

C6348984

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5716**

* Includes 1 in chamber.



Still
around

Repair Inquiry

Repair Number: RE00129490

Serial: C6348984 Model M24 SWS Center Fire
Caliber: 7.62 NATO

Repairman:

Verify Repair

Status:

New 5/18/2007 7:29:28 AM

Address Information

Customer:

☒ Received From

Return To:

☐ Received From

Name: FMC 25TH BSB (1-25TH SBCT)

FMC 25TH BSB (1-25TH SBCT)

Address 1: ATTN: CW3 A.J. AIYETORO

ATTN: CW3 A.J. AIYETORO

Address 2: 1060 GAFFNEY ROAD #9100

PO Box:

1060 GAFFNEY ROAD #9100

PO Box:

City: FORT WAINWRIGHT

FORT WAINWRIGHT

State: AK

Zip Code: 99703

Country: US

State: AK

Zip Code: 99703

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
A057	Fit and Rear Sgt Base	1

Repair Search

Refresh

Close

nagletj

5/18/2007

8:00 AM

CAPS

NUM

INS

SCRL

start

3 M...

2 M...

5 I...

Part ...

Arms...

Stoc...

8:00 AM

Serial Number: C6348984

Model: M24 SWS



RE00129490

New
Bi. POD

MAINTENANCE REQUEST For use of this form, see DA PAM 738-750 and 738-751; the proponent agency is DCSLOG				PAGE NO. 1	NO OF PAGES 3	REQUIREMENT CONTROL SYMBOL CSGLD-1047(R1)																	
SECTION I - CUSTOMER DATA				SECTION II - MAINTENANCE ACTIVITY DATA																			
1a. UIC CUSTOMER WDPRB0		1b. CUSTOMER UNIT NAME FMC 25 TH BSB		1c. PHONE NO 907-353-1721		3a. WORK ORDER NUMBER (WON)		3b. SHOP		3c. PHONE NO													
2a. SAMS-2 UIC/SAMS-I/TDA		2b. UTILIZATION CODE		2c. MCSR		4a. UIC SUPPORT UNIT		4b. SUPPORT UNIT NAME															
SECTION III - EQUIPMENT DATA																							
5. TYPE MNT REQ CODE		6. ID A		7. NSN 1005-01-240-2136		15a. FAILURE DETECTED DURING/WHEN DISCOVERED CODE (Enter code) - See Maintenance SOP				F													
8. MODEL M24		9. NOUN SNIPER WEAPON SYSTEM		10a. ORG WON/DOC NO DPRO3A700533		10b. EIC		15b. FIRST INDICATION OF TROUBLE/ HOW RECOGNIZED CODE (Enter Code) See DA Maintenance SOP		16. MILES/KILOMETERS/HOURS/ROUNDS M K													
11 SERIAL NUMBER C6348984		12. QTY 01		13. PD 02		17. PROJECT CODE (if assigned)		18. ACCOUNT ROCESSING CODE		19. IN WARRANTY? (enter Y or N)		20. ADMIN NO											
14. MALFUNCTION DESCRIPTION (for DSU. GSU/AVIM. DEPOT use)				21. REIMBURSABLE CUSTOMER (if In transit customer enter Y or N)				22. LEVEL OF WORK D				23. SIGNATURE											
24. DESCRIBE DEFICIENCIES OR SYMPTOMS ON THE BASIS OF COMPLETE CHECKOUT AND DIAGNOSTIC PROCEDURES IN EQUIPMENT TM (Do not prescribe repairs) FRONT SIGHT POST BENT																							
25. REMARKS																							
26. TECHNICAL REFERENCES																							
SECTION IV - TASK REQUIREMENTS DATA																							
27a. FILE INPUT ACT CD		27b. TASK NO		27c. ACT CODE		27d. TASK DESCRIPTION		27e. QTY TO BE RPR		27f. WORK CENTER		27g. FAILURE CODE		27h. MH PROJ		27i. MH EXP							
SECTION V - PART REQUIREMENTS																							
28a. FILE INPUT ACT CD		28b. TASK NO		28c. ID NO		28d. NSN OR PART NUMBER		28e. SFX CD		28f. QTY RQD		28g. QTY ISSUED		28h. NMCS CD		28i. FAILURE CODE		28j. STORAGE LOCATION		28k. INITIALS		28l. COST \$	
28m. TOTAL MANHOURS				28n. TOTAL MANHOURS COSTS \$				28o. TOTAL PARTS COSTS\$															
SECTION VI - COMPLETION DATA																							
29. QTY RPR		30. QTY CONDEMN		31. QTY NRTS		32. EVAC WON		33. EVAC UNIT NAME															
SECTION VII - ACTION SIGNATURES																							
34a. SUBMITTED BY A5419		35a. ACCEPTED BY		35c. DATE		36a. WORK STARTED BY		37a. INSPECTION BY		38a. PICKED UP BY													
34b. DATE		35b. STATUS		35d. TIME		36b. STATUS		36c. DATE		36d. TIME		37b. STATUS		37c. DATE		37d. TIME		38b. STATUS		38c. DATE		38d. TIME	

[illegible]

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6348984.___0

FILE DATE AND TIME: 07/09/2007 06:58

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.036
The Average Y Centroid of the Five Target Set:	0.061
The Average Point of Impact of the Five Target Set:	0.070
The Average Mean Radius of the Five Target Set:	0.694
The Distance from POA to Centroid Target #1:	0.145
The Distance from Centroid Target #2 to Centroid Target #1:	0.283
The Distance from Centroid Target #3 to Centroid Target #1:	0.029
The Distance from Centroid Target #4 to Centroid Target #1:	0.259
The Distance from Centroid Target #5 to Centroid Target #1:	0.087

