

C6225284

MODEL 700™ M24

Model 700 M24™

Action

Barrel Length

Capacity

Order No. 5715

*Includes 1 in chamber.



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

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

SERIAL NO. C6225284DATE 1/10/88TESTER J. A. 20-8

	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

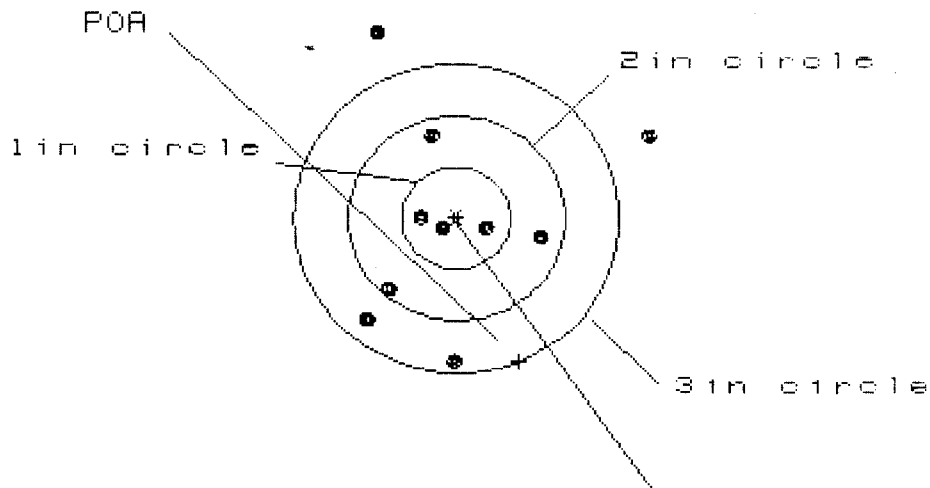
$\frac{3}{2}$
 $\frac{4}{4}$
 $\frac{5}{5} + \text{-----POB}$

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: 1.14098
 THE AMR FOR THIS RIFLE IS: .8906

