

G653 5209
Raphae
C.6649175

Repair Inquiry

Repair Number: RE00121082

Serial: G6535209 Model M24 SWS Center Fire
Caliber: 7.62 NATO

Repairman:

Status: New 12/1/2006 10:55:31 AM

Verify Repair

Address Information

Customer:

☒ Received From

Return To:

☐ Received From

Name: MARKSMANSHIP TNG

MARKSMANSHIP TNG

Address 1: KINDER, DONNIE BLDG 4900

KINDER, DONNIE BLDG 4900

Address 2: CAMP JOSEPH T ROBINSON

PO Box:

CAMP JOSEPH T ROBINSON

PO Box:

City: NORTH LITTLE ROCK

NORTH LITTLE ROCK

State: AR

Zip Code: 72199

Country: US

State: AR

Zip Code: 72199

Country: US

FFL:

Contact / Condition

Problems

Estimate

History / Status

Shipping / Billing

Contact Information

Phone: NA

Fax:

Email:

Comments:

Received Condition

Fair

Condition
Notes:CSR
Notes:

Accessories Received

Code	Desc	Qty
A007	With Stud	3
A017	Scope Base	1
A057	Fit and Rear Sgt Base	1

Repair Search

Refresh

Close

naglel

12/4/2006

9:35 AM

CAPS

NUM

INS

SERL

Serial Number: G6535209

Model: M24 SWS

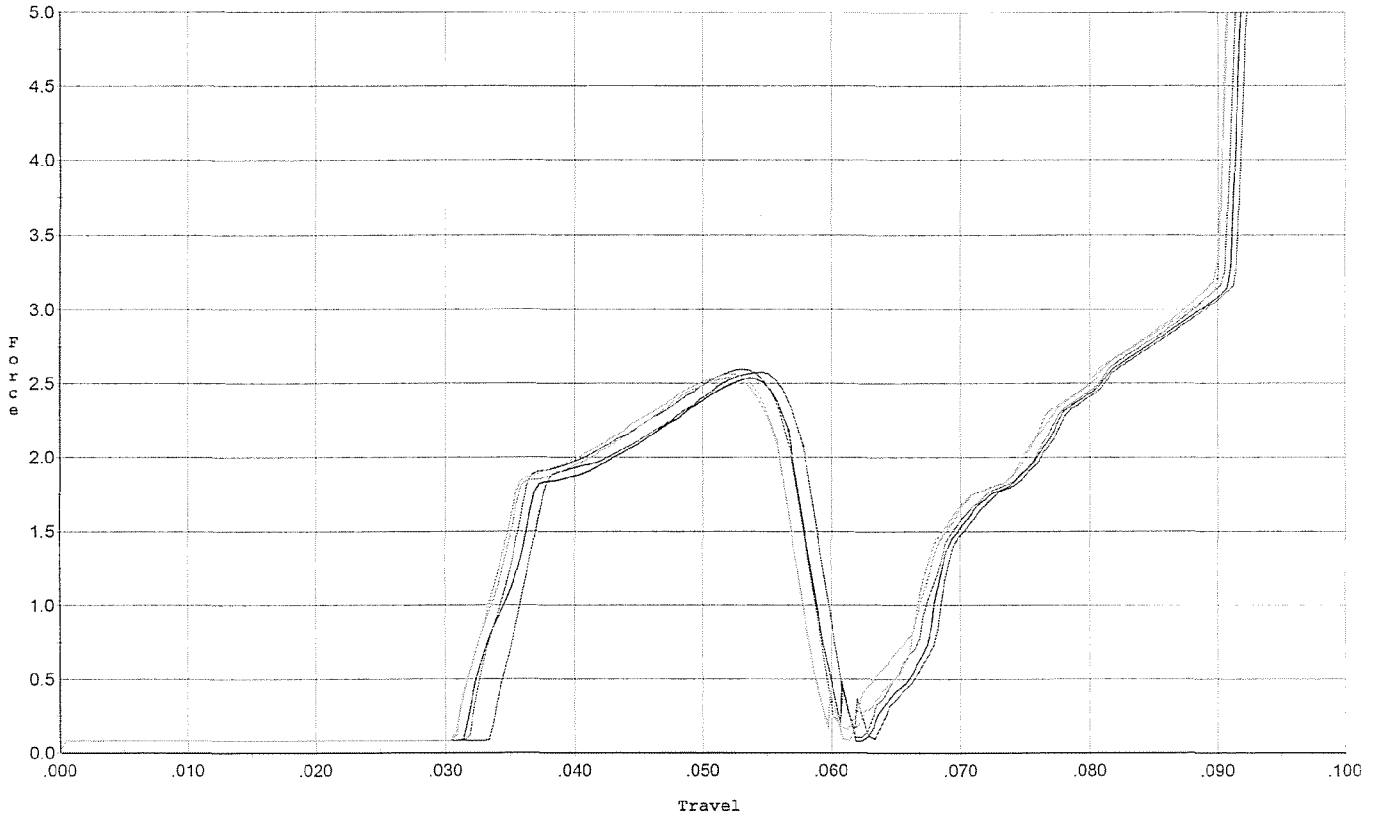


RE00121082

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 1/11/07

Model: M/24
Serial No: Form #F005
Trigger: 2.5 lbs. ini. +/- .50 lbs.



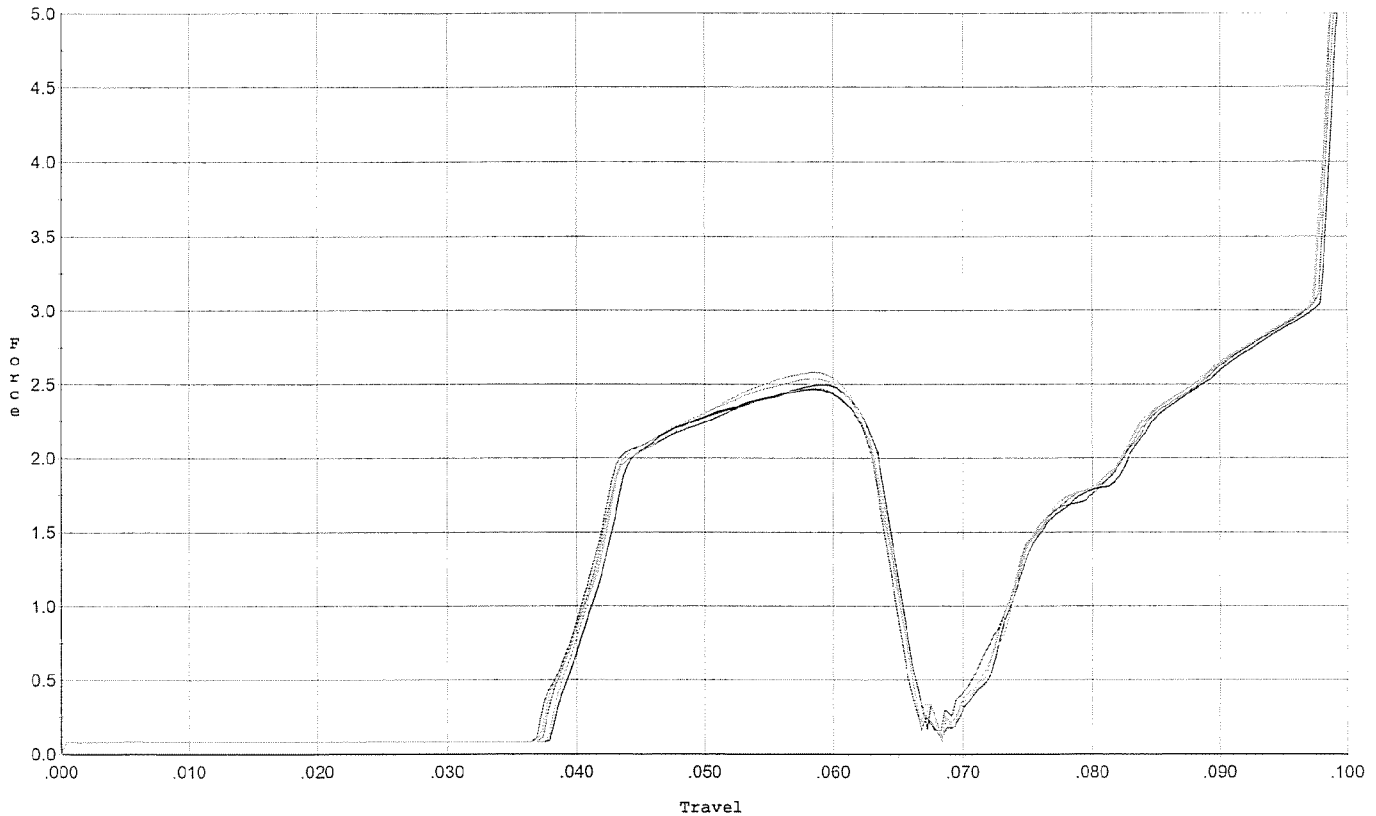
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.576	0.058	0.034	0.038	0.053		Set Trigger
2	2.537	0.057	0.032	0.039	0.052		Set Trigger
3	2.596	0.057	0.032	0.038	0.054		Set Trigger
4	2.561	0.056	0.031	0.039	0.053		Set Trigger
5	2.541	0.056	0.031	0.039	0.052		Set Trigger

AVg 2.56

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putsch 1/11/07

Model: M/24
Serial No: Form #F005
Trigger: 2.5 lbs. after 50 cycles +/- .50 lbs.



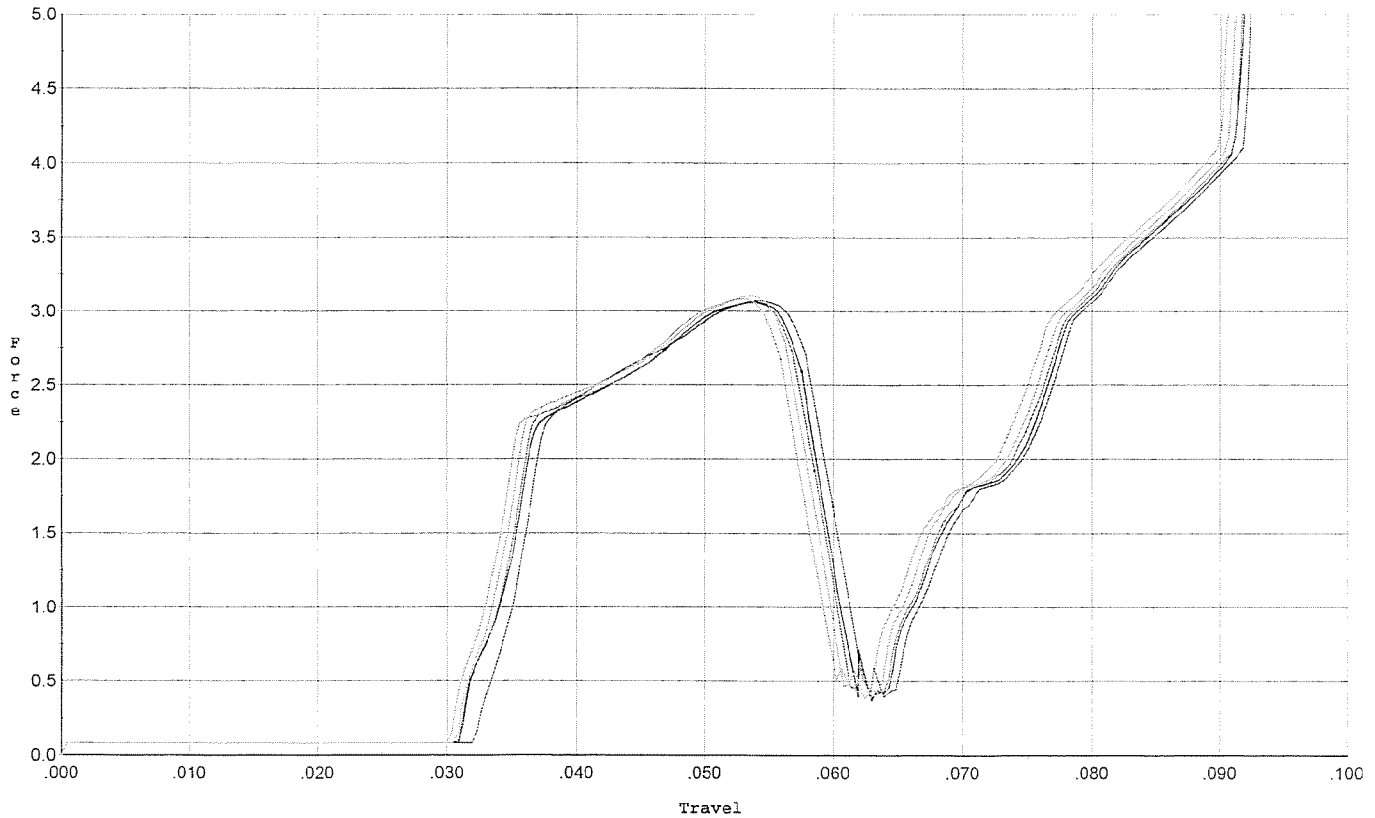
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.464	0.063	0.037	0.041	0.055		Set Trigger
2	2.497	0.063	0.038	0.041	0.055		Set Trigger
3	2.472	0.064	0.038	0.040	0.056		Set Trigger
4	2.538	0.065	0.037	0.041	0.057		Set Trigger
5	2.581	0.064	0.038	0.041	0.057		Set Trigger

Avg 2.51

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 1/11/07

Model: M/24
Serial No: Form #F005
Trigger: 3.0 lbs. ini. +/- .75 lbs.



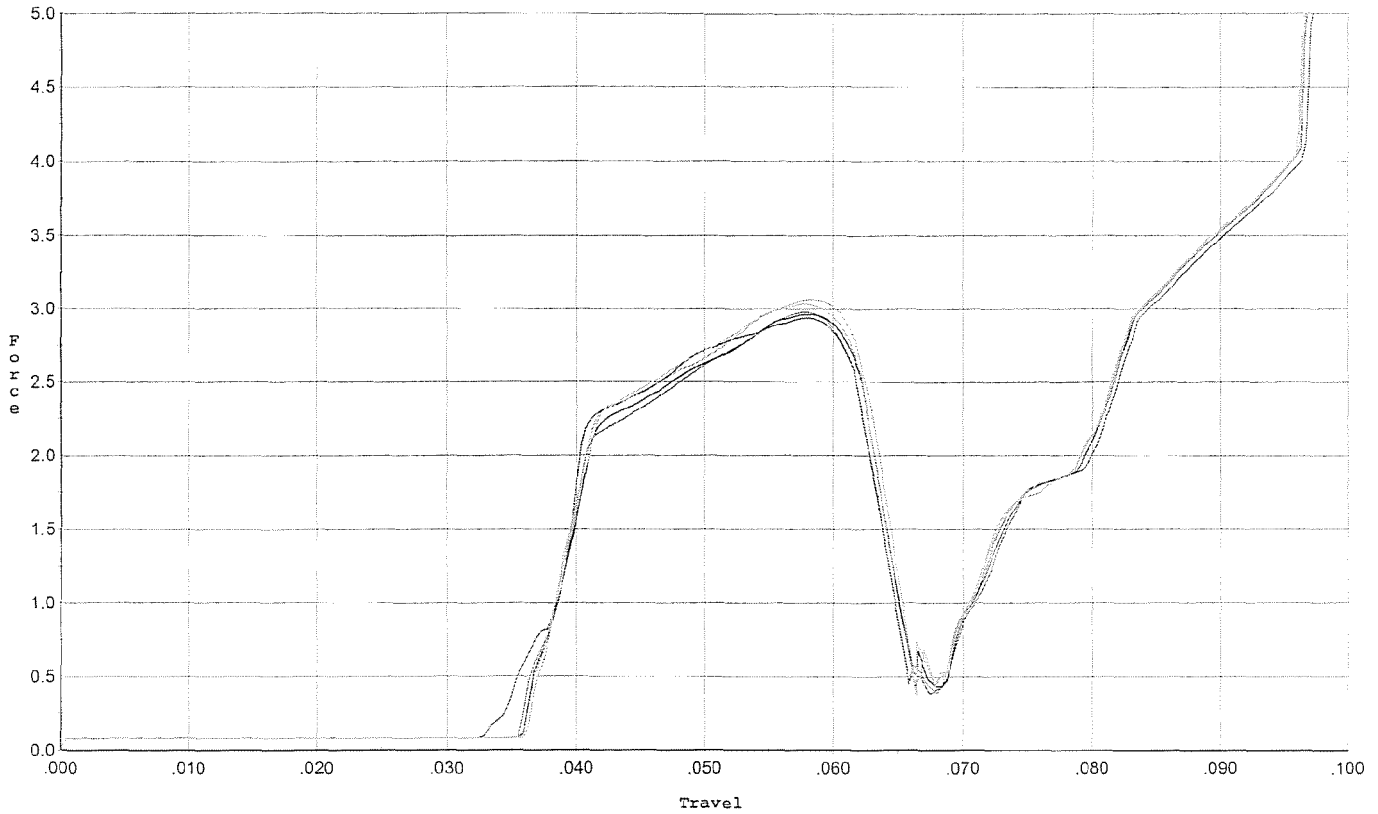
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.072	0.060	0.032	0.037	0.069		Set Trigger
2	3.066	0.058	0.031	0.037	0.066		Set Trigger
3	3.056	0.059	0.031	0.037	0.068		Set Trigger
4	3.104	0.058	0.031	0.036	0.068		Set Trigger
5	3.083	0.056	0.031	0.037	0.065		Set Trigger

Aug 3.07

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 1/11/07

Model: M/24
Serial No: Form #F005
Trigger: 3.0 lbs. after 20 cycles +/- .75 lbs.



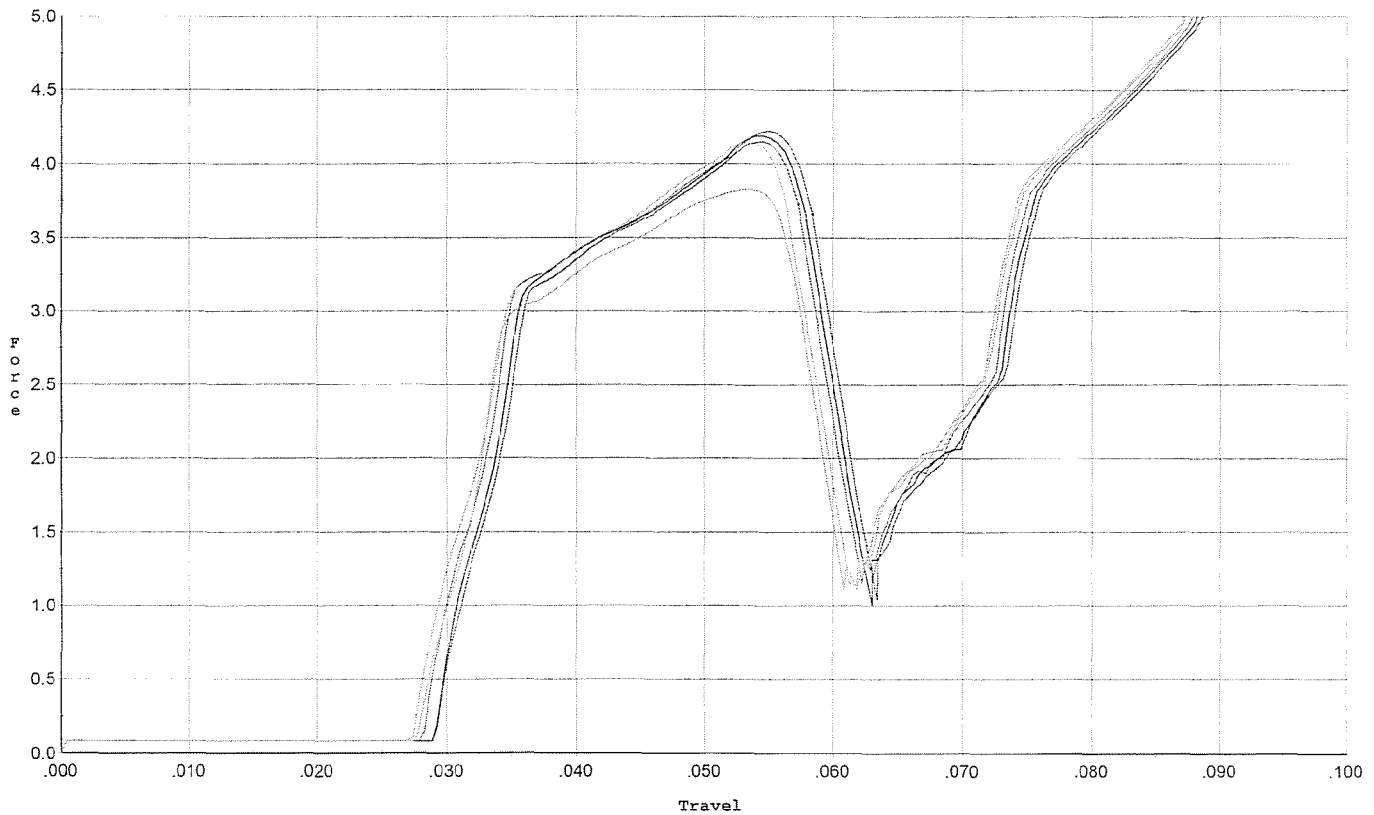
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.938	0.064	0.033	0.039	0.069		Set Trigger
2	2.959	0.062	0.036	0.039	0.066		Set Trigger
3	2.974	0.063	0.036	0.039	0.066		Set Trigger
4	3.035	0.062	0.036	0.039	0.067		Set Trigger
5	3.061	0.063	0.036	0.038	0.069		Set Trigger

Aug 2.99

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 1/11/07

Model: M/24
Serial No: Form #F005
Trigger: 4.0 lbs. ini. +/- 1.0 lbs.



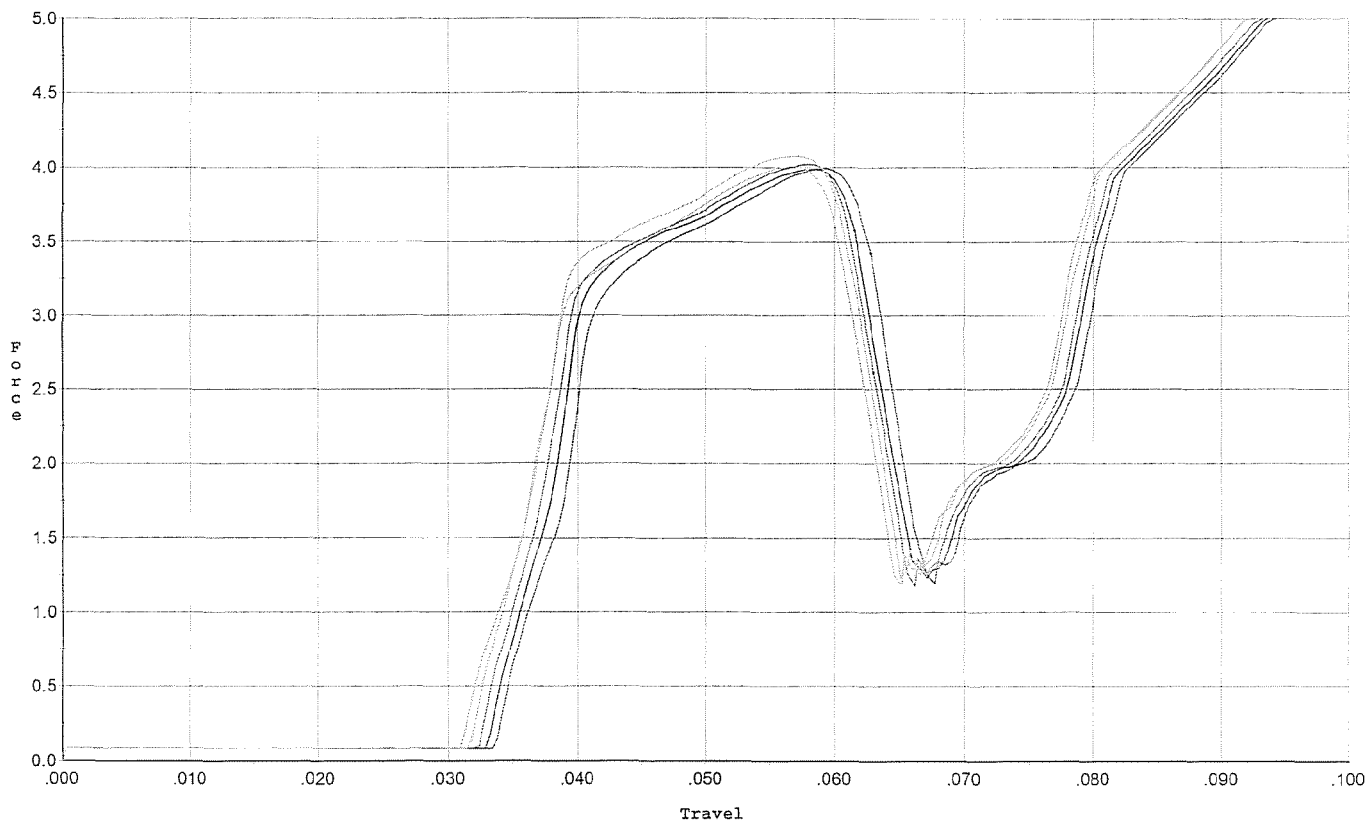
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.223	0.058	0.029	0.032	0.098		Set Trigger
2	4.193	0.058	0.029	0.032	0.098		Set Trigger
3	4.149	0.057	0.028	0.032	0.098		Set Trigger
4	4.145	0.058	0.028	0.032	0.099		Set Trigger
5	3.828	0.057	0.028	0.032	0.092		Set Trigger

Aug 4.10

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 1/11/07

Model: M/24
Serial No: Form #F005
Trigger: 4.0 lbs. after 20 cycles +/- 1.0 lbs.



