

C6225166

MODEL 700TM M24

Model **SMS** TM

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.



Repair Inquiry

Repair Number: RE00092932

Serial: C6225166 Model: M24 SWS Center Fire
Caliber: 7.62 NATO Produced: 06/21/1999

Repairman:

Status:

Closed 2/10/2005 1:14:02 PM

Address Information

Customer:

☒ Received From:

Return To:

☐ Received From:

Name: DEF DIST DEPOT ANNISTON

DEF DIST DEPOT ANNISTON

Address 1:

Address 2:

PO Box:

PO Box:

City: ANNISTON

ANNISTON

State: AL

Zip Code: 362014199

Country: US

State: AL

Zip Code: 362014199

Country: US

FPL:

Contact / Condition

Problems

Estimate

History / Status

Shipping / Billing

Contact Information

Phone:

Fax:

Email:

Comments:

Received Condition

Good

Condition
Notes:CSR
Notes:

Accessories Received

Code	Desc	Qty
A007	With Stud	3
A010	Hard Case	1
A017	Scope Base	1
A026	Scope	1
A057	Front and Rear Sgt Base	1

Repair Search

Refresh

Close

hagley

2/14/2005

9:15 AM

CAPS

NCM

INS

SCPL

start

5

2

3

Arms Service

Serial Number: C6225166

Model: M24 SWS



RE00092932

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6225166.___0
FILE DATE AND TIME: 06/08/2005 08:22

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.248
The Average Y Centroid of the Five Target Set:	0.059
The Average Point of Impact of the Five Target Set:	0.255
The Average Mean Radius of the Five Target Set:	1.026
The Distance from POA to Centroid Target #1:	0.442
The Distance from Centroid Target #2 to Centroid Target #1:	0.122
The Distance from Centroid Target #3 to Centroid Target #1:	0.336
The Distance from Centroid Target #4 to Centroid Target #1:	0.343
The Distance from Centroid Target #5 to Centroid Target #1:	0.606

SERIAL NUMBER: C6225166. 0

TARGET NUMBER: 1

FILE DATE: 06/08/2005

FILE TIME: 08:22

POINT#	X	Y
1:	0.533	0.292
2:	0.860	-0.510
3:	0.669	-0.395
4:	0.246	-0.690
5:	-0.804	-1.242
6:	-0.415	1.583
7:	-0.834	0.318
8:	-1.128	1.042
9:	-1.335	0.048
10:	-2.177	0.103

