

New Action

C6225313

E6374603

MODEL 700™ M24

Model 700 M24™

Action

Barrel Length

Capacity

Order No. 5716

*Includes 1 in chamber.

Remington

CIII

BARBER-M24 0012516

ORDER
96-02150

SNIPER M-24

ACCESSORIES	W/STUDS	SOFT CASE	SCOPE BASE
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SHIP TO:

~~COMMANDER~~
~~DEWEDEST, WARREN C.~~
D CO. 2ND BN. 1ST SWTG
FT BRAGG

NC 28307

20307

CUST NO: 135950 C.O.D

ACCOUNT NUMBER N/C

WRITE

PROM. DATE

ESTIMATED

VIA

DOOR

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

TOTAL

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

COMMENTS

Repowder Coat Trigger Guard	
Assy of Rear Sight Base	
Refine Scope Base & Survival	
Studs	

REPAIRMAN <i>Riv</i>	PROOF <i>i</i>	CLEAN <i>—</i>	TEST <i>WB</i>	TARGET <i>WB</i>	PATTERN
GALLERY TESTER <i>Riv</i>	DATE <i>1/22/96</i>	DATE <i>1/31/96</i>	DATE <i>1/31/96</i>	DATE <i>1/31/96</i>	DATE

OFFICE COPY

RD6925 RFV 1/94

BARBER - M24 0012555

PAYMENT:

Mastercard / Visa (circle one)

Card #:

Exp. Date:

Signature:

RETURN:

☐ Clark Street Entrance☒ Via US Mail or UPS

(PLEASE PRINT CLEARLY)

FIREARMS DELIVERED TO PLANT

FILE NO: 010800

DATE 1/17/96

CUSTOMER NAME:

WARREN C DEMAREST

ADDRESS:

D CO 2ND BN 1ST SWTG

FT. BRAGG NC

ZIP:

28307

PHONE:

910 432-9037

FIREARM

MODEL: M-24

CHECK FOR AMMUNITION

GAUGE: 7662

SERIAL # C6225313

CONDITION:

N/A	WOOD	GOOD	FAIR	POOR	FANCY	PLAIN
	METAL	GOOD	FAIR	POOR	FANCY	PLAIN
	BARREL	VT. RIB	PLAIN	DEER RSS		

ACCESSORIES:

SCOPE: YES NO (BRAND NAME/POWER)

SLING: YES NO GUN CASE: YES NO (HARD SOFT)

EXTRA BBL FOR GUN MENTIONED ABOVE:

OTHER (Note in this area items missing or added from orig. equipment)

CUSTOMER REQUEST:

REPAIR PER CONTRACT

SIGNATURE:

(Person delivering firearm to Plant)

DATE:

17 JAN 96

SIGNATURE:

(Security Officer)

DATE:

1/17/96

SIGNATURE:

(Firearm picked up by)

DATE:

Arm Service Copy

CONTRACT # DAAA21-87-C-0086

New Barrel /
Stock

GUN SERIAL # C6225313

OP. #	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and Stock		1/22/96	RW
600	Proof		1/22/96	RW
607	Check Headspace		1/22/96	RW
610	Dis-assemble Gun		1/22/96	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		1/30/96	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		1/30/96	RW
	C) Inspect Ejector Hole for Chamfer		1/30/96	RW
	D) Oil Firing Pin Ass'y		1/30/96	RW
	E) Adjust Trigger Pull to Min Setting and Stake		1/30/96	RW

op. #	BARBER - M24 0012519 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		1/31/96	RW
	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		1/31/96	WB
	A) Time			
	B) Malfunctions			
	C) Pierced Primers			
	D) Optical Clarity of Scope			
645	Inspect for Live Ammo		1/31/96	WB
655	Final Inspection			
	A) Headspace		2/1/96	RW
	B) Trigger Pull			
	C) Function		2/1/96	RW
660	Pack			

Final Inspection

Sn: C6225313

DATE REC'D: 1/17/96

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 # 06225313
3 Jan 1900

CENTROIDAL DISTANCES

0 TO	1	1.19162
1 TO	2	.352953
1 TO	3	.332182
1 TO	4	.144003
1 TO	5	.284881

31

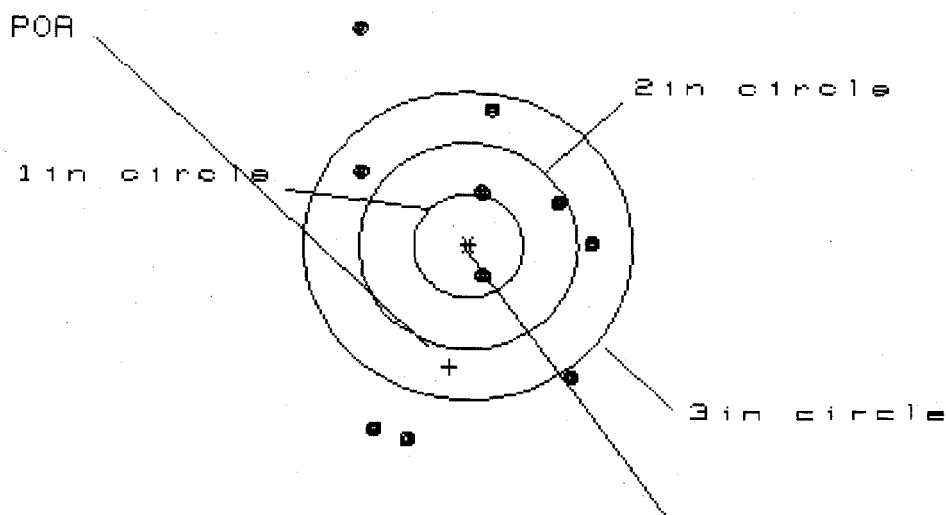
+ (----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0176
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: 1.2334
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: 1.23353
THE AMR FOR THIS RIFLE IS: .946

