

C6522319

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



Repair Inquiry

Repair Number: RE00149811

Serial: C6522319 Model M24 SWS Center Fire
Caliber: 7.62 NATO

Repairman:

Status: Closed 8/25/2008 9:52:18 AM

Verify Repair

Address Information

Customer:

☒ Received From

Return To:

☐ Received From

Name: CAMP ROBERTS MATES

CAMP ROBERTS MATES

Address 1: EAST GARRISON BLDG 25021

EAST GARRISON BLDG 25021

Address 2: ATTN: CW4 KEISTER

PO Box:

ATTN: CW4 KEISTER

PO Box:

City: SAN MIGUEL

SAN MIGUEL

State: CA

Zip Code: 93451

Country: US

State: CA

Zip Code: 93451

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
A008	With Swivel	2
A017	Scope Base	1
A057	Fit and Rear Sgt Base	1

Repair Search

Refresh

Close

naglej

8/25/2008

10:26 AM

CAPS

NUM

INS

SCRL



Serial Number: C6522319

Model: M24 SWS



RE00149811

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

W & E NUMBER 149811
 SERIAL NUMBER C6522319
 LOG-IN DATE 8-25-08

OPERATION #	OPERATION NAME		DATE	INITIAL
500	DIS-ASSEMBLE GUN			
505	RE-BARREL			
560	ASSEMBLE	Clean & EVALUATE	9-16-08	RTZ
600	PROOF			
605	CHECK HEADSPACE			
610	DIS-ASSEMBLE GUN			
612	MAGNAFLUX			
510	DRILL AND TAP			
615	ROLLMARK CALIBER			
618	ROTO-BLAST			
620	APPLY COATINGS			
625	FINAL ASSEMBLY			
640	FUNCTION TEST AND	(PASS) FAIL	9-20-08	TRW
650	TARGET	(PASS) FAIL	9-20-08	TRW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
670	FINAL INSPECTION		9-23-08	TC
	A) HEADSPACE	(PASS) FAIL	9-23-08	TC
	B) TRIGGER PULL	3.56 3.45 3.43 3.50 3.37	9-23-08	TC
680	F) SAFETY ON FORCE	2 2 2	9-23-08	TC
	G) SAFETY OFF FORCE	3 3 3	9-23-08	TC
	I) FIRING PIN INDENT	.025 .024 .025	9-23-08	TC
690	PACK		9-24-08	TC

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6522319.__1
FILE DATE AND TIME: 09/22/2008 05:54

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

ERROR - NOT POSSIBLE TO REPORT SWS STATS ON DATA
WHERE TOTAL TARGETS ARE NOT EQUAL TO FIVE

AVE MEAN - .876

SERIAL NUMBER: C6522319. __1

TARGET NUMBER: 1

FILE DATE: 09/22/2008

FILE TIME: 05:54

X CENTROID: 0.426

Y CENTROID: -0.269

POA TO CENTROID: 0.503

HORZ SPREAD: 4.279

VERT SPREAD: 1.155

GROUP SPREAD: 4.298

MIN RADIUS: 0.305

MAX RADIUS: 2.409

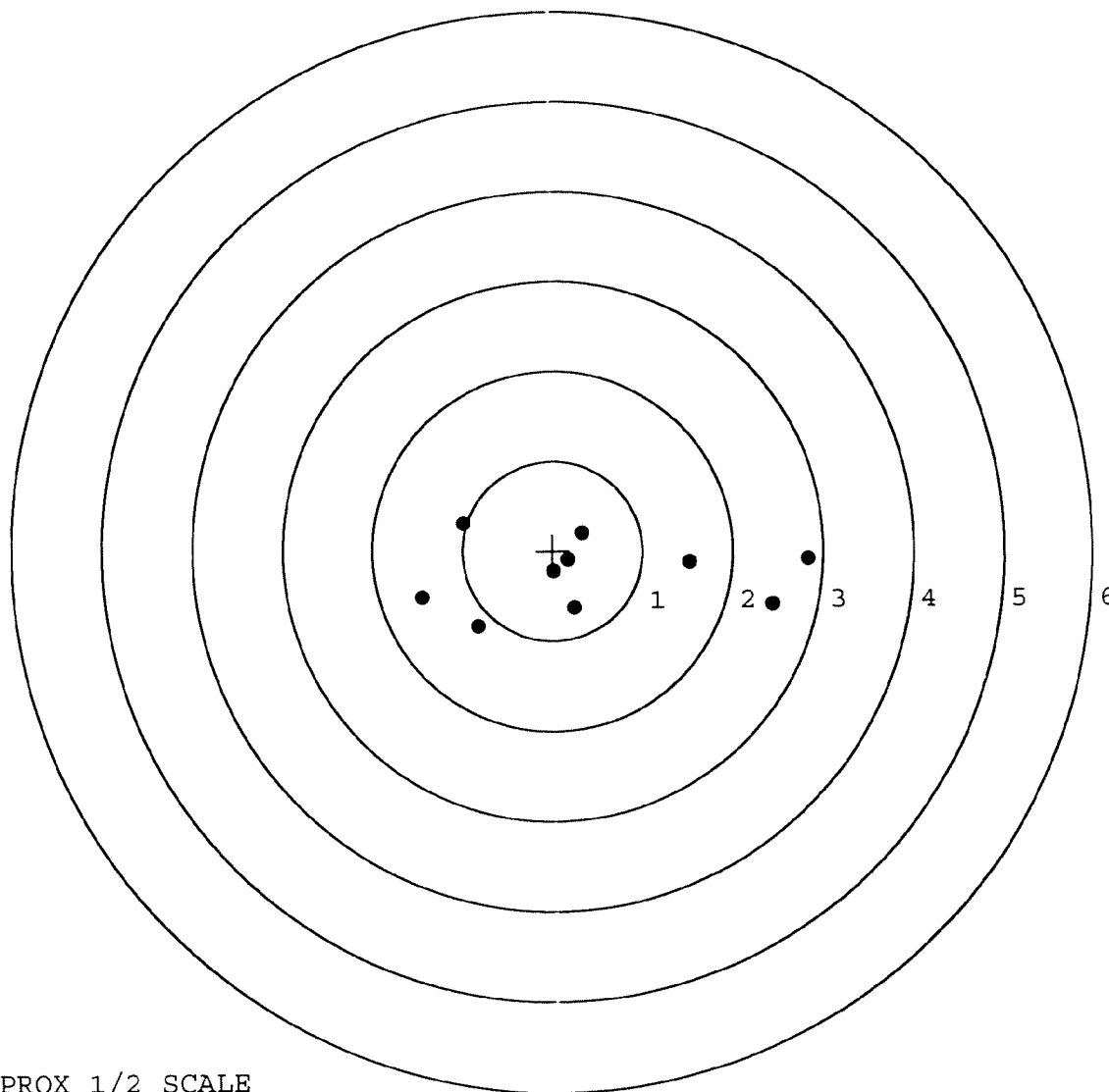
MEAN RADIUS: 1.198

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 4

in 3 IN DIAMETER: 6

POINT#	X	Y
1:	0.234	-0.644
2:	0.007	-0.227
3:	0.170	-0.103
4:	0.328	0.199
5:	-0.991	0.311
6:	-1.449	-0.517
7:	-0.828	-0.844
8:	1.524	-0.135
9:	2.434	-0.613
10:	2.830	-0.112



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6522319. 1

TARGET NUMBER: 2

FILE DATE: 09/22/2008

FILE TIME: 05:54

POINT#	X	Y
1:	0.201	-0.756
2:	-0.054	-0.494
3:	0.090	-0.337
4:	0.160	-0.149
5:	0.649	-0.074
6:	0.374	0.164
7:	0.870	0.341
8:	-0.254	0.598
9:	-0.518	-0.274
10:	-0.797	-0.259