X CENTROID: -0.439

Y CENTROID: 0.055

POA TO CENTROID: 0.442

HORZ SPREAD: 3.037

VERT SPREAD: 2.825

GROUP SPREAD: 3.098

MIN RADIUS: 0.475

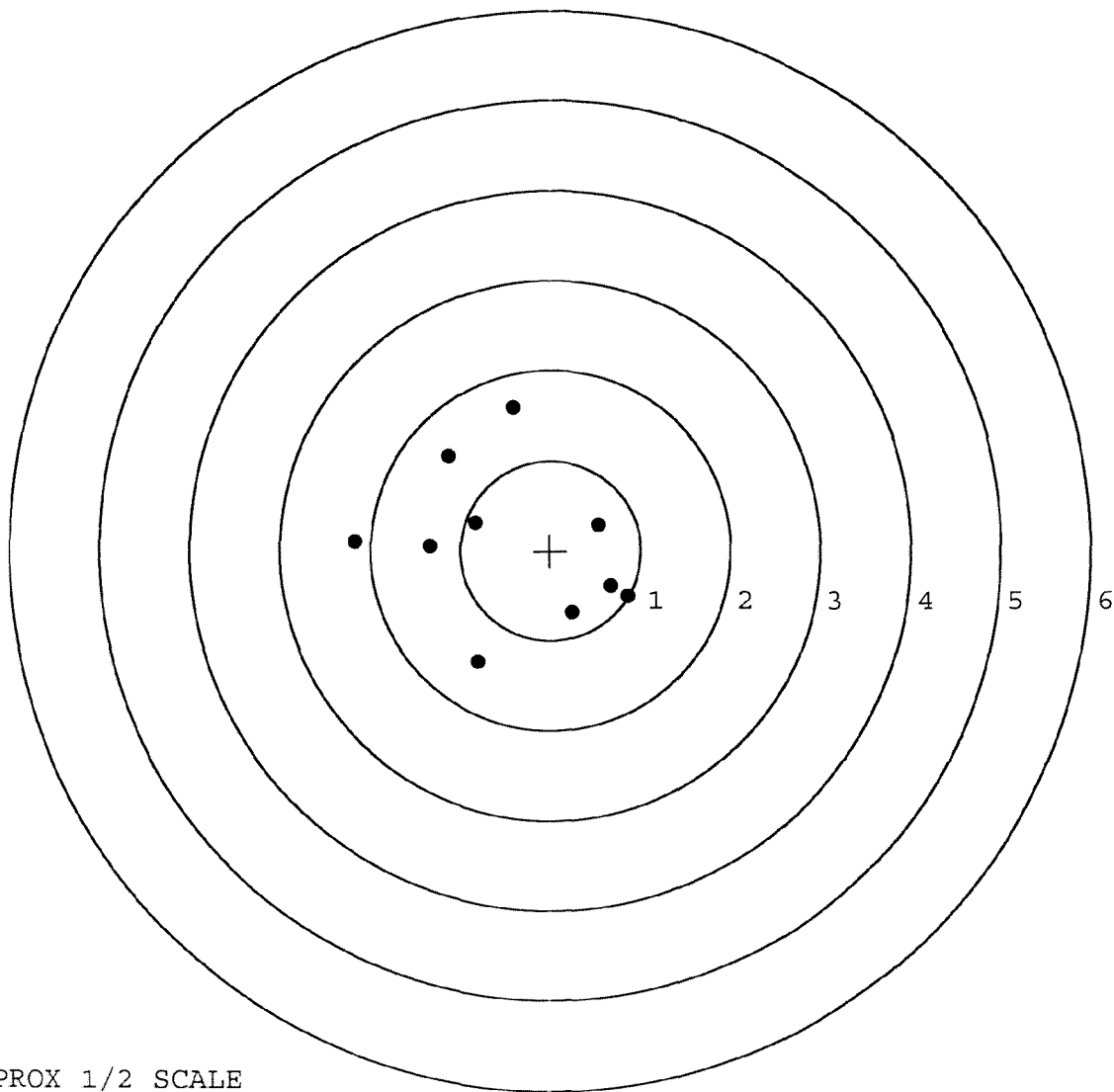
MAX RADIUS: 1.739

MEAN RADIUS: 1.181

IN 1 IN DIAMETER: 1

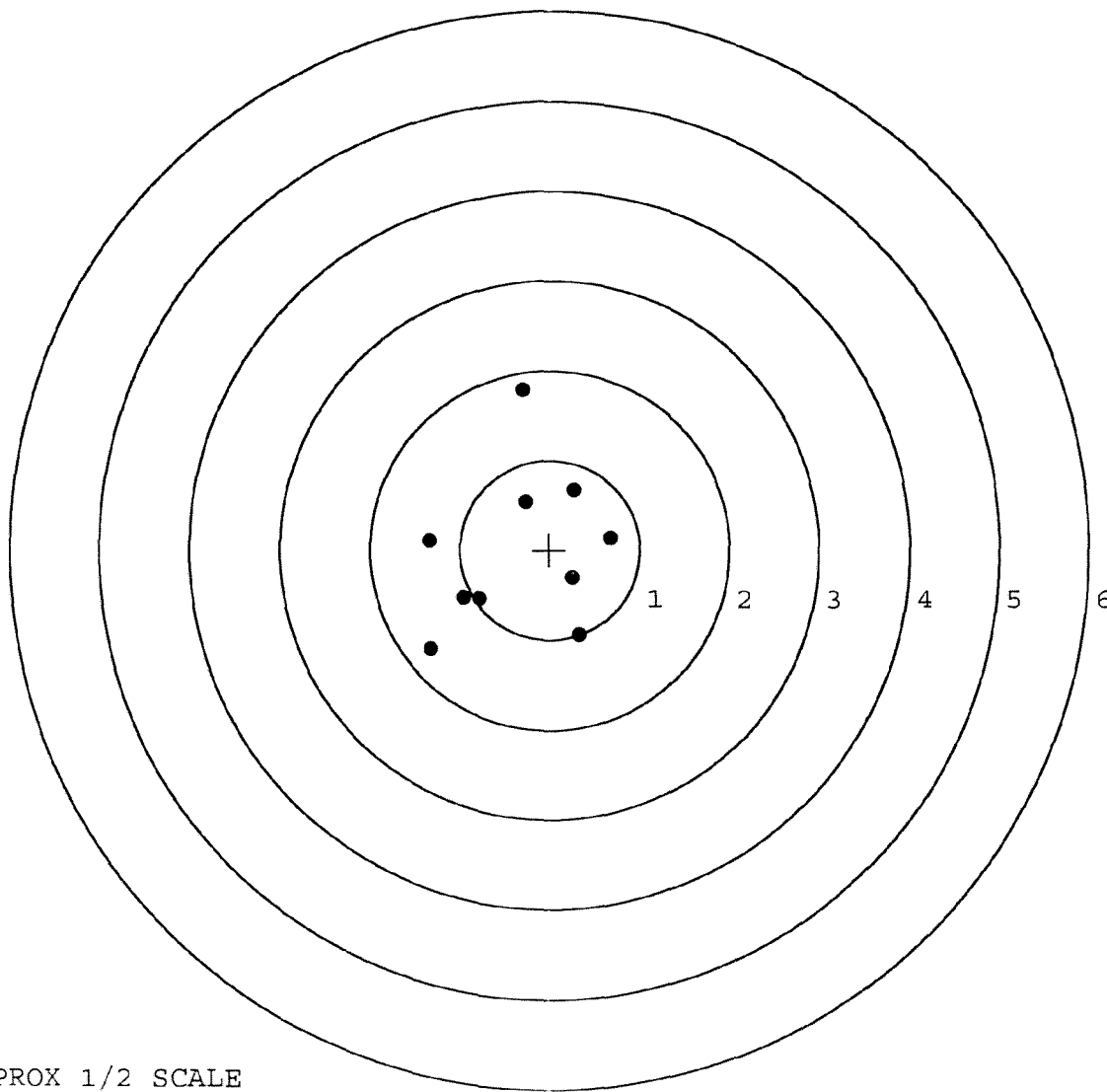
IN 2 IN DIAMETER: 2

in 3 IN DIAMETER: 8



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6225166. __0	POINT#	X	Y
TARGET NUMBER: 2	1:	0.331	-0.951
FILE DATE: 06/08/2005	2:	0.254	-0.315
FILE TIME: 08:22	3:	0.668	0.139
	4:	0.277	0.671
X CENTROID: -0.345	5:	-0.262	0.537
Y CENTROID: -0.024	6:	-0.303	1.783
POA TO CENTROID: 0.346	7:	-1.345	0.100
HORZ SPREAD: 2.013	8:	-0.960	-0.544
VERT SPREAD: 2.889	9:	-0.782	-0.552
GROUP SPREAD: 3.065	10:	-1.326	-1.106
MIN RADIUS: 0.567			
MAX RADIUS: 1.807			
MEAN RADIUS: 1.011			
# IN 1 IN DIAMETER: 0			
# IN 2 IN DIAMETER: 5			
# in 3 IN DIAMETER: 9			



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6225166. 0

TARGET NUMBER: 3

FILE DATE: 06/08/2005

FILE TIME: 08:22

POINT#	X	Y
1:	-0.175	1.136
2:	-0.807	0.231
3:	-1.723	-0.024
4:	-0.159	-0.590
5:	-0.642	-1.401
6:	0.273	-0.559
7:	0.705	0.411
8:	0.417	0.235
9:	0.344	-0.057
10:	0.413	-0.293