SERIAL NUMBER: C6348984. __0

TARGET NUMBER: 1

FILE DATE: 07/09/2007

FILE TIME: 06:58

X CENTROID: -0.057

Y CENTROID: 0.133

POA TO CENTROID: 0.145

HORZ SPREAD: 1.752

VERT SPREAD: 2.803

GROUP SPREAD: 2.844

MIN RADIUS: 0.444

MAX RADIUS: 1.798

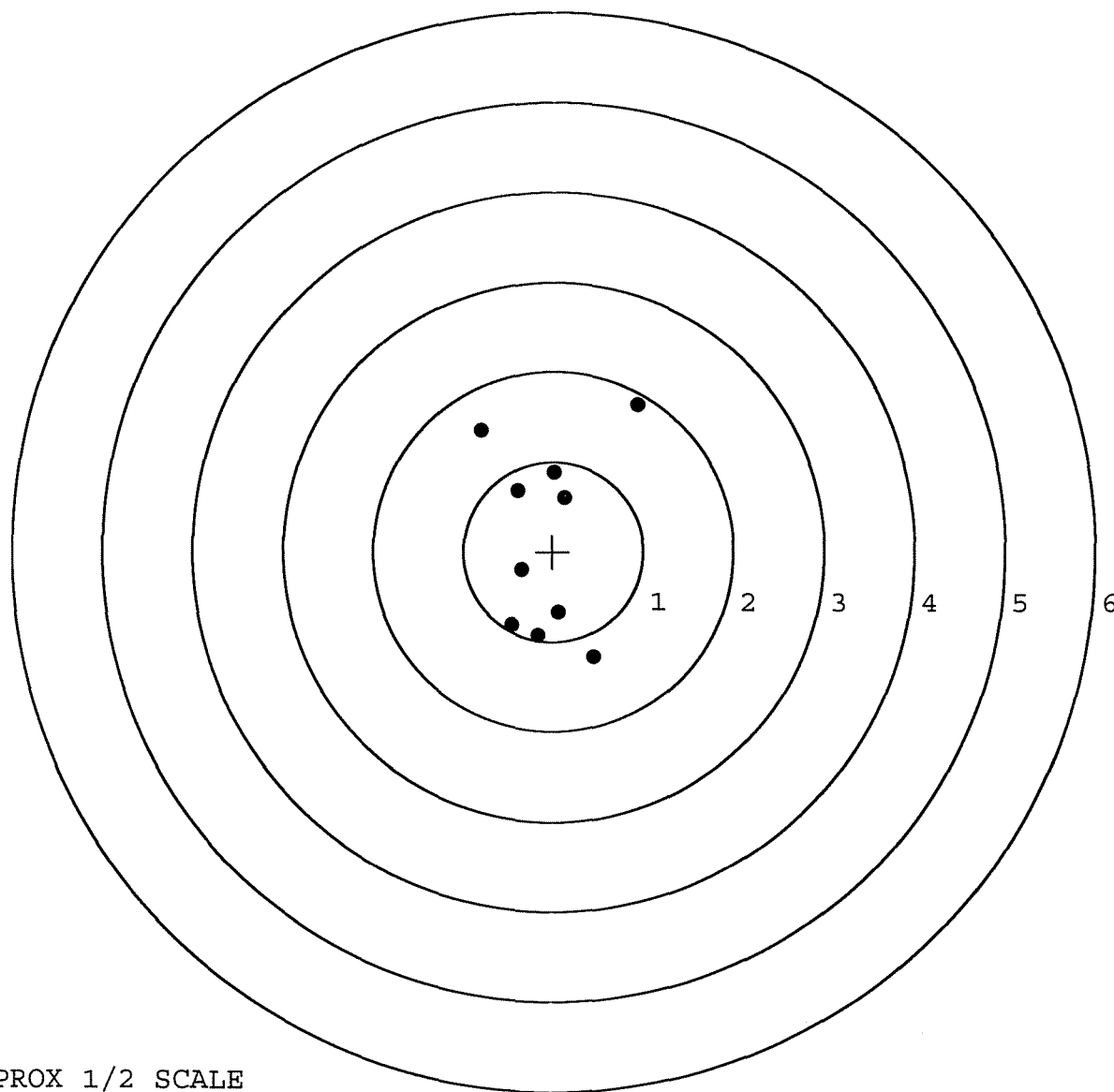
MEAN RADIUS: 0.990

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 5

in 3 IN DIAMETER: 9

POINT#	X	Y
1:	0.133	0.600
2:	0.019	0.882
3:	-0.399	0.682
4:	-0.349	-0.201
5:	0.065	-0.676
6:	-0.161	-0.936
7:	-0.460	-0.814
8:	0.459	-1.173
9:	0.939	1.630
10:	-0.813	1.340



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6348984. 0

TARGET NUMBER: 2

FILE DATE: 07/09/2007

FILE TIME: 06:58

X CENTROID: 0.058

Y CENTROID: -0.125

POA TO CENTROID: 0.138

HORZ SPREAD: 1.252

VERT SPREAD: 1.537

GROUP SPREAD: 1.543

MIN RADIUS: 0.175

MAX RADIUS: 1.044

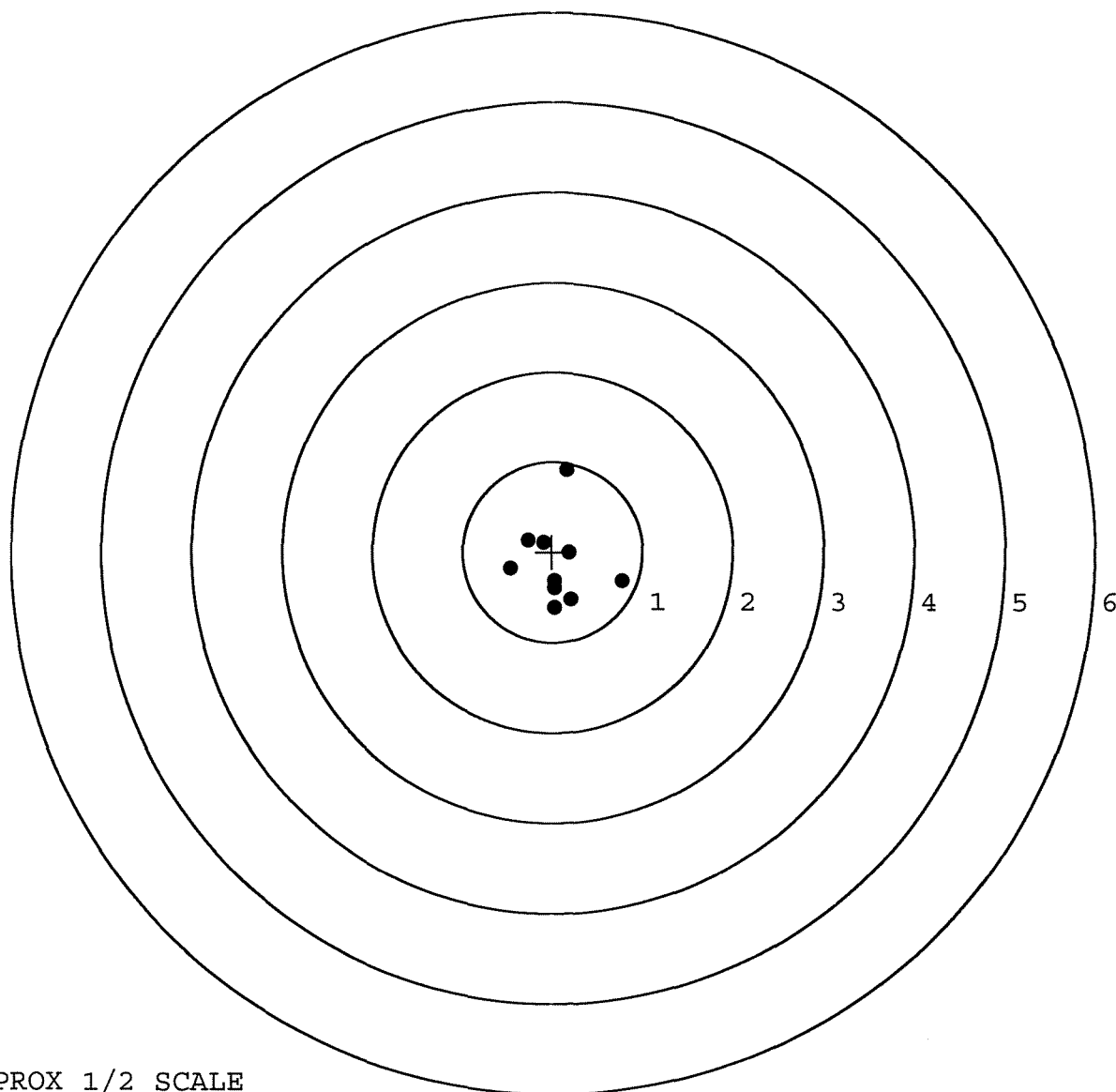
MEAN RADIUS: 0.461

IN 1 IN DIAMETER: 7

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.779	-0.322
2:	0.164	0.913
3:	-0.473	-0.183
4:	-0.279	0.127
5:	-0.096	0.103
6:	0.189	-0.010
7:	0.030	-0.325
8:	0.211	-0.528
9:	0.027	-0.624
10:	0.027	-0.405



