

New Action

C6225233

E 637 4553

MODEL 700™ M24

Model 700 M24™

Action

Barrel Length

Capacity

Order No. 5716

*Includes 1 in chamber.

Remington

RD-6947-Rev 3

PAYMENT:

Mastercard / Visa (circle one)

Card #:

Exp. Date:

Signature:

RETURN:

☐ Clark Street Entrance☐ Via US Mail or UPS

(PLEASE PRINT CLEARLY)

FIREARMS DELIVERED TO PLANT

FILE NO 010807

DATE 1/17/96

CUSTOMER NAME:

ADDRESS:

ZIP:

PHONE:

FIREARM

MODEL:

GAUGE:

SERIAL #

REMINGTON EMPLOYEE:

YES ☐ NO ☒

EMPLOYEE #

DEPT. #

CHECK FOR AMMUNITION

CONDITION:

WOOD

GOOD

FAIR

POOR

FANCY

PLAIN

METAL

GOOD

FAIR

POOR

FANCY

PLAIN

BARREL

VT. RIB

PLAIN

DEER RSS

ACCESSORIES:

SCOPE: YES

NO

(BRAND NAME/POWER)

SLING: YES

NO

GUN CASE: YES

NO

(HARD - SOFT)

EXTRA BBL FOR GUN MENTIONED ABOVE:

OTHER (Note in this area items missing or added from orig. equipment)

CUSTOMER REQUEST:

SIGNATURE:

(Person delivering firearm to Plant)

DATE:

SIGNATURE:

(Security Officer)

DATE:

SIGNATURE:

(Firearm picked up by)

DATE:

Arm Service Copy

CONTRACT # DAAA21-87-C-0086

New Barrel
Stock

GUN SERIAL # C6225233

OP. #	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and Stock		1/22/96	Ru
600	Proof		1/22/96	Ru
607	Check Headspace		1/23/96	Ru
610	Dis-assemble Gun		1/23/96	Ru
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		1/30/96	Ru
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		1/30/96	Ru
	C) Inspect Ejector Hole for Chamfer		1/30/96	Ru
	D) Oil Firing Pin Ass'y		1/30/96	Ru
	E) Adjust Trigger Pull to Min Setting and Stake			

op. #	OP. NAME BARBER - M24 0011134	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		1/30/96	RW
	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		1/31/96	WB
	A) Time			
	B) Malfunctions			
	C) Pierced Primers			
	D) Optical Clarity of Scope			
645	Inspect for Live Ammo		1/31/96	WB
655	Final Inspection A) Headspace		2/1/96	RW
	B) Trigger Pull			
	C) Function		2/1/96	RW
660	Pack			

Final Inspection

Sn: C6225233

DATE REC'D: 1/17/96

DATE RET'D:

Auditor: RW

Item:

Barrel Assy.

☒ BARREL☒ RECEIVER☒ FRONT SIGHT BLOCK☒ REAR SIGHT BLOCK☒ SCREWS☒ FINISH

Item:

Stock Assy.

☒ STOCK☒ SLING SWIVEL STUDS☒ ADJUSTABLE BUTT PLATE☒ LOCK NUTS☒ BARREL CLEARANCE☒ COLOR/FINISH

Scope Assy.

☐ SCOPE☐ SCOPE RINGS☐ MOUNTING SCREWS☐ MOUNTING BASE☐ SCREWS☐ FINISH☐ LOOSENESS☐ CLARITY

Systems Case

☐ SCOPE CASE☐ IRON SIGHTS☐ DEPLOYMENT KIT

Trigger

☒ SAFETY OPERATION☒ SET

Misc.

☐ DD-250☐ BAR CODE☐ PACKAGING

Comments: _____

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06225233
3 Jan 1900

CENTROIDAL DISTANCES

0 TO	1	2.47804
1 TO	2	.5441
1 TO	3	.885384
1 TO	4	.691903
1 TO	5	.864901

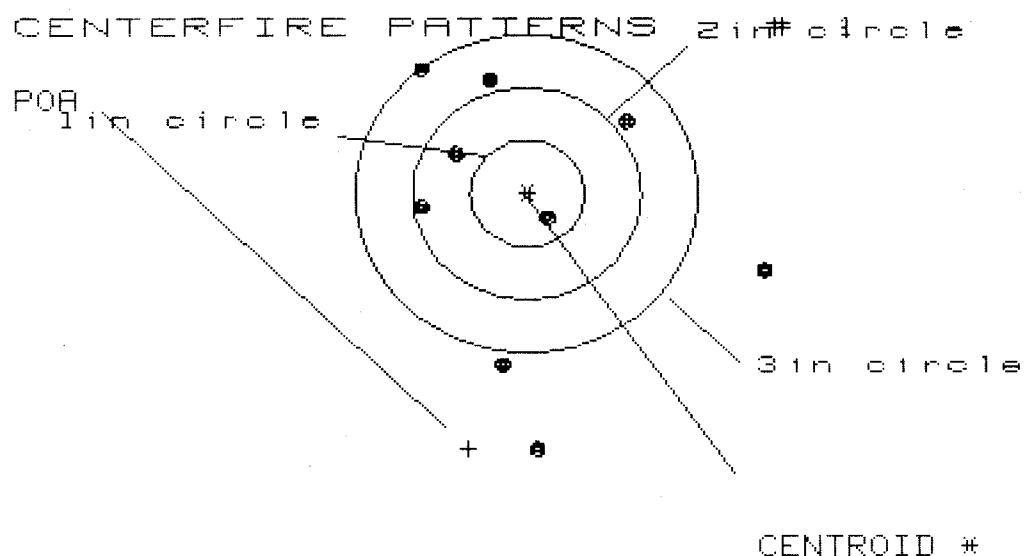
$\frac{4}{5}^1$

+ (----) FOR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0592
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: 2.055
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: 2.05585
THE AMR FOR THIS RIFLE IS: 1.092

