GC590137
Replaced
GC285935

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: RE00156051
Verify Repair

Serial: G6590137 Model M24 SWS Center Fire
Caliber: 7.62 NATO

Repairman:
Status: Closed 12/1/2008 11:15:55 AM

Address Information

Customer: (Received From)		Return To: (Received From)	
Name:	ITT SYSTEMS SECURED WAREHOUSE		ITT SYSTEMS SECURED WAREHOUSE
Address 1:	UPTON AVENUE		UPTON AVENUE
Address 2:	BUILDING 490 PO Box:		BUILDING 490 PO Box:
City:	FORT BENNING		FORT BENNING
State:	GA Zip Code: 31905 Country: US	State:	GA Zip Code: 31905 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	Qu
A007	With Stud	2
A008	With Swivel	1
A010	Hard Case A 2	1
A017	Scope Base	1
A026	Scope	1
A057	Frt and Rear Sgt Base	1

Repair Search | Refresh | Close

nagleti | 12/2/2008 | 10:12 AM | CAPS | NUM | INS | SCRL

start | 4 Micro... | Part Sear... | Arms Ser... | MMMMM... | EasyFor... | 10:12 AM

Serial Number: G6590137

Model: M24 SWS

RE00156051

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

R & E NUMBER 156051

SERIAL NUMBER G6596137

LOG-IN DATE 12-1-08

OPERATION #	OPERATION NAME		DATE	INITIAL
500	DIS-ASSEMBLE GUN		12-2-08	RSN
505	RE-BARREL		12-3-08	RSN
560	ASSEMBLE		12-3-08	RSN
600	PROOF	MAGNA - FLUX	12-3-08	L.P.D.
605	CHECK HEADSPACE		12-3-08	L.P.D.
610	DIS-ASSEMBLE GUN		12-3-08	L.P.D.
612	MAGNAFLUX	OPERATOR (KA)	12/14/08	KA
510	DRILL AND TAP		12-11-08	SP
615	ROLLMARK CALIBER		12/15/08	RT
618	ROTO-BLAST			
620	APPLY COATINGS		1 2 22	—
625	FINAL ASSEMBLY		1-5-09	RSN
640	FUNCTION TEST AND	(PASS) FAIL	1-5-09	L.P.D.
650	TARGET	(PASS) FAIL	1-5-09	L.P.D.
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION N/A		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION	1-5-09	RP
670	FINAL INSPECTION		1-6-09	L.P.D.
	A) HEADSPACE	(PASS) FAIL	1-6-09	L.P.D.
	B) TRIGGER PULL (+/- .5 LBS, MIN 2.50 LBS, MAX 4.0 LBS)	243 348 357 349 340	1-6-09	L.N.
680	F) SAFETY ON FORCE (2 LBS MIN, 10 LBS MAX)	5.0 5.0 5.0	1-6-09	L.P.D.
	G) SAFETY OFF FORCE (2 LBS MIN)	6.0 6.0 6.0	1-6-09	L.N.
	I) FIRING PIN INDENT (.020)	.022 .023 .023	1-6-09	L.N.
690	PACK		1/6/09	FM

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFOMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6590137.__1
FILE DATE AND TIME: 01/06/2009 06:29

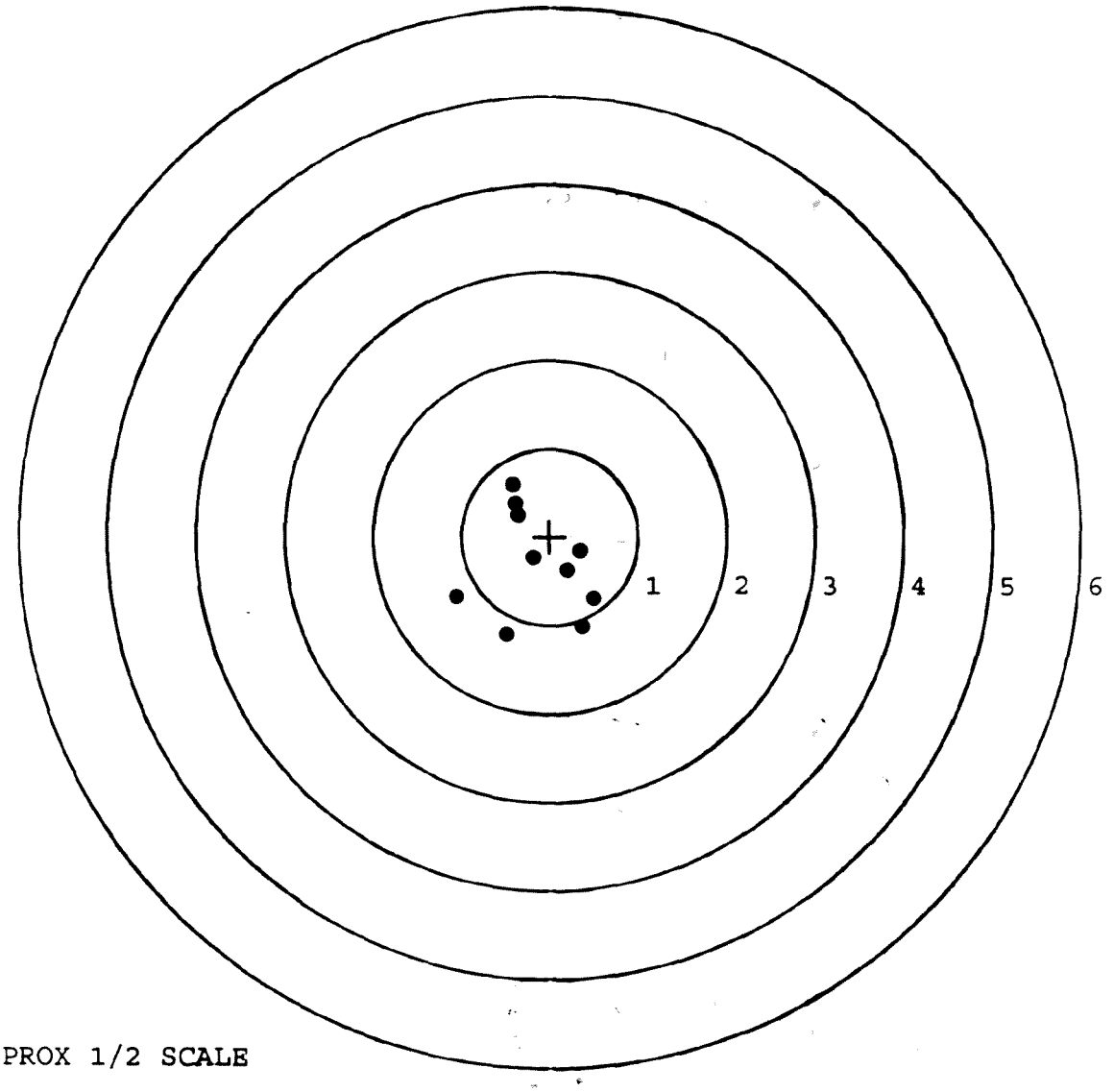
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.082
The Average Y Centroid of the Five Target Set:	-0.086
The Average Point of Impact of the Five Target Set:	0.119
The Average Mean Radius of the Five Target Set:	0.648
The Distance from POA to Centroid Target #1:	0.342
The Distance from Centroid Target #2 to Centroid Target #1:	0.458
The Distance from Centroid Target #3 to Centroid Target #1:	0.205
The Distance from Centroid Target #4 to Centroid Target #1:	0.349
The Distance from Centroid Target #5 to Centroid Target #1:	0.287

SERIAL NUMBER: G6590137.__1
TARGET NUMBER: 1
FILE DATE: 01/06/2009
FILE TIME: 06:29

X CENTROID:	-0.148
Y CENTROID:	-0.309
POA TO CENTROID:	0.342
HORZ SPREAD:	1.563
VERT SPREAD:	1.696
GROUP SPREAD:	1.563
MIN RADIUS:	0.075
MAX RADIUS:	0.983
MEAN RADIUS:	0.670
# IN 1 IN DIAMETER:	2
# IN 2 IN DIAMETER:	10
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	-0.419	0.589
2:	-0.388	0.375
3:	-0.188	-0.245
4:	0.351	-0.156
5:	0.200	-0.384
6:	-0.366	0.244
7:	0.505	-0.702
8:	0.372	-1.019
9:	-0.492	-1.107
10:	-1.058	-0.680

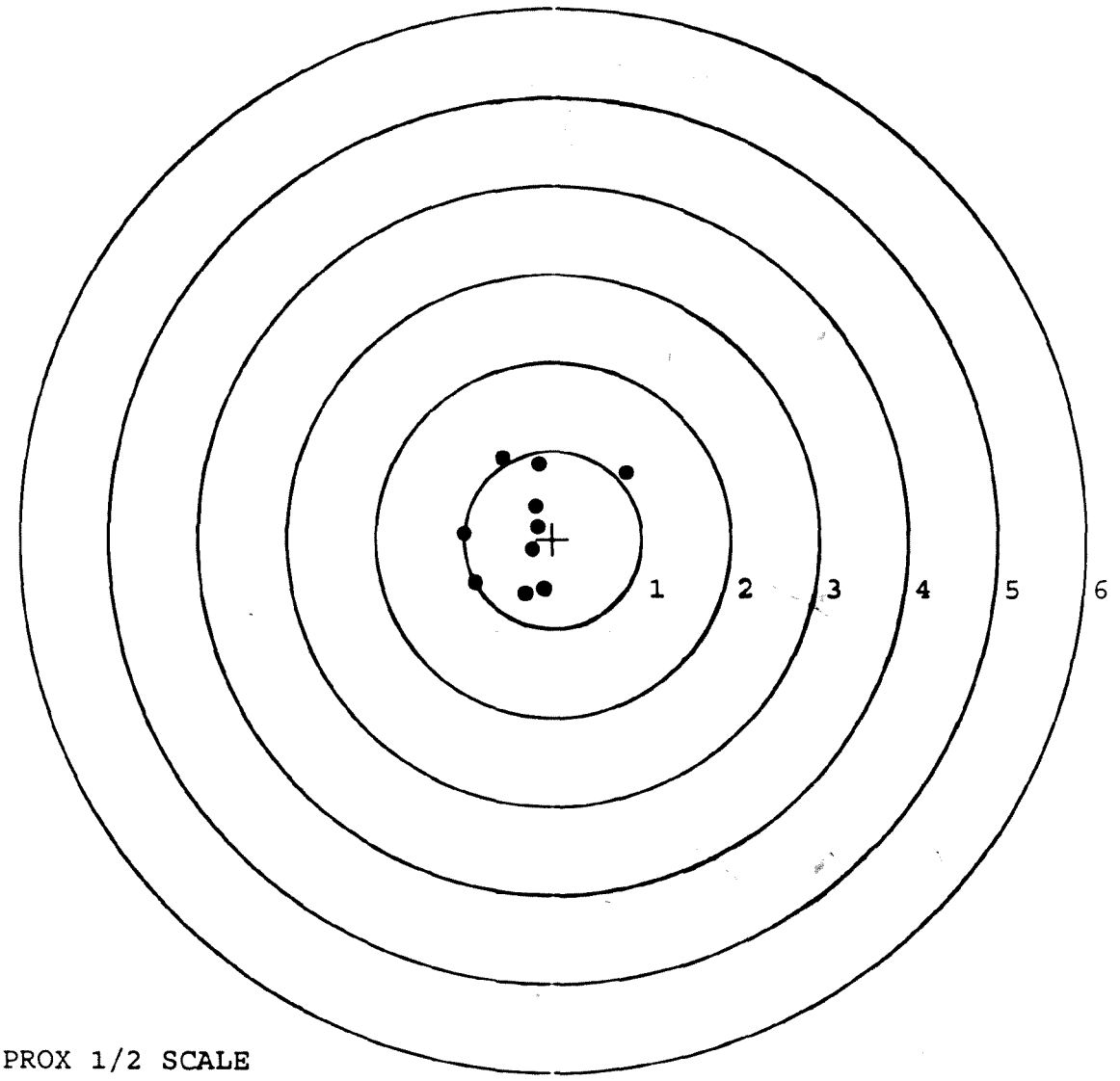


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590137.__1
TARGET NUMBER: 2
FILE DATE: 01/06/2009
FILE TIME: 06:29

X CENTROID:	-0.281
Y CENTROID:	0.130
POA TO CENTROID:	0.309
HORZ SPREAD:	1.827
VERT SPREAD:	1.540
GROUP SPREAD:	2.120
MIN RADIUS:	0.103
MAX RADIUS:	1.276
MEAN RADIUS:	0.650
# IN 1 IN DIAMETER:	3
# IN 2 IN DIAMETER:	9
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	0.831	0.755
2:	-0.166	0.850
3:	-0.571	0.923
4:	-0.200	0.368
5:	-0.178	0.134
6:	-0.233	-0.115
7:	-0.104	-0.565
8:	-0.312	-0.617
9:	-0.878	-0.500
10:	-0.996	0.063

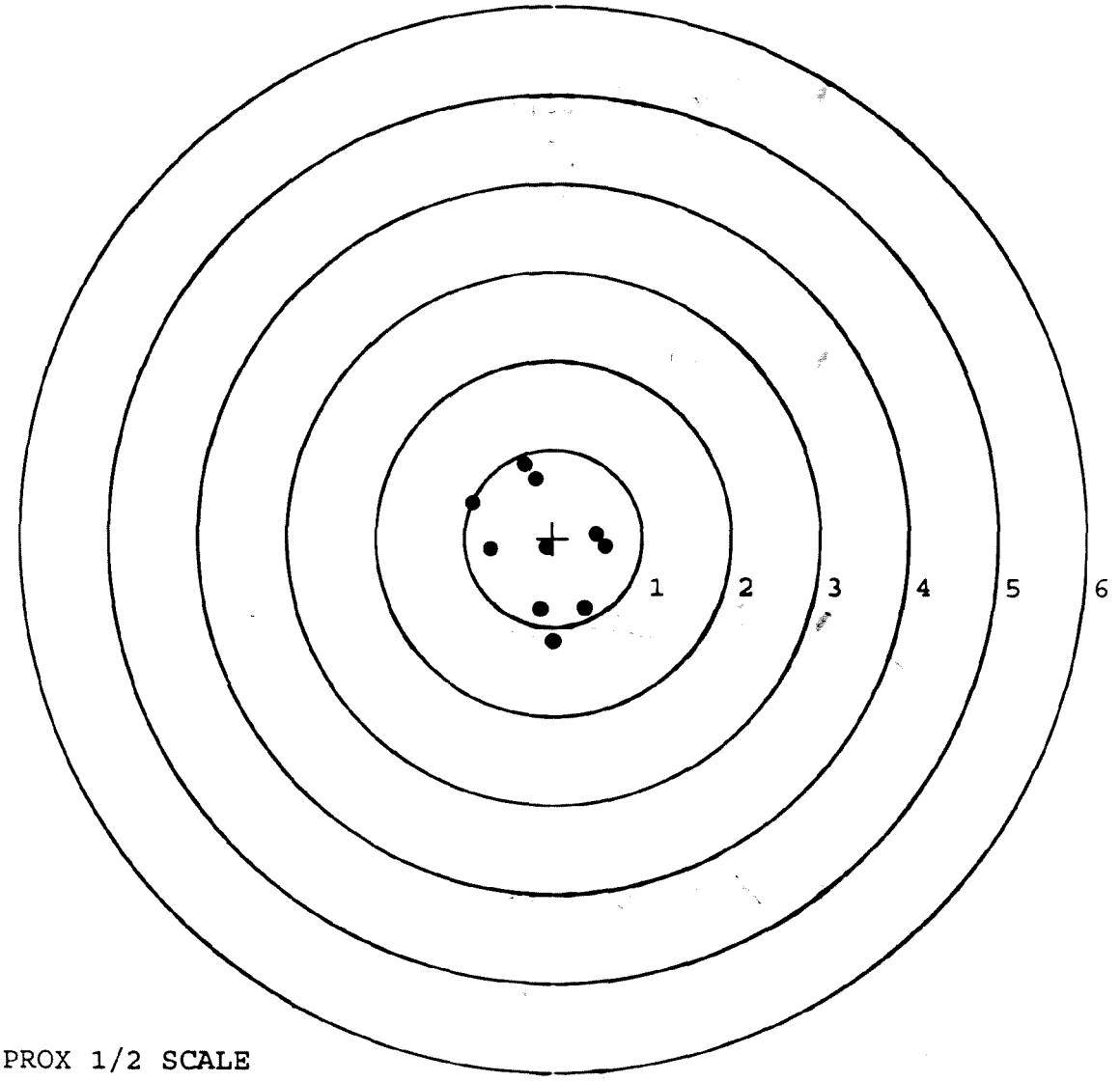


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590137.__1
TARGET NUMBER: 3
FILE DATE: 01/06/2009
FILE TIME: 06:29

X CENTROID:	-0.091
Y CENTROID:	-0.112
POA TO CENTROID:	0.144
HORZ SPREAD:	1.506
VERT SPREAD:	1.995
GROUP SPREAD:	2.020
MIN RADIUS:	0.019
MAX RADIUS:	1.054
MEAN RADIUS:	0.720
# IN 1 IN DIAMETER:	1
# IN 2 IN DIAMETER:	9
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	-0.006	-1.162
2:	-0.142	-0.800
3:	0.364	-0.787
4:	0.593	-0.095
5:	0.488	0.051
6:	-0.074	-0.104
7:	-0.700	-0.122
8:	-0.913	0.397
9:	-0.199	0.673
10:	-0.320	0.833

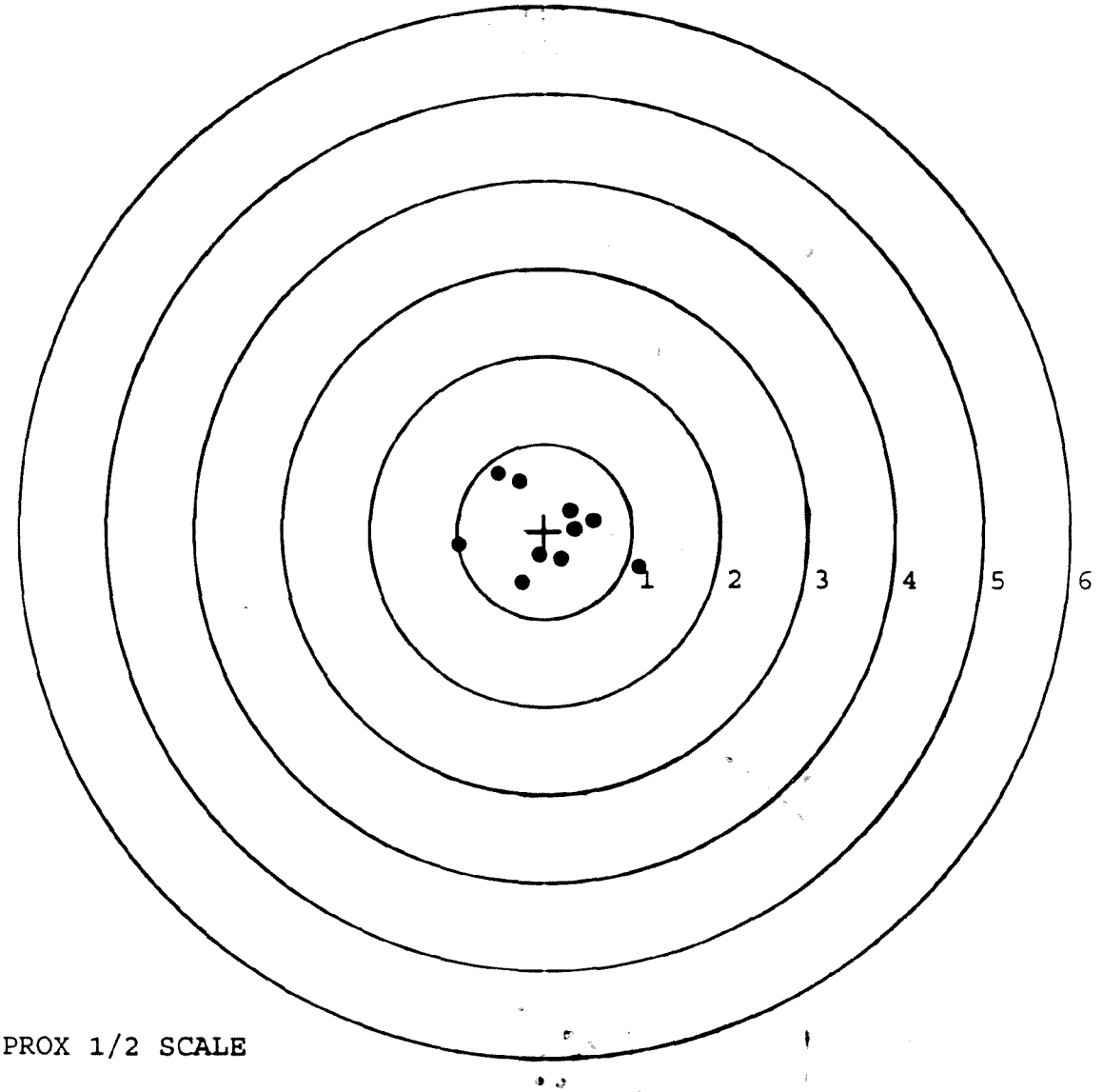


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590137.__1
TARGET NUMBER: 4
FILE DATE: 01/06/2009
FILE TIME: 06:29

