

C6349024

MODEL 700™ M24

Model SWS™

Action

Barrel Length

Capacity

Order No. 5716

*Includes 1 in chamber.

Remington

Repair Inquiry

Repair Number: RE00128532

Serial: C6349024 Model M24 SWS Center Fire
Caliber: 7.62 NATO

Repairman:

Verify Repair

Status:

New 4/24/2007 7:39:45 AM

Address Information

Customer:

☒ Received From

Return To:

☐ Received From

Name: ISSD ARMSROOM

ISSD ARMSROOM

Address 1: 8TH DESERT STORM

8TH DESERT STORM

Address 2: BLDG 5210 BAY DOOR #30

PO Box:

BLDG 5210 BAY DOOR #30

PO Box:

City: FORT CAMPBELL

FORT CAMPBELL

State: KY

Zip Code: 42223

Country: US

State: KY

Zip Code: 42223

Country: US

FFL:

Contact / Condition

Problems

Estimate

History / Status

Shipping / Billing

Contact Information

Phone: NN

Fax:

Email:

Comments:

Received Condition

Fair

Condition
Notes:CSR
Notes:

Accessories Received

Code	Desc	Qty
A007	With Stud	3
A010	Hard Case	1
A017	Scope Base	1
A026	Scope	1
A045	Bi Pod	1
A057	Frt and Rear Sgt Base	1

Repair Search

Refresh

Close

naglej

4/24/2007

8:10 AM

CAPS

NUM

INS

SCRL

Serial Number: C6349024

Model: M24 SWS



RE00128532

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6349024.___0
FILE DATE AND TIME: 06/04/2007 15:14

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.048
The Average Y Centroid of the Five Target Set:	-0.025
The Average Point of Impact of the Five Target Set:	0.054
The Average Mean Radius of the Five Target Set:	0.633
The Distance from POA to Centroid Target #1:	0.199
The Distance from Centroid Target #2 to Centroid Target #1:	0.257
The Distance from Centroid Target #3 to Centroid Target #1:	0.126
The Distance from Centroid Target #4 to Centroid Target #1:	0.273
The Distance from Centroid Target #5 to Centroid Target #1:	0.290

SERIAL NUMBER: C6349024. __0

TARGET NUMBER: 1

FILE DATE: 06/04/2007

FILE TIME: 15:14

POINT#	X	Y
1:	0.831	-0.689
2:	0.549	-0.871
3:	-0.245	-0.759
4:	0.322	0.564
5:	0.079	0.634
6:	-0.252	1.017
7:	-0.070	0.231
8:	-0.302	0.134
9:	-0.252	-0.132
10:	-2.295	1.007

