

New Action

06225425

E6374606

MODEL 700™ M24

Model 700 M24™

Action

Barrel Length

Capacity

Order No. 5715

*Includes 1 in chamber.

Remington

R ORDER
96-02147

SNIPER M-24

DATE RECEIVED	DATE OPENED	DATE CODE	SERIAL NUMBER	NEW SERIAL NUMBER	MODEL AND GRADE
01/17/96	01/17/96		C6225425		700 7.62 NATO
ACCESSORIES	W/STUDS	SOFT CASE	SCOPE BASE		

FROM:

SHIP_TO:

FREDRICKSON, ROBERT L
D CO 2ND BN 1ST SWTG
FT BRAGG

SHIP TO:
- *Commander*
~~FREDRICKSON, ROBERT L~~
D CO 2ND BN 1ST SWTG
FT BRAGG

CUST NO: 135960 C.O.D.

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

WRITE ☐

PROM. DATE

ESTIMATED

VIA

DOOR

UN 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

W52H096017 #243

Barrel	-	96003
Stock	-	96018
Firing pin Assy	-	96007

Repair Kit Coat Trigger Guard
Assy. Front & Rear Sight Bases
Re-zinc Scope Base & Swivel
Studs

REPAIRMAN <i>RW</i>	PROOF <i>L</i>	CLEAN <i>✓</i>	TEST <i>WB</i>	TARGET <i>WB</i>	PATTERN
GALLERY TESTER <i>RW</i>	DATE <i>1/31/96</i>	DATE <i>1/31/96</i>	DATE <i>1/31/96</i>	DATE <i>1/31/96</i>	DATE

RD806 REV. 1/96

OFFICE COPY

RD6925 REV. 1/94

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

BARBER - M24 ~~0060938~~ **M2400060597**

PAYMENT:

Mastercard / Visa (circle one)

Card #:

Exp. Date:

Signature

RETURN:

☐ Clark Street Entrance☐ Via US Mail or UPS

(PLEASE PRINT CLEARLY)

FIREARMS DELIVERED TO PLANT

FILE Nº 010804DATE 1/17/96

CUSTOMER NAME:

Robert L. Fredrickson

REMINGTON EMPLOYEE:

YES ☐ NO ☒

EMPLOYEE # _____

DEPT. # _____

ADDRESS:

D.C. 2 Bn 1st SWTGFort Bragg NC

ZIP:

28307

PHONE:

910 432-9037

FIREARM

MODEL: M-24

CHECK FOR AMMUNITION

GAUGE: 7.62SERIAL # C6225425

CONDITION:

N/A WOOD GOOD FAIR POOR FANCY PLAIN
METAL GOOD FAIR POOR FANCY PLAIN
BARREL VT. RIB PLAIN DEER RSS

ACCESSORIES:

SCOPE: YES NO (BRAND NAME/POWER) _____

SLING: YES NO GUN CASE: YES NO (HARD - SOFT) _____

EXTRA BBL FOR GUN MENTIONED ABOVE:

OTHER (Note in this area items missing or added from orig. equipment)

CUSTOMER REQUEST:

Repair per contractSIGNATURE: Robert L. Fredrickson
(Person delivering firearm to Plant)DATE: 17 JAN 96SIGNATURE: M. Sorenson
(Security Officer)DATE: 1/17/96SIGNATURE: Richard Wright
(Firearm picked up by)

DATE: _____

Arm Service Copy

CONTRACT # DAAA21-87-C-0086

New Barrel
Stock

GUN SERIAL # C6225425

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		1/30/96	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		1/30/96	RW
	C) Inspect Ejector Hole for Chamfer		1/30/96	RW
	D) Oil Firing Pin Ass'y		1/30/96	RW
	E) Adjust Trigger Pull to Min Setting and Stake		1/30/96	RW

op. #	BARBER - M24 0060561 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				1/30/96	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				1/31/96	WLB
	A) Time					
	B) Malfunctions					
	C) Pierced Primers					
	D) Optical Clarity of Scope					
645	Inspect for Live Ammo				1/31/96	WB
655	Final Inspection					
	A) Headspace				2/1/96	RW
	B) Trigger Pull					
	C) Function				2/1/96	RW
660	Pack					

Final Inspection

Sn: C6225425

DATE REC'D: 1/17/96

DATE RET'D:

Auditor: AW

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 # C6225425
3 Jan 1900

CENTROIDAL DISTANCES

0 TO	1	1.08985
1 TO	2	.344971
1 TO	3	.258884
1 TO	4	.59439
1 TO	5	.494825

$\frac{23}{43}$

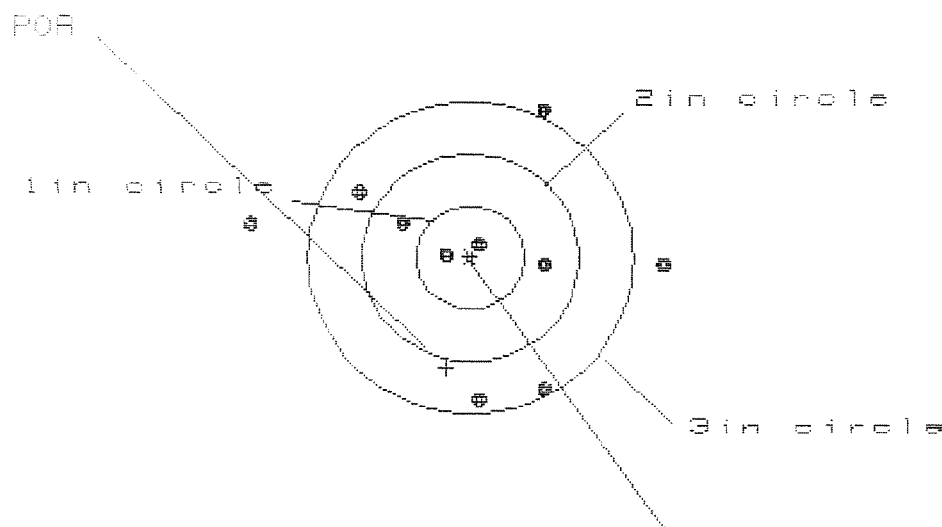
+ (----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0532
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .987
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .888594
THE AMR FOR THIS RIFLE IS: 1.086

