

C6523493

MODEL 700™ M24

Model 515™

Action

Barrel Length

Capacity

Order No. 5715

*Includes 1 in chamber.

Remington.

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: RE00146504

Serial: C6523493 Model M24 SWS Center Fire
Caliber: 7.62 NATO

Repairman:

Status:

Closed 6/17/2008 9:50:05 AM

Verify Repair

Address Information

Customer: ☒ Received From Return To: ☐ Received From

Name: DEF DIST DEPOT DEF DIST DEPOT

Address 1: 7 FRANKFORD AVE BLDG 362 7 FRANKFORD AVE BLDG 362

Address 2: PO Box: PO Box:

City: ANNISTON ANNISTON

State: AL Zip Code: 36201 Country: US State: AL Zip Code: 36201 Country: US

FFL:

Contact / Condition

Problems

Estimate

History / Status

Shipping / Billing

Contact Information

Phone: NN

Fax:

Email:

Comments:

Received Condition

Fair

Condition
Notes:CSR
Notes:

Accessories Received

Code	Desc	Qty
A007	With Stud	3
A008	With Swivel	2
A010	Hard Case	1
A017	Scope Base	1
A026	Scope	1
A045	Bi Pod	1
A057	Fit and Rear Sgt Base	1

Repair Search

Refresh

Close

nagletj

6/17/2008

10:47 AM

CAPS

NUM

INS

SCFL



10:47 AM

Number: C6523493

Model: M24 SWS



RE00146504

M-24
INSPECTION CHECKLIST - REPAIRS
CONTRACT #: W52H09-07-C-0207
ISSUED 10/1/2007

R & E NUMBER <u>146504</u>	
SERIAL NUMBER <u>C6523493</u>	
LOG-IN DATE <u>6-17-08</u>	

OPERATION #	OPERATION NAME	DATE	INITIAL
500	DIS-ASSEMBLE GUN	9-8-09	RTZ
505	RE-BARREL	9-11-09	RTZ
420	ASSEMBLE	9-11-09	RTZ
440	PROOF	9-11-09	SPD
460	CHECK HEADSPACE	9-11-09	SPD
470	DIS-ASSEMBLE GUN	9-11-09	SPD
480	MAGNAFLUX	9/17/09	SP
510	DRILL AND TAP	9-14-09	SP
500	ROLLMARK CALIBER	9/17/09	SP
520	GOFF BLAST BBL / REC	9/17/09	SP
530 & 540	APPLY COATINGS	9/18	-
560	FINAL ASSEMBLY	9-29-09	RTZ
640	FUNCTION TEST AND	9-30-09	SPD
650	TARGET	9-30-09	SPD
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
670	FINAL INSPECTION	9-30-09	RP
	A) HEADSPACE	10/1/09	RP
	B) TRIGGER PULL	2.47 2.52 2.51 2.50 2.40 10-1-09	TC
680	F) SAFETY ON FORCE	3° 3° 3°	
	G) SAFETY OFF FORCE	5° 5° 5°	
	I) FIRING PIN INDENT	.021 .021 .021	
690	PACK	10/1/09	FM

F006 REV 1/2009

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6523493.___0
FILE DATE AND TIME: 10/01/2009 07:18

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.054
The Average Y Centroid of the Five Target Set:	-0.061
The Average Point of Impact of the Five Target Set:	0.082
The Average Mean Radius of the Five Target Set:	0.679
The Distance from POA to Centroid Target #1:	0.141
The Distance from Centroid Target #2 to Centroid Target #1:	0.330
The Distance from Centroid Target #3 to Centroid Target #1:	0.205
The Distance from Centroid Target #4 to Centroid Target #1:	0.246
The Distance from Centroid Target #5 to Centroid Target #1:	0.071

SERIAL NUMBER: C6523493. __ 0

TARGET NUMBER: 1

FILE DATE: 10/01/2009

FILE TIME: 07:18

POINT#	X	Y
1:	0.927	-0.018
2:	-0.399	0.903
3:	-0.775	-0.065
4:	-0.620	-0.722
5:	0.032	-0.514
6:	0.107	-0.376
7:	-0.729	-0.335
8:	-0.418	0.004
9:	0.377	0.103
10:	0.206	0.443

X CENTROID: -0.129

Y CENTROID: -0.058

POA TO CENTROID: 0.141

HORZ SPREAD: 1.702

VERT SPREAD: 1.625

GROUP SPREAD: 1.703

MIN RADIUS: 0.295

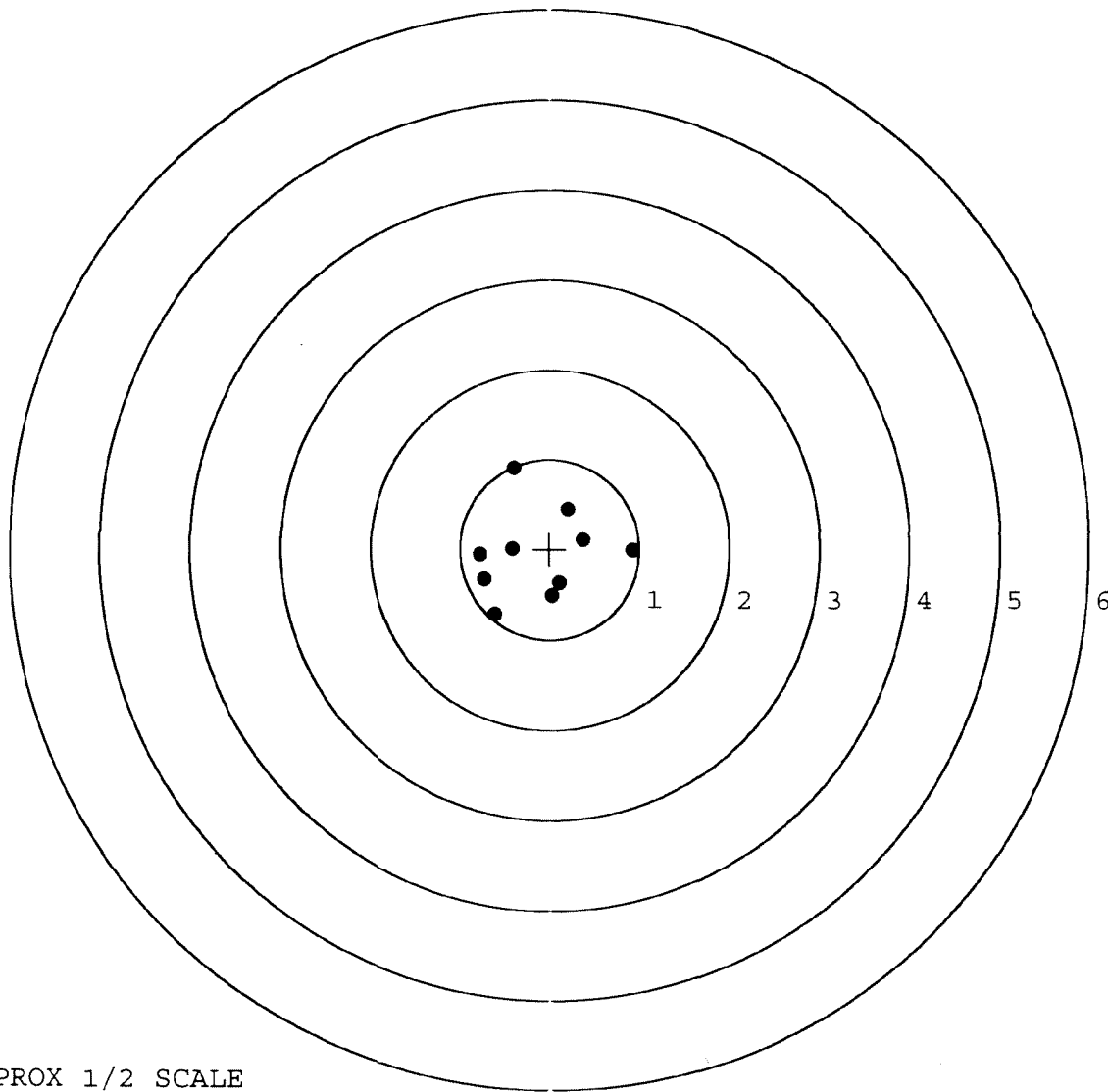
MAX RADIUS: 1.057

MEAN RADIUS: 0.650

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10

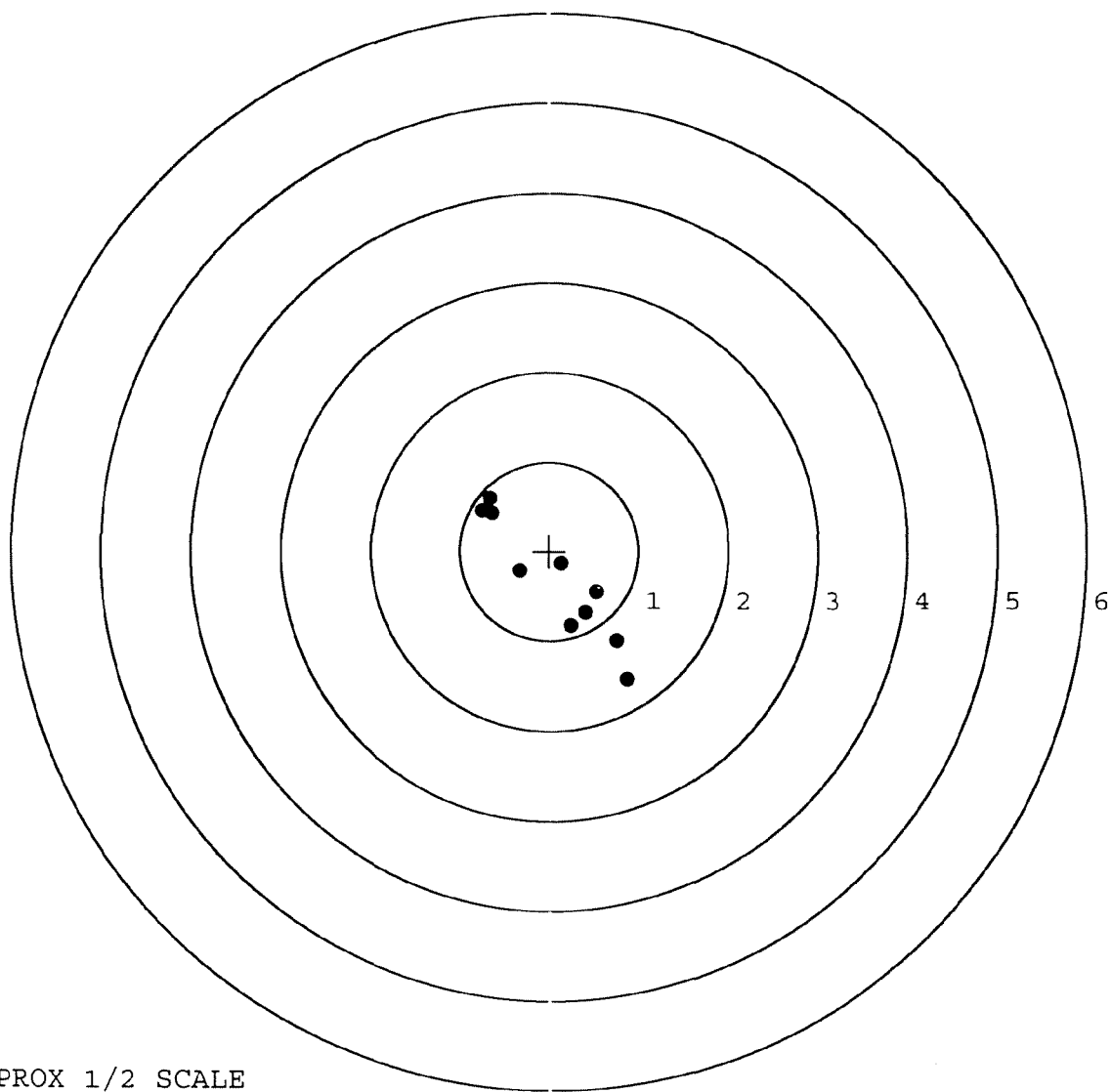


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6523493. 0
TARGET NUMBER: 2
FILE DATE: 10/01/2009
FILE TIME: 07:18

