

C6611553

MODEL 700TM M24

Model **SMS**TM

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

Remington

Arms Services Repair & Estimate System

File Add Repair Estimate Repair Expedite Repair Inquiry Repair Tools CSR Tools Reports Table Maintenance System Maintenance Help

Repair Inquiry

Repair Number: RE00141338

Serial: C6611553 Model M24 SWS Center Fire
Caliber: 7.62 NATO

Repairman:

Verify Repair

High Priority

Status:

Closed 2/7/2008 8:33:52 AM

Address Information

Customer:

☒ Received From

Return To:

☐ Received From

Name: TRANSPORTATION OFFICER

TRANSPORTATION OFFICER

Address 1: HQ US ARMY AIR DEFENSE ARTILLERY CEN

HQ US ARMY AIR DEFENSE ARTILLERY CEN

Address 2: ATTN: ATZC-ISL-TM BLDG PO Box:

ATTN: ATZC-ISL-TM BLDG PO Box:

City: FORT BLISS

FORT BLISS

State: TX

Zip Code: 79916

Country: US

State: TX

Zip Code: 79916

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
A026	Scope	1
A045	Bi Pod	1
A057	Fit and Rear Sgt Base	1
D000	SCOPE CASE	1

Repair Search

Refresh

Close

nagletj

2/7/2008

4:16 PM

NUM

Serial Number: C6611553

Model: M24 SWS

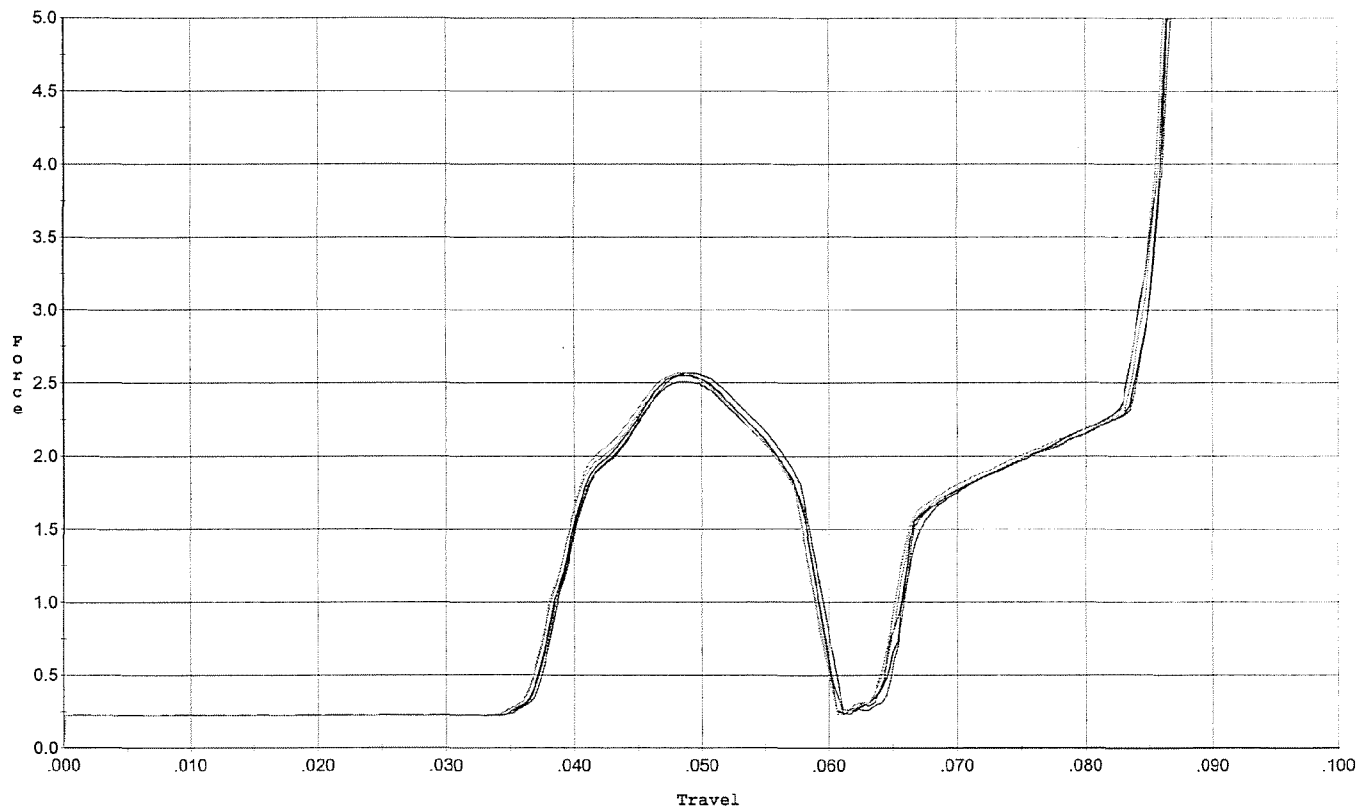


RE00141338

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: R. Putch 2/19/08

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



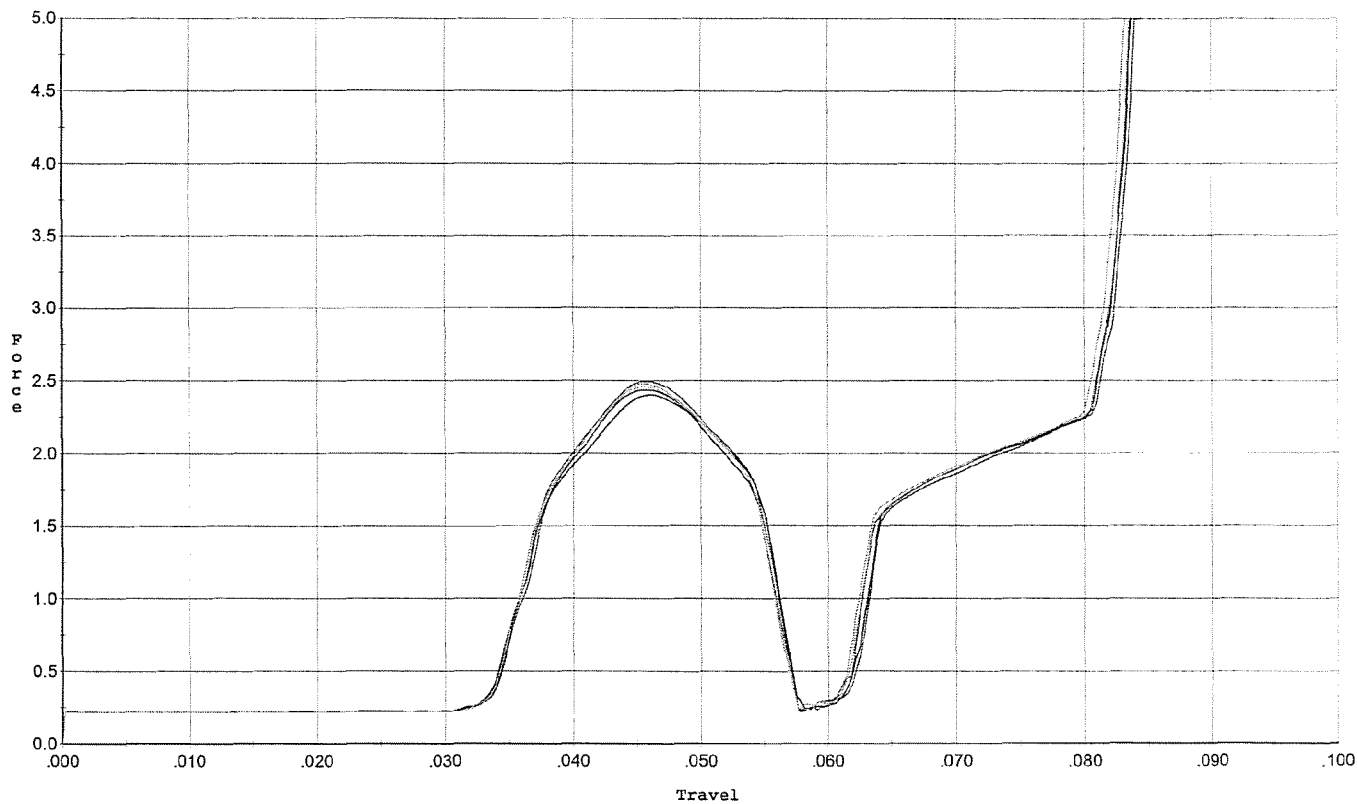
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.567	0.059	0.037	0.035	0.052		Set Trigger
2	2.550	0.058	0.037	0.036	0.051		Set Trigger
3	2.507	0.058	0.037	0.036	0.051		Set Trigger
4	2.569	0.057	0.036	0.036	0.051		Set Trigger
5	2.556	0.057	0.036	0.036	0.051		Set Trigger

Avg 2.55

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 2/19/08

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



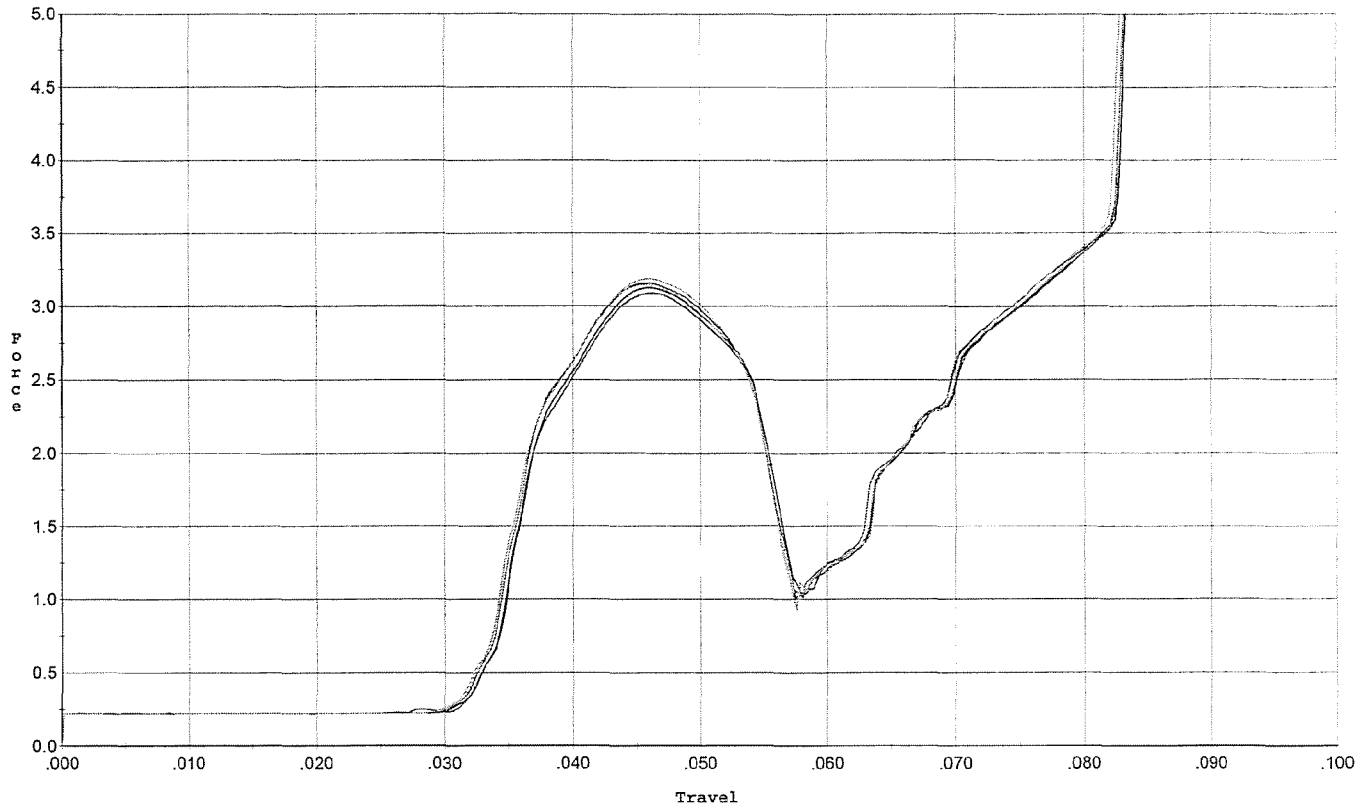
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.439	0.054	0.034	0.036	0.047		Set Trigger
2	2.402	0.055	0.034	0.035	0.048		Set Trigger
3	2.493	0.056	0.034	0.035	0.050		Set Trigger
4	2.458	0.054	0.034	0.035	0.048		Set Trigger
5	2.477	0.054	0.034	0.035	0.048		Set Trigger

