

C6348826

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5716**

* Includes 1 in chamber.

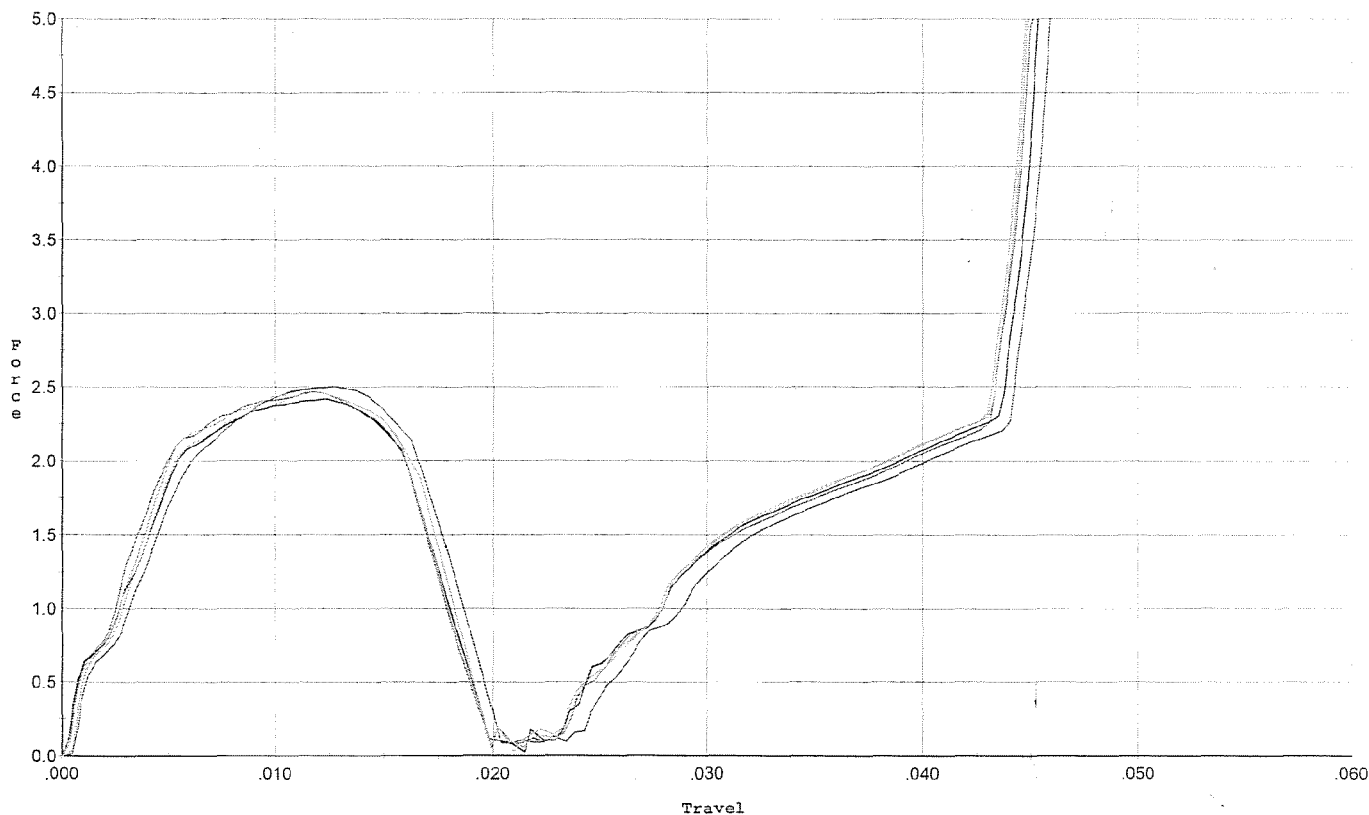


Speed
III

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 4/15/2009

Model: M/24
Serial No: Form #F005
Trigger: 2.5 lbs ini +/- .50 lb

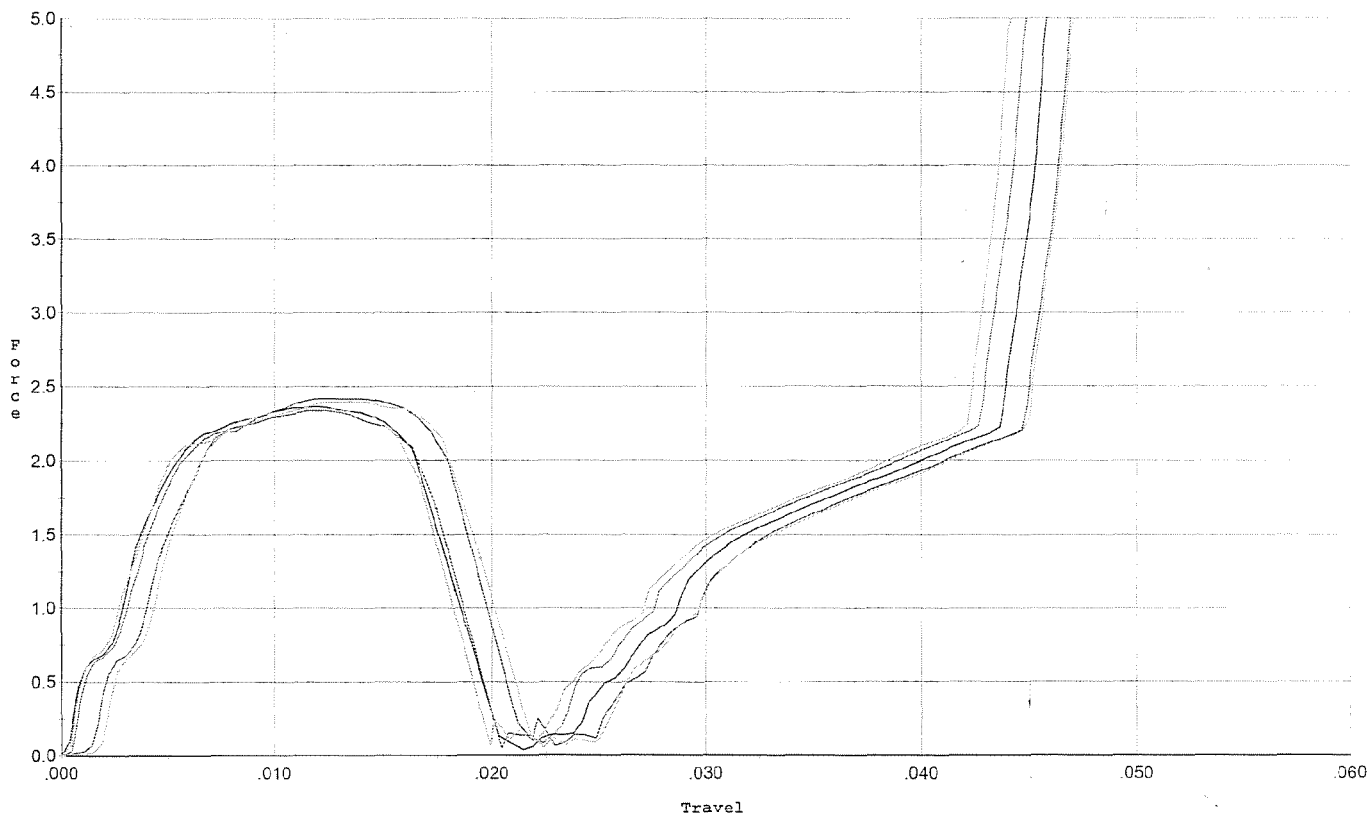


#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.503	0.018	0.00	0.034	0.031		Set Trigger
2	2.420	0.016	0.00	0.033	0.028		Set Trigger
3	2.467	0.016	0.00	0.033	0.029		Set Trigger
4	2.464	0.017	0.00	0.032	0.029		Set Trigger
5	2.478	0.016	0.00	0.033	0.028		Set Trigger

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 4/15/2009

Model: M/24
Serial No: Form #F005
Trigger: 2.5 lbs after 50 cycles+/- .50 lb



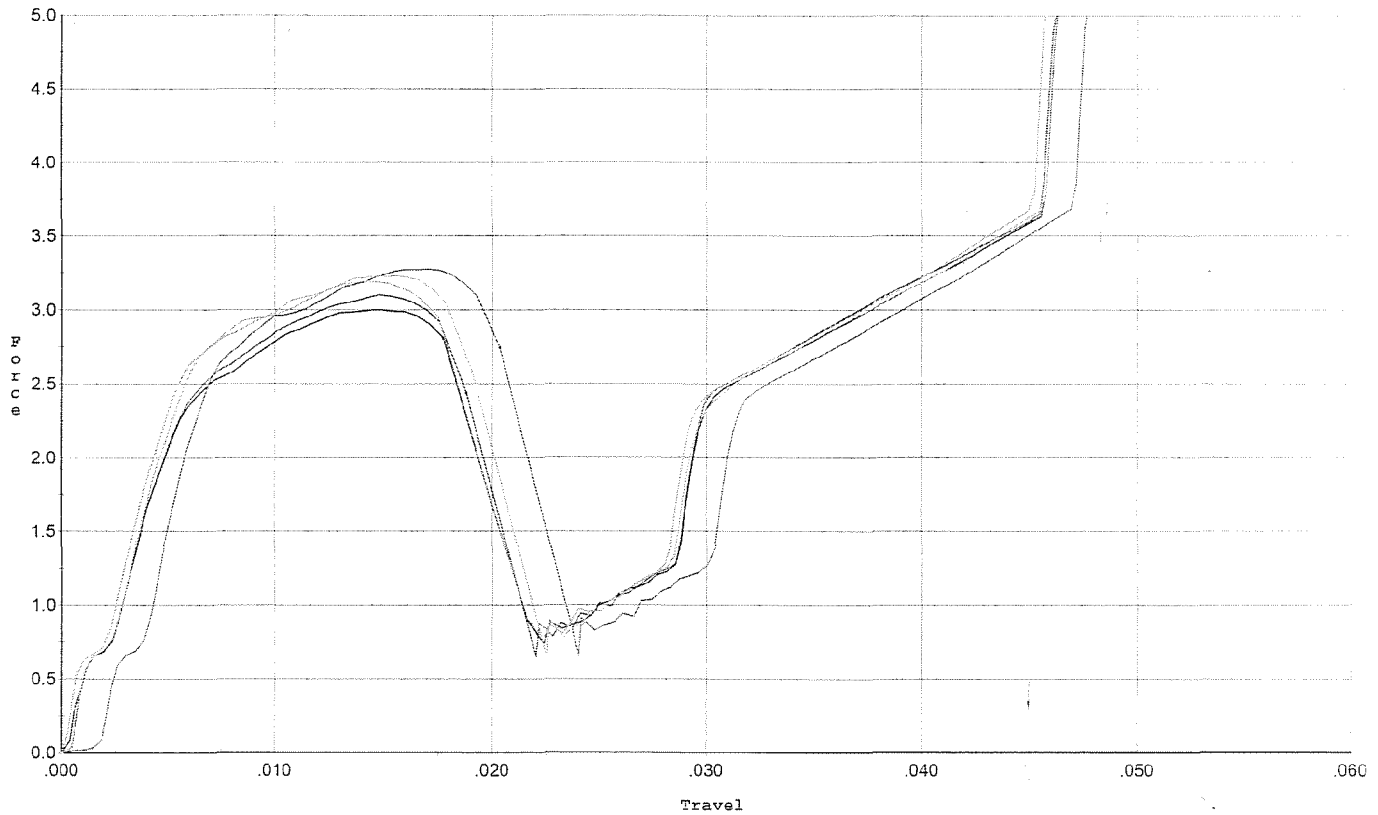
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.418	0.018	0.00	0.034	0.030		Set Trigger
2	2.366	0.018	0.00	0.033	0.032		Set Trigger
3	2.337	0.017	0.00	0.033	0.030		Set Trigger
4	2.399	0.019	0.002	0.033	0.032		Set Trigger
5	2.348	0.017	0.00	0.032	0.029		Set Trigger

