/88	RW
	M) Iron Sight Alignment						11/10/88	RW
	N) Detach Front & Rear Sights & place in numbered container						11/10/88	RW
	O) Attach Scope to Rifle						11/15/88	WB
	P) Detach & Attach Scope 20 Times						11/15/88	WB
640	Gallery Target & Test	54 R	98 L				11/16/88	DH
	A) Time							
	B) Malfunctions							
	C) Pierced Primers							
	D) Optical Clarity of Scope						11/16/88	DH
645	Inspect for Live Ammo						11/16/88	DH
655	Final Inspection							
	A) Headspace						30/10/88	JS
	B) Trigger Pull	2.75	2.69	2.67	2.65	2.66	30/10/88	JS
	C) Function						30/10/88	JS
660	Pack						14 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. C6225070

DATE 9 NOV 88

TESTER JUL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.43	2.30	2.39	2.75	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.23	2.38	2.47	2.69	
PULL #3	2.26	2.32	2.46	2.67	
PULL #4	2.22	2.39	2.41	2.65	
PULL #5	2.27	2.28	2.47	2.66	
TOTAL	11.41	11.67	11.80	13.32	
AVG.	2.282	2.334	2.36	2.664	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.30	3.27		
PULL #2	3.36	3.33		
PULL #3	3.29	3.36		
PULL #4	3.30	3.36		
PULL #5	3.32	3.36		
TOTAL	16.57	16.68		
AVG.	3.314	3.336		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.12	3.99		4.00
PULL #2	4.05	4.00		4.21
PULL #3	4.07	4.02		4.15
PULL #4	4.04	4.05		4.22
PULL #5	4.09	4.05		4.18
TOTAL	20.37	20.11		20.76
AVG.	4.074	4.022		4.152

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6225070

CENTROIDAL DISTANCES

0 TO	1	.253779
1 TO	2	.139176
1 TO	3	.476555
1 TO	4	.501866
1 TO	5	.284431

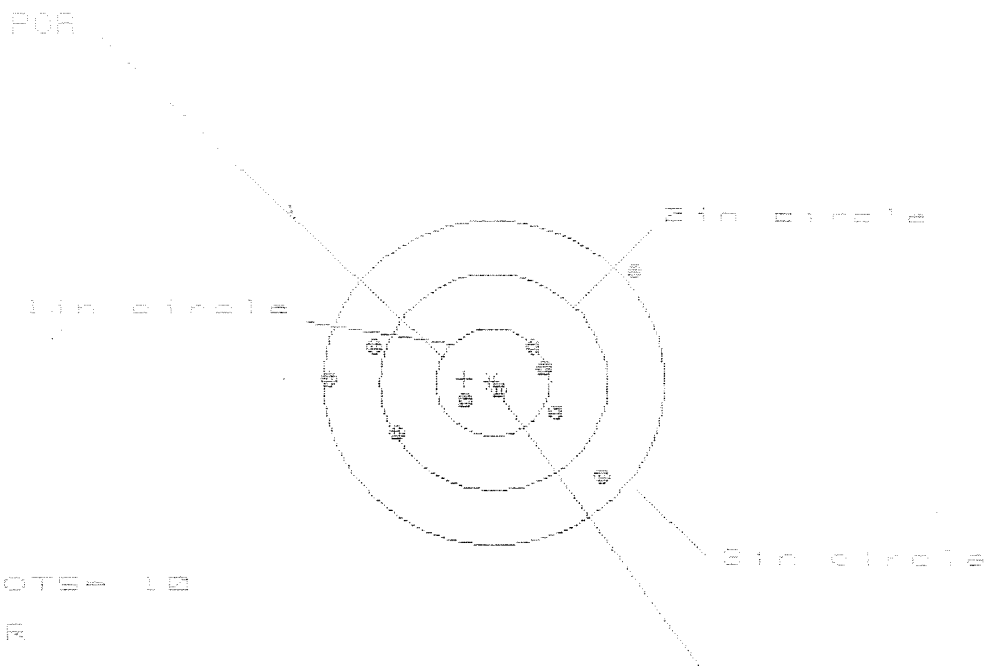
END (----FOR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0158
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0912
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0925565
THE AMR FOR THIS RIFLE IS: .863

