

G-646 1622
Replaced
C-6225051

Repair Inquiry

Repair Number: **RE00092449**

Serial: C6225051 Model: M24 SWS Center Fire
Caliber: 7.62 NATO Produced: 03/21/1989

Repairman:

Status:

Closed 2/3/2005 1:25:56 PM

Address Information

Customer:

☒ Received From

Return To:

☐ Received From

Name: DEF DIST DEPOT ANNISTON

DEF DIST DEPOT ANNISTON

Address 1:

Address 2:

City: 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
A017	Scope Base	1
A057	Fit and Rear Sgt Base	1

Repair Search

Refresh

Close

mag1aj

2/7/2005

10:55 AM

CAPS

NUM

INS

SCPL

start

3

3

ARMS SERVICES

3

3

C6461622 (New)
C6225051
Model: M24 SWS

RE00092449

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6461622.___0
FILE DATE AND TIME: 09/02/2005 11:20

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.002
The Average Y Centroid of the Five Target Set:	0.009
The Average Point of Impact of the Five Target Set:	0.009
The Average Mean Radius of the Five Target Set:	0.910
The Distance from POA to Centroid Target #1:	0.176
The Distance from Centroid Target #2 to Centroid Target #1:	0.232
The Distance from Centroid Target #3 to Centroid Target #1:	0.076
The Distance from Centroid Target #4 to Centroid Target #1:	0.306
The Distance from Centroid Target #5 to Centroid Target #1:	0.296

SERIAL NUMBER: G6461622.___0

POINT#	X	Y
--------	---	---

TARGET NUMBER: 1

FILE DATE: 09/02/2005

FILE TIME: 11:20

X CENTROID: -0.072

Y CENTROID: 0.160

POA TO CENTROID: 0.176

HORZ SPREAD: 2.372

VERT SPREAD: 2.626

GROUP SPREAD: 2.646

MIN RADIUS: 0.538

MAX RADIUS: 1.642

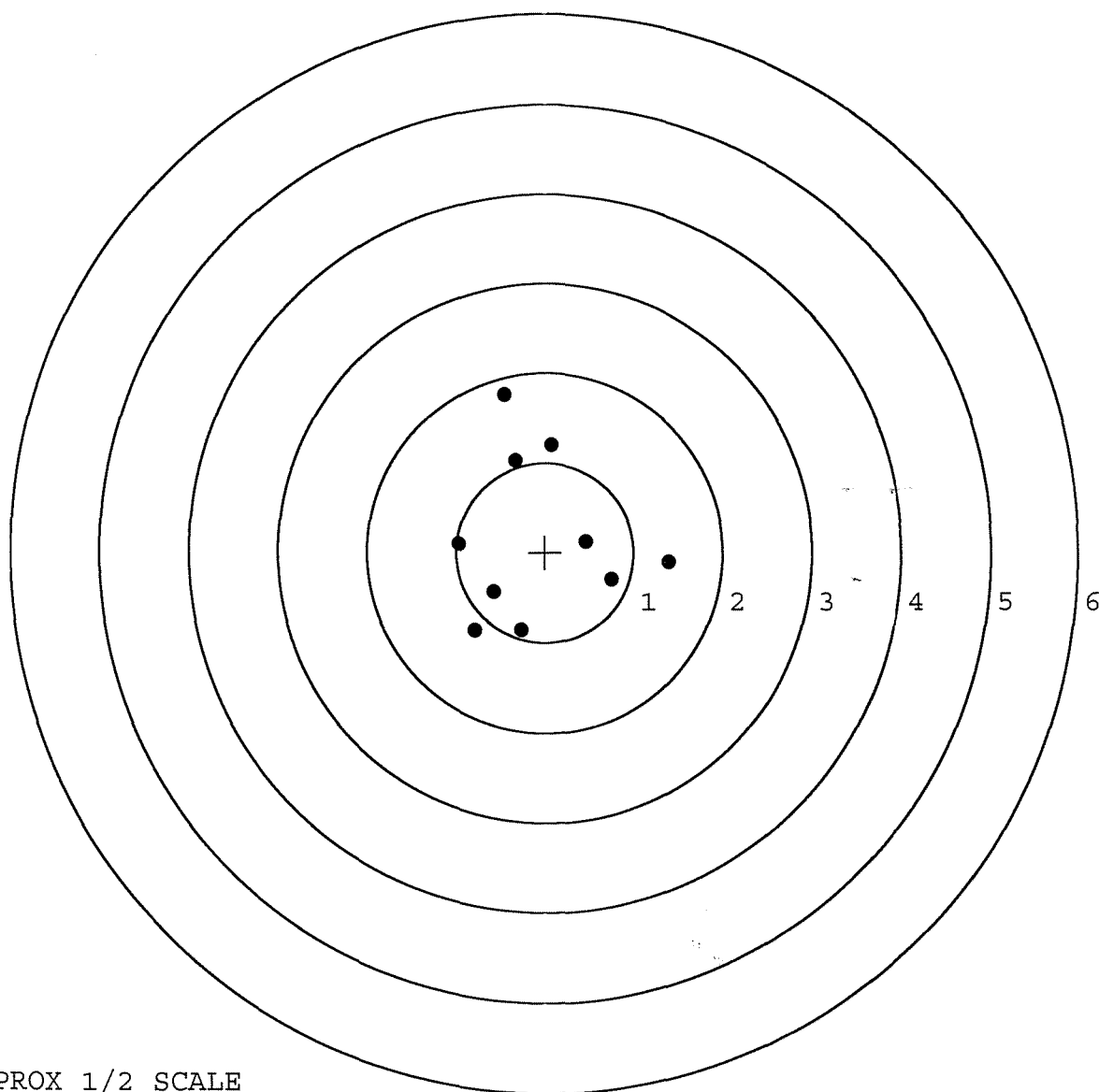
MEAN RADIUS: 1.057

IN 1 IN DIAMETER: 0

IN 2 IN DIAMETER: 5

in 3 IN DIAMETER: 9

1:	1.399	-0.112
2:	0.752	-0.300
3:	0.464	0.126
4:	-0.267	-0.869
5:	-0.581	-0.441
6:	-0.790	-0.871
7:	-0.973	0.094
8:	-0.339	1.025
9:	0.077	1.197
10:	-0.466	1.755

