

C6225068

New Action

E 6394544

MODEL 700™ M24

Model 700 M24™

Action

Barrel Length

Capacity

Order No. 5716

*Includes 1 in chamber.



Smith & Wesson®

RECEIVING AND ESTIMATING REPORT				COMMENTS			ORDER R 96-02148	
INITIAL	CUSTOMER ORDER NO.			SNIPER M-24				
FPS	10802							
DATE RECEIVED	DATE OPENED	DATE CODE	SERIAL NUMBER	NEW SERIAL NUMBER	MODEL AND GRADE			
01/17/96	01/17/96	PM 6-92	C6225068		700 7.62		NATO	
ACCESSORIES		M/STUDS		SOFT CASE		SCOPE BASE		

FROM:

DEMAREST, WARREN C.
D CO. 2ND BN. 1ST SWTG
FT BRAGG

NC 20307

SHIP TO:

~~COMMANDER~~
~~DEWAREST, WARREN G.~~
D CO. 2ND BN. 1ST SWTG
FT BRAGG

NC

20307

CUST NO: 435950 C.O.D

ACCOUNT NUMBER		ACCOUNT NUMBER N/C		PROM. DATE		ESTIMATED		VIA	
GUN CONDITION				WRITE				DOOR	
☐ 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

[illegible]

RD-6947-Rev 3
PAYMENT:
Mastercard / Visa (circle one)
Card #:
Exp. Date:
Signature:
RETURN:
☐ Clark Street Entrance
☒ Via US Mail or UPS

(PLEASE PRINT CLEARLY)
FIREARMS DELIVERED TO PLANT

FILE Nº 010802

DATE 1/17/96

CUSTOMER NAME:

WARREN DEMAREST

REMINGTON EMPLOYEE:

ADDRESS:

D CO 2ND BN 1ST SWTG

YES ☐ NO ☒

FT. BRAGG, NC

EMPLOYEE # _____

ZIP:

28307

DEPT. # _____

PHONE:

910 432-9037

FIREARM

MODEL: M-24

CHECK FOR AMMUNITION ☒

GAUGE: 7.62

SERIAL # 26225068

CONDITION:

<u>N/A</u> WOOD	GOOD	FAIR	POOR	FANCY	PLAIN
METAL	GOOD	<u>FAIR</u>	POOR	FANCY	PLAIN
BARREL	VT. RIB	<u>PLAIN</u>	DEER RSS		

ACCESSORIES:

SCOPE: YES ☐ NO ☒ (BRAND NAME/POWER) _____

SLING: YES ☐ NO ☒ GUN CASE: YES NO ☐ (HARD - SOFT)

EXTRA BBL FOR GUN MENTIONED ABOVE:

OTHER (Note in this area items missing or added from orig. equipment)

CUSTOMER REQUEST: REPAIR PER CONTRACT

SIGNATURE: Warren
(Person delivering firearm to Plant)

DATE: 17 JAN 96

SIGNATURE: M. S. Jones
(Security Officer)

DATE: 1/17/96

SIGNATURE: Richard Wright
(Firearm picked up by)

DATE: _____

Arm Service Copy

CONTRACT # DAAA21-87-C-0086

New Barrel

GUN SERIAL # C6225068

OP. #	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and Stock		1/22/96	Rw
600	Proof		1/22/96	Rw
607	Check Headspace		1/22/96	Rw
610	Dis-assemble Gun		1/22/96	Rw
612	Magnaflux Barrel Action			
	Magnaflux Bolt			
615	Rollmark Caliber			
617	Drill and Tap Sight Holes			
618	Polish Barrel			
620	Apply Coatings (Barrel Action)			
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		1/29/96	Rw
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		1/29/96	Rw
	C) Inspect Ejector Hole for Chamfer		1/29/96	Rw
	D) Oil Firing Pin Ass'y		1/29/96	Rw
	E) Adjust Trigger Pull to Min Setting and Stake		1/29/96	Rw

op. #	OP. NAME	READINGS			DATE	INIT
625 cont.	F) Safety On Force					
	G) Safety Off Force					
	H) Trigger Pull Test & Retainability					
	I) Firing Pin Indent					
	J) Assemble Stock					
	K) Assemble Swivel Studs					
	L) Attach Front and Rear Sight Assemblies					
	M) Iron Sight Alignment					
	N) Detach Front & Rear Sights & place in numbered container					
	O) Attach Scope to Rifle					
	P) Detach & Attach Scope 20 Times					
640	Gallery Target & Test				1/31/96	WLB
	A) Time					
	B) Malfunctions					
	C) Pierced Primers					
	D) Optical Clarity of Scope					
645	Inspect for Live Ammo				1/31/96	WLB
655	Final Inspection					
	A) Headspace				2/1/96	Rw
	B) Trigger Pull					
	C) Function				2/1/96	Rw
660	Pack					

