

G 641 4351
Raphed
C: 622 5496

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: RE00144831

Serial: G6414351 Model M24 SWS Center Fire
Caliber: 7.62 NATO

Repairman:

Verify Repair

Status:

Closed 4/24/2008 10:56:52 AM

Address Information

Customer:

☒ Received From

Return To:

☐ Received From

Name: B/210TH BSB

B/210TH BSB

Address 1:

2 BCT

2 BCT

Address 2:

10 TH MTN DIV

PO Box:

10 TH MTN DIV

PO Box:

City: FORT DRUM

FORT DRUM

State: NY

Zip Code: 13602

Country: US

State: NY

Zip Code: 13602

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
A008	With Swivel	2
A010	Hard Case	1
A026	Scoops	1
A057	Front and Rear Sgt Base	1

nagletj

4/24/2008

12:25 PM

NUM

Serial
Number:

G6414351

Model: M24 SWS



RE00144831

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6414351.__0

FILE DATE AND TIME: 05/20/2008 22:22

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.100
The Average Y Centroid of the Five Target Set:	0.001
The Average Point of Impact of the Five Target Set:	0.100
The Average Mean Radius of the Five Target Set:	0.704
The Distance from POA to Centroid Target #1:	0.171
The Distance from Centroid Target #2 to Centroid Target #1:	0.144
The Distance from Centroid Target #3 to Centroid Target #1:	0.263
The Distance from Centroid Target #4 to Centroid Target #1:	0.274
The Distance from Centroid Target #5 to Centroid Target #1:	0.143

BARBER - M24 0150734

SERIAL NUMBER: C6414351. __0

TARGET NUMBER: 1

FILE DATE: 05/20/2008

FILE TIME: 22:22

POINT#	X	Y
1:	-0.184	0.650
2:	-0.819	0.414
3:	-0.432	-0.139
4:	-0.889	-0.155
5:	-0.807	-0.812
6:	0.422	0.188
7:	0.864	-0.045
8:	0.376	-0.199
9:	0.024	-0.268
10:	0.126	-0.730

X CENTROID: -0.132

Y CENTROID: -0.110

POA TO CENTROID: 0.171

HORZ SPREAD: 1.753

VERT SPREAD: 1.462

GROUP SPREAD: 1.839

MIN RADIUS: 0.222

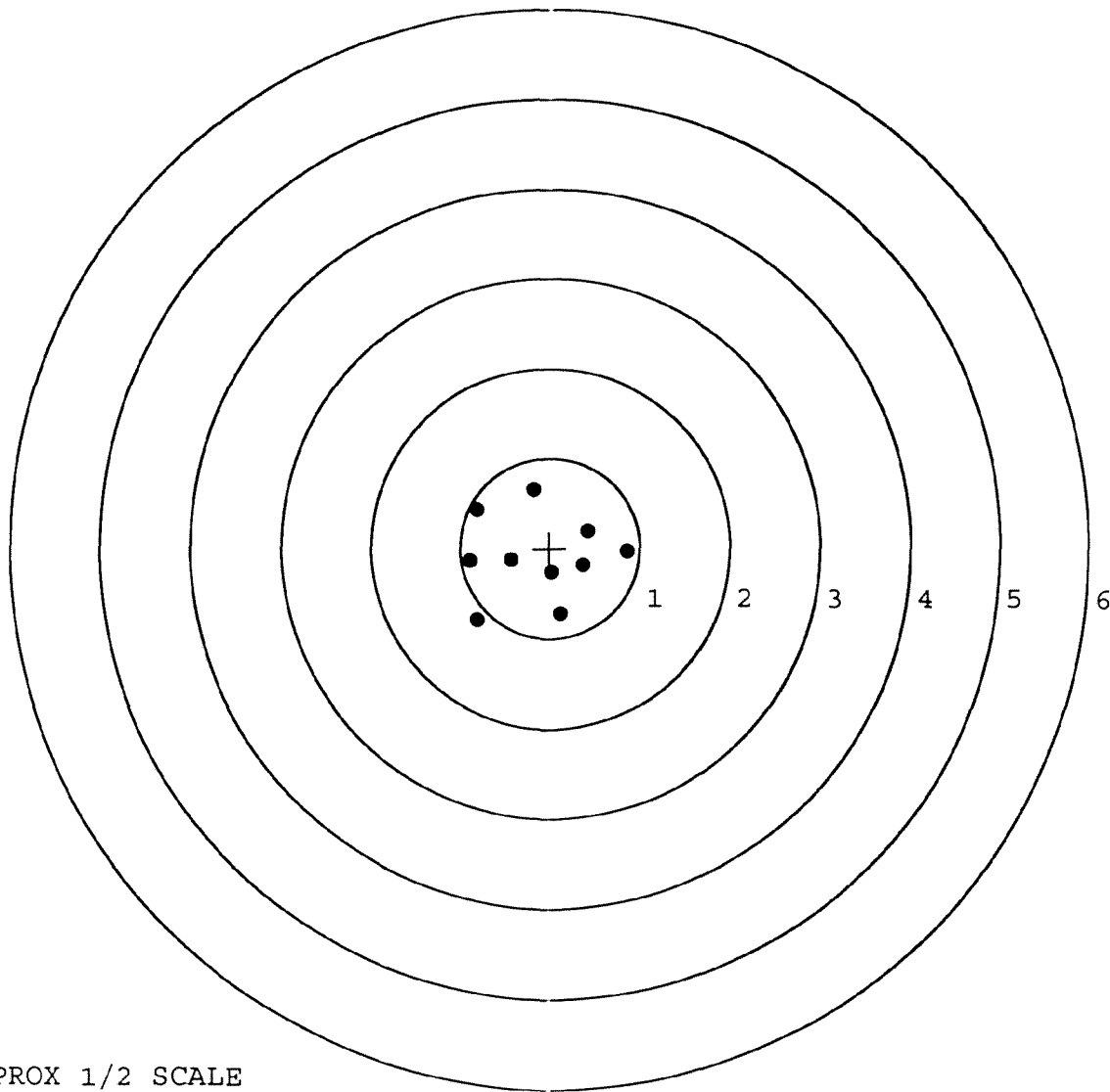
MAX RADIUS: 0.998

MEAN RADIUS: 0.670

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

BARBER - M24 0150735

SERIAL NUMBER: C6414351. __0

TARGET NUMBER: 2

FILE DATE: 05/20/2008

FILE TIME: 22:22

POINT#	X	Y
1:	0.539	0.726
2:	0.382	0.326
3:	-0.616	0.285
4:	-0.504	0.063
5:	-0.234	-0.063
6:	-1.129	0.126
7:	0.009	-0.502
8:	-0.101	-0.785
9:	0.671	-0.101
10:	-0.326	0.273

X CENTROID: -0.131

Y CENTROID: 0.035

POA TO CENTROID: 0.135

HORZ SPREAD: 1.800

VERT SPREAD: 1.511

GROUP SPREAD: 1.814

MIN RADIUS: 0.142

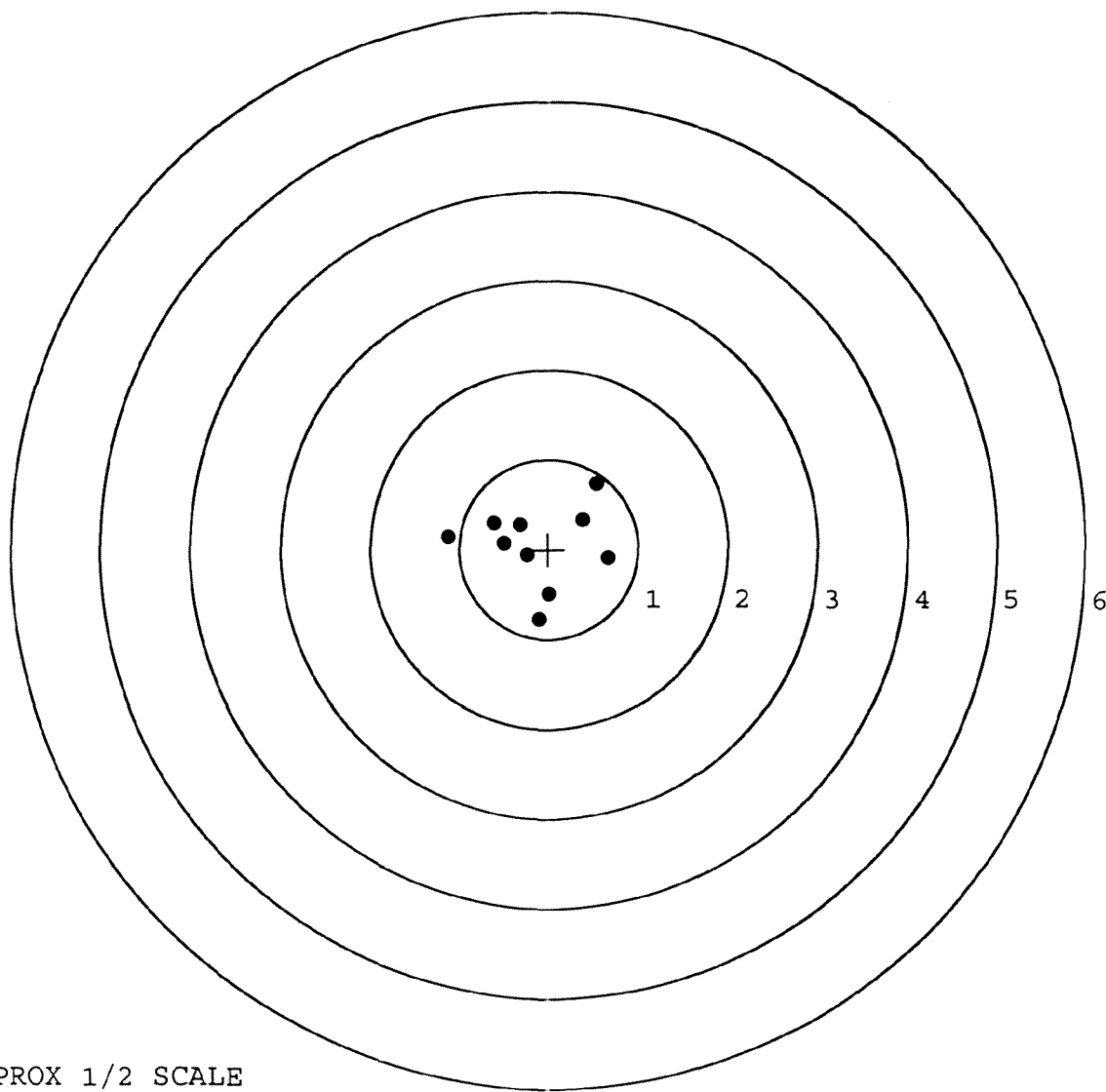
MAX RADIUS: 1.002

MEAN RADIUS: 0.611

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

BARBER - M24 0150736

SERIAL NUMBER: C6414351. __ 0

TARGET NUMBER: 3

FILE DATE: 05/20/2008

FILE TIME: 22:22

POINT#	X	Y
1:	-0.668	1.306
2:	0.463	0.565
3:	0.087	0.604
4:	-0.030	0.337
5:	-0.400	0.396
6:	-0.587	-0.101
7:	0.996	0.348
8:	0.753	-0.661
9:	-0.286	-0.620
10:	-0.650	-0.831