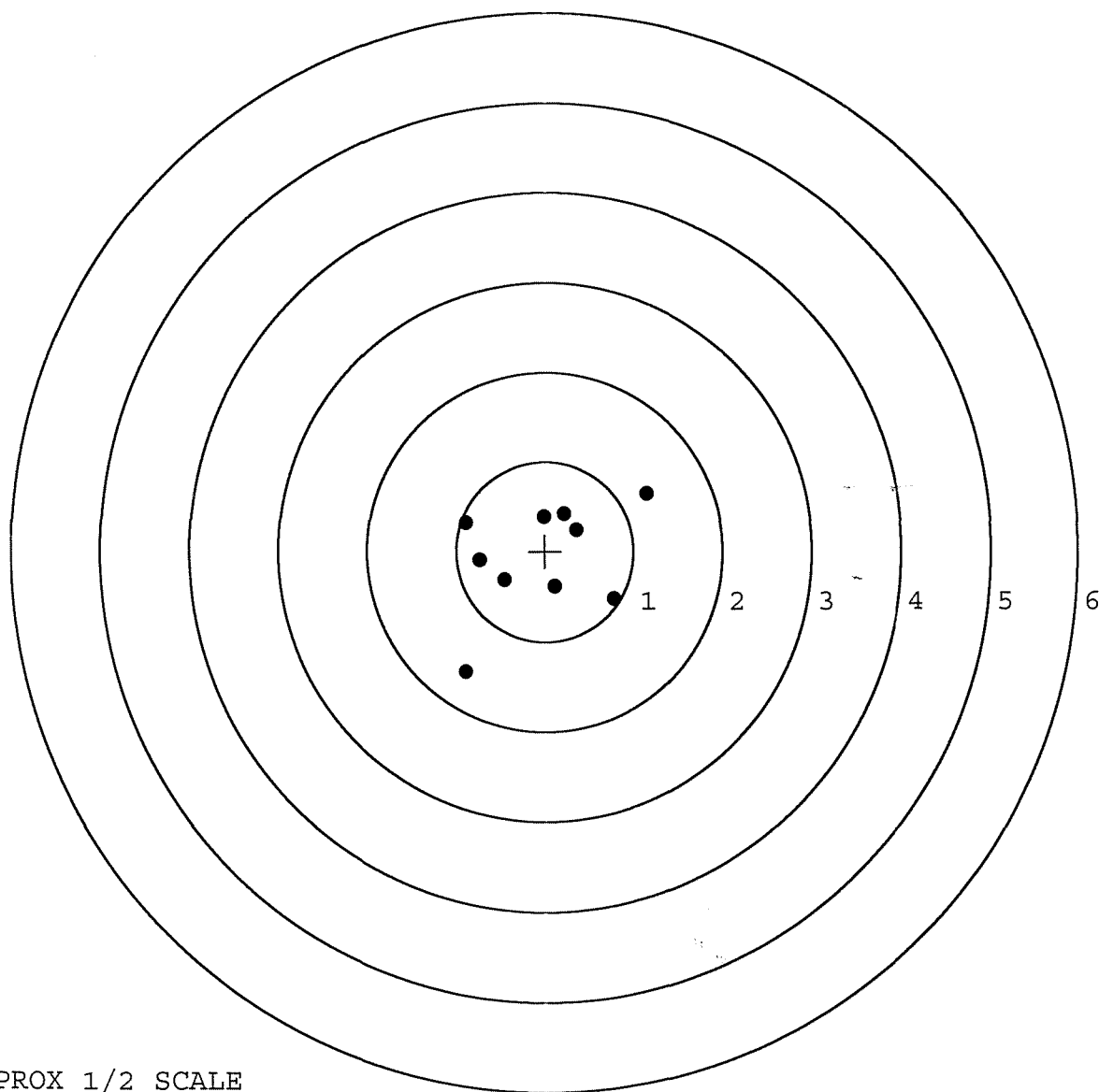


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461622.___0
TARGET NUMBER: 2
FILE DATE: 09/02/2005
FILE TIME: 11:20

X CENTROID: -0.041
Y CENTROID: -0.069
POA TO CENTROID: 0.080
HORZ SPREAD: 2.039
VERT SPREAD: 1.976
GROUP SPREAD: 2.839
MIN RADIUS: 0.359
MAX RADIUS: 1.527
MEAN RADIUS: 0.782
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 9

POINT#	X	Y
1:	0.777	-0.532
2:	0.107	-0.396
3:	1.143	0.642
4:	0.358	0.236
5:	0.212	0.414
6:	-0.021	0.381
7:	-0.887	0.317
8:	-0.738	-0.100
9:	-0.460	-0.320
10:	-0.896	-1.334

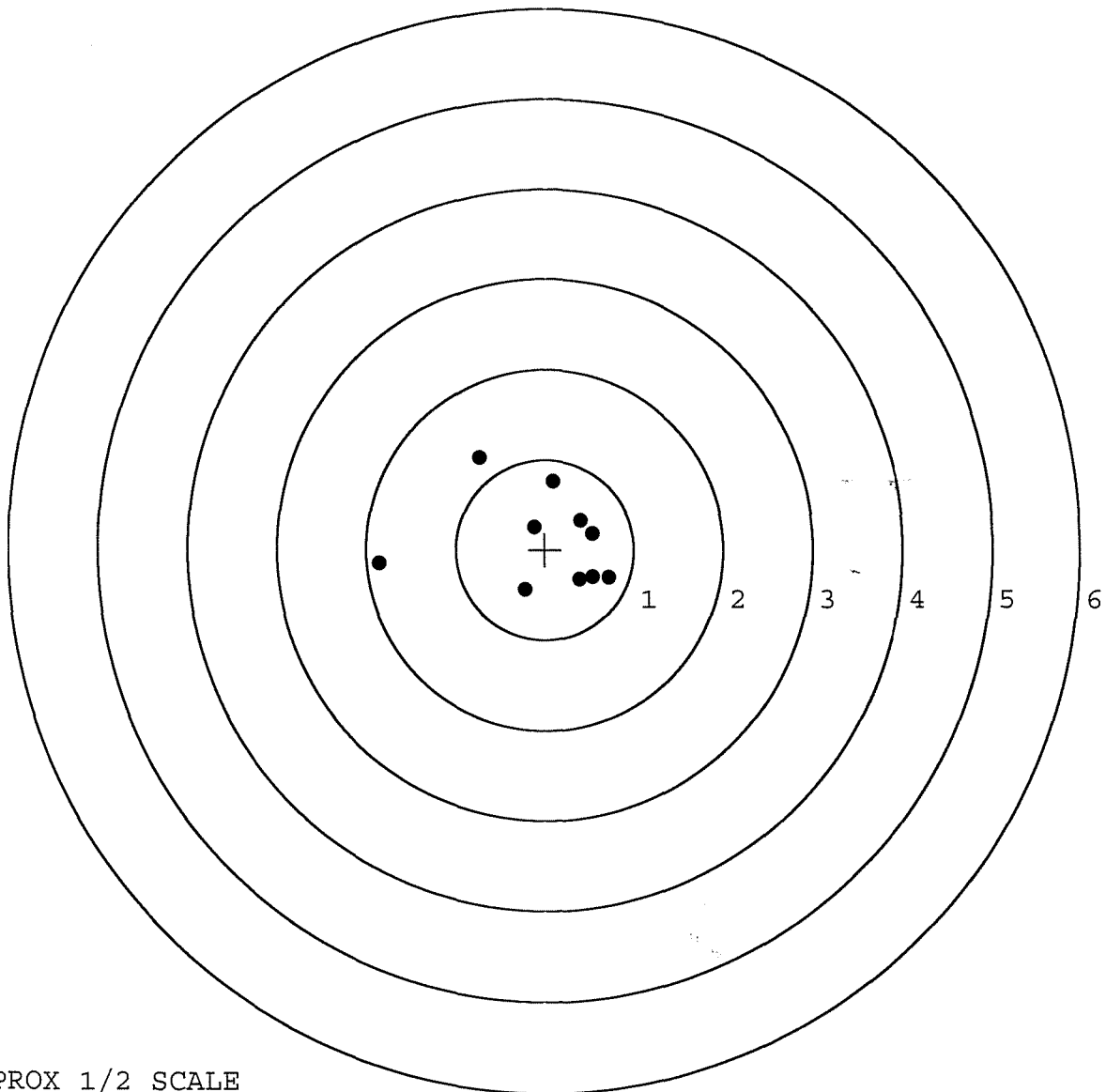


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461622. __0
TARGET NUMBER: 3
FILE DATE: 09/02/2005
FILE TIME: 11:20

X CENTROID: -0.028
Y CENTROID: 0.099
POA TO CENTROID: 0.103
HORZ SPREAD: 2.577
VERT SPREAD: 1.476
GROUP SPREAD: 2.582
MIN RADIUS: 0.182
MAX RADIUS: 1.849
MEAN RADIUS: 0.766
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 9

POINT#	X	Y
1:	0.719	-0.313
2:	0.387	-0.333
3:	0.537	0.185
4:	0.405	0.330
5:	0.091	0.759
6:	-0.126	0.253
7:	-0.229	-0.451
8:	-0.739	1.025
9:	-1.858	-0.160
10:	0.536	-0.301



SERIAL NUMBER: G6461622. 0

TARGET NUMBER: 4

FILE DATE: 09/02/2005

FILE TIME: 11:20

POINT#	X	Y
1:	1.715	0.130
2:	1.425	0.236
3:	0.715	-0.213
4:	0.179	1.494
5:	-0.170	0.906
6:	0.054	0.422
7:	-0.340	-0.178
8:	-0.488	-0.447
9:	-0.229	-1.139
10:	-1.038	-1.304

