

C6348746

MODEL 700TM M24

Model **SWS** TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington.

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6348746

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	10-9	89	RW
600	Proof	10-9	89	AC
607	Check Headspace	10-9	89	RW
610	Dis-assemble Gun	10-9	89	RW
612	Magnaflux Barrel Action	10/13/89		KCR
	Magnaflux Bolt	10/13/89		KCR
615	Rollmark Caliber			
7	Drill and Tap Sight Holes	10 1689		LB
618	Polish Barrel RB	10 1689		BT
620	Apply Coatings (Barrel Action)		10-27-89	JJA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		10/30/89	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/30/89	RW
	C) Inspect Ejector Hole for Chamfer		10/30/89	RW
	D) Oil Firing Pin Ass'y		10/30/89	RW
	E) Adjust Trigger Pull to Min Setting and Stake		11-3-89	GM

op. #	OP. NAME	READINGS			DATE	INIT
625 cont.	F) Safety On Force	4	4	4	11/6/89	JA
	G) Safety Off Force	3	3	3	11/6/89	JA
	H) Trigger Pull Test & Retainability				11-3-89	JA
	I) Firing Pin Indent	.020	.0205	.0205	11/6/89	JA
	J) Assemble Stock				11/6/89	RW
	K) Assemble Swivel Studs				11/6/89	JA
	L) Attach Front and Rear Sight Assemblies				11/6/89	RW
	M) Iron Sight Alignment				11/6/89	RW
	N) Detach Front & Rear Sights & place in numbered container				11/6/89	RW
	O) Attach Scope to Rifle				11-7-89	JA
	P) Detach & Attach Scope 20 Times				11-7-89	JA
640	Gallery Target & Test				11-8-89	JA
	A) Time				11-8-89	JA
	B) Malfunctions				11-8-89	JA
	C) Pierced Primers				11-8-89	JA
	D) Optical Clarity of Scope				11-8-89	JA
645	Inspect for Live Ammo				11-8-89	JA
655	Final Inspection					
	A) Headspace				10/15/89	JA
	B) Trigger Pull	2.10	2.29	2.21	10/15/89	JA
	C) Function				10/15/89	JA
660	Pack				15/11/89	JA

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#
3.00# + .75#
4.00# + 1.00#

SERIAL NO. C6348746

DATE 3-27-90

TESTER J28

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.51	2.47		2.27	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.32	2.51		2.38	
PULL #3	2.42	2.47		2.30	
PULL #4	2.42	2.49		2.42	
PULL #5	2.53	2.33		2.41	
TOTAL	12.20	12.27		11.78	
AVG.	2.44	2.454		2.356	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.49	3.41		
PULL #2	3.40	3.43		
PULL #3	3.42	3.44		
PULL #4	3.45	3.38		
PULL #5	3.43	3.47		
TOTAL	17.17	17.13		
AVG.	3.434	3.426		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.32	4.35		
PULL #2	4.41	4.38		
PULL #3	4.27	4.28		
PULL #4	4.29	4.34		
PULL #5	4.46	4.29		
TOTAL	21.75	21.64		
AVG.	4.35	4.328		

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06348746
8 Nov 1989

CENTROIDAL DISTANCES

0 TO	1	.600384
1 TO	2	.294389
1 TO	3	.230413
1 TO	4	.349425
1 TO	5	.548977

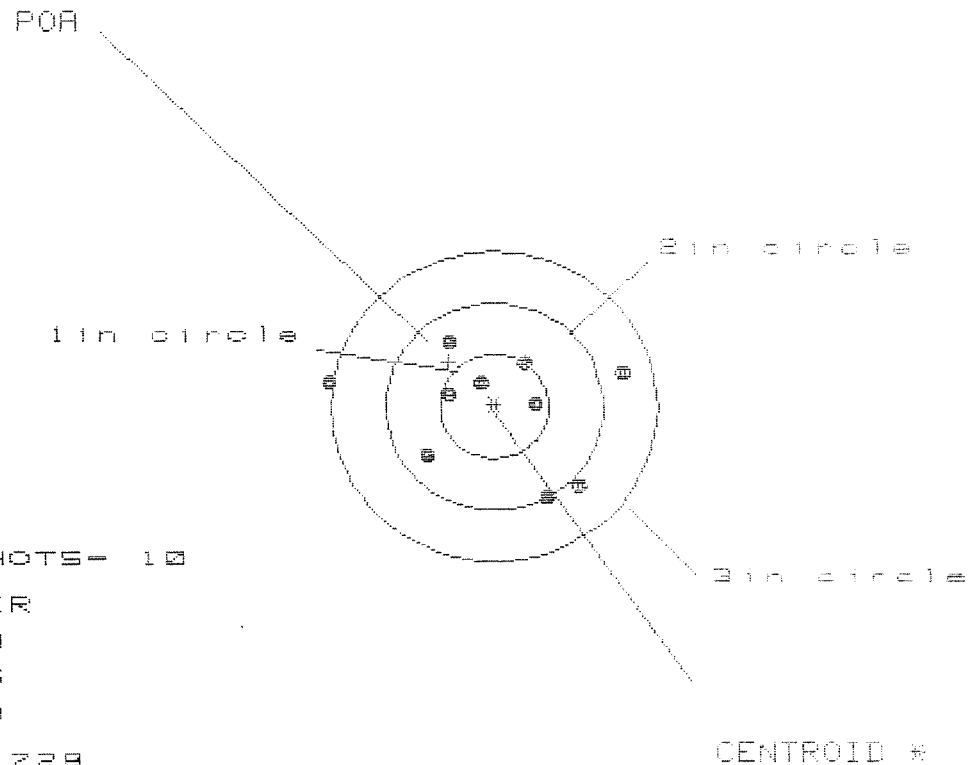
$\frac{1}{5}$ (----POI
5

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .2946
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.2578
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .391472
THE AMR FOR THIS RIFLE IS: .923

