NEW ACTION

C6225233

E6377 4553

MODEL 700™ M24

Model 700 M24™

Action

Barrel Length

Capacity

Order No. 5716

*Includes 1 in chamber.

Remington

RECEIVING AND ESTIMATING REPORT

COMMENTS: SNIPER M-24

ORDER: R 96-02143

INITIAL	CUSTOMER ORDER NO.
JJM	010807

DATE RECEIVED	DATE OPENED	DATE CODE	SERIAL NUMBER	NEW SERIAL NUMBER	MODEL AND GRADE
01/17/96	01/17/96		C6225233		700 7.62 NATO

ACCESSORIES: W/STUDS SOFT CASE SCOPE BASE

FROM:
FREDRICKSON, ROBERT L.
D CO 2ND BN 1ST SWTG
FT BRAGG NC 28307

SHIP TO:
COMMANDER
~~FREDRICKSON, ROBERT L.~~
D CO 2ND BN 1ST SWTG
FT BRAGG NC 28307

CUST NO: 135960 C.O.D.

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
W52 #096017 #245
Barrel — 96003
Stock — 96018
Firing pin Assy - 96007

COMMENTS
Repowder Coat - Trigger Guard Assy, Front + Rear Sight Bases Recine Scope Base & Swivel Studs

REPAIRMAN	PROOF	CLEAN	TEST	TARGET	PATTERN
RW	C	C	WB	WB	
GALLERY TESTER	**DATE**	**DATE**	**DATE**	**DATE**	**DATE**
RW	1/22/96	1/31/96	1/31/96	1/31/96	

OFFICE COPY

RD6925 REV. 1/94

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 010807

DATE 1/17/96

CUSTOMER NAME: Robert L Fredrickson

REMINGTON EMPLOYEE:
YES ☐ NO ☐

ADDRESS: D Co 2nd Bn 1st SWTG
Ft Bragg NC

EMPLOYEE # _____

DEPT. # _____

ZIP: 28307

PHONE: 910-432-9037

FIREARM MODEL: M-24

CHECK FOR AMMUNITION

GAUGE: 7.62

SERIAL # C622 5233

CONDITION:

N/A

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: Repair Per Contract

SIGNATURE: Robert Fredrickson DATE: 17 Jan 96
(Person delivering firearm to Plant)

SIGNATURE: _____ DATE: 1/17/96
(Security Officer)

SIGNATURE: Richard Wright DATE: _____
(Firearm picked up by)

Arm Service Copy

CONTRACT # DAAA21-87-C-0086 New Barrel Stock

GUN SERIAL # C6225233

OP. #	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and Stock		1/22/96	RW
600	Proof		1/22/96	RW
607	Check Headspace		1/22/96	RW
610	Dis-assemble Gun		1/22/96	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		1/30/96	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		1/30/96	RW
	C) Inspect Ejector Hole for Chamfer		1/30/96	RW
	D) Oil Firing Pin Ass'y		1/30/96	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		1/30/96	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 Clearity 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			

SWS/Repair

Final Inspection

S/N: C6225233	DATE REC'D: 1/17/96	DATE RET'D:

AUDITOR: RW

Item:
Barrel Assy.
- ✓ Barrel
- ✓ Receiver
- ✓ Front Sight Block
- ✓ Rear Sight Block
- ✓ Screws
- ✓ Finish

Item:
Stock Assy.
- ✓ Stock
- ✓ Sling Swivel Studs
- ✓ Adjustable Butt Plate
- ✓ Lock Nuts
- ✓ Barrel Clearance
- ✓ Color/Finish

Scope Assy.
- ___ Scope
- ___ Scope Rings
- ___ Mounting Screws
- ___ Mounting Base
- ___ Screws
- ___ Finish
- ___ Looseness
- ___ Clarity

Systems Case
- ___ Scope Case
- ___ Iron Sights
- ___ Deployment Kit

Trigger
- ✓ Safety Operation
- ✓ Set
- ___

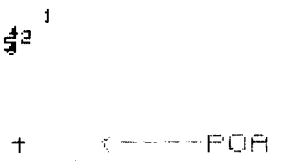
Misc.
- ___ DD-250
- ___ Bar Code
- ___ Packaging

Comments: _____

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6225233
3 Jan 1900

CENTROIDAL DISTANCES

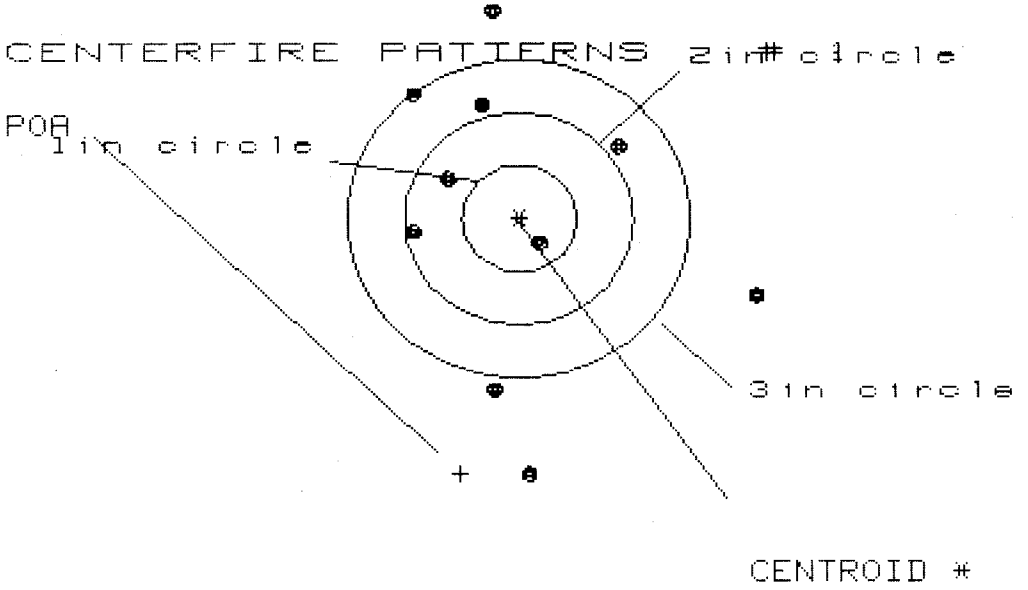
0	TO	1	2.47804
1	TO	2	.5441
1	TO	3	.885384
1	TO	4	.691903
1	TO	5	.864901



THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0592
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: 2.055
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: 2.05585

THE AMR FOR THIS RIFLE IS: 1.092

2 Jan 1900 FILE:/PATTERNING/CENTERFIRE_PATT/C6225233



OF SHOTS= 10

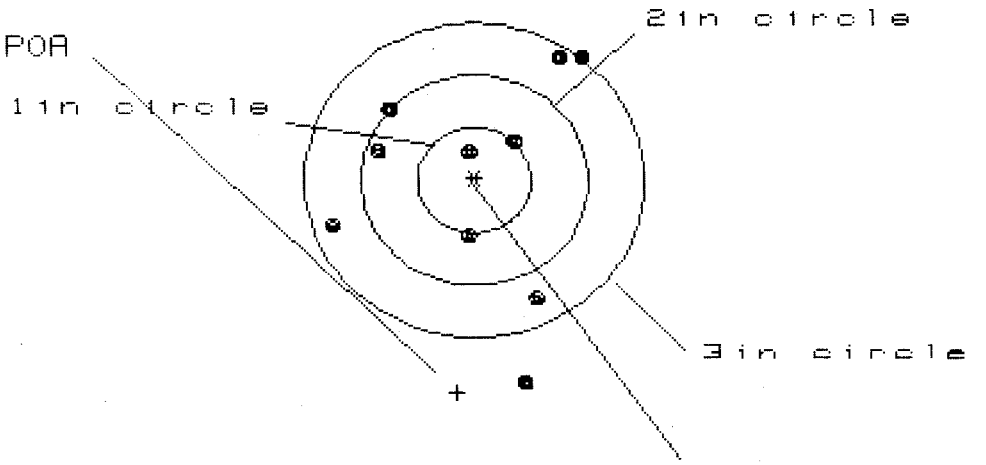
# IN CIR
1in = 1
2in = 3
3in = 6

HS= 2.948
VS= 4.396
GS= 4.404

PATTERN #	:	1	
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.035	2.042	1.139
MINIMUM X	:	-.913	-.906	-.651
MAXIMUM Y	:	1.935	1.662	1.536
MINIMUM Y	:	-2.461	-1.934	-2.060
CENTROID X	:	.524	.517	.262
CENTROID Y	:	2.422	2.695	2.821
POA TO CENTROID in.	:	2.478	2.744	2.834
MIN RADIUS	:	.319	.562	.375
MEAN RADIUS	:	1.395	1.246	1.061
MAX RADIUS	:	2.461	2.278	2.062
HORIZONTAL SPREAD	:	2.948	2.948	1.790
VERTICAL SPREAD	:	4.396	3.596	3.596
EXTREME SPREAD	:	4.404	3.596	3.596
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		6	

