

*INCLUDES 1 IN CHAMBER

C6702846

UPC



0 47700 25716 7

5716

ORDER NO.

BARREL LENGTH

CAPACITY*

GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6702846

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		5/1/92	RW
600	Proof		5/1/92	RW
607	Check Headspace		5/1/92	RW
610	Dis-assemble Gun		5/1/92	RW
612	Magnaflux Barrel Action	MAY	5 1992	KCR
	Magnaflux Bolt	MAY	5 1992	KCR
615	Rollmark Caliber	MAY	5 1992	GS
617	Drill and Tap Sight Holes	MAY	5	FB
618	Polish Barrel	MAY	5	WB
620	Apply Coatings (Barrel Action)		6-10-92	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		6/13/92	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		6/13/92	RW
	C) Inspect Ejector Hole for Chamfer		6/13/92	RW
	D) Oil Firing Pin Ass'y		6/13/92	RW
	E) Adjust Trigger Pull to Min Setting and Stake		6/15/92	RW

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	3	3.5	4			6/15/92	RW
	G) Safety Off Force	2.5	2.5	2.5			6/15/92	RW
	H) Trigger Pull Test & Retainability						6/15/92	RW
	I) Firing Pin Indent	.023	.0215	.0215			6/15/92	RW
	J) Assemble Stock						6/16/92	RW
	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						6/16/92	RW
	P) Detach & Attach Scope 20 Times						6/16/92	RW
640	Gallery Target & Test						6-24-92	DH
	A) Time						6-24-92	DH
	B) Malfunctions						6-24-92	DH
	C) Pierced Primers						6-24-92	DH
	D) Optical Clarity of Scope						6-24-92	DH
645	Inspect for Live Ammo						6-24-92	DH
655	Final Inspection							
	A) Headspace						6/24/92	RW
	B) Trigger Pull	2.57	2.35	2.39	2.47	2.35	6/24/92	RW
	C) Function						6/24/92	RW
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. C6202846
DATE 6/15/92
TESTER Rw

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.32	2.15	2.57	2.57	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.31	2.18	2.63	2.35	
PULL #3	2.38	2.15	2.54	2.39	
PULL #4	2.41	2.44	2.61	2.47	
PULL #5	2.22	2.35	2.49	2.35	
TOTAL	11.64	11.47	12.84	12.13	
AVG.	2.33	2.29	2.57	2.43	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.11	3.09		
PULL #2	3.33	3.00		
PULL #3	3.31	3.00		
PULL #4	3.06	3.04		
PULL #5	3.24	3.06		
TOTAL	16.05	15.19		
AVG.	3.21	3.04		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.17	4.19		4.04
PULL #2	4.11	4.18		4.19
PULL #3	4.12	4.14		4.08
PULL #4	4.17	4.17		4.08
PULL #5	4.14	4.12		4.05
TOTAL	20.71	20.80		
AVG.	4.14	4.16		

