

G 641 4431

Refused

C. 622 5246

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6414431.___0

FILE DATE AND TIME: 11/10/2004 08:52

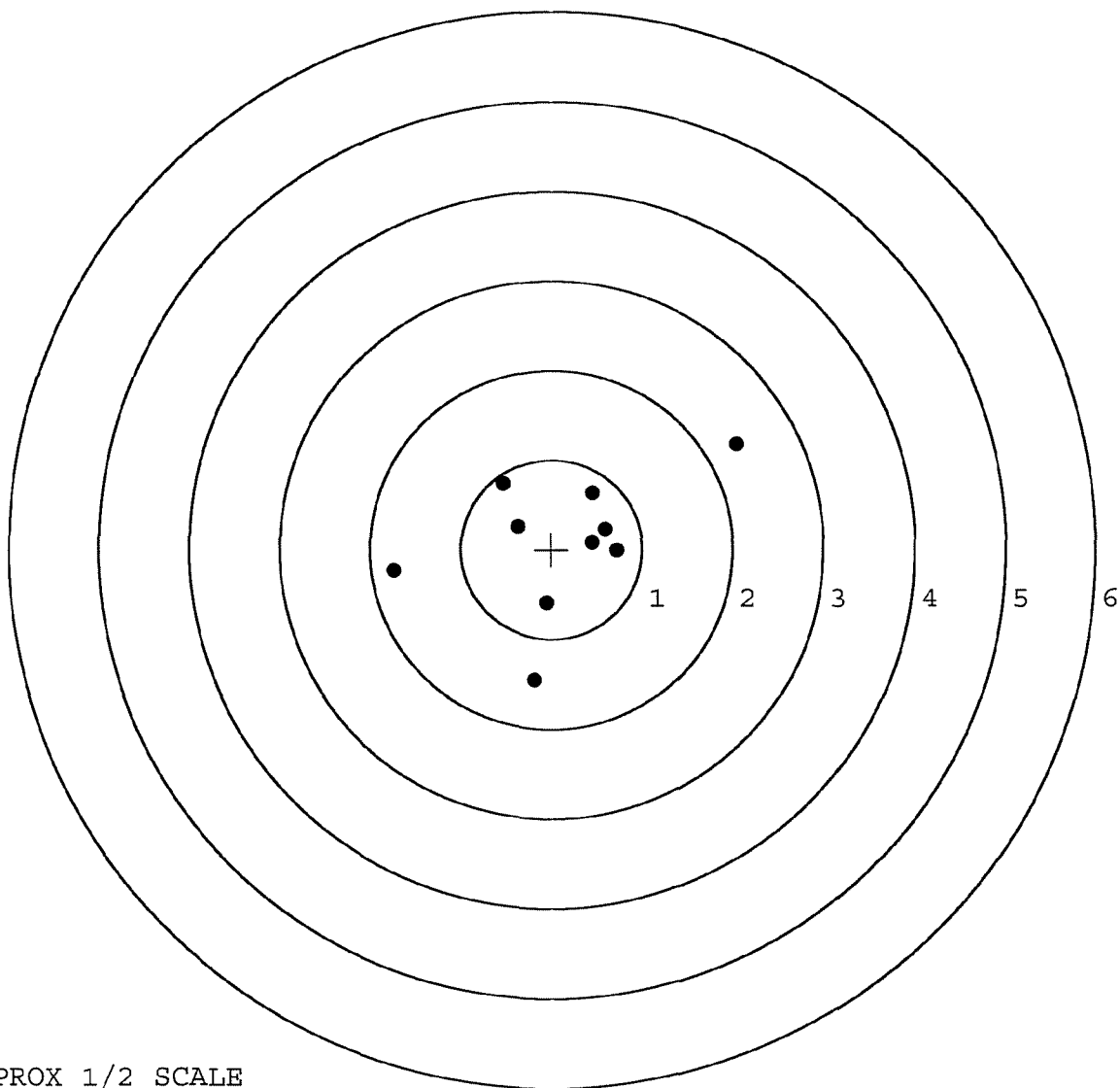
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.163
The Average Y Centroid of the Five Target Set:	0.129
The Average Point of Impact of the Five Target Set:	0.208
The Average Mean Radius of the Five Target Set:	0.682
The Distance from POA to Centroid Target #1:	0.155
The Distance from Centroid Target #2 to Centroid Target #1:	0.186
The Distance from Centroid Target #3 to Centroid Target #1:	0.240
The Distance from Centroid Target #4 to Centroid Target #1:	0.173
The Distance from Centroid Target #5 to Centroid Target #1:	0.118

SERIAL NUMBER: G6414431.____0
TARGET NUMBER: 1
FILE DATE: 11/10/2004
FILE TIME: 08:52

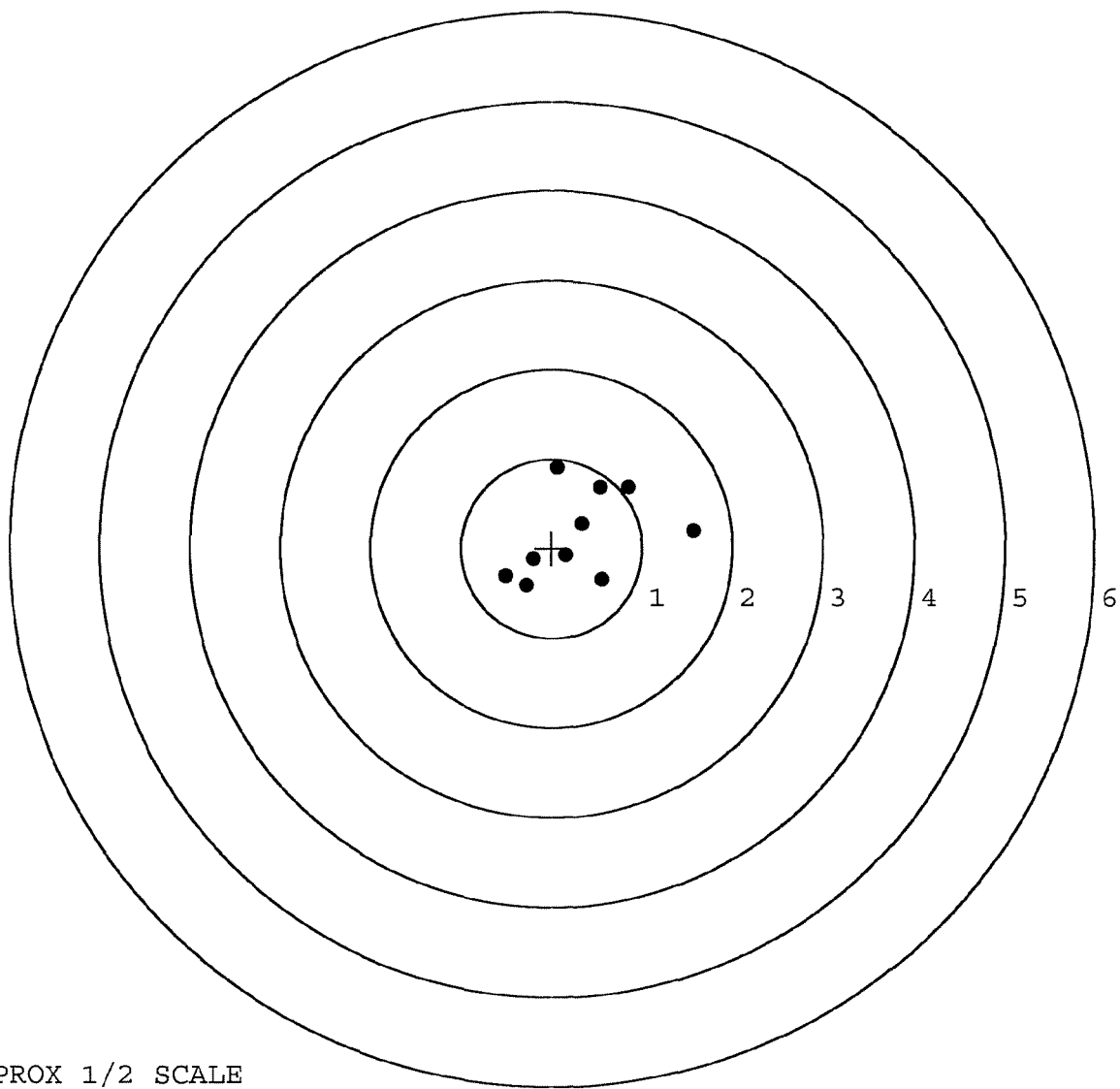
POINT#	X	Y
1:	2.045	1.168
2:	0.451	0.628
3:	0.587	0.223
4:	0.449	0.075
5:	0.722	-0.015
6:	-0.194	-1.463
7:	-0.058	-0.606
8:	-0.377	0.250
9:	-0.534	0.730
10:	-1.737	-0.243

