

C6349005

MODEL 700™ M24

Model **SMS**™

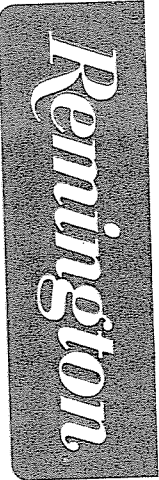
Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.



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: **RE00128538**

Serial: C6349005 Model M24 SWS Center Fire
Caliber: 7.62 NATO

Repairman:

Verify Repair

Status:

New 4/24/2007 7:55:31 AM

Address Information

Customer:

☒ Received From

Return To:

☐ Received From

Name: ISSD ARMSROOM

ISSD ARMSROOM

Address 1: 8TH DESERT STORM

8TH DESERT STORM

Address 2: BLDG 5210 BAY DOOR #30

PO Box:

BLDG 5210 BAY DOOR #30

PO Box:

City: FORT CAMPBELL

FORT CAMPBELL

State: KY

Zip Code: 42223

Country: US

State: KY

Zip Code: 42223

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
D000	FRONT BASE	1

Repair Search

Refresh

Close

nagletj

4/24/2007

8:10 AM

CAPS

NUM

INS

SCRL

start

3 Mi...

5 In...

Arms ...

Part ...

6 Mi...

2 W...

8:10 AM

Serial Number: **C6349005**

Model: **M24 SWS**



RE00128538

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

BARBER - M24 **C6349005** 105553

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6349005.___0

FILE DATE AND TIME: 05/31/2007 01:04

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

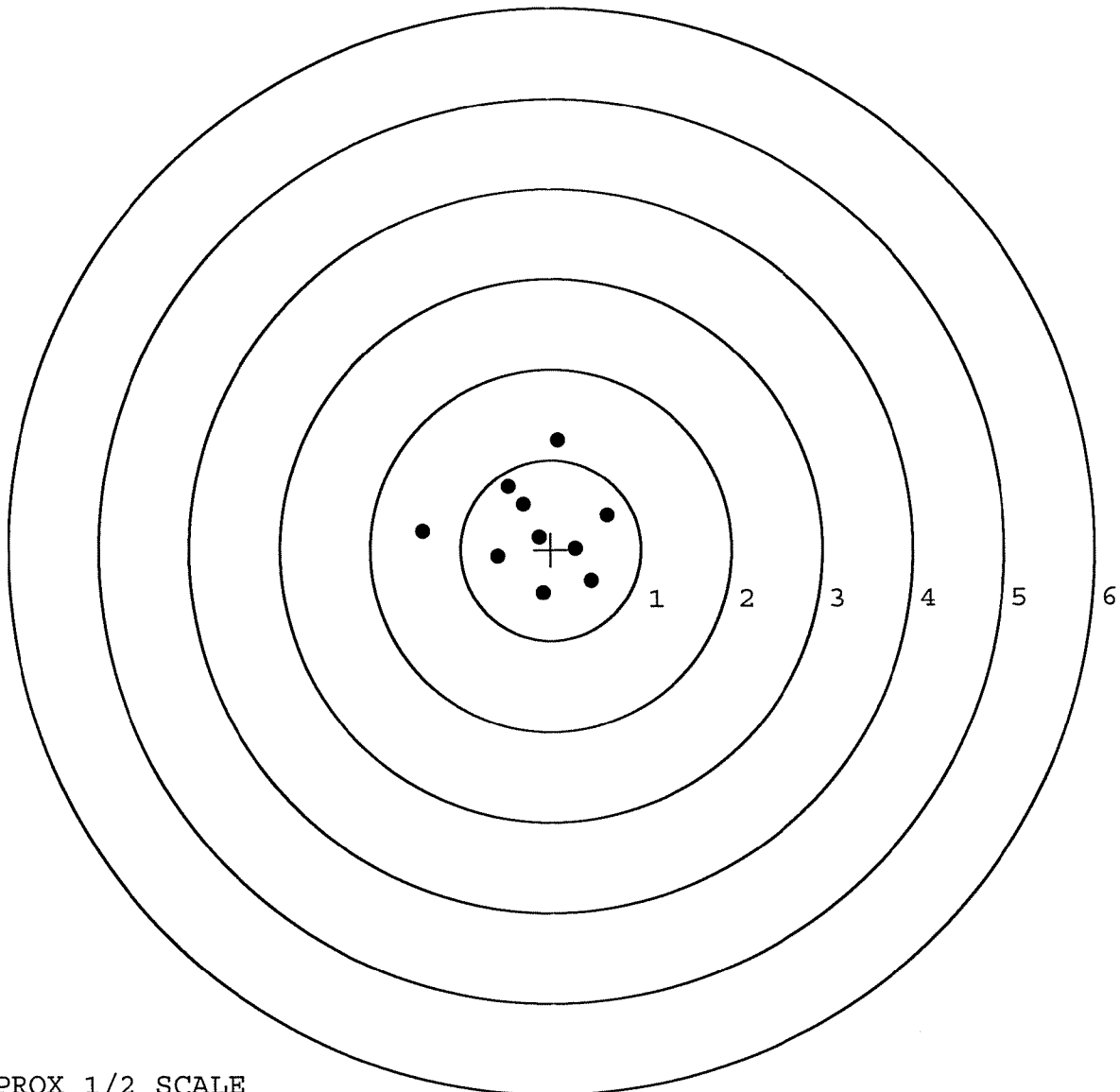
The Average X Centroid of the Five Target Set:	-0.001
The Average Y Centroid of the Five Target Set:	0.030
The Average Point of Impact of the Five Target Set:	0.030
The Average Mean Radius of the Five Target Set:	0.665
The Distance from POA to Centroid Target #1:	0.273
The Distance from Centroid Target #2 to Centroid Target #1:	0.495
The Distance from Centroid Target #3 to Centroid Target #1:	0.295
The Distance from Centroid Target #4 to Centroid Target #1:	0.297
The Distance from Centroid Target #5 to Centroid Target #1:	0.308

BARBER - M24 0105516

SERIAL NUMBER: C6349005. __0
TARGET NUMBER: 1
FILE DATE: 05/31/2007
FILE TIME: 01:04

X CENTROID: -0.156
Y CENTROID: 0.223
POA TO CENTROID: 0.273
HORZ SPREAD: 2.057
VERT SPREAD: 1.700
GROUP SPREAD: 2.064
MIN RADIUS: 0.094
MAX RADIUS: 1.270
MEAN RADIUS: 0.664
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-1.426	0.210
2:	-0.468	0.705
3:	-0.590	-0.078
4:	-0.304	0.506
5:	-0.128	0.134
6:	0.082	1.214
7:	0.631	0.374
8:	0.276	0.007
9:	0.453	-0.352
10:	-0.087	-0.486



