

C6523517

MODEL 700TM N24

Model **SWS** TM

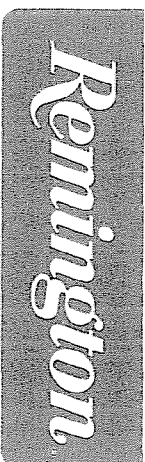
Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



09/16/08 13:27:23

Arms Services Repair & Estimate System

FileAdd RepairEstimate RepairExpedite RepairInquiryRepair ToolsCSR ToolsReportsTable MaintenanceSystem MaintenanceHelp

Repair Inquiry

Repair Number: RE00151231

Verify Repair

Serial: C6523517 Model M24 SWS Center Fire
Caliber: 7.62 NATO

Repairman:

Status: Closed 9/16/2008 2:28:33 PM

Address Information

Customer:Received FromReturn To:Received From

Name:ISD ARMSROOMISD ARMSROOM

Address 1:8TH DESERT STORM8TH DESERT STORM

Address 2:BLDG 5210 BAY DOOR #30PO Box:BLDG 5210 BAY DOOR #30PO Box:

City:FORT CAMPBELLFORT CAMPBELL

State:KYZip Code:42223Country:USState:KYZip Code:42223Country:US

FFL:

Contact / ConditionProblemsEstimateHistory / StatusShipping / Billing

Contact Information

Phone:NN

Fax:

Email:

Comments:

Received Condition

Fair

Condition Notes:

CSR Notes:

Accessories Received

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

Repair Search

Refresh

Close

naglelj

9/16/2008

3:27 PM

CAPS

NUM

INS

SCRL

start

8 M.

2 L.

3 M.

Ar...

Par...

Eas...

Sto...

3:27 PM

Serial Number: C6523517
Model M24 SWS

RE00151231

M-24 INSPECTION CHECKLIST
CONTRACT NO. DAAE20-02-C-0149

WPN ID: 151231
S/N: C6523517
DATE: 9-16-08

OPERATION #	OPERATION NAME	DATE	INITIAL
500	DIS-ASSEMBLE GUN	9-17-08	RTZ
505	RE-BARREL	9-22-08	RTZ
560	ASSEMBLE	9-22-08	RTZ
600	PROOF	9-22-08	RTZ
605	CHECK HEADSPACE	9-22-08	RTZ
610	DIS-ASSEMBLE GUN	9-22-08	RTZ
612	MAGNAFLUX	9/30/08	RTZ
610	DRILL AND TAP	9-23-08	RT
615	ROLLMARK CALIBER	9/30/08	RT
618	ROTO-BLAST		
620	APPLY COATINGS	10-1-08	RTZ
625	FINAL ASSEMBLY	10-7-08	RTZ
640	FUNCTION TEST AND	10-23-08	RTZ
650	TARGET	10-23-08	RTZ
	MALFUNCTION <u>BBMA</u>	CORRECTION	10-23-08
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	10-23-08
670	FINAL INSPECTION	10-23-08	RTZ
	A) HEADSPACE	10-23-08	RTZ
	B) TRIGGER PULL	2.57 2.59 2.51 2.53 2.53	10-23-08
	C) SAFETY ON FORCE	3.9 4.0 4.0	10-23-08
	D) SAFETY OFF FORCE	4.0 4.0 4.0	10-23-08
	E) FIRING PIN INDENT	.023 .022 .022	10-23-08
690	PACK		10/1/08

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

R & E NUMBER _____
SERIAL NUMBER CL6528517
LOG-IN DATE _____

OPERATION #	OPERATION NAME	DATE	INITIAL
500	DIS-ASSEMBLE GUN	10-14-08	RTZ
505	RE-BARREL	10-14-08	RTZ
560	ASSEMBLE	10-14-08	RTZ
600	PROOF	10-14-08	L.P.D.
605	CHECK HEADSPACE	10-14-08	L.P.D.
610	DIS-ASSEMBLE GUN	10-14-08	L.P.D.
612	MAGNAFLUX	10-17-08	(K)
510	DRILL AND TAP	10-15-08	SP
615	ROLLMARK CALIBER	10-17-08	RT
618	ROTO-BLAST	10/20/08	DG
620	APPLY COATINGS	1022	
625	FINAL ASSEMBLY		
640	FUNCTION TEST AND	PASS	FAIL
650	TARGET	PASS	FAIL
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
670	FINAL INSPECTION		
	A) HEADSPACE	PASS	FAIL
	B) TRIGGER PULL		
680	F) SAFETY ON FORCE		
	G) SAFETY OFF FORCE		
	I) FIRING PIN INDENT	.020	
690	PACK		

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6523517.___0
FILE DATE AND TIME: 10/23/2008 15:12

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.109
The Average Y Centroid of the Five Target Set:	0.033
The Average Point of Impact of the Five Target Set:	0.114
The Average Mean Radius of the Five Target Set:	0.639
The Distance from POA to Centroid Target #1:	0.143
The Distance from Centroid Target #2 to Centroid Target #1:	0.205
The Distance from Centroid Target #3 to Centroid Target #1:	0.139
The Distance from Centroid Target #4 to Centroid Target #1:	0.121
The Distance from Centroid Target #5 to Centroid Target #1:	0.171

SERIAL NUMBER: C6523517.___0

TARGET NUMBER: 1

FILE DATE: 10/23/2008

FILE TIME: 15:12

POINT#	X	Y
1:	0.990	0.795
2:	1.044	-0.363
3:	-1.258	0.364
4:	-1.008	0.089
5:	-0.822	-0.186
6:	-0.472	0.229
7:	-0.315	-0.436
8:	0.068	0.375
9:	0.407	0.374
10:	0.796	0.071

