

C6225190

MODEL 700™ M24

Model 700 M24™

Action

Barrel Length

Capacity

Order No. 5715

*Includes 1 in chamber.

Remington

Shroud®
No. 245251

Repair Inquiry

Repair Number: **RE00085993**

Serial: C6225190 Model: M24 SWS Center Fire
Caliber: 7.62 NATO

Repairman:

Verify Repair

Status:

Closed 10/5/2004 7:57:47 AM

Address Information

Customer:

☒ Received From

Return To:

☐ Received From

Name: **COMMANDER**

COMMANDER

Address 1: **ATTN CW3 SCHLITZ PHO W8009U**

ATTN CW3 SCHLITZ PHO W8009U

Address 2: **UNIT 35123 BLDG 100**

PO Box:

UNIT 35123 BLDG 100

PO Box:

City: **APO**

APO

State: **XX**

Zip Code: **96376**

Country: **AP**

State: **XX**

Zip Code: **96376**

Country: **AP**

FFL:

Contact / Condition

Problems

Estimate

History / Status

Shipping / Billing

Contact Information

Phone:

Fax:

Email:

Comments:

Received Condition

Fair

Condition Notes:

CSR Notes:

Accessories Received

Code	Desc	Qty
A007	With Studs	3
A010	Hard Case	1
A017	Scope Bases	3

Repair Search

Refresh

Close

Serial Number: **C6225190**

Model: **M24 SWS**



RE00085993

APO.

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

R & E NUMBER	85993		
SERIAL NUMBER	C6225198		
LOG-IN DATE	10/5/2004		
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	TRL
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	LB
618	ROTO-BLAST	10-22-04	LB
620	APPLY COATINGS	10/20/04	HP
625 A	FINAL ASSEMBLY	11-3-04	RTL
B	TRIGGER PULL TEST		
C	SAFETY "ON" FORCE		
D	SAFETY "OFF" FORCE		
E	FIRING PIN INDENT		
640	TARGET	11-5-04	TRL
655	FINAL INSPECT	11-8-04	RTL
660	PACK	11-8-04	OTA
		SHIP DATE	
QAR INSPECTION DATE			

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6225190.___0
FILE DATE AND TIME: 03/09/2003 11:00

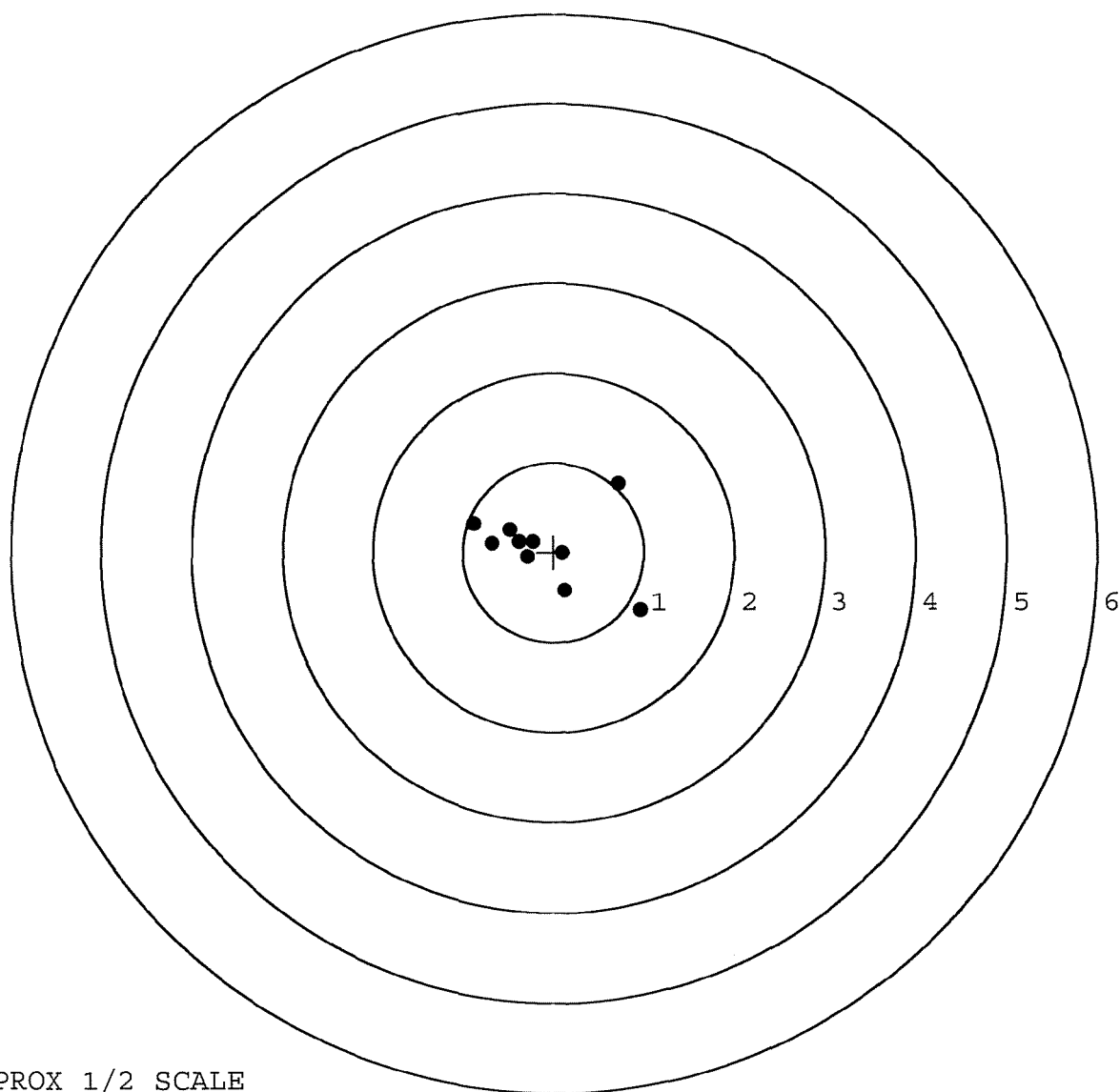
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.057
The Average Y Centroid of the Five Target Set:	0.065
The Average Point of Impact of the Five Target Set:	0.087
The Average Mean Radius of the Five Target Set:	0.626
The Distance from POA to Centroid Target #1:	0.117
The Distance from Centroid Target #2 to Centroid Target #1:	0.151
The Distance from Centroid Target #3 to Centroid Target #1:	0.452
The Distance from Centroid Target #4 to Centroid Target #1:	0.182
The Distance from Centroid Target #5 to Centroid Target #1:	0.175

SERIAL NUMBER: C6225190. 0
TARGET NUMBER: 1
FILE DATE: 03/09/2003
FILE TIME: 11:00

POINT#	X	Y
1:	0.961	-0.645
2:	0.131	-0.425
3:	0.717	0.770
4:	0.094	-0.013
5:	-0.881	0.316
6:	-0.485	0.251
7:	-0.680	0.094
8:	-0.385	0.117
9:	-0.230	0.118
10:	-0.293	-0.058

X CENTROID: -0.105
Y CENTROID: 0.053
POA TO CENTROID: 0.117
HORZ SPREAD: 1.842
VERT SPREAD: 1.415
GROUP SPREAD: 2.078
MIN RADIUS: 0.141
MAX RADIUS: 1.274
MEAN RADIUS: 0.558
IN 1 IN DIAMETER: 5
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10