X CENTROID: -0.135

Y CENTROID: -0.091

POA TO CENTROID: 0.163

HORZ SPREAD: 2.428

VERT SPREAD: 2.537

GROUP SPREAD: 2.467

MIN RADIUS: 0.481

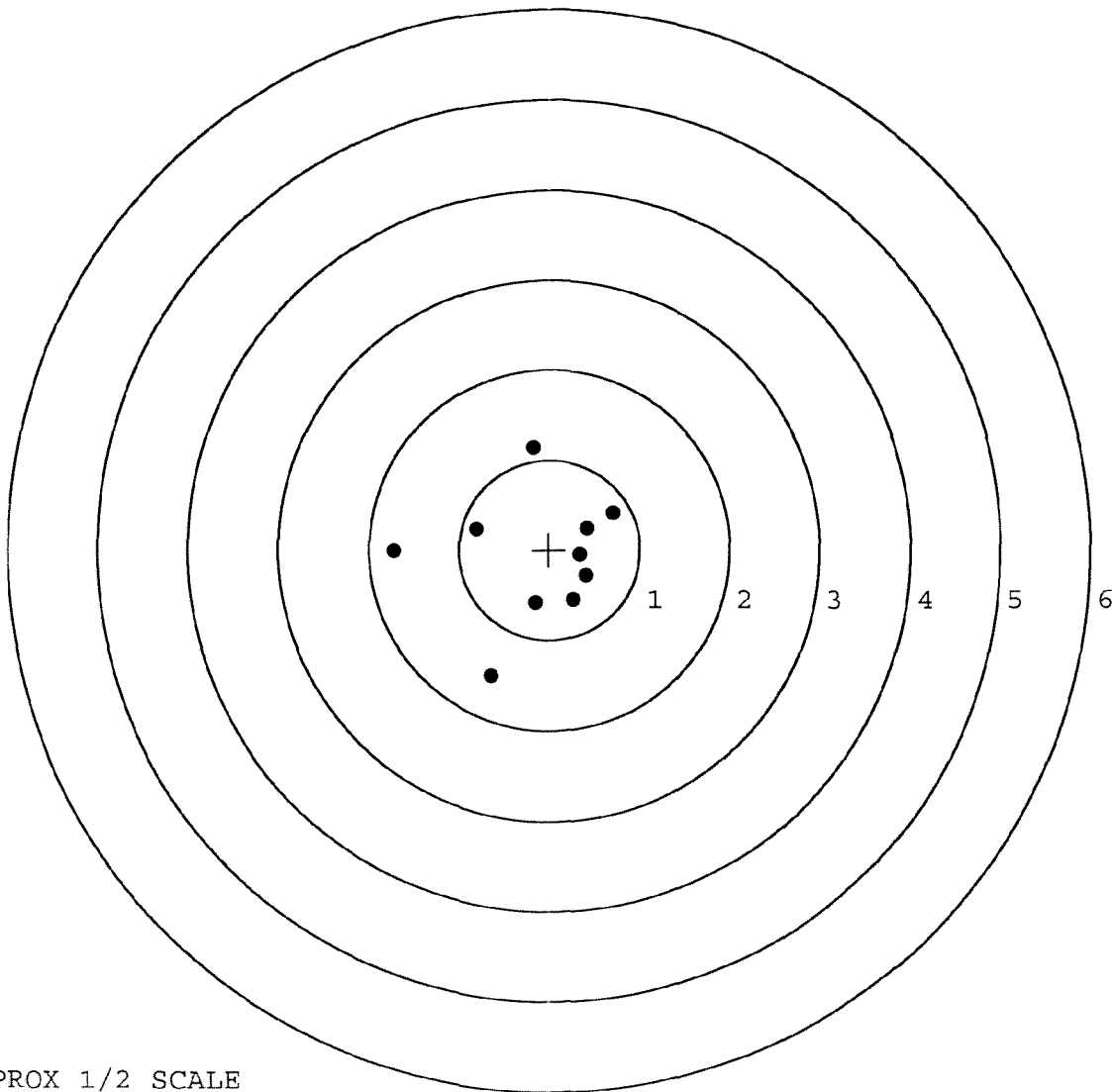
MAX RADIUS: 1.589

MEAN RADIUS: 0.877

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6225166. __0

TARGET NUMBER: 4

FILE DATE: 06/08/2005

FILE TIME: 08:22

X CENTROID: -0.481

Y CENTROID: 0.396

POA TO CENTROID: 0.623

HORZ SPREAD: 3.746

VERT SPREAD: 2.925

GROUP SPREAD: 4.274

MIN RADIUS: 0.302

MAX RADIUS: 2.345

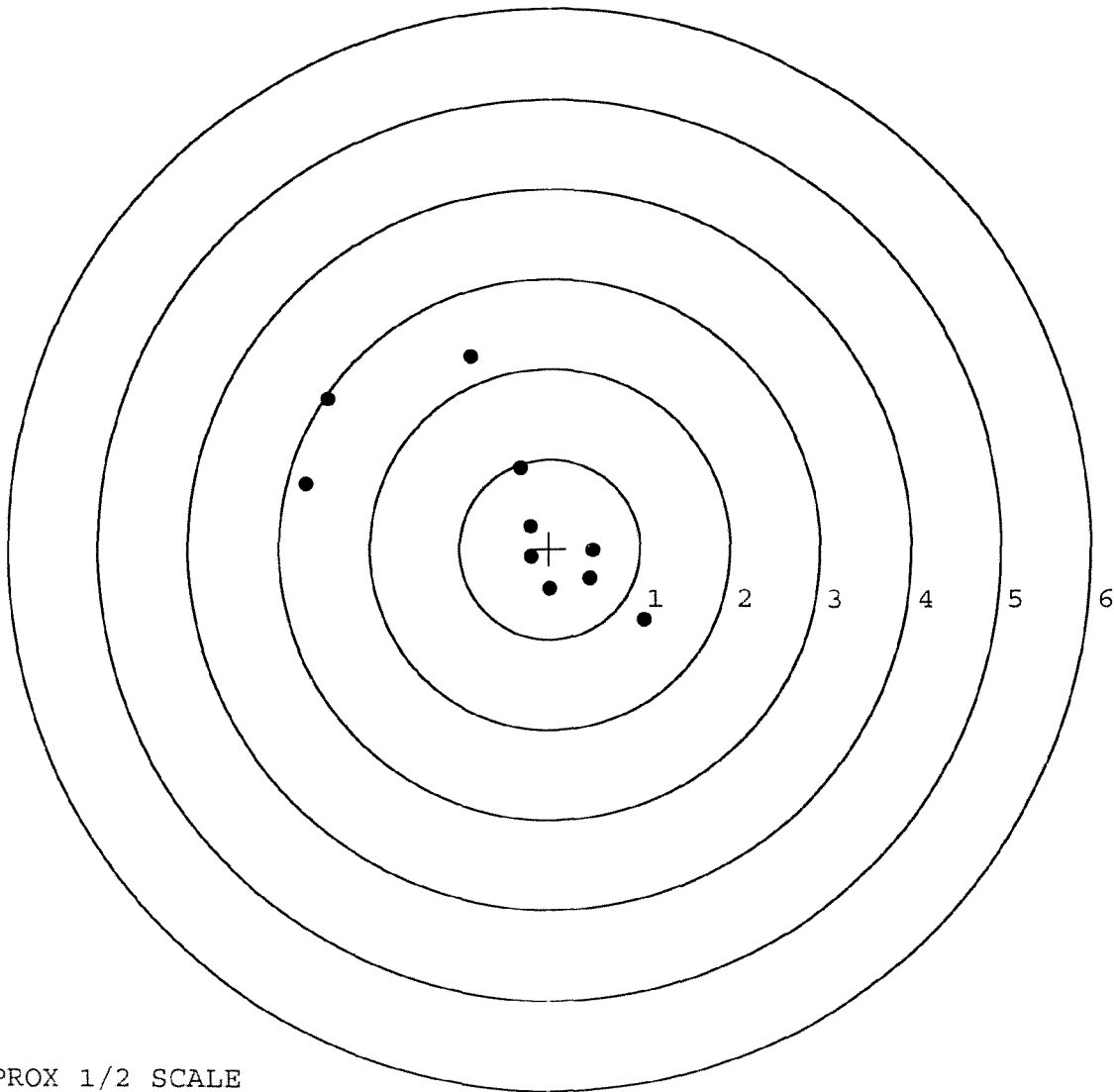
MEAN RADIUS: 1.290

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 4

in 3 IN DIAMETER: 6

POINT#	X	Y
1:	1.045	-0.793
2:	0.449	-0.339
3:	0.480	-0.020
4:	0.002	-0.448
5:	-0.206	-0.087
6:	-0.217	0.249
7:	-0.323	0.903
8:	-0.879	2.132
9:	-2.460	1.653
10:	-2.701	0.707



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6225166. __0

TARGET NUMBER: 5

FILE DATE: 06/08/2005

FILE TIME: 08:22

POINT#	X	Y
1:	0.225	-1.479
2:	1.000	0.100
3:	1.056	0.779
4:	0.186	0.209
5:	-0.387	0.726
6:	-0.532	0.443
7:	-0.589	-0.414
8:	-0.274	-0.258
9:	0.290	-0.379
10:	0.622	-0.126