8 Nov 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C6348746

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 6

3 in = 9

HS= 2.728

VS= 1.545

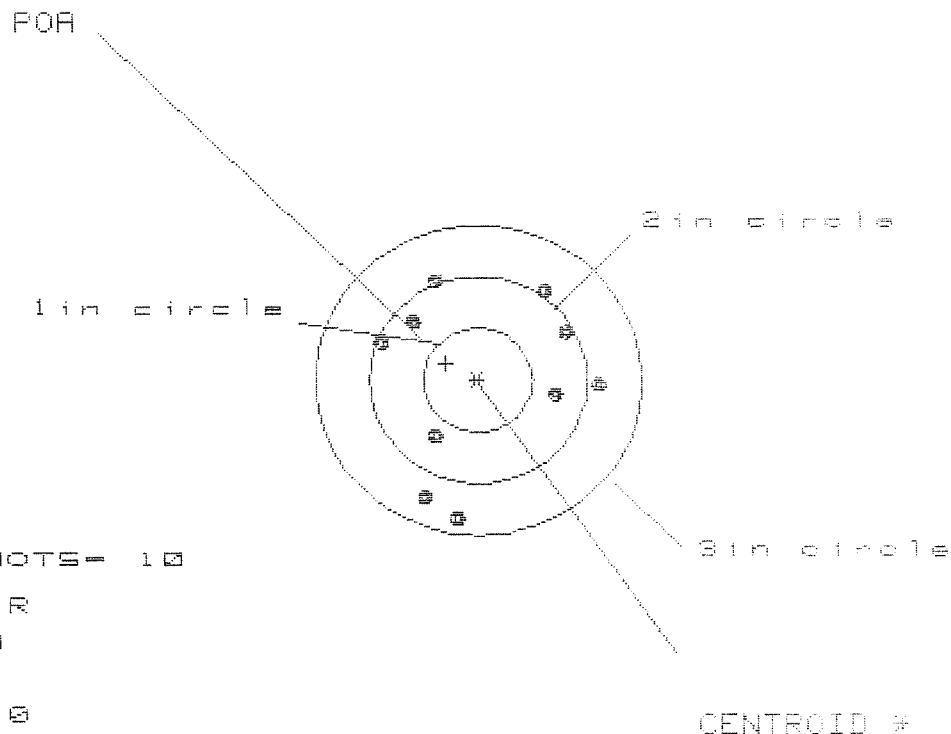
GS= 2.730

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.173	1.000	.696
MINIMUM X	-1.555	-.832	-.707
MAXIMUM Y	.679	.707	.754
MINIMUM Y	-.866	-.838	-.791
CENTROID X	.419	.592	.467
CENTROID Y	-.430	-.458	-.505
POA TO CENTROID in.	.601	.749	.688
MIN RADIUS	.216	.268	.305
MEAN RADIUS	.811	.721	.674
MAX RADIUS	1.576	1.068	.979
HORIZONTAL SPREAD	2.728	1.832	1.403
VERTICAL SPREAD	1.545	1.545	1.545
EXTREME SPREAD	2.730	1.991	1.840
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	9		

B Nov 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C8348746

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1 in = 0

2 in = 4

3 in = 10

HS= 2.016

VS= 2.298

GS= 2.383

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.072	1.049	.986
MINIMUM X	:	-.944	-.967	-1.030
MAXIMUM Y	:	.957	.808	.650
MINIMUM Y	:	-1.341	-1.271	-.847
CENTROID X	:	.295	.318	.381
CENTROID Y	:	-.163	-.014	.144
POA TO CENTROID in.	:	.337	.318	.408
MIN RADIUS	:	.672	.700	.696
MEAN RADIUS	:	.985	.929	.855
MAX RADIUS	:	1.356	1.368	1.052
HORIZONTAL SPREAD	:	2.016	2.016	2.016
VERTICAL SPREAD	:	2.298	2.079	1.497
EXTREME SPREAD	:	2.383	2.294	2.053
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		10	

8 Nov 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C6348746

CENTERFIRE PATTERNS

3

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS- 10

IN CIR

1 in = 3

2 in = 7

3 in = 10

HS= 2.195

VS= 2.041

GS= 2.271

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.897	.753	.795
MINIMUM X	:	-1.298	-.571	-.529
MAXIMUM Y	:	1.147	1.137	1.025
MINIMUM Y	:	-.894	-.904	-.762
CENTROID X	:	.310	.454	.412
CENTROID Y	:	-.633	-.623	-.765
POA TO CENTROID in.	:	.704	.771	.869
MIN RADIUS	:	.178	.194	.052
MEAN RADIUS	:	.796	.735	.658
MAX RADIUS	:	1.301	1.184	1.039
HORIZONTAL SPREAD	:	2.195	1.324	1.324
VERTICAL SPREAD	:	2.041	2.041	1.787
EXTREME SPREAD	:	2.271	2.150	1.849
NUMBER IN ONE INCH CIRCLE =			3	
NUMBER IN TWO INCH CIRCLE =			7	
NUMBER IN THREE INCH CIRCLE =			10	

