

G 641 4416
Raphano
C. 622.5382

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: RE00144821

Serial: G6414416 Model M24 SWS Center Fire
Caliber: 7.62 NATO

Repairman:

Verify Repair

Status:

Closed 4/24/2008 10:57:26 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	Scope	1
A057	Fit and Rear Sgt Base	1

maglet

4/24/2008

12:24 PM

NUM



Serial Number: G6414416

Model: M24 SWS



RE00144821

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6414416.__0
FILE DATE AND TIME: 05/29/2008 08:55

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.021
The Average Y Centroid of the Five Target Set:	-0.064
The Average Point of Impact of the Five Target Set:	0.068
The Average Mean Radius of the Five Target Set:	0.648
The Distance from POA to Centroid Target #1:	0.147
The Distance from Centroid Target #2 to Centroid Target #1:	0.185
The Distance from Centroid Target #3 to Centroid Target #1:	0.050
The Distance from Centroid Target #4 to Centroid Target #1:	0.309
The Distance from Centroid Target #5 to Centroid Target #1:	0.061

SERIAL NUMBER: G6414416. 0

TARGET NUMBER: 1

FILE DATE: 05/29/2008

FILE TIME: 08:55

X CENTROID: -0.133

Y CENTROID: -0.062

POA TO CENTROID: 0.147

HORZ SPREAD: 1.259

VERT SPREAD: 1.933

GROUP SPREAD: 1.823

MIN RADIUS: 0.329

MAX RADIUS: 1.083

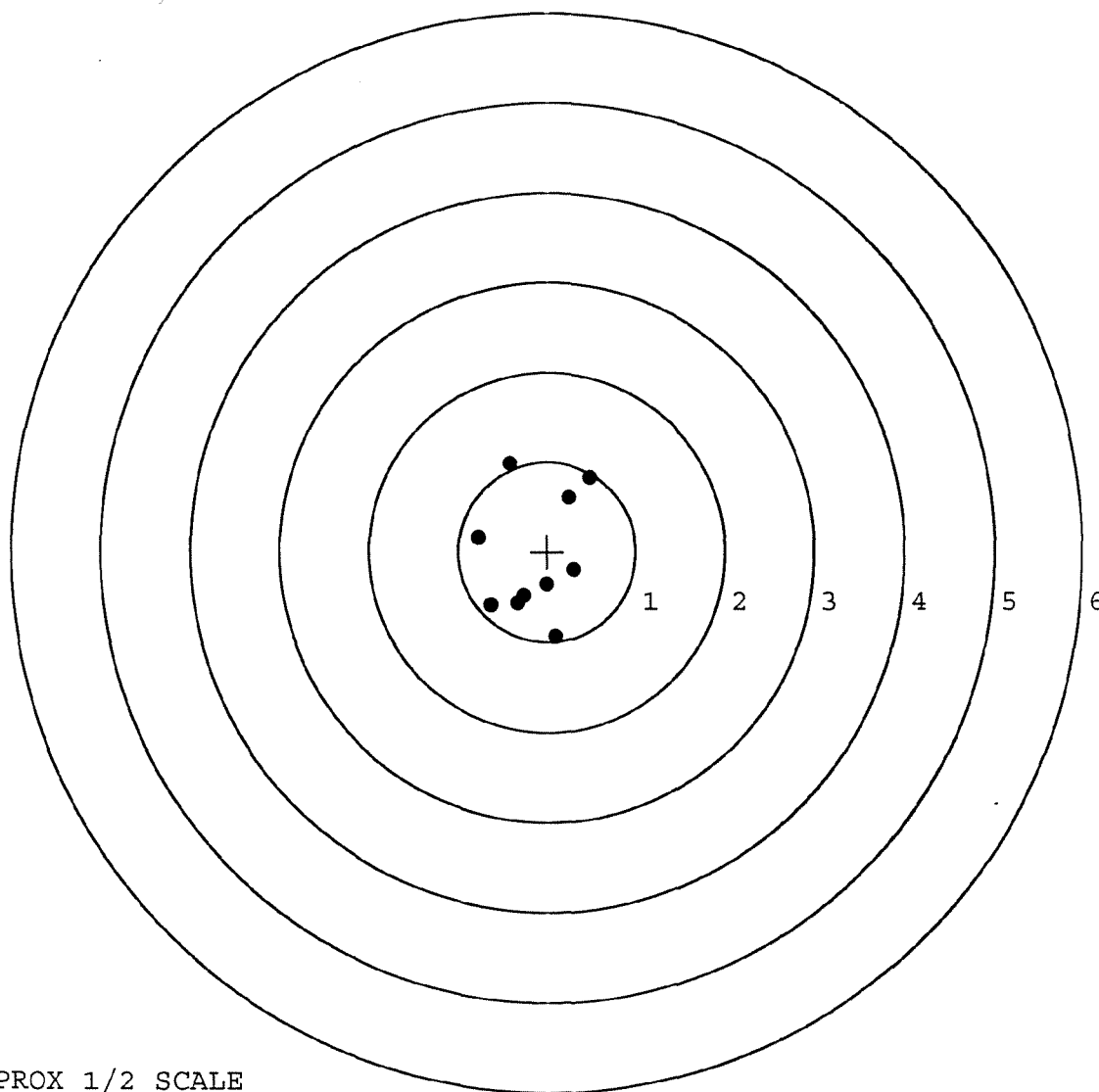
MEAN RADIUS: 0.705

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.090	-0.952
2:	0.306	-0.201
3:	-0.013	-0.368
4:	-0.273	-0.498
5:	-0.339	-0.576
6:	-0.634	-0.594
7:	-0.775	0.157
8:	0.484	0.828
9:	0.243	0.600
10:	-0.424	0.981



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6414416. 0

TARGET NUMBER: 2

FILE DATE: 05/29/2008

FILE TIME: 08:55

X CENTROID: 0.035

Y CENTROID: 0.014

POA TO CENTROID: 0.038

HORZ SPREAD: 1.088

VERT SPREAD: 1.406

GROUP SPREAD: 1.719

MIN RADIUS: 0.281

MAX RADIUS: 0.925

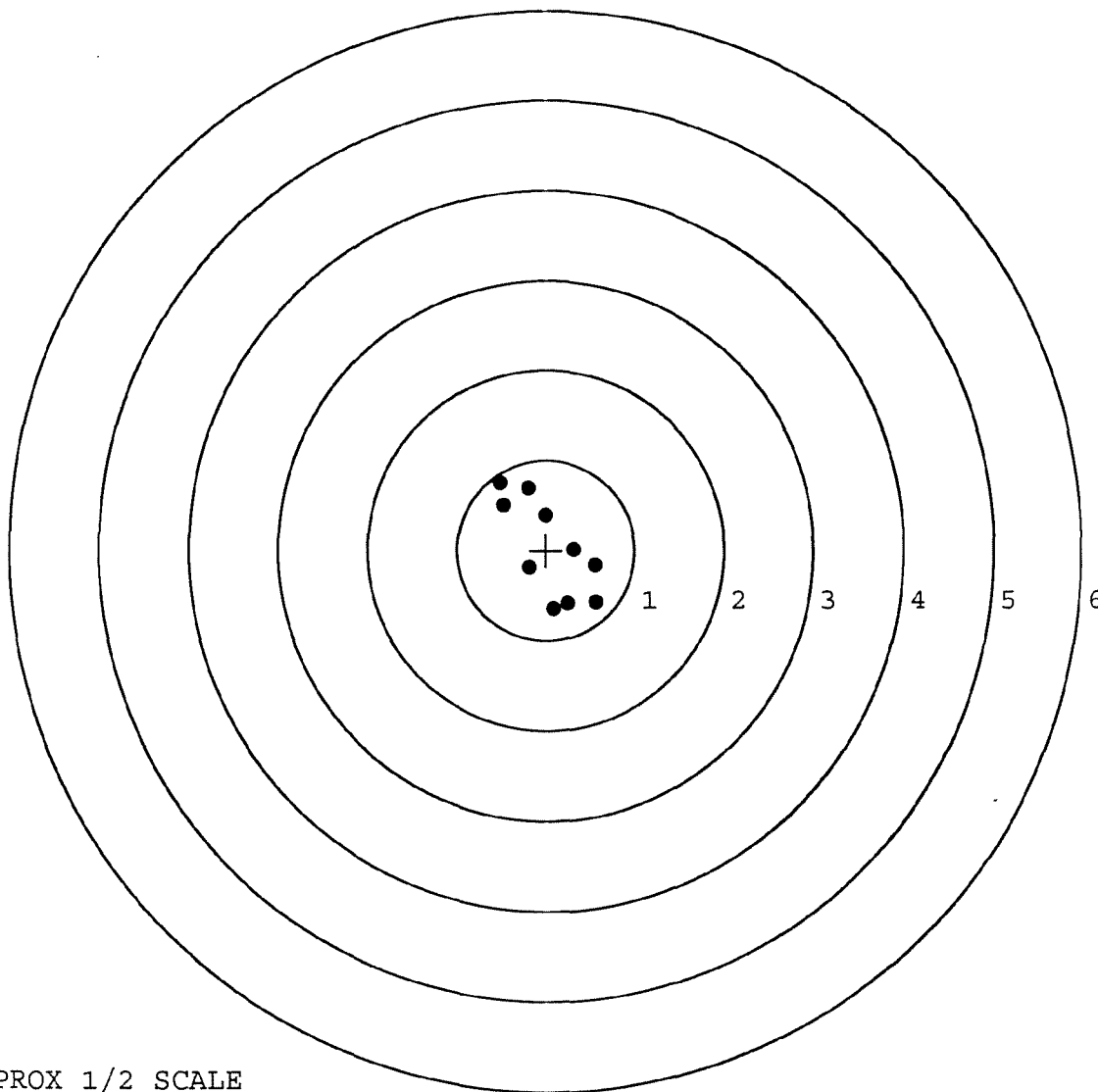
MEAN RADIUS: 0.599

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.564	-0.580
2:	0.243	-0.599
3:	0.083	-0.655
4:	0.557	-0.172
5:	0.316	0.009
6:	-0.187	-0.198
7:	-0.012	0.392
8:	-0.203	0.692
9:	-0.485	0.502
10:	-0.524	0.751



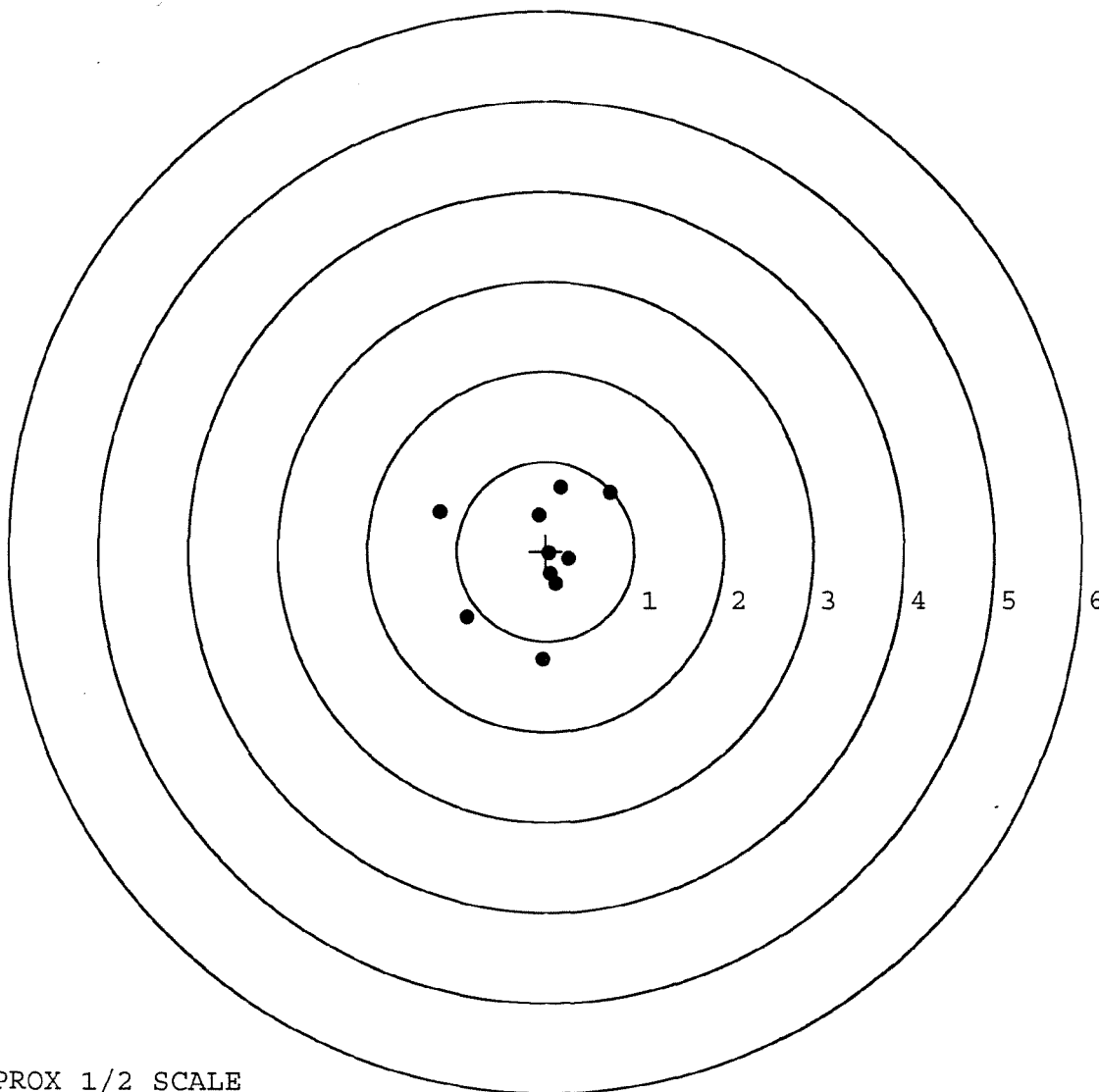
TARGET APPROX 1/2 SCALE

BARBER - M24 0151997

SERIAL NUMBER: G6414416. __0
 TARGET NUMBER: 3
 FILE DATE: 05/29/2008
 FILE TIME: 08:55

POINT#	X	Y
1:	0.725	0.657
2:	0.169	0.713
3:	-0.081	0.405
4:	-1.188	0.435
5:	-0.887	-0.738
6:	-0.040	-1.211
7:	0.112	-0.373
8:	0.034	-0.026
9:	0.254	-0.093
10:	0.049	-0.257