X CENTROID: 0.135
Y CENTROID: 0.075
POA TO CENTROID: 0.155
HORZ SPREAD: 3.782
VERT SPREAD: 2.631
GROUP SPREAD: 4.037
MIN RADIUS: 0.314
MAX RADIUS: 2.200
MEAN RADIUS: 0.988
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 7



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6414431.____0	POINT#	X	Y
TARGET NUMBER: 2	1:	0.065	0.904
FILE DATE: 11/10/2004	2:	0.540	0.685
FILE TIME: 08:52	3:	0.851	0.685
	4:	1.561	0.194
X CENTROID: 0.307	5:	0.557	-0.351
Y CENTROID: 0.146	6:	0.330	0.276
POA TO CENTROID: 0.340	7:	0.158	-0.086
HORZ SPREAD: 2.070	8:	-0.202	-0.122
VERT SPREAD: 1.322	9:	-0.509	-0.309
GROUP SPREAD: 2.130	10:	-0.280	-0.418
MIN RADIUS: 0.132			
MAX RADIUS: 1.255			
MEAN RADIUS: 0.669			
# IN 1 IN DIAMETER: 2			
# IN 2 IN DIAMETER: 9			
# in 3 IN DIAMETER: 10			



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6414431. __0

TARGET NUMBER: 3

FILE DATE: 11/10/2004

FILE TIME: 08:52

POINT#	X	Y
1:	1.782	0.856
2:	0.025	1.362
3:	-0.261	0.502
4:	-1.434	0.312
5:	0.349	0.051
6:	0.199	0.360
7:	-0.154	-0.385
8:	0.024	-0.122
9:	-0.045	0.070
10:	-0.120	-0.072

X CENTROID: 0.037

Y CENTROID: 0.293

POA TO CENTROID: 0.296

HORZ SPREAD: 3.216

VERT SPREAD: 1.747

GROUP SPREAD: 3.262

MIN RADIUS: 0.176

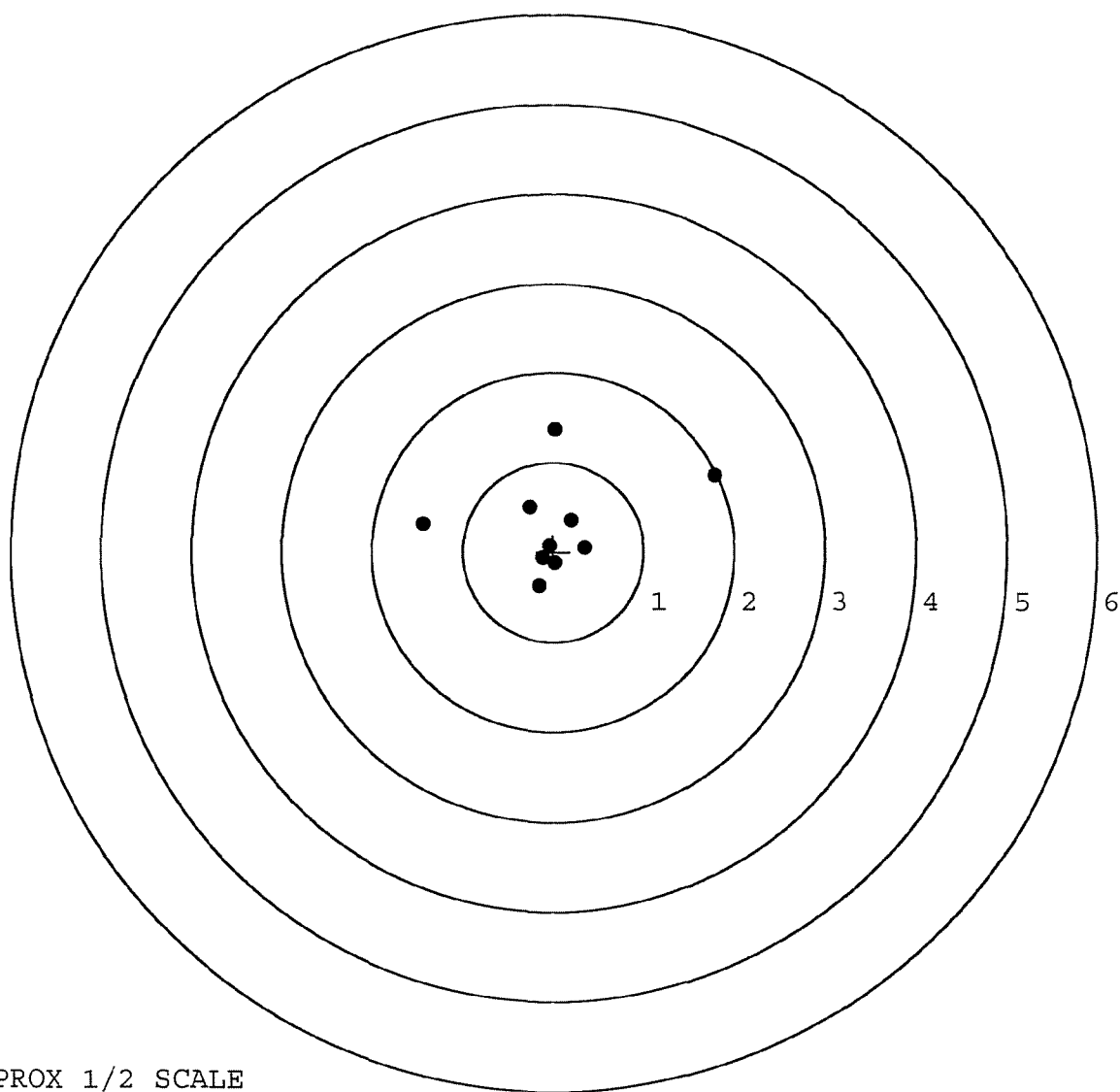
MAX RADIUS: 1.834

MEAN RADIUS: 0.706

IN 1 IN DIAMETER: 6

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6414431. __0

TARGET NUMBER: 4

FILE DATE: 11/10/2004

FILE TIME: 08:52

POINT#	X	Y
1:	1.191	0.126
2:	0.686	0.061
3:	0.625	0.325
4:	0.547	0.635
5:	0.070	1.273
6:	0.136	-0.879
7:	-0.197	-0.521
8:	-0.174	-0.191
9:	0.120	0.290
10:	0.037	-0.009

