

C6349166

MODEL 700TM N24

Model **SMS** TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

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: RE00156489

Serial: C6349166 Model M24 SWS Center Fire
Caliber: 7.62 NATO Produced: 12/13/1989

Repairman:

Status: Closed 12/6/2008 7:41:49 AM

Verify Repair

Address Information

Customer:

☒ Received From

Return To:

☐ Received From

Name: DEPARTMENT OF THE ARMY SUPPLY OFFICER

DEPARTMENT OF THE ARMY SUPPLY OFFICER

Address 1: DOL SISA BLDG 9660 BAY A

DOL SISA BLDG 9660 BAY A

Address 2: BOX 339500 MAIL STOP 181

PO Box:

BOX 339500 MAIL STOP 181

PO Box:

City: FORT LEWIS

FORT LEWIS

State: WA

Zip Code: 98433

Country: US

State: WA

Zip Code: 98433

Country: US

FFL:

Contact / Condition

Problems

Estimate

History / Status

Shipping / Billing

Contact Information

Phone: NN

Fax:

Email:

Comments:

Received Condition

Fair

Condition
Notes:CSR
Notes:

Accessories Received

Code	Desc	Qty
A007	With Stud	2
A010	Hard Case SYS	1
A017	Scoope Base	1
A057	Fit and Rear Sgt Base	1

Repair Search

Refresh

Close

naglej

12/8/2008

12:28 PM

CAPS

NUM

INS

SCRL



12:28 PM

B. Ped

mm ARD

Serial Number:

C6349166

Model: M24 SWS



RE00156489

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6349166.__1
FILE DATE AND TIME: 01/12/2009 08:29

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.045
The Average Y Centroid of the Five Target Set:	-0.165
The Average Point of Impact of the Five Target Set:	0.171
The Average Mean Radius of the Five Target Set:	0.636
The Distance from POA to Centroid Target #1:	0.139
The Distance from Centroid Target #2 to Centroid Target #1:	0.065
The Distance from Centroid Target #3 to Centroid Target #1:	0.140
The Distance from Centroid Target #4 to Centroid Target #1:	0.148
The Distance from Centroid Target #5 to Centroid Target #1:	0.041

REPORTED IN UNITS OF INCHES

SERIAL NUMBER: C6349166. 1

TARGET NUMBER: 1

FILE DATE: 01/12/2009

FILE TIME: 08:29

POINT#	X	Y
1:	-0.358	-0.988
2:	0.554	-1.013
3:	0.021	-0.678
4:	-0.732	0.458
5:	-0.457	0.022
6:	0.368	0.499
7:	0.005	0.156
8:	-0.238	0.486
9:	0.057	0.356
10:	0.034	-0.474

X CENTROID: -0.075

Y CENTROID: -0.118

POA TO CENTROID: 0.139

HORZ SPREAD: 1.286

VERT SPREAD: 1.512

GROUP SPREAD: 1.954

MIN RADIUS: 0.285

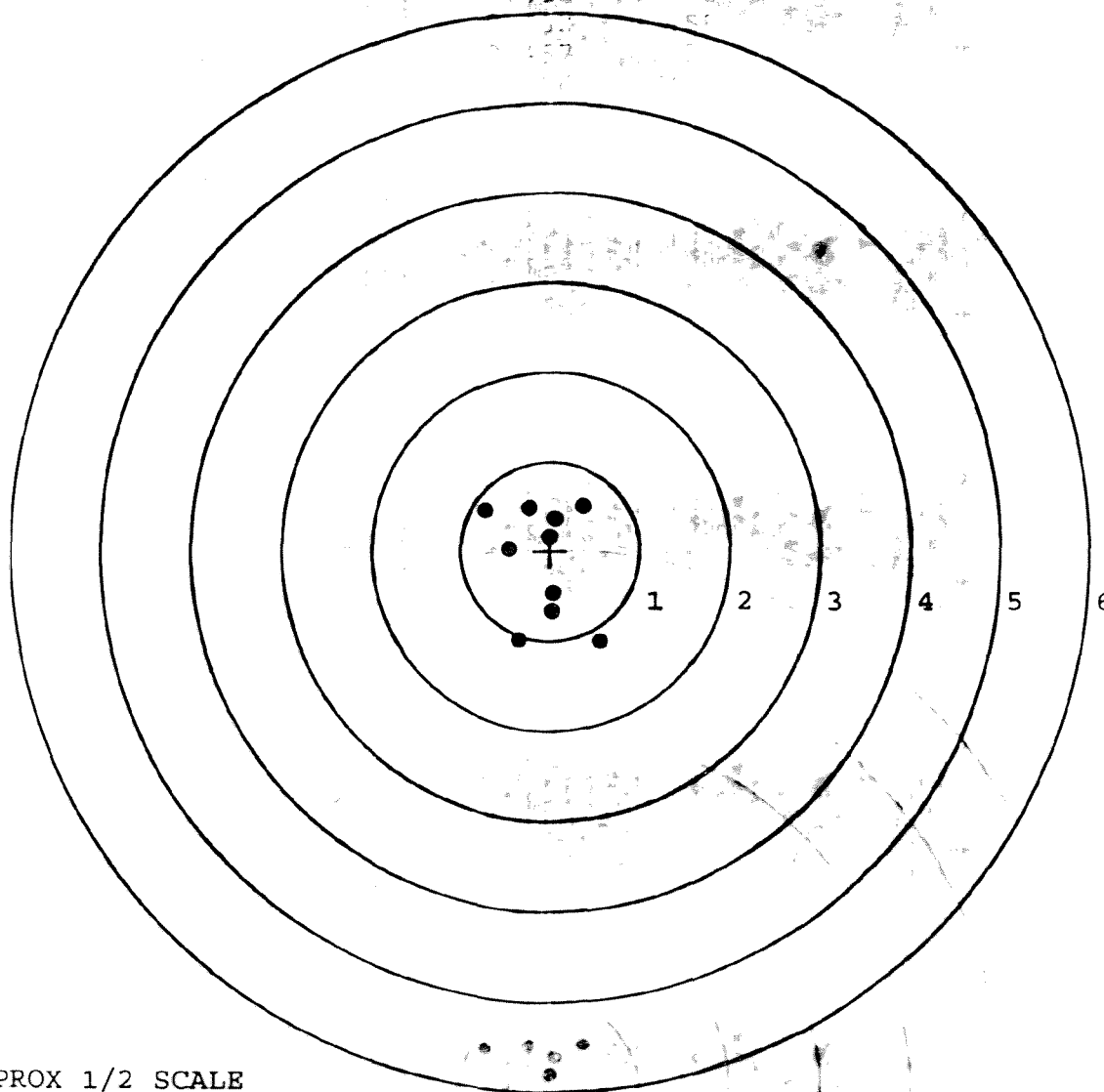
MAX RADIUS: 1.094

MEAN RADIUS: 0.639

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6349166. 1

TARGET NUMBER: 2

FILE DATE: 01/12/2009

FILE TIME: 08:29

POINT# X Y

1: 0.331 0.477

2: 0.576 -0.190

3: 0.205 -0.475

4: 0.010 0.049

5: -0.495 0.448

6: -0.393 0.184

7: -0.388 -0.015

8: -0.203 -0.098

9: -0.329 -0.469

10: 0.137 -1.704

X CENTROID: -0.055

Y CENTROID: -0.179

POA TO CENTROID: 0.188

HORZ SPREAD: 1.071

VERT SPREAD: 2.181

GROUP SPREAD: 2.243

MIN RADIUS: 0.169

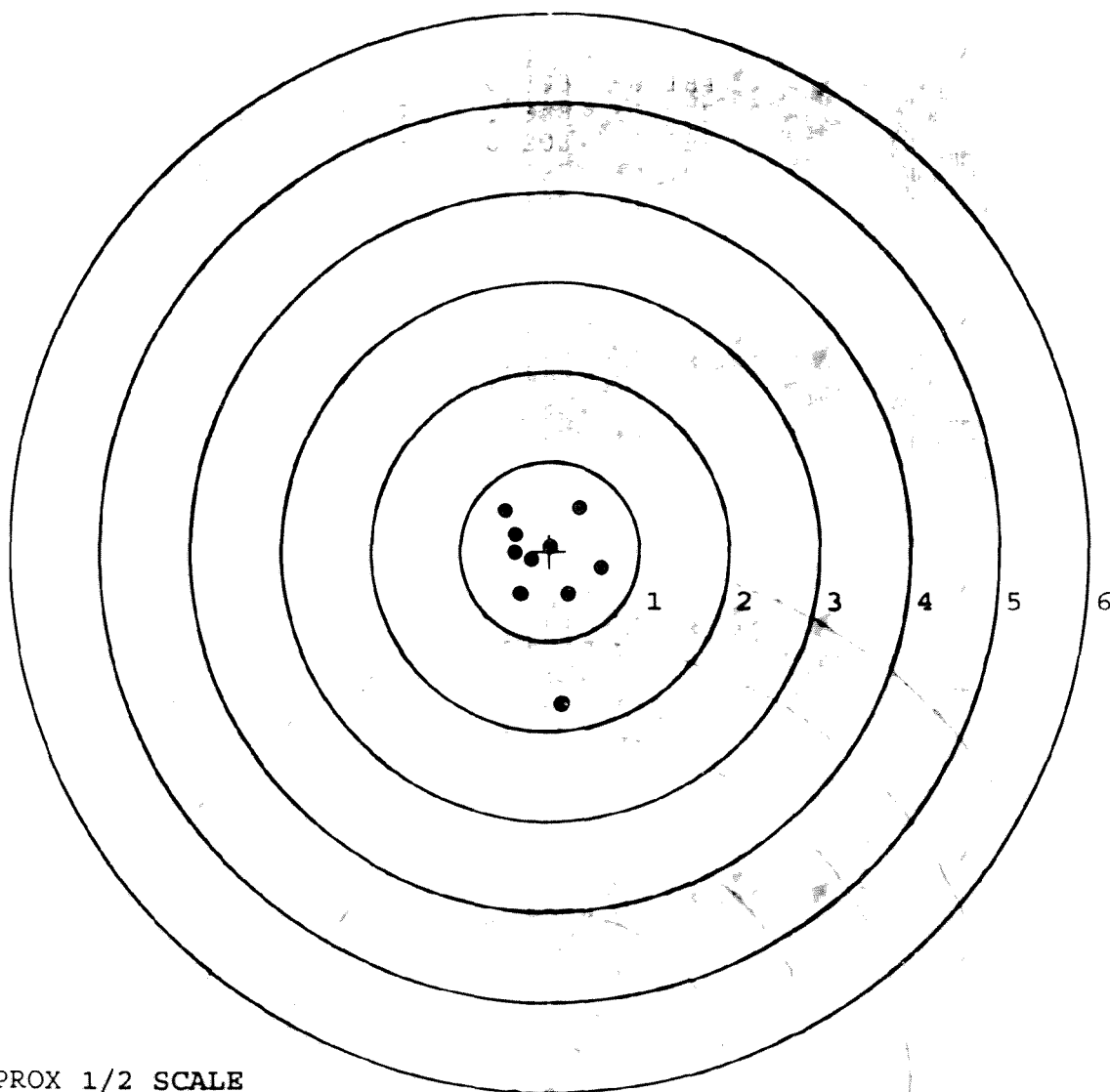
MAX RADIUS: 1.537

MEAN RADIUS: 0.576

IN 1 IN DIAMETER: 6

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6349166. 1

TARGET NUMBER: 3

FILE DATE: 01/12/2009

FILE TIME: 08:29

POINT#	X	Y
1:	-0.136	0.692
2:	-0.108	0.248
3:	-0.377	0.313
4:	-0.317	-0.078
5:	-0.680	-0.585
6:	-0.251	-0.639
7:	1.188	-0.945
8:	0.862	0.112
9:	0.695	-0.139
10:	-0.319	-0.677