X CENTROID: -0.085
 Y CENTROID: -0.049
 POA TO CENTROID: 0.098
 HORZ SPREAD: 1.913
 VERT SPREAD: 1.924
 GROUP SPREAD: 2.007
 MIN RADIUS: 0.121
 MAX RADIUS: 1.204
 MEAN RADIUS: 0.685
 # IN 1 IN DIAMETER: 5
 # IN 2 IN DIAMETER: 6
 # in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6414416. __0

TARGET NUMBER: 4

FILE DATE: 05/29/2008

FILE TIME: 08:55

X CENTROID: 0.153

Y CENTROID: -0.179

POA TO CENTROID: 0.235

HORZ SPREAD: 1.786

VERT SPREAD: 1.412

GROUP SPREAD: 1.971

MIN RADIUS: 0.234

MAX RADIUS: 1.143

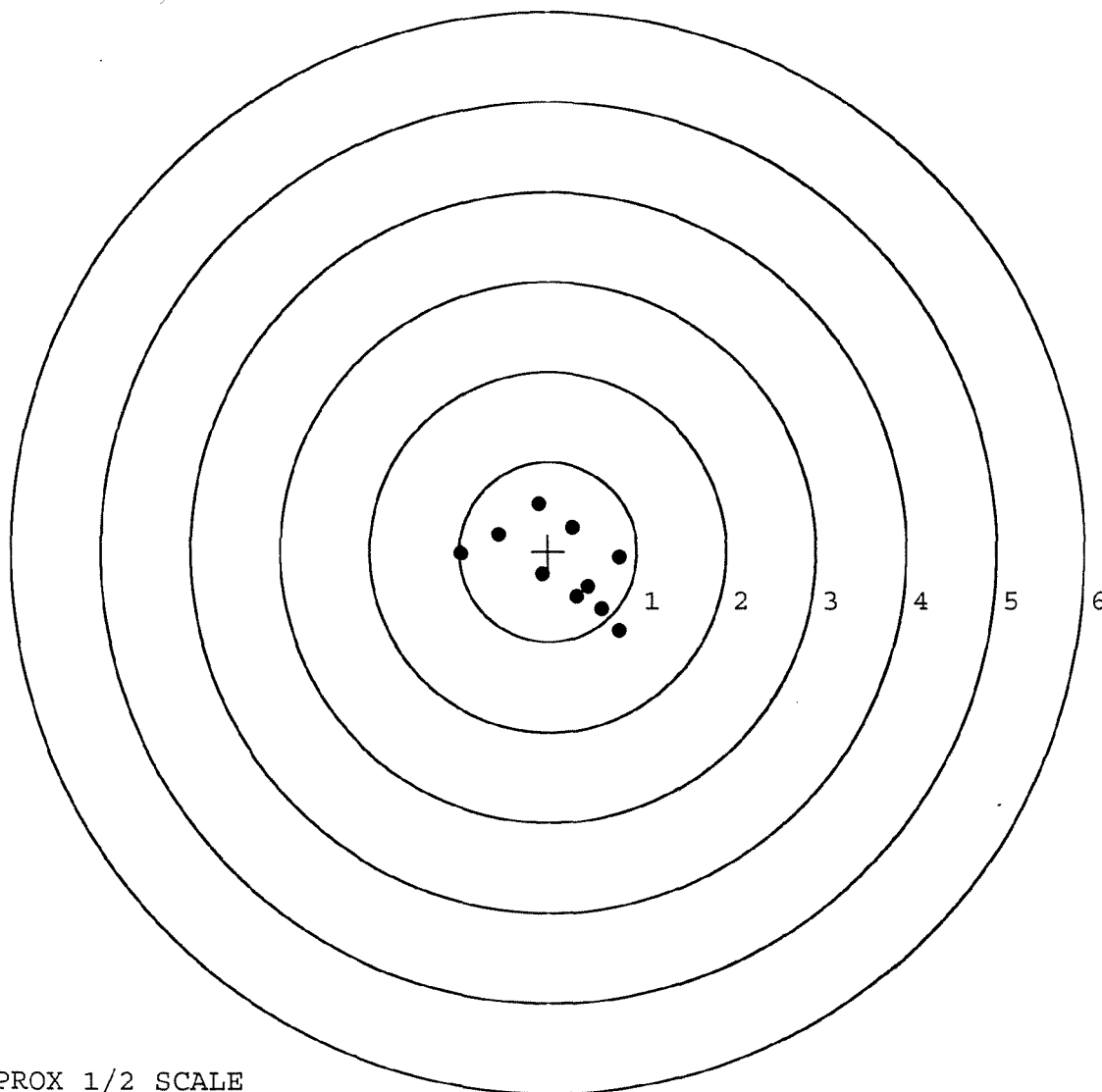
MEAN RADIUS: 0.640

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.797	-0.881
2:	0.806	-0.073
3:	0.272	0.269
4:	-0.068	-0.257
5:	-0.110	0.531
6:	-0.565	0.192
7:	-0.980	-0.028
8:	0.449	-0.392
9:	0.325	-0.504
10:	0.604	-0.645

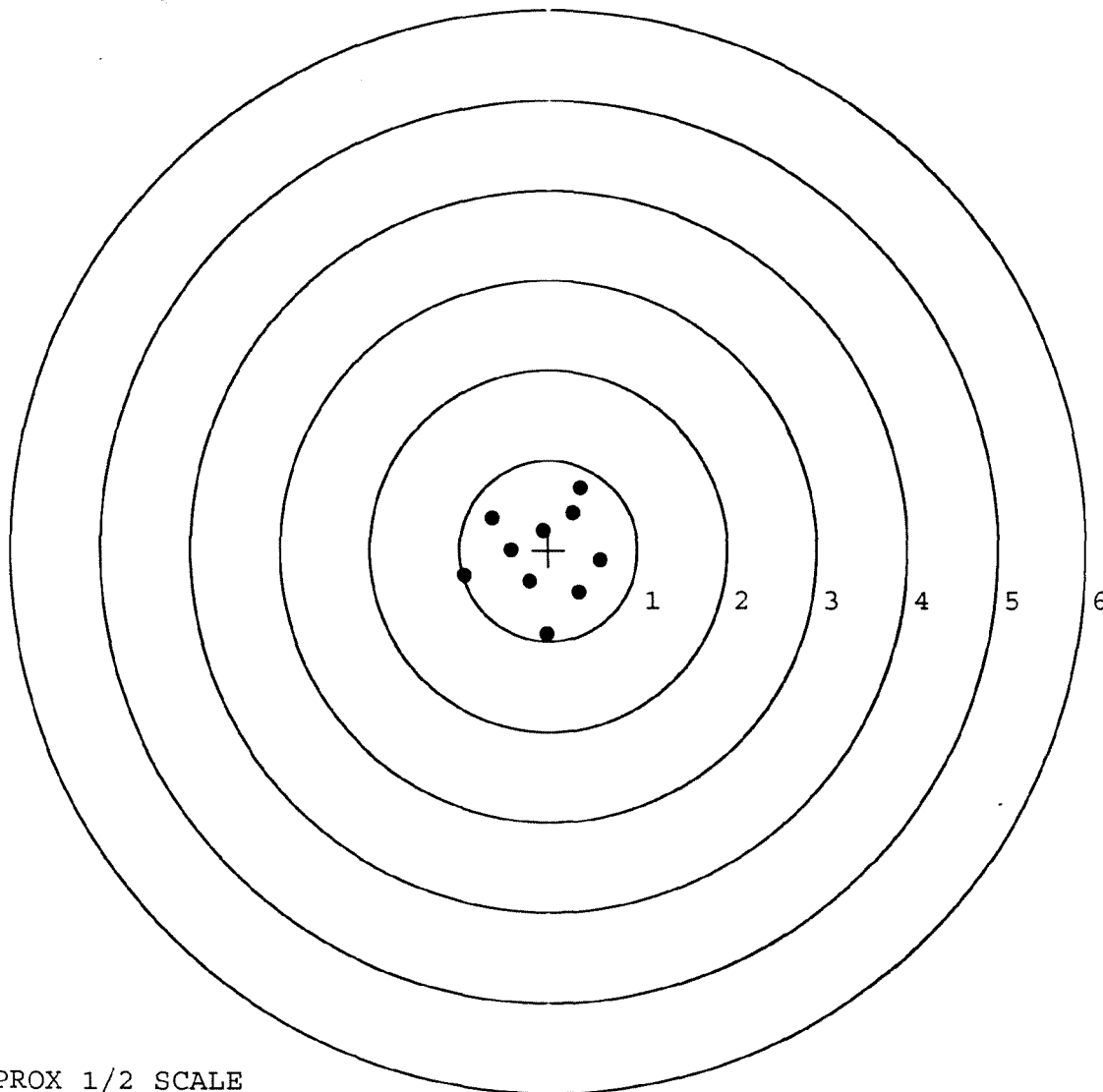


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6414416. __0
 TARGET NUMBER: 5
 FILE DATE: 05/29/2008
 FILE TIME: 08:55

POINT#	X	Y
1:	-0.021	-0.933
2:	0.344	-0.460
3:	0.585	-0.109
4:	-0.217	-0.348
5:	-0.425	-0.004
6:	-0.634	0.354
7:	-0.946	-0.284
8:	-0.065	0.220
9:	0.273	0.415
10:	0.356	0.699

X CENTROID: -0.075
 Y CENTROID: -0.045
 POA TO CENTROID: 0.087
 HORZ SPREAD: 1.531
 VERT SPREAD: 1.632
 GROUP SPREAD: 1.631
 MIN RADIUS: 0.265
 MAX RADIUS: 0.903
 MEAN RADIUS: 0.612
 # IN 1 IN DIAMETER: 3
 # IN 2 IN DIAMETER: 10
 # in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

R & B NUMBER

144821

SERIAL NUMBER

G6414416

LOG-IN DATE

4-24-08

OPERATION #	OPERATION NAME		DATE	INITIAL
500	DIS-ASSEMBLE GUN		4-28-08	RTZ
505	RE-BARREL			
560	ASSEMBLE		4-30-08	TRW
600	PROOF	MAGNA-FLUX	4-30-08	TRW
605	CHECK HEADSPACE	2100	4-30-08	TRW
610	DIS-ASSEMBLE GUN		4-30-08	P.P.D.
612	MAGNAFLUX	OPERATOR <i>unsub</i>	5/1/08	<i>unsub</i>
510	DRILL AND TAP		5-1-08	TRW
615	ROLLMARK CALIBER		5-1-08	CW
618	ROTO-BLAST		5-1-08	DG
620	APPLY COATINGS		5-5-08	CW
625	FINAL ASSEMBLY		5-27-08	RTZ
640	FUNCTION TEST AND	PASS FAIL	5-29-08	TRW
650	TARGET	PASS FAIL	5-29-08	TRW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
670	FINAL INSPECTION A) HEADSPACE	PASS FAIL	5/29/08 5/29/08 5/29/08	MED FM FM
	B) TRIGGER PULL	2.49 2.59 2.58 2.60 2.55	5-29-08	TRW
	C) SAFETY ON FORCE	6.5 6.5 6.5	5/29/08	FM
	D) SAFETY OFF FORCE	4.5 4.5 4.5	5/29/08	FM
	E) FIRING PIN INDENT	.022 .022 .023	5/29/08	FM
690	PACK		5/29/08	FM

Arms Services Repair & Estimate System

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

Repair Inquiry

Repair Number: **RE00092465** Serial: C6225382 Model: M24 SWS - Center Fire Caliber: 7.62 NATO Produced: 10/26/1988 Repairman: Status: Closed 2/4/2005 9:37:45 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	Front and Rear Sgt Base	1

