

C6225201

MODEL 700™ M24

Model **SWS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



Repair Inquiry

Repair Number: **RE00062256**Serial: C6225201 Model 700 Center Fire Caliber:
7.62 NATO M-24 (SWS)

Repairman:

Status:

Closed 2/26/2003 11:52:30 AM

Verify Repair

Address Information

Customer:

☒ Received From

Return To:

☐ Received FromName: **JOINT TRANS DIRECTORATE****JOINT TRANS DIRECTORATE**Address 1: **ATTN AFZH JTM M****ATTN AFZH JTM M**Address 2: **BOX 339500 MS 53**

PO Box:

BOX 339500 MS 53

PO Box:

City: **FORT LEWIS****FORT LEWIS**State: **WA**Zip Code: **98433**Country: **US**State: **WA**Zip Code: **98433**Country: **US**

FFL:

Contact / Condition

Problems

Estimate

History / Status

Shipping / Billing

Contact Information

Phone:

Fax:

Email:

Comments:

Received Condition

Poor

Condition
Notes:CSR
Notes:

Accessories Received

Code	Desc	Qty
A007	With Stud	1
A017	Scope Base	1
X	FRT & REAR SGT BA	1

Repair Search

Refresh

Close

nagletj

2/26/2003

1:04 PM

CAPS

NUM

INS

SCRL

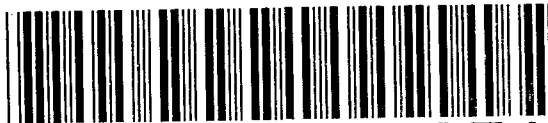
start

Inbox - Micros...

Calendar - Micro...

Arms Services R...

1:04 PM

Serial Number: **C6225201**Model: **700****RE00062256**

Repair Inquiry

Repair Number: **RE00143869**

Serial: C6225201 Model M24 SWS Center Fire
Caliber: 7.62 NATO

Repairman:

Status: Closed 4/1/2008 7:14:28 AM

Verify Repair

Address Information

Customer:

☒ Received From

Return To:

☐ Received From

Name: COMM 1 ST SFG

COMM 1 ST SFG

Address 1: ATTN 3/1/ BENDELL

ATTN 3/1/ BENDELL

Address 2: PO Box:

PO Box:

City: FORT LEWIS

FORT LEWIS

State: WA Zip Code: 98433

Country: US

State: WA Zip Code: 98433

Country: US

FFL:

Contact / Condition

Problems

Estimate

History / Status

Shipping / Billing

Contact Information

Phone: NN

Fax:

Email:

Comments:

Received Condition

Fair

Condition

Notes:

CSR

Notes:

Accessories Received

Code	Desc	Qty
A007	With Stud	3
A010	Hard Case	1
A057	Frt and Rear Sgt Base	1

Repair Search

Refresh

Close

nagletj

4/1/2008

2:09 PM

CAPS

NUM

INTS

SCSL



Serial Number: **C6225201**
Model: **M24 SWS**

RE00143869

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

R & E NUMBER 00143869

SERIAL NUMBER C6225201

LOG-IN DATE 4-1-08

OPERATION #	OPERATION NAME	DATE	INITIAL
500	DIS-ASSEMBLE GUN	4-7-08	RTZ
505	RE-BARREL	4-7-08	RTZ
560	ASSEMBLE	4-7-08	TRW
600	PROOF	4-7-08	TRW
605	CHECK HEADSPACE	4-7-08	TRW
610	DIS-ASSEMBLE GUN	4-8-08	TRW
612	MAGNAFLUX	4-9-08	TRW
510	DRILL AND TAP	4-9-08	FM
615	ROLLMARK CALIBER	4-9-08	CW
618	ROTO-BLAST	4-9-08	DC
620	APPLY COATINGS	4-11-08	CW
625	FINAL ASSEMBLY	4-14-08	RTZ
640	FUNCTION TEST AND	4-15-08	TRW
650	TARGET	4-15-08	TRW
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
670	FINAL INSPECTION	4-15-08	RP
	A) HEADSPACE	4-16-08	RTZ
	B) TRIGGER PULL	4-16-08	RTZ
680	F) SAFETY ON FORCE	4-16-08	RTZ
	G) SAFETY OFF FORCE	4-16-08	RTZ
	I) FIRING PIN INDENT	4-16-08	RTZ
690	PACK	4-16-08	FM

MAGNA - FLUX
2008
OPERATOR *TRW*

N/A

254 252 250 252 255

6° 6° 6°

3° 3° 3°

.022 .022 .022

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6225201.___0
FILE DATE AND TIME: 04/16/2008 13:10

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.037
The Average Y Centroid of the Five Target Set:	0.030
The Average Point of Impact of the Five Target Set:	0.047
The Average Mean Radius of the Five Target Set:	0.748
The Distance from POA to Centroid Target #1:	0.136
The Distance from Centroid Target #2 to Centroid Target #1:	0.169
The Distance from Centroid Target #3 to Centroid Target #1:	0.265
The Distance from Centroid Target #4 to Centroid Target #1:	0.381
The Distance from Centroid Target #5 to Centroid Target #1:	0.110

SERIAL NUMBER: C6225201. 0

TARGET NUMBER: 1

FILE DATE: 04/16/2008

FILE TIME: 13:10

X CENTROID: 0.104

Y CENTROID: -0.088

POA TO CENTROID: 0.136

HORZ SPREAD: 1.961

VERT SPREAD: 1.962

GROUP SPREAD: 1.962

MIN RADIUS: 0.205

MAX RADIUS: 1.117

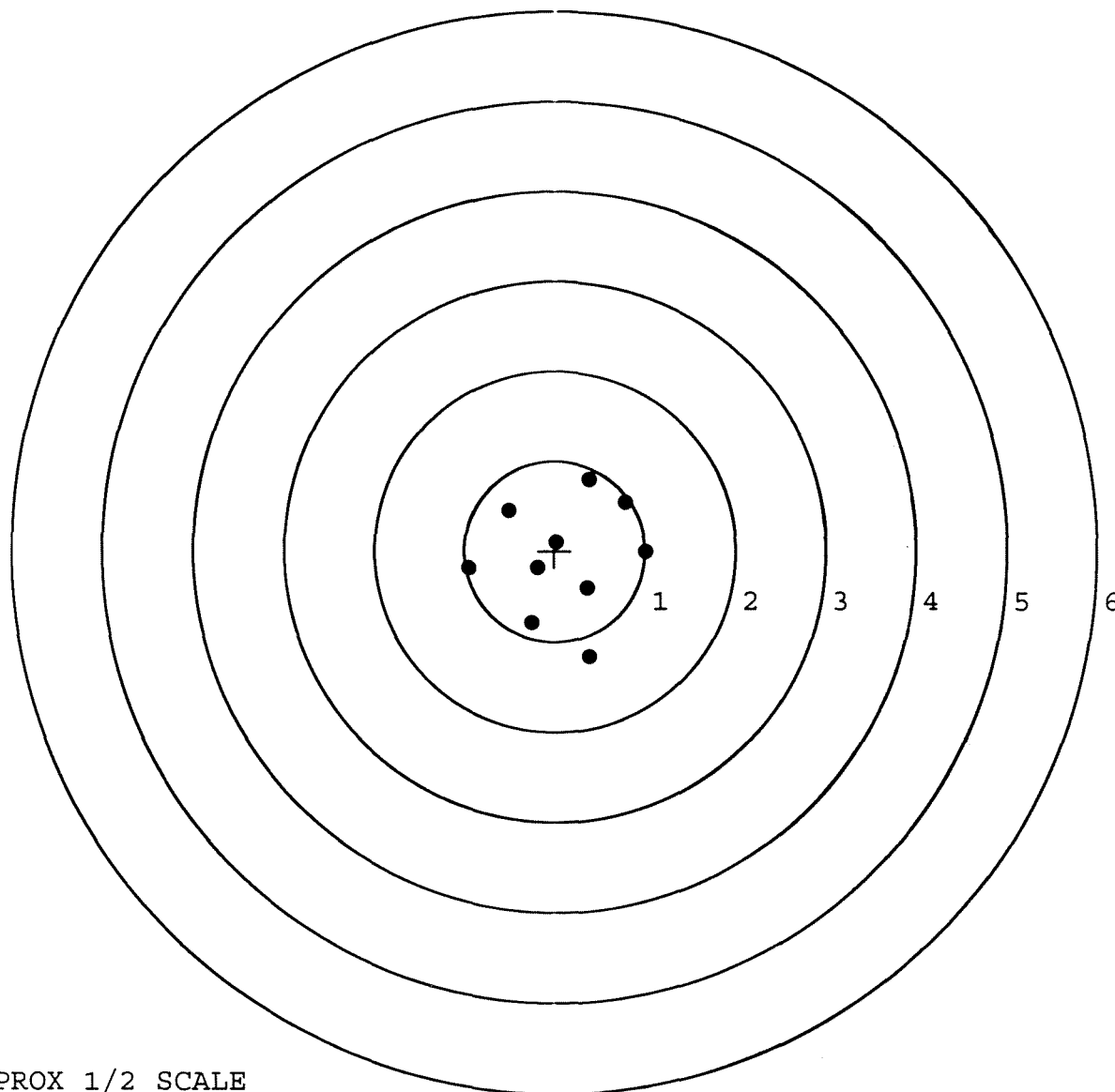
MEAN RADIUS: 0.749

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.381	0.795
2:	0.784	0.545
3:	1.010	-0.009
4:	-0.512	0.450
5:	0.020	0.099
6:	-0.193	-0.187
7:	0.363	-0.411
8:	-0.255	-0.799
9:	-0.951	-0.196
10:	0.392	-1.167



