

C6225344

MODEL 700TM M24

Model **SMS**TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

Smead[®]

Repair Inquiry

Repair Number: RE00119057

Serial: C6225344 Model M24 SWS Center Fire
Caliber: 7.62 NATO

Repairman:

Status: New 10/19/2006 8:42:56 AM

Verify Repair

Address Information

Customer:

Received From

Return To:

Received From

Name: DEPARTMENT OF THE ARMY SUPPLY OFFICER

DEPARTMENT OF THE ARMY SUPPLY OFFICER

Address 1: DOL SISA BLDG 9660 BAY A

DOL SISA BLDG 9660 BAY A

Address 2: BOX 339500 MS 18 I

PO Box:

BOX 339500 MS 18 I

PO Box:

City: FORT LEWIS

FORT LEWIS

State: WA

Zip Code: 98433

Country: US

State: WA

Zip Code: 98433

Country: US

FFL:

Contact / Condition

Problems

Estimate

History / Status

Shipping / Billing

Contact Information

Phone: NA

Fax:

Email:

Comments:

Received Condition

Fair

Condition
Notes:CSR
Notes:

Accessories Received

Code	Desc	Qty
A007	With Stud	3
A017	Scope Base	1
A045	Bi Pod	1
A057	Fit and Rear Sgt Base	1

Repair Search

Refresh

Close

nagletj

10/19/2006

9:19 AM

CAPS

NUM

INS

SCRL



9:19 AM

Serial
Number:

C6225344

Model: M24 SWS



RE00119057

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6225344.__0
FILE DATE AND TIME: 10/30/2006 14:16

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.064
The Average Y Centroid of the Five Target Set:	0.001
The Average Point of Impact of the Five Target Set:	0.064
The Average Mean Radius of the Five Target Set:	0.617
The Distance from POA to Centroid Target #1:	0.048
The Distance from Centroid Target #2 to Centroid Target #1:	0.147
The Distance from Centroid Target #3 to Centroid Target #1:	0.234
The Distance from Centroid Target #4 to Centroid Target #1:	0.155
The Distance from Centroid Target #5 to Centroid Target #1:	0.172

SERIAL NUMBER: C6225344. __0

TARGET NUMBER: 1

FILE DATE: 10/30/2006

FILE TIME: 14:16

POINT#	X	Y
1:	0.169	0.987
2:	-0.045	0.432
3:	-1.025	0.207
4:	-0.543	-0.517
5:	-0.306	-0.342
6:	-0.179	0.027
7:	-0.115	-0.432
8:	0.152	0.007
9:	0.506	-0.236
10:	1.001	0.153

X CENTROID: -0.039

Y CENTROID: 0.029

POA TO CENTROID: 0.048

HORZ SPREAD: 2.026

VERT SPREAD: 1.504

GROUP SPREAD: 2.027

MIN RADIUS: 0.141

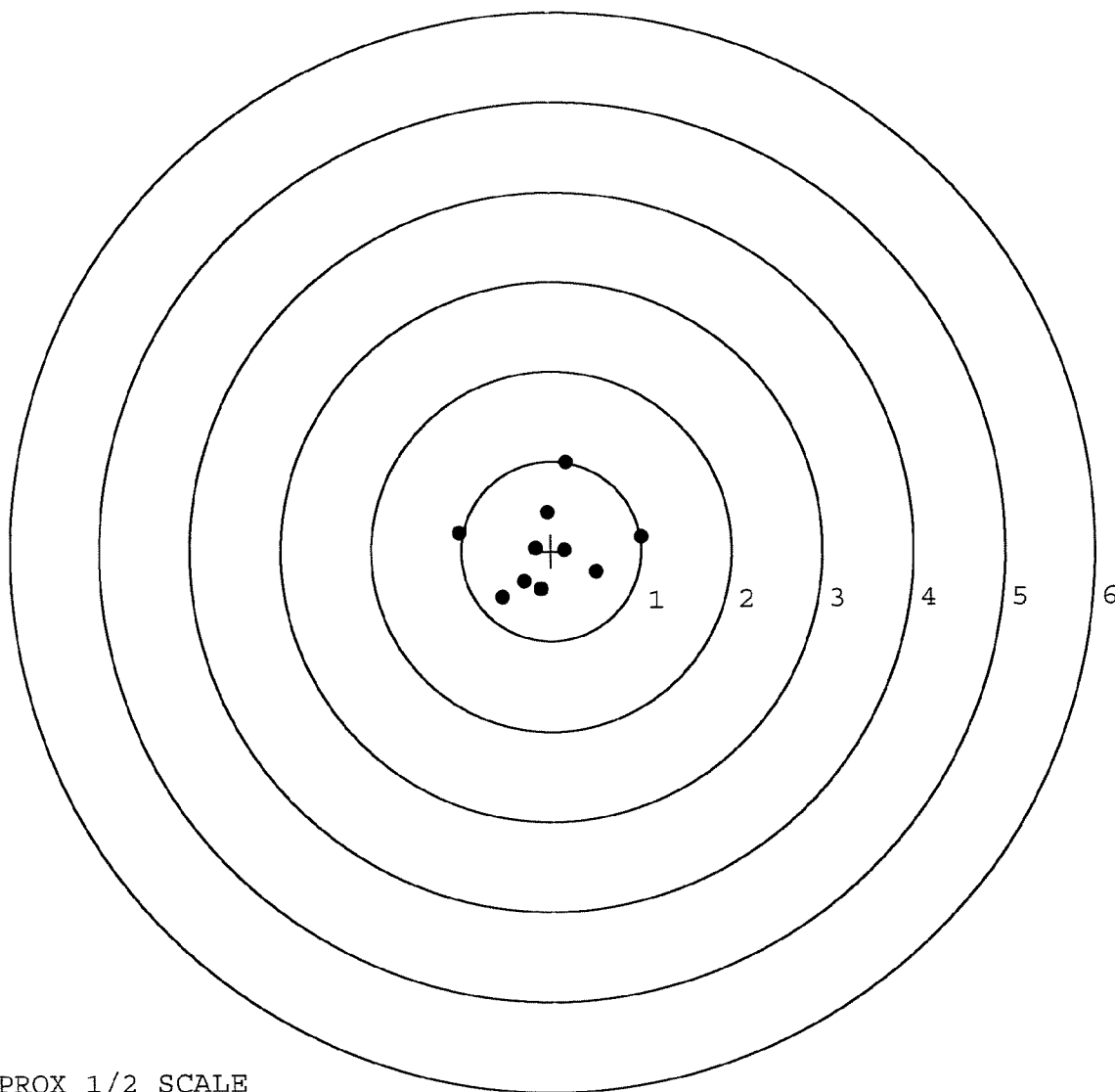
MAX RADIUS: 1.047

MEAN RADIUS: 0.604

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10

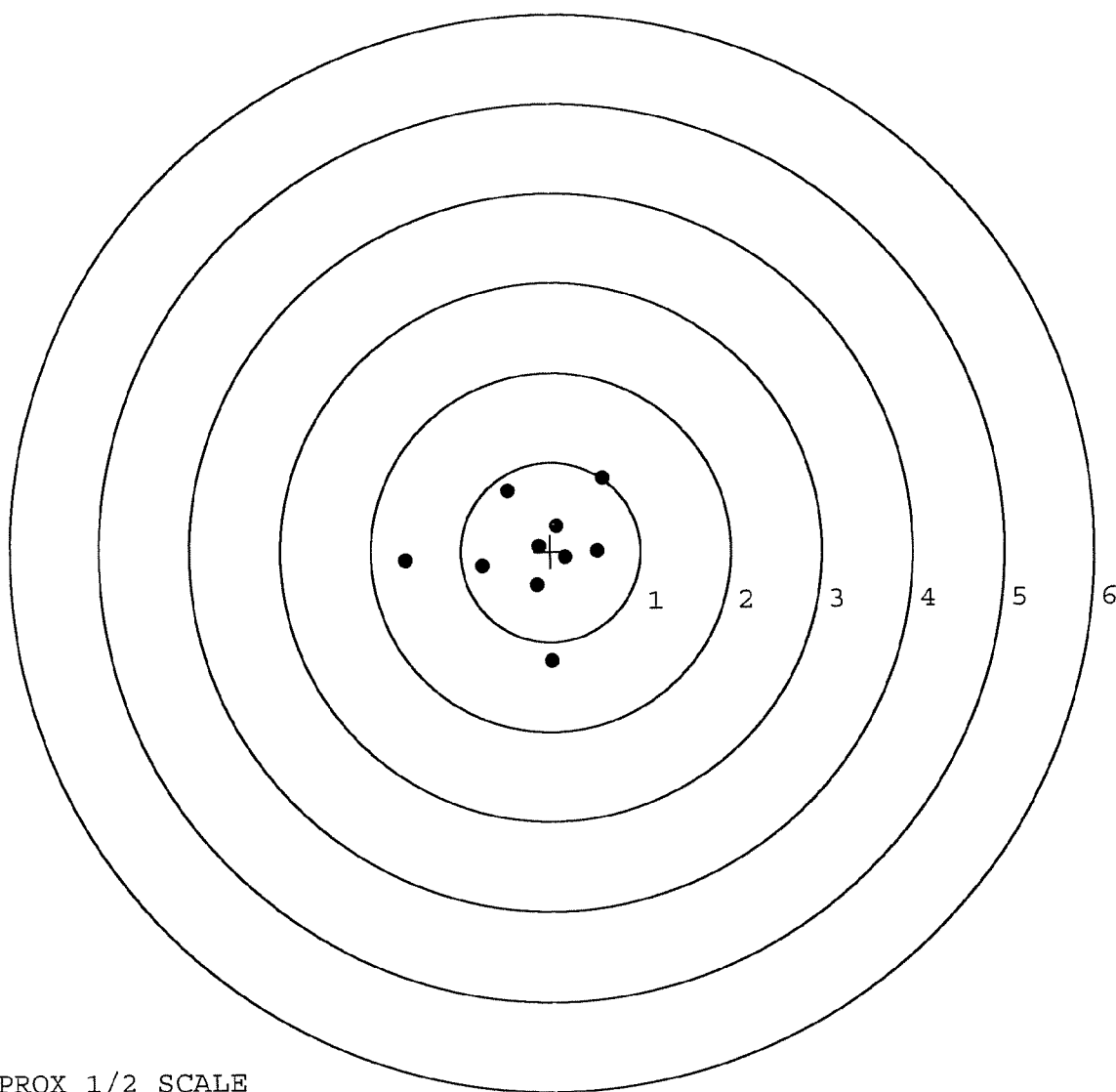


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6225344. __0
 TARGET NUMBER: 2
 FILE DATE: 10/30/2006
 FILE TIME: 14:16

POINT#	X	Y
1:	0.580	0.820
2:	-0.474	0.682
3:	-1.619	-0.094
4:	-0.762	-0.161
5:	-0.138	0.058
6:	-0.159	-0.380
7:	0.162	-0.068
8:	0.523	0.002
9:	0.011	-1.220
10:	0.072	0.280

X CENTROID: -0.180
 Y CENTROID: -0.008
 POA TO CENTROID: 0.181
 HORZ SPREAD: 2.199
 VERT SPREAD: 2.040
 GROUP SPREAD: 2.381
 MIN RADIUS: 0.079
 MAX RADIUS: 1.441
 MEAN RADIUS: 0.703
 # IN 1 IN DIAMETER: 4
 # IN 2 IN DIAMETER: 7
 # in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6225344. __0

TARGET NUMBER: 3

FILE DATE: 10/30/2006

FILE TIME: 14:16

POINT#	X	Y
1:	-0.799	0.581
2:	-1.109	0.485
3:	-0.846	0.336
4:	0.569	0.656
5:	0.129	0.313
6:	0.092	0.064
7:	-0.254	0.002
8:	-0.270	-0.312
9:	-0.010	-0.175
10:	0.240	-0.255