17 Nov 1998

FILE:/PATTERNING/CENTERFIRE_PATT/06225070

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1in = 4

2in = 6

3in = 9

HE = 2.692

VE = 1.835

GE = 2.877

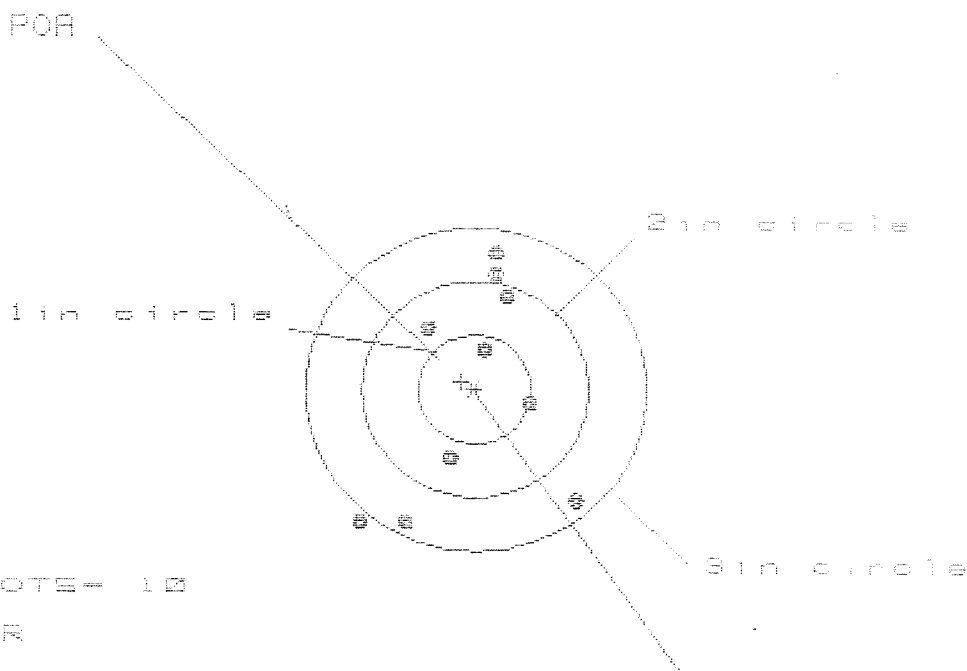
CENTROID #

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.264	1.112	.951
MINIMUM X	:	-1.428	-1.287	-1.060
MAXIMUM Y	:	1.008	.424	.437
MINIMUM Y	:	-.827	-.714	-.701
CENTROID X	:	.252	.111	.272
CENTROID Y	:	-.030	-.143	-.156
POR TO CENTROID in.	:	.254	.181	.314
MIN RADIUS	:	.076	.136	.054
MEAN RADIUS	:	.020	.733	.639
MAX RADIUS	:	1.617	1.322	1.181
HORIZONTAL SPREAD	:	2.692	2.399	2.011
VERTICAL SPREAD	:	1.835	1.138	1.138
EXTREME SPREAD	:	2.877	2.536	2.297
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

17 May 1988

FILE:/PATTERNING/CENTERFIRE_PATT/08225070

CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 5

3 in = 9

HS = 1.875

VS = 2.499

GS = 2.716

CENTROID #

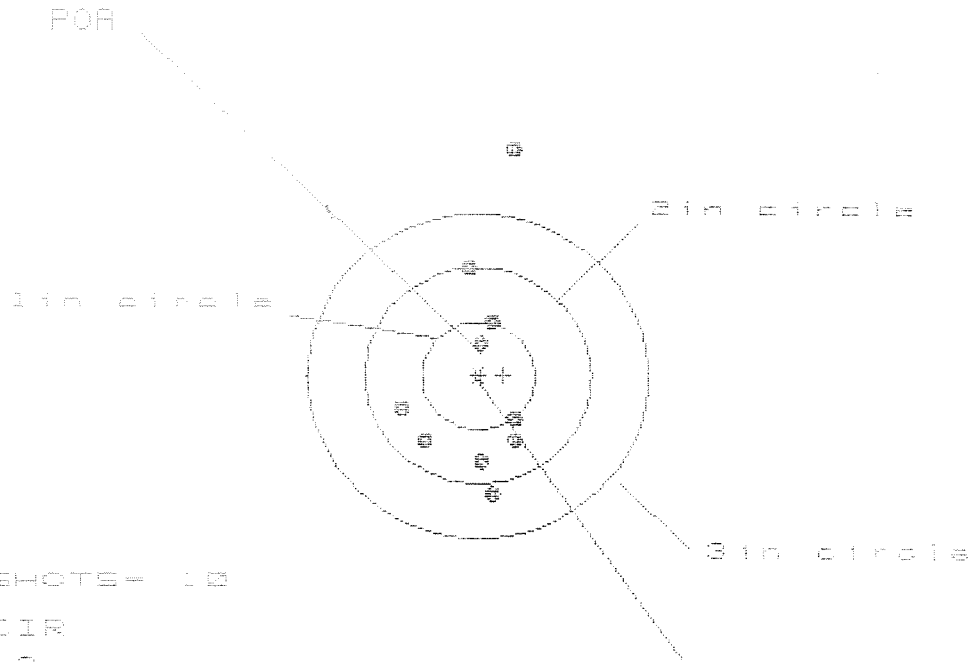
PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.983	.795	.506
MINIMUM X	:	-.972	-.696	-.596
MAXIMUM Y	:	1.291	1.159	1.011
MINIMUM Y	:	-1.208	-1.340	-1.480
CENTROID X	:	.119	.227	.127
CENTROID Y	:	-.071	.061	.209
POR TO CENTROID in.	:	.138	.235	.245
MIN RADIUS	:	.399	.250	.148
MEAN RADIUS	:	.985	.892	.791
MAX RADIUS	:	1.534	1.510	1.603
HORIZONTAL SPREAD	:	1.875	1.491	1.102
VERTICAL SPREAD	:	2.499	2.499	2.499
EXTREME SPREAD	:	2.716	2.604	2.604
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