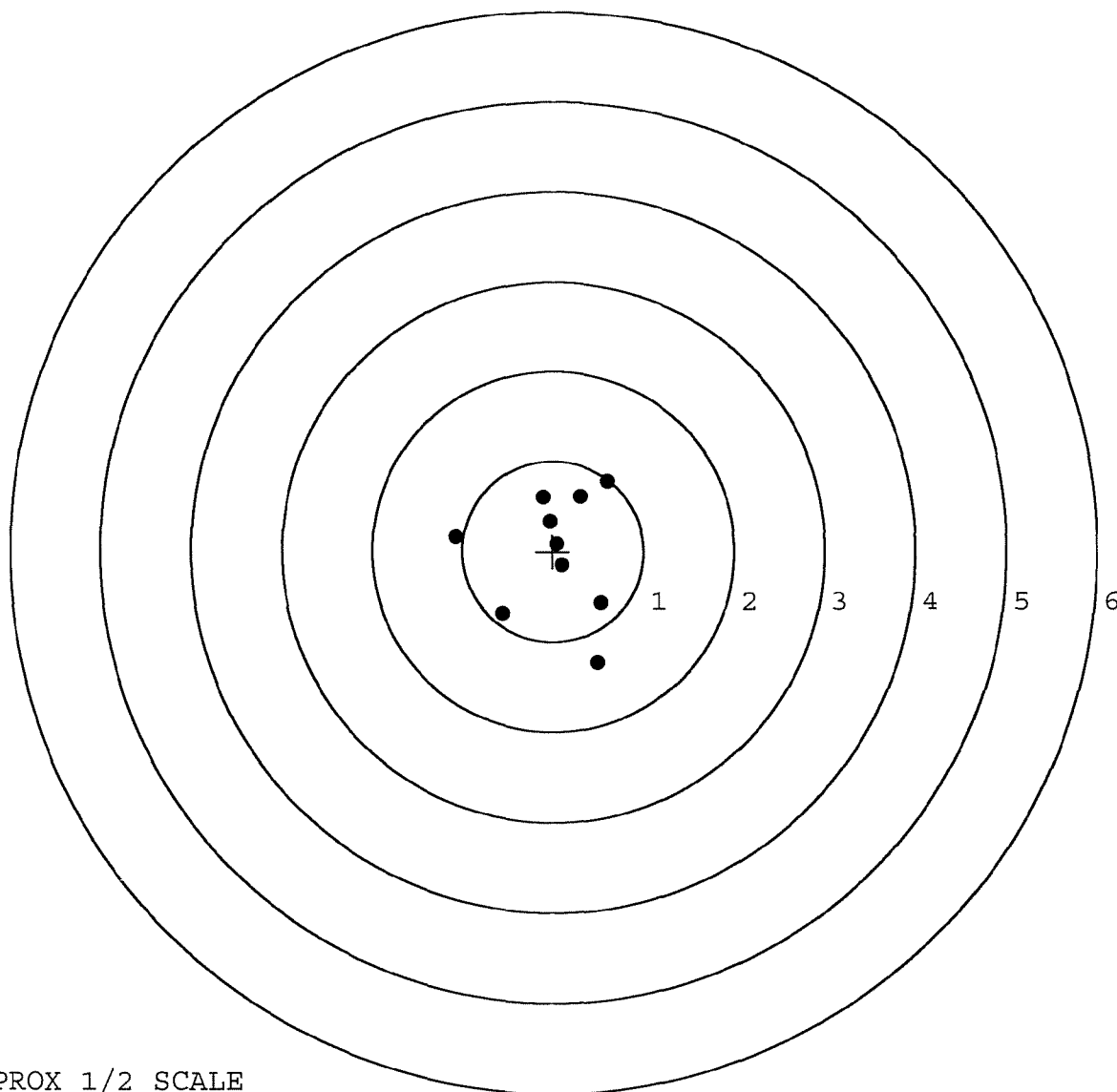


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6225190.___0
 TARGET NUMBER: 2
 FILE DATE: 03/09/2003
 FILE TIME: 11:00

POINT#	X	Y
1:	0.494	-1.237
2:	0.528	-0.568
3:	0.103	-0.158
4:	-0.553	-0.698
5:	-1.067	0.158
6:	0.600	0.777
7:	0.303	0.606
8:	0.049	0.083
9:	-0.035	0.329
10:	-0.108	0.596

X CENTROID: 0.031
 Y CENTROID: -0.011
 POA TO CENTROID: 0.033
 HORZ SPREAD: 1.667
 VERT SPREAD: 2.014
 GROUP SPREAD: 2.094
 MIN RADIUS: 0.096
 MAX RADIUS: 1.310
 MEAN RADIUS: 0.694
 # IN 1 IN DIAMETER: 3
 # IN 2 IN DIAMETER: 8
 # in 3 IN DIAMETER: 10

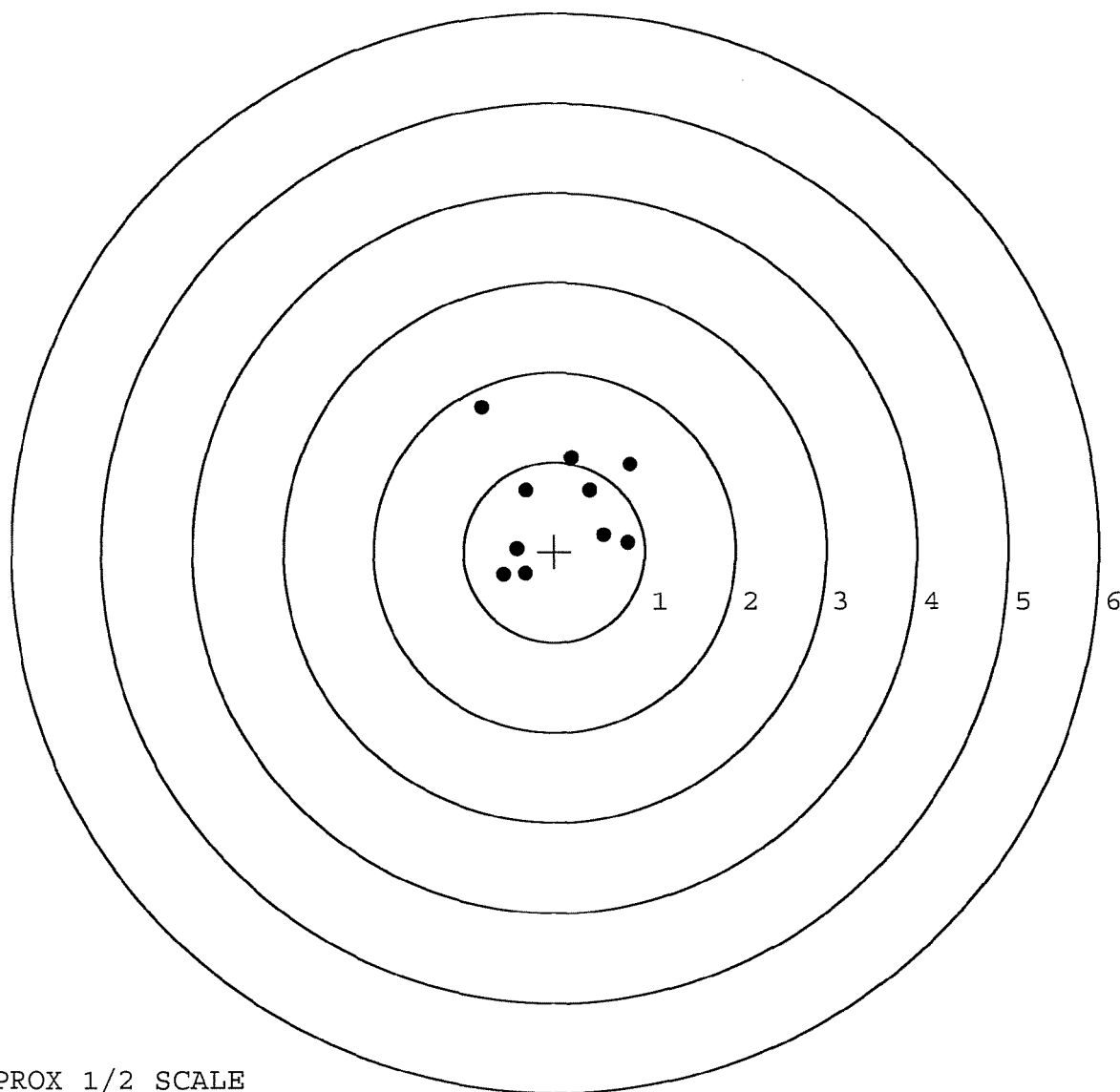


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6225190. 0
TARGET NUMBER: 3
FILE DATE: 03/09/2003
FILE TIME: 11:00

POINT#	X	Y
1:	0.807	0.106
2:	0.541	0.191
3:	0.387	0.688
4:	0.835	0.979
5:	0.188	1.047
6:	-0.314	0.686
7:	-0.809	1.605
8:	-0.415	0.033
9:	-0.319	-0.250
10:	-0.555	-0.262

X CENTROID: 0.035
Y CENTROID: 0.482
POA TO CENTROID: 0.484
HORZ SPREAD: 1.644
VERT SPREAD: 1.867
GROUP SPREAD: 2.204
MIN RADIUS: 0.404
MAX RADIUS: 1.404
MEAN RADIUS: 0.759
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

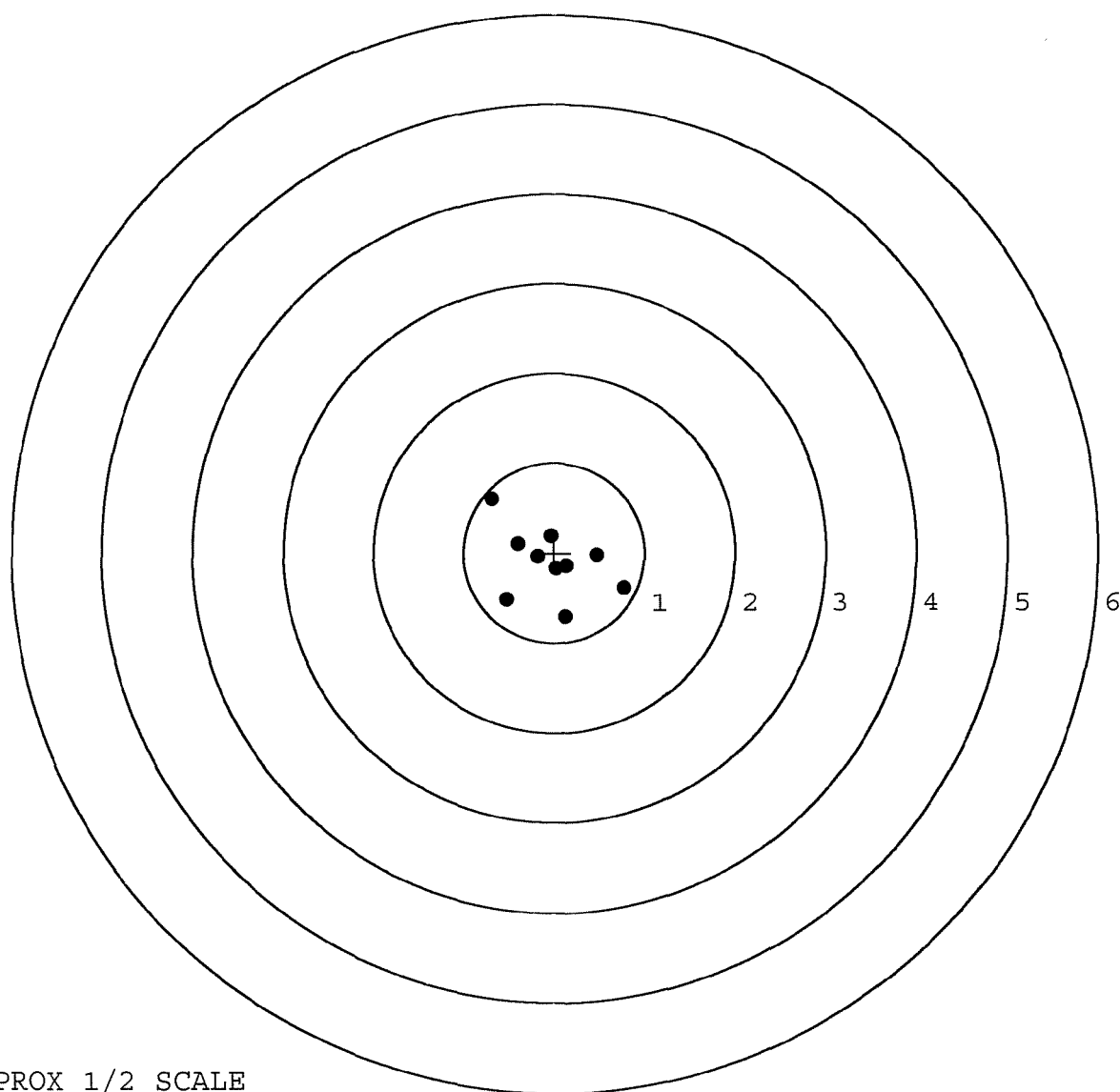


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6225190. 0
TARGET NUMBER: 4
FILE DATE: 03/09/2003
FILE TIME: 11:00

