

G 646 1744

Replaces

C- 6225409

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

R & B NUMBER 156492
SERIAL NUMBER G6461244
LOG-IN DATE 12-10-08

OPERATION #	OPERATION NAME	DATE	INITIAL
500	DIS-ASSEMBLE GUN	12-10-08	RJZ
505	RE-BARREL	12-10-08	RJZ
560	ASSEMBLE	12-10-08	RJZ
600	PROOF	12-15-08	R.P.D.
605	CHECK HEADSPACE	12-15-08	R.P.D.
610	DIS-ASSEMBLE GUN	12-15-08	R.P.D.
612	MAGNAFLUX	12/20/08	(R)
510	DRILL AND TAP	12-16-08	JP
615	ROLLMARK CALIBER	12/20/08	RT
618	ROTO-BLAST	1/5	TZ
620	APPLY COATINGS	1/7	
625	FINAL ASSEMBLY	1-9-09	RJZ
640	FUNCTION TEST AND	1-9-09	R.P.D.
650	TARGET	1-9-09	R.P.D.
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
670	FINAL INSPECTION	1-12-09	R.P.D.
	A) HEADSPACE	1-12-09	R.P.D.
	B) TRIGGER PULL	2.60 2.62 2.56 2.66 2.54	1-12-09 TL
680	F) SAFETY ON FORCE	40 40 40	1-12-09 R.P.D.
	G) SAFETY OFF FORCE	50 50 40	1-12-09 R.P.D.
	I) FIRING PIN INDENT	.023 -.023 .023	1-12-09 R.P.D.
690	PACK	1/12/09	Fm

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6461744. 0

FILE DATE AND TIME: 01/12/2009 08:22

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.143
The Average Y Centroid of the Five Target Set:	-0.148
The Average Point of Impact of the Five Target Set:	0.206
The Average Mean Radius of the Five Target Set:	0.922
The Distance from POA to Centroid Target #1:	0.120
The Distance from Centroid Target #2 to Centroid Target #1:	0.101
The Distance from Centroid Target #3 to Centroid Target #1:	0.678
The Distance from Centroid Target #4 to Centroid Target #1:	0.122
The Distance from Centroid Target #5 to Centroid Target #1:	0.263

SERIAL NUMBER: G6461744. 0

TARGET NUMBER: 1

FILE DATE: 01/12/2009

FILE TIME: 08:22

X CENTROID: 0.103

Y CENTROID: 0.060

POA TO CENTROID: 0.120

HORZ SPREAD: 1.351

VERT SPREAD: 2.201

GROUP SPREAD: 2.454

MIN RADIUS: 0.081

MAX RADIUS: 1.485

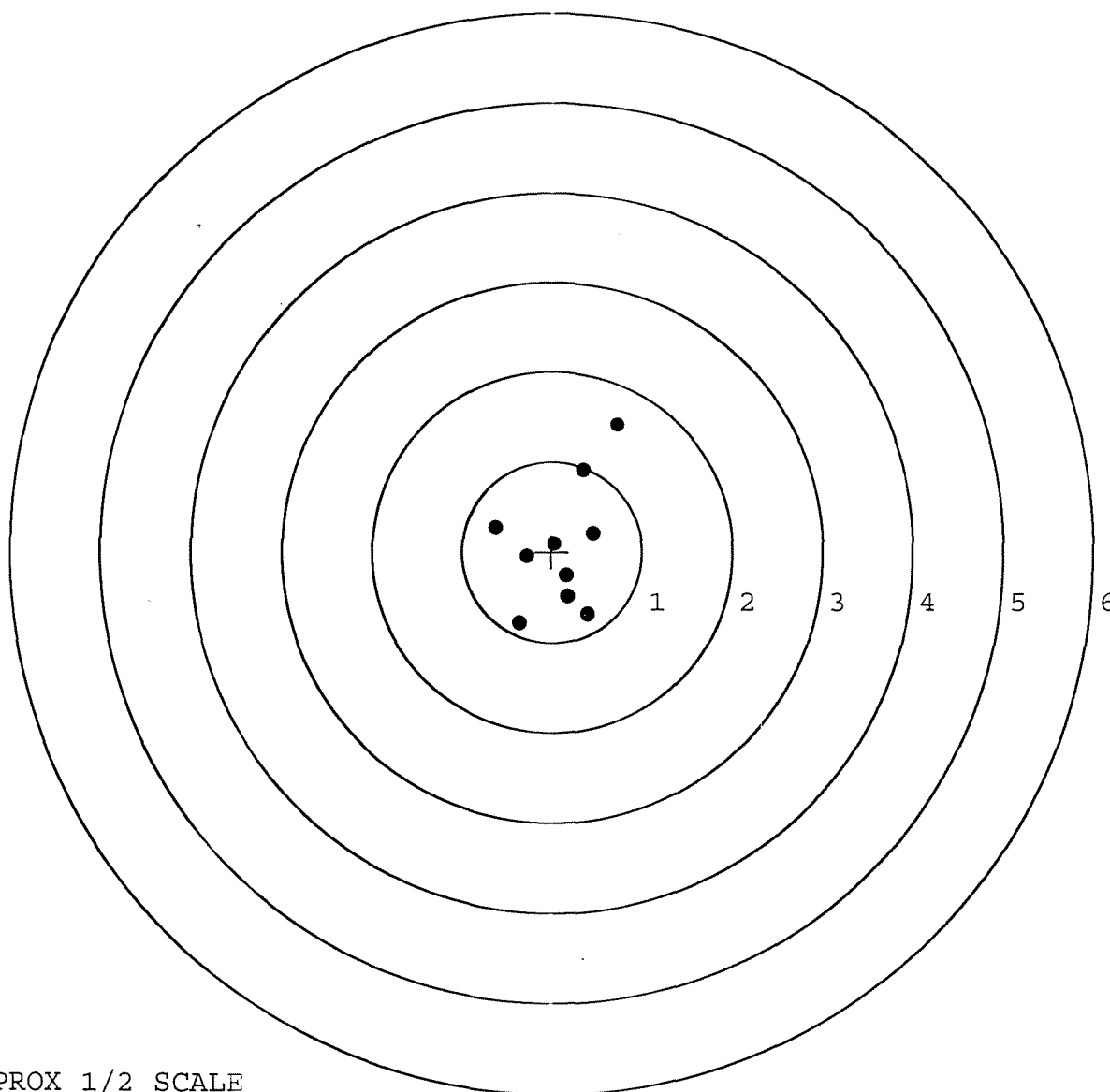
MEAN RADIUS: 0.666

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.724	1.409
2:	0.353	0.908
3:	0.454	0.211
4:	0.029	0.093
5:	-0.279	-0.048
6:	-0.627	0.269
7:	0.164	-0.265
8:	0.179	-0.494
9:	0.398	-0.690
10:	-0.362	-0.792



