

C6594575

MODEL 700TM M24

Model **SMS** TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



Arms Services Repair & Estimate System

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

Repair Inquiry

Repair Number: **RE00107959** Serial: C6594576 Model M24 SWS Center Fire
 Verify Repair: **High Priority** Caliber: 7.62 NATO Produced: 12/19/1990 Repairman: Status: Closed 2/13/2006 9:28:23 AM

Address Information

Customer: Received From Return To: Received From

Name: C C0 3/3 SFG (A) C C0 3/3 SFG (A)

Address 1: BLDG 1351 PATRICK LYNCH BLDG 1351 PATRICK LYNCH

Address 2: KUWAIT STREET PO Box: KUWAIT STREET PO Box:

City: FORT BRAGG FORT BRAGG

State: NC Zip Code: 28310 Country: US State: NC Zip Code: 28310 Country: US

FFL: ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐

Contact / Condition Problems Estimate History / Status Shipping / Billing

Contact Information

Phone: 910 286 1188

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

magletj 2/13/2006 10:32 AM CAPS NUM INS SCRL

start 2 Microsoft Offi... Arms Services R... 3 Internet Expl... Part Search by M... 10:32 AM

Serial Number: **C6594576**

Model: **M24 SWS**



RE00107959

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6594576.__0
FILE DATE AND TIME: 02/23/2006 05:09

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.132
The Average Y Centroid of the Five Target Set:	0.245
The Average Point of Impact of the Five Target Set:	0.278
The Average Mean Radius of the Five Target Set:	0.916
The Distance from POA to Centroid Target #1:	0.714
The Distance from Centroid Target #2 to Centroid Target #1:	0.755
The Distance from Centroid Target #3 to Centroid Target #1:	0.249
The Distance from Centroid Target #4 to Centroid Target #1:	0.630
The Distance from Centroid Target #5 to Centroid Target #1:	0.679

SERIAL NUMBER: C6594576. __0

TARGET NUMBER: 1

FILE DATE: 02/23/2006

FILE TIME: 05:09

X CENTROID: -0.406

Y CENTROID: 0.588

POA TO CENTROID: 0.714

HORZ SPREAD: 2.183

VERT SPREAD: 2.967

GROUP SPREAD: 3.300

MIN RADIUS: 0.239

MAX RADIUS: 1.674

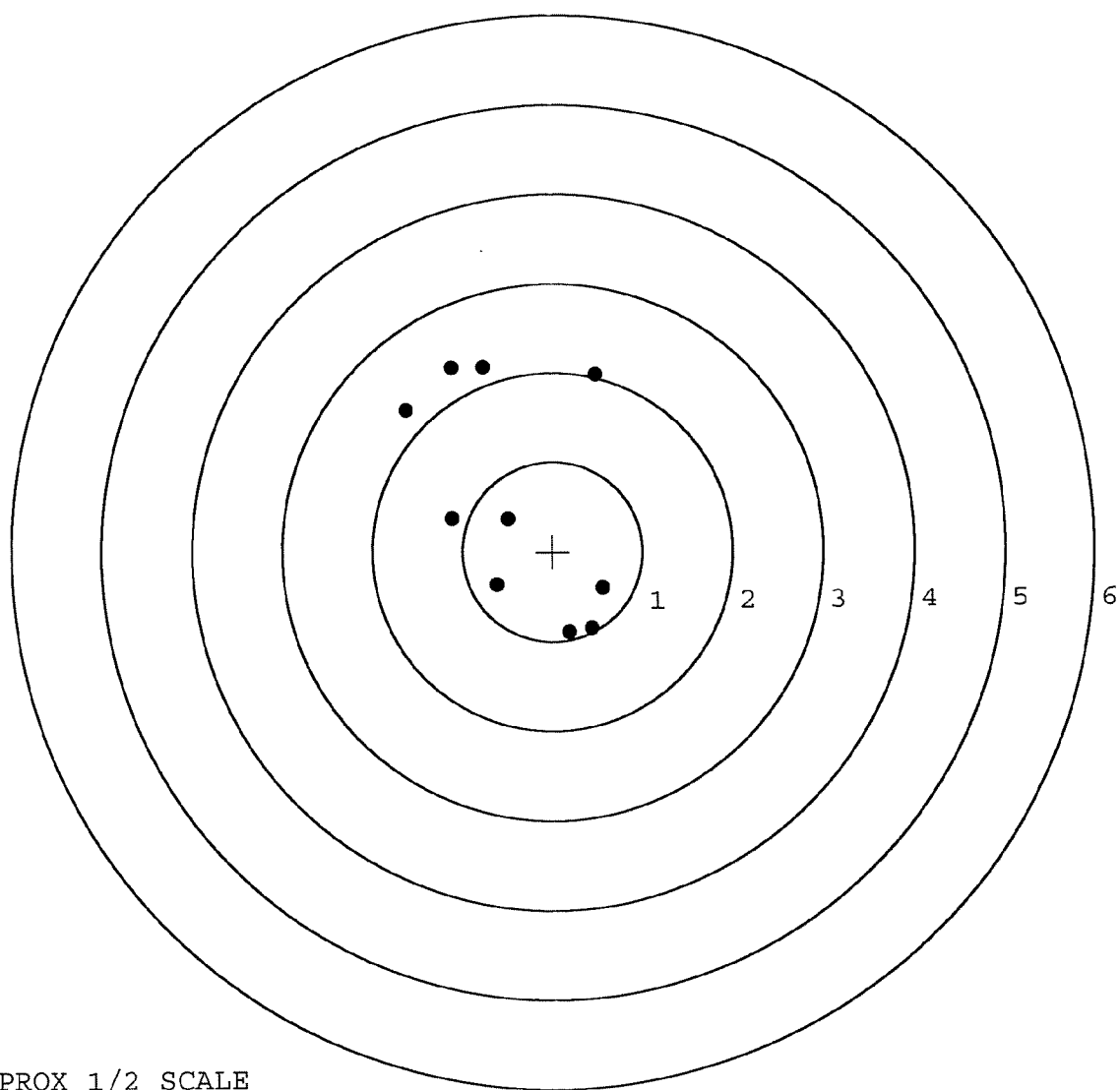
MEAN RADIUS: 1.300

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 3

in 3 IN DIAMETER: 4

POINT#	X	Y
1:	0.438	-0.858
2:	0.183	-0.901
3:	0.557	-0.412
4:	-0.621	-0.369
5:	-0.494	0.365
6:	-1.115	0.369
7:	-1.626	1.586
8:	-1.115	2.054
9:	-0.763	2.066
10:	0.493	1.976