X CENTROID:	0.036
Y CENTROID:	-0.012
POA TO CENTROID:	0.038
HORZ SPREAD:	2.050
VERT SPREAD:	1.247
GROUP SPREAD:	2.066
MIN RADIUS:	0.278
MAX RADIUS:	0.113
MEAN RADIUS:	0.616
# IN 1 IN DIAMETER:	4
# IN 2 IN DIAMETER:	8
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	1.075	-0.411
2:	0.560	0.124
3:	0.296	0.235
4:	0.347	0.032
5:	0.199	-0.317
6:	-0.066	-0.271
7:	-0.259	-0.588
8:	-0.975	-0.156
9:	-0.528	0.659
10:	-0.291	0.570

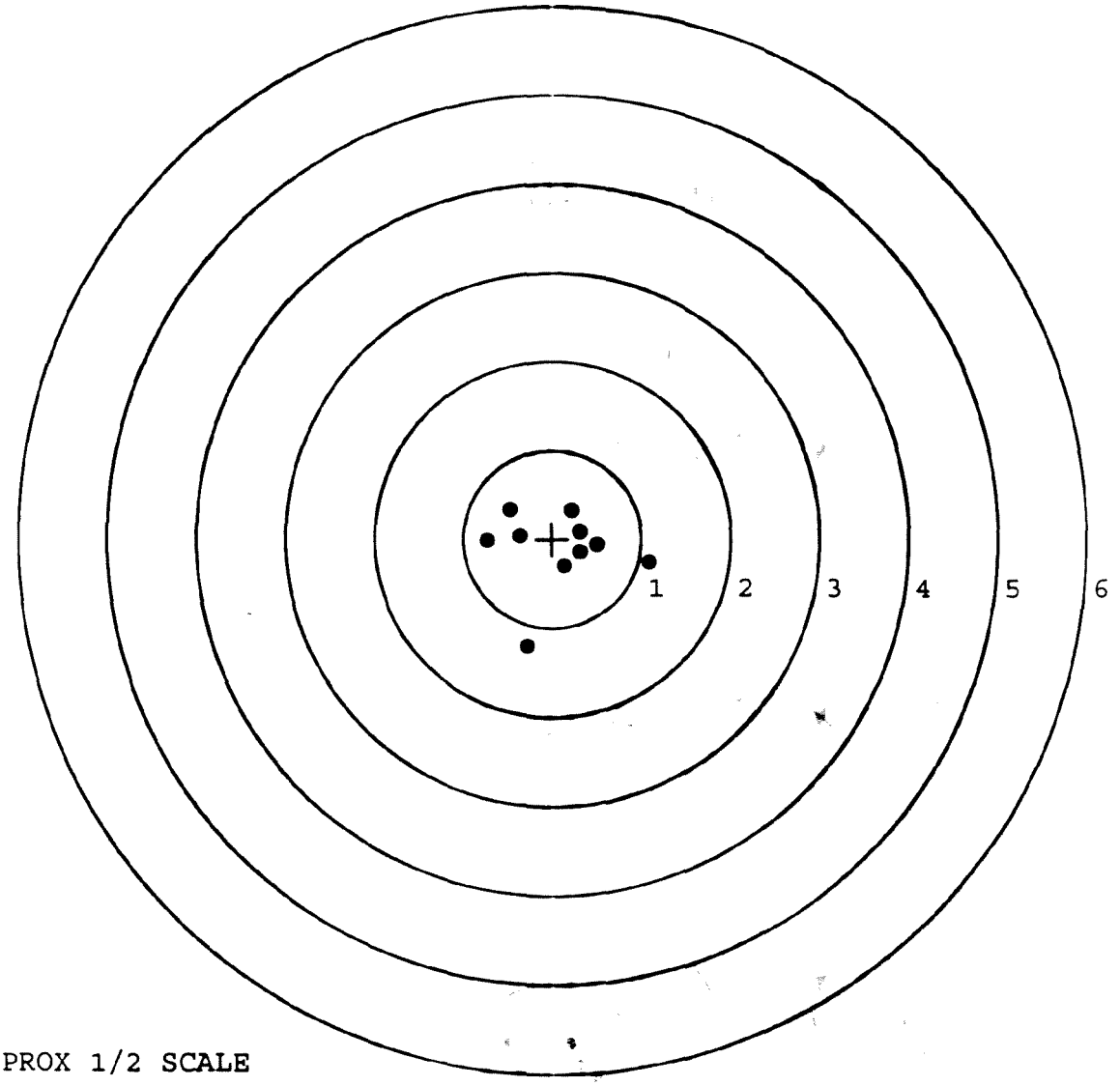


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590137.__1
TARGET NUMBER: 5
FILE DATE: 01/06/2009
FILE TIME: 06:29

X CENTROID:	0.073
Y CENTROID:	-0.126
POA TO CENTROID:	0.145
HORZ SPREAD:	1.820
VERT SPREAD:	1.536
GROUP SPREAD:	1.665
MIN RADIUS:	0.196
MAX RADIUS:	1.140
MEAN RADIUS:	0.584
# IN 1 IN DIAMETER:	6
# IN 2 IN DIAMETER:	8
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	-0.282	-1.209
2:	1.089	-0.265
3:	0.224	0.326
4:	0.317	0.084
5:	0.507	-0.068
6:	0.319	-0.153
7:	0.134	-0.312
8:	-0.479	0.327
9:	-0.365	0.039
10:	-0.731	-0.024



TARGET APPROX 1/2 SCALE

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: RE00124040 | Serial: G6285935 Model M24 SWS Center Fire | Repairman:

Verify Repair | Status: New 1/22/2007 7:15:48 AM

Address Information

Customer: (Received From)	Return To: (Received From)
Name: TRANSPORTATION DIVISION DFEL	TRANSPORTATION DIVISION DFEL
Address 1: 6759 MITCHELL AVENUE	6759 MITCHELL AVENUE
Address 2: BLDG 1836 PO Box:	BLDG 1836 PO Box:
City: FORT BENNING	FORT BENNING
State: GA Zip Code: 31905 Country: US	State: GA Zip Code: 31905 Country: US

FFL:

Contact / Condition | Problems | Estimate | History / Status | Shipping / Billing

Contact Information

Phone: NA
Fax:
Email:
Comments:

Received Condition

Fair
Condition Notes:
CSR Notes:

Accessories Received

Code	Desc	Qty
A007	With Stud	3
A010	Hard Case	1
A017	Scope Base	3
A026	Scope	1
A045	Bi Pod	1

Repair Search | Refresh | Close

nagletj | 1/22/2007 | 8:29 AM | CAPS | NUM | INS | SCRL

Start | 4 Micros... | 2 Micros... | 3 Intern... | Personal | Arms Ser... | 8:29 AM

G6590137 (New)

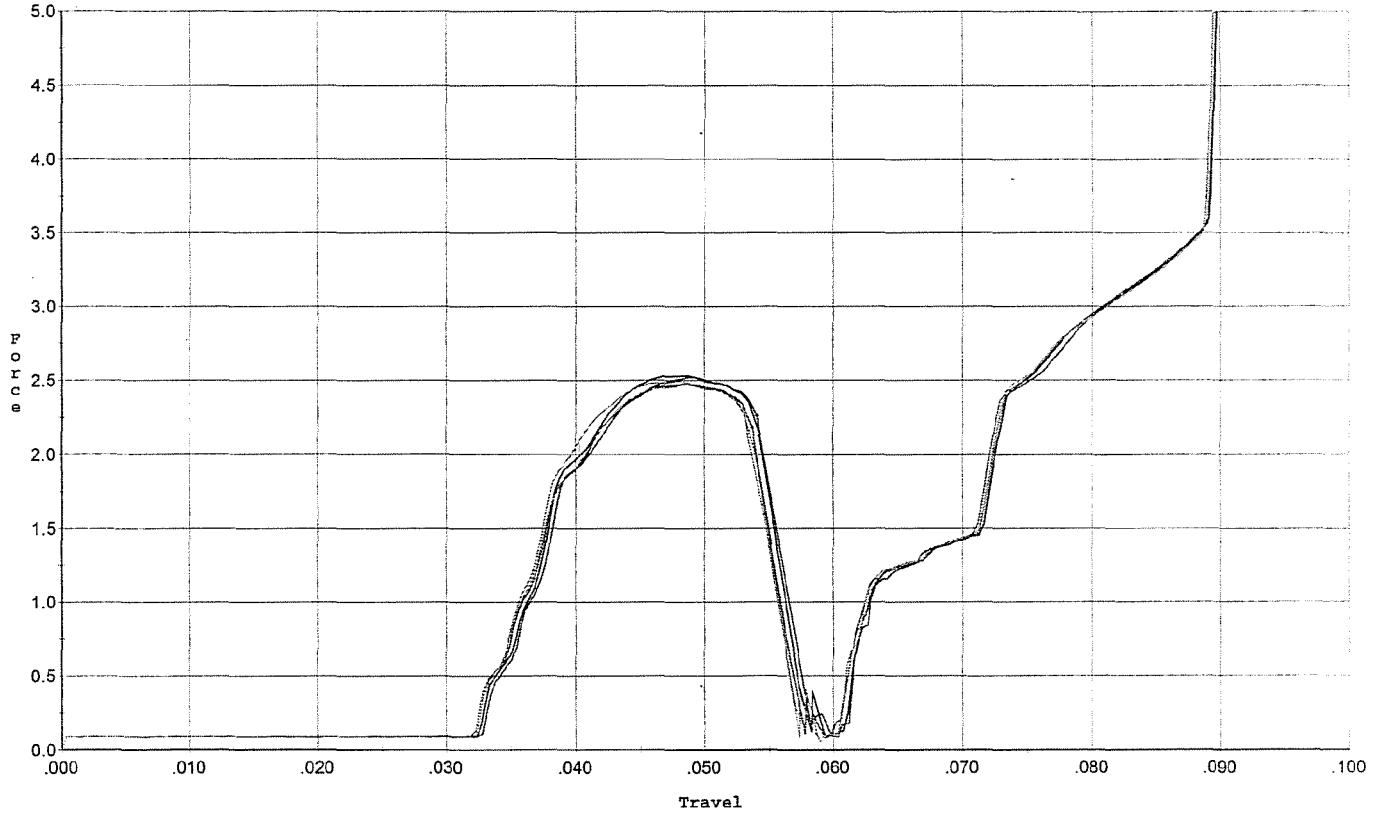
Serial Number: G6285935

Model: M24 SWS

RE00124040

Trigger Profile [lbs,inch]

Profile	SWS	**Model:**	M/24
GunType:	Rifle	**Serial No:**	Form #F005
Make:	Remington	**Trigger:**	2.5 lbs. ini. +/- .50 lbs.
Note:	R. Putch 12/21/06		



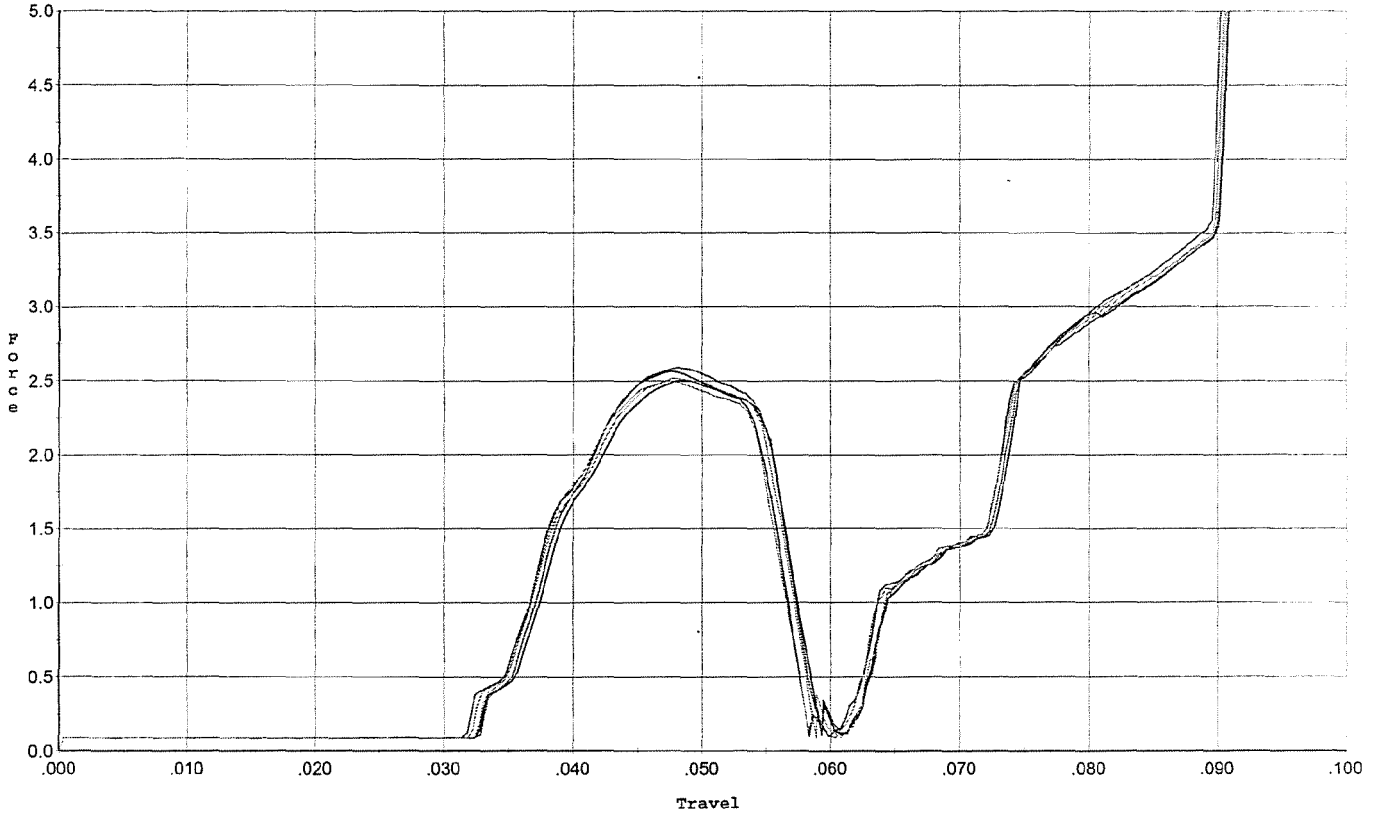
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.523	0.054	0.033	0.039	0.045		Set Trigger
2	2.532	0.054	0.033	0.039	0.046		Set Trigger
3	2.477	0.054	0.033	0.040	0.044		Set Trigger
4	2.468	0.054	0.033	0.040	0.045		Set Trigger
5	2.492	0.055	0.033	0.039	0.046		Set Trigger

Avg 2.49

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc.. 12/21/2006 7:33:19 AM

Trigger Profile [lbs,inch]

Profile	SWS	**Model:**	M/24
GunType:	Rifle	**Serial No:**	Form #F005
Make:	Remington	**Trigger:**	2.5 lbs. after 50 cycles +/- .50 lbs.
Note:	R. Putch 12/21/06		

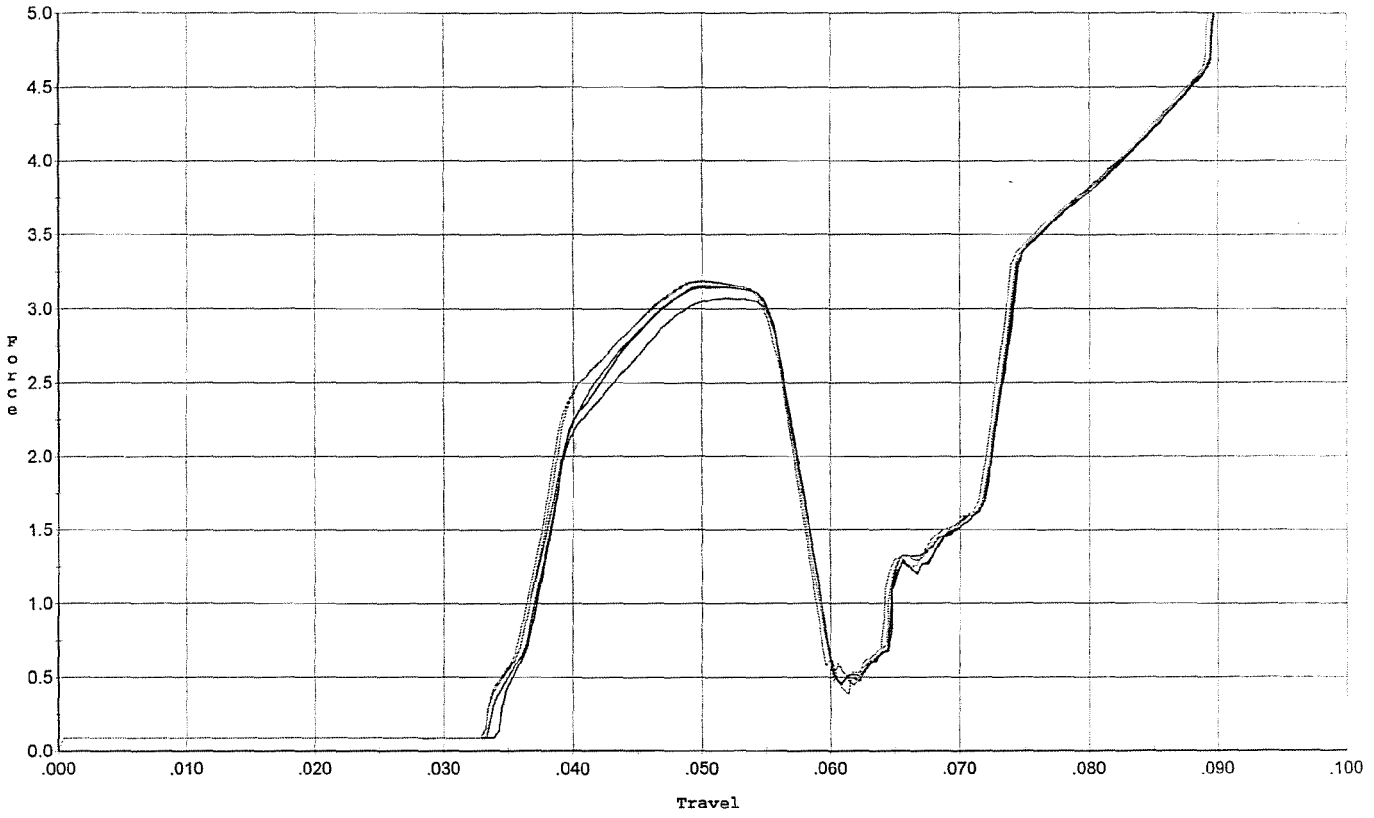


#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.567	0.055	0.032	0.039	0.047		Set Trigger
2	2.503	0.055	0.033	0.040	0.045		Set Trigger
3	2.590	0.055	0.033	0.040	0.047		Set Trigger
4	2.518	0.056	0.032	0.039	0.047		Set Trigger
5	2.499	0.056	0.033	0.040	0.046		Set Trigger