X CENTROID: 0.304

Y CENTROID: 0.111

POA TO CENTROID: 0.324

HORZ SPREAD: 1.388

VERT SPREAD: 2.152

GROUP SPREAD: 2.153

MIN RADIUS: 0.257

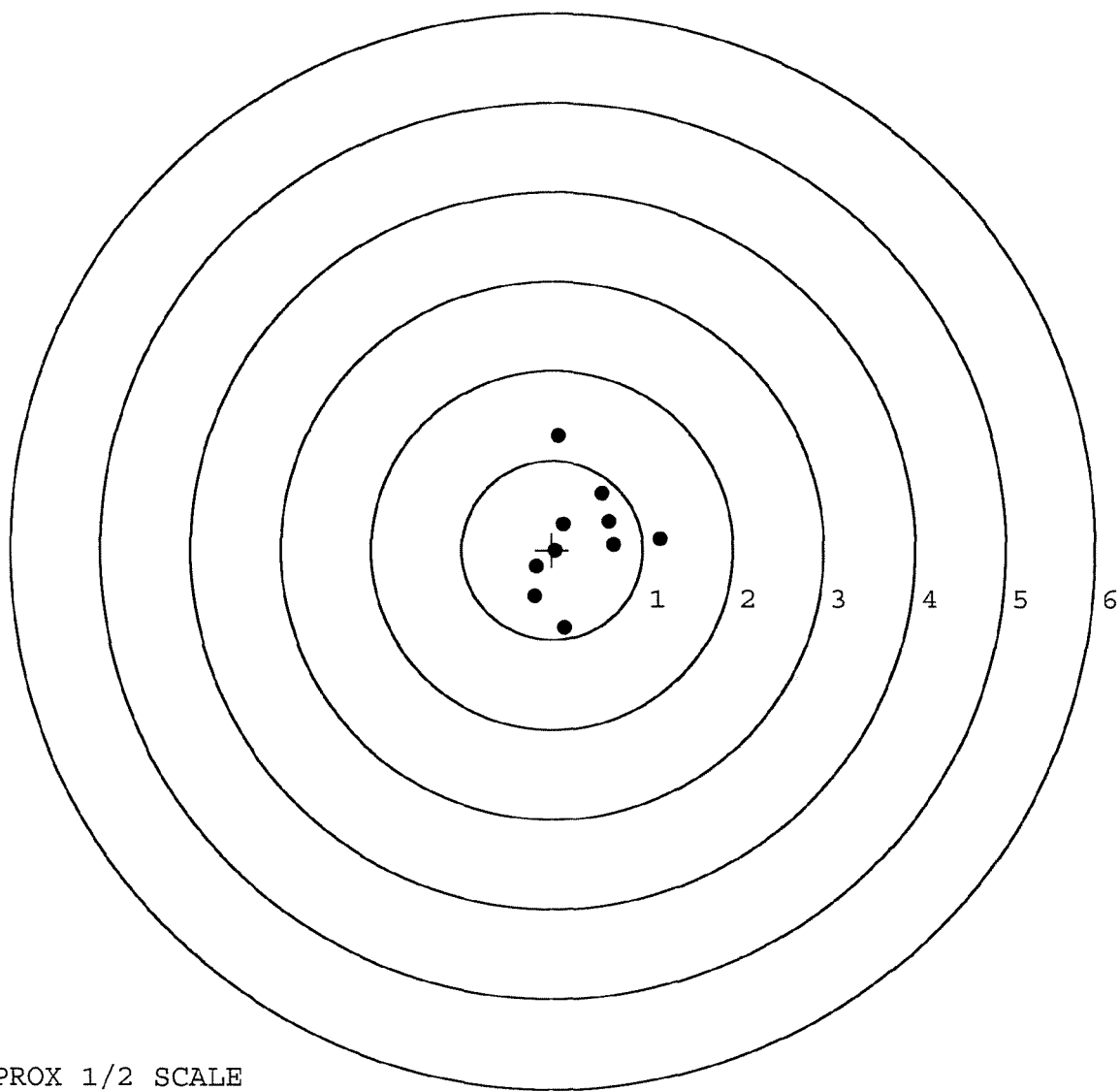
MAX RADIUS: 1.185

MEAN RADIUS: 0.635

IN 1 IN DIAMETER: 4

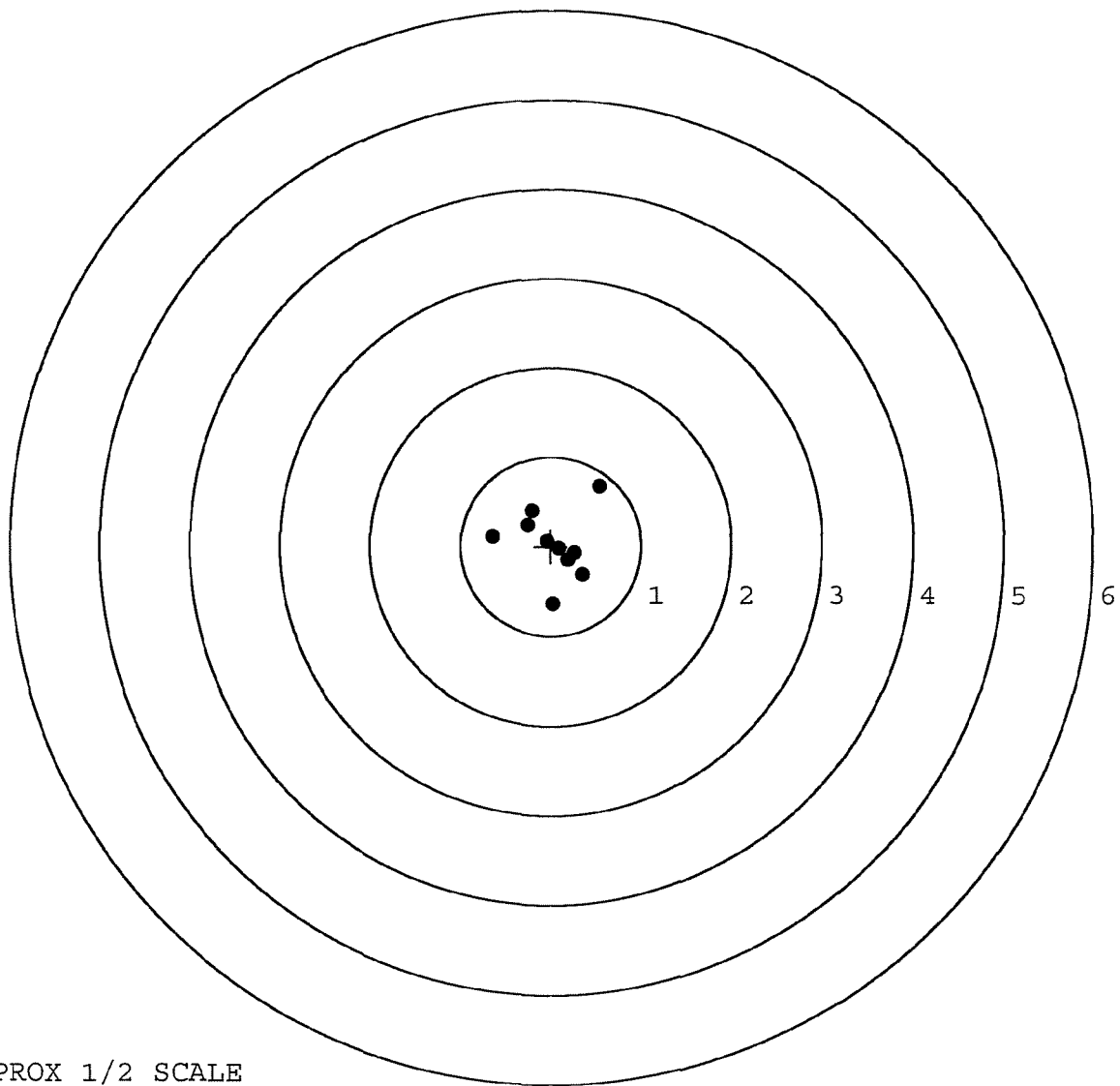
IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6414431.____0	POINT#	X	Y
TARGET NUMBER: 5	1:	-0.214	0.394
FILE DATE: 11/10/2004	2:	-0.642	0.100
FILE TIME: 08:52	3:	0.539	0.673
	4:	0.353	-0.324
X CENTROID: 0.030	5:	0.263	-0.076
Y CENTROID: 0.022	6:	0.025	-0.651
POA TO CENTROID: 0.037	7:	-0.044	0.059
HORZ SPREAD: 1.181	8:	0.092	-0.033
VERT SPREAD: 1.324	9:	-0.266	0.235
GROUP SPREAD: 1.420	10:	0.191	-0.159
MIN RADIUS: 0.083			
MAX RADIUS: 0.827			
MEAN RADIUS: 0.412			
# IN 1 IN DIAMETER: 7			
# IN 2 IN DIAMETER: 10			
# in 3 IN DIAMETER: 10			