X CENTROID: 0.056

Y CENTROID: -0.170

POA TO CENTROID: 0.179

HORZ SPREAD: 1.868

VERT SPREAD: 1.637

GROUP SPREAD: 2.105

MIN RADIUS: 0.384

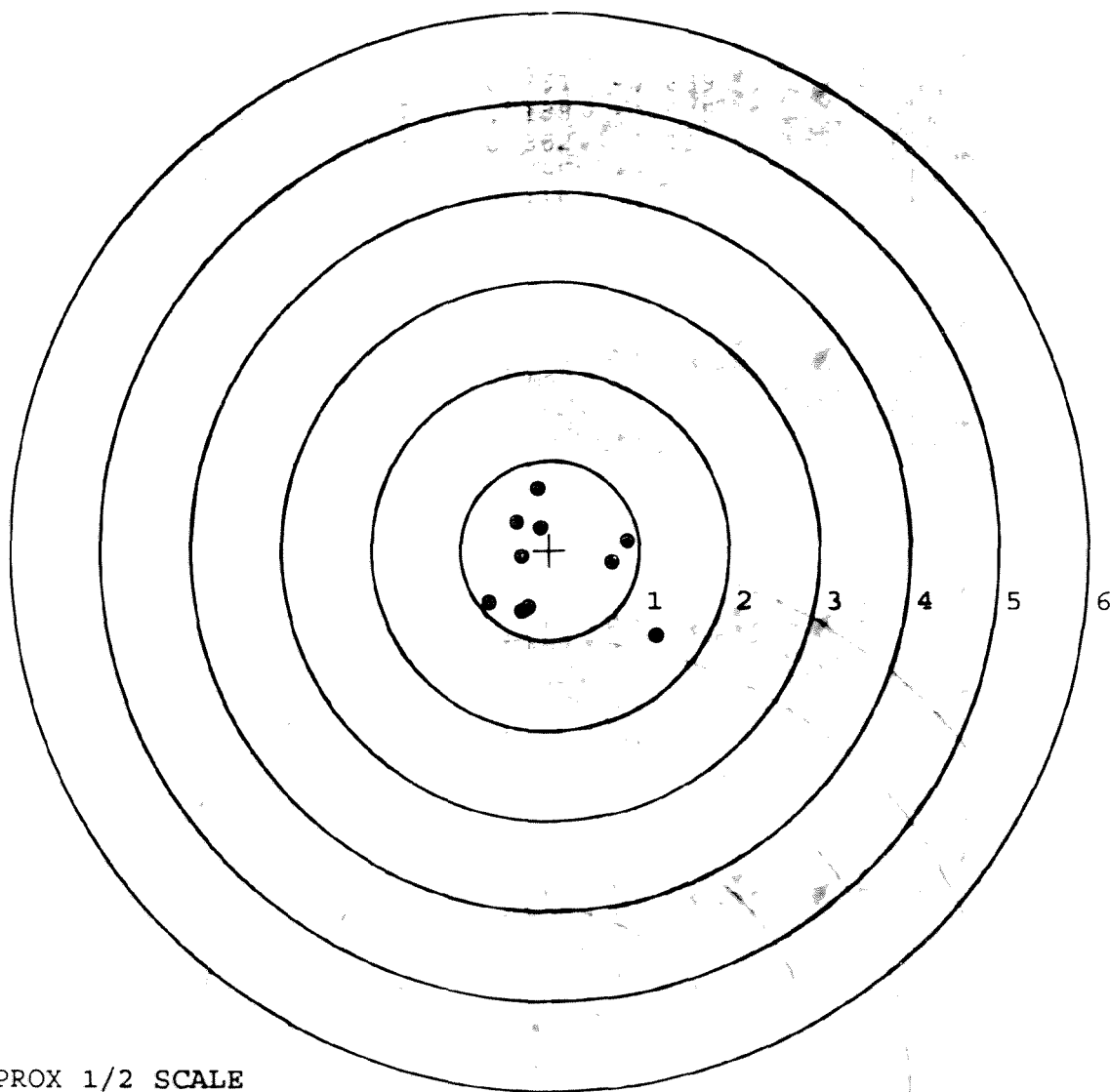
MAX RADIUS: 1.372

MEAN RADIUS: 0.727

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10

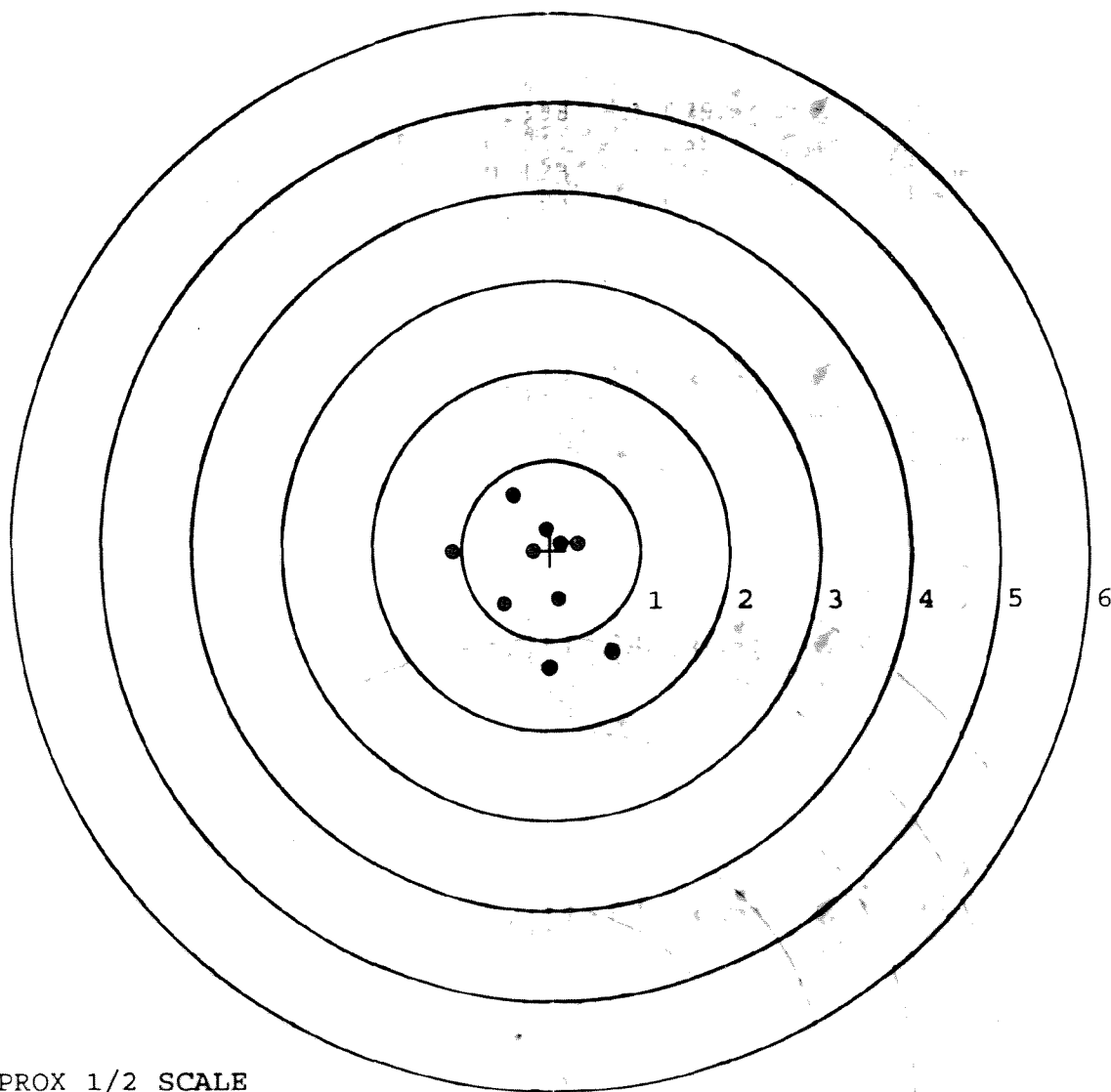


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6349166. _1
TARGET NUMBER: 4
FILE DATE: 01/12/2009
FILE TIME: 08:29

POINT#	X	Y
1:	-0.419	0.617
2:	-1.106	-0.024
3:	-0.532	-0.595
4:	0.087	-0.543
5:	-0.018	-1.311
6:	0.679	-1.131
7:	0.308	0.079
8:	-0.041	0.239
9:	0.123	0.078
10:	-0.193	-0.020

X CENTROID: -0.111
Y CENTROID: -0.261
POA TO CENTROID: 0.284
HORZ SPREAD: 1.785
VERT SPREAD: 1.928
GROUP SPREAD: 2.100
MIN RADIUS: 0.255
MAX RADIUS: 1.175
MEAN RADIUS: 0.678
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6349166. 1

TARGET NUMBER: 5

FILE DATE: 01/12/2009

FILE TIME: 08:29

POINT# X Y

1: 0.438 -0.905

2: -0.006 -0.894

3: -0.335 -0.437

4: -0.351 -0.224

5: 0.572 -0.052

6: 0.117 -0.057

7: 0.059 0.231

8: -0.711 0.516

9: -0.194 0.534

10: 0.012 0.323

X CENTROID: -0.040

Y CENTROID: -0.096

POA TO CENTROID: 0.104

HORZ SPREAD: 1.283

VERT SPREAD: 1.439

GROUP SPREAD: 1.827

MIN RADIUS: 0.162

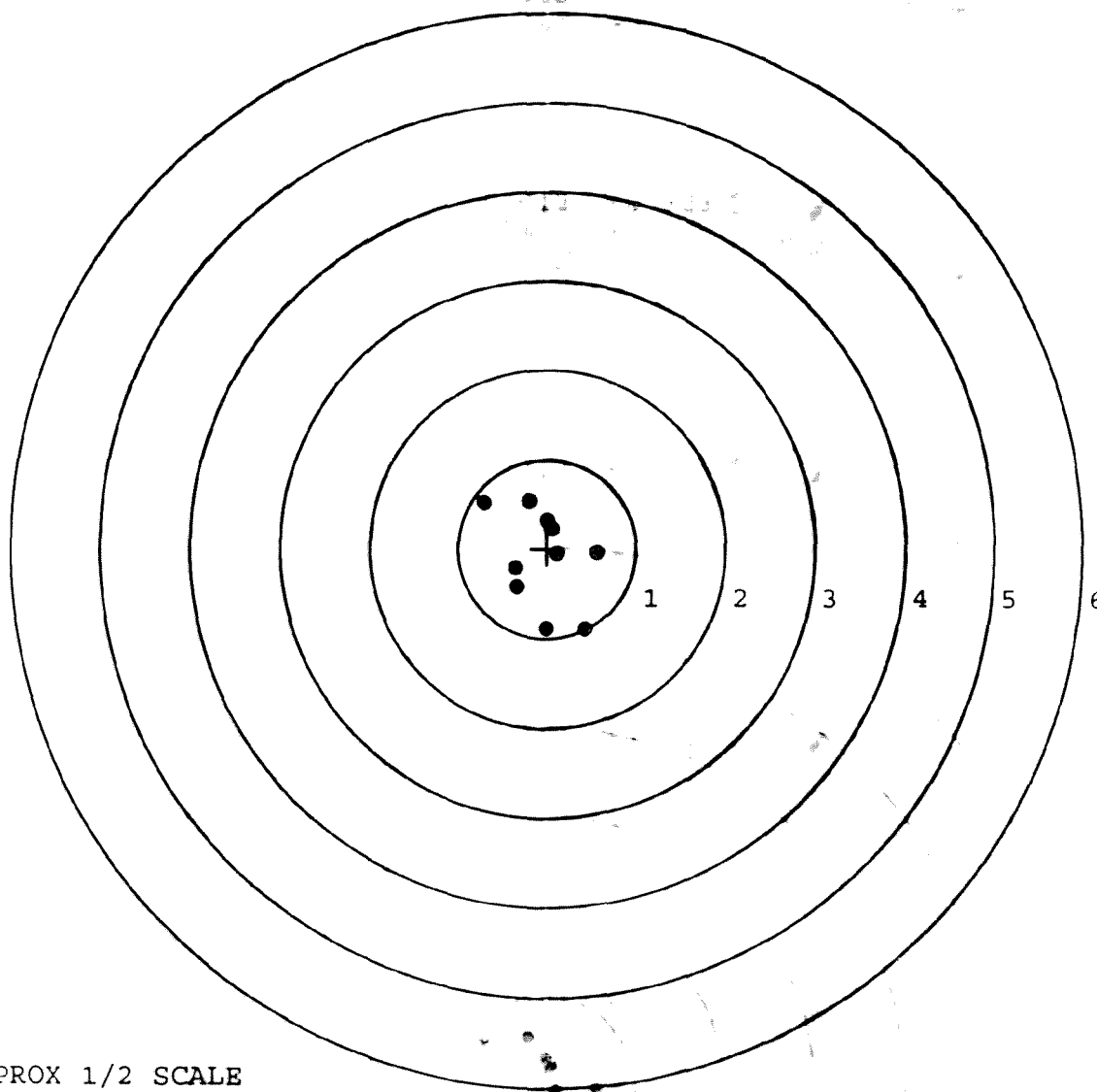
MAX RADIUS: 0.939

MEAN RADIUS: 0.562

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 10

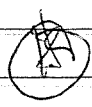
in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