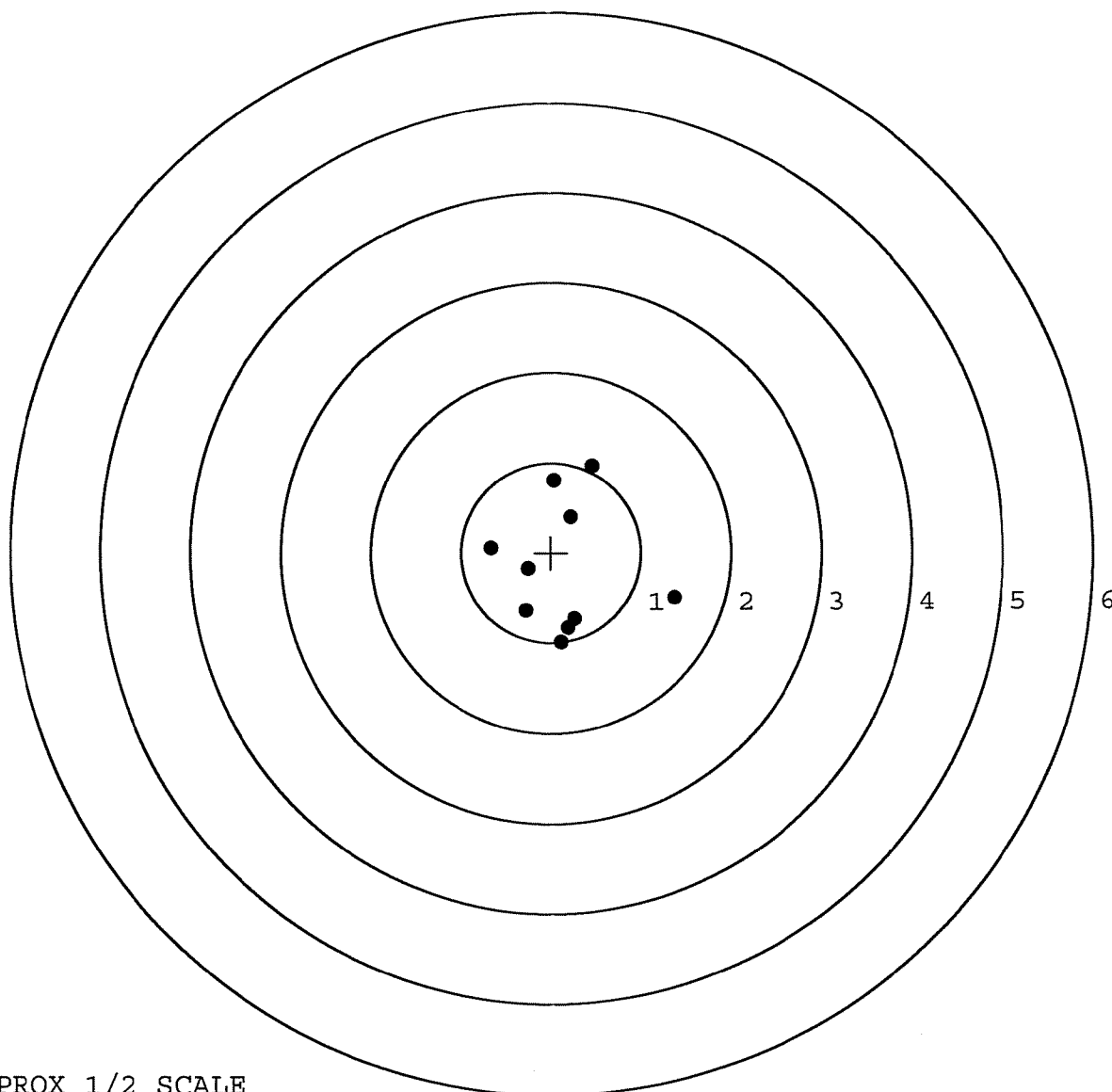
TARGET APPROX 1/2 SCALE

BARBER - M24 0105517

SERIAL NUMBER: C6349005. __ 0
 TARGET NUMBER: 2
 FILE DATE: 05/31/2007
 FILE TIME: 01:04

POINT#	X	Y
1:	0.035	0.802
2:	0.461	0.961
3:	0.220	0.397
4:	-0.673	0.057
5:	-0.260	-0.186
6:	-0.284	-0.651
7:	0.265	-0.741
8:	0.187	-0.844
9:	0.107	-1.002
10:	1.372	-0.508

X CENTROID: 0.143
 Y CENTROID: -0.172
 POA TO CENTROID: 0.223
 HORZ SPREAD: 2.045
 VERT SPREAD: 1.963
 GROUP SPREAD: 2.122
 MIN RADIUS: 0.403
 MAX RADIUS: 1.274
 MEAN RADIUS: 0.798
 # IN 1 IN DIAMETER: 1
 # IN 2 IN DIAMETER: 8
 # in 3 IN DIAMETER: 10



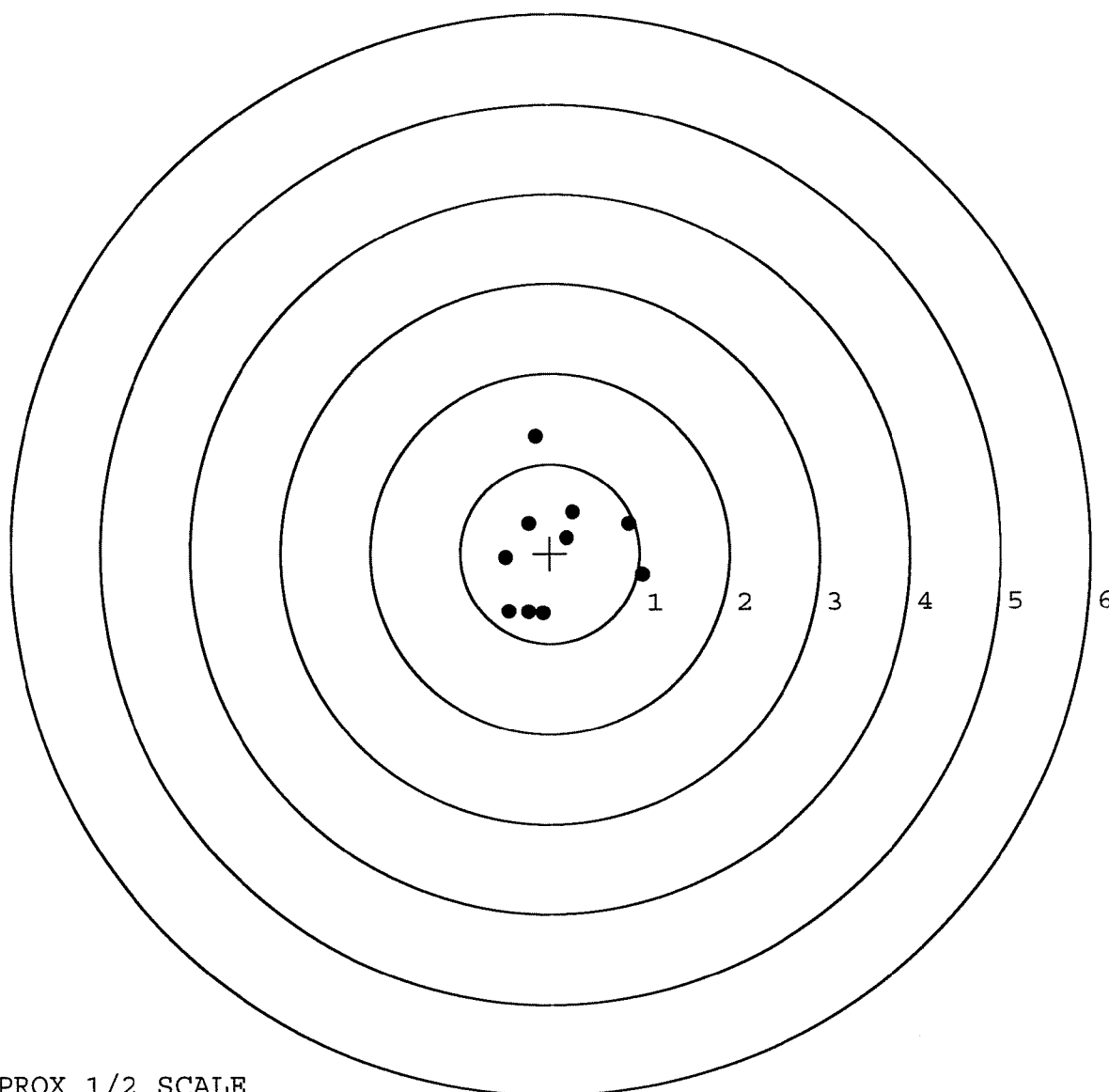
TARGET APPROX 1/2 SCALE

BARBER - M24 0105518

SERIAL NUMBER: C6349005. __0
 TARGET NUMBER: 3
 FILE DATE: 05/31/2007
 FILE TIME: 01:04

POINT#	X	Y
1:	0.886	0.321
2:	1.032	-0.242
3:	-0.158	1.302
4:	0.255	0.458
5:	0.187	0.173
6:	-0.235	0.330
7:	-0.497	-0.048
8:	-0.465	-0.652
9:	-0.246	-0.658
10:	-0.084	-0.671

X CENTROID: 0.068
 Y CENTROID: 0.031
 POA TO CENTROID: 0.074
 HORZ SPREAD: 1.529
 VERT SPREAD: 1.973
 GROUP SPREAD: 1.978
 MIN RADIUS: 0.185
 MAX RADIUS: 1.291
 MEAN RADIUS: 0.715
 # IN 1 IN DIAMETER: 3
 # IN 2 IN DIAMETER: 8
 # in 3 IN DIAMETER: 10



