

C6587577

MODEL 700™ M24

Model **SWS**™

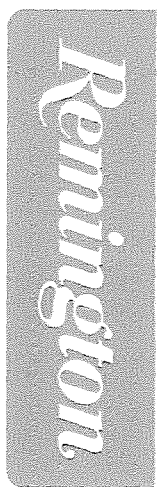
Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



Repair Inquiry

Repair Number: **RE00146507**

Serial: C6587577 Model M24 SWS Center Fire
Caliber: 7.62 NATO

Repairman:

Verify Repair

Status:

Closed 6/17/2008 9:50:25 AM

Address Information

Customer:

☒ Received From

Return To:

☐ Received From

Name: DEF DIST DEPOT

DEF DIST DEPOT

Address 1: 7 FRANKFORD AVE BLDG 362

7 FRANKFORD AVE BLDG 362

Address 2: PO Box:

PO Box:

City: ANNISTON

ANNISTON

State: AL Zip Code: 36201

Country: US

State: AL Zip Code: 36201

Country: US

FFL:

Contact / Condition

Problems

Estimate

History / Status

Shipping / Billing

Contact Information

Phone: NN

Fax:

Email:

Comments:

Received Condition

Fair

Condition Notes:

CSR Notes:

Accessories Received

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

Repair Search

Refresh

Close

nagletj

6/17/2008

10:48 AM

CAPS

NUM

INS

SCRL



Number: **C6587577**

Model: **M24 SWS**



RE00146507

INSPECTION CHECKLIST - REPAIRS

CONTRACT #: W52H09-07-C-0207

ISSUED 10/1/2007

R & E NUMBER	<u>146507</u>			
SERIAL NUMBER	<u>C6587577</u>			
LOG-IN DATE	<u>6-17-08</u>			
OPERATION #	OPERATION NAME		DATE	INITIAL
500	DIS-ASSEMBLE GUN		9-8-09	RTZ
505	RE-BARREL		9-11-09	RTZ
420	ASSEMBLE		9-11-09	RTZ
440	PROOF		9-11-09	RPD
460	CHECK HEADSPACE		9-11-09	RPD
470	DIS-ASSEMBLE GUN		9-11-09	RPD
480	MAGNAFLUX		9/11/09	RPD
510	DRILL AND TAP		9-14-09	SP
500	ROLLMARK CALIBER		9/17/09	SP
520	GOFF BLAST BBL / REC		9/17/09	RPD
530 & 540	APPLY COATINGS		9/18	
560	FINAL ASSEMBLY		9-29-09	RTZ
640	FUNCTION TEST AND	PASS	9-29-09	RPD
650	TARGET	PASS	9-29-09	RPD
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION	9-29-09	RP
670	FINAL INSPECTION			
	A) HEADSPACE	PASS	9/30/09	RP
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	2.74 2.85 2.77 2.81 2.80	9-30-09 TC
680	F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX	4.9 4.9 4.9	9/30/09 RP
	G) SAFETY OFF FORCE	2 LBS MIN	6.9 6.9 6.9	
	I) FIRING PIN INDENT	.020	.023 .023 .023	
690	PACK		10/9/09	Fm

F006 REV 1/2009

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6587577.___0

FILE DATE AND TIME: 09/30/2009 07:07

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.073
The Average Y Centroid of the Five Target Set:	0.070
The Average Point of Impact of the Five Target Set:	0.101
The Average Mean Radius of the Five Target Set:	0.593
The Distance from POA to Centroid Target #1:	0.144
The Distance from Centroid Target #2 to Centroid Target #1:	0.111
The Distance from Centroid Target #3 to Centroid Target #1:	0.153
The Distance from Centroid Target #4 to Centroid Target #1:	0.197
The Distance from Centroid Target #5 to Centroid Target #1:	0.194

SERIAL NUMBER: C6587577. __0

TARGET NUMBER: 1

FILE DATE: 09/30/2009

FILE TIME: 07:07

X CENTROID: -0.054

Y CENTROID: 0.133

POA TO CENTROID: 0.144

HORZ SPREAD: 1.200

VERT SPREAD: 1.271

GROUP SPREAD: 1.593

MIN RADIUS: 0.316

MAX RADIUS: 0.917

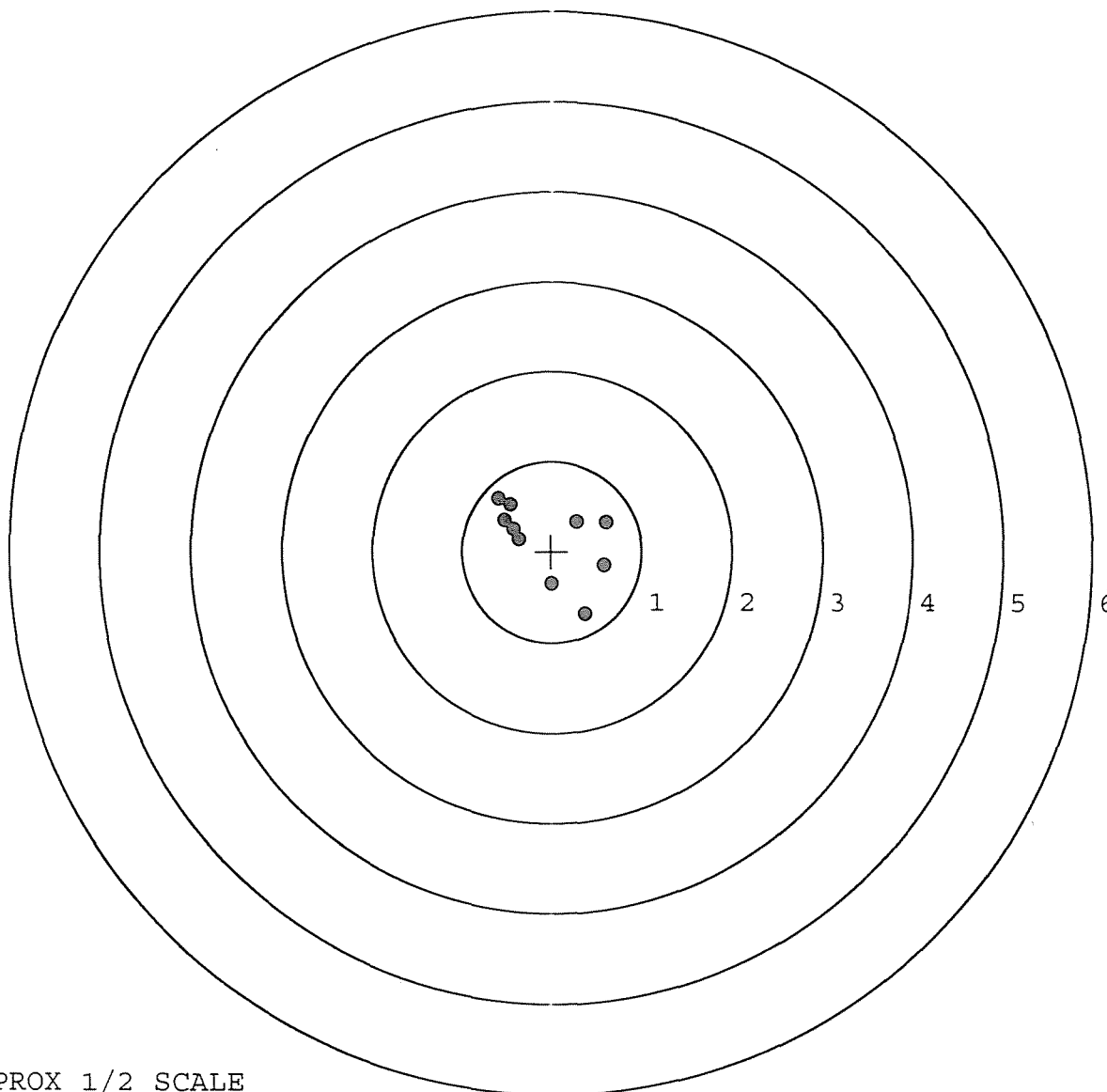
MEAN RADIUS: 0.568

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.367	-0.682
2:	0.606	0.333
3:	0.581	-0.148
4:	0.006	-0.355
5:	0.279	0.338
6:	-0.370	0.134
7:	-0.594	0.589
8:	-0.460	0.521
9:	-0.527	0.352
10:	-0.432	0.247

