

C6611799

MODEL 700™ M24

Model **S&S**™

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

Remington

Repair Inquiry

Repair Number: RE00142142

Serial: C6611799 Model M24 SWS Center Fire
Caliber: 7.62 NATO

Repairman:

Status:

Closed 2/26/2008 7:44:56 AM

Verify Repair

Address Information

Customer:

☒ Received From

Return To:

☐ Received From

Name: C/TRP 1/73 RECON

C/TRP 1/73 RECON

Address 1: C/O SGT. MEYER-SNIPER SECTION

C/O SGT. MEYER-SNIPER SECTION

Address 2: 3-1722 MALVESTI STREET PO Box:

3-1722 MALVESTI STREET PO Box:

City: FORT BRAGG

FORT BRAGG

State: NC

Zip Code: 28310

Country: US

State: NC

Zip Code: 28310

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
A008	With Swivel	3
A010	Hard Case	1
A026	Scope	1
A045	Bi Pod	1
A057	Frt and Rear Sgt Base	1

Repair Search

Refresh

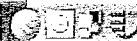
Close

naglej

2/26/2008

7:47 AM

NUM



Serial Number: C6611799

Model: M24 SWS



RE00142142

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6611799.___0
FILE DATE AND TIME: 04/04/2008 10:00

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.060
The Average Y Centroid of the Five Target Set:	0.014
The Average Point of Impact of the Five Target Set:	0.062
The Average Mean Radius of the Five Target Set:	0.709
The Distance from POA to Centroid Target #1:	0.222
The Distance from Centroid Target #2 to Centroid Target #1:	0.359
The Distance from Centroid Target #3 to Centroid Target #1:	0.258
The Distance from Centroid Target #4 to Centroid Target #1:	0.454
The Distance from Centroid Target #5 to Centroid Target #1:	0.708

SERIAL NUMBER: C6611799. __ 0

TARGET NUMBER: 1

FILE DATE: 04/04/2008

FILE TIME: 10:00

X CENTROID: -0.092

Y CENTROID: 0.201

POA TO CENTROID: 0.222

HORZ SPREAD: 2.804

VERT SPREAD: 2.127

GROUP SPREAD: 3.181

MIN RADIUS: 0.266

MAX RADIUS: 1.893

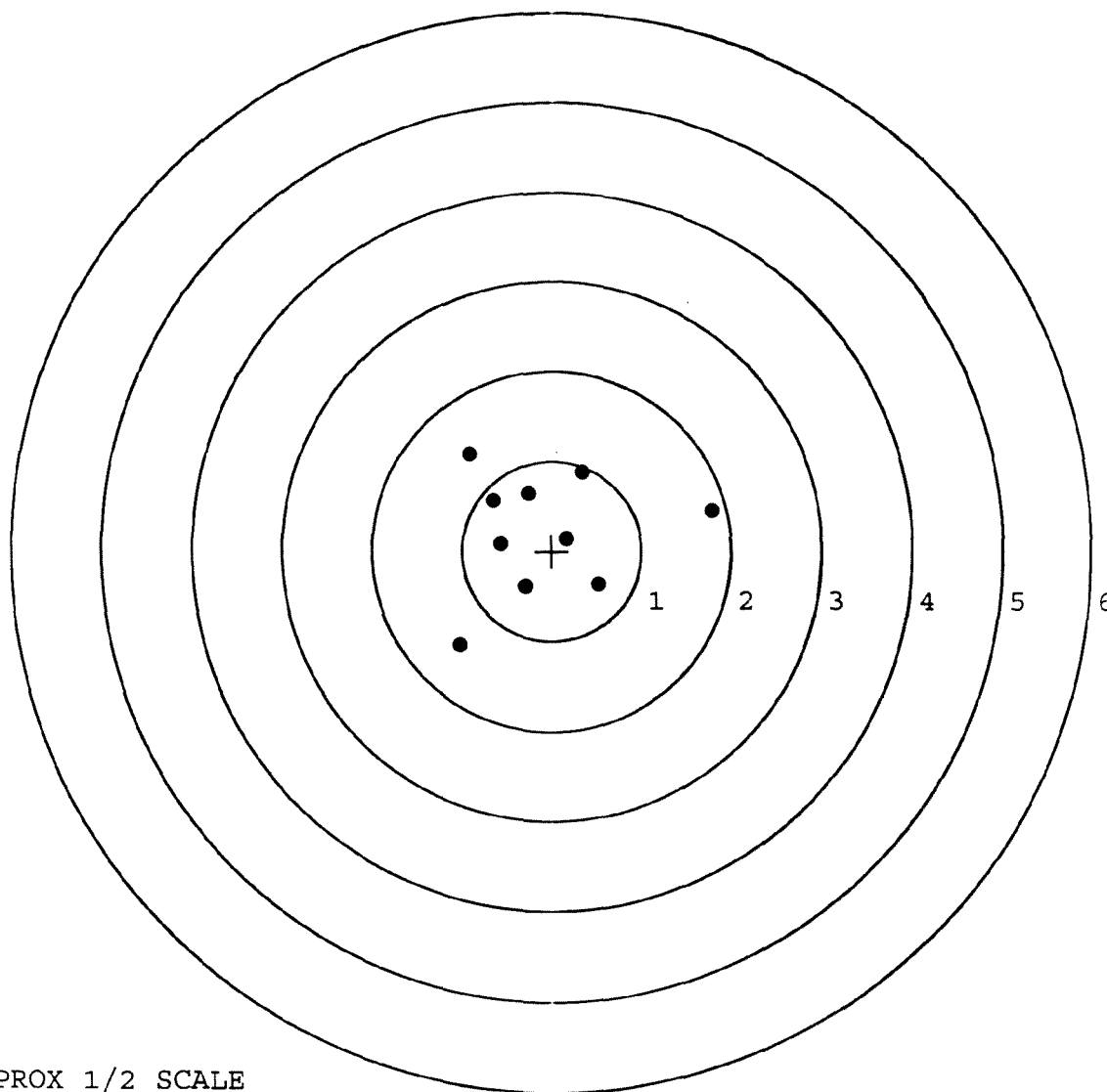
MEAN RADIUS: 0.884

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 8

POINT#	X	Y
1:	-0.924	1.076
2:	-0.659	0.562
3:	-0.266	0.646
4:	0.341	0.877
5:	0.167	0.140
6:	-0.296	-0.394
7:	-1.020	-1.051
8:	0.523	-0.377
9:	1.784	0.451
10:	-0.572	0.084



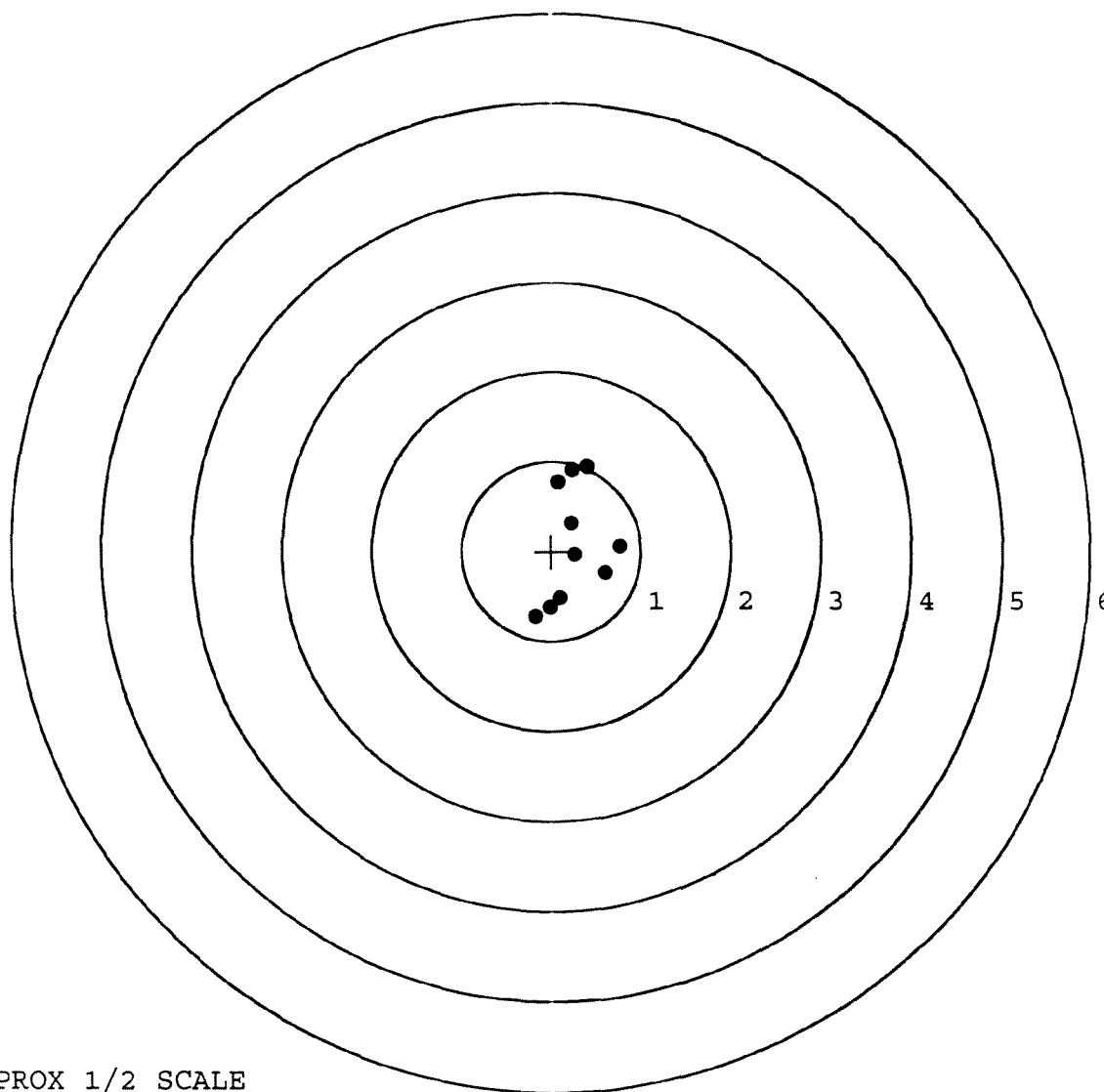
TARGET APPROX 1/2 SCALE

BARBER - M24 0036153

SERIAL NUMBER: C6611799. __0
 TARGET NUMBER: 2
 FILE DATE: 04/04/2008
 FILE TIME: 10:00

POINT#	X	Y
1:	0.075	0.768
2:	0.237	0.905
3:	0.401	0.946
4:	0.225	0.315
5:	0.263	-0.042
6:	0.603	-0.237
7:	0.770	0.063
8:	0.098	-0.522
9:	-0.014	-0.633
10:	-0.186	-0.727

