

05523414

MODEL 700™ M24

Model **SMS**™

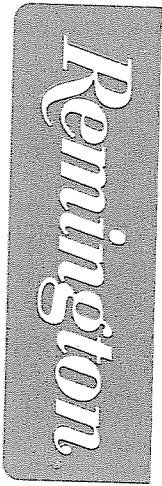
Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



Repair Inquiry

Repair Number: RE00146042

Serial: C6523414 Model M24 SWS Center Fire
Caliber: 7.62 NATO

Repairman:

Verify Repair

Status: Closed 6/3/2008 9:51:13 AM

Address Information

Customer:

☒ Received From

Return To:

☐ Received From

Name: INSTALLATION SERIALIZATION OFFICER

INSTALLATION SERIALIZATION OFFICER

Address 1: BLDG 7920

BLDG 7920

Address 2: PO Box:

PO Box:

City: FT. RILEY

FT. RILEY

State: KS Zip Code: 66442 Country: US

State: KS Zip Code: 66442 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
D000	FLASH SUPPRESSOR	1

Repair Search

Refresh

Close

nagletj

6/3/2008

12:57 PM

CAPS

NUM

DMS

STP

Number: C6523414

Model: M24 SWS



RE00146042

INSPECTION CHECKLIST - REPAIRS

CONTRACT #: W52H09-07-C-0207

ISSUED 10/1/2007

R & E NUMBER

146042

SERIAL NUMBER

C6523414

LOG-IN DATE

6-3-08

OPERATION #	OPERATION NAME	DATE	INITIAL
500	DIS-ASSEMBLE GUN	5-14-09	RT
505	RE-BARREL	5-26-09	RT
420	ASSEMBLE	5-26-09	RT
440	PROOF	5-26-09	L.P.D.
460	CHECK HEADSPACE	5-26-09	L.P.D.
470	DIS-ASSEMBLE GUN	5-26-09	L.P.D.
480	MAGNAFLUX	5-30-09	D
510	DRILL AND TAP	5-27-09	SP
500	ROLLMARK CALIBER	6-1-09	RT
520	GOFF BLAST BBL / REC	6-1-09	DWD
530 & 540	APPLY COATINGS	6-1-09	C
560	FINAL ASSEMBLY	6-4-09	RT
640	FUNCTION TEST AND	6-1-09	RB
650	TARGET	6-1-09	RB
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
670	FINAL INSPECTION	6-1-09	TQR
	A) HEADSPACE	PASS FAIL	6-5-09 XN
	B) TRIGGER PULL	261 265 275 277 271	6-5-09 RT
680	F) SAFETY ON FORCE	50 50 50	6-5-09 XN
	G) SAFETY OFF FORCE	50 50 50	6-5-09 XN
	I) FIRING PIN INDENT	.021 .021 .021	6-5-09 XN
690	PACK	6-3-09	FM

F006 REV 1/2009

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6523414.___0
FILE DATE AND TIME: 06/04/2009 14:05

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.050
The Average Y Centroid of the Five Target Set:	-0.008
The Average Point of Impact of the Five Target Set:	0.050
The Average Mean Radius of the Five Target Set:	0.555
The Distance from POA to Centroid Target #1:	0.162
The Distance from Centroid Target #2 to Centroid Target #1:	0.334
The Distance from Centroid Target #3 to Centroid Target #1:	0.084
The Distance from Centroid Target #4 to Centroid Target #1:	0.137
The Distance from Centroid Target #5 to Centroid Target #1:	0.139

BARBER - M24 0027659

SERIAL NUMBER: C6523414. __0

TARGET NUMBER: 1

FILE DATE: 06/04/2009

FILE TIME: 14:05

X CENTROID: -0.149

Y CENTROID: 0.063

POA TO CENTROID: 0.162

HORZ SPREAD: 2.093

VERT SPREAD: 2.379

GROUP SPREAD: 2.829

MIN RADIUS: 0.092

MAX RADIUS: 1.533

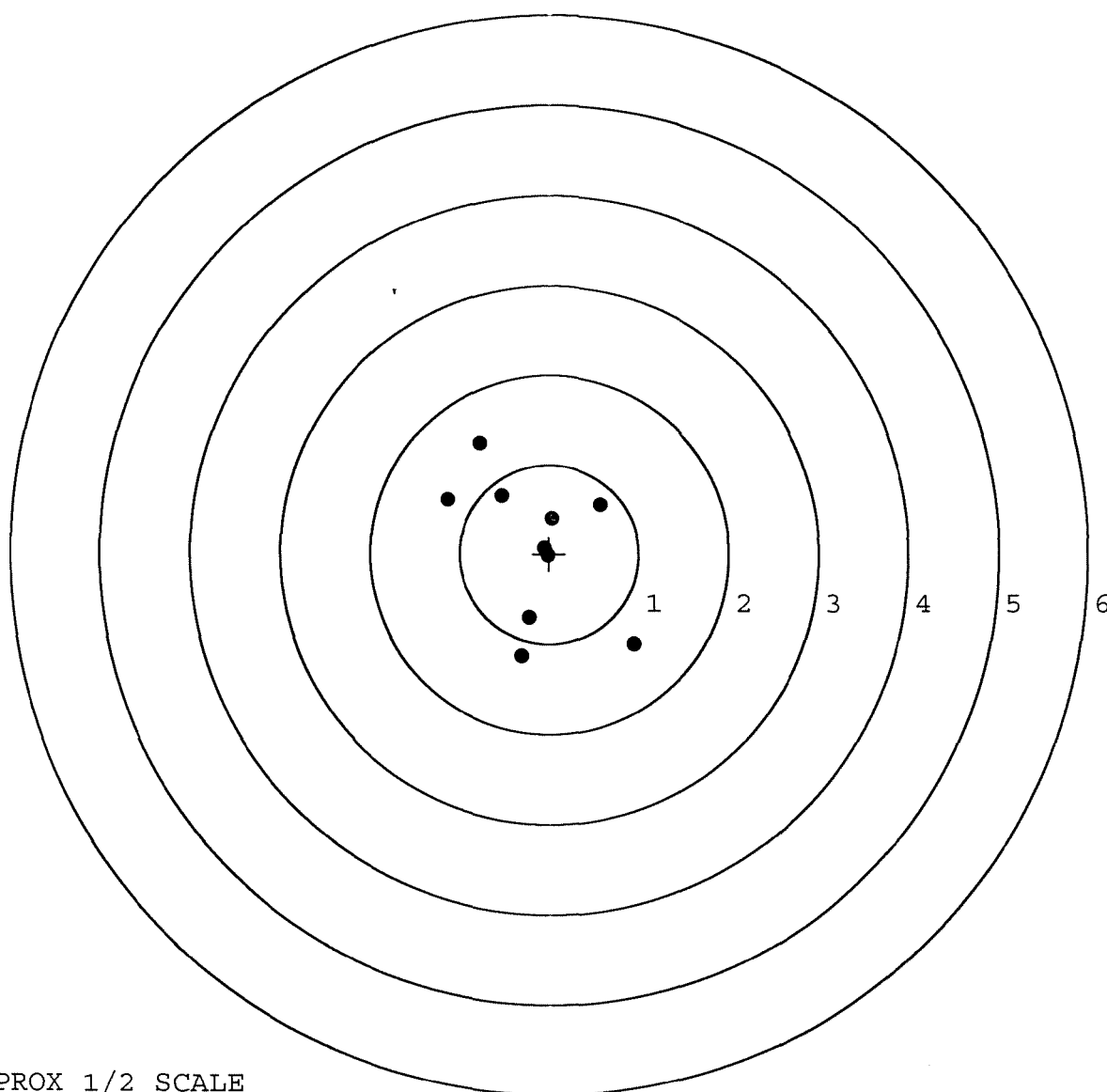
MEAN RADIUS: 0.819

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 9

POINT#	X	Y
1:	-0.768	1.243
2:	-0.530	0.652
3:	-1.140	0.606
4:	0.029	0.391
5:	0.578	0.552
6:	0.953	-1.002
7:	-0.313	-1.136
8:	-0.232	-0.715
9:	-0.014	-0.024
10:	-0.057	0.060