X CENTROID: -0.032

Y CENTROID: 0.134

POA TO CENTROID: 0.138

HORZ SPREAD: 1.664

VERT SPREAD: 2.137

GROUP SPREAD: 2.427

MIN RADIUS: 0.203

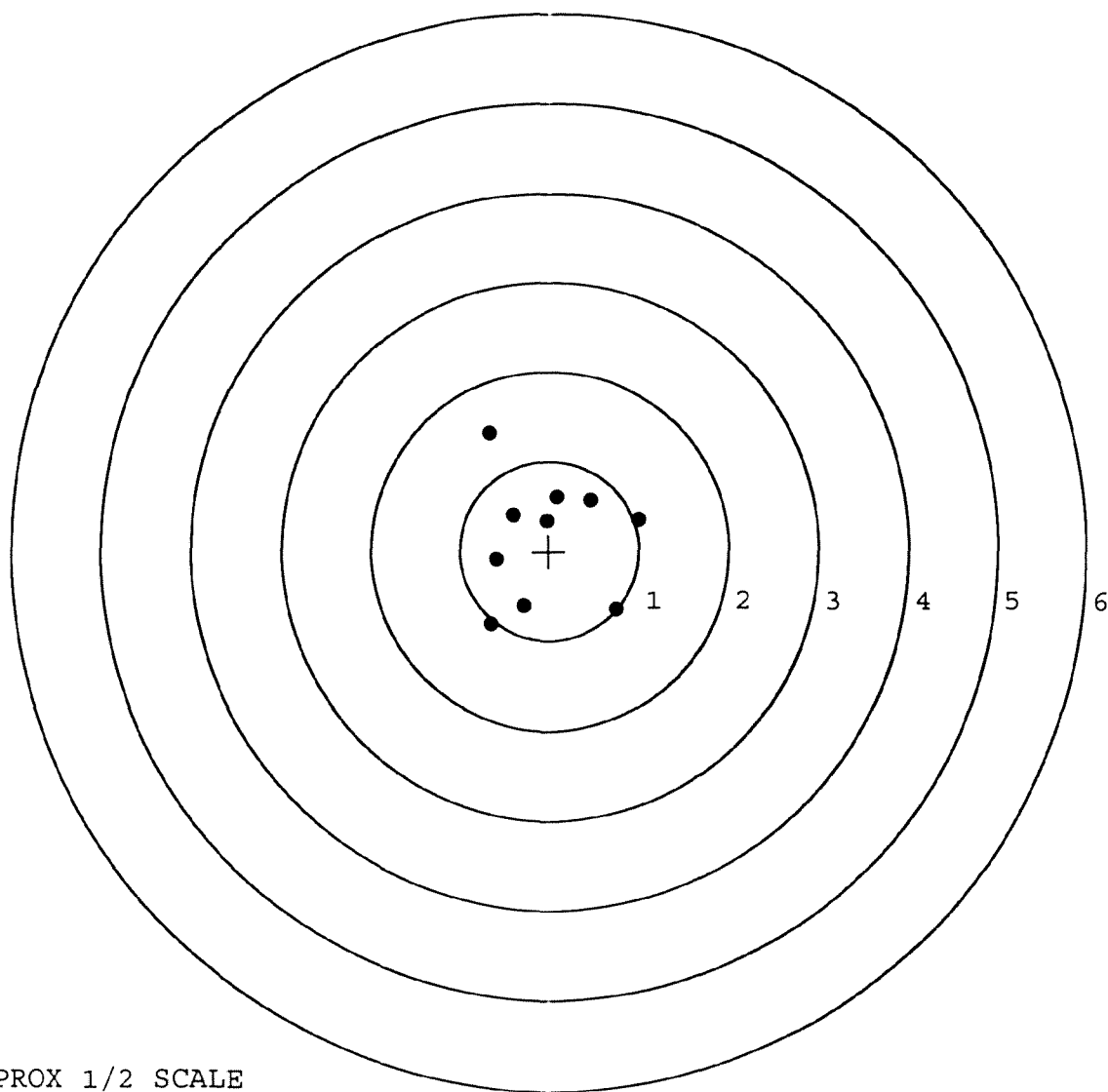
MAX RADIUS: 1.333

MEAN RADIUS: 0.784

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

BARBER - M24 0150737

SERIAL NUMBER: C6414351. __0

TARGET NUMBER: 4

FILE DATE: 05/20/2008

FILE TIME: 22:22

POINT#	X	Y
1:	-0.270	0.749
2:	0.568	0.625
3:	0.114	0.340
4:	0.000	0.179
5:	-0.273	-0.203
6:	-0.615	-0.265
7:	-0.952	-0.086
8:	0.096	-0.465
9:	1.010	0.010
10:	0.990	-0.087

X CENTROID: 0.067

Y CENTROID: 0.080

POA TO CENTROID: 0.104

HORZ SPREAD: 1.962

VERT SPREAD: 1.214

GROUP SPREAD: 1.964

MIN RADIUS: 0.120

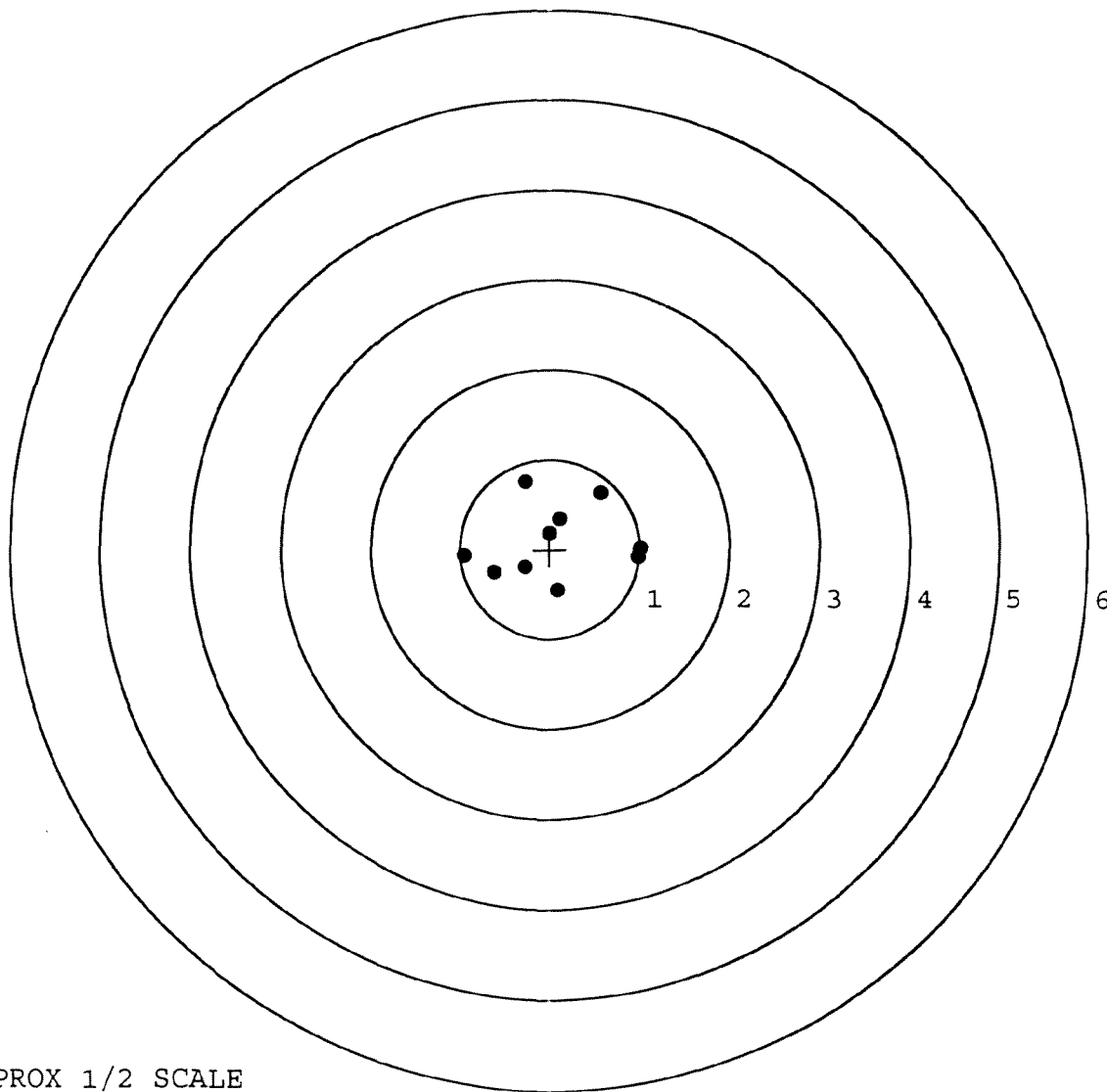
MAX RADIUS: 1.032

MEAN RADIUS: 0.654

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

BARBER - M24 0150738

SERIAL NUMBER: C6414351. 0

TARGET NUMBER: 5

FILE DATE: 05/20/2008

FILE TIME: 22:22

POINT#	X	Y
1:	-0.522	0.881
2:	-0.269	0.577
3:	-0.019	0.671
4:	-0.437	-0.041
5:	-0.485	-0.334
6:	-0.831	-0.709
7:	-0.494	-0.824
8:	-0.367	-1.478
9:	0.651	-0.799
10:	0.046	0.736