X CENTROID: -0.163

Y CENTROID: 0.114

POA TO CENTROID: 0.199

HORZ SPREAD: 3.126

VERT SPREAD: 1.888

GROUP SPREAD: 3.556

MIN RADIUS: 0.140

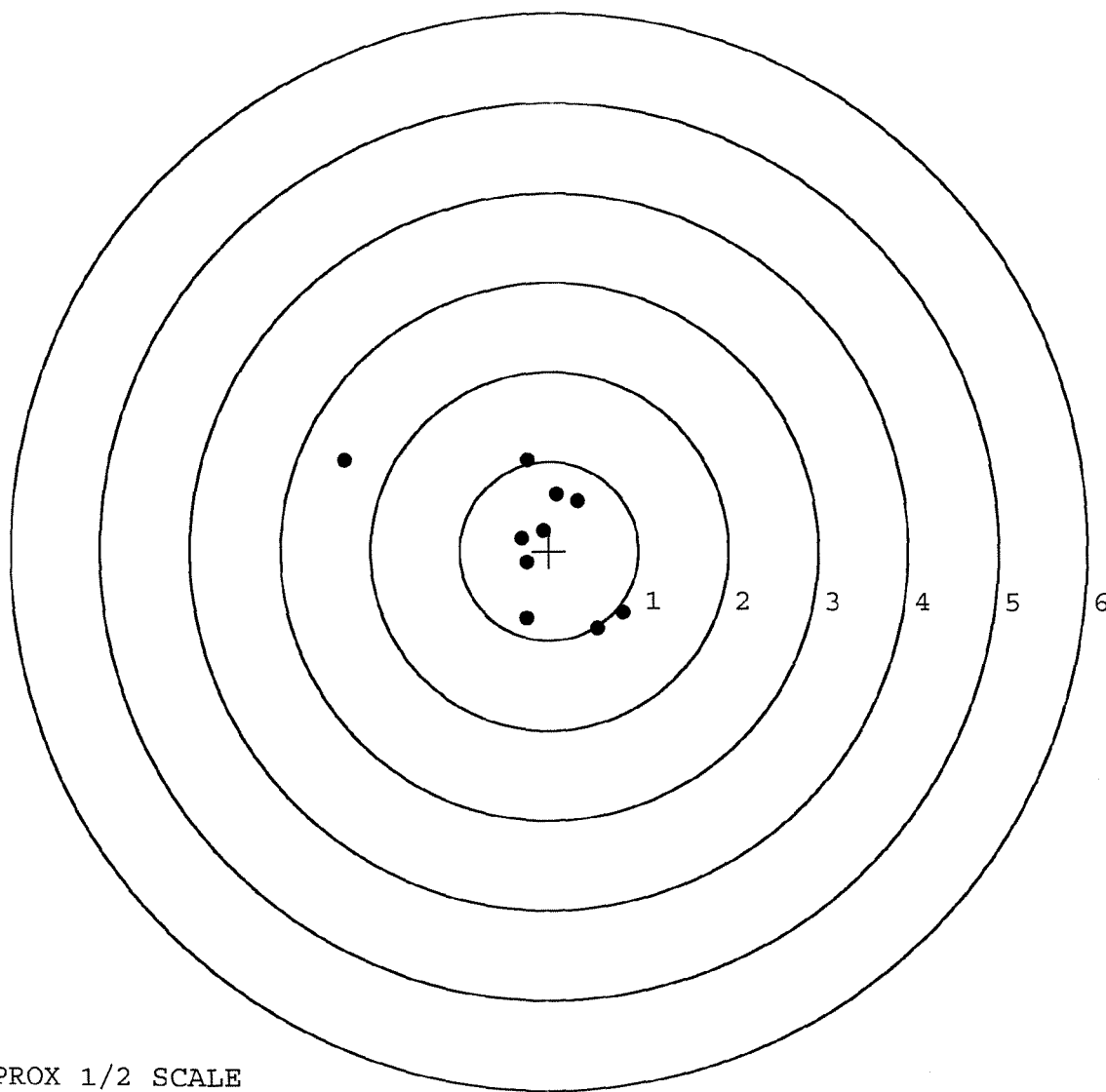
MAX RADIUS: 2.311

MEAN RADIUS: 0.838

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 9

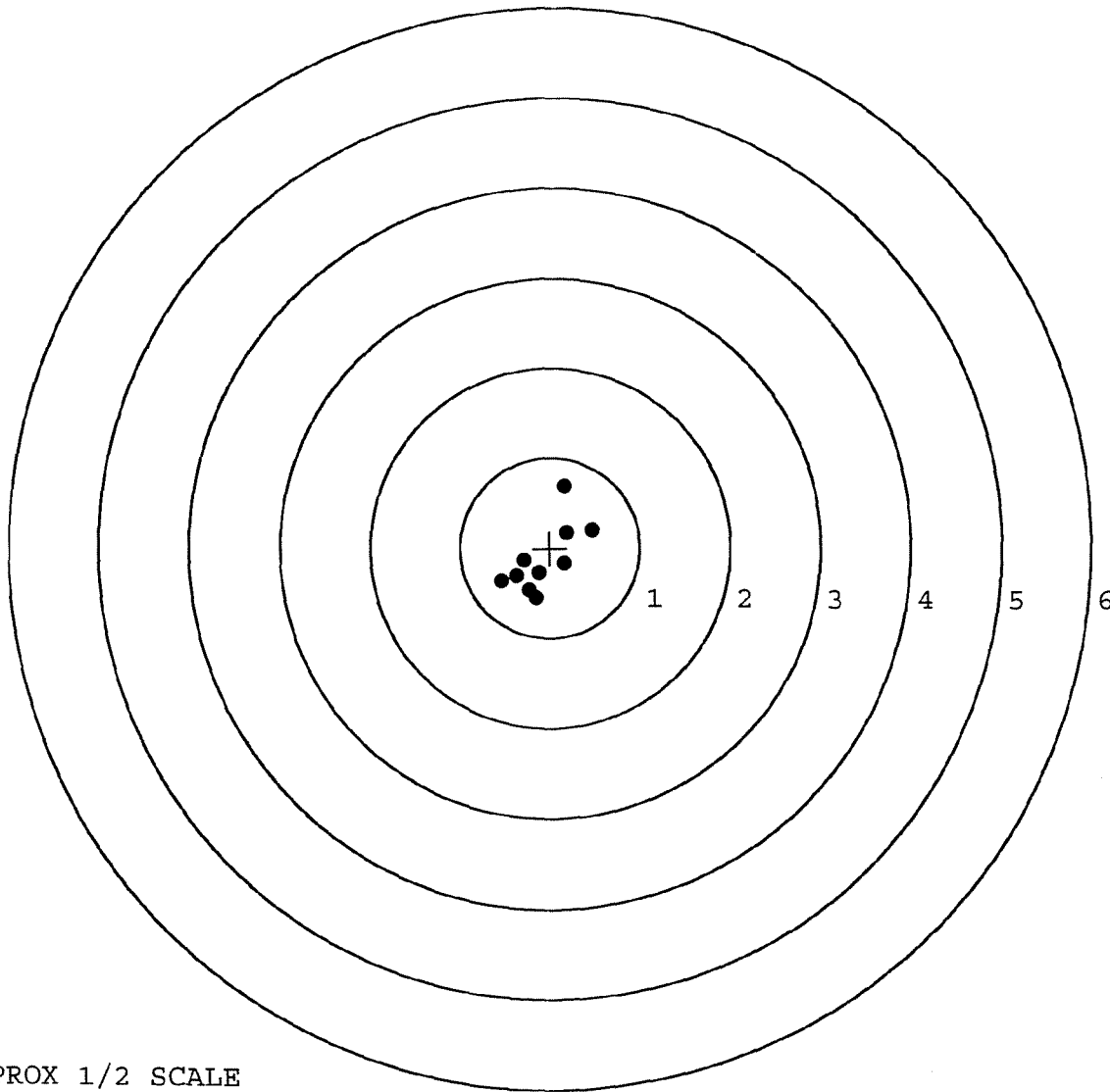


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6349024. __0
TARGET NUMBER: 2
FILE DATE: 06/04/2007
FILE TIME: 15:14

POINT#	X	Y
1:	0.469	0.203
2:	0.184	0.171
3:	0.159	0.684
4:	0.164	-0.176
5:	-0.537	-0.370
6:	-0.150	-0.560
7:	-0.371	-0.319
8:	-0.290	-0.143
9:	-0.114	-0.280
10:	-0.231	-0.478

X CENTROID: -0.072
Y CENTROID: -0.127
POA TO CENTROID: 0.146
HORZ SPREAD: 1.006
VERT SPREAD: 1.244
GROUP SPREAD: 1.282
MIN RADIUS: 0.159
MAX RADIUS: 0.843
MEAN RADIUS: 0.419
IN 1 IN DIAMETER: 7
IN 2 IN DIAMETER: 10
in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6349024. __0

TARGET NUMBER: 3

FILE DATE: 06/04/2007

FILE TIME: 15:14

POINT#	X	Y
1:	0.255	-0.882
2:	-0.479	-0.702
3:	-0.561	0.998
4:	-0.903	0.418
5:	-0.335	0.207
6:	0.225	0.540
7:	0.646	0.141
8:	0.455	0.092
9:	0.242	0.018
10:	0.037	-0.026

X CENTROID: -0.042

Y CENTROID: 0.080

POA TO CENTROID: 0.091

HORZ SPREAD: 1.549

VERT SPREAD: 1.880

GROUP SPREAD: 2.049

MIN RADIUS: 0.132

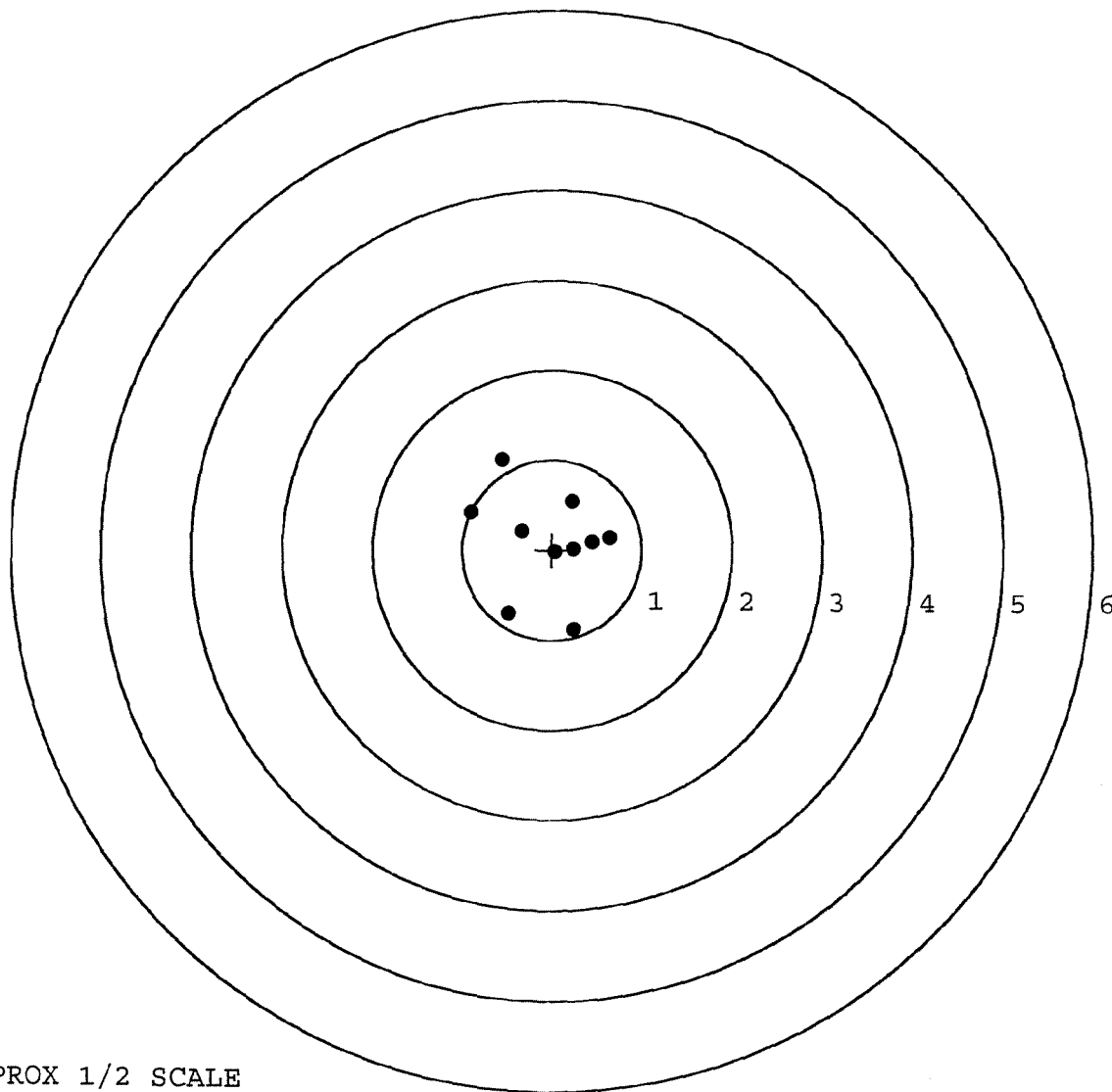
MAX RADIUS: 1.054

MEAN RADIUS: 0.634

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6349024. __0

TARGET NUMBER: 4

FILE DATE: 06/04/2007

FILE TIME: 15:14

POINT#	X	Y
1:	0.763	0.091
2:	0.499	0.339
3:	0.481	-0.638
4:	0.253	-0.392
5:	0.123	-0.219
6:	-0.333	-0.570
7:	-0.131	-0.158
8:	-0.379	-0.216
9:	-0.533	0.258
10:	-0.860	0.376

