

C6225190

MODEL 700TM M24

Model **700 M24TM**

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

Smead

No. 2152 FI

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER

(c) Reparations-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

FFL: [] [] [] [] [] []

Contact / Condition	Problems	Estimate	History / Status	Shipping / Billing												
Contact Information Phone: Fax: Email: Comments:	Received Condition Fair Condition Notes: CSR Notes:		Accessories Received <table border="1"> <thead> <tr> <th>Code</th> <th>Desc</th> <th>Qty</th> </tr> </thead> <tbody> <tr> <td>A007</td> <td>With Studs</td> <td>3</td> </tr> <tr> <td>A010</td> <td>Hard Case</td> <td>1</td> </tr> <tr> <td>A017</td> <td>Scope Bases</td> <td>3</td> </tr> </tbody> </table>		Code	Desc	Qty	A007	With Studs	3	A010	Hard Case	1	A017	Scope Bases	3
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	TRLW
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	RL
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	TRLW
655	FINAL INSPECT	11-8-04	RTL
660	PACK	11-8-04	OA
		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

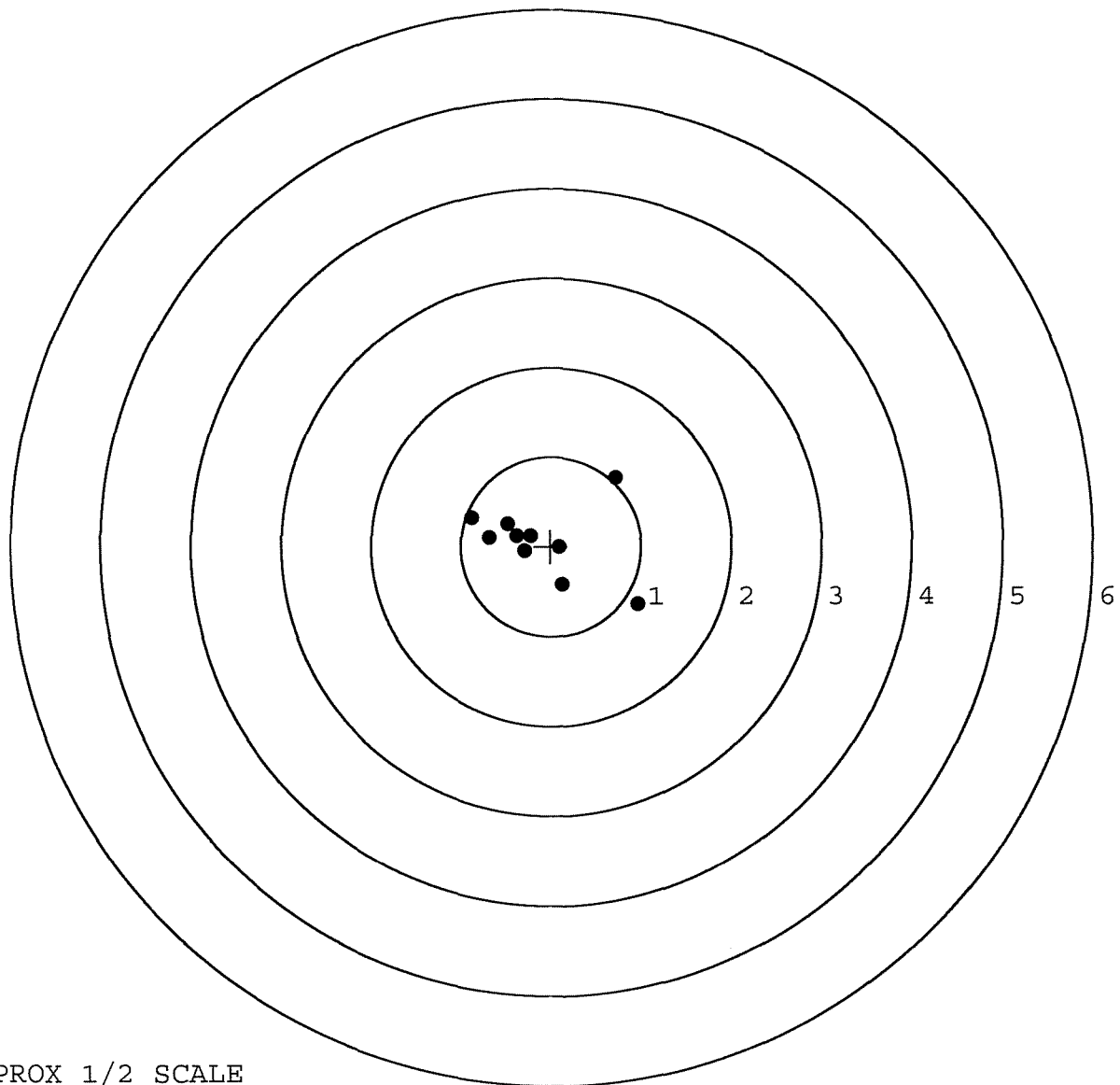
MAX RADIUS: 1.274

MEAN RADIUS: 0.558

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10

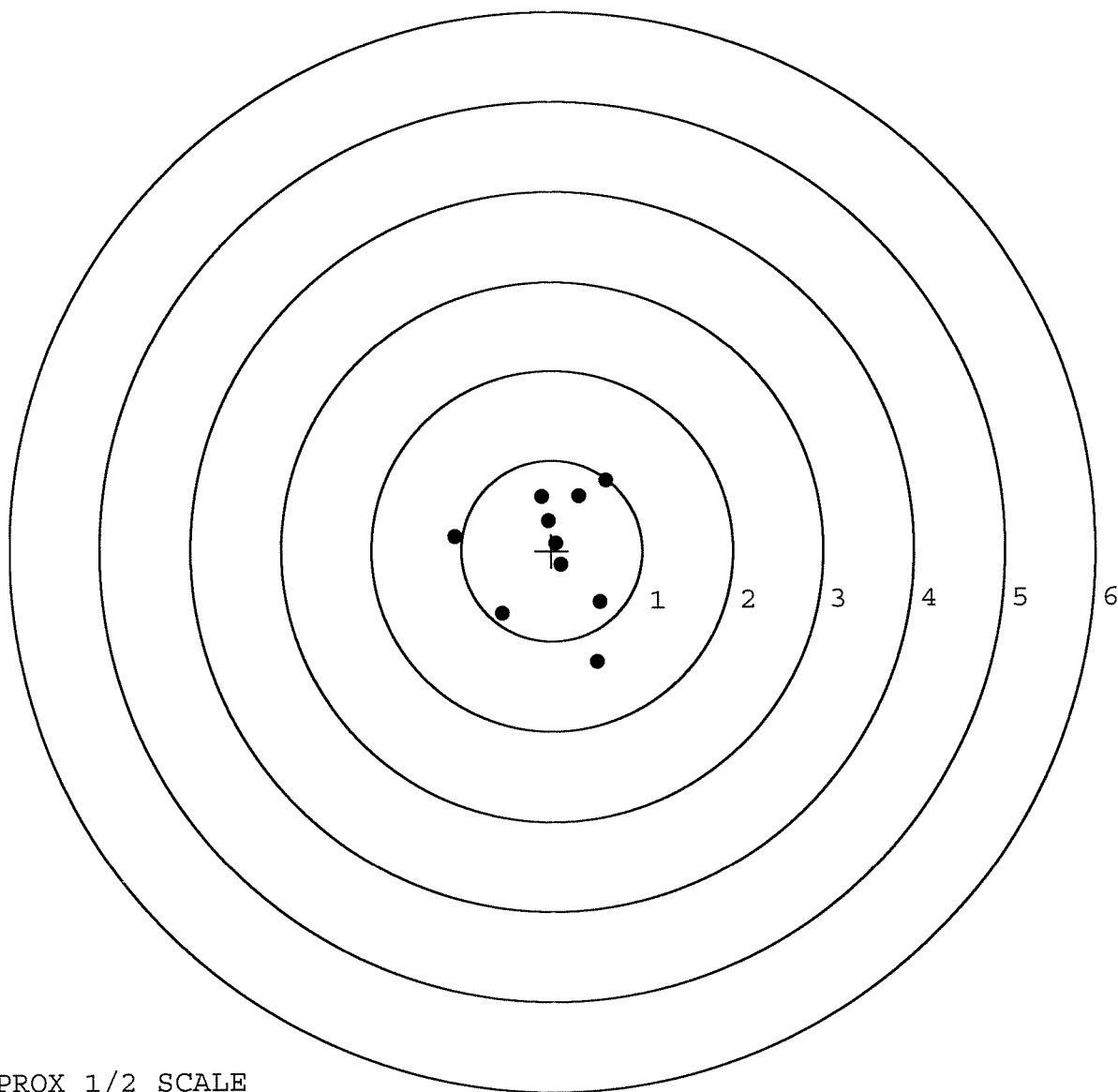


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6225190. __0
 TARGET NUMBER: 2
 FILE DATE: 03/09/2003
 FILE TIME: 11:00