TARGET APPROX 1/2 SCALE

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

SERIAL # G6411443

INSPECTED BY: RTZ

DATE REC'D: 10-4-04

DATE RET'D: 11-10-04

ITEM

BARREL ASSEMBLY

☒ BARREL
☒ RECEIVER
☒ FRONT SIGHT BASE
☒ REAR SIGHT BASE
☒ SCREWS
☒ FINISH

SCOPE ASSEMBLY

☒ SCOPE
☒ SCOPE RINGS
☒ MOUNTING SCREWS
☒ MOUNTING BASE
☒ SCREWS
☒ FINISH
☒ CLARITY

ITEM

STOCK ASSEMBLY

☒ STOCK
☒ SLING AWIVEL STUDS
☒ ADJUSTABLE
☒ BUTT PLATE
☒ LOCK NUTS
☒ BARREL CLEARANCE
☒ COLOR / FINISH

SYSTEMS CASE

☒ SCOPE CASE
☒ IRON SIGHTS
☒ DEPLOYMENT KIT

TRIGGER ASSEMBLY

☒ SAFETY OPERATION
☒ RE-SET TO FACTORY SPECS

COMMENTS:

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

R & E NUMBER	85920		
SERIAL NUMBER	66414431 C6225246 C6360985 (New)		
LOG-IN DATE	10-4-04		
INSPECT AND VERIFY:			
OPERATION #	OPERATION NAME	DATE	INITIAL
550	DIS-ASSEMBLE GUN	10-13-04	RTL
560 A	RE-BARREL	10-14-04	
B	DRILL AND TAP	10-19-04	TRW
575	ASSEMBLE	10-15-04	RTL
600	PROOF	10-18-04	RTL
605	CHECK HEADSPACE	10-18-04	RTL
610	DIS-ASSEMBLE GUN	10-19-04	RTL
612	MAGNAFLUX		
615	ROLLMARK CALIBER	10/20/04	LB
618	ROTO-BLAST	10-22-04	LB
620	APPLY COATINGS	10/24/04	HP
625 A	FINAL ASSEMBLY	11-1-04	RTL
B	TRIGGER PULL TEST		
C	SAFETY "ON" FORCE		
D	SAFETY "OFF" FORCE		
E	FIRING PIN INDENT		
640	TARGET	11-10-04	AC
655	FINAL INSPECT	11-10-04	
660	PACK	11-11-04	RA
		SHIP DATE	
		QAR INSPECTION DATE	

SCOPE #
(277)

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6225246

OP. #	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and stock	8	9/88	FB
600	Proof	9	7/88	RW
607	Check Headspace	9	7/88	RW
610	Dis-assemble gun	8	7/88	RW
612	Magnaflux Barrel Action		9-14-88	pfe.
	Magnaflux Bolt		9-14-88	pfe
615	Rollmark Caliber			
617	Drill & Tap Sight Holes			
618	Polish Barrel			
620	Apply Coatings (Barrel Action)		10-31-88	TJA
	Apply Coatings (Bolt)		10-31-88	TJA
625	Final Assembly A) Clean inside of Bolt Assembly		11/2/88	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		11/2/88	RW
	C) Inspect Ejector Hole for Chamfer		11/2/88	RW

OVER

OP.#		READINGS	DATE	INITIAL
625	D) Oil Firing Pin Ass'y		11/2/88	RW
cont.	E) Adjust Trigger Pull to Min. Setting and Stake		2 NOV 88	JS
	F) Safety on Force	5 5 5	2 NOV 88	JS
	G) Safety off Force	3 3 3	2 NOV 88	JS
	H) Trigger Pull Test & Retainability		2 NOV 88	JS
	I) Firing Pin Indent	.020 .020 .0205	2 NOV 88	JS
	J) Assemble Stock		11/9/88	RW
	K) Attach Front & Rear Sight Assemblies		11/9/88	RW
	L) Iron Sight Alignment		11/9/88	RW
	M) Detach Front & Rear Sights & place in numbered container		11/9/88	RW
	N) Attach Scope to Rifle		11/9/88	JS
	O) Detach & Attach Scope 20 times			
640	Gallery Target & Test	68R 82L	11/14/88	DH
	A) Optical Clarity of Scope		11/14/88	DH
645	Inspect for Live Ammo		11/14/88	DH
655	Final Inspection			
	A) Headspace		30 NOV 88	JS
	B) Trigger Pull	2.74 2.77 2.77	2.80 2.78	JS
	C) Function		30 NOV 88	JS
	D) Assemble Swivel Studs		30 NOV 88	JS
660	Pack		14 DEC 88	JS

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6225246

DATE 31 Oct 88

TESTER J. G. + M. S.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.39	2.44	2.57	2.74	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.53	2.44	2.58	2.77	
PULL #3	2.43	2.42	2.55	2.77	
PULL #4	2.54	2.44	2.55	2.80	
PULL #5	2.43	2.45	2.55	2.78	
TOTAL	12.32	12.19	12.80	13.86	
AVG.	2.464	2.438	2.56	2.772	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.07	2.90		
PULL #2	2.98	2.88		
PULL #3	3.00	2.97		
PULL #4	2.99	2.94		
PULL #5	2.99	2.99		
TOTAL	15.03	14.68		
AVG.	3.006	2.936		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.19	4.12		4.25
PULL #2	4.20	4.19		4.23
PULL #3	4.25	4.21		4.27
PULL #4	4.26	4.25		4.26
PULL #5	4.30	4.23		4.25
TOTAL	21.20	21.00		21.26
AVG.	4.24	4.20		4.252