X CENTROID: -0.057

Y CENTROID: 0.131

POA TO CENTROID: 0.143

HORZ SPREAD: 2.302

VERT SPREAD: 1.231

GROUP SPREAD: 2.289

MIN RADIUS: 0.274

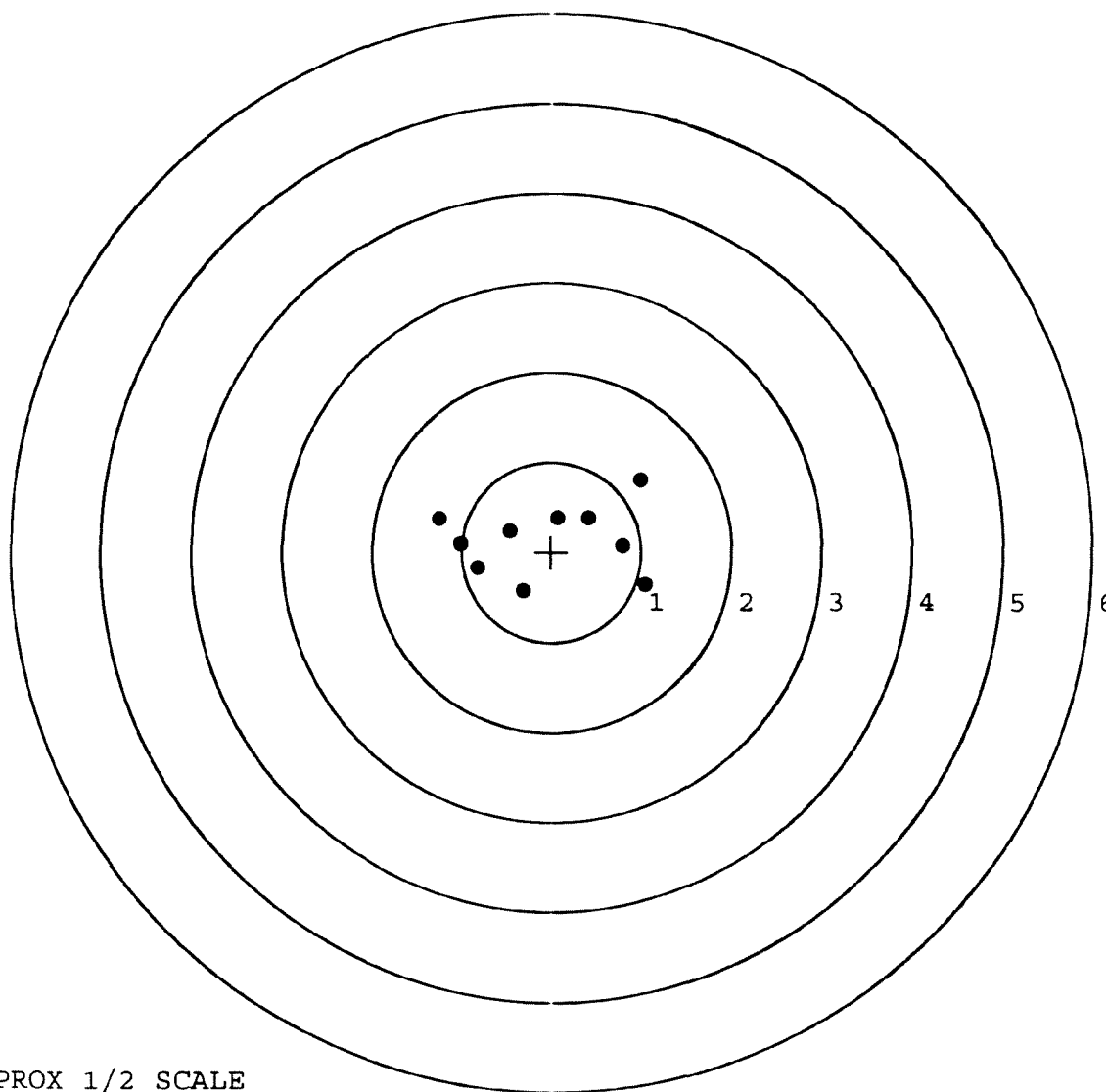
MAX RADIUS: 1.240

MEAN RADIUS: 0.815

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6523517.___0

TARGET NUMBER: 2

FILE DATE: 10/23/2008

FILE TIME: 15:12

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

1:	-1.403	0.008
----	--------	-------

2:	-0.568	0.524
----	--------	-------

3:	0.096	0.445
----	-------	-------

4:	0.477	0.272
----	-------	-------

5:	-0.536	0.018
----	--------	-------

6:	-0.435	0.005
----	--------	-------

7:	0.025	-0.660
----	-------	--------

8:	0.347	-0.136
----	-------	--------

9:	0.106	-0.360
----	-------	--------

10:	0.054	-0.411
-----	-------	--------

X CENTROID: -0.184

Y CENTROID: -0.029

POA TO CENTROID: 0.186

HORZ SPREAD: 1.880

VERT SPREAD: 1.184

GROUP SPREAD: 1.898

MIN RADIUS: 0.254

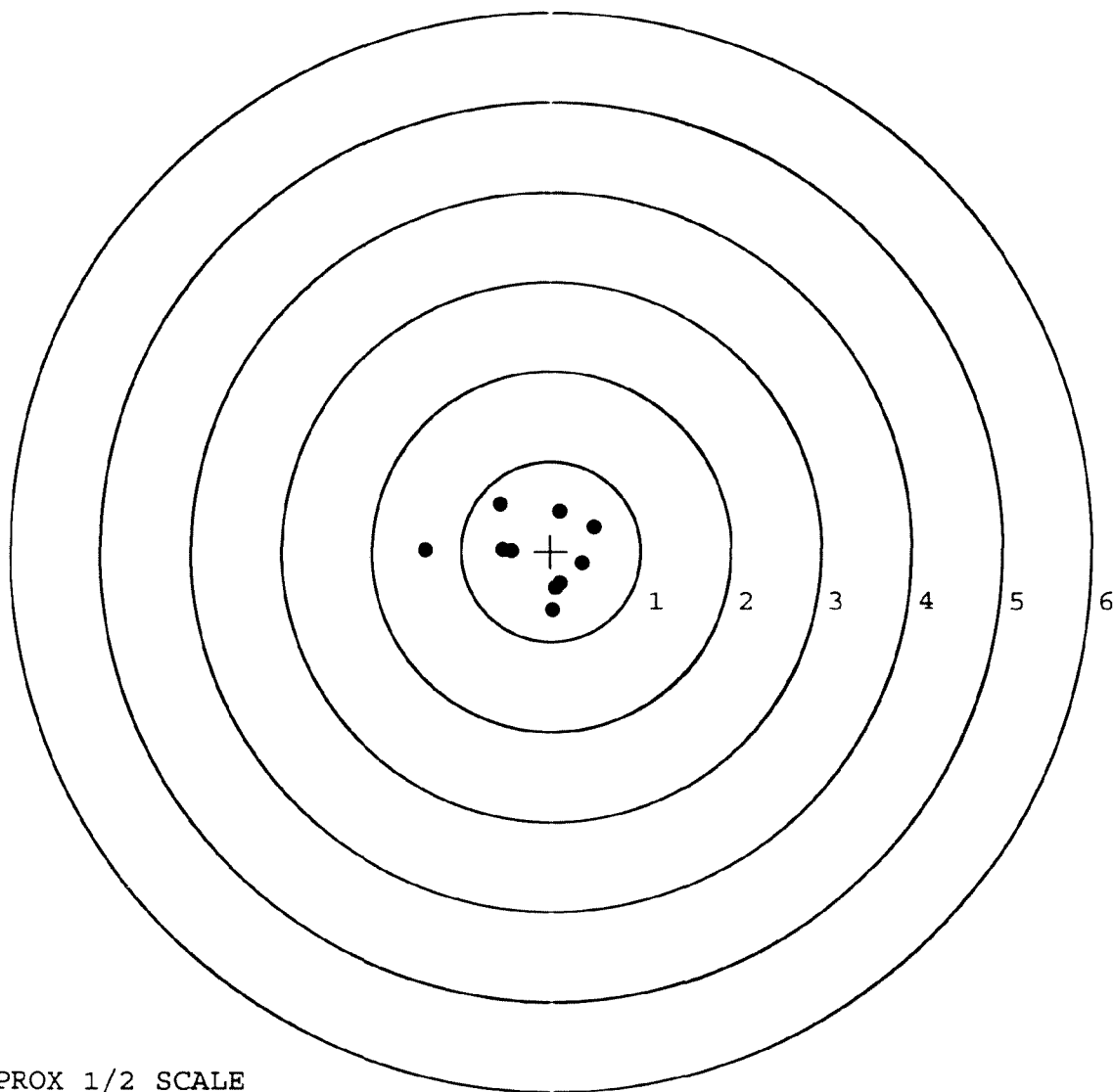
MAX RADIUS: 1.220

MEAN RADIUS: 0.587

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6523517.___0

TARGET NUMBER: 3

FILE DATE: 10/23/2008

FILE TIME: 15:12

POINT#	X	Y
1:	0.096	-0.783
2:	-0.991	-0.181
3:	-0.809	-0.062
4:	-0.614	0.260
5:	0.601	-0.078
6:	0.587	-0.052
7:	0.196	0.551
8:	0.220	0.349
9:	-0.034	0.211
10:	-0.052	-0.269

