

C6349034

MODEL 700TM M24

Model **SMS** TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

Remington®

Model 700™ H24

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

REMINGTON-UMC
REG. U.S. PAT. & TM. OFF.

SERIAL NO.
C6349034

ORDER NO.
5716

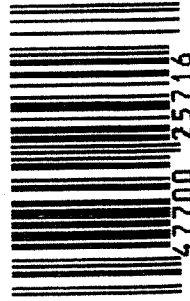
Ø1

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

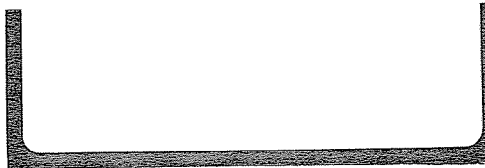


5716 C6349034

UPC



0 47700 25716 7



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: **RE00112534** Serial: C6349034 Model M24 SWS Center Fire
 Verify Repair Caliber: 7.62 NATO Produced: 03/19/1990 Repairman: Status: Closed 5/18/2006 9:46:42 AM

Address Information

Customer: ☒ Received From Return To: ☐ Received From

Name: **225TH BSB (SSA)** **225TH BSB (SSA)**

Address 1: **ATTN CW3 FUJIHARA (808-655-0211)** **ATTN CW3 FUJIHARA (808-655-0211)**

Address 2: **BLDG 1670 MELICHAMP ST.** PO Box: **BLDG 1670 MELICHAMP ST.** PO Box:

City: **SCHOFIELD BARRACKS** **SCHOFIELD BARRACKS**

State: **HI** Zip Code: **96857** Country: **US** State: **HI** Zip Code: **96857** 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
A010	Hard Case	1
C000	FRONT BASE	1

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

naglet 5/23/2006 7:21 AM C4PS NUM INS SCRL

start 2 Mic... Microsof... 2 Inter... Part Sea... Arms Se... 7:21 AM

Serial Number: **C6349034**

Model: **M24 SWS**



RE00112534

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6349034.___0
FILE DATE AND TIME: 11/13/2006 23:12

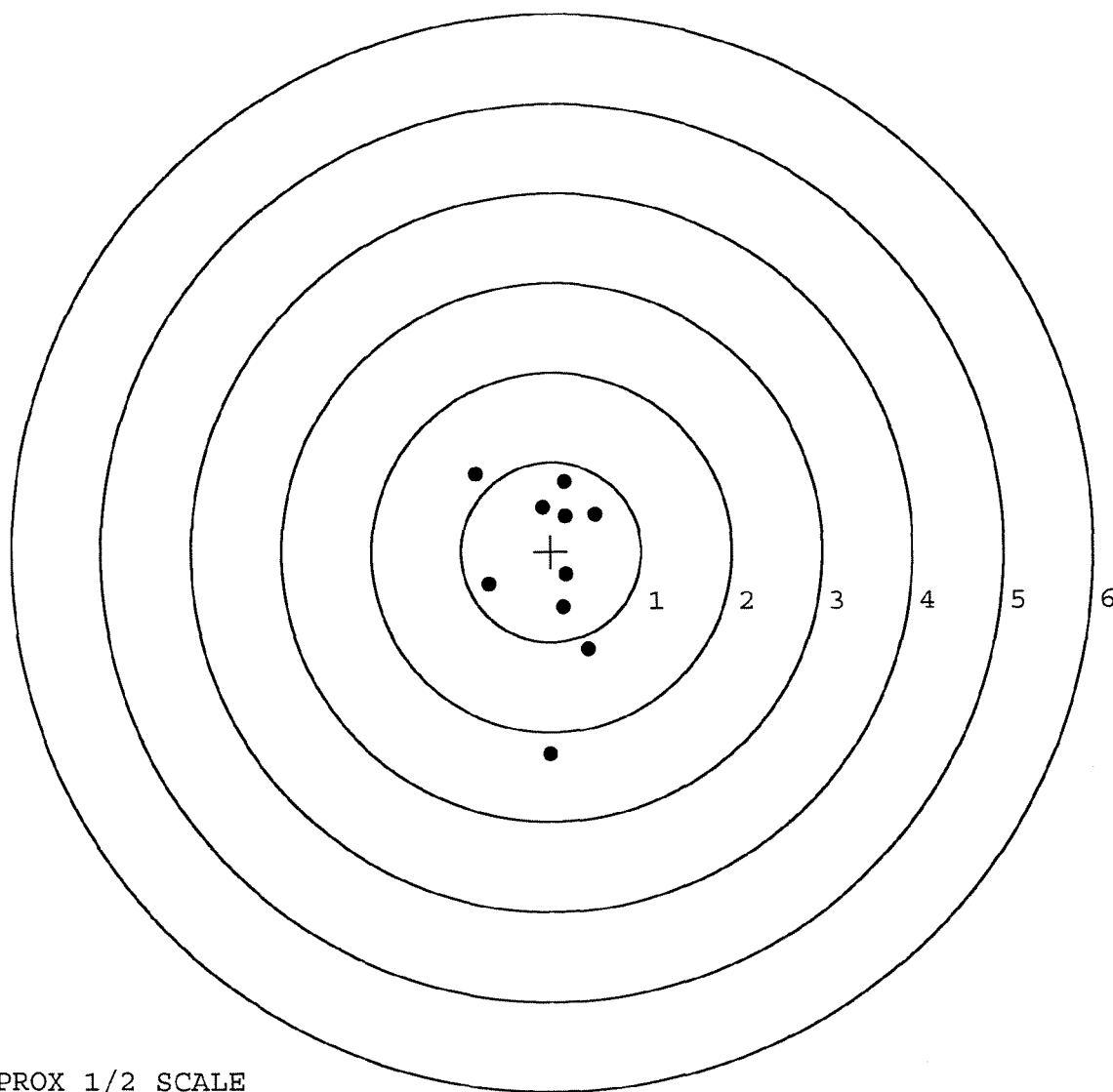
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.156
The Average Y Centroid of the Five Target Set:	-0.120
The Average Point of Impact of the Five Target Set:	0.197
The Average Mean Radius of the Five Target Set:	0.659
The Distance from POA to Centroid Target #1:	0.164
The Distance from Centroid Target #2 to Centroid Target #1:	0.232
The Distance from Centroid Target #3 to Centroid Target #1:	0.248
The Distance from Centroid Target #4 to Centroid Target #1:	0.310
The Distance from Centroid Target #5 to Centroid Target #1:	0.104

SERIAL NUMBER: C6349034. __0
TARGET NUMBER: 1
FILE DATE: 11/13/2006
FILE TIME: 23:12

X CENTROID: -0.011
Y CENTROID: -0.164
POA TO CENTROID: 0.164
HORZ SPREAD: 1.327
VERT SPREAD: 3.121
GROUP SPREAD: 3.229
MIN RADIUS: 0.206
MAX RADIUS: 2.090
MEAN RADIUS: 0.877
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 9

POINT#	X	Y
1:	-0.837	0.867
2:	-0.095	0.490
3:	0.153	0.776
4:	0.156	0.390
5:	0.490	0.419
6:	-0.687	-0.362
7:	0.170	-0.263
8:	0.137	-0.621
9:	0.418	-1.080
10:	-0.010	-2.254