X CENTROID: -0.226

Y CENTROID: 0.169

POA TO CENTROID: 0.282

HORZ SPREAD: 1.678

VERT SPREAD: 0.968

GROUP SPREAD: 1.687

MIN RADIUS: 0.170

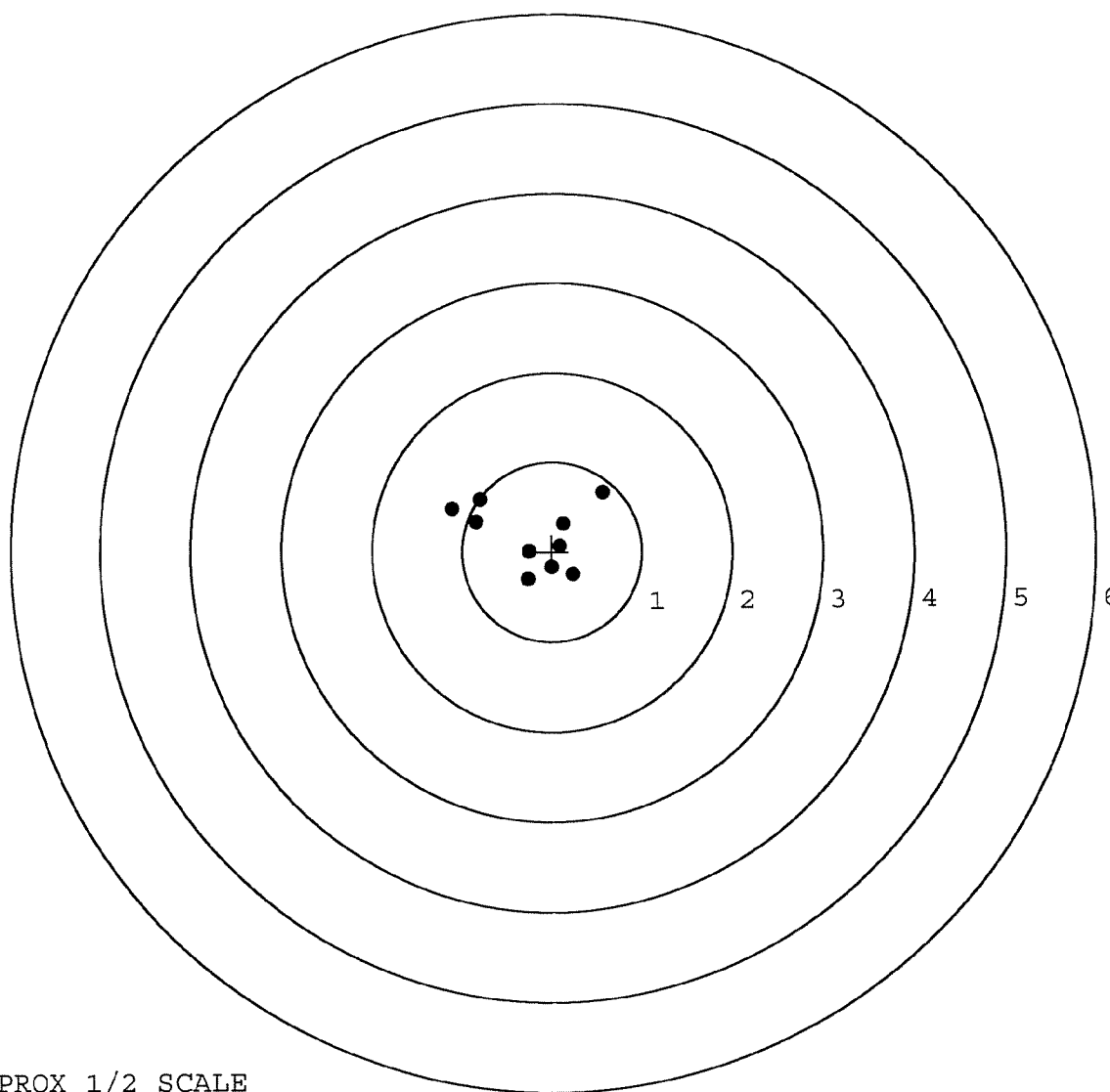
MAX RADIUS: 0.938

MEAN RADIUS: 0.563

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10

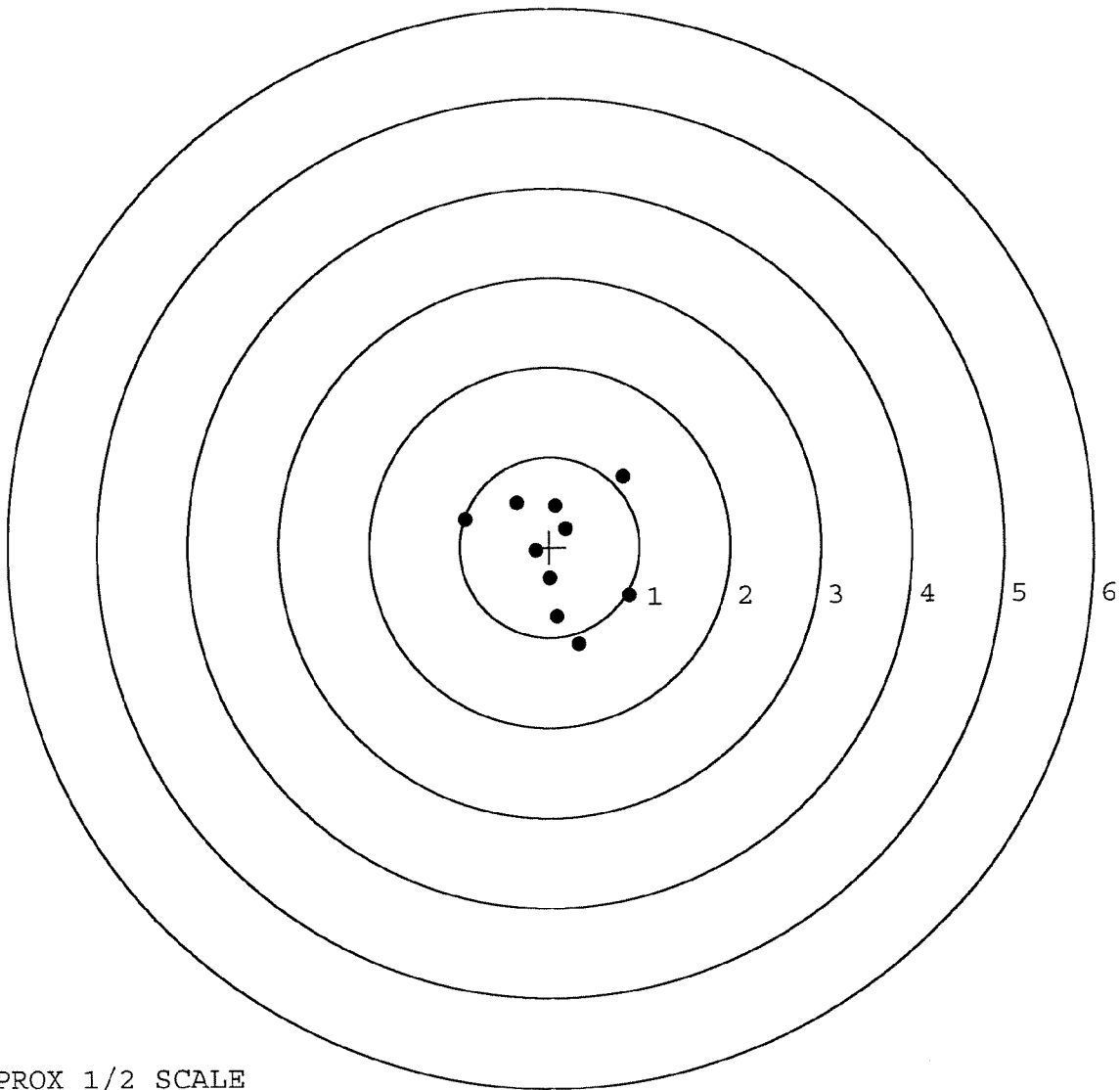


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6225344. 0
 TARGET NUMBER: 4
 FILE DATE: 10/30/2006
 FILE TIME: 14:16

POINT#	X	Y
1:	0.825	0.779
2:	0.883	-0.544
3:	0.325	-1.083
4:	0.080	-0.776
5:	0.003	-0.353
6:	-0.159	-0.041
7:	0.180	0.204
8:	0.072	0.454
9:	-0.366	0.488
10:	-0.937	0.308

X CENTROID: 0.091
 Y CENTROID: -0.056
 POA TO CENTROID: 0.107
 HORZ SPREAD: 1.820
 VERT SPREAD: 1.862
 GROUP SPREAD: 1.928
 MIN RADIUS: 0.250
 MAX RADIUS: 1.112
 MEAN RADIUS: 0.696
 # IN 1 IN DIAMETER: 3
 # IN 2 IN DIAMETER: 7
 # in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6225344. 0

TARGET NUMBER: 5

FILE DATE: 10/30/2006

FILE TIME: 14:16

X CENTROID: 0.033

Y CENTROID: -0.128

POA TO CENTROID: 0.132

HORZ SPREAD: 0.830

VERT SPREAD: 1.612

GROUP SPREAD: 1.618

MIN RADIUS: 0.170

MAX RADIUS: 0.876

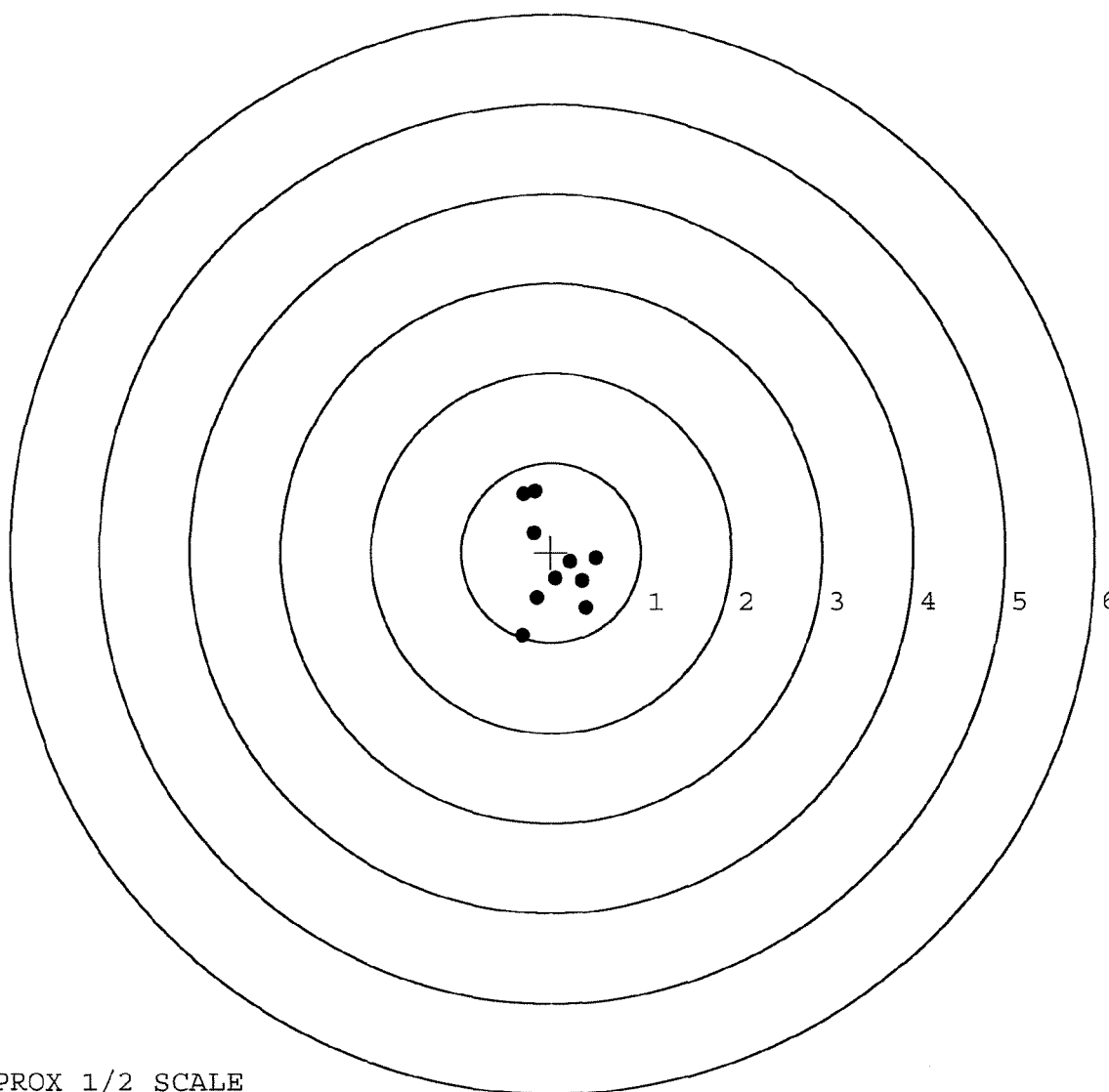
MEAN RADIUS: 0.522

IN 1 IN DIAMETER: 6

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.186	0.685
2:	-0.308	0.653
3:	-0.199	0.220
4:	0.504	-0.060
5:	0.216	-0.110
6:	0.349	-0.314
7:	0.053	-0.296
8:	-0.164	-0.510
9:	0.393	-0.616
10:	-0.326	-0.927



