

C6349024

MODEL 700TM M24

Model **S&S** TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

Repair Inquiry

Repair Number: RE00128532

Serial: C6349024 Model M24 SWS Center Fire
Caliber: 7.62 NATO

Repairman:

Status:

New 4/24/2007 7:39:45 AM

Verify Repair

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
A017	Scope Base	1
A026	Scope	1
A045	Bi Pod	1
A057	Frt and Rear Sgt Base	1

Repair Search

Refresh

Close

naglej

4/24/2007

8:10 AM

CAPS

NUM

INS

SCRL

Serial
Number:

C6349024

Model: M24 SWS



RE00128532

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6349024.___0
FILE DATE AND TIME: 06/04/2007 15:14

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.048
The Average Y Centroid of the Five Target Set:	-0.025
The Average Point of Impact of the Five Target Set:	0.054
The Average Mean Radius of the Five Target Set:	0.633
The Distance from POA to Centroid Target #1:	0.199
The Distance from Centroid Target #2 to Centroid Target #1:	0.257
The Distance from Centroid Target #3 to Centroid Target #1:	0.126
The Distance from Centroid Target #4 to Centroid Target #1:	0.273
The Distance from Centroid Target #5 to Centroid Target #1:	0.290

SERIAL NUMBER: C6349024. __0

TARGET NUMBER: 1

FILE DATE: 06/04/2007

FILE TIME: 15:14

POINT#	X	Y
1:	0.831	-0.689
2:	0.549	-0.871
3:	-0.245	-0.759
4:	0.322	0.564
5:	0.079	0.634
6:	-0.252	1.017
7:	-0.070	0.231
8:	-0.302	0.134
9:	-0.252	-0.132
10:	-2.295	1.007

X CENTROID: -0.163

Y CENTROID: 0.114

POA TO CENTROID: 0.199

HORZ SPREAD: 3.126

VERT SPREAD: 1.888

GROUP SPREAD: 3.556

MIN RADIUS: 0.140

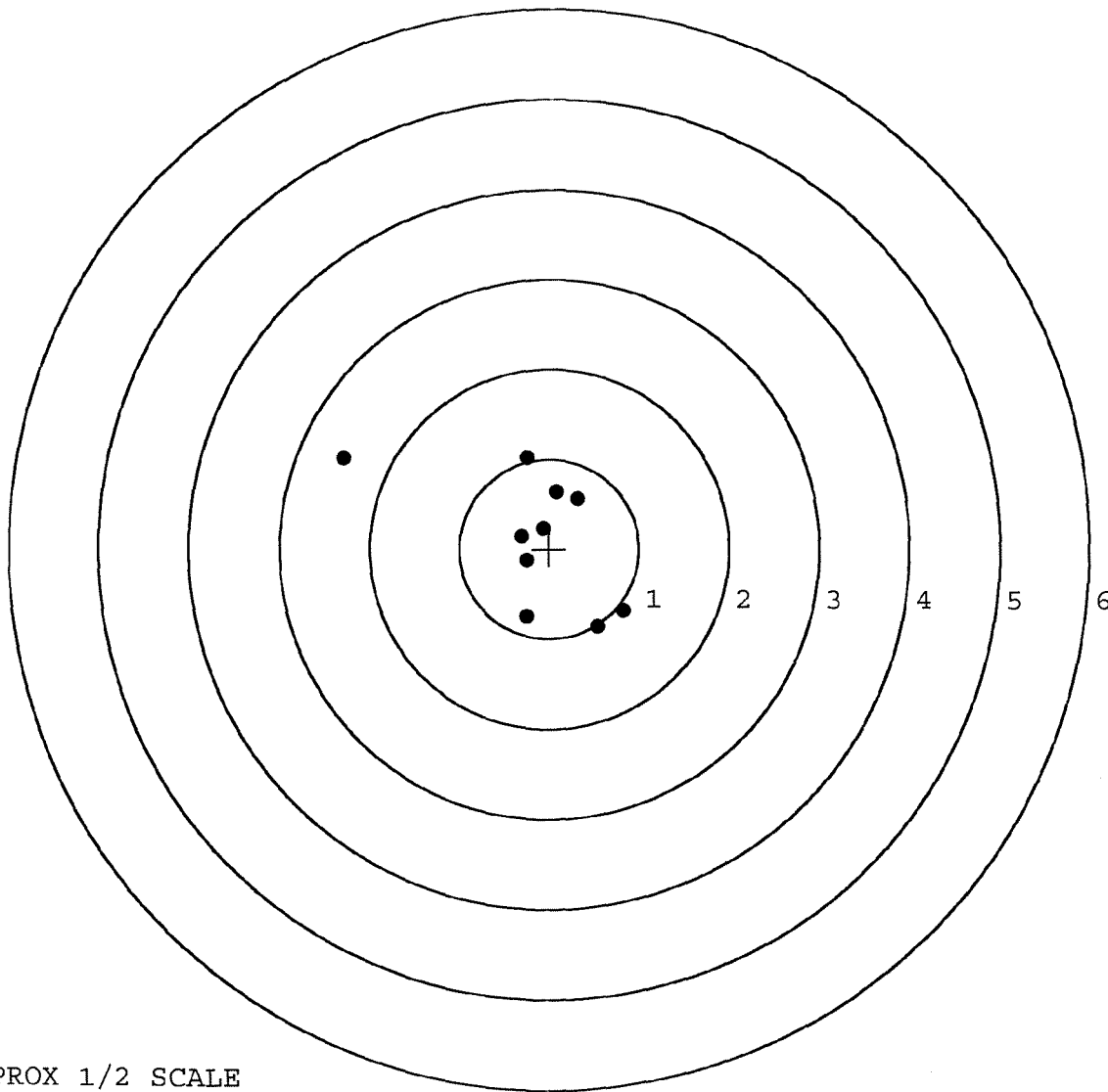
MAX RADIUS: 2.311

MEAN RADIUS: 0.838

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6349024. __0

TARGET NUMBER: 2

FILE DATE: 06/04/2007

FILE TIME: 15:14

POINT#	X	Y
1:	0.469	0.203
2:	0.184	0.171
3:	0.159	0.684
4:	0.164	-0.176
5:	-0.537	-0.370
6:	-0.150	-0.560
7:	-0.371	-0.319
8:	-0.290	-0.143
9:	-0.114	-0.280
10:	-0.231	-0.478

