

C6225323

MODEL 700™ M24

Model **700 M24™**

Action

Barrel Length

Capacity

Order No. **5716**

\*Includes 1 in chamber.

*Remington*

## Arms Services Repair &amp; Estimate System

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

## Repair Inquiry

Repair Number: RE00142405

Serial: C6225323 Model M24 SWS Center Fire  
Caliber: 7.62 NATO Produced: 12/20/1988

Repairman:

Status: Closed 3/4/2008 7:21:38 AM

Verify Repair

## Address Information

Customer:

☒ Received From

Return To:

☐ Received From

Name:

Address 1:

Address 2:

PO Box:

PO Box:

City: FORT BRAGG

FORT BRAGG

State: NC

Zip Code: 28310

Country: US

State: NC

Zip Code: 28310

Country: US

FPL:

## 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 |
|------|-----------------------|-----|
| A006 | Sling Strap           | 1   |
| A007 | With Stud             | 3   |
| A008 | With Swivel           | 3   |
| A010 | Hard Case             | 1   |
| A026 | Scope                 | 1   |
| A045 | Bi Pod                | 1   |
| A057 | Fit and Rear Sgt Base | 1   |

## Repair Search

Refresh

Close

nagletj

3/4/2008

9:14 AM

CAPS

NUM



Serial Number: C6225323

Model: M24 SWS



RE00142405



SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6225323.\_\_\_0  
FILE DATE AND TIME: 04/03/2008 09:47

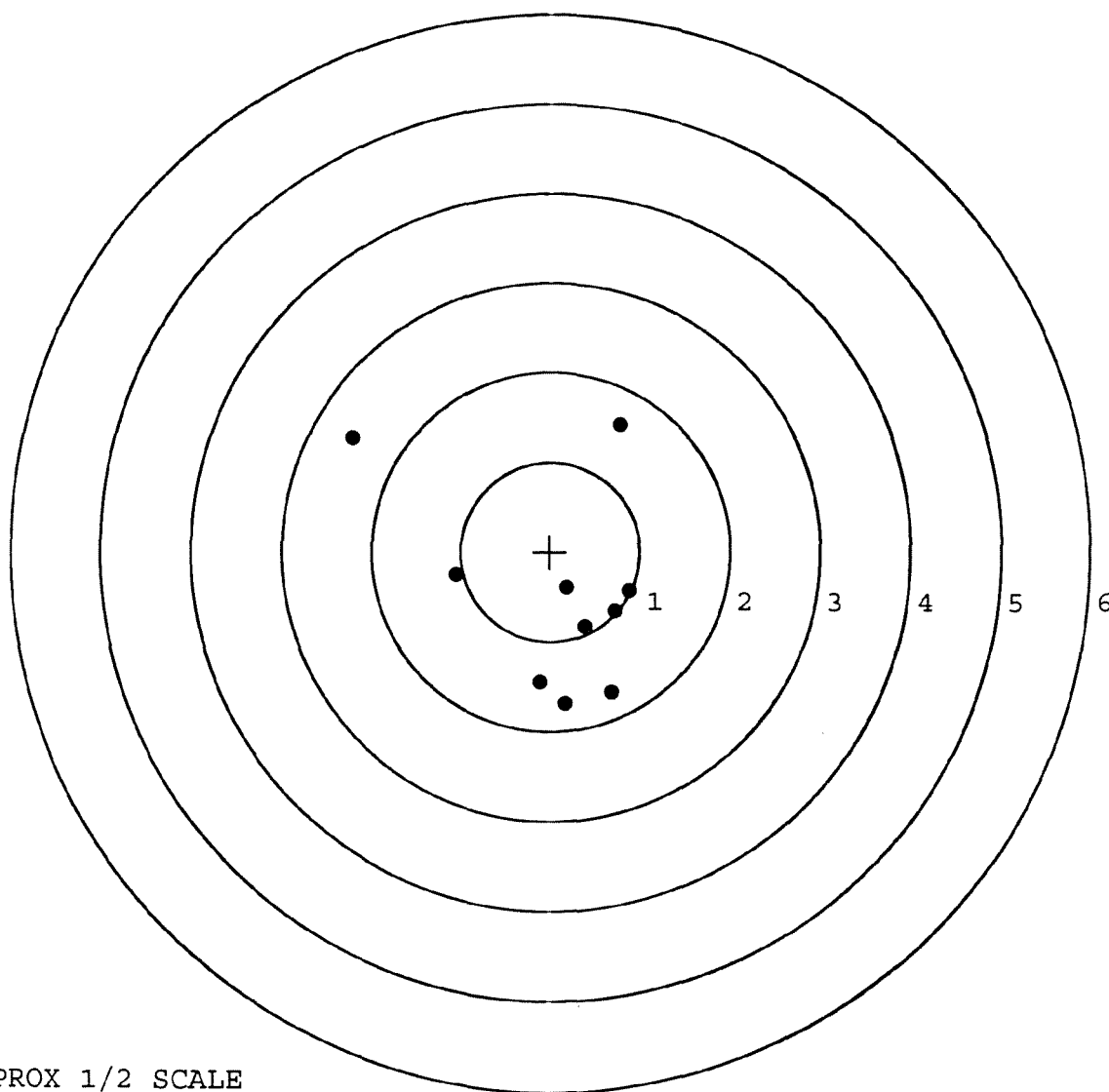
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

|                                                             |        |
|-------------------------------------------------------------|--------|
| The Average X Centroid of the Five Target Set:              | 0.075  |
| The Average Y Centroid of the Five Target Set:              | -0.075 |
| The Average Point of Impact of the Five Target Set:         | 0.106  |
| The Average Mean Radius of the Five Target Set:             | 1.035  |
| The Distance from POA to Centroid Target #1:                | 0.468  |
| The Distance from Centroid Target #2 to Centroid Target #1: | 0.748  |
| The Distance from Centroid Target #3 to Centroid Target #1: | 0.071  |
| The Distance from Centroid Target #4 to Centroid Target #1: | 0.372  |
| The Distance from Centroid Target #5 to Centroid Target #1: | 0.828  |

SERIAL NUMBER: C6225323. \_\_0  
TARGET NUMBER: 1  
FILE DATE: 04/03/2008  
FILE TIME: 09:47

X CENTROID: 0.046  
Y CENTROID: -0.466  
POA TO CENTROID: 0.468  
HORZ SPREAD: 3.097  
VERT SPREAD: 3.118  
GROUP SPREAD: 4.058  
MIN RADIUS: 0.153  
MAX RADIUS: 2.846  
MEAN RADIUS: 1.171  
# IN 1 IN DIAMETER: 1  
# IN 2 IN DIAMETER: 4  
# in 3 IN DIAMETER: 8

| POINT# | X      | Y      |
|--------|--------|--------|
| 1:     | 0.777  | 1.419  |
| 2:     | 0.187  | -0.406 |
| 3:     | 0.884  | -0.437 |
| 4:     | 0.722  | -0.661 |
| 5:     | 0.393  | -0.839 |
| 6:     | 0.691  | -1.570 |
| 7:     | 0.177  | -1.699 |
| 8:     | -0.111 | -1.463 |
| 9:     | -1.049 | -0.265 |
| 10:    | -2.213 | 1.265  |



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6225323. \_\_ 0

TARGET NUMBER: 2

FILE DATE: 04/03/2008

FILE TIME: 09:47

| POINT# | X | Y |
|--------|---|---|
|--------|---|---|

|    |       |       |
|----|-------|-------|
| 1: | 0.886 | 0.273 |
|----|-------|-------|

|    |       |        |
|----|-------|--------|
| 2: | 1.463 | -0.664 |
|----|-------|--------|

|    |       |        |
|----|-------|--------|
| 3: | 0.246 | -0.505 |
|----|-------|--------|

|    |       |        |
|----|-------|--------|
| 4: | 0.478 | -1.302 |
|----|-------|--------|

|    |        |       |
|----|--------|-------|
| 5: | -0.133 | 0.344 |
|----|--------|-------|

|    |        |       |
|----|--------|-------|
| 6: | -0.339 | 0.641 |
|----|--------|-------|

|    |        |       |
|----|--------|-------|
| 7: | -0.516 | 0.725 |
|----|--------|-------|

|    |        |       |
|----|--------|-------|
| 8: | -0.502 | 1.233 |
|----|--------|-------|

|    |        |       |
|----|--------|-------|
| 9: | -1.175 | 1.228 |
|----|--------|-------|

|     |        |       |
|-----|--------|-------|
| 10: | -1.283 | 0.731 |
|-----|--------|-------|

X CENTROID: -0.088

Y CENTROID: 0.270

POA TO CENTROID: 0.284

HORZ SPREAD: 2.746

VERT SPREAD: 2.535

GROUP SPREAD: 3.246

MIN RADIUS: 0.087

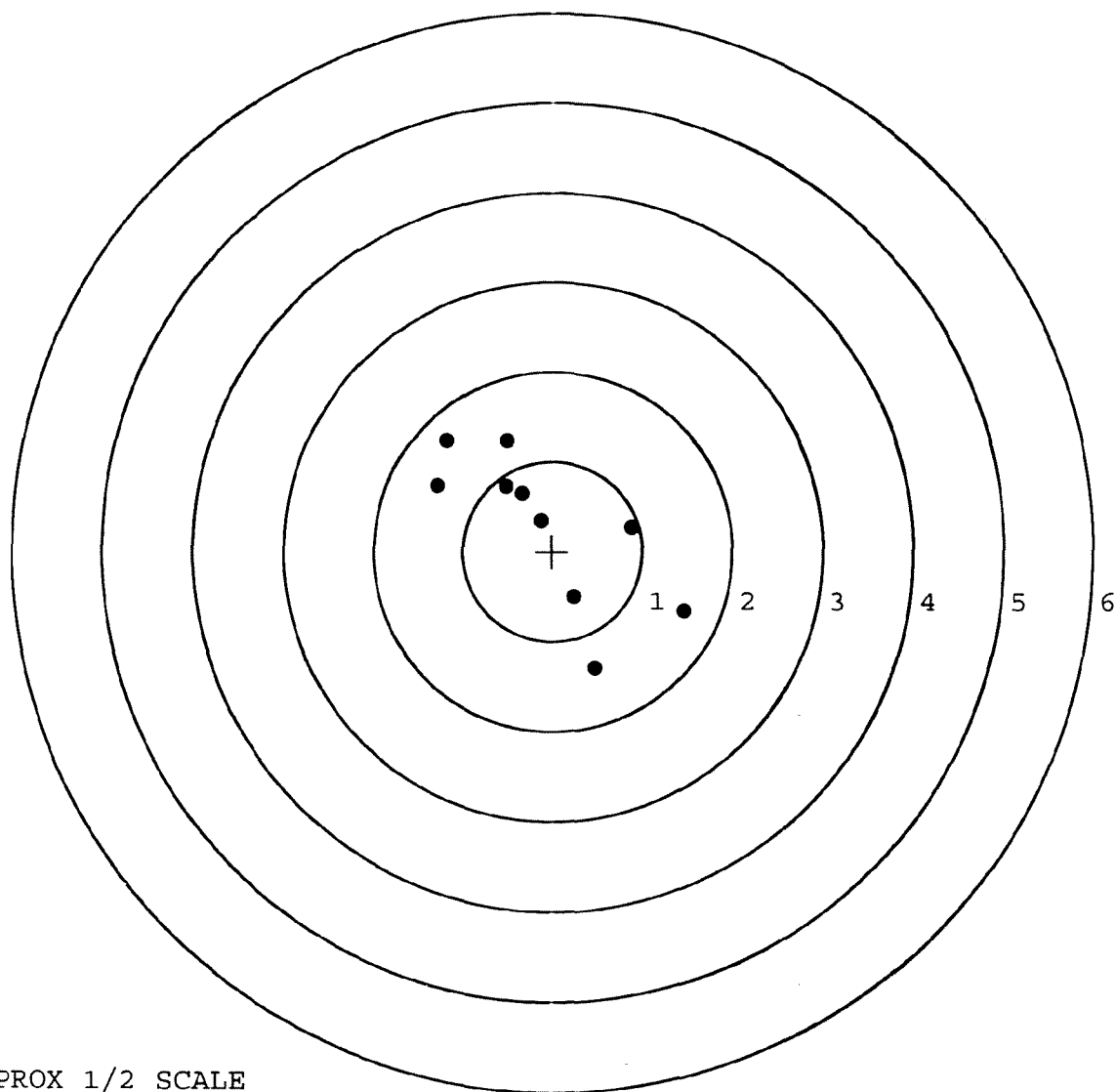
MAX RADIUS: 1.810

MEAN RADIUS: 1.024

# IN 1 IN DIAMETER: 2

# IN 2 IN DIAMETER: 5

# in 3 IN DIAMETER: 8



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6225323. 0

TARGET NUMBER: 3

FILE DATE: 04/03/2008

FILE TIME: 09:47

| POINT# | X | Y |
|--------|---|---|
|--------|---|---|

|    |        |       |
|----|--------|-------|
| 1: | -0.134 | 1.670 |
|----|--------|-------|

|    |        |       |
|----|--------|-------|
| 2: | -0.666 | 0.282 |
|----|--------|-------|

|    |       |        |
|----|-------|--------|
| 3: | 0.866 | -0.237 |
|----|-------|--------|

|    |       |        |
|----|-------|--------|
| 4: | 0.573 | -0.450 |
|----|-------|--------|

|    |       |        |
|----|-------|--------|
| 5: | 0.371 | -0.702 |
|----|-------|--------|

|    |        |        |
|----|--------|--------|
| 6: | -0.244 | -0.492 |
|----|--------|--------|

|    |        |        |
|----|--------|--------|
| 7: | -0.470 | -0.872 |
|----|--------|--------|

|    |        |        |
|----|--------|--------|
| 8: | -0.577 | -1.722 |
|----|--------|--------|

|    |       |        |
|----|-------|--------|
| 9: | 1.026 | -1.230 |
|----|-------|--------|

|     |       |        |
|-----|-------|--------|
| 10: | 0.303 | -0.515 |
|-----|-------|--------|

