

4-1

C6498872

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

Repair Inquiry

Repair Number: RE00128530

Serial: C6498872 Model M24 SWS Center Fire
Caliber: 7.62 NATO

Repairman:

Status: New 4/24/2007 7:33:30 AM

Verify Repair

Address Information

Customer:

Received From

Return To:

Received From

Name: ISSD ARMSROOM

ISSD ARMSROOM

Address 1: 8TH DESERT STORM

8TH DESERT STORM

Address 2: BLDG 5210 BAY DOOR #30

PO Box:

BLDG 5210 BAY DOOR #30

PO Box:

City: FORT CAMPBELL

FORT CAMPBELL

State: KY

Zip Code: 42223

Country: US

State: KY

Zip Code: 42223

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
A010	Hard Case	1
A017	Scope Base	1
A026	Scope	1
A045	Bi Pod	1
A057	Fit and Rear Sgt Base	1

Repair Search

Refresh

Close

naglelj

4/24/2007

8:09 AM

CAPS

NUM

INS

SCRL

start

3 Mi...

5 In...

Arms ...

Part ...

6 Mi...

2 W...

8:09 AM

Serial
Number:

C6498872

Model: M24 SWS



RE00128530

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6498872.__0

FILE DATE AND TIME: 06/01/2007 15:36

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.079
The Average Y Centroid of the Five Target Set:	-0.030
The Average Point of Impact of the Five Target Set:	0.084
The Average Mean Radius of the Five Target Set:	0.642
The Distance from POA to Centroid Target #1:	0.224
The Distance from Centroid Target #2 to Centroid Target #1:	0.272
The Distance from Centroid Target #3 to Centroid Target #1:	0.143
The Distance from Centroid Target #4 to Centroid Target #1:	0.145
The Distance from Centroid Target #5 to Centroid Target #1:	0.273

SERIAL NUMBER: C6498872. 0

TARGET NUMBER: 1

FILE DATE: 06/01/2007

FILE TIME: 15:36

X CENTROID: -0.224

Y CENTROID: 0.008

POA TO CENTROID: 0.224

HORZ SPREAD: 1.393

VERT SPREAD: 1.789

GROUP SPREAD: 1.792

MIN RADIUS: 0.132

MAX RADIUS: 1.138

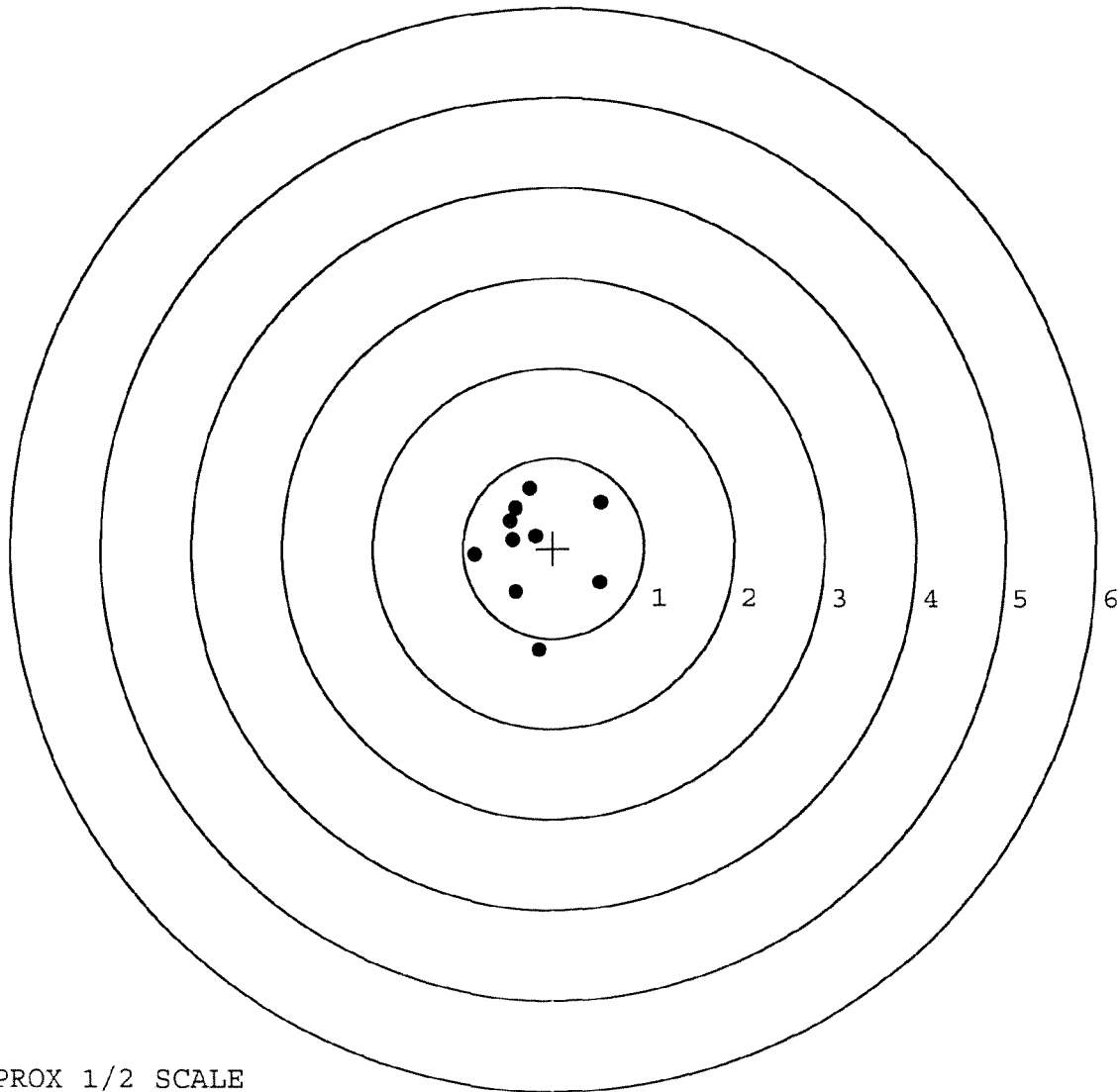
MEAN RADIUS: 0.595

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.522	0.504
2:	0.518	-0.382
3:	-0.416	-0.481
4:	-0.163	-1.128
5:	-0.871	-0.067
6:	-0.457	0.095
7:	-0.203	0.139
8:	-0.484	0.303
9:	-0.421	0.441
10:	-0.264	0.661



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6498872. __0

TARGET NUMBER: 2

FILE DATE: 06/01/2007

FILE TIME: 15:36

POINT#	X	Y
1:	-0.600	0.505
2:	0.072	1.041
3:	0.397	0.641
4:	0.594	-0.150
5:	0.665	-0.343
6:	0.131	-0.775
7:	-0.598	-0.684
8:	-0.321	-0.241
9:	-0.015	-0.041
10:	0.151	0.114

