

C6225182

MODEL 700™ M24

Model **700 M24™**

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

Remington

Repair Inquiry

Repair Number: RE00085936

Serial: C6225182 Model: M24 SWS Center Fire
Caliber: 7.62 NATO

Repairman:

Verify Repair

Status:

Closed 10/4/2004 10:56:55 AM

Address Information

Customer:

Received From:

Return To:

Received From:

Name: TRANSPORTATION OFFICER

TRANSPORTATION OFFICER

Address 1: SENSITIVE STORAGE

SENSITIVE STORAGE

Address 2: BLDG 9660

PO Box:

BLDG 9660

PO Box:

City: FORT LEWIS

FORT LEWIS

State: WA

Zip Code: 98433

Country: US

State: WA

Zip Code: 98433

Country: US

FPL:

Contact / Condition

Problems

Estimate

History / Status

Shipping / Billing

Contact Information

Phone: 253 967 5516

Fax:

Email:

Comments:

Received Condition

Fair

Condition:

Notes:

CSR:

Notes:

Accessories Received

Code	Desc	Qty
A007	With Studs	3
A017	Scope Bases	3

Repair Search

Refresh

Close

maglet

10/4/2004

11:26 AM

CAPS

NUM

INS

SCPL

start

3

4

Arms Services RL

M24

Serial Number: C6225182

Model: M24 SWS



RE00085936

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6225182.___0
FILE DATE AND TIME: 11/08/2004 02:46

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

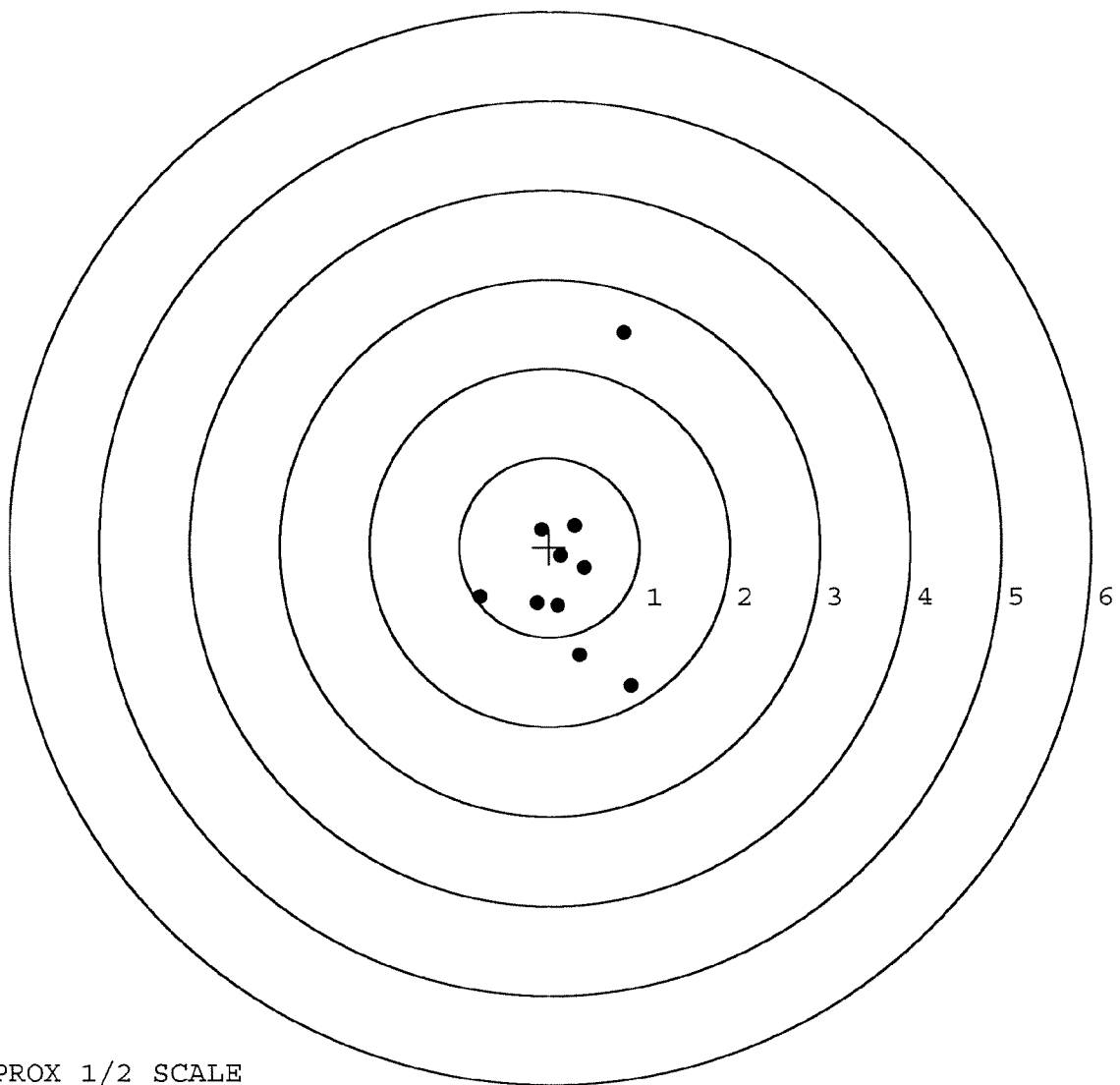
The Average X Centroid of the Five Target Set:	0.233
The Average Y Centroid of the Five Target Set:	-0.148
The Average Point of Impact of the Five Target Set:	0.276
The Average Mean Radius of the Five Target Set:	0.689
The Distance from POA to Centroid Target #1:	0.285
The Distance from Centroid Target #2 to Centroid Target #1:	0.673
The Distance from Centroid Target #3 to Centroid Target #1:	0.373
The Distance from Centroid Target #4 to Centroid Target #1:	0.311
The Distance from Centroid Target #5 to Centroid Target #1:	0.208

BARBER - M24 0010109

SERIAL NUMBER: C6225182. __0
 TARGET NUMBER: 1
 FILE DATE: 11/08/2004
 FILE TIME: 02:46

POINT#	X	Y
1:	0.823	2.405
2:	-0.090	0.198
3:	0.281	0.242
4:	0.127	-0.095
5:	0.392	-0.227
6:	-0.768	-0.555
7:	-0.137	-0.625
8:	0.099	-0.650
9:	0.339	-1.203
10:	0.911	-1.540

X CENTROID: 0.198
 Y CENTROID: -0.205
 POA TO CENTROID: 0.285
 HORZ SPREAD: 1.679
 VERT SPREAD: 3.945
 GROUP SPREAD: 3.946
 MIN RADIUS: 0.131
 MAX RADIUS: 2.684
 MEAN RADIUS: 0.850
 # IN 1 IN DIAMETER: 5
 # IN 2 IN DIAMETER: 6
 # in 3 IN DIAMETER: 8



TARGET APPROX 1/2 SCALE

BARBER - M24 0010110

SERIAL NUMBER: C6225182. __0

TARGET NUMBER: 2

FILE DATE: 11/08/2004

FILE TIME: 02:46

POINT#	X	Y
1:	-0.190	-0.318
2:	0.669	-1.159
3:	1.050	-1.193
4:	1.071	-0.953
5:	1.073	-0.770
6:	1.608	-0.572
7:	1.441	-0.298
8:	-0.041	-0.004
9:	-0.121	-0.308
10:	0.743	-0.597