18 Nov 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C6225284

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

CENTROID *

IN CIR

1 in - 3

2 in - 6

3 in - 8

HS- 2.548

VS- 3.193

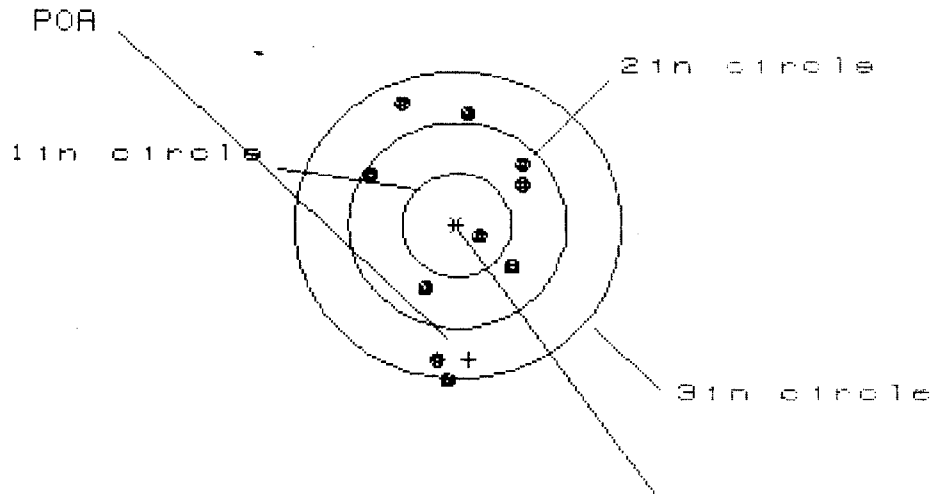
GS- 3.263

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/C62252B4

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

CENTROID #

IN CIR

1 in = 1

2 in = 6

3 in = 9

HS= 1.363

VS= 2.735

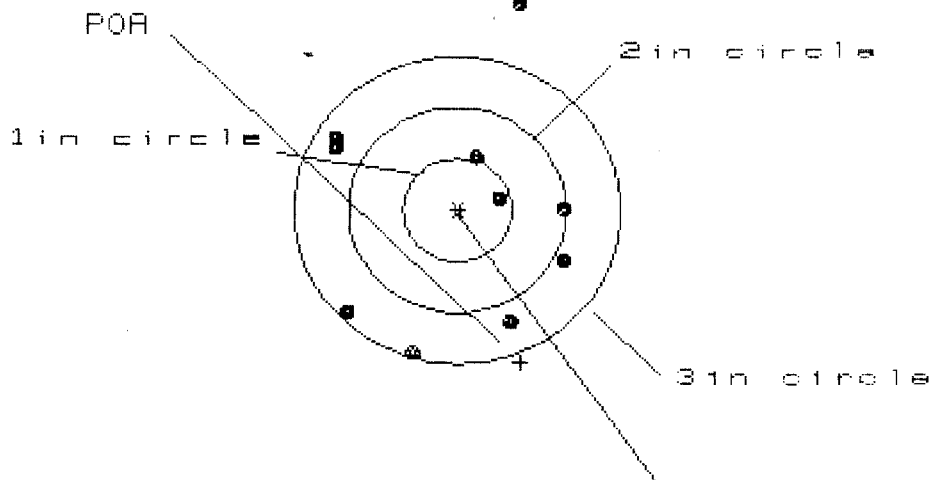
GS= 2.779

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/06225284

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

CENTROID #

IN CIR.