Avg 2.53

Trigger Profile [lbs,inch]

Profile	SWS	**Model:**	M/24
GunType:	Rifle	**Serial No:**	Form #F005
Make:	Remington	**Trigger:**	3.0 lbs. after 20 cycles +/- .75 lbs.
Note:	R. Putch 12/21/06		



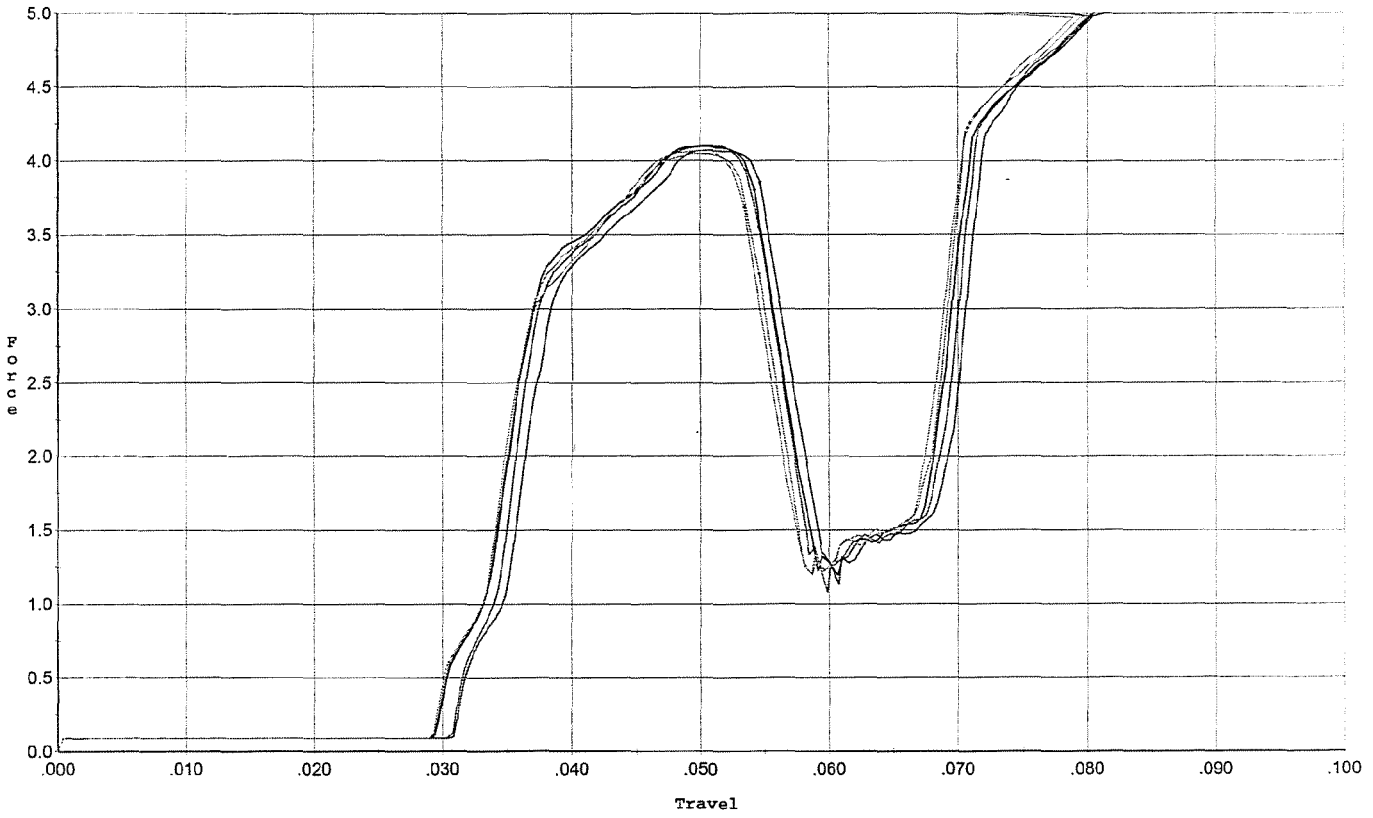
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.072	0.058	0.034	0.037	0.059		Set Trigger
2	3.145	0.058	0.035	0.037	0.060		Set Trigger
3	3.155	0.058	0.033	0.037	0.061		Set Trigger
4	3.182	0.056	0.033	0.037	0.059		Set Trigger
5	3.188	0.056	0.033	0.037	0.060		Set Trigger

Avg 3.14

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc.. 12/21/2006 9:30:47 AM

Trigger Profile [lbs,inch]

Profile	SWS	**Model:**	M/24
GunType:	Rifle	**Serial No:**	Form #F005
Make:	Remington	**Trigger:**	4.0 lbs. ini. +/- 1.0 lbs.
Note:	R. Putch 12/21/06		

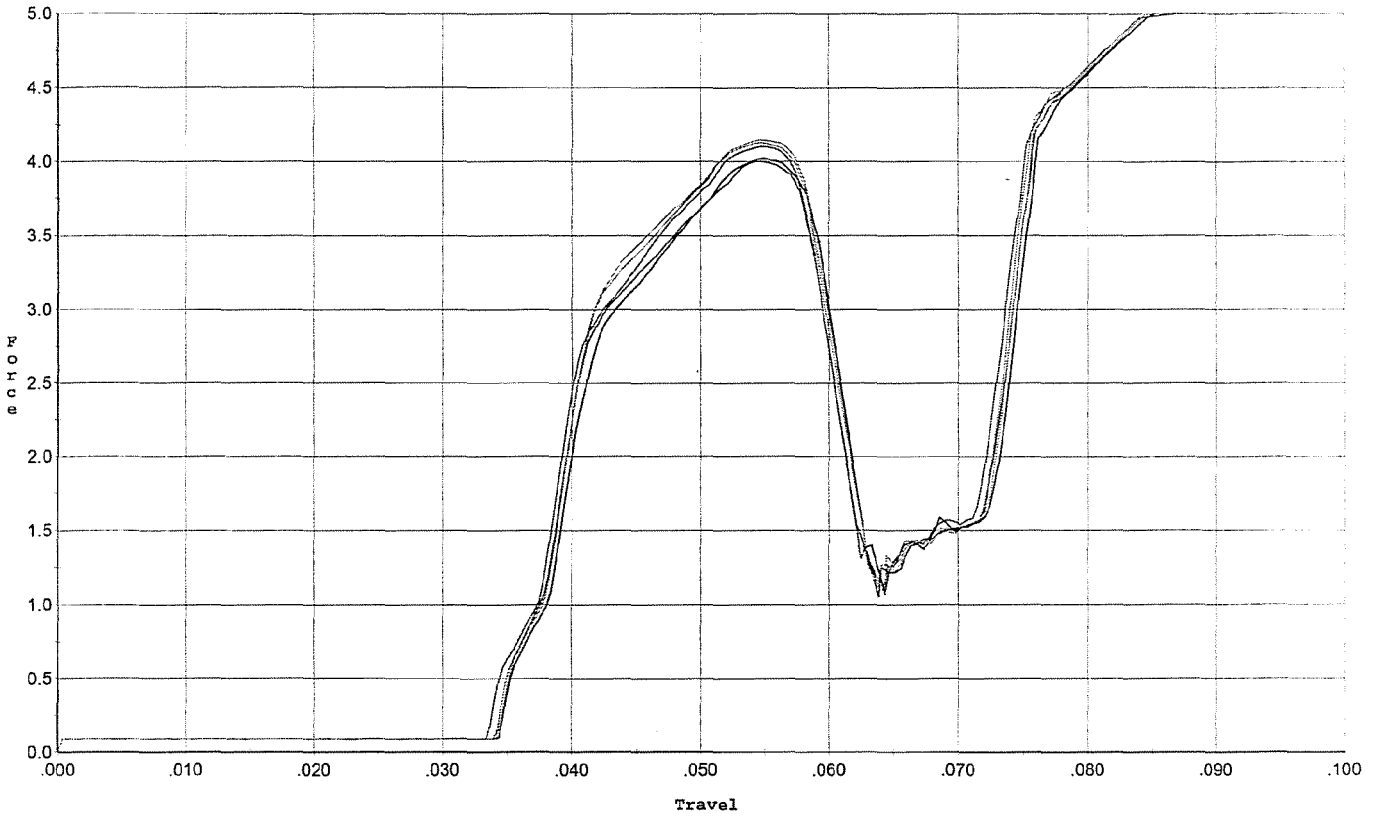


#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.070	0.055	0.031	0.034	0.078		Set Trigger
2	4.098	0.054	0.030	0.034	0.081		Set Trigger
3	4.102	0.055	0.031	0.034	0.079		Set Trigger
4	4.050	0.055	0.030	0.034	0.080		Set Trigger
5	4.068	0.053	0.030	0.034	0.077		Set Trigger

Avg 4.07

Trigger Profile [lbs,inch]

Profile	SWS	**Model:**	M/24
GunType:	Rifle	**Serial No:**	Form #F005
Make:	Remington	**Trigger:**	4.0 lbs. after 20 cycles +/- 1.0 lbs.
Note:	R. Putch 12/21/06		



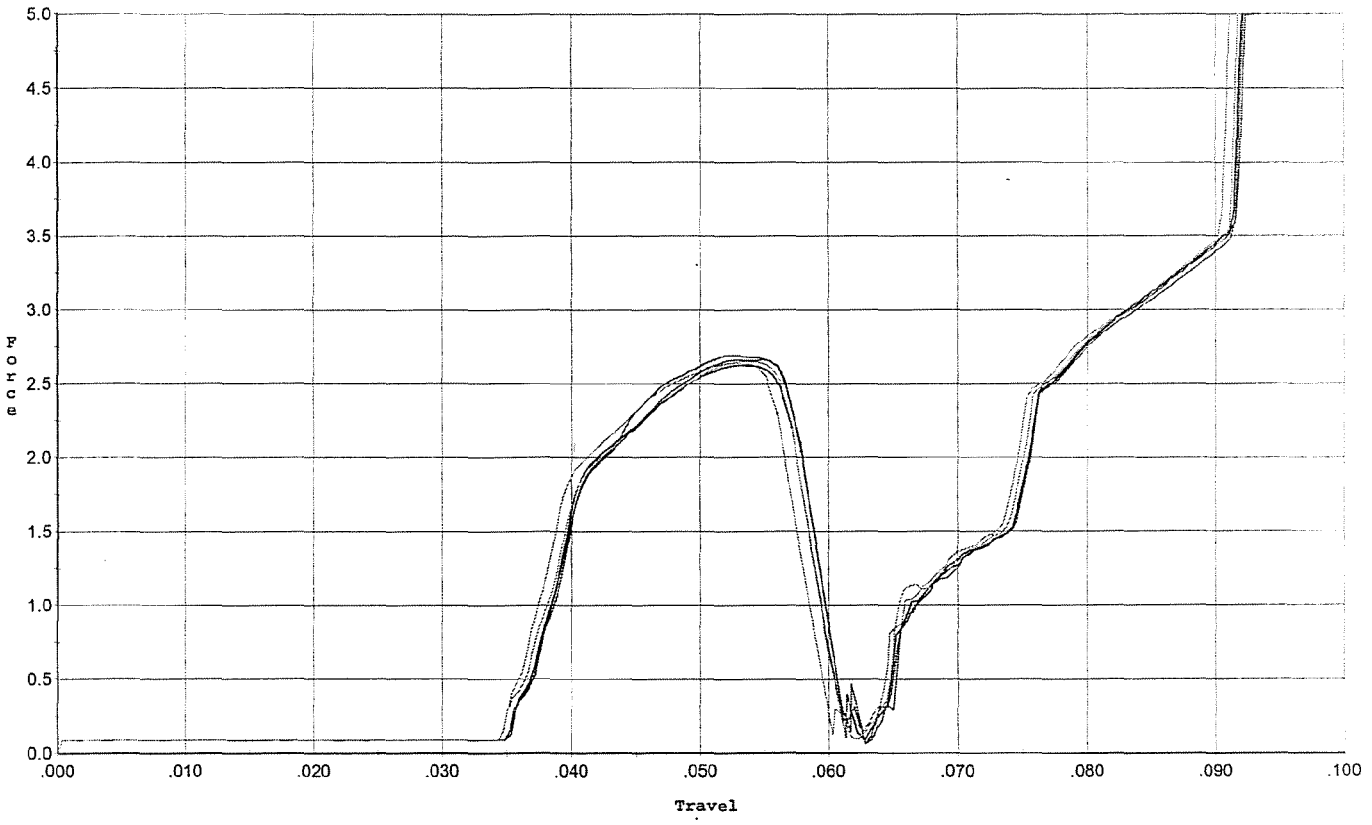
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.001	0.059	0.034	0.035	0.078		Set Trigger
2	4.023	0.059	0.035	0.035	0.078		Set Trigger
3	4.101	0.059	0.034	0.035	0.080		Set Trigger
4	4.128	0.058	0.034	0.035	0.080		Set Trigger
5	4.147	0.060	0.035	0.035	0.082		Set Trigger

4.08

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc.. 12/21/2006 9:37:04 AM

Trigger Profile [lbs,inch]

Profile	SWS	**Model:**	M/24
GunType:	Rifle	**Serial No:**	Form #F005
Make:	Remington	**Trigger:**	reset to 2.5 lbs. ini.+/- .50 lbs.
Note:	R. Putch 12/21/06		



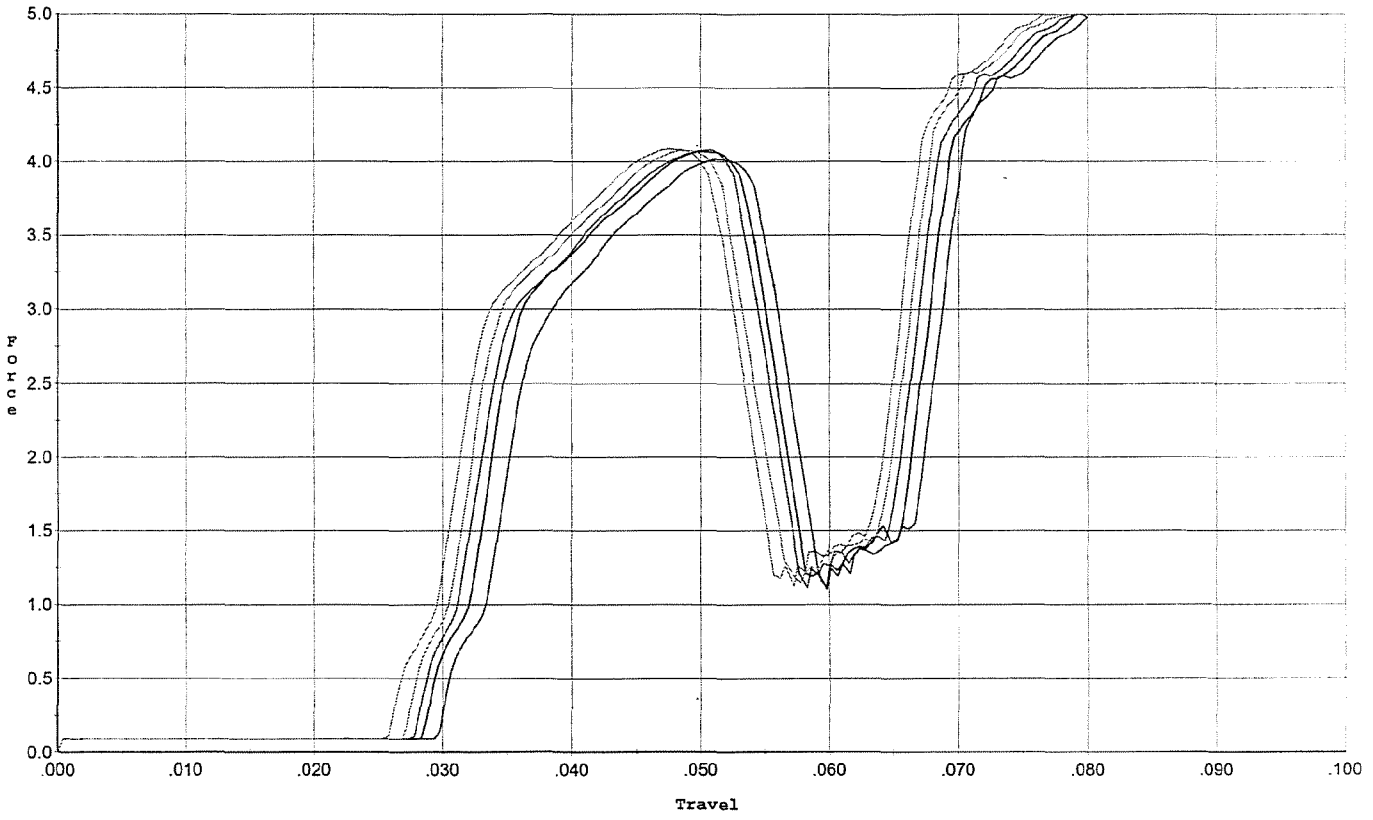
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.692	0.058	0.035	0.039	0.051		Set Trigger
2	2.625	0.057	0.036	0.039	0.049		Set Trigger
3	2.664	0.058	0.036	0.039	0.050		Set Trigger
4	2.650	0.057	0.035	0.039	0.049		Set Trigger
5	2.639	0.056	0.035	0.039	0.048		Set Trigger

Avg 2.65

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc.. 12/21/2006 9:51:10 AM

Trigger Profile [lbs,inch]

Profile	SWS	**Model:**	M/24
GunType:	Rifle	**Serial No:**	Form #F005
Make:	Remington	**Trigger:**	set to 4.0 lbs. +/- 1.0 lbs.
Note:	R. Putch 12/21/06		



#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.014	0.056	0.030	0.033	0.081		Set Trigger
2	4.067	0.054	0.029	0.033	0.082		Set Trigger
3	4.079	0.054	0.028	0.032	0.083		Set Trigger
4	4.075	0.052	0.027	0.032	0.079		Set Trigger
5	4.084	0.052	0.026	0.031	0.082		Set Trigger

Avg 4.06

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFOMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6590137.__0
FILE DATE AND TIME: 02/01/2007 23:27