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

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



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

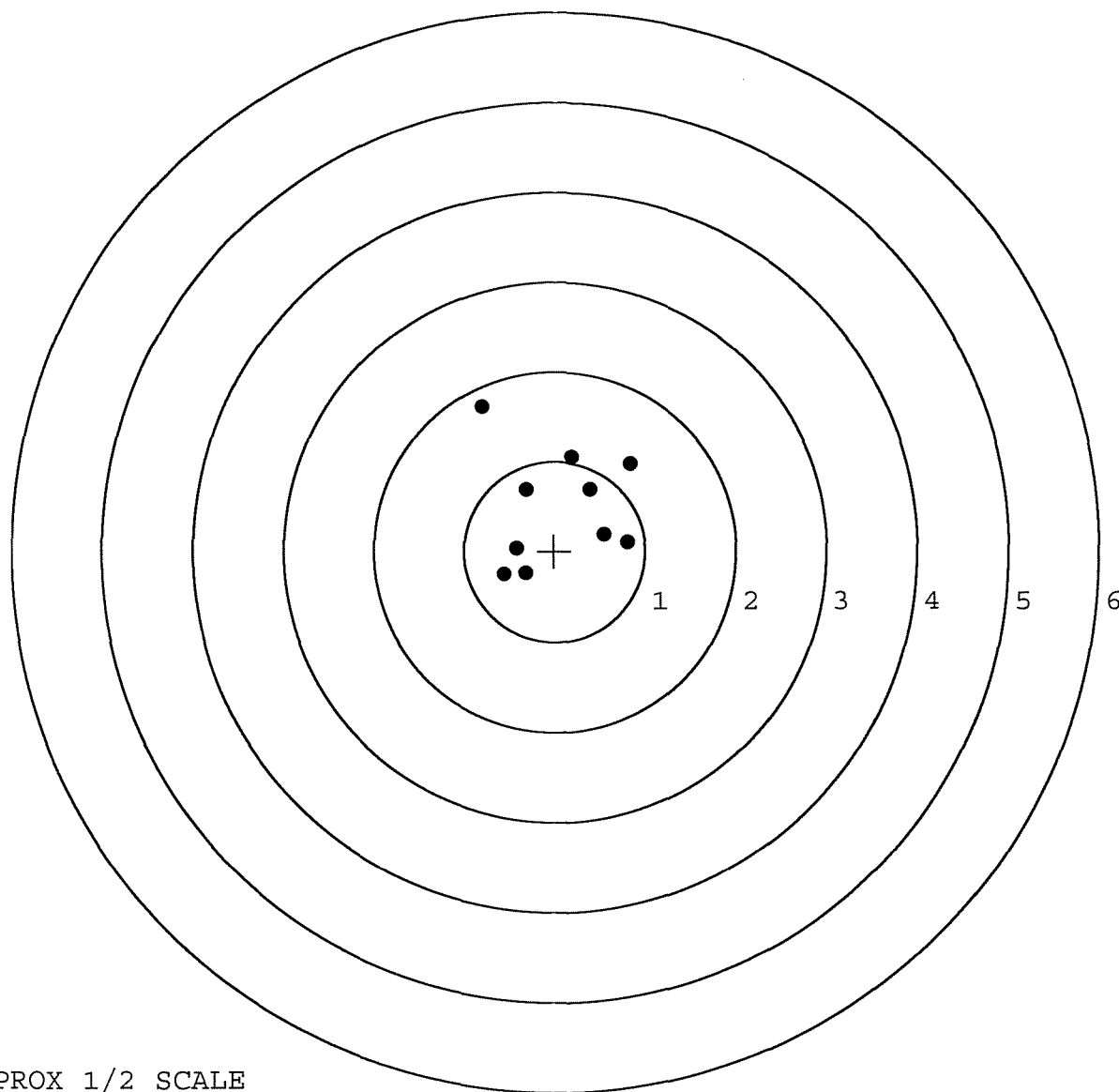
MAX RADIUS: 1.404

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

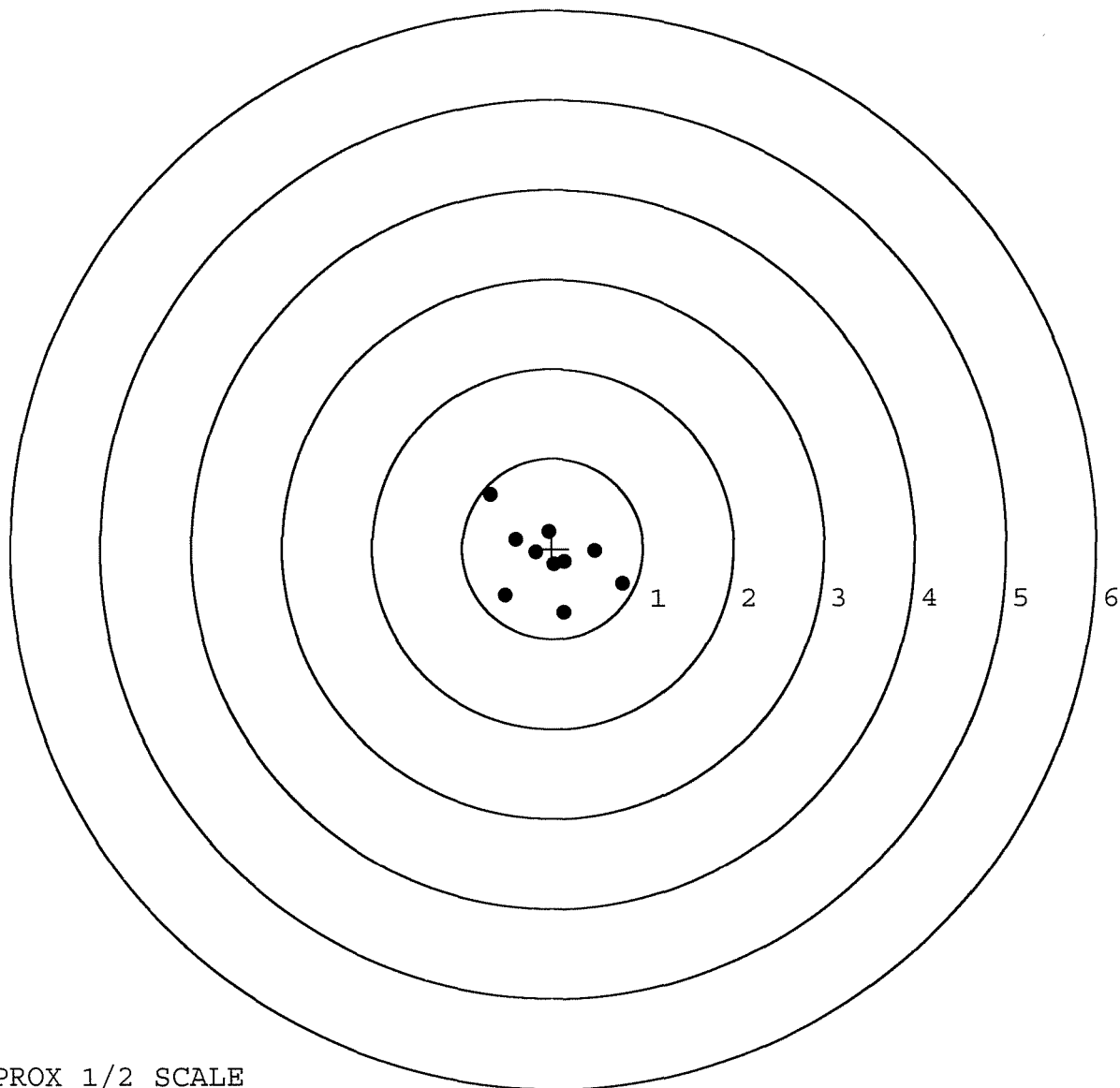
MAX RADIUS: 0.969