8 Nov 1989

FILE:/PATTERNING/CENTERFIRE_PATT/08348746

CENTERFIRE PATTERNS

4

POA

1 in circle

2 in circle

3 in circle

CENTROID #

OF SHOTS- 10

IN CIR

1 in = 1

2 in = 5

3 in = 9

HS= 2.310

VS= 2.205

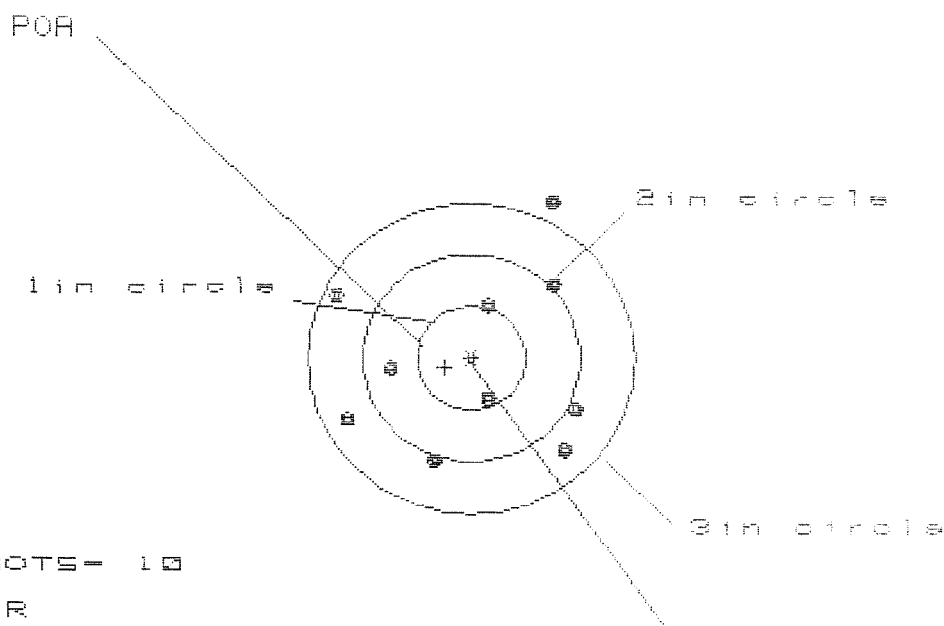
GS= 2.844

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.155	1.037	1.114
MINIMUM X	:	-1.155	-1.273	-1.196
MAXIMUM Y	:	1.167	1.175	1.061
MINIMUM Y	:	-1.038	-1.908	-1.747
CENTROID X	:	.206	.324	.247
CENTROID Y	:	-.153	-.283	-.169
POA TO CENTROID in.	:	.256	.430	.299
MIN RADIUS	:	.212	.294	.203
MEAN RADIUS	:	.978	.894	.863
MAX RADIUS	:	1.579	1.298	1.204
HORIZONTAL SPREAD	:	2.310	2.310	2.310
VERTICAL SPREAD	:	2.205	2.083	1.808
EXTREME SPREAD	:	2.844	2.357	2.357
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

8 Nov 1989

FILE:/PATTERNING/CENTERFIRE_PATT/08348746

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 3

3 in = 9

HS= 2.228

VS= 2.491

GS= 2.802

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.941	1.020	.869
MINIMUM X	:	-1.287	-1.208	-1.245
MAXIMUM Y	:	1.523	.867	.961
MINIMUM Y	:	-.968	-.798	-.705
CENTROID X	:	.243	.164	.315
CENTROID Y	:	.090	-.080	-.173
POA TO CENTROID in.	:	.259	.183	.360
MIN RADIUS	:	.383	.294	.119
MEAN RADIUS	:	1.045	.956	.870
MAX RADIUS	:	1.681	1.423	1.278
HORIZONTAL SPREAD	:	2.228	2.228	2.114
VERTICAL SPREAD	:	2.491	1.665	1.665
EXTREME SPREAD	:	2.802	2.611	2.302
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		9	

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6348746
8 Dec 1989

CENTROIDAL DISTANCES

0 TO	1	.238891
1 TO	2	.970341
1 TO	3	.553686
1 TO	4	.364179
1 TO	5	.826814

5 4 2 <----POA

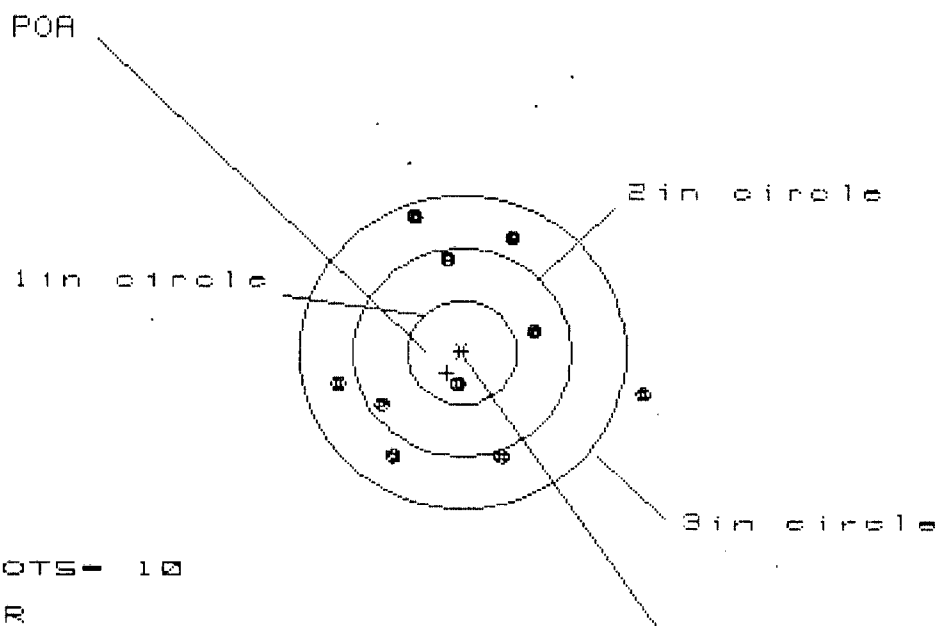
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0298
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1896
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .191928

THE AMR FOR THIS RIFLE IS: .9358

8 Dec 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C634B746.1

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 1

2in = 4

3in = 9

HS= 2.772

VS= 2.243

GS= 2.774

CENTROID #

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.639	.842	.815
MINIMUM X	:	-1.133	-.951	-.978
MAXIMUM Y	:	1.269	1.230	1.177
MINIMUM Y	:	-.974	-1.023	-.870
CENTROID X	:	.138	-.044	-.017
CENTROID Y	:	.195	.244	.091
POA TO CENTROID in.	:	.239	.248	.093
MIN RADIUS	:	.249	.325	.180
MEAN RADIUS	:	1.027	.947	.882
MAX RADIUS	:	1.696	1.240	1.307
HORIZONTAL SPREAD	:	2.772	1.793	1.793
VERTICAL SPREAD	:	2.243	2.243	2.047
EXTREME SPREAD	:	2.774	2.343	2.287
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		9	