X CENTROID: -0.012

Y CENTROID: -0.113

POA TO CENTROID: 0.114

HORZ SPREAD: 1.623

VERT SPREAD: 1.014

GROUP SPREAD: 1.681

MIN RADIUS: 0.128

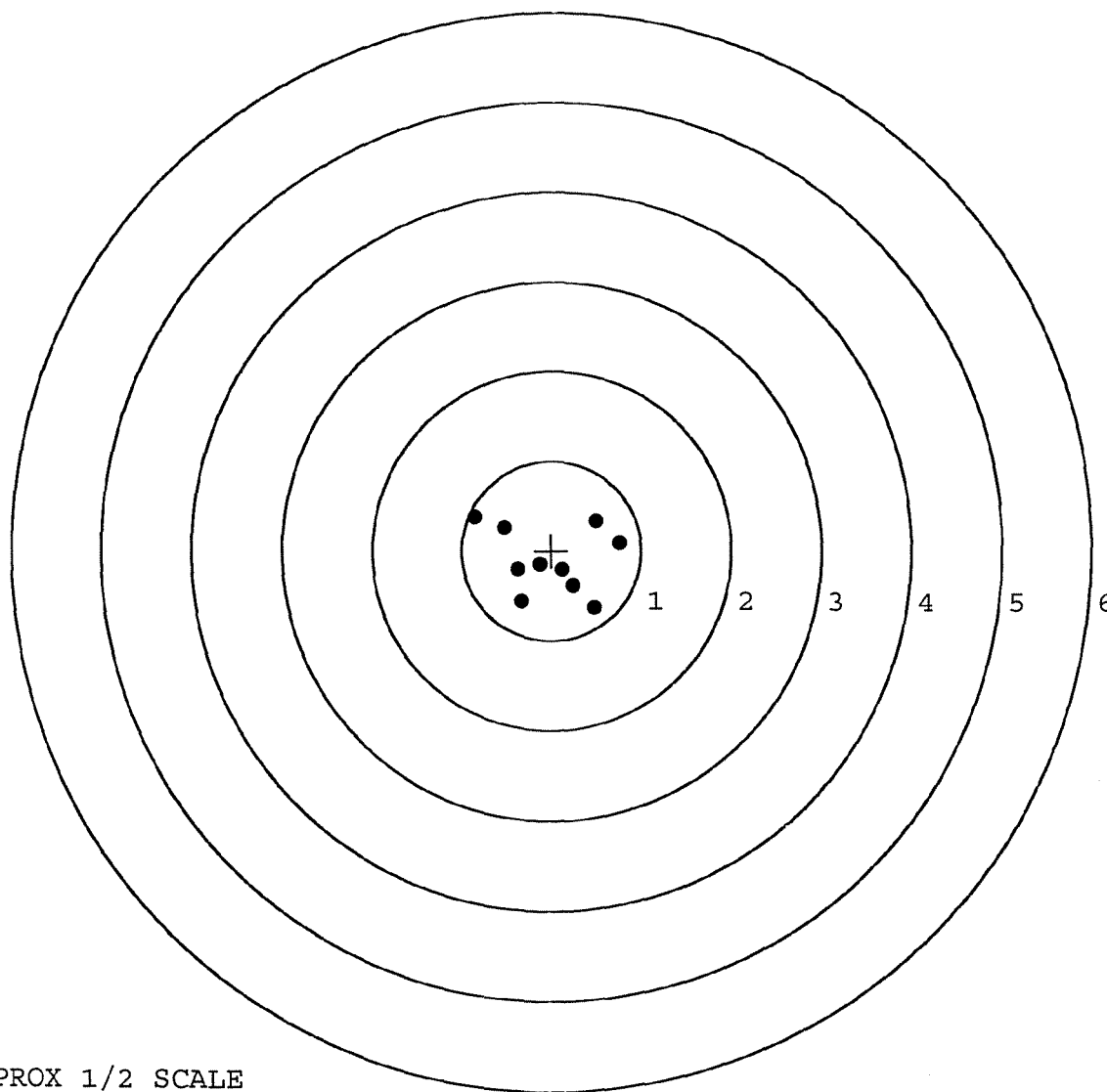
MAX RADIUS: 0.979

MEAN RADIUS: 0.545

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10

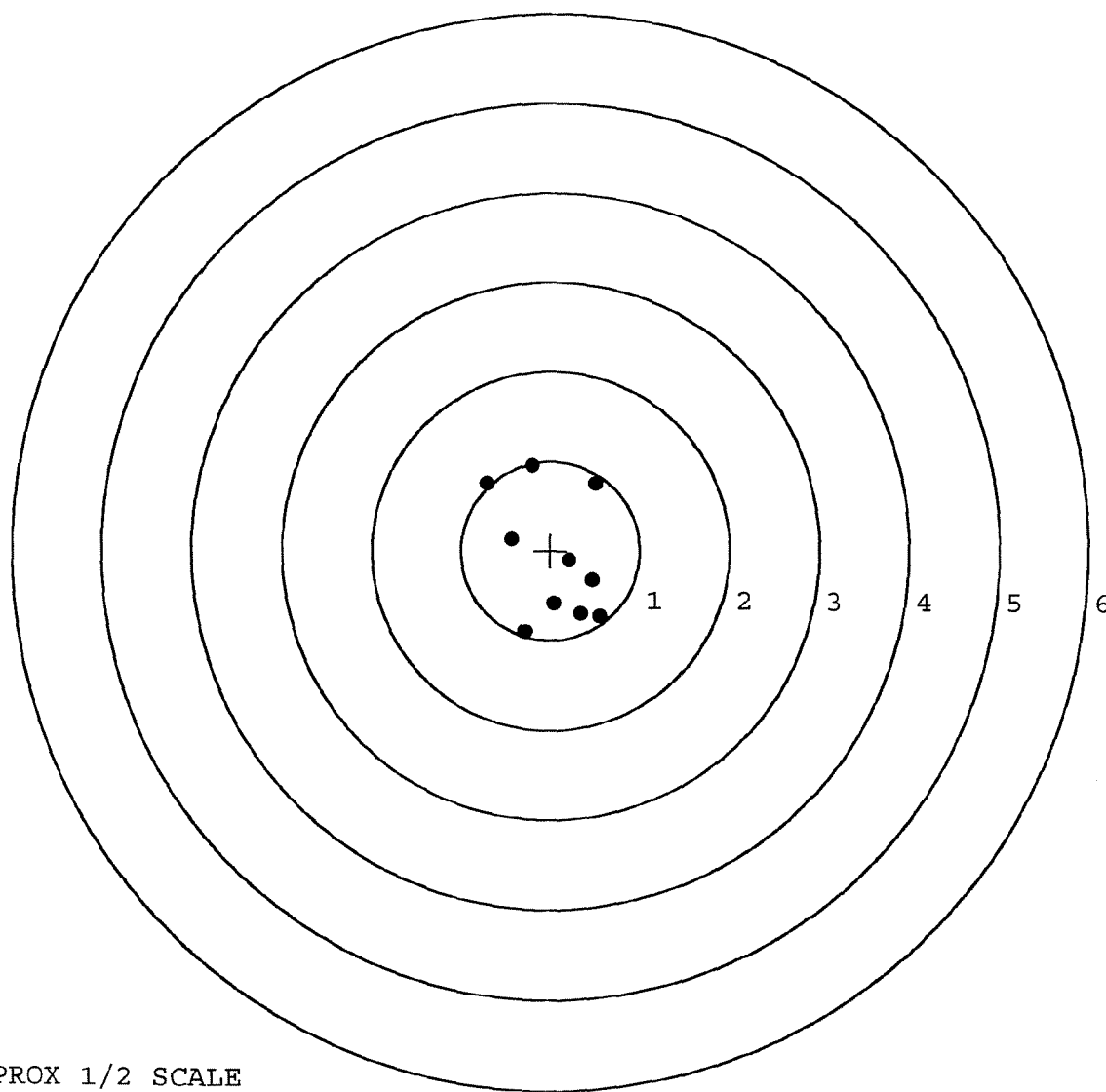


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6349024. __0
TARGET NUMBER: 5
FILE DATE: 06/04/2007
FILE TIME: 15:14