POINT#	X	Y
1:	0.779	-0.387
2:	0.129	-0.712
3:	-0.522	-0.526
4:	0.468	-0.022
5:	-0.689	0.597
6:	-0.404	0.100
7:	-0.038	0.188
8:	0.135	-0.149
9:	0.022	-0.179
10:	-0.183	-0.046

X CENTROID: -0.030
Y CENTROID: -0.114
POA TO CENTROID: 0.118
HORZ SPREAD: 1.468
VERT SPREAD: 1.309
GROUP SPREAD: 1.767
MIN RADIUS: 0.084
MAX RADIUS: 0.969
MEAN RADIUS: 0.474
IN 1 IN DIAMETER: 5
IN 2 IN DIAMETER: 10
in 3 IN DIAMETER: 10

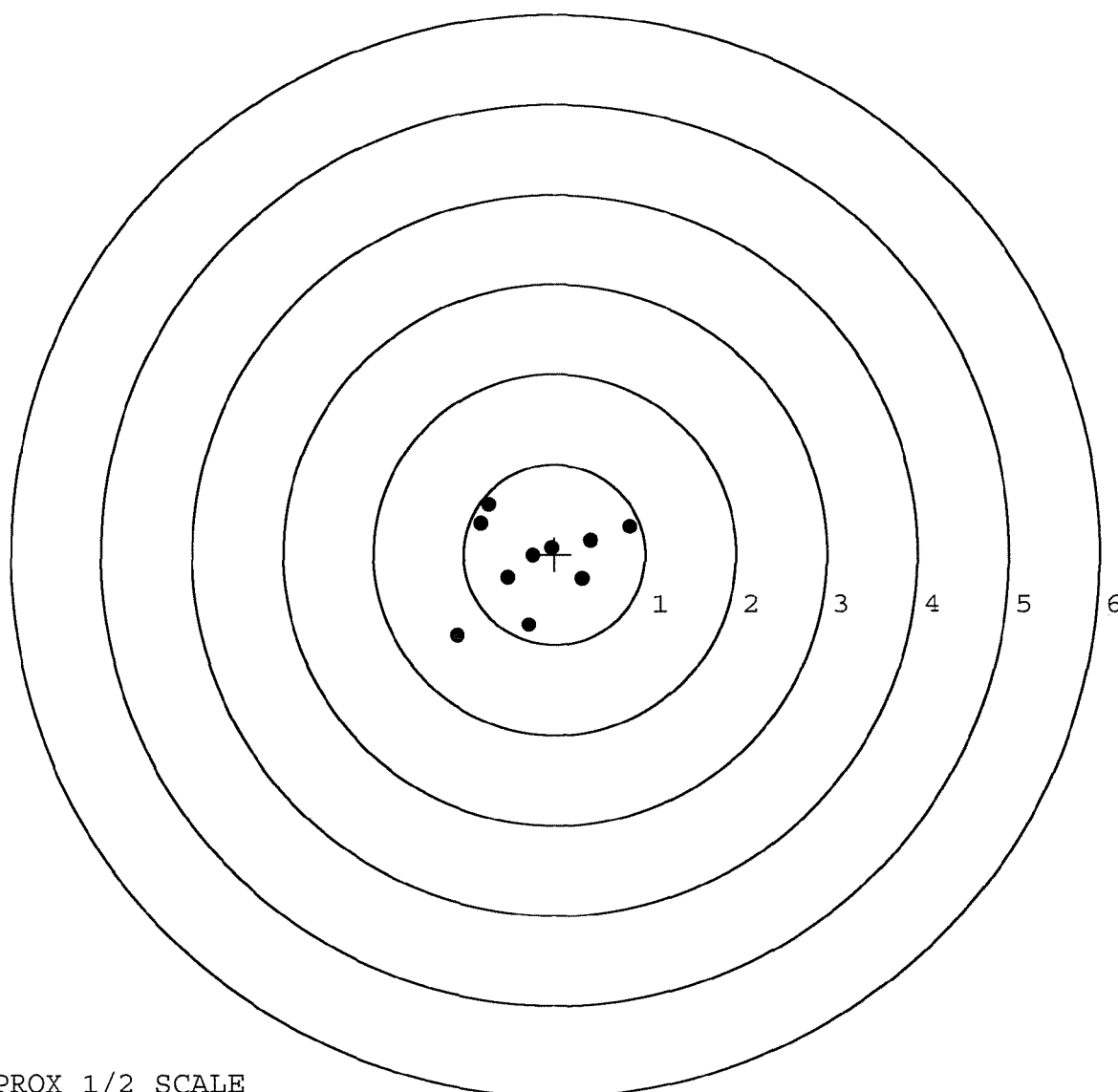


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6225190. 0
TARGET NUMBER: 5
FILE DATE: 03/09/2003
FILE TIME: 11:00

POINT#	X	Y
1:	0.310	-0.273
2:	0.827	0.307
3:	0.398	0.154
4:	-0.038	0.072
5:	-0.241	-0.015
6:	-0.511	-0.264
7:	-0.285	-0.792
8:	-1.072	-0.915
9:	-0.815	0.344
10:	-0.733	0.548

X CENTROID: -0.216
Y CENTROID: -0.083
POA TO CENTROID: 0.232
HORZ SPREAD: 1.899
VERT SPREAD: 1.463
GROUP SPREAD: 2.258
MIN RADIUS: 0.073
MAX RADIUS: 1.193
MEAN RADIUS: 0.644
IN 1 IN DIAMETER: 3
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TARGET APPROX 1/2 SCALE

Repair Number: RE00061094	Serial: C6225190 Model 700 Center Fire Caliber: 7.62 NATO M-24 (SWS)	Repairman: _____	Status: _____
Verify Repair: ☐	Closed 2/4/2003 5:14:26 PM		

Address Information

Customer: ☒ Received From	Return To: ☐ Received From
Name: COMMANDER	COMMANDER
Address 1: ATTN SGT GONZALEZ	ATTN SGT GONZALEZ
Address 2: 1/1 SFG (A) UNIT 35123 PO Box: _____	1/1 SFG (A) UNIT 35123 PO Box: _____
City: AP0	AP0
State: XX Zip Code: 96376 Country: AP	State: XX Zip Code: 96376 Country: AP

FFL:

Contact / Condition	Problems	Estimate	History / Status	Shipping / Billing
---------------------	----------	----------	------------------	--------------------

Contact Information

Phone: _____

Fax: _____

Email: _____

Comments:

Received Condition

Poor

Condition Notes: REC'D IN SAME HARD CASE
W/ SER# C6348798 & SER# C6225339

CSR Notes:

Accessories Received

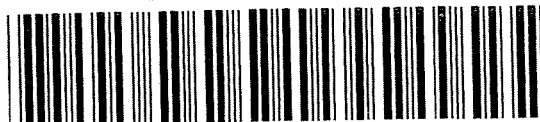
Code	Desc	Qty
A007	With Stud	1
A010	Hard Case	1
A017	Scope Base	1
X	FRT & REAR SGT BA	1