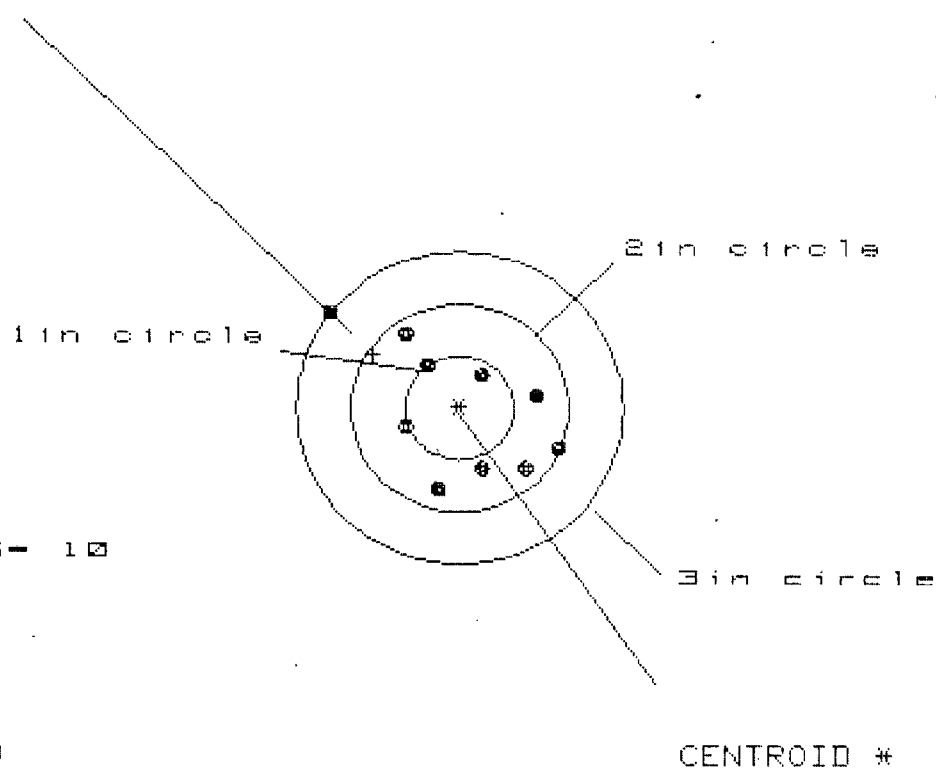
8 Dec 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C634B746.1

CENTERFIRE PATTERNS

2

POA



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 9

3 in = 10

HS= 2.068

VS= 1.607

GS= 2.413

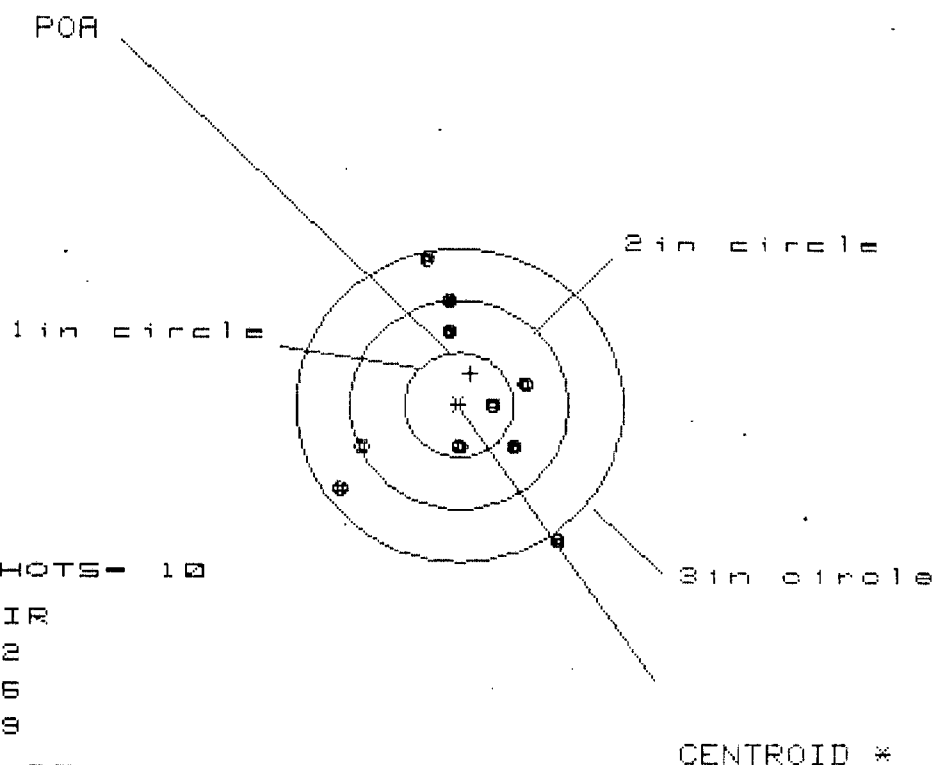
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.924	.797	.628
MINIMUM X	:	-1.144	-.640	-.541
MAXIMUM Y	:	.873	.804	.770
MINIMUM Y	:	-.734	-.637	-.671
CENTROID X	:	.794	.921	.822
CENTROID Y	:	-.520	-.617	-.583
POA TO CENTROID in.	:	.949	1.109	1.008
MIN RADIUS	:	.383	.410	.418
MEAN RADIUS	:	.752	.659	.633
MAX RADIUS	:	1.439	1.028	.941
HORIZONTAL SPREAD	:	2.068	1.437	1.169
VERTICAL SPREAD	:	1.607	1.441	1.441
EXTREME SPREAD	:	2.413	1.796	1.679
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		9	
NUMBER IN THREE INCH CIRCLE	=		10	

