

C6349105

MODEL 700™ M24

Model **SMS**™

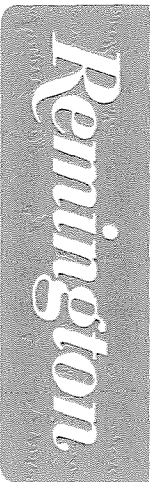
Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



C-6349106

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: **RE00007795** Serial: C6349106 Model 700 Center Fire Caliber 7.62 NATO M-24 (SW/S) Repairman: Status: Closed 4/10/00 8:28 AM

Vault Repair

Address Information

Customer: ☒ Received From Return To: ☐ Received From

Name: **TRANSPORTATION OFFICER** **TRANSPORTATION OFFICER**

Address 1: **ATTN:AFZB-DL-TO, BLDG. 873** **ATTN:AFZB-DL-TO, BLDG. 873**

Address 2: PO Box: PO Box:

City: **FORT CAMPBELL** **FORT CAMPBELL**

State: **KY** Zip Code: **422231294** Country: **US** State: **KY** Zip Code: **422231294** Country: **US**

FFL: ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐

Contact / Condition **Problems** **Estimate** **History / Status** **Shipping / Billing**

Contact Information

Phone: **502 738 7154**

Fax:

Email:

Comments:

Received Condition

Fail:

Condition Notes:

CSR Notes:

Accessories Received

Code	Desc	Qty
A010	Hard Case	1
A017	Scope Base	1
ZXX	SWIVEL STUDS	2

Repair Search **Refresh** **Close**

Start | 4/10/00 | 9:54 AM | CAPS | NUM | INS | SCPL | 9:54 AM

BBL - 96003
 Stock - 96018
 Extractor - 91816

BARBER - M24 0107894

Remington Test Lab, Ilion, N.Y.

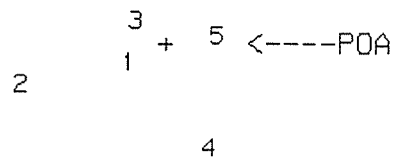
Centroidal distance calculations for Rifle # c6349106
12 Jun 2000

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1532
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.17
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .228845

THE AMR FOR THIS RIFLE IS: 1.216

CENTROIDAL DISTANCES

Ø TO	1	.271978
1 TO	2	.705239
1 TO	3	.272624
1 TO	4	.772414
1 TO	5	.595733



BARBER - M24 0107895

REMINGTON CENTERFIRE ACCURACY TEST

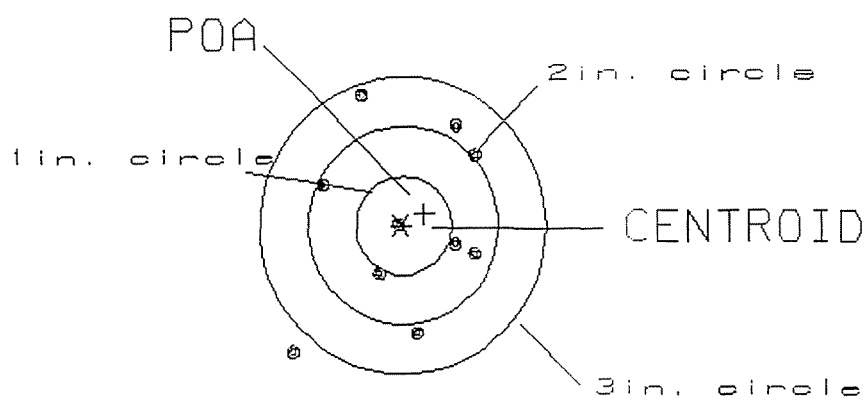
REMINGTON TEST LAB, ILION, N.Y.

PATTERN #: ☐ 1 ☐
POA TO CENTROID: .272
MIN RADIUS : .036
MEAN RADIUS : .911
MAX RADIUS : 1.732
CENTROID X : -.246
CENTROID Y : -.116

12 Jun 2000

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6349106.1

CENTERFIRE PATTERN # 1



OF SHOTS= 10

IN CIRCLE

HS= 1.87

1

VS= 2.59

5

GS= 2.84

9

BARBER - M24 0107896

REMINGTON CENTERFIRE ACCURACY TEST

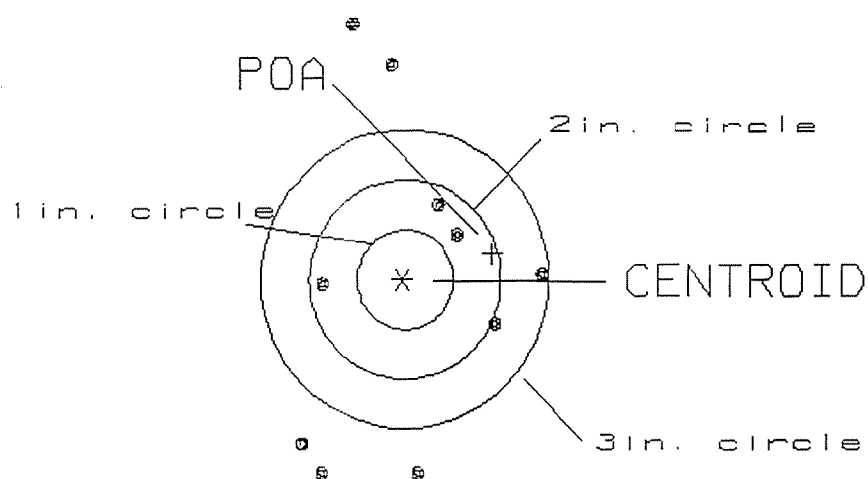
REMINGTON TEST LAB, ILION, N.Y.

