

06523412

MODEL 700™ M24

Model SMS™

Action

Barrel Length

Capacity

Order No. 5716

\*Includes 1 in chamber.

*Remington*

| Repair Number: <b>RE00080679</b>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       | Serial: C6523412 Model M24 SWS Center Fire<br>Caliber: 7.62 NATO | Repairman:                                                                                                    | Status: Closed 5/6/2004 3:02:20 PM |                                                                                                                                                                                                                                                                                                                                                                                       |          |          |                  |                    |           |   |      |           |   |      |            |   |      |                   |   |
|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|------------------------------------------------------------------|---------------------------------------------------------------------------------------------------------------|------------------------------------|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------|----------|------------------|--------------------|-----------|---|------|-----------|---|------|------------|---|------|-------------------|---|
| <b>Address Information</b><br>Customer: <input type="radio"/> Received From: <input checked="" type="radio"/> Return To: <input type="radio"/> Received From: <input type="radio"/><br>Name: <b>A CO 3/3 SFG (A)</b> <b>A CO 3/3 SFG (A)</b><br>Address 1: <b>BLDG G1351 KUWAIT ST</b> <b>BLDG G1351 KUWAIT ST</b><br>Address 2: <input type="text"/> PO Box: <input type="text"/> <input type="text"/> PO Box: <input type="text"/><br>City: <b>FT BRAGG</b> <b>FT BRAGG</b><br>State: <b>NC</b> Zip Code: <b>28310</b> Country: <b>US</b> State: <b>NC</b> Zip Code: <b>28310</b> Country: <b>US</b><br>FFL: <input type="text"/> <input type="text"/> <input type="text"/> <input type="text"/> <input type="text"/> <input type="text"/> <input type="text"/> <input type="text"/> |                                                                  |                                                                                                               |                                    |                                                                                                                                                                                                                                                                                                                                                                                       |          |          |                  |                    |           |   |      |           |   |      |            |   |      |                   |   |
| <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                                                                                                                                                                                                                                                                                                                                                                    |          |          |                  |                    |           |   |      |           |   |      |            |   |      |                   |   |
| <b>Contact Information</b><br>Phone: <input type="text"/><br>Fax: <input type="text"/><br>Email: <input type="text"/><br>Comments: <input type="text"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                |                                                                  | <b>Received Condition</b><br>Good<br>Condition Notes: <input type="text"/><br>CSR Notes: <input type="text"/> |                                    | <b>Accessories Received</b><br><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>A017</td> <td>Scope Base</td> <td>1</td> </tr> <tr> <td>C000</td> <td>FRT AND REAR BASE</td> <td>1</td> </tr> </tbody> </table> | Code     | Desc     | Qty              | A007               | With Stud | 3 | A010 | Hard Case | 1 | A017 | Scope Base | 1 | C000 | FRT AND REAR BASE | 1 |
| Code                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   | Desc                                                             | Qty                                                                                                           |                                    |                                                                                                                                                                                                                                                                                                                                                                                       |          |          |                  |                    |           |   |      |           |   |      |            |   |      |                   |   |
| A007                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   | With Stud                                                        | 3                                                                                                             |                                    |                                                                                                                                                                                                                                                                                                                                                                                       |          |          |                  |                    |           |   |      |           |   |      |            |   |      |                   |   |
| A010                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   | Hard Case                                                        | 1                                                                                                             |                                    |                                                                                                                                                                                                                                                                                                                                                                                       |          |          |                  |                    |           |   |      |           |   |      |            |   |      |                   |   |
| A017                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   | Scope Base                                                       | 1                                                                                                             |                                    |                                                                                                                                                                                                                                                                                                                                                                                       |          |          |                  |                    |           |   |      |           |   |      |            |   |      |                   |   |
| C000                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   | FRT AND REAR BASE                                                | 1                                                                                                             |                                    |                                                                                                                                                                                                                                                                                                                                                                                       |          |          |                  |                    |           |   |      |           |   |      |            |   |      |                   |   |
| <input type="button" value="Repair Search"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |                                                                  | <input type="button" value="Refresh"/> <input type="button" value="Close"/>                                   |                                    |                                                                                                                                                                                                                                                                                                                                                                                       |          |          |                  |                    |           |   |      |           |   |      |            |   |      |                   |   |

magletj

5/6/2004

3:08 PM

CAPS

NUM

INS

SCPL



Serial Number: **C6523412**  
 Model: **M24 SWS**  
  
**RE00080679**

FINAL INSPECTION CHECKLIST M-24 REPAIRS  
CONTRACT #: DAAE-20-02-D-0127SERIAL # C 6523412INSPECTED BY: RTLDATE REC'D: 5-6-04DATE RET'D: 6-2-04

## ITEM

## BARREL ASSEMBLY

☒ BARREL  
☒ RECEIVER  
☒ FRONT SIGHT BASE  
☒ REAR SIGHT BASE  
☒ SCREWS  
☒ FINISH

## SCOPE ASSEMBLY

☐ SCOPE  
☐ SCOPE RINGS  
☐ MOUNTING SCREWS  
☐ MOUNTING BASE  
☐ SCREWS  
☐ FINISH  
☐ CLARITY

## ITEM

## STOCK ASSEMBLY

☒ STOCK  
☒ SLING AWIVEL STUDS  
☒ ADJUSTABLE  
☒ BUTT PLATE  
☒ LOCK NUTS  
☒ BARREL CLEARANCE  
☒ COLOR / FINISH

## SYSTEMS CASE

☐ SCOPE CASE  
☐ IRON SIGHTS  
☐ DEPLOYMENT KIT

## TRIGGER ASSEMBLY

☒ SAFETY OPERATION  
☒ RE-SET TO FACTORY SPECS

COMMENTS:

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6523412.\_\_\_0

FILE DATE AND TIME: 06/04/2004 06:14

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

|                                                             |        |
|-------------------------------------------------------------|--------|
| The Average X Centroid of the Five Target Set:              | 0.077  |
| The Average Y Centroid of the Five Target Set:              | -0.069 |
| The Average Point of Impact of the Five Target Set:         | 0.103  |
| The Average Mean Radius of the Five Target Set:             | 0.647  |
| The Distance from POA to Centroid Target #1:                | 0.181  |
| The Distance from Centroid Target #2 to Centroid Target #1: | 0.249  |
| The Distance from Centroid Target #3 to Centroid Target #1: | 0.281  |
| The Distance from Centroid Target #4 to Centroid Target #1: | 0.278  |
| The Distance from Centroid Target #5 to Centroid Target #1: | 0.314  |

