

C6225284

MODEL 700™ M24

Model **700 M24™**

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



M-24

Scope #

1782

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6225284

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

OVER

OP.#		READINGS	DATE	INITIAL
625 cont.	D) Oil Firing Pin Ass'y		11/2/88	RW
	E) Adjust Trigger Pull to Min. Setting and Stake		2 Nov 88	JS
	F) Safety on Force	4 4 4	2 Nov 88	JS
	G) Safety off Force	6 5 5.5	2 Nov 88	JS
	H) Trigger Pull Test & Retainability		2 Nov 88	JS
	I) Firing Pin Indent	.020 .0205 .020	2 Nov 88	JS
	J) Assemble Stock		11/8/88	RW
	K) Assemble Swivel Studs		29 Nov 88	JS
	L) Attach Front & Rear Sight Assemblies		11/8/88	RW
	M) Iron Sight Alignment		11/8/88	RW
	N) Detach Front & Rear Sights & place in numbered container		11/8/88	RW
	O) Attach Scope to Rifle		11/8/88	RW
	P) Detach & Attach Scope 20 times		8 Nov 88	JS
640	Gallery Target & Test	50 R 102 L	11/9/88	AC
	A) Optical Clarity of Scope	OK	11/9/88	AC
645	Inspect for Live Ammo	NONE	11/9/88	AC
655	Final Inspection			
	A) Headspace		29 Nov 88	JS
	B) Trigger Pull		29 Nov 88	JS
	C) Function		29 Nov 88	JS
660	Pack		15 Dec 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. C6225284

DATE 1 NOV 88

TESTER J. A. 40-8

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.57	2.64	2.72	2.51	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.52	2.69	2.55	2.47	
PULL #3	2.50	2.63	2.53	2.48	
PULL #4	2.49	2.68	2.56	2.47	
PULL #5	2.54	2.66	2.56	2.47	
TOTAL	12.62	13.30	12.92	12.40	
AVG.	2.524	2.66	2.584	2.48	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.22	3.23		
PULL #2	3.19	3.13		
PULL #3	3.24	3.08		
PULL #4	3.27	3.12		
PULL #5	3.21	3.10		
TOTAL	16.13	15.66		
AVG.	3.226	3.132		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.10	4.11		4.10
PULL #2	4.06	4.12		4.13
PULL #3	4.07	4.11		4.04
PULL #4	4.06	4.10		4.07
PULL #5	4.08	4.14		4.01
TOTAL	20.37	20.59		20.35
AVG.	4.074	4.118		4.07

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6225284

CENTROIDAL DISTANCES

0 TO	1	1.50255
1 TO	2	.4789
1 TO	3	.0991262
1 TO	4	.666473
1 TO	5	1.34382

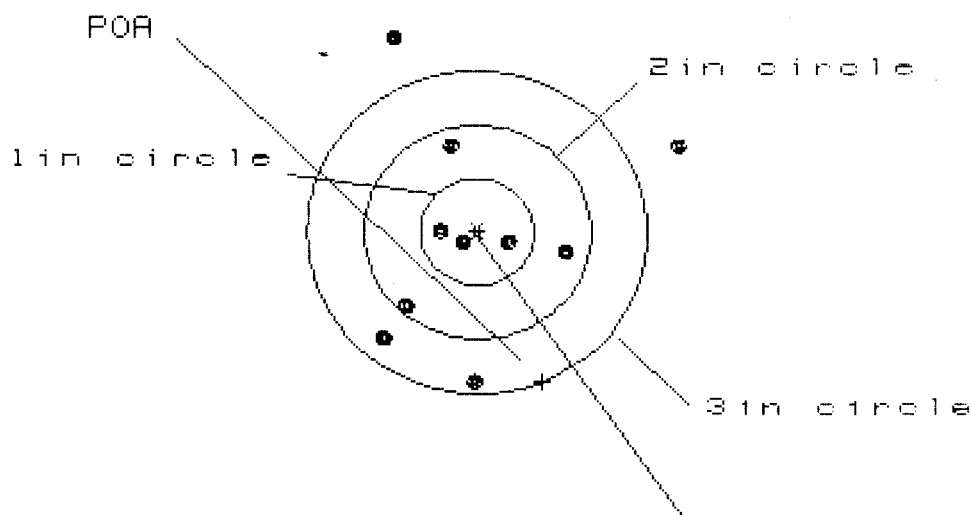
3 2
4
5 + <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.4948
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: 1.028
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: 1.14088
THE AMR FOR THIS RIFLE IS: .8906