Avg 2.45

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putsch 2/19/08

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



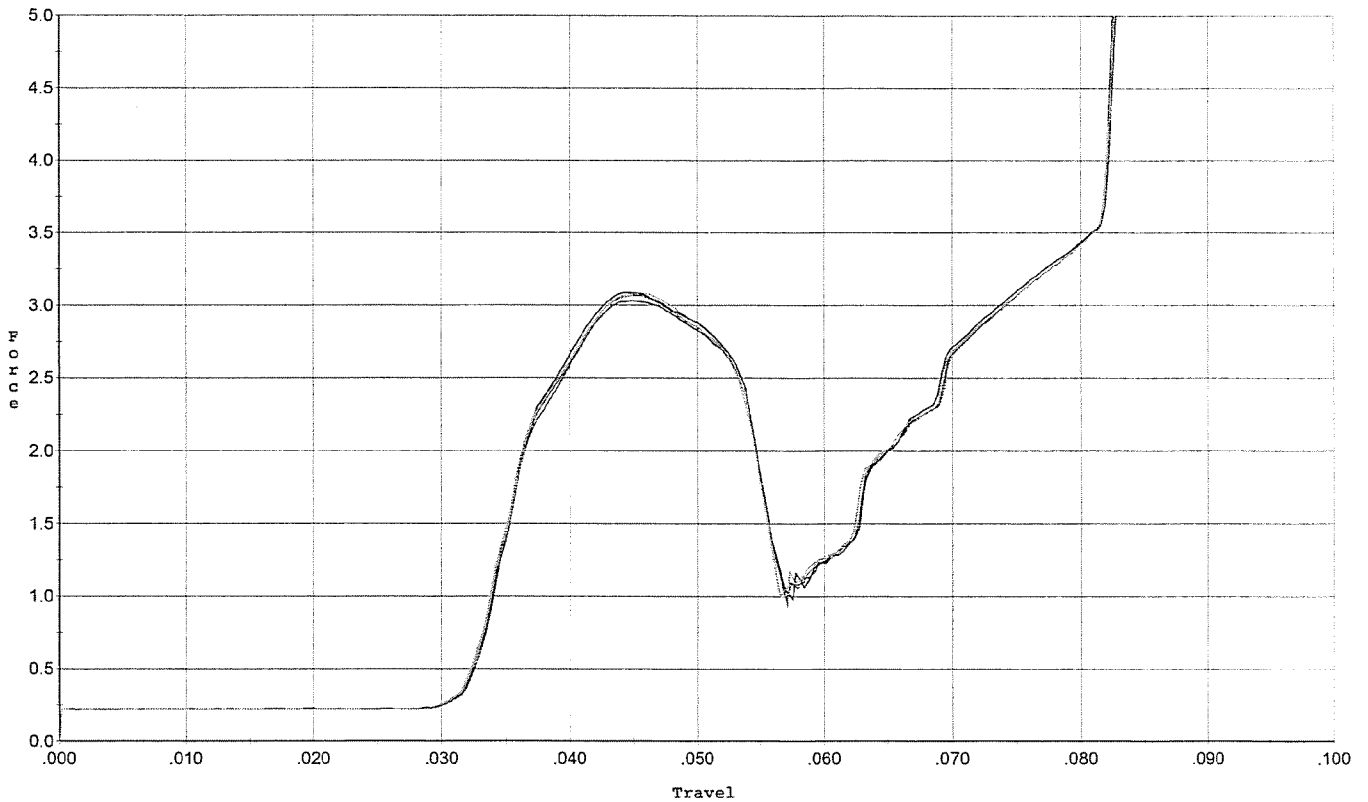
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.091	0.054	0.032	0.034	0.061		Set Trigger
2	3.125	0.056	0.032	0.034	0.064		Set Trigger
3	3.156	0.054	0.032	0.034	0.063		Set Trigger
4	3.148	0.054	0.032	0.033	0.063		Set Trigger
5	3.188	0.054	0.032	0.034	0.064		Set Trigger

Avg 3.14

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: R. Putch 2/19/08

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



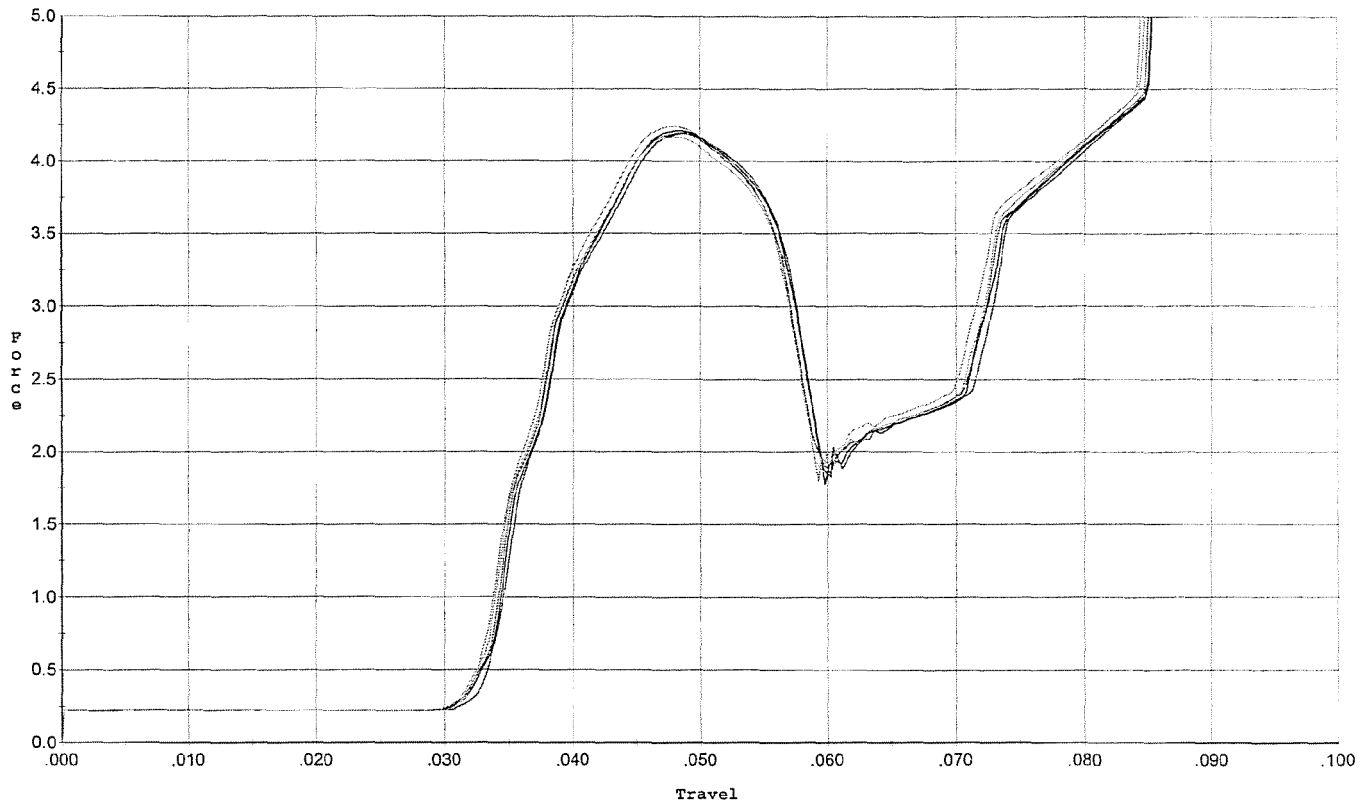
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.031	0.054	0.032	0.034	0.061		Set Trigger
2	3.087	0.054	0.032	0.034	0.062		Set Trigger
3	3.075	0.054	0.032	0.034	0.061		Set Trigger
4	3.064	0.054	0.032	0.034	0.062		Set Trigger
5	3.084	0.054	0.032	0.034	0.062		Set Trigger

Avg 3.06

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 2/19/08

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



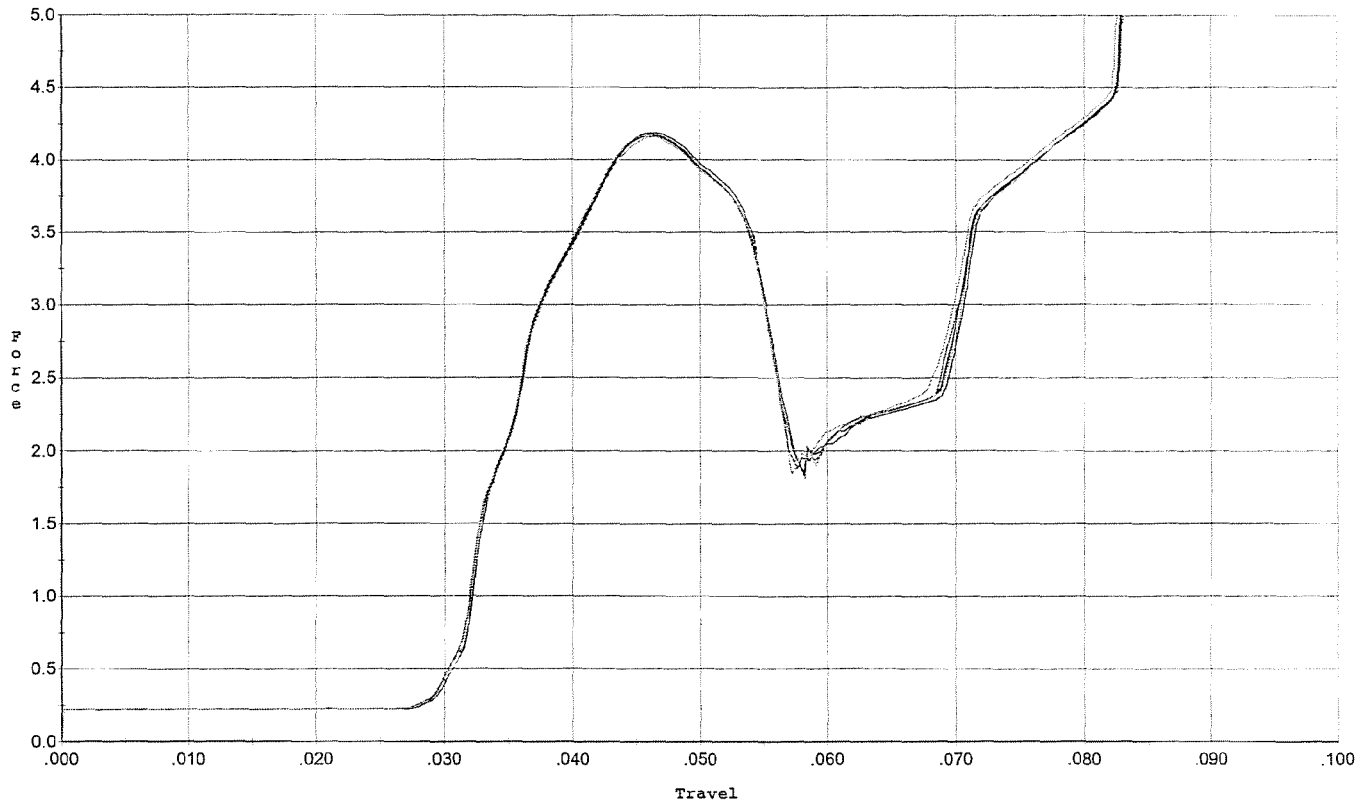
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.191	0.057	0.033	0.032	0.087		Set Trigger
2	4.209	0.057	0.032	0.032	0.088		Set Trigger
3	4.196	0.056	0.032	0.032	0.087		Set Trigger
4	4.167	0.057	0.032	0.032	0.087		Set Trigger
5	4.243	0.057	0.032	0.032	0.089		Set Trigger