X CENTROID: 0.048

Y CENTROID: 0.007

POA TO CENTROID: 0.048

HORZ SPREAD: 1.265

VERT SPREAD: 1.816

GROUP SPREAD: 1.851

MIN RADIUS: 0.079

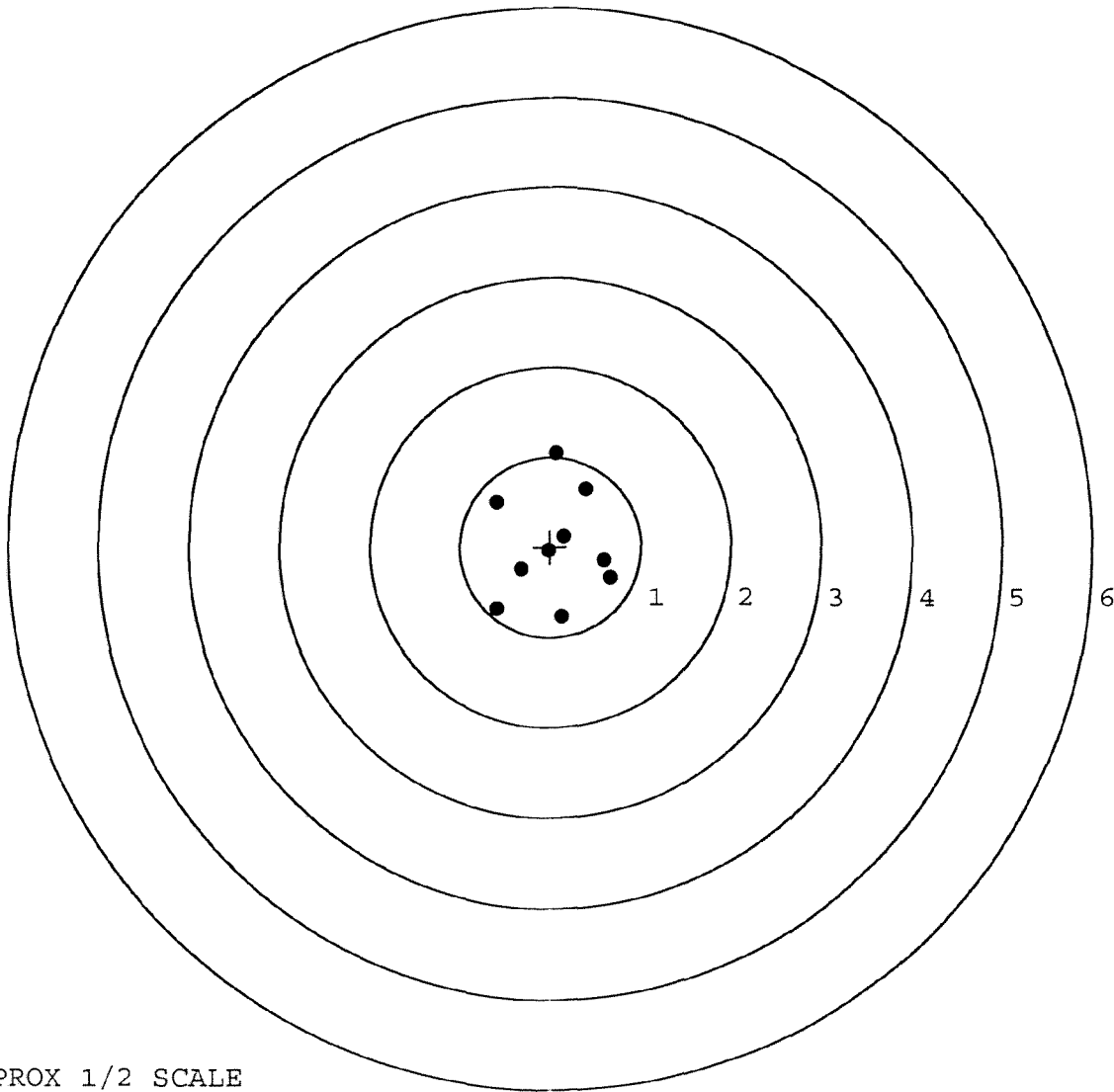
MAX RADIUS: 1.035

MEAN RADIUS: 0.626

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10

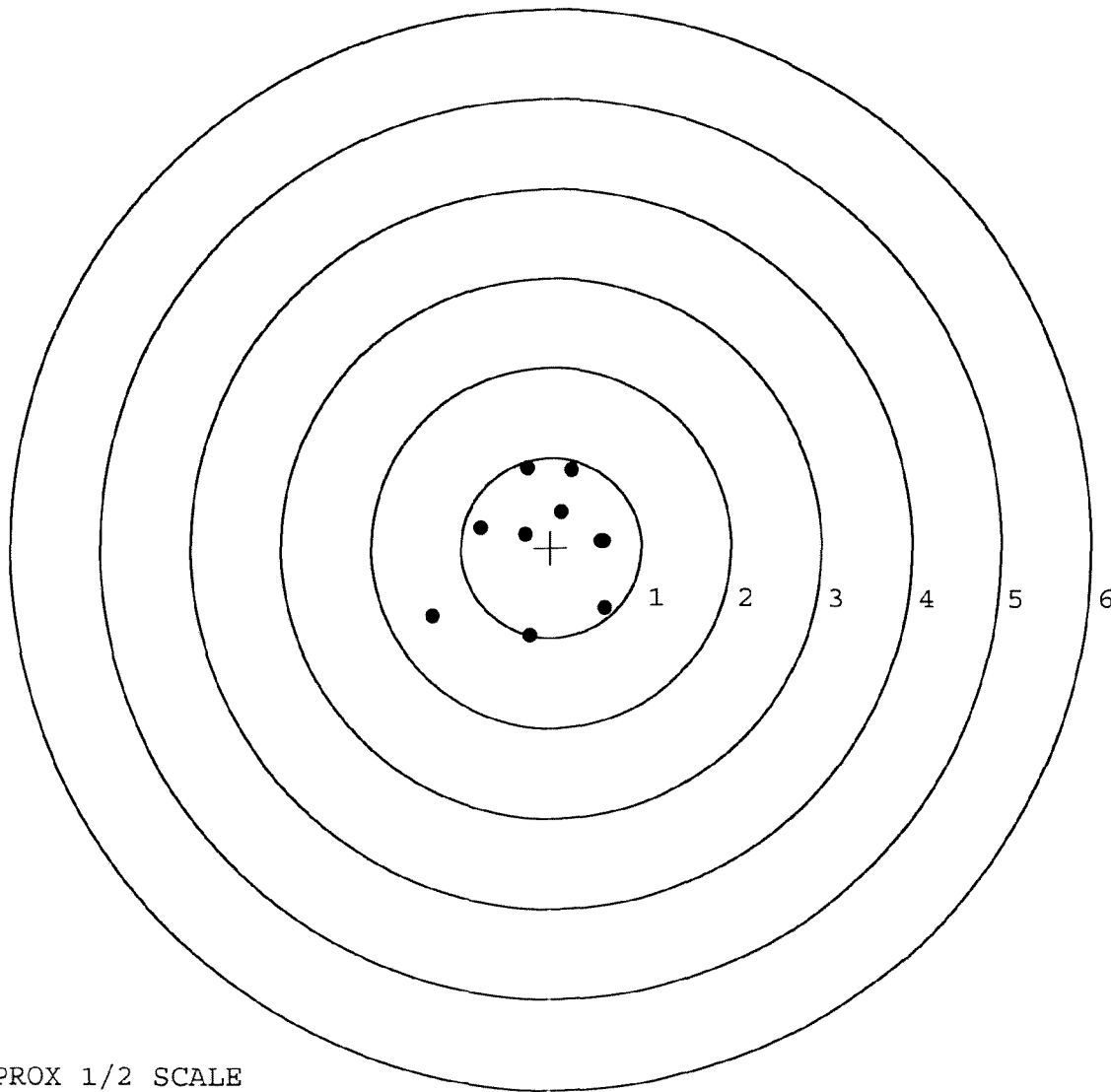


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6498872. __0
 TARGET NUMBER: 3
 FILE DATE: 06/01/2007
 FILE TIME: 15:36