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6702846
25 Jun 1992

CENTROIDAL DISTANCES

0 TO	1	.140089
1 TO	2	.341658
1 TO	3	.108116
1 TO	4	.746497
1 TO	5	.24056

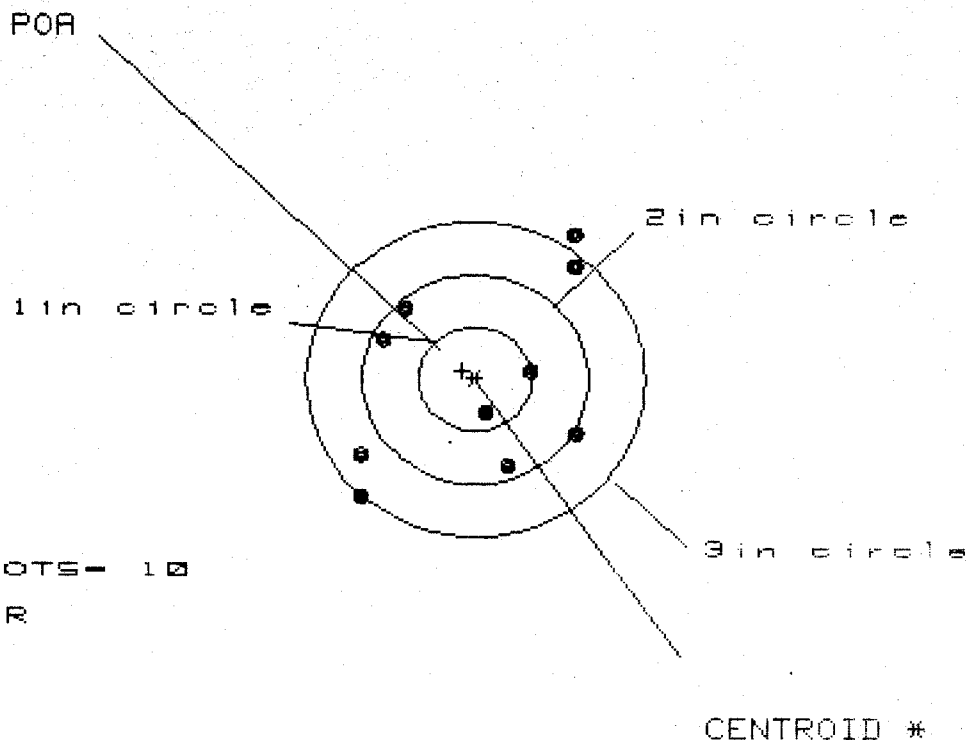
2 <----POA
4

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .2164
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1482
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .262283
THE AMR FOR THIS RIFLE IS: 1.075

24 Jun 1992

FILE:/PATTERNING/CENTERFIRE_PATT/C8702846

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 5

3 in = 8

HS= 1.943

VS= 2.472

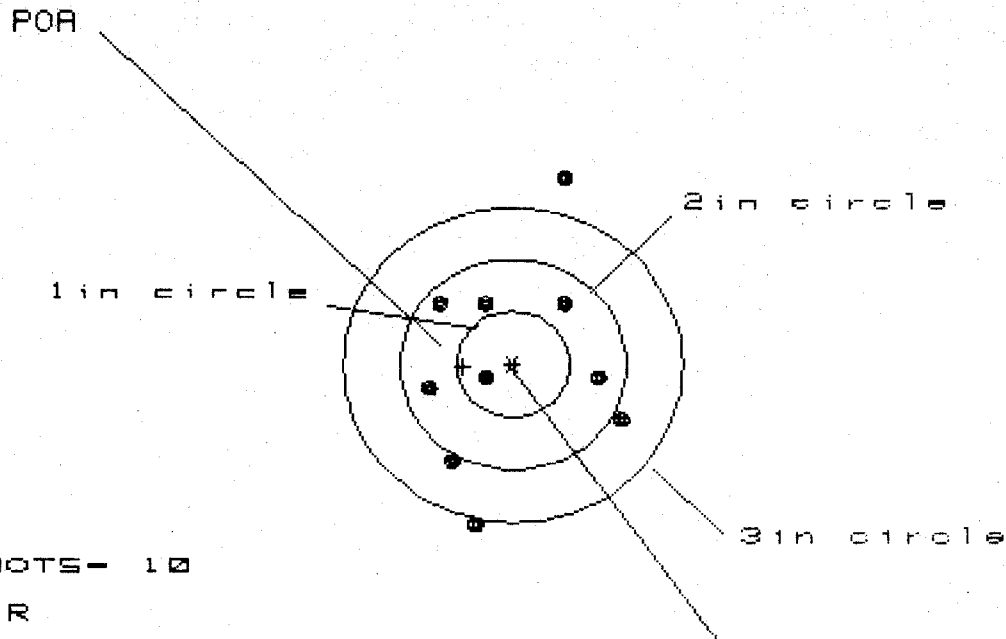
GS= 3.117

PATTERN #	1	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.897	.992	.873
MINIMUM X	-1.046	-.951	-1.010
MAXIMUM Y	1.377	1.186	1.069
MINIMUM Y	-1.095	-.943	-.824
CENTROID X	.115	.020	.139
CENTROID Y	-.080	-.233	-.116
POA TO CENTROID in.	.140	.234	.181
MIN RADIUS	.364	.259	.326
MEAN RADIUS	1.041	.959	.904
MAX RADIUS	1.620	1.547	1.380
HORIZONTAL SPREAD	1.943	1.943	1.883
VERTICAL SPREAD	2.472	2.129	1.893
EXTREME SPREAD	3.117	2.882	2.593
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	8		