1 in = 1

2 in = 3

3 in = 6

HS= 2.164

VS= 3.343

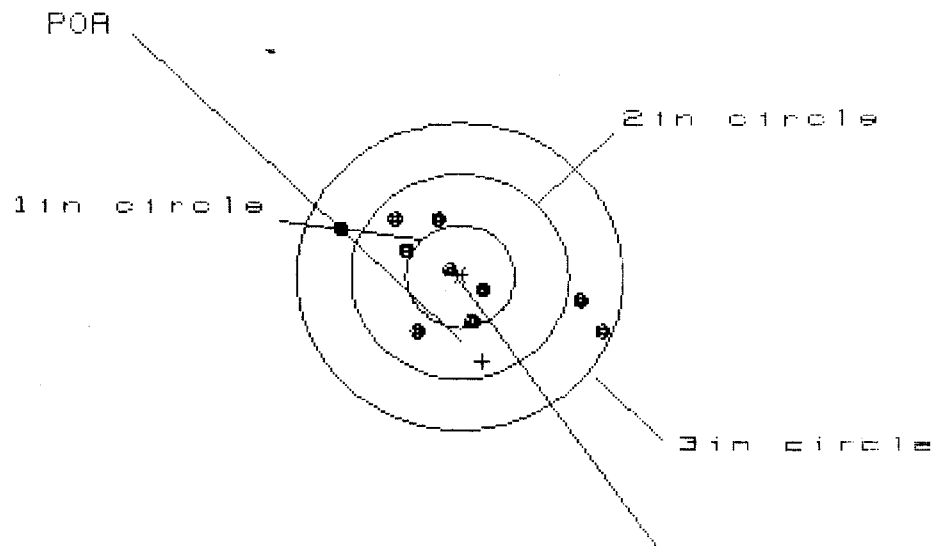
GS= 3.481

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	

18 Nov 1988

FILE:/PATTERNING/CENTERFIRE_PATT/082252B4

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in - 3

2in - 7

3in = 10

HS- 2.387

VS= 1.119

GS= 2.606

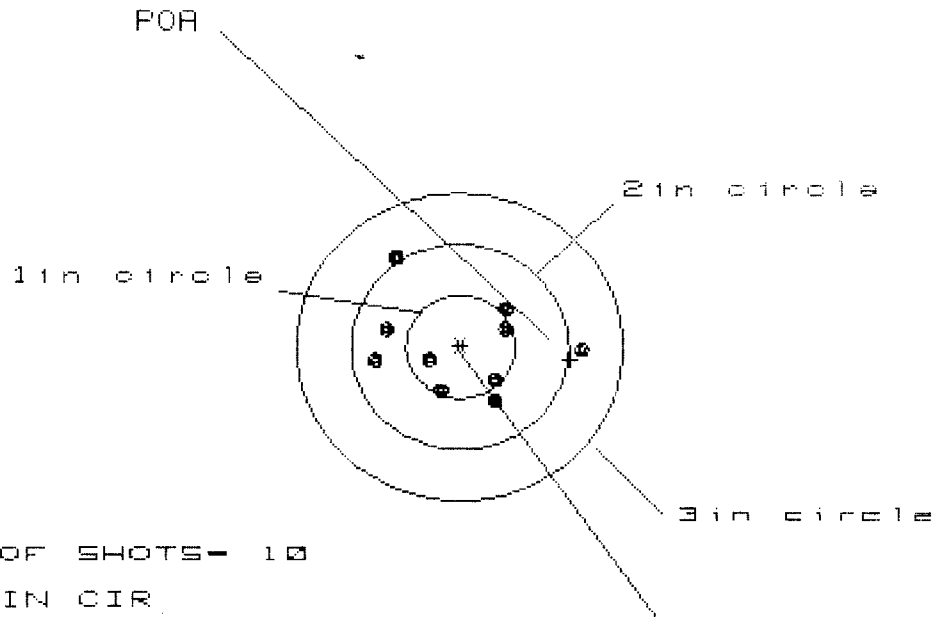
CENTROID #

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 May 1988

FILE://PATTERNING/CENTERFIRE_PATT/06225284

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in - 4

2in - 8

3in = 10

HS- 1.922

VS= 1.364

GS= 1.926

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
FOR 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	1.354
NUMBER IN ONE INCH CIRCLE	=	4	
NUMBER IN TWO INCH CIRCLE	=	8	
NUMBER IN THREE INCH CIRCLE	=	10	

BARBER M24 0012054

RECEIVING AND ESTIMATING REPORT

COMMENTS

M-24 SNIPER

ORDER

R 94-24907

INITIAL
JJM

CUSTOMER ORDER NO.

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

Barrel

96003

COMMENTS

Repower Coat Trigger Guard
HSS, Front & Rear Sight Bases
Re-line Scope Base, Rings &
Swivel Studs

REPAIRMAN

PROOF

CLEAN

TEST

TARGET

PATTERN

GALLERY TESTER

DATE

DATE

DATE

DATE

DATE

RW 9/1/94

9/12/94

9/12/94

9/12/94

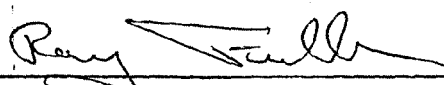
9/12/94

OFFICE COPY

RD5925 REV. 1/94

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

BARBER - M24 0012093

BARBER - M24 0012055 PACKING LIST		PACKED BY <i>Mr. Ray Fuller</i> <i>WG-10 Bn. Armorer.</i>	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		
DOX NO. (a)	CONTENTS - STOCK NUMBER AND NOMENCLATURE (b)	UNIT OF ISSUE (c)	QUANTITIES REQUIRED		
			INITIAL OPERATION (d)	RUNNING SPARES (e)	TOTAL (f)
1	<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>Ea</i>			<i>1</i>
6. THIS CERTIFIES THAT ITEMS LISTED HEREON ARE WITHIN THE SPECIFIED BOXES					
TYPED NAME AND TITLE <i>Ray Fuller WG-10 Bn. Armorer</i>			SIGNATURE 		