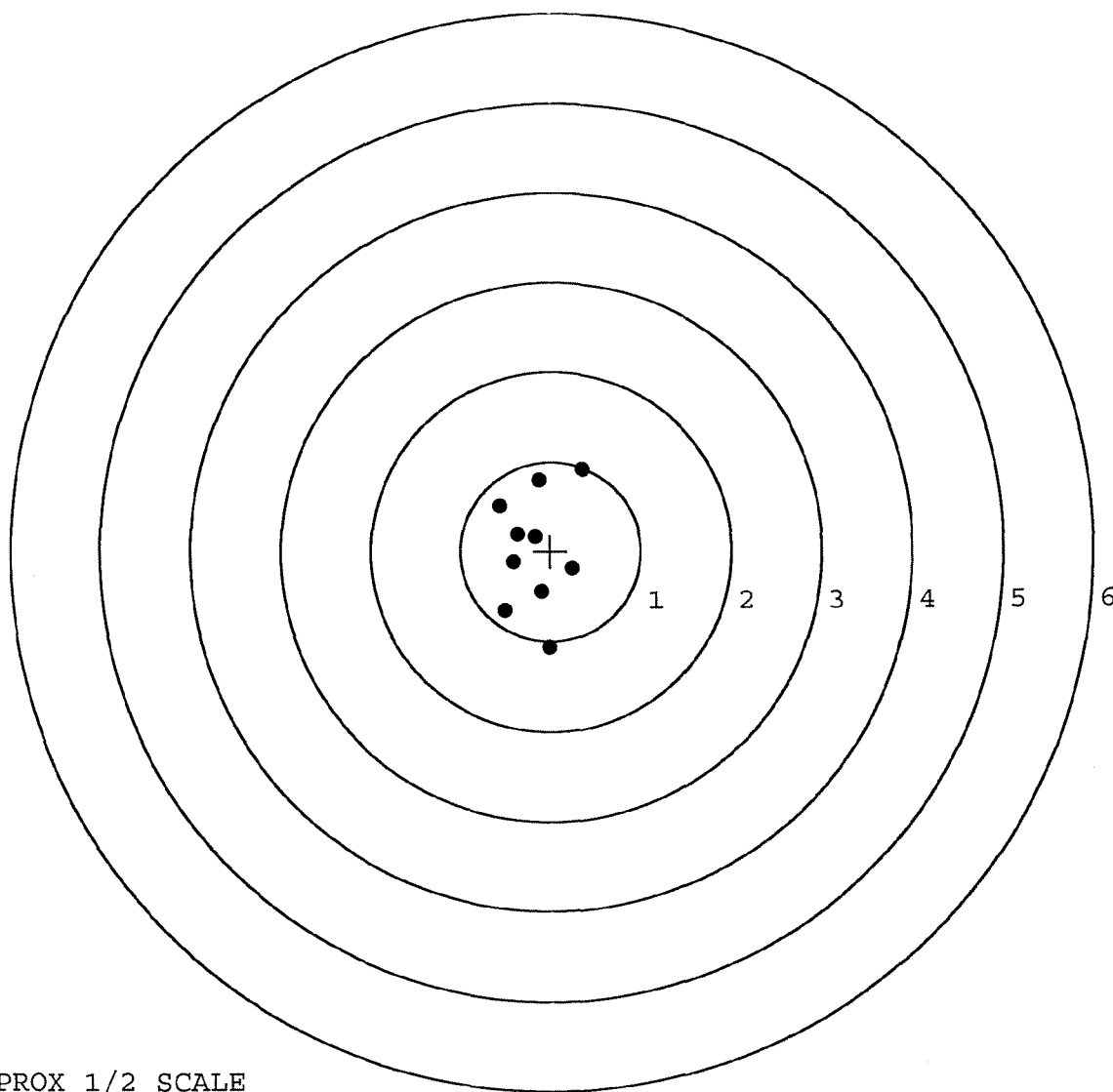


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6349034. __0
TARGET NUMBER: 2
FILE DATE: 11/13/2006
FILE TIME: 23:12

X CENTROID: -0.168
Y CENTROID: 0.006
POA TO CENTROID: 0.168
HORZ SPREAD: 0.919
VERT SPREAD: 1.991
GROUP SPREAD: 2.026
MIN RADIUS: 0.160
MAX RADIUS: 1.093
MEAN RADIUS: 0.597
IN 1 IN DIAMETER: 5
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.354	0.914
2:	-0.132	0.798
3:	-0.019	-1.077
4:	-0.513	-0.664
5:	-0.102	-0.458
6:	0.243	-0.200
7:	-0.168	0.166
8:	-0.413	-0.125
9:	-0.365	0.192
10:	-0.565	0.513

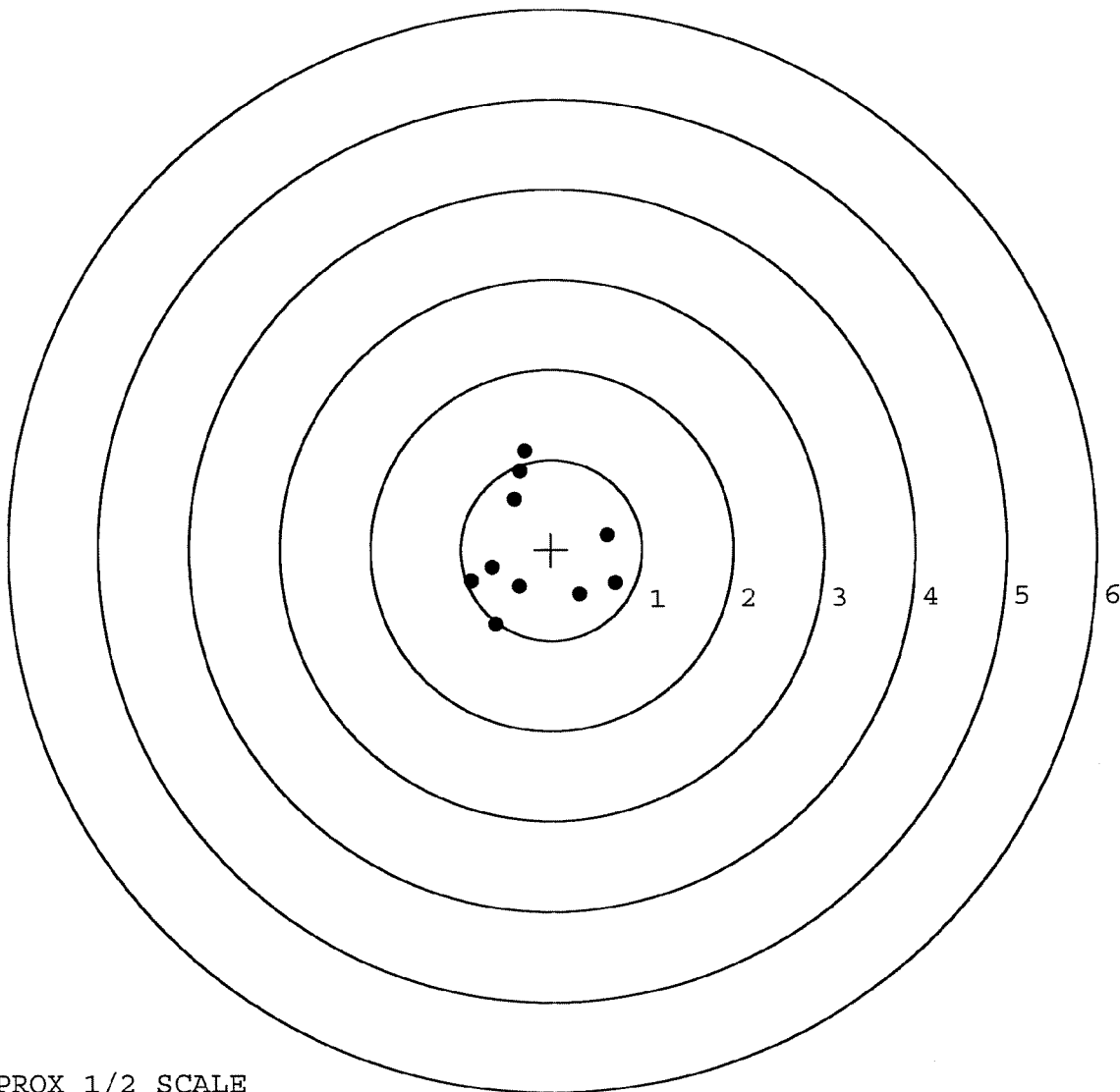


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6349034. __0
TARGET NUMBER: 3
FILE DATE: 11/13/2006
FILE TIME: 23:12