2 Jan 1988

FILE:/PATTERNING/CENTERFIRE_PATT/06225313

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in - 1

2in - 3

3in - 6

HS- 2.097

VS- 4.024

GS- 4.038

CENTROID *

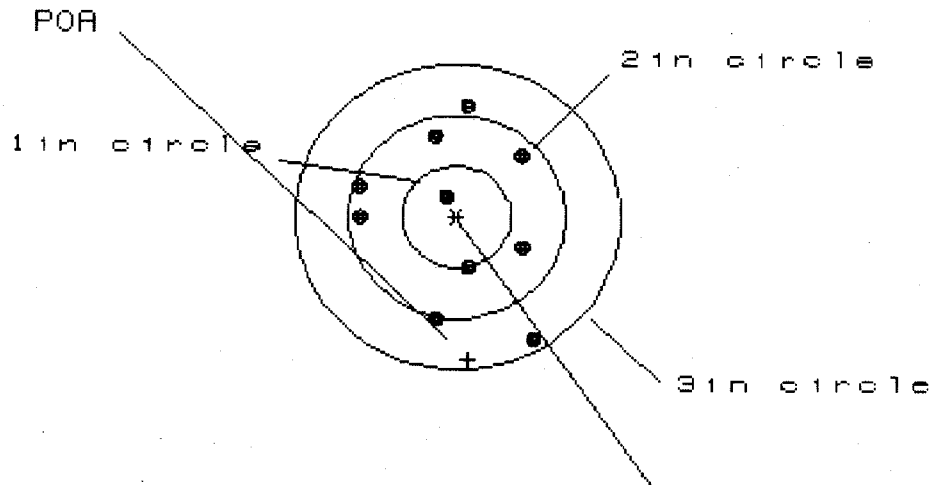
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PATTERN #           :      1
SHOTS (BEST OF)     :      10      9      8
MAXIMUM X            :      1.092      .989      .867
MINIMUM X            :     -1.005     -1.108     -1.230
MAXIMUM Y            :      2.140      1.537      1.340
MINIMUM Y            :     -1.884     -1.646     -1.843
CENTROID X           :       .173       .276       .398
CENTROID Y           :      1.179       .941      1.138
POA TO CENTROID in. :      1.191       .981      1.206
MIN RADIUS           :       .304       .072       .214
MEAN RADIUS          :      1.339      1.210      1.090
MAX RADIUS           :      2.335      1.852      2.019
HORIZONTAL SPREAD    :      2.097      2.097      2.097
VERTICAL SPREAD      :      4.024      3.183      3.183
EXTREME SPREAD       :      4.038      3.290      3.281
NUMBER IN ONE INCH CIRCLE =      1
NUMBER IN TWO INCH CIRCLE =      3
NUMBER IN THREE INCH CIRCLE =      6
  
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2 Jan 1900

FILE:/PATTERNING/CENTERFIRE_PATT/06225313

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

CENTROID #

IN CIR

1 in = 2

2 in = 7

3 in = 10

HS= 1.558

VS= 2.252

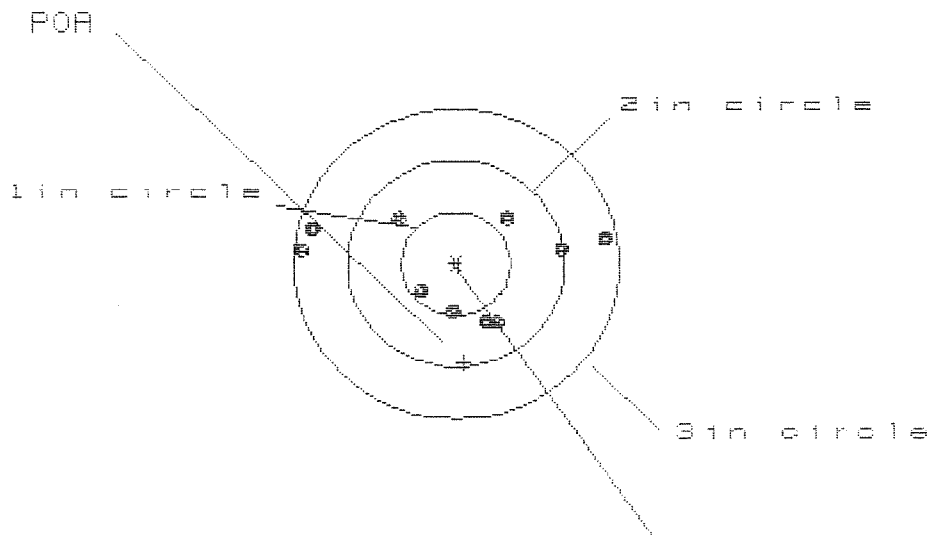
GS= 2.307

PATTERN #	:	2	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.654	.717	.745
MINIMUM X	:	-.904	-.831	-.803
MAXIMUM Y	:	1.097	.968	.746
MINIMUM Y	:	-1.155	-1.132	-1.011
CENTROID X	:	-.103	-.176	-.204
CENTROID Y	:	1.399	1.528	1.407
POA TO CENTROID in.	:	1.403	1.538	1.421
MIN RADIUS	:	.165	.026	.150
MEAN RADIUS	:	.832	.754	.731
MAX RADIUS	:	1.328	1.135	1.012
HORIZONTAL SPREAD	:	1.558	1.548	1.548
VERTICAL SPREAD	:	2.252	2.100	1.757
EXTREME SPREAD	:	2.307	2.122	1.798
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	7		
NUMBER IN THREE INCH CIRCLE	=	10		