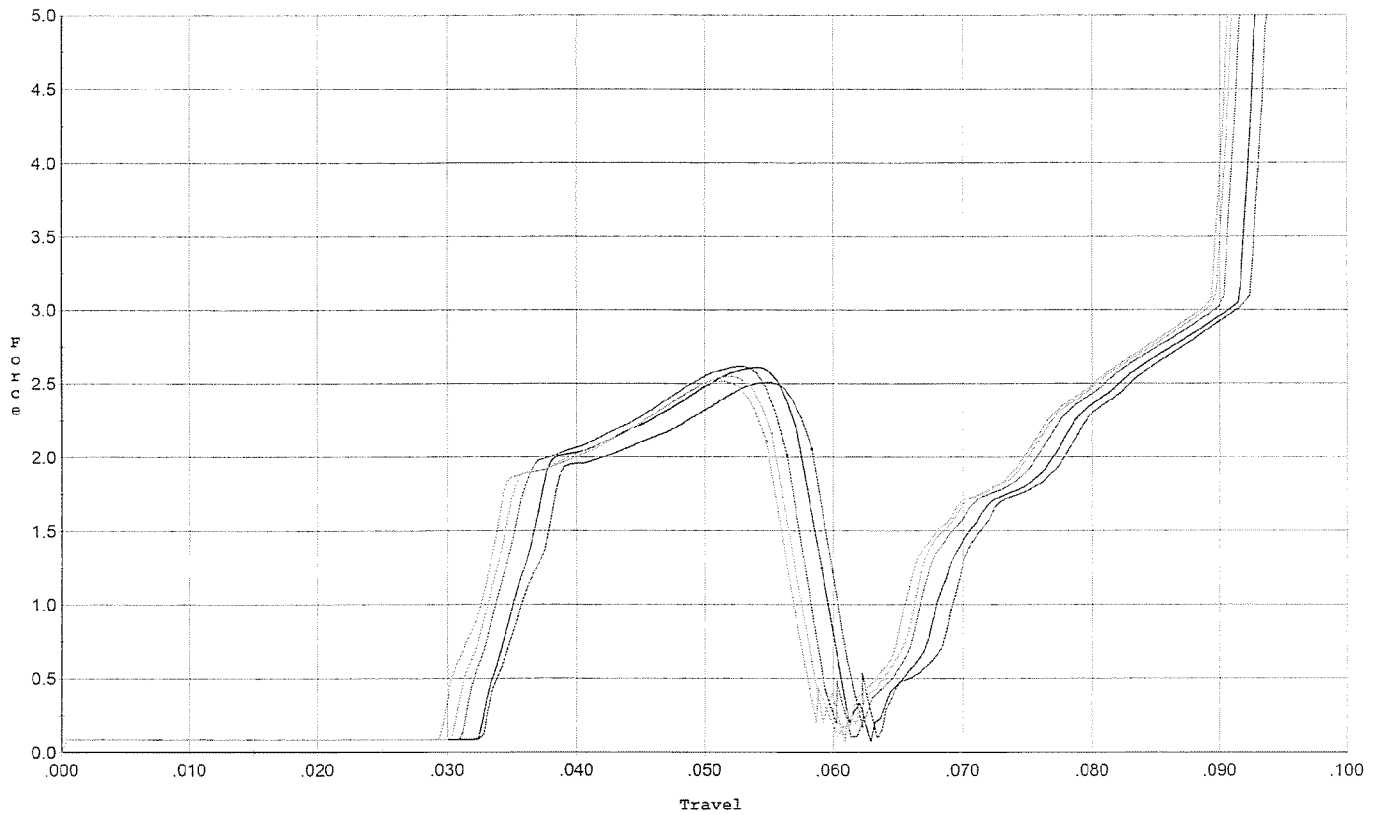
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.992	0.063	0.034	0.035	0.094		Set Trigger
2	3.991	0.062	0.033	0.035	0.094		Set Trigger
3	4.020	0.063	0.033	0.035	0.098		Set Trigger
4	4.080	0.062	0.032	0.035	0.100		Set Trigger
5	4.007	0.062	0.031	0.035	0.097		Set Trigger

Avg 4.01

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putsch 1/11/07

Model: M/24
Serial No: Form #F005
Trigger: reset to 2.5 lbs. +/- .50 lbs. for final test



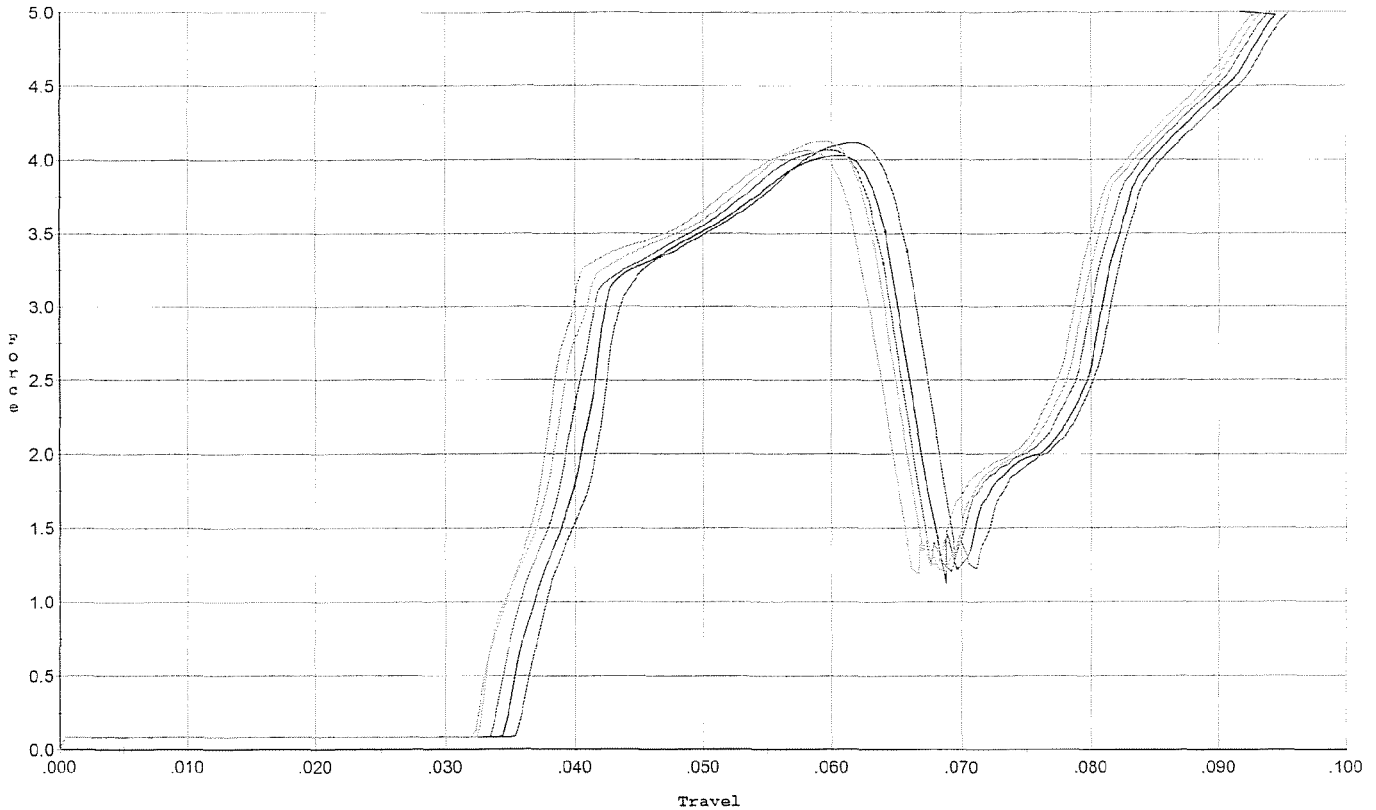
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.507	0.058	0.033	0.039	0.053		Set Trigger
2	2.608	0.059	0.033	0.038	0.056		Set Trigger
3	2.616	0.056	0.031	0.039	0.055		Set Trigger
4	2.549	0.055	0.031	0.039	0.053		Set Trigger
5	2.516	0.055	0.030	0.039	0.053		Set Trigger

Aug 2.55

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 1/11/07

Model: M/24
Serial No: Form #F005
Trigger: set to 4.0 lbs. +/- 1.0 lbs. for target & accuracy



#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.114	0.066	0.036	0.035	0.099		Set Trigger
2	4.029	0.064	0.035	0.036	0.096		Set Trigger
3	4.067	0.064	0.034	0.035	0.098		Set Trigger
4	4.126	0.063	0.033	0.034	0.100		Set Trigger
5	4.061	0.063	0.033	0.035	0.099		Set Trigger

AVG 4.07

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6535209.___0
FILE DATE AND TIME: 01/15/2007 05:34

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.068
The Average Y Centroid of the Five Target Set:	-0.043
The Average Point of Impact of the Five Target Set:	0.081
The Average Mean Radius of the Five Target Set:	0.658
The Distance from POA to Centroid Target #1:	0.131
The Distance from Centroid Target #2 to Centroid Target #1:	0.406
The Distance from Centroid Target #3 to Centroid Target #1:	0.126
The Distance from Centroid Target #4 to Centroid Target #1:	0.211
The Distance from Centroid Target #5 to Centroid Target #1:	0.141

SERIAL NUMBER: G6535209. __0

TARGET NUMBER: 1

FILE DATE: 01/15/2007

FILE TIME: 05:34

POINT#	X	Y
--------	---	---

1:	0.407	1.086
----	-------	-------

2:	0.087	0.699
----	-------	-------

3:	0.417	0.305
----	-------	-------

4:	0.556	0.195
----	-------	-------

5:	0.251	-0.133
----	-------	--------

6:	0.109	-0.507
----	-------	--------

7:	-0.310	0.130
----	--------	-------

8:	-0.336	-0.214
----	--------	--------

9:	-0.270	-0.428
----	--------	--------

10:	-0.012	-0.184
-----	--------	--------

X CENTROID: 0.090

Y CENTROID: 0.095

POA TO CENTROID: 0.131

HORZ SPREAD: 0.892

VERT SPREAD: 1.593

GROUP SPREAD: 1.658

MIN RADIUS: 0.279

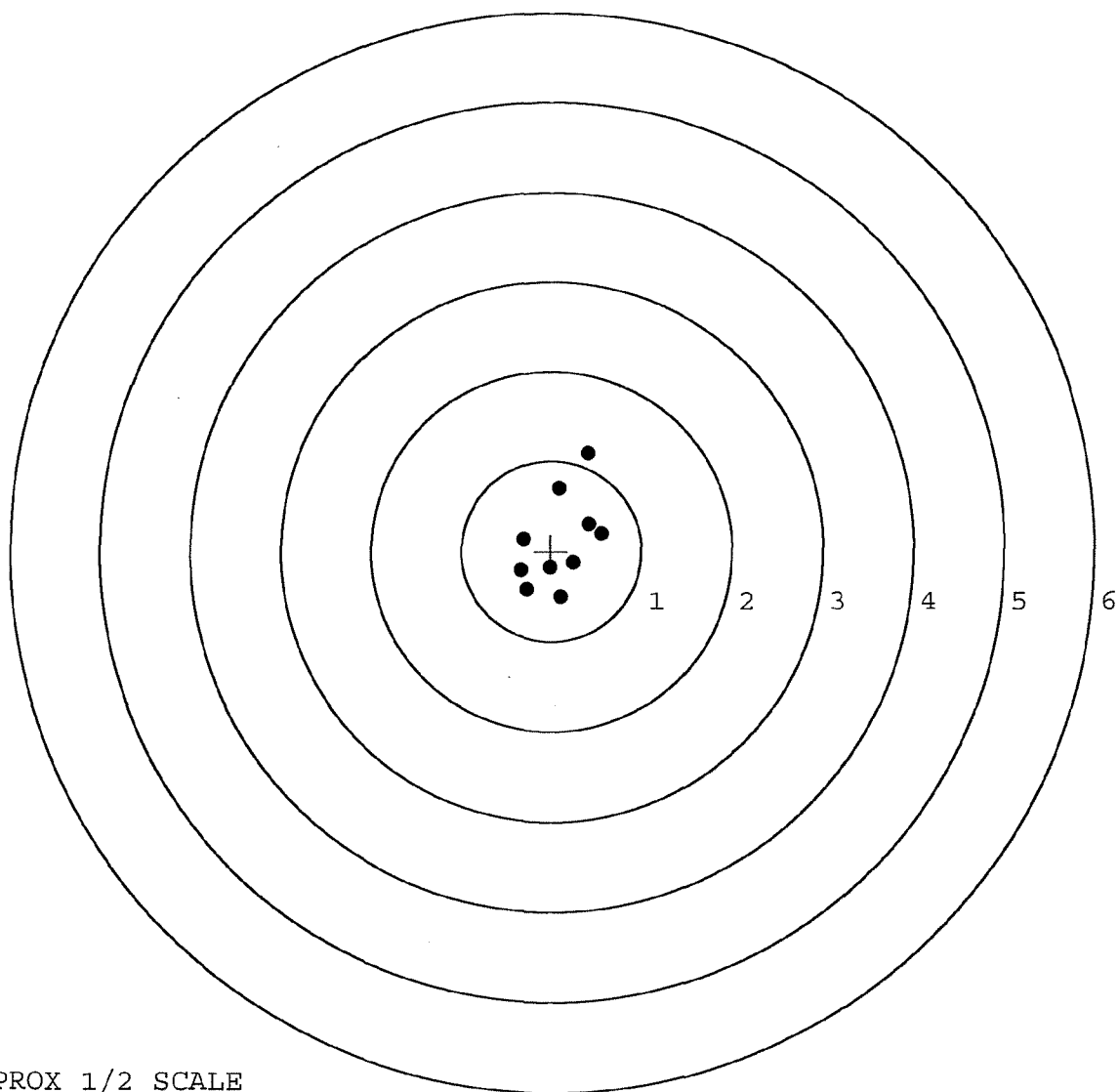
MAX RADIUS: 1.041

MEAN RADIUS: 0.525

IN 1 IN DIAMETER: 5

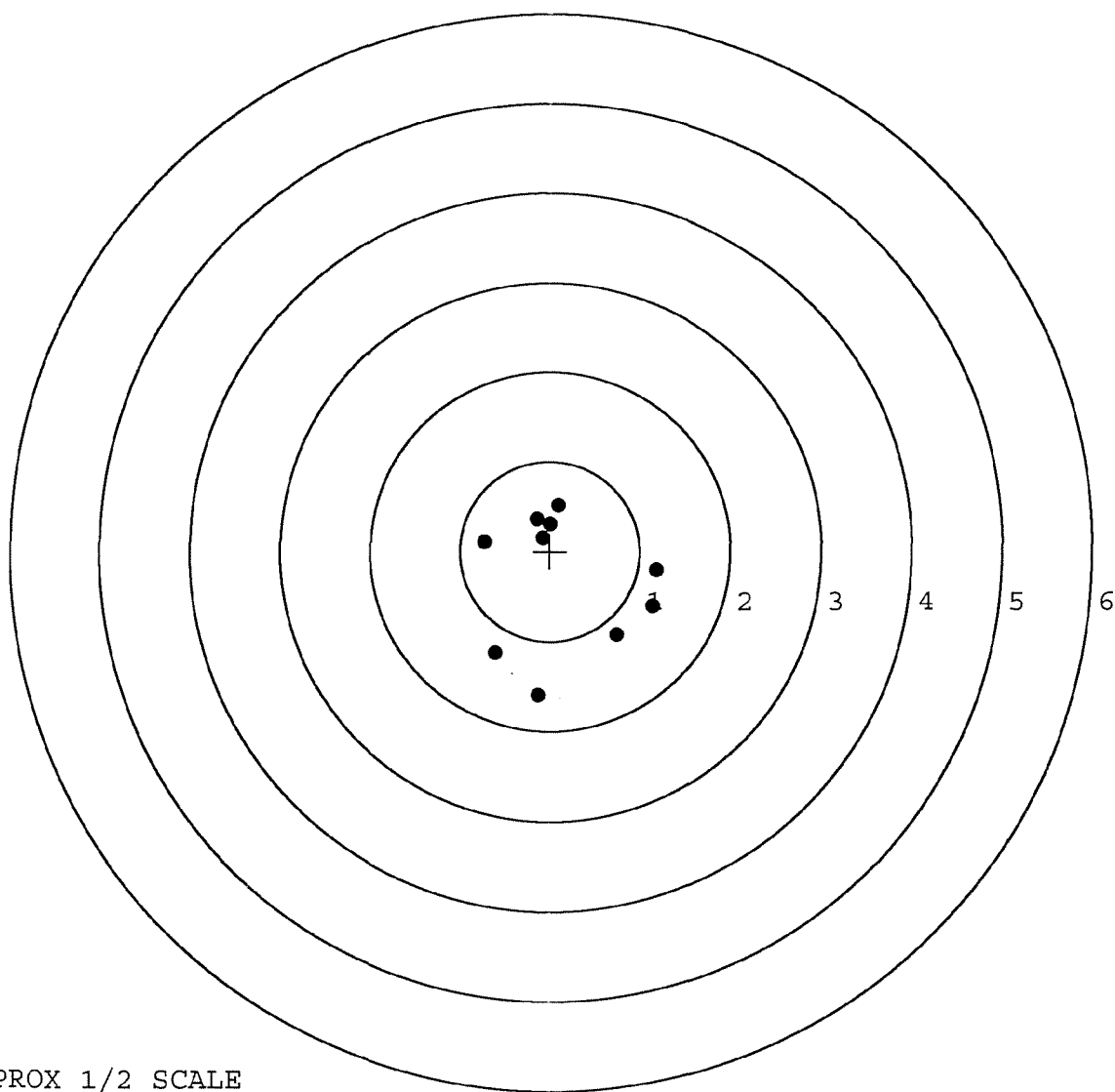
IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6535209.____0	POINT#	X	Y
TARGET NUMBER: 2	1:	-0.612	-1.134
FILE DATE: 01/15/2007	2:	-0.129	-1.608
FILE TIME: 05:34	3:	0.753	-0.932
	4:	1.141	-0.609
	5:	1.183	-0.210
X CENTROID: 0.146	6:	-0.739	0.101
Y CENTROID: -0.307	7:	0.095	0.508
POA TO CENTROID: 0.340	8:	-0.152	0.355
HORZ SPREAD: 1.922	9:	0.001	0.302
VERT SPREAD: 2.116	10:	-0.085	0.153
GROUP SPREAD: 2.128			
MIN RADIUS: 0.515			
MAX RADIUS: 1.329			
MEAN RADIUS: 0.906			
# IN 1 IN DIAMETER: 0			
# IN 2 IN DIAMETER: 6			
# in 3 IN DIAMETER: 10			



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6535209. __ 0

TARGET NUMBER: 3

FILE DATE: 01/15/2007

FILE TIME: 05:34

POINT#	X	Y
--------	---	---

1:	-0.282	-1.062
----	--------	--------

2:	-0.541	-0.308
----	--------	--------

3:	-0.828	0.175
----	--------	-------

4:	-0.357	0.668
----	--------	-------

5:	0.294	0.656
----	-------	-------

6:	0.330	0.355
----	-------	-------

7:	0.130	0.188
----	-------	-------

8:	0.292	-0.125
----	-------	--------

9:	0.400	-0.414
----	-------	--------

10:	0.676	-0.172
-----	-------	--------

X CENTROID: 0.011

Y CENTROID: -0.004

POA TO CENTROID: 0.012

HORZ SPREAD: 1.504

VERT SPREAD: 1.730

GROUP SPREAD: 1.812

MIN RADIUS: 0.226

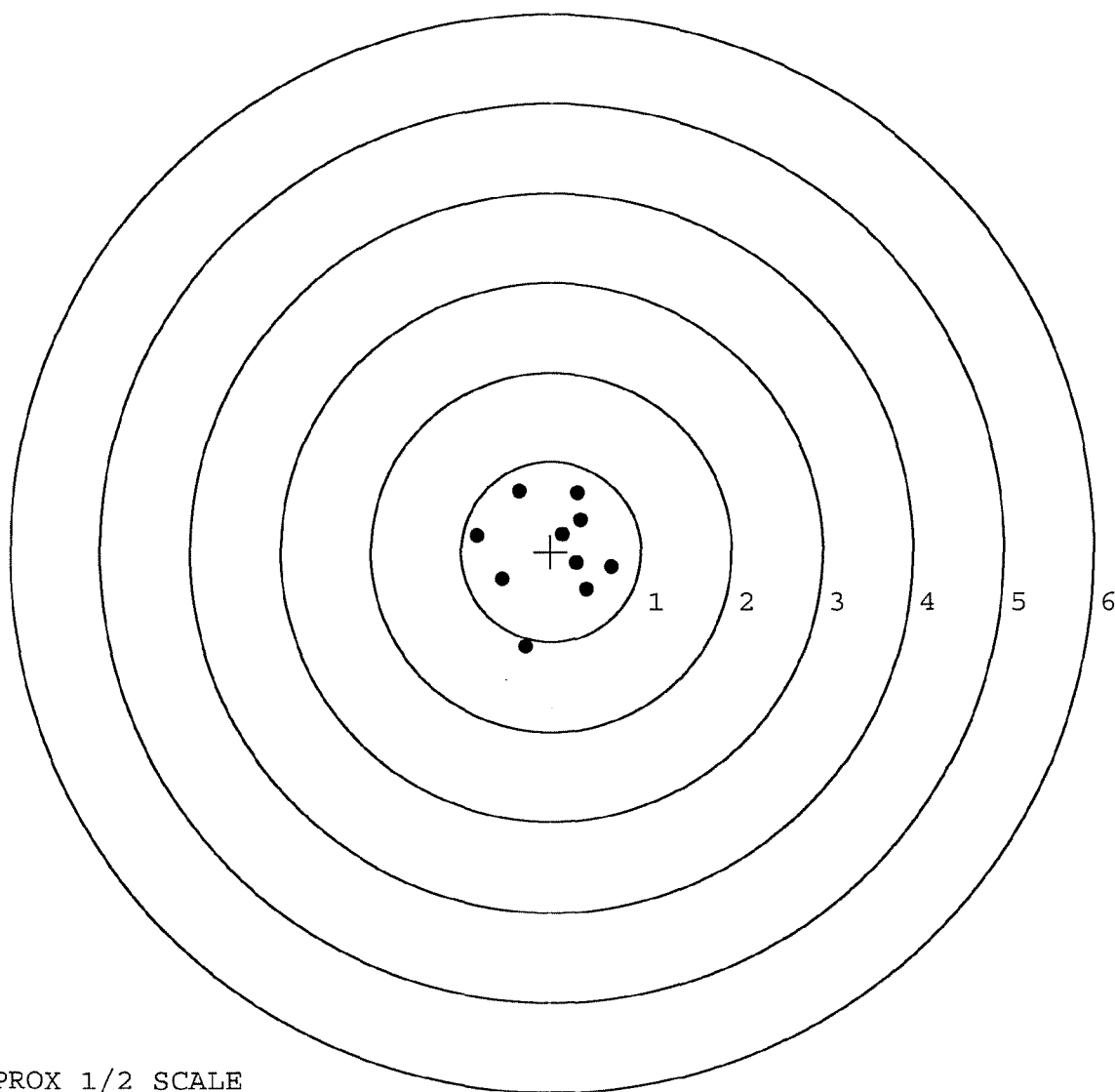
MAX RADIUS: 1.098

MEAN RADIUS: 0.633

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6535209. 0

TARGET NUMBER: 4

FILE DATE: 01/15/2007

FILE TIME: 05:34

POINT#	X	Y
1:	0.771	-0.982
2:	0.055	-0.563
3:	0.289	-0.481
4:	0.445	-0.017
5:	0.283	0.147
6:	-0.059	0.200
7:	-0.369	0.067
8:	-0.652	0.094
9:	-0.953	0.191
10:	1.644	0.262