Avg 4.20

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 2/19/08

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



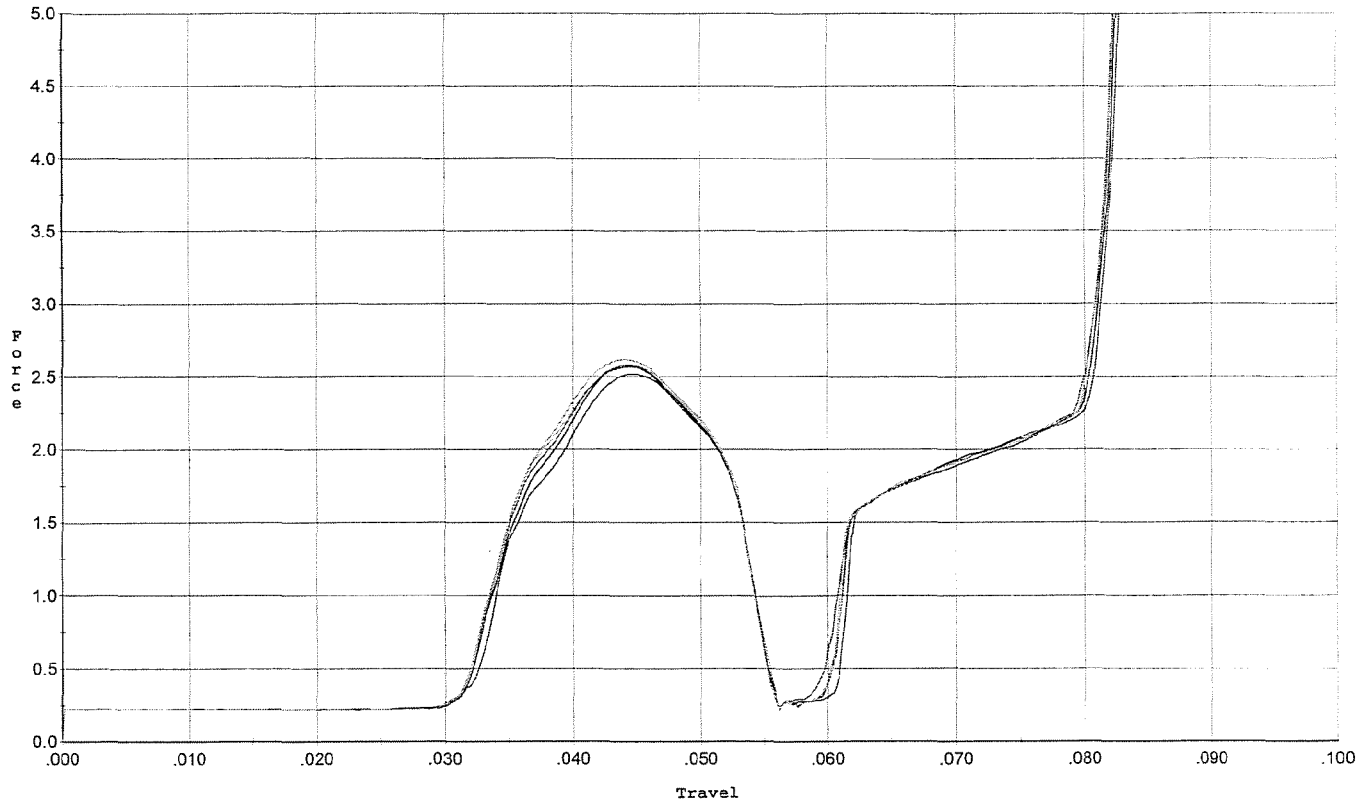
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.188	0.054	0.030	0.032	0.085		Set Trigger
2	4.166	0.054	0.030	0.032	0.085		Set Trigger
3	4.176	0.054	0.030	0.032	0.085		Set Trigger
4	4.158	0.054	0.030	0.032	0.085		Set Trigger
5	4.168	0.055	0.030	0.032	0.086		Set Trigger

Avg 4.17

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 2/19/08

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



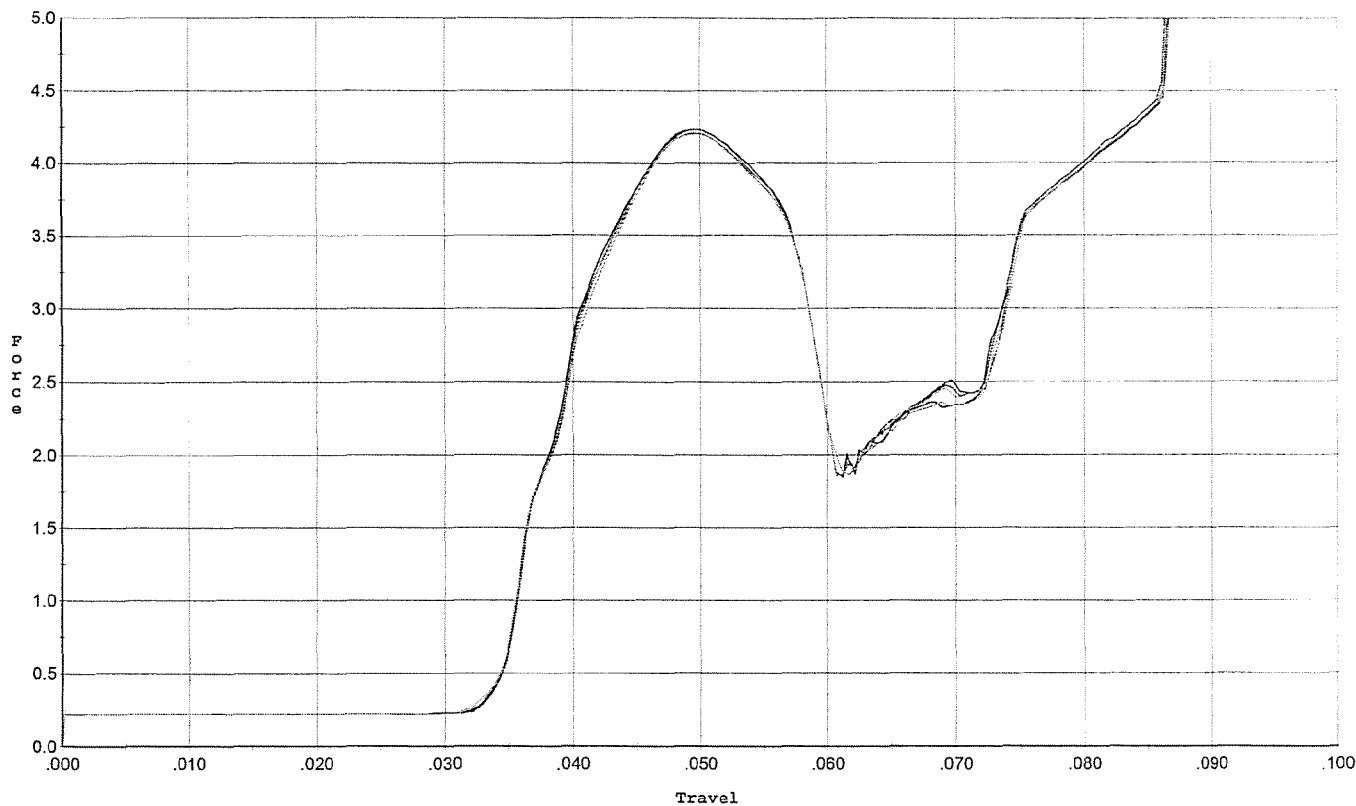
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.519	0.053	0.033	0.035	0.048		Set Trigger
2	2.579	0.053	0.032	0.035	0.050		Set Trigger
3	2.569	0.053	0.032	0.035	0.050		Set Trigger
4	2.584	0.053	0.031	0.034	0.051		Set Trigger
5	2.620	0.053	0.031	0.034	0.051		Set Trigger

Avg 2.57

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putsch 2/19/08

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



#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.232	0.058	0.034	0.033	0.087		Set Trigger
2	4.234	0.058	0.034	0.033	0.088		Set Trigger
3	4.207	0.058	0.034	0.033	0.087		Set Trigger
4	4.209	0.058	0.034	0.033	0.087		Set Trigger
5	4.201	0.058	0.034	0.033	0.087		Set Trigger

AVG 4.21

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6611553.__0
FILE DATE AND TIME: 04/03/2008 09:39

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.012
The Average Y Centroid of the Five Target Set:	0.034
The Average Point of Impact of the Five Target Set:	0.036
The Average Mean Radius of the Five Target Set:	0.723
The Distance from POA to Centroid Target #1:	0.214
The Distance from Centroid Target #2 to Centroid Target #1:	0.289
The Distance from Centroid Target #3 to Centroid Target #1:	0.175
The Distance from Centroid Target #4 to Centroid Target #1:	0.331
The Distance from Centroid Target #5 to Centroid Target #1:	0.306