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6225201. __0

TARGET NUMBER: 2

FILE DATE: 04/16/2008

FILE TIME: 13:10

X CENTROID: -0.064

Y CENTROID: -0.072

POA TO CENTROID: 0.097

HORZ SPREAD: 2.319

VERT SPREAD: 1.031

GROUP SPREAD: 2.356

MIN RADIUS: 0.251

MAX RADIUS: 1.228

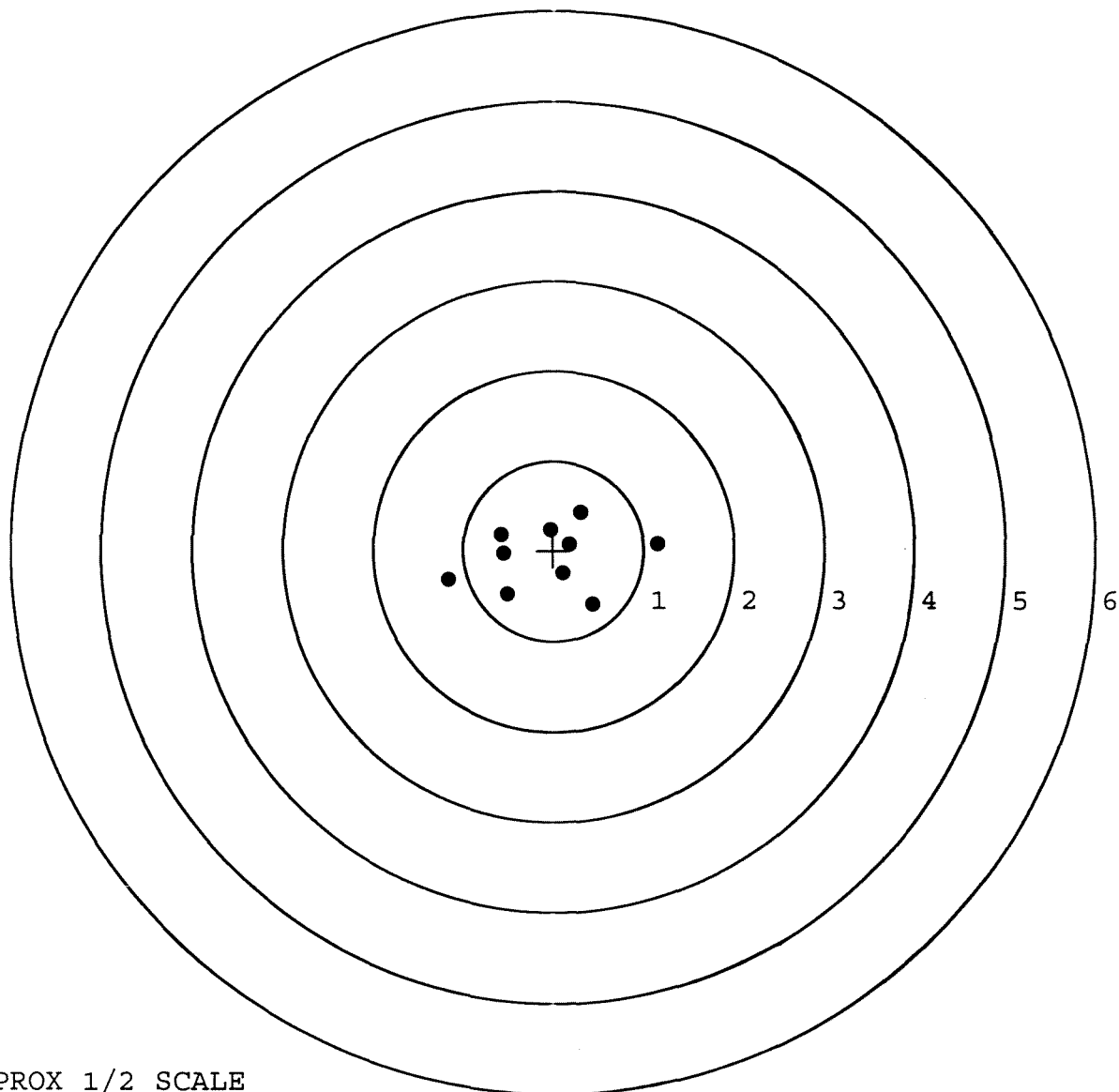
MEAN RADIUS: 0.622

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	1.154	0.080
2:	0.437	-0.598
3:	-1.165	-0.338
4:	-0.507	-0.487
5:	-0.550	-0.035
6:	-0.581	0.175
7:	0.306	0.433
8:	-0.029	0.233
9:	0.182	0.070
10:	0.109	-0.254

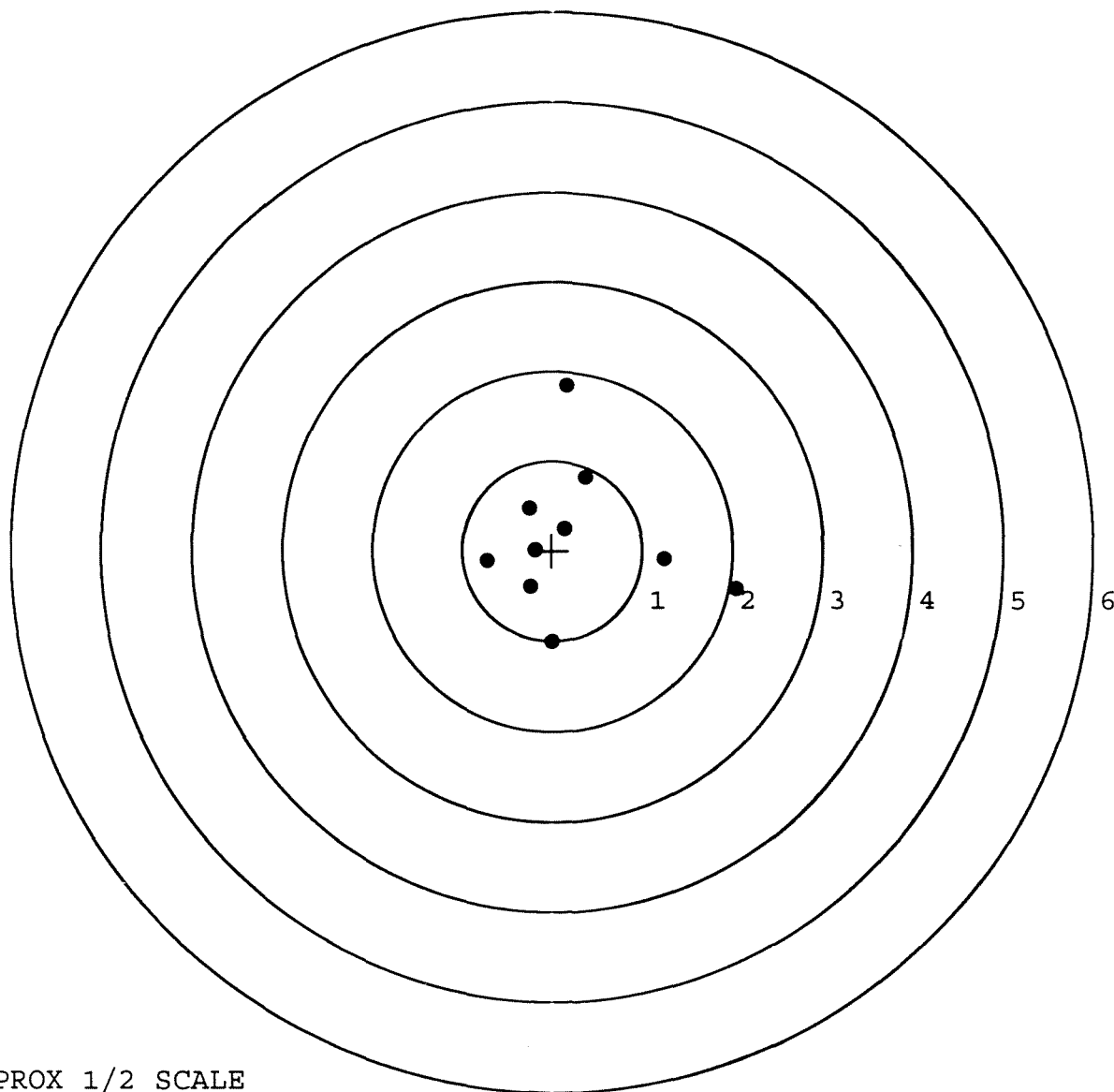


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6225201. __0
TARGET NUMBER: 3
FILE DATE: 04/16/2008
FILE TIME: 13:10

X CENTROID: 0.253
Y CENTROID: 0.130
POA TO CENTROID: 0.285
HORZ SPREAD: 2.759
VERT SPREAD: 2.853
GROUP SPREAD: 2.940
MIN RADIUS: 0.160
MAX RADIUS: 1.867
MEAN RADIUS: 0.943
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 5
in 3 IN DIAMETER: 8

POINT#	X	Y
1:	0.370	0.818
2:	-0.255	0.470
3:	0.138	0.241
4:	-0.189	0.007
5:	-0.241	-0.406
6:	-0.003	-1.015
7:	-0.725	-0.119
8:	1.241	-0.099
9:	2.034	-0.431
10:	0.165	1.838



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6225201. 0

TARGET NUMBER: 4

FILE DATE: 04/16/2008

FILE TIME: 13:10

X CENTROID: -0.187

Y CENTROID: 0.158

POA TO CENTROID: 0.245

HORZ SPREAD: 1.888

VERT SPREAD: 2.091

GROUP SPREAD: 2.172

MIN RADIUS: 0.325

MAX RADIUS: 1.190

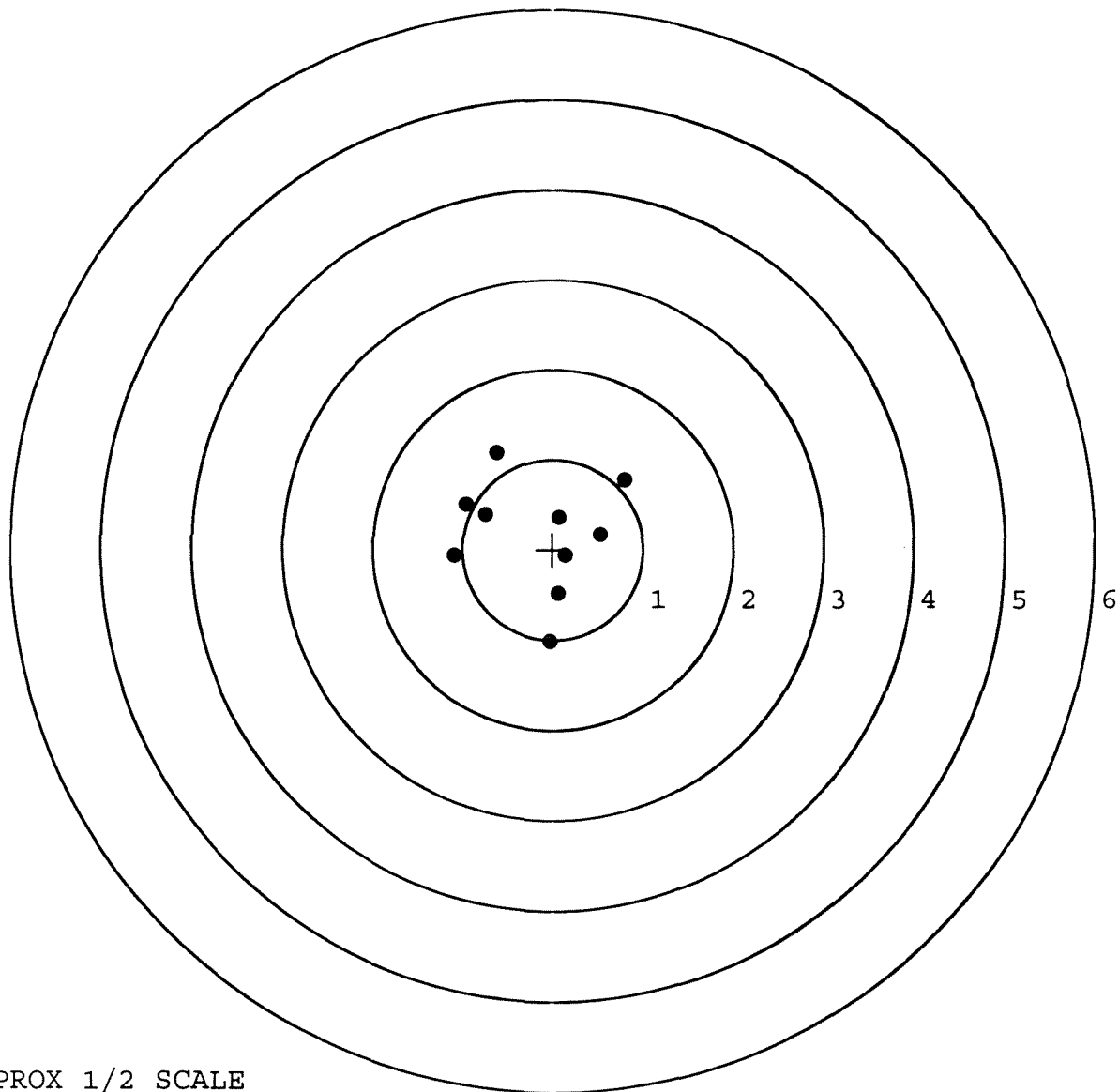
MEAN RADIUS: 0.788

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.799	0.772
2:	0.069	0.357
3:	0.523	0.165
4:	0.146	-0.071
5:	0.060	-0.492
6:	-0.040	-1.023
7:	-1.089	-0.077
8:	-0.753	0.384
9:	-0.963	0.495
10:	-0.626	1.068