Repair Search Refresh Close

maglett 2/7/2005 11:27 AM CAPS NUM INS SCPL

start 3 3

C6414416

C6225382

Serial Number: **C6225382**

Model: **M24 SWS**



RE00092465

INITIAL & CYCLE TESTS

2.50 LBS (plus or minus 0.50 LBS)

DATE

4-28-05

3.00 LBS (plus or minus 0.75 LBS)

TESTER

TRW

4.00 LBS (plus or minus 1.00 LBS)

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.37	2.90		2.43	
PULL #2	2.53	2.88		2.21	
PULL #3	2.32	2.73		2.57	
PULL #4	2.46	2.83		2.41	
PULL #5	2.55	2.65		2.50	
TOTAL	12.23	13.99		12.12	
AVERAGE	2.44	2.79		2.42	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.10	3.40		
PULL #2	3.48	3.13		
PULL #3	3.36	3.20		
PULL #4	3.42	3.26		
PULL #5	3.31	3.30		
TOTAL	16.67	16.29		
AVERAGE	3.33	3.25		

	4.00 LBS INITIAL	4.00 LBS AFTER 20 CYCLES	MAX SETTING GREATER THAN 4 LBS	RESET TO 4 LBS FOR TARGET & ACCURACY
PULL #1	4.19	4.05		4.03
PULL #2	4.31	4.25		4.04
PULL #3	4.15	4.18		4.08
PULL #4	4.04	4.22		4.10
PULL #5	4.04	4.21		4.25
TOTAL	20.73	20.91		20.50
AVERAGE	4.14	4.18		4.10

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6414416.___0
FILE DATE AND TIME: 05/03/2005 07:03

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.079
The Average Y Centroid of the Five Target Set:	-0.198
The Average Point of Impact of the Five Target Set:	0.213
The Average Mean Radius of the Five Target Set:	0.811
The Distance from POA to Centroid Target #1:	0.482
The Distance from Centroid Target #2 to Centroid Target #1:	0.626
The Distance from Centroid Target #3 to Centroid Target #1:	0.516
The Distance from Centroid Target #4 to Centroid Target #1:	0.799
The Distance from Centroid Target #5 to Centroid Target #1:	0.769

SERIAL NUMBER: G6414416. __0

TARGET NUMBER: 1

FILE DATE: 05/03/2005

FILE TIME: 07:03

X CENTROID: 0.438

Y CENTROID: 0.201

POA TO CENTROID: 0.482

HORZ SPREAD: 2.344

VERT SPREAD: 2.486

GROUP SPREAD: 2.919

MIN RADIUS: 0.574

MAX RADIUS: 1.683

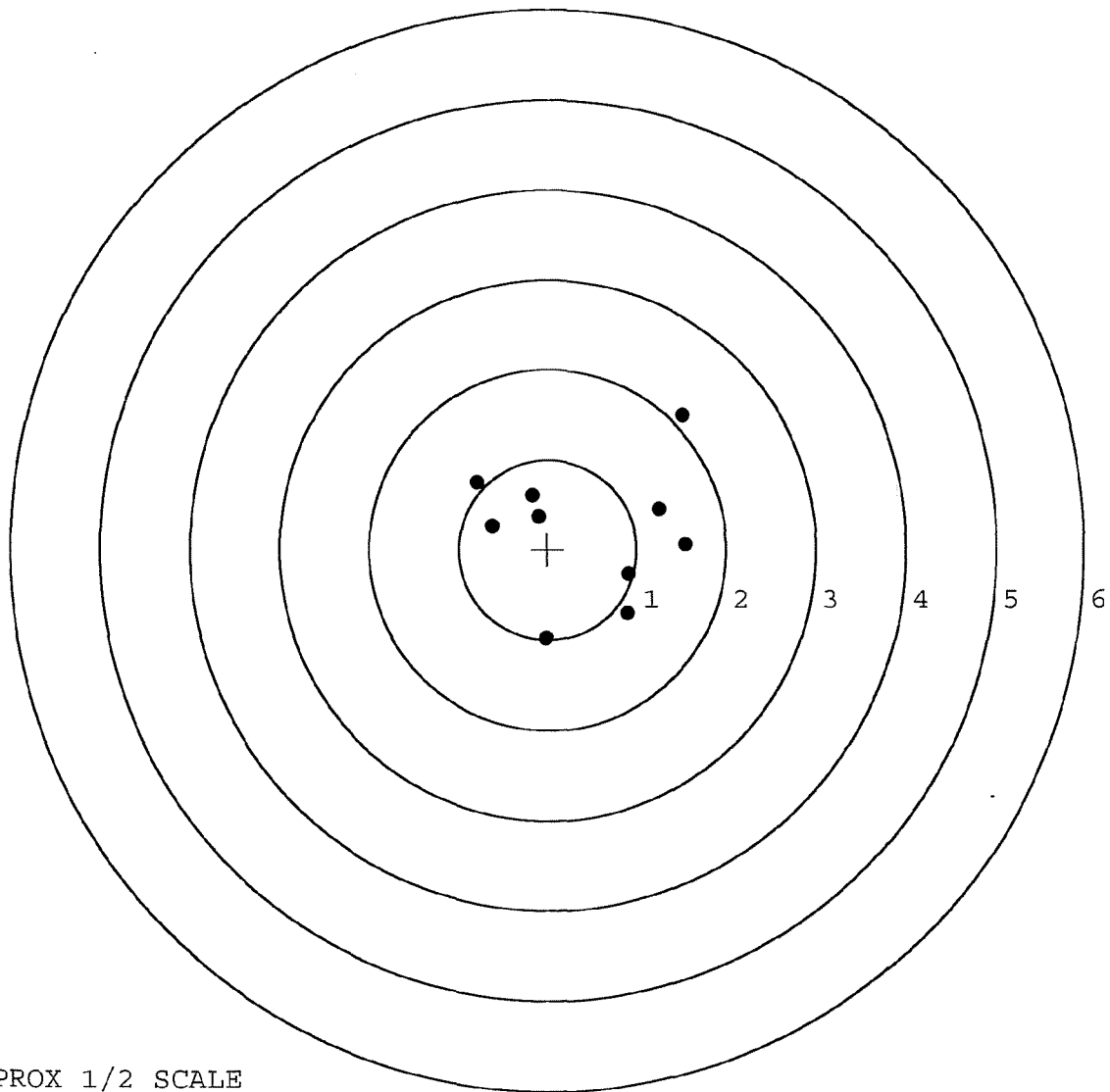
MEAN RADIUS: 1.035

IN 1 IN DIAMETER: 0

IN 2 IN DIAMETER: 4

in 3 IN DIAMETER: 9

POINT#	X	Y
1:	0.899	-0.711
2:	0.910	-0.280
3:	1.550	0.064
4:	1.248	0.447
5:	1.509	1.499
6:	-0.177	0.600
7:	-0.112	0.364
8:	-0.633	0.263
9:	-0.794	0.747
10:	-0.021	-0.987



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6414416. 0

TARGET NUMBER: 2

FILE DATE: 05/03/2005

FILE TIME: 07:03

X CENTROID: 0.108

Y CENTROID: -0.331

POA TO CENTROID: 0.349

HORZ SPREAD: 1.603

VERT SPREAD: 1.938

GROUP SPREAD: 1.949

MIN RADIUS: 0.264

MAX RADIUS: 1.132

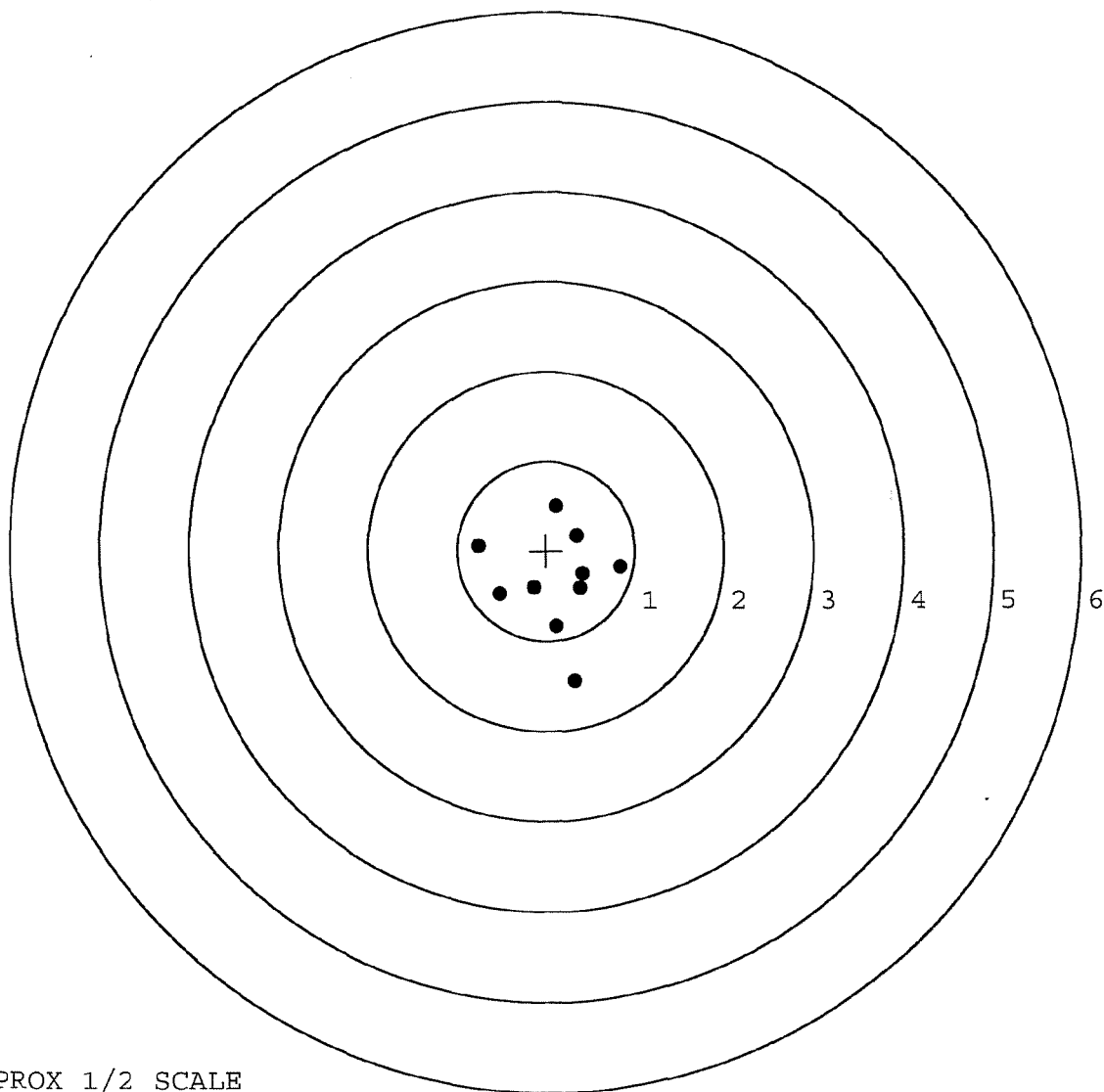
MEAN RADIUS: 0.625

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.321	-1.443
2:	0.107	-0.845
3:	0.384	-0.414
4:	0.407	-0.259
5:	0.838	-0.182
6:	-0.143	-0.414
7:	-0.532	-0.481
8:	0.353	0.170
9:	0.111	0.495
10:	-0.765	0.058