X CENTROID: 0.730

Y CENTROID: -0.617

POA TO CENTROID: 0.956

HORZ SPREAD: 1.798

VERT SPREAD: 1.193

GROUP SPREAD: 1.744

MIN RADIUS: 0.024

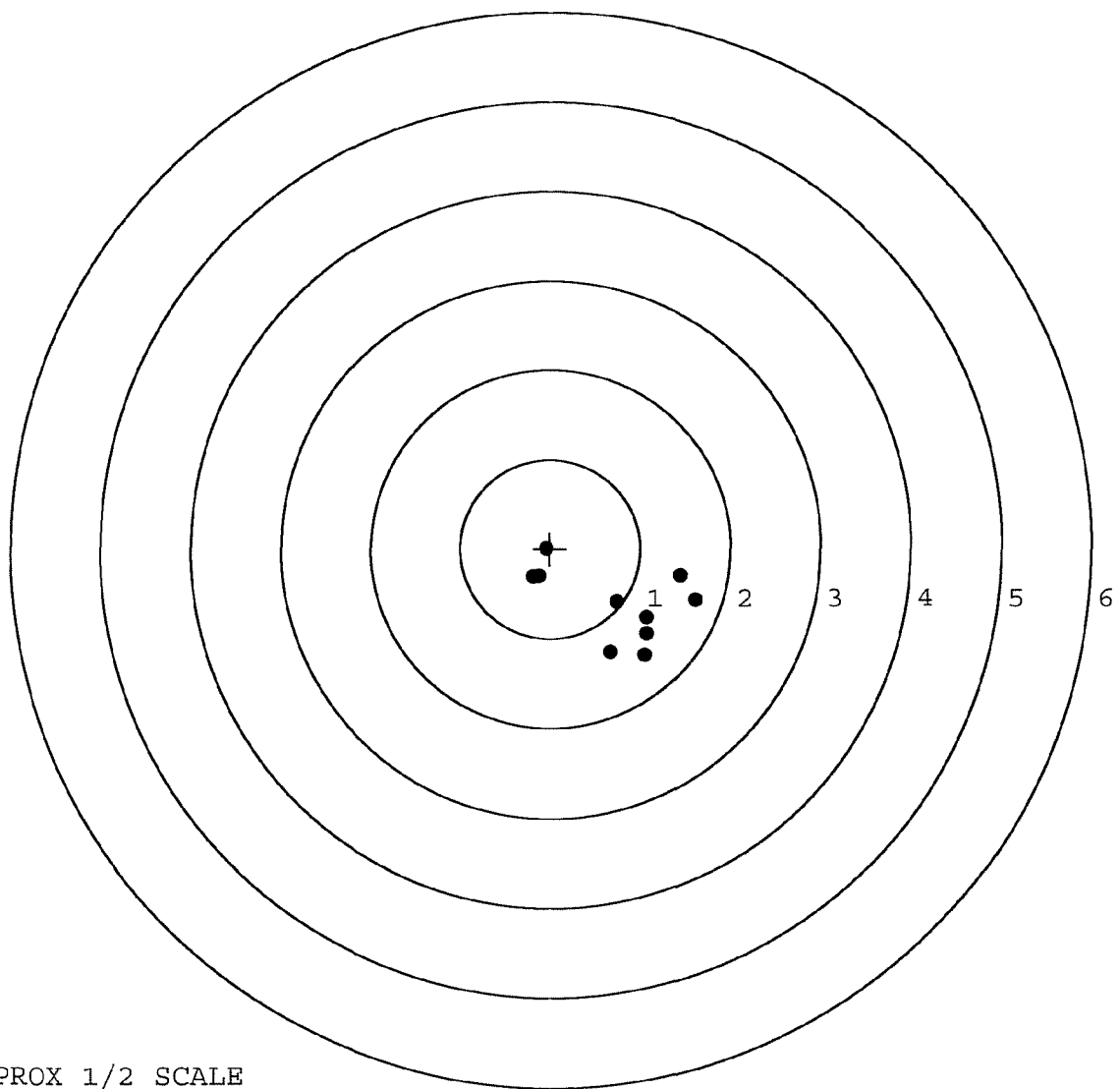
MAX RADIUS: 0.985

MEAN RADIUS: 0.660

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

BARBER - M24 0010111

SERIAL NUMBER: C6225182. __0

TARGET NUMBER: 3

FILE DATE: 11/08/2004

FILE TIME: 02:46

POINT#	X	Y
1:	-0.800	0.822
2:	-1.239	0.004
3:	-0.103	0.229
4:	-0.239	0.144
5:	-0.261	-0.077
6:	-0.840	-0.632
7:	0.291	-0.586
8:	0.508	-0.074
9:	1.046	-0.082
10:	0.548	0.322