X CENTROID: 0.056
Y CENTROID: -0.330
POA TO CENTROID: 0.335
HORZ SPREAD: 1.619
VERT SPREAD: 2.030
GROUP SPREAD: 2.541
MIN RADIUS: 0.205
MAX RADIUS: 1.368
MEAN RADIUS: 0.781
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 6
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.867	-1.432
2:	0.754	-1.004
3:	0.533	-0.465
4:	0.135	-0.141
5:	0.241	-0.834
6:	0.413	-0.690
7:	-0.328	-0.221
8:	-0.752	0.454
9:	-0.640	0.433
10:	-0.662	0.598



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6523493. 0

TARGET NUMBER: 3

FILE DATE: 10/01/2009

FILE TIME: 07:18

POINT#	X	Y
1:	-0.833	0.469
2:	-0.444	-0.191
3:	0.625	-0.521
4:	0.344	-0.566
5:	0.384	-0.058
6:	0.596	-0.018
7:	0.023	0.437
8:	-0.120	0.189
9:	0.021	0.229
10:	0.076	0.023

X CENTROID: 0.067

Y CENTROID: -0.001

POA TO CENTROID: 0.067

HORZ SPREAD: 1.458

VERT SPREAD: 1.035

GROUP SPREAD: 1.762

MIN RADIUS: 0.025

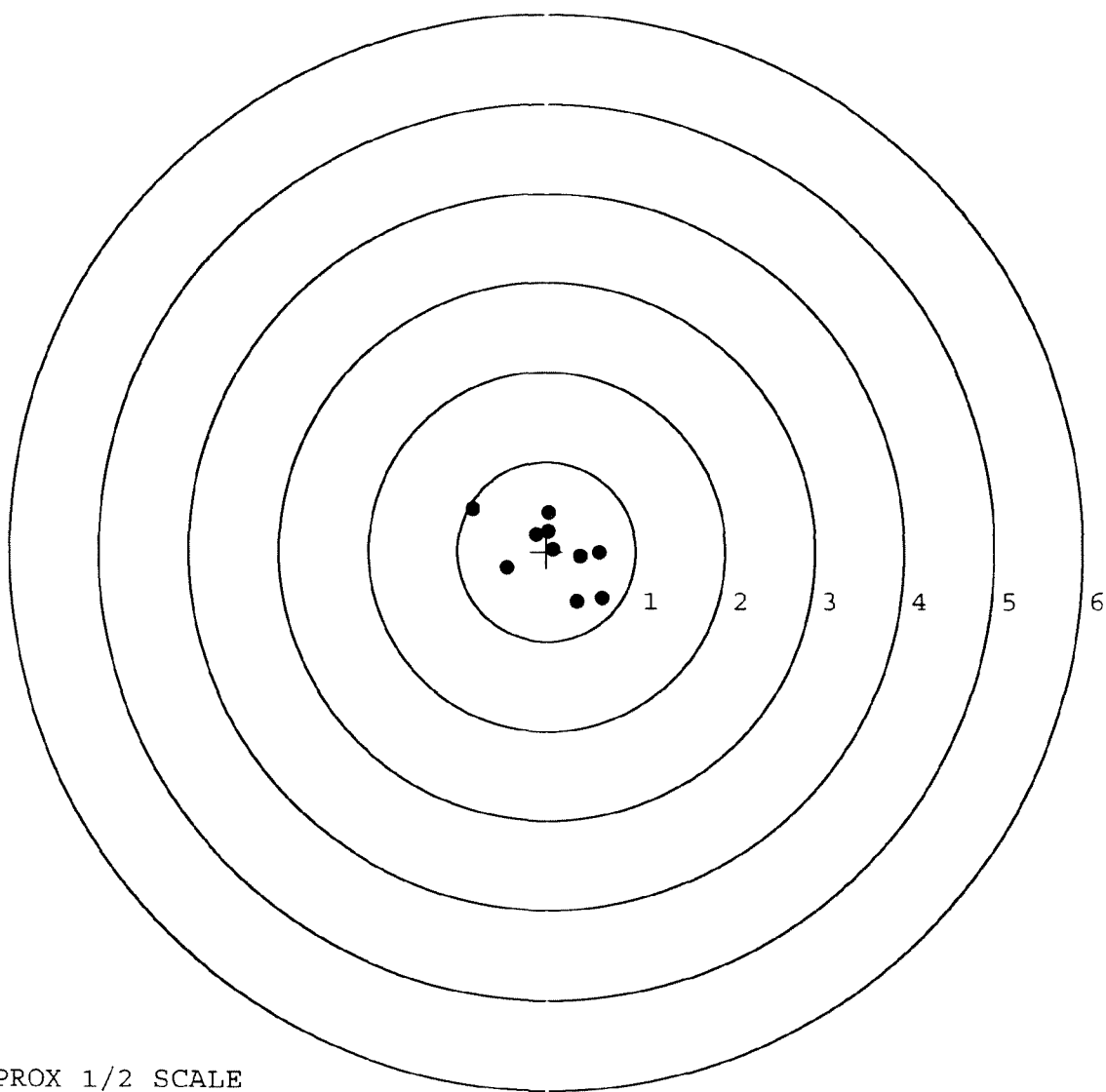
MAX RADIUS: 1.015

MEAN RADIUS: 0.477

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6523493. __0

TARGET NUMBER: 4

FILE DATE: 10/01/2009

FILE TIME: 07:18

X CENTROID: -0.080

Y CENTROID: 0.183

POA TO CENTROID: 0.200

HORZ SPREAD: 1.371

VERT SPREAD: 2.568

GROUP SPREAD: 2.587

MIN RADIUS: 0.087

MAX RADIUS: 1.313

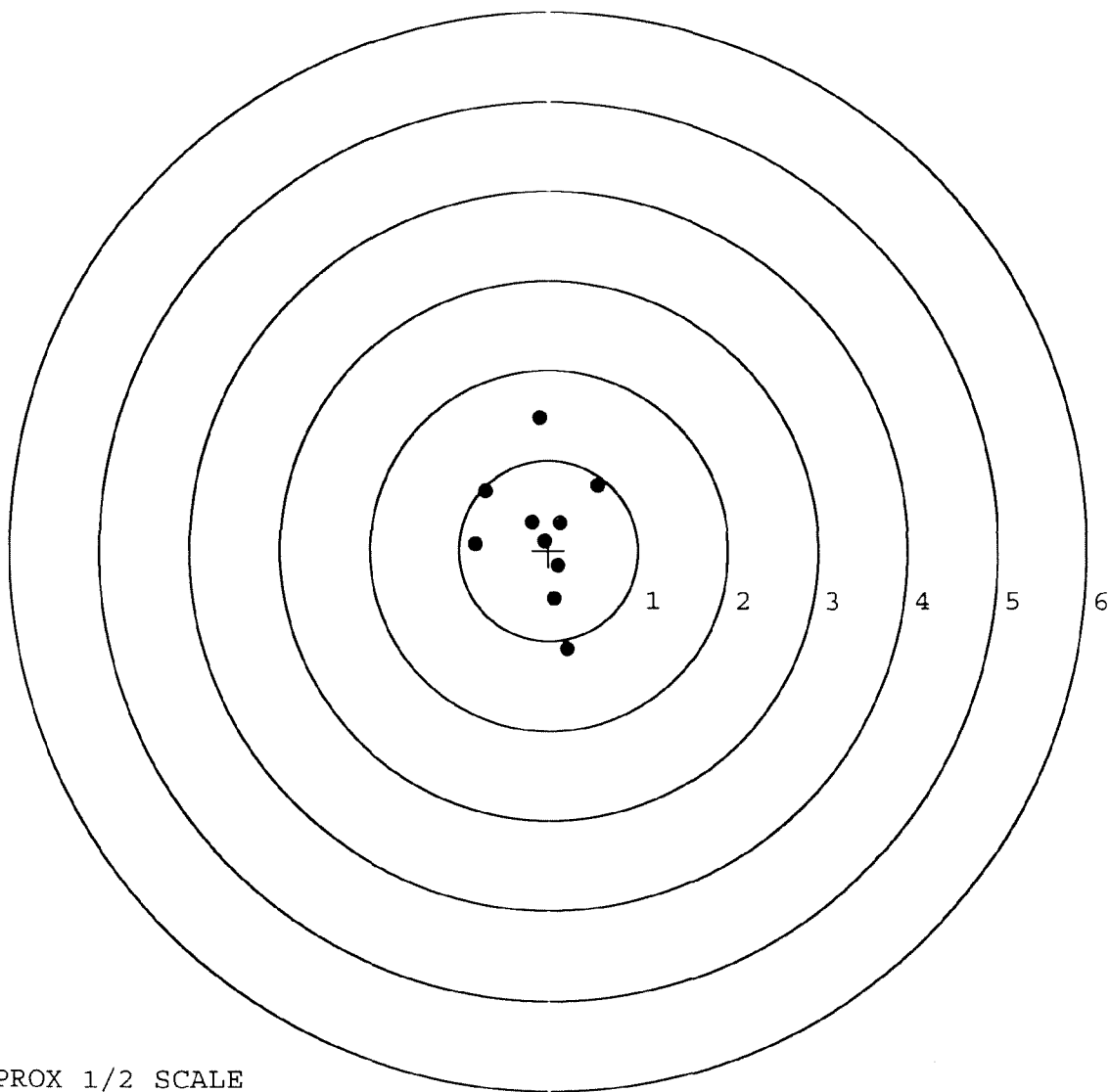
MEAN RADIUS: 0.659

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.210	-1.097
2:	0.061	-0.534
3:	-0.815	0.068
4:	0.556	0.722
5:	-0.105	1.471
6:	-0.706	0.656
7:	-0.189	0.313
8:	0.127	0.303
9:	-0.045	0.104
10:	0.107	-0.173



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6523493. 0

TARGET NUMBER: 5

FILE DATE: 10/01/2009

FILE TIME: 07:18

POINT#	X	Y
1:	-0.741	-0.415
2:	0.172	-0.699
3:	0.912	-0.317
4:	0.671	-0.814
5:	-0.185	-0.597
6:	-0.366	0.732
7:	-0.675	0.656
8:	-0.749	0.632
9:	-0.933	0.476
10:	0.029	-0.647

