

G-6590107
Replaced
C-6225071

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: RE00133027

Serial: C6225071 Model M24 SWS Center Fire
Caliber: 7.62 NATO Produced: 12/20/1988

Repairman:

Verify Repair

High Priority

Status:

Closed 8/22/2007 7:13:25 AM

Address Information

Customer:

Received From

Return To:

Received From

Name: TRANSPORTATION OFFICER

TRANSPORTATION OFFICER

Address 1: XR WOK8 USA ROCK ISL ARSENAL

XR WOK8 USA ROCK ISL ARSENAL

Address 2: BLDG 299 GILLESPIE AVE BECK PO Box:

BLDG 299 GILLESPIE AVE BECK PO Box:

City: ROCK ISLAND

ROCK ISLAND

State: IL

Zip Code: 61299

Country: US

State: IL

Zip Code: 61299

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
A017	Scope Base	1
A057	Front and Rear Sgt Base	1

Repair Search

Refresh

Close

nagletj

8/22/2007

7:54 AM

CAPS

NUM

INS

SCRL

start

Inbox - Micr...

Calendar - M...

FW: Restrict...

Arms Service...

7:54 AM

6659 0107 (New)

Serial Number: ~~C6225071~~

Model: M24 SWS



RE00133027

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6590107.___0
FILE DATE AND TIME: 11/30/2007 12:23

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.061
The Average Y Centroid of the Five Target Set:	-0.014
The Average Point of Impact of the Five Target Set:	0.062
The Average Mean Radius of the Five Target Set:	0.662
The Distance from POA to Centroid Target #1:	0.228
The Distance from Centroid Target #2 to Centroid Target #1:	0.519
The Distance from Centroid Target #3 to Centroid Target #1:	0.427
The Distance from Centroid Target #4 to Centroid Target #1:	0.164
The Distance from Centroid Target #5 to Centroid Target #1:	0.276

SERIAL NUMBER: G6590107. __0

TARGET NUMBER: 1

FILE DATE: 11/30/2007

FILE TIME: 12:23

POINT#	X	Y
1:	0.417	-1.567
2:	-0.480	-1.118
3:	-0.803	-0.981
4:	-0.154	-0.756
5:	0.424	-0.213
6:	0.063	0.203
7:	0.263	0.330
8:	-0.352	0.541
9:	-0.467	0.755
10:	-0.169	0.908