18 May 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C62252B4

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

CENTROID *

IN CIR

1in = 3

2in = 6

3in = 8

HS= 2.548

VS= 3.193

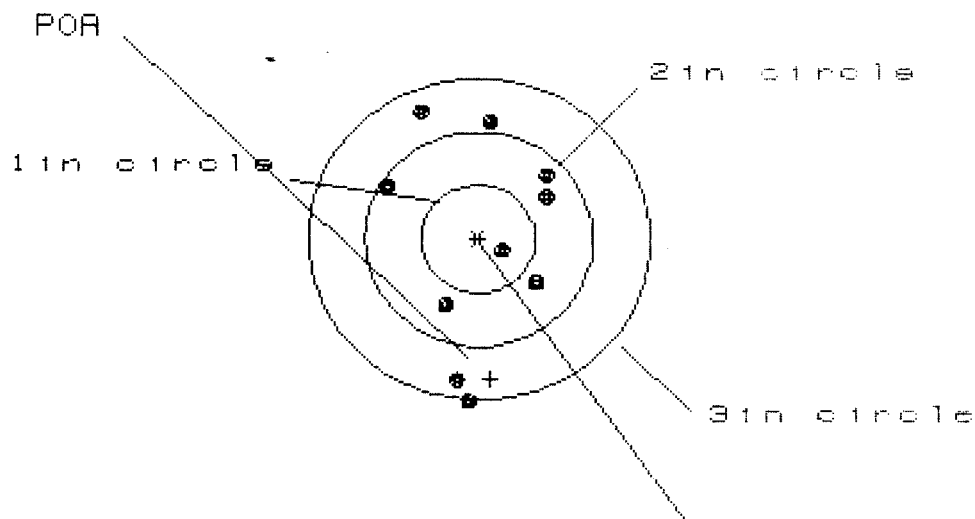
GS= 3.263

PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.763	1.686	.939
MINIMUM X	:	-.785	-.862	-.651
MAXIMUM Y	:	1.842	1.016	1.138
MINIMUM Y	:	-1.351	-1.147	-1.025
CENTROID X	:	-.573	-.496	-.707
CENTROID Y	:	1.389	1.185	1.063
POA TO CENTROID in.	:	1.503	1.284	1.277
MIN RADIUS	:	.164	.227	.270
MEAN RADIUS	:	.995	.878	.728
MAX RADIUS	:	1.967	1.945	1.144
HORIZONTAL SPREAD	:	2.548	2.548	1.590
VERTICAL SPREAD	:	3.193	2.163	2.163
EXTREME SPREAD	:	3.263	3.108	2.176
NUMBER IN ONE INCH CIRCLE =	:	3		
NUMBER IN TWO INCH CIRCLE =	:	6		
NUMBER IN THREE INCH CIRCLE =	:	8		

10 Nov 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C6225284

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 9

HS= 1.363

VS= 2.735

GS= 2.779

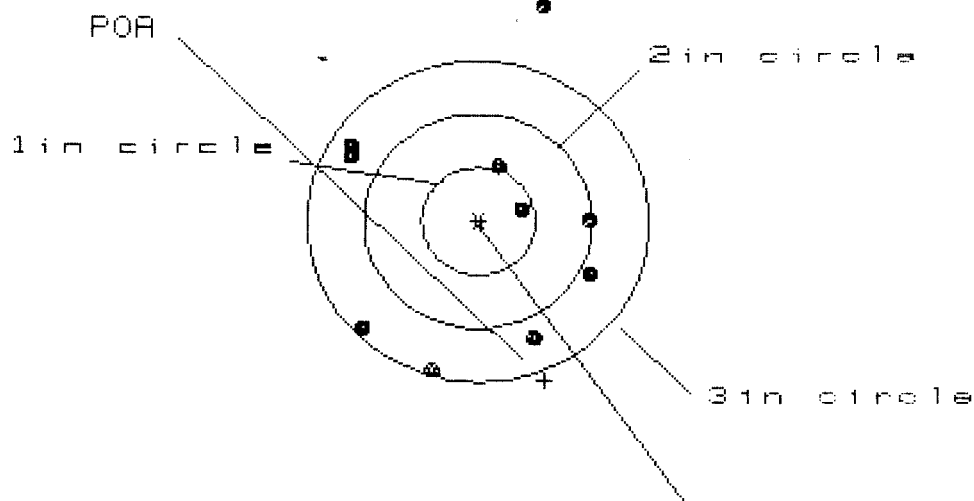
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.572	.566	.497
MINIMUM X	:	-.791	-.797	-.866
MAXIMUM Y	:	1.231	1.064	1.099
MINIMUM Y	:	-1.504	-1.485	-1.352
CENTROID X	:	-.101	-.095	-.026
CENTROID Y	:	1.308	1.475	1.342
POA TO CENTROID in.	:	1.312	1.478	1.342
MIN RADIUS	:	.253	.348	.205
MEAN RADIUS	:	.934	.863	.797
MAX RADIUS	:	1.505	1.498	1.378
HORIZONTAL SPREAD	:	1.363	1.363	1.363
VERTICAL SPREAD	:	2.735	2.549	2.451
EXTREME SPREAD	:	2.779	2.574	2.465
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