X CENTROID: -0.109

Y CENTROID: 0.007

POA TO CENTROID: 0.109

HORZ SPREAD: 2.285

VERT SPREAD: 1.454

GROUP SPREAD: 2.287

MIN RADIUS: 0.174

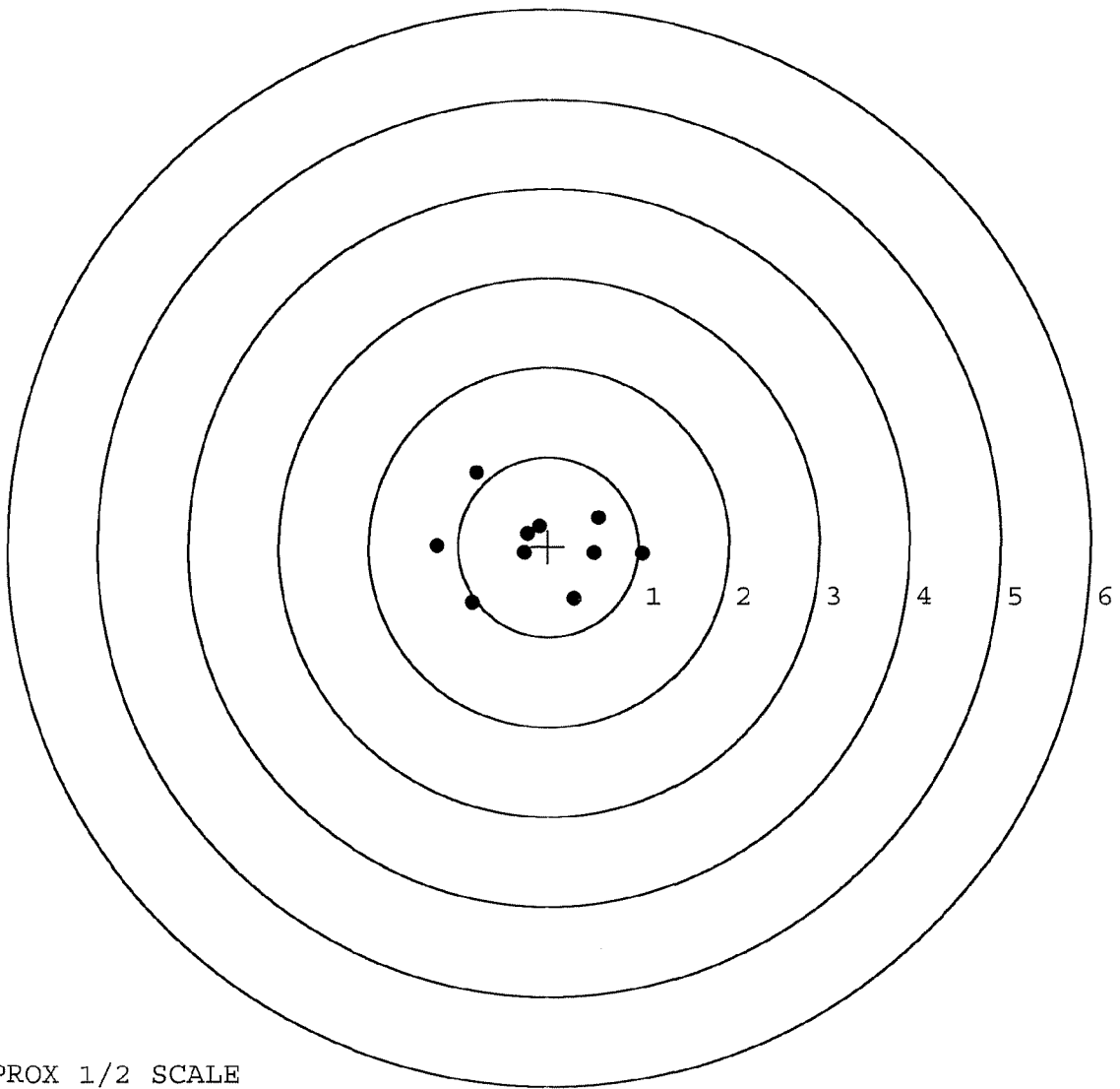
MAX RADIUS: 1.158

MEAN RADIUS: 0.698

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 7

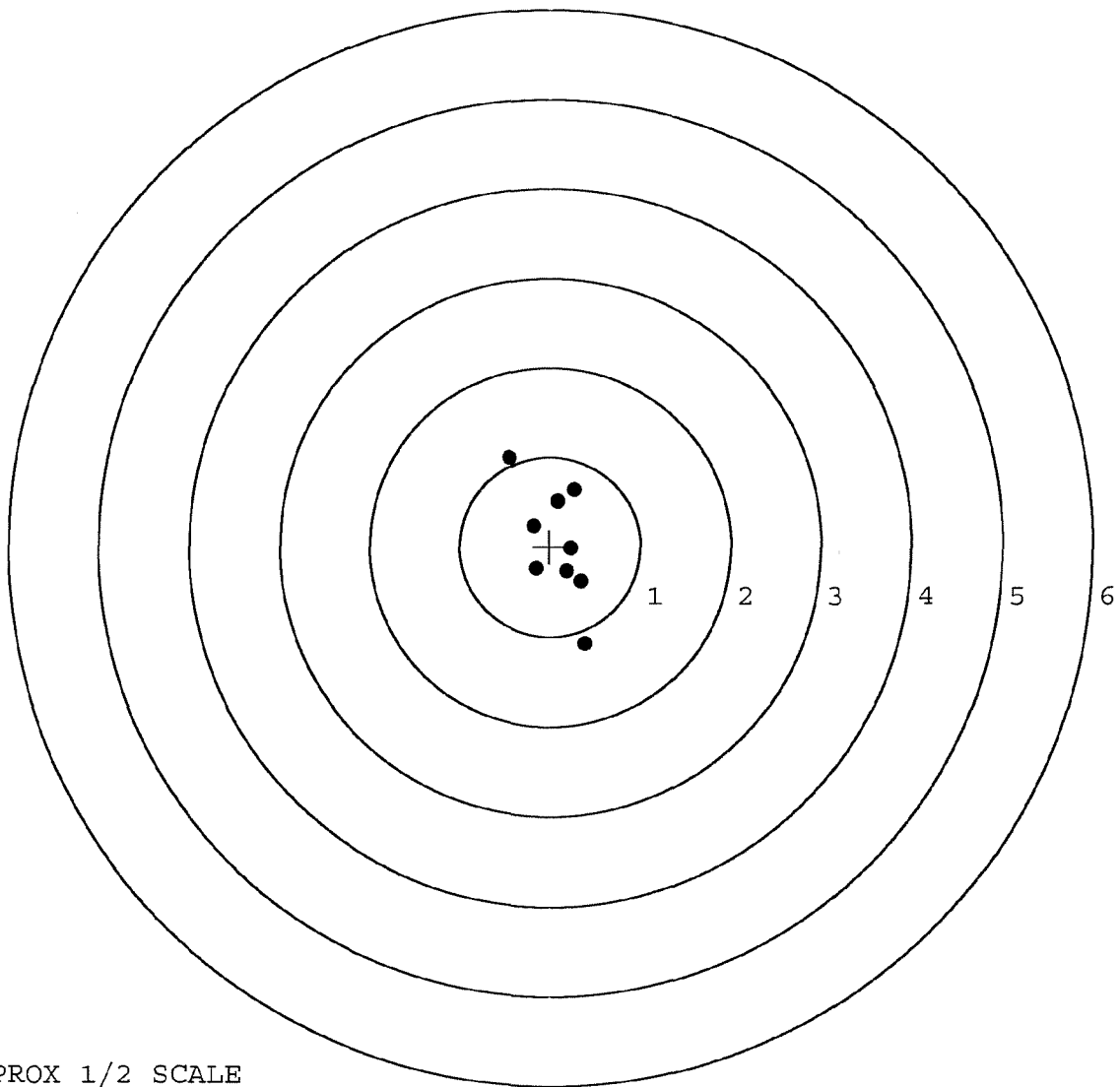
in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

BARBER - M24 0010112

SERIAL NUMBER: C6225182. __0	POINT#	X	Y
TARGET NUMBER: 4	1:	-0.448	0.991
FILE DATE: 11/08/2004	2:	0.270	0.634
FILE TIME: 02:46	3:	0.093	0.507
	4:	0.090	0.505
X CENTROID: 0.084	5:	-0.180	0.232
Y CENTROID: 0.085	6:	0.238	-0.021
POA TO CENTROID: 0.120	7:	0.191	-0.275
HORZ SPREAD: 0.837	8:	0.351	-0.391
VERT SPREAD: 2.071	9:	-0.152	-0.253
GROUP SPREAD: 2.234	10:	0.389	-1.080
MIN RADIUS: 0.187			
MAX RADIUS: 1.204			
MEAN RADIUS: 0.550			
# IN 1 IN DIAMETER: 6			
# IN 2 IN DIAMETER: 8			
# in 3 IN DIAMETER: 10			