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461744. 0

TARGET NUMBER: 2

FILE DATE: 01/12/2009

FILE TIME: 08:22

X CENTROID: 0.168

Y CENTROID: -0.017

POA TO CENTROID: 0.169

HORZ SPREAD: 2.198

VERT SPREAD: 1.892

GROUP SPREAD: 2.078

MIN RADIUS: 0.549

MAX RADIUS: 1.273

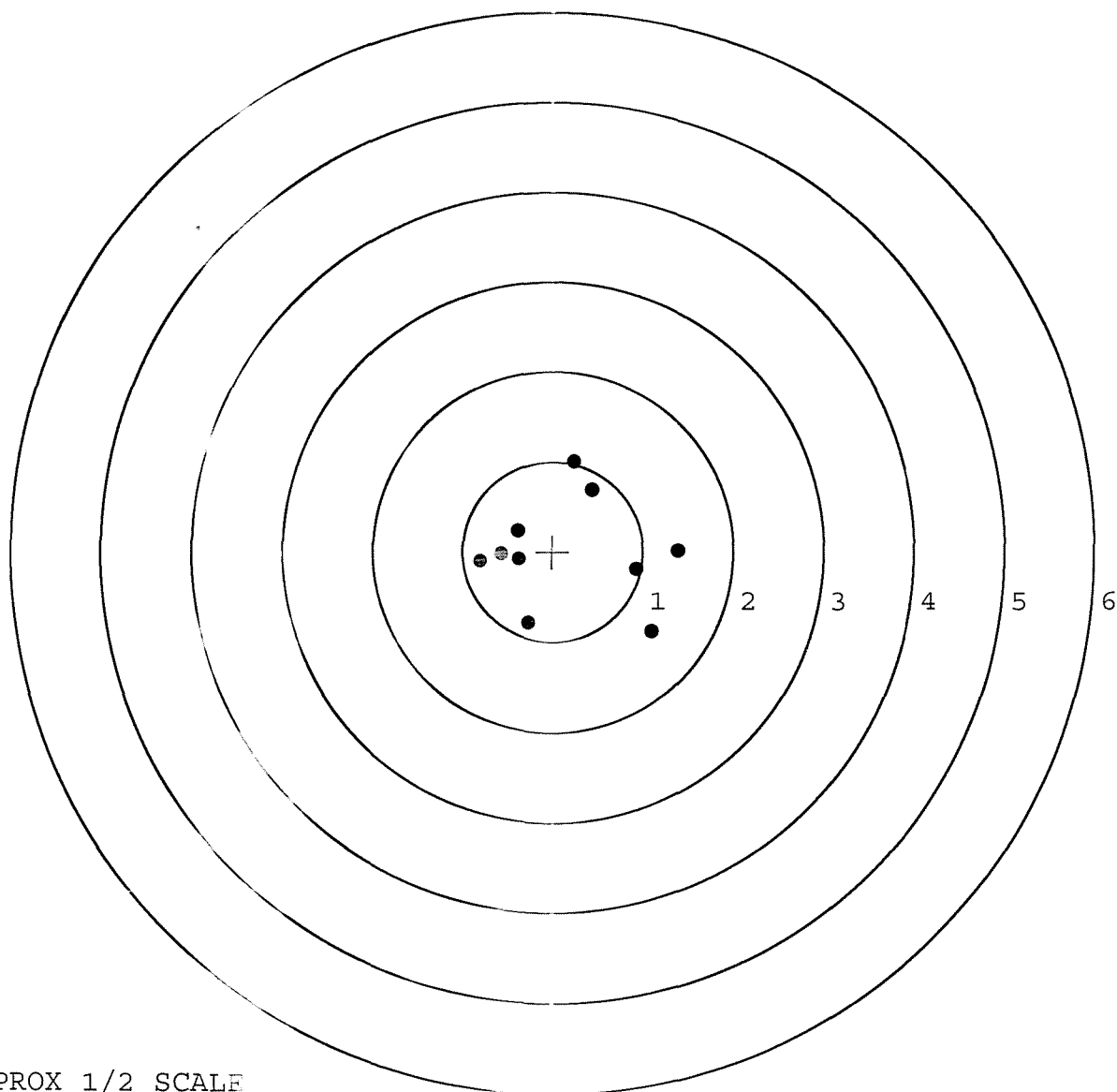
MEAN RADIUS: 0.833

IN 1 IN DIAMETER: 0

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.434	0.691
2:	0.236	1.003
3:	-0.390	0.229
4:	-0.377	-0.086
5:	-0.567	-0.032
6:	-0.806	-0.112
7:	-0.268	-0.800
8:	0.931	-0.195
9:	1.096	-0.889
10:	1.392	0.018



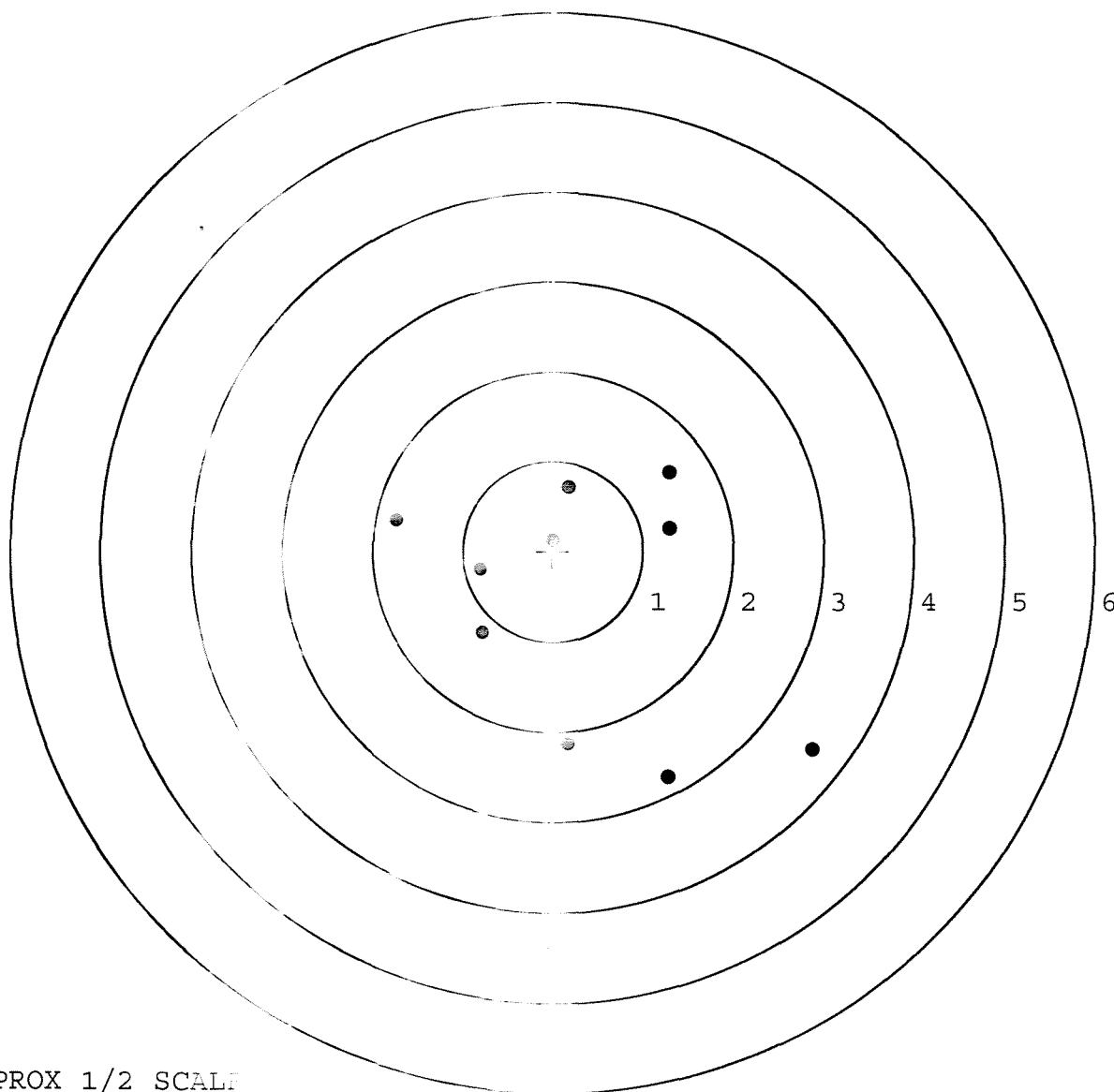
TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461744. 0
TARGET NUMBER: 3
FILE DATE: 01/12/2009
FILE TIME: 08:22

X CENTROID: 0.377
Y CENTROID: -0.561
POA TO CENTROID: 0.675
HORZ SPREAD: 4.616
VERT SPREAD: 3.380
GROUP SPREAD: 5.268
MIN RADIUS: 0.787
MAX RADIUS: 2.934
MEAN RADIUS: 1.047

IN 1 IN DIAMETER: 0
IN 2 IN DIAMETER: 1
in 3 IN DIAMETER: 5

POINT#	X	Y
1:	-1.740	0.349
2:	-0.805	-0.198
3:	-0.784	-0.899
4:	0.005	0.133
5:	0.175	0.712
6:	1.292	0.874
7:	1.292	0.254
8:	0.171	-2.136
9:	1.284	-2.506
10:	2.876	-2.190

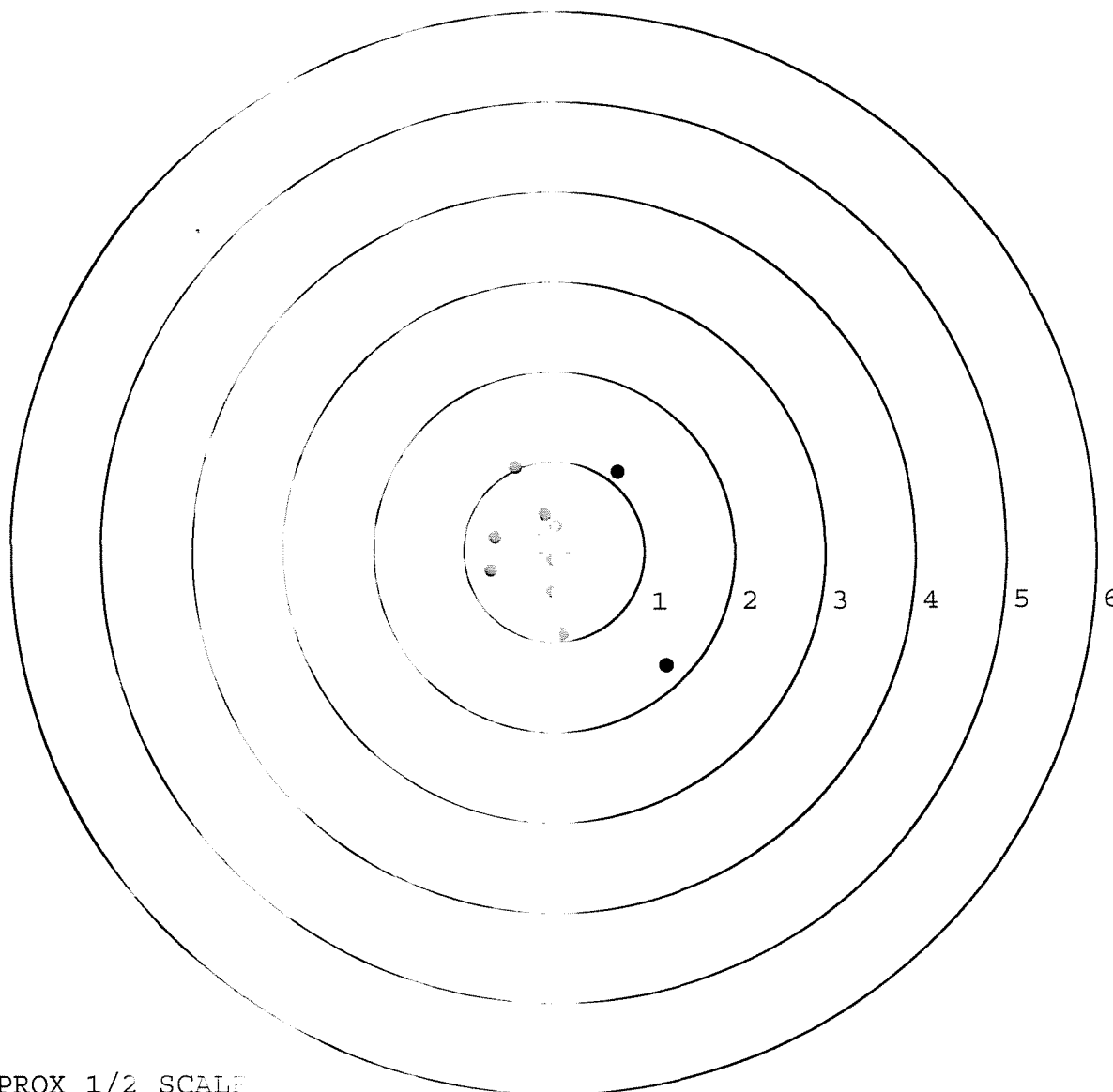


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461744. 0
TARGET NUMBER: 4
FILE DATE: 01/12/2009
FILE TIME: 08:22