X CENTROID: 0.247
 Y CENTROID: 0.084
 POA TO CENTROID: 0.261
 HORZ SPREAD: 0.956
 VERT SPREAD: 1.673
 GROUP SPREAD: 1.773
 MIN RADIUS: 0.127
 MAX RADIUS: 0.919
 MEAN RADIUS: 0.607
 # IN 1 IN DIAMETER: 3
 # IN 2 IN DIAMETER: 10
 # in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

BARBER - M24 0036154

SERIAL NUMBER: C6611799. __0

TARGET NUMBER: 3

FILE DATE: 04/04/2008

FILE TIME: 10:00

X CENTROID: -0.024

Y CENTROID: 0.450

POA TO CENTROID: 0.451

HORZ SPREAD: 1.754

VERT SPREAD: 1.709

GROUP SPREAD: 1.755

MIN RADIUS: 0.124

MAX RADIUS: 1.191

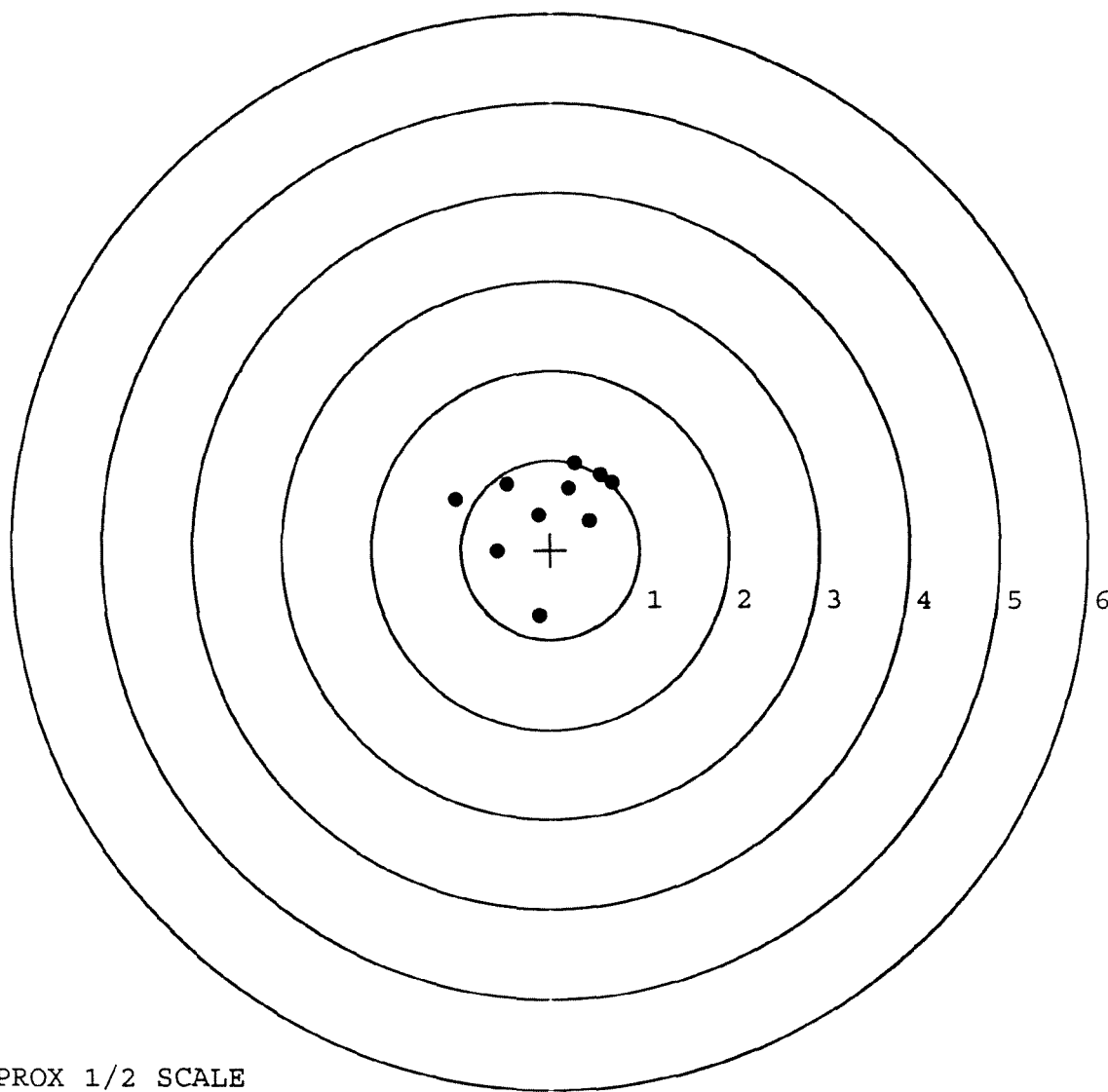
MEAN RADIUS: 0.653

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.275	0.972
2:	0.564	0.840
3:	0.200	0.687
4:	0.688	0.754
5:	0.436	0.324
6:	-0.488	0.729
7:	-0.134	0.393
8:	-1.066	0.562
9:	-0.594	-0.022
10:	-0.122	-0.737



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6611799. __ 0

TARGET NUMBER: 4

FILE DATE: 04/04/2008

FILE TIME: 10:00

X CENTROID: -0.369

Y CENTROID: -0.158

POA TO CENTROID: 0.401

HORZ SPREAD: 1.849

VERT SPREAD: 1.766

GROUP SPREAD: 1.944

MIN RADIUS: 0.110

MAX RADIUS: 1.061

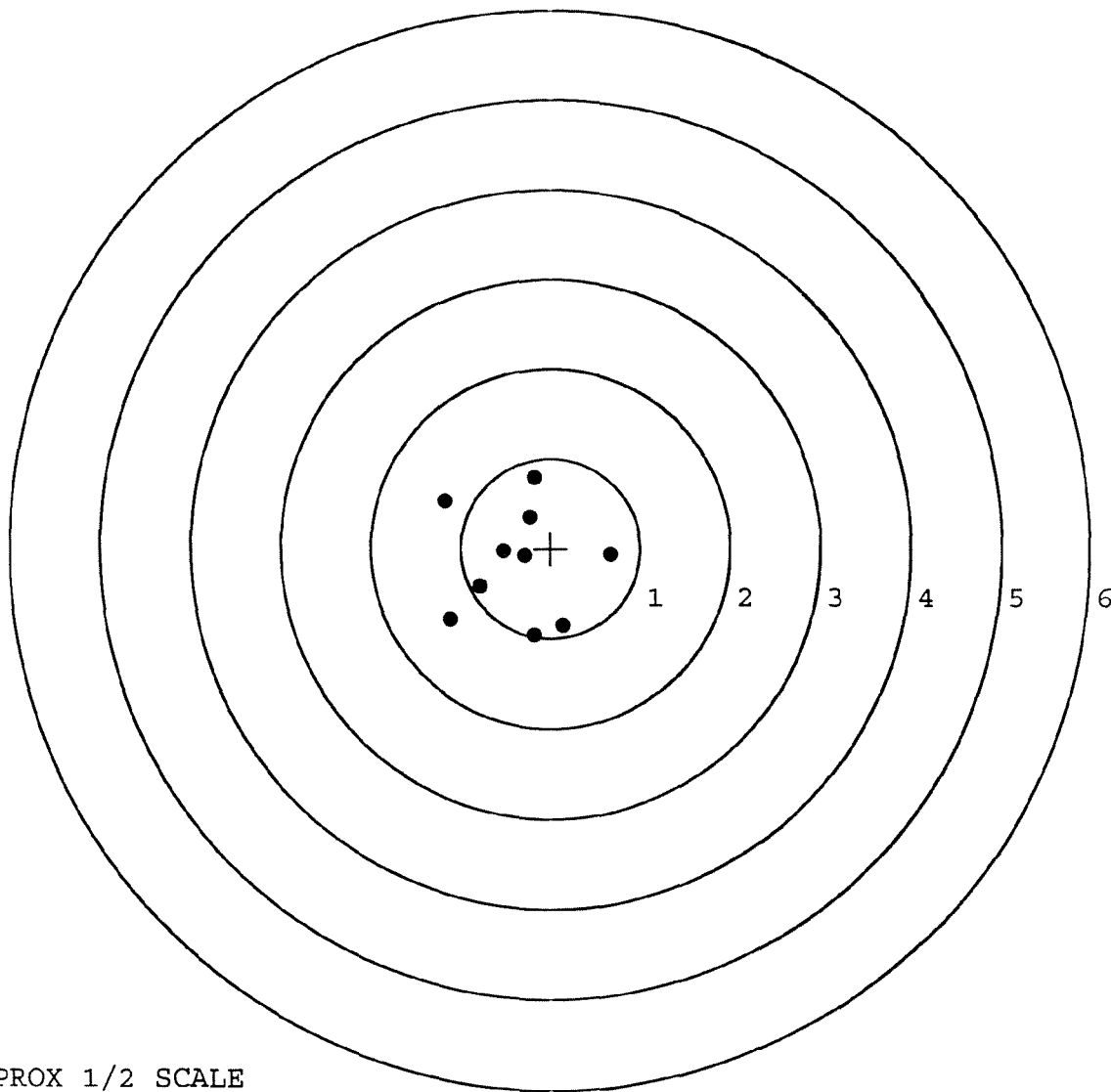
MEAN RADIUS: 0.709

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.182	0.793
2:	-0.238	0.351
3:	-0.290	-0.081
4:	-0.527	-0.040
5:	-1.179	0.527
6:	0.670	-0.072
7:	-0.788	-0.429
8:	-1.115	-0.798
9:	-0.181	-0.973
10:	0.142	-0.861