POINT#	X	Y
1:	-0.291	1.097
2:	-0.343	0.874
3:	-0.400	0.566
4:	-0.892	-0.341
5:	-0.654	-0.199
6:	-0.359	-0.409
7:	-0.621	-0.826
8:	0.312	-0.496
9:	0.706	-0.380
10:	0.618	0.159

X CENTROID: -0.192
Y CENTROID: 0.005
POA TO CENTROID: 0.192
HORZ SPREAD: 1.598
VERT SPREAD: 1.923
GROUP SPREAD: 1.951
MIN RADIUS: 0.446
MAX RADIUS: 1.097
MEAN RADIUS: 0.776
IN 1 IN DIAMETER: 1
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

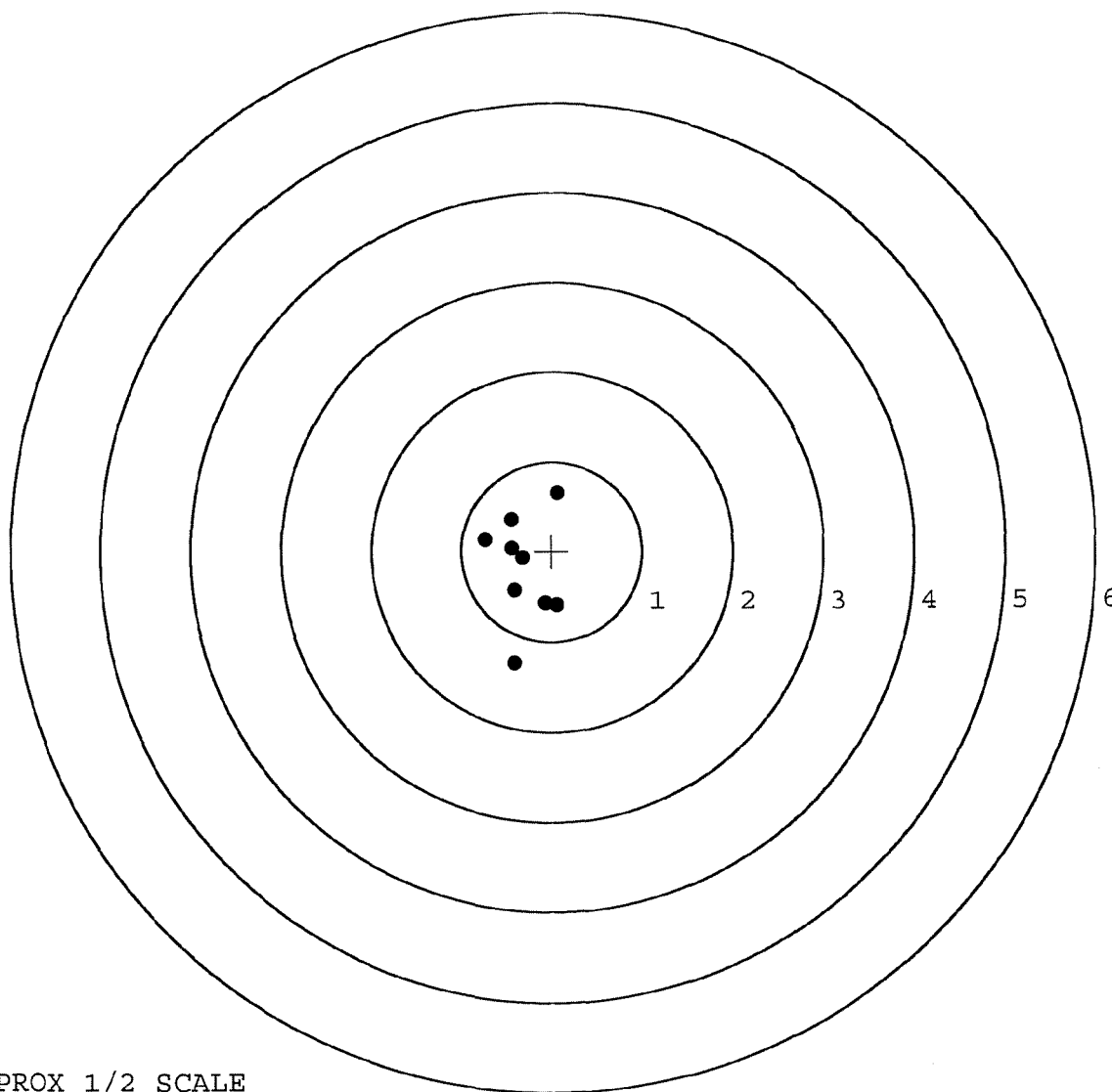


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6349034. 0
TARGET NUMBER: 4
FILE DATE: 11/13/2006
FILE TIME: 23:12

X CENTROID: -0.316
Y CENTROID: -0.219
POA TO CENTROID: 0.384
HORZ SPREAD: 0.802
VERT SPREAD: 1.888
GROUP SPREAD: 1.948
MIN RADIUS: 0.142
MAX RADIUS: 1.022
MEAN RADIUS: 0.500
IN 1 IN DIAMETER: 5
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.065	0.652
2:	-0.451	0.355
3:	-0.737	0.136
4:	-0.446	0.039
5:	-0.326	-0.077
6:	-0.415	-0.439
7:	-0.415	-0.439
8:	-0.074	-0.581
9:	0.056	-0.601
10:	-0.415	-1.236