X CENTROID: 0.145

Y CENTROID: -0.108

POA TO CENTROID: 0.181

HORZ SPREAD: 2.597

VERT SPREAD: 1.244

GROUP SPREAD: 2.598

MIN RADIUS: 0.290

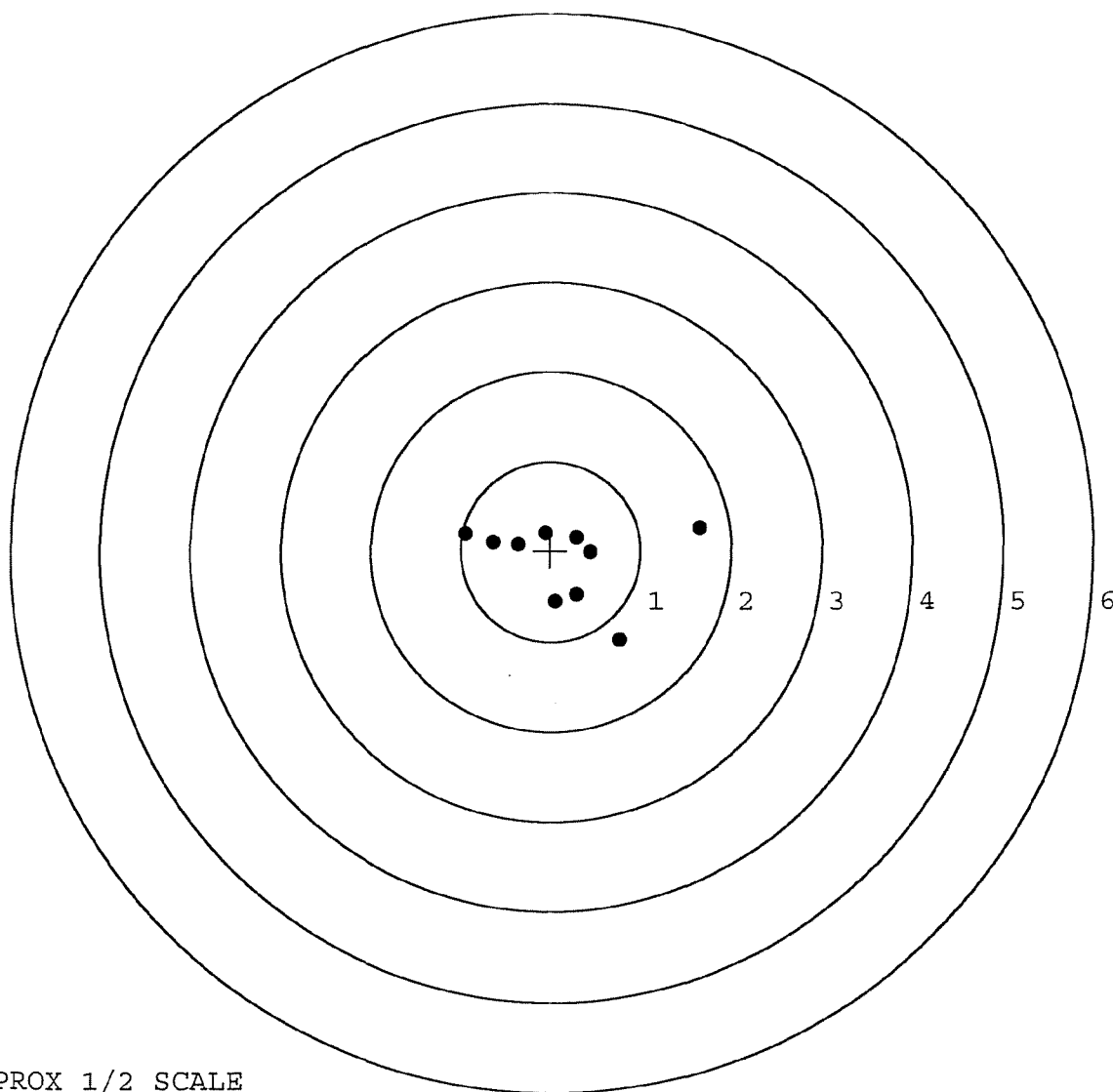
MAX RADIUS: 1.544

MEAN RADIUS: 0.696

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 9

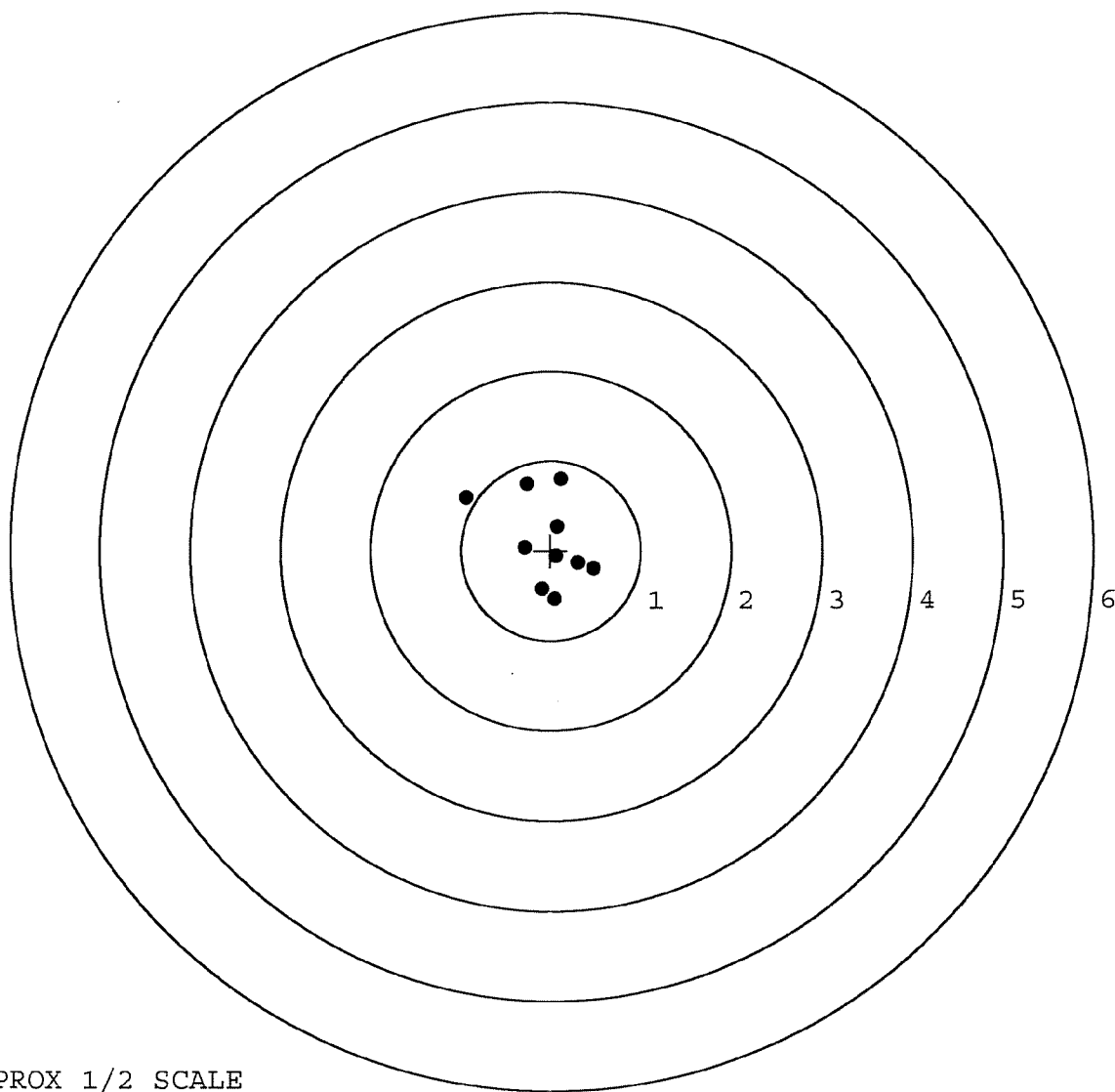


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6535209. __0
TARGET NUMBER: 5
FILE DATE: 01/15/2007
FILE TIME: 05:34

POINT#	X	Y
1:	0.051	-0.545
2:	-0.097	-0.428
3:	0.480	-0.196
4:	0.303	-0.135
5:	0.076	0.272
6:	-0.291	0.039
7:	0.061	-0.063
8:	0.114	0.799
9:	-0.263	0.741
10:	-0.944	0.593

X CENTROID: -0.051
Y CENTROID: 0.108
POA TO CENTROID: 0.119
HORZ SPREAD: 1.424
VERT SPREAD: 1.344
GROUP SPREAD: 1.628
MIN RADIUS: 0.204
MAX RADIUS: 1.016
MEAN RADIUS: 0.530
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

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

5047

R & E NUMBER	121082		
SERIAL NUMBER	G6535209		
LOG-IN DATE	12-1-06		
OPERATION #	OPERATION NAME	DATE	INITIAL
500	DIS-ASSEMBLE GUN	1-8-07	RTZ
505	RE-BARREL	1-9-07	RTZ
420	ASSEMBLE	1-9-07	RTZ
440	PROOF	1-9-07	TRW
460	CHECK HEADSPACE	1-9-07	TRW
470	DIS-ASSEMBLE GUN	1-9-07	RTZ
480	MAGNAFLUX	1/10/07	WMB
510	DRILL AND TAP		
500	ROLLMARK CALIBER	1-10-07	CW
520	GOFF BLAST BBL / REC	1-10-07	DS
530 & 540	APPLY COATINGS	1/12/07	BB
560	FINAL ASSEMBLY	1-12-07	RTZ
640	FUNCTION TEST AND	PASS FAIL	1-12-07 TRW
650	TARGET	PASS FAIL	1-12-07 TRW
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	1-12-07 Fm
670	FINAL INSPECTION	1-16-07	RTZ
	A) HEADSPACE	PASS FAIL	1-16-07 RTZ
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS 285 288 284 278 282 1-16-07 DA	
680	F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX 50 50 45 1-16-07 DA	
	G) SAFETY OFF FORCE	2 LBS MIN 2.5 2.5 2.5 1-16-07 DA	
	I) FIRING PIN INDENT	.020 .025 .024 .025 1-16-07 DA	
690	PACK	1-16-07 DA	

F006 REV 5/2006

FINAL INSPECTION CHECKLIST

BARREL ASSEMBLY

BARREL

RECEIVER

FRONT SIGHT BASE

REAR SIGHT BASE

SCREWS

FINISH

SCOPE ASSEMBLY

SCOPE

SCOPE RINGS

MOUNTING SCREWS

MOUNTING BASE

SCREWS

FINISH

CLARITY

STOCK ASSEMBLY

STOCK

SLING SWIVEL STUDS

BUTT PATE

LOCK NUTS

BARREL CLEARANCE

COLOR / FINISH

SYSTEM CASE

SCOPE CASE

IRON SIGHTS

DEPLOYMENT KIT

TRIGGER ASSEMBLY

SAFETY OPERATION

RE-SET TO FACTORY
SPECS

COMMENTS: _____

F006 REV 5/2006

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: **RE00113116** Serial: C6649175 Model M24 SWS Center Fire Repairman: _____
 Verify Repair _____ Caliber: 7.62 NATO Status: New 6/1/2006 11:14:35 AM

Address Information

Customer: _____ Received From: _____ Return To: _____ Received From: _____
 Name: **TRANSPORTATION OFFICER** **TRANSPORTATION OFFICER**
 Address 1: **USPFO FOR ARKANSAS BLDG 318** **USPFO FOR ARKANSAS BLDG 318**
 Address 2: **CAMP JOSEPH T ROBINSON** PO Box: _____ **CAMP JOSEPH T ROBINSON** PO Box: _____
 City: **NORTH LITTLE ROCK** **NORTH LITTLE ROCK**
 State: **AR** Zip Code: **72199** Country: **US** State: **AR** Zip Code: **72199** Country: **US**

FFL: _____

Contact / Condition	Problems	Estimate	History / Status	Shipping / Billing												
Contact Information Phone: NA Fax: _____ Email: _____ Comments: _____	Received Condition Fair Condition Notes: _____ CSR Notes: _____	Accessories Received <table border="1"> <thead> <tr> <th>Code</th> <th>Desc</th> <th>Qty</th> </tr> </thead> <tbody> <tr> <td>A007</td> <td>With Stud</td> <td>3</td> </tr> <tr> <td>A017</td> <td>Scope Base</td> <td>1</td> </tr> <tr> <td>A057</td> <td>Frt and Rear Sgt Base</td> <td>1</td> </tr> </tbody> </table>	Code	Desc	Qty	A007	With Stud	3	A017	Scope Base	1	A057	Frt and Rear Sgt Base	1		
Code	Desc	Qty														
A007	With Stud	3														
A017	Scope Base	1														
A057	Frt and Rear Sgt Base	1														

Repair Search | **nagletj** | **6/1/2006** | **3:17 PM** | **CAPS** | **NUM** | **INS** | **SCRL** | **Refresh** | **Close**

start | 3 Mi... | 3 Mi... | 3 Int... | Arms... | Part S... | NEW... | 3:17 PM

G-6535209

Serial Number: **C6649175**
 Model: **M24 SWS**

RE00113116

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50 LBS (plus or minus 0.50 LBS)

3.00 LBS (plus or minus 0.75 LBS)

4.00 LBS (plus or minus 1.00 LBS)

DATE 6-1-06

TESTER R.P.

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.48	2.45		2.54	
PULL #2	2.44	2.30		2.57	
PULL #3	2.46	2.45		2.35	
PULL #4	2.45	2.50		2.53	
PULL #5	2.44	2.60		2.50	
TOTAL	12.27	12.30		12.49	
AVERAGE	2.45	2.46		2.49	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.03	3.22		
PULL #2	3.06	3.26		
PULL #3	2.98	3.28		
PULL #4	3.01	3.29		
PULL #5	3.09	3.20		
TOTAL	15.17	16.25		
AVERAGE	3.03	3.25		

	4.00 LBS INITIAL	4.00 LBS AFTER 20 CYCLES	MAX SETTING GREATER THAN 4 LBS	RESET TO 4 LBS FOR TARGET & ACCURACY
PULL #1	4.09	4.14		4.13
PULL #2	4.26	3.89		4.24
PULL #3	4.22	4.02		4.18
PULL #4	4.18	4.16		4.23
PULL #5	4.26	4.19		4.16
TOTAL	21.01	20.40		20.94
AVERAGE	4.20	4.08		4.18

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6535209.__0

FILE DATE AND TIME: 06/15/2006 08:08

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.029
The Average Y Centroid of the Five Target Set:	-0.057
The Average Point of Impact of the Five Target Set:	0.064
The Average Mean Radius of the Five Target Set:	0.716
The Distance from POA to Centroid Target #1:	0.247
The Distance from Centroid Target #2 to Centroid Target #1:	0.290
The Distance from Centroid Target #3 to Centroid Target #1:	0.289
The Distance from Centroid Target #4 to Centroid Target #1:	0.321
The Distance from Centroid Target #5 to Centroid Target #1:	0.405

SERIAL NUMBER: G6535209. __0

TARGET NUMBER: 1

FILE DATE: 06/15/2006

FILE TIME: 08:08

POINT#	X	Y
1:	-0.622	-0.977
2:	-0.448	-0.870
3:	-0.438	-0.562
4:	-0.114	-0.437
5:	0.287	-0.053
6:	-0.316	1.353
7:	-0.515	1.137
8:	-0.233	0.486
9:	-0.020	0.474
10:	0.067	0.191

X CENTROID: -0.235

Y CENTROID: 0.074

POA TO CENTROID: 0.247

HORZ SPREAD: 0.909

VERT SPREAD: 2.330

GROUP SPREAD: 2.350

MIN RADIUS: 0.324

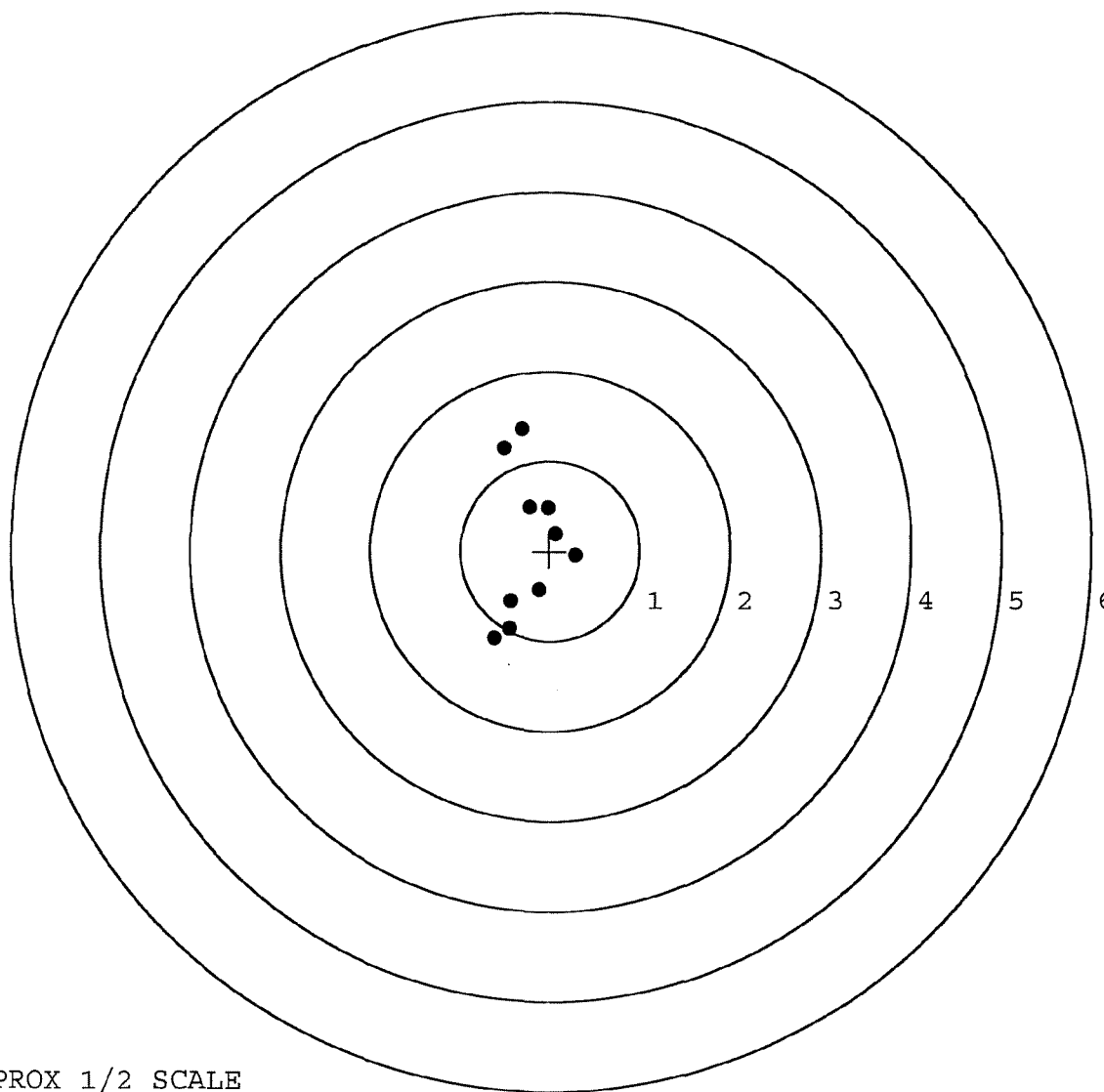
MAX RADIUS: 1.281

MEAN RADIUS: 0.739

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10

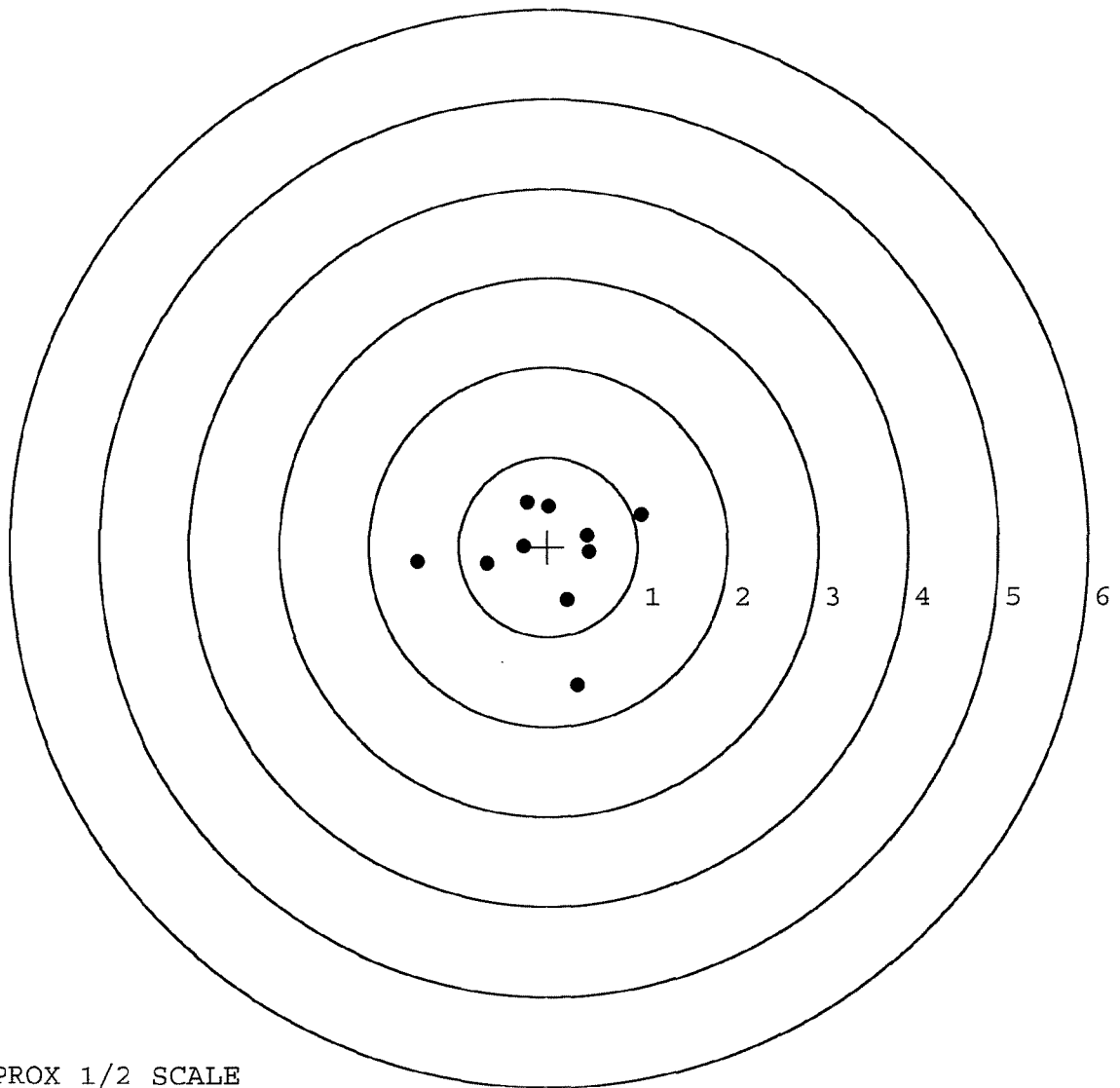


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6535209. __0
TARGET NUMBER: 2
FILE DATE: 06/15/2006
FILE TIME: 08:08

X CENTROID: -0.014
Y CENTROID: -0.113
POA TO CENTROID: 0.114
HORZ SPREAD: 2.493
VERT SPREAD: 2.038
GROUP SPREAD: 2.254
MIN RADIUS: 0.281
MAX RADIUS: 1.473
MEAN RADIUS: 0.777
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.338	-1.543
2:	0.217	-0.598
3:	1.037	0.361
4:	-1.456	-0.178
5:	-0.684	-0.193
6:	-0.234	0.495
7:	0.010	0.453
8:	-0.273	-0.003
9:	0.441	0.132
10:	0.461	-0.056

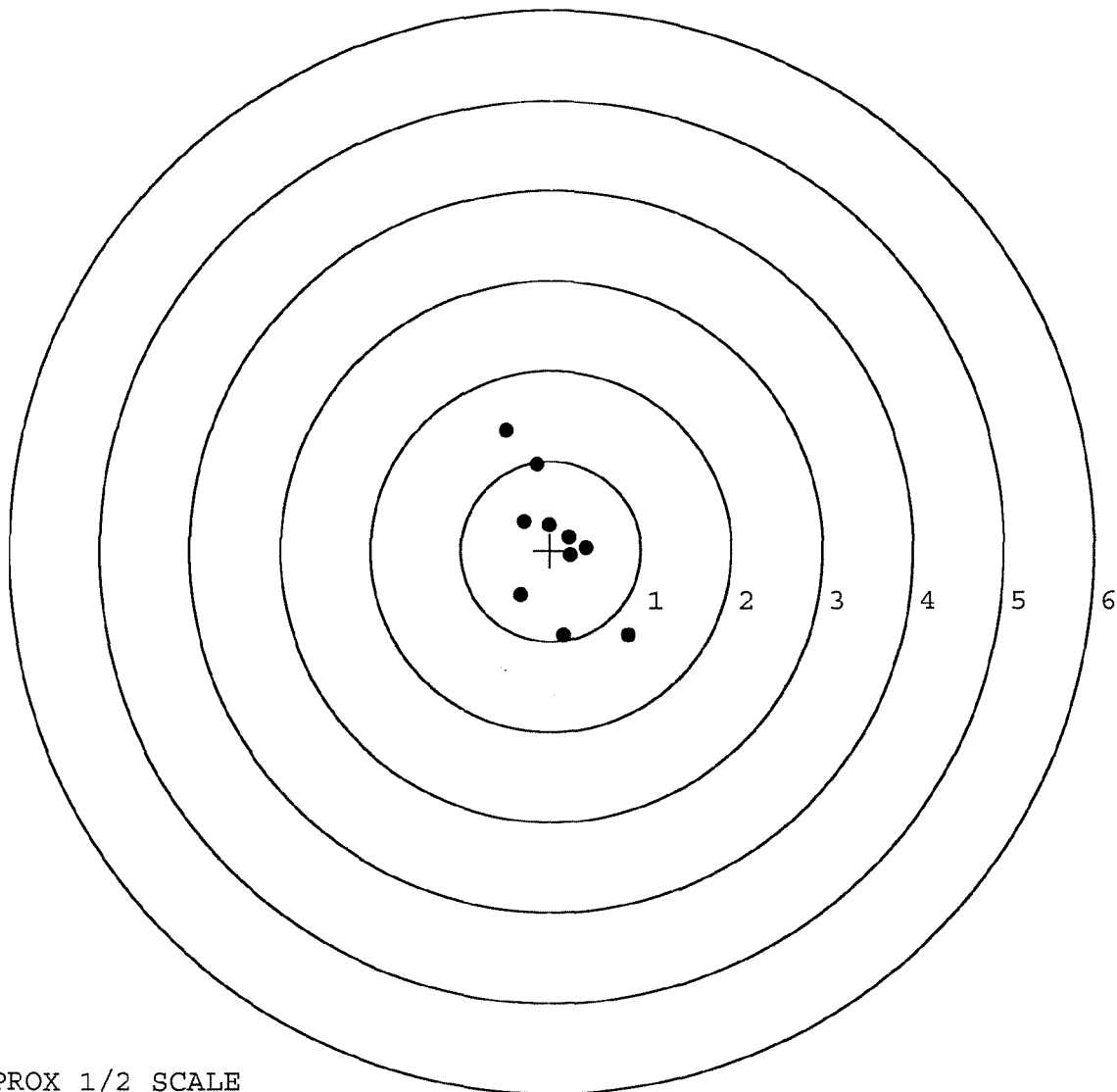


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6535209. __0
TARGET NUMBER: 3
FILE DATE: 06/15/2006
FILE TIME: 08:08

POINT#	X	Y
1:	0.863	-0.937
2:	0.148	-0.944
3:	-0.333	-0.499
4:	-0.503	1.338
5:	-0.150	0.961
6:	-0.295	0.321
7:	-0.016	0.282
8:	0.203	0.150
9:	0.225	-0.059
10:	0.399	0.036

X CENTROID: 0.054
Y CENTROID: 0.065
POA TO CENTROID: 0.084
HORZ SPREAD: 1.366
VERT SPREAD: 2.282
GROUP SPREAD: 2.654
MIN RADIUS: 0.172
MAX RADIUS: 1.390
MEAN RADIUS: 0.668
IN 1 IN DIAMETER: 5
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 10