SERIAL NUMBER: C6611553. __0

TARGET NUMBER: 1

FILE DATE: 04/03/2008

FILE TIME: 09:39

X CENTROID: 0.211

Y CENTROID: 0.036

POA TO CENTROID: 0.214

HORZ SPREAD: 2.569

VERT SPREAD: 1.737

GROUP SPREAD: 2.982

MIN RADIUS: 0.191

MAX RADIUS: 1.617

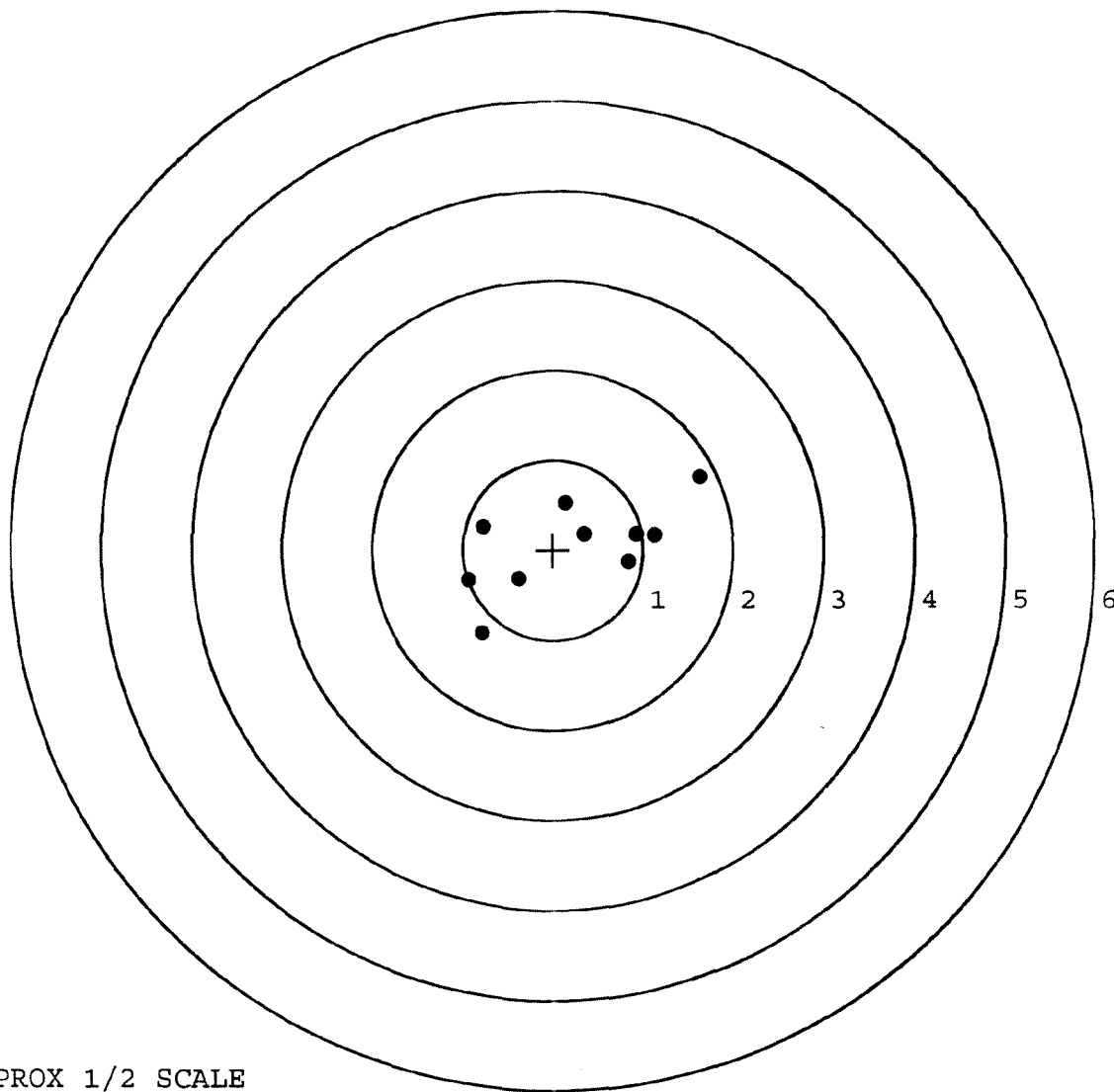
MEAN RADIUS: 0.889

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 9

POINT#	X	Y
1:	0.135	0.518
2:	0.344	0.173
3:	0.926	0.174
4:	1.124	0.160
5:	0.834	-0.131
6:	1.633	0.806
7:	-0.775	0.253
8:	-0.382	-0.321
9:	-0.936	-0.343
10:	-0.791	-0.931



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6611553. __0

TARGET NUMBER: 2

FILE DATE: 04/03/2008

FILE TIME: 09:39

X CENTROID: -0.056

Y CENTROID: -0.077

POA TO CENTROID: 0.095

HORZ SPREAD: 2.431

VERT SPREAD: 1.522

GROUP SPREAD: 2.438

MIN RADIUS: 0.151

MAX RADIUS: 1.268

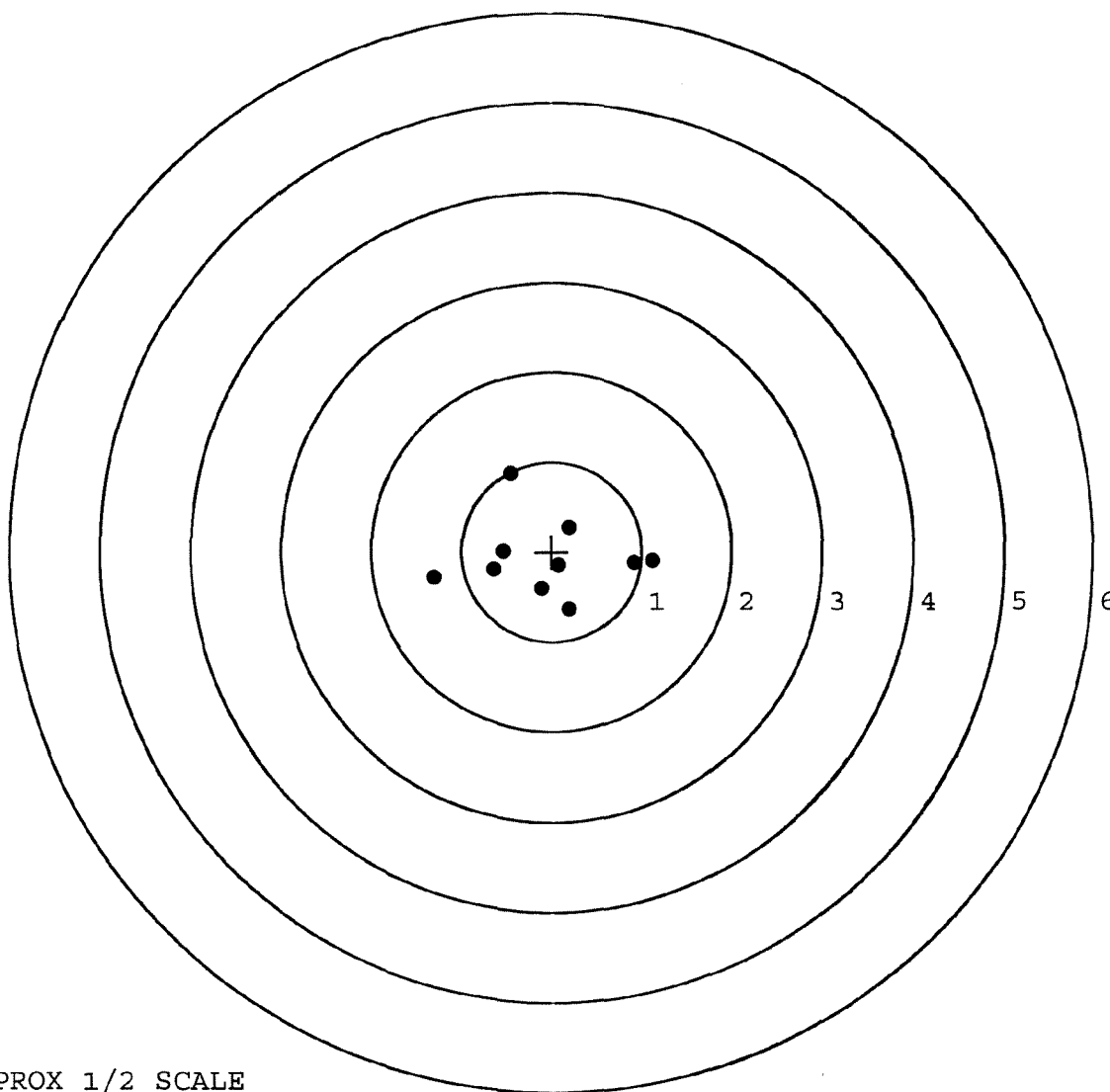
MEAN RADIUS: 0.709

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.458	0.877
2:	0.191	0.272
3:	-0.537	0.009
4:	-0.641	-0.204
5:	-1.306	-0.288
6:	0.077	-0.150
7:	-0.116	-0.413
8:	0.193	-0.645
9:	0.917	-0.123
10:	1.125	-0.102

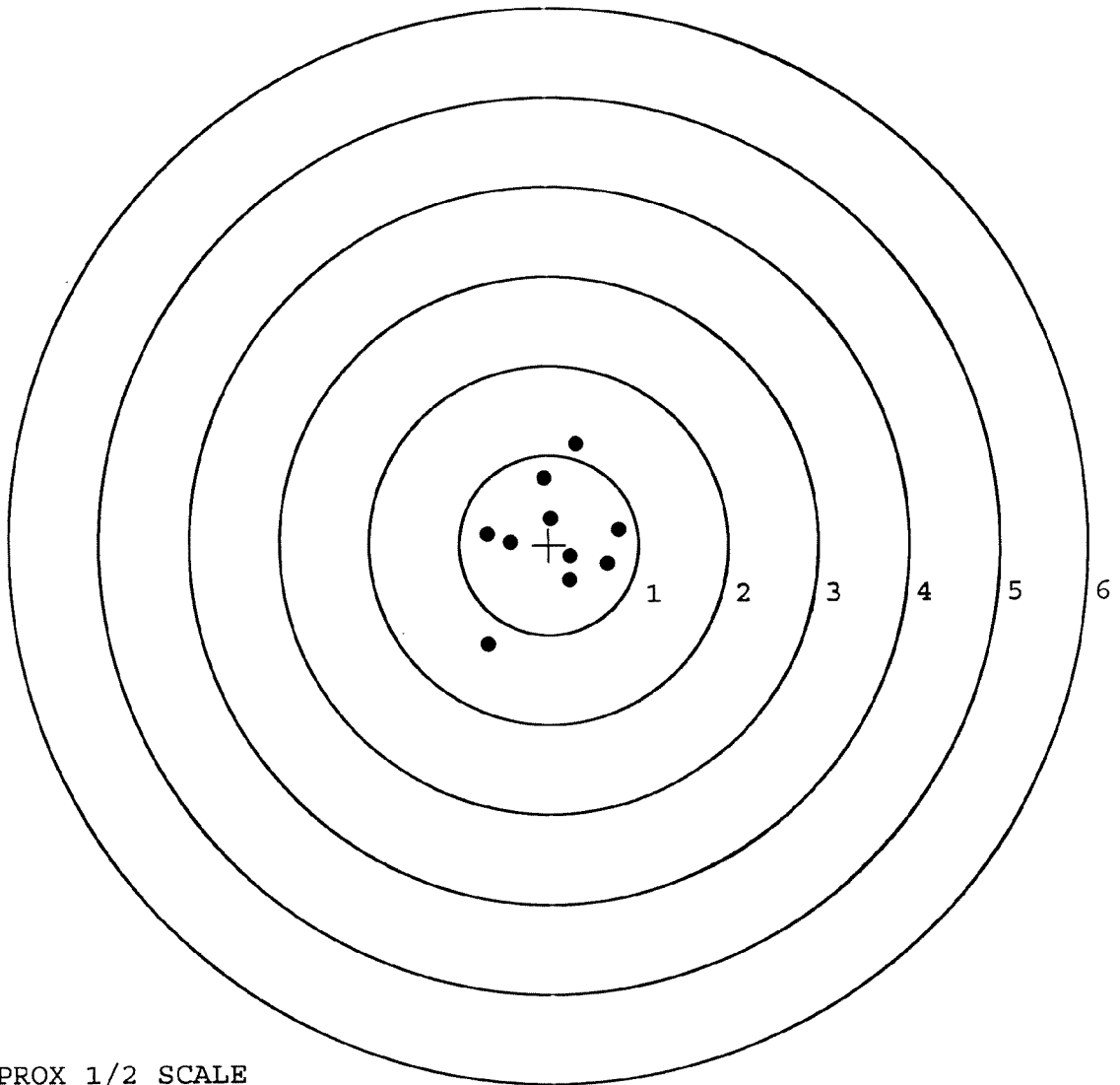


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6611553. __0
 TARGET NUMBER: 3
 FILE DATE: 04/03/2008
 FILE TIME: 09:39

X CENTROID: 0.038
 Y CENTROID: 0.063
 POA TO CENTROID: 0.074
 HORZ SPREAD: 1.462
 VERT SPREAD: 2.230
 GROUP SPREAD: 2.439
 MIN RADIUS: 0.230
 MAX RADIUS: 1.374
 MEAN RADIUS: 0.677
 # IN 1 IN DIAMETER: 4
 # IN 2 IN DIAMETER: 8
 # in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.308	1.122
2:	-0.049	0.746
3:	0.023	0.292
4:	-0.427	0.032
5:	-0.686	0.126
6:	0.228	-0.396
7:	0.240	-0.128
8:	0.653	-0.219
9:	0.776	0.161
10:	-0.681	-1.108