M-24 INSPECTION CHECKLIST
CONTRACT #: DAAE20-02-C-0149

R & E NUMBER 156489
SERIAL NUMBER 06349166
LOG-IN DATE 12-6-08

OPERATION #	OPERATION NAME		DATE	INITIAL
500	DIS-ASSEMBLE GUN		12-10-08	RTZ
505	RE-BARREL		12-10-08	RTZ
560	ASSEMBLE		12-10-08	LR
600	PROOF	MAGNA-FLUX	12-15-08	S.P.N.
605	CHECK HEADSPACE		12-15-08	S.P.N.
610	DIS-ASSEMBLE GUN		12-15-08	S.P.N.
612	MAGNAFLUX	OPERATOR 	12-20-08	
510	DRILL AND TAP		12-16-08	JP
615	ROLLMARK CALIBER		12/24/08	RT
618	ROTO-BLAST		1/1	RL
620	APPLY COATINGS		1/1	✓
625	FINAL ASSEMBLY		1-8-09	RTZ
640	FUNCTION TEST AND	<u>PASS</u> FAIL	1-9-09	S.P.N.
650	TARGET	<u>PASS</u> FAIL	1-9-09	S.P.N.
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
670	FINAL INSPECTION		1-9-09	RP
	A) HEADSPACE	<u>PASS</u> FAIL	1-12-09	L. J.
			1-12-09	L. J.
	B) TRIGGER PULL	MIN 2.50 LBS MAX 4.0 LBS	2.50 2.50 2.49 2.46 2.46	1-12-09 TL
	F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX	4.0 4.0 4.0	1-12-09 L. J.
	G) SAFETY OFF FORCE	2 LBS (MIN)	5.0 5.0 6.0	1-12-09 L. J.
	H) FIRING PIN INDENT	.020	.023 .023 .023	1-12-09 L. J.
690	PACK		1/13/09	F. J.

Repair Inquiry

Repair Number: RE00125973

Serial: C6349166 Model M24 SWS Center Fire
Produced: 12/13/1989

Repairman:

Status: Closed 3/2/2007 8:32:54 AM

Verify Repair

Address Information

Customer:

Received From

Return To:

Received From

Name: DEPT. OF THE ARMY.

DEPT. OF THE ARMY.

Address 1: C. CO.2/23 INF. 4TH DDE. 2ID

C. CO.2/23 INF. 4TH DDE. 2ID

Address 2: ARMORER NCO. SUPPLY NCO

PO Box:

ARMORER NCO. SUPPLY NCO

PO Box:

City: FORT LEWIS

FORT LEWIS

State: WA

Zip Code: 98433

Country: US

State: WA

Zip Code: 98433

Country: US

FFL:

Contact / Condition

Problems

Estimate

History / Status

Shipping / Billing

Contact Information

Phone: NA

Fax:

Email:

Comments:

Received Condition

Fair

Condition
Notes:CSR
Notes:

Accessories Received

Code	Desc	Qty
A006	Sling Strap	1
A007	With Stud	3
A010	Hard Case	1
A017	Scope Base	1
A026	Scope	1
A055	Deployment Kit	1
A057	Fit and Rear Sgt Base	2

Repair Search

Refresh

Close

naglej

3/5/2007

8:18 AM

CAPS

NUM

INS

SCRL



3 Mi...

Arms ...

Part S...

3 Mi...

4 Int...

MyLab...



8:18 AM

Serial Number: C6349166

Model: M24 SWS



RE00125973

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6349166.___0
FILE DATE AND TIME: 03/14/2007 22:28

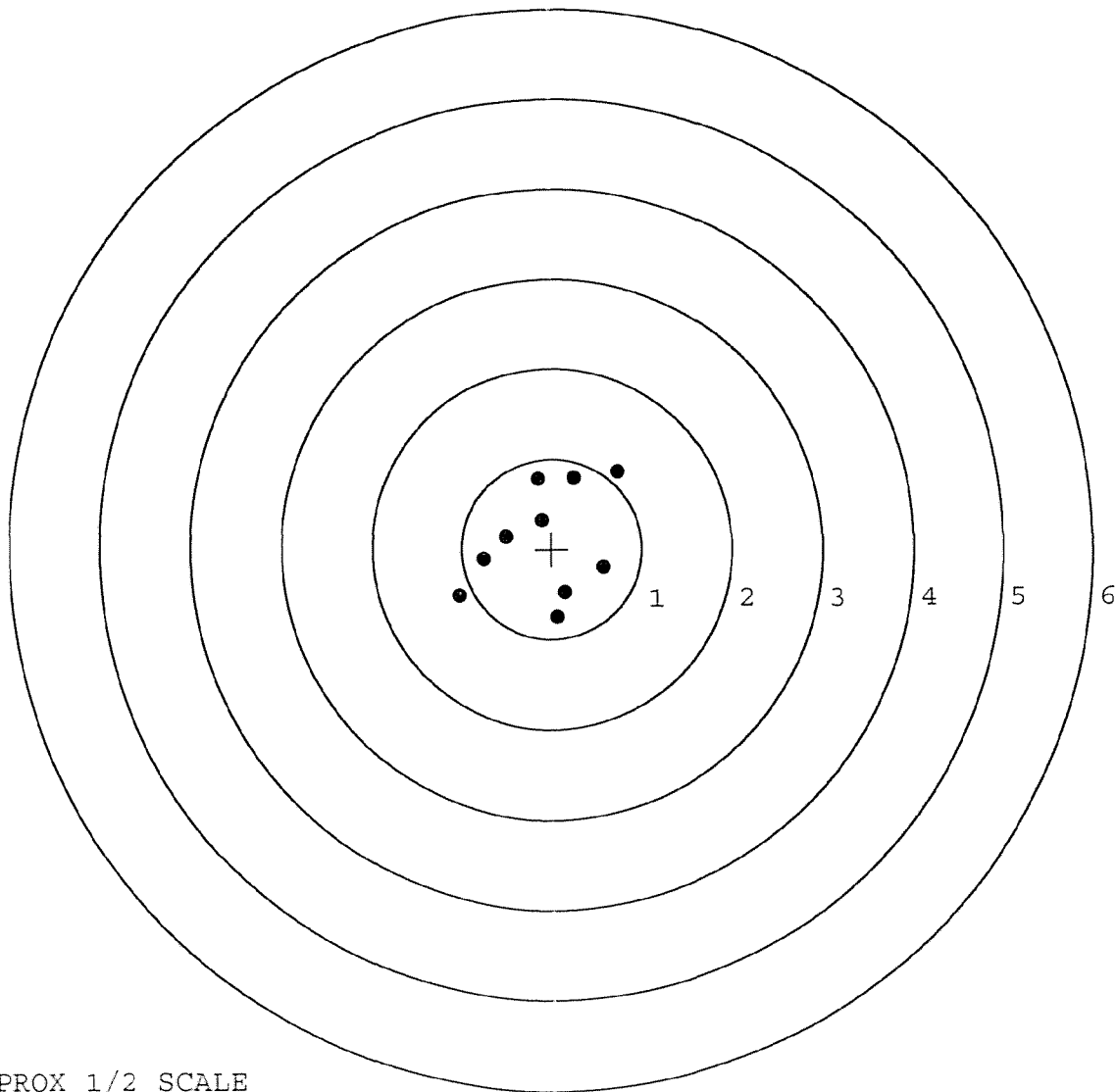
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.057
The Average Y Centroid of the Five Target Set:	0.049
The Average Point of Impact of the Five Target Set:	0.075
The Average Mean Radius of the Five Target Set:	0.595
The Distance from POA to Centroid Target #1:	0.107
The Distance from Centroid Target #2 to Centroid Target #1:	0.119
The Distance from Centroid Target #3 to Centroid Target #1:	0.076
The Distance from Centroid Target #4 to Centroid Target #1:	0.108
The Distance from Centroid Target #5 to Centroid Target #1:	0.043

SERIAL NUMBER: C6349166. __0
TARGET NUMBER: 1
FILE DATE: 03/14/2007
FILE TIME: 22:28

X CENTROID: -0.074
Y CENTROID: 0.077
POA TO CENTROID: 0.107
HORZ SPREAD: 1.768
VERT SPREAD: 1.621
GROUP SPREAD: 2.246
MIN RADIUS: 0.240
MAX RADIUS: 1.129
MEAN RADIUS: 0.731
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-1.027	-0.527
2:	-0.754	-0.119
3:	-0.507	0.136
4:	-0.144	0.782
5:	-0.100	0.316
6:	0.254	0.792
7:	0.741	0.858
8:	0.580	-0.213
9:	0.152	-0.491
10:	0.061	-0.763

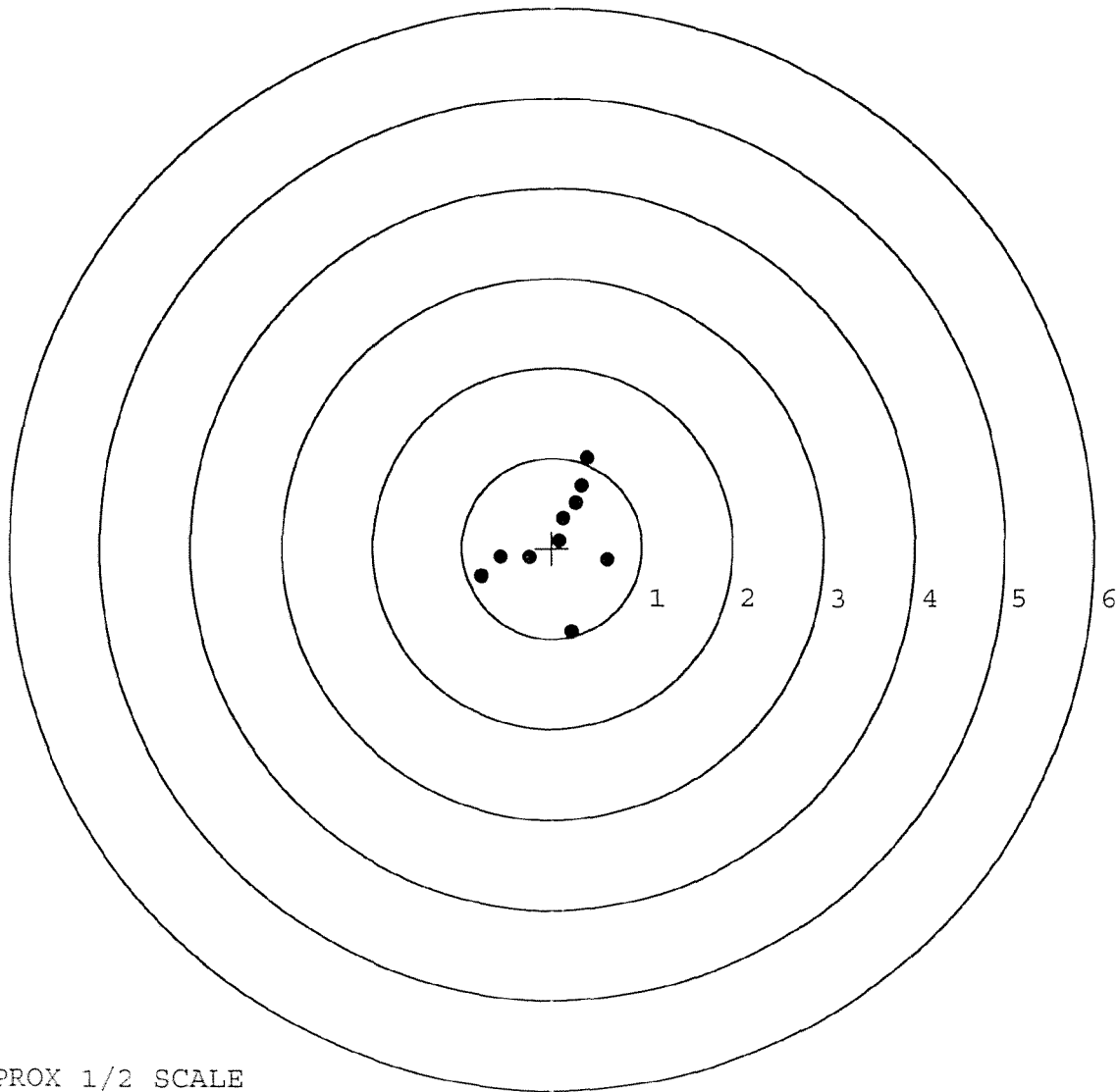


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6349166. __0
TARGET NUMBER: 2
FILE DATE: 03/14/2007
FILE TIME: 22:28

