

C6522319

M2400005136

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

08/25/08 10:26 AM

Arms Services Repair & Estimate System

FileAdd RepairEstimate RepairExpedite RepairInquiryRepair ToolsCSR ToolsReportsTable MaintenanceSystem MaintenanceHelp

Repair Inquiry

Repair Number: RE00149811Serial: C6522319 Model M24 SWS Center Fire Caliber: 7.62 NATORepairman:Status: Closed 8/25/2008 9:52:18 AM

Address Information

Customer:Received FromReturn To:Received From

Name: CAMP ROBERTS MATES

Address 1: EAST GARRISON BLDG 25021

Address 2: ATTN: CW4 KEISTERPO Box:

City: SAN MIGUEL

State: CAZip Code: 93451Country: US

State: CAZip Code: 93451Country: US

FFL:

Contact / ConditionProblemsEstimateHistory / StatusShipping / Billing

Contact Information

Phone: NNFax:Email:Comments:

Received Condition

Fair

Condition Notes:

CSR Notes:

Accessories Received

Code	Desc	Qty
A007	With Stud	3
A008	With Swivel	2
A017	Scope Base	1
A057	Fit and Rear Sgt Base	1

Repair SearchRefreshClose

naglej8/25/200810:26 AMCAPSNUMINS

start13 Mic...VanuK's E...5 Micros...Part Sear...Arms Ser...

Serial Number: C6522319
Model: M24 SWS

RE00149811

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

M2400005137

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

P&E NUMBER 149811
SERIAL NUMBER C6522319
LOG-IN DATE 8-25-08

OPERATION #	OPERATION NAME		DATE	INITIAL
500	DIS-ASSEMBLE GUN			
505	RE-BARREL			
560	ASSEMBLE	Clean & EVALUATE	9-16-08	RTZ
600	PROOF			
605	CHECK HEADSPACE			
610	DIS-ASSEMBLE GUN			
612	MAGNAFLUX			
510	DRILL AND TAP			
615	ROLLMARK CALIBER			
618	ROTO-BLAST			
620	APPLY COATINGS			
625	FINAL ASSEMBLY			
640	FUNCTION TEST AND	PASS FAIL	9-20-08	TRW
650	TARGET	PASS FAIL	9-20-08	TRW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
670	FINAL INSPECTION		9/24/08	JS
	A) HEADSPACE	PASS FAIL	9-23-08	TC
	B) TRIGGER PULL	3.56 3.45 3.43 3.50 3.37	9-23-08	TC
680	F) SAFETY ON FORCE	2 2 2	9-23-08	TC
	G) SAFETY OFF FORCE	3 3 3	9-23-08	TC
	I) FIRING PIN INDENT	.025 .024 .025	9-23-08	TC
690	PACK		9/24/08	TC

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6522319.__1
FILE DATE AND TIME: 09/22/2008 05:54

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

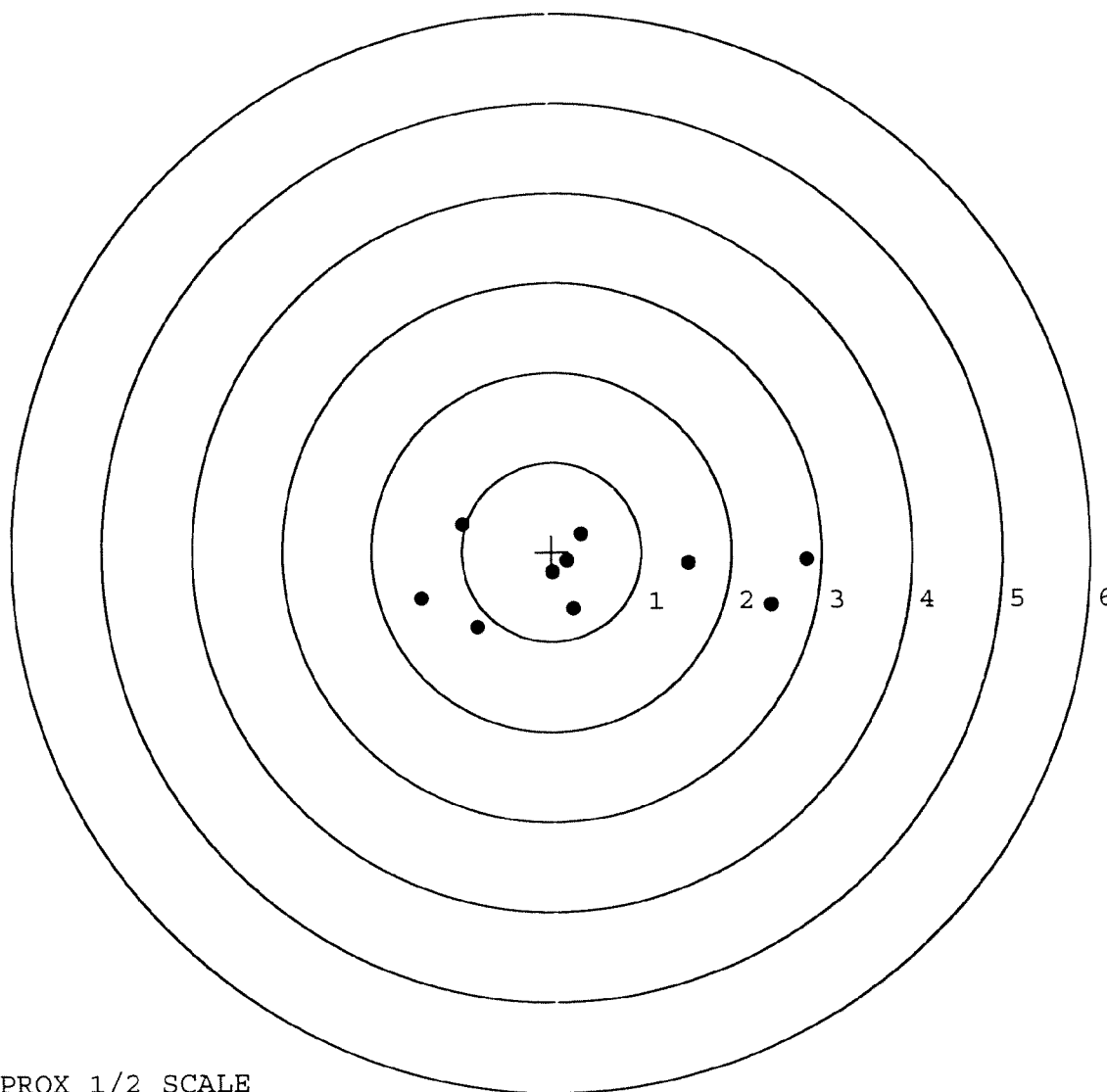
ERROR - NOT POSSIBLE TO REPORT SWS STATS ON DATA
WHERE TOTAL TARGETS ARE NOT EQUAL TO FIVE

AVE MEAN - .876

SERIAL NUMBER: C6522319.___1
TARGET NUMBER: 1
FILE DATE: 09/22/2008
FILE TIME: 05:54

X CENTROID: 0.426
Y CENTROID: -0.269
POA TO CENTROID: 0.503
HORZ SPREAD: 4.279
VERT SPREAD: 1.155
GROUP SPREAD: 4.298
MIN RADIUS: 0.305
MAX RADIUS: 2.409
MEAN RADIUS: 1.198
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 4
in 3 IN DIAMETER: 6

POINT#	X	Y
1:	0.234	-0.644
2:	0.007	-0.227
3:	0.170	-0.103
4:	0.328	0.199
5:	-0.991	0.311
6:	-1.449	-0.517
7:	-0.828	-0.844
8:	1.524	-0.135
9:	2.434	-0.613
10:	2.830	-0.112