POINT#	X	Y
1:	-0.261	0.887
2:	0.117	0.398
3:	0.228	0.861
4:	-0.292	0.151
5:	-0.783	0.224
6:	-1.318	-0.774
7:	-0.237	-0.982
8:	0.597	-0.674
9:	0.550	0.076
10:	0.580	0.077

X CENTROID: -0.082
 Y CENTROID: 0.024
 POA TO CENTROID: 0.085
 HORZ SPREAD: 1.915
 VERT SPREAD: 1.869
 GROUP SPREAD: 2.250
 MIN RADIUS: 0.245
 MAX RADIUS: 1.472
 MEAN RADIUS: 0.793
 # IN 1 IN DIAMETER: 2
 # IN 2 IN DIAMETER: 8
 # in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6498872. __0

TARGET NUMBER: 4

FILE DATE: 06/01/2007

FILE TIME: 15:36

POINT#	X	Y
1:	0.692	-0.012
2:	0.906	-0.675
3:	-0.205	-0.735
4:	-0.670	-0.407
5:	-0.744	-0.067
6:	-0.598	0.277
7:	-0.318	0.281
8:	-0.030	0.233
9:	0.014	0.414
10:	0.157	0.858

X CENTROID: -0.080

Y CENTROID: 0.017

POA TO CENTROID: 0.081

HORZ SPREAD: 1.650

VERT SPREAD: 1.593

GROUP SPREAD: 1.780

MIN RADIUS: 0.222

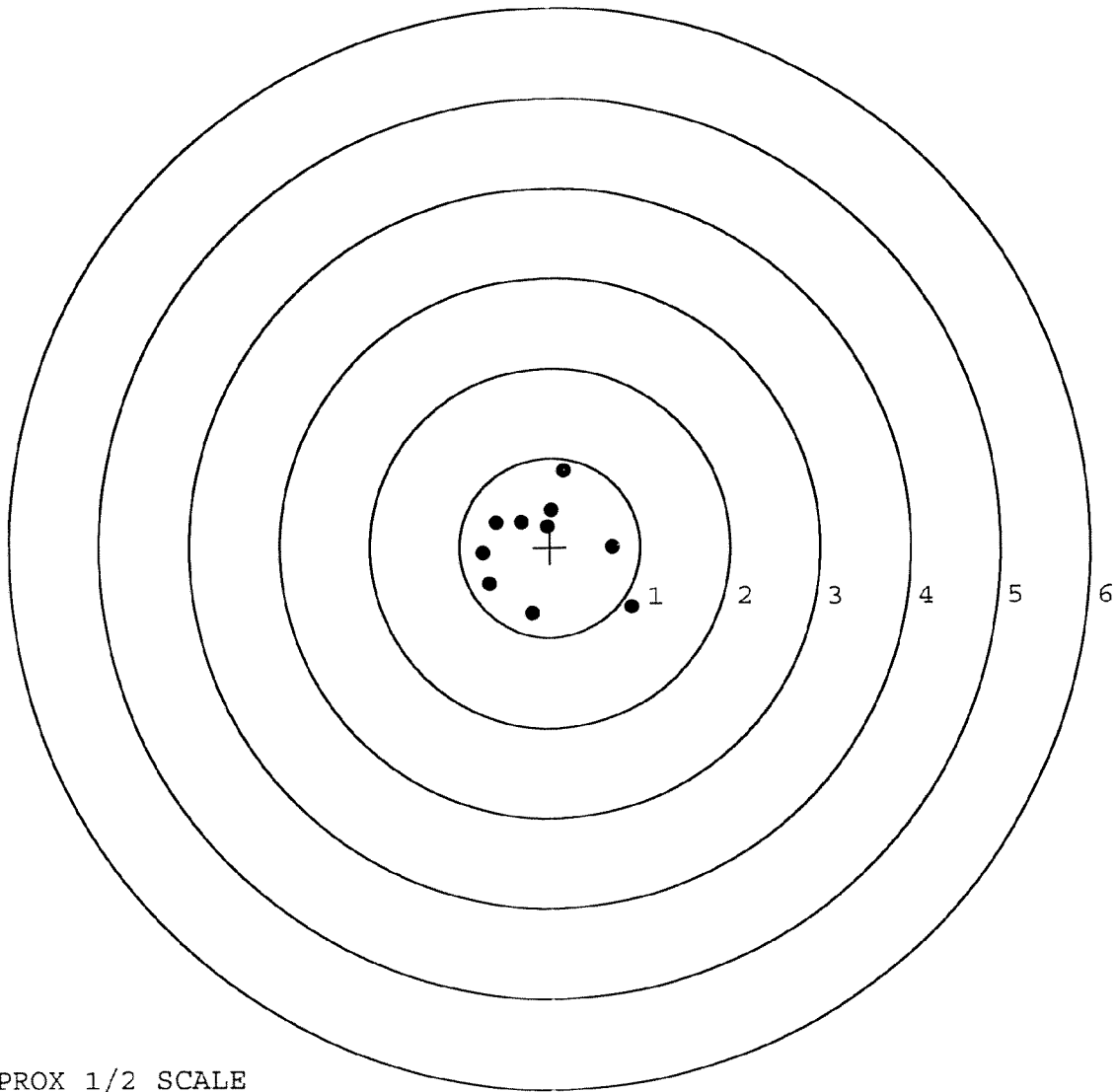
MAX RADIUS: 1.204

MEAN RADIUS: 0.657

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6498872. __0

TARGET NUMBER: 5

FILE DATE: 06/01/2007

FILE TIME: 15:36

POINT#	X	Y
1:	-0.238	0.324
2:	-0.031	0.146
3:	0.688	0.261
4:	0.295	-0.191
5:	-0.107	-0.070
6:	-0.292	-0.328
7:	-0.391	-0.474
8:	-0.643	-0.427
9:	0.167	-1.526
10:	-0.005	0.216