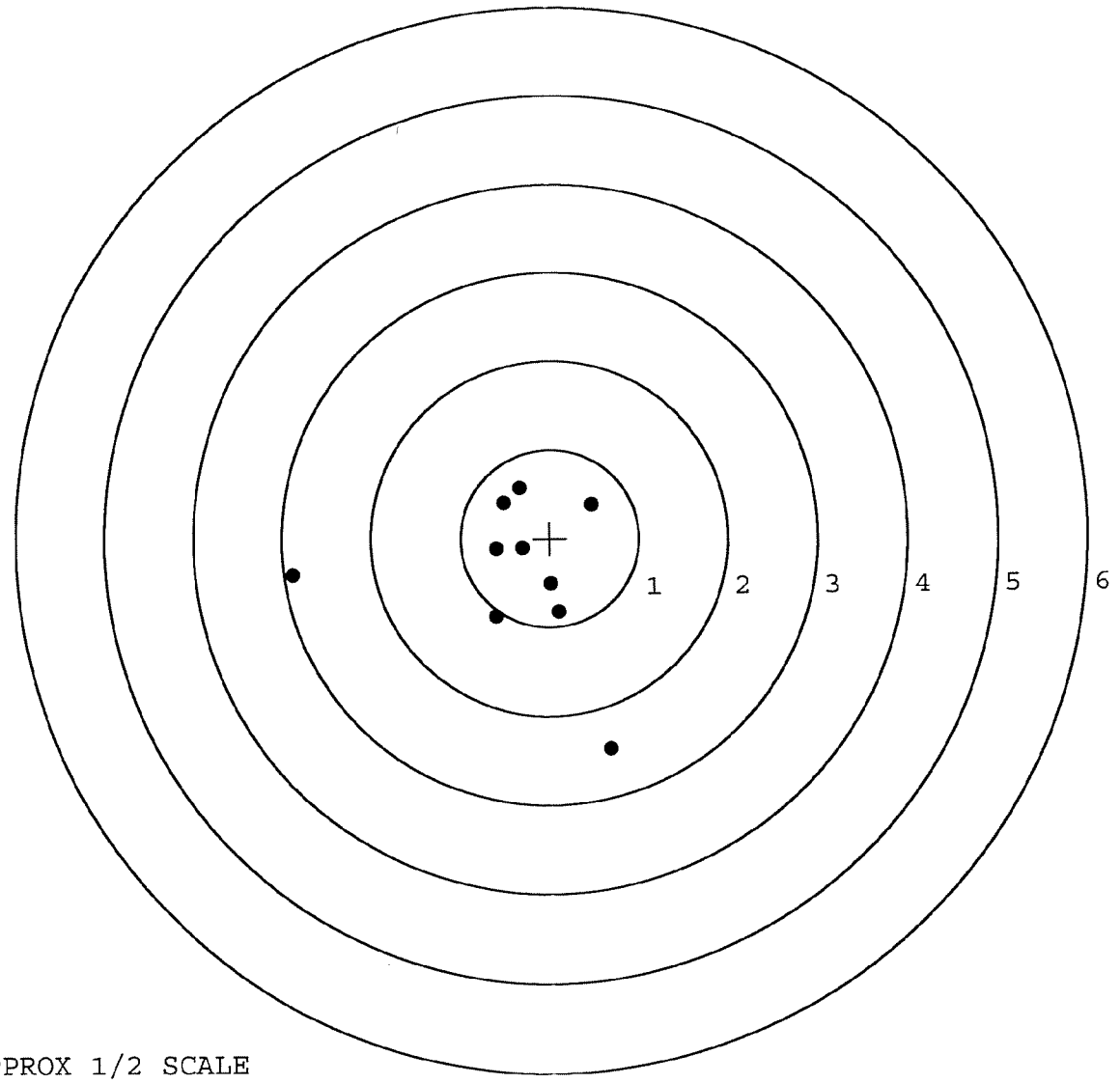
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.197
The Average Y Centroid of the Five Target Set:	0.074
The Average Point of Impact of the Five Target Set:	0.210
The Average Mean Radius of the Five Target Set:	1.008
The Distance from POA to Centroid Target #1:	0.559
The Distance from Centroid Target #2 to Centroid Target #1:	0.768
The Distance from Centroid Target #3 to Centroid Target #1:	0.757
The Distance from Centroid Target #4 to Centroid Target #1:	0.697
The Distance from Centroid Target #5 to Centroid Target #1:	0.592

SERIAL NUMBER: G6590137.__0
TARGET NUMBER: 1
FILE DATE: 02/01/2007
FILE TIME: 23:27

X CENTROID:	-0.402
Y CENTROID:	-0.388
POA TO CENTROID:	0.559
HORZ SPREAD:	3.548
VERT SPREAD:	2.948
GROUP SPREAD:	4.065
MIN RADIUS:	0.291
MAX RADIUS:	2.476
MEAN RADIUS:	0.993
# IN 1 IN DIAMETER:	3
# IN 2 IN DIAMETER:	7
# in 3 IN DIAMETER:	8

POINT#	X	Y
1:	-0.340	0.569
2:	-0.518	0.402
3:	-0.312	-0.112
4:	-0.605	-0.114
5:	0.470	0.379
6:	0.012	-0.514
7:	0.095	-0.839
8:	-0.611	-0.881
9:	-2.878	-0.395
10:	0.670	-2.379

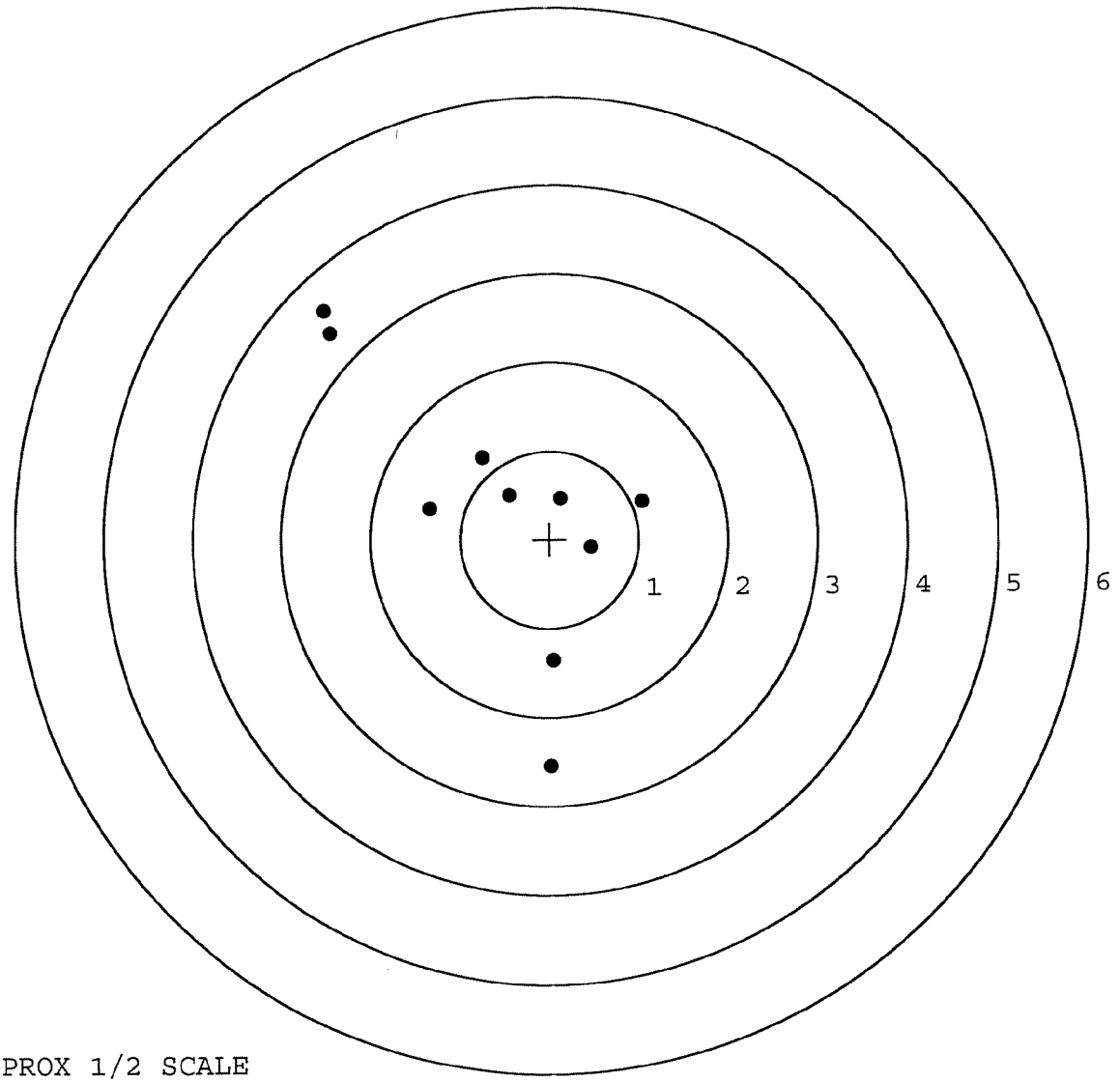


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590137.__0
TARGET NUMBER: 2
FILE DATE: 02/01/2007
FILE TIME: 23:27

X CENTROID:	-0.581
Y CENTROID:	0.359
POA TO CENTROID:	0.683
HORZ SPREAD:	3.535
VERT SPREAD:	5.145
GROUP SPREAD:	5.720
MIN RADIUS:	0.197
MAX RADIUS:	2.973
MEAN RADIUS:	1.548
# IN 1 IN DIAMETER:	1
# IN 2 IN DIAMETER:	4
# in 3 IN DIAMETER:	5

POINT#	X	Y
1:	-0.751	0.927
2:	-0.450	0.506
3:	-1.339	0.359
4:	0.125	0.465
5:	1.034	0.421
6:	0.466	-0.098
7:	0.040	-1.363
8:	-0.002	-2.557
9:	-2.435	2.338
10:	-2.501	2.588

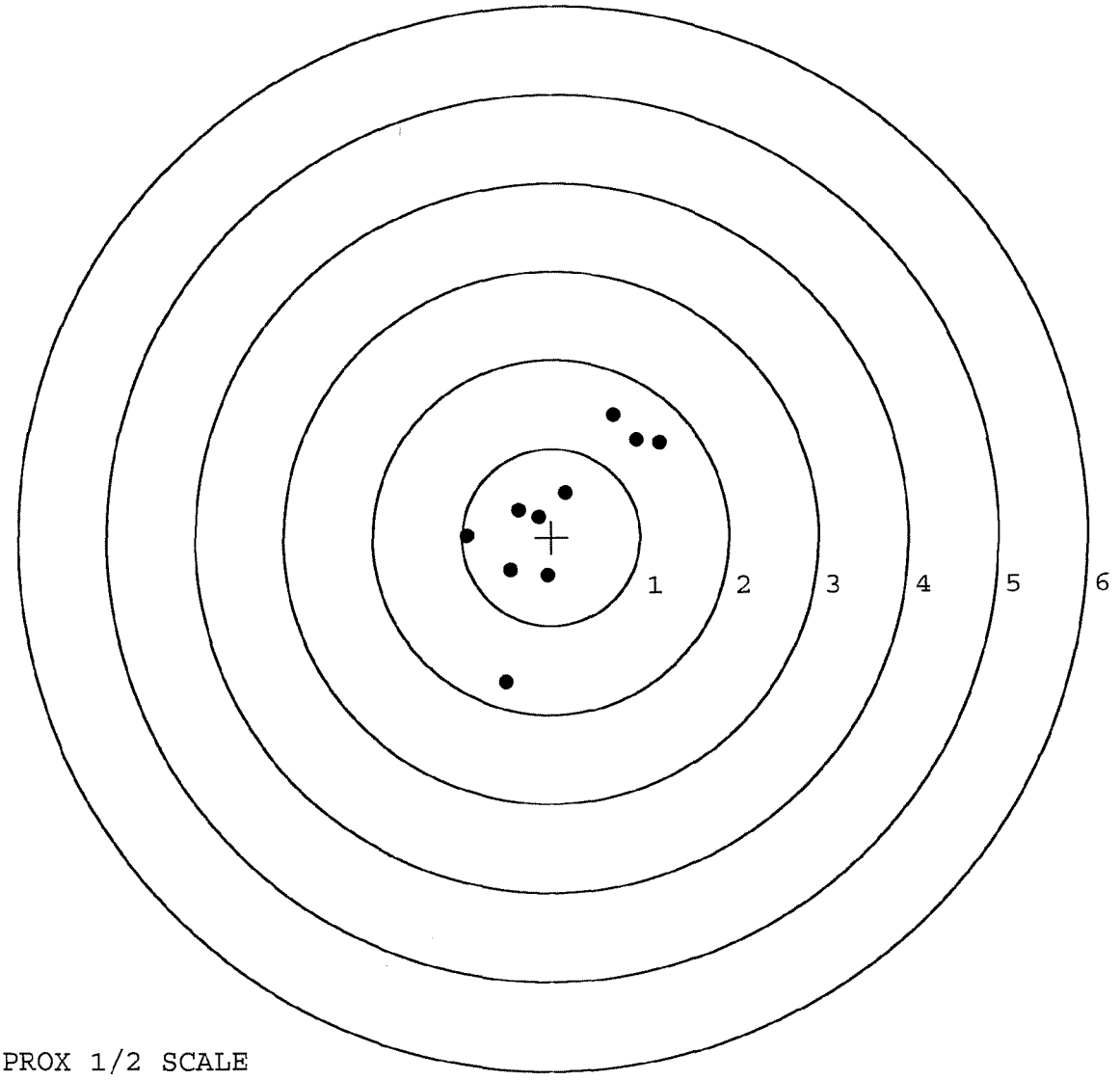


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590137.__0
TARGET NUMBER: 3
FILE DATE: 02/01/2007
FILE TIME: 23:27

X CENTROID:	0.056
Y CENTROID:	0.214
POA TO CENTROID:	0.221
HORZ SPREAD:	2.170
VERT SPREAD:	3.016
GROUP SPREAD:	3.248
MIN RADIUS:	0.200
MAX RADIUS:	1.939
MEAN RADIUS:	0.939
# IN 1 IN DIAMETER:	3
# IN 2 IN DIAMETER:	5
# in 3 IN DIAMETER:	9

POINT#	X	Y
1:	-0.144	0.227
2:	-0.373	0.310
3:	0.163	0.506
4:	0.694	1.376
5:	0.960	1.098
6:	1.220	1.066
7:	-0.045	-0.436
8:	-0.457	-0.380
9:	-0.950	0.015
10:	-0.511	-1.640

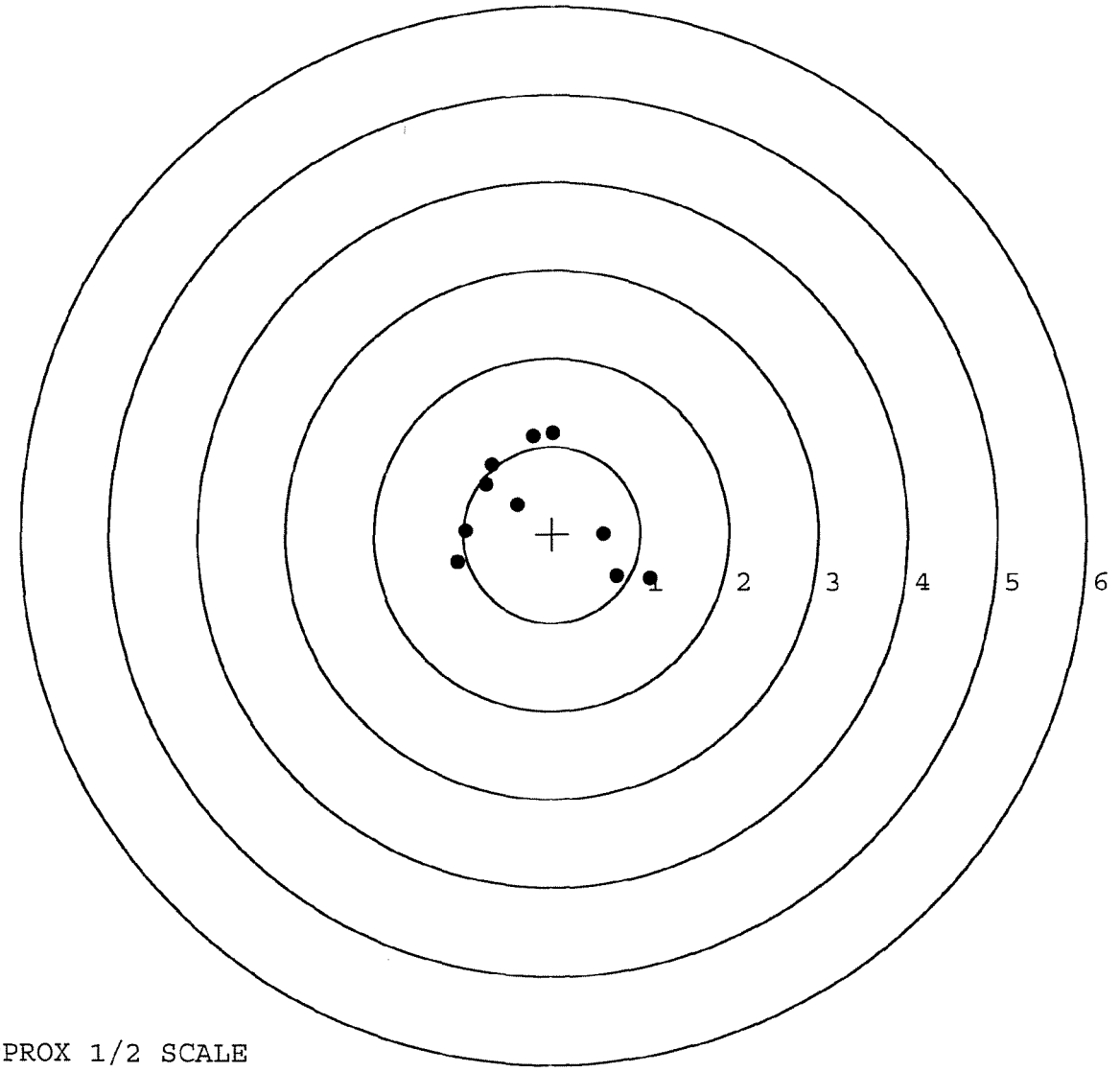


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590137.__0
TARGET NUMBER: 4
FILE DATE: 02/01/2007
FILE TIME: 23:27

X CENTROID:	-0.164
Y CENTROID:	0.267
POA TO CENTROID:	0.313
HORZ SPREAD:	2.173
VERT SPREAD:	1.663
GROUP SPREAD:	2.220
MIN RADIUS:	0.235
MAX RADIUS:	1.495
MEAN RADIUS:	0.875
# IN 1 IN DIAMETER:	1
# IN 2 IN DIAMETER:	7
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	-0.388	0.336
2:	-0.745	0.565
3:	-0.685	0.790
4:	-0.975	0.034
5:	-1.061	-0.321
6:	-0.214	1.120
7:	0.012	1.150
8:	0.576	-0.006
9:	0.730	-0.484
10:	1.112	-0.513

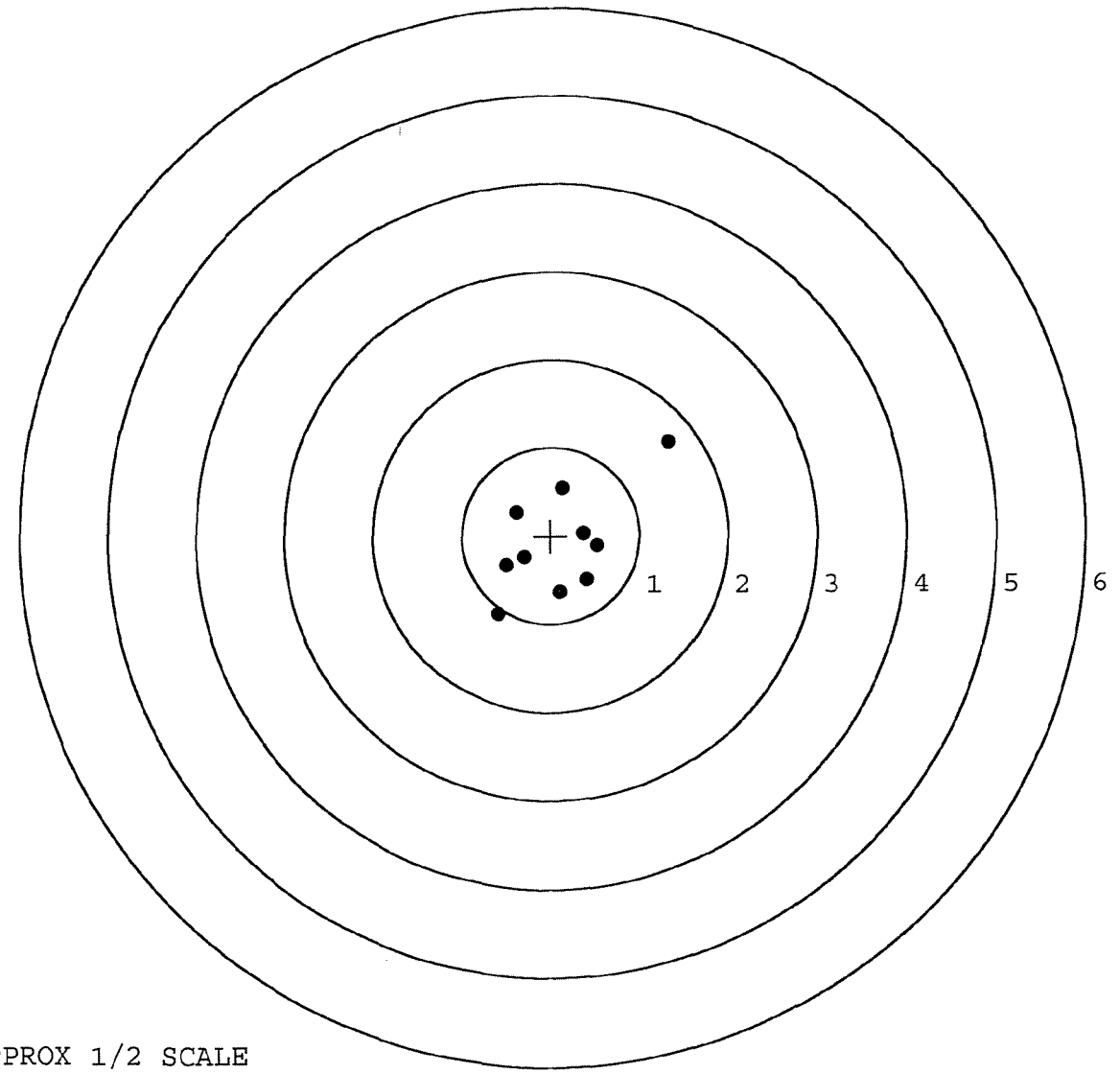


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590137.__0
TARGET NUMBER: 5
FILE DATE: 02/01/2007
FILE TIME: 23:27