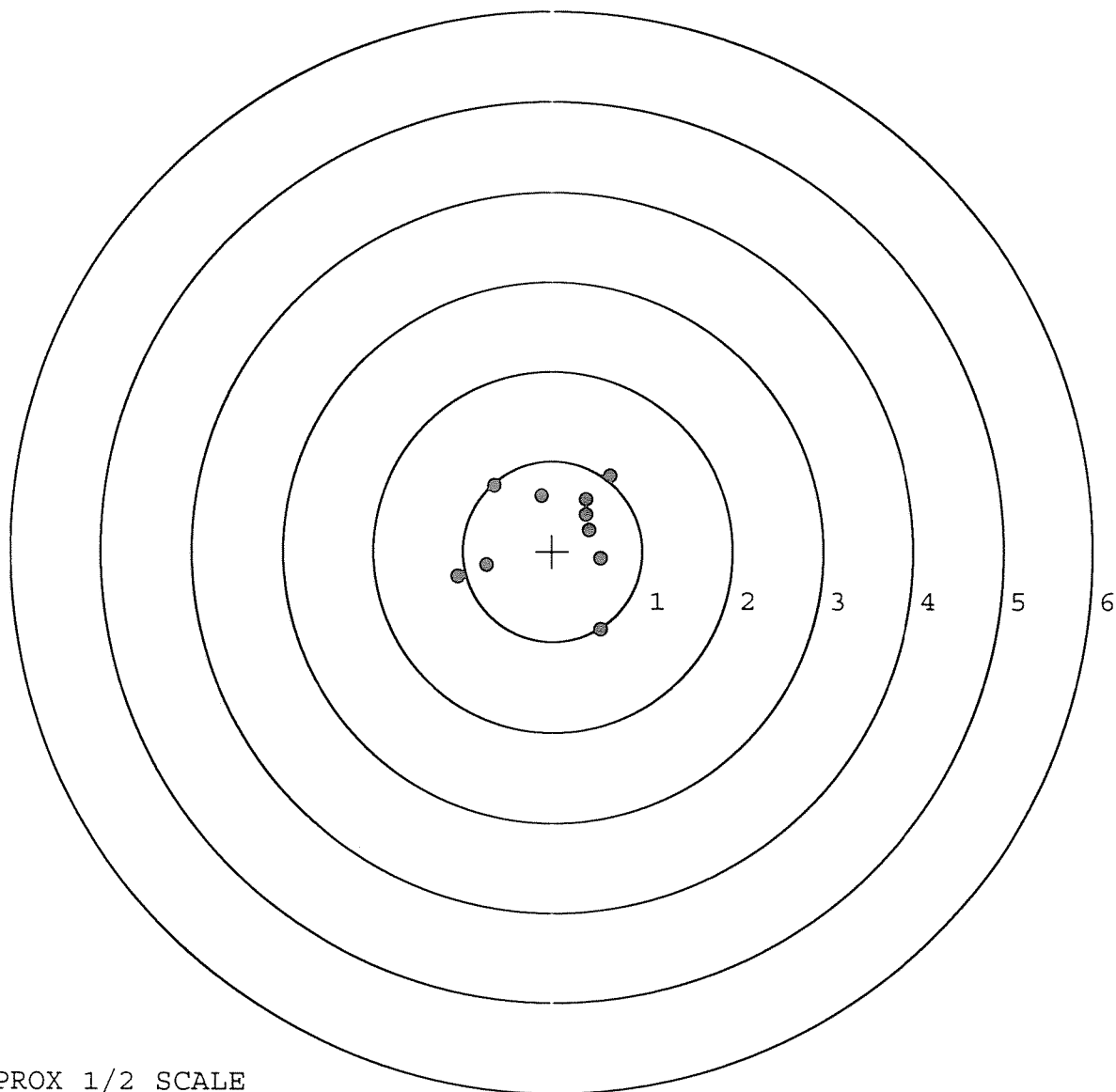


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6587577. 0
 TARGET NUMBER: 2
 FILE DATE: 09/30/2009
 FILE TIME: 07:07

X CENTROID: 0.032
 Y CENTROID: 0.202
 POA TO CENTROID: 0.205
 HORZ SPREAD: 1.699
 VERT SPREAD: 1.712
 GROUP SPREAD: 2.034
 MIN RADIUS: 0.383
 MAX RADIUS: 1.188
 MEAN RADIUS: 0.728
 # IN 1 IN DIAMETER: 3
 # IN 2 IN DIAMETER: 8
 # in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.534	-0.873
2:	-1.054	-0.280
3:	-0.736	-0.157
4:	-0.648	0.730
5:	0.536	-0.080
6:	-0.124	0.615
7:	0.645	0.839
8:	0.413	0.239
9:	0.375	0.413
10:	0.377	0.575

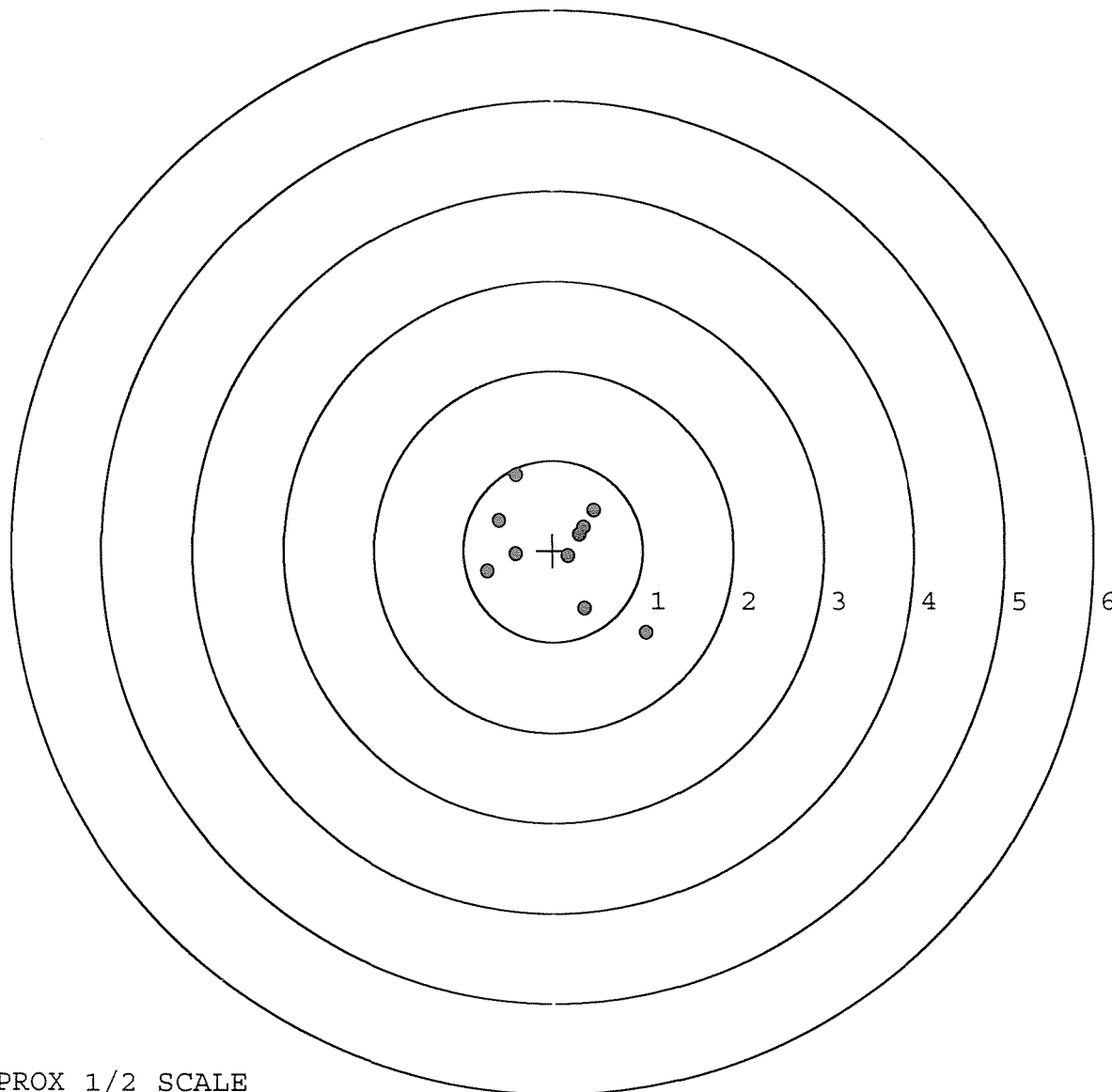


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6587577. __0
 TARGET NUMBER: 3
 FILE DATE: 09/30/2009
 FILE TIME: 07:07

X CENTROID: 0.045
 Y CENTROID: 0.017
 POA TO CENTROID: 0.048
 HORZ SPREAD: 1.765
 VERT SPREAD: 1.740
 GROUP SPREAD: 2.257
 MIN RADIUS: 0.148
 MAX RADIUS: 1.347
 MEAN RADIUS: 0.642
 # IN 1 IN DIAMETER: 4
 # IN 2 IN DIAMETER: 9
 # in 3 IN DIAMETER: 10

POINT#	X	Y
1:	1.030	-0.903
2:	0.450	0.445
3:	-0.408	0.837
4:	0.348	-0.638
5:	0.172	-0.060
6:	-0.609	0.333
7:	-0.419	-0.043
8:	-0.735	-0.232
9:	0.287	0.174
10:	0.337	0.254