Repair Search

Refresh

Close

Model: 700



RE00061094

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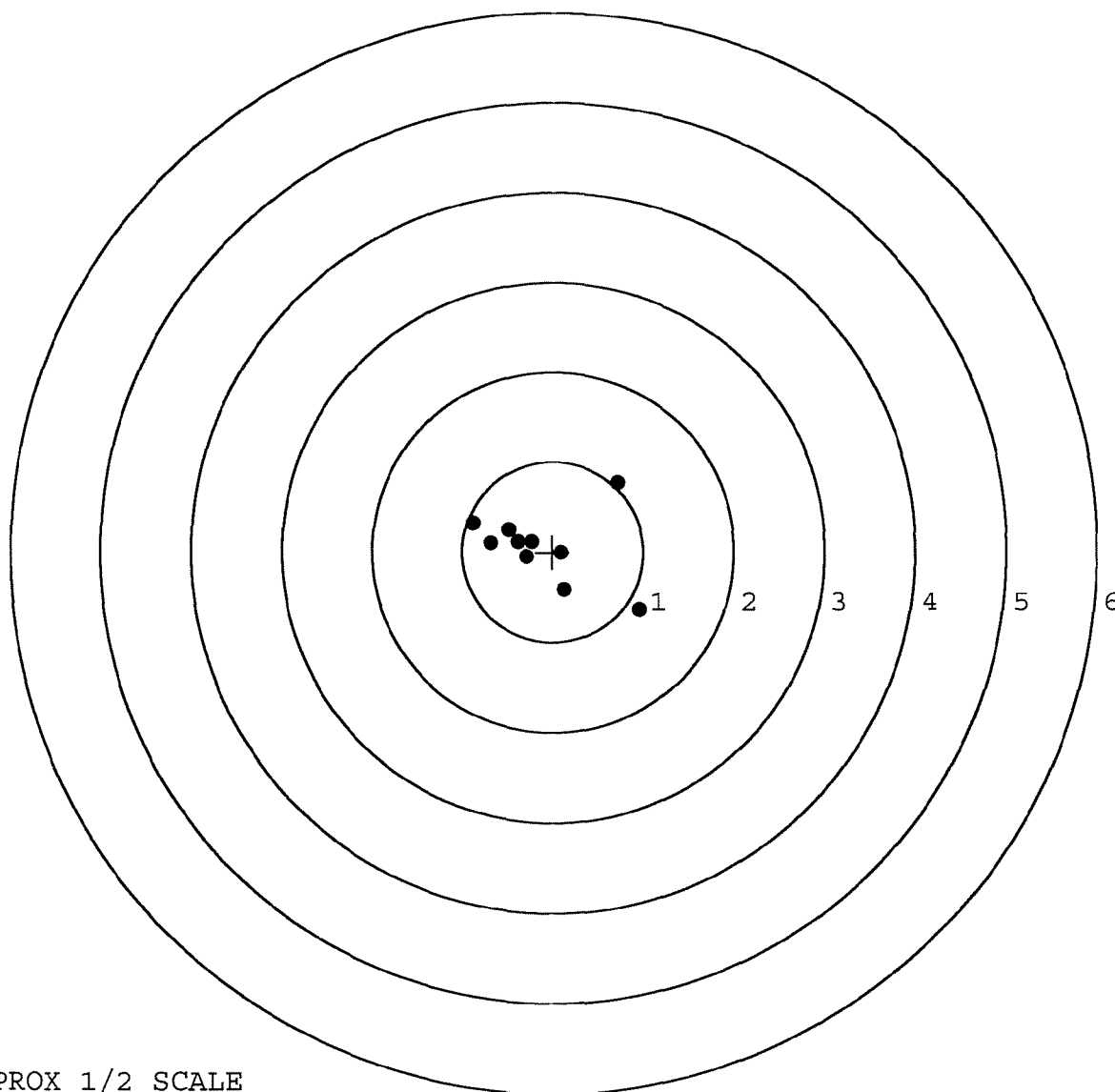
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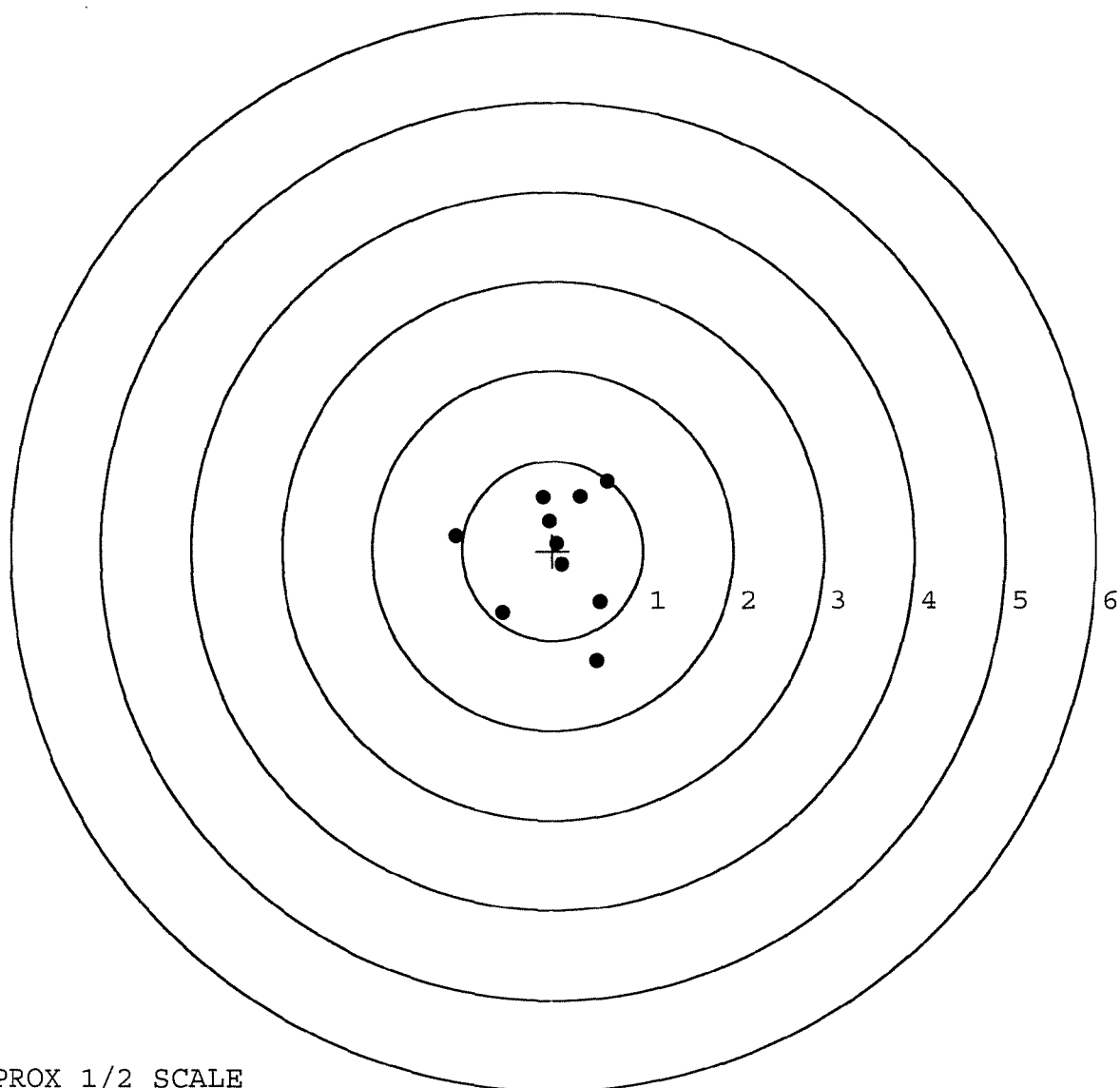


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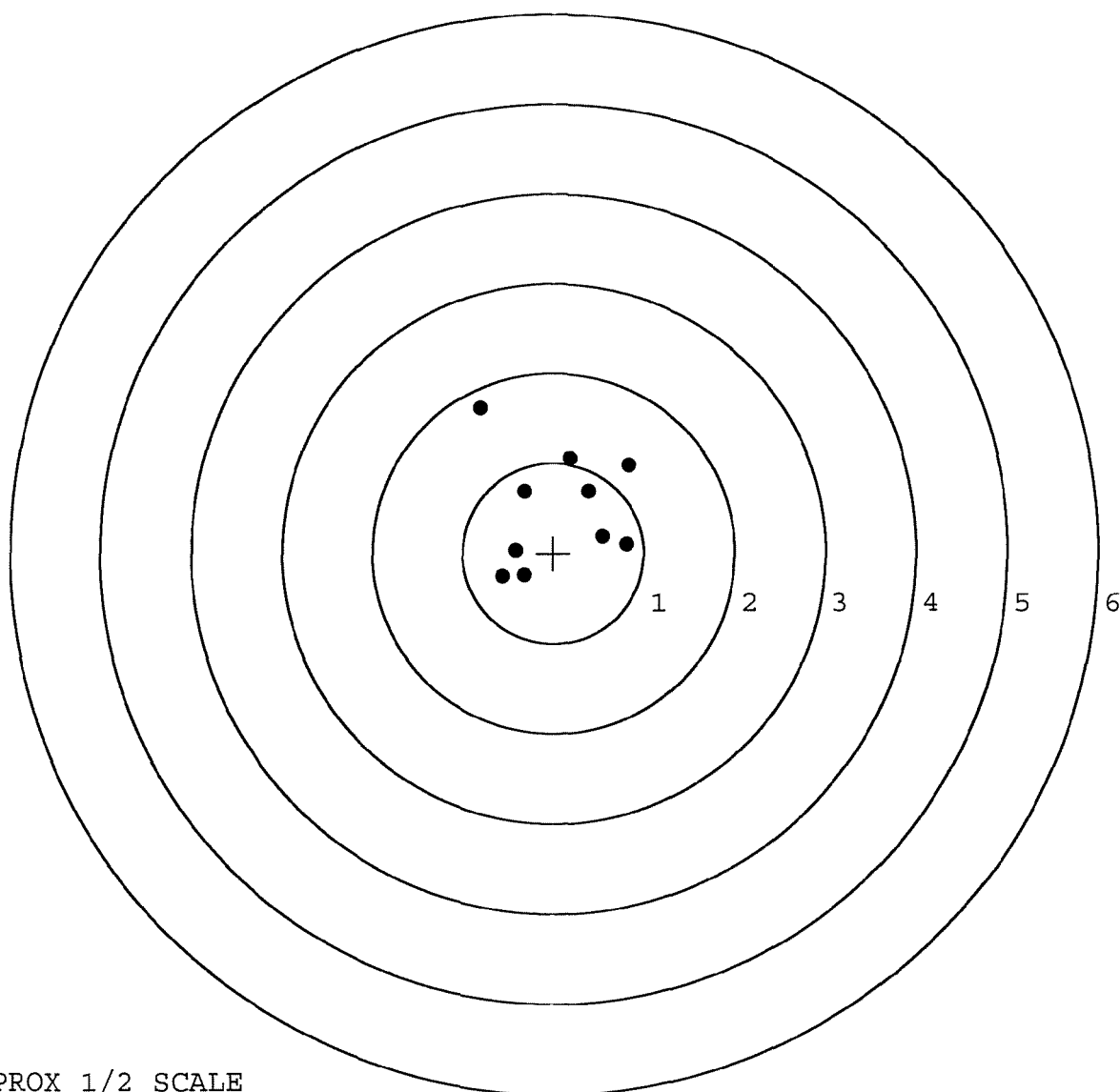


