

C6348731

MODEL 700TM M24

Model **SMS** TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington.

Repair Number:	RE00151232	Serial: C6348731 Model M24 SWS Center Fire	Repairman:	
Verify Repair		Caliber: 7.62 NATO	Status:	Closed 9/16/2008 2:28:44 PM

Customer:		Received From:	Return To:		Received From:
Name:	ISD ARMSROOM		ISD 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

[illegible]

Shipping / Billing

Phone:

Fax:

Email:

Comments:

	Fair
Condition Notes:	
CSR Notes:	

Code	Desc	Qty
A007	With Stud	3
A017	Scope Base	1
A057	Frt and Rear Sgt Base	1

Close

naqletj	9/16/2008	3:27 PM	CAPS	NUM	INS	SCRL
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Serial Number:

C634873 1

Model M24 SWS



RE00151232

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

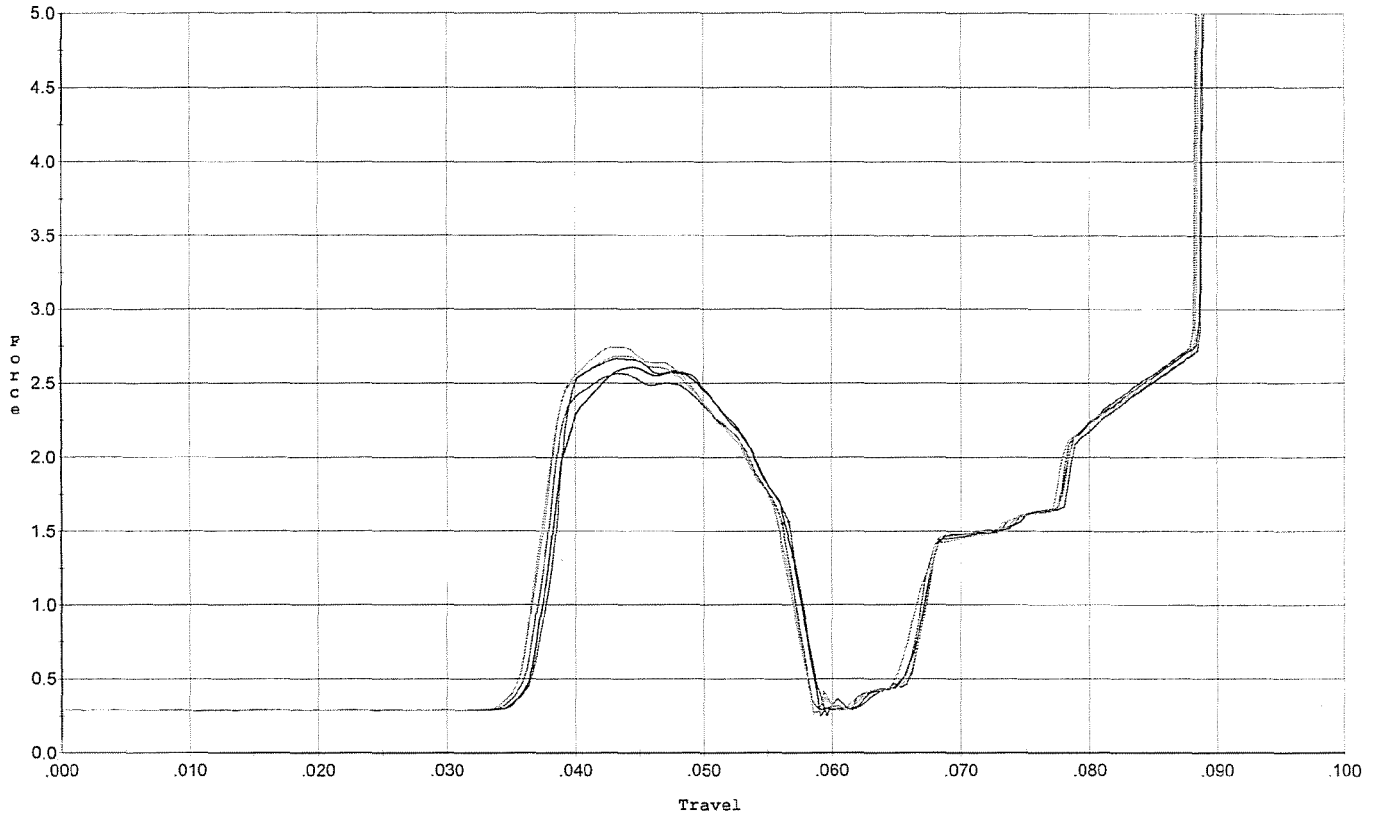
WALD NUMBER 151232
 SERIAL NUMBER C6348731
 LOG IN DATE 9-16-08

OPERATION #	OPERATION NAME	DATE	INITIAL
500	DIS-ASSEMBLE GUN	9-17-08	RTZ
505	RE-BARREL	9-22-08	LR
560	ASSEMBLE	9-22-08	RTZ
600	PROOF	9-22-08	RTZ
605	CHECK HEADSPACE	9-22-08	RTZ
610	DIS-ASSEMBLE GUN	9-22-08	RTZ
612	MAGNAFLUX	9/30/08	RTZ
510	DRILL AND TAP	9-23-08	SP
615	ROLLMARK CALIBER	9/30/08	RT
618	ROTO-BLAST		
620	APPLY COATINGS	10/1	
625	FINAL ASSEMBLY	10-7-08	RTZ
640	FUNCTION TEST AND	10-9-08	RTZ
650	TARGET	10-8-08	RTZ
	MALFUNCTION <i>Bac</i>	10-9-08	RTZ
	MALFUNCTION		
	MALFUNCTION		
	MALFUNCTION		
670	FINAL INSPECTION A) HEADSPACE	10-22-08	RTZ
	4.5 LBS MIN 2.50 LBS BI TRIGGER PULL MAX 4.0 LBS	2.43 2.47 2.45 2.38 2.47	10/16/08 Fm
	2 LBS MIN 10 LBS MAX	4.5 4.5 5.0	10-22-08 RTZ
	F) SAFETY ON FORCE	5.0 5.0 5.0	10-22-08 RTZ
	G) SAFETY OFF FORCE	5.0 5.0 5.0	10-22-08 RTZ
	I) FIRING PIN INDENT .020	.001 .020 .020	10-22-08 RTZ
690	PACK		10/24/08 Fm

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 9/2/08

Model: M/24
 Serial No: Form #F005
 Trigger: 2.5 lbs. ini. +/- .50 lbs.



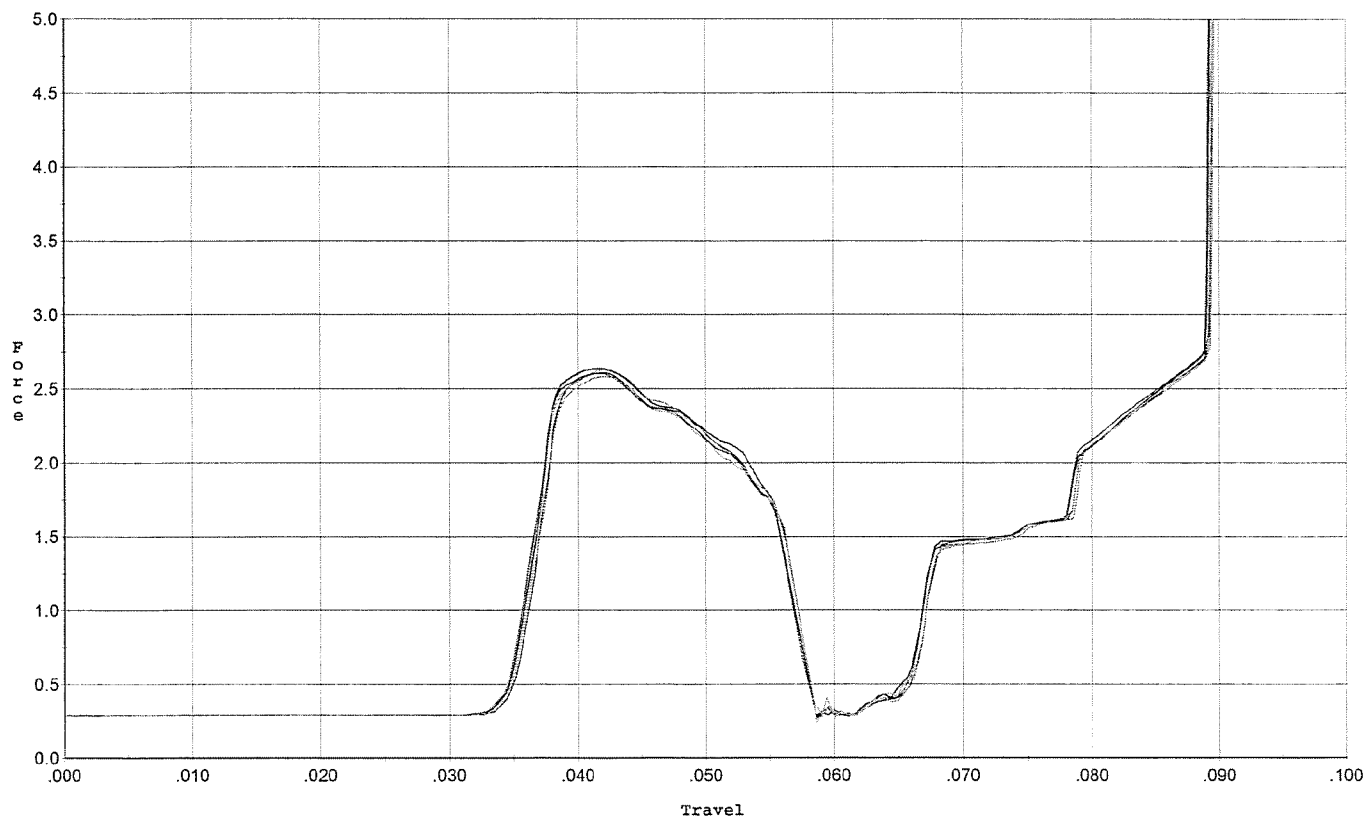
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.669	0.057	0.037	0.038	0.055		Set Trigger
2	2.609	0.057	0.036	0.038	0.055		Set Trigger
3	2.567	0.056	0.036	0.038	0.054		Set Trigger
4	2.685	0.057	0.036	0.037	0.056		Set Trigger
5	2.748	0.055	0.035	0.038	0.055		Set Trigger

Avg 2.65

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putsch 9/2/08

Model: M/24
 Serial No: Form #F005
 Trigger: 2.5 lbs. after 50 cycles +/- .50 lbs.