X CENTROID: 0.182

Y CENTROID: -0.009

POA TO CENTROID: 0.183

HORZ SPREAD: 2.753

VERT SPREAD: 2.798

GROUP SPREAD: 3.104

MIN RADIUS: 0.450

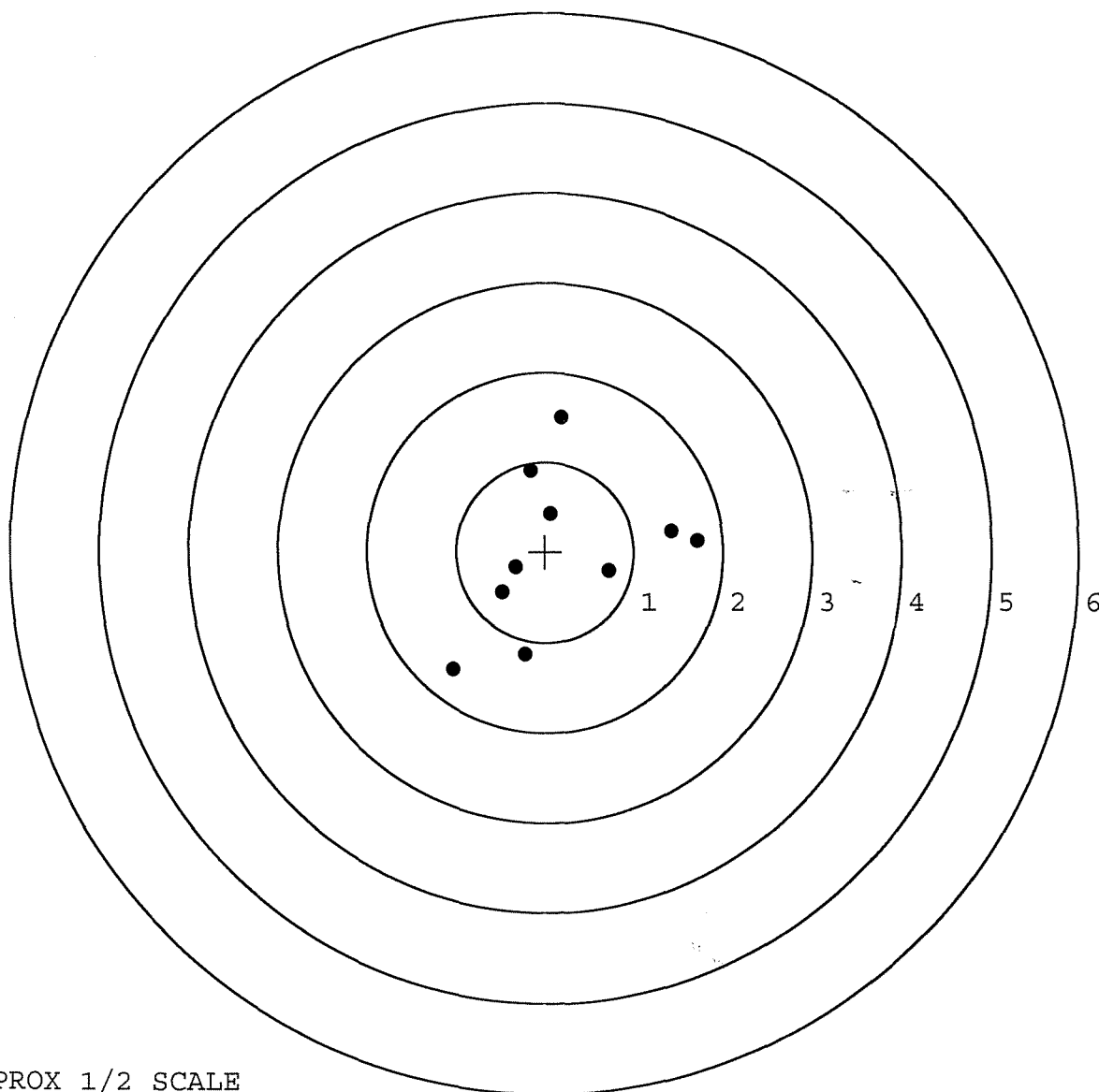
MAX RADIUS: 1.779

MEAN RADIUS: 1.064

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 5

in 3 IN DIAMETER: 7

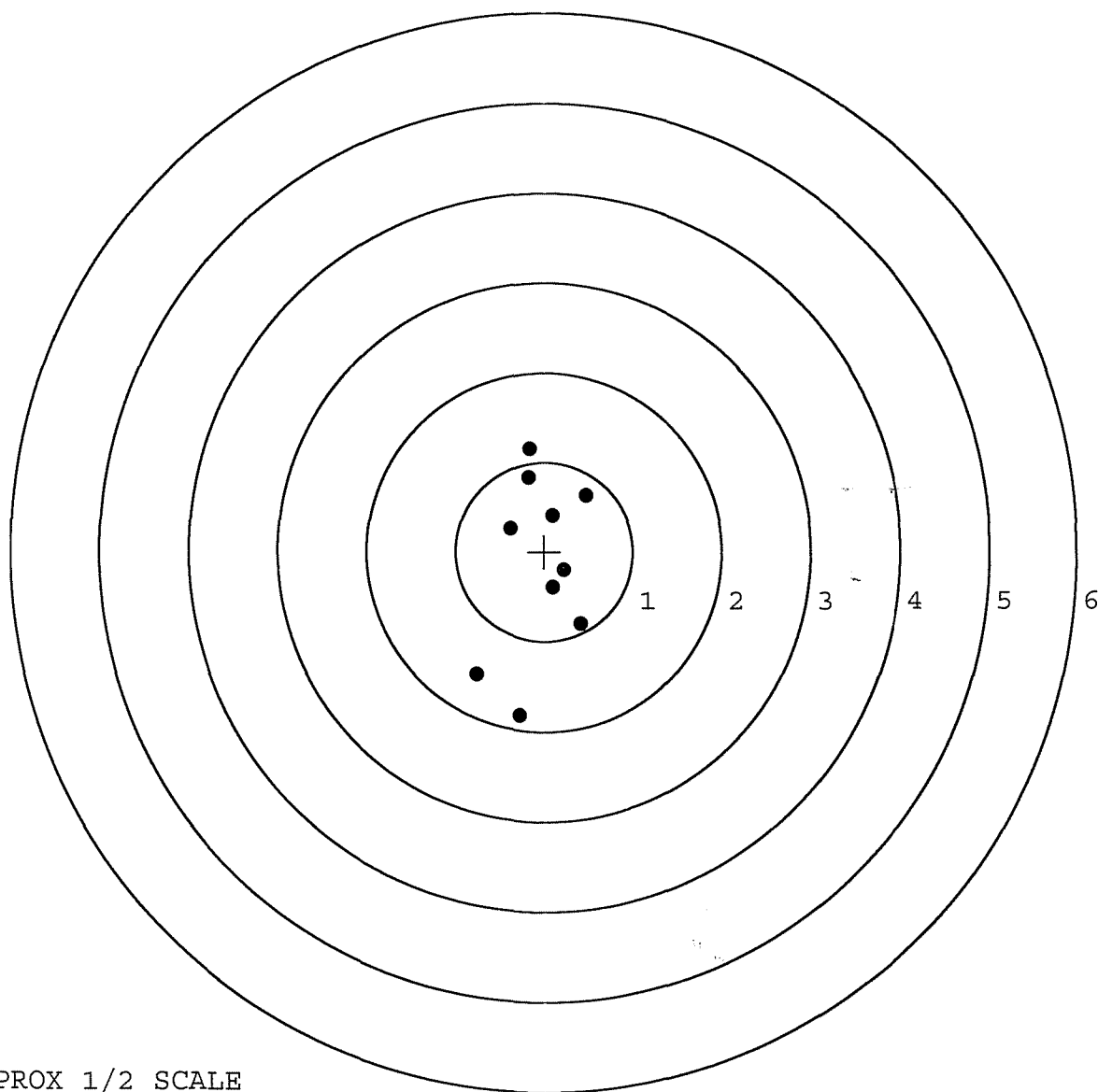


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461622._0
TARGET NUMBER: 5
FILE DATE: 09/02/2005
FILE TIME: 11:20

POINT#	X	Y
1:	-0.284	-1.820
2:	-0.764	-1.370
3:	0.411	-0.812
4:	0.096	-0.406
5:	0.222	-0.211
6:	0.472	0.629
7:	0.088	0.400
8:	-0.384	0.258
9:	-0.185	0.833
10:	-0.171	1.153

X CENTROID: -0.050
Y CENTROID: -0.135
POA TO CENTROID: 0.144
HORZ SPREAD: 1.236
VERT SPREAD: 2.973
GROUP SPREAD: 2.975
MIN RADIUS: 0.282
MAX RADIUS: 1.702
MEAN RADIUS: 0.880
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

AVERAGE PULL FORCE BETWEEN

SERIAL NO.