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6611799. __ 0

TARGET NUMBER: 5

FILE DATE: 04/04/2008

FILE TIME: 10:00

X CENTROID: -0.062

Y CENTROID: -0.506

POA TO CENTROID: 0.510

HORZ SPREAD: 2.159

VERT SPREAD: 1.432

GROUP SPREAD: 2.425

MIN RADIUS: 0.055

MAX RADIUS: 1.476

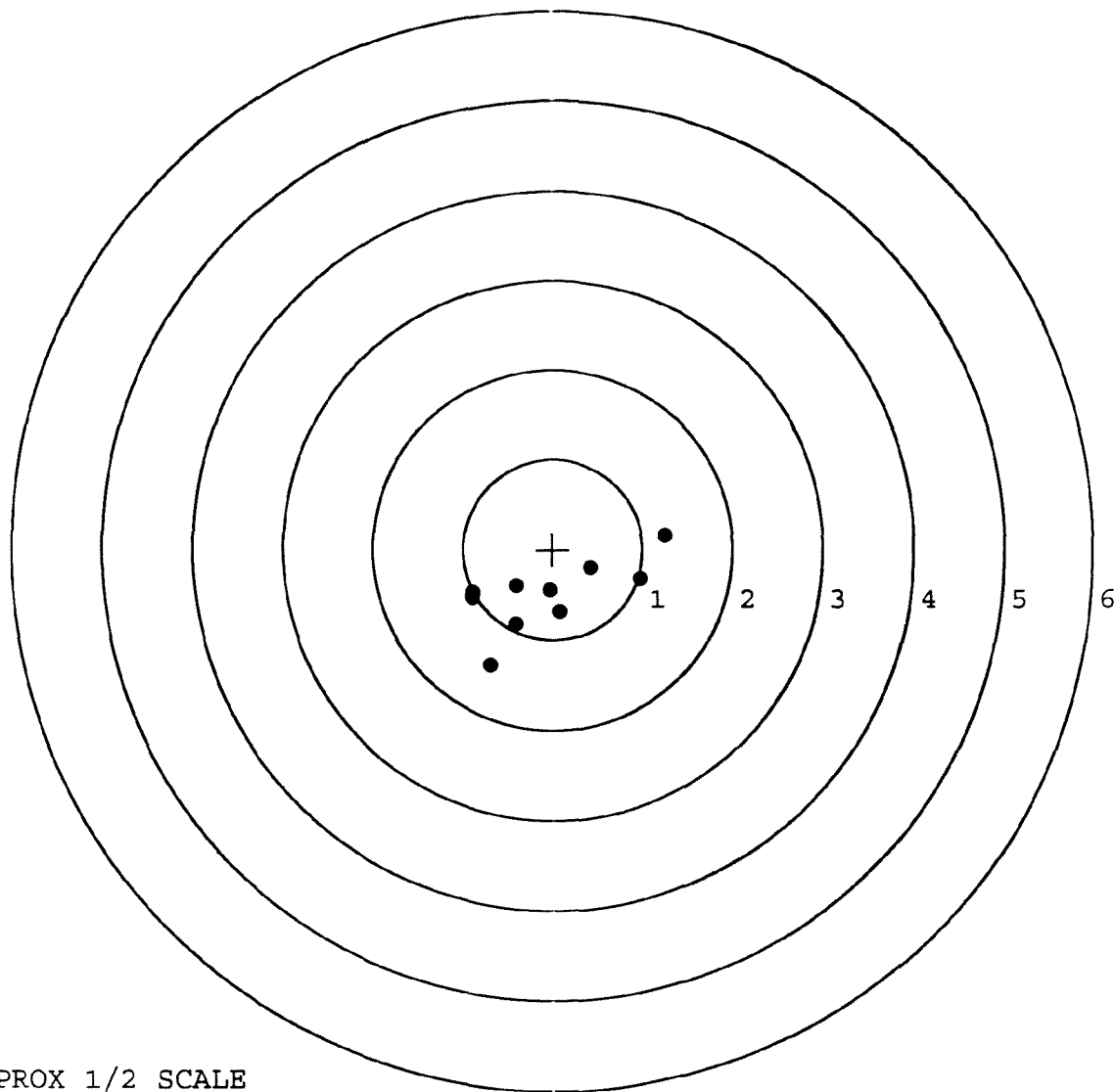
MEAN RADIUS: 0.691

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.900	-0.537
2:	-0.413	-0.405
3:	-0.035	-0.459
4:	0.074	-0.700
5:	-0.417	-0.829
6:	-0.698	-1.281
7:	0.423	-0.201
8:	0.976	-0.329
9:	1.259	0.151
10:	-0.891	-0.474



TARGET APPROX 1/2 SCALE

M-24 INSPECTION CHECKLIST
 CONTRACT #: DAAE-20-02-C-0149

Deployment
KIT

R & E NUMBER 142142SERIAL NUMBER C6611799LOG-IN DATE 2-26-08

OPERATION #	OPERATION NAME	DATE	INITIAL
500	DIS-ASSEMBLE GUN	3-27-08	RTZ
505	RE-BARREL	3-28-08	RTZ
560	ASSEMBLE	3-28-08	TRLW
600	PROOF	3-28-08	TRLW
605	CHECK HEADSPACE	3-28-08	TRLW
610	DIS-ASSEMBLE GUN		
612	MAGNAFLUX	3/31/08	unus
510	DRILL AND TAP	3-28-08	Fm
615	ROLLMARK CALIBER	3-31-08	CW
618	ROTO-BLAST	3/31/08	FW
620	APPLY COATINGS	4/3/08	HP
625	FINAL ASSEMBLY	4-4-08	RTZ
640	FUNCTION TEST AND	4-4-08	SD
650	TARGET	4-4-08	SD
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
670	FINAL INSPECTION	4-4-08	TRLW
	A) HEADSPACE	PASS FAIL	4-8-08 Fm
	B) TRIGGER PULL	2.23 2.18 2.19 2.17 2.18	4/7/08 Fm
680	F) SAFETY ON FORCE	4- 4- 4-	4/8/08 Fm
	G) SAFETY OFF FORCE	3- 3- 3-	4/8/08 Fm
	I) FIRING PIN INDENT	.022 .022 .022	4/8/08 Fm
690	PACK		4/14/08 Fm

Repair Inquiry

Repair Number: RE00092998

Serial: C6611799 Model: M24 SWS - Center Fire
Caliber: 7.62 NATO Produced: 03/20/1991

Repairman:

Status:

Closed: 2/11/2005 7:31:47 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
A052	Fit and Rear Sgt Base	1

Repair Search

Refresh

Close

logoff

2/14/2005

9:13 AM

CAPS

NUM

INS

SCALE

start

5

2

3

Arms Services

Serial Number:

C6611799

Model: M24 SWS



RE00092998

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50 LBS (plus or minus 0.50 LBS)

3.00 LBS (plus or minus 0.75 LBS)

4.00 LBS (plus or minus 1.00 LBS)

SERIAL NO. _____

DATE 2-18-05TESTER TRLW

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.18	2.20		2.30	
PULL #2	2.12	2.33		2.19	
PULL #3	2.33	2.18		2.15	
PULL #4	2.31	2.20		2.24	
PULL #5	2.44	2.09		2.24	
TOTAL	11.38	11.00		11.12	
AVERAGE	2.27	2.20		2.22	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.01	3.06		
PULL #2	3.09	3.28		
PULL #3	3.19	3.36		
PULL #4	3.18	3.32		
PULL #5	3.17	3.03		
TOTAL	15.64	16.05		
AVERAGE	3.12	3.21		

	4.00 LBS INITIAL	4.00 LBS AFTER 20 CYCLES	MAX SETTING GREATER THAN 4 LBS	RESET TO 4 LBS FOR TARGET & ACCURACY
PULL #1	4.43	4.18		4.45
PULL #2	4.43	4.24		4.53
PULL #3	4.49	4.28		4.52
PULL #4	4.47	4.18		4.53
PULL #5	4.50	4.18		4.55
TOTAL	22.32	21.06		22.58
AVERAGE	4.46	4.21		4.51