X CENTROID: 0.105

Y CENTROID: -0.427

POA TO CENTROID: 0.439

HORZ SPREAD: 1.692

VERT SPREAD: 3.392

GROUP SPREAD: 3.421

MIN RADIUS: 0.217

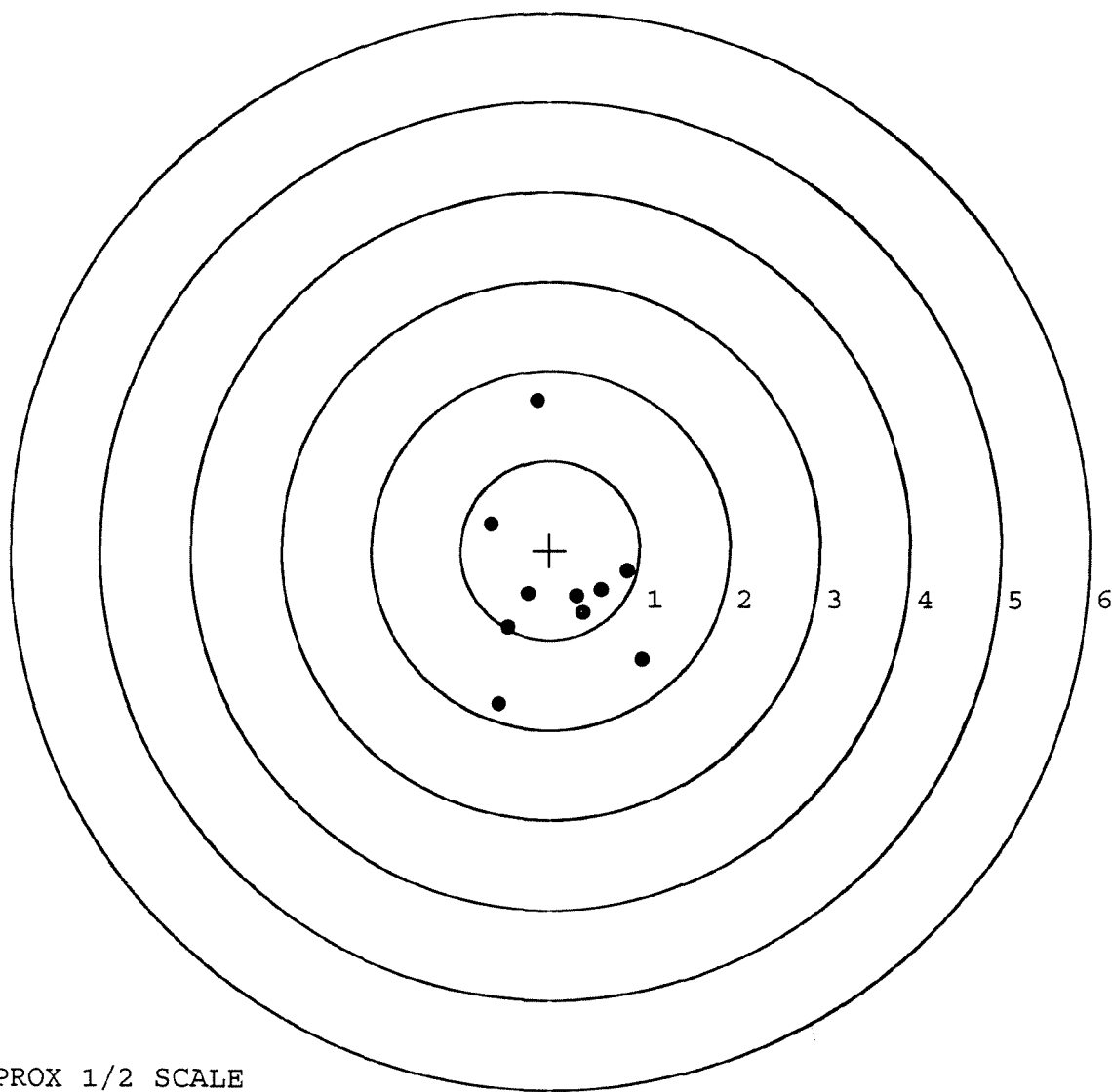
MAX RADIUS: 2.110

MEAN RADIUS: 0.878

# IN 1 IN DIAMETER: 4

# IN 2 IN DIAMETER: 6

# in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6225323.\_0

TARGET NUMBER: 4

FILE DATE: 04/03/2008

FILE TIME: 09:47

| POINT# | X      | Y      |
|--------|--------|--------|
| 1:     | 0.805  | 1.244  |
| 2:     | 0.114  | 0.151  |
| 3:     | -0.264 | 0.450  |
| 4:     | -0.637 | 0.902  |
| 5:     | -0.139 | -0.289 |
| 6:     | 0.297  | -0.447 |
| 7:     | 0.307  | -0.822 |
| 8:     | -0.022 | -0.934 |
| 9:     | -0.487 | -0.726 |
| 10:    | 1.208  | -0.540 |

X CENTROID: 0.118

Y CENTROID: -0.101

POA TO CENTROID: 0.156

HORZ SPREAD: 1.845

VERT SPREAD: 2.178

GROUP SPREAD: 2.356

MIN RADIUS: 0.252

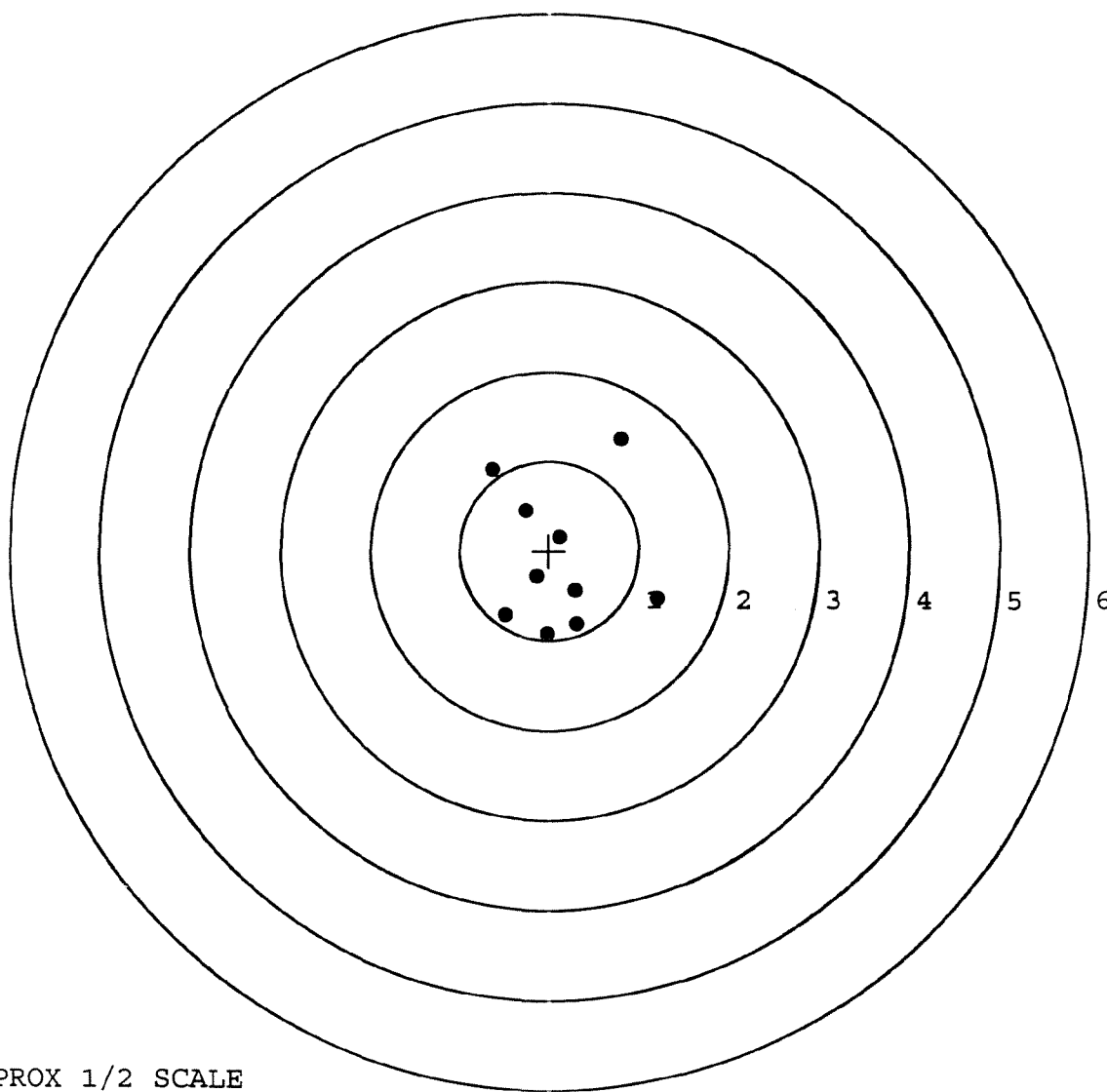
MAX RADIUS: 1.510

MEAN RADIUS: 0.803

# IN 1 IN DIAMETER: 3

# IN 2 IN DIAMETER: 7

# in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE



SERIAL NUMBER: C6225323. \_\_0

TARGET NUMBER: 5

FILE DATE: 04/03/2008

FILE TIME: 09:47

| POINT# | X      | Y      |
|--------|--------|--------|
| 1:     | 0.232  | 1.156  |
| 2:     | -0.482 | 1.133  |
| 3:     | -0.965 | 0.791  |
| 4:     | -1.042 | 1.083  |
| 5:     | -1.418 | 1.154  |
| 6:     | 0.451  | 0.256  |
| 7:     | 1.539  | -0.035 |
| 8:     | 2.015  | 0.141  |
| 9:     | 0.715  | -0.506 |
| 10:    | 0.879  | -1.679 |