X CENTROID: -0.056

Y CENTROID: -0.207

POA TO CENTROID: 0.214

HORZ SPREAD: 1.331

VERT SPREAD: 1.850

GROUP SPREAD: 1.894

MIN RADIUS: 0.146

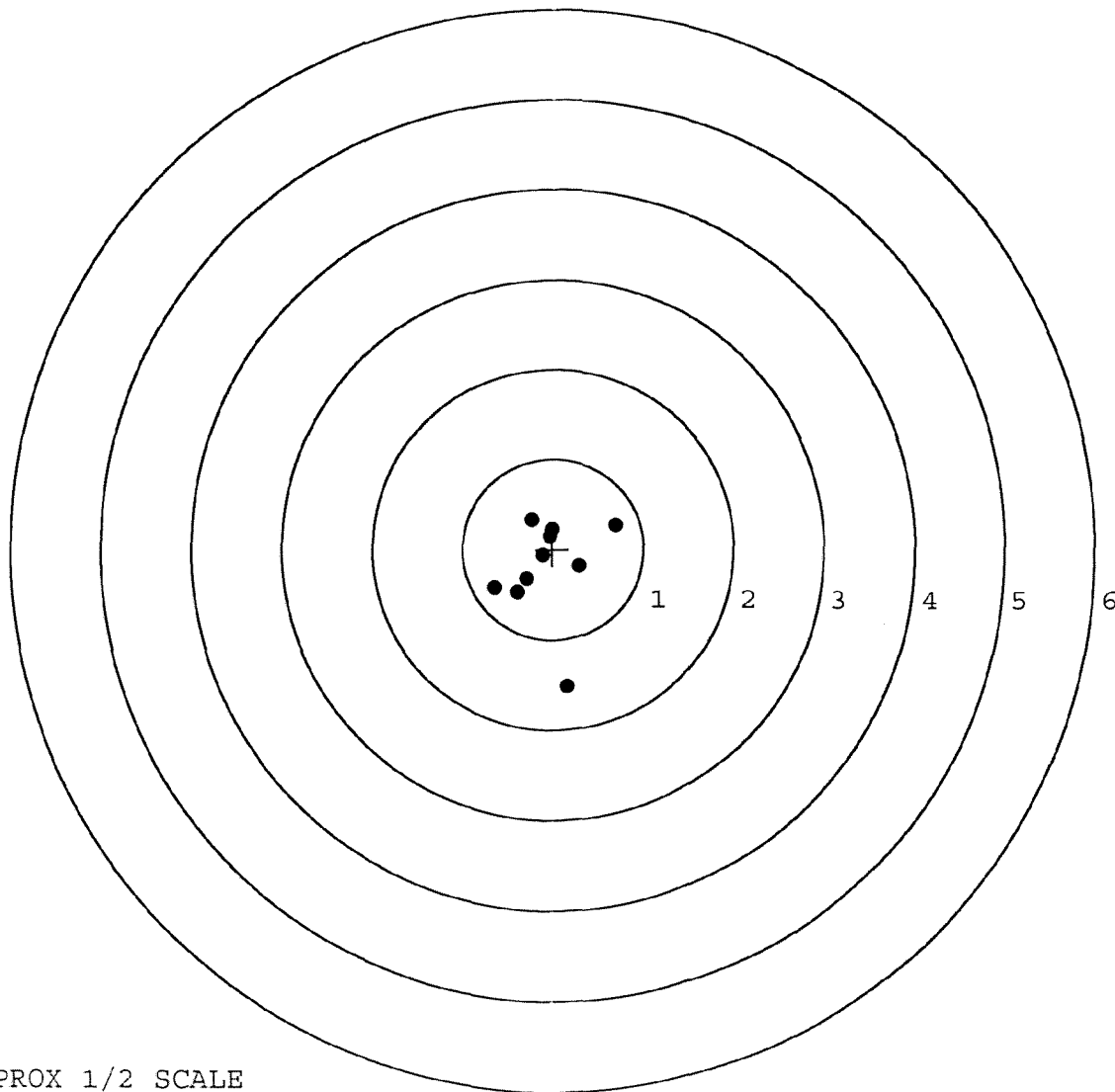
MAX RADIUS: 1.338

MEAN RADIUS: 0.538

IN 1 IN DIAMETER: 6

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50 LBS (plus or minus 0.50 LBS)
 3.00 LBS (plus or minus 0.75 LBS)
 4.00 LBS (plus or minus 1.00 LBS)

DATE 5-16-07TESTER TRW

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.23	2.52		2.63	
PULL #2	2.31	2.60		2.49	
PULL #3	2.47	2.53		2.69	
PULL #4	2.41	2.29		2.62	
PULL #5	2.43	2.51		2.51	
TOTAL	11.85	12.45		12.94	
AVERAGE	2.37	2.49		2.58	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.34	3.19		
PULL #2	3.32	3.11		
PULL #3	3.23	3.00		
PULL #4	3.35	3.05		
PULL #5	3.32	3.03		
TOTAL	16.56	15.38		
AVERAGE	3.31	3.07		

	4.00 LBS INITIAL	4.00 LBS AFTER 20 CYCLES	MAX SETTING GREATER THAN 4 LBS	RESET TO 4 LBS FOR TARGET & ACCURACY
PULL #1	4.06	4.42		4.43
PULL #2	4.34	4.43		4.60
PULL #3	4.29	4.40		4.55
PULL #4	4.50	4.38		4.45
PULL #5	4.36	4.39		4.39
TOTAL	21.55	22.02		22.42
AVERAGE	4.31	4.40		4.48

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

R & E NUMBER		128530	
SERIAL NUMBER		C6498872	
LOG-IN DATE		4-24-07	
OPERATION #	OPERATION NAME	DATE	INITIAL
500	DIS-ASSEMBLE GUN	5-16-07	RTZ
505	RE-BARREL	5-18-07	RTZ
560	ASSEMBLE	5-18-07	RTZ
600	PROOF	5-18-07	TRW
605	CHECK HEADSPACE	5-18-07	TRW
610	DIS-ASSEMBLE GUN	5-21-07	RTZ
612	MAGNAFLUX	5-21-07	Wmms
510	DRILL AND TAP	5-21-07	TRW
615	ROLLMARK CALIBER	5-21-07	GW
618	ROTO-BLAST	5-22-07	LB
620	APPLY COATINGS	5-25-07	W
625	FINAL ASSEMBLY	5-30-07	RTZ
640	FUNCTION TEST AND	PASS FAIL	6-1-07 TRW
650	TARGET	PASS FAIL	6-1-07 TRW
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
670	FINAL INSPECTION	6-1-07	FM
	A) HEADSPACE	PASS FAIL	6-8-07 RTZ
	B) TRIGGER PULL	2.54 2.57 2.58 2.59 2.62	6-4-07 DA
680	F) SAFETY ON FORCE	6.0 6.0 5.5	6-4-07 DA
	G) SAFETY OFF FORCE	3.0 2.5 2.5	6-4-07 DA
	I) FIRING PIN INDENT	.023 .023 .023	6-4-07 DA
690	PACK		6-8-07



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

MODEL 700™ M24

01

SERIAL NO.
C6498872

ORDER NO.
5716

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



5716 C6498872



95A

MAINTENANCE REQUEST				PAGE NO. 1	NO. OF PAGES 1	REQUIREMENTS CONTROL SYMBOL CSGLD - 1047(R1)	
For use of this form, see DA PAM 738-750; the proponent agency is DCSLOG							
SECTION I - EQUIPMENT DATA							
CONTROL NUMBER		WORK ORDER NO.		WESDC		ORG. PD	
PD AUTHENTICATION							
☐ Work Request ☐ MWO ☒ Warranty Claim		1A. ORGANIZATION C Co 3/5 SFG		B. LOCATION Ft. Campbell Ky 42223		C. UNIT IDENT CODE WH0600	
2. SERIAL NO. C6498872		3. NOUN NOMENCLATURE 7.62 Sniper Rifle M24		4. LINE NO. R95387		5. MODEL M24	
6. NATIONAL STOCK NUMBER 1005-01-240-2136							
7A. MAINTENANCE ACTIVITY IMO		B. LEVEL		8. UTILIZATION CODE		9A. MCSR ITEM	
14. FAILURE DETECTED DURING (Select one - use ☒ or X)		15. FIRST INDICATION OF TROUBLE (Select one - use ☒ or X)					
☐ A Sch. Main. ☐ C Test ☐ E Storage ☐ G Flight ☐ B Handling ☐ D Normal Op ☐ F Inspection ☒ H Other		☐ 068 Inoperative ☐ 258 Overheating ☐ 790 Out of Adjustment ☐ 008 Noisy ☐ 387 Low Performance ☒ Other					
16A. DESCRIBE DEFICIENCIES OR SYMPTOMS ON THE BASIS OF COMPLETE CHECKOUT AND DIAGNOSTIC PROCEDURE IN EQUIPMENT TM (Do not prescribe repairs) S.O.I. Rnds fired							
B. REMARKS W55H095345H245							
PREPARATION INSTRUCTIONS (Prior to using this form, read DA PAM 738-750 for detailed preparation instructions)							
1. Place a "✓" or an "X" in the box for the type of action required. 2. Enter the WESDC if the item is Materiel Condition Status Reportable. 3. Enter the priority designator as determined from the urgency of need and force activity designator. 4. The Unit Commander, Chief of TDA activity or their designated representative will authenticate, by signature, a priority of 01 through 08. 5. Block 1A. Enter the name of the organization submitting the request. 6. Block 1B. Enter the unit submitting the request; units overseas enter APO only. 7. Block 1C. Enter the unit identification code of the unit in block 1A. 8. Block 2. Enter the equipment serial number. For ammunition, enter the lot number. For administrative-use vehicles, enter the USA registration number. 9. Block 3. Enter the noun abbreviation of the item. 10. Block 4. Enter the item line number, if applicable. 11. Block 5. Enter the model number. 12. Block 6. Enter the National Stock Number of the item listed in Block 3.				13. Block 7. Enter the name of the support activity. 14. Block 7A. Enter the symbol of the maintenance category (O, F, H, D, or L). 15. Block 8. Enter the utilization code. 16. Block 9A. Enter the word "yes" if the item is Materiel Condition Status Reportable. 17. Block 9B. Enter the equipment readiness code, if applicable. 18. Block 9C. Enter the word "yes" if the item is a pacing item. 19. Block 10. Enter the hour reading, if applicable. 20. Block 11. Enter the mileage from the odometer, if applicable. 21. Block 12. Enter the total rounds fired, if applicable. 22. Block 13. For turbine engines, enter the number of hot starts. 23. Block 14. Enter a "✓" or "X" in the proper block. 24. Block 15. Enter a "✓" or "X" in the proper block. 25. Block 16. Describe briefly the fault or symptoms needing correction.			
23. SUBMITTED BY Tony J. [Signature]		24. RECEIVED BY					
JULIAN DATE		JULIAN DATE					