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6225201. __0

TARGET NUMBER: 5

FILE DATE: 04/16/2008

FILE TIME: 13:10

X CENTROID: 0.080

Y CENTROID: 0.019

POA TO CENTROID: 0.082

HORZ SPREAD: 2.140

VERT SPREAD: 1.767

GROUP SPREAD: 2.194

MIN RADIUS: 0.176

MAX RADIUS: 1.220

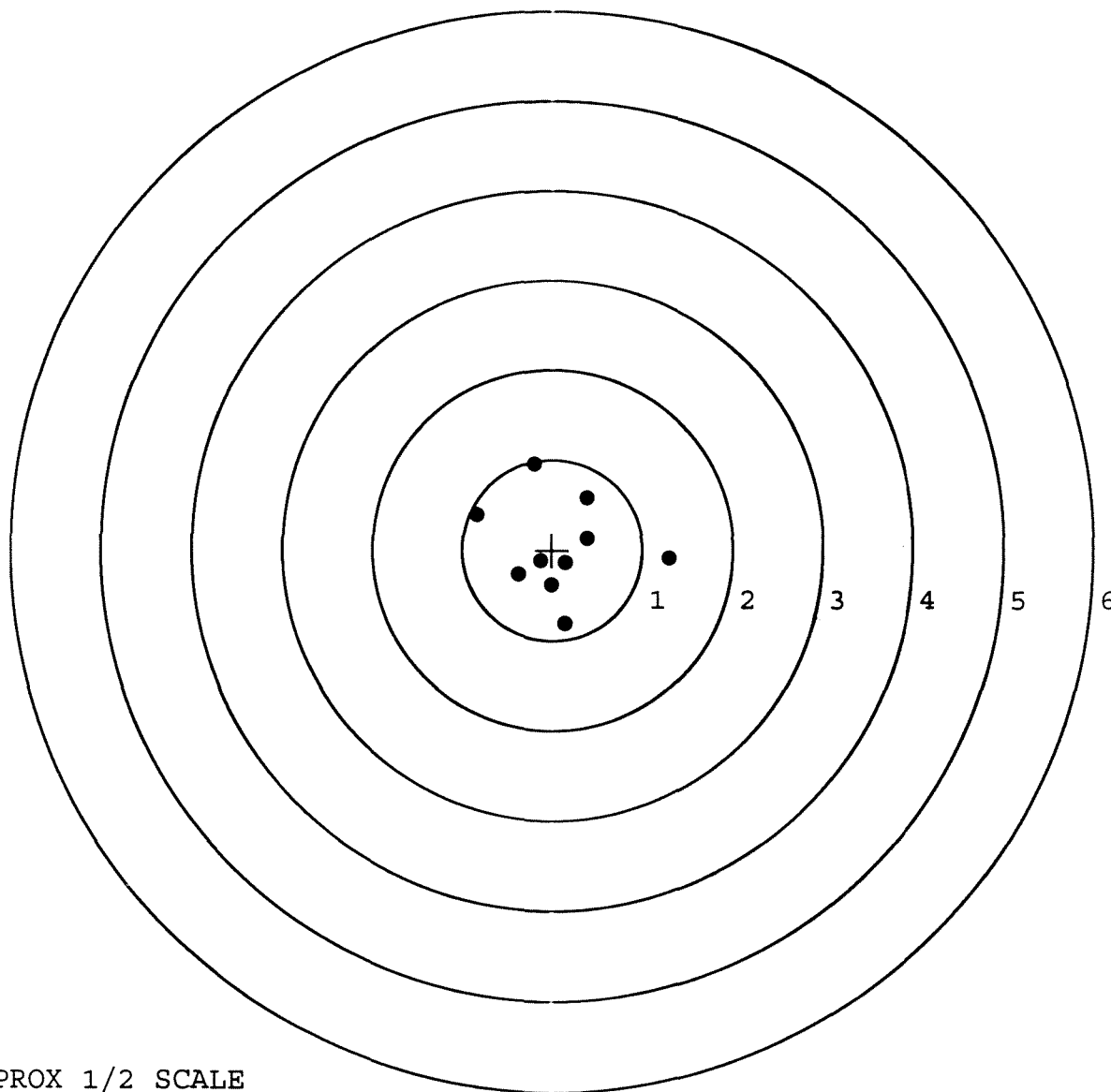
MEAN RADIUS: 0.638

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.204	0.953
2:	-0.846	0.384
3:	0.381	0.577
4:	1.294	-0.100
5:	0.391	0.127
6:	0.152	-0.141
7:	-0.129	-0.125
8:	-0.010	-0.391
9:	-0.375	-0.276
10:	0.144	-0.814



TARGET APPROX 1/2 SCALE

Remington®



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

MODEL 700™ M24

SERIAL NO.
C6225201

ORDER NO.
5716

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

01



5716 C6225201

UPC



0 47700 25716 7

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER

M2400010499

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6225201.___0

FILE DATE AND TIME: 03/21/2003 22:39

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.057
The Average Y Centroid of the Five Target Set:	-0.007
The Average Point of Impact of the Five Target Set:	0.058
The Average Mean Radius of the Five Target Set:	0.602
The Distance from POA to Centroid Target #1:	0.284
The Distance from Centroid Target #2 to Centroid Target #1:	0.188
The Distance from Centroid Target #3 to Centroid Target #1:	0.296
The Distance from Centroid Target #4 to Centroid Target #1:	0.255
The Distance from Centroid Target #5 to Centroid Target #1:	0.497

SERIAL NUMBER: C6225201. __0

TARGET NUMBER: 1

FILE DATE: 03/21/2003

FILE TIME: 22:39

X CENTROID: -0.256

Y CENTROID: 0.123

POA TO CENTROID: 0.284

HORZ SPREAD: 1.772

VERT SPREAD: 1.819

GROUP SPREAD: 1.787

MIN RADIUS: 0.095

MAX RADIUS: 1.082

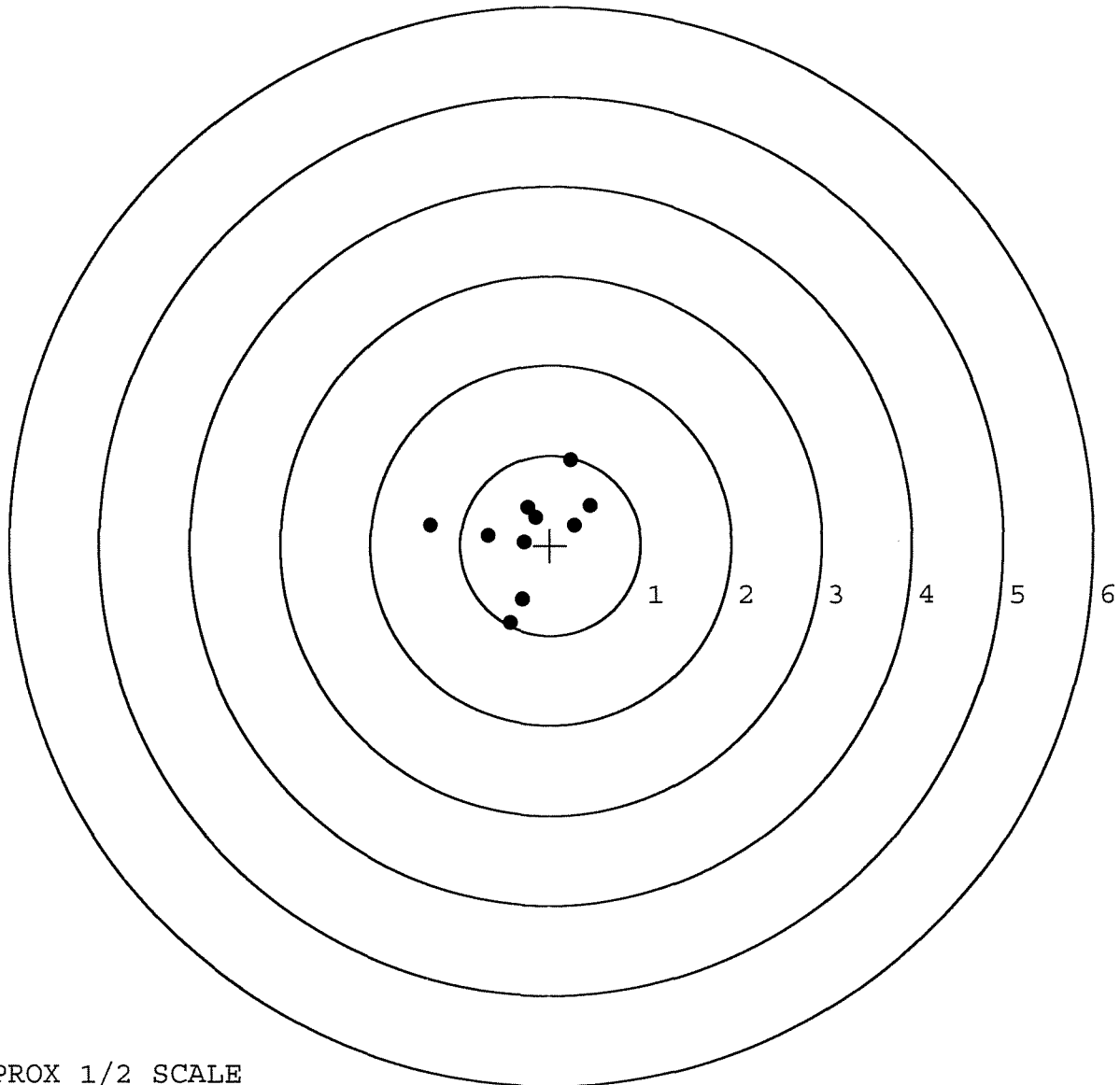
MEAN RADIUS: 0.611

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.440	-0.872
2:	-0.308	-0.601
3:	0.266	0.224
4:	0.438	0.445
5:	0.226	0.947
6:	-0.257	0.426
7:	-0.168	0.308
8:	-0.288	0.034
9:	-0.693	0.105
10:	-1.334	0.215



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6225201. __0

TARGET NUMBER: 2

FILE DATE: 03/21/2003

FILE TIME: 22:39

X CENTROID: -0.134

Y CENTROID: -0.021

POA TO CENTROID: 0.136

HORZ SPREAD: 1.966

VERT SPREAD: 1.316

GROUP SPREAD: 1.968

MIN RADIUS: 0.102

MAX RADIUS: 1.119

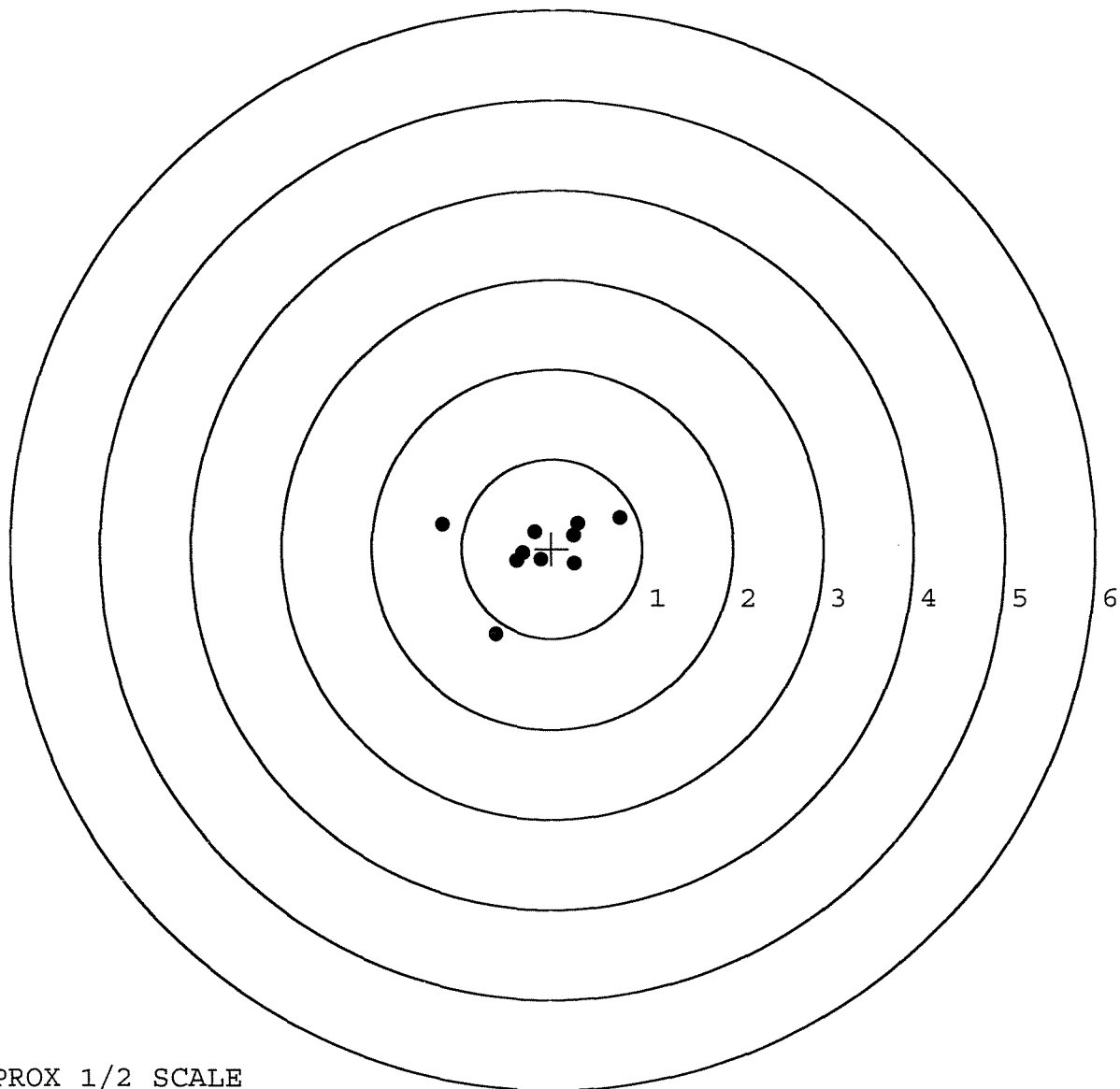
MEAN RADIUS: 0.527

IN 1 IN DIAMETER: 6

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.617	-0.966
2:	-1.215	0.268
3:	0.751	0.350
4:	0.282	0.284
5:	0.238	0.153
6:	0.251	-0.172
7:	-0.198	0.188
8:	-0.123	-0.122
9:	-0.321	-0.052
10:	-0.389	-0.137