PATTERN #: ☐ 2 ☐
POA TO CENTROID: .972
MIN RADIUS : .711
MEAN RADIUS : 1.575
MAX RADIUS : 2.653
CENTROID X : -.937
CENTROID Y : -.257

12 Jun 2000

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6349106.1

CENTERFIRE PATTERN # 2



OF SHOTS= 10

IN CIRCLE

HS= 2.48

0

VS= 4.58

3

GS= 4.63

5

BARBER - M24 0107897

REMINGTON CENTERFIRE ACCURACY TEST

REMINGTON TEST LAB, ILION, N.Y.

PATTERN #: ☐ 3 ☐

POA TO CENTROID: .248

MIN RADIUS : .106

MEAN RADIUS : .844

MAX RADIUS : 1.995

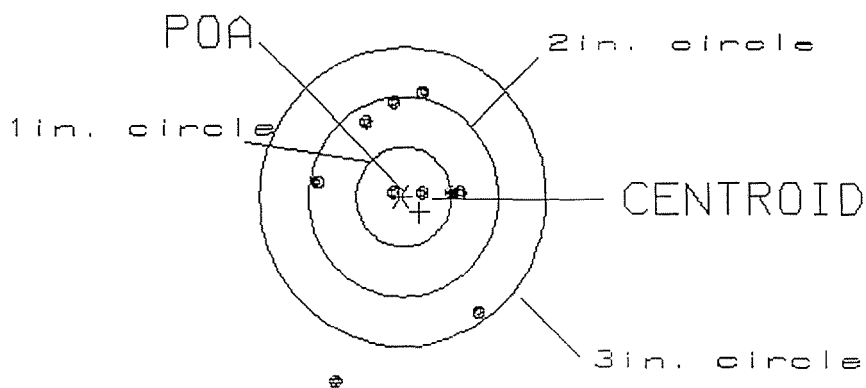
CENTROID X : -.196

CENTROID Y : .152

12 Jun 2000

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6349106.1

CENTERFIRE PATTERN # 3



OF SHOTS= 10

IN CIRCLE

HS= 1.65

3

VS= 2.91

7

GS= 3.03

9

BARBER - M24 0107898

REMINGTON CENTERFIRE ACCURACY TEST

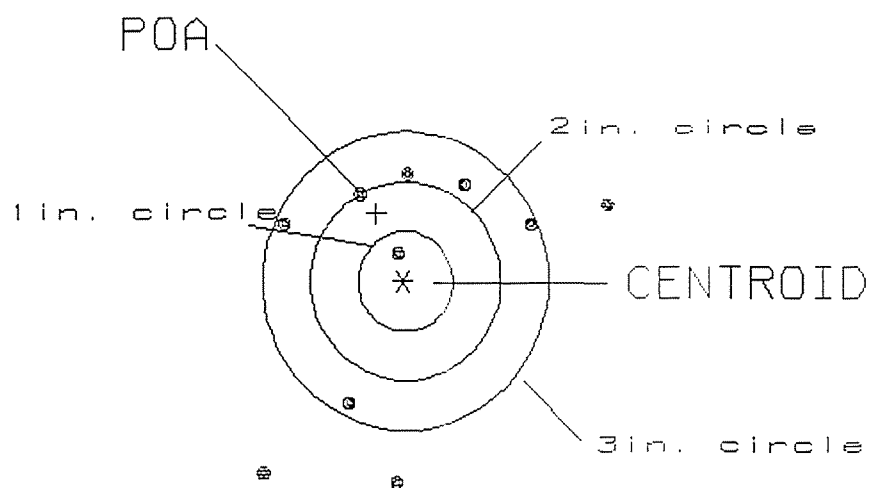
REMINGTON TEST LAB, ILION, N.Y.

PATTERN #: ☐ 4 ☐
POA TO CENTROID: .734
MIN RADIUS : .335
MEAN RADIUS : 1.454
MAX RADIUS : 2.465
CENTROID X : .286
CENTROID Y : -.676

12 Jun 2000

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6349106.1

CENTERFIRE PATTERN # 4



OF SHOTS= 10

IN CIRCLE

HS= 3.56
VS= 3.10
GS= 4.50

1
1
7

BARBER - M24 0107899

REMINGTON CENTERFIRE ACCURACY TEST

REMINGTON TEST LAB, ILION, N.Y.