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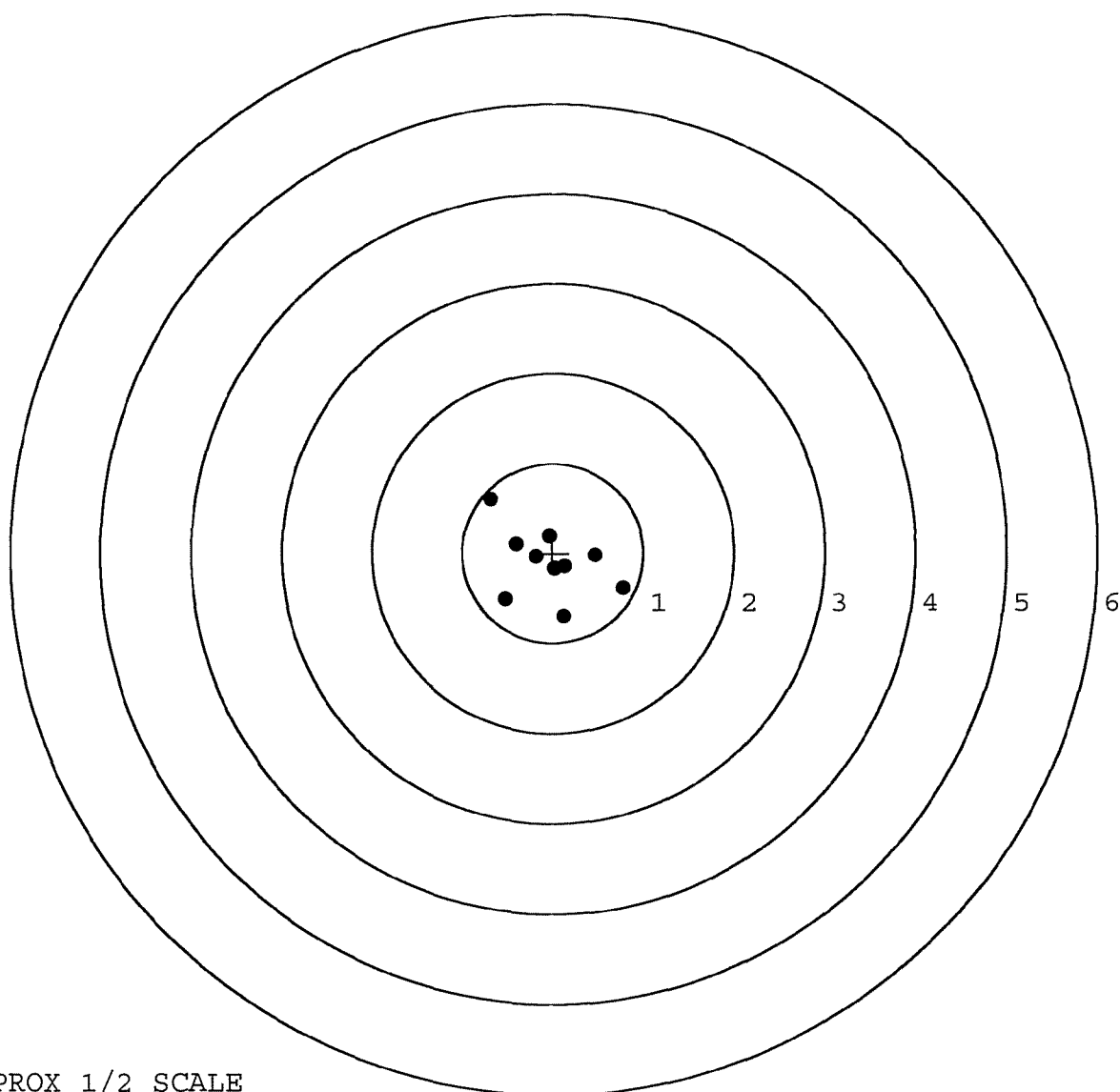


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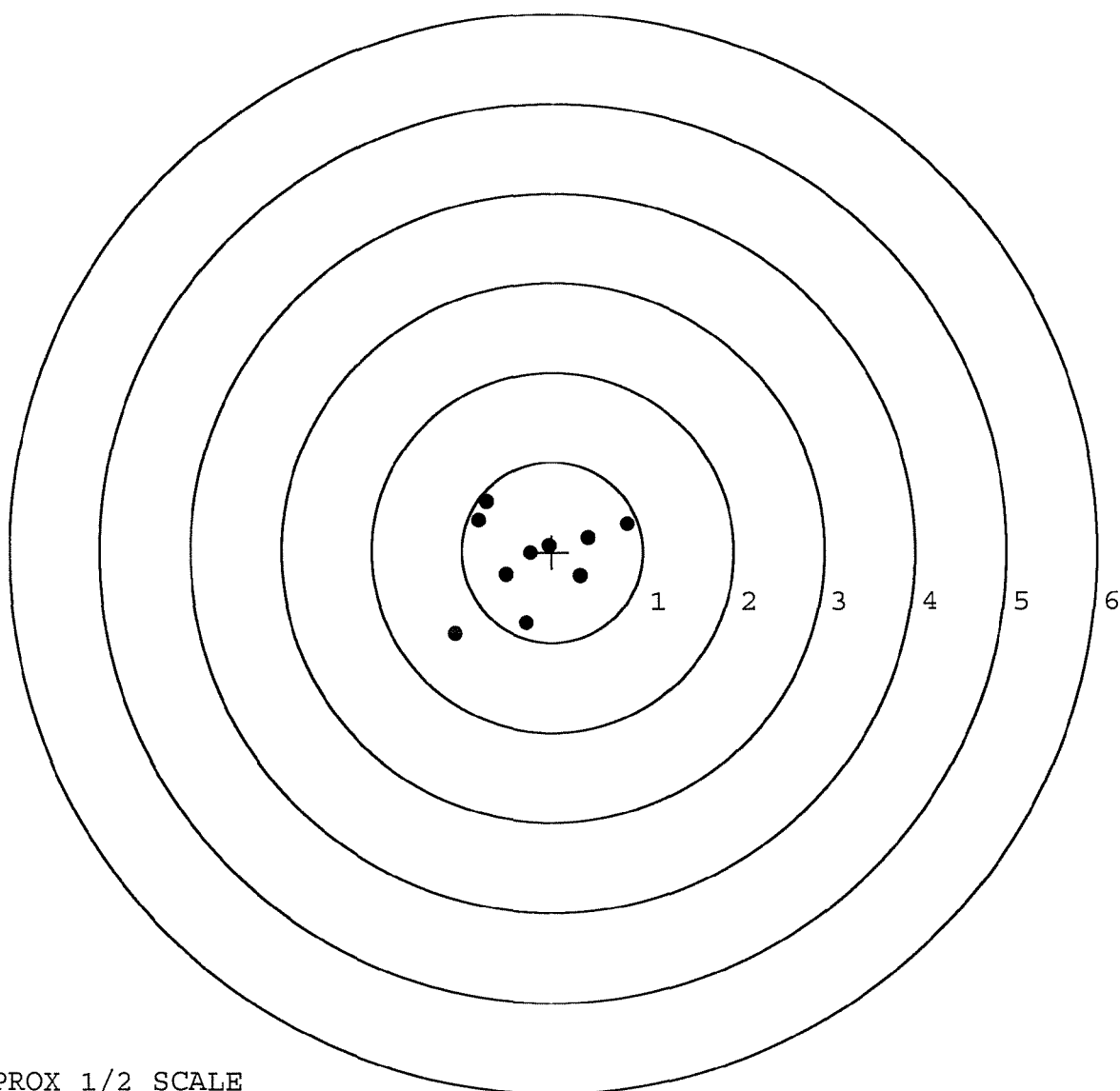


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Y CENTROID: -0.083
POA TO CENTROID: 0.232
HORZ SPREAD: 1.899
VERT SPREAD: 1.463
GROUP SPREAD: 2.258
MIN RADIUS: 0.073
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MEAN RADIUS: 0.644
IN 1 IN DIAMETER: 3
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in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

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

SERIAL # C6225190 INSPECTED BY: RTL

DATE REC'D: 2-4-03 DATE RET'D: 3-10-03

ITEM

BARREL ASSEMBLY

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

SCOPE ASSEMBLY

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

ITEM

STOCK ASSEMBLY

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

SYSTEMS CASE

☐ SCOPE CASE
☐ IRON SIGHTS
☐ DEPLOYMENT KIT

TRIGGER ASSEMBLY

☒ SAFETY OPERATION
☒ RE-SET TO FACTORY SPECS

COMMENTS:

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

R & E NUMBER	61094		
SERIAL NUMBER	C6225190		
LOG-IN DATE	2/4/03		
INSPECT AND VERIFY:			
OPERATION #	OPERATION NAME	DATE	INITIAL
550	DIS-ASSEMBLE GUN	2/10/03	RTL
560 A	RE-BARREL	2-11-03	RTL
B	DRILL AND TAP	2-20-03	TRW
575	ASSEMBLE	2-13-03	RTL
600	PROOF	2-13-03	AC
605	CHECK HEADSPACE	2-13-03	AC
610	DIS-ASSEMBLE GUN	2-14-03	RTL
612	MAGNAFLUX		
615	ROLLMARK CALIBER	2/19/03	LB
618	ROTO-BLAST	2-26-03	JA
620	APPLY COATINGS	3-3	JA
625 A	FINAL ASSEMBLY	3-6-03	RW
B	TRIGGER PULL TEST		
C	SAFETY "ON" FORCE		
D	SAFETY "OFF" FORCE		
E	FIRING PIN INDENT		
640	TARGET	3-8-03	AC
655	FINAL INSPECT	3-10-03	RTL
660	PACK	3-10-03	DA
		SHIP DATE	
QAR INSPECTION DATE			