X CENTROID: -0.080

Y CENTROID: -0.005

POA TO CENTROID: 0.080

HORZ SPREAD: 1.592

VERT SPREAD: 1.334

GROUP SPREAD: 1.595

MIN RADIUS: 0.221

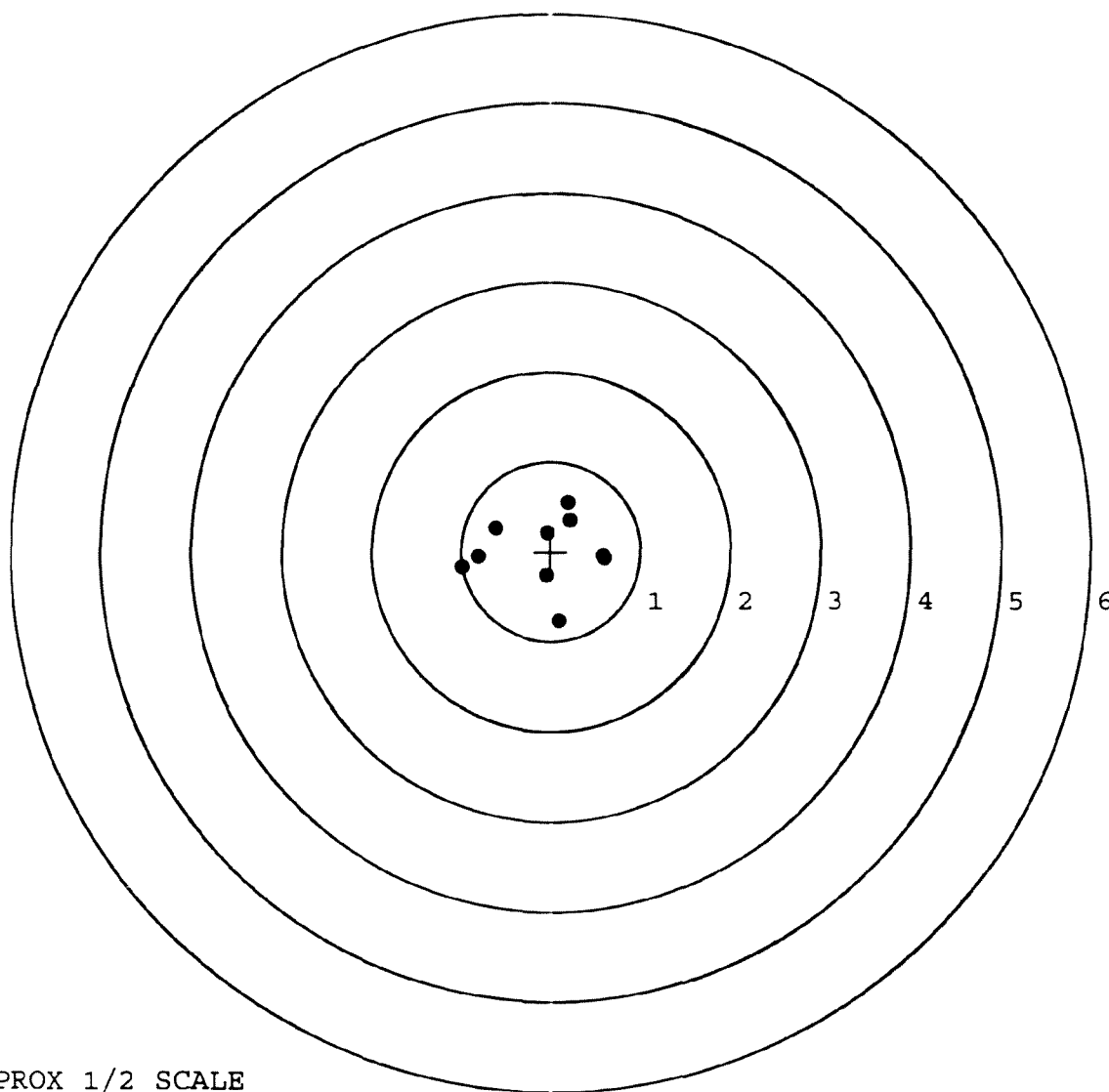
MAX RADIUS: 0.928

MEAN RADIUS: 0.598

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6523517. __0

TARGET NUMBER: 4

FILE DATE: 10/23/2008

FILE TIME: 15:12

POINT#	X	Y
1:	-0.772	0.914
2:	-0.089	0.966
3:	-0.526	0.300
4:	-0.695	-0.704
5:	-0.089	-0.580
6:	-0.029	-0.449
7:	0.011	-0.305
8:	-0.122	0.232
9:	0.142	0.345
10:	0.410	0.381