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6611799.___0

FILE DATE AND TIME: 04/01/2005 09:03

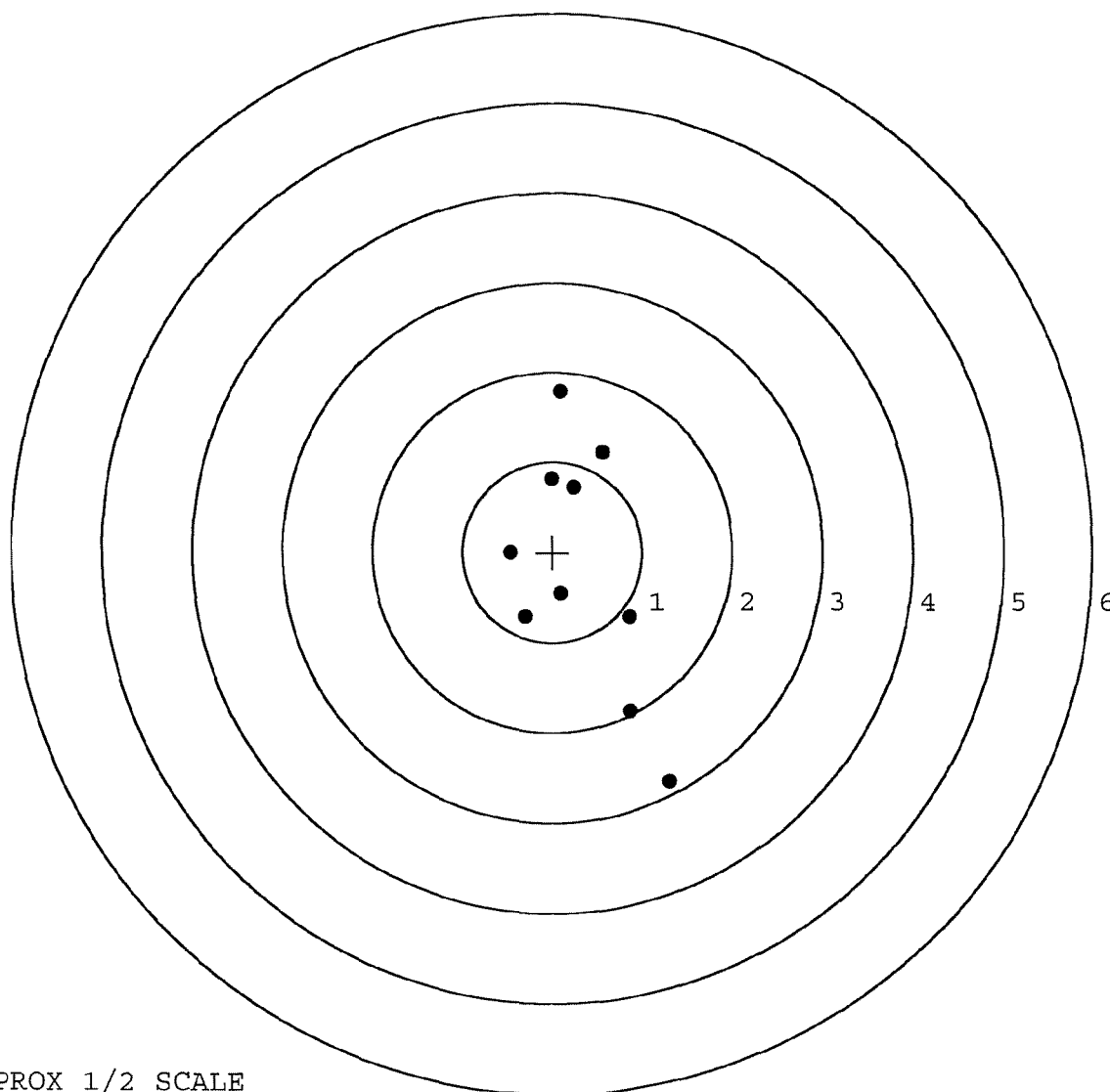
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.135
The Average Y Centroid of the Five Target Set:	0.166
The Average Point of Impact of the Five Target Set:	0.214
The Average Mean Radius of the Five Target Set:	1.083
The Distance from POA to Centroid Target #1:	0.371
The Distance from Centroid Target #2 to Centroid Target #1:	0.435
The Distance from Centroid Target #3 to Centroid Target #1:	0.658
The Distance from Centroid Target #4 to Centroid Target #1:	0.539
The Distance from Centroid Target #5 to Centroid Target #1:	0.437

SERIAL NUMBER: C6611799. __ 0
 TARGET NUMBER: 1
 FILE DATE: 04/01/2005
 FILE TIME: 09:03

POINT#	X	Y
1:	0.089	1.784
2:	0.563	1.107
3:	-0.008	0.812
4:	0.234	0.716
5:	-0.472	-0.011
6:	0.092	-0.465
7:	-0.301	-0.714
8:	0.866	-0.719
9:	0.869	-1.764
10:	1.312	-2.553

X CENTROID: 0.324
 Y CENTROID: -0.181
 POA TO CENTROID: 0.371
 HORZ SPREAD: 1.784
 VERT SPREAD: 4.337
 GROUP SPREAD: 4.506
 MIN RADIUS: 0.367
 MAX RADIUS: 2.570
 MEAN RADIUS: 1.225
 # IN 1 IN DIAMETER: 1
 # IN 2 IN DIAMETER: 5
 # in 3 IN DIAMETER: 7



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6611799. __0

TARGET NUMBER: 2

FILE DATE: 04/01/2005

FILE TIME: 09:03

X CENTROID: -0.018

Y CENTROID: 0.088

POA TO CENTROID: 0.089

HORZ SPREAD: 3.011

VERT SPREAD: 2.891

GROUP SPREAD: 3.817

MIN RADIUS: 0.391

MAX RADIUS: 2.308

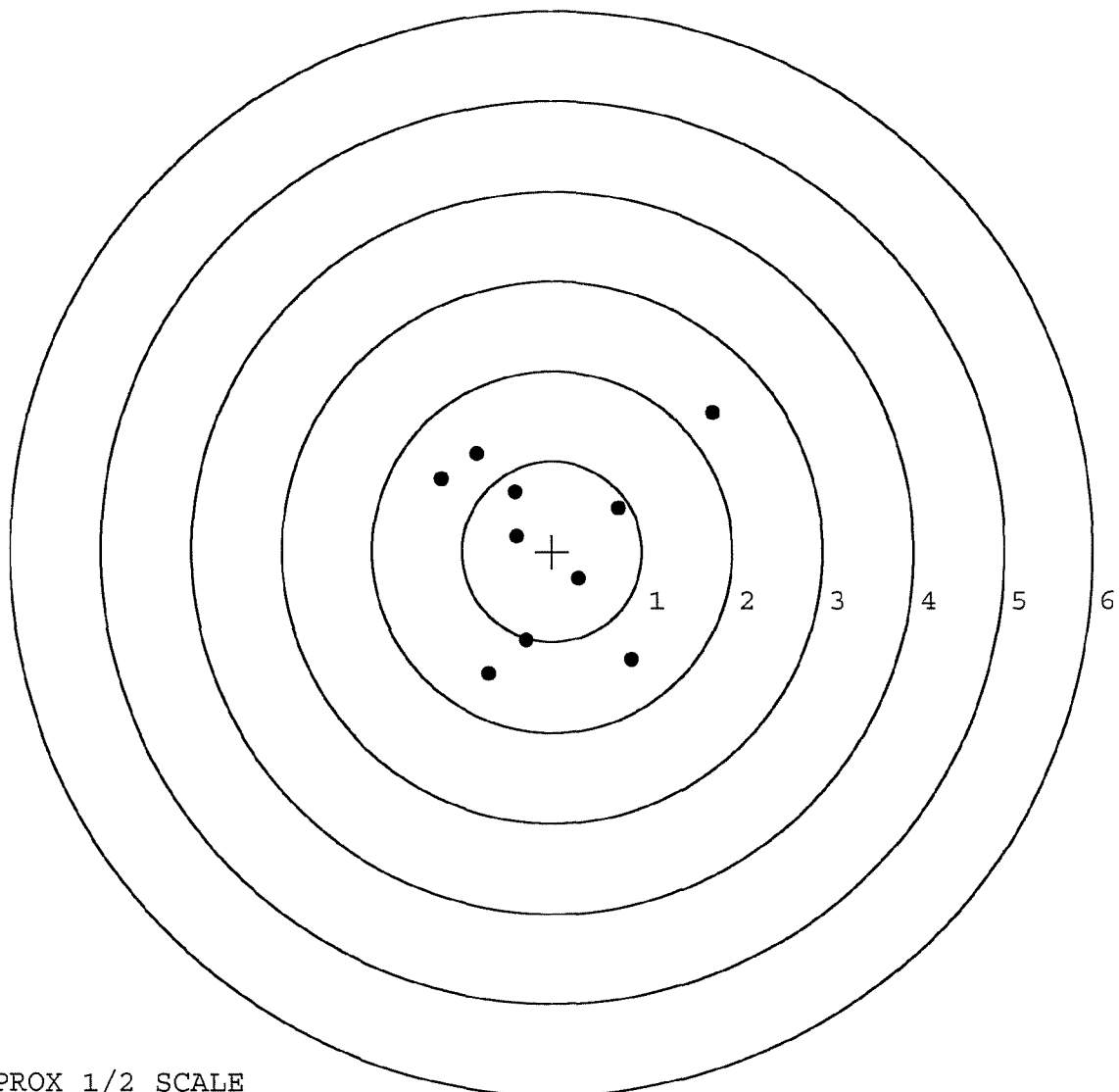
MEAN RADIUS: 1.174

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 4

in 3 IN DIAMETER: 7

POINT#	X	Y
1:	-0.835	1.084
2:	-1.229	0.805
3:	-0.416	0.663
4:	-0.400	0.168
5:	0.734	0.480
6:	0.298	-0.305
7:	-0.287	-0.989
8:	0.886	-1.206
9:	-0.711	-1.358
10:	1.782	1.533