2 Jan 1900 FILE:/PATTERNING/CENTERFIRE_PATT/C6225233

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

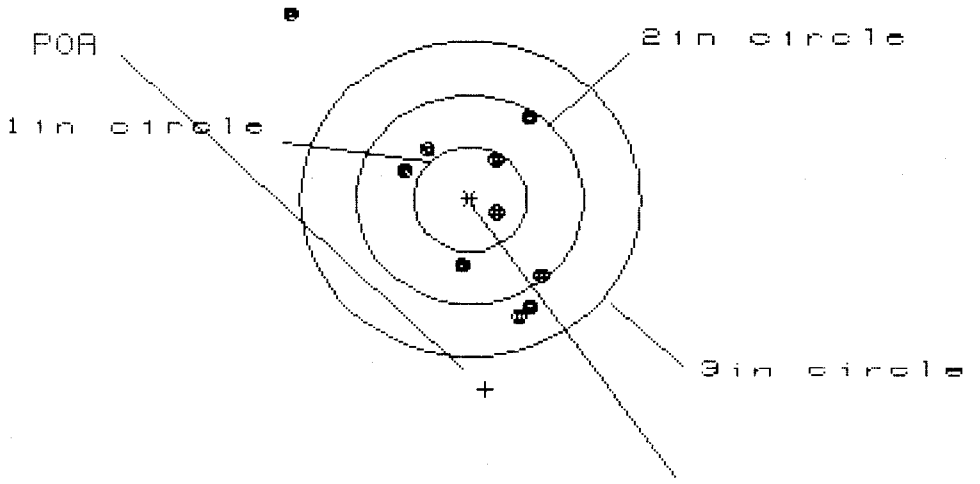
# IN CIR
1in = 1
2in = 4
3in = 8

HS= 2.221
VS= 3.175
GS= 3.213

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.989	1.039	.932
MINIMUM X	:	-1.232	-1.182	-1.052
MAXIMUM Y	:	1.219	1.002	1.126
MINIMUM Y	:	-1.956	-1.382	-1.258
CENTROID X	:	.153	.103	-.027
CENTROID Y	:	2.024	2.241	2.117
POA TO CENTROID in.	:	2.030	2.243	2.117
MIN RADIUS	:	.263	.051	.178
MEAN RADIUS	:	1.082	.938	.875
MAX RADIUS	:	2.006	1.497	1.462
HORIZONTAL SPREAD	:	2.221	2.221	1.984
VERTICAL SPREAD	:	3.175	2.384	2.384
EXTREME SPREAD	:	3.213	2.740	2.556
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	

2 Jan 1900 FILE:/PATTERNING/CENTERFIRE_PATT/C6225233

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

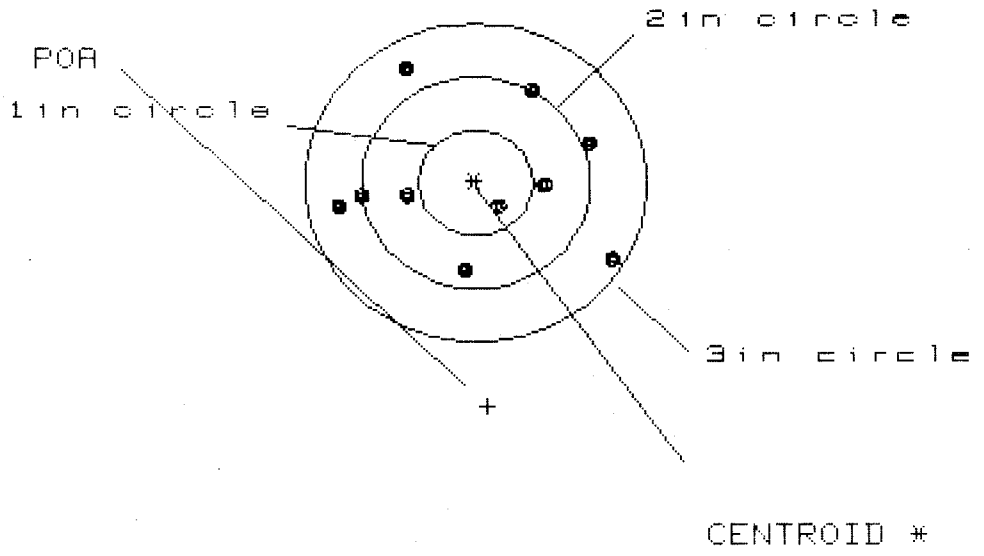
# IN CIR
1in = 2
2in = 7
3in = 9

HS= 2.181
VS= 2.902
GS= 3.527

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.599	.423	.454
MINIMUM X	:	-1.582	-.750	-.719
MAXIMUM Y	:	1.734	.969	.848
MINIMUM Y	:	-1.168	-.976	-.939
CENTROID X	:	-.128	.048	.017
CENTROID Y	:	1.823	1.631	1.752
POA TO CENTROID in.	:	1.828	1.631	1.753
MIN RADIUS	:	.259	.121	.099
MEAN RADIUS	:	.924	.733	.687
MAX RADIUS	:	2.347	1.048	1.007
HORIZONTAL SPREAD	:	2.181	1.173	1.173
VERTICAL SPREAD	:	2.902	1.945	1.786
EXTREME SPREAD	:	3.527	1.951	1.787
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

2 Jan 1900 FILE:/PATTERNING/CENTERFIRE_PATT/C6225233

CENTERFIRE PATTERNS # 4



OF SHOTS= 10

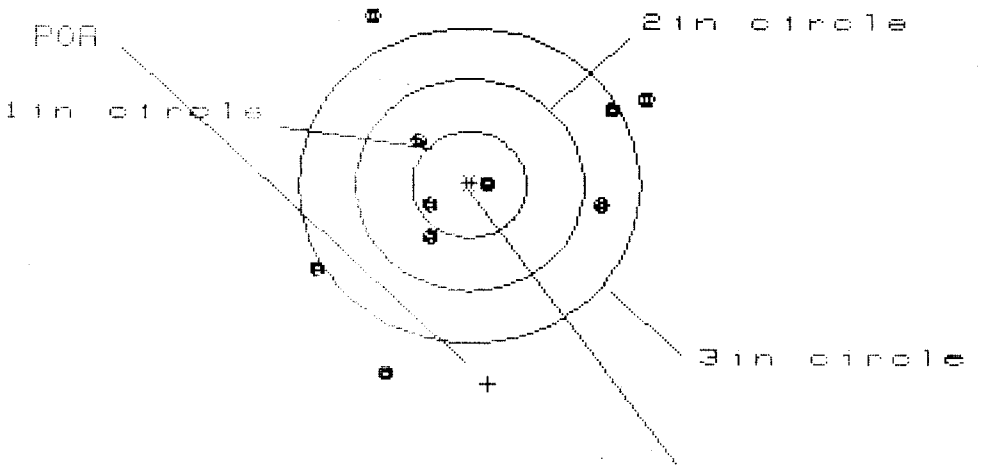
% IN CIR
1in = 1
2in = 5
3in = 10

HS= 2.402
VS= 1.939
CS= 2.470

PATTERN #	:	4	
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.163	1.107	.968
MINIMUM X	:	-1.239	-1.110	-.962
MAXIMUM Y	:	1.068	.991	.952
MINIMUM Y	:	-.871	-.948	-.987
CENTROID X	:	-.099	-.228	-.089
CENTROID Y	:	2.121	2.198	2.237
POA TO CENTROID in.	:	2.123	2.210	2.239
MIN RADIUS	:	.300	.448	.384
MEAN RADIUS	:	.919	.872	.826
MAX RADIUS	:	1.353	1.153	1.115
HORIZONTAL SPREAD	:	2.402	2.217	1.930
VERTICAL SPREAD	:	1.939	1.939	1.939
EXTREME SPREAD	:	2.470	2.293	1.994
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		10	

