

G641 4336

Raphad

C. 622 5379

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: RE00144807

Serial: G6414336 Model M24 SWS Center Fire
Caliber: 7.62 NATO

Repairman:

Verify Repair

Status:

Closed 4/24/2008 10:58:11 AM

Address Information

Customer:

☒ Received From

Return To:

☐ Received From

Name: B/210TH BSB

B/210TH BSB

Address 1: 2 BCT

2 BCT

Address 2: 10 TH MTN DIV

PO Box:

10 TH MTN DIV

PO Box:

City: FORT DRUM

FORT DRUM

State: NY

Zip Code: 13602

Country: US

State: NY

Zip Code: 13602

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
A008	With Swivel	2
A010	Hard Case	1
A026	Scope	1
A057	Fit and Rear Sgt Base	1

naglej

4/24/2008

12:23 PM

LAP3

NUM



Serial Number:

G6414336

Model: M24 SWS



RE00144807

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6414336.___0
FILE DATE AND TIME: 05/27/2008 06:03

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.106
The Average Y Centroid of the Five Target Set:	-0.090
The Average Point of Impact of the Five Target Set:	0.139
The Average Mean Radius of the Five Target Set:	0.723
The Distance from POA to Centroid Target #1:	0.275
The Distance from Centroid Target #2 to Centroid Target #1:	0.171
The Distance from Centroid Target #3 to Centroid Target #1:	0.184
The Distance from Centroid Target #4 to Centroid Target #1:	0.121
The Distance from Centroid Target #5 to Centroid Target #1:	0.258

SERIAL NUMBER: G6414336. __0

TARGET NUMBER: 1

FILE DATE: 05/27/2008

FILE TIME: 06:03

X CENTROID: -0.210

Y CENTROID: -0.178

POA TO CENTROID: 0.275

HORZ SPREAD: 2.436

VERT SPREAD: 1.301

GROUP SPREAD: 2.468

MIN RADIUS: 0.088

MAX RADIUS: 1.523

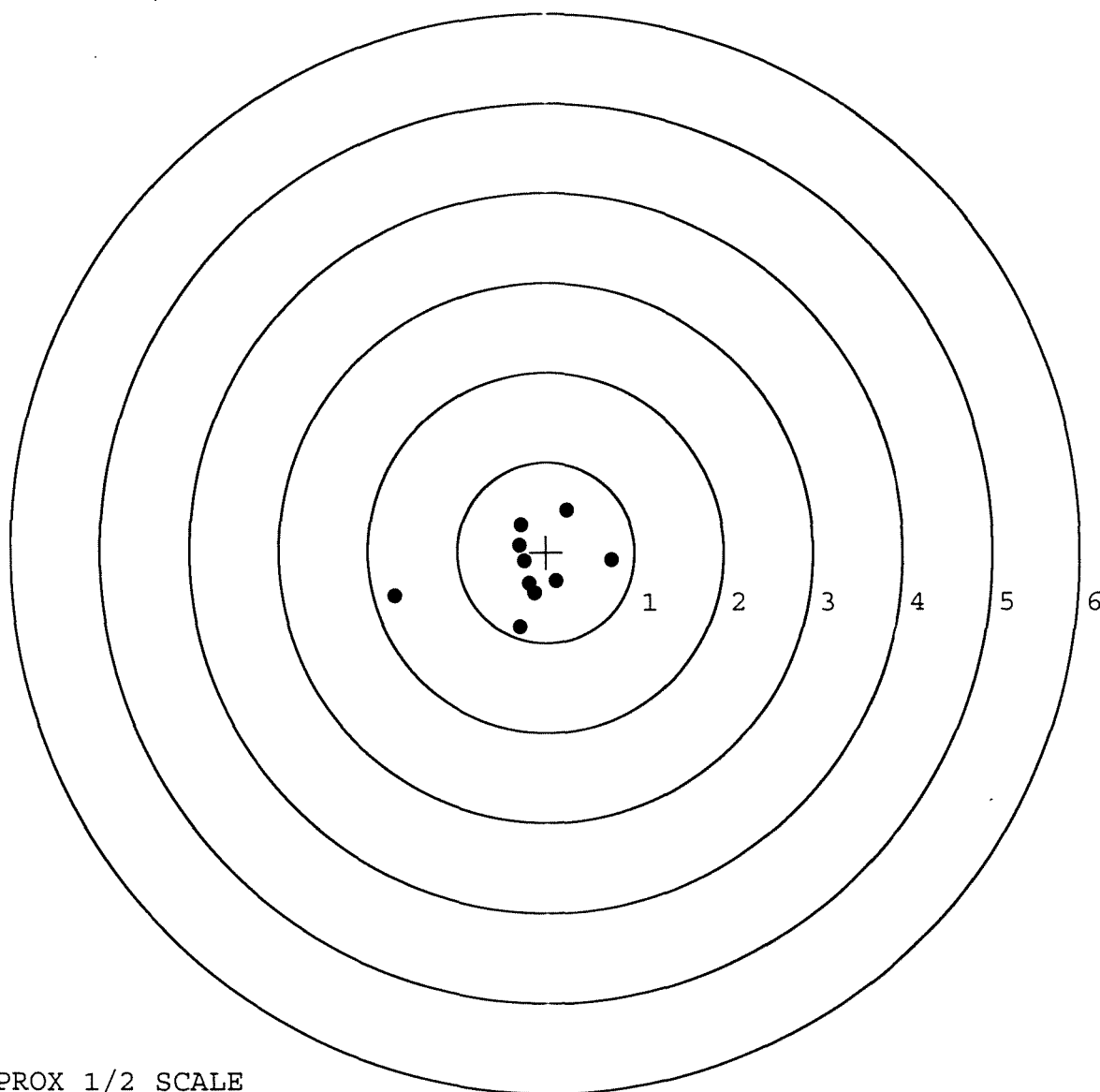
MEAN RADIUS: 0.556

IN 1 IN DIAMETER: 6

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 9

POINT#	X	Y
1:	-0.294	-0.830
2:	-1.701	-0.488
3:	0.735	-0.092
4:	0.227	0.471
5:	-0.282	0.305
6:	-0.300	0.077
7:	-0.252	-0.101
8:	-0.198	-0.349
9:	-0.138	-0.454
10:	0.108	-0.322

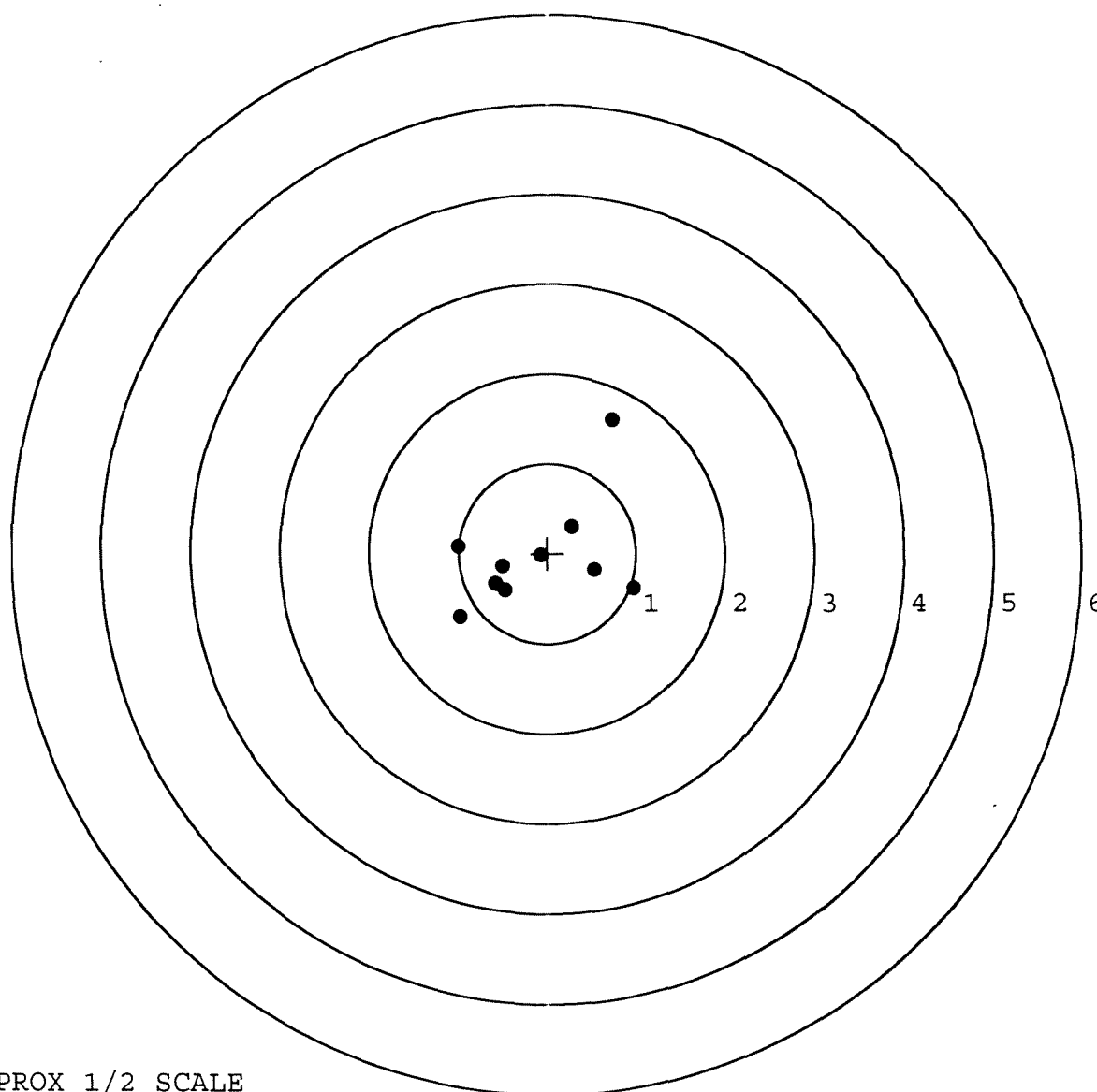


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6414336. 0
TARGET NUMBER: 2
FILE DATE: 05/27/2008
FILE TIME: 06:03

POINT#	X	Y
1:	0.969	-0.390
2:	0.727	1.491
3:	-1.006	0.076
4:	-0.981	-0.710
5:	-0.485	-0.420
6:	-0.511	-0.149
7:	-0.074	-0.025
8:	0.271	0.294
9:	0.533	-0.181
10:	-0.587	-0.346

X CENTROID: -0.114
Y CENTROID: -0.036
POA TO CENTROID: 0.120
HORZ SPREAD: 1.975
VERT SPREAD: 2.201
GROUP SPREAD: 2.786
MIN RADIUS: 0.042
MAX RADIUS: 1.743
MEAN RADIUS: 0.760
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6414336. __0

TARGET NUMBER: 3

FILE DATE: 05/27/2008

FILE TIME: 06:03

X CENTROID: -0.075

Y CENTROID: -0.053

POA TO CENTROID: 0.091

HORZ SPREAD: 2.019

VERT SPREAD: 1.641

GROUP SPREAD: 2.152

MIN RADIUS: 0.593

MAX RADIUS: 1.194

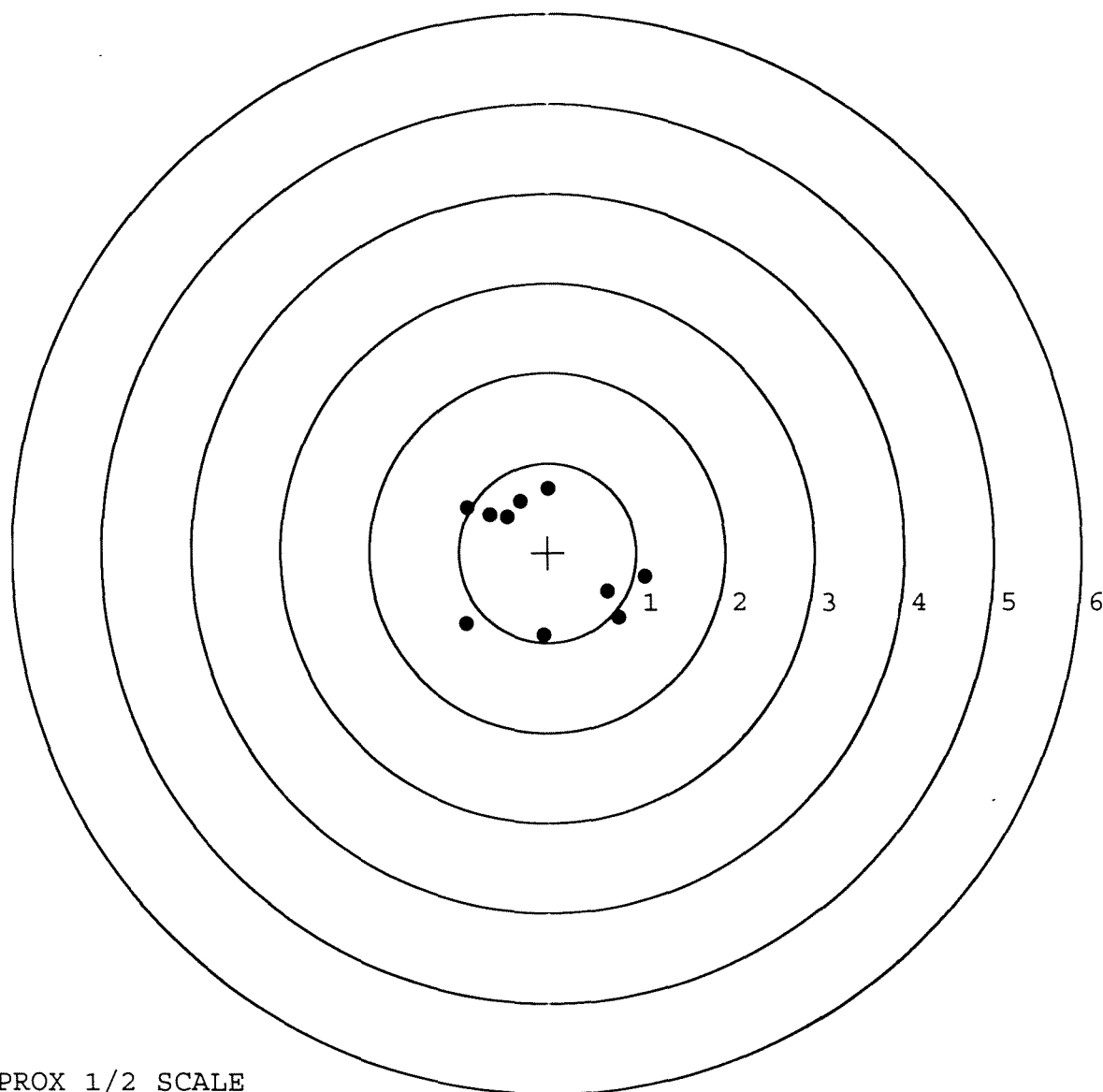
MEAN RADIUS: 0.892

IN 1 IN DIAMETER: 0

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	1.100	-0.267
2:	0.671	-0.429
3:	0.803	-0.720
4:	-0.051	-0.926
5:	-0.919	-0.796
6:	-0.004	0.715
7:	-0.319	0.574
8:	-0.465	0.394
9:	-0.654	0.423
10:	-0.908	0.506



