

C6594486

MODEL 760<sup>TM</sup> M24

Model **S&S**<sup>TM</sup>

Action

Barrel Length

Capacity

Order No. **5715**

\*Includes 1 in chamber.

*Remington*

**Remington**  
MODEL 700™ M24

**DUPONT**  
REG. U.S. PAT. & TM. OFF.

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

SERIAL NO.  
C6594486

ORDER NO.  
5716

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

UPC

0 4700 25716 7

5716 C6594486

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: **RE00089022** Serial: C6594486 Model M24 SWS Center Fire Caliber: 7.62 NATO Repairman: Status: Closed 12/6/2004 7:41:11 AM

Verify Repair

**Address Information**

Customer: ☒ Received From Return To: ☐ Received From

Name: **TRANSPORTATION OFFICER** **TRANSPORTATION OFFICER**

Address 1: **DEF DIST DEPOT ANNISTON AL** **DEF DIST DEPOT ANNISTON AL**

Address 2:  PO Box:   PO Box:

City: **ANNISTON** **ANNISTON**

State: **AL** Zip Code: **36201** Country: **US** State: **AL** Zip Code: **36201** Country: **US**

FFL: ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐

Contact / Condition Problems Estimate History / Status Shipping / Billing

Contact Information

Phone:

Fax:

Email:

Comments:

Received Condition

Good

Condition Notes:

CSR Notes:

Accessories Received

| Code | Desc             | Qty |
|------|------------------|-----|
| A006 | Sling Strap      | 1   |
| A007 | With Stud        | 3   |
| A010 | Hard Case        | 1   |
| A017 | Scope Base       | 1   |
| A026 | Scope            | 1   |
| A055 | Deployment Kit   | 1   |
| C000 | FRT AND REAR SGT | 1   |
| C001 | SCOPE CASE       | 1   |

Repair Search Refresh Close

logletj 12/6/2004 8:51 AM CAPS NUM INS SCRL

start 2 2 2 2 2 2 2 2

Serial Number:

**C6594486**Model: **M24 SWS****RE00089022**

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6594486.\_\_0  
FILE DATE AND TIME: 01/11/2005 11:24

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

|                                                             |        |
|-------------------------------------------------------------|--------|
| The Average X Centroid of the Five Target Set:              | 0.000  |
| The Average Y Centroid of the Five Target Set:              | -0.093 |
| The Average Point of Impact of the Five Target Set:         | 0.093  |
| The Average Mean Radius of the Five Target Set:             | 0.573  |
| The Distance from POA to Centroid Target #1:                | 0.114  |
| The Distance from Centroid Target #2 to Centroid Target #1: | 0.182  |
| The Distance from Centroid Target #3 to Centroid Target #1: | 0.237  |
| The Distance from Centroid Target #4 to Centroid Target #1: | 0.050  |
| The Distance from Centroid Target #5 to Centroid Target #1: | 0.166  |

SERIAL NUMBER: C6594486. \_\_0

TARGET NUMBER: 1

FILE DATE: 01/11/2005

FILE TIME: 11:24

| POINT# | X      | Y      |
|--------|--------|--------|
| 1:     | 0.781  | 0.028  |
| 2:     | 0.485  | -0.055 |
| 3:     | 0.363  | -0.263 |
| 4:     | 0.303  | 0.257  |
| 5:     | -0.112 | 0.259  |
| 6:     | -0.215 | 0.106  |
| 7:     | -0.765 | 0.043  |
| 8:     | -0.239 | -0.138 |
| 9:     | -0.561 | -0.334 |
| 10:    | -0.518 | -0.936 |