POINT#	X	Y
1:	0.709	0.885
2:	-0.425	0.940
3:	-0.100	0.419
4:	0.028	0.291
5:	-0.651	0.164
6:	-0.703	-0.209
7:	-0.015	-0.089
8:	-0.013	-0.450
9:	0.030	-0.919
10:	1.216	-1.268

X CENTROID: 0.015
Y CENTROID: -0.024
POA TO CENTROID: 0.028
HORZ SPREAD: 1.939
VERT SPREAD: 2.208
GROUP SPREAD: 2.763
MIN RADIUS: 0.070
MAX RADIUS: 1.741
MEAN RADIUS: 0.751
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 9

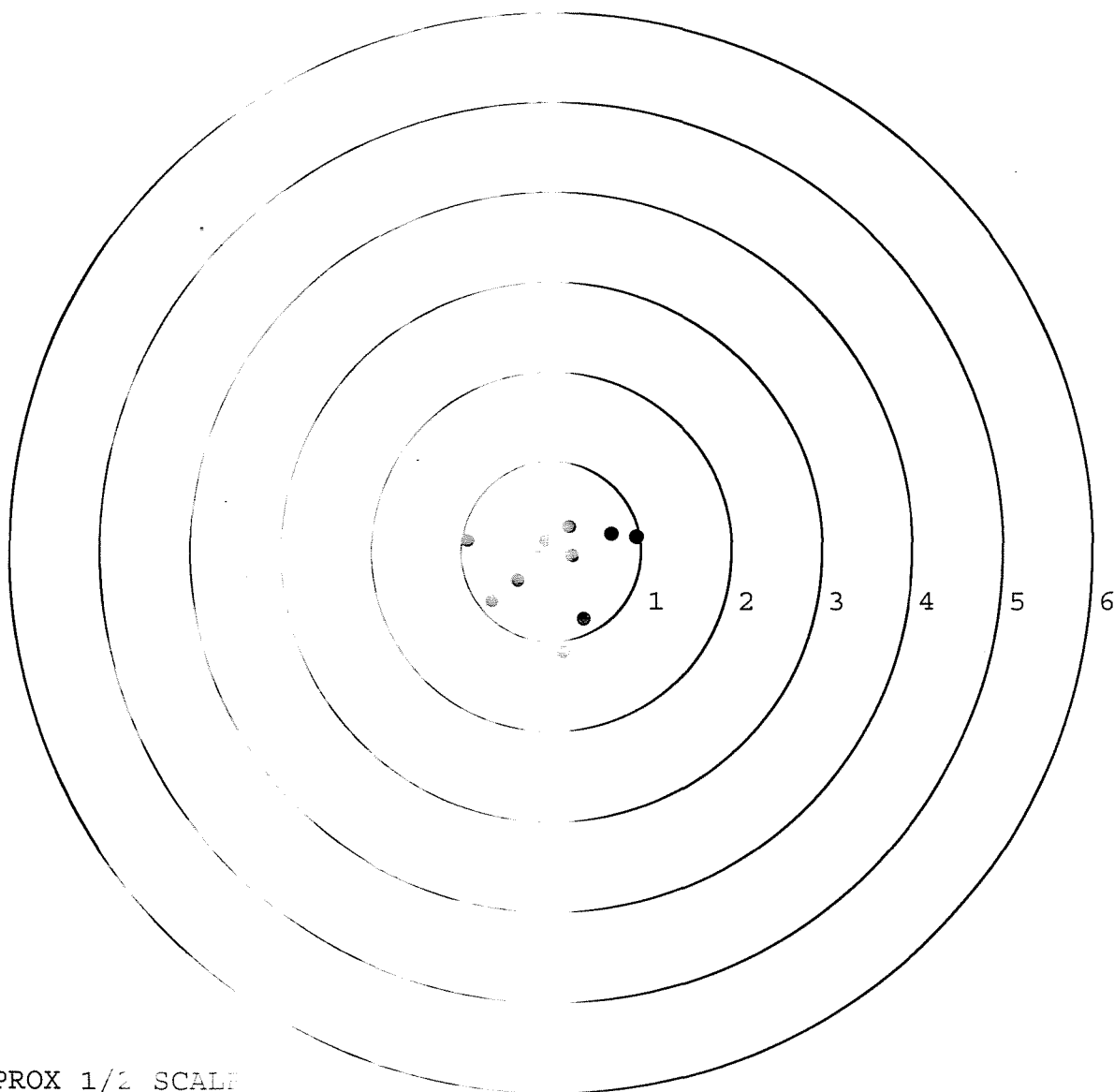


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461744...0
 TARGET NUMBER: 5
 FILE DATE: 01/12/2009
 FILE TIME: 08:22

POINT#	X	Y
1:	0.951	0.158
2:	0.642	0.188
3:	0.155	0.269
4:	0.286	-0.058
5:	-0.063	0.119
6:	-0.173	-0.331
7:	-0.113	0.118
8:	-0.619	-0.556
9:	0.11	-0.756
10:	0.110	-1.125

X CENTROID: 0.051
 Y CENTROID: -0.197
 POA TO CENTROID: 0.204
 HORZ SPREAD: 1.834
 VERT SPREAD: 1.284
 GROUP SPREAD: 1.864
 MIN RADIUS: 0.11
 MAX RADIUS: 1.125
 MEAN RADIUS: 0.11
 # IN 1 IN DIAMETER: 1
 # IN 2 IN DIAMETER: 1
 # in 3 IN DIAMETER: 1



TARGET APPROX 1/2 SCALE

Repair Inquiry

Repair Number: **RE00092204**

Serial: C6225407 Model M24 SWS Center Fire
Caliber 7.62 NATO Produced 03/21/1989

Repairman:

Status: Closed 2/1/2005 7:07:38 AM

Address Information

Customer:

☒ Received From

Return To:

☐ Received From

Name: DEF DIST DEPOT ANNISTON

DEF DIST DEPOT ANNISTON

Address 1:

Address 2:

PO Box:

PO 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
A017	Scope Base	1
A026	Scope	1
A057	Frt and Rear Sgt Base	1

Repair Search

Refresh

Close

nagletj

2/7/2005

12:40 PM

CAPS

NUM

INS

SCRL

start

3

3

Arms Services P...

3

M 3

G6461744 (New)

Serial Number: **C6225407**

Model: M24 SWS



RE00092204

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6461744.___0
FILE DATE AND TIME: 08/11/2005 08:13