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6414336. 0

TARGET NUMBER: 4

FILE DATE: 05/27/2008

FILE TIME: 06:03

X CENTROID: -0.171

Y CENTROID: -0.064

POA TO CENTROID: 0.182

HORZ SPREAD: 2.177

VERT SPREAD: 1.712

GROUP SPREAD: 2.297

MIN RADIUS: 0.191

MAX RADIUS: 1.324

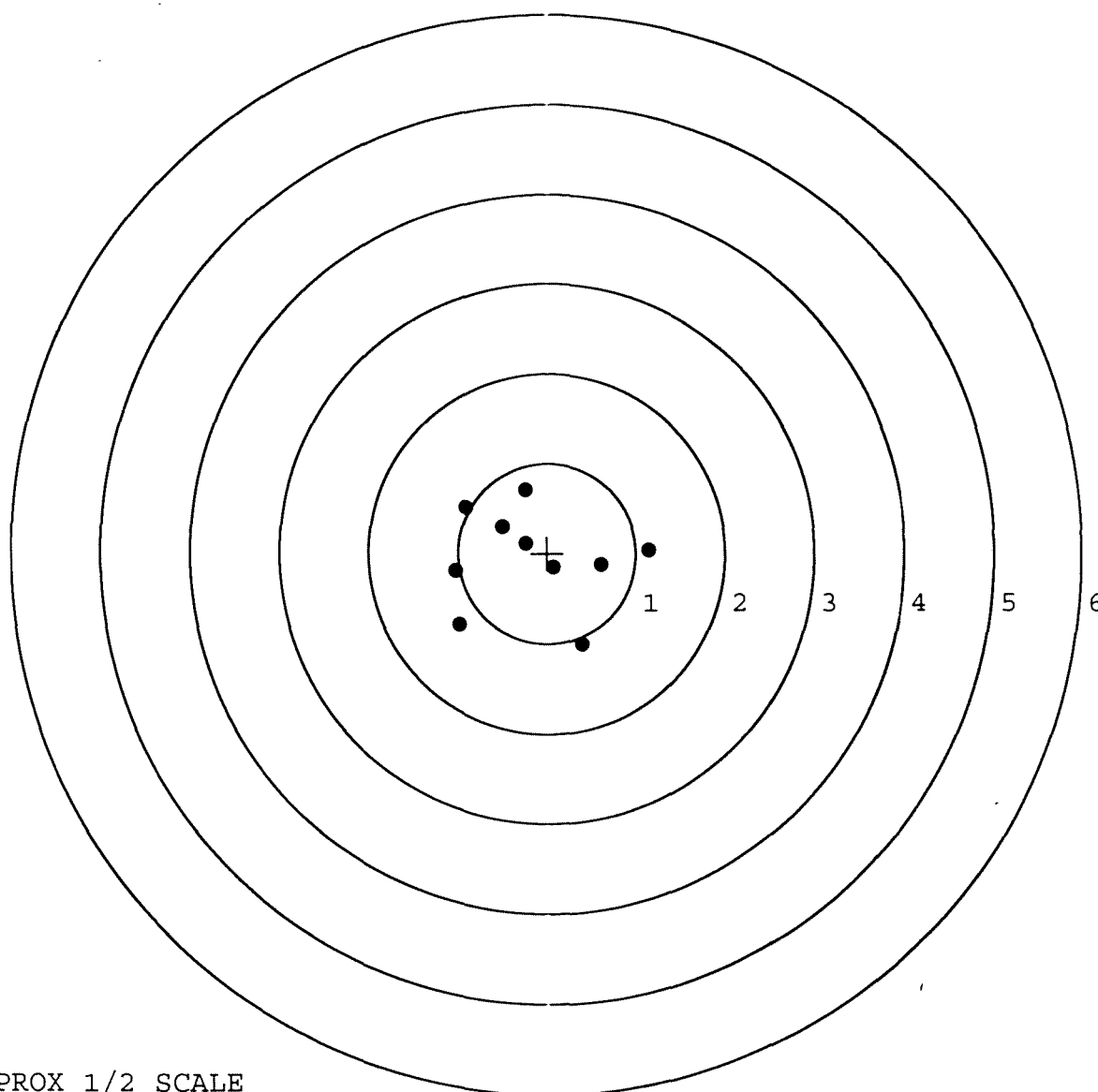
MEAN RADIUS: 0.784

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	1.149	0.037
2:	0.610	-0.129
3:	0.400	-1.009
4:	0.069	-0.165
5:	-0.242	0.113
6:	-0.505	0.300
7:	-0.252	0.703
8:	-0.917	0.508
9:	-1.028	-0.201
10:	-0.992	-0.795



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6414336. 0

TARGET NUMBER: 5

FILE DATE: 05/27/2008

FILE TIME: 06:03

X CENTROID: 0.041

Y CENTROID: -0.117

POA TO CENTROID: 0.124

HORZ SPREAD: 1.833

VERT SPREAD: 1.037

GROUP SPREAD: 1.922

MIN RADIUS: 0.302

MAX RADIUS: 1.094

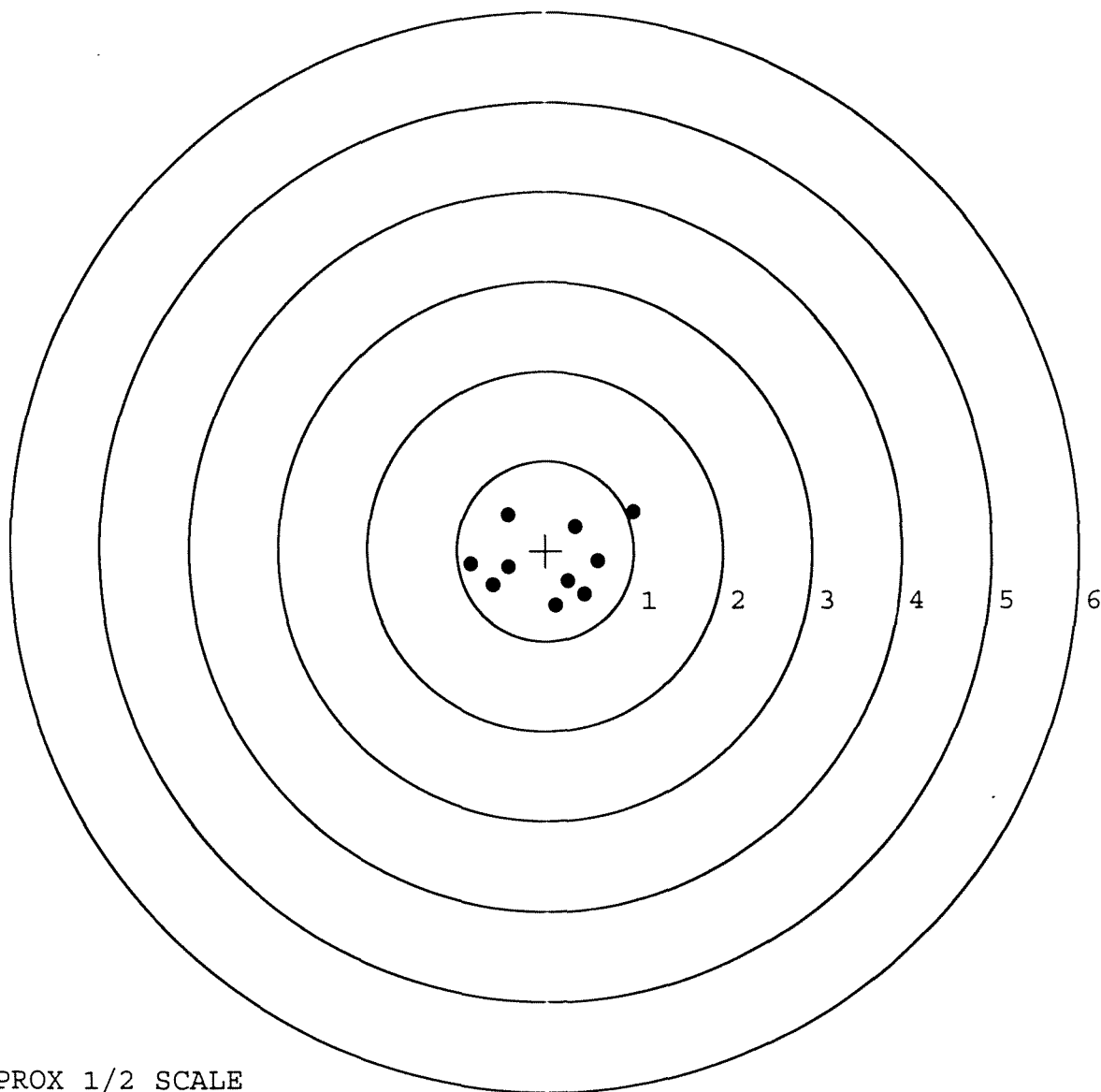
MEAN RADIUS: 0.621

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.988	0.430
2:	0.338	0.267
3:	0.587	-0.117
4:	-0.424	-0.181
5:	-0.598	-0.386
6:	-0.845	-0.147
7:	-0.432	0.396
8:	0.112	-0.607
9:	0.434	-0.486
10:	0.248	-0.337



TARGET APPROX 1/2 SCALE

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

R & E NUMBER

144807

SERIAL NUMBER

G644 4336

LOG-IN DATE

4-24-08

OPERATION #	OPERATION NAME	DATE	INITIAL
500	DIS-ASSEMBLE GUN	4-25-08	RTZ
505	RE-BARREL	4-25-08	LR
560	ASSEMBLE	4-30-08	TRW
600	PROOF	4-30-08	TRW
605	CHECK HEADSPACE	4-30-08	TRW
610	DIS-ASSEMBLE GUN	4-30-08	TRW
612	MAGNAFLUX	5-1-08	TRW
510	DRILL AND TAP	5-1-08	TRW
615	ROLLMARK CALIBER	5-1-08	CW
618	ROTO-BLAST	5-1-08	DS
620	APPLY COATINGS	5-5-08	CW
625	FINAL ASSEMBLY	5-23-08	RTZ
640	FUNCTION TEST AND	5-23-08	RP
650	TARGET	5-23-08	RP
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
670	FINAL INSPECTION	5-27-08	Fm
	A) HEADSPACE	5-27-08	Fm
	B) TRIGGER PULL	2.39 2.38 2.40 2.34 2.37 5-27-08	TRW
680	F) SAFETY ON FORCE	7 6.5 7 5-27-08	Fm
	G) SAFETY OFF FORCE	3 3 3 5-27-08	Fm
	I) FIRING PIN INDENT	.024 .024 .025 5-27-08	Fm
690	PACK	5-29-08	Fm

Repair Inquiry

Repair Number: **RE00092467**

Serial: C6225379 Model: M24 SWS Center Fire
Caliber: 7.62 NATO Produced: 10/26/1988

Repairman:

Status: Closed 2/4/2005 9:37:51 AM

Address Information

Customer:

☒ Received From

Return To:

☐ Received From

Name: DEF DIST DEPOT ANNISTON

DEF DIST DEPOT ANNISTON

Address 1:

Address 2:

P.O. Box:

P.O. Box:

City: ANNISTON

ANNISTON

State: AL

Zip Code: 362014199

Country: US

State: AL

Zip Code: 362014199

Country: US

FFL

Contact / Condition

Problems

Estimate

History / Status

Shipping / Billing

Contact Information

Phone:

Fax:

Email:

Comments:

Received Condition

Good

Condition Notes:

CSR Notes:

Accessories Received

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

Repair Search

Refresh

Close

magletj

2/7/2005

11:27 AM

CAFS

NUM

INS

SCPL

start

3

3

Arms Services R

3

MS

Serial Number:

C6225379

Model: M24 SWS



RE00092467

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6414336.___0
FILE DATE AND TIME: 05/10/2005 07:54

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.022
The Average Y Centroid of the Five Target Set:	-0.099
The Average Point of Impact of the Five Target Set:	0.101
The Average Mean Radius of the Five Target Set:	1.012
The Distance from POA to Centroid Target #1:	0.562
The Distance from Centroid Target #2 to Centroid Target #1:	0.958
The Distance from Centroid Target #3 to Centroid Target #1:	0.388
The Distance from Centroid Target #4 to Centroid Target #1:	0.733
The Distance from Centroid Target #5 to Centroid Target #1:	0.368

SERIAL NUMBER: G6414336. __0

TARGET NUMBER: 1

FILE DATE: 05/10/2005

FILE TIME: 07:54

POINT#	X	Y
1:	1.099	0.075
2:	0.309	-0.261
3:	-0.466	-0.015
4:	-0.898	0.007
5:	-0.212	0.476
6:	0.252	0.813
7:	0.225	-1.026
8:	0.086	-1.931
9:	-1.393	-1.260
10:	-1.987	-1.638