A-2.37

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 4/15/2009

Model: M/24
Serial No: Form #F005
Trigger: 3.0 lbs ini +/- .75 lb



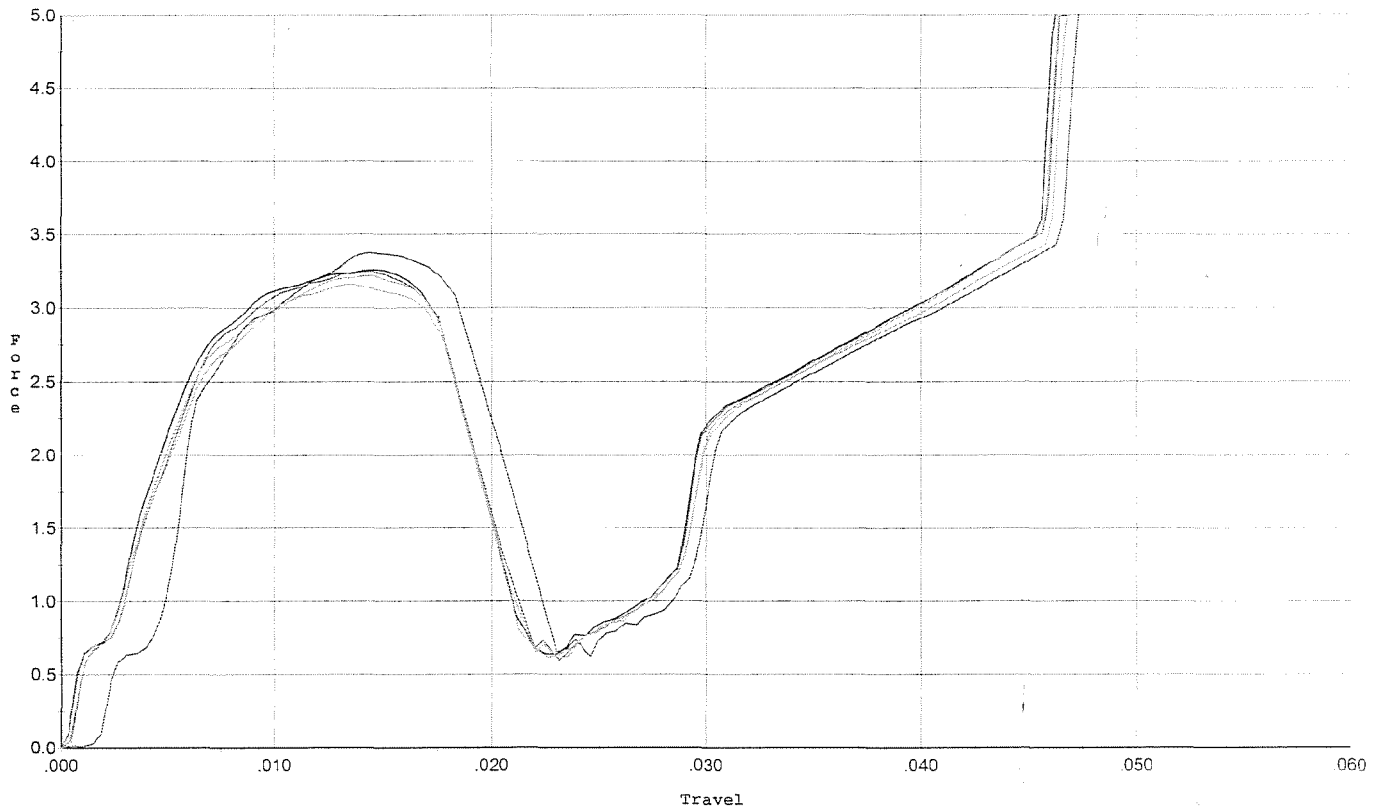
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.101	0.019	0.00	0.030	0.041		Set Trigger
2	2.999	0.018	0.00	0.030	0.038		Set Trigger
3	3.272	0.020	0.00	0.031	0.045		Set Trigger
4	3.229	0.019	0.00	0.030	0.044		Set Trigger
5	3.192	0.018	0.00	0.030	0.040		Set Trigger

A-3.15

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 4/15/2009

Model: M/24
Serial No: Form #F005
Trigger: 3.0 lbs after 20 cycles+/- .75 lb



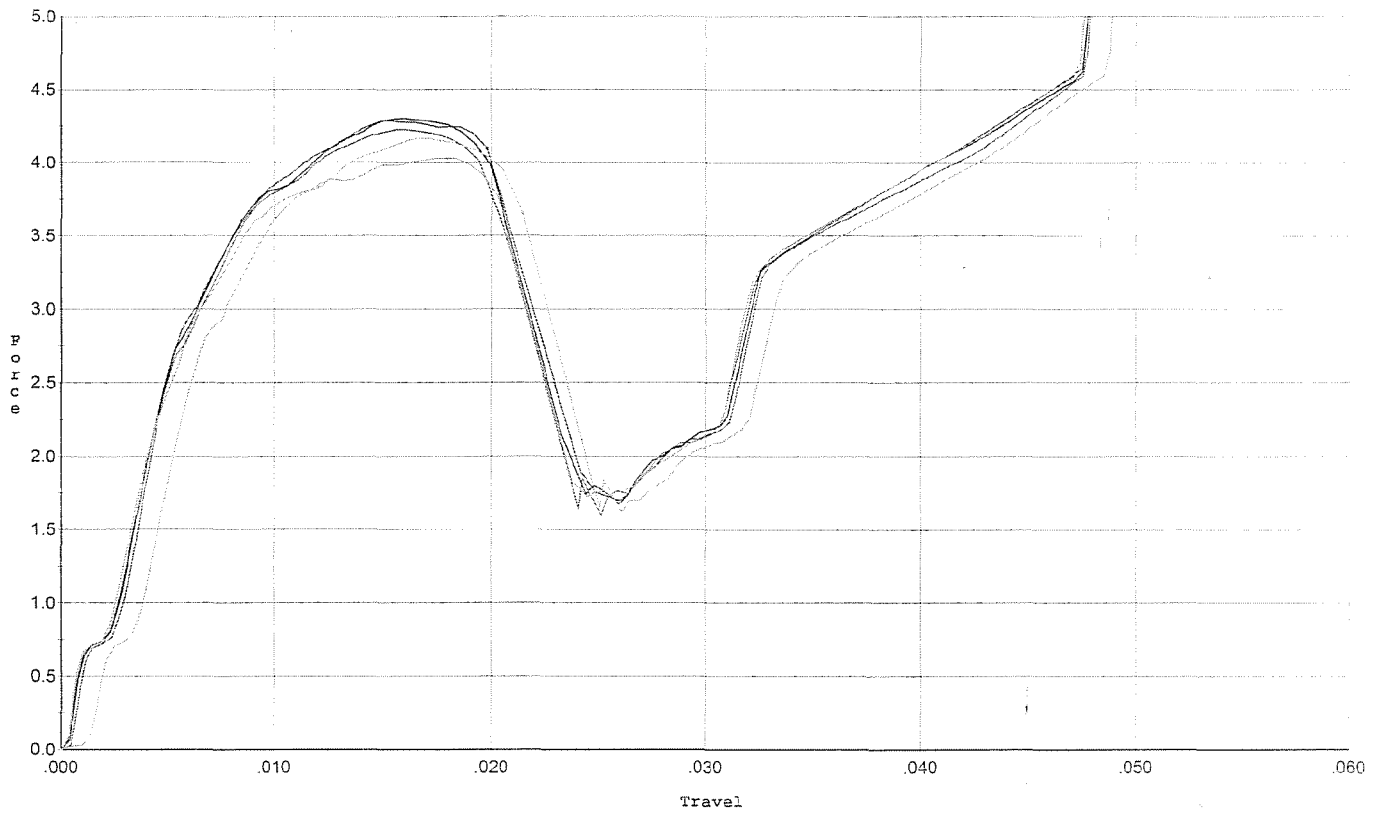
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.379	0.020	0.00	0.030	0.044		Set Trigger
2	3.258	0.018	0.00	0.031	0.040		Set Trigger
3	3.247	0.018	0.00	0.031	0.039		Set Trigger
4	3.154	0.018	0.00	0.031	0.039		Set Trigger
5	3.218	0.018	0.00	0.031	0.039		Set Trigger