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6225201.___0

TARGET NUMBER: 3

FILE DATE: 03/21/2003

FILE TIME: 22:39

X CENTROID: -0.011

Y CENTROID: -0.042

POA TO CENTROID: 0.044

HORZ SPREAD: 1.273

VERT SPREAD: 1.709

GROUP SPREAD: 1.912

MIN RADIUS: 0.090

MAX RADIUS: 1.070

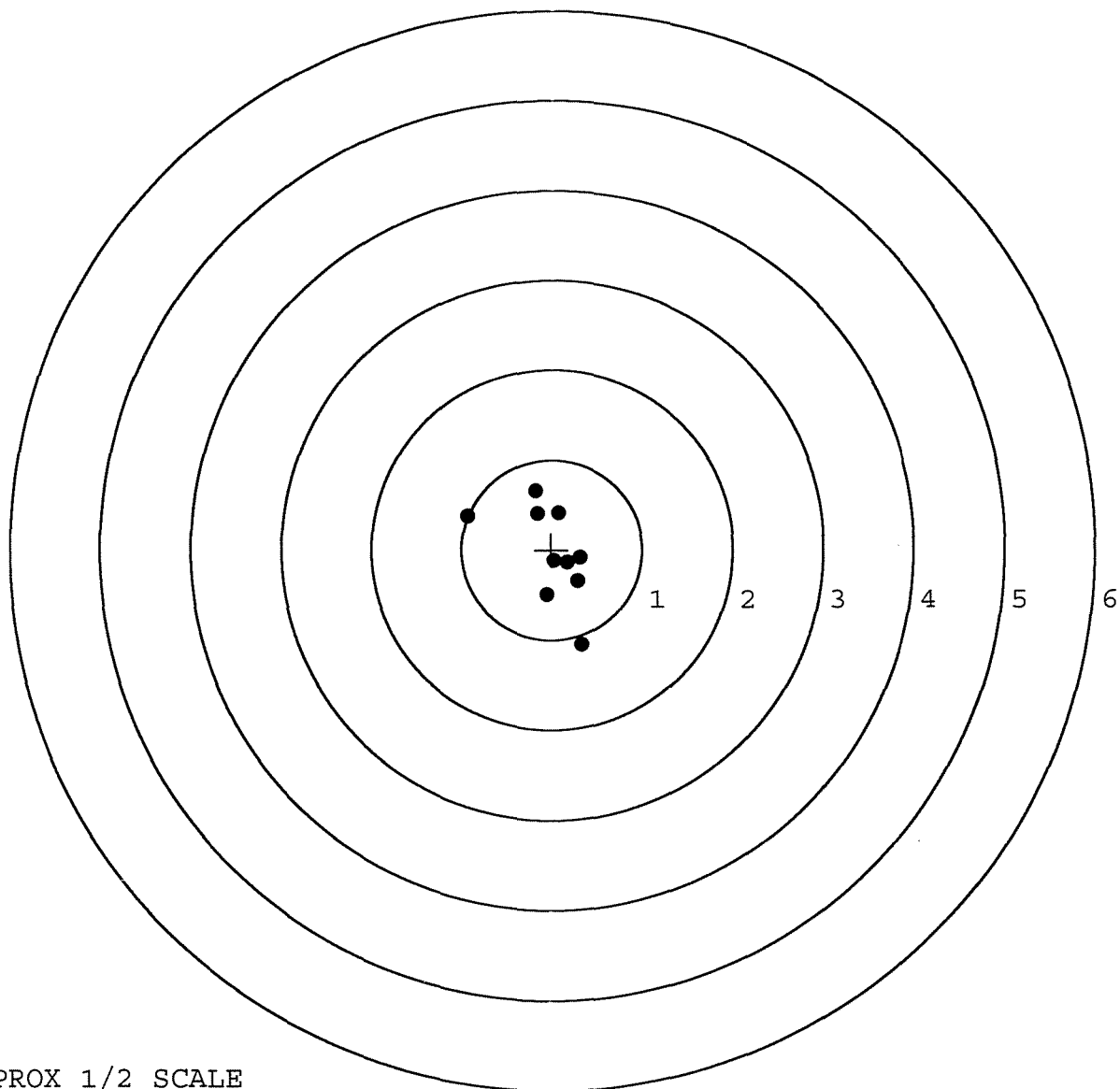
MEAN RADIUS: 0.527

IN 1 IN DIAMETER: 7

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.337	-1.054
2:	-0.054	-0.504
3:	0.290	-0.353
4:	0.174	-0.141
5:	0.320	-0.089
6:	0.080	0.411
7:	-0.164	0.403
8:	-0.186	0.655
9:	-0.936	0.372
10:	0.031	-0.122



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6225201. __0

TARGET NUMBER: 4

FILE DATE: 03/21/2003

FILE TIME: 22:39

X CENTROID: -0.001

Y CENTROID: 0.114

POA TO CENTROID: 0.114

HORZ SPREAD: 1.554

VERT SPREAD: 2.255

GROUP SPREAD: 2.361

MIN RADIUS: 0.351

MAX RADIUS: 1.609

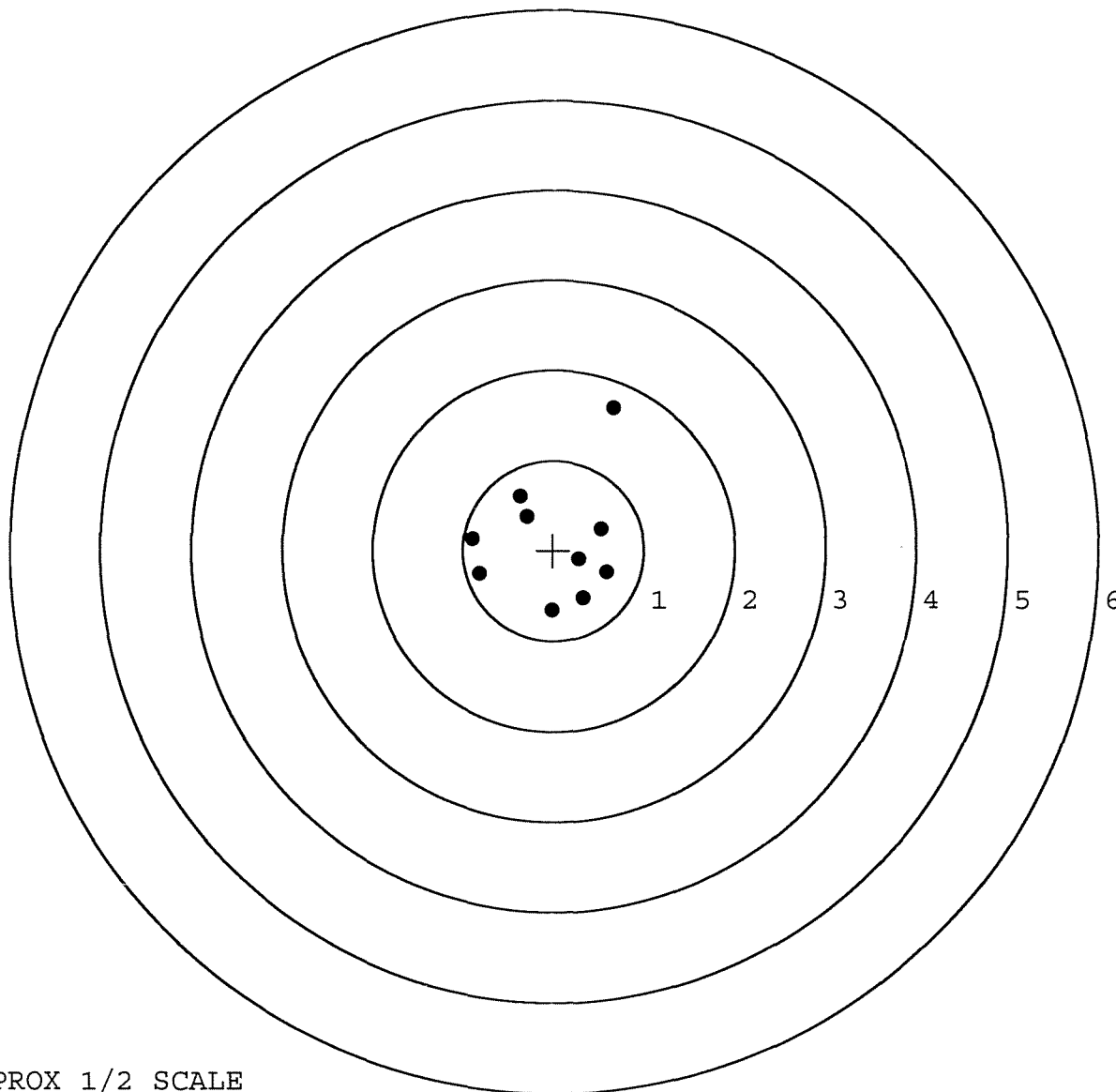
MEAN RADIUS: 0.749

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 9

POINT#	X	Y
1:	-0.015	-0.673
2:	0.329	-0.527
3:	0.587	-0.240
4:	0.282	-0.094
5:	0.523	0.246
6:	-0.815	-0.262
7:	-0.894	0.130
8:	-0.294	0.378
9:	-0.370	0.604
10:	0.660	1.582