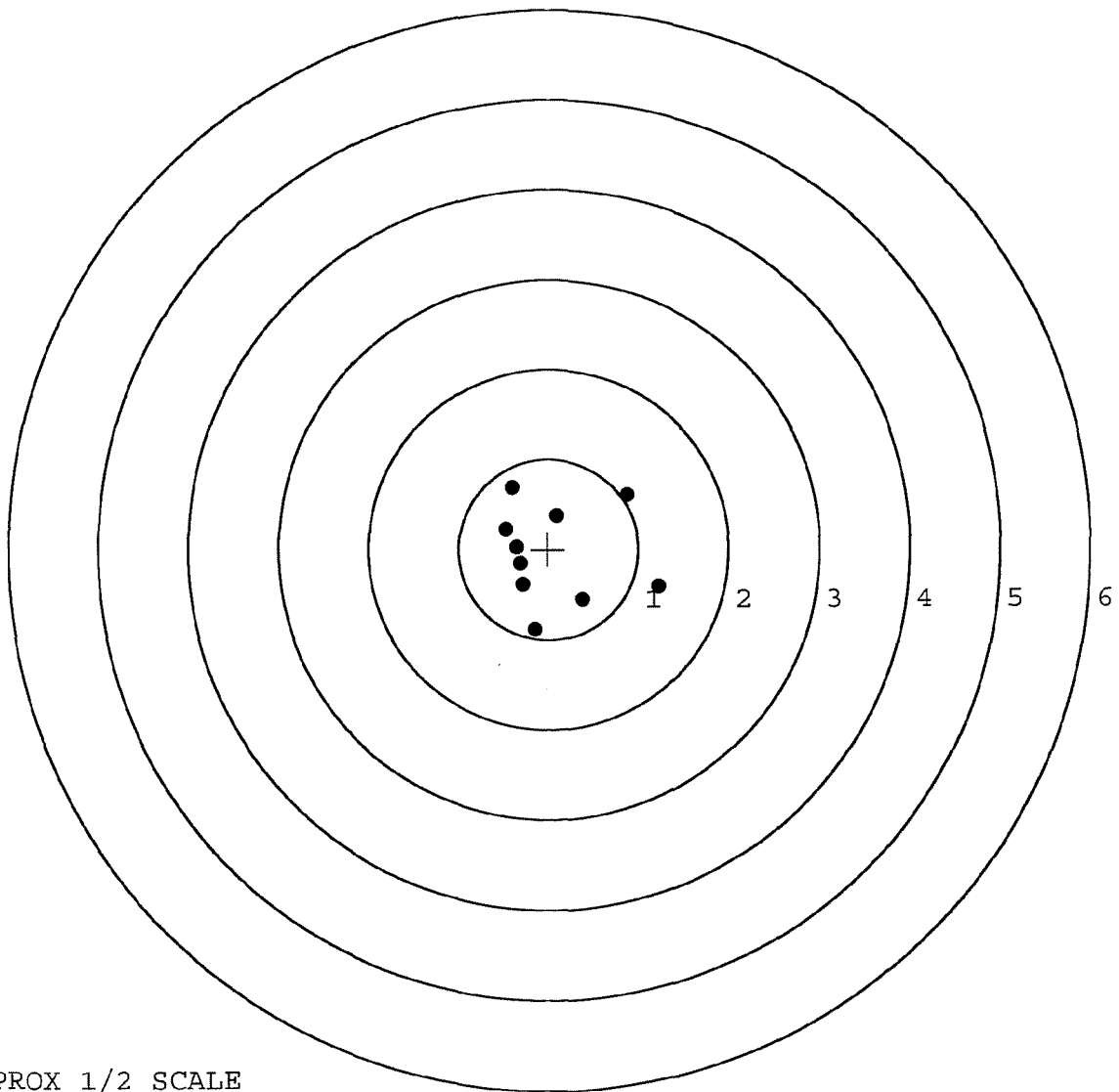


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6535209. __0
TARGET NUMBER: 4
FILE DATE: 06/15/2006
FILE TIME: 08:08

X CENTROID: 0.060
Y CENTROID: -0.052
POA TO CENTROID: 0.080
HORZ SPREAD: 1.696
VERT SPREAD: 1.582
GROUP SPREAD: 1.963
MIN RADIUS: 0.388
MAX RADIUS: 1.217
MEAN RADIUS: 0.692
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	1.222	-0.414
2:	0.384	-0.557
3:	0.874	0.600
4:	-0.152	-0.897
5:	0.098	0.373
6:	-0.286	-0.396
7:	-0.349	0.025
8:	-0.474	0.226
9:	-0.404	0.685
10:	-0.311	-0.165



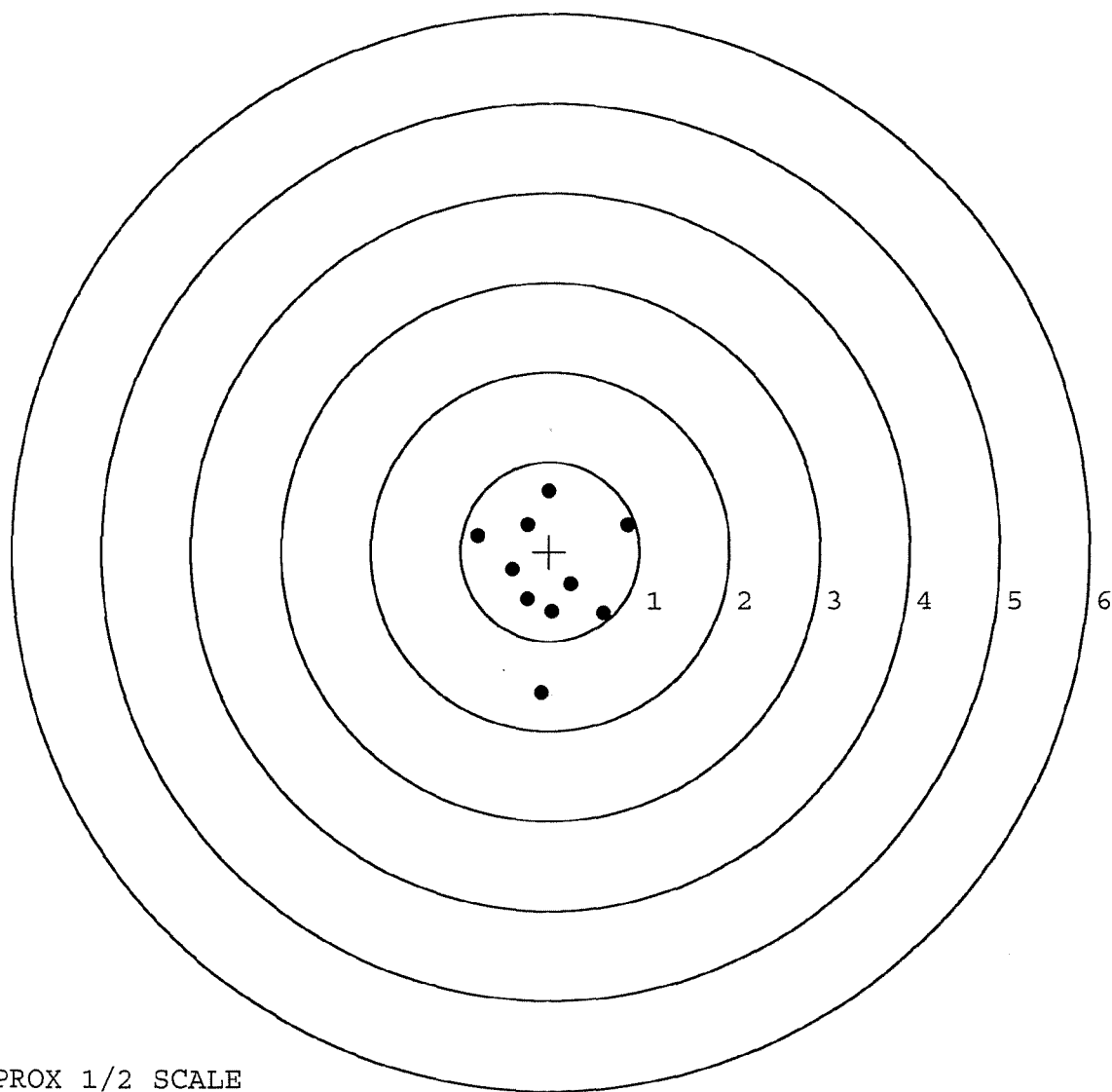
TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6535209. __0
TARGET NUMBER: 5
FILE DATE: 06/15/2006
FILE TIME: 08:08

X CENTROID: -0.008
Y CENTROID: -0.262
POA TO CENTROID: 0.262
HORZ SPREAD: 1.677
VERT SPREAD: 2.260
GROUP SPREAD: 2.261
MIN RADIUS: 0.270
MAX RADIUS: 1.327
MEAN RADIUS: 0.705

POINT#	X	Y
1:	-0.090	-1.586
2:	0.606	-0.688
3:	0.238	-0.373
4:	0.029	-0.679
5:	-0.253	-0.538
6:	0.870	0.303
7:	-0.415	-0.211
8:	-0.248	0.304
9:	-0.807	0.178
10:	-0.012	0.674

IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

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

7 of 10

R & E NUMBER	00113116		Markham Ship Training Center	
SERIAL NUMBER	66649175		B 6535209	
LOG-IN DATE	6-1-06			
OPERATION #	OPERATION NAME		DATE	INITIAL
500	DIS-ASSEMBLE GUN		6-5-06	AC
505	RE-BARREL		6-6-06	AC
560	ASSEMBLE		6-6-06	AC
600	PROOF	MAGNA-FLUX INSPECTED	6-7-06	RP
605	CHECK HEADSPACE		6-7-06	RP
610	DIS-ASSEMBLE GUN	JUN 09 2006	6-7-06	AC
612	MAGNAFLUX	OPERATOR APD	6-9-06	APD
510	DRILL AND TAP		6-8-06	TRW
615	ROLLMARK CALIBER		6-9-06	CW
618	ROTO-BLAST		6-9-06	LB
620	APPLY COATINGS		6/13/06	RS
625	FINAL ASSEMBLY		6-14-06	AC
640	FUNCTION TEST AND	PASS FAIL	6-15-06	TRW
650	TARGET	PASS FAIL	6-15-06	TRW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
670	FINAL INSPECTION		6-15-06	R.P.
	A) HEADSPACE	PASS FAIL	6-21-06	WJW
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	2.78 2.79 2.84 2.80 2.83	6-16-06 RA
680	F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX	7.2 7.2 7.5	6-16-06 RA
	G) SAFETY OFF FORCE	2 LBS MIN	4.0 4.0 4.0	6-16-06 RA
	I) FIRING PIN INDENT	.020	.0215 .0215 .0215	6-16-06 RA
690	PACK		7-5-06	RA

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: **RE00068117** Serial: C6649175 Model 700 Center Fire Caliber: 7 Repairman:
 Verify Repair 62 NATO M/24 SWS Status: Closed 7/28/2003 11:17:46 AM

Address Information

Customer: ☒ Received From Return To: ☐ Received From

Name: **USPFO FOR ARK** **USPFO FOR ARK**

Address 1: **CAMP J T ROBINSON** **CAMP J T ROBINSON**

Address 2: PO Box: PO Box:

City: **NORTH LITTLE ROCK** **NORTH LITTLE ROCK**

State: **AR** Zip Code: **72119** Country: **US** State: **AR** Zip Code: **72119** Country: **US**

FFL: ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐

Contact / Condition	Problems	Estimate	History / Status	Shipping / Billing												
Contact Information Phone: Fax: Email: Comments:	Received Condition Fair Condition Notes: CSR Notes:	Accessories Received <table border="1"> <thead> <tr> <th>Code</th> <th>Desc</th> <th>Qty</th> </tr> </thead> <tbody> <tr> <td>A007</td> <td>With Stud</td> <td>3</td> </tr> <tr> <td>A017</td> <td>Scope Base</td> <td>1</td> </tr> <tr> <td>C000</td> <td>FRONT AND REAR B.</td> <td>1</td> </tr> </tbody> </table>			Code	Desc	Qty	A007	With Stud	3	A017	Scope Base	1	C000	FRONT AND REAR B.	1
Code	Desc	Qty														
A007	With Stud	3														
A017	Scope Base	1														
C000	FRONT AND REAR B.	1														

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

negletj 7/28/2003 12:49 PM CAPS NUM INS SCRL

start 6 Mic... 4 Mic... Arms Se... My Excl... Malfunction 2 Mic... Part Sep... 12:49 PM

Serial Number: **C6649175**

Model: **700**



RE00068117

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6649175.__0

FILE DATE AND TIME: 08/22/2003 07:52

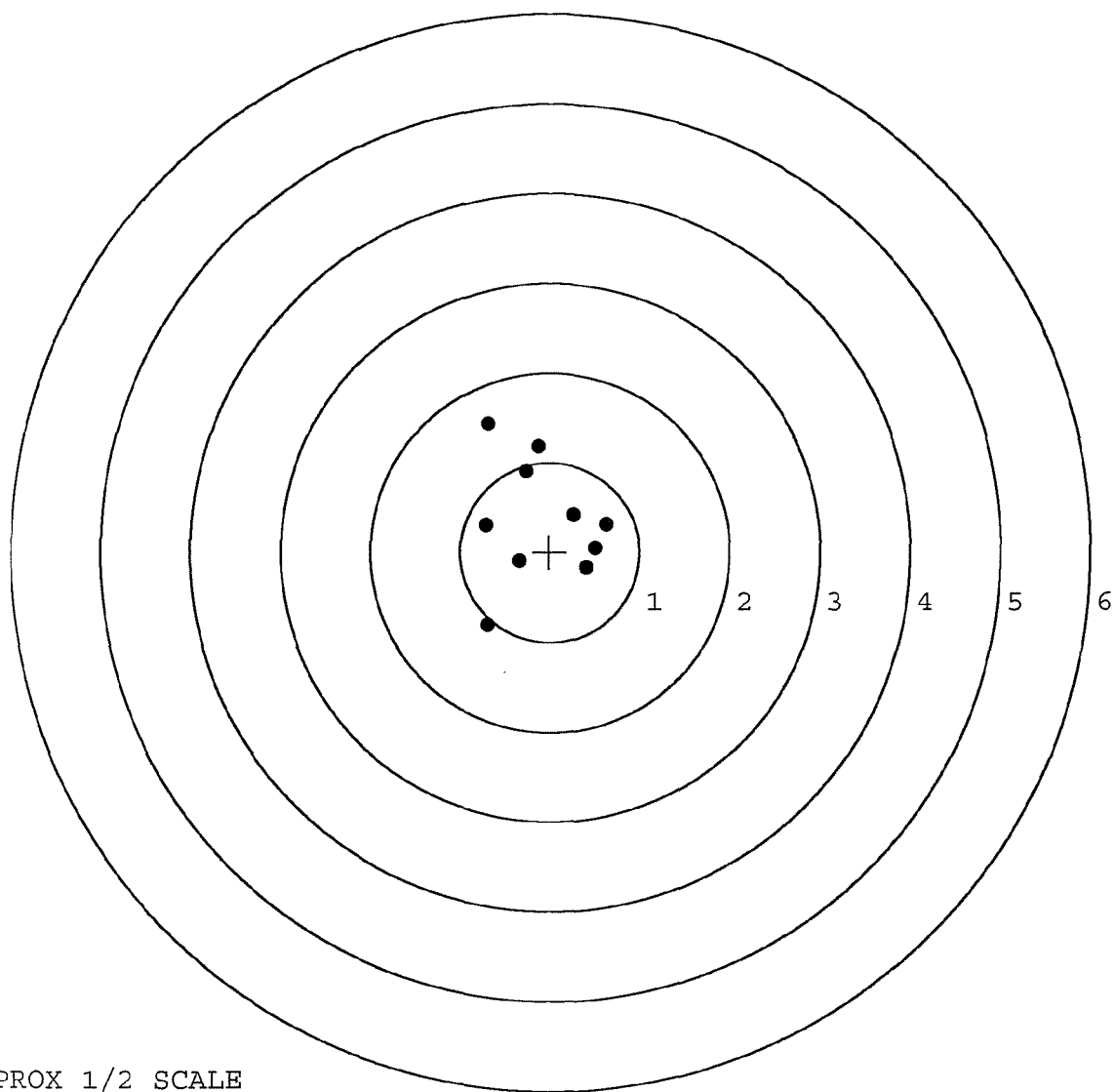
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.102
The Average Y Centroid of the Five Target Set:	0.096
The Average Point of Impact of the Five Target Set:	0.140
The Average Mean Radius of the Five Target Set:	0.609
The Distance from POA to Centroid Target #1:	0.365
The Distance from Centroid Target #2 to Centroid Target #1:	0.345
The Distance from Centroid Target #3 to Centroid Target #1:	0.182
The Distance from Centroid Target #4 to Centroid Target #1:	0.334
The Distance from Centroid Target #5 to Centroid Target #1:	0.461

SERIAL NUMBER: C6649175. __0
TARGET NUMBER: 1
FILE DATE: 08/22/2003
FILE TIME: 07:52

X CENTROID: -0.102
Y CENTROID: 0.351
POA TO CENTROID: 0.365
HORZ SPREAD: 1.349
VERT SPREAD: 2.252
GROUP SPREAD: 2.252
MIN RADIUS: 0.373
MAX RADIUS: 1.313
MEAN RADIUS: 0.760
IN 1 IN DIAMETER: 1
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.263	0.423
2:	0.633	0.318
3:	0.508	0.050
4:	0.409	-0.173
5:	-0.339	-0.104
6:	-0.696	-0.820
7:	-0.716	0.302
8:	-0.264	0.900
9:	-0.123	1.179
10:	-0.700	1.432



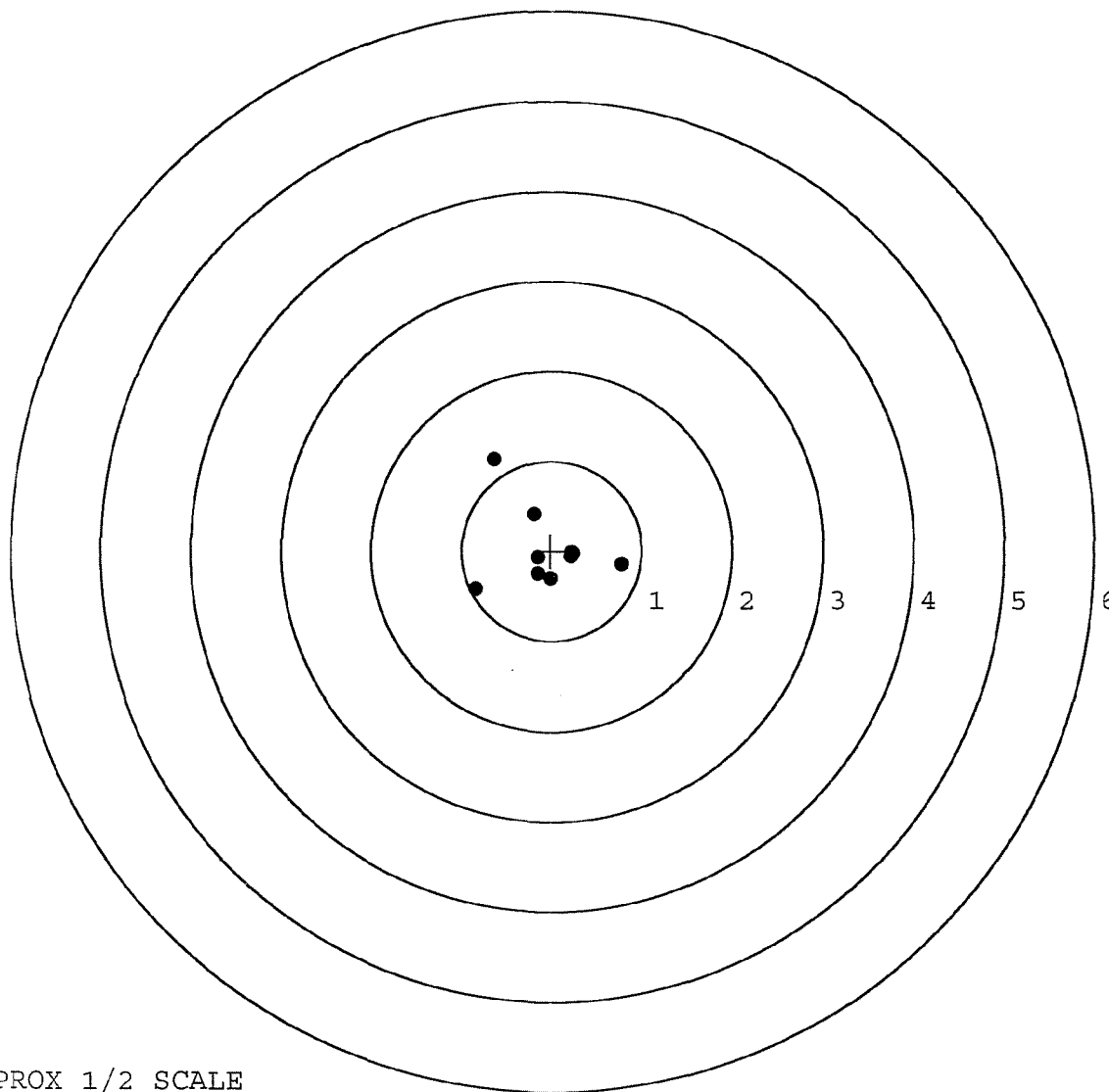
TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6649175. __0
TARGET NUMBER: 2
FILE DATE: 08/22/2003
FILE TIME: 07:52

X CENTROID: -0.052
Y CENTROID: 0.009
POA TO CENTROID: 0.053
HORZ SPREAD: 1.622
VERT SPREAD: 1.442
GROUP SPREAD: 1.841
MIN RADIUS: 0.131
MAX RADIUS: 1.167
MEAN RADIUS: 0.495

POINT#	X	Y
1:	-0.841	-0.427
2:	-0.644	1.015
3:	-0.198	0.413
4:	0.781	-0.151
5:	0.224	-0.061
6:	-0.148	-0.080
7:	-0.010	-0.311
8:	0.240	-0.028
9:	-0.153	-0.259
10:	0.229	-0.019

IN 1 IN DIAMETER: 7
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10



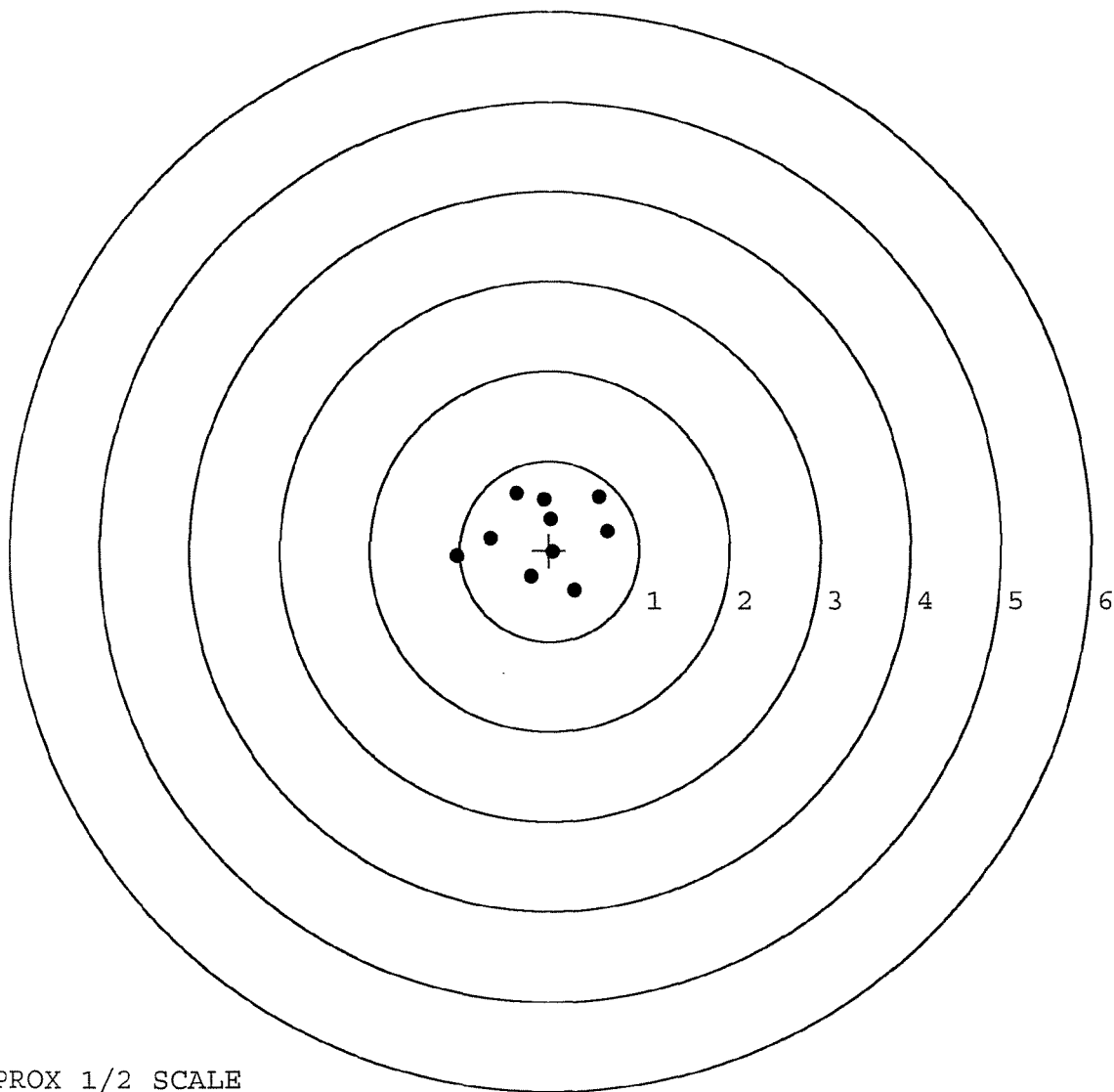
TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6649175. 0
TARGET NUMBER: 3
FILE DATE: 08/22/2003
FILE TIME: 07:52