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6348984. __ 0

TARGET NUMBER: 3

FILE DATE: 07/09/2007

FILE TIME: 06:58

X CENTROID: -0.030

Y CENTROID: 0.144

POA TO CENTROID: 0.147

HORZ SPREAD: 2.301

VERT SPREAD: 1.875

GROUP SPREAD: 2.533

MIN RADIUS: 0.433

MAX RADIUS: 1.503

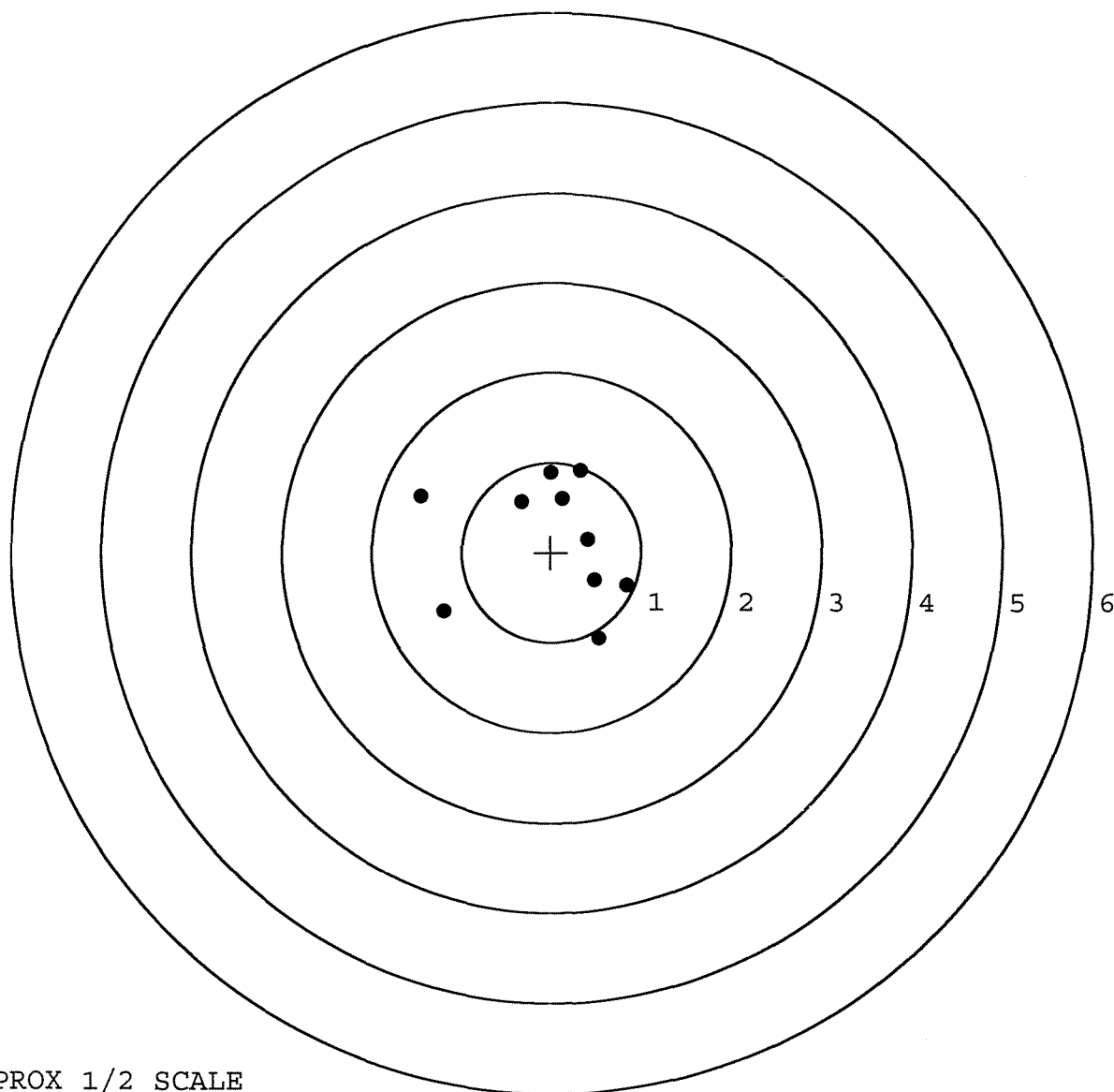
MEAN RADIUS: 0.888

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 9

POINT#	X	Y
1:	0.527	-0.957
2:	0.846	-0.367
3:	0.483	-0.308
4:	0.403	0.149
5:	0.121	0.595
6:	-0.336	0.562
7:	-1.197	-0.666
8:	-1.455	0.620
9:	0.321	0.918
10:	-0.010	0.892



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6348984. __0

TARGET NUMBER: 4

FILE DATE: 07/09/2007

FILE TIME: 06:58

X CENTROID: 0.179

Y CENTROID: 0.024

POA TO CENTROID: 0.180

HORZ SPREAD: 1.268

VERT SPREAD: 1.307

GROUP SPREAD: 1.454

MIN RADIUS: 0.358

MAX RADIUS: 0.791

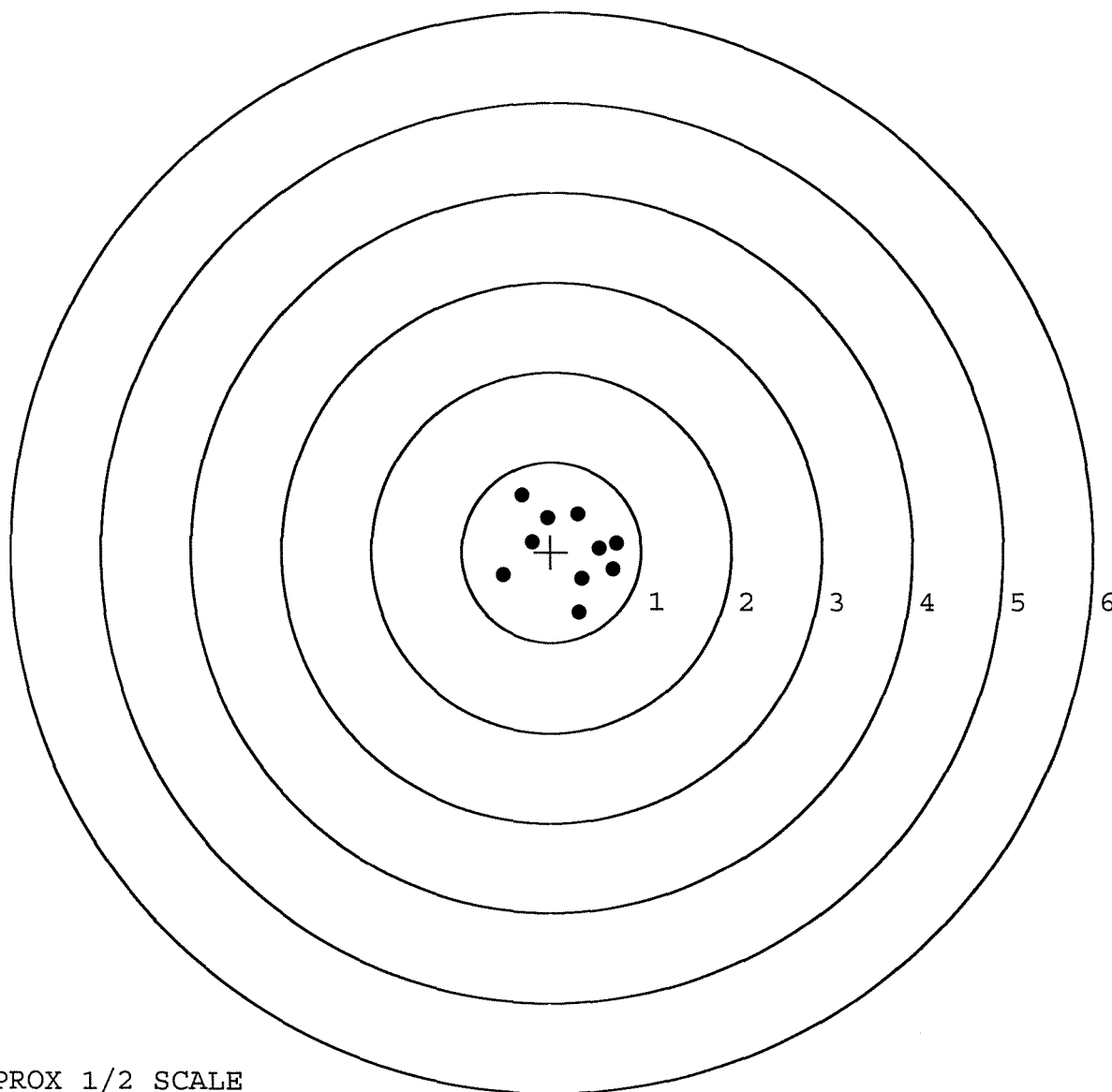
MEAN RADIUS: 0.534

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.732	0.098
2:	0.688	-0.196
3:	0.340	-0.304
4:	0.536	0.045
5:	0.299	0.420
6:	-0.044	0.374
7:	-0.211	0.108
8:	-0.536	-0.263
9:	-0.328	0.632
10:	0.309	-0.675