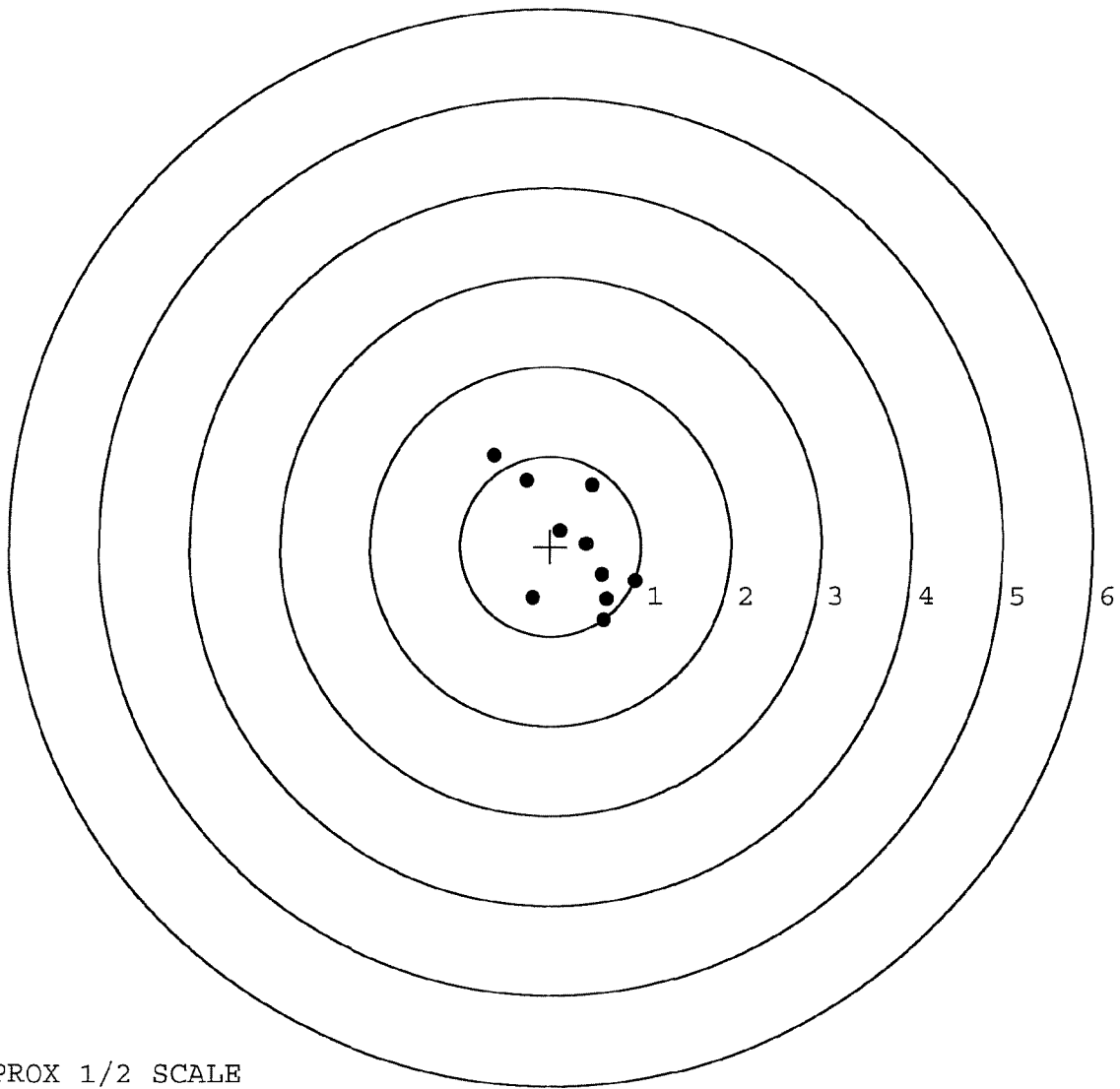
TARGET APPROX 1/2 SCALE

BARBER - M24 0010113

SERIAL NUMBER: C6225182. __0
 TARGET NUMBER: 5
 FILE DATE: 11/08/2004
 FILE TIME: 02:46

POINT#	X	Y
1:	-0.623	1.004
2:	-0.261	0.731
3:	0.460	0.681
4:	0.112	0.175
5:	0.399	0.033
6:	-0.190	-0.577
7:	0.938	-0.391
8:	0.578	-0.316
9:	0.630	-0.589
10:	0.593	-0.824

X CENTROID: 0.264
 Y CENTROID: -0.007
 POA TO CENTROID: 0.264
 HORZ SPREAD: 1.561
 VERT SPREAD: 1.828
 GROUP SPREAD: 2.196
 MIN RADIUS: 0.141
 MAX RADIUS: 1.345
 MEAN RADIUS: 0.686
 # IN 1 IN DIAMETER: 3
 # IN 2 IN DIAMETER: 9
 # in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

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

R & E NUMBER	85936		
SERIAL NUMBER	C 6225182		
LOG-IN DATE	10-4-04		
INSPECT AND VERIFY:			
OPERATION #	OPERATION NAME	DATE	INITIAL
550	DIS-ASSEMBLE GUN	10-13-04	RTL
560 A	RE-BARREL	10-14-04	RTL
B	DRILL AND TAP	10-19-04	TRW
575	ASSEMBLE	10-15-04	RTL
600	PROOF	10-18-04	RTL
605	CHECK HEADSPACE	10-18-04	RTL
610	DIS-ASSEMBLE GUN	10-19-04	RTL
612	MAGNAFLUX	OPERATOR	
615	ROLLMARK CALIBER	10/20/04	AB
618	ROTO-BLAST	10-22-04	CB
620	APPLY COATINGS	10/20/04	HP
625 A	FINAL ASSEMBLY	11-1-04	
B	TRIGGER PULL TEST		
C	SAFETY "ON" FORCE		
D	SAFETY "OFF" FORCE		
E	FIRING PIN INDENT		
640	TARGET	11-6-04	RTL
655	FINAL INSPECT	11-8-04	RTL
660	PACK	11-8-04	RA
		SHIP DATE	
	QAR INSPECTION DATE		

M-24

1068

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6225182

OP. #	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and stock	8	9/88	FB
600	Proof	9	7/88	RW
607	Check Headspace	9	7/88	RW
610	Dis-assemble gun	9	7/88	RW
612	Magnaflux Barrel Action		9-14-88	PJC.
	Magnaflux Bolt		9-14-88	PJC.
615	Rollmark Caliber			
617	Drill & Tap Sight Holes			
618	Polish Barrel			
620	Apply Coatings (Barrel Action)		10-31-88	TJA
	Apply Coatings (Bolt)		10-31-88	TJA
625	Final Assembly A) Clean inside of Bolt Assembly		11/2/88	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		11/2/88	RW
	C) Inspect Ejector Hole for Chamfer		11/2/88	RW

OVER

OP.#		READINGS	DATE	INITIAL
625	D) Oil Firing Pin Ass'y		11/2/88	RW
cont.	E) Adjust Trigger Pull to Min. Setting and Stake		2/10/88	JS
	F) Safety on Force	6 : 6 : 6	2/10/88	JS
	G) Safety off Force	3 : 3 : 3	2/10/88	JS
	H) Trigger Pull Test & Retainability		2/10/88	JS
	I) Firing Pin Indent	.020 : .020 : .0205	2/10/88	JS
	J) Assemble Stock		11/8/88	RW
	K) Attach Front & Rear Sight Assemblies		11/8/88	RW
	L) Iron Sight Alignment		11/8/88	RW
	M) Detach Front & Rear Sights & place in numbered container		11/8/88	RW
	N) Attach Scope to Rifle		11/8/88	RW
	O) Detach & Attach Scope 20 times		8/10/88	JS
640	Gallery Target & Test	56 R 96 L	11/9/88	DA
	A) Optical Clarity of Scope		11/9/88	DA
645	Inspect for Live Ammo		11/9/88	DA
655	Final Inspection			
	A) Headspace		29 NOV 88	JS
	B) Trigger Pull	2.33 : 2.26 : 2.21	2.14 : 2.30	JS
	C) Function		29 NOV 88	JS
	D) Assemble Swivel Studs		29 NOV 88	JS
660	Pack		14 Dec 88	JS

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6225182

DATE 31 Oct 88

TESTER J. J. J. J.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.23	2.18	2.29	2.33	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.20	2.16	2.25	2.26	
PULL #3	2.24	2.17	2.24	2.21	
PULL #4	2.22	2.18	2.22	2.14	
PULL #5	2.26	2.14	2.24	2.30	
TOTAL	11.15	10.83	11.22	11.24	
AVG.	2.23	2.166	2.244	2.248	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.28	3.43		
PULL #2	3.41	3.43		
PULL #3	3.41	3.40		
PULL #4	3.40	3.38		
PULL #5	3.45	3.44		
TOTAL	16.95	17.08		
AVG.	3.39	3.416		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.36	4.25		4.29
PULL #2	4.33	4.27		4.36
PULL #3	4.35	4.29		4.26
PULL #4	4.35	4.33		4.36
PULL #5	4.36	4.27		4.38
TOTAL	21.75	21.41		21.65
AVG.	4.35	4.282		4.33