X CENTROID: 0.192

Y CENTROID: 0.349

POA TO CENTROID: 0.399

HORZ SPREAD: 3.433

VERT SPREAD: 2.835

GROUP SPREAD: 3.647

MIN RADIUS: 0.275

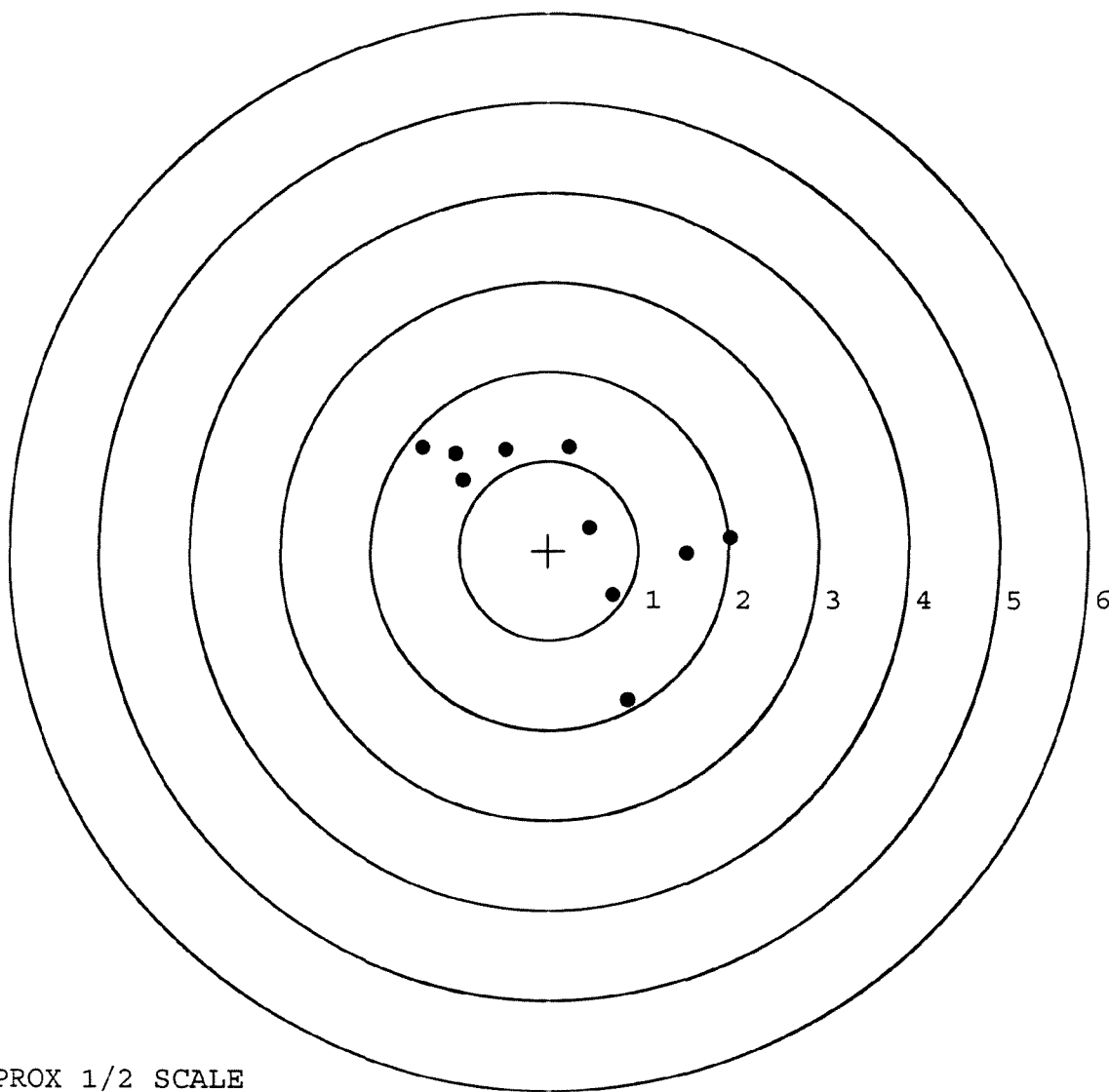
MAX RADIUS: 2.141

MEAN RADIUS: 1.297

# IN 1 IN DIAMETER: 1

# IN 2 IN DIAMETER: 2

# in 3 IN DIAMETER: 7



TARGET APPROX 1/2 SCALE

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

R & E NUMBER 00142405

SERIAL NUMBER C 6225323

LOG-IN DATE 3-3-08

| OPERATION # | OPERATION NAME       |                                                                                                                                              | DATE                            | INITIAL |
|-------------|----------------------|----------------------------------------------------------------------------------------------------------------------------------------------|---------------------------------|---------|
| 500         | DIS-ASSEMBLE GUN     |                                                                                                                                              | 3-11-08                         | APD     |
| 505         | RE-BARREL            |                                                                                                                                              | 3-12-08                         | APD     |
| 560         | ASSEMBLE             |                                                                                                                                              | 3-12-08                         | APD     |
| 600         | PROOF                | <div style="border: 1px solid black; padding: 5px; text-align: center;"> MAGNA - FLUX<br/> MAX 4.0 2008<br/> OPERATOR <i>unmarked</i> </div> | 3-13-08                         | TRW     |
| 605         | CHECK HEADSPACE      |                                                                                                                                              | 3-13-08                         | TRW     |
| 610         | DIS-ASSEMBLE GUN     |                                                                                                                                              | 3-13-08                         | APD     |
| 612         | MAGNAFLUX            |                                                                                                                                              | 3-14-08                         | WNS     |
| 510         | DRILL AND TAP        |                                                                                                                                              | 3-13-08                         | FM      |
| 615         | ROLLMARK CALIBER     |                                                                                                                                              | 3-13-08                         | CW      |
| 618         | ROTO-BLAST           |                                                                                                                                              | 3-14-08                         | DC      |
| 620         | APPLY COATINGS       |                                                                                                                                              | 3-20-08                         | HP      |
| 625         | FINAL ASSEMBLY       |                                                                                                                                              | 4-1-08                          | APD     |
| 640         | FUNCTION TEST AND    | PASS FAIL                                                                                                                                    | 4-3-08                          | SD      |
| 650         | TARGET               | PASS FAIL                                                                                                                                    | 4-3-08                          | SD      |
|             | MALFUNCTION          | CORRECTION                                                                                                                                   |                                 |         |
|             | MALFUNCTION          | CORRECTION                                                                                                                                   |                                 |         |
|             | MALFUNCTION          | CORRECTION                                                                                                                                   |                                 |         |
|             | MALFUNCTION          | CORRECTION                                                                                                                                   | 4-3-08                          | TRW     |
| 670         | FINAL INSPECTION     |                                                                                                                                              | 4/7/08                          | FM      |
|             | A) HEADSPACE         | PASS FAIL                                                                                                                                    | 4/12/08                         | FM      |
|             | B) TRIGGER PULL      | <div style="border: 1px solid black; padding: 2px; display: inline-block;"> +/- .5 LBS<br/> MIN 2.50 LBS<br/> MAX 4.0 LBS </div>             | 2.77 2.58 2.57 2.60 2.55 4/7/08 | FM      |
| 680         | F) SAFETY ON FORCE   | <div style="border: 1px solid black; padding: 2px; display: inline-block;"> 2 LBS MIN<br/> 10 LBS MAX </div>                                 | 4.5 4 4 4/7/08                  | FM      |
|             | G) SAFETY OFF FORCE  | <div style="border: 1px solid black; padding: 2px; display: inline-block;"> 2 LBS<br/> MIN </div>                                            | 2.5 2.5 2.5 4/7/08              | FM      |
|             | I) FIRING PIN INDENT | .020                                                                                                                                         | .023 .022 .022 4/7/08           | FM      |
| 690         | PACK                 |                                                                                                                                              | 4/16/08                         | FM      |

Serial Number: C6225323

Model: M24 SWS



RE00078725

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6225323.\_\_\_0  
FILE DATE AND TIME: 04/06/2004 06:24

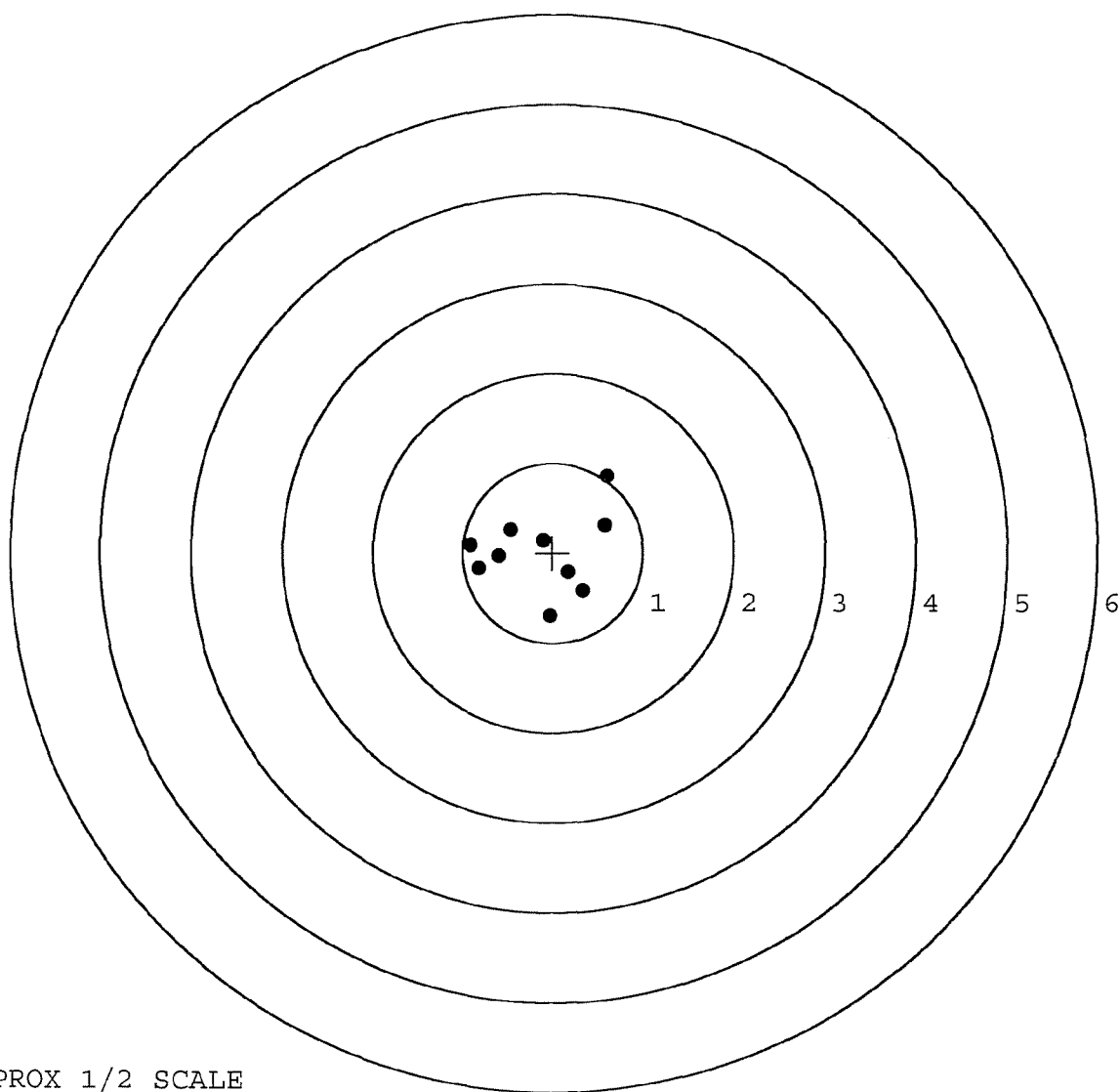
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

|                                                             |        |
|-------------------------------------------------------------|--------|
| The Average X Centroid of the Five Target Set:              | -0.082 |
| The Average Y Centroid of the Five Target Set:              | -0.059 |
| The Average Point of Impact of the Five Target Set:         | 0.101  |
| The Average Mean Radius of the Five Target Set:             | 0.727  |
| The Distance from POA to Centroid Target #1:                | 0.126  |
| The Distance from Centroid Target #2 to Centroid Target #1: | 0.076  |
| The Distance from Centroid Target #3 to Centroid Target #1: | 0.318  |
| The Distance from Centroid Target #4 to Centroid Target #1: | 0.118  |
| The Distance from Centroid Target #5 to Centroid Target #1: | 0.145  |

SERIAL NUMBER: C6225323. \_\_0  
TARGET NUMBER: 1  
FILE DATE: 04/06/2004  
FILE TIME: 06:24

| POINT# | X      | Y      |
|--------|--------|--------|
| 1:     | 0.576  | 0.310  |
| 2:     | 0.603  | 0.857  |
| 3:     | 0.335  | -0.414 |
| 4:     | -0.029 | -0.701 |
| 5:     | 0.175  | -0.220 |
| 6:     | -0.106 | 0.134  |
| 7:     | -0.471 | 0.255  |
| 8:     | -0.598 | -0.036 |
| 9:     | -0.823 | -0.169 |
| 10:    | -0.919 | 0.089  |

X CENTROID: -0.126  
Y CENTROID: 0.011  
POA TO CENTROID: 0.126  
HORZ SPREAD: 1.522  
VERT SPREAD: 1.558  
GROUP SPREAD: 1.757  
MIN RADIUS: 0.125  
MAX RADIUS: 1.117  
MEAN RADIUS: 0.614  
# IN 1 IN DIAMETER: 4  
# IN 2 IN DIAMETER: 9  
# in 3 IN DIAMETER: 10