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6349034. 0

TARGET NUMBER: 5

FILE DATE: 11/13/2006

FILE TIME: 23:12

X CENTROID: -0.091

Y CENTROID: -0.230

POA TO CENTROID: 0.247

HORZ SPREAD: 1.448

VERT SPREAD: 1.813

GROUP SPREAD: 1.923

MIN RADIUS: 0.111

MAX RADIUS: 1.098

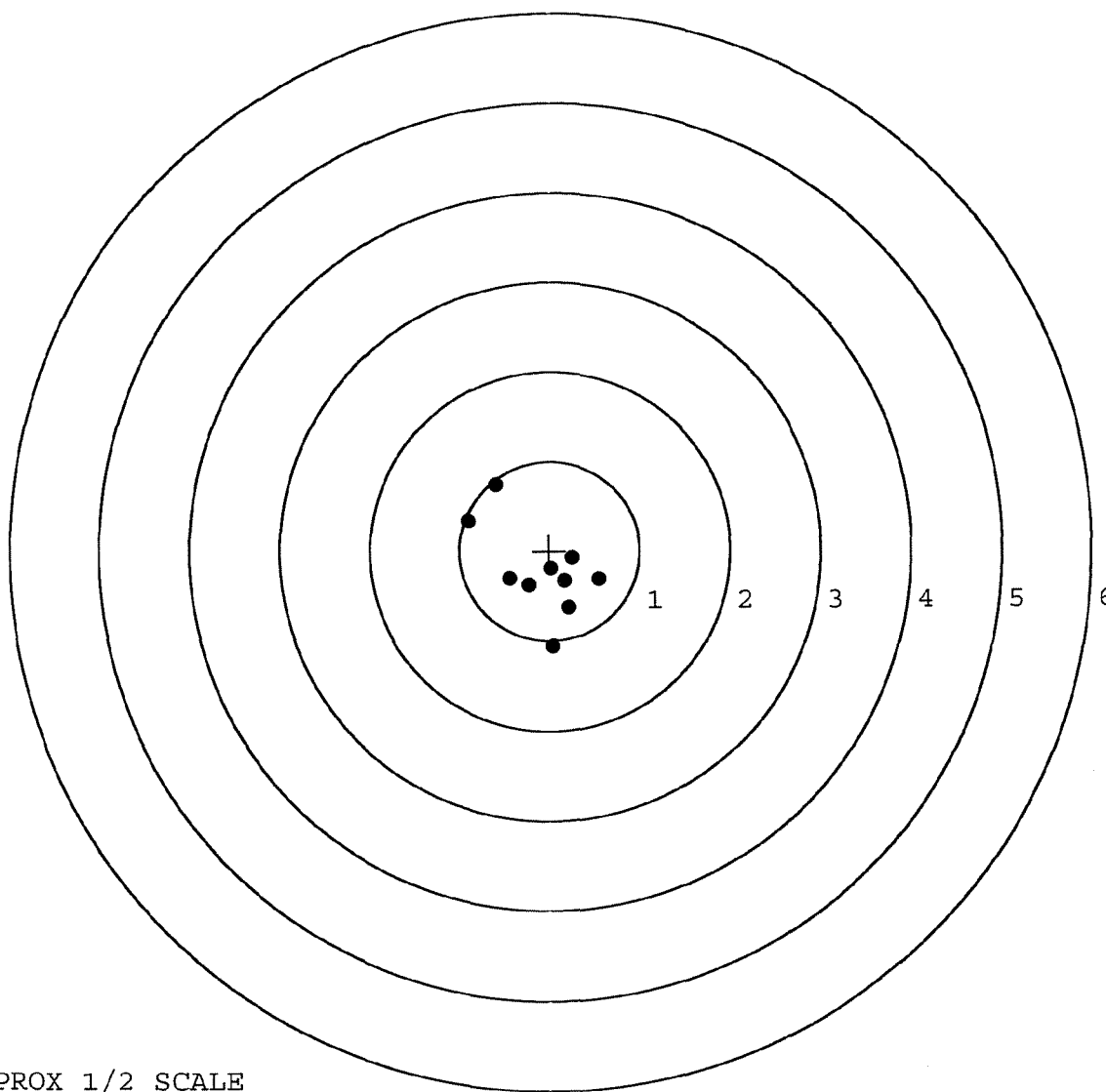
MEAN RADIUS: 0.545

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.901	0.334
2:	-0.595	0.746
3:	-0.442	-0.320
4:	-0.230	-0.391
5:	0.017	-0.205
6:	0.258	-0.085
7:	0.547	-0.323
8:	0.219	-0.645
9:	0.046	-1.067
10:	0.171	-0.343



TARGET APPROX 1/2 SCALE

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 5-5-06

TESTER R.P.

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	260	243		244	
PULL #2	251	257		252	
PULL #3	244	253		256	
PULL #4	249	243		247	
PULL #5	242	249		254	
TOTAL	1246	1245		1253	
AVERAGE	249	249		250	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	304	320		
PULL #2	305	317		
PULL #3	314	316		
PULL #4	300	308		
PULL #5	305	299		
TOTAL	1528	1560		
AVERAGE	305	312		

	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	404	413		410
PULL #2	400	409		398
PULL #3	393	391		400
PULL #4	395	400		398
PULL #5	392	395		401
TOTAL	1984	2008		2007
AVERAGE	396	401		401

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

R & E NUMBER	112534			
SERIAL NUMBER	06349034			
LOG-IN DATE	5-18-06			
OPERATION #	OPERATION NAME	DATE	INITIAL	
500	DIS-ASSEMBLE GUN	5-23-06	RTZ	
505	RE-BARREL	5-26-06	RTZ	
560	ASSEMBLE	5-30-06	RTZ	
600	PROOF	5-30-06	TRW	
605	CHECK HEADSPACE	5-30-06	TRW	
610	DIS-ASSEMBLE GUN	6-1-06	RTZ	
612	MAGNAFLUX	6-2-06	APD	
510	DRILL AND TAP	6-1-06	TRW	
615	ROLLMARK CALIBER	6-2-06	CW	
618	ROTO-BLAST	6-2-06	LB	
620	APPLY COATINGS	6-5-06	PB	
625	FINAL ASSEMBLY	6-7-06	RTZ	
640	FUNCTION TEST AND	11-11-06	RTZ	
650	TARGET	11-13-06	TRW	
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
670	FINAL INSPECTION	11-13-06	SAK	
	A) HEADSPACE	11-15-06	RTZ	
	B) TRIGGER PULL	11-14-06	RTZ	
680	F) SAFETY ON FORCE	11-14-06	RTZ	
	G) SAFETY OFF FORCE	11-14-06	RTZ	
	I) FIRING PIN INDENT	11-14-06	RTZ	
690	PACK	11-15-06	RTZ	

RC-12
replaced

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6349034

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	12-20	89	RW
600	Proof	12-20	89	A
607	Check Headspace	12-20	89	A
610	Dis-assemble Gun	12-20	89	RW
612	Magnaflux Barrel Action	1-5-90		KAR
	Magnaflux Bolt	1-5-90		
615	Rollmark Caliber		1/3/90	JS
17	Drill and Tap Sight Holes		1/8/90	FB
618	Polish Barrel ROB		1/9/90	WB
620	Apply Coatings (Barrel Action)		1-15-90	TS
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		1/17/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		1/17/90	RW
	C) Inspect Ejector Hole for Chamfer		1/17/90	RW
	D) Oil Firing Pin Ass'y		1/17/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		2/2/90	JS

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			1-22-90	JS
	G) Safety Off Force	4	4	4			1-22-90	JS
	H) Trigger Pull Test & Retainability						2/12/90	JS
	I) Firing Pin Indent	.020	.020	.020			1-22-90	JS
	J) Assemble Stock						1/23/90	RW
	K) Assemble Swivel Studs						3/12/90	WB
	L) Attach Front and Rear Sight Assemblies						1/26/90	RW
	M) Iron Sight Alignment						1/26/90	RW
	N) Detach Front & Rear Sights & place in numbered container						1/26/90	RW
	O) Attach Scope to Rifle						3/5/90	WB
	P) Detach & Attach Scope 20 Times						3/5/90	WB
640	Gallery Target & Test						3/6/90	JS Temp. Help
	A) Time							
	B) Malfunctions							
	C) Pierced Primers							
	D) Optical Clarity of Scope							
645	Inspect for Live Ammo							
655	Final Inspection						3/12/90	WB
	A) Headspace							
	B) Trigger Pull	2.73	2.71	2.83	2.86	2.86	3/12/90	G.S.
	C) Function						3/12/90	WB
660	Pack						20 Mar 90	JS

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50#+ .50#

3.00#+ .75#

4.00#+1.00#

SERIAL NO. C6349034

DATE 22 Jan 90

TESTER JSS

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	229	262	207	273	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	230	250	204	271	
PULL #3	228	239	225	283	
PULL #4	225	242	227	286	
PULL #5	222	237	228	286	
TOTAL	1134	1230	1092		
AVG.	2.268	2.46	2.184		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	325	298		
PULL #2	327	309		
PULL #3	320	304		
PULL #4	319	303		
PULL #5	323	303		
TOTAL	1614	1508		
AVG.	3.228	3.016		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	400	380		3.99
PULL #2	394	391		3.94
PULL #3	403	396		3.91
PULL #4	394	387		3.88
PULL #5	394	386		3.94
TOTAL	1985	1946		19.66
AVG.	3.97	3.892		3.932