X CENTROID: -0.072

Y CENTROID: -0.127

POA TO CENTROID: 0.146

HORZ SPREAD: 1.006

VERT SPREAD: 1.244

GROUP SPREAD: 1.282

MIN RADIUS: 0.159

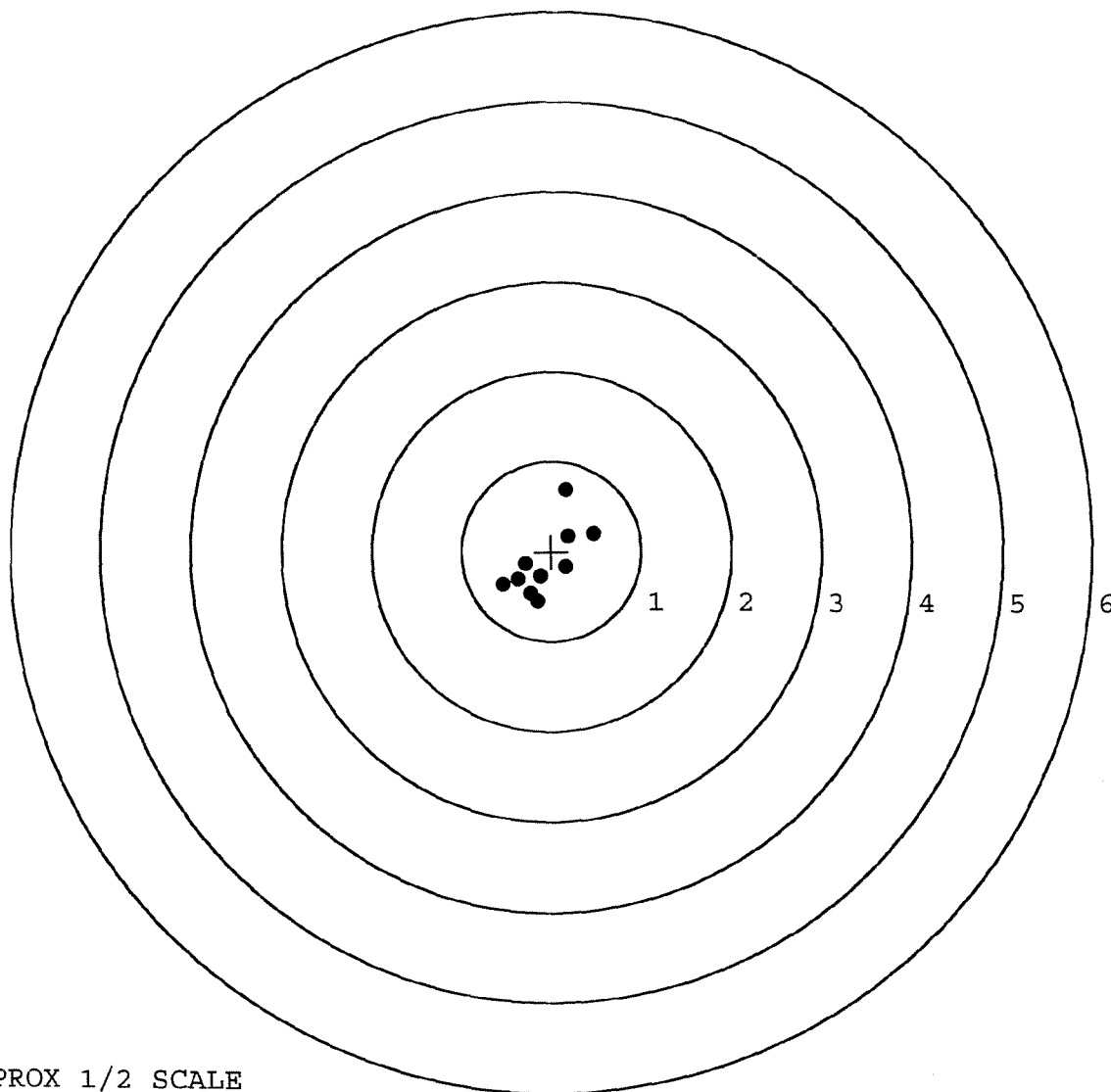
MAX RADIUS: 0.843

MEAN RADIUS: 0.419

IN 1 IN DIAMETER: 7

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6349024. __0

TARGET NUMBER: 3

FILE DATE: 06/04/2007

FILE TIME: 15:14

X CENTROID: -0.042

Y CENTROID: 0.080

POA TO CENTROID: 0.091

HORZ SPREAD: 1.549

VERT SPREAD: 1.880

GROUP SPREAD: 2.049

MIN RADIUS: 0.132

MAX RADIUS: 1.054

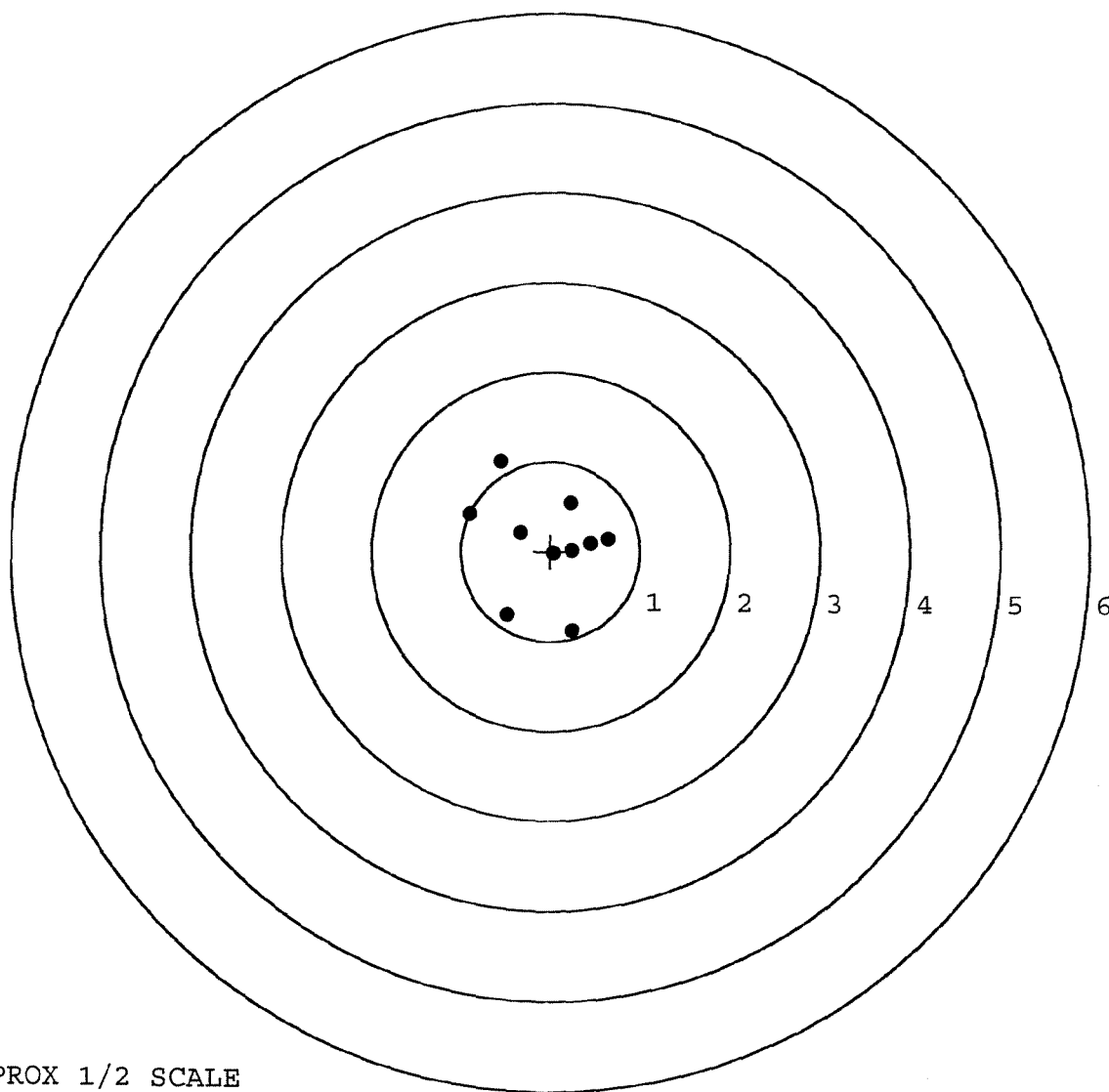
MEAN RADIUS: 0.634

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.255	-0.882
2:	-0.479	-0.702
3:	-0.561	0.998
4:	-0.903	0.418
5:	-0.335	0.207
6:	0.225	0.540
7:	0.646	0.141
8:	0.455	0.092
9:	0.242	0.018
10:	0.037	-0.026