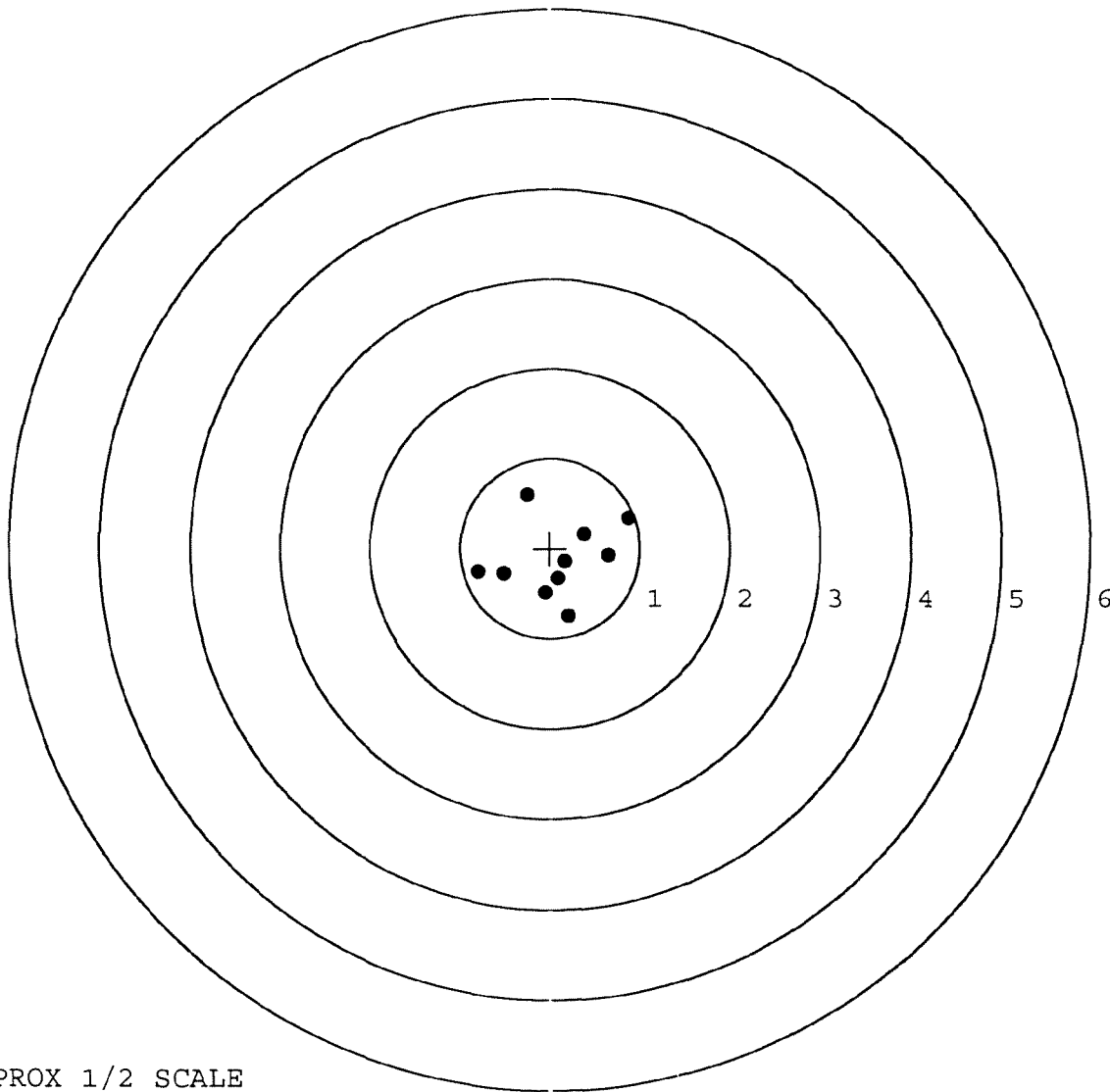


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6522319. __1
TARGET NUMBER: 2
FILE DATE: 09/22/2008
FILE TIME: 05:54

POINT#	X	Y
1:	0.201	-0.756
2:	-0.054	-0.494
3:	0.090	-0.337
4:	0.160	-0.149
5:	0.649	-0.074
6:	0.374	0.164
7:	0.870	0.341
8:	-0.254	0.598
9:	-0.518	-0.274
10:	-0.797	-0.259

X CENTROID: 0.072
Y CENTROID: -0.124
POA TO CENTROID: 0.143
HORZ SPREAD: 1.667
VERT SPREAD: 1.354
GROUP SPREAD: 1.772
MIN RADIUS: 0.091
MAX RADIUS: 0.924
MEAN RADIUS: 0.554
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 10
in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

Repair Inquiry

Repair Number: RE00123776

Serial: C6522319 Model M24 SWS Center Fire
Caliber: 308

Repairman:

Verify Repair

Status:

Closed 1/17/2007 9:35:59 AM

Address Information

Customer:

☒ Received From

Return To:

☐ Received From

Name: CO A(-) 5TH BN 19TH SFG(A)

CO A(-) 5TH BN 19TH SFG(A)

Address 1: ATTN: SSG DONAT (SUPPLY)

ATTN: SSG DONAT (SUPPLY)

Address 2: 4203 SARATOGA AVE SUITE

PO Box:

4203 SARATOGA AVE SUITE

PO Box:

City: JFTB LOS ALAMITOS

JFTB LOS ALAMITOS

State: CA

Zip Code: 90720

Country: US

State: CA

Zip Code: 90720

Country: US

FFL:

Contact / Condition

Problems

Estimate

History / Status

Shipping / Billing

Contact Information

Phone: NA

Fax:

Email:

Comments:

Received Condition

Fair

Condition
Notes:CSR
Notes:

Accessories Received

Code	Desc	Qty
A006	Sling Strap	1
A007	With Stud	3
A010	Hard Case	1
A017	Scope Base	3
A026	Scope	1
A045	Bi Pod	1
A055	Deployment Kit	1

Repair Search

Refresh

Close

nagletj

1/17/2007

10:10 AM

CAPS

NUM

INS

SCRL



Serial Number: C6522319

Model: M24 SWS



RE00123776

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6522319.___0
FILE DATE AND TIME: 01/31/2007 12:57

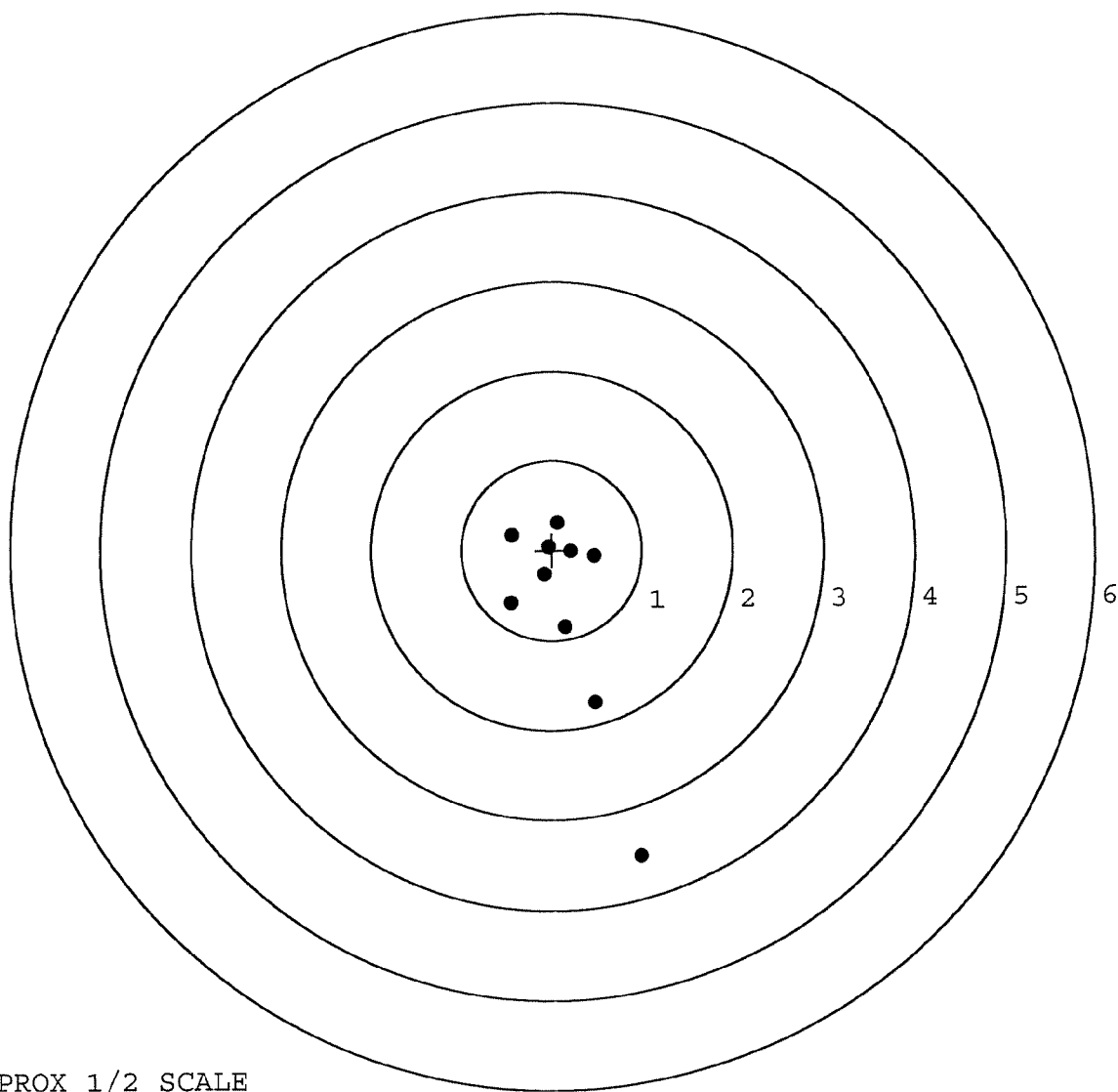
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.015
The Average Y Centroid of the Five Target Set:	-0.121
The Average Point of Impact of the Five Target Set:	0.121
The Average Mean Radius of the Five Target Set:	0.707
The Distance from POA to Centroid Target #1:	0.653
The Distance from Centroid Target #2 to Centroid Target #1:	0.729
The Distance from Centroid Target #3 to Centroid Target #1:	0.674
The Distance from Centroid Target #4 to Centroid Target #1:	0.639
The Distance from Centroid Target #5 to Centroid Target #1:	0.627