X CENTROID: -0.126

Y CENTROID: -0.190

POA TO CENTROID: 0.228

HORZ SPREAD: 1.227

VERT SPREAD: 2.475

GROUP SPREAD: 2.543

MIN RADIUS: 0.436

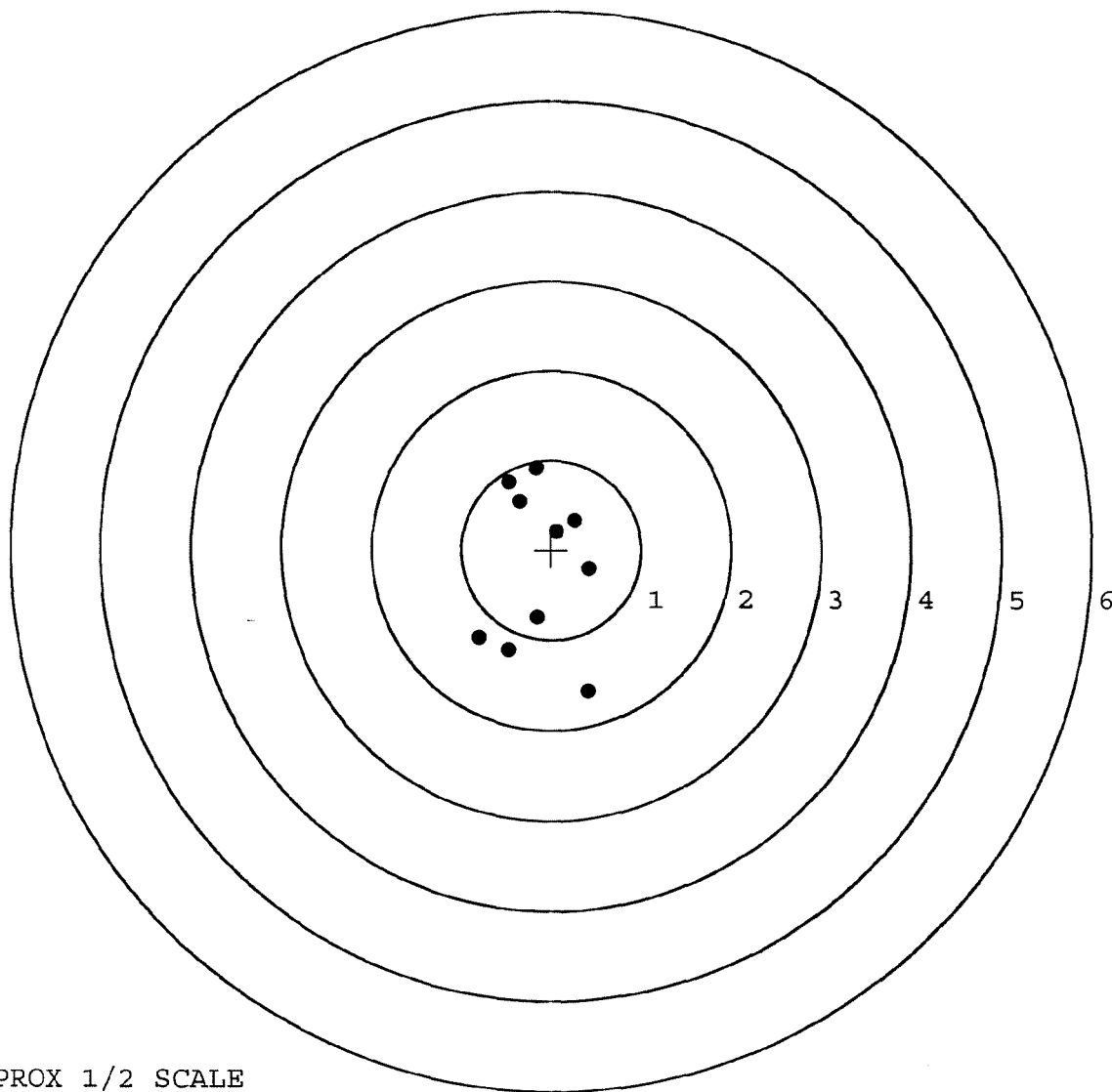
MAX RADIUS: 1.480

MEAN RADIUS: 0.859

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 10

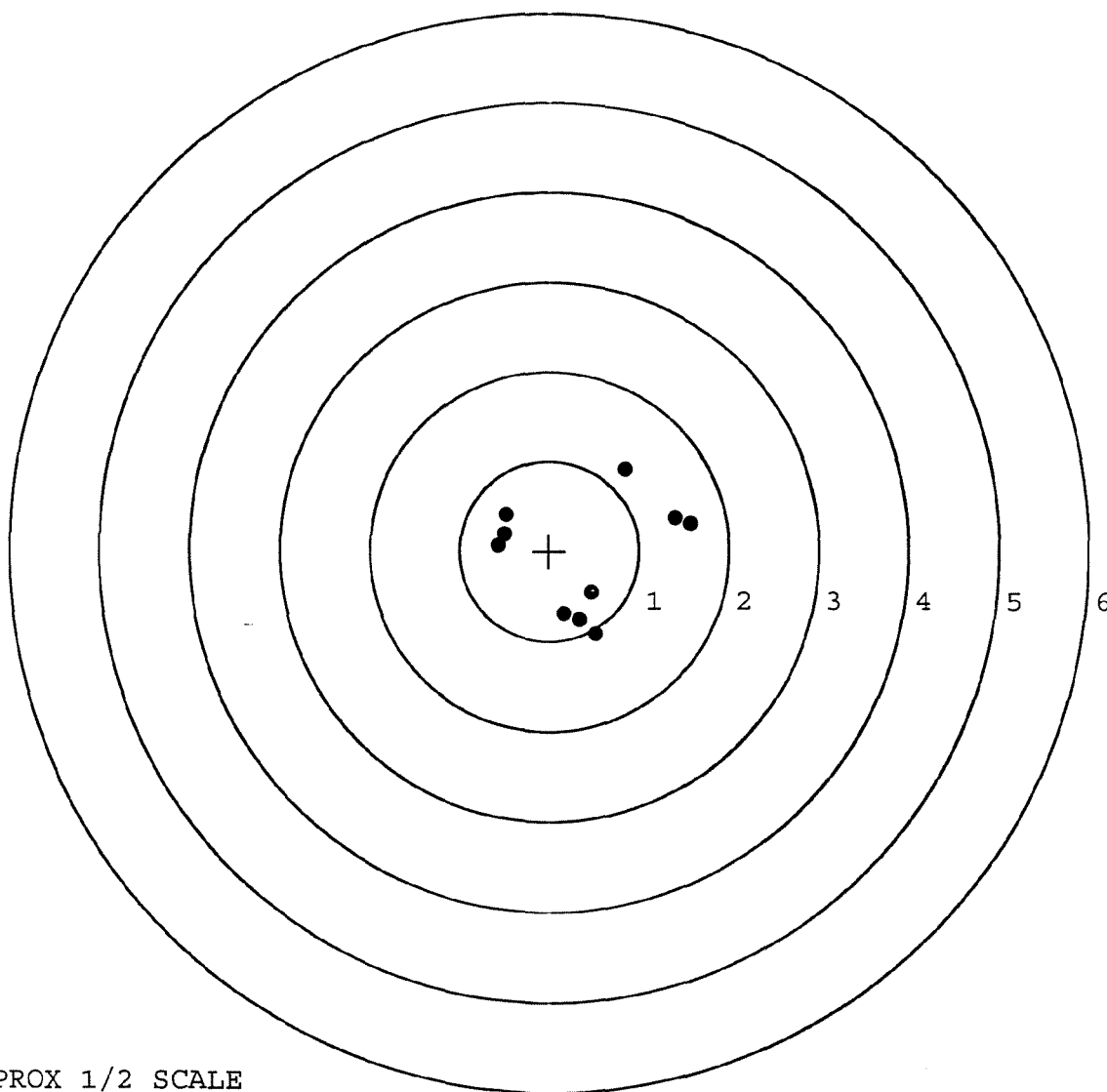


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590107.___0
TARGET NUMBER: 2
FILE DATE: 11/30/2007
FILE TIME: 12:23

X CENTROID: 0.376
Y CENTROID: -0.060
POA TO CENTROID: 0.381
HORZ SPREAD: 2.141
VERT SPREAD: 1.832
GROUP SPREAD: 2.155
MIN RADIUS: 0.411
MAX RADIUS: 1.250
MEAN RADIUS: 0.894
IN 1 IN DIAMETER: 1
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	1.571	0.309
2:	1.397	0.371
3:	0.847	0.911
4:	0.467	-0.461
5:	0.166	-0.700
6:	0.521	-0.921
7:	0.344	-0.762
8:	-0.570	0.061
9:	-0.498	0.188
10:	-0.483	0.406

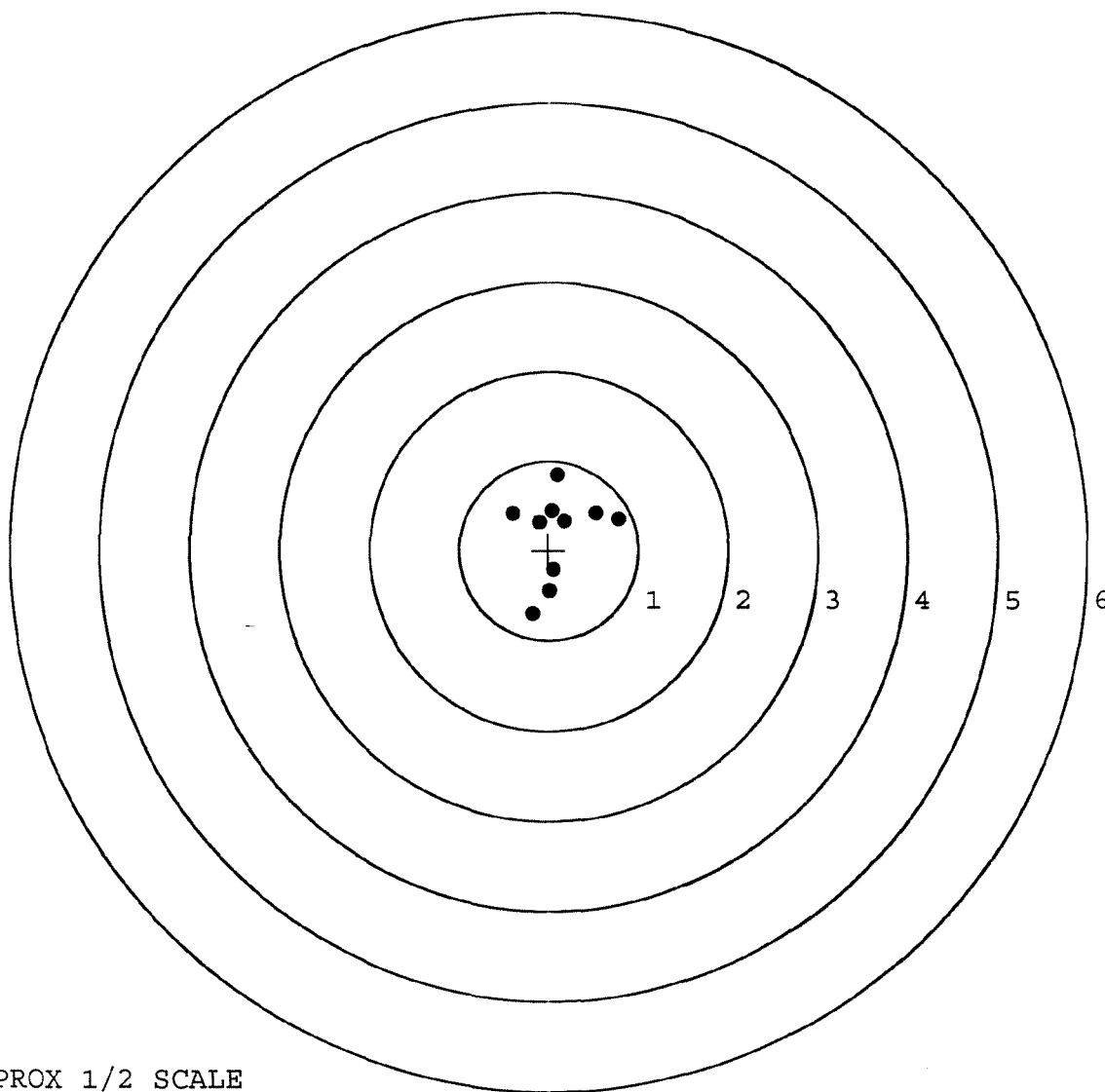


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590107.___0
TARGET NUMBER: 3
FILE DATE: 11/30/2007
FILE TIME: 12:23

POINT#	X	Y
1:	0.776	0.356
2:	0.530	0.425
3:	0.102	0.842
4:	0.179	0.330
5:	-0.404	0.418
6:	-0.112	0.314
7:	0.058	-0.224
8:	0.011	-0.455
9:	-0.186	-0.713
10:	0.035	0.440

X CENTROID: 0.099
Y CENTROID: 0.173
POA TO CENTROID: 0.200
HORZ SPREAD: 1.180
VERT SPREAD: 1.555
GROUP SPREAD: 1.581
MIN RADIUS: 0.176
MAX RADIUS: 0.931
MEAN RADIUS: 0.510
IN 1 IN DIAMETER: 5
IN 2 IN DIAMETER: 10
in 3 IN DIAMETER: 10