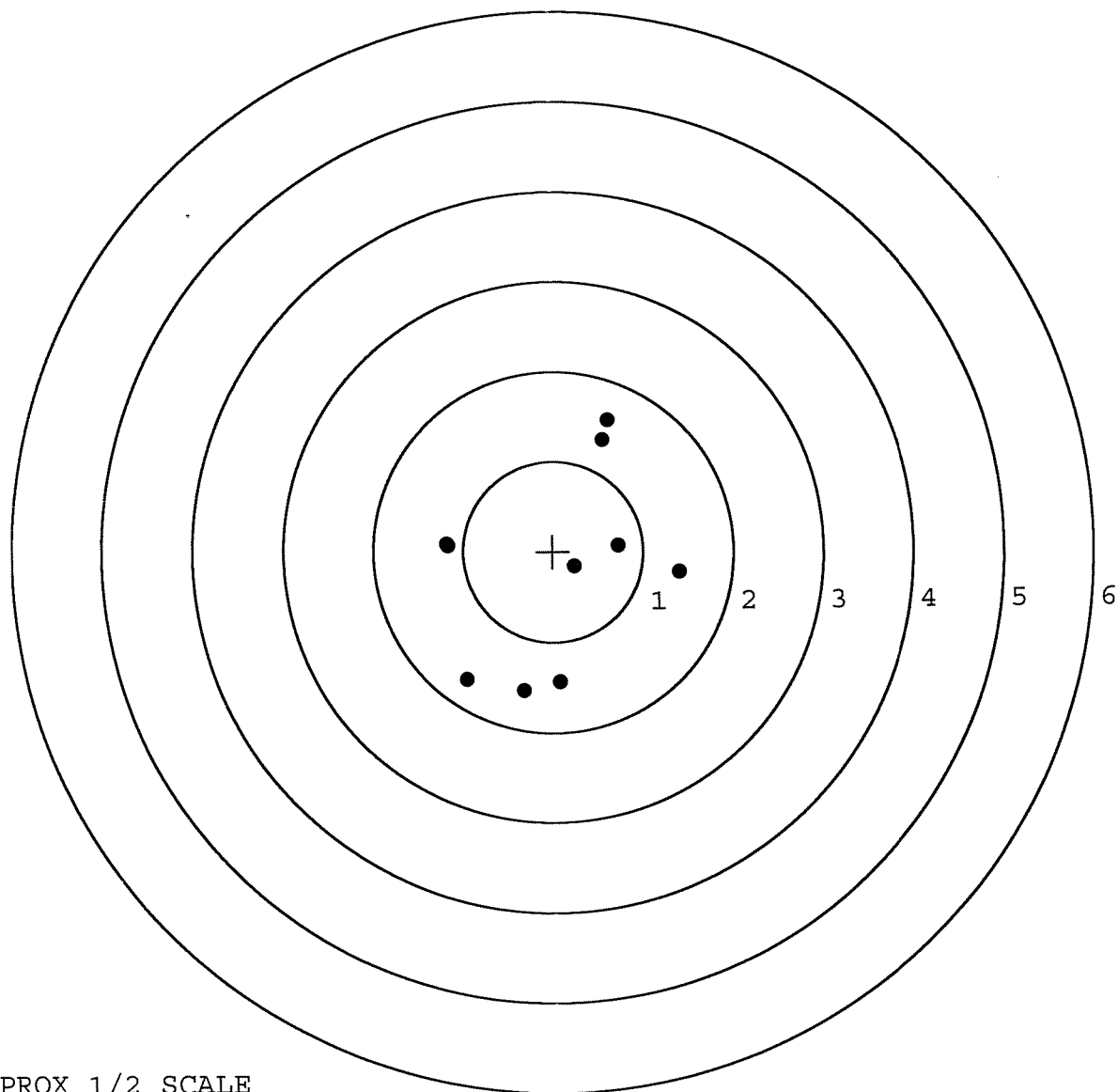
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.065
The Average Y Centroid of the Five Target Set:	-0.025
The Average Point of Impact of the Five Target Set:	0.070
The Average Mean Radius of the Five Target Set:	0.964
The Distance from POA to Centroid Target #1:	0.188
The Distance from Centroid Target #2 to Centroid Target #1:	0.483
The Distance from Centroid Target #3 to Centroid Target #1:	0.075
The Distance from Centroid Target #4 to Centroid Target #1:	0.246
The Distance from Centroid Target #5 to Centroid Target #1:	0.223

SERIAL NUMBER: G6461744. __0
TARGET NUMBER: 1
FILE DATE: 08/11/2005
FILE TIME: 08:13

X CENTROID: -0.006
Y CENTROID: -0.188
POA TO CENTROID: 0.188
HORZ SPREAD: 2.585
VERT SPREAD: 2.995
GROUP SPREAD: 3.277
MIN RADIUS: 0.242
MAX RADIUS: 1.761
MEAN RADIUS: 1.232
IN 1 IN DIAMETER: 1
IN 2 IN DIAMETER: 2
in 3 IN DIAMETER: 7

POINT#	X	Y
1:	0.620	1.458
2:	0.556	1.234
3:	-1.168	0.071
4:	0.235	-0.169
5:	0.723	0.061
6:	1.399	-0.237
7:	-0.339	-1.537
8:	0.070	-1.446
9:	-0.969	-1.408
10:	-1.186	0.092

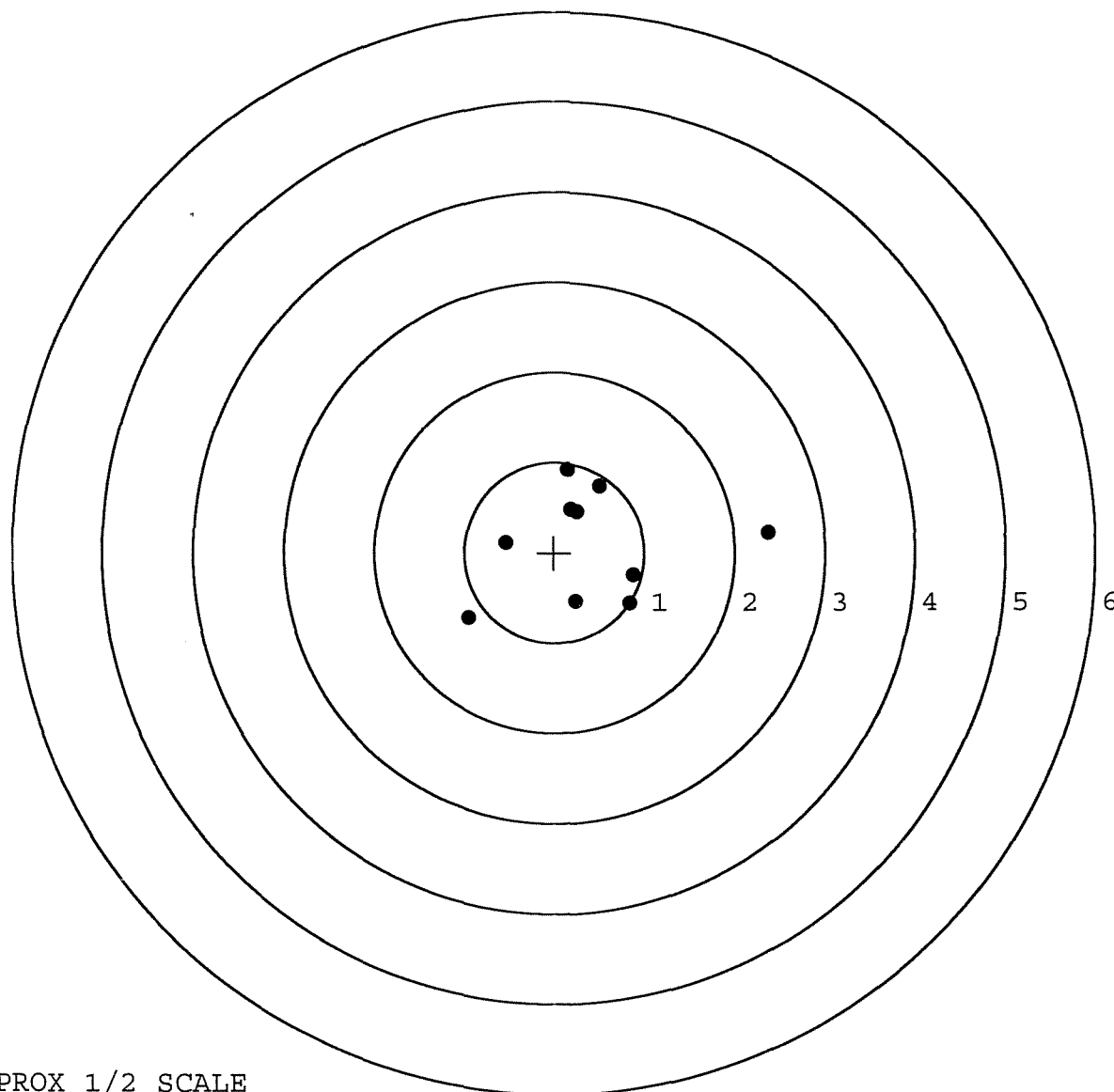


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461744. __0
TARGET NUMBER: 2
FILE DATE: 08/11/2005
FILE TIME: 08:13

X CENTROID: 0.391
Y CENTROID: 0.086
POA TO CENTROID: 0.400
HORZ SPREAD: 3.324
VERT SPREAD: 1.641
GROUP SPREAD: 3.456
MIN RADIUS: 0.397
MAX RADIUS: 1.983
MEAN RADIUS: 0.888
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 8

POINT#	X	Y
1:	0.152	0.920
2:	-0.537	0.116
3:	-0.955	-0.721
4:	0.502	0.737
5:	0.184	0.485
6:	0.248	0.456
7:	0.234	-0.545
8:	0.878	-0.251
9:	0.836	-0.561
10:	2.369	0.226