SERIAL NUMBER: C6522319.___0
TARGET NUMBER: 1
FILE DATE: 01/31/2007
FILE TIME: 12:57

X CENTROID: 0.128
Y CENTROID: -0.640
POA TO CENTROID: 0.653
HORZ SPREAD: 1.424
VERT SPREAD: 3.709
GROUP SPREAD: 3.846
MIN RADIUS: 0.221
MAX RADIUS: 2.892
MEAN RADIUS: 0.916
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 9

POINT#	X	Y
1:	0.470	-1.696
2:	0.146	-0.860
3:	0.468	-0.071
4:	-0.457	-0.582
5:	-0.444	0.170
6:	-0.092	-0.273
7:	0.207	-0.017
8:	-0.043	0.034
9:	0.062	0.301
10:	0.967	-3.408

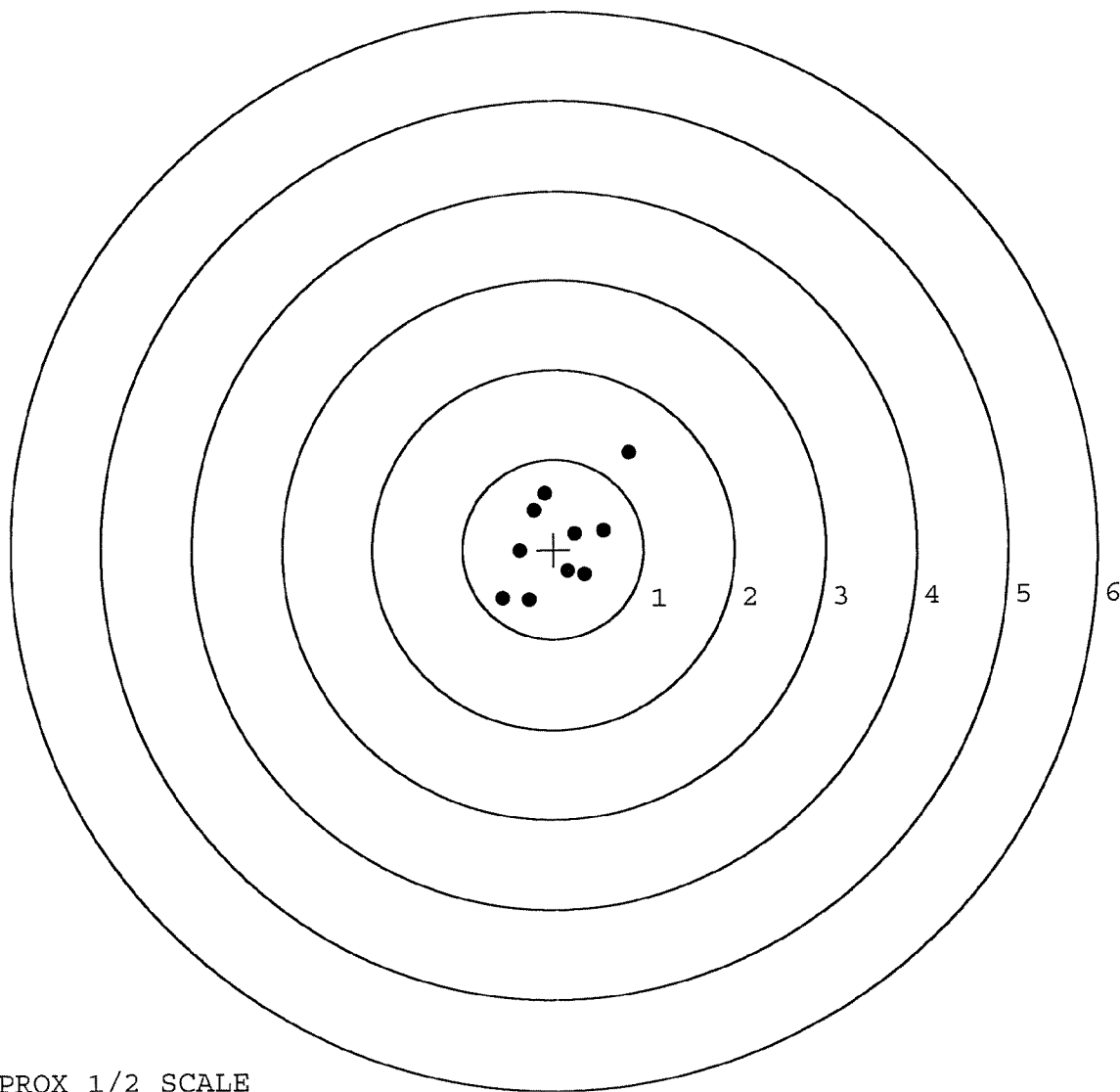


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6522319.___0
TARGET NUMBER: 2
FILE DATE: 01/31/2007
FILE TIME: 12:57

X CENTROID: 0.060
Y CENTROID: 0.086
POA TO CENTROID: 0.105
HORZ SPREAD: 1.414
VERT SPREAD: 1.630
GROUP SPREAD: 2.144
MIN RADIUS: 0.198
MAX RADIUS: 1.256
MEAN RADIUS: 0.585
IN 1 IN DIAMETER: 5
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.845	1.067
2:	-0.099	0.626
3:	-0.214	0.434
4:	-0.377	-0.015
5:	-0.569	-0.545
6:	-0.274	-0.563
7:	0.555	0.209
8:	0.235	0.178
9:	0.345	-0.285
10:	0.154	-0.246