X CENTROID: 0.051
Y CENTROID: -0.082
POA TO CENTROID: 0.096
HORZ SPREAD: 1.275
VERT SPREAD: 1.872
GROUP SPREAD: 1.959
MIN RADIUS: 0.163
MAX RADIUS: 1.131
MEAN RADIUS: 0.727
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.506	0.754
2:	-0.216	0.958
3:	-0.715	0.751
4:	-0.429	0.122
5:	0.211	-0.111
6:	0.474	-0.331
7:	0.560	-0.736
8:	0.048	-0.597
9:	-0.281	-0.914
10:	0.348	-0.711



TARGET APPROX 1/2 SCALE

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

R & E NUMBER		128532		
SERIAL NUMBER		C60349024		
LOG-IN DATE		4-24-07		
OPERATION #	OPERATION NAME		DATE	INITIAL
500	DIS-ASSEMBLE GUN		5-15-07	RTZ
505	RE-BARREL		5-18-07	RTZ
560	ASSEMBLE		5-18-07	RTZ
600	PROOF	MAGNA - FLUX MAY 21 2008 OPERATOR <u>unnd</u>	5-18-07	TRW
605	CHECK HEADSPACE		5-18-07	TRW
610	DIS-ASSEMBLE GUN		5-21-07	RTZ
612	MAGNAFLUX		5/21/07	unnd
510	DRILL AND TAP		5-21-07	TRW
615	ROLLMARK CALIBER		5-21-07	CW
618	ROTO-BLAST		5-22-07	LB
620	APPLY COATINGS		5-24-07	W
625	FINAL ASSEMBLY		6-1-07	RTZ
640	FUNCTION TEST AND	(PASS) FAIL	6-4-07	TRW
650	TARGET	(PASS) FAIL	6-4-07	TRW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
670	FINAL INSPECTION		6-4-07	Fm
	A) HEADSPACE	(PASS) FAIL	6-7-07	RTZ
			6-7-07	RTZ
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	282 280 280 281 284 6-5-07 DA	
680	F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX	4.0 3.5 3.5 6-5-07 DA	
	G) SAFETY OFF FORCE	2 LBS MIN	2.2 2.2 2.2 6-5-07 DA	
	I) FIRING PIN INDENT	.020	.021 .022 .022 6-5-07 DA	
690	PACK		6-8-07	DA

Cco 91B

MAINTENANCE REQUEST				PAGE NO. 1	NO. OF PAGES 1	REQUIREMENTS CONTROL SYMBOL CSGLD - 1047(R1)	
SECTION I - EQUIPMENT DATA							
CONTROL NUMBER		WORK ORDER NO.		WESDC		ORG. PD X	
☐ Work Request ☐ MWO ☒ Warranty Claim		1A. ORGANIZATION Dco 3/5 SFG		B. LOCATION Ft. Campbell KY 42223		C. UNIT IDENT CODE WH0600	
2. SERIAL NO. C6349024		3. NOUN NOMENCLATURE 7.62 mm Sniper Weapons M24		4. LINE NO.		5. MODEL	
7A. MAINTENANCE ACTIVITY IMO		B. LEVEL Ø		8. UTILIZATION CODE Ø		9A. MCSR ITEM	
				9B. ERC		9C. 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 Sch. Main. ☐ C Test ☐ E Storage ☐ G Flight ☐ B Handling ☐ D Normal Op ☐ F Inspection ☒ H Other				☐ 068 Inoperative ☐ 258 Overheating ☐ 790 Out of Adjustment ☐ 008 Noisy ☐ 387 Low Performance ☒ Other			
16A. DESCRIBE DEFICIENCIES OR SYMPTOMS ON THE BASIS OF COMPLETE CHECKOUT AND DIAGNOSTIC PROCEDURE IN EQUIPMENT TM (Do not prescribe repairs) 5,200 RNDs Fired							
B. REMARKS W 52H095345 H246							
PREPARATION INSTRUCTIONS (Prior to using this form, read DA PAM 738-750 for detailed preparation instructions)							
1. Place a "✓" or an "X" in the box for the type of action required. 2. Enter the WESDC if the item is Materiel Condition Status Reportable. 3. Enter the priority designator as determined from the urgency of need and force activity designator. 4. The Unit Commander, Chief of TDA activity or their designated representative will authenticate, by signature, a priority of 01 through 08. 5. Block 1A. Enter the name of the organization submitting the request. 6. Block 1B. Enter the unit submitting the request; units overseas enter APO only. 7. Block 1C. Enter the unit identification code of the unit in block 1A. 8. Block 2. Enter the equipment serial number. For ammunition, enter the lot number. For administrative-use vehicles, enter the USA registration number. 9. Block 3. Enter the noun abbreviation of the item. 10. Block 4. Enter the item line number, if applicable. 11. Block 5. Enter the model number. 12. Block 6. Enter the National Stock Number of the item listed in Block 3.				13. Block 7. Enter the name of the support activity. 14. Block 7A. Enter the symbol of the maintenance category (O, F, H, D, or L). 15. Block 8. Enter the utilization code. 16. Block 9A. Enter the word "yes" if the item is Materiel Condition Status Reportable. 17. Block 9B. Enter the equipment readiness code, if applicable. 18. Block 9C. Enter the word "yes" if the item is a pacing item. 19. Block 10. Enter the hour reading, if applicable. 20. Block 11. Enter the mileage from the odometer, if applicable. 21. Block 12. Enter the total rounds fired, if applicable. 22. Block 13. For turbine engines, enter the number of hot starts. 23. Block 14. Enter a "✓" or "X" in the proper block. 24. Block 15. Enter a "✓" or "X" in the proper block. 25. Block 16. Describe briefly the fault or symptoms needing correction.			
23. SUBMITTED BY <i>Tony W. W. W.</i>		24. RECEIVED BY					
JULIAN DATE		JULIAN DATE					