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6225246

CENTROIDAL DISTANCES

0 TO	1	.506004
1 TO	2	.785576
1 TO	3	.6404
1 TO	4	.205779
1 TO	5	.372828

$\frac{1}{5}$
 $\frac{1}{5}$
 $\frac{1}{5}$
 $\frac{1}{5}$
 $\frac{1}{5}$

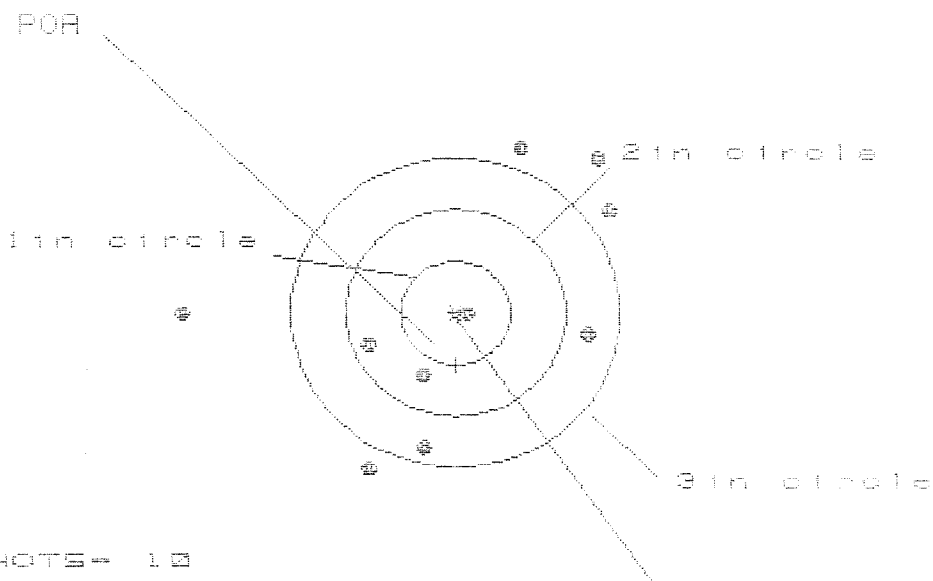
<----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1008
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .124
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .159802
THE AMR FOR THIS RIFLE IS: 1.171

14 Nov 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C6225246

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 3

3 in = 5

HS = 3.893

VS = 3.094

GS = 4.100

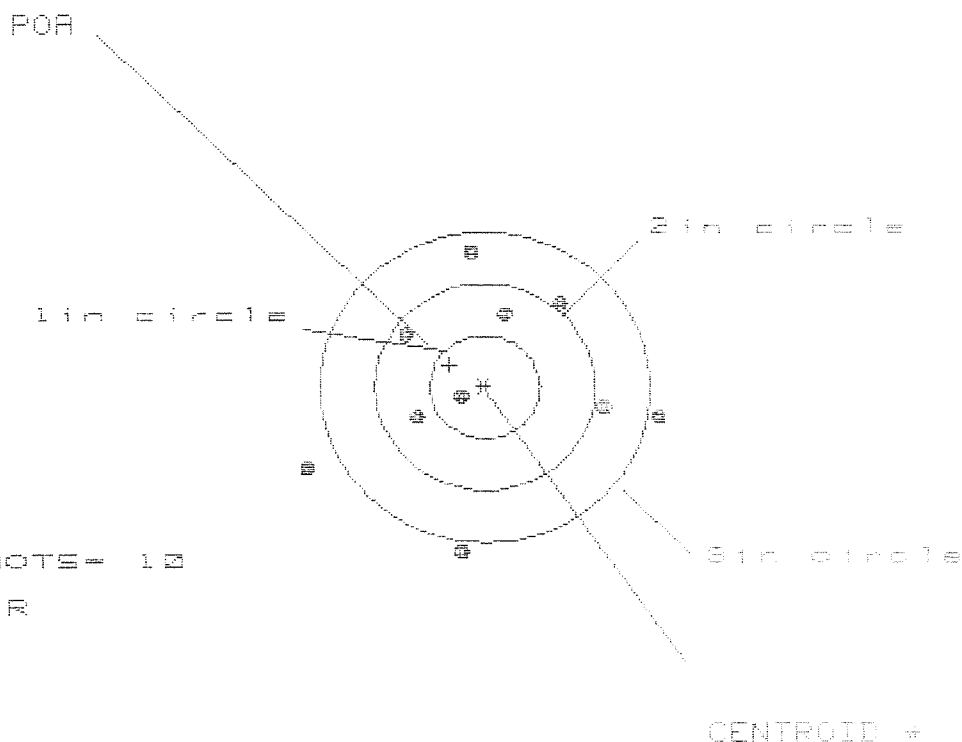
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.489	1.133	1.266
MINIMUM X	-2.484	-1.093	-0.960
MAXIMUM Y	1.618	1.613	1.794
MINIMUM Y	-1.476	-1.481	-1.300
CENTROID X	-0.002	.274	.141
CENTROID Y	.506	.511	.330
POB TO CENTROID in.	.506	.580	.358
MIN RADIUS	.159	.140	.122
MEAN RADIUS	1.385	1.251	1.143
MAX RADIUS	2.485	1.841	1.860
HORIZONTAL SPREAD	3.893	2.226	2.226
VERTICAL SPREAD	3.094	3.094	3.094
EXTREME SPREAD	4.100	3.640	3.417
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	3		
NUMBER IN THREE INCH CIRCLE =	5		

14 Nov 1988

FILE:/PATTERNING/CENTERFIRE_PATT/08225245

CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 4

3 in = 7

HS = 3.277

VS = 2.963

GS = 3.318

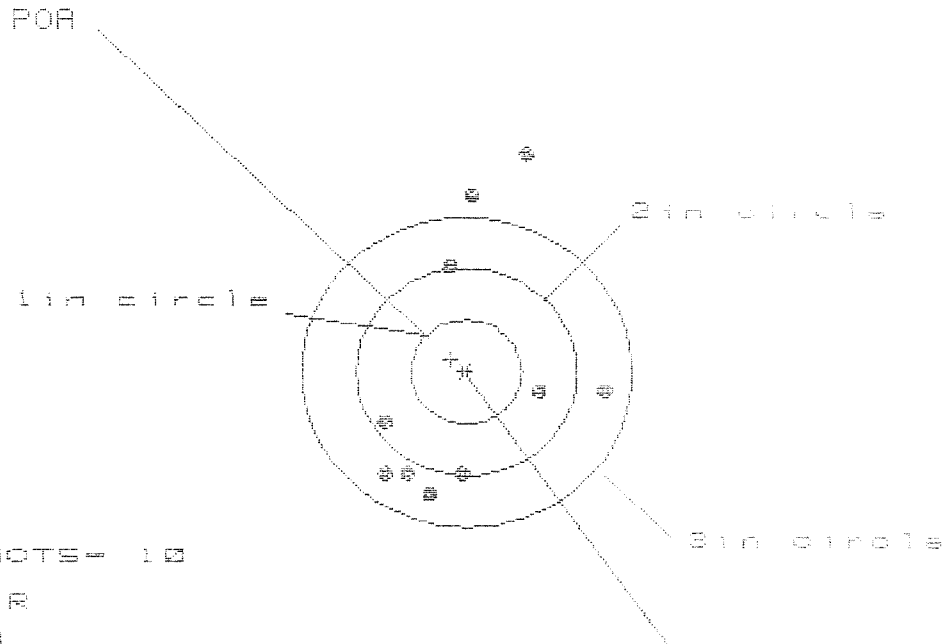
CENTROID +

PATTERN #	2		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.626	1.443	1.040
MINIMUM X	-1.651	-.937	-.757
MAXIMUM Y	1.333	1.242	1.193
MINIMUM Y	-1.630	-1.721	-1.770
CENTROID X	.319	.502	.322
CENTROID Y	-.211	-.120	-.071
POA TO CENTROID in.	.383	.517	.330
MIN RADIUS	.265	.469	.360
MEAN RADIUS	1.115	1.030	.942
MAX RADIUS	1.844	1.757	1.778
HORIZONTAL SPREAD	3.277	2.380	1.797
VERTICAL SPREAD	2.963	2.963	2.963
EXTREME SPREAD	3.318	2.963	2.963
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		4	
NUMBER IN THREE INCH CIRCLE =		7	