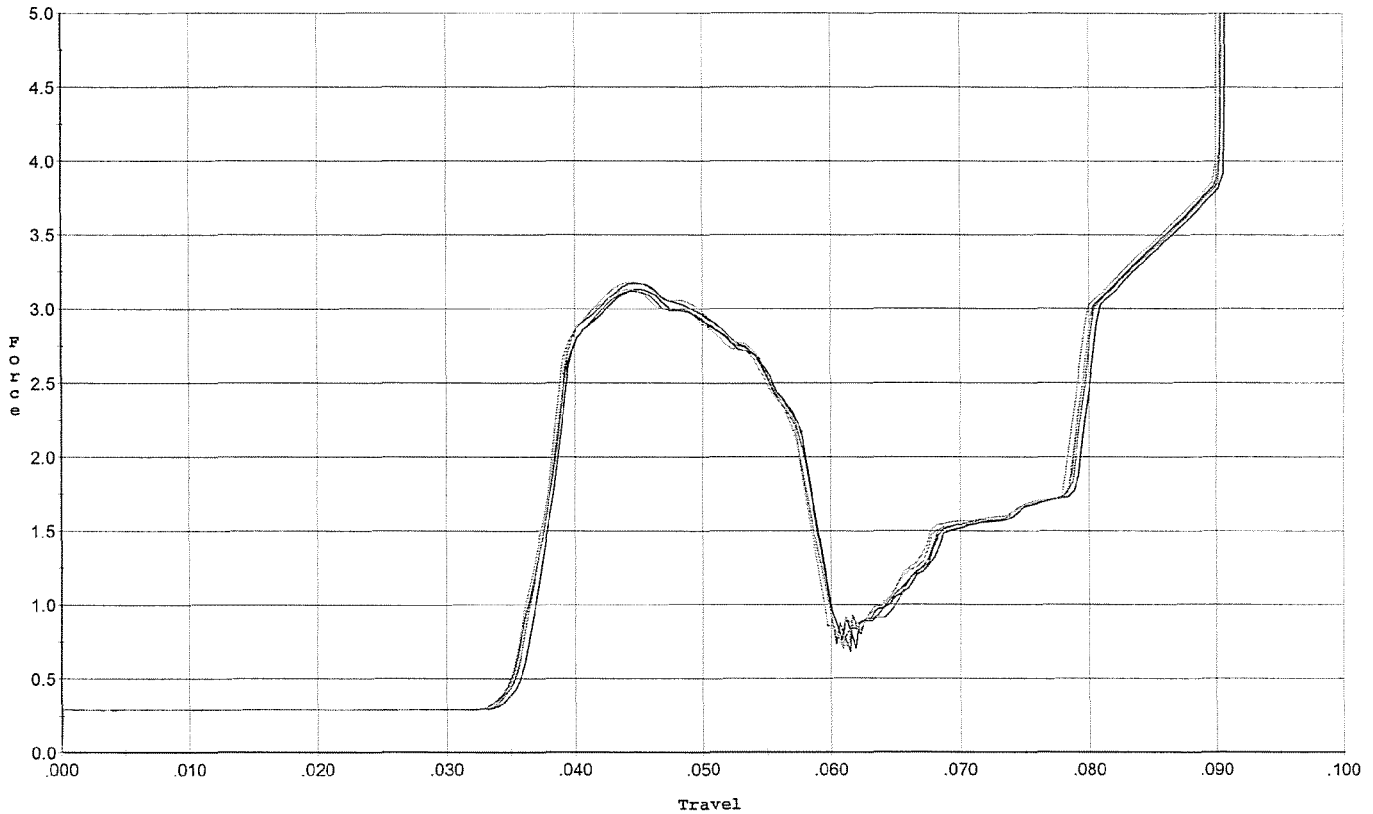
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.607	0.056	0.035	0.038	0.055		Set Trigger
2	2.635	0.055	0.035	0.038	0.055		Set Trigger
3	2.604	0.055	0.034	0.038	0.055		Set Trigger
4	2.582	0.056	0.035	0.038	0.055		Set Trigger
5	2.625	0.056	0.035	0.038	0.056		Set Trigger

Avg 2.61

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putsch 9/2/08

Model: M/24
 Serial No: Form #F005
 Trigger: 3.0 lbs. ini. +/- .75 lbs.



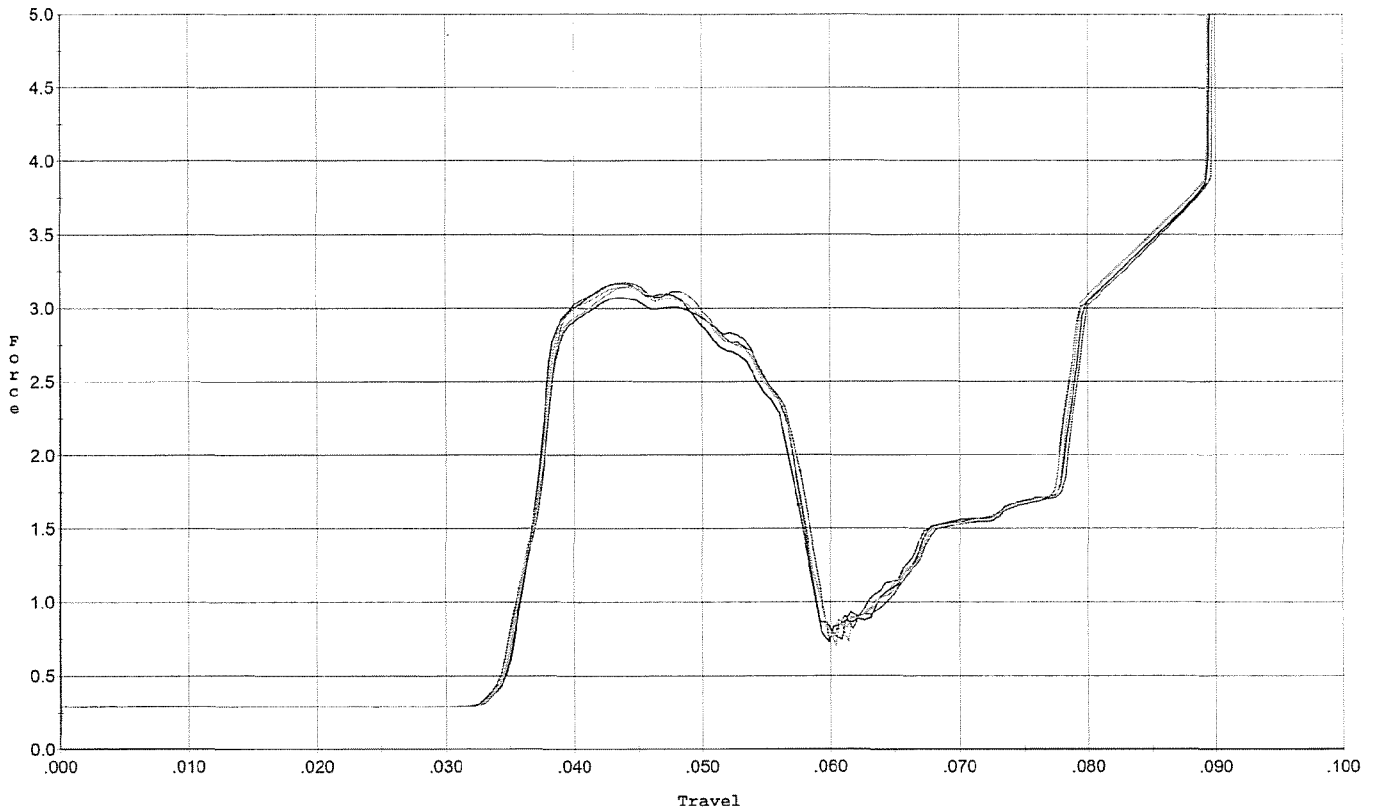
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.172	0.058	0.035	0.037	0.070		Set Trigger
2	3.131	0.058	0.036	0.037	0.068		Set Trigger
3	3.120	0.057	0.035	0.037	0.067		Set Trigger
4	3.179	0.057	0.035	0.037	0.068		Set Trigger
5	3.131	0.057	0.035	0.037	0.068		Set Trigger

Avg 3.14

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 9/2/08

Model: M/24
 Serial No: Form #F005
 Trigger: 3.0 lbs. after 20 cycles +/- .75 lbs.



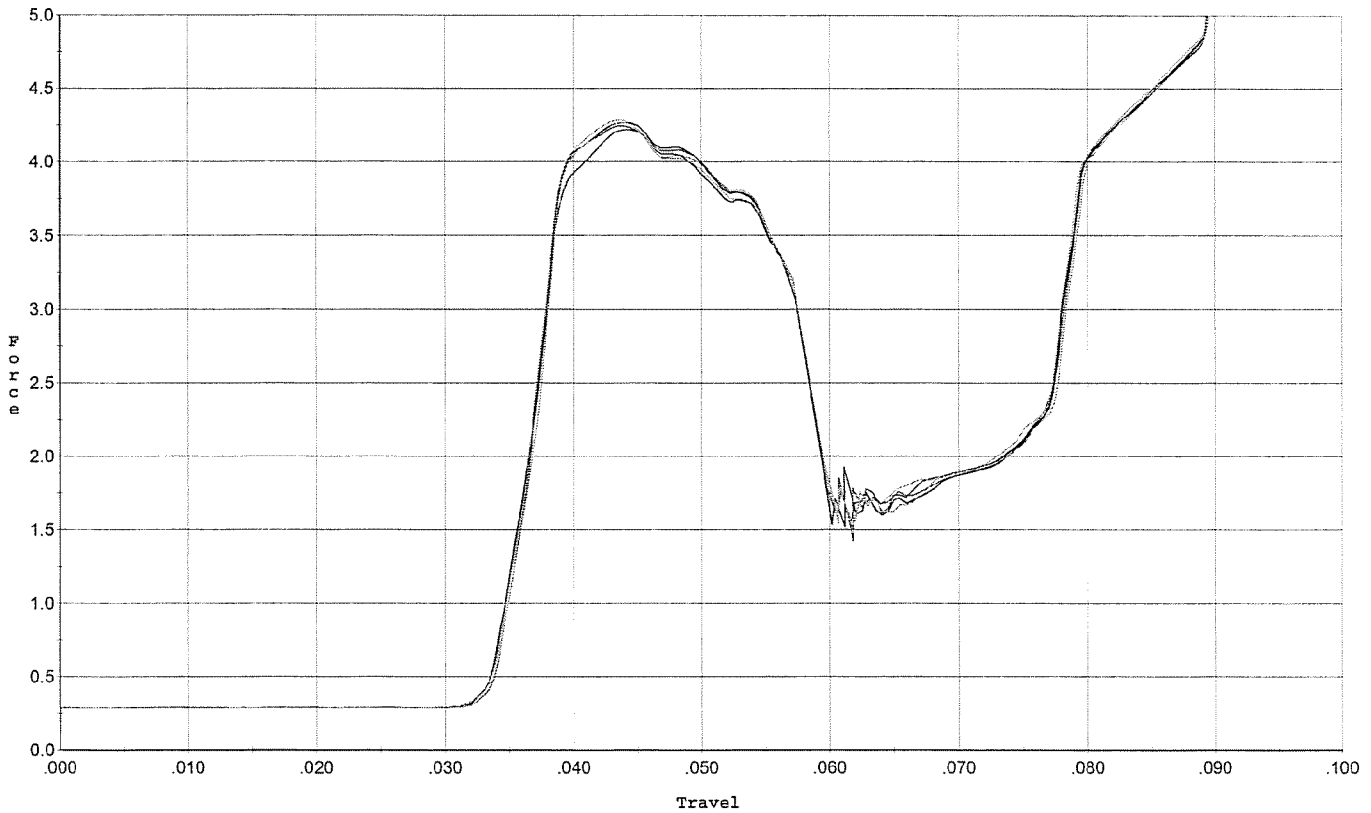
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.072	0.057	0.034	0.037	0.069		Set Trigger
2	3.163	0.057	0.035	0.037	0.069		Set Trigger
3	3.173	0.058	0.035	0.037	0.071		Set Trigger
4	3.142	0.057	0.034	0.037	0.069		Set Trigger
5	3.145	0.057	0.034	0.037	0.069		Set Trigger

Avg 3.13

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putsch 9/2/08

Model: M/24
 Serial No: Form #F005
 Trigger: 4.0 lbs. ini. +/- 1.0 lbs.