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6594576. __0

TARGET NUMBER: 2

FILE DATE: 02/23/2006

FILE TIME: 05:09

X CENTROID: -0.050

Y CENTROID: -0.079

POA TO CENTROID: 0.093

HORZ SPREAD: 2.796

VERT SPREAD: 2.094

GROUP SPREAD: 2.820

MIN RADIUS: 0.047

MAX RADIUS: 1.816

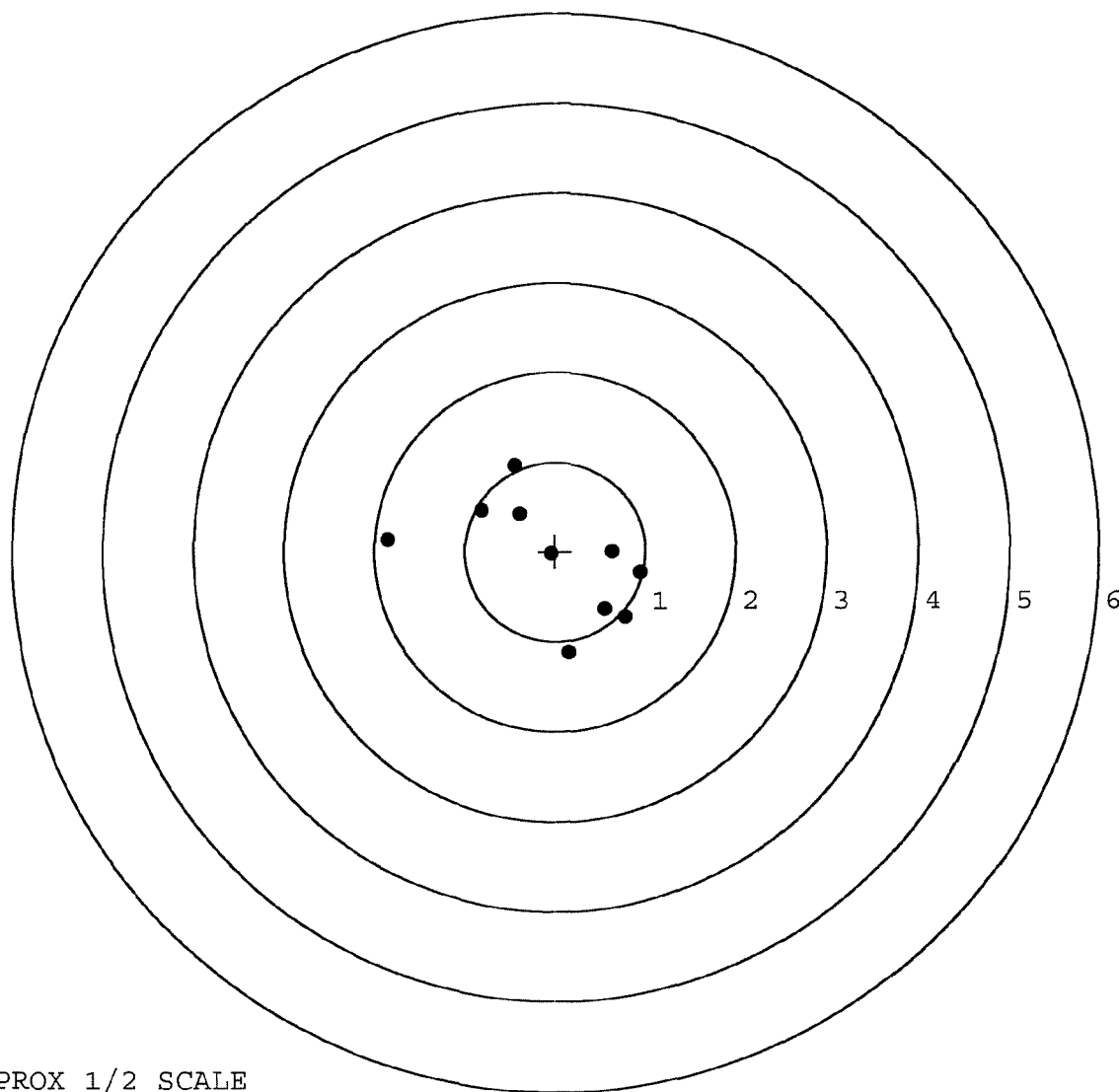
MEAN RADIUS: 0.917

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 5

in 3 IN DIAMETER: 9

POINT#	X	Y
1:	0.154	-1.131
2:	0.779	-0.727
3:	0.548	-0.642
4:	0.942	-0.239
5:	0.635	0.005
6:	-0.046	-0.032
7:	-0.397	0.423
8:	-0.447	0.963
9:	-0.819	0.464
10:	-1.854	0.130



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6594576. __0

TARGET NUMBER: 3

FILE DATE: 02/23/2006

FILE TIME: 05:09

X CENTROID: -0.157

Y CENTROID: 0.586

POA TO CENTROID: 0.607

HORZ SPREAD: 1.807

VERT SPREAD: 4.238

GROUP SPREAD: 4.335

MIN RADIUS: 0.214

MAX RADIUS: 2.926

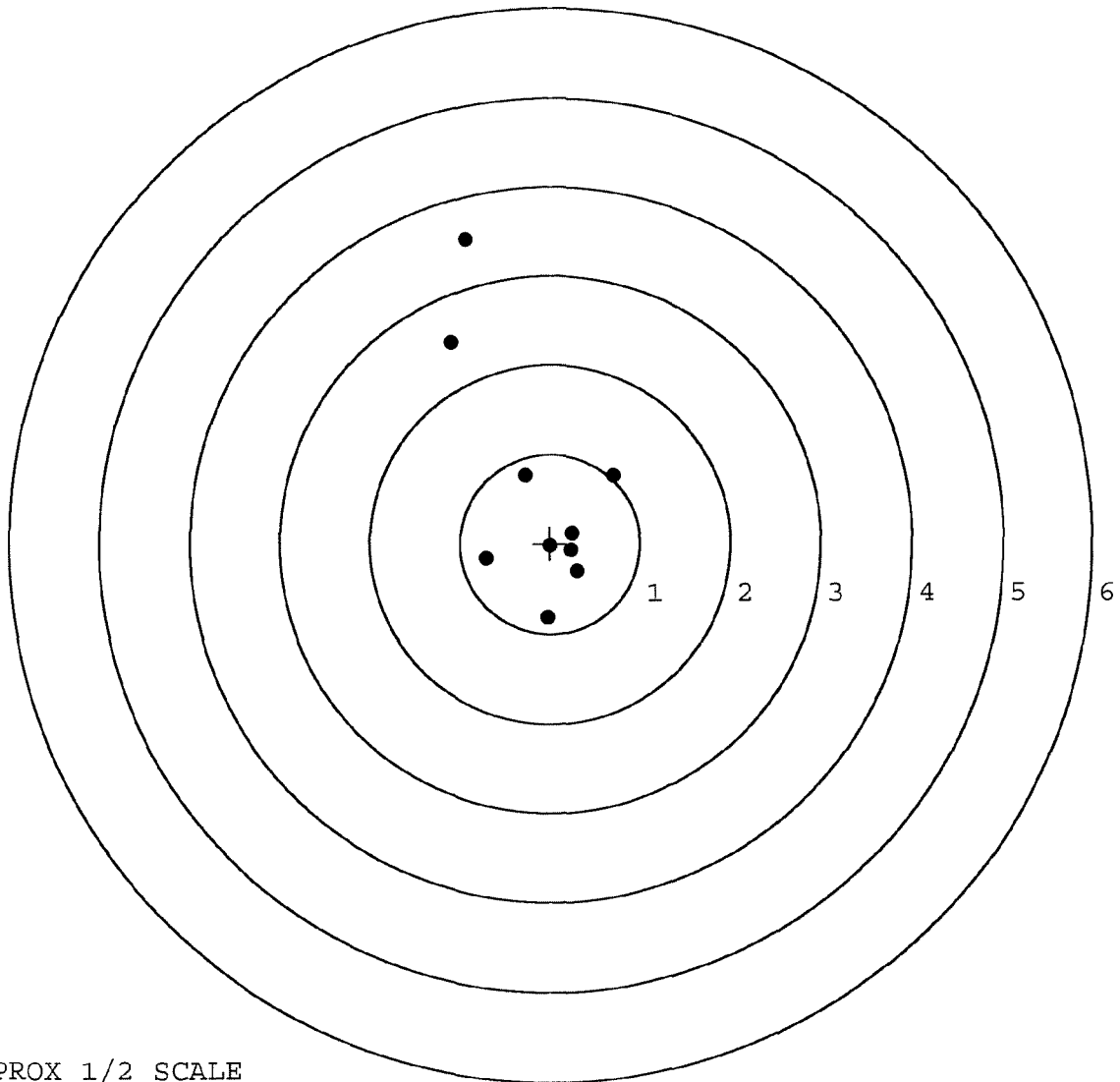
MEAN RADIUS: 1.132

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 8

POINT#	X	Y
1:	-0.030	-0.833
2:	-0.709	-0.170
3:	-0.277	0.764
4:	0.703	0.764
5:	0.246	0.116
6:	0.003	-0.031
7:	0.301	-0.310
8:	0.235	-0.081
9:	-1.104	2.241
10:	-0.942	3.405



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6594576. 0

TARGET NUMBER: 4

FILE DATE: 02/23/2006

FILE TIME: 05:09

POINT#	X	Y
1:	1.077	0.855
2:	0.091	1.111
3:	0.732	-0.269
4:	-0.374	0.466
5:	-0.920	0.186
6:	0.194	0.158
7:	-0.136	0.009
8:	-0.273	-0.185
9:	0.084	-0.357
10:	-0.097	-0.565