2 Jan 1988

FILE:/PATTERNING/CENTERFIRE_PATT/08225313

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in - 2

2 in - 7

3 in - 10

HS= 2.759

VS= 1.078

GS= 2.763

CENTROID *

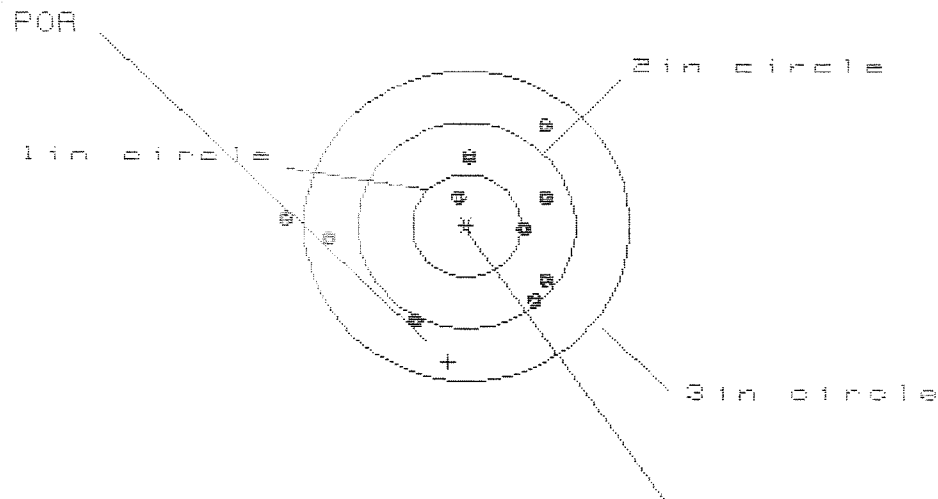
PATTERN #	3	3	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.370	1.107	.953
MINIMUM X	-1.389	-1.237	-1.319
MAXIMUM Y	.485	.516	.535
MINIMUM Y	-.593	-.562	-.543
CENTROID X	-.075	-.227	-.073
CENTROID Y	.958	.927	.908
POA TO CENTROID in.	.960	.955	.911
MIN RADIUS	.377	.243	.354
MEAN RADIUS	.864	.796	.723
MAX RADIUS	1.397	1.246	1.367
HORIZONTAL SPREAD	2.759	2.344	2.271
VERTICAL SPREAD	1.078	1.078	1.078
EXTREME SPREAD	2.763	2.344	2.275
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		10	

2 Jan 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C8225313

CENTERFIRE PATTERNS

4



OF SHOTS= 10

CENTROID #

IN CIR

1 in = 1

2 in = 7

3 in = 8

HS= 2.447

VS= 1.874

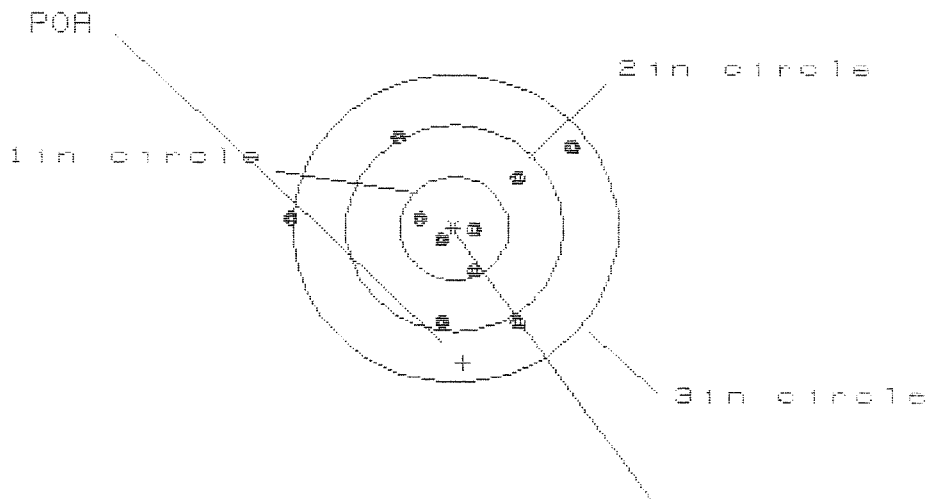
GS= 2.545

PATTERN #	4		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.775	.590	.412
MINIMUM X	-1.672	-1.422	-.819
MAXIMUM Y	.988	.991	.982
MINIMUM Y	-.886	-.883	-.892
CENTROID X	.174	.359	.537
CENTROID Y	1.323	1.320	1.329
POA TO CENTROID in.	1.334	1.368	1.433
MIN RADIUS	.299	.340	.163
MEAN RADIUS	.924	.803	.686
MAX RADIUS	1.672	1.424	1.211
HORIZONTAL SPREAD	2.447	2.012	1.231
VERTICAL SPREAD	1.874	1.874	1.874
EXTREME SPREAD	2.545	2.199	2.195
NUMBER IN ONE INCH CIRCLE		1	
NUMBER IN TWO INCH CIRCLE		7	
NUMBER IN THREE INCH CIRCLE		9	

2 Jan 1988

FILE:/PATTERNING/CENTERFIRE_PATT/06225313

CENTERFIRE PATTERNS # 5



OF SHOTS = 10

CENTROID #

IN CIR

1 in = 4

2 in = 6

3 in = 10

HS = 2.571

VS = 1.822

GS = 2.656

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.098	.934	.545
MINIMUM X	-1.473	-.726	-.609
MAXIMUM Y	.876	.888	.986
MINIMUM Y	-.946	-.934	-.836
CENTROID X	-.081	.083	-.034
CENTROID Y	1.308	1.296	1.198
POA TO CENTROID in.	1.311	1.299	1.199
MIN RADIUS	.119	.060	.144
MEAN RADIUS	.771	.686	.604
MAX RADIUS	1.477	1.220	1.159
HORIZONTAL SPREAD	2.571	1.660	1.154
VERTICAL SPREAD	1.822	1.822	1.822
EXTREME SPREAD	2.656	2.157	2.157
NUMBER IN ONE INCH CIRCLE =	4		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	10		