TARGET APPROX 1/2 SCALE

BARBER - M24 0027660

SERIAL NUMBER: C6523414. __0

TARGET NUMBER: 2

FILE DATE: 06/04/2009

FILE TIME: 14:05

X CENTROID: 0.174

Y CENTROID: -0.021

POA TO CENTROID: 0.175

HORZ SPREAD: 1.055

VERT SPREAD: 1.277

GROUP SPREAD: 1.310

MIN RADIUS: 0.061

MAX RADIUS: 0.900

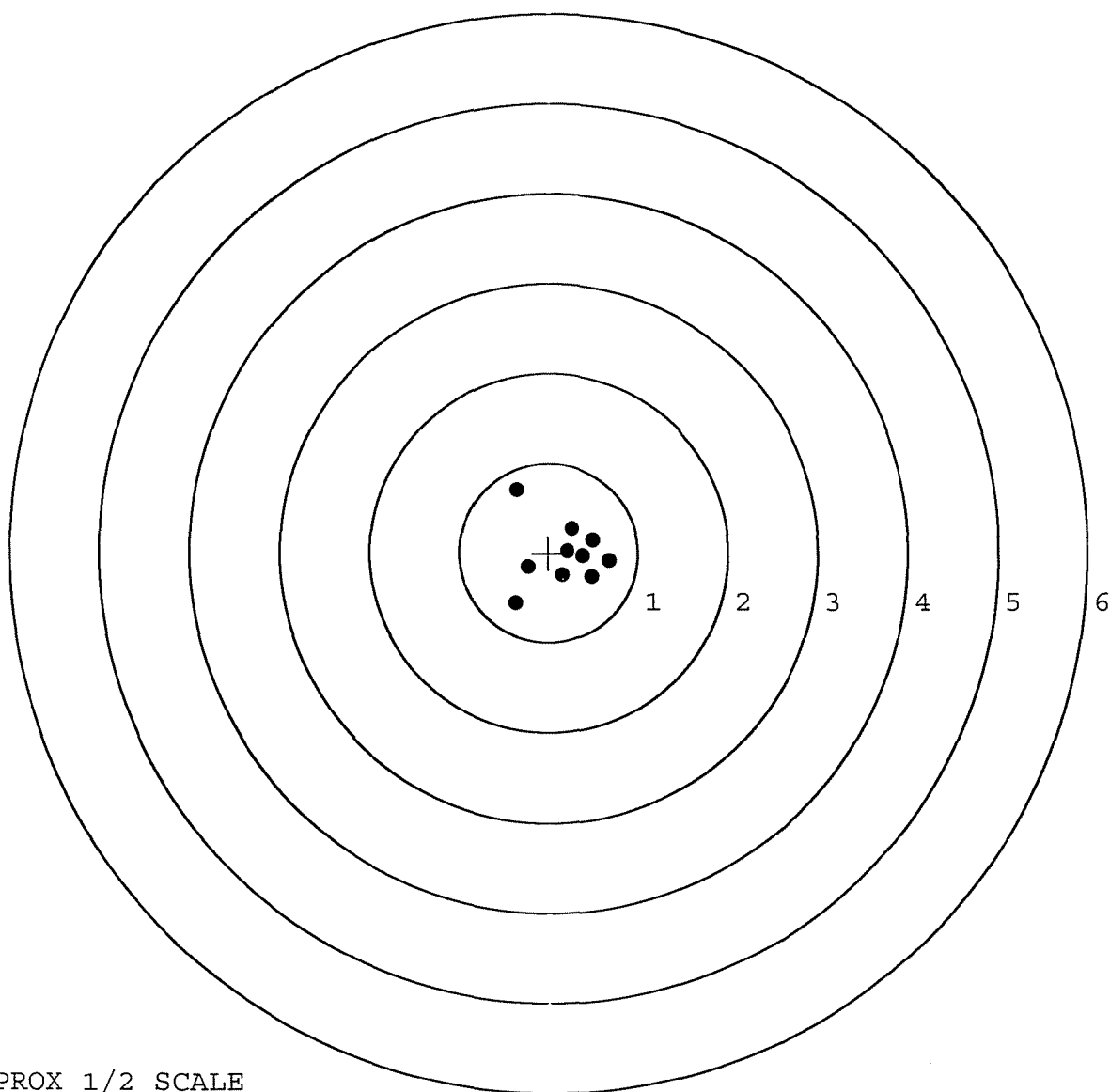
MEAN RADIUS: 0.420

IN 1 IN DIAMETER: 7

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.369	-0.572
2:	-0.233	-0.155
3:	-0.359	0.705
4:	0.260	0.272
5:	0.506	0.152
6:	0.686	-0.085
7:	0.488	-0.262
8:	0.154	-0.252
9:	0.216	0.024
10:	0.388	-0.033



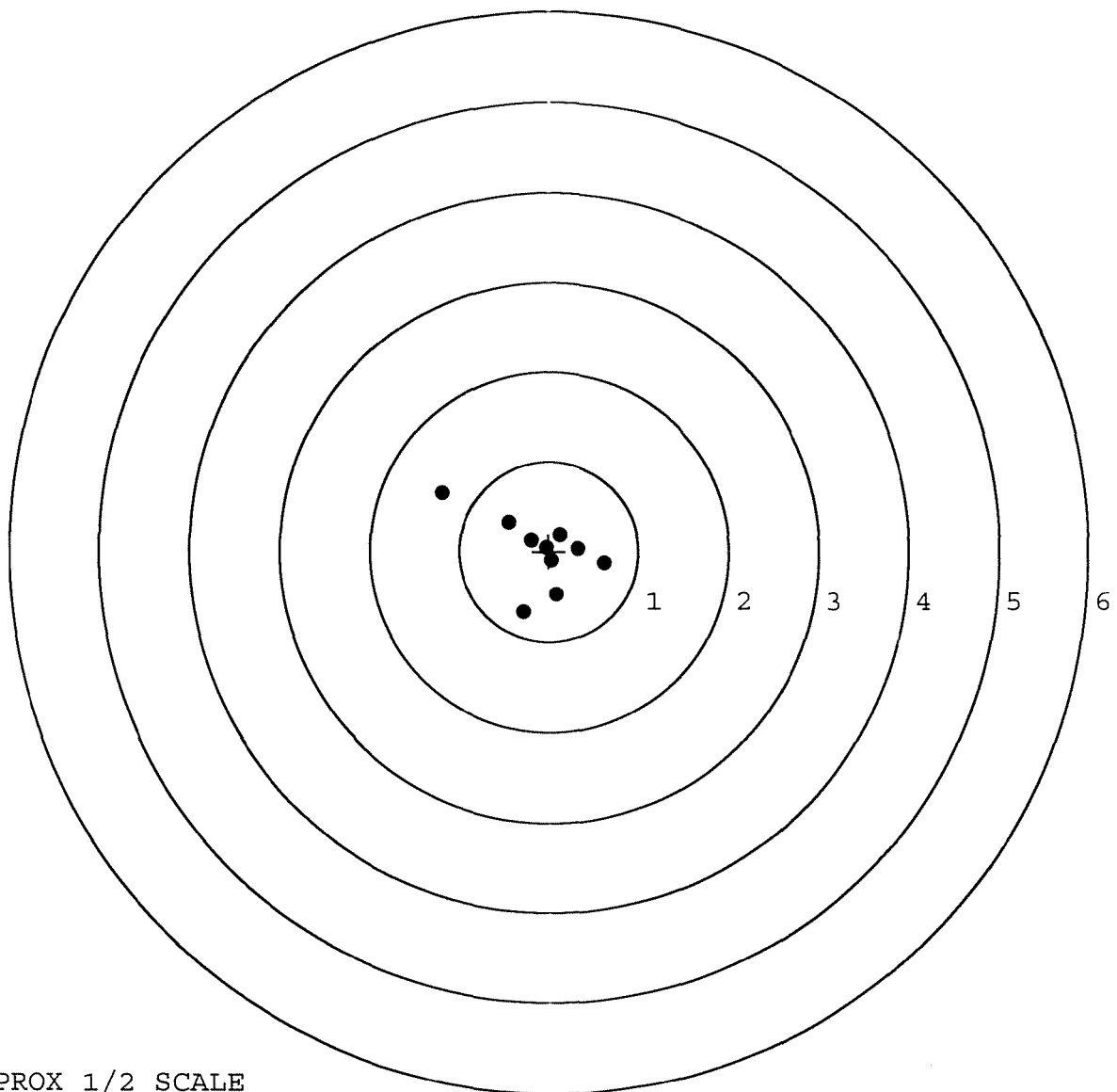
TARGET APPROX 1/2 SCALE

BARBER - M24 0027661

SERIAL NUMBER: C6523414. __0
TARGET NUMBER: 3
FILE DATE: 06/04/2009
FILE TIME: 14:05

POINT#	X	Y
1:	-1.198	0.651
2:	-0.292	-0.677
3:	0.080	-0.484
4:	0.624	-0.131
5:	0.328	0.033
6:	0.131	0.184
7:	-0.451	0.325
8:	-0.196	0.123
9:	0.029	-0.105
10:	-0.027	0.045

X CENTROID: -0.097
Y CENTROID: -0.004
POA TO CENTROID: 0.097
HORZ SPREAD: 1.822
VERT SPREAD: 1.328
GROUP SPREAD: 1.983
MIN RADIUS: 0.085
MAX RADIUS: 1.281
MEAN RADIUS: 0.484
IN 1 IN DIAMETER: 6
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