X CENTROID: -0.187

Y CENTROID: -0.099

POA TO CENTROID: 0.211

HORZ SPREAD: 1.845

VERT SPREAD: 1.546

GROUP SPREAD: 2.008

MIN RADIUS: 0.498

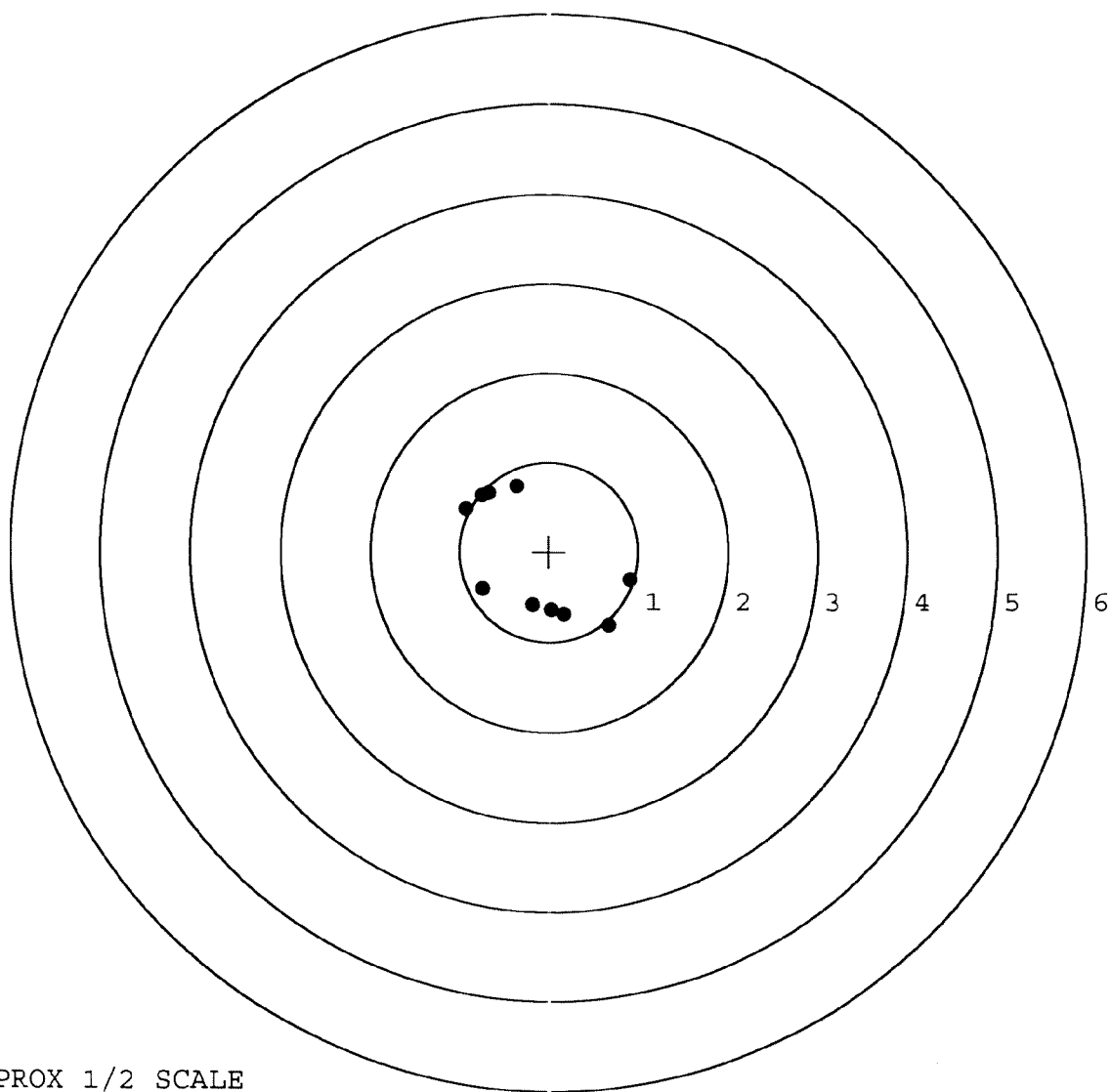
MAX RADIUS: 1.120

MEAN RADIUS: 0.827

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

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: **RE00092982** Serial: C6523493 Model: M24 SWS Center Fire Caliber: 7.62 NATO Produced: 12/19/1990 Repairman: Status: Closed 2/11/2005 7:30:46 AM

Verify Repair

Address Information

Customer: ☒ Received From Return To: ☐ Received From

Name: DEF DIST DEPOT ANNISTON DEF DIST DEPOT ANNISTON

Address 1: Address 2: PO Box: PO Box:

City: ANNISTON ANNISTON

State: AL Zip Code: 36201 4199 Country: US State: AL Zip Code: 36201 4199 Country: US

FFL: ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐

Contact / Condition Problems Estimate History / Status Shipping / Billing

Contact Information: Phone: Fax: Email: Comments:

Received Condition: Good Condition Notes: CSR Notes:

Accessories Received:

Code	Desc	Qty
A007	With Stud	3
A010	Hard Case	1
A017	Scope Base	1
A026	Scope	1
A057	Fit and Rear Sgt Base	1

Repair Search Refresh Close

macell 2/14/2005 9:11 AM CAPS NUM INS SCAL

start 5 2 3 Arms Service

Serial Number: **C6523493**

Model: **M24 SWS**



RE00092982

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6523493.__1
FILE DATE AND TIME: 02/21/2005 09:22

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.038
The Average Y Centroid of the Five Target Set:	-0.043
The Average Point of Impact of the Five Target Set:	0.058
The Average Mean Radius of the Five Target Set:	0.672
The Distance from POA to Centroid Target #1:	0.154
The Distance from Centroid Target #2 to Centroid Target #1:	0.188
The Distance from Centroid Target #3 to Centroid Target #1:	0.121
The Distance from Centroid Target #4 to Centroid Target #1:	0.204
The Distance from Centroid Target #5 to Centroid Target #1:	0.048

SERIAL NUMBER: C6523493. __1

TARGET NUMBER: 1

FILE DATE: 02/21/2005

FILE TIME: 09:22

POINT#	X	Y
1:	0.778	-1.220
2:	1.166	0.428
3:	0.359	0.291
4:	0.096	0.489
5:	-0.785	-0.684
6:	-0.070	-0.379
7:	-0.356	-0.316
8:	-0.364	-0.085
9:	-0.555	0.003
10:	-0.788	0.027

X CENTROID: -0.052

Y CENTROID: -0.145

POA TO CENTROID: 0.154

HORZ SPREAD: 1.954

VERT SPREAD: 1.709

GROUP SPREAD: 2.002

MIN RADIUS: 0.235

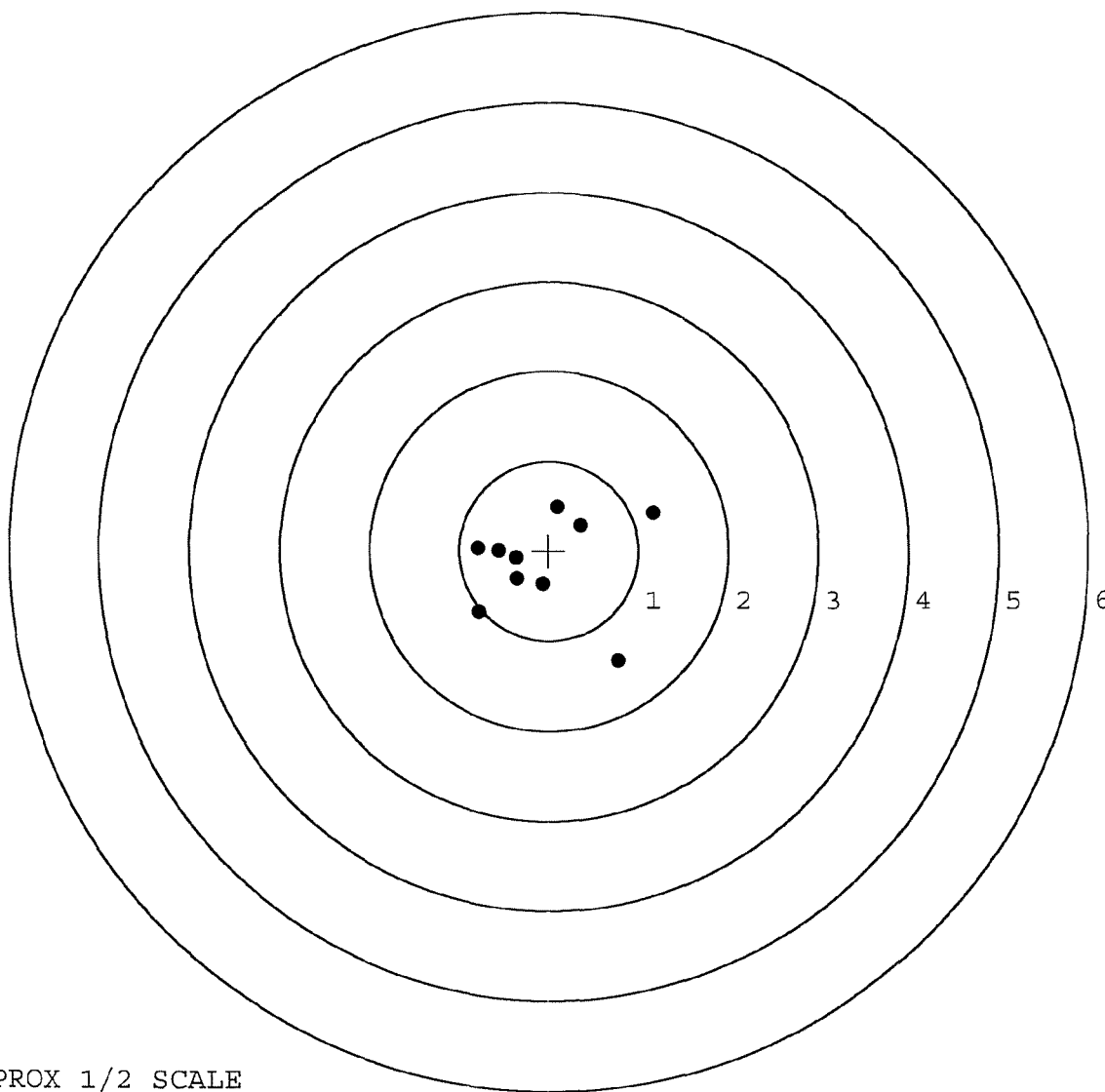
MAX RADIUS: 1.358

MEAN RADIUS: 0.705

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10

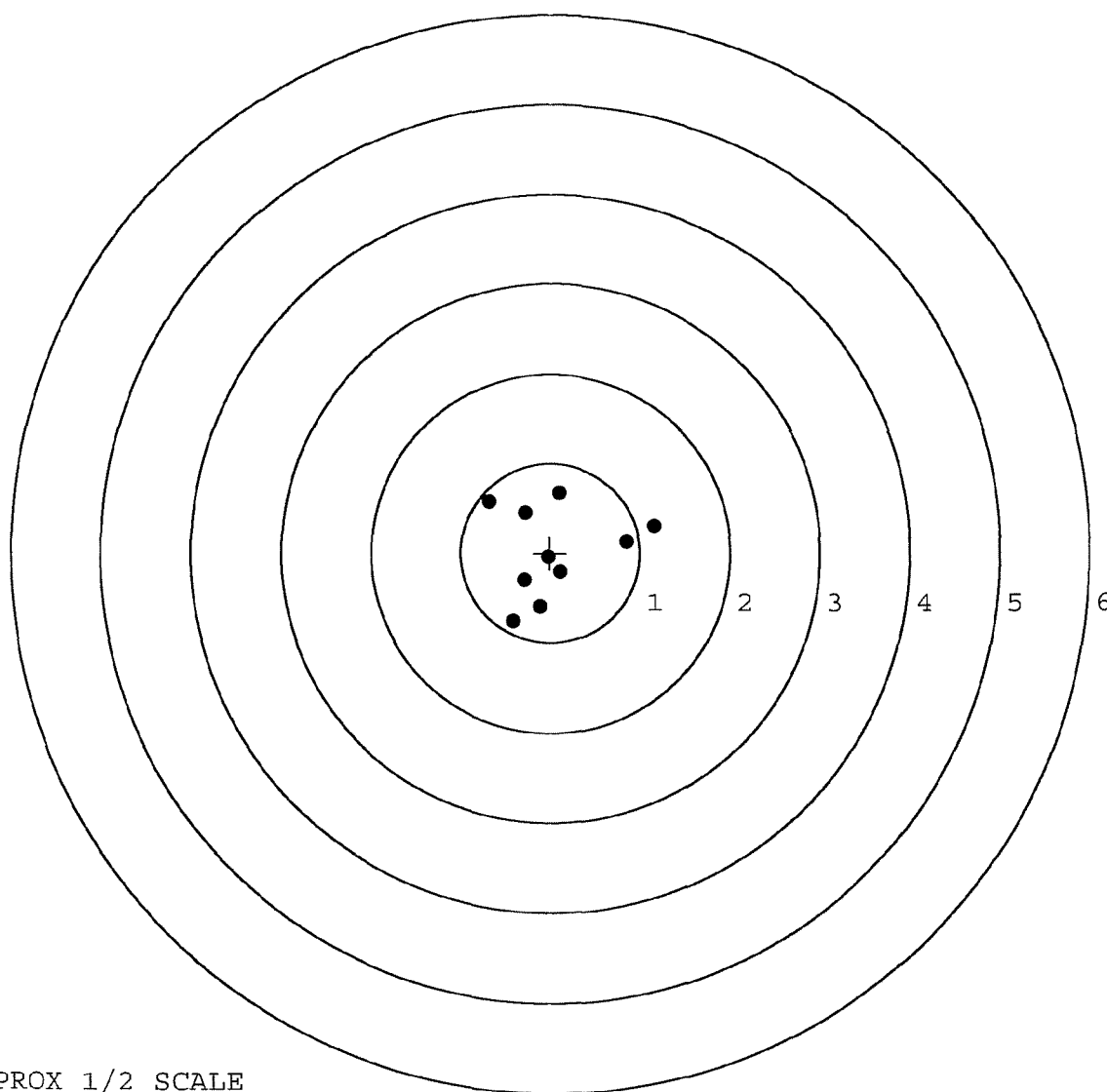


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6523493. __1
TARGET NUMBER: 2
FILE DATE: 02/21/2005
FILE TIME: 09:22