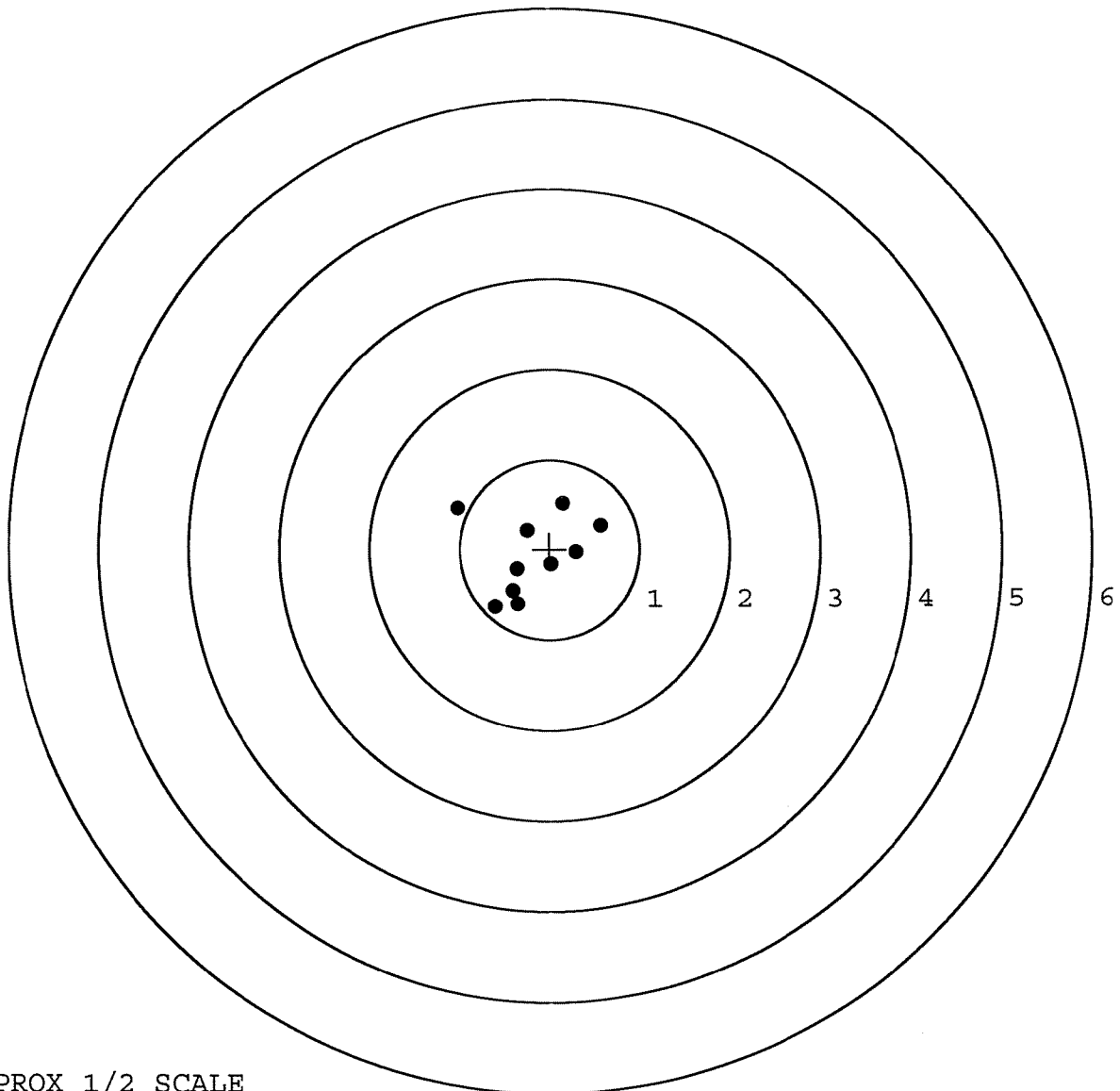
TARGET APPROX 1/2 SCALE

BARBER - M24 0105519

SERIAL NUMBER: C6349005. __0
TARGET NUMBER: 4
FILE DATE: 05/31/2007
FILE TIME: 01:04

X CENTROID: -0.198
Y CENTROID: -0.070
POA TO CENTROID: 0.210
HORZ SPREAD: 1.596
VERT SPREAD: 1.146
GROUP SPREAD: 1.608
MIN RADIUS: 0.229
MAX RADIUS: 0.981
MEAN RADIUS: 0.545
IN 1 IN DIAMETER: 5
IN 2 IN DIAMETER: 10
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-1.023	0.461
2:	-0.610	-0.638
3:	-0.355	-0.612
4:	0.149	0.508
5:	0.573	0.266
6:	0.294	-0.035
7:	-0.248	0.208
8:	0.015	-0.168
9:	-0.366	-0.226
10:	-0.413	-0.466



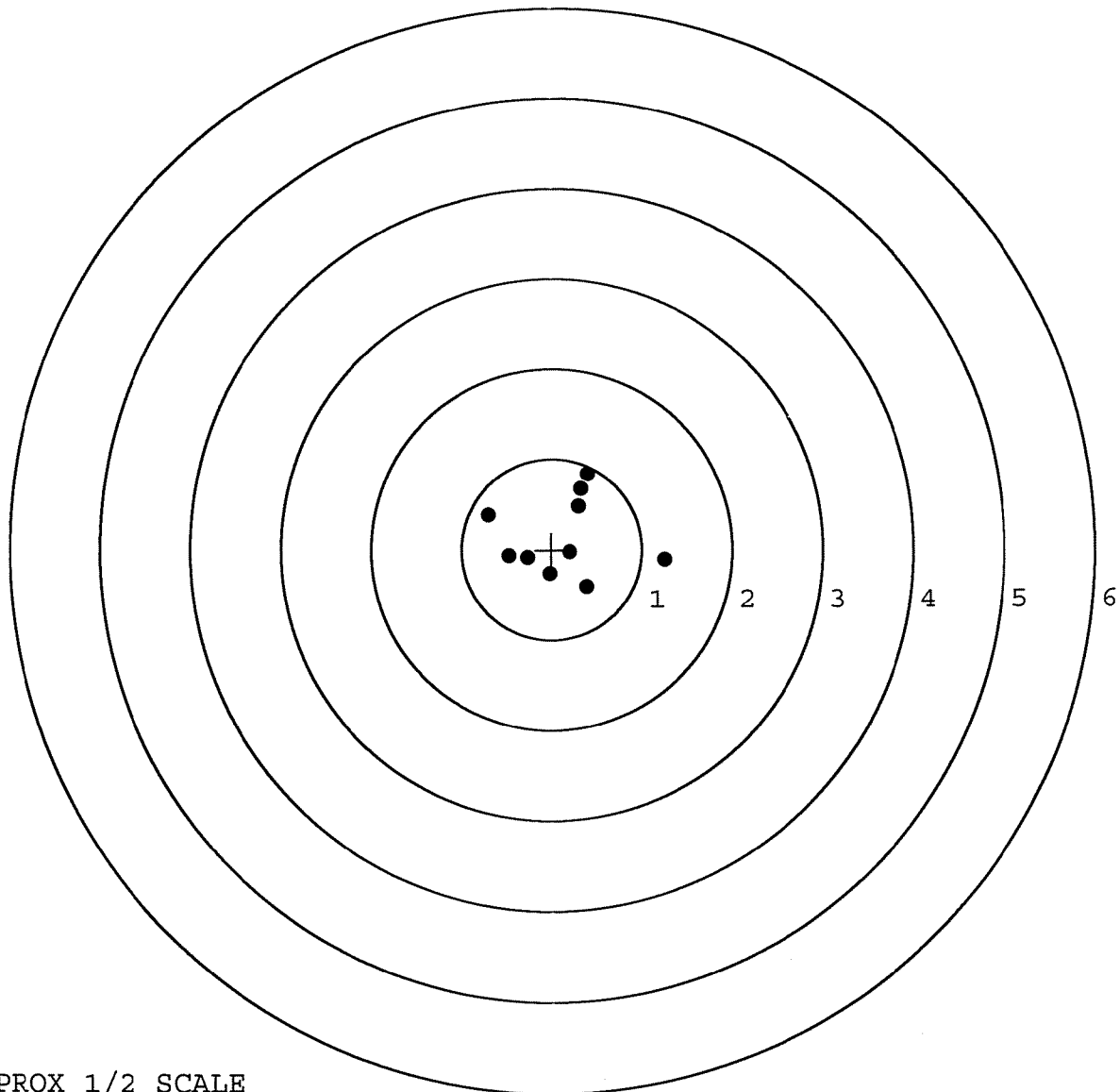
TARGET APPROX 1/2 SCALE

BARBER - M24 0105520

SERIAL NUMBER: C6349005. __0
TARGET NUMBER: 5
FILE DATE: 05/31/2007
FILE TIME: 01:04

X CENTROID: 0.139
Y CENTROID: 0.137
POA TO CENTROID: 0.196
HORZ SPREAD: 1.953
VERT SPREAD: 1.243
GROUP SPREAD: 2.016
MIN RADIUS: 0.177
MAX RADIUS: 1.137
MEAN RADIUS: 0.605
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.401	0.829
2:	0.302	0.479
3:	1.248	-0.116
4:	0.388	-0.414
5:	0.201	-0.029
6:	-0.022	-0.273
7:	-0.272	-0.092
8:	-0.479	-0.067
9:	-0.705	0.386
10:	0.331	0.669