BARBER - M24 0027662

SERIAL NUMBER: C6523414. __0

TARGET NUMBER: 4

FILE DATE: 06/04/2009

FILE TIME: 14:05

X CENTROID: -0.149

Y CENTROID: -0.074

POA TO CENTROID: 0.167

HORZ SPREAD: 1.924

VERT SPREAD: 1.231

GROUP SPREAD: 2.008

MIN RADIUS: 0.128

MAX RADIUS: 1.090

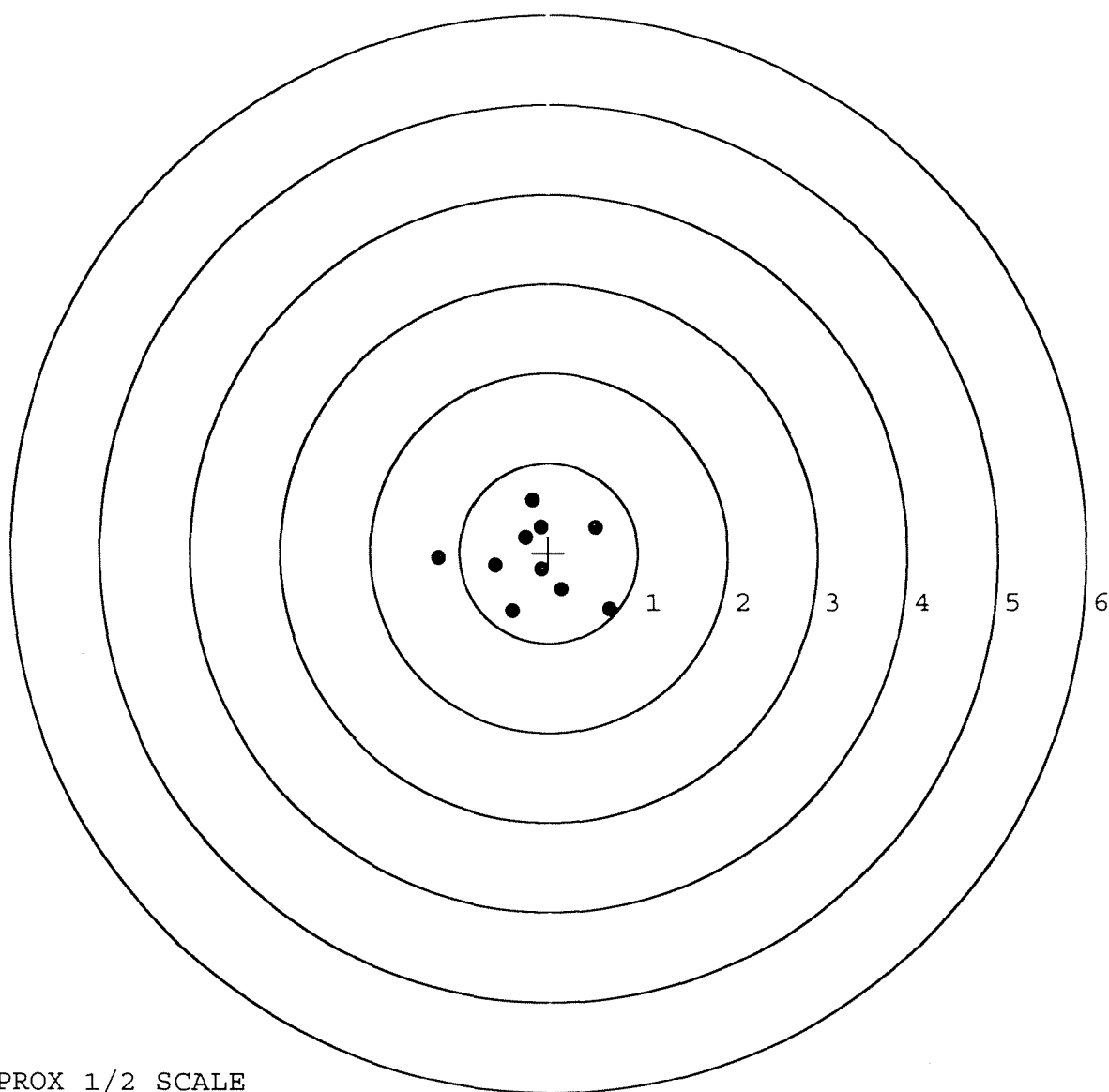
MEAN RADIUS: 0.581

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.184	0.583
2:	-0.091	0.282
3:	-0.254	0.173
4:	0.533	0.284
5:	-0.594	-0.134
6:	-1.239	-0.055
7:	-0.411	-0.648
8:	0.143	-0.413
9:	0.685	-0.631
10:	-0.081	-0.182

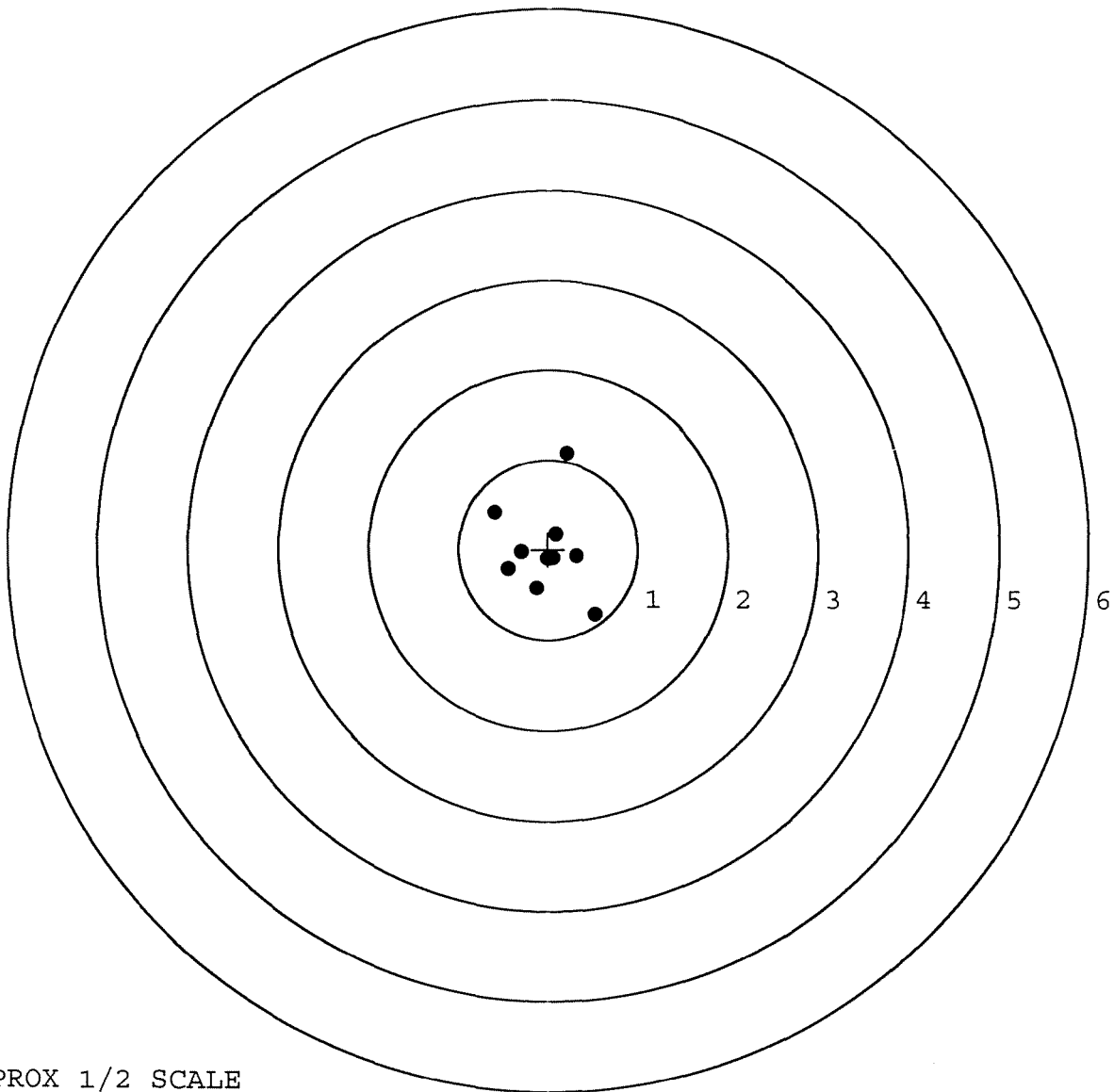


TARGET APPROX 1/2 SCALE

BARBER - M24 0027663

SERIAL NUMBER: C6523414. __0
TARGET NUMBER: 5
FILE DATE: 06/04/2009
FILE TIME: 14:05

	POINT#	X	Y
	1:	0.208	1.071
	2:	-0.599	0.410
	3:	0.531	-0.721
	4:	-0.133	-0.438
X CENTROID:	5:	-0.440	-0.216
Y CENTROID:	6:	-0.295	-0.027
POA TO CENTROID:	7:	0.090	0.172
HORZ SPREAD:	8:	0.325	-0.078
VERT SPREAD:	9:	0.057	-0.099
GROUP SPREAD:	10:	-0.013	-0.100
MIN RADIUS:		0.098	
MAX RADIUS:		1.099	
MEAN RADIUS:		0.469	
# IN 1 IN DIAMETER:		7	
# IN 2 IN DIAMETER:		9	
# in 3 IN DIAMETER:		10	