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6348984. 0

TARGET NUMBER: 5

FILE DATE: 07/09/2007

FILE TIME: 06:58

X CENTROID: 0.030

Y CENTROID: 0.127

POA TO CENTROID: 0.131

HORZ SPREAD: 1.594

VERT SPREAD: 0.834

GROUP SPREAD: 1.623

MIN RADIUS: 0.197

MAX RADIUS: 0.948

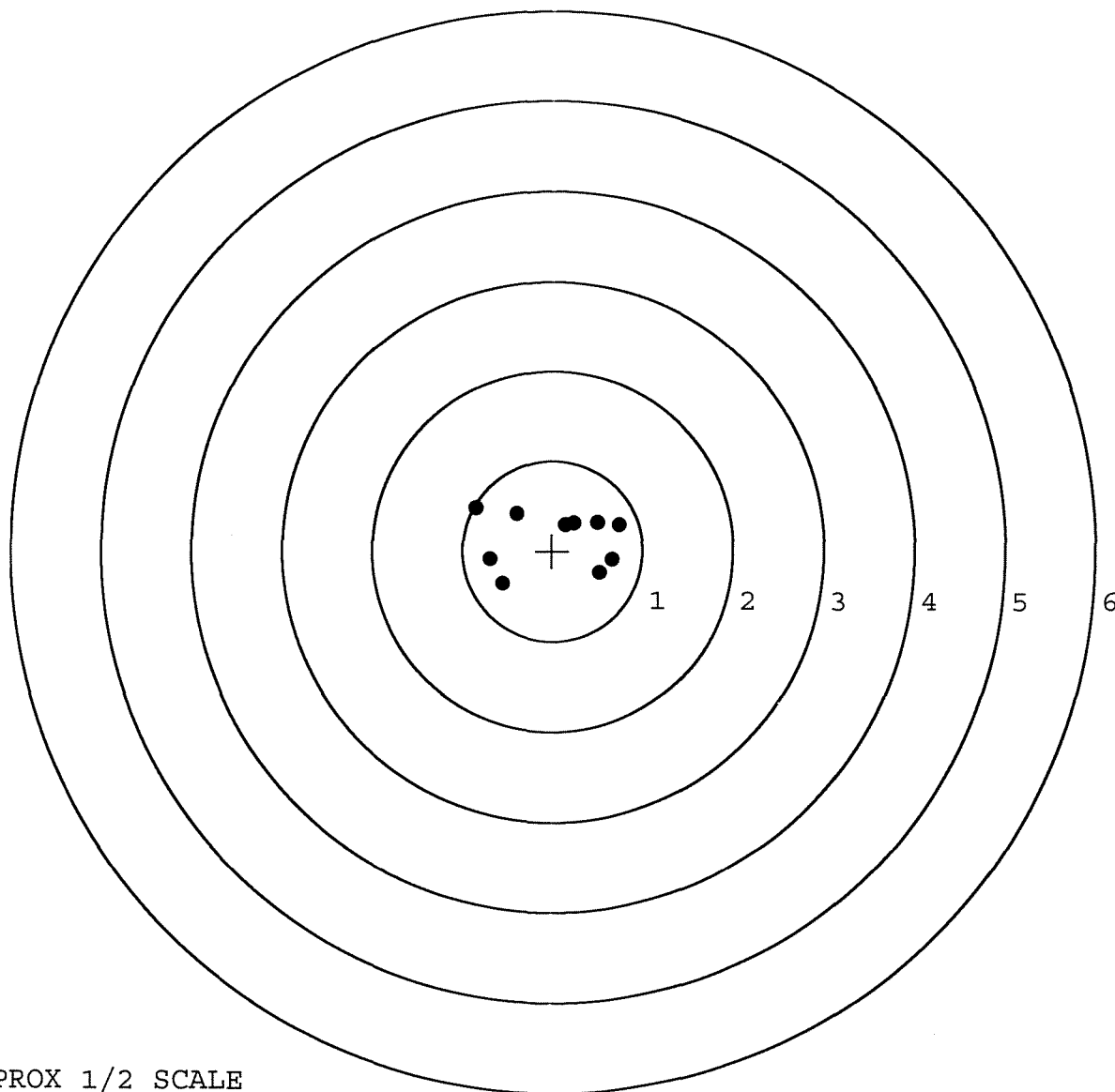
MEAN RADIUS: 0.599

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.523	-0.245
2:	0.666	-0.100
3:	0.739	0.291
4:	0.500	0.316
5:	0.239	0.308
6:	0.143	0.289
7:	-0.403	0.410
8:	-0.855	0.467
9:	-0.697	-0.098
10:	-0.554	-0.367



TARGET APPROX 1/2 SCALE

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)

DATE 6-6-07TESTER TRW

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.51	2.45		2.40	
PULL #2	2.42	2.35		2.30	
PULL #3	2.76	2.25		2.42	
PULL #4	2.80	2.37		2.48	
PULL #5	2.71	2.34		2.41	
TOTAL	13.20	11.76		12.01	
AVERAGE	2.64	2.35		2.40	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.22	3.41		
PULL #2	3.19	3.24		
PULL #3	3.07	3.20		
PULL #4	3.12	3.21		
PULL #5	3.20	3.29		
TOTAL	15.80	16.35		
AVERAGE	3.16	3.27		

	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	4.06	3.92		4.57
PULL #2	4.22	3.88		4.04
PULL #3	4.17	3.91		4.00
PULL #4	4.01	3.85		4.02
PULL #5	3.97	3.89		3.99
TOTAL	20.43	19.45		20.62
AVERAGE	4.08	3.89		4.12

R & E NUMBER	129490		
SERIAL NUMBER	C6348984		
LOG-IN DATE	5-18-07		
OPERATION #	OPERATION NAME	DATE	INITIAL
500	DIS-ASSEMBLE GUN	6-12-07	RTZ
505	RE-BARREL	6-15-07	RTZ
560	ASSEMBLE	6-18-07	RTZ
600	PROOF	6-18-07	TRW
605	CHECK HEADSPACE	6-18-07	TRW
610	DIS-ASSEMBLE GUN	6-18-07	RTZ
612	MAGNAFLUX	6-19-07	Wms
510	DRILL AND TAP	6-18-07	SD
615	ROLLMARK CALIBER	6-19-07	CW
618	ROTO-BLAST	6-19-07	DG
620	APPLY COATINGS	6-21-07	TS
625	FINAL ASSEMBLY	7-5-07	J.P.D.
640	FUNCTION TEST AND	(PASS) FAIL	7-6-07 TRW
650	TARGET	(PASS) FAIL	7-6-07 TRW
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	7-6-07 MAD
670	FINAL INSPECTION	7-9-07	DA
	A) HEADSPACE	PASS FAIL	7-9-07 DA
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	2.64 2.61 2.63 2.66 2.56 7-9-07 DA
680	F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX	6.0 6.5 6.5 7-9-07 DA
	G) SAFETY OFF FORCE	2 LBS MIN	3.0 3.5 3.5 7-9-07 DA
	I) FIRING PIN INDENT	.020	.023 .024 .024 7-9-07 DA
690	PACK		7-11-07 DA

RECEIVING AND ESTIMATING REPORT

R 96-02008

INITIAL	CUSTOMER ORDER NO.
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JAM

W/LEUPOLD SCOPE W/BI-FOD
W/DEPLOYMENT KIT

DATE RECEIVED	DATE OPENED	DATE CODE	SERIAL NUMBER	NEW SERIAL NUMBER	MODEL AND GRADE
01/16/86	01/17/86		C6348984		700 7

DATE	TIME	LOCATION	WIND	TEMP	REL	WIND	TEMP	REL	WIND	TEMP	REL	WIND	TEMP	REL	WIND	TEMP	REL
01/17/72	01:17:02					2000	12:02		1000	13:02		1000	13:02		1000	13:02	
ACCESSORIES			HARD CASE			SCOPE MNTS			SCOPE BASE								

FROM:

SHIP TO:

US ARMY
HHC 4/9 INF
FT WAINWRIGHT

AK 99703

US ARMY
HHC 4/9 INF
FT WAINWRIGHT

AK
99703

CUST NO:135896 C.O.D

ACCOUNT NUMBER	ACCOUNT NUMBER N/C
----------------	--------------------

WRITE

PROM. DATE	ESTIMATED	VIA UPS
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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

✓ Barrel 1 - 96003	
✓ Stock - 96018	
✓ Scope Dust Cover front & Rear - 96043 & 96044	
✓ Bi pod - 96117	Repowder Coat - Trigger Guard
✓ Soft Carrying Case 96076	Assy Front & Rear Sight Bases
	ReZinc Scope Base & Swivel
	Studs, Scope Rings

REPAIRMAN <i>RW</i>	PROOF <i>✓</i>	CLEAN <i>✓</i>	TEST <i>A</i>	TARGET <i>A</i>	PATTERN
GALLERY TESTER <i>RW</i>	DATE <i>1/22/96</i>	DATE <i>2/1/96</i>	DATE <i>2/1</i>	DATE <i>2/1</i>	DATE