18 Nov 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C62252B4

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

CENTROID #

IN CIR

1in = 1

2in = 3

3in = 6

HS= 2.164

VS= 3.343

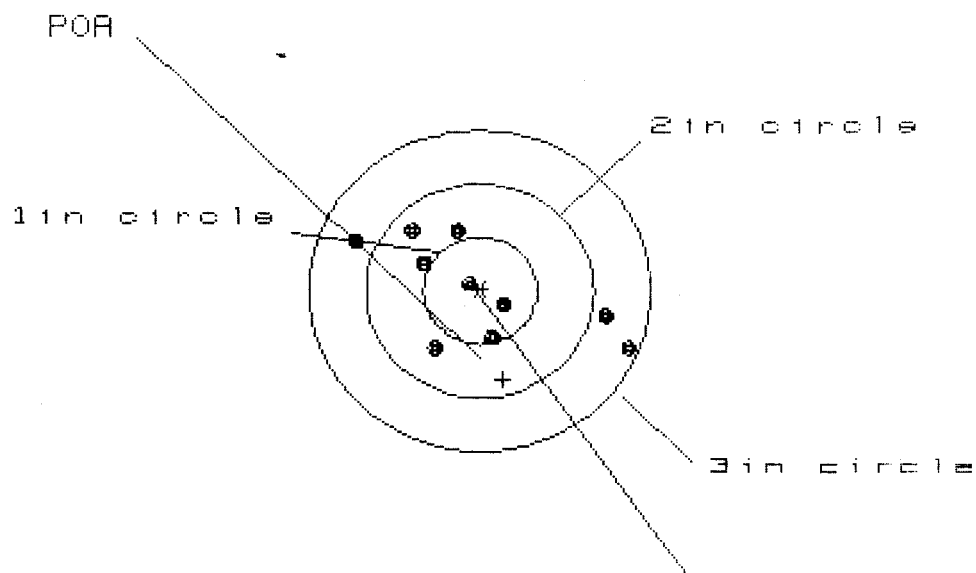
GS= 3.481

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.014	1.080	.962
MINIMUM X	:	-1.150	-1.084	-1.202
MAXIMUM Y	:	1.995	.951	.850
MINIMUM Y	:	-1.348	-1.127	-1.228
CENTROID X	:	-.578	-.644	-.526
CENTROID Y	:	1.488	1.267	1.368
POA TO CENTROID in.	:	1.597	1.421	1.466
MIN RADIUS	:	.389	.566	.411
MEAN RADIUS	:	1.169	1.073	1.017
MAX RADIUS	:	2.081	1.442	1.472
HORIZONTAL SPREAD	:	2.164	2.164	2.164
VERTICAL SPREAD	:	3.343	2.078	2.078
EXTREME SPREAD	:	3.481	2.483	2.483
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		9	

10 Nov 1988

FILE:/PATTERNING/CENTERFIRE_PATT/06225284

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 3

2in = 7

3in = 10

HS= 2.387

VS= 1.119

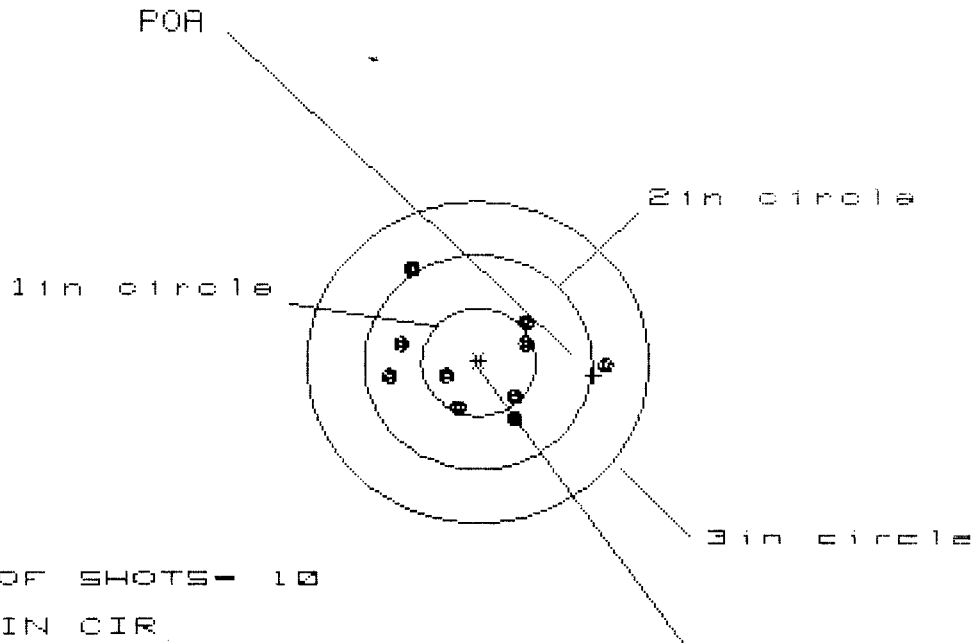
GS= 2.606

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.319	1.284	1.169
MINIMUM X	:	-1.068	-.922	-.563
MAXIMUM Y	:	.543	.479	.530
MINIMUM Y	:	-.576	-.589	-.538
CENTROID X	:	-.204	-.350	-.235
CENTROID Y	:	.834	.898	.847
POA TO CENTROID in.	:	.858	.964	.879
MIN RADIUS	:	.081	.080	.048
MEAN RADIUS	:	.700	.602	.545
MAX RADIUS	:	1.439	1.311	1.188
HORIZONTAL SPREAD	:	2.387	2.206	1.732
VERTICAL SPREAD	:	1.119	1.068	1.068
EXTREME SPREAD	:	2.606	2.305	1.879
NUMBER IN ONE INCH CIRCLE =			3	
NUMBER IN TWO INCH CIRCLE =			7	
NUMBER IN THREE INCH CIRCLE =			10	