17 Nov 1988

FILE:/PATTERNING/CENTERFIRE_PATT/08225070

CENTERFIRE PATTERNS

3



OF SHOTS= 10

IN CIR

1in = 2

2in = 8

3in = 9

HS= 1.041

VS= 3.172

GS= 3.177

CENTROID *

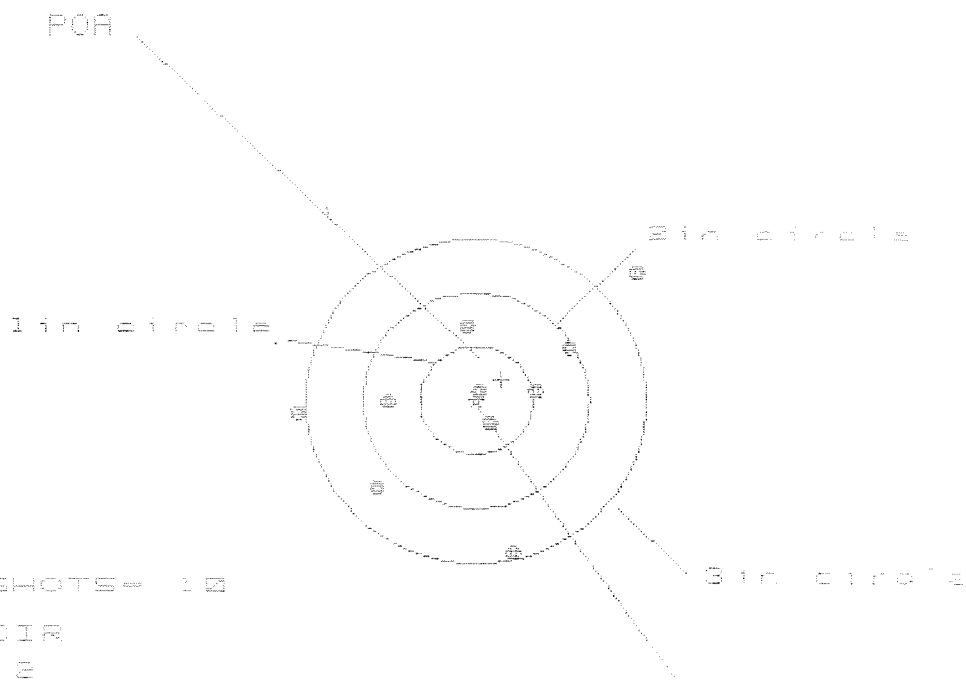
PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.355	.396	.416
MINIMUM X	-.686	-.947	-.621
MAXIMUM Y	2.074	1.227	1.119
MINIMUM Y	-1.098	-.867	-.698
CENTROID X	-.224	-.263	-.289
CENTROID Y	-.007	-.238	-.130
FOR TO CENTROID in.	.224	.355	.317
MIN RADIUS	.260	.412	.388
MEAN RADIUS	.851	.678	.653
MAX RADIUS	2.105	1.228	1.119
HORIZONTAL SPREAD	1.041	1.037	1.037
VERTICAL SPREAD	3.172	2.094	1.869
EXTREME SPREAD	3.177	2.109	1.811
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		8	
NUMBER IN THREE INCH CIRCLE =		9	

17 Nov 1988

FILE:/PATTERNING/CENTERFIRE_PATT/06225070

CENTERFIRE PATTERNS

4



OF SHOTS = 10

IN CIR

1 in = 2

2 in = 5

3 in = 8

HS = 2.863

VS = 2.602

CS = 3.210

CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.422	.965	.792
MINIMUM X	-1.541	-1.383	-1.892
MAXIMUM Y	1.151	.803	.808
MINIMUM Y	-1.451	-1.323	-1.318
CENTROID X	-.223	-.381	-.208
CENTROID Y	-.192	-.320	-.325
POA TO CENTROID in.	.294	.498	.387
MIN RADIUS	.081	.271	.118
MEAN RADIUS	.925	.847	.746
MAX RADIUS	1.830	1.420	1.362
HORIZONTAL SPREAD	2.963	2.348	1.675
VERTICAL SPREAD	2.602	2.126	2.126
EXTREME SPREAD	3.210	2.415	2.176
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	8		