X CENTROID:	0.106
Y CENTROID:	-0.084
POA TO CENTROID:	0.135
HORZ SPREAD:	1.930
VERT SPREAD:	1.946
GROUP SPREAD:	2.741
MIN RADIUS:	0.282
MAX RADIUS:	1.676
MEAN RADIUS:	0.684
# IN 1 IN DIAMETER:	3
# IN 2 IN DIAMETER:	8
# in 3 IN DIAMETER:	9

POINT#	X	Y
1:	-0.393	0.260
2:	0.129	0.538
3:	1.332	1.058
4:	0.522	-0.112
5:	0.102	-0.642
6:	-0.598	-0.888
7:	-0.501	-0.338
8:	-0.299	-0.244
9:	0.400	-0.504
10:	0.362	0.033



TARGET APPROX 1/2 SCALE

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

R & E NUMBER	124040				
SERIAL NUMBER	~~C628593~~	G659D137 (New)			
LOG-IN DATE	1-22-07				

OPERATION #	OPERATION NAME			DATE	INITIAL
500	DIS-ASSEMBLE GUN			1-22-07	RTL
505	RE-BARREL			1-24-07	RTL
420	ASSEMBLE			1-24-07	RTL
440	PROOF	MAGNA-FLUX INSPECTED JAN 29 2007		1-25-07	TRW
460	CHECK HEADSPACE			1-25-07	TRW
470	DIS-ASSEMBLE GUN			1-25-07	RTL
480	MAGNAFLUX	OPERATOR APD		1-29-07	APD
510	DRILL AND TAP			1-26-07	TRW
500	ROLLMARK CALIBER			1-29-07	CW
520	GOFF BLAST BBL / REC			1-29-07	LB
530 & 540	APPLY COATINGS			1-29-07	WJ
560	FINAL ASSEMBLY			1-31-07	RTL
640	FUNCTION TEST AND	(PASS)	FAIL	2/1/07	mon
650	TARGET	(PASS)	FAIL	2/1/07	mon
	MALFUNCTION	CORRECTION			
	MALFUNCTION	CORRECTION	N/A		
	MALFUNCTION	CORRECTION			
	MALFUNCTION	CORRECTION			
670	FINAL INSPECTION			2-16-07	RTL
	A) HEADSPACE	(PASS)	FAIL	2-16-07	RTL
	B) TRIGGER PULL (+/- .5 LBS, MIN 2.50 LBS, MAX 4.0 LBS)	2.80 2.76 2.78 2.80 2.79		2-9-07	FM
680	F) SAFETY ON FORCE (2 LBS MIN, 10 LBS MAX)	7.0 6.75 6.75		2-9-07	TRW
	G) SAFETY OFF FORCE (2 LBS MIN)	2.75 2.75 2.5		2-9-07	TRW
	I) FIRING PIN INDENT (.020)	.0245 .0245 .025		2-9-07	TRW
690	PACK			2-16-07	RTL

F006 REV 5/2006

FINAL INSPECTION CHECKLIST

BARREL ASSEMBLY

_____ BARREL

_____ RECEIVER

_____ FRONT SIGHT BASE

_____ REAR SIGHT BASE

_____ SCREWS

_____ FINISH

SCOPE ASSEMBLY

_____ SCOPE

_____ SCOPE RINGS

_____ MOUNTING SCREWS

_____ MOUNTING BASE

_____ SCREWS

_____ FINISH

_____ CLARITY

STOCK ASSEMBLY

_____ STOCK

_____ SLING SWIVEL STUDS

_____

_____ BUTT PATE

_____ LOCK NUTS

_____ BARREL CLEARANCE

_____ COLOR / FINISH

SYSTEM CASE

_____ SCOPE CASE

_____ IRON SIGHTS

_____ DEPLOYMENT KIT

TRIGGER ASSEMBLY

_____ SAFETY OPERATION

_____ RE-SET TO FACTORY SPECS

COMMENTS: _____

F006 REV 5/2006

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: **RE00073081**

Verify Repair

Serial: C6498753 Model 700 Center Fire Caliber: 7
62 NATO M24 SWS

Repairman:

Status: Closed 11/17/2003 8:51:29 AM

Address Information

	Customer: (•) Received From	Return To: ( ) Received From
Name:	TRANSPORTATION DIV DFEL	TRANSPORTATION DIV DFEL
Address 1:	WAREHOUSE BLDG 280	WAREHOUSE BLDG 280
Address 2:	6701 TRANSPORTATION AVE — PO Box:	6701 TRANSPORTATION AVE — PO Box:
City:	FORT BENNING	FORT BENNING
State:	GA — Zip Code: 31905 — Country: US	GA — Zip Code: 31905 — Country: US

FFL:

Contact / Condition | Problems | Estimate | History / Status | Shipping / Billing

Contact Information

Phone:

Fax:

Email:

Comments:

Received Condition

Fair

Condition Notes:

CSR Notes:

Accessories Received

Code	Desc	Qty
A007	With Studs	3
A017	F/R Scope Bases	2
A026	Scope / w/base	1

Repair Search **Refresh** **Close**

nagletj | 11/17/2003 | 9:01 AM | CAPS | NUM | INS | SCRL

start | 2 Micros... | My Explo... | Arms Serv... | 3 Micros... | 3½ Flopp... | CATT MSL... | 9:01 AM

~~G6300604~~ G6285935

Serial Number: ~~C6498753~~

Model: 700

RE00073081

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

M2400165361

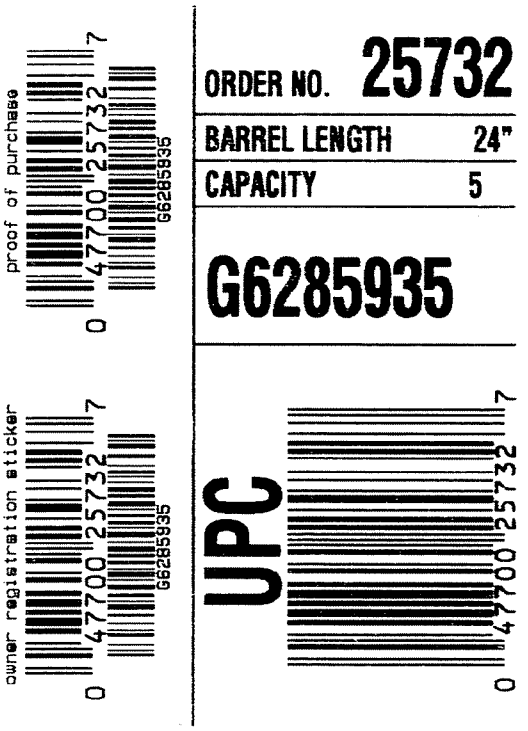
M-24 INSPECTION CHECKLIST
CONTRACT #: DAAE-20-02-D-0127

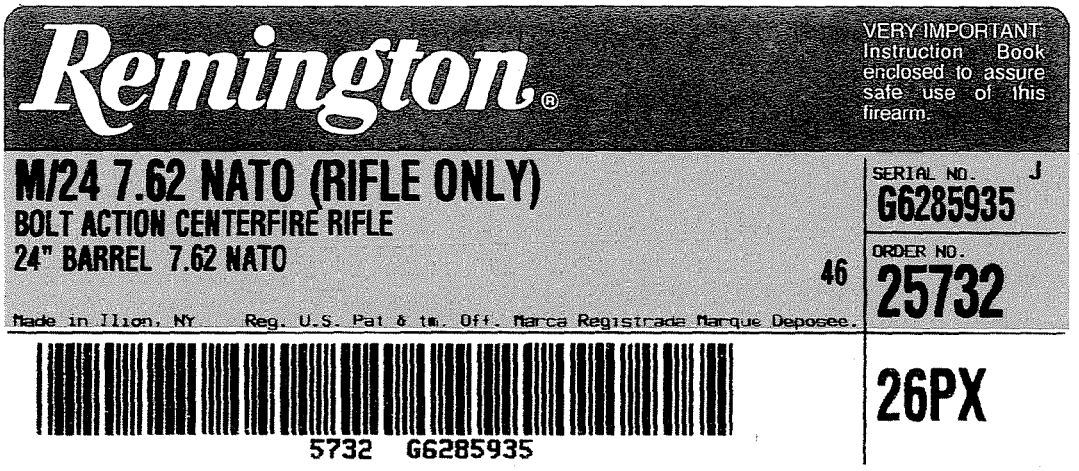
R & E NUMBER	073081		
SERIAL NUMBER	~~C6498753~~ ~~C6498804~~	G6285935	
LOG-IN DATE	11-17-03		
INSPECT AND VERIFY:			
OPERATION #	OPERATION NAME	DATE	INITIAL
550	DIS-ASSEMBLE GUN	12-16-03	RW
560 A	RE-BARREL		
B	DRILL AND TAP		
575	ASSEMBLE		
600	PROOF		
605	CHECK HEADSPACE		
610	DIS-ASSEMBLE GUN		
612	MAGNAFLUX		
615	ROLLMARK CALIBER		
618	ROTO-BLAST		
620	APPLY COATINGS		
625 A	FINAL ASSEMBLY		
B	TRIGGER PULL TEST		
C	SAFETY "ON" FORCE		
D	SAFETY "OFF" FORCE		
E	FIRING PIN INDENT		
640	TARGET	12-19-03	RW
655	FINAL INSPECT	12-22-03	RTC
660	PACK	12/22/03	DA
		SHIP DATE	
	QAR INSPECTION DATE		

M/24 7.62 NATO (RIFLE ONLY)
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO

– INSTUCTION BOOK 3518

46 FORM 200348




Remington®
VERY IMPORTANT
Instruction Book
enclosed to assure
safe use of this
firearm.
M/24 7.62 NATO (RIFLE ONLY)
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO
46
SERIAL NO. J
G6285935
ORDER NO.
25732
Made in Ilion, NY Reg. U.S. Pat & tm. Off. Marca Registrada Marque Deposee.
5732 G6285935
26PX

INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G628 5935

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		11-14-02	RL
600	PROOF		11-18-02	
607	CHECK HEADSPACE	MAGNA-FLUX INSPECTED	11-18-02	
610	DIS-ASSEMBLE GUN		11-19-02	RL
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	NOV 2002 OPERATOR RL		
615	ROLLMARK CALIBER		11-22-02	SB
617	DRILL AND TAP SIGHT HOLES		11-22-02	TRW
620	APPLY COATINGS (BARREL ACTION)		12-5	TA
	(BOLT)		12-5	TA
625	FINAL ASSEMBLY A) CLEAN INSIDE OF BOLT ASSEMBLY		5-21-03	RW
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		5-21-03	RW
	C) INSPECT EJECTOR HOLE FOR CHAMFER		5-21-03	RW
	D) OIL FIRING PIN ASSEMBLY		5-21-03	RW
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS		6-3-02	TRW

OP #	OPERATION NAME	READINGS	DATE	INITIAL
625	F) SAFETY ON FORCE [2 LBS MIN 10 LBS MAX]	8.75 8.5 8.0	6-2-03	TRW
CONT.	G) SAFETY OFF FORCE [2 LBS MIN]	2.25 2.75 2.75	6-2-03	TRW
	H) TRIGGER PULL TEST AND RETAINABILITY		6-2-03	RTL
	I) FIRING PIN INDENT [.020 MIN]	.022⁵ .023 .022	6-2-03	TRW
	J) ASSEMBLE STOCK		5-21-03	RW
	K) ASSEMBLE SWIVEL STUDS		6-25-03	RTL
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		6-25-03	RTL
	M) IRON SIGHT ALIGNMENT		6-25-03	RTL
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		6-25-03	RTL
640	GALLERY TEST AND TARGET	PASS FAIL	5-22-03	TRW
	MALFUNCTION	CORRECTION	5-22-03	TRW
	MALFUNCTION	CORRECTION	5-22-03	TRW
	MALFUNCTION	CORRECTION	5-22-03	TRW
	MALFUNCTION	CORRECTION	5-22-03	TRW
645	INSPECT FOR LIVE AMMO		5-22-03	TRW
655	FINAL INSPECTION A) HEADSPACE		6-25-03	RTL
	B) TRIGGER PULL [+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS]	2.85 2.88 2.90 2.81 2.87	6-2-03	TRW
	C) FUNCTION		6-25-03	RTL
660	PACK		6-27-03	DA

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

SERIAL NO. _____

DATE 12-6-02

TESTER TRW

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.64	2.45		2.39	MIN. SETTING,
PULL #2	2.56	2.42		2.51	NO AVG. OF 5
PULL #3	2.57	2.37		2.55	READINGS ACCEPT
PULL #4	2.65	2.41		2.51	ABLE LESS THAN
PULL #5	2.59	2.60		2.53	
TOTAL	13.01	12.25		12.49	
AVG.	2.60	2.45		2.49	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.16	3.05		
PULL #2	3.15	3.08		
PULL #3	3.11	3.07		
PULL #4	3.18	3.11		
PULL #5	3.18	3.16		
TOTAL	15.78	15.47		
AVG.	3.15	3.09		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# F TARGET & ACCU
PULL #1	4.22	4.05		4.08
PULL #2	4.17	4.07		4.09
PULL #3	4.15	4.05		4.11
PULL #4	4.11 TRW	4.07		4.09
PULL #5	4.17	4.06		4.10
TOTAL	20.82	20.30		20.47
AVG.	4.16	4.06		4.09

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFOMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6285935.__0
FILE DATE AND TIME: 05/22/2003 06:14

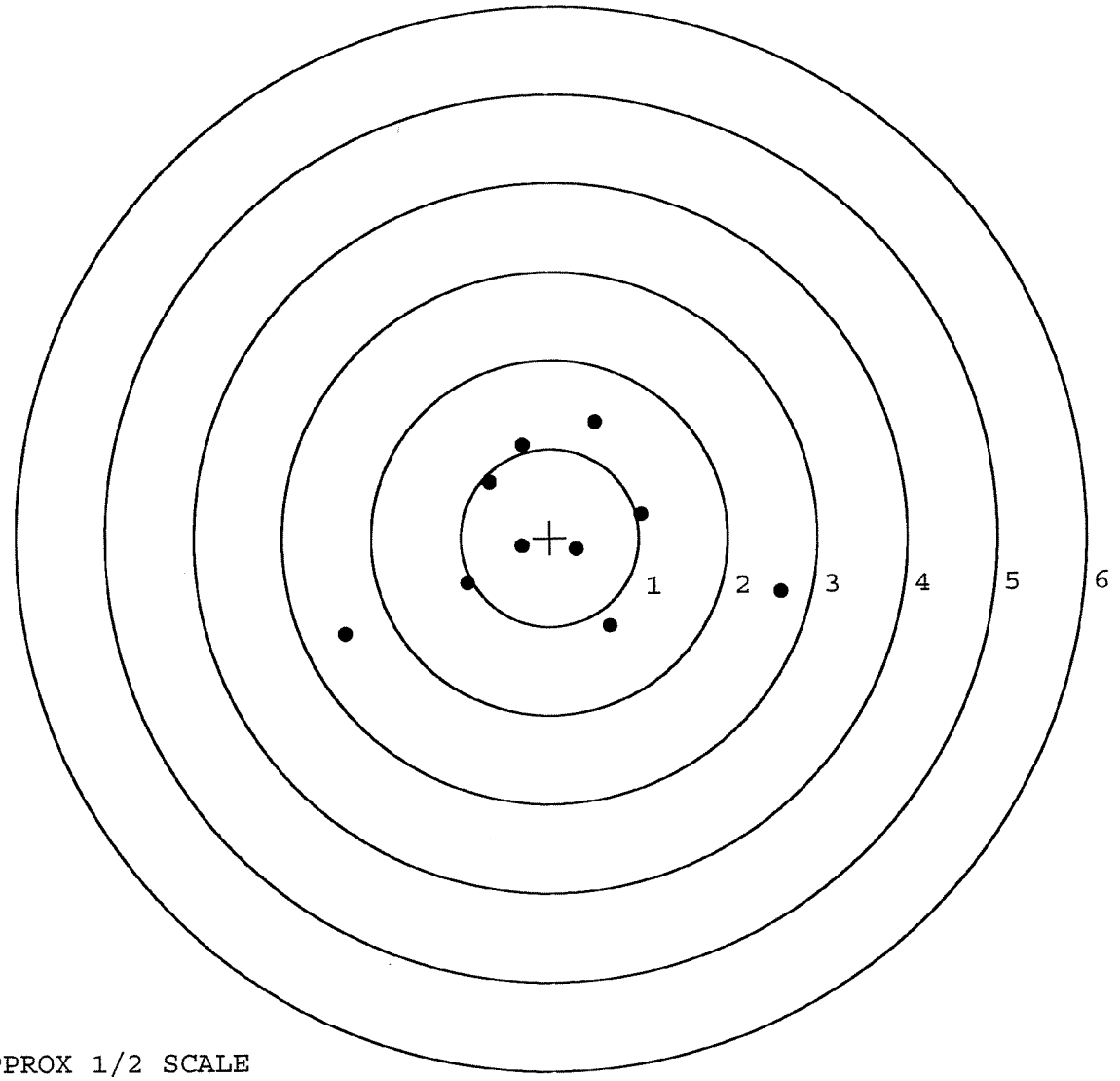
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.097
The Average Y Centroid of the Five Target Set:	0.106
The Average Point of Impact of the Five Target Set:	0.143
The Average Mean Radius of the Five Target Set:	1.101
The Distance from POA to Centroid Target #1:	0.062
The Distance from Centroid Target #2 to Centroid Target #1:	0.416
The Distance from Centroid Target #3 to Centroid Target #1:	0.485
The Distance from Centroid Target #4 to Centroid Target #1:	0.329
The Distance from Centroid Target #5 to Centroid Target #1:	0.201

SERIAL NUMBER: G6285935.__0
TARGET NUMBER: 1
FILE DATE: 05/22/2003
FILE TIME: 06:14

X CENTROID:	0.058
Y CENTROID:	-0.023
POA TO CENTROID:	0.062
HORZ SPREAD:	4.885
VERT SPREAD:	2.365
GROUP SPREAD:	4.904
MIN RADIUS:	0.262
MAX RADIUS:	2.602
MEAN RADIUS:	1.259
# IN 1 IN DIAMETER:	2
# IN 2 IN DIAMETER:	3
# in 3 IN DIAMETER:	8

POINT#	X	Y
1:	2.587	-0.635
2:	1.031	0.252
3:	0.294	-0.136
4:	0.673	-1.002
5:	-0.316	-0.096
6:	-0.678	0.623
7:	-0.928	-0.510
8:	-2.298	-1.067
9:	-0.302	1.046
10:	0.516	1.298