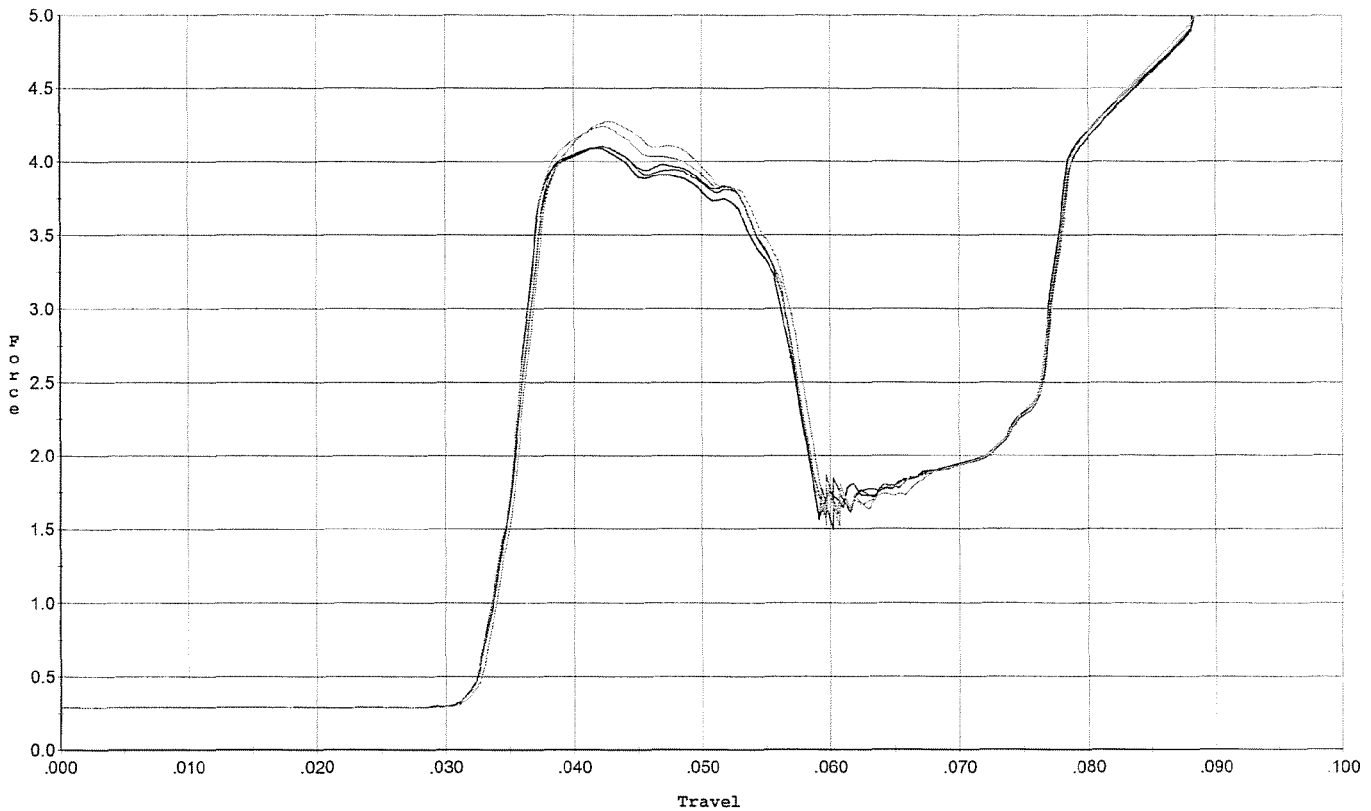
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.220	0.057	0.033	0.035	0.092		Set Trigger
2	4.269	0.057	0.034	0.035	0.094		Set Trigger
3	4.246	0.057	0.034	0.035	0.093		Set Trigger
4	4.269	0.057	0.034	0.035	0.092		Set Trigger
5	4.286	0.057	0.033	0.035	0.093		Set Trigger

Avg 4.25

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 9/2/08

Model: M/24
 Serial No: Form #F005
 Trigger: 4.0 lbs. after 20 cycles +/- 1.0 lbs.



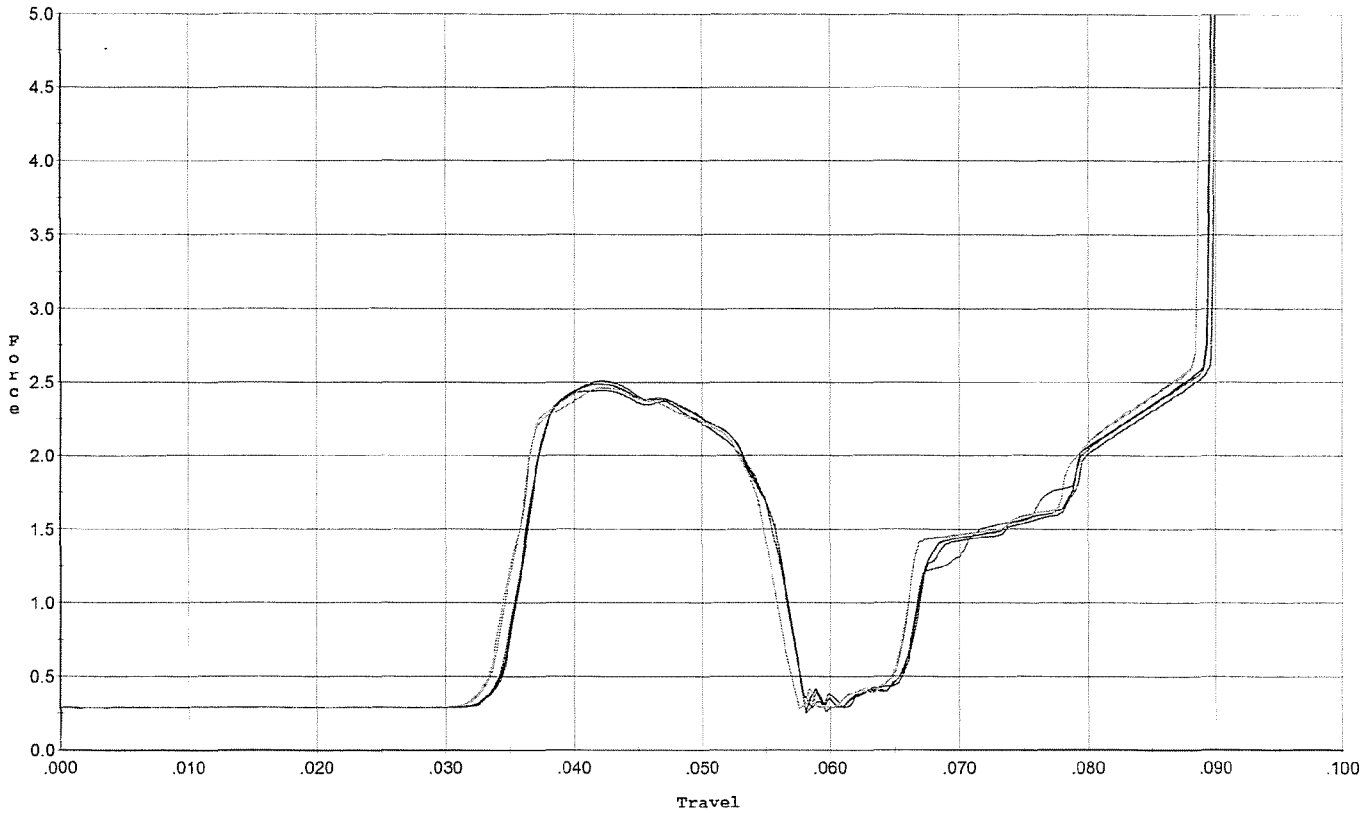
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.103	0.056	0.032	0.035	0.092		Set Trigger
2	4.091	0.057	0.032	0.034	0.093		Set Trigger
3	4.101	0.056	0.032	0.035	0.092		Set Trigger
4	4.238	0.056	0.032	0.035	0.093		Set Trigger
5	4.270	0.057	0.033	0.034	0.095		Set Trigger

Avg 4.16

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 9/2/08

Model: M/24
 Serial No: Form #F005
 Trigger: reset to 2.5 lbs. +/- .50 lbs. for final test



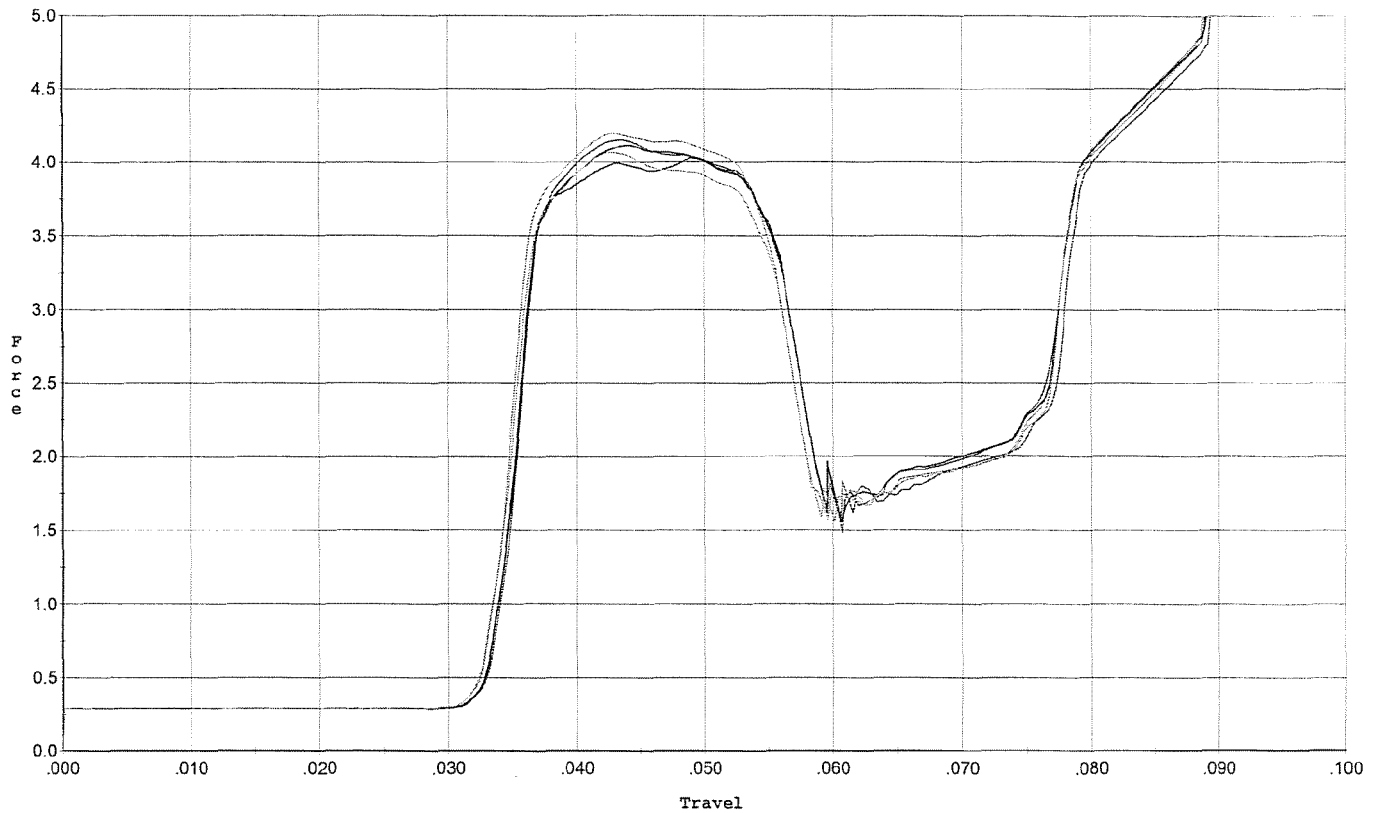
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.510	0.056	0.034	0.038	0.055		Set Trigger
2	2.489	0.056	0.034	0.038	0.056		Set Trigger
3	2.444	0.056	0.034	0.038	0.055		Set Trigger
4	2.479	0.054	0.033	0.038	0.055		Set Trigger
5	2.458	0.054	0.033	0.038	0.054		Set Trigger