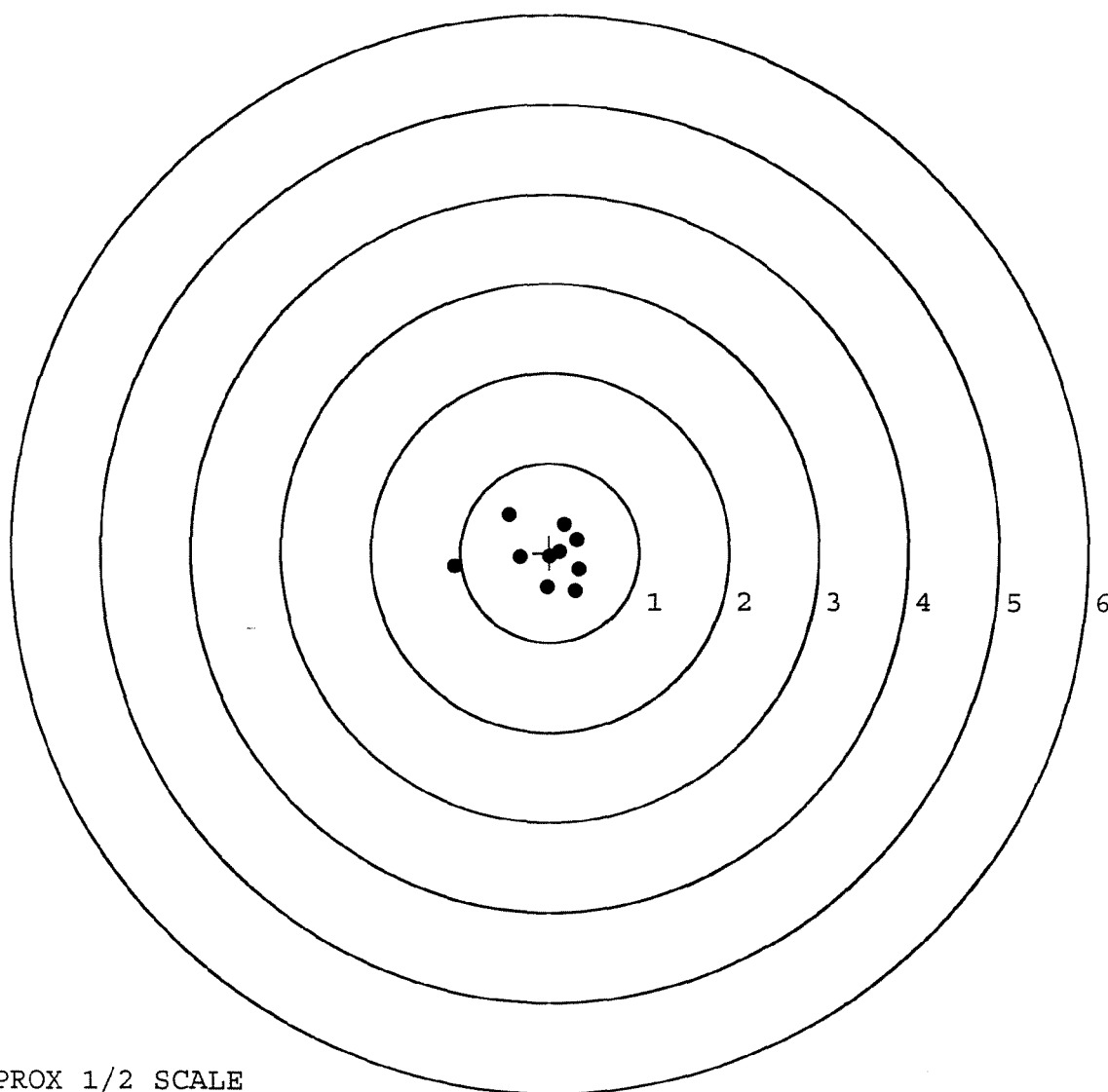


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590107.___0
TARGET NUMBER: 4
FILE DATE: 11/30/2007
FILE TIME: 12:23

POINT#	X	Y
1:	-0.454	0.419
2:	-1.064	-0.156
3:	0.162	0.320
4:	-0.333	-0.058
5:	-0.027	-0.391
6:	0.288	-0.430
7:	0.332	-0.190
8:	0.001	-0.040
9:	0.118	0.015
10:	0.304	0.145

X CENTROID: -0.067
Y CENTROID: -0.037
POA TO CENTROID: 0.077
HORZ SPREAD: 1.396
VERT SPREAD: 0.849
GROUP SPREAD: 1.401
MIN RADIUS: 0.068
MAX RADIUS: 1.004
MEAN RADIUS: 0.428
IN 1 IN DIAMETER: 7
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

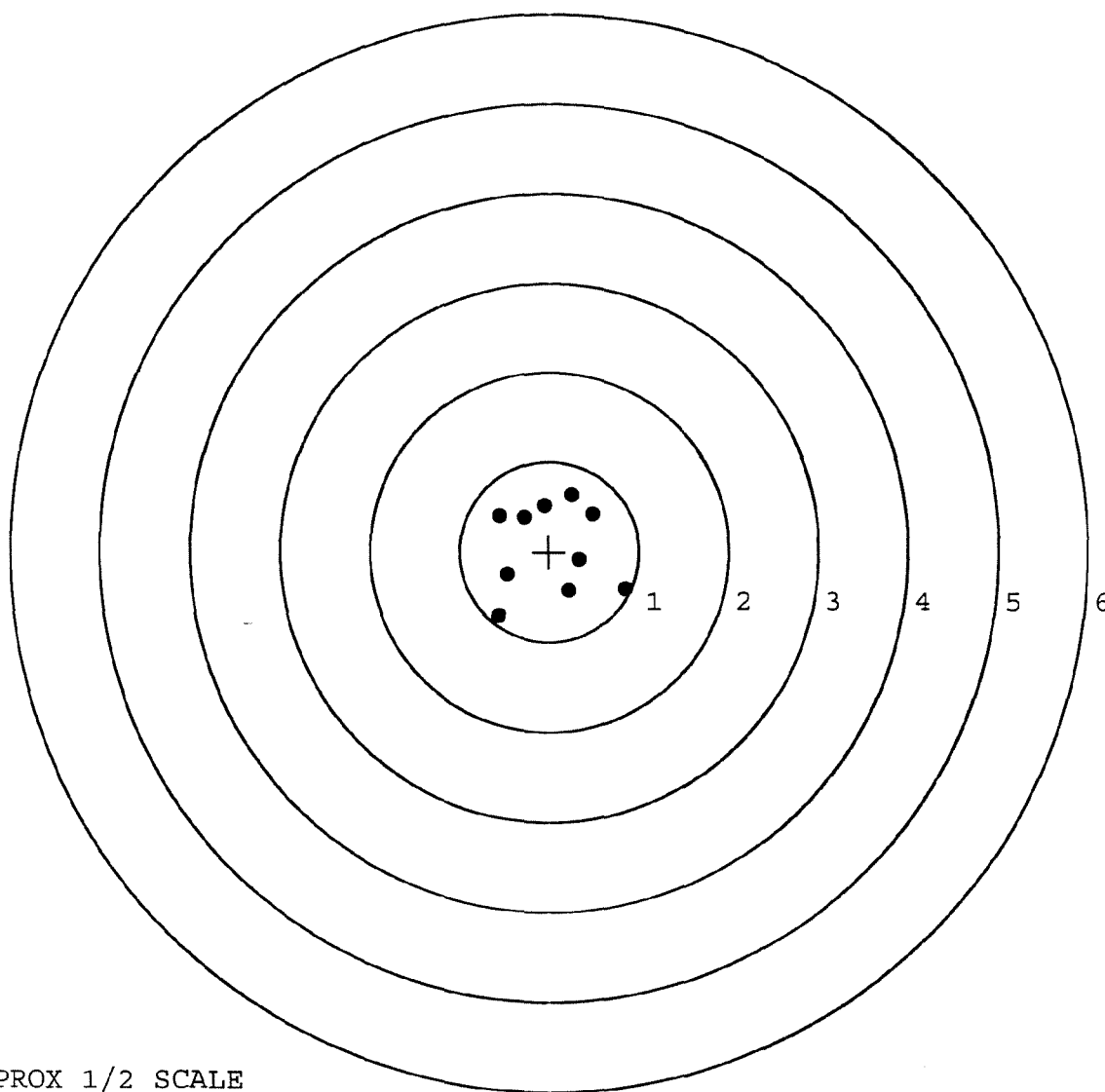


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590107. __0
TARGET NUMBER: 5
FILE DATE: 11/30/2007
FILE TIME: 12:23

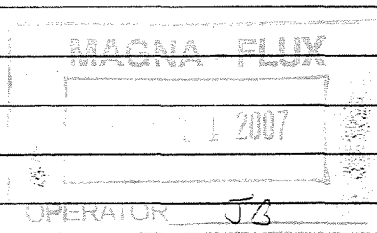
X CENTROID: 0.022
Y CENTROID: 0.043
POA TO CENTROID: 0.048
HORZ SPREAD: 1.413
VERT SPREAD: 1.346
GROUP SPREAD: 1.578
MIN RADIUS: 0.341
MAX RADIUS: 0.960
MEAN RADIUS: 0.618
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 10
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.848	-0.415
2:	0.337	-0.088
3:	0.225	-0.435
4:	-0.469	-0.256
5:	-0.565	-0.717
6:	0.485	0.420
7:	0.259	0.629
8:	-0.057	0.509
9:	-0.284	0.382
10:	-0.558	0.399



TARGET APPROX 1/2 SCALE

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

R & E NUMBER		133027		G6590107NW	
SERIAL NUMBER		G6225071			
LOG-IN DATE		8-22-07			
OPERATION #	OPERATION NAME		DATE	INITIAL	
500	DIS-ASSEMBLE GUN		11-5-07	RTZ	
505	RE-BARREL				
560	ASSEMBLE				
600	PROOF		11-7-07	TRW	
605	CHECK HEADSPACE		11-7-07	TRW	
610	DIS-ASSEMBLE GUN		11-08-07	TRW	
612	MAGNAFLUX		11-14-07	JB	
510	DRILL AND TAP		11-8-07	SD	
615	ROLLMARK CALIBER		11-13-07	CW	
618	ROTO-BLAST		11-14-07	YJ	
620	APPLY COATINGS		11-27-07	FB	
625	FINAL ASSEMBLY		11-29-07	RTZ	
640	FUNCTION TEST AND	(PASS) FAIL	11-29-07	TRW	
650	TARGET	(PASS) FAIL	11-29-07	TRW	
	MALFUNCTION	CORRECTION			
	MALFUNCTION	CORRECTION			
	MALFUNCTION	CORRECTION			
	MALFUNCTION	CORRECTION			
670	FINAL INSPECTION		11-29-07	TRW	
	A) HEADSPACE	(PASS) FAIL	11-30-07	RTZ	
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	2.17 2.15 2.25 2.25 2.32 11-30-07	RTZ	
680	F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX	6.9 6.9 6.9 11-30-07	RTZ	
	G) SAFETY OFF FORCE	2 LBS MIN	2.9 2.9 2.9 11-30-07	RTZ	
	I) FIRING PIN INDENT	.020	.021 .021 .021 11-30-07	RTZ	
690	PACK		11-30-07	RTZ	