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6414416. 0

TARGET NUMBER: 3

FILE DATE: 05/03/2005

FILE TIME: 07:03

X CENTROID: 0.117

Y CENTROID: -0.203

POA TO CENTROID: 0.234

HORZ SPREAD: 1.075

VERT SPREAD: 1.764

GROUP SPREAD: 1.792

MIN RADIUS: 0.107

MAX RADIUS: 1.112

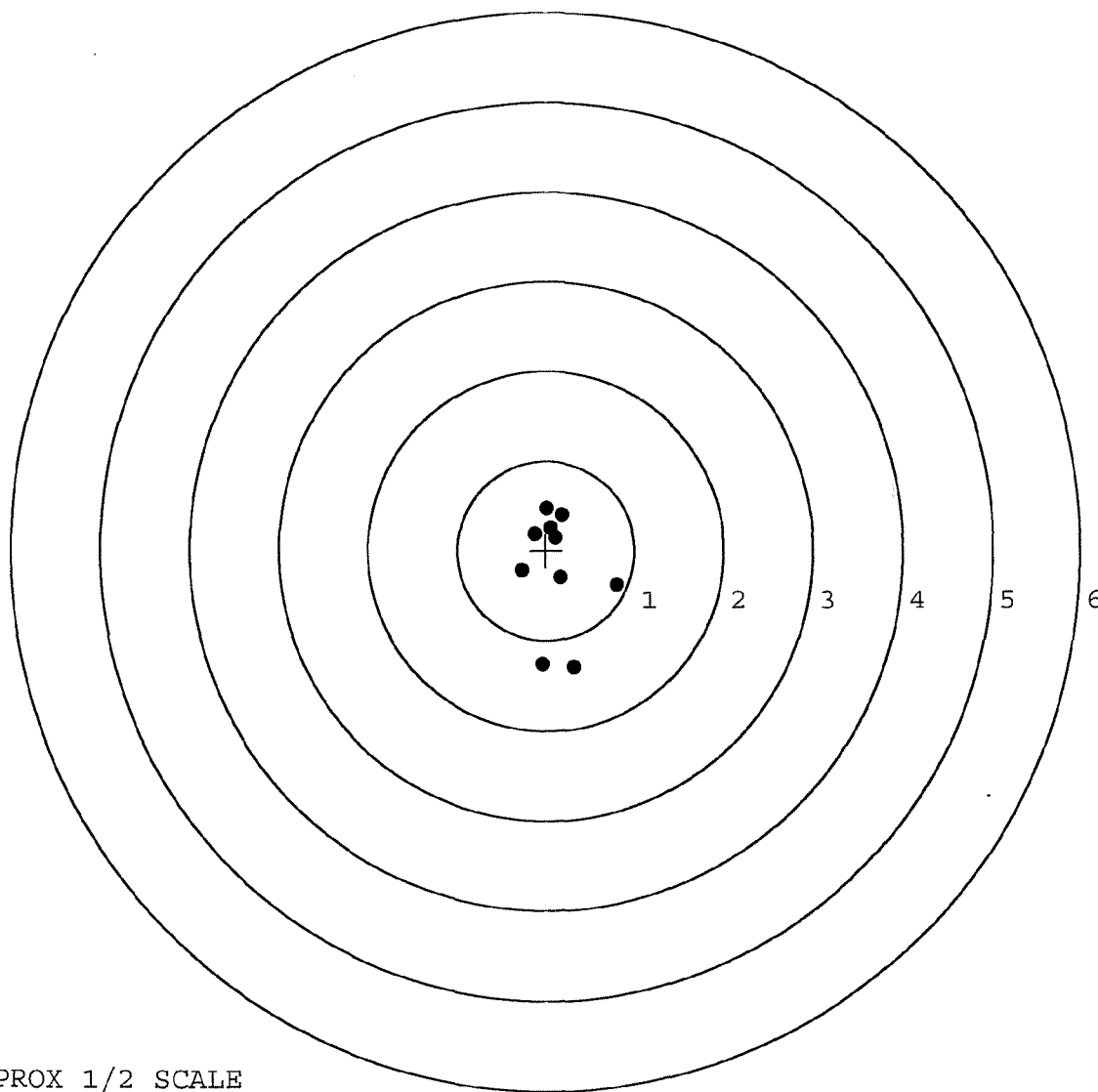
MEAN RADIUS: 0.595

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.319	-1.296
2:	-0.044	-1.273
3:	0.796	-0.382
4:	0.161	-0.300
5:	-0.279	-0.222
6:	0.178	0.397
7:	0.002	0.468
8:	0.108	0.146
9:	-0.127	0.181
10:	0.056	0.252



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6414416. 0

TARGET NUMBER: 4

FILE DATE: 05/03/2005

FILE TIME: 07:03

X CENTROID: -0.093

Y CENTROID: -0.397

POA TO CENTROID: 0.408

HORZ SPREAD: 2.113

VERT SPREAD: 2.170

GROUP SPREAD: 2.312

MIN RADIUS: 0.304

MAX RADIUS: 1.363

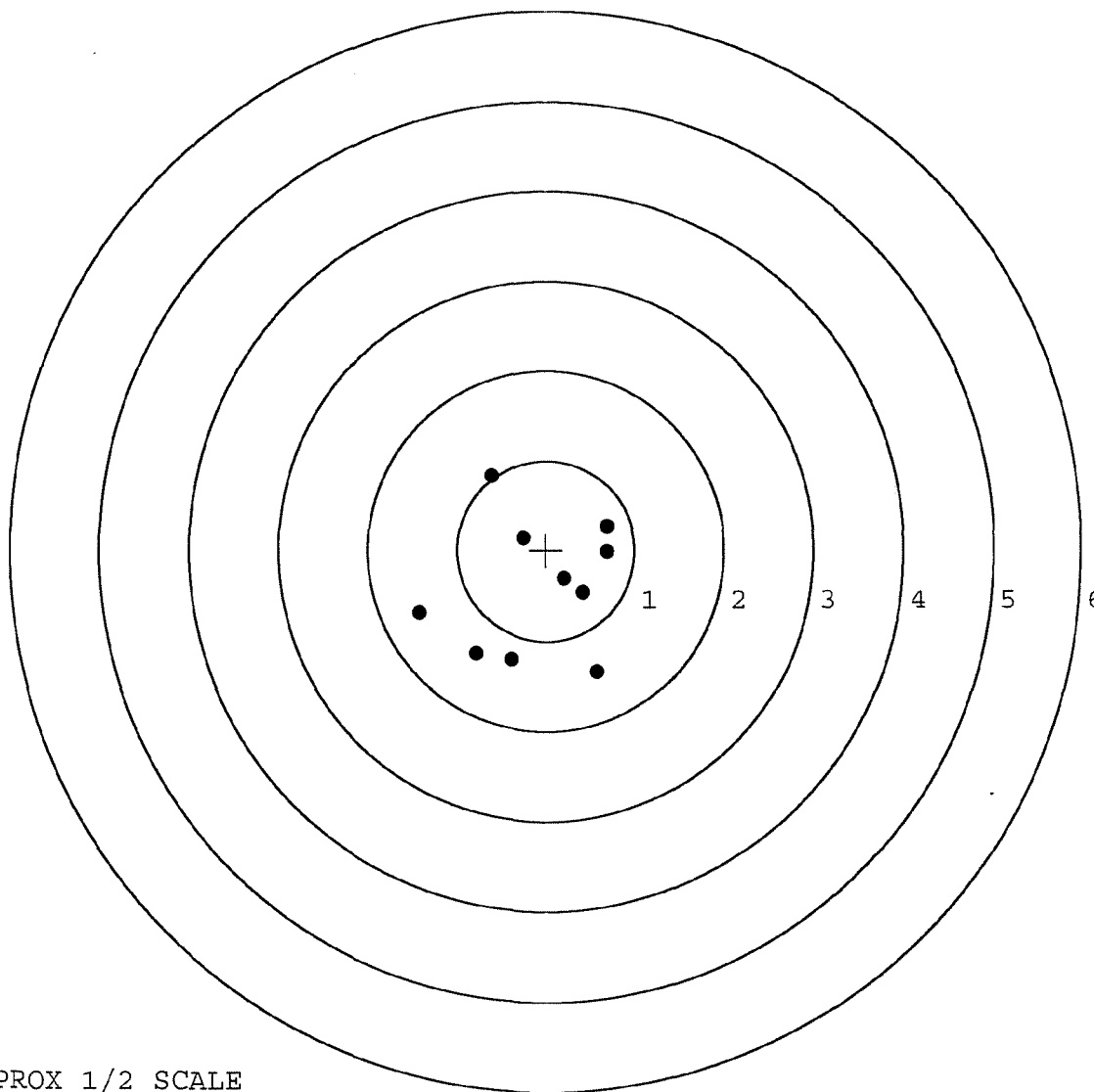
MEAN RADIUS: 0.900

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 5

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.568	-1.343
2:	-0.398	-1.210
3:	-0.792	-1.140
4:	-1.422	-0.696
5:	-0.615	0.827
6:	-0.254	0.135
7:	0.415	-0.472
8:	0.200	-0.315
9:	0.691	-0.020
10:	0.681	0.264



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6414416. 0

TARGET NUMBER: 5

FILE DATE: 05/03/2005

FILE TIME: 07:03

POINT#	X	Y
1:	-0.136	-2.018
2:	-0.172	-0.985
3:	0.339	-0.520
4:	-1.193	-0.671
5:	-1.218	-0.073
6:	-0.541	0.370
7:	0.378	-0.005
8:	0.026	0.319
9:	0.282	0.374
10:	0.469	0.599

X CENTROID: -0.177

Y CENTROID: -0.261

POA TO CENTROID: 0.315

HORZ SPREAD: 1.687

VERT SPREAD: 2.617

GROUP SPREAD: 2.686

MIN RADIUS: 0.577

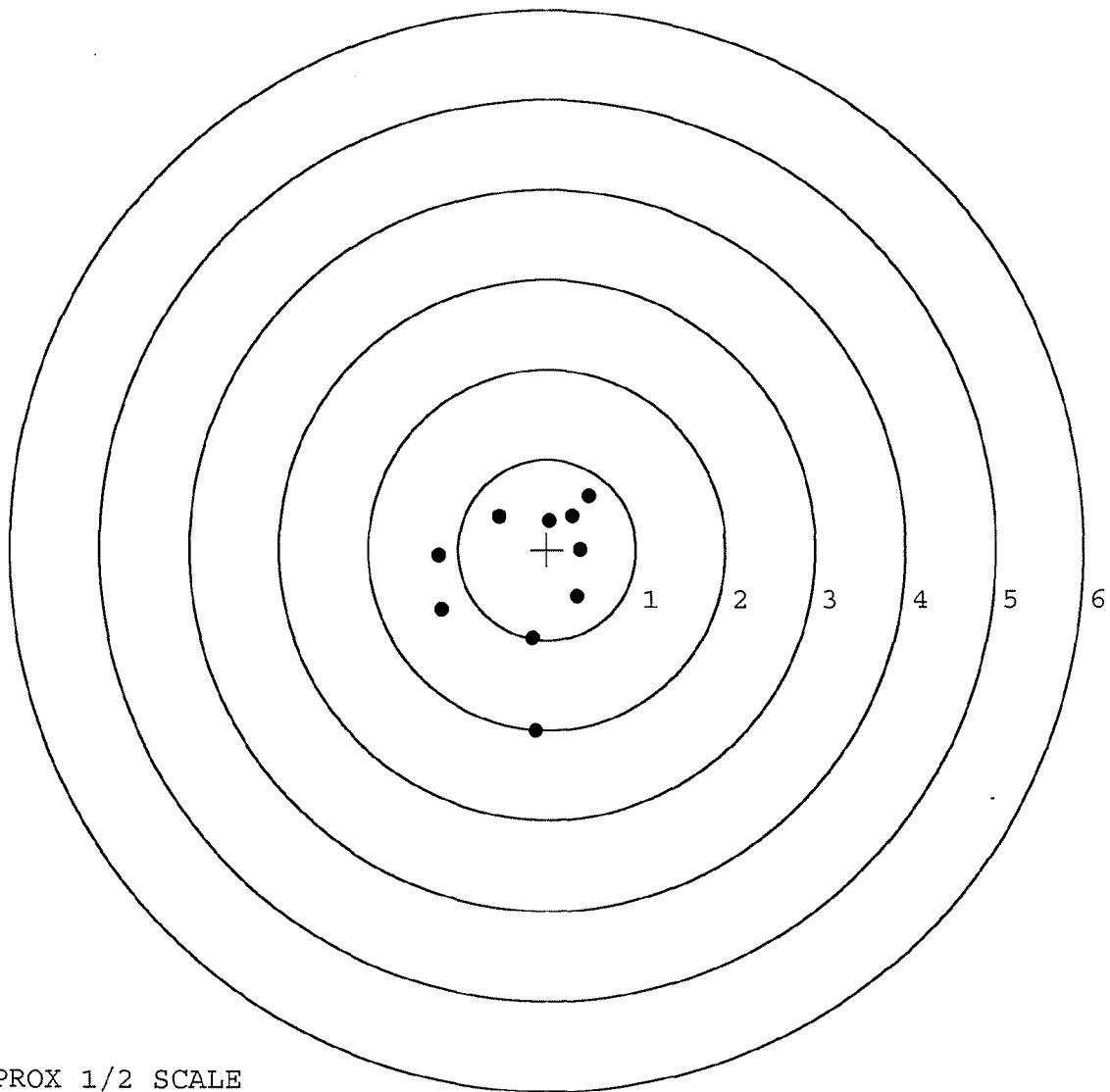
MAX RADIUS: 1.757

MEAN RADIUS: 0.903

IN 1 IN DIAMETER: 0

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

R & E NUMBER	92465		
SERIAL NUMBER	C6225382	C6414416 New	
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	TRW
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	4-12-05	BS
615	ROLLMARK CALIBER	4-12-05	CW
618	ROTO-BLAST	4-18-05	LB
620	APPLY COATINGS	4-25-05	WR
625 A	FINAL ASSEMBLY	4-29-05	RTZ
B	TRIGGER PULL TEST	5-9-05	TRW
C	SAFETY "ON" FORCE	5-9-05	AC
D	SAFETY "OFF" FORCE	5-9-05	AC
E	FIRING PIN INDENT	5-9-05	AC
640	TARGET	5-2-05	TRW
655	FINAL INSPECT	5-9-05	AC
660	PACK	5-10-05	DA
		SHIP DATE	
		QAR INSPECTION DATE	

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06225382

CENTROIDAL DISTANCES

0 TO	1	1.13567
1 TO	2	.901619
1 TO	3	.386956
1 TO	4	.657682
1 TO	5	1.13006

5
T2 3 ----POA
4 1

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .6084
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1434
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .625071
THE AMR FOR THIS RIFLE IS: .9264

6 Oct 1988

FILE:/PATTERNING/CENTERFIRE_PATT/0602253B2

CENTERFIRE PATTERNS # 1

POR

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS = 10

IN CIR

1in = 5

2in = 8

3in = 9

HE = 1.472

VS = 2.977

GS = 2.989

PATTERN #

1

SHOTS (BEST OF)

10

9

8

MAXIMUM X

.896

.873

.812

MINIMUM X

-.576

-.599

-.660

MAXIMUM Y

1.622

.586

.359

MINIMUM Y

-1.355

-1.175

-.165

CENTROID X

1.044

1.067

1.128

CENTROID Y

-.447

-.627

-.480

POR TO CENTROID in.