X CENTROID: -0.176

Y CENTROID: 0.110

POA TO CENTROID: 0.207

HORZ SPREAD: 1.182

VERT SPREAD: 1.670

GROUP SPREAD: 1.643

MIN RADIUS: 0.133

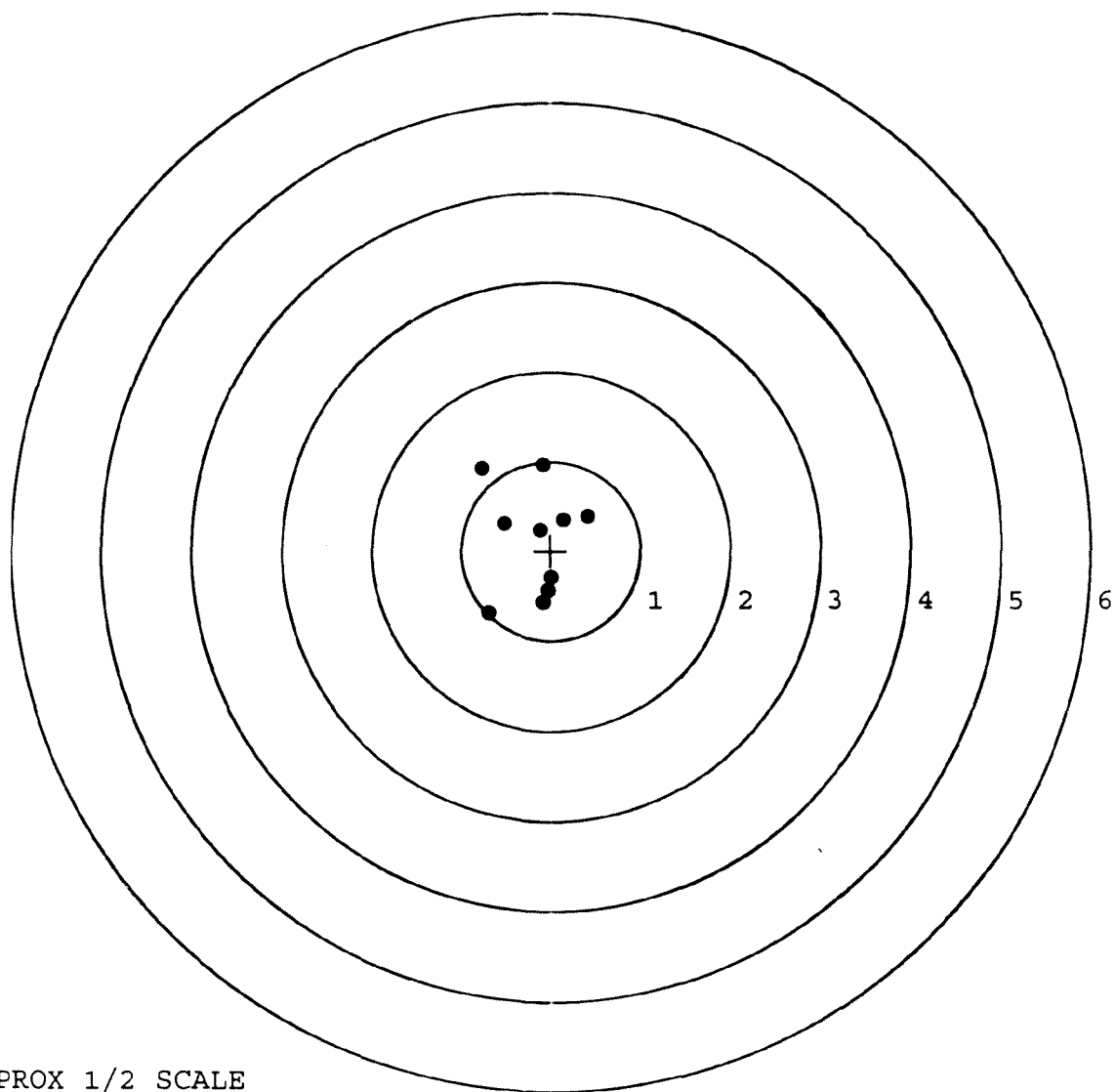
MAX RADIUS: 1.001

MEAN RADIUS: 0.613

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10

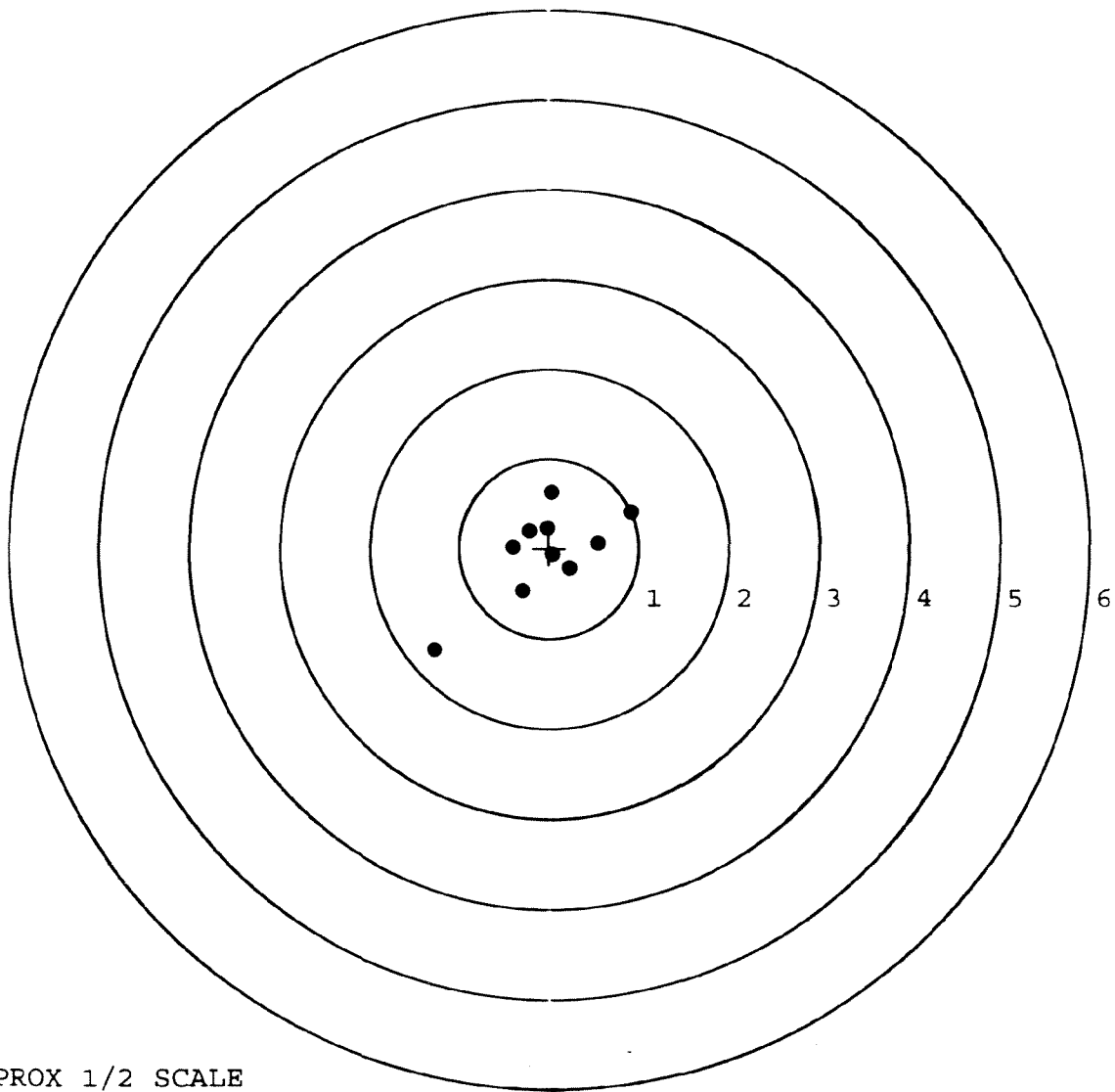


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6523517.___0
TARGET NUMBER: 5
FILE DATE: 10/23/2008
FILE TIME: 15:12

POINT#	X	Y
1:	-1.286	-1.130
2:	0.914	0.404
3:	0.033	0.624
4:	0.538	0.056
5:	-0.402	0.013
6:	-0.233	0.189
7:	-0.018	0.221
8:	0.227	-0.226
9:	0.044	-0.069
10:	-0.299	-0.474

X CENTROID: -0.048
Y CENTROID: -0.039
POA TO CENTROID: 0.062
HORZ SPREAD: 2.200
VERT SPREAD: 1.754
GROUP SPREAD: 2.682
MIN RADIUS: 0.097
MAX RADIUS: 1.650
MEAN RADIUS: 0.582
IN 1 IN DIAMETER: 5
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

RECEIVING AND ESTIMATING REPORT

COMMENTS

ORDER
R 99-09177

INITIAL CUSTOMER ORDER NO.