X CENTROID: 0.072

Y CENTROID: -0.124

POA TO CENTROID: 0.143

HORZ SPREAD: 1.667

VERT SPREAD: 1.354

GROUP SPREAD: 1.772

MIN RADIUS: 0.091

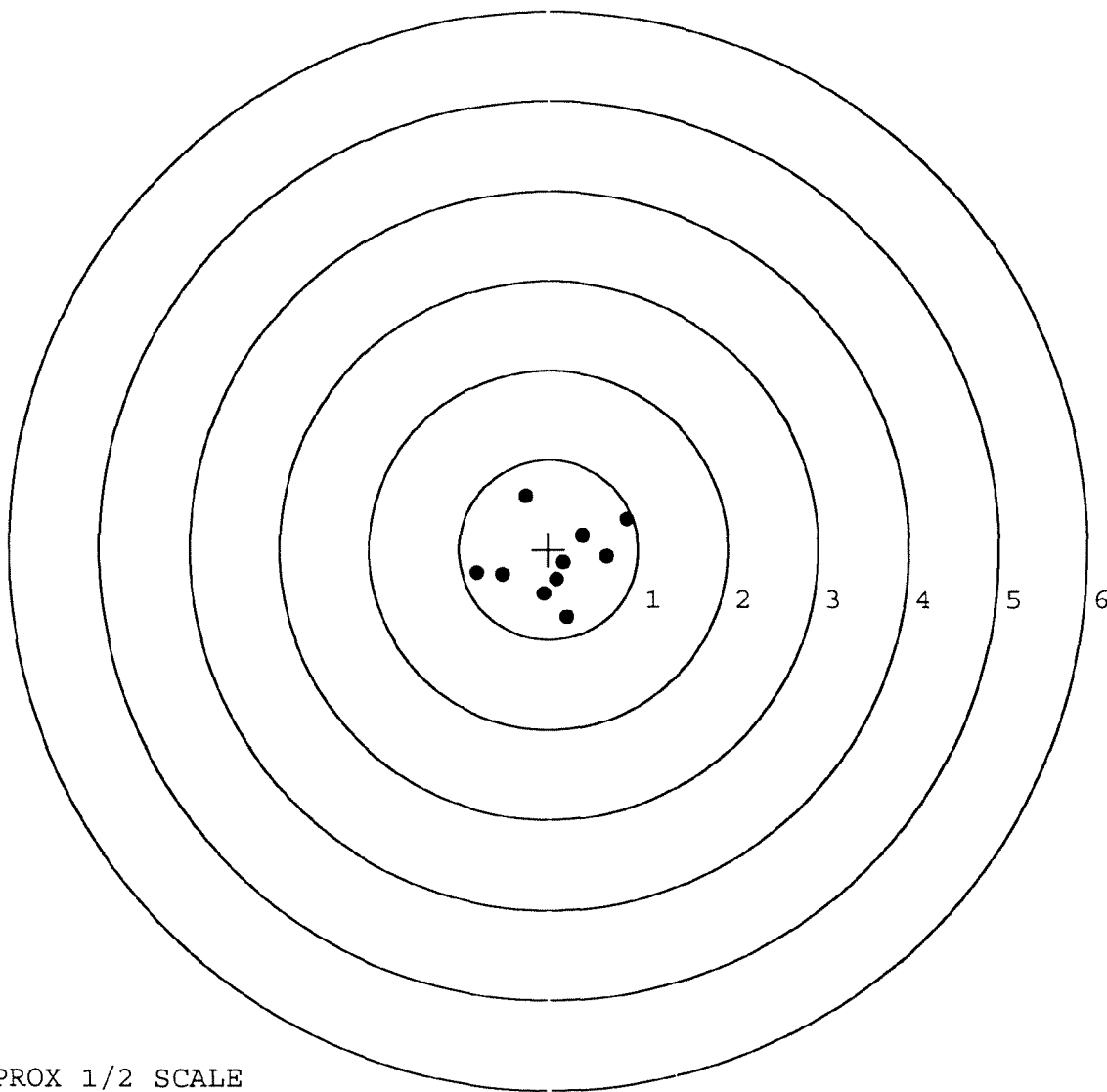
MAX RADIUS: 0.924

MEAN RADIUS: 0.554

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

Repair Inquiry

Repair Number: RE00123776

Serial: C6522319 Model M24 SWS Center Fire
Caliber: 308

Repairman:

Status: Closed 1/17/2007 9:35:59 AM

Verify Repair

Address Information

Customer:

☒ Received From

Return To:

☐ Received From

Name: CO A(-) 5TH BN 19TH SFG(A)

CO A(-) 5TH BN 19TH SFG(A)

Address 1: ATTN: SSG DONAT (SUPPLY)

ATTN: SSG DONAT (SUPPLY)

Address 2: 4203 SARATOGA AVE SUITE

PO Box:

4203 SARATOGA AVE SUITE

PO Box:

City: JFTB LOS ALAMITOS

JFTB LOS ALAMITOS

State: CA

Zip Code: 90720

Country: US

State: CA

Zip Code: 90720

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
A006	Sling Strap	1
A007	With Stud	3
A010	Hard Case	1
A017	Scope Base	3
A026	Scope	1
A045	Bi Pod	1
A055	Deployment Kit	1

Repair Search

Refresh

Close

maglet

1/17/2007

10:10 AM

CAPS

NUM

INS

SCRL



10:10 AM

Serial Number: C6522319

Model: M24 SWS



RE00123776

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6522319.___0
FILE DATE AND TIME: 01/31/2007 12:57

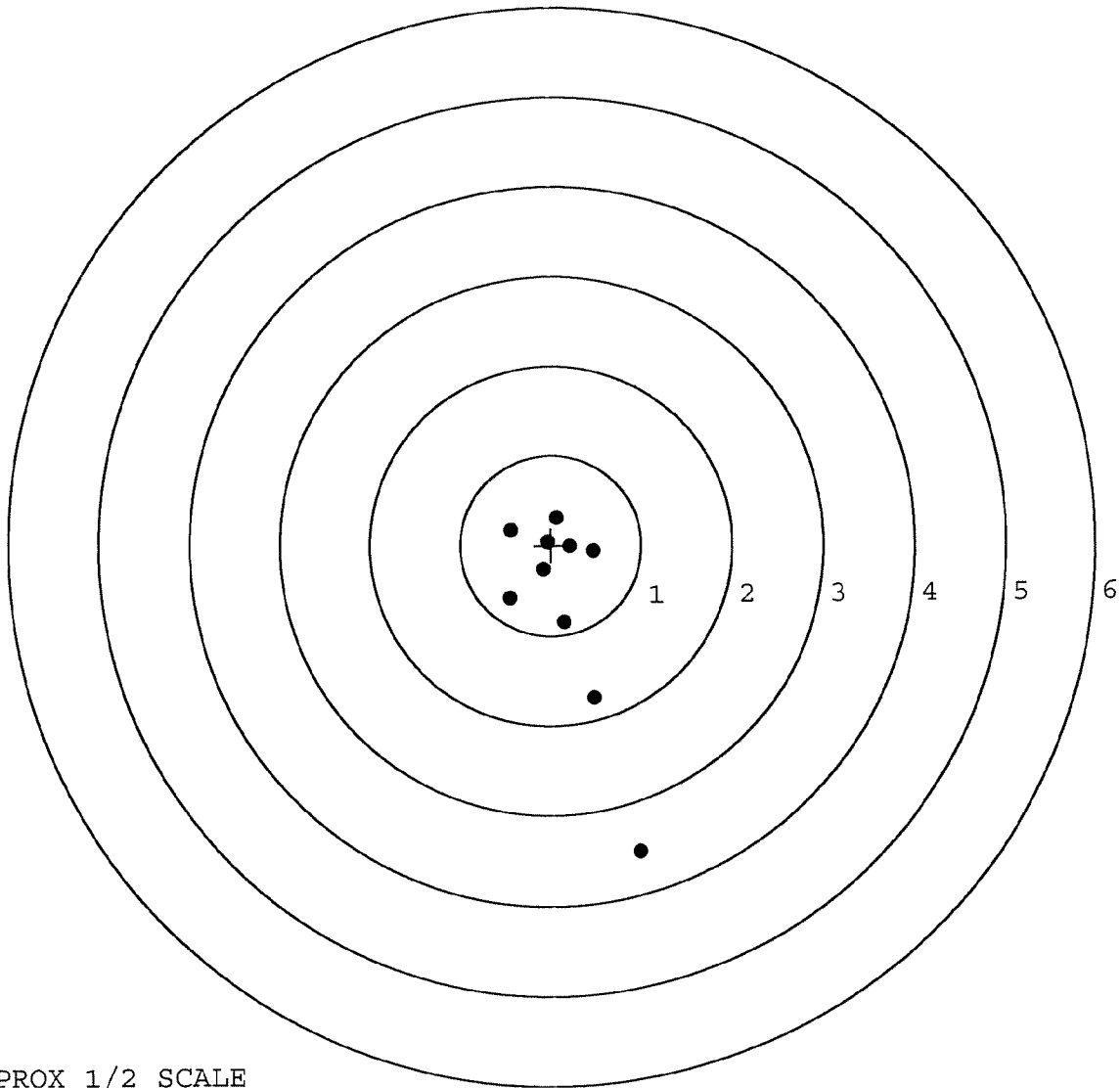
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.015
The Average Y Centroid of the Five Target Set:	-0.121
The Average Point of Impact of the Five Target Set:	0.121
The Average Mean Radius of the Five Target Set:	0.707
The Distance from POA to Centroid Target #1:	0.653
The Distance from Centroid Target #2 to Centroid Target #1:	0.729
The Distance from Centroid Target #3 to Centroid Target #1:	0.674
The Distance from Centroid Target #4 to Centroid Target #1:	0.639
The Distance from Centroid Target #5 to Centroid Target #1:	0.627