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06349034
6 Mar 1990

CENTROIDAL DISTANCES

0 TO	1	.452354
1 TO	2	.771421
1 TO	3	1.1793
1 TO	4	1.25648
1 TO	5	.827539

$\bar{x}_T$ -----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.351
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0424
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .353553
THE AMR FOR THIS RIFLE IS: 1.031

6 Mar 1998

FILE:/PATTERNING/CENTERFIRE_PATT/060490034

CENTERFIRE PATTERNS

1

POB

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 3

2in = 4

3in = 7

HS= 2.394

VS= 3.124

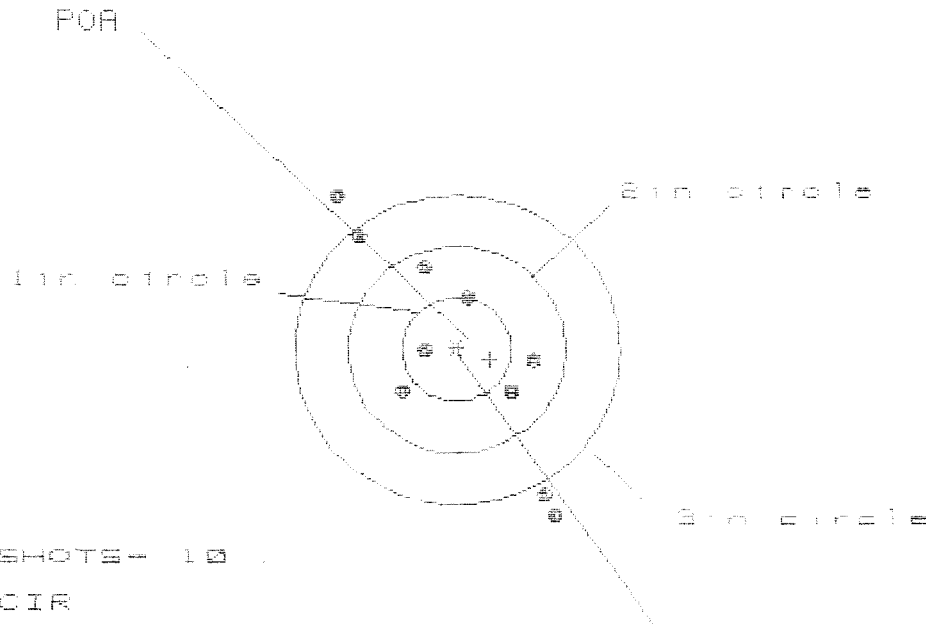
GS= 3.809

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.378	1.075	.967
MINIMUM X	:	-1.018	-.865	-.787
MAXIMUM Y	:	1.572	1.417	1.157
MINIMUM Y	:	-1.552	-1.707	-1.530
CENTROID X	:	.420	.267	.375
CENTROID Y	:	-.168	-.013	-.190
POB TO CENTROID in.	:	.452	.267	.420
MIN RADIUS	:	.240	.240	.189
MEAN RADIUS	:	1.056	.934	.833
MAX RADIUS	:	1.957	1.708	1.539
HORIZONTAL SPREAD	:	2.394	1.940	1.754
VERTICAL SPREAD	:	3.124	3.124	2.687
EXTREME SPREAD	:	3.809	3.227	2.707
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		7	

6 Mar 1998

FILE:/PATTERNING/CENTERFIRE_PATT/08349034

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 2

2in = 6

3in = 7

HS= 2.013

VS= 3.132

GS= 3.723

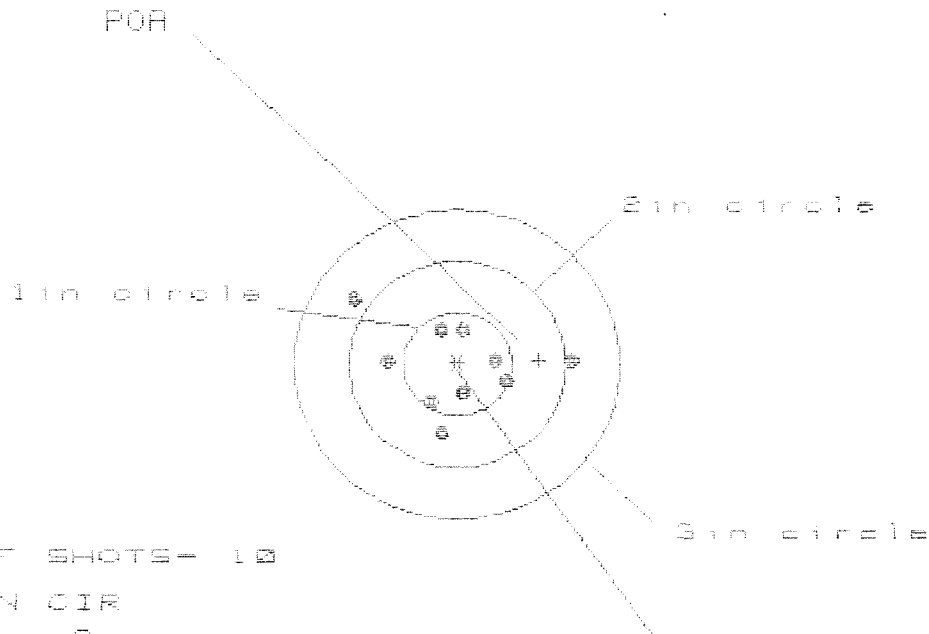
CENTROID +

PATTERN #	2	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.948	.862	.742
MINIMUM X	-1.065	-.960	-.942
MAXIMUM Y	1.494	1.312	1.121
MINIMUM Y	-1.638	-1.632	-1.468
CENTROID X	-.303	-.408	-.298
CENTROID Y	.101	.283	.119
POA TO CENTROID in.	.319	.497	.312
MIN RADIUS	.280	.232	.293
MEAN RADIUS	1.040	.927	.833
MAX RADIUS	1.892	1.846	1.645
HORIZONTAL SPREAD	2.013	1.822	1.684
VERTICAL SPREAD	3.132	2.944	2.589
EXTREME SPREAD	3.723	3.462	3.088
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	7		