GFM

CONTRACT # DAAA21-87-C-0086

Repair
New BarrelGUN SERIAL # *06325071*

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		<i>1/5/93</i>	<i>RW</i>
600	Proof		<i>1/5/93</i>	<i>RW</i>
607	Check Headspace		<i>1/5/93</i>	<i>RW</i>
610	Dis-assemble Gun		<i>1/5/93</i>	<i>RW</i>
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		<i>1/12/93</i>	<i>RW</i>
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		<i>1/12/93</i>	<i>RW</i>
	C) Inspect Ejector Hole for Chamfer		<i>1/12/93</i>	<i>RW</i>
	D) Oil Firing Pin Ass'y		<i>1/12/93</i>	<i>RW</i>
	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						1/13/93	RW
	A) Time							
	B) Malfunctions							
	C) Pierced Primers							
	D) Optical Clarity of Scope							
645	Inspect for Live Ammo						1/13/93	RW
655	Final Inspection							
	A) Headspace						1/13/93	RW
	B) Trigger Pull	2.16	2.30	2.32	2.25	2.28	1/13/93	RW
	C) Function						1/13/93	RW
660	Pack							

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6225071
14 Jan 1993

CENTROIDAL DISTANCES

0 TO	1	.609161
1 TO	2	1.0858
1 TO	3	.767289
1 TO	4	1.05273
1 TO	5	1.8624

1
3 + <----POA
31
5

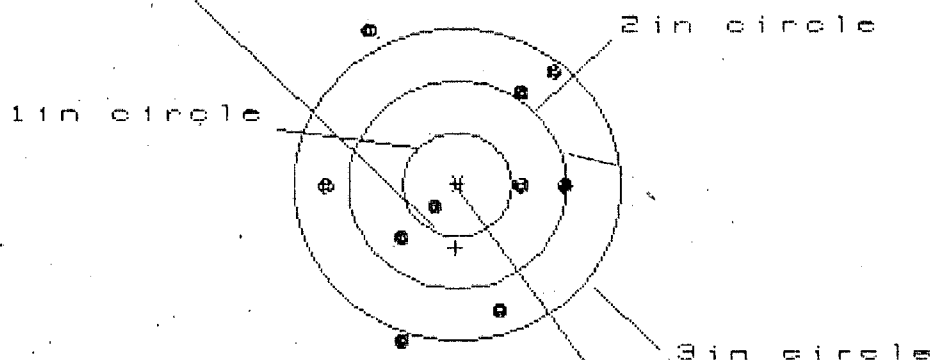
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.456
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.2164
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .504742
THE AMR FOR THIS RIFLE IS: .9744

14 Jan 1993

FILE:/PATTERNING/CENTERFIRE_PATT/C6225071

CENTERFIRE PATTERNS # 1

POB



OF SHOTS- 10

IN CIR

1in = 1

2in = 4

3in = 8

HS= 2.234

VS= 3.042

GS= 3.056

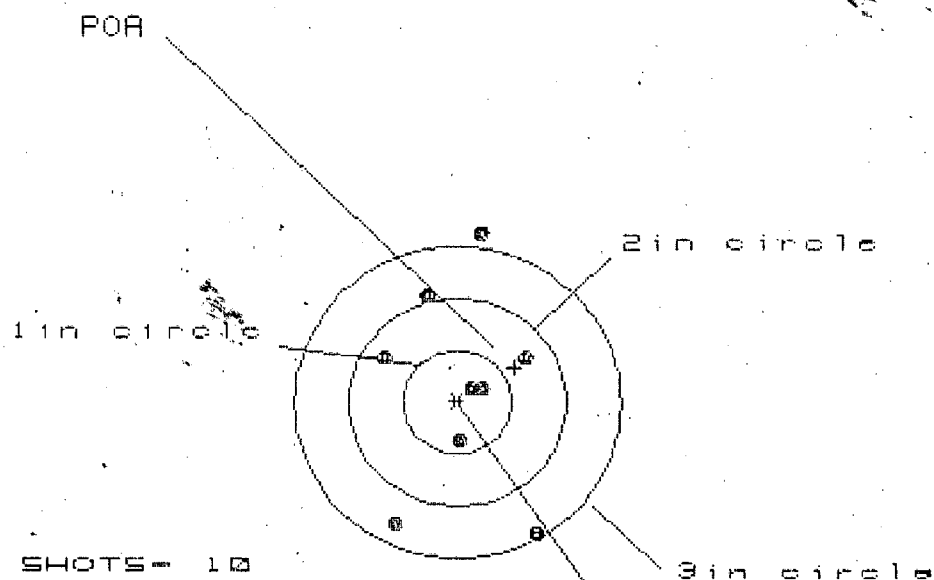
CENTROID #

PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.995	.903	.823
MINIMUM X	:	-1.239	-1.331	-1.411
MAXIMUM Y	:	1.525	1.274	1.105
MINIMUM Y	:	-1.517	-1.347	-1.187
CENTROID X	:	.014	.106	.186
CENTROID Y	:	.609	.439	.608
POB TO CENTROID in.	:	.609	.452	.635
MIN RADIUS	:	.298	.282	.375
MEAN RADIUS	:	1.093	.998	.931
MAX RADIUS	:	1.738	1.493	1.411
HORIZONTAL SPREAD	:	2.234	2.234	2.234
VERTICAL SPREAD	:	3.042	2.621	2.292
EXTREME SPREAD	:	3.056	2.979	2.388
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	4		
NUMBER IN THREE INCH CIRCLE	=	8		

14 Jan 1933.

FILE:/PATTERNING/CENTERFIRE_PATT/06225071

CENTERFIRE PATTERNS # 2



OF SHOTS - 10

IN CIR

1in = 3

2in = 5

3in = 9

HS = 1.394

VS = 2.906

GS = 2.951

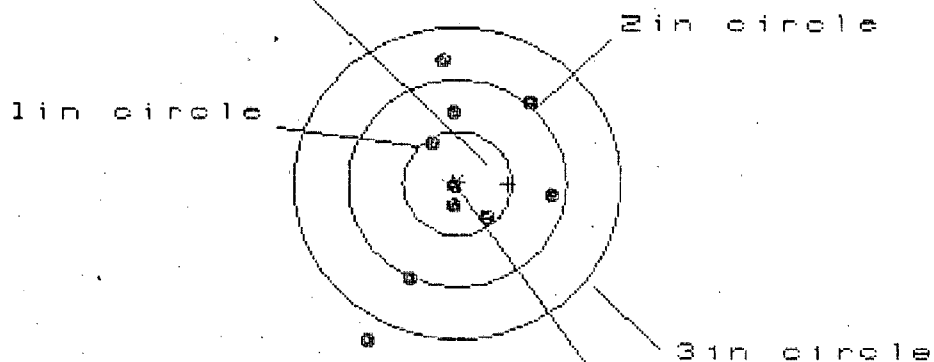
PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.764	.792	.718
MINIMUM X	-.630	-.602	-.503
MAXIMUM Y	1.677	1.254	1.123
MINIMUM Y	-1.229	-1.043	-1.099
CENTROID X	-.526	-.554	-.653
CENTROID Y	-.333	-.519	-.389
POA TO CENTROID in	.622	.759	.760
MIN RADIUS	.189	.186	.324
MEAN RADIUS	.909	.829	.765
MAX RADIUS	1.695	1.310	1.187
HORIZONTAL SPREAD	1.394	1.394	1.221
VERTICAL SPREAD	2.906	2.297	2.223
EXTREME SPREAD	2.951	2.519	2.244
NUMBER IN ONE INCH CIRCLE =	3	5	9
NUMBER IN TWO INCH CIRCLE =	5	9	10
NUMBER IN THREE INCH CIRCLE =	9	10	10

14 Jan 1993

FILE:/PATTERNING/CENTERFIRE_PATT/06225071

CENTERFIRE PATTERNS # 3

POA



OF SHOTS- 10

IN CIR

1in = 4

2in = 6

3in = 9

HS= 1.651

VS= 2.621

GS= 2.700

CENTROID *

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.837	.746	.715
MINIMUM X	-.814	-.546	-.577
MAXIMUM Y	1.146	.982	.747
MINIMUM Y	-1.475	-1.094	-.971
CENTROID X	-.468	-.377	-.346
CENTROID Y	.012	.176	.053
POA TO CENTROID in.	.468	.417	.350
MIN RADIUS	.023	.201	.127
MEAN RADIUS	.748	.651	.587
MAX RADIUS	1.685	1.223	1.130
HORIZONTAL SPREAD	1.651	1.292	1.292
VERTICAL SPREAD	2.621	2.076	1.718
EXTREME SPREAD	2.700	2.096	2.028
NUMBER IN ONE INCH CIRCLE =		4	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		9	