X CENTROID: -0.273

Y CENTROID: -0.132

POA TO CENTROID: 0.303

HORZ SPREAD: 1.482

VERT SPREAD: 2.359

GROUP SPREAD: 2.364

MIN RADIUS: 0.188

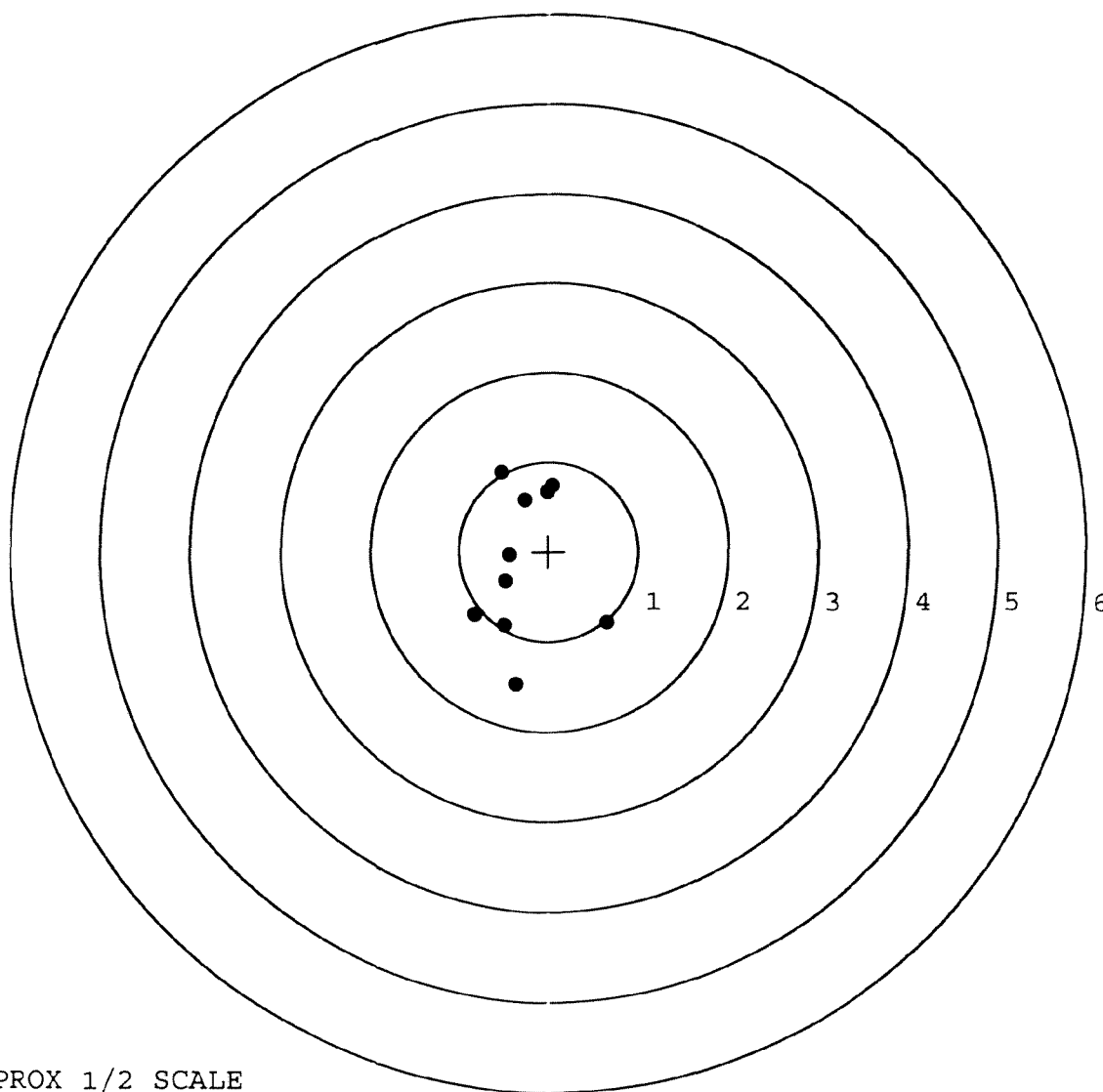
MAX RADIUS: 1.349

MEAN RADIUS: 0.802

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

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

R & E NUMBER 00144831SERIAL NUMBER G6414351LOG-IN DATE 4-24-08

OPERATION #	OPERATION NAME		DATE	INITIAL
500	DIS-ASSEMBLE GUN		5-2-08	RP
505	RE-BARREL		5-6-08	RTZ
560	ASSEMBLE		5-6-08	RTZ
600	PROOF	MAGNA - FLUX	5-7-08	TRW
605	CHECK HEADSPACE	MAY 09 2008	5-7-08	TRW
610	DIS-ASSEMBLE GUN		5-7-08	RTZ
612	MAGNAFLUX	OPERATOR <u>unm</u>	5/9/08	unm
510	DRILL AND TAP		5-7-08	TRW
615	ROLLMARK CALIBER		5-7-08	CW
618	ROTO-BLAST		5-9-08	DG
620	APPLY COATINGS		5/19/08	CW
625	FINAL ASSEMBLY		5-20-08	RTZ
640	FUNCTION TEST AND	PASS FAIL	5-20-08	SD
650	TARGET	PASS FAIL	5-20-08	SD
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION	5-20-08	RP
670	FINAL INSPECTION		5/22/08	FM
	A) HEADSPACE	PASS FAIL	5/22/08	FM
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	2.73 2.58 2.57 2.52 2.59 5-22-08	TRW
680	F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX	5.5 5.5 5.5 5/22/08	FM
	G) SAFETY OFF FORCE	2 LBS MIN	3.5 3.5 3.5 5/22/08	FM
	I) FIRING PIN INDENT	.020	.023 .023 .025 5/22/08	FM
690	PACK		5/29/08	FM

Repair Inquiry

Repair Number: **RE00092468**Serial: C6225476 Model: M24 SWS Center Fire
Caliber: 7.62 NATO Produced: 10/26/1988

Repairman:

Status:

Closed 2/4/2005 9:37:54 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
A010	Hard Case	1
A017	Scope Base	1
A026	Scope	1
A057	Frt and Rear Sgt Base	1

Repair Search

Refresh

Close

maglet

2/7/2005

11:27 AM

CAPS

NUM

INS

SCPL

start

3

3

Arms Services R

3

M

66414351

Serial Number: **C6225476**

Model: **M24 SWS**



RE00092468

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6414351.___0
FILE DATE AND TIME: 05/02/2005 06:50

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

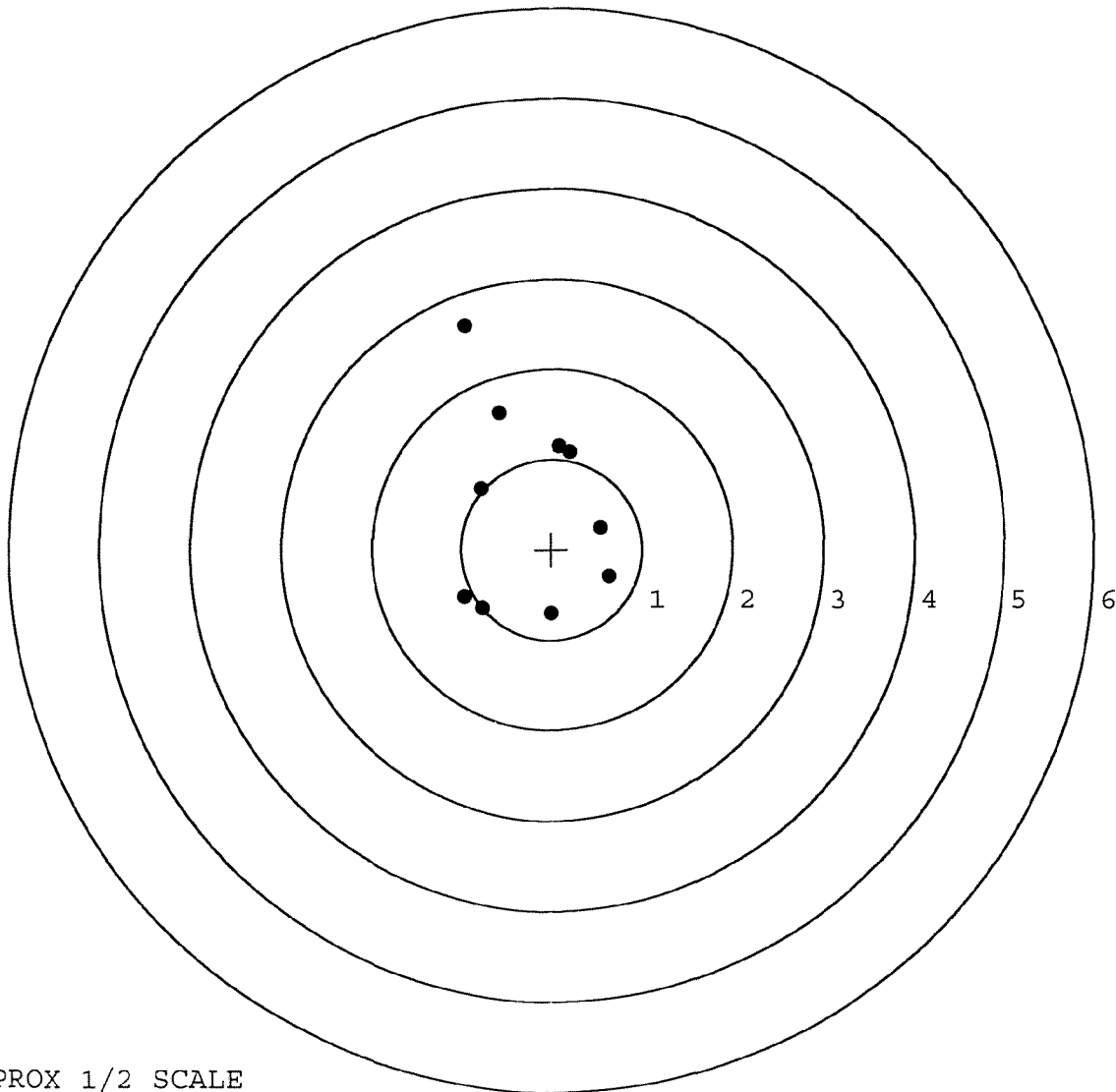
The Average X Centroid of the Five Target Set:	0.023
The Average Y Centroid of the Five Target Set:	0.282
The Average Point of Impact of the Five Target Set:	0.283
The Average Mean Radius of the Five Target Set:	1.169
The Distance from POA to Centroid Target #1:	0.554
The Distance from Centroid Target #2 to Centroid Target #1:	0.369
The Distance from Centroid Target #3 to Centroid Target #1:	0.722
The Distance from Centroid Target #4 to Centroid Target #1:	0.363
The Distance from Centroid Target #5 to Centroid Target #1:	0.460

BARBER - M24 0150742

SERIAL NUMBER: G6414351. __0
 TARGET NUMBER: 1
 FILE DATE: 05/02/2005
 FILE TIME: 06:50

POINT#	X	Y
1:	0.639	-0.303
2:	0.535	0.234
3:	-0.005	-0.709
4:	-0.763	-0.658
5:	-0.962	-0.538
6:	0.206	1.078
7:	0.083	1.142
8:	-0.774	0.668
9:	-0.581	1.510
10:	-0.961	2.473

X CENTROID: -0.258
 Y CENTROID: 0.490
 POA TO CENTROID: 0.554
 HORZ SPREAD: 1.601
 VERT SPREAD: 3.182
 GROUP SPREAD: 3.323
 MIN RADIUS: 0.546
 MAX RADIUS: 2.104
 MEAN RADIUS: 1.096
 # IN 1 IN DIAMETER: 0
 # IN 2 IN DIAMETER: 4
 # in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

BARBER - M24 0150743

SERIAL NUMBER: G6414351. 0

TARGET NUMBER: 2

FILE DATE: 05/02/2005

FILE TIME: 06:50

POINT#	X	Y
1:	1.745	0.318
2:	0.242	-1.103
3:	0.317	-0.240
4:	0.432	0.096
5:	0.722	0.455
6:	0.473	1.204
7:	-0.632	2.108
8:	-1.291	-0.641
9:	-2.139	-0.500
10:	-0.541	0.040