RD6925 REV. 1/94

OFFICE COPY

BD6925 REV. 1/94

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER

BARBER - M24 ~~0043938~~ M2400043275

New Barrel / Stock

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6398984

OP. #	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and Stock		1/22/96	RW
600	Proof		1/22/96	RW
607	Check Headspace		1/22/96	RW
610	Dis-assemble Gun		1/22/96	RW
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		2/1/96	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		2/1/96	RW
	C) Inspect Ejector Hole for Chamfer		2/1/96	RW
	D) Oil Firing Pin Ass'y		2/1/96	RW
	E) Adjust Trigger Pull to Min Setting and Stake			

Op. #	OP. NAME	READINGS	DATE	INIT
625 cont.	F) Safety On Force			
	G) Safety Off Force			
	H) Trigger Pull Test & Retainability			
	I) Firing Pin Indent			
	J) Assemble Stock		2/1/96	Rw
	K) Assemble Swivel Studs			
	L) Attach Front and Rear Sight Assemblies			
	M) Iron Sight Alignment			
	N) Detach Front & Rear Sights & place in numbered container			
	O) Attach Scope to Rifle			
	P) Detach & Attach Scope 20 Times			
640	Gallery Target & Test		2/2/96	Ad
	A) Time			
	B) Malfunctions			
	C) Pierced Primers			
	D) Optical Clarity of Scope			
645	Inspect for Live Ammo		2/2/96	Ad
655	Final Inspection			
	A) Headspace		2/2/96	Rw
	B) Trigger Pull			
	C) Function		2/2/96	Rw
660	Pack			

Final Inspection

Sn: C6348984

DATE REC'D: 1/17/96

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:

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06348984
3 Jan 1988

CENTROIDAL DISTANCES

0 TO	1	1.03401
1 TO	2	.216585
1 TO	3	.170294
1 TO	4	.288259
1 TO	5	.424643

5
4
3
2

+

(----POA

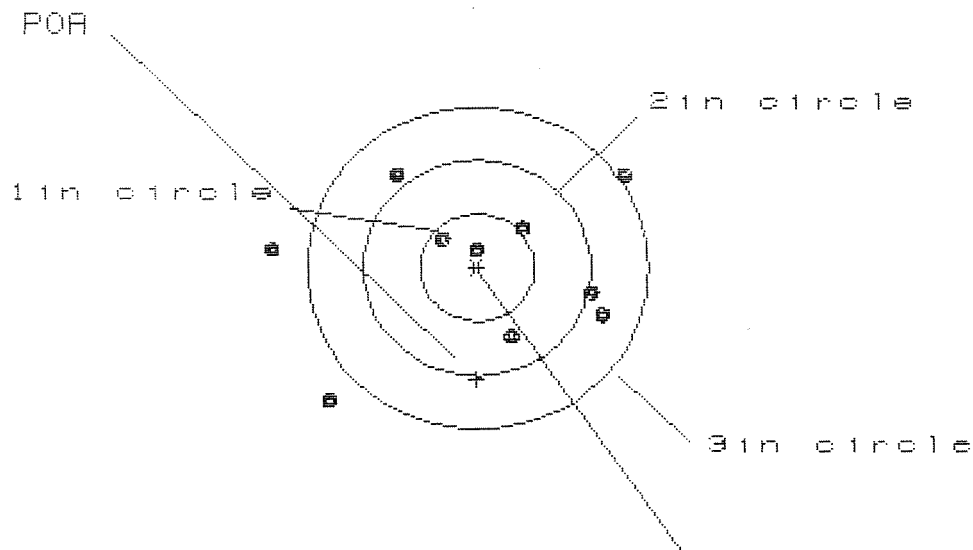
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0332
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: 1.1026
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: 1.1031

THE AMP FOR THIS RIFLE IS: 1.145

3 Jan 1968

FILE:/PATTERNING/CENTERFIRE_PATT/C6346964.1

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

CENTROID #

1 in = 2

2 in = 4

3 in = 7

HS= 3.165

VS= 2.149

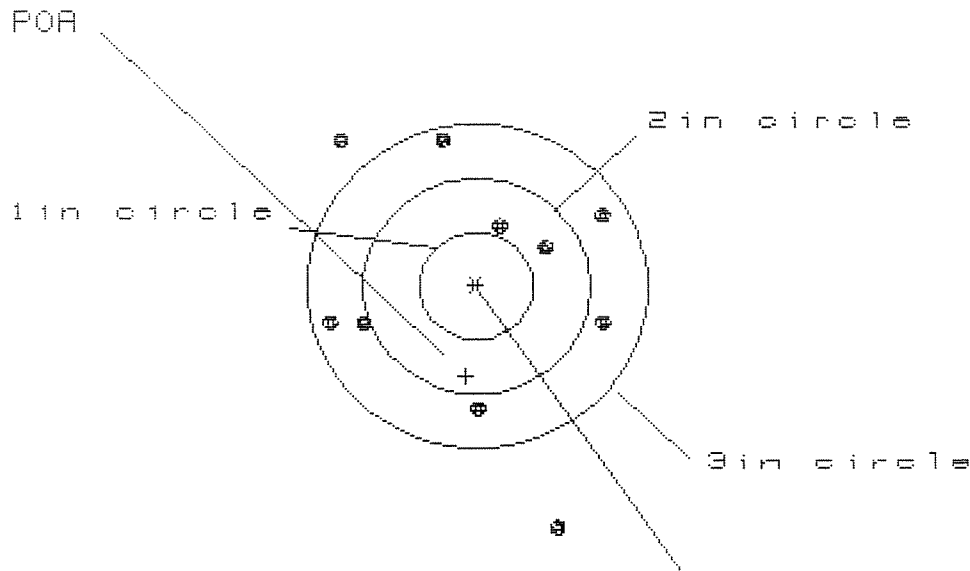
GS= 3.361

PATTERN #	:	1	2	3
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.341	1.138	.952
MINIMUM X	:	-1.824	-1.491	-1.139
MAXIMUM Y	:	.884	.904	.749
MINIMUM Y	:	-1.265	-1.245	-1.791
CENTROID X	:	.005	.208	.394
CENTROID Y	:	1.034	1.014	1.169
POA TO CENTROID in.	:	1.034	1.035	1.234
MIN RADIUS	:	.147	.250	.214
MEAN RADIUS	:	1.048	.942	.794
MAX RADIUS	:	1.833	1.942	1.363
HORIZONTAL SPREAD	:	3.165	2.629	2.091
VERTICAL SPREAD	:	2.149	2.149	1.540
EXTREME SPREAD	:	3.361	3.361	2.333
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		7	

3 Jan 1900

FILE:/PATTERNING/CENTERFIRE_PATT/C634B9B4.1

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1 in = 0

2 in = 2

3 in = 8

HS= 2.372

VS= 3.677

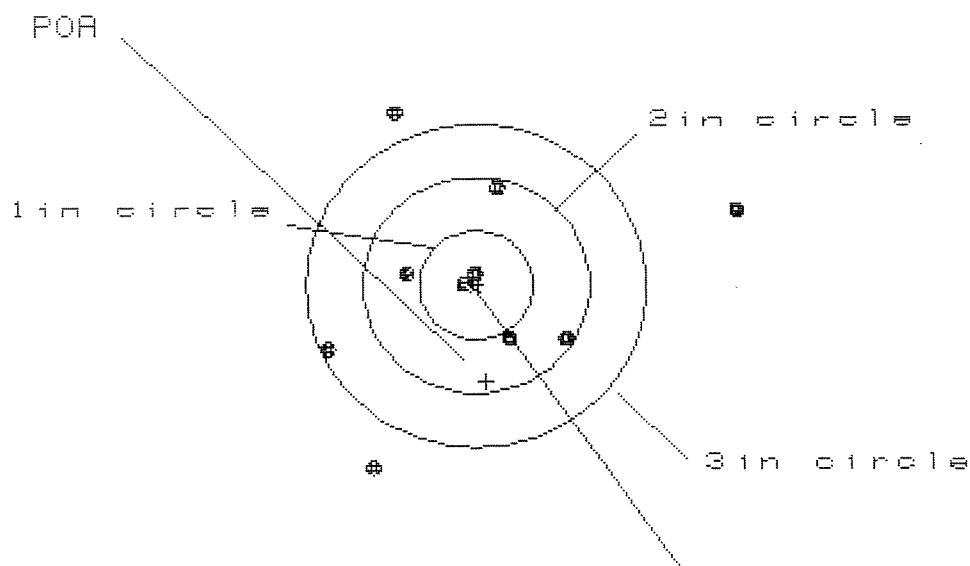
GS= 4.146

PATTERN #	2	2	2
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.095	1.179	1.040
MINIMUM X	-1.277	-1.193	-1.332
MAXIMUM Y	1.403	1.150	1.292
MINIMUM Y	-2.274	-1.414	-1.272
CENTROID X	.095	.011	.150
CENTROID Y	.837	1.090	.948
POA TO CENTROID in.	.842	1.090	.959
MIN RADIUS	.626	.447	.503
MEAN RADIUS	1.293	1.140	1.069
MAX RADIUS	2.395	1.586	1.401
HORIZONTAL SPREAD	2.372	2.372	2.372
VERTICAL SPREAD	3.677	2.564	2.564
EXTREME SPREAD	4.146	2.876	2.576
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	2		
NUMBER IN THREE INCH CIRCLE =	8		