DA FORM 2407, AUG 88

EDITION OF MAY 81 MAY BE USED

RECEIPT COPY 1

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

M2400106030

MAINTENANCE REQUEST				PAGE NO.	NO OF PAGES	REQUIREMENTS CONTROL SYMBOL																													
For use of this form, see DA PAM 738-750; the proponent agency is DCSLOG				1	1	CSGLD - 1047(R1)																													
SECTION I - EQUIPMENT DATA																																			
CONTROL NUMBER		WORK ORDER NO.		WESDC	ORG. PD	PD AUTHENTICATION																													
☐ Work Request ☐ MWO ☒ Warranty Claim		1A. ORGANIZATION Dco 3/5 SFG		B. LOCATION Ft. Campbell KY 42223		C. UNIT IDENT CODE WH0600																													
2. SERIAL NO. C6349024		3. NOUN NOMENCLATURE 7.62 mm Super Weapon M24		4. LINE NO.	5. MODEL	6. NATIONAL STOCK NUMBER 1005-01-240-2136																													
7A. MAINTENANCE ACTIVITY IMO		B. LEVEL 0	8. UTILIZATION CODE 0	9A. MCSR ITEM	9B. ERC	9C. PACING ITEM	10. HOURS /	11. MILES /	12. ROUNDS	13. STARTS																									
14. FAILURE DETECTED DURING (Select one - use ☒ or X) <table border="1"><tr><td>☐ A</td><td>Sch. Main.</td><td>☐ C</td><td>Test</td><td>☐ E</td><td>Storage</td><td>☐ G</td><td>Flight</td></tr><tr><td>☐ B</td><td>Handling</td><td>☐ D</td><td>Normal Op</td><td>☐ F</td><td>Inspection</td><td>☒ H</td><td>Other</td></tr></table>				☐ A	Sch. Main.	☐ C	Test	☐ E	Storage	☐ G	Flight	☐ B	Handling	☐ D	Normal Op	☐ F	Inspection	☒ H	Other	15. FIRST INDICATION OF TROUBLE (Select one - use ☒ or X) <table border="1"><tr><td>☐ 068</td><td>Inoperative</td><td>☐ 258</td><td>Overheating</td><td>☐ 790</td><td>Out of Adjustment</td></tr><tr><td>☐ 008</td><td>Noisy</td><td>☐ 387</td><td>Low Performance</td><td>☒</td><td>Other</td></tr></table>				☐ 068	Inoperative	☐ 258	Overheating	☐ 790	Out of Adjustment	☐ 008	Noisy	☐ 387	Low Performance	☒	Other
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B. REMARKS W 52 H095345 H246																																			
SECTION II - WORK ACCOMPLISHED																																			
17A. REPAIR ORGANIZATION/ACTIVITY			C. UNIT IDENT. CODE		18. TYPE ORGANIZATION/ACTIVITY ACCOMPLISHING WORK (Select one - use ☒ or X) <table border="1"><tr><td>☐ 1</td><td>TOE</td><td>☐ 2</td><td>TD</td><td>☐ 3</td><td>Contractor</td></tr></table>		☐ 1	TOE	☐ 2	TD	☐ 3	Contractor	19. AMS ACCT. CODE																						
☐ 1	TOE	☐ 2	TD	☐ 3	Contractor																														
B. LOCATION																																			
20A. ACT. CODE	B. FAILURE CODE	C. COMPONENT/PART NOUN, SVC, OR MWO NO. (1) CB CODE (2) REF DESIGN. (3) MFR. CODE			D. MANHOURS (Hrs. & tenths)	E. NATIONAL STOCK NUMBER	F. PART SOURCE CODE	G. QTY.	H. PARTS COST																										
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I. TOTAL MANHOURS					J. TOTAL MANHOURS COST \$		K. TOTAL PARTS COST \$																												
21. DELAY (Select One) <table border="1"><tr><td>☐ 1</td><td>Parts</td><td>☐ 2</td><td>Manpower</td><td>☐ 3</td><td>Facilities</td><td>☐ 4</td><td>Funds</td><td>☐ 5</td><td>Tools</td></tr></table>					☐ 1	Parts	☐ 2	Manpower	☐ 3	Facilities	☐ 4	Funds	☐ 5	Tools	22. Data Transcribed																				
☐ 1	Parts	☐ 2	Manpower	☐ 3	Facilities	☐ 4	Funds	☐ 5	Tools																										
23. SUBMITTED BY Tony [Signature]		24. RECEIVED BY		25. WORK STARTED BY		26. INSPECTED BY		27. ACCEPTED BY		28. DISPOSITION (Select One) <table border="1"><tr><td>☐ A</td><td>To User</td><td>☐ D</td><td>Evacuated</td></tr><tr><td>☐ B</td><td>To Stock</td><td>☐ E</td><td>Cannibalization</td></tr><tr><td>☐ C</td><td>Salvaged</td><td></td><td></td></tr></table>		☐ A	To User	☐ D	Evacuated	☐ B	To Stock	☐ E	Cannibalization	☐ C	Salvaged														
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JULIAN DATE		JULIAN DATE		JULIAN DATE		JULIAN DATE		JULIAN DATE																											

RECEIVING AND ESTIMATING REPORT

COMMENTS

ORDER
R 95-30891INITIAL
JJM

CUSTOMER ORDER NO.

W/LEUPOLD 10X SCOPE (SCOPE #89-0934)
NIGHT VISION BASEDATE RECEIVED
12/01/95DATE OPENED
12/05/95

DATE CODE

SERIAL NUMBER
C6349024

NEW SERIAL NUMBER

MODEL AND GRADE
700 7.62

NATO

ACCESSORIES

HARD CASE

SCOPE MNTS

SCOPE BASE

FROM:

TRANSPORTATION OFFICE
FT CAMPBELL

KY 42223

SHIP TO:

TRANSPORTATION OFFICE
FT CAMPBELLKY
42223

CUST NO: 087942 C.O.D.L.

ACCOUNT NUMBER

ACCOUNT NUMBER N/C

WRITE ☐

PROM. DATE

ESTIMATED

VIA

UPS

GUN CONDITION

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

REPAIR CHARGE

EXCISE

TAX

INSURANCE

UPS

PARCEL POST

TOTAL

CUSTOMER CONCERN	AMMO	FUNCTION	FINISH	ACCURACY	FIT	INSPECT
CYCLE	A1	B1				
TRIGGER GROUP		B2				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

PARTS

COMMENTS

Barrel - 96003

Repowder Coat Trigger Guard
Assy. Front & Rear Sight Bases
Reclining Scope Base, Rings &
Swivel StudsScope sent back to Vendor
to be checked

REPAIRMAN

PROOF

CLEAN

TEST

TARGET

PATTERN

GALLERY TESTER

DATE

DATE

DATE

DATE

DATE

OFFICE COPY

RD6925 REV. 1/84

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

M2400106032

New Barrel

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6349024

OP. #	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and Stock		12/21/95	RW
600	Proof		12/21/95	RW
607	Check Headspace		12/21/95	RW
610	Dis-assemble Gun		12/21/95	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		1/5/96	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		1/5/96	RW
	C) Inspect Ejector Hole for Chamfer		1/5/96	RW
	D) Oil Firing Pin Ass'y		1/5/96	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		1/8/96	RW
	A) Time			
	B) Malfunctions			
	C) Pierced Primers			
	D) Optical Clarity of Scope			
645	Inspect for Live Ammo		1/8/96	RW
655	Final Inspection			
	A) Headspace		1/10/96	RW
	B) Trigger Pull		1/10/96	RW
	C) Function		1/10/96	RW
660	Pack			

Final Inspection

Sn: C6349024

DATE REC'D: 12/04/95

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: _____




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

REG. U.S. PAT. & TM. OFF.

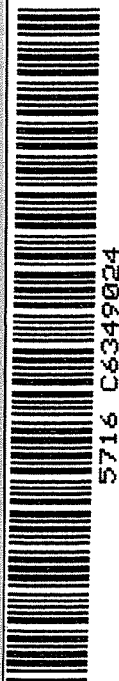
MODEL 700™ H24

SERIAL NO.
C6349024

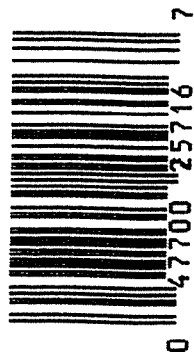
ORDER NO.
5716

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

Ø1



UPC



CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C8349024
7 Jan 1980

CENTROIDAL DISTANCES

0 TO	1	1.04946
1 TO	2	.39308
1 TO	3	.384178
1 TO	4	.3178
1 TO	5	.205828

342

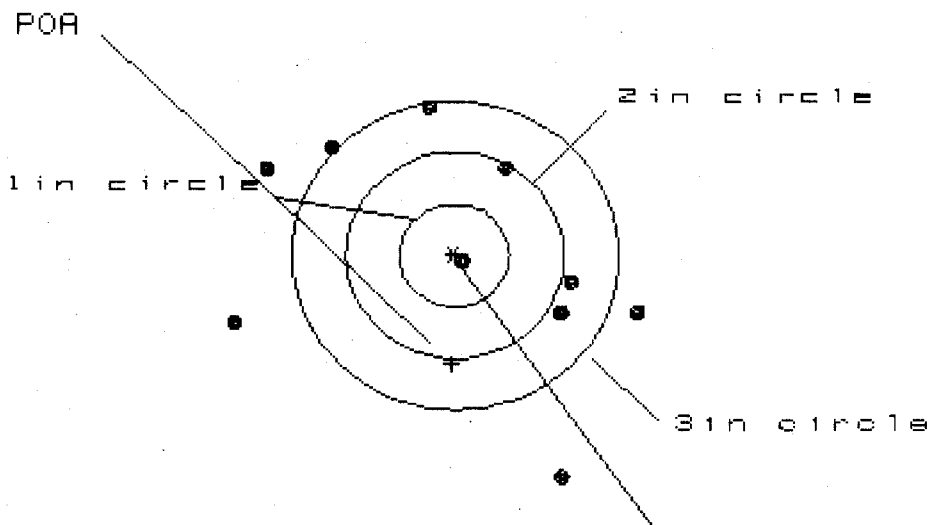
+ (----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0306
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: 1.2348
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: 1.23518
THE AMR FOR THIS RIFLE IS: .9848