24 Jun 1992

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in - 1

2 in - 6

3 in - 8

HS- 1.775

VS- 3.277

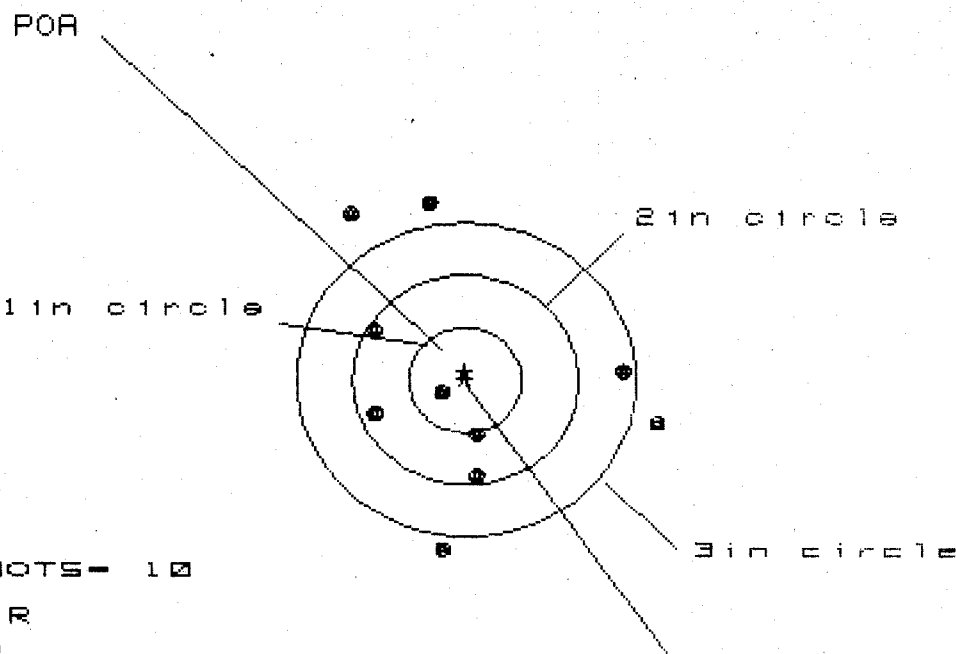
GS- 3.379

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.001	1.054	1.016
MINIMUM X	:	-.774	-.721	-.759
MAXIMUM Y	:	1.780	.794	.632
MINIMUM Y	:	-1.497	-1.300	-.925
CENTROID X	:	.442	.389	.427
CENTROID Y	:	.019	-.178	-.016
POA TO CENTROID in.	:	.443	.428	.427
MIN RADIUS	:	.231	.181	.203
MEAN RADIUS	:	.971	.867	.791
MAX RADIUS	:	1.842	1.333	1.140
HORIZONTAL SPREAD	:	1.775	1.775	1.775
VERTICAL SPREAD	:	3.277	2.094	1.557
EXTREME SPREAD	:	3.379	2.255	1.992
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	6		
NUMBER IN THREE INCH CIRCLE	=	8		