A-3.25

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 4/15/2009

Model: M/24
 Serial No: Form #F005
 Trigger: 4.0 lbs ini +/- 1.0 lb



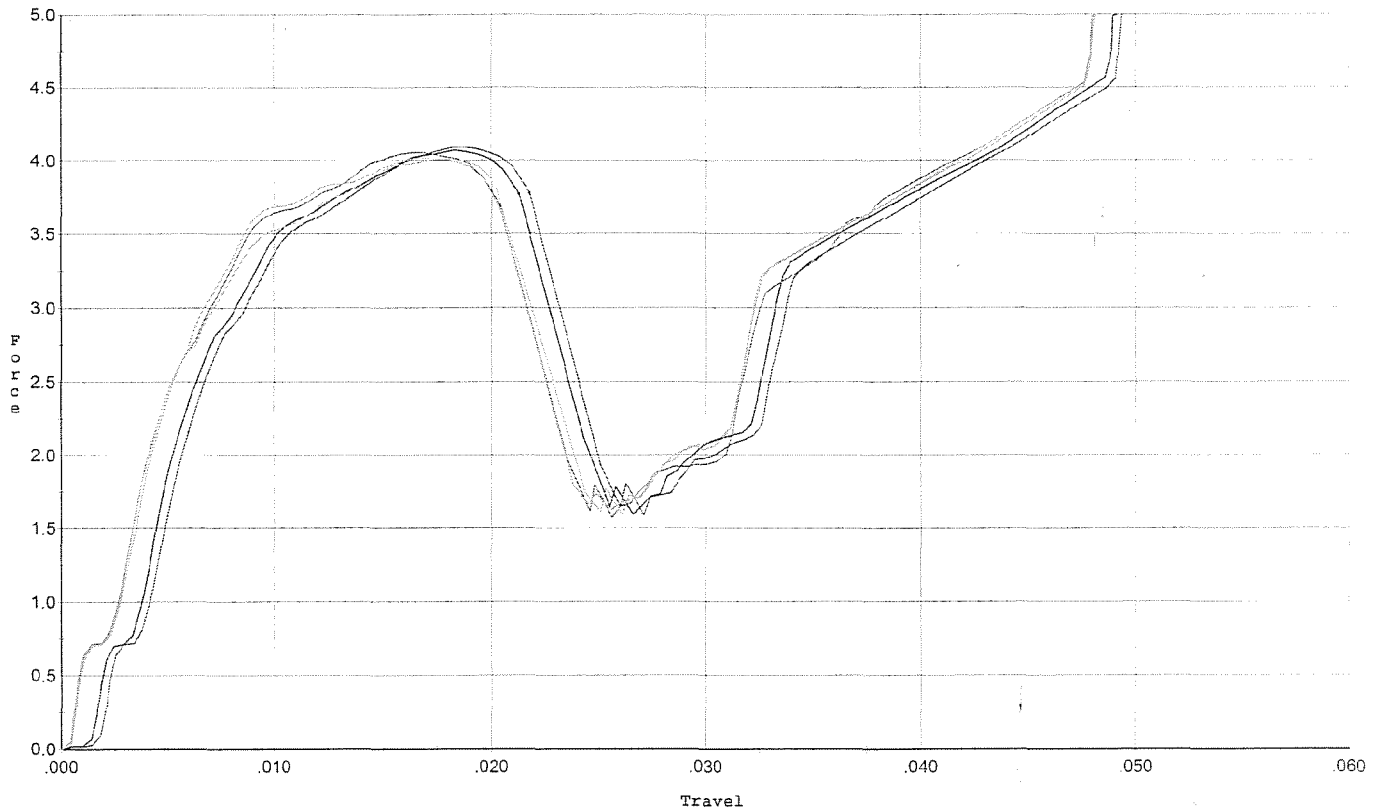
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.288	0.020	0.00	0.028	0.058		Set Trigger
2	4.299	0.020	0.00	0.028	0.059		Set Trigger
3	4.224	0.021	0.00	0.028	0.060		Set Trigger
4	4.166	0.021	0.00	0.029	0.059		Set Trigger
5	4.026	0.020	0.00	0.028	0.058		Set Trigger

4-4-19

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 4/15/2009

Model: M/24
 Serial No: Form #F005
 Trigger: 4.0 lbs after 20 cyclesd +/- 1.0 lb



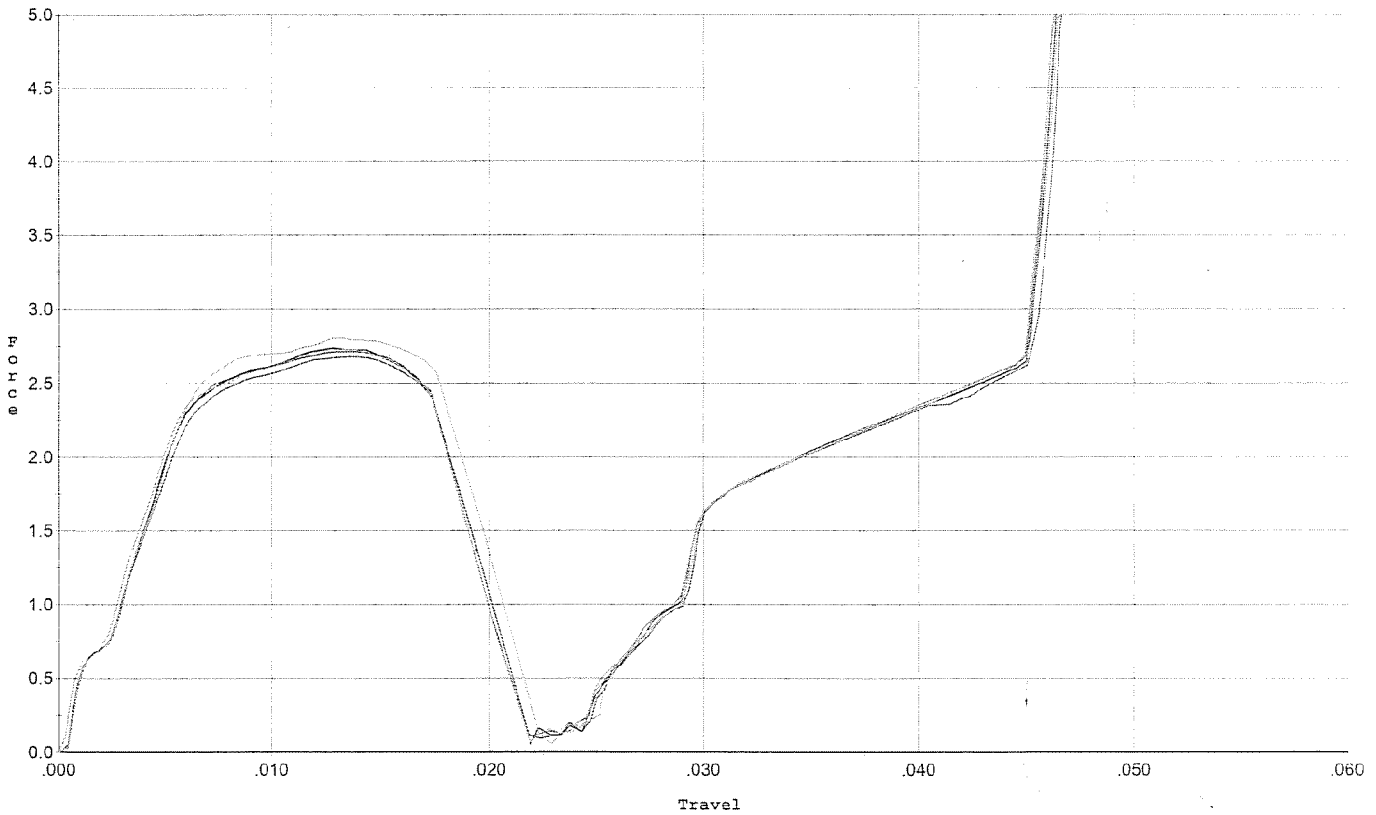
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.090	0.022	0.00	0.029	0.058		Set Trigger
2	4.071	0.021	0.00	0.029	0.057		Set Trigger
3	4.055	0.020	0.00	0.029	0.057		Set Trigger
4	4.017	0.022	0.00	0.028	0.063		Set Trigger
5	3.996	0.020	0.00	0.029	0.056		Set Trigger

A 4.0~1

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 4/15/2009

Model: M/24
Serial No: Form #F005
Trigger: set to 2.5 lb +/- .50 lb for final test



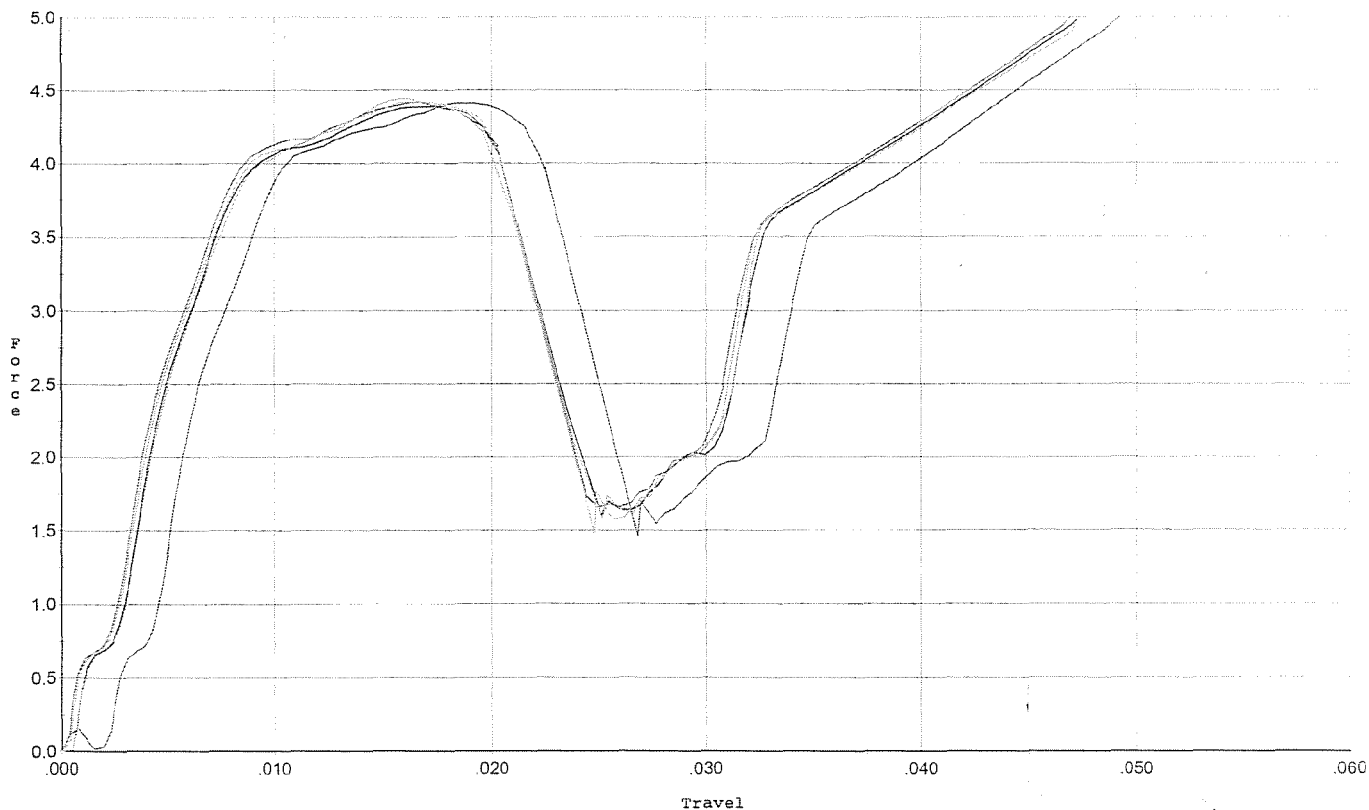
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.715	0.019	0.00	0.032	0.038		Set Trigger
2	2.739	0.017	0.00	0.033	0.034		Set Trigger
3	2.680	0.019	0.00	0.032	0.037		Set Trigger
4	2.809	0.020	0.00	0.032	0.040		Set Trigger
5	2.730	0.017	0.00	0.032	0.034		Set Trigger

A-2.73

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 4/15/2009

Model: M/24
Serial No: Form #F005
Trigger: set to 4.0 lbs +/- 1.0 lb for target & accuracy



#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.409	0.022	0.00	0.028	0.065		Set Trigger
2	4.388	0.020	0.00	0.028	0.061		Set Trigger
3	4.414	0.020	0.00	0.028	0.063		Set Trigger
4	4.414	0.021	0.00	0.027	0.064		Set Trigger
5	4.437	0.020	0.00	0.028	0.061		Set Trigger