X CENTROID: 0.160

Y CENTROID: -0.040

POA TO CENTROID: 0.165

HORZ SPREAD: 1.645

VERT SPREAD: 2.258

GROUP SPREAD: 2.406

MIN RADIUS: 0.250

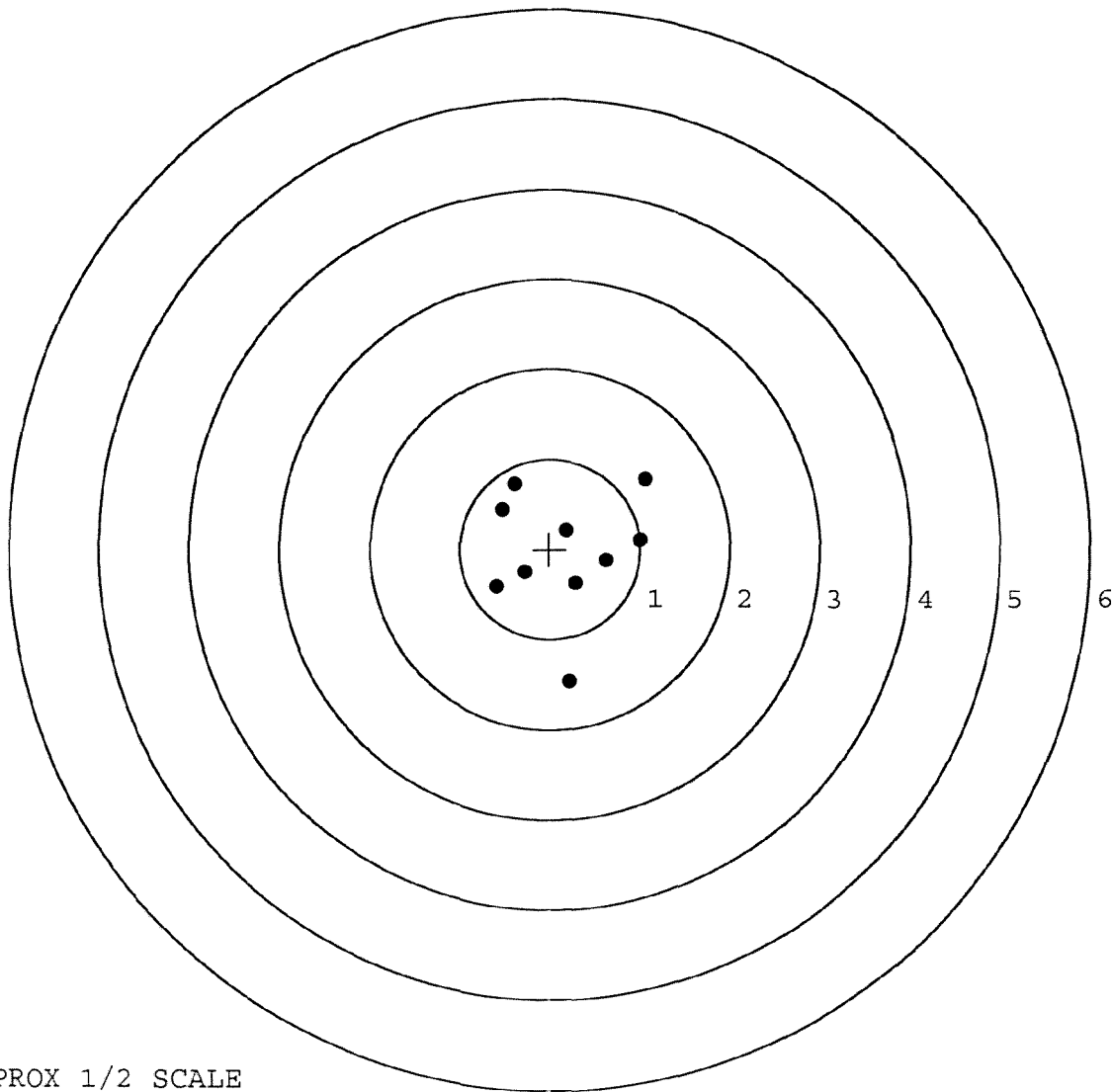
MAX RADIUS: 1.441

MEAN RADIUS: 0.770

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

R & E NUMBER	92932		
SERIAL NUMBER	C6225166		
LOG-IN DATE	2-10-05		
INSPECT AND VERIFY:			
OPERATION #	OPERATION NAME	DATE	INITIAL
550	DIS-ASSEMBLE GUN	4-25-05	RTZ
560 A	RE-BARREL	5-3-05	RTZ
B	DRILL AND TAP	5-5-05	TRW
575	ASSEMBLE	5-3-05	RTZ
600	PROOF	5-4-05	- - - A
605	CHECK HEADSPACE	5-4-05	A
610	DIS-ASSEMBLE GUN	5-6-05	RTZ
612	MAGNAFLUX OPERATOR	5-9-05	CW
615	ROLLMARK CALIBER	5-9-05	LB
618	ROTO-BLAST	5-16-05	W
620	APPLY COATINGS	6-2-05	RTZ
625 A	FINAL ASSEMBLY	6-9-05	A
B	TRIGGER PULL TEST	6-9-05	A
C	SAFETY "ON" FORCE	6-9-05	A
D	SAFETY "OFF" FORCE	6-9-05	A
E	FIRING PIN INDENT	6-8-05	TRW
640	TARGET	6-9-05	AC
655	FINAL INSPECT	7-6-05	DA
660	PACK	7-6-05	
		SHIP DATE	
QAR INSPECTION DATE			

Remington
REG. U.S. PAT. & TM. OFF.

Model 700™ M24

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

SERIAL NO.
C6225166

ORDER NO.
5716

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



5716 C6225166

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C 6225166

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	4 21	89	RW
600	Proof	4 21	89	RW
607	Check Headspace	4 21	89	RW
610	Dis-assemble Gun	4 21	89	RW
612	Magnaflux Barrel Action		4/26	KCR
	Magnaflux Bolt		4/27	KCR
615	Rollmark Caliber		4/27	LS
617	Drill and Tap Sight Holes	4 27	89	LB
618	Polish Barrel RUB	4 27	89	BT
620	Apply Coatings (Barrel Action)		5-7-89	TJA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		5/12/89	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/17/89	RW
	C) Inspect Ejector Hole for Chamfer		5/17/89	RW
	D) Oil Firing Pin Ass'y		5/15/89	RW
	E) Adjust Trigger Pull to Min Setting and Stake		5/24/89	WLB

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			5/24/89	JS
	G) Safety Off Force	4	4	4			5/24/89	JS
	H) Trigger Pull Test & Retainability						5/24/89	WB
	I) Firing Pin Indent	.020	.020	.020			5/24/89	JS
	J) Assemble Stock						5/24/89	RW
	K) Assemble Swivel Studs						31 May 89	JS
	L) Attach Front and Rear Sight Assemblies						5/24/89	RW
	M) Iron Sight Alignment						5/24/89	RW
	N) Detach Front & Rear Sights & place in numbered container						5/24/89	RW
	O) Attach Scope to Rifle						5/24/89	JS
	P) Detach & Attach Scope 20 Times						5/24/89	JS
640	Gallery Target & Test	48 R	106 L				5-30-89	JS
	A) Time						"	JS
	B) Malfunctions						"	JS
	C) Pierced Primers						"	JS
	D) Optical Clarity of Scope						"	JS
645	Inspect for Live Ammo						5-30-89	JS
655	Final Inspection							
	A) Headspace						31 May 89	JS
	B) Trigger Pull	2.61	2.72	2.65	2.68	2.54	31 May 89	JS
	C) Function						31 May 89	JS
660	Pack						31 May 89	JS

BARBER - M24 0009779

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C6225166DATE 3/28/90TESTER DH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#	COMMENTS
PULL #1	2.42	2.44	2.40	MIN. SETTING,
PULL #2	2.46	2.42	2.41	NO AVG. OF 5
PULL #3	2.37	2.44	2.39	READINGS ACCEPT-
PULL #4	2.38	2.41	2.39	ABLE LESS THAN 2#
PULL #5	2.40	2.46	2.41	
TOTAL	12.03	12.17	12.00	
AVG.	2.41	2.43	2.40	

	3.00# INITIAL	3.00# AFTER 20 CYCLES	COMMENTS
PULL #1	3.40	3.23	
PULL #2	3.19	3.26	
PULL #3	3.13	3.24	
PULL #4	3.19	3.24	
PULL #5	3.18	3.14	
TOTAL	16.09	16.11	
AVG.	3.21	3.22	

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.11	4.12		
PULL #2	4.22	4.07		
PULL #3	4.19	4.18		
PULL #4	4.16	4.09		
PULL #5	4.21	4.12		
TOTAL	20.89	20.58		
AVG.	4.17	4.11		