Avg 2.47

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 9/2/08

Model: M/24
 Serial No: Form #F005
 Trigger: set to 4.0 lbs. +/- 1.0 lbs. for target & accuracy



#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.028	0.056	0.033	0.035	0.092		Set Trigger
2	4.113	0.056	0.033	0.035	0.093		Set Trigger
3	4.151	0.056	0.033	0.035	0.093		Set Trigger
4	4.066	0.056	0.032	0.035	0.091		Set Trigger
5	4.195	0.056	0.032	0.035	0.094		Set Trigger

Avg 4.11

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6348731.___0

FILE DATE AND TIME: 10/08/2008 15:48

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.009
The Average Y Centroid of the Five Target Set:	-0.014
The Average Point of Impact of the Five Target Set:	0.016
The Average Mean Radius of the Five Target Set:	0.819
The Distance from POA to Centroid Target #1:	0.062
The Distance from Centroid Target #2 to Centroid Target #1:	0.124
The Distance from Centroid Target #3 to Centroid Target #1:	0.095
The Distance from Centroid Target #4 to Centroid Target #1:	0.177
The Distance from Centroid Target #5 to Centroid Target #1:	0.035

BARBER - M24 0062583

SERIAL NUMBER: C6348731. __0

TARGET NUMBER: 1

FILE DATE: 10/08/2008

FILE TIME: 15:48

POINT#	X	Y
1:	0.556	0.983
2:	-1.254	0.050
3:	-0.738	-0.499
4:	-0.208	0.423
5:	-0.227	-0.322
6:	0.202	0.089
7:	0.280	-0.200
8:	0.862	-0.300
9:	0.391	-0.304
10:	0.048	-0.538

X CENTROID: -0.009

Y CENTROID: -0.062

POA TO CENTROID: 0.062

HORZ SPREAD: 2.116

VERT SPREAD: 1.521

GROUP SPREAD: 2.145

MIN RADIUS: 0.259

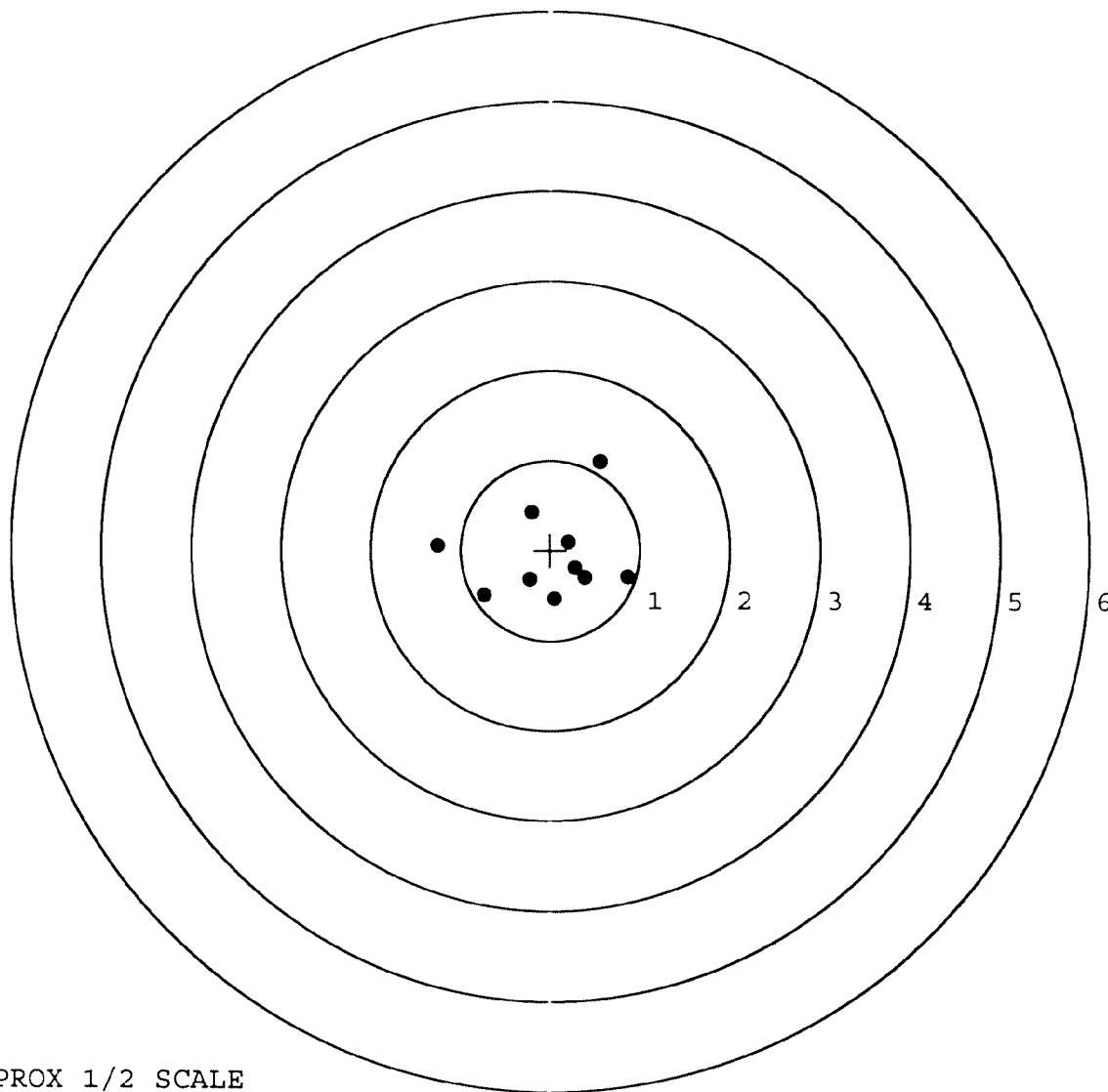
MAX RADIUS: 1.250

MEAN RADIUS: 0.658

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

BARBER - M24 0062584

SERIAL NUMBER: C6348731. __0

TARGET NUMBER: 2

FILE DATE: 10/08/2008

FILE TIME: 15:48

POINT#	X	Y
1:	-1.380	-0.672
2:	-0.857	-0.524
3:	1.086	0.610
4:	0.815	0.027
5:	0.258	0.910
6:	-0.167	0.630
7:	-0.260	0.476
8:	0.093	-0.107
9:	0.276	-0.233
10:	0.313	-0.528