X CENTROID: -0.298

Y CENTROID: -0.476

POA TO CENTROID: 0.562

HORZ SPREAD: 3.086

VERT SPREAD: 2.744

GROUP SPREAD: 3.530

MIN RADIUS: 0.490

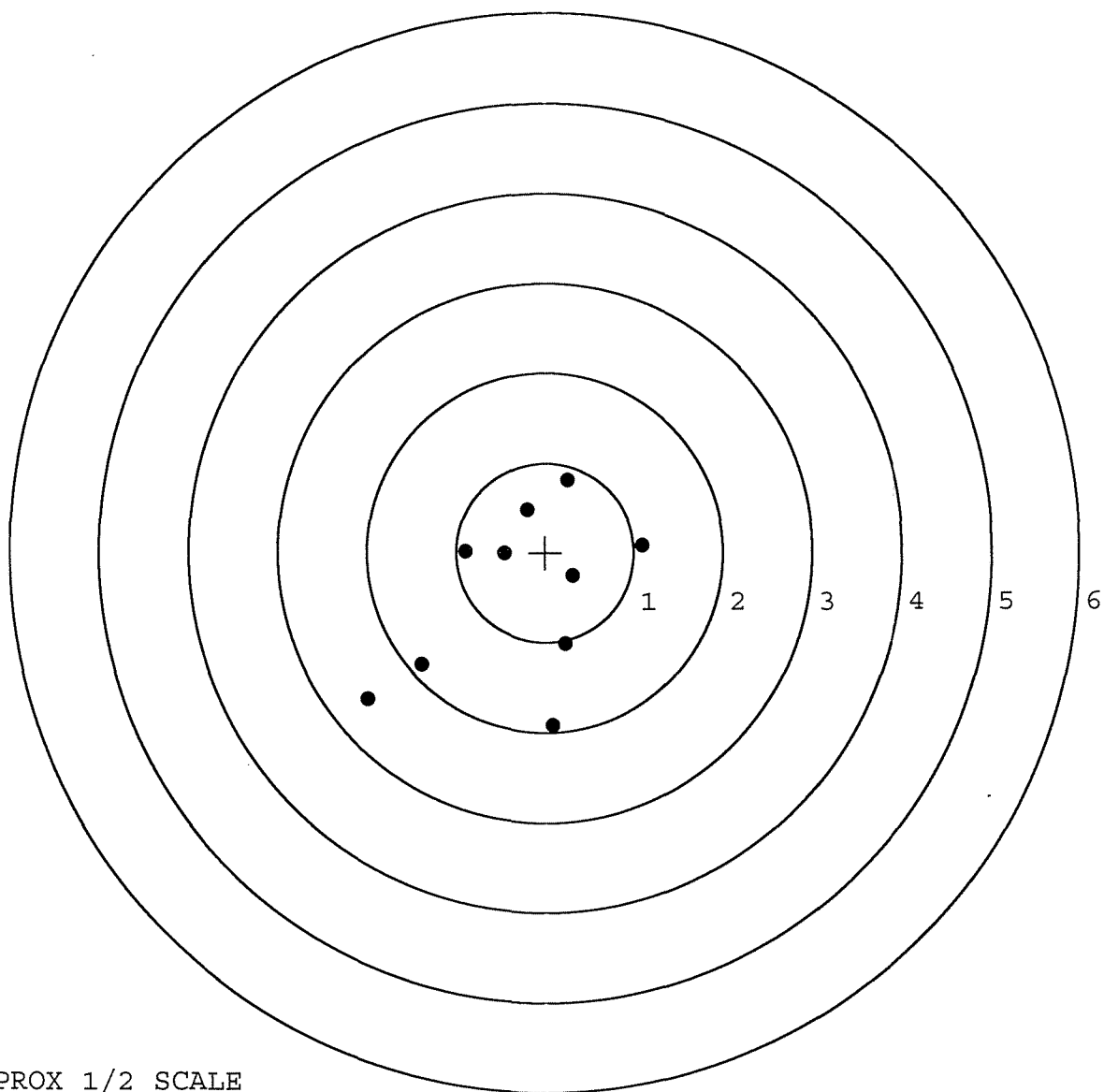
MAX RADIUS: 2.050

MEAN RADIUS: 1.142

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 5

in 3 IN DIAMETER: 7



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6414336. __0

TARGET NUMBER: 2

FILE DATE: 05/10/2005

FILE TIME: 07:54

POINT#	X	Y
1:	0.690	-0.648
2:	0.201	-0.758
3:	0.474	-0.128
4:	0.073	0.195
5:	-0.635	0.463
6:	-0.988	-0.071
7:	1.438	0.309
8:	-0.013	1.040
9:	0.458	1.241
10:	0.700	1.521

X CENTROID: 0.240

Y CENTROID: 0.316

POA TO CENTROID: 0.397

HORZ SPREAD: 2.426

VERT SPREAD: 2.279

GROUP SPREAD: 2.333

MIN RADIUS: 0.206

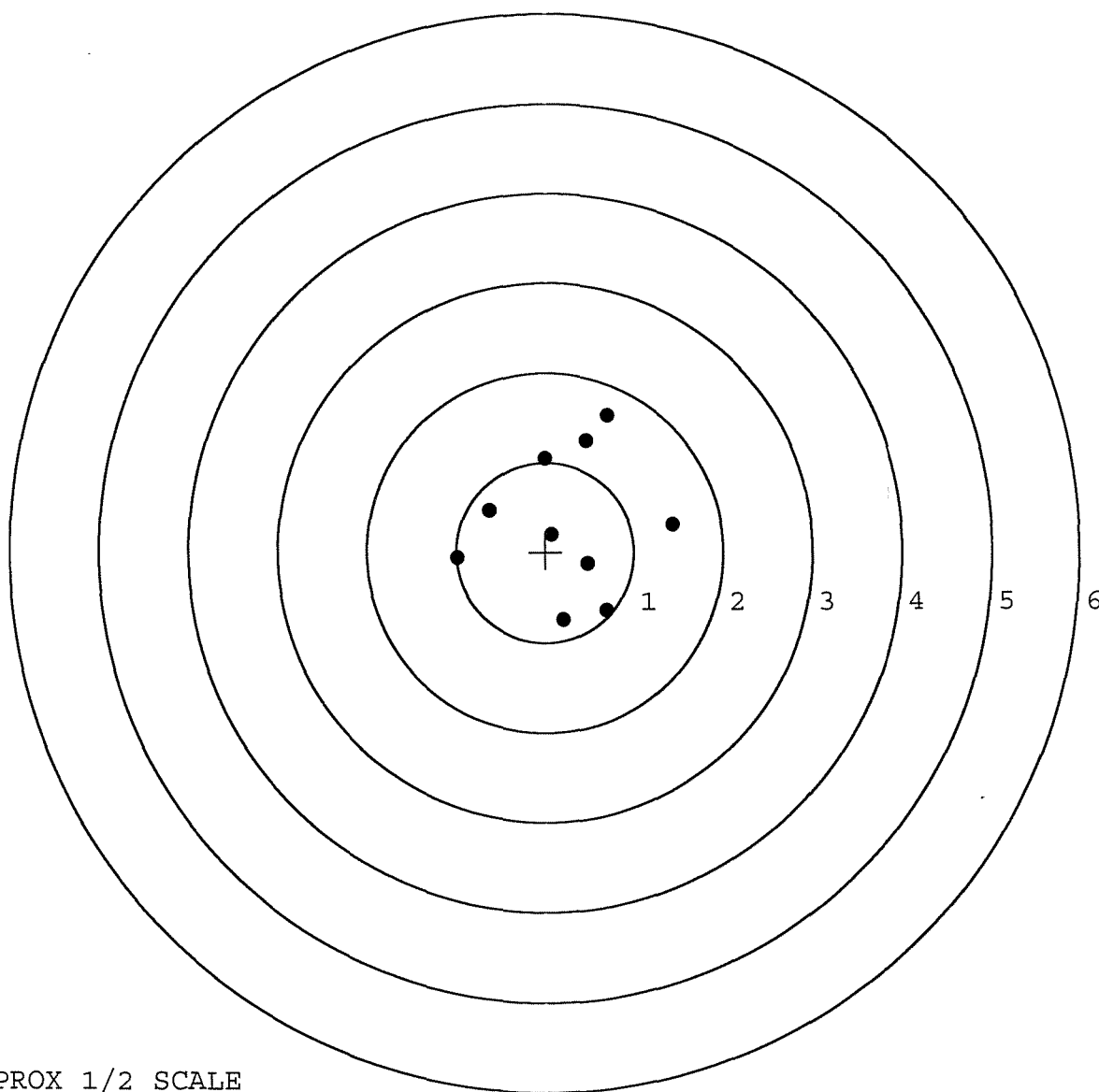
MAX RADIUS: 1.290

MEAN RADIUS: 0.923

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 5

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6414336. __0

TARGET NUMBER: 3

FILE DATE: 05/10/2005

FILE TIME: 07:54

POINT#	X	Y
1:	0.567	-1.341
2:	0.229	-1.423
3:	-0.825	-1.463
4:	0.180	-0.590
5:	0.041	-0.069
6:	0.661	0.333
7:	-0.344	0.034
8:	-0.623	0.211
9:	0.166	0.940
10:	-0.505	1.554

X CENTROID: -0.045

Y CENTROID: -0.181

POA TO CENTROID: 0.187

HORZ SPREAD: 1.486

VERT SPREAD: 3.017

GROUP SPREAD: 3.087

MIN RADIUS: 0.142

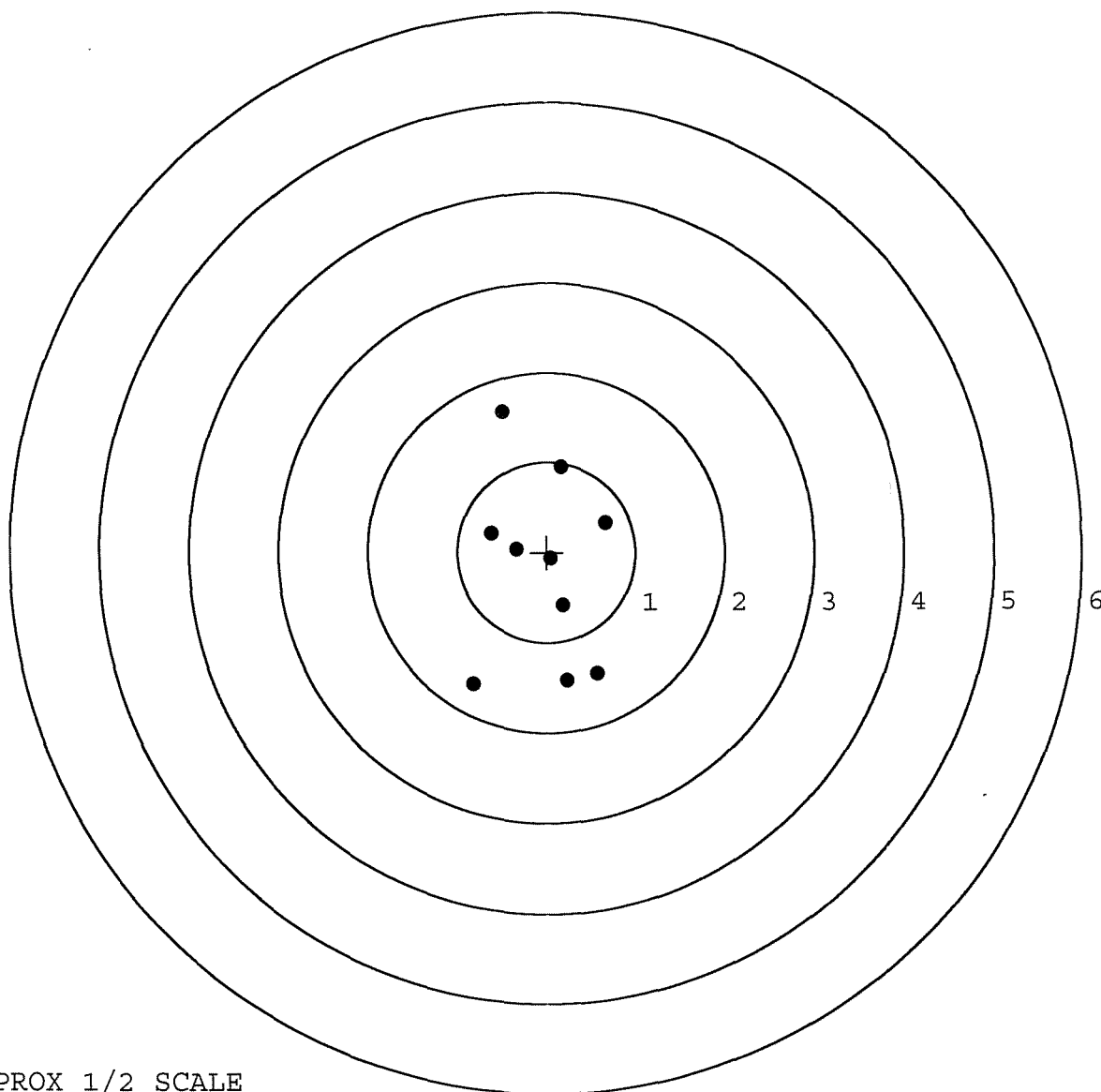
MAX RADIUS: 1.795

MEAN RADIUS: 0.957

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 5

in 3 IN DIAMETER: 8



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6414336. __0

TARGET NUMBER: 4

FILE DATE: 05/10/2005

FILE TIME: 07:54

POINT#	X	Y
1:	1.040	-0.867
2:	0.783	-0.555
3:	0.134	-0.300
4:	-0.299	-0.278
5:	-0.186	0.028
6:	-0.489	0.203
7:	-0.626	-0.599
8:	0.669	1.043
9:	-0.199	1.560
10:	-1.437	1.942