X CENTROID: -0.079
Y CENTROID: 0.170
POA TO CENTROID: 0.188
HORZ SPREAD: 1.675
VERT SPREAD: 1.076
GROUP SPREAD: 1.718
MIN RADIUS: 0.204
MAX RADIUS: 0.981
MEAN RADIUS: 0.562

POINT#	X	Y
1:	-1.031	-0.068
2:	-0.663	0.135
3:	-0.371	0.639
4:	-0.060	0.568
5:	0.015	0.352
6:	0.550	0.604
7:	0.644	0.218
8:	0.043	-0.017
9:	-0.200	-0.290
10:	0.284	-0.437

IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 10
in 3 IN DIAMETER: 10

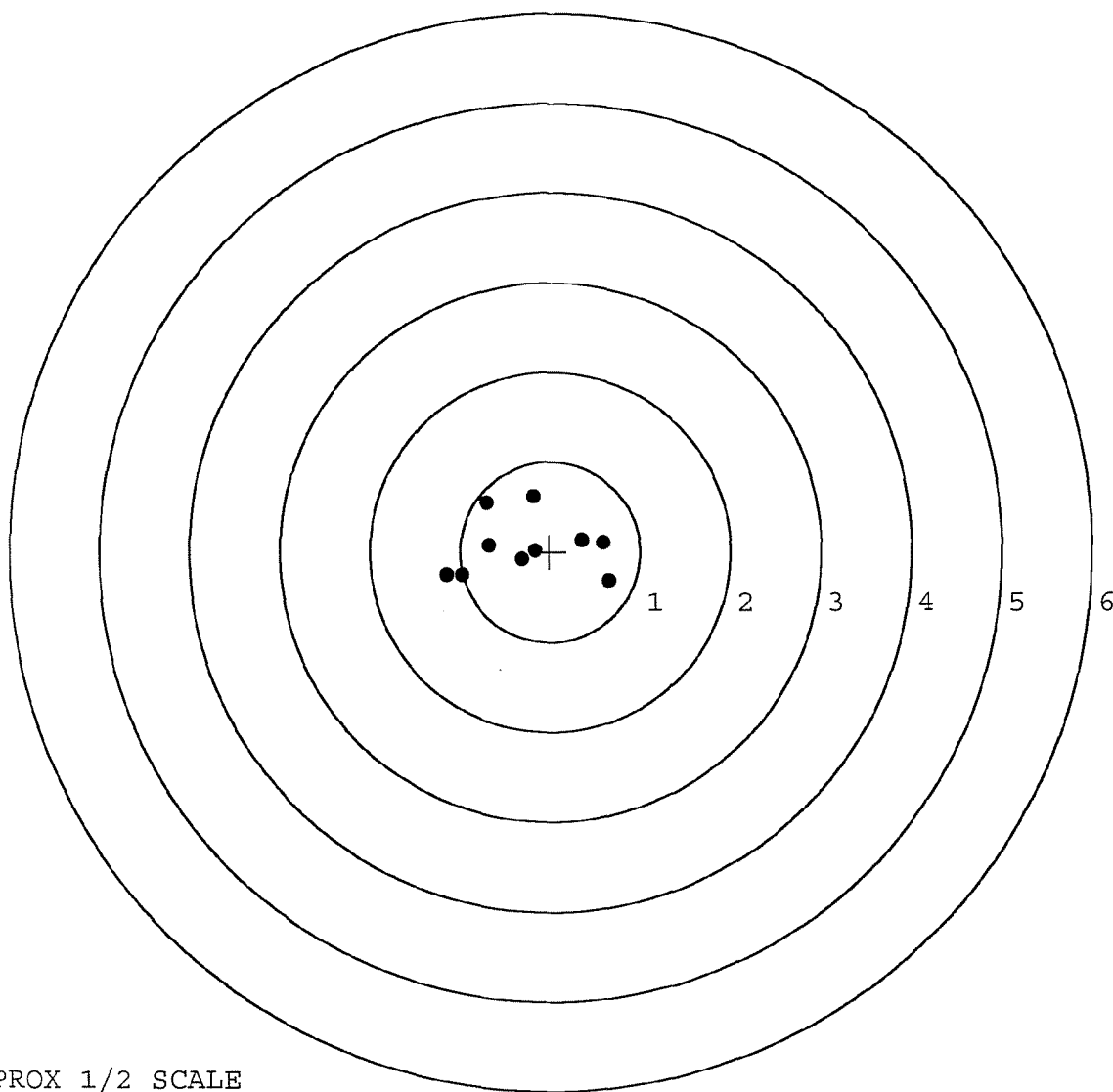


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6649175. __0
TARGET NUMBER: 4
FILE DATE: 08/22/2003
FILE TIME: 07:52

X CENTROID: -0.256
Y CENTROID: 0.054
POA TO CENTROID: 0.261
HORZ SPREAD: 1.808
VERT SPREAD: 0.932
GROUP SPREAD: 1.809
MIN RADIUS: 0.103
MAX RADIUS: 0.987
MEAN RADIUS: 0.610
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 10
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.181	0.612
2:	-0.712	0.542
3:	-0.675	0.073
4:	-1.150	-0.263
5:	-0.979	-0.261
6:	-0.160	0.015
7:	-0.310	-0.090
8:	0.357	0.128
9:	0.595	0.103
10:	0.658	-0.320

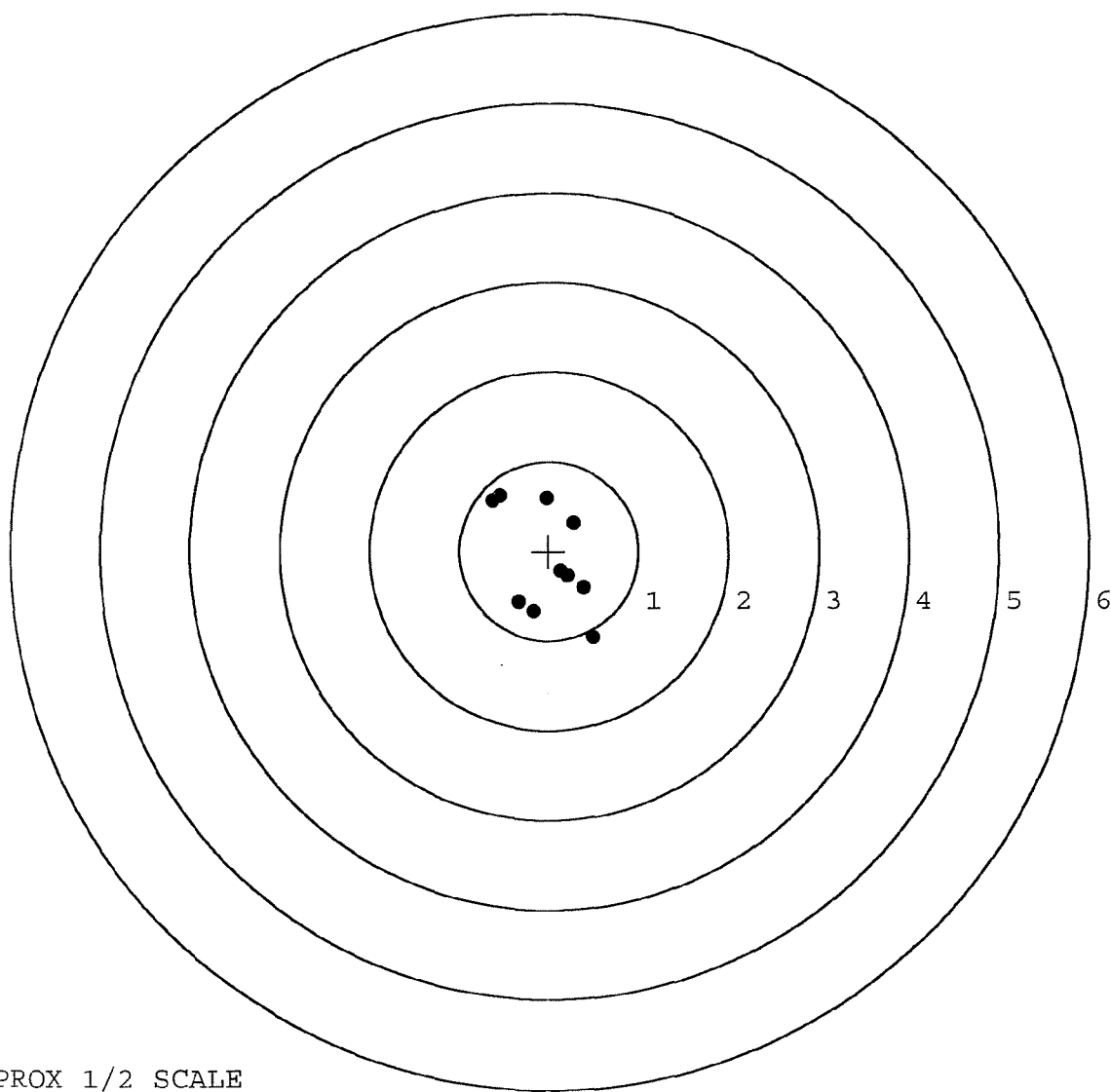


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6649175.___0
TARGET NUMBER: 5
FILE DATE: 08/22/2003
FILE TIME: 07:52

X CENTROID: -0.021
Y CENTROID: -0.103
POA TO CENTROID: 0.105
HORZ SPREAD: 1.128
VERT SPREAD: 1.579
GROUP SPREAD: 1.897
MIN RADIUS: 0.199
MAX RADIUS: 1.003
MEAN RADIUS: 0.617
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.552	0.618
2:	-0.629	0.561
3:	-0.025	0.597
4:	0.276	0.317
5:	0.137	-0.224
6:	0.212	-0.278
7:	0.387	-0.411
8:	-0.337	-0.570
9:	-0.173	-0.675
10:	0.499	-0.961



TARGET APPROX 1/2 SCALE

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

R & E NUMBER	68117		
SERIAL NUMBER	C6649175		
LOG-IN DATE	7-28-03		
INSPECT AND VERIFY:			
OPERATION #	OPERATION NAME	DATE	INITIAL
550	DIS-ASSEMBLE GUN	7-3-03	RTL
560 A	RE-BARREL	8-7-03	RTL
B	DRILL AND TAP	8-11-03	TRW
575	ASSEMBLE	8-11-03	RTL
600	PROOF	8-11-03	AC
605	CHECK HEADSPACE	8-11-03	AC
610	DIS-ASSEMBLE GUN	8-11-03	RTL
612	MAGNAFLUX OPERATOR		
615	ROLLMARK CALIBER	8-12-03	SB
618	ROTO-BLAST	8-13-03	JB
620	APPLY COATINGS	8-14	TH
625 A	FINAL ASSEMBLY	8-19-03	RTL
B	TRIGGER PULL TEST		
C	SAFETY "ON" FORCE		
D	SAFETY "OFF" FORCE		
E	FIRING PIN INDENT		
640	TARGET	8-22-03	TRW
655	FINAL INSPECT	8-22-03	EW
660	PACK	8-25-03	RA
		SHIP DATE	
	QAR INSPECTION DATE		

Remington



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

MODEL 700 TM M24

SERIAL NO.

C6649175

ORDER NO.

5716

20

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



5716 C6649175

ORDER 5716
MODEL 700 TM M24
UPC



0 47700 25716 7

ORDER 5716
MODEL 700 TM M24
UPC



0 47700 25716 7

GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6649175

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	10 1 91		RW
600	Proof	10 1 91		RW
607	Check Headspace	10 1 91		RW
610	Dis-assemble Gun	10 1 91		RW
612	Magnaflux Barrel Action	OCT 1 0 1991		KR
	Magnaflux Bolt	OCT 1 0 1991		KR
615	Rollmark Caliber	OCT 1 0 1991		GS.
617	Drill and Tap Sight Holes	OCT 1 0 1991		LB
618	Polish Barrel		10/15/91	WB
620	Apply Coatings (Barrel Action)		11/8/91	AA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		11/14/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		11/14/91	RW
	C) Inspect Ejector Hole for Chamfer		11/14/91	RW
	D) Oil Firing Pin Ass'y		11/14/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		11/27/91	WB

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			12-30-91	AC
	G) Safety Off Force	4	5	5			12-30-91	AC
	H) Trigger Pull Test & Retainability						12/27/91	WB
	I) Firing Pin Indent	.021	.021	.020			12-30-91	AC
	J) Assemble Stock						12/30/91	RW
	K) Assemble Swivel Studs						1-3-92	JEP
	L) Attach Front and Rear Sight Assemblies						12/30/91	RW
	M) Iron Sight Alignment						12/30/91	RW
	N) Detach Front & Rear Sights & place in numbered container						12/30/91	RW
	O) Attach Scope to Rifle						12/30/91	RW
	P) Detach & Attach Scope 20 Times						12/30/91	RW
640	Gallery Target & Test						1-2-92	AC
	A) Time						1-2-92	AC
	B) Malfunctions						1-2-92	AC
	C) Pierced Primers						1-2-92	AC
	D) Optical Clarity of Scope						1-2-92	AC
645	Inspect for Live Ammo						1-2-92	AC
655	Final Inspection							
	A) Headspace						1-3-92	JEP
	B) Trigger Pull	2.32	2.44	2.38	2.40	2.35	1-2-92	AC
	C) Function							
660	Pack						2-25-92	VF

SWS TRIGGER PULL TEST

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

SERIAL NO. C6649175
DATE 12/27/91
TESTER WB

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.42	2.33	2.23	2.32	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.36	2.27	2.21	2.44	
PULL #3	2.34	2.27	2.24	2.38	
PULL #4	2.26	2.36	2.19	2.40	
PULL #5	2.31	2.29	2.27	2.35	
TOTAL	11.69	11.52	11.14	11.89	
AVG.	2.34	2.30	2.23	2.37	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.23	3.23		
PULL #2	3.22	3.11		
PULL #3	3.20	3.00		
PULL #4	3.01	3.00		
PULL #5	3.00	2.97		
TOTAL	15.66	15.31		
AVG.	3.13	3.06		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.21	4.22		3.96
PULL #2	4.10	4.03		4.05
PULL #3	4.14	4.04		4.01
PULL #4	4.00	4.16		4.02
PULL #5	4.21	4.14		4.01
TOTAL	20.66	20.59		20.05
AVG.	4.13	4.12		4.01

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6649175
2 Jan 1992

CENTROIDAL DISTANCES

0 TO 1	.0410366
1 TO 2	.359134
1 TO 3	.199251
1 TO 4	.259147
1 TO 5	.31161

$\frac{91}{3}^2$ <----POA

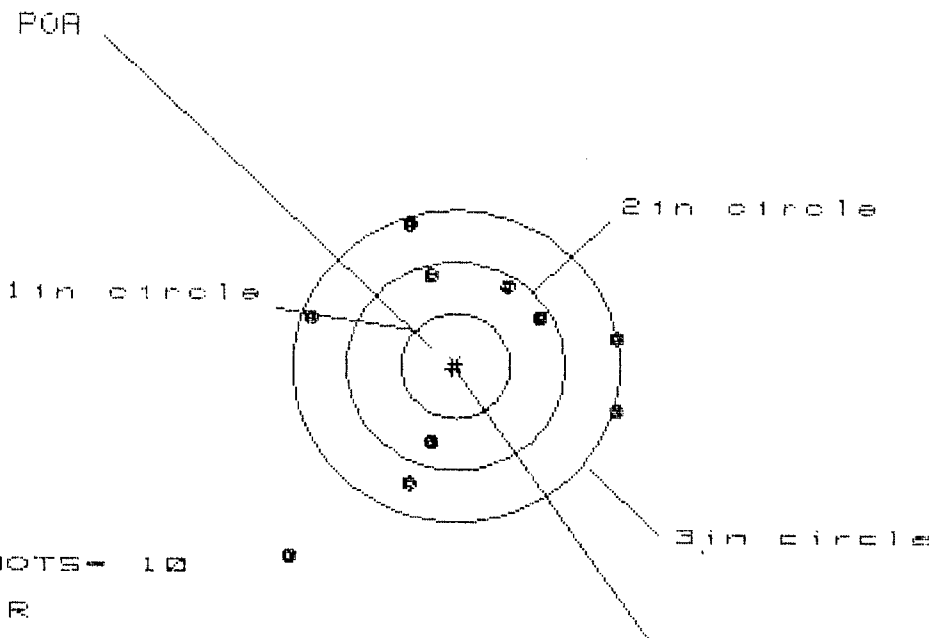
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0056
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .084
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0041865
THE ANR FOR THIS RIFLE IS: 1.153

2 Jan 1992

FILE:/PATTERNING/CENTERFIRE_PATT/C8649175

CENTERFIRE PATTERNS

1



OF SHOTS- 10

IN CIR

1 in = 0

2 in = 4

3 in = 8

HS= 2.981

VS= 3.197

GS= 3.625

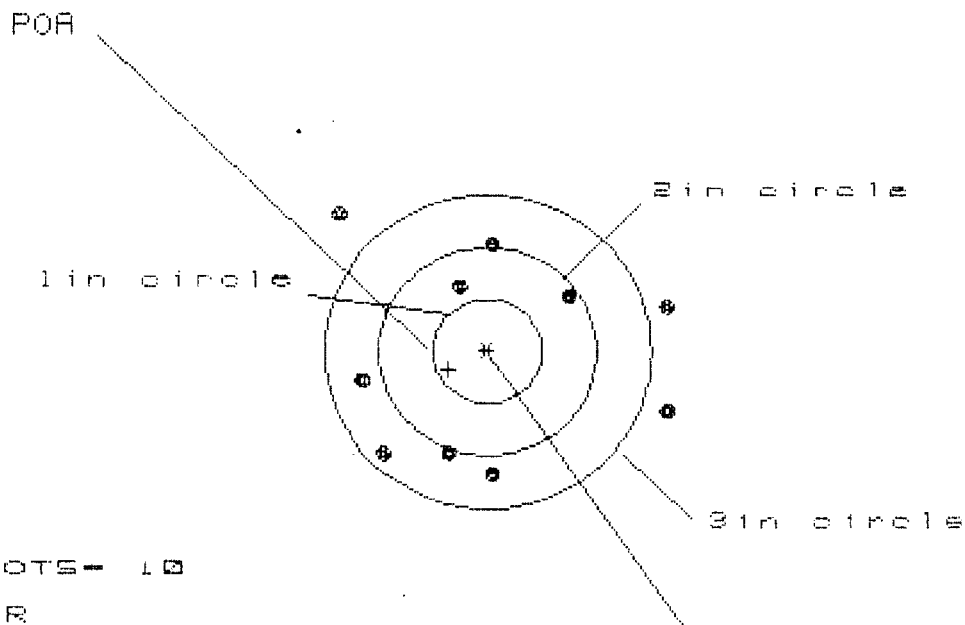
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.466	1.298	1.454
MINIMUM X	-1.515	-1.478	-1.322
MAXIMUM Y	1.387	1.186	1.102
MINIMUM Y	-1.810	-1.348	-1.432
CENTROID X	.028	.196	.040
CENTROID Y	.030	.231	.315
POA TO CENTROID in.	.041	.304	.318
MIN RADIUS	.807	.653	.616
MEAN RADIUS	1.292	1.129	1.080
MAX RADIUS	2.361	1.507	1.493
HORIZONTAL SPREAD	2.981	2.776	2.776
VERTICAL SPREAD	3.197	2.534	2.534
EXTREME SPREAD	3.625	2.899	2.787
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	9		

2 Jan 1992

FILE:/PATTERNING/CENTERFIRE_PATT/C6649175

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 0

2 in = 3

3 in = 7

HS= 3.003

VS= 2.539

GS= 3.573

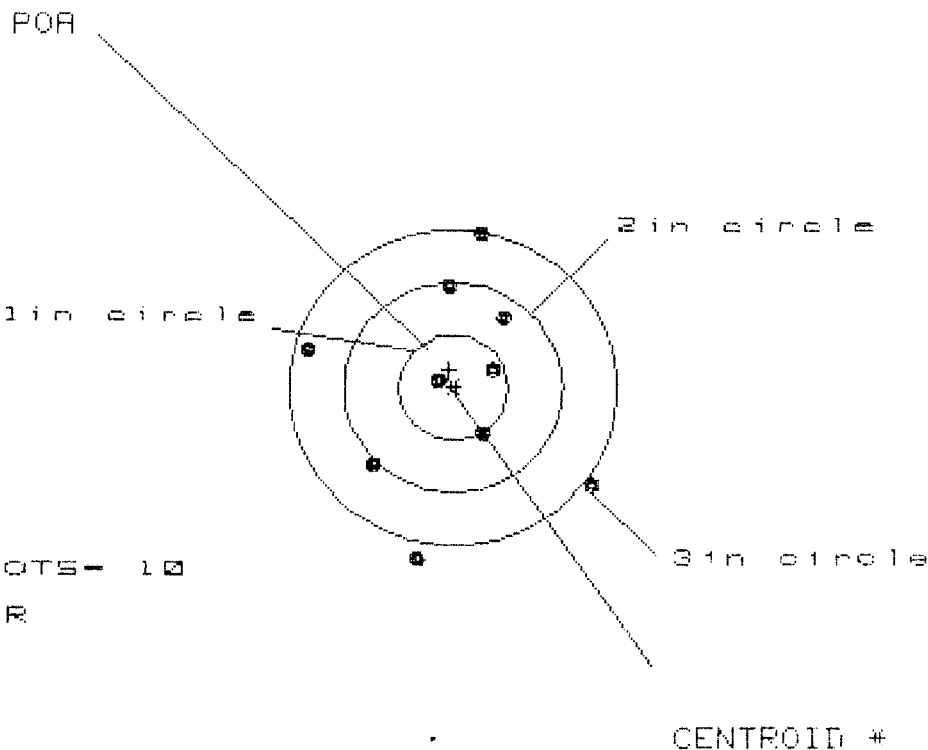
CENTROID #

PATTERN #	2
SHOTS (BEST OF)	10
MAXIMUM X	1.627
MINIMUM X	-1.376
MAXIMUM Y	1.364
MINIMUM Y	-1.175
CENTROID X	.357
CENTROID Y	.174
POA TO CENTROID in.	.397
MIN RADIUS	.720
MEAN RADIUS	1.271
MAX RADIUS	1.938
HORIZONTAL SPREAD	3.003
VERTICAL SPREAD	2.539
EXTREME SPREAD	3.573
NUMBER IN ONE INCH CIRCLE =	0
NUMBER IN TWO INCH CIRCLE =	3
NUMBER IN THREE INCH CIRCLE =	7

2 Jan 1992

FILE:/PATTERNING/CENTERFIRE_PATT/C8849175

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 5

3 in = 8

HS= 2.588

VS= 3.092

GS= 3.140

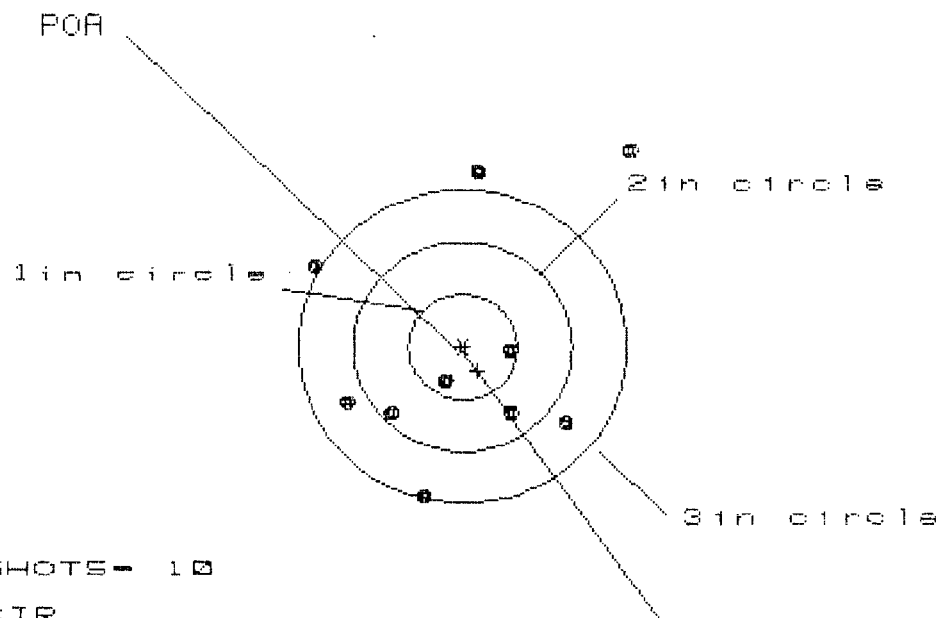
CENTROID #

PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	1.245
MINIMUM X	-1.343
MAXIMUM Y	1.436
MINIMUM Y	-1.656
CENTROID X	.038
CENTROID Y	-.169
POR TO CENTROID in.	.173
MIN RADIUS	.136
MEAN RADIUS	.994
MAX RADIUS	1.688
HORIZONTAL SPREAD	2.588
VERTICAL SPREAD	3.092
EXTREME SPREAD	3.140
NUMBER IN ONE INCH CIRCLE =	2
NUMBER IN TWO INCH CIRCLE =	5
NUMBER IN THREE INCH CIRCLE =	8