A.4.41

INSPECTION CHECKLIST - REPAIRS

CONTRACT #: W52H09-07-C-0207

ISSUED 10/1/2007

Deployment Kit

R & E NUMBER

168555

SERIAL NUMBER

C6248826

LOG-IN DATE

5-26-09

OPERATION #	OPERATION NAME	DATE	INITIAL
500	DIS-ASSEMBLE GUN	5-27-09	RT
505	RE-BARREL	5-28-09	RT
420	ASSEMBLE	5-28-09	RT
440	PROOF	5-28-09	SP
460	CHECK HEADSPACE	5-28-09	SP
470	DIS-ASSEMBLE GUN	5-28-09	SP
480	MAGNAFLUX	5/30/09	SP
510	DRILL AND TAP	5-29-09	SP
500	ROLLMARK CALIBER	6/1/09	RT
520	GOFF BLAST BBL / REC	6-1-09	DWO
530 & 540	APPLY COATINGS	6-3	
560	FINAL ASSEMBLY	6-8-09	RT
640	FUNCTION TEST AND	PASS FAIL	6-8-09 RP
650	TARGET	PASS FAIL	6-8-09 RP
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	N/A
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	6-8-09 SP
670	FINAL INSPECTION		
	A) HEADSPACE	PASS FAIL	6-15-09 L N
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	2.88 2.86 2.83 2.86 2.83 6-15-09 RT
680	F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX	3.0 3.5 4.0 6-15-09 L N
	G) SAFETY OFF FORCE	2 LBS MIN	5.0 5.0 5.0 6-15-09 L N
	I) FIRING PIN INDENT	.020	.021 .021 .021 6-15-09 RT
690	PACK		6-15-09 FN

F006 REV 1/2009

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6348826.___0
FILE DATE AND TIME: 06/09/2009 07:47

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.073
The Average Y Centroid of the Five Target Set:	-0.001
The Average Point of Impact of the Five Target Set:	0.073
The Average Mean Radius of the Five Target Set:	0.873
The Distance from POA to Centroid Target #1:	0.517
The Distance from Centroid Target #2 to Centroid Target #1:	0.646
The Distance from Centroid Target #3 to Centroid Target #1:	0.917
The Distance from Centroid Target #4 to Centroid Target #1:	0.560
The Distance from Centroid Target #5 to Centroid Target #1:	0.619

BARBER - M24 0039176

SERIAL NUMBER: C6348826. __0

TARGET NUMBER: 1

FILE DATE: 06/09/2009

FILE TIME: 07:47

POINT#	X	Y
1:	-0.343	0.999
2:	-0.280	0.576
3:	0.181	0.158
4:	-0.001	0.050
5:	-0.242	0.026
6:	-0.262	-0.232
7:	0.529	-0.486
8:	0.637	-1.702
9:	0.280	-2.013
10:	0.561	-2.436

X CENTROID: 0.106

Y CENTROID: -0.506

POA TO CENTROID: 0.517

HORZ SPREAD: 0.980

VERT SPREAD: 3.435

GROUP SPREAD: 3.552

MIN RADIUS: 0.423

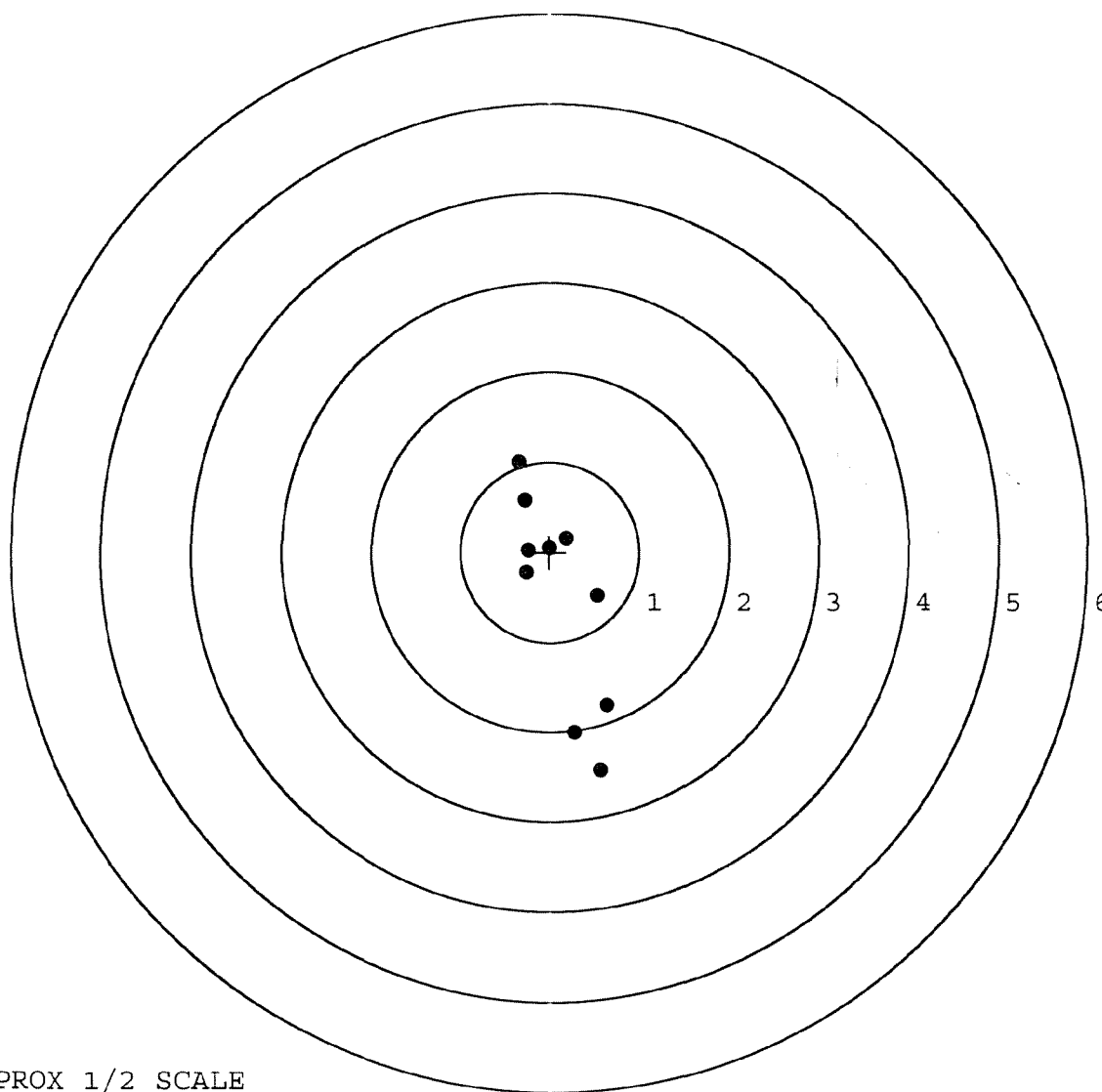
MAX RADIUS: 1.983

MEAN RADIUS: 1.028

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 5

in 3 IN DIAMETER: 7



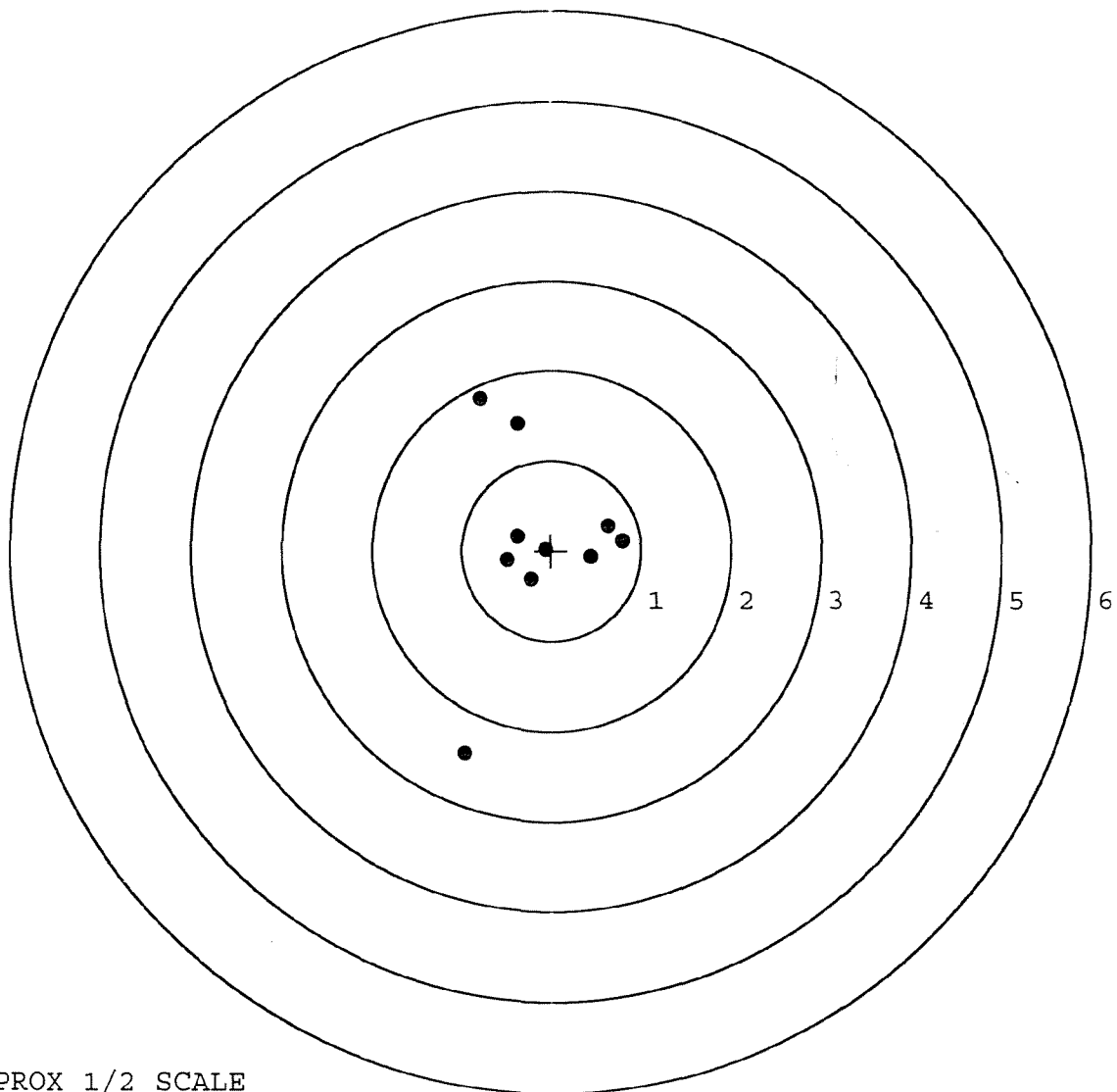
TARGET APPROX 1/2 SCALE

BARBER - M24 0039177

SERIAL NUMBER: C6348826. 0
 TARGET NUMBER: 2
 FILE DATE: 06/09/2009
 FILE TIME: 07:47

POINT#	X	Y
1:	-0.383	0.159
2:	-0.490	-0.112
3:	-0.064	0.018
4:	-0.227	-0.318
5:	0.789	0.109
6:	0.633	0.277
7:	0.444	-0.073
8:	-0.375	1.402
9:	-0.788	1.682
10:	-0.972	-2.248