14 Jan 1993

FILE:/PATTERNING/CENTERFIRE_PATT/C6225071

CENTERFIRE PATTERNS

4

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 2

2in = 6

3in = 10

HS= 1.843

VS= 2.526

GS= 2.680

CENTROID #

PATTERN #

SHOTS (BEST OF)	10	9	8
MAXIMUM X	.940	.992	.937
MINIMUM X	-.903	-.851	-.906
MAXIMUM Y	1.425	1.030	.915
MINIMUM Y	-1.101	-.943	-1.058
CENTROID X	-.383	-.435	-.380
CENTROID Y	-.366	-.524	-.409
POA TO CENTROID in.	.530	.681	.558
MIN RADIUS	.095	.181	.115
MEAN RADIUS	.894	.832	.788
MAX RADIUS	1.498	1.141	1.156
HORIZONTAL SPREAD	1.843	1.843	1.843
VERTICAL SPREAD	2.526	1.973	1.973
EXTREME SPREAD	2.680	2.163	2.063
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	10		

14 Jan 1993

FILE:/PATTERNING/CENTERFIRE_PATT/06225071

CENTERFIRE PATTERNS # 5

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS- 10

IN CIR

1 in - 0

2 in - 4

3 in - 6

HS- 2.369

VS- 3.337

GS- 3.418

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.531	1.456	1.455
MINIMUM X	-0.838	-0.913	-0.914
MAXIMUM Y	1.659	1.473	1.098
MINIMUM Y	-1.678	-1.651	-1.467
CENTROID X	-0.917	-0.842	-0.841
CENTROID Y	-1.004	-0.818	-1.002
POA TO CENTROID in.	1.360	1.174	1.308
MIN RADIUS	.661	.605	.714
MEAN RADIUS	1.228	1.138	1.102
MAX RADIUS	1.808	1.781	1.612
HORIZONTAL SPREAD	2.369	2.369	2.369
VERTICAL SPREAD	3.337	3.124	2.565
EXTREME SPREAD	3.418	3.192	2.868
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	6		

COMMENTS

ORDER

INITIAL	CUSTOMER ORDER NO.
---------	--------------------

FP3

M24 W/ULTRA 10X-M3A SCOPE
W/BI POD & ADJUSTABLE RECOIL PAD

DATE RECEIVED	DATE OPENED	DATE CODE	SERIAL NUMBER	NEW SERIAL NUMBER	MODEL AND GRADE
12/21/92	12/21/92	DI 9-88	C6225071		700 7.62 NATO/SWS
ACCESSORIES	W/STUDS	SCOPE MNTS	SCOPE BASE	HARD CASE	

FROM:

SHIP TO:

CDR, 1ST BN 75TH RANGER REGT
ATTN CPT CHINN
AORG-FB-ACO
HAAF GA 3

GA 31409

CDR, 1ST BN 75TH RANGER REGT
ATTN CPT CHINN
AORG-FB-ACO
HAAF GA

GA
31409

CUST NO: 059608 C.O.D

ACCOUNT NUMBER

ACCOUNT NUMBER N/C

WRITE

CLEAN/TEST

PROM. DATE

ESTIMATED

V1A

UPS

GUN CONDITION

☐ NEW
☐ LIGHTLY WORN
☐ WORN
☐ VERY WORN
☐ UNREPAIRABLE
☐ MARRED

REPAIR CHARGE

EXCISE

TAX

INSURANCE

UPS

PARCEL POST

1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41	42	43	44	45	46	47	48	49	50	51	52	53	54	55	56	57	58	59	60	61	62	63	64	65	66	67	68	69	70	71	72	73	74	75	76	77	78	79	80	81	82	83	84	85	86	87	88	89	90	91	92	93	94	95	96	97	98	99	100	101	102	103	104	105	106	107	108	109	110	111	112	113	114	115	116	117	118	119	120	121	122	123	124	125	126	127	128	129	130	131	132	133	134	135	136	137	138	139	140	141	142	143	144	145	146	147	148	149	150	151	152	153	154	155	156	157	158	159	160	161	162	163	164	165	166	167	168	169	170	171	172	173	174	175	176	177	178	179	180	181	182	183	184	185	186	187	188	189	190	191	192	193	194	195	196	197	198	199	200	201	202	203	204	205	206	207	208	209	210	211	212	213	214	215	216	217	218	219	220	221	222	223	224	225	226	227	228	229	230	231	232	233	234	235	236	237	238	239	240	241	242	243	244	245	246	247	248	249	250	251	252	253	254	255	256	257	258	259	260	261	262	263	264	265	266	267	268	269	270	271	272	273	274	275	276	277	278	279	280	281	282	283	284	285	286	287	288	289	290	291	292	293	294	295	296	297	298	299	300	301	302	303	304	305	306	307	308	309	310	311	312	313	314	315	316	317	318	319	320	321	322	323	324	325	326	327	328	329	330	331	332	333	334	335	336	337	338	339	340	341	342	343	344	345	346	347	348	349	350	351	352	353	354	355	356	357	358	359	360	361	362	363	364	365	366	367	368	369	370	371	372	373	374	375	376	377	378	379	380	381	382	383	384	385	386	387	388	389	390	391	392	393	394	395	396	397	398	399	400	401	402	403	404	405	406	407	408	409	410	411	412	413	414	415	416	417	418	419	420	421	422	423	424	425	426	427	428	429	430	431	432	433	434	435	436	437	438	439	440	441	442	443	444	445	446	447	448	449	450	451	452	453	454	455	456	457	458	459	460	461	462	463	464	465	466
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CUSTOMER CONCERN	AMMO	FUNCTION	FINISH	ACCURACY	FIT	INSPECT
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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

PARTS

COMMENTS

REPAIRMAN <i>RW</i>	PROOF <i>[initials]</i>	CLEAN	TEST <i>[initials]</i>	TARGET <i>[initials]</i>	PATTERN
GALLERY TESTER <i>RW</i>	DATE <i>1/5/93</i>	DATE	DATE <i>1/13/93</i>	DATE <i>1/13/93</i>	DATE

OFFICE COPY

RD6925 REV. 1/92

M2400164730

DA FORM 2007

EDITION OF JUL 79 IS OBSOLETE.

CONTROL CORV 2

M2400164731

[illegible]

Replaces edition of 1 Jan 64, which will be used

CONTRACT # DAAA21-87-C-0086

INTERCHANGEABILITY

GUN SERIAL #

C6225071

OP. #	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and Stock	QUALITY AUDIT	9 12 88	FB
600	Proof		9 19 88	RW
607	Check Headspace		9 19 88	RW
610	Dis-assemble Gun		9 19 88	RW
612	Magnaflux Barrel Action		9 22 88	Pf.
	Magnaflux Bolt		9 22 88	Pf.
615	Rollmark Caliber		10/12	WC
617	Drill and Tap Sight Holes		11/12	FB
618	Polish Barrel		10/20	WT
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		11/15/88	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		11/15/88	RW
	C) Inspect Ejector Hole for Chamfer		11/15/88	RW
	D) Oil Firing Pin Ass'y		11/15/88	RW
	E) Adjust Trigger Pull to Min Setting and Stake		11/15/88	LD

op. #	OP. NAME	READINGS					DATE	INITIAL
625 cont.	F) Safety On Force	5	5	5			16 NOV 88	JSJ
	G) Safety Off Force	4	3	3			16 NOV 88	JSJ
	H) Trigger Pull Test & Retainability						15 NOV 88	JSJ
	I) Firing Pin Indent	.021	.0205	.021			16 NOV 88	JSJ
	J) Assemble Stock						11/12/88	RW
	K) Assemble Swivel Studs						6 Dec 88	JSJ
	L) Attach Front and Rear Sight Assemblies						12/6/88	RW
	M) Iron Sight Alignment						12/6/88	RW
	N) Detach Front & Rear Sights & place in numbered container						12/6/88	RW
	O) Attach Scope to Rifle						11/28/88	RW
	P) Detach & Attach Scope 20 Times						11/28/88	WB
640	Gallery Target & Test	58 R	96 L				12/5/88	DH
	A) Time							
	B) Malfunctions							
	C) Pierced Primers							
	D) Optical Clarity of Scope						12/5/88	DH
645	Inspect for Live Ammo						12/5/88	DH
655	Final Inspection							
	A) Headspace						6 Dec 88	JSJ
	B) Trigger Pull	275	263	263	248	256	6 Dec 88	JSJ
	C) Function						6 Dec 88	JSJ
660	Pack						12/15/88	RW