X CENTROID: -0.061

Y CENTROID: 0.218

POA TO CENTROID: 0.226

HORZ SPREAD: 2.477

VERT SPREAD: 2.809

GROUP SPREAD: 3.745

MIN RADIUS: 0.227

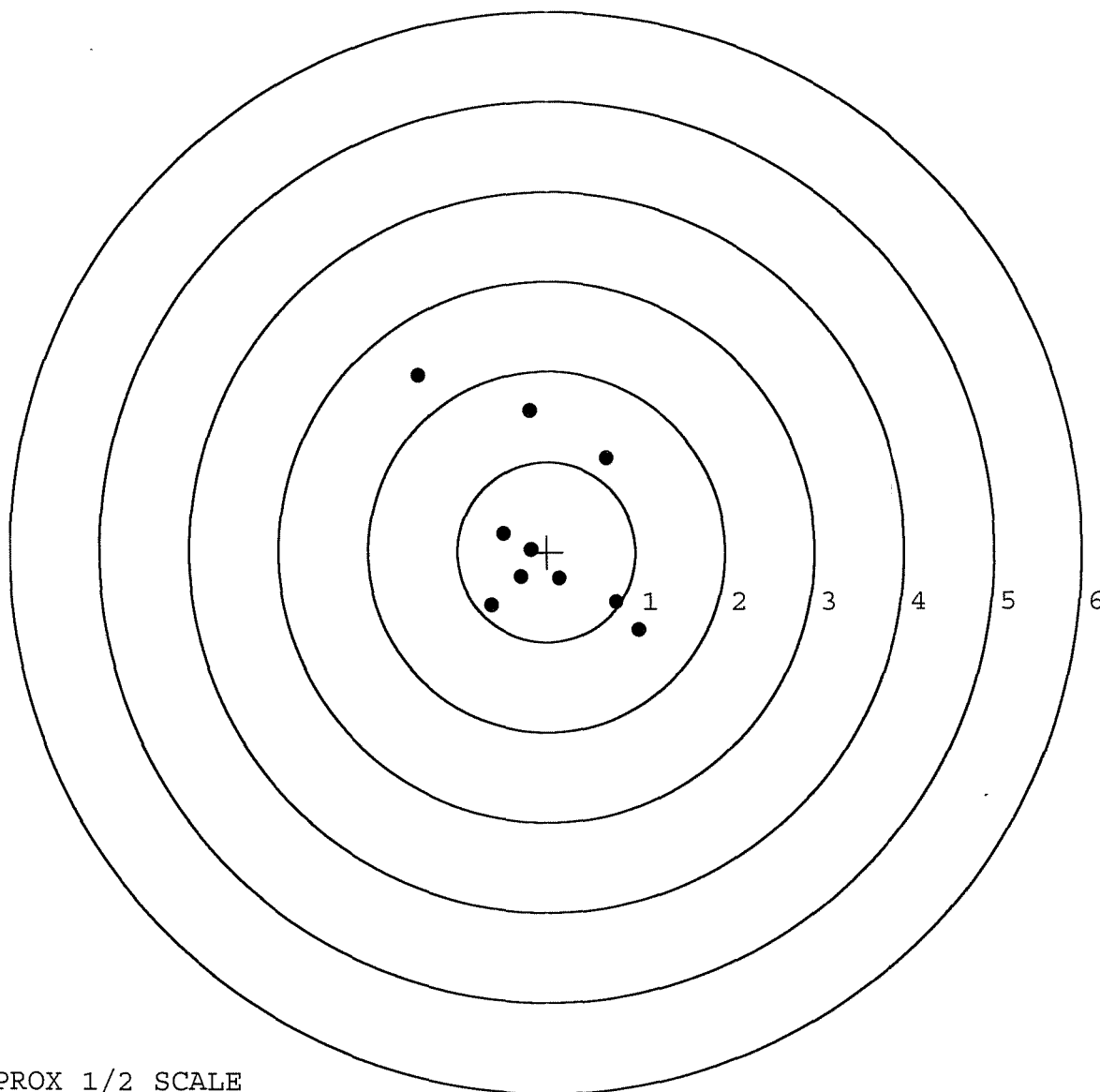
MAX RADIUS: 2.206

MEAN RADIUS: 1.010

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 5

in 3 IN DIAMETER: 8



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6414336. __0

TARGET NUMBER: 5

FILE DATE: 05/10/2005

FILE TIME: 07:54

POINT#	X	Y
1:	1.366	-0.682
2:	0.876	-1.195
3:	0.329	-2.621
4:	0.622	-0.113
5:	-0.173	-0.632
6:	-0.088	0.063
7:	-0.468	0.070
8:	-0.742	0.061
9:	-0.634	0.486
10:	-0.544	0.854

X CENTROID: 0.054

Y CENTROID: -0.371

POA TO CENTROID: 0.375

HORZ SPREAD: 2.108

VERT SPREAD: 3.475

GROUP SPREAD: 3.583

MIN RADIUS: 0.346

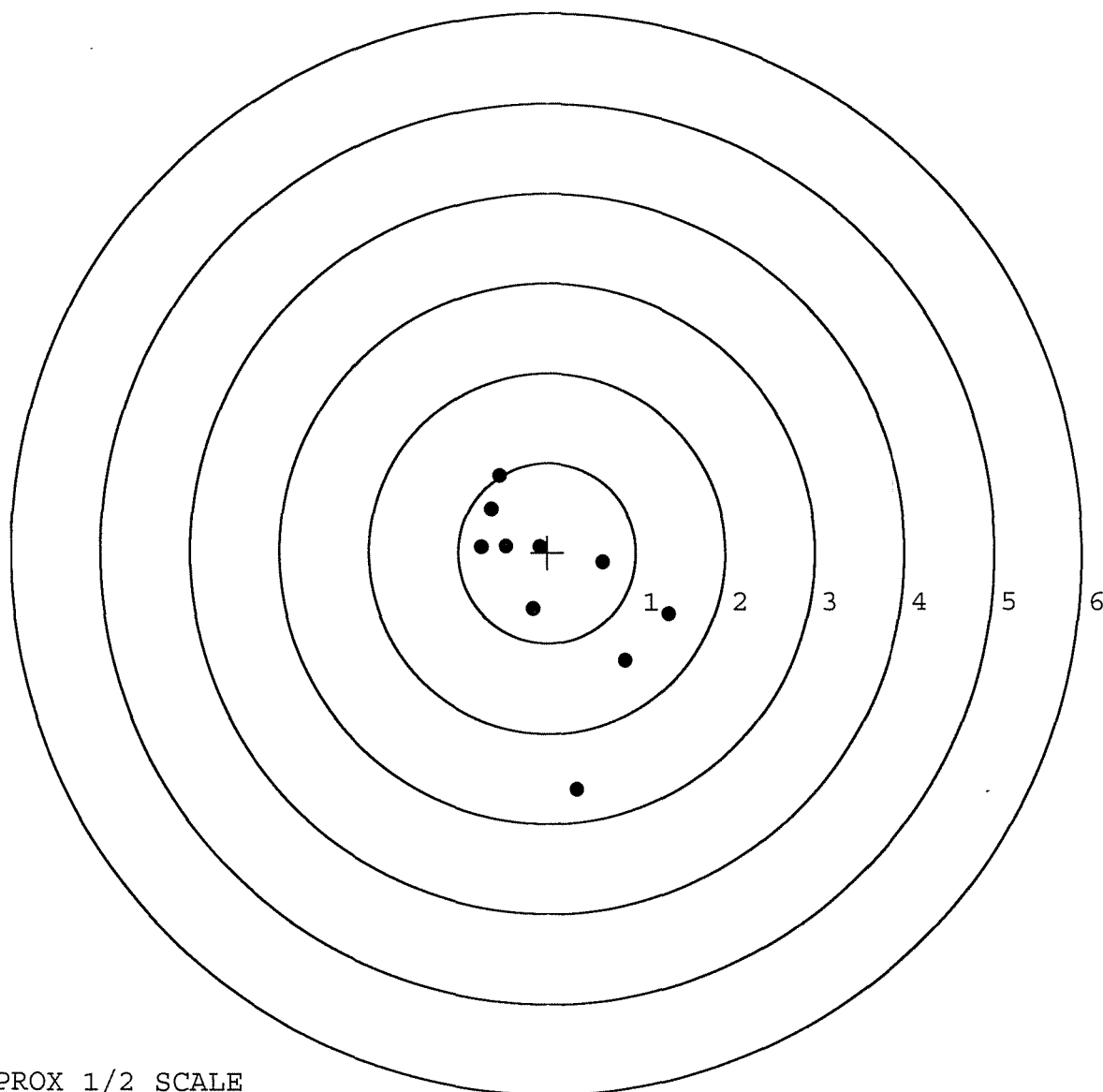
MAX RADIUS: 2.267

MEAN RADIUS: 1.026

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 5

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

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

R & E NUMBER	92467		
SERIAL NUMBER	C6225379	C641433 (6 New)	
LOG-IN DATE	2-4-05		
INSPECT AND VERIFY:			
OPERATION #	OPERATION NAME	DATE	INITIAL
550	DIS-ASSEMBLE GUN	4-4-05	RTZ
560 A	RE-BARREL	4-7-05	RTZ
B	DRILL AND TAP	4-11-05	TRW
575	ASSEMBLE	4-7-05	RTZ
600	PROOF	4-8-05	AC
605	CHECK HEADSPACE	4-8-05	AC
610	DIS-ASSEMBLE GUN	4-11-05	RTZ
612	MAGNAFLUX	4-12-05	CW
615	ROLLMARK CALIBER	4-18-05	LB
618	ROTO-BLAST	4-25-05	LB
620	APPLY COATINGS	4-25-05	CW
625 A	FINAL ASSEMBLY	5-4-05	RTZ
B	TRIGGER PULL TEST		
C	SAFETY "ON" FORCE	5-10-05	AC
D	SAFETY "OFF" FORCE	5-10-05	AC
E	FIRING PIN INDENT	5-10-05	AC
640	TARGET	5-10-05	TRW
655	FINAL INSPECT	5-10-05	AC
660	PACK	5-11-05	RTZ
		SHIP DATE	
QAR INSPECTION DATE			

R 95-08694

FROM:	SHIP TO:
DEPARTMENT OF THE ARMY COMMANDER D CO 2ND BN 1ST SWTG FORT BRAGG NC 28307	DEPARTMENT OF THE ARMY COMMANDER D CO 2ND BN 1ST SWTG FORT BRAGG NC 28307

CUSTOMER CONCERN	AMMO	FUNCTION	FINISH	ACCURACY	FIT	INSPECT
CYCLE	A1	B1				
TRIGGER GROUP		B2			E1	F1
BOLT ASSY.		B3			E2	F2
BARREL ASSY.	New Barrel			D1	E3	F3
REC. ASSY.		B5		D2	E4	F4
WOOD			C1	D3	E5	F5
METAL			C2			
MAIN FAULT						

OFFICE COPY

RD6925 BEV 1/94

M2400150535

PAYMENT:

Mastercard / Visa (circle one)

Card #: _____

Exp. Date: _____

Signature: _____

RETURN:

☐ Clark Street Entrance☐ Via US Mail or UPS

(PLEASE PRINT CLEARLY)

FIREARMS DELIVERED TO PLANT

FILE Nº 009499DATE 3/13/95CUSTOMER NAME: US ARMY

REMINGTON EMPLOYEE:

ADDRESS: D Co 2nd Bn 1st SGTGYES ☐ NO ☒

EMPLOYEE # _____

ZIP: 28307

DEPT. # _____

PHONE: 910 499 9037FIREARM MODEL: M-24

CHECK FOR AMMUNITION

GAUGE: 7.62SERIAL # 06925-379

CONDITION:

WOOD N/A GOOD FAIR POOR FANCY PLAIN

METAL GOOD FAIR POOR FANCY PLAIN

BARREL VT. RIB PLAIN DEER RSS

ACCESSORIES:

SCOPE: YES NO (BRAND NAME/POWER) _____

SLING: YES NO GUN CASE: YES NO (HARD - SOFT)

EXTRA BBL FOR GUN MENTIONED ABOVE:

OTHER (Note in this area items missing or added from orig. equipment)

CUSTOMER REQUEST: scope base
ReconditioningSIGNATURE: _____
(Person delivering firearm to Plant)DATE: 13 mar 95SIGNATURE: _____
(Security Officer)DATE: 3/13/95SIGNATURE: _____
(Firearm picked up by)DATE: 3-14-95

Arm Service Copy

Final Inspection

Sn: C6225379

DATE REC'D: 3/14/95

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:

CONTRACT # DAAA21-87-C-0086

New Barrel

GUN SERIAL # C6225379

OP. #	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and Stock		3/16/95	RW
600	Proof		3/16/95	RW
607	Check Headspace		3/16/95	RW
610	Dis-assemble Gun		3/16/95	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		3/31/95	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		3/31/95	RW
	C) Inspect Ejector Hole for Chamfer		3/31/95	RW
	D) Oil Firing Pin Ass'y		3/31/95	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		4/3/95	Rw
	A) Time			
	B) Malfunctions			
	C) Pierced Primers			
	D) Optical Clarity of Scope			
645	Inspect for Live Ammo		4/3/95	Rw
655	Final Inspection			
	A) Headspace		4/3/95	Rw
	B) Trigger Pull			
	C) Function		4/3/95	Rw
660	Pack			

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06225379
22 May 1995

CENTROIDAL DISTANCES

0 TO	1	.306036
1 TO	2	.311294
1 TO	3	.247413
1 TO	4	.28372
1 TO	5	.336013

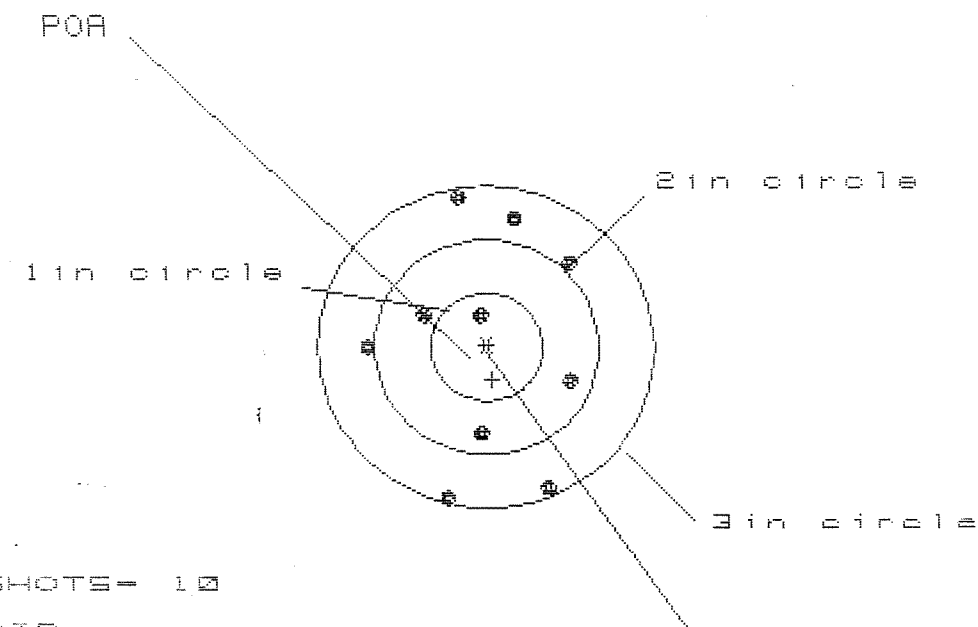
312
54+ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1056
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .2278
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .251086
THE AMR FOR THIS RIFLE IS: .9998