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6522319. __0

TARGET NUMBER: 3

FILE DATE: 01/31/2007

FILE TIME: 12:57

X CENTROID: -0.039

Y CENTROID: 0.012

POA TO CENTROID: 0.041

HORZ SPREAD: 2.032

VERT SPREAD: 1.388

GROUP SPREAD: 2.134

MIN RADIUS: 0.369

MAX RADIUS: 1.327

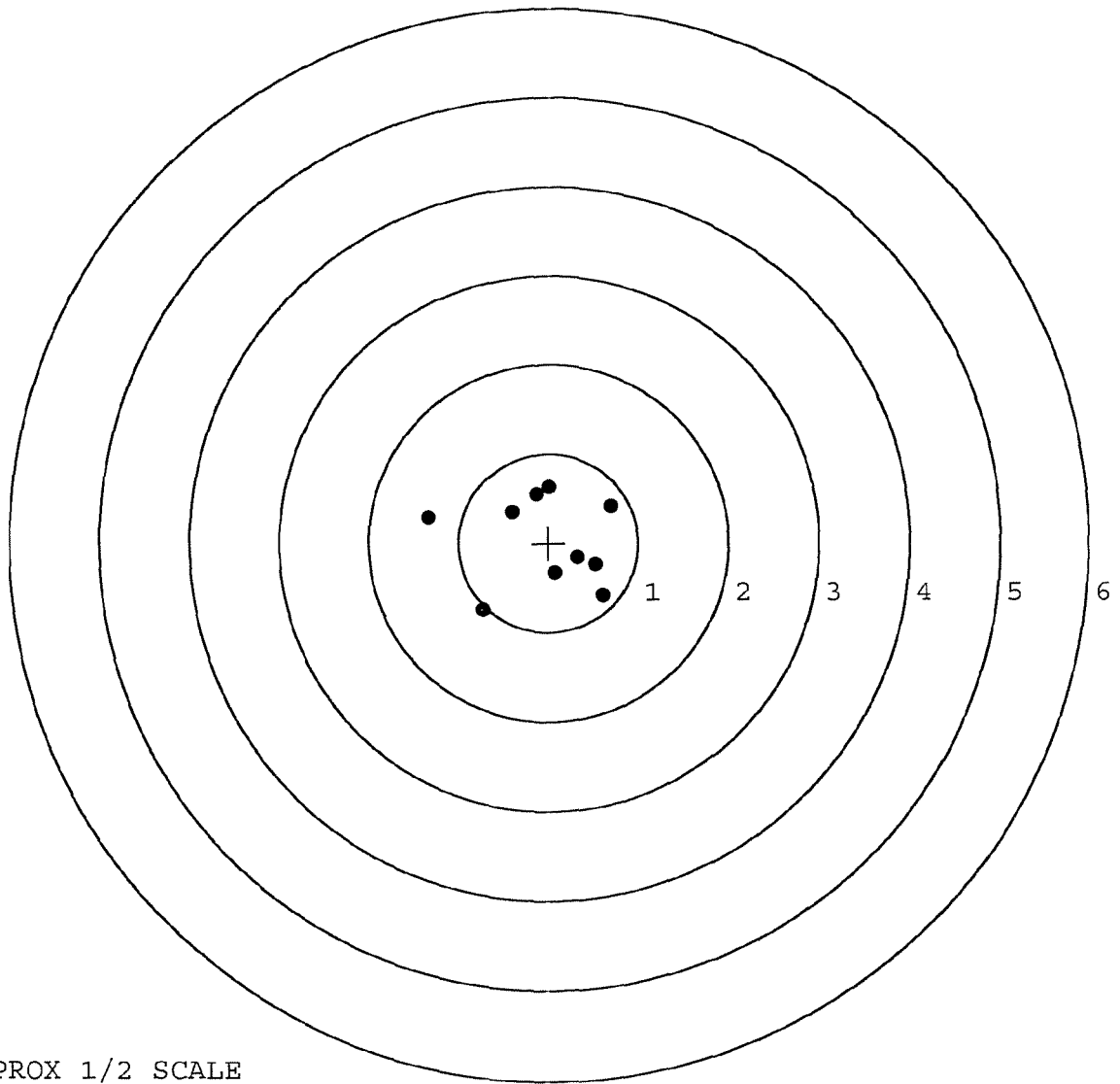
MEAN RADIUS: 0.714

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.610	-0.588
2:	0.521	-0.244
3:	0.321	-0.171
4:	0.071	-0.340
5:	0.694	0.415
6:	0.009	0.629
7:	-0.411	0.349
8:	-0.135	0.550
9:	-0.728	-0.759
10:	-1.338	0.283

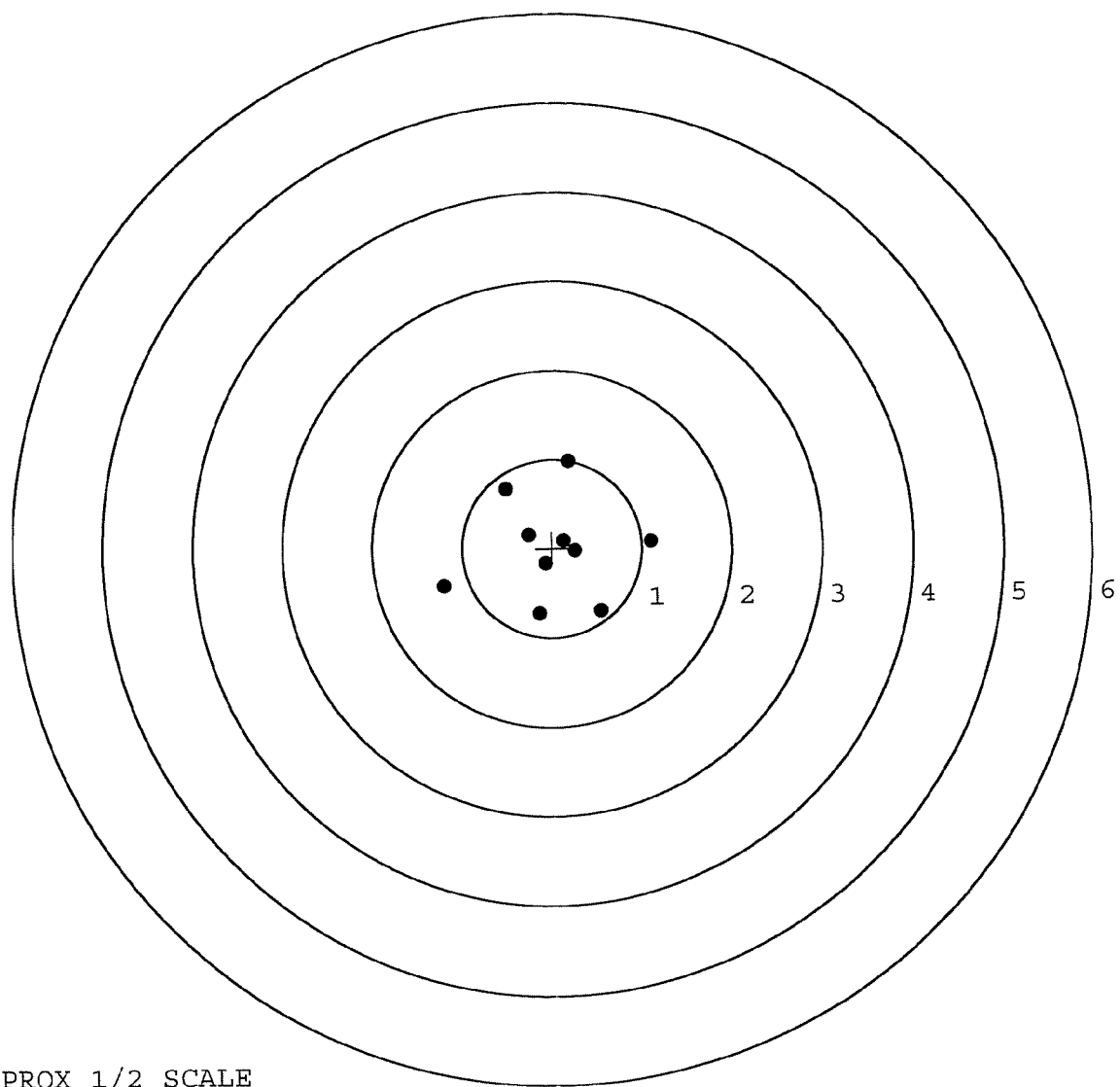


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6522319. __0
TARGET NUMBER: 4
FILE DATE: 01/31/2007
FILE TIME: 12:57

X CENTROID: 0.001
Y CENTROID: -0.014
POA TO CENTROID: 0.014
HORZ SPREAD: 2.301
VERT SPREAD: 1.715
GROUP SPREAD: 2.353
MIN RADIUS: 0.161
MAX RADIUS: 1.269
MEAN RADIUS: 0.677
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.191	0.976
2:	-0.512	0.670
3:	-1.201	-0.420
4:	1.100	0.070
5:	0.543	-0.710
6:	-0.153	-0.739
7:	0.255	-0.038
8:	-0.080	-0.179
9:	0.129	0.084
10:	-0.261	0.151