8 Dec 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C6348746.1

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 6

3 in = 9

HS= 1.981

VS= 2.745

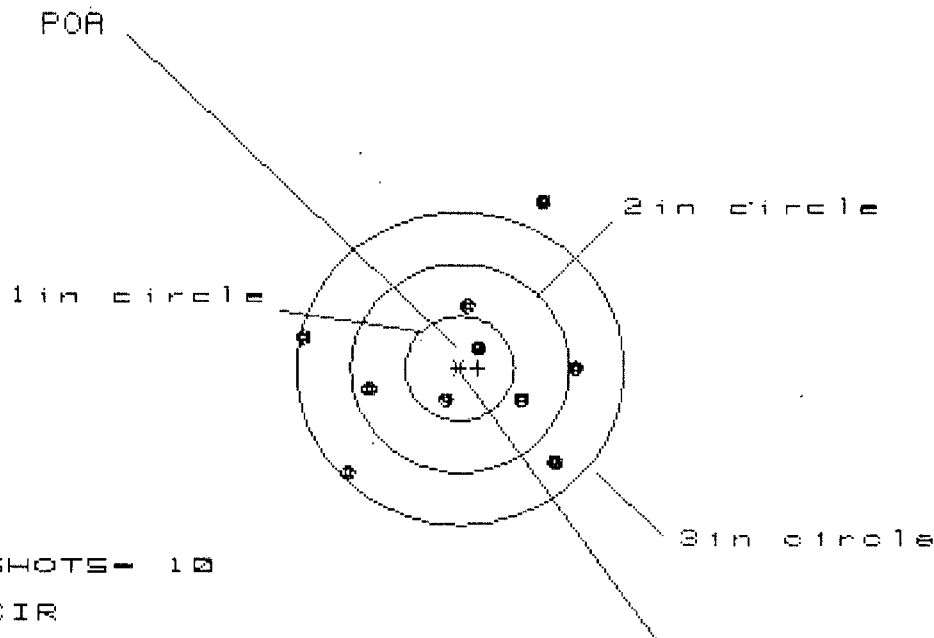
GS= 2.994

PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	.925
MINIMUM X	-1.056
MAXIMUM Y	1.406
MINIMUM Y	-1.339
CENTROID X	-.104
CENTROID Y	-.303
POA TO CENTROID in.	.320
MIN RADIUS	.331
MEAN RADIUS	.898
MAX RADIUS	1.628
HORIZONTAL SPREAD	1.981
VERTICAL SPREAD	2.745
EXTREME SPREAD	2.994
NUMBER IN ONE INCH CIRCLE	2
NUMBER IN TWO INCH CIRCLE	6
NUMBER IN THREE INCH CIRCLE	9

8 Dec 1989

FILE:/PATTERNING/CENTERFIRE_PATT/06348746.1

CENTERFIRE PATTERNS # 4



OF SHOTS - 10

IN CIR

1 in = 2

2 in = 5

3 in = 9

HS = 2.556

VS = 2.655

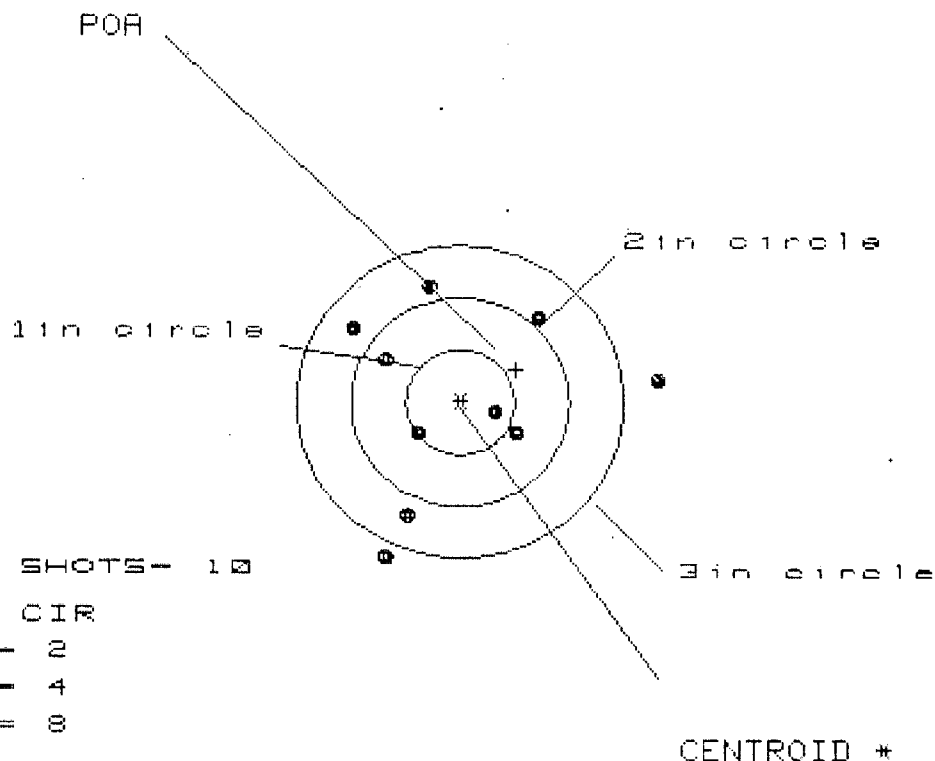
GS = 3.201

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.095	1.182	1.010
MINIMUM X	:	-1.461	-1.374	-1.086
MAXIMUM Y	:	1.632	.783	.846
MINIMUM Y	:	-1.023	-.842	-.779
CENTROID X	:	-.167	-.254	-.082
CENTROID Y	:	-.004	-.185	-.248
POA TO CENTROID in.	:	.167	.314	.261
MIN RADIUS	:	.238	.146	.260
MEAN RADIUS	:	.980	.879	.798
MAX RADIUS	:	1.812	1.462	1.336
HORIZONTAL SPREAD	:	2.556	2.556	2.096
VERTICAL SPREAD	:	2.655	1.625	1.625
EXTREME SPREAD	:	3.201	2.627	2.314
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

8 Dec 1989

FILE:/PATTERNING/CENTERFIRE_PATT/06348746.1

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 2

2in = 4

3in = 8

HS= 2.772

VS= 2.623

GS= 3.027

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.834	.900	.842
MINIMUM X	-.938	-.734	-.792
MAXIMUM Y	1.145	1.170	.988
MINIMUM Y	-1.478	-1.453	-1.252
CENTROID X	-.512	-.716	-.658
CENTROID Y	-.316	-.341	-.159
POA TO CENTROID in.	.602	.793	.677
MIN RADIUS	.326	.327	.514
MEAN RADIUS	1.022	.918	.838
MAX RADIUS	1.848	1.526	1.286
HORIZONTAL SPREAD	2.772	1.634	1.634
VERTICAL SPREAD	2.623	2.623	2.240
EXTREME SPREAD	3.027	2.710	2.264
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		4	
NUMBER IN THREE INCH CIRCLE =		8	

MOD. M-24 GA. CAL. 7.62 ^{C6348746}
 # GUN #

# TEST	DATE	MALFUNCTION/DEFECT	ASSEM. #
	1st		
	11/28	STOCK CRACKED 14" F/END TIP	
	2nd		
		Reshot 5-10 shot groups 12-8-89	AC
	3rd		
	4th		
		FUNCTION	RD 6654 Rev 1

TEST INIT. ACTION TO CORRECT		ASSEM. #
PROOF	shot OK 12-8-89	AC
TEST		
TGT		
PROOF		
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		

Remington®



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

MODEL 700™ H24

SERIAL NO.