DD FORM 1 SEP 70 1750

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

BARBER - M24 001209912094

MAINTENANCE REQUEST				PAGE NO. <u>1</u>		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. <u>94242</u>			WESDC		ORG. PD <u>02</u>		PD AUTHENTICATION <u>[Signature]</u> CPT N				
☒ Work Request ☐ MWO ☐ Warranty Claim		1A. ORGANIZATION <u>Bn Arms HHC</u> <u>2/75 Rgr Rgd.</u>			B. LOCATION <u>Fort Lewis WA</u>				C. UNIT IDENT. CODE <u>WH3MFA</u>				
2. SERIAL NO. <u>C6225284</u>		3. NOUN NOMENCLATURE <u>07245WS</u>			4. LINE NO.		5. MODEL <u>0724</u>		6. NATIONAL STOCK NUMBER <u>105-41-240-2136</u>				
7A. MAINTENANCE ACTIVITY <u>Remington Arms Co</u> <u>Ensign Ship</u>		B. LEVEL		8. UTILIZATION CODE		9A. MCSR ITEM		9B. ERC		9C. PACING ITEM			
10. HOURS		11. MILES		12. ROUNDS		13. STARTS							
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		☐ 068 Inoperative		☐ 258 Overheating			
☐ B Handling		☐ D Normal Op		☐ F Inspection		☐ H Other		☐ 008 Noisy		☐ 387 Low Performance			
16A. DESCRIBE DEFICIENCIES OR SYMPTOMS ON THE BASIS OF COMPLETE CHECKOUT AND DIAGNOSTIC PROCEDURE IN EQUIPMENT TM (Do not prescribe repairs). <u>This weapon has fired over 10,000 Rds. During Bench Rest Test Fire at 200/300 Yds,</u> <u>groups were shot exceeding the criteria of 2.6" at 200 & 3.8" at 300 Yds. (5-10 Shot Groups)</u> <u>The criteria was provided us by Mr Jim Glenn ARDCE USN FPU-7071</u>													
B. REMARKS <u>Request ReBarreling and Complete Weapon Reconditioning</u>													
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		22. Data Transcribed			
23. SUBMITTED BY <u>Ray Fuller</u>		24. RECEIVED BY		25. WORK STARTED BY		26. INSPECTED BY		27. ACCEPTED BY		28. DISPOSITION (Select One)			
JULIAN DATE <u>4235</u>		JULIAN DATE		JULIAN DATE		JULIAN DATE		JULIAN DATE		☐ A To User ☐ D Evacuated ☐ B To Stock ☐ E Cannibalization ☐ C Salvaged			