14 Nov 1988

FILE:/PATTERNING/CENTERFIRE_PATT/08225246

CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1 in = 0

2 in = 2

3 in = 8

HS = 2.048

VS = 3.313

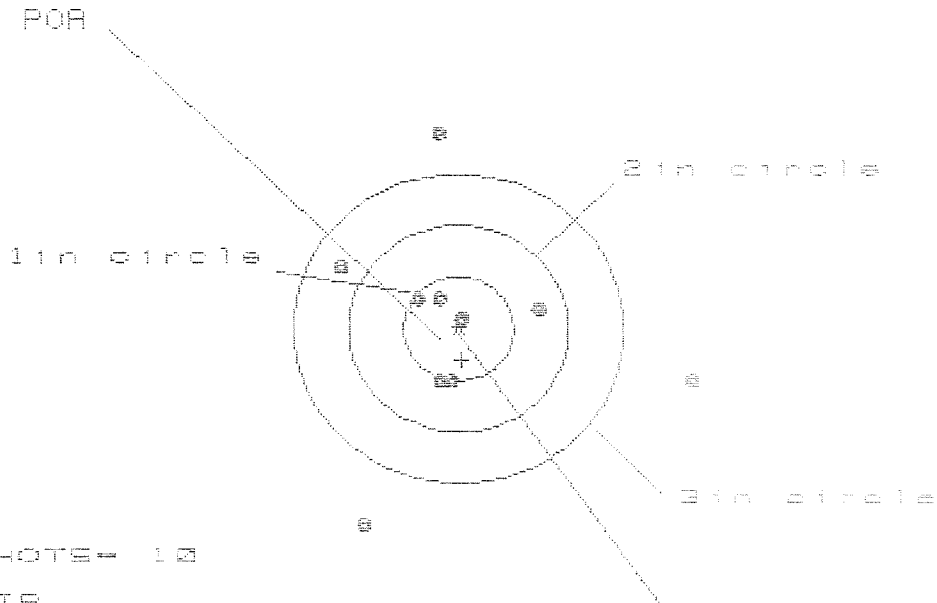
GS = 3.434

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.291	1.354	1.371
MINIMUM X	-1.757	-1.694	-1.677
MAXIMUM Y	2.163	1.978	1.517
MINIMUM Y	-1.150	-1.909	-1.662
CENTROID X	.142	.079	.862
CENTROID Y	-1.118	-1.359	-1.606
POA TO CENTROID in.	.185	.367	.609
MIN RADIUS	.646	.685	.520
MEAN RADIUS	1.240	1.069	.887
MAX RADIUS	2.238	1.982	1.519
HORIZONTAL SPREAD	2.048	2.048	2.048
VERTICAL SPREAD	3.313	2.887	2.174
EXTREME SPREAD	3.434	2.914	2.201
NUMBER IN ONE INCH CIRCLE	=	0	
NUMBER IN TWO INCH CIRCLE	=	2	
NUMBER IN THREE INCH CIRCLE	=	8	

14 NOV 1988

FILE:/PATTERNING/CENTERFIRE_PATT/08225248

CENTERFIRE PATTERNS # 4



OF SHOTS = 10

IN CIR

1 in = 3

2 in = 6

3 in = 7

HS = 3.106

VS = 3.847

CS = 3.911

CENTROID *

PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	2.084	1.884	1.428
MINIMUM X	-1.022	-0.790	-0.874
MAXIMUM Y	1.922	1.863	1.615
MINIMUM Y	-1.925	-1.984	-0.805
CENTROID X	-0.029	-0.261	-0.177
CENTROID Y	0.302	0.361	0.609
POA TO CENTROID in.	0.304	0.445	0.634
MIN RADIUS	0.107	0.236	0.035
MEAN RADIUS	1.011	0.871	0.693
MAX RADIUS	2.149	2.094	1.616
HORIZONTAL SPREAD	3.106	1.794	1.794
VERTICAL SPREAD	3.847	3.847	2.426
EXTREME SPREAD	3.911	3.911	2.422
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	7		

14 Nov 1988

FILE:/PATTERNING/CENTERFIRE_PATT/08225246

CENTERFIRE PATTERNS

5

POA

1 in circle

2 in circle

3 in circle

OF SHOTS - 10

IN CIR

1 in = 2

2 in = 5

3 in = 7

HS = 2.458

VS = 1.747

GS = 3.473

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.619	1.414	1.524
MINIMUM X	:	-1.839	-1.586	-1.829
MAXIMUM Y	:	1.062	1.021	.930
MINIMUM Y	:	-.685	-.726	-.687
CENTROID X	:	.074	.279	.102
CENTROID Y	:	.141	.182	.273
POA TO CENTROID in.	:	.160	.333	.291
MIN RADIUS	:	.360	.555	.395
MEAN RADIUS	:	1.106	1.025	.923
MAX RADIUS	:	1.875	1.596	1.672
HORIZONTAL SPREAD	:	3.458	2.920	2.853
VERTICAL SPREAD	:	1.747	1.747	1.617
EXTREME SPREAD	:	3.473	3.087	2.983
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		7	

RECEIVING AND ESTIMATING REPORT

COMMENTS

ORDER
R 94-22611

INITIAL FPS	CUSTOMER ORDER NO.		M-24 ATTN: FRED MARTIN PAINTED OUTSIDE SHOP			
DATE RECEIVED 08/01/94	DATE OPENED 08/02/94	DATE CODE DI 7-88	SERIAL NUMBER C6225246	NEW SERIAL NUMBER	MODEL AND GRADE 700 7.32	NATO
ACCESSORIES W/STUDS		SCOPE MNTS		SCOPE BASE		

FROM:

SHIP TO:

DEPT OF THE ARMY
B CO ARMS
2/75 RANGER BATTALION
FT LEWIS

WA 98433

DEPT OF THE ARMY
B CO ARMS
2/75 RANGER BATTALION
FT LEWIS

WA

98433

CUST NO: 062072 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			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

New Barrel

PARTS	COMMENTS					
Barrel - 96003	Repowder Coat Trigger Guard Assy, Front & Rear Sight Bases ReZinc Scope Base, Rings & Swivel Studs					
W52 H09 422 / #227	REPAIRMAN RW	PROOF ✓	CLEAN ✓	TEST ✓	TARGET ✓	PATTERN
	GALLERY TESTER RW	DATE 8/13/94	DATE 8/13/94	DATE 8/15/94	DATE 8/15/94	DATE

OFFICE COPY

RD6925 REV. 1/94

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

M2400152425

PACKING LIST		PACKED BY <i>Mr. Ray Fuller</i> WG-10 Bn. Armorer	1. NO. BOXES /	2a. REQUISITION NO. 92067	
3. END ITEM 7.62mm M24 Sniper Weapons System (SW5)		4. DATE 26 July 1994		2b. ORDER NO.	
				5. PAGE 1 OF 1 PAGES	
BOX NO.	CONTENTS - STOCK NUMBER AND NOMENCLATURE	UNIT OF ISSUE	QUANTITIES REQUIRED		
(a)	(b)	(c)	INITIAL OPERATION (d)	RUNNING SPARES (e)	TOTAL (f)
1	7.62mm M24 Sniper Weapon System (SW5) Serial No. <u>C6225246</u> NSN: 1005-01-240-2136 	Ea			1
<u>Note:</u> All Optic Scope Ring mounts Packed					
6. THIS CERTIFIES THAT ITEMS LISTED HEREON ARE WITHIN THE SPECIFIED BOXES					
TYPED NAME AND TITLE <i>Ray Fuller WG-10 Bn. Armorer</i>			SIGNATURE 		

DD FORM 1 SEP 70 1750

PAGE NO.