8 Mar 1998

FILE:/PATTERNING/CENTERFIRE_PATT/06349004

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 6

2in = 8

3in = 10

HS= 1.989

VS= 1.273

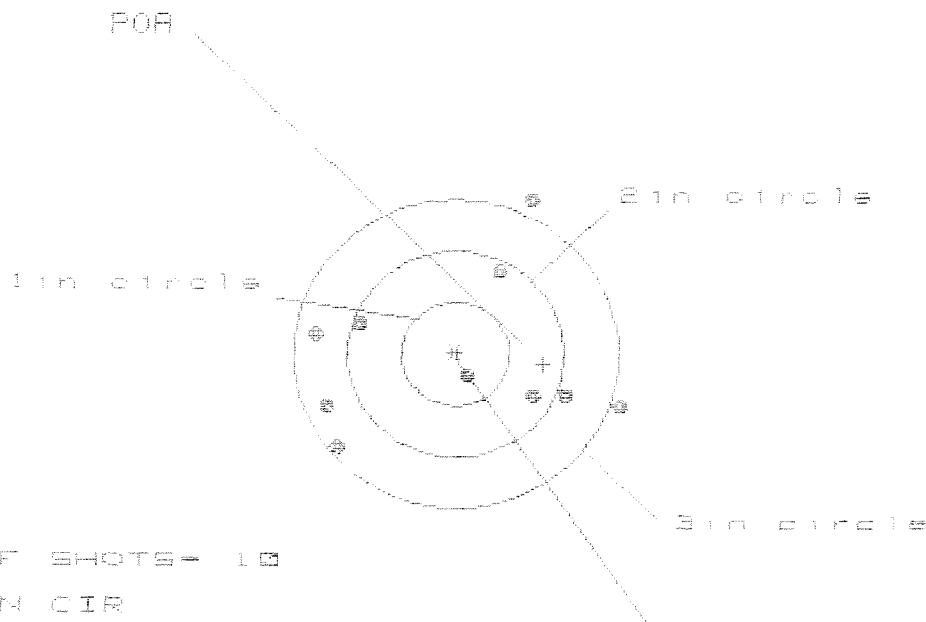
GS= 2.062

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.066	.964	.487
MINIMUM X	:	-.923	-.730	-.610
MAXIMUM Y	:	.595	.435	.450
MINIMUM Y	:	-.678	-.612	-.597
CENTROID X	:	-.752	-.650	-.770
CENTROID Y	:	-.037	-.103	-.118
POA TO CENTROID in.	:	.753	.658	.779
MIN RADIUS	:	.270	.222	.191
MEAN RADIUS	:	.584	.515	.452
MAX RADIUS	:	1.098	.971	.631
HORIZONTAL SPREAD	:	1.989	1.694	1.097
VERTICAL SPREAD	:	1.273	1.047	1.047
EXTREME SPREAD	:	2.062	1.634	1.116
NUMBER IN ONE INCH CIRCLE =			6	
NUMBER IN TWO INCH CIRCLE =			8	
NUMBER IN THREE INCH CIRCLE =			10	

6 Mar 1990

FILE:/PATTERNING/CENTERFIRE_PATT/C8349034

CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 4

3 in = 5

HS= 2.730

VS= 2.442

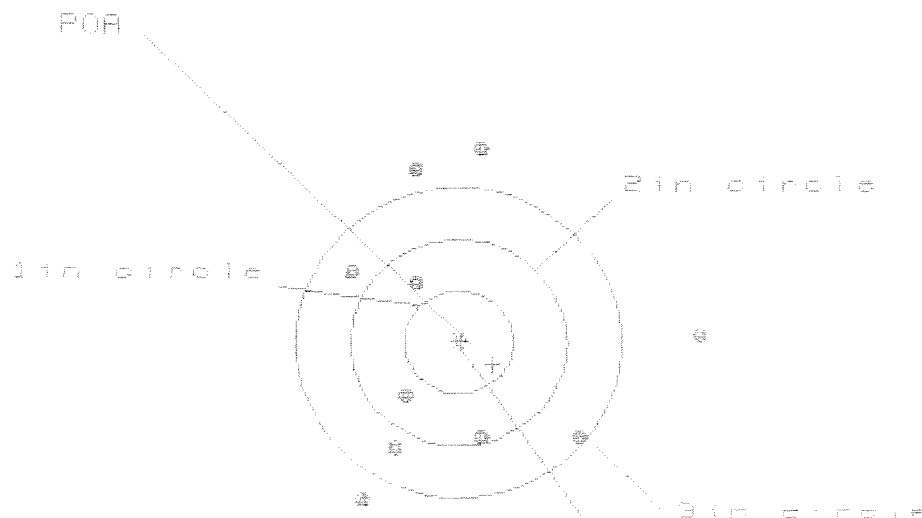
GS= 3.027

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.468	1.540	1.382
MINIMUM X	:	-1.270	-1.190	-0.998
MAXIMUM Y	:	1.542	1.819	.993
MINIMUM Y	:	-.900	-.729	-.765
CENTROID X	:	-.808	-.888	-1.080
CENTROID Y	:	.098	-.073	-.037
POA TO CENTROID in.	:	.814	.891	1.081
MIN RADIUS	:	.286	.164	.359
MEAN RADIUS	:	1.130	1.049	.982
MAX RADIUS	:	1.700	1.567	1.320
HORIZONTAL SPREAD	:	2.730	2.730	2.380
VERTICAL SPREAD	:	2.442	1.748	1.748
EXTREME SPREAD	:	3.027	2.803	2.359
NUMBER IN ONE INCH CIRCLE =			1	
NUMBER IN TWO INCH CIRCLE =			4	
NUMBER IN THREE INCH CIRCLE =			5	

8 Mar 1998

FILE:/PATTERNING/CENTERFIRE_PATT/06349034

CENTERFIRE PATTERNS # 5



OF SHOTS = 12

IN CIR

1in = 0

2in = 3

3in = 6

HE = 3.266

VS = 3.361

GS = 3.537

CENTROID +

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	2.235	1.983	1.408
MINIMUM X	-1.031	-0.782	-0.727
MAXIMUM Y	1.837	1.844	1.914
MINIMUM Y	-1.524	-1.517	-1.287
CENTROID X	-0.312	-0.561	-0.616
CENTROID Y	0.218	0.211	-0.019
POA TO CENTROID (in)	0.381	0.599	0.617
MIN RADIUS	0.695	0.550	0.321
MEAN RADIUS	1.379	1.243	1.118
MAX RADIUS	2.236	1.897	1.918
HORIZONTAL SPREAD	3.266	2.165	2.165
VERTICAL SPREAD	3.361	3.361	3.201
EXTREME SPREAD	3.537	3.537	3.226
NUMBER IN ONE INCH CIRCLE =	0	0	0
NUMBER IN TWO INCH CIRCLE =	0	3	3
NUMBER IN THREE INCH CIRCLE =	0	6	6

For use of this form, see DA PAM 738-750 and 738-751; the proponent agency is DCSLOG

DA FORM 2404
1 APR 79

Replaces edition of 1 Jan 64, which will be used

DATE: 24-FEB-93

MAINTENANCE REQUEST

AWAMF511

CUSTOMER DATA

UIC: WALUAA
UTIL CODE: 0

HHC 1/14TH INF BN

PHONE: (808) 655-9024

ACTIVITY DATA

SUP WDN: 1761
SUP UIC: WH06CO

C CO, 225 FSB

PHONE: 655-2679
SHOP SEC: B

EQUIPMENT DATA

TYPE MNT REQ: 1 ID: 1 NSN: 005012402136 MODEL: M-24 SWS

NOUN: 7.62MM SNIPER SYSTEM SER NUM: C6349034/891169 QTY: 00001

ORG WDN: ALUAA1300748 PRIORITY: 13 FAILURE DETECTED: F

MI/KM: 000000 HOURS: 000000 ROUNDS:

IN WARRANTY: N LEVEL OF WORK: F ADMIN NUM:

MALFUNCTION/REMARKS: BARREL HAS SCRATCHES

PD AUTHENTICATING SIGNATURE:

changed by SGT Thompson
[Signature] TC, B1-10

SIGNATURE DATA

SUBMITTED BY: *[Signature]* ORD DATE: 93075 MIL TIME:

ACCEPTED BY: *[Signature]* STATUS: ORD DATE: 93075 MIL TIME:

ACTION DATA

WORK STARTED BY: *[Signature]* STATUS: B ORD DATE: 93095 MIL TIME:

INSPECTED BY: *[Signature]* STATUS: R ORD DATE: 93095 MIL TIME:

PICKED UP BY: *[Signature]* STATUS: LI ORD DATE: 93097 MIL TIME:

COMPLETION DATA

QTY RPR: QTY CONDEMNED: NRTS:

EVAC WDN: EVAC UNIT NAME:

Scope # 1169

M-24

GFM

CONTRACT # DAAA21-87-C-0086

New Barrel

GUN SERIAL # C6349034

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		5/4/93	RW
600	Proof		5/4/93	RW
607	Check Headspace		5/4/93	RW
610	Dis-assemble Gun		5/4/93	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		5/17/93	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/17/93	RW
	C) Inspect Ejector Hole for Chamfer		5/17/93	RW
	D) Oil Firing Pin Ass'y			
	E) Adjust Trigger Pull to Min Setting and Stake			

op. #	OP. NAME	READINGS				DATE	INIT
625 cont.	F) Safety On Force						
	G) Safety Off Force						
	H) Trigger Pull Test & Retainability						
	I) Firing Pin Indent						
	J) Assemble Stock						
	K) Assemble Swivel Studs						
	L) Attach Front and Rear Sight Assemblies						
	M) Iron Sight Alignment						
	N) Detach Front & Rear Sights & place in numbered container						
	O) Attach Scope to Rifle						
	P) Detach & Attach Scope 20 Times						
	Gallery Target & Test						
	A) Time						
	B) Malfunctions						
	C) Pierced Primers						
	D) Optical Clarity of Scope						
645	Inspect for Live Ammo					5/17/93	RW
655	Final Inspection						
	A) Headspace					5/18/93	RW
	B) Trigger Pull						
	C) Function					5/17/93	RW
660	Pack						

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6349034
21 May 1993

CENTROIDAL DISTANCES

0 TO	1	.876741
1 TO	2	1.11646
1 TO	3	1.4556
1 TO	4	1.36515
1 TO	5	1.01287

$\frac{24}{5}$ <----POA
1

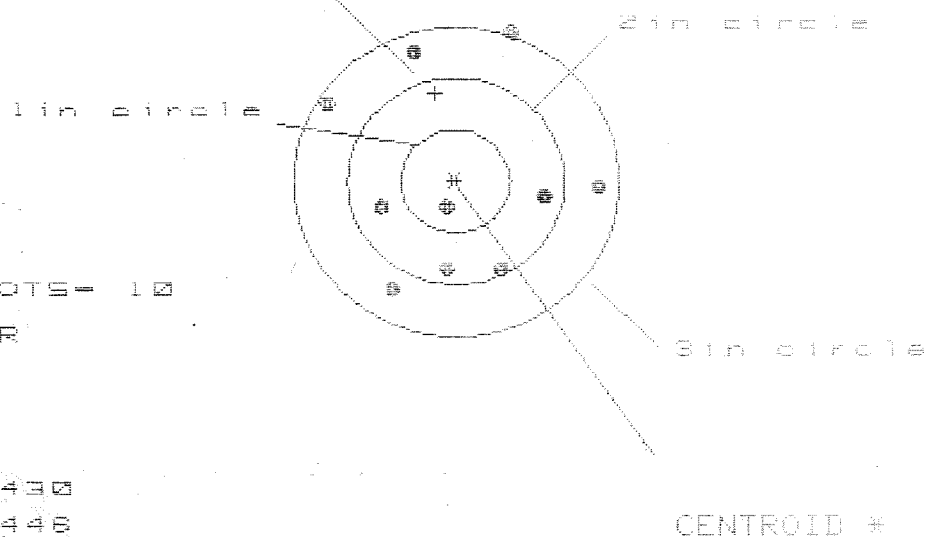
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .082
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1228
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .147661
THE AMR FOR THIS RIFLE IS: .9534

21 May 1993

FILE:/PATTERNING/CENTERFIRE_PATT/C6949034

CENTERFIRE PATTERNS # 1

POA



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 5

3 in = 9

HS= 2.430

VS= 2.446

GS= 2.682

CENTROID *

PATTERN #

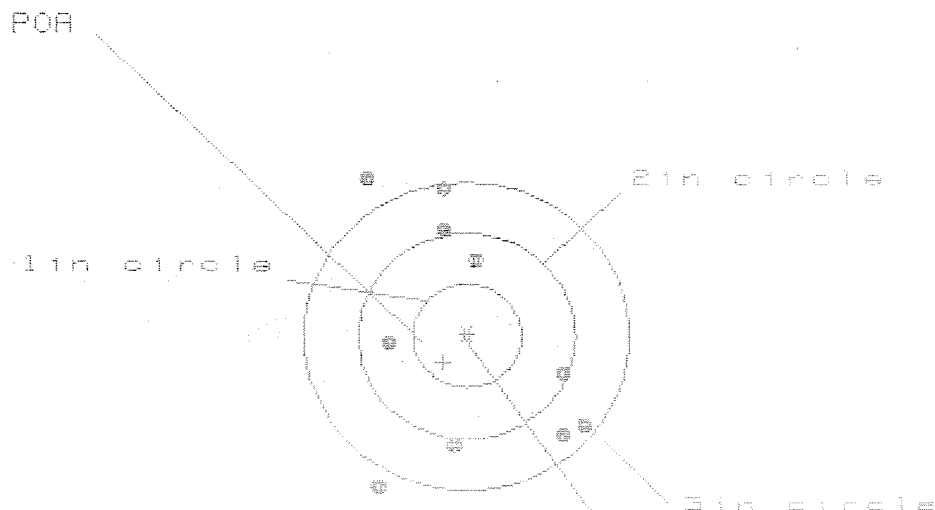
1

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.282	1.306	1.200
MINIMUM X	-1.148	-1.094	-0.748
MAXIMUM Y	1.437	1.428	1.546
MINIMUM Y	-1.009	-0.850	-0.732
CENTROID X	.185	.131	.267
CENTROID Y	-.857	-1.016	-1.134
POA TO CENTROID in.	.876	1.025	1.165
MIN RADIUS	.278	.189	.165
MEAN RADIUS	1.034	.934	.845
MAX RADIUS	1.519	1.475	1.627
HORIZONTAL SPREAD	2.430	2.430	1.948
VERTICAL SPREAD	2.446	2.278	2.278
EXTREME SPREAD	2.682	2.583	2.285
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		9	

21 May 1993

FILE:/PATTERNING/CENTERFIRE_PATT/C6345034

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1in = 0

2in = 3

3in = 8

HS= 2.059

VS= 2.958

GS= 3.136

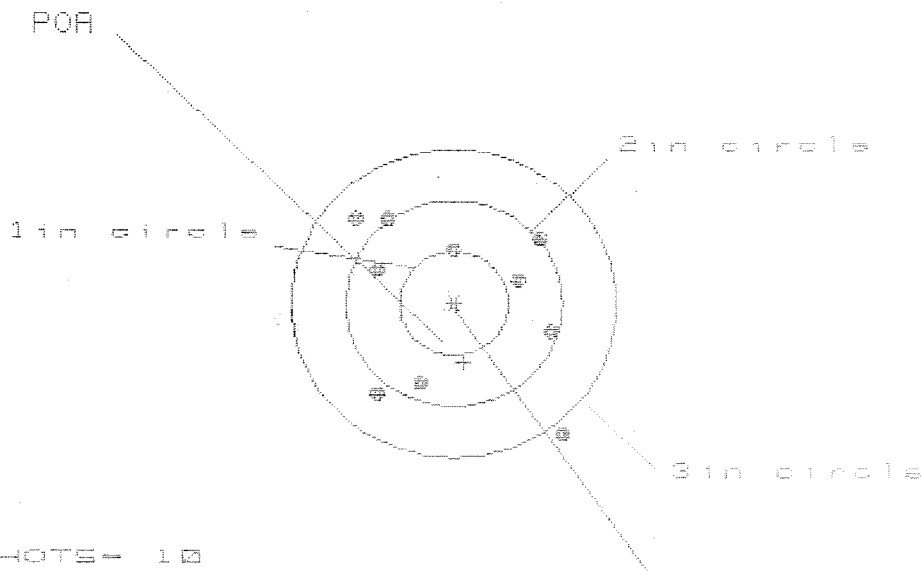
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.126	1.022	.907
MINIMUM X	:	-.933	-.920	-.964
MAXIMUM Y	:	1.530	1.582	1.424
MINIMUM Y	:	-1.428	-1.258	-.997
CENTROID X	:	.217	.321	.436
CENTROID Y	:	.259	.089	.247
POA TO CENTROID in.	:	.338	.333	.501
MIN RADIUS	:	.708	.843	.729
MEAN RADIUS	:	1.220	1.143	1.030
MAX RADIUS	:	1.792	1.621	1.500
HORIZONTAL SPREAD	:	2.059	1.942	1.871
VERTICAL SPREAD	:	2.958	2.840	2.421
EXTREME SPREAD	:	3.136	2.896	2.678
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		8	