1.136

1.237

1.226

MIN RADIUS

.272

.210

.296

MEAN RADIUS

.694

.593

.488

MAX RADIUS

1.634

1.274

.828

HORIZONTAL SPREAD

1.472

1.472

1.472

VERTICAL SPREAD

2.977

1.681

.524

EXTREME SPREAD

2.989

1.846

1.472

NUMBER IN ONE INCH CIRCLE =

5

NUMBER IN TWO INCH CIRCLE =

8

NUMBER IN THREE INCH CIRCLE =

9

6 Oct 1988

FILE:/PATTERNING/CENTERFIRE_PATT/08225382

CENTERFIRE PATTERNS # 2

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS= 10

IN CIR

1 in = 3

2 in = 8

3 in = 9

HS= 2.898

VS= 1.693

GS= 2.974

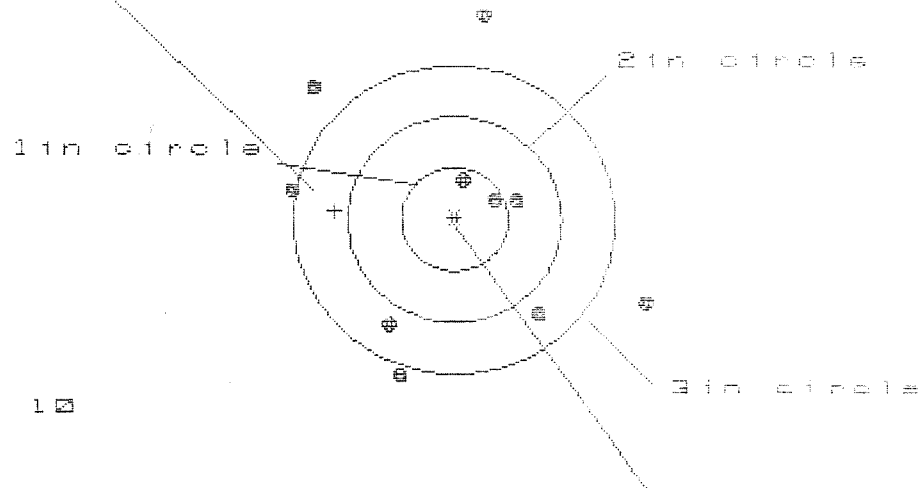
PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.366	1.218	.861
MINIMUM X	:	-1.332	-1.006	-.854
MAXIMUM Y	:	.829	.915	.865
MINIMUM Y	:	-.864	-.778	-.828
CENTROID X	:	.234	.382	.230
CENTROID Y	:	-.051	-.137	-.087
POA TO CENTROID in.	:	.240	.406	.246
MIN RADIUS	:	.333	.237	.296
MEAN RADIUS	:	.808	.713	.634
MAX RADIUS	:	1.539	1.280	.877
HORIZONTAL SPREAD	:	2.698	2.224	1.715
VERTICAL SPREAD	:	1.693	1.693	1.693
EXTREME SPREAD	:	2.974	2.312	1.715
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	

6 Oct 1988

FILE:/PATTERNING/CENTERFIRE_PATT/062253B2

CENTERFIRE PATTERNS # 3

POA



OF SHOTS = 10

IN CIR

1 in = 2

2 in = 3

3 in = 5

HS = 3.249

VS = 3.531

GS = 3.744

CENTROID #

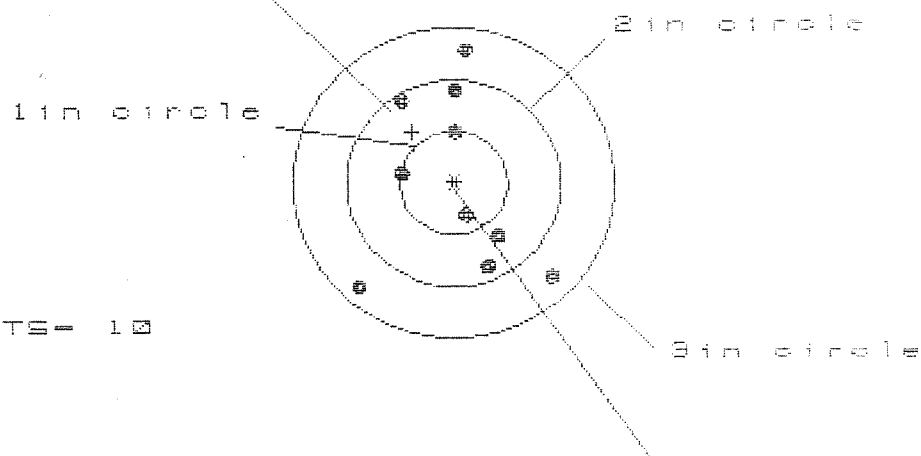
PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.775	1.868	1.079
MINIMUM X	:	-1.474	-1.441	-1.215
MAXIMUM Y	:	2.031	1.515	1.442
MINIMUM Y	:	-1.500	-1.275	-1.348
CENTROID X	:	1.120	1.087	.861
CENTROID Y	:	-.088	-.313	-.240
POA TO CENTROID in.	:	1.123	1.131	.894
MIN RADIUS	:	.355	.569	.610
MEAN RADIUS	:	1.273	1.194	1.117
MAX RADIUS	:	2.053	1.991	1.793
HORIZONTAL SPREAD	:	3.249	3.249	2.294
VERTICAL SPREAD	:	3.531	2.798	2.798
EXTREME SPREAD	:	3.744	3.744	3.091
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		5	

6 Oct 1988

FILE:/PATTERNING/CENTERFIRE_PATT/08225382

CENTERFIRE PATTERNS # 4

POA



OF SHOTS- 10

IN CIR

1in = 1

2in = 7

3in = 10

HS= 1.783

VS= 2.265

GS= 2.474

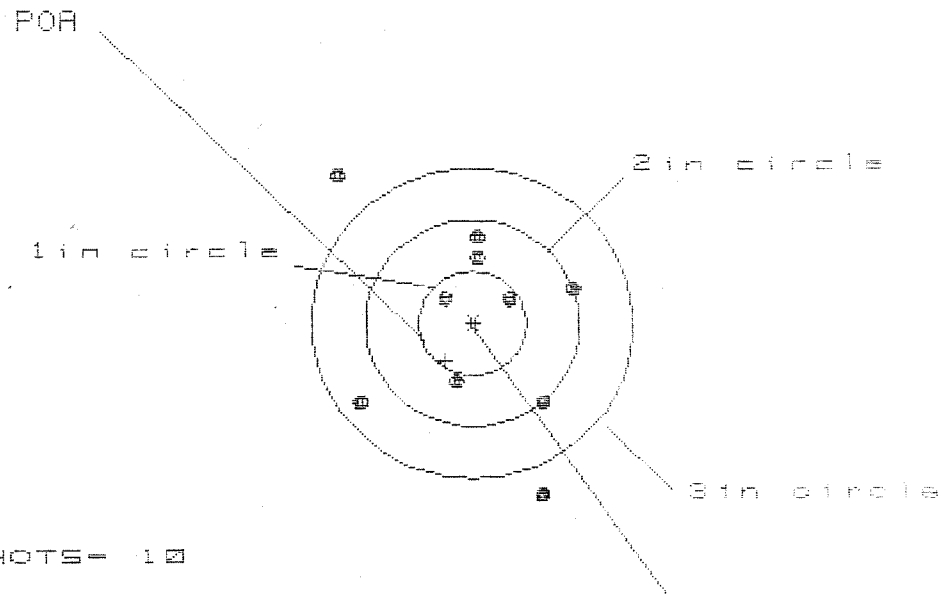
CENTROID #

PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.889	.790	.790
MINIMUM X	-.894	-.618	-.618
MAXIMUM Y	1.285	1.176	.919
MINIMUM Y	-.980	-1.037	-.890
CENTROID X	.388	.487	.487
CENTROID Y	-.494	-.385	-.532
POA TO CENTROID in.	.628	.621	.722
MIN RADIUS	.370	.416	.310
MEAN RADIUS	.873	.817	.760
MAX RADIUS	1.327	1.303	1.190
HORIZONTAL SPREAD	1.783	1.408	1.408
VERTICAL SPREAD	2.265	2.213	1.809
EXTREME SPREAD	2.474	2.349	2.203
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	10		

5 Oct 1988

FILE:/PATTERNING/CENTERFIRE_PATT/06225382

CENTERFIRE PATTERNS # 5



OF SHOTS - 10

IN CIR

1 in = 2

2 in = 5

3 in = 8

HS = 2.199

VS = 3.174

GS = 3.690

CENTROID *

PATTERN #	5	5	5
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.963	.825	.889
MINIMUM X	-1.236	-1.184	-1.120
MAXIMUM Y	1.480	.962	.771
MINIMUM Y	-1.694	-1.530	-1.808
CENTROID X	.256	.394	.330
CENTROID Y	.363	.199	.390
POA TO CENTROID in.	.444	.441	.511
MIN RADIUS	.371	.472	.361
MEAN RADIUS	.984	.884	.753
MAX RADIUS	1.928	1.612	1.381
HORIZONTAL SPREAD	2.199	2.009	2.009
VERTICAL SPREAD	3.174	2.492	1.579
EXTREME SPREAD	3.690	2.574	2.289
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	8		

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6225382

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		JUL 29 1991	dw
600	Proof		JUL 29 1991	dw
607	Check Headspace		JUL 29 1991	dw
610	Dis-assemble Gun		JUL 29 1991	dw
612	Magnaflux Barrel Action		JUL 30 1991	KCD
	Magnaflux Bolt		JUL 30 1991	KCD
615	Rollmark Caliber		JUL 30 1991	CS
617	Drill and Tap Sight Holes		JUL 30 1991	FB
618	Polish Barrel		JUL 31 1991	WB
620	Apply Coatings (Barrel Action)		AUG 1 1991	TTA
	Apply Coating (Bolt)		AUG 1 1991	TTA
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			

BARBER - M24 0152017		READINGS					DATE	INIT
op. #	OP. NAME							
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						7-25-91	D/H
	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						7-24-91	D/H
	A) Time						7-24-91	D/H
	B) Malfunctions						7-24-91	D/H
	C) Pierced Primers						7-24-91	D/H
	D) Optical Clarity of Scope						7-24-91	D/H
645	Inspect for Live Ammo						7-24-91	D/H
655	Final Inspection							
	A) Headspace						7-25-91	D/H
	B) Trigger Pull	2.65	2.54	2.53	2.58	2.52	9/24/91	RW
	C) Function						7-25-91	D/H
660	Pack						9/25/91	WB

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6225382
24 Sep 1991

CENTROIDAL DISTANCES

0 TO 1	.302703
1 TO 2	.38266
1 TO 3	.455089
1 TO 4	.326221
1 TO 5	.0936002

25 <---POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.192
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1742
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .259246
THE AMR FOR THIS RIFLE IS: 1.03

24 Sep 1991 FILE:/PATTERNING/CENTERFIRE_PATT/CG2253B2

CENTERFIRE PATTERNS # 1

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 2

2in = 4

3in = 6

HSE= 2.088

VSE= 3.826

ESE= 3.831

PATTERN # :

10

SHOTS (BEST OF) :

10

9

8

MAXIMUM X :

1.325

1.341

1.385

MINIMUM X :

-.763

-.747

-.703

MAXIMUM Y :

1.846

1.626

1.667

MINIMUM Y :

-1.980

-1.131

-.927

CENTROID X :

-.102

-.118

-.162

CENTROID Y :

-.285

-.065

-.269

POA TO CENTROID in. :

.303

.135

.314

MIN RADIUS :

.349

.443

.296

MEAN RADIUS :

1.151

1.074

.949

MAX RADIUS :

1.984

1.665

1.667

HORIZONTAL SPREAD :

2.088

2.088

2.088

VERTICAL SPREAD :

3.826

2.757

2.594

EXTREME SPREAD :