10 Nov 1988

FILE:/PATTERNING/CENTERFIRE_PATT/062252B4

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in - 4

2in - 8

3in = 10

HS= 1.922

VS= 1.364

GS= 1.926

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.138	.574	.519
MINIMUM X	:	-.784	-.657	-.712
MAXIMUM Y	:	.829	.827	.523
MINIMUM Y	:	-.535	-.537	-.434
CENTROID X	:	-1.018	-1.145	-1.090
CENTROID Y	:	.121	.123	.020
POA TO CENTROID in.	:	1.025	1.151	1.090
MIN RADIUS	:	.337	.230	.238
MEAN RADIUS	:	.655	.592	.530
MAX RADIUS	:	1.138	.937	.736
HORIZONTAL SPREAD	:	1.922	1.231	1.231
VERTICAL SPREAD	:	1.364	1.364	.957
EXTREME SPREAD	:	1.926	1.605	1.254
NUMBER IN ONE INCH CIRCLE =			4	
NUMBER IN TWO INCH CIRCLE =			8	
NUMBER IN THREE INCH CIRCLE =			10	

RECEIVING AND ESTIMATING REPORT

COMMENTS

ORDER
R 94-24907

INITIAL
JJM

CUSTOMER ORDER NO.

M-24 SNIPER

DATE RECEIVED
08/29/94

DATE OPENED
08/30/94

DATE CODE
DI 9-88

SERIAL NUMBER
C6225284

NEW SERIAL NUMBER

MODEL AND GRADE

700 7.62

NATO

ACCESSORIES

SCOPE MNTS

SCOPE BASE

FROM:

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

WA 98433

SHIP TO:

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

WA

98433

CUST NO:062072 C.D.D.L

ACCOUNT NUMBER

ACCOUNT NUMBER N/C

WRITE ☐

PROM. DATE

ESTIMATED

VIA

UPS

GUN CONDITION

- ☐ NEW
☐ LIGHTLY WORN
☐ WORN
☐ VERY WORN
☐ UNREPAIRABLE
☐ MARRED

REPAIR CHARGE

EXCISE

TAX

INSURANCE

UPS

PARCEL POST

TOTAL

CUSTOMER CONCERN

AMMO

FUNCTION

FINISH

ACCURACY

FIT

INSPECT

CYCLE

A1

B1

TRIGGER GROUP

B2

E1

F1

BOLT ASSY.

B3

E2

F2

BARREL ASSY.

B4

D1

E3

F3

REC. ASSY.

B5

D2

E4

F4

WOOD

C1

D3

E5

F5

METAL

C2

MAIN FAULT

New Barrel

PARTS

COMMENTS

Barrel 96003

Repowder Coat Trigger Guard
HSSy, Front & Rear Sight Bases
Reticle Scope Base Rings &
Swivel Studs

REPAIRMAN

PROOF

CLEAN

TEST

TARGET

PATTERN

GALLERY TESTER

DATE

DATE

DATE

DATE

DATE

OFFICE COPY

RD6925 REV. 1/94

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

M2400012093

PACKING LIST		PACKED BY <i>Mr. Ray Fuller</i> WG-10 Bn. Armorer.	1. NO. BOXES <i>1</i>	2a. REQUISITION NO. <i>94242</i>	
				2b. ORDER NO.	
3. END ITEM <i>7.62mm M24 Sniper Weapons System (SW5)</i>			4. DATE <i>26 July 1994</i>		
			5. PAGE <i>1</i> OF <i>1</i> PAGES		
BOX NO. (a)	CONTENTS - STOCK NUMBER AND NOMENCLATURE (b)	UNIT OF ISSUE (c)	QUANTITIES REQUIRED		
			INITIAL OPERATION (d)	RUNNING SPARES (e)	TOTAL (f)
	<i>7.62mm M24 Sniper Weapon System (SW5) Serial No. C6225284</i> <i>NSN: 1005-01-240-2136</i> <i>Note: All Optic Scope Ring mounts Packed</i>	<i>Fa</i>			<i>1</i>
6. THIS CERTIFIES THAT ITEMS LISTED HEREON ARE WITHIN THE SPECIFIED BOXES					
TYPED NAME AND TITLE			SIGNATURE		
<i>Ray Fuller WG-10 Bn. Armorer</i>			<i>Ray Fuller</i>		