2 Jan 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C6225233



OF SHOTS - 10

IN CIR

1 in = 1

2 in = 3

3 in = 6

HS = 2.948

VS = 4.396

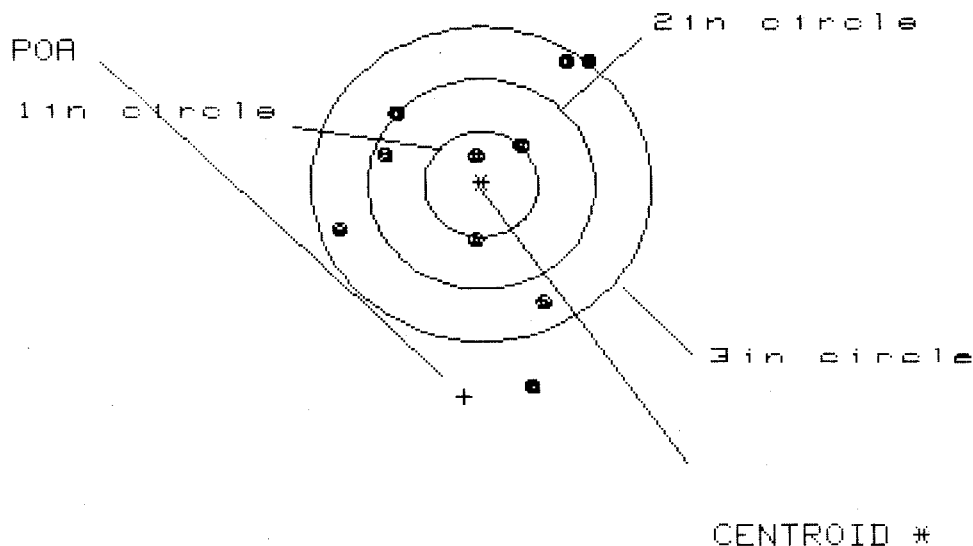
GS = 4.404

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	2.035	2.042	1.139
MINIMUM X	-0.913	-0.906	-0.651
MAXIMUM Y	1.935	1.662	1.536
MINIMUM Y	-2.461	-1.934	-2.060
CENTROID X	.524	.517	.262
CENTROID Y	2.422	2.695	2.821
POA TO CENTROID in.	2.478	2.744	2.834
MIN RADIUS	.319	.562	.375
MEAN RADIUS	1.395	1.246	1.061
MAX RADIUS	2.461	2.278	2.062
HORIZONTAL SPREAD	2.948	2.948	1.790
VERTICAL SPREAD	4.396	3.596	3.596
EXTREME SPREAD	4.404	3.596	3.596
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	3		
NUMBER IN THREE INCH CIRCLE =	6		

2 Jan 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C6225233

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 1

2in = 4

3in = 8

HS= 2.221

VS= 3.175

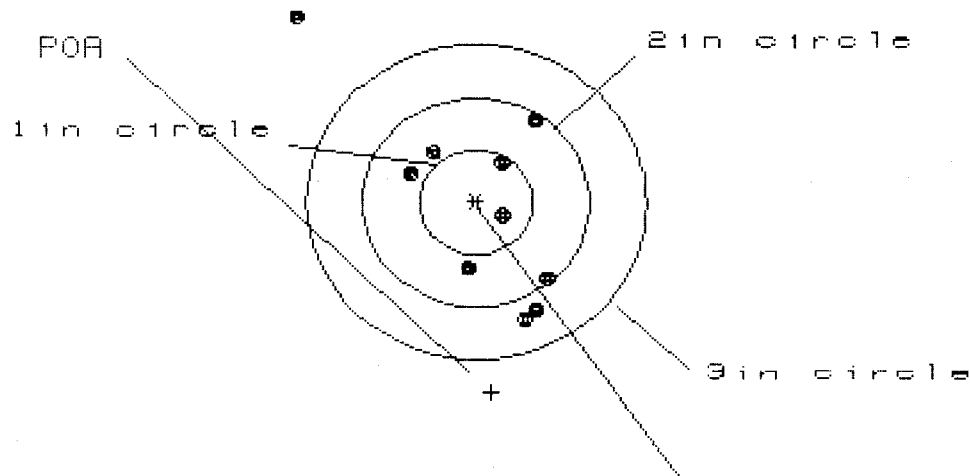
GS= 3.213

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.989	1.039	.932
MINIMUM X	:	-1.232	-1.182	-1.052
MAXIMUM Y	:	1.219	1.002	1.126
MINIMUM Y	:	-1.956	-1.382	-1.258
CENTROID X	:	.153	.103	-.027
CENTROID Y	:	2.024	2.241	2.117
POA TO CENTROID in.	:	2.030	2.243	2.117
MIN RADIUS	:	.263	.051	.178
MEAN RADIUS	:	1.082	.938	.875
MAX RADIUS	:	2.006	1.497	1.462
HORIZONTAL SPREAD	:	2.221	2.221	1.984
VERTICAL SPREAD	:	3.175	2.384	2.384
EXTREME SPREAD	:	3.213	2.740	2.556
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	

2 Jan 1988

FILE:/PATTERNING/CENTERFIRE_PATT/06225233

CENTERFIRE PATTERNS # 3



CENTROID *

OF SHOTS - 10

IN CIR

1 in - 2

2 in - 7

3 in - 9

HS - 2.181

VS - 2.982

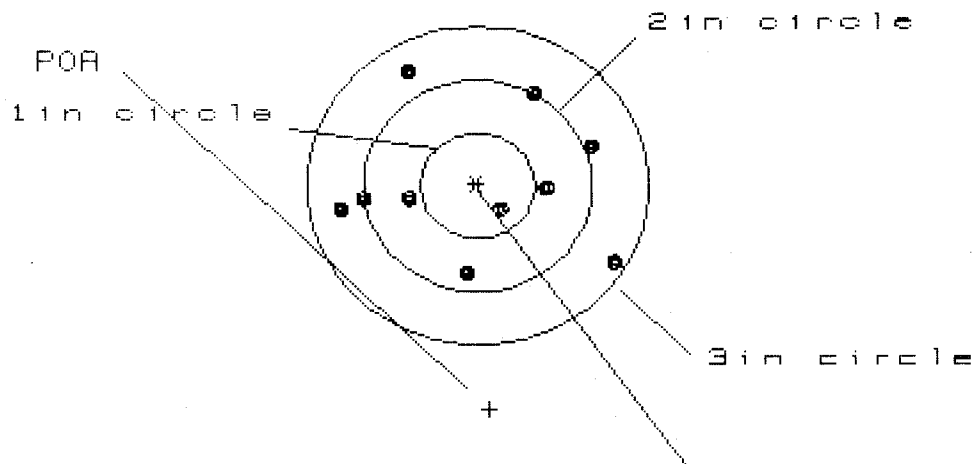
GS - 3.527

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.599	.423	.454
MINIMUM X	:	-1.582	-.750	-.719
MAXIMUM Y	:	1.734	.969	.848
MINIMUM Y	:	-1.168	-.976	-.939
CENTROID X	:	-.128	.048	.017
CENTROID Y	:	1.823	1.631	1.752
POA TO CENTROID in.	:	1.828	1.631	1.753
MIN RADIUS	:	.259	.121	.099
MEAN RADIUS	:	.924	.733	.687
MAX RADIUS	:	2.347	1.048	1.007
HORIZONTAL SPREAD	:	2.181	1.173	1.173
VERTICAL SPREAD	:	2.982	1.945	1.786
EXTREME SPREAD	:	3.527	1.951	1.787
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