3 Jan 1968

FILE:/PATTERNING/CENTERFIRE_PATT/C634B3B4.1

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1 in = 2

2 in = 6

3 in = 7

HS= 3.631

VS= 3.290

GS= 4.043

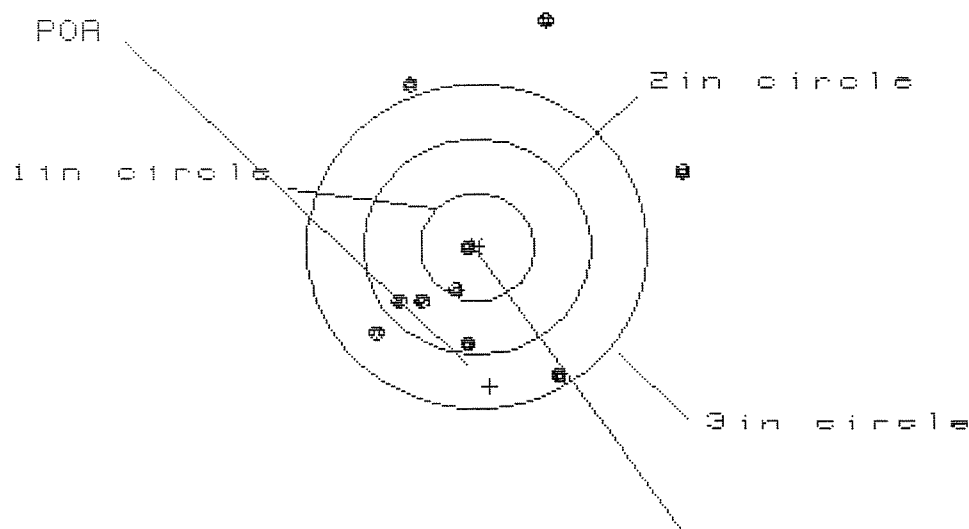
CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.337	1.084	1.000
MINIMUM X	:	-1.294	-1.034	-1.118
MAXIMUM Y	:	1.592	1.668	1.465
MINIMUM Y	:	-1.698	-1.622	-1.741
CENTROID X	:	-.089	-.349	-.265
CENTROID Y	:	.892	.816	1.019
POA TO CENTROID in.	:	.897	.888	1.053
MIN RADIUS	:	.110	.161	.172
MEAN RADIUS	:	1.087	.940	.813
MAX RADIUS	:	2.436	1.754	1.549
HORIZONTAL SPREAD	:	3.631	2.118	2.118
VERTICAL SPREAD	:	3.290	3.290	2.206
EXTREME SPREAD	:	4.043	3.299	2.593
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		7	

3 Jan 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C63483B4.1

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 7

HS= 2.756

VS= 3.332

GS= 3.333

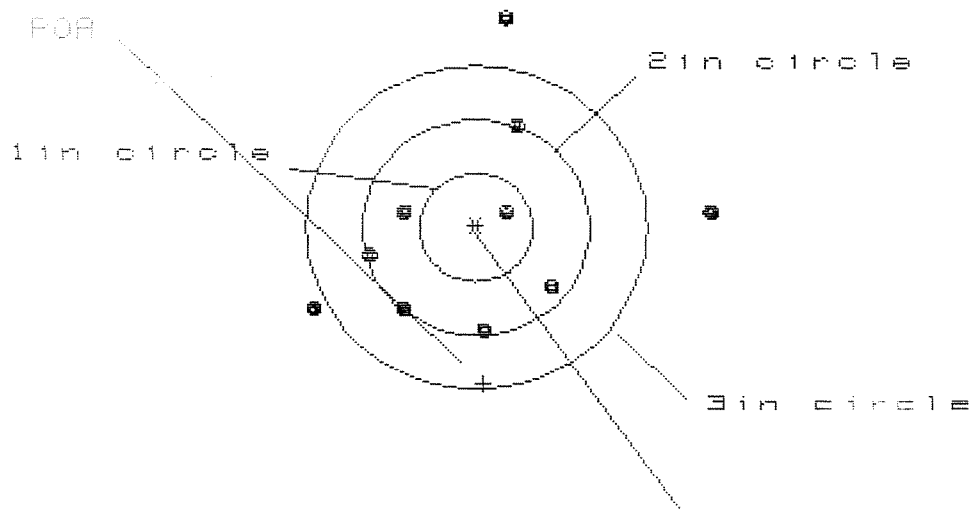
CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.838	1.907	1.027
MINIMUM X	:	-.918	-.849	-.611
MAXIMUM Y	:	2.124	1.781	1.903
MINIMUM Y	:	-1.208	-.972	-.850
CENTROID X	:	-.113	-.182	-.420
CENTROID Y	:	1.297	1.061	.939
POA TO CENTROID in.	:	1.302	1.076	1.029
MIN RADIUS	:	.128	.216	.079
MEAN RADIUS	:	1.159	.957	.719
MAX RADIUS	:	2.214	2.141	1.924
HORIZONTAL SPREAD	:	2.756	2.756	1.638
VERTICAL SPREAD	:	3.332	2.753	2.753
EXTREME SPREAD	:	3.333	3.168	3.051
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		7	

3 Jan 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C6348984.1

CENTERFIRE PATTERNS # 5



OF SHOTS= 10

CENTROID *

IN CIR

1 in = 1

2 in = 7

3 in = 7

HS= 3.509

VS= 2.907

GS= 3.634

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	2.093	.867	.924
MINIMUM X	-1.416	-1.184	-1.127
MAXIMUM Y	1.929	1.947	1.196
MINIMUM Y	-.978	-.960	-.716
CENTROID X	-.064	-.296	-.353
CENTROID Y	1.453	1.435	1.191
POA TO CENTROID in.	1.454	1.465	1.242
MIN RADIUS	.309	.478	.560
MEAN RADIUS	1.139	1.008	.850
MAX RADIUS	2.099	1.999	1.349
HORIZONTAL SPREAD	3.509	2.051	2.051
VERTICAL SPREAD	2.907	2.907	1.912
EXTREME SPREAD	3.634	3.164	2.450
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		7	

Remington®

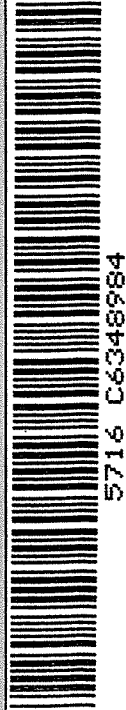
MODEL 700™ H24

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.

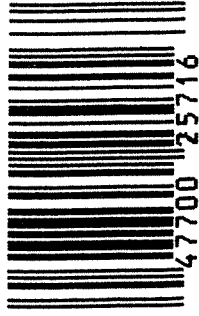
DUPONT
REG. U.S. PAT. & T.M. OFF.