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 7-5-05

TESTER TRW

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.32	2.49		2.74	
PULL #2	2.36	2.68		2.41	
PULL #3	2.31	2.62		2.27	
PULL #4	2.61	2.63		2.40	
PULL #5	2.66	2.55		2.33	
TOTAL	12.26	12.97		12.15	
AVERAGE	2.45	2.59		2.43	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.35	3.20		
PULL #2	3.21	3.12		
PULL #3	3.24	3.14		
PULL #4	3.06	3.14		
PULL #5	3.06	3.16		
TOTAL	15.92	15.76		
AVERAGE	3.18	3.15		

	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	4.61	4.08		4.68
PULL #2	4.16	4.34		4.44
PULL #3	4.16	4.40		4.48
PULL #4	4.06	4.08		4.31
PULL #5	4.15	4.22		4.53
TOTAL	21.14	21.12		22.44
AVERAGE	4.22	4.22		4.48

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

R & E NUMBER	92449		
SERIAL NUMBER	06225051 66461622 (New)		
LOG-IN DATE	2-3-05		
INSPECT AND VERIFY:			
OPERATION #	OPERATION NAME	DATE	INITIAL
550	DIS-ASSEMBLE GUN	8-16-05	RTJ
560 A	RE-BARREL	8-23-05	RTJ
B	DRILL AND TAP	8-25-05	TRW
575	ASSEMBLE	8-24-05	RTJ
600	PROOF	8-24-05	AC
605	CHECK HEADSPACE	8-24-05	AC
610	DIS-ASSEMBLE GUN	8-25-05	RTJ
612	MAGNAFLUX	8/25/05	Wmcs
615	ROLLMARK CALIBER	8-25-05	CW
618	ROTO-BLAST	8-26-05	LB
620	APPLY COATINGS	8/29/05	RTJ
625 A	FINAL ASSEMBLY	9-1-05	RTJ
B	TRIGGER PULL TEST	9-7-05	AC
C	SAFETY "ON" FORCE	9-7-05	AC
D	SAFETY "OFF" FORCE	9-7-05	AC
E	FIRING PIN INDENT	9-7-05	AC
640	TARGET	9-2-05	TRW
655	FINAL INSPECT	9-7-05	AC
660	PACK	9-9-05	OA
		SHIP DATE	
		QAR INSPECTION DATE	

Remington



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

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

MODEL 700TM H24

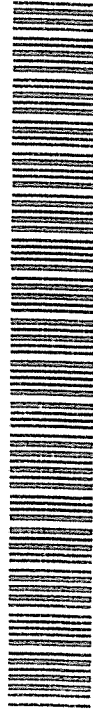
SERIAL NO.

C6225051

ORDER NO.

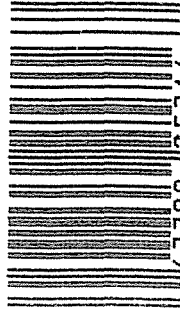
5716

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



5716 C6225051

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6225051

OP. #	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and Stock	9 12	8 8	FB
600	Proof	9 19	8 8	RW
607	Check Headspace	9 19	8 8	RW
610	Dis-assemble Gun	9 19	8 8	RW
612	Magnaflux Barrel Action		9 22 88	P/c.
	Magnaflux Bolt		9 22 88	P/c.
615	Rollmark Caliber		10-77	G.S.
617	Drill and Tap Sight Holes		10-78	F.B.
618	Polish Barrel		10-79	WST
620	Apply Coatings (Barrel Action)		10-31-88	TJA
	Apply Coating (Bolt)		10-31-88	TJA
625	Final Assembly A) Clean inside of Bolt Assembly		10/10/88	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/10/88	RW
	C) Inspect Ejector Hole for Chamfer		10/10/88	RW
	D) Oil Firing Pin Ass'y		10/10/88	RW
	E) Adjust Trigger Pull to Min Setting and Stake		10/10/88	GL

op. #	OP. NAME	READINGS					DATE	INITIAL
625 cont.	F) Safety On Force	5	5	5			11/10/88	JSJ
	G) Safety Off Force	3	3	3			11/10/88	JSJ
	H) Trigger Pull Test & Retainability						10/10/88	JLJ
	I) Firing Pin Indent	.022	.022	.022			11/10/88	JSJ
	J) Assemble Stock						2/3/89	RW
	K) Assemble Swivel Studs						8/26/89	JSJ
	L) Attach Front and Rear Sight Assemblies						2/3/89	RW
	M) Iron Sight Alignment						2/3/89	RW
	N) Detach Front & Rear Sights & place in numbered container						2/3/89	RW
	O) Attach Scope to Rifle						2/3/89	RW
	P) Detach & Attach Scope 20 Times						6/26/89	JSJ
640	Gallery Target & Test	GIR 91L					2/7/89	DH
	A) Time						2/7/89	DH
	B) Malfunctions						2/7/89	DH
	C) Pierced Primers						2/7/89	DH
	D) Optical Clarity of Scope						2/7/89	DH
645	Inspect for Live Ammo						2/7/89	DH
655	Final Inspection							
	A) Headspace						8/26/89	JSJ
	B) Trigger Pull	2.27	2.33	2.45	2.48	2.52	8/26/89	JSJ
	C) Function						8/26/89	JSJ
660	Pack						27/10/89	JSJ

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. 5051
C6775217

DATE 5/26/89

TESTER WB

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.41	2.25	2.20	2.27	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.30	2.37	2.22	2.37	
PULL #3	2.40	2.38	2.22	2.43	
PULL #4	2.37	2.38	2.15	2.36	
PULL #5	2.24	2.23	2.15	2.41	
TOTAL	11.72	11.61	10.94	11.84	
AVG.	2.34	2.32	2.19	2.368	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.24	3.24		
PULL #2	3.23	3.19		
PULL #3	3.32	3.33		
PULL #4	3.40	3.25		
PULL #5	3.44	3.29		
TOTAL	16.63	16.30		
AVG.	3.32	3.26		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.45	4.26		4.07
PULL #2	4.39	4.28		4.13
PULL #3	4.28	4.24		4.09
PULL #4	4.20	4.24		4.18
PULL #5	4.28	4.21		4.15
TOTAL	21.60	21.23		20.62
AVG.	4.32	4.24		4.12

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6225051
10 Feb 1989

CENTROIDAL DISTANCES

0 TO 1	.395545
1 TO 2	.571685
1 TO 3	.277914
1 TO 4	.538065
1 TO 5	.485603

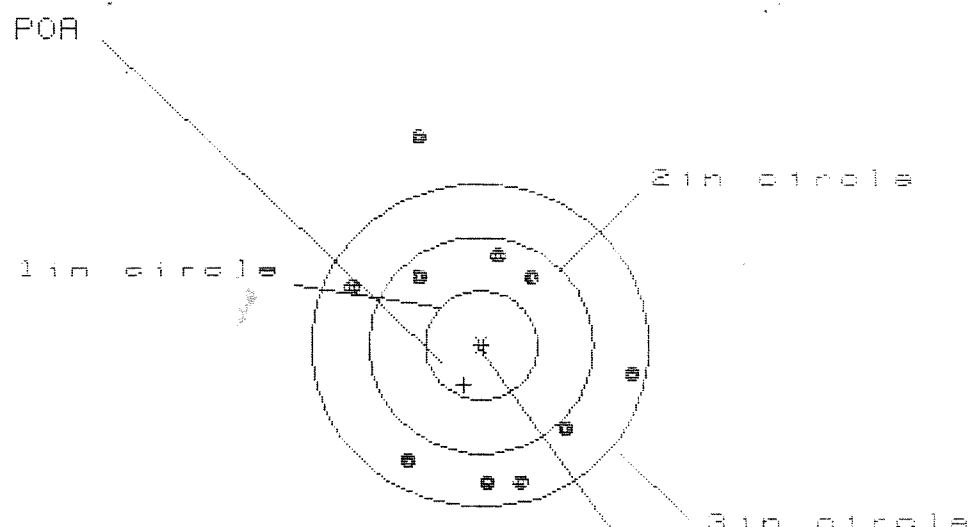
2
L
+3 (----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .3712
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .2070
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .439227
THE AMR FOR THIS RIFLE IS: 1.088