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6611553. __0

TARGET NUMBER: 4

FILE DATE: 04/03/2008

FILE TIME: 09:39

X CENTROID: -0.101

Y CENTROID: -0.072

POA TO CENTROID: 0.124

HORZ SPREAD: 2.721

VERT SPREAD: 1.426

GROUP SPREAD: 3.053

MIN RADIUS: 0.265

MAX RADIUS: 1.566

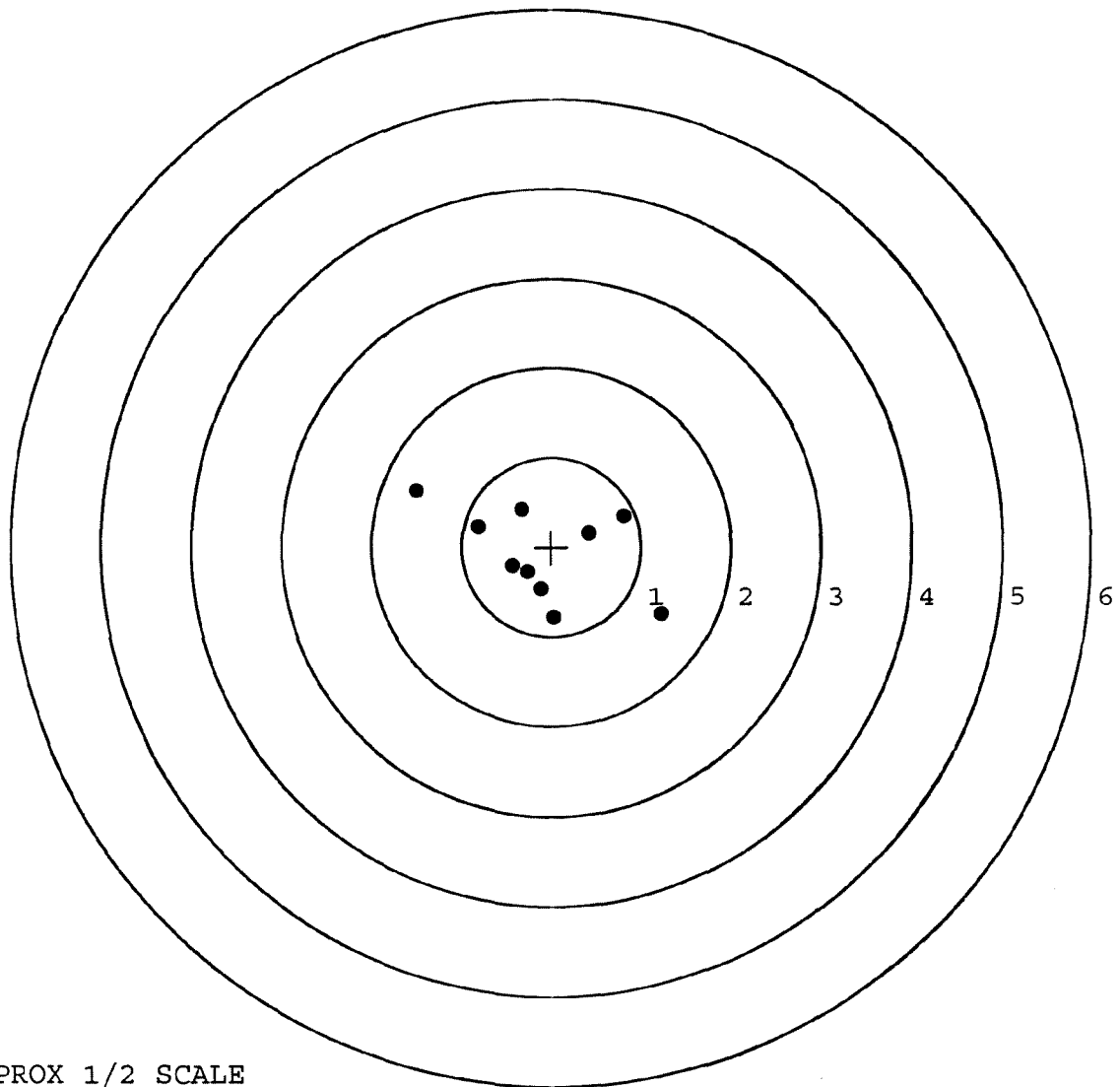
MEAN RADIUS: 0.770

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 9

POINT#	X	Y
1:	0.803	0.347
2:	0.422	0.159
3:	-0.337	0.423
4:	-0.818	0.223
5:	-1.500	0.633
6:	-0.436	-0.212
7:	-0.269	-0.277
8:	-0.124	-0.470
9:	0.024	-0.793
10:	1.221	-0.751



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6611553. __0

TARGET NUMBER: 5

FILE DATE: 04/03/2008

FILE TIME: 09:39

X CENTROID: -0.033

Y CENTROID: 0.222

POA TO CENTROID: 0.224

HORZ SPREAD: 1.327

VERT SPREAD: 2.013

GROUP SPREAD: 2.022

MIN RADIUS: 0.119

MAX RADIUS: 1.088

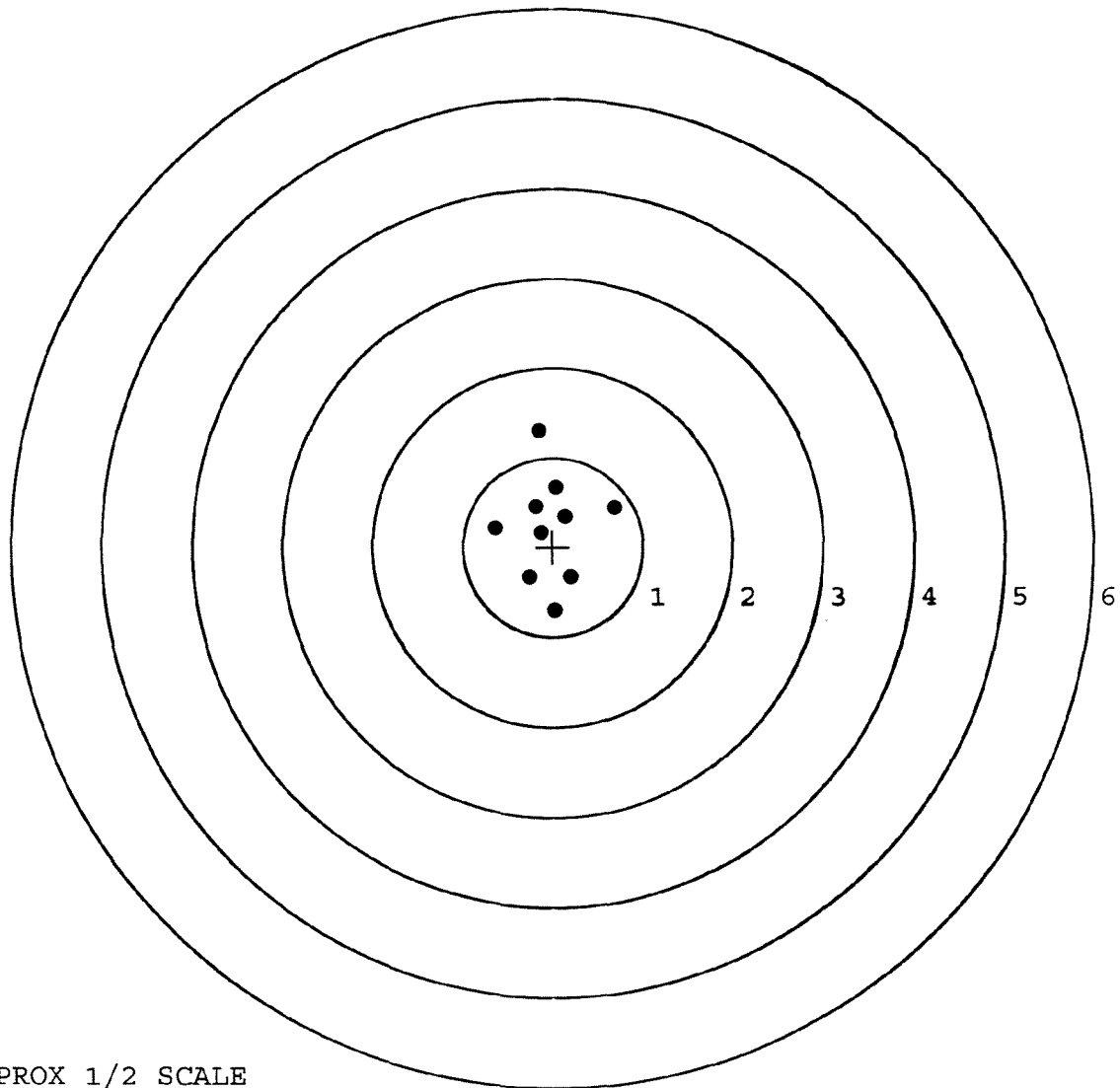
MEAN RADIUS: 0.567

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.681	0.452
2:	0.139	0.346
3:	0.038	0.673
4:	-0.197	0.457
5:	-0.165	1.301
6:	-0.646	0.213
7:	-0.135	0.160
8:	-0.261	-0.336
9:	0.199	-0.339
10:	0.021	-0.712



TARGET APPROX 1/2 SCALE

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

R & E NUMBER 00141338SERIAL NUMBER C6611553LOG-IN DATE 2-7-08

OPERATION #	OPERATION NAME	DATE	INITIAL
500	DIS-ASSEMBLE GUN	2-20-08	A.P.D.
505	RE-BARREL	2-20-08	A.P.D.
560	ASSEMBLE	2-20-08	A.P.D.
600	PROOF	2-20-08	TRW
605	CHECK HEADSPACE	2-20-08	TRW
610	DIS-ASSEMBLE GUN	3-12-08	RTZ
612	MAGNAFLUX	3/14/08	WMD
510	DRILL AND TAP	3-12-08	Fm
615	ROLLMARK CALIBER	3-13-08	CW
618	ROTO-BLAST	3-14-08	DG
620	APPLY COATINGS	3-14-08	AP
625	FINAL ASSEMBLY	4-2-08	RTZ
640	FUNCTION TEST AND	4-4-08	SD
650	TARGET	4-3-08	SD
	MALFUNCTION <u>HUR</u>	CORRECTION <u>OK</u>	4-4-08 TRW
	MALFUNCTION	CORRECTION <u>N/A</u>	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	4-3-08 TRW
670	FINAL INSPECTION	4/7/08	Fm
	A) HEADSPACE	PASS FAIL	4/7/08 Fm
	B) TRIGGER PULL	2.21 2.29 2.25 2.26 2.15 4/7/08	Fm
680	F) SAFETY ON FORCE	5.5 6 5.5 4/7/08	Fm
	G) SAFETY OFF FORCE	4 4.5 4.5 4/7/08	Fm
	I) FIRING PIN INDENT	.022 .022 .022 4/7/08	Fm
690	PACK	4/24/08	Fm

Arms Services Repair & Estimate System

File Add Repair Estimate Repair Expedite Repair Inquiry Repair Tools CSR Tools Reports Table Maintenance System Maintenance Help

Repair Inquiry

Repair Number: **RE00092197** Serial: C6611553 Model: M24 SWS Center Fire Caliber: 7.62 NATO Produced: 06/18/1991 Repairman: Status: Closed 2/1/2005 7:08:07 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:

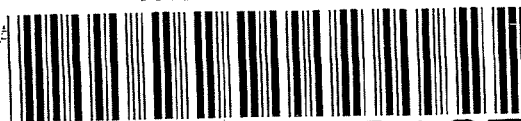
Accessories Received

Code	Desc	Qty
A007	With Stud	3
A017	Scope Base	1
A026	Scope	1
A057	Frt and Rear Sgt Base	1

Repair Search Refresh Close

maglet 2/7/2005 11:05 AM CAPS NUM INS SCPL

start 3 3

Serial Number: **C6611553**Model: **M24 SWS****RE00092197**

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6611553.__0

FILE DATE AND TIME: 06/15/2005 07:58

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.139
The Average Y Centroid of the Five Target Set:	0.024
The Average Point of Impact of the Five Target Set:	0.141
The Average Mean Radius of the Five Target Set:	0.886
The Distance from POA to Centroid Target #1:	0.441
The Distance from Centroid Target #2 to Centroid Target #1:	0.070
The Distance from Centroid Target #3 to Centroid Target #1:	1.029
The Distance from Centroid Target #4 to Centroid Target #1:	0.686
The Distance from Centroid Target #5 to Centroid Target #1:	0.378