DD FORM 1750
1 SEP 70

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

M2400012094

MAINTENANCE REQUEST				PAGE NO <i>1</i>	NO OF PAGES	REQUIREMENTS CONTROL SYMBOL CSGLD - 1047(R1)			
For use of this form, see DA PAM 738-750; the proponent agency is DCSLOG									
SECTION I - EQUIPMENT DATA									
CONTROL NUMBER		WORK ORDER NO. <i>94242</i>		WESDC		ORG. PD <i>02</i>		PD AUTHENTICATION <i>[Signature]</i>	
☒ Work Request ☐ MWO ☐ Warranty Claim		1A. ORGANIZATION <i>Bn Arms HHC</i> <i>2/75 Rgr Rgt.</i>		B. LOCATION <i>Fort Lewis Wa</i>			C. UNIT IDENT. CODE <i>WH3MFA</i>		
2. SERIAL NO. <i>C6225284</i>		3. NOUN NOMENCLATURE <i>07245WS</i>		4. LINE NO.		5. MODEL <i>0724</i>		6. NATIONAL STOCK NUMBER <i>1005-01-240-2136</i>	
7A. MAINTENANCE ACTIVITY <i>Remington Arms Co.</i>		B. LEVEL		8. UTILIZATION CODE		9A. MCSR ITEM		9B. ERC	
14. FAILURE DETECTED DURING (Select one - use ☒ or X)		15. FIRST INDICATION OF TROUBLE (Select one - use ☒ or X)							
☐ A Sch. Main. ☐ B Handling		☒ C Test ☐ D Normal Op		☐ E Storage ☐ F Inspection		☐ G Flight ☐ H Other		☐ 068 Inoperative ☐ 008 Noisy	
								☐ 258 Overheating ☐ 387 Low Performance	
								☐ 790 Out of Adjustment ☒ Other	
16A. DESCRIBE DEFICIENCIES OR SYMPTOMS ON THE BASIS OF COMPLETE CHECKOUT AND DIAGNOSTIC PROCEDURE IN EQUIPMENT TM (Do not prescribe repairs).									
<i>This weapon has fired over 10,000 Rds. During Bench Rest Test Fire at 200/300 Yds, groups were shot exceeding the criteria of 2.6" at 200 to 3.8" at 300 Yds. (5-10 Shot Groups)</i>									
<i>The action was provided us by Mr Jim Glenn ARDCE USN SPN-7071</i>									
B. REMARKS <i>Request ReBarreling and Complete Weapon Reconditioning</i>									
SECTION II - WORK ACCOMPLISHED									
17A. REPAIR ORGANIZATION/ACTIVITY				C. UNIT IDENT. CODE		18. TYPE ORGANIZATION/ACTIVITY ACCOMPLISHING WORK (Select one - use ☒ or X)		19. AMS ACCT. CODE	
B. LOCATION						☐ 1 TOE ☐ 2 TD ☐ 3 Contractor			
20A. ACT. CODE	B. FAILURE CODE	C. COMPONENT/PART NOUN, SVC, OR MWO NO.			D. MANHOURS (Hrs. & tenths)	E. NATIONAL STOCK NUMBER	F. PART SOURCE CODE	G. QTY.	H. PARTS COST
		(1) CB CODE	(2) REF DESIGN.	(3) MFR. CODE					
					.				\$
					.				\$
					.				\$
					.				\$
					.				\$
					.				\$
					.				\$
					.				\$
					.				\$
					.				\$
					.				\$
					.				\$
					.				\$
I. TOTAL MANHOURS					J. TOTAL MANHOURS COST		K. TOTAL PARTS COST		
					\$		\$		
21. DELAY (Select One)									
☐ 1 Parts ☐ 2 Manpower ☐ 3 Facilities ☐ 4 Funds ☐ 5 Tools									
23. SUBMITTED BY <i>Ray Fuller</i>		24. RECEIVED BY		25. WORK STARTED BY		26. INSPECTED BY		27. ACCEPTED BY	
JULIAN DATE <i>4235</i>		JULIAN DATE		JULIAN DATE		JULIAN DATE		JULIAN DATE	
28. DISPOSITION (Select One)									
☐ A To User ☐ B To Stock ☐ C Salvaged									
☐ D Evacuated ☐ E Cannibalization									

DA FORM 2407, AUG 88

EDITION OF MAY 81 MAY BE USED

NMP COPY 2

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

M2400012095

Final Inspection

Sn: C6275284 | DATE REC'D: 8/29/94 | 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: _____

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6225284
15 Sep 1994

CENTROIDAL DISTANCES

0 TO	1	.230326
1 TO	2	.118127
1 TO	3	.116966
1 TO	4	.557918
1 TO	5	.355563

50g <----POA

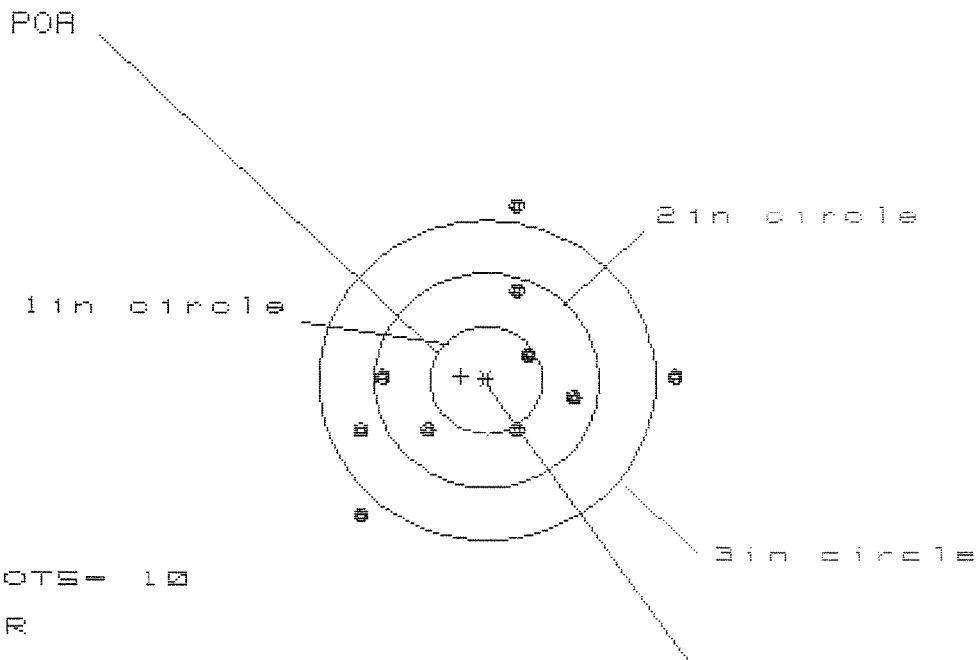
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0222
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0178
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0284549