18 Feb 1989

FILE:/PATTERNING/CENTERFIRE_PATT/06225051

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1 in = 0

2 in = 3

3 in = 8

HS = 2.513

VS = 3.250

GS = 3.347

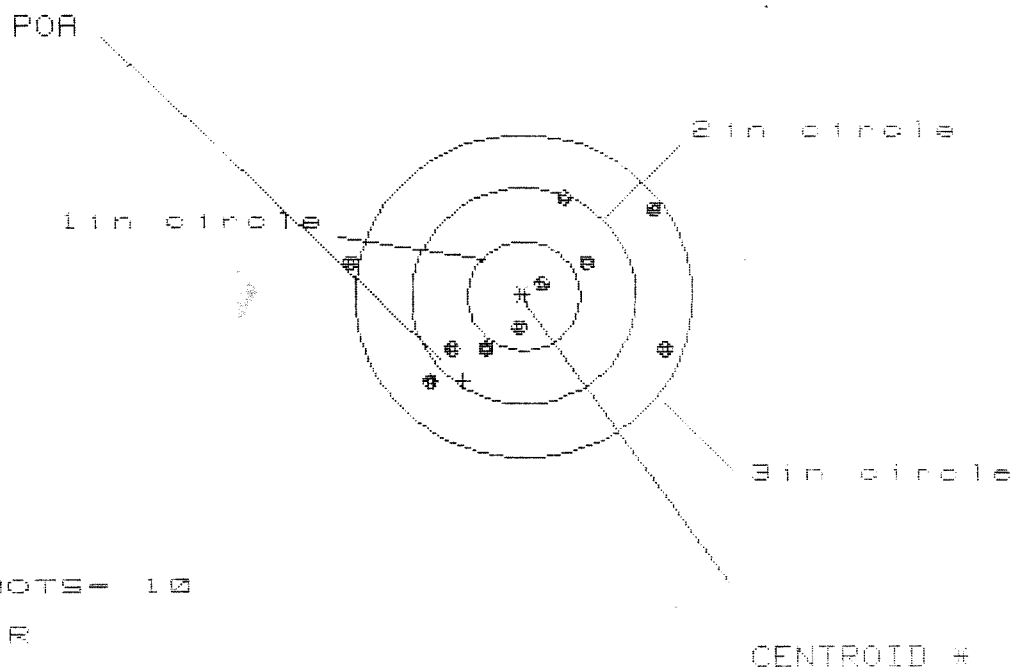
CENTROID #

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.349	1.283	.838
MINIMUM X	:	-1.164	-1.230	-1.070
MAXIMUM Y	:	1.975	1.018	1.017
MINIMUM Y	:	-1.275	-1.056	-1.057
CENTROID X	:	.150	.216	.056
CENTROID Y	:	.366	.147	.148
POR TO CENTROID in.	:	.396	.261	.158
MIN RADIUS	:	.773	.883	.989
MEAN RADIUS	:	1.208	1.100	1.072
MAX RADIUS	:	2.062	1.451	1.317
HORIZONTAL SPREAD	:	2.513	2.513	1.908
VERTICAL SPREAD	:	3.250	2.074	2.074
EXTREME SPREAD	:	3.347	2.631	2.339
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		9	

18 Feb 1989

FILE:/PATTERNING/CENTERFIRE_PATT/06225051

CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1 in = 2

2 in = 6

3 in = 9

HS = 2.825

VS = 1.755

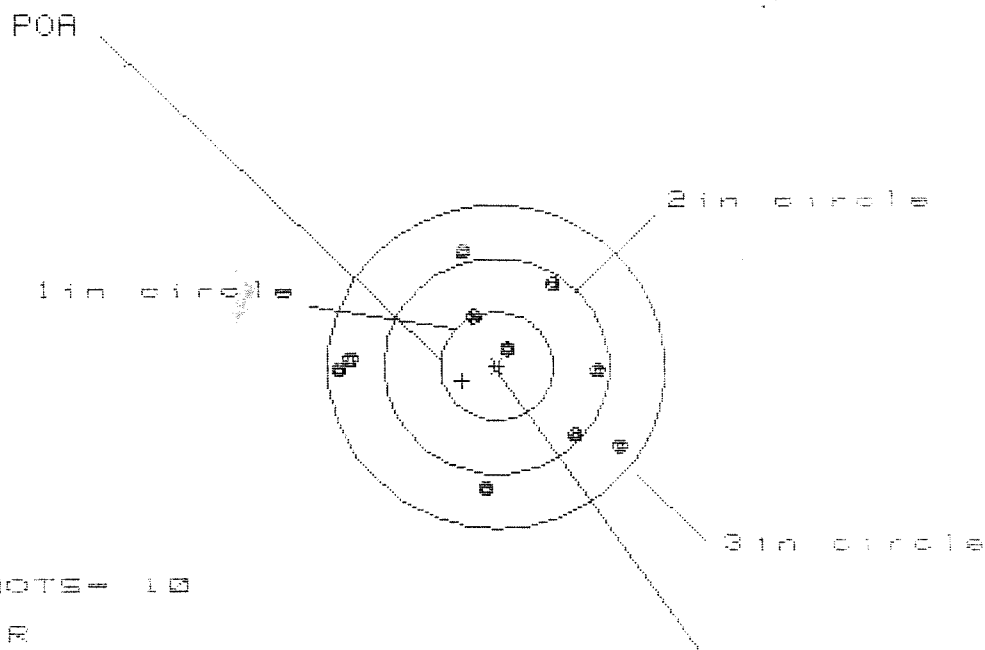
GS = 2.945

PATTERN #	2		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.287	1.116	1.241
MINIMUM X	-1.538	-1.013	-0.888
MAXIMUM Y	.948	.985	1.091
MINIMUM Y	-.807	-.770	-.665
CENTROID X	.540	.711	.586
CENTROID Y	.784	.747	.642
POA TO CENTROID in.	.952	1.032	.869
MIN RADIUS	.181	.174	.146
MEAN RADIUS	.910	.832	.751
MAX RADIUS	1.573	1.314	1.292
HORIZONTAL SPREAD	2.825	2.129	2.129
VERTICAL SPREAD	1.755	1.755	1.755
EXTREME SPREAD	2.945	2.586	2.151
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		9	

10 Feb 1989

FILE:/PATTERNING/CENTERFIRE_PATT/06225051

CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1in = 1

2in = 5

3in = 10

HS = 2.485

VS = 2.257

GS = 2.569

CENTROID *

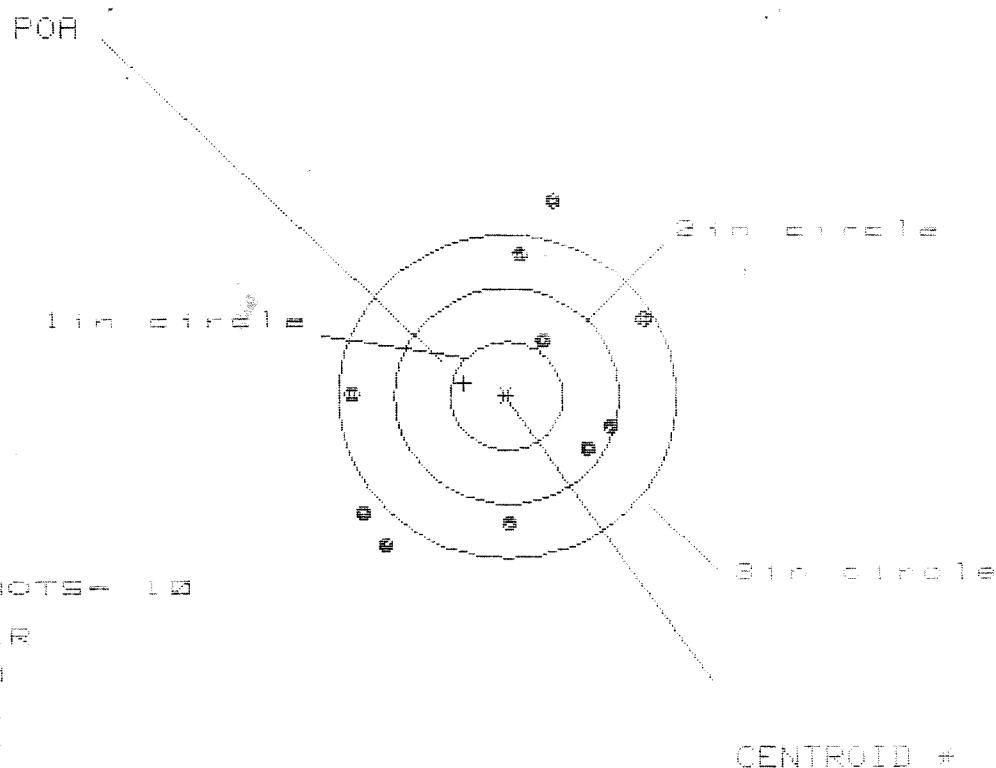
PATTERN #	3	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.082	.926	.745
MINIMUM X	-1.403	-1.449	-.670
MAXIMUM Y	1.081	1.076	1.080
MINIMUM Y	-1.176	-1.181	-1.177
CENTROID X	.306	.462	.643
CENTROID Y	.136	.140	.136
FOR TO CENTROID in.	.335	.482	.657
MIN RADIUS	.197	.187	.308
MEAN RADIUS	.977	.911	.829
MAX RADIUS	1.403	1.449	1.271
HORIZONTAL SPREAD	2.485	2.375	1.415
VERTICAL SPREAD	2.257	2.257	2.257
EXTREME SPREAD	2.569	2.483	2.270
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		10	