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6225166
1 Jun 1989

CENTROIDAL DISTANCES

Ø TO	1	.635938
1 TO	2	.821678
1 TO	3	.49706
1 TO	4	.57869
1 TO	5	.836869

25
34
1 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.157
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.2028
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .25647

THE AMR FOR THIS RIFLE IS: .8344

30 May 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C6225166

CENTERFIRE PATTERNS # 1

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS- 10

IN CIR

1 in = 2

2 in = 7

3 in = 9

HS= 2.832

VS= 2.191

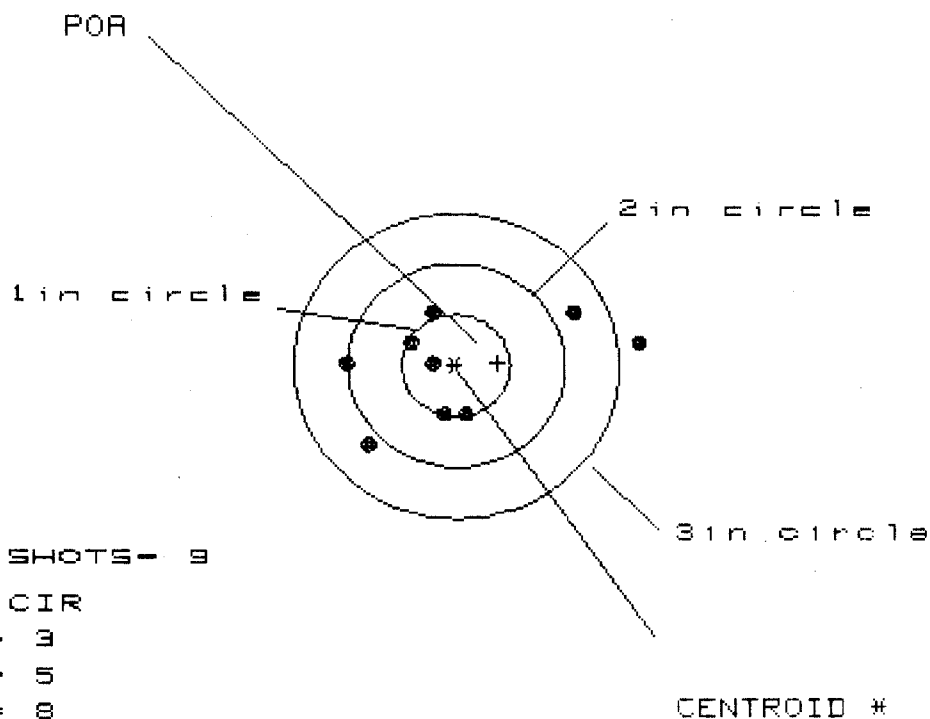
GS= 2.971

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.747	.710	.599
MINIMUM X	-1.085	-.891	-.766
MAXIMUM Y	1.223	1.252	1.175
MINIMUM Y	-.968	-.939	-1.016
CENTROID X	.199	.005	.116
CENTROID Y	-.604	-.633	-.556
POA TO CENTROID in.	.636	.633	.568
MIN RADIUS	.487	.303	.400
MEAN RADIUS	.900	.781	.739
MAX RADIUS	1.766	1.253	1.176
HORIZONTAL SPREAD	2.832	1.601	1.365
VERTICAL SPREAD	2.191	2.191	2.191
EXTREME SPREAD	2.971	2.191	2.191
NUMBER IN ONE INCH CIRCLE	= 2		
NUMBER IN TWO INCH CIRCLE	= 7		
NUMBER IN THREE INCH CIRCLE	= 9		

30 May 1989

FILE:/PATTERNING/CENTERFIRE_PATT/06225166

CENTERFIRE PATTERNS # 2



OF SHOTS - 9

IN CIR

1 in = 3

2 in = 5

3 in = 8

HS = 2.737

VS = 1.300

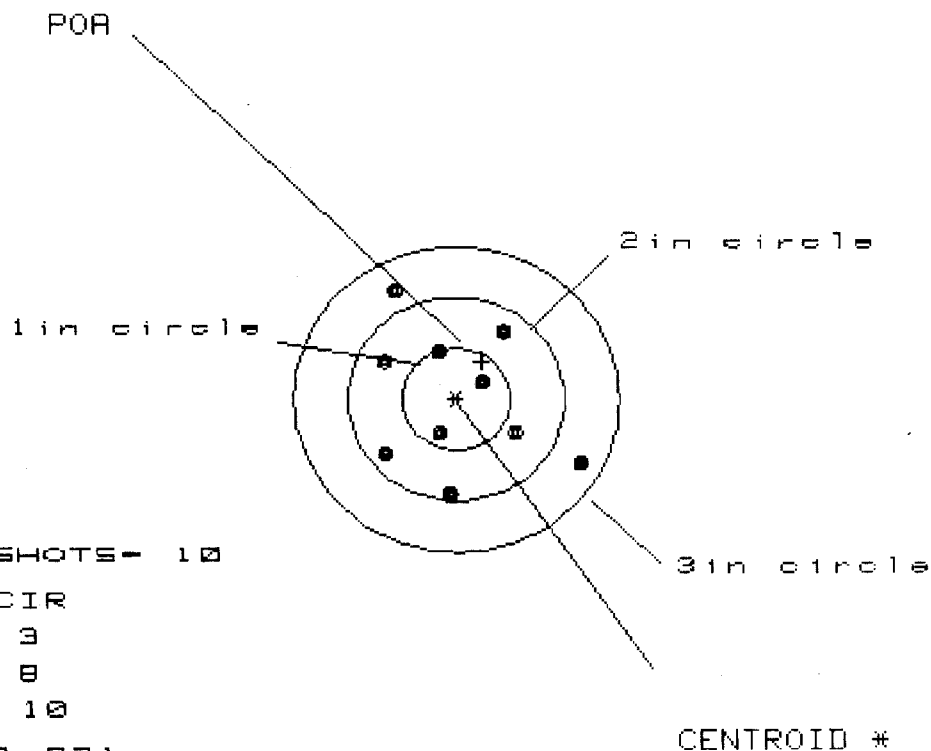
GS = 2.749

PATTERN #	:	9	8	7
SHOTS (BEST OF)	:	9	8	7
MAXIMUM X	:	1.701	1.335	.485
MINIMUM X	:	-1.036	-.823	-.633
MAXIMUM Y	:	.563	.596	.609
MINIMUM Y	:	-.737	-.704	-.618
CENTROID X	:	-.386	-.599	-.789
CENTROID Y	:	-.027	-.060	-.146
POR TO CENTROID in.	:	.387	.602	.803
MIN RADIUS	:	.224	.091	.258
MEAN RADIUS	:	.819	.649	.533
MAX RADIUS	:	1.722	1.462	.766
HORIZONTAL SPREAD	:	2.737	2.158	1.118
VERTICAL SPREAD	:	1.300	1.300	1.227
EXTREME SPREAD	:	2.749	2.367	1.373
NUMBER IN ONE INCH CIRCLE =	:	3		
NUMBER IN TWO INCH CIRCLE =	:	5		
NUMBER IN THREE INCH CIRCLE =	:	8		