SERIAL NUMBER: C6522319. 0
 TARGET NUMBER: 1
 FILE DATE: 01/31/2007
 FILE TIME: 12:57

X CENTROID: 0.128
 Y CENTROID: -0.640
 POA TO CENTROID: 0.653
 HORZ SPREAD: 1.424
 VERT SPREAD: 3.709
 GROUP SPREAD: 3.846
 MIN RADIUS: 0.221
 MAX RADIUS: 2.892
 MEAN RADIUS: 0.916
 # IN 1 IN DIAMETER: 2
 # IN 2 IN DIAMETER: 8
 # in 3 IN DIAMETER: 9

POINT#	X	Y
1:	0.470	-1.696
2:	0.146	-0.860
3:	0.468	-0.071
4:	-0.457	-0.582
5:	-0.444	0.170
6:	-0.092	-0.273
7:	0.207	-0.017
8:	-0.043	0.034
9:	0.062	0.301
10:	0.967	-3.408



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6522319. __0

TARGET NUMBER: 2

FILE DATE: 01/31/2007

FILE TIME: 12:57

POINT#	X	Y
1:	0.845	1.067
2:	-0.099	0.626
3:	-0.214	0.434
4:	-0.377	-0.015
5:	-0.569	-0.545
6:	-0.274	-0.563
7:	0.555	0.209
8:	0.235	0.178
9:	0.345	-0.285
10:	0.154	-0.246