TARGET APPROX 1/2 SCALE

R & E NUMBER	128538			
SERIAL NUMBER	C6349005			
LOG-IN DATE	4-24-07			
OPERATION #	OPERATION NAME		DATE	INITIAL
500	DIS-ASSEMBLE GUN		5-16-07	RTZ
505	RE-BARREL		5-18-07	RTZ
560	ASSEMBLE		5-18-07	RTZ
600	PROOF	MAGNA - FLUX	5-18-07	TRW
605	CHECK HEADSPACE	MAY 21 2008	5-18-07	TRW
610	DIS-ASSEMBLE GUN		5-21-07	RTZ
612	MAGNAFLUX	OPERATOR <i>unms</i>	5/21/07	<i>unms</i>
510	DRILL AND TAP		5-21-07	TRW
615	ROLLMARK CALIBER		5-21-07	CW
618	ROTO-BLAST		5-22-07	UB
620	APPLY COATINGS		5-24-07	WS
625	FINAL ASSEMBLY		5-30-07	RTZ
640	FUNCTION TEST AND	(PASS) FAIL	5-30-07	TRW
650	TARGET	(PASS) FAIL	5-30-07	TRW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION	5-30-07	Fm
670	FINAL INSPECTION		6-8-07	RTZ
	A) HEADSPACE	(PASS) FAIL	6-8-07	RTZ
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	2.84 2.82 2.81 2.84 2.83	6-1-07
680	F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX	4.5 4.5 4.2	6-1-07
	G) SAFETY OFF FORCE	2 LBS MIN	2.2 2.5 2.2	6-1-07
	I) FIRING PIN INDENT	.020	1023 .024 1024	6-1-07
690	PACK		6-8-07	RA

96B

MAINTENANCE REQUEST				PAGE NO.	NO. OF PAGES	REQUIREMENTS CONTROL SYMBOL													
For use of this form, see DA PAM 738-750; the proponent agency is DCSLOG				1	1	CSGLD - 1047(R1)													
SECTION I - EQUIPMENT DATA																			
CONTROL NUMBER		WORK ORDER NO.		WESDC		ORG. PD		PD AUTHENTICATION											
☐ Work Request ☐ MWO ☒ Warranty Claim		1A. ORGANIZATION C Co 315 SFG		B. LOCATION Ft. Campbell Ky 42223			C. UNIT IDENT CODE WH06CO												
2. SERIAL NO. C6349005		3. NOUN NOMENCLATURE 7.62 Superc Rifle M24		4. LINE NO. R95387		5. MODEL		6. NATIONAL STOCK NUMBER 1005-01-240-2136											
7A. MAINTENANCE ACTIVITY IMO		B. LEVEL		8. UTILIZATION CODE		9A. MCSR ITEM		9B. ERC		9C. PACING ITEM		10. HOURS		11. MILES		12. ROUNDS		13. STARTS	
14. FAILURE DETECTED DURING (Select one - use ☒ or X)										15. FIRST INDICATION OF TROUBLE (Select one - use ☒ or X)									
☐ A Sch. Main. ☐ C Test ☐ E Storage ☐ G Flight ☐ B Handling ☐ D Normal Op ☐ F Inspection ☒ H Other										☐ 068 Inoperative ☐ 258 Overheating ☐ 790 Out of Adjustment ☐ 008 Noisy ☐ 387 Low Performance ☒ Other									
16A. DESCRIBE DEFICIENCIES OR SYMPTOMS ON THE BASIS OF COMPLETE CHECKOUT AND DIAGNOSTIC PROCEDURE IN EQUIPMENT TM (Do not prescribe repairs). 5,300 Rounds Fired																			
B. REMARKS W 52 4095345 H 245																			
PREPARATION INSTRUCTIONS (Prior to using this form, read DA PAM 738-750 for detailed preparation instructions)																			
- Place a "✓" or an "X" in the box for the type of action required. - Enter the WESDC if the item is Materiel Condition Status Reportable. - Enter the priority designator as determined from the urgency of need and force activity designator. - The Unit Commander, Chief of TDA activity or their designated representative will authenticate, by signature, a priority of 01 through 08. - Block 1A. Enter the name of the organization submitting the request. - Block 1B. Enter the unit submitting the request; units overseas enter APO only. - Block 1C. Enter the unit identification code of the unit in block 1A. - Block 2. Enter the equipment serial number. For ammunition, enter the lot number. For administrative-use vehicles, enter the USA registration number. - Block 3. Enter the noun abbreviation of the item. - Block 4. Enter the item line number, if applicable. - Block 5. Enter the model number. - Block 6. Enter the National Stock Number of the item listed in Block 3.										- Block 7. Enter the name of the support activity. - Block 7A. Enter the symbol of the maintenance category (O, F, H, D, or L). - Block 8. Enter the utilization code. - Block 9A. Enter the word "yes" if the item is Materiel Condition Status Reportable. - Block 9B. Enter the equipment readiness code, if applicable. - Block 9C. Enter the word "yes" if the item is a pacing item. - Block 10. Enter the hour reading, if applicable. - Block 11. Enter the mileage from the odometer, if applicable. - Block 12. Enter the total rounds fired, if applicable. - Block 13. For turbine engines, enter the number of hot starts. - Block 14. Enter a "✓" or "X" in the proper block. - Block 15. Enter a "✓" or "X" in the proper block. - Block 16. Describe briefly the fault or symptoms needing correction.									
23. SUBMITTED BY Tony J. Williams		24. RECEIVED BY																	
JULIAN DATE		JULIAN DATE																	

96B

MAINTENANCE REQUEST				PAGE NO.	NO. OF PAGES	REQUIREMENTS CONTROL SYMBOL													
For use of this form, see DA PAM 738-750; the proponent agency is DCSLOG				1	1	CSGLD - 1047(R1)													
SECTION I - EQUIPMENT DATA																			
CONTROL NUMBER		WORK ORDER NO.		WESDC		ORG. PD		PD AUTHENTICATION											
☐ Work Request ☐ MWO ☒ Warranty Claim		1A. ORGANIZATION C Co 315 SFG		B. LOCATION Ft. Campbell Ky 42223			C. UNIT IDENT CODE WH06CO												
2. SERIAL NO. C6349005		3. NOUN NOMENCLATURE 762 Sniper Rifle M24		4. LINE NO. R295387		5. MODEL		6. NATIONAL STOCK NUMBER 1005-01-240-2136											
7A. MAINTENANCE ACTIVITY IMO		B. LEVEL		8. UTILIZATION CODE		9A. MCSR ITEM		9B. ERC		9C. PACING ITEM		10. HOURS		11. MILES		12. ROUNDS		13. STARTS	
14. FAILURE DETECTED DURING (Select one - use ☒ or X) ☐ A Sch. Main. ☐ C Test ☐ E Storage ☐ G Flight ☐ B Handling ☐ D Normal Op ☐ F Inspection ☒ H Other										15. FIRST INDICATION OF TROUBLE (Select one - use ☒ or X) ☐ 068 Inoperative ☐ 258 Overheating ☐ 790 Out of Adjustment ☐ 008 Noisy ☐ 387 Low Performance ☒ Other									
16A. DESCRIBE DEFICIENCIES OR SYMPTOMS ON THE BASIS OF COMPLETE CHECKOUT AND DIAGNOSTIC PROCEDURE IN EQUIPMENT TM (Do not prescribe repairs). 5300 Rounds Fired																			
B. REMARKS W 56 4095 345 H 645																			
SECTION II - WORK ACCOMPLISHED																			
17A. REPAIR ORGANIZATION/ACTIVITY				C. UNIT IDENT. CODE				18. TYPE ORGANIZATION/ACTIVITY ACCOMPLISHING WORK (Select one - use ☒ or X) ☐ 1 TOE ☐ 2 TD ☐ 3 Contractor				19. AMS ACCT. CODE							
B. LOCATION																			
20A. ACT. CODE		B. FAILURE CODE		C. COMPONENT/PART NOUN, SVC, OR MWO NO. (1) CB CODE (2) REF DESIGN. (3) MFR. CODE			D. MANHOURS (Hrs. & tenths)		E. NATIONAL STOCK NUMBER		F. PART SOURCE CODE		G. QTY.		H. PARTS COST				
							.								\$				
							.								\$				
							.								\$				
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							.								\$				
							.								\$				
				I. TOTAL MANHOURS				J. TOTAL MANHOURS COST \$				K. TOTAL PARTS COST \$							
21. DELAY (Select One) ☐ 1 Parts ☐ 2 Manpower ☐ 3 Facilities ☐ 4 Funds ☐ 5 Tools								22. Data Transcribed											
23. SUBMITTED BY Tony J. Santos		24. RECEIVED BY		25. WORK STARTED BY		26. INSPECTED BY		27. ACCEPTED BY		28. DISPOSITION (Select One) ☐ A To User ☐ D Evacuated ☐ B To Stock ☐ E Cannibalization ☐ C Salvaged									
JULIAN DATE		JULIAN DATE		JULIAN DATE		JULIAN DATE		JULIAN DATE											