X CENTROID: -0.048

Y CENTROID: -0.103

POA TO CENTROID: 0.114

HORZ SPREAD: 1.546

VERT SPREAD: 1.195

GROUP SPREAD: 1.618

MIN RADIUS: 0.194

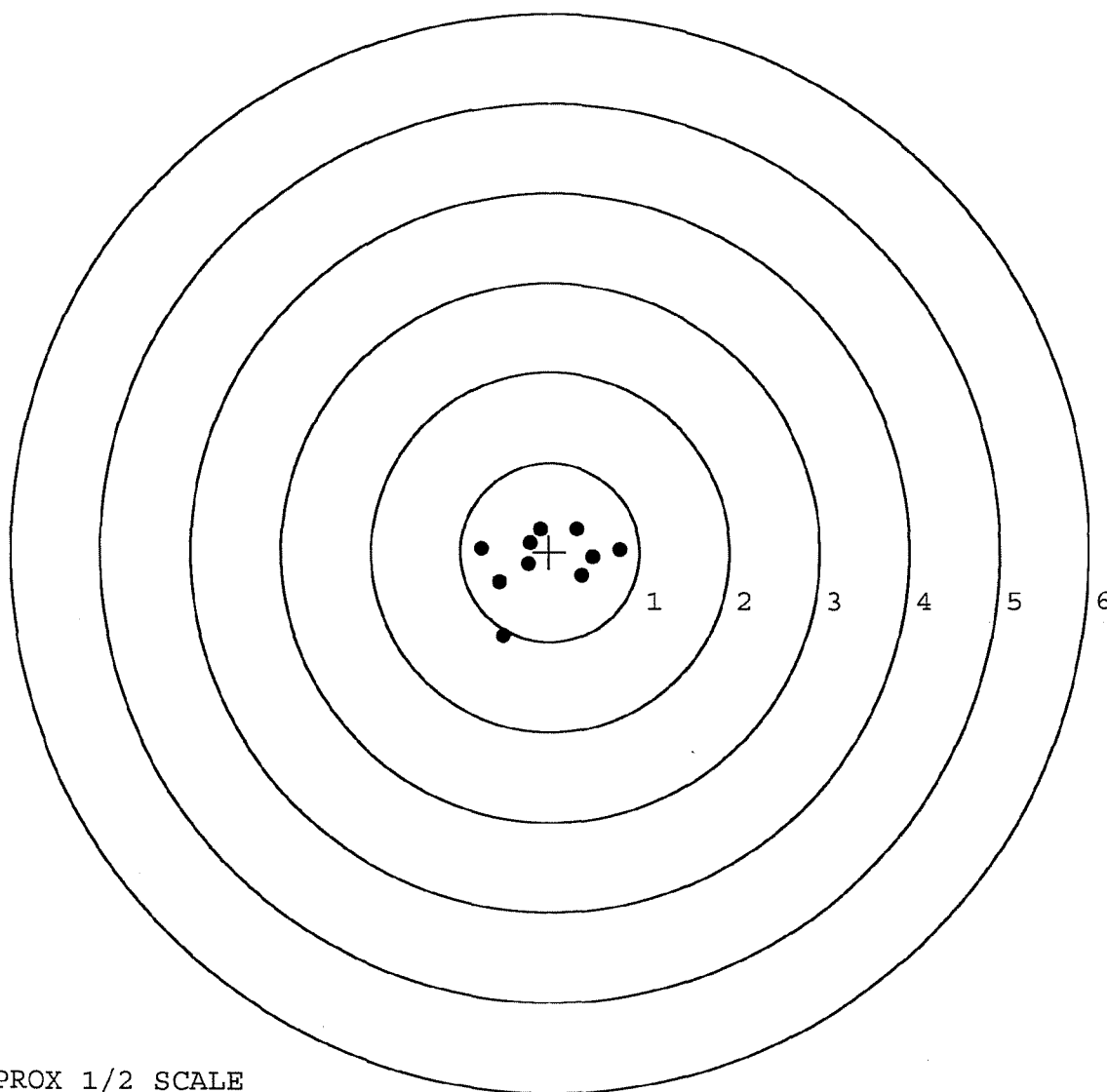
MAX RADIUS: 0.956

MEAN RADIUS: 0.540

# IN 1 IN DIAMETER: 4

# IN 2 IN DIAMETER: 10

# in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6594486. \_\_0

TARGET NUMBER: 2

FILE DATE: 01/11/2005

FILE TIME: 11:24

| POINT# | X      | Y      |
|--------|--------|--------|
| 1:     | 0.796  | 0.394  |
| 2:     | 0.642  | 0.273  |
| 3:     | 0.514  | -0.427 |
| 4:     | -0.468 | -0.574 |
| 5:     | -0.260 | -0.124 |
| 6:     | -0.480 | 0.551  |
| 7:     | -0.298 | 0.605  |
| 8:     | -0.585 | 0.122  |
| 9:     | -0.681 | -0.097 |
| 10:    | -0.420 | -0.100 |