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6611799. __0

TARGET NUMBER: 3

FILE DATE: 04/01/2005

FILE TIME: 09:03

X CENTROID: -0.093

Y CENTROID: 0.328

POA TO CENTROID: 0.341

HORZ SPREAD: 2.774

VERT SPREAD: 1.699

GROUP SPREAD: 2.912

MIN RADIUS: 0.450

MAX RADIUS: 1.733

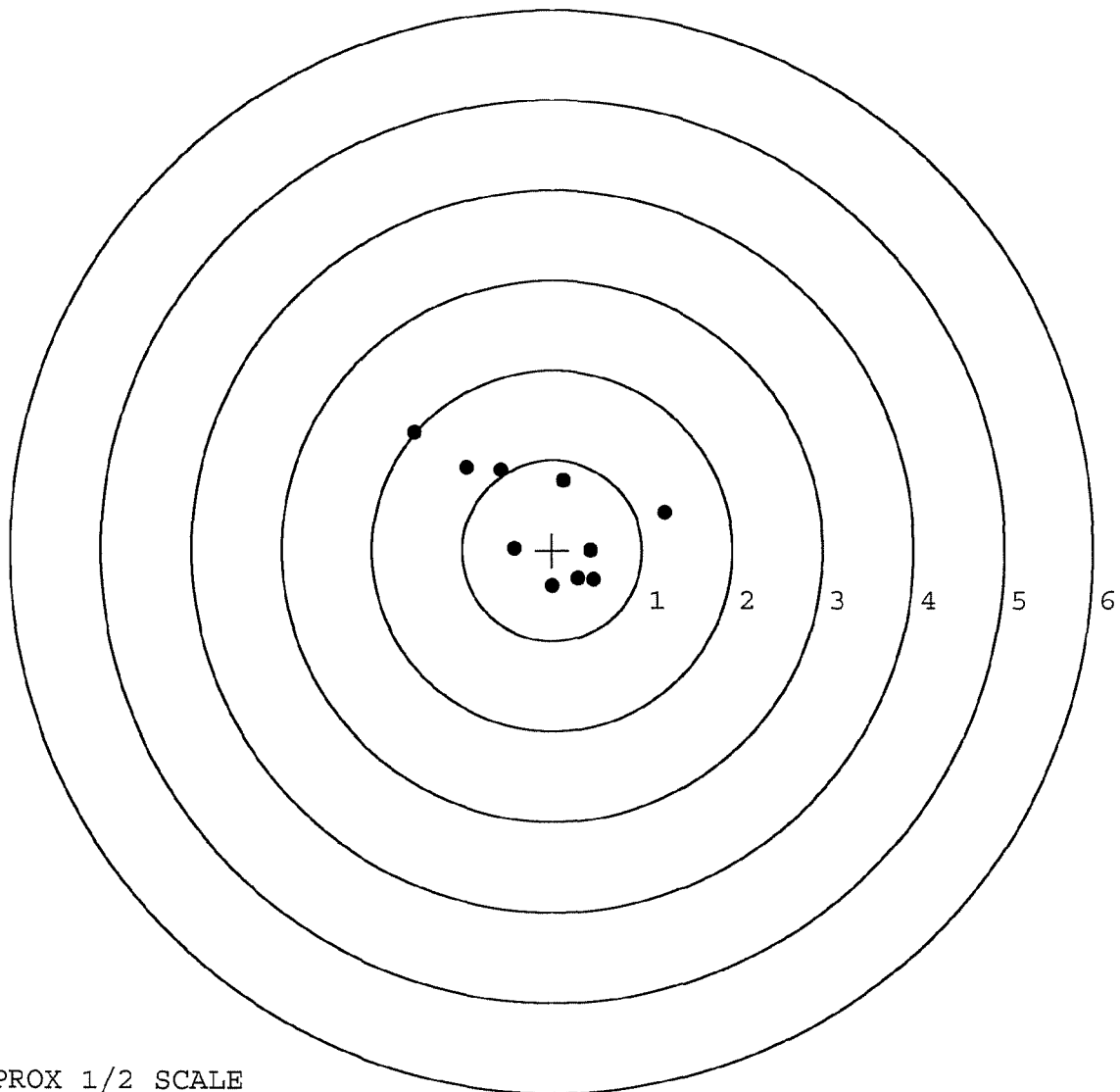
MEAN RADIUS: 0.875

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 9

POINT#	X	Y
1:	-1.527	1.301
2:	-0.957	0.911
3:	-0.578	0.889
4:	0.126	0.769
5:	-0.425	0.025
6:	1.247	0.415
7:	0.432	-0.001
8:	0.463	-0.321
9:	0.000	-0.398
10:	0.289	-0.309



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6611799. __0

TARGET NUMBER: 4

FILE DATE: 04/01/2005

FILE TIME: 09:03

POINT#	X	Y
1:	0.677	-1.850
2:	1.232	-0.840
3:	0.298	-0.966
4:	0.274	-0.422
5:	0.526	-0.001
6:	-0.913	0.944
7:	-0.135	0.854
8:	-0.057	1.210
9:	0.785	1.748
10:	-0.221	2.847

X CENTROID: 0.247

Y CENTROID: 0.352

POA TO CENTROID: 0.430

HORZ SPREAD: 2.145

VERT SPREAD: 4.697

GROUP SPREAD: 4.782

MIN RADIUS: 0.451

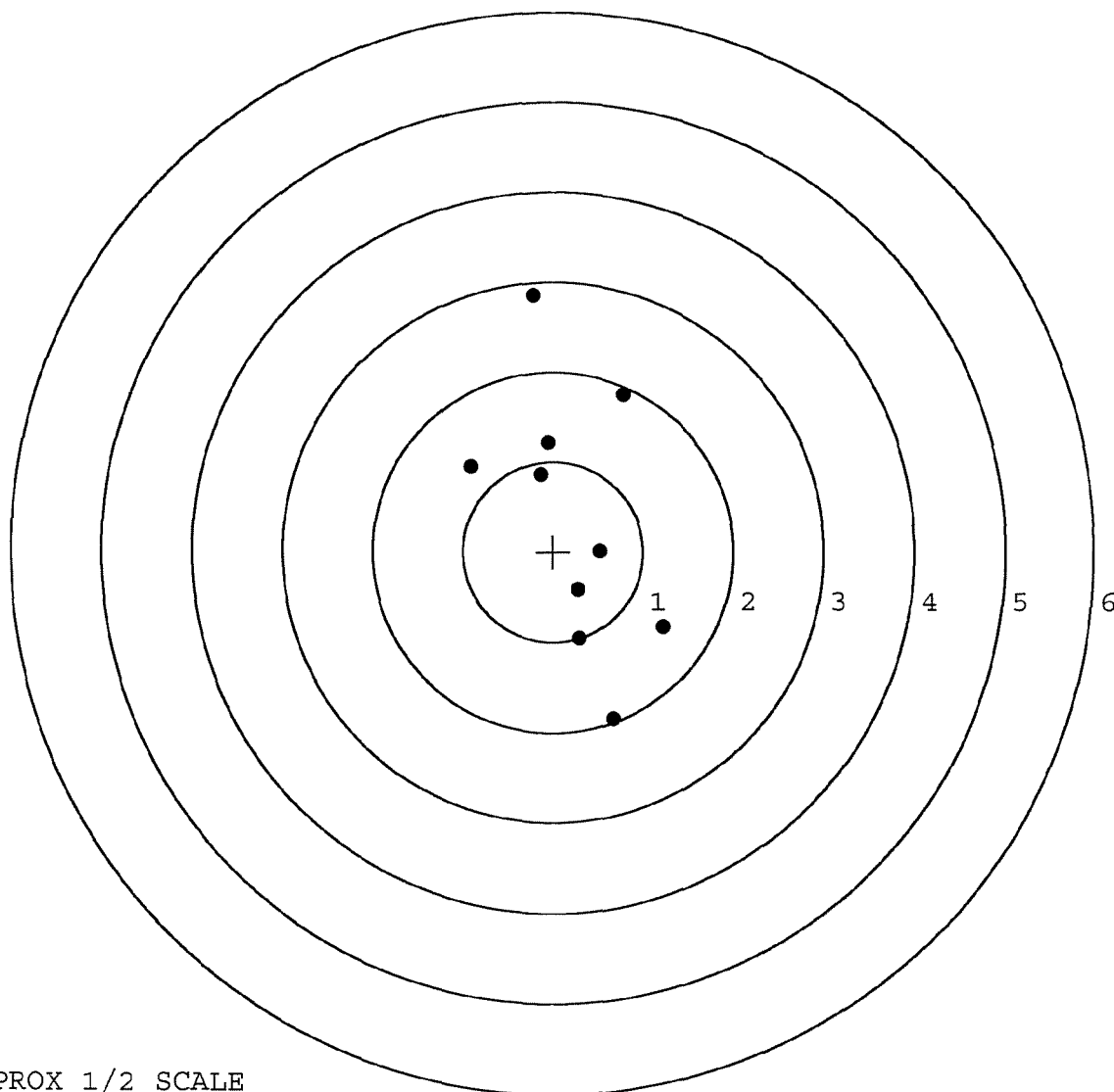
MAX RADIUS: 2.538

MEAN RADIUS: 1.321

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 4

in 3 IN DIAMETER: 7



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6611799. __0

TARGET NUMBER: 5

FILE DATE: 04/01/2005

FILE TIME: 09:03

POINT#	X	Y
1:	1.045	1.464
2:	-0.007	0.610
3:	-0.343	0.833
4:	-0.687	0.621
5:	-0.579	0.341
6:	0.183	0.050
7:	0.525	-0.135
8:	0.663	-0.470
9:	1.277	-0.031
10:	0.089	-0.851