25 Apr 1995

FILE:/PATTERNING/CENTERFIRE_PATT/C8225379

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1in = 1

2in = 4

3in = 10

HS= 1.835

VS= 2.829

GS= 2.831

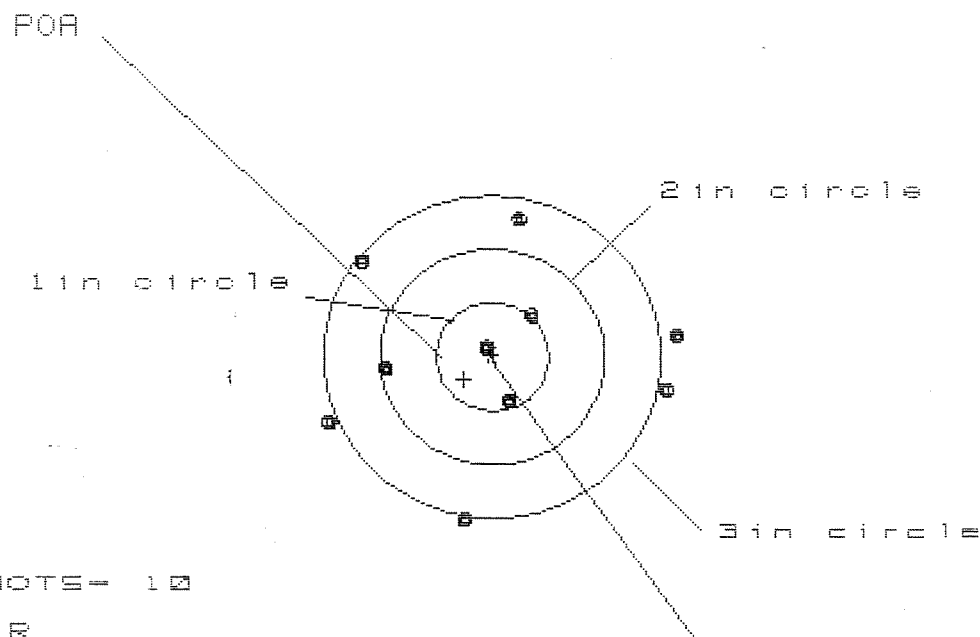
CENTROID #

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.782	.744	.812
MINIMUM X	:	-1.053	-1.091	-1.023
MAXIMUM Y	:	1.388	1.228	1.043
MINIMUM Y	:	-1.441	-1.480	-1.171
CENTROID X	:	-.043	-.005	-.073
CENTROID Y	:	.303	.463	.648
POA TO CENTROID in.	:	.306	.463	.652
MIN RADIUS	:	.284	.162	.085
MEAN RADIUS	:	1.031	.959	.852
MAX RADIUS	:	1.482	1.578	1.171
HORIZONTAL SPREAD	:	1.835	1.835	1.835
VERTICAL SPREAD	:	2.829	2.708	2.214
EXTREME SPREAD	:	2.831	2.829	2.222
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		10	

25 Apr 1995

FILE:/PATTERNING/CENTERFIRE_PATT/CG225379

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1in = 2

2in = 4

3in = 6

HS= 3.178

VS= 2.802

GS= 3.272

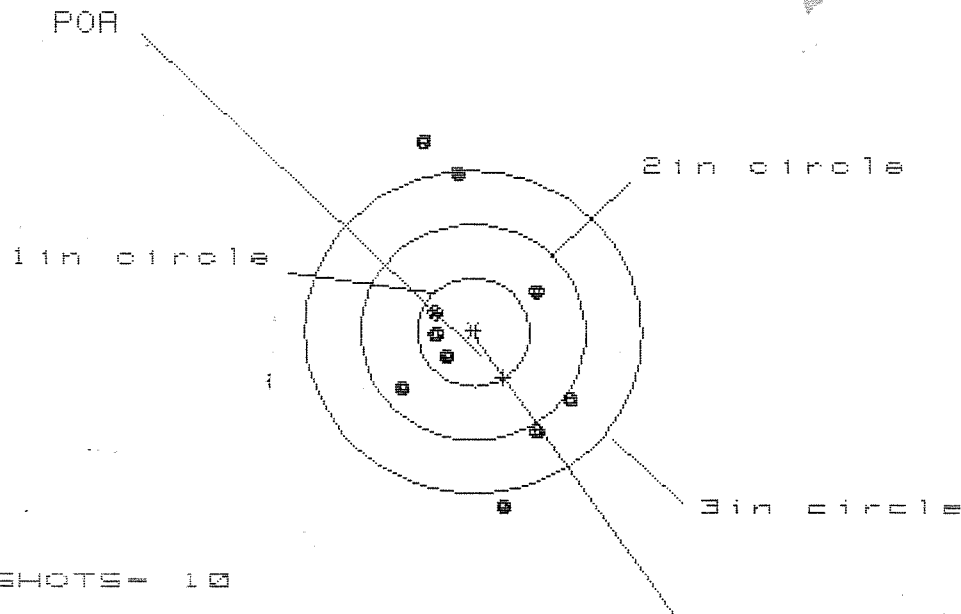
PATTERN #	:	2	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.694	1.769	.798
MINIMUM X	:	-1.484	-1.296	-1.075
MAXIMUM Y	:	1.310	1.333	1.294
MINIMUM Y	:	-1.492	-1.469	-1.508
CENTROID X	:	.255	.067	-.154
CENTROID Y	:	.213	.190	.229
POA TO CENTROID in.	:	.332	.201	.276
MIN RADIUS	:	.143	.152	.320
MEAN RADIUS	:	1.133	1.062	.975
MAX RADIUS	:	1.706	1.796	1.514
HORIZONTAL SPREAD	:	3.178	3.065	1.873
VERTICAL SPREAD	:	2.802	2.802	2.802
EXTREME SPREAD	:	3.272	3.074	2.847
NUMBER IN ONE INCH CIRCLE =	:	2		
NUMBER IN TWO INCH CIRCLE =	:	4		
NUMBER IN THREE INCH CIRCLE =	:	6		

25 Apr 1995

FILE:/PATTERNING/CENTERFIRE_PATT/06225379

CENTERFIRE PATTERNS

3



OF SHOTS- 10

IN CIR

1in = 3

2in = 5

3in = 8

HS= 1.501

VS= 3.358

GS= 3.427

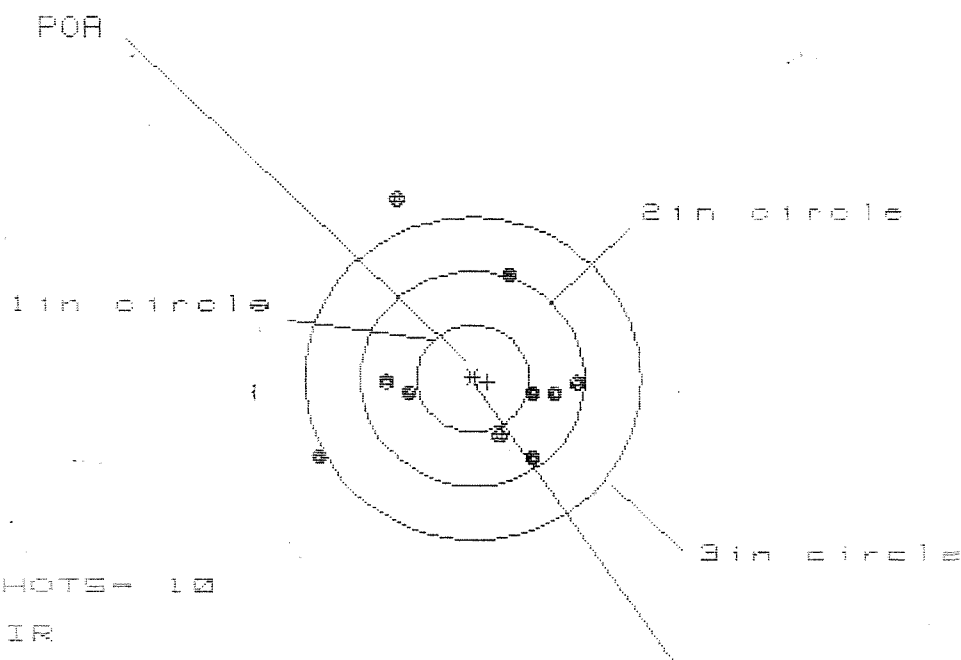
CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.849	.801	.825
MINIMUM X	:	-.652	-.700	-.675
MAXIMUM Y	:	1.779	1.631	1.459
MINIMUM Y	:	-1.579	-1.382	-.887
CENTROID X	:	-.261	-.213	-.237
CENTROID Y	:	.420	.223	.396
POR TO CENTROID in.	:	.495	.308	.461
MIN RADIUS	:	.309	.286	.332
MEAN RADIUS	:	.952	.844	.763
MAX RADIUS	:	1.832	1.644	1.470
HORIZONTAL SPREAD	:	1.501	1.501	1.501
VERTICAL SPREAD	:	3.358	3.013	2.345
EXTREME SPREAD	:	3.427	3.040	2.439
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

25 Apr 1995

FILE:/PATTERNING/CENTERFIRE_PATT/C6225379

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 0

2in = 8

3in = 8

HS= 2.355

VS= 2.423

GS= 2.730

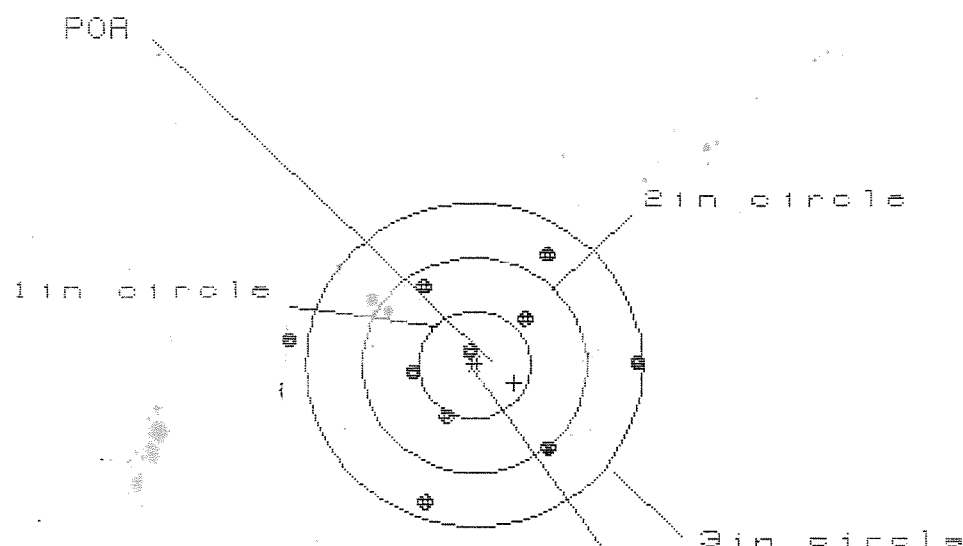
CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.976	.897	.715
MINIMUM X	:	-1.379	-1.458	-1.034
MAXIMUM Y	:	1.643	1.120	1.053
MINIMUM Y	:	-.780	-.598	-.665
CENTROID X	:	-.127	-.048	.134
CENTROID Y	:	.032	-.150	-.083
POA TO CENTROID in.	:	.131	.158	.157
MIN RADIUS	:	.528	.385	.247
MEAN RADIUS	:	.948	.816	.686
MAX RADIUS	:	1.789	1.555	1.055
HORIZONTAL SPREAD	:	2.355	2.355	1.749
VERTICAL SPREAD	:	2.423	1.718	1.718
EXTREME SPREAD	:	2.730	2.443	1.749
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		8	

25 Apr 1935

FILE:/PATTERNING/CENTERFIRE_PATT/C8225379

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 9

HS= 3.138

VS= 2.260

GS= 3.141

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.481	1.296	.653
MINIMUM X	:	-1.657	-.692	-.529
MAXIMUM Y	:	.998	1.019	1.029
MINIMUM Y	:	-1.262	-1.241	-1.231
CENTROID X	:	-.352	-.167	-.330
CENTROID Y	:	.171	.150	.140
POA TO CENTROID in.	:	.391	.225	.358
MIN RADIUS	:	.170	.307	.208
MEAN RADIUS	:	.935	.864	.780
MAX RADIUS	:	1.668	1.385	1.312
HORIZONTAL SPREAD	:	3.138	1.988	1.182
VERTICAL SPREAD	:	2.260	2.260	2.260
EXTREME SPREAD	:	3.141	2.516	2.516
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

00000

5091

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6225379

OPERATION		DATE	INT
#	NAME		
575- 580	ASSEMBLY	2 26	FE
600	PROOF		Ru
615	MAGNAFLUX BARREL	5/13/88	Pfe.
	MAGNAFLUX BOLT	5/13/88	Pfe.
620	COATING	8/11/88	JH
625- 630	FINAL ASSEMBLY		
635	TEST		
640	TARGET		
	FIRING PIN INDENT		
660	PACK		

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6225379

OP.#	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and stock			
600	Proof			
607	Check Headspace			
610	Dis-assemble gun			
612	Magnaflux Barrel Action			
	Magnaflux Bolt			
615	Rollmark Caliber			
617	Drill & Tap Sight Holes			
618	Polish Barrel			
620	Apply Coatings (Barrel Action)			
	Apply Coatings (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/26/88	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/26/88	RW
	C) Inspect Ejector Hole for Chamfer		8/26/88	RW

OVER

OP.#		READINGS	DATE	INITIAL
625 cont.	D) Oil Firing Pin Ass'y		8/26/88	RW
	E) Adjust Trigger Pull to Min. Setting and Stake		26 aug 88	W.B. + J.S.
	F) Safety on Force	6 6 5.5	26 aug 88	W.B. + J.S.
	G) Safety off Force	3.25 3 3	26 aug 88	W.B. + J.S.
	H) Trigger Pull Test & Retainabilty		26 aug 88	W.B. + J.S.
	I) Firing Pin Indent	.022 .0225 .022	26 aug 88	W.B. + J.S.
	J) Assemble Stock		9/21/88	RW
	K) Assemble Swivel Studs		10-13-88	J.S.
	L) Attach Front & Rear Sight Assemblies		9/21/88	RW
	M) Iron Sight Alignment		9/21/88	RW
	N) Detach Front & Rear Sights & place in numbered container		9/21/88	RW
	O) Attach Scope to Rifle		10/4/88	RW
	P) Detach & Attach Scope 20 times	64 R 91 L	10/5/88	J.S.
640	Gallery Target & Test	RESHOT. 10/12/88	10-10-88	AC
	A) Optical Clarity of Scope	OK	10-10-88	AC
645	Inspect for Live Ammo	NONE	10-10-88	AC
655	Final Inspection			
	A) Headspace		10-13-88	J.S.
	B) Trigger Pull		10-14-88	J.S.
	C) Function		10-13-88	J.S.
660	Pack		10-21-88	J.S.