X CENTROID: -0.124

Y CENTROID: 0.062

POA TO CENTROID: 0.139

HORZ SPREAD: 1.477

VERT SPREAD: 1.179

GROUP SPREAD: 1.592

MIN RADIUS: 0.231

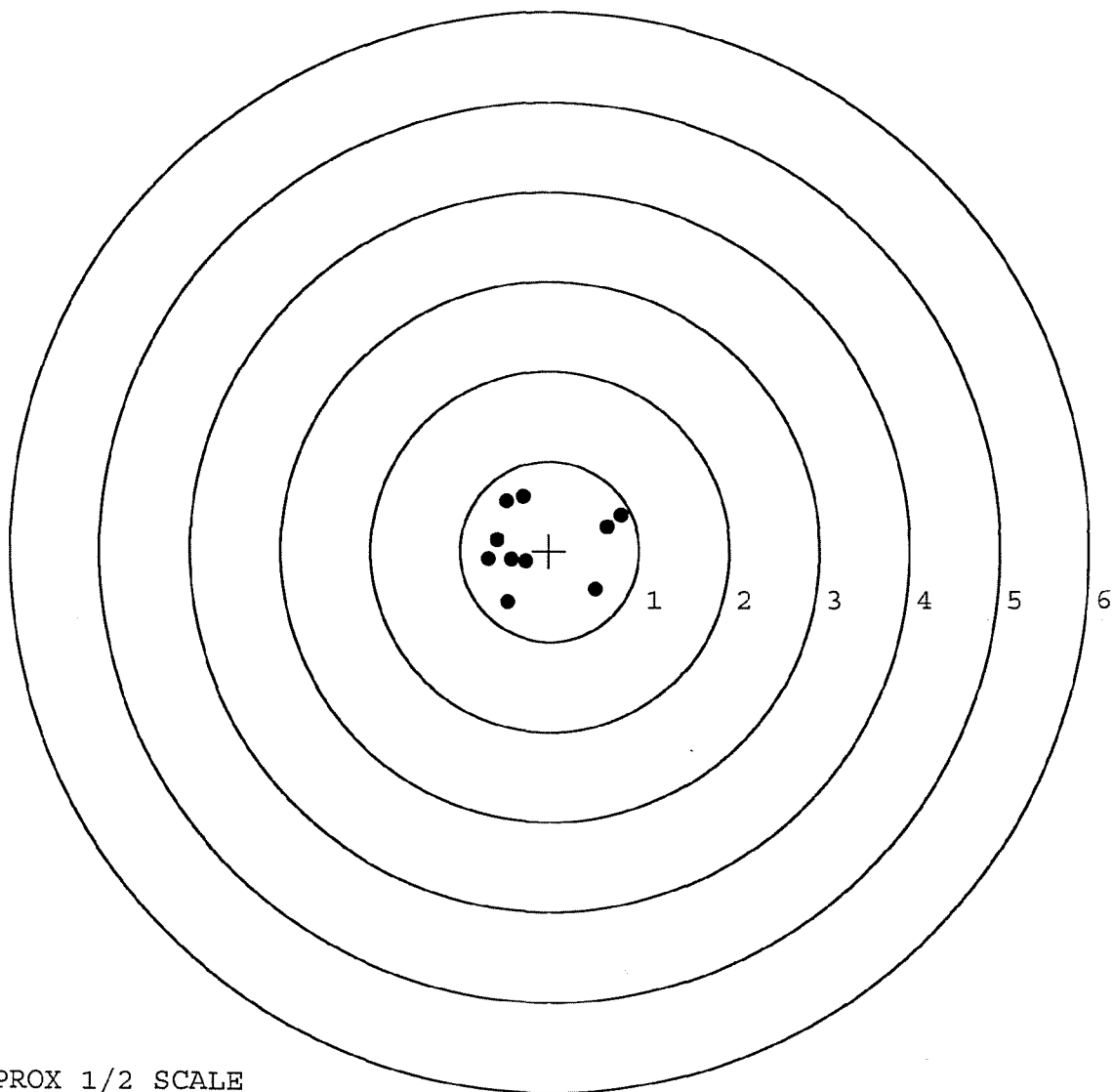
MAX RADIUS: 0.978

MEAN RADIUS: 0.609

# IN 1 IN DIAMETER: 3

# IN 2 IN DIAMETER: 10

# in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6594486. \_\_0

TARGET NUMBER: 3

FILE DATE: 01/11/2005

FILE TIME: 11:24

X CENTROID: 0.128

Y CENTROID: -0.262

POA TO CENTROID: 0.292

HORZ SPREAD: 1.198

VERT SPREAD: 1.132

GROUP SPREAD: 1.287

MIN RADIUS: 0.125

MAX RADIUS: 0.711

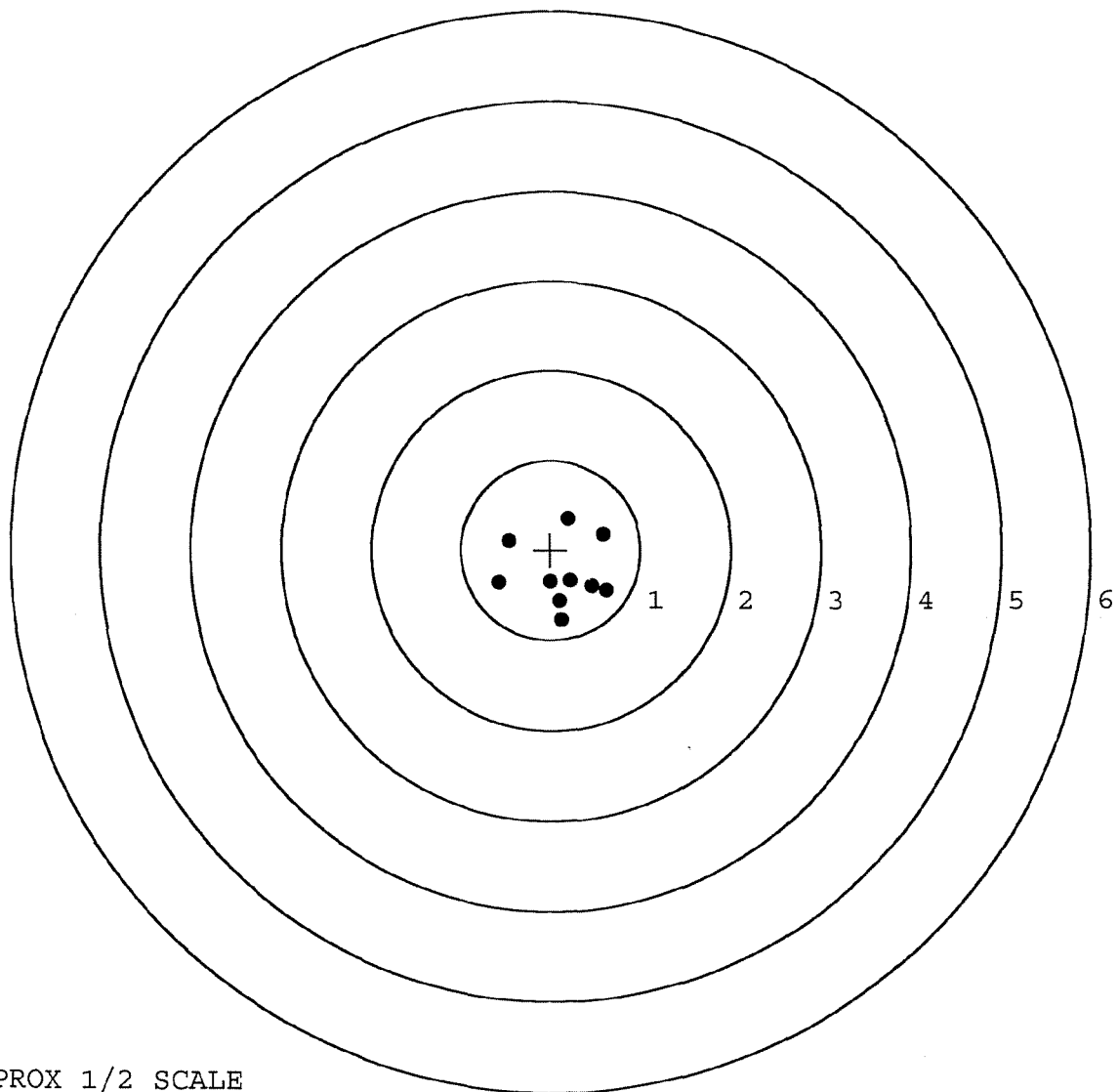
MEAN RADIUS: 0.467

# IN 1 IN DIAMETER: 4

# IN 2 IN DIAMETER: 10

# in 3 IN DIAMETER: 10

| POINT# | X      | Y      |
|--------|--------|--------|
| 1:     | 0.590  | 0.184  |
| 2:     | 0.196  | 0.347  |
| 3:     | -0.461 | 0.104  |
| 4:     | -0.576 | -0.361 |
| 5:     | 0.622  | -0.441 |
| 6:     | 0.465  | -0.398 |
| 7:     | 0.222  | -0.345 |
| 8:     | -0.004 | -0.359 |
| 9:     | 0.103  | -0.567 |
| 10:    | 0.126  | -0.785 |



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6594486. \_\_0

TARGET NUMBER: 4

FILE DATE: 01/11/2005

FILE TIME: 11:24

| POINT# | X      | Y      |
|--------|--------|--------|
| 1:     | 0.730  | 0.369  |
| 2:     | 0.180  | 0.241  |
| 3:     | 0.004  | 0.613  |
| 4:     | -0.985 | 0.062  |
| 5:     | -0.653 | -0.530 |
| 6:     | 0.324  | -0.092 |
| 7:     | -0.010 | -0.310 |
| 8:     | -0.143 | -0.478 |
| 9:     | -0.124 | -0.684 |
| 10:    | 0.223  | -0.727 |