0.2
SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

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

SERIAL NO. C625071

DATE 15 NOV 88

TESTER JS

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.27	2.22	2.37	2.75	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.14	2.20	2.27	2.63	
PULL #3	2.36	2.15	2.30	2.63	
PULL #4	2.30	2.20	2.28	2.48	
PULL #5	2.25	2.16	2.29	2.56	
TOTAL	11.32	10.93	11.52	13.05	
AVG.	2.264	2.186	2.304	2.61	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.29	3.26		
PULL #2	3.31	3.22		
PULL #3	3.27	3.20		
PULL #4	3.11	3.25		
PULL #5	3.22	3.26		
TOTAL	16.20	16.19		
AVG.	3.24	3.238		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.18	4.24		4.13
PULL #2	4.23	4.23		4.13
PULL #3	4.25	4.22		4.12
PULL #4	4.19	4.24		4.20
PULL #5	4.24	4.22		4.21
TOTAL	21.09	21.12		20.89
AVG.	4.218	4.224		4.178

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6225071

CENTROIDAL DISTANCES

0 TO	1	.642966
1 TO	2	.681534
1 TO	3	.648991
1 TO	4	.149372
1 TO	5	1.02532

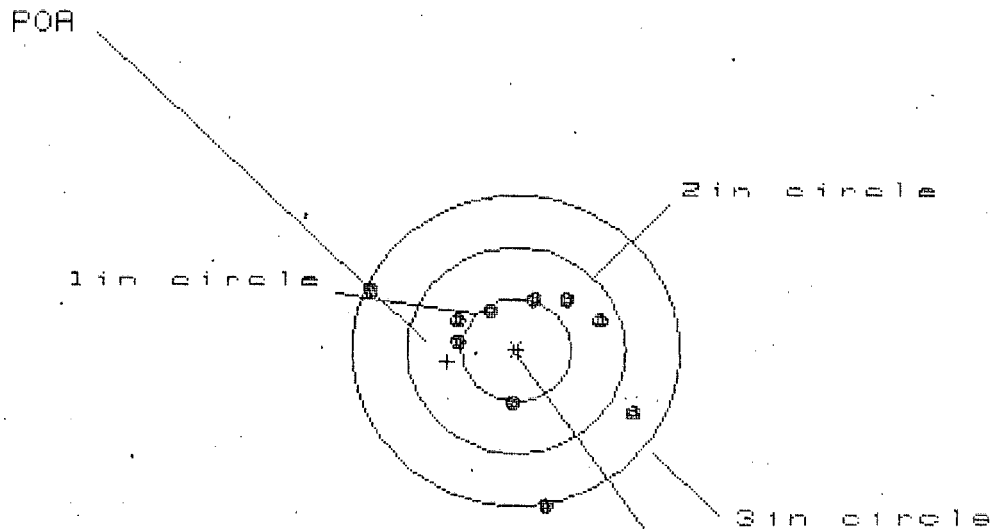
$\frac{5}{3}$
+ $\frac{1}{2}$ <----FOR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .5254
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .2688
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .590168
THE AMR FOR THIS RIFLE IS: .9078

6 Dec 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C8225071

CENTERFIRE PATTERNS #. 1



OF SHOTS - 10

IN CIR

1in = 2

2in = 7

3in = 9

HM = 2.402

VS = 2.087

GS = 2.681

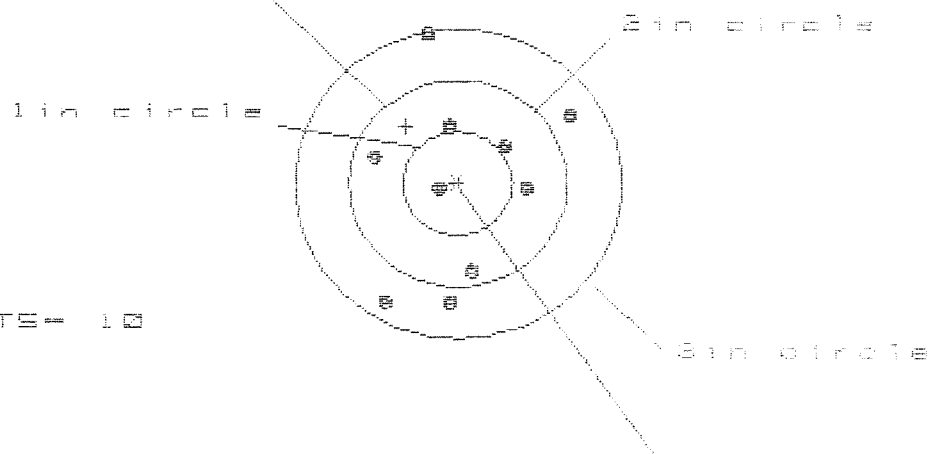
PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.041	1.066	.897
MINIMUM X	:	-1.381	-1.356	-.716
MAXIMUM Y	:	.569	.400	.360
MINIMUM Y	:	-1.510	-.750	-.700
CENTROID X	:	.634	.609	.778
CENTROID Y	:	.107	.276	.225
POA TO CENTROID in.	:	.643	.668	.810
MIN RADIUS	:	.481	.338	.363
MEAN RADIUS	:	.839	.730	.648
MAX RADIUS	:	1.535	1.414	1.137
HORIZONTAL SPREAD	:	2.422	2.422	1.613
VERTICAL SPREAD	:	2.087	1.150	1.060
EXTREME SPREAD	:	2.681	2.681	1.786
NUMBER IN ONE INCH CIRCLE =		2		
NUMBER IN TWO INCH CIRCLE =		7		
NUMBER IN THREE INCH CIRCLE =		9		

5 Dec 1988

FILE:/PATTERNING/CENTERFIRE_PATT/08225071

CENTERFIRE PATTERNS # 2

FOR



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 6

3 in = 3

IS= 1.799

VS= 2.607

GS= 2.637

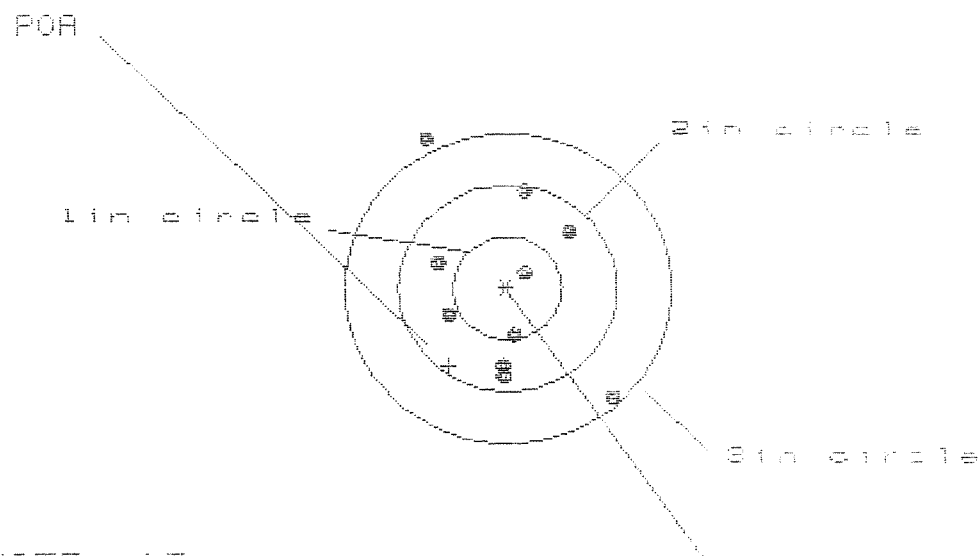
CENTROID X

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.989	.956	.865
MINIMUM X	:	-.810	-.843	-.934
MAXIMUM Y	:	1.419	.842	.713
MINIMUM Y	:	-1.188	-1.030	-1.109
CENTROID X	:	.472	.505	.596
CENTROID Y	:	-.555	-.713	-.584
FOR TO CENTROID in.	:	.729	.874	.834
MIN RADIUS	:	.173	.245	.296
MEAN RADIUS	:	.877	.816	.740
MAX RADIUS	:	1.451	1.274	1.125
HORIZONTAL SPREAD	:	1.799	1.799	1.799
VERTICAL SPREAD	:	2.607	1.872	1.822
EXTREME SPREAD	:	2.637	2.517	2.186
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	

8 Dec 1988

FILE:/PATTERNING/CENTERFIRE_PATT/06285071

CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1 in = 2

2 in = 8

3 in = 9

HS = 1.759

VS = 2.490

GS = 3.049

PATTERN #	1	3	9	8
SHOTS (BEST OF)	10	9	9	8
MAXIMUM X	1.007	.924	.924	.588
MINIMUM X	-.752	-.704	-.704	-.589
MAXIMUM Y	1.439	1.092	1.092	.981
MINIMUM Y	-1.051	-.891	-.891	-.766
CENTROID X	.539	.622	.622	.507
CENTROID Y	.749	.589	.589	.700
POA TO CENTROID in.	.923	.857	.857	.865
MIN RADIUS	.251	.265	.265	.307
MEAN RADIUS	.830	.726	.726	.649
MAX RADIUS	1.624	1.283	1.283	.998
HORIZONTAL SPREAD	1.759	1.628	1.628	1.177
VERTICAL SPREAD	2.490	1.983	1.983	1.747
EXTREME SPREAD	3.049	2.158	2.158	1.733
NUMBER IN ONE INCH CIRCLE =		2	2	
NUMBER IN TWO INCH CIRCLE =		8	8	
NUMBER IN THREE INCH CIRCLE =		9	9	