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C 6225313

OP. #	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and Stock		JUL 29 1991	RW
600	Proof		JUL 29 1991	RW
607	Check Headspace		JUL 29 1991	RW
610	Dis-assemble Gun		JUL 29 1991	RW
612	Magnaflux Barrel Action		JUL 30 1991	KCR
	Magnaflux Bolt		JUL 30 1991	KCR
615	Rollmark Caliber		JUL 30 1991	GS
617	Drill and Tap Sight Holes		JUL 30 1991	FB
618	Polish Barrel		JUL 31 1991	WB
620	Apply Coatings (Barrel Action)		AUG 1 1991	TJA
	Apply Coating (Bolt)		AUG 1 1991	TJA
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. #	NAME M24 0012528	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						9-25-91	OK OH
	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						9-23-91	NF
	A) Time						"	NF
	B) Malfunctions						"	NF
	C) Pierced Primers						"	NF
	D) Optical Clarity of Scope						"	NF
645	Inspect for Live Ammo						9-23-91	NF
655	Final Inspection							
	A) Headspace						9-25-91	OK
	B) Trigger Pull	2.14	2.40	2.35	2.28	1.29	9/24/91	OK
	C) Function						9-25-91	OK
660	Pack						9/25/91	W.B.

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06625313
23 Sep 1991

CENTROIDAL DISTANCES

0 TO	1	.214227
1 TO	2	.148327
1 TO	3	.252769
1 TO	4	.304923
1 TO	5	.201604

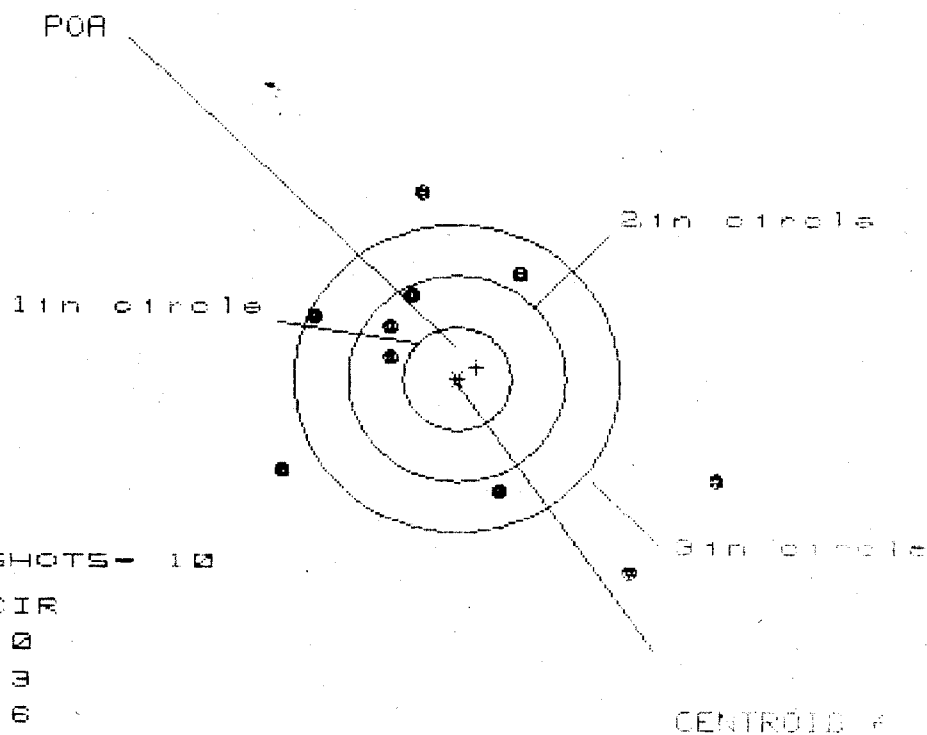
-----FOR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0500
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0150
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .097100
THE AMR FOR THIS RIFLE IS: 1.186

23 Sep 1991

FILE://PATTERNING/CENTERFIRE_PATT/C6B25313

CENTERFIRE PATTERNS # 1



OF SHOTS - 10

IN CIR

1 in = 0

2 in = 3

3 in = 6

HS = 3.960

VS = 3.685

GS = 4.158

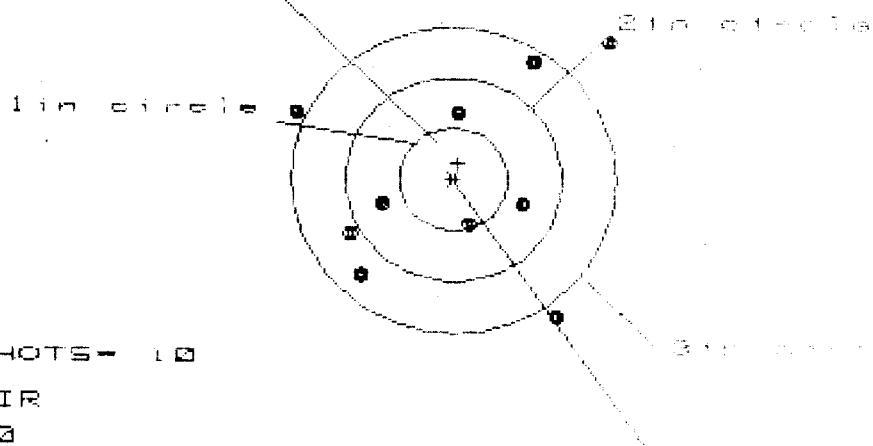
PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	2.340	1.835	1.162
MINIMUM X	-1.620	-1.360	-1.130
MAXIMUM Y	1.792	1.687	1.437
MINIMUM Y	-1.893	-1.998	-1.413
CENTROID X	-0.182	-0.442	-0.672
CENTROID Y	-0.113	-0.008	0.242
POA TO CENTROID in.	0.215	0.442	0.714
MIN RADIUS	0.611	0.332	0.177
MEAN RADIUS	1.464	1.259	0.964
MAX RADIUS	2.526	2.713	1.679
HORIZONTAL SPREAD	3.960	3.195	2.309
VERTICAL SPREAD	3.685	3.685	2.850
EXTREME SPREAD	4.158	4.158	2.964
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	3		
NUMBER IN THREE INCH CIRCLE =	6		