30 May 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C6225166

CENTERFIRE PATTERNS # 3



OF SHOTS - 10

IN CIR

1 in - 3

2 in - 8

3 in - 10

HS = 1.831

VS = 2.007

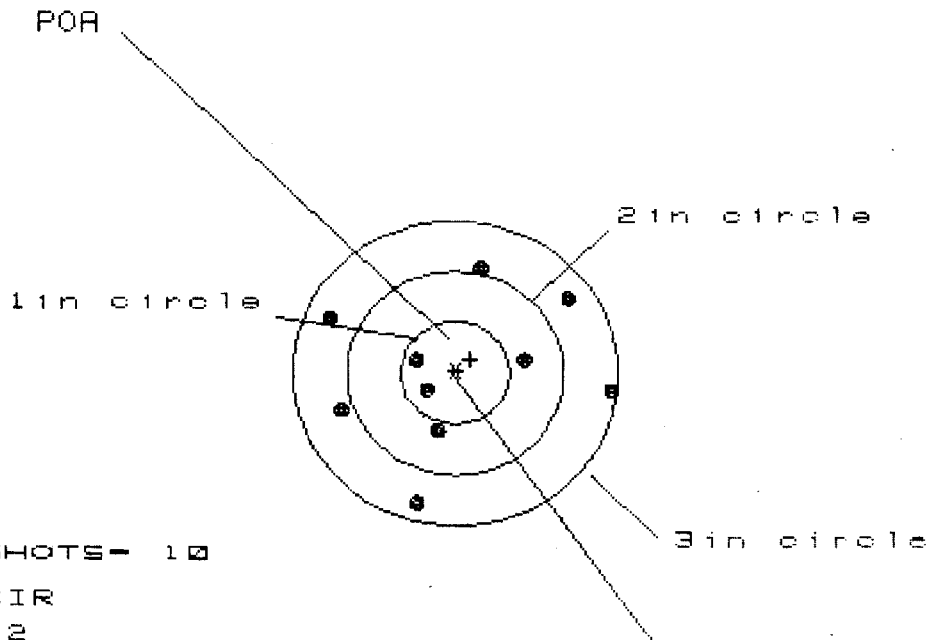
GS = 2.424

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.145	.634	.585
MINIMUM X	-.686	-.558	-.607
MAXIMUM Y	1.096	1.021	.715
MINIMUM Y	-.911	-.986	-.858
CENTROID X	-.239	-.367	-.318
CENTROID Y	-.369	-.294	-.422
POA TO CENTROID in.	.440	.470	.528
MIN RADIUS	.274	.353	.296
MEAN RADIUS	.759	.689	.630
MAX RADIUS	1.327	1.092	.859
HORIZONTAL SPREAD	1.831	1.192	1.192
VERTICAL SPREAD	2.007	2.007	1.573
EXTREME SPREAD	2.424	2.059	1.637
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		8	
NUMBER IN THREE INCH CIRCLE =		10	

30 May 1989

FILE:/PATTERNING/CENTERFIRE_PATT/06225166

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1 in - 2

2 in - 4

3 in = 10

HS= 2.529

VS= 2.299

GS= 2.627

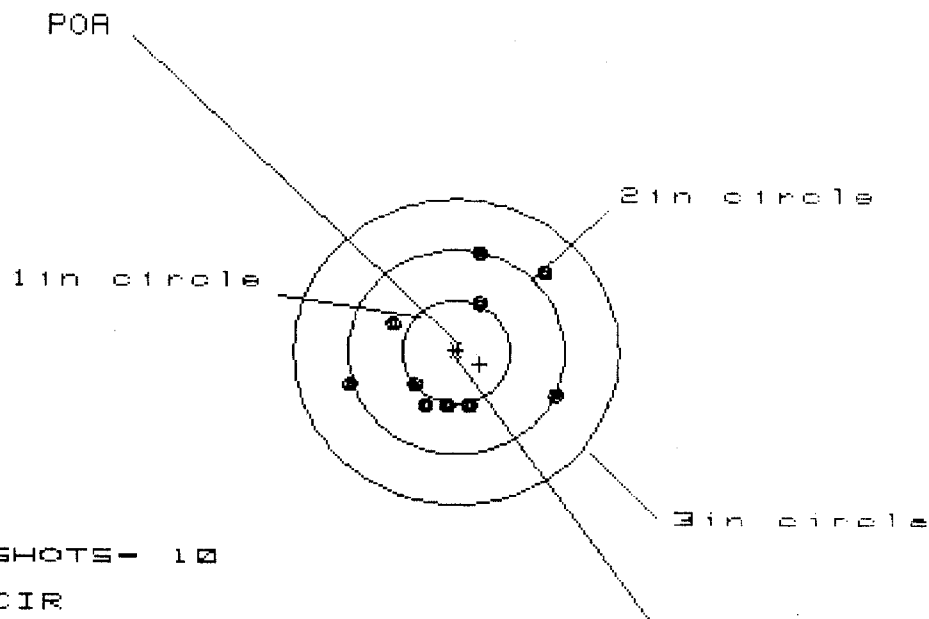
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.395	1.242	1.218
MINIMUM X	-1.134	-.979	-1.003
MAXIMUM Y	1.013	.992	.829
MINIMUM Y	-1.286	-1.307	-.775
CENTROID X	-.140	-.295	-.271
CENTROID Y	-.135	-.114	.049
POA TO CENTROID in.	.194	.316	.275
MIN RADIUS	.312	.193	.230
MEAN RADIUS	.948	.867	.818
MAX RADIUS	1.407	1.431	1.335
HORIZONTAL SPREAD	2.529	2.221	2.221
VERTICAL SPREAD	2.299	2.299	1.604
EXTREME SPREAD	2.627	2.476	2.425
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	10		

30 May 1985

FILE:/PATTERNING/CENTERFIRE_PATT/C6225166

CENTERFIRE PATTERNS # 5



OF SHOTS - 10

IN CIR

1 in = 1

2 in = 7

3 in = 10

HS = 1.851

VS = 1.525

GS = 2.105

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.877	.966	.855
MINIMUM X	-.974	-.885	-.597
MAXIMUM Y	.998	1.085	1.053
MINIMUM Y	-.527	-.440	-.472
CENTROID X	-.219	-.308	-.197
CENTROID Y	.121	.033	.065
POA TO CENTROID in.	.250	.309	.207
MIN RADIUS	.482	.393	.423
MEAN RADIUS	.746	.676	.654
MAX RADIUS	1.123	1.134	1.076
HORIZONTAL SPREAD	1.851	1.851	1.452
VERTICAL SPREAD	1.525	1.525	1.525
EXTREME SPREAD	2.105	1.851	1.593
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	10		

RECEIVED BARBER M24 0099786

COMMENTS

ORDER

R 94-32250

M24 W/ULTRA 10X-M3A SCOPE & DEPLOYMENT KIT

SCOPE 90 0907

INITIAL FPS	CUSTOMER ORDER NO.		M24 W/ULTRA 10X-M3A SCOPE & DEPLOYMENT KIT			
DATE RECEIVED 11/08/94	DATE OPENED 11/09/94	DATE CODE CJ 4-89	SERIAL NUMBER C6225166	NEW SERIAL NUMBER	MODEL AND GRADE 700 7.62 NATO	
ACCESSORIES W/STUDS		W/SWIVELS	SCOPE MNTS	SCOPE BASE	HARD CASE	
W/SOFT CASE & HARD CASE						

FROM: SHIP TO:

DEPT. OF THE ARMY
USASCH DOL. SUP/SVC.
BLDG. 6037 EAST RANGE
SCHO. BKS.

HI 96857

DEPT. OF THE ARMY
USASCH DOL. SUP/SVC.
BLDG. 6037 EAST RANGE
SCHO. BKS.