SERIAL NUMBER: C6523412. 0

TARGET NUMBER: 1

FILE DATE: 06/04/2004

FILE TIME: 06:14

X CENTROID: 0.144

Y CENTROID: 0.109

POA TO CENTROID: 0.181

HORZ SPREAD: 2.157

VERT SPREAD: 1.806

GROUP SPREAD: 2.168

MIN RADIUS: 0.227

MAX RADIUS: 1.249

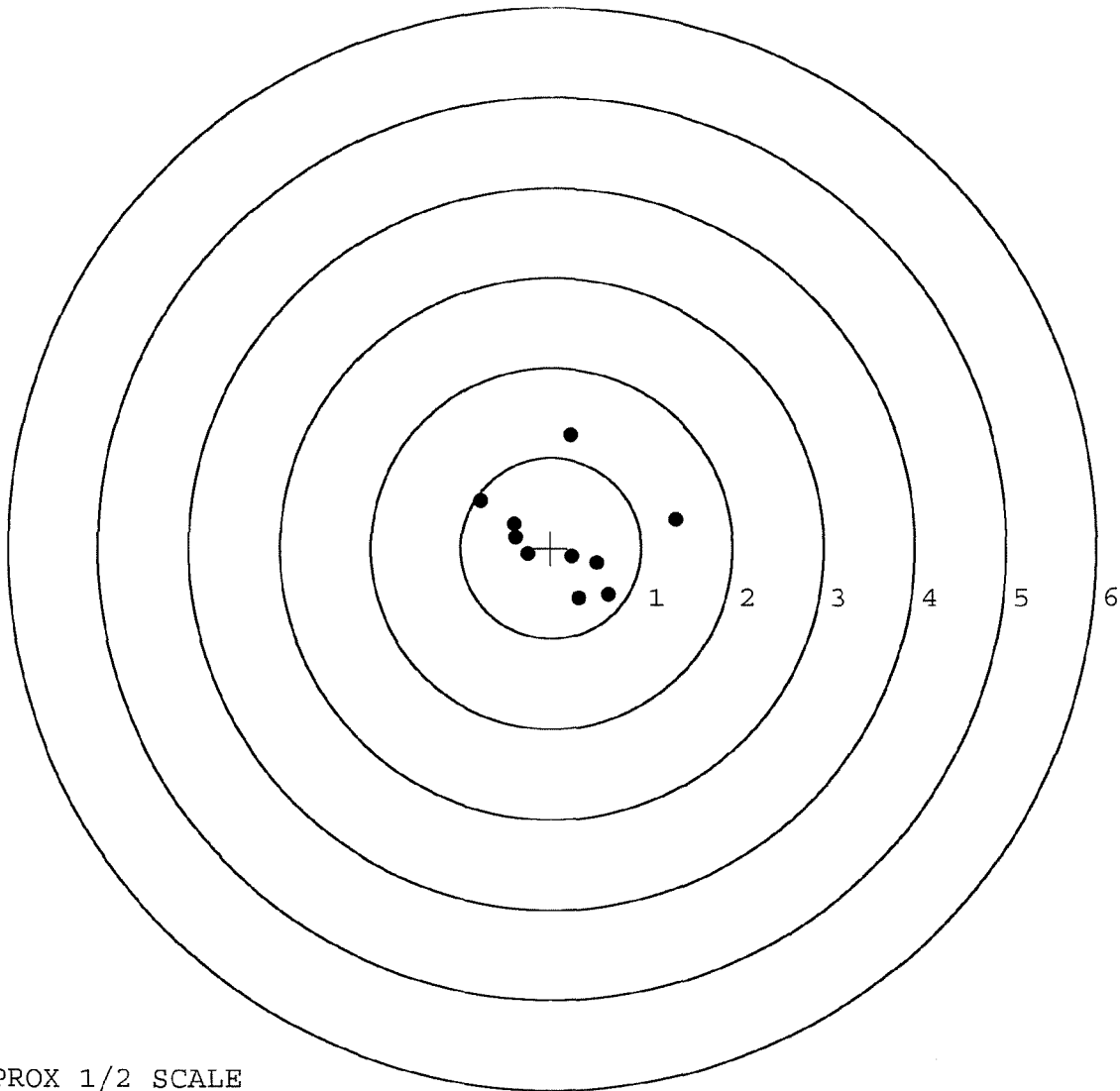
MEAN RADIUS: 0.713

# IN 1 IN DIAMETER: 3

# IN 2 IN DIAMETER: 7

# in 3 IN DIAMETER: 10

| POINT# | X      | Y      |
|--------|--------|--------|
| 1:     | 0.221  | 1.252  |
| 2:     | 1.375  | 0.319  |
| 3:     | 0.634  | -0.515 |
| 4:     | 0.309  | -0.554 |
| 5:     | 0.511  | -0.161 |
| 6:     | 0.236  | -0.098 |
| 7:     | -0.255 | -0.073 |
| 8:     | -0.409 | 0.268  |
| 9:     | -0.782 | 0.533  |
| 10:    | -0.399 | 0.123  |

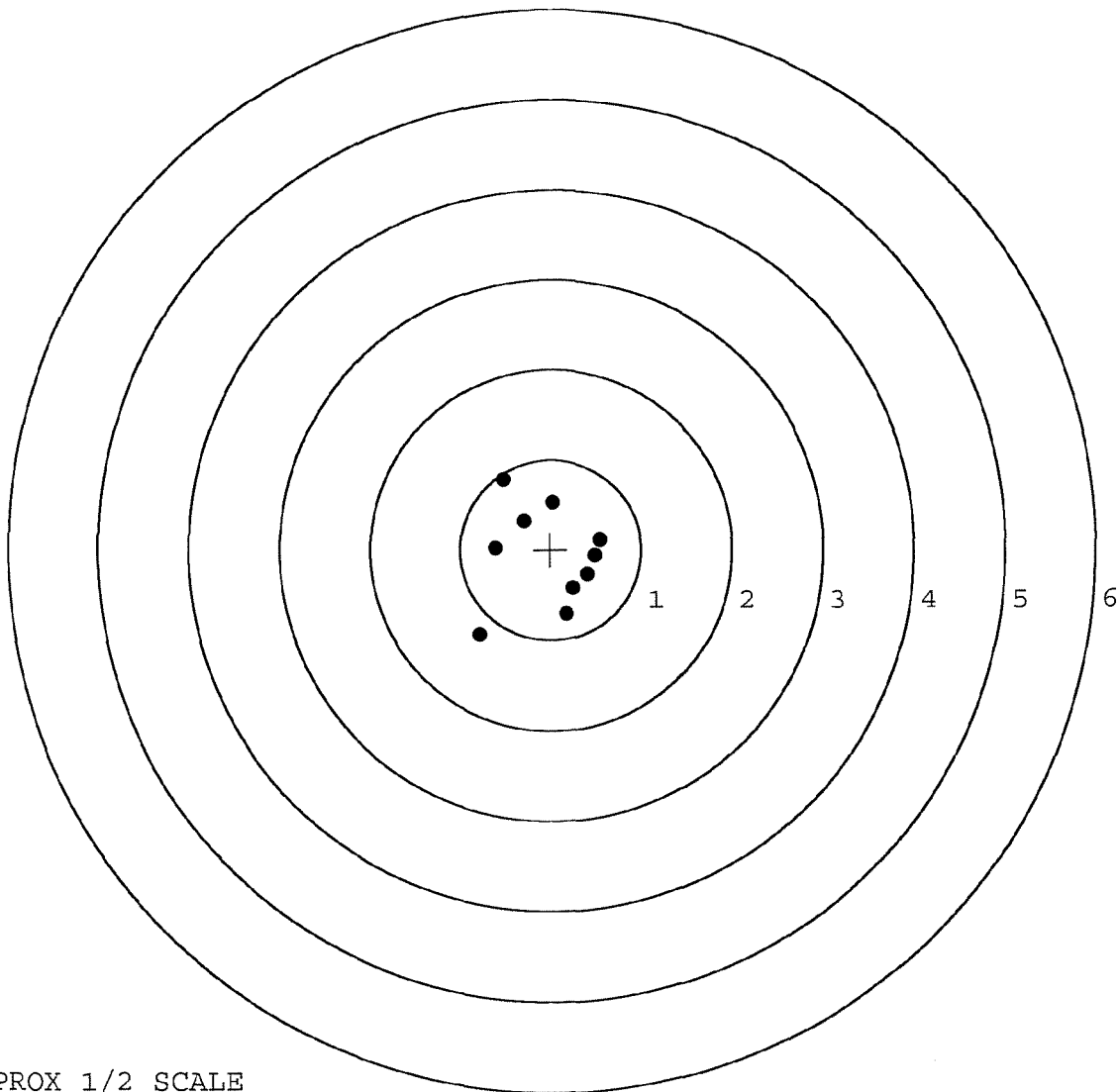


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6523412. \_\_0  
 TARGET NUMBER: 2  
 FILE DATE: 06/04/2004  
 FILE TIME: 06:14