23 Sep 1991

FILE: PATTERNING/CENTERFIRE_PATT-08625313

CENTERFIRE PATTERNS # 2

FOR



OF SHOTS - 10

IN CIR

1 in - 0

2 in - 4

3 in - 7

HS - 2.880

VS - 2.632

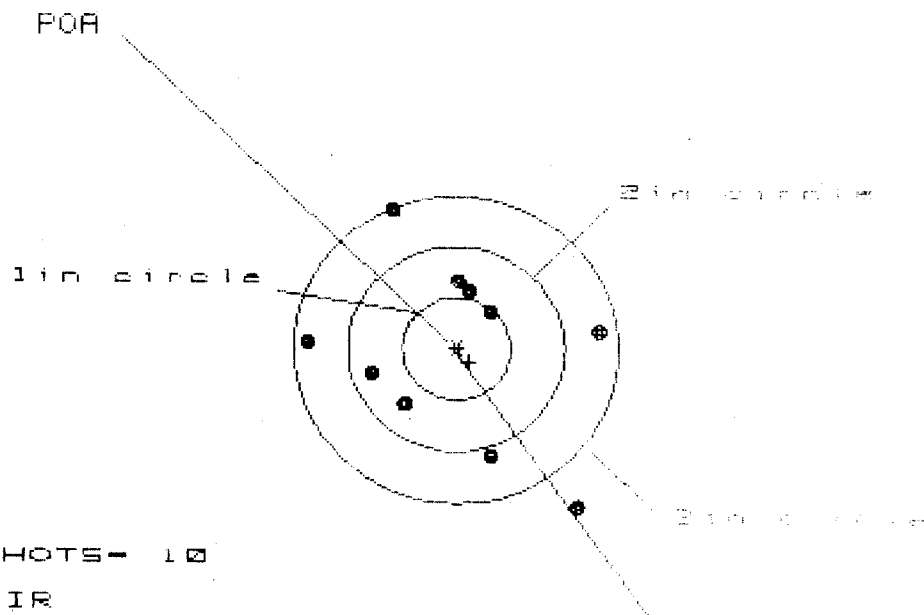
GS - 3.176

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.401	1.092	.920
MINIMUM X	-1.479	-1.323	-1.005
MAXIMUM Y	1.318	1.285	1.389
MINIMUM Y	-1.314	-1.168	-1.064
CENTROID X	-.042	-.198	-.032
CENTROID Y	-.162	-.388	-.412
POA TO CENTROID in.	.167	.366	.414
MIN RADIUS	.510	.472	.284
MEAN RADIUS	1.157	1.045	.960
MAX RADIUS	1.923	1.599	1.673
HORIZONTAL SPREAD	2.880	2.415	1.991
VERTICAL SPREAD	2.632	2.453	2.193
EXTREME SPREAD	3.176	3.136	2.612
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	7		

23 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08020918

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in = 0

2 in = 5

3 in = 8

HS= 2.689

VS= 2.898

GS= 3.342

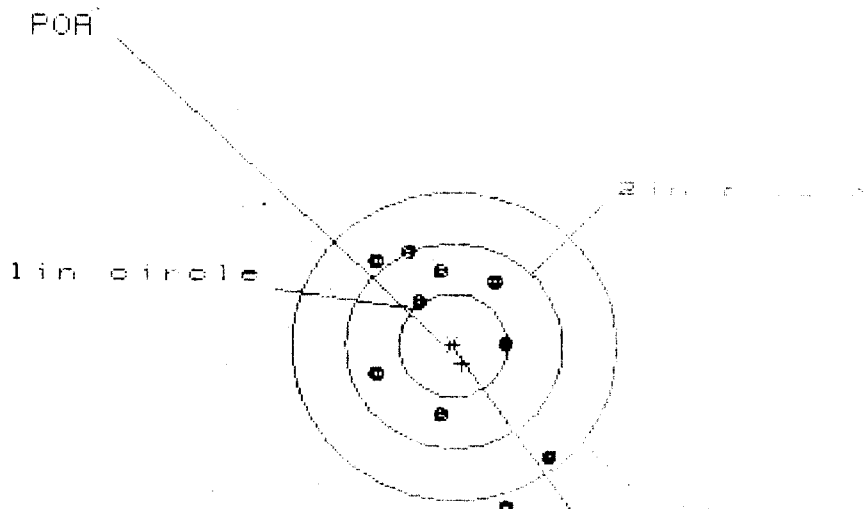
CENTROID

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.298	1.421	1.367
MINIMUM X	:	-1.391	-1.268	-1.322
MAXIMUM Y	:	1.410	1.245	.696
MINIMUM Y	:	-1.488	-1.228	-1.073
CENTROID X	:	-.116	-.239	-.185
CENTROID Y	:	.131	.296	.141
POA TO CENTROID in.	:	.175	.381	.232
MIN RADIUS	:	.519	.491	.558
MEAN RADIUS	:	1.059	.942	.980
MAX RADIUS	:	1.856	1.421	1.373
HORIZONTAL SPREAD	:	2.689	2.689	2.689
VERTICAL SPREAD	:	2.898	2.473	1.769
EXTREME SPREAD	:	3.342	2.690	2.690
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