DA FORM 2407, AUG 88

EDITION OF MAY 81 MAY BE USED

RECEIPT COPY 1

New Barrel

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6498872

OP. #	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and Stock		12/24/95	RW
600	Proof		12/21/95	RW
607	Check Headspace		12/21/95	RW
610	Dis-assemble Gun		12/21/95	RW
612	Magnaflux Barrel Action			
	Magnaflux Bolt			
615	Rollmark Caliber			
617	Drill and Tap Sight Holes			
618	Polish Barrel			
620	Apply Coatings (Barrel Action)			
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		1/5/96	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		1/5/96	RW
	C) Inspect Ejector Hole for Chamfer		1/5/96	RW
	D) Oil Firing Pin Ass'y		1/5/96	RW
	E) Adjust Trigger Pull to Min Setting and Stake			

op. #	BARBER - M24 0009258 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		1/8/96	Rw
	A) Time			
	B) Malfunctions			
	C) Pierced Primers			
	D) Optical Clarity of Scope			
645	Inspect for Live Ammo		1/8/96	Rw
655	Final Inspection			
	A) Headspace		1/10/96	Rw
	B) Trigger Pull		1/10/96	Rw
	C) Function		1/10/96	Rw
660	Pack			

Final Inspection

Sn: C6498872

DATE REC'D: 12/04/95

DATE RET'D:

AUDITOR: PW

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:

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6498872
7 Jan 1988

CENTROIDAL DISTANCES

0 TO	1	.974939
1 TO	2	.094921
1 TO	3	.258089
1 TO	4	.137641
1 TO	5	.652371

ap 1

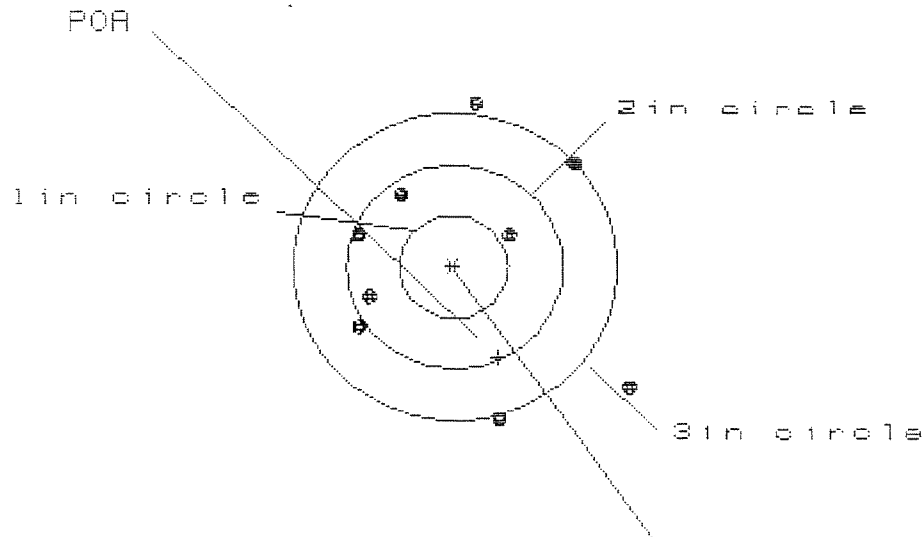
+ (----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.2238
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .8984
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .925856
THE AMR FOR THIS RIFLE IS: 1.185

7 Jan 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C8498872

CENTERFIRE PATTERNS # 1



OF SHOTS - 10

IN CIR

1in = 0

2in = 4

3in = 5

HS = 2.567

VS = 3.152

GS = 3.235

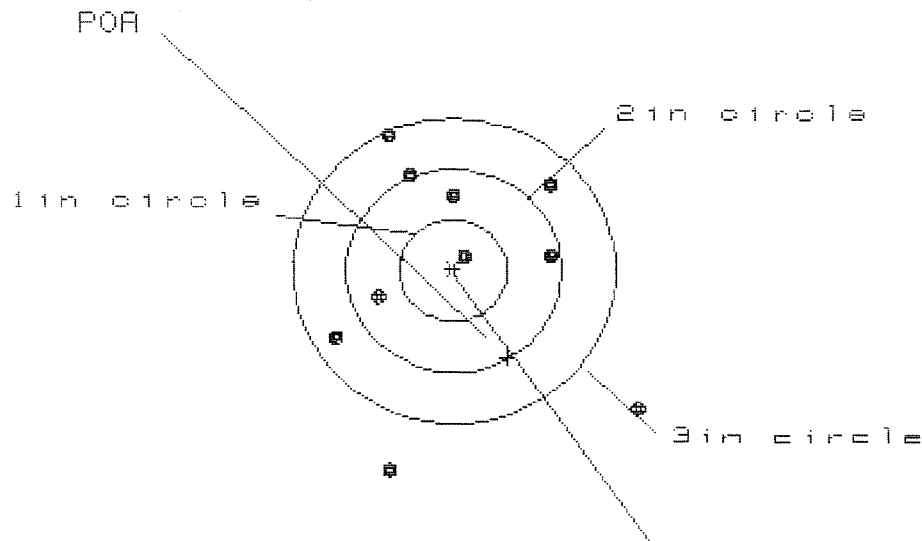
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.647	1.301	1.347
MINIMUM X	-0.920	-0.737	-0.691
MAXIMUM Y	1.660	1.524	1.064
MINIMUM Y	-1.492	-1.628	-1.438
CENTROID X	-0.409	-0.592	-0.638
CENTROID Y	0.885	1.021	0.831
POA TO CENTROID in.	0.975	1.181	1.047
MIN RADIUS	0.622	0.683	0.557
MEAN RADIUS	1.216	1.079	1.000
MAX RADIUS	2.052	1.749	1.717
HORIZONTAL SPREAD	2.567	2.038	2.038
VERTICAL SPREAD	3.152	3.152	2.502
EXTREME SPREAD	3.235	3.164	2.592
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	5		