X CENTROID: -0.032  
 Y CENTROID: -0.067  
 POA TO CENTROID: 0.074  
 HORZ SPREAD: 1.343  
 VERT SPREAD: 1.726  
 GROUP SPREAD: 1.747  
 MIN RADIUS: 0.463  
 MAX RADIUS: 1.161  
 MEAN RADIUS: 0.655  
 # IN 1 IN DIAMETER: 3  
 # IN 2 IN DIAMETER: 9  
 # in 3 IN DIAMETER: 10

| POINT# | X      | Y      |
|--------|--------|--------|
| 1:     | -0.790 | -0.946 |
| 2:     | -0.522 | 0.780  |
| 3:     | -0.613 | 0.020  |
| 4:     | -0.298 | 0.316  |
| 5:     | 0.020  | 0.521  |
| 6:     | 0.177  | -0.718 |
| 7:     | 0.253  | -0.432 |
| 8:     | 0.553  | 0.117  |
| 9:     | 0.497  | -0.062 |
| 10:    | 0.407  | -0.267 |



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6523412. 0

TARGET NUMBER: 3

FILE DATE: 06/04/2004

FILE TIME: 06:14

X CENTROID: -0.034

Y CENTROID: -0.108

POA TO CENTROID: 0.113

HORZ SPREAD: 1.916

VERT SPREAD: 1.310

GROUP SPREAD: 1.943

MIN RADIUS: 0.018

MAX RADIUS: 1.010

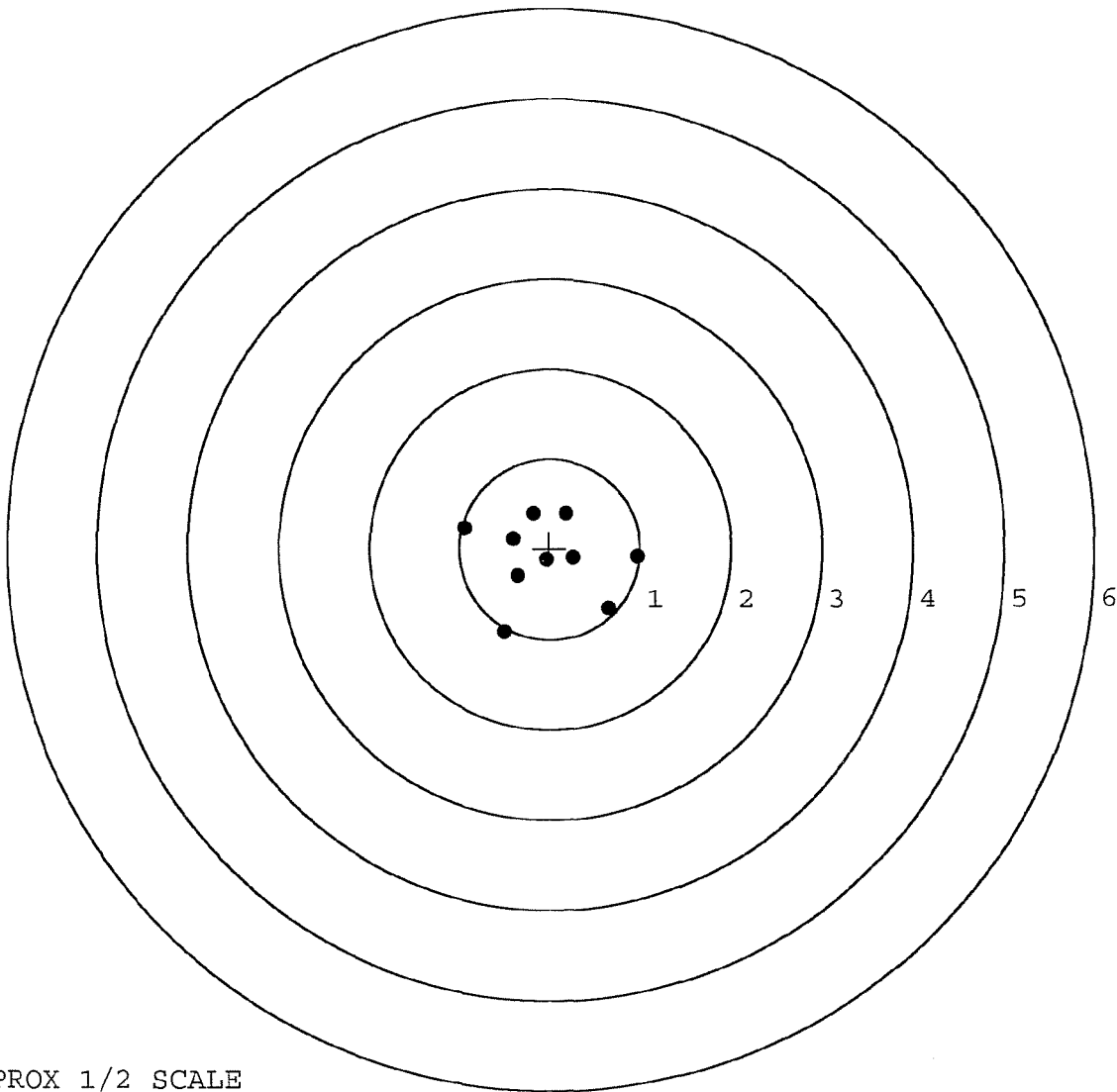
MEAN RADIUS: 0.598

# IN 1 IN DIAMETER: 4

# IN 2 IN DIAMETER: 9

# in 3 IN DIAMETER: 10

| POINT# | X      | Y      |
|--------|--------|--------|
| 1:     | 0.976  | -0.092 |
| 2:     | 0.653  | -0.659 |
| 3:     | -0.508 | -0.920 |
| 4:     | -0.940 | 0.233  |
| 5:     | -0.180 | 0.390  |
| 6:     | -0.401 | 0.109  |
| 7:     | 0.185  | 0.389  |
| 8:     | -0.359 | -0.304 |
| 9:     | -0.034 | -0.126 |
| 10:    | 0.265  | -0.098 |