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6225182

CENTROIDAL DISTANCES

0	TO	1	.784312
1	TO	2	.310459
1	TO	3	.100802
1	TO	4	.654481
1	TO	5	1.03921

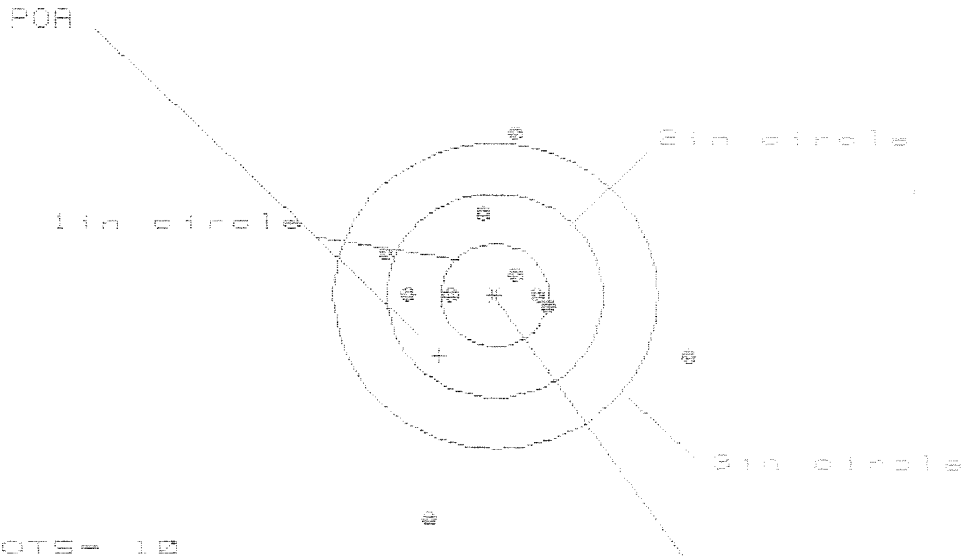
$\bar{x}$
 $\bar{y}$
 $\bar{r}$

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .7542
 THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .4012
 THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .854271
 THE AMR FOR THIS RIFLE IS: .9546

9 Nov 1988

FILE:/PATTERNING/CENTERFIRE_PATT/CS2251B2

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1 in = 4

2 in = 6

3 in = 7

HS = 2.816

VS = 3.796

GS = 3.877

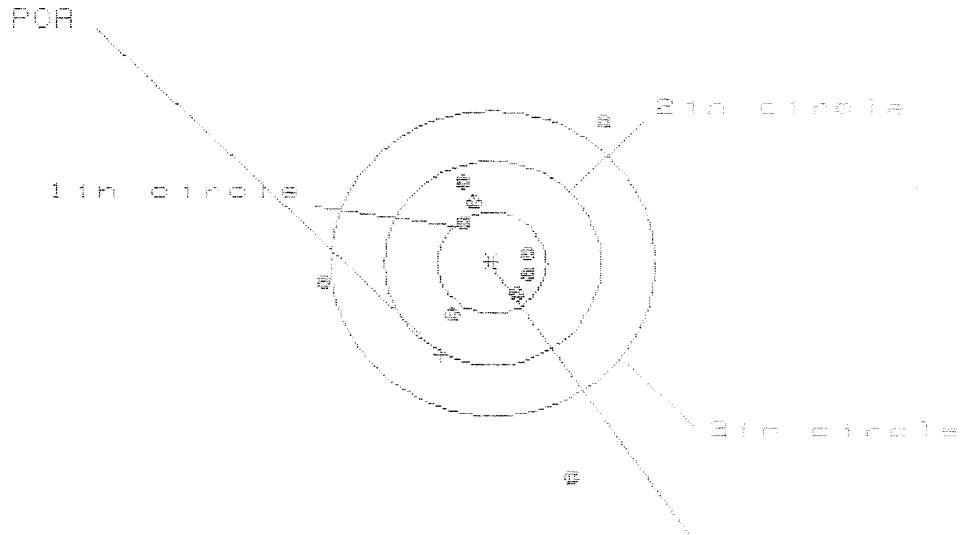
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.797	1.726	.614
MINIMUM X	-1.019	-1.098	-.874
MAXIMUM Y	1.575	1.328	1.222
MINIMUM Y	-2.221	-.848	-.411
CENTROID X	.511	.582	.366
CENTROID Y	.595	.842	.948
POR TO CENTROID in.	.784	1.024	1.016
MIN RADIUS	.285	.158	.399
MEAN RADIUS	1.018	.846	.716
MAX RADIUS	2.311	1.923	1.256
HORIZONTAL SPREAD	2.816	2.816	1.488
VERTICAL SPREAD	3.796	2.176	1.633
EXTREME SPREAD	3.877	2.978	1.896
NUMBER IN ONE INCH CIRCLE =	4		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	7		

9 Nov 1988

FILE:/PATTERNING/CENTERFIRE_PATT/08285188

CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1 in = 4

2 in = 7

3 in = 7

HE = 3.584

VS = 3.551

GS = 3.571

CENTROID #

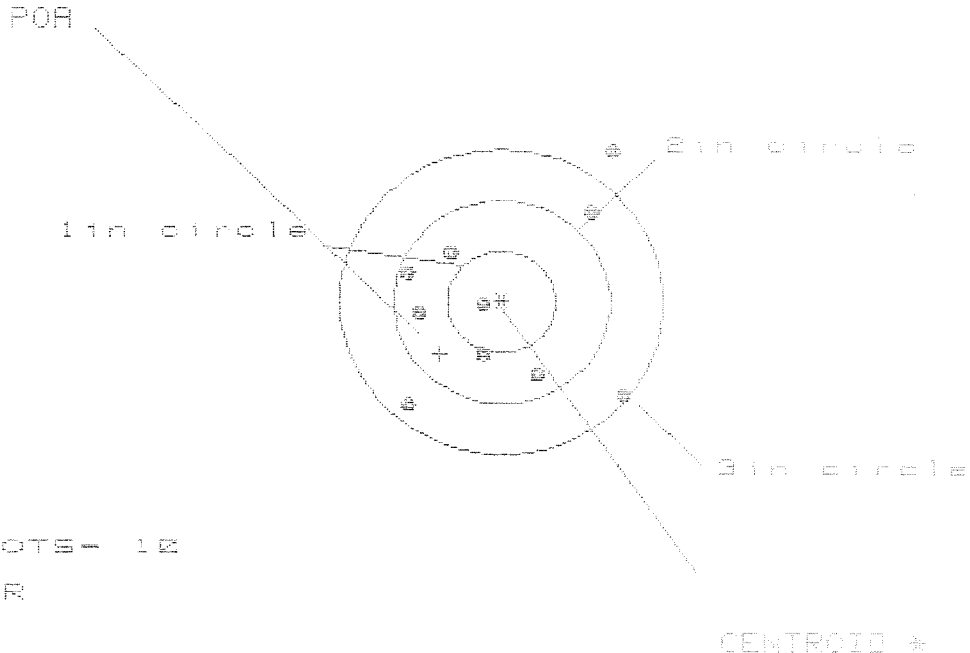
PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.855	1.135	.559
MINIMUM X	-1.565	-1.489	-1.347
MAXIMUM Y	1.426	1.190	.753
MINIMUM Y	-2.125	-1.743	-1.595
CENTROID X	.472	.396	.254
CENTROID Y	.903	1.139	.991
POR TO CENTROID in.	1.019	1.206	1.023
MIN RADIUS	.348	.235	.274
MEAN RADIUS	.929	.763	.662
MAX RADIUS	2.232	1.644	1.375
HORIZONTAL SPREAD	2.624	2.624	1.905
VERTICAL SPREAD	3.551	1.933	1.348
EXTREME SPREAD	3.571	3.084	1.934
NUMBER IN ONE INCH CIRCLE =		4	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		7	

9 Nov 1988

FILE:/PATTERNING/CENTERFIRE_PATT/00225100

CENTERFIRE PATTERNS

3



OF SHOTS- 10

IN CIR

1in = 1

2in = 6

3in = 9

HS= 1.287

VS= 2.536

GS= 3.173

PATTERN #

:

3

SHOTS (BEST OF)

:

10

9

8

MAXIMUM X

:

1.114

1.229

1.091

MINIMUM X

:

-.873

-.758

-.605

MAXIMUM Y

:

1.516

1.095

.999

MINIMUM Y

:

-1.020

-.852

-.948

CENTROID X

:

.571

.456

.302

CENTROID Y

:

.514

.346

.442

POA TO CENTROID IN.