2 Jan 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C6225233

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 10

HS= 2.402

VS= 1.939

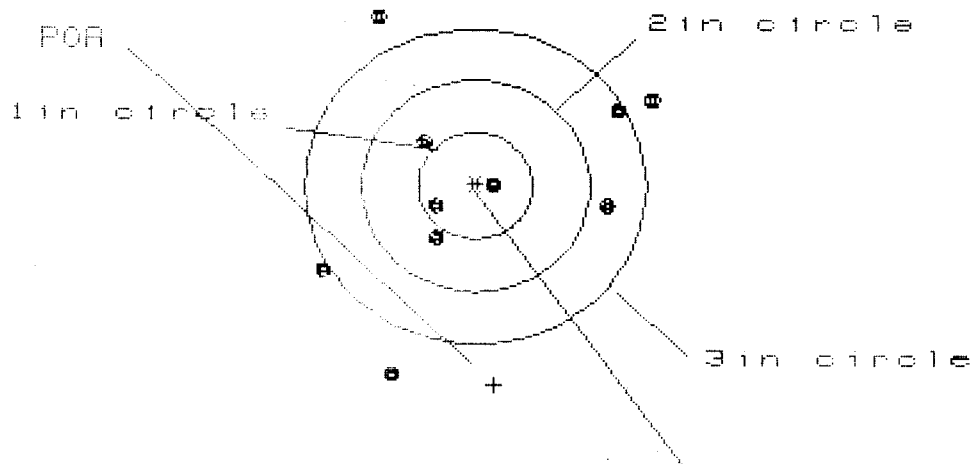
GS= 2.470

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.163	1.107	.968
MINIMUM X	:	-1.239	-1.110	-.962
MAXIMUM Y	:	1.068	.991	.952
MINIMUM Y	:	-.871	-.948	-.987
CENTROID X	:	-.099	-.228	-.089
CENTROID Y	:	2.121	2.198	2.237
POA TO CENTROID in.	:	2.123	2.210	2.239
MIN RADIUS	:	.300	.448	.384
MEAN RADIUS	:	.919	.872	.826
MAX RADIUS	:	1.353	1.153	1.115
HORIZONTAL SPREAD	:	2.402	2.217	1.930
VERTICAL SPREAD	:	1.939	1.939	1.939
EXTREME SPREAD	:	2.470	2.293	1.994
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	5		
NUMBER IN THREE INCH CIRCLE	=	10		

2 Jan 1968

FILE:/PATTERNING/CENTERFIRE_PATT/C6225233

CENTERFIRE PATTERNS # 5



OF SHOTS - 10

IN CIR

1 in - 2

2 in - 4

3 in - 7

MEAN = 2.808

MS = 3.486

CS = 3.436

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.511	1.424	1.304
MINIMUM X	:	-1.297	-1.384	-1.504
MAXIMUM Y	:	1.613	1.414	.742
MINIMUM Y	:	-1.793	-.947	-.771
CENTROID X	:	-.154	-.067	.053
CENTROID Y	:	1.885	2.084	1.908
POB TO CENTROID in.	:	1.891	2.085	1.908
MIN RADIUS	:	.172	.246	.066
MEAN RADIUS	:	1.140	1.064	.951
MAX RADIUS	:	1.956	1.710	1.690
HORIZONTAL SPREAD	:	2.808	2.808	2.808
VERTICAL SPREAD	:	3.486	3.361	1.512
EXTREME SPREAD	:	3.486	3.190	3.190
SHOTS IN ONE INCH CIRCLE	=		2	
SHOTS IN TWO INCH CIRCLE	=		4	
SHOTS IN THREE INCH CIRCLE	=		7	

RECEIVING AND ESTIMATING REPORT

COMMENTS

ORDER
R 93-26583

INITIAL CUSTOMER ORDER NO.

FPS 8326

WOG 5 OF 7 M-24 ATTN: FRED MARTIN
W/ADJUSTABLE RECOIL PAD

DATE RECEIVED

DATE OPENED

DATE CODE

SERIAL NUMBER

NEW SERIAL NUMBER

MODEL AND GRADE

12/09/93

12/09/93

LI 2-88

C6225233

700 7.62

NATO

ACCESSORIES

W/STUDS

SCOPE BASE

FROM:

SHIP TO:

U. S. ARMY
THOMPSON, ALLAN R
CO. D 2ND BN. 1ST SWTG
FT BRAGG NC 28307

U. S. ARMY
THOMPSON, ALLAN R
CO. D 2ND BN. 1ST SWTG
FT BRAGG NC 28307

CUST NO: 088383 C.O.D

ACCOUNT NUMBER

ACCOUNT NUMBER N/C

WRITE ☐

PROM. DATE

ESTIMATED

VIA

UPS Door

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

Replace Barrel Assy

PARTS

COMMENTS

Barrel Assy - 96003

Re zinc - Scope Base & Swivel Studs

Repowder Coat - Floor plate, Latch, Trigger Guard Front & Rear Sight Bases

W52 H09401 H229

REPAIRMAN

PROOF

CLEAN

TEST

TARGET

PATTERN

Rw

✓

✓

✓

✓

GALLERY TESTER

DATE

DATE

DATE

DATE

DATE

Rw

12/16/93

1/4/94

1/4/94

1/4/94

OFFICE COPY

RD6925 REV. 1/92

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

BARBER - M24 0844922 11181

New Barrel

GUN SERIAL # C6225233

OP. #	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and Stock		12/16/93	RW
600	Proof		12/16/93	RW
607	Check Headspace		12/16/93	RW
610	Dis-assemble Gun		12/16/93	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		12/28/93	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		12/28/93	RW
	C) Inspect Ejector Hole for Chamfer		12/28/93	RW
	D) Oil Firing Pin Ass'y		12/28/93	RW
	E) Adjust Trigger Pull to Min Setting and Stake		12/28/93	RW