17 Nov 1988

FILE:/PATTERNING/CENTERFIRE_PATT/08285070

CENTERFIRE PATTERNS # 5

POR

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS = 10

IN ONE

1in = 3

2in = 7

3in = 10

1st = 1.817

2nd = 2.240

3rd = 2.510

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.897	.485	.436
MINIMUM X	:	-.720	-.598	-.647
MAXIMUM Y	:	1.053	1.136	.998
MINIMUM Y	:	-1.187	-1.104	-.621
CENTROID X	:	-.802	-.125	-.075
CENTROID Y	:	-.156	-.239	-.101
POR TO CENTROID in.	:	.156	.269	.127
MIN RADIUS	:	.141	.097	.079
MEAN RADIUS	:	.734	.652	.585
MAX RADIUS	:	1.325	1.235	1.089
HORIZONTAL SPREAD	:	1.817	1.083	1.083
VERTICAL SPREAD	:	2.240	2.240	1.619
EXTREME SPREAD	:	2.510	2.403	1.947
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

RECEIVING AND ESTIMATING REPORT

R 92-11755

INITIAL FPS	CUSTOMER ORDER NO.	M-24 SWS W/SCOPE PAINTED CAMO				
DATE RECEIVED 05/11/92	DATE OPENED 05/20/92	DATE CODE	SERIAL NUMBER C6225070	NEW SERIAL NUMBER	MODEL AND GRADE 700 7.62	NATO
ACCESSORIES W/STUDS		SCOPE BASE		SOFT CASE L/FRONT SIGHT		

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.B.D L

ACCOUNT NUMBER	ACCOUNT NUMBER N/C	WRITE ☐	CLEAN/TEST	PROM. DATE	ESTIMATED	VIA	
						R765480543	
GUN CONDITION	REGISTERED MAIL R 512 380 907					REPAIR CHARGE	
☐ NEW						USPS	EXCISE PRIORITY
☐ LIGHTLY WORN						73	TAX
☐ WORN						21 LB 14 0 OZ	INSURANCE
☐ VERY WORN						N SP	UPS
☐ UNREPAIRABLE						JV HND	PARCEL POST
☐ MARRED	TOTAL CHARGE					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

REFINISH BBL - Re
REPLACE STOCK ASSY
REFINISH TRIG GUARD

PARTS	COMMENTS					
	W68PX K2169					
	W68PXE					
	Acct. Prop Officer					
	Mr. FLATBOW 357-4577					
	W53H092171#227					
	REPAIRMAN	PROOF	CLEAN	TEST	TARGET	PATTERN
	GALLERY TESTER	DATE	DATE	DATE	DATE	DATE

WITH GUN

P6925 REV. 1/92

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER

M2400084242

MATERIAL INSPECTION AND RECEIVING REPORT

Form Approved
OMB No. 0704-0248
Expires Dec 31, 1990

Public reporting burden for this collection of information is estimated to average 35 minutes per response, including the time for reviewing instructions, searching existing data sources, gathering and maintaining the data needed, and completing and reviewing the collection of information. Send comments regarding this burden estimate or any other aspect of this collection of information, including suggestions for reducing this burden, to Washington Headquarters Services, Directorate for Information Operations and Reports, 1215 Jefferson Davis Highway, Suite 1204, Arlington, VA 22202-4302, and to the Office of Management and Budget, Paperwork Reduction Project (0704-0248), Washington, DC 20503.

1. PROC. INSTRUMENT IDEN. (CONTRACT) DAAA21-87-G-0001	(ORDER) NO. 0022L	6. INVOICE RAC0011	7. PAGE 1	OF 1	8. ACCEPTANCE POINT S
--	----------------------	-----------------------	--------------	---------	--------------------------

2. SHIPMENT NO. RAC0011	3. DATE SHIPPED 30 JUL 92 E	4. BL TCN	5. DISCOUNT TERMS H	NET 30 DAYS
----------------------------	--------------------------------	--------------	------------------------	-------------

9. PRIME CONTRACTOR REMYNGTON ARMS CO INC 14 HOEFLE AVE ILION, N.Y. 13357	10. ADMINISTERED BY DCMAO - SYRACUSE 615 ERIE BLVD WEST SYRACUSE, N.Y. 13204-2408
--	--

11. SHIPPED FROM (if other than 9) REMYNGTON ARMS CO INC 14 HOEFLE AVE ILION, N.Y. 13357	12. PAYMENT WILL BE MADE BY DFAS - COLUMBUS BUNKER HILL DIVISION PO BOX 182077 COLUMBUS, OH. 43218-2077
---	---

13. SHIPPED TO ACCOUNTABLE PROPERTY OFFICER ATTN: MR. FLATBOHU 357-4577 FT LEWIS, WA. 98433	14. MARKED FOR ACCOUNTABLE PROPERTY OFFICER ATTN: MR FLATBO 357-4577 FT LEWIS, WA. 98433
--	---

15. ITEM NO.	16. STOCK/PART NO. (Indicate number of shipping containers - type of container - container number.)	DESCRIPTION	17. QUANTITY SHIP/REC'D *	18. UNIT	19. UNIT PRICE	20. AMOUNT
0007 AA		REPLACE STOCK ASSEMBLY P/N 96018	1	EA	\$522.04	\$522.04
0007 AB		REFINISH TRIGGER GUARD P/N 96099	1	EA	\$ 33.17	\$ 33.17
0002 AG		EXPEDITING FEE	1	EA	\$ 55.00	\$ 55.00
		POSTAGE & HANDLING 1 CARTON - U.S MAIL WGT: MILSTRIP W52H092171H227	1		\$30.80	\$30.80