X CENTROID: 0.018

Y CENTROID: 0.059

POA TO CENTROID: 0.062

HORZ SPREAD: 2.466

VERT SPREAD: 1.582

GROUP SPREAD: 2.779

MIN RADIUS: 0.182

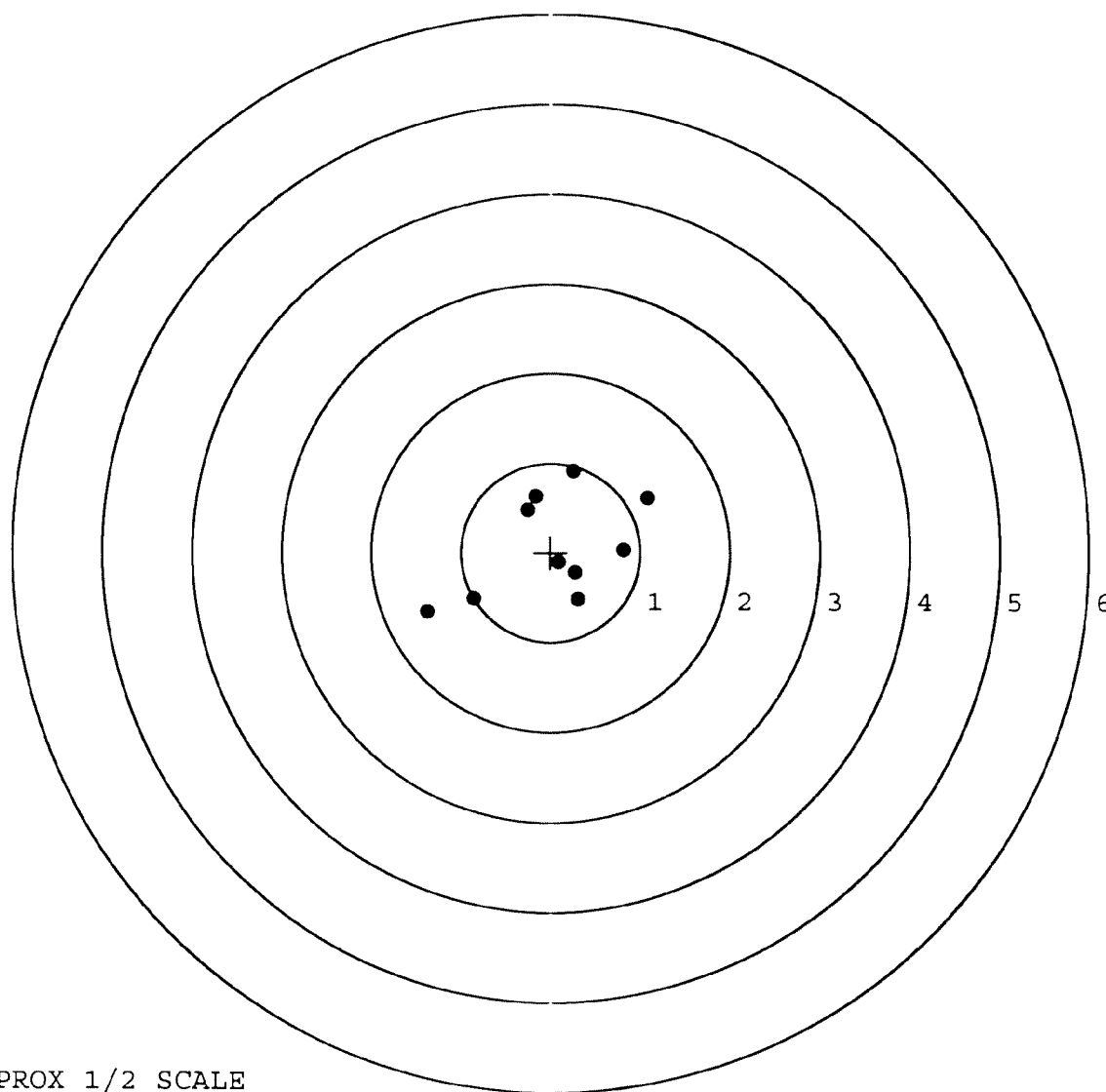
MAX RADIUS: 1.577

MEAN RADIUS: 0.784

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

BARBER - M24 0062585

SERIAL NUMBER: C6348731. __0

TARGET NUMBER: 3

FILE DATE: 10/08/2008

FILE TIME: 15:48

POINT#	X	Y
1:	-0.553	1.553
2:	0.049	0.575
3:	0.692	0.532
4:	-0.682	0.148
5:	-0.856	-0.617
6:	-0.318	-0.463
7:	-0.130	-1.055
8:	0.190	-0.927
9:	0.472	-0.685
10:	0.724	-0.572

X CENTROID: -0.041

Y CENTROID: -0.151

POA TO CENTROID: 0.157

HORZ SPREAD: 1.580

VERT SPREAD: 2.608

GROUP SPREAD: 2.642

MIN RADIUS: 0.417

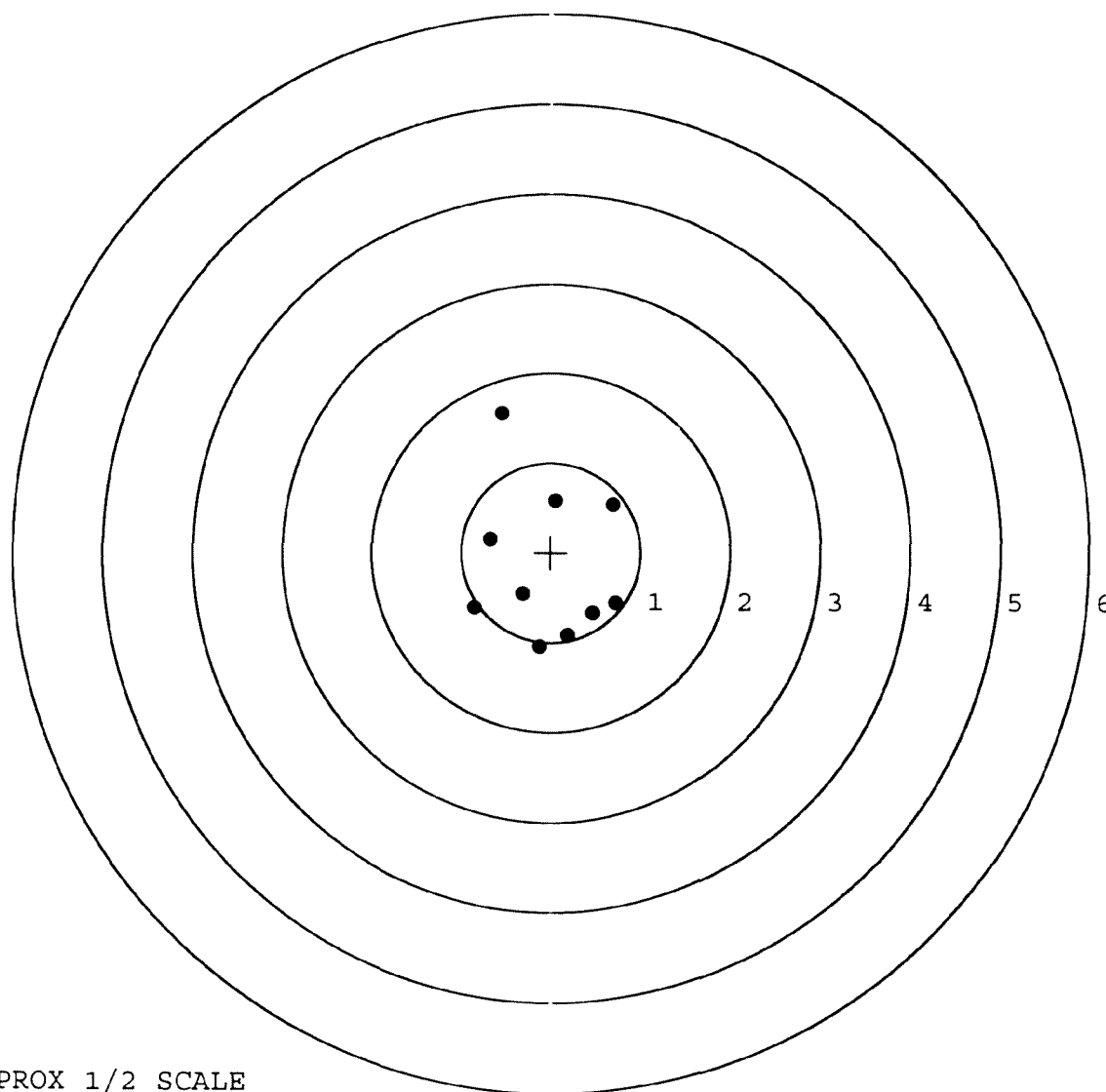
MAX RADIUS: 1.779

MEAN RADIUS: 0.891

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 9



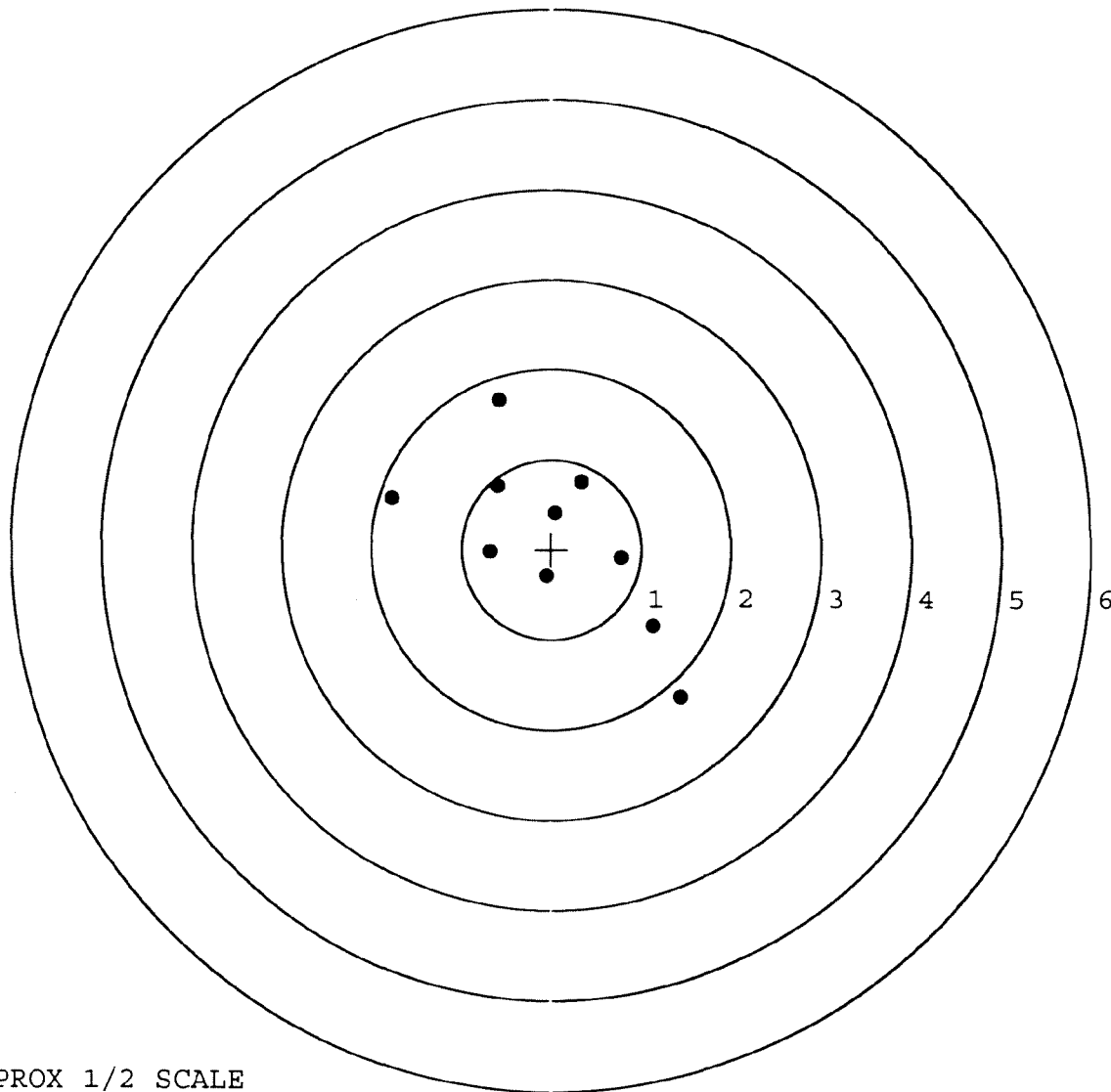
TARGET APPROX 1/2 SCALE

BARBER - M24 0062586

SERIAL NUMBER: C6348731. 0
 TARGET NUMBER: 4
 FILE DATE: 10/08/2008
 FILE TIME: 15:48

POINT#	X	Y
1:	-0.583	1.651
2:	1.442	-1.641
3:	1.134	-0.858
4:	0.778	-0.098
5:	-1.769	0.566
6:	-0.680	-0.031
7:	-0.058	-0.300
8:	-0.603	0.705
9:	0.047	0.402
10:	0.343	0.749

X CENTROID: 0.005
 Y CENTROID: 0.115
 POA TO CENTROID: 0.115
 HORZ SPREAD: 3.211
 VERT SPREAD: 3.292
 GROUP SPREAD: 3.896
 MIN RADIUS: 0.291
 MAX RADIUS: 2.269
 MEAN RADIUS: 1.101
 # IN 1 IN DIAMETER: 2
 # IN 2 IN DIAMETER: 6
 # in 3 IN DIAMETER: 7