X CENTROID: 0.060

Y CENTROID: 0.086

POA TO CENTROID: 0.105

HORZ SPREAD: 1.414

VERT SPREAD: 1.630

GROUP SPREAD: 2.144

MIN RADIUS: 0.198

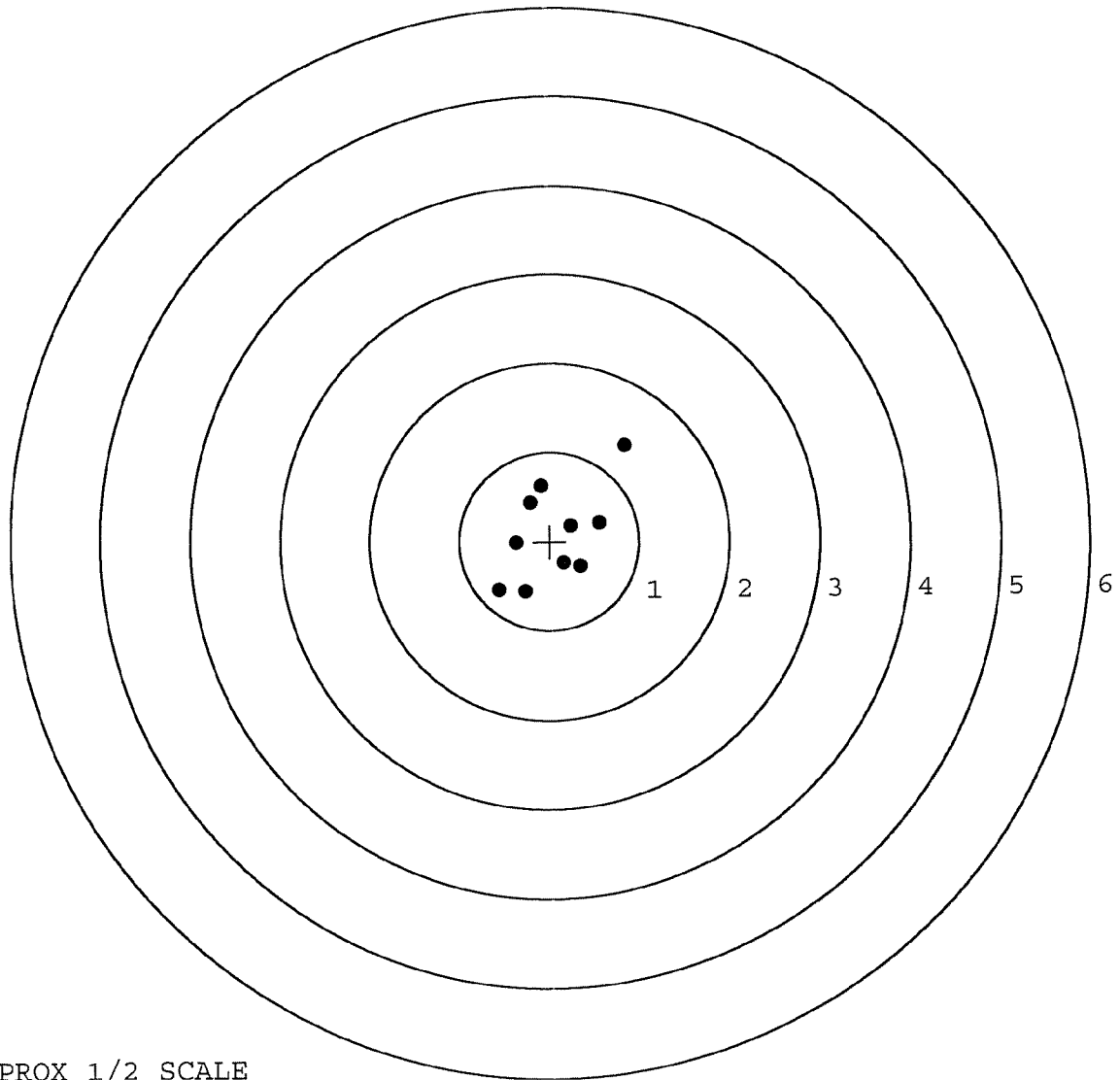
MAX RADIUS: 1.256

MEAN RADIUS: 0.585

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10

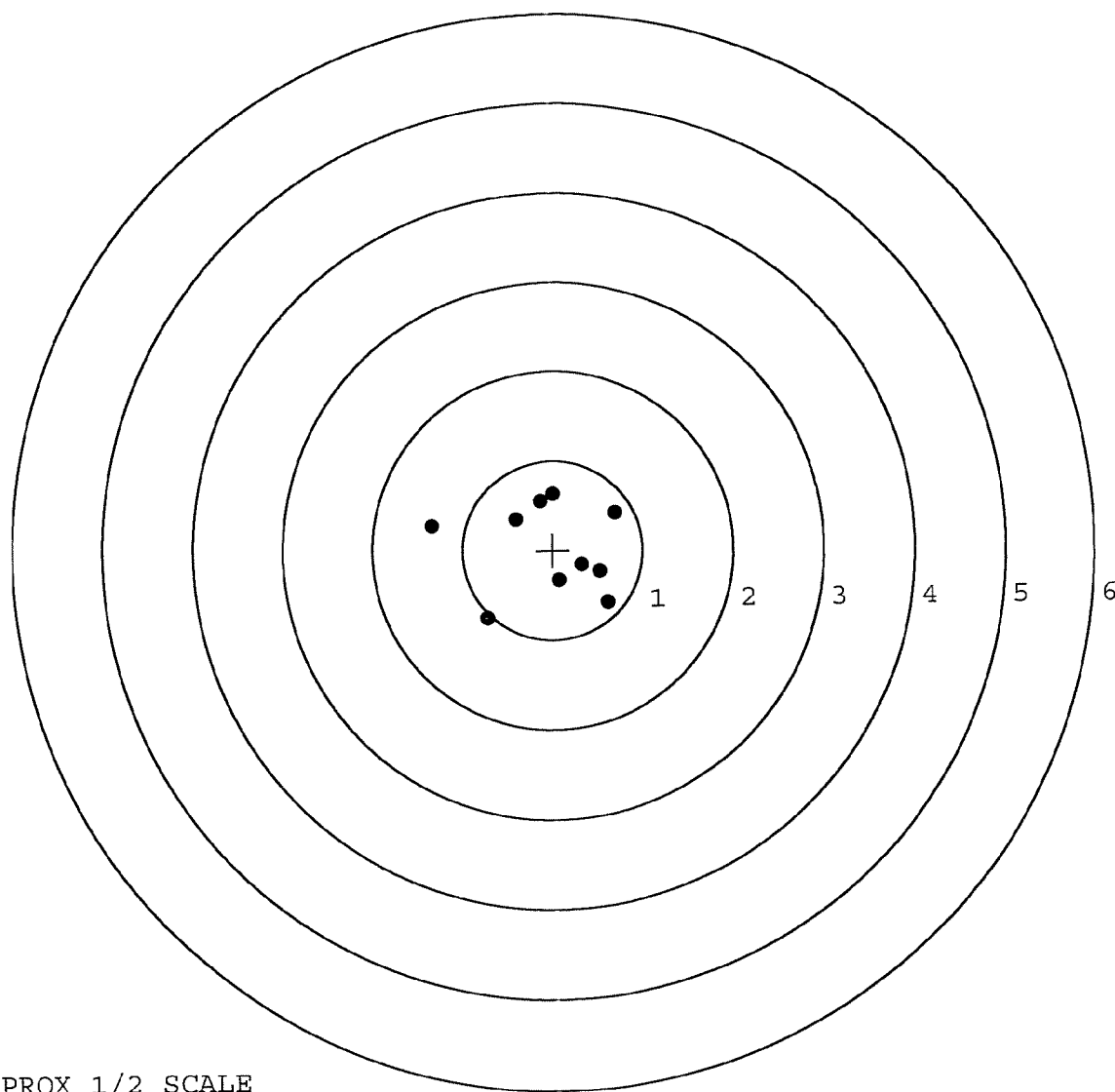


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6522319. __0
 TARGET NUMBER: 3
 FILE DATE: 01/31/2007
 FILE TIME: 12:57

POINT#	X	Y
1:	0.610	-0.588
2:	0.521	-0.244
3:	0.321	-0.171
4:	0.071	-0.340
5:	0.694	0.415
6:	0.009	0.629
7:	-0.411	0.349
8:	-0.135	0.550
9:	-0.728	-0.759
10:	-1.338	0.283

X CENTROID: -0.039
 Y CENTROID: 0.012
 POA TO CENTROID: 0.041
 HORZ SPREAD: 2.032
 VERT SPREAD: 1.388
 GROUP SPREAD: 2.134
 MIN RADIUS: 0.369
 MAX RADIUS: 1.327
 MEAN RADIUS: 0.714
 # IN 1 IN DIAMETER: 2
 # IN 2 IN DIAMETER: 8
 # in 3 IN DIAMETER: 10

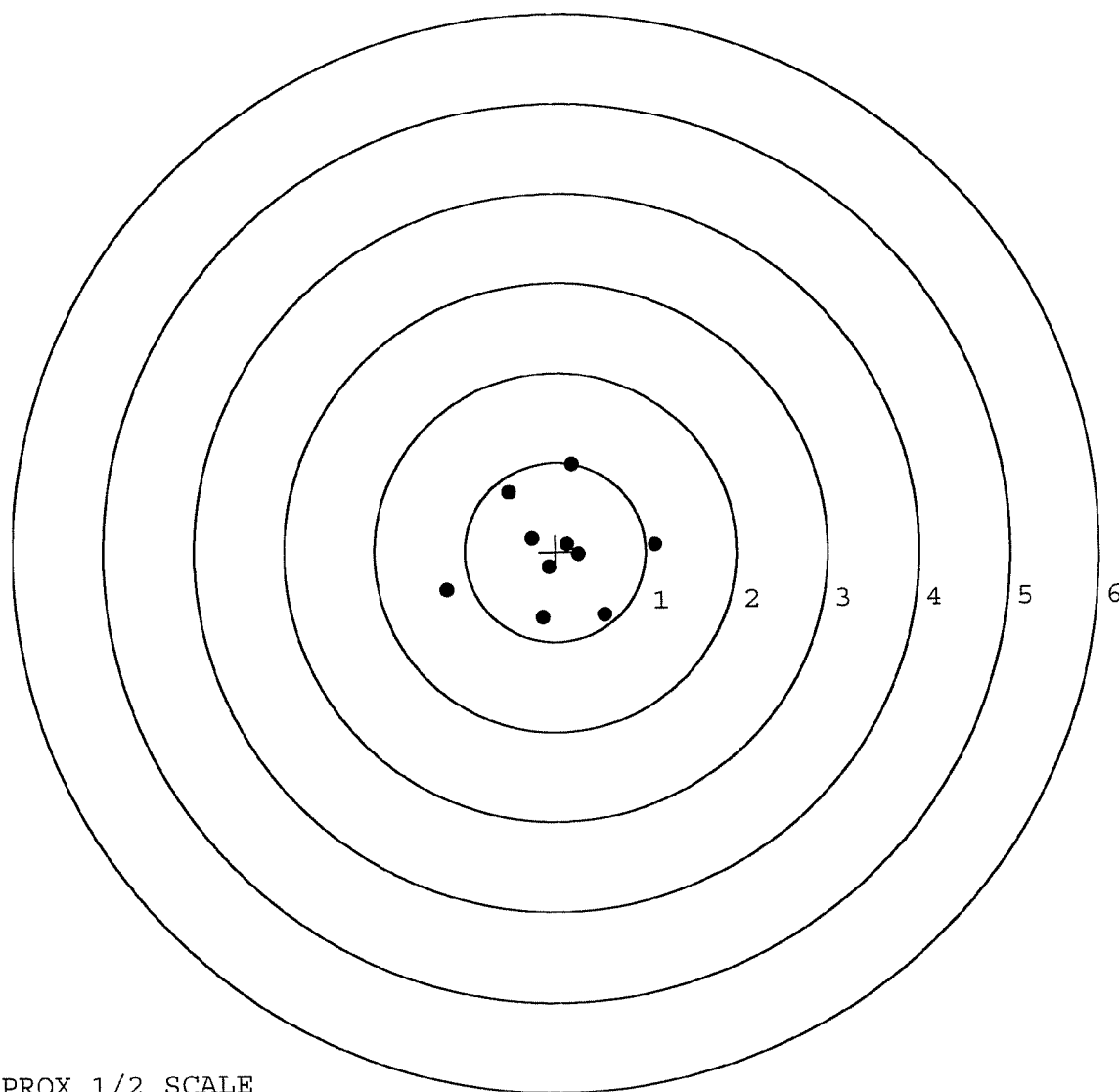


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6522319. __0
 TARGET NUMBER: 4
 FILE DATE: 01/31/2007
 FILE TIME: 12:57

POINT#	X	Y
1:	0.191	0.976
2:	-0.512	0.670
3:	-1.201	-0.420
4:	1.100	0.070
5:	0.543	-0.710
6:	-0.153	-0.739
7:	0.255	-0.038
8:	-0.080	-0.179
9:	0.129	0.084
10:	-0.261	0.151

X CENTROID: 0.001
 Y CENTROID: -0.014
 POA TO CENTROID: 0.014
 HORZ SPREAD: 2.301
 VERT SPREAD: 1.715
 GROUP SPREAD: 2.353
 MIN RADIUS: 0.161
 MAX RADIUS: 1.269
 MEAN RADIUS: 0.677
 # IN 1 IN DIAMETER: 4
 # IN 2 IN DIAMETER: 7
 # in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6522319. __0