POINT#	X	Y
1:	0.614	-0.139
2:	0.217	-0.930
3:	-0.781	-0.323
4:	-0.572	-0.101
5:	-0.251	-0.101
6:	0.085	0.084
7:	0.126	0.338
8:	0.263	0.503
9:	0.329	0.688
10:	0.388	0.998

X CENTROID: 0.042
Y CENTROID: 0.102
POA TO CENTROID: 0.110
HORZ SPREAD: 1.395
VERT SPREAD: 1.928
GROUP SPREAD: 1.936
MIN RADIUS: 0.047
MAX RADIUS: 1.046
MEAN RADIUS: 0.597
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

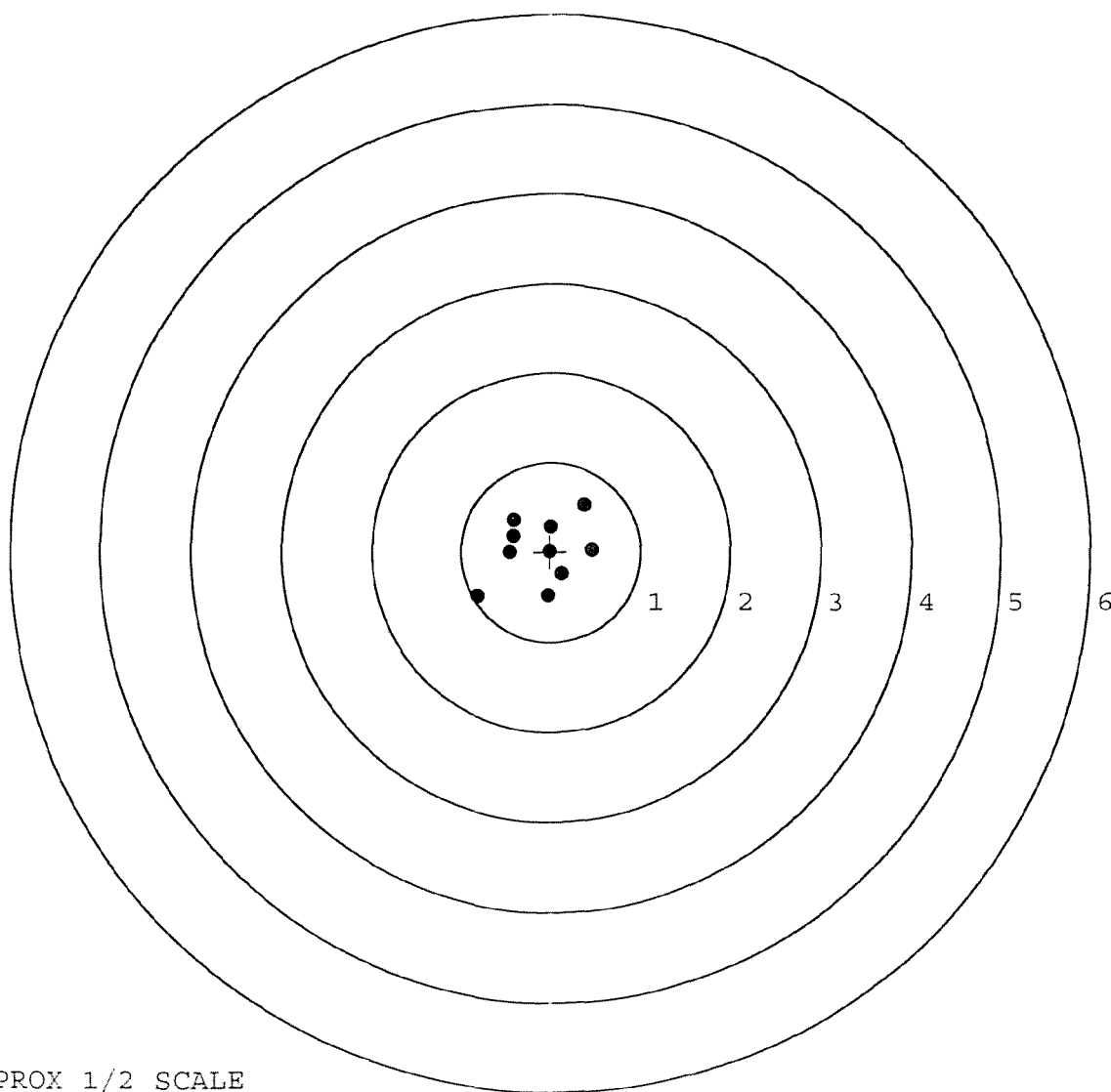


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6349166.___0
TARGET NUMBER: 3
FILE DATE: 03/14/2007
FILE TIME: 22:28

POINT#	X	Y
1:	-0.415	0.358
2:	-0.423	0.177
3:	-0.454	0.006
4:	-0.814	-0.488
5:	-0.027	-0.488
6:	0.128	-0.248
7:	-0.008	0.001
8:	0.001	0.278
9:	0.376	0.522
10:	0.465	0.022

X CENTROID: -0.117
Y CENTROID: 0.014
POA TO CENTROID: 0.118
HORZ SPREAD: 1.279
VERT SPREAD: 1.010
GROUP SPREAD: 1.561
MIN RADIUS: 0.110
MAX RADIUS: 0.859
MEAN RADIUS: 0.456
IN 1 IN DIAMETER: 6
IN 2 IN DIAMETER: 10
in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6349166. __0

TARGET NUMBER: 4

FILE DATE: 03/14/2007

FILE TIME: 22:28

POINT#	X	Y
1:	-0.575	0.561
2:	-0.715	0.035
3:	-0.618	0.100
4:	0.382	0.757
5:	0.509	0.058
6:	0.308	-0.595
7:	0.205	-0.368
8:	-0.004	-0.359
9:	-0.217	-0.188
10:	-0.287	-0.278