2 Jan 80E

FILE:/PATTERNING/CENTERFIRE_PATT/08225425

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 2

2in = 4

3in = 7

HS= 3.777

VS= 2.791

GS= 3.888

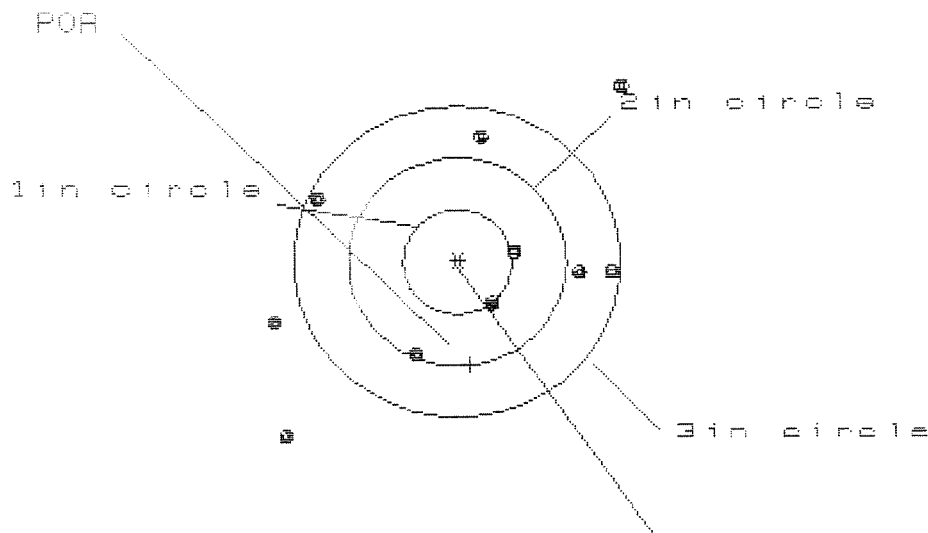
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.760	1.536	.674
MINIMUM X	-2.017	-1.259	-1.067
MAXIMUM Y	1.409	1.450	1.441
MINIMUM Y	-1.382	-1.341	-1.350
CENTROID X	.222	.446	.254
CENTROID Y	1.067	1.026	1.035
POB TO CENTROID in.	1.089	1.119	1.066
MIN RADIUS	.151	.257	.177
MEAN RADIUS	1.120	1.034	.936
MAX RADIUS	2.049	1.537	1.591
HORIZONTAL SPREAD	3.777	2.795	1.741
VERTICAL SPREAD	2.791	2.791	2.791
EXTREME SPREAD	3.888	2.888	2.870
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	7		

2 Jan 1988

FILE:/PATTERNING/CENTERFIRE_PATT/08225425

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 3

3 in = 7

HS = 3.291

VS = 3.376

GS = 4.638

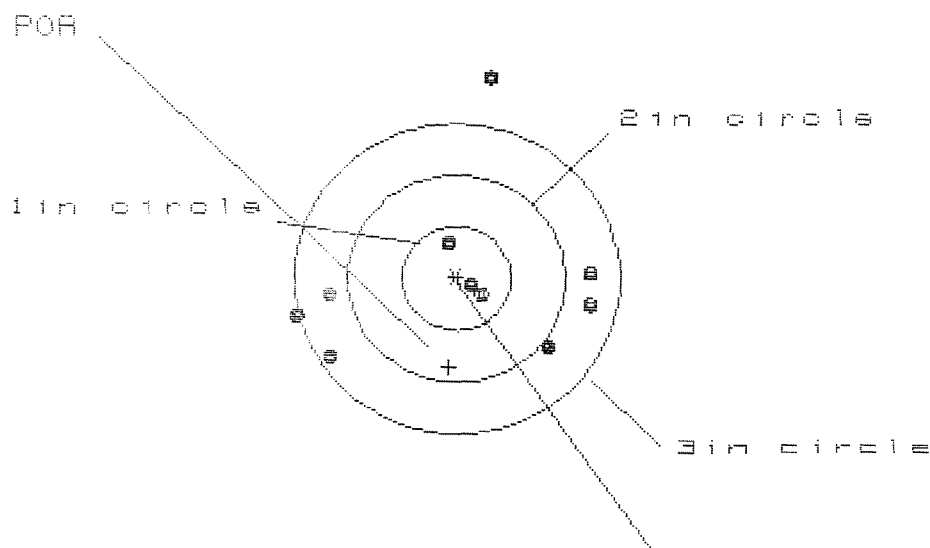
CENTROID #

PATTERN #	2	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.558	1.378	1.377
MINIMUM X	-1.733	-1.913	-1.740
MAXIMUM Y	1.657	1.467	1.233
MINIMUM Y	-1.719	-1.080	-0.897
CENTROID X	-0.116	0.064	-0.109
CENTROID Y	0.333	1.133	1.030
POA TO CENTROID in.	0.999	1.185	1.006
MIN RADIUS	0.443	0.328	0.444
MEAN RADIUS	1.356	1.212	1.114
MAX RADIUS	2.363	2.060	1.835
HORIZONTAL SPREAD	3.291	3.291	3.118
VERTICAL SPREAD	3.376	2.547	2.130
EXTREME SPREAD	4.638	3.976	3.161
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	3		
NUMBER IN THREE INCH CIRCLE =	7		