TARGET NUMBER: 5

FILE DATE: 01/31/2007

FILE TIME: 12:57

POINT#	X	Y
1:	-1.312	0.830
2:	0.378	0.843
3:	0.144	0.341
4:	0.388	-1.150
5:	0.543	-0.367
6:	-0.131	-0.470
7:	0.136	-0.242
8:	-0.564	-0.114
9:	-0.306	0.015
10:	-0.026	-0.159

X CENTROID: -0.075

Y CENTROID: -0.047

POA TO CENTROID: 0.089

HORZ SPREAD: 1.855

VERT SPREAD: 1.993

GROUP SPREAD: 2.610

MIN RADIUS: 0.122

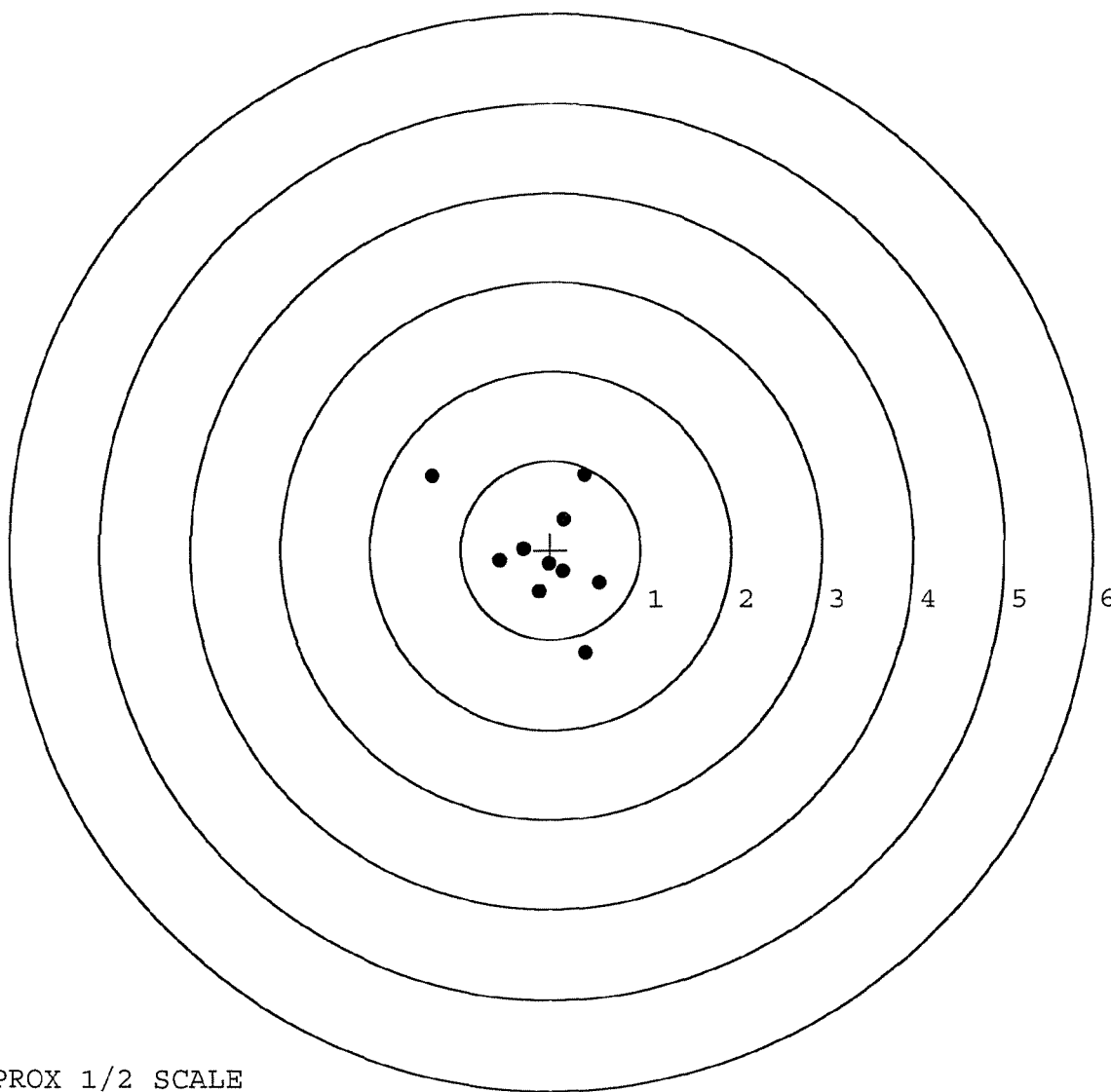
MAX RADIUS: 1.517

MEAN RADIUS: 0.642

IN 1 IN DIAMETER: 6

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

INSPECTION CHECKLIST - REPAIRS

CONTRACT #: DAAE-20-02-C-0149

R & E NUMBER	123776		
SERIAL NUMBER	C6522319		
LOG-IN DATE	1-17-07		
OPERATION #	OPERATION NAME	DATE	INITIAL
500	DIS-ASSEMBLE GUN	1-18-07	RTZ
505	RE-BARREL	1-19-07	RTZ
420	ASSEMBLE	1-19-07	RTZ
440	PROOF	MAGNA-FLUX INSPECTED 1-19-07	RP
460	CHECK HEADSPACE		
470	DIS-ASSEMBLE GUN	JAN 23 2007 1-22-07	RTZ
480	MAGNAFLUX	OPERATOR <u>API</u> 1-23-07	APD
510	DRILL AND TAP	1-22-07	FM
500	ROLLMARK CALIBER	1-23-07	CW
520	GOFF BLAST BBL / REC	1-23-07	LB
530 & 540	APPLY COATINGS	1-25-07	WJ
560	FINAL ASSEMBLY	1-30-07	RTZ
640	FUNCTION TEST AND	PASS FAIL 1/30/07	WJ
650	TARGET	PASS FAIL 1/30/07	WJ
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
670	FINAL INSPECTION	1-30-07	TRW
	A) HEADSPACE	PASS FAIL 2-2-07	RTZ
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS 2.32 2.32 2.42 2.44 2.32 1-31-07	TRW
680	F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX 5.5 5.5 5.5 1-31-07	TRW
	G) SAFETY OFF FORCE	2 LBS MIN 2.25 2.25 2.25 1-31-07	TRW
	I) FIRING PIN INDENT	.020 .025 .025 .025 1-31-07	TRW
690	PACK	2-8-07	DA

F006 REV 5/2006

BARREL ASSEMBLY

BARREL_____
RECEIVER_____
FRONT SIGHT BASE_____
REAR SIGHT BASE_____
SCREWS_____
FINISH

STOCK ASSEMBLY

STOCK_____
SLING SWIVEL STUDS_____
BUTT PATE_____
LOCK NUTS_____
BARREL CLEARANCE_____
COLOR / FINISH

SCOPE ASSEMBLY

SCOPE_____
SCOPE RINGS_____
MOUNTING SCREWS_____
MOUNTING BASE_____
SCREWS_____
FINISH_____
CLARITY

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:		RE00033802				Serial: C6522319 Model 700 Center Fire Caliber: 7.62 NATO M-24 (SW)		Repairman:	
Verify Repair						Status:		Closed 10/11/01 2:43:53 PM	
Address Information									
Customer: ☒ Received From					Return To: ☐ Received From				
Name: CO A(-) 5TH BN 19TH SFG(A)					CO A(-) 5TH BN 19TH SFG(A)				
Address 1: ATTN: SSG DONAT (SUPPLY)					ATTN: SSG DONAT (SUPPLY)				
Address 2: 4203 SARATOGA AVE SUITE PO Box:					4203 SARATOGA AVE SUITE PO Box:				
City: JFTB LOS ALAMITOS					JFTB LOS ALAMITOS				
State: CA Zip Code: 90720 Country: US					State: CA Zip Code: 90720 Country: US				
FFL: ☐ ☐ ☐ ☐ ☐									
Contact / Condition Problems Estimate History / Status Shipping / Billing									
Contact Information					Received Condition			Accessories Received	
Phone:					Fair			Code Desc Qty	
Fax:					Condition Notes:			AOC7 With Stud 1	
Email:					CSR Notes:			AOC9 Soft Case 1	
Comments:								X L/F-PIN ASSY 1	
								XX L/GUARD SCREWS 2	
								XXX W/ SM ACCESSORY 1	
Repair Search Refresh Close									
naglej 10/11/01 3:29 PM CAPS NUM NS SCHL									
Start End Print Save In Out P Di 3:29 PM									

Serial Number: C6522319

Model: 700



RE00033802

Remington Test Lab, Ilion, N.Y.