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6523412. \_\_0

TARGET NUMBER: 4

FILE DATE: 06/04/2004

FILE TIME: 06:14

X CENTROID: 0.312

Y CENTROID: -0.112

POA TO CENTROID: 0.332

HORZ SPREAD: 2.363

VERT SPREAD: 1.354

GROUP SPREAD: 2.366

MIN RADIUS: 0.307

MAX RADIUS: 1.342

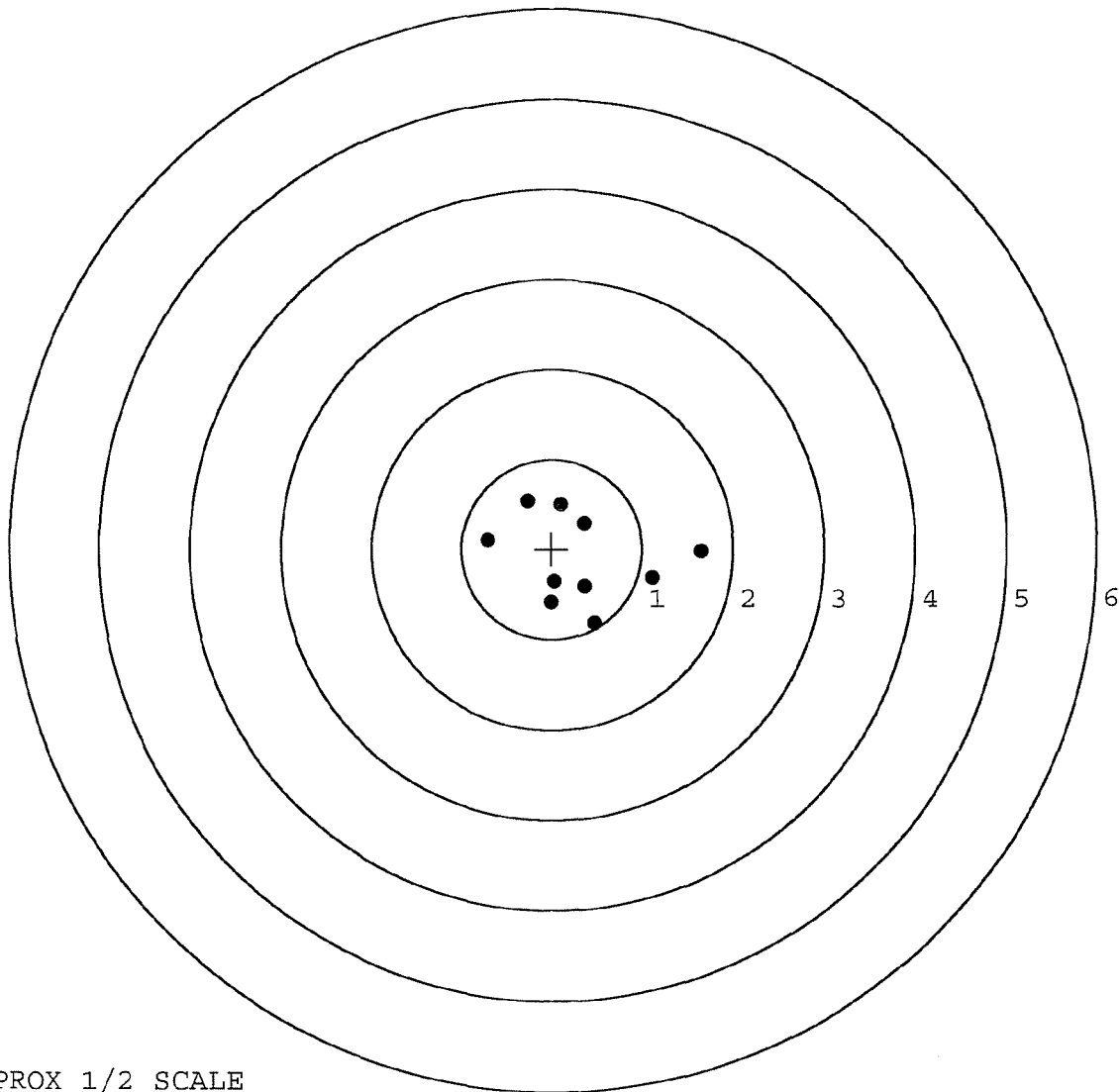
MEAN RADIUS: 0.713

# IN 1 IN DIAMETER: 3

# IN 2 IN DIAMETER: 8

# in 3 IN DIAMETER: 10

| POINT# | X      | Y      |
|--------|--------|--------|
| 1:     | 1.652  | -0.026 |
| 2:     | 1.118  | -0.321 |
| 3:     | 0.474  | -0.820 |
| 4:     | 0.371  | -0.414 |
| 5:     | -0.013 | -0.598 |
| 6:     | 0.033  | -0.364 |
| 7:     | -0.711 | 0.101  |
| 8:     | -0.268 | 0.534  |
| 9:     | 0.105  | 0.498  |
| 10:    | 0.362  | 0.287  |



TARGET APPROX 1/2 SCALE

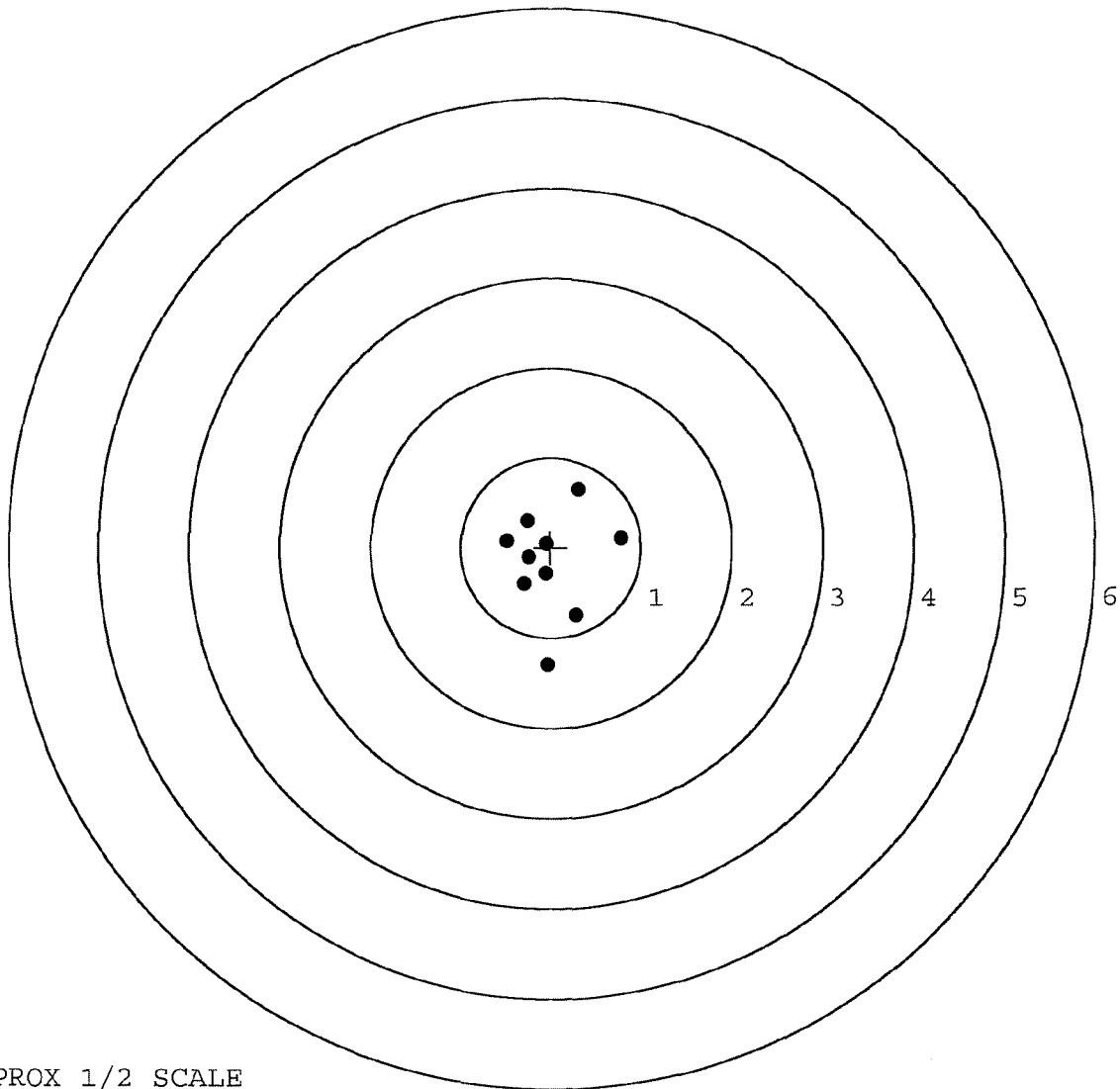
SERIAL NUMBER: C6523412. 0

TARGET NUMBER: 5

FILE DATE: 06/04/2004

FILE TIME: 06:14

|                     | POINT# | X      | Y      |
|---------------------|--------|--------|--------|
|                     | 1:     | -0.039 | -1.305 |
|                     | 2:     | 0.286  | -0.751 |
|                     | 3:     | 0.783  | 0.113  |
|                     | 4:     | 0.308  | 0.653  |
| X CENTROID:         | 5:     | -0.265 | 0.300  |
| Y CENTROID:         | 6:     | -0.485 | 0.076  |
| POA TO CENTROID:    | 7:     | -0.049 | 0.046  |
| HORZ SPREAD:        | 8:     | -0.300 | -0.401 |
| VERT SPREAD:        | 9:     | -0.056 | -0.291 |
| GROUP SPREAD:       | 10:    | -0.244 | -0.107 |
| MIN RADIUS:         |        | 0.134  |        |
| MAX RADIUS:         |        | 1.139  |        |
| MEAN RADIUS:        |        | 0.555  |        |
| # IN 1 IN DIAMETER: |        | 4      |        |
| # IN 2 IN DIAMETER: |        | 9      |        |
| # in 3 IN DIAMETER: |        | 10     |        |