TARGET APPROX 1/2 SCALE

INSPECTION CHECKLIST - REPAIRS

CONTRACT #: DAAE-20-02-C-0149

R & E NUMBER	119057		
SERIAL NUMBER	CG225344		
LOG-IN DATE	10-19-06		
OPERATION #	OPERATION NAME	DATE	INITIAL
500	DIS-ASSEMBLE GUN	10-19-06	RTL
505	RE-BARREL	10-19-06	RTL
420	ASSEMBLE	10-19-06	RTL
440	PROOF	10-20-06	RTL
460	CHECK HEADSPACE	10-20-06	RTL
470	DIS-ASSEMBLE GUN	10-20-06	RTL
480	MAGNAFLUX	10-20-06	RTL
510	DRILL AND TAP	10-20-06	TRW
500	ROLLMARK CALIBER	10-20-06	CU
520	GOFF BLAST BBL / REC	10-23-06	US
530 & 540	APPLY COATINGS	10-25-06	TRW
560	FINAL ASSEMBLY	10-27-06	RTL
640	FUNCTION TEST AND	(PASS) FAIL	11-28-06 TRW
650	TARGET	(PASS) FAIL	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
670	FINAL INSPECTION		10-28-06 OK
	A) HEADSPACE	(PASS) FAIL	10-31-06 RTL
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	2.63 2.62 2.64 2.63 2.76 10-31-06 RTL
680	F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX	4.0 4.0 4.0 10-31-06 RTL
	G) SAFETY OFF FORCE	2 LBS MIN	2.0 2.0 2.0 10-31-06 RTL
	I) FIRING PIN INDENT	.020	.021 .021 .022 10-31-06 RTL
690	PACK		11-27-06 RTA

F006 REV 5/2006

BARBER - M24 0013243 FINAL INSPECTION CHECKLIST

BARREL ASSEMBLY	STOCK ASSEMBLY
_____ BARREL	_____ STOCK
_____ RECEIVER	_____ SLING SWIVEL STUDS
_____ FRONT SIGHT BASE	_____
_____ REAR SIGHT BASE	_____ BUTT PATE
_____ SCREWS	_____ LOCK NUTS
_____ FINISH	_____ BARREL CLEARANCE
_____	_____ COLOR / FINISH
SCOPE ASSEMBLY	SYSTEM CASE
_____ SCOPE	_____ SCOPE CASE
_____ SCOPE RINGS	_____ IRON SIGHTS
_____ MOUNTING SCREWS	_____ DEPLOYMENT KIT
_____ MOUNTING BASE	
_____ SCREWS	TRIGGER ASSEMBLY
_____ FINISH	_____ SAFETY OPERATION
_____ CLARITY	_____ RE-SET TO FACTORY SPECS
COMMENTS: _____	

F006 REV 5/2006

Repair Number: RE00076766	Serial: C6225344 Model 700 Center Fire Caliber: 7 64 NATO M/24 SWS Produced: 04/16/1988	Repairman:	Status: Closed 2/4/2004 5:42:48 AM																			
Address Information Customer: ☒ Received From Return To: ☐ Received From Name: DOL DOL Address 1: WEAPONS CAGE WEAPONS CAGE Address 2: BLDG 9660 PO Box: BLDG 9660 PO Box: City: FORT LEWIS FORT LEWIS State: WA Zip Code: 98433 Country: US State: WA Zip Code: 98433 Country: US FFL:																						
<table border="1"> <tr> <td>Contact / Condition</td> <td>Problems</td> <td>Estimate</td> <td>History / Status</td> <td>Shipping / Billing</td> </tr> </table>				Contact / Condition	Problems	Estimate	History / Status	Shipping / Billing														
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 Stud</td> <td>3</td> </tr> <tr> <td>A010</td> <td>Hard Case</td> <td>1</td> </tr> <tr> <td>A016</td> <td>Scope Rings</td> <td>2</td> </tr> <tr> <td>A017</td> <td>Scope Base</td> <td>1</td> </tr> <tr> <td>A026</td> <td>Scope</td> <td>1</td> </tr> </tbody> </table>	Code	Desc	Qty	A007	With Stud	3	A010	Hard Case	1	A016	Scope Rings	2	A017	Scope Base	1	A026	Scope	1
Code	Desc	Qty																				
A007	With Stud	3																				
A010	Hard Case	1																				
A016	Scope Rings	2																				
A017	Scope Base	1																				
A026	Scope	1																				
Repair Search		Refresh Close																				

nagle 2/4/2004 7:12 AM CAPS NUM INS SCPL
 start 3 2

 Serial Number: **C6225344**

 Model: **700**

RE00076766

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6225344.__0
FILE DATE AND TIME: 06/27/2002 13:48

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.109
The Average Y Centroid of the Five Target Set:	-0.089
The Average Point of Impact of the Five Target Set:	0.141
The Average Mean Radius of the Five Target Set:	0.739
The Distance from POA to Centroid Target #1:	0.288
The Distance from Centroid Target #2 to Centroid Target #1:	0.157
The Distance from Centroid Target #3 to Centroid Target #1:	0.268
The Distance from Centroid Target #4 to Centroid Target #1:	0.242
The Distance from Centroid Target #5 to Centroid Target #1:	0.278

SERIAL NUMBER: C6225344. 0

TARGET NUMBER: 1

FILE DATE: 06/27/2002

FILE TIME: 13:48

POINT#	X	Y
1:	1.612	-1.762
2:	0.874	-1.191
3:	0.566	-1.675
4:	-0.259	-0.586
5:	-0.583	0.240
6:	-0.383	0.340
7:	-0.340	0.745
8:	-0.170	1.306
9:	-1.264	0.335
10:	-2.151	0.276

X CENTROID: -0.210

Y CENTROID: -0.197

POA TO CENTROID: 0.288

HORZ SPREAD: 3.763

VERT SPREAD: 3.068

GROUP SPREAD: 4.279

MIN RADIUS: 0.392

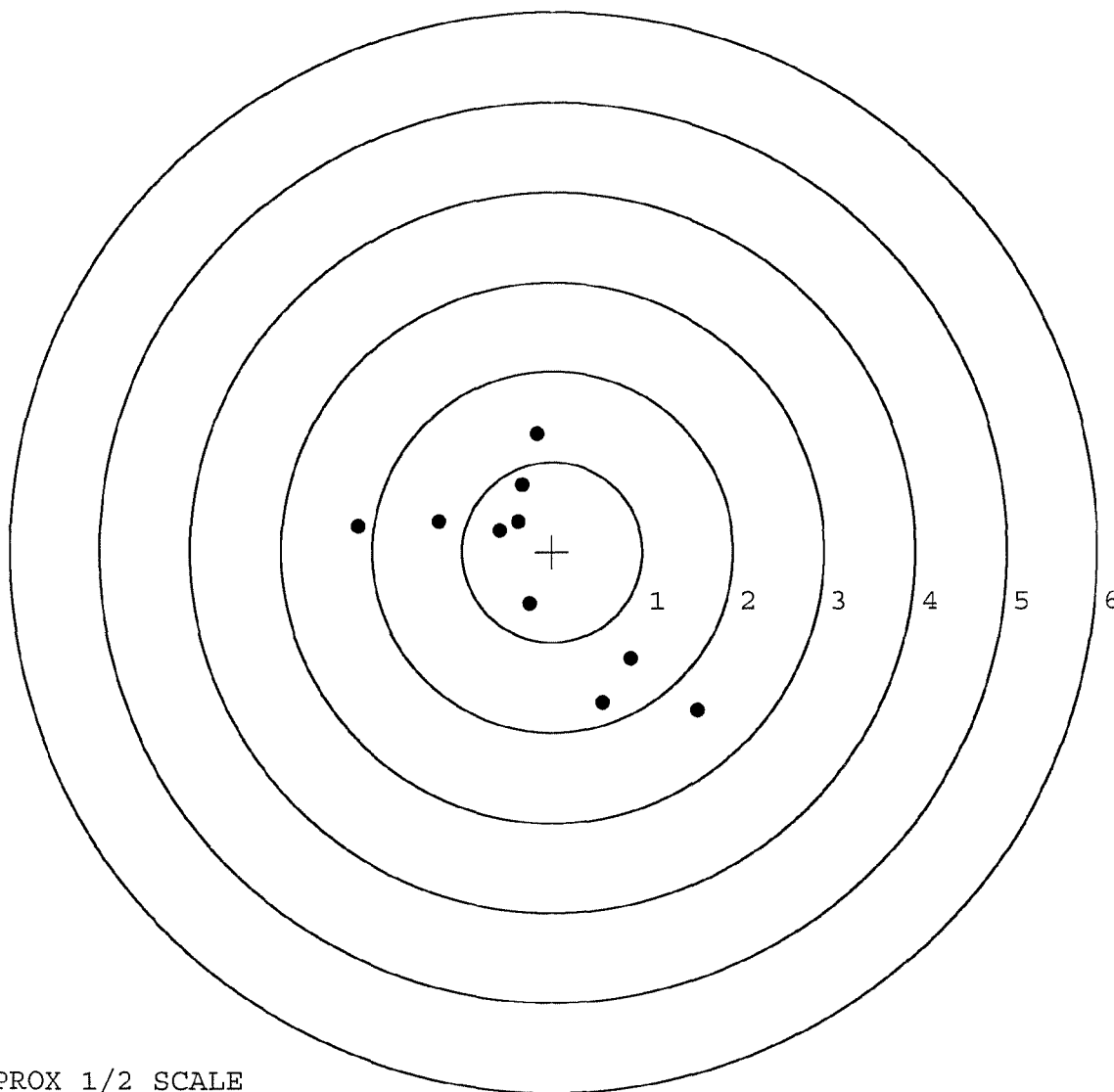
MAX RADIUS: 2.402

MEAN RADIUS: 1.271

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 4

in 3 IN DIAMETER: 6



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6225344. 0

TARGET NUMBER: 2

FILE DATE: 06/27/2002

FILE TIME: 13:48

POINT#	X	Y
1:	-0.384	1.067
2:	0.018	-2.057
3:	0.368	-0.472
4:	-0.219	-0.675
5:	-0.263	-0.310
6:	0.269	-0.179
7:	0.120	0.384
8:	-0.121	0.491
9:	-0.368	0.333
10:	-0.093	0.107