PATTERN #: ☐ 5 ☐

POA TO CENTROID: .330

MIN RADIUS : .291

MEAN RADIUS : 1.300

MAX RADIUS : 2.739

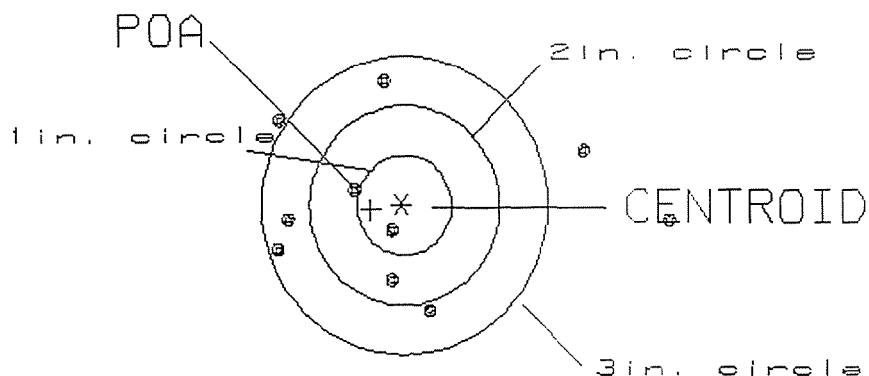
CENTROID X : .327

CENTROID Y : .047

12 Jun 2000

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6349106.1

CENTERFIRE PATTERN # 5



OF SHOTS= 10

IN CIRCLE

HS= 4.07

1

VS= 2.37

3

GS= 4.10

7

Final Inspection

Sn: C6349106

DATE REC'D: 3-31-00

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:

M-24 INSPECTION CHECKLIST
CONTRACT #: DAAE-20-97-C-242

R & E NUMBER 0000 7795			
SERIAL NUMBER C6349106			
LOG-IN DATE 3-31-00			
INSPECT AND VERIFY:			
OPERATION #	OPERATION NAME	DATE	INITIAL
550	DIS-ASSEMBLE GUN	4-6-00	RW
560 A	RE-BARREL AT CUSTOM SHOP		
B	DRILL AND TAP		
C	POLISH		
575	ASSEMBLE		
600	PROOF	4-24-00	RW
605	CHECK HEADSPACE	4-24-00	RW
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		
D	SAFETY "OFF" FORCE		
E	FIRING PIN INDENT		
640	TARGET	6-8-00	RW
655	FINAL INSPECT	6-12-00	RW
660	PACK		
		SHIP DATE	
		QAR INSPECTION DATE	

82A

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 Bco 315 SFG (A)		B. LOCATION Ft Campbell Ky 42223		C. UNIT IDENT CODE WH0680													
2. SERIAL NO. C6349106		3. NOUN NOMENCLATURE 7.62 Sniper 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) ☐ 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) 5000 Rnds Fired																			
B. REMARKS WS2H095345 H&45																			
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 J. [Signature] JULIAN/DATE										24. RECEIVED BY [Signature] JULIAN DATE									

NMP COPY 2

RECEIVING BARBER M24 10X 7942

COMMENTS

ORDER

R 95-30900

INITIAL CUSTOMER ORDER NO.

J.M.

W/LEUPOLD 10X SCOPE

Scope 89-0951

DATE RECEIVED	DATE OPENED	DATE CODE	SERIAL NUMBER	NEW SERIAL NUMBER	MODEL AND GRADE
12/04/95	12/05/95		C6349106		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

L 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			E1	F1
BOLT ASSY.		B3			E2	F2
BARREL ASSY.		B4		D1	E3	F3
REC. ASSY.		B5		D2	E4	F4
WOOD			C1	D3	E5	F5
METAL			C2			

MAIN FAULT

PARTS

COMMENTS

Barrel	-	96003	Repower Coat Trigger Guard Assy Front & Rear Sight Bases ReZind Scope Base, Rings & Swivel Studs
Stock	-	96018	
Mag Spring	-	15677	

Scope Sent back to Vendor
to be Checked

REPAIRMAN	PROOF	CLEAN	TEST	TARGET	PATTERN
-----------	-------	-------	------	--------	---------

GALLERY TESTER	DATE	DATE	DATE	DATE	DATE
----------------	------	------	------	------	------

Rw	12/21/95	1/5/96	1/8/96	1/8/96	
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OFFICE COPY

RD6925 REV. 1/94

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

BARBER - M24 087942 07943

Final Inspection

Sn: C6349/06 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: _____

New Stock
Barrel

GUN SERIAL # C6349106

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 0107907 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						1/5/96	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						1/8/96	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	2.28	2.67	2.67	2.66	2.60	1/10/96	RW
	C) Function						1/10/96	RW
660	Pack							