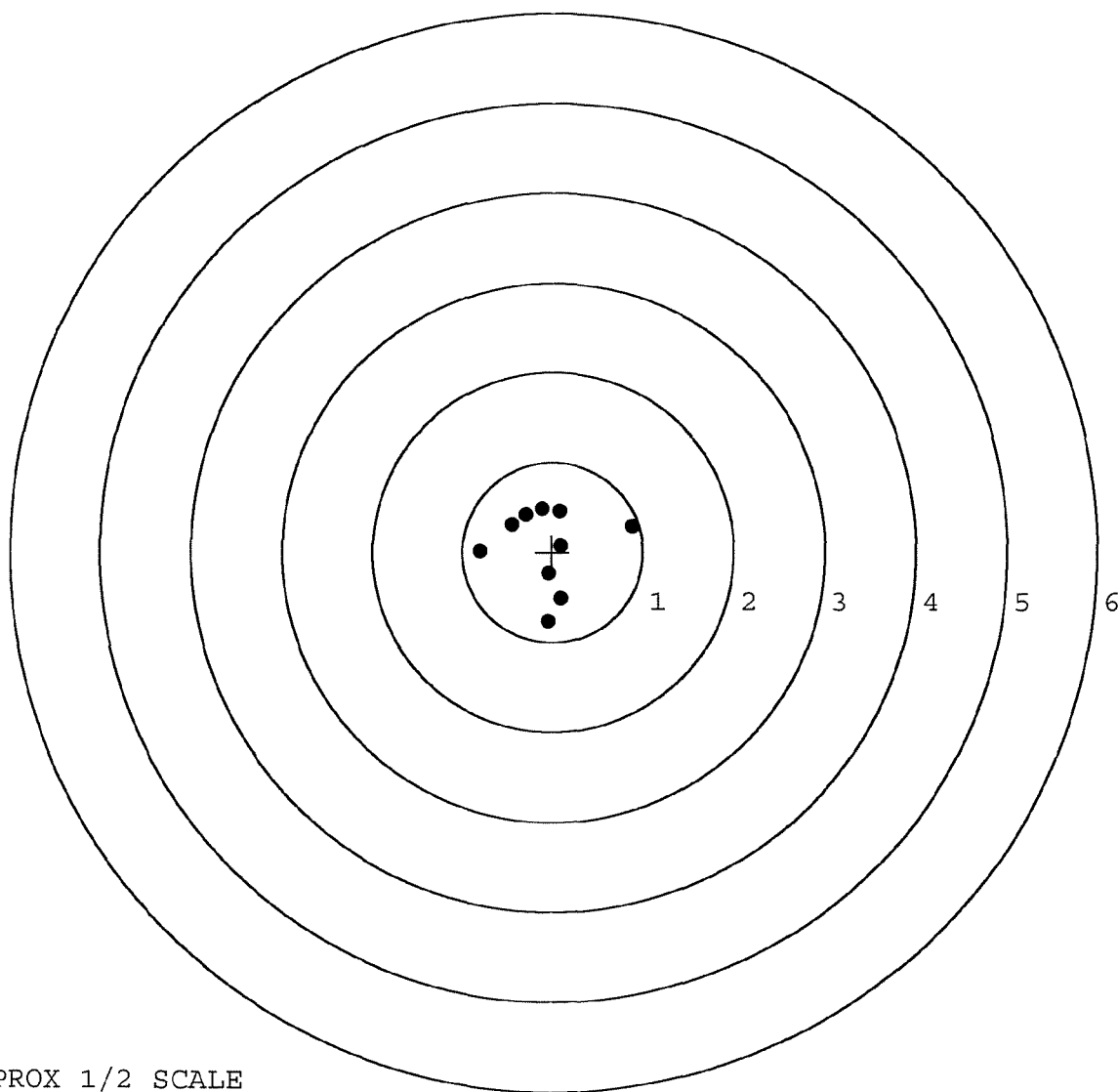


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6225323. \_\_0  
TARGET NUMBER: 2  
FILE DATE: 04/06/2004  
FILE TIME: 06:24

X CENTROID: -0.060  
Y CENTROID: 0.050  
POA TO CENTROID: 0.078  
HORZ SPREAD: 1.685  
VERT SPREAD: 1.260  
GROUP SPREAD: 1.707  
MIN RADIUS: 0.159  
MAX RADIUS: 0.971  
MEAN RADIUS: 0.537  
# IN 1 IN DIAMETER: 6  
# IN 2 IN DIAMETER: 10  
# in 3 IN DIAMETER: 10

| POINT# | X      | Y      |
|--------|--------|--------|
| 1:     | 0.881  | 0.288  |
| 2:     | -0.804 | 0.015  |
| 3:     | -0.453 | 0.312  |
| 4:     | -0.295 | 0.417  |
| 5:     | -0.117 | 0.482  |
| 6:     | 0.083  | 0.460  |
| 7:     | 0.098  | 0.070  |
| 8:     | -0.041 | -0.241 |
| 9:     | 0.095  | -0.525 |
| 10:    | -0.049 | -0.778 |

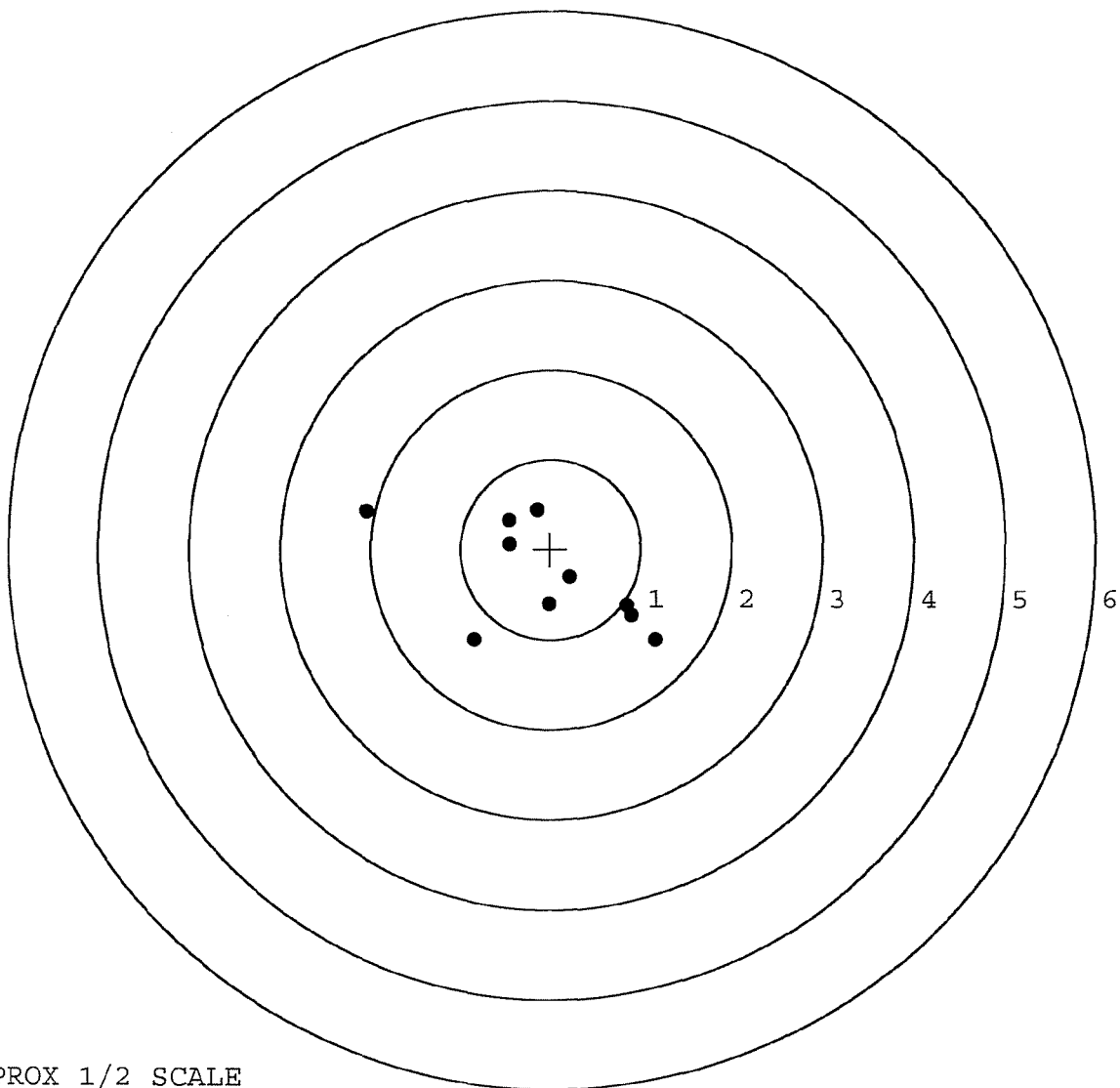


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6225323. \_\_0  
TARGET NUMBER: 3  
FILE DATE: 04/06/2004  
FILE TIME: 06:24

| POINT# | X      | Y      |
|--------|--------|--------|
| 1:     | 1.155  | -1.009 |
| 2:     | 0.899  | -0.739 |
| 3:     | 0.840  | -0.622 |
| 4:     | 0.216  | -0.308 |
| 5:     | -0.015 | -0.612 |
| 6:     | -0.849 | -1.001 |
| 7:     | -2.052 | 0.425  |
| 8:     | -0.448 | 0.058  |
| 9:     | -0.465 | 0.323  |
| 10:    | -0.150 | 0.437  |

X CENTROID: -0.087  
Y CENTROID: -0.305  
POA TO CENTROID: 0.317  
HORZ SPREAD: 3.207  
VERT SPREAD: 1.446  
GROUP SPREAD: 3.513  
MIN RADIUS: 0.303  
MAX RADIUS: 2.096  
MEAN RADIUS: 0.922  
# IN 1 IN DIAMETER: 2  
# IN 2 IN DIAMETER: 6  
# in 3 IN DIAMETER: 9

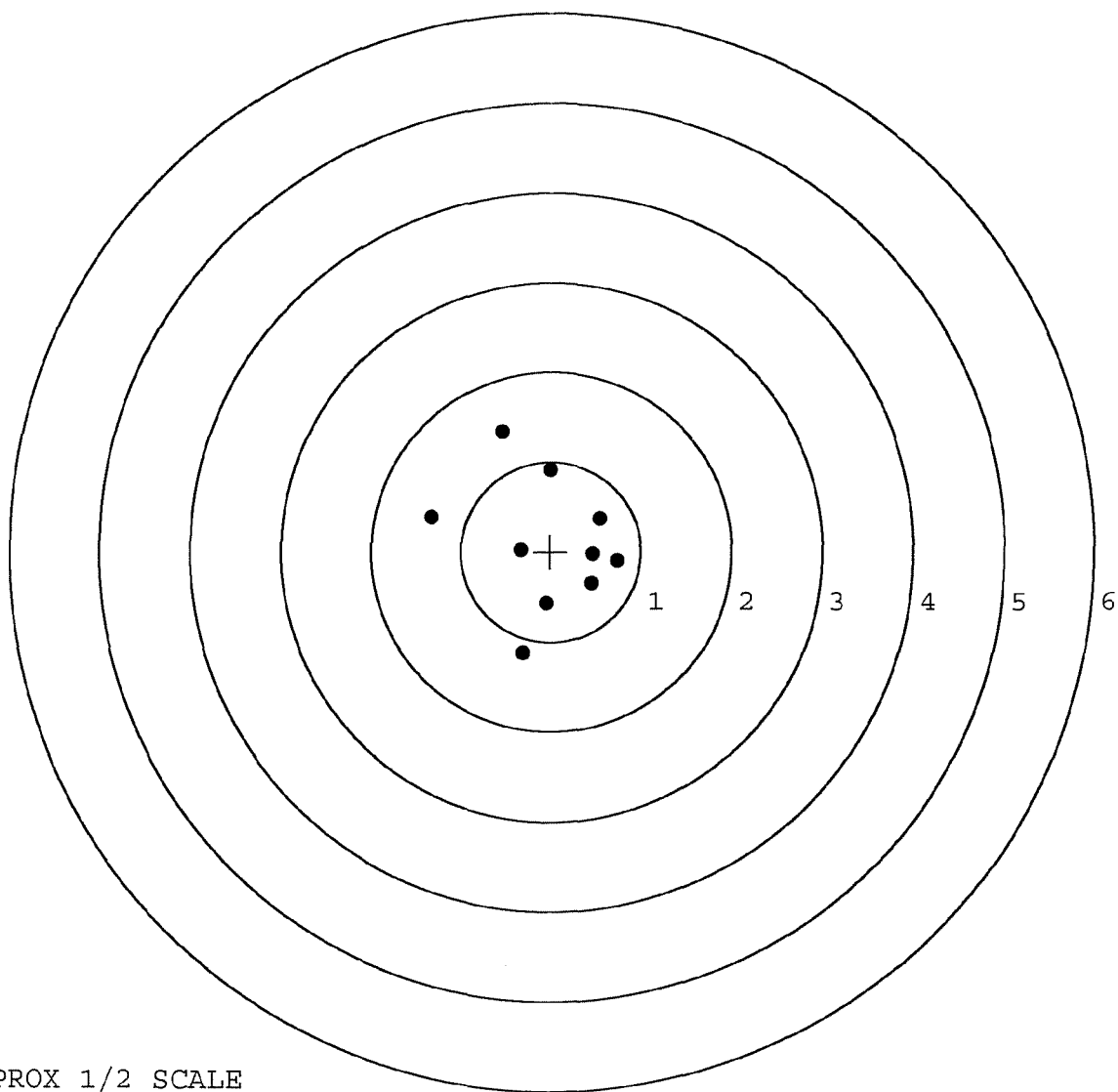


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6225323. 0  
TARGET NUMBER: 4  
FILE DATE: 04/06/2004  
FILE TIME: 06:24

| POINT# | X      | Y      |
|--------|--------|--------|
| 1:     | -0.302 | -1.127 |
| 2:     | -0.049 | -0.578 |
| 3:     | 0.455  | -0.352 |
| 4:     | 0.743  | -0.101 |
| 5:     | 0.546  | 0.370  |
| 6:     | 0.006  | 0.912  |
| 7:     | -0.543 | 1.336  |
| 8:     | -0.332 | 0.021  |
| 9:     | -1.327 | 0.385  |
| 10:    | 0.472  | -0.024 |