21. PROCUREMENT QUALITY ASSURANCE <table style="width: 100%;"> <tr> <td style="width: 50%;"> A. ORIGIN ☒ PQA ☒ ACCEPTANCE of listed items has been made by me or under my supervision and they conform to contract, except as noted herein or on supporting documents. 92 Jul 30 <i>Bernard Riley</i> DATE SIGNATURE OF AUTH GOVT REP TYPED NAME AND OFFICE BERNARD RILEY S3306A </td> <td style="width: 50%;"> B. DESTINATION ☐ PQA ☐ ACCEPTANCE of listed items has been made by me or under my supervision and they conform to contract, except as noted herein or on supporting documents. DATE SIGNATURE OF AUTH GOVT REP TYPED NAME AND TITLE </td> </tr> </table>	A. ORIGIN ☒ PQA ☒ ACCEPTANCE of listed items has been made by me or under my supervision and they conform to contract, except as noted herein or on supporting documents. 92 Jul 30 <i>Bernard Riley</i> DATE SIGNATURE OF AUTH GOVT REP TYPED NAME AND OFFICE BERNARD RILEY S3306A	B. DESTINATION ☐ PQA ☐ ACCEPTANCE of listed items has been made by me or under my supervision and they conform to contract, except as noted herein or on supporting documents. DATE SIGNATURE OF AUTH GOVT REP TYPED NAME AND TITLE	22. RECEIVER'S USE Quantities shown in column 17 were received in apparent good condition except as noted. DATE RECEIVED SIGNATURE OF AUTH GOVT REP TYPED NAME AND OFFICE * If quantity received by the Government is the same as quantity shipped, indicate by (✓) mark, if different, enter actual quantity received below quantity shipped and encircle.
A. ORIGIN ☒ PQA ☒ ACCEPTANCE of listed items has been made by me or under my supervision and they conform to contract, except as noted herein or on supporting documents. 92 Jul 30 <i>Bernard Riley</i> DATE SIGNATURE OF AUTH GOVT REP TYPED NAME AND OFFICE BERNARD RILEY S3306A	B. DESTINATION ☐ PQA ☐ ACCEPTANCE of listed items has been made by me or under my supervision and they conform to contract, except as noted herein or on supporting documents. DATE SIGNATURE OF AUTH GOVT REP TYPED NAME AND TITLE		

23. CONTRACTOR USE ONLY

SERIAL #: C6225070

FRED MARTIN
CONTRACT COORDINATOR/GOVT. SALES
REMYNGTON ARMS CO INC
ILION, NEW YORK 13357
PHONE: 315-894-9961 EXT. 282

R 94-24905

INITIAL	CUSTOMER ORDER NO.
JJM	

DATE RECEIVED	DATE OPENED	DATE CODE	SERIAL NUMBER	NEW SERIAL NUMBER	MODEL AND GRADE
08/29/94	08/30/94	DI 9-88	C6225070		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.DL

ACCOUNT NUMBER

ACCOUNT NUMBER N/C

WRITE

PROM. DATE

ESTIMATED

VIA

UP 5

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
Mag Spring - 15627

Repowder Coat Trigger Guard
Assy, Front & Rear Sight Bases
Rezinc Scope Base, Rings &
Swivel Studs

REPAIRMAN <i>RW</i>	PROOF <i>✓</i>	CLEAN <i>✓</i>	TEST <i>✓</i>	TARGET <i>✓</i>	PATTERN
GALLERY TESTER <i>RW</i>	DATE <i>9/1/94</i>	DATE <i>9/12/94</i>	DATE <i>9/12/94</i>	DATE <i>9/12/94</i>	DATE

OFFICE COPY

BD6925 REV 1/94

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER

M2400084245

PACKING LIST		PACKED BY <i>Mr. Ray Fuller</i> WG-10 Bn. Armorer.	1. NO. BOXES /	2a. REQUISITION NO. <i>94240</i>	
				2b. ORDER NO.	
3. END ITEM <i>7.62mm M24 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)
1	<i>7.62mm M24 Sniper Weapon System (SW5) Serial No. <u>CG225070</u></i> <i>NSN: 1005-01-240-2136</i> <u>Note: All Optic Scope</u> <u>Ring mounts Packed</u>	<i>EA</i>			<i>1</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

S.N: C6225070 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 # C6225070
15 Sep 1994