TARGET APPROX 1/2 SCALE

|                     |                    |           |         |
|---------------------|--------------------|-----------|---------|
| R & E NUMBER        | 80679              |           |         |
| SERIAL NUMBER       | C6523412           |           |         |
| LOG-IN DATE         | 5-6-04             |           |         |
| INSPECT AND VERIFY: |                    |           |         |
| OPERATION #         | OPERATION NAME     | DATE      | INITIAL |
| 550                 | DIS-ASSEMBLE GUN   | 5-10-04   | RTL     |
| 560 A               | RE-BARREL          | 5-14-04   | RTL     |
| B                   | DRILL AND TAP      | 5-20-04   | TRW     |
| 575                 | ASSEMBLE           | 5-14-04   | RTL     |
| 600                 | PROOF              | 5-18-04   | AC      |
| 605                 | CHECK HEADSPACE    | 5-18-04   | AC      |
| 610                 | DIS-ASSEMBLE GUN   | 5-18-04   | RTL     |
| 612                 | MAGNAFLUX RATOR    |           |         |
| 615                 | ROLLMARK CALIBER   | 5/28/04   | AB      |
| 618                 | ROTO-BLAST         | 5/24/04   | DG      |
| 620                 | APPLY COATINGS     | 6-1       | TA      |
| 625 A               | FINAL ASSEMBLY     | 6-3-04    | RTL     |
| B                   | TRIGGER PULL TEST  |           |         |
| C                   | SAFETY "ON" FORCE  |           |         |
| D                   | SAFETY "OFF" FORCE |           |         |
| E                   | FIRING PIN INDENT  |           |         |
| 640                 | TARGET             | 6/3/04    | AC      |
| 655                 | FINAL INSPECT      | 6-7-04    | RTL     |
| 660                 | PACK               | 6-8-04    | TA      |
|                     |                    | SHIP DATE |         |
| QAR INSPECTION DATE |                    |           |         |

**GFM**

CONTRACT # DAAA21-87-C-0086

Repair

GUN SERIAL # C6523412

| OP. #        | OP. NAME                                                       | READINGS | DATE    | INIT |
|--------------|----------------------------------------------------------------|----------|---------|------|
| 575 &<br>580 | Assemble Action<br>and Stock                                   |          |         |      |
| 600          | Proof                                                          |          |         |      |
| 607          | Check Headspace                                                |          |         |      |
| 610          | Dis-assemble Gun                                               |          |         |      |
| 612          | Magnaflux Barrel<br>Action                                     |          |         |      |
|              | Magnaflux Bolt                                                 |          |         |      |
| 615          | Rollmark Caliber                                               |          |         |      |
| 617          | Drill and Tap Sight Holes                                      |          |         |      |
| 618          | Polish Barrel                                                  |          |         |      |
| 620          | Apply Coatings<br>(Barrel Action)                              |          |         |      |
|              | Apply Coating (Bolt)                                           |          |         |      |
| 625          | Final Assembly<br>A) Clean inside of<br>Bolt Assembly          |          | 2/15/93 | RW   |
|              | B) Inspect Rear Firing<br>Pin Hole for Chamfer<br>in Bolt Head |          | 2/15/93 | RW   |
|              | C) Inspect Ejector Hole<br>for Chamfer                         |          | 2/15/93 | RW   |
|              | D) Oil Firing Pin Ass'y                                        |          | 2/15/93 | RW   |
|              | E) Adjust Trigger Pull to<br>Min Setting and Stake             |          | 2/15/93 | RW   |

| op. #        | BARBER - M24 0027625<br>OP. NAME                                  | READINGS |      |      |      |      | DATE    | INIT |
|--------------|-------------------------------------------------------------------|----------|------|------|------|------|---------|------|
| 625<br>cont. | F) Safety On Force                                                | 4        | 4    | 4    |      |      | 2/15/93 | RW   |
|              | G) Safety Off Force                                               | 3        | 3    | 3    |      |      | 2/15/93 | RW   |
|              | H) Trigger Pull Test &<br>Retainability                           |          |      |      |      |      | 2/15/93 | RW   |
|              | I) Firing Pin Indent                                              |          |      |      |      |      |         |      |
|              | J) Assemble Stock                                                 |          |      |      |      |      |         |      |
|              | K) Assemble Swivel Studs                                          |          |      |      |      |      |         |      |
|              | L) Attach Front and Rear<br>Sight Assemblies                      |          |      |      |      |      |         |      |
|              | M) Iron Sight Alignment                                           |          |      |      |      |      |         |      |
|              | N) Detach Front & Rear<br>Sights & place in<br>numbered container |          |      |      |      |      |         |      |
|              | O) Attach Scope to Rifle                                          |          |      |      |      |      | 2/15/93 | RW   |
|              | P) Detach & Attach Scope<br>20 Times                              |          |      |      |      |      |         |      |
| 640          | Gallery Target & Test                                             |          |      |      |      |      | 2/26/93 | RW   |
|              | A) Time                                                           |          |      |      |      |      |         |      |
|              | B) Malfunctions                                                   |          |      |      |      |      |         |      |
|              | C) Pierced Primers                                                |          |      |      |      |      |         |      |
|              | D) Optical Clarity of Scope                                       |          |      |      |      |      |         |      |
| 645          | Inspect for Live Ammo                                             |          |      |      |      |      | 3/5/93  | RW   |
| 655          | Final Inspection                                                  |          |      |      |      |      |         |      |
|              | A) Headspace                                                      |          |      |      |      |      | 3/4/93  | RW   |
|              | B) Trigger Pull                                                   | 2.62     | 2.56 | 2.60 | 2.60 | 2.57 | 3/4/93  | RW   |
|              | C) Function                                                       |          |      |      |      |      | 3/4/93  | RW   |
| 660          | Pack                                                              |          |      |      |      |      |         |      |

SWS TRIGGER PULL TEST

New Trigger Assy.