BARBER - M24 0011144

op. #	OP. NAME	READINGS					DATE	INIT
5 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						1/4/94	RW
	A) Time							
	B) Malfunctions							
	C) Pierced Primers							
	D) Optical Clarity of Scope							
645	Inspect for Live Ammo						1/4/94	RW
655	Final Inspection						1/4/94	RW
	A) Headspace						1/4/94	RW
	B) Trigger Pull	2.52	2.39	2.24	2.33	2.37	1/4/94	RW
	C) Function						1/4/94	RW
660	Pack							

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06225233
11 Jan 1994

CENTROIDAL DISTANCES

0 TO	1	.246343
1 TO	2	.284431
1 TO	3	.216585
1 TO	4	.781231
1 TO	5	.531504

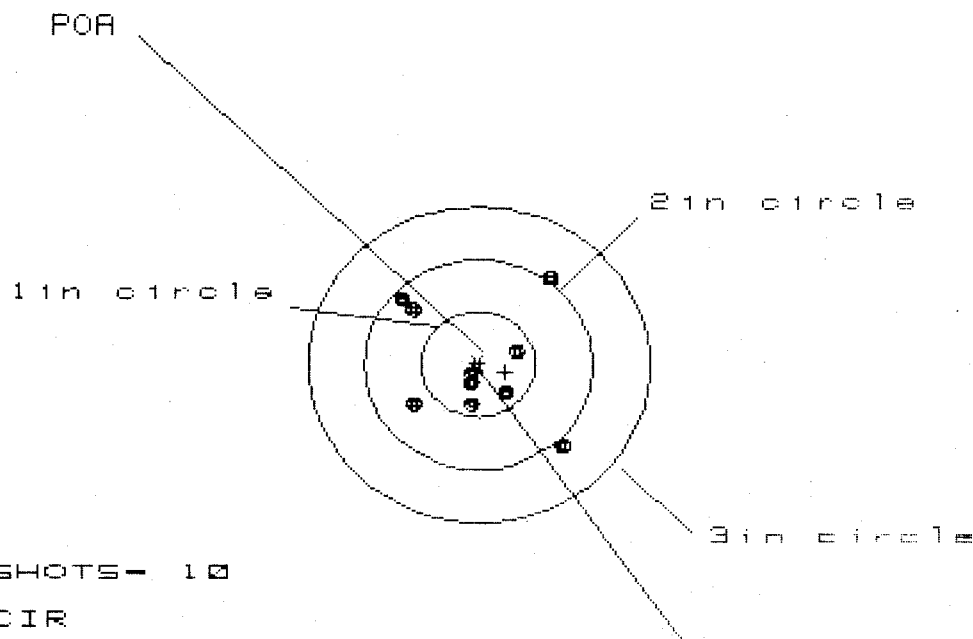
$\frac{1}{5}$
 $\frac{1}{25}$ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.2352
 THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .2472
 THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .341214
 THE AMR FOR THIS RIFLE IS: .8352

11 Jan 1994

FILE:/PATTERNING/CENTERFIRE_PATT/08225233

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in - 5

2in - 8

3in = 10

HS= 1.384

VS= 1.584

GS= 1.989

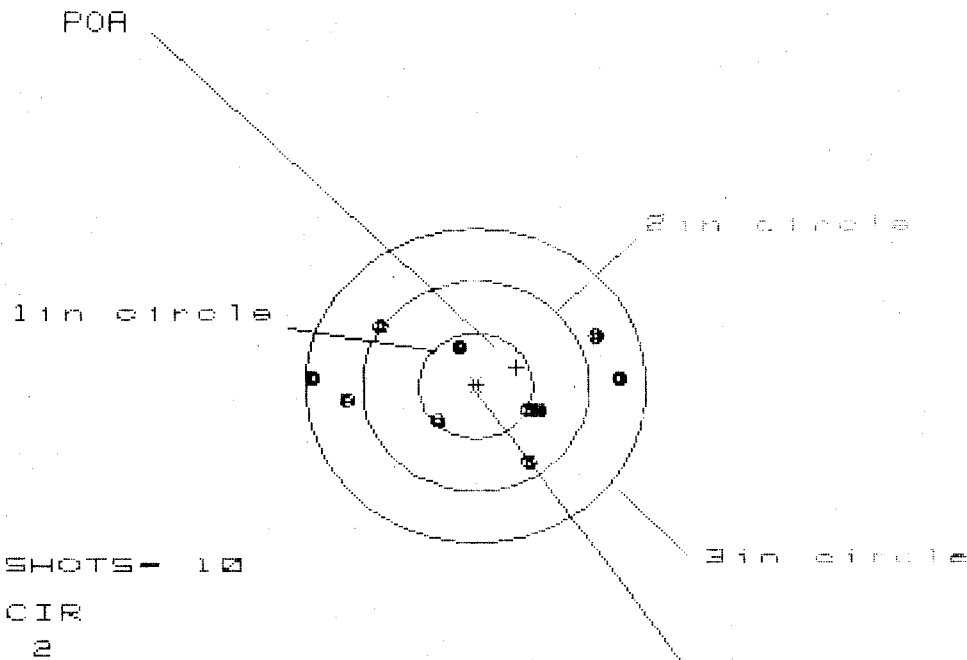
CENTROID #

PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.747	.693	.527
MINIMUM X	:	-.637	-.554	-.467
MAXIMUM Y	:	.816	.731	.667
MINIMUM Y	:	-.768	-.511	-.420
CENTROID X	:	-.234	-.317	-.404
CENTROID Y	:	.077	.162	.071
POA TO CENTROID in.	:	.247	.357	.410
MIN RADIUS	:	.127	.192	.142
MEAN RADIUS	:	.598	.560	.480
MAX RADIUS	:	1.072	1.007	.814
HORIZONTAL SPREAD	:	1.384	1.247	.994
VERTICAL SPREAD	:	1.584	1.242	1.087
EXTREME SPREAD	:	1.989	1.662	1.273
NUMBER IN ONE INCH CIRCLE	=		5	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	