7 Jan 1900

FILE:/PATTERNING/CENTERFIRE_PATT/C6349024

CENTERFIRE PAT ERNS # 1



OF SHOTS- 10

IN CIR

1in - 1

2in - 2

3in = 5

HS= 3.690

VS= 3.664

GS= 4.084

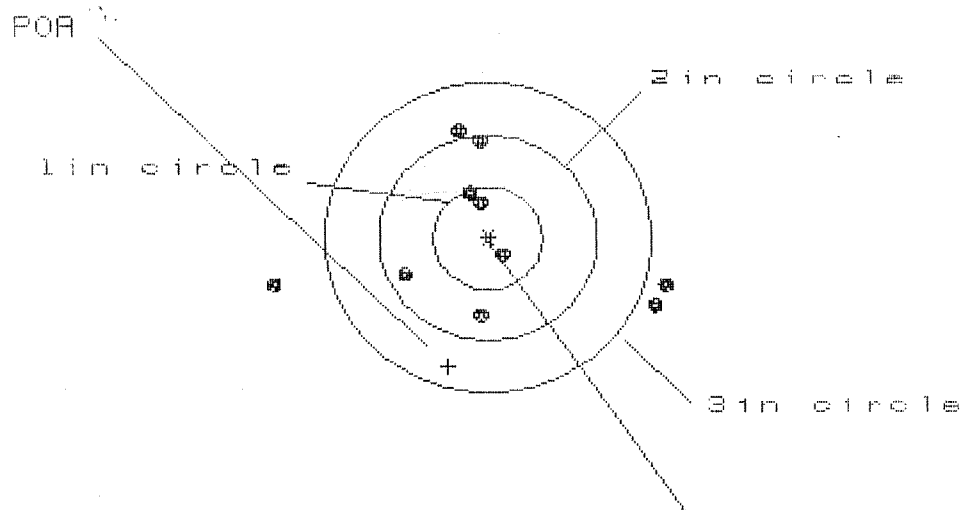
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.652	1.758	1.517
MINIMUM X	-2.038	-1.932	-1.856
MAXIMUM Y	1.473	1.229	1.124
MINIMUM Y	-2.191	-.845	-.892
CENTROID X	.031	-.075	.166
CENTROID Y	1.049	1.293	1.398
POA TO CENTROID in.	1.050	1.295	1.408
MIN RADIUS	.100	.364	.460
MEAN RADIUS	1.446	1.341	1.209
MAX RADIUS	2.391	2.108	1.934
HORIZONTAL SPREAD	3.690	3.690	3.373
VERTICAL SPREAD	3.664	2.074	2.016
EXTREME SPREAD	4.084	3.691	3.663
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	2		
NUMBER IN THREE INCH CIRCLE =	5		

7 Jan 1988

FILE:/PATTERNING/CENTER E_PATT/C6349824

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 3

2in = 6

3in = 7

HS= 3.636

VS= 1.775

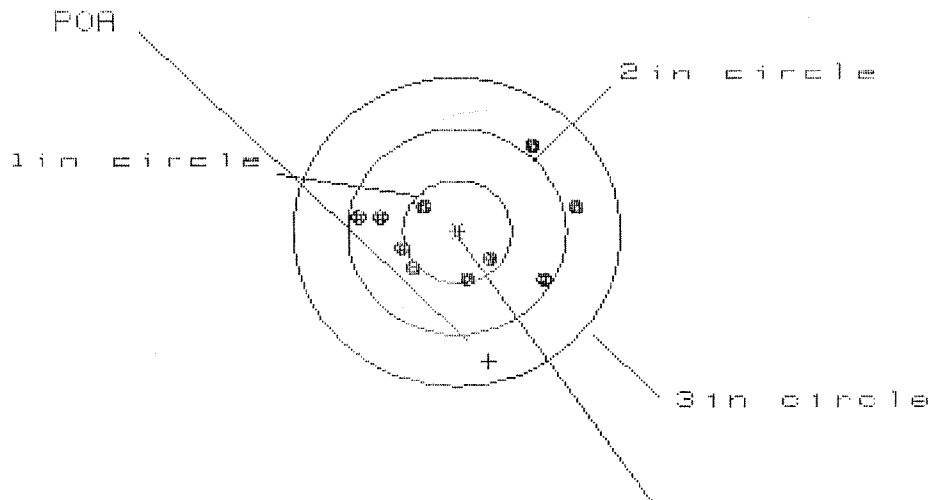
GS= 3.636

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.646	1.425	1.496
MINIMUM X	:	-1.990	-.960	-.782
MAXIMUM Y	:	1.048	1.002	.944
MINIMUM Y	:	-.727	-.773	-.831
CENTROID X	:	.367	.588	.410
CENTROID Y	:	1.253	1.299	1.357
POA TO CENTROID in.	:	1.305	1.426	1.418
MIN RADIUS	:	.216	.197	.215
MEAN RADIUS	:	.996	.890	.766
MAX RADIUS	:	2.033	1.500	1.675
HORIZONTAL SPREAD	:	3.636	2.385	2.278
VERTICAL SPREAD	:	1.775	1.775	1.775
EXTREME SPREAD	:	3.636	2.514	2.514
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		7	

7 Jan 1900

FILE:/PATTERNING/CENTERFIRE_PATT/C6349024

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 4

2 in = 8

3 in = 10

HS= 2.034

VS= 1.249

CS= 2.041

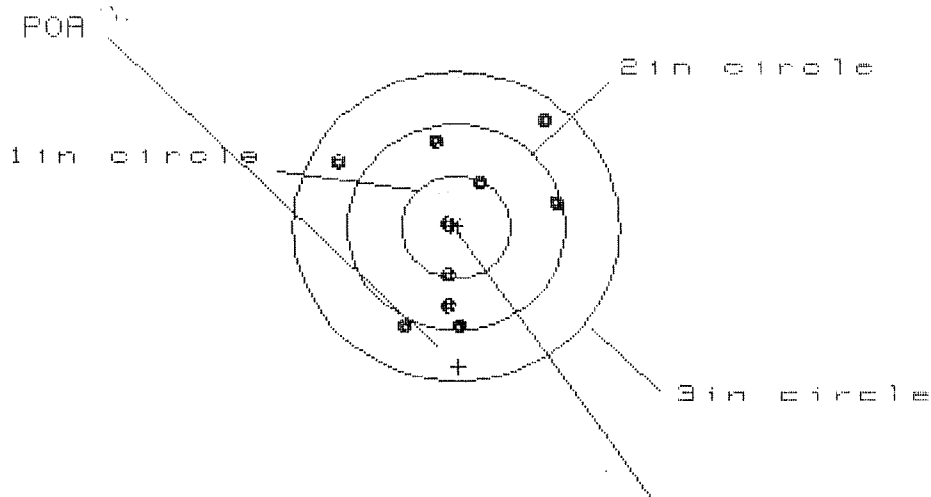
CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.101	.868	.967
MINIMUM X	:	-.933	-.810	-.711
MAXIMUM Y	:	.831	.859	.410
MINIMUM Y	:	-.418	-.390	-.282
CENTROID X	:	-.292	-.415	-.514
CENTROID Y	:	1.257	1.229	1.121
POA TO CENTROID in.	:	1.291	1.297	1.234
MIN RADIUS	:	.354	.372	.241
MEAN RADIUS	:	.694	.619	.517
MAX RADIUS	:	1.131	1.173	1.008
HORIZONTAL SPREAD	:	2.034	1.678	1.678
VERTICAL SPREAD	:	1.249	1.249	.692
EXTREME SPREAD	:	2.041	1.770	1.754
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		8	