X CENTROID: -0.033  
Y CENTROID: 0.084  
POA TO CENTROID: 0.090  
HORZ SPREAD: 2.070  
VERT SPREAD: 2.463  
GROUP SPREAD: 2.475  
MIN RADIUS: 0.306  
MAX RADIUS: 1.352  
MEAN RADIUS: 0.833  
# IN 1 IN DIAMETER: 1  
# IN 2 IN DIAMETER: 7  
# in 3 IN DIAMETER: 10



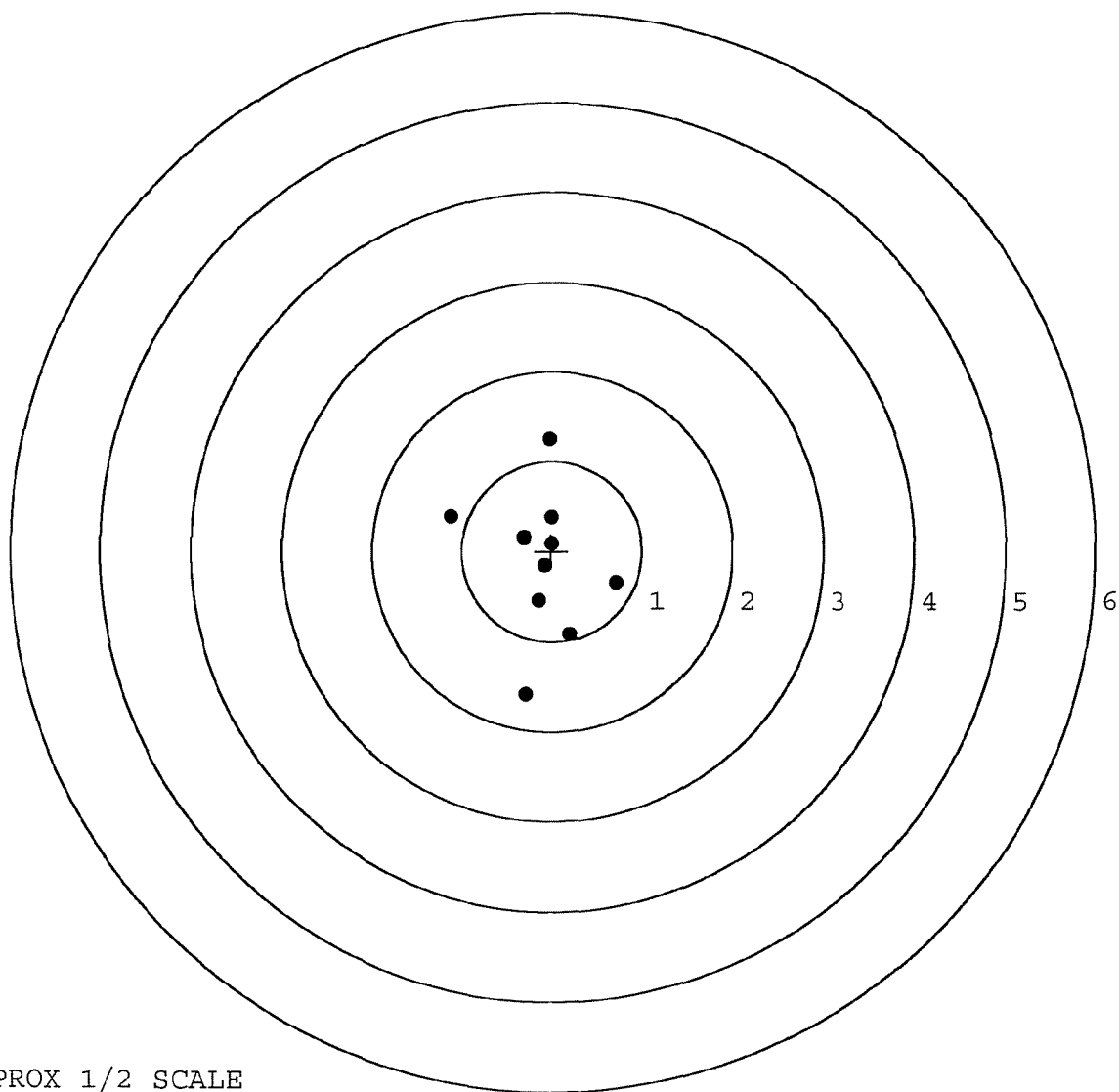
TARGET APPROX 1/2 SCALE



SERIAL NUMBER: C6225323.\_\_\_\_0  
TARGET NUMBER: 5  
FILE DATE: 04/06/2004  
FILE TIME: 06:24

X CENTROID: -0.103  
Y CENTROID: -0.133  
POA TO CENTROID: 0.168  
HORZ SPREAD: 1.838  
VERT SPREAD: 2.838  
GROUP SPREAD: 2.850  
MIN RADIUS: 0.040  
MAX RADIUS: 1.469  
MEAN RADIUS: 0.726  
# IN 1 IN DIAMETER: 4  
# IN 2 IN DIAMETER: 7  
# in 3 IN DIAMETER: 10

| POINT# | X      | Y      |
|--------|--------|--------|
| 1:     | 0.715  | -0.353 |
| 2:     | 0.201  | -0.921 |
| 3:     | -0.142 | -0.547 |
| 4:     | -0.281 | -1.591 |
| 5:     | -1.123 | 0.383  |
| 6:     | -0.024 | 1.247  |
| 7:     | 0.002  | 0.378  |
| 8:     | -0.309 | 0.154  |
| 9:     | -0.077 | -0.163 |
| 10:    | 0.008  | 0.085  |



TARGET APPROX 1/2 SCALE

FINAL INSPECTION CHECKLIST M-24 REPAIRS  
CONTRACT #: DAAE-20-02-D-0127

SERIAL # C6225323

INSPECTED BY: RTL

DATE REC'D: 3-16-04

DATE RET'D: 6-7-04

ITEM

BARREL ASSEMBLY

         BARREL  
         RECEIVER  
         FRONT SIGHT BASE  
         REAR SIGHT BASE  
         SCREWS  
         FINISH

SCOPE ASSEMBLY

         SCOPE  
         SCOPE RINGS  
         MOUNTING SCREWS  
         MOUNTING BASE  
         SCREWS  
         FINISH  
         CLARITY

ITEM

STOCK ASSEMBLY

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

SYSTEMS CASE

         SCOPE CASE  
         IRON SIGHTS  
         DEPLOYMENT KIT

TRIGGER ASSEMBLY

         SAFETY OPERATION  
         RE-SET TO FACTORY SPECS

COMMENTS:

|                     |                    |           |         |
|---------------------|--------------------|-----------|---------|
| R & E NUMBER        | 78725              |           |         |
| SERIAL NUMBER       | C6225323           |           |         |
| LOG-IN DATE         | 3-16-04            |           |         |
| INSPECT AND VERIFY: |                    |           |         |
| OPERATION #         | OPERATION NAME     | DATE      | INITIAL |
| 550                 | DIS-ASSEMBLE GUN   | 3-17-04   | RTL     |
| 560 A               | RE-BARREL          | 3-22-04   | RTL     |
| B                   | DRILL AND TAP      | 3-23-04   | TRW     |
| 575                 | ASSEMBLE           | 3-22-04   | RTL     |
| 600                 | PROOF              | 3-22-04   | RTL     |
| 605                 | CHECK HEADSPACE    | 3-22-04   | RTL     |
| 610                 | DIS-ASSEMBLE GUN   | 3-22-04   | RTL     |
| 612                 | MAGNAFLUX          | 3-22-04   | RTL     |
| 615                 | ROLLMARK CALIBER   | 3-22-04   | RTL     |
| 618                 | ROTO-BLAST         | 3/25/2004 | Dns.    |
| 620                 | APPLY COATINGS     | 4-3       | TA      |
| 625 A               | FINAL ASSEMBLY     | 4-5-04    | RW      |
| B                   | TRIGGER PULL TEST  |           |         |
| C                   | SAFETY "ON" FORCE  |           |         |
| D                   | SAFETY "OFF" FORCE |           |         |
| E                   | FIRING PIN INDENT  |           |         |
| 640                 | TARGET             | 4-6-04    | AC      |
| 655                 | FINAL INSPECT      | 4-16-04   | RR      |
| 660                 | PACK               | 6-14-04   | DA      |
|                     |                    | SHIP DATE |         |
| QAR INSPECTION DATE |                    |           |         |

SCOPE #

M-24

1056

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6225323

| OP. #        | OP. NAME                                                       | READINGS | DATE     | INITIAL |
|--------------|----------------------------------------------------------------|----------|----------|---------|
| 575 &<br>580 | Assemble Action<br>and stock                                   | 8        | 9/88     | FB      |
| 600          | Proof                                                          | 9        | 7/88     | RW      |
| 607          | Check Headspace                                                | 9        | 7/88     | RW      |
| 610          | Dis-assemble gun                                               |          | 6/88     | RW      |
| 612          | Magnaflux Barrel<br>Action                                     |          | 9-14-88  | Pfe.    |
|              | Magnaflux Bolt                                                 |          | 9-14-88  | Pfe.    |
| 615          | Rollmark Caliber                                               |          |          |         |
| 617          | Drill & Tap Sight Holes                                        |          |          |         |
| 618          | Polish Barrel                                                  |          |          |         |
| 620          | Apply Coatings<br>(Barrel Action)                              |          | 10-31-88 | TJA     |
|              | Apply Coatings (Bolt)                                          |          | 10-31-88 | TJA     |
| 625          | Final Assembly<br>A) Clean inside of<br>Bolt Assembly          |          | 11/2/88  | RW      |
|              | B) Inspect Rear Firing<br>Pin Hole for Chamfer<br>in Bolt Head |          | 11/2/88  | RW      |
|              | C) Inspect Ejector Hole<br>for Chamfer                         |          | 11/2/88  | RW      |

OVER

| OP.#         |                                                                   | READINGS           | DATE      | INITIAL |
|--------------|-------------------------------------------------------------------|--------------------|-----------|---------|
| 625<br>cont. | D) Oil Firing Pin Ass'y                                           |                    | 11/2/88   | RW      |
|              | E) Adjust Trigger Pull to<br>Min. Setting and Stake               |                    | 3 NOV 88  | JSJ     |
|              | F) Safety on Force                                                | 4   4   4          | 4 NOV 88  | JSJ     |
|              | G) Safety off Force                                               | 3   3   3          | 4 NOV 88  | JSJ     |
|              | H) Trigger Pull Test &<br>Retainability                           |                    | 3 NOV 88  | JSJ     |
|              | I) Firing Pin Indent                                              | .021   .025   .021 | 4 NOV 88  | JSJ     |
|              | J) Assemble Stock                                                 |                    | 11/2/88   | RW      |
|              | K) Assemble Swivel Studs                                          |                    | 29 NOV 88 | JSJ     |
|              | L) Attach Front & Rear<br>Sight Assemblies                        |                    | 11/7/88   | RW      |
|              | M) Iron Sight Alignment                                           |                    | 11/7/88   | RW      |
|              | N) Detach Front & Rear<br>Sights & place in<br>numbered container |                    | 11/7/88   | RW      |
|              | O) Attach Scope to Rifle                                          |                    | 11/8/88   | RW      |
|              | P) Detach & Attach Scope<br>20 times                              |                    | 8 NOV 88  | JSJ     |
| 640          | Gallery Target & Test                                             | 76 R 74 L          | 11/10/88  | DH      |
|              | A) Optical Clarity of Scope                                       |                    | 11/10/88  | DH      |
| 645          | Inspect for Live Ammo                                             |                    | 11/10/88  | DH      |
| 655          | Final Inspection<br>A) Headspace                                  |                    | 29 NOV 88 | JSJ     |
|              | B) Trigger Pull                                                   |                    | 29 NOV 88 | JSJ     |
|              | C) Function                                                       |                    | 29 NOV 88 | JSJ     |
| 660          | Pack                                                              |                    | 15 Dec 88 | JSJ     |