2 Jan 1988

FILE:/PATTERNING/CENTERFIRE_PATT/06225425

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1 in = 3

2 in = 4

3 in = 8

HS= 2.748

VS= 2.681

GS= 3.076

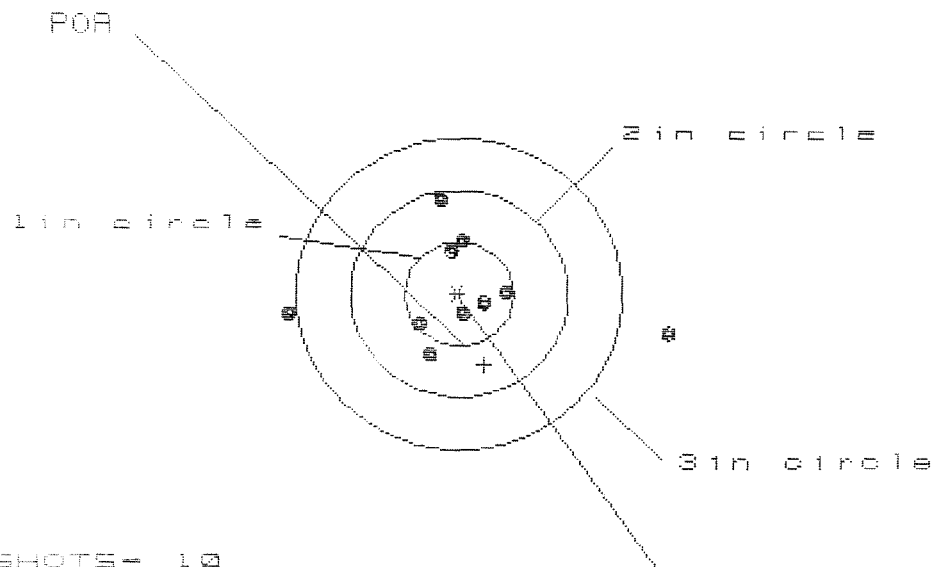
CENTROID *

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.273	1.311	1.131
MINIMUM X	:	-1.475	-1.438	-1.347
MAXIMUM Y	:	1.912	.561	.538
MINIMUM Y	:	-.749	-.536	-.559
CENTROID X	:	.072	.034	.214
CENTROID Y	:	.856	.643	.666
POA TO CENTROID in.	:	.859	.644	.700
MIN RADIUS	:	.090	.210	.128
MEAN RADIUS	:	1.027	.934	.826
MAX RADIUS	:	1.942	1.450	1.459
HORIZONTAL SPREAD	:	2.749	2.749	2.478
VERTICAL SPREAD	:	2.661	1.097	1.097
EXTREME SPREAD	:	3.076	2.754	2.530
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	

2 Jan 1968

FILE:/PATTERNING/CENTERFIRE_PATT/06225425

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1 in = 5

2 in = 8

3 in = 8

HS= 3.530

VS= 1.522

GS= 3.537

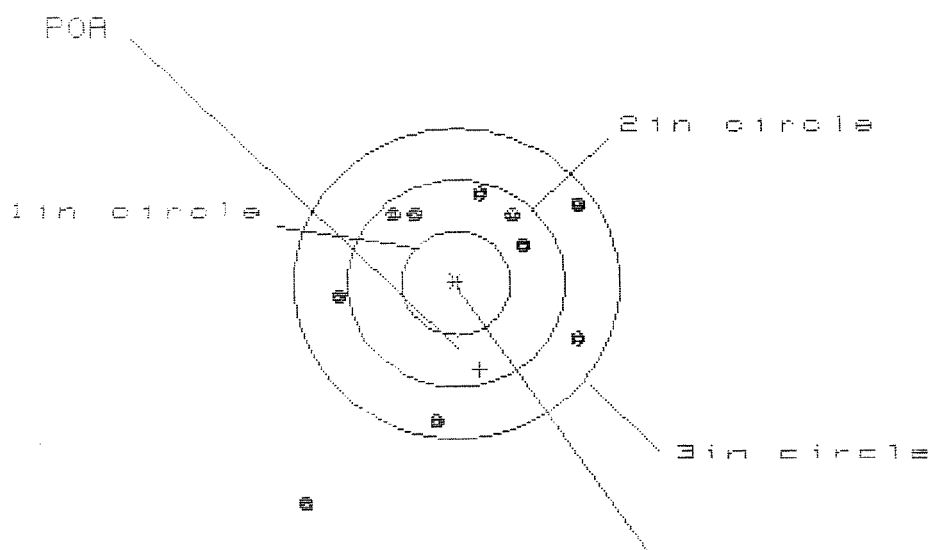
CENTROID #

PATTERN #	4		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.930	.674	.501
MINIMUM X	-1.600	-1.386	-.344
MAXIMUM Y	.900	.854	.824
MINIMUM Y	-.622	-.668	-.698
CENTROID X	-.230	-.444	-.271
CENTROID Y	.681	.727	.757
POA TO CENTROID in.	.719	.852	.804
MIN RADIUS	.174	.304	.253
MEAN RADIUS	.746	.624	.489
MAX RADIUS	1.973	1.406	.842
HORIZONTAL SPREAD	3.530	2.060	.845
VERTICAL SPREAD	1.522	1.522	1.522
EXTREME SPREAD	3.537	2.067	1.525
NUMBER IN ONE INCH CIRCLE =		5	
NUMBER IN TWO INCH CIRCLE =		8	
NUMBER IN THREE INCH CIRCLE =		8	

2 Jan 1988

FILE:/PATTERNING/CENTERFIRE_PATT/06825425

CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1 in = 0

2 in = 5

3 in = 8

HS= 2.530

VS= 3.046

GS= 3.837

CENTROID *

PATTERN #

	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.133	.978	1.098
MINIMUM X	-1.397	-1.257	-1.135
MAXIMUM Y	.913	.676	.740
MINIMUM Y	-2.133	-1.523	-1.459
CENTROID X	-.214	-.059	-.131
CENTROID Y	.833	1.070	1.006
POA TO CENTROID in.	.860	1.072	1.022
MIN RADIUS	.740	.501	.637
MEAN RADIUS	1.175	.944	.934
MAX RADIUS	2.550	1.571	1.483
HORIZONTAL SPREAD	2.530	2.235	2.233
VERTICAL SPREAD	3.046	2.199	2.199
EXTREME SPREAD	3.837	2.452	2.275
NUMBER IN ONE INCH CIRCLE =		0	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		9	

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6225425

OP. #	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and Stock		2/12/92	RW
600	Proof		2/12/92	RW
607	Check Headspace		2/12/92	RW
610	Dis-assemble Gun		2/12/92	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			
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head			
	C) Inspect Ejector Hole for Chamfer			
	D) Oil Firing Pin Ass'y			
	E) Adjust Trigger Pull to Min Setting and Stake			

op. #	BARBER M24 0060570	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4.5	4	4			2/26/92	RW
	G) Safety Off Force	3	3	3			2/26/92	RW
	H) Trigger Pull Test & Retainability							
	I) Firing Pin Indent	.020	.020	.020			2/26/92	RW
	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							
	P) Detach & Attach Scope 20 Times							
640	Gallery Target & Test						2-21-92	K
	A) Time						2-21-92	K
	B) Malfunctions						2-21-92	K
	C) Pierced Primers						2-21-92	K
	D) Optical Clarity of Scope						2-21-92	K
645	Inspect for Live Ammo						2-21-92	K
655	Final Inspection							
	A) Headspace						2/26/92	RW
	B) Trigger Pull	2.33	2.34	2.37	2.36	2.36	2/26/92	RW
	C) Function						2/26/92	RW
660	Pack							

Bring
Pass?

RECEIVING AND ESTIMATING REPORT

BARBER M24 0060572

COMMENTS

ORDER
R 92-03431

INITIAL CUSTOMER ORDER NO.