X CENTROID: 0.041
Y CENTROID: 0.018
POA TO CENTROID: 0.045
HORZ SPREAD: 1.843
VERT SPREAD: 1.442
GROUP SPREAD: 1.904
MIN RADIUS: 0.095
MAX RADIUS: 1.152
MEAN RADIUS: 0.646
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

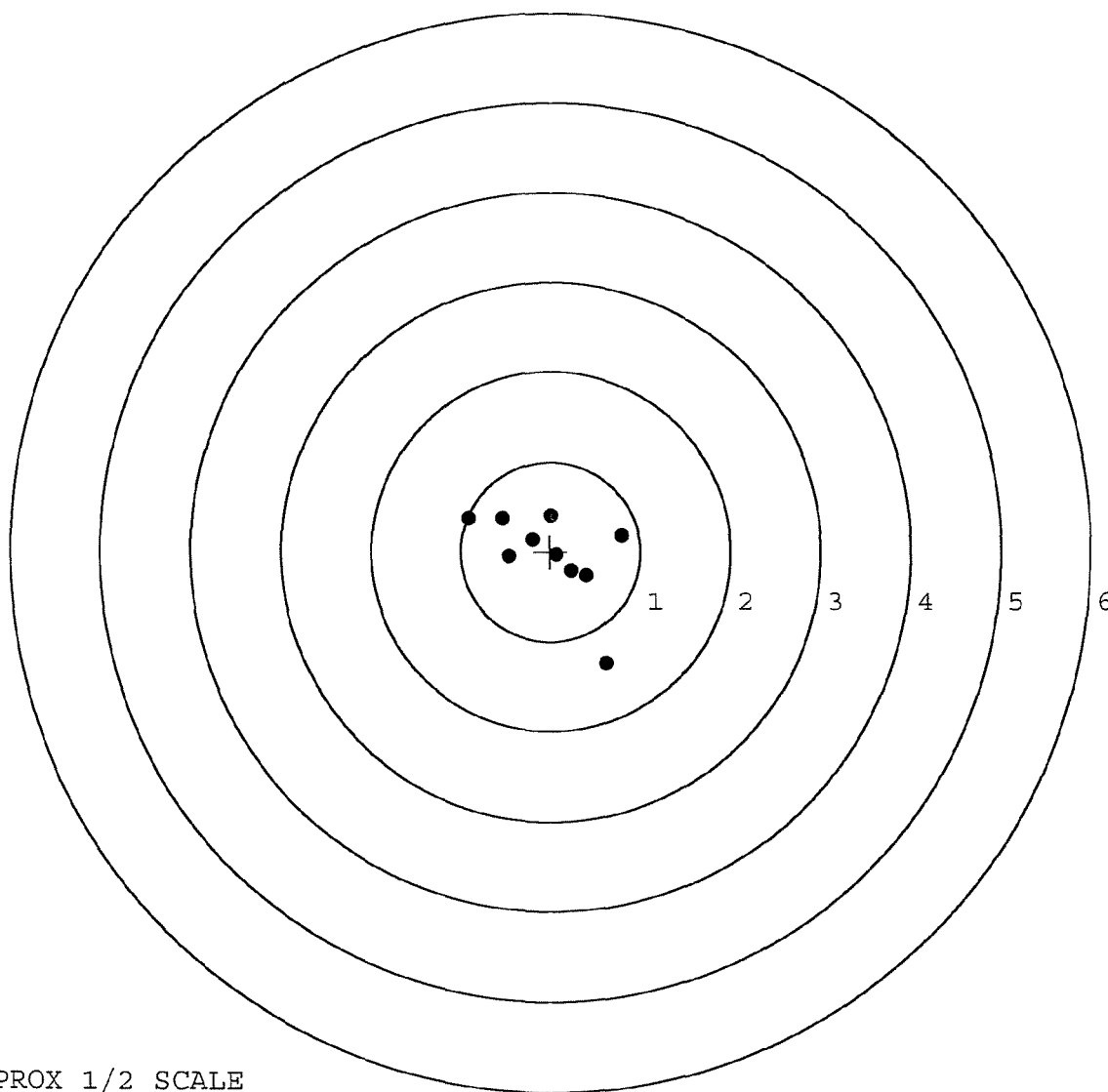
POINT#	X	Y
1:	1.157	0.305
2:	0.857	0.133
3:	0.101	0.672
4:	-0.284	0.451
5:	-0.686	0.578
6:	-0.025	-0.050
7:	0.114	-0.218
8:	-0.287	-0.309
9:	-0.119	-0.609
10:	-0.415	-0.770



SERIAL NUMBER: C6523493. __1
TARGET NUMBER: 3
FILE DATE: 02/21/2005
FILE TIME: 09:22

X CENTROID: 0.003
Y CENTROID: -0.037
POA TO CENTROID: 0.037
HORZ SPREAD: 1.714
VERT SPREAD: 1.649
GROUP SPREAD: 2.231
MIN RADIUS: 0.069
MAX RADIUS: 1.359
MEAN RADIUS: 0.586
IN 1 IN DIAMETER: 6
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.624	-1.246
2:	0.798	0.182
3:	0.006	0.403
4:	0.406	-0.269
5:	0.236	-0.215
6:	0.072	-0.040
7:	-0.196	0.136
8:	-0.463	-0.058
9:	-0.538	0.368
10:	-0.916	0.368

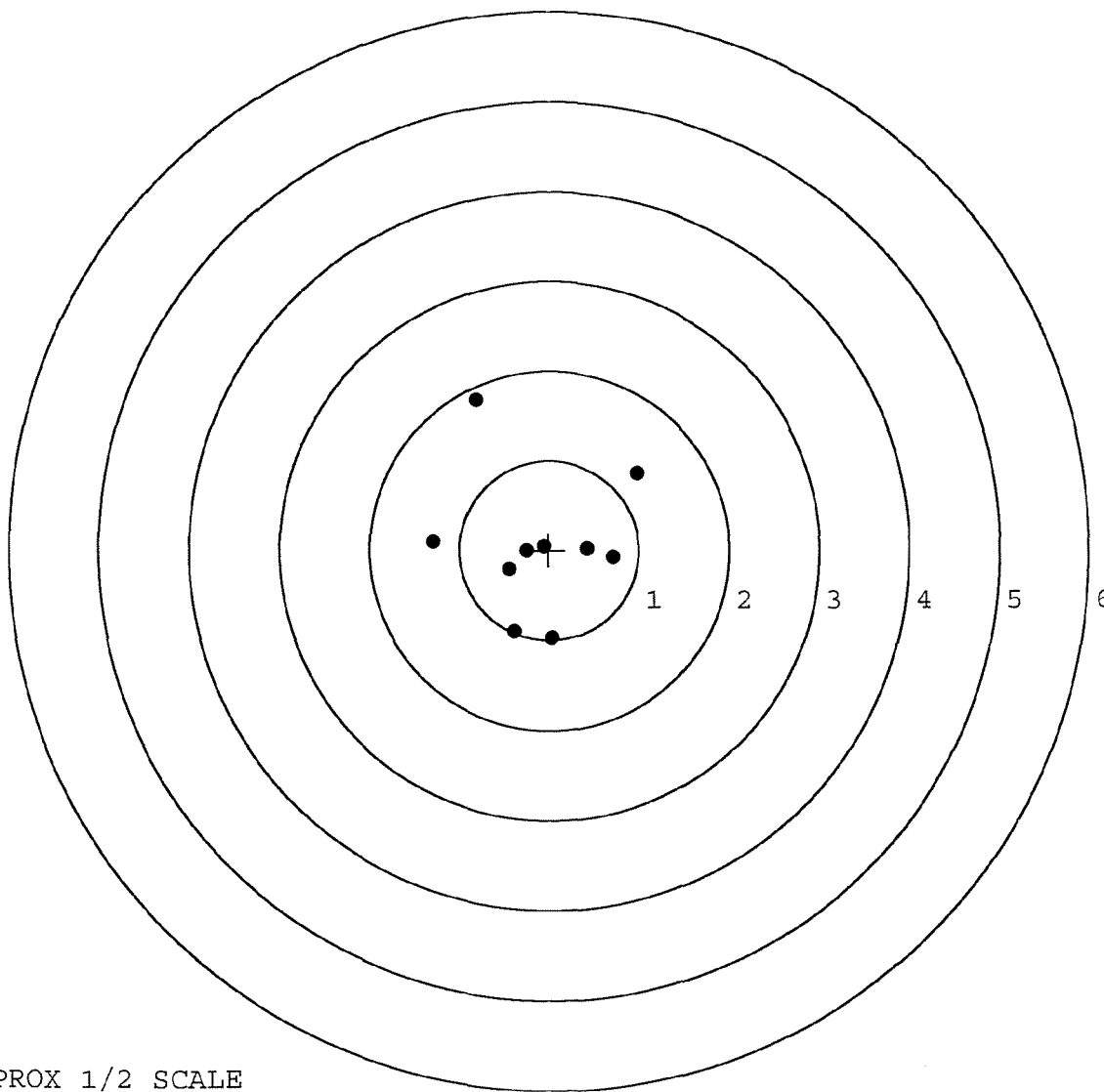


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6523493. __1
TARGET NUMBER: 4
FILE DATE: 02/21/2005
FILE TIME: 09:22

POINT#	X	Y
1:	0.716	-0.077
2:	0.430	0.024
3:	0.981	0.863
4:	-0.820	1.678
5:	-1.292	0.098
6:	0.035	-0.986
7:	-0.390	-0.909
8:	-0.441	-0.218
9:	-0.253	-0.008
10:	-0.054	0.043

X CENTROID: -0.109
Y CENTROID: 0.051
POA TO CENTROID: 0.120
HORZ SPREAD: 2.273
VERT SPREAD: 2.664
GROUP SPREAD: 2.798
MIN RADIUS: 0.055
MAX RADIUS: 1.776
MEAN RADIUS: 0.838
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 5
in 3 IN DIAMETER: 9