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6587577. 0

TARGET NUMBER: 4

FILE DATE: 09/30/2009

FILE TIME: 07:07

X CENTROID: -0.172

Y CENTROID: -0.026

POA TO CENTROID: 0.174

HORZ SPREAD: 1.365

VERT SPREAD: 1.164

GROUP SPREAD: 1.372

MIN RADIUS: 0.080

MAX RADIUS: 0.833

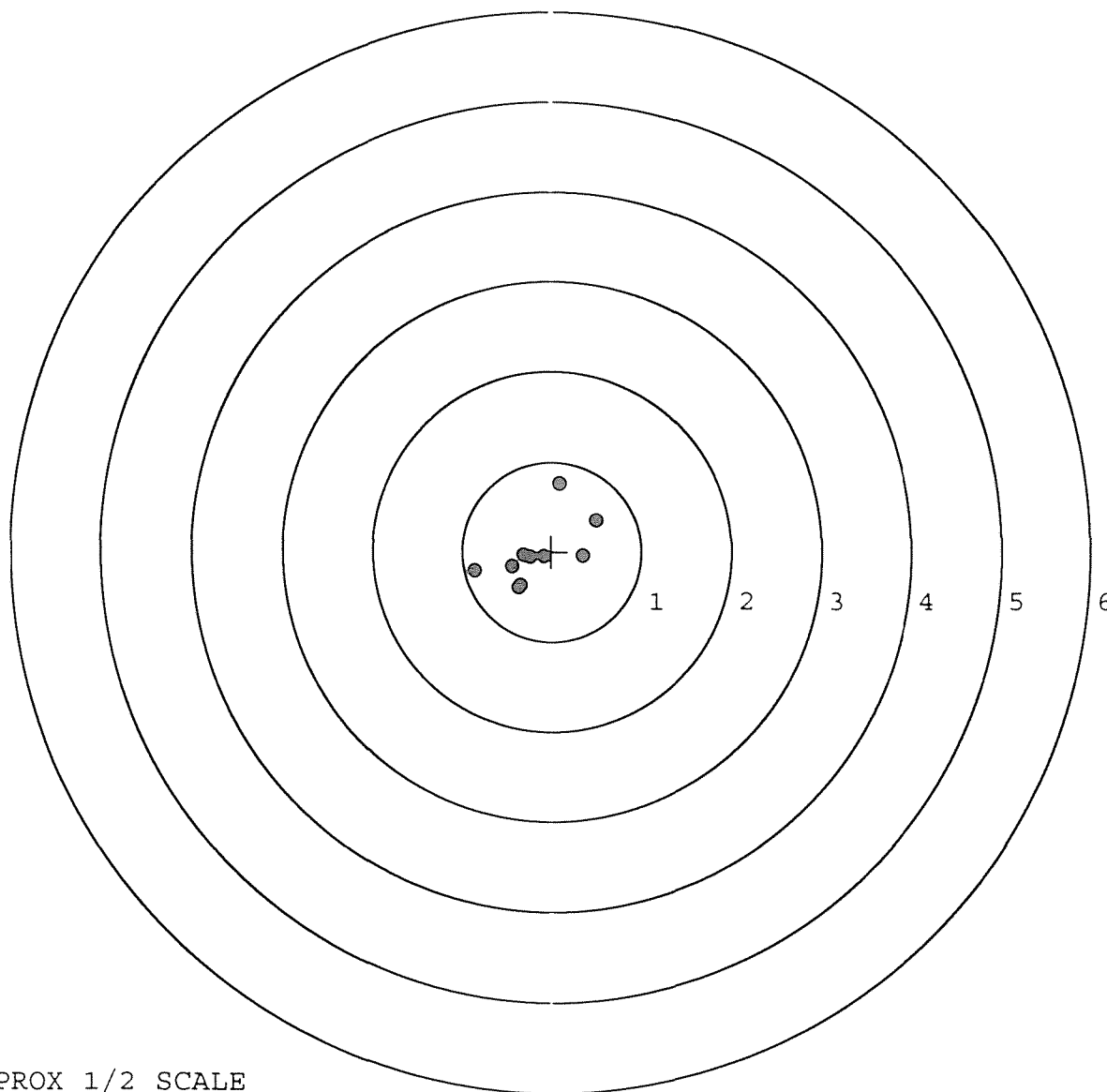
MEAN RADIUS: 0.428

IN 1 IN DIAMETER: 6

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.863	-0.217
2:	0.098	0.762
3:	0.502	0.353
4:	0.350	-0.047
5:	-0.092	-0.057
6:	-0.348	-0.375
7:	-0.315	-0.041
8:	-0.441	-0.167
9:	-0.242	-0.065
10:	-0.370	-0.402

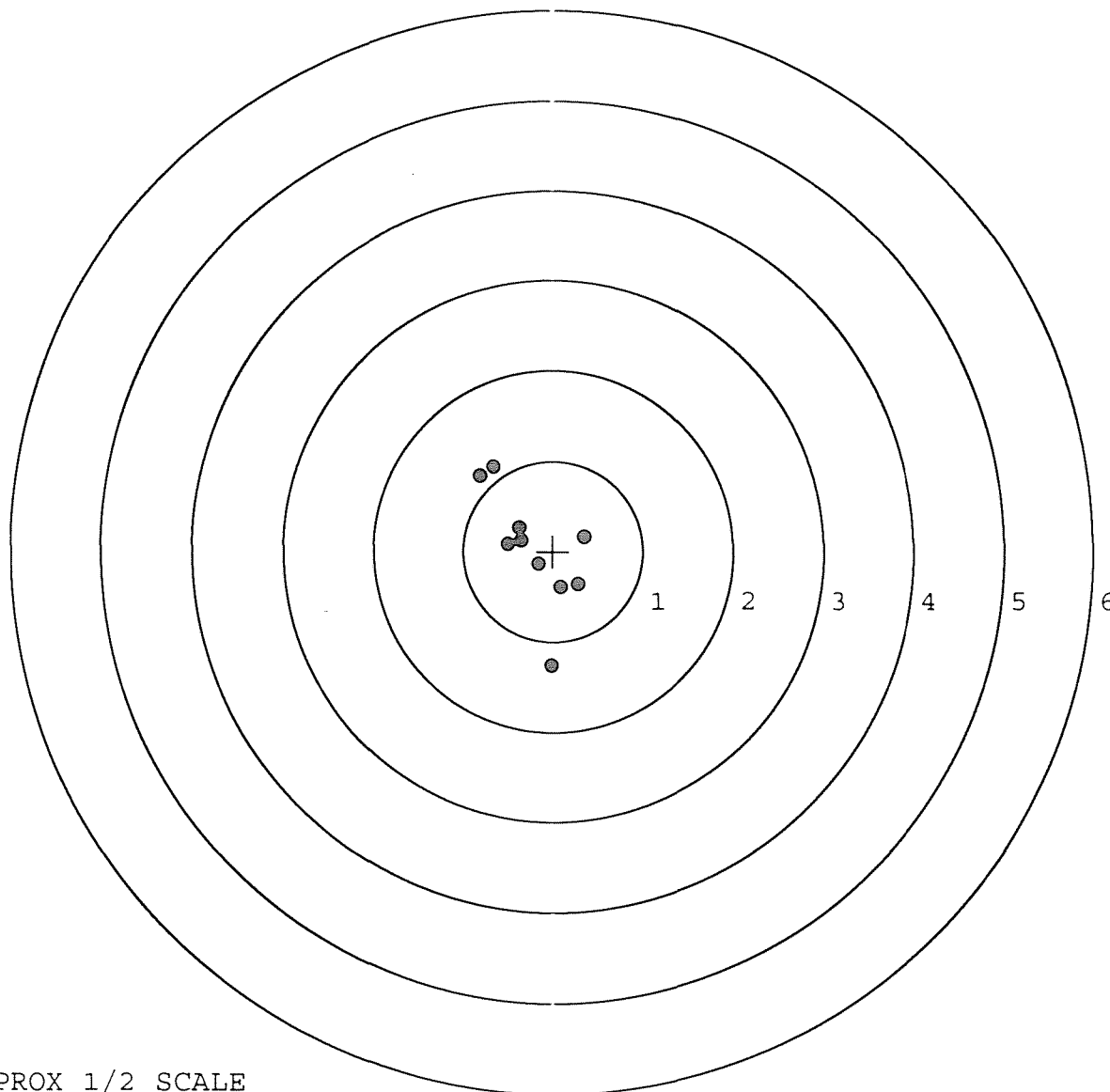


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6587577. 0
 TARGET NUMBER: 5
 FILE DATE: 09/30/2009
 FILE TIME: 07:07