X CENTROID: -0.045

Y CENTROID: -0.154

POA TO CENTROID: 0.160

HORZ SPREAD: 1.715

VERT SPREAD: 1.340

GROUP SPREAD: 1.742

MIN RADIUS: 0.160

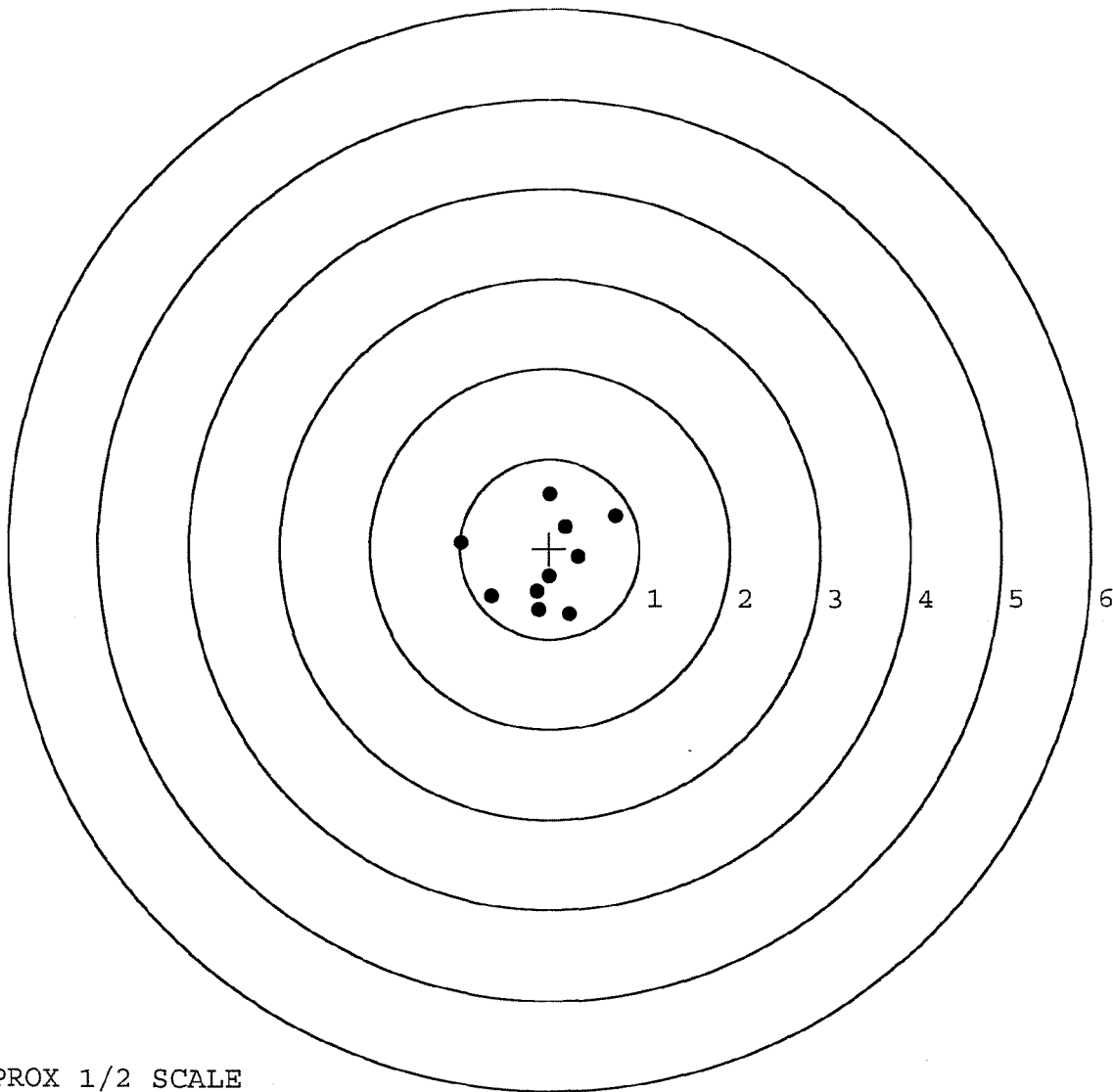
MAX RADIUS: 0.964

MEAN RADIUS: 0.588

# IN 1 IN DIAMETER: 4

# IN 2 IN DIAMETER: 10

# in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE



SERIAL NUMBER: C6594486. 0

TARGET NUMBER: 5

FILE DATE: 01/11/2005

FILE TIME: 11:24

X CENTROID: 0.089

Y CENTROID: -0.009

POA TO CENTROID: 0.089

HORZ SPREAD: 2.201

VERT SPREAD: 1.464

GROUP SPREAD: 2.431

MIN RADIUS: 0.231

MAX RADIUS: 1.408

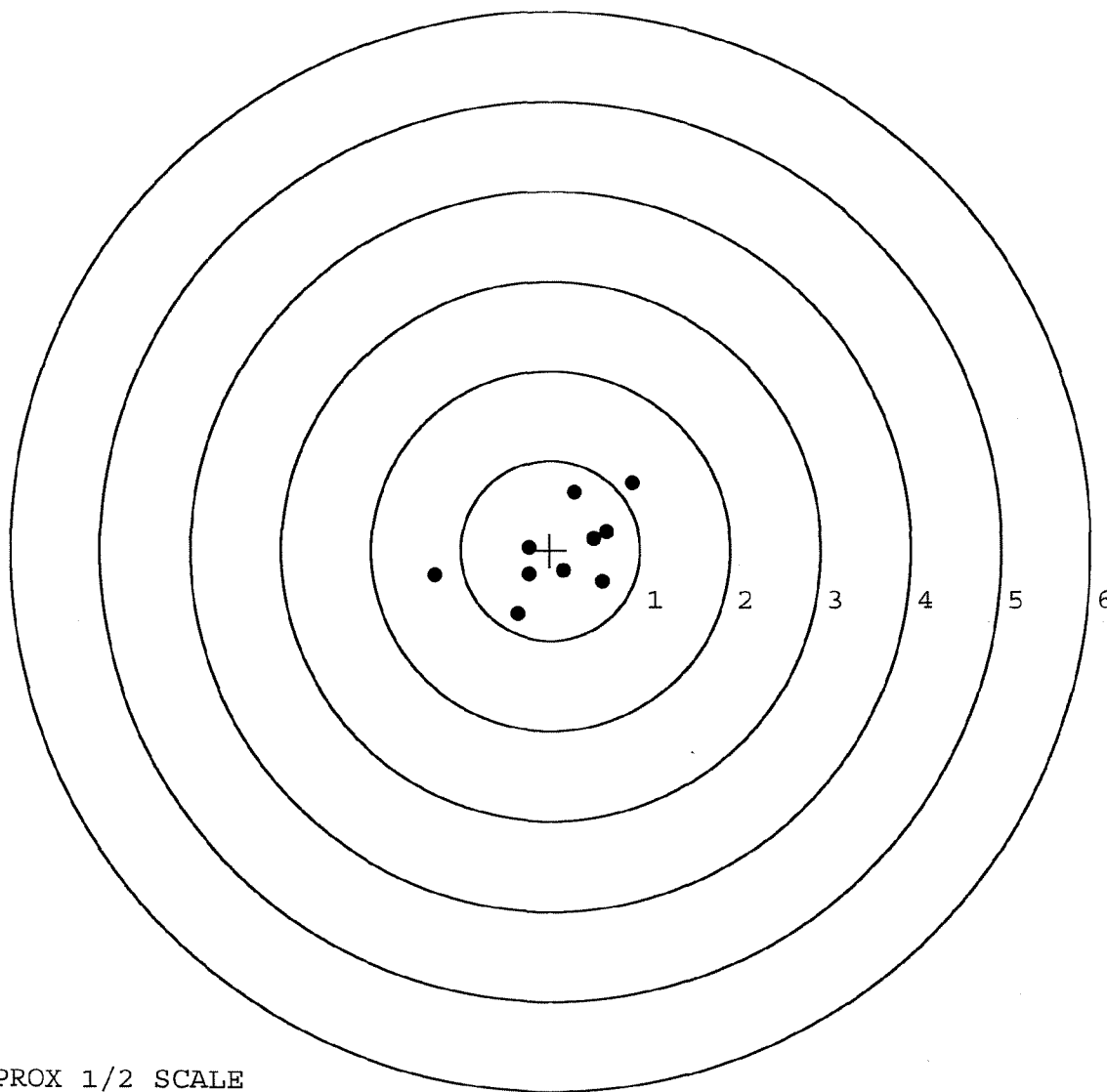
MEAN RADIUS: 0.662

# IN 1 IN DIAMETER: 4

# IN 2 IN DIAMETER: 8

# in 3 IN DIAMETER: 10

| POINT# | X      | Y      |
|--------|--------|--------|
| 1:     | 0.908  | 0.750  |
| 2:     | 0.267  | 0.644  |
| 3:     | 0.629  | 0.201  |
| 4:     | 0.581  | -0.347 |
| 5:     | 0.148  | -0.232 |
| 6:     | -0.239 | -0.271 |
| 7:     | -0.239 | 0.030  |
| 8:     | -1.293 | -0.281 |
| 9:     | -0.362 | -0.714 |
| 10:    | 0.488  | 0.128  |