X CENTROID: -0.067

Y CENTROID: -0.131

POA TO CENTROID: 0.147

HORZ SPREAD: 0.752

VERT SPREAD: 3.124

GROUP SPREAD: 3.150

MIN RADIUS: 0.239

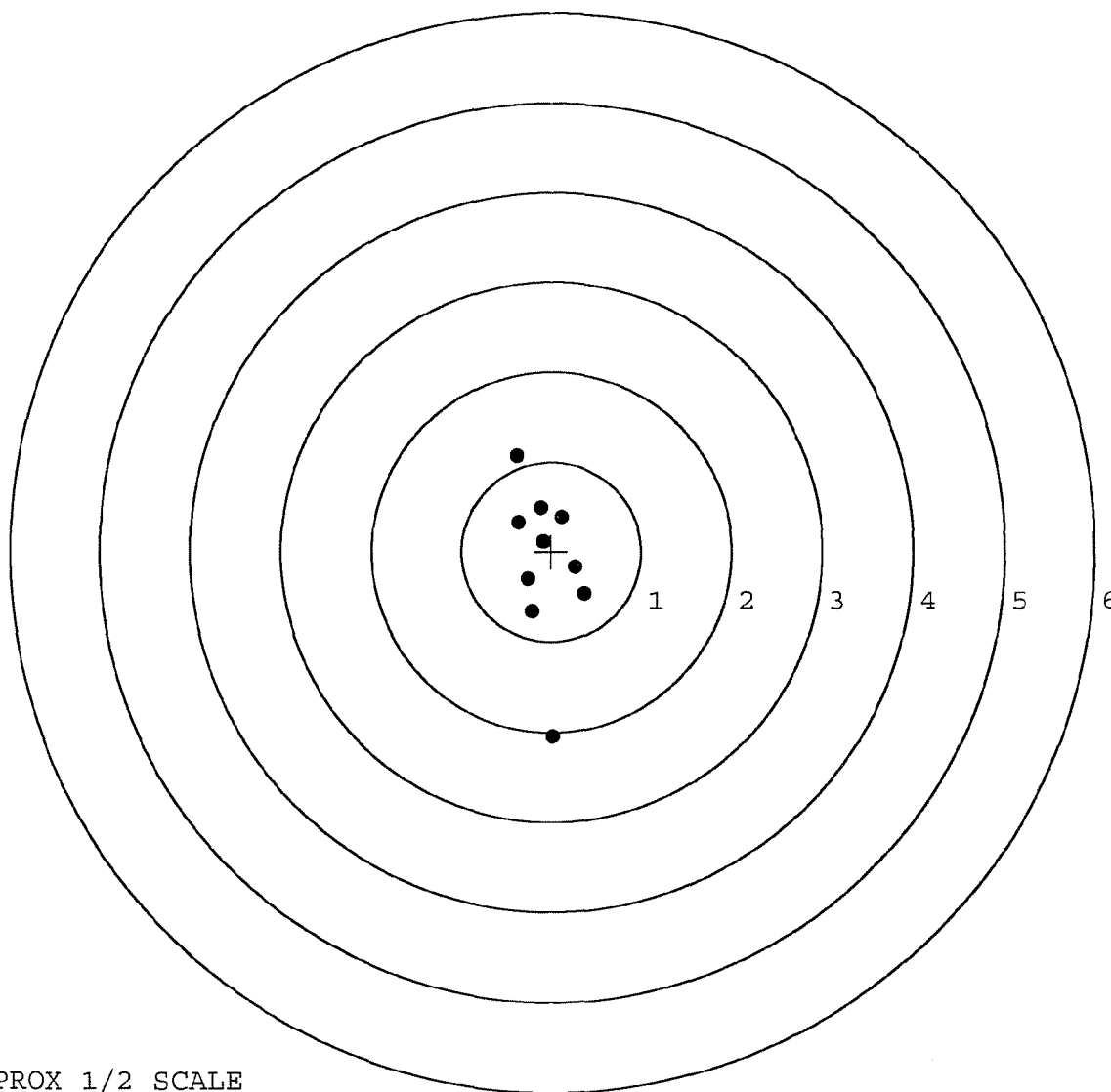
MAX RADIUS: 1.928

MEAN RADIUS: 0.685

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6225344. 0

TARGET NUMBER: 3

FILE DATE: 06/27/2002

FILE TIME: 13:48

POINT#	X	Y
1:	0.570	-0.857
2:	-0.047	-0.555
3:	-0.581	-0.941
4:	-0.703	0.092
5:	-0.276	0.126
6:	0.162	0.128
7:	-0.012	0.339
8:	0.048	0.589
9:	0.501	0.588
10:	0.330	0.191

X CENTROID: -0.001

Y CENTROID: -0.030

POA TO CENTROID: 0.030

HORZ SPREAD: 1.273

VERT SPREAD: 1.530

GROUP SPREAD: 1.873

MIN RADIUS: 0.227

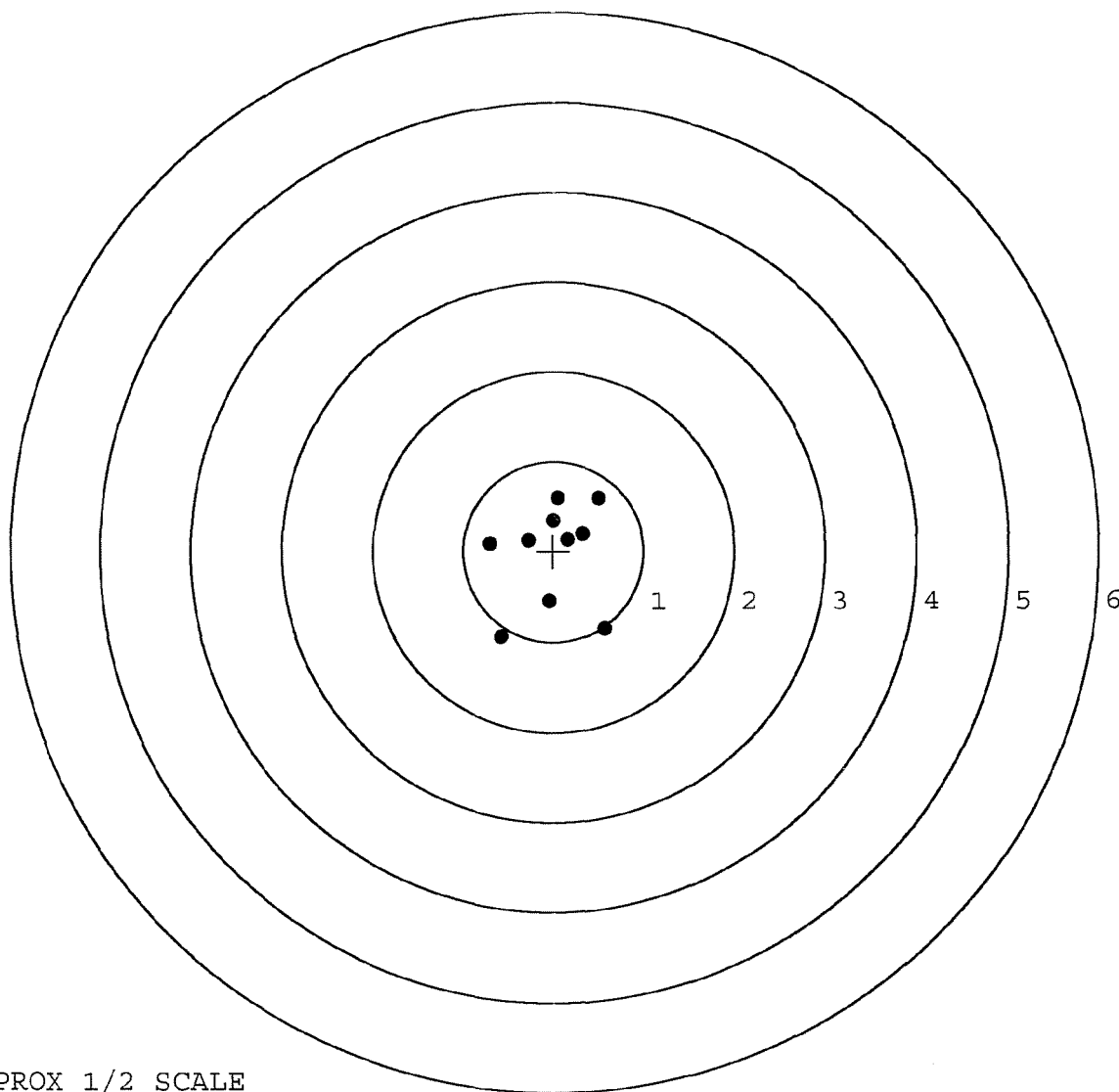
MAX RADIUS: 1.080

MEAN RADIUS: 0.605

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6225344. 0

TARGET NUMBER: 4

FILE DATE: 06/27/2002

FILE TIME: 13:48

X CENTROID: 0.028

Y CENTROID: -0.153

POA TO CENTROID: 0.156

HORZ SPREAD: 0.664

VERT SPREAD: 1.340

GROUP SPREAD: 1.349

MIN RADIUS: 0.149

MAX RADIUS: 0.871

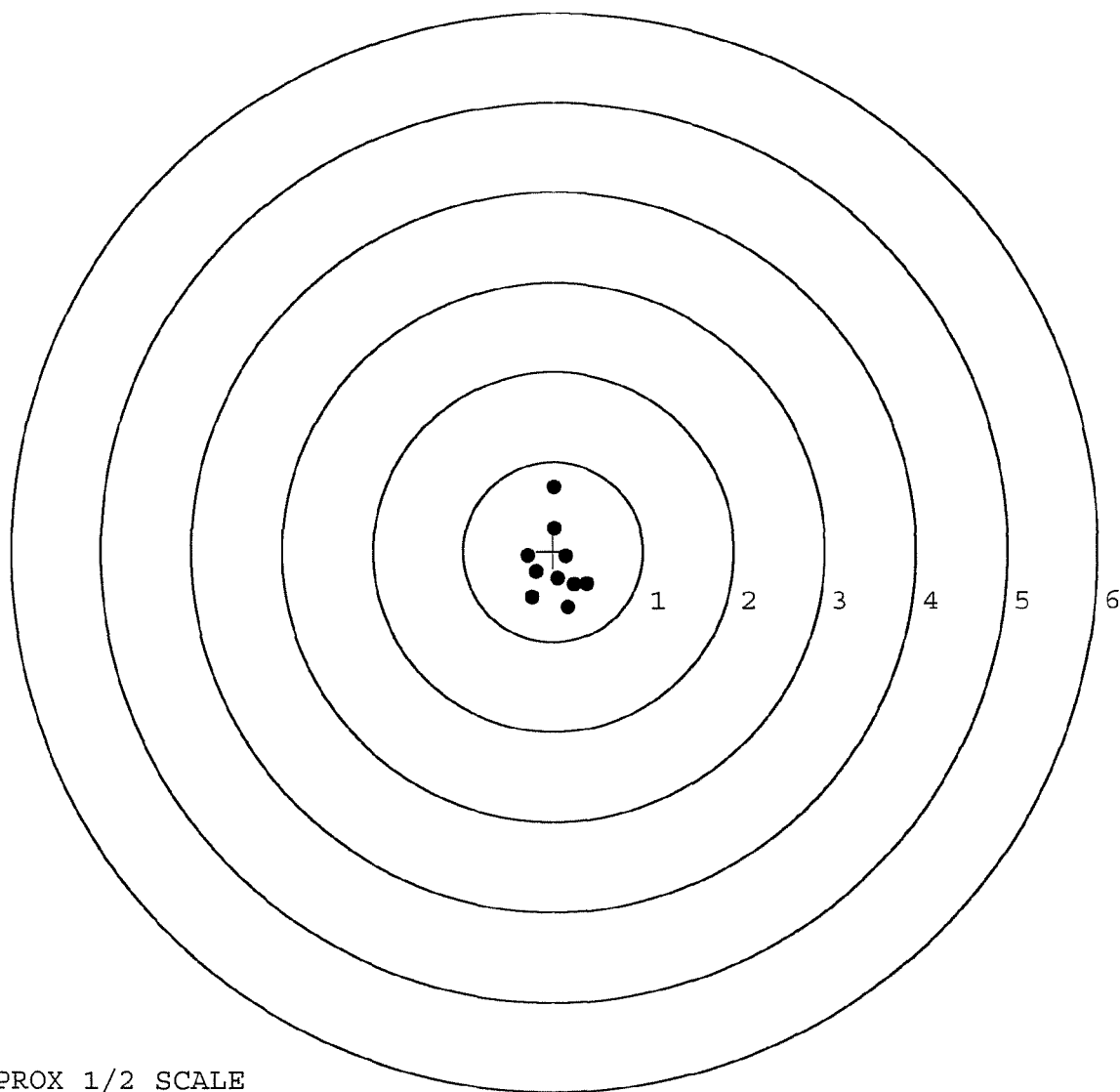
MEAN RADIUS: 0.378

IN 1 IN DIAMETER: 9

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.015	0.258
2:	0.007	0.718
3:	-0.286	-0.049
4:	0.144	-0.059
5:	0.378	-0.366
6:	0.162	-0.622
7:	-0.238	-0.510
8:	-0.189	-0.231
9:	0.050	-0.300
10:	0.236	-0.369