C6348746

ORDER NO.

5716

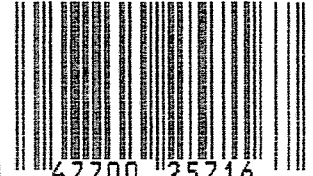
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat & Tm. Off. Marca Registrada Marque Deposee.

01



5716 C6348746

UPC



0 47700 25716 7

C6498746, C6349011

MAINTENANCE REQUEST				PAGE NO.	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.		WESDC		ORG. PD		PD AUTHENTICATION	
☐ Work Request ☐ MWO ☒ Warranty Claim		1A. ORGANIZATION Bco 3/5 SFG		B. LOCATION Ft. Campbell Ky 42223			C. UNIT IDENT CODE W346M7 WHC680		
2. SERIAL NO. C6498746		3. NOUN NOMENCLATURE Rifle 7.62 Sniper		4. LINE NO. R95387		5. MODEL M24		6. NATIONAL STOCK NUMBER 1005-01-240-2136	
7A. MAINTENANCE ACTIVITY		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. ☐ C Test ☐ E Storage ☐ G Flight ☐ B Handling ☐ D Normal Op ☐ F Inspection ☒ H Other					☐ 068 Inoperative ☐ 258 Overheating ☐ 790 Out of Adjustment ☐ 008 Noisy ☐ 387 Low Performance ☒ Other				
16A. DESCRIBE DEFICIENCIES OR SYMPTOMS ON THE BASIS OF COMPLETE CHECKOUT AND DIAGNOSTIC PROCEDURE IN EQUIPMENT TM (Do not prescribe repairs). Rwp Count over 5,000 Rnds									
B. REMARKS									
PREPARATION INSTRUCTIONS (Prior to using this form, read DA PAM 738-750 for detailed preparation instructions)									
1. Place a "✓" or an "X" in the box for the type of action required. 2. Enter the WESDC if the item is Materiel Condition Status Reportable. 3. Enter the priority designator as determined from the urgency of need and force activity designator. 4. The Unit Commander, Chief of TDA activity or their designated representative will authenticate, by signature, a priority of 01 through 08. 5. Block 1A. Enter the name of the organization submitting the request. 6. Block 1B. Enter the unit submitting the request; units overseas enter APO only. 7. Block 1C. Enter the unit identification code of the unit in block 1A. 8. Block 2. Enter the equipment serial number. For ammunition, enter the lot number. For administrative-use vehicles, enter the USA registration number. 9. Block 3. Enter the noun abbreviation of the item. 10. Block 4. Enter the item line number, if applicable. 11. Block 5. Enter the model number. 12. Block 6. Enter the National Stock Number of the item listed in Block 3.					13. Block 7. Enter the name of the support activity. 14. Block 7A. Enter the symbol of the maintenance category (O, F, H, D, or L). 15. Block 8. Enter the utilization code. 16. Block 9A. Enter the word "yes" if the item is Materiel Condition Status Reportable. 17. Block 9B. Enter the equipment readiness code, if applicable. 18. Block 9C. Enter the word "yes" if the item is a pacing item. 19. Block 10. Enter the hour reading, if applicable. 20. Block 11. Enter the mileage from the odometer, if applicable. 21. Block 12. Enter the total rounds fired, if applicable. 22. Block 13. For turbine engines, enter the number of hot starts. 23. Block 14. Enter a "✓" or "X" in the proper block. 24. Block 15. Enter a "✓" or "X" in the proper block. 25. Block 16. Describe briefly the fault or symptoms needing correction.				
23. SUBMITTED BY Tony [Signature]		24. RECEIVED BY							
JULIAN DATE		JULIAN DATE							

MAINTENANCE REQUEST				PAGE NO.	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.		WESDC		ORG. PD		PD AUTHENTICATION	
☐ Work Request ☐ MWO ☒ Warranty Claim		1A. ORGANIZATION 25 SIC		B. LOCATION 104 42-03			C. UNIT IDENT CODE M200		
2. SERIAL NO.		3. NOUN NOMENCLATURE		4. LINE NO.		5. MODEL		6. NATIONAL STOCK NUMBER	
7A. MAINTENANCE ACTIVITY		B. LEVEL	8. UTILIZATION CODE	9A. MCSR ITEM	9B. ERC	9C. PACING ITEM	10. HOURS	11. MILES	12. ROUNDS
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	☐ 058 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).									
B. REMARKS									
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)		22. Data Transcribed							
☐ 1 Parts ☐ 2 Manpower ☐ 3 Facilities ☐ 4 Funds ☐ 5 Tools									
23. SUBMITTED BY		24. RECEIVED BY		25. WORK STARTED BY		26. INSPECTED BY		27. ACCEPTED BY	
JULIAN DATE		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

FILE COPY 5

Final Inspection

Sn: C6498746

DATE REC'D: 4/24/96

DATE RET'D:

AUDITOR: MW

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:

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6498746

Barre 1 + BOLT

Wrong BOLT Returned
with Gun
(9072)

OP. #	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and Stock		4/29/96	Rw
600	Proof		4/29/96	Rw
607	Check Headspace		4/29/96	Rw
610	Dis-assemble Gun		4/29/96	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		5/8/96	Rw
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/8/96	Rw
	C) Inspect Ejector Hole for Chamfer		5/8/96	Rw
	D) Oil Firing Pin Ass'y		5/8/96	Rw
	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		5/8/96	RA
	A) Time			
	B) Malfunctions			
	C) Pierced Primers			
	D) Optical Clarity of Scope			
645	Inspect for Live Ammo		5/8/96	RA
655	Final Inspection			
	A) Headspace		5/11/96	RW
	B) Trigger Pull		5/11/96	RW
	C) Function		5/11/96	RW
660	Pack			