2 Jan 1900 FILE:/PATTERNING/CENTERFIRE_PATT/C6225233

CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR
1 in = 2
2 in = 4
3 in = 7

X = 2.000
Y= 3.406
CS= 3.430

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.511	1.424	1.304
MINIMUM X	:	-1.297	-1.384	-1.504
MAXIMUM Y	:	1.613	1.414	.742
MINIMUM Y	:	-1.793	-.947	-.771
CENTROID X	:	-.154	-.067	.053
CENTROID Y	:	1.885	2.084	1.908
POA TO CENTROID in.	:	1.891	2.085	1.908
MIN RADIUS	:	.172	.246	.066
MEAN RADIUS	:	1.140	1.064	.951
MAX RADIUS	:	1.956	1.710	1.690
HORIZONTAL SPREAD	:	2.808	2.808	2.808
VERTICAL SPREAD	:	3.486	3.961	1.512
EXTREME SPREAD	:	3.486	3.190	3.190
SHOTS IN ONE INCH CIRCLE	=		2	
SHOTS IN TWO INCH CIRCLE	=		4	
SHOTS IN THREE INCH CIRCLE	=		7	

RECEIVING AND ESTIMATING REPORT

COMMENTS: WOG 5 OF 7 M-24 ATTN: FRED MARTIN W/ADJUSTABLE RECOIL PAD

ORDER: R 93-26583

INITIAL	CUSTOMER ORDER NO.
FPS	8326

DATE RECEIVED	DATE OPENED	DATE CODE	SERIAL NUMBER	NEW SERIAL NUMBER	MODEL AND GRADE
12/09/93	12/09/93	LI 2-88	C6225233		700 7.62 NATO

ACCESSORIES: W/STUDS SCOPE BASE

FROM:

U. S. ARMY
THOMPSON, ALLAN R
CO. D 2ND BN. 1ST SWTG
FT BRAGG NC 28307

SHIP TO:

U. S. ARMY
THOMPSON, ALLAN R
CO. D 2ND BN. 1ST SWTG
FT BRAGG NC 28307

CUST NO: 089383 C.O.D

ACCOUNT NUMBER	ACCOUNT NUMBER N/C	WRITE	PROM. DATE	ESTIMATED	VIA
		☐			~~UPS~~ 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: Replace Barrel Assy

PARTS: Barrel Assy - 96003

COMMENTS: Rezinc - Scope Base & Swivel Studs. Repounder Coat - Floorplate / Mtch, Trigger Guard Front & Rear Sight Base Sr.

W52 H094011 4229

REPAIRMAN	PROOF	CLEAN	TEST	TARGET	PATTERN
RW	✓	✓	✓	✓	

GALLERY TESTER	DATE	DATE	DATE	DATE	DATE
RW	12/16/93	1/4/94	1/4/94	1/4/94	

OFFICE COPY

RD6925 REV. 1/92

CONTRACT # DAAA21-87-C-0086 New Barrel

GUN SERIAL # C6225233

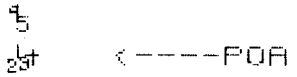
OP. #	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and Stock		12/16/93	RW
600	Proof		12/16/93	RW
607	Check Headspace		12/16/93	RW
610	Dis-assemble Gun		12/16/93	RW
612	Magnaflux Barrel Action			
	Magnaflux Bolt			
615	Rollmark Caliber			
617	Drill and Tap Sight Holes			
618	Polish Barrel			
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			

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		1/4/94	RW
	A) Time			
	B) Malfunctions			
	C) Pierced Primers			
	D) Optical Clearity of Scope			
645	Inspect for Live Ammo		1/4/94	RW
655	Final Inspection A) Headspace		1/4/94	RW
	B) Trigger Pull	2.52 2.39 2.24 2.33 2.37	1/4/94	RW
	C) Function		1/4/94	RW
660	Pack			

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6225233
11 Jan 1994

CENTROIDAL DISTANCES

0	TO	1	.246343
1	TO	2	.284431
1	TO	3	.216585
1	TO	4	.781231
1	TO	5	.531504

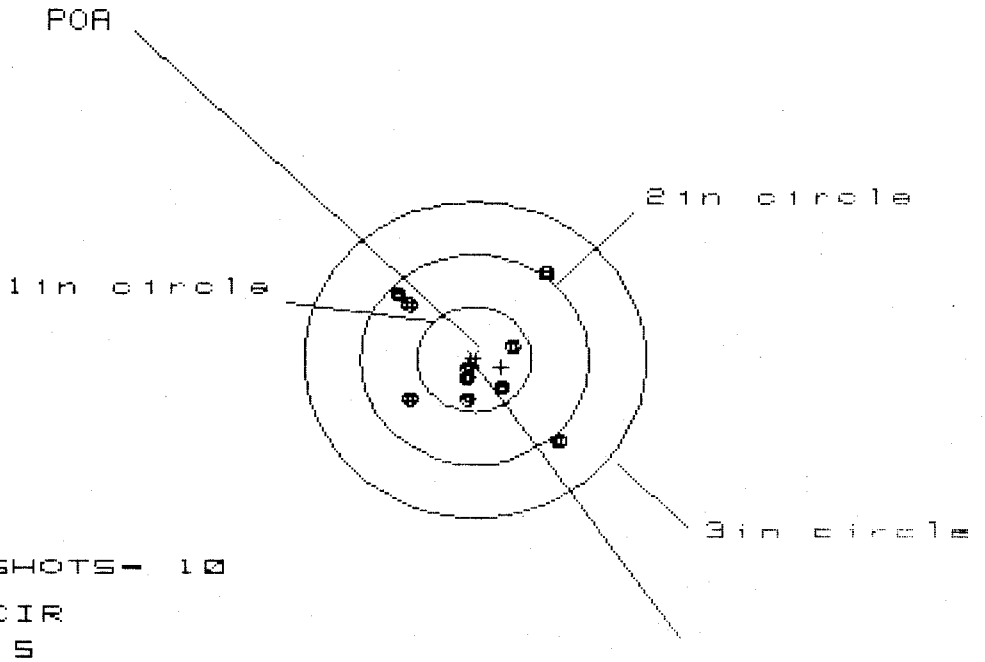


THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.2352
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .2472
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .341214