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6349024. __0

TARGET NUMBER: 4

FILE DATE: 06/04/2007

FILE TIME: 15:14

POINT#	X	Y
1:	0.763	0.091
2:	0.499	0.339
3:	0.481	-0.638
4:	0.253	-0.392
5:	0.123	-0.219
6:	-0.333	-0.570
7:	-0.131	-0.158
8:	-0.379	-0.216
9:	-0.533	0.258
10:	-0.860	0.376

X CENTROID: -0.012

Y CENTROID: -0.113

POA TO CENTROID: 0.114

HORZ SPREAD: 1.623

VERT SPREAD: 1.014

GROUP SPREAD: 1.681

MIN RADIUS: 0.128

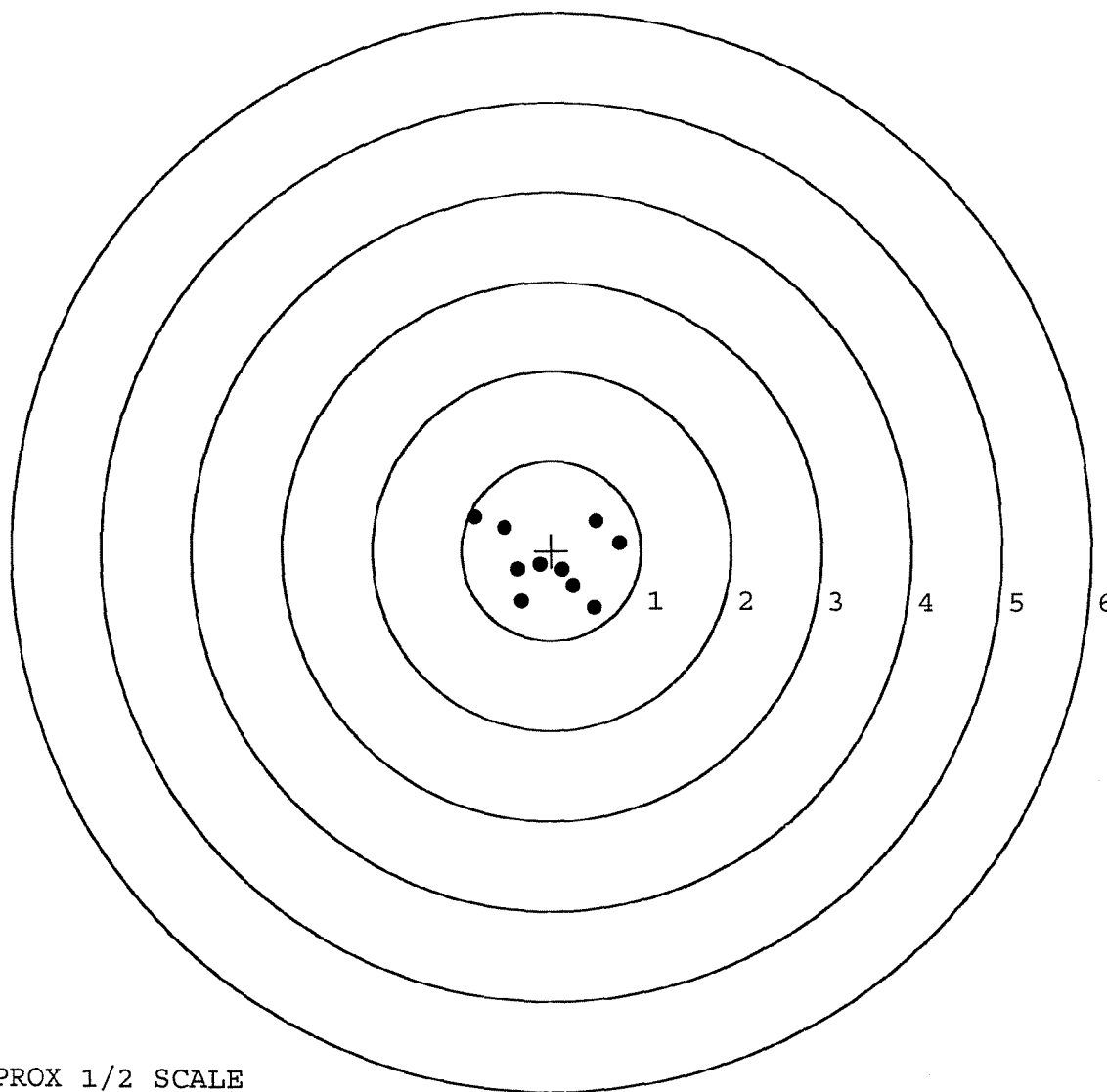
MAX RADIUS: 0.979

MEAN RADIUS: 0.545

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10

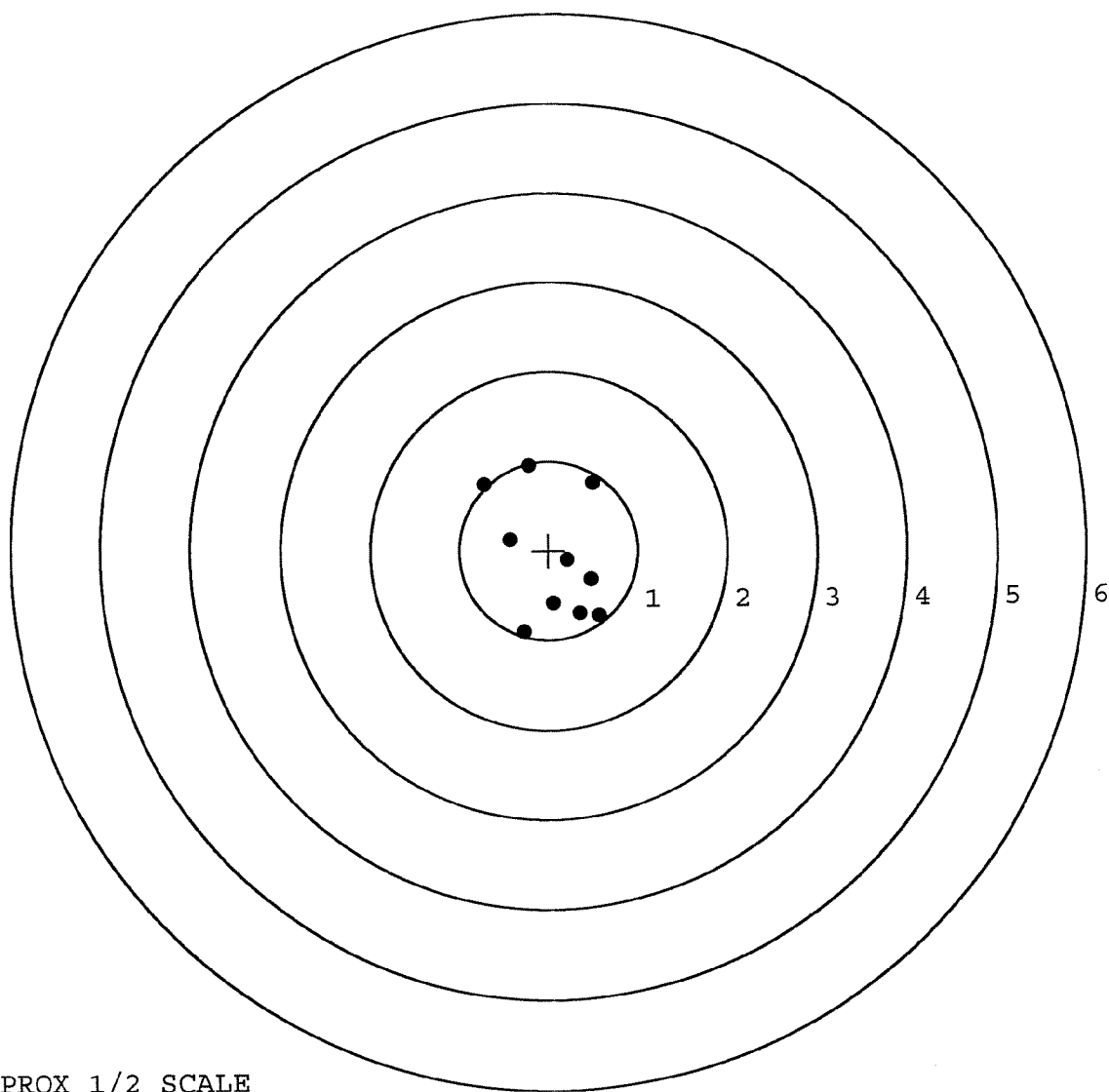


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6349024. __0
 TARGET NUMBER: 5
 FILE DATE: 06/04/2007
 FILE TIME: 15:14

POINT#	X	Y
1:	0.506	0.754
2:	-0.216	0.958
3:	-0.715	0.751
4:	-0.429	0.122
5:	0.211	-0.111
6:	0.474	-0.331
7:	0.560	-0.736
8:	0.048	-0.597
9:	-0.281	-0.914
10:	0.348	-0.711

X CENTROID: 0.051
 Y CENTROID: -0.082
 POA TO CENTROID: 0.096
 HORZ SPREAD: 1.275
 VERT SPREAD: 1.872
 GROUP SPREAD: 1.959
 MIN RADIUS: 0.163
 MAX RADIUS: 1.131
 MEAN RADIUS: 0.727
 # IN 1 IN DIAMETER: 2
 # IN 2 IN DIAMETER: 8
 # in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

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

R & E NUMBER		128532	
SERIAL NUMBER		C60349024	
LOG-IN DATE		4-24-07	
OPERATION #	OPERATION NAME	DATE	INITIAL
500	DIS-ASSEMBLE GUN	5-15-07	RTZ
505	RE-BARREL	5-18-07	RTZ
560	ASSEMBLE	5-18-07	RTZ
600	PROOF	5-18-07	TRW
605	CHECK HEADSPACE	5-18-07	TRW
610	DIS-ASSEMBLE GUN	5-21-07	RTZ
612	MAGNAFLUX	5/21/07	unnd
510	DRILL AND TAP	5-21-07	TRW
615	ROLLMARK CALIBER	5-21-07	CW
618	ROTO-BLAST	5-22-07	LB
620	APPLY COATINGS	5-24-07	WJ
625	FINAL ASSEMBLY	6-1-07	RTZ
640	FUNCTION TEST AND	(PASS) FAIL	6-4-07 TRW
650	TARGET	(PASS) FAIL	6-4-07 TRW
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
670	FINAL INSPECTION	6-4-07	Fm
	A) HEADSPACE	(PASS) FAIL	6-7-07 RTZ
	B) TRIGGER PULL	282 280 280 281 284 6-5-07	RTZ
680	F) SAFETY ON FORCE	4.0 3.5 3.5 6-5-07	RTZ
	G) SAFETY OFF FORCE	2.2 2.2 2.2 6-5-07	RTZ
	I) FIRING PIN INDENT	1021 1022 1022 6-5-07	RTZ
690	PACK	6-8-07	RTZ

Cco 91B

MAINTENANCE REQUEST				PAGE NO. 1	NO. OF PAGES 1	REQUIREMENTS CONTROL SYMBOL CSGLD - 1047(R1)			
SECTION I - EQUIPMENT DATA									
CONTROL NUMBER		WORK ORDER NO.		WESDC		ORG. PD		PD AUTHENTICATION X	
☐ Work Request ☐ MWO ☒ Warranty Claim		1A. ORGANIZATION Dco 3/5 SFG		B. LOCATION Ft. Campbell KY 42223			C. UNIT IDENT CODE WH0600		