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6498746
11 Mar 1900

CENTROIDAL DISTANCES

0 TO 1	.595477
1 TO 2	.361204
1 TO 3	.315493
1 TO 4	.0732462
1 TO 5	.451143

$\bar{x}$ <----POA

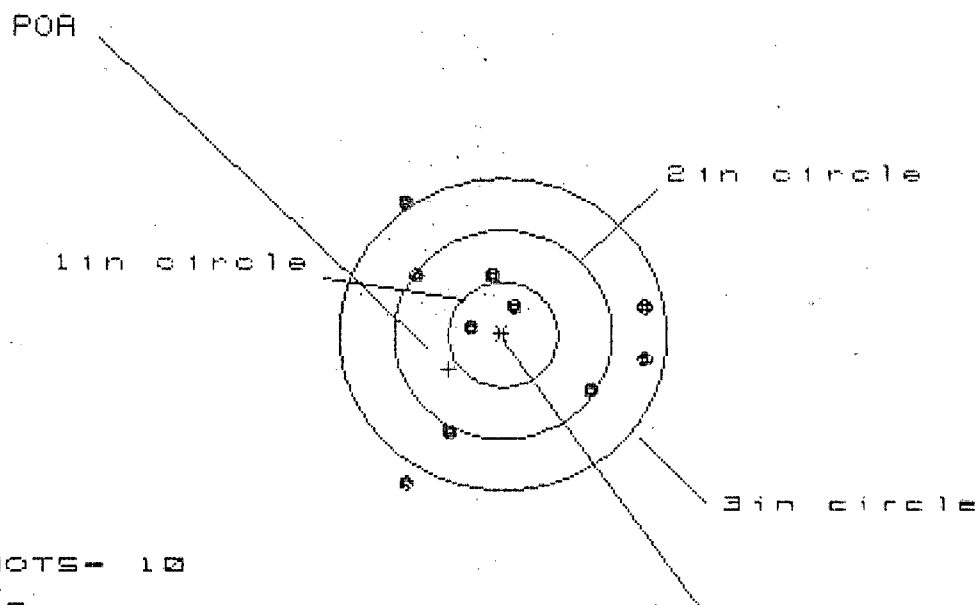
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .2814
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .2562
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .380558
THE AMR FOR THIS RIFLE IS: .9884

11 Mar 1908

FILE:/PATTERNING/CENTERFIRE_PATT/06438746

CENTERFIRE PATTERNS

1



OF SHOTS- 10

IN CIR

1in = 2

2in = 4

3in = 8

HS= 2.140

VS= 2.707

GS= 2.707

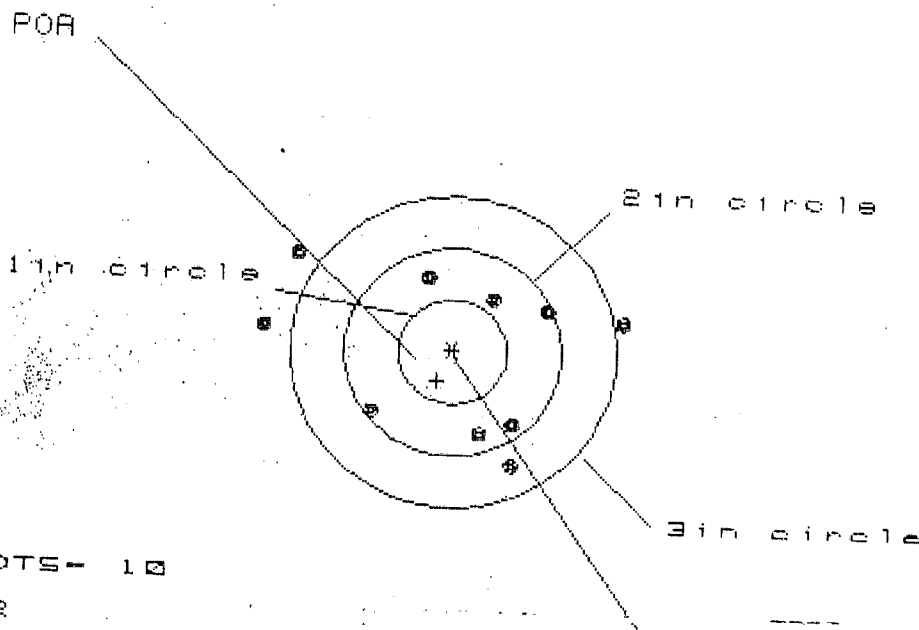
CENTROID *

PATTERN #			
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.276	1.180	1.061
MINIMUM X	-.864	-.952	-1.053
MAXIMUM Y	1.291	1.134	.602
MINIMUM Y	-1.416	-1.088	-.946
CENTROID X	.497	.593	.712
CENTROID Y	.328	.485	.343
POA TO CENTROID in.	.595	.766	.790
MIN RADIUS	.301	.122	.282
MEAN RADIUS	.997	.896	.840
MAX RADIUS	1.658	1.481	1.213
HORIZONTAL SPREAD	2.140	2.132	2.114
VERTICAL SPREAD	2.707	2.222	1.548
EXTREME SPREAD	2.707	2.609	2.271
NUMBER IN ONE INCH CIRCLE	=	2	
NUMBER IN TWO INCH CIRCLE	=	4	
NUMBER IN THREE INCH CIRCLE	=	8	