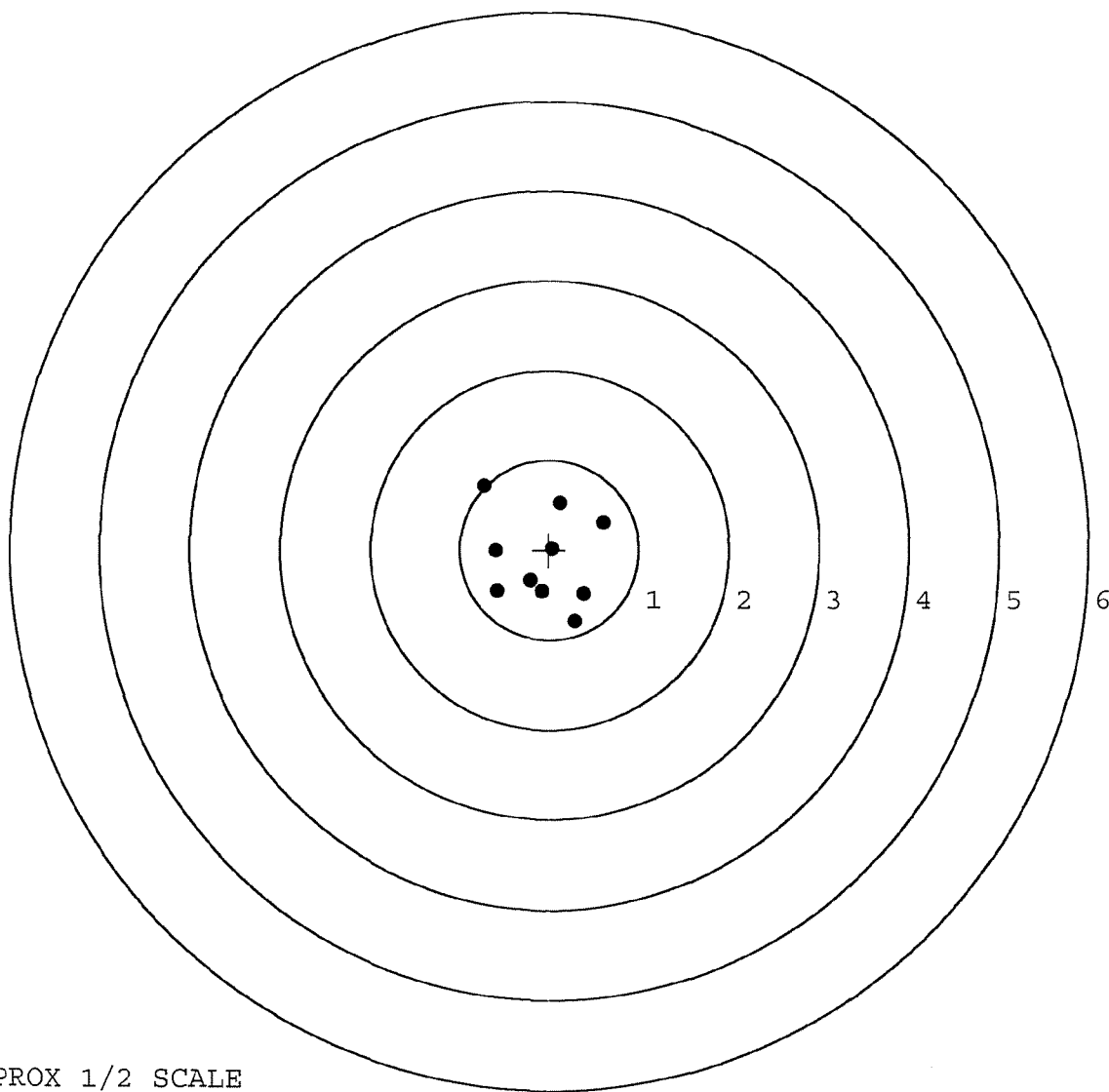


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6523493.___1
TARGET NUMBER: 5
FILE DATE: 02/21/2005
FILE TIME: 09:22

POINT#	X	Y
1:	0.604	0.303
2:	0.124	0.521
3:	-0.727	0.712
4:	0.290	-0.799
5:	0.387	-0.487
6:	0.038	0.016
7:	-0.082	-0.466
8:	-0.583	-0.466
9:	-0.599	-0.017
10:	-0.211	-0.342

X CENTROID: -0.076
Y CENTROID: -0.103
POA TO CENTROID: 0.128
HORZ SPREAD: 1.331
VERT SPREAD: 1.511
GROUP SPREAD: 1.821
MIN RADIUS: 0.164
MAX RADIUS: 1.043
MEAN RADIUS: 0.583
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

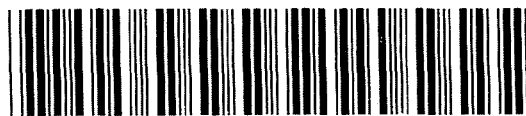
M-24 INSPECTION CHECKLIST
CONTRACT #: DAAE-20-02-D-0127

R & E NUMBER	92982				
SERIAL NUMBER	C6523493				
LOG-IN DATE	2-11-05				
INSPECT AND VERIFY:					
OPERATION #	OPERATION NAME	DATE	INITIAL		
550	DIS-ASSEMBLE GUN				
560 A	RE-BARREL				
B	DRILL AND TAP				
575	ASSEMBLE				
600	PROOF				
605	CHECK HEADSPACE				
610	DIS-ASSEMBLE GUN				
612	MAGNAFLUX				
615	ROLLMARK CALIBER				
618	ROTO-BLAST				
620	APPLY COATINGS				
625 A	FINAL ASSEMBLY				
B	TRIGGER PULL TEST				
C	SAFETY "ON" FORCE			3-9-05	K
D	SAFETY "OFF" FORCE			3-9-05	K
E	FIRING PIN INDENT	3-9-05	K		
640	TARGET	2-21-05	TRW		
655	FINAL INSPECT	3-9-05	AC		
660	PACK	3-11-05	DA		
		SHIP DATE			
QAR INSPECTION DATE					

Serial Number:

C6523493

Model: 700



RE00079504

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6523493.___0
FILE DATE AND TIME: 04/20/2004 06:55

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.017
The Average Y Centroid of the Five Target Set:	-0.127
The Average Point of Impact of the Five Target Set:	0.128
The Average Mean Radius of the Five Target Set:	0.645
The Distance from POA to Centroid Target #1:	0.129
The Distance from Centroid Target #2 to Centroid Target #1:	0.122
The Distance from Centroid Target #3 to Centroid Target #1:	0.092
The Distance from Centroid Target #4 to Centroid Target #1:	0.117
The Distance from Centroid Target #5 to Centroid Target #1:	0.081

SERIAL NUMBER: C6523493. __0

TARGET NUMBER: 1

FILE DATE: 04/20/2004

FILE TIME: 06:55

POINT#	X	Y
1:	0.508	-1.637
2:	0.194	-1.446
3:	0.458	-0.770
4:	-0.583	-0.388
5:	0.423	-0.009
6:	0.240	0.255
7:	-0.364	0.113
8:	-0.366	0.505
9:	-0.029	0.946
10:	-0.475	1.144