NO. OF PAGES

REQUIREMENT CONTROL SYMBOL

CSGLD--1047(R1)

SECTION I - EQUIPMENT DATA

SECTION II - WORK ACCOMPLISHED

DA FORM 2407
MAY 81

EDITION OF JUL 79 IS OBSOLETE

NMP COPY 2

M2400152427

Final Inspection

In: C6225246

DATE REC'D: 8/1/94

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 #

C6225246

OP. #	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and Stock		8/3/94	RW
600	Proof		8/3/94	RW
607	Check Headspace		8/3/94	RW
610	Dis-assemble Gun		8/3/94	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		8/13/94	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/13/94	RW
	C) Inspect Ejector Hole for Chamfer		8/13/94	RW
	D) Oil Firing Pin Ass'y		8/13/94	RW
	E) Adjust Trigger Pull to Min Setting and Stake			

op. #	OP. NAME	READINGS					DATE	INITIAL
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							
	A) Time							
	B) Malfunctions							
	C) Pierced Primers							
	D) Optical Clarity of Scope							
645	Inspect for Live Ammo							
655	Final Inspection A) Headspace						8/16/94	W.B
	B) Trigger Pull	2.70	2.71	2.66	2.66	2.68	8/16/94	W.B
	C) Function							
660	Pack							

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06225246
18 Aug 1994

CENTROIDAL DISTANCES

0 TO	1	.251796
1 TO	2	.330055
1 TO	3	.144589
1 TO	4	.258118
1 TO	5	.154932

4
3

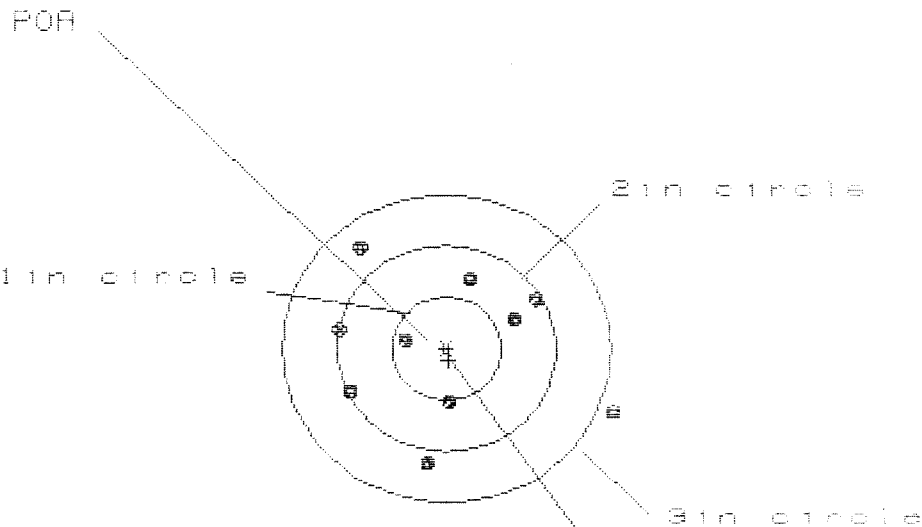
-----POA

THE AVERAGE X COORDINATE FOR THIS RIFLE IS: -.1472
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1328
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .193252
THE AMR FOR THIS RIFLE IS: .8356

15 Aug 1994

FILE:/PATTERNING/CENTERFIRE_PATT/06225246

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1in = 1

2in = 6

3in = 3

HS= 2.526

VS= 2.050

GS= 2.797

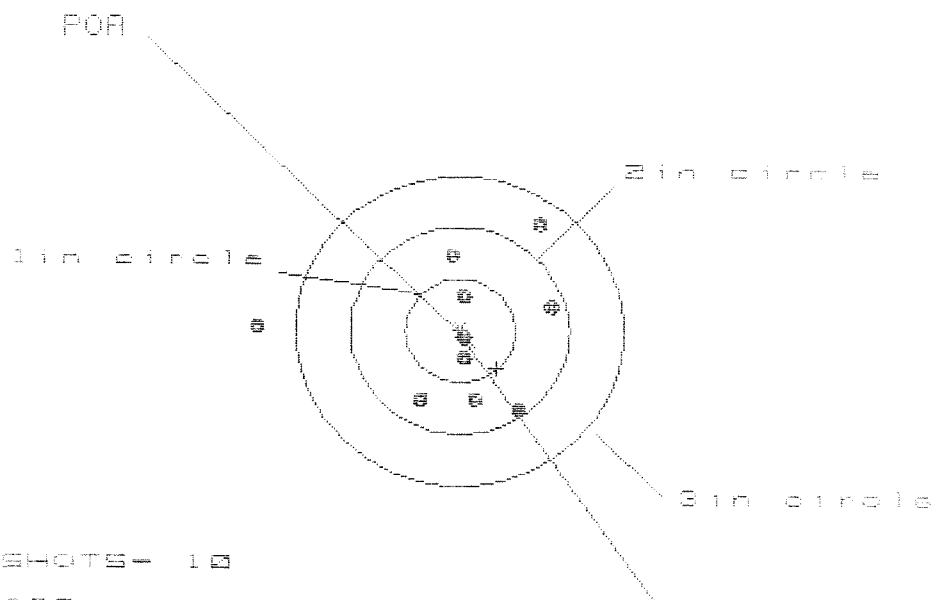
CENTROID #

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.519	.959	.879
MINIMUM X	:	-1.007	-.838	-.918
MAXIMUM Y	:	.949	.881	.726
MINIMUM Y	:	-1.101	-1.169	-1.059
CENTROID X	:	-.020	-.189	-.109
CENTROID Y	:	.115	.183	.073
FOR TO CENTROID in.	:	.117	.263	.131
MIN RADIUS	:	.363	.187	.291
MEAN RADIUS	:	.929	.829	.795
MAX RADIUS	:	1.637	1.169	1.068
HORIZONTAL SPREAD	:	2.526	1.797	1.797
VERTICAL SPREAD	:	2.050	2.050	1.785
EXTREME SPREAD	:	2.797	2.141	1.917
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

18 Aug 1994

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 5

3 in = 6

HS= 2.737

VS= 1.780

CS= 2.809

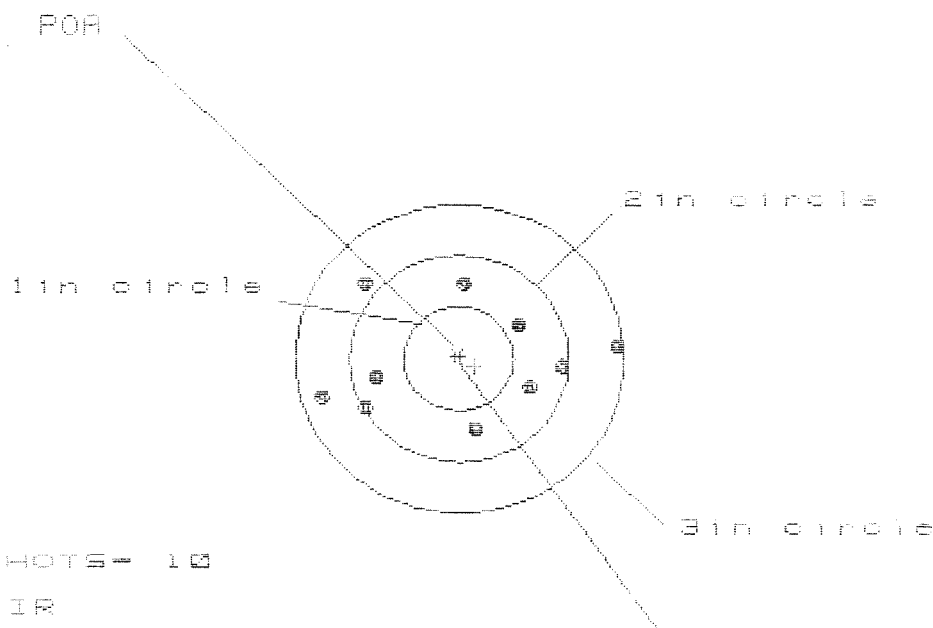
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.836	.619	.683
MINIMUM X	-1.907	-.557	-.493
MAXIMUM Y	1.040	1.048	.925
MINIMUM Y	-.740	-.732	-.601
CENTROID X	-.335	-.124	-.189
CENTROID Y	.359	.351	.220
POA TO CENTROID in.	.492	.372	.290
MIN RADIUS	.027	.189	.176
MEAN RADIUS	.782	.657	.568
MAX RADIUS	1.908	1.170	.941
HORIZONTAL SPREAD	2.737	1.176	1.176
VERTICAL SPREAD	1.780	1.780	1.526
EXTREME SPREAD	2.809	2.018	1.622
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		8	
NUMBER IN THREE INCH CIRCLE =		9	