RECEIVING AND ESTIMATING REPORT

COMMENTS

ORDER
R99-12457

INITIALS CUSTOMER ORDER NO.
SWS 011-81-611-744-4441

W/SCOPE
W/I SWIVEL

Scope # 87-1127

DATE RECEIVED 06/09/99 DATE OPENED 06/10/99 DATE CODE LI 2-88 SERIAL NUMBER C6225190 NEW SERIAL NUMBER MODEL AND GRADE 700 7.62 M24/NATO
ACCESSORIES W/STUDS

FROM:

SHIP TO:

COMMANDER
1ST BN 1ST SFG A UNIT 35123
ATTN PROPERTY BOOK OFFICER
PSC 560 TORII STA. CA 96376

COMMANDER
1ST BN 1ST SFG A UNIT 35123
ATTN PROPERTY BOOK OFFICER
PSC 560 TORII STA. CA 96376

CUST NO: 198287 C.O.L.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

PARTS

COMMENTS

Barrel 1 96003

REPAIRMAN PROOF CLEAN TEST TARGET PATTERN

GALLERY TESTER DATE DATE DATE DATE DATE DATE

OFFICE COPY

RD6925 REV. 7/97

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

M2400010291

EQUIPMENT INSPECTION AND MAINTENANCE WORKSHEET

For use of this form, see DA PAM 738-750 and 738-751; the proponent agency is DCSLOG

[illegible]

EQUIPMENT INSPECTION AND MAINTENANCE WORKSHEET

For use of this form, see DA PAM 738-750 and 738-751; the proponent agency is DCSLOG

[illegible]

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DA FORM 2709-1, APR 76																															
DOC IDENT		ROUT IDENT		FSC		NNN		ADD		QUANTITY		REQUISITIONER		DATE		SERIAL		SUPPLEMENTARY ADDRESS		FUND		DISTRIBUTION		PROJECT		PRIORITY		REQ DEL DATE		ADV STAT	
SEND TO: JFCSMCS										REQUEST IS FROM: PBO, 1st BN, 1st SFG (A) UNIT 35123 APO, AP 96376-5123 Okinawa, Japan																					
A										B																					
C										D																					
E										F																					
G										H																					
I										J																					
K										L																					
M										N																					
O										P																					
Q										R																					
S										T																					
U										V																					
W										X																					
Y										Z																					
AA										AB																					
AC										AD																					
AE										AF																					
AG										AH																					
AI										AJ																					
AK										AL																					
AM										AN																					
AO										AP																					
AQ										AR																					
AS										AT																					
AU										AV																					
AW										AX																					
AY										AZ																					
BA										BB																					
BC										BD																					
BE										BF																					
BG										BH																					
BI										BJ																					
BK										BL																					
BM										BN																					
BO										BP																					
BQ										BR																					
BS										BT																					
BU										BV																					
BW										BX																					
BY										BZ																					
CA										CB																					
CC										CD																					
CE										CF																					
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CM										CN																					
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CQ										CR																					
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REQUISITION AND INVOICE / SHIPPING DOCUMENT										Form Approved OMB No. 0704-0248 Expires Dec 13, 1998					
Public reporting burden for this collection of information is estimated to average 1 hour per response, including the time for reviewing instructions, searching existing data sources, gathering and maintaining the data needed, and completing and reviewing this collection of information. Send comments regarding this burden estimate or any other aspect of this collection of information, including suggestions for reducing this burden, to Washington Headquarters Services, Directorate for Information Operations and Reports, 1215 Jefferson Davis Highway, Suite 1204, Arlington, VA 22202-4302, and to the Office of Management and Budget, Paperwork Reduction Project (0704-0248), Washington, DC 20503.															
PLEASE DO NOT RETURN YOUR COMPLETED FORM TO EITHER OF THESE ADDRESSES, RETURN COMPLETED FORM TO THE ADDRESS IN ITEM 2															
1. FROM: (Include ZIP Code) Commander 1st Bn, 1st SFG (A) APO, AP 96376 Attn: PBO Com #: 011-81-611-744-4441						SHEET NO.	NO. OF SHEETS	5. REQUISITION DATE		6. REQUISITION NUMBER					
						7. DATE MATERIAL REQUIRED (YYMMDD)		8. PRIORITY							
2. TO: (Include ZIP Code) Remington Arms Co., Inc. 14 Hoefler Avenue Llion, NY 13357-1816						9. AUTHORITY OR PURPOSE									
						10. SIGNATURE		11a. VOUCHER NUMBER & DATE (YYMMDD)							
3. SHIP TO - MARK FOR Attn: Fabricated Products Dept.						12. DATE SHIPPED (YYMMDD)		b.							
						13. MODE OF SHIPMENT		14. BILL OF LADING NUMBER							
						15. AIR MOVEMENT DESIGNATOR OR PORT REFERENCE NO.									
4. APPROPRIATIONS SYMBOL AND SUBHEAD				OBJECT CLASS	EXPENDITURE ACCOUNT (From) (To)		CHARGEABLE ACTIVITY		BUREAU CONTROL ACTIVITY NO.		BUREAU CONTROL NO.	AMOUNT			
ITEM NO. (a)	FEDERAL STOCK NUMBER, DESCRIPTION, AND CODING OF MATERIEL AND / OR SERVICES (b)					UNIT OF ISSUE (c)	QUANTITY REQUESTED (d)	SUPPLY ACTION (e)	TYPE CON-TAINER (f)	CON-TAINER NOS. (g)	UNIT PRICE (h)	TOTAL COST (i)			
1.	1005-01-01-240-2136 Rifle, 7.62mm Sniper M24 S/N# C6225190/871127, C6225339, C6225343/881219, C6348920, C6225218					EA	55				5,145.00	25,725.00			
	-----Nothing Follows-----														
16. TRANSPORTATION VIA MATS OR MSTs CHARGEABLE TO						17. SPECIAL HANDLING									
18. R E C E I V E R S H I P I N G I N F O R M A T I O N	ISSUED BY	TOTAL CON-TAINERS	TYPE CON-TAINER	DESCRIPTION		TOTAL WEIGHT	TOTAL CUBE	19. R E C E I V E R S H I P I N G I N F O R M A T I O N	CONTAINERS RECEIVED EXCEPT AS NOTED	DATE (YYMMDD)	BY	SHEET TOTAL			
	CHECKED BY								QUANTITIES RECEIVED EXCEPT AS NOTED	DATE (YYMMDD)	BY	GRAND TOTAL			
	PACKED BY								POSTED	DATE (YYMMDD)	BY	20. RECEIVER'S VOUCHER NO.			
				← →											

FROM: COMMANDER
1ST BN, 1ST SFG (A)
ATTN: PBO TORII STATION
OKINAWA JAPAN
APO, AP 96376

Received in Damaged Condition
at Buffalo, N.Y. 14240

Received in Damaged Condition
at Buffalo, N.Y. 14240

TO: REMINGTON ARMS CO., INC.
14 HOFER AVENUE
ATTN: FABRICATED PRODUCTS DEPT.
LLION, NY 13357-1816

LEUPOLD & STEVENS, INC.

MAILING: PO BOX 688
BEAVERTON OR 97075-0688
(503) 646-9171

SHIPPING: 14400 NW GREENBRIER PARKWAY
BEAVERTON OR 97006-5934
FAX (503) 526-1455

TELEX 15-1227

MAIL REMITTANCE IN U.S.
FUNDS TO:

LEUPOLD & STEVENS, INC.
PO BOX 4985
BEAVERTON OR 97076-4985 USA

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REMINGTON ARMS CO., INC.
Attn:
14 HOEFLER AVE.
ILION NY 13357

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REMINGTON ARMS CO., INC.
Attn:
14 HOEFLER AVE.
ILION NY 13357

Invoice No.	Date	Type of Service	Via
0181498	07/09/99	WARRANTY	
1 ea ULTRA M3A-10X S/N# 871127			Charge
Complaints/Requests WARRANTY- INSPECTION INTERNAL PARTICLES			
Service Activity: CLEANED OPTICS			
SHIPPING & HANDLING			AMOUNT DUE
			NO CHG

For Customer Use Only:

Charge/Debit Card Payment: ☐ Visa ☐ Master Card Card # _____

Expiration Date: _____ Signature: _____

VALUE FOR CUSTOMS PURPOSES ONLY \$ _____ THESE COMMODITIES ARE EXITING THE U.S.A. UNDER GENERAL LICENSE _____

"THESE COMMODITIES LICENSED BY THE UNITED STATES FOR ULTIMATE DESTINATION USA DIVERSION CONTRARY TO UNITED STATES LAW PROHIBITED."

EXPORTER/MANUFACTURER: LEUPOLD & STEVENS INC.
PLACE: BEAVERTON, OREGON USA
ECCN: 0A987

SIGNATURE: _____
NAME: _____ EXPORT/INVOICING SPECIALIST I.D. 93-0372974

Remington Test Lab, Ilion, N.Y.