THE AMR FOR THIS RIFLE IS: .8352

11 Jan 1994 FILE:/PATTERNING/CENTERFIRE_PATT/C6225233

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

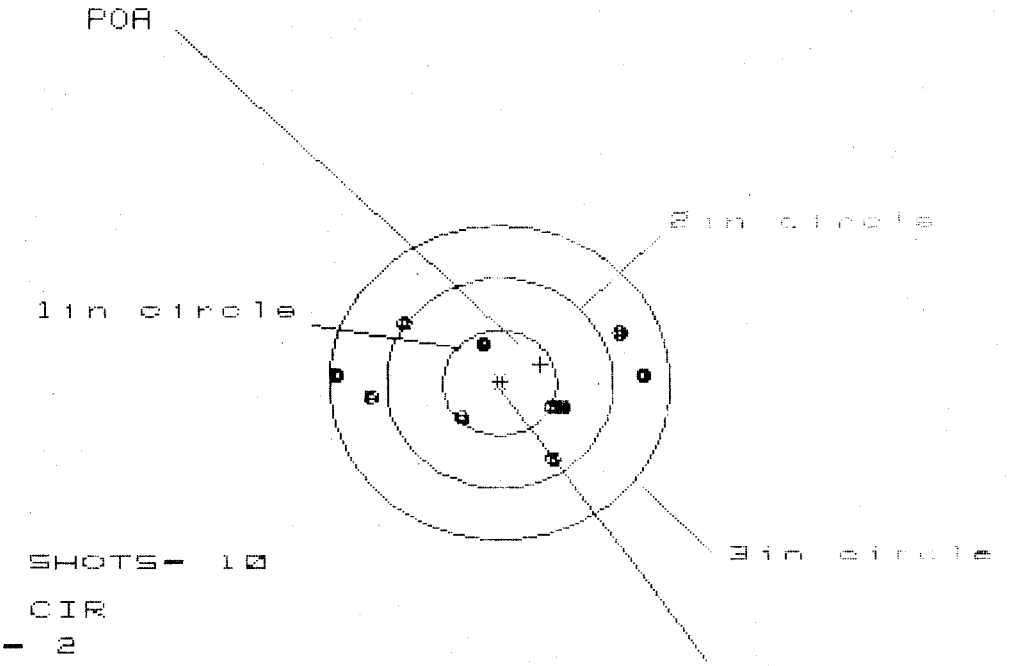
# IN CIR
1in = 5
2in = 8
3in = 10

HS= 1.384
VS= 1.584
GS= 1.989

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.747	.693	.527
MINIMUM X	:	-.637	-.554	-.467
MAXIMUM Y	:	.816	.731	.667
MINIMUM Y	:	-.768	-.511	-.420
CENTROID X	:	-.234	-.317	-.404
CENTROID Y	:	.077	.162	.071
POA TO CENTROID in.	:	.247	.357	.410
MIN RADIUS	:	.127	.192	.142
MEAN RADIUS	:	.598	.560	.480
MAX RADIUS	:	1.072	1.007	.814
HORIZONTAL SPREAD	:	1.384	1.247	.994
VERTICAL SPREAD	:	1.584	1.242	1.087
EXTREME SPREAD	:	1.989	1.662	1.273
NUMBER IN ONE INCH CIRCLE	=		5	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	

11 Jan 1994 FILE:/PATTERNING/CENTERFIRE_PATT/06225233

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

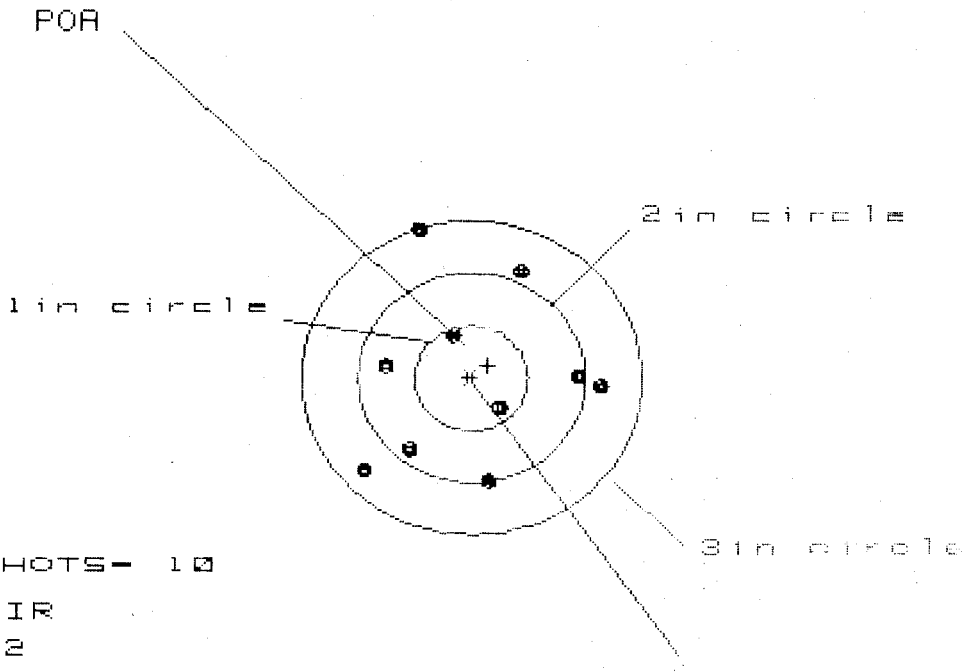
# IN CIR	
1in	= 2
2in	= 5
3in	= 10

HS= 2.661
VS= 1.354
GS= 2.661

PATTERN # :	2		
SHOTS (BEST OF) :	10	9	8
MAXIMUM X :	1.269	1.114	1.035
MINIMUM X :	-1.392	-1.307	-1.166
MAXIMUM Y :	.611	.623	.633
MINIMUM Y :	-.743	-.731	-.721
CENTROID X :	-.360	-.205	-.344
CENTROID Y :	-.178	-.190	-.200
POA TO CENTROID in.:	.401	.279	.398
MIN RADIUS :	.424	.389	.450
MEAN RADIUS :	.888	.811	.775
MAX RADIUS :	1.397	1.313	1.174
HORIZONTAL SPREAD :	2.661	2.421	2.203
VERTICAL SPREAD :	1.354	1.354	1.354
EXTREME SPREAD :	2.661	2.430	2.280
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		10	

11 Jan 1994 FILE:/PATTERNING/CENTERFIRE_PATT/C6225233

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

# IN CIR
1in = 2
2in = 6
3in = 9

HS= 2.120
VS= 2.377
GS= 2.452

PATTERN # : 3

SHOTS (BEST OF) :	10	9	8
MAXIMUM X :	1.181	1.126	1.002
MINIMUM X :	-.939	-.994	-.918
MAXIMUM Y :	1.429	1.135	1.047
MINIMUM Y :	-.948	-.790	-.878
CENTROID X :	-.144	-.089	.035
CENTROID Y :	-.120	-.278	-.190
POA TO CENTROID in.:	.187	.292	.193
MIN RADIUS :	.397	.253	.237
MEAN RADIUS :	.942	.862	.808
MAX RADIUS :	1.512	1.221	1.077
HORIZONTAL SPREAD :	2.120	2.120	1.920
VERTICAL SPREAD :	2.377	1.925	1.925
EXTREME SPREAD :	2.452	2.300	1.957

NUMBER IN ONE INCH CIRCLE = 2
NUMBER IN TWO INCH CIRCLE = 6
NUMBER IN THREE INCH CIRCLE = 9

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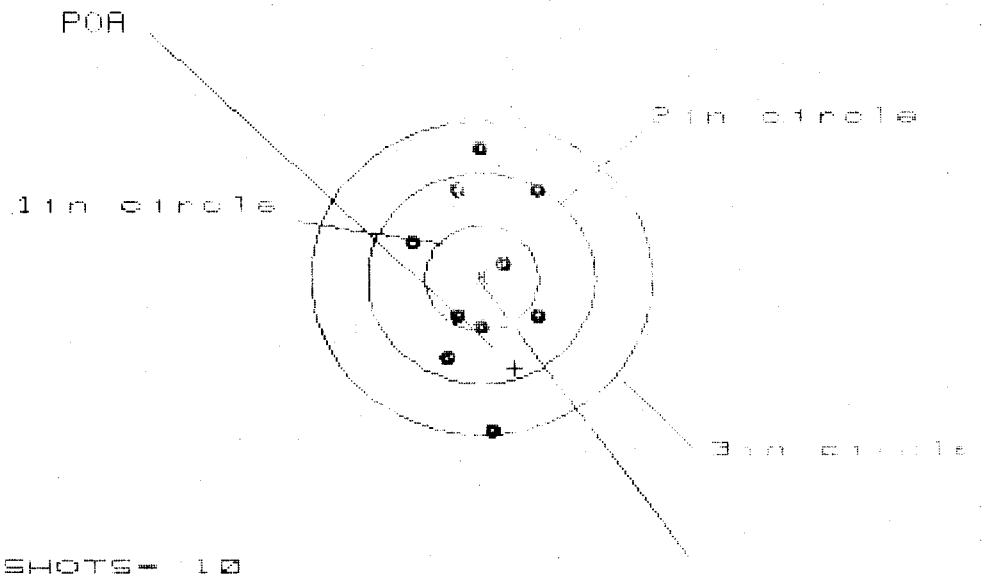
CENTERFIRE PATTERNS # 4