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6225344. __0

TARGET NUMBER: 5

FILE DATE: 06/27/2002

FILE TIME: 13:48

POINT#	X	Y
1:	0.423	-0.729
2:	-0.325	-1.434
3:	0.520	0.105
4:	0.436	0.442
5:	-0.441	0.892
6:	-0.396	0.385
7:	-0.660	0.400
8:	-0.615	0.146
9:	-0.867	0.255
10:	-1.030	0.211

X CENTROID: -0.295

Y CENTROID: 0.067

POA TO CENTROID: 0.303

HORZ SPREAD: 1.550

VERT SPREAD: 2.326

GROUP SPREAD: 2.329

MIN RADIUS: 0.329

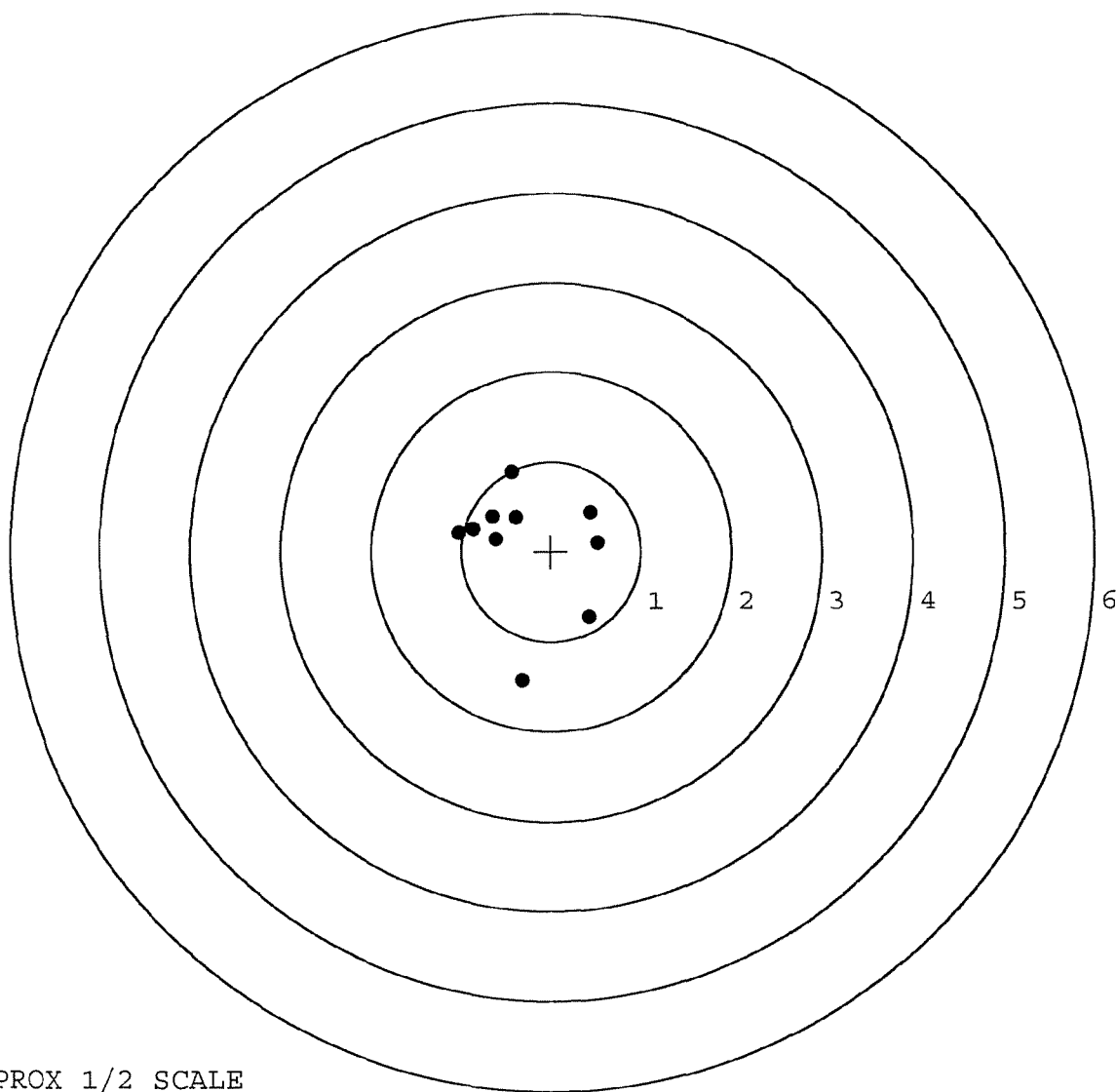
MAX RADIUS: 1.502

MEAN RADIUS: 0.756

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

Aims Services Repair & Estimate System

File Add Repair Estimate Repair Expedite Repair Inquiry Repair Tools CSR Tools Reports Table Maintenance System Maintenance Help

Repair Inquiry

Repair Number: **RE00047662** Serial: **C6225344** Model: **700** Center Fire Caliber: **7.62 NATO M-24 (SWS)** Repairman: Status: **Closed 6/4/02 2:15:23 PM**

Verify Repair

Address Information

Customer: **Received From** Return To: **Received From**

Name: **CDR HHC 3 21 INF MS85** **CDR HHC 3 21 INF MS85**

Address 1: **BOX 339500** **BOX 339500**

Address 2: PO Box: PO Box:

City: **FORT LEWIS** **FORT LEWIS**

State: **WA** Zip Code: **98433** Country: **US** State: **WA** Zip Code: **98433** Country: **US**

FFL:

Contact / Condition Problems Estimate History / Status Shipping / Billing

Contact Information

Phone:

Fax:

Email:

Comments:

Received Condition

Condition: **Poor**

Condition Notes:

CSR Notes:

Accessories Received

Code	Desc	Qty
A007	With Stud	3
A017	Scope Base	1
X	SGT BASES	2

Repair Search Refresh Close

Start | naget | 6/4/02 | 2:55 PM | CAPS | NUM | NS | SRL | 2:55 PM

Serial Number: **C6225344**

Model: **700**



RE00047662

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SERIAL NUMBER: C6225344. __0

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FILE DATE: 06/27/2002

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X CENTROID: -0.210

Y CENTROID: -0.197

POA TO CENTROID: 0.288

HORZ SPREAD: 3.763

VERT SPREAD: 3.068

GROUP SPREAD: 4.279

MIN RADIUS: 0.392

MAX RADIUS: 2.402

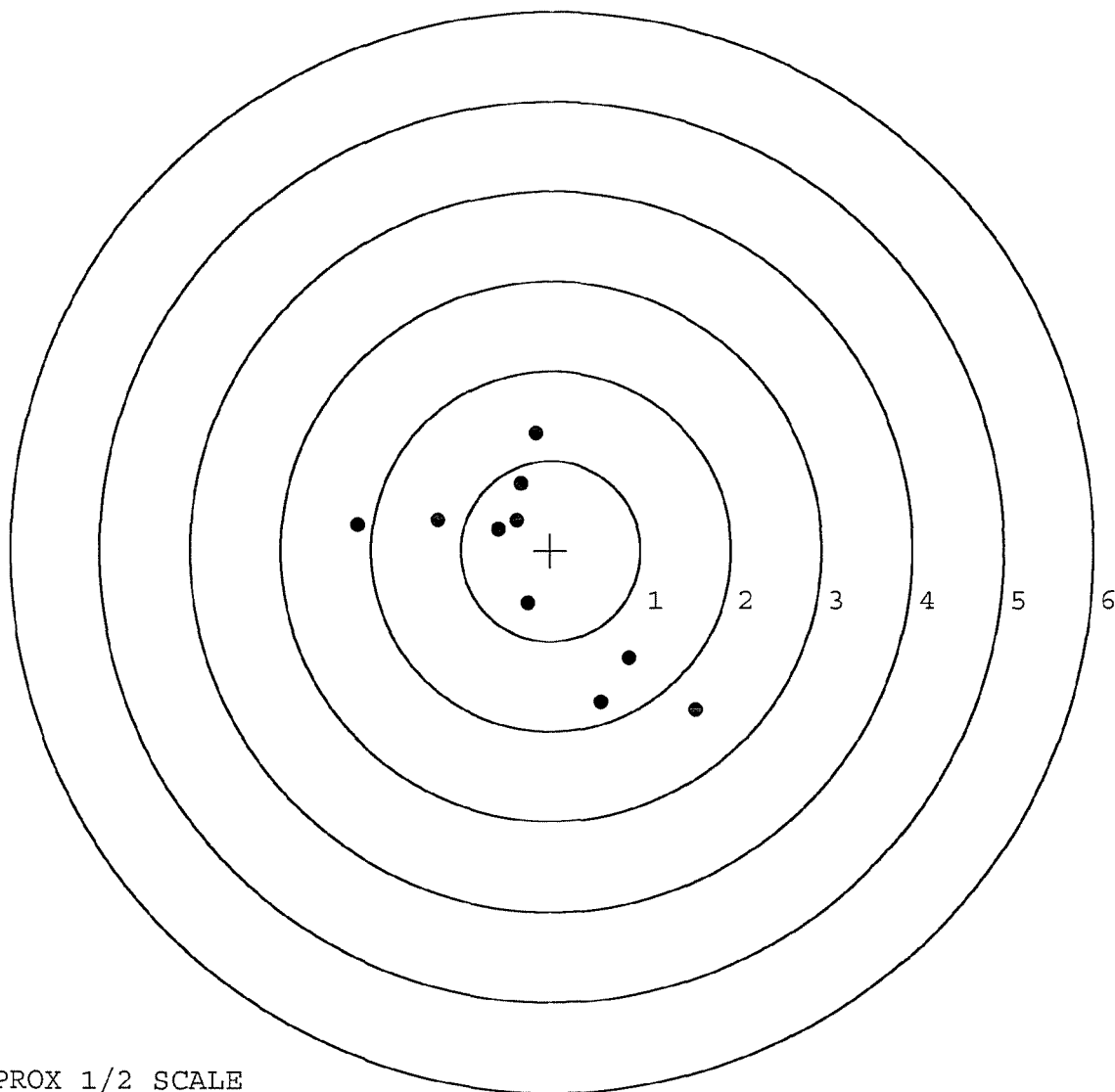
MEAN RADIUS: 1.271

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 4

in 3 IN DIAMETER: 6

POINT#	X	Y
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TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6225344. __0