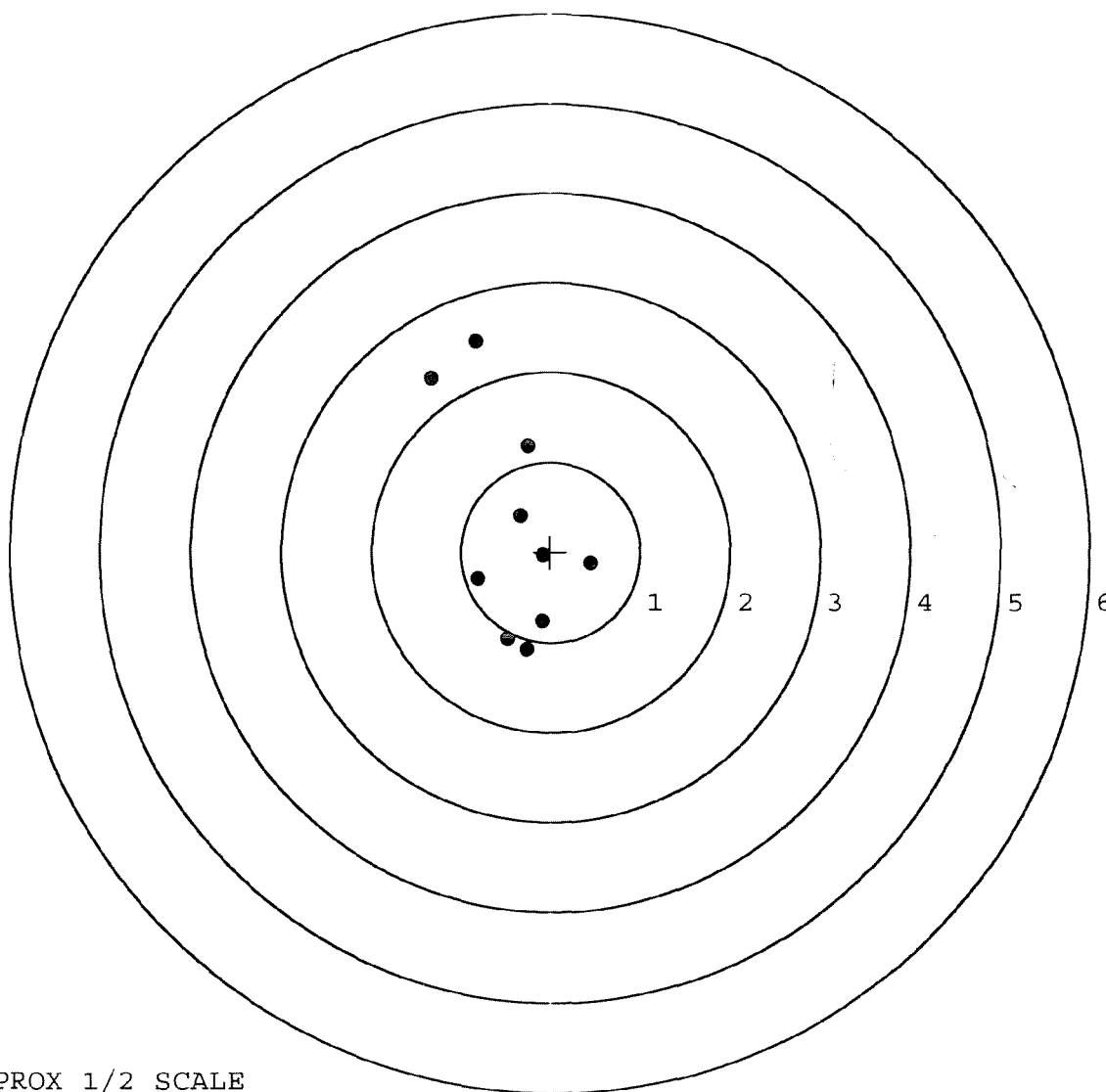
X CENTROID: -0.143
 Y CENTROID: 0.090
 POA TO CENTROID: 0.169
 HORZ SPREAD: 1.761
 VERT SPREAD: 3.930
 GROUP SPREAD: 3.934
 MIN RADIUS: 0.107
 MAX RADIUS: 2.480
 MEAN RADIUS: 0.904
 # IN 1 IN DIAMETER: 4
 # IN 2 IN DIAMETER: 7
 # in 3 IN DIAMETER: 8



TARGET APPROX 1/2 SCALE

BARBER - M24 0039178

SERIAL NUMBER: C6348826. 0	POINT#	X	Y
TARGET NUMBER: 3	1:	-0.833	2.336
FILE DATE: 06/09/2009	2:	-1.331	1.921
FILE TIME: 07:47	3:	-0.250	1.174
	4:	-0.339	0.401
X CENTROID: -0.404	5:	-0.082	-0.034
Y CENTROID: 0.256	6:	0.449	-0.123
POA TO CENTROID: 0.478	7:	-0.808	-0.299
HORZ SPREAD: 1.780	8:	-0.094	-0.767
VERT SPREAD: 3.420	9:	-0.485	-0.965
GROUP SPREAD: 3.467	10:	-0.267	-1.084
MIN RADIUS: 0.159			
MAX RADIUS: 2.124			
MEAN RADIUS: 1.081			
# IN 1 IN DIAMETER: 2			
# IN 2 IN DIAMETER: 5			
# in 3 IN DIAMETER: 8			



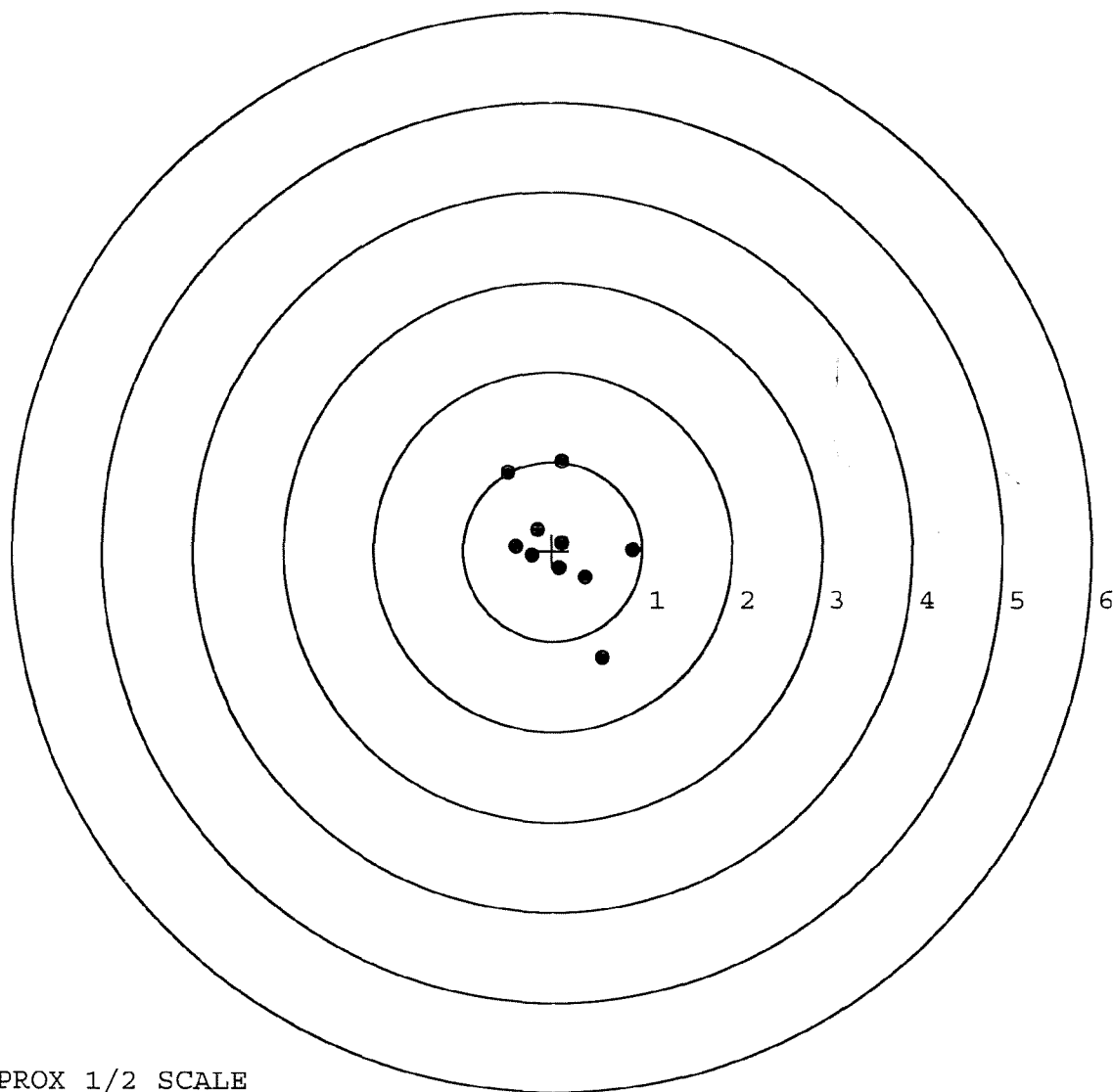
TARGET APPROX 1/2 SCALE

BARBER - M24 0039179

SERIAL NUMBER: C6348826. __0
 TARGET NUMBER: 4
 FILE DATE: 06/09/2009
 FILE TIME: 07:47

POINT#	X	Y
1:	0.552	-1.190
2:	0.894	0.009
3:	0.111	1.002
4:	-0.498	0.880
5:	-0.169	0.236
6:	0.108	0.089
7:	0.365	-0.298
8:	0.075	-0.187
9:	-0.229	-0.052
10:	-0.411	0.040

X CENTROID: 0.080
 Y CENTROID: 0.053
 POA TO CENTROID: 0.096
 HORZ SPREAD: 1.392
 VERT SPREAD: 2.192
 GROUP SPREAD: 2.321
 MIN RADIUS: 0.046
 MAX RADIUS: 1.330
 MEAN RADIUS: 0.597
 # IN 1 IN DIAMETER: 6
 # IN 2 IN DIAMETER: 8
 # in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6348826. __0

TARGET NUMBER: 5

FILE DATE: 06/09/2009

FILE TIME: 07:47

POINT#	X	Y
1:	-0.697	1.381
2:	1.160	0.535
3:	0.496	0.405
4:	-0.142	0.596
5:	-0.748	0.270
6:	-0.446	-0.233
7:	-0.195	-0.509
8:	0.287	-0.784
9:	0.189	-0.544
10:	0.057	-0.086