TARGET APPROX 1/2 SCALE

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

|                            |                    |                     |         |
|----------------------------|--------------------|---------------------|---------|
| R & E NUMBER               | 89022              |                     |         |
| SERIAL NUMBER              | C6594486           |                     |         |
| LOG-IN DATE                | 12-6-04            |                     |         |
| <b>INSPECT AND VERIFY:</b> |                    |                     |         |
| OPERATION #                | OPERATION NAME     | DATE                | INITIAL |
| 550                        | DIS-ASSEMBLE GUN   | 12-7-04             | RTZ     |
| 560 A                      | RE-BARREL          | 12-15-04            | RTZ     |
| B                          | DRILL AND TAP      | 12-27-04            | TRW     |
| 575                        | ASSEMBLE           | 12-16-04            | RTZ     |
| 600                        | PROOF              | 12-16-04            | RTZ     |
| 605                        | CHECK HEADSPACE    | 12-16-04            | RTZ     |
| 610                        | DIS-ASSEMBLE GUN   | 12-27-04            | RTZ     |
| 612                        | MAGNAFLUX          | OPERATOR            |         |
| 615                        | ROLLMARK CALIBER   | 12-27-04            | CW      |
| 618                        | ROTO-BLAST         | 12/28/04            | DG      |
| 620                        | APPLY COATINGS     | 1/3/05              | #P      |
| 625 A                      | FINAL ASSEMBLY     | 1-7-05              | RTZ     |
| B                          | TRIGGER PULL TEST  | N/A                 |         |
| C                          | SAFETY "ON" FORCE  |                     |         |
| D                          | SAFETY "OFF" FORCE |                     |         |
| E                          | FIRING PIN INDENT  |                     |         |
| 640                        | TARGET             | 1-11-05             | TRW     |
| 655                        | FINAL INSPECT      | 1-12-05             | AC      |
| 660                        | PACK               | 3-1-05              | DA      |
|                            |                    | SHIP DATE           |         |
|                            |                    | QAR INSPECTION DATE |         |

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6594486

| OP. #        | OP. NAME                                                       | READINGS | DATE    | INIT |
|--------------|----------------------------------------------------------------|----------|---------|------|
| 575 &<br>580 | Assemble Action<br>and Stock                                   | 1240 90  |         | RW   |
| 600          | Proof                                                          | 1228 90  |         | RW   |
| 607          | Check Headspace                                                | 1228 90  |         | RW   |
| 610          | Dis-assemble Gun                                               | 1228 90  |         | RW   |
| 612          | Magnaflux Barrel<br>Action                                     |          | 1-7-91  | KR   |
|              | Magnaflux Bolt                                                 |          | 1-7-91  | KR   |
| 615          | Rollmark Caliber                                               |          | 11      | JS.  |
| 617          | Drill and Tap Sight Holes                                      | 1 10 91  |         | KB   |
| 618          | Polish Barrel                                                  | 1 10 91  |         | KB   |
| 620          | Apply Coatings<br>(Barrel Action)                              |          | 1-18-91 | TH   |
|              | Apply Coating (Bolt)                                           |          |         |      |
| 625          | Final Assembly<br>A) Clean inside of<br>Bolt Assembly          |          | 1/19/91 | RW   |
|              | B) Inspect Rear Firing<br>Pin Hole for Chamfer<br>in Bolt Head |          | 1/19/91 | RW   |
|              | C) Inspect Ejector Hole<br>for Chamfer                         |          | 1/19/91 | RW   |
|              | D) Oil Firing Pin Ass'y                                        |          | 1/19/91 | RW   |
|              | E) Adjust Trigger Pull to<br>Min Setting and Stake             |          | 1-23-91 | JS   |

| op. #        | BARBER - M24 0017936<br>OP. NAME                            | READINGS |       |       |      |      | DATE    | INIT |
|--------------|-------------------------------------------------------------|----------|-------|-------|------|------|---------|------|
| 625<br>cont. | F) Safety On Force                                          | 4 1/4    | 4 1/4 | 4 1/4 |      |      | 1/23/91 | WB   |
|              | G) Safety Off Force                                         | 2        | 2     | 2     |      |      | 1/23/91 | WB   |
|              | H) Trigger Pull Test & Retainability                        |          |       |       |      |      | 1-23-91 | JH   |
|              | I) Firing Pin Indent                                        | .020     | .020  | .020  |      |      | 1/23/91 | WB   |
|              | J) Assemble Stock                                           |          |       |       |      |      | 1/24/91 | RW   |
|              | K) Assemble Swivel Studs                                    |          |       |       |      |      | 2-4-91  | K    |
|              | L) Attach Front and Rear Sight Assemblies                   |          |       |       |      |      | 1/24/91 | RW   |
|              | M) Iron Sight Alignment                                     |          |       |       |      |      | 1/24/91 | RW   |
|              | N) Detach Front & Rear Sights & place in numbered container |          |       |       |      |      | 1/24/91 | RW   |
|              | O) Attach Scope to Rifle                                    |          |       |       |      |      | 1/24/91 | RW   |
|              | P) Detach & Attach Scope 20 Times                           |          |       |       |      |      | 1/24/91 | RW   |
| 640          | Gallery Target & Test                                       |          |       |       |      |      | 1-24-91 | DH   |
|              | A) Time                                                     |          |       |       |      |      | 1-24-91 | DH   |
|              | B) Malfunctions                                             |          |       |       |      |      | 1-24-91 | DH   |
|              | C) Pierced Primers                                          |          |       |       |      |      | 1-24-91 | DH   |
|              | D) Optical Clarity of Scope                                 |          |       |       |      |      | 1-24-91 | DH   |
| 645          | Inspect for Live Ammo                                       |          |       |       |      |      | 1-24-91 | DH   |
| 655          | Final Inspection                                            |          |       |       |      |      |         |      |
|              | A) Headspace                                                |          |       |       |      |      | 2-4-91  | K    |
|              | B) Trigger Pull                                             | 2.36     | 2.47  | 2.27  | 2.21 | 2.32 | 2-1-91  | JH   |
|              | C) Function                                                 |          |       |       |      |      | 2-4-91  | AC   |
| 660          | Pack                                                        |          |       |       |      |      | 3-19-91 | N    |