2. SERIAL NO. C6349024		3. NOUN NOMENCLATURE 7.62 mm Sniper Weapons M24		4. LINE NO.		5. MODEL		6. NATIONAL STOCK NUMBER 1005-01-240-2136	
7A. MAINTENANCE ACTIVITY IMO		B. LEVEL Ø		8. UTILIZATION CODE Ø		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) 5,200 RNDs Fired									
B. REMARKS W 52H095345 H246									
PREPARATION INSTRUCTIONS (Prior to using this form, read DA PAM 738-750 for detailed preparation instructions)									
1. Place a "✓" or an "X" in the box for the type of action required. 2. Enter the WESDC if the item is Materiel Condition Status Reportable. 3. Enter the priority designator as determined from the urgency of need and force activity designator. 4. The Unit Commander, Chief of TDA activity or their designated representative will authenticate, by signature, a priority of 01 through 08. 5. Block 1A. Enter the name of the organization submitting the request. 6. Block 1B. Enter the unit submitting the request; units overseas enter APO only. 7. Block 1C. Enter the unit identification code of the unit in block 1A. 8. Block 2. Enter the equipment serial number. For ammunition, enter the lot number. For administrative-use vehicles, enter the USA registration number. 9. Block 3. Enter the noun abbreviation of the item. 10. Block 4. Enter the item line number, if applicable. 11. Block 5. Enter the model number. 12. Block 6. Enter the National Stock Number of the item listed in Block 3.					13. Block 7. Enter the name of the support activity. 14. Block 7A. Enter the symbol of the maintenance category (O, F, H, D, or L). 15. Block 8. Enter the utilization code. 16. Block 9A. Enter the word "yes" if the item is Materiel Condition Status Reportable. 17. Block 9B. Enter the equipment readiness code, if applicable. 18. Block 9C. Enter the word "yes" if the item is a pacing item. 19. Block 10. Enter the hour reading, if applicable. 20. Block 11. Enter the mileage from the odometer, if applicable. 21. Block 12. Enter the total rounds fired, if applicable. 22. Block 13. For turbine engines, enter the number of hot starts. 23. Block 14. Enter a "✓" or "X" in the proper block. 24. Block 15. Enter a "✓" or "X" in the proper block. 25. Block 16. Describe briefly the fault or symptoms needing correction.				
23. SUBMITTED BY Tony W. W. [Signature]		24. RECEIVED BY							
JULIAN DATE		JULIAN DATE							

NMP COPY 2

BARBER M24-9195993 RECEIVING AND ESTIMATING REPORT

COMMENTS

ORDER
R 95-30891

INITIAL
JJM

CUSTOMER ORDER NO.