SERIAL NUMBER: 6611553. 0

TARGET NUMBER: 1

FILE DATE: 06/15/2005

FILE TIME: 07:58

X CENTROID: -0.236

Y CENTROID: -0.372

POA TO CENTROID: 0.441

HORZ SPREAD: 2.761

VERT SPREAD: 4.238

GROUP SPREAD: 4.251

MIN RADIUS: 0.134

MAX RADIUS: 2.192

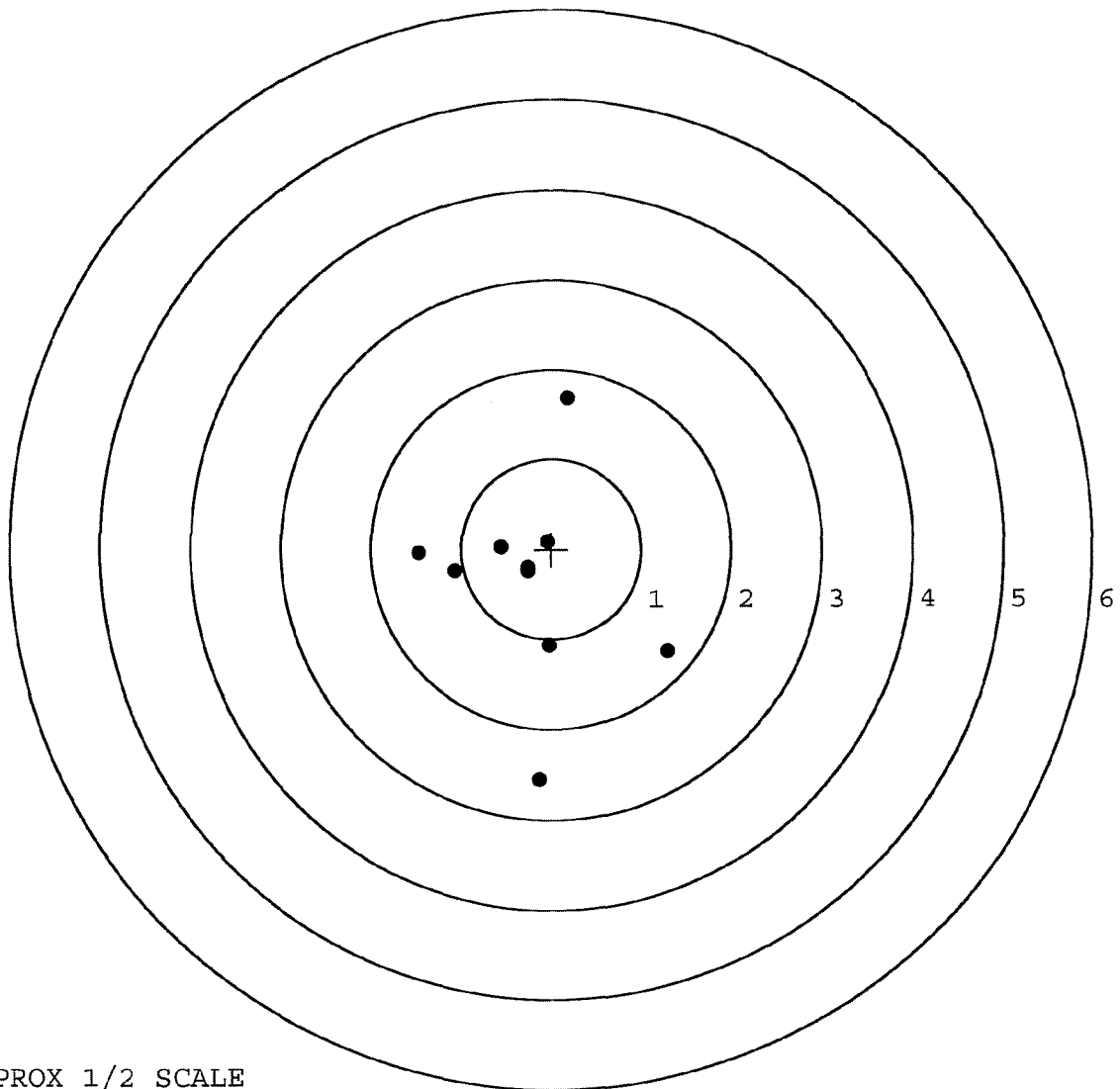
MEAN RADIUS: 1.016

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 7

POINT#	X	Y
1:	-0.264	-0.241
2:	-0.261	-0.206
3:	1.293	-1.134
4:	-0.029	-1.079
5:	-1.468	-0.048
6:	-1.072	-0.242
7:	0.185	1.675
8:	-0.557	0.032
9:	-0.045	0.081
10:	-0.146	-2.563



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: 6611553. 0

TARGET NUMBER: 2

FILE DATE: 06/15/2005

FILE TIME: 07:58

X CENTROID: -0.166

Y CENTROID: -0.373

POA TO CENTROID: 0.408

HORZ SPREAD: 1.684

VERT SPREAD: 2.776

GROUP SPREAD: 2.789

MIN RADIUS: 0.269

MAX RADIUS: 1.567

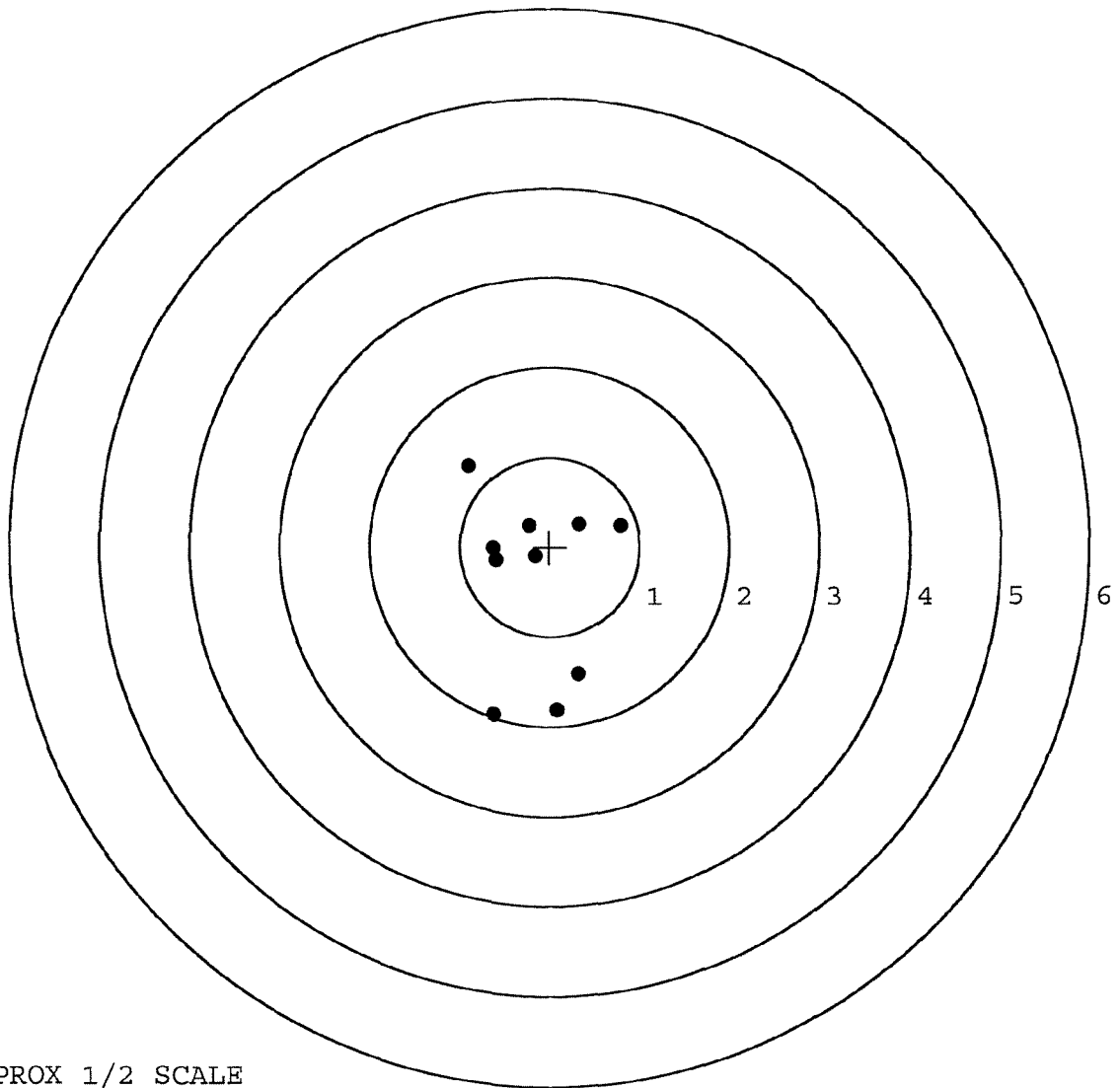
MEAN RADIUS: 0.957

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 5

in 3 IN DIAMETER: 9

POINT#	X	Y
1:	-0.237	0.242
2:	-0.631	-0.008
3:	-0.599	-0.145
4:	-0.165	-0.104
5:	0.317	-1.425
6:	0.076	-1.826
7:	-0.628	-1.870
8:	0.782	0.243
9:	0.324	0.258
10:	-0.902	0.906

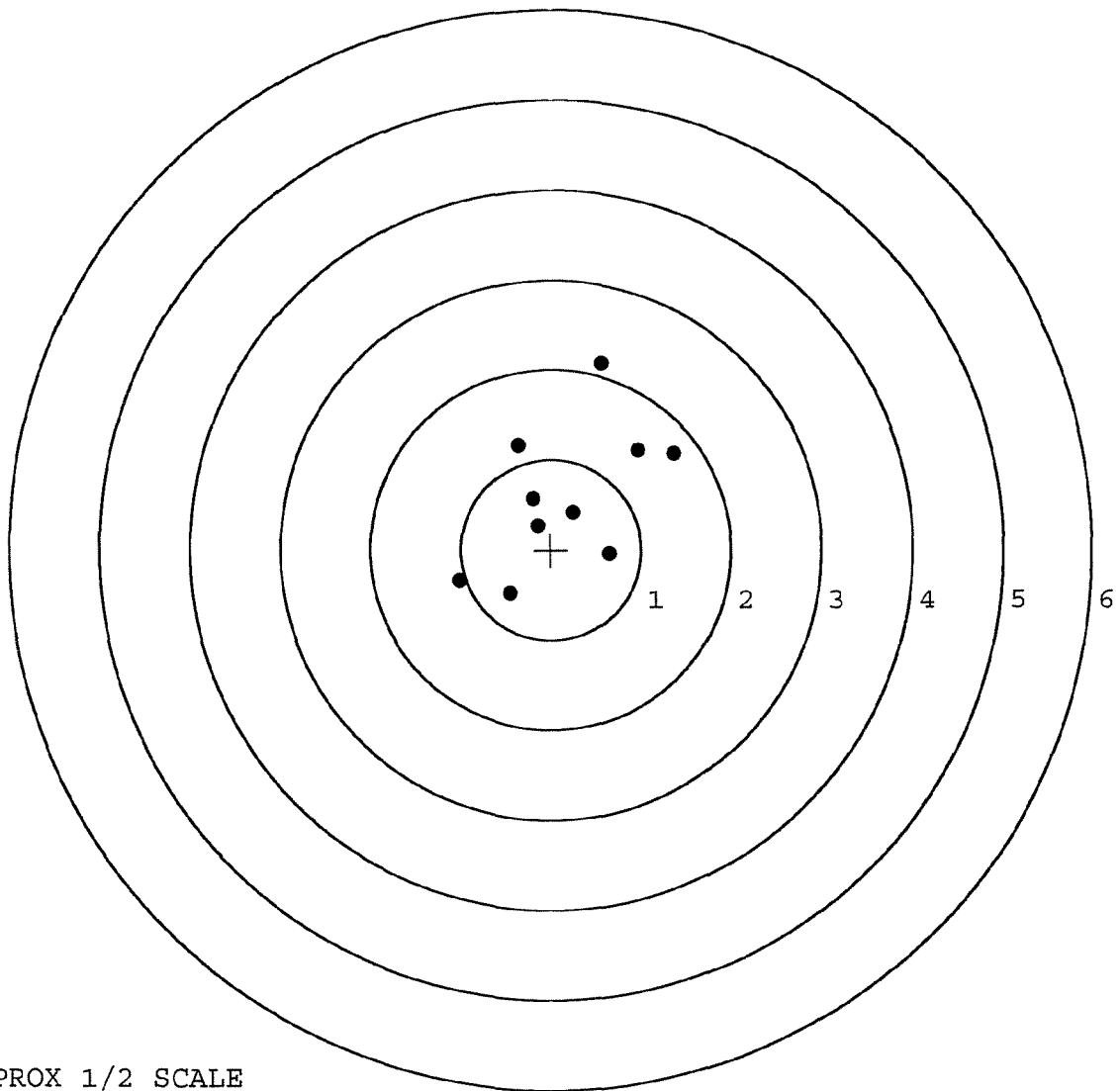


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: 6611553. __0
 TARGET NUMBER: 3
 FILE DATE: 06/15/2005
 FILE TIME: 07:58