SWS 379

DATE RECEIVED

DATE OPENED

DATE CODE

SERIAL NUMBER

NEW SERIAL NUMBER

MODEL AND GRADE

04/07/99

04/08/99

WK 8-90

C6523517

700 7.62

M24

ACCESSORIES

W/STUDS

SCOPE BASE

FROM:

SHIP TO:

US ARMY
ATTN: JAMES C STARNES JR
GSC 5TH SFG (A)
FORT CAMPBELL

KY 42223

US ARMY
ATTN: JAMES C STARNES JR
GSC 5TH SFG (A)
FORT CAMPBELL

KY

42223

CUST NO: 208414 C.O.D.L

ACCOUNT NUMBER

ACCOUNT NUMBER N/C

WRITE ☐

PROM. DATE

ESTIMATED

VIA

DOOR

GUN CONDITION

- ☐ NEW
☐ LIGHTLY WORN
☐ WORN
☐ VERY WORN
☐ UNREPAIRABLE
☐ MARRED

REPAIR CHARGE

EXCISE

TAX

INSURANCE

UPS

PARCEL POST

TOTAL

CUSTOMER CONCERN

AMMO

FUNCTION

FINISH

ACCURACY

FIT

INSPECT

CYCLE

A1

B1

TRIGGER GROUP

B2

E1

F1

BOLT ASSY.

B3

E2

F2

BARREL ASSY.

B4

D1

E3

F3

REC. ASSY.

B5

D2

E4

F4

WOOD

C1

D3

E5

F5

METAL

C2

MAIN FAULT

PARTS

COMMENTS

Barrel
Extractor

96003
91816

REPAIRMAN

PROOF

CLEAN

TEST

TARGET

PATTERN

GALLERY TESTER

DATE

DATE

DATE

DATE

DATE

OFFICE COPY

RD6925 REV 7/97

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

M2400029541

Receipt Of Firearm(s) Delivered to the Plant for Repair
Firearm Checked For Live Ammunition []

File # 00373

Delivery Date 4/7/99

Customer Name (Print) US Army James C Starns Jr.
Address GSC 5th SFGCA Ft Campbell State KY Zip 42223
Phone Number (502)-798-2862/7932

Firearm Description Model 700 (M24) Cal./ Ga. 7.62
Serial Number C6523517

Stock/ Fore-end Condition circle the description
(Excellent; Good ; Fair; Poor; Fancy; Plain, Synthetic, Wood)

Comments on Stock/ Fore-end condition _____

Metal Condition circle the description
(Excellent; Good ; Fair; Poor; Fancy; Plain Stainless Steel)

Comments on Metal condition _____

Barrel Type (VT. Rib; Plain; Deer; Stainless Steel) Barrel length _____

List additional accessories IE Scope, Sling, Gun case and description;

Customer request: Reconditioning

Return Process Return to Clark St. Ent. [] Return via UPS [X]

By signing this receipt the person delivering the firearm understands to be the only person to receive the firearm upon completion of repairs.

Signature James C Starns Jr. Date 4/7/99
person delivering firearm

Signature [Signature] Date 4/7/99
security officer

Signature Greg Sanguine Date 4/7/99
arms service / CSR

Customer Pick Up Verification

I certify, I am the same person whom delivered the above described firearm to the Remington Ilion plant for repair and may lawfully possess a firearm in New York State

Signature _____ Date ____/____/____
person receiving firearm must be the same whom delivered

Signature _____ Date ____/____/____
security officer or other witness returning the firearm

Remington Test Lab, Ilion, N.Y.

Centroidal distance calculations for Rifle # c6523517
21 Jun 1999

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.039
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0006
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0390046

THE AMR FOR THIS RIFLE IS: 1.041

CENTROIDAL DISTANCES

Ø TO	1	.53238
1 TO	2	.932507
1 TO	3	.87262
1 TO	4	.565828
1 TO	5	.491904

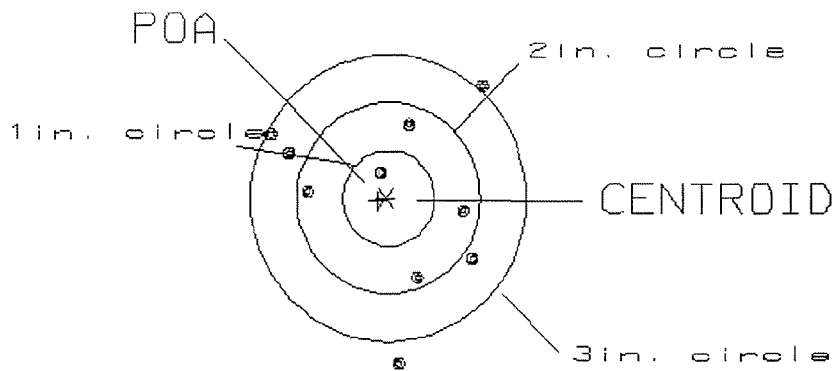
23
+5 <----POA
4
1

PATTERN #: ☐ 1 ☐
 POA TO CENTROID: .090
 MIN RADIUS : .266
 MEAN RADIUS : 1.062
 MAX RADIUS : 1.691
 CENTROID X : .085
 CENTROID Y : .029

21 Jun 1999

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6523517

CENTERFIRE PATTERN # 1



OF SHOTS= 10

IN CIRCLE

HS= 2.38

1

VS= 2.81

5

GS= 2.96

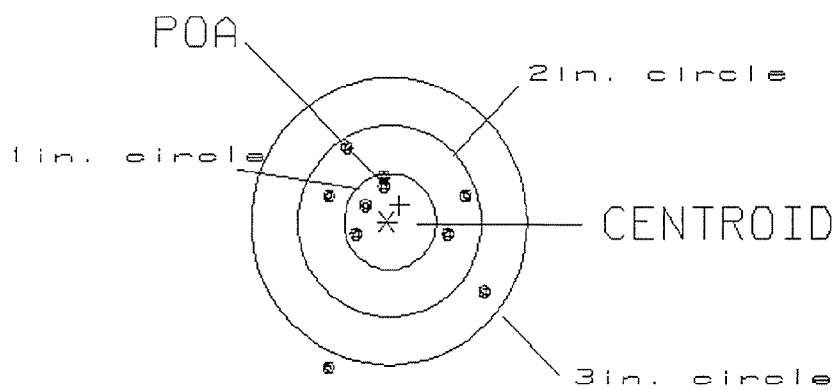
8

PATTERN #: ☐ 2 ☐
 POA TO CENTROID: .218
 MIN RADIUS : .322
 MEAN RADIUS : .777
 MAX RADIUS : 1.690
 CENTROID X : -.132
 CENTROID Y : -.173