11 Jan 1994

FILE:/PATTERNING/CENTERFIRE_PATT/06225233

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in - 2

2in - 5

3in = 10

HS= 2.661

VS= 1.354

GS= 2.661

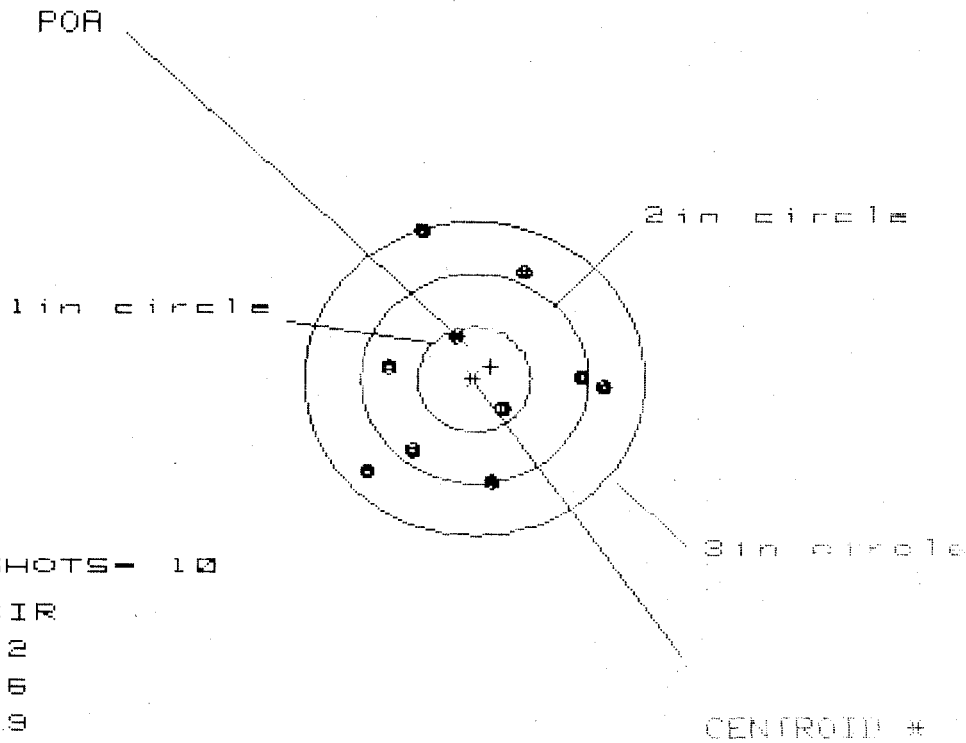
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.269	1.114	1.035
MINIMUM X	:	-1.392	-1.307	-1.168
MAXIMUM Y	:	.611	.623	.633
MINIMUM Y	:	-.743	-.731	-.721
CENTROID X	:	-.360	-.205	-.344
CENTROID Y	:	-.178	-.190	-.200
POA TO CENTROID in.	:	.401	.279	.398
MIN RADIUS	:	.424	.389	.450
MEAN RADIUS	:	.888	.811	.775
MAX RADIUS	:	1.397	1.313	1.174
HORIZONTAL SPREAD	:	2.661	2.421	2.203
VERTICAL SPREAD	:	1.354	1.354	1.354
EXTREME SPREAD	:	2.661	2.430	2.280
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		10	

11 Jan 1994

FILE:/PATTERNING/CENTERFIRE_PATT/C6225233

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in - 2

2 in - 6

3 in - 9

HS- 2.120

VS- 2.377

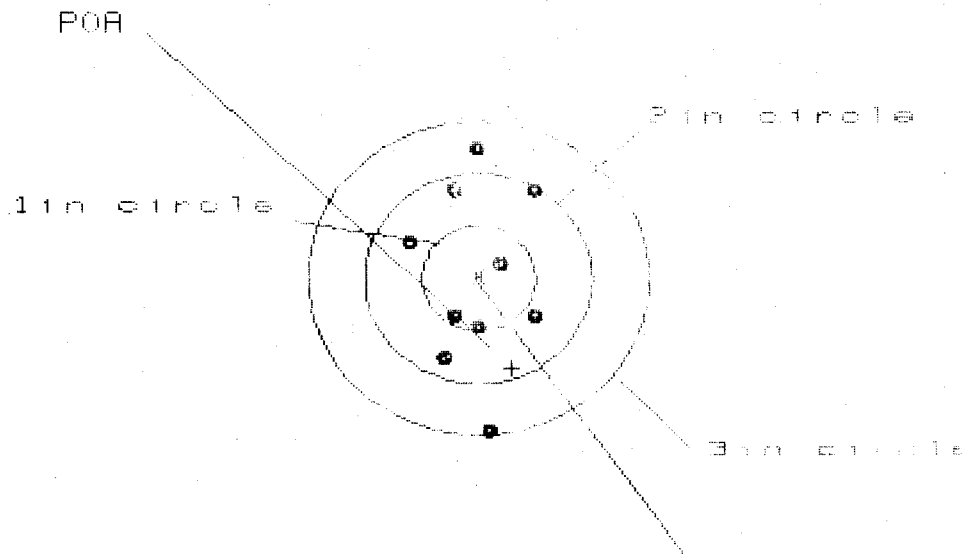
GS- 2.452

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.181	1.126	1.002
MINIMUM X	:	-.939	-.994	-.718
MAXIMUM Y	:	1.429	1.135	1.047
MINIMUM Y	:	-.948	-.790	-.878
CENTROID X	:	-.144	-.089	.035
CENTROID Y	:	-.120	-.278	-.190
POA TO CENTROID in.	:	.187	.292	.193
MIN RADIUS	:	.397	.253	.237
MEAN RADIUS	:	.942	.862	.808
MAX RADIUS	:	1.512	1.221	1.077
HORIZONTAL SPREAD	:	2.120	2.120	1.920
VERTICAL SPREAD	:	2.377	1.925	1.925
EXTREME SPREAD	:	2.452	2.300	1.957
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