M24

JJM 6784

DATE RECEIVED

DATE OPENED

DATE CODE

SERIAL NUMBER

NEW SERIAL NUMBER

MODEL AND GRADE

01/28/92

01/28/92

KI 5-88

C6225425

700 7.62

NATO

ACCESSORIES

W/STUDS

SCOPE BASE

FROM:

SHIP TO:

CO D 2ND BN 1ST SPWAR TNG GP
C/O CPT M K STEPHENSON
FT BRAGG NC 28307

CO D 2ND BN 1ST SPWAR TNG GP
C/O CPT M K STEPHENSON
FT BRAGG NC 28307

L

CUST NO: 046771 CJO.IL

ACCOUNT NUMBER

ACCOUNT NUMBER N/C

WRITE ☐

CLEAN/TEST

PROM. DATE

ESTIMATED

VIA

DOOR

GUN CONDITION

- ☐ NEW
☐ LIGHTLY WORN
☐ WORN
☐ VERY WORN
☐ UNREPAIRABLE

REPAIR CHARGE

EXCISE

TAX

INSURANCE

UPS

PARCEL POST

TOTAL

CUSTOMER CONCERN

AMMO

FUNCTION

FINISH

ACCURACY

FIT

INSPECT

CYCLE

A1

B1

TRIGGER GROUP

B2

BOLT ASSY.

B3

BARREL ASSY.

B4

D1

E3

F3

REC. ASSY.

B5

D2

E4

F4

WOOD

C1

D3

E5

F5

METAL

C2

MAIN FAULT

New BARREL

PARTS

COMMENTS

REPAIRMAN

PROOF

CLEAN

TEST

TARGET

PATTERN

GALLERY TESTER

DATE

DATE

DATE

DATE

DATE

OFFICE COPY

RD6925 REV. 8/91

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

BARBER - M24 0060572 0060611

(PLEASE PRINT CLEARLY)

RETURN:

☐ Clark Street Entrance☒ Via US Mail or UPS**FIREARMS DELIVERED TO PLANT**FILE Nº 006784DATE 27 Jan 92

OWNER'S NAME:

CPT STEPHENSON

REMINGTON EMPLOYEE:

OWNER'S ADDRESS:

CO D 2nd Bn 1st SWTGYES ☐ NO ☒FT Bragg NC

EMPLOYEE # _____

ZIP: _____

DEPT. # _____

PHONE: _____

919 396 7330

FIREARM

MODEL: M-24CHECK FOR AMMUNITION ☒GAUGE: 308 CalSERIAL # C6225425

CONDITION:

WOOD

GOOD

FAIR

POOR

FANCY

PLAIN

METAL

GOOD

FAIR

POOR

FANCY

PLAIN

BARREL

VT. RIB

PLAIN

DEER RSS

ACCESSORIES:

SCOPE: YES

NO

(BRAND NAME/POWER) _____

SLING: YES

NO

GUN CASE: YES

NO

(HARD - SOFT)

EXTRA BBL FOR GUN MENTIONED ABOVE: _____

OTHER (Note in this area items missing or added from orig. equipment)

CUSTOMER REQUEST: _____

Replace Barrel.

SIGNATURE: _____

(Person delivering firearm to Plant)

DATE: _____

27 Jan 92

SIGNATURE: _____

(Security Officer)

DATE: _____

1/27/92

SIGNATURE: _____

(Firearm picked up by)

DATE: _____

1-28-92

Arm Service Copy

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6225425
24 Feb 1992

CENTROIDAL DISTANCES

0 TO	1	.136795
1 TO	2	.37207
1 TO	3	.390128
1 TO	4	.195645
1 TO	5	.834693

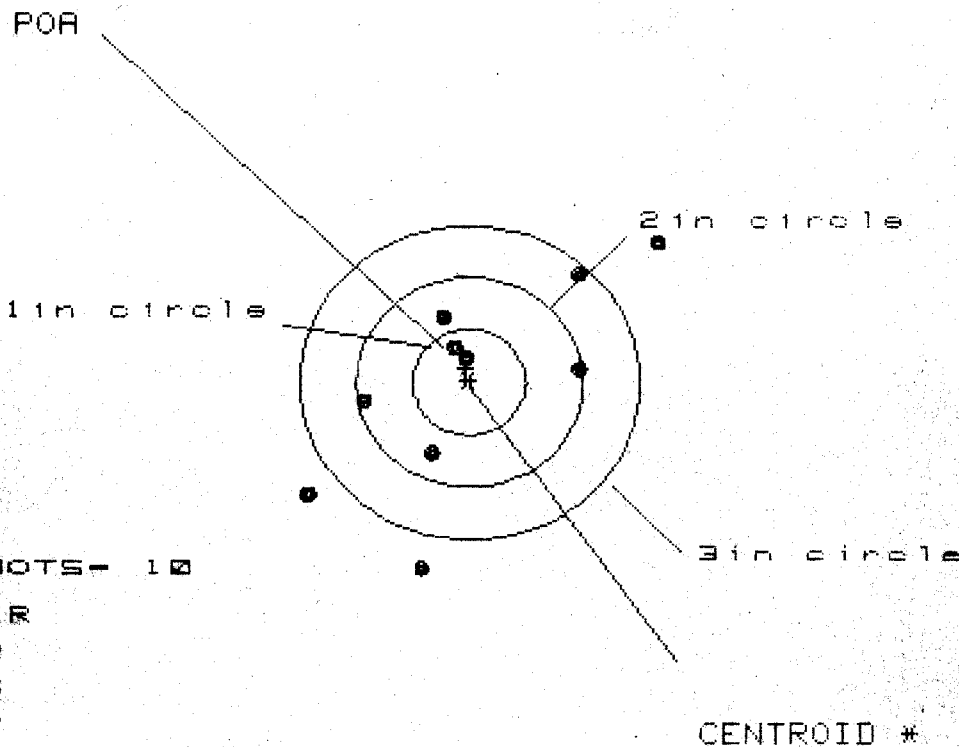
5
←----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .2432
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0028
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .243216
THE AMR FOR THIS RIFLE IS: 1.151