2 Jan 1992

FILE:/PATTERNING/CENTERFIRE_PATT/C6649175

CENTERFIRE PATTERNS # 4



OF SHOTS - 10

IN CIR

1in = 2

2in = 4

3in = 7

HS = 2.822

VS = 3.359

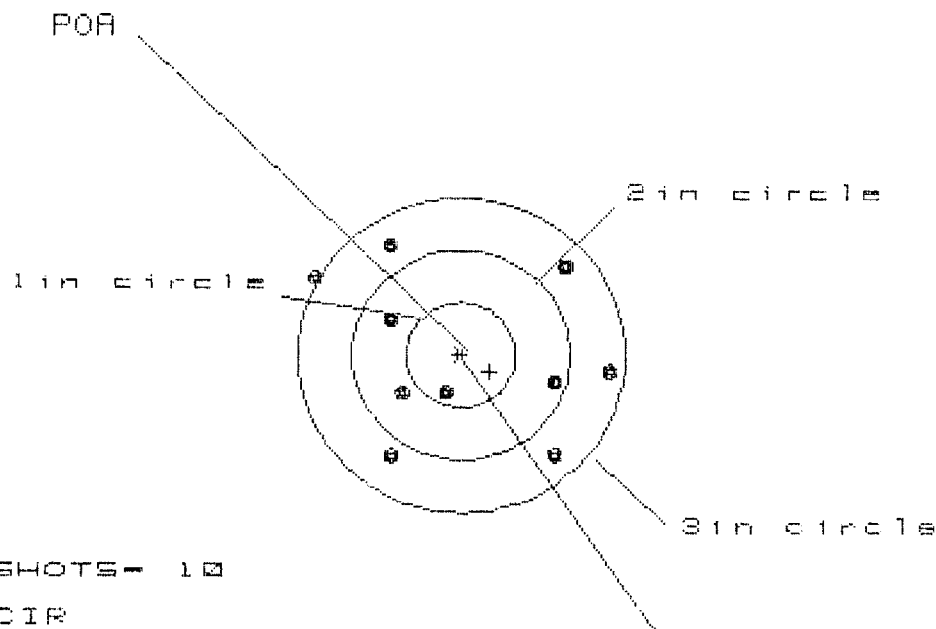
GS = 3.818

PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.503	1.086	1.120
MINIMUM X	-1.319	-1.152	-1.118
MAXIMUM Y	1.905	1.909	1.184
MINIMUM Y	-1.454	-1.242	-1.004
CENTROID X	-.138	-.385	-.339
CENTROID Y	.229	.017	-.221
POA TO CENTROID in.	.267	.305	.405
MIN RADIUS	.382	.153	.117
MEAN RADIUS	1.198	.999	.838
MAX RADIUS	2.427	1.928	1.629
HORIZONTAL SPREAD	2.822	2.238	2.238
VERTICAL SPREAD	3.359	3.151	2.188
EXTREME SPREAD	3.818	3.178	2.649
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	7		

2 Jan 1992

FILE:/PATTERNING/CENTERFIRE_PATT-06649175

CENTERFIRE PATTERNS # 5



OF SHOTS - 10

IN CIR

1 in = 1

2 in = 4

3 in = 9

HS = 2.658

VS = 2.024

GS = 2.791

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.333	1.186	.941
MINIMUM X	:	-1.325	-.819	-.671
MAXIMUM Y	:	1.078	1.157	1.149
MINIMUM Y	:	-.946	-.867	-.876
CENTROID X	:	-.257	-.110	-.258
CENTROID Y	:	.156	.077	.085
POA TO CENTROID in.	:	.301	.134	.272
MIN RADIUS	:	.325	.337	.258
MEAN RADIUS	:	1.034	.974	.926
MAX RADIUS	:	1.502	1.395	1.319
HORIZONTAL SPREAD	:	2.658	2.005	1.612
VERTICAL SPREAD	:	2.024	2.024	2.024
EXTREME SPREAD	:	2.791	2.453	2.453
NUMBER IN ONE INCH CIRCLE =			1	
NUMBER IN TWO INCH CIRCLE =			4	
NUMBER IN THREE INCH CIRCLE =			9	

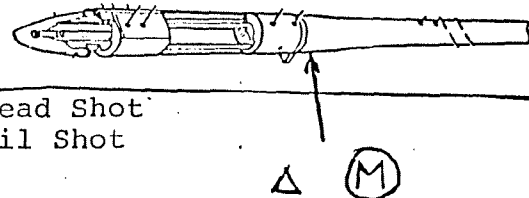
5W- Endurance BBL & Bc ?
QP 0041
C-6665832

MAGNETIC PARTICLE INSPECTION

PART NUMBER _____

PART NAME Final Bbl.Assem.MATERIAL Bbl. Rem.Spec.#155-Rec.Spec.4137M

OPERATION NUMBER 615

METHOD	S I N G L E P A R T S			M U L T I P L E P A R T S			SKETCH AND/OR REMARKS
	HEAD SHOT	CENTRAL	CONDUCTOR	HEAD SHOT	CENTRAL	COIL SHOT	
	HEAD SHOT	CONDUCTOR	COIL SHOT	CONDUCTOR	IN BASKET	AMPERES	
NON-FLUORESCENT CONTINUOUS WET							
FLUORESCENT CONTINUOUS WET	Yes		Yes (2 Overlapping)				
NON-FLUORESCENT RESIDUAL WET							
FLUORESCENT RESIDUAL WET							

APPROVAL:
INSP. _____ LEV III _____
DATE: _____ DATE: _____

ACCEPTANCE STANDARD

No Indications acceptable in the
Locking Lug area of Receiver or
chamber area of Bbl.

STEEL STAMP ON. Triangular stamp Δ and letter "M" circled
OTHER Location-right side near Receiver.

PROCEDURE:

1. All parts must be cleaned before testing.
2. All parts shall be satisfactorily demagnetized after all magnetization has been completed.
3. The magnetic substance shall be completely removed from all parts after inspection and demagnetization.
4. All accepted parts must be marked with a mangaflux stamp, acid etch, or ink stamp (If the part is too small or is a critical part, contact inspection supervisor).
5. Parts having indications not acceptable shall be segregated and identified, and are to be reviewed by Metallurgy and inspection groups.
6. All areas to be inspected 100%.
7. Inspection to be performed by a certified Level I, acceptance or rejection of product will be done by a certified Level II, or Level III.

USE BACK SIDE OF THIS CARD TO RECORD EACH LOT INSPECTED.
ALL BLOCKS MUST BE PROPERLY FILLED IN.

LEV III. Karl Rice
INSP. 8458-8096

SWS Endurance Bolt Bolt

QP 0041

Redefined

DATE	MFG. ORDER NO.	QUANTITY	SERIAL #	QUANTITY OF PARTS	
				ACCEPTED	REJECTED
10/29/91	2,500	1		1	1
11/8/91	5,000	1		1	1
11/15/91	7,500	1		1	1
11/26/91	10,000	1		1	1

OK
gghill
11/26/91

GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C 6665832

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		9/23/91	KL
600	Proof		9/23/91	KL
607	Check Headspace		9/23/91	KL
610	Dis-assemble Gun		9/23/91	KL
612	Magnaflux Barrel Action		SEP 30 1991	KR
	Magnaflux Bolt		SEP 30 1991	KR
615	Rollmark Caliber		SEP 30 1991	LL
617	Drill and Tap Sight Holes		SEP 30 1991	EB
618	Polish Barrel		OCT 2 1991	WB
620	Apply Coatings (Barrel Action)		9/29/91	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		10/8/91	KL
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/8/91	KL
	C) Inspect Ejector Hole for Chamfer		10/8/91	KL
	D) Oil Firing Pin Ass'y		10/8/91	KL
	E) Adjust Trigger Pull to Min Setting and Stake		10/10/91	KL

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	5	6			10-10-91	AC
	G) Safety Off Force	4	4	4			10-10-91	AC
	H) Trigger Pull Test & Retainability						10/10/91	AC
	I) Firing Pin Indent	.021	.021	.022			10-10-91	AC
	J) Assemble Stock						10/10/91	AC
	K) Assemble Swivel Studs						10-17-91	AC
	L) Attach Front and Rear Sight Assemblies						10/10/91	AC
	M) Iron Sight Alignment						10/10/91	AC
	N) Detach Front & Rear Sights & place in numbered container						10/10/91	AC
	O) Attach Scope to Rifle						10/10/91	AC
	P) Detach & Attach Scope 20 Times						10/10/91	AC
640	Gallery Target & Test						10-14-91	AC
	A) Time						"	AC
	B) Malfunctions						"	AC
	C) Pierced Primers						"	AC
	D) Optical Clarity of Scope						"	AC
645	Inspect for Live Ammo						10-14-91	AC
655	Final Inspection						10-14-91	AC
	A) Headspace							
	B) Trigger Pull	227	227	226	228	230	10-15-91	AC
	C) Function						10-17-91	AC
660	Pack							

SWS TRIGGER PULL TEST

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

SERIAL NO. C6665832
DATE 10/10/91
TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.44	2.15	2.20	2.27	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.43	2.28	2.28	2.27	
PULL #3	2.28	2.18	2.20	2.26	
PULL #4	2.19	2.22	2.28	2.28	
PULL #5	2.21	2.19	2.30	2.30	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.46	3.32		
PULL #2	3.35	3.32		
PULL #3	3.38	3.18		
PULL #4	3.20	3.30		
PULL #5	3.37	3.19		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.40	4.23		4.24
PULL #2	4.28	4.17		4.23
PULL #3	4.24	4.18		4.22
PULL #4	4.30	4.21		4.22
PULL #5	4.25	4.21		4.17
TOTAL				
AVG.				

ENDURANCE

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6665832
14 Oct 1991

O RDS

CENTROIDAL DISTANCES

0 TO	1	.213588
1 TO	2	.193313
1 TO	3	.157493
1 TO	4	.2414
1 TO	5	.206293

←----POA

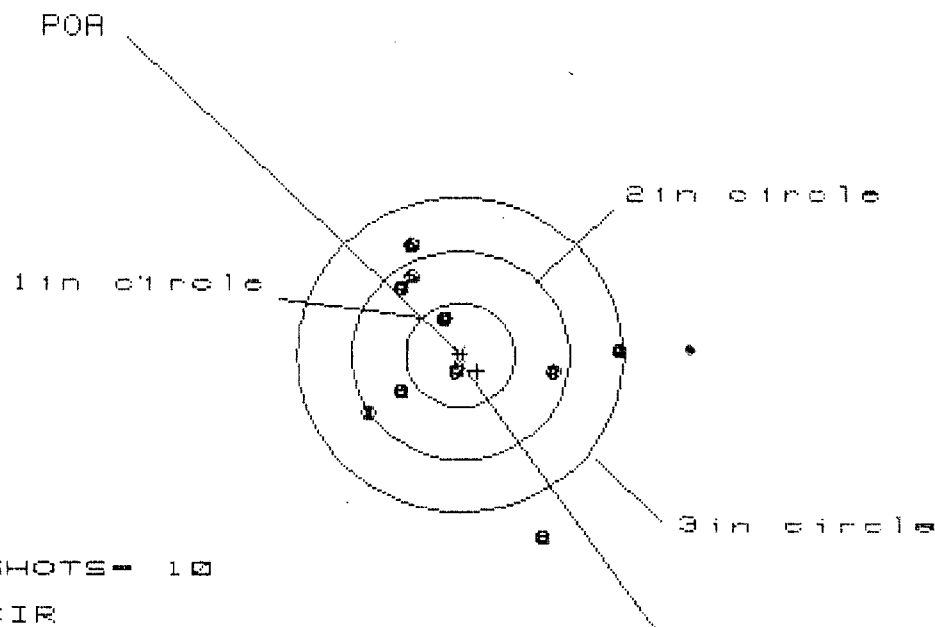
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.081
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .012
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0818841

THE AMR FOR THIS RIFLE IS: 1.007

14 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6865832

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 2

2in = 6

3in = 8

HS= 2.310

VS= 2.785

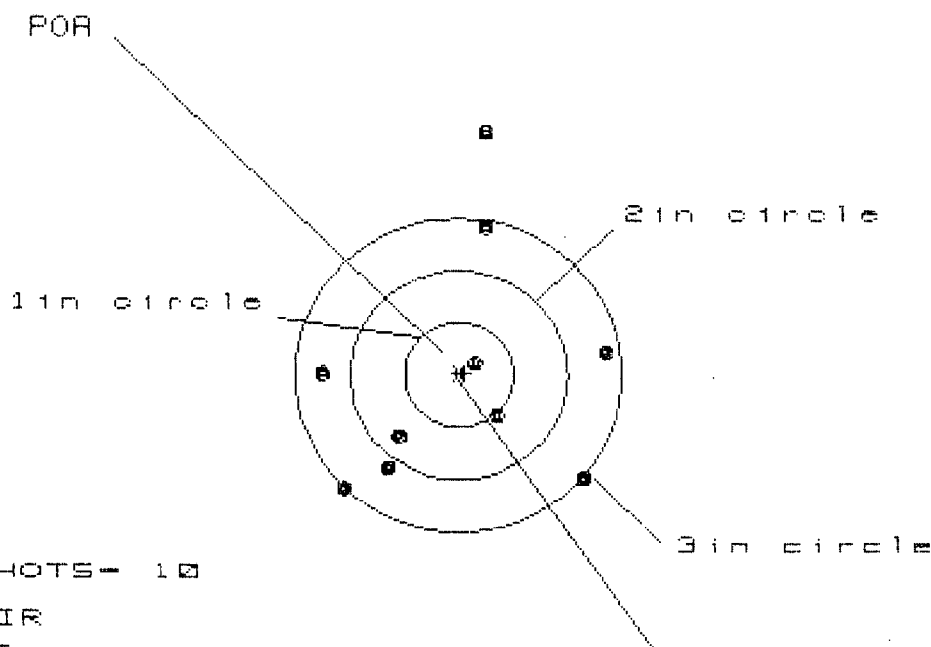
GS= 3.044

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.446	1.533	1.109
MINIMUM X	-.864	-.777	-.585
MAXIMUM Y	1.010	.813	.797
MINIMUM Y	-1.775	-.721	-.737
CENTROID X	-.154	-.241	-.433
CENTROID Y	.148	.345	.361
POA TO CENTROID in.	.214	.421	.564
MIN RADIUS	.109	.217	.206
MEAN RADIUS	.929	.783	.660
MAX RADIUS	1.941	1.538	1.158
HORIZONTAL SPREAD	2.310	2.310	1.694
VERTICAL SPREAD	2.785	1.534	1.534
EXTREME SPREAD	3.044	2.386	1.741
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	9		

14 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6B65832

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 2

2in = 3

3in = 8

HS= 2.595

VS= 3.342

GS= 3.573

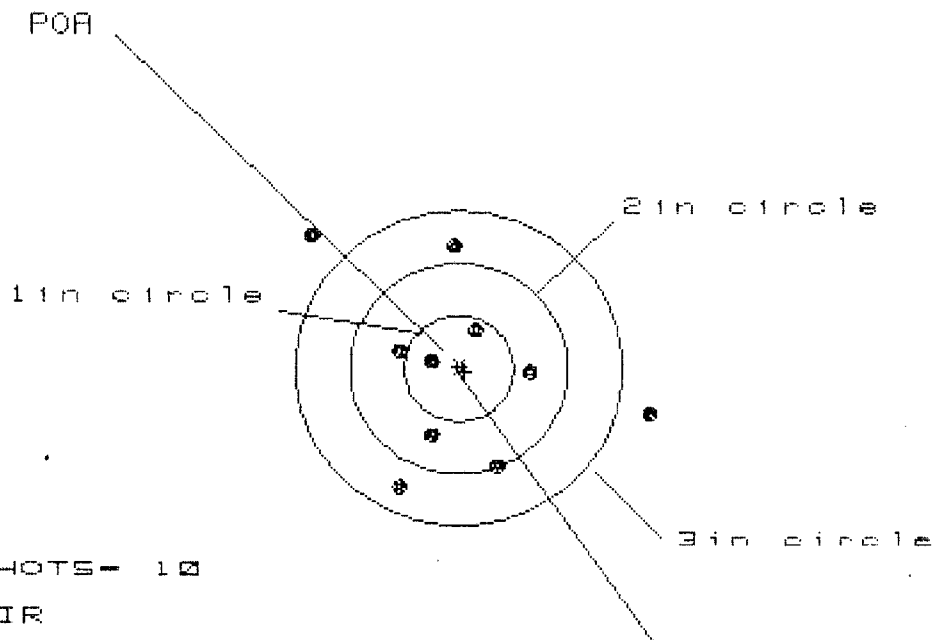
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.322	1.351	1.500
MINIMUM X	:	-1.273	-1.244	-1.095
MAXIMUM Y	:	2.282	1.683	1.587
MINIMUM Y	:	-1.060	-.807	-.903
CENTROID X	:	-.047	-.076	-.225
CENTROID Y	:	-.013	-.266	-.169
POA TO CENTROID in.	:	.049	.277	.282
MIN RADIUS	:	.176	.388	.411
MEAN RADIUS	:	1.200	1.046	.998
MAX RADIUS	:	2.296	1.707	1.645
HORIZONTAL SPREAD	:	2.595	2.595	2.595
VERTICAL SPREAD	:	3.342	2.490	2.490
EXTREME SPREAD	:	3.573	2.792	2.792
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		8	

14 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06665832

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 2

2in = 6

3in = 8

HS= 3.014

VS= 2.394

GS= 3.444

CENTROID #

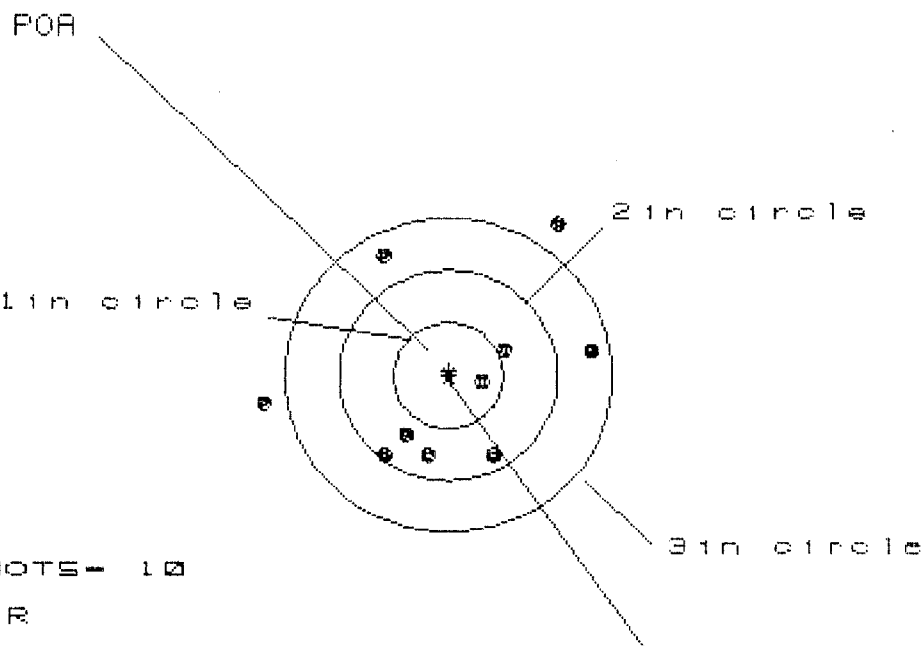
PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.708	1.563	.704
MINIMUM X	:	-1.306	-.653	-.457
MAXIMUM Y	:	1.274	1.316	1.285
MINIMUM Y	:	-1.120	-.978	-1.009
CENTROID X	:	-.052	.093	-.103
CENTROID Y	:	.028	-.114	-.083
POA TO CENTROID in.	:	.059	.147	.132
MIN RADIUS	:	.260	.448	.268
MEAN RADIUS	:	.943	.851	.727
MAX RADIUS	:	1.824	1.583	1.285
HORIZONTAL SPREAD	:	3.014	2.216	1.161
VERTICAL SPREAD	:	2.394	2.294	2.294
EXTREME SPREAD	:	3.444	2.343	2.343
NUMBER IN ONE INCH CIRCLE =			2	
NUMBER IN TWO INCH CIRCLE =			6	
NUMBER IN THREE INCH CIRCLE =			8	

14 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6665832

CENTERFIRE PATTERNS

4



OF SHOTS- 10

IN CIR

1in = 1

2in = 6

3in = 8

HS= 3.014

VS= 2.190

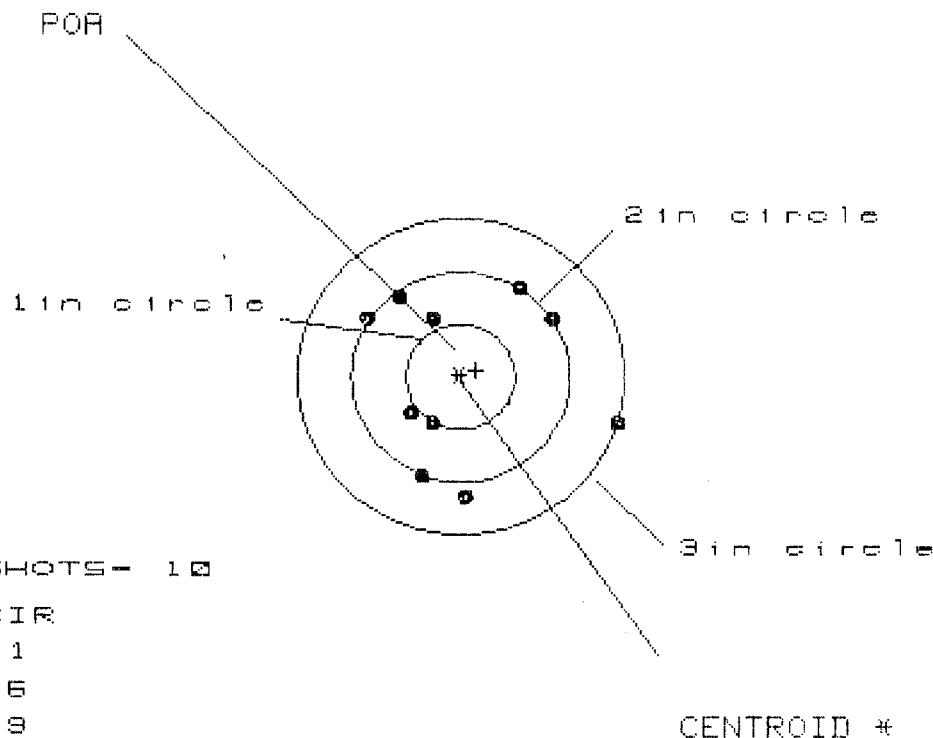
GS= 3.261

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.294	1.408	1.208
MINIMUM X	:	-1.720	-1.606	-.700
MAXIMUM Y	:	1.448	1.348	1.331
MINIMUM Y	:	-.742	-.581	-.598
CENTROID X	:	-.009	-.123	.077
CENTROID Y	:	-.045	-.206	-.189
POA TO CENTROID in.	:	.046	.240	.204
MIN RADIUS	:	.290	.413	.218
MEAN RADIUS	:	1.029	.920	.806
MAX RADIUS	:	1.779	1.612	1.504
HORIZONTAL SPREAD	:	3.014	3.014	1.908
VERTICAL SPREAD	:	2.190	1.929	1.929
EXTREME SPREAD	:	3.261	3.067	2.150
NUMBER IN ONE INCH CIRCLE =	:	1		
NUMBER IN TWO INCH CIRCLE =	:	6		
NUMBER IN THREE INCH CIRCLE =	:	8		

14 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6665832

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 1

2in = 6

3in = 9

HS= 2.338

VS= 1.979

GS= 2.552

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.467	.956	.980
MINIMUM X	-.871	-.708	-.684
MAXIMUM Y	.829	.781	.631
MINIMUM Y	-1.150	-1.198	-1.165
CENTROID X	-.143	-.306	-.330
CENTROID Y	-.058	-.010	.140
POA TO CENTROID in.	.155	.306	.359
MIN RADIUS	.479	.472	.404
MEAN RADIUS	.935	.840	.777
MAX RADIUS	1.532	1.214	1.177
HORIZONTAL SPREAD	2.338	1.664	1.664
VERTICAL SPREAD	1.979	1.979	1.796
EXTREME SPREAD	2.552	2.038	1.994
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	9		

Endurance

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06665832
21 Oct 1991

500 RDS

CENTROIDAL DISTANCES

0 TO	1	.528992
1 TO	2	.6508
1 TO	3	.528607
1 TO	4	.673011
1 TO	5	.461192

3-2 (----POA
1

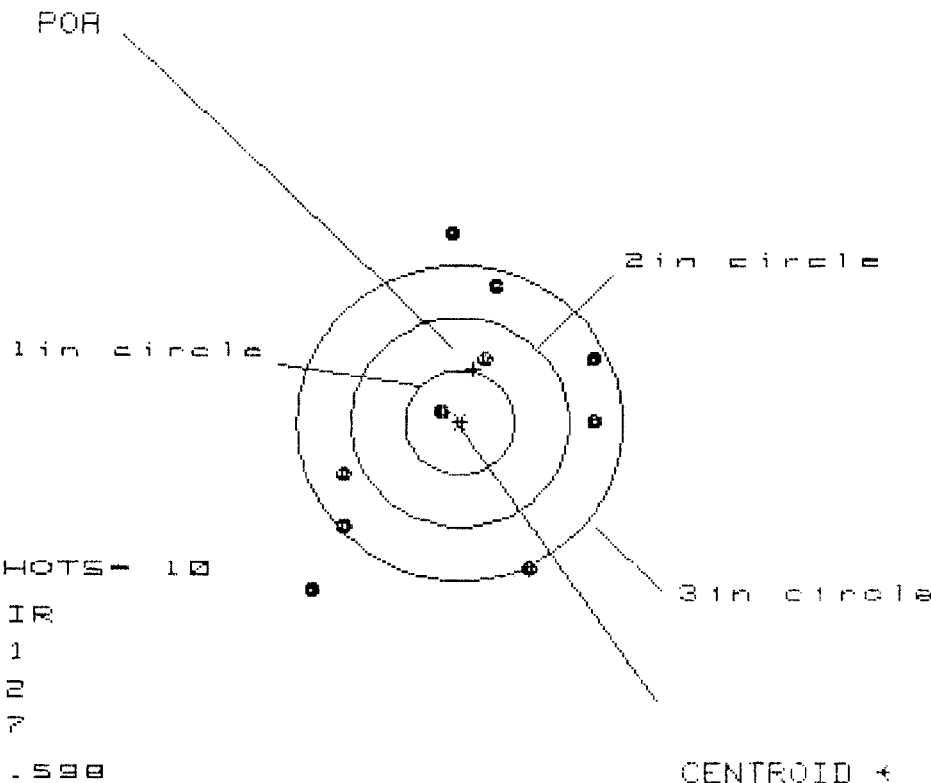
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0214
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.098
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .100309