AVERAGE PULL FORCE BETWEEN  
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6523412DATE 2/15/93TESTER RW

|         | 2.50#<br>INITIAL | 2.50# AFTER<br>50 CYCLES | FINAL TEST &<br>TO RESET 2.50# | COMMENTS                                                               |
|---------|------------------|--------------------------|--------------------------------|------------------------------------------------------------------------|
| PULL #1 | 2.45             | 2.48                     | 2.48                           | MIN. SETTING,<br>NO AVG. OF 5<br>READINGS ACCEPT-<br>ABLE LESS THAN 2# |
| PULL #2 | 2.37             | 2.46                     | 2.61                           |                                                                        |
| PULL #3 | 2.37             | 2.48                     | 2.64                           |                                                                        |
| PULL #4 | 2.41             | 2.46                     | 2.66                           |                                                                        |
| PULL #5 | 2.43             | 2.25                     | 2.60                           |                                                                        |
| TOTAL   | 12.03            | 12.13                    | 12.99                          |                                                                        |
| AVG.    | 2.41             | 2.43                     | 2.60                           |                                                                        |

|         | 3.00#<br>INITIAL | 3.00# AFTER<br>20 CYCLES | COMMENTS |
|---------|------------------|--------------------------|----------|
| PULL #1 | 3.19             | 3.22                     |          |
| PULL #2 | 3.17             | 3.14                     |          |
| PULL #3 | 3.20             | 3.15                     |          |
| PULL #4 | 3.17             | 3.14                     |          |
| PULL #5 | 3.18             | 3.14                     |          |
| TOTAL   | 15.91            | 15.79                    |          |
| AVG.    | 3.18             | 3.16                     |          |

|         | 4.00#<br>INITIAL | 4.00# AFTER<br>20 CYCLES | MAX SETTING<br>GREATER THAN 4# | RESET TO 4# FOR<br>TARGET & ACCURACY |
|---------|------------------|--------------------------|--------------------------------|--------------------------------------|
| PULL #1 | 4.08             | 4.06                     |                                | 4.16                                 |
| PULL #2 | 4.02             | 4.08                     |                                | 4.20                                 |
| PULL #3 | 4.06             | 4.00                     |                                | 4.20                                 |
| PULL #4 | 4.06             | 4.07                     |                                | 4.23                                 |
| PULL #5 | 4.07             | 4.08                     |                                | 4.21                                 |
| TOTAL   | 20.29            | 20.29                    |                                | 21.00                                |
| AVG.    | 4.06             | 4.06                     |                                | 4.20                                 |



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

**MODEL 700™ M24**

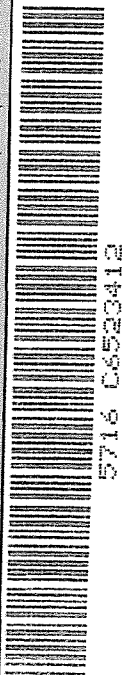
**DUPONT**  
REG. U.S. PAT. & TM. OFF.

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

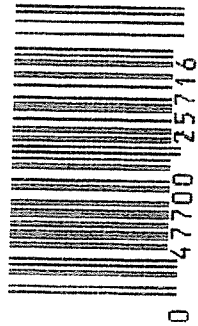
**SERIAL NO.**  
 C6523412

**ORDER NO.**  
 5716

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



UPC



| op. #      | OP. NAME                                                    | READINGS |       |       |     |     | DATE     | INIT |
|------------|-------------------------------------------------------------|----------|-------|-------|-----|-----|----------|------|
| 635<br>nt. | F) Safety On Force                                          | 4 1/2    | 4 1/2 | 4 1/2 |     |     | 10/10/90 | WB   |
|            | G) Safety Off Force                                         | 3        | 3     | 3     |     |     | 10/10/90 | WB   |
|            | H) Trigger Pull Test & Retainability                        |          |       |       |     |     | 10/10/90 | WB   |
|            | I) Firing Pin Indent                                        | .024     | .024  | .024  |     |     | 10/10/90 | WB   |
|            | J) Assemble Stock                                           |          |       |       |     |     | 10/10/90 | RW   |
|            | K) Assemble Swivel Studs                                    |          |       |       |     |     | 20/10/90 | YS   |
|            | L) Attach Front and Rear Sight Assemblies                   |          |       |       |     |     | 10/10/90 | RW   |
|            | M) Iron Sight Alignment                                     |          |       |       |     |     | 10/10/90 | RW   |
|            | N) Detach Front & Rear Sights & place in numbered container |          |       |       |     |     | 10/10/90 | RW   |
|            | O) Attach Scope to Rifle                                    |          |       |       |     |     | 10/10/90 | RW   |
|            | P) Detach & Attach Scope 20 Times                           |          |       |       |     |     | 10/10/90 | RW   |
| 640        | Gallery Target & Test                                       |          |       |       |     |     | 10-11-90 | DH   |
|            | A) Time                                                     |          |       |       |     |     | 10-11-90 | DH   |
|            | B) Malfunctions                                             |          |       |       |     |     | 10-11-90 | DH   |
|            | C) Pierced Primers                                          |          |       |       |     |     | 10-11-90 | DH   |
|            | D) Optical Clarity of Scope                                 |          |       |       |     |     | 10-11-90 | DH   |
| 645        | Inspect for Live Ammo                                       |          |       |       |     |     | 10-11-90 | DH   |
| 655        | Final Inspection                                            |          |       |       |     |     |          |      |
|            | A) Headspace                                                |          |       |       |     |     | 20/10/90 | YS   |
|            | B) Trigger Pull                                             | 238      | 216   | 211   | 213 | 214 | 20/10/90 | YS   |
|            | C) Function                                                 |          |       |       |     |     | 20/10/90 | YS   |
| 660        | Pack                                                        |          |       |       |     |     | 12-17-90 | DH   |

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6523412

| OP. #        | OP. NAME                                                       | READINGS | DATE     | INIT |
|--------------|----------------------------------------------------------------|----------|----------|------|
| 575 &<br>580 | Assemble Action<br>and Stock                                   | 9 24     | 90       | RW   |
| 600          | Proof                                                          | 9 24     | 90       | RW   |
| 607          | Check Headspace                                                | 9 24     | 90       | RW   |
| 610          | Dis-assemble Gun                                               | 9 24     | 30       | RW   |
| 612          | Magnaflux Barrel<br>Action                                     |          | 9-25-90  | KR.  |
|              | Magnaflux Bolt                                                 |          | 9-25-90  | KR   |
| 615          | Rollmark Caliber                                               |          | 9-25-90  | RL   |
| 617          | Drill and Tap Sight Holes                                      |          | 9-25-90  | FB   |
| 618          | Polish Barrel RB                                               |          | 9/28/90  | WB   |
| 620          | Apply Coatings<br>(Barrel Action)                              |          | 10-7-90  | JA   |
|              | Apply Coating (Bolt)                                           |          |          |      |
| 625          | Final Assembly<br>A) Clean inside of<br>Bolt Assembly          |          | 10/8/90  | RW   |
|              | B) Inspect Rear Firing<br>Pin Hole for Chamfer<br>in Bolt Head |          | 10/8/90  | RW   |
|              | C) Inspect Ejector Hole<br>for Chamfer                         |          | 10/8/90  | RW   |
|              | D) Oil Firing Pin Ass'y                                        |          | 10/8/90  | RW   |
|              | E) Adjust Trigger Pull to<br>Min Setting and Stake             |          | 10/10/90 | WB   |

AVERAGE PULL FORCE BETWEEN  
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6523412