X CENTROID: -0.067

Y CENTROID: 0.174

POA TO CENTROID: 0.186

HORZ SPREAD: 3.884

VERT SPREAD: 3.211

GROUP SPREAD: 3.969

MIN RADIUS: 0.492

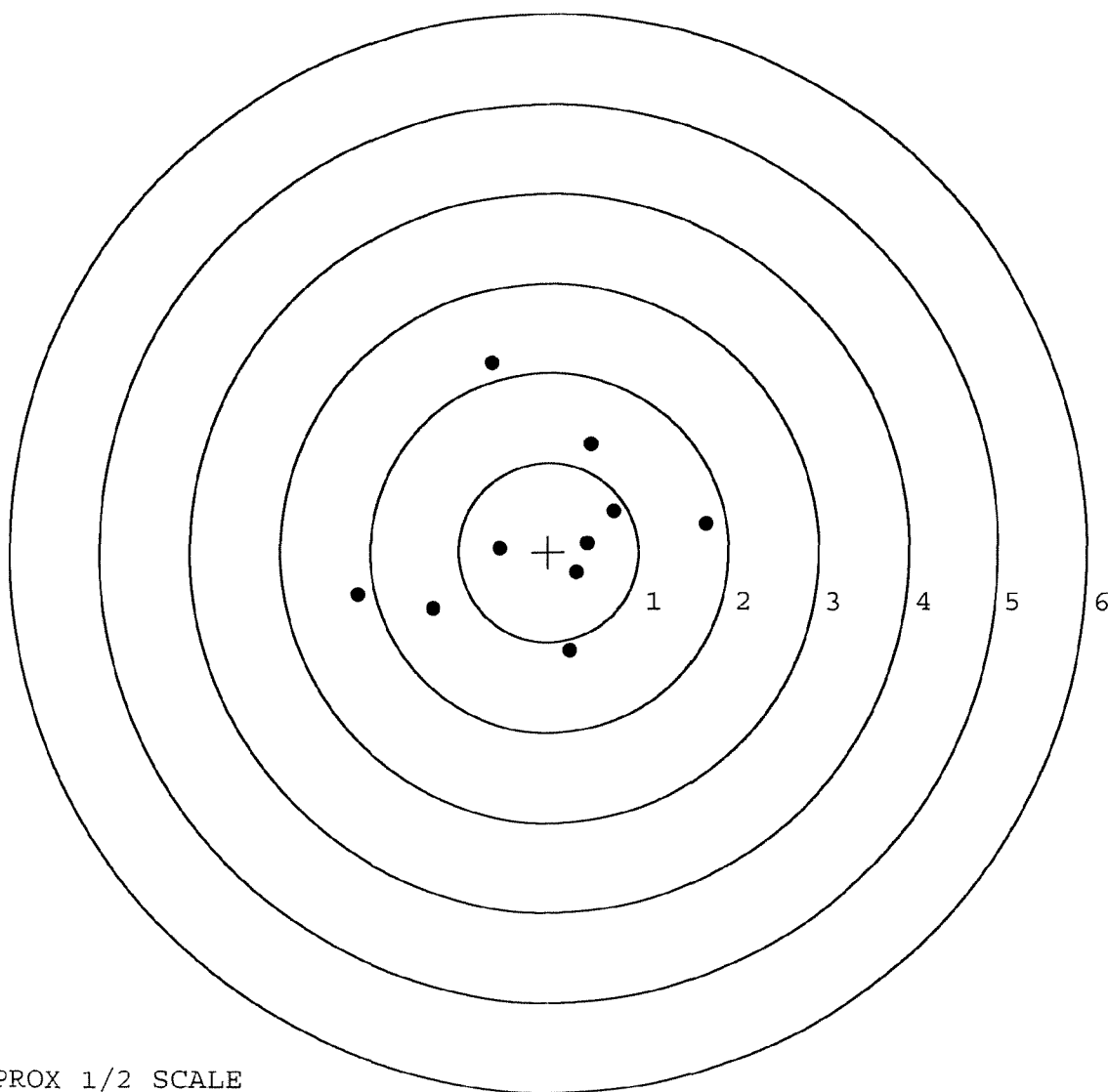
MAX RADIUS: 2.179

MEAN RADIUS: 1.236

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 4

in 3 IN DIAMETER: 7



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6414351. __0

TARGET NUMBER: 3

FILE DATE: 05/02/2005

FILE TIME: 06:50

POINT#	X	Y
1:	3.105	1.316
2:	1.806	0.674
3:	0.955	-0.162
4:	-0.081	-1.498
5:	0.366	0.084
6:	0.419	0.577
7:	-0.541	0.124
8:	-0.635	-0.492
9:	-1.161	-0.203
10:	-0.955	0.269