OF SHOTS= 10

# IN CIR
1in = 3
2in = 8
3in = 10

HS= 1.157
VS= 2.677
GS= 2.678

CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.540	.551	.544
MINIMUM X	:	-.617	-.606	-.603
MAXIMUM Y	:	1.217	1.055	.832
MINIMUM Y	:	-1.460	-.927	-.795
CENTROID X	:	-.293	-.304	-.307
CENTROID Y	:	.856	1.018	.886
POA TO CENTROID in.	:	.905	1.062	.938
MIN RADIUS	:	.218	.185	.213
MEAN RADIUS	:	.786	.711	.649
MAX RADIUS	:	1.463	1.055	.972
HORIZONTAL SPREAD	:	1.157	1.157	1.157
VERTICAL SPREAD	:	2.677	1.982	1.627
EXTREME SPREAD	:	2.678	2.005	1.799
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	

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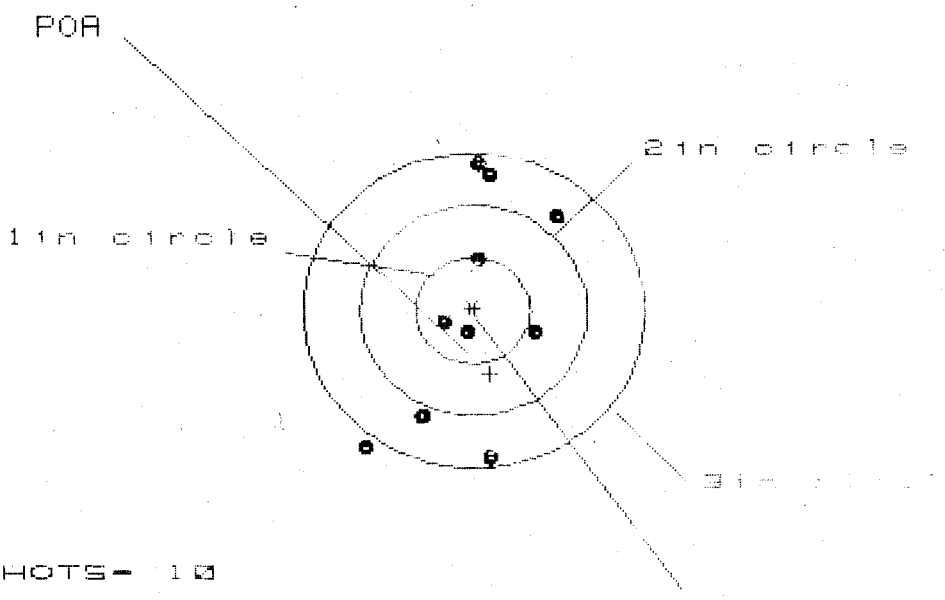
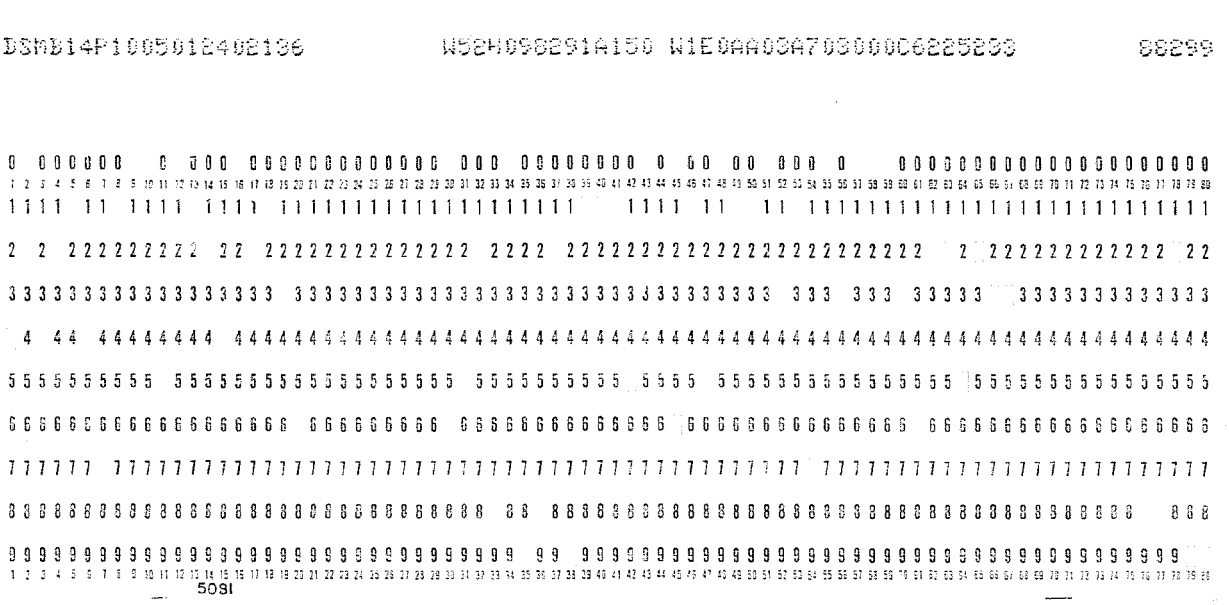
CENTERFIRE PATTERNS # 5



# OF SHOTS= 10
# IN CIR
1in = 2
2in = 4
3in = 9
HS= 1.735
VS= 2.833
GS= 2.888

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	
MAXIMUM X	:	.749	.639	.726
MINIMUM X	:	-.986	-.580	-.583
MAXIMUM Y	:	1.442	1.301	1.236
MINIMUM Y	:	-1.391	-1.391	-1.369
CENTROID X	:	-.145	.029	-.022
CENTROID Y	:	.601	.742	.579
POA TO CENTROID in.	:	.618	.743	.580
MIN RADIUS	:	.201	.366	.230
MEAN RADIUS	:	.962	.890	.823
MAX RADIUS	:	1.604	1.532	1.370
HORIZONTAL SPREAD	:	1.735	1.159	1.159
VERTICAL SPREAD	:	2.833	2.833	2.655
EXTREME SPREAD	:	2.888	2.835	2.655
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		9	


DSMb14P100501840Z136
W52H090291A150 W1E0AA0CA7030000C6825899
88299
5091

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6225233

OPERATION #	OPERATION NAME	DATE	INT
575-580	ASSEMBLY	1/22	FB
600	PROOF	1/28/88	KW
615	MAGNAFLUX BARREL	2/15/88	PJC
	MAGNAFLUX BOLT	2/25/88	PJC
620	COATING	3/24/88	JA
625-630	FINAL ASSEMBLY		
635	TEST		
640	TARGET		
	FIRING PIN INDENT		
660	PACK		

SCOPE #
1129

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6225233

OP.#	OP. NAME	READINGS	DATE	INITIAI
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		9/13/88	KW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		9/13/88	KW
	C) Inspect Ejector Hole for Chamfer		9/13/88	KW