DATE 10/10/90

TESTER WB

|         | 2.50#<br>INITIAL | 2.50# AFTER<br>50 CYCLES | FINAL TEST &<br>TO RESET 2.50# |      | COMMENTS                                                               |
|---------|------------------|--------------------------|--------------------------------|------|------------------------------------------------------------------------|
| PULL #1 | 2.36             | 2.54                     | 2.46                           | 2.38 | MIN. SETTING,<br>NO AVG. OF 5<br>READINGS ACCEPT-<br>ABLE LESS THAN 2# |
| PULL #2 | 2.35             | 2.53                     | 2.43                           | 2.16 |                                                                        |
| PULL #3 | 2.40             | 2.51                     | 2.42                           | 2.11 |                                                                        |
| PULL #4 | 2.49             | 2.48                     | 2.32                           | 2.13 |                                                                        |
| PULL #5 | 2.48             | 2.43                     | 2.37                           | 2.16 |                                                                        |
| TOTAL   | 12.08            | 12.49                    | 12.00                          |      |                                                                        |
| AVG.    | 2.42             | 2.50                     | 2.40                           |      |                                                                        |

|         | 3.00#<br>INITIAL | 3.00# AFTER<br>20 CYCLES |  | COMMENTS |
|---------|------------------|--------------------------|--|----------|
| PULL #1 | 3.09             | 3.03                     |  |          |
| PULL #2 | 3.02             | 3.08                     |  |          |
| PULL #3 | 3.10             | 3.09                     |  |          |
| PULL #4 | 3.13             | 3.05                     |  |          |
| PULL #5 | 3.14             | 3.05                     |  |          |
| TOTAL   | 15.48            | 15.30                    |  |          |
| AVG.    | 3.10             | 3.06                     |  |          |

|         | 4.00#<br>INITIAL | 4.00# AFTER<br>20 CYCLES | MAX SETTING<br>GREATER THAN 4# | RESET TO 4# FOR<br>TARGET & ACCURACY |
|---------|------------------|--------------------------|--------------------------------|--------------------------------------|
| PULL #1 | 4.02             | 4.09                     |                                | 4.41                                 |
| PULL #2 | 4.00             | 4.02                     |                                | 4.38                                 |
| PULL #3 | 3.95             | 4.03                     |                                | 4.34                                 |
| PULL #4 | 4.06             | 4.06                     |                                | 4.31                                 |
| PULL #5 | 4.04             | 4.00                     |                                | 4.17                                 |
| TOTAL   | 20.07            | 20.20                    |                                | 21.61                                |
| AVG.    | 4.01             | 4.04                     |                                | 4.32                                 |

CENTROIDAL DISTANCE CALCULATIONS  
FOR RIFLE # C6523412  
12 Oct 1990

CENTROIDAL DISTANCES

|      |   |         |
|------|---|---------|
| 0 TO | 1 | .364967 |
| 1 TO | 2 | .194373 |
| 1 TO | 3 | .598767 |
| 1 TO | 4 | .779762 |
| 1 TO | 5 | .363593 |

$\frac{21}{3 \frac{5}{4}}$ 
 $\leftarrow$ ----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0656  
 THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .085  
 THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .10737  
 THE AMR FOR THIS RIFLE IS: .9506

12 Oct 1998

FILE:/PATTERNING/CENTERFIRE\_PATT/06523412

## CENTERFIRE PATTERNS # 1

POA

1in circle

2in circle

3in circle

# OF SHOTS = 10

# IN CIR

1in = 2

2in = 7

3in = 10

HS = 1.865

VS = 2.691

GS = 2.730

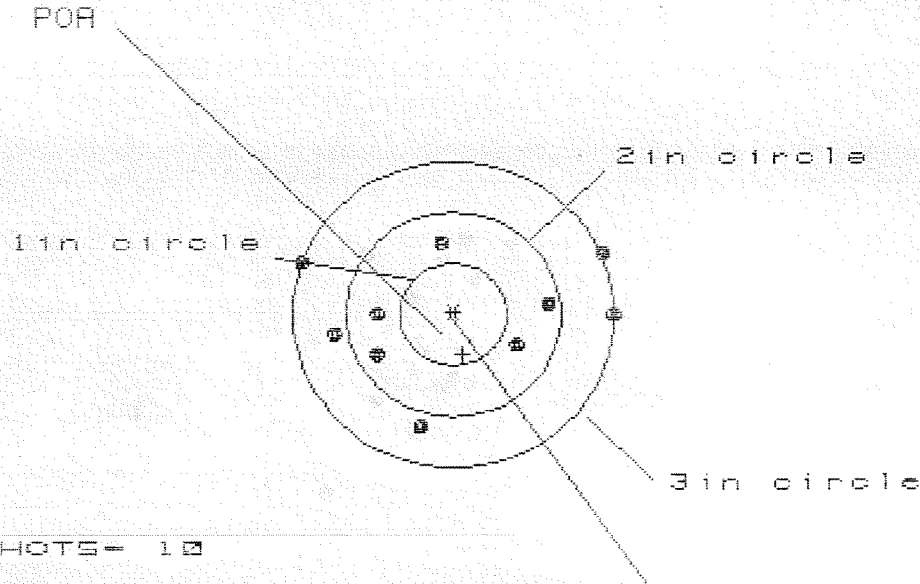
CENTROID #

| PATTERN #                     | 1      | 2      | 3      |
|-------------------------------|--------|--------|--------|
| SHOTS (BEST OF)               | 10     | 9      | 8      |
| MAXIMUM X                     | .636   | .665   | .644   |
| MINIMUM X                     | -1.229 | -1.200 | -1.221 |
| MAXIMUM Y                     | 1.457  | .643   | .509   |
| MINIMUM Y                     | -1.234 | -1.073 | -.578  |
| CENTROID X                    | .100   | .071   | .092   |
| CENTROID Y                    | .351   | .190   | .324   |
| POA TO CENTROID in.           | .365   | .202   | .336   |
| MIN RADIUS                    | .134   | .297   | .162   |
| MEAN RADIUS                   | .753   | .684   | .605   |
| MAX RADIUS                    | 1.480  | 1.201  | 1.235  |
| HORIZONTAL SPREAD             | 1.865  | 1.865  | 1.865  |
| VERTICAL SPREAD               | 2.691  | 1.716  | 1.087  |
| EXTREME SPREAD                | 2.730  | 1.865  | 1.865  |
| NUMBER IN ONE INCH CIRCLE =   | 2      |        |        |
| NUMBER IN TWO INCH CIRCLE =   | 7      |        |        |
| NUMBER IN THREE INCH CIRCLE = | 10     |        |        |