CENTROIDAL DISTANCES

0 TO	1	.354035
1 TO	2	.403586
1 TO	3	.785148
1 TO	4	.360212
1 TO	5	.45284

$\frac{9 \times 10^9}{1}$ <----POA

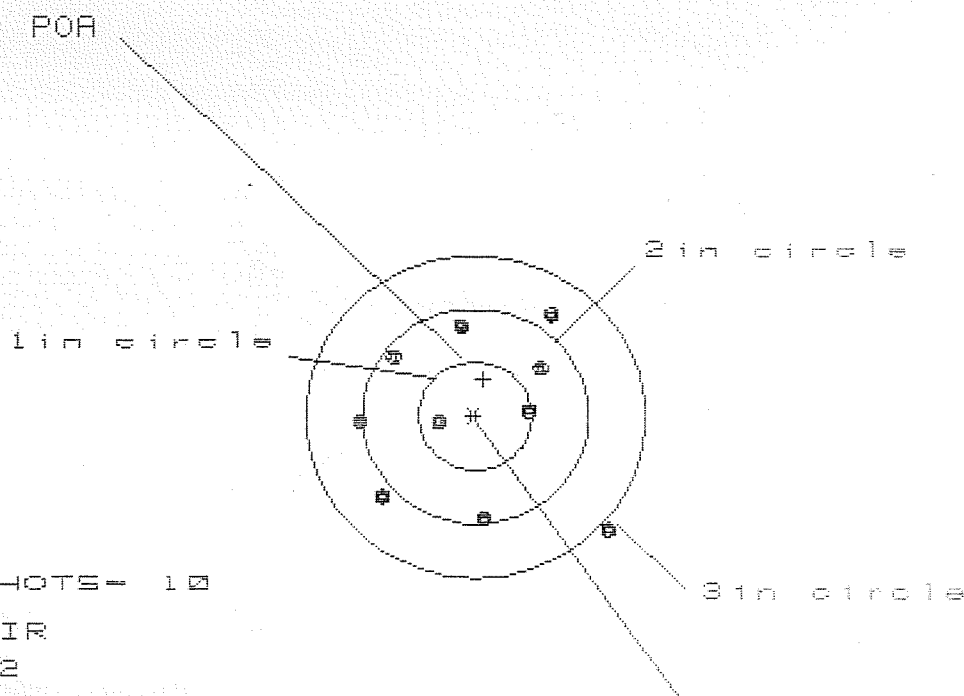
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0056
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0102
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0116362

THE AMR FOR THIS RIFLE IS: .9632

15 Sep 1994

FILE:/PATTERNING/CENTERFIRE_PATT/C6225070

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 2

2in = 6

3in = 9

HS= 2.245

VS= 2.058

GS= 2.484

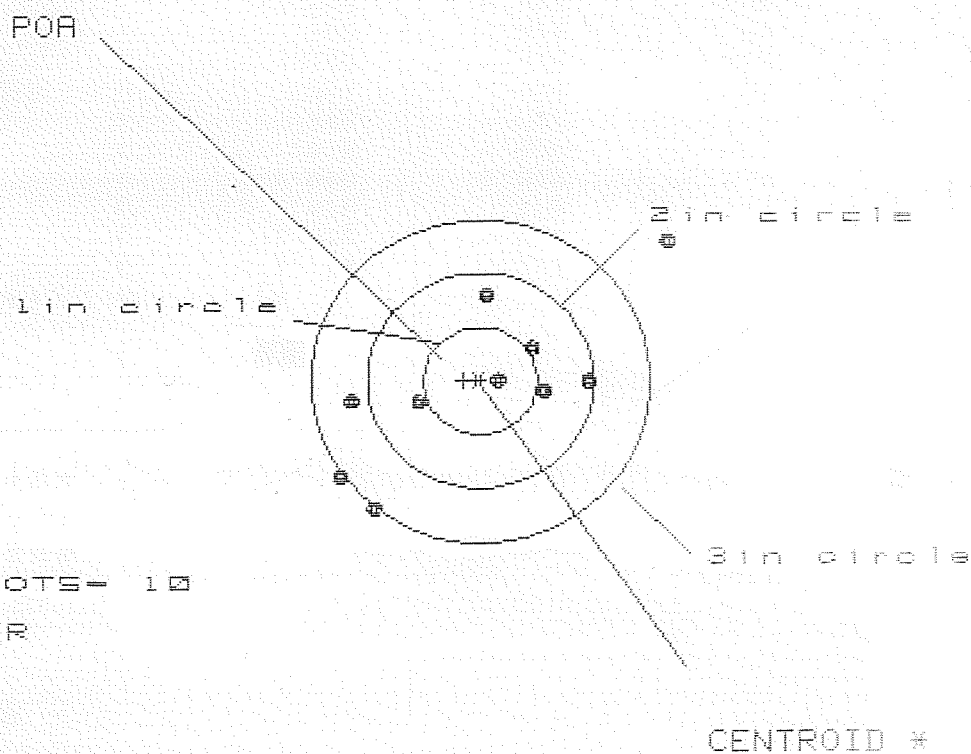
CENTROID #

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.173	.815	.768
MINIMUM X	:	-1.072	-.941	-.840
MAXIMUM Y	:	.978	.858	.844
MINIMUM Y	:	-1.080	-1.042	-.934
CENTROID X	:	-.075	-.206	-.307
CENTROID Y	:	-.346	-.226	-.334
POA TO CENTROID in.	:	.354	.306	.454
MIN RADIUS	:	.289	.216	.069
MEAN RADIUS	:	.908	.813	.750
MAX RADIUS	:	1.594	1.183	.980
HORIZONTAL SPREAD	:	2.245	1.756	1.607
VERTICAL SPREAD	:	2.058	1.900	1.778
EXTREME SPREAD	:	2.484	2.300	1.801
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 5