X CENTROID: -0.214
 Y CENTROID: 0.023
 POA TO CENTROID: 0.216
 HORZ SPREAD: 1.165
 VERT SPREAD: 2.208
 GROUP SPREAD: 2.302
 MIN RADIUS: 0.167
 MAX RADIUS: 1.309
 MEAN RADIUS: 0.599
 # IN 1 IN DIAMETER: 4
 # IN 2 IN DIAMETER: 7
 # in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.014	-1.271
2:	0.354	0.163
3:	-0.666	0.937
4:	-0.811	0.840
5:	-0.372	0.262
6:	-0.495	0.082
7:	-0.348	0.123
8:	-0.161	-0.142
9:	0.087	-0.400
10:	0.281	-0.367



TARGET APPROX 1/2 SCALE

Arms 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: RE00092663

Serial: C6587577 Model: M24 SWS Center Fire
Caliber: 7.62 NATO

Repairman:

Verify Repair

Status:

Closed 2/8/2005 7:41:23 AM

Address Information

Customer:

☒ Received From

Return To:

☐ Received From

Name: DEF DIST DEPOT ANNISTON

DEF DIST DEPOT ANNISTON

Address 1:

Address 2:

PO Box

PO Box

City: ANNISTON

ANNISTON

State: AL

Zip Code: 362014199

Country: US

State: AL

Zip Code: 362014199

Country: US

FFL:

Contact / Condition

Problems

Estimate

History / Status

Shipping / Billing

Contact Information

Phone:

Fax:

Email:

Comments:

Received Condition

Good

Condition
Notes:CSR
Notes:

Accessories Received

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

Repair Search

Refresh

Close

nagletj

2/8/2005

9:40 AM

CAPS

NUM

INS

SCPL

start

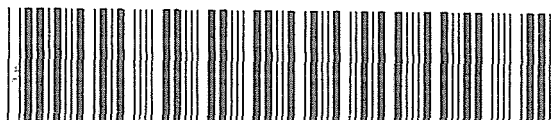
3

Arms Services R...

4

Serial Number: C6587577

Model: M24 SWS



RE00092663

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6587577.___0

FILE DATE AND TIME: 03/08/2005 07:46

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.009
The Average Y Centroid of the Five Target Set:	-0.061
The Average Point of Impact of the Five Target Set:	0.062
The Average Mean Radius of the Five Target Set:	0.874
The Distance from POA to Centroid Target #1:	0.079
The Distance from Centroid Target #2 to Centroid Target #1:	0.189
The Distance from Centroid Target #3 to Centroid Target #1:	0.186
The Distance from Centroid Target #4 to Centroid Target #1:	0.193
The Distance from Centroid Target #5 to Centroid Target #1:	0.191

SERIAL NUMBER: C6587577. __0

TARGET NUMBER: 1

FILE DATE: 03/08/2005

FILE TIME: 07:46

X CENTROID: -0.053

Y CENTROID: -0.058

POA TO CENTROID: 0.079

HORZ SPREAD: 2.031

VERT SPREAD: 1.549

GROUP SPREAD: 2.453

MIN RADIUS: 0.067

MAX RADIUS: 1.360

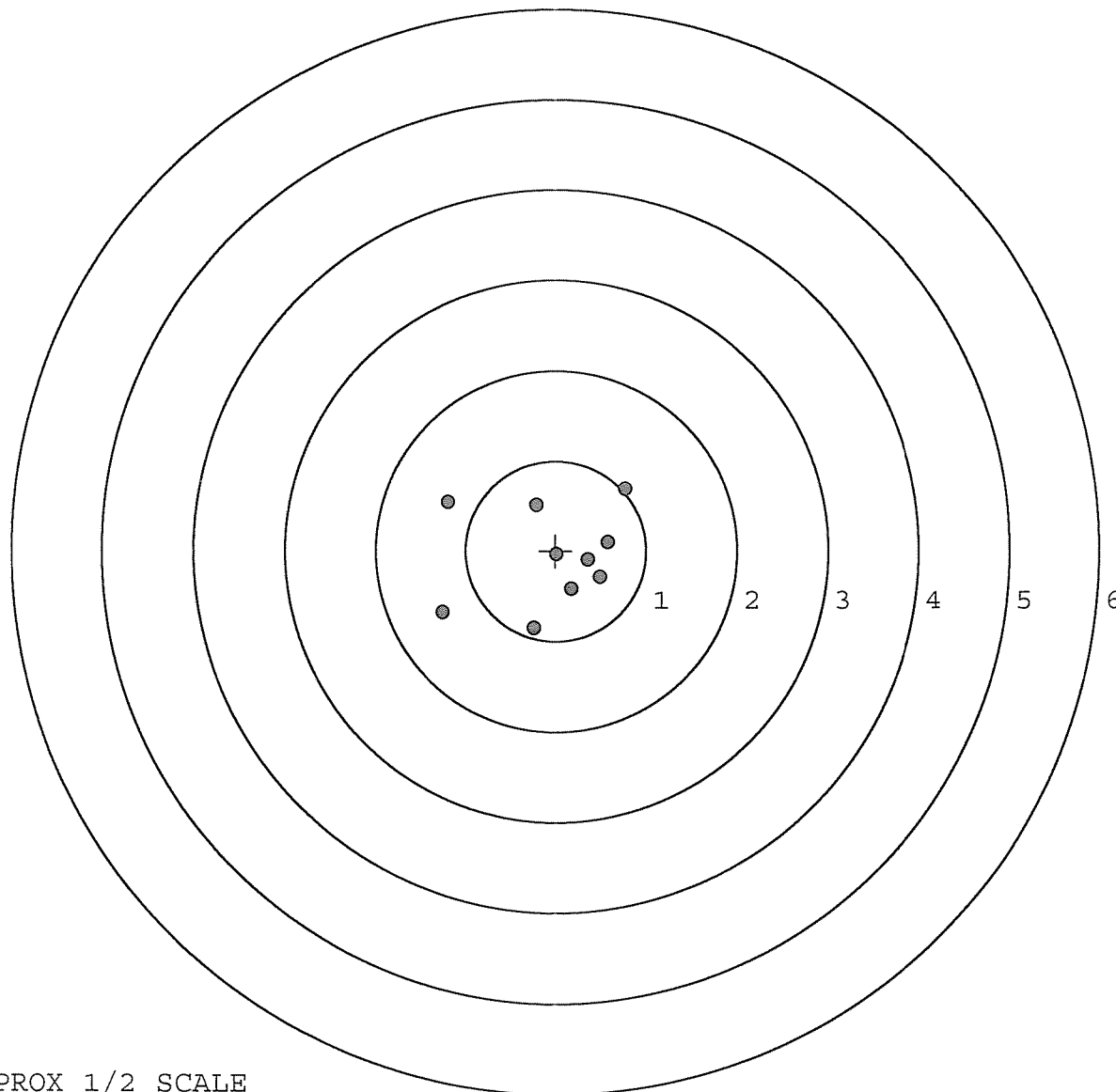
MEAN RADIUS: 0.734

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.244	-0.861
2:	-1.259	-0.688
3:	-1.199	0.544
4:	-0.214	0.512
5:	0.772	0.688
6:	0.574	0.098
7:	0.489	-0.294
8:	0.177	-0.432
9:	0.012	-0.042
10:	0.357	-0.102