21 Jun 1999

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6523517

CENTERFIRE PATTERN # 2



OF SHOTS= 10

IN CIRCLE

HS= 1.70

3

VS= 2.32

6

GS= 2.40

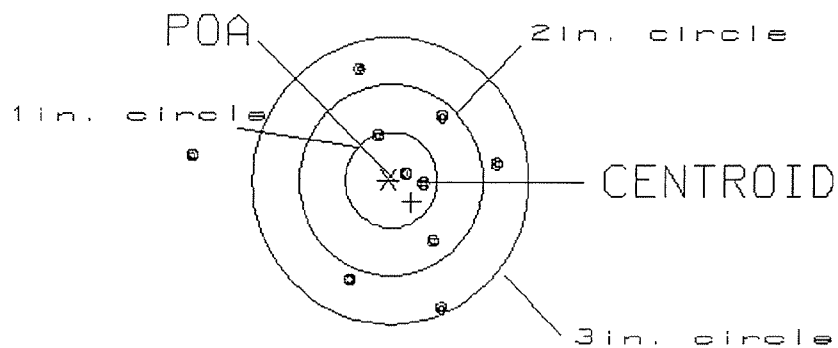
9

PATTERN #: ☐ 3 ☐
 POA TO CENTROID: .341
 MIN RADIUS : .152
 MEAN RADIUS : .964
 MAX RADIUS : 2.160
 CENTROID X : -.251
 CENTROID Y : .230

21 Jun 1999

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6523517

CENTERFIRE PATTERN # 3



OF SHOTS= 10

IN CIRCLE

HS= 3.26

2

VS= 2.48

5

GS= 3.26

9

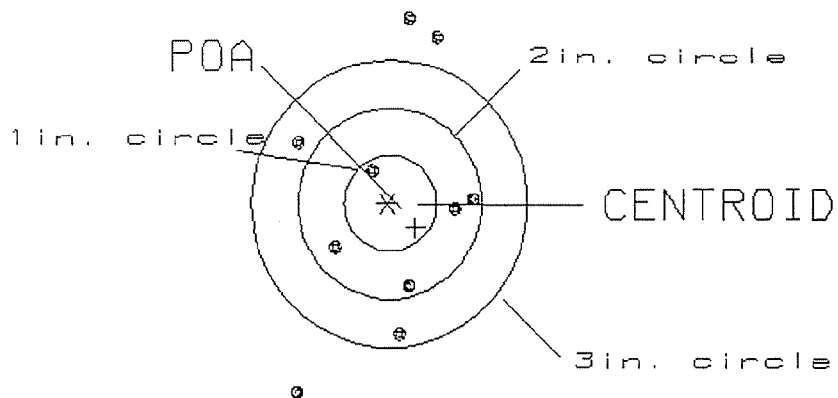
PATTERN #: ☐ 4 ☐

POA TO CENTROID: .400
 MIN RADIUS : .383
 MEAN RADIUS : 1.205
 MAX RADIUS : 2.186
 CENTROID X : -.305
 CENTROID Y : .259

21 Jun 1999

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6523517

CENTERFIRE PATTERN # 4



OF SHOTS= 10

IN CIRCLE

HS= 1.92

1

VS= 3.87

5

GS= 4.06

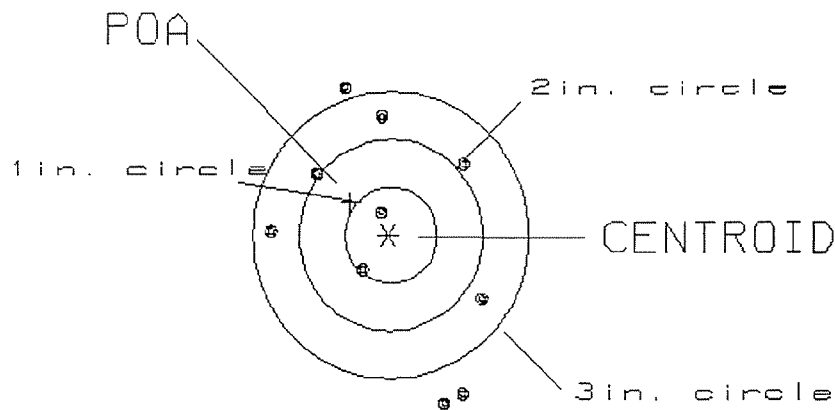
7

PATTERN #: 5
 POA TO CENTROID: .533
 MIN RADIUS : .268
 MEAN RADIUS : 1.195
 MAX RADIUS : 1.892
 CENTROID X : .408
 CENTROID Y : -.342

21 Jun 1999

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6523517

CENTERFIRE PATTERN # 5



OF SHOTS= 10

IN CIRCLE

HS= 2.30
 VS= 3.21
 GS= 3.45

1
 2
 7




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

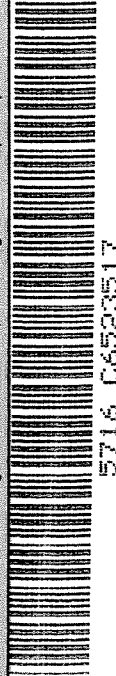
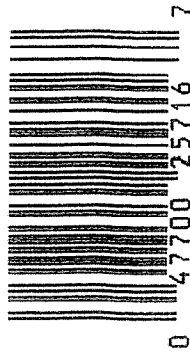
MODEL 700™ H24

SERIAL NO.
C6523517

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

ORDER NO.
5716

UPC



SWS TRIGGER PULL TEST

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

SERIAL NO. C6523517
DATE 9/4/40
TESTER W.B.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.48	2.28	2.75	2.52	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.49	2.35	2.72	2.49	
PULL #3	2.51	2.44	2.72	2.59	
PULL #4	2.53	2.51	2.77	2.49	
PULL #5	2.44	2.51	2.77	2.46	
TOTAL	12.45	12.09	13.73	12.55	
AVG.	2.49	2.42	2.74	2.51	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.28	3.46		
PULL #2	3.36	3.48		
PULL #3	3.40	3.42		
PULL #4	3.42	3.39		
PULL #5	3.43	3.42		
TOTAL	16.89	17.17		
AVG.	3.38	3.43		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.35	4.48		4.17
PULL #2	4.32	4.44		4.19
PULL #3	4.35	4.45		4.26
PULL #4	4.39	4.46		4.24
PULL #5	4.34	4.46		4.27
TOTAL	21.75	22.29		21.13
AVG.	4.35	4.46		4.22

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06523517
11 Sep 1990

CENTROIDAL DISTANCES

0 TO	1	.196023
1 TO	2	.182584
1 TO	3	.20283
1 TO	4	.174614
1 TO	5	.0486621

$\frac{1}{5}$ <----POA

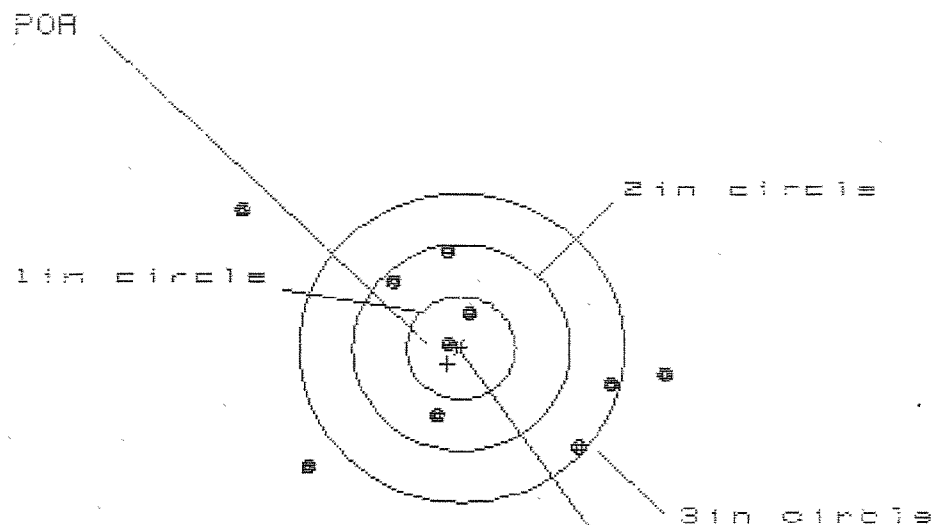
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0282
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1194
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .122685
THE AMR FOR THIS RIFLE IS: .8048