OVER

OP.#		READINGS			DATE	INITIAL
625 cont.	D) Oil Firing Pin Ass'y				9/13/88	RW
	E) Adjust Trigger Pull to Min. Setting and Stake					
	F) Safety on Force	5	5	5	13 Sept 88	DH
	G) Safety off Force	3#	3	3	13 Sept 88	DH
	H) Trigger Pull Test & Retainabilty				~~10-7-88~~	~~DS~~
	I) Firing Pin Indent	.021	.021	.021	13 Sept 88	DH
	J) Assemble Stock				9/14/88	RW
	K) Assemble Swivel Studs				10-7-88	DS
	L) Attach Front & Rear Sight Assemblies				9/14/88	RW
	M) Iron Sight Alignment				9/14/88	RW
	N) Detach Front & Rear Sights & place in numbered container				9/14/88	RW
	0) Attach Scope to Rifle				~~10~~ 9/5/88	RW
	P) Detach & Attach Scope 20 times				10-5-88	DS
640	Gallery Target & Test	62 R	93 L		10/6-88	I.E.S
	A) Optical Clearity of Scope				10/6/88	DH
645	Inspect for Live Ammo				10/6/88	DH
655	Final Inspection A) Headspace				10-7-88	DS
	B) Trigger Pull				10-7-88	DS
	C) Function				10-7-88	DS
660	Pack		OK		10/20/88	W.B

SWS TRIGGER PULL TEST

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

SERIAL NO. C6225233

DATE 13 SEPT - 88

TESTER JPL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#	COMMENTS
PULL #1	2.52	2.36	2.57 2.39	MIN. SETTING,
PULL #2	2.48	2.46	2.56 2.33	NO AVG. OF 5
PULL #3	2.48	2.39	2.62 2.32	READINGS ACCEPT-
PULL #4	2.44	2.58	2.57 2.35	ABLE LESS THAN 2#
PULL #5	2.51	2.52	2.54 2.35	
TOTAL	12.43	12.31	12.86 11.74	
AVG.	2.486	2.462	2.572 2.348	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.37	3.18		
PULL #2	3.28	3.25		
PULL #3	3.32	3.21		
PULL #4	3.25	3.28		
PULL #5	3.25	3.27		
TOTAL	16.47	16.19		
AVG.	3.294	3.238		

	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		4.38
PULL #2	4.13	4.12		4.35
PULL #3	4.12	4.10		4.37
PULL #4	4.18	4.09		4.37
PULL #5	4.17	4.13		4.39
TOTAL	20.82	20.53		21.85
AVG.	4.164	4.106		4.372

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6225233

CENTROIDAL DISTANCES

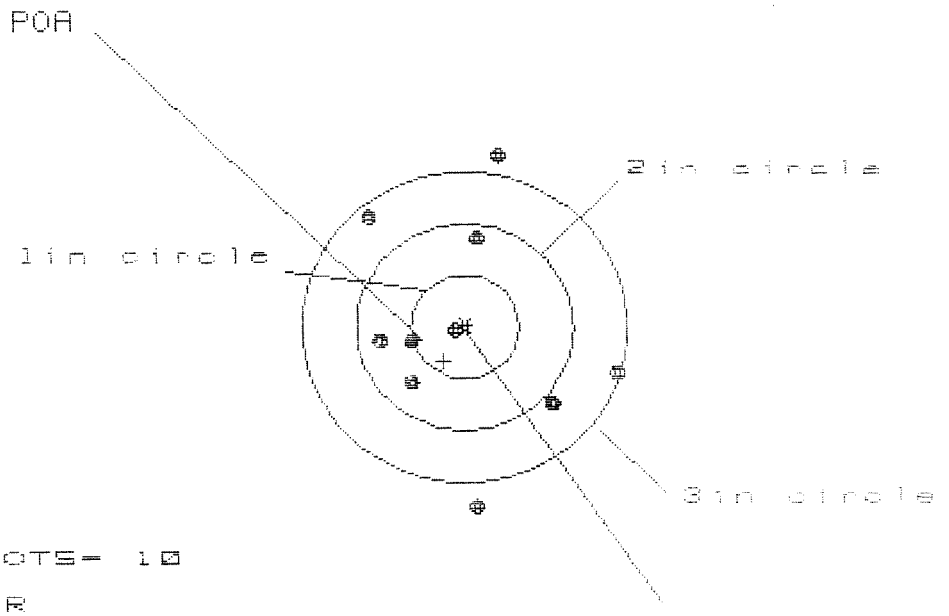
0	TO	1	.385253
1	TO	2	.830509
1	TO	3	.0621289
1	TO	4	.545495
1	TO	5	.552067

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .2346
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0544
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .240825