TARGET APPROX 1/2 SCALE

BARBER - M24 0027664

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: RE00092459 Serial: C6523414 Model: M24 SWS Center Fire Caliber: 7.62 NATO Produced: 12/18/1990 Repairman: Status: Closed 2/4/2005 9:37:18 AM

Verify Repair

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	Frt and Rear Sgt Base	1

Repair Search Refresh Close

naglatj 2/7/2005 11:26 AM DAPS NUM INS SCPL

start 3 3 M

Serial Number: C6523414

Model: M24 SWS

RE00092459

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

BARBER - M24 0027664

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6523414.___0
FILE DATE AND TIME: 05/04/2005 06:42

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

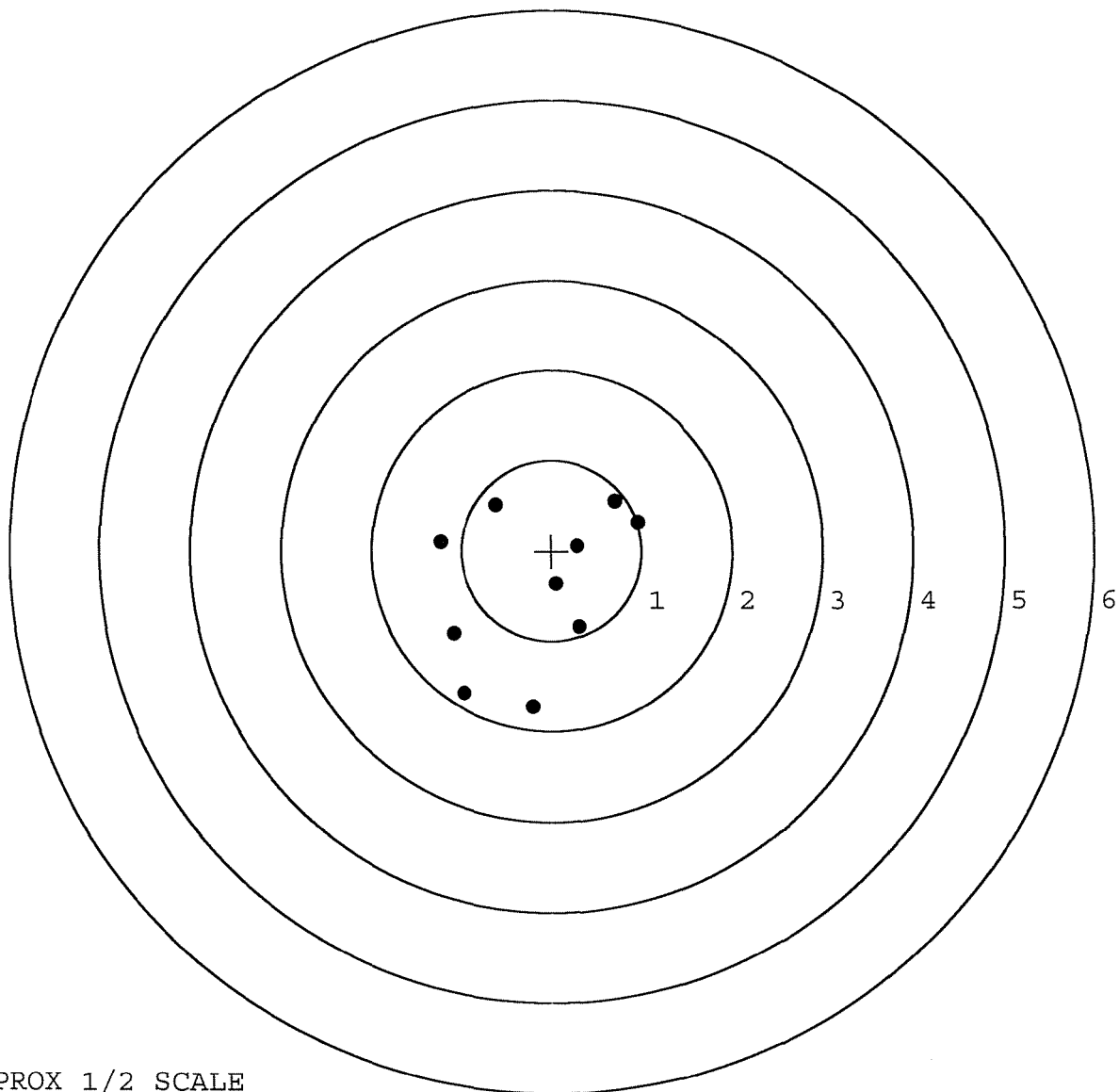
The Average X Centroid of the Five Target Set:	0.057
The Average Y Centroid of the Five Target Set:	0.157
The Average Point of Impact of the Five Target Set:	0.167
The Average Mean Radius of the Five Target Set:	1.086
The Distance from POA to Centroid Target #1:	0.433
The Distance from Centroid Target #2 to Centroid Target #1:	0.433
The Distance from Centroid Target #3 to Centroid Target #1:	0.875
The Distance from Centroid Target #4 to Centroid Target #1:	1.522
The Distance from Centroid Target #5 to Centroid Target #1:	0.226

BARBER - M24 0027666

SERIAL NUMBER: C6523414. __0
TARGET NUMBER: 1
FILE DATE: 05/04/2005
FILE TIME: 06:42

POINT#	X	Y
1:	-0.208	-1.736
2:	-0.970	-1.585
3:	-1.084	-0.924
4:	0.310	-0.844
5:	0.048	-0.372
6:	0.289	0.054
7:	0.955	0.318
8:	0.701	0.548
9:	-0.622	0.508
10:	-1.230	0.105

X CENTROID: -0.181
Y CENTROID: -0.393
POA TO CENTROID: 0.433
HORZ SPREAD: 2.185
VERT SPREAD: 2.284
GROUP SPREAD: 2.710
MIN RADIUS: 0.230
MAX RADIUS: 1.430
MEAN RADIUS: 1.016
IN 1 IN DIAMETER: 1
IN 2 IN DIAMETER: 3
in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

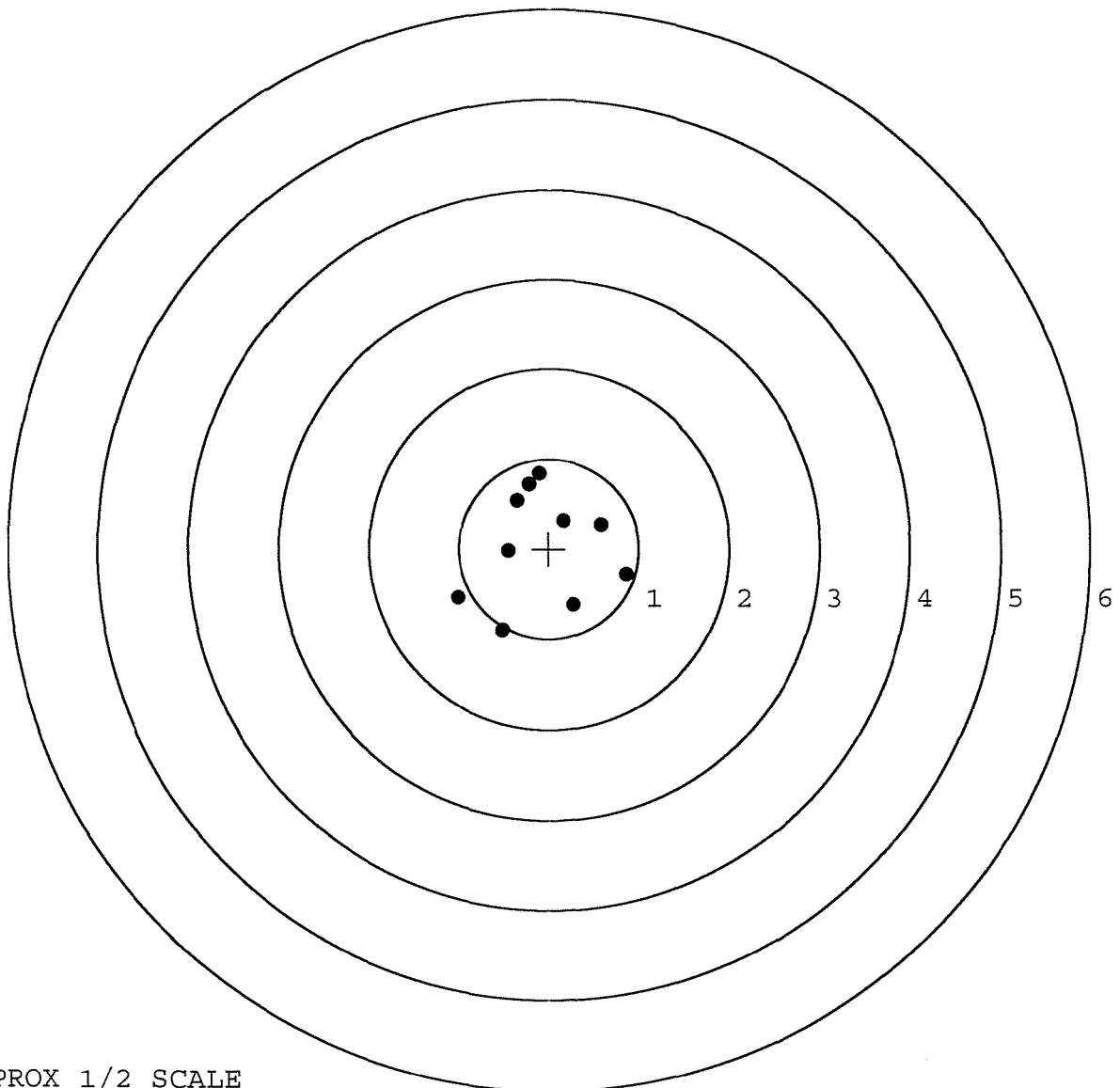
BARBER - M24 0027667

SERIAL NUMBER: C6523414. __0
TARGET NUMBER: 2
FILE DATE: 05/04/2005
FILE TIME: 06:42

X CENTROID: -0.077
Y CENTROID: 0.028
POA TO CENTROID: 0.082
HORZ SPREAD: 1.875
VERT SPREAD: 1.747
GROUP SPREAD: 1.894
MIN RADIUS: 0.369
MAX RADIUS: 1.095
MEAN RADIUS: 0.742

IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.866	-0.280
2:	0.581	0.268
3:	0.279	-0.633
4:	0.164	0.307
5:	-0.448	-0.026
6:	-0.519	-0.909
7:	-1.009	-0.547
8:	-0.356	0.540
9:	-0.222	0.719
10:	-0.107	0.838



TARGET APPROX 1/2 SCALE

BARBER - M24 0027668

SERIAL NUMBER: C6523414. __0

TARGET NUMBER: 3

FILE DATE: 05/04/2005

FILE TIME: 06:42

X CENTROID: -0.015

Y CENTROID: 0.466

POA TO CENTROID: 0.466

HORZ SPREAD: 1.954

VERT SPREAD: 3.227

GROUP SPREAD: 3.328

MIN RADIUS: 0.039

MAX RADIUS: 2.073

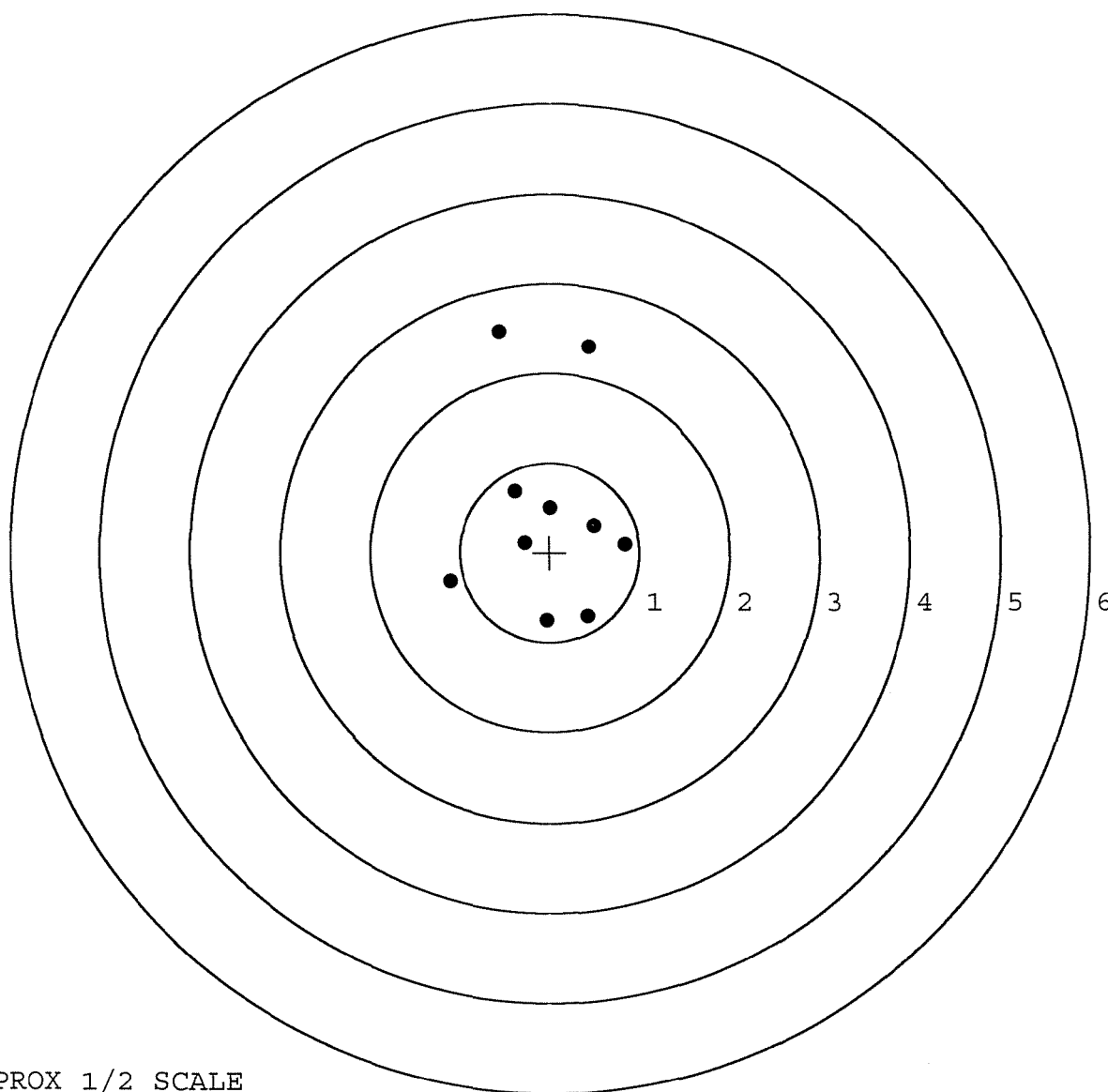
MEAN RADIUS: 1.018

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 5

in 3 IN DIAMETER: 8

POINT#	X	Y
1:	0.430	-0.711
2:	-0.034	-0.761
3:	0.841	0.100
4:	0.496	0.304
5:	0.004	0.500
6:	-0.274	0.108
7:	-0.387	0.681
8:	-1.113	-0.325
9:	0.444	2.300
10:	-0.560	2.466