SERIAL NO. C6348984	Ø1
ORDER NO. 5716	



5716 C6348984

UPC



0 47700 25716 7

ORDER # 124 0043247
replaced

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6348984

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	12-20 89		RW
600	Proof	12-20 89		A
607	Check Headspace	12-20 89		A
610	Dis-assemble Gun	12-20 89		RW
612	Magnaflux Barrel Action	1-5-90		NER
	Magnaflux Bolt	1-5-90		
615	Rollmark Caliber		1/5/90	ES
17	Drill and Tap Sight Holes		1/8/90	FB
618	Polish Barrel RB		1/9/90	WB
620	Apply Coatings (Barrel Action)		1-5-90	TS
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		1/17/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		1/17/90	RW
	C) Inspect Ejector Hole for Chamfer		1/17/90	RW
	D) Oil Firing Pin Ass'y		1/17/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		24/2/90	ES

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			1-24-90	gfl
	G) Safety Off Force	3	3	3			1-24-90	gfl
	H) Trigger Pull Test & Retainability						24/20/90	gfl
	I) Firing Pin Indent	.023	.0235	.0235			1-24-90	gfl
	J) Assemble Stock						1/24/90	RW
	K) Assemble Swivel Studs						3/13/90	WB
	L) Attach Front and Rear Sight Assemblies						1/24/90	RW
	M) Iron Sight Alignment						1/24/90	RW
	N) Detach Front & Rear Sights & place in numbered container						1/24/90	RW
	O) Attach Scope to Rifle						3/13/90	WB
	P) Detach & Attach Scope 20 Times						3/13/90	WB
640	Gallery Target & Test						3-5-90	A
	A) Time						11	A
	B) Malfunctions						11	A
	C) Pierced Primers						11	A
	D) Optical Clarity of Scope						11	A
645	Inspect for Live Ammo						3-5-90	A
655	Final Inspection						3/13/90	WB
	A) Headspace						3/13/90	WB
	B) Trigger Pull	2.27	2.67	2.55	2.71	2.68	3/13/90	GB
	C) Function						3/13/90	WB
660	Pack						20/10/90	gfl

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50#+.50#
3.00#+.75#
4.00#+1.00#

SERIAL NO. C6348984DATE 23 Jun 90TESTER JS

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	271	248	210	227	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	249	242	233	255	
PULL #3	264	265	216	267	
PULL #4	257	206	214	271	
PULL #5	259	202	239	268	
TOTAL	1300	1163	1112		
AVG.	260	2326	2224		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	340	340		
PULL #2	331	341		
PULL #3	322	357		
PULL #4	338	351		
PULL #5	316	338		
TOTAL	1647	1727		
AVG.	3294	3454		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	415	407		404
PULL #2	403	402		391
PULL #3	404	401		396
PULL #4	396	406		391
PULL #5	415	384		393
TOTAL	2033	2000		1975
AVG.	4066	400		395

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6348984
5 Mar 1998

CENTROIDAL DISTANCES

0 TO	1	.233309
1 TO	2	.41365
1 TO	3	.525148
1 TO	4	.218836
1 TO	5	.487494

$\bar{x}$ <----POA

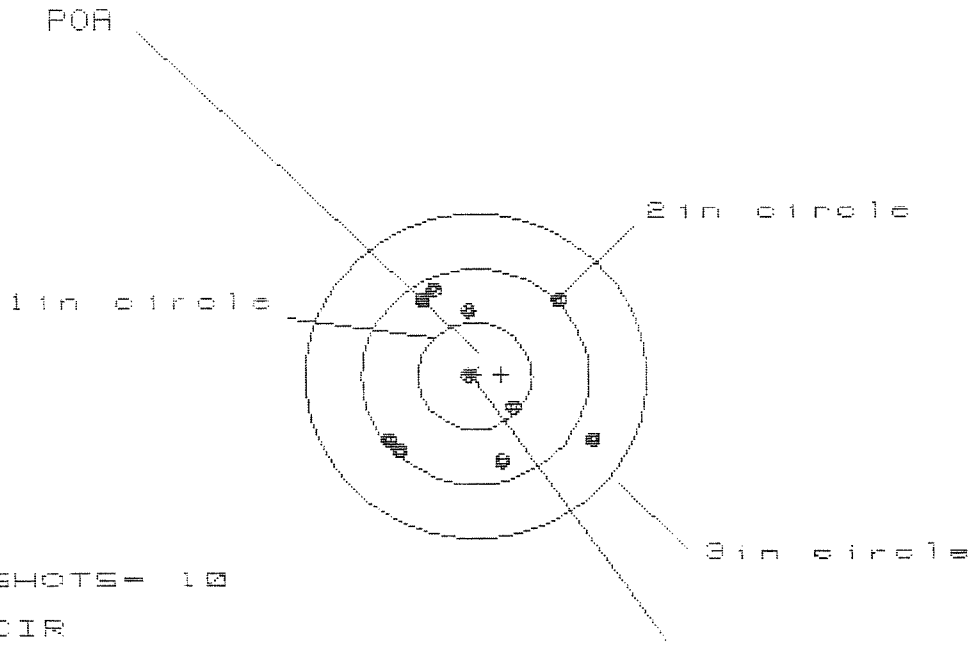
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0494
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0154
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0517448

THE AMR FOR THIS RIFLE IS: .9782

5 Mar 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C8340984

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1in = 2

2in = 8

3in = 10

HS= 1.782

VS= 1.612

GS= 2.065

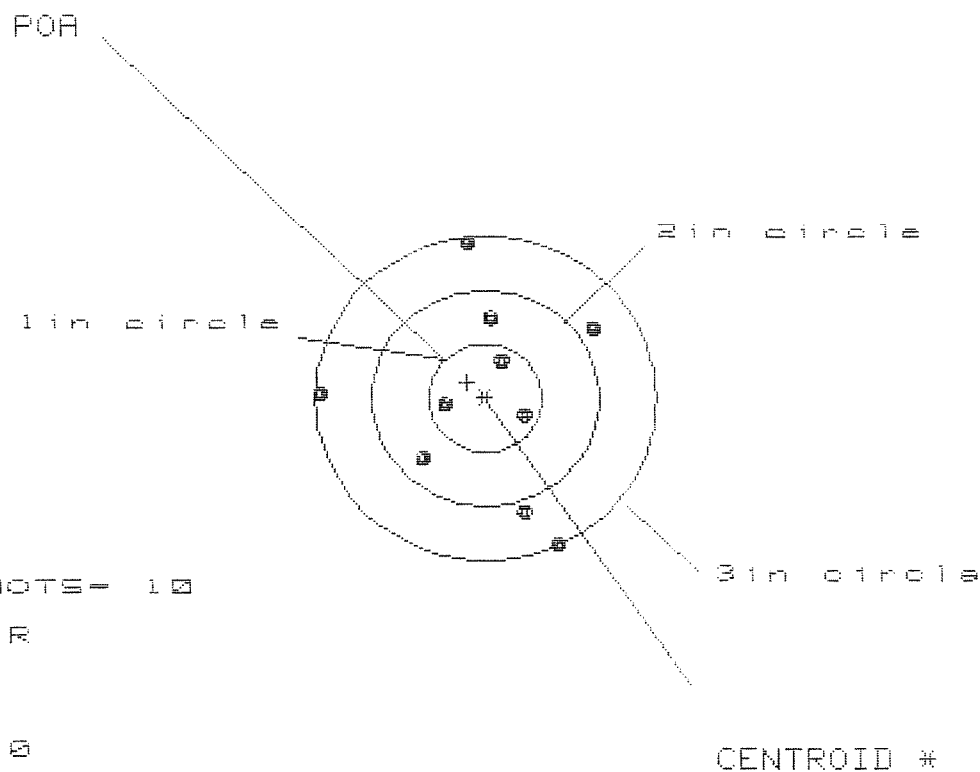
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.047	.835	.527
MINIMUM X	-.735	-.618	-.514
MAXIMUM Y	.830	.761	.847
MINIMUM Y	-.782	-.851	-.765
CENTROID X	-.233	-.350	-.454
CENTROID Y	-.012	.057	-.029
POA TO CENTROID in.	.234	.354	.455
MIN RADIUS	.095	.070	.127
MEAN RADIUS	.779	.721	.678
MAX RADIUS	1.217	1.080	.886
HORIZONTAL SPREAD	1.782	1.453	1.041
VERTICAL SPREAD	1.612	1.612	1.612
EXTREME SPREAD	2.065	1.994	1.701
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	8		
NUMBER IN THREE INCH CIRCLE =	10		