3.831

2.970

2.769

NUMBER IN ONE INCH CIRCLE =

2

NUMBER IN TWO INCH CIRCLE =

4

NUMBER IN THREE INCH CIRCLE =

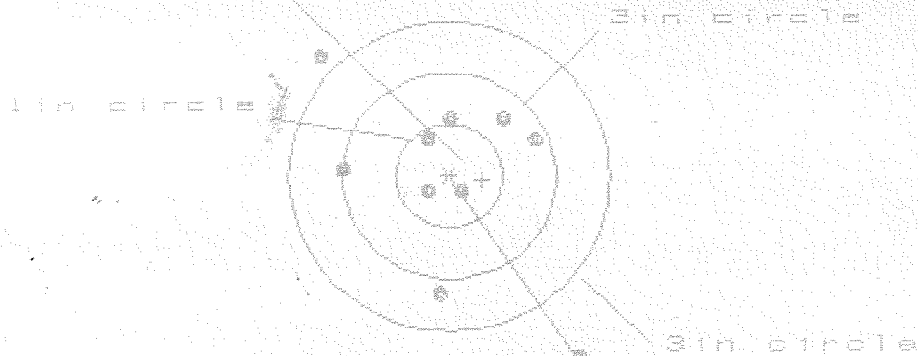
6

24 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/CG225382

CENTERFIRE PATTERNS # 2

POA



OF SHOTS= 10

IN CIR

1in = 3

2in = 4

3in = 8

CENTROID *

HE= 2.282

VS= 2.891

CS= 3.746

PATTERN #

2

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.207	.963	.832
MINIMUM X	-1.175	-1.041	-.982
MAXIMUM Y	1.135	.940	.519
MINIMUM Y	-1.756	-1.344	-1.226
CENTROID X	-.304	-.439	-.308
CENTROID Y	.040	.235	.117
POA TO CENTROID in.	.307	.497	.330
MIN RADIUS	.163	.213	.218
MEAN RADIUS	.907	.747	.656
MAX RADIUS	2.130	1.403	1.228
HORIZONTAL SPREAD	2.382	2.004	1.814
VERTICAL SPREAD	2.891	2.284	1.745
EXTREME SPREAD	3.746	2.537	1.848
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	8		

24 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/UG225382

CENTERFIRE PATTERNS # 3

POA

2in circle

3in circle

3in circle

OF SHOTS = 10

IN CIR

1in = 2

2in = 4

3in = 8

HS = 2.573

VS = 2.962

GS = 3.543

CENTROID #

PATTERN #

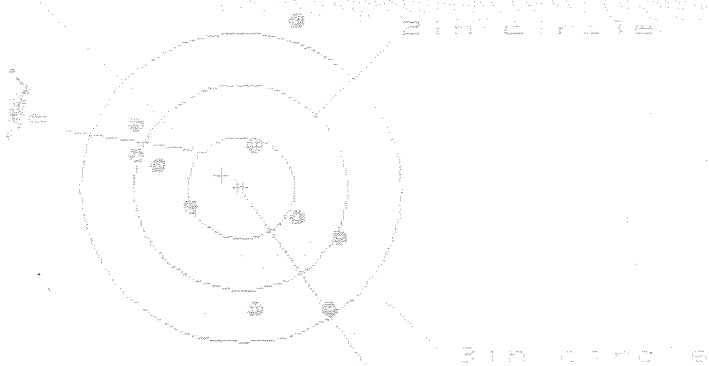
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.013	.840	.611
MINIMUM X	-1.660	-1.833	-1.350
MAXIMUM Y	1.269	1.081	1.028
MINIMUM Y	-1.693	-1.188	-1.243
CENTROID X	-.557	-.384	-.155
CENTROID Y	-.276	-.088	-.033
POA TO CENTROID in.	.621	.394	.158
MIN RADIUS	.358	.208	.172
MEAN RADIUS	1.095	.891	.733
MAX RADIUS	2.299	1.885	1.244
HORIZONTAL SPREAD	2.673	2.673	.961
VERTICAL SPREAD	2.962	2.269	2.269
EXTREME SPREAD	3.540	2.705	2.275
NUMBER IN ONE INCH CIRCLE	=	2	
NUMBER IN TWO INCH CIRCLE	=	4	
NUMBER IN THREE INCH CIRCLE	=	8	

24 Sep 1951

FILE: PATTERNING/CENTERFIRE_PATT/06225362

CENTERFIRE PATTERNS # 4

FOR



* OF SHOTS - 10

IN. CIR

1st - 1

2nd - 5

3rd - 2

X-CO = 1.521

Y-CO = 2.637

R-CO = 2.958

CENTROID *

PATTERN

SHOTS (BEST OF)

	10	9	8
MAXIMUM X	.964	1.019	1.128
MINIMUM X	-.967	-.912	-.803
MAXIMUM Y	1.617	1.632	1.719
MINIMUM Y	-1.220	-1.041	-1.160
CENTROID X	.180	.125	.016
CENTROID Y	-.121	-.300	-.181
PCR TO CENTROID (IN.)	.217	.325	.181
MIN RADIUS	.468	.433	.341
MEAN RADIUS	.992	.906	.832
MAX RADIUS	1.692	1.293	1.204
HORIZONTAL SPREAD	1.931	1.931	1.931
VERTICAL SPREAD	2.837	1.873	1.873
EXTREME SPREAD	2.858	2.525	2.221
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		9	

RECEIVED

PATTERNS

51

PAYMENT:
Mastercard / Visa (circle one)
Card #:
Exp. Date:
Signature:

RETURN:
☐ Clark Street Entrance
☐ Via US Mail or UPS

(PLEASE PRINT CLEARLY)

FIREARMS DELIVERED TO PLANT

FILE NO 008326

DATE 12/9/93

CUSTOMER NAME:

ADDRESS:

ZIP:

PHONE:

FIREARM

U.S. ARMY
THOMPSON ALLAN R
D Co 2 BN 1st SIG
FT BRAGG NC
28307
432-9037

REMINGTON EMPLOYEE:

YES ☐ NO ☒

EMPLOYEE # _____

DEPT. # _____

MODEL: 84

CHECK FOR AMMUNITION ☒

GAUGE: 7.62 C6225233, C6225379

SERIAL # C6225229, C6225414

CONDITION:

WOOD GOOD FAIR POOR FANCY PLAIN

METAL GOOD FAIR POOR FANCY PLAIN

BARREL 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: REBARREL - Allen Fred
MARTIN

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

DATE: 12/9/93

SIGNATURE: [Signature]
(Security Officer)

DATE: 12/9/93

SIGNATURE: [Signature]
(Firearm picked up by)

DATE: 12/9/93

Arm Service Copy

CONTRACT # DAAA21-87-C-0086

New Barrel

GUN SERIAL # C6225382

OP. #	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and Stock		12/16/93	RW
600	Proof		12/16/93	RW
607	Check Headspace		12/16/93	RW
610	Dis-assemble Gun		12/16/93	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		12/28/93	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		12/28/93	RW
	C) Inspect Ejector Hole for Chamfer		12/28/93	RW
	D) Oil Firing Pin Ass'y		12/28/93	RW
	E) Adjust Trigger Pull to Min Setting and Stake		12/28/93	RW

op. #	OP. NAME	READINGS					DATE	INIT
5 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						12/29/93	RW
	A) Time							
	B) Malfunctions							
	C) Pierced Primers							
	D) Optical Clarity of Scope							
645	Inspect for Live Ammo						12/29/93	RW
655	Final Inspection							
	A) Headspace						1/3/94	RW
	B) Trigger Pull	2.49	2.41	2.48	2.59	2.68	1/3/94	RW
	C) Function						1/3/94	RW
660	Pack							

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6225382
11 Jan 1994

CENTROIDAL DISTANCES

0 TO 1	.711891
1 TO 2	.847257
1 TO 3	.600787
1 TO 4	.444605
1 TO 5	.609147

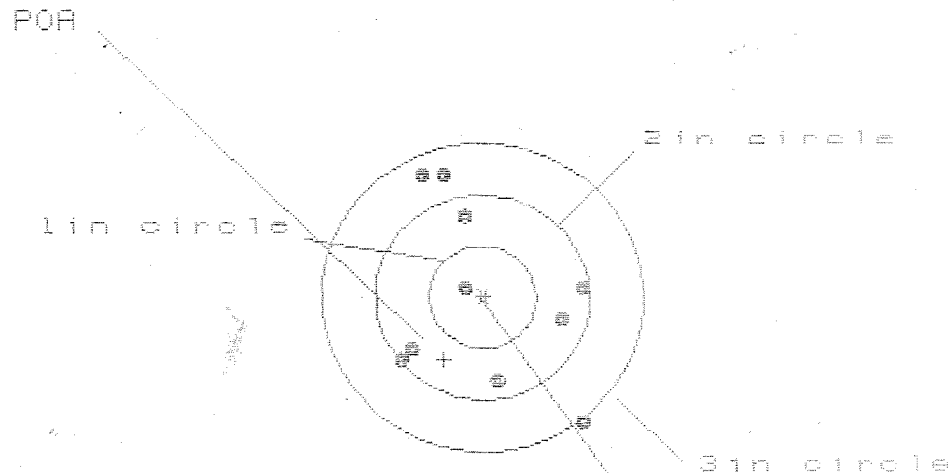
1
4 8 (----FOR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .277
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1524
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .316156
THE AMR FOR THIS RIFLE IS: 1.017

11 Jan 1994

FILE:/PATTERNING/CENTERFIRE_PATT/082253B2

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1in = 1

2in = 7

3in = 9

HS= 1.726

VS= 2.436

GS= 2.864

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.948	1.006	.950
MINIMUM X	-.778	-.673	-.730
MAXIMUM Y	1.212	1.077	1.140
MINIMUM Y	-1.224	-.928	-.794
CENTROID X	.367	.262	.319
CENTROID Y	.610	.746	.612
POA TO CENTROID in.	.712	.791	.690
MIN RADIUS	.153	.073	.111
MEAN RADIUS	.934	.850	.802
MAX RADIUS	1.548	1.168	1.188
HORIZONTAL SPREAD	1.726	1.679	1.679
VERTICAL SPREAD	2.436	2.005	1.934
EXTREME SPREAD	2.864	2.112	1.994
NUMBER IN ONE INCH CIRCLE	= 1		
NUMBER IN TWO INCH CIRCLE	= 7		
NUMBER IN THREE INCH CIRCLE	= 9		

11 Jan 1984

FILE:/PATTERNING/CENTERFIRE_PATT/08225382

CENTERFIRE PATTERNS

2

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 2

2in = 4

3in = 8

HS= 2.514

VS= 2.547

GS= 3.579

CENTROID #

PATTERN #

2

SHOTS (BEST OF)		10	9	8
MAXIMUM	X	1.241	1.124	.982
MINIMUM	X	-1.273	-1.135	-1.128
MAXIMUM	Y	1.248	1.104	1.212
MINIMUM	Y	-1.299	-1.389	-1.251
CENTROID	X	-.042	-.180	-.038
CENTROID	Y	-.132	.012	-.126
POA TO CENTROID in.		.139	.190	.131
MIN RADIUS		.111	.086	.117
MEAN RADIUS		1.017	.930	.824
MAX RADIUS		1.796	1.584	1.254
HORIZONTAL SPREAD		2.514	2.259	2.110
VERTICAL SPREAD		2.547	2.493	2.463
EXTREME SPREAD		3.579	2.766	2.486
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	

11 Jan 1934

FILE:/PATTERNING/CENTERFIRE_PATT/C62253B2

CENTERFIRE PATTERNS

3

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 7

HS= 1.816

VS= 3.021

GS= 3.331

PATTERN #

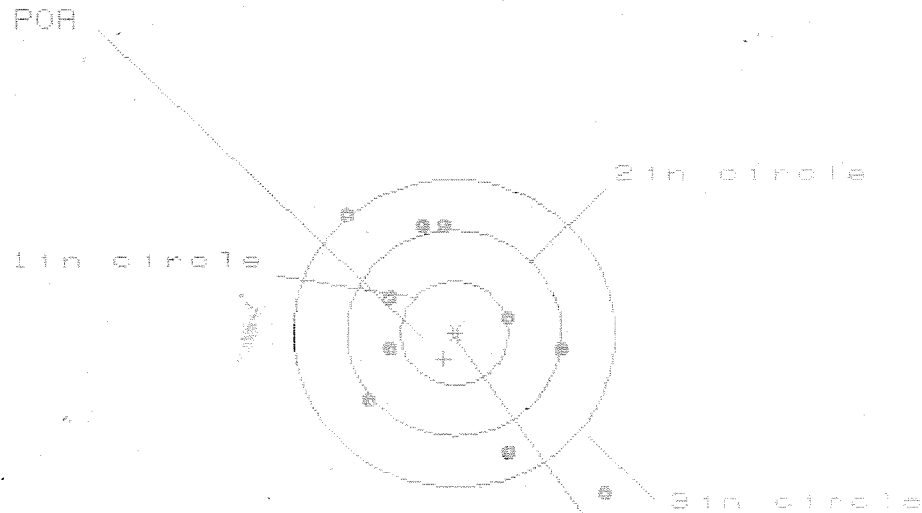
3

SHOTS (BEST OF)	10	9	8
MAXIMUM X	.950	1.014	.983
MINIMUM X	-.866	-.802	-.933
MAXIMUM Y	1.692	1.878	1.340
MINIMUM Y	-1.329	-1.143	-.908
CENTROID X	.475	.411	.442
CENTROID Y	.019	-.167	-.402
POA TO CENTROID in.	.475	.444	.597
MIN RADIUS	.200	.159	.372
MEAN RADIUS	1.104	1.002	.871
MAX RADIUS	1.771	1.895	1.484
HORIZONTAL SPREAD	1.816	1.816	1.816
VERTICAL SPREAD	3.021	3.021	2.248
EXTREME SPREAD	3.331	3.072	2.574
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		7	