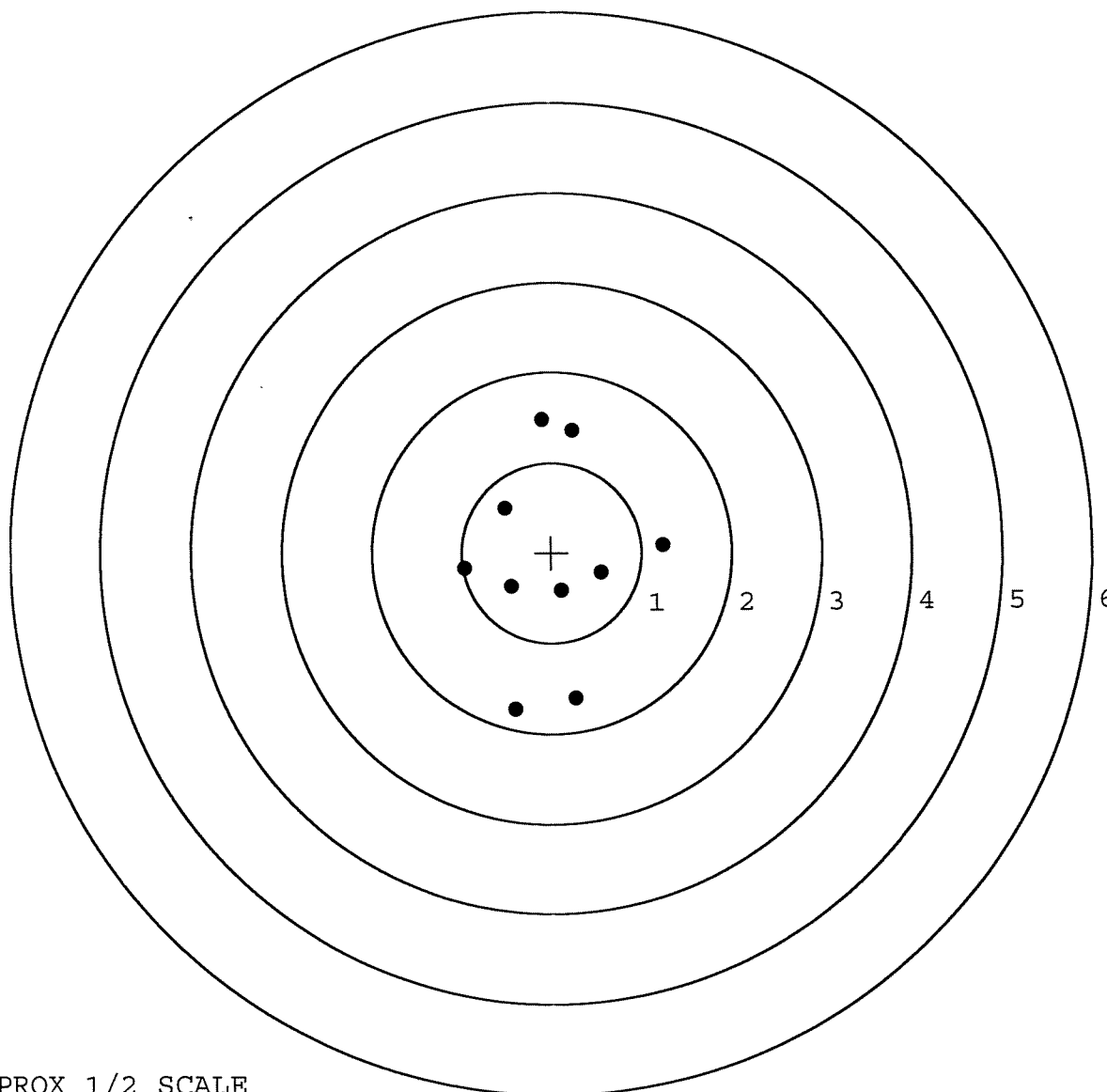


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461744. __0
TARGET NUMBER: 3
FILE DATE: 08/11/2005
FILE TIME: 08:13

X CENTROID: -0.005
Y CENTROID: -0.113
POA TO CENTROID: 0.114
HORZ SPREAD: 2.211
VERT SPREAD: 3.214
GROUP SPREAD: 3.228
MIN RADIUS: 0.334
MAX RADIUS: 1.670
MEAN RADIUS: 1.072
IN 1 IN DIAMETER: 1
IN 2 IN DIAMETER: 5
in 3 IN DIAMETER: 7

POINT#	X	Y
1:	1.238	0.086
2:	0.553	-0.224
3:	0.112	-0.426
4:	-0.448	-0.374
5:	-0.973	-0.174
6:	-0.517	0.494
7:	-0.105	1.480
8:	0.236	1.356
9:	0.261	-1.618
10:	-0.410	-1.734

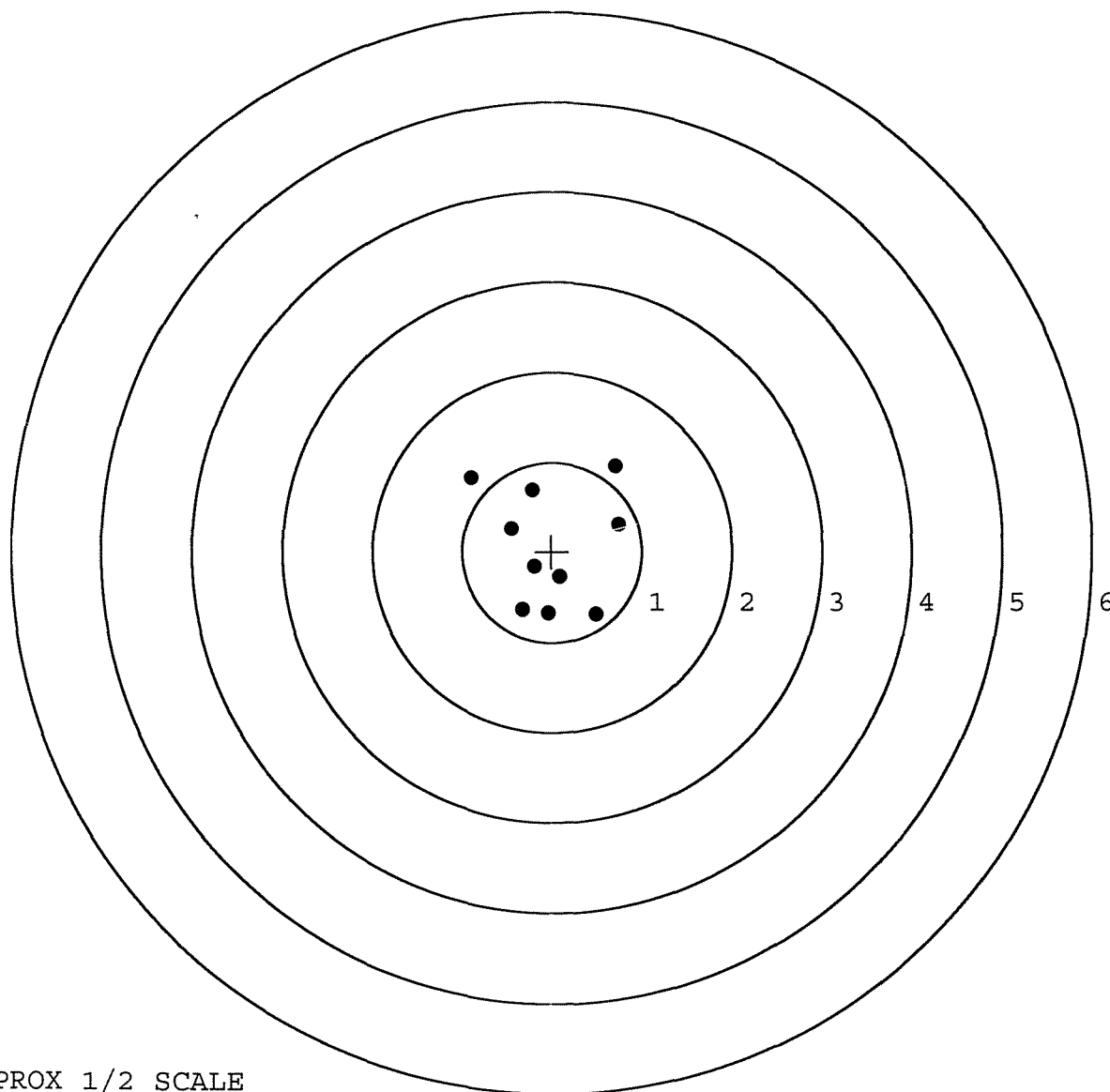


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461744. __0
TARGET NUMBER: 4
FILE DATE: 08/11/2005
FILE TIME: 08:13

X CENTROID: -0.013
Y CENTROID: 0.058
POA TO CENTROID: 0.059
HORZ SPREAD: 1.638
VERT SPREAD: 1.654
GROUP SPREAD: 2.062
MIN RADIUS: 0.292
MAX RADIUS: 1.176
MEAN RADIUS: 0.733
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.194	-0.171
2:	0.087	-0.284
3:	-0.330	-0.646
4:	-0.045	-0.680
5:	0.492	-0.692
6:	0.738	0.307
7:	0.701	0.962
8:	-0.220	0.692
9:	-0.900	0.829
10:	-0.456	0.259