X CENTROID: 0.001

Y CENTROID: -0.129

POA TO CENTROID: 0.129

HORZ SPREAD: 1.091

VERT SPREAD: 2.781

GROUP SPREAD: 2.950

MIN RADIUS: 0.437

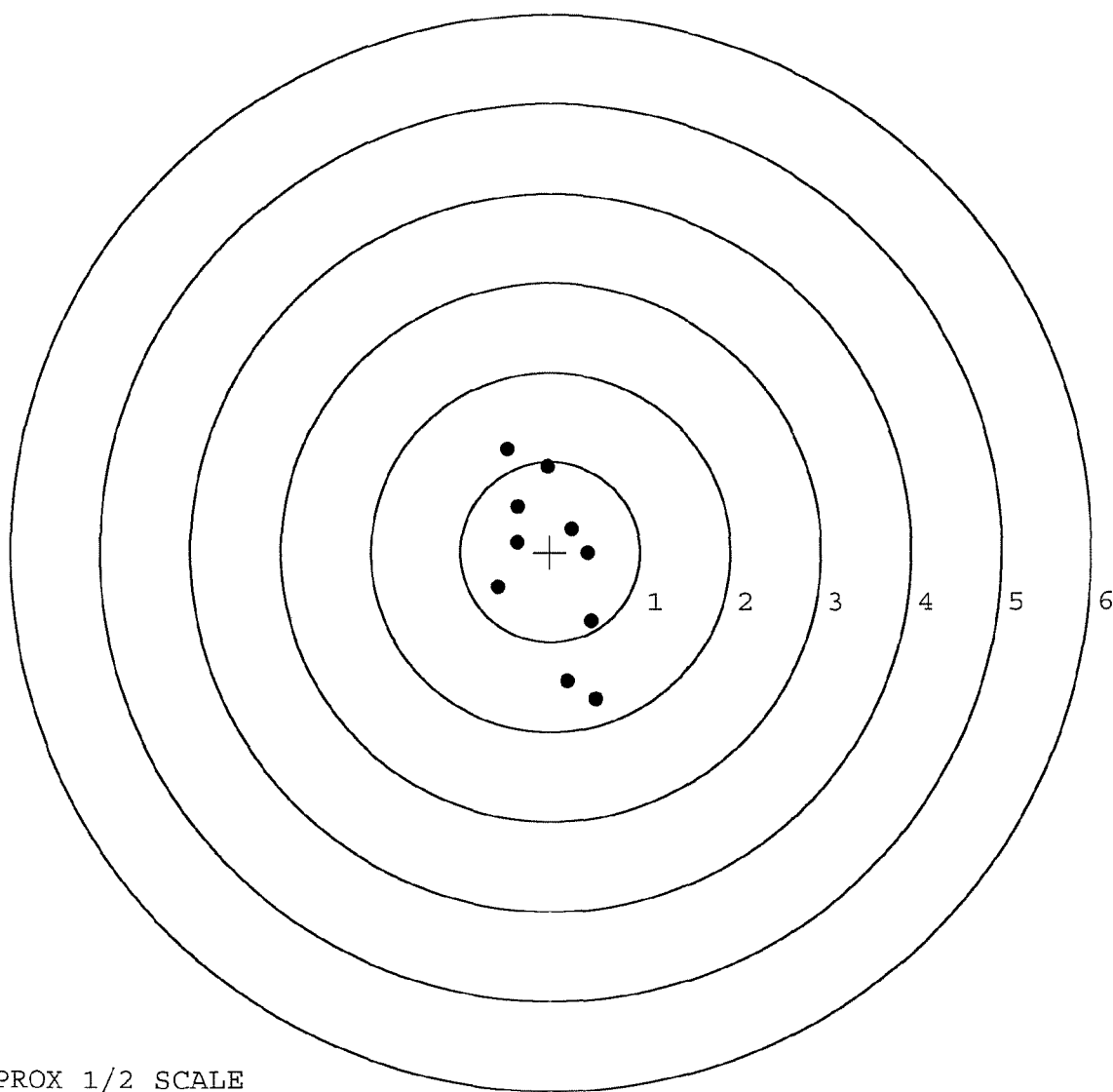
MAX RADIUS: 1.591

MEAN RADIUS: 0.884

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6523493. __0

TARGET NUMBER: 2

FILE DATE: 04/20/2004

FILE TIME: 06:55

X CENTROID: -0.007

Y CENTROID: -0.250

POA TO CENTROID: 0.250

HORZ SPREAD: 2.257

VERT SPREAD: 1.981

GROUP SPREAD: 2.627

MIN RADIUS: 0.042

MAX RADIUS: 1.576

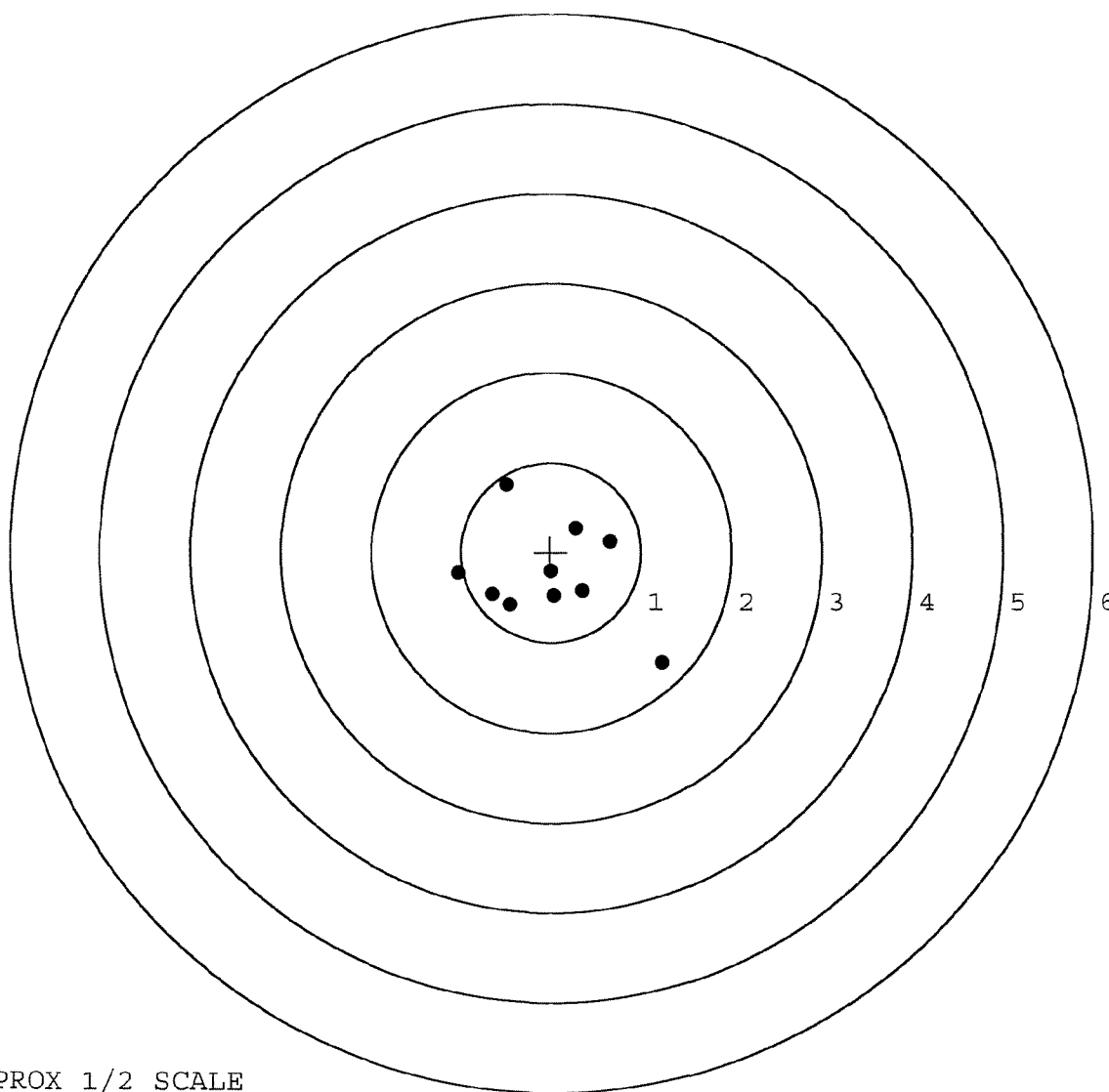
MEAN RADIUS: 0.701

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 9

POINT#	X	Y
1:	1.229	-1.228
2:	-0.457	-0.591
3:	-0.652	-0.468
4:	-1.028	-0.235
5:	-0.497	0.753
6:	-0.005	-0.208
7:	0.359	-0.431
8:	0.666	0.122
9:	0.277	0.270
10:	0.040	-0.484



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6523493. __0

TARGET NUMBER: 3

FILE DATE: 04/20/2004

FILE TIME: 06:55

POINT#	X	Y
1:	0.266	-0.488
2:	0.612	0.242
3:	0.016	0.352
4:	-0.216	0.000
5:	-0.719	-0.159
6:	-0.283	-0.495
7:	0.445	-0.266
8:	-0.045	-0.138
9:	0.179	0.123
10:	0.235	0.321

X CENTROID: 0.049

Y CENTROID: -0.051

POA TO CENTROID: 0.071

HORZ SPREAD: 1.331

VERT SPREAD: 0.847

GROUP SPREAD: 1.390

MIN RADIUS: 0.128

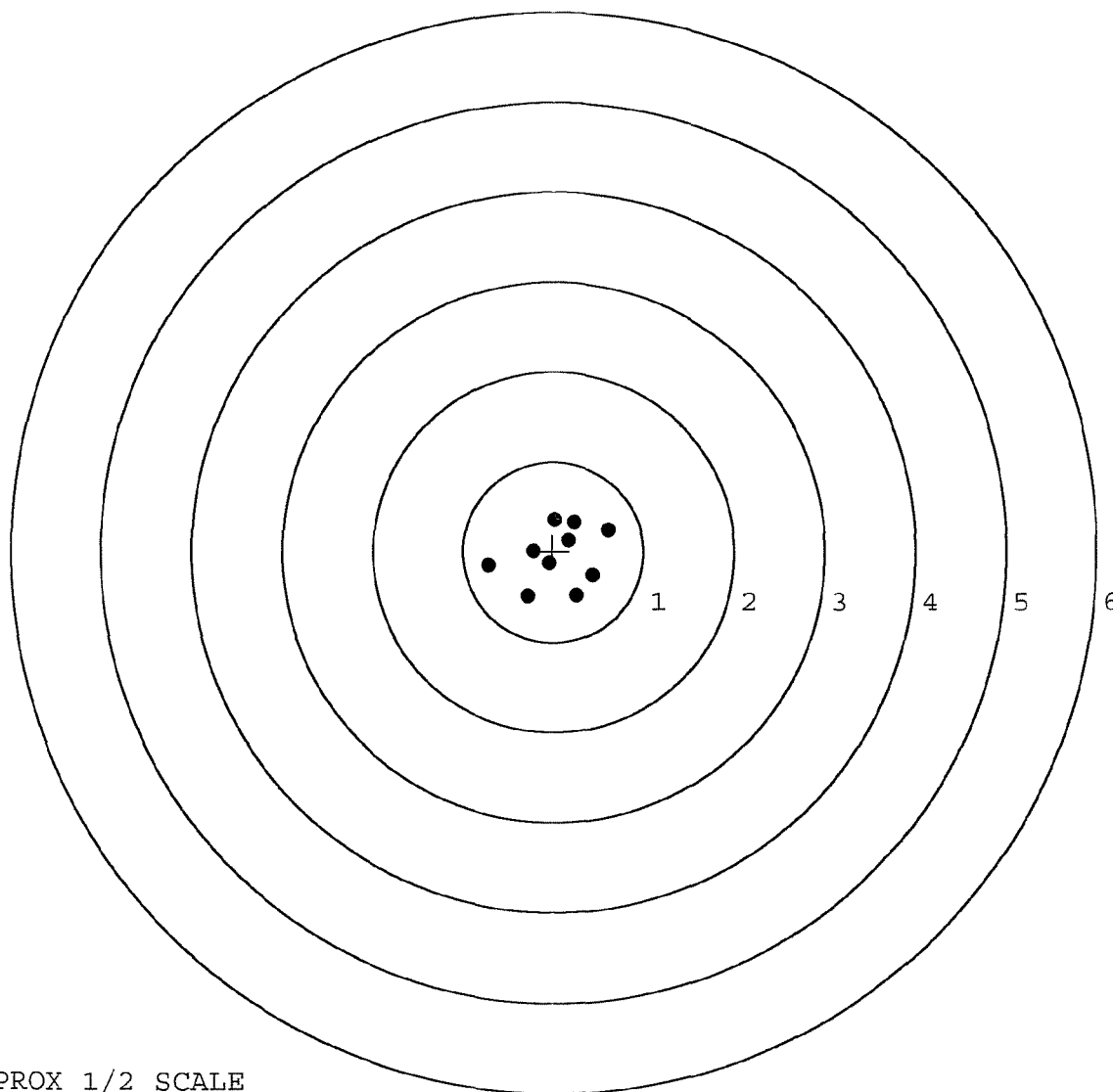
MAX RADIUS: 0.776

MEAN RADIUS: 0.434

IN 1 IN DIAMETER: 7

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6523493. __0

TARGET NUMBER: 4

FILE DATE: 04/20/2004

FILE TIME: 06:55

X CENTROID: -0.009

Y CENTROID: -0.012

POA TO CENTROID: 0.015

HORZ SPREAD: 1.339

VERT SPREAD: 1.668

GROUP SPREAD: 1.719

MIN RADIUS: 0.165

MAX RADIUS: 0.964

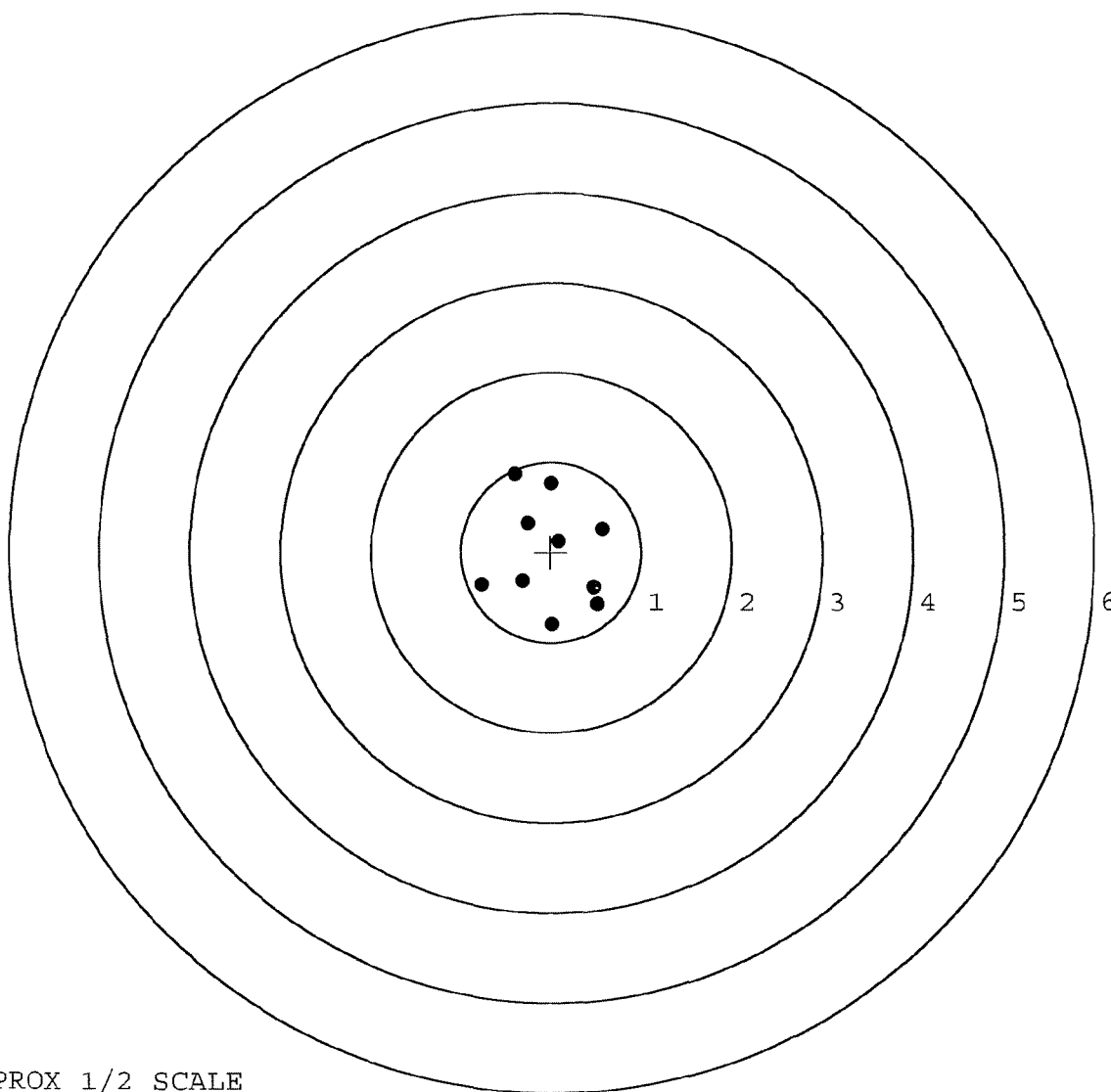
MEAN RADIUS: 0.642

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.518	-0.578
2:	0.476	-0.390
3:	0.009	-0.801
4:	-0.317	-0.325
5:	-0.768	-0.366
6:	0.571	0.261
7:	0.089	0.121
8:	-0.263	0.324
9:	-0.002	0.765
10:	-0.405	0.867