3 in = 9

HS= 2.900

VS= 2.506

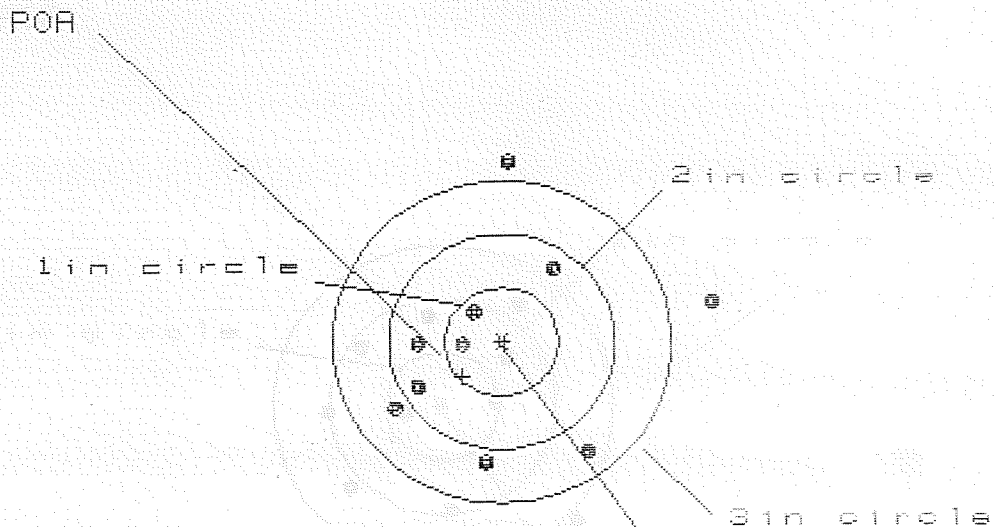
GS= 3.652

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.699	1.131	1.004
MINIMUM X	:	-1.201	-1.012	-1.101
MAXIMUM Y	:	1.339	.933	.842
MINIMUM Y	:	-1.167	-1.018	-1.109
CENTROID X	:	.144	-.045	.082
CENTROID Y	:	-.007	-.156	-.065
POA TO CENTROID in.	:	.144	.162	.104
MIN RADIUS	:	.143	.365	.214
MEAN RADIUS	:	.983	.869	.787
MAX RADIUS	:	2.163	1.249	1.395
HORIZONTAL SPREAD	:	2.900	2.143	2.105
VERTICAL SPREAD	:	2.506	1.951	1.951
EXTREME SPREAD	:	3.652	2.325	2.199
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1 in = 2

2 in = 5

3 in = 8

HS = 2.771

VS = 2.809

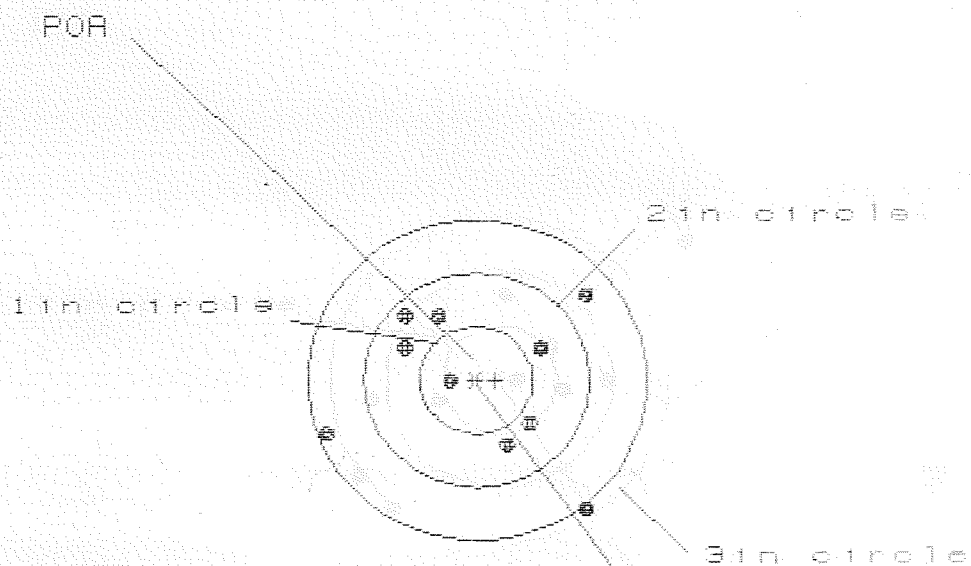
GS = 2.944

PATTERN #	3	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.832	.931	.967
MINIMUM X	-.939	-.736	-.700
MAXIMUM Y	1.726	1.773	.993
MINIMUM Y	-1.083	-1.036	-.815
CENTROID X	.344	.141	.105
CENTROID Y	.318	.271	.050
POA TO CENTROID in.	.469	.306	.116
MIN RADIUS	.356	.148	.232
MEAN RADIUS	1.018	.859	.732
MAX RADIUS	1.879	1.795	1.230
HORIZONTAL SPREAD	2.771	1.667	1.667
VERTICAL SPREAD	2.809	2.809	1.808
EXTREME SPREAD	2.944	2.818	1.930
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	8		