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6587577. __0

TARGET NUMBER: 2

FILE DATE: 03/08/2005

FILE TIME: 07:46

X CENTROID: 0.130

Y CENTROID: -0.012

POA TO CENTROID: 0.130

HORZ SPREAD: 2.806

VERT SPREAD: 2.192

GROUP SPREAD: 3.183

MIN RADIUS: 0.483

MAX RADIUS: 1.694

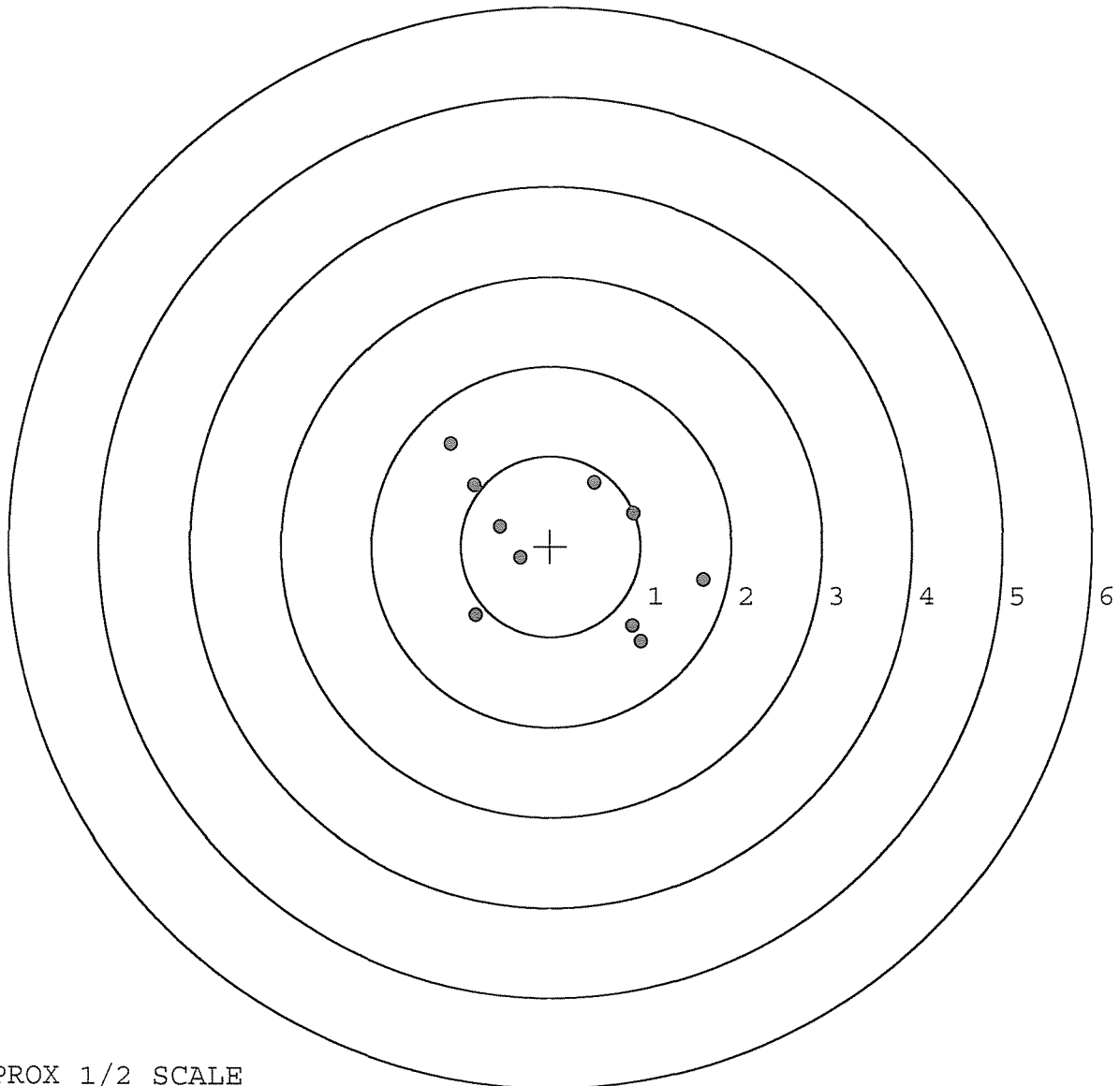
MEAN RADIUS: 1.114

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 4

in 3 IN DIAMETER: 8

POINT#	X	Y
1:	1.004	-1.058
2:	0.911	-0.886
3:	1.688	-0.368
4:	0.920	0.364
5:	0.486	0.701
6:	-0.338	-0.133
7:	-0.567	0.214
8:	-0.839	-0.762
9:	-0.849	0.674
10:	-1.118	1.134



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6587577. __0

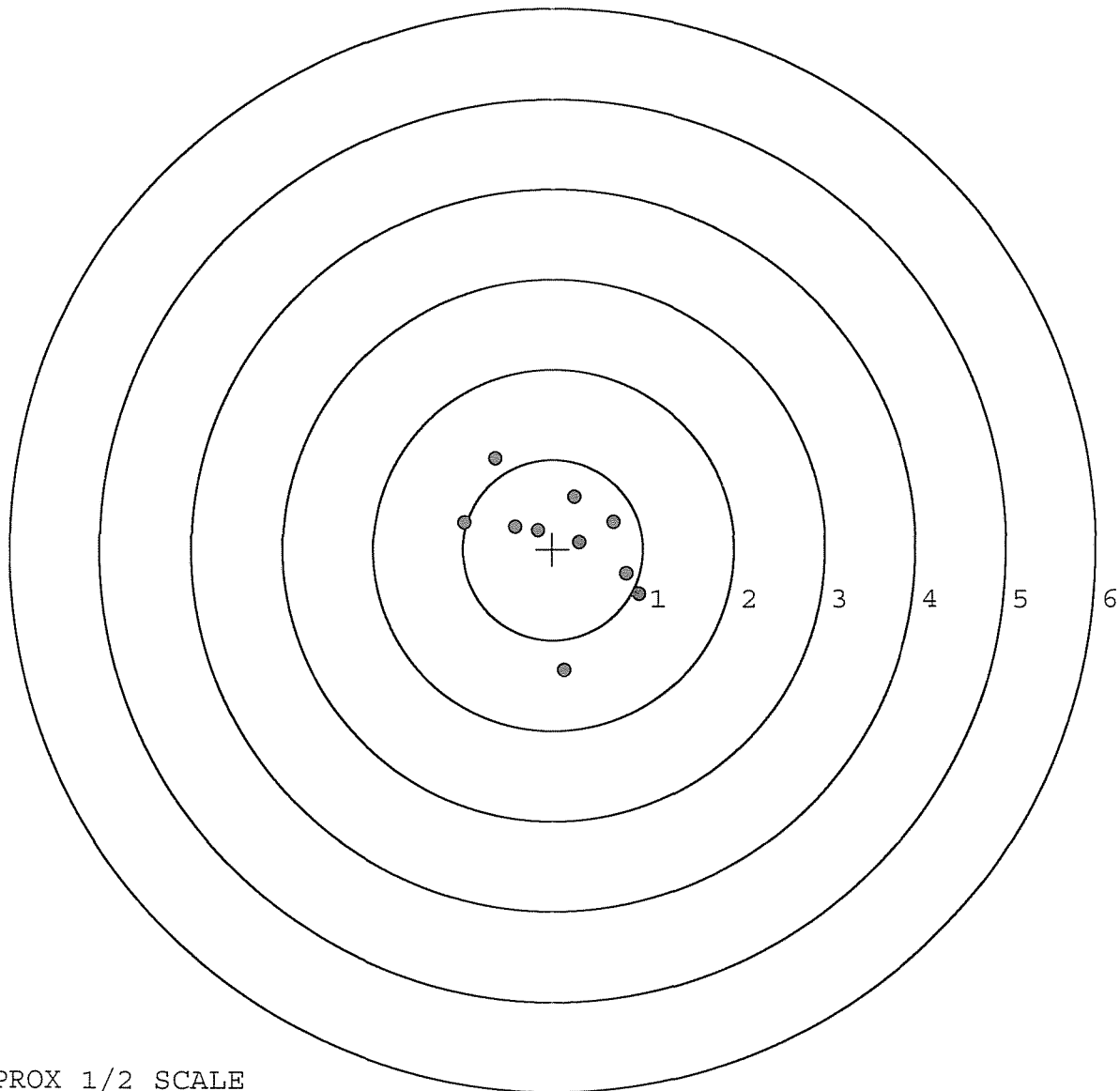
TARGET NUMBER: 3

FILE DATE: 03/08/2005

FILE TIME: 07:46

X CENTROID: 0.090
 Y CENTROID: 0.062
 POA TO CENTROID: 0.109
 HORZ SPREAD: 1.940
 VERT SPREAD: 2.348
 GROUP SPREAD: 2.471
 MIN RADIUS: 0.211
 MAX RADIUS: 1.399
 MEAN RADIUS: 0.776
 # IN 1 IN DIAMETER: 2
 # IN 2 IN DIAMETER: 6
 # in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.958	-0.501
2:	0.820	-0.274
3:	0.130	-1.337
4:	0.671	0.303
5:	0.300	0.079
6:	0.238	0.581
7:	-0.173	0.211
8:	-0.425	0.248
9:	-0.982	0.297
10:	-0.641	1.011