X CENTROID: 0.038

Y CENTROID: 0.141

POA TO CENTROID: 0.146

HORZ SPREAD: 1.997

VERT SPREAD: 1.676

GROUP SPREAD: 2.106

MIN RADIUS: 0.157

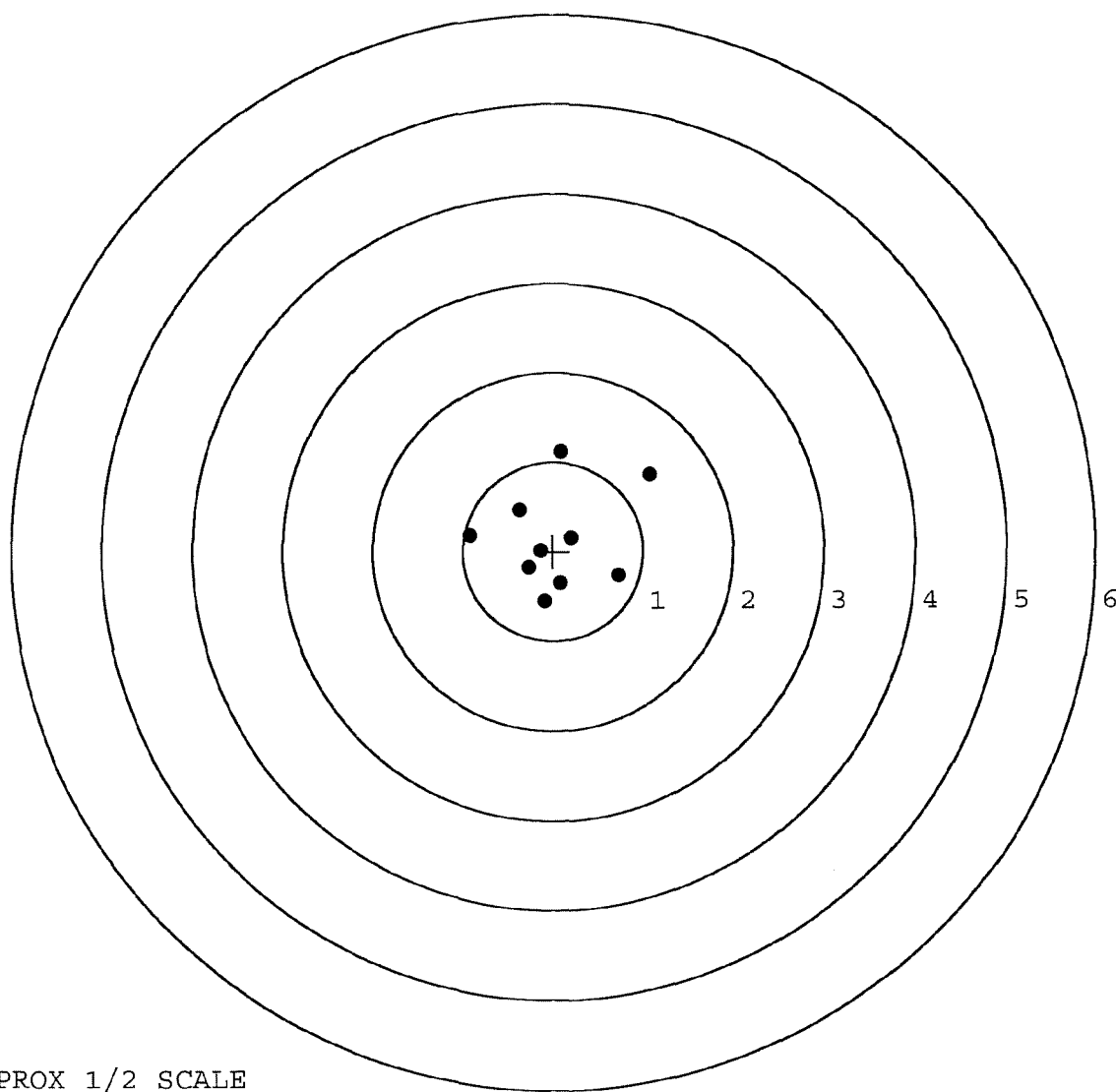
MAX RADIUS: 1.261

MEAN RADIUS: 0.657

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6594576. __0

TARGET NUMBER: 5

FILE DATE: 02/23/2006

FILE TIME: 05:09

POINT#	X	Y
1:	0.729	-0.517
2:	0.161	-0.472
3:	0.195	-0.146
4:	-0.268	-0.326
5:	-0.453	-0.885
6:	0.024	0.295
7:	-0.453	0.178
8:	-0.192	0.423
9:	-0.301	0.575
10:	-0.255	0.784

X CENTROID: -0.081

Y CENTROID: -0.009

POA TO CENTROID: 0.082

HORZ SPREAD: 1.182

VERT SPREAD: 1.669

GROUP SPREAD: 1.631

MIN RADIUS: 0.308

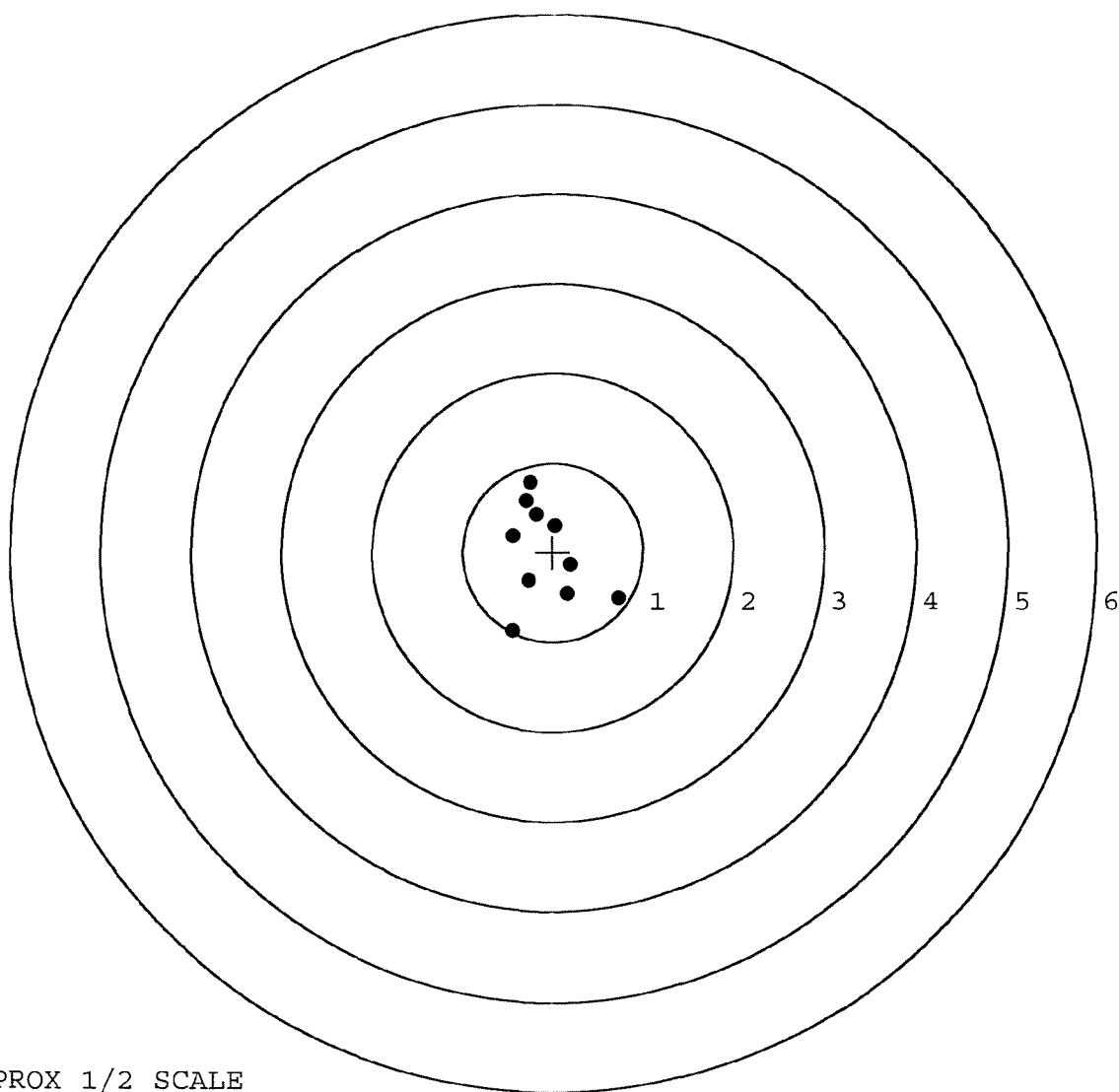
MAX RADIUS: 0.956

MEAN RADIUS: 0.573

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

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

R & E NUMBER	107959			
SERIAL NUMBER	C6594576			
LOG-IN DATE	2-13-06			
OPERATION #	OPERATION NAME		DATE	INITIAL
500	DIS-ASSEMBLE GUN		2-13-06	RTZ
505	RE-BARREL		2-14-06	RTZ
560	ASSEMBLE		2-14-06	RTZ
600	PROOF	MAGNA-FLUX INSPECTED	2-14-06	TRW
605	CHECK HEADSPACE		2-14-06	TRW
610	DIS-ASSEMBLE GUN	FEB 16 2006	2-15-06	RTZ
612	MAGNAFLUX	OPERATOR <i>Wms</i>	2-16-06	<i>Wms</i>
510	DRILL AND TAP		2-15-06	TRW
615	ROLLMARK CALIBER		2-15-06	CW
618	ROTO-BLAST		2-16-06	LB
620	APPLY COATINGS		2-21-06	RTZ
625	FINAL ASSEMBLY		2-22-06	RTZ
640	FUNCTION TEST AND	PASS FAIL	2-23-06	TRW
650	TARGET	PASS FAIL		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION	2-23-06	<i>SH</i>
670	FINAL INSPECTION		2-27-06	<i>Ac</i>
	A) HEADSPACE	PASS FAIL	2-27-06	<i>Ac</i>
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS		N/A
680	F) SAFETY ON FORCE	2 LBS MIN 10 LBS	41 lbs 41 lbs 41 lbs	<i>A</i>
	G) SAFETY OFF FORCE	2 LBS MIN	31 lbs 31 lbs 31 lbs	<i>Ac</i>
	I) FIRING PIN INDENT	.020	.021 .021 .021	<i>Ac</i>
690	PACK		33-06	<i>SH</i>