THE AMR FOR THIS RIFLE IS: .9684

21 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8665832.1

CENTERFIRE PATTERNS # 1



OF SHOTS - 10

IN CIR

1 in = 1

2 in = 2

3 in = 7

HS = 2.598

VS = 3.377

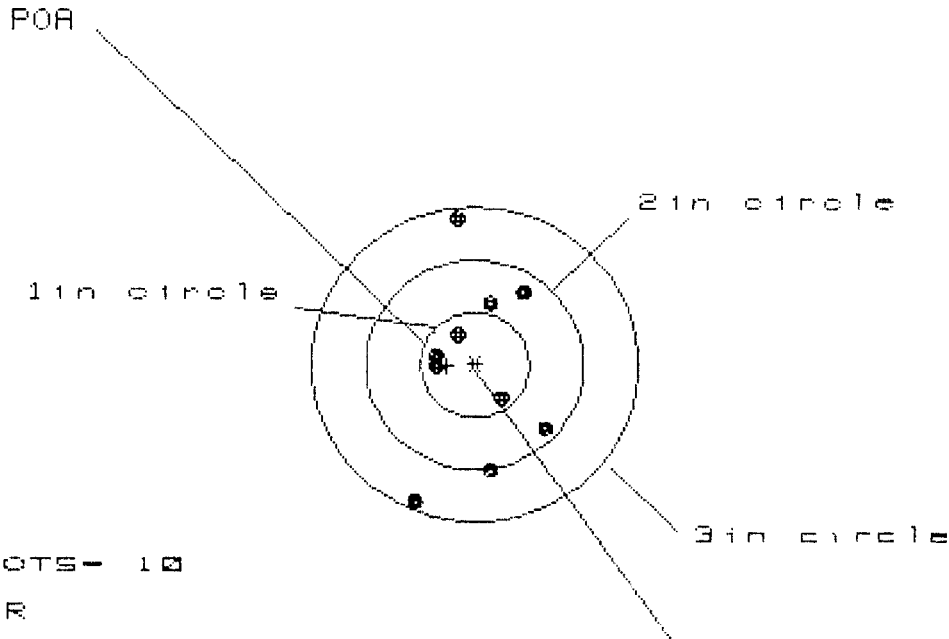
GS = 3.635

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.209	1.055	1.030
MINIMUM X	:	-1.389	-1.219	-1.244
MAXIMUM Y	:	1.809	1.634	1.317
MINIMUM Y	:	-1.568	-1.537	-1.332
CENTROID X	:	-.133	.021	.046
CENTROID Y	:	-.512	-.337	-.542
POA TO CENTROID in.	:	.529	.338	.544
MIN RADIUS	:	.181	.336	.360
MEAN RADIUS	:	1.270	1.152	1.101
MAX RADIUS	:	2.095	1.685	1.570
HORIZONTAL SPREAD	:	2.598	2.274	2.274
VERTICAL SPREAD	:	3.377	3.171	2.649
EXTREME SPREAD	:	3.635	3.251	2.764
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		2	
NUMBER IN THREE INCH CIRCLE	=		7	

21 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6865832.1

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 4

2in = 7

3in = 10

HS- 1.111

VS= 2.638

GS= 2.665

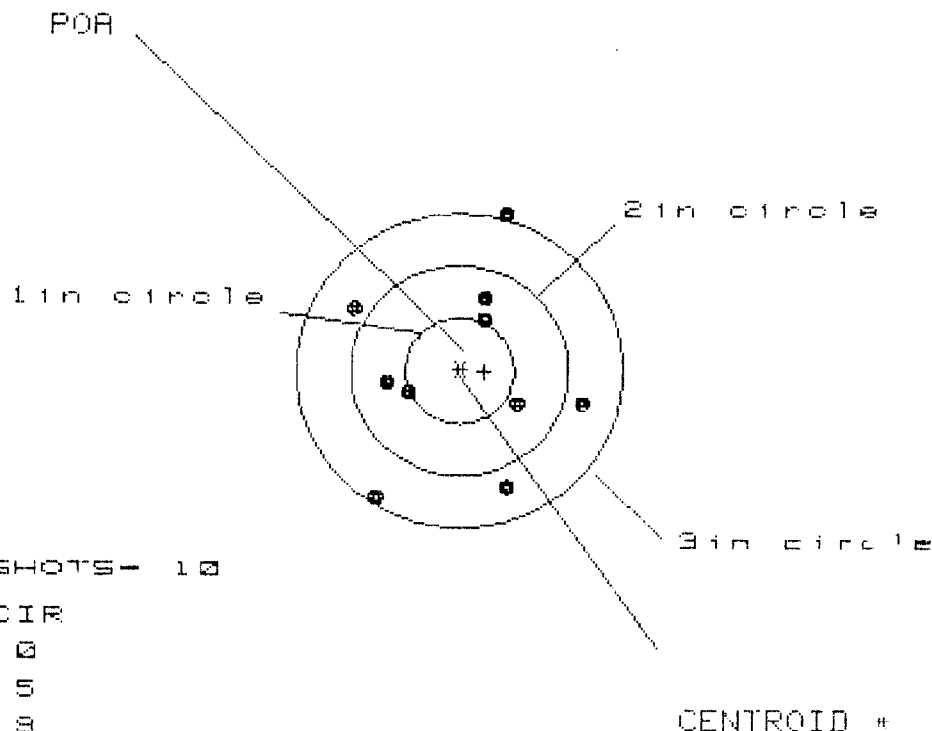
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.593	.577	.511
MINIMUM X	:	-.518	-.534	-.481
MAXIMUM Y	:	1.377	.868	.730
MINIMUM Y	:	-1.261	-1.108	-.998
CENTROID X	:	.257	.273	.339
CENTROID Y	:	.009	-.144	-.006
POA TO CENTROID in.	:	.258	.308	.339
MIN RADIUS	:	.345	.244	.298
MEAN RADIUS	:	.746	.681	.595
MAX RADIUS	:	1.384	1.230	.999
HORIZONTAL SPREAD	:	1.111	1.111	.992
VERTICAL SPREAD	:	2.638	1.976	1.728
EXTREME SPREAD	:	2.665	2.193	1.755
NUMBER IN ONE INCH CIRCLE =			4	
NUMBER IN TWO INCH CIRCLE =			7	
NUMBER IN THREE INCH CIRCLE =			10	

21 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8665832.1

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 0

2in = 5

3in = 9

HS= 2.114

VS= 2.643

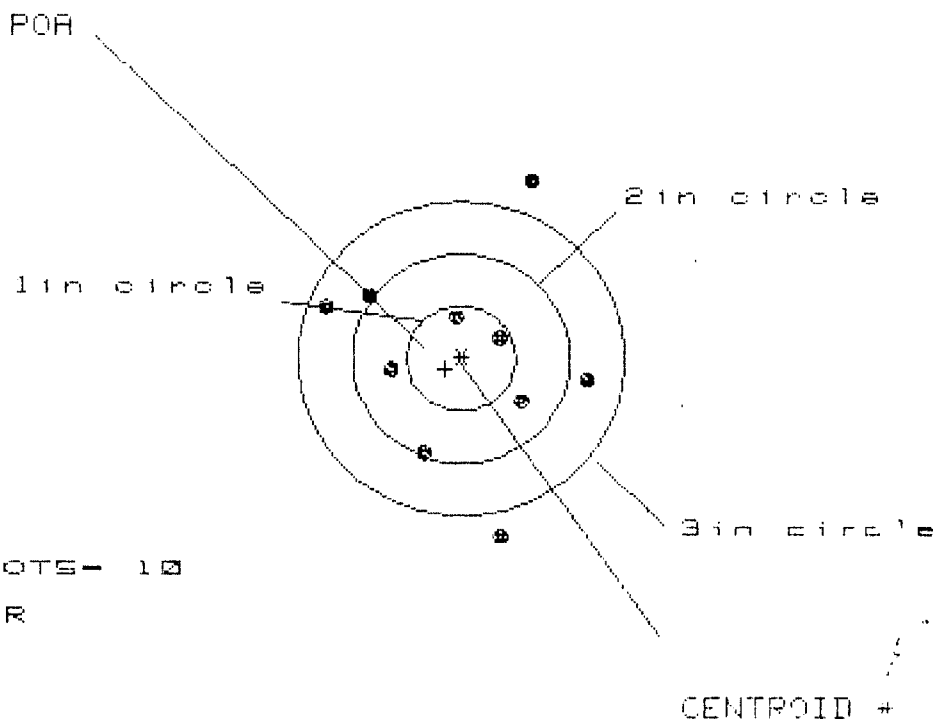
GS= 2.925

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.124	1.174	1.079
MINIMUM X	:	-.990	-.940	-1.035
MAXIMUM Y	:	1.467	.834	.707
MINIMUM Y	:	-1.176	-1.013	-1.079
CENTROID X	:	-.228	-.278	-.183
CENTROID Y	:	.008	-.155	-.028
POA TO CENTROID in.	:	.229	.318	.185
MIN RADIUS	:	.544	.459	.548
MEAN RADIUS	:	.959	.890	.830
MAX RADIUS	:	1.532	1.266	1.212
HORIZONTAL SPREAD	:	2.114	2.114	2.114
VERTICAL SPREAD	:	2.643	1.847	1.786
EXTREME SPREAD	:	2.925	2.318	2.318
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

21 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6665832.1

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 8

HS= 2.403

VS= 3.363

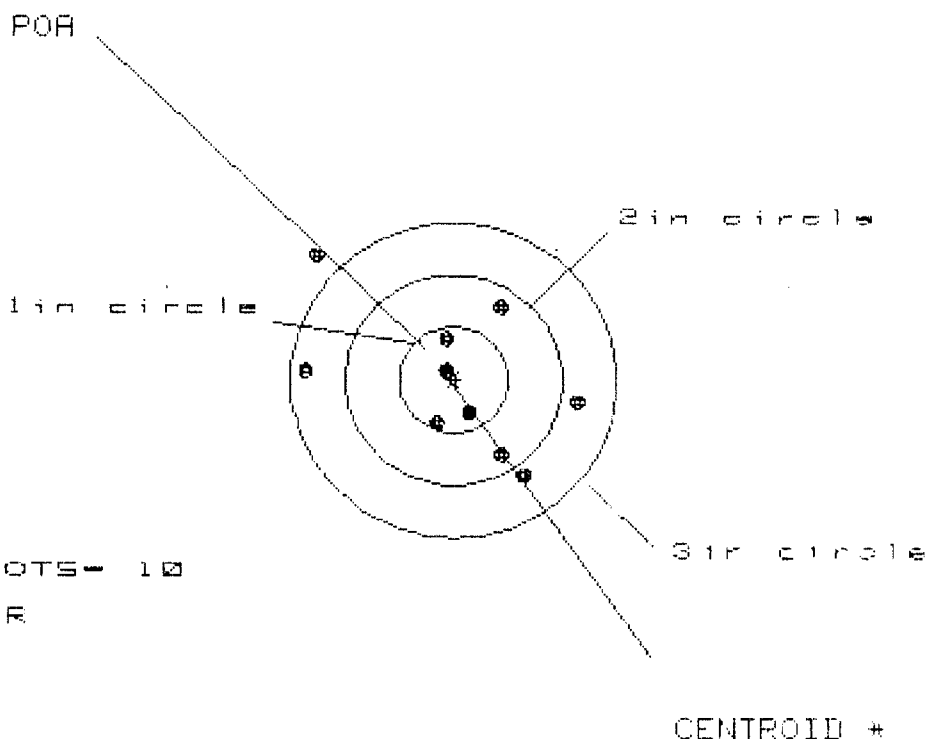
GS= 3.386

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.162	1.239	1.293
MINIMUM X	:	-1.241	-1.164	-1.110
MAXIMUM Y	:	1.663	.776	.586
MINIMUM Y	:	-1.706	-1.522	-.863
CENTROID X	:	.147	.070	.015
CENTROID Y	:	.100	-.084	.106
POA TO CENTROID in.	:	.178	.109	.107
MIN RADIUS	:	.372	.560	.386
MEAN RADIUS	:	1.023	.940	.833
MAX RADIUS	:	1.802	1.582	1.318
HORIZONTAL SPREAD	:	2.403	2.403	2.403
VERTICAL SPREAD	:	3.369	2.298	1.449
EXTREME SPREAD	:	3.386	2.709	2.511
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

21 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6665032.1

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 4

2in = 6

3in = 8

HS= 2.515

VS= 2.079

GS= 2.790

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.178	1.043	.859
MINIMUM X	:	-1.337	-1.472	-.503
MAXIMUM Y	:	1.224	.816	.843
MINIMUM Y	:	-.855	-.719	-.692
CENTROID X	:	.864	.199	.383
CENTROID Y	:	-.895	-.231	-.258
POA TO CENTROID in.	:	.114	.305	.462
MIN RADIUS	:	.132	.203	.253
MEAN RADIUS	:	.844	.729	.638
MAX RADIUS	:	1.727	1.488	.859
HORIZONTAL SPREAD	:	2.515	2.515	1.362
VERTICAL SPREAD	:	2.079	1.535	1.535
EXTREME SPREAD	:	2.790	2.528	1.547
NUMBER IN ONE INCH CIRCLE =	:	4		

NUMBER IN TWO INCH CIRCLE = 6
NUMBER IN THREE INCH CIRCLE = 9

ENDURANCE GUN
4500 RDS

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6665832
6 Nov 1991

CENTROIDAL DISTANCES

0 TO	1	.137906
1 TO	2	.0286007
1 TO	3	.4664
1 TO	4	.266092
1 TO	5	.135765

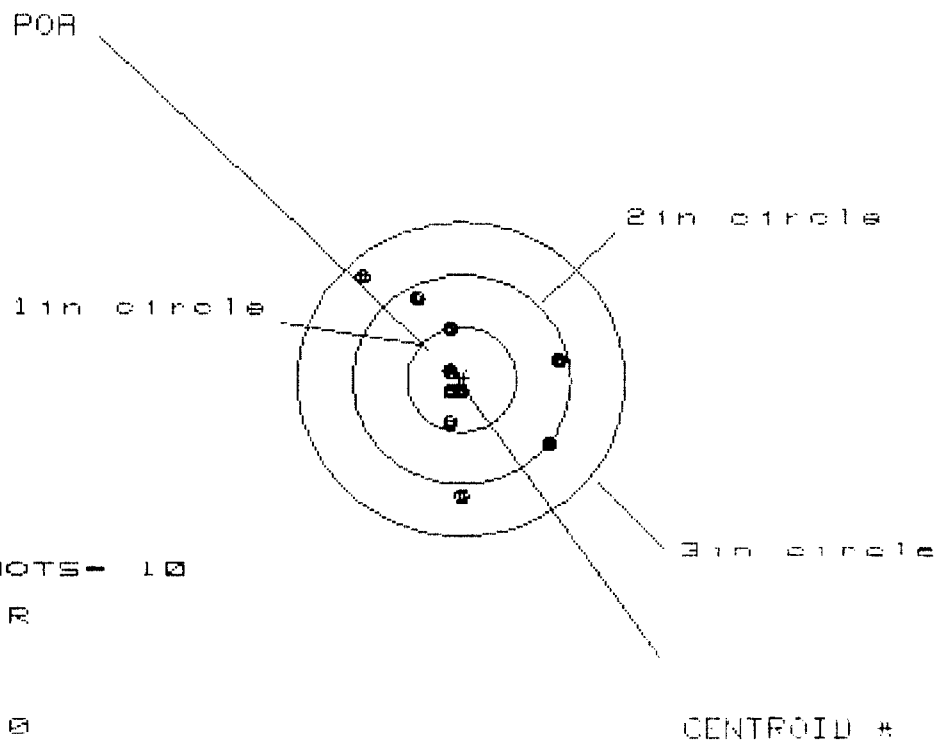
³
76 <----FOR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1486
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0794
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .168481
THE AMR FOR THIS RIFLE IS: .9156

6 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06665832.1.1

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 5

2in = 7

3in = 10

HS= 1.000

VS= 2.100

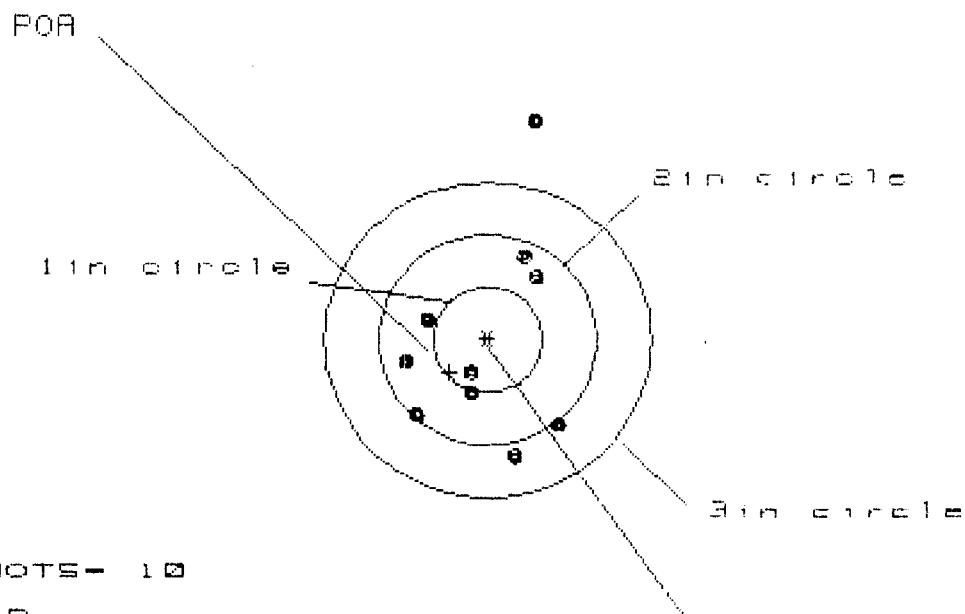
3= 2.292

PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.931	.833	.820
MINIMUM X	:	-.877	-.503	-.516
MAXIMUM Y	:	.952	.850	.720
MINIMUM Y	:	-1.148	-1.042	-.634
CENTROID X	:	.107	.205	.218
CENTROID Y	:	-.087	-.193	-.062
POA TO CENTROID in.	:	.138	.281	.227
MIN RADIUS	:	.111	.067	.154
MEAN RADIUS	:	.653	.588	.534
MAX RADIUS	:	1.294	1.048	.937
HORIZONTAL SPREAD	:	1.808	1.336	1.306
VERTICAL SPREAD	:	2.100	1.892	1.354
EXTREME SPREAD	:	2.292	1.933	1.813
NUMBER IN ONE INCH CIRCLE =	:	5		
NUMBER IN TWO INCH CIRCLE =	:	7		
NUMBER IN THREE INCH CIRCLE =	:	10		

6 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6665832.1.1

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 7

3 in = 9

HS= 1.368

VS= 3.174

GS= 3.180

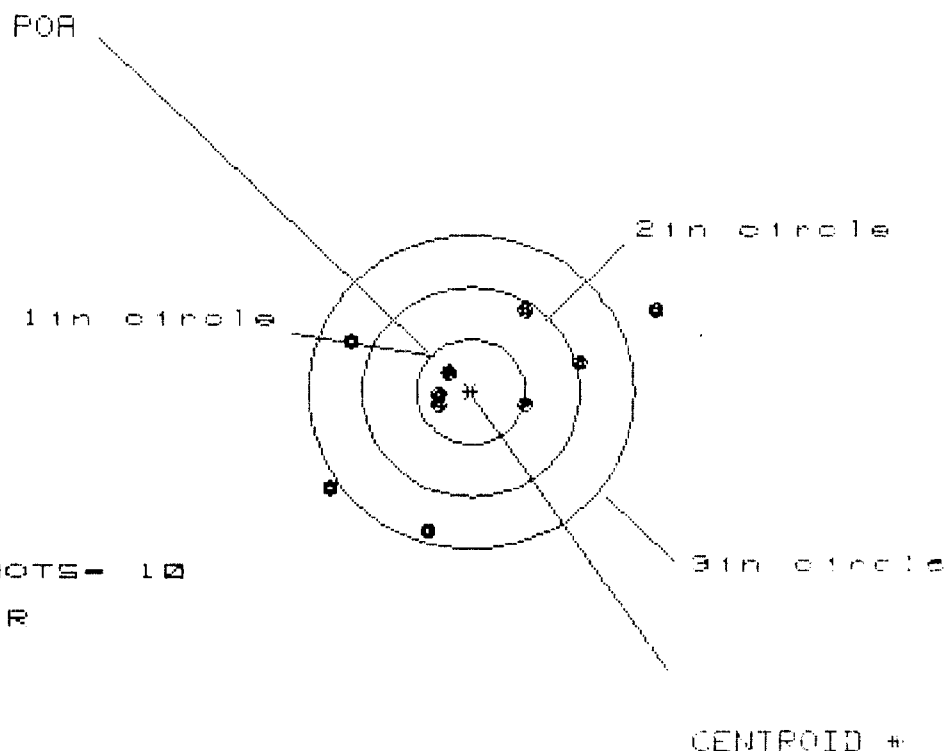
CENTROID +

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.626	.677	.715
MINIMUM X	:	-.742	-.691	-.653
MAXIMUM Y	:	2.050	1.015	.903
MINIMUM Y	:	-1.124	-.896	-.715
CENTROID X	:	.355	.304	.266
CENTROID Y	:	.308	.080	.192
POA TO CENTROID in.	:	.469	.315	.328
MIN RADIUS	:	.298	.084	.159
MEAN RADIUS	:	.910	.719	.696
MAX RADIUS	:	2.100	1.098	1.012
HORIZONTAL SPREAD	:	1.368	1.368	1.368
VERTICAL SPREAD	:	3.174	1.911	1.618
EXTREME SPREAD	:	3.180	1.914	1.783
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

6 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6665832.1.1

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 3

2in = 5

3in = 8

HS= 2.972

VS= 2.155

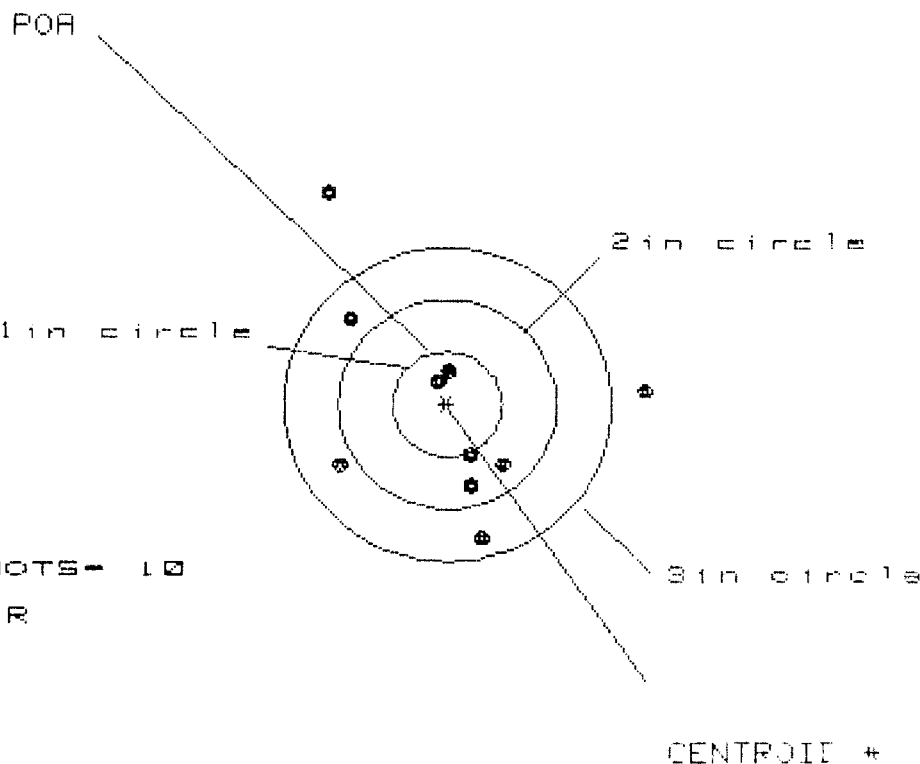
GS= 3.407

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.659	1.167	1.026
MINIMUM X	:	-1.313	-1.128	-1.101
MAXIMUM Y	:	.803	.887	.783
MINIMUM Y	:	-1.352	-1.268	-1.371
CENTROID X	:	.203	.018	.159
CENTROID Y	:	-.183	-.267	-.163
POA TO CENTROID in.	:	.273	.267	.228
MIN RADIUS	:	.260	.135	.214
MEAN RADIUS	:	.939	.813	.737
MAX RADIUS	:	1.823	1.398	1.409
HORIZONTAL SPREAD	:	2.972	2.295	2.127
VERTICAL SPREAD	:	2.155	2.155	2.155
EXTREME SPREAD	:	3.407	2.576	2.306
NUMBER IN ONE INCH CIRCLE =			3	
NUMBER IN TWO INCH CIRCLE =			5	
NUMBER IN THREE INCH CIRCLE =			8	