SWS TRIGGER PULL TEST

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

SERIAL NO. C6225323  
DATE 3/10/88  
TESTER J.H. + M.S.

|         | 2.50#<br>INITIAL | 2.50# AFTER<br>50 CYCLES | FINAL TEST &<br>TO RESET 2.50# |       | COMMENTS                                                               |
|---------|------------------|--------------------------|--------------------------------|-------|------------------------------------------------------------------------|
| PULL #1 | 2.55             | 2.42                     | 2.58                           | 2.72  | MIN. SETTING,<br>NO AVG. OF 5<br>READINGS ACCEPT-<br>ABLE LESS THAN 2# |
| PULL #2 | 2.50             | 2.46                     | 2.59                           | 2.69  |                                                                        |
| PULL #3 | 2.56             | 2.43                     | 2.60                           | 2.77  |                                                                        |
| PULL #4 | 2.52             | 2.42                     | 2.60                           | 2.76  |                                                                        |
| PULL #5 | 2.54             | 2.40                     | 2.58                           | 2.81  |                                                                        |
| TOTAL   | 12.67            | 12.13                    | 12.95                          | 13.75 |                                                                        |
| AVG.    | 2.534            | 2.426                    | 2.59                           | 2.75  |                                                                        |

|         | 3.00#<br>INITIAL | 3.00# AFTER<br>20 CYCLES |  | COMMENTS |
|---------|------------------|--------------------------|--|----------|
| PULL #1 | 3.12             | 3.04                     |  |          |
| PULL #2 | 3.07             | 3.12                     |  |          |
| PULL #3 | 3.08             | 3.13                     |  |          |
| PULL #4 | 3.06             | 3.14                     |  |          |
| PULL #5 | 3.14             | 3.11                     |  |          |
| TOTAL   | 15.47            | 15.54                    |  |          |
| AVG.    | 3.094            | 3.108                    |  |          |

|         | 4.00#<br>INITIAL | 4.00# AFTER<br>20 CYCLES | MAX SETTING<br>GREATER THAN 4# | RESET TO 4# FOR<br>TARGET & ACCURACY |
|---------|------------------|--------------------------|--------------------------------|--------------------------------------|
| PULL #1 | 4.17             | 4.11                     |                                | 4.11                                 |
| PULL #2 | 4.15             | 4.15                     |                                | 4.16                                 |
| PULL #3 | 4.06             | 4.09                     |                                | 4.12                                 |
| PULL #4 | 4.15             | 4.19                     |                                | 4.13                                 |
| PULL #5 | 4.15             | 4.17                     |                                | 4.12                                 |
| TOTAL   | 20.68            | 20.71                    |                                | 20.64                                |
| AVG.    | 4.136            | 4.142                    |                                | 4.148                                |

CENTROIDAL DISTANCE CALCULATIONS  
FOR RIFLE # 06225323

CENTROIDAL DISTANCES

|      |   |         |
|------|---|---------|
| 0 TO | 1 | 1.4981  |
| 1 TO | 2 | .73112  |
| 1 TO | 3 | 1.09076 |
| 1 TO | 4 | .726571 |
| 1 TO | 5 | .955704 |

1  
2 45  
3 + <----POA

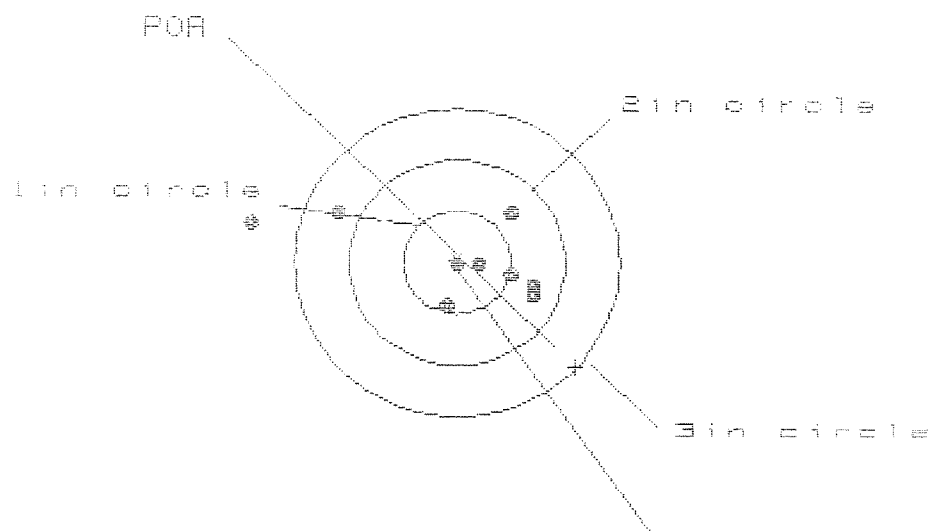
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.685  
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .4978  
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .846776  
THE AMR FOR THIS RIFLE IS: .976

18 Nov 1988

FILE:/PATTERNING/CENTERFIRE\_PATT/08225923

# CENTERFIRE PATTERNS

# 1



# OF SHOTS = 10

# IN CIR

1 in = 4

2 in = 6

3 in = 0

HO = 2.630

VO = .889

GO = 2.704

CENTROID #

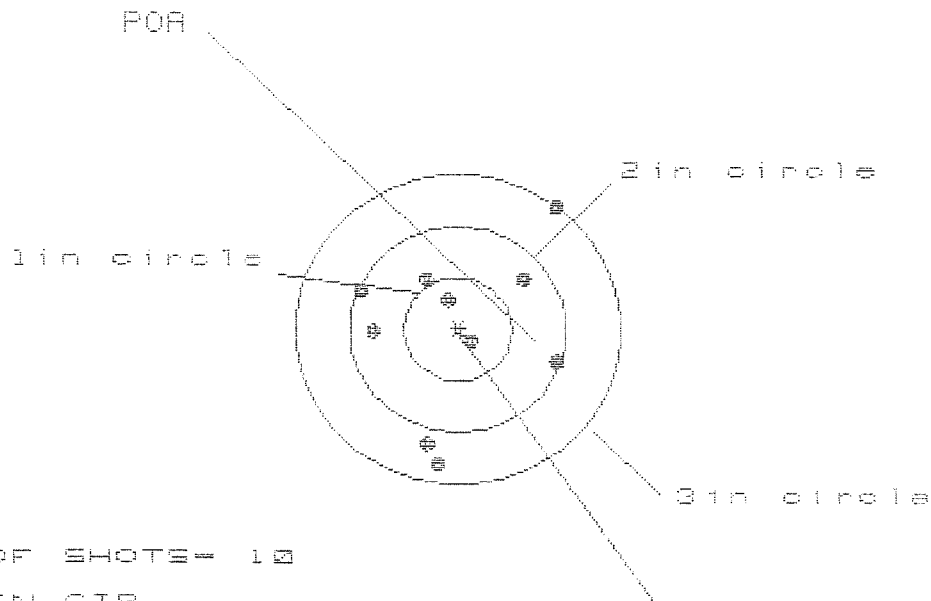
| PATTERN #                   | : | 1      | 2      | 3      |
|-----------------------------|---|--------|--------|--------|
| SHOTS (BEST OF)             | : | 10     | 9      | 8      |
| MAXIMUM X                   | : | .697   | .482   | .315   |
| MINIMUM X                   | : | -1.933 | -1.339 | -1.501 |
| MAXIMUM Y                   | : | .520   | .564   | .633   |
| MINIMUM Y                   | : | -.369  | -.325  | -.256  |
| CENTROID X                  | : | -1.100 | -.885  | -.718  |
| CENTROID Y                  | : | 1.017  | .973   | .904   |
| POA TO CENTROID in.         | : | 1.498  | 1.316  | 1.154  |
| MIN RADIUS                  | : | .041   | .029   | .081   |
| MEAN RADIUS                 | : | .723   | .512   | .363   |
| MAX RADIUS                  | : | 1.973  | 1.450  | .644   |
| HORIZONTAL SPREAD           | : | 2.630  | 1.821  | .816   |
| VERTICAL SPREAD             | : | .889   | .889   | .889   |
| EXTREME SPREAD              | : | 2.704  | 1.988  | 1.083  |
| NUMBER IN ONE INCH CIRCLE   | = | 4      |        |        |
| NUMBER IN TWO INCH CIRCLE   | = | 6      |        |        |
| NUMBER IN THREE INCH CIRCLE | = | 9      |        |        |



10 Nov 1980

FILE:/PATTERNING/CENTERFIRE\_PATT/C8225323

# CENTERFIRE PATTERNS # 2



# OF SHOTS= 10

# IN CIR

1in = 2

2in = 7

3in = 10

RS= 1.825

VS= 2.497

GS= 2.715

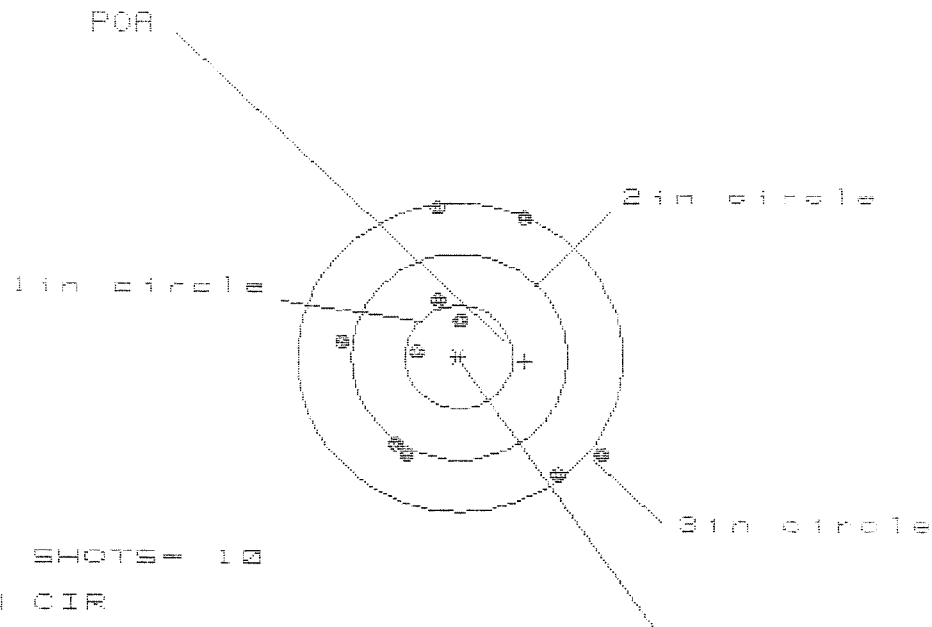
CENTROID #

| PATTERN #                     | 2      |        |        |
|-------------------------------|--------|--------|--------|
| SHOTS (BEST OF)               | 10     | 9      | 8      |
| MAXIMUM X                     | .921   | 1.022  | 1.014  |
| MINIMUM X                     | -.984  | -.803  | -.811  |
| MAXIMUM Y                     | 1.178  | .654   | .584   |
| MINIMUM Y                     | -1.327 | -1.197 | -1.105 |
| CENTROID X                    | -.910  | -1.011 | -1.003 |
| CENTROID Y                    | .311   | .181   | .331   |
| POR TO CENTROID in.           | .962   | 1.027  | 1.056  |
| MIN RADIUS                    | .151   | .170   | .223   |
| MEAN RADIUS                   | .845   | .779   | .697   |
| MAX RADIUS                    | 1.479  | 1.199  | 1.128  |
| HORIZONTAL SPREAD             | 1.825  | 1.825  | 1.825  |
| VERTICAL SPREAD               | 2.497  | 1.851  | 1.689  |
| EXTREME SPREAD                | 2.715  | 2.012  | 1.958  |
| NUMBER IN ONE INCH CIRCLE =   |        | 2      |        |
| NUMBER IN TWO INCH CIRCLE =   |        | 7      |        |
| NUMBER IN THREE INCH CIRCLE = |        | 10     |        |