23 Sep 1991

FILE: \PATTERNING\CENTERFIRE_PATT\0602533

CENTERFIRE PATTERNS



OF SHOTS - 10

IN CIR

1 in - 1

2 in - 6

3 in - 9

HS = 1.605

VS = 2.509

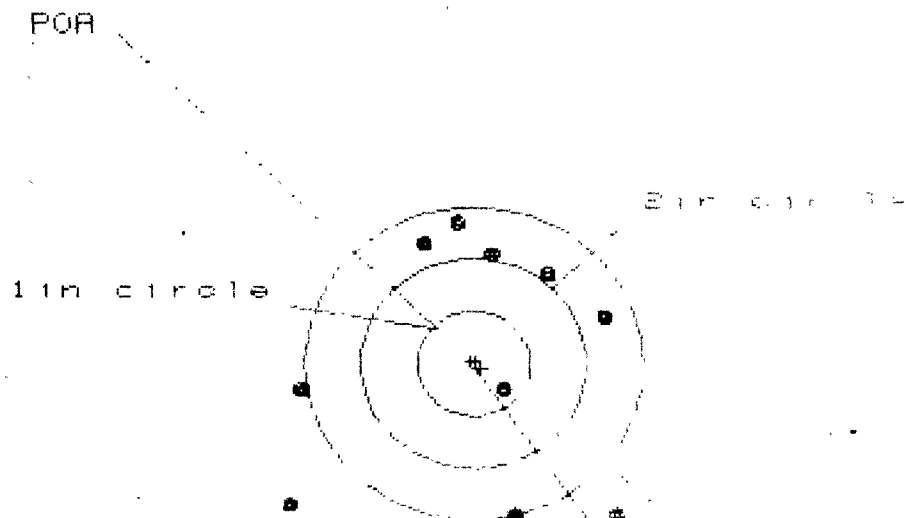
GS = 2.674

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.922	.979	.640
MINIMUM X	-.683	-.626	-.504
MAXIMUM Y	.971	.800	.645
MINIMUM Y	-1.538	-1.239	-.903
CENTROID X	-.079	-.136	-.258
CENTROID Y	.174	.345	.500
POA TO CENTROID in.	.191	.371	.563
MIN RADIUS	.469	.364	.167
MEAN RADIUS	.904	.787	.640
MAX RADIUS	1.620	1.579	.903
HORIZONTAL SPREAD	1.605	1.605	1.133
VERTICAL SPREAD	2.509	2.039	1.603
EXTREME SPREAD	2.674	2.430	1.603
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	9		

23 Sep 1991

FILE: PATTERNING CENTERFIRE_PATT:06625313

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 1

2in = 1

3in = 6

HS= 2.884

VS= 2.771

GS= 3.365

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.232	1.049	1.116
MINIMUM X	-1.652	-1.757	-1.626
MAXIMUM Y	1.309	1.157	.961
MINIMUM Y	-1.462	-1.614	-1.810
CENTROID X	-.062	.121	-.010
CENTROID Y	.049	.201	.397
POA TO CENTROID in.	.080	.234	.397
MIN RADIUS	.358	.433	.651
MEAN RADIUS	1.344	1.214	1.097
MAX RADIUS	2.140	1.890	1.877
HORIZONTAL SPREAD	2.884	2.806	2.744
VERTICAL SPREAD	2.771	2.771	2.771
EXTREME SPREAD	3.365	3.186	2.850
NUMBER IN ONE INCH CIRCLE =	1	1	1
NUMBER IN TWO INCH CIRCLE =	1	1	1
NUMBER IN THREE INCH CIRCLE =	6	6	6

BARBER - M24 0012535

RECEIVING AND ESTIMATING REPORT

CUST NO: 046771 C.O.D

COMMENTS

M-24 SNIPER

INITIAL JJM	CUSTOMER ORDER NO. 006246				
DATE RECEIVED 07/29/91	DATE OPENED 07/29/91	DATE CODE KI 5-88	SERIAL NUMBER C6225313	MODEL AND GRADE 700 7.62 NATO	ORDER R 91-14526
ACCESSORIES W/STUDS		SCOPE BASE			

FROM:

CO D 2ND BN 1ST SPWAR TNG GP
C/O CPT M K STEPHENSON
FT BRAGG NC 28307
USA

SHIP TO:

CO D 2ND BN 1ST SPWAR TNG GP
C/O CPT M K STEPHENSON
FT BRAGG NC
USA 28307

ACCOUNT NUMBER	ACCOUNT NUMBER N/C	WRITE ☐	CLEAN/TEST	PROM. DATE	ESTIMATED	VIA BOOK
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REPAIR CHARGE	TAX	INSURANCE	UPS	PARCEL POST	TOTAL
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GUN CONDITION:

☐ NEW☐ SLIGHTLY WORN☒ VERY WORN☐ MISUSED☐ MARRED

CUSTOMER'S REQUEST

MAIN FAULT

- 1) NEW BARREL
- 2) NEW STOCK
- 3) RE POWDER COAT TRIGGER GUARD
- 4) CLEAN FIRE CONTROL

PARTS

REPAIRMAN RW	PROOF ✓	CLEAN NF	TEST NE	TARGET NF	PATTERN
GALLERY TESTER NF	DATE 7/29/91	DATE 9-23-91	DATE 9-23-91	DATE 9-23-91	DATE

OFFICE COPY

RD5925 REV. 7/90

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

BARBER - M24 0012535 12574

[illegible]

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6225313

OPERATION		DATE	INT
#	NAME		
575-580	ASSEMBLY 2	20	FB
600	PROOF		RW
615	MAGNAFLUX BARREL	5/13/88	PJC
	MAGNAFLUX BOLT	5/13/88	PJC
620	COATING	8/11/88	TJA
625-630	FINAL ASSEMBLY		
635	TEST		
640	TARGET		
	FIRING PIN INDENT		
660	PACK		