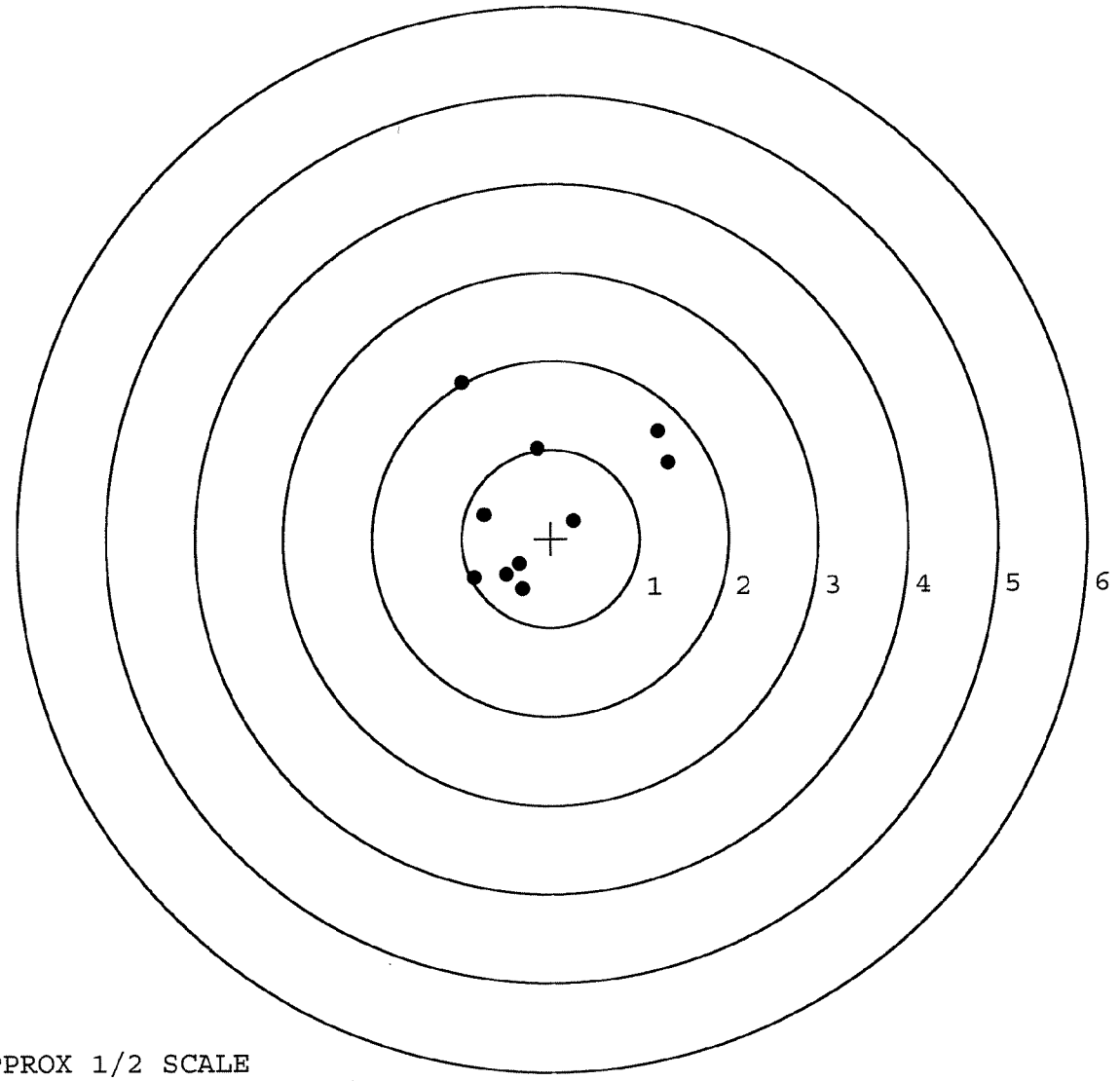


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6285935.__0
TARGET NUMBER: 2
FILE DATE: 05/22/2003
FILE TIME: 06:14

X CENTROID:	-0.113
Y CENTROID:	0.357
POA TO CENTROID:	0.374
HORZ SPREAD:	2.318
VERT SPREAD:	2.329
GROUP SPREAD:	2.492
MIN RADIUS:	0.403
MAX RADIUS:	1.655
MEAN RADIUS:	1.003
# IN 1 IN DIAMETER:	1
# IN 2 IN DIAMETER:	6
# in 3 IN DIAMETER:	7

POINT#	X	Y
1:	1.325	0.843
2:	1.209	1.194
3:	-0.147	1.013
4:	-0.993	1.759
5:	0.257	0.198
6:	-0.747	0.272
7:	-0.861	-0.443
8:	-0.355	-0.287
9:	-0.500	-0.411
10:	-0.320	-0.570

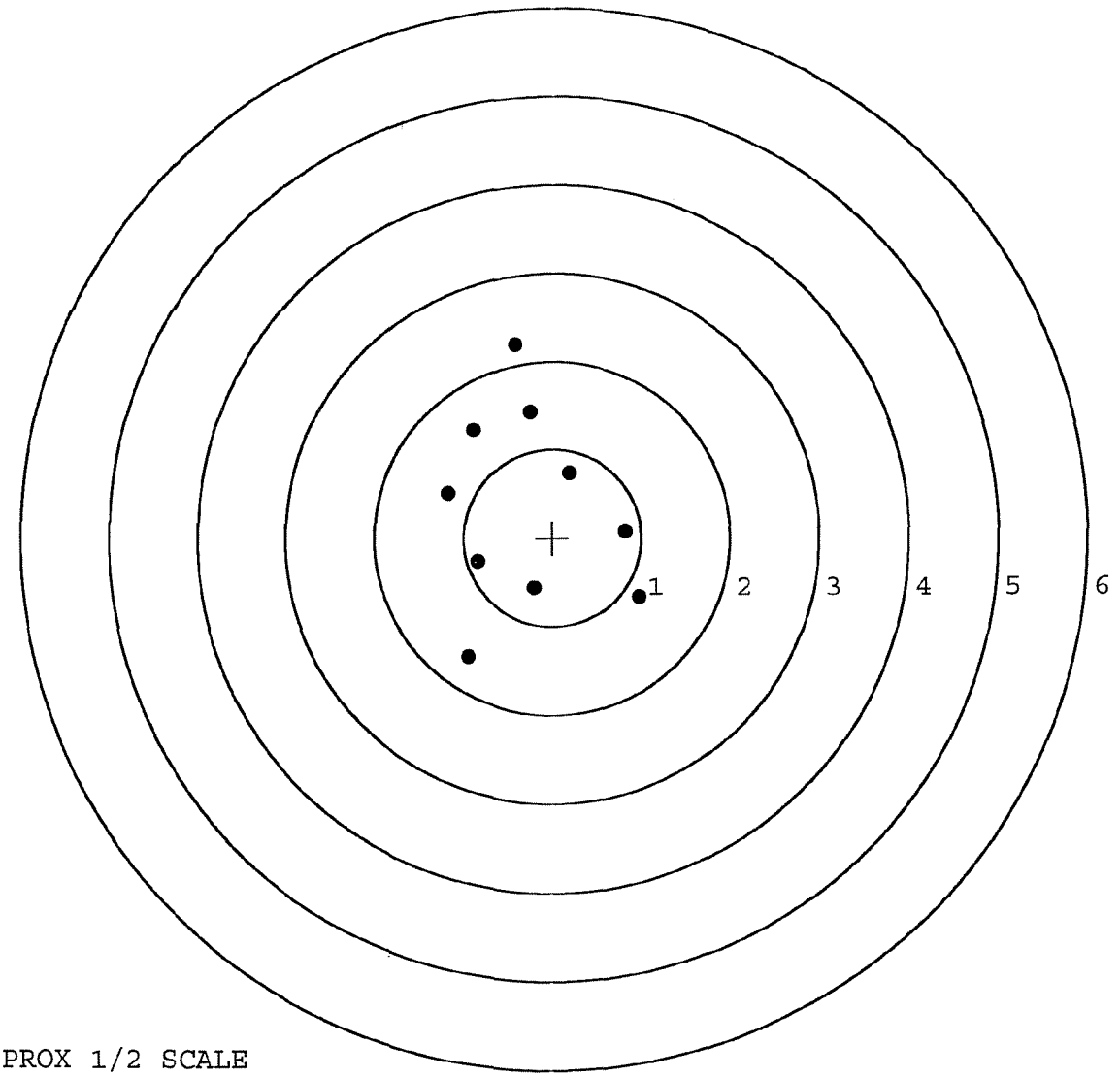


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6285935.__0
TARGET NUMBER: 3
FILE DATE: 05/22/2003
FILE TIME: 06:14

X CENTROID:	-0.275
Y CENTROID:	0.329
POA TO CENTROID:	0.429
HORZ SPREAD:	2.158
VERT SPREAD:	3.543
GROUP SPREAD:	3.580
MIN RADIUS:	0.617
MAX RADIUS:	1.870
MEAN RADIUS:	1.185
# IN 1 IN DIAMETER:	0
# IN 2 IN DIAMETER:	4
# in 3 IN DIAMETER:	7

POINT#	X	Y
1:	0.980	-0.668
2:	0.821	0.078
3:	0.191	0.733
4:	-0.212	-0.571
5:	-0.840	-0.273
6:	-0.942	-1.350
7:	-1.178	0.504
8:	-0.891	1.220
9:	-0.256	1.426
10:	-0.426	2.193

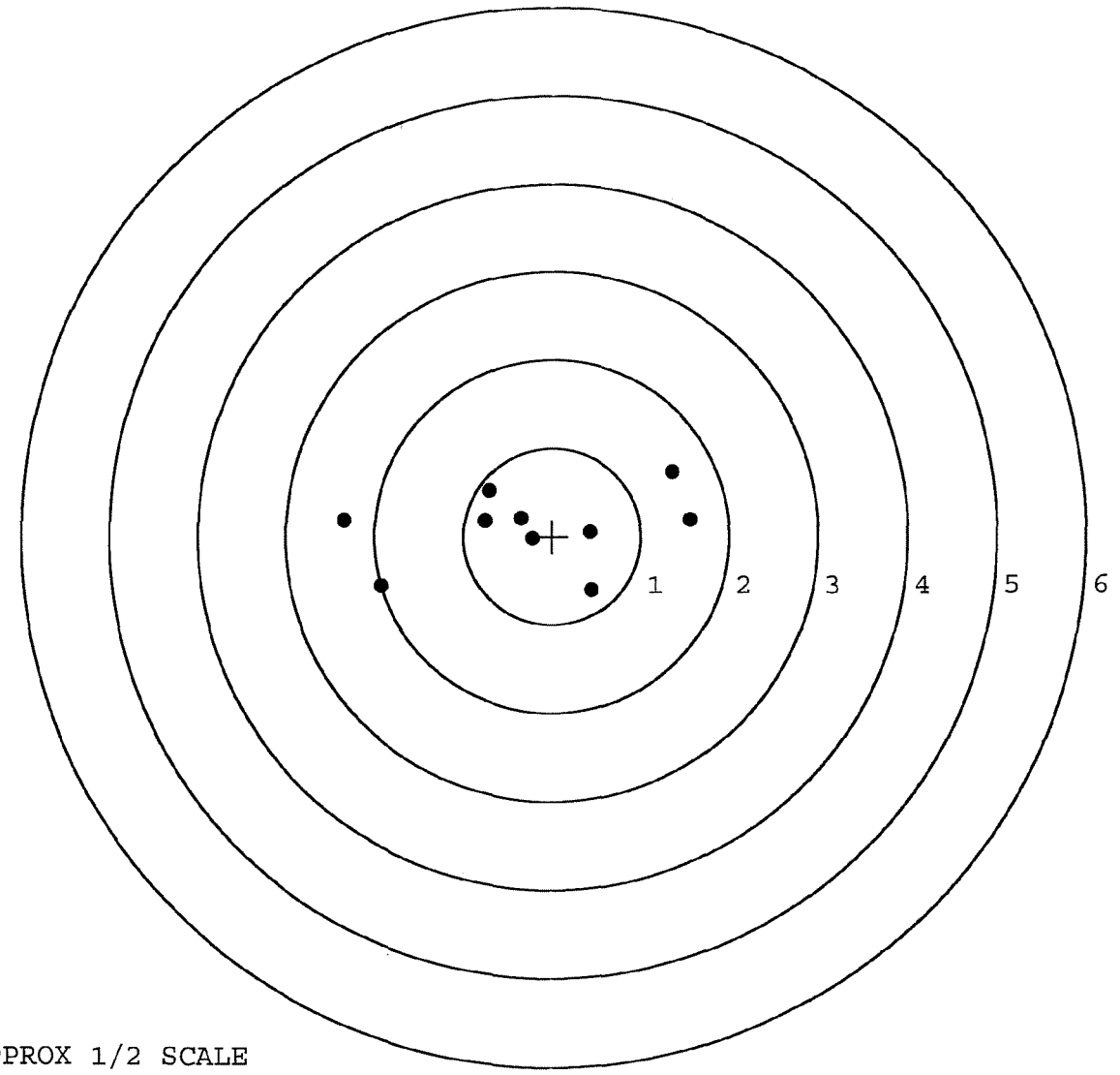


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6285935.__0
TARGET NUMBER: 4
FILE DATE: 05/22/2003
FILE TIME: 06:14

X CENTROID:	-0.253
Y CENTROID:	0.085
POA TO CENTROID:	0.267
HORZ SPREAD:	3.905
VERT SPREAD:	1.345
GROUP SPREAD:	3.905
MIN RADIUS:	0.114
MAX RADIUS:	2.095
MEAN RADIUS:	1.054
# IN 1 IN DIAMETER:	2
# IN 2 IN DIAMETER:	6
# in 3 IN DIAMETER:	6

POINT#	X	Y
1:	0.446	-0.617
2:	0.431	0.049
3:	-0.221	-0.024
4:	-0.357	0.207
5:	-0.764	0.179
6:	-0.715	0.520
7:	-2.346	0.184
8:	-1.923	-0.569
9:	1.559	0.192
10:	1.358	0.728

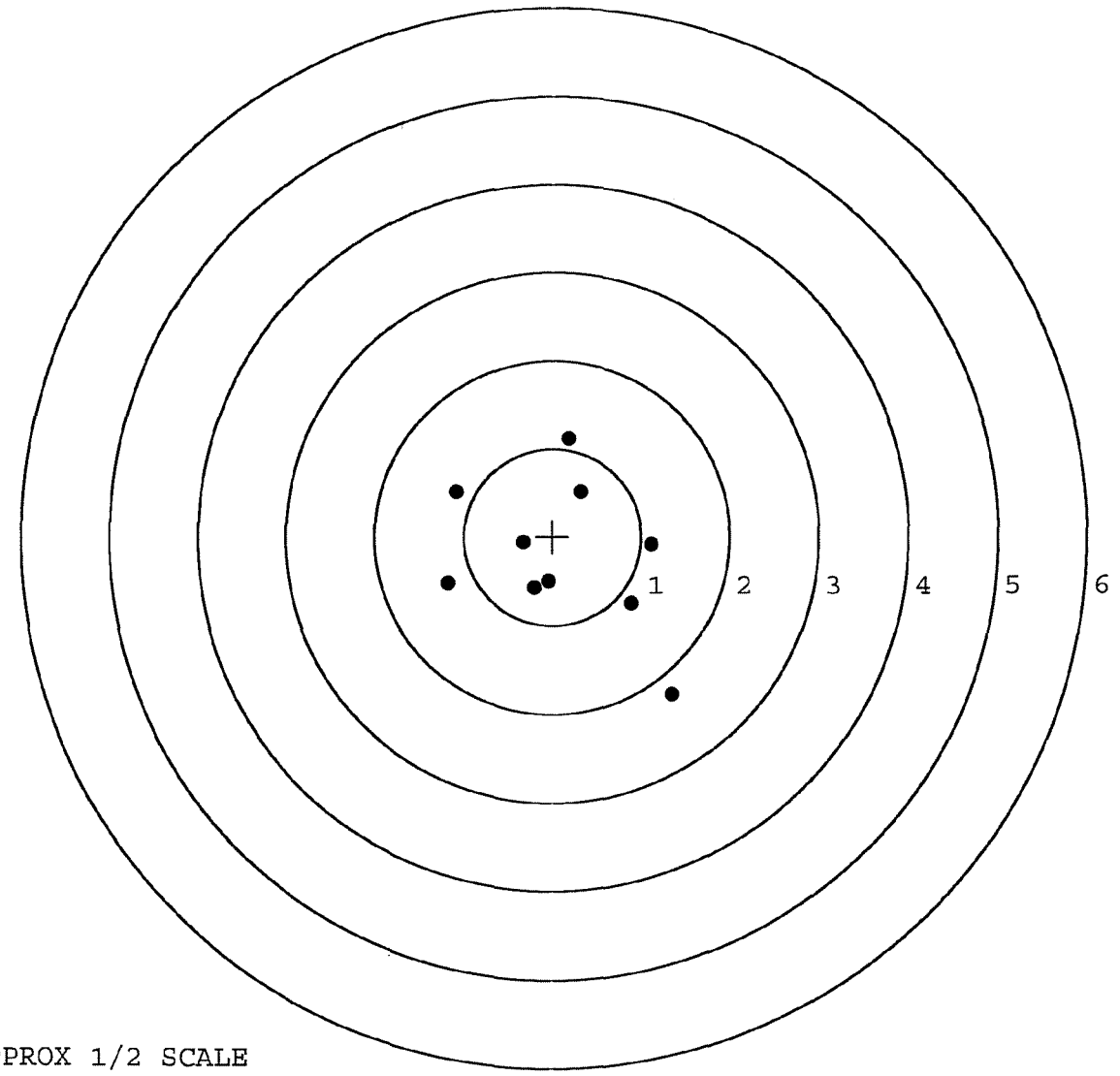


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6285935.__0
TARGET NUMBER: 5
FILE DATE: 05/22/2003
FILE TIME: 06:14

X CENTROID:	0.099
Y CENTROID:	-0.219
POA TO CENTROID:	0.241
HORZ SPREAD:	2.528
VERT SPREAD:	2.899
GROUP SPREAD:	3.353
MIN RADIUS:	0.324
MAX RADIUS:	2.003
MEAN RADIUS:	1.005
# IN 1 IN DIAMETER:	3
# IN 2 IN DIAMETER:	5
# in 3 IN DIAMETER:	9

POINT#	X	Y
1:	1.350	-1.784
2:	0.889	-0.759
3:	1.115	-0.095
4:	0.316	0.507
5:	0.184	1.115
6:	-0.333	-0.072
7:	-0.047	-0.509
8:	-0.209	-0.583
9:	-1.178	-0.527
10:	-1.093	0.512



TARGET APPROX 1/2 SCALE

RECEIVING AND ESTIMATING REPORT

COMMENTS: M/24 W/SCOPE, W/HARD CASE

ORDER: R 99-20503

INITIAL	CUSTOMER ORDER NO.
SWS	

DATE RECEIVED	DATE OPENED	DATE CODE	SERIAL NUMBER	NEW SERIAL NUMBER	MODEL AND GRADE
10/18/99	10/20/99		C6498753		700 7.62 NATO

ACCESSORIES: W/STUDS W/SWIVELS SCOPE BASE

Scope S/N 88-1297

FROM:

U S ARMY
CO D 2/29 INF REGT
BLDG 73
FT BENNING GA 31905

SHIP TO: Used Scope 86-0734 Exchanged

U S ARMY
CO D 2/29 INF REGT
BLDG 73
FT BENNING GA 31905

CUST NO: 187354 C.O.D.