11 Jan 1994

FILE:/PATTERNING/CENTERFIRE_PATT/C6225233

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1 in - 3

2 in - 8

3 in = 10

HS- 1.157

VS= 2.677

GS= 2.678

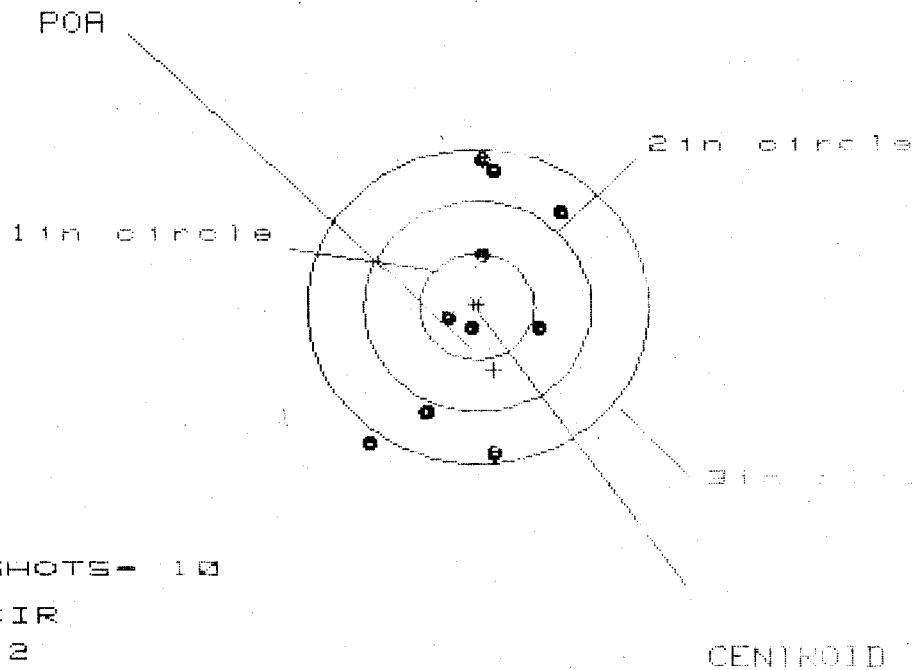
CENTROID

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.540	.551	.554
MINIMUM X	:	-.617	-.606	-.603
MAXIMUM Y	:	1.217	1.055	.832
MINIMUM Y	:	-1.460	-.927	-.795
CENTROID X	:	-.293	-.304	-.307
CENTROID Y	:	.856	1.018	.886
POA TO CENTROID in.	:	.905	1.062	.938
MIN RADIUS	:	.218	.185	.213
MEAN RADIUS	:	.786	.711	.649
MAX RADIUS	:	1.463	1.055	.972
HORIZONTAL SPREAD	:	1.157	1.157	1.157
VERTICAL SPREAD	:	2.677	1.982	1.627
EXTREME SPREAD	:	2.678	2.005	1.799
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	

11 Jan 1994

FILE:/PATTERNING/CENTERFIRE_PATT/C8225233

CENTERFIRE PATTERNS # 5



OF SHOTS - 10

IN CIR

1in = 2

2in = 4

3in = 9

HS= 1.735

VS= 2.833

GS= 2.888

PATTERN #	:	5
SHOTS (BEST OF)	:	10
MAXIMUM X	:	.749
MINIMUM X	:	-.986
MAXIMUM Y	:	1.442
MINIMUM Y	:	-1.391
CENTROID X	:	-.145
CENTROID Y	:	.601
POA TO CENTROID in.	:	.618
MIN RADIUS	:	.201
MEAN RADIUS	:	.962
MAX RADIUS	:	1.609
HORIZONTAL SPREAD	:	1.735
VERTICAL SPREAD	:	2.833
EXTREME SPREAD	:	2.888
NUMBER IN ONE INCH CIRCLE	=	2
NUMBER IN TWO INCH CIRCLE	=	4
NUMBER IN THREE INCH CIRCLE	=	9

00299

[illegible]

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # *C6225233*

OPERATION		DATE	INT
#	NAME		
575-580	ASSEMBLY	1/22	FB
600	PROOF	<i>1/28/88</i>	<i>RL</i>
615	MAGNAFLUX BARREL	<i>2/18/88</i>	<i>Pfc.</i>
	MAGNAFLUX BOLT	<i>2/25/88</i>	<i>Pfc.</i>
620	COATING	<i>3/21/88</i>	<i>JA</i>
625-630	FINAL ASSEMBLY		
635	TEST		
640	TARGET		
	FIRING PIN INDENT		
660	PACK		

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6225233

OP.#	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and stock			
600	Proof			
607	Check Headspace			
610	Dis-assemble gun			
612	Magnaflux Barrel Action			
	Magnaflux Bolt			
615	Rollmark Caliber			
617	Drill & Tap Sight Holes			
618	Polish Barrel			
620	Apply Coatings (Barrel Action)			
	Apply Coatings (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		9/13/88	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		9/13/88	RW
	C) Inspect Ejector Hole for Chamfer		9/13/88	RW

OVER

OP. #		READINGS	DATE	INITIAL
625 cont.	D) Oil Firing Pin Ass'y		9/13/88	RW
	E) Adjust Trigger Pull to Min. Setting and Stake			
	F) Safety on Force	5 5 5	13 Sept 88	RL
	G) Safety off Force	3 ^{FF} 3 3	13 Sept 88	RL
	H) Trigger Pull Test & Retainability		10-7-88	JS
	I) Firing Pin Indent	.021 .021 .021	13 Sept 88	RL
	J) Assemble Stock		9/14/88	RW
	K) Assemble Swivel Studs		10-7-88	JS
	L) Attach Front & Rear Sight Assemblies		9/14/88	RW
	M) Iron Sight Alignment		9/14/88	RW
	N) Detach Front & Rear Sights & place in numbered container		9/14/88	RW
	O) Attach Scope to Rifle		10/5/88	RW
	P) Detach & Attach Scope 20 times		10-5-88	JS
640	Gallery Target & Test	62 R 93 L	10/6-88	JES
	A) Optical Clarity of Scope		10/6/88	RL
645	Inspect for Live Ammo		10/6/88	RL
655	Final Inspection			
	A) Headspace		10-7-88	JS
	B) Trigger Pull		10-7-88	JS
	C) Function		10-7-88	JS
660	Pack	OK	10/20/88	W.B.

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

SERIAL NO. C6225233DATE 13 SEPT - 88TESTER J.P.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#	COMMENTS
PULL #1	2.52	2.36	2.57 2.39	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.48	2.46	2.56 2.33	
PULL #3	2.48	2.39	2.62 2.32	
PULL #4	2.44	2.58	2.57 2.35	
PULL #5	2.51	2.52	2.54 2.35	
TOTAL	12.43	12.31	12.86 11.74	
AVG.	2.486	2.462	2.572 2.348	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.37	3.18		
PULL #2	3.28	3.25		
PULL #3	3.32	3.21		
PULL #4	3.25	3.28		
PULL #5	3.25	3.27		
TOTAL	16.47	16.14		
AVG.	3.294	3.238		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.22	4.09		4.38
PULL #2	4.13	4.12		4.35
PULL #3	4.12	4.10		4.37
PULL #4	4.18	4.09		4.37
PULL #5	4.17	4.13		4.39
TOTAL	20.82	20.53		21.85
AVG.	4.164	4.106		4.372