Centroidal distance calculations for Rifle # c6225190
9 Sep 1999

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1996
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0258
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .201261
THE AMR FOR THIS RIFLE IS: .9784

CENTROIDAL DISTANCES

Ø TO	1	.17789
1 TO	2	.542196
1 TO	3	.122642
1 TO	4	.324089
1 TO	5	.2547

2
+ 5 <----POA
3 4

REMINGTON CENTERFIRE ACCURACY TEST

REMINGTON TEST LAB, ILION, N.Y.

PATTERN #: ☐ 1 ☐

POA TO CENTROID: .177

MIN RADIUS : .594

MEAN RADIUS : 1.116

MAX RADIUS : 1.617

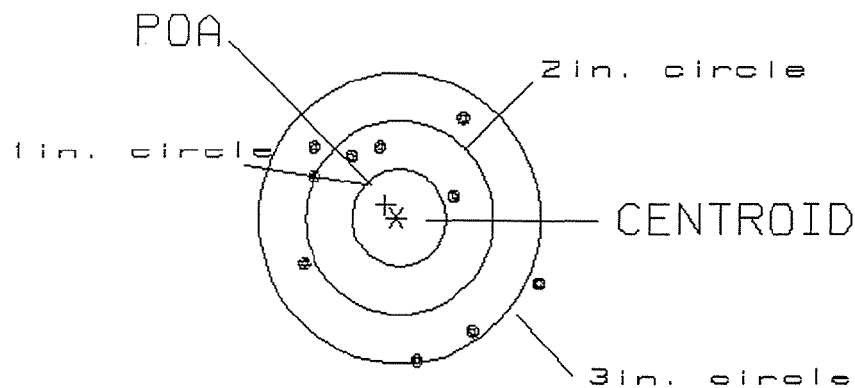
CENTROID X : .117

CENTROID Y : -.134

9 Sep 1999

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6225190

CENTERFIRE PATTERN # 1



OF SHOTS= 10

IN CIRCLE

HS= 2.52

0

VS= 2.54

3

GS= 2.80

0

PATTERN #: ☐ 2 ☐

POA TO CENTROID: .435

MIN RADIUS : .179

MEAN RADIUS : 1.294

MAX RADIUS : 2.938

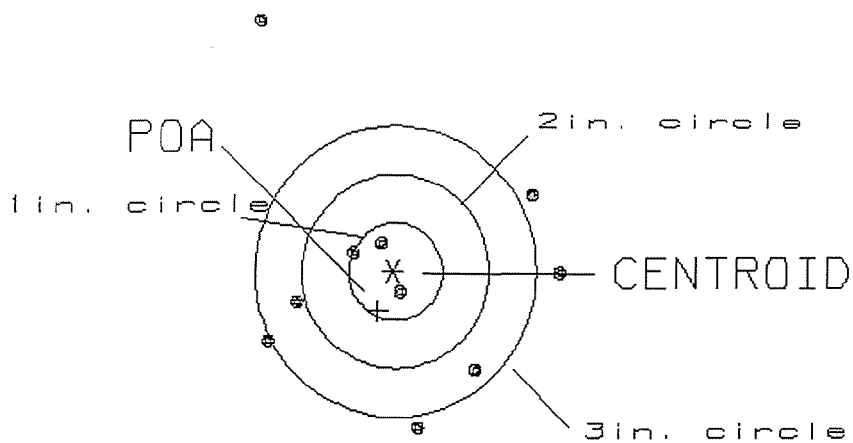
CENTROID X : .153

CENTROID Y : .407

9 Sep 1999

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6225198

CENTERFIRE PATTERN # 2



OF SHOTS= 10

IN CIRCLE

HS= 3.19

3

VS= 4.15

3

GS= 4.47

5

PATTERN #: ☐ 3 ☐

POA TO CENTROID: .206

MIN RADIUS : .242

MEAN RADIUS : .833

MAX RADIUS : 1.395

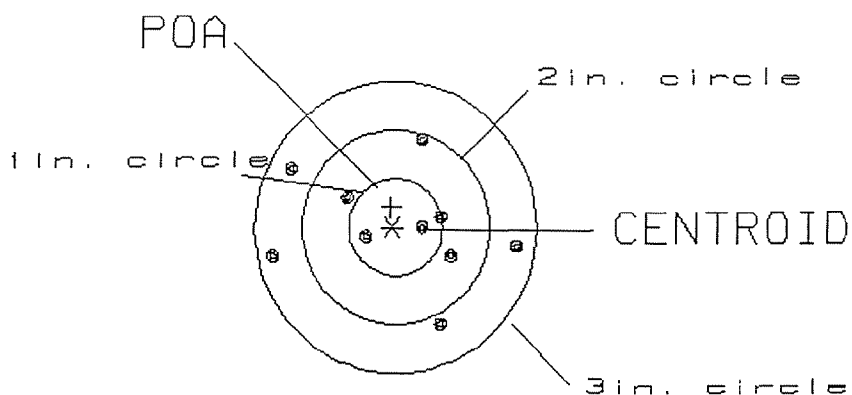
CENTROID X : .017

CENTROID Y : -.205

9 Sep 1999

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6225190

CENTERFIRE PATTERN # 3



OF SHOTS= 10

IN CIRCLE

HS= 2.69

2

VS= 1.88

6

GS= 2.69

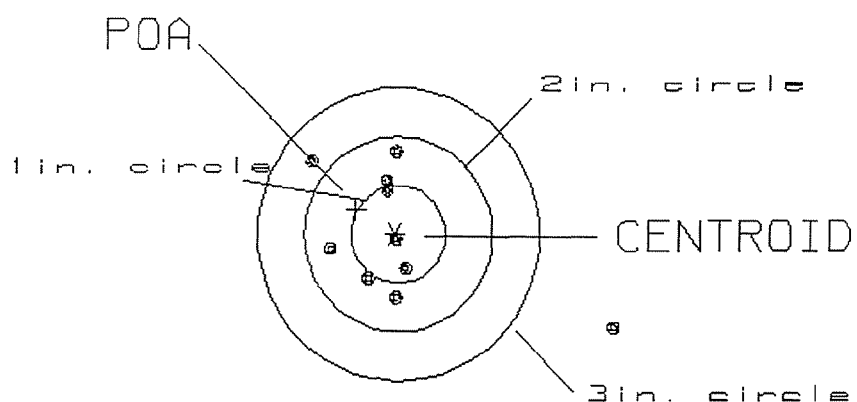
10

PATTERN #: ☐ 4 ☐
 POA TO CENTROID: .488
 MIN RADIUS : .054
 MEAN RADIUS : .781
 MAX RADIUS : 2.430
 CENTROID X : .420
 CENTROID Y : -.249

9 Sep 1999

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6225190

CENTERFIRE PATTERN # 4



OF SHOTS= 10

IN CIRCLE

HS= 3.17

3

VS= 1.76

8

GS= 3.59

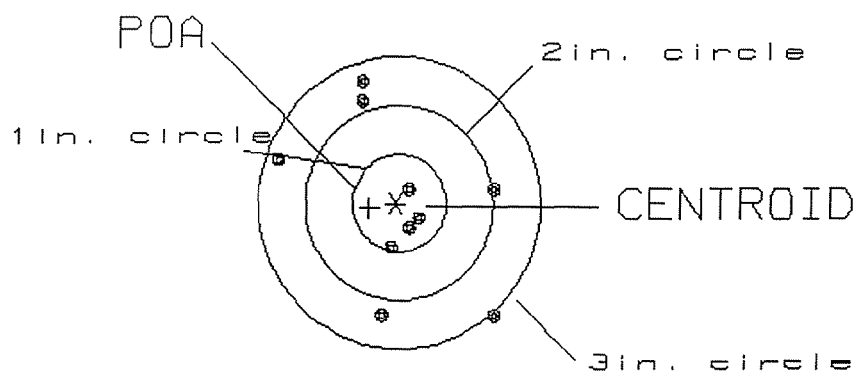
9

PATTERN #: ☐ 5 ☐
 POA TO CENTROID: .295
 MIN RADIUS : .209
 MEAN RADIUS : .868
 MAX RADIUS : 1.517
 CENTROID X : .291
 CENTROID Y : .052

9 Sep 1999

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6225198

CENTERFIRE PATTERN # 5



OF SHOTS= 10

IN CIRCLE

HS= 2.38

4

VS= 2.38

4

GS= 2.85

9

21 DAY TURN - AROUND

M-24
CONTRACT # DAAA09-92-C-0834

R&E NO.