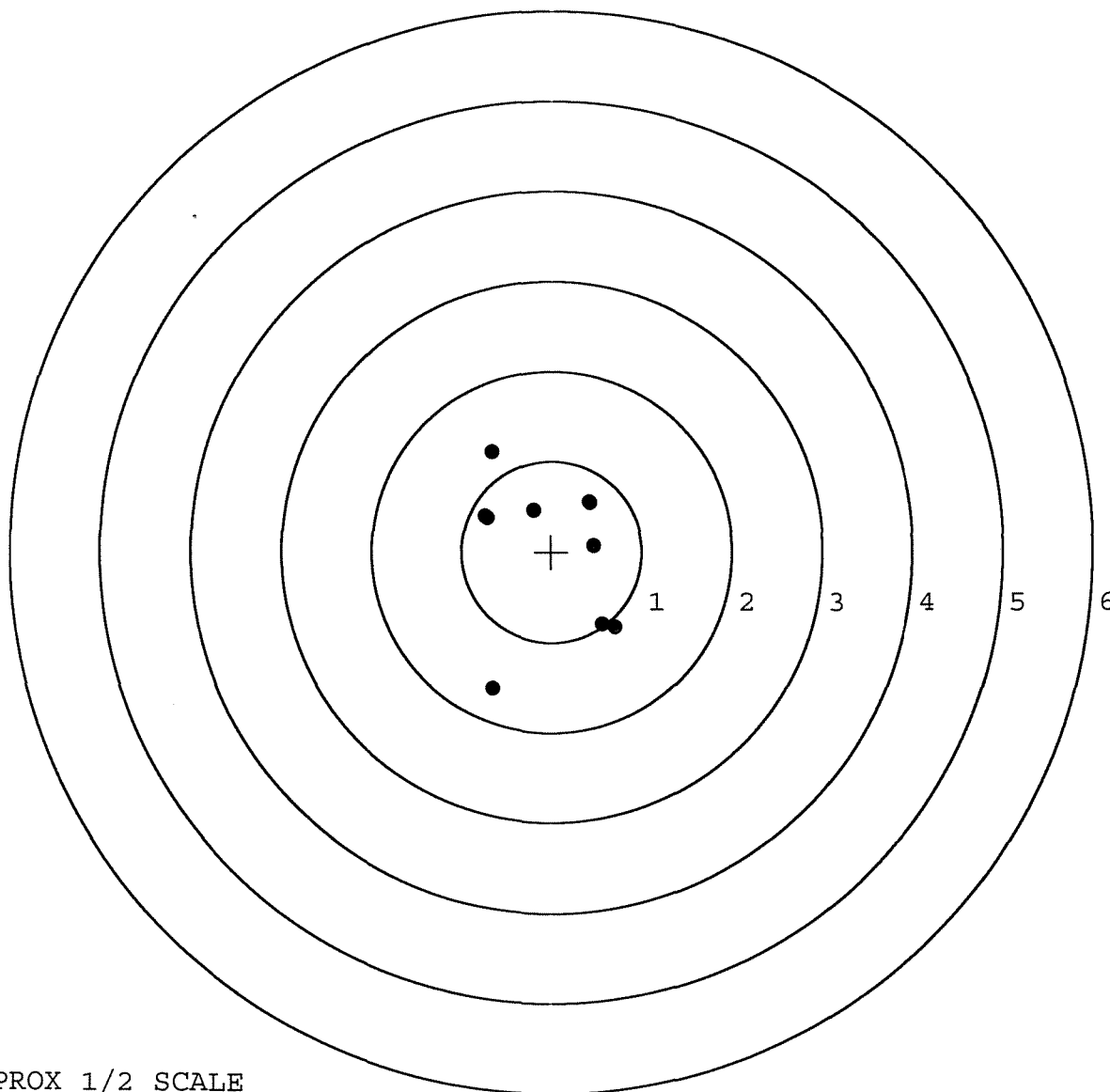


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461744. __0
TARGET NUMBER: 5
FILE DATE: 08/11/2005
FILE TIME: 08:13

X CENTROID: -0.040
Y CENTROID: 0.032
POA TO CENTROID: 0.051
HORZ SPREAD: 1.444
VERT SPREAD: 2.611
GROUP SPREAD: 2.611
MIN RADIUS: 0.453
MAX RADIUS: 1.664
MEAN RADIUS: 0.896
IN 1 IN DIAMETER: 1
IN 2 IN DIAMETER: 6
in 3 IN DIAMETER: 9

POINT#	X	Y
1:	-0.718	0.372
2:	-0.661	1.094
3:	-0.743	0.388
4:	-0.205	0.454
5:	0.421	0.546
6:	0.416	0.552
7:	0.472	0.068
8:	0.701	-0.836
9:	-0.648	-1.517
10:	0.562	-0.803



TARGET APPROX 1/2 SCALE

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

R & E NUMBER	92204		
SERIAL NUMBER	C6225407	C6461744	New
LOG-IN DATE	2-1-05		
INSPECT AND VERIFY:			
OPERATION #	OPERATION NAME	DATE	INITIAL
550	DIS-ASSEMBLE GUN	6-14-05	RTL
560 A	RE-BARREL	6-20-05	RTL
B	DRILL AND TAP	6-22-05	TRW
575	ASSEMBLE	6-20-05	RTL
600	PROOF	6-22-05	Ac
605	CHECK HEADSPACE	6-22-05	Ac
610	DIS-ASSEMBLE GUN	6-22-05	RTL
612	MAGNAFLUX	6/23/05	WWS
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	RTL
B	TRIGGER PULL TEST		
C	SAFETY "ON" FORCE	8-17-05	Ac
D	SAFETY "OFF" FORCE	8-17-05	Ac
E	FIRING PIN INDENT	8-17-05	Ac
640	TARGET	8-11-05	Ac
655	FINAL INSPECT	8-17-05	Ac
660	PACK	9-19-05	RA
		SHIP DATE	
		QAR INSPECTION DATE	

RECEIVING AND ESTIMATING REPORT

R 95-22316

INITIAL	CUSTOMER ORDER NO.	M-24 W/ULTRA 10X X M3A SCOPE ATTN: FRED MARTIN			
FPS					
DATE RECEIVED	DATE OPENED	DATE CODE	SERIAL NUMBER	NEW SERIAL NUMBER	MODEL AND GRADE
09/08/95	09/12/95	BJ 1-89	C6225407		700 7.62 NATO
ACCESSORIES	W/STUDS	SCOPE MNTS	SCOPE BASE		

FROM:

SHIP TO:

DEPT OF THE ARMY-COMMANDER
~~HHC~~ 82ND ABN DIV-ARMS RM.
HHC 1/325 A.T.R.
FT BRAGG

NC 28307

DEPT OF THE ARMY-COMMANDER
HHC 82ND ABN DIV-ARMS RM.
HHC 1/325 A.T.R.
FT BRAGG

NC

28307

CUST NO: 028948 C.O.D.

ACCOUNT NUMBER	ACCOUNT NUMBER N/C	WRITE ☐	PROM. DATE	ESTIMATED	VIA
					UPS
GUN CONDITION					REPAIR CHARGE
☐ NEW					EXCISE
☐ LIGHTLY WORN					TAX
☐ WORN					INSURANCE
☐ VERY WORN					UPS
☐ UNREPAIRABLE					PARCEL POST
☐ MARRED					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

Butt Plate Broken on Stock
MAX Heaper

PARTS	COMMENTS					
Bolt Assy	96005	Repair Butt plate on Stock				
W52H095262H246		REPAIRMAN	PROOF	CLEAN	TEST	TARGET
		RW	✓	✓	✓	
		GALLERY TESTER	DATE	DATE	DATE	DATE
		RW	9/15/95	9/15/95	9/15/95	

OFFICE COPY

RD6925 REV. 1/94

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER

M2400155623

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

COMMANDER
DEPARTMENT OF THE ARMY

82D ABN DIV (ATTN: ARMS RM.)

HHC 1/325th A.I.R.

FORT BRAGG, N.C. 28307-5700

OFFICIAL BUSINESS

REMINGTON ARMS CO. INC.

ATTN: FABRICATED PRODUCTS DEPT.

14 HOEFLEN AVENUE

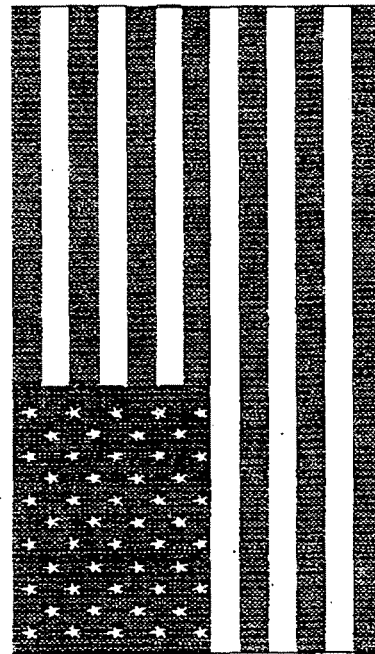
ILION, NY. 13357-1816

82d Airborne Division Materiel

Management Center

Round count is 645
nmc fault reads "adjustable
buttstock broke"

- TO: REMINGTON Arms
- FOR: FRED MARTIN
- FROM: CPT JOHNSON 910-432-7924
- THIS TRANSMISSION
CONSISTS OF PAGE(S),
• NOT INCLUDING
COVERSHEET.



FAX #432-6432 Voice #432-3138
FAX COVERSHEET

09/12/95 16:21 918 432 6432

DMNC 82D ABN DIV

002

FROM: KONICA FAX

915 432 6432

OCT 28, 1995 5:05PM F-12

WEAPON RECORD DATA

For use of this form, see DA PAMs 738-750 and 738-751, the proponent Agency & DSC, DG

REQUIREMENT CONTROL SYMBOL
CSGLD-1634

1. TUBE SERIAL NO. 6225407	2. CANNON TYPE, MODEL OR SERIES M-24 SWS	3. ORGANIZATION (HIC) HHC 1-325 AIR	4. SPECIAL LIFE DATA 10,000 rds
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5. END ITEM IDENTIFICATION

6. RDS/EFC COMPUTATION

7. CANNON SERIAL NO.

8. RETUBINGS

9. REBUSHINGS

Date	Projectile Type	Zone of Charge	Rounds Fired	EFC RDS Fired	Cumulative RDS Fired	Cumulative EFC RDS	Remaining Life (EFC RDS)	Remarks: Recoil Exercise (RE), Charge or Velocity Reading, Safety Inspection (SI)	Signature
a	b	c	d	e	f	g	h		i

*Per DA Form 210N-4 final status.