Arms Services Repair & Estimate System

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

Repair Inquiry

Repair Number: **RE00009454** Serial: **C6594576** Model **700** Center Fire Caliber: **7.62 NATO M-24 (SWS)** Repairman:
 Verify Repair Status: **New 5/18/00 2:47:16 PM**

Address Information

Customer: ☒ Received From Return To: ☐ Received From
 Name: **HSC 3RD BN, 3RD SFG (A)** **HSC 3RD BN, 3RD SFG (A)**
 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**
 FFL:

Contact / Condition **Problems** **Estimate** **History / Status** **Shipping / Billing**

Contact Information **Received Condition** **Accessories Received**

Phone: **Poor**
 Fax: Condition Notes:
 Email: CSR Notes:
 Comments:

Code	Desc	Qty
A007	With Stud	2
A008	With Swivel	2
A010	Hard Case	1
A017	Scope Base	1

Repair Search **Refresh** **Close**

naglejt 5/18/00 3:04 PM CAPS NUM INS SCRL

Start Inb... Micr... SA... Nag... Audit R&... Ar... RE... Prin... 3:04 PM

Serial Number: **C6594576**

Model: **700**

96003 - BBL



RE00009454

Remington Test Lab, Ilion, N.Y.

Centroidal distance calculations for Rifle # c6594576
8 Sep 2000

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0098
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .218
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .21822

THE AMR FOR THIS RIFLE IS: 1.262

CENTROIDAL DISTANCES

0 TO 1	.127424
1 TO 2	.485644
1 TO 3	.52692
1 TO 4	.14073
1 TO 5	.445253

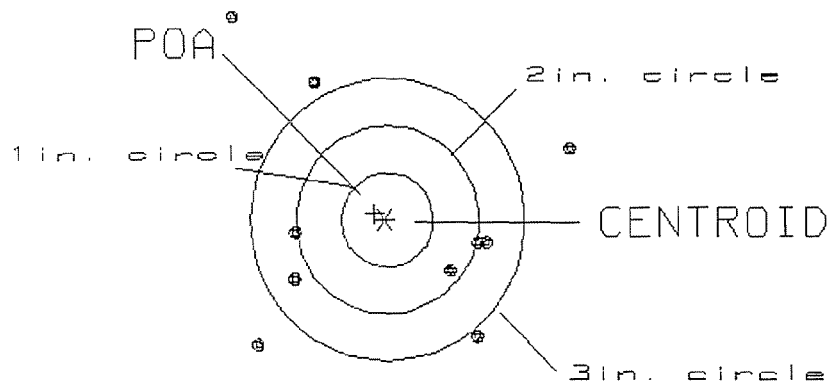
5^{23}
+₁⁴ <----POA

PATTERN #: 1
 POA TO CENTROID: .127
 MIN RADIUS : .887
 MEAN RADIUS : 1.524
 MAX RADIUS : 2.714
 CENTROID X : .109
 CENTROID Y : -.066

8 Sep 2000

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6594576

CENTERFIRE PATTERN # 1



OF SHOTS= 10

IN CIRCLE

HS= 3.71
 VS= 3.42
 GS= 4.31

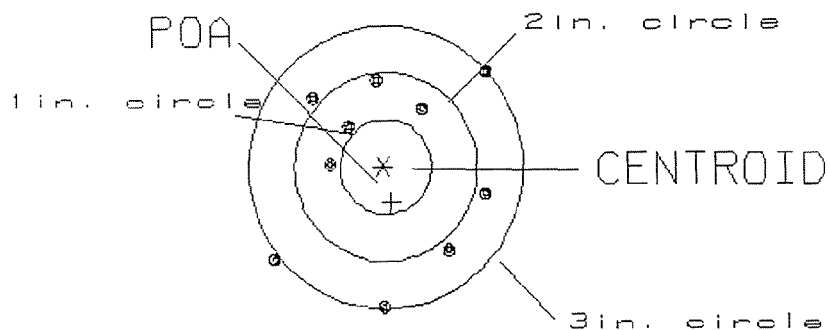
0
 1
 5

PATTERN #: 2
 POA TO CENTROID: .388
 MIN RADIUS : .554
 MEAN RADIUS : 1.068
 MAX RADIUS : 1.574
 CENTROID X : -.090
 CENTROID Y : .377

8 Sep 2000

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6594576

CENTERFIRE PATTERN # 2



OF SHOTS= 10

IN CIRCLE

HS= 2.33

0

VS= 2.46

4

GS= 3.03

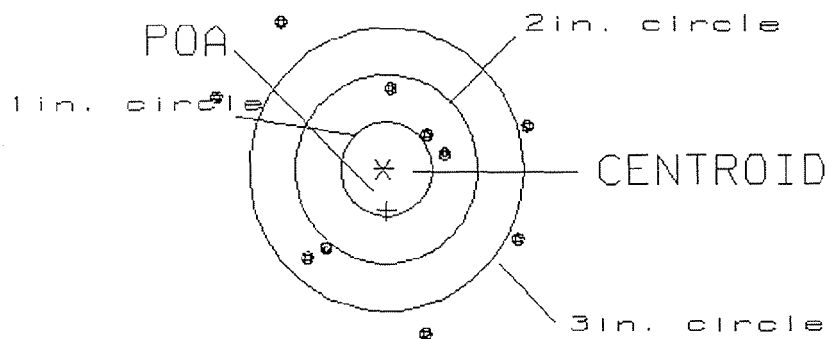
9

PATTERN #: 3
POA TO CENTROID: .441
MIN RADIUS : .528
MEAN RADIUS : 1.345
MAX RADIUS : 2.024
CENTROID X : -.038
CENTROID Y : .440

8 Sep 2000

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6594576

CENTERFIRE PATTERN # 3



OF SHOTS= 10

IN CIRCLE

HS= 3.45

0

VS= 3.29

3

GS= 3.67

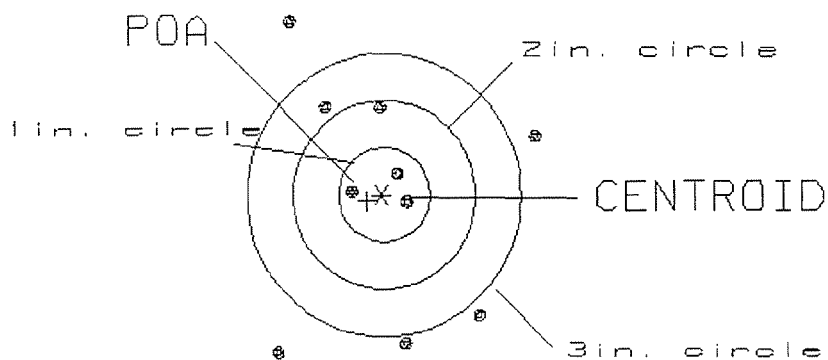
5

PATTERN #: 4
 POA TO CENTROID: .167
 MIN RADIUS : .226
 MEAN RADIUS : 1.212
 MAX RADIUS : 2.120
 CENTROID X : .152
 CENTROID Y : .068

8 Sep 2000

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6594576

CENTERFIRE PATTERN # 4



OF SHOTS= 10

IN CIRCLE

HS= 2.79

3

VS= 3.57

4

GS= 3.75

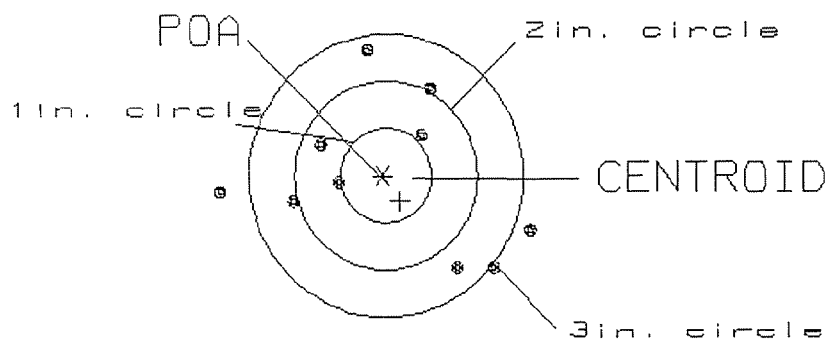
5

PATTERN #: 5
 POA TO CENTROID: .326
 MIN RADIUS : .537
 MEAN RADIUS : 1.160
 MAX RADIUS : 1.851
 CENTROID X : -.182
 CENTROID Y : .271

8 Sep 2000

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6594576

CENTERFIRE PATTERN # 5



OF SHOTS= 10

IN CIRCLE

HS= 3.44
 VS= 2.24
 GS= 3.46

0
 3
 7

Final Inspection

Sr: C6594576

DATE REC'D: 5-12-00

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-350

☐ 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:

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

R & E NUMBER	00009454		
SERIAL NUMBER	C6594576		
LOG-IN DATE	5-12-00		
INSPECT AND VERIFY:			
OPERATION #	OPERATION NAME	DATE	INITIAL
550	DIS-ASSEMBLE GUN	5-15-00	RW
560 A	RE-BARREL AT CUSTOM SHOP		
B	DRILL AND TAP		
C	POLISH		
575	ASSEMBLE		
600	PROOF	5-23-00	RW
605	CHECK HEADSPACE	5-23-00	RW
610	DIS-ASSEMBLE GUN		
612	MAGNAFLUX		
615	ROLLMARK CALIBER		
618	ROTO-BLAST		
620	APPLY COATINGS		
625 A	FINAL ASSEMBLY	9-8-00	CK
B	TRIGGER PULL TEST		
C.	SAFETY "ON" FORCE		
D	SAFETY "OFF" FORCE		
E	FIRING PIN INDENT		
640	TARGET	9-8-00	RW
655	FINAL INSPECT	9-11-00	RW
660	PACK		
		SHIP DATE	
QAR INSPECTION DATE			

GFM

CONTRACT # DAAA21-87-C-0086

Repair

GUN SERIAL # C6594576

New Barrel

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		2/4/93	RW
600	Proof		2/4/93	RW
607	Check Headspace		2/4/93	RW
610	Dis-assemble Gun		2/4/93	RW
612	Magnaflux Barrel Action		2/5/93	CP
	Magnaflux Bolt			
615	Rollmark Caliber		2/5/93	CP
617	Drill and Tap Sight Holes			
618	Polish Barrel		2/5/93	RT
620	Apply Coatings (Barrel Action)		2/5/93	RT
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		2/11/93	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		2/11/93	RW
	C) Inspect Ejector Hole for Chamfer		2/11/93	RW
	D) Oil Firing Pin Ass'y		2/11/93	RW
	E) Adjust Trigger Pull to Min Setting and Stake		2/11/93	RW

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4.5	4.5	4.5			2/11/93	RW
	G) Safety Off Force	3	3	3			2/11/93	RW
	H) Trigger Pull Test & Retainability						2/11/93	RW
	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						2/11/93	RW
	P) Detach & Attach Scope 20 Times							
640	Gallery Target & Test						3/1/93	RW
	A) Time							
	B) Malfunctions							
	C) Pierced Primers							
	D) Optical Clarity of Scope							
645	Inspect for Live Ammo						3/1/93	RW
655	Final Inspection							
	A) Headspace						3/4/93	RW
	B) Trigger Pull	2.52	2.52	2.50	2.55	2.51	3/4/93	RW
	C) Function						3/4/93	RW
660	Pack							

SWS TRIGGER PULL TEST

New Trigger Assy.

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C6594576DATE 2/11/93TESTER RW

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#	COMMENTS
PULL #1	2.56	2.32	2.49	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.53	2.42	2.45	
PULL #3	2.43	2.55	2.36	
PULL #4	2.54	2.46	2.52	
PULL #5	2.50	2.40	2.45	
TOTAL	12.56	12.15	12.27	
AVG.	2.51	2.43	2.45	

	3.00# INITIAL	3.00# AFTER 20 CYCLES	COMMENTS
PULL #1	3.22	3.11	
PULL #2	3.13	3.33	
PULL #3	3.19	3.10	
PULL #4	3.11	3.06	
PULL #5	3.24	3.07	
TOTAL	15.89	15.67	
AVG.	3.18	3.13	

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.11	4.31		4.07
PULL #2	4.06	4.27		4.07
PULL #3	4.20	4.18		4.12
PULL #4	4.09	4.23		4.12
PULL #5	4.16	4.10		4.00
TOTAL	20.62	21.09		20.38
AVG.	4.12	4.22		4.08

RECEIVING AND ESTIMATING REPORT

COMMENTS

ORDER

R 93-02471

INITIAL CUSTOMER ORDER NO.

WOG 19 OF 30 W/10X SCOPE & DEPLOYMENT KIT

DATE RECEIVED

DATE OPENED

DATE CODE

SERIAL NUMBER

NEW SERIAL NUMBER

MODEL AND GRADE

01/25/93

01/25/93

RK 11-90

06594576

700 7-62

NATO

ACCESSORIES

W/STUDS

W/SWIVELS

SOFT CASE

SCOPE BASE

FROM:

SHIP TO:

MCHALE, EDWARD J CPT,SF
HSC 3RD BN 3RD SFG (A)
FT BRAGG NC 28307

MCHALE, EDWARD J CPT,SF
HSC 3RD BN 3RD SFG (A)
FT BRAGG NC 28307

ACCOUNT NUMBER

ACCOUNT NUMBER N/C

CUST NO: 073985 C.D.D

WRITE

☐

CLEAN/TEST

PROM. DATE

ESTIMATED

VIA

UPS

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

CLE

A

B1

IGGER GROUP

B2

LT ASSY.

B3

RRREL ASSY.

B4

D1

EC. ASSY.

B5

D2

OOD

C1

D3

ETAL

C2

E3

E4

E5

E6

AIN FAULT

PARTS

COMMENTS

REPAIRMAN

PROOF

CLEAN

TEST

TARGET

PATTERN

GALLERY TESTER

DATE

DATE

DATE

DATE

DATE

RD6925 REV. 1/92

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

M2400019613

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6594576
3 Mar 1993

CENTROIDAL DISTANCES

0 TO	1	.229401
1 TO	2	.231465
1 TO	3	.986116
1 TO	4	1.37664
1 TO	5	1.41719

5

3

t_2

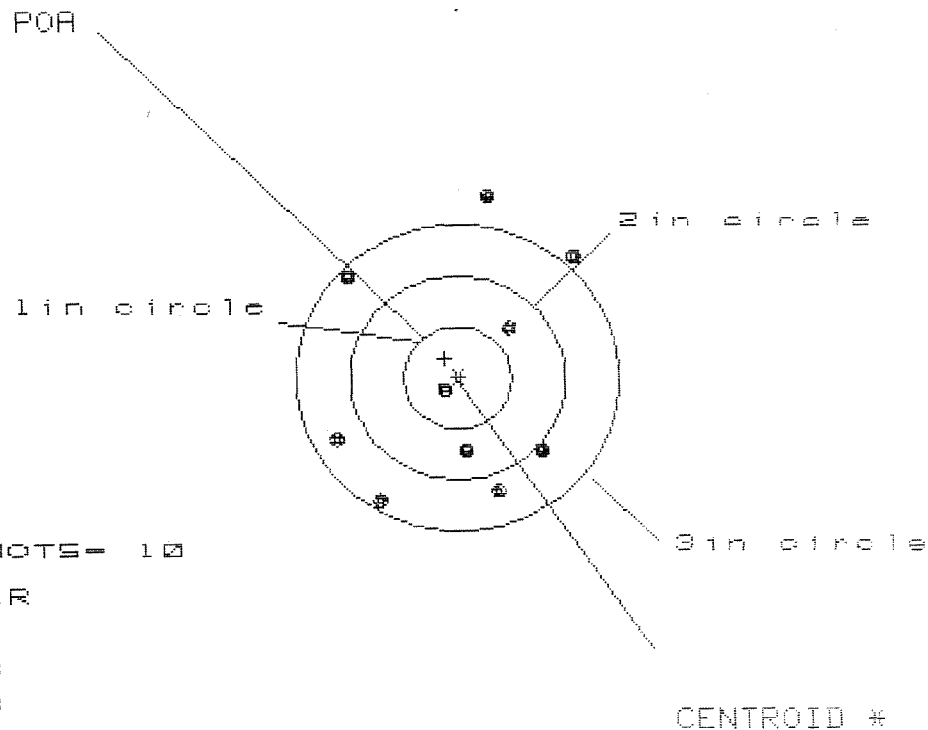
<----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1402
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .5648
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .581941
THE AMR FOR THIS RIFLE IS: .8888