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6523493. __0

TARGET NUMBER: 5

FILE DATE: 04/20/2004

FILE TIME: 06:55

X CENTROID: 0.053

Y CENTROID: -0.191

POA TO CENTROID: 0.198

HORZ SPREAD: 1.799

VERT SPREAD: 1.191

GROUP SPREAD: 1.883

MIN RADIUS: 0.085

MAX RADIUS: 1.231

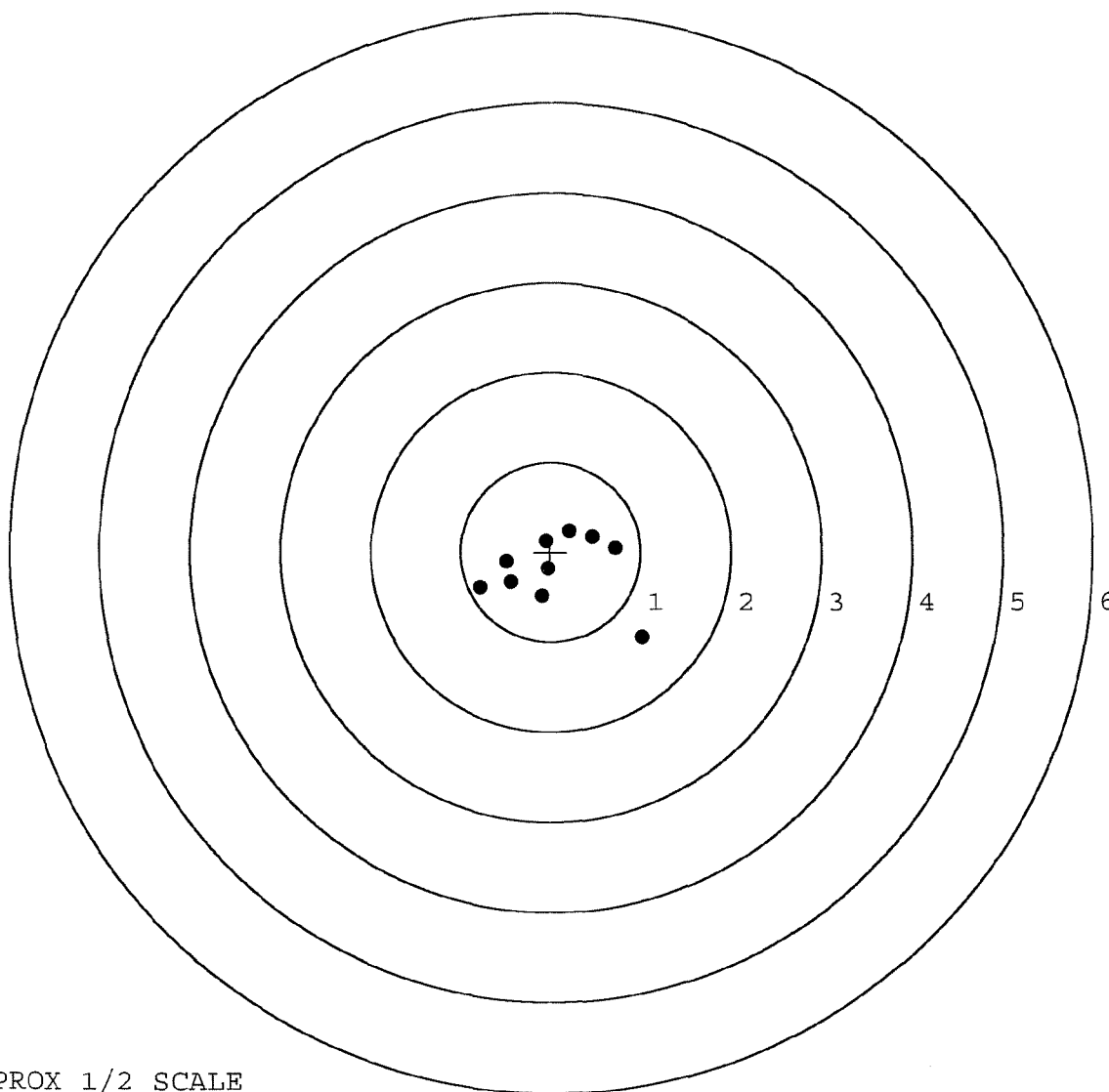
MEAN RADIUS: 0.564

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	1.019	-0.953
2:	0.721	0.047
3:	0.472	0.175
4:	0.208	0.238
5:	-0.048	0.122
6:	-0.032	-0.193
7:	-0.098	-0.500
8:	-0.490	-0.110
9:	-0.446	-0.337
10:	-0.780	-0.398



TARGET APPROX 1/2 SCALE

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

SERIAL # C6523493

INSPECTED BY: RTL

DATE REC'D: 4-1-04

DATE RET'D: RTL

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	78504		
SERIAL NUMBER	C6523493		
LOG-IN DATE	4-1-04		
INSPECT AND VERIFY:			
OPERATION #	OPERATION NAME	DATE	INITIAL
550	DIS-ASSEMBLE GUN	4-5-04	RTL
560 A	RE-BARREL	4-6-04	RTL
B	DRILL AND TAP	4-6-04	
575	ASSEMBLE	4-6-04	RTL
600	PROOF	4-12-04	RTL
605	CHECK HEADSPACE	4-12-04	RTL
610	DIS-ASSEMBLE GUN	4-13-04	RTL
612	MAGNAFLUX		OPERATOR DS
615	ROLLMARK CALIBER	4-13-04	RTL
618	ROTO-BLAST	4/14/04	DG
620	APPLY COATINGS	4-16	TA
625 A	FINAL ASSEMBLY	4-19-04	RTL
B	TRIGGER PULL TEST		
C	SAFETY "ON" FORCE		
D	SAFETY "OFF" FORCE		
E	FIRING PIN INDENT		
640	TARGET	4-20-04	AC
655	FINAL INSPECT	4-21-04	RTL
660	PACK	6-17-04	RA
		SHIP DATE	
	QAR INSPECTION DATE		




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

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

MODEL 700™ M24

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

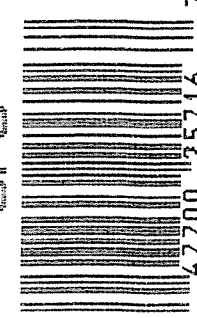
SERIAL NO.
C6523493

ORDER NO.
5716



5716 C6523493

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C 6523493

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		10/3/90	Kd
600	Proof		10/3/90	Kd
607	Check Headspace		10/2/90	Kd
610	Dis-assemble Gun		10/2/90	Kd
612	Magnaflux Barrel Action		10/5/90	KR
	Magnaflux Bolt		10/5/90	KR
615	Rollmark Caliber		10/5/90	GB
617	Drill and Tap Sight Holes		10/8/90	KB
618	Polish Barrel RB		10/9/90	WB
620	Apply Coatings (Barrel Action)		10-20-90	TH
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		11/8/90	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		11/14/90	KS
	C) Inspect Ejector Hole for Chamfer		11/18/90	KS
	D) Oil Firing Pin Ass'y		11/18/90	KS
	E) Adjust Trigger Pull to Min Setting and Stake		11-9-90	JK

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			11/9/90	WB
	G) Safety Off Force	2 1/2	2 1/2	2 1/2			11/9/90	WB
	H) Trigger Pull Test & Retainability						11-9-90	84
	I) Firing Pin Indent	.0205	.0205	.0205			11/9/90	WB
	J) Assemble Stock						11/9/90	KS
	K) Assemble Swivel Studs						11-19-90	DH
	L) Attach Front and Rear Sight Assemblies						11/9/90	KS
	M) Iron Sight Alignment						11/9/90	KS
	N) Detach Front & Rear Sights & place in numbered container						11/9/90	KS
	O) Attach Scope to Rifle						11/9/90	KS
	P) Detach & Attach Scope 20 Times						11/9/90	KS
640	Gallery Target & Test						11-12-90	KT
	A) Time						11-12-90	KT
	B) Malfunctions						11-12-90	KT
	C) Pierced Primers						11-12-90	KT
	D) Optical Clarity of Scope						11-12-90	KT
645	Inspect for Live Ammo						11-12-90	KT
655	Final Inspection							
	A) Headspace						11-19-90	DH
	B) Trigger Pull	2.78	2.81	2.65	2.90	2.73	11-19-90	DH
	C) Function						11-19-90	DH
660	Pack						12/18/90	NF

SWS TRIGGER PULL TEST

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

SERIAL NO. C6523493

DATE 11-9-90

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.46	2.47	2.39	2.78	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.45	2.39	2.42	2.81	
PULL #3	2.48	2.42	2.44	2.65	
PULL #4	2.46	2.43	2.45	2.90	
PULL #5	2.44	2.40	2.45	2.73	
TOTAL	12.29	12.11	12.15		
AVG.	2.458	2.422	2.43		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.27	3.27		
PULL #2	3.50	3.15		
PULL #3	3.47	3.14		
PULL #4	3.11	3.18		
PULL #5	3.36	3.15		
TOTAL	16.71	15.91		
AVG.	3.342	3.182		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.46	4.47		4.42
PULL #2	4.34	4.45		4.48
PULL #3	4.14	4.49		4.49
PULL #4	4.49	4.43		4.46
PULL #5	4.47	4.45		4.47
TOTAL	21.90	22.29		22.32
AVG.	4.38	4.458		4.464

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06523493
13 Nov 1990

CENTROIDAL DISTANCES

0 TO 1	.27012
1 TO 2	.345801
1 TO 3	.53217
1 TO 4	.51086
1 TO 5	.29345

$\frac{1}{N}$ <----POA

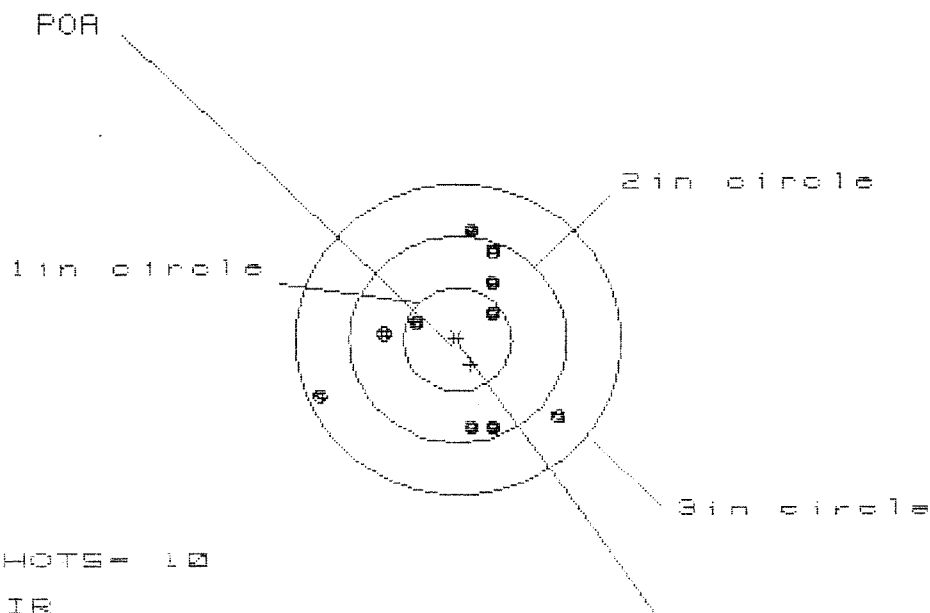
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0248
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0426
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .049293