Nov 94	M-118		160		160		9840		
Dec 94	M-118		140		290		9700		
Mar 95	M-118		80		370		9620		
May 95	M-118		150		520		9470		
Jun 95	M-118		125		645		9345		

John H. Hill

CONTINUE ON REVERSE

DA FORM 2408-4

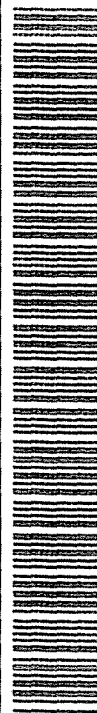
EDITION OF 1 DEC 77 WILL BE USED

[illegible]

DA FORM 2404
1 APR 79

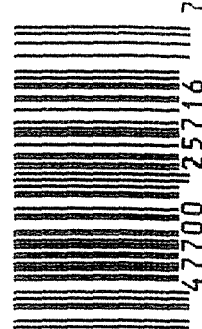
Replaces edition of 1 Jan 64, which will be used

Remington®		VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.	
MODEL 700™ H24		SERIAL NO. 06225407	
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat & Tm. Off. Marca Registrada Marque Deposee.		ORDER NO. 5716	



5716 06225407

UPC



0

47700 25716

7

RECEIVING AND ESTIMATING REPORT

R 94-09533

INITIAL
FPS

CUSTOMER ORDER NO.

ATTN: FRED MARTIN W/ULTRA 10X-M3A SCOPE
M-24

DATE RECEIVED	DATE OPENED	DATE CODE	SERIAL NUMBER	NEW SERIAL NUMBER	MODEL AND GRADE
03/14/94	03/15/94	BJ 1-89	C6225407		700 7.62 NATO
ACCESSORIES SCOPE MNTS SCOPE BASE W/STUDS					

FROM:

DEPT. OF THE ARMY
CDR 82ND ABN DIV
HHC 1-325 AFR/UNIT ARMS ROOM
FORT BRAGG NC 28307

SHIP TO:

DEPT. OF THE ARMY
CDR 82ND ABN DIV
HHC 1-325 AFR/UNIT ARMS ROOM
FORT BRAGG NC 28307

CUST NO: 094133 C.D.D.L

ACCOUNT NUMBER	ACCOUNT NUMBER N/C	WRITE	PROM. DATE	ESTIMATED	VIA
		☐			R760136651

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

mag screw missing, Bolt Release Spring Broken, Crown
Buried, Bolt pitted, Adj Butistock loose, Barrel Nicked
Crosshairs are Canted 1/4 Right.

PARTS

COMMENTS

Re-powder Coat Barrel & Bolt
Assy & Floor plate, Latch, Trigger
Guard, Front & Rear Sight Bases
Re-zinc, Scope Base, Scope Rings &
Swivel Studs.
Replace mag screw, Bolt Release
Spring.
Crown OK, Butistock OK, Crosshairs
OK.

REPAIRMAN	PROOF	CLEAN	TEST	TARGET	PATTERN
Rw			☒		
GALLERY TESTER	DATE	DATE	DATE	DATE	DATE
Rw			4/18/94		

OFFICE COPY

RD6925 REV. 1/94

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER

M2400155630

[illegible]

[illegible]

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

DEPARTMENT OF THE ARMY
CDR, 82nd Abn Div
HHC V325 AIR
Attn: Arms-Room
Fort Bragg, NC. 28307-
5100
OFFICIAL BUSINESS

REGISTERED MAIL

R 760 136 651

Remington Arms Company
Attn: Fabricated Products Dept.
14 Hoefler Avenue
Ilion, NY. 13357-1816

GUN SERIAL #

C6225407

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	12 9 88		RW
600	Proof	12 9 88		RW
607	Check Headspace	12 9 88		RW
610	Dis-assemble Gun	12 9 88		RW
612	Magnaflux Barrel Action		12-22-88	RK.
	Magnaflux Bolt		1-3-89	RK.
615	Rollmark Caliber		12-22-88	MBC
617	Drill and Tap Sight Holes	1 3 89		FB
618	Polish Barrel	12 2 88		WJK
620	Apply Coatings (Barrel Action)		1-16-89	TJA
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		1/25/89	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		1/25/89	RW
	C) Inspect Ejector Hole for Chamfer		1/25/89	RW
	D) Oil Firing Pin Ass'y		1/25/89	RW
	E) Adjust Trigger Pull to Min Setting and Stake		25 Jan 89	ES

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			30 Jun 89	JSJ
	G) Safety Off Force	3	3	3			30 Jun 89	JSJ
	H) Trigger Pull Test & Retainability						25 Jun 89	JSJ
	I) Firing Pin Indent	.0205	.021	.0205			30 Jun 89	JSJ
	J) Assemble Stock						2/3/89	RW
	K) Assemble Swivel Studs						8 Jul 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 Jul 89	JSJ
640	Gallery Target & Test	65 R	88 L				2/7/89	AC
	A) Time						"	AC
	B) Malfunctions				NONE		"	AC
	C) Pierced Primers				NONE		"	AC
	D) Optical Clarity of Scope				OK		2/7/89	AC
645	Inspect for Live Ammo				NONE		2/7/89	AC
655	Final Inspection							
	A) Headspace						8 Jul 89	JSJ
	B) Trigger Pull	2.42	2.46	2.42	2.40	2.41	8 Jul 89	JSJ
	C) Function						8 Jul 89	JSJ
660	Pack						27 Mar 89	JSJ

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#
3.00# ± .75#
4.00# ± 1.00#

SERIAL NO. 06349162

DATE 11-3-89

TESTER JLL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.39	2.36	2.29	267	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.12	2.32	1.95	281	
PULL #3	2.59	2.42	2.06	278	
PULL #4	2.23	2.31	2.00	280	
PULL #5	2.43	2.29	2.44	271	
TOTAL	11.76	11.70	11.74	1377	
AVG.	2.352	2.34	2.348	2.754	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.19	3.30		
PULL #2	3.38	3.41		
PULL #3	3.16	3.23		
PULL #4	3.16	3.20		
PULL #5	3.20	3.20		
TOTAL	16.09	16.34		
AVG.	3.218	3.268		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.19	4.20		4.07
PULL #2	4.28	4.27		4.30
PULL #3	4.26	4.30		4.27
PULL #4	4.29	4.26		4.30
PULL #5	4.28	4.30		4.20
TOTAL	21.30	21.33		21.14
AVG.	4.26	4.266		4.228

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6225407
10 Feb 1989

CENTROIDAL DISTANCES

0 TO	1	.621631
1 TO	2	.588933
1 TO	3	1.04901
1 TO	4	.20025
1 TO	5	.570636

3
2.5
1

<----PDR

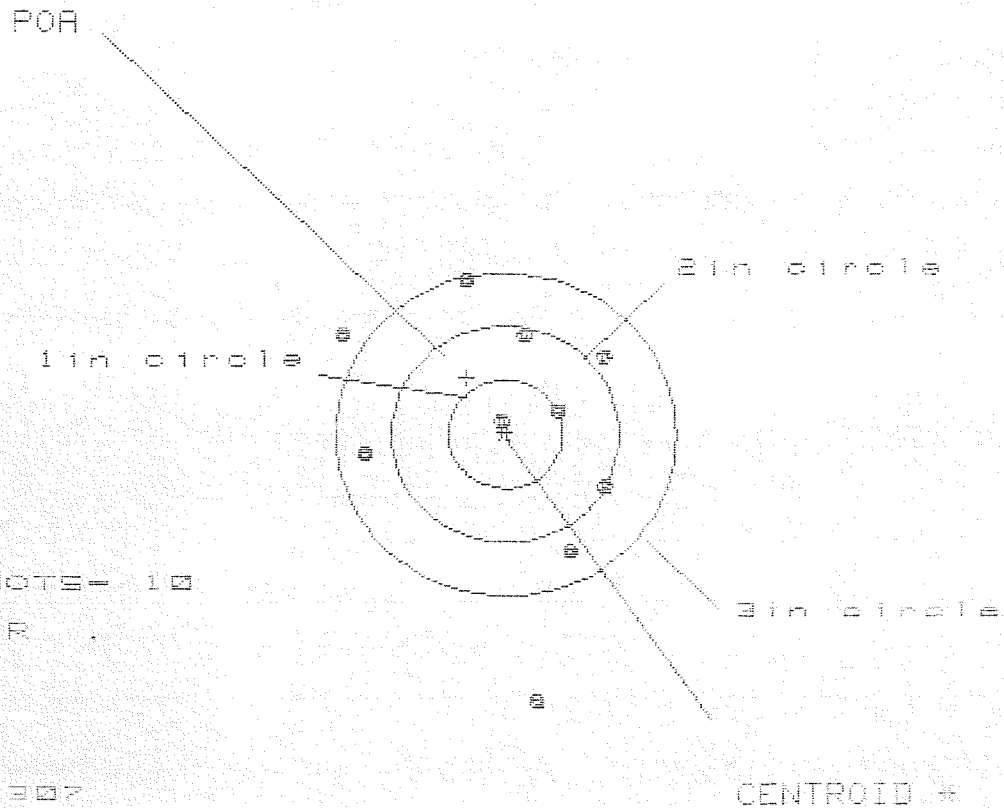
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1712
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1342
THE RESULTING AVERAGE PDI RADIUS FOR THIS RIFLE IS: .217529
THE AMP FOR THIS RIFLE IS: 1.031

10 Feb 1989

FILE:/PATTERNING/CENTERFIRE_PATT/00225407

CENTERFIRE PATTERNS

1



OF SHOTS= 10

IN CIR .