Final Inspection

Sn: C6225284

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

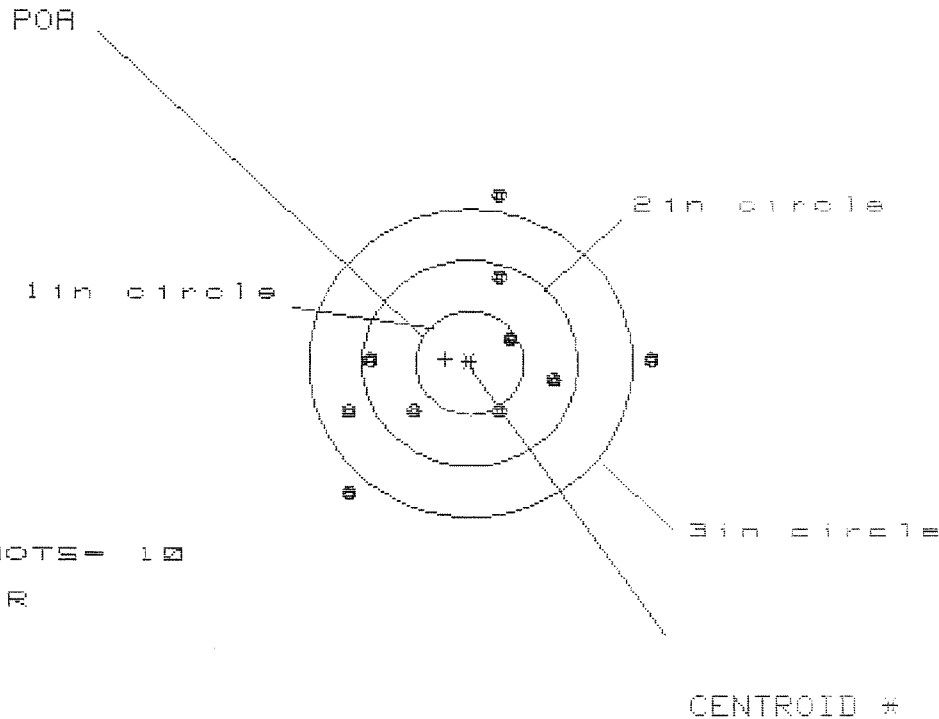
4.54 <----POB

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/C8225284

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1 in = 2

2 in = 6

3 in = 7

HS= 2.833

VS= 2.824

GS= 3.169

PATTERN #	:	1	2	3
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/08225284

CENTERFIRE PATTERNS # 2

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS= 10

IN CIR

1in = 1

2in = 6

3in = 8

HS= 2.708

VS= 2.405

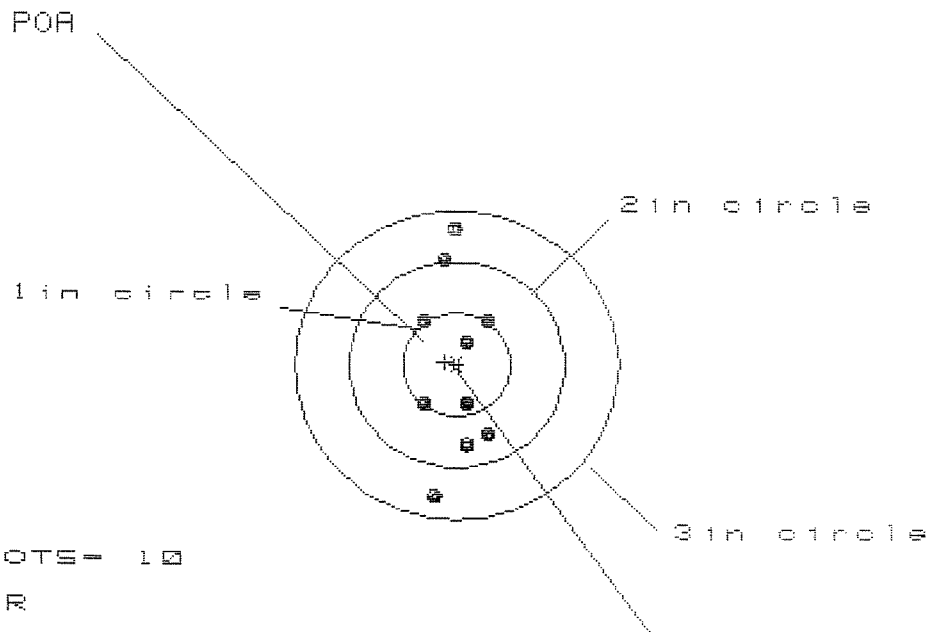
GS= 3.003

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/C6225284

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1 in = 3

2 in = 7

3 in = 10

HS= .647

VS= 2.615

GS= 2.624

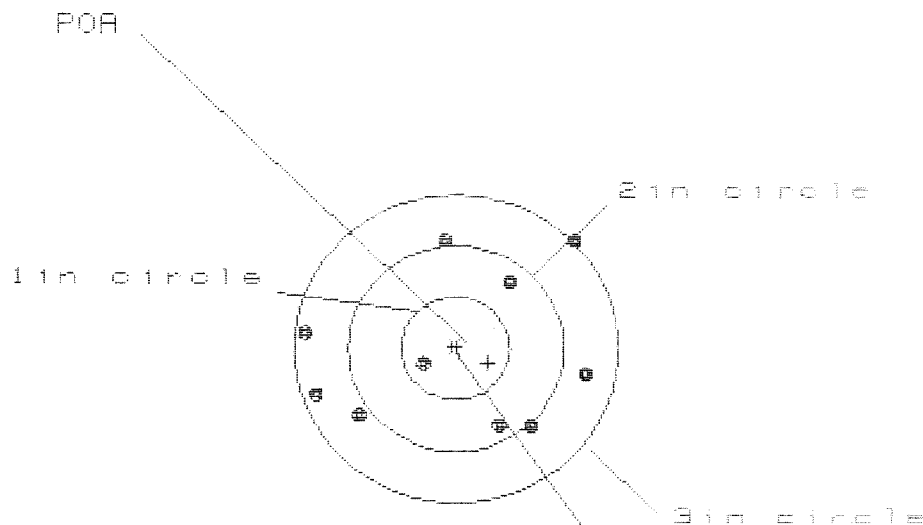
CENTROID #

PATTERN #	:	3	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.322	.325	.303
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	1.808
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		