X CENTROID: -0.004

Y CENTROID: 0.103

POA TO CENTROID: 0.103

HORZ SPREAD: 1.908

VERT SPREAD: 2.165

GROUP SPREAD: 2.378

MIN RADIUS: 0.199

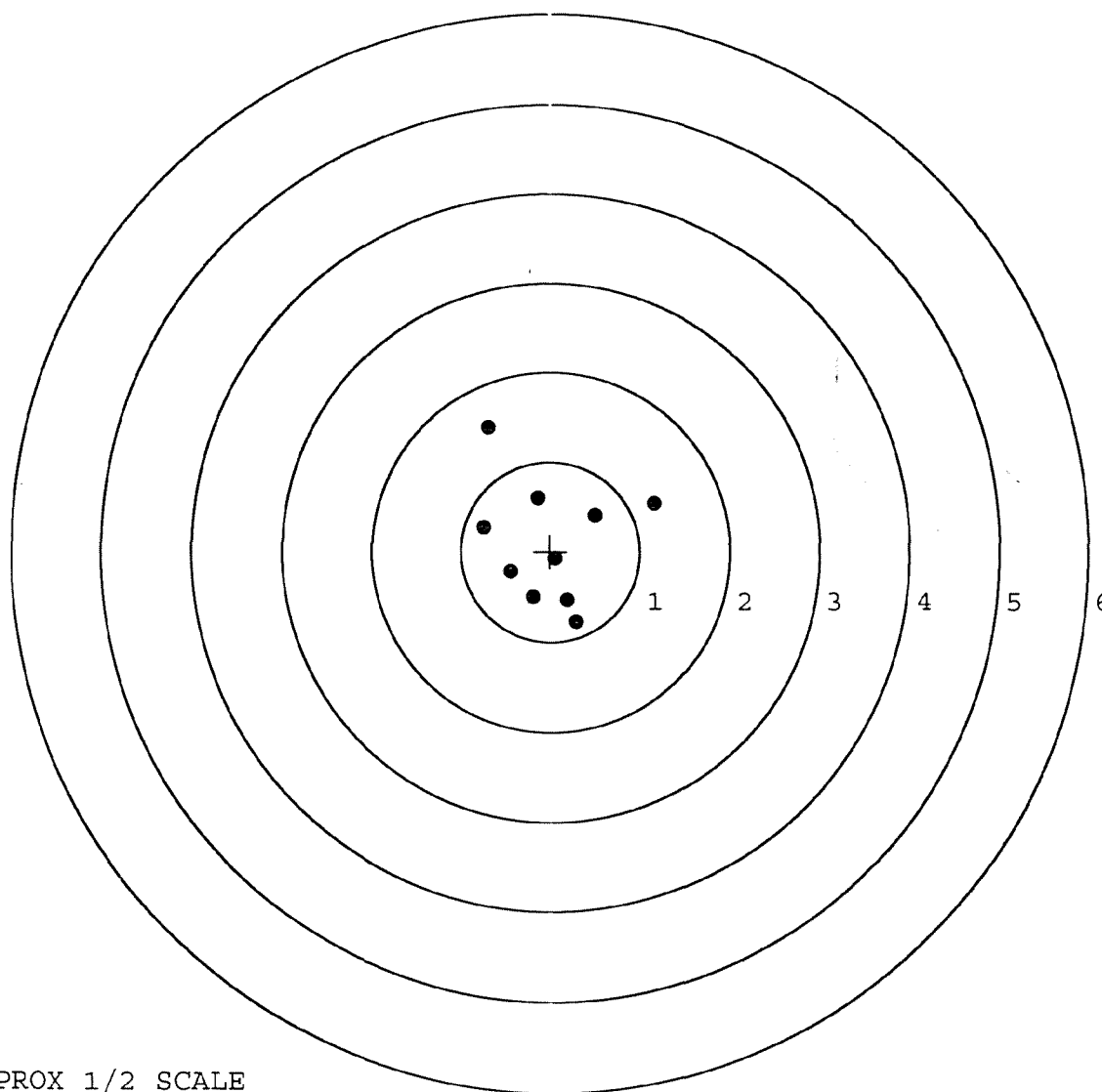
MAX RADIUS: 1.454

MEAN RADIUS: 0.756

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

Final Inspection

S.N. C6348826 DATE REC'D: 9-16-00 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:

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

R & E NUMBER		14563	
SERIAL NUMBER		C6348826	
LOG-IN DATE		9-26-00	
INSPECT AND VERIFY:			
OPERATION #	OPERATION NAME	DATE	INITIAL
550	DIS-ASSEMBLE GUN	9-28-00	CK
560 A	RE-BARREL AT CUSTOM SHOP		
B	DRILL AND TAP		
C	POLISH		
575	ASSEMBLE		
600	PROOF	10-3-00	RW
605	CHECK HEADSPACE	10-3-00	CK
610	DIS-ASSEMBLE GUN		
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	10-17-00	RW
655	FINAL INSPECT	10-25-00	CK
660	PACK		
		SHIP DATE	
		QAR INSPECTION DATE	

BARBER - M24 0039184

Remington Test Lab, Ilion, N.Y.

Centroidal distance calculations for Rifle # c6348826
25 Oct 2000

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0578
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0212
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0615653

THE AMR FOR THIS RIFLE IS: 1.271

CENTROIDAL DISTANCES

0	TO	1	.447672
1	TO	2	.68535
1	TO	3	.892911
1	TO	4	.635423
1	TO	5	.570056

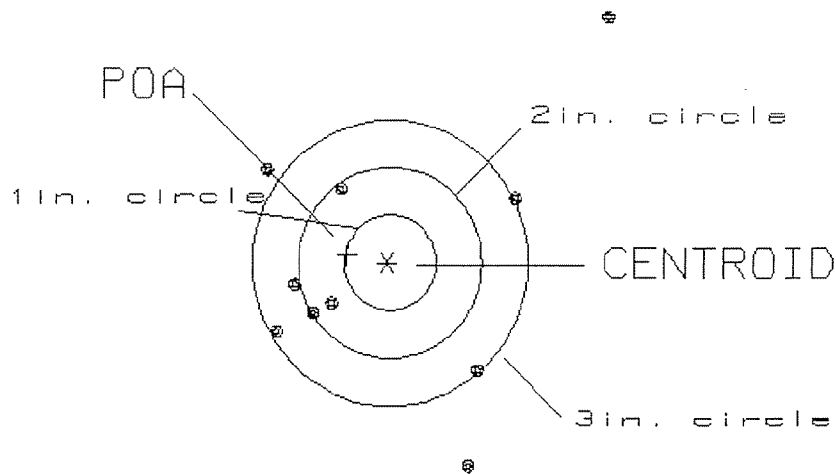
3 5
2 + 1 <----POA
4

PATTERN #: 1
 POA TO CENTROID: .448
 MIN RADIUS : .739
 MEAN RADIUS : 1.557
 MAX RADIUS : 3.480
 CENTROID X : .441
 CENTROID Y : -.077

25 Oct 2000

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6348026.1

CENTERFIRE PATTERN # 1



OF SHOTS= 10

IN CIRCLE

HS= 3.67

0

VS= 4.69

3

GS= 4.92

6

BARBER - M24 0039186

REMINGTON CENTERFIRE ACCURACY TEST

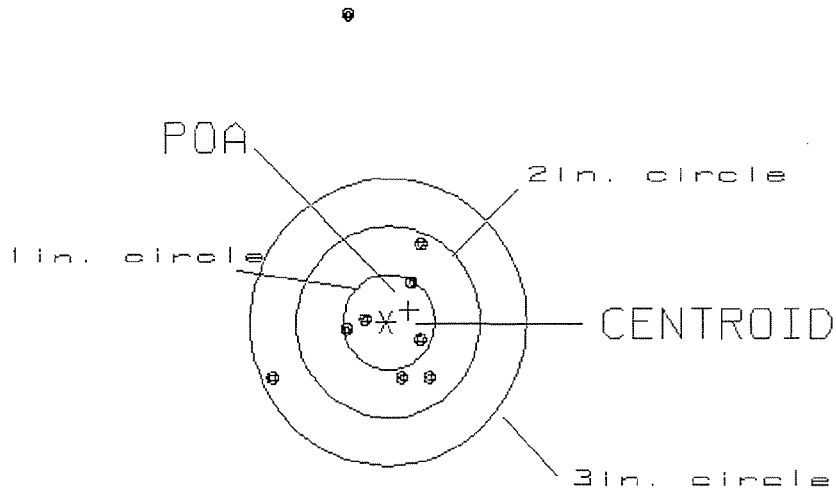
REMINGTON TEST LAB, ILION, N.Y.

PATTERN #: 2
 POA TO CENTROID: .271
 MIN RADIUS : .207
 MEAN RADIUS : 1.103
 MAX RADIUS : 3.240
 CENTROID X : -.243
 CENTROID Y : -.120

25 Oct 2000

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6348826.1

CENTERFIRE PATTERN # 2



OF SHOTS= 10

IN CIRCLE

HS= 2.06

3

VS= 5.61

7

GS= 5.76

8

BARBER - M24 0039187

REMINGTON CENTERFIRE ACCURACY TEST

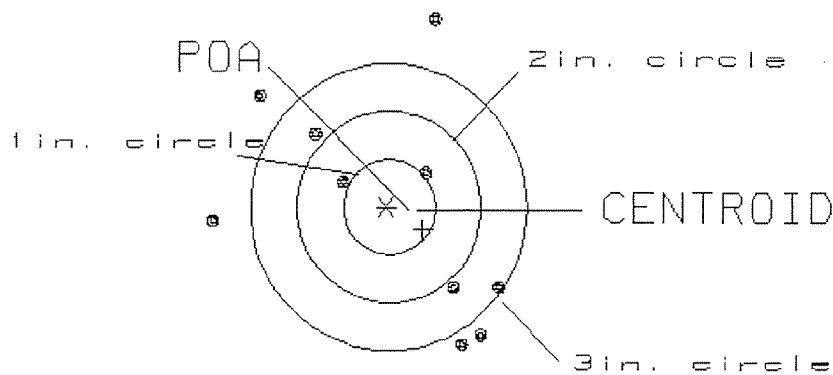
REMINGTON TEST LAB, ILION, N.Y.

PATTERN #: ☐ 3 ☐
 POA TO CENTROID: .460
 MIN RADIUS : .570
 MEAN RADIUS : 1.389
 MAX RADIUS : 2.040
 CENTROID X : -.396
 CENTROID Y : .234

25 Oct 2000

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6348826.1

CENTERFIRE PATTERN # 3



OF SHOTS= 10

IN CIRCLE

HS= 3.10
 VS= 3.36
 GS= 3.46

0
 2
 5

BARBER - M24 0039188

REMINGTON CENTERFIRE ACCURACY TEST

REMINGTON TEST LAB, ILION, N.Y.