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6587577. __0

TARGET NUMBER: 4

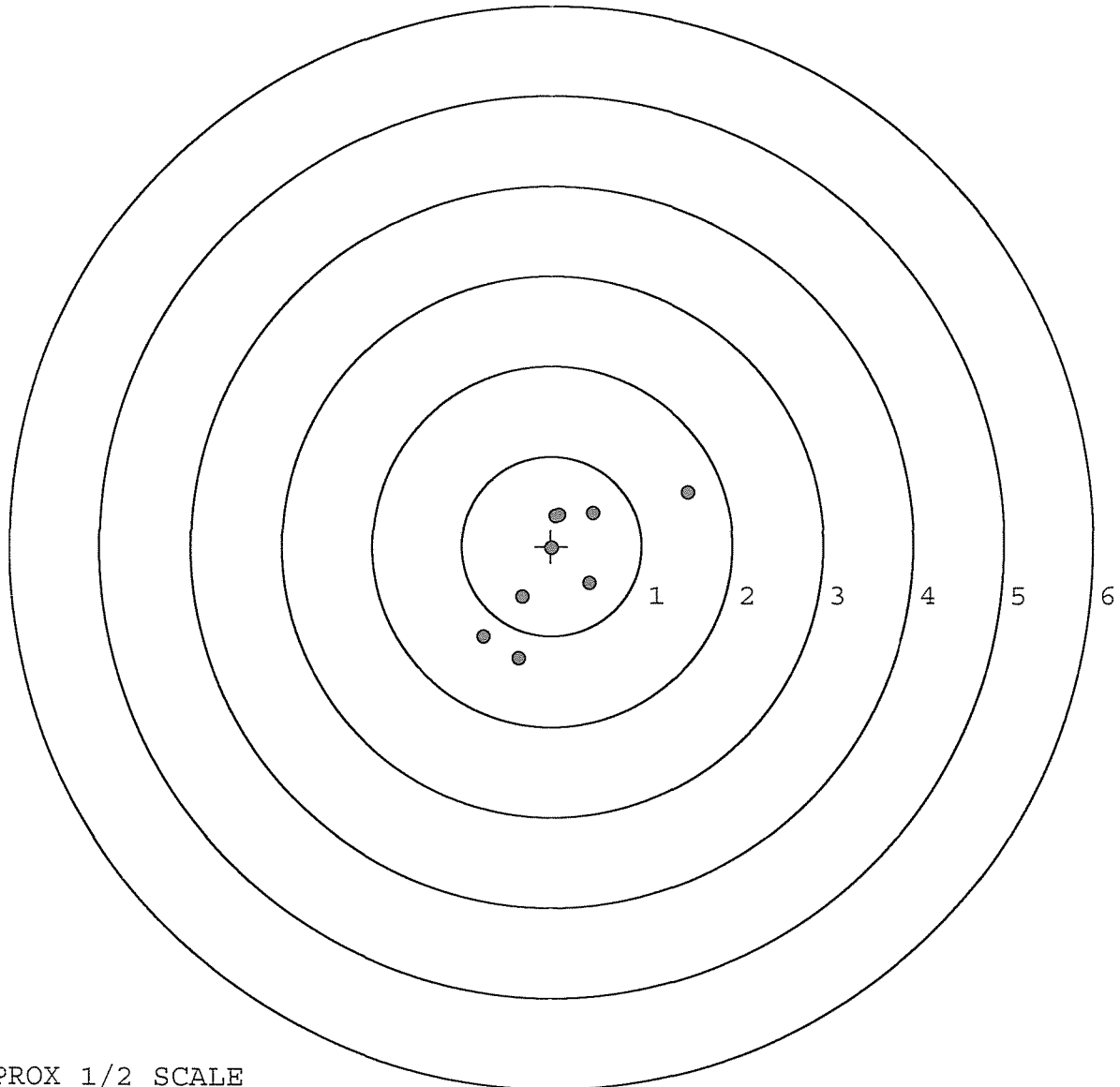
FILE DATE: 03/08/2005

FILE TIME: 07:46

X CENTROID: 0.107
 Y CENTROID: -0.164
 POA TO CENTROID: 0.196
 HORZ SPREAD: 2.262
 VERT SPREAD: 1.865
 GROUP SPREAD: 2.785
 MIN RADIUS: 0.175
 MAX RADIUS: 1.595
 MEAN RADIUS: 0.701

IN 1 IN DIAMETER: 3
 # IN 2 IN DIAMETER: 7
 # in 3 IN DIAMETER: 9

POINT#	X	Y
1:	0.006	-0.021
2:	0.009	-0.020
3:	-0.363	-1.259
4:	-0.758	-1.018
5:	-0.324	-0.572
6:	0.420	-0.419
7:	0.456	0.373
8:	0.080	0.353
9:	1.504	0.606
10:	0.043	0.335



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6587577. 0

TARGET NUMBER: 5

FILE DATE: 03/08/2005

FILE TIME: 07:46

X CENTROID: -0.229

Y CENTROID: -0.134

POA TO CENTROID: 0.265

HORZ SPREAD: 3.437

VERT SPREAD: 2.644

GROUP SPREAD: 3.578

MIN RADIUS: 0.317

MAX RADIUS: 2.533

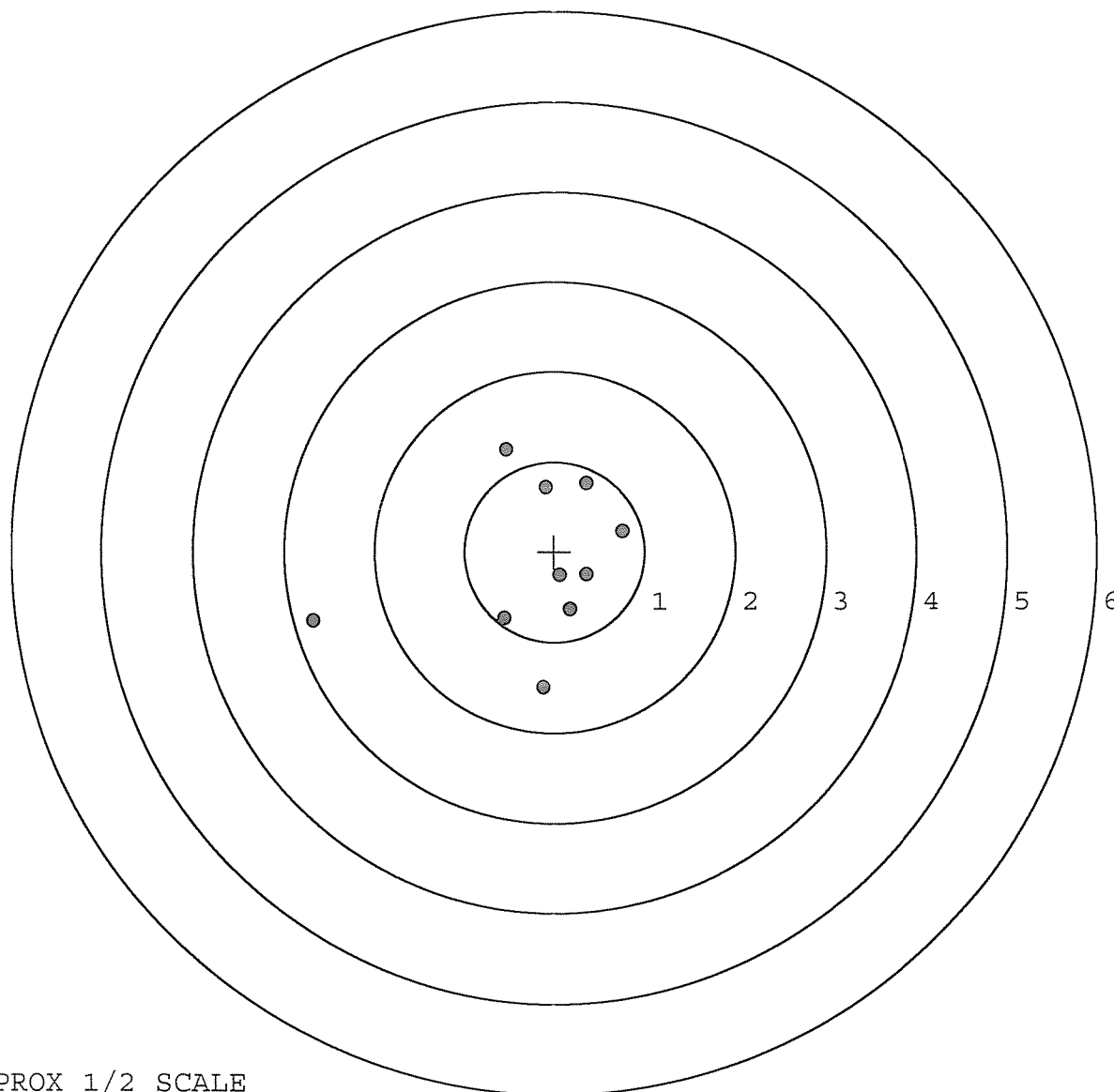
MEAN RADIUS: 1.045

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 5

in 3 IN DIAMETER: 9

POINT#	X	Y
1:	-0.122	-1.505
2:	-0.555	-0.744
3:	-2.681	-0.768
4:	0.756	0.228
5:	0.356	0.761
6:	-0.096	0.718
7:	-0.538	1.139
8:	0.061	-0.262
9:	0.355	-0.260
10:	0.174	-0.643



TARGET APPROX 1/2 SCALE

R & E NUMBER		92663	
SERIAL NUMBER		06587577	
LOG-IN DATE		2-8-05	
INSPECT AND VERIFY:			
OPERATION #	OPERATION NAME	DATE	INITIAL
550	DIS-ASSEMBLE GUN	2-11-05	RTZ
560 A	RE-BARREL	2-16-05	RTZ
B	DRILL AND TAP	2-17-05	TRW
575	ASSEMBLE	2-16-05	RTZ
600	PROOF	2-17-05	MAGNA-FLUX INSPECTED
605	CHECK HEADSPACE	2-17-05	FC
610	DIS-ASSEMBLE GUN	2-17-05	RTZ
612	MAGNAFLUX	2-18-05	CN
615	ROLLMARK CALIBER	2-18-05	LB
618	ROTO-BLAST	3-1-05	RTZ
620	APPLY COATINGS	3-5-05	RTZ
625 A	FINAL ASSEMBLY	3-9-05	FC
B	TRIGGER PULL TEST	3-9-05	FC
C	SAFETY "ON" FORCE	3-9-05	FC
D	SAFETY "OFF" FORCE	3-9-05	FC
E	FIRING PIN INDENT	3-9-05	FC
640	TARGET	3-8-05	TRW
655	FINAL INSPECT	3-9-05	FC
660	PACK	3-11-05	RTZ
SHIP DATE			
QAR INSPECTION DATE			