THE AMR FOR THIS RIFLE IS: 1.127

7 Oct 1988 FILE:/PATTERNING/CENTERFIRE_PATT/C6225233

CENTERFIRE PATTERNS # 1



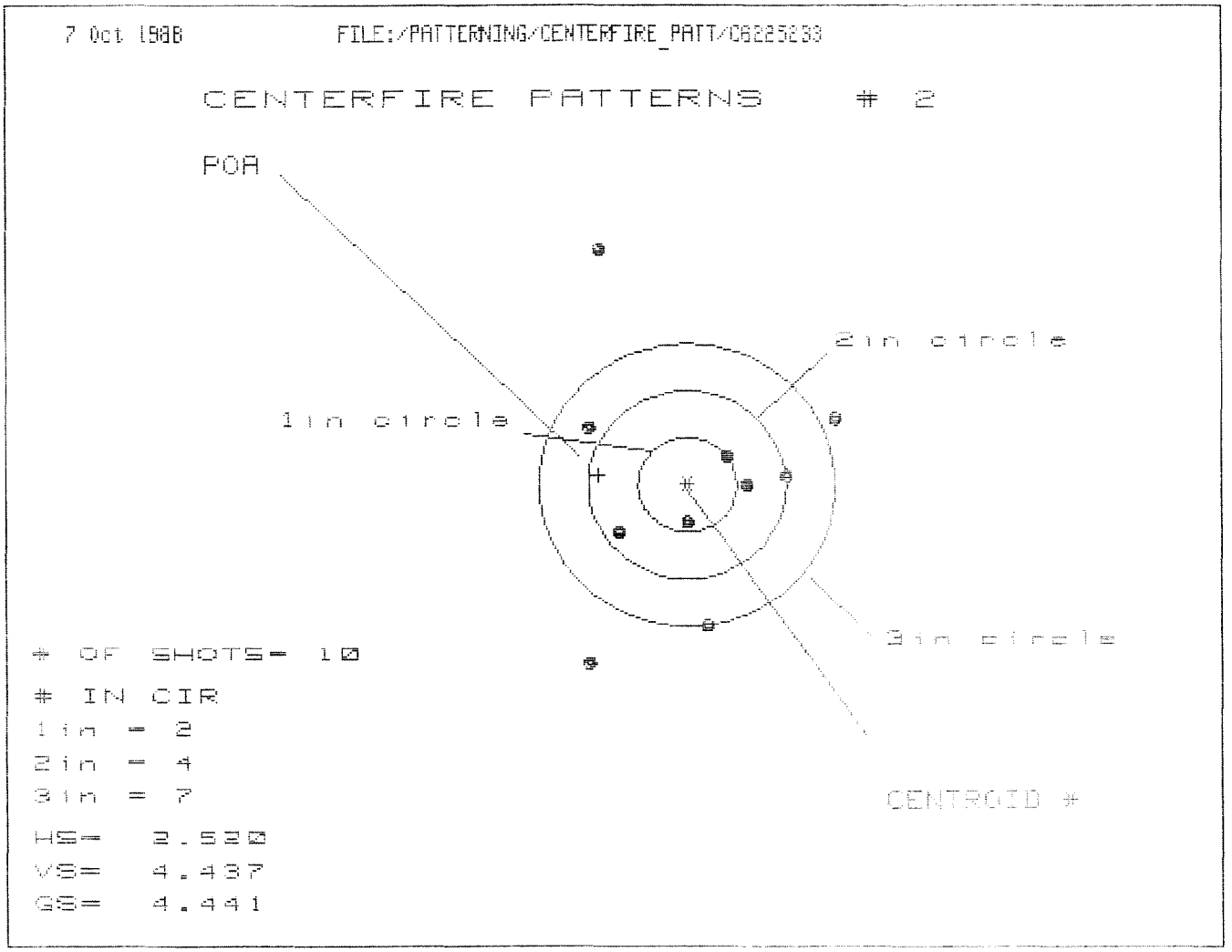
OF SHOTS= 10

# IN CIR	
1in	= 2
2in	= 5
3in	= 8

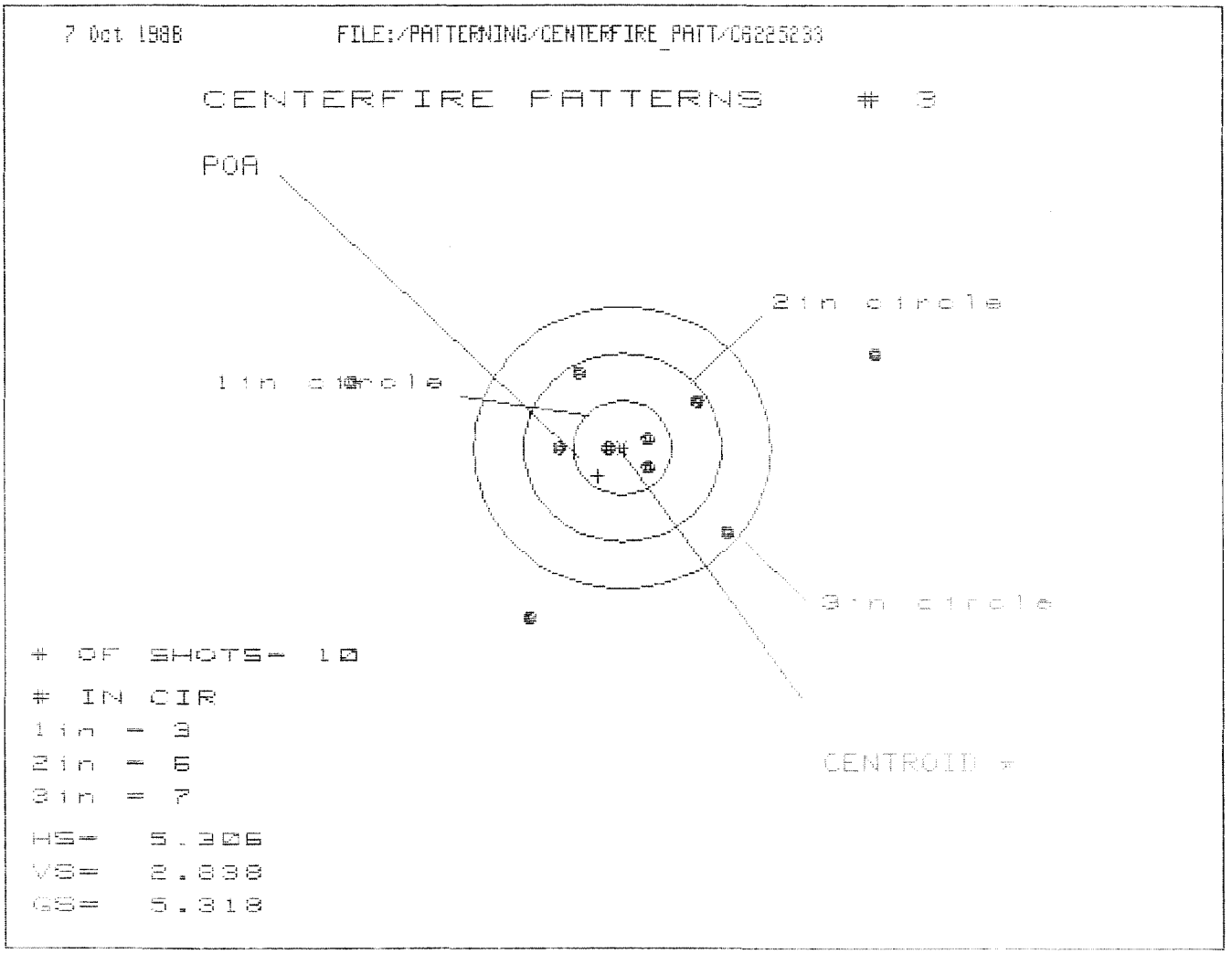
HS= 2.221
VS= 3.443
GS= 3.450

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.371	1.381	1.421
MINIMUM X	:	-.850	-.840	-.800
MAXIMUM Y	:	1.689	1.494	1.059
MINIMUM Y	:	-1.754	-.917	-.731
CENTROID X	:	.192	.182	.142
CENTROID Y	:	.334	.529	.343
POA TO CENTROID in.	:	.386	.560	.371
MIN RADIUS	:	.101	.228	.055
MEAN RADIUS	:	1.029	.958	.839
MAX RADIUS	:	1.757	1.528	1.475
HORIZONTAL SPREAD	:	2.221	2.221	2.221
VERTICAL SPREAD	:	3.443	2.411	1.790
EXTREME SPREAD	:	3.450	2.655	2.655

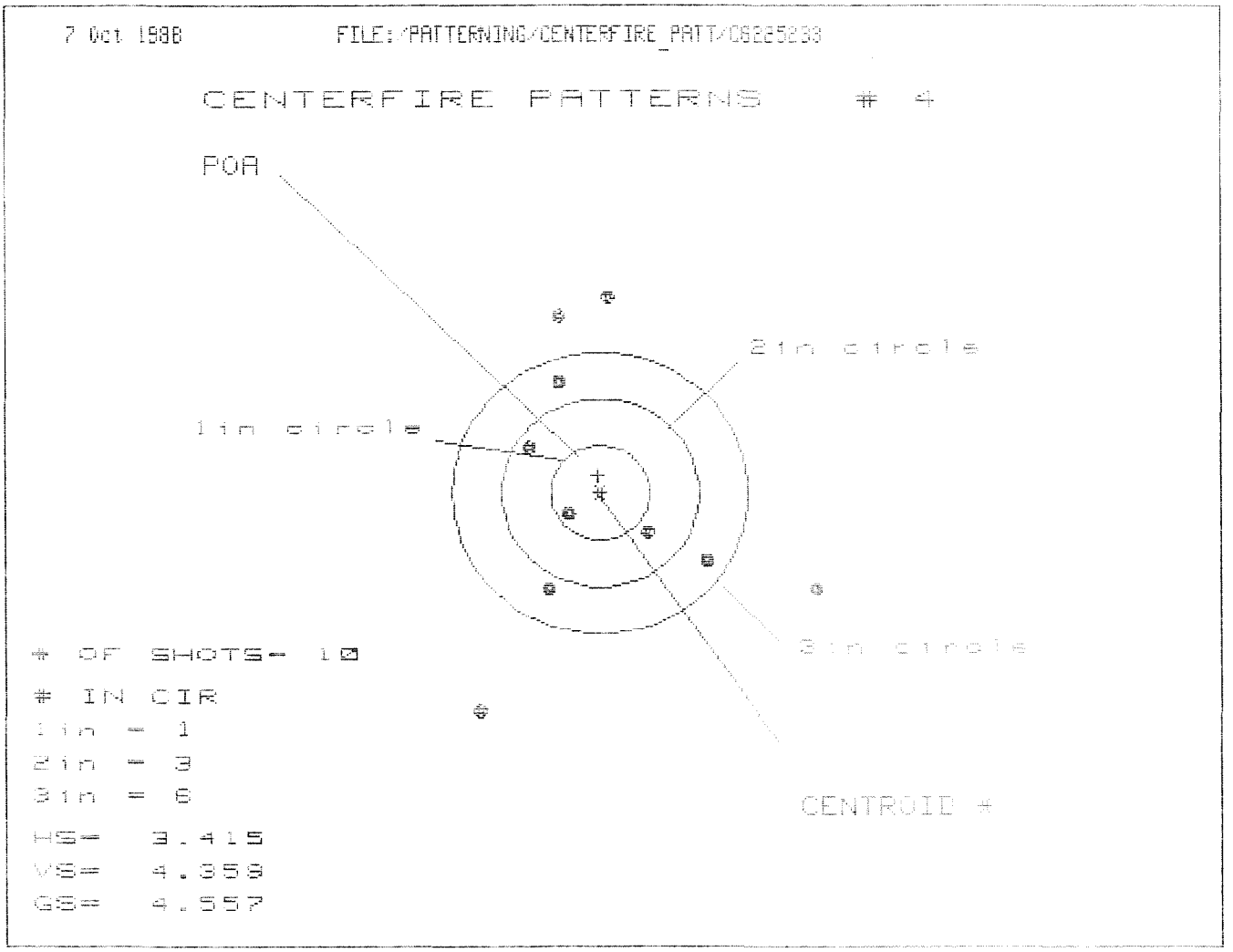
NUMBER IN ONE INCH CIRCLE = 2
NUMBER IN TWO INCH CIRCLE = 5
NUMBER IN THREE INCH CIRCLE = 8