11 Jan 1994

FILE:/PATTERNING/CENTERFIRE_PATT/C6225382

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 0

2in = 3

3in = 9

HS= 2.378

VS= 2.626

CS= 3.543

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.486	1.185	1.083
MINIMUM X	-0.971	-0.815	-0.711
MAXIMUM Y	1.110	0.942	1.014
MINIMUM Y	-1.516	-1.350	-1.233
CENTROID X	0.102	-0.054	0.048
CENTROID Y	0.253	0.421	0.304
POA TO CENTROID in.	0.273	0.425	0.307
MIN RADIUS	0.544	0.497	0.587
MEAN RADIUS	1.093	0.948	0.916
MAX RADIUS	2.068	1.493	1.344
HORIZONTAL SPREAD	2.378	2.000	1.794
VERTICAL SPREAD	2.626	2.292	2.247
EXTREME SPREAD	3.543	2.714	2.359
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	3		
NUMBER IN THREE INCH CIRCLE =	9		

11 Jan 1984

FILE:/PATTERNING/CENTERFIRE_PATT/CS225382

CENTERFIRE PATTERNS # 5

POR

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 10

HS= 2.113

VS= 2.573

GS= 2.581

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.926	.958	.974
MINIMUM X	-1.187	-1.155	-1.139
MAXIMUM Y	1.296	1.672	1.530
MINIMUM Y	-1.277	-1.133	-1.871
CENTROID X	.483	.451	.435
CENTROID Y	.012	-.132	.010
POR TO CENTROID in.	.483	.478	.435
MIN RADIUS	.485	.491	.530
MEAN RADIUS	.936	.895	.848
MAX RADIUS	1.329	1.160	1.167
HORIZONTAL SPREAD	2.113	2.113	2.113
VERTICAL SPREAD	2.573	1.805	1.401
EXTREME SPREAD	2.581	2.147	2.147
NUMBER IN ONE INCH CIRCLE	=	2	
NUMBER IN TWO INCH CIRCLE	=	6	
NUMBER IN THREE INCH CIRCLE	=	10	

RECEIVING AND ESTIMATING REPORT

BARBER - M24 0152054

CUST NO: 046771 C.O.D

COMMENTS

M-24 SNIPER

INITIAL
JJM

CUSTOMER ORDER NO.

006252

DATE RECEIVED

07/29/91

DATE OPENED

07/29/91

DATE CODE

KI 5-88

SERIAL NUMBER

C6225382

MODEL AND GRADE

700 7.62

NATO

ORDER

R 91-14521

ACCESSORIES

W/STUDS

SCOPE BASE

FROM:

CO D 2ND BN 1ST SPWAR TNG GP
C/O CPT M K STEPHENSON
FT BRAGG NC 28307
USA

SHIP TO:

CO D 2ND BN 1ST SPWAR TNG GP
C/O CPT M K STEPHENSON
FT BRAGG NC
USA 28307

ACCOUNT NUMBER

ACCOUNT NUMBER N/C

WRITE ☐

CLEAN/TEST

PROM. DATE

ESTIMATED

VIA

DOOR

REPAIR CHARGE

TAX

INSURANCE

UPS

PARCEL POST

TOTAL

GUN CONDITION:

☐ NEW

☐ SLIGHTLY WORN

☒ VERY WORN

☐ MISUSED

☐ MARRED

CUSTOMER'S REQUEST

1) NEW BARREL

2) REDUCER-COAT TRIGGER GUARD ASSY

3) CLEAN FIRE CONTROL

MAIN FAULT

PARTS

REPAIRMAN

RW

PROOF

✓

CLEAN

D.H.

TEST

D.H.

TARGET

D.H.

PATTERN

GALLERY TESTER

D.H.

DATE

7/29/91

DATE

Sept 21

DATE

Sept 24

DATE

Sept 24

DATE

OFFICE COPY

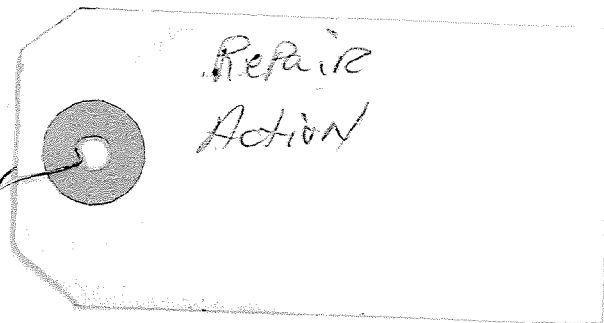
RD6925 REV. 7/90

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

BARBER - M24 0152054

88299

BARBER - M24 0152035



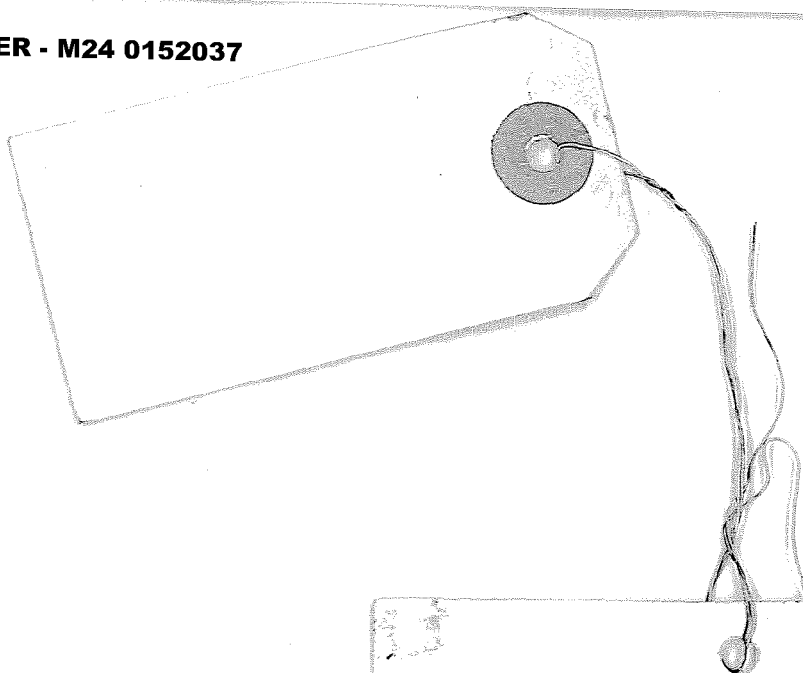
C 6775382

MOD. _____ GA. CAL. _____ GUN # _____

# TEST	DATE	MALFUNCTION/DEFECT	ASSEM. #
A.C.	1st	DOESN'T EJECT SHAVES BRASS, LAST SHELL ON 3 TARGETS	
	2nd	Clean Ejector Hole Tested OK 10/7/58 RW	
	3rd		
	4th		

FUNCTION

RD 6654 Rev 1



TEST INIT. ACTION TO CORRECT		ASSEM. #
PROOF		
TEST		
TGT		
PROOF		
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		

M.24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # *C6225382*

OPERATION		DATE	INT
#	NAME		
575- 580	ASSEMBLY <i>2</i>	<i>26</i>	<i>FB</i>
600	PROOF <i>2</i>	<i>29</i>	<i>RU</i>
615	MAGNAFLUX BARREL	<i>5/13/88</i>	<i>PJR</i>
	MAGNAFLUX BOLT	<i>5/13/88</i>	<i>PJR</i>
620	COATING	<i>8/11/88</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 #

C6225382

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		9/9/88	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		9/9/88	RW
	C) Inspect Ejector Hole for Chamfer		9/9/88	RW

OVER

OP.#		READINGS	DATE	INITIAL
625 cont.	D) Oil Firing Pin Ass'y		9/9/88	RW
	E) Adjust Trigger Pull to Min. Setting and Stake		9/9/88	J.W. H.S.
	F) Safety on Force	6 6 5.5	9/9/88	J.W. H.S.
	G) Safety off Force	3 3 3	9/9/88	J.W. H.S.
	H) Trigger Pull Test & Retainability		9/9/88	J.W. H.S.
	I) Firing Pin Indent	.023 .0225 .0225	9/9/88	J.W. H.S.
	J) Assemble Stock		9/20/88	RW
	K) Assemble Swivel Studs		10-7-88	J.S.S.
	L) Attach Front & Rear Sight Assemblies		9/20/88	RW
	M) Iron Sight Alignment		9/20/88	RW
	N) Detach Front & Rear Sights & place in numbered container		9/20/88	RW
	O) Attach Scope to Rifle		10/3/88	RW
	P) Detach & Attach Scope 20 times		10/4/88	J.S.S.
640	Gallery Target & Test	56 R 99L	10-6-88	AC
	A) Optical Clarity of Scope	OK	10-6-88	AC
645	Inspect for Live Ammo	none	10-6-88	AC
655	Final Inspection			
	A) Headspace		10-7-88	J.S.S.
	B) Trigger Pull		10-7-88	J.S.S.
	C) Function		10-7-88	J.S.S.
660	Pack	OK	10/20/88	W.B.

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS
2.50# + .50#
3.00# + .75#
4.00# + 1.00#

SERIAL NO. C625382
DATE 9 Sept. 88
TESTER J. J. S. S.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.66	2.16	2.44	2.91	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.72	2.25	2.46	2.90	
PULL #3	2.67	2.31	2.54	2.90	
PULL #4	2.56	2.31	2.36	2.83	
PULL #5	2.53	2.23	2.56	2.85	
TOTAL	13.13	11.26	12.36	14.39	
AVG.	2.626	2.252	2.472	2.878	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.04	2.86		
PULL #2	2.99	3.24		
PULL #3	2.99	3.15		
PULL #4	2.99	3.06		
PULL #5	3.05	3.16		
TOTAL	15.06	15.46		
AVG.	3.012	3.092		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.16	4.02		4.28
PULL #2	4.17	4.10		4.30
PULL #3	4.20	4.14		4.33
PULL #4	4.19	4.15		4.35
PULL #5	4.19	4.18		4.36
TOTAL	20.91	20.59		21.62
AVG.	4.182	4.118		4.324

RECEIVING BARBER STIM 2410652842RT

COMMENTS

ORDER

R 96-02141

INITIAL

CUSTOMER ORDER NO.

SNIPER M-24

FPS

10799

DATE RECEIVED

DATE OPENED

DATE CODE

SERIAL NUMBER

NEW SERIAL NUMBER

MODEL AND GRADE

01/11/96

01/17/96

C6225382

700 7.62

NATO

ACCESSORIES

W/STUDS

SCOPE BASE

SOFT CASE

FROM:

DENAREST, WARREN C.
D CO. 2ND BN. 1ST SWTG
FT BRAGG NC 28307

SHIP TO:

Commander
~~DENAREST, WARREN C.~~
D CO. 2ND BN. 1ST SWTG
FT BRAGG NC 28307

CUST NO: 135950 C.O.D.L

ACCOUNT NUMBER

ACCOUNT NUMBER N/C

WRITE ☐

PROM. DATE

ESTIMATED

VIA

Door

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

W52 H096017#245

*Repowder Coat Trigger Guard
Assy & Rear Sight Base
Reznice Scope Base & Swivel
Studs.*

*Barrel - 96003
Stock - 96018*

*Firing pin Assy - 96007
Front Sight Base - 18844*

REPAIRMAN

PROOF

CLEAN

TEST

TARGET

PATTERN

GALLERY TESTER

DATE

DATE

DATE

DATE

DATE

OFFICE COPY

RD6925 REV. 1/94

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

BARBER - M24 *M24902152081*

RD-6947-Rev 3

PAYMENT:

Mastercard / Visa (circle one)

Card #:

Exp. Date:

Signature:

RETURN:

☐ Clark Street Entrance☒ Via US Mail or UPS

(PLEASE PRINT CLEARLY)

FIREARMS DELIVERED TO PLANT

FILE NO 010799

DATE 1/17/96

CUSTOMER NAME:

ADDRESS:

ZIP:

PHONE:

FIREARM

MODEL:

GAUGE:

SERIAL #

REMINGTON EMPLOYEE:

YES ☐NO ☒

EMPLOYEE #

DEPT. #

CHECK FOR AMMUNITION

CONDITION:

WOOD

GOOD

FAIR

POOR

FANCY

PLAIN

METAL

GOOD

FAIR

POOR

FANCY

PLAIN

BARREL

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:

SIGNATURE:

(Person delivering firearm to Plant)

DATE:

SIGNATURE:

(Security Officer)

DATE:

SIGNATURE:

(Firearm picked up by)

DATE:

Arm Service Copy

CONTRACT # DAAA21-87-C-0086

*New Barrel & Stock*GUN SERIAL # *C6225382*

OP. #	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and Stock		<i>1/22/96</i>	<i>RW</i>
600	Proof		<i>1/22/96</i>	<i>RW</i>
607.	Check Headspace		<i>1/22/96</i>	<i>RW</i>
610	Dis-assemble Gun		<i>1/22/96</i>	<i>RW</i>
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		<i>1/27/96</i>	<i>RW</i>
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		<i>1/27/96</i>	<i>RW</i>
	C) Inspect Ejector Hole for Chamfer		<i>1/27/96</i>	<i>RW</i>
	D) Oil Firing Pin Ass'y		<i>1/27/96</i>	<i>RW</i>
	E) Adjust Trigger Pull to Min Setting and Stake		<i>1/27/96</i>	<i>RW</i>

op. #	BARBER - M24 0152045 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		1/27/96	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		1/31/96	WB
	A) Time			
	B) Malfunctions			
	C) Pierced Primers			
	D) Optical Clarity of Scope			
645	Inspect for Live Ammo		1/31/96	WB
655	Final Inspection			
	A) Headspace		2/1/96	RW
	B) Trigger Pull			
	C) Function		2/1/96	RW
660	Pack			

Final Inspection

Seri: C6225382

DATE REC'D: 1/17/96

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:

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6225382
3 Jan 1988

CENTROIDAL DISTANCES

0 TO 1	1.65309
1 TO 2	.27236
1 TO 3	.126127
1 TO 4	.28008
1 TO 5	.414276

5
4
3
2

+ <----POB

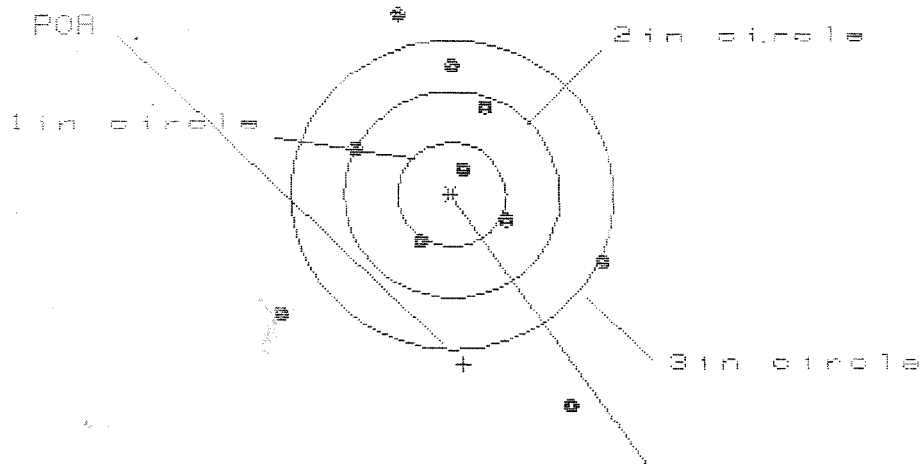
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1538
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: 1.7216
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: 1.72846

THE AMR FOR THIS RIFLE IS: .9948

2 Jan 1968

FILE:/PATTERNING/CENTERFIRE_PATT/06225382

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

CENTROID #

IN CIR

1in = 1

2in = 5

3in = 6

HS = 2.933

VS = 3.804

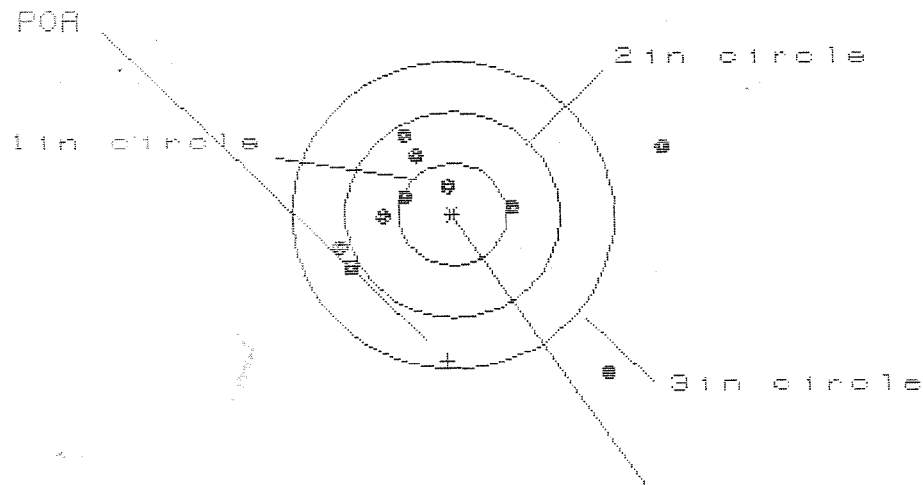
GS = 4.133

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.374	1.492	1.312
MINIMUM X	-1.559	-1.441	-0.940
MAXIMUM Y	1.764	1.537	1.362
MINIMUM Y	-2.040	-1.400	-1.067
CENTROID X	-1.101	-1.219	-1.039
CENTROID Y	1.650	1.877	2.052
POA TO CENTROID in.	1.653	1.890	2.052
MIN RADIUS	.275	.215	.146
MEAN RADIUS	1.215	1.068	.918
MAX RADIUS	2.303	2.009	1.691
HORIZONTAL SPREAD	2.933	2.933	2.252
VERTICAL SPREAD	3.804	2.937	2.429
EXTREME SPREAD	4.133	3.106	3.097
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	6		

2 Jan 1988

FILE:/PATTERNING/CENTERFIRE_PATT/08225382

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

CENTROID *

IN CIR

1in = 2

2in = 6

3in = 8

HS= 3.039

VS= 2.257

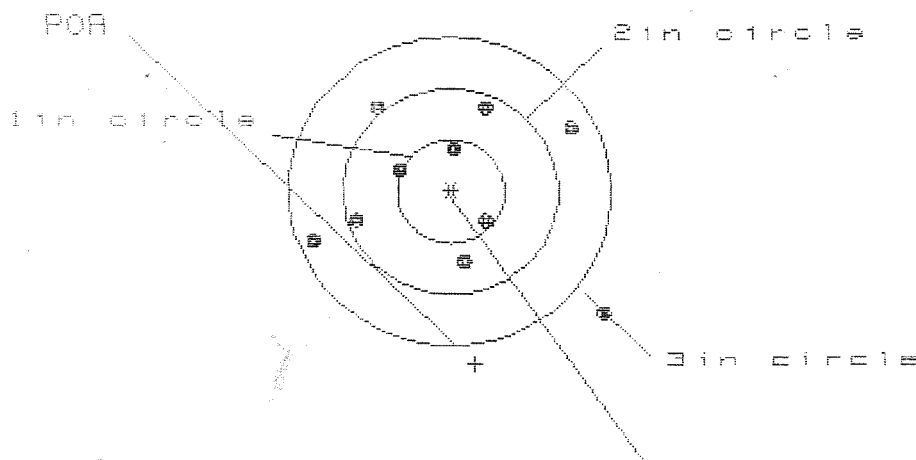
GS= 3.221

PATTERN #	2	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.958	2.123	.988
MINIMUM X	-1.081	-.916	-.650
MAXIMUM Y	.735	.566	.634
MINIMUM Y	-1.522	-.731	-.663
CENTROID X	.051	-.114	-.380
CENTROID Y	1.424	1.593	1.525
POA TO CENTROID in.	1.425	1.597	1.572
MIN RADIUS	.260	.100	.106
MEAN RADIUS	.989	.776	.553
MAX RADIUS	2.127	2.192	.990
HORIZONTAL SPREAD	3.039	3.039	1.638
VERTICAL SPREAD	2.257	1.297	1.297
EXTREME SPREAD	3.221	3.221	1.682
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	8		

2 Jan 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C8225382

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1in = 2

2in = 7

3in = 9

HE= 2.757

VS= 2.053

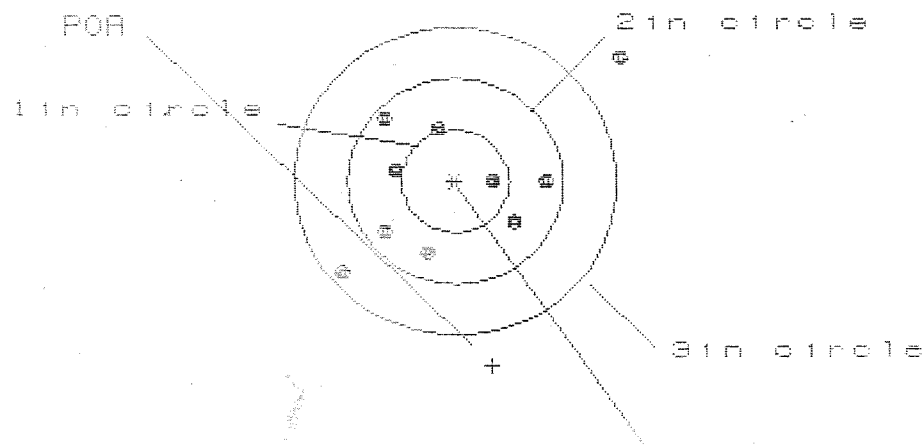
GS= 2.869

CENTROID #

PATTERN #	3		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.443	1.260	1.116
MINIMUM X	-1.314	-1.154	-.908
MAXIMUM Y	.838	.703	.625
MINIMUM Y	-1.215	-.821	-.899
CENTROID X	-.223	-.383	-.239
CENTROID Y	1.682	1.817	1.895
POA TO CENTROID in.	1.697	1.857	1.910
MIN RADIUS	.393	.328	.188
MEAN RADIUS	.946	.816	.739
MAX RADIUS	1.887	1.358	1.195
HORIZONTAL SPREAD	2.757	2.414	2.024
VERTICAL SPREAD	2.053	1.524	1.524
EXTREME SPREAD	2.869	2.663	2.205
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		9	

2 Jan 1968 FILE:/PATTERNING/CENTERFIRE_PATT/06225362

CENTERFIRE PATTERNS # 4



OF SHOTS = 10

IN CIR

1in = 1

2in = 8

3in = 8

HS = 2.537

VS = 2.109

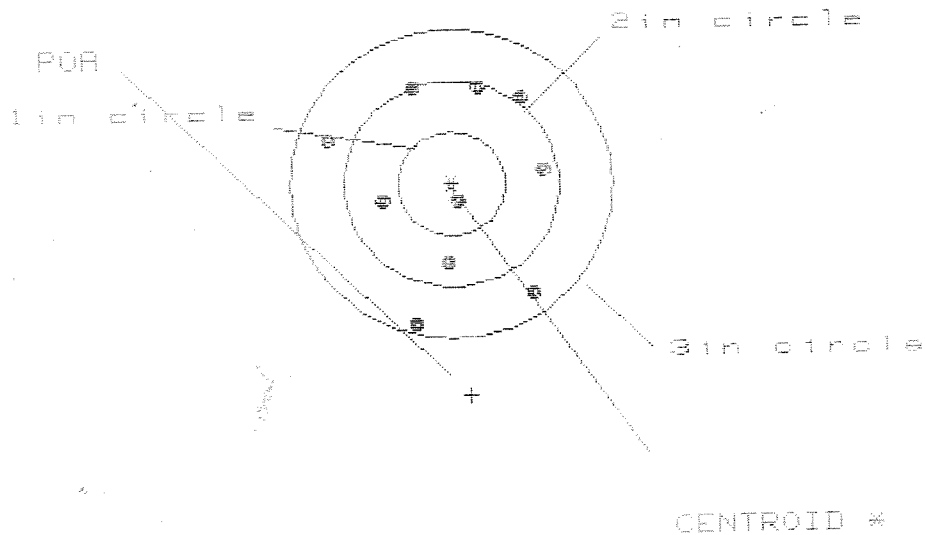
GS = 3.299

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.496	1.019	.910
MINIMUM X	-1.041	-.875	-.627
MAXIMUM Y	1.182	.714	.615
MINIMUM Y	-.927	-.796	-.673
CENTROID X	-.343	-.509	-.400
CENTROID Y	1.791	1.660	1.759
POA TO CENTROID in.	1.823	1.736	1.804
MIN RADIUS	.382	.450	.443
MEAN RADIUS	.886	.758	.694
MAX RADIUS	1.907	1.183	.913
HORIZONTAL SPREAD	2.537	1.894	1.537
VERTICAL SPREAD	2.109	1.510	1.288
EXTREME SPREAD	3.299	2.132	1.637
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	8		
NUMBER IN THREE INCH CIRCLE =	9		

2 Jan 1988

FILE:/PATTERNING/CENTERFIRE_PATT/08225982

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 10

HS= 1.927

VS= 2.299

GS= 2.410

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.849	.814	.989
MINIMUM X	-1.128	-1.163	-1.068
MAXIMUM Y	.963	.815	.666
MINIMUM Y	-1.336	-1.192	-1.032
CENTROID X	-.153	-.118	-.213
CENTROID Y	2.061	2.209	2.358
POA TO CENTROID in.	2.066	2.212	2.368
MIN RADIUS	.127	.271	.430
MEAN RADIUS	.930	.890	.818
MAX RADIUS	1.371	1.413	1.074
HORIZONTAL SPREAD	1.977	1.977	1.977
VERTICAL SPREAD	2.299	2.007	1.698
EXTREME SPREAD	2.410	2.410	1.993
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	10		