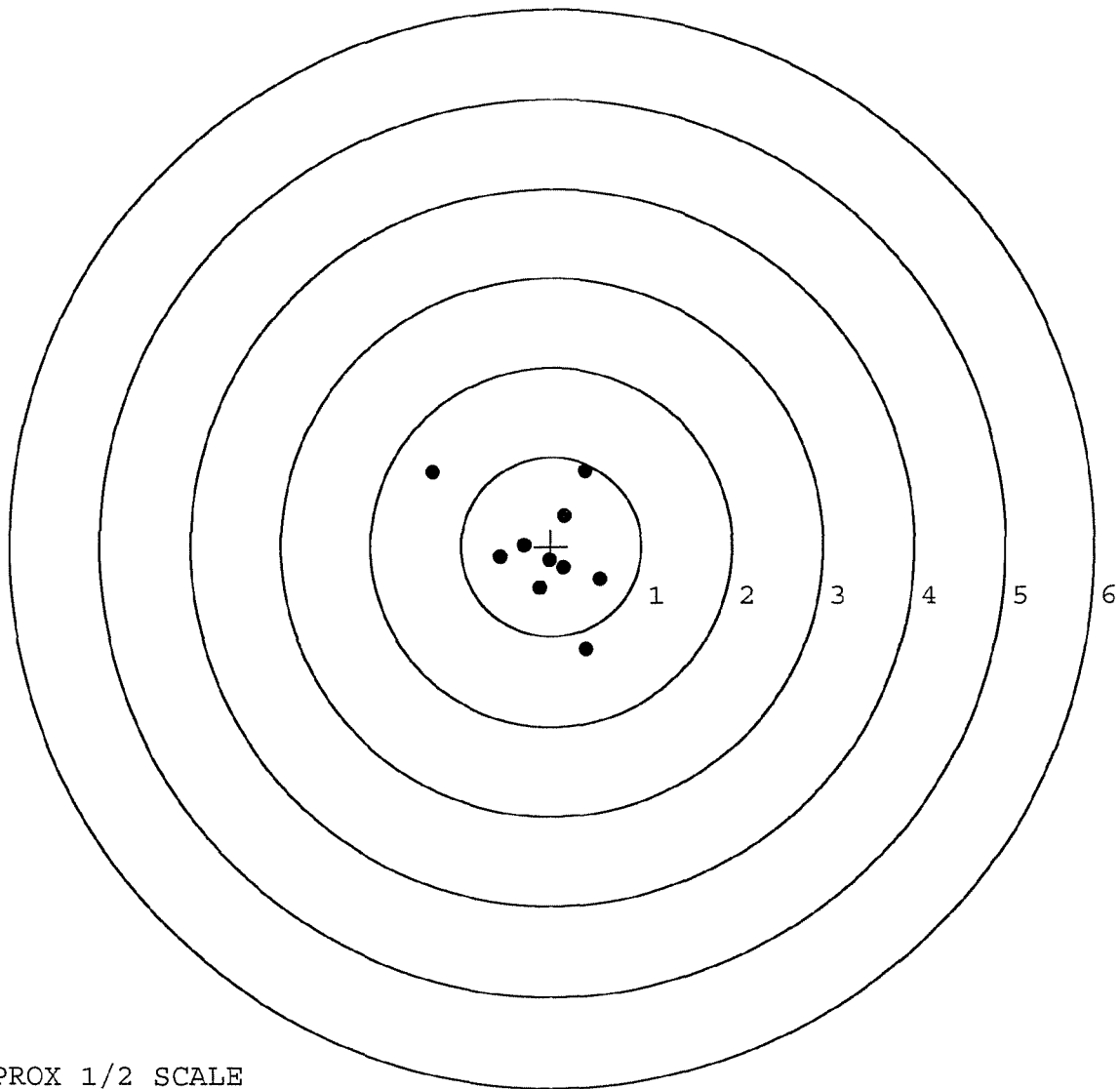


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6522319. __0
TARGET NUMBER: 5
FILE DATE: 01/31/2007
FILE TIME: 12:57

POINT#	X	Y
1:	-1.312	0.830
2:	0.378	0.843
3:	0.144	0.341
4:	0.388	-1.150
5:	0.543	-0.367
6:	-0.131	-0.470
7:	0.136	-0.242
8:	-0.564	-0.114
9:	-0.306	0.015
10:	-0.026	-0.159

X CENTROID: -0.075
Y CENTROID: -0.047
POA TO CENTROID: 0.089
HORZ SPREAD: 1.855
VERT SPREAD: 1.993
GROUP SPREAD: 2.610
MIN RADIUS: 0.122
MAX RADIUS: 1.517
MEAN RADIUS: 0.642
IN 1 IN DIAMETER: 6
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

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

R & E NUMBER	123776		
SERIAL NUMBER	C6522319		
LOG-IN DATE	1-17-07		
OPERATION #	OPERATION NAME	DATE	INITIAL
500	DIS-ASSEMBLE GUN	1-18-07	RTZ
505	RE-BARREL	1-19-07	RTZ
420	ASSEMBLE	1-19-07	RTZ
440	PROOF	MAGNA-FLUX INSPECTED 1-19-07	RP
460	CHECK HEADSPACE		
470	DIS-ASSEMBLE GUN	JAN 23 2007 1-22-07	RTZ
480	MAGNAFLUX	OPERATOR <u>API</u> 1-23-07	APD
510	DRILL AND TAP	1-22-07	FM
500	ROLLMARK CALIBER	1-23-07	CW
520	GOFF BLAST BBL / REC	1-23-07	LB
530 & 540	APPLY COATINGS	1-25-07	W?
560	FINAL ASSEMBLY	1-30-07	RTZ
640	FUNCTION TEST AND	PASS FAIL 1/30/07	W
650	TARGET	PASS FAIL 1/30/07	W
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
670	FINAL INSPECTION	1-30-07	TRW
	A) HEADSPACE	PASS FAIL 2-2-07	RTZ
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS 2.32 2.32 2.42 2.44 2.32 1-31-07	TRW
680	F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX 5.5 5.5 5.5 1-31-07	TRW
	G) SAFETY OFF FORCE	2 LBS MIN 2.25 2.25 2.25 1-31-07	TRW
	I) FIRING PIN INDENT	.020 .025 .025 .025 1-31-07	TRW
690	PACK	2-8-07	DA

F006 REV 5/2006

FINAL INSPECTION CHECKLIST

BARREL ASSEMBLY _____ BARREL _____ RECEIVER _____ FRONT SIGHT BASE _____ REAR SIGHT BASE _____ SCREWS _____ FINISH	STOCK ASSEMBLY _____ STOCK _____ SLING SWIVEL STUDS _____ BUTT PATE _____ LOCK NUTS _____ BARREL CLEARANCE _____ COLOR / FINISH
SCOPE ASSEMBLY _____ SCOPE _____ SCOPE RINGS _____ MOUNTING SCREWS _____ MOUNTING BASE _____ SCREWS _____ FINISH _____ CLARITY	SYSTEM CASE _____ SCOPE CASE _____ IRON SIGHTS _____ DEPLOYMENT KIT TRIGGER ASSEMBLY _____ SAFETY OPERATION _____ RE-SET TO FACTORY SPECS
COMMENTS: _____	

F006 REV 5/2006

Remington Test Lab, Ilion, N.Y.

Centroidal distance calculations for Rifle # c6522319
19 Oct 2001

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .3446
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0852
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .354976

THE AMR FOR THIS RIFLE IS: 1.151

CENTROIDAL DISTANCES

Ø TO	1	1.23696
1 TO	2	.848869
1 TO	3	1.50094
1 TO	4	1.19673
1 TO	5	1.28437

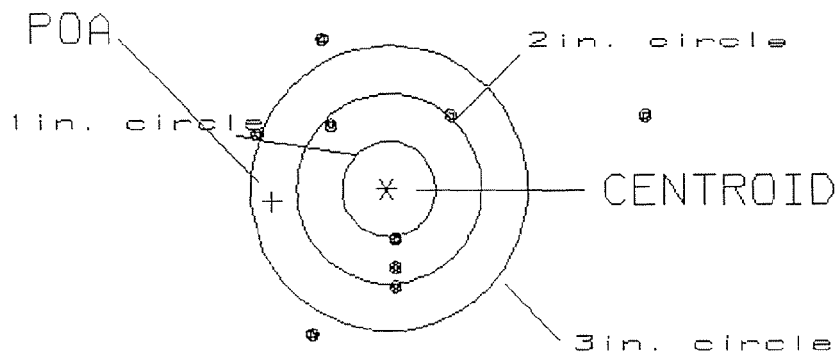
5
4 <----POA
3 2

PATTERN #: ☐ 1 ☐
 POA TO CENTROID: 1.237
 MIN RADIUS : .510
 MEAN RADIUS : 1.268
 MAX RADIUS : 2.847
 CENTROID X : 1.230
 CENTROID Y : .131