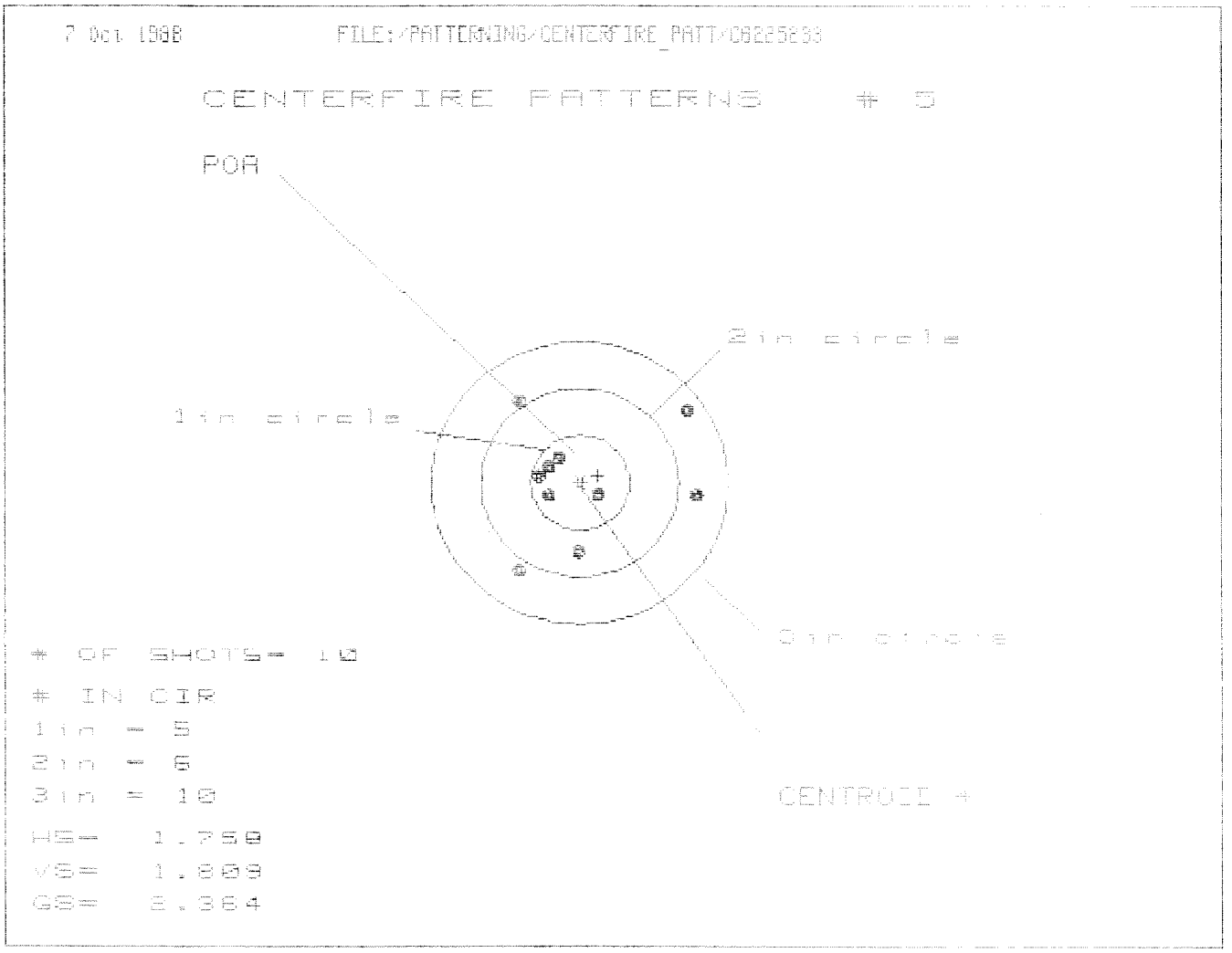
PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.484	1.389	1.247
MINIMUM X	:	-1.036	-1.131	-1.210
MAXIMUM Y	:	2.533	1.012	.810
MINIMUM Y	:	-1.904	-1.623	-1.383
CENTROID X	:	.897	.992	1.133
CENTROID Y	:	-.105	-.386	-.184
POA TO CENTROID in.	:	.903	1.065	1.148
MIN RADIUS	:	.379	.164	.351
MEAN RADIUS	:	1.244	1.052	.907
MAX RADIUS	:	2.673	1.978	1.487
HORIZONTAL SPREAD	:	2.520	2.520	2.458
VERTICAL SPREAD	:	4.437	2.635	2.193
EXTREME SPREAD	:	4.441	3.646	2.557
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		7	



PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.589	2.288	1.036
MINIMUM X	:	-2.717	-1.214	-.929
MAXIMUM Y	:	1.021	1.095	.965
MINIMUM Y	:	-1.817	-1.743	-1.606
CENTROID X	:	.244	.545	.260
CENTROID Y	:	.300	.226	.089
POA TO CENTROID in.	:	.386	.590	.274
MIN RADIUS	:	.125	.136	.255
MEAN RADIUS	:	1.214	1.030	.841
MAX RADIUS	:	2.796	2.536	1.855
HORIZONTAL SPREAD	:	5.306	3.502	1.965
VERTICAL SPREAD	:	2.838	2.838	2.571
EXTREME SPREAD	:	5.318	4.508	2.805
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		7	



PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.146	2.005	1.141
MINIMUM X	:	-1.269	-.880	-.630
MAXIMUM Y	:	2.085	1.832	1.677
MINIMUM Y	:	-2.274	-1.243	-1.381
CENTROID X	:	.021	.162	-.088
CENTROID Y	:	-.184	.069	.224
POA TO CENTROID in.	:	.185	.176	.241
MIN RADIUS	:	.401	.661	.636
MEAN RADIUS	:	1.449	1.335	1.166
MAX RADIUS	:	2.604	2.359	1.685
HORIZONTAL SPREAD	:	3.415	2.885	1.771
VERTICAL SPREAD	:	4.359	3.075	3.058
EXTREME SPREAD	:	4.557	3.844	3.112
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		6	



PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.142	1.258	.460
MINIMUM X	:	-.616	-.500	-.343
MAXIMUM Y	:	.873	.960	.957
MINIMUM Y	:	-.936	-.849	-.852
CENTROID X	:	-.181	-.297	-.454
CENTROID Y	:	-.073	-.160	-.156
POA TO CENTROID in.	:	.195	.337	.480
MIN RADIUS	:	.250	.201	.089
MEAN RADIUS	:	.697	.602	.492
MAX RADIUS	:	1.304	1.258	1.016
HORIZONTAL SPREAD	:	1.758	1.758	.803
VERTICAL SPREAD	:	1.809	1.809	1.809
EXTREME SPREAD	:	2.364	2.017	1.809
NUMBER IN ONE INCH CIRCLE	=	5		
NUMBER IN TWO INCH CIRCLE	=	6		
NUMBER IN THREE INCH CIRCLE	=	10		