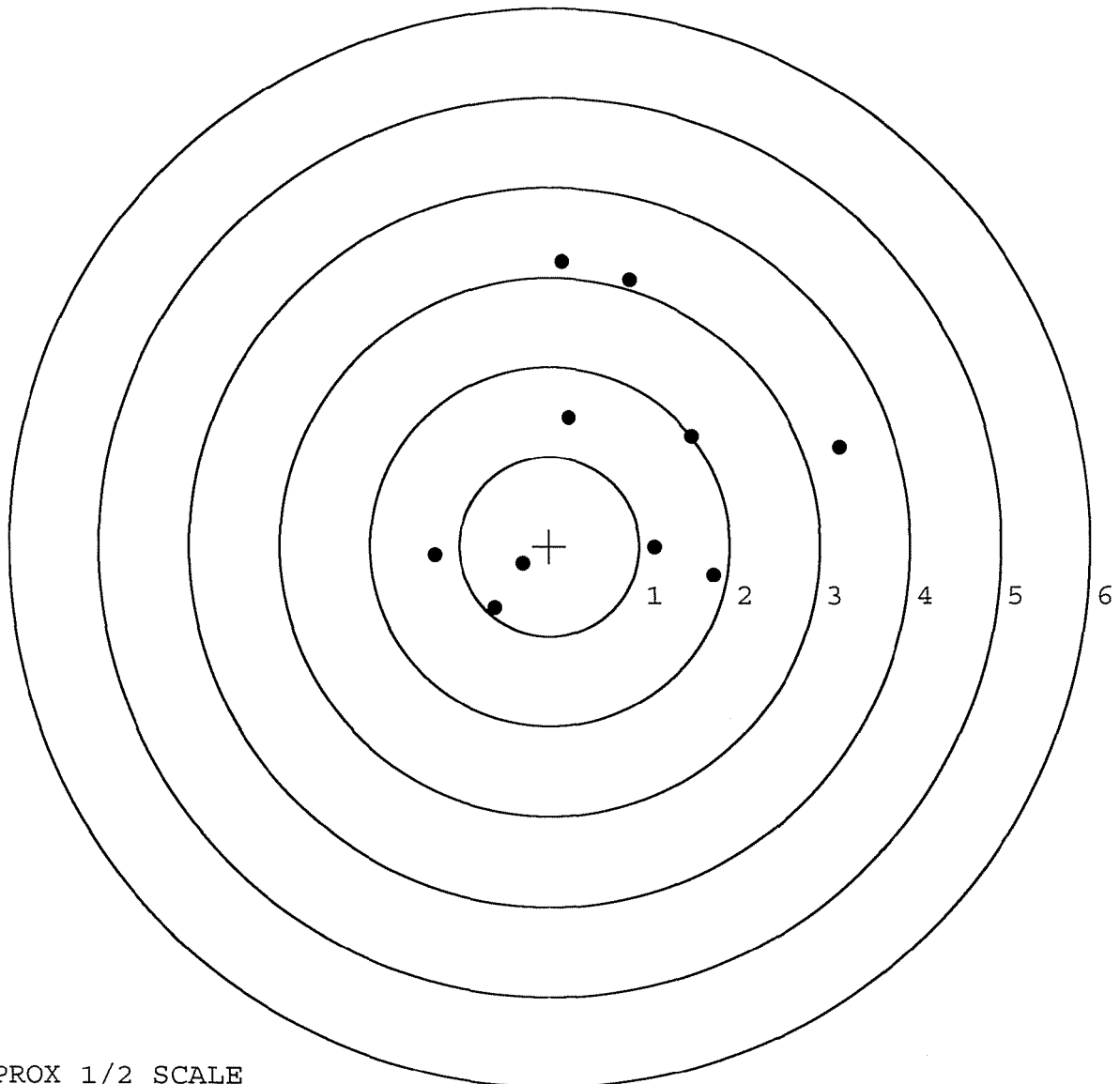
TARGET APPROX 1/2 SCALE

BARBER - M24 0027669

SERIAL NUMBER: C6523414. __0
 TARGET NUMBER: 4
 FILE DATE: 05/04/2005
 FILE TIME: 06:42

X CENTROID: 0.686
 Y CENTROID: 0.858
 POA TO CENTROID: 1.098
 HORZ SPREAD: 4.495
 VERT SPREAD: 3.864
 GROUP SPREAD: 4.655
 MIN RADIUS: 0.742
 MAX RADIUS: 2.542
 MEAN RADIUS: 1.705
 # IN 1 IN DIAMETER: 0
 # IN 2 IN DIAMETER: 3
 # in 3 IN DIAMETER: 4

POINT#	X	Y
1:	1.820	-0.326
2:	1.172	-0.014
3:	1.586	1.233
4:	3.216	1.105
5:	0.214	1.430
6:	0.894	2.971
7:	0.145	3.173
8:	-0.300	-0.198
9:	-0.608	-0.691
10:	-1.279	-0.104



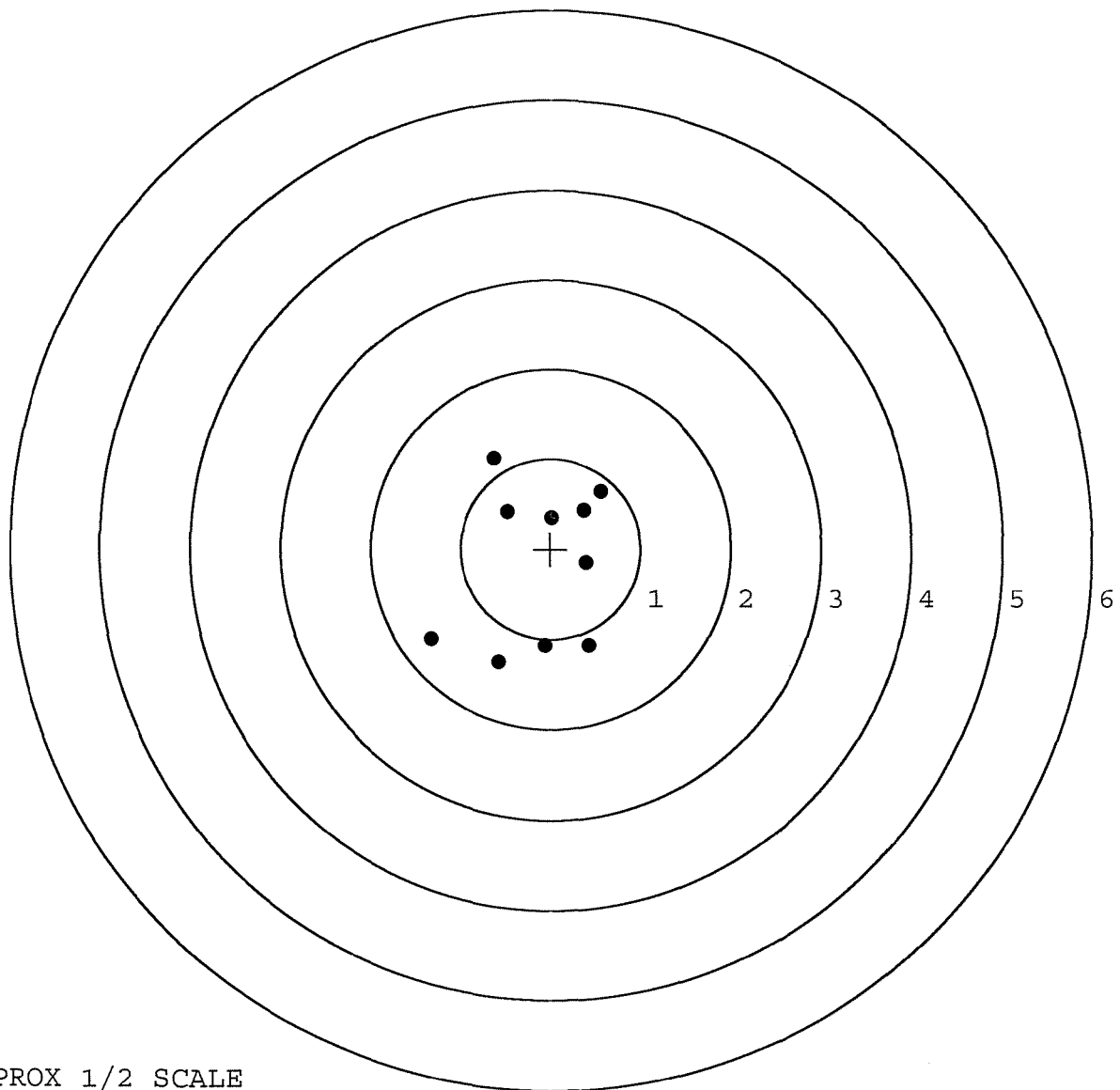
TARGET APPROX 1/2 SCALE

BARBER - M24 0027670

SERIAL NUMBER: C6523414. __0
 TARGET NUMBER: 5
 FILE DATE: 05/04/2005
 FILE TIME: 06:42

POINT#	X	Y
1:	0.434	-1.067
2:	-0.064	-1.078
3:	-0.574	-1.258
4:	-1.331	-1.000
5:	0.405	-0.151
6:	0.566	0.638
7:	0.374	0.433
8:	0.007	0.344
9:	-0.481	0.412
10:	-0.627	1.001

X CENTROID: -0.129
 Y CENTROID: -0.173
 POA TO CENTROID: 0.216
 HORZ SPREAD: 1.897
 VERT SPREAD: 2.259
 GROUP SPREAD: 2.506
 MIN RADIUS: 0.534
 MAX RADIUS: 1.459
 MEAN RADIUS: 0.948
 # IN 1 IN DIAMETER: 0
 # IN 2 IN DIAMETER: 5
 # in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

R & E NUMBER	92459		
SERIAL NUMBER	C6523414		
LOG-IN DATE	2-4-05		
INSPECT AND VERIFY:			
OPERATION #	OPERATION NAME	DATE	INITIAL
550	DIS-ASSEMBLE GUN	4-1-05	RTZ
560 A	RE-BARREL	4-7-05	RTZ
B	DRILL AND TAP	4-11-05	TRW
575	ASSEMBLE	4-7-05	RTZ
600	PROOF	4-8-05	AE
605	CHECK HEADSPACE	4-8-05	AE
610	DIS-ASSEMBLE GUN	4-11-05	RTZ
612	MAGNAFLUX	OPERATOR	BS
615	ROLLMARK CALIBER	4-12-05	CW
618	ROTO-BLAST	4-18-05	LB
620	APPLY COATINGS	4-25-05	WJ
625 A	FINAL ASSEMBLY	5-3-05	RTZ
B	TRIGGER PULL TEST		
C	SAFETY "ON" FORCE	5-9-05	AE
D	SAFETY "OFF" FORCE	5-9-05	AC
E	FIRING PIN INDENT	5-9-05	AC
640	TARGET	5-4-05	TRW
655	FINAL INSPECT	5-9-05	AC
660	PACK	5-11-05	DA
		SHIP DATE	
QAR INSPECTION DATE			

GFM

CONTRACT # DAAA21-87-C-0086

Repair

GUN SERIAL # C6523414

OP. #	OP. NAME	READINGS	DATE	INIT
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		2/22/93	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		2/22/93	RW
	C) Inspect Ejector Hole for Chamfer		2/22/93	RW
	D) Oil Firing Pin Ass'y		2/22/93	RW
	E) Adjust Trigger Pull to Min Setting and Stake		2/22/93	RW