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6225233

CENTROIDAL DISTANCES

0 TO	1	.385253
1 TO	2	.830509
1 TO	3	.0621289
1 TO	4	.545495
1 TO	5	.552067

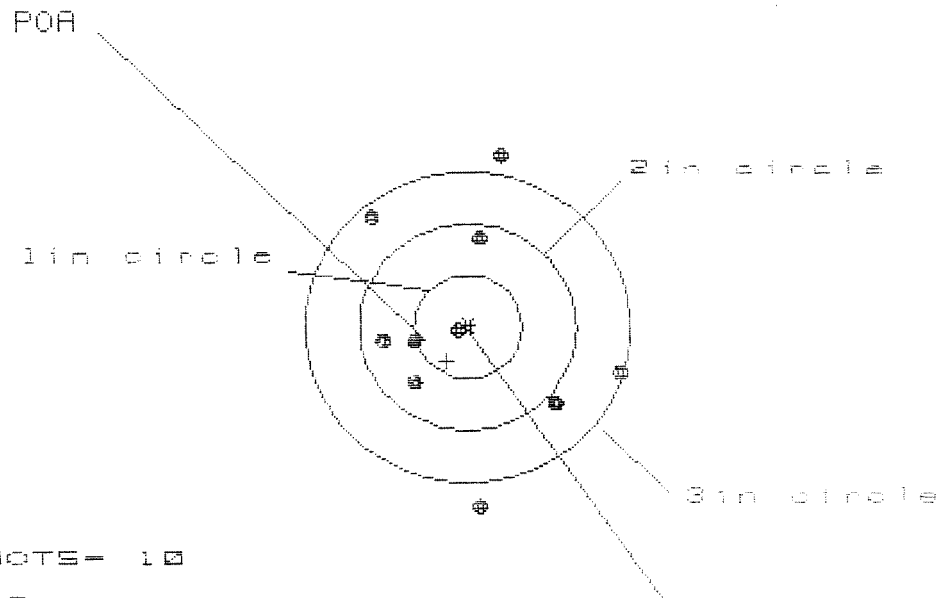
$\frac{9}{54} \times 2 \times \text{----POA}$

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .2346
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0544
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .240825
THE AMR FOR THIS RIFLE IS: 1.127

7 Oct 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C8285233

CENTERFIRE PATTERNS # 1



OF SHOTS - 10

IN CIR

1in = 2

2in = 5

3in = 8

HS = 2.221

VS = 3.443

GS = 3.450

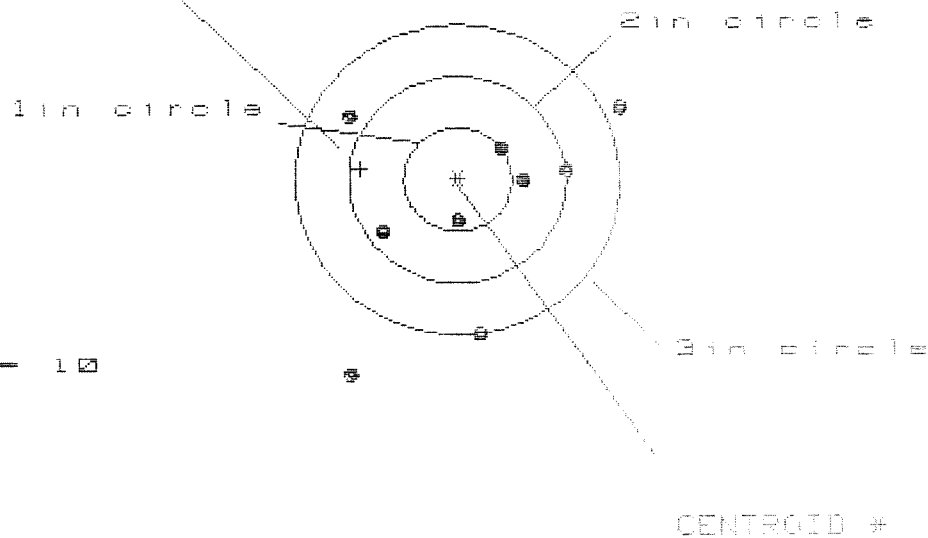
PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.371	1.381	1.421
MINIMUM X	-0.850	-0.840	-0.800
MAXIMUM Y	1.689	1.494	1.059
MINIMUM Y	-1.754	-0.917	-0.731
CENTROID X	.192	.182	.142
CENTROID Y	.334	.529	.343
POA TO CENTROID in.	.386	.560	.371
MIN RADIUS	.101	.228	.055
MEAN RADIUS	1.029	.958	.839
MAX RADIUS	1.757	1.528	1.475
HORIZONTAL SPREAD	2.221	2.221	2.221
VERTICAL SPREAD	3.443	2.411	1.790
EXTREME SPREAD	3.450	2.655	2.655
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	8		