X CENTROID: 0.328

Y CENTROID: 0.069

POA TO CENTROID: 0.335

HORZ SPREAD: 4.266

VERT SPREAD: 2.814

GROUP SPREAD: 4.528

MIN RADIUS: 0.041

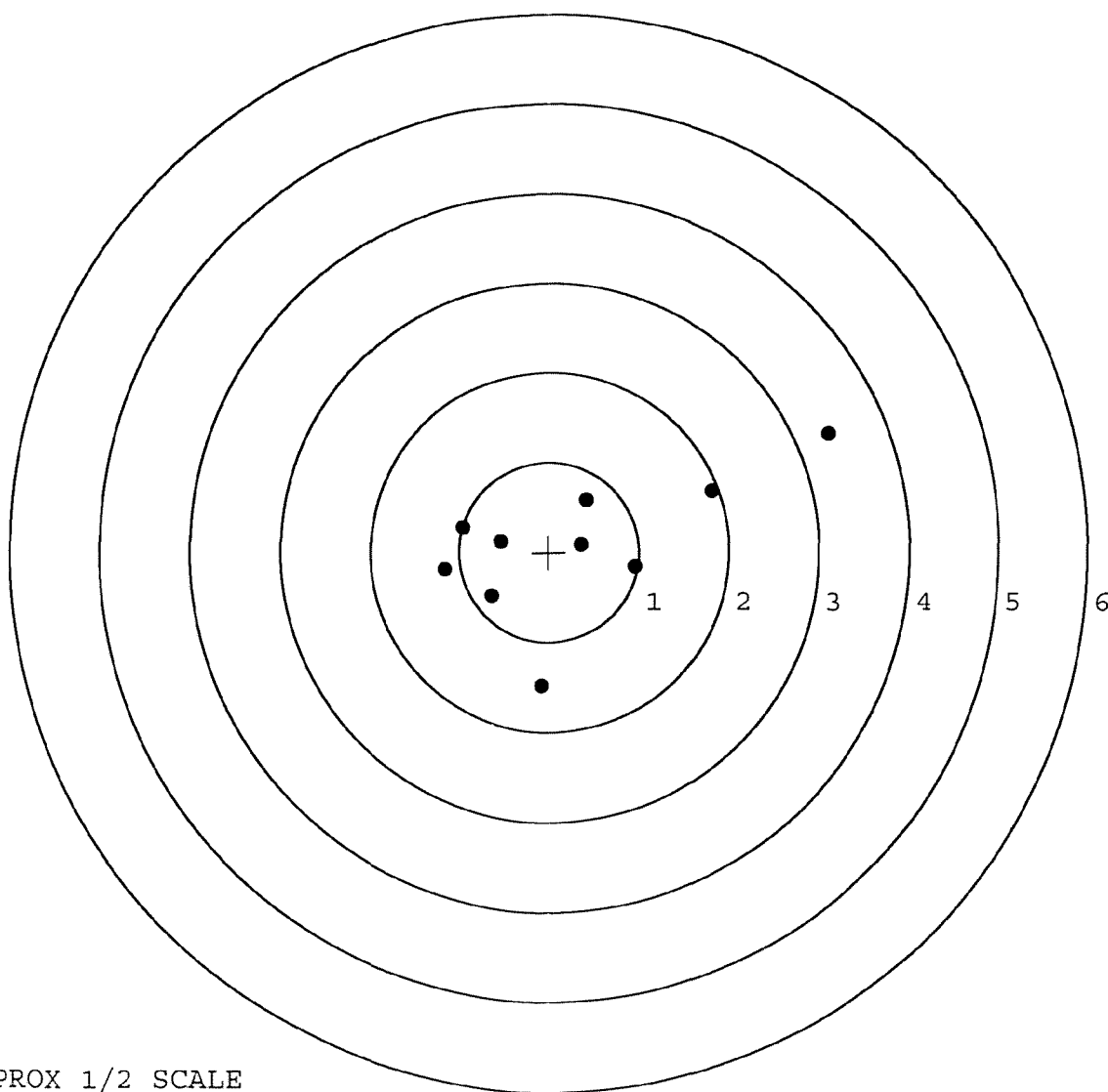
MAX RADIUS: 3.044

MEAN RADIUS: 1.228

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 4

in 3 IN DIAMETER: 6



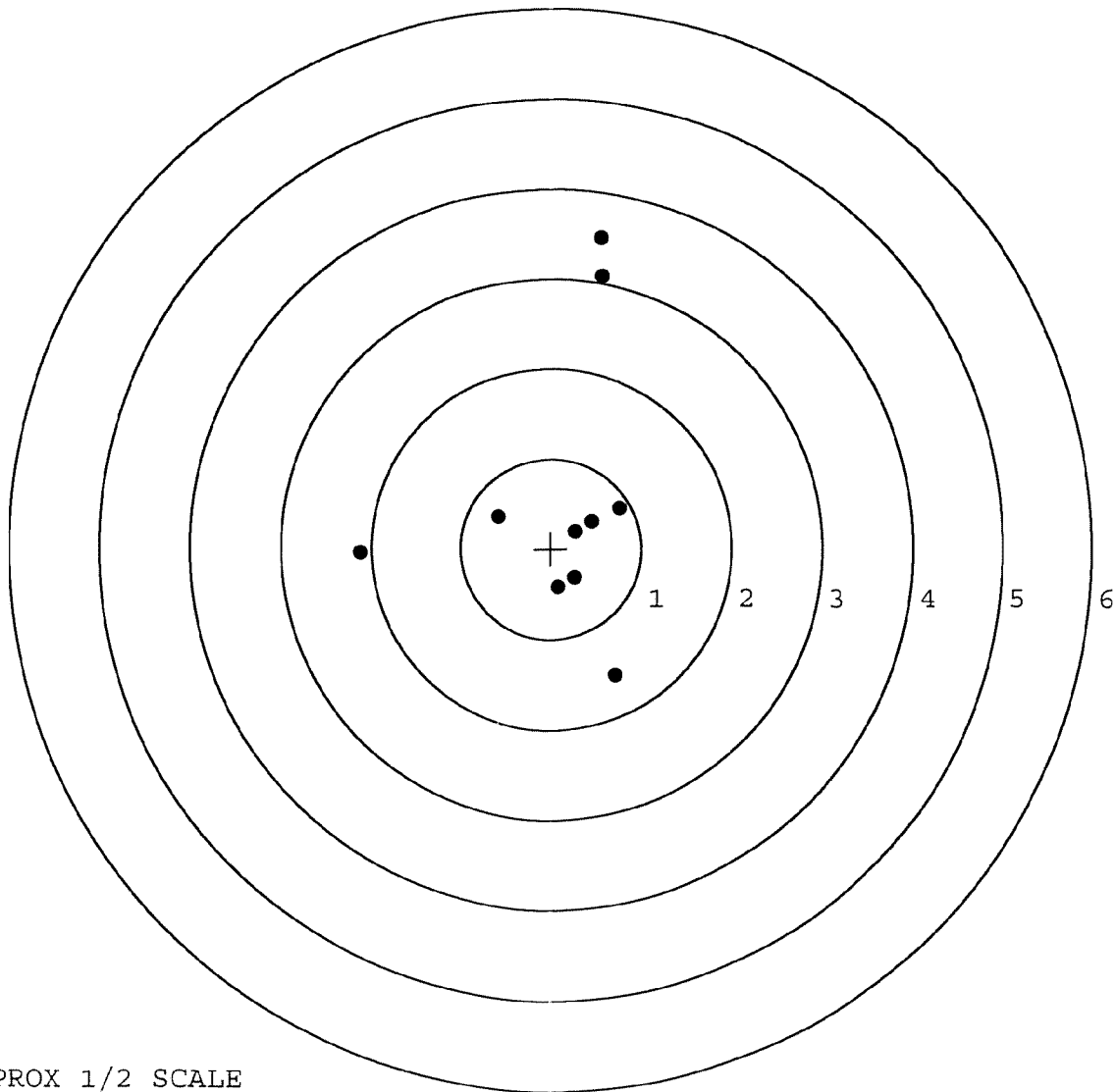
TARGET APPROX 1/2 SCALE

BARBER - M24 0150745

SERIAL NUMBER: G6414351. __0
 TARGET NUMBER: 4
 FILE DATE: 05/02/2005
 FILE TIME: 06:50

POINT#	X	Y
1:	0.719	-1.405
2:	0.082	-0.427
3:	0.268	-0.326
4:	0.761	0.448
5:	0.459	0.303
6:	0.276	0.189
7:	-0.583	0.357
8:	-2.124	-0.054
9:	0.570	3.025
10:	0.555	3.451

X CENTROID: 0.098
 Y CENTROID: 0.556
 POA TO CENTROID: 0.565
 HORZ SPREAD: 2.885
 VERT SPREAD: 4.856
 GROUP SPREAD: 4.859
 MIN RADIUS: 0.408
 MAX RADIUS: 2.931
 MEAN RADIUS: 1.392
 # IN 1 IN DIAMETER: 2
 # IN 2 IN DIAMETER: 6
 # in 3 IN DIAMETER: 6



TARGET APPROX 1/2 SCALE

BARBER - M24 0150746

SERIAL NUMBER: G6414351. __0

TARGET NUMBER: 5

FILE DATE: 05/02/2005

FILE TIME: 06:50

POINT#	X	Y
1:	0.059	-0.880
2:	0.538	0.088
3:	0.944	0.406
4:	0.634	1.290
5:	0.385	1.396
6:	0.098	0.448
7:	-0.435	0.201
8:	-0.503	-0.372
9:	-0.680	-0.594
10:	-0.873	-0.777

X CENTROID: 0.017

Y CENTROID: 0.121

POA TO CENTROID: 0.122

HORZ SPREAD: 1.817

VERT SPREAD: 2.276

GROUP SPREAD: 2.511

MIN RADIUS: 0.337

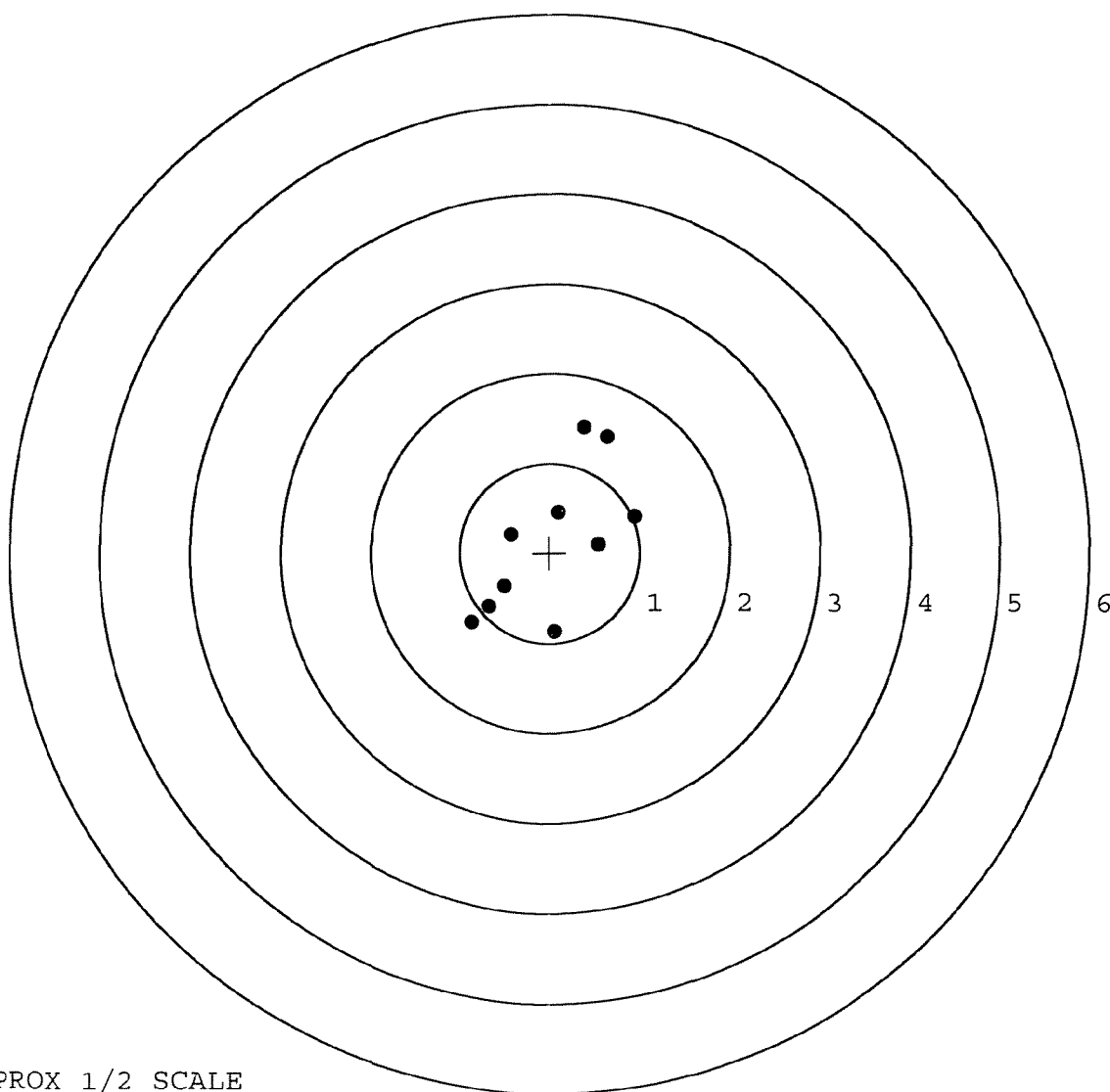
MAX RADIUS: 1.328

MEAN RADIUS: 0.892

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

R & E NUMBER	92468		
SERIAL NUMBER	C10225476	66414351	
LOG-IN DATE	2-4-05		
INSPECT AND VERIFY:			
OPERATION #	OPERATION NAME	DATE	INITIAL
550	DIS-ASSEMBLE GUN	4-4-05	RTZ
560 A	RE-BARREL	4-7-05	RTZ
B	DRILL AND TAP	4-11-05	THW
575	ASSEMBLE	4-7-05	RTZ
600	PROOF	4-8-05	AC
605	CHECK HEADSPACE	4-8-05	AC
610	DIS-ASSEMBLE GUN	4-11-05	RTZ
612	MAGNAFLUX	OPERATOR	BS
615	ROLLMARK CALIBER	4-12-05	CW
618	ROTO-BLAST	4-18-05	LB
620	APPLY COATINGS	4-25-05	WJ
625 A	FINAL ASSEMBLY	4-28-05	RTZ
B	TRIGGER PULL TEST		
C	SAFETY "ON" FORCE	5-3-05	AC
D	SAFETY "OFF" FORCE	5-3-05	AC
E	FIRING PIN INDENT	5-3-05	AC
640	TARGET	5-2-05	AC
655	FINAL INSPECT	5-3-05	AC
660	PACK	5-5-05	DA
		SHIP DATE	
		QAR INSPECTION DATE	

80295

[illegible]

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # *C6225476*

OPERATION		DATE	INT
#	NAME		
575- 580	ASSEMBLY <i>2</i>	<i>26</i>	<i>P.R.</i>
600	PROOF		<i>RW</i>
615	MAGNAFLUX BARREL	<i>5/13/88</i>	<i>P/R.</i>
	MAGNAFLUX BOLT	<i>5/13/88</i>	<i>P/R.</i>
620	COATING	<i>8/1/88</i>	<i>TJA</i>
625- 630	FINAL ASSEMBLY		
635	TEST		
640	TARGET		
	FIRING PIN INDENT		
660	PACK		

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6225476

OP. #	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and stock			
600	Proof			
607	Check Headspace			
610	Dis-assemble gun			
612	Magnaflux Barrel Action			
	Magnaflux Bolt			
615	Rollmark Caliber			
617	Drill & Tap Sight Holes			
618	Polish Barrel			
620	Apply Coatings (Barrel Action)			
	Apply Coatings (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/25/88	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/25/88	RW
	C) Inspect Ejector Hole for Chamfer		8/25/88	RW

OVER

OP.#		READINGS	DATE	INITIAL
625 cont.	D) Oil Firing Pin Ass'y		8/25/88	RW
	E) Adjust Trigger Pull to Min. Setting and Stake		25 Aug 88	J. U. + J. S.
	F) Safety on Force	4 4 4	25 Aug 88	J. U. + J. S.
	G) Safety off Force	2.75 3 3	25 Aug 88	J. U. + J. S.
	H) Trigger Pull Test & Retainability		25 Aug 88	J. U. + J. S.
	I) Firing Pin Indent	.0225 .0225 .0225	25 Aug 88	J. U. + J. S.
	J) Assemble Stock		9/26/88	RW
	K) Assemble Swivel Studs		10-6-88	J. S.
	L) Attach Front & Rear Sight Assemblies		9/26/88	RW
	M) Iron Sight Alignment		9/26/88	RW
	N) Detach Front & Rear Sights & place in numbered container		9/26/88	RW
	O) Attach Scope to Rifle		10-1-88	RW
	P) Detach & Attach Scope 20 times		10-1-88	J. S.
640	Gallery Target & Test	45 R 110 L	10/3/88	W. B.
	A) Optical Clarity of Scope		10/3/88	W. B.
645	Inspect for Live Ammo		10/3/88	A. C. & W. B.
655	Final Inspection			
	A) Headspace		10-6-88	J. S.
	B) Trigger Pull		10-6-88	J. S.
	C) Function		10-6-88	J. S.
660	Pack		10-20-88	J. S.