24 Feb 1992

FILE:/PATTERNING/CENTERFIRE_PATT/08225425

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 2

2in = 6

3in = 7

HS= 2.063

VS= 3.108

GS= 3.915

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.618	1.163	1.126
MINIMUM X	:	-1.445	-1.265	-1.302
MAXIMUM Y	:	1.370	1.178	.980
MINIMUM Y	:	-1.738	-1.586	-1.114
CENTROID X	:	.032	-.148	-.112
CENTROID Y	:	-.133	-.285	-.087
POA TO CENTROID in.	:	.137	.321	.142
MIN RADIUS	:	.248	.431	.238
MEAN RADIUS	:	1.100	.989	.861
MAX RADIUS	:	2.120	1.635	1.713
HORIZONTAL SPREAD	:	3.063	2.428	2.428
VERTICAL SPREAD	:	3.108	2.764	2.094
EXTREME SPREAD	:	3.915	3.184	3.184
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	6		
NUMBER IN THREE INCH CIRCLE	=	7		

24 Feb 1992

FILE:/PATTERNING/CENTERFIRE_PATT/C6225425

CENTERFIRE PATTERNS # 2

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS- 10

IN CIR

1 in = 2

2 in = 2

3 in = 6

HS= 3.048

VS= 4.181

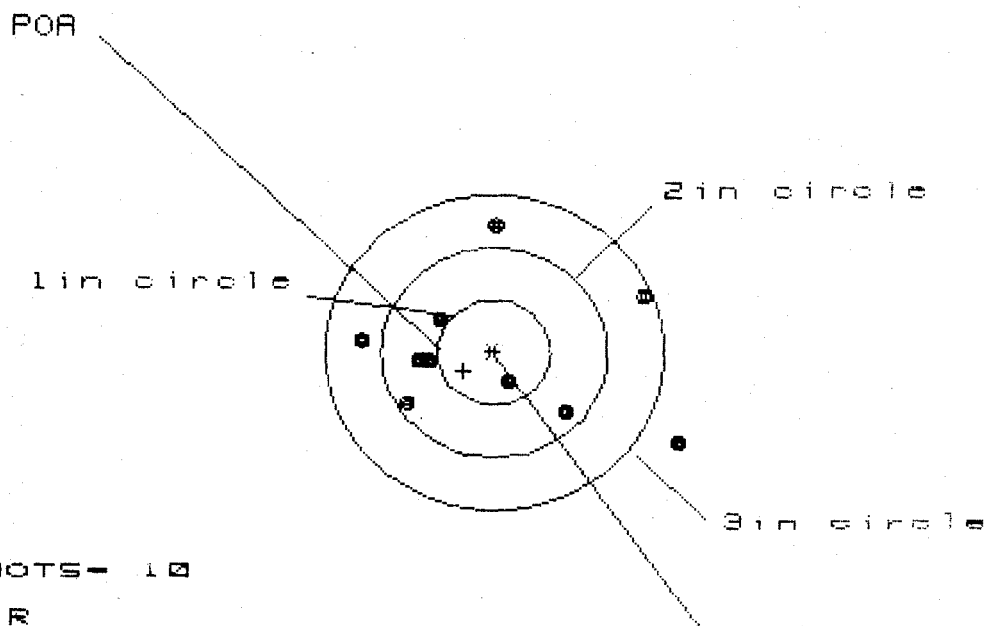
GS= 4.734

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.893	2.066	2.004
MINIMUM X	:	-1.155	-.982	-1.044
MAXIMUM Y	:	2.192	1.687	1.469
MINIMUM Y	:	-1.989	-1.746	-1.459
CENTROID X	:	.126	-.047	.015
CENTROID Y	:	-.493	-.736	-.518
POA TO CENTROID in.	:	.509	.738	.518
MIN RADIUS	:	.199	.111	.116
MEAN RADIUS	:	1.394	1.221	1.122
MAX RADIUS	:	2.688	2.112	2.017
HORIZONTAL SPREAD	:	3.048	3.048	3.048
VERTICAL SPREAD	:	4.181	3.433	2.928
EXTREME SPREAD	:	4.734	3.476	3.049
NUMBER IN ONE INCH CIRCLE =	:	2	2	2
NUMBER IN TWO INCH CIRCLE =	:	2	2	2
NUMBER IN THREE INCH CIRCLE =	:	6	6	6

24 Feb 1992

FILE:/PATTERNING/CENTERFIRE_PATT/C6225425

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 1

2in = 6

3in = 9

HS= 2.011

VS= 2.162

GS= 3.000

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.611	1.548	.991
MINIMUM X	:	-1.200	-1.022	-.828
MAXIMUM Y	:	1.271	1.172	1.232
MINIMUM Y	:	-.891	-.713	-.653
CENTROID X	:	.274	.096	-.098
CENTROID Y	:	.173	.272	.212
POA TO CENTROID in.	:	.324	.288	.234
MIN RADIUS	:	.257	.355	.245
MEAN RADIUS	:	.968	.832	.672
MAX RADIUS	:	1.840	1.620	1.283
HORIZONTAL SPREAD	:	2.811	2.570	1.919
VERTICAL SPREAD	:	2.162	1.985	1.885
EXTREME SPREAD	:	3.000	2.604	1.988
NUMBER IN ONE INCH CIRCLE =	:	1		
NUMBER IN TWO INCH CIRCLE =	:	6		
NUMBER IN THREE INCH CIRCLE =	:	9		

24 Feb 1992

FILE:/PATTERNING/CENTERFIRE_PATT/C8225425

CENTERFIRE PATTERNS

4

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 0

2in = 5

3in = 8

HS= 2.747

VS= 2.943

GS= 3.522

CENTROID *

PATTERN #	:	1	2	3
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.424	1.507	1.368
MINIMUM X	:	-1.323	-1.240	-1.379
MAXIMUM Y	:	1.792	1.149	1.030
MINIMUM Y	:	-1.151	-.952	-1.071
CENTROID X	:	.146	.063	.202
CENTROID Y	:	.026	-.173	-.054
POA TO CENTROID in.	:	.148	.184	.209
MIN RADIUS	:	.544	.412	.525
MEAN RADIUS	:	1.129	1.004	.955
MAX RADIUS	:	1.941	1.516	1.471
HORIZONTAL SPREAD	:	2.747	2.747	2.747
VERTICAL SPREAD	:	2.943	2.101	2.101
EXTREME SPREAD	:	3.522	2.847	2.786
NUMBER IN ONE INCH CIRCLE	=	0		
NUMBER IN TWO INCH CIRCLE	=	5		
NUMBER IN THREE INCH CIRCLE	=	8		