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6225313

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		8/29/88	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/29/88	RW
	C) Inspect Ejector Hole for Chamfer		8/29/88	RW

OVER

OP.#		READINGS	DATE	INITIAL
625 cont.	D) Oil Firing Pin Ass'y		8/29/88	RW
	E) Adjust Trigger Pull to Min. Setting and Stake		29aug88	J. U. + J.S.
	F) Safety on Force	8 7 6.25	29aug88	J. U. + J.S.
	G) Safety off Force	3.75 3.25 4	29aug88	J. U. + J.S.
	H) Trigger Pull Test & Retainability		29aug88	J. U. + J.S.
	I) Firing Pin Indent	.027 .0215 .0215	29aug88	J. U. + J.S.
	J) Assemble Stock		9/26/88	RW
	K) Assemble Swivel Studs		10-10-88	J.S.
	L) Attach Front & Rear Sight Assemblies		9/26/88	RW
	M) Iron Sight Alignment		9/26/88	RW
	N) Detach Front & Rear Sights & place in numbered container		9/26/88	RW
	O) Attach Scope to Rifle		10/3/88	RW
	P) Detach & Attach Scope 20 times		10/4/88	J.S.
640	Gallery Target & Test	51 R 104L	10/7/88	DH
	A) Optical Clarity of Scope		10/7/88	J. U.
645	Inspect for Live Ammo		10/7/88	J. U.
655	Final Inspection			
	A) Headspace		10-10-88	J.S.
	B) Trigger Pull		10-10-88	J.S.
	C) Function		10-10-88	J.S.
660	Pack		10-20-88	J.S.

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6225313

DATE 29 Aug 88

TESTER J. U. + K. 8

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#	COMMENTS
PULL #1	258	243	264 257	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	241	250	252 257	
PULL #3	242	253	265 260	
PULL #4	242	252	265 257	
PULL #5	245	252	266 264	
TOTAL	1228	1250	1312 1295	
AVG.	2456	250	2624 259	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.08	3.09		
PULL #2	3.04	3.08		
PULL #3	3.07	2.97		
PULL #4	3.08	3.09		
PULL #5	3.10	3.09		
TOTAL	15.37	15.32		
AVG.	3.074	3.064		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.32	4.32		4.28
PULL #2	4.31	4.32		4.27
PULL #3	4.32	4.32		4.26
PULL #4	4.33	4.36		4.31
PULL #5	4.35	4.36		4.30
TOTAL	21.63	21.68		21.42
AVG.	4.326	4.336		4.284

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6225313

CENTROIDAL DISTANCES

0 TO	1	.70752
1 TO	2	.661636
1 TO	3	.683356
1 TO	4	1.38224
1 TO	5	.375832

4
+ (----POI
15

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .786
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.3974
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .888751
THE AMR FOR THIS RIFLE IS: 1.14

7 Oct 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C8225313

CENTERFIRE PATTERNS # 1

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS = 10

IN CIR

1in = 2

2in = 4

3in = 7

HE = 2.122

VS = 3.239

GS = 3.674

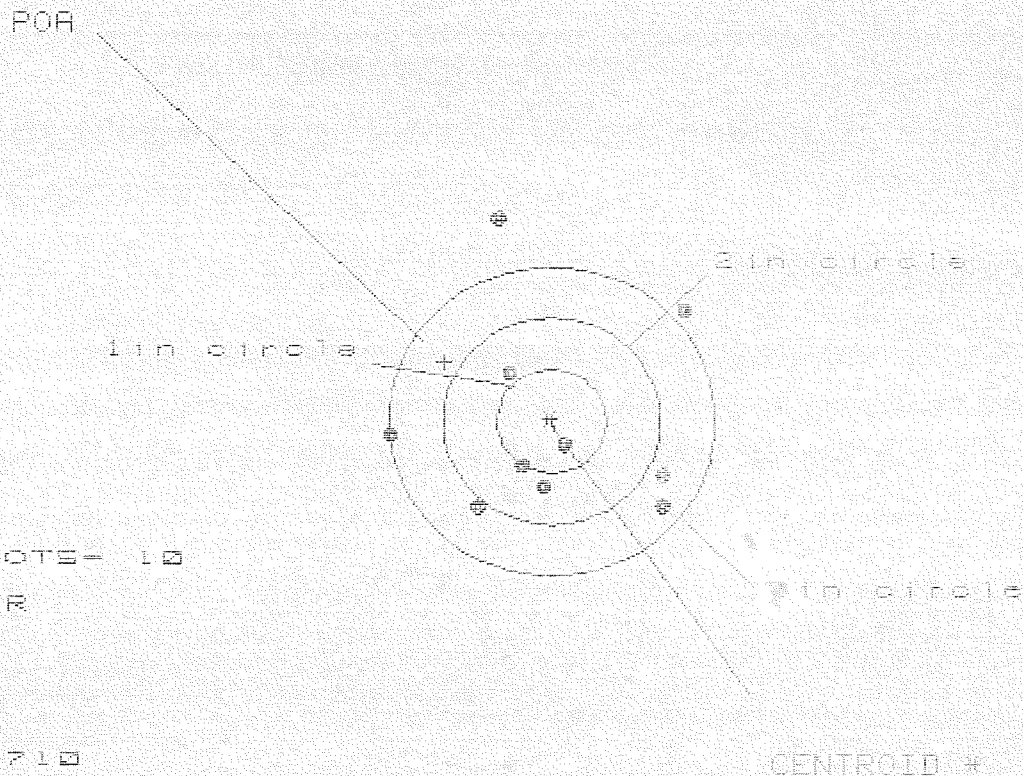
PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.872	.733	.793
MINIMUM X	-1.250	-.781	-.721
MAXIMUM Y	1.610	1.429	1.598
MINIMUM Y	-1.629	-1.502	-1.433
CENTROID X	.322	.461	.401
CENTROID Y	-.630	-.449	-.618
POA TO CENTROID in.	.708	.644	.737