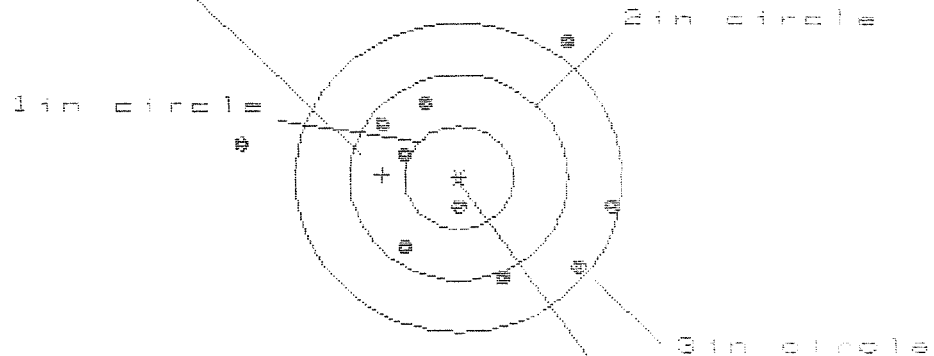
8 Dec 1988

FILE:/PATTERNING/CENTERFIRE_PATT/08225071

CENTERFIRE PATTERNS

4

POA



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 5

3 in = 8

HS= 3.422

VS= 2.351

GS= 3.482

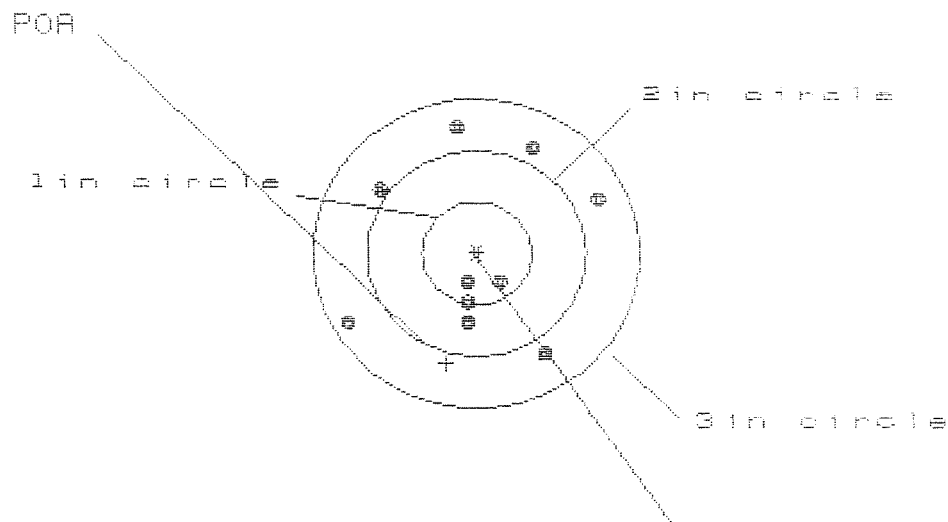
CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.441	1.220	1.319
MINIMUM X	:	-1.981	-.882	-.783
MAXIMUM Y	:	1.352	1.388	.939
MINIMUM Y	:	-.999	-.963	-.789
CENTROID X	:	.700	.921	.822
CENTROID Y	:	-.027	-.063	-.237
POA TO CENTROID in.	:	.701	.923	.855
MIN RADIUS	:	.252	.340	.172
MEAN RADIUS	:	1.088	1.004	.987
MAX RADIUS	:	2.008	1.598	1.324
HORIZONTAL SPREAD	:	3.422	2.102	2.102
VERTICAL SPREAD	:	2.351	2.351	1.728
EXTREME SPREAD	:	3.482	2.642	2.273
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

6 Dec 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C6225071

CENTERFIRE PATTERNS # 5



OF SHOTS = 10

IN CIR

1 in = 3

2 in = 4

3 in = 10

HS = 2.340

VS = 2.244

GS = 2.606

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.137	1.004	.969
MINIMUM X	-1.203	-.965	-1.000
MAXIMUM Y	1.239	1.166	1.106
MINIMUM Y	-1.005	-1.078	-.933
CENTROID X	.282	.415	.450
CENTROID Y	1.070	1.143	.990
POA TO CENTROID in.	1.106	1.216	1.094
MIN RADIUS	.305	.339	.189
MEAN RADIUS	.905	.863	.777
MAX RADIUS	1.373	1.199	1.210
HORIZONTAL SPREAD	2.340	1.969	1.969
VERTICAL SPREAD	2.244	2.244	2.038
EXTREME SPREAD	2.606	2.375	2.179
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		4	
NUMBER IN THREE INCH CIRCLE =		10	

INTERCHANGEABILITY

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6225071

CENTROIDAL DISTANCES

0 TO 1	.282577
1 TO 2	.147299
1 TO 3	.21
1 TO 4	.273912
1 TO 5	.10959

4 <----POA

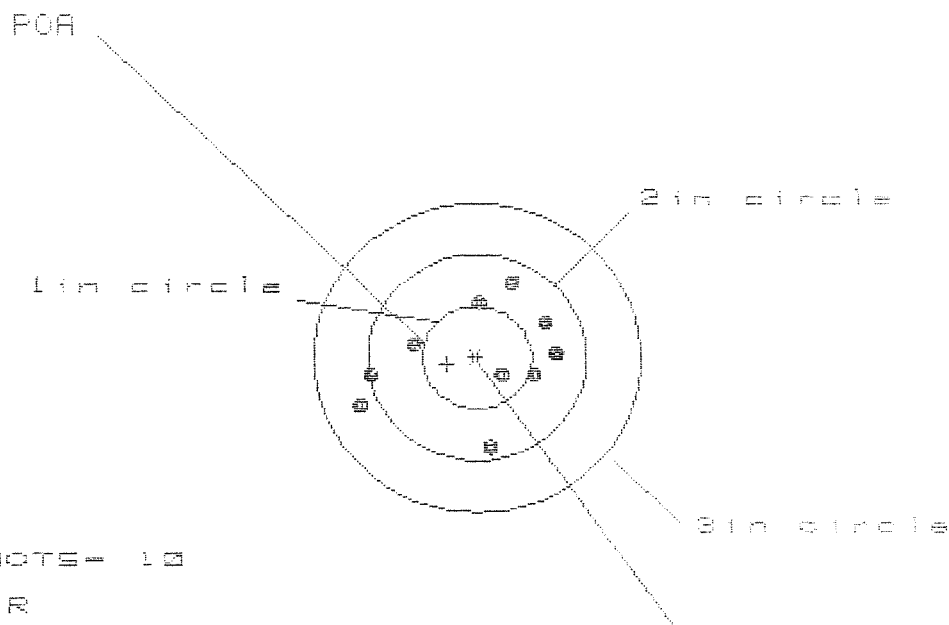
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1516
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0458
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .158367
THE AMR FOR THIS RIFLE IS: .894