7 Oct 1986

FILE:/PATTERNING/CENTERFIRE_PATT/C6225233

CENTERFIRE PATTERNS # 2

POA



OF SHOTS = 10

IN CIR

1 in = 2

2 in = 4

3 in = 7

HS = 2.520

VS = 4.437

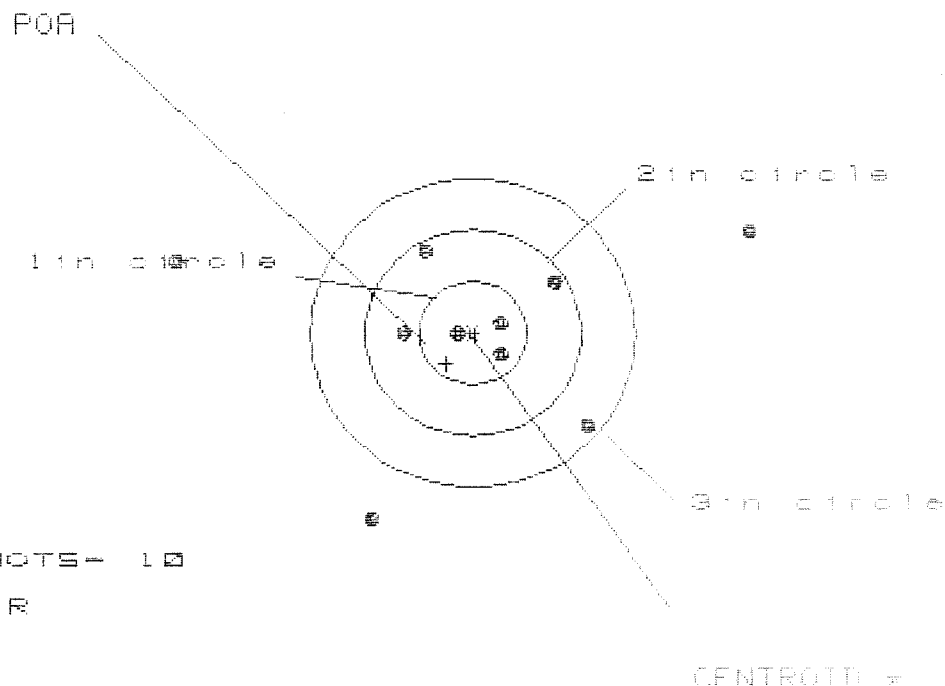
GS = 4.441

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.484	1.389	1.247
MINIMUM X	:	-1.036	-1.131	-1.210
MAXIMUM Y	:	2.533	1.012	.810
MINIMUM Y	:	-1.904	-1.623	-1.383
CENTROID X	:	.897	.992	1.133
CENTROID Y	:	-.105	-.386	-.184
POA TO CENTROID in.	:	.903	1.065	1.148
MIN RADIUS	:	.379	.164	.351
MEAN RADIUS	:	1.244	1.052	.907
MAX RADIUS	:	2.673	1.978	1.487
HORIZONTAL SPREAD	:	2.520	2.520	2.458
VERTICAL SPREAD	:	4.437	2.635	2.193
EXTREME SPREAD	:	4.441	3.646	2.557
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		7	

7 Oct 1988

FILE:/PATTERNING/CENTERFIRE_PATT/08225233

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 6

3 in = 7

HS= 5.206

VS= 2.838

GS= 5.318

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	2.589	2.288	1.636
MINIMUM X	-2.717	-1.214	-1.929
MAXIMUM Y	1.021	1.095	.965
MINIMUM Y	-1.817	-1.743	-1.606
CENTROID X	.244	.545	.260
CENTROID Y	.300	.226	.089
POA TO CENTROID in.	.386	.590	.274
MIN RADIUS	.125	.136	.255
MEAN RADIUS	1.214	1.030	.841
MAX RADIUS	2.796	2.536	1.855
HORIZONTAL SPREAD	5.306	3.502	1.965
VERTICAL SPREAD	2.838	2.838	2.571
EXTREME SPREAD	5.318	4.508	2.805
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	7		

7 Oct 1988

FILE:/PATTERNING/CENTERFIRE_PATT/08225233

CENTERFIRE PATTERNS # 4

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS - 10

IN CIR

1in = 1

2in = 3

3in = 6

H0 = 3.415

V0 = 4.359

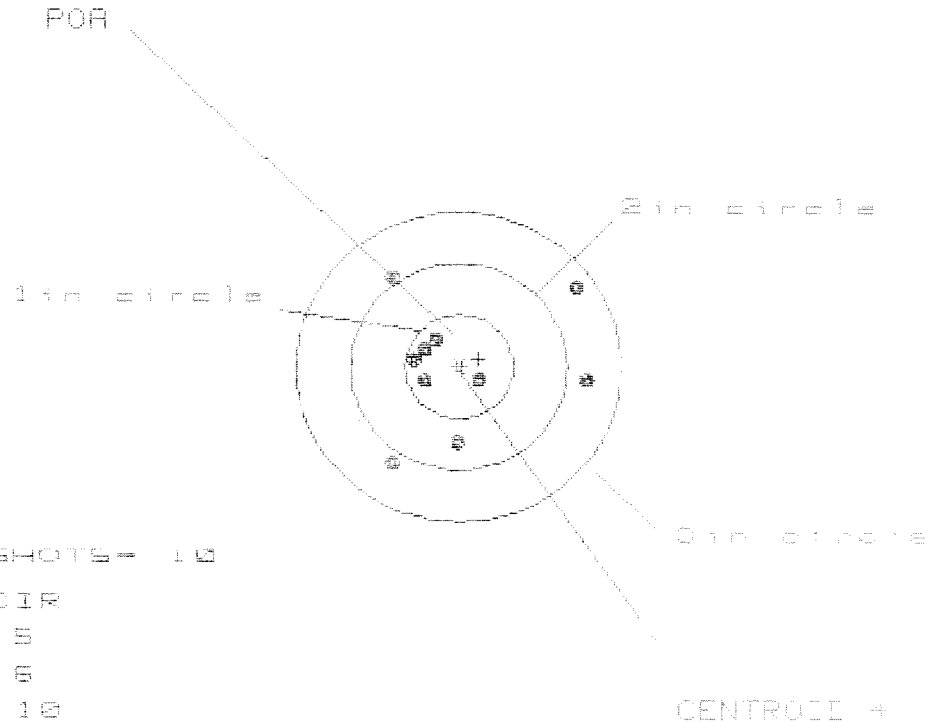
G0 = 4.557

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.146	2.085	1.141
MINIMUM X	:	-1.269	-0.880	-0.600
MAXIMUM Y	:	2.085	1.832	1.677
MINIMUM Y	:	-2.274	-1.243	-1.381
CENTROID X	:	.021	.162	-0.088
CENTROID Y	:	-.184	.069	.224
POA TO CENTROID in.	:	.185	.176	.241
MIN RADIUS	:	.401	.661	.636
MEAN RADIUS	:	1.449	1.335	1.166
MAX RADIUS	:	2.604	2.359	1.885
HORIZONTAL SPREAD	:	3.415	2.885	1.771
VERTICAL SPREAD	:	4.359	3.075	3.058
EXTREME SPREAD	:	4.557	3.844	3.112
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		6	

7 Oct 1988

FILE:/PATTERNING/CENTERFIRE_PATT/08225293

CENTERFIRE PATTERNS # 5



OF SHOTS = 10

IN CIR

1in = 5

2in = 6

3in = 10

HS = 1.758

VS = 1.809

GS = 2.364

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.142	1.258	.468
MINIMUM X	-.616	-.588	-.343
MAXIMUM Y	.873	.960	.957
MINIMUM Y	-.936	-.849	-.852
CENTROID X	-.181	-.297	-.454
CENTROID Y	-.073	-.160	-.156
POR TO CENTROID in.	.195	.337	.480
MIN RADIUS	.250	.201	.089
MEAN RADIUS	.697	.602	.492
MAX RADIUS	1.304	1.258	1.016
HORIZONTAL SPREAD	1.758	1.758	.803
VERTICAL SPREAD	1.809	1.809	1.809
EXTREME SPREAD	2.364	2.017	1.809
NUMBER IN ONE INCH CIRCLE =	5		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	10		