6 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6665832.1.1

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 8

HS= 2.860

VS= 3.318

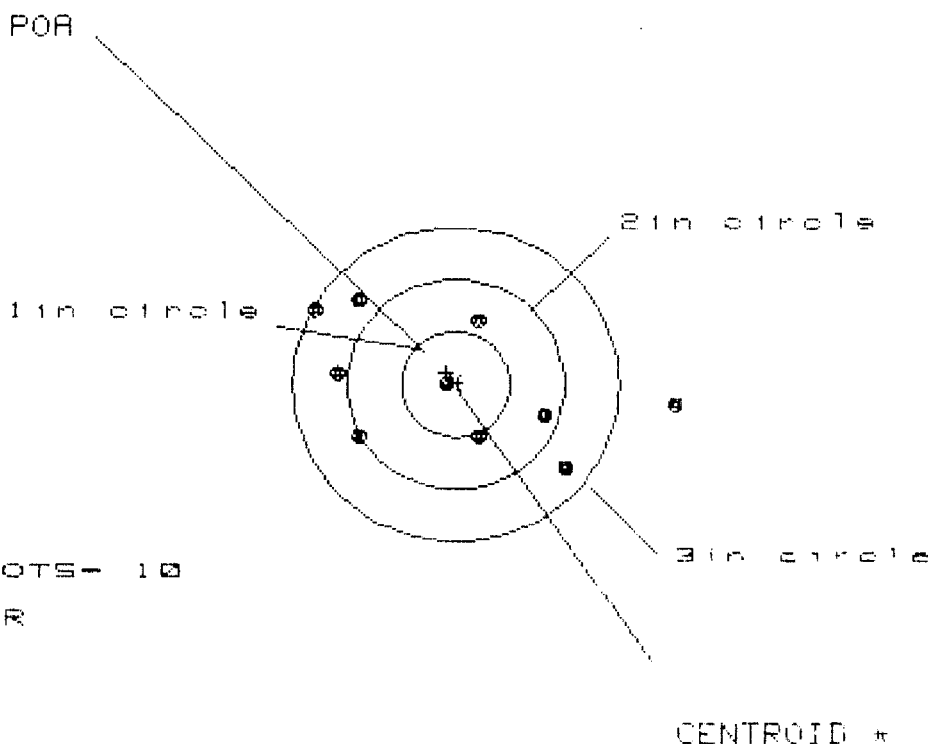
GS= 3.597

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.797	1.679	.588
MINIMUM X	:	-1.063	-1.122	-.912
MAXIMUM Y	:	2.066	1.089	1.134
MINIMUM Y	:	-1.252	-1.022	-.977
CENTROID X	:	-.012	.106	-.104
CENTROID Y	:	-.325	-.555	-.600
POA TO CENTROID in.	:	.325	.565	.609
MIN RADIUS	:	.242	.288	.367
MEAN RADIUS	:	1.041	.863	.759
MAX RADIUS	:	2.323	1.718	1.380
HORIZONTAL SPREAD	:	2.860	2.801	1.500
VERTICAL SPREAD	:	3.318	2.111	2.111
EXTREME SPREAD	:	3.597	2.884	2.430
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

6 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8665832.1.1

CENTERFIRE PATTERNS # 2



OF SHOTS - 10

IN CIR

1in = 1

2in = 4

3in = 9

HS = 3.319

VS = 1.660

GS = 3.438

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.059	1.261	1.132
MINIMUM X	:	-1.260	-1.032	-1.028
MAXIMUM Y	:	.822	.803	.891
MINIMUM Y	:	-.838	-.857	-.769
CENTROID X	:	.090	-.138	-.009
CENTROID Y	:	-.110	-.091	-.179
POA TO CENTROID in.	:	.143	.166	.190
MIN RADIUS	:	.098	.144	.114
MEAN RADIUS	:	1.035	.910	.853
MAX RADIUS	:	2.066	1.525	1.369
HORIZONTAL SPREAD	:	3.319	2.293	2.160
VERTICAL SPREAD	:	1.660	1.660	1.660
EXTREME SPREAD	:	3.438	2.775	2.540
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		9	

ENDURANCE

5000 R.DS

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6665832
8 Nov 1991

CENTROIDAL DISTANCES

0 TO 1	.172247
1 TO 2	.198849
1 TO 3	.224207
1 TO 4	.676563
1 TO 5	.264462

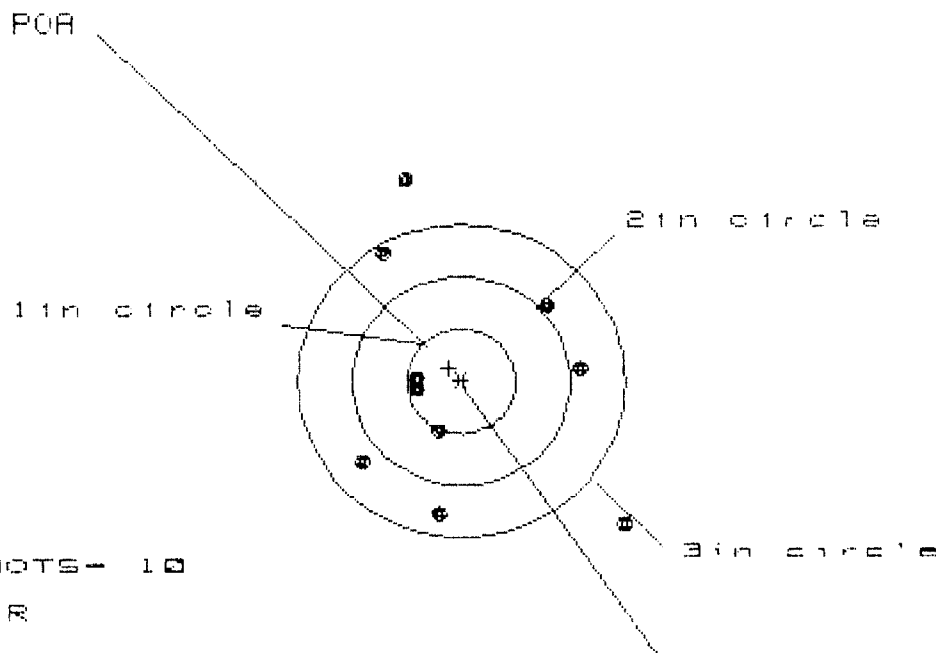
4 9 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0982
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0572
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .113645
THE AMR FOR THIS RIFLE IS: .9292

8 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6665832.1.1.1

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 2

2in = 3

3in = 8

HS= 2.410

VS= 3.334

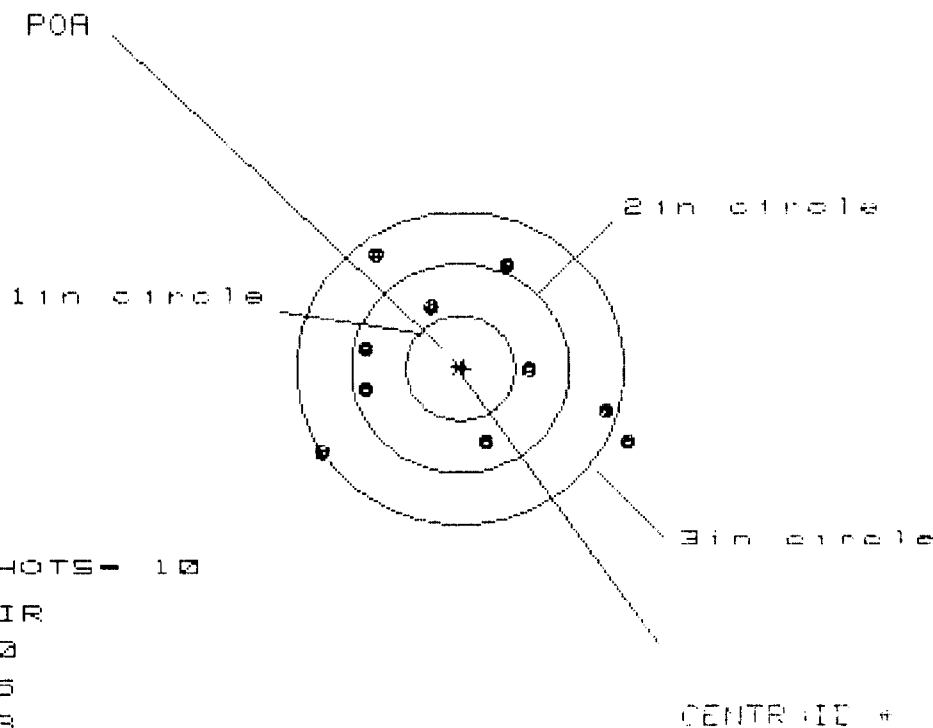
GS= 3.858

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.456	1.234	1.194
MINIMUM X	-.954	-.792	-.832
MAXIMUM Y	1.939	1.784	1.264
MINIMUM Y	-1.395	-1.437	-1.214
CENTROID X	.113	-.049	-.009
CENTROID Y	-.130	.025	-.198
POA TO CENTROID in.	.172	.055	.198
MIN RADIUS	.412	.266	.285
MEAN RADIUS	1.145	1.029	.896
MAX RADIUS	2.017	1.813	1.387
HORIZONTAL SPREAD	2.410	2.026	2.026
VERTICAL SPREAD	3.334	3.221	2.478
EXTREME SPREAD	3.858	3.231	2.521
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	3		
NUMBER IN THREE INCH CIRCLE =	8		

8 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8865832.1.1.1

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 0

2in = 5

3in = 8

HS= 2.837

VS= 1.889

GS= 2.943

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	9
MAXIMUM X	:	1.521	1.487	1.343
MINIMUM X	:	-1.316	-1.147	-.872
MAXIMUM Y	:	1.071	.989	.876
MINIMUM Y	:	-.818	-.980	-.864
CENTROID X	:	-.033	-.202	-.058
CENTROID Y	:	.005	.087	.200
POA TO CENTROID in.	:	.033	.220	.208
MIN RADIUS	:	.611	.486	.424
MEAN RADIUS	:	1.069	.978	.908
MAX RADIUS	:	1.693	1.551	1.454
HORIZONTAL SPREAD	:	2.837	2.634	2.215
VERTICAL SPREAD	:	1.889	1.889	1.740
EXTREME SPREAD	:	2.943	2.673	2.553
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

8 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6665832.1.1.1

CENTERFIRE PATTERNS # 3

POA

1 in circle

2 in circle

3 in circle

CENTROID #

OF SHOTS- 10

IN CIR

1 in = 6

2 in = 8

3 in = 10

HS= 2.296

VS= 1.751

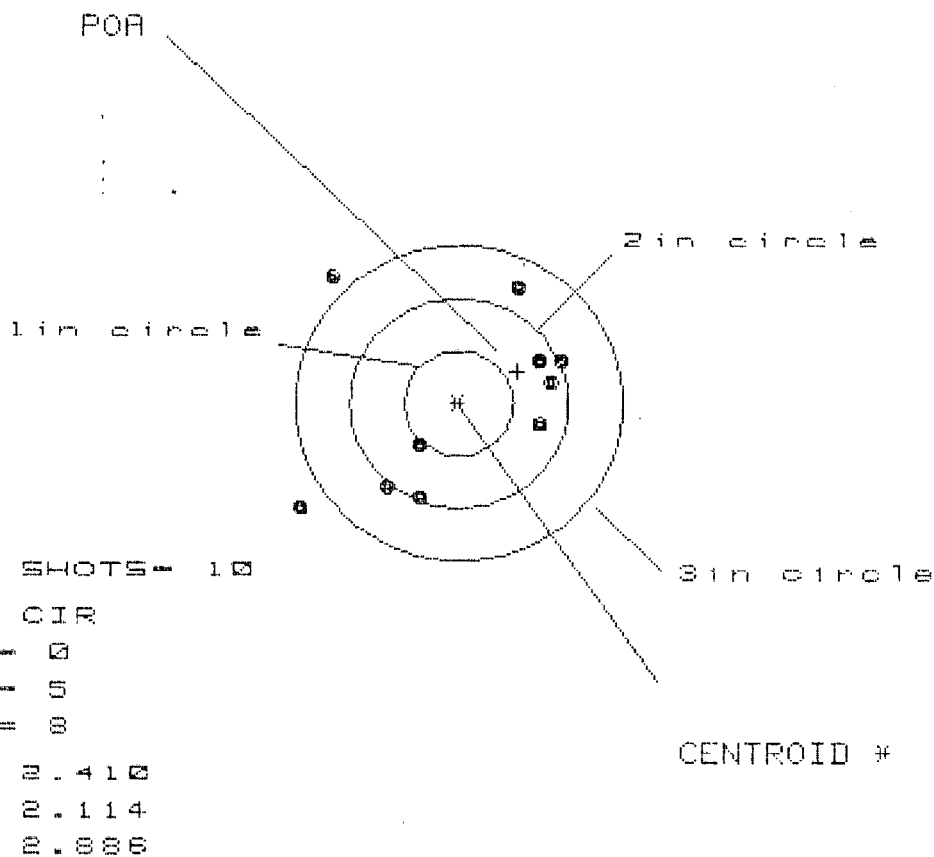
GS= 2.399

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.474	.471	.414
MINIMUM X	:	-.822	-.658	-.715
MAXIMUM Y	:	.866	.884	.469
MINIMUM Y	:	-.885	-.867	-.756
CENTROID X	:	-.842	-.286	-.149
CENTROID Y	:	.032	.014	-.097
POA TO CENTROID in.	:	.053	.207	.178
MIN RADIUS	:	.200	.187	.166
MEAN RADIUS	:	.623	.537	.475
MAX RADIUS	:	1.484	.996	.820
HORIZONTAL SPREAD	:	2.296	1.129	1.129
VERTICAL SPREAD	:	1.751	1.751	1.225
EXTREME SPREAD	:	2.399	1.780	1.257
NUMBER IN ONE INCH CIRCLE =			6	
NUMBER IN TWO INCH CIRCLE =			8	
NUMBER IN THREE INCH CIRCLE =			10	

8 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6865832.1.1.1

CENTERFIRE PATTERNS # 4

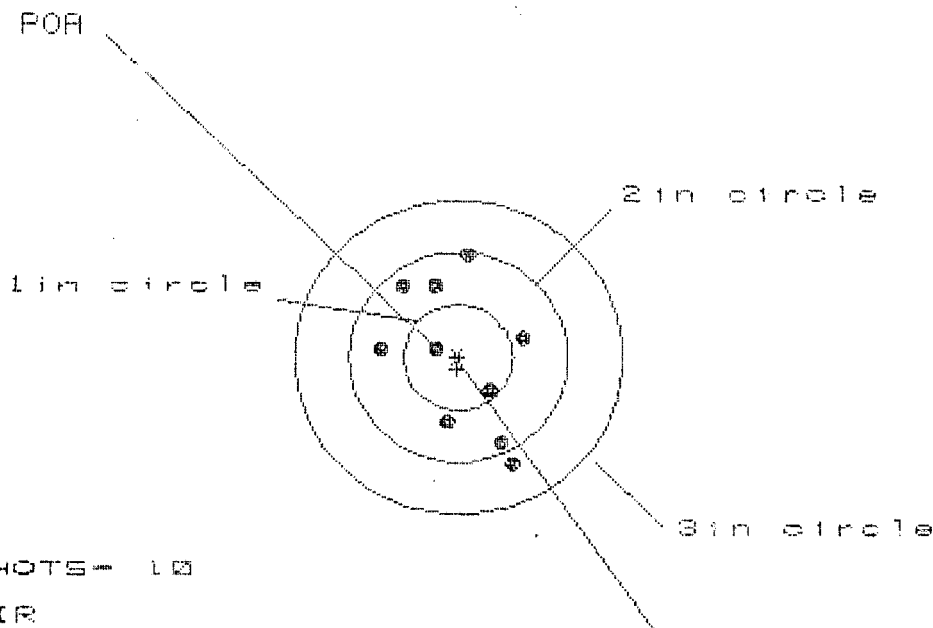


PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.954	.792	.630
MINIMUM X	:	-1.456	-1.296	-.967
MAXIMUM Y	:	1.161	1.055	1.114
MINIMUM Y	:	-.953	-.950	-.818
CENTROID X	:	-.540	-.378	-.216
CENTROID Y	:	-.307	-.201	-.333
POA TO CENTROID in.	:	.621	.429	.397
MIN RADIUS	:	.590	.663	.460
MEAN RADIUS	:	1.073	.971	.840
MAX RADIUS	:	1.740	1.671	1.253
HORIZONTAL SPREAD	:	2.410	2.088	1.598
VERTICAL SPREAD	:	2.114	2.005	1.932
EXTREME SPREAD	:	2.886	2.325	2.271
NUMBER IN ONE INCH CIRCLE =			0	
NUMBER IN TWO INCH CIRCLE =			5	
NUMBER IN THREE INCH CIRCLE =			8	

8 Nov 1931

FILE:/PATTERNING/CENTERFIRE_PATT/C8865832.1.1.1

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 2

2in = 8

3in = 10

HS= 1.385

VS= 2.081

GS= 2.135

CENTROID #

PATTERN #	5	9	3
SHOTS (BEST OF)	10	9	3
MAXIMUM X	.625	.683	.696
MINIMUM X	-.760	-.702	-.690
MAXIMUM Y	1.033	.916	.722
MINIMUM Y	-1.048	-.958	-.843
CENTROID X	.011	-.047	-.060
CENTROID Y	.114	.231	.116
POA TO CENTROID in.	.115	.235	.130
MIN RADIUS	.203	.147	.137
MEAN RADIUS	.736	.679	.632
MAX RADIUS	1.170	1.051	.954
HORIZONTAL SPREAD	1.385	1.385	1.385
VERTICAL SPREAD	2.081	1.874	1.565
EXTREME SPREAD	2.135	1.984	1.820
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	8		
NUMBER IN THREE INCH CIRCLE =	10		

SWS ENDURANCE TEST REPORT

SERIAL NO. C6665832 SHOOTER _____ DATE 10-21-91

AMMO CODE	AMMO TYPE	RDS.	RESULTS	OBSERVATIONS
10-21-91	7.62	60	OK	NONE TARGET & ACC.
10/21/91	7.62	240	OK	NONE TEST
		300	TOTAL 10/21	
360 10-21-91	7.62	60		NONE TEST
420 10-21-91	7.62	60		NONE TEST
440 10-21-91	7.62	20		NONE TEST
		440	TOTAL KB 10-21	
10/21/91	7.62	60	TXT K.T.	
10/22/91	7.62	60	OK RQ	none
	7.62	40	OK RQ	none
		600	TOTAL RQ	
10/22/91	7.62	60	OK	None
	7.62	60	OK	None
	7.62	60	OK	None
	7.62	60	OK	None
	7.62	60	OK	None
	7.62	60	OK	None
	7.62	60	OK	None
	7.62	20	OK	None
		1040	End 2 nd shift	10/22/91 K.O.

SWS ENDURANCE TEST REPORT

SERIAL NO. C-665532 SHOOTER _____ DATE 10-23-91

AMMO CODE	AMMO TYPE	RDS.	RESULTS	OBSERVATIONS
<u>10/23-91</u>	<u>7.62</u>	<u>1040</u>	<u>OK</u>	<u>NONE</u>
	<u>7.62</u>	<u>60</u>	<u>OK</u>	<u>NONE</u>
	<u>7.62</u>	<u>60</u>	<u>OK</u>	<u>NONE</u>
	<u>7.62</u>	<u>60</u>	<u>OK</u>	<u>NONE</u>
	<u>7.62</u>	<u>60</u>	<u>OK</u>	<u>NONE</u>
	<u>7.62</u>	<u>60</u>	<u>OK</u>	<u>NONE</u>
	<u>7.62</u>	<u>60</u>	<u>OK</u>	<u>NONE</u>
	<u>7.62</u>	<u>60</u>	<u>OK</u>	<u>NONE</u>
	<u>7.62</u>	<u>40</u>	<u>OK</u>	<u>NONE</u>
<u>10-23-91</u>		<u>1500</u>		
<u>10-24-91</u>	<u>7.62</u>	<u>30</u>	<u>OK</u>	<u>NONE</u> <u>P.C.</u>
	<u>7.62</u>	<u>30</u>	<u>OK</u>	<u>NONE</u>
	<u>7.62</u>	<u>30</u>	<u>OK</u>	<u>NONE</u>
	<u>7.62</u>	<u>30</u>	<u>OK</u>	<u>NONE</u>
		<u>1620</u>	<u>TOTAL</u> <u>P.C.</u>	
<u>10/24</u>	<u>7.62</u>	<u>60</u>	<u>OK</u>	<u>NONE</u>
	<u>7.62</u>	<u>60</u>	<u>OK</u>	<u>NONE</u>
	<u>7.62</u>	<u>60</u>	<u>OK</u>	<u>NONE</u>
	<u>7.62</u>	<u>60</u>	<u>OK</u>	<u>NONE</u>
	<u>7.62</u>	<u>60</u>	<u>OK</u>	<u>NONE</u>
	<u>7.62</u>	<u>60</u>	<u>OK</u>	<u>NONE</u>
	<u>7.62</u>	<u>60</u>	<u>OK</u>	<u>NONE</u>
	<u>7.62</u>	<u>40</u>	<u>OK</u>	<u>NONE</u>
		<u>2080</u>	<u>TOTAL</u> <u>RB</u>	

M2400089658

SWS ENDURANCE TEST REPORT

SERIAL NO. C6665832 SHOOTER TF DATE 10-30-91

AMMO CODE	AMMO TYPE	RDS.	RESULTS	OBSERVATIONS
10-30-91	7-62	60	OK	NONE
"	"	60	"	"
"	"	60	"	"
"	"	60	"	"
"	"	60	"	"
"	"	60	"	"
		360		
		+ 2500		
		2860	Total	
10-31-91	7-62	60	OK	None GAS
"	"	60	OK	None "
"	"	60	OK	None "
"	"	60	OK	None "
"	"	60	OK	None "
"	"	40	OK	None "
		3200		
4/1	7-62	60	OK	None
11/1	7-62	60	"	"
"	7-62	60	"	"
"	7-62	40	"	"
		3420		

SWS ENDURANCE TEST REPORT

SERIAL NO. C 6665832 SHOOTER W7 DATE 11-4-91

AMMO CODE	AMMO TYPE	RDS.	RESULTS	OBSERVATIONS
11-4-91	7.62	60	OK	None
"	"	60	OK	"
"	"	60	OK	"
"	"	60	OK	"
"	"	60	OK	"
"	"	60	OK	"
"	"	60	OK	"
"	"	20	OK	"
		440 3860		
11-5	7.62	60	O.K.	none
"	"	60	O.K.	"
"	"	60	O.K.	"
"	"	60	O.K.	"
		240		
		3860		
		4100		
		60 RRE	OK	NONE
		60	OK	"
		60	OK	"
		60	OK	"
		60	OK	"
		4400		

SWS ENDURANCE TEST REPORT

SERIAL NO. C 666 5832 SHOOTER _____ DATE 11-6-91

4460
4500 :

AMMO CODE	AMMO TYPE	RDS.	RESULTS	OBSERVATIONS
11-6-91	7.62	60	OK	NONE TEST
	7.62	40	OK	NONE TEST
		4500	TOTAL KB	
4560	7.62	60	OK 11/6/91	NO
4620	11-7 7.62	60	OK	NONE TEST PC
4680	7.62	60	OK	NONE TEST
4740	7.62	60	OK	NONE TEST
4800	7.62	60	OK	NONE TEST
4860	7.62	60	OK	NONE TEST
4920	7.62	60	OK	NONE TEST
4940	7.62	20	OK	NONE TEST
		4940	TOTAL PC	
11-8-91		60	OK Target	NONE AC
11-8-91		5000		
		60	OK RHE	
		60	"	
		60	"	
		60	"	
		60	"	
		60	"	
		5360		

SWS ENDURANCE TEST REPORT

SERIAL NO. C6665832 SHOOTER BAILEY DATE 11/12/91

AMMO CODE	AMMO TYPE	RDS.	RESULTS	OBSERVATIONS
<u>2091B-</u>				
<u>193-002</u>	<u>7.62</u>	<u>60</u>	<u>OK</u>	<u>NONE</u>
	<u>7.62</u>	<u>60</u>	<u>OK</u>	<u>NONE</u>
	<u>7.62</u>	<u>60</u>	<u>OK</u>	<u>NONE</u>
	<u>7.62</u>	<u>60</u>	<u>OK</u>	<u>NONE</u>
	<u>7.62</u>	<u>60</u>	<u>OK</u>	<u>NONE</u>
	<u>7.62</u>	<u>60</u>	<u>OK</u>	<u>NONE</u>
	<u>7.62</u>	<u>60</u>	<u>OK</u>	<u>NONE</u>
	<u>7.62</u>	<u>60</u>	<u>OK</u>	<u>NONE</u>
		<u>5840</u>	<u>TOTAL R.B.</u>	
	<u>7.62</u>	<u>60</u>	<u>OK</u>	<u>none</u>
	<u>"</u>	<u>60</u>	<u>OK</u>	<u>none</u>
	<u>"</u>	<u>40</u>	<u>OK</u>	<u>none</u>
		<u>6000</u>		
	<u>"</u>	<u>60</u>	<u>OK</u>	<u>none</u>
	<u>"</u>	<u>60</u>	<u>OK</u>	<u>none</u>
	<u>"</u>	<u>60</u>	<u>OK</u>	<u>none</u>
	<u>"</u>	<u>60</u>	<u>OK</u>	<u>none</u>
	<u>"</u>	<u>60</u>	<u>OK</u>	<u>none</u>
	<u>"</u>	<u>60</u>	<u>OK</u>	<u>none</u>
	<u>"</u>	<u>60</u>	<u>OK</u>	<u>none</u>
		<u>6420</u>	<u>TOTAL RD</u>	

11/13

SWS ENDURANCE TEST REPORT

SERIAL NO. C6665832 SHOOTER WHITE DATE 11/14/91

AMMO CODE	AMMO TYPE	RDS.	RESULTS	OBSERVATIONS
	7.62	⁶⁴²⁰ 100	OK	NONE
	7.62	100	OK	NONE
	7.62	100	OK	NONE
	7.62	100	OK	NONE
	7.62	100	OK	NONE
	7.62	100	OK	NONE
	7.62	100	OK	NONE
		7220	TOTAL RW	
7280 11-14-91	7.62	60	OK	NONE
7340	7.62	60	OK	NONE
7400	7.62	60	OK	NONE
7460	7.62	60	OK	NONE
7500	7.62	40	OK	NONE
		7500	TOTAL RB	
	7.62	100	OK	NONE
	7.62	100	OK	NONE
	7.62	100	OK	NONE
	7.62	100	OK	NONE
	7.62	100	OK	NONE
		8000	TOTAL RW 11/14/91	

SWS ENDURANCE TEST REPORT

SERIAL NO. C6665832 SHOOTER EASTWOOD DATE 11-20-91

AMMO CODE	AMMO TYPE	RDS.	RESULTS	OBSERVATIONS
	762	8,000		
		100		
		100		
		100		
		100		
		100		
		100		
		8600	RKE 11-20-91	
		100		
		100		
		100		
		100		
		100		
		100		
		9200	RKE 11-21-91	
		100		
		100		
		100		
		100		
		100		
		100		
		100		
		10,000	RKE 11-25-91	