W/LEUPOLD 10X SCOPE (SCOPE #89-0934)
NIGHT VISION BASE

DATE RECEIVED
12/01/95

DATE OPENED
12/05/95

DATE CODE

SERIAL NUMBER
C6349024

NEW SERIAL NUMBER

MODEL AND GRADE
700 7.62

NATO

ACCESSORIES

HARD CASE

SCOPE MNTS

SCOPE BASE

FROM:

TRANSPORTATION OFFICE
FT CAMPBELL

KY 42223

SHIP TO:

TRANSPORTATION OFFICE
FT CAMPBELL

KY
42223

CUST NO: 087942 C.O.D.L.

ACCOUNT NUMBER

ACCOUNT NUMBER N/C

WRITE ☐

PROM. DATE

ESTIMATED

VIA

UPS

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

BOLT ASSY.

B3

BARREL ASSY.

B4

D1

E3

F3

REC. ASSY.

B5

D2

E4

F4

WOOD

C1

D3

E5

F5

METAL

C2

MAIN FAULT

PARTS

COMMENTS

Barrel - 96003

Repowder Coat Trigger Guard
Assy. Front A Root Sight Bases
Reeding Scope Base, Rings &
Swivel Studs

Scope sent back to Vendor
to be checked

REPAIRMAN

PROOF

CLEAN

TEST

TARGET

PATTERN

GALLERY TESTER

DATE

DATE

DATE

DATE

DATE

OFFICE COPY

RD6925 REV. 1/84

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

BARBER - M24 M2499306032

New Barrel

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6349024

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. #	OP BARBER- M24 0105995	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		1/10/96	RW
	C) Function		1/10/96	RW
660	Pack			

Final Inspection

Sn: C6349024

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:

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

MODEL 700™ M24

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

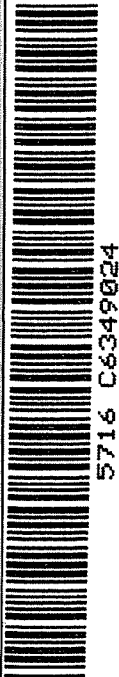
DUPONT

SERIAL NO.
C6349024

ORDER NO.
5716

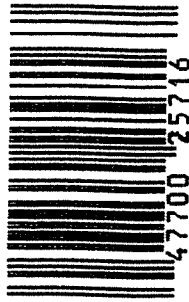
01

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



5716 C6349024

UPC



0 47700 25716 7

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C8349024
7 Jan 1980

CENTROIDAL DISTANCES

0 TO	1	1.04946
1 TO	2	.39308
1 TO	3	.384178
1 TO	4	.3178
1 TO	5	.205828

342

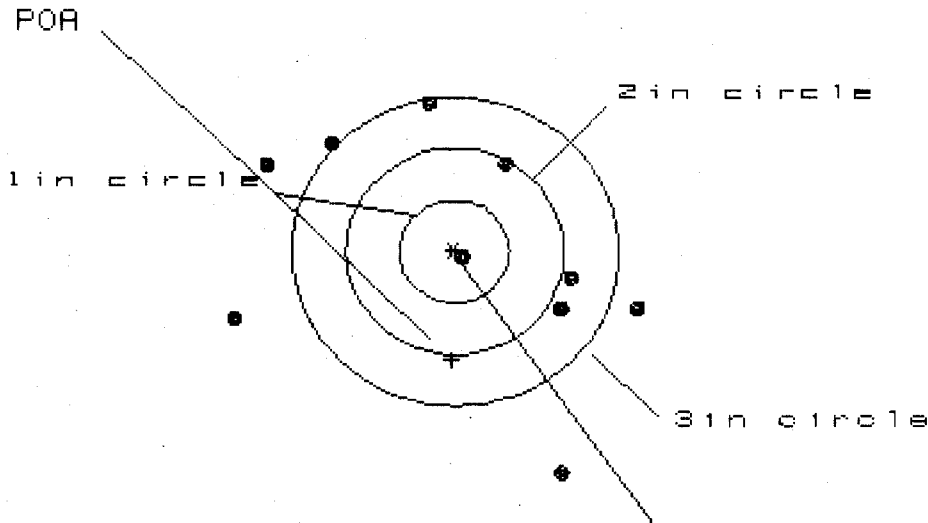
+ (----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0306
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: 1.2348
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: 1.23518
THE AMR FOR THIS RIFLE IS: .9848

7 Jan 1900

FILE:/PATTERNING/CENTERFIRE_PATT/C6349024

CENTERFIRE PAT ERNS # 1



OF SHOTS- 10

IN CIR

1in - 1

2in - 2

3in = 5

HS= 3.690

VS= 3.664

GS= 4.084

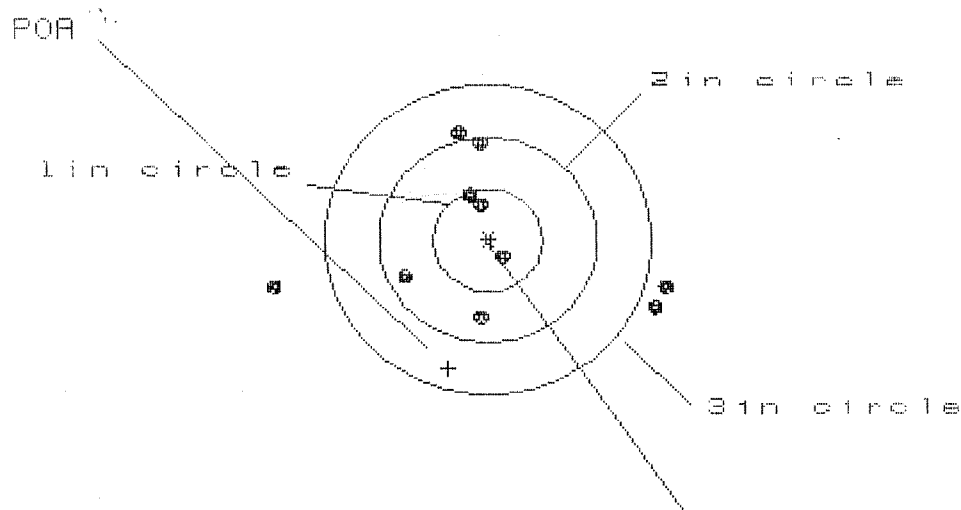
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.652	1.758	1.517
MINIMUM X	-2.038	-1.932	-1.856
MAXIMUM Y	1.473	1.229	1.124
MINIMUM Y	-2.191	-.845	-.892
CENTROID X	.031	-.075	.166
CENTROID Y	1.049	1.293	1.398
POA TO CENTROID in.	1.050	1.295	1.408
MIN RADIUS	.100	.364	.460
MEAN RADIUS	1.446	1.341	1.209
MAX RADIUS	2.391	2.108	1.934
HORIZONTAL SPREAD	3.690	3.690	3.373
VERTICAL SPREAD	3.664	2.074	2.016
EXTREME SPREAD	4.084	3.691	3.663
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	2		
NUMBER IN THREE INCH CIRCLE =	5		