3 Mar 1993

FILE:/PATTERNING/CENTERFIRE_PATT/C8594576

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 3

3 in = 8

HS = 2.264

VS = 3.025

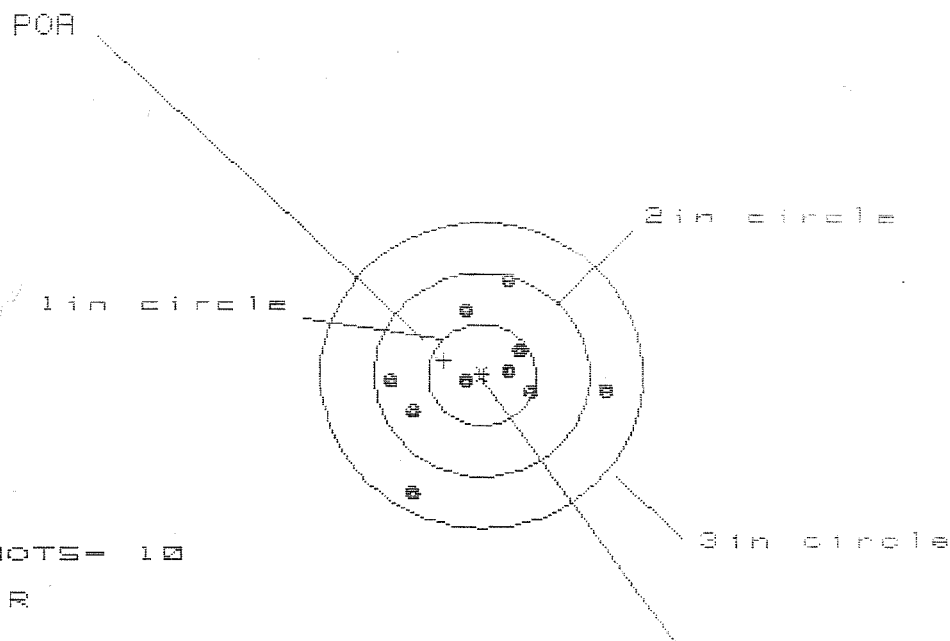
GS = 3.193

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.091	1.127	.977
MINIMUM X	:	-1.173	-1.137	-.996
MAXIMUM Y	:	1.827	1.427	1.348
MINIMUM Y	:	-1.198	-.995	-.816
CENTROID X	:	.124	.088	-.052
CENTROID Y	:	-.193	-.396	-.575
POA TO CENTROID in.	:	.230	.406	.577
MIN RADIUS	:	.216	.154	.250
MEAN RADIUS	:	1.152	1.034	.913
MAX RADIUS	:	1.855	1.819	1.600
HORIZONTAL SPREAD	:	2.264	2.264	1.973
VERTICAL SPREAD	:	3.025	2.422	2.164
EXTREME SPREAD	:	3.193	3.014	2.517
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		8	

3 Mar 1993

FILE:/PATTERNING/CENTERFIRE_PATT/08594578

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 4

2in = 8

3in = 10

HS= 1.998

VS= 2.132

GS= 2.296

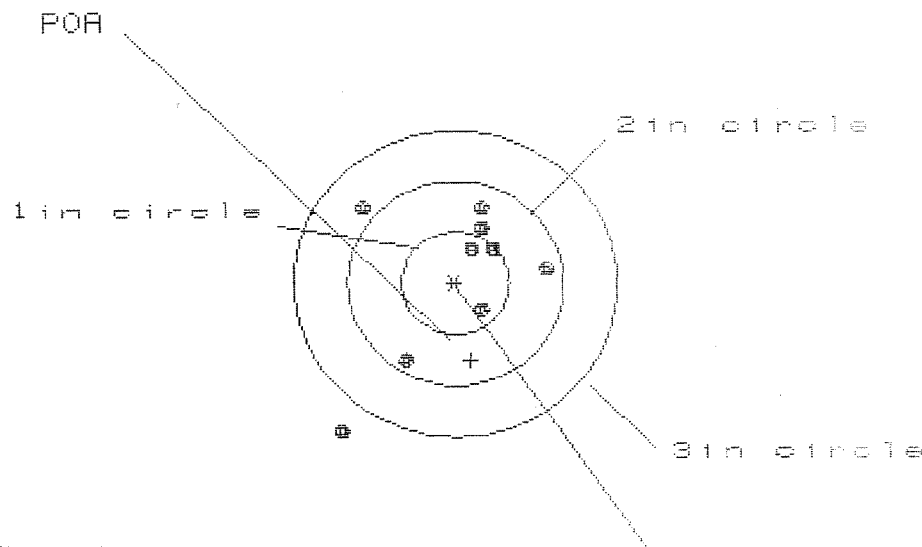
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.142	1.069	.527
MINIMUM X	:	-.856	-.929	-.795
MAXIMUM Y	:	.980	.852	.812
MINIMUM Y	:	-1.152	-.461	-.501
CENTROID X	:	.350	.423	.289
CENTROID Y	:	-.143	-.015	.025
POA TO CENTROID in.	:	.378	.423	.290
MIN RADIUS	:	.154	.234	.230
MEAN RADIUS	:	.714	.630	.576
MAX RADIUS	:	1.324	1.116	.853
HORIZONTAL SPREAD	:	1.998	1.998	1.322
VERTICAL SPREAD	:	2.132	1.313	1.313
EXTREME SPREAD	:	2.296	2.000	1.569
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	

3 Mar 1993

FILE:/PATTERNING/CENTERFIRE_PATT/08594526

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1 in = 4

2 in = 8

3 in = 9

HS= 1.821

VS= 2.165

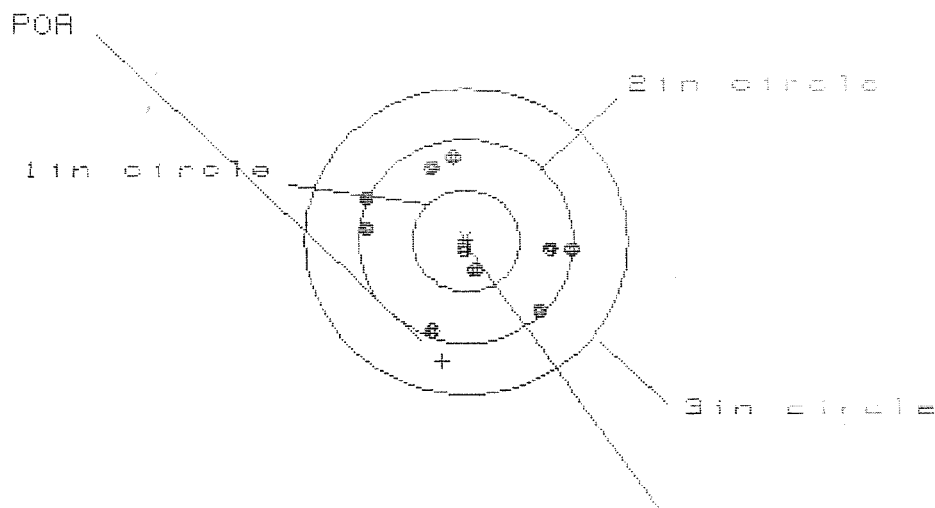
GS= 2.486

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.885	.692	.575
MINIMUM X	:	-1.016	-.937	-.671
MAXIMUM Y	:	.730	.570	.615
MINIMUM Y	:	-1.435	-.891	-.819
CENTROID X	:	-.144	-.031	.086
CENTROID Y	:	.756	.916	.844
POA TO CENTROID in.	:	.770	.916	.849
MIN RADIUS	:	.338	.151	.231
MEAN RADIUS	:	.737	.564	.483
MAX RADIUS	:	1.758	1.097	1.059
HORIZONTAL SPREAD	:	1.821	1.629	1.246
VERTICAL SPREAD	:	2.165	1.461	1.434
EXTREME SPREAD	:	2.486	1.720	1.593
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	

3 Mar 1993

FILE:/PATTERNING/CENTERFIRE_PATT/06594576

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 2

2in = 9

3in = 10

HS= 1.903

VS= 1.628

GS= 1.982

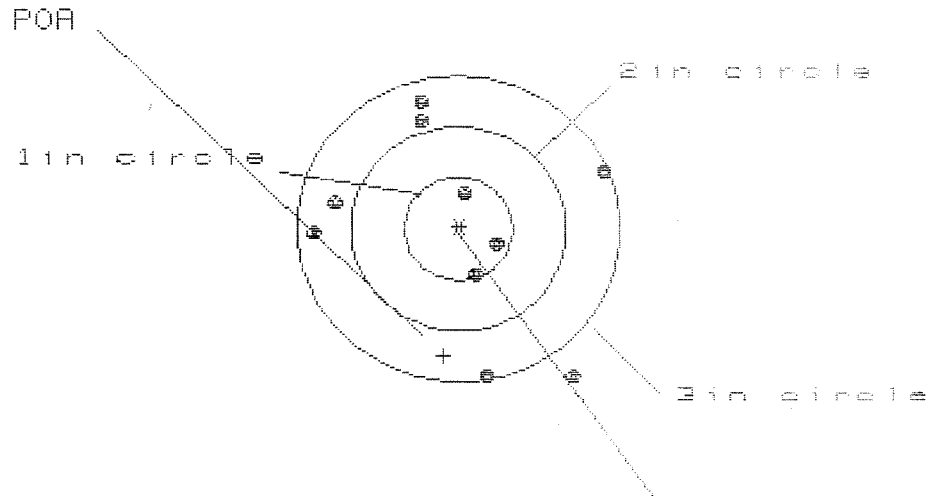
CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.992	.891	.969
MINIMUM X	:	-.911	-1.004	-.926
MAXIMUM Y	:	.787	.835	.754
MINIMUM Y	:	-.841	-.793	-.874
CENTROID X	:	.224	.325	.247
CENTROID Y	:	1.180	1.132	1.213
POA TO CENTROID in.	:	1.201	1.178	1.238
MIN RADIUS	:	.070	.091	.102
MEAN RADIUS	:	.754	.717	.696
MAX RADIUS	:	1.008	1.012	.975
HORIZONTAL SPREAD	:	1.903	1.895	1.895
VERTICAL SPREAD	:	1.628	1.628	1.628
EXTREME SPREAD	:	1.982	1.902	1.902
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		9	
NUMBER IN THREE INCH CIRCLE	=		10	