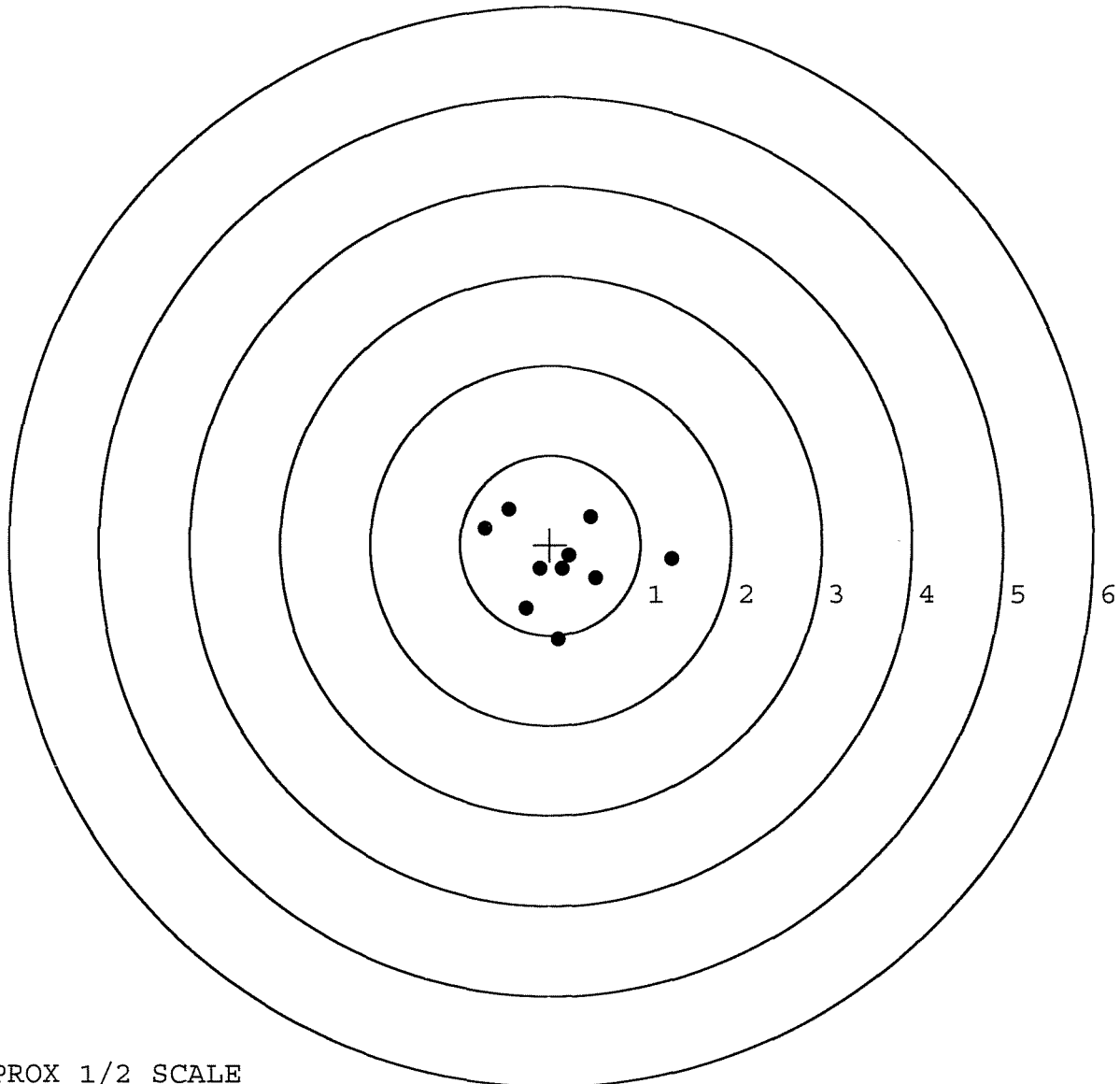


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6225201. __0
TARGET NUMBER: 5
FILE DATE: 03/21/2003
FILE TIME: 22:39

X CENTROID: 0.115
Y CENTROID: -0.207
POA TO CENTROID: 0.237
HORZ SPREAD: 2.079
VERT SPREAD: 1.448
GROUP SPREAD: 2.107
MIN RADIUS: 0.068
MAX RADIUS: 1.232
MEAN RADIUS: 0.596
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	1.346	-0.163
2:	0.506	-0.372
3:	0.095	-1.051
4:	-0.267	-0.713
5:	0.136	-0.272
6:	0.212	-0.124
7:	0.441	0.316
8:	-0.120	-0.273
9:	-0.466	0.397
10:	-0.733	0.181



TARGET APPROX 1/2 SCALE

M24 INSPECTION CHECKLIST
CONTRACT #: DAAE-20-02-D-0127

R & E NUMBER	602256		
SERIAL NUMBER	C60225201		
LOG-IN DATE	2-26-03		
INSPECT AND VERIFY:			
OPERATION #	OPERATION NAME	DATE	INITIAL
550	DIS-ASSEMBLE GUN	2/27/03	RTL
560 A	RE-BARREL	3-4-03	RTL
B	DRILL AND TAP	3-6-03	TRL
575	ASSEMBLE	3-5-03	RTL
600	PROOF	3-5-03	AC
605	CHECK HEADSPACE	3-5-03	AC
610	DIS-ASSEMBLE GUN	3-5-03	AC
612	MAGNAFLUX	3-7-03	JO
615	ROLLMARK CALIBER	3-7-03	B
618	ROTO-BLAST	3-10-03	KO
620	APPLY COATINGS	3-18	TA
625 A	FINAL ASSEMBLY	3-19-03	RL
B	TRIGGER PULL TEST		
C	SAFETY "ON" FORCE		
D	SAFETY "OFF" FORCE		
E	FIRING PIN INDENT		
640	TARGET	3-20-03	RL
655	FINAL INSPECT	3-21-03	RTL
660	PACK	3-21-03	JA
		SHIP DATE	
	QAR INSPECTION DATE		

CONTRACT # DAAA21-87-C-0086

INTERCHANGEABILITY

GUN SERIAL # C6225201

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	4 21	89	RW
600	Proof	4 21	89	RW
607	Check Headspace	4 21	89	RW
610	Dis-assemble Gun	4 21	89	RW
612	Magnaflux Barrel Action		4/26	KCR
	Magnaflux Bolt		4/27	KCR
615	Rollmark Caliber		4/27	GL
617	Drill and Tap Sight Holes	4 27	89	JB
618	Polish Barrel RB	4 27	89	BT
620	Apply Coatings (Barrel Action)		5-2-89	TJA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		5/22/89	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/22/89	RW
	C) Inspect Ejector Hole for Chamfer		5/22/89	RW
	D) Oil Firing Pin Ass'y		5/22/89	RW
	E) Adjust Trigger Pull to Min Setting and Stake		5/26/89	WB

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			5/31/89	JL
	G) Safety Off Force	3	3	3			5/31/89	JL
	H) Trigger Pull Test & Retainability						5/26/89	W.B.
	I) Firing Pin Indent	.021	.020.5	.020			5/30/89	JL
	J) Assemble Stock						5/30/89	RW
	K) Assemble Swivel Studs						31 May 89	JS
	L) Attach Front and Rear Sight Assemblies						5/30/89	RW
	M) Iron Sight Alignment						5/30/89	RW
	N) Detach Front & Rear Sights & place in numbered container						5/30/89	RW
	O) Attach Scope to Rifle						5/30/89	JL
	P) Detach & Attach Scope 20 Times						5/30/89	JL
640	Gallery Target & Test	51 R	102L				5-30-89	JS
	A) Time						"	JS
	B) Malfunctions						"	JS
	C) Pierced Primers						"	JS
	D) Optical Clarity of Scope						"	JS
645	Inspect for Live Ammo						5-30-89	JS
655	Final Inspection							
	A) Headspace						31 May 89	JS
	B) Trigger Pull	2.64	2.69	2.70	2.73	2.70	31 May 89	JS
	C) Function						31 May 89	JS
660	Pack						27 June 89	JS

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6225201DATE 3/30/90TESTER PH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#	COMMENTS
PULL #1	2.21	2.16	2.34	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.09	2.03	2.05	
PULL #3	2.04	2.03	2.20	
PULL #4	2.07	2.05	2.12	
PULL #5	2.03	2.01	2.12	
TOTAL	10.44	10.28	10.83	
AVG.	2.08	2.05	2.16	

	3.00# INITIAL	3.00# AFTER 20 CYCLES	COMMENTS
PULL #1	3.27	3.04	
PULL #2	3.09	3.03	
PULL #3	3.13	3.05	
PULL #4	3.16	3.10	
PULL #5	3.19	3.13	
TOTAL	15.84	15.35	
AVG.	3.16	3.07	

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.22	4.09		
PULL #2	4.12	4.11		
PULL #3	4.16	4.04		
PULL #4	4.19	4.19		
PULL #5	4.14	4.21		
TOTAL	20.83	20.64		
AVG.	4.16	4.12		

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6225201
1 Jun 1989

CENTROIDAL DISTANCES

0 TO	1	.122287
1 TO	2	.0957549
1 TO	3	.332569
1 TO	4	.14857
1 TO	5	.0630317

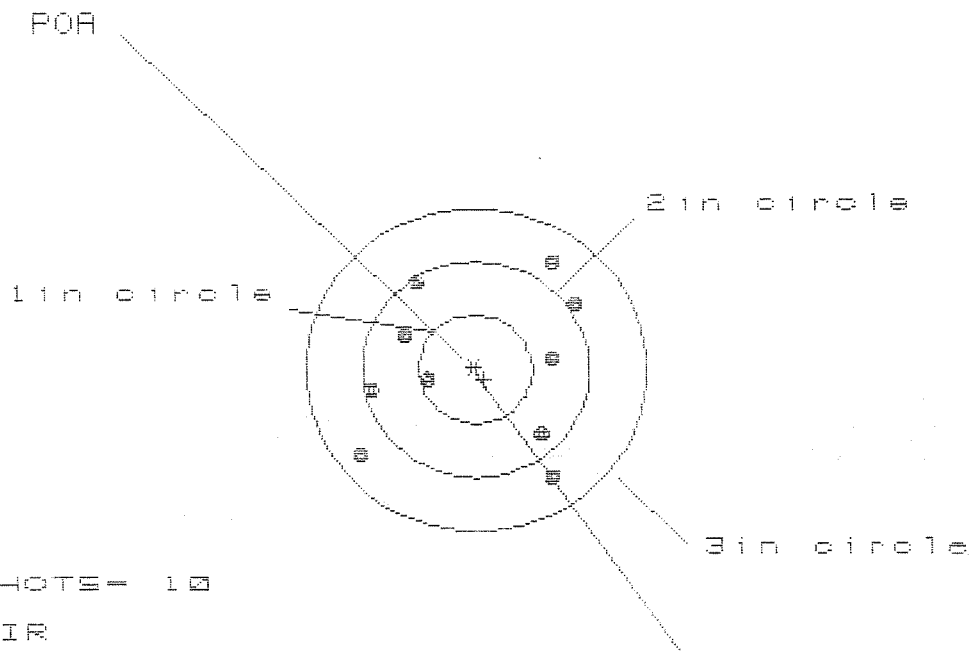
42 8 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.047
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0412
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0625015
THE AMR FOR THIS RIFLE IS: .9118

30 May 1989

FILE:/PATTERNING/CENTERFIRE_PATT/05225201

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 5

3 in = 10

HS= 1.948

VS= 1.962

GS= 2.471

CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.889	.771	.839
MINIMUM X	-1.059	-1.000	-.932
MAXIMUM Y	.958	.866	.728
MINIMUM Y	-1.004	-1.096	-.816
CENTROID X	-.077	.041	-.027
CENTROID Y	.095	.187	.325
POA TO CENTROID in.	.122	.192	.326
MIN RADIUS	.399	.543	.560
MEAN RADIUS	.937	.886	.834
MAX RADIUS	1.350	1.224	1.043
HORIZONTAL SPREAD	1.948	1.771	1.771
VERTICAL SPREAD	1.962	1.962	1.544
EXTREME SPREAD	2.471	2.196	1.946
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	10		

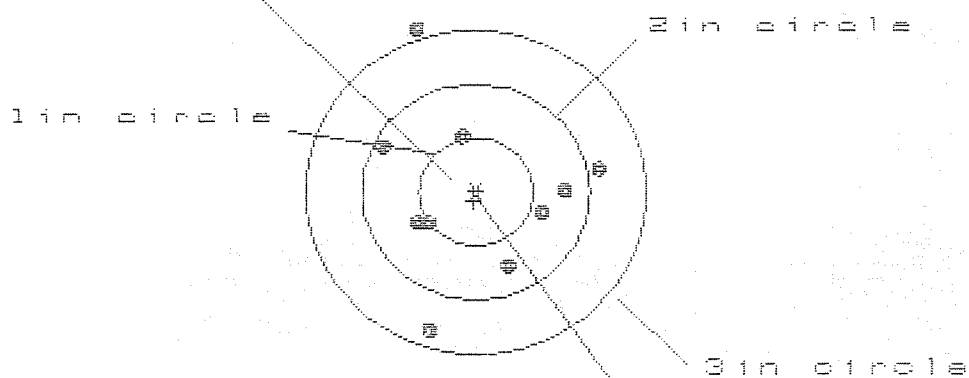
30 May 1989

FILE:/PATTERNING/CENTERFIRE_PATT/08225201

CENTERFIRE PATTERNS

2

FOR



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 7

3 in = 9

HS = 1.874

VS = 2.705

GS = 2.706

CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.047	.994	.935
MINIMUM X	:	-.827	-.880	-.939
MAXIMUM Y	:	1.467	.670	.535
MINIMUM Y	:	-1.238	-1.075	-.620
CENTROID X	:	.018	.071	.130
CENTROID Y	:	.083	-.080	.055
FOR TO CENTROID in.	:	.085	.106	.141
MIN RADIUS	:	.484	.477	.531
MEAN RADIUS	:	.861	.769	.712
MAX RADIUS	:	1.543	1.177	1.060
HORIZONTAL SPREAD	:	1.874	1.874	1.874
VERTICAL SPREAD	:	2.705	1.745	1.155
EXTREME SPREAD	:	2.706	2.057	1.893
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