Remington
MODEL 700™ M24

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

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

SERIAL NO.
C6587577

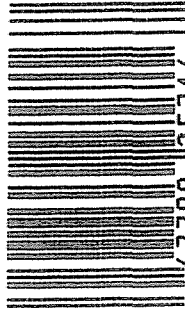
ORDER NO.
5716

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



5716 C6587577

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C 6587577

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		10/22/90	KH
600	Proof		10/22/90	KH
607	Check Headspace		10/22/90	KH
610	Dis-assemble Gun		10/22/90	KH
612	Magnaflux Barrel Action		10/24/90	KH
	Magnaflux Bolt		10/24/90	KH
615	Rollmark Caliber		10/24/90	DL
617	Drill and Tap Sight Holes		10/25/90	KH
618	Polish Barrel <i>RB</i>		10/26/90	WH
620	Apply Coatings (Barrel Action)		11-7-90	TS
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		11/8/90	KH
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		11/8/90	KH
	C) Inspect Ejector Hole for Chamfer		11/8/90	KH
	D) Oil Firing Pin Ass'y		11/8/90	KH
	E) Adjust Trigger Pull to Min Setting and Stake		11-10-90	DL

BARBER - M24 0023050		READINGS			DATE	INIT		
op. #	OP. NAME							
625 cont.	F) Safety On Force	4.50	4.50	4.25	11-9-90	K		
	G) Safety Off Force	2.50	2.50	2.50	11-9-90	K		
	H) Trigger Pull Test & Retainability				11-10-90	JL		
	I) Firing Pin Indent	0.22	0.23	0.22	11-9-90	K		
	J) Assemble Stock				11/10/90	KS		
	K) Assemble Swivel Studs				11-20-90	JS		
	L) Attach Front and Rear Sight Assemblies				11/19/90	KS		
	M) Iron Sight Alignment				11/10/90	KS		
	N) Detach Front & Rear Sights & place in numbered container				11/14/90	KS		
	O) Attach Scope to Rifle				11/10/90	KS		
	P) Detach & Attach Scope 20 Times				11/10/90	KS		
640	Gallery Target & Test				11/13/90	AF		
	A) Time				"	AF		
	B) Malfunctions				"	AF		
	C) Pierced Primers				"	AF		
	D) Optical Clarity of Scope				"	AF		
645	Inspect for Live Ammo				11/13/90	AF		
655	Final Inspection							
	A) Headspace				11-20-90	JS		
	B) Trigger Pull	264	285	255	287	283	11-20-90	JS
	C) Function						11-20-90	JS
660	Pack						12-17-90	DL

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C6587577

DATE 11-10-90

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.28	2.26	2.18	264	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.48	2.44	2.42	285	
PULL #3	2.37	2.43	2.48	255	
PULL #4	2.19	2.47	2.60	287	
PULL #5	2.21	2.36	2.48	283	
TOTAL	11.53	11.96	12.06		
AVG.	2.306	2.392	2.412		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.18	3.41		
PULL #2	3.29	3.35		
PULL #3	3.34	3.23		
PULL #4	3.30	3.26		
PULL #5	3.31	3.33		
TOTAL	16.42	16.58		
AVG.	3.284	3.316		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.34	4.36		4.43
PULL #2	4.38	4.15		4.16
PULL #3	4.30	4.16		4.23
PULL #4	4.36	4.24		4.17
PULL #5	4.38	4.34		4.21
TOTAL	21.76	21.25		21.30
AVG.	4.352	4.25		4.26

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06587577
14 Nov 1990

CENTROIDAL DISTANCES

0 TO	1	.211729
1 TO	2	.0529528
1 TO	3	.145908
1 TO	4	.393154
1 TO	5	.204365

<----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .033
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.146
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .149683

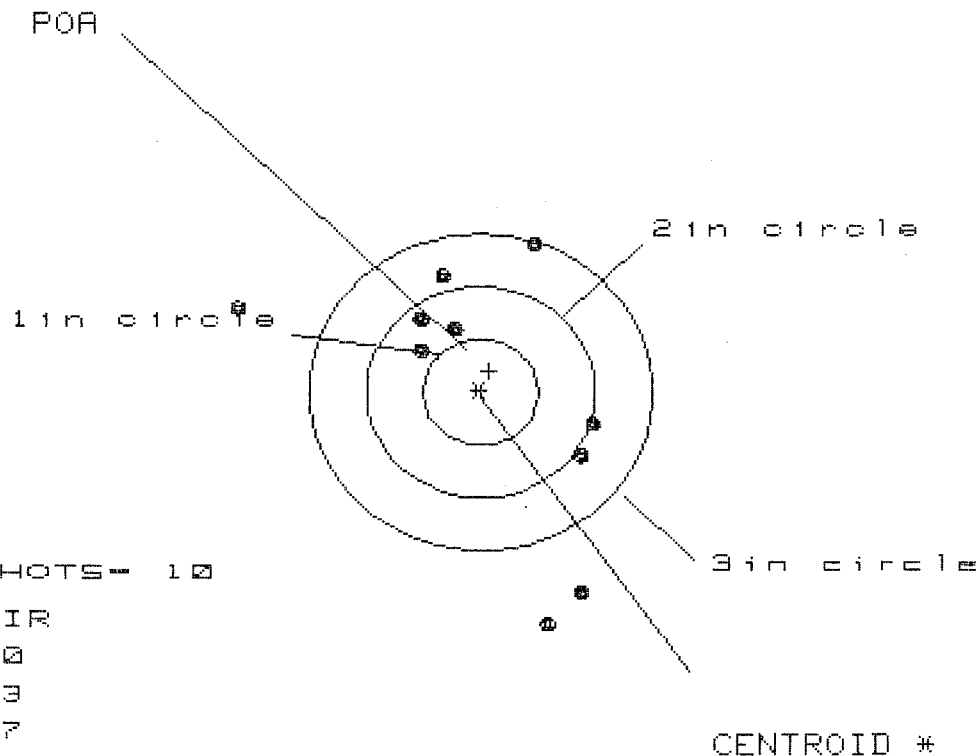
THE AMR FOR THIS RIFLE IS: 1.153

14 May 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6587577

CENTERFIRE PATTERNS

1



OF SHOTS - 10

IN CIR

1 in = 0

2 in = 3

3 in = 7

HS = 3.141

VS = 3.563

GS = 4.034

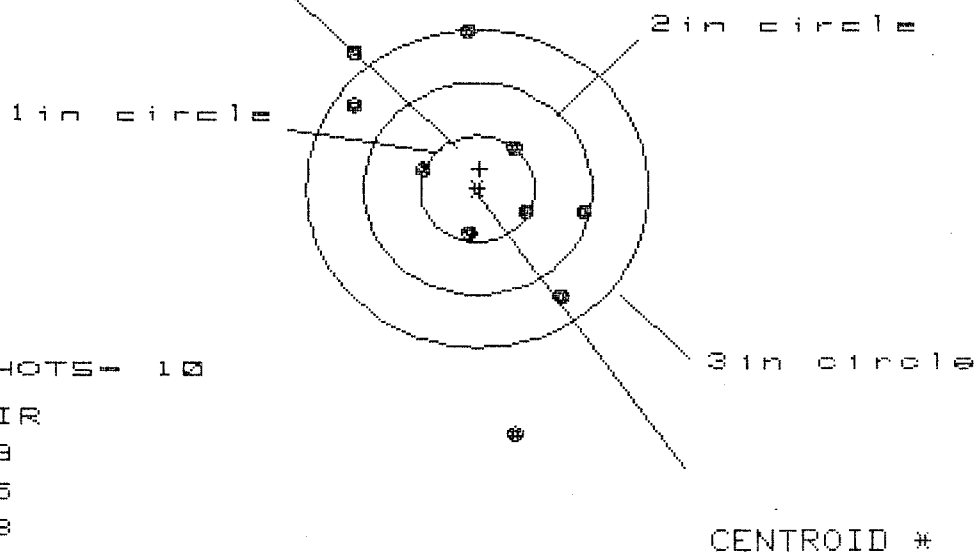
PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.021	.786	.826
MINIMUM X	:	-2.120	-.803	-.763
MAXIMUM Y	:	1.377	1.469	1.207
MINIMUM Y	:	-2.186	-2.094	-2.022
CENTROID X	:	-.075	.160	.120
CENTROID Y	:	-.198	-.290	-.028
POA TO CENTROID in.	:	.211	.331	.123
MIN RADIUS	:	.608	.795	.563
MEAN RADIUS	:	1.352	1.257	1.091
MAX RADIUS	:	2.276	2.120	2.130
HORIZONTAL SPREAD	:	3.141	1.589	1.589
VERTICAL SPREAD	:	3.563	3.563	3.229
EXTREME SPREAD	:	4.034	3.565	3.257
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		7	