THE AOR FOR THIS RIFLE IS: 1.009

13 Nov 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6523493

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1in = 2

2in = 7

3in = 10

HS= 2.179

VS= 1.907

GS= 2.186

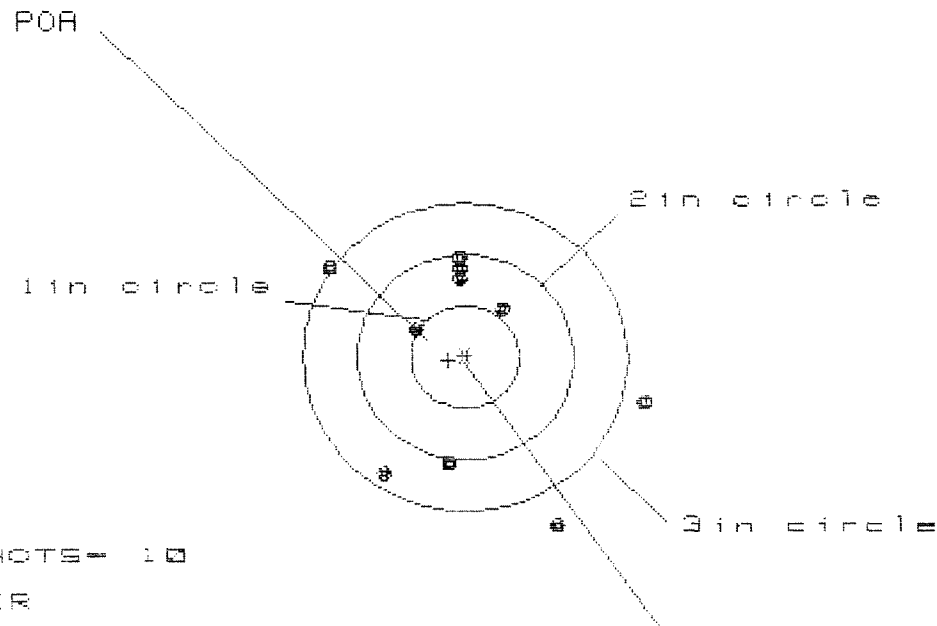
CENTROID #

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.874	.729	.272
MINIMUM X	:	-1.305	-.804	-.713
MAXIMUM Y	:	1.053	.989	.889
MINIMUM Y	:	-.854	-.918	-1.018
CENTROID X	:	-.122	.023	-.068
CENTROID Y	:	.241	.305	.405
POA TO CENTROID in.	:	.270	.305	.411
MIN RADIUS	:	.385	.298	.304
MEAN RADIUS	:	.835	.752	.687
MAX RADIUS	:	1.424	1.085	1.053
HORIZONTAL SPREAD	:	2.179	1.533	.985
VERTICAL SPREAD	:	1.907	1.907	1.907
EXTREME SPREAD	:	2.186	1.952	1.920
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

13 Nov 1998

FILE:/PATTERNING/CENTERFIRE_PATT/08523493

CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1in = 3

2in = 4

3in = 3

IS = 0.000

VS = 2.653

GS = 3.268

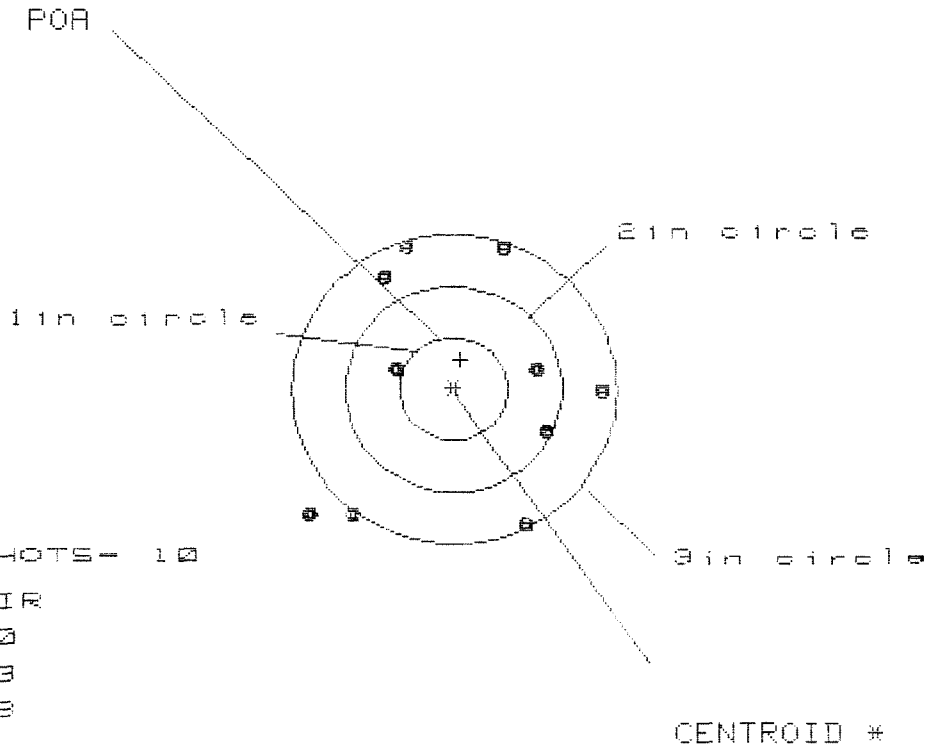
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.639	1.731	.664
MINIMUM X	:	-1.261	-1.169	-.953
MAXIMUM Y	:	1.005	.822	.749
MINIMUM Y	:	-1.648	-1.284	-1.357
CENTROID X	:	.154	.062	-.154
CENTROID Y	:	.033	.216	.289
POA TO CENTROID in.	:	.158	.225	.327
MIN RADIUS	:	.547	.382	.154
MEAN RADIUS	:	1.115	.976	.834
MAX RADIUS	:	1.845	1.827	1.423
HORIZONTAL SPREAD	:	2.900	2.900	1.617
VERTICAL SPREAD	:	2.653	2.106	2.106
EXTREME SPREAD	:	3.268	3.163	2.204
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		7	

13 Nov 1990

FILE:/PATTERNING/CENTERFIRE_PATT/06523493

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 0

2 in = 3

3 in = 8

HS= 2.636

VS= 2.662

GS= 3.100

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.321	1.175	1.034
MINIMUM X	:	-1.315	-1.128	-0.924
MAXIMUM Y	:	1.377	1.243	1.069
MINIMUM Y	:	-1.285	-1.419	-1.593
CENTROID X	:	-0.064	.082	.223
CENTROID Y	:	-.288	-.154	.020
POA TO CENTROID in.	:	.295	.174	.224
MIN RADIUS	:	.606	.582	.440
MEAN RADIUS	:	1.263	1.179	1.073
MAX RADIUS	:	1.785	1.791	1.631
HORIZONTAL SPREAD	:	2.636	2.303	1.958
VERTICAL SPREAD	:	2.662	2.662	2.662
EXTREME SPREAD	:	3.100	2.969	2.881
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		8	

13 Nov 1998

FILE:/PATTERNING/CENTERFIRE_PATT/06523493

CENTERFIRE PATTERNS

4

POA

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 2

2 in = 4

3 in = 8

HS= 2.656

VS= 1.339

GS= 2.657

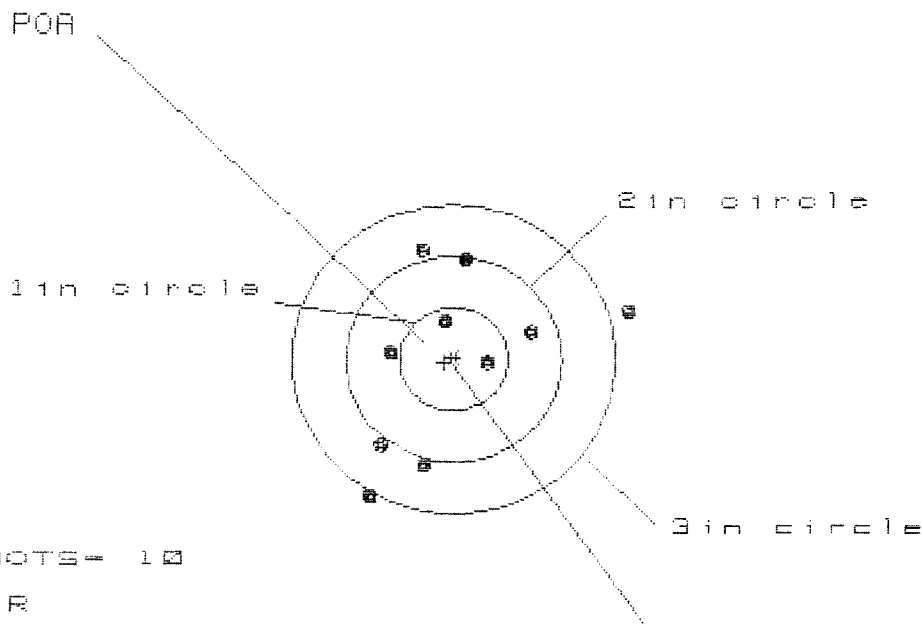
CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.127	.957	1.057
MINIMUM X	:	-1.529	-1.198	-1.097
MAXIMUM Y	:	.667	.656	.402
MINIMUM Y	:	-.672	-.683	-.601
CENTROID X	:	.071	.241	.140
CENTROID Y	:	-.232	-.221	-.303
POA TO CENTROID in.	:	.242	.327	.334
MIN RADIUS	:	.216	.120	.205
MEAN RADIUS	:	.862	.765	.734
MAX RADIUS	:	1.532	1.252	1.123
HORIZONTAL SPREAD	:	2.656	2.155	2.155
VERTICAL SPREAD	:	1.339	1.339	1.003
EXTREME SPREAD	:	2.657	2.286	2.177
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		9	

13 Nov 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6523493

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 8

HB= 2.362

VB= 2.474

GB= 3.019

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.621	.872	.802
MINIMUM X	:	-.741	-.561	-.604
MAXIMUM Y	:	1.093	1.149	.983
MINIMUM Y	:	-1.381	-1.325	-1.125
CENTROID X	:	.085	-.095	-.025
CENTROID Y	:	.033	-.023	.143
POB TO CENTROID in.	:	.091	.098	.145
MIN RADIUS	:	.344	.442	.303
MEAN RADIUS	:	.971	.889	.788
MAX RADIUS	:	1.696	1.439	1.161
HORIZONTAL SPREAD	:	2.362	1.433	1.406
VERTICAL SPREAD	:	2.474	2.474	2.108
EXTREME SPREAD	:	3.019	2.529	2.108
NUMBER IN ONE INCH CIRCLE =			2	
NUMBER IN TWO INCH CIRCLE =			5	
NUMBER IN THREE INCH CIRCLE =			8	