:

.768

.572

.536

MIN RADIUS

:

.163

.201

.147

MEAN RADIUS

:

.765

.832

.724

MAX RADIUS

:

1.835

1.458

1.479

HORIZONTAL SPREAD

:

1.987

1.987

1.695

VERTICAL SPREAD

:

2.536

1.947

1.947

EXTREME SPREAD

:

3.173

2.581

2.581

NUMBER IN ONE INCH CIRCLE =

1

NUMBER IN TWO INCH CIRCLE =

6

NUMBER IN THREE INCH CIRCLE =

9

9 Nov 1988

FILE:/PATTERNING/CENTERFIRE_PATT/05225162

CENTERFIRE PATTERNS

4

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS- 10

IN CIR

1 in - 4

2 in - 7

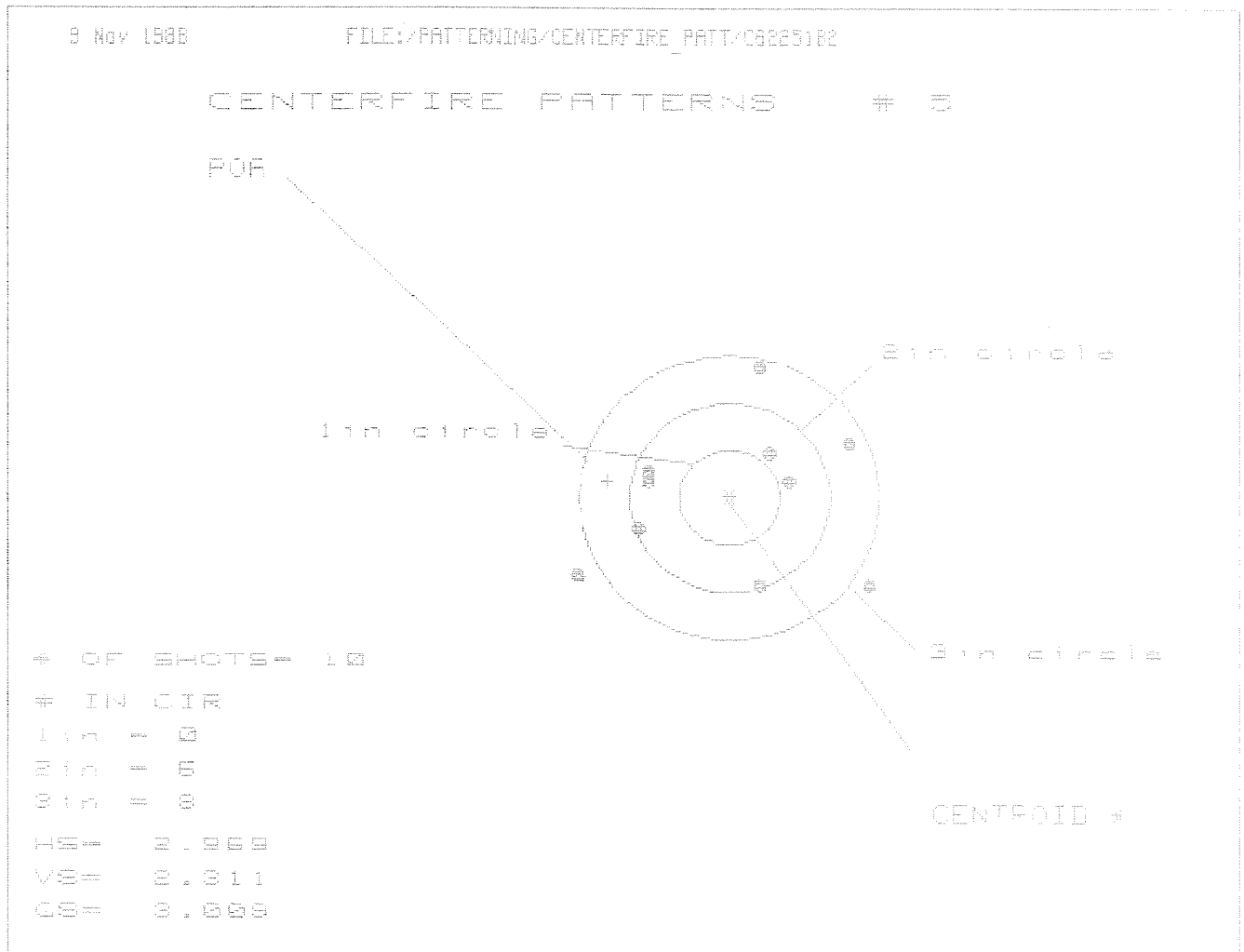
3 in - 9

HS- 2.501

VS- 1.749

GS- 2.720

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.314	1.171	.800
MINIMUM X	:	-1.287	-.848	-.701
MAXIMUM Y	:	.742	.630	.566
MINIMUM Y	:	-1.007	-.579	-.643
CENTROID X	:	1.007	1.150	1.003
CENTROID Y	:	-.038	.074	.138
POA TO CENTROID in.	:	1.007	1.152	1.012
MIN RADIUS	:	.168	.064	.206
MEAN RADIUS	:	.772	.658	.567
MAX RADIUS	:	1.634	1.278	.900
HORIZONTAL SPREAD	:	2.601	2.019	1.501
VERTICAL SPREAD	:	1.749	1.209	1.209
EXTREME SPREAD	:	2.720	2.213	1.906
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	



PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.435	1.300	1.128
MINIMUM X	-1.523	-1.374	-1.540
MAXIMUM Y	1.356	1.253	1.139
MINIMUM Y	-1.955	-1.031	-1.142
CENTROID X	1.210	1.051	1.223
CENTROID Y	-1.174	-1.069	1.043
POB TO CENTROID in.	1.223	1.053	1.223
MIN RADIUS	.565	.625	.430
MEAN RADIUS	1.089	1.001	.903
MAX RADIUS	1.724	1.635	1.191
HORIZONTAL SPREAD	2.969	2.674	2.076
VERTICAL SPREAD	2.311	2.281	2.281
EXTREME SPREAD	3.009	3.009	2.282
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	8		

BARBER M24 0010124NG REPORT

COMMENTS

ORDER
R 94-22620

INITIAL
FPS

CUSTOMER ORDER NO.