21 May 1993

FILE:/PATTERNING/CENTERFIRE_PATT/C8349034

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 0

2 in = 7

3 in = 9

HS= 1.905

VS= 2.082

GS= 2.807

CENTROID X

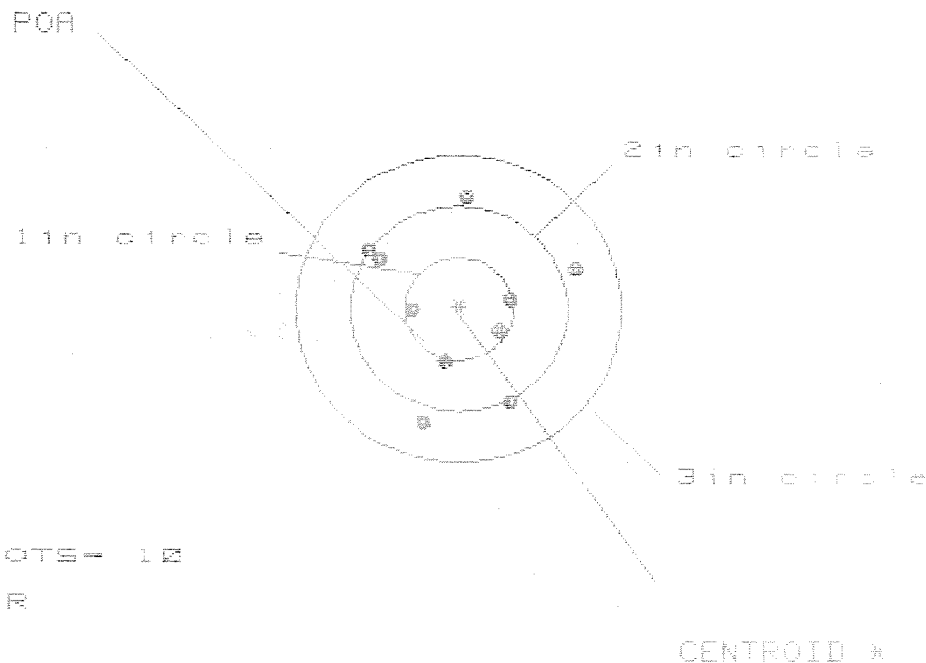
PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.957	1.034	.929
MINIMUM X	-.948	-.842	-.751
MAXIMUM Y	.818	.677	.759
MINIMUM Y	-1.264	-1.014	-.932
CENTROID X	-.092	-.198	-.093
CENTROID Y	.572	.713	.631
POA TO CENTROID in.	.580	.740	.637
MIN RADIUS	.551	.422	.492
MEAN RADIUS	.971	.879	.854
MAX RADIUS	1.585	1.202	1.197
HORIZONTAL SPREAD	1.905	1.876	1.680
VERTICAL SPREAD	2.082	1.691	1.691
EXTREME SPREAD	2.807	2.162	2.134
NUMBER IN ONE INCH CIRCLE =		0	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		9	

21 May 1993

FILE:/PATTERNING/CENTERFIRE_PATT/C6349834

CENTERFIRE PATTERNS

4



OF SHOTS= 10

IN CIR

1in = 3

2in = 6

3in = 10

HS= 1.902

VS= 2.232

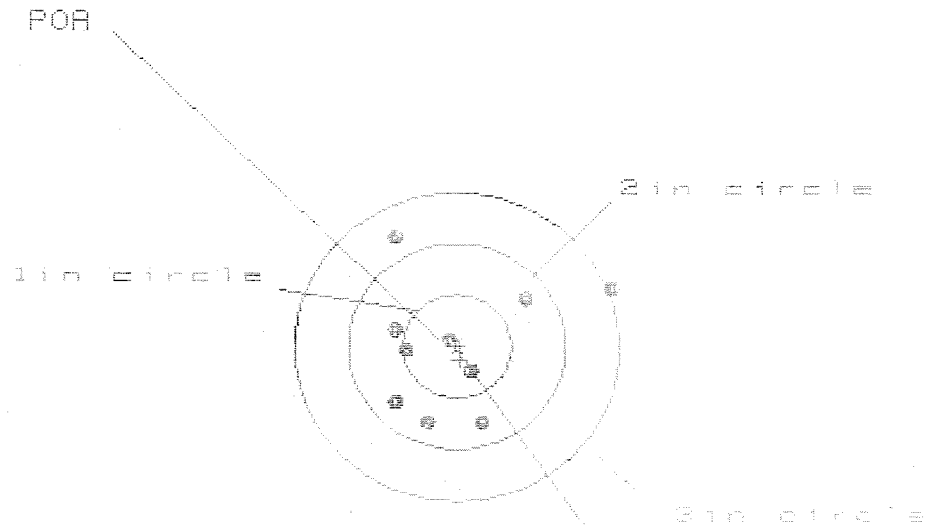
GS= 2.268

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.058	1.024	.599
MINIMUM X	:	-.844	-.878	-.750
MAXIMUM Y	:	1.094	.967	1.002
MINIMUM Y	:	-1.138	-1.003	-.969
CENTROID X	:	.129	.163	.035
CENTROID Y	:	.507	.634	.600
POA TO CENTROID in.	:	.524	.654	.600
MIN RADIUS	:	.382	.428	.385
MEAN RADIUS	:	.815	.776	.729
MAX RADIUS	:	1.177	1.092	1.118
HORIZONTAL SPREAD	:	1.902	1.902	1.349
VERTICAL SPREAD	:	2.232	1.970	1.970
EXTREME SPREAD	:	2.268	2.003	2.003
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	

21 May 1993

FILE:/PATTERNING/CENTERFIRE_PATT/C8949034

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 3

2in = 8

3in = 9

HS= 2.069

VS= 1.822

GS= 2.231

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.452	.799	.742
MINIMUM X	-.617	-.456	-.435
MAXIMUM Y	1.063	1.121	.675
MINIMUM Y	-.759	-.701	-.560
CENTROID X	-.029	-.190	-.133
CENTROID Y	.133	.075	-.066
POA TO CENTROID (in.)	.136	.204	.148
MIN RADIUS	.114	.199	.190
MEAN RADIUS	.727	.610	.523
MAX RADIUS	1.544	1.211	1.003
HORIZONTAL SPREAD	2.069	1.255	1.177
VERTICAL SPREAD	1.822	1.822	1.235
EXTREME SPREAD	2.231	1.990	1.527
NUMBER IN ONE INCH CIRCLE	=	3	
NUMBER IN TWO INCH CIRCLE	=	8	
NUMBER IN THREE INCH CIRCLE	=	9	