SWS TRIGGER PULL TEST

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

SERIAL NO. C6225379

DATE 26 Aug 88

TESTER W.B. + K.2

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.68	2.22	2.51	2.23 2.23	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.56	2.21	2.31	2.29 2.29	
PULL #3	2.60	2.20	2.38	2.35 2.35	
PULL #4	2.49	2.18	2.33	2.32	
PULL #5	2.56	2.19	2.38	2.37	
TOTAL	12.89	11.00	11.81	11.70	
AVG.	2.578	2.20	2.362	2.34	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.42	3.52		
PULL #2	3.47	3.49		
PULL #3	3.40	3.51		
PULL #4	3.50	3.50		
PULL #5	3.51	3.54		
TOTAL	17.30	17.56		
AVG.	3.46	3.512		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.35	4.23		4.06
PULL #2	4.27	4.29		4.21
PULL #3	4.28	4.34		4.18
PULL #4	4.33	4.24		4.10
PULL #5	4.37	4.30		4.22
TOTAL	21.60	21.40		20.77
AVG.	4.32	4.28		4.154

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06225379

Retest

CENTROIDAL DISTANCES

0 TO	1	1.4099
1 TO	2	1.04313
1 TO	3	1.36581
1 TO	4	.90649
1 TO	5	1.19664

4⁵ + <----POA
1 23

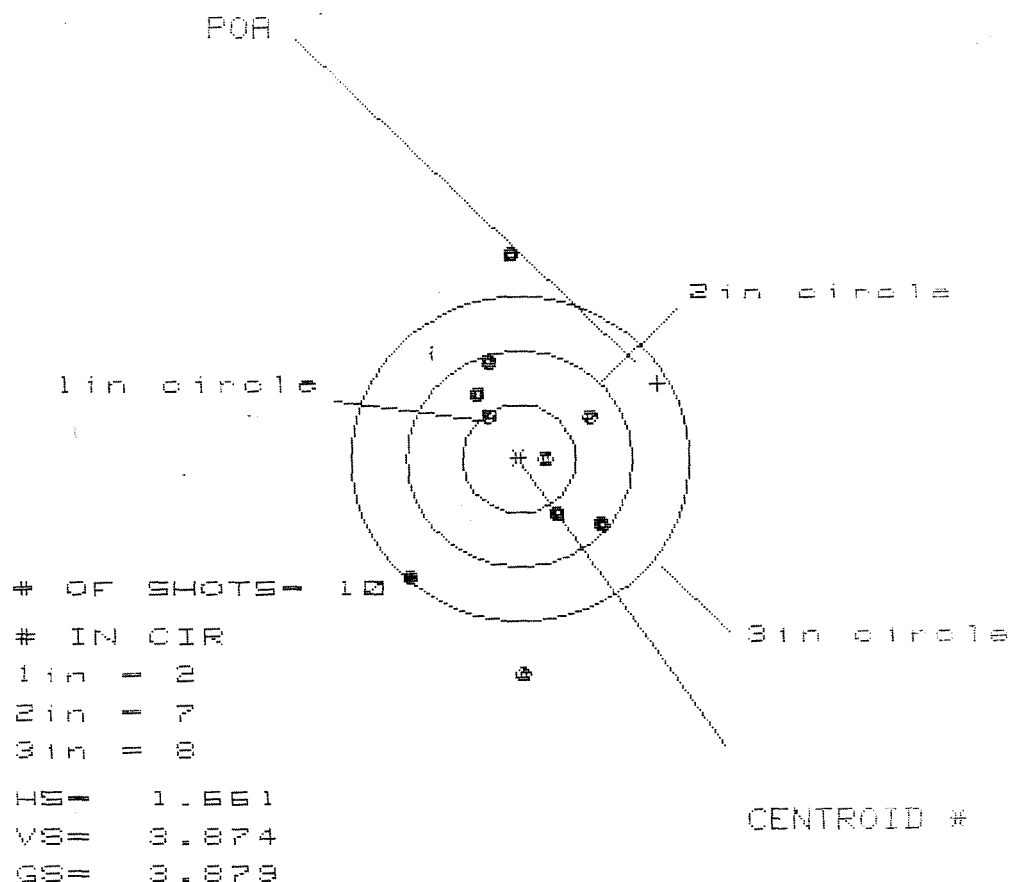
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.496
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.4172
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .648129
THE AMR FOR THIS RIFLE IS: 1.123

12 Oct 1988

FILE:/PATTERNING/CENTERFIRE_PATT/06225379

Retest

CENTERFIRE PATTERNS # 1



PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.734	.742	.729
MINIMUM X	:	-.927	-.919	-.932
MAXIMUM Y	:	1.849	1.624	.883
MINIMUM Y	:	-2.025	-1.285	-1.082
CENTROID X	:	-1.225	-1.233	-1.220
CENTROID Y	:	-.698	-.473	-.678
POA TO CENTROID in.	:	1.410	1.321	1.395
MIN RADIUS	:	.213	.296	.210
MEAN RADIUS	:	.988	.846	.747
MAX RADIUS	:	2.026	1.628	1.428
HORIZONTAL SPREAD	:	1.661	1.661	1.661
VERTICAL SPREAD	:	3.874	2.909	1.965
EXTREME SPREAD	:	3.879	3.019	2.170
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		8	

Retest

12 Oct 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C8225379

CENTERFIRE PATTERNS # 2

POA

1 in circle

2 in circle

3 in circle

CENTROID #

OF SHOTS- 10

IN CIR

1 in = 2

2 in = 5

3 in = 8

HS= 1.532

VS= 5.096

GS= 5.220

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.724	.634	.663
MINIMUM X	:	-.808	-.664	-.635
MAXIMUM Y	:	2.774	1.654	1.402
MINIMUM Y	:	-2.322	-2.014	-1.015
CENTROID X	:	-.197	-.107	-.136
CENTROID Y	:	-.875	-1.183	-.931
POA TO CENTROID in.	:	.897	1.188	.941
MIN RADIUS	:	.221	.167	.138
MEAN RADIUS	:	1.143	.907	.758
MAX RADIUS	:	2.889	2.027	1.539
HORIZONTAL SPREAD	:	1.532	1.298	1.298
VERTICAL SPREAD	:	5.096	3.668	2.417
EXTREME SPREAD	:	5.220	3.776	2.743
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

Retest

12 Oct 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C8225379

CENTERFIRE PATTERNS # 3

POA

1 in circle

2 in circle

3 in circle

OF SHOTS - 10

IN CIR

1 in = 0

2 in = 3

3 in = 8

HS= 2.026

VS= 3.301

GS= 3.420

CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.973	1.068	1.075
MINIMUM X	:	-1.053	-.958	-.951
MAXIMUM Y	:	1.584	1.132	.939
MINIMUM Y	:	-1.717	-1.541	-1.251
CENTROID X	:	.137	.042	.035
CENTROID Y	:	-.800	-.976	-.783
POA TO CENTROID in.	:	.811	.977	.784
MIN RADIUS	:	.800	.754	.795
MEAN RADIUS	:	1.219	1.150	1.076
MAX RADIUS	:	1.800	1.542	1.425
HORIZONTAL SPREAD	:	2.026	2.026	2.026
VERTICAL SPREAD	:	3.301	2.673	2.190
EXTREME SPREAD	:	3.420	2.735	2.559
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		8	

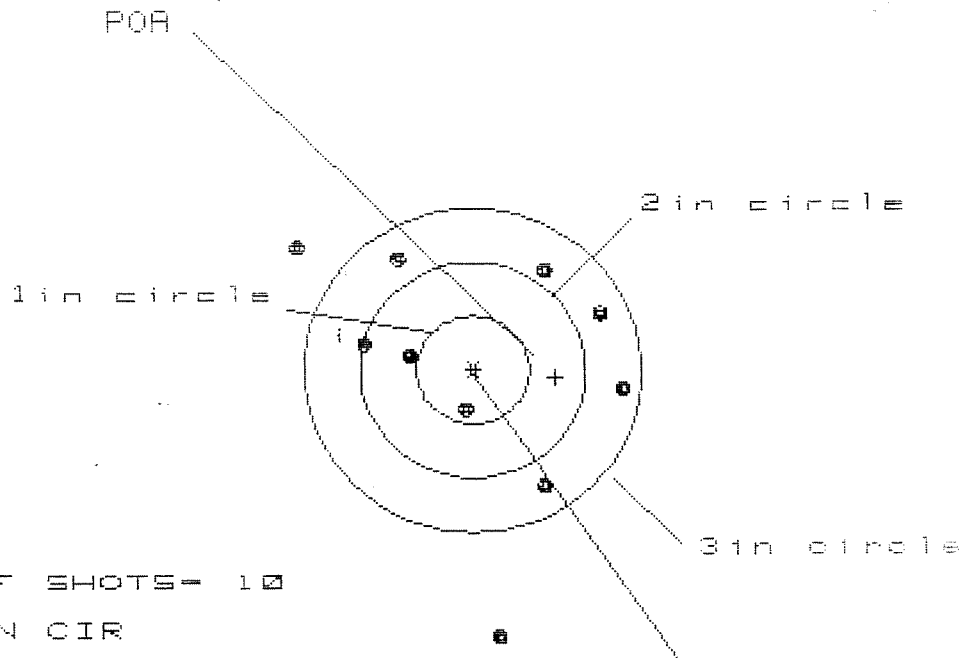
Retest

12 Oct 1988

FILE:/PATTERNING/CENTERFIRE_PATT/08225379

CENTERFIRE PATTERNS

4



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 2

3 in = 8

HS= 2.877

VS= 3.572

GS= 4.009

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.304	1.331	1.138
MINIMUM X	:	-1.573	-1.546	-1.157
MAXIMUM Y	:	1.118	.845	.885
MINIMUM Y	:	-2.454	-1.384	-1.278
CENTROID X	:	-.734	-.761	-.568
CENTROID Y	:	.064	.337	.232
POA TO CENTROID in.	:	.736	.832	.613
MIN RADIUS	:	.367	.598	.570
MEAN RADIUS	:	1.262	1.112	1.023
MAX RADIUS	:	2.467	1.762	1.348
HORIZONTAL SPREAD	:	2.877	2.877	2.295
VERTICAL SPREAD	:	3.572	2.229	2.164
EXTREME SPREAD	:	4.009	3.141	2.510
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	2		
NUMBER IN THREE INCH CIRCLE	=	8		

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 6225379

CENTROIDAL DISTANCES

0 TO 1 .732023
1 TO 2 .910381
1 TO 3 1.00568
1 TO 4 1.41317
1 TO 5 2.33187

5

$\frac{4}{5}x$

+ <----POA

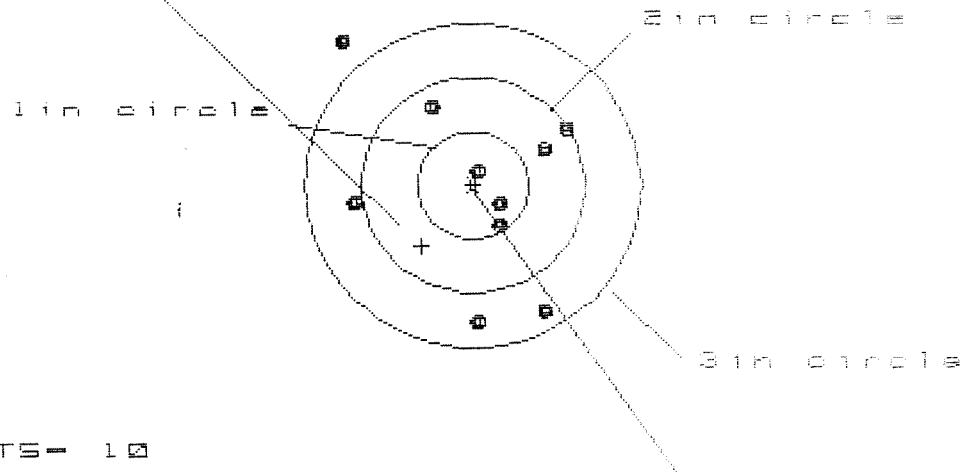
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.5266
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: 1.0404
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: 1.16608
THE AMR FOR THIS RIFLE IS: 1.221