7 Jan 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C6498872

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 1

2in = 4

3in = 8

HS= 2.799

VS= 3.213

GS= 3.555

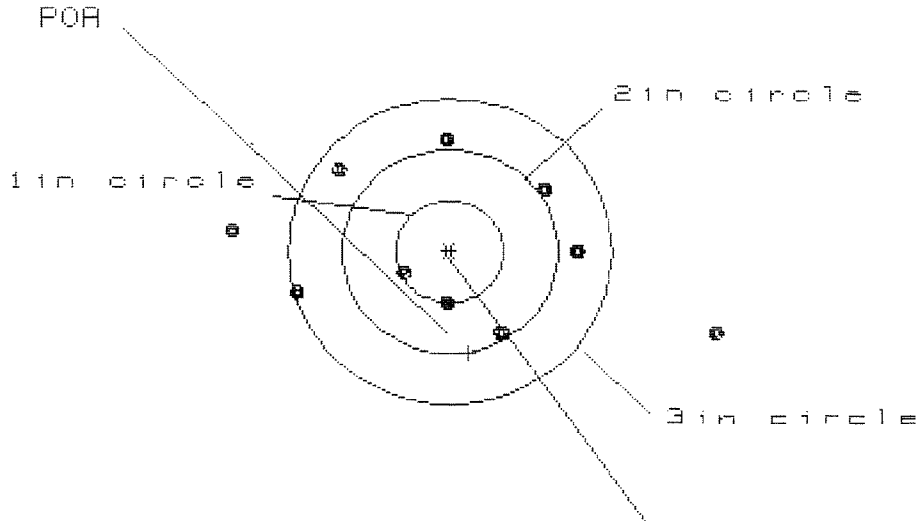
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.702	1.052	.995
MINIMUM X	:	-1.097	-.908	-.965
MAXIMUM Y	:	1.303	1.149	.891
MINIMUM Y	:	-1.910	-2.064	-1.067
CENTROID X	:	-.500	-.689	-.632
CENTROID Y	:	.858	1.012	1.270
POA TO CENTROID in.:	:	.993	1.224	1.418
MIN RADIUS	:	.197	.248	.292
MEAN RADIUS	:	1.182	1.033	.846
MAX RADIUS	:	2.195	2.114	1.439
HORIZONTAL SPREAD	:	2.799	1.960	1.960
VERTICAL SPREAD	:	3.213	3.213	1.958
EXTREME SPREAD	:	3.555	3.213	2.466
NUMBER IN ONE INCH CIRCLE =	:		1	
NUMBER IN TWO INCH CIRCLE =	:		4	
NUMBER IN THREE INCH CIRCLE =	:		8	

7 Jan 1988

FILE:/PATTERNING/CENTERFIRE_PATT/0649B872

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 3

3 in = 7

HS= 4.463

VS= 1.972

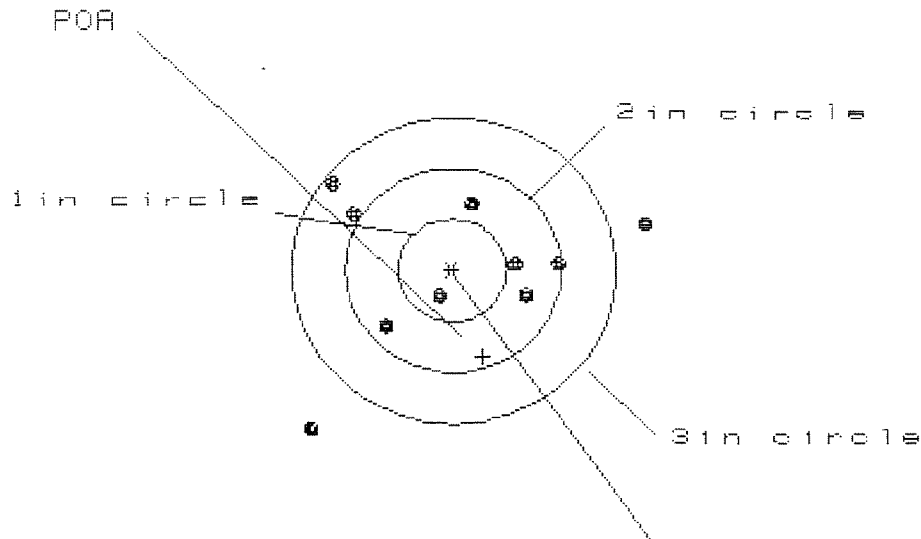
GS= 4.570

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.457	1.452	1.235
MINIMUM X	:	-2.006	-1.733	-1.416
MAXIMUM Y	:	1.146	1.054	1.062
MINIMUM Y	:	-.826	-.887	-.879
CENTROID X	:	-.176	-.449	-.232
CENTROID Y	:	.996	1.088	1.080
POA TO CENTROID in.	:	1.012	1.177	1.105
MIN RADIUS	:	.463	.315	.455
MEAN RADIUS	:	1.269	1.104	1.014
MAX RADIUS	:	2.592	1.735	1.487
HORIZONTAL SPREAD	:	4.463	3.185	2.651
VERTICAL SPREAD	:	1.972	1.911	1.911
EXTREME SPREAD	:	4.570	3.191	2.671
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		7	

7 Jan 1968

FILE:/PATTERNING/CENTERFIRE_PATT/06498872

CENTERFIRE PATTERNS # 4



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 6

3 in = 8

HS = 3.088

VS = 2.446

GS = 3.708

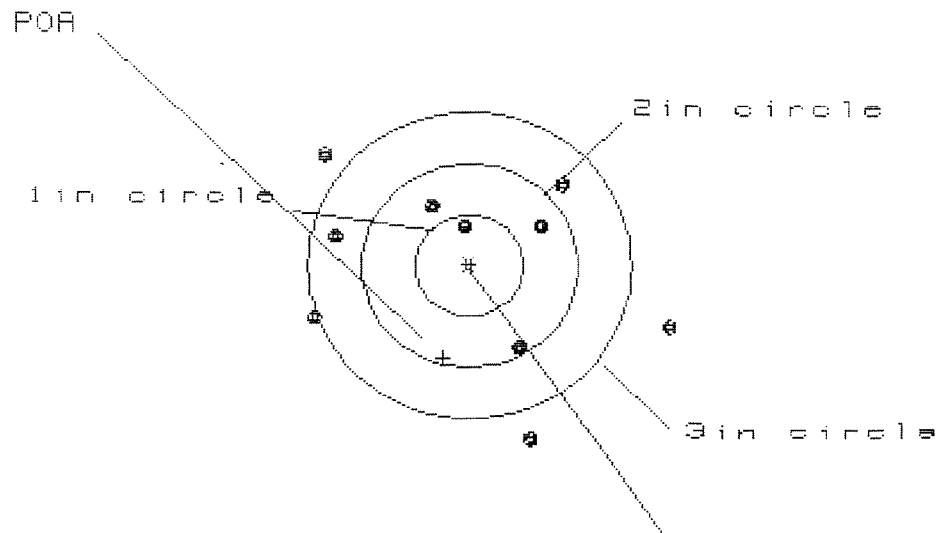
CENTROID #

PATTERN #	4		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.734	1.584	.993
MINIMUM X	-1.354	-1.233	-1.035
MAXIMUM Y	.872	.697	.735
MINIMUM Y	-1.574	-.737	-.699
CENTROID X	-.277	-.127	-.325
CENTROID Y	.846	1.021	.983
POA TO CENTROID in.	.890	1.029	1.035
MIN RADIUS	.252	.437	.358
MEAN RADIUS	1.034	.902	.813
MAX RADIUS	2.076	1.613	1.270
HORIZONTAL SPREAD	3.088	2.817	2.028
VERTICAL SPREAD	2.446	1.434	1.434
EXTREME SPREAD	3.708	2.844	2.184
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		8	