DA FORM 2407, AUG 88

EDITION OF MAY 81 MAY BE USED

NMP COPY 2

Final Inspection

Sn: C6349005

DATE REC'D: 12/04/95

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:

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6349005

OP. #	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and Stock		12/21/95	RW
600	Proof		12/21/95	RW
607	Check Headspace		12/21/95	RW
610	Dis-assemble Gun		12/21/95	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		1/5/96	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		1/5/96	RW
	C) Inspect Ejector Hole for Chamfer		1/5/96	RW
	D) Oil Firing Pin Ass'y		1/5/96	RW
	E) Adjust Trigger Pull to Min Setting and Stake			

op. #	BARBER - M24 0105527 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			
	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		1/8/96	RW
	A) Time			
	B) Malfunctions			
	C) Pierced Primers			
	D) Optical Clarity of Scope			
645	Inspect for Live Ammo		1/8/96	RW
655	Final Inspection A) Headspace		1/10/96	RW
	B) Trigger Pull	2.23 2.31 2.47 2.30 2.35	1/10/96	RW
	C) Function		1/10/96	RW
660	Pack			

CENTROIDAL DISTANCE CALCULATIONS

FOR RIFLE # 06349005

7 Jan 1900

CENTROIDAL DISTANCES

0 TO	1	1.33379
1 TO	2	.537532
1 TO	3	.169009
1 TO	4	.318729
1 TO	5	.299803

$\frac{5^2}{43}$

+ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1346

THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: 1.4414

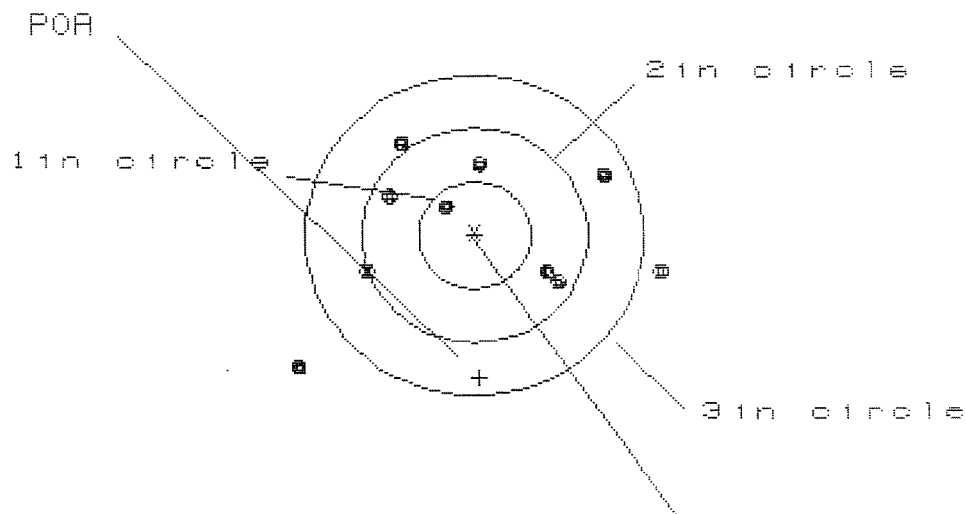
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: 1.44767

THE AMR FOR THIS RIFLE IS: 1.045

7 Jan 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C6349005

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

CENTROID #

IN CIR

1 in = 1

2 in = 5

3 in = 8

HS= 3.196

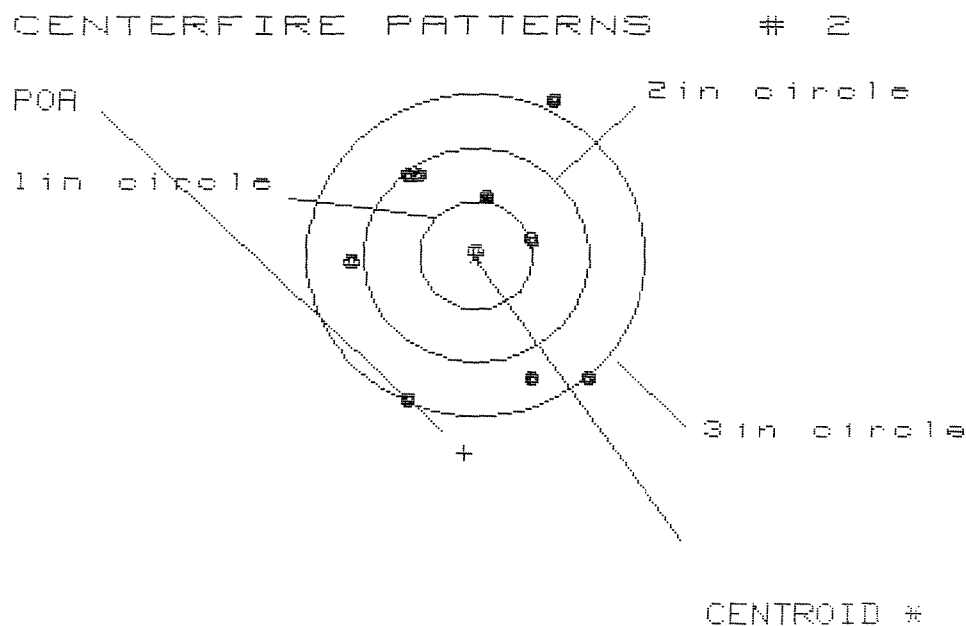
VS= 2.129

GS= 3.324

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.689	1.432	1.098
MINIMUM X	-1.587	-1.180	-1.001
MAXIMUM Y	.851	.709	.646
MINIMUM Y	-1.278	-.622	-.685
CENTROID X	-.046	.131	-.048
CENTROID Y	1.333	1.475	1.538
POA TO CENTROID in.	1.333	1.480	1.539
MIN RADIUS	.364	.423	.233
MEAN RADIUS	1.054	.923	.815
MAX RADIUS	2.038	1.520	1.154
HORIZONTAL SPREAD	3.196	2.612	2.099
VERTICAL SPREAD	2.129	1.331	1.331
EXTREME SPREAD	3.324	2.613	2.273
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	8		