11 Oct 1988

FILE:/PATTERNING/CENTERFIRE_PATT/6225379

CENTERFIRE PATTERNS # 1

FOR



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 6

3 in = 9

HS= 2.004

VS= 2.607

GS= 3.032

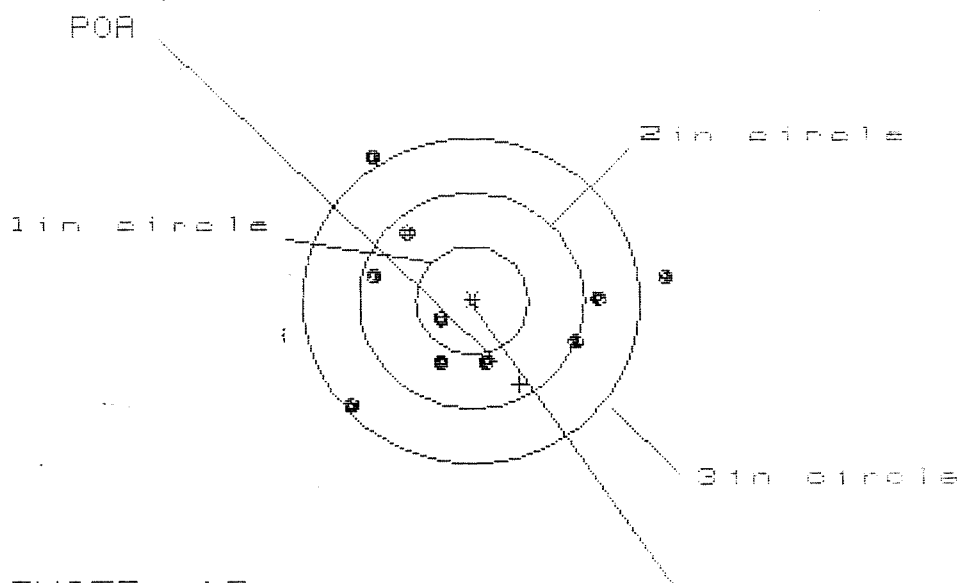
CENTROID *

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.822	.690	.683
MINIMUM X	:	-1.182	-1.162	-1.169
MAXIMUM Y	:	1.301	.920	.775
MINIMUM Y	:	-1.306	-1.161	-1.161
CENTROID X	:	.463	.595	.602
CENTROID Y	:	.567	.422	.567
FOR TO CENTROID in.	:	.732	.729	.827
MIN RADIUS	:	.150	.122	.170
MEAN RADIUS	:	.873	.748	.693
MAX RADIUS	:	1.758	1.162	1.245
HORIZONTAL SPREAD	:	2.004	1.852	1.852
VERTICAL SPREAD	:	2.607	2.081	1.936
EXTREME SPREAD	:	3.032	2.137	2.137
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

01 Oct 1988

FILE:/PATTERNING/CENTERFIRE_PATT/6825375

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 6

3 in = 8

HS= 2.743

VS= 2.369

GS= 3.022

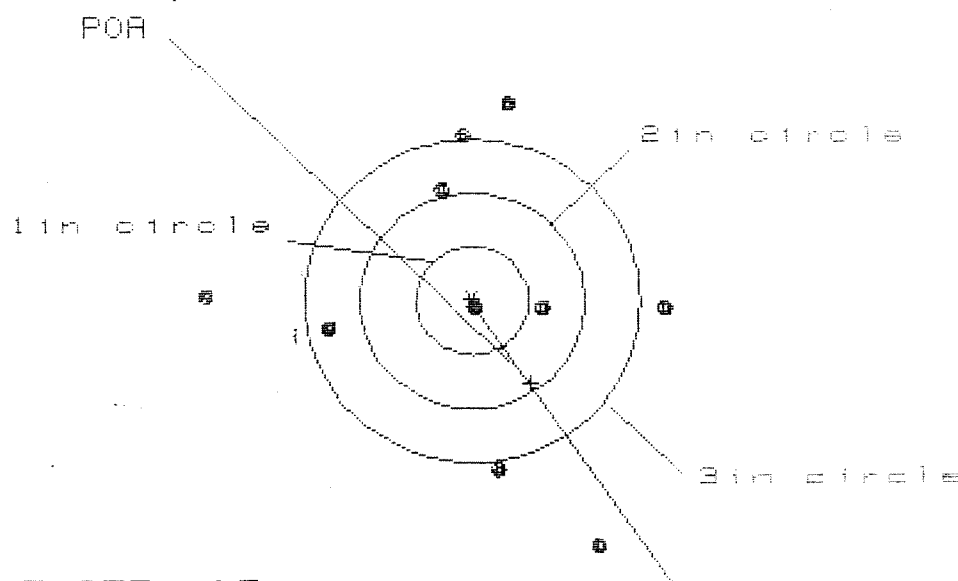
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.679	1.318	1.236
MINIMUM X	:	-1.064	-.877	-.959
MAXIMUM Y	:	1.349	1.376	.856
MINIMUM Y	:	-1.020	-.993	-.821
CENTROID X	:	-.424	-.611	-.529
CENTROID Y	:	.772	.745	.573
POA TO CENTROID in.	:	.881	.963	.780
MIN RADIUS	:	.288	.122	.171
MEAN RADIUS	:	1.012	.900	.801
MAX RADIUS	:	1.697	1.524	1.265
HORIZONTAL SPREAD	:	2.743	2.195	2.195
VERTICAL SPREAD	:	2.369	2.369	1.677
EXTREME SPREAD	:	3.022	2.451	2.451
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

11 Oct 1988

FILE:/PATTERNING/CENTERFIRE_PATT/6225379

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1in = 1

2in = 2

3in = 4

HS= 4.015

VS= 4.138

GS= 4.219

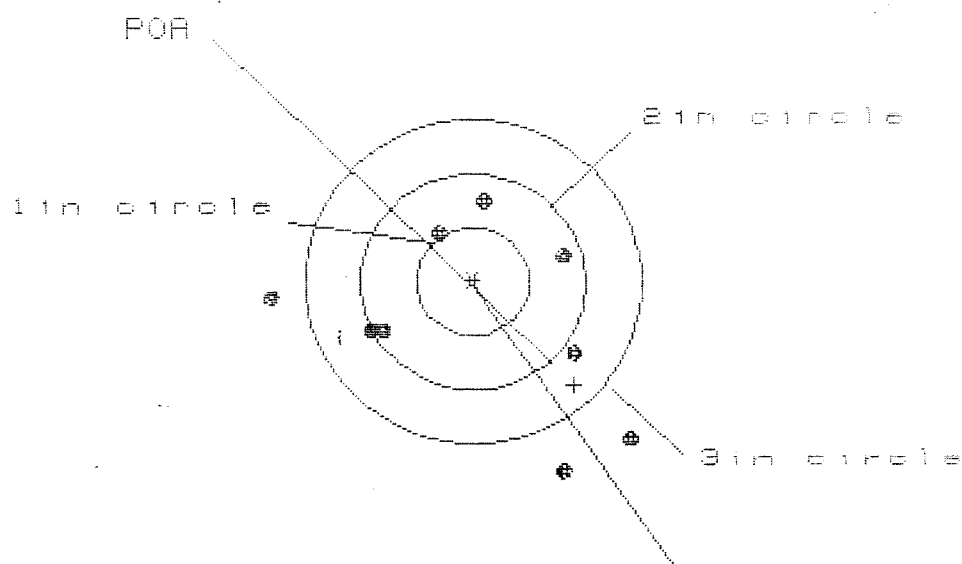
CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.678	1.804	1.528
MINIMUM X	:	-2.337	-2.211	-1.473
MAXIMUM Y	:	1.825	1.567	1.539
MINIMUM Y	:	-2.313	-1.821	-1.849
CENTROID X	:	-0.523	-0.649	-0.373
CENTROID Y	:	0.765	1.023	1.051
POA TO CENTROID in.	:	0.927	1.211	1.116
MIN RADIUS	:	0.083	0.365	0.395
MEAN RADIUS	:	1.463	1.338	1.199
MAX RADIUS	:	2.578	2.222	1.853
HORIZONTAL SPREAD	:	4.015	4.015	3.081
VERTICAL SPREAD	:	4.138	3.388	3.388
EXTREME SPREAD	:	4.219	4.017	3.388
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		2	
NUMBER IN THREE INCH CIRCLE	=		4	

11 Oct 1988

FILE:/PATTERNING/CENTERFIRE_PATT/8225378

CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1in = 0

2in = 4

3in = 6

HS= 3.135

VS= 5.010

GS= 5.080

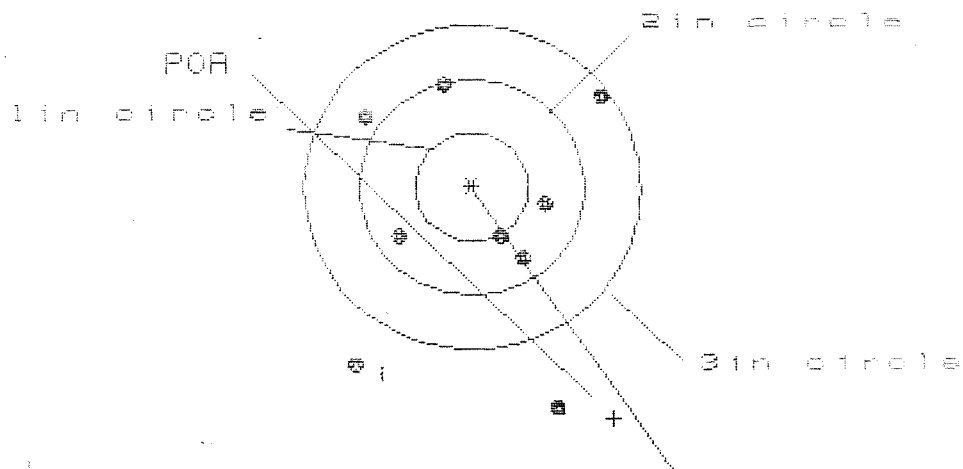
CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.376	1.370	1.022
MINIMUM X	:	-1.759	-1.765	-1.594
MAXIMUM Y	:	3.283	1.157	1.025
MINIMUM Y	:	-1.727	-1.363	-1.495
CENTROID X	:	-0.892	-0.891	-1.063
CENTROID Y	:	.951	.587	.719
POA TO CENTROID in.	:	1.308	1.067	1.283
MIN RADIUS	:	.512	.837	.661
MEAN RADIUS	:	1.411	1.198	1.095
MAX RADIUS	:	3.283	1.784	1.774
HORIZONTAL SPREAD	:	3.135	3.135	2.615
VERTICAL SPREAD	:	5.010	2.520	2.520
EXTREME SPREAD	:	5.080	3.401	3.022
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		6	

11 Oct 1988

FILE:/PATTERNING/CENTERFIRE_PATT/6225379

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 0

2in = 5

3in = 7

HS= 2.262

VS= 5.014

GS= 5.169

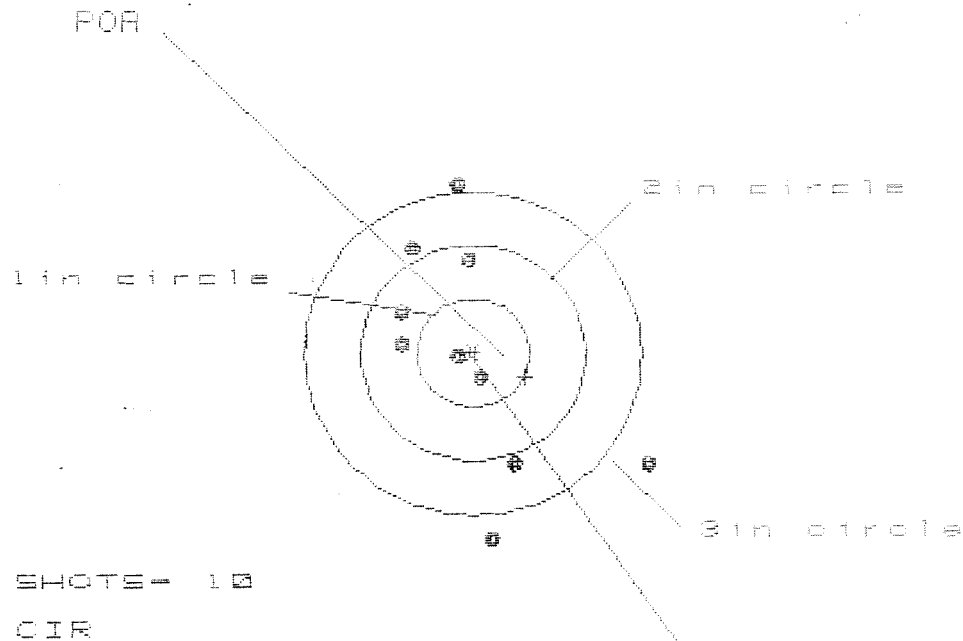
PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.201	1.150	1.243
MINIMUM X	:	-1.061	-1.112	-1.019
MAXIMUM Y	:	2.963	1.288	1.073
MINIMUM Y	:	-2.051	-1.722	-1.508
CENTROID X	:	-1.252	-1.201	-1.294
CENTROID Y	:	2.147	1.818	2.033
POA TO CENTROID in.	:	2.485	2.179	2.410
MIN RADIUS	:	.542	.259	.473
MEAN RADIUS	:	1.348	1.111	1.024
MAX RADIUS	:	2.998	1.876	1.820
HORIZONTAL SPREAD	:	2.262	2.262	2.262
VERTICAL SPREAD	:	5.014	3.010	2.581
EXTREME SPREAD	:	5.169	3.335	3.335
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		7	

Re-test

12 Oct 1988

FILE:/PATTERNING/CENTERFIRE_PATT/08225373

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 5

3 in = 7

HS= 2.270

VS= 3.307

GS= 3.320

CENTROID #

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.590	.561	.607
MINIMUM X	-.680	-.504	-.458
MAXIMUM Y	1.618	1.507	1.282
MINIMUM Y	-1.689	-1.800	-1.327
CENTROID X	-.461	-.637	-.683
CENTROID Y	.223	.334	.559
POA TO CENTROID in.	.512	.719	.882
MIN RADIUS	.152	.089	.318
MEAN RADIUS	1.003	.867	.737
MAX RADIUS	1.874	1.837	1.459
HORIZONTAL SPREAD	2.270	1.865	1.865
VERTICAL SPREAD	3.307	3.307	2.609
EXTREME SPREAD	3.320	3.320	2.655
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	7		

CONTRACT # DAAA21-87-C-0086

C 6225379

GUN SERIAL # [REDACTED]

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		7/29/91	RW
600	Proof		7/29/91	RW
607	Check Headspace		7/29/91	RW
610	Dis-assemble Gun		7/29/91	RW
612	Magnaflux Barrel Action		7/30/91	KCR
	Magnaflux Bolt		7/30/91	KCR
615	Rollmark Caliber		7/30/91	G.S.
617	Drill and Tap Sight Holes		7/30/91	FB
618	Polish Barrel		7/31/91	WB
620	Apply Coatings (Barrel Action)		8/1/91	TJA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly			
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head			
	C) Inspect Ejector Hole for Chamfer			
	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			
640	Gallery Target & Test		8-2-91	AC
	A) Time		8-2-91	AC
	B) Malfunctions		8-2-91	AC
	C) Pierced Primers		8-2-91	AC
	D) Optical Clarity of Scope		8-2-91	AC
645	Inspect for Live Ammo		8-2-91	AC
655	Final Inspection			
	A) Headspace			
	B) Trigger Pull			
	C) Function			
660	Pack			