11 Mar 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C6498746

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 0

2in = 5

3in = 7

HS= 3.246

VS= 1.950

GS= 3.246

CENTROID #

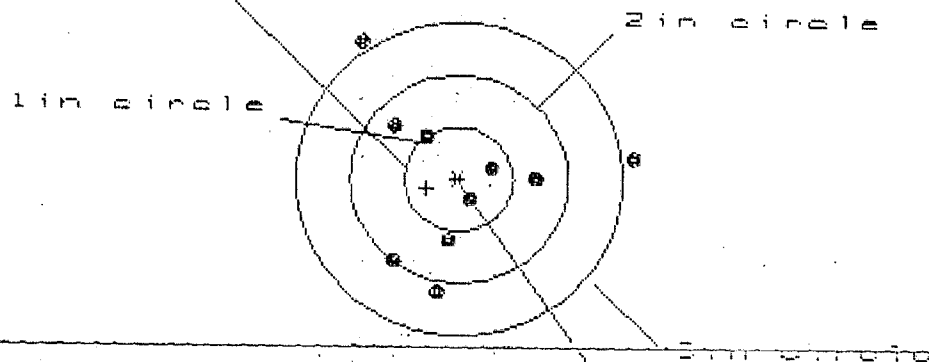
PATTERN #	120	121	122
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.551	1.362	1.461
MINIMUM X	-1.695	-1.612	-1.146
MAXIMUM Y	.909	.938	.844
MINIMUM Y	-1.041	-1.012	-.895
CENTROID X	.139	.328	.529
CENTROID Y	.280	.251	.134
POA TO CENTROID in.	.313	.413	.546
MIN RADIUS	.630	.558	.529
MEAN RADIUS	1.109	1.011	.869
MAX RADIUS	1.715	1.865	1.245
HORIZONTAL SPREAD	3.246	2.974	2.307
VERTICAL SPREAD	1.950	1.950	1.739
EXTREME SPREAD	3.246	3.035	2.472
NUMBER IN ONE INCH CIRCLE	=	0	
NUMBER IN TWO INCH CIRCLE	=	6	
NUMBER IN THREE INCH CIRCLE	=	7	

11 Mar 1988

FILE:/PATTERNING/CENTERFIRE_PATT/CG498746

CENTERFIRE PATTERNS # 3

POA



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 6

3 in = 8

HS= 2.500

VS= 2.412

GS= 2.745

CENTROID #

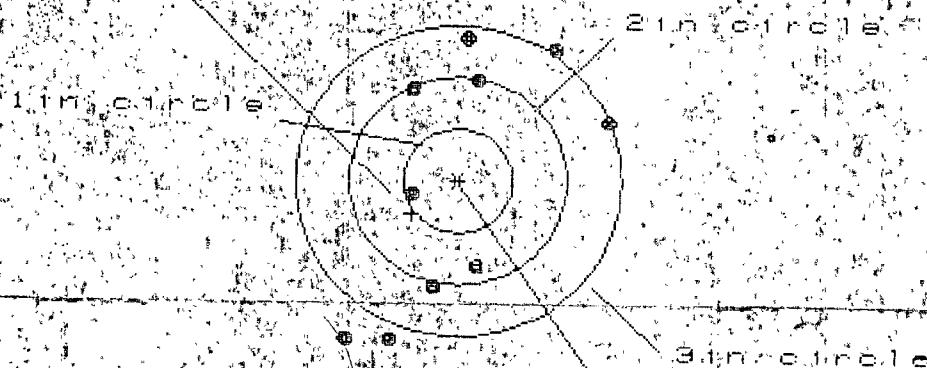
PATTERN #	3	3	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.554	1.449	.809
MINIMUM X	-.946	-.749	-.568
MAXIMUM Y	1.337	.628	.672
MINIMUM Y	-1.075	-.926	-.882
CENTROID X	.297	.402	.221
CENTROID Y	.084	-.065	-.109
POA TO CENTROID in.	.308	.407	.246
MIN RADIUS	.224	.057	.169
MEAN RADIUS	.847	.734	.640
MAX RADIUS	1.638	1.491	.886
HORIZONTAL SPREAD	2.500	2.198	1.377
VERTICAL SPREAD	2.412	1.554	1.554
EXTREME SPREAD	2.745	2.399	1.627
NUMBER IN ONE INCH CIRCLE	= 3		
NUMBER IN TWO INCH CIRCLE	= 6		
NUMBER IN THREE INCH CIRCLE	= 8		

11 Mar 1988

FILE: PATTERNING CENTERFIRE PATT C6498746

CENTERFIRE PATTERNS # 4

POA



OF SHOTS- 10

IN CIR

1 in = 1
2 in = 3
3 in = 2
10 = 6
400 = 2
005 = 0
000 = 0

CENTROID #

PATTERN #	10	8	8
SHOTS (BEST OF)	10	8	8
MAXIMUM X	1.388	1.230	1.178
MINIMUM X	-1.041	-1.755	-1.655
MAXIMUM Y	1.261	1.192	.988
MINIMUM Y	-1.524	-1.689	-1.402
CENTROID X	.424	.539	.634
CENTROID Y	.322	.491	.703
POA TO CENTROID in.	.532	.730	.946
MIN RADIUS	.453	.615	.627
MEAN RADIUS	1.221	1.141	1.023
MAX RADIUS	1.842	1.854	1.460
HORIZONTAL SPREAD	2.429	2.028	1.833
VERTICAL SPREAD	2.985	2.985	2.382
EXTREME SPREAD	3.383	3.174	2.524
NUMBER IN ONE INCH CIRCLE	= 4	4	4
NUMBER IN TWO INCH CIRCLE	= 3	3	3
NUMBER IN THREE INCH CIRCLE	= 7	7	7

Mar 1900

FILE: PATTERNING/CENTERFIRE_PATT/06498746

CENTERFIRE PATTERNS # 5

POA

1 in circle

2 in circle

3 in circle

OF SHOTS - 10

IN CIR

1 2

2 8

3 10

10 1.555

20 0.011

30 0.505

CENTROID

PATTERN #

15

SHOTS (BEST OF)

10

9

8

MAXIMUM X

.727

.788

.678

MINIMUM X

-.939

-.878

-.688

MAXIMUM Y

.848

.719

.752

MINIMUM Y

-1.168

-.788

-.698

CENTROID X

.090

.011

.099

CENTROID Y

.267

.396

.306

POA TO CENTROID in

.271

.396

.321

MIN RADIUS

.276

.306

.336

MEAN RADIUS

.768

.705

.646

MAX RADIUS

1.288

1.135

.895

HORIZONTAL SPREAD

1.666

1.666

1.366

VERTICAL SPREAD

2.011

1.507

1.450

EXTREME SPREAD

2.505

1.833

1.605

NUMBER IN ONE INCH CIRCLE =

2

NUMBER IN TWO INCH CIRCLE =

8

NUMBER IN THREE INCH CIRCLE =

10