30 May 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C8225201

CENTERFIRE PATTERNS

3

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS= 10

IN CIR

1 in = 3

2 in = 6

3 in = 9

HS= 2.757

VS= 1.737

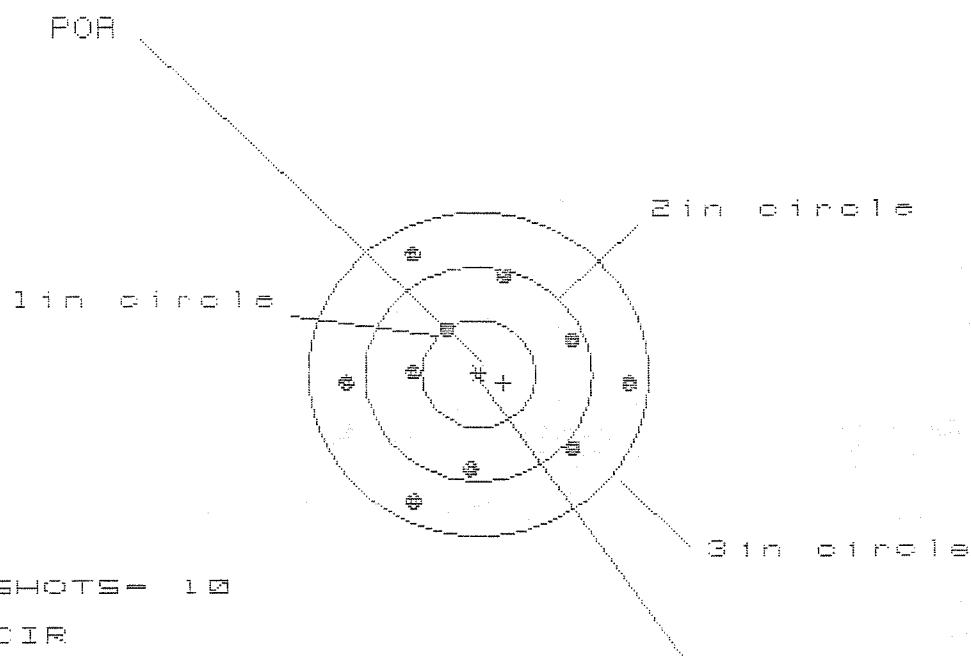
GS= 2.791

PATTERN #	3		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.125	.944	.742
MINIMUM X	-1.632	-1.614	-.851
MAXIMUM Y	.803	.845	.813
MINIMUM Y	-.934	-.892	-.924
CENTROID X	.084	.265	.467
CENTROID Y	-.196	-.238	-.206
POA TO CENTROID in.	.213	.356	.510
MIN RADIUS	.244	.156	.296
MEAN RADIUS	.918	.798	.670
MAX RADIUS	1.674	1.634	1.107
HORIZONTAL SPREAD	2.757	2.558	1.593
VERTICAL SPREAD	1.737	1.737	1.737
EXTREME SPREAD	2.791	2.784	2.201
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		9	

30 May 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C6225201

CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1 in = 0

2 in = 5

3 in = 10

HS= 2.477

VS= 2.289

GS= 2.478

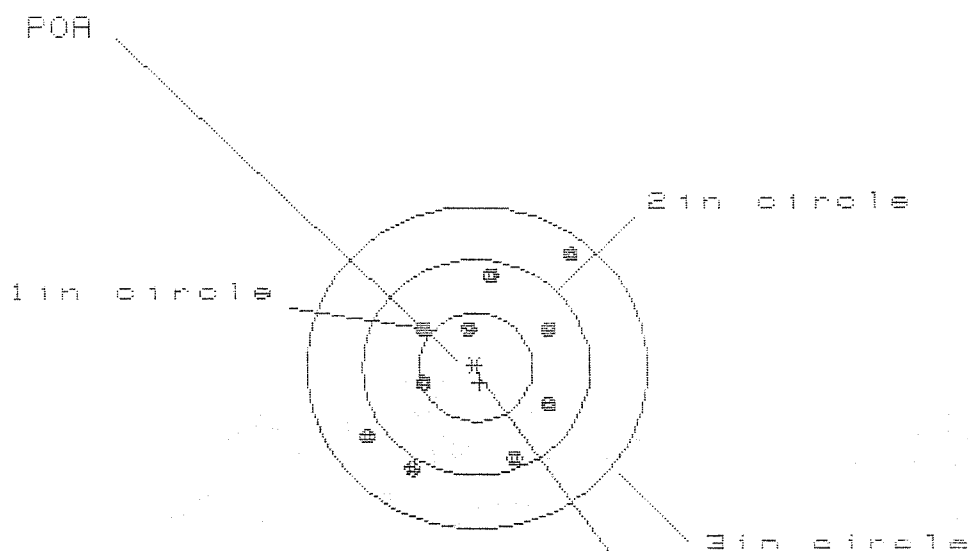
CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.307	1.246	.955
MINIMUM X	:	-1.170	-1.231	-1.075
MAXIMUM Y	:	1.084	.950	.921
MINIMUM Y	:	-1.206	-.993	-1.022
CENTROID X	:	-.225	-.164	-.320
CENTROID Y	:	.082	.215	.244
POA TO CENTROID in.	:	.239	.271	.402
MIN RADIUS	:	.520	.455	.332
MEAN RADIUS	:	.994	.945	.880
MAX RADIUS	:	1.323	1.266	1.218
HORIZONTAL SPREAD	:	2.477	2.477	2.030
VERTICAL SPREAD	:	2.289	1.943	1.943
EXTREME SPREAD	:	2.478	2.478	2.209
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		10	

30 May 1989

FILE:/PATTERNING/CENTERFIRE_PATT/08225201

CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1 in = 2

2 in = 7

3 in = 10

HS= 1.832

VS= 2.054

GS= 2.520

CENTROID *

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.820	.771	.655
MINIMUM X	-1.012	-.921	-.620
MAXIMUM Y	1.063	.948	.879
MINIMUM Y	-.991	-.873	-.942
CENTROID X	-.035	-.127	-.011
CENTROID Y	.142	.024	.093
POA TO CENTROID in.	.147	.129	.094
MIN RADIUS	.388	.381	.441
MEAN RADIUS	.849	.791	.746
MAX RADIUS	1.342	1.073	1.127
HORIZONTAL SPREAD	1.832	1.692	1.275
VERTICAL SPREAD	2.054	1.821	1.821
EXTREME SPREAD	2.520	1.986	1.973
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		10	

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6225201
9 Jun 1989

INTERCHANGEABILITY

CENTROIDAL DISTANCES

0 TO	1	1.02316
1 TO	2	.282661
1 TO	3	.25632
1 TO	4	.143283
1 TO	5	.509135

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

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .8032
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0904
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .808271
THE AMR FOR THIS RIFLE IS: .8552

9 Jun 1989

FILE:/PATTERNING/CENTERFIRE_PATT/082252B1.1

CENTERFIRE PATTERNS

1

POA

1in circle

2in circle

3in circle

CENTROID #

OF SHOTS- 10

IN CIR

1in = 2

2in = 6

3in = 10

HS= 1.828

VS= 2.374

GS= 2.544

PATTERN #

1

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.004

.912

.912

MINIMUM X

-.824

-.905

-.905

MAXIMUM Y

1.280

1.158

.877

MINIMUM Y

-1.094

-1.207

-1.062

CENTROID X

1.002

1.094

1.094

CENTROID Y

-.207

-.085

-.230

POA TO CENTROID in.

1.023

1.097

1.110

MIN RADIUS

.389

.386

.470

MEAN RADIUS

.929

.871

.838

MAX RADIUS

1.370

1.207

1.063

HORIZONTAL SPREAD

1.828

1.817

1.817

VERTICAL SPREAD

2.374

2.365

1.939

EXTREME SPREAD

2.544

2.365

1.969

NUMBER IN ONE INCH CIRCLE =

2

NUMBER IN TWO INCH CIRCLE =

6

NUMBER IN THREE INCH CIRCLE =

10

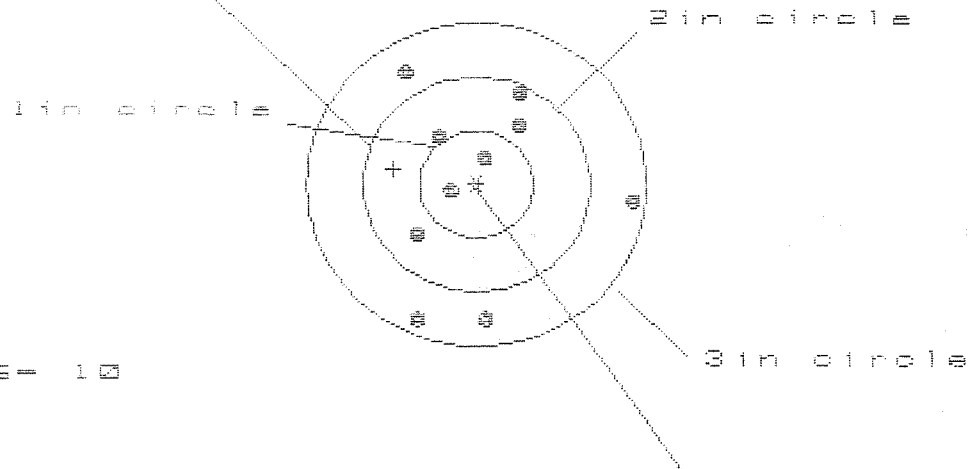
9 Jun 1989

FILE:/PATTERNING/CENTERFIRE_PATT/06225201.1

CENTERFIRE PATTERNS

2

POA



OF SHOTS = 10

IN CIR

1in = 2

2in = 6

3in = 10

HS = 1.994

VS = 2.239

CS = 2.332

CENTROID *

PATTERN #	2	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.345	-.533	.485
MINIMUM X	-.649	-.500	-.548
MAXIMUM Y	1.010	.987	.831
MINIMUM Y	-1.230	-1.252	-1.386
CENTROID X	.726	.577	.625
CENTROID Y	-.146	-.123	.033
POA TO CENTROID in.	.740	.590	.626
MIN RADIUS	.263	.079	.192
MEAN RADIUS	.837	.757	.667
MAX RADIUS	1.360	1.311	1.394
HORIZONTAL SPREAD	1.994	1.033	1.033
VERTICAL SPREAD	2.239	2.239	2.217
EXTREME SPREAD	2.332	2.322	2.322
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	10		

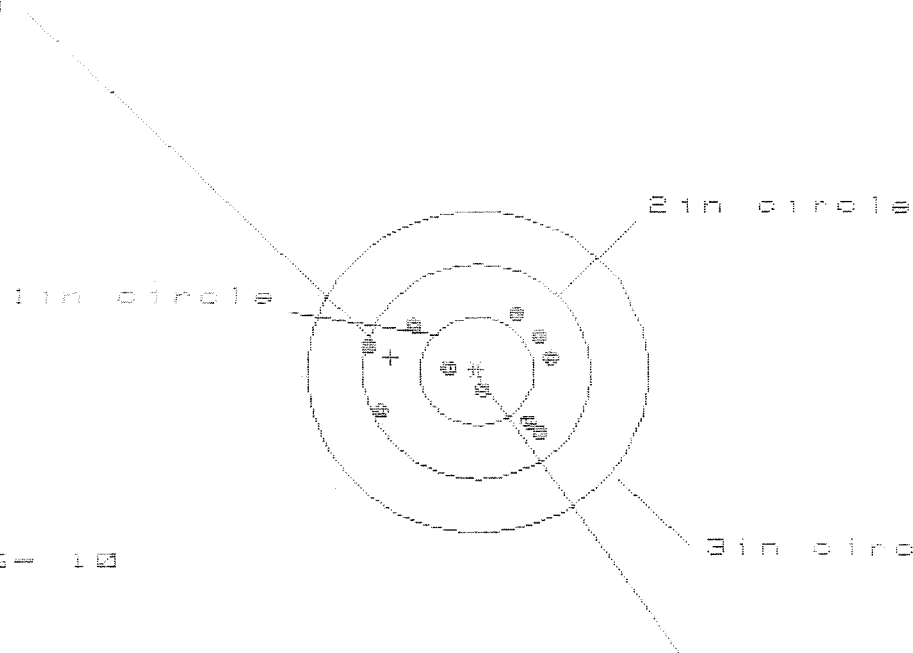
5 Jun 1989

FILE:/PATTERNING/CENTERFIRE_PATT/08225201.1

CENTERFIRE PATTERNS

3

POA



OF SHOTS- 10

IN CIR

1in = 2

2in = 10

3in = 10

HE = 1.517

VE = 1.014

GE = 1.648

CENTROID #

PATTERN #	3	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.608	.512	.387
MINIMUM X	-.909	-1.005	-.734
MAXIMUM Y	.485	.442	.463
MINIMUM Y	-.528	-.572	-.551
CENTROID X	.756	.852	.977
CENTROID Y	-.135	-.091	-.112
POA TO CENTROID in.	.768	.857	.984
MIN RADIUS	.167	.190	.220
MEAN RADIUS	.628	.583	.513
MAX RADIUS	.946	1.019	.822
HORIZONTAL SPREAD	1.517	1.517	1.121
VERTICAL SPREAD	1.014	1.014	1.014
EXTREME SPREAD	1.648	1.648	1.416
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	10		
NUMBER IN THREE INCH CIRCLE =	10		