7 Jan 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C6349085



OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 8

HS= 2.070

VS= 2.799

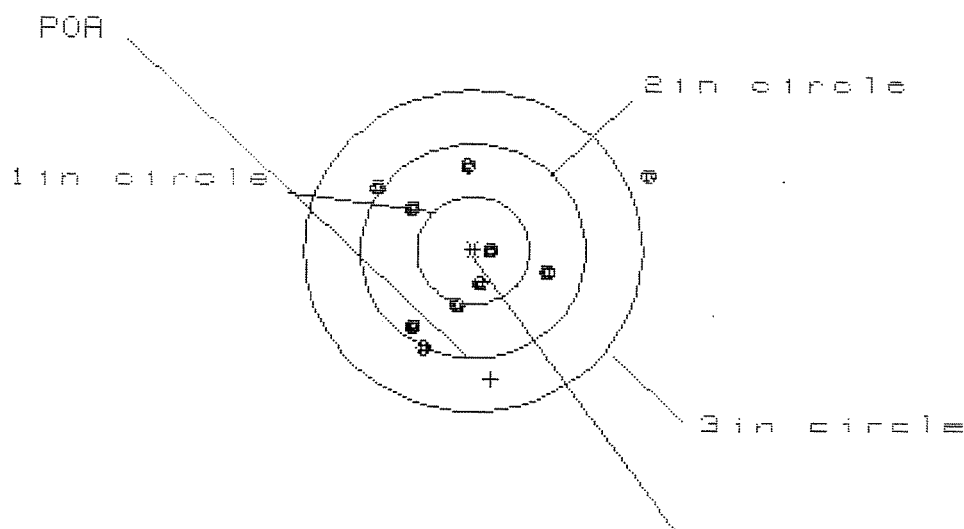
GS= 3.083

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.006	1.083	.744
MINIMUM X	:	-1.064	-.987	-.851
MAXIMUM Y	:	1.472	.954	.831
MINIMUM Y	:	-1.327	-1.164	-1.287
CENTROID X	:	.108	.031	-.105
CENTROID Y	:	1.848	1.685	1.808
POA TO CENTROID in.	:	1.851	1.685	1.811
MIN RADIUS	:	.085	.239	.202
MEAN RADIUS	:	.999	.955	.858
MAX RADIUS	:	1.628	1.467	1.368
HORIZONTAL SPREAD	:	2.070	2.070	1.595
VERTICAL SPREAD	:	2.799	2.118	2.118
EXTREME SPREAD	:	3.083	2.528	2.284
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

7 Jan 1988

FILE:/PATTERNING/CENTERFIRE_PATT/06349085

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 8

3 in = 9

HS= 2.459

VS= 1.717

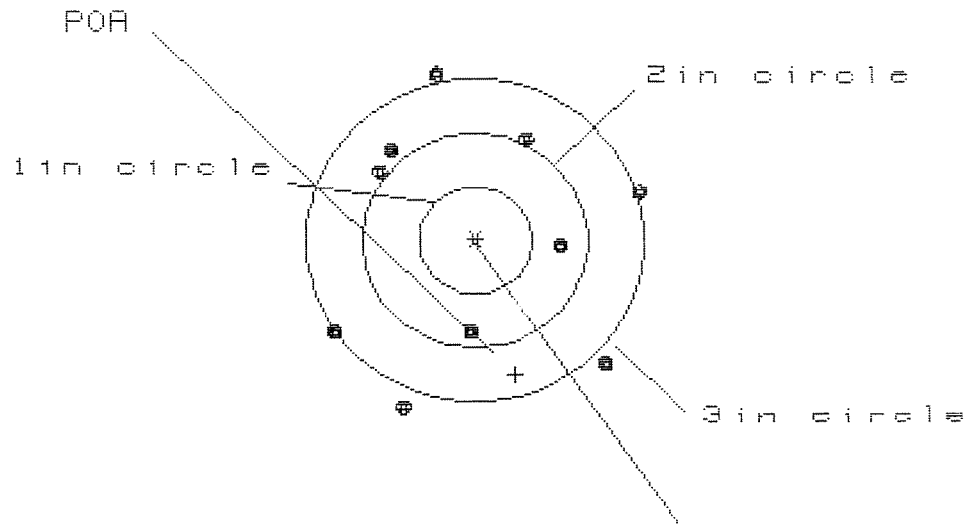
GS= 2.549

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.596	.843	.757
MINIMUM X	:	-.863	-.686	-.458
MAXIMUM Y	:	.838	.917	1.002
MINIMUM Y	:	-.879	-.800	-.715
CENTROID X	:	-.154	-.331	-.245
CENTROID Y	:	1.203	1.124	1.039
POA TO CENTROID in.	:	1.213	1.172	1.067
MIN RADIUS	:	.173	.337	.217
MEAN RADIUS	:	.780	.664	.599
MAX RADIUS	:	1.745	.969	1.003
HORIZONTAL SPREAD	:	2.459	1.529	1.215
VERTICAL SPREAD	:	1.717	1.717	1.717
EXTREME SPREAD	:	2.549	1.752	1.752
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	

7 Jan 1988

FILE:/PATTERNING/CENTERFIRE_PATT/06349005

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 0

2in = 2

3in = 5

HS= 2.660

VS= 3.047

GS= 3.131

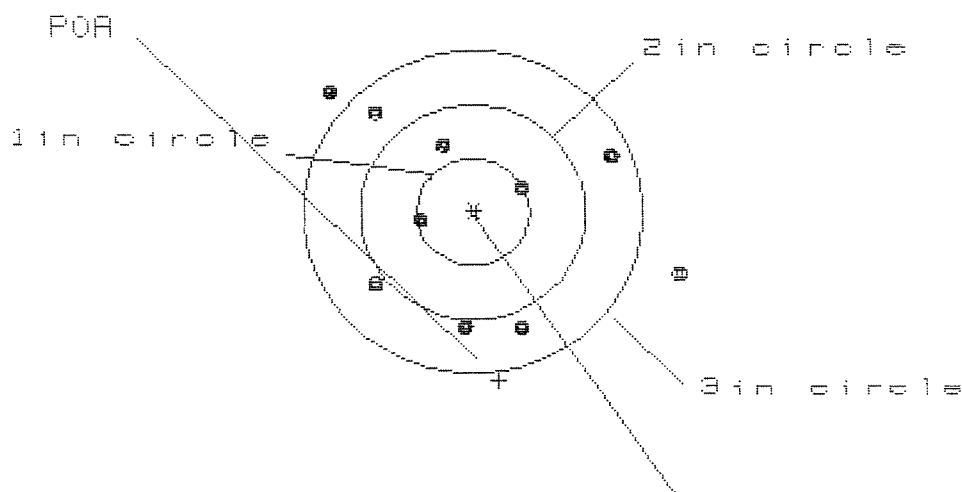
CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.431	1.565	1.498
MINIMUM X	:	-1.229	-1.095	-1.162
MAXIMUM Y	:	1.527	1.395	1.188
MINIMUM Y	:	-1.520	-1.652	-1.202
CENTROID X	:	-.354	-.488	-.421
CENTROID Y	:	1.251	1.383	1.590
POA TO CENTROID in.	:	1.300	1.467	1.645
MIN RADIUS	:	.750	.889	.795
MEAN RADIUS	:	1.272	1.211	1.117
MAX RADIUS	:	1.693	1.736	1.671
HORIZONTAL SPREAD	:	2.660	2.660	2.660
VERTICAL SPREAD	:	3.047	3.047	2.398
EXTREME SPREAD	:	3.131	3.063	2.973
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		2	
NUMBER IN THREE INCH CIRCLE	=		5	

7 Jan 1988

FILE:/PATTERNING/CENTERFIRE_PATT/06349005

CENTERFIRE PATTERNS # 5



OF SHOTS= 10

CENTROID #

IN CIR

1in = 2

2in = 3

3in = 8

HS= 3.128

VS= 2.189

GS= 3.539

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.829	1.386	1.249
MINIMUM X	:	-1.299	-1.095	-.854
MAXIMUM Y	:	1.097	1.035	1.034
MINIMUM Y	:	-1.102	-1.164	-1.034
CENTROID X	:	-.227	-.431	-.294
CENTROID Y	:	1.572	1.634	1.504
POA TO CENTROID in.	:	1.588	1.689	1.533
MIN RADIUS	:	.443	.261	.375
MEAN RADIUS	:	1.120	1.006	.945
MAX RADIUS	:	1.913	1.507	1.370
HORIZONTAL SPREAD	:	3.128	2.481	2.103
VERTICAL SPREAD	:	2.199	2.199	2.068
EXTREME SPREAD	:	3.539	2.789	2.433
NUMBER IN ONE INCH CIRCLE =			2	
NUMBER IN TWO INCH CIRCLE =			3	
NUMBER IN THREE INCH CIRCLE =			8	



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

MODEL 700™ M24

01

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

SERIAL NO.
C6349005

ORDER NO.
5716



5716 C6349005

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6349005

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	4 12	90	RW
600	Proof	4 12	90	A
607	Check Headspace	4 12	90	A
610	Dis-assemble Gun	4 12	90	RW
612	Magnaflux Barrel Action	4-19-90		KCR
	Magnaflux Bolt	4-19-90		KCR
615	Rollmark Caliber	4-19-90		LS
617	Drill and Tap Sight Holes		4/23/90	LB
618	Polish Barrel RB		4/24/90	WB
620	Apply Coatings (Barrel Action)		4/30/90	JA
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		5/1/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/1/90	RW
	C) Inspect Ejector Hole for Chamfer		5/1/90	RW
	D) Oil Firing Pin Ass'y		5/1/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		5/18/90	WB