THE AMR FOR THIS RIFLE IS: .9532

15 Sep 1994

FILE:/PATTERNING/CENTERFIRE_PATT/C82252B4

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1in = 2

2in = 5

3in = 7

HS= 2.833

VS= 2.824

GS= 3.169

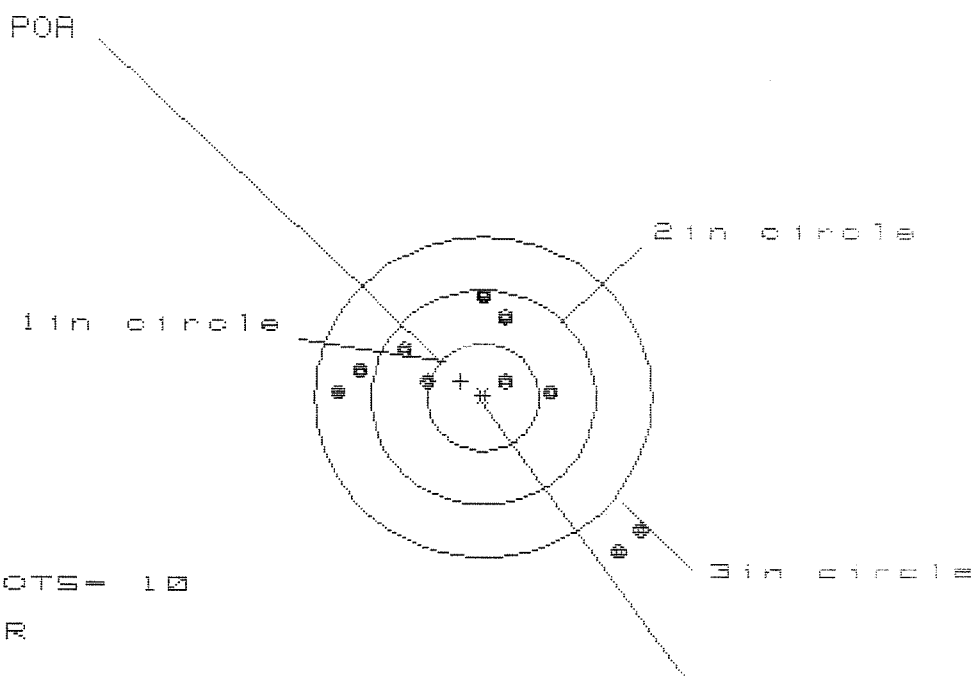
CENTROID *

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.700	.951	.833
MINIMUM X	:	-1.133	-.945	-1.014
MAXIMUM Y	:	1.599	1.599	1.446
MINIMUM Y	:	-1.225	-1.225	-.614
CENTROID X	:	.227	.039	.157
CENTROID Y	:	-.039	-.039	.114
POA TO CENTROID in.	:	.231	.055	.194
MIN RADIUS	:	.430	.549	.423
MEAN RADIUS	:	1.028	.950	.868
MAX RADIUS	:	1.700	1.674	1.494
HORIZONTAL SPREAD	:	2.833	1.896	1.847
VERTICAL SPREAD	:	2.824	2.824	2.060
EXTREME SPREAD	:	3.169	3.169	2.448
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		7	