R 93-26580

FROM:	SHIP TO:
U. S. ARMY THOMPSON, ALLAN R CO. D 2ND BN. 1ST SWTG FT BRAGG NC 28307	U. S. ARMY THOMPSON, ALLAN R CO. D 2ND BN. 1ST SWTG FT BRAGG NC 28307

CUSTOMER CONCERN	AMMO	FUNCTION	FINISH	ACCURACY	FIT	INSPECT
CYCLE	A1	B1				
TRIGGER GROUP		B2			E1	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 *Replace barrel Assy*

OFFICE COPY / / / / / RD6925 REV. 1/92

CONTRACT # DAAA21-87-C-0086

New Barrel

GUN SERIAL # C6225379

OP. #	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and Stock		12/16/93	RW
600	Proof		12/16/93	RW
607	Check Headspace		12/16/93	RW
610	Dis-assemble Gun		12/16/93	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		12/28/93	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		12/28/93	RW
	C) Inspect Ejector Hole for Chamfer		12/28/93	RW
	D) Oil Firing Pin Ass'y		12/28/93	RW
	E) Adjust Trigger Pull to Min Setting and Stake			

op. #	OP. NAME	READINGS					DATE	INIT
65 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						12/29/93	RW
	A) Time							
	B) Malfunctions							
	C) Pierced Primers							
	D) Optical Clarity of Scope							
645	Inspect for Live Ammo						12/29/93	RW
655	Final Inspection						1/3/94	RW
	A) Headspace						1/3/94	RW
	B) Trigger Pull	2.82	2.56	2.77	2.75	2.79	1/3/94	RW
	C) Function						1/3/94	RW
660	Pack							

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6225379
11 Jan 1994

CENTROIDAL DISTANCES

0 TO	1	.163783
1 TO	2	.573697
1 TO	3	.461767
1 TO	4	.520332
1 TO	5	.406989

$\frac{1}{n} \sum_{i=1}^n x_i$

----FOR

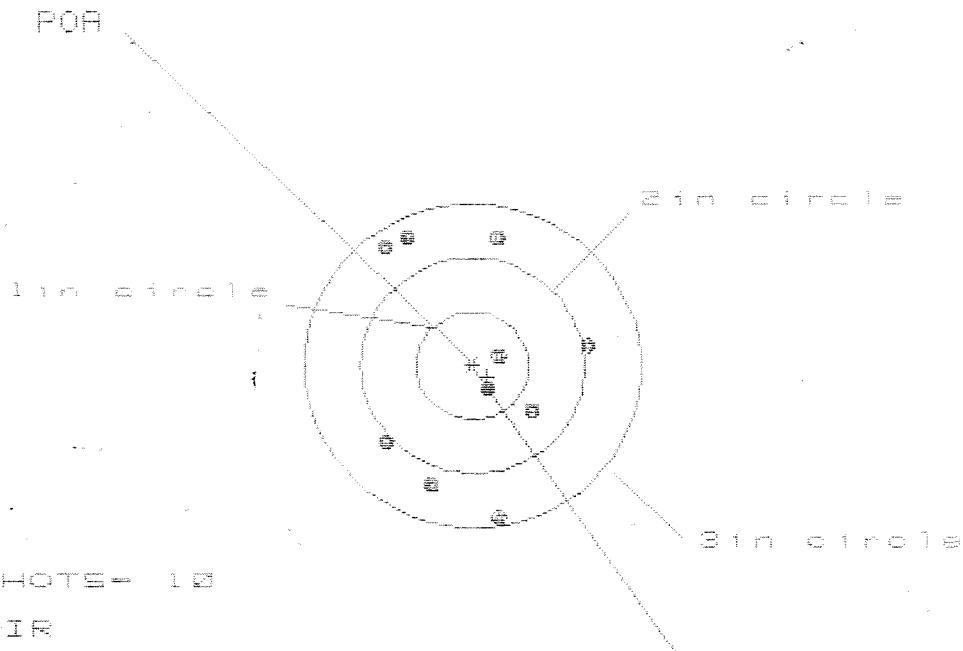
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .159
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0312
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .162032
THE AMR FOR THIS RIFLE IS: .877

11 Jan 1994

FILE:/PATTERNING/CENTERFIRE_PATT/08225379

CENTERFIRE PATTERNS

1



OF SHOTS= 10

IN CIR

1in = 2

2in = 4

3in = 10

HS= 1.810

VS= 2.641

GS= 2.753

CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.822	1.848	.952
MINIMUM X	-.788	-.762	-.807
MAXIMUM Y	1.224	1.067	1.183
MINIMUM Y	-1.417	-1.226	-1.109
CENTROID X	-.124	-.150	-.054
CENTROID Y	.107	.264	.148
POA TO CENTROID in.	.164	.304	.157
MIN RADIUS	.240	.289	.183
MEAN RADIUS	.969	.929	.852
MAX RADIUS	1.435	1.265	1.335
HORIZONTAL SPREAD	1.810	1.810	1.759
VERTICAL SPREAD	2.641	2.293	2.293
EXTREME SPREAD	2.753	2.337	2.337
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		4	
NUMBER IN THREE INCH CIRCLE =		10	

11 Jan 1994

FILE:/PATTERNING/CENTERFIRE_PATT/08225379

CENTERFIRE PATTERNS # 2

POR

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in - 1

2 in - 5

3 in - 10

HS= 2.223

VS= 2.444

GS= 2.666

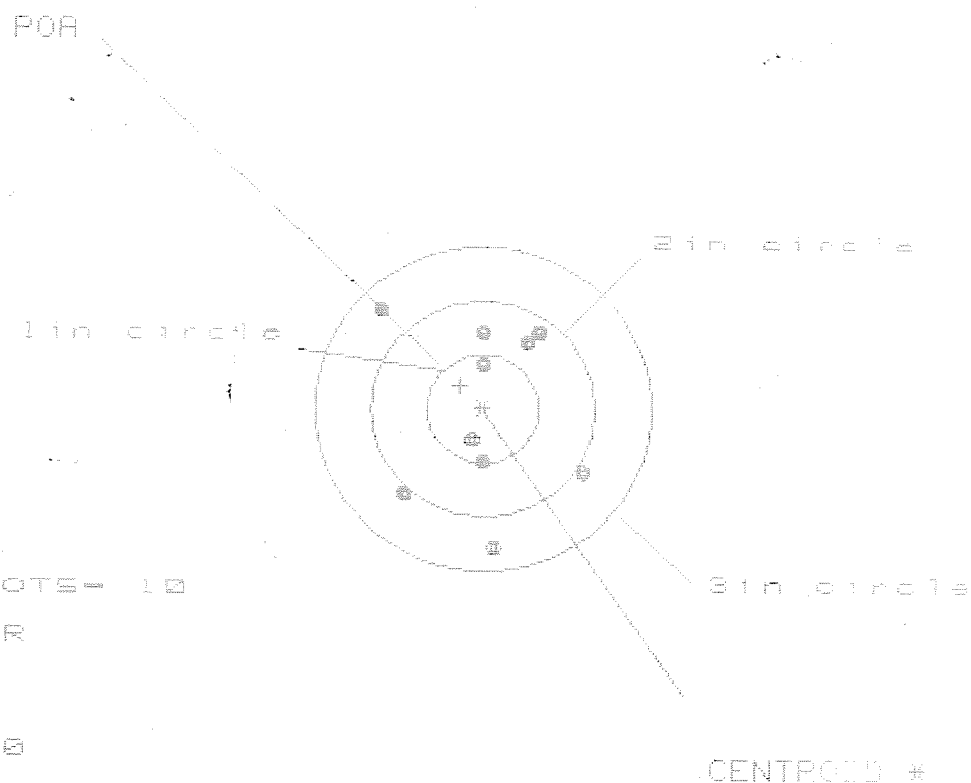
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.995	1.078	1.048
MINIMUM X	:	-1.228	-1.145	-1.175
MAXIMUM Y	:	1.171	1.221	1.078
MINIMUM Y	:	-1.273	-1.143	-1.414
CENTROID X	:	.114	.031	.061
CENTROID Y	:	-.415	-.545	-.402
POR TO CENTROID in.	:	.430	.546	.407
MIN RADIUS	:	.337	.440	.390
MEAN RADIUS	:	.976	.930	.888
MAX RADIUS	:	1.388	1.243	1.246
HORIZONTAL SPREAD	:	2.223	2.223	2.223
VERTICAL SPREAD	:	2.444	2.364	1.492
EXTREME SPREAD	:	2.666	2.364	2.240
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		10	

11 Jan 1994

FILE:/PATTERNING/CENTERFIRE_PATT/CB225379

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 2

2in = 6

3in = 10

HS= 1.810

VS= 2.152

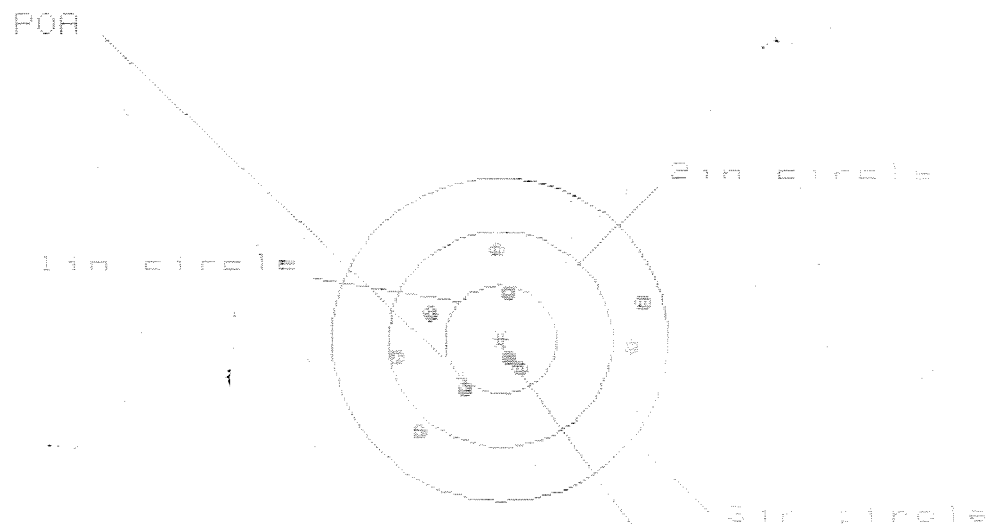
GS= 2.410

PATTERN #	3	3	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.859	.754	.757
MINIMUM X	-.951	-.788	-.784
MAXIMUM Y	.908	.854	.712
MINIMUM Y	-1.244	-1.143	-.815
CENTROID X	.206	.311	.307
CENTROID Y	-.216	-.316	-.174
POA TO CENTROID in.	.298	.444	.358
MIN RADIUS	.274	.246	.354
MEAN RADIUS	.817	.758	.696
MAX RADIUS	1.315	1.143	1.131
HORIZONTAL SPREAD	1.810	1.542	1.542
VERTICAL SPREAD	2.152	1.997	1.527
EXTREME SPREAD	2.410	2.004	1.886
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		10	

11 Jan 1994

FILE:/PATTERNING/CENTERFIRE_PATT/06225373

CENTERFIRE PATTERNS # 4



OF SHOTS = 10

IN CIR

1in = 3

2in = 7

3in = 10

HS = 2.217

VS = 1.745

GS = 2.356

PATTERN #	4		
SHOTS (BEST OF)	10	5	5
MAXIMUM X	1.260	1.342	.435
MINIMUM X	-.957	-.817	-.649
MAXIMUM Y	.876	.918	.913
MINIMUM Y	-.869	-.827	-.832
CENTROID X	.329	.189	.021
CENTROID Y	.363	.321	.326
POA TO CENTROID in.	.490	.373	.327
MIN RADIUS	.127	.181	.341
MEAN RADIUS	.756	.683	.600
MAX RADIUS	1.315	1.343	.958
HORIZONTAL SPREAD	2.217	2.159	1.084
VERTICAL SPREAD	1.745	1.745	1.745
EXTREME SPREAD	2.356	2.161	1.885
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		10	

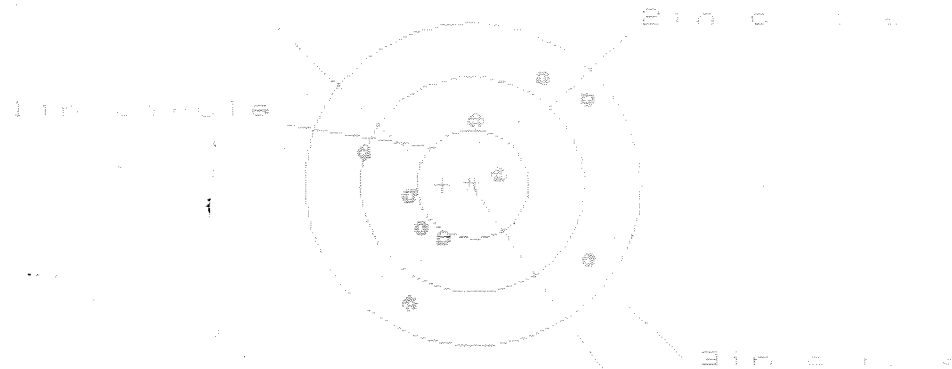
11 Jan 1994

FILE:/PATTERNING/CENTERFIRE_PATT/06225379

CENTERFIRE PATTERN # 5

5

POA



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 5

3 in = 10

HS= 2.075

VS= 2.108

GS= 2.503

PATTERN #

5

SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.961	1.159	1.662
MINIMUM X	:	-1.014	-0.896	-0.751
MAXIMUM Y	:	.981	1.067	.933
MINIMUM Y	:	-1.127	-1.041	-1.120
CENTROID X	:	.270	.152	.007
CENTROID Y	:	.005	-.081	-.002
POA TO CENTROID in.	:	.270	.172	.007
MIN RADIUS	:	.250	.395	.336
MEAN RADIUS	:	.870	.800	.710
MAX RADIUS	:	1.316	1.320	1.111
HORIZONTAL SPREAD	:	2.075	2.055	1.613
VERTICAL SPREAD	:	2.108	2.108	2.108
EXTREME SPREAD	:	2.503	2.407	2.407
NUMBER IN ONE INCH CIRCLE	=	1	1	1
NUMBER IN TWO INCH CIRCLE	=	5	5	5
NUMBER IN THREE INCH CIRCLE	=	10	10	10