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

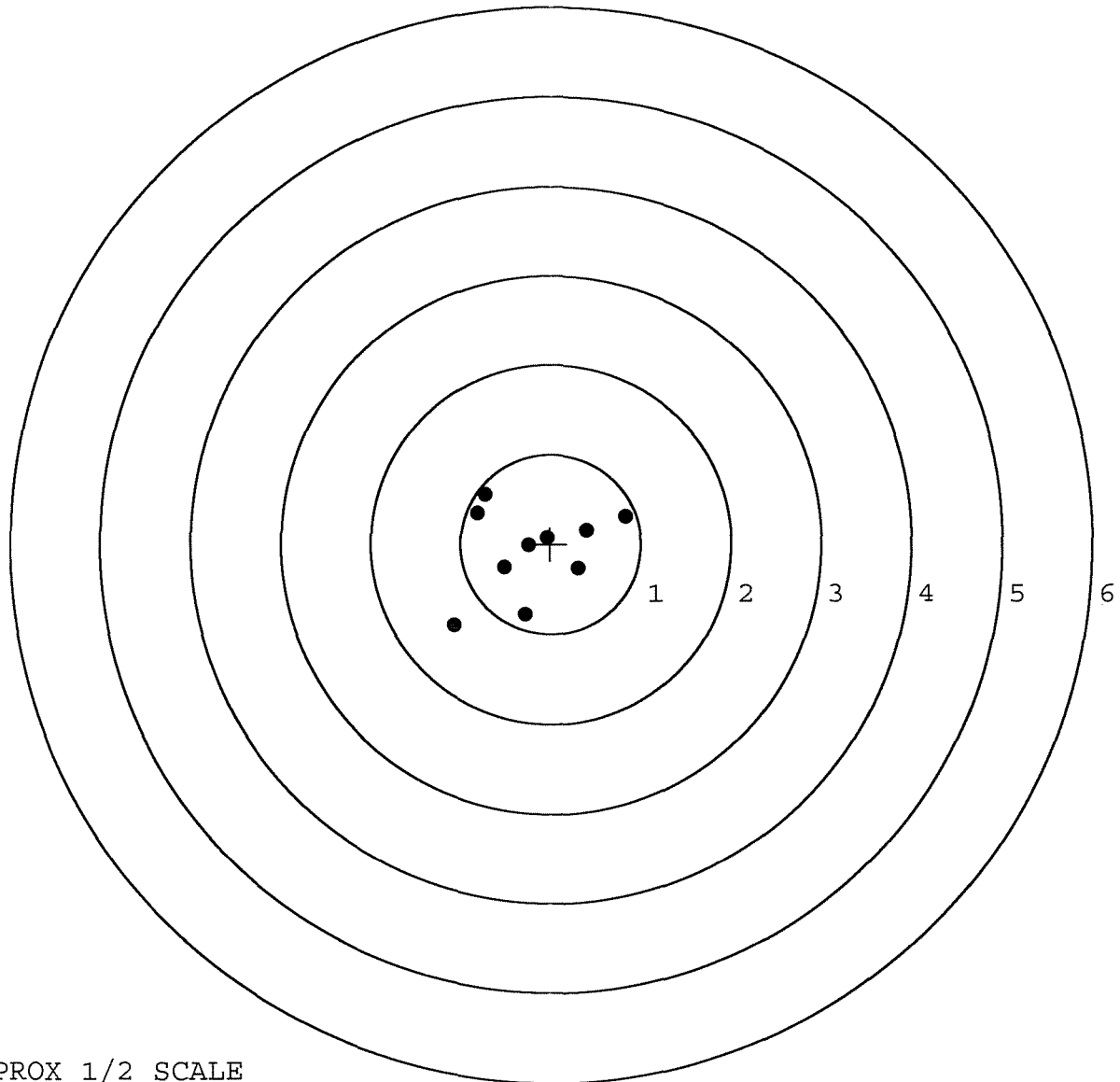
MAX RADIUS: 1.193

MEAN RADIUS: 0.644

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 8

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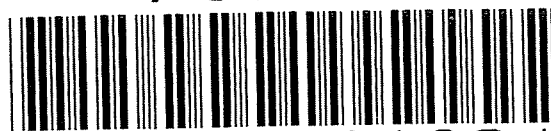
TARGET APPROX 1/2 SCALE

nagletj	2/6/2003	7:53 AM	CAPS	NUM	INS	SCRL

Serial Number:

C6225190

Model: 700



RE00061094

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

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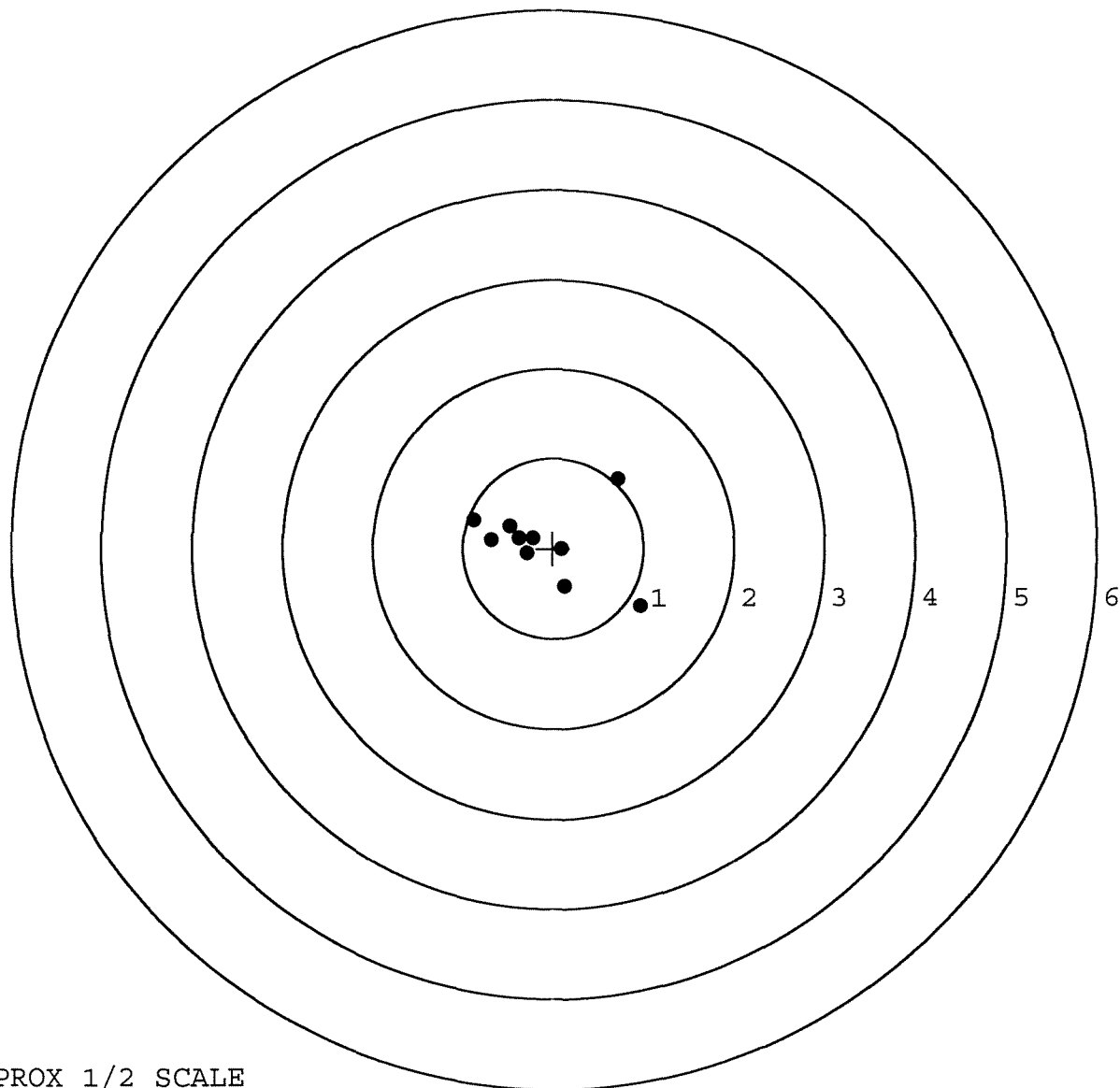
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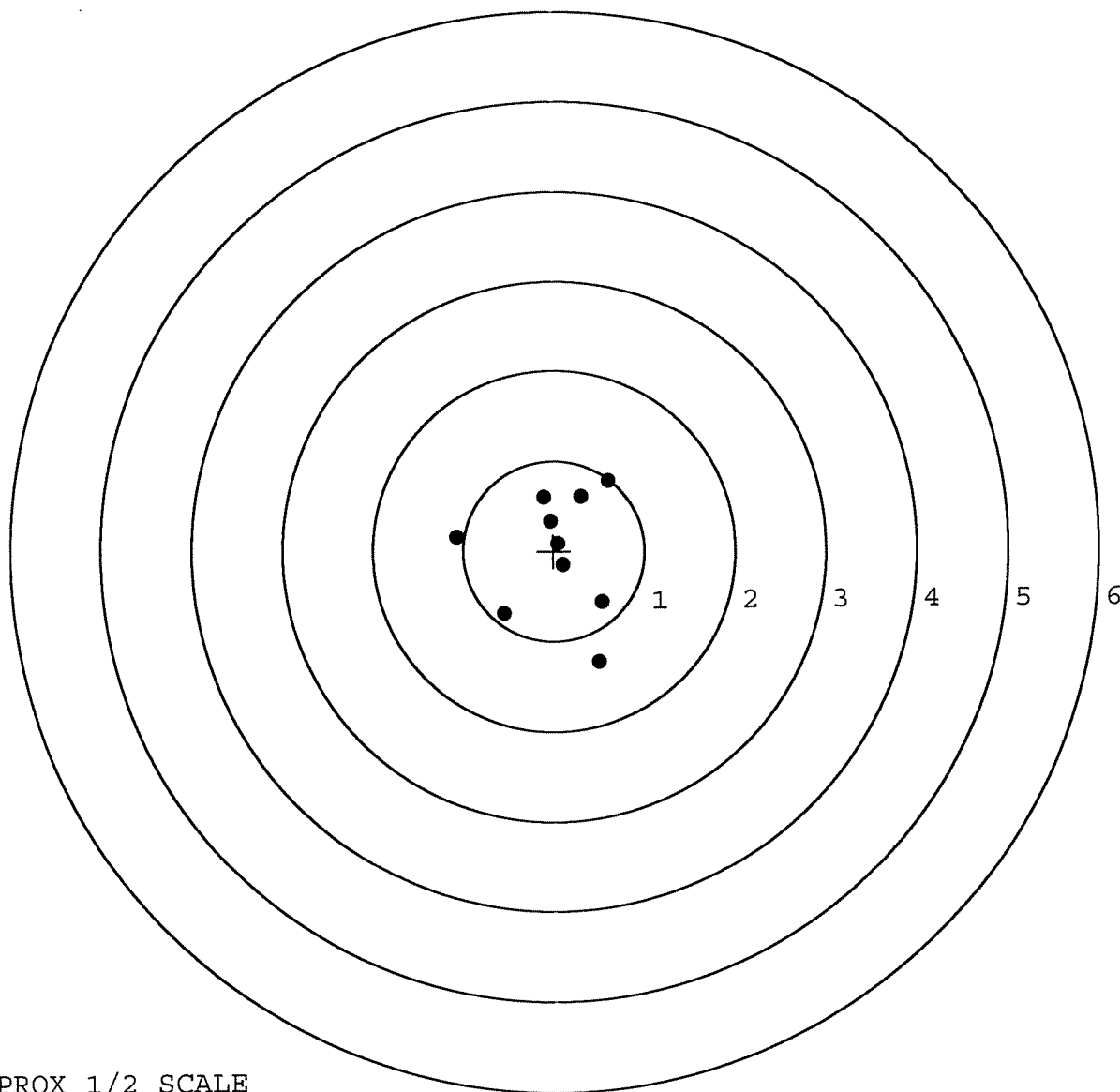


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TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6225190. __ 0