11 Sep 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6523517

CENTERFIRE PATTERNS

1



OF SHOTS= 10

IN CIR

1in = 2

2in = 5

3in = 7

HS= 3.854

VS= 2.486

GS= 4.165

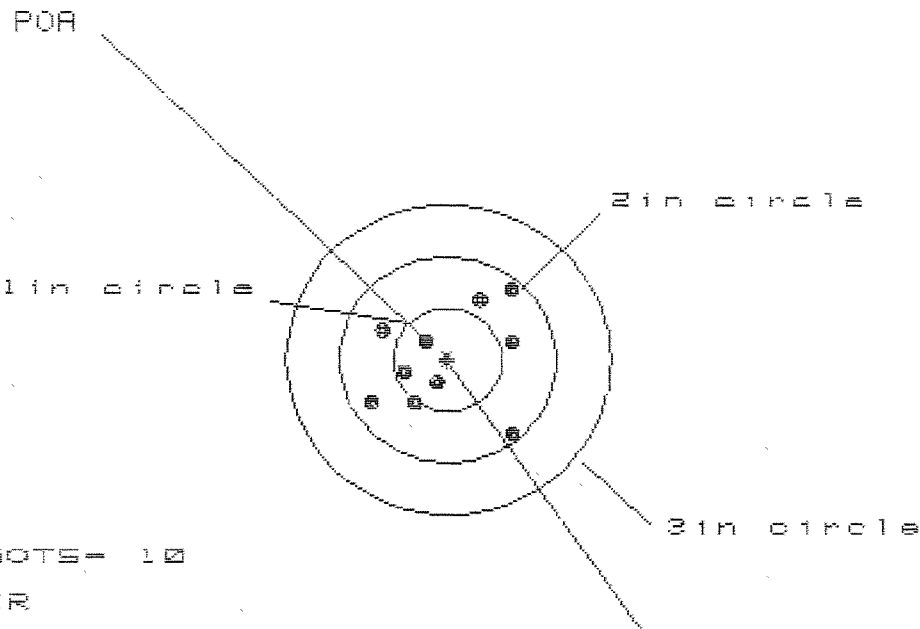
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.880	1.660	1.359
MINIMUM X	-1.974	-1.635	-1.427
MAXIMUM Y	1.318	1.134	1.120
MINIMUM Y	-1.168	-1.022	-1.036
CENTROID X	.120	.340	.132
CENTROID Y	.155	.009	.023
POA TO CENTROID in.	.196	.340	.134
MIN RADIUS	.174	.437	.269
MEAN RADIUS	1.206	1.095	.991
MAX RADIUS	2.374	1.928	1.763
HORIZONTAL SPREAD	3.854	3.295	2.786
VERTICAL SPREAD	2.486	2.156	2.156
EXTREME SPREAD	4.165	3.418	2.904
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	7		

11 Sep 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C6323517

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1 in = 4

2 in = 10

3 in = 10

HS= 1.292

VS= 1.396

GS= 1.647

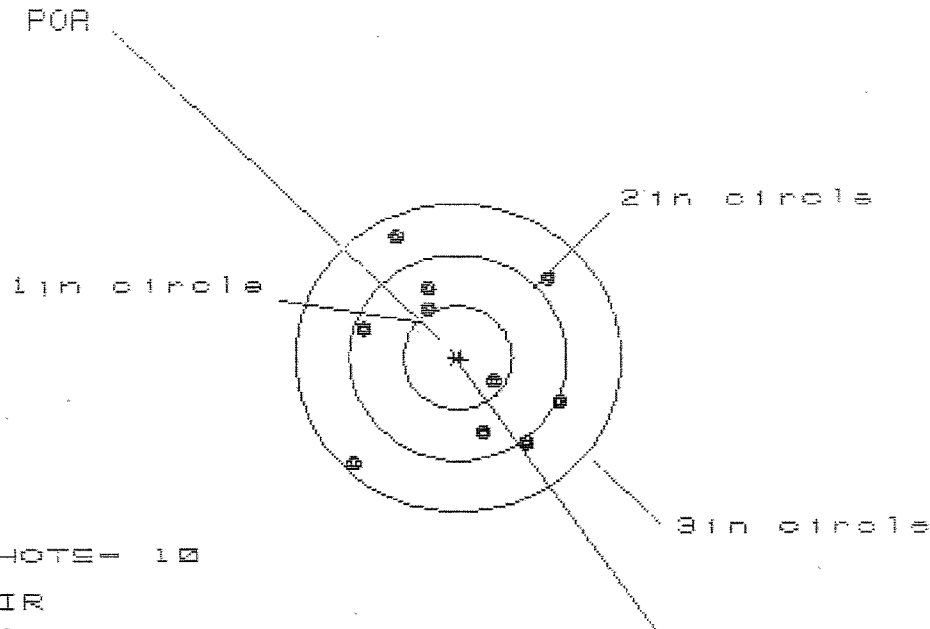
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.633	.696	.782
MINIMUM X	:	-.659	-.589	-.503
MAXIMUM Y	:	.661	.579	.548
MINIMUM Y	:	-.735	-.467	-.394
CENTROID X	:	.004	-.066	-.152
CENTROID Y	:	.014	.096	.023
POA TO CENTROID in.	:	.015	.117	.154
MIN RADIUS	:	.242	.148	.157
MEAN RADIUS	:	.592	.536	.465
MAX RADIUS	:	.970	.896	.797
HORIZONTAL SPREAD	:	1.292	1.285	1.285
VERTICAL SPREAD	:	1.396	1.046	.942
EXTREME SPREAD	:	1.647	1.647	1.399
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		10	
NUMBER IN THREE INCH CIRCLE	=		10	