Centroidal distance calculations for Rifle # c6522319
19 Oct 2001

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .3446
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0852
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .354976

THE AMR FOR THIS RIFLE IS: 1.151

CENTROIDAL DISTANCES

Ø TO	1	1.23696
1 TO	2	.848869
1 TO	3	1.50094
1 TO	4	1.19673
1 TO	5	1.28437

5
4 <----POA
3 2

REMINGTON CENTERFIRE ACCURACY TEST

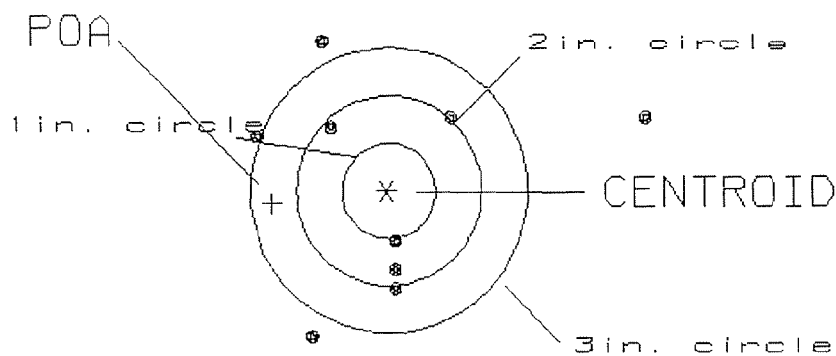
REMINGTON TEST LAB, ILION, N.Y.

PATTERN #: ☐ 1 ☐
 POA TO CENTROID: 1.237
 MIN RADIUS : .510
 MEAN RADIUS : 1.268
 MAX RADIUS : 2.847
 CENTROID X : 1.230
 CENTROID Y : .131

18 Oct 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/C6522319

CENTERFIRE PATTERN # 1



OF SHOTS= 10

IN CIRCLE

HS= 4.12

0

VS= 3.17

5

GS= 4.27

7

REMINGTON CENTERFIRE ACCURACY TEST

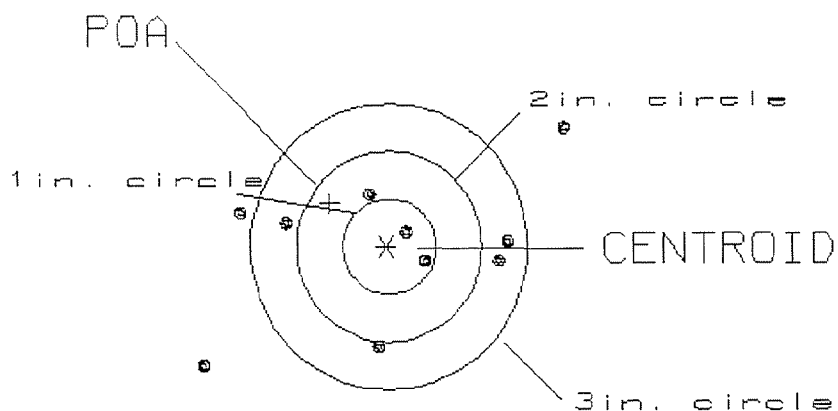
REMINGTON TEST LAB, ILION, N.Y.

PATTERN #: ☐ 2 ☐
 POA TO CENTROID: .761
 MIN RADIUS : .241
 MEAN RADIUS : 1.215
 MAX RADIUS : 2.369
 CENTROID X : .613
 CENTROID Y : -.452

18 Oct 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/C6522319

CENTERFIRE PATTERN # 2



OF SHOTS= 10

IN CIRCLE

HS= 3.89
 VS= 2.53
 GS= 4.64

2
 3
 7

REMINGTON CENTERFIRE ACCURACY TEST

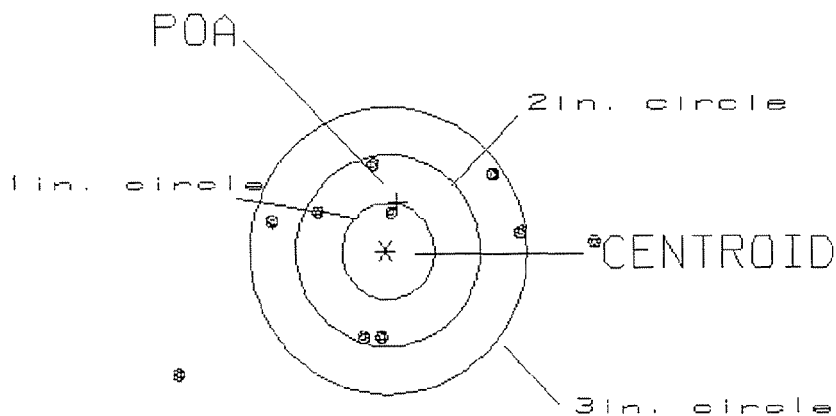
REMINGTON TEST LAB, ILION, N.Y.

PATTERN #: □ 3 □
 POA TO CENTROID: .520
 MIN RADIUS : .401
 MEAN RADIUS : 1.301
 MAX RADIUS : 2.646
 CENTROID X : -.130
 CENTROID Y : -.504

19 Oct 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/C6522319

CENTERFIRE PATTERN # 3



OF SHOTS= 10

IN CIRCLE

HS= 4.58
 VS= 2.16
 GS= 4.77

1
 5
 8

REMINGTON CENTERFIRE ACCURACY TEST

REMINGTON TEST LAB, ILION, N.Y.

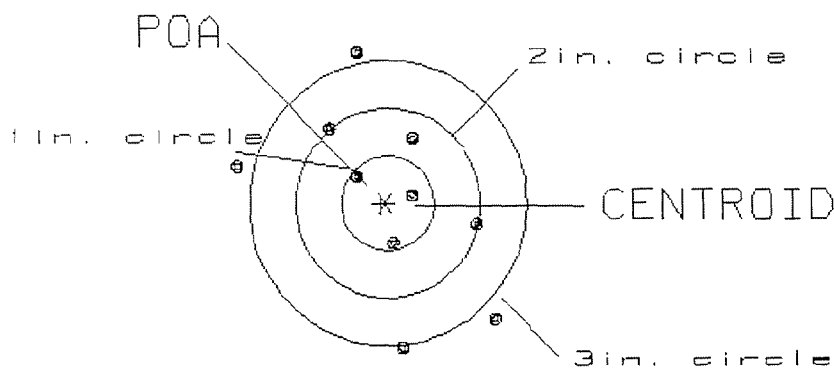
PATTERN #: ☐ 4 ☐

POA TO CENTROID: .041
 MIN RADIUS : .271
 MEAN RADIUS : .982
 MAX RADIUS : 1.717
 CENTROID X : .039
 CENTROID Y : .014

18 Oct 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/C6522319

CENTERFIRE PATTERN # 4



OF SHOTS= 11

IN CIRCLE

HS= 2.80

4

VS= 3.14

7

GS= 3.24

7

REMINGTON CENTERFIRE ACCURACY TEST

REMINGTON TEST LAB, ILION, N.Y.