18 Oct 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/C6522319

CENTERFIRE PATTERN # 1



OF SHOTS= 10

IN CIRCLE

HS= 4.12

0

VS= 3.17

5

GS= 4.27

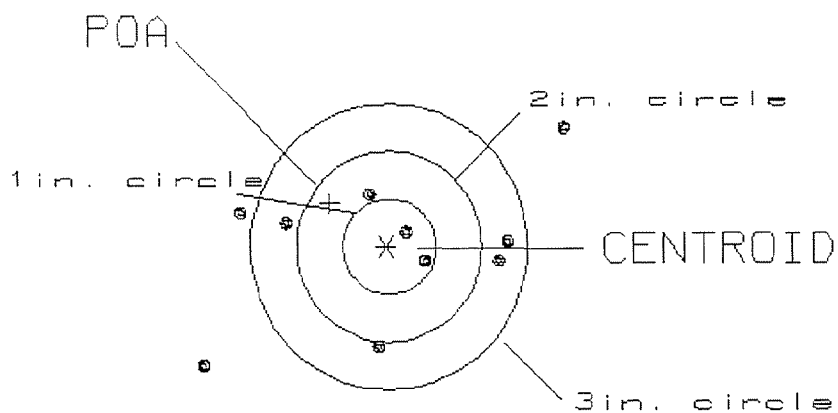
7

PATTERN #: ☐ 2 ☐
 POA TO CENTROID: .761
 MIN RADIUS : .241
 MEAN RADIUS : 1.215
 MAX RADIUS : 2.369
 CENTROID X : .613
 CENTROID Y : -.452

18 Oct 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/C6522319

CENTERFIRE PATTERN # 2



OF SHOTS= 10

IN CIRCLE

HS= 3.89

2

VS= 2.53

3

GS= 4.64

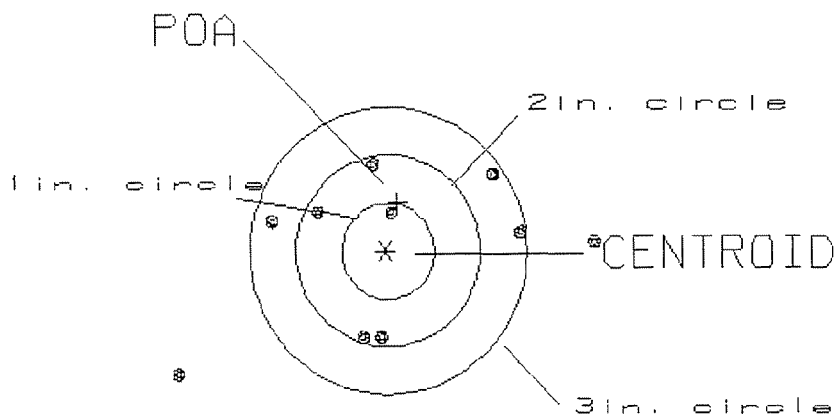
7

PATTERN #: ☐ 3 ☐
 POA TO CENTROID: .520
 MIN RADIUS : .401
 MEAN RADIUS : 1.301
 MAX RADIUS : 2.646
 CENTROID X : -.130
 CENTROID Y : -.504

19 Oct 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/C6522319

CENTERFIRE PATTERN # 3



OF SHOTS= 10

IN CIRCLE

HS= 4.58
 VS= 2.16
 GS= 4.77

1
 5
 8

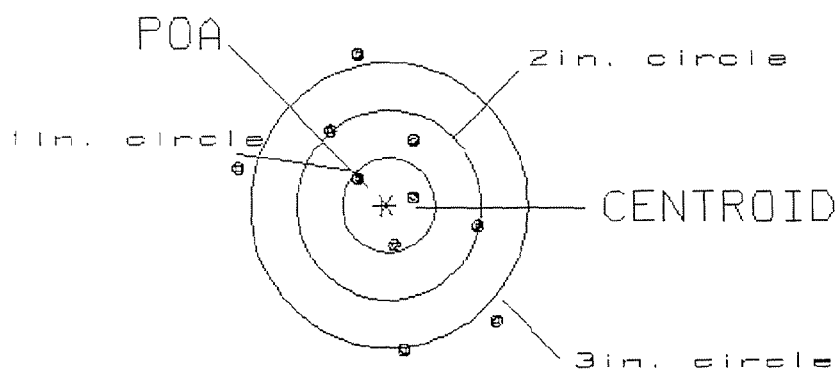
PATTERN #: ☐ 4 ☐

POA TO CENTROID: .041
MIN RADIUS : .271
MEAN RADIUS : .982
MAX RADIUS : 1.717
CENTROID X : .039
CENTROID Y : .014

18 Oct 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/C6522319

CENTERFIRE PATTERN # 4



OF SHOTS= 11

IN CIRCLE

HS= 2.80

4

VS= 3.14

7

GS= 3.24

7

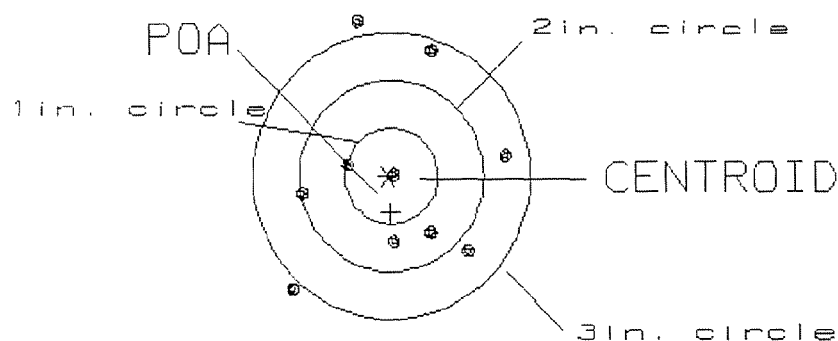
PATTERN #: 5

POA TO CENTROID: .386
 MIN RADIUS : .012
 MEAN RADIUS : .990
 MAX RADIUS : 1.708
 CENTROID X : -.029
 CENTROID Y : .385

18 Oct 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/C6522319

CENTERFIRE PATTERN # 5



OF SHOTS= 10

IN CIRCLE

HS= 2.32
 VS= 2.63
 GS= 2.92

2
 5
 8

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

R & E NUMBER 33802			
SERIAL NUMBER C6522319			
LOG-IN DATE 10-11-01			
INSPECT AND VERIFY:			
OPERATION #	OPERATION NAME	DATE	INITIAL
550	DIS-ASSEMBLE GUN	10-16-01	RTK
560 A	RE-BARREL AT CUSTOM SHOP		
B	DRILL AND TAP		
C	POLISH		
575	ASSEMBLE	10-18-01	RTK
600	PROOF		
605	CHECK HEADSPACE	10-18-01	RTK
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	10-18-01	RTK
655	FINAL INSPECT	10-19-01	RTK
660	PACK	10-19-01	RTK
		SHIP DATE	
		QAR INSPECTION DATE	

Final Inspection

In: C6522319

DATE REC'D: 10-11-01

DATE RET'D: 10-22-01

EDITOR: *[Signature]*

Item:

Barrel Assy.

☐ BARREL☒ RECEIVER☒ FRONT SIGHT BLOCK☒ REAR SIGHT BLOCK☒ SCREWS☒ FINISH

Scope Assy.

☒ SCOPE☒ SCOPE RINGS☒ MOUNTING SCREWS☒ MOUNTING BASE☒ SCREWS☒ FINISH☒ LOOSENESS☒ CLARITY

Misc.

☐ DD-250☐ BAR CODE☐ PACKAGING

Item:

Stock Assy.

☒ STOCK☒ SLING SWIVEL STUDS☒ ADJUSTABLE BUTT PLATE☒ LOCK NUTS☒ BARREL CLEARANCE☒ COLOR/FINISH

Systems Case

☒ SCOPE CASE☒ IRON SIGHTS☒ DEPLOYMENT KIT

Trigger

☒ SAFETY OPERATION☒ SET

Comments: _____

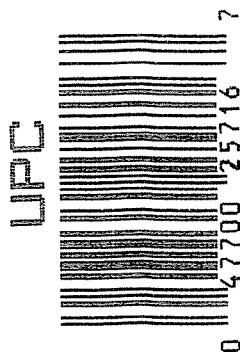
Remington®
 REG. U.S. PAT. & TM. OFF.

MODEL 700™ H24

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

SERIAL NO. C6522319	ORDER NO. 5716
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MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada. Marque Deposee.



CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6522319
7 Sep 1990

CENTROIDAL DISTANCES

0 TO	1	.220227
1 TO	2	.150864
1 TO	3	.0581808
1 TO	4	.17404
1 TO	5	.314379

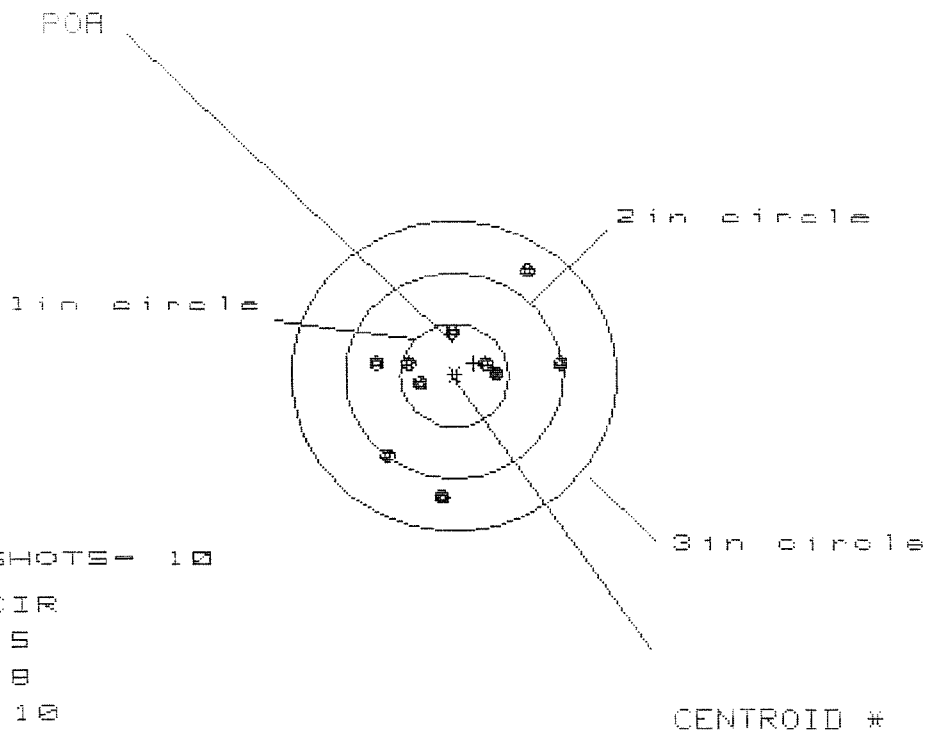
25 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1138
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.048
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .123589
THE AMR FOR THIS RIFLE IS: .7852

7 Sep 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C8522319

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 5

2in = 8

3in = 10

HS= 1.663

VS= 2.198

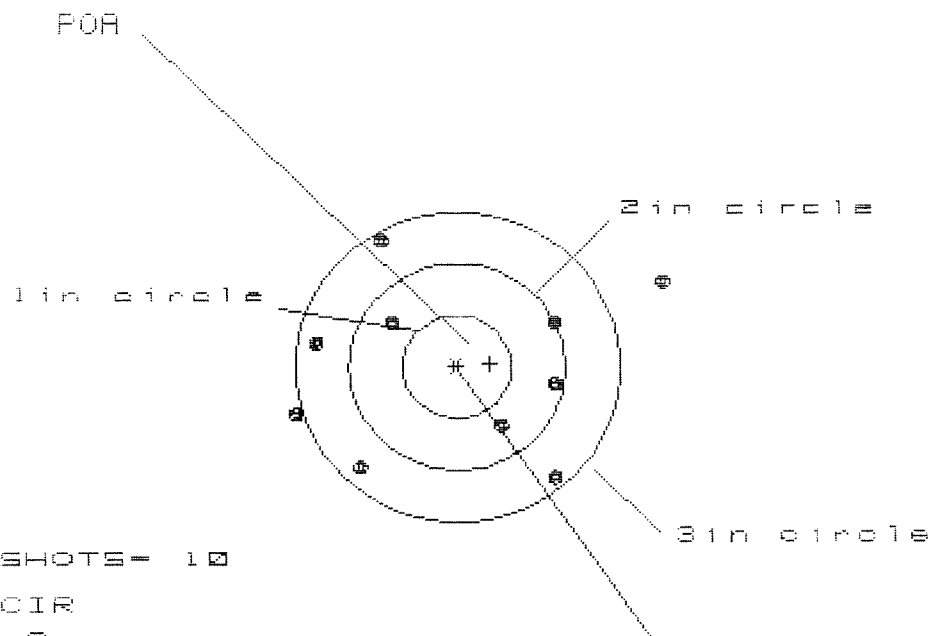
GS= 2.334

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.962	.949	1.030
MINIMUM X	:	-.701	-.714	-.633
MAXIMUM Y	:	.983	.848	.424
MINIMUM Y	:	-1.215	-.892	-.786
CENTROID X	:	-.182	-.169	-.250
CENTROID Y	:	-.124	.011	-.095
POR TO CENTROID in.	:	.220	.169	.267
MIN RADIUS	:	.276	.222	.294
MEAN RADIUS	:	.703	.627	.569
MAX RADIUS	:	1.221	1.088	1.040
HORIZONTAL SPREAD	:	1.663	1.663	1.663
VERTICAL SPREAD	:	2.198	1.740	1.211
EXTREME SPREAD	:	2.334	2.156	1.824
NUMBER IN ONE INCH CIRCLE	=		5	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	

7 Sep 1998

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CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1 in = 0

2 in = 4

3 in = 8

HS = 3.405

VS = 2.286

GS = 3.631

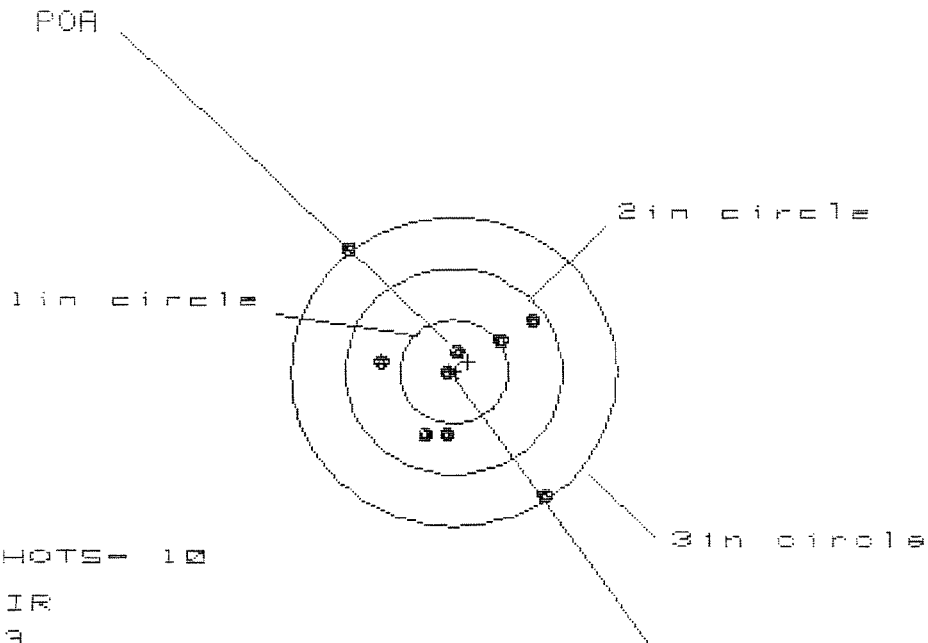
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.887	1.105	.941
MINIMUM X	:	-1.518	-1.308	-1.227
MAXIMUM Y	:	1.249	1.341	1.298
MINIMUM Y	:	-1.037	-.945	-.988
CENTROID X	:	-.300	-.510	-.346
CENTROID Y	:	-.030	-.122	-.079
FOR TO CENTROID in.	:	.302	.524	.355
MIN RADIUS	:	.718	.654	.707
MEAN RADIUS	:	1.235	1.131	1.089
MAX RADIUS	:	2.059	1.444	1.439
HORIZONTAL SPREAD	:	3.405	2.413	2.168
VERTICAL SPREAD	:	2.286	2.286	2.286
EXTREME SPREAD	:	3.631	2.762	2.762
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 3