7 Jan 1988

FILE:/PATTERNING/CENTER E_PATT/C6349824

CENTERFIRE PATTERNS # 2



OF SHOTS - 10

IN CIR

1in = 3

2in = 6

3in = 7

HS = 3.636

VS = 1.775

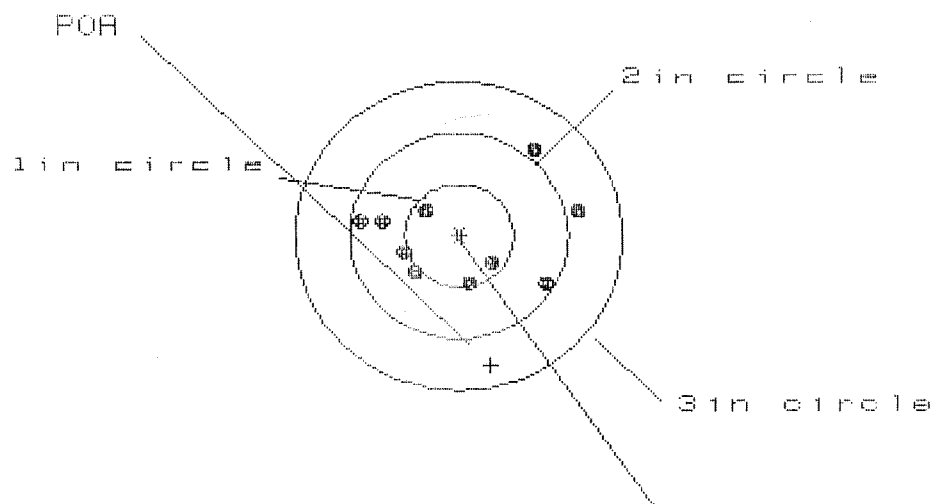
GS = 3.636

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.646	1.425	1.496
MINIMUM X	:	-1.990	-.960	-.782
MAXIMUM Y	:	1.048	1.002	.944
MINIMUM Y	:	-.727	-.773	-.831
CENTROID X	:	.367	.588	.410
CENTROID Y	:	1.253	1.299	1.357
POA TO CENTROID in.	:	1.305	1.426	1.418
MIN RADIUS	:	.216	.197	.215
MEAN RADIUS	:	.996	.890	.766
MAX RADIUS	:	2.033	1.500	1.675
HORIZONTAL SPREAD	:	3.636	2.385	2.278
VERTICAL SPREAD	:	1.775	1.775	1.775
EXTREME SPREAD	:	3.636	2.514	2.514
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		7	

7 Jan 1900

FILE:/PATTERNING/CENTERFIRE_PATT/C6349024

CENTERFIRE PATTERNS # 3



OF SHOTS - 10

IN CIR

1 in = 4

2 in = 8

3 in = 10

HS= 2.034

VS= 1.249

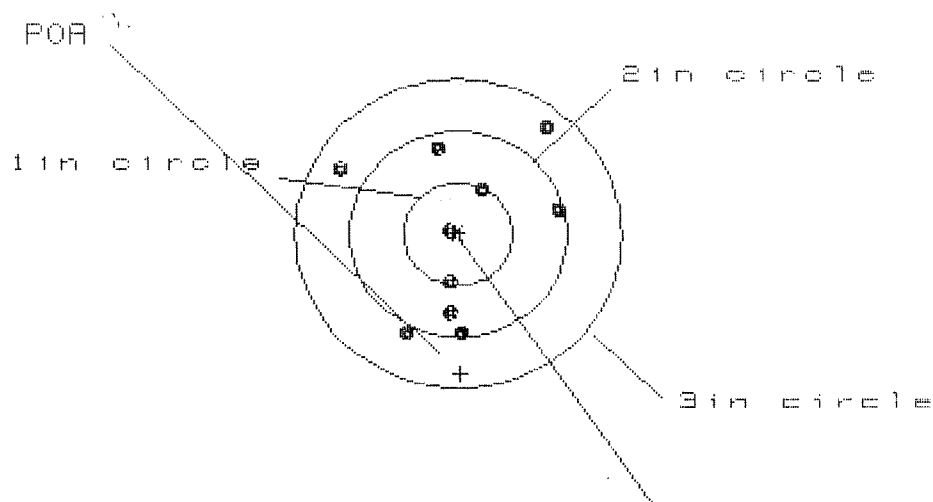
CS= 2.041

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.101	.868	.967
MINIMUM X	:	-.933	-.810	-.711
MAXIMUM Y	:	.831	.859	.410
MINIMUM Y	:	-.418	-.390	-.282
CENTROID X	:	-.292	-.415	-.514
CENTROID Y	:	1.257	1.229	1.121
POA TO CENTROID in.	:	1.291	1.297	1.234
MIN RADIUS	:	.354	.372	.241
MEAN RADIUS	:	.694	.619	.517
MAX RADIUS	:	1.131	1.173	1.008
HORIZONTAL SPREAD	:	2.034	1.678	1.678
VERTICAL SPREAD	:	1.249	1.249	.692
EXTREME SPREAD	:	2.041	1.770	1.754
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		8	

7 Jan 1988

FILE:/PATTERNING/CENTER/ PATT/C6349024

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

CENTROID *

IN CIR

1in = 3

2in = 7

3in = 10

HS= 2.015

VS= 2.055

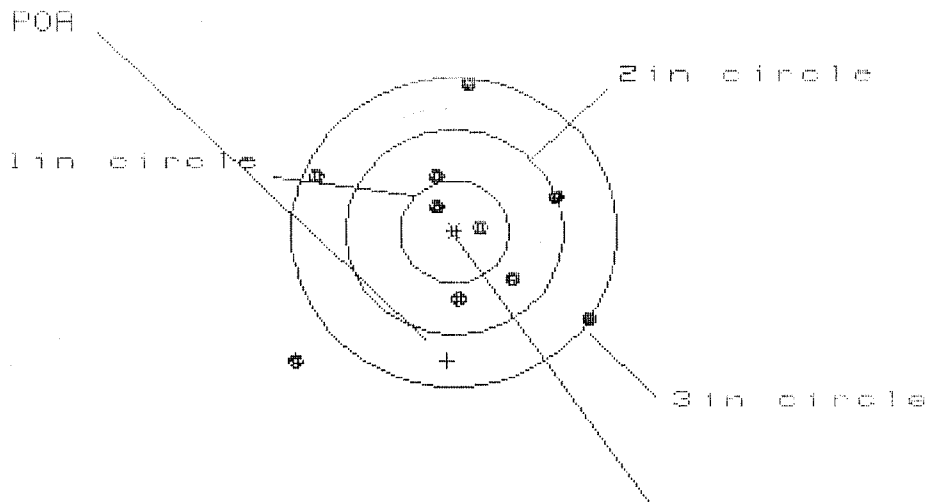
GS= 2.441

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.913	1.010	.884
MINIMUM X	:	-1.102	-1.005	-.480
MAXIMUM Y	:	1.067	.996	1.088
MINIMUM Y	:	-.988	-.870	-.778
CENTROID X	:	-.018	-.115	.011
CENTROID Y	:	1.363	1.245	1.153
POA TO CENTROID in.	:	1.363	1.250	1.153
MIN RADIUS	:	.076	.125	.239
MEAN RADIUS	:	.832	.761	.689
MAX RADIUS	:	1.375	1.245	1.113
HORIZONTAL SPREAD	:	2.015	2.015	1.364
VERTICAL SPREAD	:	2.055	1.866	1.866
EXTREME SPREAD	:	2.441	2.049	1.882
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