X CENTROID: 0.217

Y CENTROID: 0.243

POA TO CENTROID: 0.326

HORZ SPREAD: 1.964

VERT SPREAD: 2.315

GROUP SPREAD: 2.505

MIN RADIUS: 0.196

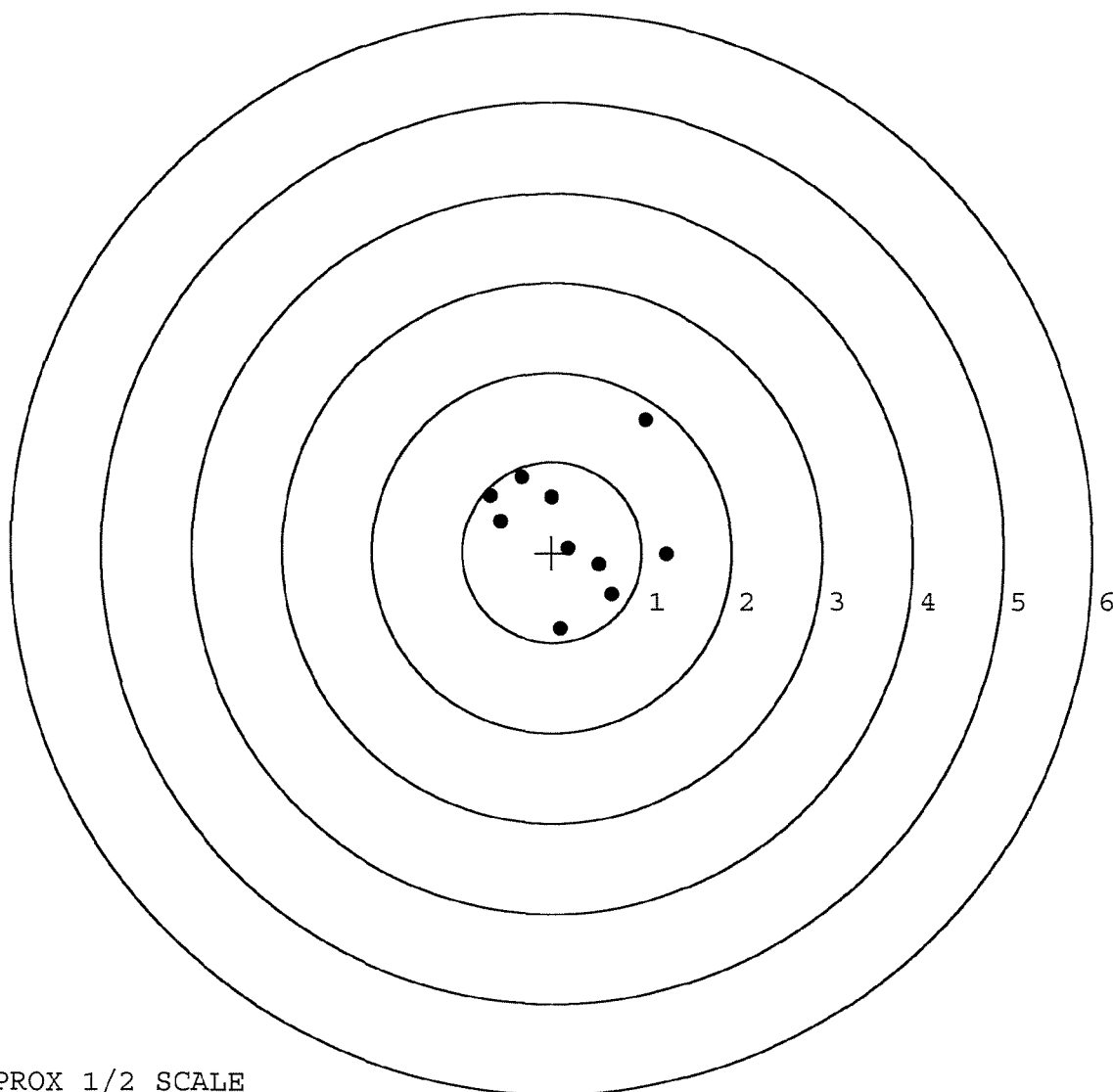
MAX RADIUS: 1.475

MEAN RADIUS: 0.822

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

M-24 INSPECTION CHECKLIST
CONTRACT #: DAAE-20-02-D-0127

R & E NUMBER	92998		
SERIAL NUMBER	06611799		
LOG-IN DATE	2-11-05		
INSPECT AND VERIFY:			
OPERATION #	OPERATION NAME	DATE	INITIAL
550	DIS-ASSEMBLE GUN	2-21-05	RTL
560 A	RE-BARREL	2-22-05	RTL
B	DRILL AND TAP	2-28-05	TRW
575	ASSEMBLE	2-23-05	RTL
600	PROOF	2-24-05	AC
605	CHECK HEADSPACE	2-24-05	AC
610	DIS-ASSEMBLE GUN	2-24-05	RTL
612	MAGNAFLUX	OPERATOR	AC
615	ROLLMARK CALIBER	3-1-05	CW
618	ROTO-BLAST	3-3-05	LB
620	APPLY COATINGS	3/6/05	HP
625 A	FINAL ASSEMBLY	3-31-05	RTL
B	TRIGGER PULL TEST	4-8-05	TRW
C	SAFETY "ON" FORCE	4-12-05	AC
D	SAFETY "OFF" FORCE	4-12-05	AC
E	FIRING PIN INDENT	4-12-05	AC
640	TARGET	4-1-05	TRW
655	FINAL INSPECT	4-12-05	AC
660	PACK	4-21-05	DA
		SHIP DATE	
		QAR INSPECTION DATE	

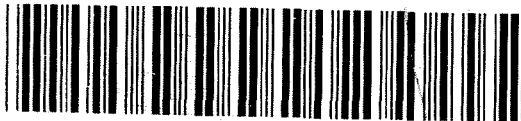
C-6611799

Repair Number: RE00002338		Serial: C6611793 Model 700 Center Fire Caliber: 7.62 NATO M-24 SWS		Repairman:																						
Verify Repair				Status:	New 1/12/00 7:58:53 AM																					
Address Information																										
Customer:		☒ Received From		Return To: ☐ Received From																						
Name: UNCSB-JSA		UNCSB-JSA																								
Address 1: UNIT 15162		UNIT 15162																								
Address 2:		PO Box:																								
City: APO		APO																								
State: AP Zip Code: 962510417 Country: US		State: AP Zip Code: 962510417 Country: US																								
FFL: ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐																										
Contact / Condition		Problems		Estimate																						
History / Status		Shipping / Billing																								
Contact Information Phone: Fax: Email: Comments:		Received Condition Fair Condition Notes: CSR Notes:		Accessories Received <table border="1"> <thead> <tr> <th>Code</th> <th>Desc</th> <th>Qty</th> </tr> </thead> <tbody> <tr> <td>A007</td> <td>With Studs</td> <td>2</td> </tr> <tr> <td>A008</td> <td>With Swivels</td> <td>2</td> </tr> <tr> <td>A016</td> <td>Scope Mounts</td> <td>2</td> </tr> <tr> <td>A017</td> <td>Scope Base</td> <td>2</td> </tr> <tr> <td>A026</td> <td>Scope</td> <td>1</td> </tr> <tr> <td>XXXX</td> <td>W/BIPOD</td> <td>1</td> </tr> </tbody> </table>		Code	Desc	Qty	A007	With Studs	2	A008	With Swivels	2	A016	Scope Mounts	2	A017	Scope Base	2	A026	Scope	1	XXXX	W/BIPOD	1
Code	Desc	Qty																								
A007	With Studs	2																								
A008	With Swivels	2																								
A016	Scope Mounts	2																								
A017	Scope Base	2																								
A026	Scope	1																								
XXXX	W/BIPOD	1																								
Repair Search		Refresh		Close																						

Serial Number: C6611793

Model ID: 700

SWS



RE00002338

BBL 96003
 Stock 96018
 Boit 96005

BARBER - M24 0036168

Remington Test Lab, Ilion, N.Y.

Centroidal distance calculations for Rifle # C6611793

4 Apr 2000

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: $-.0976$

THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: $-.4048$

THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: $.4164$

THE AMR FOR THIS RIFLE IS: 1.22

CENTROIDAL DISTANCES

0 TO 1	.632229
1 TO 2	.753608
1 TO 3	.240111
1 TO 4	.225175
1 TO 5	.458328

2
+ <----POA
3
5 4 1

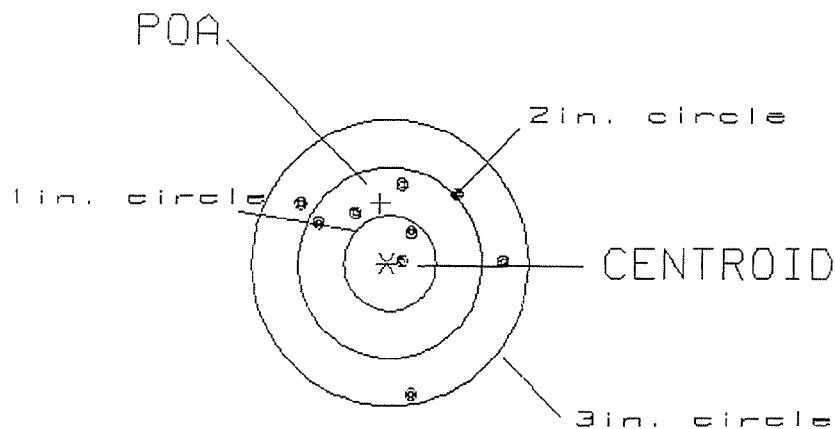
PATTERN #: 1

POA TO CENTROID: .632
 MIN RADIUS : .092
 MEAN RADIUS : 1.000
 MAX RADIUS : 2.298
 CENTROID X : .073
 CENTROID Y : -.628

4 Apr 2000

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/C6611793

CENTERFIRE PATTERN # 1



OF SHOTS= 10

IN CIRCLE

HS= 2.17

2

VS= 3.05

5

GS= 3.23

9

REMINGTON CENTERFIRE ACCURACY TEST

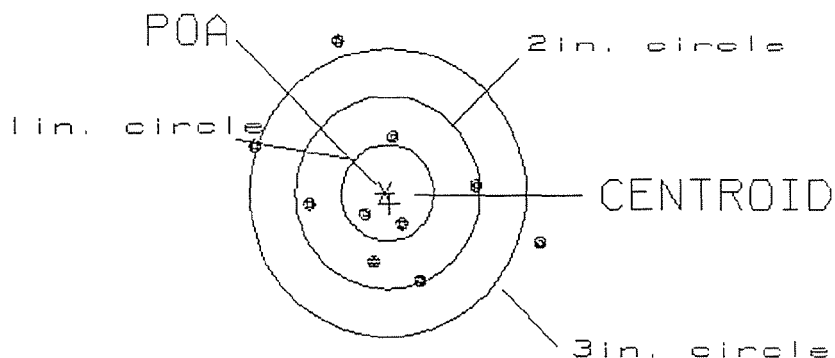
REMINGTON TEST LAB, ILION, N.Y.

PATTERN #: ☐ 2 ☐
 POA TO CENTROID: .126
 MIN RADIUS : .304
 MEAN RADIUS : .969
 MAX RADIUS : 1.770
 CENTROID X : -.053
 CENTROID Y : .115

4 Apr 2000

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/C6611793

CENTERFIRE PATTERN # 2



OF SHOTS= 10

IN CIRCLE

HS= 3.15
 VS= 2.48
 GS= 3.31

2
 7
 7

REMINGTON CENTERFIRE ACCURACY TEST

REMINGTON TEST LAB, ILION, N.Y.