X CENTROID: -0.101

Y CENTROID: -0.028

POA TO CENTROID: 0.105

HORZ SPREAD: 1.224

VERT SPREAD: 1.352

GROUP SPREAD: 1.354

MIN RADIUS: 0.198

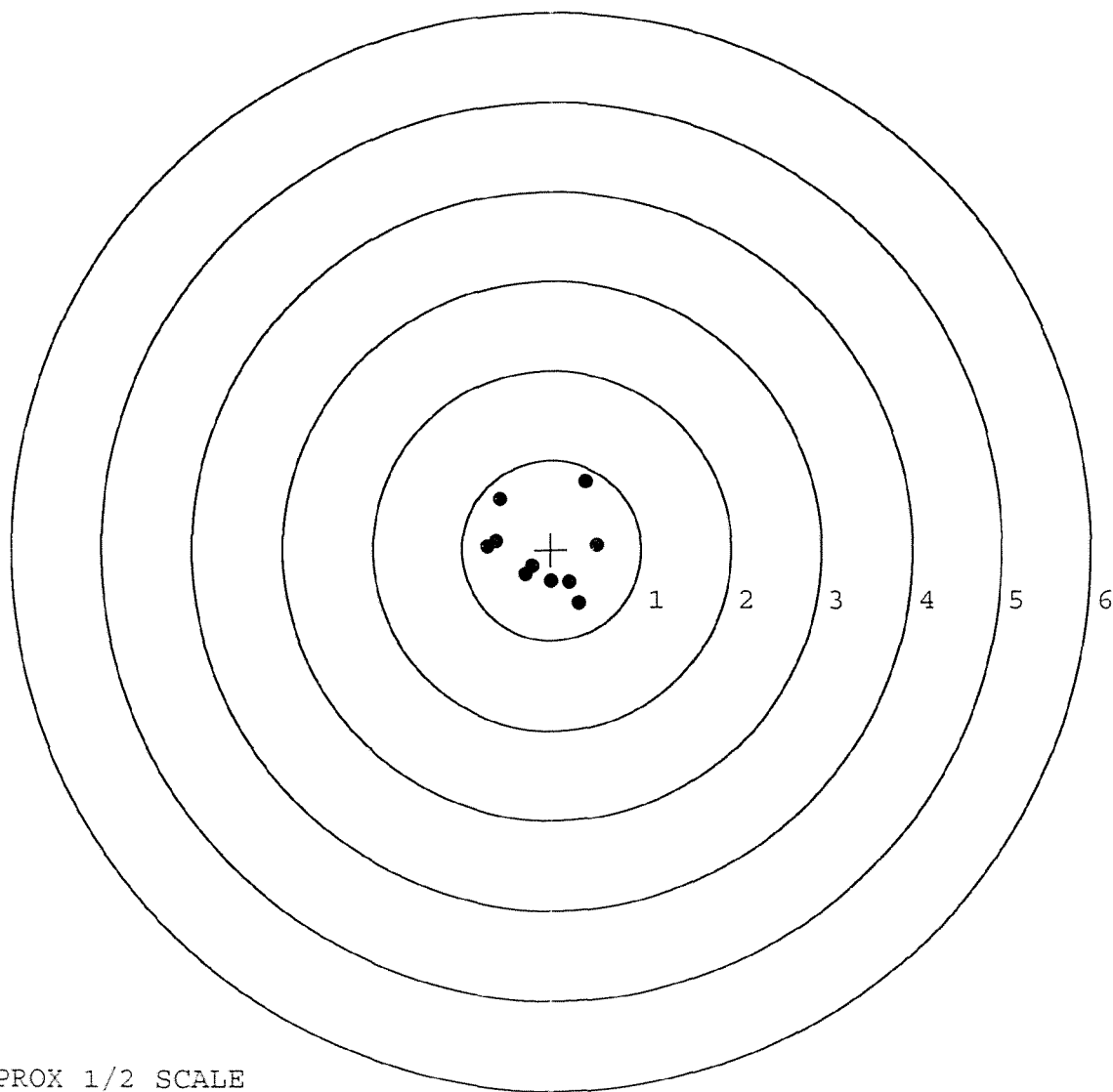
MAX RADIUS: 0.922

MEAN RADIUS: 0.545

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10

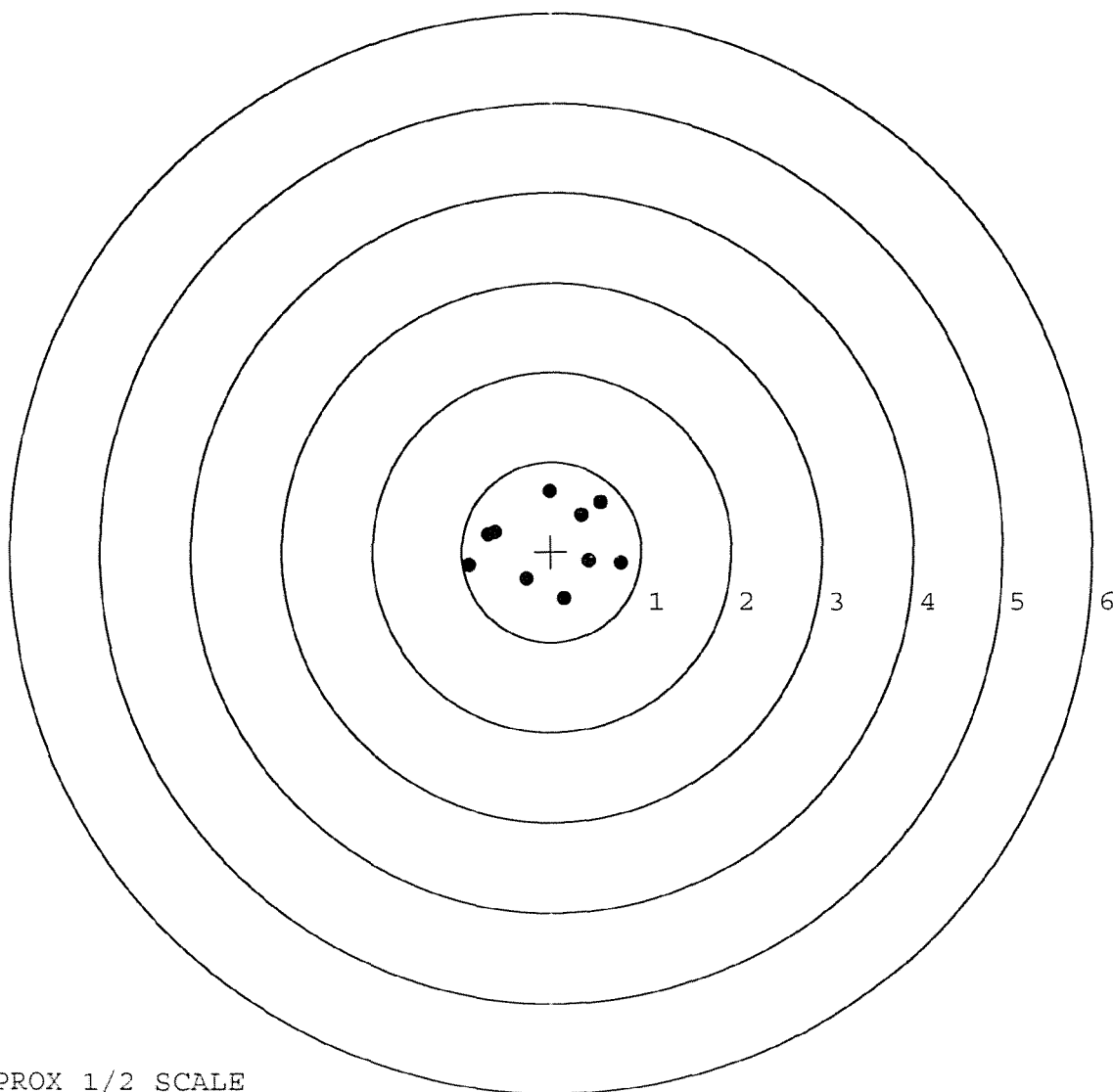


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6349166. __0
TARGET NUMBER: 5
FILE DATE: 03/14/2007
FILE TIME: 22:28

POINT#	X	Y
1:	-0.713	0.188
2:	-0.919	-0.160
3:	-0.279	-0.303
4:	0.148	-0.523
5:	0.421	-0.105
6:	0.779	-0.133
7:	0.340	0.402
8:	0.550	0.547
9:	-0.015	0.667
10:	-0.629	0.214

X CENTROID: -0.032
Y CENTROID: 0.079
POA TO CENTROID: 0.085
HORZ SPREAD: 1.698
VERT SPREAD: 1.190
GROUP SPREAD: 1.698
MIN RADIUS: 0.455
MAX RADIUS: 0.919
MEAN RADIUS: 0.646
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 10
in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

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

R & E NUMBER	125973		
SERIAL NUMBER	C6349166		
LOG-IN DATE	3-2-07		
OPERATION #	OPERATION NAME	DATE	INITIAL
500	DIS-ASSEMBLE GUN	3-5-07	RTZ
505	RE-BARREL	3-7-07	RTZ
560	ASSEMBLE	3-7-07	RTZ
600	PROOF	3-7-07	RTZ
605	CHECK HEADSPACE	INSPECTED	RTZ
610	DIS-ASSEMBLE GUN	MAR 08 2007	RTZ
612	MAGNAFLUX	OPERATOR <u>CAP</u>	APO
510	DRILL AND TAP	3-7-07	SD
615	ROLLMARK CALIBER	3-8-07	CW
618	ROTO-BLAST	3-8-07	UB
620	APPLY COATINGS	3-12-07	WJ
625	FINAL ASSEMBLY	3-14-07	RTZ
640	FUNCTION TEST AND	(PASS) FAIL	3-14-07 non
650	TARGET	(PASS) FAIL	3-14-07 non
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
670	FINAL INSPECTION	3-26-07	RTZ
	A) HEADSPACE	(PASS) FAIL	3-26-07 RTZ
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	
		284 283 285 291 287	3-15-07 TRW
680	F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX	
		6.0 6.0 6.5	3-15-07 TRW
	G) SAFETY OFF FORCE	2 LBS MAX	
		2.5 2.5 2.25	3-15-07 TRW
	I) FIRING PIN INDENT	.020	
		.0235 .023 .0225	3-15-07 TRW
690	PACK		3-26-07 N/A

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6349166.___0
FILE DATE AND TIME: 08/09/2005 11:16

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.019
The Average Y Centroid of the Five Target Set:	0.173
The Average Point of Impact of the Five Target Set:	0.174
The Average Mean Radius of the Five Target Set:	1.004
The Distance from POA to Centroid Target #1:	0.258
The Distance from Centroid Target #2 to Centroid Target #1:	0.660
The Distance from Centroid Target #3 to Centroid Target #1:	0.449
The Distance from Centroid Target #4 to Centroid Target #1:	0.359
The Distance from Centroid Target #5 to Centroid Target #1:	0.645

SERIAL NUMBER: C6349166. 0

TARGET NUMBER: 1

FILE DATE: 08/09/2005

FILE TIME: 11:16

POINT#	X	Y
1:	0.371	0.306
2:	-0.173	1.336
3:	-0.173	0.691
4:	-0.325	0.461
5:	-0.442	0.306
6:	0.837	-0.655
7:	0.621	-0.853
8:	-0.632	-1.289
9:	-1.013	-0.559
10:	-1.636	-0.031

X CENTROID: -0.257

Y CENTROID: -0.029

POA TO CENTROID: 0.258

HORZ SPREAD: 2.473

VERT SPREAD: 2.625

GROUP SPREAD: 2.551

MIN RADIUS: 0.383

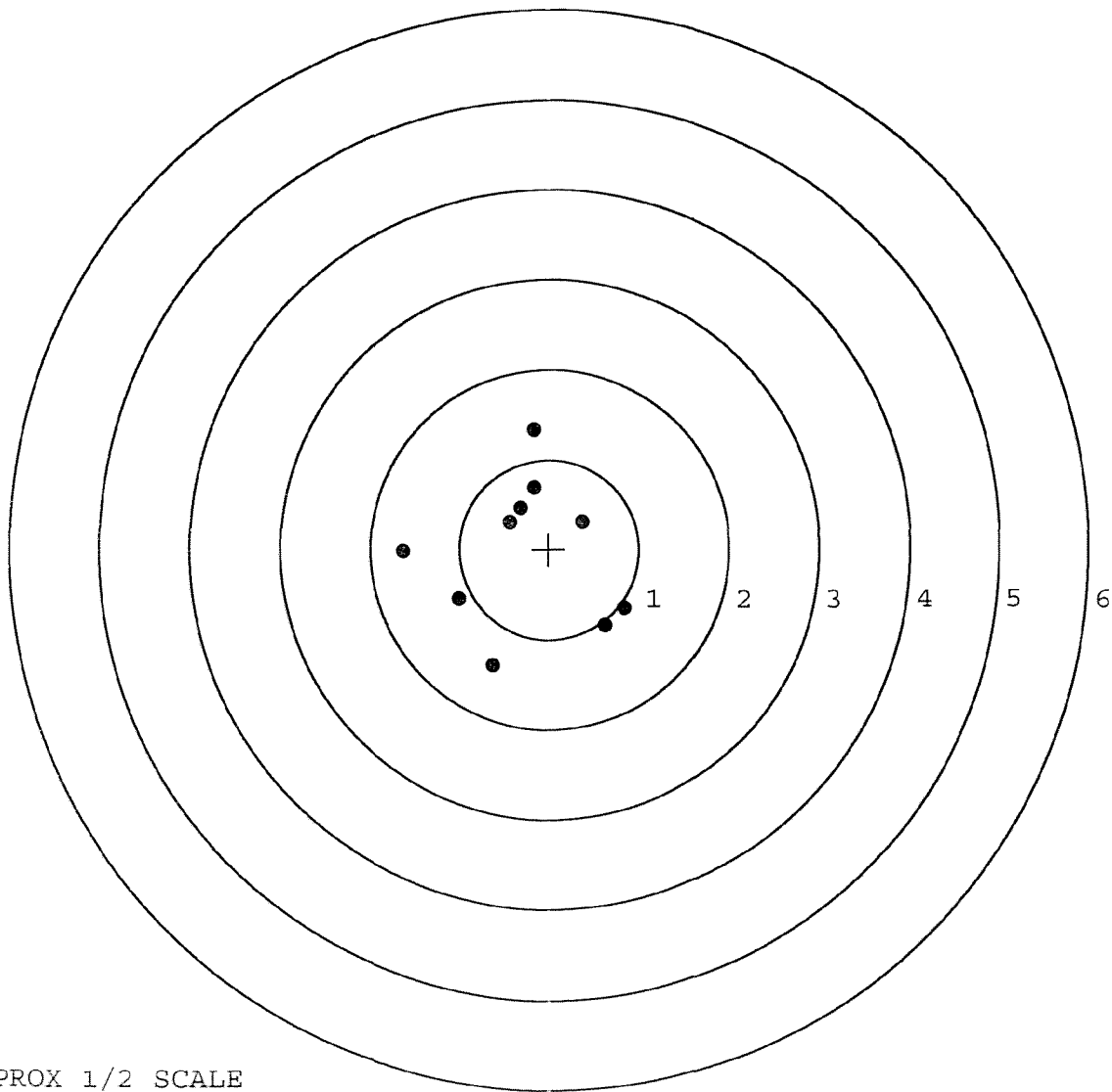
MAX RADIUS: 1.380

MEAN RADIUS: 0.976

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 5

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6349166.___0

TARGET NUMBER: 2

FILE DATE: 08/09/2005

FILE TIME: 11:16

POINT#	X	Y
1:	0.750	-0.770
2:	0.263	-0.376
3:	0.114	-0.155
4:	-0.093	-0.295
5:	-0.280	-0.253
6:	-0.874	0.811
7:	0.024	1.030
8:	1.226	0.848
9:	1.604	1.271
10:	-0.221	1.816