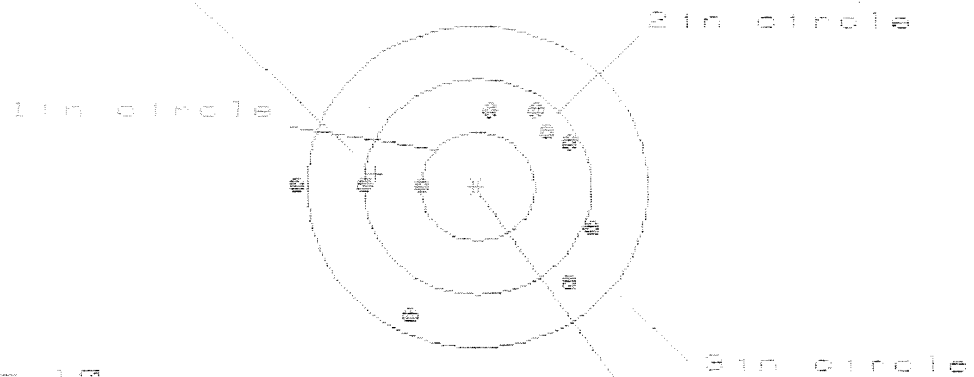
9 Jun 1989

FILE:/PATTERNING/CENTERFIRE_PATT/06225291.1

CENTERFIRE PATTERNS

4

POA



OF SHOTS = 10

IN CIR

1 in = 0

2 in = 5

3 in = 5

HSI = 2.554

VS = 1.851

GS = 2.617

CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.957	.778	.687
MINIMUM X	:	-1.687	-1.220	-1.311
MAXIMUM Y	:	.786	.712	.570
MINIMUM Y	:	-1.145	-1.139	-1.035
CENTROID X	:	.893	1.072	1.163
CENTROID Y	:	-.114	-.120	.022
POA TO CENTROID in.	:	.901	1.079	1.163
MIN RADIUS	:	.523	.672	.584
MEAN RADIUS	:	.990	.901	.801
MAX RADIUS	:	1.688	1.351	1.320
HORIZONTAL SPREAD	:	2.564	1.998	1.998
VERTICAL SPREAD	:	1.851	1.851	1.605
EXTREME SPREAD	:	2.617	2.110	2.066
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

9 Jun 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C8225201.1

CENTERFIRE PATTERNS

5

POA

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 3

2 in = 4

3 in = 9

HS= 2.669

VS= 2.044

GS= 2.860

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.319	1.169	1.098
MINIMUM X	:	-1.350	-1.166	-1.020
MAXIMUM Y	:	1.129	1.028	.959
MINIMUM Y	:	-.915	-.569	-.638
CENTROID X	:	.639	.789	.643
CENTROID Y	:	.150	.251	.320
POA TO CENTROID in.	:	.656	.828	.718
MIN RADIUS	:	.136	.099	.260
MEAN RADIUS	:	.892	.818	.769
MAX RADIUS	:	1.631	1.398	1.250
HORIZONTAL SPREAD	:	2.669	2.335	2.118
VERTICAL SPREAD	:	2.044	1.597	1.597
EXTREME SPREAD	:	2.860	2.642	2.171
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		9	

RECEIVING AND ESTIMATING REPORT

R 96-06351

INITIAL FPS	CUSTOMER ORDER NO.	M24 SNIPER L/I Stud				
DATE RECEIVED 02/26/96	DATE OPENED 02/26/96	DATE CODE CJ 4-89	SERIAL NUMBER C6225204	NEW SERIAL NUMBER	MODEL AND GRADE 700 7.62	NATO
ACCESSORIES W/STUDS		SCOPE BASE				

FROM:

DEPT. OF THE ARMY
A CO. 3RD BATT. 1ST SP. FORCES
BLDG 9177, BOX 339502
FT LEWIS WA 98433

SHIP TO:

DEPT. OF THE ARMY
A CO. 3RD BATT. 1ST SP. FORCES
BLDG 9177, BOX 339502
FT LEWIS WA 98433

CUST NO: 138744 C.O.D.L

ACCOUNT NUMBER	ACCOUNT NUMBER N/C	WRITE ☐	PROM. DATE	ESTIMATED	VIA UPS
GUN CONDITION					REPAIR CHARGE
☐ NEW					EXCISE
☐ LIGHTLY WORN					TAX
☐ WORN					INSURANCE
☐ VERY WORN					UPS
☐ UNREPAIRABLE					PARCEL POST
☐ MARRED					TOTAL

CUSTOMER CONCERN	AMMO	FUNCTION	FINISH	ACCURACY	FIT	INSPECT
CYCLE	A1	B1				
TRIGGER GROUP		B2			E1	F1
BOLT ASSY.		B3			E2	F2
BARREL ASSY.		B4		D1	E3	F3
REC. ASSY.		B5		D2	E4	F4
WOOD			C1	D3	E5	F5
METAL			C2			

MAIN FAULT

PARTS	COMMENTS
Barrel - 96003	Repowder Coat Trigger Guard Assy, front & Rear Sight Base Retline Scope Base & Swivel Studs
REPAIRMAN RW	PROOF L RW
GALLERY TESTER AH	DATE 3/30/96
	CLEAN ✓
	DATE 4/3/96
	TEST K
	DATE 4/3/96
	TARGET K
	DATE 4/3/96
	PATTERN

OFFICE COPY

RD6925 REV. 1/94

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER

M2400010522

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6225201

OP. #	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and Stock		3/20/96	RW
600	Proof		3/20/96	RW
607	Check Headspace		3/20/96	RW
610	Dis-assemble Gun		3/20/96	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		4/3/96	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		4/3/96	RW
	C) Inspect Ejector Hole for Chamfer		4/3/96	RW
	D) Oil Firing Pin Ass'y		4/3/96	RW
	E) Adjust Trigger Pull to Min Setting and Stake			

op. #	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			
	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		4/3/96	RF
	A) Time			
	B) Malfunctions			
	C) Pierced Primers			
	D) Optical Clarity of Scope			
645	Inspect for Live Ammo		4/3/96	RF
655	Final Inspection A) Headspace		4/4/96	RW
	B) Trigger Pull			
	C) Function		4/4/96	RW
660	Pack			

Final Inspection

Sn: C6225201

DATE REC'D: 2/26/96

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

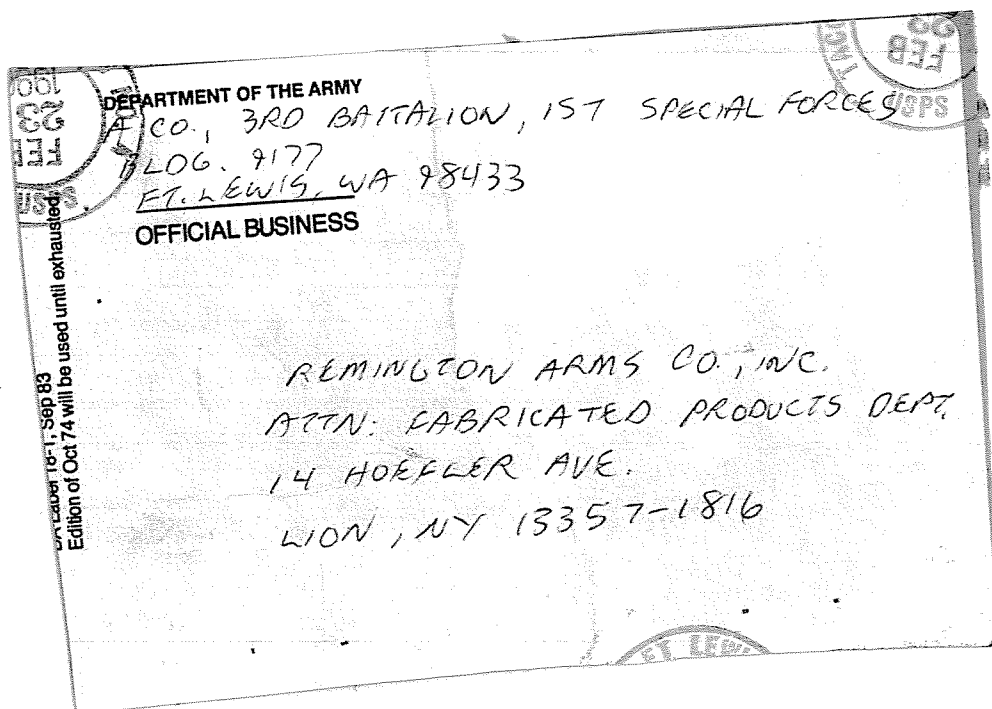
☐ DEPLOYMENT KIT

TRIGGER

☒ SAFETY OPERATION

☒ SET

Comments:



CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06225201
5 Feb 1900

CENTROIDAL DISTANCES

0 TO 1	.960946
1 TO 2	.268062
1 TO 3	.402906
1 TO 4	.485523
1 TO 5	.1186

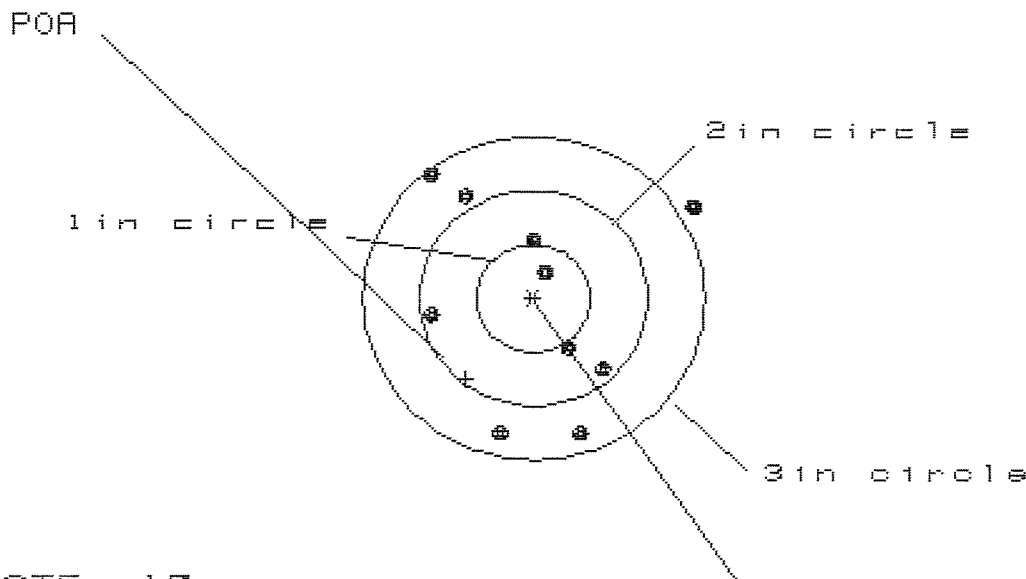
+ ^A₇₃ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .525
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .5172
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .736967
THE AMR FOR THIS RIFLE IS: 1.085