PATTERN #: 5

POA TO CENTROID: .386

MIN RADIUS : .012

MEAN RADIUS : .990

MAX RADIUS : 1.708

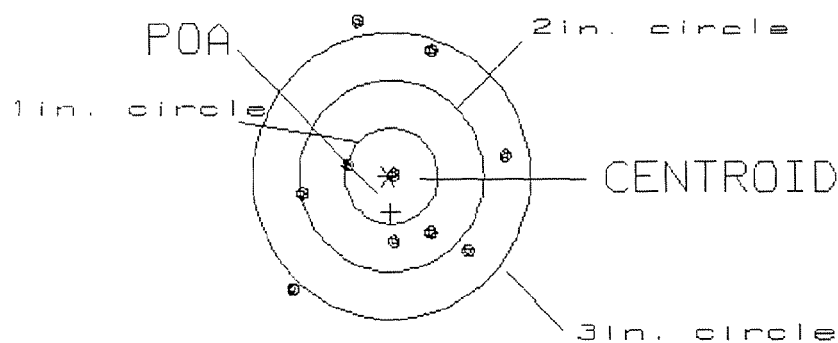
CENTROID X : -.029

CENTROID Y : .385

18 Oct 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/C6522319

CENTERFIRE PATTERN # 5



OF SHOTS= 10

IN CIRCLE

HS= 2.32

2

VS= 2.63

5

GS= 2.92

8

M-24 INSPECTION CHECKLIST
CONTRACT #: DAAE-20-97-C-242

R & E NUMBER 33802			
SERIAL NUMBER C6522319			
LOG-IN DATE 10-11-01			
INSPECT AND VERIFY:			
OPERATION #	OPERATION NAME	DATE	INITIAL
550	DIS-ASSEMBLE GUN	10-16-01	RH
560 A	RE-BARREL AT CUSTOM SHOP		
B	DRILL AND TAP		
C	POLISH		
575	ASSEMBLE	10-18-01	RH
600	PROOF		
605	CHECK HEADSPACE	10-18-01	RH
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	10-18-01	RH
655	FINAL INSPECT	10-19-01	RH
660	PACK	10-19-01	RH
		SHIP DATE	
QAR INSPECTION DATE			

Final Inspection

In: C6522319

DATE REC'D: 10-11-01

DATE RET'D: 10-22-01

EDITOR: *[Signature]*

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: _____

Remington®
REG. U.S. PAT. & TM. OFF.

MODEL 700™ H24

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

SERIAL NO.
C6522319

ORDER NO.
5716

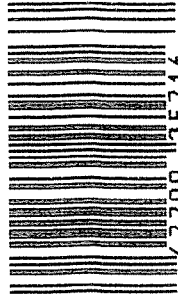
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada. Marque Deposee.

01



5716 C6522319

LPC



0 47700 25716 7

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6522319
7 Sep 1990

CENTROIDAL DISTANCES

0 TO	1	.220227
1 TO	2	.150864
1 TO	3	.0581808
1 TO	4	.17404
1 TO	5	.314379

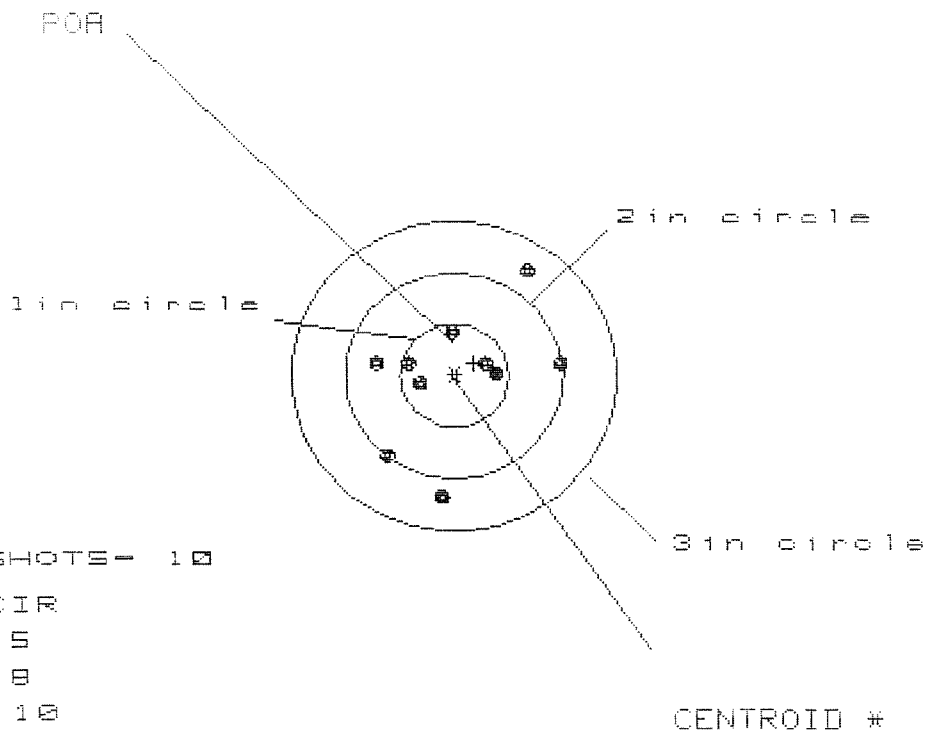
25 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1138
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.048
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .123589
THE AMR FOR THIS RIFLE IS: .7852

7 Sep 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C8522319

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 5

2in = 8

3in = 10

HS= 1.663

VS= 2.198

GS= 2.334

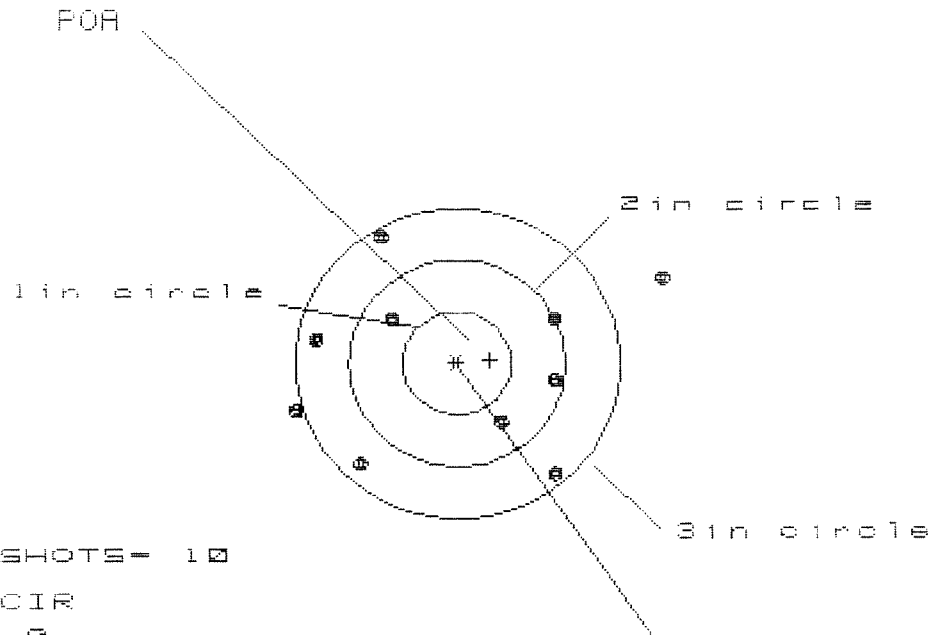
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.962	.949	1.030
MINIMUM X	-.701	-.714	-.633
MAXIMUM Y	.983	.848	.424
MINIMUM Y	-1.215	-.892	-.786
CENTROID X	-.182	-.169	-.250
CENTROID Y	-.124	.011	-.095
POR TO CENTROID in.	.220	.169	.267
MIN RADIUS	.276	.222	.294
MEAN RADIUS	.703	.627	.569
MAX RADIUS	1.221	1.088	1.040
HORIZONTAL SPREAD	1.663	1.663	1.663
VERTICAL SPREAD	2.198	1.740	1.211
EXTREME SPREAD	2.334	2.156	1.824
NUMBER IN ONE INCH CIRCLE =	5		
NUMBER IN TWO INCH CIRCLE =	8		
NUMBER IN THREE INCH CIRCLE =	10		

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CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1 in = 0