X CENTROID: 0.251

Y CENTROID: 0.393

POA TO CENTROID: 0.466

HORZ SPREAD: 2.478

VERT SPREAD: 2.586

GROUP SPREAD: 2.520

MIN RADIUS: 0.565

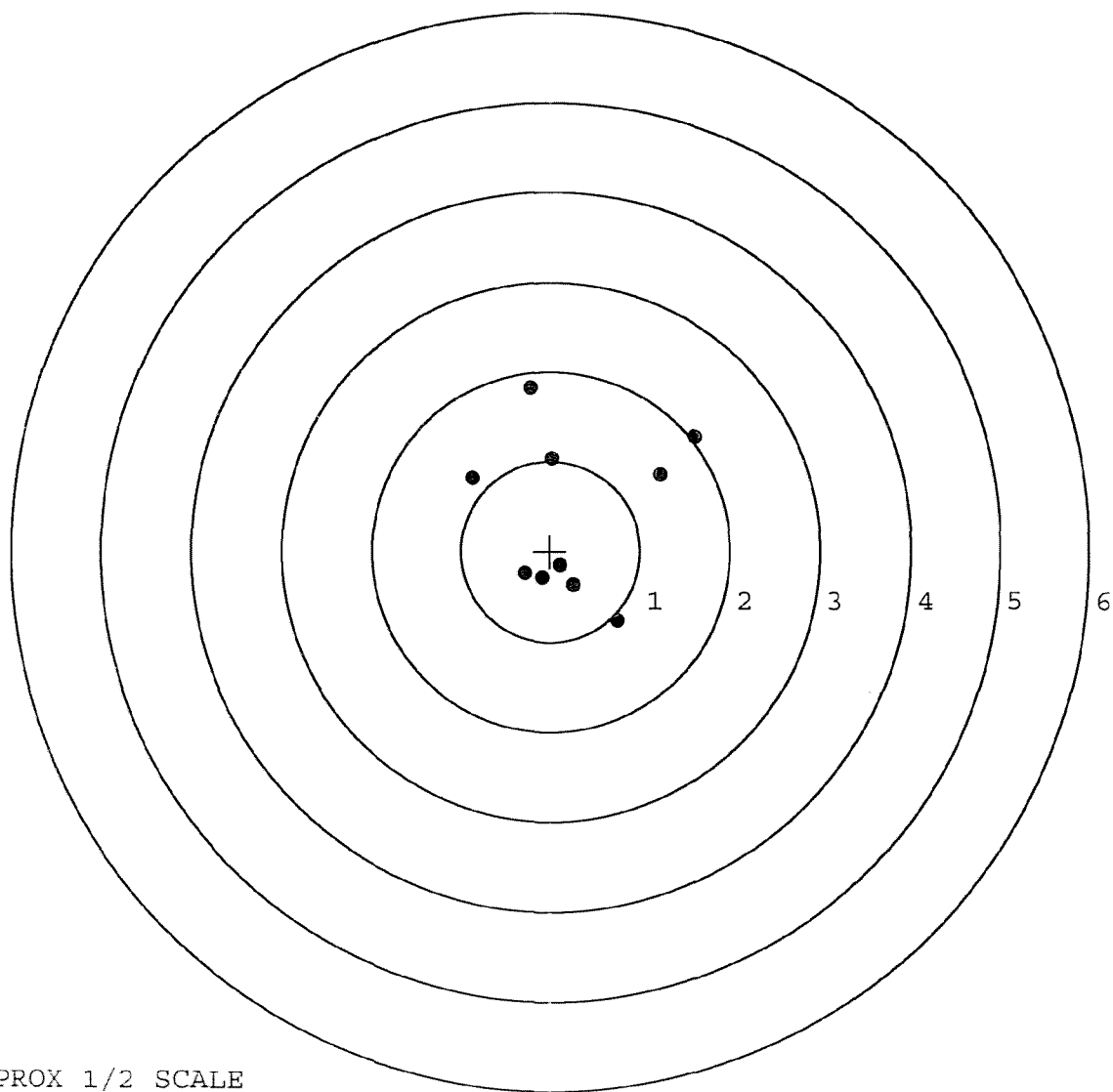
MAX RADIUS: 1.613

MEAN RADIUS: 1.027

IN 1 IN DIAMETER: 0

IN 2 IN DIAMETER: 5

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6349166. 0

TARGET NUMBER: 3

FILE DATE: 08/09/2005

FILE TIME: 11:16

POINT#	X	Y
1:	0.868	-0.642
2:	-0.485	0.110
3:	-0.353	0.165
4:	-0.132	0.083
5:	0.012	0.069
6:	-0.011	-0.069
7:	0.181	-0.026
8:	-1.307	0.774
9:	-0.994	1.559
10:	0.425	2.115

X CENTROID: -0.180

Y CENTROID: 0.414

POA TO CENTROID: 0.451

HORZ SPREAD: 2.175

VERT SPREAD: 2.757

GROUP SPREAD: 2.792

MIN RADIUS: 0.303

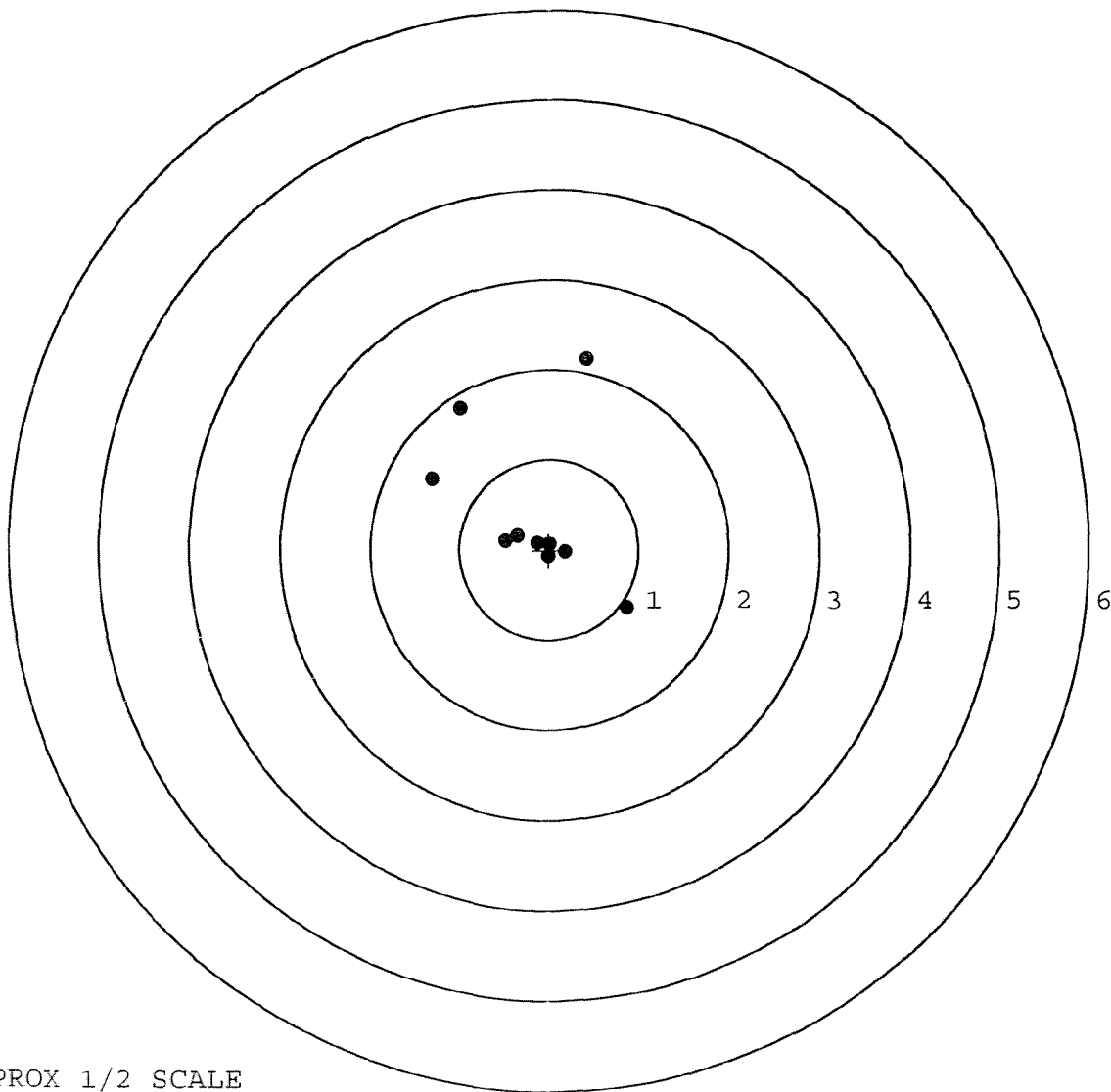
MAX RADIUS: 1.805

MEAN RADIUS: 0.842

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6349166. __0

TARGET NUMBER: 4

FILE DATE: 08/09/2005

FILE TIME: 11:16

POINT#	X	Y
1:	0.678	-1.453
2:	0.786	-0.995
3:	0.234	-0.764
4:	-0.800	-1.583
5:	-1.744	-0.964
6:	0.158	0.291
7:	-0.009	0.465
8:	-0.647	0.384
9:	-0.941	0.346
10:	1.308	0.768