	1	2	3
MIN RADIUS	.272	.439	.268
MEAN RADIUS	1.153	1.059	.983
MAX RADIUS	2.054	1.606	1.605
HORIZONTAL SPREAD	2.122	1.514	1.514
VERTICAL SPREAD	3.239	3.031	3.031
EXTREME SPREAD	3.674	3.031	3.031
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		4	
NUMBER IN THREE INCH CIRCLE =		7	

7 Oct 1988

FILE:/PATTERNING/CENTERFIRE_PATT/08225313

CENTERFIRE PATTERNS # 2



PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.198	1.148	1.137
MINIMUM X	-1.512	-1.562	-1.418
MAXIMUM Y	1.953	1.290	.812
MINIMUM Y	-.799	-.582	-.420
CENTROID X	.981	1.031	.887
CENTROID Y	-.571	-.788	-.956
POR TO CENTROID in.	1.136	1.238	1.299
MIN RADIUS	.283	.036	.217
MEAN RADIUS	1.057	.894	.755
MAX RADIUS	2.003	1.727	1.441
HORIZONTAL SPREAD	2.710	2.710	2.555
VERTICAL SPREAD	2.752	1.872	1.232
EXTREME SPREAD	3.127	2.962	2.643
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		4	
NUMBER IN THREE INCH CIRCLE =		7	

7 Oct 1968

FILE:/PATTERNING/CENTERFIRE_PATT/08225313

CENTERFIRE PATTERNS # 3

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS= 10

IN CIR

1 in = 2

2 in = 5

3 in = 7

HS= 3.554

VS= 3.973

GS= 4.396

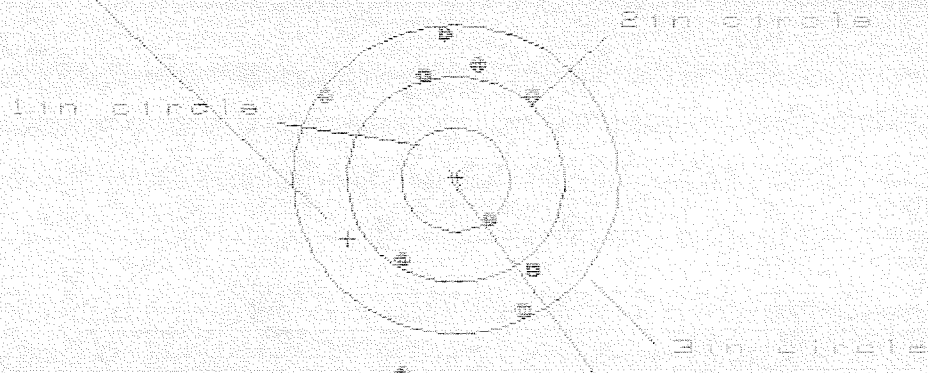
PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.028	.933	.874
MINIMUM X	-1.526	-1.621	-1.505
MAXIMUM Y	2.577	1.131	.992
MINIMUM Y	-1.396	-1.110	-.984
CENTROID X	.998	1.093	.977
CENTROID Y	-.530	-.816	-.677
POA TO CENTROID in.	1.130	1.364	1.189
MIN RADIUS	.379	.079	.251
MEAN RADIUS	1.205	.967	.922
MAX RADIUS	2.715	1.763	1.603
HORIZONTAL SPREAD	2.554	2.554	2.378
VERTICAL SPREAD	3.973	2.241	1.976
EXTREME SPREAD	4.396	3.126	2.831
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	7		

7 Oct 1988

FILE:/PATTERNING/CENTERFIRE_PATT/08225313

CENTERFIRE PATTERNS # 4

POB



OF SHOTS= 10

IN CIR

1in = 1

2in = 2

3in = 9

HS= 1.826

VS= 3.278

GS= 3.295

CENTROID +

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.682	.631	.706
MINIMUM X	-1.144	-1.195	-1.120
MAXIMUM Y	1.421	1.214	1.026
MINIMUM Y	-1.857	-1.502	-1.312
CENTROID X	.992	1.043	.968
CENTROID Y	.579	.785	.973
POB TO CENTROID in.	1.148	1.305	1.372
MIN RADIUS	.468	.609	.666
MEAN RADIUS	1.194	1.096	1.003
MAX RADIUS	1.913	1.618	1.487
HORIZONTAL SPREAD	1.826	1.826	1.826
VERTICAL SPREAD	3.278	2.716	2.338
EXTREME SPREAD	3.295	2.824	2.483
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	2		
NUMBER IN THREE INCH CIRCLE =	9		

7 Oct 1988

FILE:/PATTERNING/CENTERFIRE_PATT/08225313

CENTERFIRE PATTERNS # 5

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS= 10

IN CIR

1 in = 1

2 in = 5

3 in = 7

HS= 3.414

VS= 2.412

GS= 3.568

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.641	1.065	.866
MINIMUM X	-1.773	-1.590	-1.283
MAXIMUM Y	1.256	1.137	1.082
MINIMUM Y	-1.156	-1.275	-1.330
CENTROID X	.637	.454	.653
CENTROID Y	-.835	-.716	-.661
POA TO CENTROID in.	1.850	.848	.929
MIN RADIUS	.382	.342	.396
MEAN RADIUS	1.091	.979	.878
MAX RADIUS	1.962	1.661	1.597
HORIZONTAL SPREAD	3.414	2.655	2.149
VERTICAL SPREAD	2.412	2.412	2.412
EXTREME SPREAD	3.568	3.038	3.038
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		7	