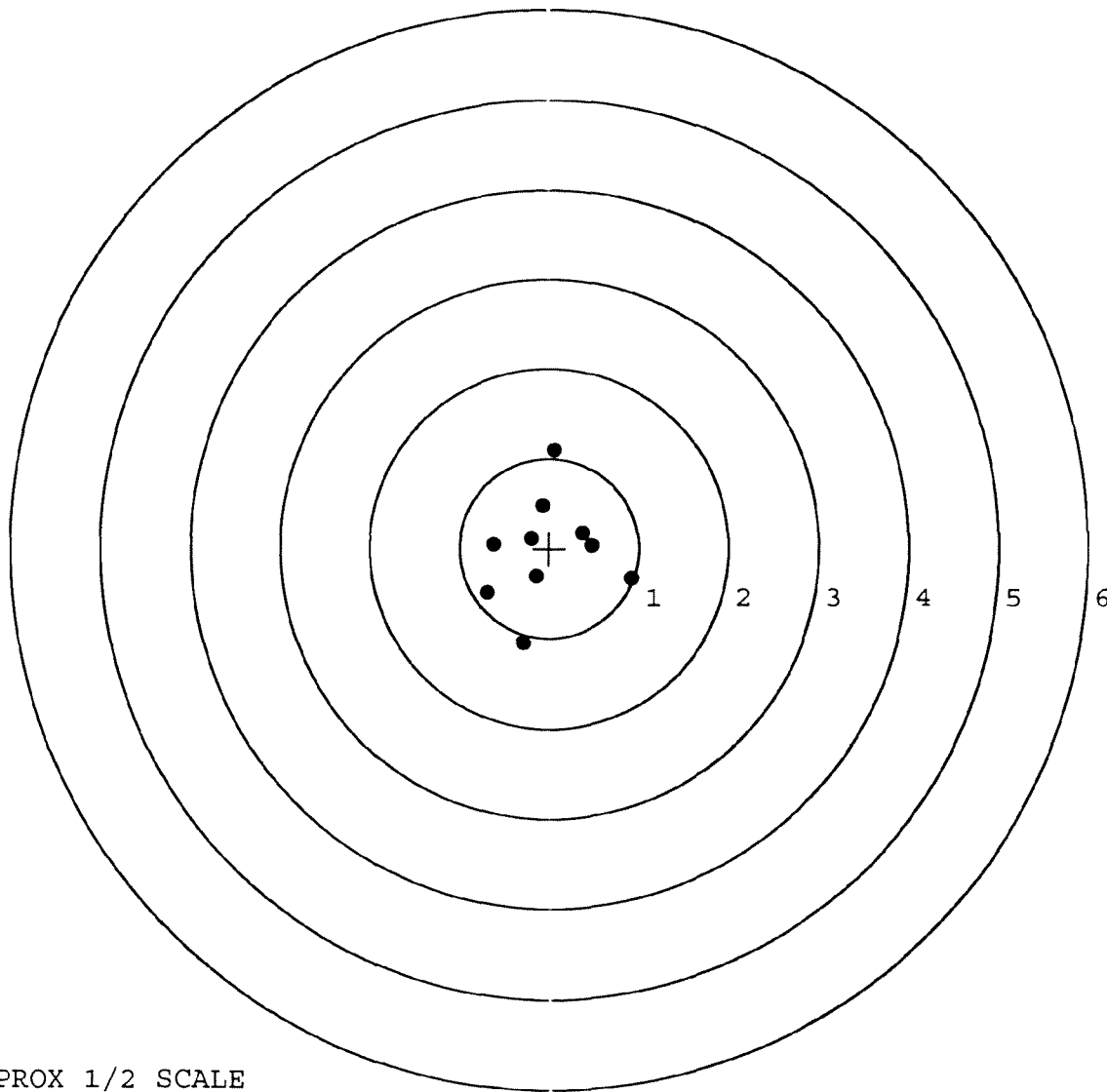
TARGET APPROX 1/2 SCALE

BARBER - M24 0062587

SERIAL NUMBER: C6348731. __0
TARGET NUMBER: 5
FILE DATE: 10/08/2008
FILE TIME: 15:48

POINT#	X	Y
1:	0.065	1.100
2:	-0.296	-1.058
3:	-0.690	-0.502
4:	-0.622	0.044
5:	0.918	-0.344
6:	-0.147	-0.315
7:	-0.202	0.113
8:	-0.069	0.475
9:	0.375	0.169
10:	0.478	0.034

X CENTROID: -0.019
Y CENTROID: -0.028
POA TO CENTROID: 0.034
HORZ SPREAD: 1.608
VERT SPREAD: 2.158
GROUP SPREAD: 2.188
MIN RADIUS: 0.231
MAX RADIUS: 1.132
MEAN RADIUS: 0.661
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

BARBER - M24 0062588
RECEIVING AND ESTIMATING REPORT

COMMENTS

ORDER
R 99-09171

INITIAL CUSTOMER ORDER NO.

SWS

393

DATE RECEIVED

DATE OPENED

DATE CODE

SERIAL NUMBER

NEW SERIAL NUMBER

MODEL AND GRADE

04/07/99

04/08/99

RJ 11-89

C6348731

700 7.62

M24

ACCESSORIES

W/STUDS

SCOPE BASE

FROM:

SHIP TO:

**US ARMY
 ATTN: JAMES C STARNES JR
 GSC 5TH SFG (A)
 FORT CAMPBELL**

KY 42223

**US ARMY
 ATTN: JAMES C STARNES JR
 GSC 5TH SFG (A)
 FORT CAMPBELL**

KY

42223

CUST NO: 208414 C.O.D.L

ACCOUNT NUMBER

ACCOUNT NUMBER N/C

WRITE ☐

PROM. DATE

ESTIMATED

VIA

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

BOLT ASSY.

B3

BARREL ASSY.

B4

D1

REC. ASSY.

B5

D2

WOOD

C1

D3

METAL

C2

E5

MAIN FAULT

PARTS

COMMENTS

*Barrel 96003
 Extractor 91816*

REPAIRMAN

PROOF

CLEAN

TEST

TARGET

PATTERN

GALLERY TESTER

DATE

DATE

DATE

DATE

DATE

OFFICE COPY

RD6925 REV. 7/97

**CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
 KINZER V. REMINGTON**

BARBER - M24 0062588 62627

Receipt Of Firearm(s) Delivered to the Plant for Repair
Firearm Checked For Live Ammunition []

File # 00393

Delivery Date 4/7/99Customer Name (Print) US Army James C Starns Jr.
Address GSC 5th SFG (A) Ft Campbell State KY Zip 42223
Phone Number (502)-798-2882/7932Firearm Description Model 700 (m24) Cal./ Ga. 7.62
Serial Number C6348731Stock/ Fore-end Condition circle the description
(Excellent; Good; Fair; Poor; Fancy; Plain, Synthetic, Wood)

Comments on Stock/ Fore-end condition _____

Metal Condition circle the description

(Excellent; Good; Fair; Poor; Fancy; Plain Stainless Steel)

Comments on Metal condition _____

Barrel Type (VT. Rib; Plain; Deer; Stainless Steel) Barrel length _____List additional accessories IE Scope, Sling, Gun case and description;
_____Customer request: ReconditioningReturn Process Return to Clark St. Ent. [] Return via UPS ☒

By signing this receipt the person delivering the firearm understands to be the only person to receive the firearm upon completion of repairs.

Signature James C Starns Jr. Date 4/7/99
person delivering firearmSignature [Signature] Date 4/7/99
security officerSignature [Signature] Date 4/7/99
arms service / CSR

Customer Pick Up Verification

I certify, I am the same person whom delivered the above described firearm to the Remington Ilion plant for repair and may lawfully possess a firearm in New York State

Signature _____ Date ____/____/____
person receiving firearm must be the same whom deliveredSignature _____ Date ____/____/____
security officer or other witness returning the firearm

BARBER - M24 0062590

Remington Test Lab, Ilion, N.Y.

Centroidal distance calculations for Rifle # c6348731
21 Jun 1999

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: $-.0054$
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: $-.0796$
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: $.079783$

THE AMR FOR THIS RIFLE IS: 1.242

CENTROIDAL DISTANCES

0 TO 1	.376175
1 TO 2	1.36746
1 TO 3	.469564
1 TO 4	.635012
1 TO 5	.0907965

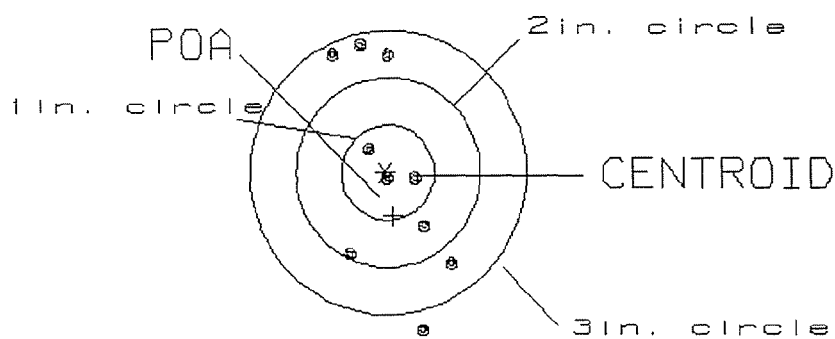
5
3+ 4 <----POA
2

PATTERN #: ☐ 1 ☐
 POA TO CENTROID: .466
 MIN RADIUS : .022
 MEAN RADIUS : .919
 MAX RADIUS : 1.691
 CENTROID X : -.090
 CENTROID Y : .458

21 Jun 1999

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6348731

CENTERFIRE PATTERN # 1



OF SHOTS= 10

IN CIRCLE

HS= 1.28

3

VS= 2.99

5

GS= 3.07

9

REMINGTON CENTERFIRE ACCURACY TEST

REMINGTON TEST LAB, ILION, N.Y.