BARBER - M24 0105536

BARBER - M24 0105536								
op. #	OP. NAME	READINGS			DATE	INIT		
625 cont.	F) Safety On Force	4 1/2	4 1/2	4 1/2	5/19/90	WB		
	G) Safety Off Force	2 1/2	2 1/2	2 1/2	5/19/90	WB		
	H) Trigger Pull Test & Retainability				5/18/90	WB		
	I) Firing Pin Indent	.073	.073	.073	5/19/90	WB		
	J) Assemble Stock				5/19/90	RW		
	K) Assemble Swivel Studs				25 May 90	JS		
	L) Attach Front and Rear Sight Assemblies				5/19/90	RW		
	M) Iron Sight Alignment				5/19/90	RW		
	N) Detach Front & Rear Sights & place in numbered container				5/19/90	RW		
	O) Attach Scope to Rifle				5/19/90	WB		
	P) Detach & Attach Scope 20 Times				5/19/90	WB		
640	Gallery Target & Test				5-21-90	DH		
	A) Time				5-21-90	DH		
	B) Malfunctions				5-21-90	DH		
	C) Pierced Primers				5-21-90	DH		
	D) Optical Clarity of Scope				5-21-90	DH		
645	Inspect for Live Ammo				5-21-90	DH		
655	Final Inspection							
	A) Headspace				25 May 90	JS		
	B) Trigger Pull	273	260	264	263	282	25 May 90	JS
	C) Function						25 May 90	JS
660	Pack						6/20/90	DH

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C6349005

DATE 5/18/90

TESTER WB

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.51	2.30	2.47	2.73	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.49	2.31	2.48	2.60	
PULL #3	2.44	2.23	2.47	2.64	
PULL #4	2.41	2.24	2.44	2.63	
PULL #5	2.43	2.23	2.45	2.82	
TOTAL	12.28	11.31	12.31		
AVG.	2.45	2.26	2.46		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.39	3.41		
PULL #2	3.43	3.39		
PULL #3	3.47	3.58		
PULL #4	3.56	3.55		
PULL #5	3.52	3.34		
TOTAL	17.37	17.27		
AVG.	3.47	3.45		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.08	4.09		4.43
PULL #2	4.08	4.14		4.13
PULL #3	4.06	4.16		4.23
PULL #4	4.14	4.17		4.24
PULL #5	4.06	4.16		4.17
TOTAL	204.2	20.72		21.20
AVG.	4.08	4.14		4.24

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6349005
22 May 1990

CENTROIDAL DISTANCES

0 TO	1	.408534
1 TO	2	.733665
1 TO	3	.21281
1 TO	4	1.022
1 TO	5	.772243

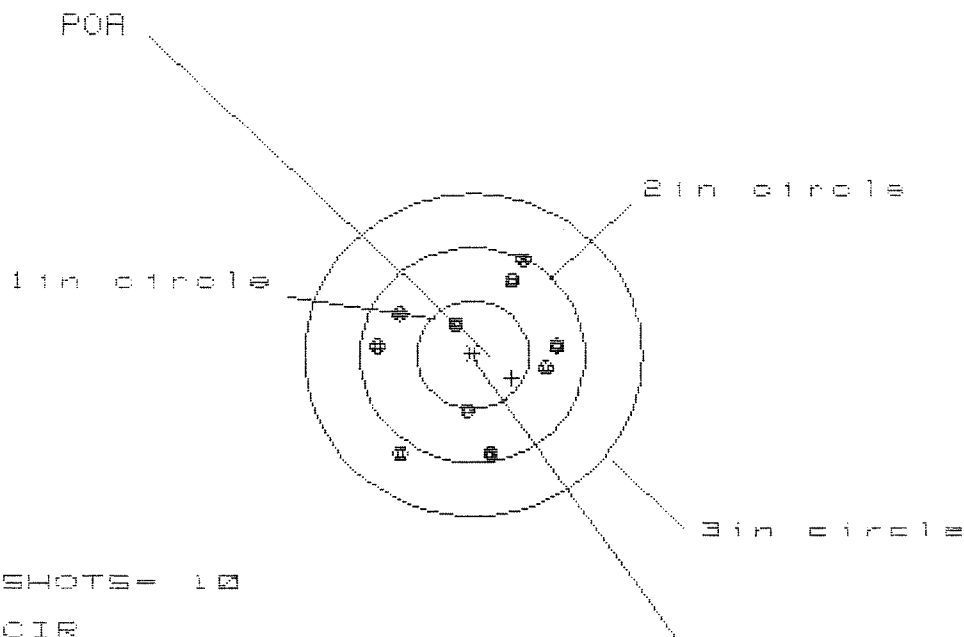
4
13 $\frac{4}{5}$ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0804
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .4698
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .47663
THE AMR FOR THIS RIFLE IS: .9468

21 May 1990

FILE:/PATTERNING/CENTERFIRE_PATT/06349005

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 8

3 in = 10

HS= 1.624

VS= 1.850

GS= 2.149

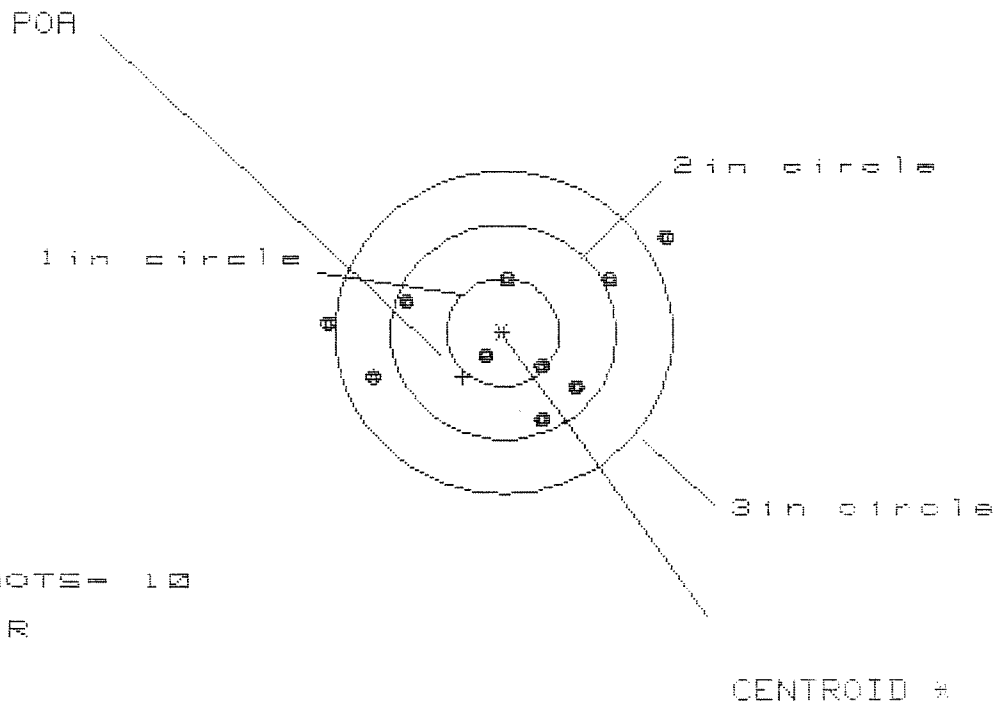
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.774	.701	.750
MINIMUM X	-.850	-.923	-.873
MAXIMUM Y	.910	.808	.658
MINIMUM Y	-.940	-1.042	-.942
CENTROID X	-.348	-.275	-.325
CENTROID Y	.214	.316	.216
POA TO CENTROID in.	.408	.419	.390
MIN RADIUS	.298	.281	.310
MEAN RADIUS	.773	.720	.696
MAX RADIUS	1.132	1.048	.954
HORIZONTAL SPREAD	1.624	1.624	1.624
VERTICAL SPREAD	1.850	1.850	1.600
EXTREME SPREAD	2.149	1.872	1.624
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =		8	
NUMBER IN THREE INCH CIRCLE =		10	