18 Aug 1994

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CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1in = 0

2in = 7

3in = 10

HSI = 2.733

VS = 1.440

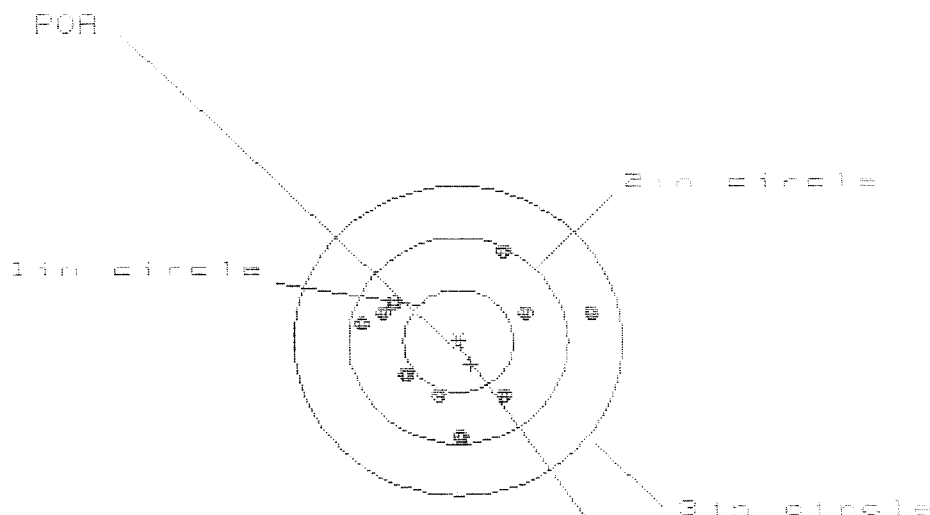
GS = 2.787

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.461	1.086	.948
MINIMUM X	:	-1.272	-1.110	-.814
MAXIMUM Y	:	.756	.771	.722
MINIMUM Y	:	-.684	-.669	-.718
CENTROID X	:	-.145	-.307	-.169
CENTROID Y	:	.072	.057	.106
POA TO CENTROID in.	:	.162	.312	.199
MIN RADIUS	:	.655	.609	.659
MEAN RADIUS	:	.932	.866	.815
MAX RADIUS	:	1.467	1.178	1.088
HORIZONTAL SPREAD	:	2.733	2.196	1.761
VERTICAL SPREAD	:	1.440	1.440	1.440
EXTREME SPREAD	:	2.787	2.225	1.936
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

16 Aug 1984

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CENTERFIRE PATTERNS # 4



OF SHOTS = 10

IN CIR

1 in = 0

2 in = 9

3 in = 10

HS = 2.117

VS = 1.710

GS = 2.120

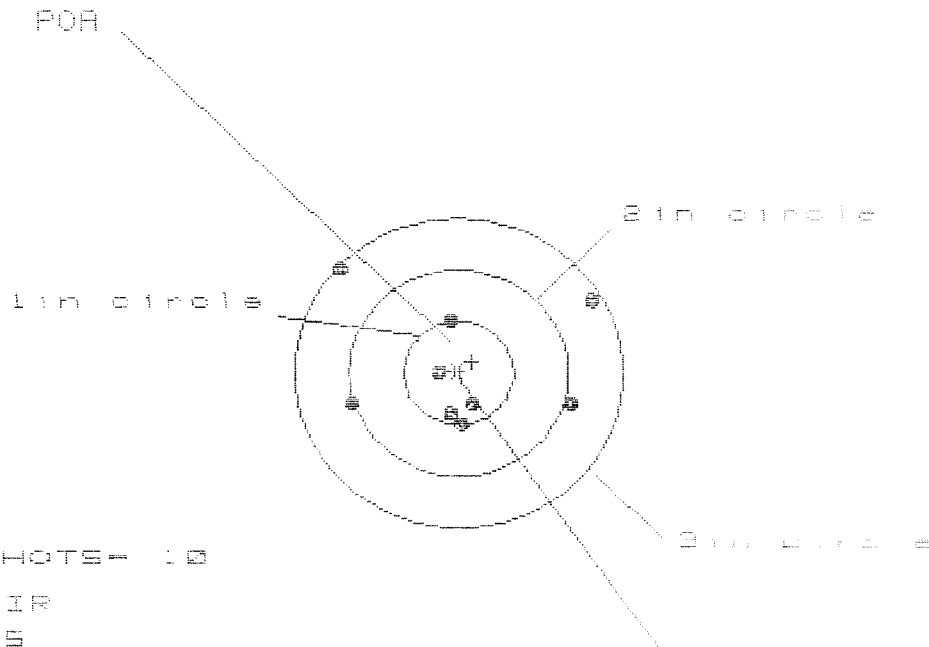
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.233	.795	.869
MINIMUM X	-.884	-.747	-.673
MAXIMUM Y	.831	.861	.540
MINIMUM Y	-.879	-.849	-.741
CENTROID X	-.115	-.252	-.326
CENTROID Y	.224	.194	.086
POA TO CENTROID in.	.251	.318	.337
MIN RADIUS	.542	.457	.335
MEAN RADIUS	.801	.727	.662
MAX RADIUS	1.261	1.045	.977
HORIZONTAL SPREAD	2.117	1.542	1.542
VERTICAL SPREAD	1.710	1.710	1.281
EXTREME SPREAD	2.120	1.760	1.540
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	9		
NUMBER IN THREE INCH CIRCLE =	10		

18 Aug 1984

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CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1 in = 5

2 in = 7

3 in = 10

HS= 2.326

VS= 1.511

GS= 2.502

CENTROID #

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.226	1.163	1.058
MINIMUM X	-1.101	-1.068	-0.936
MAXIMUM Y	.981	.855	.696
MINIMUM Y	-.538	-.421	-.315
CENTROID X	-.121	.001	-.137
CENTROID Y	-.186	-.215	-.321
POA TO CENTROID in.	.181	.215	.343
MIN RADIUS	.199	.173	.139
MEAN RADIUS	.734	.632	.481
MAX RADIUS	1.474	1.395	1.062
HORIZONTAL SPREAD	2.326	2.171	1.988
VERTICAL SPREAD	1.511	1.276	1.011
EXTREME SPREAD	2.502	2.386	1.989
NUMBER IN ONE INCH CIRCLE =	5		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	10		