TARGET NUMBER: 2

FILE DATE: 06/27/2002

FILE TIME: 13:48

X CENTROID: -0.067

Y CENTROID: -0.131

POA TO CENTROID: 0.147

HORZ SPREAD: 0.752

VERT SPREAD: 3.124

GROUP SPREAD: 3.150

MIN RADIUS: 0.239

MAX RADIUS: 1.928

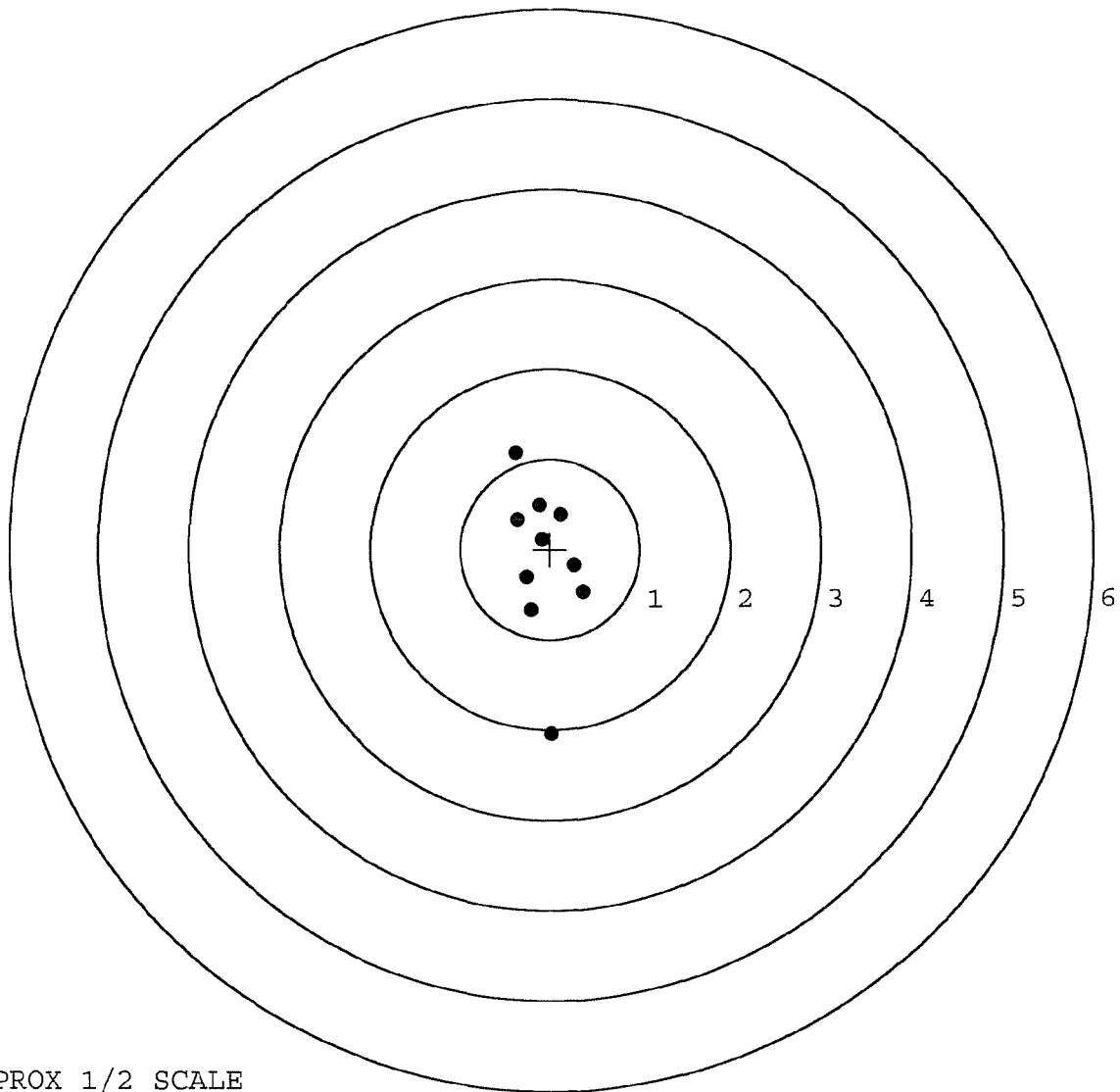
MEAN RADIUS: 0.685

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 8

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4:	-0.703	0.092
5:	-0.276	0.126
6:	0.162	0.128
7:	-0.012	0.339
8:	0.048	0.589
9:	0.501	0.588
10:	0.330	0.191

X CENTROID: -0.001

Y CENTROID: -0.030

POA TO CENTROID: 0.030

HORZ SPREAD: 1.273

VERT SPREAD: 1.530

GROUP SPREAD: 1.873

MIN RADIUS: 0.227

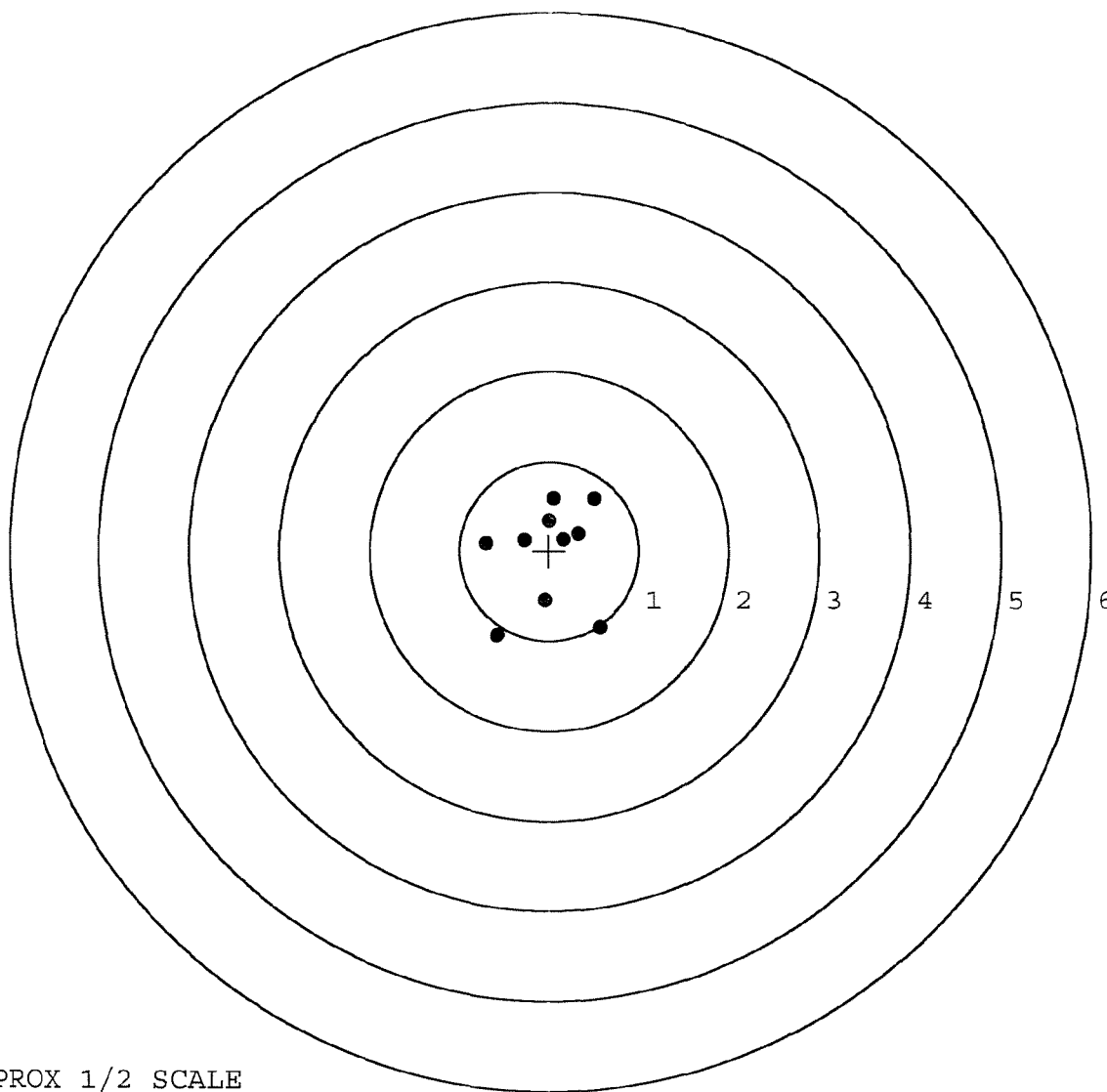
MAX RADIUS: 1.080

MEAN RADIUS: 0.605

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6225344. 0

TARGET NUMBER: 4

FILE DATE: 06/27/2002

FILE TIME: 13:48

X CENTROID: 0.028

Y CENTROID: -0.153

POA TO CENTROID: 0.156

HORZ SPREAD: 0.664

VERT SPREAD: 1.340

GROUP SPREAD: 1.349

MIN RADIUS: 0.149

MAX RADIUS: 0.871

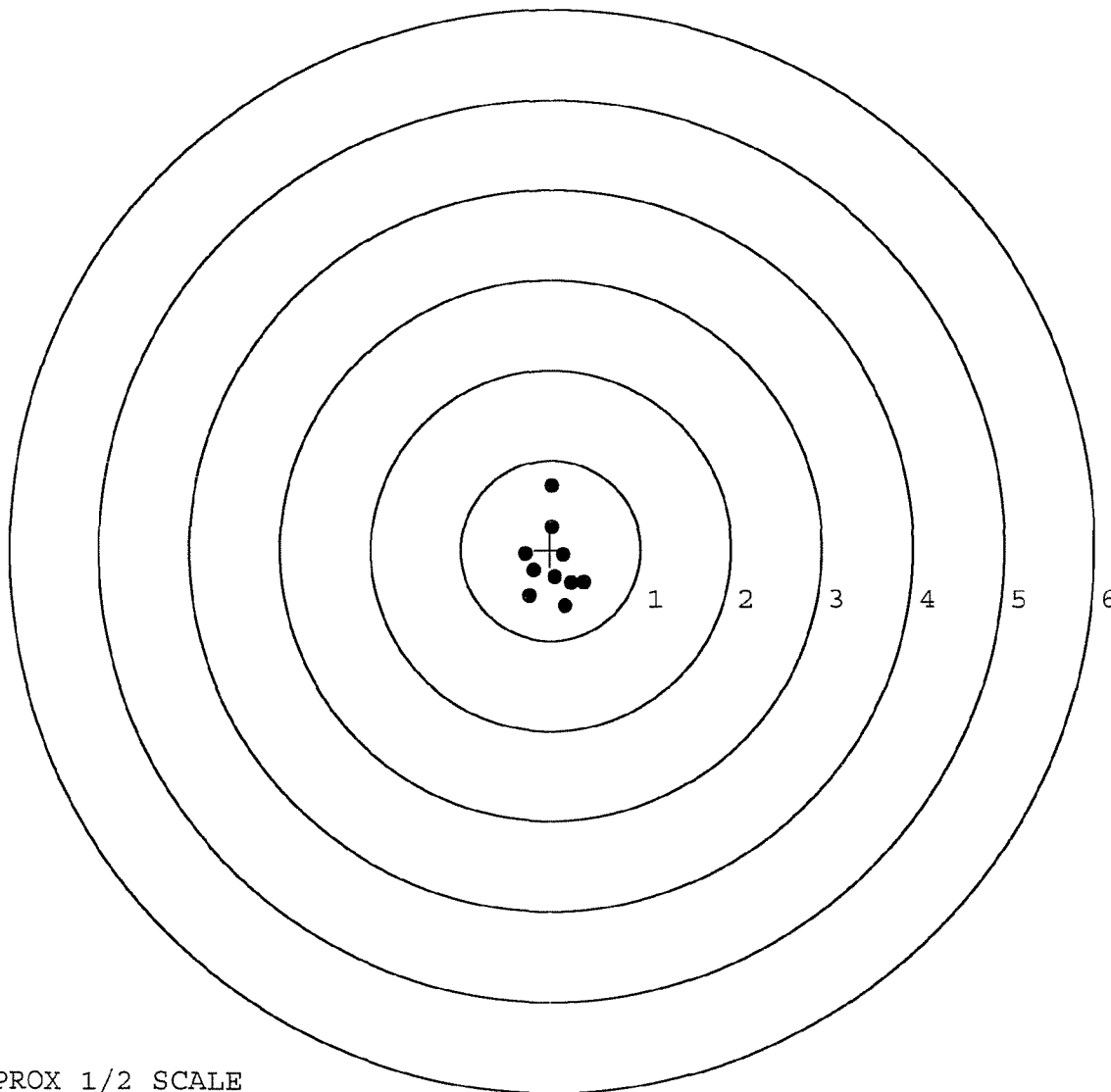
MEAN RADIUS: 0.378

IN 1 IN DIAMETER: 9

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.015	0.258
2:	0.007	0.718
3:	-0.286	-0.049
4:	0.144	-0.059
5:	0.378	-0.366
6:	0.162	-0.622
7:	-0.238	-0.510
8:	-0.189	-0.231
9:	0.050	-0.300
10:	0.236	-0.369



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6225344. 0

TARGET NUMBER: 5

FILE DATE: 06/27/2002

FILE TIME: 13:48

POINT#	X	Y
1:	0.423	-0.729
2:	-0.325	-1.434
3:	0.520	0.105
4:	0.436	0.442
5:	-0.441	0.892
6:	-0.396	0.385
7:	-0.660	0.400
8:	-0.615	0.146
9:	-0.867	0.255
10:	-1.030	0.211