Op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			2/22/93	RW
	G) Safety Off Force	3	2.5	2.5			2/22/93	RW
	H) Trigger Pull Test & Retainability						2/22/93	RW
	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						2/22/93	RW
	P) Detach & Attach Scope 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						2/26/93	RW
655	Final Inspection							
	A) Headspace						2/26/93	RW
	B) Trigger Pull	2.62	2.75	2.64	2.59	2.62	2/26/93	RW
	C) Function						2/26/93	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. C6523414DATE 2/22/93TESTER RW

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.61	2.58	2.51		MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.66	2.56	2.49		
PULL #3	2.66	2.57	2.52		
PULL #4	2.66	2.55	2.58		
PULL #5	2.65	2.53	2.53		
TOTAL	13.24	12.79	12.63		
AVG.	2.65	2.56	2.53		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.15	3.12		
PULL #2	3.12	3.11		
PULL #3	3.06	3.11		
PULL #4	3.14	3.05		
PULL #5	3.10	3.13		
TOTAL	15.57	15.52		
AVG.	3.12	3.10		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.21	4.15		4.32
PULL #2	4.18	4.16		4.08
PULL #3	4.22	4.16		4.15
PULL #4	4.23	4.16		4.16
PULL #5	4.14	4.14		4.17
TOTAL	20.98	20.77		20.88
AVG.	4.20	4.15		4.18

RECEIVING AND ESTIMATING REPORT

COMMENTS

ORDER

R 93-02462

INITIAL FPS	CUSTOMER ORDER NO.	WOG 12 OF 30 W/10X SCOPE & DEPLOYMENT KIT M24			
DATE RECEIVED 01/25/93	DATE OPENED 01/25/93	DATE CODE DK 9-90	SERIAL NUMBER C6523414	NEW SERIAL NUMBER	MODEL AND GRADE 700 7-62 NATO
ACCESSORIES W/STUDS	W/SWIVELS	SOFT CASE	SCOPE BASE		

FROM:

MCHALE, EDWARD J CPT,SF
HSC 3RD BN 3RD SFG (A)
FT BRAGG NC 28307

SHIP TO:

MCHALE, EDWARD J CPT,SF
HSC 3RD BN 3RD SFG (A)
FT BRAGG NC
28307

CUST NO:073985 C.L.D L

ACCOUNT NUMBER	ACCOUNT NUMBER N/C	WRITE ☐	CLEAN/TEST	PROM. DATE	ESTIMATED	VIA UPS
GUN CONDITION ☐ NEW ☐ LIGHTLY WORN ☐ WORN ☐ VERY WORN ☐ UNREPAIRABLE ☐ MARRED				REPAIR CHARGE EXCISE TAX INSURANCE UPS PARCEL POST TOTAL		

CUSTOMER CONCERN	AMMO *	FUNCTION	FINISH	ACCURACY	FIT	INSPECT
CYCLE	A1	B1				
TRIGGER GROUP		B2			E1	F1
BOLT ASSY.		B3			E2	F2
BARREL ASSY.		B4		D1	E3	F3
REC. ASSY.		B5		D2	E4	F4
WOOD			C1	D3	E5	F5
METAL			C2			

MAIN FAULT

PARTS	COMMENTS					
	REPAIRMAN	PROOF	CLEAN	TEST	TARGET	PATTERN
	GALLERY TESTER	DATE	DATE	DATE	DATE	DATE

RD6925 REV. 1/92

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

BARBER - M24 002789527714

Remington
REMINGTON & CO. NEW YORK, N.Y.
REG. U.S. PAT. & TM. OFF.

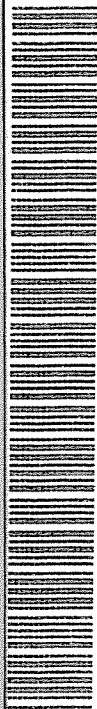
Model 700™ M24

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

SERIAL NO.
C6523414

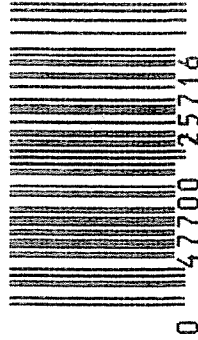
ORDER NO.
5716

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



5716 C6523414

UPC



0 47700 25716 7

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6523414

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action 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	90	RW
612	Magnaflux Barrel Action		9-25-90	KR
	Magnaflux Bolt		9-25-90	KR
615	Rollmark Caliber		9-25-90 L.S.	()
617	Drill and Tap Sight Holes		9-25-90	FB
618	Polish Barrel RB		9/28/90	WB
620	Apply Coatings (Barrel Action)		10-8-90	TH
	Apply Coating (Bolt)		10-8-90	TH
625	Final Assembly			
	A) Clean inside of Bolt Assembly		10/9/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/9/90	RW
	C) Inspect Ejector Hole for Chamfer		10/9/90	RW
	D) Oil Firing Pin Ass'y		10/9/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		10/30/90	JH

-BARBER - M24 0027678

op. #	OP. NAME	READINGS					DATE	INIT
625 nt.	F) Safety On Force	4 1/4	4 1/4	4 1/4			10/31/90	WLB
	G) Safety Off Force	2 1/4	2 1/4	2 1/4			10/31/90	WLB
	H) Trigger Pull Test & Retainability						10/30/90	WLB
	I) Firing Pin Indent	.0205	.021	.0205			10/31/90	WLB
	J) Assemble Stock						10/31/90	RW
	K) Assemble Swivel Studs						3/10/90	WLB
	L) Attach Front and Rear Sight Assemblies						10/31/90	RW
	M) Iron Sight Alignment						10/31/90	RW
	N) Detach Front & Rear Sights & place in numbered container						10/31/90	RW
	O) Attach Scope to Rifle						10/31/90	RW
	P) Detach & Attach Scope 20 Times						10/31/90	RW
640	Gallery Target & Test						10-31-90	KT
	A) Time						10-31-90	KT
	B) Malfunctions						10-31-90	KT
	C) Pierced Primers						10-31-90	KT
	D) Optical Clarity of Scope						10-31-90	KT
645	Inspect for Live Ammo						10-31-90	KT
655	Final Inspection						3/10/90	WLB
	A) Headspace						3/10/90	WLB
	B) Trigger Pull	239	242	220	227	219	3/10/90	WLB
	C) Function						3/10/90	WLB
660	Pack						12-17-90	DH

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C6523414

DATE 10/30/90

TESTER JR

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.32	2.50	2.45	2.39	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.21	2.42	2.38	2.42	
PULL #3	2.31	2.43	2.44	2.20	
PULL #4	2.45	2.44	2.32	2.27	
PULL #5	2.42	2.49	2.50	2.19	
TOTAL	11.71	12.28	12.09		
AVG.	2.342	2.456	2.418		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.39	3.30		
PULL #2	3.29	3.36		
PULL #3	3.26	3.32		
PULL #4	3.34	3.13		
PULL #5	3.35	3.30		
TOTAL	16.63	16.41		
AVG.	3.326	3.282		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.33	4.50		4.52
PULL #2	4.42	4.28		4.41
PULL #3	4.51	4.42		4.11
PULL #4	4.47	4.48		4.46
PULL #5	4.52	4.48		4.18
TOTAL	22.25	22.16		21.68
AVG.	4.45	4.432		4.336

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6523414
1 Nov 1990

CENTROIDAL DISTANCES

0 TO 1	.105233
1 TO 2	.185626
1 TO 3	.265424
1 TO 4	.343006
1 TO 5	.396505

4 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0916
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0516
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .105134
THE AMR FOR THIS RIFLE IS: 1.074

1 Nov 1980

FILE:/PATTERNING/CENTERFIRE_PATT/06523414

CENTERFIRE PATTERNS

1

POA

1in circle

2in circle

3in circle

OF SHOTS = 10

IN CIR

1in = 1

2in = 5

3in = 8

HS = 2.035

VS = 3.301

GS = 3.326

CENTROID *

PATTERN #	1	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.727	.744	.660
MINIMUM X	-1.308	-1.291	-1.375
MAXIMUM Y	1.475	1.272	1.416
MINIMUM Y	-1.826	-1.124	-1.980
CENTROID X	.105	.088	.172
CENTROID Y	.007	.210	.066
POA TO CENTROID in.	.105	.227	.185
MIN RADIUS	.384	.497	.388
MEAN RADIUS	1.036	.950	.859
MAX RADIUS	1.832	1.583	1.577
HORIZONTAL SPREAD	2.035	2.035	2.035
VERTICAL SPREAD	3.301	2.396	2.396
EXTREME SPREAD	3.326	2.445	2.441
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	8		

1 May 1998

FILE:/PATTERNING/CENTERFIRE_PATT/06523414

CENTERFIRE PATTERNS

2

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS= 10

IN CIR

1 in = 1

2 in = 4

3 in = 9

HS= 2.730

VS= 2.422

GS= 2.801

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.956	.759	.658
MINIMUM X	:	-1.774	-.801	-.586
MAXIMUM Y	:	1.225	1.239	1.213
MINIMUM Y	:	-1.197	-1.183	-1.028
CENTROID X	:	.046	.243	.344
CENTROID Y	:	-.169	-.183	-.338
POA TO CENTROID in.	:	.175	.305	.482
MIN RADIUS	:	.386	.543	.561
MEAN RADIUS	:	1.056	.954	.863
MAX RADIUS	:	1.779	1.476	1.237
HORIZONTAL SPREAD	:	2.730	1.560	1.244
VERTICAL SPREAD	:	2.422	2.422	2.241
EXTREME SPREAD	:	2.801	2.449	2.260
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		9	