AVERAGE PULL FORCE BETWEEN  
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. 06594486

DATE 1-23-91

TESTER JL

|         | 2.50#<br>INITIAL | 2.50# AFTER<br>50 CYCLES | FINAL TEST &<br>TO RESET 2.50# |      | COMMENTS                                                               |
|---------|------------------|--------------------------|--------------------------------|------|------------------------------------------------------------------------|
| PULL #1 | 2.20             | 2.29                     | 2.15                           | 2.36 | MIN. SETTING,<br>NO AVG. OF 5<br>READINGS ACCEPT-<br>ABLE LESS THAN 2# |
| PULL #2 | 2.52             | 2.19                     | 2.19                           | 2.42 |                                                                        |
| PULL #3 | 2.36             | 2.24                     | 2.31                           | 2.27 |                                                                        |
| PULL #4 | 2.49             | 2.32                     | 2.30                           | 2.21 |                                                                        |
| PULL #5 | 2.25             | 2.20                     | 2.30                           | 2.32 |                                                                        |
| TOTAL   |                  |                          |                                |      |                                                                        |
| AVG.    |                  |                          |                                |      |                                                                        |

|         | 3.00#<br>INITIAL | 3.00# AFTER<br>20 CYCLES |  | COMMENTS |
|---------|------------------|--------------------------|--|----------|
| PULL #1 | 3.25             | 3.28                     |  |          |
| PULL #2 | 3.34             | 3.32                     |  |          |
| PULL #3 | 3.44             | 3.45                     |  |          |
| PULL #4 | 3.39             | 3.40                     |  |          |
| PULL #5 | 3.48             | 3.20                     |  |          |
| TOTAL   |                  |                          |  |          |
| AVG.    |                  |                          |  |          |

|         | 4.00#<br>INITIAL | 4.00# AFTER<br>20 CYCLES | MAX SETTING<br>GREATER THAN 4# | RESET TO 4# FOR<br>TARGET & ACCURACY |
|---------|------------------|--------------------------|--------------------------------|--------------------------------------|
| PULL #1 | 4.21             | 4.26                     |                                | 4.28                                 |
| PULL #2 | 4.26             | 4.20                     |                                | 4.26                                 |
| PULL #3 | 4.25             | 4.46                     |                                | 4.20                                 |
| PULL #4 | 4.26             | 4.39                     |                                | 4.20                                 |
| PULL #5 | 4.21             | 4.39                     |                                | 4.25                                 |
| TOTAL   |                  |                          |                                |                                      |
| AVG.    |                  |                          |                                |                                      |

CENTROIDAL DISTANCE CALCULATIONS  
FOR RIFLE # C6594486  
25 Jan 1991

CENTROIDAL DISTANCES

|      |   |         |
|------|---|---------|
| Ø TO | 1 | .143098 |
| 1 TO | 2 | .424438 |
| 1 TO | 3 | .26524  |
| 1 TO | 4 | .114978 |
| 1 TO | 5 | .171172 |

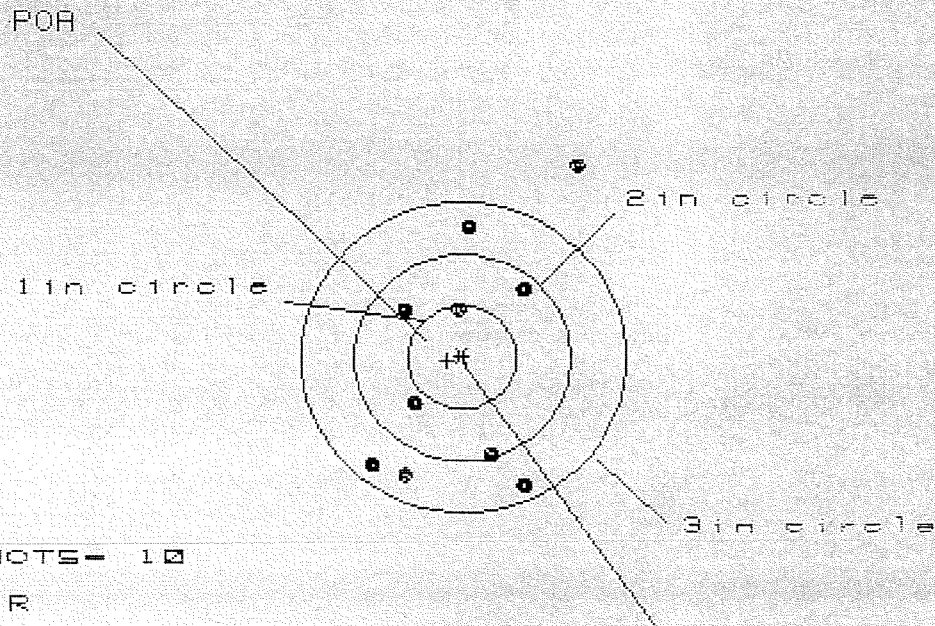
234 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0394  
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0728  
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .082778  
THE AMR FOR THIS RIFLE IS: 1.04