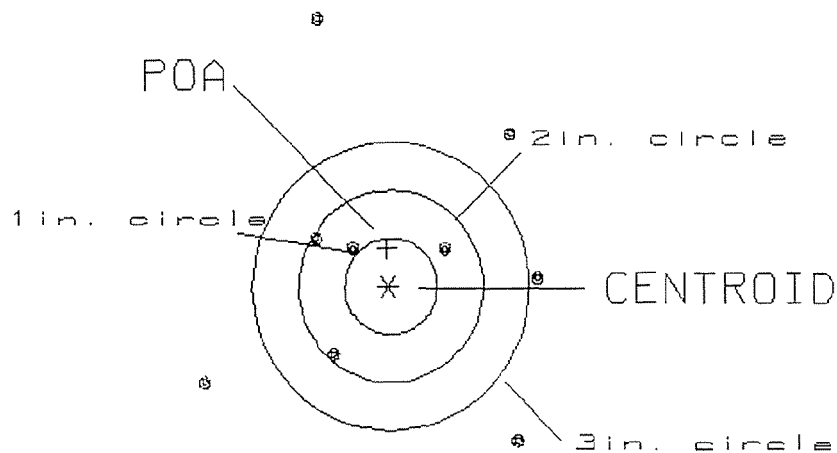
PATTERN #: 3

POA TO CENTROID: .395
 MIN RADIUS : .595
 MEAN RADIUS : 1.662
 MAX RADIUS : 2.892
 CENTROID X : .015
 CENTROID Y : -.395

4 Apr 2000

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/C6611793

CENTERFIRE PATTERN # 3



OF SHOTS= 10

IN CIRCLE

H3= 3.66
 V5= 5.23
 GS= 5.28

0
 4
 4

REMINGTON CENTERFIRE ACCURACY TEST

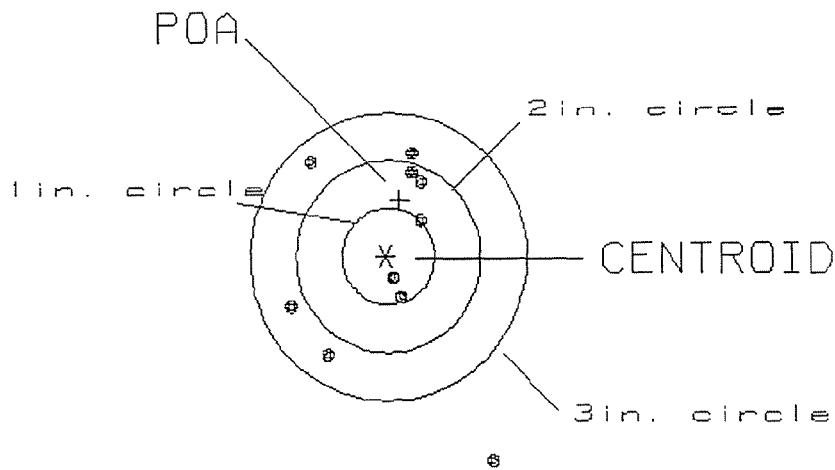
REMINGTON TEST LAB, ILION, N.Y.

PATTERN #: ☐ 4 ☐
 POA TO CENTROID: .599
 MIN RADIUS : .191
 MEAN RADIUS : 1.020
 MAX RADIUS : 2.437
 CENTROID X : -.147
 CENTROID Y : -.580

4 Apr 2000

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/C6611793

CENTERFIRE PATTERN # 4



OF SHOTS= 10

IN CIRCLE

HS= 2.26

2

VS= 3.24

5

GS= 3.74

9

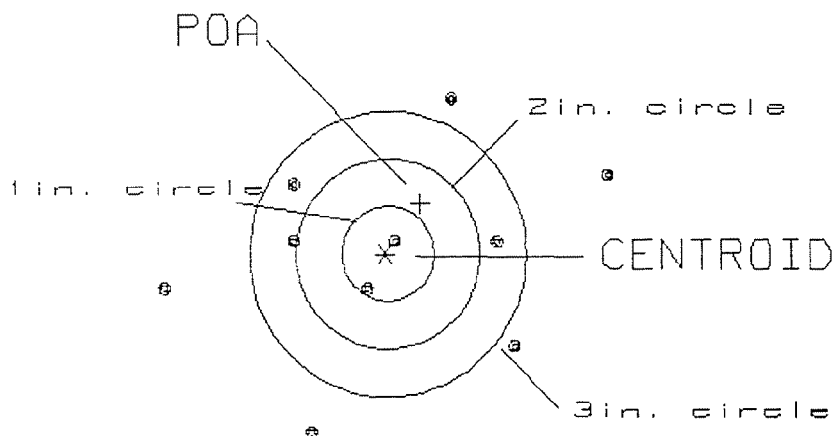
PATTERN #: 5

POA TO CENTROID: .655
 MIN RADIUS : .196
 MEAN RADIUS : 1.451
 MAX RADIUS : 2.486
 CENTROID X : -.376
 CENTROID Y : -.536

4 Apr 2000

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/C6611793

CENTERFIRE PATTERN # 5



OF SHOTS= 10

IN CIRCLE

HS= 4.80
 VS= 3.47
 GS= 4.95

2
 2
 5

Final Inspection

Sn: Cleb11793

DATE REC'D: 1-5-00

DATE RET'D:

Auditor: RW

Item:

Barrel Assy.

☒ BARREL☒ RECEIVER☒ FRONT SIGHT BLOCK☒ REAR SIGHT BLOCK☒ SCREWS☐ FINISH

Scope Assy.

☒ Scope☒ Scope Rings☒ Mounting Screws☒ Mounting Base☒ SCREWS☒ FINISH☒ Looseness☒ CLARITY

Misc.

☐ DD-250☐ BAR CODE☐ PACKAGING

Item:

Stock Assy.

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

Systems Case

☒ Scope Case☐ Iron SIGHTS☐ Deployment Kit

Trigger

☒ SAFETY OPERATION☒ SET

Comments:

21 DAY TURN - AROUND

M-24

CONTRACT # DAAA09-92-C-0834

R&E NO.

SERIAL NO. *C6611793*

LOG IN DATE: / /		DATE	INT.
INSPECT & VERIFY:			
OP. #	OP. NAME		
550	DIS-ASSEMBLE GUN	<i>1-10-00</i>	<i>Rw</i>
560 A	RE-BARREL AT CUSTOM SHOP		
B	DRILL & TAP		
C	POLISH		
575	ASSEMBLE		
600	PROOF	<i>1-12-00</i>	<i>Rw</i>
605	CHECK HEADSPACE	<i>1-12-00</i>	<i>Rw</i>
610	DIS-ASSEMBLE		
612	MAGNAFLUX		
615	ROLLMARK CALIBER		
618	ROTO-BLAST		
620	APPLY COATINGS		
625 A	FINAL ASSEMBLY		
B	TRIGGER PULL TEST		
C	SAFETY ON FORCE		
D	SAFETY OFF FORCE		
E	FIRING PIN INDENT		
640	TARGET	<i>4-5-00</i>	<i>Rw</i>
655	FINAL INSPECT	<i>4-10-00</i>	<i>Rw</i>
660	PACK		
QAR INSPECTION		SHIP DATE	

 		VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.
MODEL 700TM M24		SERIAL NO. C6611799
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat & Tm. Off, Marca Registrada Marque Deposee.		ORDER NO. 5716



5716 C6611799



MOD.		GA. CAL.	GUN #
			1799
INSP. #	DATE	MALFUNCTION/DEFECT	ASSEM. #
	1st		
NF	2/18	Scope Cockeyed	K5
	2nd	adjusted Scope 2-18-91	K X
	3rd		
	4th		
		FINAL INSPECTION	RD 6657 Rev 1

TEST INIT. ACTION TO CORRECT		ASSEM. #
PROOF		
TEST		
TGT		
PROOF		
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		

CEM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6611799

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		1/22/91	KS
600	Proof		1/22/91	KS
607	Check Headspace		1/22/91	KS
610	Dis-assemble Gun		1/22/91	KS
612	Magnaflux Barrel Action		1/29/91	KR
	Magnaflux Bolt		"	KR
615	Rollmark Caliber		"	GL
617	Drill and Tap Sight Holes	2 2 91		EB
618	Polish Barrel <i>RBB</i>	2 2 91		WB
620	Apply Coatings (Barrel Action)		2/11/91	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		2/12/91	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		2/12/91	KS
	C) Inspect Ejector Hole for Chamfer		2/12/91	KS
	D) Oil Firing Pin Ass'y		2/12/91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		2/13/91	GU

op. #	BARBER M24 0036180	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5 1/4	5 1/4	5 1/4			2/13/91	WB
	G) Safety Off Force	8 1/2	8 1/2	8 1/2			2/13/91	WB
	H) Trigger Pull Test & Retainability						2/13/91	JP
	I) Firing Pin Indent	.0205	.021	.0205			2/13/91	WB
	J) Assemble Stock						2/15/91	KA
	K) Assemble Swivel Studs						2-25-91	AC
	L) Attach Front and Rear Sight Assemblies						2/15/91	KA
	M) Iron Sight Alignment						2/15/91	KA
	N) Detach Front & Rear Sights & place in numbered container						2/15/91	KA
	O) Attach Scope to Rifle						2/15/91	KA
	P) Detach & Attach Scope 20 Times						2/15/91	KA
640	Gallery Target & Test						2-18-91	AF
	A) Time						"	AF
	B) Malfunctions						"	AF
	C) Pierced Primers						"	AF
	D) Optical Clarity of Scope						"	AF
645	Inspect for Live Ammo						2-18-91	AF
655	Final Inspection							
	A) Headspace						2-25-91	AC
	B) Trigger Pull	2.68	2.65	2.68	2.69	2.67	2/21/91	JP
	C) Function						2-25-91	AC
660	Pack						3-19-91	AF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6611799

DATE 2/13/01

TESTER [Signature]

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.34	2.17	2.20	2.58	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.51	2.21	2.29	2.65	
PULL #3	2.33	2.19	2.29	2.68	
PULL #4	2.33	2.29	2.32	2.69	
PULL #5	2.29	2.30	2.36	2.67	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.47	3.11		
PULL #2	3.50	3.51		
PULL #3	3.53	3.20		
PULL #4	3.25	3.22		
PULL #5	3.44	3.36		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.24	4.51		4.51
PULL #2	4.37	4.41		4.45
PULL #3	4.31	4.34		4.50
PULL #4	4.25	4.51		4.45
PULL #5	4.32	4.43		4.46
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06611799
19 Feb 1991