3 Mar 1993

FILE:/PATTERNING/CENTERFIRE_PATT/C8534528

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 3

2in = 3

3in = 9

HS= 2.649

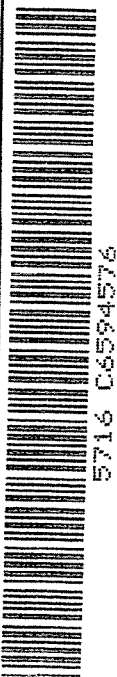
VS= 2.744

GS= 3.081

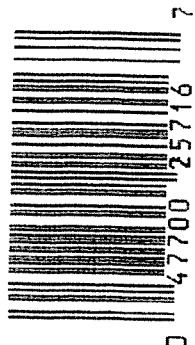
CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.352	1.470	1.511
MINIMUM X	:	-1.297	-1.179	-1.138
MAXIMUM Y	:	1.276	1.112	.913
MINIMUM Y	:	-1.468	-1.599	-1.828
CENTROID X	:	.147	.029	-.012
CENTROID Y	:	1.244	1.408	1.607
POA TO CENTROID in.	:	1.253	1.408	1.608
MIN RADIUS	:	.356	.274	.176
MEAN RADIUS	:	1.087	.992	.890
MAX RADIUS	:	1.809	1.633	1.518
HORIZONTAL SPREAD	:	2.649	2.649	2.649
VERTICAL SPREAD	:	2.744	2.711	1.733
EXTREME SPREAD	:	3.081	2.768	2.713
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		9	

Remington®  REG. U.S. PAT. & TM. OFF.		VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.
MODEL 700™ H24		SERIAL NO. C6594576
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada. Marque Deposee.		ORDER NO. 5716



UFC



CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C 6594576

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		10/31/90	Kd
600	Proof		10/31/90	Kd
607	Check Headspace		10/31/90	Kd
610	Dis-assemble Gun		10/31/90	Kd
612	Magnaflux Barrel Action		11/1/90	KCR
	Magnaflux Bolt		11/1/90	KCR
615	Rollmark Caliber		11/1/90	KCR
617	Drill and Tap Sight Holes		11/6/90	LB
618	Polish Barrel RB		11/7/90	WLB
620	Apply Coatings (Barrel Action)		11-26-90	HA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		11/30/90	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		11/30/90	KS
	C) Inspect Ejector Hole for Chamfer		11/30/90	KS
	D) Oil Firing Pin Ass'y		11/30/90	KS
	E) Adjust Trigger Pull to Min Setting and Stake		12/3/90	RM

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4 $\frac{3}{4}$	4 $\frac{3}{4}$	4 $\frac{3}{4}$			12/3/90	WLB
	G) Safety Off Force	3	3	3			12/3/90	WLB
	H) Trigger Pull Test & Retainability						12/3/90	WLB
	I) Firing Pin Indent	.021	.0215	.021			12/3/90	WLB
	J) Assemble Stock						12/3/90	KS
	K) Assemble Swivel Studs						12-5-90	WLB
	L) Attach Front and Rear Sight Assemblies						12/3/90	KS
	M) Iron Sight Alignment						12/3/90	KS
	N) Detach Front & Rear Sights & place in numbered container						12/3/90	KS
	O) Attach Scope to Rifle						12/3/90	KS
	P) Detach & Attach Scope 20 Times						12/3/90	KS
640	Gallery Target & Test						12-4-90	DH
	A) Time						12-4-90	DH
	B) Malfunctions						12-4-90	DH
	C) Pierced Primers						12-4-90	DH
	D) Optical Clarity of Scope						12-4-90	DH
645	Inspect for Live Ammo						12-4-90	DH
655	Final Inspection							
	A) Headspace						12-5-90	WLB
	B) Trigger Pull	277	287	295	290	281	12-5-90	WLB
	C) Function						12-5-90	WLB
660	Pack						12/8-90	DH

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C 6594576

DATE 12-5-90

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.44	2.42	2.37	2.77	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.46	2.40	2.33	2.87	
PULL #3	2.46	2.33	2.35	2.95	
PULL #4	2.44	2.39	2.37	2.90	
PULL #5	2.41	2.37	2.37	2.81	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.18	3.31		
PULL #2	3.44	3.15		
PULL #3	3.38	3.29		
PULL #4	3.29	3.34		
PULL #5	3.32	3.31		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.20	4.29		4.35
PULL #2	4.25	4.34		4.36
PULL #3	4.34	4.31		4.20
PULL #4	4.34	4.36		4.25
PULL #5	4.28	4.35		4.35
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6594576
4 Dec 1990

CENTROIDAL DISTANCES

0 TO	1	.317405
1 TO	2	.224404
1 TO	3	.317036
1 TO	4	.563152
1 TO	5	.320062

4²5 <----POA

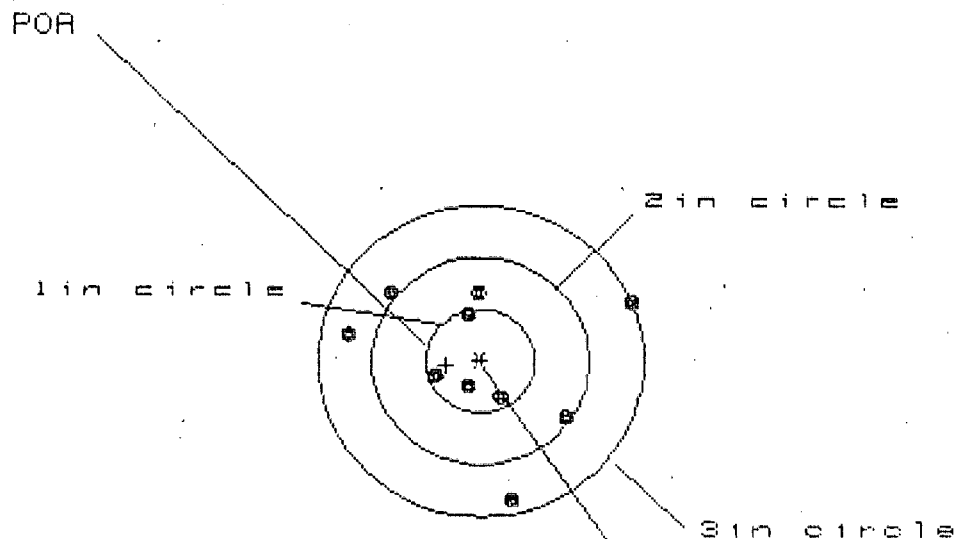
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1808
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0382
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .184791

THE AMR FOR THIS RIFLE IS: .828

4 Dec 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6594576

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 4

2in = 7

3in = 9

HS= 2.557

VS= 2.019

GS= 2.674

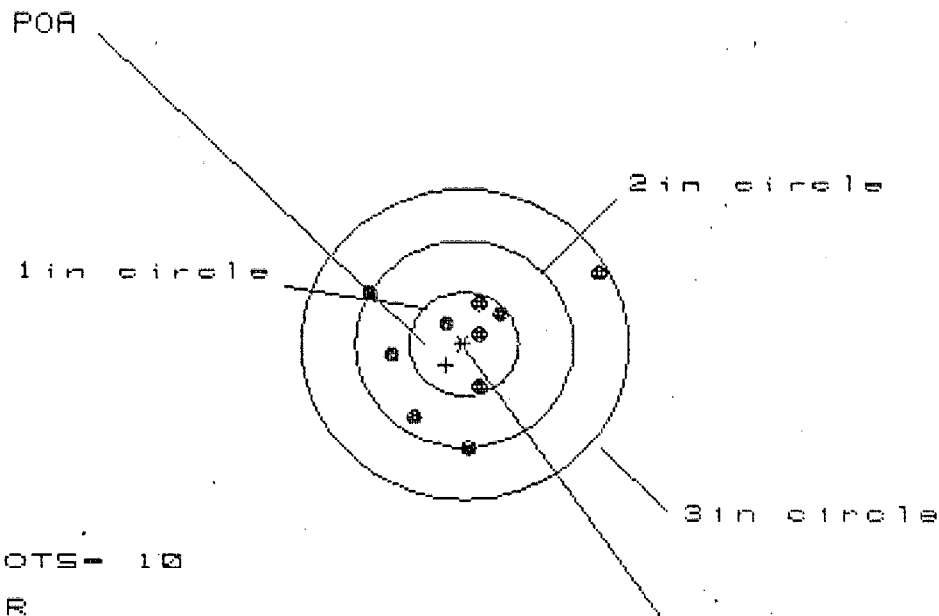
CENTROID *

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.397	.972	1.022
MINIMUM X	:	-1.260	-1.105	-1.055
MAXIMUM Y	:	.682	.746	.587
MINIMUM Y	:	-1.337	-1.273	-.657
CENTROID X	:	.315	.160	.110
CENTROID Y	:	.039	-.025	.134
POA TO CENTROID in.	:	.317	.162	.173
MIN RADIUS	:	.294	.189	.323
MEAN RADIUS	:	.841	.744	.667
MAX RADIUS	:	1.514	1.333	1.215
HORIZONTAL SPREAD	:	2.657	2.077	2.077
VERTICAL SPREAD	:	2.019	2.019	1.244
EXTREME SPREAD	:	2.674	2.243	2.243
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