25 Jan 1991

FILE:/PATTERNING/CENTERFIRE\_PATT/C85944B6

## CENTERFIRE PATTERNS # 1



# OF SHOTS = 10

# IN CIR

1 in = 1

2 in = 5

3 in = 9

HS = 1.873

VS = 3.155

GS = 3.468

CENTROID \*

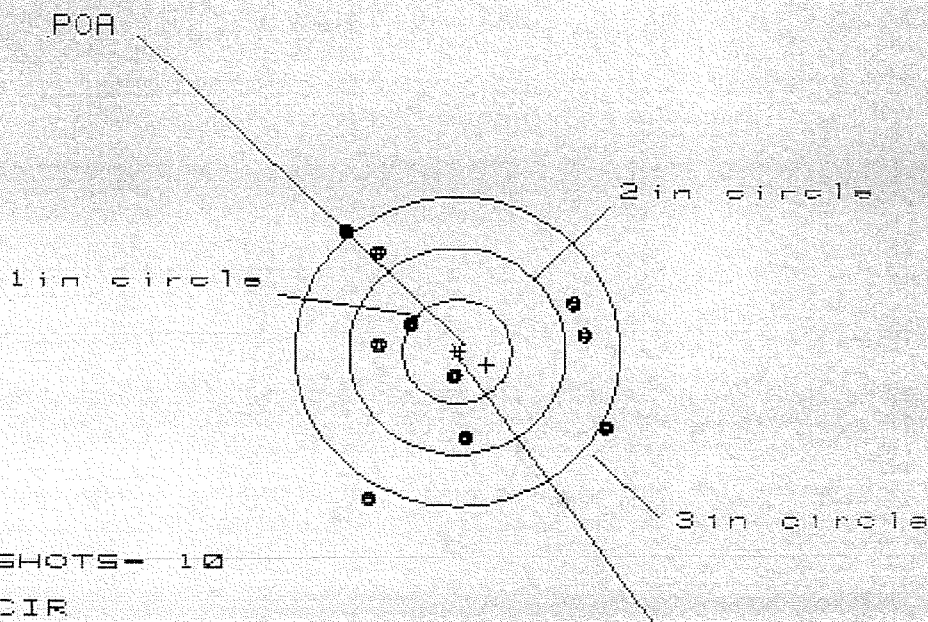
| PATTERN #                     | 1      | 2      | 3      |
|-------------------------------|--------|--------|--------|
| SHOTS (BEST OF)               | 10     | 9      | 8      |
| MAXIMUM X                     | 1.032  | .715   | .796   |
| MINIMUM X                     | -.841  | -.727  | -.646  |
| MAXIMUM Y                     | 1.898  | 1.487  | 1.357  |
| MINIMUM Y                     | -1.257 | -1.046 | -1.057 |
| CENTROID X                    | .139   | .025   | -.056  |
| CENTROID Y                    | .034   | -.177  | -.047  |
| POA TO CENTROID in.           | .143   | .179   | .073   |
| MIN RADIUS                    | .424   | .397   | .428   |
| MEAN RADIUS                   | 1.101  | .958   | .912   |
| MAX RADIUS                    | 2.161  | 1.493  | 1.373  |
| HORIZONTAL SPREAD             | 1.873  | 1.442  | 1.442  |
| VERTICAL SPREAD               | 3.155  | 2.533  | 2.414  |
| EXTREME SPREAD                | 3.468  | 2.584  | 2.482  |
| NUMBER IN ONE INCH CIRCLE =   | 1      |        |        |
| NUMBER IN TWO INCH CIRCLE =   | 5      |        |        |
| NUMBER IN THREE INCH CIRCLE = | 9      |        |        |



25 Jan 1991

FILE:/PATTERNING/CENTERFIRE\_PATT/C65944B6

## CENTERFIRE PATTERNS # 2



| PATTERN #                   | : | 2      |        |        |
|-----------------------------|---|--------|--------|--------|
| SHOTS (BEST OF)             | : | 10     | 9      | 8      |
| MAXIMUM X                   | : | 1.384  | 1.293  | 1.233  |
| MINIMUM X                   | : | -.999  | -1.090 | -.928  |
| MAXIMUM Y                   | : | 1.130  | 1.023  | .912   |
| MINIMUM Y                   | : | -1.417 | -.958  | -1.069 |
| CENTROID X                  | : | -.273  | -.182  | -.344  |
| CENTROID Y                  | : | .136   | .293   | .404   |
| POA TO CENTROID in.         | : | .304   | .345   | .530   |
| MIN RADIUS                  | : | .238   | .414   | .340   |
| MEAN RADIUS                 | : | 1.066  | 1.014  | .921   |
| MAX RADIUS                  | : | 1.635  | 1.567  | 1.302  |
| HORIZONTAL SPREAD           | : | 2.383  | 2.383  | 2.161  |
| VERTICAL SPREAD             | : | 2.597  | 1.981  | 1.981  |
| EXTREME SPREAD              | : | 3.053  | 3.053  | 2.377  |
| NUMBER IN ONE INCH CIRCLE   | = |        | 2      |        |
| NUMBER IN TWO INCH CIRCLE   | = |        | 4      |        |
| NUMBER IN THREE INCH CIRCLE | = |        | 7      |        |



25 Jan 1991

FILE:/PATTERNING/CENTERFIRE\_PATT/C6594486

## CENTERFIRE PATTERNS # 3

POA

1in circle

2in circle

3in circle

# OF SHOTS- 10

# IN CIR

1in = 2

2in = 5

3in = 8

HS= 2.058

VS= 3.033

GS= 3.464

CENTROID \*

| PATTERN #                   | : | 3      |        |       |
|-----------------------------|---|--------|--------|-------|
| SHOTS (BEST OF)             | : | 10     | 9      | 8     |
| MAXIMUM X                   | : | .782   | .854   | .704  |
| MINIMUM X                   | : | -1.276 | -1.204 | -.959 |
| MAXIMUM Y                   | : | 2.003  | .855   | .773  |
| MINIMUM Y                   | : | -1.030 | -.807  | -.889 |
| CENTROID X                  | : | -.105  | -.177  | -.027 |
| CENTROID Y                  | : | .138   | -.085  | -.003 |
| POA TO CENTROID in.         | : | .173   | .197   | .027  |
| MIN RADIUS                  | : | .405   | .473   | .318  |
| MEAN RADIUS                 | : | .944   | .809   | .696  |
| MAX RADIUS                  | : | 2.106  | 1.370  | 1.186 |
| HORIZONTAL SPREAD           | : | 2.058  | 2.058  | 1.663 |
| VERTICAL SPREAD             | : | 3.033  | 1.662  | 1.662 |
| EXTREME SPREAD              | : | 3.464  | 2.068  | 2.068 |
| NUMBER IN ONE INCH CIRCLE   | = |        | 2      |       |
| NUMBER IN TWO INCH CIRCLE   | = |        | 5      |       |
| NUMBER IN THREE INCH CIRCLE | = |        | 8      |       |