11 Sep 1988

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 10

HS= 1.917

VS= 2.114

GS= 2.506

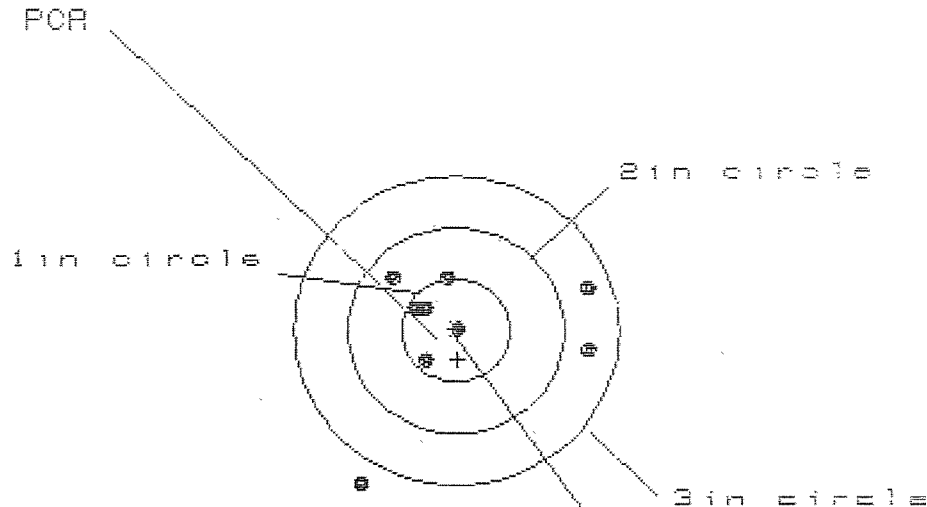
CENTROID #

PATTERN #	3	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.931	.821	.736
MINIMUM X	-.986	-1.024	-1.109
MAXIMUM Y	1.131	1.022	.747
MINIMUM Y	-.983	-.960	-.832
CENTROID X	-.034	.076	.162
CENTROID Y	.023	.132	.004
POR TO CENTROID in.	.040	.152	.162
MIN RADIUS	.414	.416	.262
MEAN RADIUS	.926	.862	.799
MAX RADIUS	1.392	1.230	1.139
HORIZONTAL SPREAD	1.917	1.845	1.845
VERTICAL SPREAD	2.114	1.982	1.579
EXTREME SPREAD	2.506	2.319	1.972
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		10	

11 Sep 1998

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1 in = 5

2 in = 7

3 in = 8

US= 2.126

VS= 1.976

GS= 2.853

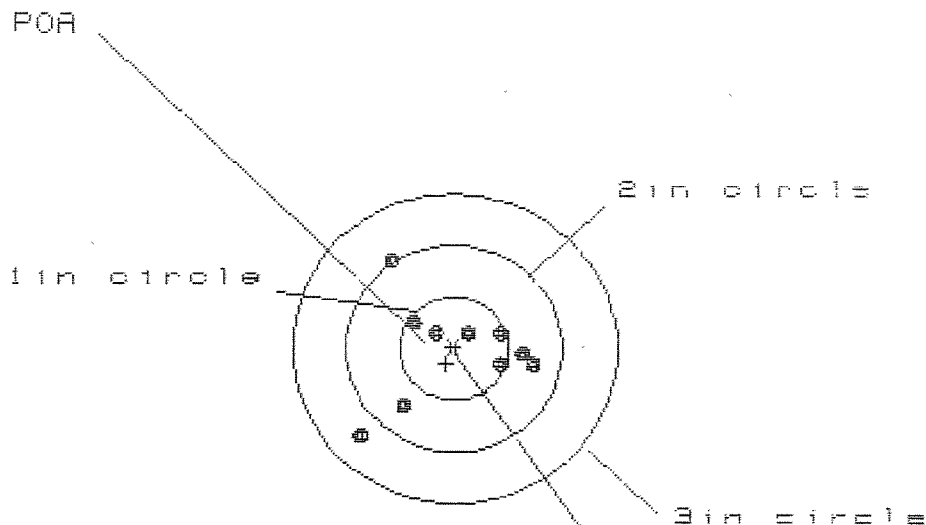
CENTROID #

PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.240	1.142	1.230
MINIMUM X	-.886	-.676	-.533
MAXIMUM Y	.529	.369	.405
MINIMUM Y	-1.447	-.458	-.421
CENTROID X	-.021	.077	-.065
CENTROID Y	.285	.445	.408
POA TO CENTROID in.	.285	.452	.414
MIN RADIUS	.040	.140	.109
MEAN RADIUS	.682	.588	.463
MAX RADIUS	1.696	1.179	1.282
HORIZONTAL SPREAD	2.126	1.818	1.764
VERTICAL SPREAD	1.976	.827	.827
EXTREME SPREAD	2.853	1.910	1.910
NUMBER IN ONE INCH CIRCLE =	5		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	9		

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in = 5

2 in = 8

3 in = 10

HS= 1.599

VS= 1.671

GS= 1.721

CENTROID *

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.730	.634	.547
MINIMUM X	-.869	-.695	-.612
MAXIMUM Y	.864	.774	.297
MINIMUM Y	-.807	-.599	-.502
CENTROID X	.072	.168	.255
CENTROID Y	.147	.237	.140
POR TO CENTROID in.	.163	.290	.291
MIN RADIUS	.216	.097	.196
MEAN RADIUS	.618	.526	.455
MAX RADIUS	1.186	1.041	.791
HORIZONTAL SPREAD	1.599	1.329	1.159
VERTICAL SPREAD	1.671	1.373	.799
EXTREME SPREAD	1.721	1.689	1.220
NUMBER IN ONE INCH CIRCLE =	5		
NUMBER IN TWO INCH CIRCLE =	8		
NUMBER IN THREE INCH CIRCLE =	10		

C Ad - 70C

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C 6523517

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		8-21-90	DB
600	Proof		8-21-90	DB
607	Check Headspace		8-21-90	DB
610	Dis-assemble Gun		8-21-90	DB
612	Magnaflux Barrel Action	grv new MM	8/23/90	KCR
	Magnaflux Bolt		8/21/90	KCR
615	Rollmark Caliber		8/21/90	GS
617	Drill and Tap Sight Holes			
618	Polish Barrel			
620	Apply Coatings (Barrel Action)		8-20-90	TA
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		8/31/90	Rw
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/31/90	Rw
	C) Inspect Ejector Hole for Chamfer		8/31/90	Rw
	D) Oil Firing Pin Ass'y		8/31/90	Rw
	E) Adjust Trigger Pull to Min Setting and Stake		9/4/90	WB

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4 1/2	4 1/2	4 1/2			9/4/90	WLB
	G) Safety Off Force	7 1/2	7 1/2	7 1/2			9/4/90	WLB
	H) Trigger Pull Test & Retainability						9/4/90	WLB
	I) Firing Pin Indent	.023	.023	.023			9/4/90	WLB
	J) Assemble Stock						9/10/90	RW
	K) Assemble Swivel Studs						9/13/90	428
	L) Attach Front and Rear Sight Assemblies						9/10/90	RW
	M) Iron Sight Alignment						9/10/90	RW
	N) Detach Front & Rear Sights & place in numbered container						9/10/90	RW
	O) Attach Scope to Rifle						9/10/90	RW
	P) Detach & Attach Scope 20 Times						9/10/90	RW
640	Gallery Target & Test						9/11/90	NF
	A) Time						"	NF
	B) Malfunctions						"	NF
	C) Pierced Primers						"	NF
	D) Optical Clarity of Scope						"	NF
645	Inspect for Live Ammo						9/11/90	NF
655	Final Inspection							
	A) Headspace						9/13/90	428
	B) Trigger Pull	2.52	2.49	2.59	2.49	2.46	9-12-90	9/
	C) Function						9/13/90	428
660	Pack						9-18-90	9/