15 Sep 1984

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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

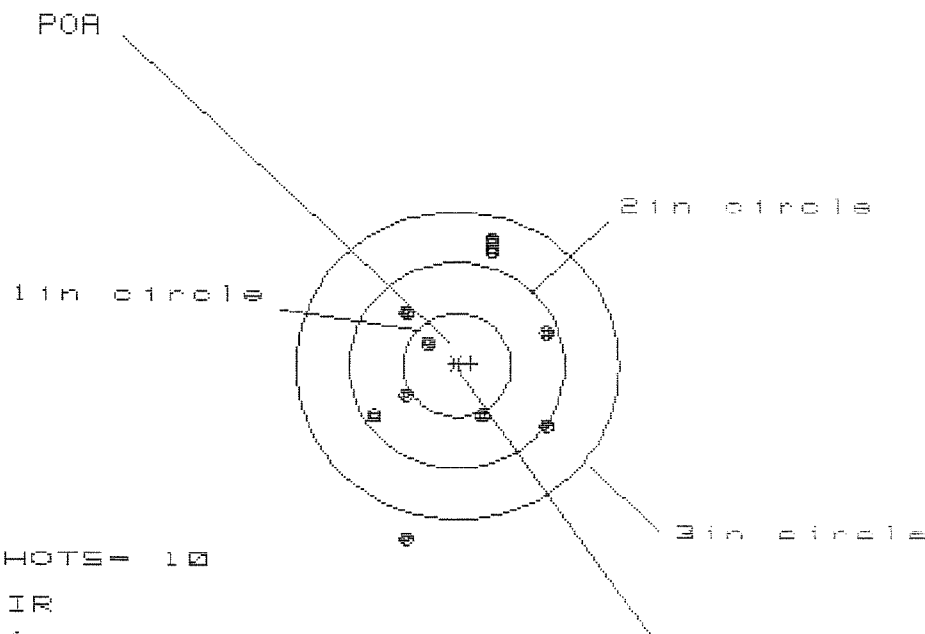
CENTROID *

PATTERN #	1	2	3
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		

15 Sep 1994

FILE:/PATTERNING/CENTERFIRE_PATT/C62252B4

CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1in = 1

2in = 7

3in = 9

HS= 1.620

VS= 2.880

GS= 2.960

CENTROID #

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	.815
MINIMUM X	-.806
MAXIMUM Y	1.246
MINIMUM Y	-1.634
CENTROID X	-.128
CENTROID Y	-.019
POA TO CENTROID in.	.129
MIN RADIUS	.378
MEAN RADIUS	.898
MAX RADIUS	1.689
HORIZONTAL SPREAD	1.620
VERTICAL SPREAD	2.880
EXTREME SPREAD	2.960
NUMBER IN ONE INCH CIRCLE =	1
NUMBER IN TWO INCH CIRCLE =	7
NUMBER IN THREE INCH CIRCLE =	9

CONTRACT # DAAA21-87-C-0086

New Barrel

GUN SERIAL # C6225284

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. #	BARBER - M24 0012065 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							