INTERCHANGEABILITY

18 Dec 1988

FILE:/PATTERNING/CENTERFIRE_PATT/06225071.1

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1in = 1

2in = 8

3in = 10

HS = 1.817

VS = 1.666

GS = 1.882

CENTROID *

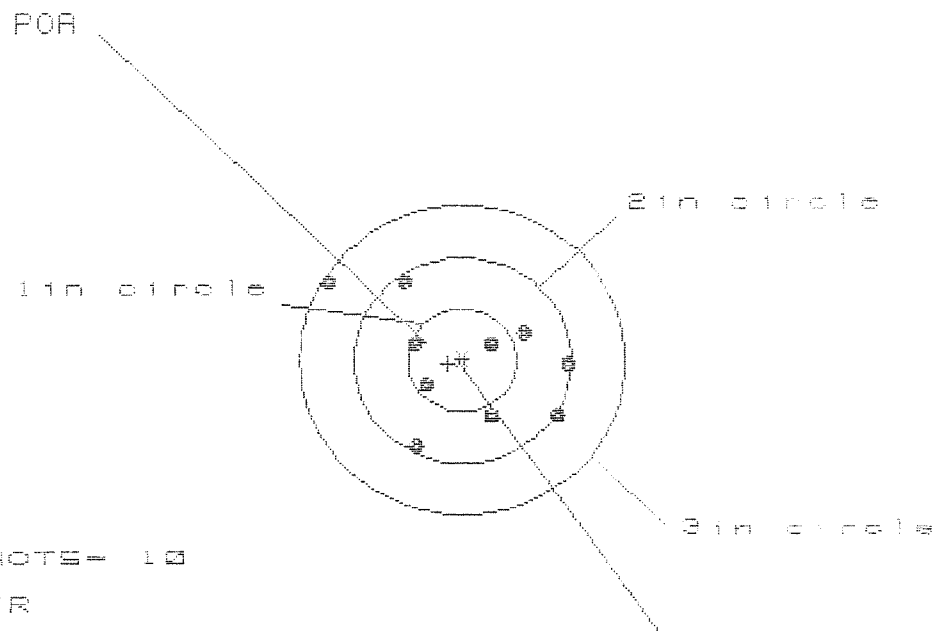
PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.757	.639	.509
MINIMUM X	-1.066	-1.043	-.815
MAXIMUM Y	.770	.721	.700
MINIMUM Y	-.896	-.945	-.966
CENTROID X	.275	.393	.523
CENTROID Y	.065	.114	.135
POA TO CENTROID in.	.283	.409	.541
MIN RADIUS	.312	.285	.285
MEAN RADIUS	.723	.651	.573
MAX RADIUS	1.150	1.057	.979
HORIZONTAL SPREAD	1.817	1.682	1.323
VERTICAL SPREAD	1.556	1.666	1.666
EXTREME SPREAD	1.882	1.690	1.678
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	9		
NUMBER IN THREE INCH CIRCLE =	10		

INTERCHANGEABILITY

13 Dec 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C8225071.1

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1in = 3

2in = 8

3in = 10

HS= 2.154

VS= 1.564

GS= 2.487

CENTROID #

PATTERN #	:	2	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.949	.815	.912
MINIMUM X	:	-1.205	-.640	-.543
MAXIMUM Y	:	.775	.806	.752
MINIMUM Y	:	-.789	-.783	-.758
CENTROID X	:	.131	.265	.168
CENTROID Y	:	.034	-.052	.003
POR TO CENTROID in.	:	.136	.270	.168
MIN RADIUS	:	.324	.302	.315
MEAN RADIUS	:	.757	.668	.634
MAX RADIUS	:	1.433	1.030	.927
HORIZONTAL SPREAD	:	2.154	1.455	1.455
VERTICAL SPREAD	:	1.564	1.509	1.509
EXTREME SPREAD	:	2.487	1.889	1.619
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	

INTERCHANGEABILITY

19 Dec 1988

FILE:/PATTERNING/CENTERFIRE_PATT/08225071.1

CENTERFIRE PATTERNS

3

FOR

1 in circle

2 in circle

3 in circle

OF SHOTS = 10

IN CIR

1 in = 1

2 in = 4

3 in = 8

HS = 2.484

VS = 2.858

GS = 3.242

CENTROID

PATTERN #

3

SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.172	1.096	1.027
MINIMUM X	:	-1.322	-1.398	-1.251
MAXIMUM Y	:	1.556	1.153	1.037
MINIMUM Y	:	-1.103	-.931	-1.039
CENTROID X	:	.107	.183	.046
CENTROID Y	:	.191	.019	.135
FOR TO CENTROID in.	:	.219	.184	.142
MIN RADIUS	:	.292	.425	.249
MEAN RADIUS	:	1.105	1.037	.960
MAX RADIUS	:	1.699	1.466	1.460
HORIZONTAL SPREAD	:	2.494	2.494	2.288
VERTICAL SPREAD	:	2.659	2.084	2.076
EXTREME SPREAD	:	3.242	2.846	2.485
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	4		
NUMBER IN THREE INCH CIRCLE	=	8		

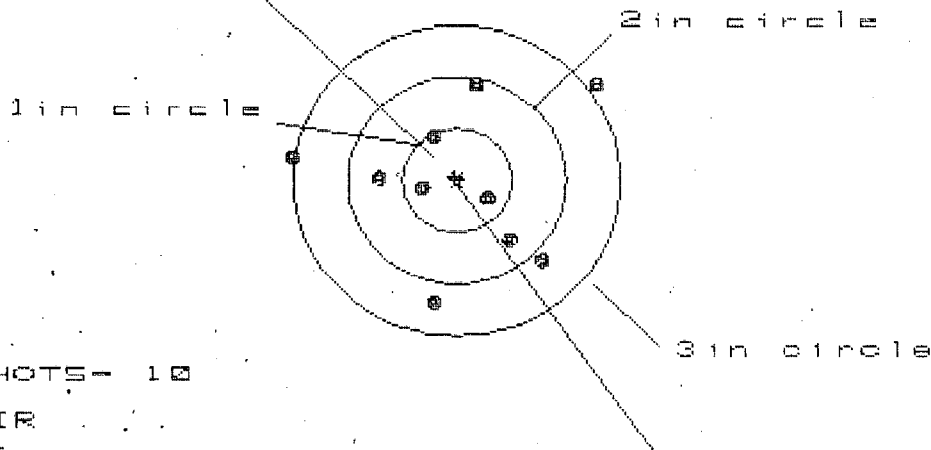
INTERCHANGEABILITY

13 Dec 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C6225071.1

CENTERFIRE PATTERNS # 4

POA



OF SHOTS- 10

IN CIR

1in = 2

2in = 6

3in = 8

HS= 2.761

VS= 2.084

GS= 2.853

CENTROID *

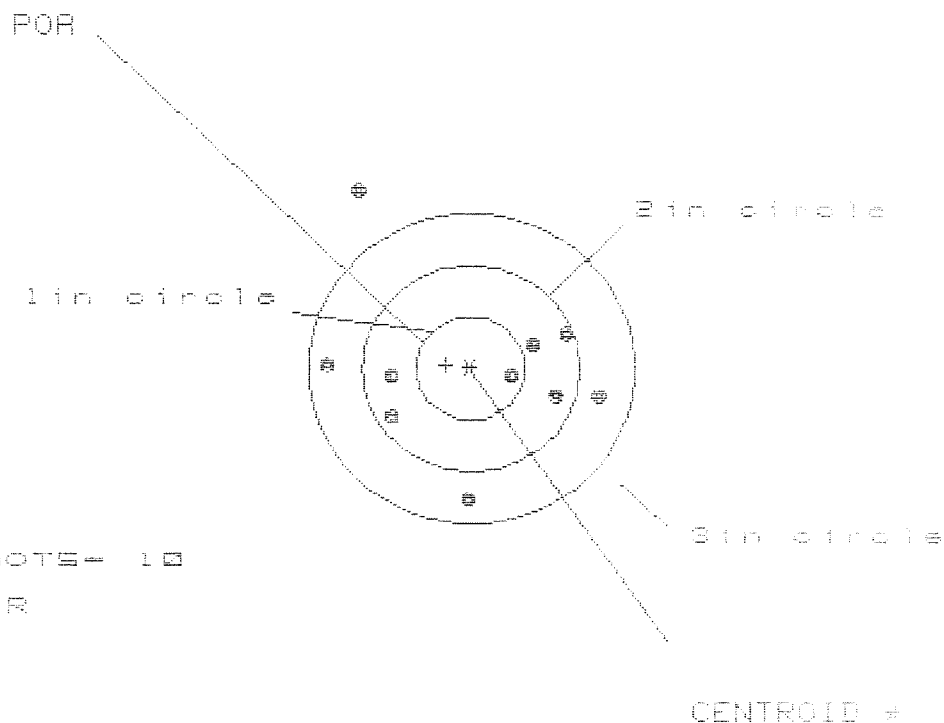
PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.245	.966	.794
MINIMUM X	-1.516	-1.378	-.767
MAXIMUM Y	.955	1.032	1.075
MINIMUM Y	-1.129	-1.023	-.980
CENTROID X	.017	-.121	.051
CENTROID Y	-.027	-.133	-.176
POA TO CENTROID in.	.032	.180	.183
MIN RADIUS	.278	.142	.212
MEAN RADIUS	.884	.793	.706
MAX RADIUS	1.569	1.420	1.082
HORIZONTAL SPREAD	2.761	2.344	1.561
VERTICAL SPREAD	2.084	2.055	2.055
EXTREME SPREAD	2.853	2.535	2.085
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	8		

INTERCHANGEABILITY

13 Dec 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C8225071.1

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 5

3 in = 9

HS= 2.520

VS= 3.008

GS= 3.169

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	1.192
MINIMUM X	-1.328
MAXIMUM Y	1.739
MINIMUM Y	-1.269
CENTROID X	.228
CENTROID Y	-.034
POR TO CENTROID in.	.230
MIN RADIUS	.383
MEAN RADIUS	1.001
MAX RADIUS	1.998
HORIZONTAL SPREAD	2.520
VERTICAL SPREAD	3.008
EXTREME SPREAD	3.169
NUMBER IN ONE INCH CIRCLE =	1
NUMBER IN TWO INCH CIRCLE =	5
NUMBER IN THREE INCH CIRCLE =	9