X CENTROID: -0.295

Y CENTROID: 0.067

POA TO CENTROID: 0.303

HORZ SPREAD: 1.550

VERT SPREAD: 2.326

GROUP SPREAD: 2.329

MIN RADIUS: 0.329

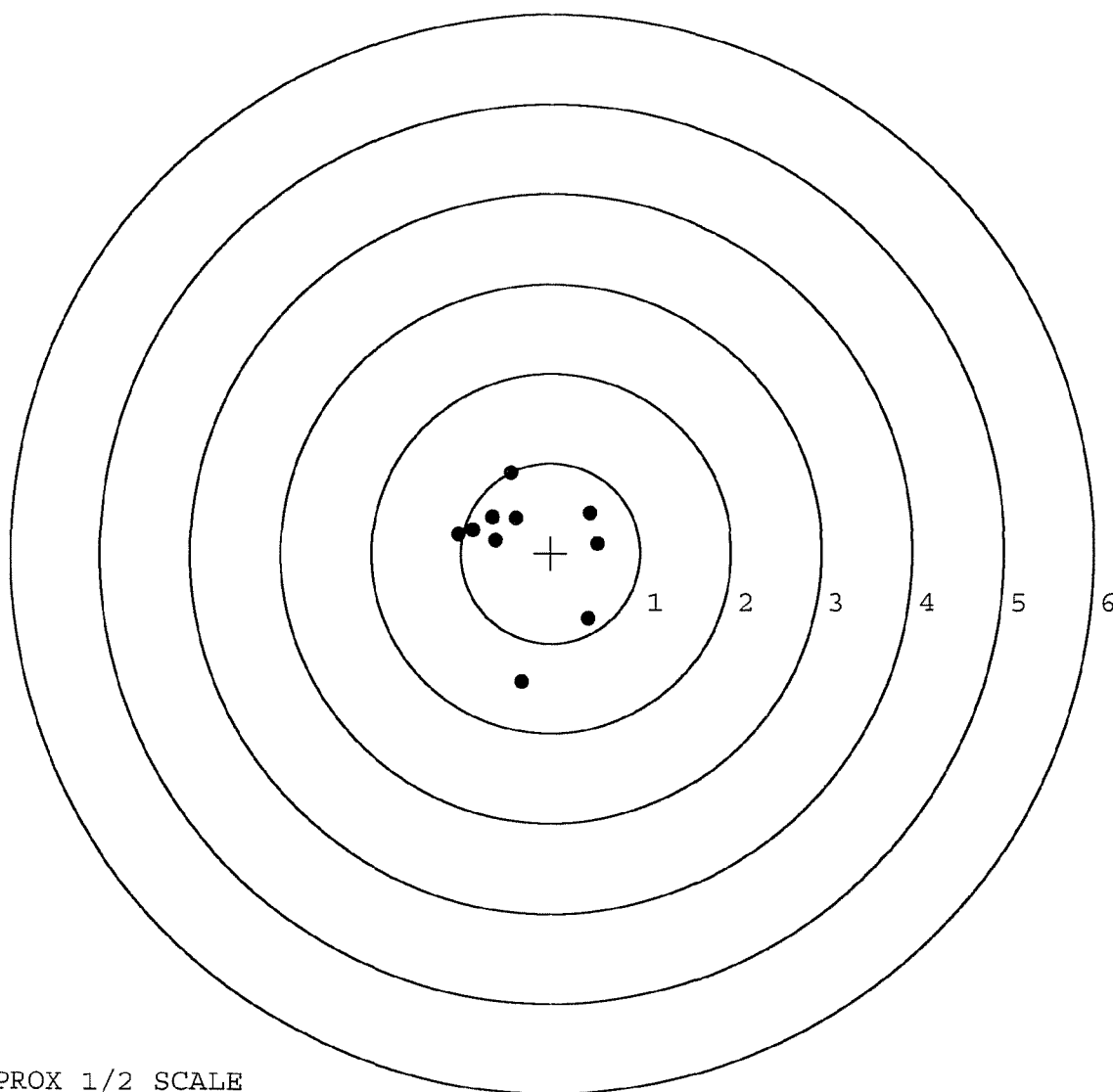
MAX RADIUS: 1.502

MEAN RADIUS: 0.756

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

M-24 INSPECTION CHECKLIST
CONTRACT #: DAAE-20-97-C-242

R & E NUMBER 47662

SERIAL NUMBER C622 5344

LOG-IN DATE 6/14/02

INSPECT AND VERIFY:			
OPERATION #	OPERATION NAME	DATE	INITIAL
550	DIS-ASSEMBLE GUN	6/14/02	RL
560 A	RE-BARREL AT CUSTOM SHOP	6/17/02	BWT
B	DRILL AND TAP	6/17/02	BWT
C	POLISH		
575	ASSEMBLE	6/17/02	RL
600	PROOF MAGNA-FLUX	6/17/02	RW
605	CHECK HEADSPACE INSPECTED	6/17/02	RW
610	DIS-ASSEMBLE GUN N 18 2002	6/17/02	RW
612	MAGNAFLUX OPERATOR ARB		
615	ROLLMARK CALIBER	6/17/02	RW
618	ROTO-BLAST	6/19/02	RO
620	APPLY COATINGS	6-24	TA
625 A	FINAL ASSEMBLY	6/26/02	RL
B	TRIGGER PULL TEST		
C	SAFETY "ON" FORCE		
D	SAFETY "OFF" FORCE		
E	FIRING PIN INDENT		
640	TARGET	6-26-02	TRW
655	FINAL INSPECT	6/28/02	RL
660	PACK	6/28/02	RA
		SHIP DATE	
QAR INSPECTION DATE			

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

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

MODEL 700™ H24

SERIAL NO.
C6225344

ORDER NO.
5716

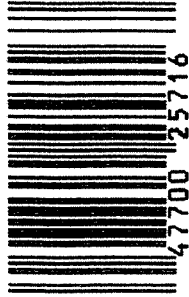
Ø1

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



5716 C6225344

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6225344

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	3 17	89	RW
600	Proof	3 17	89	RW
607	Check Headspace	3 17	89	RW
610	Dis-assemble Gun	3 17	89	RW
612	Magnaflux Barrel Action		3/21	KCR
	Magnaflux Bolt		3/21	KCR
615	Rollmark Caliber		3/21	h d
617	Drill and Tap Sight Holes	3 22	89	FB.
618	Polish Barrel	3 22	89	BT.
620	Apply Coatings (Barrel Action)		3/21/89	ISA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		4/4/89	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		4/4/89	RW
	C) Inspect Ejector Hole for Chamfer		4/4/89	RW
	D) Oil Firing Pin Ass'y		4/4/89	RW
	E) Adjust Trigger Pull to Min Setting and Stake		4-6-89	FW

op. #	BARBER - M24 0013262 OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	3	3	3			4-6-89	JU
	G) Safety Off Force	6	6	6			4-6-89	JU
	H) Trigger Pull Test & Retainability						4-5-89	2.8.
	I) Firing Pin Indent	.022	.020	.020			4-5-89	JU
	J) Assemble Stock						4/13/89	RW
	K) Assemble Swivel Studs						19 April 89	JU
	L) Attach Front and Rear Sight Assemblies						4/13/89	RW
	M) Iron Sight Alignment						4/13/89	RW
	N) Detach Front & Rear Sights & place in numbered container						4/13/89	RW
	O) Attach Scope to Rifle						4/14/89	JU
	P) Detach & Attach Scope 20 Times						4/17/89	JU
640	Gallery Target & Test	87R	65L				4/18/89	A
	A) Time						4/18/89	A
	B) Malfunctions						4/18/89	A
	C) Pierced Primers						4/18/89	A
	D) Optical Clarity of Scope						4/18/89	A
645	Inspect for Live Ammo						4/18/89	A
655	Final Inspection A) Headspace						19 April 89	JU
	B) Trigger Pull	2.18	2.31	2.31	2.22	2.27	19 April 89	JU
	C) Function						19 April 89	JU
660	Pack						27 June 89	JU

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6225344

DATE 3/28/90

TESTER DH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.27	2.26		2.19	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.31	2.28		2.25	
PULL #3	2.30	2.27		2.18	
PULL #4	2.27	2.26		2.24	
PULL #5	2.29	2.24		2.23	
TOTAL	11.44	11.31		10.99	
AVG.	2.28	2.26		2.19	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.33	3.24		
PULL #2	3.34	3.18		
PULL #3	3.27	3.24		
PULL #4	3.20	3.18		
PULL #5	3.20	3.20		
TOTAL	16.34	16.04		
AVG.	3.26	3.21		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.31	4.26		
PULL #2	4.28	4.24		
PULL #3	4.37	4.34		
PULL #4	4.29	4.33		
PULL #5	4.36	4.33		
TOTAL	21.61	21.70		
AVG.	4.32	4.34		

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6225344
19 Apr 1989

CENTROIDAL DISTANCES

0 TO	1	.128658
1 TO	2	.314197
1 TO	3	.607289
1 TO	4	.109202
1 TO	5	.0936483

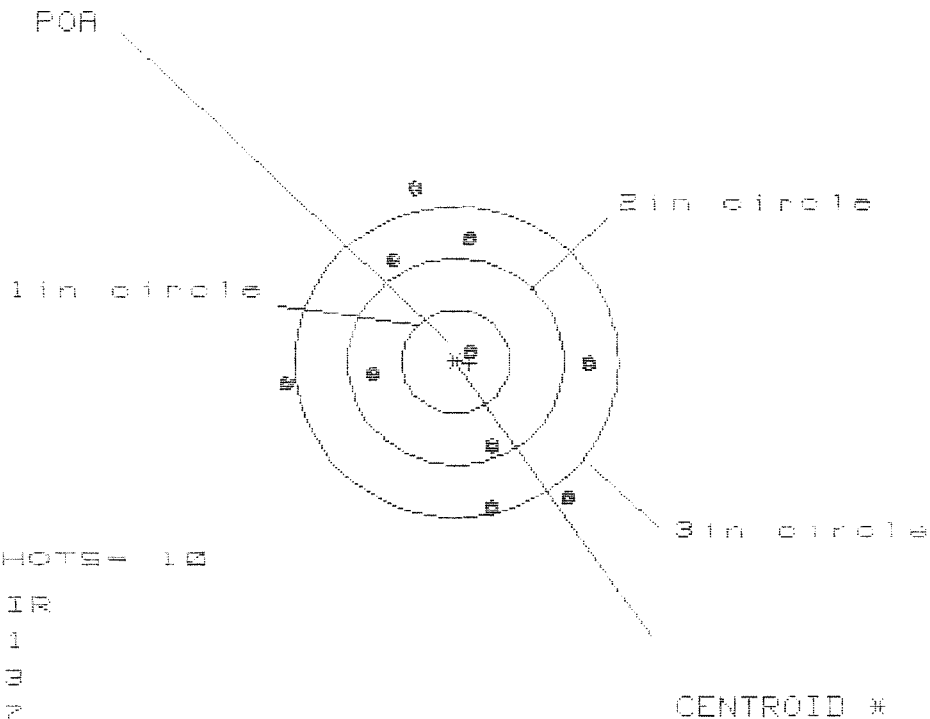
2.4 ←----POB
0

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1852
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0764
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .20034
THE AMR FOR THIS RIFLE IS: 1.062