7 Jan 1968

FILE:/PATTERNING/CENTERFIRE_PATT/06349024

CENTERFIRE PATTERNS # 5



OF SHOTS = 10

IN CIR

1 in = 2

2 in = 5

3 in = 9

HS = 2.624

VS = 2.624

GS = 3.040

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.208	1.051	.932
MINIMUM X	:	-1.416	-1.421	-1.290
MAXIMUM Y	:	1.408	1.273	1.154
MINIMUM Y	:	-1.216	-.951	-.877
CENTROID X	:	.065	.222	.091
CENTROID Y	:	1.252	1.387	1.506
POA TO CENTROID in.	:	1.253	1.404	1.508
MIN RADIUS	:	.291	.141	.212
MEAN RADIUS	:	.956	.827	.748
MAX RADIUS	:	1.866	1.468	1.314
HORIZONTAL SPREAD	:	2.624	2.472	2.222
VERTICAL SPREAD	:	2.624	2.224	2.031
EXTREME SPREAD	:	3.040	2.802	2.231
NUMBER IN ONE INCH CIRCLE =			2	
NUMBER IN TWO INCH CIRCLE =			5	
NUMBER IN THREE INCH CIRCLE =			9	

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6349024

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		4-12-90	RW
600	Proof		4-12-90	RW
607	Check Headspace		4-12-90	RW
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		BS
617	Drill and Tap Sight Holes		4/23/90	KCB
618	Polish Barrel RWB		4/24/90	WB
620	Apply Coatings (Barrel Action)		4/30/90	TH
	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		5/7/90	RW

BARBER - M24 0106005		READINGS					DATE	INIT
op. #	OP. NAME							
625 cont.	F) Safety On Force	4	4	4			5/8/90	SM
	G) Safety Off Force	3	3	3			5/8/90	SM
	H) Trigger Pull Test & Retainability						5/7/90	90U
	I) Firing Pin Indent	.020	.020	.020			5/8/90	JP
	J) Assemble Stock						5/15/90	RW
	K) Assemble Swivel Studs						5/15/90	WB
	L) Attach Front and Rear Sight Assemblies						5/15/90	RW
	M) Iron Sight Alignment						5/15/90	RW
	N) Detach Front & Rear Sights & place in numbered container						5/15/90	RW
	O) Attach Scope to Rifle						5-15-90	AC
	P) Detach & Attach Scope 20 Times						5-15-90	AC
640	Gallery Target & Test						5-15-90	DH
	A) Time						5-15-90	DH
	B) Malfunctions						5-15-90	DH
	C) Pierced Primers						5-15-90	DH
	D) Optical Clarity of Scope						5-15-90	DH
645	Inspect for Live Ammo						5-15-90	DH
655	Final Inspection						5/17/90	WB
	A) Headspace							
	B) Trigger Pull	2.34	2.31	2.48	2.50	2.37	5/17/90	WB
	C) Function						5/17/90	WB
660	Pack						6/2/90	DH

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. 66349024DATE 5/7/90TESTER JR

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.55	2.83	2.25	2.34	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.30	2.34	2.30	2.31	
PULL #3	2.54	2.43	2.20	2.48	
PULL #4	2.37	2.25	2.40	2.50	
PULL #5	2.31	2.18	2.41	2.37	
TOTAL	12.07	11.43	11.56		
AVG.	2.414	2.286	2.312		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.50	3.31		
PULL #2	3.38	3.26		
PULL #3	3.35	3.35		
PULL #4	3.38	3.34		
PULL #5	3.33	3.36		
TOTAL	16.94	16.62		
AVG.	3.388	3.324		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.32	4.29		4.27
PULL #2	4.37	4.33		4.37
PULL #3	4.39	4.30		4.37
PULL #4	4.39	4.37		4.40
PULL #5	4.25	4.21		4.41
TOTAL	21.72	21.50		21.82
AVG.	4.344	4.3		4.364

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 05349024
12 May 1990

CENTROIDAL DISTANCES

0 TO	1	.474976
1 TO	2	.355141
1 TO	3	.391063
1 TO	4	.478961
1 TO	5	.3786

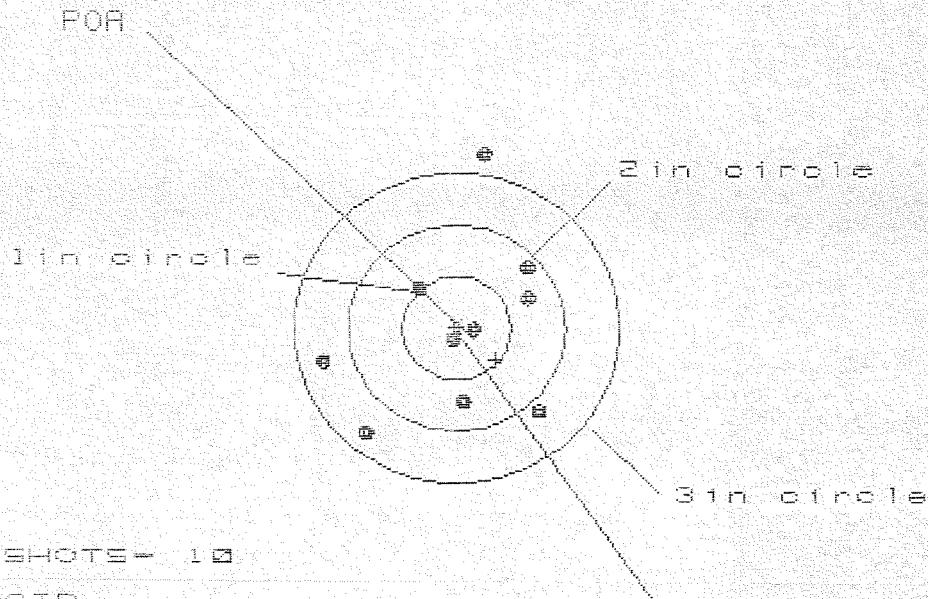
1
←----FOR

THE AVERAGE Y COORDINATE FOR THIS RIFLE IS: -.1493
THE AVERAGE X COORDINATE FOR THIS RIFLE IS: .3703
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .155339
THE AMP FOR THIS RIFLE IS: .8586