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 7

3 in = 9

HS= 2.341

VS= 2.009

GS= 2.688

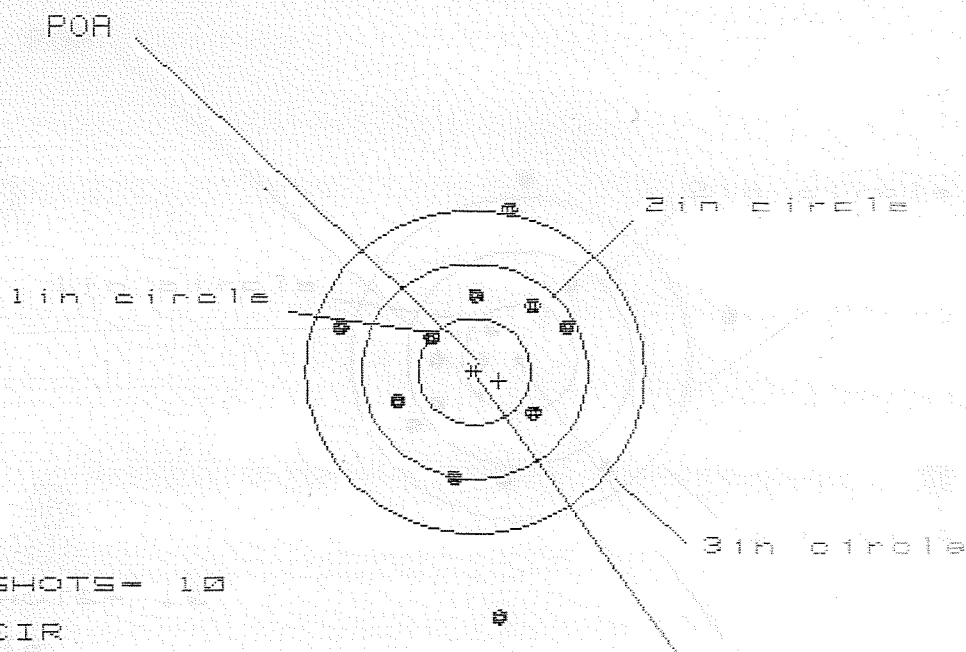
CENTROID *

PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.016	1.126	1.974
MINIMUM X	-1.325	-1.215	-1.713
MAXIMUM Y	.825	.694	.615
MINIMUM Y	-1.184	-1.772	-1.851
CENTROID X	-1.168	-1.278	-1.126
CENTROID Y	-.0002	-.133	-.212
POA TO CENTROID in.	.168	.308	.246
MIN RADIUS	.275	.208	.378
MEAN RADIUS	.882	.786	.718
MAX RADIUS	1.541	1.368	1.152
HORIZONTAL SPREAD	2.341	2.341	1.697
VERTICAL SPREAD	2.009	1.466	1.466
EXTREME SPREAD	2.688	2.688	1.757
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		9	

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CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1 in = 0

2 in = 7

3 in = 9

HS= 1.921

VS= 3.781

GS= 3.781

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.781	.807	.844
MINIMUM X	:	-1.140	-1.114	-1.077
MAXIMUM Y	:	1.469	1.212	.612
MINIMUM Y	:	-2.312	-1.234	-1.083
CENTROID X	:	-.217	-.243	-.280
CENTROID Y	:	.084	.341	.190
POA TO CENTROID in.	:	.233	.419	.338
MIN RADIUS	:	.517	.397	.407
MEAN RADIUS	:	1.025	.841	.791
MAX RADIUS	:	2.324	1.247	1.121
HORIZONTAL SPREAD	:	1.921	1.921	1.921
VERTICAL SPREAD	:	3.781	2.446	1.694
EXTREME SPREAD	:	3.781	2.484	1.921
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

CONTRACT # DAAA21-87-C-0086

New Barrel

GUN SERIAL # C6225070

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						9/12/02	WB
	A) Time						9/12	WB
	B) Malfunctions						9/12/02	WB
	C) Pierced Primers						9/12/02	WB
	D) Optical Clarity of Scope						9/12/02	WB
645	Inspect for Live Ammo						9/12/94	RW
655	Final Inspection							
	A) Headspace						9/14/94	RW
	B) Trigger Pull	2.52	2.85	2.92	2.90	2.90	9/14/94	RW
	C) Function						9/14/94	RW
660	Pack							