18 Feb 1989

FILE:/PATTERNING/CENTERFIRE_PATT/08225051

CENTERFIRE PATTERNS

4



OF SHOTS- 10

IN CIR

1 in = 0

2 in = 3

3 in = 7

HS= 2.624

VS= 3.171

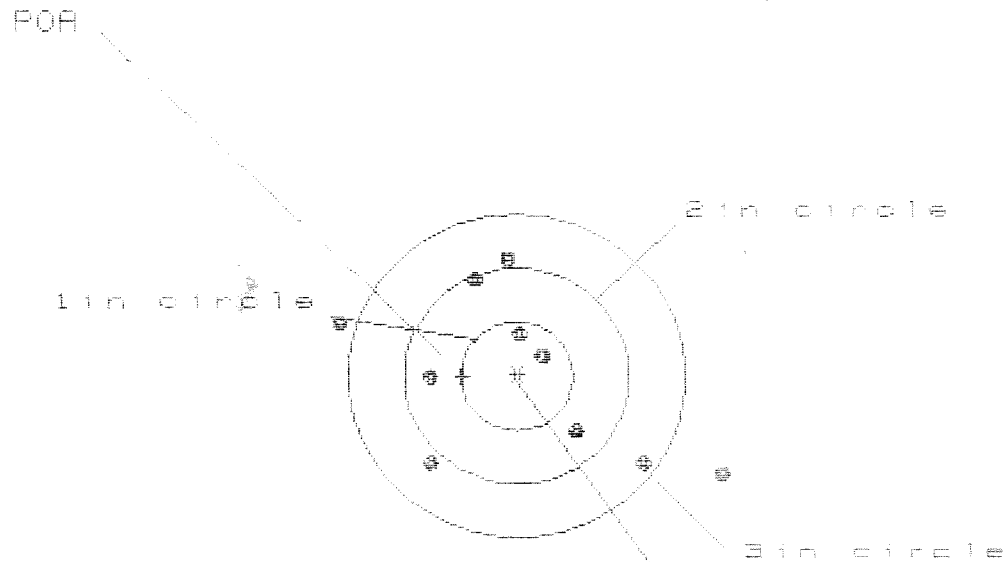
GS= 3.504

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.198	1.247	1.123
MINIMUM X	:	-1.426	-1.377	-1.502
MAXIMUM Y	:	1.825	1.525	1.382
MINIMUM Y	:	-1.346	-1.143	-1.103
CENTROID X	:	.383	.334	.459
CENTROID Y	:	-.119	-.322	-.179
POA TO CENTROID in.	:	.401	.464	.492
MIN RADIUS	:	.615	.819	.640
MEAN RADIUS	:	1.303	1.232	1.168
MAX RADIUS	:	1.878	1.530	1.690
HORIZONTAL SPREAD	:	2.624	2.624	2.624
VERTICAL SPREAD	:	3.171	2.668	2.485
EXTREME SPREAD	:	3.504	3.029	3.029
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		7	

18 Feb 1989

FILE:/PATTERNING/CENTERFIRE_PATT/08225051

CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1in = 2

2in = 5

3in = 8

HS= 3.356

VS= 2.000

GS= 3.621

CENTROID #

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.784	1.331	1.168
MINIMUM X	-1.572	-1.374	-1.788
MAXIMUM Y	1.114	1.016	1.063
MINIMUM Y	-1.886	-1.924	-1.877
CENTROID X	.477	.279	.458
CENTROID Y	.007	.105	.059
POR TO CENTROID in.	.477	.298	.454
MIN RADIUS	.273	.377	.264
MEAN RADIUS	1.040	.917	.837
MAX RADIUS	1.992	1.621	1.454
HORIZONTAL SPREAD	3.356	2.705	1.940
VERTICAL SPREAD	2.000	1.940	1.940
EXTREME SPREAD	3.621	3.001	2.309
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		8	

R 94-19418

M2400153907

DEPARTMENT OF THE ARMY

HAC 1/325 AIR
ATTN: SPC Roman
Ft. Bragg N.C. 28307

OFFICIAL BUSINESS

Remington Arms Co. INC.
ATTN: Fabricated products Dept.
14 Hoefler Avenue
Ilion NY, 13357 1816

DA Label 18-1, Sep 83
Edition of Oct 74 will be used until exhausted.

Gun #3 SN -

SNIPER'S RECORD

DATE	TYPE OF ROUNDS	NO. RDS. FIRED	TOTAL	DATE	TYPE OF ROUNDS	NO. RDS. FIRED	TOTAL
3 Mar 89	M118	50	50	15 Nov 89	M118	70	720
24 Mar 89	M118	50	100	16 Nov 89	M118	100	820
16 June 89	M118	50	150	17 Nov 89	M118	50	870
29 June 89	M118	50	200	18 Nov 89	M118	100	970
8 July 89	M118	80	280	27 Nov 89	M118	80	1050
26 Aug 89	M118	80	360	28 Nov 89	M118	80	1130
24 Aug 89	M118	140	500	4 Dec 89	M118	100	1230
10 Sep 89	M118	50	550	10 Dec 89	M118	60	1290
6 Oct 89	M118	50	600	Jan 15, 90	M118	80	1370
7 Oct 89	M118	50	650	Jan 16, 90	M118	50	1420
REMARKS				TOTAL THIS PAGE			1420
				TOTAL FROM PREVIOUS PAGES			0
				CUMULATIVE TOTAL			1420

SNIPER'S RECORD

DATE	TYPE OF ROUNDS	NO. RDS. FIRED	TOTAL	DATE	TYPE OF ROUNDS	NO. RDS. FIRED	TOTAL
7 Feb 90	M118	70	1490	10 June 90	M118	50	2250
8 Feb 90	M118	60	1550	11 Jan 90	M118	50	2300
13 Mar 90	M118	150	1700	8 July 90	M118	70	2370
14 Mar 90	M118	50	1750	9 July 90	M118	150	2520
15 Mar 90	M118	50	1800	20 July 90	M118	70	2590
20 Apr 90	M118	100	1900	21 July 90	M118	70	2660
21 Apr 90	M118	100	2000	22 July 90	M118	70	2730
4 May 90	M118	50	2050	23 July 90	M118	70	2800
5 May	M118	50	2100	24 July 90	M118	80	2880
6 June 90	M118	100	2200	25 July 90	M118	100	2980
REMARKS				TOTAL THIS PAGE			
				TOTAL FROM PREVIOUS PAGES			
				CUMULATIVE TOTAL			
				2980			

2980
SNIPER'S RECORD

DATE	TYPE OF ROUNDS	NO. RDS. FIRED	TOTAL	DATE	TYPE OF ROUNDS	NO. RDS. FIRED	TOTAL
20 Mar 91	M118	40	3020	Aug 91	M118	60	3315
22 Mar 91	M118	50	3070	Sep 91	M118	30	3345
23 Apr 91	M118	70	3140	7 Oct 91	M80	25	3370
5 May 91	M118	40	3180	8 Oct 91	M118	100	3470
6 May 91	M118	30	3210	10 Nov 91	M118	90	3550
8 Jun 91	M118	50	3260	11 Dec 91	M118	30	3600
9 Jul 91	M118	100	3360	14 Dec 91	M118	25	3625
12 Jul 91	M118	110	3470	15 Jan 92	M118	100	3725
Aug 91	M118	105	3575	16 Jan 92	M118	90	3815
Aug 91	M118	80	3255	13 Feb 92	M118	40	3855
REMARKS				TOTAL THIS PAGE			
				TOTAL FROM PREVIOUS PAGES			
				CUMULATIVE TOTAL			

3855

SNIPER'S RECORD

DATE	TYPE OF ROUNDS	NO. RDS. FIRED	TOTAL	DATE	TYPE OF ROUNDS	NO. RDS. FIRED	TOTAL
7 Mar 92	M118	50	3905	9 Feb 93	M118	25	4485
8 Mar 92	M118	60	3965	10 Feb 93	M118	100	4585
14 Apr 92	M118	40	4005	20 Mar 93	M118	50	4635
9 Jun 92	M118	100	4105	16 May 93	M118	100	4735
10 Jun 92	M118	100	4205	17 May 93	M118	40	4795
8 Aug 92	M118	100	4305	9 Jun 93	M118	50	4845
10 Oct 92	M118	60	4365	7 Aug 93	M118	60	4905
15 Nov 92	M118	30	4395	9 Sep 93	M118	25	4930
16 Nov 92	M118	25	4420	28 Nov 93	M118	25	4955
7 Jan 93	M118	40	4460	29 Nov 93	M118	100	5055
REMARKS				TOTAL THIS PAGE			
				TOTAL FROM PREVIOUS PAGES			
				CUMULATIVE TOTAL			