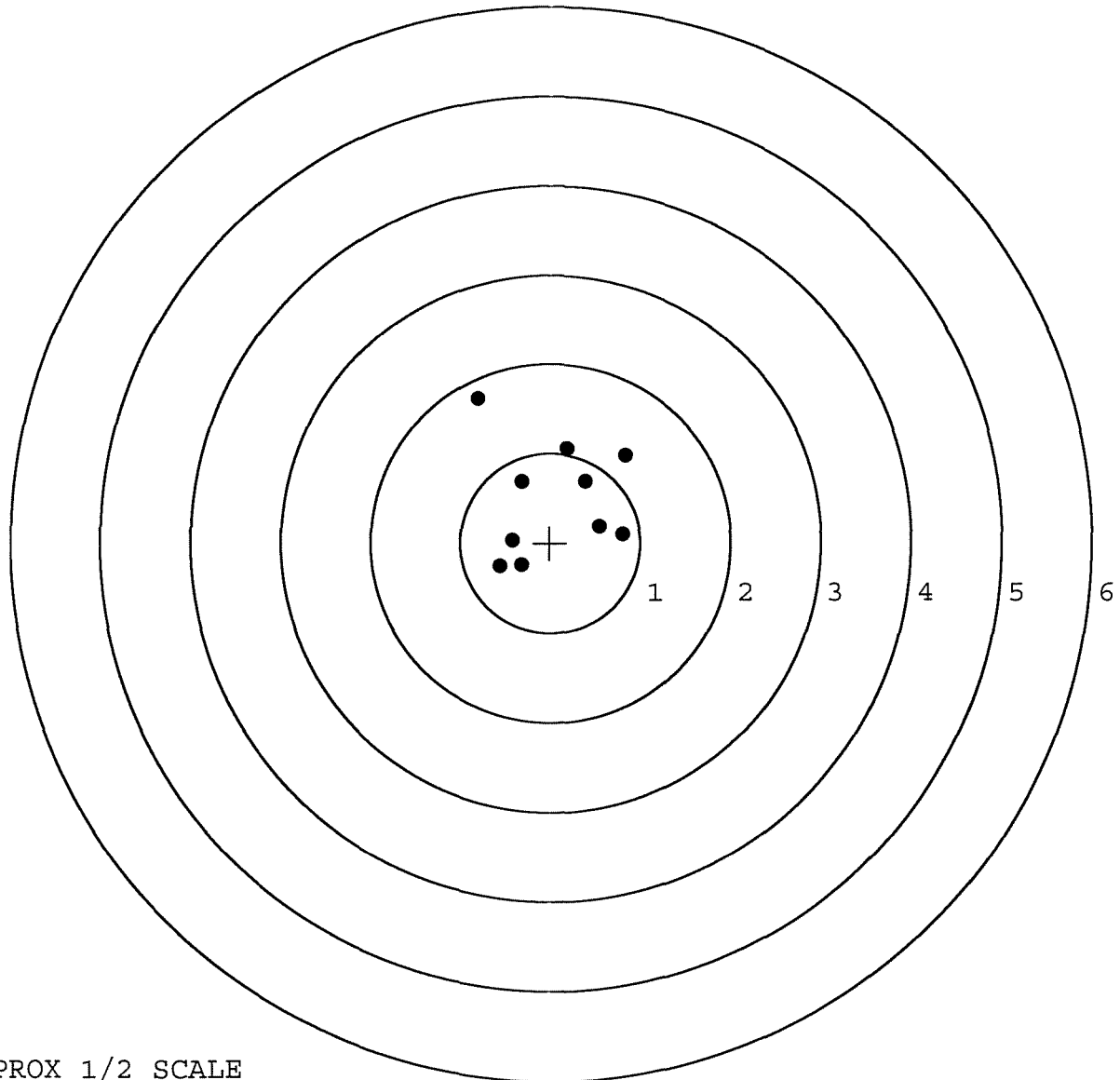
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SERIAL NUMBER: C6225190. __0

TARGET NUMBER: 4

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FILE TIME: 11:00

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POA TO CENTROID: 0.118

HORZ SPREAD: 1.468

VERT SPREAD: 1.309

GROUP SPREAD: 1.767

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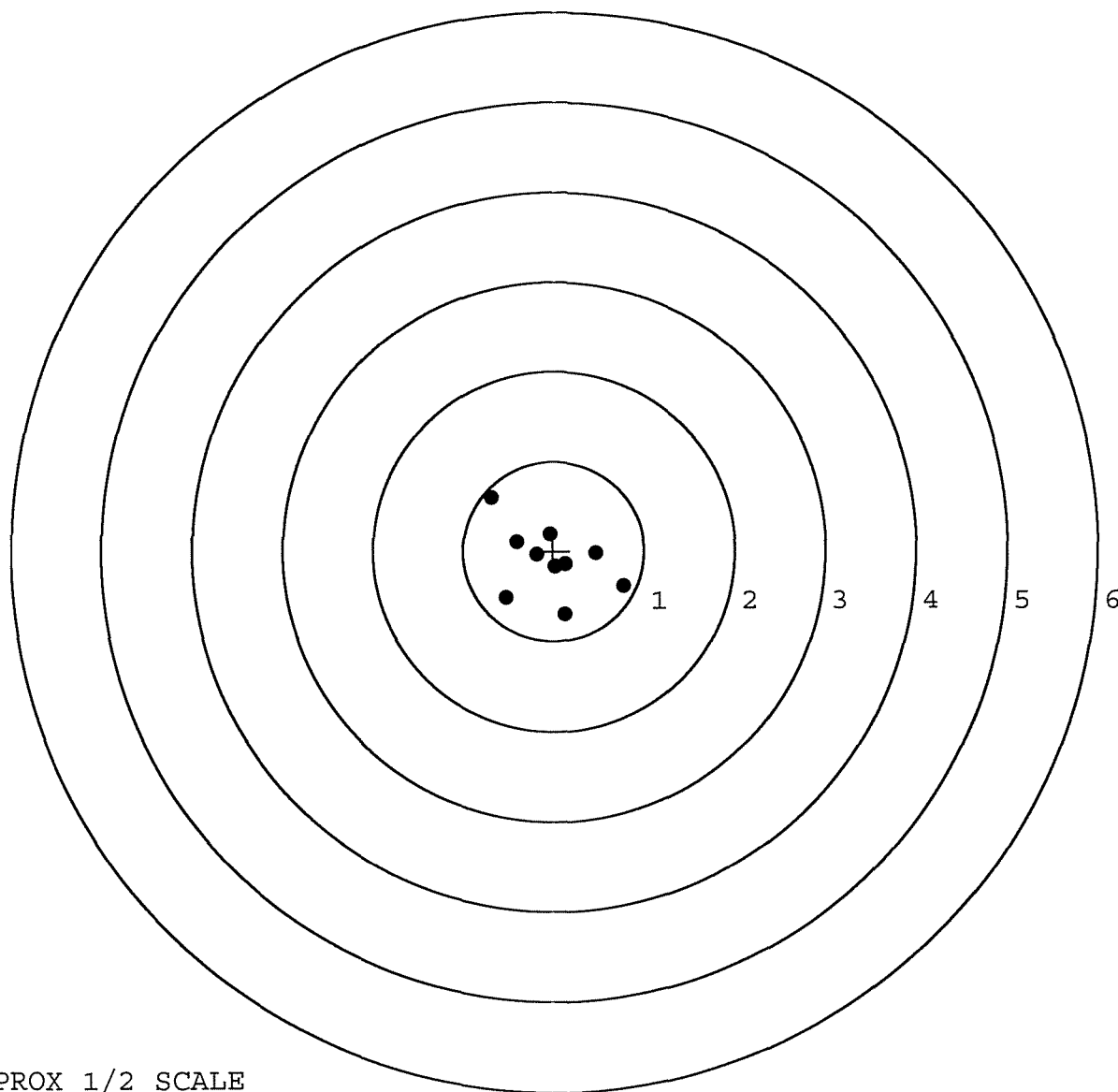
MEAN RADIUS: 0.474