X CENTROID: 0.159
 Y CENTROID: 0.577
 POA TO CENTROID: 0.599
 HORZ SPREAD: 2.391
 VERT SPREAD: 2.554
 GROUP SPREAD: 2.894
 MIN RADIUS: 0.178
 MAX RADIUS: 1.549
 MEAN RADIUS: 0.910
 # IN 1 IN DIAMETER: 3
 # IN 2 IN DIAMETER: 6
 # in 3 IN DIAMETER: 8

POINT#	X	Y
1:	-0.365	1.157
2:	0.242	0.420
3:	-0.206	0.569
4:	-0.152	0.267
5:	-1.018	-0.353
6:	-0.456	-0.481
7:	0.648	-0.046
8:	0.968	1.100
9:	1.373	1.066
10:	0.560	2.073

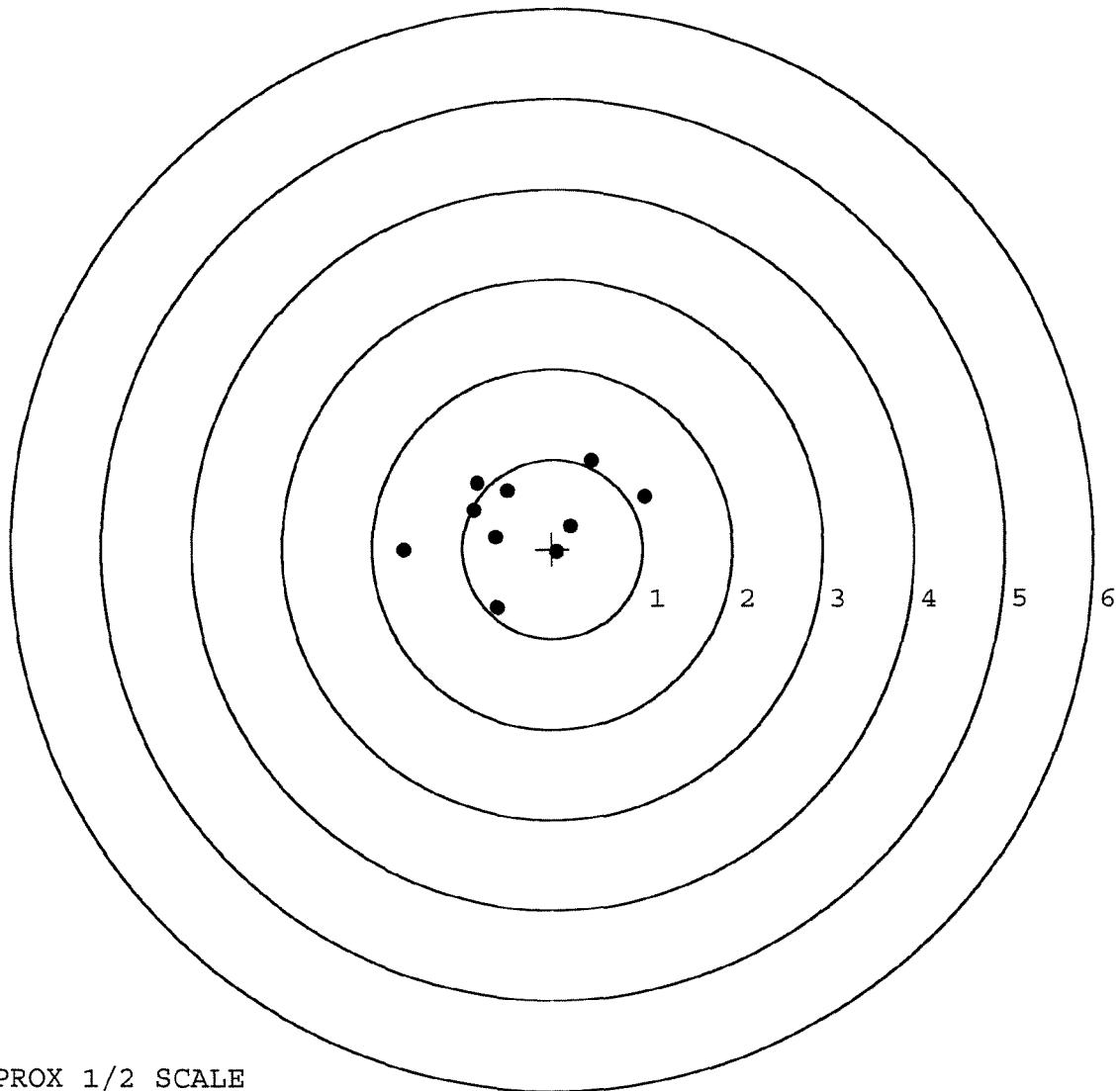


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: 6611553. __0
 TARGET NUMBER: 4
 FILE DATE: 06/15/2005
 FILE TIME: 07:58

X CENTROID: -0.343
 Y CENTROID: 0.305
 POA TO CENTROID: 0.459
 HORZ SPREAD: 2.676
 VERT SPREAD: 1.645
 GROUP SPREAD: 2.744
 MIN RADIUS: 0.334
 MAX RADIUS: 1.395
 MEAN RADIUS: 0.776
 # IN 1 IN DIAMETER: 2
 # IN 2 IN DIAMETER: 6
 # in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.047	-0.037
2:	-0.839	0.730
3:	-0.875	0.427
4:	-0.505	0.656
5:	-0.631	0.137
6:	-0.618	-0.664
7:	-1.653	-0.020
8:	0.429	0.981
9:	1.023	0.588
10:	0.195	0.257



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: 6611553. 0

TARGET NUMBER: 5

FILE DATE: 06/15/2005

FILE TIME: 07:58

X CENTROID: -0.109

Y CENTROID: -0.016

POA TO CENTROID: 0.110

HORZ SPREAD: 2.191

VERT SPREAD: 2.148

GROUP SPREAD: 2.191

MIN RADIUS: 0.272

MAX RADIUS: 1.240

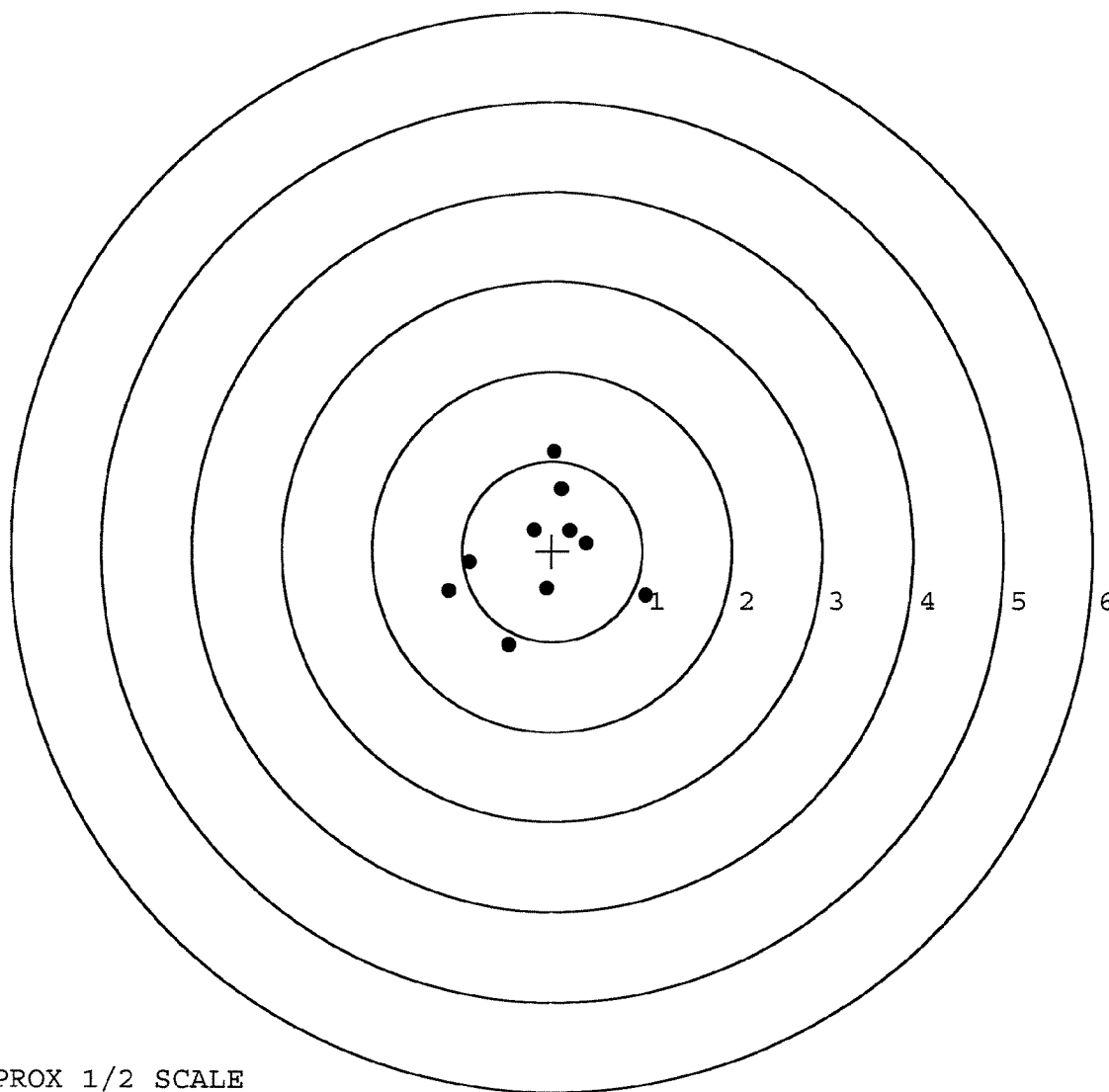
MEAN RADIUS: 0.772

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.020	1.112
2:	0.102	0.689
3:	0.199	0.228
4:	0.377	0.093
5:	1.038	-0.488
6:	-0.202	0.239
7:	-0.065	-0.419
8:	-0.482	-1.036
9:	-1.153	-0.450
10:	-0.922	-0.130



TARGET APPROX 1/2 SCALE

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

R. & E NUMBER	92197				
SERIAL NUMBER	C6611553				
LOG-IN DATE	2-1-05				
INSPECT AND VERIFY:					
OPERATION #	OPERATION NAME	DATE	INITIAL		
550	DIS-ASSEMBLE GUN				
560 A	RE-BARREL				
B	DRILL AND TAP				
575	ASSEMBLE				
600	PROOF				
605	CHECK HEADSPACE				
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			6-21-05	AC
D	SAFETY "OFF" FORCE			6-21-05	AC
E	FIRING PIN INDENT	6-21-05	AC		
640	TARGET <i>test</i>	6-15-05	AC		
655	FINAL INSPECT	6-21-05	AC		
660	PACK	7-11-05	NA		
		SHIP DATE			
		QAR INSPECTION DATE			

Remington
MODEL 700™ H24

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

REG. U.S. PAT. & TM. OFF.