M-24 ATTN: FRED MARTIN/PAINTED OUTSIDE SHUP

DATE RECEIVED
08/01/94

DATE OPENED
08/02/94

DATE CODE
DI 9-88

SERIAL NUMBER
C6225182

NEW SERIAL NUMBER

MODEL AND GRADE
700 7.62

NATO

ACCESSORIES

W/STUDS

SCOPE MNTS

SCOPE BASE

FROM:

DEPT OF THE ARMY
B CO ARMS
2/75 RANGER BATTALION
FT LEWIS

WA 98433

SHIP TO:

DEPT OF THE ARMY
B CO ARMS
2/75 RANGER BATTALION
FT LEWIS

WA

98433

CUST NO: 062072 C.O.D.L

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

New Barrel

PARTS

COMMENTS

Barrel - 96003

Repowder Coat - Trigger Guard
Assy, Front & Rear Sight Bases
ReZinc - Scope Base, Rings
& Swivel Studs

REPAIRMAN

PROOF

CLEAN

TEST

TARGET

PATTERN

GALLERY TESTER

DATE

DATE

DATE

DATE

DATE

OFFICE COPY

RD6925 REV. 1/94

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

BARBER - M24 0010124NG 10163

BARBER - M24 0010125 PACKING LIST		BY <u>Mr. Ray Fuller</u> <u>WG-10 Bn. Armorer.</u>		1. NO. BOXES <u>1</u>		2a. REQUISITION NO. <u>92063</u>	
3. END ITEM <u>7.62mm 1124 Sniper Weapons System</u> <u>(SW5)</u>		4. DATE <u>26 July 1994</u>		5. PAGE <u>1</u> OF <u>1</u> PAGES			
BOX NO. (a)	CONTENTS - STOCK NUMBER AND NOMENCLATURE (b)	UNIT OF ISSUE (c)	QUANTITIES REQUIRED				
			INITIAL OPERATION (d)	RUNNING SPARES (e)	TOTAL (f)		
	<u>7.62mm 1124 Sniper Weapon System</u> <u>(SW5) Serial No. C6225182</u> <u>NSN: 1005-01-240-2136</u> <u>Note: All Optic Scope</u> <u>Ring mounts Packed</u>	<u>EA</u>			<u>1</u>		
6. THIS CERTIFIES THAT ITEMS LISTED HEREON ARE WITHIN THE SPECIFIED BOXES							
TYPED NAME AND TITLE <u>Ray Fuller WG-10 Bn. Armorer</u>			SIGNATURE 				

DD FORM 1 SEP 70 1750

USE TYPEWRITER - PRINT FIRMLY ON HARD SURFACE WITH HARD PENCIL OR BALLPOINT PEN

DA FORM 2407
MAY 81

EDITION OF JUL 79 IS OBSOLETE

NMP COPY 2

Final Inspection

In: C 6225/82

DATE REC'D: 8/2/94

DATE RET'D:

EDITOR:

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:

New Barrel

GUN SERIAL # C6225182

OP. #	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and Stock		8/3/94	RW
600	Proof		8/3/94	RW
607	Check Headspace		8/3/94	RW
610	Dis-assemble Gun		8/3/94	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		8/13/94	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/13/94	RW
	C) Inspect Ejector Hole for Chamfer		8/13/94	RW
	D) Oil Firing Pin Ass'y		8/13/94	RW
	E) Adjust Trigger Pull to Min Setting and Stake			

op. #	BARBER - M24 0010129 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							
	A) Time							
	B) Malfunctions							
	C) Pierced Primers							
	D) Optical Clarity of Scope							
645	Inspect for Live Ammo							
655	Final Inspection						8/14/94	WLB
	A) Headspace							
	B) Trigger Pull	2.56	2.55	2.57	2.55	2.56	8/15/94	WLB
	C) Function							
660	Pack							

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6225182
18 Aug 1994

CENTROIDAL DISTANCES

0 TO	1	.212603
1 TO	2	.241748
1 TO	3	.394707
1 TO	4	.224864
1 TO	5	.267899

3
1
0
0 <----POA

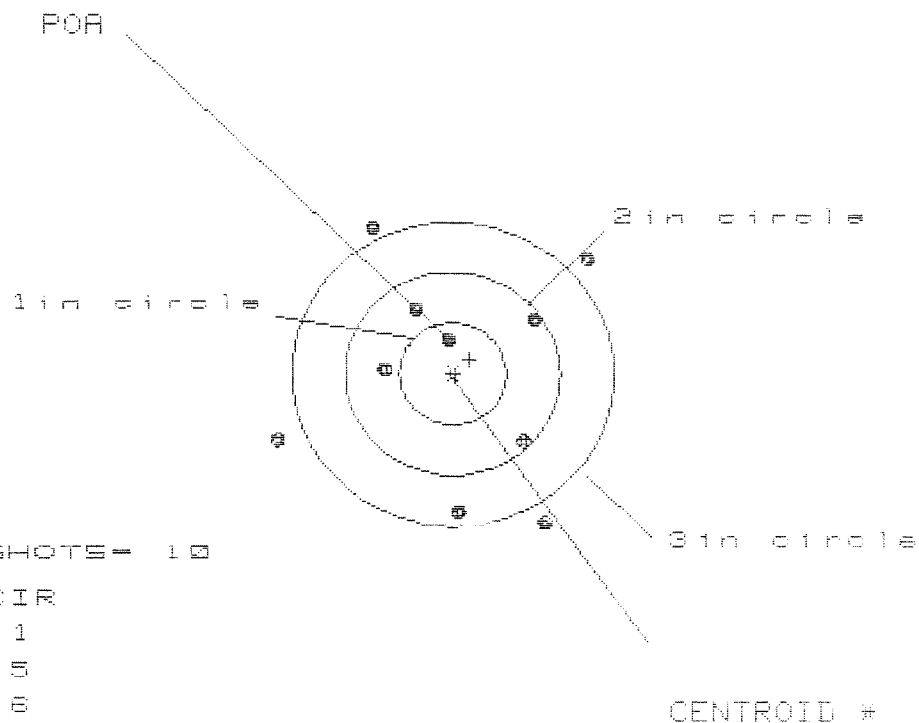
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0526
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1726
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .180437

THE AMR FOR THIS RIFLE IS: 1.017

18 Aug 1994

FILE:/PATTERNING/CENTERFIRE_PATT/08225182

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 5

3 in = 6

HS= 2.899

VS= 2.801

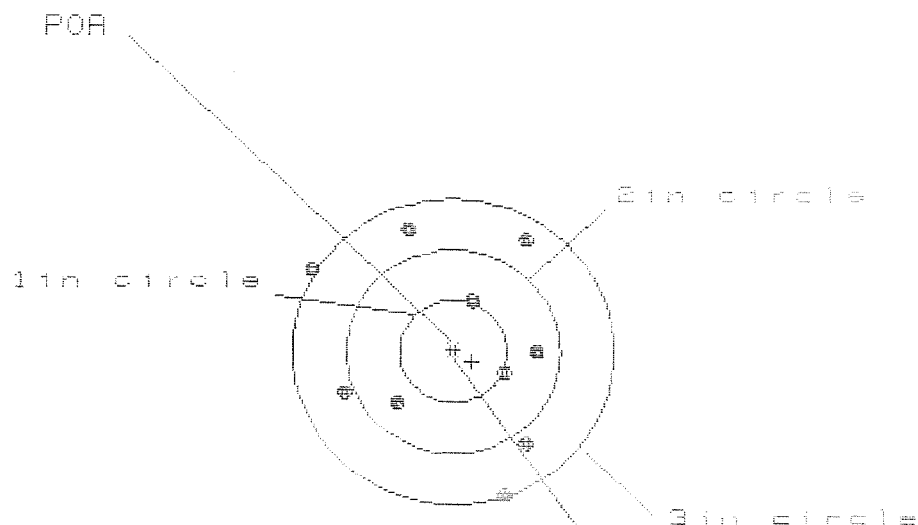
GS= 3.417

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.219	1.033	.780
MINIMUM X	-1.680	-.931	-.802
MAXIMUM Y	1.390	1.316	1.449
MINIMUM Y	-1.411	-1.485	-1.352
CENTROID X	-.160	.026	-.103
CENTROID Y	-.140	-.066	-.199
POA TO CENTROID in.	.213	.071	.224
MIN RADIUS	.382	.400	.453
MEAN RADIUS	1.182	1.000	1.025
MAX RADIUS	1.809	1.621	1.656
HORIZONTAL SPREAD	2.899	1.964	1.582
VERTICAL SPREAD	2.801	2.801	2.801
EXTREME SPREAD	3.417	3.217	3.217
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	6		