2in = 8

3in = 9

HS= 1.8000

VS= 2.414

GS= 3.011

CENTROID #

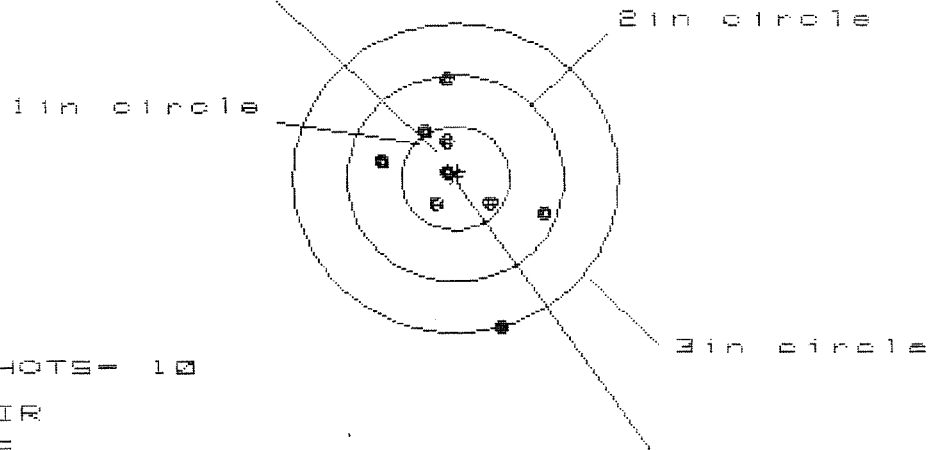
PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.875	.772	.732
MINIMUM X	:	-.925	-.802	-.705
MAXIMUM Y	:	1.215	.613	.480
MINIMUM Y	:	-1.199	-1.064	-.579
CENTROID X	:	-.131	-.028	-.125
CENTROID Y	:	-.096	-.231	-.098
POA TO CENTROID in.	:	.163	.233	.159
MIN RADIUS	:	.075	.232	.081
MEAN RADIUS	:	.666	.600	.457
MAX RADIUS	:	1.527	1.315	.875
HORIZONTAL SPREAD	:	1.800	1.574	1.437
VERTICAL SPREAD	:	2.414	1.677	1.059
EXTREME SPREAD	:	3.011	2.043	1.485
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 4

FOR



OF SHOTS = 10

IN CIR

1in = 5

2in = 9

3in = 9

HS = 1.485

VS = 2.427

GS = 2.472

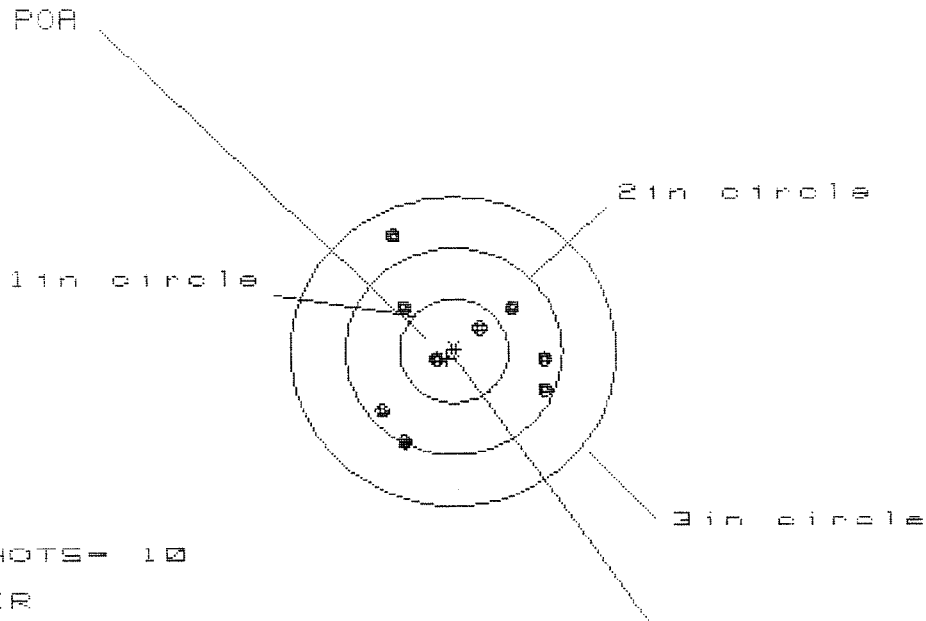
CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.791	.835	.832
MINIMUM X	:	-.694	-.650	-.653
MAXIMUM Y	:	.956	.793	.416
MINIMUM Y	:	-1.471	-.517	-.418
CENTROID X	:	-.019	-.063	-.060
CENTROID Y	:	-.063	.100	.001
FOR TO CENTROID in.	:	.066	.119	.060
MIN RADIUS	:	.083	.105	.018
MEAN RADIUS	:	.613	.479	.437
MAX RADIUS	:	1.524	.983	.931
HORIZONTAL SPREAD	:	1.485	1.485	1.485
VERTICAL SPREAD	:	2.427	1.310	.834
EXTREME SPREAD	:	2.472	1.569	1.559
NUMBER IN ONE INCH CIRCLE	=		5	
NUMBER IN TWO INCH CIRCLE	=		9	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 3

2in = 8

3in = 10

HS= 1.583

VS= 2.094

GS= 2.138

CENTROID #

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	.886
MINIMUM X	-.697
MAXIMUM Y	1.173
MINIMUM Y	-.921
CENTROID X	.063
CENTROID Y	.073
FOR TO CENTROID in.	.097
MIN RADIUS	.171
MEAN RADIUS	.709
MAX RADIUS	1.311
HORIZONTAL SPREAD	1.583
VERTICAL SPREAD	2.094
EXTREME SPREAD	2.138
NUMBER IN ONE INCH CIRCLE =	3
NUMBER IN TWO INCH CIRCLE =	8
NUMBER IN THREE INCH CIRCLE =	10

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6522319

DATE 8/31/90

TESTER JS

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	212	225	227	244	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	212	230	216	262	
PULL #3	210	224	202	271	
PULL #4	244	225	210	284	
PULL #5	238	222	215	286	
TOTAL	1116	1126			
AVG.	2232	2252			

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	304	286		
PULL #2	302	288		
PULL #3	301	281		
PULL #4	283	285		
PULL #5	288	283		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	405	399		389
PULL #2	401	394		390
PULL #3	402	399		389
PULL #4	397	400		408
PULL #5	398	399		391
TOTAL				
AVG.				

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6522319

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	8 2	90	RW
600	Proof	8 2	90	RW
607	Check Headspace	8 2	90	RW
610	Dis-assemble Gun	8 2	90	RW
612	Magnaflux Barrel Action		8/7/90	KR
	Magnaflux Bolt		8/7/90	KR
615	Rollmark Caliber		8/7/90	GL
617	Drill and Tap Sight Holes		8/10/90	LB
618	Polish Barrel RB		8/14/90	WB
620	Apply Coatings (Barrel Action)		8/24/90	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/27/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/27/90	RW
	C) Inspect Ejector Hole for Chamfer		8/27/90	RW
	D) Oil Firing Pin Ass'y		8/27/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		8/31/90	GB

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	3 ³ / ₄	4	3 ³ / ₄			9/3/90	WB
	G) Safety Off Force	2	2	2			9/5/90	WB
	H) Trigger Pull Test & Retainability						8/31/90	GL
	I) Firing Pin Indent	.022	.022	.022			9/5/90	WB
	J) Assemble Stock						9/5/90	RW
	K) Assemble Swivel Studs						9/6/90	JSB
	L) Attach Front and Rear Sight Assemblies						9/5/90	RW
	M) Iron Sight Alignment						9/5/90	RW
	N) Detach Front & Rear Sights & place in numbered container						9/5/90	RW
	O) Attach Scope to Rifle						9/6/90	RW
	P) Detach & Attach Scope 20 Times						9/5/90	RW
640	Gallery Target & Test						9-7-90	DH
	A) Time						9-7-90	DH
	B) Malfunctions						9-7-90	DH
	C) Pierced Primers						9-7-90	DH
	D) Optical Clarity of Scope						9-7-90	DH
645	Inspect for Live Ammo						9-7-90	DH
655	Final Inspection							
	A) Headspace						9/9/90	JSB
	B) Trigger Pull	244	262	271	284	284	9/9/90	JSB
	C) Function						9/9/90	JSB
660	Pack						9-9-90	DH