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POINT#	X	Y
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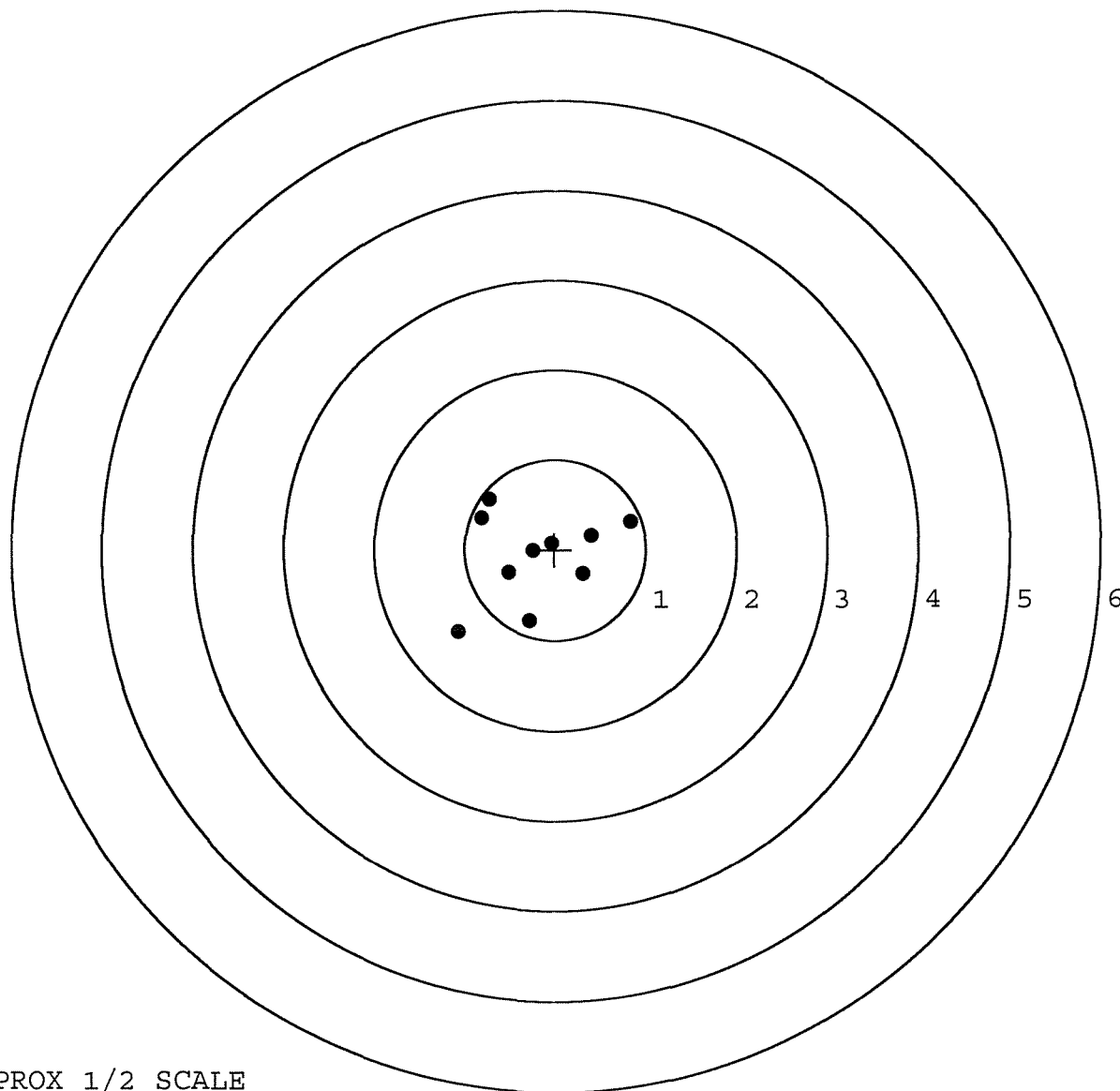


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 FILE TIME: 11:00

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8:	-1.072	-0.915
9:	-0.815	0.344
10:	-0.733	0.548



TARGET APPROX 1/2 SCALE

SERIAL # 06225190INSPECTED BY: RTLDATE REC'D: 2-4-03DATE 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
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600	PROOF	2-13-03	AL
605	CHECK HEADSPACE	2-13-03	AL
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	GA
625 A	FINAL ASSEMBLY	3-6-03	RU
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	BA
		SHIP DATE	
	QAR INSPECTION DATE		

INITIALS SWS	CUSTOMER ORDER NO. 011-81-611-744-4441		W/SCOPE W/1 SWIVEL		Scope # 87-1124	
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: 498287 C.O.D

ACCOUNT NUMBER		ACCOUNT NUMBER N/C		WRITE ☐		PROM. DATE		ESTIMATED		VIA UPS		
GUN CONDITION										REPAIR CHARGE		
☐ NEW										EXCISE		
☐ LIGHTLY WORN										TAX		
☐ WORN										INSURANCE		
☐ VERY WORN										UPS		
☐ UNREPAIRABLE										PARCEL POST		
☐ MARRED										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		96003					
REPAIRMAN		PROOF	CLEAN	TEST	TARGET	PATTE	
<i>RW</i>		<i>c</i>	<i>c</i>	<i>c</i>	<i>c</i>		
GALLERY TESTER	DATE	DATE	DATE	DATE	DATE	DATE	
<i>RW</i>		<i>9-1-99</i>	<i>9-3-99</i>	<i>9-3-99</i>			

OFFICE COPY

RD6925 REV. 7

BARRER - M24 M2400010292

BARBER - M24 0040955 M2400010294

DA FORM 2765-1, APR 76

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DOC IDENT	ROUT IDENT	FSC	NIN	ADD	UNIT OF ISSUE	QUANTITY	REQUISITIONER	DATE	SERIAL	SUPPLEMENTARY ADDRESS	FUND	DISTRIBUTION	PROJECT	PRIORITY	REQ DEL DATE	ADV STAT																																																																								
SEND TO: JFKSWCS REQUEST IS FROM: PBO, 1st BN, 1st SFG (A) UNIT 35123 APO, AP 96376-5123 Okinawa, Japan																																																																																								
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REQUEST FOR ISSUE OR TURN-IN (DA Pam 710-2-1)

U.S. GOVERNMENT PRINTING OFFICE 1995 398-905

CRC 5207



1A

DD FORM 1348-1A, JUL 91 ISSUE RELEASE/RECEIPT DOCUMENT

1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27																																	
DI	OD	CE	NT	RI	FROM	M	NS	IS	QUANTITY	SUPP- MENTARY ADDRESS	S	F	DIS- TRI- BU- TION	PRO- JECT	P	R	RDD EEA QLT DE	A	RI	OC	OG	CM	OG	CM	OG	CM																																	
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FTE										EA 00005										W31G1Z																																							
9142-000Z										1005-01-240-2136										Serial Numbers: Box 1: C225190/871127, C6225218 Box 2: C6225339, C225343/881219, C6348920																																							
1. TOTAL PRICE										2. SHIP FROM										3. SHIP TO																																							
UNIT PRICE										DOLLARS										CTS																																							
DOLLARS										CTS										4. MARK FOR																																							
\$5,14500										\$27,725 00																																																	
5. DOC DATE										6. NMFC										7. FRT RATE										8. TYPE CARGO										9. PS																			
10. QTY. REC'D										11. UP										12. UNIT WEIGHT										13. UNIT CUBE										14. UFC										15. SL									
16. FREIGHT CLASSIFICATION NOMENCLATURE																																																											
17. ITEM NOMENCLATURE RIFLE, 7.62 MM Sniper M24																																																											
18. TY CONT										19. NO CONT										20. TOTAL WEIGHT										21. TOTAL CUBE																													
22. RECEIVED BY																						23. DATE RECEIVED																																					
ZIP CODE 96376																																																											