X CENTROID: -0.098

Y CENTROID: -0.351

POA TO CENTROID: 0.364

HORZ SPREAD: 3.052

VERT SPREAD: 2.351

GROUP SPREAD: 3.509

MIN RADIUS: 0.530

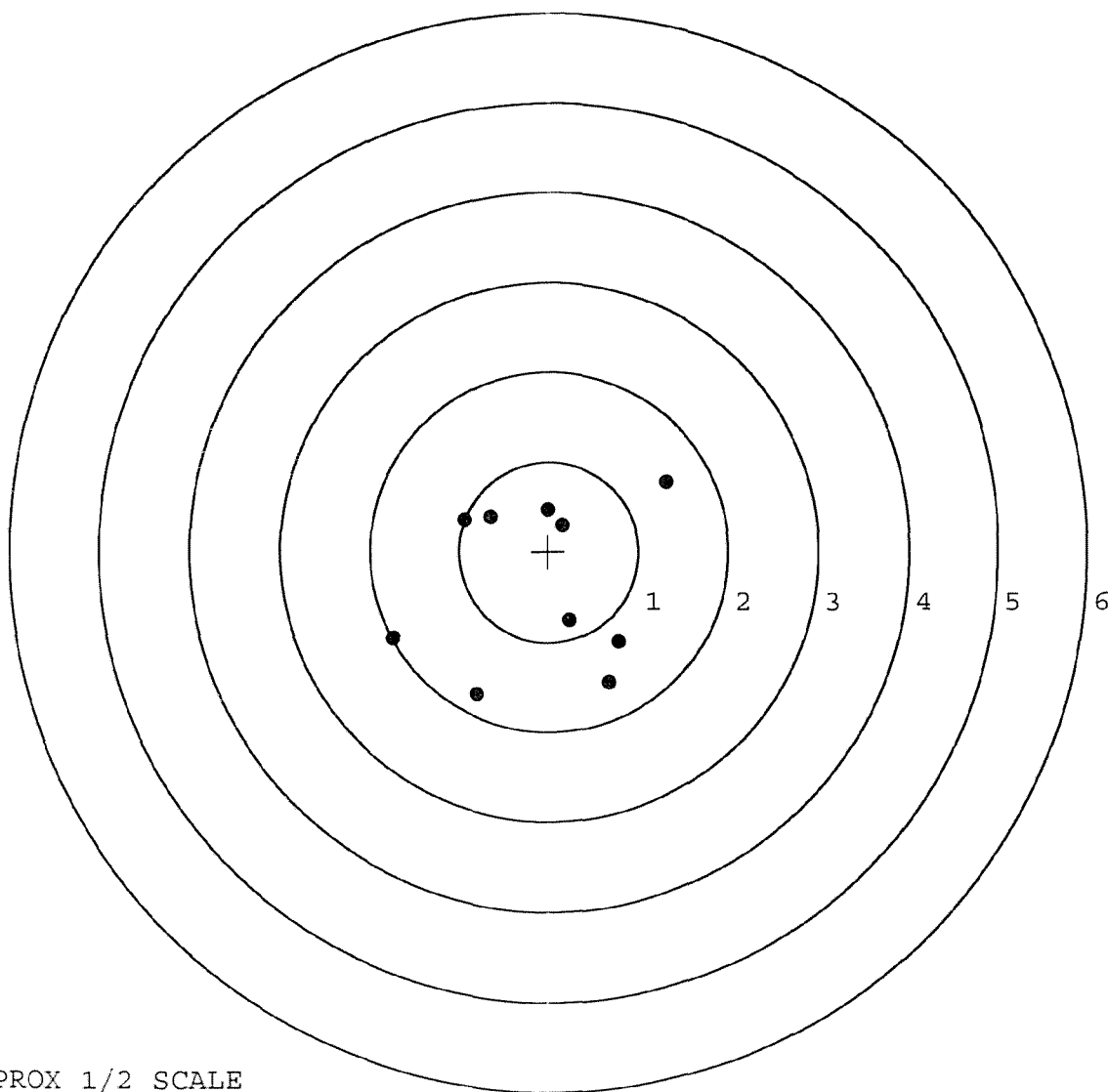
MAX RADIUS: 1.796

MEAN RADIUS: 1.147

IN 1 IN DIAMETER: 0

IN 2 IN DIAMETER: 4

in 3 IN DIAMETER: 8

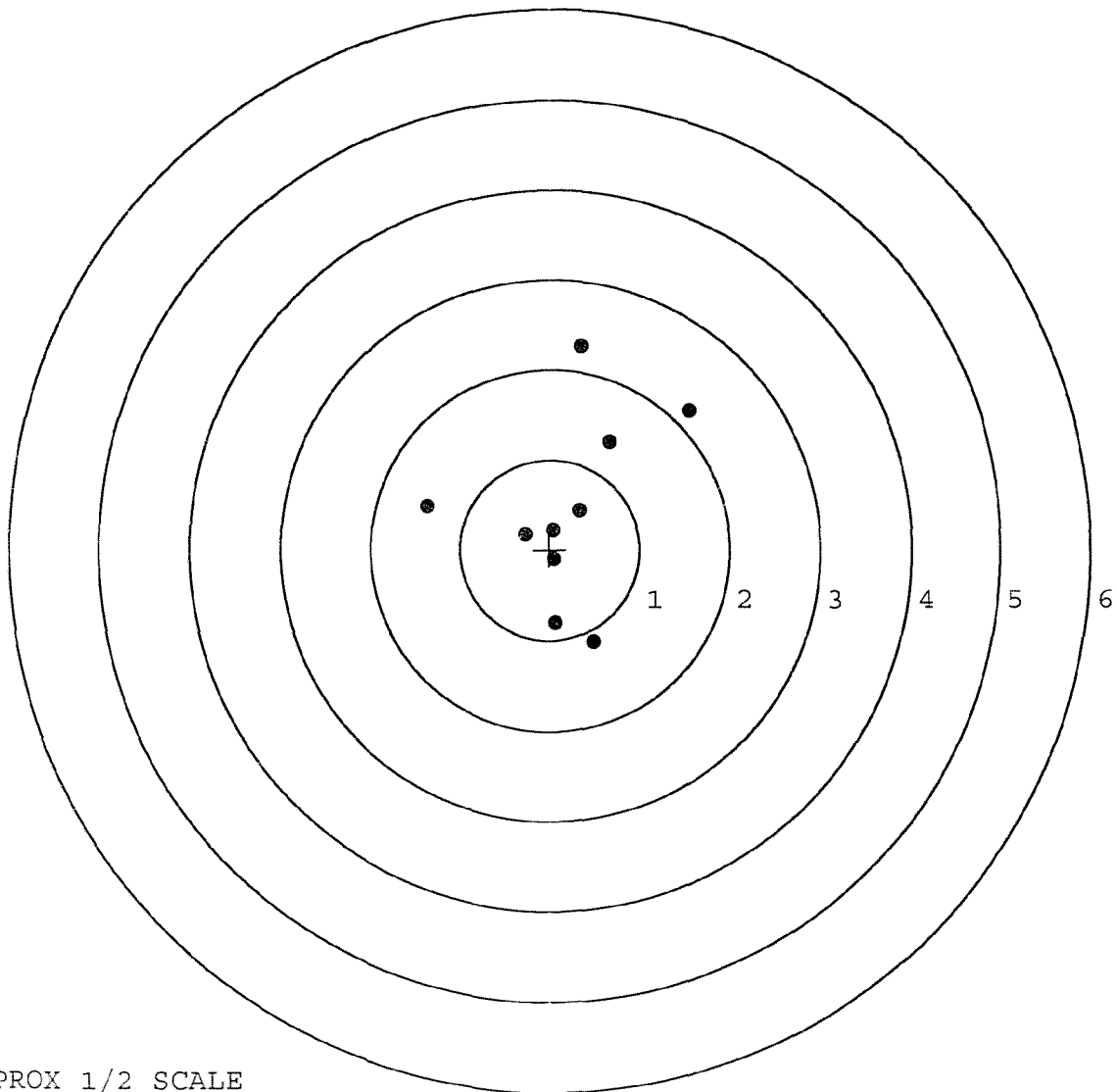


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6349166. 0
TARGET NUMBER: 5
FILE DATE: 08/09/2005
FILE TIME: 11:16

X CENTROID: 0.190
Y CENTROID: 0.437
POA TO CENTROID: 0.477
HORZ SPREAD: 2.915
VERT SPREAD: 3.286
GROUP SPREAD: 3.289
MIN RADIUS: 0.139
MAX RADIUS: 1.831
MEAN RADIUS: 1.029
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 5
in 3 IN DIAMETER: 7

POINT#	X	Y
1:	0.487	-1.025
2:	0.064	-0.816
3:	0.328	0.438
4:	0.048	-0.111
5:	0.043	0.216
6:	-0.272	0.178
7:	-1.370	0.486
8:	0.670	1.198
9:	1.545	1.548
10:	0.352	2.261



TARGET APPROX 1/2 SCALE

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

R. & E NUMBER	92199		
SERIAL NUMBER	C6349166		
LOG-IN DATE	2-1-05		
INSPECT AND VERIFY:			
OPERATION #	OPERATION NAME	DATE	INITIAL
550	DIS-ASSEMBLE GUN	6-13-05	RTZ
560 A	RE-BARREL	6-20-05	RTZ
B	DRILL AND TAP	6-22-05	TRW
575	ASSEMBLE	6-20-05	RTZ
600	PROOF	6-22-05	AC
605	CHECK HEADSPACE	6-22-05	AC
610	DIS-ASSEMBLE GUN	6-22-05	RTZ
612	MAGNAFLUX	6-23-05	unib
615	ROLLMARK CALIBER	6-23-05	CW
618	ROTO-BLAST	7-7-05	JS
620	APPLY COATINGS	7-18-05	WJ
625 A	FINAL ASSEMBLY	8-3-05	RTZ
B	TRIGGER PULL TEST		
C	SAFETY "ON" FORCE	8-16-05	AC
D	SAFETY "OFF" FORCE	8-16-05	AC
E	FIRING PIN INDENT	8-16-05	AC
640	TARGET	8-9-05	TRW
655	FINAL INSPECT	8-16-05	AC
660	PACK	9-15-05	RTZ
		SHIP DATE	
		QAR INSPECTION DATE	

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6349166

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	10-9	89	RW
600	Proof	10-9	89	AC.
607	Check Headspace	10-9	89	RW
610	Dis-assemble Gun	10-9	89	RW
612	Magnaflux Barrel Action		10/13/89	KCR
	Magnaflux Bolt		10/13/89	KCR
615	Rollmark Caliber			
7	Drill and Tap Sight Holes	10 1689		JB
618	Polish Barrel <i>RB</i>	10 1689		BT
620	Apply Coatings (Barrel Action)		10-27-89	JA
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		10/30/89	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/30/89	RW
	C) Inspect Ejector Hole for Chamfer		10/30/89	RW
	D) Oil Firing Pin Ass'y		10/30/89	RW
	E) Adjust Trigger Pull to Min Setting and Stake		11/7/89	WB

op. #	OP. NAME	READINGS			DATE	INIT		
625 cont.	F) Safety On Force	5	5	5	11/2/89	JD		
	G) Safety Off Force	4	4	4	11/2/89	JD		
	H) Trigger Pull Test & Retainability				11/2/89	WB		
	I) Firing Pin Indent	.0225	.0225	.0225	11/2/89	gll		
	J) Assemble Stock				11/3/89	RW		
	K) Assemble Swivel Studs				11/3/89	JD		
	L) Attach Front and Rear Sight Assemblies				11/3/89	RW		
	M) Iron Sight Alignment				11/3/89	RW		
	N) Detach Front & Rear Sights & place in numbered container				11/3/89	RW		
	O) Attach Scope to Rifle				11/4/89	JD		
	P) Detach & Attach Scope 20 Times				11/6/89	JD		
640	Gallery Target & Test				11-8-89	AC		
	A) Time				11-8-89	AC		
	B) Malfunctions				11-8-89	AC		
	C) Pierced Primers				11-8-89	AC		
	D) Optical Clarity of Scope				11-8-89	AC		
645	Inspect for Live Ammo				11-8-89	AC		
655	Final Inspection							
	A) Headspace				10/20/89	JD		
	B) Trigger Pull	254	271	262	253	253	10/20/89	JD
	C) Function						10/20/89	JD
660	Pack						15 Dec 89	JD

RC 49

SWS TRIGGER PULL TESTAVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. 06359166DATE 14 Mar 90TESTER JS

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	272	270		284	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	268	276		283	
PULL #3	268	249		280	
PULL #4	271	274		277	
PULL #5	272	270		273	
TOTAL	1341	1339			
AVG.	2682	2678			

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	347	346		
PULL #2	348	347		
PULL #3	344	345		
PULL #4	320	348		
PULL #5	349	349		
TOTAL	1708	1735		
AVG.	3416	347		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	438	439		
PULL #2	438	436		
PULL #3	438	430		
PULL #4	434	436		
PULL #5	439	436		
TOTAL	2177	2177		
AVG.	4354	4354		

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6349166
8 Nov 1989

CENTROIDAL DISTANCES

0 TO 1	.108259
1 TO 2	.390247
1 TO 3	.12963
1 TO 4	.155756
1 TO 5	.294478

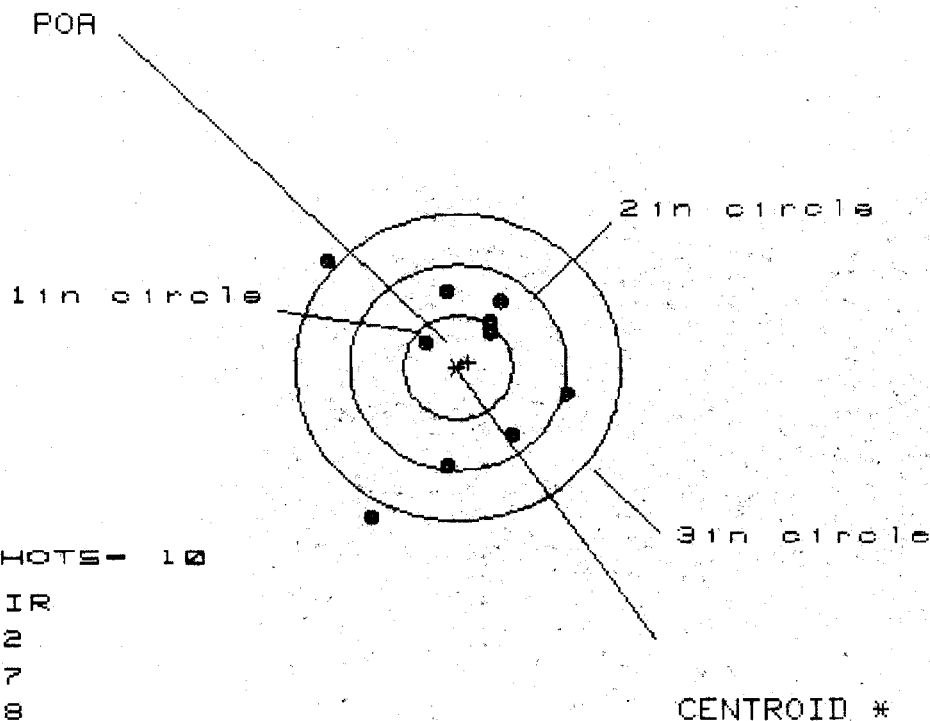
POI <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .061
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0486
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0779933
POI RADIUS FOR THIS RIFLE IS: .9148