7 Jan 1968

FILE:/PATTERNING/CENTER# PATT/C6349024

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

CENTROID *

IN CIR

1in = 3

2in = 7

3in = 10

HS= 2.015

VS= 2.055

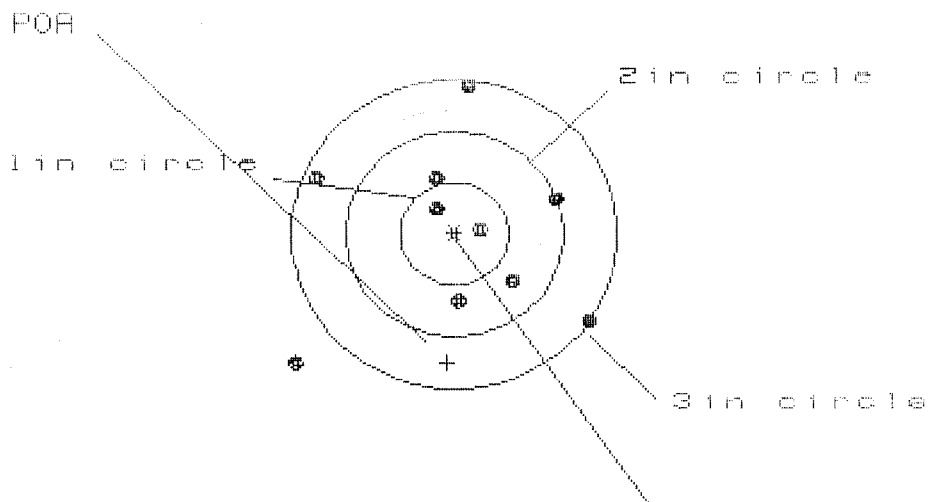
GS= 2.441

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.913	1.010	.884
MINIMUM X	:	-1.102	-1.005	-.480
MAXIMUM Y	:	1.067	.996	1.088
MINIMUM Y	:	-.988	-.870	-.778
CENTROID X	:	-.018	-.115	.011
CENTROID Y	:	1.363	1.245	1.153
POA TO CENTROID in.	:	1.363	1.250	1.153
MIN RADIUS	:	.076	.125	.239
MEAN RADIUS	:	.832	.761	.689
MAX RADIUS	:	1.375	1.245	1.113
HORIZONTAL SPREAD	:	2.015	2.015	1.364
VERTICAL SPREAD	:	2.055	1.866	1.866
EXTREME SPREAD	:	2.441	2.049	1.882
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

7 Jan 1968

FILE:/PATTERNING/CENTERFIRE_PATT/C6349024

CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1in = 2

2in = 5

3in = 9

HS= 2.624

VS= 2.624

GS= 3.040

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.208	1.051	.932
MINIMUM X	:	-1.416	-1.421	-1.290
MAXIMUM Y	:	1.408	1.273	1.154
MINIMUM Y	:	-1.216	-.951	-.877
CENTROID X	:	.065	.222	.091
CENTROID Y	:	1.252	1.387	1.506
POA TO CENTROID in.	:	1.253	1.404	1.508
MIN RADIUS	:	.291	.141	.212
MEAN RADIUS	:	.956	.827	.748
MAX RADIUS	:	1.866	1.468	1.314
HORIZONTAL SPREAD	:	2.624	2.472	2.222
VERTICAL SPREAD	:	2.624	2.224	2.031
EXTREME SPREAD	:	3.040	2.802	2.231
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6349024

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		4-12-90	RW
600	Proof		4-12-90	RW
607	Check Headspace		4-12-90	RW
610	Dis-assemble Gun		4-12-90	RW
612	Magnaflux Barrel Action		4-19-90	KCR
	Magnaflux Bolt		4-19-90	KCR
615	Rollmark Caliber		4-19-90	BS
617	Drill and Tap Sight Holes		4/23/90	KCB
618	Polish Barrel RWB		4/24/90	WB
620	Apply Coatings (Barrel Action)		4/30/90	TH
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		5/1/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/1/90	RW
	C) Inspect Ejector Hole for Chamfer		5/1/90	RW
	D) Oil Firing Pin Ass'y		5/1/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		5/7/90	RW

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			5/8/90	SM
	G) Safety Off Force	3	3	3			5/8/90	SM
	H) Trigger Pull Test & Retainability						5/7/90	90U
	I) Firing Pin Indent	.020	.020	.020			5/8/90	JP
	J) Assemble Stock						5/15/90	RW
	K) Assemble Swivel Studs						5/15/90	WB
	L) Attach Front and Rear Sight Assemblies						5/15/90	RW
	M) Iron Sight Alignment						5/15/90	RW
	N) Detach Front & Rear Sights & place in numbered container						5/15/90	RW
	O) Attach Scope to Rifle						5-15-90	AC
	P) Detach & Attach Scope 20 Times						5-15-90	AC
640	Gallery Target & Test						5-15-90	DH
	A) Time						5-15-90	DH
	B) Malfunctions						5-15-90	DH
	C) Pierced Primers						5-15-90	DH
	D) Optical Clarity of Scope						5-15-90	DH
645	Inspect for Live Ammo						5-15-90	DH
655	Final Inspection						5/17/90	WB
	A) Headspace						5/17/90	WB
	B) Trigger Pull	2.34	2.31	2.48	2.50	2.37	5/17/90	WB
	C) Function						5/17/90	WB
660	Pack						6/2/90	DH

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. 66349024

DATE 5/7/90

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.55	2.83	2.25	2.34	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.30	2.34	2.30	2.31	
PULL #3	2.54	2.43	2.20	2.48	
PULL #4	2.37	2.25	2.40	2.50	
PULL #5	2.31	2.18	2.41	2.37	
TOTAL	12.07	11.43	11.56		
AVG.	2.414	2.286	2.312		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.50	3.31		
PULL #2	3.38	3.26		
PULL #3	3.35	3.35		
PULL #4	3.38	3.34		
PULL #5	3.33	3.36		
TOTAL	16.94	16.62		
AVG.	3.388	3.324		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.32	4.29		4.27
PULL #2	4.37	4.33		4.37
PULL #3	4.39	4.30		4.37
PULL #4	4.39	4.37		4.40
PULL #5	4.25	4.21		4.41
TOTAL	21.72	21.50		21.82
AVG.	4.344	4.3		4.364

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 05349024
18 May 1990

CENTROIDAL DISTANCES

0 TO	1	.474976
1 TO	2	.355141
1 TO	3	.391063
1 TO	4	.478961
1 TO	5	.3786

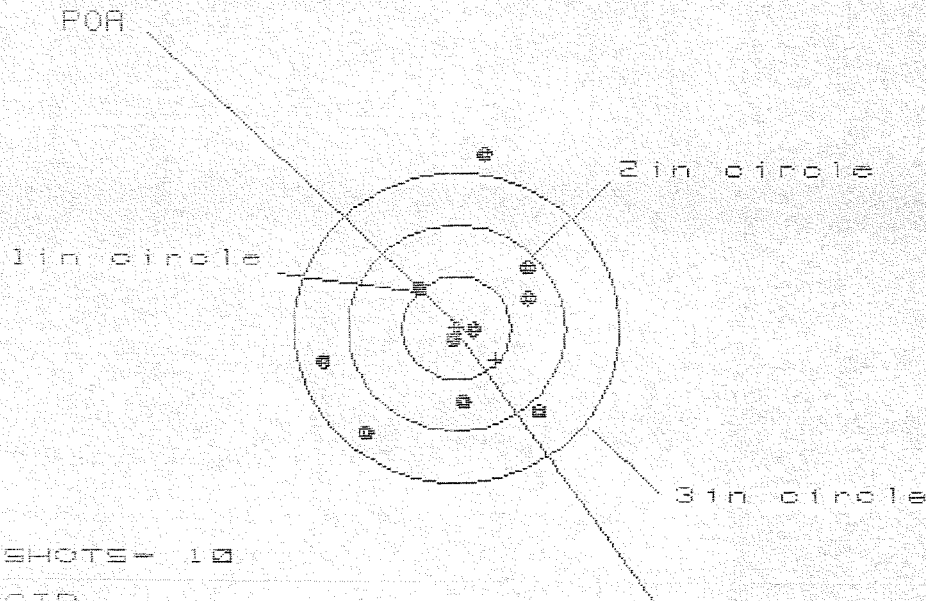
$\frac{1}{5}$ <----POB

THE AVERAGE Y COORDINATE FOR THIS RIFLE IS: -.1499
THE AVERAGE X COORDINATE FOR THIS RIFLE IS: .0703
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .155889
THE AMP FOR THIS RIFLE IS: .8586