SNIPER'S RECORD

DATE	TYPE OF ROUNDS	NO. RDS. FIRED	TOTAL	DATE	TYPE OF ROUNDS	NO. RDS. FIRED	TOTAL
12 Jan 94	M118	25	5680				
13 Jan 94	M618	100	5180				
7 Mar 94	M118	25	5205				
8 Mar 94	M118	100	5305				
REMARKS				TOTAL THIS PAGE			
				TOTAL FROM PREVIOUS PAGES			
				CUMULATIVE TOTAL			

SNIPER'S RECORD

DATE	TYPE OF ROUNDS	NO. RDS. FIRED	TOTAL	DATE	TYPE OF ROUNDS	NO. RDS. FIRED	TOTAL
REMARKS				TOTAL THIS PAGE			
				TOTAL FROM PREVIOUS PAGES			
				CUMULATIVE TOTAL			

Final Inspection

In: C6225051

DATE REC'D: 6/21/94

DATE RET'D:

EDITOR: RW

Item:

Barrel Assy.

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

Item:

Stock Assy.

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

Scope Assy.

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

Systems Case

☐ SCOPE CASE☐ IRON SIGHTS☐ DEPLOYMENT KIT

Trigger

☒ SAFETY OPERATION☒ SET

Comments: _____

Misc.

☐ DD-250☐ BAR CODE☐ PACKAGING

CONTRACT # DAAA21-87-C-0086

New Barrel

GUN SERIAL # C6225051

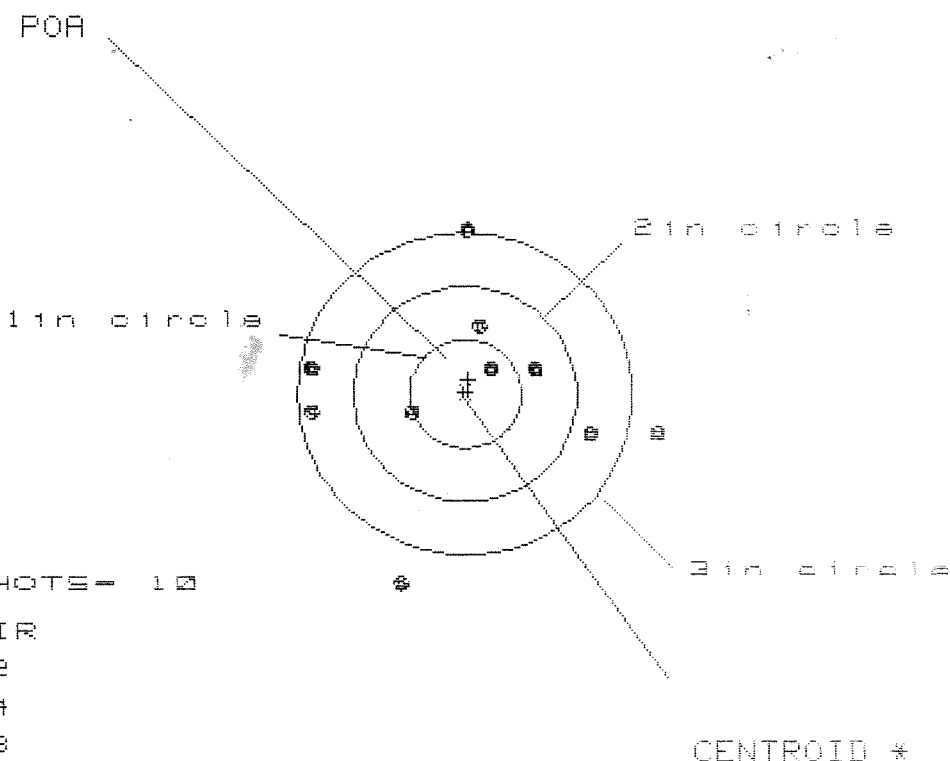
OP. #	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and Stock		6/23/94	RW
600	Proof		6/23/94	RW
607	Check Headspace		6/23/94	RW
610	Dis-assemble Gun		6/23/94	RW
612	Magnaflux Barrel Action			
	Magnaflux Bolt			
615	Rollmark Caliber			
617	Drill and Tap Sight Holes			
618	Polish Barrel			
620	Apply Coatings (Barrel Action)			
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		7/19/94	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		7/19/94	RW
	C) Inspect Ejector Hole for Chamfer		7/19/94	RW
	D) Oil Firing Pin Ass'y		7/19/94	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						7/22/94	RW
	A) Time							
	B) Malfunctions							
	C) Pierced Primers							
	D) Optical Clarity of Scope							
645	Inspect for Live Ammo						7/22/94	RW
655	Final Inspection							
	A) Headspace						7/23/94	RW
	B) Trigger Pull	2.79	2.75	2.76	2.77	2.74	7/23/94	RW
	C) Function						7/23/94	RW
660	Pack							

22 Jul 1994

FILE:/PATTERNING/CENTERFIRE_PATT/C8225051

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 2

2in = 4

3in = 8

HS= 3.152

VS= 3.236

GS= 3.282

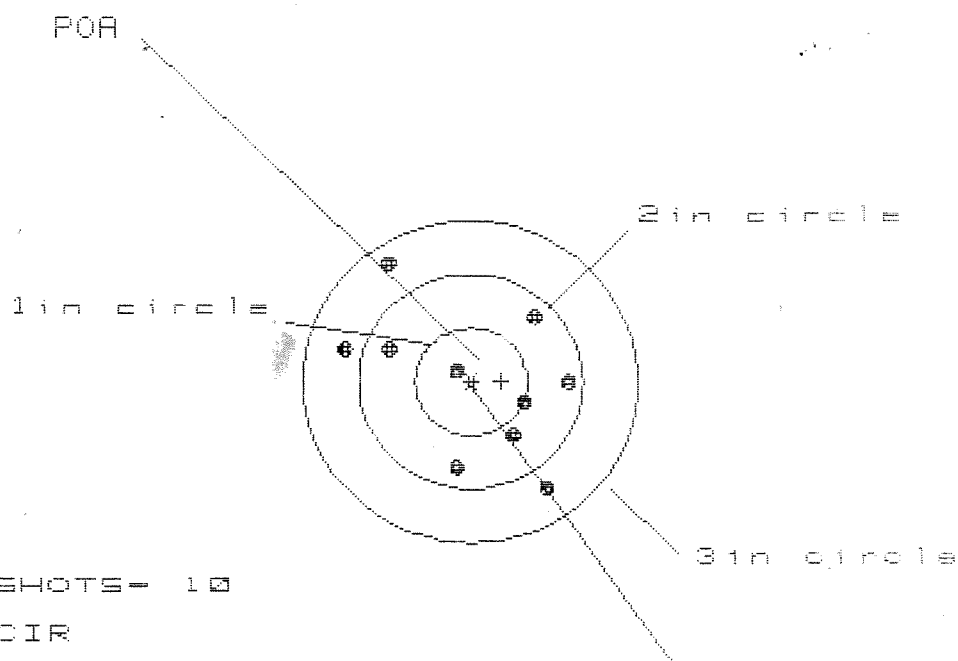
PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.759	1.696	1.252
MINIMUM X	:	-1.393	-1.456	-1.244
MAXIMUM Y	:	1.482	1.287	1.220
MINIMUM Y	:	-1.754	-1.553	-1.620
CENTROID X	:	-.023	.040	-.172
CENTROID Y	:	-.132	.063	.130
POA TO CENTROID in.	:	.134	.074	.216
MIN RADIUS	:	.373	.203	.398
MEAN RADIUS	:	1.115	.993	.903
MAX RADIUS	:	1.843	1.780	1.398
HORIZONTAL SPREAD	:	3.152	3.152	2.496
VERTICAL SPREAD	:	3.236	1.840	1.840
EXTREME SPREAD	:	3.282	3.166	2.524
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	