19 Apr 1985

FILE:/PATTERNING/CENTERFIRE_PATT/06225344

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 3

3 in = 7

HS = 2.852

VS = 3.055

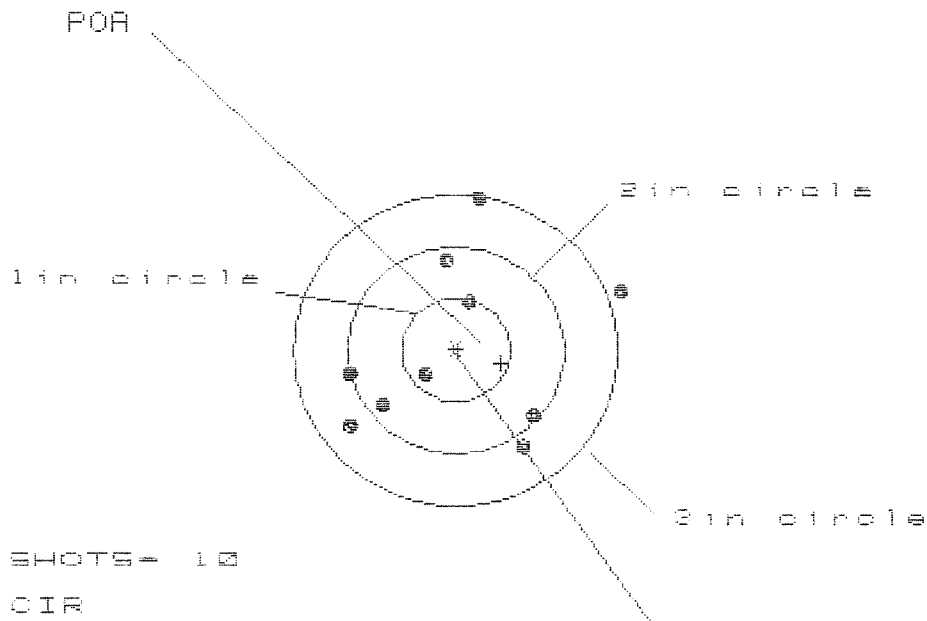
GS = 3.313

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.267	1.230	1.348
MINIMUM X	-1.585	-1.622	-1.504
MAXIMUM Y	1.689	1.352	1.206
MINIMUM Y	-1.366	-1.178	-1.324
CENTROID X	-.128	-.091	-.209
CENTROID Y	.013	-.175	-.029
POA TO CENTROID in.	.128	.197	.211
MIN RADIUS	.163	.310	.253
MEAN RADIUS	1.175	1.112	1.048
MAX RADIUS	1.721	1.623	1.517
HORIZONTAL SPREAD	2.852	2.852	2.852
VERTICAL SPREAD	3.055	2.530	2.530
EXTREME SPREAD	3.313	2.861	2.861
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	3		
NUMBER IN THREE INCH CIRCLE =	7		

19 Apr 1989

FILE:/PATTERNING/CENTERFIRE_PATT/08225344

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1 in = 2

2 in = 6

3 in = 9

HS= 2.488

VS= 2.393

ES= 2.772

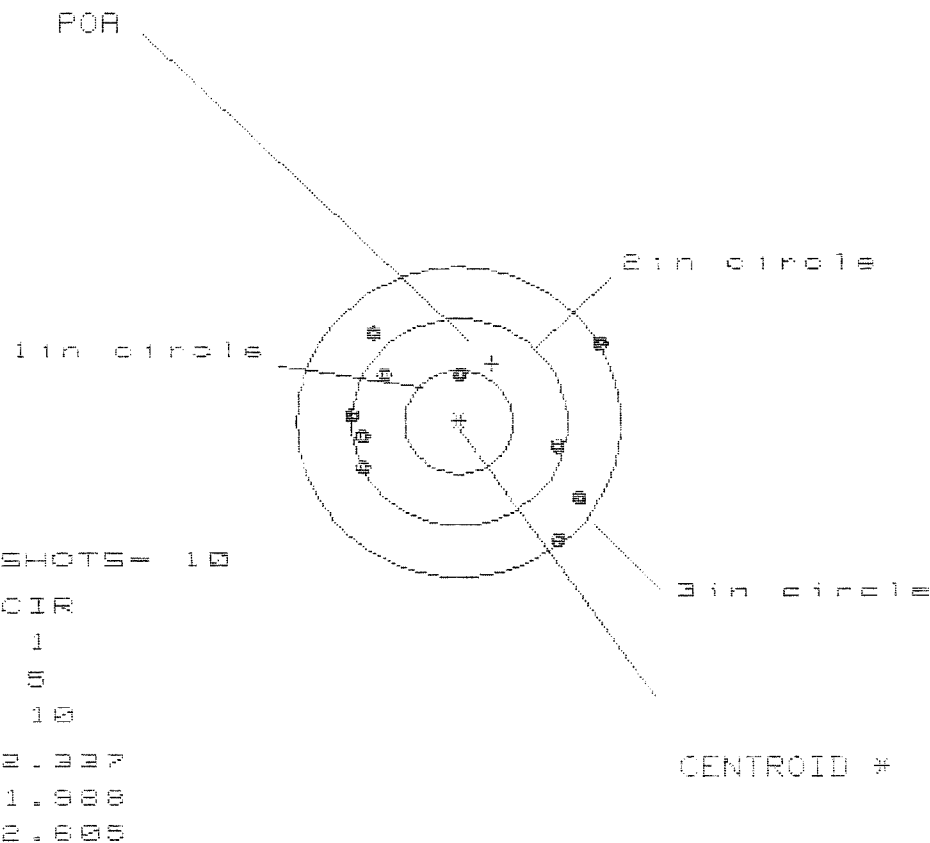
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.475	.878	.928
MINIMUM X	:	-1.013	-.850	-.800
MAXIMUM Y	:	1.424	1.483	1.155
MINIMUM Y	:	-.969	-.910	-.725
CENTROID X	:	-.420	-.583	-.633
CENTROID Y	:	.129	.070	-.115
POR TO CENTROID in.	:	.439	.588	.643
MIN RADIUS	:	.386	.225	.097
MEAN RADIUS	:	.996	.904	.793
MAX RADIUS	:	1.567	1.534	1.162
HORIZONTAL SPREAD	:	2.488	1.728	1.728
VERTICAL SPREAD	:	2.393	2.393	1.880
EXTREME SPREAD	:	2.772	2.455	1.996
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

19 Apr 1989

FILE:/PATTERNING/CENTERFIRE_PATT/08225344

CENTERFIRE PATTERNS # 3

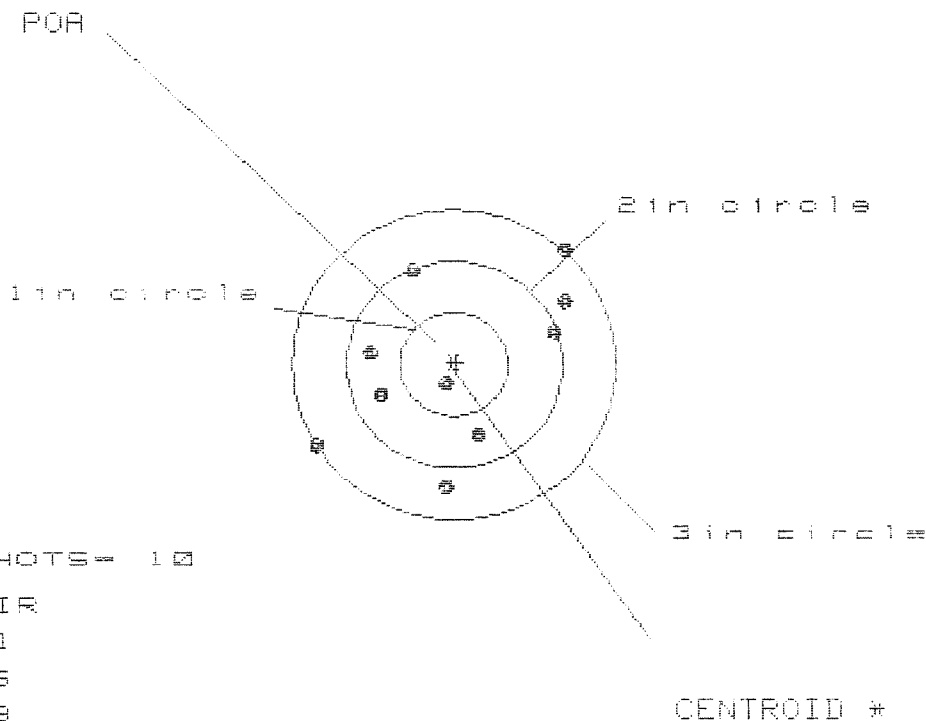


PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	1.296
MINIMUM X	-1.041
MAXIMUM Y	.887
MINIMUM Y	-1.101
CENTROID X	-.308
CENTROID Y	-.567
POB TO CENTROID in.	.646
MIN RADIUS	.429
MEAN RADIUS	1.052
MAX RADIUS	1.482
HORIZONTAL SPREAD	2.337
VERTICAL SPREAD	1.988
EXTREME SPREAD	2.605
NUMBER IN ONE INCH CIRCLE =	1
NUMBER IN TWO INCH CIRCLE =	5
NUMBER IN THREE INCH CIRCLE =	10

19 Apr 1988

FILE:/PATTERNING/CENTERFIRE_PATT/08225944

CENTERFIRE PATTERNS # 4



OF SHOTS = 10

IN CIR

1in = 1

2in = 6

3in = 9

HS = 2.318

VS = 2.323

GS = 2.954

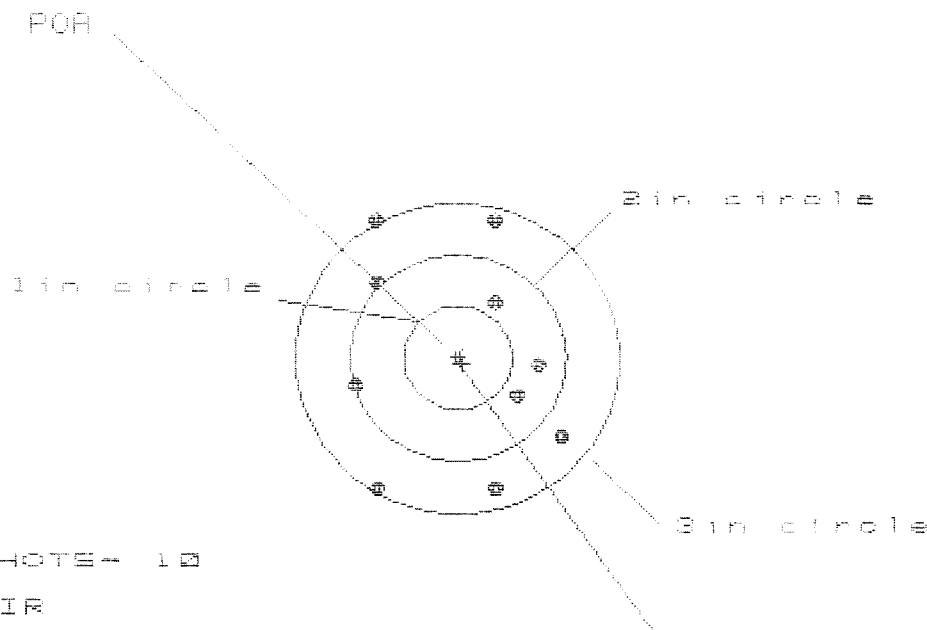
PATTERN #	4
SHOTS (BEST OF)	10
MAXIMUM X	1.067
MINIMUM X	-1.251
MAXIMUM Y	1.145
MINIMUM Y	-1.178
CENTROID X	-.023
CENTROID Y	-.017
POA TO CENTROID in.	.028
MIN RADIUS	.230
MEAN RADIUS	.973
MAX RADIUS	1.509
HORIZONTAL SPREAD	2.318
VERTICAL SPREAD	2.323
EXTREME SPREAD	2.954
NUMBER IN ONE INCH CIRCLE =	1
NUMBER IN TWO INCH CIRCLE =	6
NUMBER IN THREE INCH CIRCLE =	9

19 Apr 1989

FILE:/PATTERNING/CENTERFIRE_PATT/08285344

CENTERFIRE PATTERNS

5



OF SHOTS- 10

IN CIR

1 in = 0

2 in = 3

3 in = 9

HS= 1.980

VS= 2.631

GS= 2.843

CENTROID #

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	.979
MINIMUM X	-1.001
MAXIMUM Y	1.369
MINIMUM Y	-1.262
CENTROID X	-.047
CENTROID Y	.060
POA TO CENTROID in.	.076
MIN RADIUS	.610
MEAN RADIUS	1.115
MAX RADIUS	1.557
HORIZONTAL SPREAD	1.980
VERTICAL SPREAD	2.631
EXTREME SPREAD	2.843
NUMBER IN ONE INCH CIRCLE =	0
NUMBER IN TWO INCH CIRCLE =	3
NUMBER IN THREE INCH CIRCLE =	9