15 May 1998

FILE:/PATTERNING/CENTERFIRE_PATT/09349024

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1in = 3

2in = 6

3in = 9

HS = 1.993

VS = 2.668

CS = 2.854

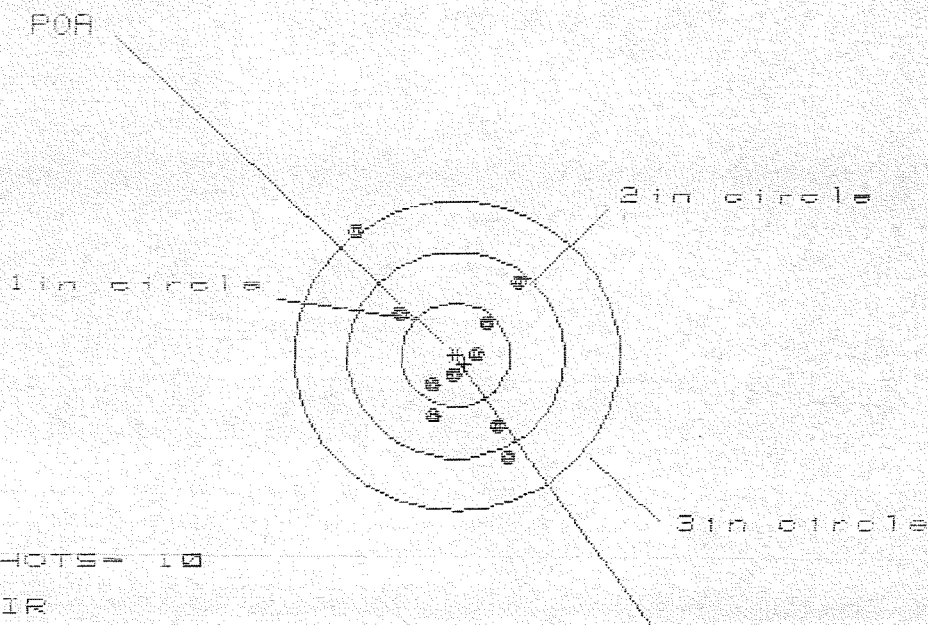
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.766	.790	.640
MINIMUM X	-1.227	-1.203	-.918
MAXIMUM Y	1.704	.728	.714
MINIMUM Y	-.964	-.775	-.789
CENTROID X	-.359	-.383	-.233
CENTROID Y	.311	.122	.136
FOR TO CENTROID in.	.475	.402	.270
MIN RADIUS	.116	.089	.151
MEAN RADIUS	.830	.727	.658
MAX RADIUS	1.718	1.208	1.211
HORIZONTAL SPREAD	1.993	1.993	1.558
VERTICAL SPREAD	2.668	1.503	1.503
EXTREME SPREAD	2.854	2.085	2.085
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	9		

15 May 1998

FILE:/PATTERNING/CENTERFIRE_PATT/06349024

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1 in = 4

2 in = 8

3 in = 8

HS= 1.495

VS= 2.172

GS= 2.571

CENTROID #

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.588	.479	.523
MINIMUM X	-.915	-.654	-.610
MAXIMUM Y	1.205	.821	.717
MINIMUM Y	-.967	-.833	-.622
CENTROID X	-.0881	.020	-.024
CENTROID Y	.090	-.044	.060
POA TO CENTROID in.	.121	.049	.065
MIN RADIUS	.152	.109	.109
MEAN RADIUS	.659	.545	.493
MAX RADIUS	1.513	.950	.888
HORIZONTAL SPREAD	1.495	1.133	1.133
VERTICAL SPREAD	2.172	1.654	1.339
EXTREME SPREAD	2.571	1.676	1.461
NUMBER IN ONE INCH CIRCLE =		4	
NUMBER IN TWO INCH CIRCLE =		8	
NUMBER IN THREE INCH CIRCLE =		9	

15 May 1986

FILE:/PATTERNING/CENTERFIRE_PATT/C8349024

CENTERFIRE PATTERNS # 3

POA

1 in circle

2 in circle

3 in circle

OF SHOTS = 10

IN CIR

1 in = 1

2 in = 3

3 in = 8

HS = 2.931

VS = 2.362

GS = 3.026

CENTROID *

PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	1.377
MINIMUM X	-1.554
MAXIMUM Y	1.461
MINIMUM Y	-0.901
CENTROID X	-0.100
CENTROID Y	0.018
POA TO CENTROID in	0.102
MIN RADIUS	0.451
MEAN RADIUS	1.098
MAX RADIUS	1.606
HORIZONTAL SPREAD	2.931
VERTICAL SPREAD	2.362
EXTREME SPREAD	3.026
NUMBER IN ONE INCH CIRCLE =	1
NUMBER IN TWO INCH CIRCLE =	3
NUMBER IN THREE INCH CIRCLE =	8

15 May 1990

FILE://PATTERNING/CENTERFIRE_PATT/06349024

CENTERFIRE PATTERNS

4

POA

1 in circle

2 in circle

3 in circle

OF SHOTS = 10

IN CIR

1 in = 1

2 in = 5

3 in = 9

HS = 2.368

VS = 2.507

CS = 2.824

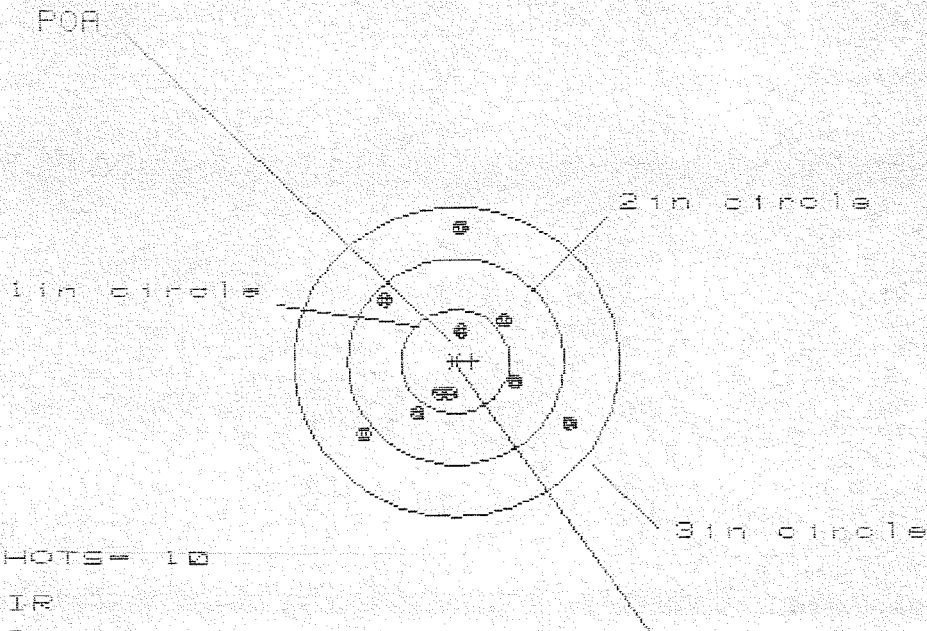
CENTROID #

PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.313	1.195	1.211
MINIMUM X	-1.056	-1.096	-1.088
MAXIMUM Y	1.426	1.306	.779
MINIMUM Y	-1.081	-1.046	-.082
CENTROID X	-.063	.054	.038
CENTROID Y	-.063	.057	-.107
POA TO CENTROID in.	.090	.078	.113
MIN RADIUS	.177	.274	.287
MEAN RADIUS	.983	.934	.868
MAX RADIUS	1.510	1.313	1.268
HORIZONTAL SPREAD	2.368	2.291	2.291
VERTICAL SPREAD	2.507	2.352	1.661
EXTREME SPREAD	2.824	2.411	2.294
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	9		

15 May 1998

FILE:/PATTERNING/CENTERFIRE_PATT/06349024

CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1 in = 3

2 in = 7

3 in = 10

HS= 1.863

VS= 2.021

CS= 2.218

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.004	1.010	.668
MINIMUM X	:	-.859	-.853	-.727
MAXIMUM Y	:	1.306	.708	.656
MINIMUM Y	:	-.714	-.569	-.621
CENTROID X	:	-.146	-.152	-.278
CENTROID Y	:	-.002	-.147	-.095
POA TO CENTROID in.:	:	.146	.211	.294
MIN RADIUS	:	.269	.129	.100
MEAN RADIUS	:	.723	.634	.576
MAX RADIUS	:	1.308	1.090	.956
HORIZONTAL SPREAD	:	1.863	1.063	1.395
VERTICAL SPREAD	:	2.021	1.277	1.277
EXTREME SPREAD	:	2.218	2.002	1.712
NUMBER IN ONE INCH CIRCLE =	:		3	
NUMBER IN TWO INCH CIRCLE =	:		7	
NUMBER IN THREE INCH CIRCLE =	:		10	