HI

96857

CUST NO: 107708 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						

PARTS	COMMENTS
Barrel	643.45
Stock	471.11
Firing pin Assy	9.96
Trigger Assy	173.31
Mag Spring	1.70
CTI	50.00
	\$1349.50
REPAIRMAN	PROOF
CLEAN	TEST
TARGET	PATTERN
GALLERY TESTER	DATE
DATE	DATE
3/1	3/1

OFFICE COPY

FD6925 REV. 1/94

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

BARBER - M24 0099786

M2400009825

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS
2.50# ± .50#
3.00# ± .75#
4.00# ± 1.00#

SERIAL NO. C16225166DATE 11-15-95TESTER DA

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#	COMMENTS
PULL #1	2.28	2.43	2.46	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.34	2.42	2.48	
PULL #3	2.28	2.40	2.46	
PULL #4	2.32	2.42	2.50	
PULL #5	2.26	2.47	2.44	
TOTAL	11.48	12.14	12.54	
AVG.	2.29	2.42	2.50	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.24	3.30		
PULL #2	3.23	3.34		
PULL #3	3.13	3.32		
PULL #4	3.17	3.27		
PULL #5	3.13	3.18		
TOTAL	15.90	16.41		
AVG.	3.18	3.28		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.21	4.25		4.20
PULL #2	4.13	4.16		4.26
PULL #3	4.24	4.32		4.22
PULL #4	4.00	4.07		4.32
PULL #5	4.16	4.15		4.33
TOTAL	20.74	20.95		21.33
AVG.	4.14	4.19		4.26

FSN, PART NO. AND ITEM DESCRIPTION 1005-01-240-2136 RIFLE, M24, 7.62MM		SERVICEABLE TAG-MATERIEL	
		NEXT INSPECTION DUE/OVER: AGE DATE	CONDITION CODE B
SERIAL NO./LOT NO. C6225166		UNIT OF ISSUE RM	INSPECTION ACTIVITY IAA 26 Jan. 94 DoI Maint Div 3017 Inspected By <i>[Signature]</i>
CONTRACT OR PURCHASE ORDER NO.	QUANTITY 1		
REMARKS			

WARNING: Unauthorized persons removing, defacing, or destroying this tag may be subject to a fine of not more than \$1,000 or imprisonment for not more than one year or both. (18 USC 1361)

DD FORM 1574, 1 OCT. 68 * U.S. GPO: 1985-481-841

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6225166

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 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. #	BARBER - M24 0009790 OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			3/7	AC
	G) Safety Off Force	3	3	3			3/7	AC
	H) Trigger Pull Test & Retainability							
	I) Firing Pin Indent	.0215	.0205	.0210			3/7	AC
	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	234	234	229	230	224	3/1/96	WS
	C) Function							
660	Pack							

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06225166
2 Jan 1900

CENTROIDAL DISTANCES

0 TO	1	1.24386
1 TO	2	.511434
1 TO	3	.561712
1 TO	4	.644957
1 TO	5	.314428

25¹
4 3

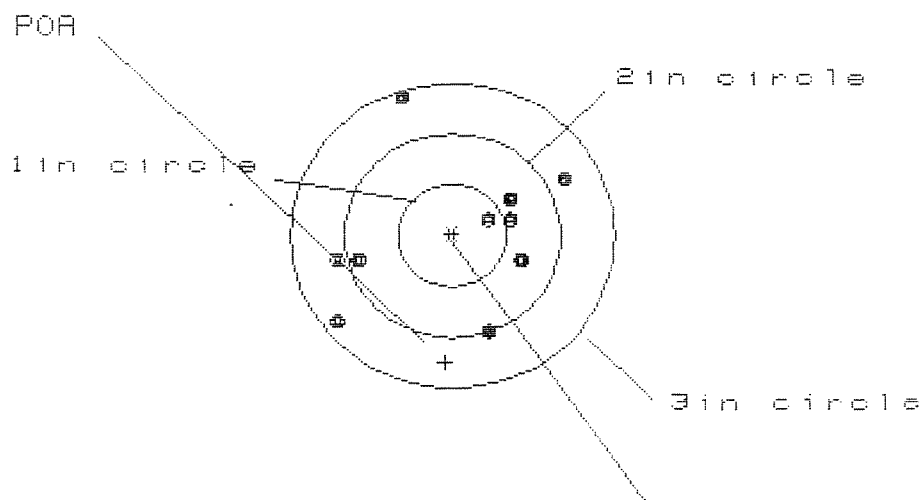
+ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0704
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .9286
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .931265
THE AMR FOR THIS RIFLE IS: .9632

2 Jan 1968

FILE:/PATTERNING/CENTERFIRE_PATT/C8225166

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 6

3 in = 10

HS = 2.143

VS = 2.264

ES = 2.565

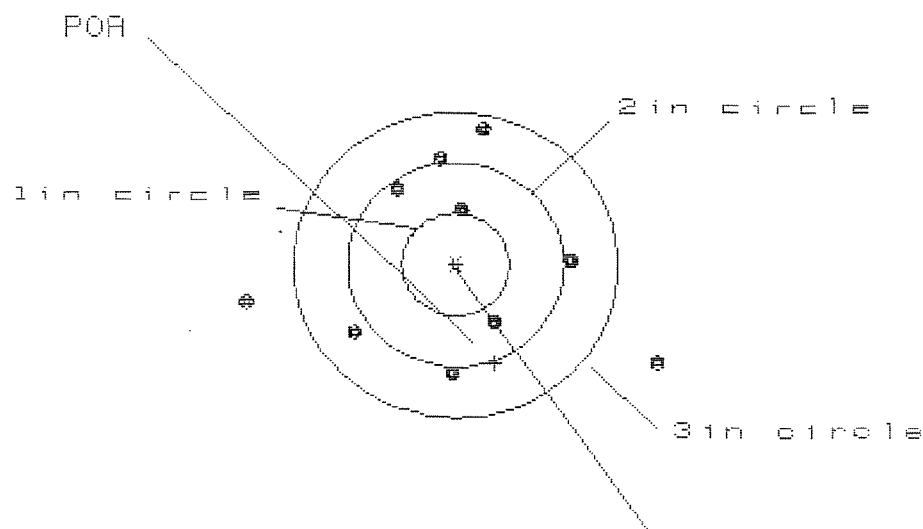
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.031	.982	.837
MINIMUM X	-1.112	-1.161	-1.247
MAXIMUM Y	1.358	.694	.604
MINIMUM Y	-.906	-.755	-.845
CENTROID X	.068	.117	.262
CENTROID Y	1.242	1.091	1.181
POA TO CENTROID in.	1.244	1.098	1.210
MIN RADIUS	.364	.404	.240
MEAN RADIUS	.918	.850	.731
MAX RADIUS	1.428	1.364	1.264
HORIZONTAL SPREAD	2.143	2.143	2.084
VERTICAL SPREAD	2.264	1.449	1.449
EXTREME SPREAD	2.565	2.565	2.236
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	10		