5 Feb 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C8225281

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 5

3 in = 9

HS= 2.313

VS= 2.413

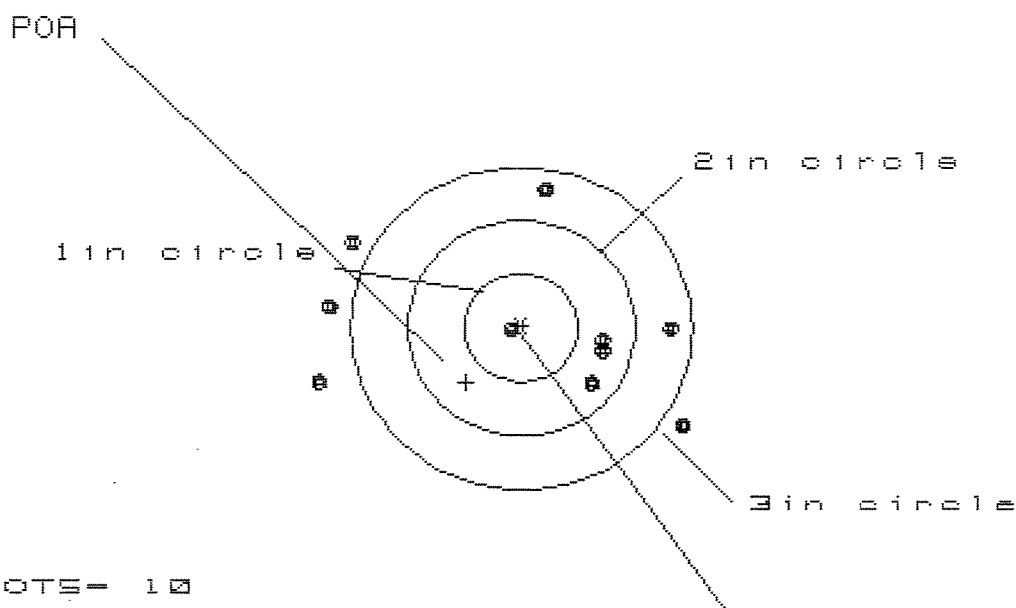
GS= 2.706

PATTERN #	:	1	2	3
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.367	.709	.609
MINIMUM X	:	-.946	-.794	-.821
MAXIMUM Y	:	1.136	1.233	1.207
MINIMUM Y	:	-1.277	-1.180	-1.026
CENTROID X	:	.597	.445	.545
CENTROID Y	:	.753	.656	.502
POA TO CENTROID in.	:	.961	.793	.741
MIN RADIUS	:	.294	.444	.422
MEAN RADIUS	:	.995	.929	.844
MAX RADIUS	:	1.620	1.467	1.327
HORIZONTAL SPREAD	:	2.313	1.503	1.430
VERTICAL SPREAD	:	2.413	2.413	2.233
EXTREME SPREAD	:	2.706	2.706	2.393
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	5		
NUMBER IN THREE INCH CIRCLE	=	9		

5 Feb 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C8225201

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1in = 1

2in = 4

3in = 6

HS= 3.189

VS= 2.185

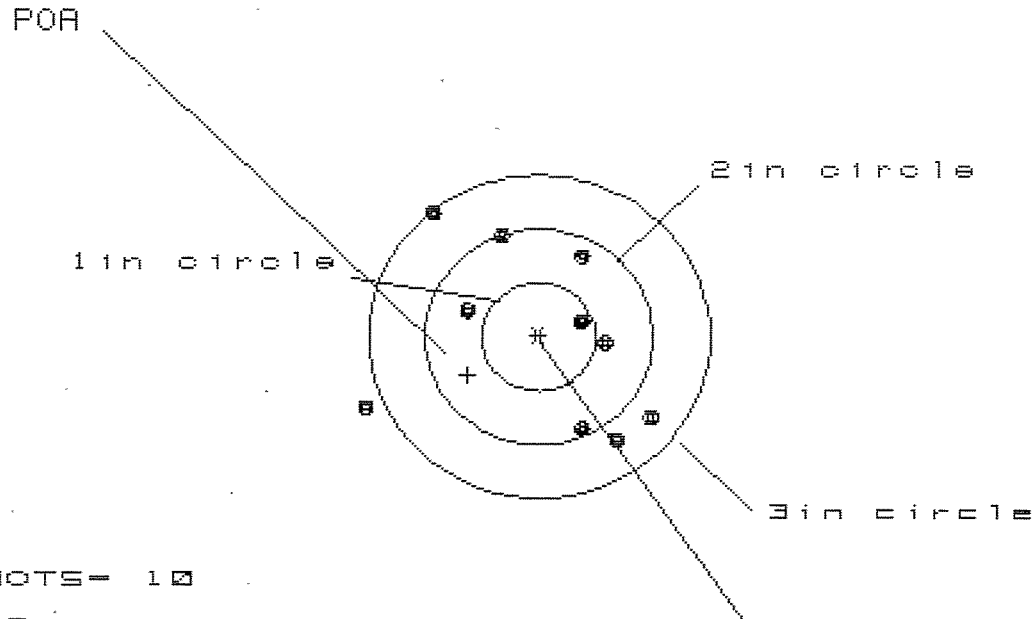
GS= 3.380

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.428	1.232	1.305
MINIMUM X	:	-1.761	-1.876	-1.722
MAXIMUM Y	:	1.263	1.205	1.083
MINIMUM Y	:	-.922	-.980	-.646
CENTROID X	:	.486	.682	.528
CENTROID Y	:	.509	.567	.689
POA TO CENTROID in.	:	.704	.887	.868
MIN RADIUS	:	.052	.256	.216
MEAN RADIUS	:	1.184	1.080	1.047
MAX RADIUS	:	1.836	1.883	1.722
HORIZONTAL SPREAD	:	3.189	3.108	3.027
VERTICAL SPREAD	:	2.185	2.185	1.729
EXTREME SPREAD	:	3.380	3.380	3.033
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		6	

5 Feb 1988

FILE:/PATTERNING/CENTERFIRE_PATT/08225201

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1in = 1

2in = 5

3in = 9

HS= 2.426

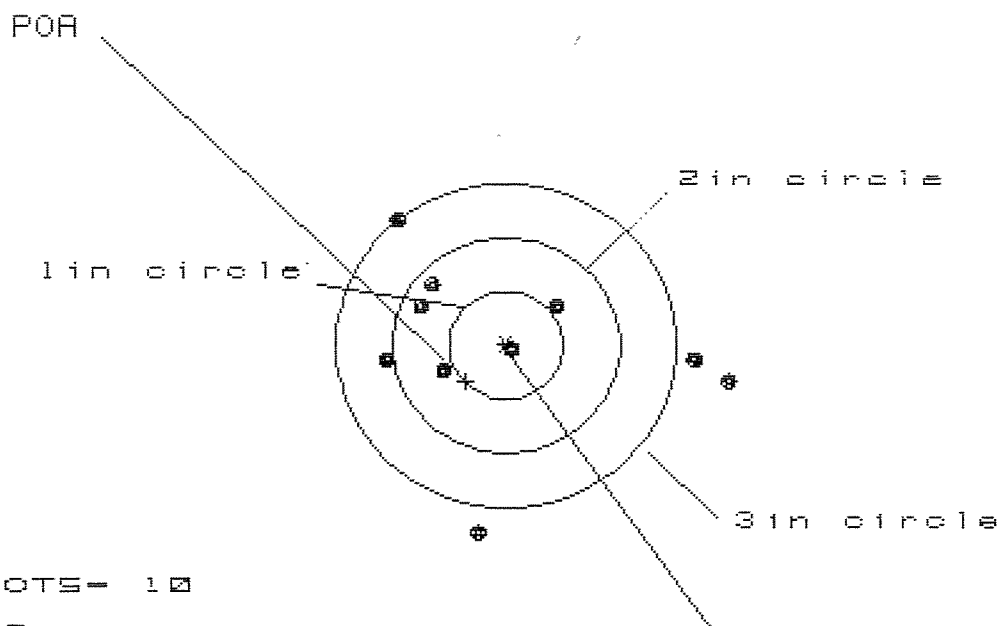
VS= 2.148

GS= 2.679

CENTROID *

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.942	.777	.641
MINIMUM X	:	-1.484	-1.094	-.877
MAXIMUM Y	:	1.170	1.095	1.021
MINIMUM Y	:	-.978	-1.053	-.916
CENTROID X	:	.624	.789	.925
CENTROID Y	:	.351	.426	.289
POA TO CENTROID in.	:	.716	.896	.970
MIN RADIUS	:	.403	.222	.234
MEAN RADIUS	:	.994	.886	.779
MAX RADIUS	:	1.630	1.547	1.187
HORIZONTAL SPREAD	:	2.426	1.871	1.518
VERTICAL SPREAD	:	2.148	2.148	1.937
EXTREME SPREAD	:	2.679	2.679	2.161
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 6

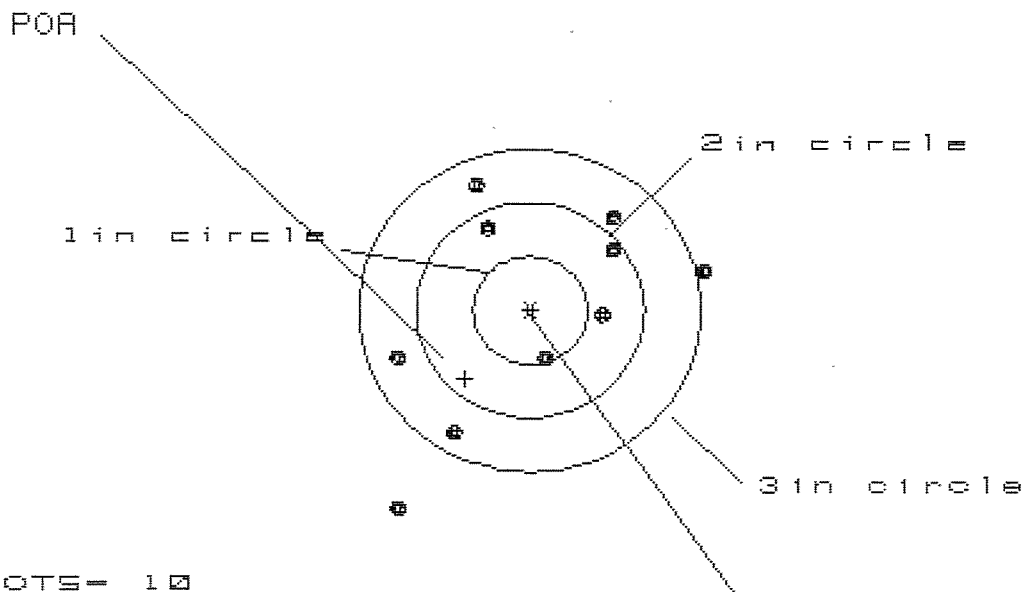
HS= 3.023

VS= 2.882

GS= 3.242

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.943	1.904	1.905
MINIMUM X	:	-1.080	-.864	-.863
MAXIMUM Y	:	1.151	1.119	.898
MINIMUM Y	:	-1.731	-1.763	-.440
CENTROID X	:	.350	.134	.133
CENTROID Y	:	.335	.367	.588
POA TO CENTROID in.	:	.485	.391	.602
MIN RADIUS	:	.093	.311	.412
MEAN RADIUS	:	1.095	.965	.848
MAX RADIUS	:	1.964	1.910	1.941
HORIZONTAL SPREAD	:	3.023	2.768	2.768
VERTICAL SPREAD	:	2.882	2.882	1.338
EXTREME SPREAD	:	3.242	2.980	2.939
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		6	

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 4

3 in = 8

HS= 2.726

VS= 3.018

GS= 3.512

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.559	1.429	.821
MINIMUM X	:	-1.167	-1.270	-1.091
MAXIMUM Y	:	1.208	1.007	1.033
MINIMUM Y	:	-1.810	-1.354	-1.328
CENTROID X	:	.568	.698	.519
CENTROID Y	:	.638	.839	.813
POA TO CENTROID in.	:	.854	1.091	.965
MIN RADIUS	:	.419	.537	.600
MEAN RADIUS	:	1.159	1.013	.968
MAX RADIUS	:	2.153	1.585	1.477
HORIZONTAL SPREAD	:	2.726	2.699	1.912
VERTICAL SPREAD	:	3.018	2.361	2.361
EXTREME SPREAD	:	3.512	2.822	2.486
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	