PREVIOUS EDITION MAY BE USED



1A

SHIPPING CONTAINER TALLY

1 2 3 4 5 6 7 8 9 10 11 12 13 14 15 16 17 18 19 20 21 22 23 24 25 26 27 28 29 30 31 32 33 34 35 36 37 38 39 40 41 42 43 44 45 46 47 48 49 50

REQUISITION AND INVOICE / SHIPPING DOCUMENT

Form Approved
OMB No. 0704-0246
Expires Dec 13, 1996

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 the 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 (0704-0246), 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 Llioni, 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 MATERIAL AND / OR SERVICES (b)				UNIT OF ISSUE (c)	QUANTITY REQUESTED (d)	SUPPLY ACTION (e)	TYPE CONTAINER (f)	CONTAINER 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 -----Nothing Follows-----				EA	5	5			5,145.00	25,725.00												
16. TRANSPORTATION VIA MATS OR MSTs CHARGEABLE TO												17. SPECIAL HANDLING											
18. RECEIVED SHIPMENT TALLY	ISSUED BY	TOTAL CONTAINERS	TYPE CONTAINER	DESCRIPTION				TOTAL WEIGHT	TOTAL CUBE	19. RECEIVED SHIPMENT	CONTAINERS RECEIVED EXCEPT AS NOTED	DATE (YYMMDD)	BY	SHEET TOTAL									
															25,725.00								
	CHECKED BY											QUANTITIES RECEIVED EXCEPT AS NOTED	DATE (YYMMDD)	BY	GRAND TOTAL								
	PACKED BY										POSTED	DATE (YYMMDD)	BY	20. RECEIVER'S VOUCHER NO.									
				TOTAL																			

DD Form 1149, DEC 93

51 52 53 54 55 56 57 58 59 60 61 62 63 64 65 66 67 68 69 70 71 72 73 74 75 76 77 78 79 80 81 82 83 84 85 86 87 88 89 90 91 92 93 94 95 96 97 98 99 100
PREVIOUS EDITION MAY BE USED.

USAPPC V1.10

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

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

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

LEUPOLD & STEVENS, INC.MAILING: PO BOX 688
BEAVERTON OR 97075-0688
(503) 646-9171SHIPPING: 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**B** REMINGTON ARMS CO., INC.
I Attn:
L 14 HOEFLER AVE.
L ILION NY 13357**S** REMINGTON ARMS CO., INC.
H Attn:
I 14 HOEFLER AVE.
P ILION NY 13357**T**
O**T**
O