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

PARTS

BBL	96003
Stock	96018
Scope Ring Assy (2)	96082
BOLT ASSY	96005
Rear Sight Base	96016
EXTractor	91816

COMMENTS

REPAIRMAN	PROOF	CLEAN	TEST	TARGET	PATTERN
RW	✓	✓	✓	✓	
GALLERY TESTER	**DATE**	**DATE**	**DATE**	**DATE**	**DATE**
RW		1-27-00	2-1-00	2-1-00	

OFFICE COPY

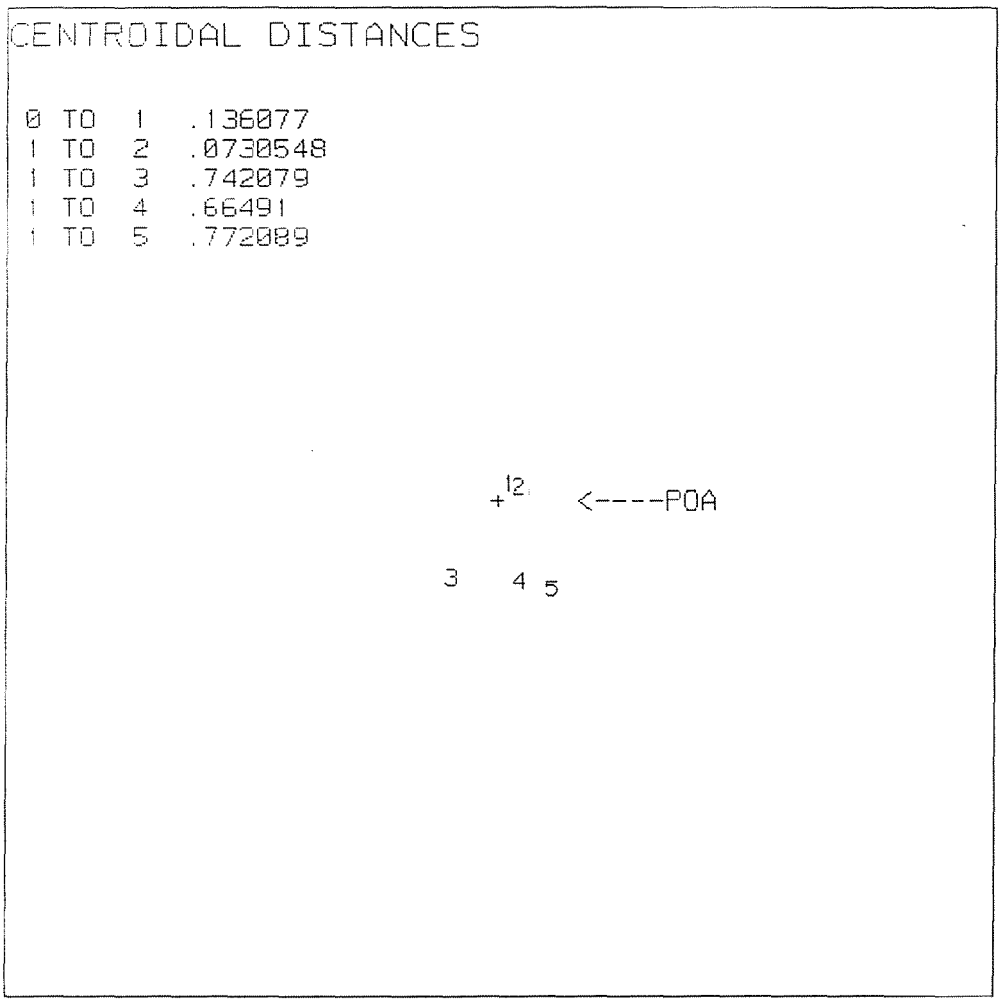
RD6925 REV. 7/97

Remington Test Lab, Ilion, N.Y.

Centroidal distance calculations for Rifle # c6498753
9 Feb 2000

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0776
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.2872
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .297499

THE AMR FOR THIS RIFLE IS: 1.259



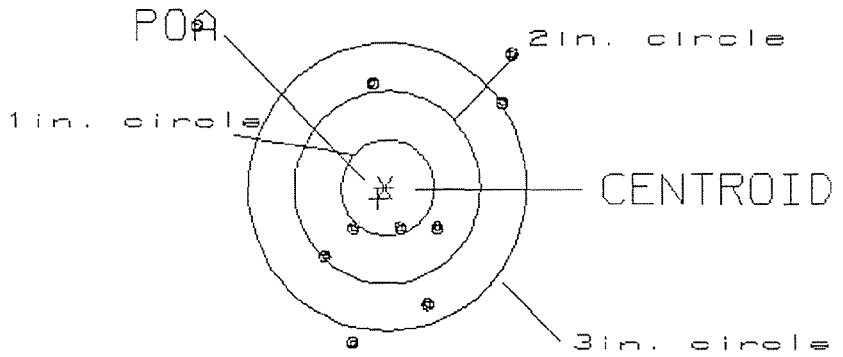
REMINGTON CENTERFIRE ACCURACY TEST REMINGTON TEST LAB, ILION, N.Y.

PATTERN #: □ 1 □

POA TO CENTROID:		.136
MIN RADIUS	:	.484
MEAN RADIUS	:	1.284
MAX RADIUS	:	2.685
CENTROID X	:	.066
CENTROID Y	:	.119

9 Feb 2000 FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6498753.1

CENTERFIRE PATTERN # 1



# OF SHOTS= 10	# IN CIRCLE
HS= 3.49	1
VS= 3.25	3
GS= 3.82	7

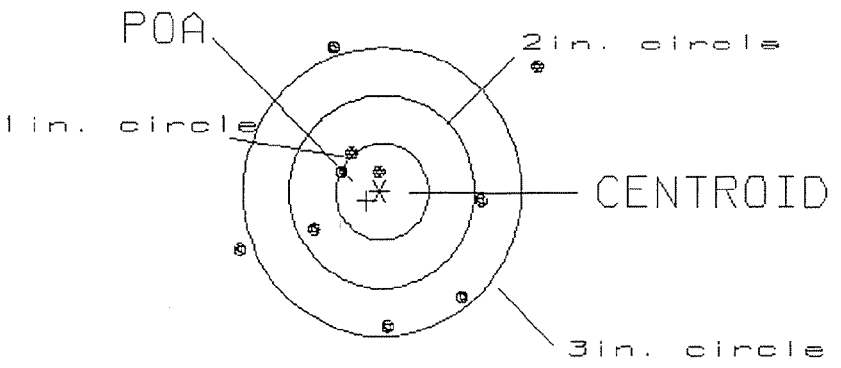
REMINGTON CENTERFIRE ACCURACY TEST REMINGTON TEST LAB, ILION, N.Y.

PATTERN #: 2

POA TO CENTROID:		.165
MIN RADIUS	:	.173
MEAN RADIUS	:	1.134
MAX RADIUS	:	2.113
CENTROID X	:	.135
CENTROID Y	:	.095

9 Feb 2000 FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6498753.1

CENTERFIRE PATTERN # 2



# OF SHOTS= 10	# IN CIRCLE
HS= 3.25	1
VS= 2.91	4
GS= 3.74	7

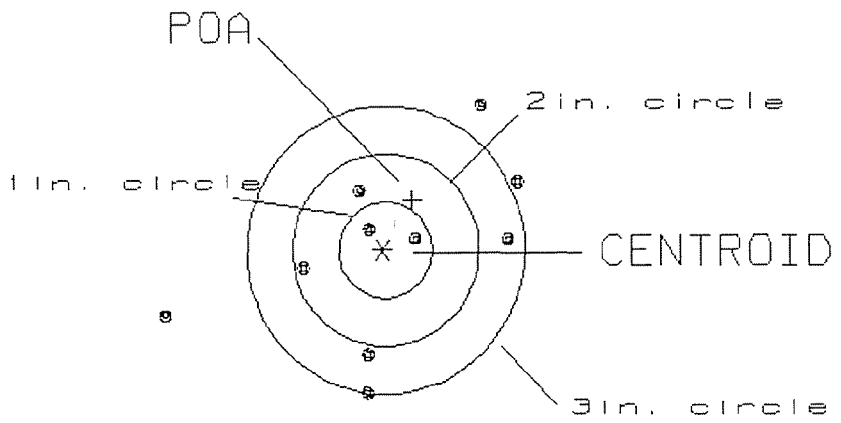
REMINGTON CENTERFIRE ACCURACY TEST REMINGTON TEST LAB, ILION, N.Y.

PATTERN #: □ 3 □

POA TO CENTROID:		.606
MIN RADIUS	:	.307
MEAN RADIUS	:	1.222
MAX RADIUS	:	2.475
CENTROID X	:	-.318
CENTROID Y	:	-.516

9 Feb 2000 FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6498753.1

CENTERFIRE PATTERN # 3

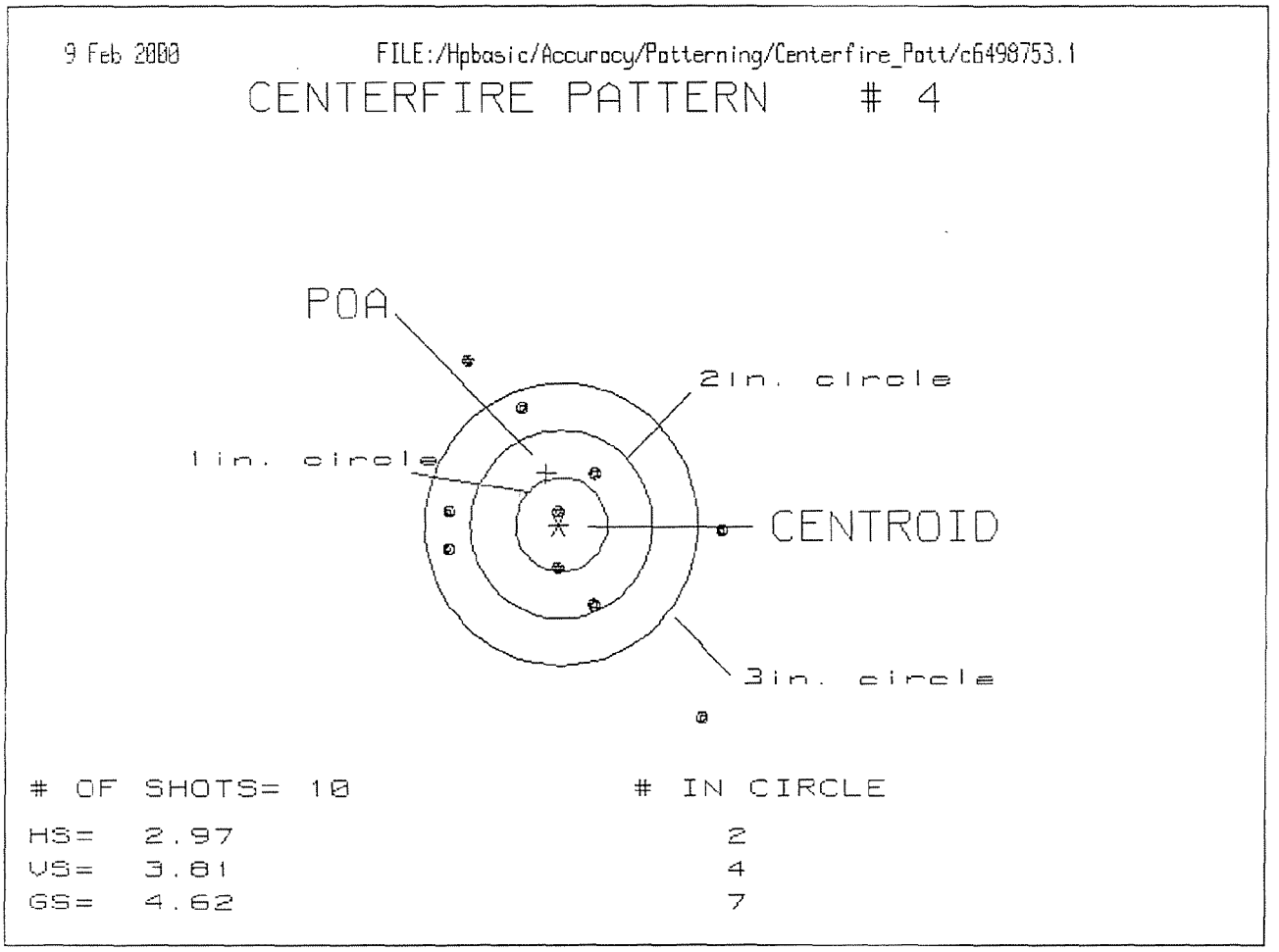


# OF SHOTS= 10	# IN CIRCLE
HS= 3.84	2
VS= 3.08	4
GS= 4.09	6

REMINGTON CENTERFIRE ACCURACY TEST REMINGTON TEST LAB, ILION, N.Y.

PATTERN #: 4

POA TO CENTROID:		.559
MIN RADIUS	:	.188
MEAN RADIUS	:	1.243
MAX RADIUS	:	2.615
CENTROID X	:	.138
CENTROID Y	:	-.542



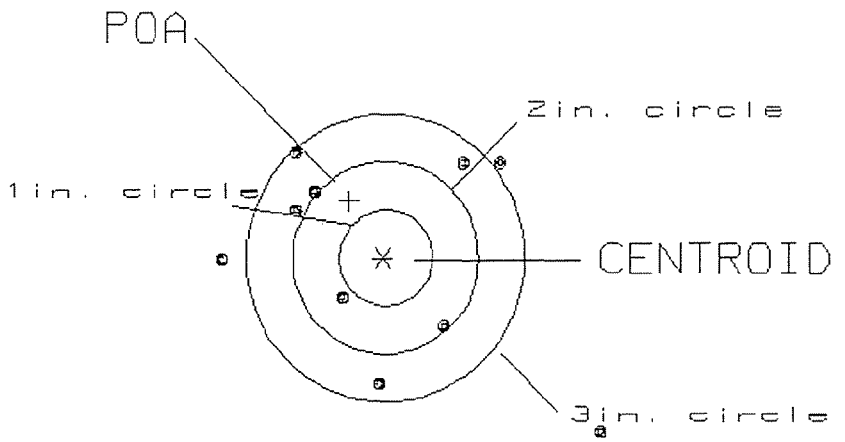
REMINGTON CENTERFIRE ACCURACY TEST REMINGTON TEST LAB, ILION, N.Y.

PATTERN #: 5

POA TO CENTROID:		.696
MIN RADIUS	:	.623
MEAN RADIUS	:	1.410
MAX RADIUS	:	2.938
CENTROID X	:	.367
CENTROID Y	:	-.592

9 Feb 2000 FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6498753.1

CENTERFIRE PATTERN # 5



# OF SHOTS= 10	# IN CIRCLE
HS= 4.02	0
VS= 2.95	2
GS= 4.44	7

21 DAY TURN - AROUND

M-24
CONTRACT # DAAA09-92-C-0834

R&E NO. **SERIAL NO.** C6498753

		LOG IN DATE: / /	DATE	INIT.
		INSPECT & VERIFY:		
OP. #		OP. NAME		
550		DIS-ASSEMBLE GUN		
560	A	RE-BARREL AT CUSTOM SHOP		
	B	DRILL & TAP		
	C	POLISH		
575		ASSEMBLE		
600		PROOF	12-12-99	RW
605		CHECK HEADSPACE	12-12-99	RW
610		DIS-ASSEMBLE		
612		MAGNAFLUX		
615		ROLLMARK CALIBER		
618		ROTO-BLAST		
620		APPLY COATINGS		
625	A	FINAL ASSEMBLY		
	B	TRIGGER PULL TEST		
	C	SAFETY ON FORCE		
	D	SAFETY OFF FORCE		
	E	FIRING PIN INDENT		
640		TARGET	2-1-00	RW
655		FINAL INSPECT	2-8-00	RW
660		PACK		
		QAR INSPECTION	SHIP DATE	

Final Inspection

S/N: C6498753	DATE REC'D: 10-18-99	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

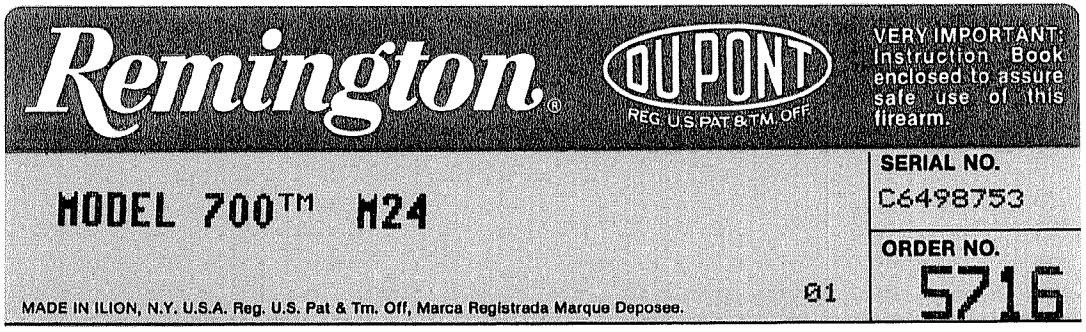
Item:

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: _____



5716 C6498753

UPC

0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6498753

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	4 12	90	RW
600	Proof	4 12	90	E
607	Check Headspace	4 12	90	E
610	Dis-assemble Gun	4 12	90	RW
612	Magnaflux Barrel Action	4-19-90		KER
	Magnaflux Bolt	4-19-90		KER
615	Rollmark Caliber	4-19-90		GL
617	Drill and Tap Sight Holes		4/23/90	LOT-3
618	Polish Barrel NB		4/24/90	WB
620	Apply Coatings (Barrel Action)		4-30-90	TJA
	Apply Coating (Bolt)			TJA
625	Final Assembly A) Clean inside of Bolt Assembly		4/18/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		4/18/90	RW
	C) Inspect Ejector Hole for Chamfer		4/18/90	RW
	D) Oil Firing Pin Ass'y		4/18/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		5/7/90	SL

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			5/8/90	
	G) Safety Off Force	3	3	3			5/8/90	
	H) Trigger Pull Test & Retainability						5/7/90	
	I) Firing Pin Indent	.021	.0215	.0215			5/8/90	
	J) Assemble Stock						5/10/90	
	K) Assemble Swivel Studs						5/16/90	
	L) Attach Front and Rear Sight Assemblies						5/10/90	
	M) Iron Sight Alignment						5/10/90	
	N) Detach Front & Rear Sights & place in numbered container						5/10/90	
	O) Attach Scope to Rifle						5/10/90	
	P) Detach & Attach Scope 20 Times						5/10/90	
640	Gallery Target & Test						5-11-90	AC
	A) Time						5-11-90	AC
	B) Malfunctions						5-11-90	AC
	C) Pierced Primers						5-11-90	AC
	D) Optical Clearity of Scope						5-11-90	AC
645	Inspect for Live Ammo						5-11-90	AC
655	Final Inspection A) Headspace						5/15/90	WB
	B) Trigger Pull	2.59	263	265	2.69	2.68	5/15/90	WB
	C) Function						5/16/90	WB
660	Pack						5-20-90	DH

SWS TRIGGER PULL TEST

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

SERIAL NO. C6498753
DATE 5/7/90
TESTER JRL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.49	2.45	2.40	2.59	MIN. SETTING,
PULL #2	2.50	2.48	2.35	2.63	NO AVG. OF 5
PULL #3	2.51	2.31	2.45	2.65	READINGS ACCEPT-
PULL #4	2.44	2.34	2.46	2.69	ABLE LESS THAN 2#
PULL #5	2.34	2.40	2.40	2.68	
TOTAL	12.28	11.98	12.06		
AVG.	2.456	2.396	2.412		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.48	3.41		
PULL #2	3.52	3.46		
PULL #3	3.50	3.29		
PULL #4	3.49	3.37		
PULL #5	3.49	3.35		
TOTAL	17.48	16.82		
AVG.	3.496	3.364		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.30	4.45		4.24
PULL #2	4.35	4.35		4.41
PULL #3	4.30	4.14		4.40
PULL #4	4.44	4.35		4.18
PULL #5	4.44	4.42		4.41
TOTAL	21.83	21.71		21.64
AVG.	4.366	4.342		4.328