1 in = 1

2 in = 4

3 in = 8

HS= 2.307

VS= 3.899

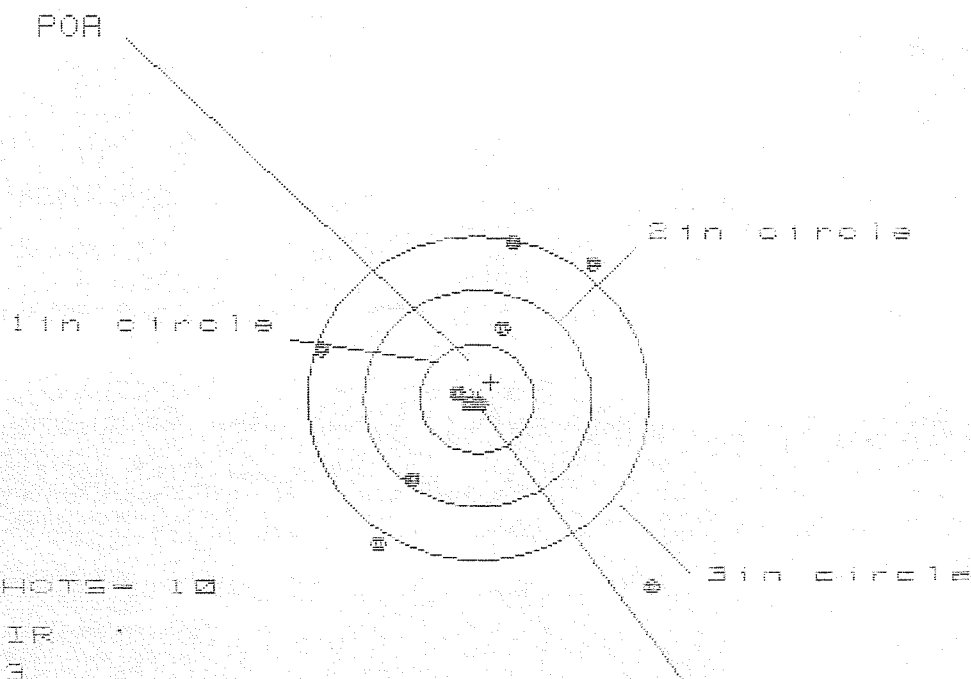
GS= 3.954

PATTERN #	1	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.838	.872	.693
MINIMUM X	-1.469	-1.435	-1.399
MAXIMUM Y	1.388	1.109	1.186
MINIMUM Y	-2.511	-1.401	-1.324
CENTROID X	.336	.302	.481
CENTROID Y	-.523	-.244	-.321
POA TO CENTROID in.	.621	.388	.578
MIN RADIUS	.147	.138	.197
MEAN RADIUS	1.187	.996	.899
MAX RADIUS	2.529	1.561	1.462
HORIZONTAL SPREAD	2.307	2.307	2.092
VERTICAL SPREAD	3.899	2.510	2.510
EXTREME SPREAD	3.954	2.829	2.655
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	8		

18 Feb 1989

FILE:/PATTERNING/CENTERFIRE_PATT/06225407

CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1 in = 3

2 in = 5

3 in = 7

HS = 2.945

VS = 3.178

GS = 3.672

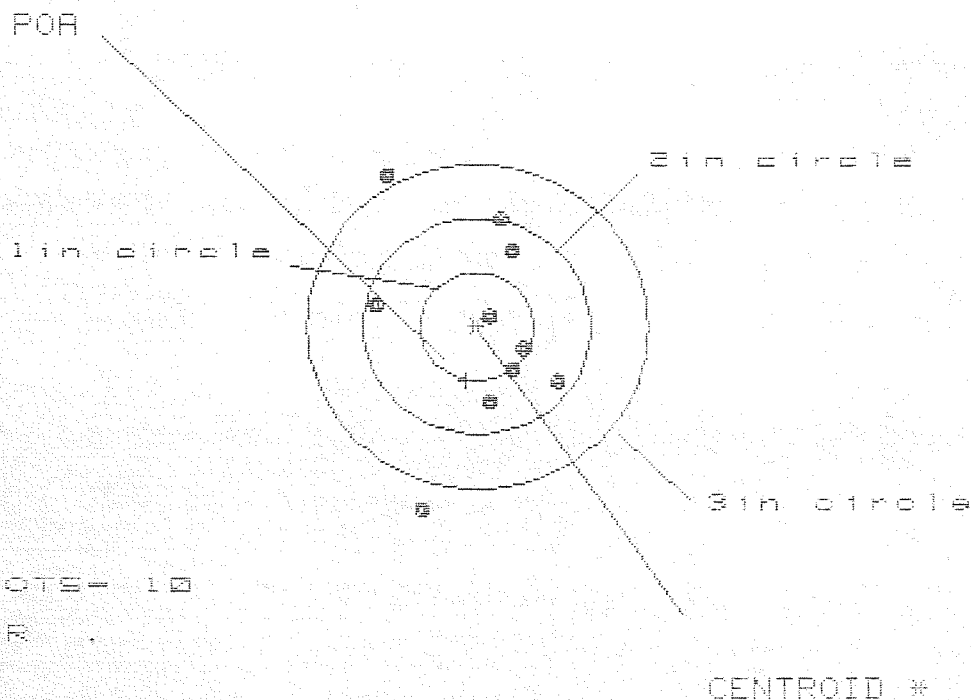
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.535	1.162	1.075
MINIMUM X	:	-1.410	-1.240	-1.327
MAXIMUM Y	:	1.433	1.239	1.043
MINIMUM Y	:	-1.745	-1.567	-1.125
CENTROID X	:	-.123	-.293	-.206
CENTROID Y	:	-.154	.040	.235
POA TO CENTROID in.	:	.197	.296	.313
MIN RADIUS	:	.072	.106	.317
MEAN RADIUS	:	1.049	.910	.831
MAX RADIUS	:	2.324	1.715	1.381
HORIZONTAL SPREAD	:	2.945	2.402	2.402
VERTICAL SPREAD	:	3.178	2.806	2.168
EXTREME SPREAD	:	3.672	3.221	2.539
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		7	

10 Feb 1995

FILE:/PATTERNING/CENTERFIRE_PATT/C6225487

CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR .

1 in = 3

2 in = 7

3 in = 8

HS = 1.543

VS = 3.154

CS = 3.171

PATTERN #	3	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.754	.701	.593
MINIMUM X	-.889	-.942	-1.050
MAXIMUM Y	1.444	1.253	.955
MINIMUM Y	-1.711	-.869	-.712
CENTROID X	.091	.144	.252
CENTROID Y	.497	.688	.531
POA TO CENTROID in.	.506	.703	.588
MIN RADIUS	.156	.080	.110
MEAN RADIUS	.887	.779	.648
MAX RADIUS	1.776	1.521	1.066
HORIZONTAL SPREAD	1.643	1.643	1.643
VERTICAL SPREAD	3.154	2.122	1.667
EXTREME SPREAD	3.171	2.502	1.798
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		8	

10 Feb 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C8225407

CENTERFIRE PATTERNS

4

POA

1 in circle

2 in circle

3 in circle

CENTROID #

OF SHOTS= 10

IN CIR

1 in = 0

2 in = 3

3 in = 9

HS= 1.822

VS= 2.813

GS= 2.898

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.676	.635	.691
MINIMUM X	:	-1.146	-1.187	-1.131
MAXIMUM Y	:	1.078	.886	.715
MINIMUM Y	:	-1.735	-1.367	-1.216
CENTROID X	:	.136	.177	.122
CENTROID Y	:	-.533	-.341	-.170
POA TO CENTROID in.	:	.550	.384	.209
MIN RADIUS	:	.525	.471	.351
MEAN RADIUS	:	1.087	.980	.887
MAX RADIUS	:	1.774	1.438	1.399
HORIZONTAL SPREAD	:	1.822	1.822	1.822
VERTICAL SPREAD	:	2.813	2.253	1.931
EXTREME SPREAD	:	2.898	2.260	2.137
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		9	

10 Feb 1989

FILE:/PATTERNING/CENTERFIRE_PATT/06225407

CENTERFIRE PATTERNS

5

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS = 10

IN CIR

1 in = 4

2 in = 5

3 in = 7

HS = 1.345

VS = 3.461

GS = 3.476

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.789	.727	.237
MINIMUM X	-.557	-.322	-.231
MAXIMUM Y	1.553	1.341	1.135
MINIMUM Y	-1.908	-1.646	-.888
CENTROID X	.416	.478	.387
CENTROID Y	.042	.254	.460
POA TO CENTROID in.	.418	.541	.601
MIN RADIUS	.299	.092	.192
MEAN RADIUS	.946	.823	.710
MAX RADIUS	1.988	1.799	1.154
HORIZONTAL SPREAD	1.346	1.049	.468
VERTICAL SPREAD	3.461	2.987	2.023
EXTREME SPREAD	3.476	3.158	2.023
NUMBER IN ONE INCH CIRCLE =	4		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	7		