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

PATTERN #: ☐ 1 ☐

POA TO CENTROID: .177

MIN RADIUS : .594

MEAN RADIUS : 1.116

MAX RADIUS : 1.617

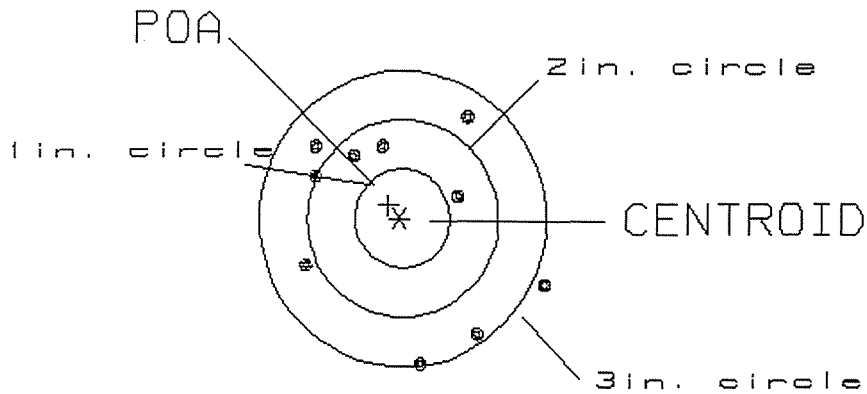
CENTROID X : .117

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

8

PATTERN #: ☐ 2 ☐

POA TO CENTROID: .435

MIN RADIUS : .179

MEAN RADIUS : 1.294

MAX RADIUS : 2.938

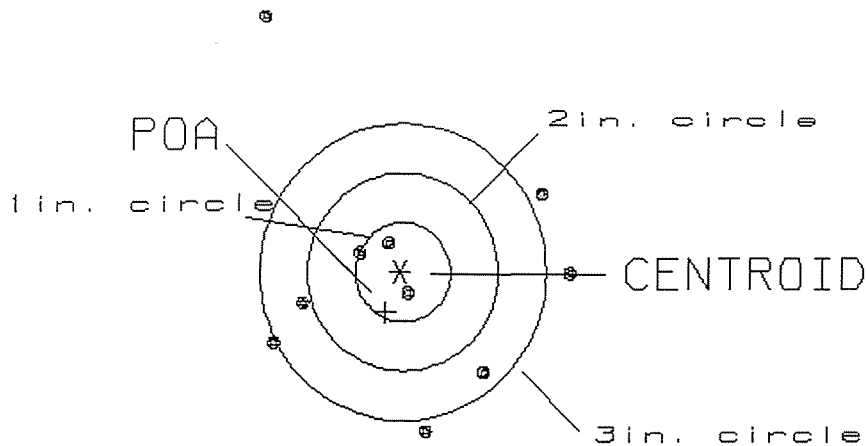
CENTROID X : .153

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

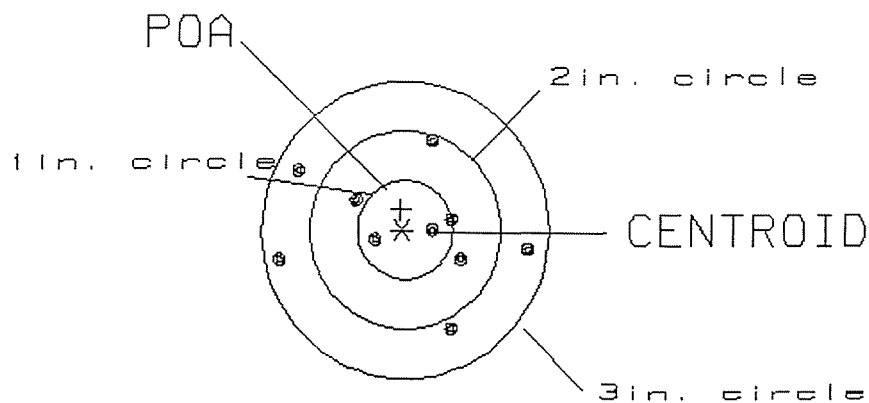
CENTROID X : .017

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

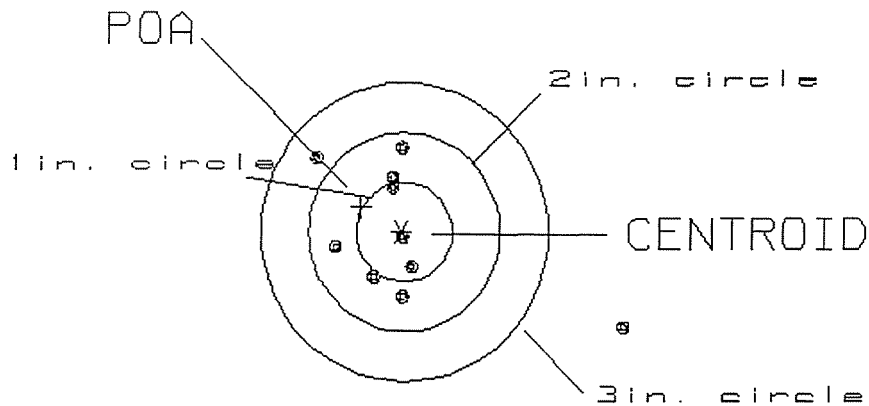
PATTERN #: ☐ 4 ☐

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

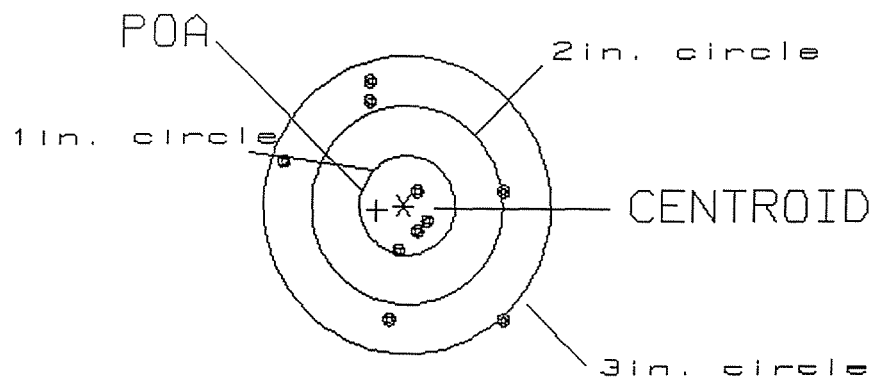
CENTROID X : .291

CENTROID Y : .052

9 Sep 1999

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

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

INIT.

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

Sn: 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: _____

5081

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # *C6225190*

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

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		9/13/88	RW
	E) Adjust Trigger Pull to Min. Setting and Stake		12/8/88	Ju WB
	F) Safety on Force	5 1/4 5# 5#	12 Sept 88	J.V. W.B.
	G) Safety off Force	3# 3# 3 1/4#	12 Sept 88	J.V. W.B.
	H) Trigger Pull Test & Retainability		12 Sept 88	J.V. W.B.
	I) Firing Pin Indent	.0215 .022 .0215	12 Sept 88	J.V. W.B.
	J) Assemble Stock		9/15/88	RW
	K) Assemble Swivel Studs		10-12 88	JSJ
	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	JSJ
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	JSJ
	B) Trigger Pull		10-14-88	JSJ
	C) Function		10-12-88	JSJ
660	Pack		10-21-88	JSJ

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

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

SERIAL NO. C-6225190DATE 12-SEPT-88TESTER JW 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

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

+ <----FOR

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

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CENTERFIRE PATTERNS

1

POA

1 in circle

2 in circle

3 in circle

OF SHOTS= 10

IN CIR

1 in = 2

2 in = 5

3 in = 9

HS= 2.195

VS= 2.299

GS= 2.812

CENTROID #

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

:

1.483

1.529

1.648

CENTROID Y

:

-.696

-.585

-.723

POA 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

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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	

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CENTERFIRE PATTERNS

3

POA

+

2 in circle

1 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

3 in circle

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	

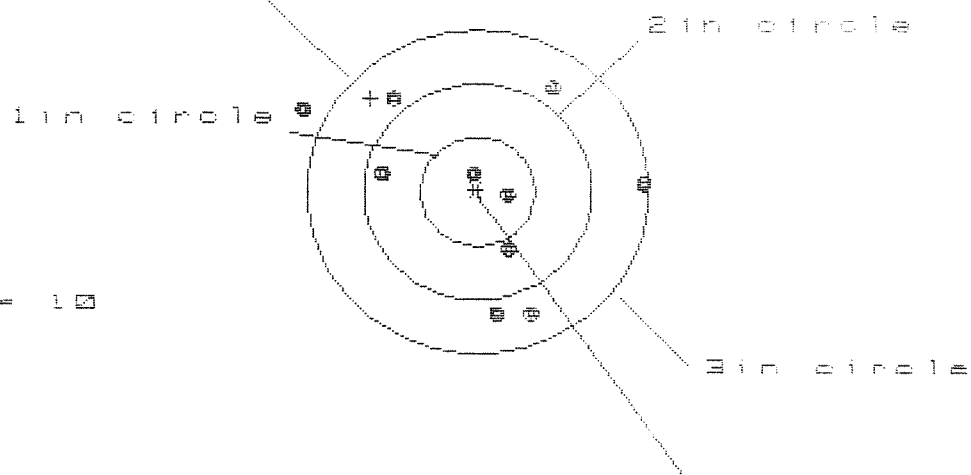
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CENTERFIRE PATTERNS

4

POA



OF SHOTS= 10

IN CIR

1in = 2

2in = 4

3in = 8

HS= 3.037

VS= 2.113

GS= 3.135

CENTROID #

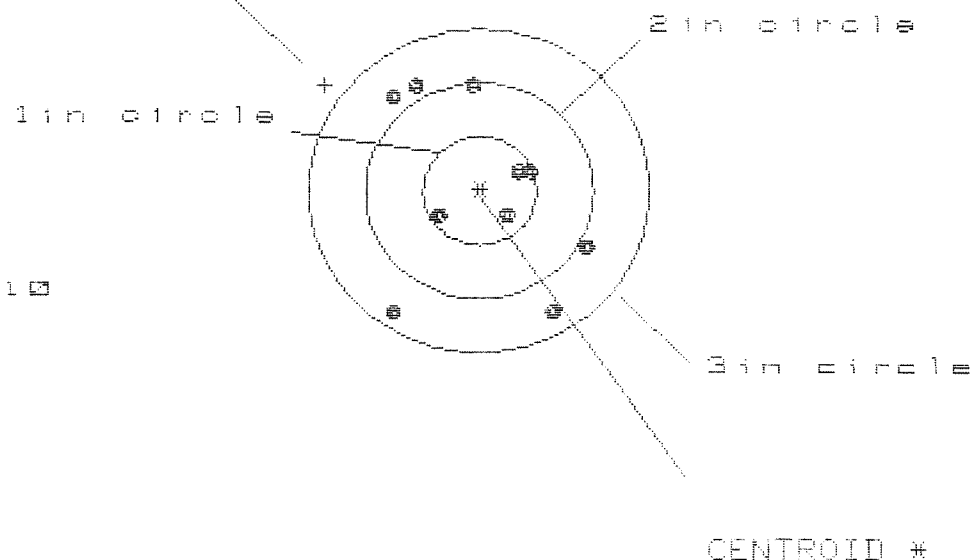
PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.462	1.287	.629
MINIMUM X	-1.575	-1.021	-.861
MAXIMUM Y	.935	1.024	1.038
MINIMUM Y	-1.178	-1.089	-1.075
CENTROID X	.937	1.112	.952
CENTROID Y	-.867	-.956	-.970
POA TO CENTROID in.	1.277	1.466	1.359
MIN RADIUS	.120	.095	.224
MEAN RADIUS	.972	.868	.814
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	

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CENTERFIRE PATTERNS # 5

POA



OF SHOTS= 10

IN CIR

1in = 3

2in = 4

3in = 10

HS= 1.7800

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	