14 Nov 1998

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CENTERFIRE PATTERNS # 2

POA



OF SHOTS - 10

IN CIR

1 in = 3

2 in = 5

3 in = 8

HS = 2.054

VS = 3.763

GS = 3.788

CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.946	.984	.859
MINIMUM X	:	-1.108	-1.070	-1.195
MAXIMUM Y	:	1.492	1.239	1.364
MINIMUM Y	:	-2.271	-1.252	-1.127
CENTROID X	:	-.023	-.061	.064
CENTROID Y	:	-.188	.065	-.060
POA TO CENTROID in.	:	.189	.089	.088
MIN RADIUS	:	.379	.372	.328
MEAN RADIUS	:	1.080	.942	.854
MAX RADIUS	:	2.297	1.476	1.375
HORIZONTAL SPREAD	:	2.054	2.054	2.054
VERTICAL SPREAD	:	3.763	2.491	2.491
EXTREME SPREAD	:	3.788	2.867	2.626
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

14 Nov 1998

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CENTERFIRE PATTERNS

3

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS= 10

IN CIR

1in = 1

2in = 4

3in = 8

HS= 3.347

VS= 2.789

GS= 3.376

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.382	1.163	.942
MINIMUM X	:	-1.965	-1.769	-.519
MAXIMUM Y	:	1.359	1.344	1.255
MINIMUM Y	:	-1.430	-1.445	-1.534
CENTROID X	:	.058	.277	.498
CENTROID Y	:	-.138	-.123	-.034
POA TO CENTROID in.	:	.150	.303	.499
MIN RADIUS	:	.434	.307	.382
MEAN RADIUS	:	1.200	1.067	.930
MAX RADIUS	:	1.970	1.906	1.573
HORIZONTAL SPREAD	:	3.347	2.932	1.461
VERTICAL SPREAD	:	2.789	2.789	2.789
EXTREME SPREAD	:	3.376	3.098	2.794
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	

14 Nov 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C8587577

CENTERFIRE PATTERNS # 4

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS- 10

IN CIR

1 in = 2

2 in = 5

3 in = 9

HS= 1.888

VS= 2.392

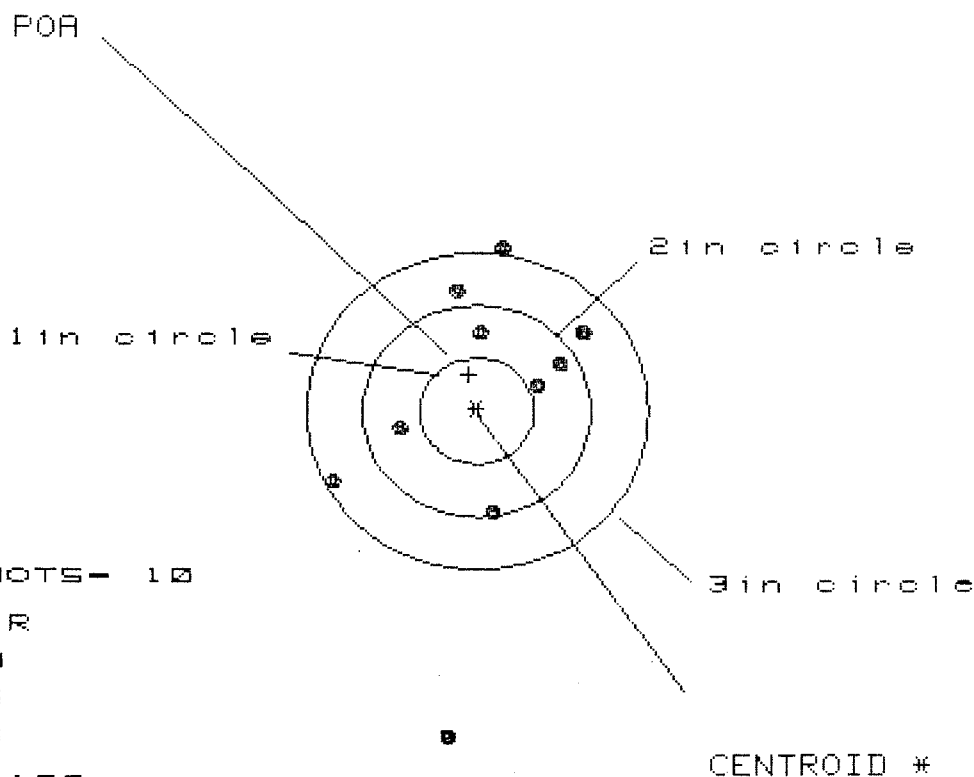
GS= 2.579

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.068	1.134	1.093
MINIMUM X	:	-.820	-.754	-.794
MAXIMUM Y	:	1.005	.851	.670
MINIMUM Y	:	-1.387	-1.446	-.915
CENTROID X	:	.134	.068	.108
CENTROID Y	:	.135	.289	.470
POA TO CENTROID in.	:	.190	.297	.482
MIN RADIUS	:	.295	.303	.119
MEAN RADIUS	:	.903	.801	.666
MAX RADIUS	:	1.506	1.481	1.426
HORIZONTAL SPREAD	:	1.888	1.888	1.888
VERTICAL SPREAD	:	2.392	2.297	1.585
EXTREME SPREAD	:	2.579	2.297	2.293
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

14 Nov 1998

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 0

2in = 5

3in = 8

HS= 2.162

VS= 4.673

GS= 4.698

CENTROID *

PATTERN #	:	5	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.886	.853	.872
MINIMUM X	:	-1.276	-1.309	-1.290
MAXIMUM Y	:	1.567	1.222	.969
MINIMUM Y	:	-3.106	-1.289	-1.136
CENTROID X	:	.071	.104	.085
CENTROID Y	:	-.341	.004	-.149
POA TO CENTROID in.	:	.349	.105	.172
MIN RADIUS	:	.588	.377	.513
MEAN RADIUS	:	1.228	.935	.911
MAX RADIUS	:	3.120	1.532	1.530
HORIZONTAL SPREAD	:	2.162	2.162	2.162
VERTICAL SPREAD	:	4.673	2.511	2.105
EXTREME SPREAD	:	4.698	2.641	2.545
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

R 94-18717

90-0651

SHIP TO:

AL 36201-5025

COMMANDER (W52H094138H226)
DEFENSE DIST DEPOT ANNISTON
ATTN DDAA-UR BLDG 112
ANNISTON AL
36201-5021

36201-5025

ACCOUNT NUMBER	ACCOUNT NUMBER N/C	WRITE ☐	PROM. DATE	ESTIMATED	VIA
----------------	--------------------	--------------------------------	------------	-----------	-----

UP3

TOTAL

MAIN FAULT

REPAIRMAN	PROOF	CLEAN	TEST ✓	TARGET	PATTERN
GALLERY TESTER BB	DATE	DATE	DATE 12-9-95	DATE	DATE

RD6925 REV. 1/94

BARRER - M24 M3400023103

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6587577DATE 10-28-95TESTER DA

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#	COMMENTS
PULL #1	2.51	2.48	2.41	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.52	2.40	2.47	
PULL #3	2.58	2.40	2.46	
PULL #4	2.59	2.46	2.41	
PULL #5	2.64	2.37	2.47	
TOTAL	12.84	12.11	12.22	
AVG.	2.56	2.42	2.44	

	3.00# INITIAL	3.00# AFTER 20 CYCLES	COMMENTS
PULL #1	3.06	2.97	
PULL #2	3.00	2.98	
PULL #3	3.02	3.01	
PULL #4	3.08	2.91	
PULL #5	3.07	3.03	
TOTAL	15.23	14.90	
AVG.	3.04	2.98	

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.15	4.00	4.20	
PULL #2	4.06	3.90	4.15	
PULL #3	4.07	3.94	4.15	
PULL #4	4.09	4.04	4.20	
PULL #5	4.07	4.02	4.28	
TOTAL	20.44	19.90	20.98	
AVG.	4.08	3.98	4.19	

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6587577

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

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			12/14	WB
	G) Safety Off Force	3	3	3			12/14	WB
	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							
	A) Time							
	B) Malfunctions							
	C) Pierced Primers							
	D) Optical Clarity of Scope							
645	Inspect for Live Ammo							
655	Final Inspection							
	A) Headspace							
	B) Trigger Pull	2.25	2.23	2.22	2.27	2.25	12/14	WB
	C) Function							
660	Pack							