21 May 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6349005

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1 in = 2

2 in = 6

3 in = 8

HS= 2.967

VS= 1.616

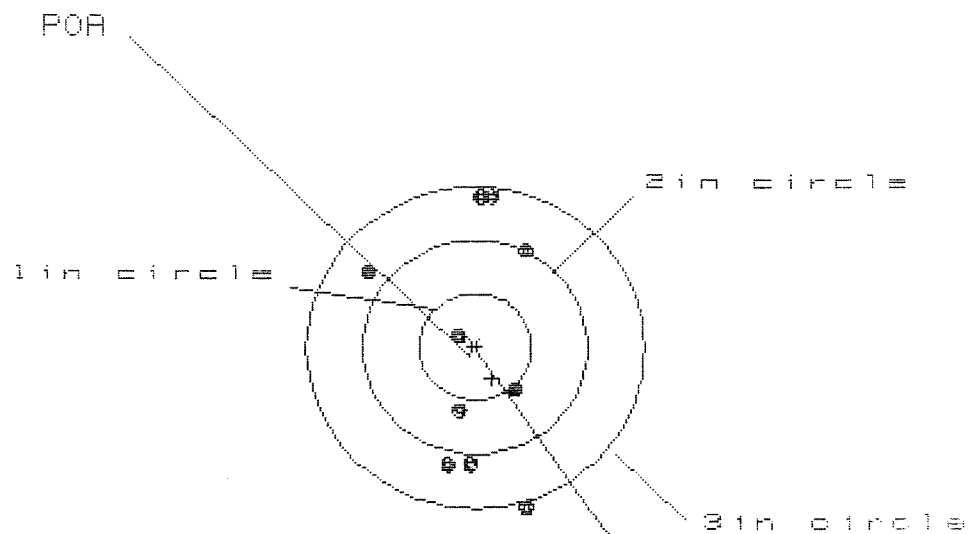
GS= 3.073

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.406	1.060	.884
MINIMUM X	:	-1.561	-1.405	-1.161
MAXIMUM Y	:	.854	.627	.646
MINIMUM Y	:	-.762	-.667	-.648
CENTROID X	:	.359	.203	.379
CENTROID Y	:	.410	.315	.296
POA TO CENTROID in.	:	.545	.374	.480
MIN RADIUS	:	.273	.101	.231
MEAN RADIUS	:	.926	.832	.742
MAX RADIUS	:	1.645	1.413	1.209
HORIZONTAL SPREAD	:	2.967	2.465	2.045
VERTICAL SPREAD	:	1.616	1.294	1.294
EXTREME SPREAD	:	3.073	2.504	2.253
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

21 May 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6349085

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 3

3 in = 6

HS= 1.332

VS= 2.928

GS= 2.945

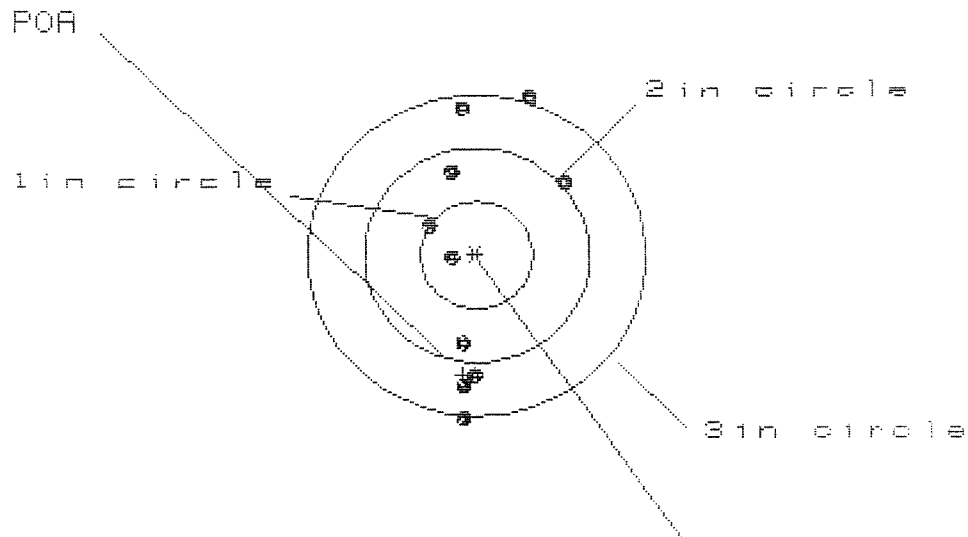
CENTROID *

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.431	.458	.478
MINIMUM X	:	-.901	-.853	-.833
MAXIMUM Y	:	1.442	1.276	1.425
MINIMUM Y	:	-1.486	-1.250	-1.090
CENTROID X	:	-.150	-.198	-.218
CENTROID Y	:	.292	.458	.298
POA TO CENTROID in.	:	.329	.499	.369
MIN RADIUS	:	.179	.093	.132
MEAN RADIUS	:	1.012	.948	.886
MAX RADIUS	:	1.548	1.287	1.433
HORIZONTAL SPREAD	:	1.332	1.311	1.311
VERTICAL SPREAD	:	2.928	2.526	2.515
EXTREME SPREAD	:	2.945	2.529	2.517
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	3		
NUMBER IN THREE INCH CIRCLE	=	6		

21 May 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6349005

CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 4

3 in = 9

HS= 1.216

VS= 2.953

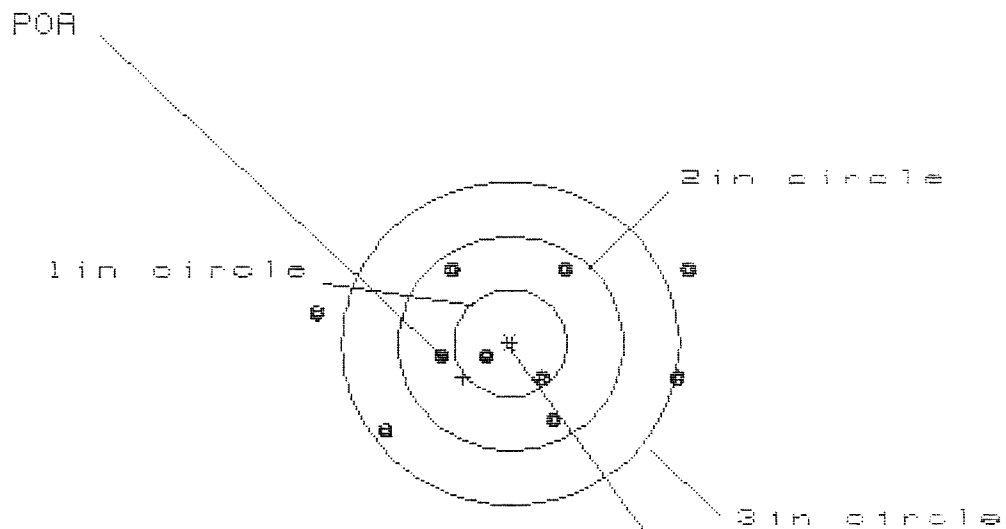
GS= 3.011

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.818	.872	.866
MINIMUM X	:	-.398	-.344	-.350
MAXIMUM Y	:	1.465	1.518	1.353
MINIMUM Y	:	-1.488	-1.325	-1.213
CENTROID X	:	.123	.069	.075
CENTROID Y	:	1.121	.958	1.123
POA TO CENTROID in.	:	1.127	.960	1.126
MIN RADIUS	:	.195	.233	.147
MEAN RADIUS	:	1.013	.944	.878
MAX RADIUS	:	1.543	1.522	1.357
HORIZONTAL SPREAD	:	1.216	1.216	1.216
VERTICAL SPREAD	:	2.953	2.843	2.566
EXTREME SPREAD	:	3.011	2.843	2.566
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		9	

21 May 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6349005

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 6

3 in = 7

HS= 3.264

VS= 1.474

GS= 3.294

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.550	1.359	1.452
MINIMUM X	-1.715	-1.277	-1.107
MAXIMUM Y	.698	.725	.814
MINIMUM Y	-.776	-.749	-.660
CENTROID X	.418	.609	.439
CENTROID Y	.312	.285	.196
POA TO CENTROID in.	.522	.673	.481
MIN RADIUS	.229	.245	.242
MEAN RADIUS	1.010	.931	.824
MAX RADIUS	1.732	1.536	1.472
HORIZONTAL SPREAD	3.264	2.636	2.559
VERTICAL SPREAD	1.474	1.474	1.474
EXTREME SPREAD	3.294	3.016	2.593
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	7		