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6349186
7 Jan 1900

CENTROIDAL DISTANCES

0	TO	1	1.38906
1	TO	2	.601569
1	TO	3	1.24446
1	TO	4	.424019
1	TO	5	.308185

4
3

4

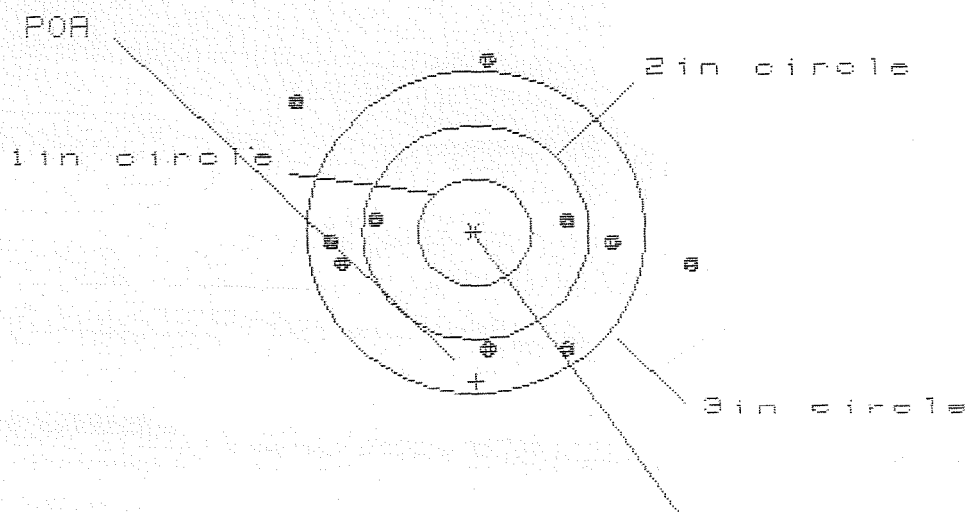
-----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0954
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .92162
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .926544
THE AMR FOR THIS RIFLE IS: 1.134

7 Jan 1988

FILE:/PATTERNING/CENTERFIRE_PATT/06349106

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

CENTROID *

IN CIR

1 in = 0

2 in = 2

3 in = 7

HS= 3.508

VS= 2.655

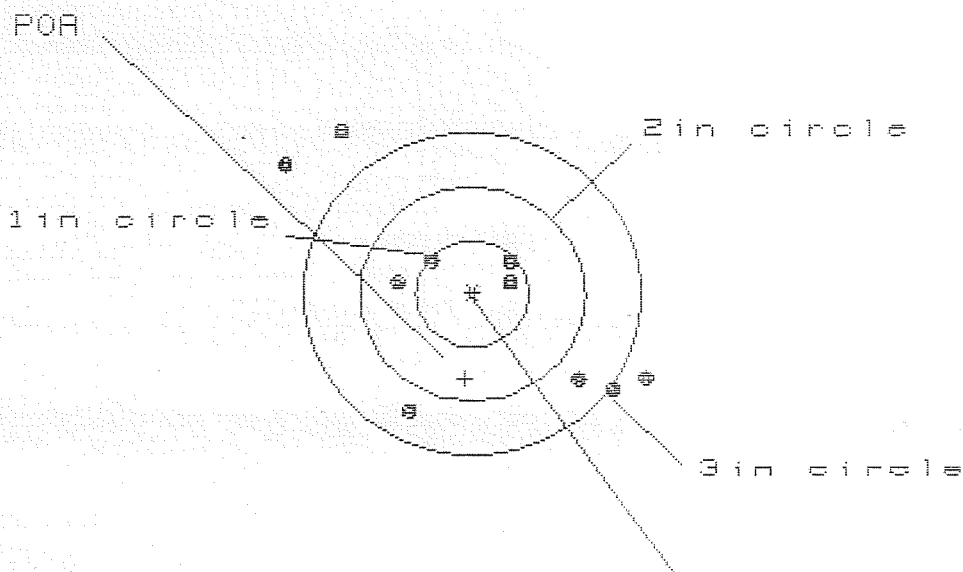
GS= 3.834

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.891	1.712	1.220
MINIMUM X	-1.617	-1.471	-1.257
MAXIMUM Y	1.577	1.712	1.688
MINIMUM Y	-1.078	-0.943	-0.967
CENTROID X	-0.013	.167	-0.047
CENTROID Y	1.389	1.254	1.278
POA TO CENTROID in.	1.389	1.265	1.279
MIN RADIUS	.835	.686	.880
MEAN RADIUS	1.335	1.234	1.165
MAX RADIUS	2.022	1.723	1.693
HORIZONTAL SPREAD	3.508	3.183	2.477
VERTICAL SPREAD	2.655	2.655	2.655
EXTREME SPREAD	3.834	3.191	2.758
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	2		
NUMBER IN THREE INCH CIRCLE =	7		