SERIAL NO.
C6611553

ORDER NO.
5716

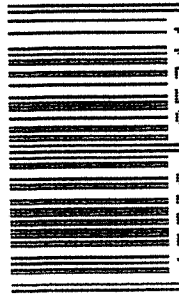
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MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada. Marque Deposee.



5716 C6611553

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6611553

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	3 25 91		RW
600	Proof	3 25 91		RW
607	Check Headspace	3 25 91		RW
610	Dis-assemble Gun	3 25 91		RW
612	Magnaflux Barrel Action	3 28 91		KR
	Magnaflux Bolt	3 28 91		u
615	Rollmark Caliber	3 28 91		LS
617	Drill and Tap Sight Holes	APR 3 1991		FB
618	Polish Barrel	APR 3 1991		WB
620	Apply Coatings (Barrel Action)		4-11-91	TS
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		4/16/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		4/16/91	RW
	C) Inspect Ejector Hole for Chamfer		4/16/91	RW
	D) Oil Firing Pin Ass'y		4/16/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		5/6/91	JH

op. #	BARBER - M24 0078745 OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			5/6/91	JM
	G) Safety Off Force	3	3	3			5/6/91	JM
	H) Trigger Pull Test & Retainability						5/6/91	JM
	I) Firing Pin Indent	10225	10225	10225			5/6/91	JM
	J) Assemble Stock						5/7/91	RW
	K) Assemble Swivel Studs						5-10-91	AC
	L) Attach Front and Rear Sight Assemblies						5/7/91	RW
	M) Iron Sight Alignment						5/7/91	RW
	N) Detach Front & Rear Sights & place in numbered container						5/7/91	RW
	O) Attach Scope to Rifle						5/7/91	RW
	P) Detach & Attach Scope 20 Times						5/7/91	RW
640	Gallery Target & Test						5-7-91	AC
	A) Time						5-7-91	AC
	B) Malfunctions						5-7-91	AC
	C) Pierced Primers						5-7-91	AC
	D) Optical Clarity of Scope						5-7-91	AC
645	Inspect for Live Ammo						5-7-91	AC
655	Final Inspection							
	A) Headspace						5-10-91	AC
	B) Trigger Pull	2.42	2.45	2.45	2.48	2.50	5/9/91	JM
	C) Function						5-10-91	AC
660	Pack						6-17-91	VF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C-6611553

DATE 5/6/91

TESTER JP

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.53	2.45	2.48	2.42	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.42	2.50	2.45	2.45	
PULL #3	2.57	2.48	2.50	2.45	
PULL #4	2.56	2.49	2.55	2.48	
PULL #5	2.28	2.55	2.49	2.50	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.55	3.29		
PULL #2	3.58	3.31		
PULL #3	3.52	3.34		
PULL #4	3.45	3.31		
PULL #5	3.46	3.33		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.22	4.34		4.25
PULL #2	4.19	4.32		4.30
PULL #3	4.18	4.30		4.26
PULL #4	4.18	4.34		4.35
PULL #5	4.32	4.26		4.33
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611553
7 May 1991

CENTROIDAL DISTANCES

0 TO	1	.244125
1 TO	2	.401759
1 TO	3	.281626
1 TO	4	.0910824
1 TO	5	.277478

$\frac{1}{5}$ <----FOR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .156
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0188
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .157129
THE AMR FOR THIS RIFLE IS: .9778

7 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611553

CENTERFIRE PATTERNS

1

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 2

2in = 6

3in = 9

HS= 2.415

VS= 2.462

GS= 2.979

CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.462	.870	.851
MINIMUM X	-.953	-.791	-.810
MAXIMUM Y	1.127	1.239	1.086
MINIMUM Y	-1.335	-1.223	-.778
CENTROID X	.131	-.031	-.012
CENTROID Y	.206	.094	.247
POA TO CENTROID in.	.244	.099	.247
MIN RADIUS	.156	.050	.152
MEAN RADIUS	.917	.784	.746
MAX RADIUS	1.775	1.309	1.159
HORIZONTAL SPREAD	2.415	1.661	1.661
VERTICAL SPREAD	2.462	2.462	1.864
EXTREME SPREAD	2.979	2.528	2.224
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	9		

7 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611553

CENTERFIRE PATTERNS # 2

POA

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 2

2 in = 7

3 in = 9

HS= 1.799

VS= 2.998

GS= 3.015

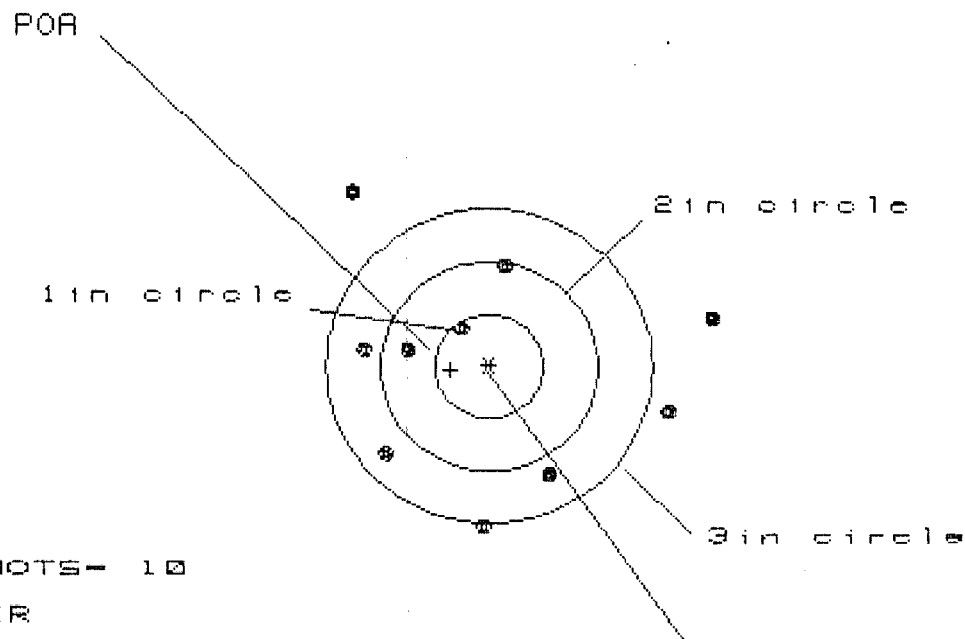
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.964	.910	.883
MINIMUM X	:	-.835	-.889	-.916
MAXIMUM Y	:	1.327	1.141	1.093
MINIMUM Y	:	-1.671	-.710	-.567
CENTROID X	:	.084	.138	.165
CENTROID Y	:	-.193	-.007	-.150
POA TO CENTROID in.	:	.210	.138	.223
MIN RADIUS	:	.158	.279	.136
MEAN RADIUS	:	.857	.779	.687
MAX RADIUS	:	1.740	1.162	1.131
HORIZONTAL SPREAD	:	1.799	1.799	1.799
VERTICAL SPREAD	:	2.998	1.851	1.660
EXTREME SPREAD	:	3.015	1.965	1.804
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

7 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611553

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 1

2in = 2

3in = 6

HS= 3.286

VS= 3.157

GS= 3.503

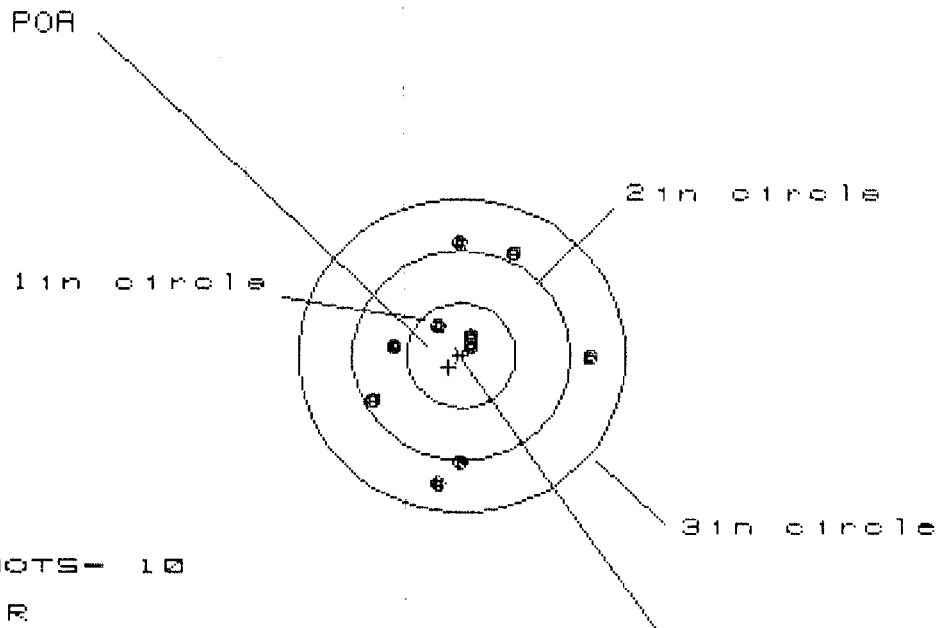
CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.065	1.829	1.705
MINIMUM X	:	-1.221	-.991	-1.073
MAXIMUM Y	:	1.648	1.698	1.257
MINIMUM Y	:	-1.509	-1.459	-1.246
CENTROID X	:	.354	.124	.248
CENTROID Y	:	.034	-.016	-.229
POA TO CENTROID in.	:	.355	.125	.337
MIN RADIUS	:	.434	.391	.623
MEAN RADIUS	:	1.313	1.183	1.101
MAX RADIUS	:	2.115	1.966	1.713
HORIZONTAL SPREAD	:	3.286	2.820	2.778
VERTICAL SPREAD	:	3.157	3.157	2.503
EXTREME SPREAD	:	3.503	3.503	2.847
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		2	
NUMBER IN THREE INCH CIRCLE	=		6	

7 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611553

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 3

2in = 5

3in = 10

HS= 2.0007

VS= 2.260

GS= 2.338

CENTROID #

PATTERN #	:	4	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.178	1.149	.625
MINIMUM X	:	-.829	-.858	-.714
MAXIMUM Y	:	1.063	.930	.909
MINIMUM Y	:	-1.197	-1.162	-1.183
CENTROID X	:	.117	.146	.002
CENTROID Y	:	.116	.249	.270
POA TO CENTROID in.	:	.165	.289	.270
MIN RADIUS	:	.113	.049	.142
MEAN RADIUS	:	.783	.705	.641
MAX RADIUS	:	1.225	1.162	1.190
HORIZONTAL SPREAD	:	2.007	2.007	1.339
VERTICAL SPREAD	:	2.260	2.092	2.092
EXTREME SPREAD	:	2.338	2.101	2.101
NUMBER IN ONE INCH CIRCLE =	:	3		
NUMBER IN TWO INCH CIRCLE =	:	5		
NUMBER IN THREE INCH CIRCLE =	:	10		

7 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611553

CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS - 10

IN CIR.

1in = 0

2in = 6

3in = 9

HS = 3.115

VS = 1.499

GS = 3.150

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.909	1.270	1.146
MINIMUM X	-1.206	-.994	-.815
MAXIMUM Y	.752	.759	.827
MINIMUM Y	-.747	-.740	-.672
CENTROID X	.094	-.118	.006
CENTROID Y	-.069	-.076	-.144
POA TO CENTROID in.	.116	.141	.144
MIN RADIUS	.624	.448	.511
MEAN RADIUS	1.019	.885	.853
MAX RADIUS	1.910	1.480	1.413
HORIZONTAL SPREAD	3.115	2.264	1.961
VERTICAL SPREAD	1.499	1.499	1.499
EXTREME SPREAD	3.150	2.346	2.346
NUMBER IN ONE INCH CIRCLE =		0	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		9	