SERIAL NO. C6225190

LOG IN DATE: / /		DATE	INT.
INSPECT & VERIFY:			
OP. #	OP. NAME		
550	DIS-ASSEMBLE GUN	6-14-99	RW
560 A	RE-BARREL AT CUSTOM SHOP		
B	DRILL & TAP		
C	POLISH		
575	ASSEMBLE		
600	PROOF	6-16-99	RW
605	CHECK HEADSPACE	6-16-99	RW
610	DIS-ASSEMBLE		
612	MAGNAFLUX	6-16-99	
615	ROLLMARK CALIBER		
618	ROTO-BLAST		
620	APPLY COATINGS		
625 A	FINAL ASSEMBLY		
B	TRIGGER PULL TEST		
C	SAFETY ON FORCE		
D	SAFETY OFF FORCE		
E	FIRING PIN INDENT		
640	TARGET	9-3-99	RW
655	FINAL INSPECT	9-10-99	RW
660	PACK		

QAR INSPECTION

SHIP DATE

Final Inspection

Sni: C6225190

DATE REC'D: 6/9/99

DATE RET'D:

Auditor: 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:

M2400010309

[illegible]

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6225190

OPERATION		DATE	INT
#	NAME		
575-580	ASSEMBLY	2/1	FB
600	PROOF	2/2/88	RLW
615	MAGNAFLUX BARREL	2/18/88	P/C
	MAGNAFLUX BOLT	2/25/88	P/C
620	COATING	3/21/88	SA
625-630	FINAL ASSEMBLY		
635	TEST		
640	TARGET		
	FIRING PIN INDENT		
660	PACK		

SCOPE # 1127

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6225190

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		9/12/88	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		9/12/88	RW
	C) Inspect Ejector Hole for Chamfer		9/12/88	RW

OVER

OP.#		READINGS	DATE	INITIAL
625 cont.	D) Oil Firing Pin Ass'y		9/12/88	RW
	E) Adjust Trigger Pull to Min. Setting and Stake		12 Sept 88	Ju WB
	F) Safety on Force	5 1/4 5# 5#	12 Sept 88	J.U. W.B
	G) Safety off Force	3# 3# 3 1/4#	12 Sept 88	J.U. W.B
	H) Trigger Pull Test & Retainabilty		12 Sept 88	J.U. W.B
	I) Firing Pin Indent	.0215 .022 .0215	12 Sept 88	J.U. W.B
	J) Assemble Stock		9/15/88	RW
	K) Assemble Swivel Studs		10-12 88	JS
	L) Attach Front & Rear Sight Assemblies		9/15/88	RW
	M) Iron Sight Alignment		9/15/88	RW
	N) Detach Front & Rear Sights & place in numbered container		9/15/88	RW
	O) Attach Scope to Rifle		10/5/88	RW
	P) Detach & Attach Scope 20 times		10-5-88	JS
640	Gallery Target & Test	44 R 111 L	10/11/88	DT.
	A) Optical Clarity of Scope		10/11/88	JU
645	Inspect for Live Ammo		10/11/88	JU
655	Final Inspection			
	A) Headspace		10-12-88	JS
	B) Trigger Pull		10-14-88	JS
	C) Function		10-12-88	JS
660	Pack		10-21-88	JS

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C-6225190

DATE 12-SEPT-88

TESTER JH W.B

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#	COMMENTS
PULL #1	2.46	2.19	2.41 2.75	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.50	2.22	2.38 2.90	
PULL #3	2.53	2.23	2.34 2.73	
PULL #4	2.49	2.37	2.38 2.59	
PULL #5	2.48	2.38	2.36 2.59	
TOTAL	12.46	11.39	11.87 13.56	
AVG.	2.49	2.28	2.374 2.712	

	3.00# INITIAL	3.00# AFTER 20 CYCLES	COMMENTS
PULL #1	3.34	3.25	
PULL #2	3.24	3.28	
PULL #3	3.26	3.28	
PULL #4	3.25	3.29	
PULL #5	3.25	3.24	
TOTAL	16.34	16.34	
AVG.	3.27	3.27	

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.26	4.21		4.29
PULL #2	4.26	4.27		4.32
PULL #3	4.21	4.28		4.32
PULL #4	4.21	4.27		4.32
PULL #5	4.24	4.31		4.34
TOTAL	21.18	21.34		21.59
AVG.	4.236	4.268		4.32

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 6225190

CENTROIDAL DISTANCES

Ø TO	1	1.56615
1 TO	2	.482296
1 TO	3	1.07802
1 TO	4	.496384
1 TO	5	.28526

+ <----POA

25

3

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: 1.212
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -1.0612
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: 1.61093
THE AMR FOR THIS RIFLE IS: .8698

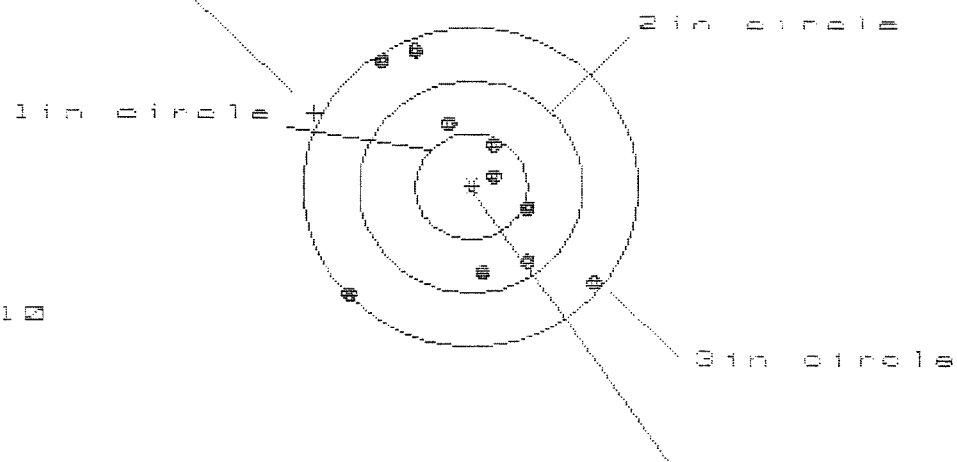
11 Oct 1968

FILE:/PATTERNING/CENTERFIRE_PATT/6225190

CENTERFIRE PATTERNS

1

FOR



OF SHOTS- 10

IN CIR

1in = 2

2in = 6

3in = 9

HS= 2.195

VS= 2.299

GS= 2.812

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.056	.930	.811
MINIMUM X	:	-1.139	-.953	-.714
MAXIMUM Y	:	1.300	1.189	1.327
MINIMUM Y	:	-.999	-.983	-.845
CENTROID X	:	1.403	1.529	1.648
CENTROID Y	:	-.696	-.585	-.723
FOR TO CENTROID in.	:	1.566	1.637	1.800
MIN RADIUS	:	.207	.060	.137
MEAN RADIUS	:	.931	.828	.735
MAX RADIUS	:	1.515	1.460	1.507
HORIZONTAL SPREAD	:	2.195	1.883	1.525
VERTICAL SPREAD	:	2.299	2.172	2.172
EXTREME SPREAD	:	2.812	2.812	2.654
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

11 Oct 1988

FILE:/PATTERNING/CENTERFIRE_PATT/B225180

CENTERFIRE PATTERNS

2

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS- 10

IN CIR

1 in = 2

2 in = 8

3 in = 10

HS= 1.724

VS= 2.210

GS= 2.270

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.050	1.104	1.005
MINIMUM X	:	-.674	-.620	-.482
MAXIMUM Y	:	1.299	.751	.756
MINIMUM Y	:	-.911	-.766	-.761
CENTROID X	:	1.023	.969	.831
CENTROID Y	:	-.993	-1.138	-1.143
POA TO CENTROID in.	:	1.426	1.494	1.413
MIN RADIUS	:	.285	.139	.096
MEAN RADIUS	:	.772	.668	.583
MAX RADIUS	:	1.389	1.105	1.059
HORIZONTAL SPREAD	:	1.724	1.724	1.487
VERTICAL SPREAD	:	2.210	1.517	1.517
EXTREME SPREAD	:	2.270	1.784	1.661
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	

11 Oct 1988

FILE://PATTERNING/CENTERFIRE_PATT/8225198

CENTERFIRE PATTERNS # 3

POA

1 in circle

2 in circle

3 in circle

OF SHOTS = 10

IN CIR

1 in = 3

2 in = 8

3 in = 10

HS = 1.919

VS = 2.241

GS = 2.442

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.076	1.067	1.095
MINIMUM X	:	-.843	-.723	-.695
MAXIMUM Y	:	1.201	1.086	.849
MINIMUM Y	:	-1.040	-.687	-.552
CENTROID X	:	1.337	1.217	1.189
CENTROID Y	:	-1.772	-1.657	-1.792
POA TO CENTROID in.	:	2.220	2.056	2.151
MIN RADIUS	:	.405	.335	.359
MEAN RADIUS	:	.808	.712	.643
MAX RADIUS	:	1.497	1.134	1.123
HORIZONTAL SPREAD	:	1.919	1.790	1.790
VERTICAL SPREAD	:	2.241	1.773	1.401
EXTREME SPREAD	:	2.442	1.813	1.813
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	

11 Oct 1988

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CENTERFIRE PATTERNS

4

POA

1in circle

2in circle

3in circle

CENTROID #

OF SHOTS - 10

IN CIR

1in = 2

2in = 4

3in = 8

HS = 3.037

VS = 2.113

GS = 3.135

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.462	1.287	.629
MINIMUM X	:	-1.575	-1.021	-.861
MAXIMUM Y	:	.935	1.024	1.038
MINIMUM Y	:	-1.178	-1.089	-1.075
CENTROID X	:	.937	1.112	.952
CENTROID Y	:	-.867	-.956	-.970
POA TO CENTROID in.	:	1.277	1.466	1.359
MIN RADIUS	:	.120	.095	.224
MEAN RADIUS	:	.972	.868	.814
MAX RADIUS	:	1.768	1.311	1.218
HORIZONTAL SPREAD	:	3.037	2.308	1.489
VERTICAL SPREAD	:	2.113	2.113	2.113
EXTREME SPREAD	:	3.135	2.341	2.341
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		9	

11 Oct 1988

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CENTERFIRE PATTERNS

5

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS = 10

IN CIR

1 in = 3

2 in = 4

3 in = 10

HS = 1.780

VS = 2.102

GS = 2.427

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.972	.883	.949
MINIMUM X	:	-.808	-.879	-.813
MAXIMUM Y	:	1.007	.886	.736
MINIMUM Y	:	-1.095	-1.193	-.820
CENTROID X	:	1.360	1.449	1.383
CENTROID Y	:	-.978	-.857	-.707
POA TO CENTROID in.	:	1.675	1.684	1.553
MIN RADIUS	:	.344	.211	.282
MEAN RADIUS	:	.866	.792	.734
MAX RADIUS	:	1.360	1.306	1.254
HORIZONTAL SPREAD	:	1.780	1.762	1.762
VERTICAL SPREAD	:	2.102	2.079	1.556
EXTREME SPREAD	:	2.427	2.427	2.283
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		10	