18 Nov 1988

FILE:/PATTERNING/CENTERFIRE\_PATT/06225323

# CENTERFIRE PATTERNS # 3



# OF SHOTS= 10

# IN CIR

1in = 2

2in = 3

3in = 8

HS= 2.464

VS= 2.592

GS= 2.859

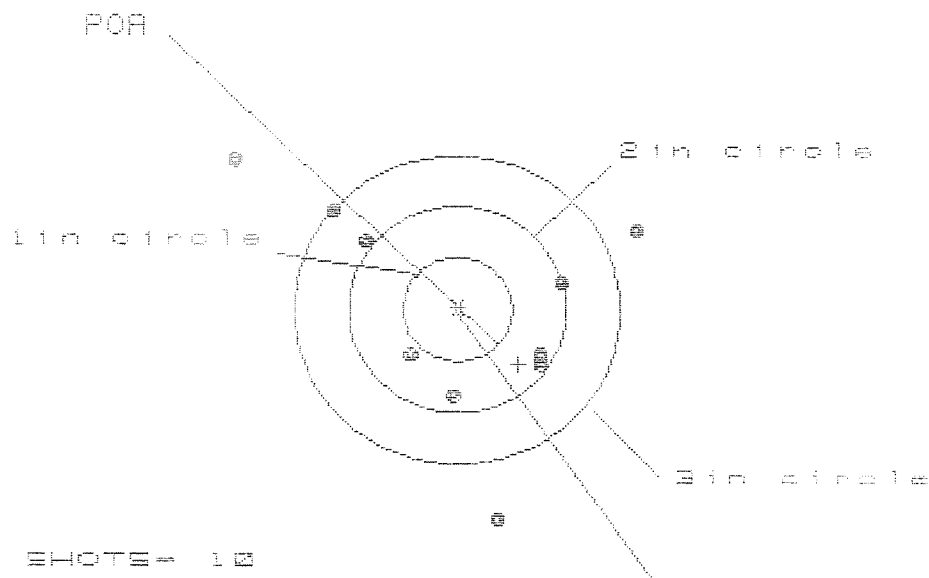
PATTERN # : 3

|                             |   |        |        |        |
|-----------------------------|---|--------|--------|--------|
| SHOTS (BEST OF)             | : | 10     | 9      | 8      |
| MAXIMUM X                   | : | 1.350  | 1.089  | 1.138  |
| MINIMUM X                   | : | -1.114 | -.964  | -.865  |
| MAXIMUM Y                   | : | 1.428  | 1.319  | 1.478  |
| MINIMUM Y                   | : | -1.164 | -1.273 | -1.115 |
| CENTROID X                  | : | -.689  | -.759  | -.858  |
| CENTROID Y                  | : | .043   | .152   | -.006  |
| POA TO CENTROID in.         | : | .611   | .774   | .858   |
| MIN RADIUS                  | : | .367   | .264   | .220   |
| MEAN RADIUS                 | : | 1.069  | .956   | .835   |
| MAX RADIUS                  | : | 1.666  | 1.675  | 1.629  |
| HORIZONTAL SPREAD           | : | 2.464  | 2.053  | 2.053  |
| VERTICAL SPREAD             | : | 2.592  | 2.592  | 2.592  |
| EXTREME SPREAD              | : | 2.859  | 2.830  | 2.830  |
| NUMBER IN ONE INCH CIRCLE   | = |        | 2      |        |
| NUMBER IN TWO INCH CIRCLE   | = |        | 3      |        |
| NUMBER IN THREE INCH CIRCLE | = |        | 8      |        |

18 Nov 1988

FILE:/PATTERNING/CENTERFIRE\_PATT/08285323

# CENTERFIRE PATTERNS # 4



# OF SHOTS = 10

# IN CIR

1 in = 0

2 in = 5

3 in = 5

H0 = 3.710

V0 = 3.468

G0 = 4.224

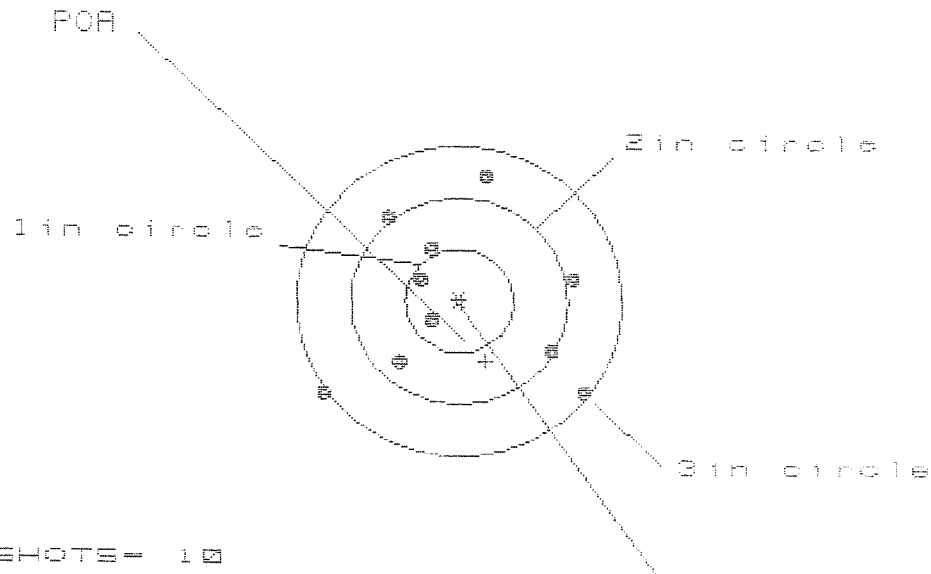
CENTROID +

|                             |   |        |        |        |
|-----------------------------|---|--------|--------|--------|
| PATTERN #                   | : | 4      |        |        |
| SHOTS (BEST OF)             | : | 10     | 9      | 8      |
| MAXIMUM X                   | : | 1.677  | 1.451  | 1.476  |
| MINIMUM X                   | : | -2.033 | -1.365 | -1.346 |
| MAXIMUM Y                   | : | 1.480  | 1.141  | .913   |
| MINIMUM Y                   | : | -1.988 | -1.824 | -1.894 |
| CENTROID X                  | : | -.559  | -.333  | -.352  |
| CENTROID Y                  | : | .532   | .368   | .596   |
| POA TO CENTROID in.         | : | .772   | .496   | .692   |
| MIN RADIUS                  | : | .585   | .547   | .687   |
| MEAN RADIUS                 | : | 1.309  | 1.123  | 1.054  |
| MAX RADIUS                  | : | 2.515  | 1.830  | 1.645  |
| HORIZONTAL SPREAD           | : | 3.710  | 2.816  | 2.816  |
| VERTICAL SPREAD             | : | 3.468  | 2.965  | 1.807  |
| EXTREME SPREAD              | : | 4.224  | 3.331  | 2.821  |
| NUMBER IN ONE INCH CIRCLE   | = |        | 0      |        |
| NUMBER IN TWO INCH CIRCLE   | = |        | 5      |        |
| NUMBER IN THREE INCH CIRCLE | = |        | 6      |        |

10 May 1988

FILE:/PATTERNING/CENTERFIRE\_PATT/08225323

# CENTERFIRE PATTERNS # 5



# OF SHOTS- 10

# IN CIR

1 in = 2

2 in = 5

3 in = 8

HS= 2.462

VS= 2.093

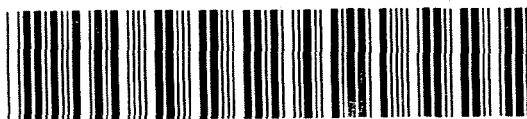
GS= 2.607

CENTROID \*

| PATTERN #                     | 5      |       |       |
|-------------------------------|--------|-------|-------|
| SHOTS (BEST OF)               | 10     | 9     | 8     |
| MAXIMUM X                     | 1.170  | 1.026 | 1.073 |
| MINIMUM X                     | -1.292 | -.788 | -.659 |
| MAXIMUM Y                     | 1.197  | 1.097 | .980  |
| MINIMUM Y                     | -.896  | -.937 | -.762 |
| CENTROID X                    | -.247  | -.103 | -.232 |
| CENTROID Y                    | .586   | .686  | .803  |
| POA TO CENTROID in.           | .636   | .693  | .835  |
| MIN RADIUS                    | .259   | .434  | .373  |
| MEAN RADIUS                   | .934   | .872  | .772  |
| MAX RADIUS                    | 1.573  | 1.389 | 1.074 |
| HORIZONTAL SPREAD             | 2.462  | 1.814 | 1.732 |
| VERTICAL SPREAD               | 2.093  | 2.034 | 1.742 |
| EXTREME SPREAD                | 2.607  | 2.425 | 1.923 |
| NUMBER IN ONE INCH CIRCLE =   |        | 2     |       |
| NUMBER IN TWO INCH CIRCLE =   |        | 5     |       |
| NUMBER IN THREE INCH CIRCLE = |        | 9     |       |

Serial Number: C6225323

BBL 96003



RE00014570

# Final Inspection

S.N. C6225323 DATE REC'D: 9-26-00 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

☒ INON SIGHTS

☒ DEPLOYMENT KIT

TRIGGER

☒ SAFETY OPERATION

☒ SET

Comments:

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

[illegible]

Remington Test Lab, Ilion, N.Y.

Centroidal distance calculations for Rifle # c6225323  
25 Oct 2000

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0732  
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1208  
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .141248

THE AMR FOR THIS RIFLE IS: .9834

### CENTROIDAL DISTANCES

|        |         |
|--------|---------|
| 0 TO 1 | .388209 |
| 1 TO 2 | .750479 |
| 1 TO 3 | .454018 |
| 1 TO 4 | .569619 |
| 1 TO 5 | .900374 |

1  
+3 <----POA  
4 2 5

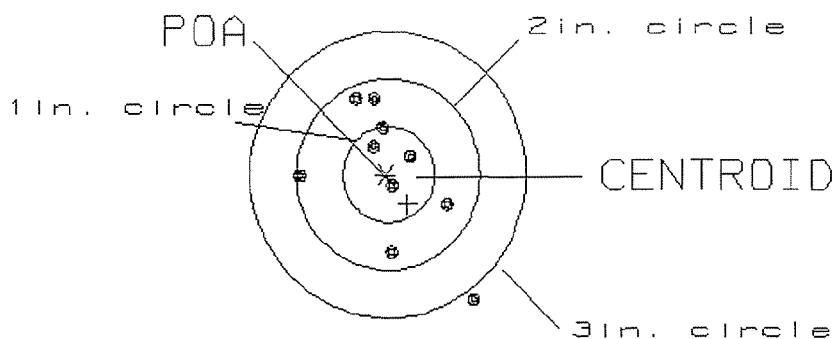


PATTERN #: 1  
 POA TO CENTROID: .388  
 MIN RADIUS : .065  
 MEAN RADIUS : .692  
 MAX RADIUS : 1.572  
 CENTROID X : -.235  
 CENTROID Y : .309

25 Oct 2000

FILE:/Hpbasic/Accuracy/Patterning/Centerfire\_Patt/c6225323.1

# CENTERFIRE PATTERN # 1



# OF SHOTS= 10

# IN CIRCLE

HS= 1.94  
 VS= 2.05  
 GS= 2.42

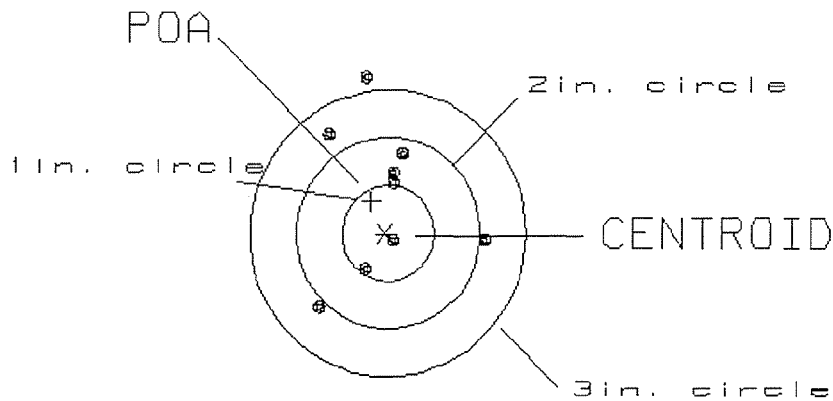
4  
 6  
 9

PATTERN #: 2  
 POA TO CENTROID: .367  
 MIN RADIUS : .080  
 MEAN RADIUS : 1.090  
 MAX RADIUS : 3.351  
 CENTROID X : .152  
 CENTROID Y : -.334