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C6225476

DATE 25 Aug 88

TESTER J. D. + S. S.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.48	2.18	2.13	2.71	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.46	2.26	2.06	2.73	
PULL #3	2.22	2.20	2.11	2.80	
PULL #4	2.53	2.22	2.24	2.68	
PULL #5	2.54	2.13	2.13	2.92	
TOTAL	12.23	10.99	10.67	13.84	
AVG.	2.446	2.198	2.134	2.768	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.09	3.08		
PULL #2	3.02	3.00		
PULL #3	3.14	3.00		
PULL #4	3.00	3.01		
PULL #5	3.04	3.01		
TOTAL	15.29	15.10		
AVG.	3.058	3.02		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.12	4.14		4.01
PULL #2	4.19	4.16		3.93
PULL #3	4.19	4.14		3.96
PULL #4	4.16	4.13		3.96
PULL #5	4.19	4.17		3.96
TOTAL	20.85	20.74		19.82
AVG.	4.17	4.148		3.964

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06225476

CENTROIDAL DISTANCES

0 TO	1	1.65963
1 TO	2	.666694
1 TO	3	.586042
1 TO	4	1.40018
1 TO	5	1.09264

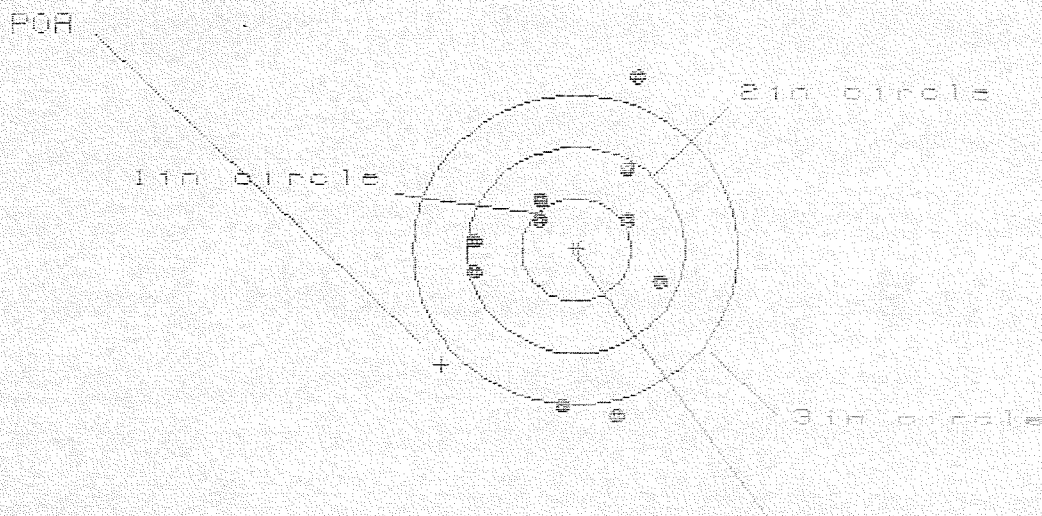
1
2
3
4
+ 5 x-----FOR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: 1.0702
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .3954
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: 1.14091
THE AMR FOR THIS RIFLE IS: .9804

5 Oct 1986

FILE:/PATTERNING/CENTERFIRE_PATT/05225476

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1in = 1

2in = 7

3in = 8

HS= 1.748

VS= 3.274

GS= 3.279

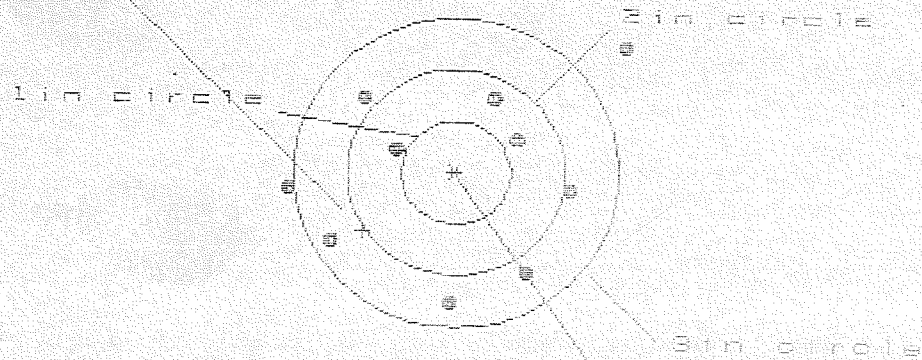
PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.793	1.856	1.911
MINIMUM X	-1.955	-1.892	-1.837
MAXIMUM Y	1.691	1.603	1.829
MINIMUM Y	-1.583	-1.395	-1.460
CENTROID X	1.232	1.169	1.114
CENTROID Y	1.112	1.924	1.098
POA TO CENTROID IN.	1.660	1.490	1.564
MIN RADIUS	.420	.520	.345
MEAN RADIUS	1.015	.944	.832
MAX RADIUS	1.784	1.464	1.460
HORIZONTAL SPREAD	1.748	1.748	1.748
VERTICAL SPREAD	3.274	2.398	2.289
EXTREME SPREAD	3.279	2.401	2.374
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	8		

5 Oct 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C8225476

CENTERFIRE PATTERNS # 2

POA



OF SHOTS= 10

IN CIR

1 in = 0

2 in = 3

3 in = 7

HS= 3.079

VS= 2.581

GS= 3.418

CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.514	1.268	1.098
MINIMUM X	-1.565	-1.397	-1.190
MAXIMUM Y	1.282	.867	.860
MINIMUM Y	-1.299	-1.157	-1.164
CENTROID X	.848	.690	.855
CENTROID Y	.567	.425	.432
POA TO CENTROID in.	1.020	.802	.958
MIN RADIUS	.588	.536	.663
MEAN RADIUS	1.160	1.067	1.011
MAX RADIUS	1.984	1.398	1.285
HORIZONTAL SPREAD	3.079	2.665	2.293
VERTICAL SPREAD	2.581	2.024	2.024
EXTREME SPREAD	3.418	2.665	2.328
NUMBER IN ONE INCH CIRCLE	=	0	
NUMBER IN TWO INCH CIRCLE	=	3	
NUMBER IN THREE INCH CIRCLE	=	8	

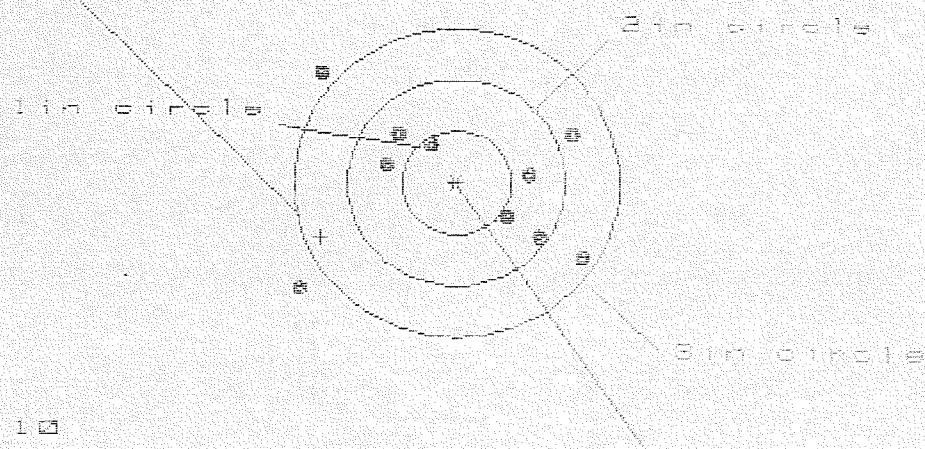
5 Oct 1988

FILE:/PATTERNING/CENTERFIRE_PATT/06225475

BARBER - M24 0150756

CENTERFIRE PATTERNS # 3

POR



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 6

3 in = 8

HS= 2.591

VS= 2.108

GS= 3.043

CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.173	1.015	.837
MINIMUM X	-1.418	-1.421	-1.947
MAXIMUM Y	1.103	.991	.500
MINIMUM Y	-1.005	-.833	-1.709
CENTROID X	1.239	1.397	1.575
CENTROID Y	.526	.638	.514
POR TO CENTROID in.	1.346	1.536	1.656
MIN RADIUS	.411	.450	.319
MEAN RADIUS	.990	.888	.751
MAX RADIUS	1.738	1.733	1.097

	1	2	3
HORIZONTAL SPREAD	2.591	2.436	1.784
VERTICAL SPREAD	2.108	1.824	1.269
EXTREME SPREAD	3.043	3.043	2.188
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	8		

5 Oct 1998

FILE:\PATTERNING\CENTERFIRE_PATT\06225476

CENTERFIRE PATTERNS

4

POR

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS- 10

IN CIR

1 in = 2

2 in = 8

3 in = 9

HS= 2.886

VS= 1.475

GS= 2.887

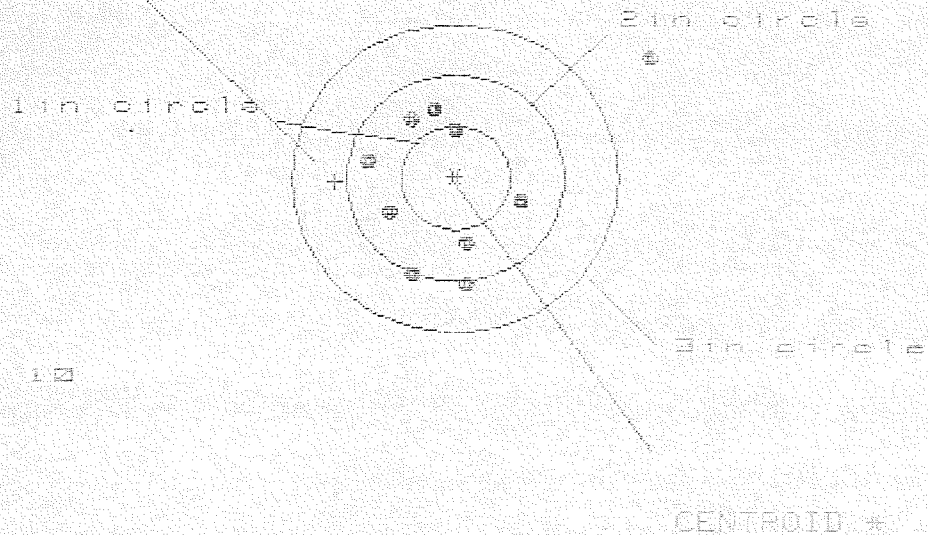
PATTERN #	4		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.897	.926	.929
MINIMUM X	-.989	-.778	-.683
MAXIMUM Y	.857	.789	.710
MINIMUM Y	-.618	-.632	-.669
CENTROID X	.929	.718	.815
CENTROID Y	-.255	-.187	-.188
POR TO CENTROID in.	.963	.742	.822
MIN RADIUS	.244	.458	.380
MEAN RADIUS	.865	.720	.671
MAX RADIUS	1.995	1.026	.956
HORIZONTAL SPREAD	2.886	1.704	1.512
VERTICAL SPREAD	1.475	1.421	1.379
EXTREME SPREAD	2.887	2.019	1.856
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		8	
NUMBER IN THREE INCH CIRCLE =		9	