7 Jan 1988

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CENTERFIRE PATTERNS # 5



OF SHOTS - 10

IN CIR

1 in = 1

2 in = 4

3 in = 6

HS = 3.369

VS = 2.806

GS = 3.633

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.884	1.097	1.188
MINIMUM X	:	-1.485	-1.276	-1.185
MAXIMUM Y	:	1.142	1.074	.857
MINIMUM Y	:	-1.664	-1.732	-1.083
CENTROID X	:	.243	.034	-.057
CENTROID Y	:	.907	.975	1.192
POA TO CENTROID IN.	:	.939	.976	1.133
MIN RADIUS	:	.377	.339	.257
MEAN RADIUS	:	1.224	1.121	.980
MAX RADIUS	:	1.982	1.880	1.442
HORIZONTAL SPREAD	:	3.369	2.373	2.373
VERTICAL SPREAD	:	2.806	2.806	1.940
EXTREME SPREAD	:	3.633	3.342	2.704
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	4		
NUMBER IN THREE INCH CIRCLE	=	6		

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6498872

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	5 17	90	RW
600	Proof	5 17	90	RW
607	Check Headspace	5 17	90	RW
610	Dis-assemble Gun	5 17	90	RW
612	Magnaflux Barrel Action		5/22/90	KCR
	Magnaflux Bolt		5/22/90	KCR
615	Rollmark Caliber		5/22/90	GS.
617	Drill and Tap Sight Holes		5/23/90	FB
618	Polish Barrel RB		5/24/90	WB
620	Apply Coatings (Barrel Action)		6/4/90	JA
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		6/4/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		6/4/90	RW
	C) Inspect Ejector Hole for Chamfer		6/4/90	RW
	D) Oil Firing Pin Ass'y		6/4/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		6/7/90	JA

BARBER - M24 0009267		READINGS					DATE	INIT
op. #	OP. NAME							
625 cont.	F) Safety On Force	3 1/2	3 1/2	3 1/2			6/8/90	WB
	G) Safety Off Force	2	2	2			6/8/90	WB
	H) Trigger Pull Test & Retainability						6-7-90	JH
	I) Firing Pin Indent	.0225	.0225	.0225			6/7/90	WB
	J) Assemble Stock						6/8/90	RW
	K) Assemble Swivel Studs						6/15/90	JH
	L) Attach Front and Rear Sight Assemblies						6/8/90	RW
	M) Iron Sight Alignment						6/8/90	RW
	N) Detach Front & Rear Sights & place in numbered container						6/8/90	RW
	O) Attach Scope to Rifle						6/8/90	WB
	P) Detach & Attach Scope 20 Times						6/8/90	WB
640	Gallery Target & Test						6-11-90	DH
	A) Time						6-11-90	DH
	B) Malfunctions						6-11-90	DH
	C) Pierced Primers						6-11-90	DH
	D) Optical Clarity of Scope						6-11-90	DH
645	Inspect for Live Ammo						6-11-90	DH
655	Final Inspection							
	A) Headspace						6/15/90	JH
	B) Trigger Pull	2.95	2.90	2.91	2.88	2.88	6-14-90	JH
	C) Function						6/15/90	JH
660	Pack						6-20-90	DH

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

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

SERIAL NO. C6498872DATE 6/7/90TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.32	2.22	2.25	2.95	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.26	2.14	2.30	2.90	
PULL #3	2.24	2.18	2.28	2.91	
PULL #4	2.17	2.28	2.35	2.88	
PULL #5	2.13	2.24	2.15	2.88	
TOTAL	11.12	11.06	11.33		
AVG.	2.224	2.212	2.266		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.52	3.49		
PULL #2	3.34	3.55		
PULL #3	3.35	3.48		
PULL #4	3.17	3.52		
PULL #5	3.41	3.41		
TOTAL	16.79	17.45		
AVG.	3.358	3.49		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.34	4.24		4.34
PULL #2	4.04	4.21		4.30
PULL #3	4.44	4.20		4.27
PULL #4	4.35	4.27		4.28
PULL #5	4.43	4.33		4.24
TOTAL	21.60	21.25		21.43
AVG.	4.32	4.25		4.286

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06498872
12 Jun 1990

CENTROIDAL DISTANCES

0 TO	1	.182543
1 TO	2	.588308
1 TO	3	.237453
1 TO	4	.126811
1 TO	5	.121149

3
1 2 <----POB

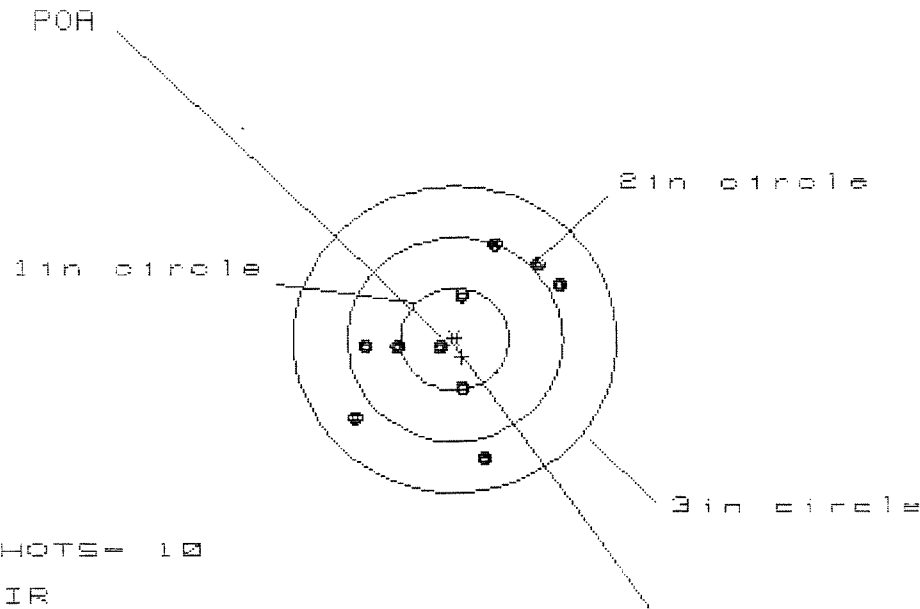
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0254
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .125
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .127555
THE AMR FOR THIS RIFLE IS: .829

01 Jun 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C849B872

CENTERFIRE PATTERNS

1



OF SHOTS - 10

IN CIR

1in = 3

2in = 5

3in = 10

HS = 1.865

VS = 2.095

GS = 2.347

CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.996	.888	.904
MINIMUM X	-.969	-.950	-.934
MAXIMUM Y	.946	.858	.703
MINIMUM Y	-1.149	-1.237	-.728
CENTROID X	-.069	.039	.023
CENTROID Y	.169	.257	.412
POA TO CENTROID in.	.183	.260	.412
MIN RADIUS	.167	.299	.225
MEAN RADIUS	.815	.772	.699
MAX RADIUS	1.249	1.243	.986
HORIZONTAL SPREAD	1.965	1.838	1.838
VERTICAL SPREAD	2.095	2.095	1.431
EXTREME SPREAD	2.347	2.102	1.924
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		10	