18 Aug 1994

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CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 4

3 in = 9

H0 = 2.054

V0 = 2.603

G0 = 2.815

PATTERN #	2	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.767	.821	.667
MINIMUM X	-1.287	-1.233	-1.158
MAXIMUM Y	1.169	1.010	1.084
MINIMUM Y	-1.433	-1.092	-1.018
CENTROID X	-.179	-.233	-.079
CENTROID Y	.101	.260	.186
POA TO CENTROID in.	.205	.349	.202
MIN RADIUS	.482	.359	.379
MEAN RADIUS	1.036	.976	.901
MAX RADIUS	1.514	1.368	1.241
HORIZONTAL SPREAD	2.054	2.054	1.825
VERTICAL SPREAD	2.603	2.102	2.102
EXTREME SPREAD	2.815	2.614	2.384
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	9		

18 Aug 1994

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CENTERFIRE PATTERNS # 3

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS = 10

IN CIR

1in = 0

2in = 0

3in = 0

H0 = 2.615

V0 = 2.225

G0 = 2.769

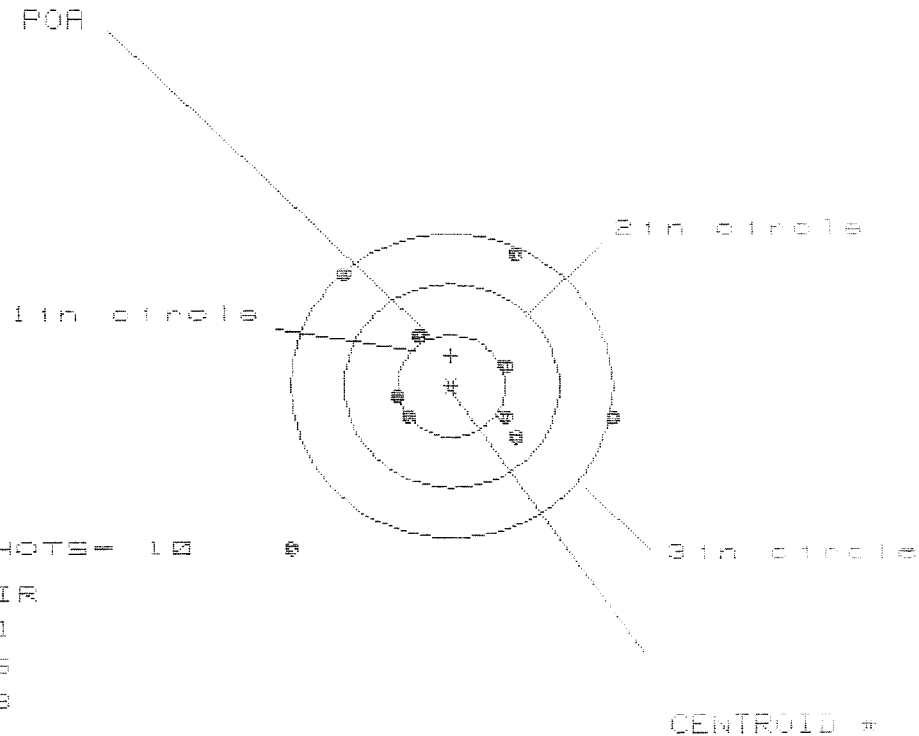
PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	1.430
MINIMUM X	-1.185
MAXIMUM Y	1.122
MINIMUM Y	-1.103
CENTROID X	-0.005
CENTROID Y	-0.503
POA TO CENTROID in.	.503
MIN RADIUS	.567
MEAN RADIUS	1.011
MAX RADIUS	1.542
HORIZONTAL SPREAD	2.615
VERTICAL SPREAD	2.225
EXTREME SPREAD	2.769
NUMBER IN ONE INCH CIRCLE =	0
NUMBER IN TWO INCH CIRCLE =	3
NUMBER IN THREE INCH CIRCLE =	9

18 Aug 1994

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CENTERFIRE PATTERNS

4

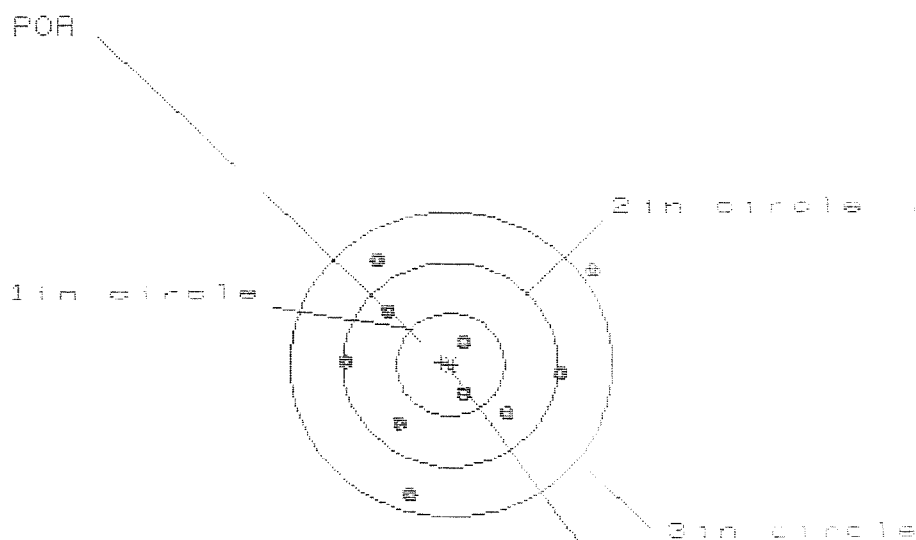


PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.485	1.320	.567
MINIMUM X	-1.481	-1.130	-.965
MAXIMUM Y	1.309	1.134	1.071
MINIMUM Y	-1.574	-.673	-.736
CENTROID X	.000	.165	-.000
CENTROID Y	-.298	-.123	-.060
POR TO CENTROID in.	.298	.206	.060
MIN RADIUS	.463	.302	.360
MEAN RADIUS	.995	.856	.781
MAX RADIUS	2.161	1.467	1.300
HORIZONTAL SPREAD	2.966	2.450	1.532
VERTICAL SPREAD	2.883	1.807	1.807
EXTREME SPREAD	3.536	2.843	2.211
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	8		

18 Aug 1994

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CENTERFIRE PATTERNS # 5



OF SHOTS = 10

IN CIR

1 in = 2

2 in = 6

3 in = 9

HS = 2.283

VS = 2.290

GS = 2.771

PATTERN #	5	5	5
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.344	1.149	1.119
MINIMUM X	-.939	-.790	-.821
MAXIMUM Y	1.006	1.103	.955
MINIMUM Y	-1.284	-1.187	-.587
CENTROID X	.081	-.069	-.038
CENTROID Y	-.023	-.120	.028
POA TO CENTROID in.	.084	.138	.047
MIN RADIUS	.229	.298	.254
MEAN RADIUS	.883	.795	.739
MAX RADIUS	1.603	1.230	1.121
HORIZONTAL SPREAD	2.283	1.939	1.939
VERTICAL SPREAD	2.290	2.290	1.542
EXTREME SPREAD	2.771	2.389	1.984
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	9		