2 Jan 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C8225166

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 0

2 in = 3

3 in = 8

HS= 3.728

VS= 2.456

GS= 3.780

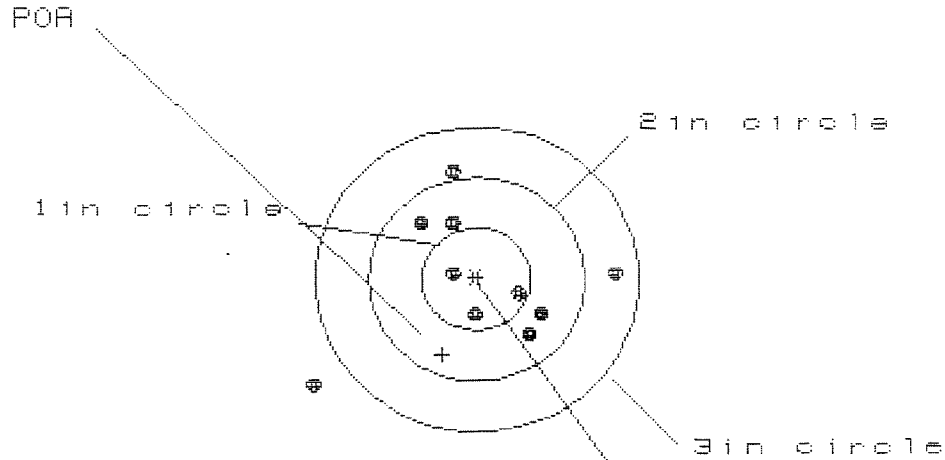
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.829	1.270	1.050
MINIMUM X	:	-1.899	-1.695	-1.983
MAXIMUM Y	:	1.377	1.266	1.205
MINIMUM Y	:	-1.079	-1.190	-1.251
CENTROID X	:	-.358	-.562	-.350
CENTROID Y	:	.959	1.070	1.131
POA TO CENTROID in.	:	1.024	1.209	1.184
MIN RADIUS	:	.515	.489	.344
MEAN RADIUS	:	1.152	1.079	.961
MAX RADIUS	:	2.094	1.764	1.295
HORIZONTAL SPREAD	:	3.728	2.965	2.041
VERTICAL SPREAD	:	2.456	2.456	2.456
EXTREME SPREAD	:	3.780	3.000	2.481
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		8	

2 Jan 1988

FILE:/PATTERNING/CENTERFIRE_PATT/06225166

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 3

2in = 7

3in = 9

HS= 2.000

VS= 2.095

GS= 3.023

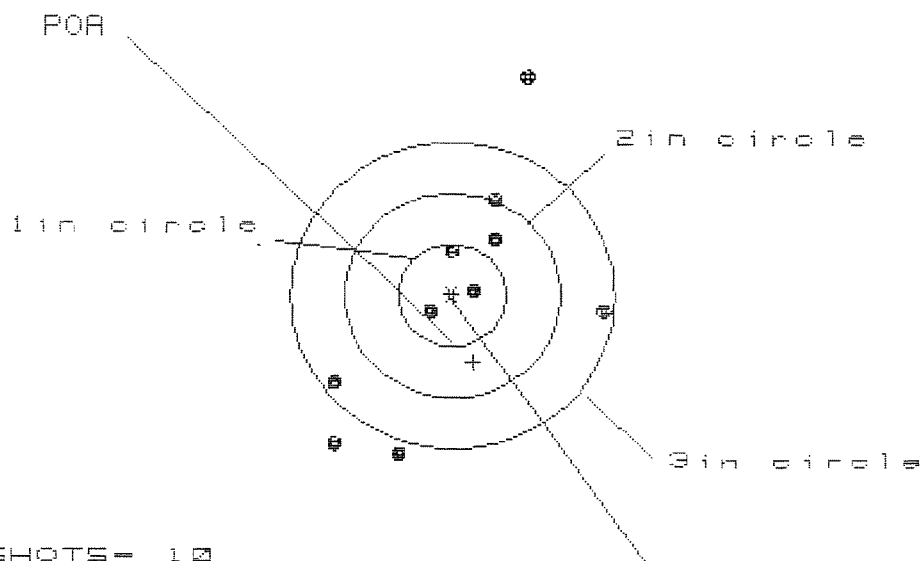
CENTROID *

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.258	1.086	.581
MINIMUM X	:	-1.550	-.723	-.588
MAXIMUM Y	:	1.071	.957	.955
MINIMUM Y	:	-1.024	-.665	-.667
CENTROID X	:	.316	.488	.353
CENTROID Y	:	.738	.852	.854
POA TO CENTROID in.	:	.803	.982	.924
MIN RADIUS	:	.240	.359	.264
MEAN RADIUS	:	.809	.689	.623
MAX RADIUS	:	1.858	1.086	.996
HORIZONTAL SPREAD	:	2.808	1.809	1.169
VERTICAL SPREAD	:	2.095	1.622	1.622
EXTREME SPREAD	:	3.023	1.880	1.794
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

2 Jan 1988

FILE:/PATTERNING/CENTERFIRE_PATT/06225166

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 3

2in = 5

3in = 7

HS= 2.563

VS= 3.758

GS= 4.027

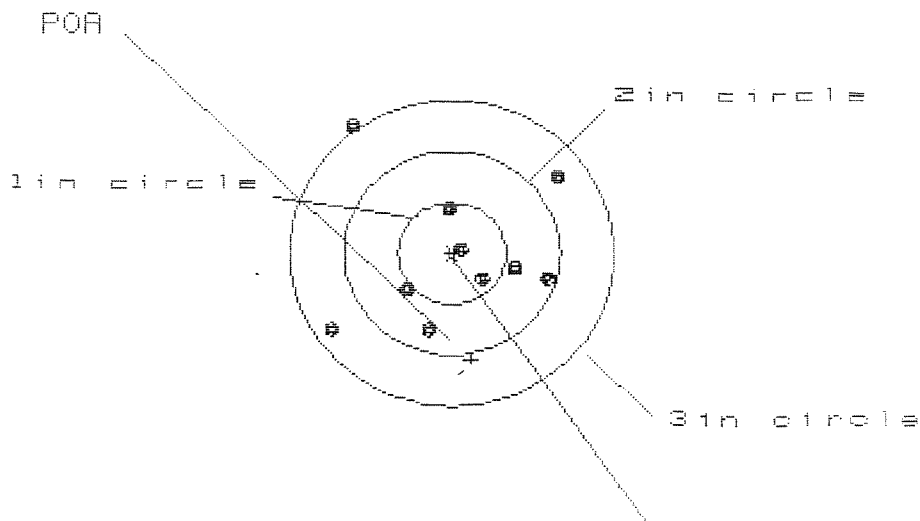
CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.422	1.497	1.373
MINIMUM X	:	-1.141	-1.066	-1.190
MAXIMUM Y	:	2.167	1.172	1.019
MINIMUM Y	:	-1.591	-1.350	-1.503
CENTROID X	:	-.197	-.272	-.148
CENTROID Y	:	.654	.413	.566
POA TO CENTROID in.	:	.683	.494	.585
MIN RADIUS	:	.164	.182	.176
MEAN RADIUS	:	1.111	1.013	.893
MAX RADIUS	:	2.270	1.575	1.606
HORIZONTAL SPREAD	:	2.563	2.563	2.563
VERTICAL SPREAD	:	3.758	2.522	2.522
EXTREME SPREAD	:	4.027	2.828	2.670
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		7	

2 Jan 1900

FILE:/PATTERNING/CENTERFIRE_PATT/06225166

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 7

3 in = 9

HS= 2.156

VS= 2.040

GS= 2.669

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.003	.903	.746
MINIMUM X	:	-1.153	-1.253	-.702
MAXIMUM Y	:	1.254	.927	.847
MINIMUM Y	:	-.786	-.647	-.670
CENTROID X	:	-.181	-.081	.076
CENTROID Y	:	1.050	.911	.991
POA TO CENTROID in.	:	1.065	.914	.994
MIN RADIUS	:	.051	.157	.161
MEAN RADIUS	:	.786	.680	.578
MAX RADIUS	:	1.547	1.410	1.128
HORIZONTAL SPREAD	:	2.156	2.156	1.448
VERTICAL SPREAD	:	2.040	1.574	1.517
EXTREME SPREAD	:	2.669	2.669	1.945
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	