22 Jul 1994

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CENTERFIRE PATTERNS

2



OF SHOTS= 10

IN CIR

1in = 1

2in = 7

3in = 10

HS= 2.010

VS= 2.024

GS= 2.462

PATTERN #	:	2	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.837	.759	.603
MINIMUM X	:	-1.173	-1.251	-1.008
MAXIMUM Y	:	1.072	.750	.807
MINIMUM Y	:	-.952	-.833	-.776
CENTROID X	:	-.270	-.192	-.036
CENTROID Y	:	-.004	-.123	-.180
POA TO CENTROID in.	:	.270	.228	.184
MIN RADIUS	:	.186	.316	.216
MEAN RADIUS	:	.830	.762	.659
MAX RADIUS	:	1.279	1.331	1.104
HORIZONTAL SPREAD	:	2.010	2.010	1.611
VERTICAL SPREAD	:	2.024	1.583	1.583
EXTREME SPREAD	:	2.462	2.277	1.920
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	7		
NUMBER IN THREE INCH CIRCLE	=	10		

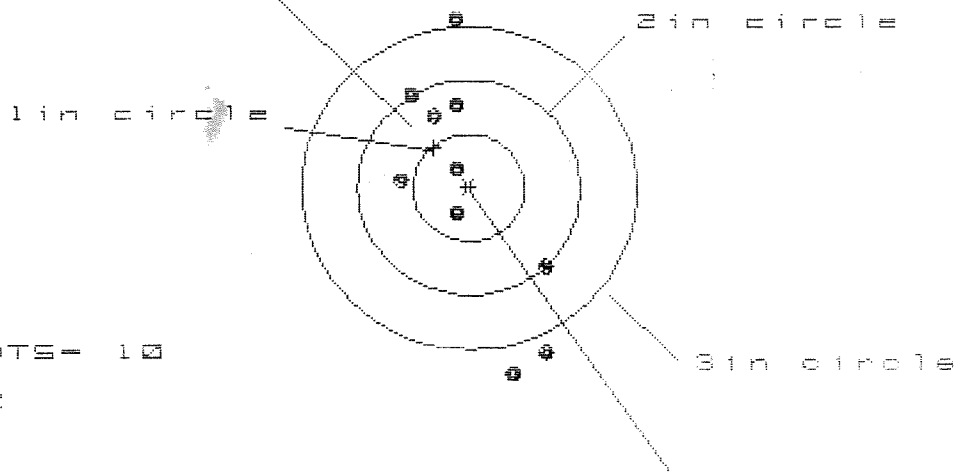
22 Jul 1994

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CENTERFIRE PATTERNS

3

FOR



OF SHOTS = 10

IN CIR

1 in = 2

2 in = 6

3 in = 7

HS = 1.347

VS = 3.287

GS = 3.325

CENTROID *

PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	.728
MINIMUM X	-.619
MAXIMUM Y	1.603
MINIMUM Y	-1.684
CENTROID X	.316
CENTROID Y	-.373
FOR TO CENTROID in.	.489
MIN RADIUS	.220
MEAN RADIUS	.951
MAX RADIUS	1.732
HORIZONTAL SPREAD	1.347
VERTICAL SPREAD	3.287
EXTREME SPREAD	3.325
NUMBER IN ONE INCH CIRCLE =	2
NUMBER IN TWO INCH CIRCLE =	6
NUMBER IN THREE INCH CIRCLE =	7

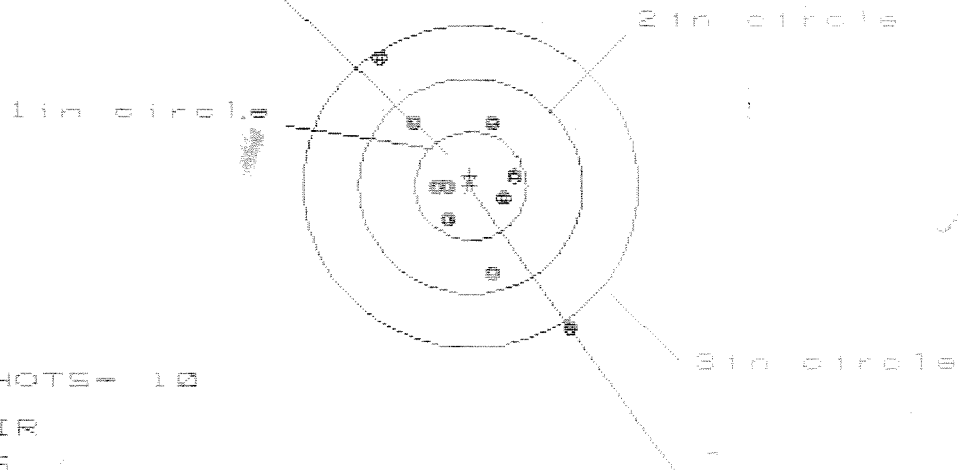
22 Jul 1994

FILE:/PATTERNING/CENTERFIRE_PATT/C8225051

CENTERFIRE PATTERNS

4

POA



OF SHOTS- 10

IN CIR

1in = 5

2in = 8

3in = 9

HS= 1.746

VS= 2.502

GS= 3.051

CENTROID *

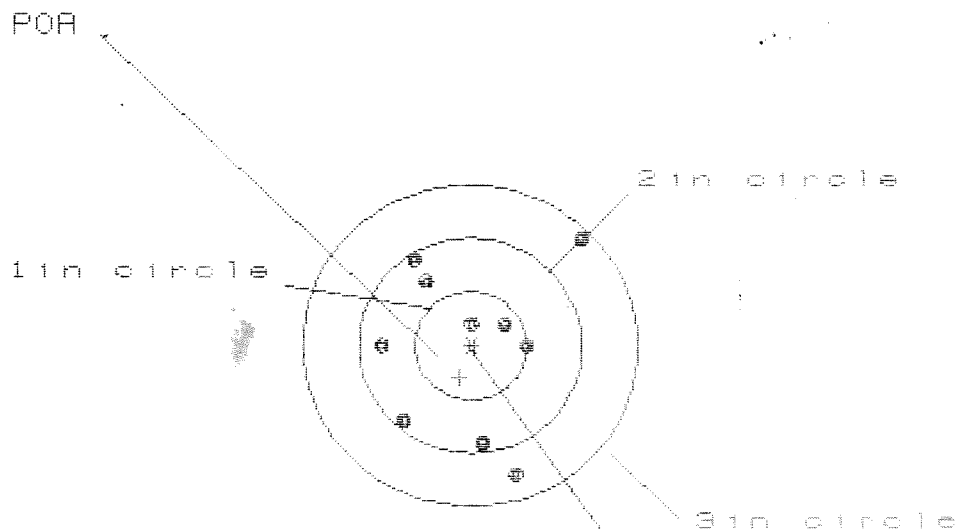
PATTERN #	:	4	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.917	.475	.384
MINIMUM X	:	-.829	-.728	-.459
MAXIMUM Y	:	1.220	1.077	.604
MINIMUM Y	:	-1.282	-.935	-.800
CENTROID X	:	.011	-.091	-.000
CENTROID Y	:	-.092	.050	-.085
POA TO CENTROID in.	:	.093	.104	.085
MIN RADIUS	:	.181	.176	.171
MEAN RADIUS	:	.673	.574	.459
MAX RADIUS	:	1.576	1.300	.835
HORIZONTAL SPREAD	:	1.746	1.203	.843
VERTICAL SPREAD	:	2.502	2.012	1.404
EXTREME SPREAD	:	3.051	2.273	1.513
NUMBER IN ONE INCH CIRCLE	=	5		
NUMBER IN TWO INCH CIRCLE	=	8		
NUMBER IN THREE INCH CIRCLE	=	9		

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CENTERFIRE PATTERNS

5



OF SHOTS- 10

IN CIR

1in = 2

2in = 8

3in = 10

HS= 1.833

VS= 2.182

GS= 2.328

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.026	.654	.714
MINIMUM X	:	-.807	-.693	-.633
MAXIMUM Y	:	1.013	.931	.799
MINIMUM Y	:	-1.169	-1.057	-.930
CENTROID X	:	.102	-.012	-.072
CENTROID Y	:	.298	.186	.318
POA TO CENTROID in.	:	.315	.186	.326
MIN RADIUS	:	.204	.321	.224
MEAN RADIUS	:	.806	.742	.667
MAX RADIUS	:	1.441	1.161	.975
HORIZONTAL SPREAD	:	1.833	1.347	1.347
VERTICAL SPREAD	:	2.182	1.988	1.729
EXTREME SPREAD	:	2.328	2.164	1.833
NUMBER IN ONE INCH CIRCLE =			2	
NUMBER IN TWO INCH CIRCLE =			8	
NUMBER IN THREE INCH CIRCLE =			10	