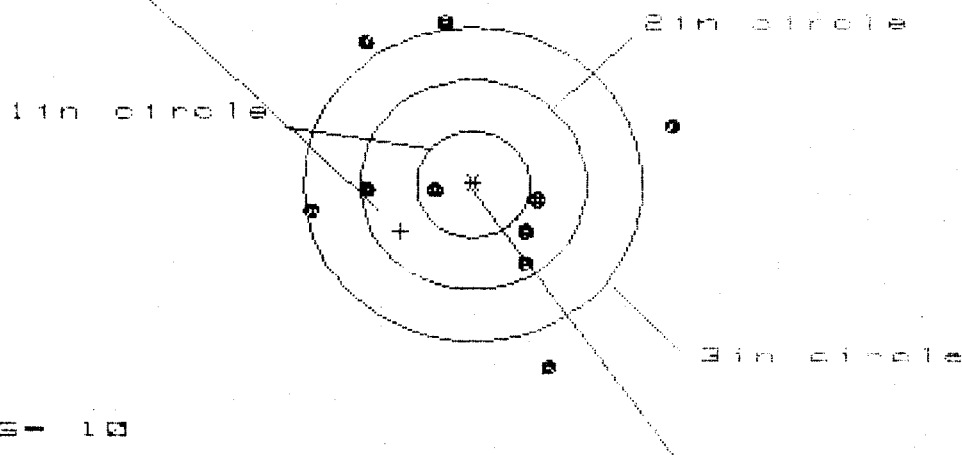
24 Feb 1992

FILE:/PATTERNING/CENTERFIRE_PATT/06225425

CENTERFIRE PATTERNS

5

POA



OF SHOTS - 10

IN CIR

1 in = 1

2 in = 5

3 in = 6

HS = 3.126

VS = 3.290

GS = 3.436

CENTROID *

PATTERN #	:	5	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.714	1.784	.853
MINIMUM X	:	-1.412	-1.342	-1.119
MAXIMUM Y	:	1.557	1.365	1.405
MINIMUM Y	:	-1.733	-.927	-.887
CENTROID X	:	.638	.568	.345
CENTROID Y	:	.441	.633	.593
POA TO CENTROID in.	:	.775	.851	.686
MIN RADIUS	:	.327	.332	.173
MEAN RADIUS	:	1.163	1.099	.980
MAX RADIUS	:	1.842	1.813	1.406
HORIZONTAL SPREAD	:	3.126	3.126	1.972
VERTICAL SPREAD	:	3.290	2.292	2.292
EXTREME SPREAD	:	3.436	3.224	2.511
NUMBER IN ONE INCH CIRCLE =	:	1		
NUMBER IN TWO INCH CIRCLE =	:	5		
NUMBER IN THREE INCH CIRCLE =	:	6		

BARBER - M24 M2499860619

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # *C625425*

OPERATION		DATE	INT
#	NAME		
575-580	ASSEMBLY <i>2</i>	<i>26</i>	<i>FO</i>
600	PROOF <i>2-29</i>	<i>2-29</i>	<i>RW</i>
615	MAGNAFLUX BARREL	<i>5/13/88</i>	<i>Pfl.</i>
	MAGNAFLUX BOLT	<i>5/13/88</i>	<i>Pfl.</i>
620	COATING	<i>8/11/88</i>	<i>TJD</i>
625-630	FINAL ASSEMBLY		
635	TEST		
640	TARGET		
	FIRING PIN INDENT		
660	PACK		

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C 6225425

OP.#	OP. NAME	READINGS	DATE	INITIAL
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 & Tap Sight Holes			
618	Polish Barrel			
620	Apply Coatings (Barrel Action)			
	Apply Coatings (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/26/88	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/26/88	RW
	C) Inspect Ejector Hole for Chamfer		8/26/88	RW

OVER

OP. #		READINGS	DATE	INITIAL
625 cont.	D) Oil Firing Pin Ass'y		8/26/88	RW
	E) Adjust Trigger Pull to Min. Setting and Stake		26aug88	W.B. + J.S.
	F) Safety on Force	7.25 7.25 7.25	26aug88	W.B. + J.S.
	G) Safety off Force	3 3 3	26aug88	W.B. + J.S.
	H) Trigger Pull Test & Retainability		26aug88	W.B. + J.S.
	I) Firing Pin Indent	.022 .022 .022	26aug88	W.B. + J.S.
	J) Assemble Stock		9/26/88	RW
	K) Assemble Swivel Studs		10-6-88	J.S.
	L) Attach Front & Rear Sight Assemblies		9/26/88	RW
	M) Iron Sight Alignment		9/26/88	RW
	N) Detach Front & Rear Sights & place in numbered container		9/26/88	RW
	O) Attach Scope to Rifle		10/3/88	RW
	P) Detach & Attach Scope 20 times		10/3/88	J.S.
640	Gallery Target & Test	60 R 95L	10/3/88	W.B.
	A) Optical Clarity of Scope		10/3/88	W.B.
645	Inspect for Live Ammo		10/3/88	A.C.
655	Final Inspection			
	A) Headspace		10-6-88	J.S.
	B) Trigger Pull		10-6-88	J.S.
	C) Function		10-6-88	J.S.
660	Pack		10-20-88	J.S.

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS
2.50# + .50#
3.00# + .75#
4.00# + 1.00#

SERIAL NO. C 6725425
DATE 26 Aug 88
TESTER W. B.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.43	2.24	2.27	2.17	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.41	2.25	2.27	2.18	
PULL #3	2.39	2.23	2.27	2.18	
PULL #4	2.37	2.24	2.25	2.21	
PULL #5	2.36	2.23	2.25	2.18	
TOTAL	11.96	11.19	11.31	10.92	
AVG.	2.392	2.238	2.262	2.18	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.09	3.04		
PULL #2	3.08	3.05		
PULL #3	3.07	3.04		
PULL #4	3.08	3.04		
PULL #5	3.07	3.05		
TOTAL	15.39	15.22		
AVG.	3.078	3.044		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.26	4.00	4.29	4.17
PULL #2	4.19	3.96	4.21	4.23
PULL #3	4.12	4.02	4.25	4.21
PULL #4	4.10	3.98	4.17	4.23
PULL #5	4.10	4.11	4.21	4.24
TOTAL	20.77	20.07	21.13	21.08
AVG.	4.154	4.014	4.226	4.216