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 6

HS= 2.653

VS= 3.328

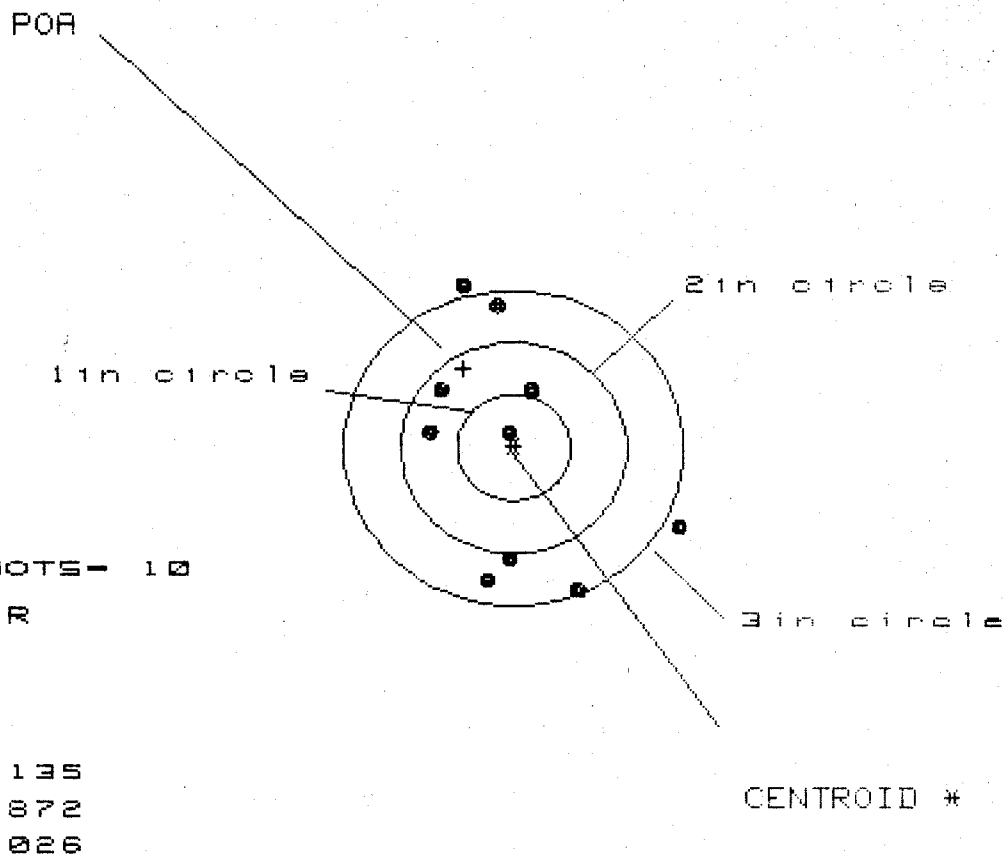
GS= 3.342

PATTERN #	:			
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.655	1.544	1.496
MINIMUM X	:	-.998	-.965	-1.013
MAXIMUM Y	:	1.694	1.873	.931
MINIMUM Y	:	-1.634	-1.455	-1.221
CENTROID X	:	.007	.118	.166
CENTROID Y	:	-.085	-.264	-.498
POA TO CENTROID in.	:	.086	.289	.525
MIN RADIUS	:	.227	.283	.105
MEAN RADIUS	:	1.191	1.086	.943
MAX RADIUS	:	1.890	1.911	1.497
HORIZONTAL SPREAD	:	2.653	2.509	2.509
VERTICAL SPREAD	:	3.328	3.328	2.152
EXTREME SPREAD	:	3.342	3.329	2.606
NUMBER IN ONE INCH CIRCLE =			2	
NUMBER IN TWO INCH CIRCLE =			5	
NUMBER IN THREE INCH CIRCLE =			6	

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CENTERFIRE PATTERNS # 4



OF SHOTS - 10

IN CIR

1in = 1

2in = 4

3in = 8

HS = 2.135

VS = 2.872

GS = 3.026

PATTERN #	:			
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.437	1.390	.656
MINIMUM X	:	-.698	-.745	-.571
MAXIMUM Y	:	1.572	1.547	1.476
MINIMUM Y	:	-1.300	-1.126	-1.197
CENTROID X	:	.438	.485	.311
CENTROID Y	:	-.753	-.927	-.856
POA TO CENTROID in.	:	.871	1.047	.911
MIN RADIUS	:	.149	.328	.278
MEAN RADIUS	:	1.072	1.026	.936
MAX RADIUS	:	1.628	1.556	1.476
HORIZONTAL SPREAD	:	2.135	2.135	1.227
VERTICAL SPREAD	:	2.872	2.673	2.673
EXTREME SPREAD	:	3.026	2.750	2.750
NUMBER IN ONE INCH CIRCLE =			1	
NUMBER IN TWO INCH CIRCLE =			4	
NUMBER IN THREE INCH CIRCLE =			8	

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CENTERFIRE PATTERNS

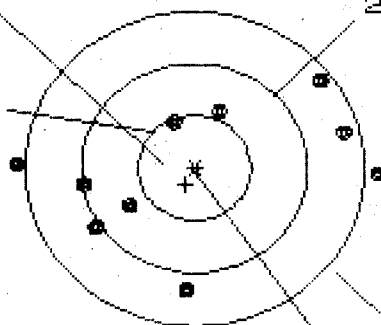
5

POA

1in circle

2in circle

3in circle



OF SHOTS- 10

IN CIR

1in = 0

2in = 4

3in = 6

LS = 3.172

VS = 2.064

GS = 3.172

CENTROID *

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.583	1.406	1.304
MINIMUM X	:	-1.589	-1.158	-.982
MAXIMUM Y	:	.868	.868	.862
MINIMUM Y	:	-1.196	-1.196	-1.202
CENTROID X	:	.080	.257	.081
CENTROID Y	:	.158	.158	.164
POA TO CENTROID in.	:	.177	.301	.183
MIN RADIUS	:	.507	.507	.502
MEAN RADIUS	:	1.099	1.051	.977
MAX RADIUS	:	1.589	1.407	1.405
HORIZONTAL SPREAD	:	3.172	2.564	2.286
VERTICAL SPREAD	:	2.064	2.064	2.064
EXTREME SPREAD	:	3.172	2.565	2.499
NUMBER IN ONE INCH CIRCLE	=	0		
NUMBER IN TWO INCH CIRCLE	=	4		
NUMBER IN THREE INCH CIRCLE	=	6		