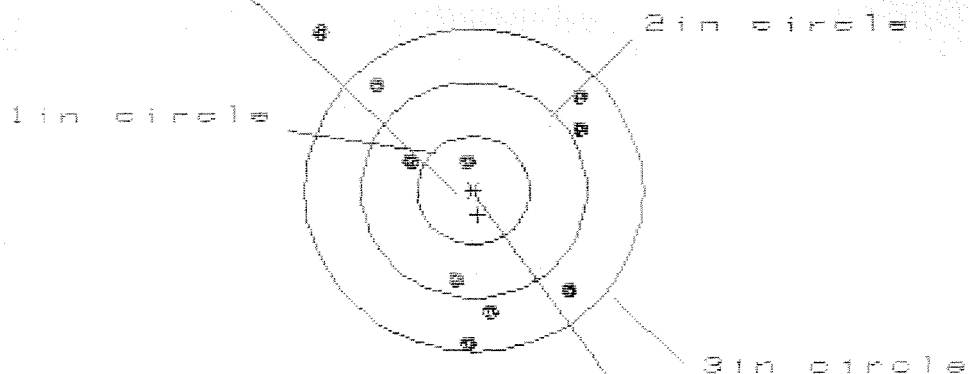
1 May 1990

FILE:/PATTERNING/CENTERFIRE_PATT/06523414

CENTERFIRE PATTERNS

3

POA



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 3

3 in = 6

HS= 2.288

VS= 2.898

GS= 3.227

CENTROID *

PATTERN #	3	3	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.980	.834	.808
MINIMUM X	-1.308	-1.017	-1.043
MAXIMUM Y	1.467	1.134	.976
MINIMUM Y	-1.431	-1.268	-1.126
CENTROID X	-.042	.104	.130
CENTROID Y	.228	.065	.223
POA TO CENTROID in.	.231	.122	.258
MIN RADIUS	.239	.433	.308
MEAN RADIUS	1.108	1.007	.961
MAX RADIUS	1.966	1.523	1.428
HORIZONTAL SPREAD	2.288	1.851	1.851
VERTICAL SPREAD	2.898	2.402	2.102
EXTREME SPREAD	3.227	2.566	2.566
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	3		
NUMBER IN THREE INCH CIRCLE =	9		

1 Nov 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6523414

CENTERFIRE PATTERNS

4

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS = 10

IN CIR

1in = 3

2in = 5

3in = 6

HE = 3.287

VS = 3.657

GS = 3.894

PATTERN #

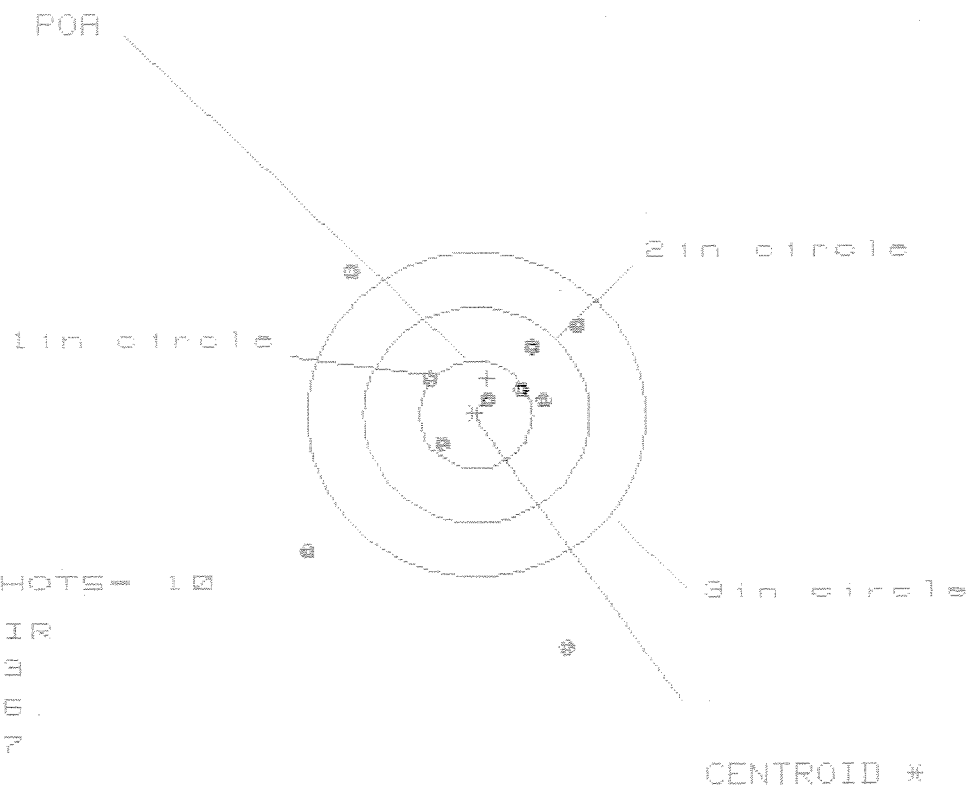
4

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.837	1.891	.573
MINIMUM X	-1.450	-1.396	-1.160
MAXIMUM Y	2.206	1.218	1.222
MINIMUM Y	-1.451	-1.206	-1.202
CENTROID X	.448	.394	.158
CENTROID Y	.009	-.236	-.240
POA TO CENTROID in.	.448	.460	.287
MIN RADIUS	.186	.204	.403
MEAN RADIUS	1.156	1.024	.937
MAX RADIUS	2.259	1.891	1.328
HORIZONTAL SPREAD	3.287	3.287	1.733
VERTICAL SPREAD	3.657	2.424	2.424
EXTREME SPREAD	3.894	3.294	2.575
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		6	

1 Nov 1990

FILE:/PATTERNING/CENTERFIRE_PATT/08523414

CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1in = 3

2in = 6

3in = 7

HS= 2.405

VS= 3.421

GS= 3.892

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.940	1.024	.852
MINIMUM X	-1.465	-1.381	-1.189
MAXIMUM Y	1.295	1.059	.868
MINIMUM Y	-2.126	-1.531	-.670
CENTROID X	-.099	-.183	-.011
CENTROID Y	-.333	-.097	.094
POA TO CENTROID in.	.348	.208	.095
MIN RADIUS	.205	.250	.291
MEAN RADIUS	1.013	.853	.671
MAX RADIUS	2.256	2.061	1.472
HORIZONTAL SPREAD	2.405	2.405	2.041
VERTICAL SPREAD	3.421	2.590	1.538
EXTREME SPREAD	3.892	3.232	2.086
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		7	

RECEIVING AND ESTIMATING REPORT

BARBER - M24-0027686

COMMENTS

ORDER

R 93-02462

INITIAL FPS	CUSTOMER ORDER NO.		WDG 12 OF 30 W/10X SCOPE & DEPLOYMENT KIT M24			
DATE RECEIVED 01/25/93	DATE OPENED 01/25/93	DATE CODE DK 9-90	SERIAL NUMBER C6523414	NEW SERIAL NUMBER	MODEL AND GRADE 700 7-62	NATO
ACCESSORIES W/STUDS		W/SWIVELS		SOFT CASE	SCOPE BASE	

FROM:

MCHALE, EDWARD J CPT, SF
HSC 3RD BN 3RD SFG (A)
FT BRAGG NC 28307

SHIP TO:

MCHALE, EDWARD J CPT, SF
HSC 3RD BN 3RD SFG (A)
FT BRAGG NC 28307

CUST NO: 073985 C.O.D L

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

GUN CONDITION	REPAIR CHARGE
☐ NEW	EXCISE
☐ LIGHTLY WORN	TAX
☐ WORN	INSURANCE
☐ VERY WORN	UPS
☐ UNREPAIRABLE	PARCEL POST
☐ MARRED	TOTAL

CUSTOMER CONCERN	AMMO	FUNCTION	FINISH	ACCURACY	FIT	INSPECT
CYCLE	A1	B1				
TRIGGER GROUP		B2			E1	F1
BOLT ASSY.		B3			E2	F2
BARREL ASSY.		B4		D1	E3	F3
REC. ASSY.		B5		D2	E4	F4
WOOD			C1	D3	E5	F5
METAL			C2			

MAIN FAULT Rust on Gun

PARTS	COMMENTS
Trigger Assy. - 96024	Zinc phosphate Scope Base, Scope Rings, Swivels & Swivel Studs Re-powder Coat Barrel Assy - 96001
REPAIRMAN	PROOF
Rw	
GALLERY TESTER	DATE
Rw	2/26/93
CLEAN	TEST
	✓
TARGET	PATTERN

OFFICE COPY

RD6925 REV. 1/92

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

BARBER - M24 0027686 27725