5 Mar 1998

FILE:/PATTERNING/CENTERFIRE_PATT/08346984

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1 in = 3

2 in = 5

3 in = 10

HS= 2.439

VS= 2.760

GS= 2.886

CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.954	.789	.855
MINIMUM X	:	-1.485	-.710	-.644
MAXIMUM Y	:	1.445	1.453	1.290
MINIMUM Y	:	-1.315	-1.307	-1.245
CENTROID X	:	.158	.323	.257
CENTROID Y	:	-.147	-.155	.008
POA TO CENTROID in.	:	.215	.358	.257
MIN RADIUS	:	.343	.267	.171
MEAN RADIUS	:	.938	.869	.780
MAX RADIUS	:	1.487	1.488	1.315
HORIZONTAL SPREAD	:	2.439	1.499	1.499
VERTICAL SPREAD	:	2.760	2.760	2.535
EXTREME SPREAD	:	2.886	2.886	2.588
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		10	

5 Mar 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C634B9B4

CENTERFIRE PATTERNS

3

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS = 10

IN CIR

1 in = 1

2 in = 5

3 in = 10

HS = 0.437

VS = 2.362

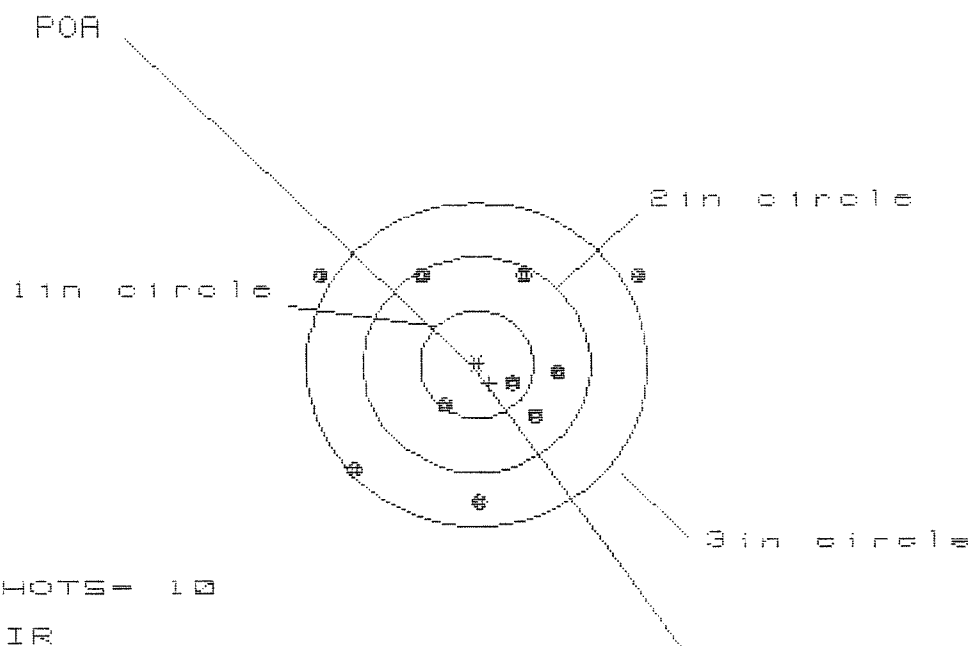
GS = 2.438

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.156	1.014	.410
MINIMUM X	:	-1.281	-.453	-.327
MAXIMUM Y	:	1.068	1.140	1.239
MINIMUM Y	:	-1.294	-1.222	-1.123
CENTROID X	:	.255	.397	.271
CENTROID Y	:	.182	.110	.011
POA TO CENTROID in.	:	.313	.412	.271
MIN RADIUS	:	.385	.456	.300
MEAN RADIUS	:	1.000	.950	.874
MAX RADIUS	:	1.437	1.286	1.240
HORIZONTAL SPREAD	:	2.437	1.467	.736
VERTICAL SPREAD	:	2.362	2.362	2.362
EXTREME SPREAD	:	2.438	2.369	2.369
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		10	

5 Mar 1990

FILE:/PATTERNING/CENTERFIRE_PATT/06346364

CENTERFIRE PATTERNS # 4



OF SHOTS = 10

IN CIR

1 in = 2

2 in = 6

3 in = 8

HS = 2.819

VS = 2.192

GS = 3.078

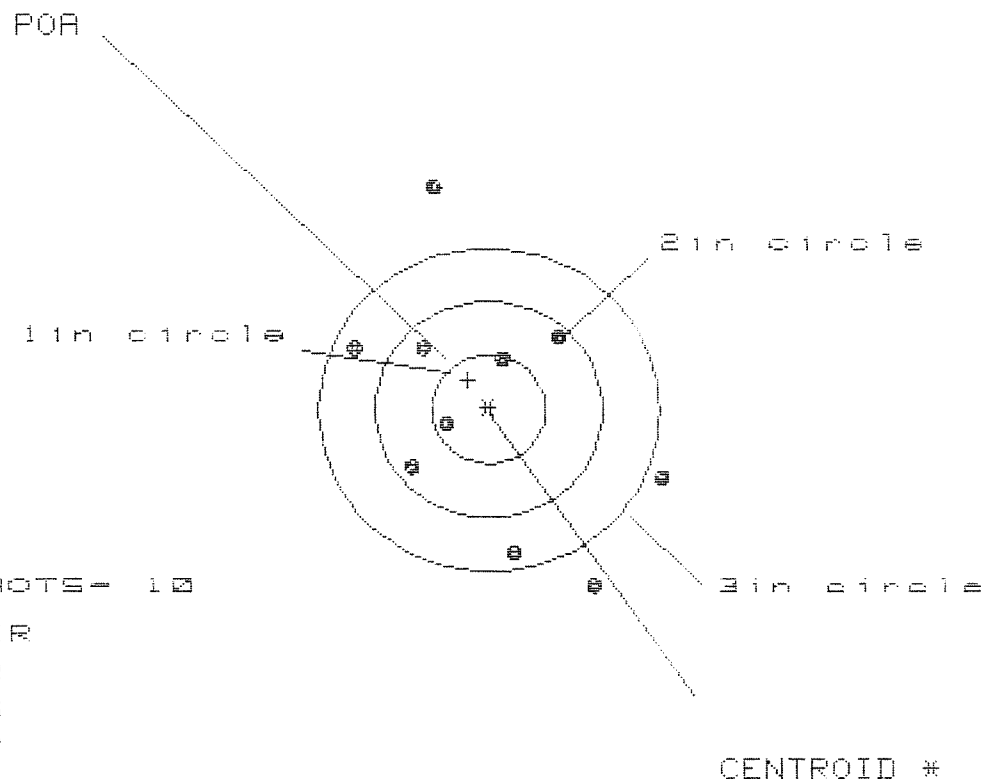
CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.407	.854	.697
MINIMUM X	:	-1.412	-1.256	-1.072
MAXIMUM Y	:	.874	.966	1.080
MINIMUM Y	:	-1.318	-1.226	-1.112
CENTROID X	:	-.113	-.269	-.112
CENTROID Y	:	.171	.079	-.035
POA TO CENTROID in.	:	.204	.280	.117
MIN RADIUS	:	.349	.277	.278
MEAN RADIUS	:	1.011	.941	.822
MAX RADIUS	:	1.633	1.550	1.332
HORIZONTAL SPREAD	:	2.819	2.110	1.769
VERTICAL SPREAD	:	2.192	2.192	2.192
EXTREME SPREAD	:	3.078	2.546	2.381
NUMBER IN ONE INCH CIRCLE =			2	
NUMBER IN TWO INCH CIRCLE =			6	
NUMBER IN THREE INCH CIRCLE =			8	

5 Mar 1998

FILE:/PATTERNING/CENTERFIRE_PATT/06348384

CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1 in = 2

2 in = 5

3 in = 7

HS= 2.630

VS= 3.703

GS= 3.937

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.482	1.433	1.538
MINIMUM X	:	-1.148	-1.197	-1.091
MAXIMUM Y	:	2.032	.869	.688
MINIMUM Y	:	-1.671	-1.445	-1.311
CENTROID X	:	.180	.229	.123
CENTROID Y	:	-.271	-.497	-.316
POA TO CENTROID in.	:	.325	.547	.339
MIN RADIUS	:	.381	.439	.316
MEAN RADIUS	:	1.163	1.076	.951
MAX RADIUS	:	2.079	1.675	1.641
HORIZONTAL SPREAD	:	2.630	2.630	2.630
VERTICAL SPREAD	:	3.703	2.314	1.999
EXTREME SPREAD	:	3.937	3.044	2.891
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	5		
NUMBER IN THREE INCH CIRCLE	=	7		