7 Jan 1900

FILE:/PATTERNING/CENTERFIRE_PATT/08349106

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 4

3 in = 7

HS= 3.184

VS= 2.541

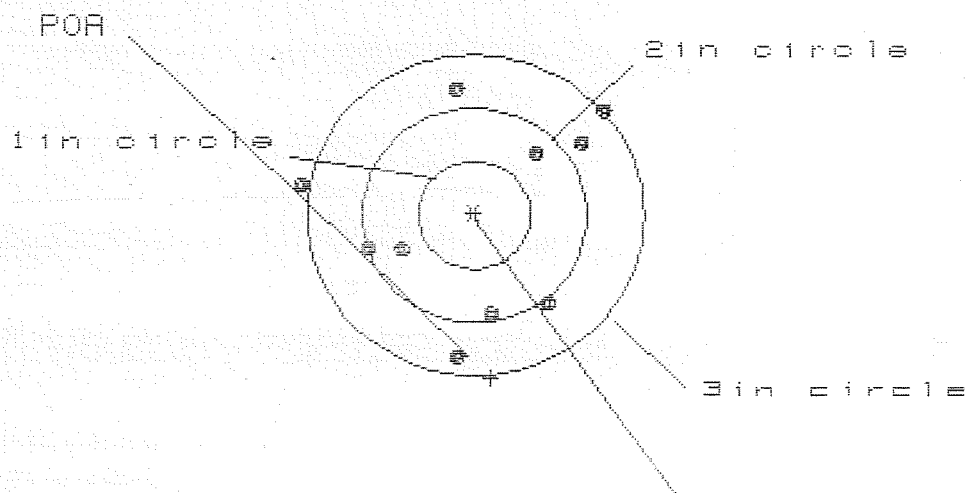
GS= 3.764

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.522	1.337	1.169
MINIMUM X	:	-1.662	-1.346	-1.050
MAXIMUM Y	:	1.471	1.605	.648
MINIMUM Y	:	-1.070	-.936	-.735
CENTROID X	:	.061	.246	.414
CENTROID Y	:	.792	.658	.457
POA TO CENTROID in.	:	.794	.702	.617
MIN RADIUS	:	.396	.307	.436
MEAN RADIUS	:	1.160	1.048	.919
MAX RADIUS	:	2.054	2.095	1.258
HORIZONTAL SPREAD	:	3.184	2.683	2.219
VERTICAL SPREAD	:	2.541	2.541	1.383
EXTREME SPREAD	:	3.764	3.516	2.405
NUMBER IN ONE INCH CIRCLE	=	3		
NUMBER IN TWO INCH CIRCLE	=	4		
NUMBER IN THREE INCH CIRCLE	=	7		

7 Jan 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C8349186

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

CENTROID #

IN CIR

1 in = 0

2 in = 5

3 in = 9

HS= 2.619

VS= 2.510

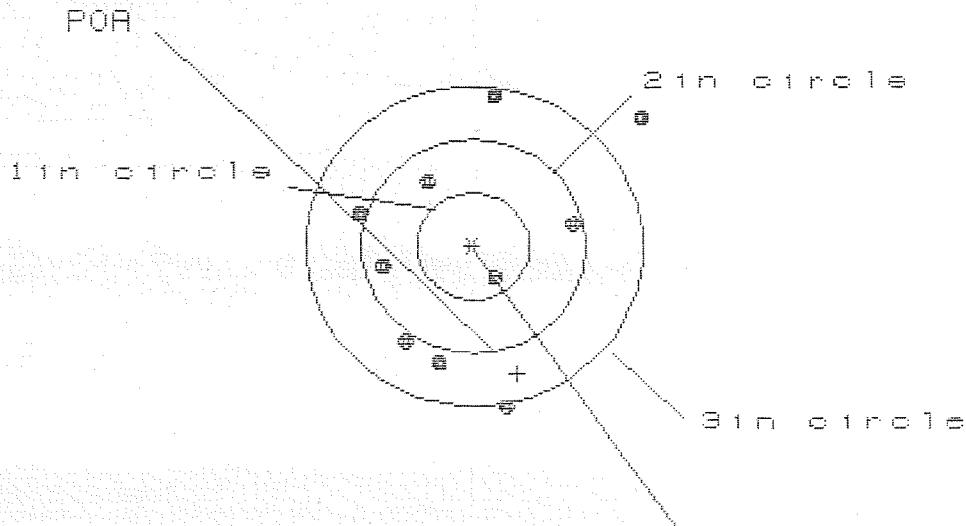
GS= 2.701

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.119	.952	.895
MINIMUM X	:	-1.500	-1.070	-.951
MAXIMUM Y	:	1.198	1.228	1.348
MINIMUM Y	:	-1.312	-1.282	-1.162
CENTROID X	:	-.150	.017	-.102
CENTROID Y	:	1.521	1.491	1.371
POA TO CENTROID in.	:	1.528	1.491	1.375
MIN RADIUS	:	.751	.701	.738
MEAN RADIUS	:	1.110	1.053	.998
MAX RADIUS	:	1.524	1.351	1.357
HORIZONTAL SPREAD	:	2.619	2.022	1.846
VERTICAL SPREAD	:	2.510	2.510	2.510
EXTREME SPREAD	:	2.701	2.597	2.512
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

7 Jan 1988

FILE:/PATTERNING/CENTERFIRE_PATT/08349108

CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 4

3 in = 9

HS= 2.496

VS= 2.854

GS= 2.997

CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.498	1.047	1.109
MINIMUM X	:	-.998	-.831	-.769
MAXIMUM Y	:	1.400	1.538	1.373
MINIMUM Y	:	-1.454	-1.316	-1.117
CENTROID X	:	-.389	-.556	-.618
CENTROID Y	:	1.193	1.055	1.220
POA TO CENTROID in.	:	1.255	1.192	1.367
MIN RADIUS	:	.336	.404	.529
MEAN RADIUS	:	1.090	.967	.904
MAX RADIUS	:	1.948	1.585	1.444
HORIZONTAL SPREAD	:	2.496	1.878	1.878
VERTICAL SPREAD	:	2.854	2.854	2.491
EXTREME SPREAD	:	2.997	2.856	2.544
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	4		
NUMBER IN THREE INCH CIRCLE	=	9		

7 Jan 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C8349106

CENTERFIRE PATTERNS # 5

POA

1 in circle

2 in circle

3 in circle

OF SHOTS = 10

IN CIR

1 in = 2

2 in = 5

3 in = 8

HE = 2.414

VS = 2.475

GS = 3.181

CENTROID #

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.277	1.151	1.243
MINIMUM X	-1.137	-1.210	-1.118
MAXIMUM Y	1.369	.832	.712
MINIMUM Y	-1.106	-.954	-.710
CENTROID X	.014	.140	.048
CENTROID Y	1.082	.930	1.050
POA TO CENTROID in.	1.082	.941	1.051
MIN RADIUS	.169	.157	.148
MEAN RADIUS	.975	.884	.823
MAX RADIUS	1.779	1.468	1.326
HORIZONTAL SPREAD	2.414	2.361	2.361
VERTICAL SPREAD	2.475	1.786	1.422
EXTREME SPREAD	3.181	2.641	2.561
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		9	