25 Oct 2000

FILE:/Hpbasic/Accuracy/Patterning/Centerfire\_Patt/c6225323.1

# CENTERFIRE PATTERN # 2



# OF SHOTS= 10

# IN CIRCLE

HS= 1.80

2

VS= 4.91

5

GS= 4.97

8

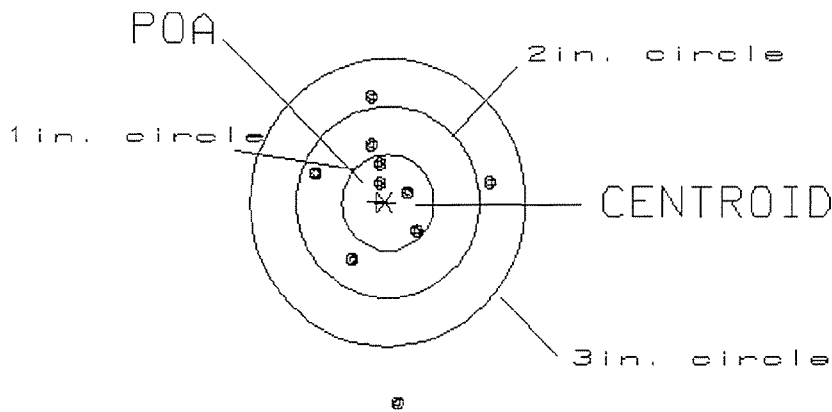
PATTERN #: 3

POA TO CENTROID: .091  
 MIN RADIUS : .262  
 MEAN RADIUS : .803  
 MAX RADIUS : 2.144  
 CENTROID X : .091  
 CENTROID Y : -.007

25 Oct 2000

FILE:/Hpbasic/Accuracy/Patterning/Centerfire\_Patt/c6225323.1

# CENTERFIRE PATTERN # 3



# OF SHOTS= 10

# IN CIRCLE

HS= 1.92

4

VS= 3.27

7

GS= 3.28

9

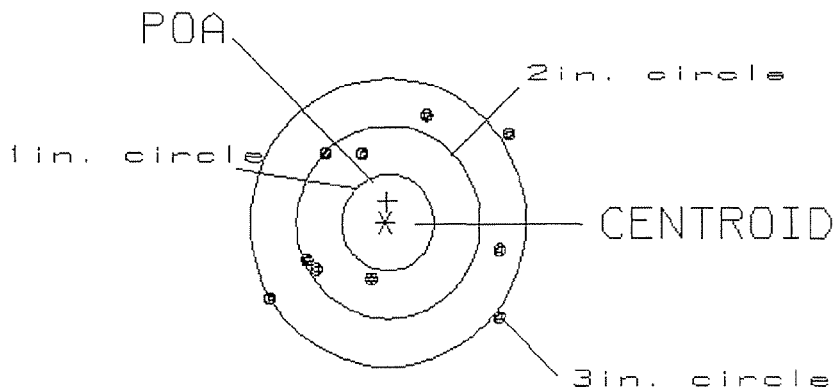
PATTERN #: ☐ 4 ☐

POA TO CENTROID: .217  
 MIN RADIUS : .603  
 MEAN RADIUS : 1.157  
 MAX RADIUS : 1.633  
 CENTROID X : -.014  
 CENTROID Y : -.216

25 Oct 2000

FILE:/Hpbasic/Accuracy/Patterning/Centerfire\_Patt/cb225323.1

# CENTERFIRE PATTERN # 4



# OF SHOTS= 10

# IN CIRCLE

HS= 2.65

0

VS= 2.14

4

GS= 3.19

7

PATTERN #: ☐ 5 ☐

POA TO CENTROID: .515

MIN RADIUS : .049

MEAN RADIUS : 1.175

MAX RADIUS : 2.533

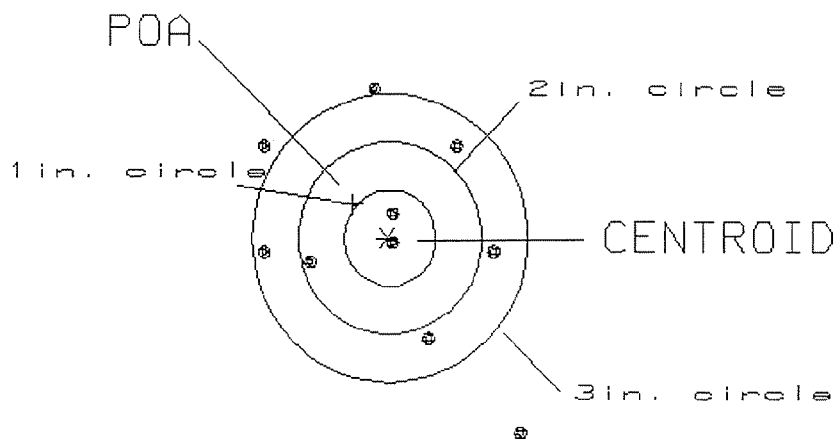
CENTROID X : .372

CENTROID Y : -.356

25 Oct 2000

FILE:/Hpbasic/Accuracy/Patterning/Centerfire\_Patt/c6225323.1

# CENTERFIRE PATTERN # 5



# OF SHOTS= 10

# IN CIRCLE

HS= 2.83

2

VS= 3.61

3

GS= 4.14

7

Remington Test Lab, Ilion, N.Y.

Centroidal distance calculations for Rifle # c6225323  
23 Oct 2000

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.372  
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.2046  
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .424553

THE AMR FOR THIS RIFLE IS: 1.364

# CENTROIDAL DISTANCES

|      |   |         |
|------|---|---------|
| Ø TO | 1 | .374995 |
| 1 TO | 2 | .148385 |
| 1 TO | 3 | .495601 |
| 1 TO | 4 | .568075 |
| 1 TO | 5 | .490111 |

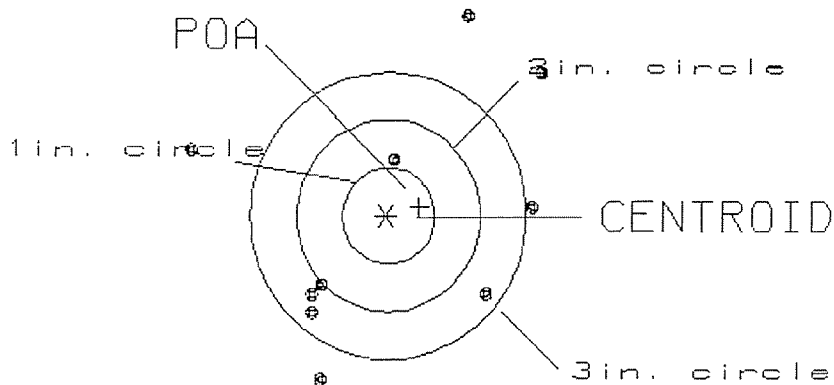
3  
2 1 + <----POA  
5  
4

PATTERN #: 1  
 POA TO CENTROID: .375  
 MIN RADIUS : .603  
 MEAN RADIUS : 1.565  
 MAX RADIUS : 2.294  
 CENTROID X : -.365  
 CENTROID Y : -.086

23 Oct 2000

FILE:/Hpbasic/Accuracy/Patterning/Centerfire\_Patt/c6225323

# CENTERFIRE PATTERN # 1



# OF SHOTS= 10

# IN CIRCLE

HS= 3.81  
 VS= 3.81  
 GS= 4.16

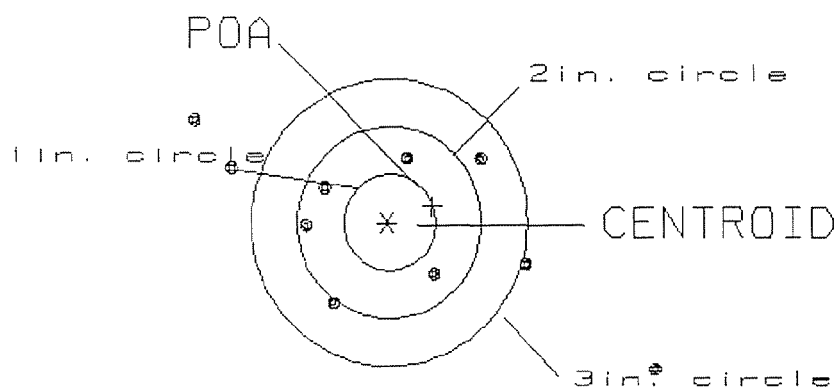
0  
 1  
 5

PATTERN #: 2  
 POA TO CENTROID: .516  
 MIN RADIUS : .691  
 MEAN RADIUS : 1.429  
 MAX RADIUS : 3.287  
 CENTROID X : -.488  
 CENTROID Y : -.169

23 Oct 2000

FILE:/Hpbasic/Accuracy/Patterning/Centerfire\_Patt/c6225323

# CENTERFIRE PATTERN # 2



# OF SHOTS= 10

# IN CIRCLE

HS= 4.99

0

VS= 2.61

4

GS= 5.63

6

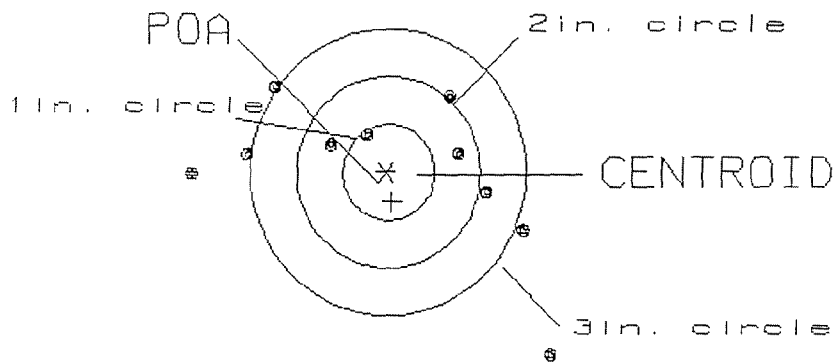


PATTERN #: 3  
 POA TO CENTROID: .317  
 MIN RADIUS : .439  
 MEAN RADIUS : 1.346  
 MAX RADIUS : 2.576  
 CENTROID X : -.067  
 CENTROID Y : .310

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# CENTERFIRE PATTERN # 3



# OF SHOTS= 10

# IN CIRCLE

HS= 3.81  
 VS= 2.83  
 GS= 4.27

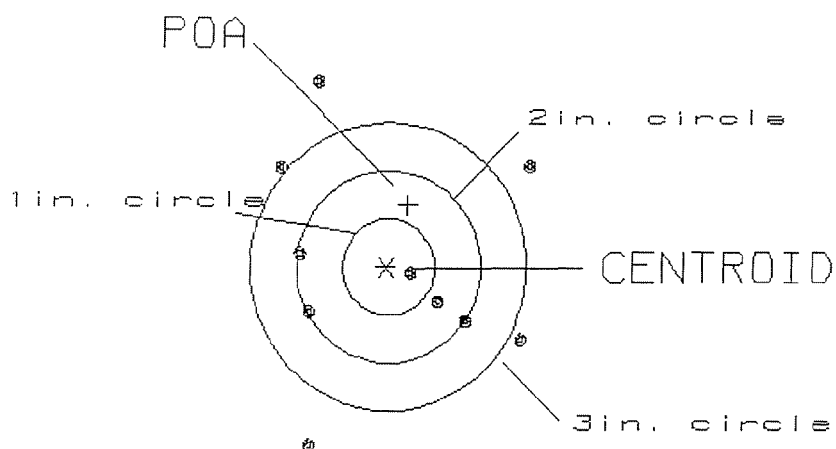
1  
 3  
 5

PATTERN #: 4  
 POA TO CENTROID: .681  
 MIN RADIUS : .275  
 MEAN RADIUS : 1.305  
 MAX RADIUS : 2.064  
 CENTROID X : -.235  
 CENTROID Y : -.639

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# CENTERFIRE PATTERN # 4



# OF SHOTS= 10

# IN CIRCLE

HS= 2.72

1

VS= 3.60

4

GS= 3.80

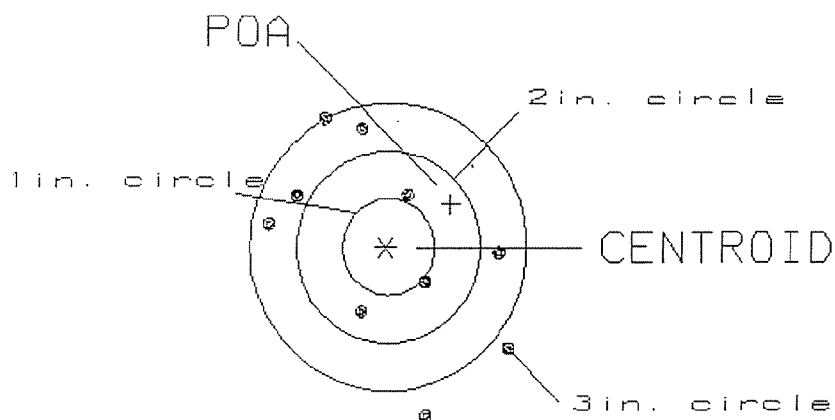
5

PATTERN #: 5  
 POA TO CENTROID: .830  
 MIN RADIUS : .512  
 MEAN RADIUS : 1.177  
 MAX RADIUS : 1.786  
 CENTROID X : -.705  
 CENTROID Y : -.439

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# CENTERFIRE PATTERN # 5



# OF SHOTS= 10

# IN CIRCLE

HS= 2.59

0

VS= 3.04

3

GS= 3.23

8