25 Jan 1991

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## CENTERFIRE PATTERNS # 4

POA

1 in circle

2 in circle

3 in circle

# OF SHOTS - 10

# IN CIR

1 in = 2

2 in = 6

3 in = 9

HS = 2.531

VS = 2.554

GS = 2.726

CENTROID #

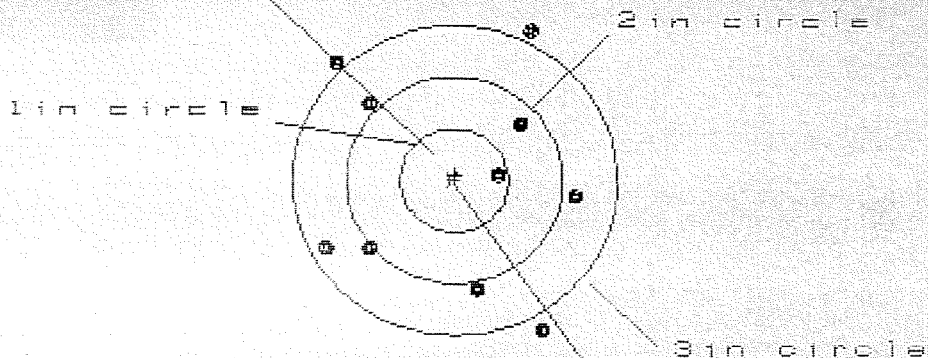
| PATTERN #                   | : | 4      |        |       |
|-----------------------------|---|--------|--------|-------|
| SHOTS (BEST OF)             | : | 10     | 9      | 8     |
| MAXIMUM X                   | : | 1.428  | 1.411  | 1.271 |
| MINIMUM X                   | : | -1.103 | -1.120 | -.520 |
| MAXIMUM Y                   | : | 1.560  | 1.072  | .969  |
| MINIMUM Y                   | : | -.994  | -.821  | -.739 |
| CENTROID X                  | : | .051   | .068   | .208  |
| CENTROID Y                  | : | .108   | -.065  | .038  |
| POA TO CENTROID in.         | : | .120   | .094   | .211  |
| MIN RADIUS                  | : | .322   | .158   | .320  |
| MEAN RADIUS                 | : | .913   | .807   | .764  |
| MAX RADIUS                  | : | 1.567  | 1.412  | 1.272 |
| HORIZONTAL SPREAD           | : | 2.531  | 2.531  | 1.791 |
| VERTICAL SPREAD             | : | 2.554  | 1.893  | 1.708 |
| EXTREME SPREAD              | : | 2.726  | 2.681  | 1.936 |
| NUMBER IN ONE INCH CIRCLE   | = |        | 2      |       |
| NUMBER IN TWO INCH CIRCLE   | = |        | 6      |       |
| NUMBER IN THREE INCH CIRCLE | = |        | 9      |       |

25 Jan 1991

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## CENTERFIRE PATTERNS # 5

POB



# OF SHOTS = 10

# IN CIR

1 in = 1

2 in = 2

3 in = 7

HS = 2.340

VS = 2.934

GS = 3.239

CENTROID #

| PATTERN #                   | : | 5      |        |        |
|-----------------------------|---|--------|--------|--------|
| SHOTS (BEST OF)             | : | 10     | 9      | 8      |
| MAXIMUM X                   | : | 1.158  | 1.249  | 1.345  |
| MINIMUM X                   | : | -1.182 | -1.091 | -.995  |
| MAXIMUM Y                   | : | 1.444  | 1.278  | 1.145  |
| MINIMUM Y                   | : | -1.490 | -1.196 | -1.036 |
| CENTROID X                  | : | -.009  | -.100  | -.196  |
| CENTROID Y                  | : | -.052  | .114   | -.046  |
| POB TO CENTROID in.         | : | .052   | .152   | .201   |
| MIN RADIUS                  | : | .387   | .492   | .573   |
| MEAN RADIUS                 | : | 1.176  | 1.115  | 1.060  |
| MAX RADIUS                  | : | 1.700  | 1.492  | 1.438  |
| HORIZONTAL SPREAD           | : | 2.340  | 2.340  | 2.340  |
| VERTICAL SPREAD             | : | 2.934  | 2.474  | 2.181  |
| EXTREME SPREAD              | : | 3.239  | 2.821  | 2.562  |
| NUMBER IN ONE INCH CIRCLE   | = |        | 1      |        |
| NUMBER IN TWO INCH CIRCLE   | = |        | 2      |        |
| NUMBER IN THREE INCH CIRCLE | = |        | 7      |        |





AVERAGE PULL FORCE BETWEEN  
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C6594486DATE 12-4-94TESTER BM

|         | 2.50#<br>INITIAL | 2.50# AFTER<br>50 CYCLES | FINAL TEST &<br>TO RESET 2.50# |  | COMMENTS                                                               |
|---------|------------------|--------------------------|--------------------------------|--|------------------------------------------------------------------------|
| PULL #1 | 2.74             | 2.62                     | 2.58                           |  | MIN. SETTING,<br>NO AVG. OF 5<br>READINGS ACCEPT-<br>ABLE LESS THAN 2# |
| PULL #2 | 2.65             | 2.67                     | 2.78                           |  |                                                                        |
| PULL #3 | 2.61             | 2.56                     | 2.57                           |  |                                                                        |
| PULL #4 | 2.62             | 2.57                     | 2.76                           |  |                                                                        |
| PULL #5 | 2.55             | 2.54                     | 2.57                           |  |                                                                        |
| TOTAL   | 13.17            | 12.96                    | 13.26                          |  |                                                                        |
| AVG.    | 2.63             | 2.54                     | 2.65                           |  |                                                                        |

|         | 3.00#<br>INITIAL | 3.00# AFTER<br>20 CYCLES |  | COMMENTS |
|---------|------------------|--------------------------|--|----------|
| PULL #1 | 3.08             | 3.10                     |  |          |
| PULL #2 | 3.28             | 3.25                     |  |          |
| PULL #3 | 3.25             | 3.07                     |  |          |
| PULL #4 | 3.14             | 3.06                     |  |          |
| PULL #5 | 3.20             | 3.15                     |  |          |
| TOTAL   | 15.95            | 15.63                    |  |          |
| AVG.    | 3.19             | 3.12                     |  |          |

|         | 4.00#<br>INITIAL | 4.00# AFTER<br>20 CYCLES | MAX SETTING<br>GREATER THAN 4# | RESET TO 4# FOR<br>TARGET & ACCURACY |
|---------|------------------|--------------------------|--------------------------------|--------------------------------------|
| PULL #1 | 4.01             | 4.07                     |                                | 4.22                                 |
| PULL #2 | 4.04             | 3.97                     |                                | 4.04                                 |
| PULL #3 | 4.05             | 3.98                     |                                | 4.00                                 |
| PULL #4 | 4.16             | 4.12                     |                                | 4.06                                 |
| PULL #5 | 3.92             | 4.01                     |                                | 4.08                                 |
| TOTAL   | 20.18            | 20.15                    |                                | 20.40                                |
| AVG.    | 4.03             | 4.03                     |                                | 4.08                                 |

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C 6594486

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

**BARBER - M24 0017947**

| op. #        | OP. NAME                                                    | READINGS |       |       |      |      | DATE  | INIT. |
|--------------|-------------------------------------------------------------|----------|-------|-------|------|------|-------|-------|
| 625<br>cont. | F) Safety On Force                                          | 4 1/2    | 4 1/2 | 4 1/2 |      |      | 12/14 | WB    |
|              | G) Safety Off Force                                         | 2 3/4    | 2 3/4 | 2 3/4 |      |      | 12/14 | WB    |
|              | 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                                            |          |       |       |      |      |       |       |
|              | A) Headspace                                                |          |       |       |      |      |       |       |
|              | B) Trigger Pull                                             | 2.49     | 2.57  | 2.64  | 2.51 | 2.46 | 12/14 | WB    |
|              | C) Function                                                 |          |       |       |      |      |       |       |
| 660          | Pack                                                        |          |       |       |      |      |       |       |