PATTERN #: ☐ 4 ☐

POA TO CENTROID: .435

MIN RADIUS : .396

MEAN RADIUS : 1.188

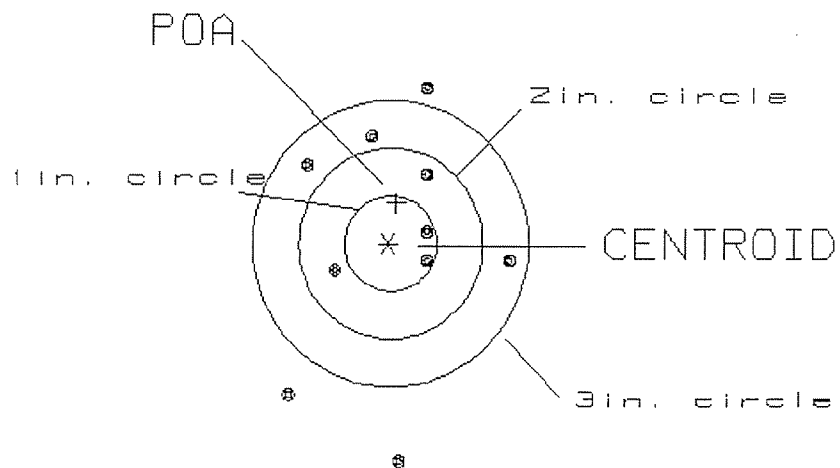
MAX RADIUS : 2.268

CENTROID X : -.090

CENTROID Y : -.426

25 Oct 2000

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6348826.1

CENTERFIRE PATTERN # 4

OF SHOTS= 10

IN CIRCLE

HS= 2.36

2

VS= 3.68

4

GS= 3.89

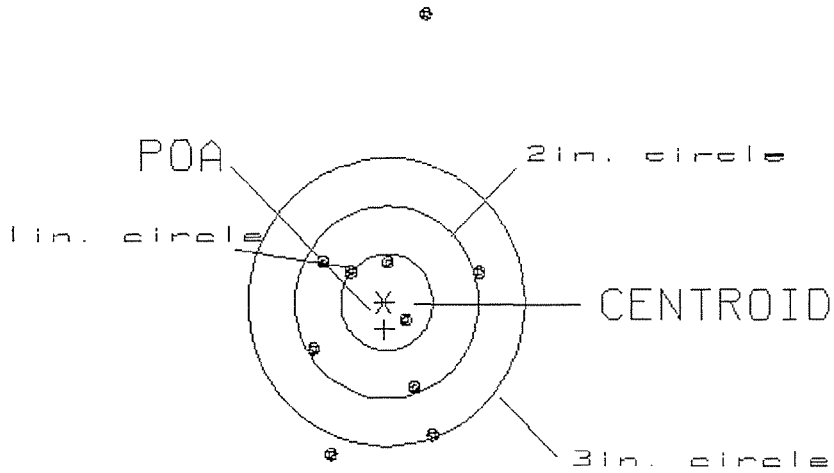
7

PATTERN #: 5
 POA TO CENTROID: .283
 MIN RADIUS : .260
 MEAN RADIUS : 1.117
 MAX RADIUS : 3.071
 CENTROID X : -.001
 CENTROID Y : .283

25 Oct 2000

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6348826.1

CENTERFIRE PATTERN # 5



OF SHOTS= 10

IN CIRCLE

HS= 1.77
 VS= 4.67
 GS= 4.78

2
 6
 8

BARBER - M24 0039190

Remington Test Lab, Ilion, N.Y.

Centroidal distance calculations for Rifle # c6348826
23 Oct 2000

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1212
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.3776
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .396574

THE AMR FOR THIS RIFLE IS: 1.465

CENTROIDAL DISTANCES

0 TO	1	.182858
1 TO	2	.735579
1 TO	3	.859694
1 TO	4	.387475
1 TO	5	.771298

1 +
2 ---- POA
4
5
3

BARBER - M24 0039191

REMINGTON CENTERFIRE ACCURACY TEST

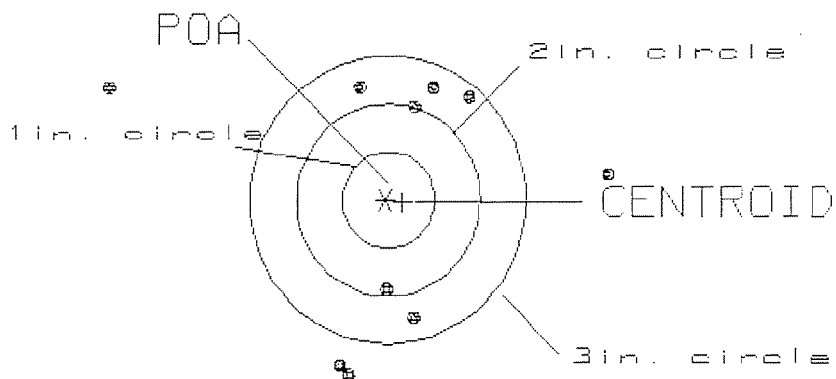
REMINGTON TEST LAB, ILION, N.Y.

PATTERN #: 010
 POA TO CENTROID: .183
 MIN RADIUS : .949
 MEAN RADIUS : 1.635
 MAX RADIUS : 3.210
 CENTROID X : -.181
 CENTROID Y : .026

23 Oct 2000

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6348826

CENTERFIRE PATTERN # 1



OF SHOTS= 10

IN CIRCLE

HS= 5.34

0

VS= 3.05

1

GS= 5.42

6

BARBER - M24 0039192

REMINGTON CENTERFIRE ACCURACY TEST

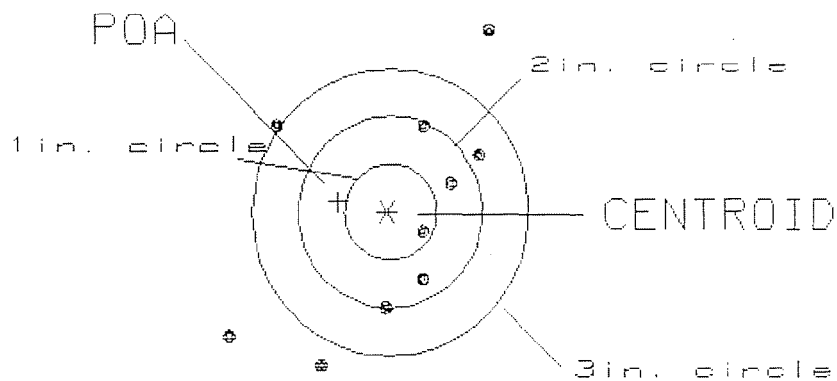
REMINGTON TEST LAB, ILION, N.Y.

PATTERN #: 2
 POA TO CENTROID: .552
 MIN RADIUS : .428
 MEAN RADIUS : 1.270
 MAX RADIUS : 2.185
 CENTROID X : .543
 CENTROID Y : -.104

23 Oct 2000

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6348825

CENTERFIRE PATTERN # 2



OF SHOTS= 10

IN CIRCLE

HS= 2.84
 VS= 3.52
 GS= 4.26

1
 5
 6

BARBER - M24 0039193

REMINGTON CENTERFIRE ACCURACY TEST

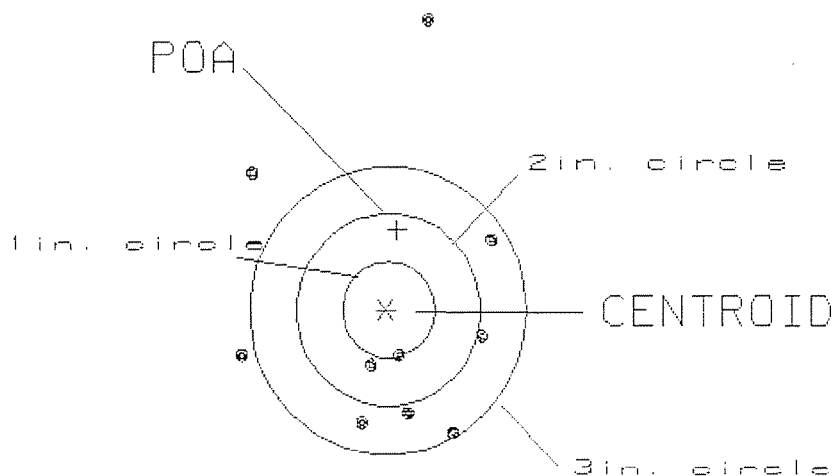
REMINGTON TEST LAB, ILION, N.Y.

PATTERN #: 3
 POA TO CENTROID: .839
 MIN RADIUS : .489
 MEAN RADIUS : 1.403
 MAX RADIUS : 3.091
 CENTROID X : -.113
 CENTROID Y : -.831

23 Oct 2000

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6348826

CENTERFIRE PATTERN # 3



OF SHOTS= 10

IN CIRCLE

HS= 2.75
 VS= 4.29
 GS= 4.30

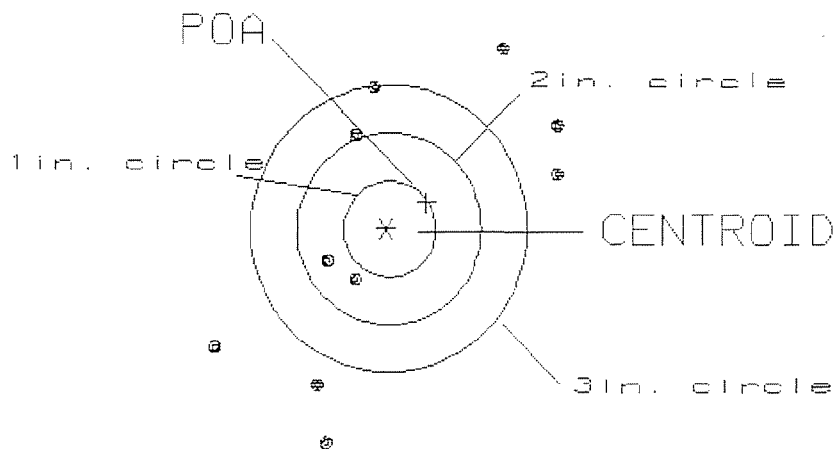
1
 2
 7

PATTERN #: 4
 POA TO CENTROID: .506
 MIN RADIUS : .634
 MEAN RADIUS : 1.674
 MAX RADIUS : 2.357
 CENTROID X : -.425
 CENTROID Y : -.275

23 Oct 2000

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/cb348826

CENTERFIRE PATTERN # 4



OF SHOTS= 10

IN CIRCLE

HS= 3.75

0

VS= 4.18

2

GS= 4.59

3

BARBER - M24 0039195

REMINGTON CENTERFIRE ACCURACY TEST

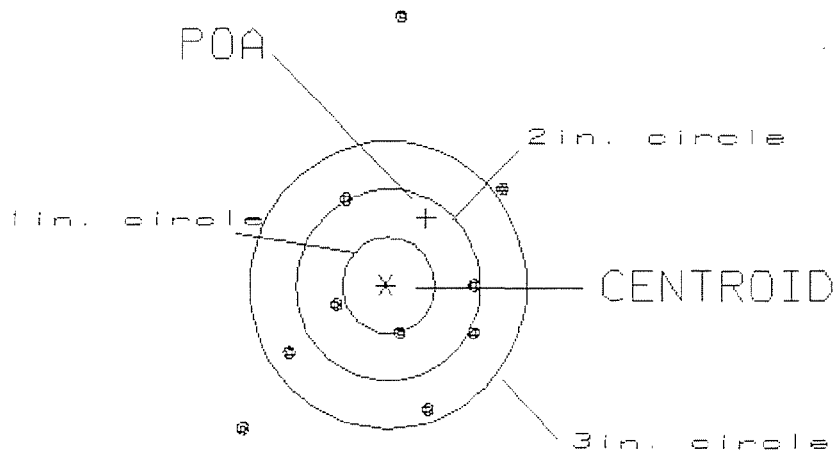
REMINGTON TEST LAB, ILION, N.Y.