Remington®
MODEL 700™ H24

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

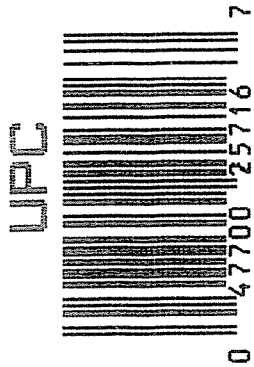
DUPONT
REG. U.S. PAT. & TM. OFF.

SERIAL NO.
C6349106

ORDER NO.
5716

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

Q1



CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6349106

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	5 2	90	RW
600	Proof	5 2	90	RW
607	Check Headspace	5 2	90	RW
610	Dis-assemble Gun	5 2	90	RW
612	Magnaflux Barrel Action	5-8-90		KCR
	Magnaflux Bolt	5-8-90		KCR
615	Rollmark Caliber		5/8/90	GB
617	Drill and Tap Sight Holes		5/9/90	RB
618	Polish Barrel RB		5/10/90	RB
620	Apply Coatings (Barrel Action)		5/16/90	TJA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		5/18/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/18/90	RW
	C) Inspect Ejector Hole for Chamfer		5/18/90	RW
	D) Oil Firing Pin Ass'y		5/18/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		5/23/90	JH

BARBER - M24 0107916

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			5/23/90	WB
	G) Safety Off Force	3 1/4	3 1/4	3 1/4			5/23/90	WB
	H) Trigger Pull Test & Retainability						5/23/90	RC
	I) Firing Pin Indent	.023	.0235	.023			5/23/90	WB
	J) Assemble Stock						5/23/90	RW
	K) Assemble Swivel Studs						4/14/90	JM
	L) Attach Front and Rear Sight Assemblies						5/23/90	RW
	M) Iron Sight Alignment						5/23/90	RW
	N) Detach Front & Rear Sights & place in numbered container						5/23/90	RW
	O) Attach Scope to Rifle						5/23/90	WB
	P) Detach & Attach Scope 20 Times						5/23/90	WB
640	Gallery Target & Test						5-23-90	DH
	A) Time						5-23-90	DH
	B) Malfunctions						5-23-90	DH
	C) Pierced Primers						5-23-90	DH
	D) Optical Clarity of Scope						5-23-90	DH
645	Inspect for Live Ammo						5-23-90	DH
655	Final Inspection							
	A) Headspace						24 May 90	JS
	B) Trigger Pull	281	277	261	275	264	24 May 90	JS
	C) Function						24 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. C6349106DATE 5/23/90TESTER JU

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.38	2.34	2.41	2.81	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.43	2.35	2.41	2.77	
PULL #3	2.43	2.34	2.45	2.61	
PULL #4	2.41	2.09	2.45	2.75	
PULL #5	2.40	2.31	2.49	2.64	
TOTAL	12.05	11.43	12.21		
AVG.	2.41	2.286	2.442		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.25	3.30		
PULL #2	3.22	3.22		
PULL #3	3.18	3.26		
PULL #4	3.13	3.26		
PULL #5	3.15	3.25		
TOTAL	15.93	16.29		
AVG.	3.186	3.258		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.42	4.32		4.22
PULL #2	4.45	4.27		4.20
PULL #3	4.33	4.18		4.12
PULL #4	4.29	4.27		4.15
PULL #5	4.07	4.28		4.14
TOTAL	21.56	21.32		20.83
AVG.	4.312	4.264		4.166

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6349106
24 May 1990

CENTROIDAL DISTANCES

0 TO	1	.161199
1 TO	2	.122589
1 TO	3	.349857
1 TO	4	.440736
1 TO	5	.298397

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

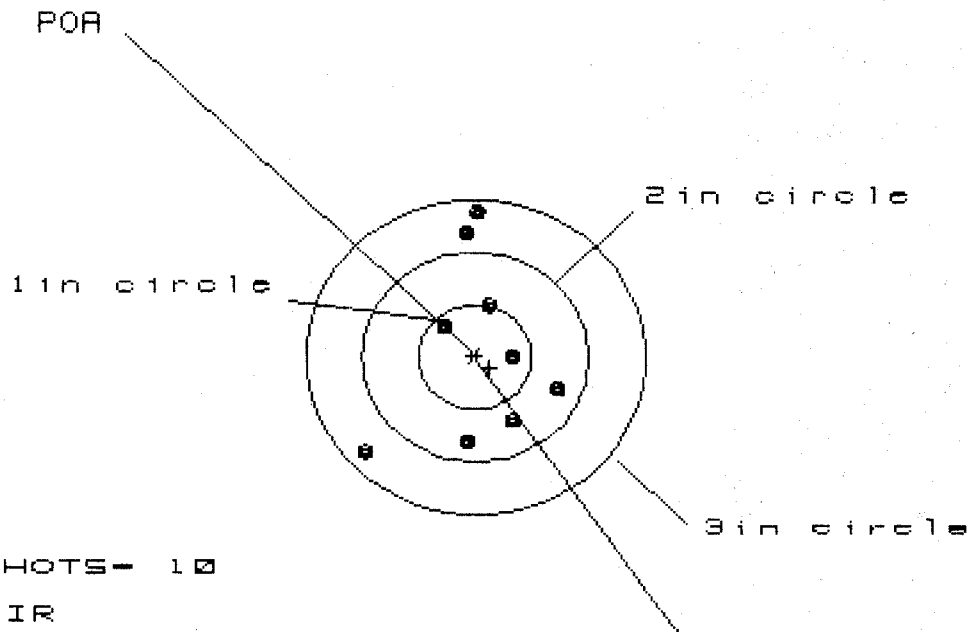
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .053
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0094
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0538271