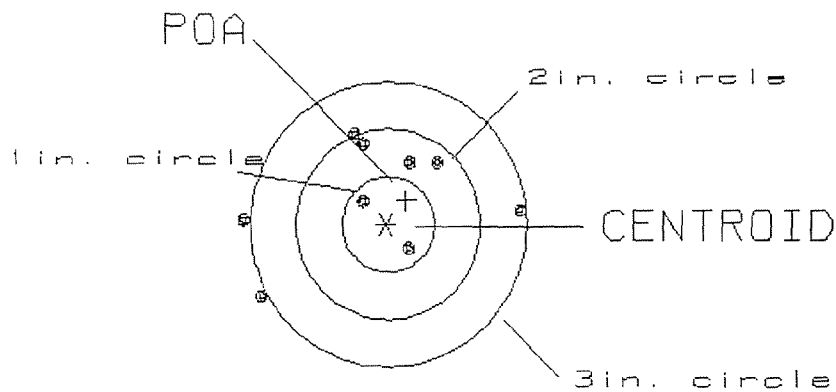
PATTERN #: 2

POA TO CENTROID: .336
 MIN RADIUS : .295
 MEAN RADIUS : 1.151
 MAX RADIUS : 2.984
 CENTROID X : -.224
 CENTROID Y : -.250

21 Jun 1999

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6348731

CENTERFIRE PATTERN # 2



OF SHOTS= 10

IN CIRCLE

HS= 3.07
 VS= 3.49
 GS= 4.04

2
 6
 7

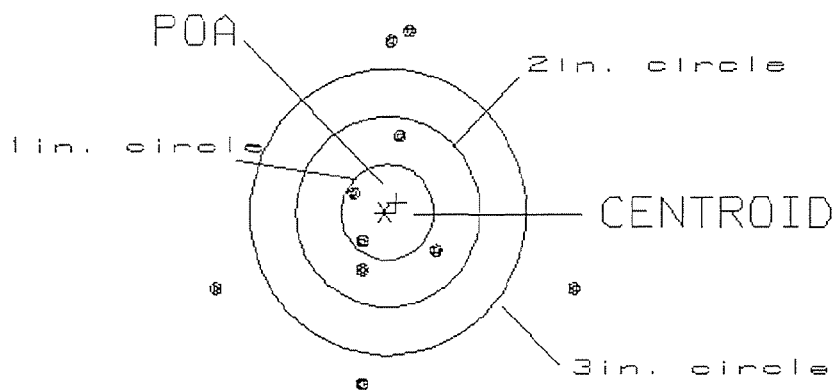
PATTERN #: 3

POA TO CENTROID: .161
 MIN RADIUS : .409
 MEAN RADIUS : 1.271
 MAX RADIUS : 2.191
 CENTROID X : -.127
 CENTROID Y : -.099

21 Jun 1999

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6348731

CENTERFIRE PATTERN # 3



OF SHOTS= 10

IN CIRCLE

HS= 3.90

2

VS= 3.71

5

GS= 3.90

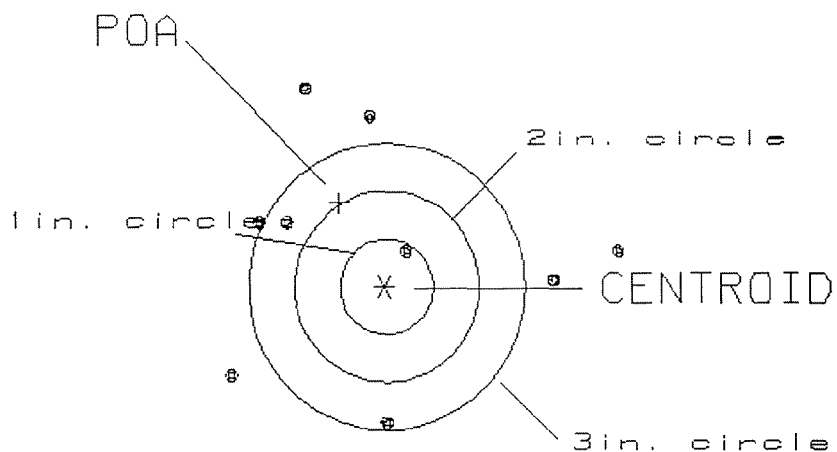
5

PATTERN #: 4
 POA TO CENTROID: 1.004
 MIN RADIUS : .452
 MEAN RADIUS : 1.869
 MAX RADIUS : 3.752
 CENTROID X : .492
 CENTROID Y : -.875

21 Jun 1999

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6348731

CENTERFIRE PATTERN # 4



OF SHOTS= 10

IN CIRCLE

HS= 4.14

1

VS= 5.74

1

GS= 5.97

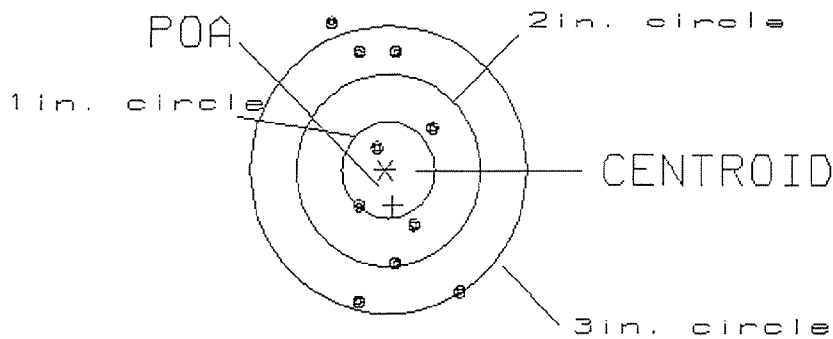
3

PATTERN #: 5
 POA TO CENTROID: .377
 MIN RADIUS : .288
 MEAN RADIUS : .998
 MAX RADIUS : 1.652
 CENTROID X : -.078
 CENTROID Y : .368

21 Jun 1999

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6348731

CENTERFIRE PATTERN # 5



OF SHOTS= 10

IN CIRCLE

HS= 1.41
 VS= 2.67
 GS= 3.13

2
 4
 9

Remington[®]

MODEL 700TM M24

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

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

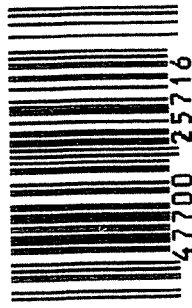
DUPONT
REG. U.S. PAT. & T.M. OFF.

SERIAL NO. C6348731	ORDER NO. 5716
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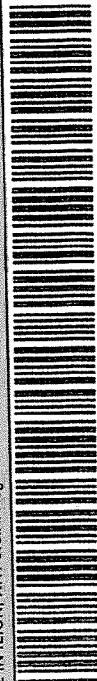
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5716 C6348731

UPC



0 47700 25716 7



5716 C6348731

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6348731

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	10-9	89	RW
600	Proof	10-9	89	A
607	Check Headspace	10-9	89	RW
610	Dis-assemble Gun	10-9	89	RW
612	Magnaflux Barrel Action	REJECTED	11/3/89	KCR
	Magnaflux Bolt		11/2/89	KCR
615	Rollmark Caliber			
.7	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			
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head			
	C) Inspect Ejector Hole for Chamfer			
	D) Oil Firing Pin Ass'y			
	E) Adjust Trigger Pull to Min Setting and Stake			

op. #	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 A) Headspace			
	B) Trigger Pull			
	C) Function			
660	Pack			

EIAQ

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6348731

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		11-2 89	RW
600	Proof		11-2 89	AT
607	Check Headspace		11-2 89	RW
610	Dis-assemble Gun		11-2 89	RW
612	Magnaflux Barrel Action		11-9-89	KCR
	Magnaflux Bolt		11-9-89	KCR
615	Rollmark Caliber		11/9/89	CS
617	Drill and Tap Sight Holes		11 9 89	7B
618	Polish Barrel RB		11 9 89	BT
620	Apply Coatings (Barrel Action)		11-11-89	TJA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		1/8/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		1/8/90	RW
	C) Inspect Ejector Hole for Chamfer		1/8/90	RW
	D) Oil Firing Pin Ass'y		1/8/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		10/14/90	QSS

BARBER - M24 0062600

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			1-10-90	JS
	G) Safety Off Force	3	3	3			1-10-90	JS
	H) Trigger Pull Test & Retainability						10/10/90	JS
	I) Firing Pin Indent	.020	.020	.020			1-10-90	JS
	J) Assemble Stock						1/10/90	RW
	K) Assemble Swivel Studs						3/15/90	WB
	L) Attach Front and Rear Sight Assemblies						1/26/90	RW
	M) Iron Sight Alignment						1/26/90	RW
	N) Detach Front & Rear Sights & place in numbered container						1/26/90	RW
	O) Attach Scope to Rifle						3/2/90	RW
	P) Detach & Attach Scope 20 Times						3/2/90	RW
640	Gallery Target & Test						3-5-90	J.S. Temp. Help
	A) Time							
	B) Malfunctions							
	C) Pierced Primers							
	D) Optical Clarity of Scope							
645	Inspect for Live Ammo							
655	Final Inspection							
	A) Headspace						16/10/90	JS
	B) Trigger Pull	2.15	2.43	2.66	2.68	2.73	16/10/90	JS
	C) Function						16/10/90	JS
660	Pack						19/10/90	JS

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6348731DATE 18 Jan 90TESTER 928

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	257	231	239	215	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	245	241	222	243	
PULL #3	233	235	237	266	
PULL #4	229	213	223	268	
PULL #5	230	212	247	273	
TOTAL	1194	1132	1168	1265	
AVG.	2388	2264	2336	253	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	353	346		
PULL #2	344	352		
PULL #3	353	347		
PULL #4	314	348		
PULL #5	343	350		
TOTAL	1707	1743		
AVG.	3414	3486		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.00	3.97		3.87
PULL #2	4.04	3.98		3.99
PULL #3	4.04	4.03		3.98
PULL #4	4.03	3.89		3.95
PULL #5	4.00	3.67		3.98
TOTAL	20.11	19.54		19.77
AVG.	4.022	3.908		3.954

MOD. _____ GA. CAL. _____ GUN. # C6348731

#	DATE	MALFUNCTION/DEFECT	ASSEM. #
TEST			
T+A	1st	Bolt hits stock when closing	
	5/22/20		
	2nd	Fite Bolt Shot	3/15/90 RW
	3rd		
	4th		

FUNCTION _____ RD 6654 Rev 1

TEST INIT. ACTION TO CORRECT		ASSEM. #
PROOF		
TEST		
TGT		
PROOF		
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		

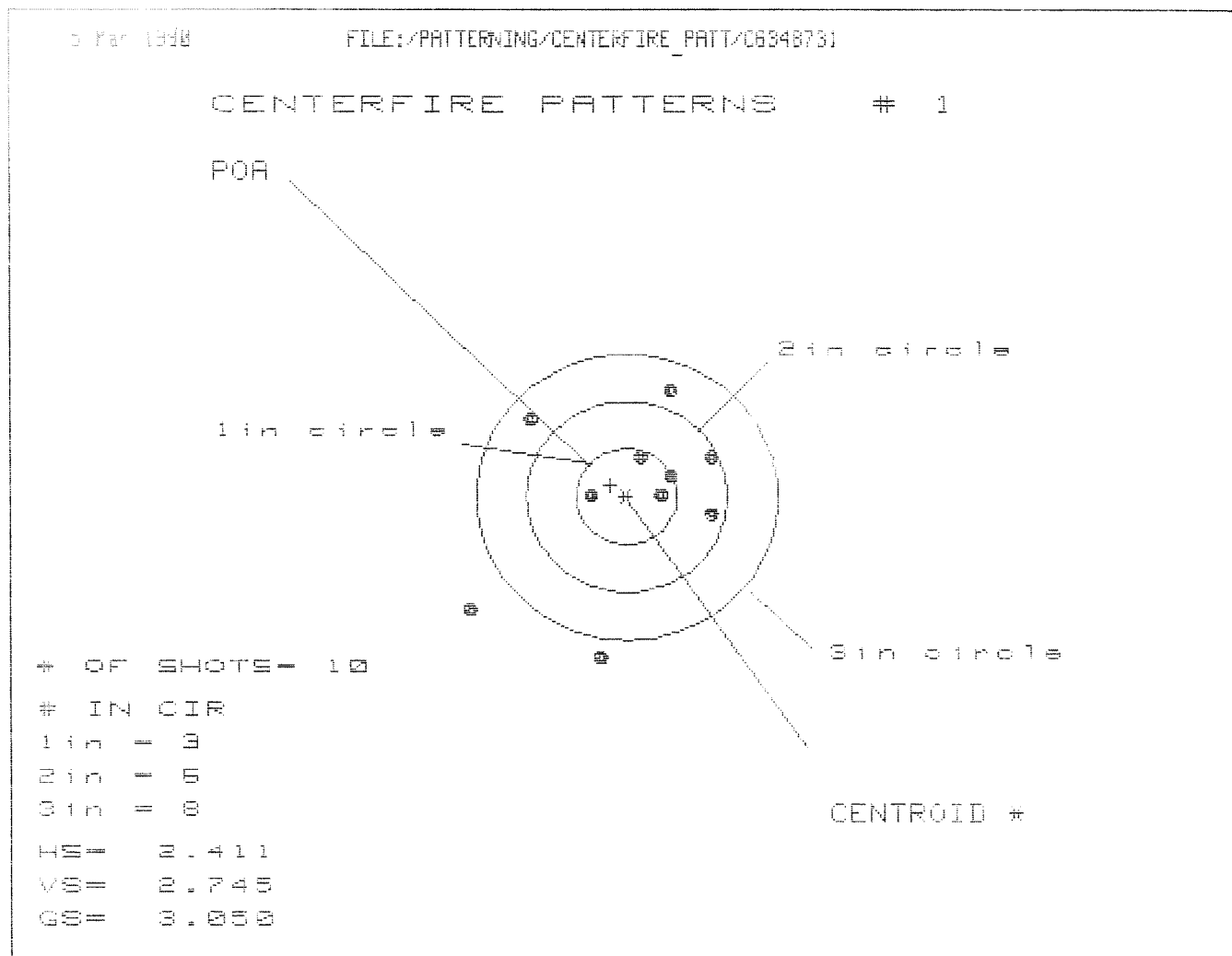
CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6348731
5 Mar 1990