15 Sep 1994

FILE:/PATTERNING/CENTERFIRE_PATT/062252B4

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1in = 1

2in = 6

3in = 3

HS= 2.708

VS= 2.405

GS= 3.003

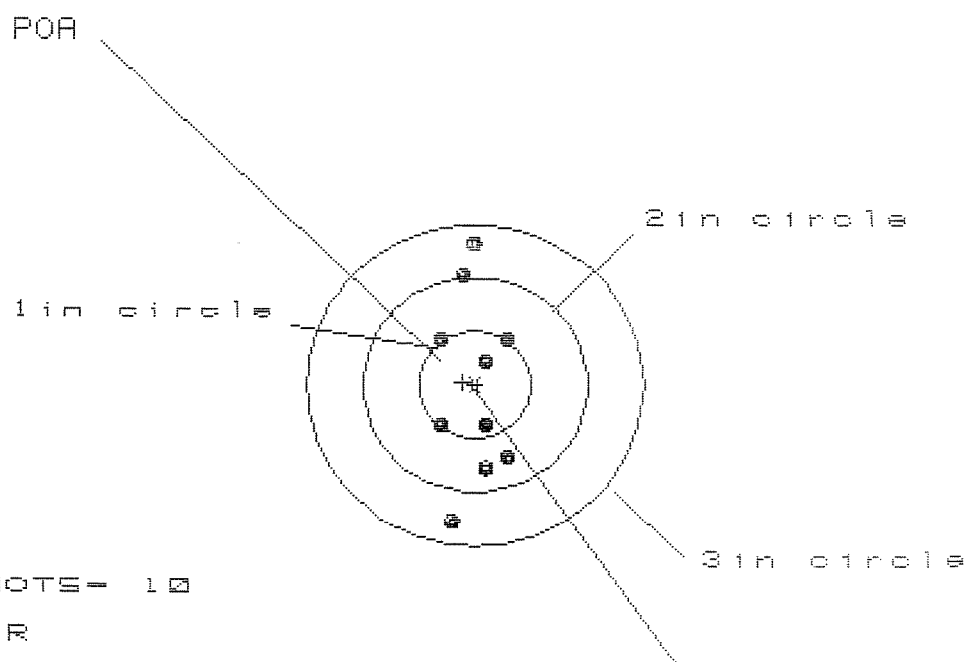
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.395	1.323	.936
MINIMUM X	:	-1.313	-1.158	-.992
MAXIMUM Y	:	.948	.807	.607
MINIMUM Y	:	-1.457	-1.598	-.322
CENTROID X	:	.200	.045	-.121
CENTROID Y	:	-.154	-.013	.187
POA TO CENTROID in.	:	.252	.047	.222
MIN RADIUS	:	.271	.343	.256
MEAN RADIUS	:	1.014	.870	.671
MAX RADIUS	:	1.888	2.075	1.041
HORIZONTAL SPREAD	:	2.708	2.481	1.929
VERTICAL SPREAD	:	2.405	2.405	.929
EXTREME SPREAD	:	3.003	2.891	1.929
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

15 Sep 1994

FILE:/PATTERNING/CENTERFIRE_PATT/C8225264

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 3

2in = 7

3in = 10

HS= .647

VS= 2.615

GS= 2.624

CENTROID #

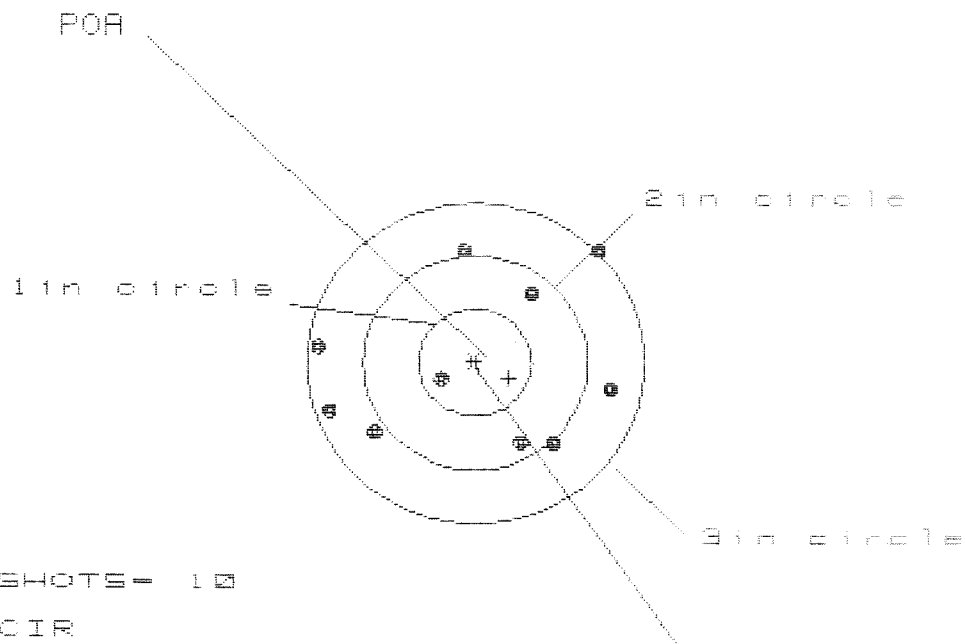
PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.322	.325	.383
MINIMUM X	:	-.325	-.322	-.344
MAXIMUM Y	:	1.360	1.187	1.050
MINIMUM Y	:	-1.255	-1.104	-.759
CENTROID X	:	.111	.108	.130
CENTROID Y	:	-.024	-.175	-.038
POA TO CENTROID in.	:	.113	.206	.136
MIN RADIUS	:	.299	.249	.303
MEAN RADIUS	:	.737	.652	.592
MAX RADIUS	:	1.361	1.191	1.056
HORIZONTAL SPREAD	:	.647	.647	.647
VERTICAL SPREAD	:	2.615	2.291	1.888
EXTREME SPREAD	:	2.624	2.293	1.814
NUMBER IN ONE INCH CIRCLE =			3	
NUMBER IN TWO INCH CIRCLE =			7	
NUMBER IN THREE INCH CIRCLE =			10	