CENTROIDAL DISTANCES

0 TO	1	.134082
1 TO	2	.0382884
1 TO	3	.155261
1 TO	4	.122874
1 TO	5	.208396

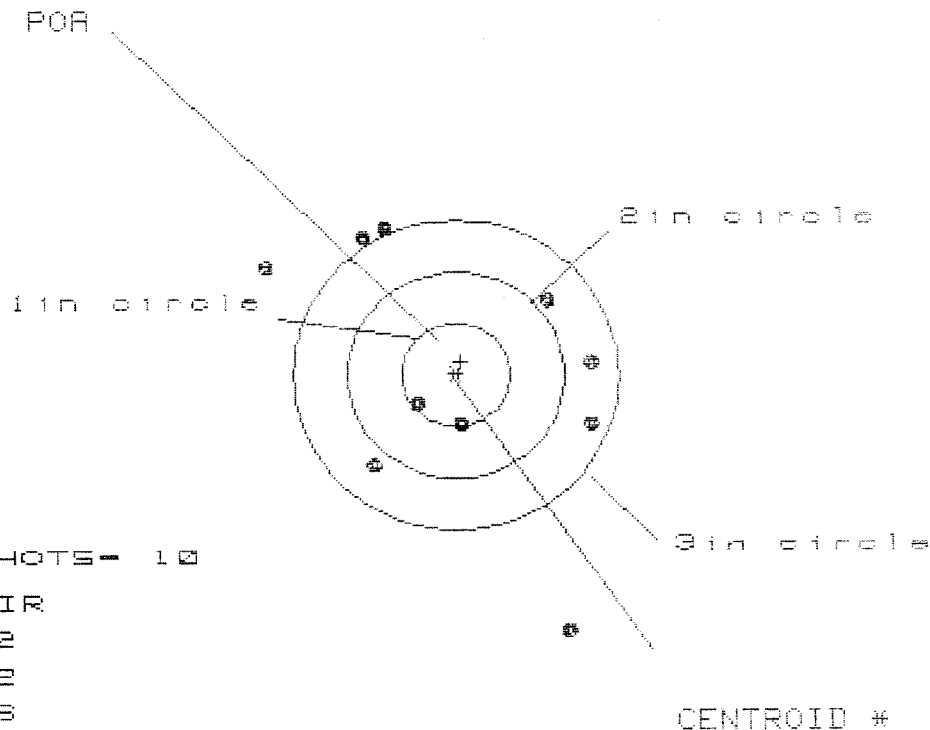
✱ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.032
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.123
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .127094
THE AMR FOR THIS RIFLE IS: 1.148

19 Feb 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8611799

CENTERFIRE PATTERNS # 1



OF SHOTS - 10

IN CIR

1 in = 2

2 in = 2

3 in = 6

HS = 3.042

VS = 3.866

GS = 4.465

PATTERN #	:	1	2	3
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.269	1.383	1.176
MINIMUM X	:	-1.773	-1.659	-0.972
MAXIMUM Y	:	1.379	1.103	1.132
MINIMUM Y	:	-2.487	-1.101	-1.012
CENTROID X	:	-0.043	-0.157	0.050
CENTROID Y	:	-0.127	0.149	0.060
POA TO CENTROID in.	:	0.134	0.217	0.078
MIN RADIUS	:	0.466	0.606	0.656
MEAN RADIUS	:	1.364	1.224	1.125
MAX RADIUS	:	2.691	1.805	1.499
HORIZONTAL SPREAD	:	3.042	3.042	2.148
VERTICAL SPREAD	:	3.866	2.204	2.204
EXTREME SPREAD	:	4.465	3.367	2.792
NUMBER IN ONE INCH CIRCLE	=	2	2	2
NUMBER IN TWO INCH CIRCLE	=	2	2	2
NUMBER IN THREE INCH CIRCLE	=	6	6	6

19 Feb 1991

FILE:/PATTERNING/CENTERFIRE_PATT/CAB11799

CENTERFIRE PATTERNS # 2

POA

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 3

2 in = 5

3 in = 8

HS= 2.165

VS= 3.590

GS= 3.672

CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	-1.069	1.102	1.089
MINIMUM X	:	-1.096	-1.063	-.925
MAXIMUM Y	:	1.982	1.039	.865
MINIMUM Y	:	-1.608	-1.388	-.871
CENTROID X	:	-.018	-.051	-.189
CENTROID Y	:	-.098	-.318	-.144
POA TO CENTROID in.	:	.099	.322	.238
MIN RADIUS	:	.215	.037	.194
MEAN RADIUS	:	.989	.826	.720
MAX RADIUS	:	2.004	1.773	1.308
HORIZONTAL SPREAD	:	2.165	2.165	2.014
VERTICAL SPREAD	:	3.590	2.427	1.736
EXTREME SPREAD	:	3.672	2.890	2.486
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

19 Feb 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06611799

CENTERFIRE PATTERNS # 3

POA

1in circle

2in circle

3in circle

CENTROID #

OF SHOTS - 10

IN CIR

1in = 0

2in = 5

3in = 8

HS= 4.130

VS= 2.517

GS= 4.243

PATTERN #

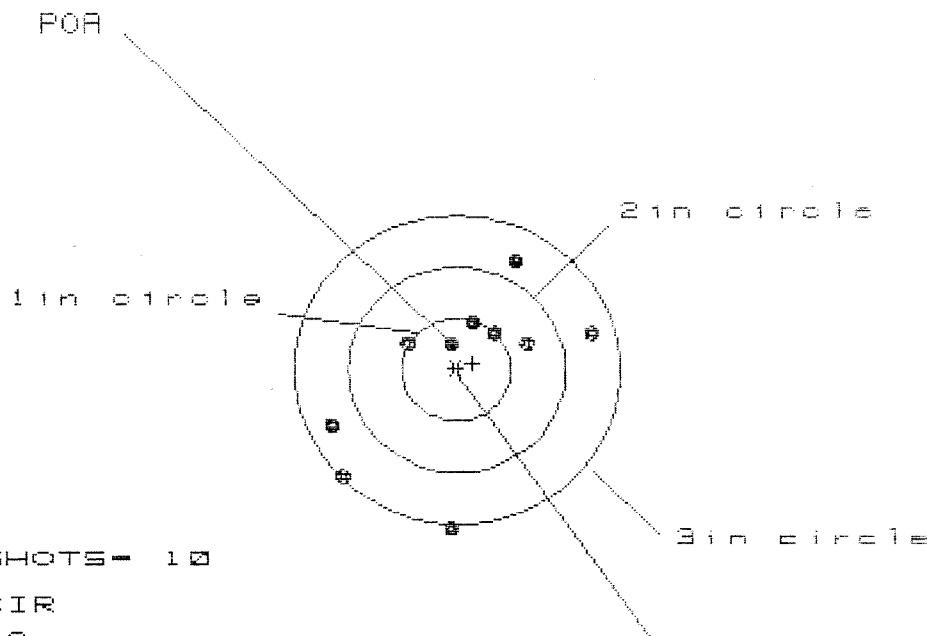
3

SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.537	1.249	.642
MINIMUM X	:	-2.593	-1.169	-1.013
MAXIMUM Y	:	1.142	.998	.939
MINIMUM Y	:	-1.375	-1.519	-1.578
CENTROID X	:	-.108	.180	.024
CENTROID Y	:	-.268	-.124	-.065
POA TO CENTROID in.	:	.289	.219	.069
MIN RADIUS	:	.642	.521	.663
MEAN RADIUS	:	1.229	.964	.926
MAX RADIUS	:	2.900	1.712	1.700
HORIZONTAL SPREAD	:	4.130	2.418	1.655
VERTICAL SPREAD	:	2.517	2.517	2.517
EXTREME SPREAD	:	4.243	2.635	2.635
NUMBER IN ONE INCH CIRCLE	=	0		
NUMBER IN TWO INCH CIRCLE	=	5		
NUMBER IN THREE INCH CIRCLE	=	8		

19 Feb 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8611799

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1 in - 2

2 in - 5

3 in = 8

HS= 2.429

VS= 2.570

GS= 2.792

CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.266	1.256	1.118
MINIMUM X	:	-1.163	-1.173	-1.311
MAXIMUM Y	:	1.027	.855	.699
MINIMUM Y	:	-1.543	-1.252	-.851
CENTROID X	:	-.146	-.136	.002
CENTROID Y	:	-.060	.112	.268
POA TO CENTROID in.	:	.157	.176	.268
MIN RADIUS	:	.311	.155	.156
MEAN RADIUS	:	.941	.815	.647
MAX RADIUS	:	1.546	1.671	1.564
HORIZONTAL SPREAD	:	2.429	2.429	2.429
VERTICAL SPREAD	:	2.570	2.107	1.550
EXTREME SPREAD	:	2.792	2.792	2.602
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	5		
NUMBER IN THREE INCH CIRCLE	=	8		

19 Feb 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06611799

CENTERFIRE PATTERNS # 5

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS- 10

IN CIR

1 in = 2

2 in = 5

3 in = 7

HS= 3.540

VS= 2.992

GS= 3.690

PATTERN #

5

SHOTS (BEST OF)

10

9

8

MAXIMUM X

2.106

1.463

1.313

MINIMUM X

-1.434

-1.200

-.963

MAXIMUM Y

1.298

1.199

.975

MINIMUM Y

-1.694

-1.793

-1.233

CENTROID X

.155

-.079

.071

CENTROID Y

-.062

.037

.261

POA TO CENTROID in.

.167

.087

.270

MIN RADIUS

.212

.321

.198

MEAN RADIUS

1.217

1.089

.905

MAX RADIUS

2.286

2.157

1.564

HORIZONTAL SPREAD

3.540

2.663

2.276

VERTICAL SPREAD

2.992

2.992

2.208

EXTREME SPREAD

3.690

3.690

2.884

NUMBER IN ONE INCH CIRCLE =

2

NUMBER IN TWO INCH CIRCLE =

5

NUMBER IN THREE INCH CIRCLE =

7