THE AMR FOR THIS RIFLE IS: .8892

23 May 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6349106

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in - 2

2 in - 7

3 in = 10

HS= 1.694

VS= 2.303

GS= 2.502

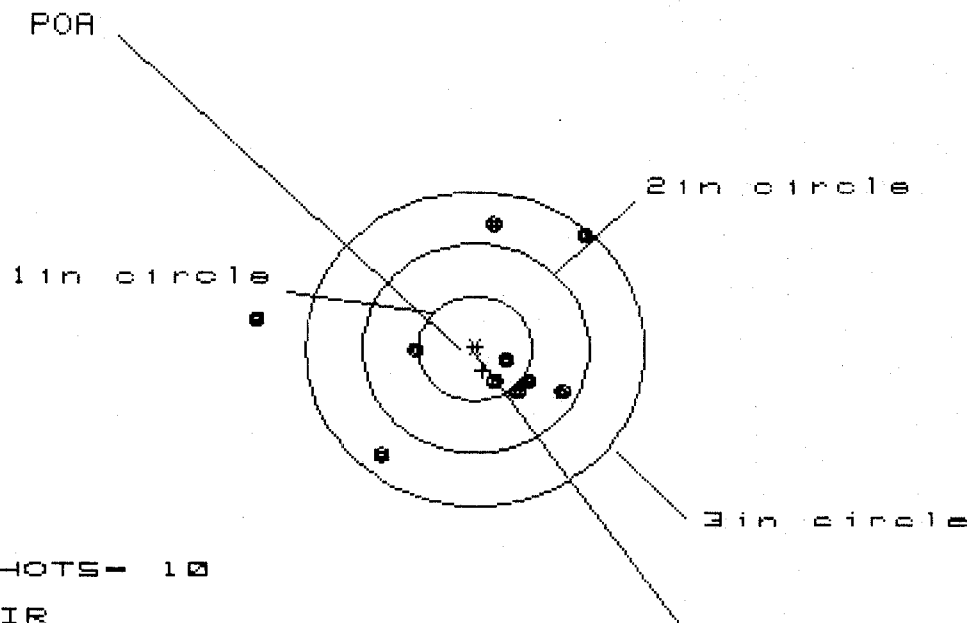
CENTROID *

PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.733	.735	.615
MINIMUM X	:	-.961	-.959	-.372
MAXIMUM Y	:	1.357	1.363	1.264
MINIMUM Y	:	-.946	-.796	-.729
CENTROID X	:	-.124	-.126	-.006
CENTROID Y	:	.103	-.047	.052
POA TO CENTROID in.	:	.162	.135	.053
MIN RADIUS	:	.278	.330	.176
MEAN RADIUS	:	.809	.738	.654
MAX RADIUS	:	1.357	1.367	1.282
HORIZONTAL SPREAD	:	1.694	1.694	.987
VERTICAL SPREAD	:	2.303	2.159	1.993
EXTREME SPREAD	:	2.502	2.324	1.994
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	7		
NUMBER IN THREE INCH CIRCLE	=	10		