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6348753
11 May 1990

CENTROIDAL DISTANCES

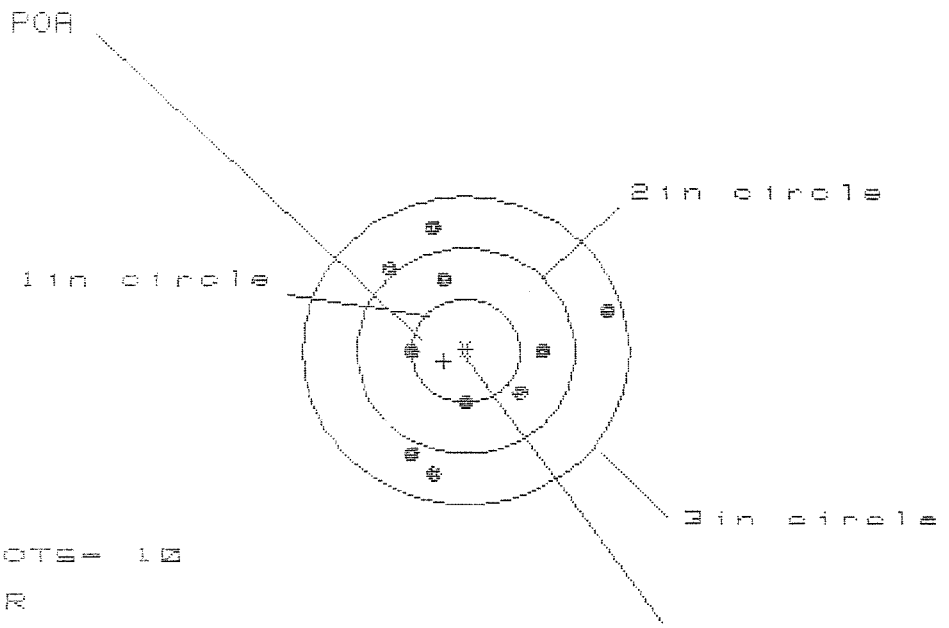
0	TO	1	.221382
1	TO	2	.245247
1	TO	3	.264613
1	TO	4	.178101
1	TO	5	.374012

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .2566
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.058
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .263073

THE AMR FOR THIS RIFLE IS: .8474

11 May 1998 FILE:/PATTERNING/CENTERFIRE_PATT/C6348753

CENTERFIRE PATTERNS # 1



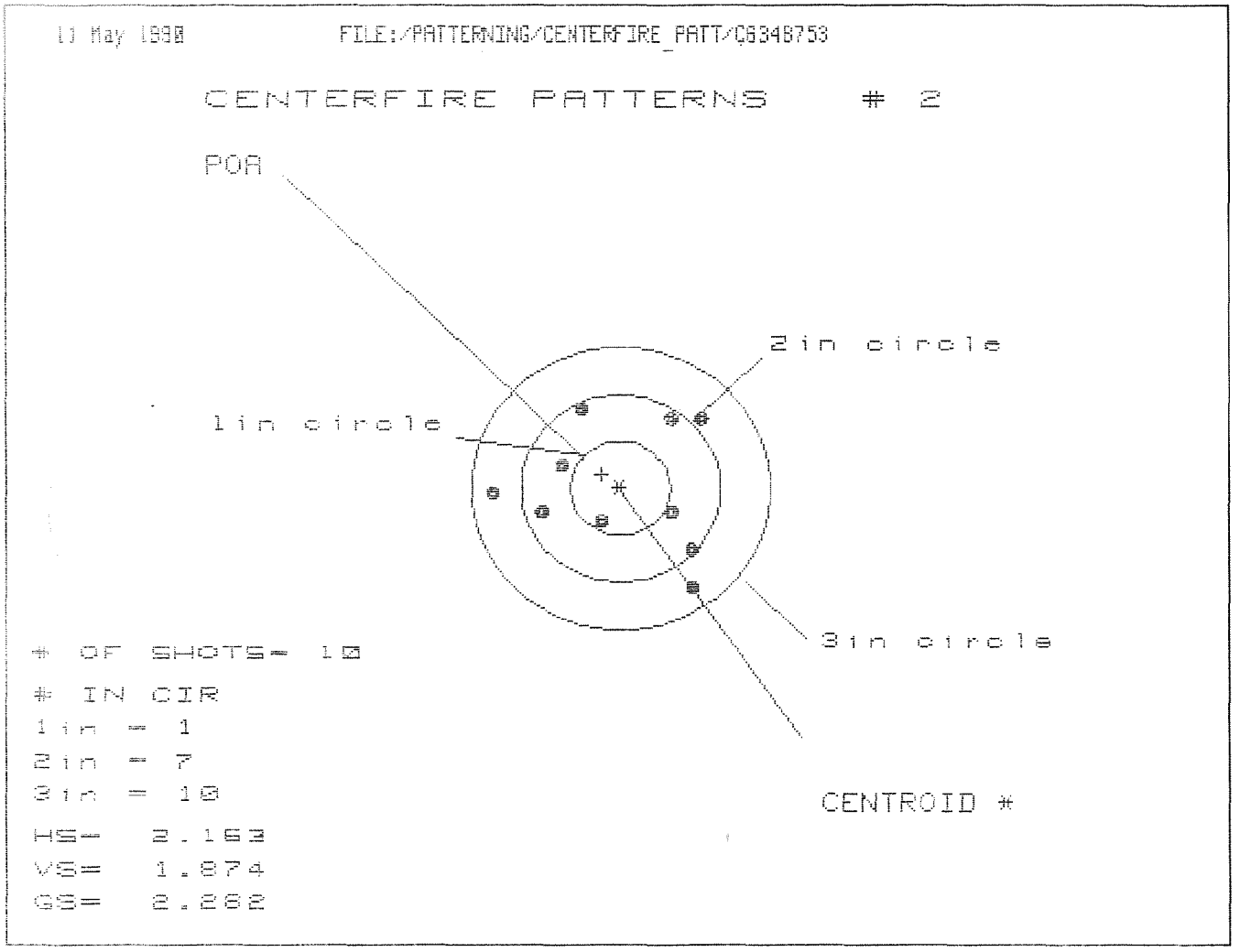
OF SHOTS= 10

# IN CIR
1in = 0
2in = 5
3in = 10

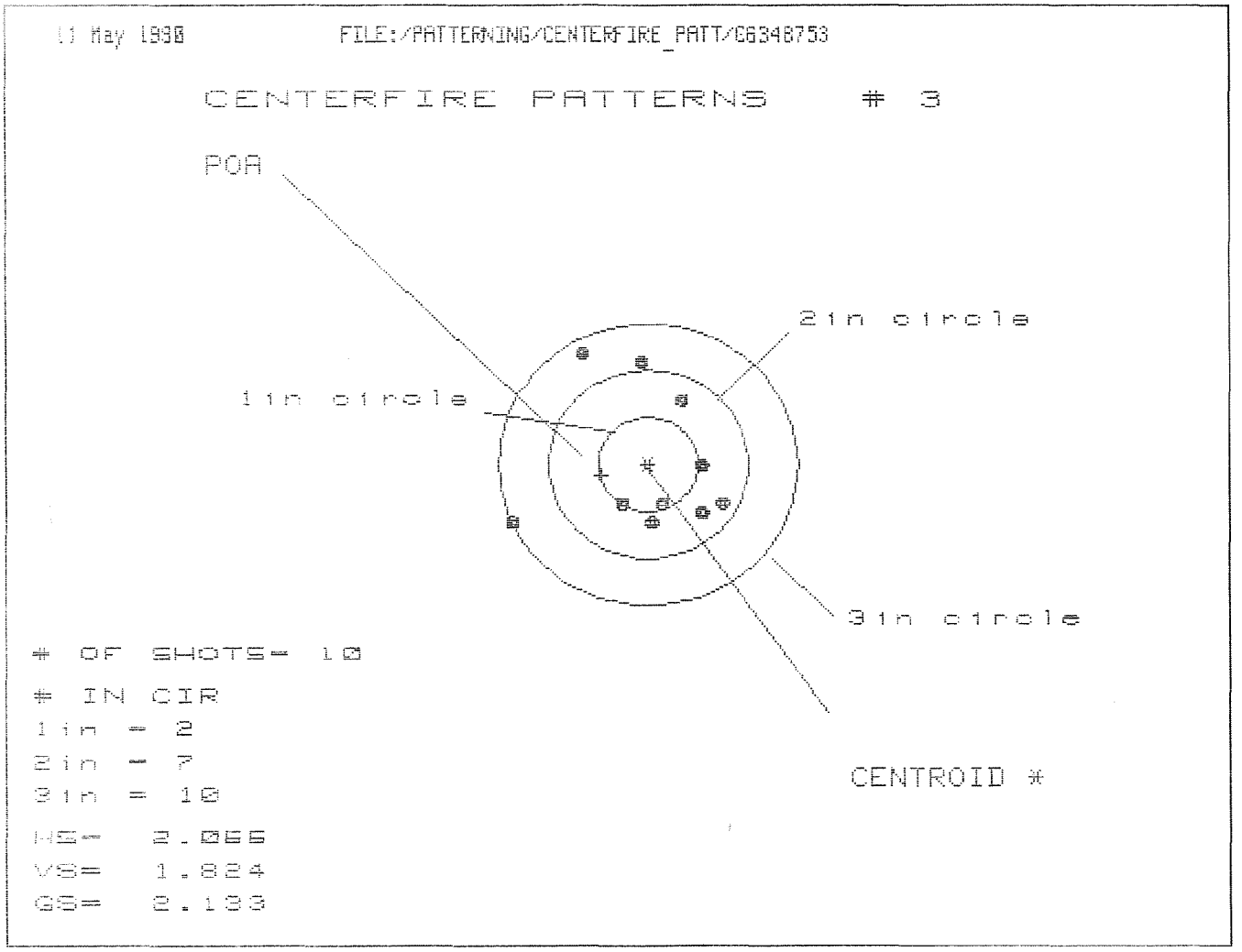
HS= 1.977
VS= 2.471
GS= 2.471

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.301	.875	.852
MINIMUM X	:	-.676	-.532	-.555
MAXIMUM Y	:	1.248	1.288	.990
MINIMUM Y	:	-1.223	-1.183	-1.022
CENTROID X	:	.199	.055	.078
CENTROID Y	:	.097	.057	-.103
POA TO CENTROID in.	:	.221	.079	.129
MIN RADIUS	:	.531	.395	.368
MEAN RADIUS	:	.921	.864	.792
MAX RADIUS	:	1.348	1.301	1.135
HORIZONTAL SPREAD	:	1.977	1.407	1.407
VERTICAL SPREAD	:	2.471	2.471	2.013
EXTREME SPREAD	:	2.471	2.471	2.041

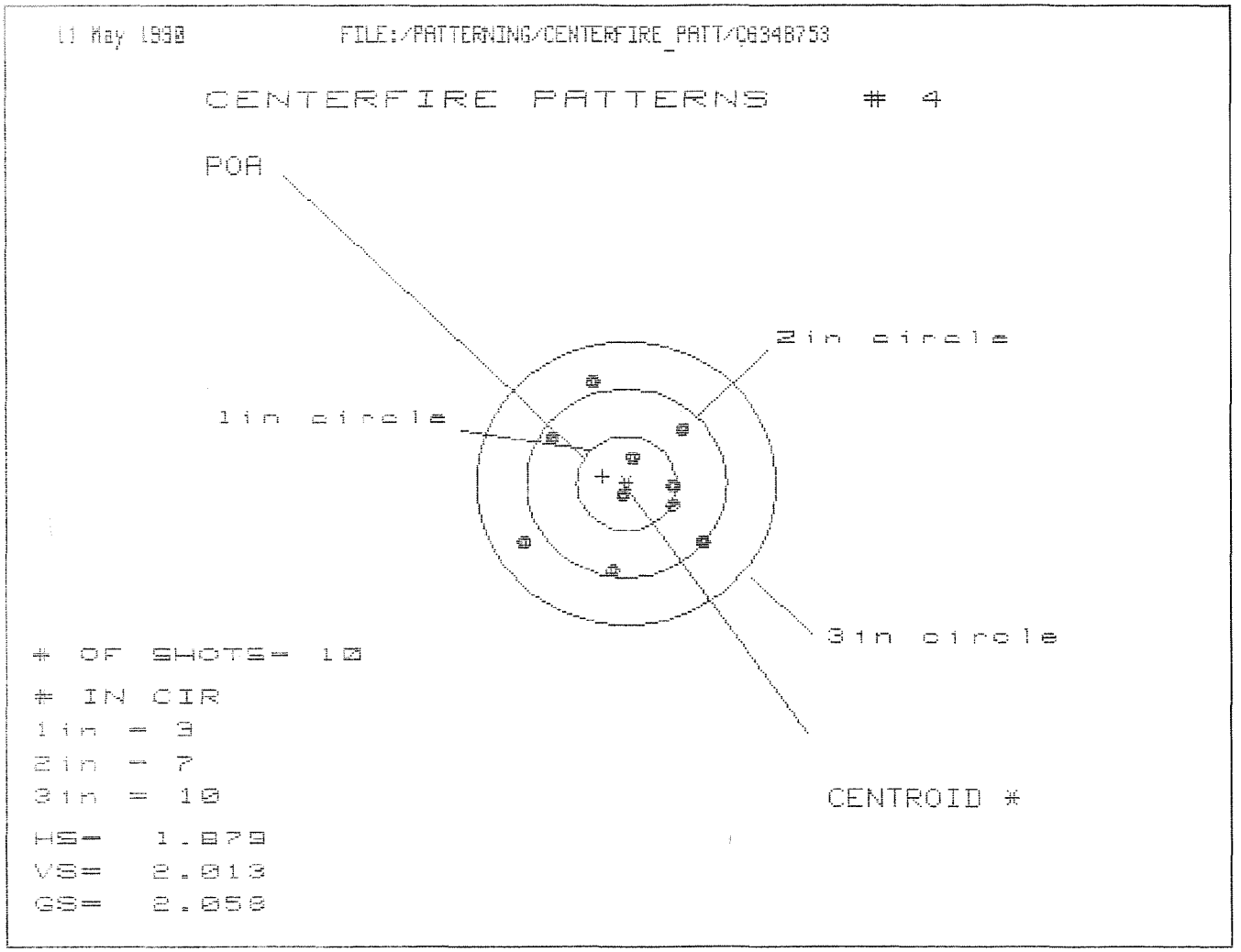
NUMBER IN ONE INCH CIRCLE = 0
NUMBER IN TWO INCH CIRCLE = 5
NUMBER IN THREE INCH CIRCLE = 10



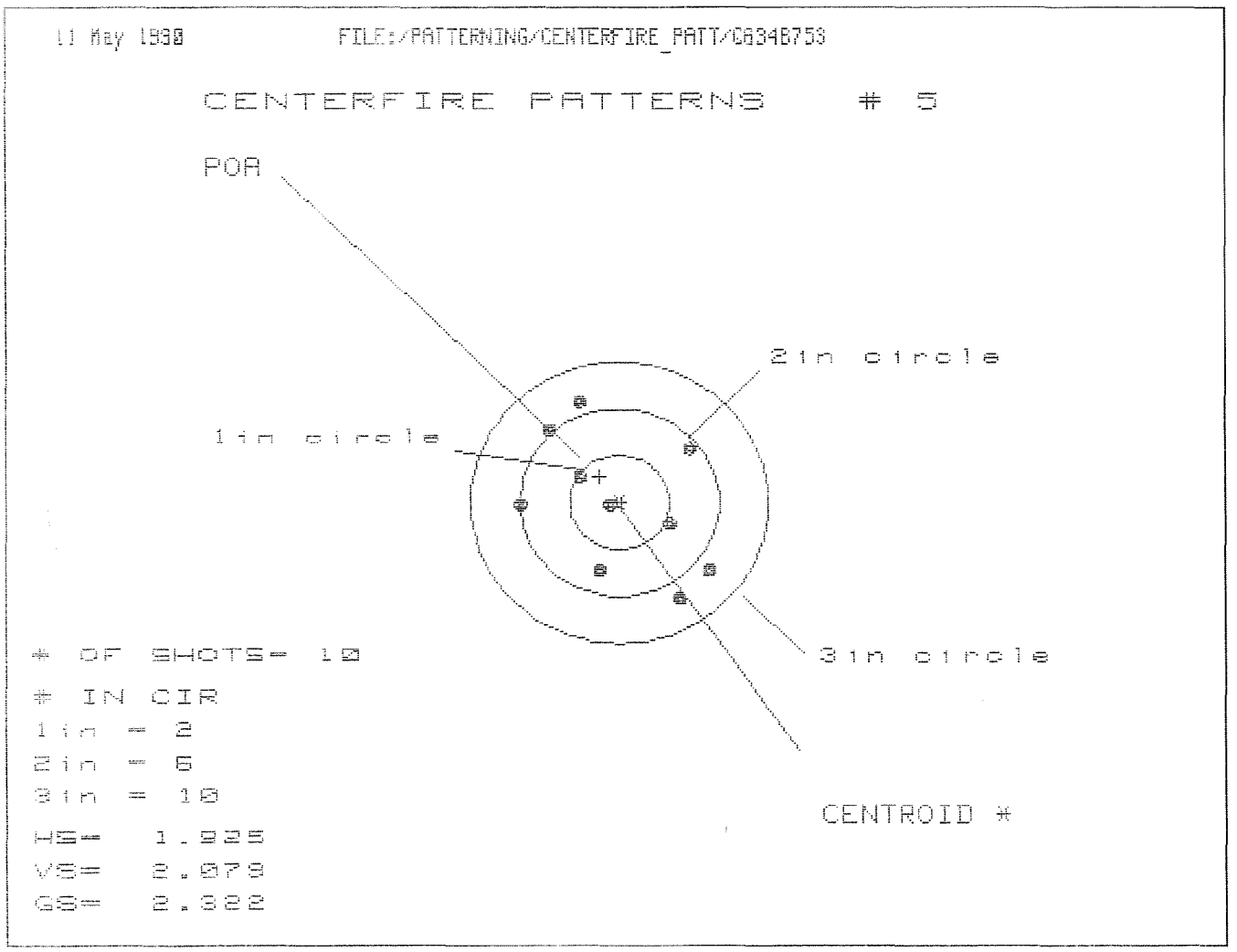
PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.852	.706	.773
MINIMUM X	:	-1.311	-.914	-.847
MAXIMUM Y	:	.843	.843	.714
MINIMUM Y	:	-1.031	-1.031	-.774
CENTROID X	:	.188	.334	.267
CENTROID Y	:	-.148	-.148	-.019
POA TO CENTROID in.	:	.239	.365	.268
MIN RADIUS	:	.412	.460	.562
MEAN RADIUS	:	.896	.843	.801
MAX RADIUS	:	1.311	1.160	.976
HORIZONTAL SPREAD	:	2.163	1.620	1.620
VERTICAL SPREAD	:	1.874	1.874	1.488
EXTREME SPREAD	:	2.282	2.157	1.915
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	



PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.707	.556	.455
MINIMUM X	:	-1.359	-.806	-.477
MAXIMUM Y	:	1.219	1.156	1.139
MINIMUM Y	:	-.605	-.668	-.523
CENTROID X	:	.463	.614	.715
CENTROID Y	:	.115	.178	.033
POA TO CENTROID in.	:	.477	.639	.715
MIN RADIUS	:	.459	.361	.266
MEAN RADIUS	:	.832	.742	.606
MAX RADIUS	:	1.473	1.409	1.175
HORIZONTAL SPREAD	:	2.066	1.362	.932
VERTICAL SPREAD	:	1.824	1.824	1.663
EXTREME SPREAD	:	2.133	2.133	1.705
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	



PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.795	.675	.615
MINIMUM X	:	-1.084	-.896	-.956
MAXIMUM Y	:	1.075	1.010	.685
MINIMUM Y	:	-.938	-1.003	-.876
CENTROID X	:	.237	.357	.417
CENTROID Y	:	-.077	-.012	-.139
POA TO CENTROID in.	:	.249	.358	.439
MIN RADIUS	:	.113	.248	.266
MEAN RADIUS	:	.754	.685	.620
MAX RADIUS	:	1.232	1.116	1.104
HORIZONTAL SPREAD	:	1.879	1.571	1.571
VERTICAL SPREAD	:	2.013	2.013	1.561
EXTREME SPREAD	:	2.058	2.058	1.932
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	



PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.946	1.018	.900
MINIMUM X	:	-.979	-.907	-.780
MAXIMUM Y	:	1.041	.925	.824
MINIMUM Y	:	-1.038	-.813	-.914
CENTROID X	:	.196	.124	-.003
CENTROID Y	:	-.277	-.161	-.060
POA TO CENTROID in.	:	.339	.203	.060
MIN RADIUS	:	.099	.154	.203
MEAN RADIUS	:	.834	.783	.703
MAX RADIUS	:	1.225	1.302	.984
HORIZONTAL SPREAD	:	1.925	1.925	1.680
VERTICAL SPREAD	:	2.079	1.738	1.738
EXTREME SPREAD	:	2.322	2.223	1.811
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	6		
NUMBER IN THREE INCH CIRCLE	=	10		