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CENTERFIRE PATTERNS

4



OF SHOTS= 10

IN CIR

1in = 1

2in = 3

3in = 6

HS= 2.634

VS= 1.880

GS= 2.818

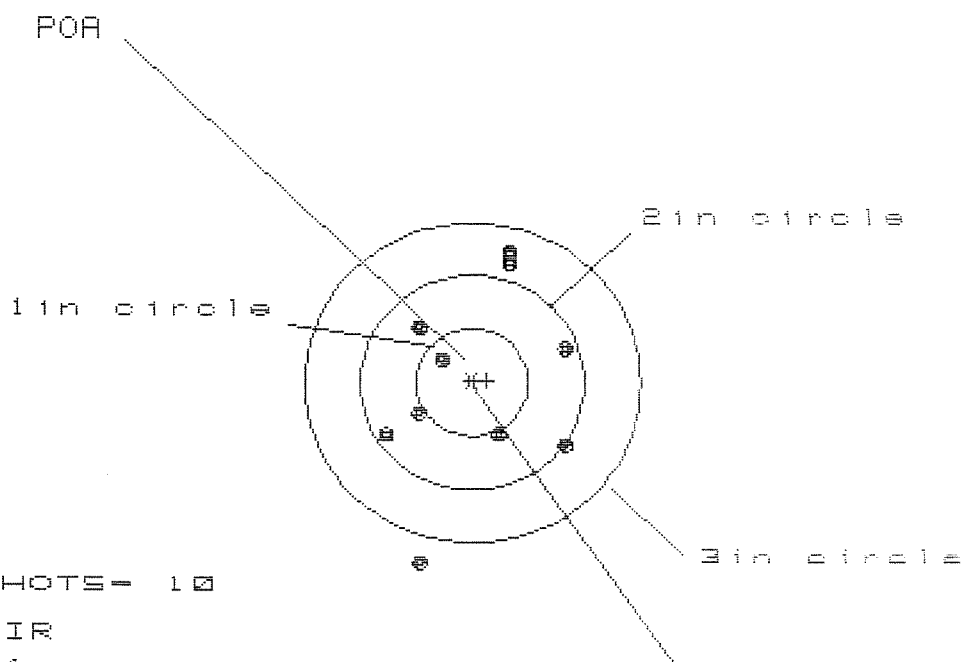
CENTROID #

PATTERN #	4		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.230	1.356	1.196
MINIMUM X	-1.404	-1.278	-1.335
MAXIMUM Y	1.101	1.215	1.251
MINIMUM Y	-.778	-.665	-.629
CENTROID X	-.299	-.425	-.265
CENTROID Y	.147	.033	-.003
POA TO CENTROID in.	.333	.426	.265
MIN RADIUS	.302	.142	.297
MEAN RADIUS	1.089	1.018	.978
MAX RADIUS	1.521	1.358	1.360
HORIZONTAL SPREAD	2.634	2.634	2.531
VERTICAL SPREAD	1.880	1.880	1.880
EXTREME SPREAD	2.818	2.661	2.540
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	3		
NUMBER IN THREE INCH CIRCLE =	9		

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 1

2in = 7

3in = 9

HS= 1.620

VS= 2.880

GS= 2.968

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.815	.767	.797
MINIMUM X	:	-.806	-.853	-.823
MAXIMUM Y	:	1.246	1.064	1.027
MINIMUM Y	:	-1.634	-.722	-.589
CENTROID X	:	-.128	-.080	-.110
CENTROID Y	:	-.019	.163	.030
POA TO CENTROID in.	:	.129	.181	.114
MIN RADIUS	:	.378	.334	.361
MEAN RADIUS	:	.898	.800	.752
MAX RADIUS	:	1.689	1.092	1.066
HORIZONTAL SPREAD	:	1.620	1.620	1.620
VERTICAL SPREAD	:	2.880	1.786	1.616
EXTREME SPREAD	:	2.968	2.034	1.900
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

M-24

CONTRACT # DAAA21-87-C-0086

New Barrel

GUN SERIAL # C 6225284

OP. #	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and Stock		9/1/94	RW
600	Proof		9/1/94	RW
607	Check Headspace		9/1/94	RW
610	Dis-assemble Gun		9/1/94	RW
612	Magnaflux Barrel Action			
	Magnaflux Bolt			
615	Rollmark Caliber			
617	Drill and Tap Sight Holes			
618	Polish Barrel			
620	Apply Coatings (Barrel Action)			
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		9/13/94	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		9/13/94	RW
	C) Inspect Ejector Hole for Chamfer		9/13/94	RW
	D) Oil Firing Pin Ass'y		9/13/94	RW
	E) Adjust Trigger Pull to Min Setting and Stake		9/13/94	RW

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						9/13 OK	WB
	A) Time						9/13	WB
	B) Malfunctions						9/13 OK	WB
	C) Pierced Primers						9/13 OK	WB
	D) Optical Clarity of Scope						9/13 OK	WB
645	Inspect for Live Ammo						9/13/94	RW
655	Final Inspection							
	A) Headspace						9/14/94	RW
	B) Trigger Pull	2.90	2.89	2.92	2.85	2.94	9/14/94	RW
	C) Function						9/14/94	RW
660	Pack							