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## CENTERFIRE PATTERNS # 2



# OF SHOTS- 10

# IN CIR

1in = 0

2in = 5

3in = 5

HS= 2.843

VS= 1.747

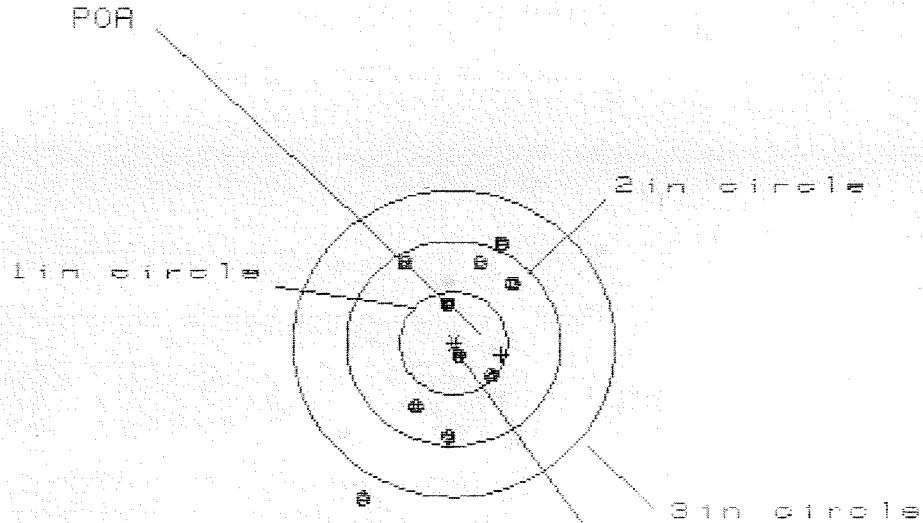
GS= 2.881

| PATTERN #                     | 2      |        |        |
|-------------------------------|--------|--------|--------|
| SHOTS (BEST OF)               | 10     | 9      | 8      |
| MAXIMUM X                     | 1.444  | 1.598  | 1.443  |
| MINIMUM X                     | -1.399 | -1.245 | -1.077 |
| MAXIMUM Y                     | .666   | .729   | .802   |
| MINIMUM Y                     | -1.081 | -1.018 | -.944  |
| CENTROID X                    | -.090  | -.244  | -.089  |
| CENTROID Y                    | .392   | .329   | .256   |
| POA TO CENTROID in.           | .402   | .410   | .270   |
| MIN RADIUS                    | .679   | .577   | .640   |
| MEAN RADIUS                   | 1.045  | .972   | .924   |
| MAX RADIUS                    | 1.501  | 1.603  | 1.455  |
| HORIZONTAL SPREAD             | 2.843  | 2.843  | 2.519  |
| VERTICAL SPREAD               | 1.747  | 1.747  | 1.747  |
| EXTREME SPREAD                | 2.881  | 2.881  | 2.531  |
| NUMBER IN ONE INCH CIRCLE =   |        | 0      |        |
| NUMBER IN TWO INCH CIRCLE =   |        | 5      |        |
| NUMBER IN THREE INCH CIRCLE = |        | 9      |        |

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## CENTERFIRE PATTERNS # 3



# OF SHOTS = 10

# IN CIR

1 in = 3

2 in = 8

3 in = 9

HS = 1.335

VS = 2.543

GS = 2.866

| PATTERN #                     | 3      | 9      | 8     |
|-------------------------------|--------|--------|-------|
| SHOTS (BEST OF)               | 10     | 9      | 8     |
| MAXIMUM X                     | .507   | .415   | .465  |
| MINIMUM X                     | -.828  | -.582  | -.532 |
| MAXIMUM Y                     | 1.015  | .845   | .759  |
| MINIMUM Y                     | -1.528 | -1.091 | -.985 |
| CENTROID X                    | -.449  | -.357  | -.407 |
| CENTROID Y                    | .112   | .282   | .176  |
| POA TO CENTROID in.           | .463   | .455   | .444  |
| MIN RADIUS                    | .132   | .195   | .165  |
| MEAN RADIUS                   | .798   | .671   | .635  |
| MAX RADIUS                    | 1.738  | 1.098  | .988  |
| HORIZONTAL SPREAD             | 1.335  | .997   | .997  |
| VERTICAL SPREAD               | 2.543  | 1.936  | 1.744 |
| EXTREME SPREAD                | 2.866  | 2.006  | 1.803 |
| NUMBER IN ONE INCH CIRCLE =   |        | 3      |       |
| NUMBER IN TWO INCH CIRCLE =   |        | 8      |       |
| NUMBER IN THREE INCH CIRCLE = |        | 9      |       |

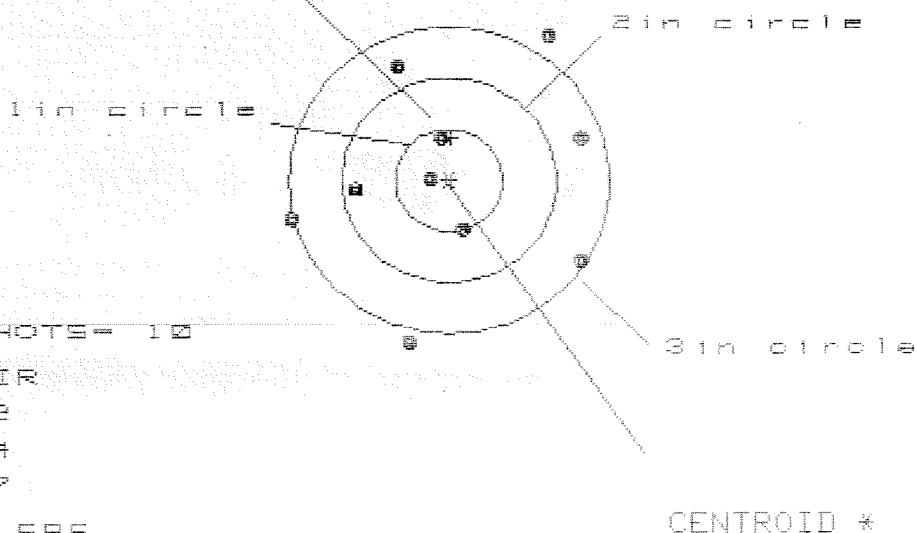
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## CENTERFIRE PATTERNS

# 4

POA



# OF SHOTS = 10

# IN CIR

1in = 2

2in = 4

3in = 7

HS = 2.686

VS = 2.997

GS = 3.257

CENTROID \*

| PATTERN #                     | 4      | 9      | 8      |
|-------------------------------|--------|--------|--------|
| SHOTS (BEST OF)               | 10     | 9      | 8      |
| MAXIMUM X                     | 1.219  | 1.318  | 1.281  |
| MINIMUM X                     | -1.467 | -1.368 | -1.405 |
| MAXIMUM Y                     | 1.409  | 1.298  | 1.119  |
| MINIMUM Y                     | -1.588 | -1.431 | -1.785 |
| CENTROID X                    | -.023  | -.122  | -.085  |
| CENTROID Y                    | -.419  | -.576  | -.397  |
| POA TO CENTROID in.           | .420   | .588   | .406   |
| MIN RADIUS                    | .157   | .150   | .102   |
| MEAN RADIUS                   | 1.071  | .994   | .916   |
| MAX RADIUS                    | 1.664  | 1.461  | 1.502  |
| HORIZONTAL SPREAD             | 2.686  | 2.686  | 2.686  |
| VERTICAL SPREAD               | 2.997  | 2.729  | 1.984  |
| EXTREME SPREAD                | 3.257  | 2.771  | 2.771  |
| NUMBER IN ONE INCH CIRCLE =   | 2      |        |        |
| NUMBER IN TWO INCH CIRCLE =   | 4      |        |        |
| NUMBER IN THREE INCH CIRCLE = | 7      |        |        |

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## CENTERFIRE PATTERNS

# 5

FOR

1 in circle

2 in circle

3 in circle

# OF SHOTS= 10

# IN CIR

1 in = 0

2 in = 4

3 in = 9

CENTROID #

HS= 2.788

VS= 2.493

GS= 2.901

PATTERN #

5

| SHOTS (BEST OF)               | 10     | 9      | 8     |
|-------------------------------|--------|--------|-------|
| MAXIMUM X                     | 1.618  | .939   | .949  |
| MINIMUM X                     | -1.170 | -.990  | -.980 |
| MAXIMUM Y                     | 1.030  | 1.092  | .917  |
| MINIMUM Y                     | -1.463 | -1.401 | -.835 |
| CENTROID X                    | .134   | -.046  | -.056 |
| CENTROID Y                    | -.011  | -.073  | .102  |
| FOR TO CENTROID in.           | .134   | .086   | .117  |
| MIN RADIUS                    | .575   | .459   | .631  |
| MEAN RADIUS                   | 1.086  | .990   | .933  |
| MAX RADIUS                    | 1.712  | 1.440  | 1.320 |
| HORIZONTAL SPREAD             | 2.788  | 1.929  | 1.929 |
| VERTICAL SPREAD               | 2.493  | 2.493  | 1.752 |
| EXTREME SPREAD                | 2.901  | 2.637  | 2.311 |
| NUMBER IN ONE INCH CIRCLE =   |        | 0      |       |
| NUMBER IN TWO INCH CIRCLE =   |        | 4      |       |
| NUMBER IN THREE INCH CIRCLE = |        | 9      |       |