23 May 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6349106

CENTERFIRE PATTERNS # 2



OF SHOTS - 10

IN CIR

1 in - 2

2 in - 6

3 in - 9

HS - 2.925

VS = 2.187

GS = 3.026

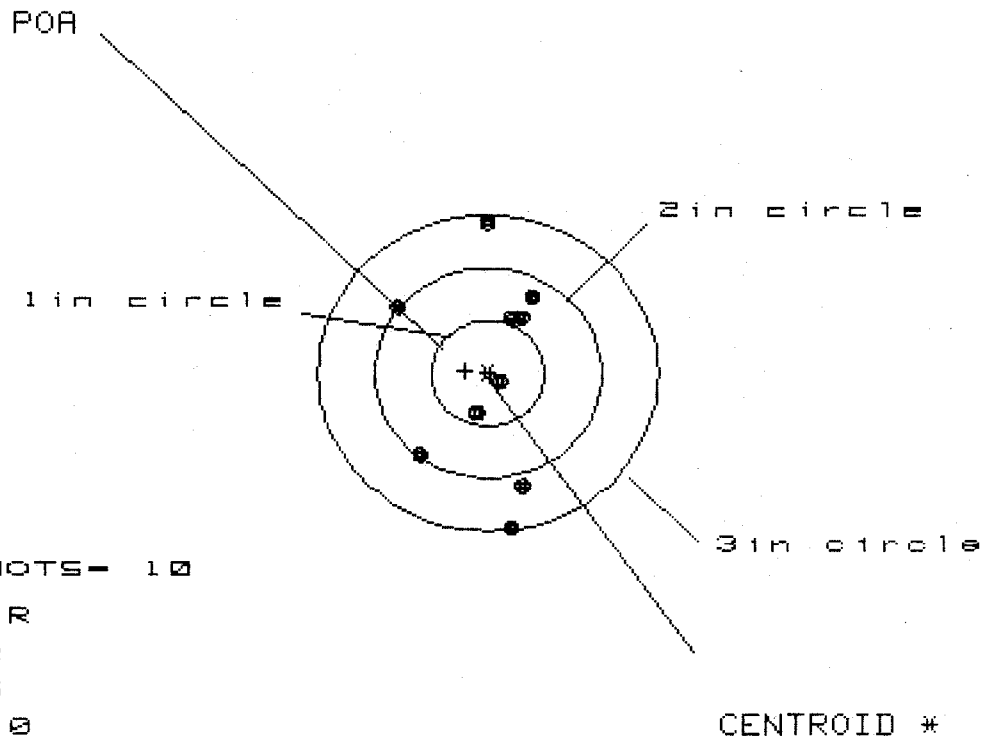
CENTROID #

PATTERN #	:	2	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.987	.772	.686
MINIMUM X	:	-1.938	-1.085	-.989
MAXIMUM Y	:	1.206	1.237	1.372
MINIMUM Y	:	-.981	-.950	-.815
CENTROID X	:	-.066	.149	.052
CENTROID Y	:	.211	.180	.045
POR TO CENTROID in.	:	.221	.234	.069
MIN RADIUS	:	.306	.090	.141
MEAN RADIUS	:	.915	.735	.642
MAX RADIUS	:	1.957	1.442	1.374
HORIZONTAL SPREAD	:	2.925	1.857	1.675
VERTICAL SPREAD	:	2.187	2.187	2.187
EXTREME SPREAD	:	3.026	2.752	2.435
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	6		
NUMBER IN THREE INCH CIRCLE	=	9		

23 May 1990

FILE:/PATTERNING/CENTERFIRE_PATT/C6349106

CENTERFIRE PATTERNS # 3



OF SHOTS - 10
 # IN CIR
 1 in - 2
 2 in - 6
 3 in - 10
 HS - 1.239
 VS - 2.926
 GS - 2.940

PATTERN #	:	3	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.400	.427	.425
MINIMUM X	:	-.839	-.812	-.814
MAXIMUM Y	:	1.456	1.293	.686
MINIMUM Y	:	-1.470	-1.280	-1.118
CENTROID X	:	.200	.173	.174
CENTROID Y	:	-.029	.134	-.028
POA TO CENTROID in.	:	.202	.219	.177
MIN RADIUS	:	.112	.247	.136
MEAN RADIUS	:	.853	.776	.701
MAX RADIUS	:	1.490	1.314	1.157
HORIZONTAL SPREAD	:	1.239	1.239	1.239
VERTICAL SPREAD	:	2.926	2.573	1.804
EXTREME SPREAD	:	2.940	2.591	2.030
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	6		
NUMBER IN THREE INCH CIRCLE	=	10		

23 May 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6349106

CENTERFIRE PATTERNS

4

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in - 2

2in - 8

3in - 10

HS- 2.015

VS= 1.757

GS= 2.631

PATTERN #	:	4	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.805	.678	.538
MINIMUM X	:	-1.210	-1.120	-.622
MAXIMUM Y	:	.657	.535	.593
MINIMUM Y	:	-1.100	-.735	-.677
CENTROID X	:	.154	.064	.204
CENTROID Y	:	-.239	-.117	-.175
POA TO CENTROID in.	:	.284	.133	.269
MIN RADIUS	:	.159	.095	.109
MEAN RADIUS	:	.701	.600	.529
MAX RADIUS	:	1.363	1.215	.864
HORIZONTAL SPREAD	:	2.015	1.798	1.160
VERTICAL SPREAD	:	1.757	1.270	1.270
EXTREME SPREAD	:	2.631	2.164	1.451
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	

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FILE:/PATTERNING/CENTERFIRE_PATT/C6349106

CENTERFIRE PATTERNS # 5

POA

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 1

2 in = 3

3 in = 7

HS= 2.302

VS= 3.540

GS= 3.600

CENTROID *

PATTERN #	:	5	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.334	1.299	1.174
MINIMUM X	:	-.968	-1.003	-.880
MAXIMUM Y	:	2.047	1.155	.996
MINIMUM Y	:	-1.493	-1.265	-.965
CENTROID X	:	.101	.136	.261
CENTROID Y	:	-.093	-.321	-.162
POA TO CENTROID in.	:	.138	.348	.308
MIN RADIUS	:	.354	.421	.467
MEAN RADIUS	:	1.168	1.068	.983
MAX RADIUS	:	2.071	1.615	1.337
HORIZONTAL SPREAD	:	2.302	2.302	2.054
VERTICAL SPREAD	:	3.540	2.420	1.962
EXTREME SPREAD	:	3.600	2.878	2.475
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	3		
NUMBER IN THREE INCH CIRCLE	=	7		