5 Oct 1988

FILE: PATTERNING/CENTERFIRE_PATT/C8225476

CENTERFIRE PATTERNS # 5

POR



OF SHOTS- 10

IN CIR

1 in = 0

2 in = 9

3 in = 9

HS= 2.581

VS= 2.141

ES= 3.006

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.765	.780	.749
MINIMUM X	-.816	-.620	-.651
MAXIMUM Y	1.161	.760	.666
MINIMUM Y	-.980	-.051	-.945
CENTROID X	1.103	.987	.938
CENTROID Y	.027	-.162	-.003
POR TO CENTROID in.	1.104	.913	.938
MIN RADIUS	.501	.463	.529
MEAN RADIUS	.872	.703	.683
MAX RADIUS	2.112	.900	.981
HORIZONTAL SPREAD	2.581	1.400	1.400
VERTICAL SPREAD	2.141	1.611	1.611
EXTREME SPREAD	3.006	1.646	1.646
NUMBER IN ONE INCH CIRCLE	=	0	
NUMBER IN TWO INCH CIRCLE	=	9	
NUMBER IN THREE INCH CIRCLE	=	9	

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6225476

OP. #	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and Stock		2/12/92	RW
600	Proof		2/12/92	RW
607	Check Headspace		2/12/92	RW
610	Dis-assemble Gun		2/12/92	RW
612	Magnaflux Barrel Action			
	Magnaflux Bolt			
615	Rollmark Caliber			
617	Drill and Tap Sight Holes			
618	Polish Barrel			
620	Apply Coatings (Barrel Action)			
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly			
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head			
	C) Inspect Ejector Hole for Chamfer			
	D) Oil Firing Pin Ass'y			
	E) Adjust Trigger Pull to Min Setting and Stake			

op. #	BARBER - M24 0150760	READINGS					DATE	INIT
625 cont.	F) Safety On Force	3.5	4	4			2/26/92	RW
	G) Safety Off Force	2.5	2.5	2.5			2/26/92	RW
	H) Trigger Pull Test & Retainability							
	I) Firing Pin Indent	.0215	.022	.021			2/26/92	RW
	J) Assemble Stock							
	K) Assemble Swivel Studs							
	L) Attach Front and Rear Sight Assemblies							
	M) Iron Sight Alignment							
	N) Detach Front & Rear Sights & place in numbered container							
	O) Attach Scope to Rifle							
	P) Detach & Attach Scope 20 Times							
640	Gallery Target & Test						2-21-92	✓
	A) Time						2-21-92	✓
	B) Malfunctions						2-21-92	✓
	C) Pierced Primers						2-21-92	✓
	D) Optical Clarity of Scope						2-21-92	✓
645	Inspect for Live Ammo						2-21-92	✓
655	Final Inspection						2/26/92	RW
	A) Headspace						2/25/92	RW
	B) Trigger Pull	2.46	2.49	2.45	2.41	2.44	2/26/92	RW
	C) Function						2/26/92	RW
660	Pack							

(PLEASE PRINT CLEARLY)

RETURN:

☐ Clark Street Entrance☒ Via US Mail or UPS

FIREARMS DELIVERED TO PLANT

FILE NO. 006768

DATE 1/27/92

OWNER'S NAME: CPT M. K. STEPHENSON REMINGTON EMPLOYEE:

OWNER'S ADDRESS: Co D 2nd BN 1st SWTG YES ☐ NO ☐

FT. BRAGG, NC

EMPLOYEE # _____

DEPT. # _____

ZIP: 28307-5000

PHONE: (919) 396-7330

FIREARM MODEL: M24

CHECK FOR AMMUNITION ☒

GAUGE: 308

SERIAL # C6225476

CONDITION:

WOOD GOOD FAIR POOR FANCY PLAINMETAL GOOD FAIR POOR FANCY PLAINBARREL VT. RIB PLAIN DEER RSS

ACCESSORIES:

SCOPE: YES NO (BRAND NAME/POWER) _____SLING: YES NO GUN CASE: YES NO (HARD - SOFT)

EXTRA BBL FOR GUN MENTIONED ABOVE:

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

CUSTOMER REQUEST: RE BARREL - Replace present barrel.

SIGNATURE: [Signature]
(Person delivering firearm to Plant)

DATE: 27 JAN 92

SIGNATURE: [Signature]
(Security Officer)

DATE: 1/27/92

SIGNATURE: [Signature]
(Firearm picked up by)

DATE: 1-28-92

Arm Service Copy

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06225476
24 Feb 1992

CENTROIDAL DISTANCES

0 TO 1	.759023
1 TO 2	.557169
1 TO 3	.695012
1 TO 4	.935822
1 TO 5	.544538

σ^2 ← PDA

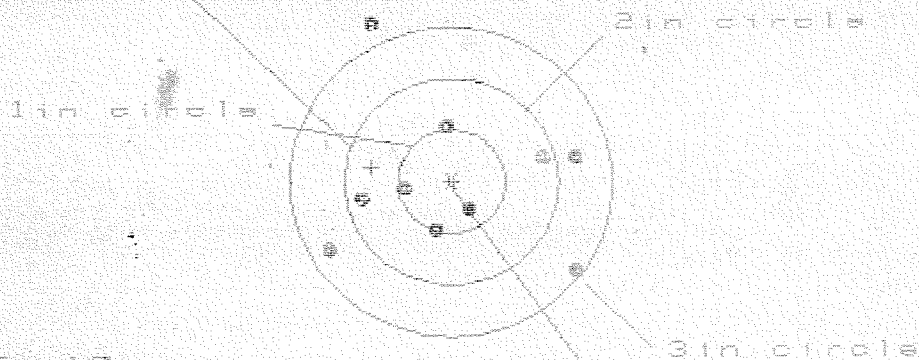
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .3466
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1926
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .396918
THE AMR FOR THIS RIFLE IS: .9414

24 Feb 1992

FILE:/PATTERNING/CENTERFIRE_PATT/08225476

CENTERFIRE PATTERNS # 1

POA



OF SHOTS= 10

IN CIR

1in = 2

2in = 6

3in = 9

HS= 2.373

VS= 2.472

GS= 3.154

PATTERN #

1

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.194	1.109	1.247
MINIMUM X	-1.179	-1.264	-1.126
MAXIMUM Y	1.573	.687	.597
MINIMUM Y	-.899	-.724	-.612
CENTROID X	.746	.831	.693
CENTROID Y	-.140	-.315	-.225
POA TO CENTROID in.	.759	.889	.728
MIN RADIUS	.289	.111	.275
MEAN RADIUS	.940	.830	.757
MAX RADIUS	1.750	1.368	1.291
HORIZONTAL SPREAD	2.373	2.373	2.373
VERTICAL SPREAD	2.472	1.411	1.209
EXTREME SPREAD	3.154	2.539	2.539
NUMBER IN ONE INCH CIRCLE	=	2	
NUMBER IN TWO INCH CIRCLE	=	6	
NUMBER IN THREE INCH CIRCLE	=	9	

24 Feb 1992

FILE:/PATTERNING/CENTERFIRE_PATT/CB225476

CENTERFIRE PATTERNS

2

POB

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS= 10

IN CIR

1 in = 2

2 in = 6

3 in = 10

HS= 2.286

VS= 2.161

GS= 2.776

PATTERN #

2

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.233

1.168

1.304

MINIMUM X

-1.053

-1.118

-.982

MAXIMUM Y

.794

.642

.694

MINIMUM Y

-1.367

-.586

-.586

CENTROID X

.587

.652

.516

CENTROID Y

.394

.546

.466

POB TO CENTROID in.

.707

.851

.696

MIN RADIUS

.282

.390

.233

MEAN RADIUS

.871

.809

.717

MAX RADIUS

1.489

1.263

1.343

HORIZONTAL SPREAD

2.286

2.286

2.286

VERTICAL SPREAD

2.161

1.228

1.200

EXTREME SPREAD

2.776

2.426

2.426

NUMBER IN ONE INCH CIRCLE =

2

NUMBER IN TWO INCH CIRCLE =

6

NUMBER IN THREE INCH CIRCLE =

10

24 Feb 1992

FILE:/PATTERNING/CENTERFIRE_PATT/C8235476

CENTERFIRE PATTERNS

3

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS- 10

IN CIR

1 in - 0

2 in - 5

3 in - 10

HS= 2.082

VS= 1.889

GS= 2.137

PATTERN #

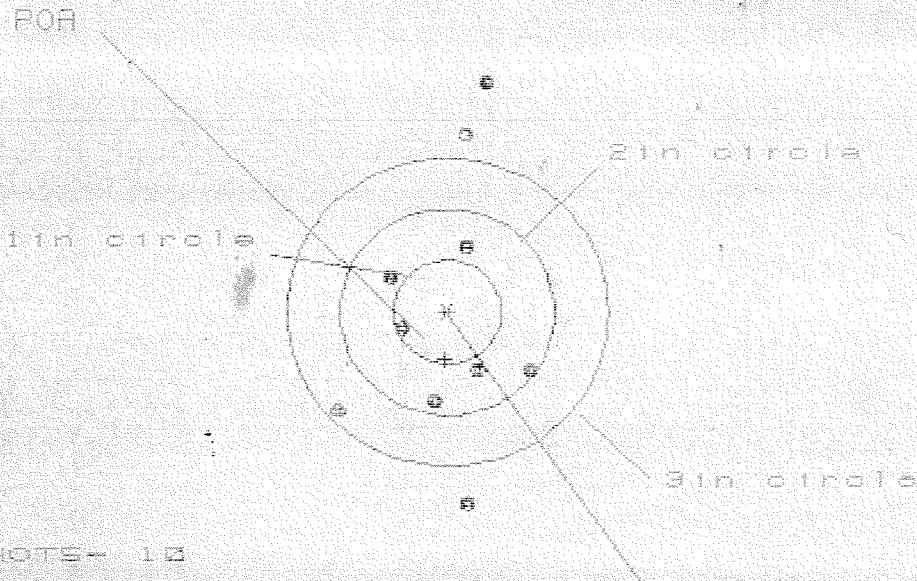
3

SHOTS (BEST OF)	10	9	8
MAXIMUM X	.952	1.047	.917
MINIMUM X	-1.129	-1.035	-.774
MAXIMUM Y	.800	.796	.826
MINIMUM Y	-1.089	-1.000	-.970
CENTROID X	.106	.012	.142
CENTROID Y	.131	.042	.012
POA TO CENTROID in.	.169	.043	.142
MIN RADIUS	.505	.453	.382
MEAN RADIUS	.916	.877	.846
MAX RADIUS	1.166	1.125	1.036
HORIZONTAL SPREAD	2.082	2.082	1.691
VERTICAL SPREAD	1.889	1.796	1.796
EXTREME SPREAD	2.137	2.137	1.983
NUMBER IN ONE INCH CIRCLE	= 0		
NUMBER IN TWO INCH CIRCLE	= 5		
NUMBER IN THREE INCH CIRCLE	= 10		