15 May 1998

FILE:/PATTERNING/CENTERFIRE_PATT/08349024

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1in = 3

2in = 6

3in = 9

HS = 1.993

VS = 2.668

GS = 2.854

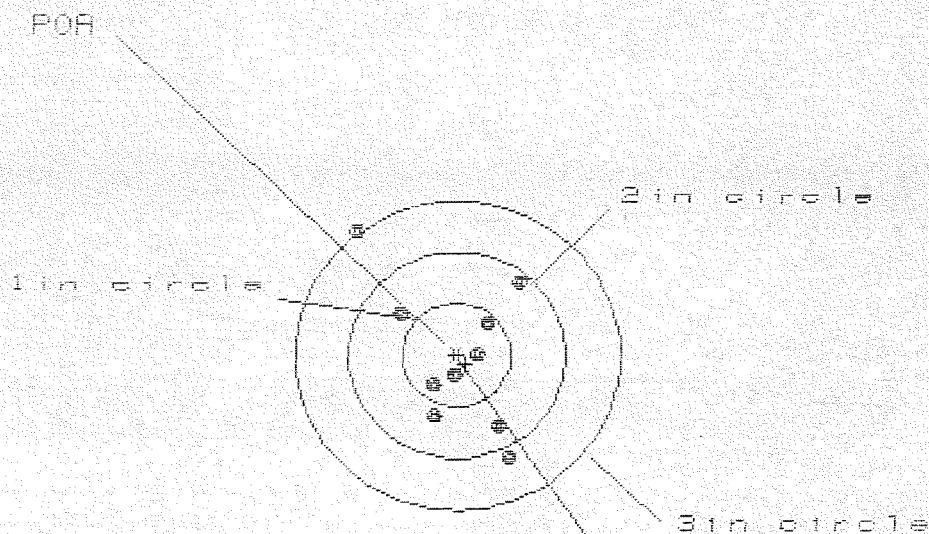
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.766	.790	.640
MINIMUM X	-1.227	-1.203	-.918
MAXIMUM Y	1.704	.728	.714
MINIMUM Y	-.964	-.775	-.789
CENTROID X	-.359	-.383	-.233
CENTROID Y	.311	.122	.136
POA TO CENTROID in.	.475	.402	.270
MIN RADIUS	.116	.089	.151
MEAN RADIUS	.830	.727	.658
MAX RADIUS	1.718	1.208	1.211
HORIZONTAL SPREAD	1.993	1.993	1.558
VERTICAL SPREAD	2.668	1.503	1.503
EXTREME SPREAD	2.854	2.085	2.085
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	9		

15 May 1998

FILE:/PATTERNING/CENTERFIRE_PATT/06349024

CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1 in = 4

2 in = 8

3 in = 8

HS = 1.495

VS = 2.172

GS = 2.571

CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.588	.479	.523
MINIMUM X	-.915	-.654	-.610
MAXIMUM Y	1.205	.821	.717
MINIMUM Y	-.967	-.833	-.622
CENTROID X	-.0881	.020	-.024
CENTROID Y	.090	-.044	.060
POA TO CENTROID in.	.121	.049	.065
MIN RADIUS	.152	.109	.109
MEAN RADIUS	.659	.545	.493
MAX RADIUS	1.513	.950	.888
HORIZONTAL SPREAD	1.495	1.133	1.133
VERTICAL SPREAD	2.172	1.654	1.339
EXTREME SPREAD	2.571	1.676	1.461
NUMBER IN ONE INCH CIRCLE =		4	
NUMBER IN TWO INCH CIRCLE =		8	
NUMBER IN THREE INCH CIRCLE =		9	

15 May 1990

FILE:/PATTERNING/CENTERFIRE_PATT/C8349024

CENTERFIRE PATTERNS # 3

POA

1 in circle

2 in circle

3 in circle

OF SHOTS = 10

IN CIR

1 in = 1

2 in = 3

3 in = 8

HS = 2.931

VS = 2.362

GS = 3.026

CENTROID #

PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	1.377
MINIMUM X	-1.554
MAXIMUM Y	1.461
MINIMUM Y	-0.901
CENTROID X	-0.100
CENTROID Y	0.018
POA TO CENTROID in	0.102
MIN RADIUS	0.451
MEAN RADIUS	1.098
MAX RADIUS	1.606
HORIZONTAL SPREAD	2.931
VERTICAL SPREAD	2.362
EXTREME SPREAD	3.026
NUMBER IN ONE INCH CIRCLE =	1
NUMBER IN TWO INCH CIRCLE =	3
NUMBER IN THREE INCH CIRCLE =	8

15 May 1990

FILE:/PATTERNING/CENTERFIRE_PATT/06349024

CENTERFIRE PATTERNS

4

POA

1 in circle

2 in circle

3 in circle

OF SHOTS = 10

IN CIR

1 in = 1

2 in = 5

3 in = 9

HS = 2.368

VS = 2.507

CS = 2.824

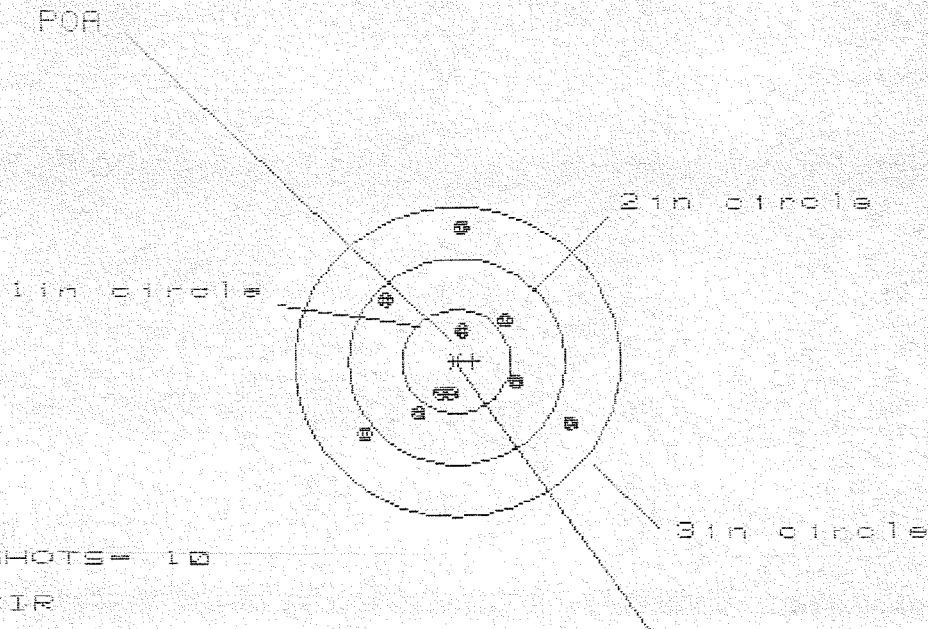
CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.313	1.195	1.211
MINIMUM X	:	-1.056	-1.096	-1.080
MAXIMUM Y	:	1.426	1.306	.779
MINIMUM Y	:	-1.081	-1.046	-.082
CENTROID X	:	-.063	.054	.038
CENTROID Y	:	-.063	.057	-.107
POA TO CENTROID in.	:	.090	.078	.113
MIN RADIUS	:	.177	.274	.287
MEAN RADIUS	:	.983	.934	.868
MAX RADIUS	:	1.510	1.313	1.268
HORIZONTAL SPREAD	:	2.368	2.291	2.291
VERTICAL SPREAD	:	2.507	2.352	1.661
EXTREME SPREAD	:	2.824	2.411	2.294
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

15 May 1998

FILE:/PATTERNING/CENTERFIRE_PATT/06349024

CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1 in = 3

2 in = 7

3 in = 10

HS= 1.863

VS= 2.021

CS= 2.218

PATTERN #

5

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.004	1.010	.668
MINIMUM X	-.859	-.853	-.727
MAXIMUM Y	1.306	.708	.656
MINIMUM Y	-.714	-.569	-.621
CENTROID X	-.146	-.152	-.278
CENTROID Y	-.002	-.147	-.095
POA TO CENTROID in.	.146	.211	.294
MIN RADIUS	.269	.129	.100
MEAN RADIUS	.723	.634	.576
MAX RADIUS	1.308	1.090	.956
HORIZONTAL SPREAD	1.863	1.863	1.395
VERTICAL SPREAD	2.021	1.277	1.277
EXTREME SPREAD	2.218	2.002	1.712
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		10	