4 Dec 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6594526

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 5

2 in = 9

3 in = 10

HS= 2.037

VS= 1.705

GS= 2.156

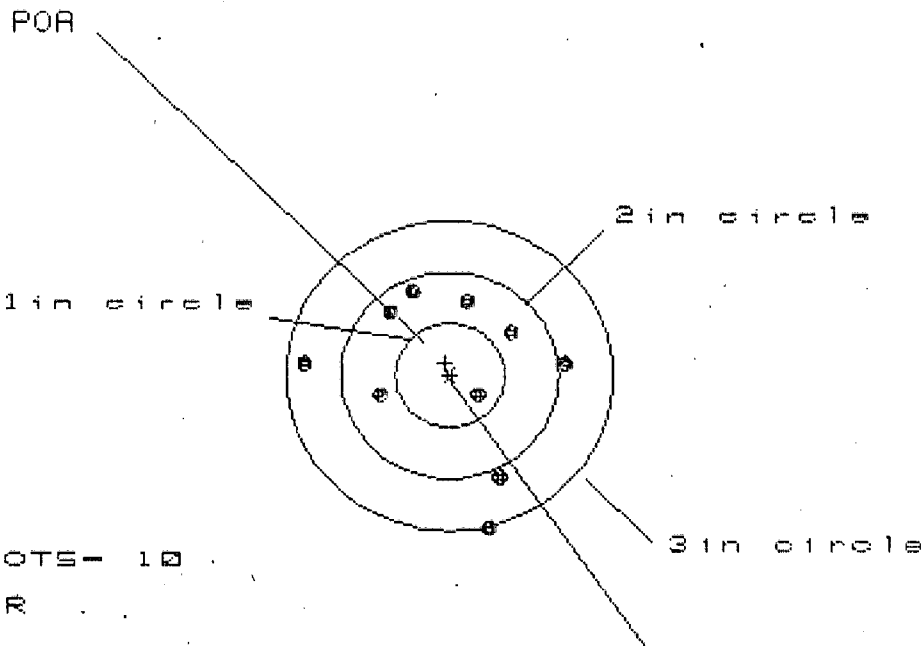
CENTROID *

PATTERN #	2		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.192	.502	.526
MINIMUM X	-.845	-.712	-.688
MAXIMUM Y	.734	.536	.425
MINIMUM Y	-.971	-.889	-.717
CENTROID X	.164	.031	.007
CENTROID Y	.205	.123	.234
POA TO CENTROID in.	.262	.127	.234
MIN RADIUS	.199	.280	.169
MEAN RADIUS	.662	.586	.528
MAX RADIUS	1.400	.910	.808
HORIZONTAL SPREAD	2.037	1.214	1.214
VERTICAL SPREAD	1.705	1.425	1.142
EXTREME SPREAD	2.156	1.689	1.316
NUMBER IN ONE INCH CIRCLE =		5	
NUMBER IN TWO INCH CIRCLE =		9	
NUMBER IN THREE INCH CIRCLE =		10	

4 Dec 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6534576

CENTERFIRE PATTERNS # 3



OF SHOTS - 10

IN CIR

1 in = 1

2 in = 6

3 in = 9

IS = 2.439

VS = 2.261

GS = 2.439

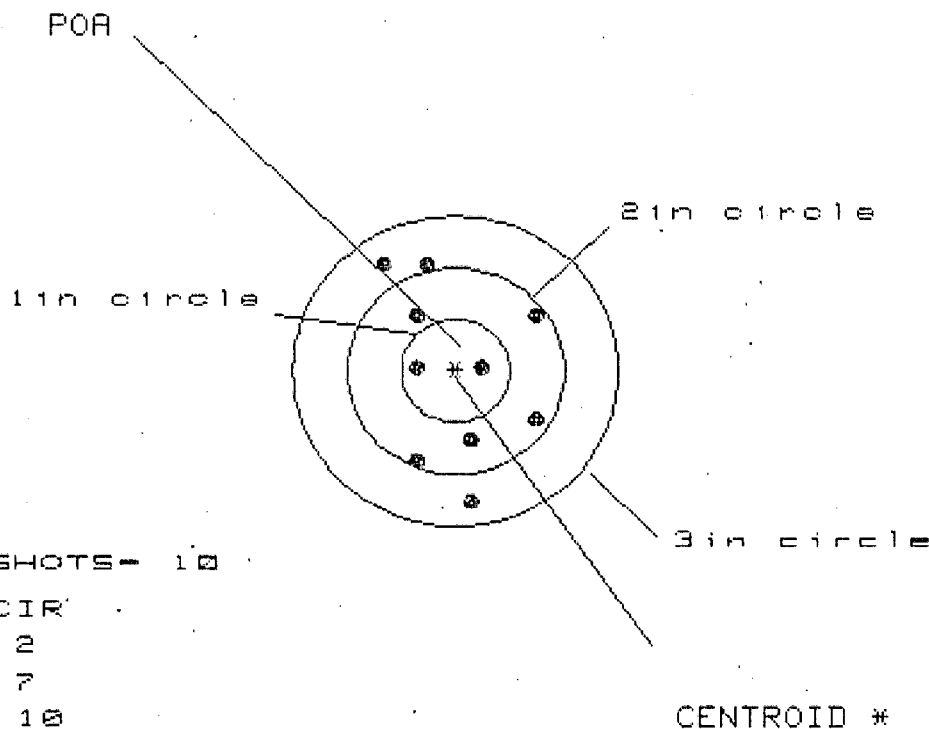
CENTROID *

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.094	1.137	.974
MINIMUM X	:	-1.345	-1.302	-.772
MAXIMUM Y	:	.789	.625	.620
MINIMUM Y	:	-1.472	-1.103	-1.109
CENTROID X	:	.039	-.004	.159
CENTROID Y	:	-.117	.047	.052
POA TO CENTROID in.	:	.123	.047	.167
MIN RADIUS	:	.274	.414	.335
MEAN RADIUS	:	.912	.824	.749
MAX RADIUS	:	1.522	1.303	1.159
HORIZONTAL SPREAD	:	2.439	2.439	1.746
VERTICAL SPREAD	:	2.261	1.728	1.728
EXTREME SPREAD	:	2.439	2.439	1.911
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

4 Dec 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6594576

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 2

2in = 7

3in = 10

HS= 1.413

VS= 2.291

GS= 2.435

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.712	.634	.639
MINIMUM X	:	-.701	-.424	-.419
MAXIMUM Y	:	1.076	1.180	1.043
MINIMUM Y	:	-1.215	-1.095	-.904
CENTROID X	:	-.243	-.165	-.170
CENTROID Y	:	-.037	-.157	-.020
POA TO CENTROID in.	:	.245	.227	.171
MIN RADIUS	:	.237	.227	.162
MEAN RADIUS	:	.815	.755	.700
MAX RADIUS	:	1.284	1.227	1.094
HORIZONTAL SPREAD	:	1.413	1.058	1.058
VERTICAL SPREAD	:	2.291	2.275	1.947
EXTREME SPREAD	:	2.435	2.307	1.949
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

4 Dec 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6594576

CENTERFIRE PATTERNS

5

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 1

2in = 8

3in = 9

HS= 2.472

VS= 2.151

GS= 2.973

PATTERN #

5

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.378	1.126	1.009
MINIMUM X	-1.094	-.941	-.639
MAXIMUM Y	1.213	1.043	1.005
MINIMUM Y	-.938	-.803	-.841
CENTROID X	.629	.476	.594
CENTROID Y	.101	-.034	.004
POA TO CENTROID in.	.637	.477	.594
MIN RADIUS	.331	.192	.295
MEAN RADIUS	.910	.762	.745
MAX RADIUS	1.836	1.130	1.012
HORIZONTAL SPREAD	2.472	2.067	1.647
VERTICAL SPREAD	2.151	1.846	1.846
EXTREME SPREAD	2.973	2.105	1.881
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =		8	
NUMBER IN THREE INCH CIRCLE =		9	