PATTERN #: 5
 POA TO CENTROID: .825
 MIN RADIUS : .521
 MEAN RADIUS : 1.341
 MAX RADIUS : 2.835
 CENTROID X : -.430
 CENTROID Y : -.704

23 Oct 2000

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6348826

CENTERFIRE PATTERN # 5



OF SHOTS= 10

IN CIRCLE

HS= 2.86

0

VS= 4.31

3

GS= 4.63

7

Remington[®] **DUPONT**
REG. U.S. PAT. & TM. OFF.

MODEL 700™ H24

SERIAL NO.
C6348826

ORDER NO.
5716

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

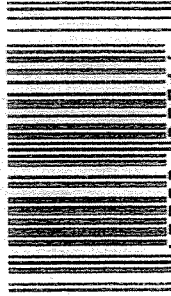
VERY IMPORTANT:
Instruction Book
enclosed to assure
safe use of this
firearm.

21



5716 C6348826

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6348826

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	QUALITY AUDIT	7 11 89	RW
600	Proof		7 11 89	RW
607	Check Headspace		7 11 89	RW
610	Dis-assemble Gun		7 11 89	RW
612	Magnaflux Barrel Action		7/13	KCR
	Magnaflux Bolt	RODDED	7/13	KCR
615	Rollmark Caliber		7/13	SS
617	Drill and Tap Sight Holes	7 13	89	FB
618	Polish Barrel RB	7 13	89	BT
620	Apply Coatings (Barrel Action)		7/21/89	TJA
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		7/25/89	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		7/25/89	RW
	C) Inspect Ejector Hole for Chamfer		7/25/89	RW
	D) Oil Firing Pin Ass'y		7/25/89	RW
	E) Adjust Trigger Pull to Min Setting and Stake		1 Aug 89	JSS

op. #	OP. NAME	READINGS			DATE	INIT
625 cont.	F) Safety On Force	5	4	4	1 aug 89	JS
	G) Safety Off Force	3	3	3	1 aug 89	JS
	H) Trigger Pull Test & Retainability				1 aug 89	JS
	I) Firing Pin Indent	.021	.0215	.0215	1 aug 89	JS
	J) Assemble Stock				8/3/89	RW
	K) Assemble Swivel Studs				1 aug 89	JS
	L) Attach Front and Rear Sight Assemblies				8/3/89	RW
	M) Iron Sight Alignment				8/3/89	RW
	N) Detach Front & Rear Sights & place in numbered container				8/3/89	RW
	O) Attach Scope to Rifle				8/4/89	JS
	P) Detach & Attach Scope 20 Times				8/4/89	JS
640	Gallery Target & Test	86 R	66 L		8-4-89	A
	A) Time				8-4-89	A
	B) Malfunctions				8-4-89	A
	C) Pierced Primers				8-4-89	A
	D) Optical Clarity of Scope				8-4-89	A
645	Inspect for Live Ammo				8-4-89	A
655	Final Inspection				1 aug 89	JS
	A) Headspace				1 aug 89	JS
	B) Trigger Pull	207	219	222	1 aug 89	JS
	C) Function				1 aug 89	JS
660	Pack				19 Sep 89	JS

BARBER - M24 0039199

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C6348826DATE 7-9-90TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#	COMMENTS
PULL #1	2.37	2.13	2.20	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.42	2.33	2.24	
PULL #3	2.45	2.41	2.21	
PULL #4	2.24	2.21	2.30	
PULL #5	2.31	2.18	2.32	
TOTAL	11.79	11.26	11.29	
AVG.	2.358	2.252	2.258	

	3.00# INITIAL	3.00# AFTER 20 CYCLES	COMMENTS
PULL #1	3.29	3.42	
PULL #2	3.32	3.40	
PULL #3	3.28	3.38	
PULL #4	3.40	3.39	
PULL #5	3.38	3.39	
TOTAL	16.67	16.98	
AVG.	3.334	3.396	

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.18	4.35		4.41
PULL #2	4.40	4.41		4.41
PULL #3	4.35	4.45		4.32
PULL #4	4.32	4.42		4.45
PULL #5	4.35	4.43		4.45
TOTAL	21.60	22.06		22.04
AVG.	4.32	4.412		4.408

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6348826
4 Aug 1989

CENTROIDAL DISTANCES

5 TO	1	.31044
1 TO	2	.2364
1 TO	3	.298062
1 TO	4	.189156
1 TO	5	.128845

4
-----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0546
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .239
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .245157
THE RMR FOR THIS RIFLE IS: 1.051

4 Aug 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C334B826

CENTERFIRE PATTERNS # 1

POA

1in circle

2in circle

3in circle

OF SHOTS= 10

IN CIR

1in = 2

2in = 4

3in = 9

ME= 2.676

VS= 2.736

GS= 3.132

CENTROID #

PATTERN #

1

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.399

1.434

.431

MINIMUM X

-1.277

-1.121

-.942

MAXIMUM Y

1.195

1.024

1.094

MINIMUM Y

-1.541

-1.348

-1.278

CENTROID X

.087

-.069

-.248

CENTROID Y

.298

.469

.399

POA TO CENTROID in.

.310

.474

.470

MIN RADIUS

.360

.369

.258

MEAN RADIUS

1.040

.891

.783

MAX RADIUS

2.081

1.539

1.349

HORIZONTAL SPREAD

2.676

2.555

1.373

VERTICAL SPREAD

2.736

2.372

2.372

EXTREME SPREAD

3.132

2.667

2.382

NUMBER IN ONE INCH CIRCLE =

2

NUMBER IN TWO INCH CIRCLE =

4

NUMBER IN THREE INCH CIRCLE =

9

4 Aug 1985

FILE:/PATTERNING/CENTERFIRE_PATT/CS346826

CENTERFIRE PATTERNS

2

POA

1in circle

2in circle

3in circle

OF SHOTS= 10

IN CIR

1in = 2

2in = 3

3in = 9

HS= 2.740

VS= 2.365

GS= 2.957

CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.208	1.038	.899
MINIMUM X	-1.532	-1.257	-1.127
MAXIMUM Y	1.113	1.054	1.119
MINIMUM Y	-1.252	-1.311	-1.246
CENTROID X	.153	.323	.193
CENTROID Y	.071	.130	.065
POA TO CENTROID in.	.159	.348	.204
MIN RADIUS	.341	.306	.355
MEAN RADIUS	1.058	.982	.950
MAX RADIUS	1.622	1.345	1.288
HORIZONTAL SPREAD	2.740	2.295	2.026
VERTICAL SPREAD	2.365	2.365	2.365
EXTREME SPREAD	2.957	2.503	2.381
NUMBER IN ONE INCH CIRCLE	=	2	
NUMBER IN TWO INCH CIRCLE	=	3	
NUMBER IN THREE INCH CIRCLE	=	9	

4 Aug 1989

FILE: \PATTERNING\CENTERFIRE_PATT\06340826

CENTERFIRE PATTERNS

3

POA

1in circle

2in circle

3in circle

OF SHOTS - 10

IN CIR

1in = 1

2in = 4

3in = 9

CENTROID #

HS = 2.552

VS = 2.583

GS = 2.775

PATTERN #

3

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.093

1.127

.949

MINIMUM X

-1.460

-1.425

-1.321

MAXIMUM Y

1.470

1.200

1.181

MINIMUM Y

-1.113

-.949

-.971

CENTROID X

.052

.018

.197

CENTROID Y

.002

-.162

-.140

POA TO CENTROID in.

.053

.163

.241

MIN RADIUS

.356

.292

.155

MEAN RADIUS

1.108

1.039

.976

MAX RADIUS

1.582

1.553

1.428

HORIZONTAL SPREAD

2.552

2.552

2.269

VERTICAL SPREAD

2.583

2.152

2.152

EXTREME SPREAD

2.775

2.775

2.412

NUMBER IN ONE INCH CIRCLE =

1

NUMBER IN TWO INCH CIRCLE =

4

NUMBER IN THREE INCH CIRCLE =

9

4 Aug 1989

FILE: PATTERNING/CENTERFIRE_PATT/C8348826

CENTERFIRE PATTERNS

4

POA

1 in circle

2 in circle

3 in circle

OF SHOTS= 10

IN CIR

1 in = 3

2 in = 5

3 in = 9

HS= 2.709

VS= 1.637

GS= 2.719

CENTROID X

PATTERN

#

4

SHOTS (BEST OF)

#

10

9

8

MAXIMUM X

#

1.727

1.328

.838

MINIMUM X

#

-.982

-.790

-.624

MAXIMUM Y

#

1.062

1.024

.994

MINIMUM Y

#

-.575

-.613

-.643

CENTROID X

#

-.071

-.263

-.429

CENTROID Y

#

.402

.440

.470

POA TO CENTROID in.

#

.408

.512

.636

MIN RADIUS

#

.082

.243

.145

MEAN RADIUS

#

.872

.751

.653

MAX RADIUS

#

1.760

1.350

1.125

HORIZONTAL SPREAD

#

2.709

2.118

1.462

VERTICAL SPREAD

#

1.637

1.637

1.637

EXTREME SPREAD

#

2.719

2.150

2.002

NUMBER IN ONE INCH CIRCLE =

#

3

5

NUMBER IN TWO INCH CIRCLE =

#

5

9

NUMBER IN THREE INCH CIRCLE =

#

9

9

4 Aug 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C6348326

CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 0

2in = 3

3in = 7

HS= 2.733

VS= 2.558

GS= 3.117

CENTROID *

PATTERN

5

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.478	1.590	1.687
MINIMUM X	-1.255	-1.143	-1.046
MAXIMUM Y	1.492	1.657	1.585
MINIMUM Y	-1.066	-0.901	-0.694
CENTROID X	.052	-.060	-.157
CENTROID Y	.422	.257	.050
POA TO CENTROID in.	.425	.264	.165
MIN RADIUS	.563	.433	.408
MEAN RADIUS	1.178	1.078	.957
MAX RADIUS	1.794	1.828	1.703
HORIZONTAL SPREAD	2.733	2.793	2.733
VERTICAL SPREAD	2.558	2.558	1.279
EXTREME SPREAD	3.117	2.887	2.847
NUMBER IN ONE INCH CIRCLE =		0	
NUMBER IN TWO INCH CIRCLE =		3	
NUMBER IN THREE INCH CIRCLE =		7	