11 Jun 1998

FILE:/PATTERNING/CENTERFIRE_PATT/CG49B072

CENTERFIRE PATTERNS # 2

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS = 10

IN CIR

1 in = 2

2 in = 7

3 in = 10

HS = 1.785

VS = 2.219

GS = 2.337

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.765	.820	.835
MINIMUM X	:	-1.020	-.935	-.921
MAXIMUM Y	:	1.223	1.112	.845
MINIMUM Y	:	-.996	-.903	-.764
CENTROID X	:	.226	.141	.127
CENTROID Y	:	-.340	-.229	-.368
POA TO CENTROID in.	:	.408	.269	.389
MIN RADIUS	:	.250	.157	.292
MEAN RADIUS	:	.841	.775	.735
MAX RADIUS	:	1.256	1.118	1.011
HORIZONTAL SPREAD	:	1.785	1.755	1.755
VERTICAL SPREAD	:	2.219	2.015	1.609
EXTREME SPREAD	:	2.337	2.017	1.996
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

11 Jun 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6498872

CENTERFIRE PATTERNS # 3

POB

1in circle

2in circle

3in circle

OF SHOTS - 10

IN CIR

1in = 2

2in = 6

3in = 9

HS = 1.815

VS = 2.497

GS = 2.551

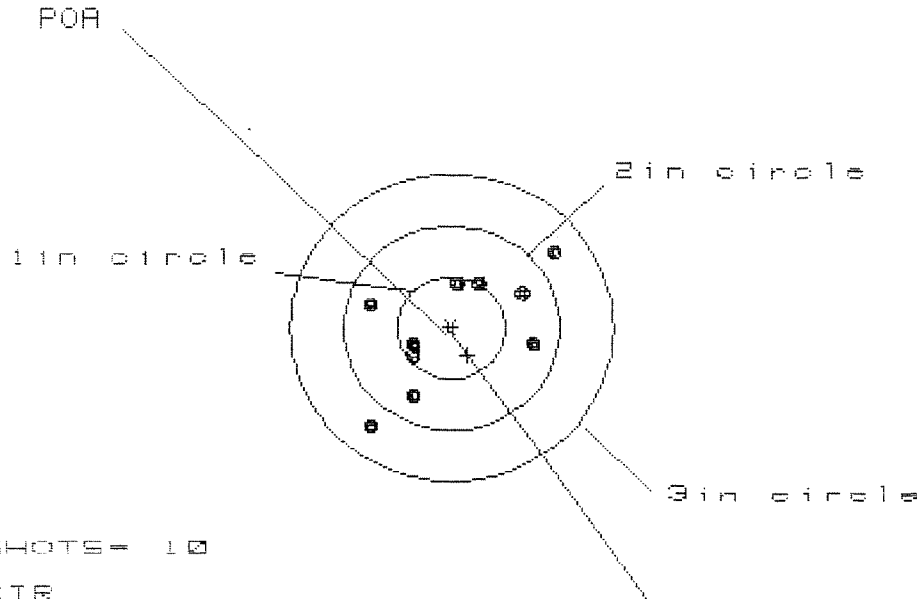
CENTROID #

PATTERN #	3	3	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.868	.810	.684
MINIMUM X	-.947	-1.005	-.719
MAXIMUM Y	1.499	1.118	1.014
MINIMUM Y	-.998	-.832	-.756
CENTROID X	.059	.117	.243
CENTROID Y	.369	.203	.306
POB TO CENTROID in.	.374	.234	.391
MIN RADIUS	.226	.144	.216
MEAN RADIUS	.874	.765	.702
MAX RADIUS	1.587	1.304	1.161
HORIZONTAL SPREAD	1.815	1.815	1.403
VERTICAL SPREAD	2.497	1.950	1.771
EXTREME SPREAD	2.551	2.551	1.932
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		9	

11 Jun 1998

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CENTERFIRE PATTERNS # 4



OF SHOTS = 10

IN CIR

1 in = 3

2 in = 8

3 in = 10

HS = 1.705

VS = 1.732

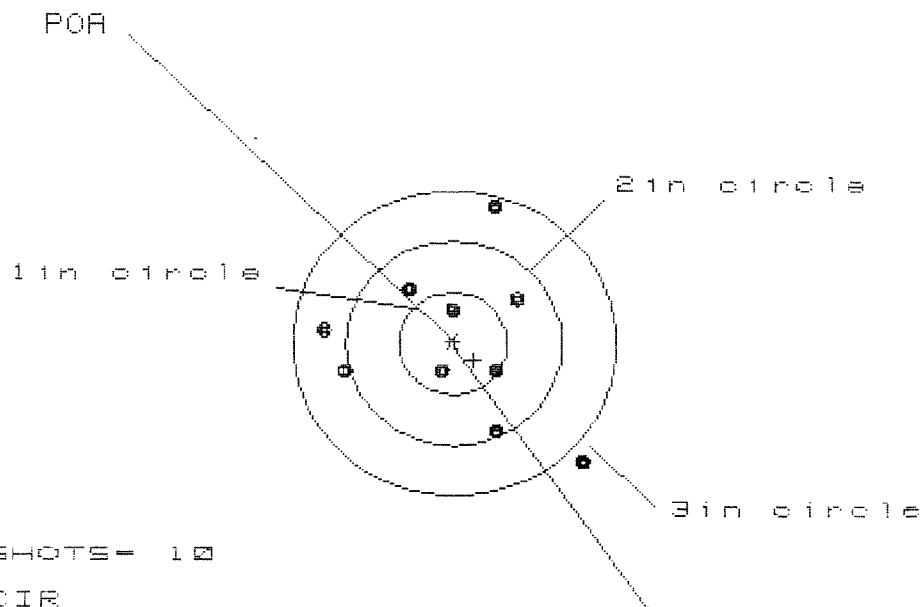
ES = 2.414

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.946	.888	.810
MINIMUM X	:	-.759	-.654	-.732
MAXIMUM Y	:	.781	.558	.450
MINIMUM Y	:	-.951	-.864	-.664
CENTROID X	:	-.153	-.258	-.180
CENTROID Y	:	.264	.177	.285
POA TO CENTROID in.	:	.305	.313	.337
MIN RADIUS	:	.416	.283	.404
MEAN RADIUS	:	.734	.662	.610
MAX RADIUS	:	1.227	1.069	.836
HORIZONTAL SPREAD	:	1.705	1.542	1.542
VERTICAL SPREAD	:	1.732	1.422	1.114
EXTREME SPREAD	:	2.414	1.862	1.594
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	

11 Jun 1998

FILE:/PATTERNING/CENTERFIRE_PATT/06498872

CENTERFIRE PATTERNS # 5



OF SHOTS = 10

IN CIR

1in = 3

2in = 6

3in = 9

HS = 2.379

VS = 2.480

CS = 2.720

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.195	.678	.739
MINIMUM X	:	-1.184	-1.052	-.991
MAXIMUM Y	:	1.323	1.194	.604
MINIMUM Y	:	-1.157	-1.038	-.888
CENTROID X	:	-.190	-.322	-.383
CENTROID Y	:	.163	.292	.142
POA TO CENTROID in.	:	.250	.435	.408
MIN RADIUS	:	.315	.224	.279
MEAN RADIUS	:	.881	.782	.716
MAX RADIUS	:	1.663	1.288	1.040
HORIZONTAL SPREAD	:	2.379	1.730	1.730
VERTICAL SPREAD	:	2.480	2.232	1.492
EXTREME SPREAD	:	2.720	2.232	1.869
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	