2 in = 4

3 in = 8

HS = 3.405

VS = 2.286

GS = 3.631

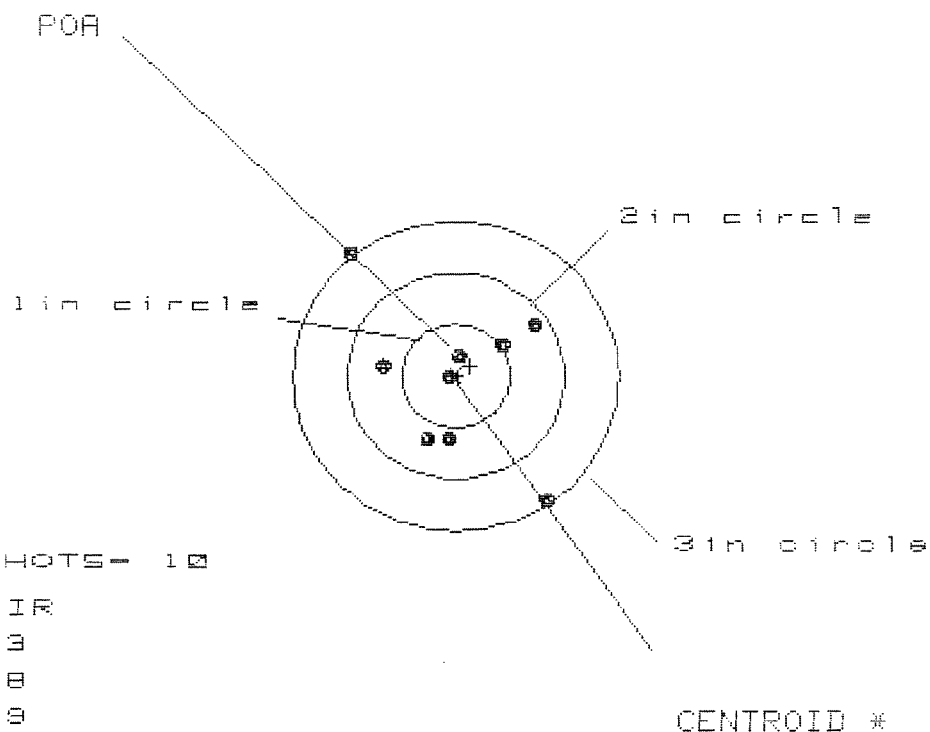
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.887	1.105	.941
MINIMUM X	:	-1.518	-1.308	-1.227
MAXIMUM Y	:	1.249	1.341	1.298
MINIMUM Y	:	-1.037	-.945	-.988
CENTROID X	:	-.300	-.510	-.346
CENTROID Y	:	-.030	-.122	-.079
POR TO CENTROID in.	:	.302	.524	.355
MIN RADIUS	:	.718	.654	.707
MEAN RADIUS	:	1.235	1.131	1.089
MAX RADIUS	:	2.059	1.444	1.439
HORIZONTAL SPREAD	:	3.405	2.413	2.168
VERTICAL SPREAD	:	2.286	2.286	2.286
EXTREME SPREAD	:	3.631	2.762	2.762
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 3

2in = 8

3in = 9

HS= 1.8000

VS= 2.414

GS= 3.011

CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.875	.772	.732
MINIMUM X	:	-.925	-.802	-.705
MAXIMUM Y	:	1.215	.613	.480
MINIMUM Y	:	-1.199	-1.064	-.579
CENTROID X	:	-.131	-.028	-.125
CENTROID Y	:	-.096	-.231	-.098
POA TO CENTROID in.	:	.163	.233	.159
MIN RADIUS	:	.075	.232	.081
MEAN RADIUS	:	.666	.600	.457
MAX RADIUS	:	1.527	1.315	.875
HORIZONTAL SPREAD	:	1.800	1.574	1.437
VERTICAL SPREAD	:	2.414	1.677	1.059
EXTREME SPREAD	:	3.011	2.043	1.485
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	

7 Sep 1990

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CENTERFIRE PATTERNS # 4

POA

1in circle

2in circle

3in circle

OF SHOTS = 10

IN CIR

1in = 5

2in = 9

3in = 9

CENTROID #

HS = 1.485

VS = 2.427

GS = 2.472

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.791	.835	.832
MINIMUM X	:	-.694	-.650	-.653
MAXIMUM Y	:	.956	.793	.416
MINIMUM Y	:	-1.471	-.517	-.418
CENTROID X	:	-.019	-.063	-.060
CENTROID Y	:	-.063	.100	.001
POA TO CENTROID in.	:	.066	.119	.060
MIN RADIUS	:	.083	.105	.018
MEAN RADIUS	:	.613	.479	.437
MAX RADIUS	:	1.524	.983	.931
HORIZONTAL SPREAD	:	1.485	1.485	1.485
VERTICAL SPREAD	:	2.427	1.310	.834
EXTREME SPREAD	:	2.472	1.569	1.559
NUMBER IN ONE INCH CIRCLE	=		5	
NUMBER IN TWO INCH CIRCLE	=		9	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 5

POR

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 3

2in = 8

3in = 10

HS= 1.583

VS= 2.094

GS= 2.138

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.886	.821	.750
MINIMUM X	:	-.697	-.762	-.833
MAXIMUM Y	:	1.173	.519	.420
MINIMUM Y	:	-.921	-.791	-.530
CENTROID X	:	.063	.128	.198
CENTROID Y	:	.073	-.057	.042
POR TO CENTROID in.	:	.097	.140	.203
MIN RADIUS	:	.171	.214	.270
MEAN RADIUS	:	.709	.647	.595
MAX RADIUS	:	1.311	.973	.987
HORIZONTAL SPREAD	:	1.583	1.583	1.583
VERTICAL SPREAD	:	2.094	1.310	.950
EXTREME SPREAD	:	2.138	1.693	1.658
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6522319

DATE 8/31/90

TESTER JS

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	212	225	227	244	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	212	230	216	262	
PULL #3	210	224	202	271	
PULL #4	244	225	210	284	
PULL #5	238	222	215	286	
TOTAL	1116	1126			
AVG.	2232	2252			

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	304	286		
PULL #2	302	288		
PULL #3	301	281		
PULL #4	283	285		
PULL #5	288	283		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	405	399		389
PULL #2	401	394		390
PULL #3	402	399		387
PULL #4	397	400		408
PULL #5	398	399		391
TOTAL				
AVG.				

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6522319

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	8 2	90	RW
600	Proof	8 2	90	RW
607	Check Headspace	8 2	90	RW
610	Dis-assemble Gun	8 2	90	RW
612	Magnaflux Barrel Action		8/7/90	KR
	Magnaflux Bolt		8/7/90	KR
615	Rollmark Caliber		8/7/90	GL
617	Drill and Tap Sight Holes		8/10/90	LB
618	Polish Barrel RB		8/14/90	WB
620	Apply Coatings (Barrel Action)		8/24/90	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/27/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/27/90	RW
	C) Inspect Ejector Hole for Chamfer		8/27/90	RW
	D) Oil Firing Pin Ass'y		8/27/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		8/31/90	GB

op. #	OP. NAME	READINGS			DATE	INIT		
625 cont.	F) Safety On Force	3 3/4	4	3 3/4	9/3/90	WB		
	G) Safety Off Force	2	2	2	9/5/90	WB		
	H) Trigger Pull Test & Retainability				8/31/90	GL		
	I) Firing Pin Indent	.022	.022	.022	9/5/90	WB		
	J) Assemble Stock				9/5/90	RW		
	K) Assemble Swivel Studs				9/6/90	JSB		
	L) Attach Front and Rear Sight Assemblies				9/5/90	RW		
	M) Iron Sight Alignment				9/5/90	RW		
	N) Detach Front & Rear Sights & place in numbered container				9/5/90	RW		
	O) Attach Scope to Rifle				9/6/90	RW		
	P) Detach & Attach Scope 20 Times				9/5/90	RW		
640	Gallery Target & Test				9-7-90	DH		
	A) Time				9-7-90	DH		
	B) Malfunctions				9-7-90	DH		
	C) Pierced Primers				9-7-90	DH		
	D) Optical Clarity of Scope				9-7-90	DH		
645	Inspect for Live Ammo				9-7-90	DH		
655	Final Inspection							
	A) Headspace				9/9/90	JSB		
	B) Trigger Pull	244	262	271	284	284	9/9/90	JSB
	C) Function						9/9/90	JSB
660	Pack						9-9-90	DH