CENTROIDAL DISTANCES

0 TO	1	.199832
1 TO	2	.988661
1 TO	3	.502757
1 TO	4	.846463
1 TO	5	.913585

2
4 3 5 (----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .4708
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .125
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .487112
THE AMR FOR THIS RIFLE IS: 1.132

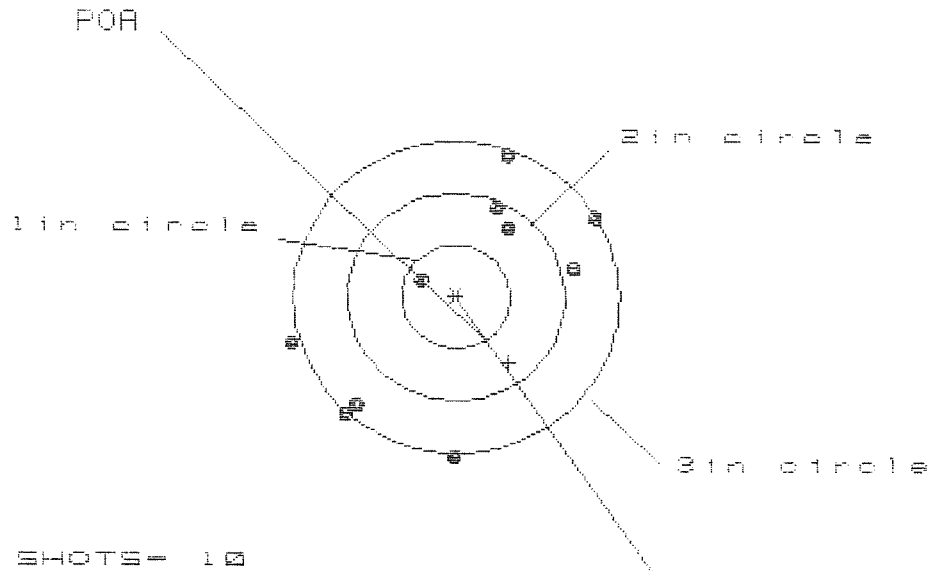


PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.859	.687	.637
MINIMUM X	-1.552	-1.114	-1.164
MAXIMUM Y	1.092	.960	.737
MINIMUM Y	-1.653	-1.785	-1.533
CENTROID X	.162	.334	.384
CENTROID Y	-.117	.015	.238
POA TO CENTROID in.	.199	.334	.451
MIN RADIUS	.315	.179	.148
MEAN RADIUS	.945	.767	.607
MAX RADIUS	1.951	1.828	1.260
HORIZONTAL SPREAD	2.411	1.801	1.801
VERTICAL SPREAD	2.745	2.745	1.270
EXTREME SPREAD	3.050	2.834	2.658
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	8		

5 Mar 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C8348731

CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 3

3 in = 6

HS = 2.769

VS = 2.825

GS = 2.984

CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.271	1.105	.952
MINIMUM X	-1.498	-1.223	-1.203
MAXIMUM Y	1.328	1.285	1.138
MINIMUM Y	-1.497	-1.540	-1.687
CENTROID X	-.481	-.315	-.162
CENTROID Y	.634	.677	.824
POA TO CENTROID in.	.796	.747	.839
MIN RADIUS	.352	.496	.492
MEAN RADIUS	1.207	1.151	1.032
MAX RADIUS	1.547	1.692	1.712
HORIZONTAL SPREAD	2.769	2.328	2.155
VERTICAL SPREAD	2.825	2.825	2.825
EXTREME SPREAD	2.984	2.974	2.863
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	3		
NUMBER IN THREE INCH CIRCLE =	6		

5 Mar 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6348731

CENTERFIRE PATTERNS # 3

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS = 10

IN CIR

1 in = 0

2 in = 4

3 in = 9

HS = 1.741

VS = 3.184

GS = 3.258

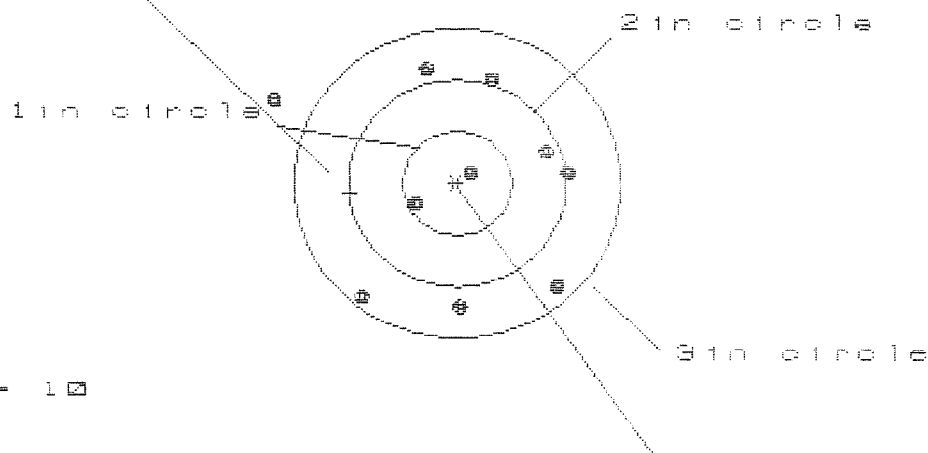
PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.801	.869	.975
MINIMUM X	:	-.940	-.872	-.766
MAXIMUM Y	:	1.815	1.293	1.169
MINIMUM Y	:	-1.369	-1.167	-1.291
CENTROID X	:	.663	.595	.489
CENTROID Y	:	-.159	-.361	-.237
POA TO CENTROID in.	:	.682	.696	.543
MIN RADIUS	:	.587	.769	.613
MEAN RADIUS	:	1.127	1.045	.984
MAX RADIUS	:	1.916	1.309	1.294
HORIZONTAL SPREAD	:	1.741	1.741	1.741
VERTICAL SPREAD	:	3.184	2.460	2.460
EXTREME SPREAD	:	3.259	2.514	2.467
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		9	

5 Mar 1998

FILE:/PATTERNING/CENTERFIRE_PATT/06348731

CENTERFIRE PATTERNS # 4

POA



OF SHOTS = 10

IN CIR

1 in = 2

2 in = 3

3 in = 5

HS = 2.718

VS = 2.286

GS = 3.122

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.056	.872	.736
MINIMUM X	:	-1.662	-1.082	-.740
MAXIMUM Y	:	1.134	1.219	1.098
MINIMUM Y	:	-1.152	-1.067	-1.188
CENTROID X	:	.982	1.166	1.301
CENTROID Y	:	.093	.008	.129
POA TO CENTROID in.	:	.986	1.166	1.308
MIN RADIUS	:	.159	.166	.184
MEAN RADIUS	:	1.044	.941	.857
MAX RADIUS	:	1.828	1.451	1.258
HORIZONTAL SPREAD	:	2.718	1.954	1.477
VERTICAL SPREAD	:	2.286	2.286	2.286
EXTREME SPREAD	:	3.122	2.427	2.427
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		9	

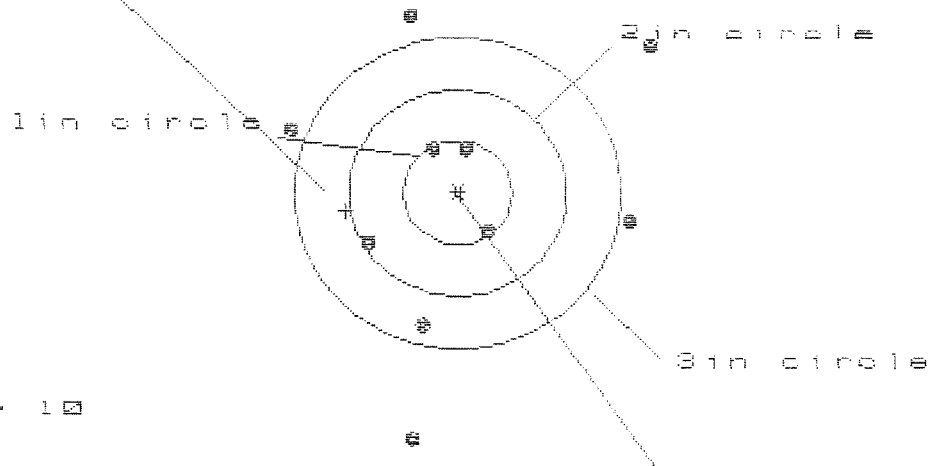
5 Mar 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6348731

CENTERFIRE PATTERNS

5

POA



OF SHOTS - 10

IN CIR

1 in = 3

2 in = 4

3 in = 5

HE = 3.312

VS = 4.100

GS = 4.324

CENTROID #

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	1.741
MINIMUM X	-1.571
MAXIMUM Y	1.775
MINIMUM Y	-2.325
CENTROID X	1.028
CENTROID Y	.174
POA TO CENTROID in.	1.042
MIN RADIUS	.438
MEAN RADIUS	1.335
MAX RADIUS	2.361
HORIZONTAL SPREAD	3.312
VERTICAL SPREAD	4.100
EXTREME SPREAD	4.324
NUMBER IN ONE INCH CIRCLE =	3
NUMBER IN TWO INCH CIRCLE =	4
NUMBER IN THREE INCH CIRCLE =	5