24 Feb 1992

FILE:/PATTERNING/CENTERFIRE_PATT/CG225476

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 7

HS= 1.781

VS= 4.184

GS= 4.189

CENTROID *

PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.797	.844	.877
MINIMUM X	-.984	-.937	-.904
MAXIMUM Y	2.203	2.022	1.816
MINIMUM Y	-1.901	-1.647	-1.947
CENTROID X	.027	-.020	-.053
CENTROID Y	.459	.205	.411
POA TO CENTROID in.	.459	.205	.414
MIN RADIUS	.433	.366	.341
MEAN RADIUS	1.160	.988	.907
MAX RADIUS	2.321	2.037	1.837
HORIZONTAL SPREAD	1.781	1.781	1.781
VERTICAL SPREAD	4.184	3.669	2.763
EXTREME SPREAD	4.189	3.669	3.005
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		7	

24 Feb 1992

FILE:/PATTERNING/CENTERFIRE_PATT/CG225476

CENTERFIRE PATTERNS

5

POA

1in circle

2in circle

3in circle

OF SHOTS= 10

IN CIR

1in = 3

2in = 7

3in = 9

HS= 2.700

VS= 1.821

GS= 2.932

CENTROID *

PATTERN #

5

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.257	.838	.675
MINIMUM X	-1.443	-1.303	-.767
MAXIMUM Y	.929	.579	.565
MINIMUM Y	-.891	-.788	-.802
CENTROID X	.267	.127	.290
CENTROID Y	.119	.016	.030
POA TO CENTROID in.	.292	.128	.291
MIN RADIUS	.266	.364	.298
MEAN RADIUS	.820	.740	.654
MAX RADIUS	1.564	1.308	1.048
HORIZONTAL SPREAD	2.700	2.141	1.442
VERTICAL SPREAD	1.821	1.367	1.367
EXTREME SPREAD	2.932	2.246	1.674
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		9	

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6225476
26 Feb 1992

CENTROIDAL DISTANCES

0 TO	1	.667659
1 TO	2	.666731
1 TO	3	.652798
1 TO	4	.795759
1 TO	5	.635813

0.2 - - - - - FOR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .2044
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.125
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .239592
THE AMR FOR THIS RIFLE IS: 1.289

26 Feb 1992

FILE: PATTERNING/CENTERFIRE PATT/C6225476.1

CENTERFIRE PATTERNS # 1

POA

1in circle

2in circle

3in circle

+ OF SHOTS- 10

IN CIR

1in = 1

2in = 3

3in = 7

HS= 3.485

VS= 2.957

CS= 3.857

CENTROID *

PATTERN #

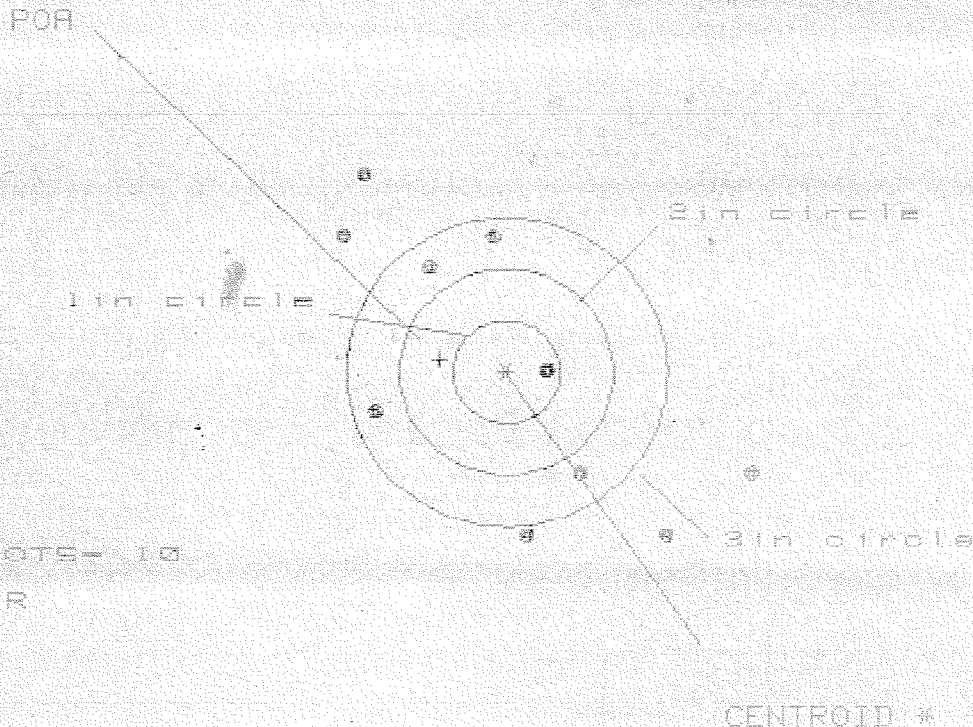
1

SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.360	1.505	1.421
MINIMUM X	:	-1.125	-0.863	-0.947
MAXIMUM Y	:	1.252	1.183	0.962
MINIMUM Y	:	-1.706	-1.774	-0.815
CENTROID X	:	.200	-0.062	.022
CENTROID Y	:	-.637	-.563	-.347
POA TO CENTROID in.	:	.667	.572	.347
MIN RADIUS	:	.322	.583	.559
MEAN RADIUS	:	1.316	1.172	1.062
MAX RADIUS	:	2.438	1.897	1.510
HORIZONTAL SPREAD	:	3.485	2.368	2.368
VERTICAL SPREAD	:	2.957	2.957	1.777
EXTREME SPREAD	:	3.857	3.186	2.696
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	3		
NUMBER IN THREE INCH CIRCLE	=	7		

26 Feb 1982

FILE: \PATTERNING\CENTERFIRE_PATT\CB225476.1

CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 1

3 in = 5

HS = 3.839

VS = 3.508

GS = 4.686

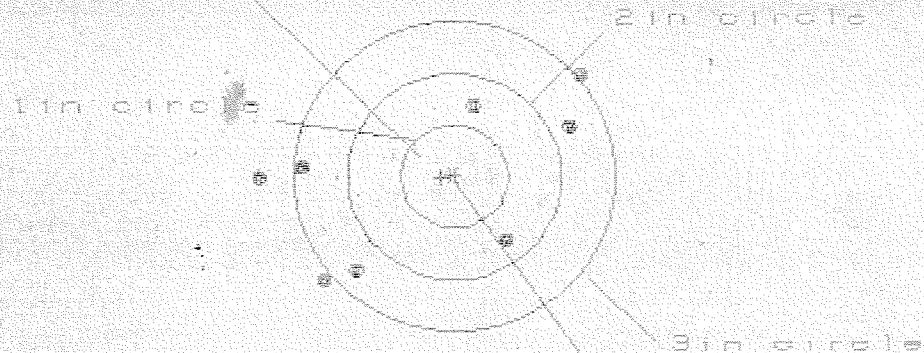
PATTERN #	2		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	2.300	1.699	1.561
MINIMUM X	-1.539	-1.284	-1.422
MAXIMUM Y	1.924	1.813	1.401
MINIMUM Y	-1.584	-1.695	-1.468
CENTROID X	.621	.366	.504
CENTROID Y	-.128	-.009	-.236
POA TO CENTROID in.	.633	.366	.557
MIN RADIUS	.335	.605	.460
MEAN RADIUS	1.586	1.472	1.375
MAX RADIUS	2.507	2.374	2.118
HORIZONTAL SPREAD	3.839	2.983	2.983
VERTICAL SPREAD	3.508	3.508	2.869
EXTREME SPREAD	4.686	4.464	4.113
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		1	
NUMBER IN THREE INCH CIRCLE =		5	

26 Feb 1992

FILE:/PATTERNING/CENTERFIRE_PATT/06225476.J

CENTERFIRE PATTERNS # 3

POR



OF SHOTS= 10

IN CIR

1in = 0

2in = 2

3in = 5

HS= 3.259

VS= 4.331

GS= 4.367

CENTROID #

PATTERN #	3	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.468	1.568	1.492
MINIMUM X	-1.791	-1.691	-1.495
MAXIMUM Y	2.377	1.212	1.000
MINIMUM Y	-1.954	-1.690	-0.997
CENTROID X	.121	.021	-.175
CENTROID Y	.011	-.254	-.042
POR TO CENTROID in.	.122	.254	.180
MIN RADIUS	.718	.686	.876
MEAN RADIUS	1.532	1.403	1.270
MAX RADIUS	2.543	2.306	1.797
HORIZONTAL SPREAD	3.259	3.259	2.987
VERTICAL SPREAD	4.331	2.902	1.997
EXTREME SPREAD	4.367	3.882	3.132
NUMBER IN ONE INCH CIRCLE	=	0	
NUMBER IN TWO INCH CIRCLE	=	2	
NUMBER IN THREE INCH CIRCLE	=	5	

26 Feb 1992

FILE: \PATTERNING\CENTERFIRE_PATT\08225476.1

CENTERFIRE PATTERNS # 4

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 3

2in = 7

3in = 10

HS= 2.153

VS= 1.264

GS= 2.217

PATTERN #	4		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.070	.948	.529
MINIMUM X	-1.093	-.939	-.821
MAXIMUM Y	.763	.707	.698
MINIMUM Y	-.501	-.465	-.474
CENTROID X	.007	.128	.010
CENTROID Y	.135	.191	.200
POA TO CENTROID IN.	.135	.230	.200
MIN RADIUS	.324	.206	.317
MEAN RADIUS	.713	.614	.604
MAX RADIUS	1.203	1.114	1.019
HORIZONTAL SPREAD	2.163	1.887	1.350
VERTICAL SPREAD	1.264	1.172	1.172
EXTREME SPREAD	2.217	1.969	1.521
NUMBER IN ONE INCH CIRCLE	= 3		
NUMBER IN TWO INCH CIRCLE	= 7		
NUMBER IN THREE INCH CIRCLE	= 10		

25 Feb 1992

FILE: \PATTERNING\CENTERFIRE_PATT\CG223476.J

CENTERFIRE PATTERNS # 5

POA

1 in circle

2 in circle

3 in circle

CENTROID #

OF SHOTS- 10

IN CIR

1 in = 1

2 in = 3

3 in = 5

HS= 2.705

VS= 3.381

GS= 3.996

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.344	1.491	1.387
MINIMUM X	-1.361	-1.214	-1.318
MAXIMUM Y	1.831	1.698	1.179
MINIMUM Y	-1.550	-1.347	-1.135
CENTROID X	.073	-.074	.030
CENTROID Y	-.014	-.217	-.429
POA TO CENTROID in.	.074	.229	.430
MIN RADIUS	.220	.402	.664
MEAN RADIUS	1.298	1.180	1.036
MAX RADIUS	2.256	1.888	1.821
HORIZONTAL SPREAD	2.705	2.705	2.705
VERTICAL SPREAD	3.381	3.045	2.314
EXTREME SPREAD	3.996	3.273	3.273
NUMBER IN ONE INCH CIRCLE	= 1		
NUMBER IN TWO INCH CIRCLE	= 3		
NUMBER IN THREE INCH CIRCLE	= 5		