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6225425

CENTROIDAL DISTANCES

0 TO	1	1.39688
1 TO	2	.291172
1 TO	3	.660007
1 TO	4	1.07929
1 TO	5	1.15771

$\frac{1}{2}$
 $\frac{4}{5}$
 3
 + (----POA

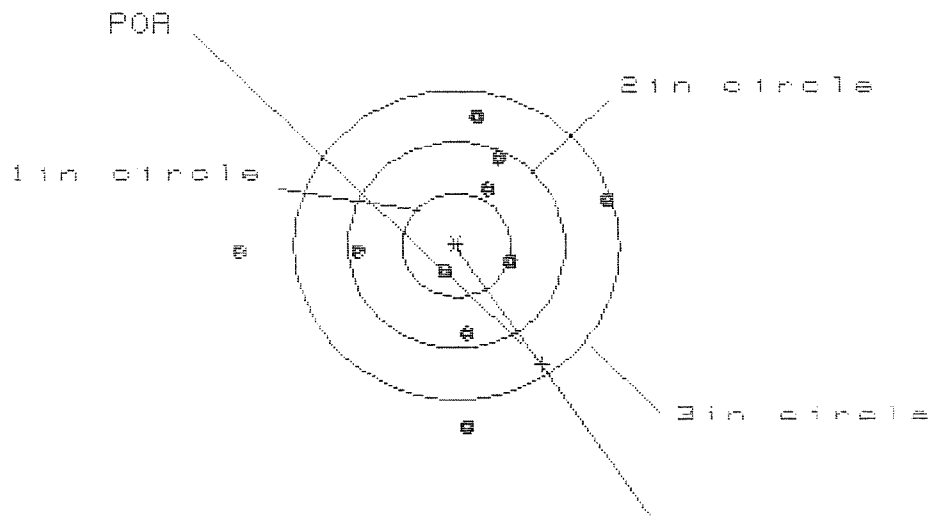
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.2642
 THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: 1.0262
 THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: 1.05966

THE AMR FOR THIS RIFLE IS: .983

5 Oct 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C6225425

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 6

3 in = 8

HS = 3.284

VS = 2.964

GS = 3.410

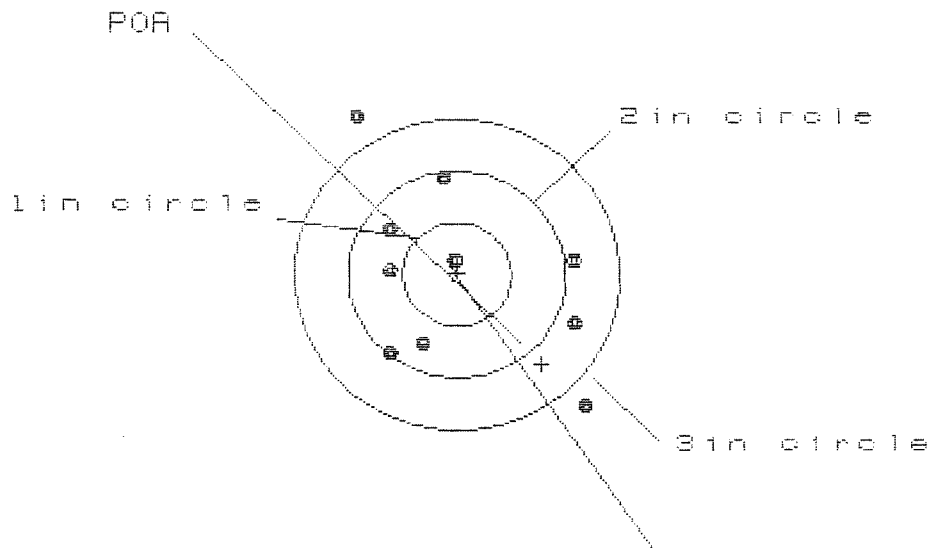
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.410	1.190	1.180
MINIMUM X	-1.974	-1.126	-1.136
MAXIMUM Y	1.240	1.239	1.023
MINIMUM Y	-1.724	-1.725	-1.041
CENTROID X	-0.790	-0.570	-0.560
CENTROID Y	1.152	1.153	1.369
POA TO CENTROID in.	1.397	1.287	1.479
MIN RADIUS	.287	.328	.337
MEAN RADIUS	1.051	.925	.807
MAX RADIUS	1.974	1.727	1.196
HORIZONTAL SPREAD	3.384	2.316	2.316
VERTICAL SPREAD	2.964	2.964	2.064
EXTREME SPREAD	3.410	2.964	2.360
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	8		

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CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 6

3 in = 8

HS = 2.0887

VS = 2.844

GS = 3.528

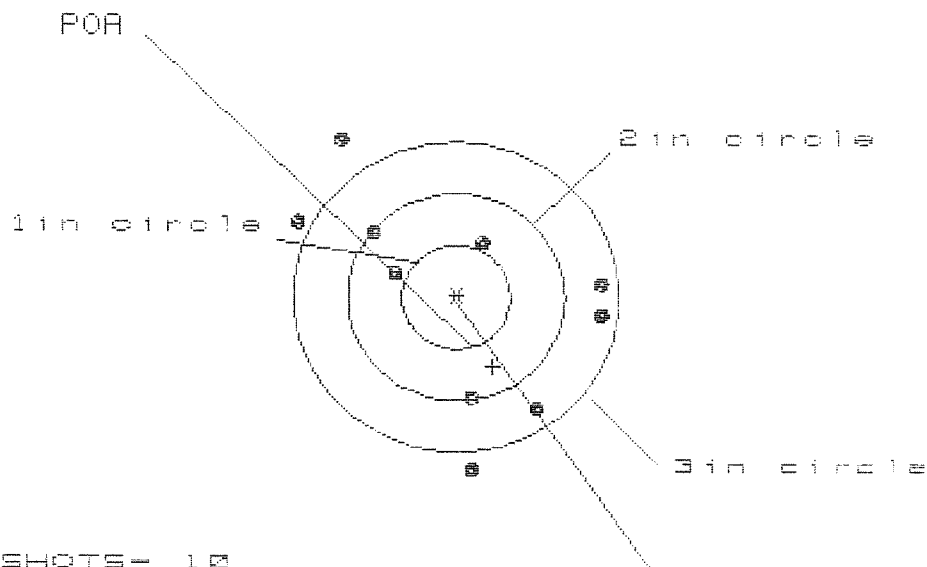
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.173	1.071	1.134
MINIMUM X	:	-.914	-.770	-.636
MAXIMUM Y	:	1.567	1.095	.957
MINIMUM Y	:	-1.277	-1.103	-.720
CENTROID X	:	-.780	-.678	-.812
CENTROID Y	:	.861	.687	.825
POA TO CENTROID in.	:	1.162	.965	1.158
MIN RADIUS	:	.133	.333	.162
MEAN RADIUS	:	1.000	.925	.804
MAX RADIUS	:	1.814	1.738	1.154
HORIZONTAL SPREAD	:	2.087	1.841	1.770
VERTICAL SPREAD	:	2.844	2.198	1.677
EXTREME SPREAD	:	3.528	2.540	1.934
NUMBER IN ONE INCH CIRCLE =			1	
NUMBER IN TWO INCH CIRCLE =			6	
NUMBER IN THREE INCH CIRCLE =			8	