8 Nov 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C8349166

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 7

3 in = 8

HS= 2.176

VS= 2.492

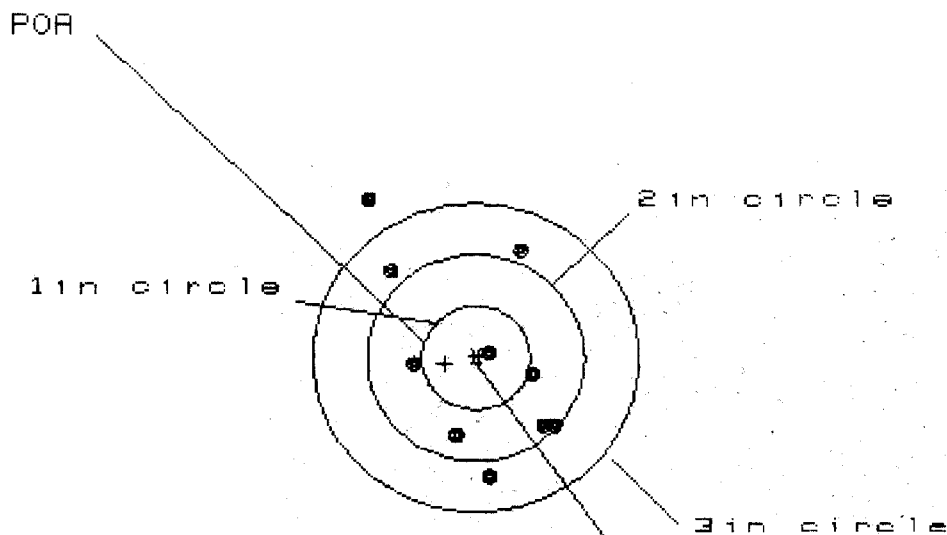
GS= 2.529

PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.977	.892	.731
MINIMUM X	:	-1.199	-1.284	-.585
MAXIMUM Y	:	1.003	.837	.660
MINIMUM Y	:	-1.489	-1.118	-1.013
CENTROID X	:	-.098	-.013	.148
CENTROID Y	:	-.046	.120	.015
POA TO CENTROID in.	:	.108	.120	.149
MIN RADIUS	:	.395	.260	.282
MEAN RADIUS	:	.885	.747	.648
MAX RADIUS	:	1.675	1.533	1.076
HORIZONTAL SPREAD	:	2.176	2.176	1.316
VERTICAL SPREAD	:	2.492	1.955	1.673
EXTREME SPREAD	:	2.529	2.515	1.674
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	7		
NUMBER IN THREE INCH CIRCLE	=	8		

8 Nov 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C6349166

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in - 1

2in - 6

3in - 9

HS- 1.745

VS= 2.773

GS= 3.002

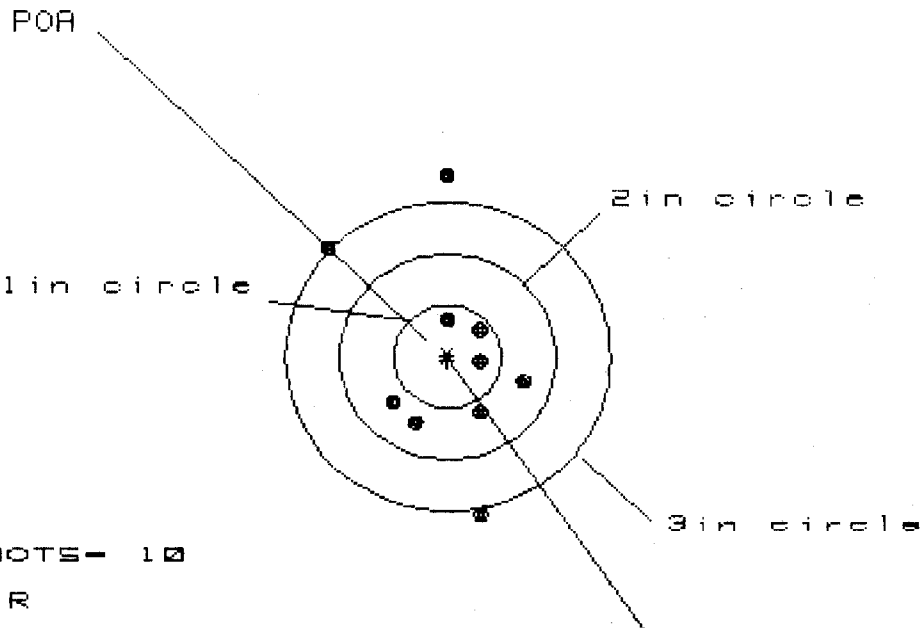
CENTROID #

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.716	.601	.602
MINIMUM X	:	-1.029	-.875	-.874
MAXIMUM Y	:	1.581	1.248	1.121
MINIMUM Y	:	-1.192	-1.017	-.677
CENTROID X	:	.280	.395	.394
CENTROID Y	:	.051	-.124	.003
POA TO CENTROID in.	:	.285	.414	.394
MIN RADIUS	:	.138	.219	.093
MEAN RADIUS	:	.927	.784	.751
MAX RADIUS	:	1.886	1.350	1.255
HORIZONTAL SPREAD	:	1.745	1.476	1.476
VERTICAL SPREAD	:	2.773	2.265	1.798
EXTREME SPREAD	:	3.002	2.287	2.139
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	6		
NUMBER IN THREE INCH CIRCLE	=	9		

8 Nov 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C8349186

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 3

2in = 7

3in = 8

HS= 1.795

VS= 3.258

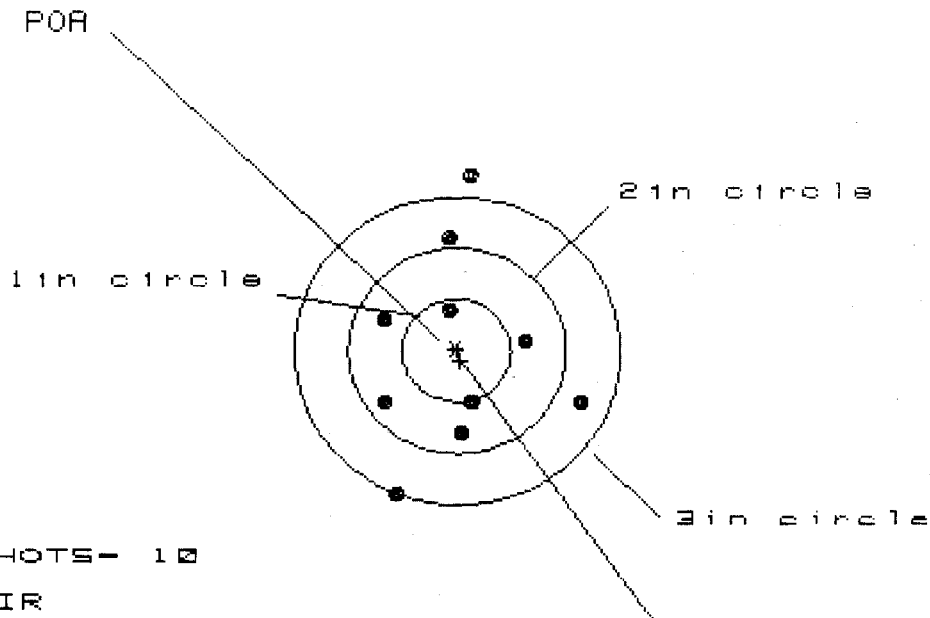
GS= 3.274

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.719	.716	.753
MINIMUM X	-1.076	-1.079	-1.042
MAXIMUM Y	1.740	1.226	1.061
MINIMUM Y	-1.518	-1.325	-.623
CENTROID X	.004	.007	-.030
CENTROID Y	.035	-.158	.007
POA TO CENTROID in.	.035	.158	.031
MIN RADIUS	.280	.341	.316
MEAN RADIUS	.865	.753	.675
MAX RADIUS	1.740	1.633	1.487
HORIZONTAL SPREAD	1.795	1.795	1.795
VERTICAL SPREAD	3.258	2.551	1.684
EXTREME SPREAD	3.274	2.898	2.225
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		8	

B Nov 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C6349166

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 2

2in = 6

3in = 9

HS= 1.8008

VS= 3.024

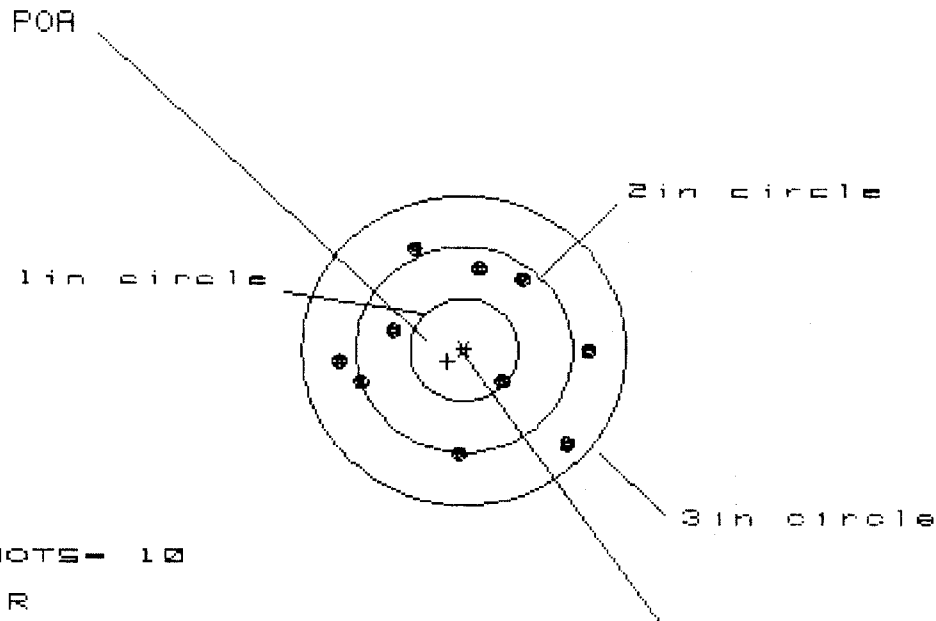
GS= 3.099

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.114	1.124	1.052
MINIMUM X	:	-.694	-.684	-.756
MAXIMUM Y	:	1.664	1.279	1.132
MINIMUM Y	:	-1.360	-1.175	-.714
CENTROID X	:	-.034	-.044	.028
CENTROID Y	:	.096	-.089	.057
POA TO CENTROID in.	:	.102	.100	.064
MIN RADIUS	:	.424	.291	.418
MEAN RADIUS	:	.932	.831	.769
MAX RADIUS	:	1.667	1.309	1.137
HORIZONTAL SPREAD	:	1.808	1.808	1.808
VERTICAL SPREAD	:	3.024	2.454	1.846
EXTREME SPREAD	:	3.099	2.516	1.932
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

8 May 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C8349166

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in - 1

2 in - 5

3 in = 10

HS- 2.300

VS= 2.069

GS= 2.444

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.185	1.293	.780
MINIMUM X	:	-1.115	-1.007	-.846
MAXIMUM Y	:	1.041	.938	.919
MINIMUM Y	:	-1.028	-1.131	-1.150
CENTROID X	:	.153	.045	-.116
CENTROID Y	:	.108	.211	.230
POA TO CENTROID in.	:	.187	.216	.258
MIN RADIUS	:	.499	.544	.383
MEAN RADIUS	:	.965	.908	.838
MAX RADIUS	:	1.341	1.301	1.171
HORIZONTAL SPREAD	:	2.300	2.300	1.626
VERTICAL SPREAD	:	2.069	2.069	2.069
EXTREME SPREAD	:	2.444	2.302	2.113
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		10	




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

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

MODEL 700TH H24

SERIAL NO.
C6349166

ORDER NO.
5716

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

01