5 Oct 1988

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 0

2in = 4

3in = 7

HS= 2.769

VS= 3.290

GS= 3.494

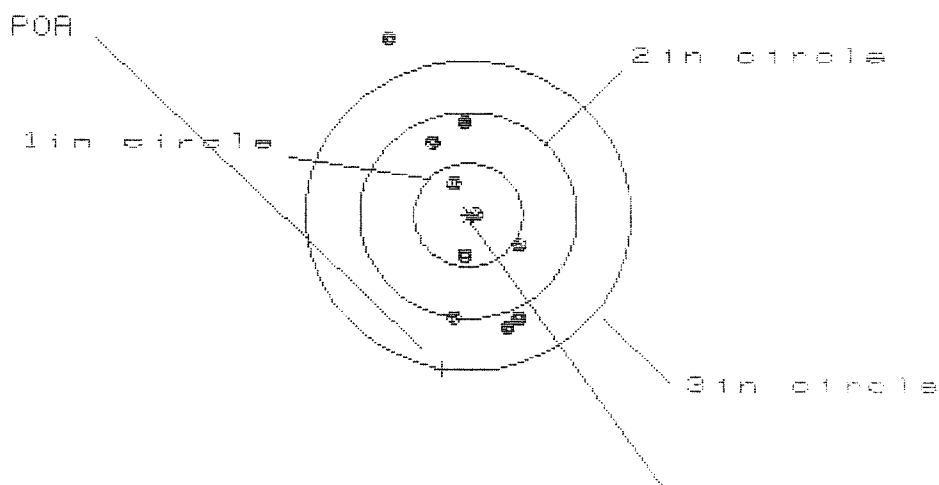
CENTROID *

PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	1.314
MINIMUM X	-1.455
MAXIMUM Y	1.570
MINIMUM Y	-1.720
CENTROID X	-.337
CENTROID Y	.672
POA TO CENTROID in.	.751
MIN RADIUS	.589
MEAN RADIUS	1.228
MAX RADIUS	1.894
HORIZONTAL SPREAD	2.769
VERTICAL SPREAD	3.290
EXTREME SPREAD	3.494
NUMBER IN ONE INCH CIRCLE	0
NUMBER IN TWO INCH CIRCLE	4
NUMBER IN THREE INCH CIRCLE	7

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CENTERFIRE PATTERNS # 4



OF SHOTS = 10

CENTROID #

IN CIR

1 in = 4

2 in = 6

3 in = 0

HS = 1.216

VS = 2.853

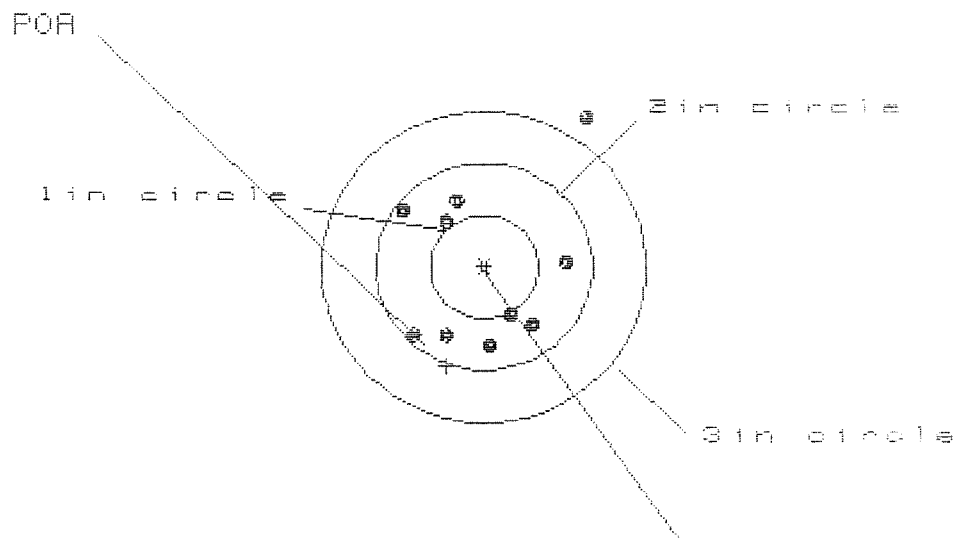
GS = 3.045

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.493	.412	.445
MINIMUM X	:	-.723	-.382	-.349
MAXIMUM Y	:	1.750	1.108	.994
MINIMUM Y	:	-1.103	-.909	-.958
CENTROID X	:	.235	.316	.293
CENTROID Y	:	1.490	1.296	1.410
POA TO CENTROID in.	:	1.509	1.334	1.438
MIN RADIUS	:	.062	.175	.085
MEAN RADIUS	:	.819	.682	.639
MAX RADIUS	:	1.893	1.115	1.025
HORIZONTAL SPREAD	:	1.216	.794	.794
VERTICAL SPREAD	:	2.853	2.017	1.952
EXTREME SPREAD	:	3.045	2.054	1.992
NUMBER IN ONE INCH CIRCLE =			4	
NUMBER IN TWO INCH CIRCLE =			6	

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FILE:/PATTERNING/CENTERFIRE_PATT/06225425

CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1 in = 0

2 in = 9

3 in = 9

HS= 1.711

VS= 2.211

GS= 2.625

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.966	.806	.737
MINIMUM X	:	-.745	-.638	-.707
MAXIMUM Y	:	1.443	.766	.709
MINIMUM Y	:	-.768	-.608	-.665
CENTROID X	:	.351	.244	.313
CENTROID Y	:	.956	.796	.853
POA TO CENTROID in.	:	1.019	.832	.908
MIN RADIUS	:	.515	.441	.442
MEAN RADIUS	:	.817	.687	.630
MAX RADIUS	:	1.736	.920	.932
HORIZONTAL SPREAD	:	1.711	1.444	1.444
VERTICAL SPREAD	:	2.211	1.374	1.374
EXTREME SPREAD	:	2.625	1.555	1.555
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		9	
NUMBER IN THREE INCH CIRCLE	=		9	