Final Inspection

Sn: C6225068

DATE REC'D: 4/27/96

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
- ☐ Iron Sights
- ☐ Deployment Kit

Trigger

- ☒ SAFETY OPERATION
- ☒ SET
- ☐

Comments: _____

AX
CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6225068
3 Jan 1900

CENTROIDAL DISTANCES

0 TO	1	1.02144
1 TO	2	.211028
1 TO	3	.5272
1 TO	4	.101119
1 TO	5	.17565

σ_2

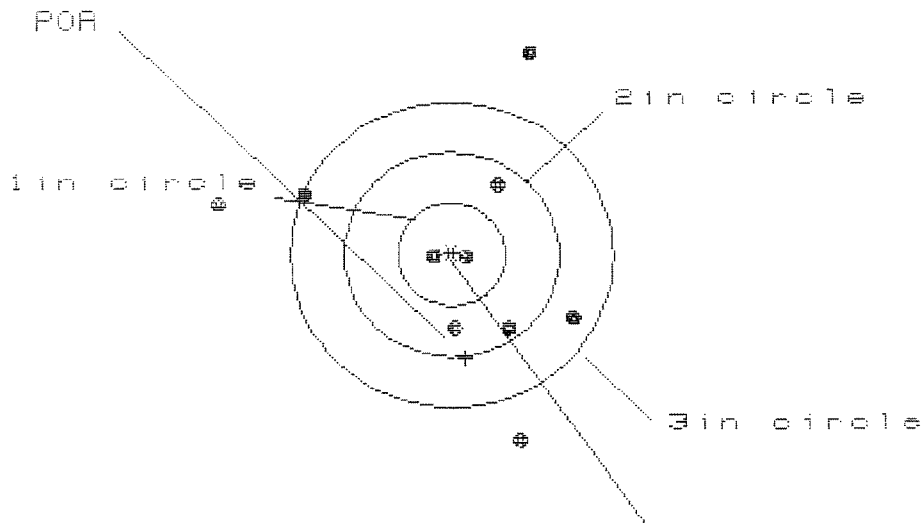
+ <-----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0158
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .9684
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .968529
THE AMR FOR THIS RIFLE IS: 1.152

8 Jan 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C6225068.1

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1 in = 2

2 in = 5

3 in = 7

HS= 3.341

VS= 3.821

GS= 3.824

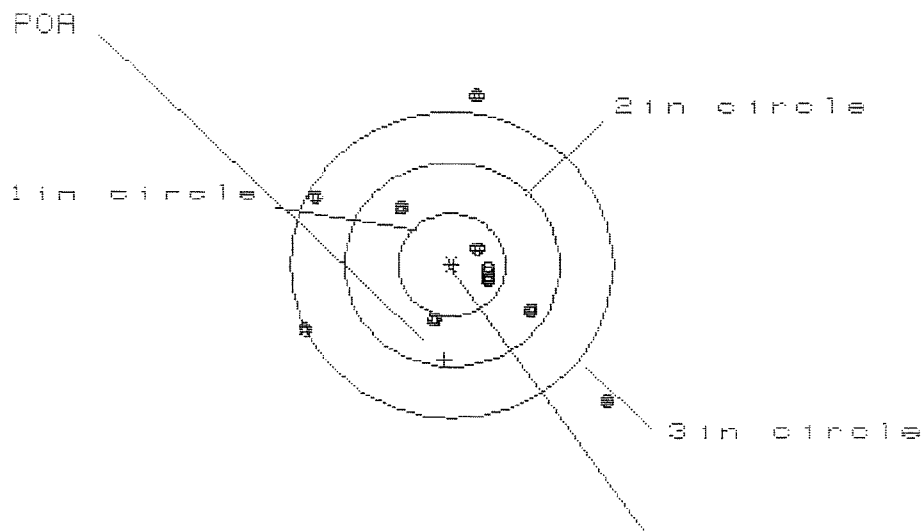
CENTROID #

PATTERN #	:	1	2	3
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.180	.940	1.007
MINIMUM X	:	-2.161	-1.593	-1.526
MAXIMUM Y	:	2.026	2.082	1.049
MINIMUM Y	:	-1.795	-1.739	-1.479
CENTROID X	:	-.131	.109	.042
CENTROID Y	:	1.013	.957	.697
POR TO CENTROID in.	:	1.021	.963	.698
MIN RADIUS	:	.129	.120	.308
MEAN RADIUS	:	1.180	1.052	.893
MAX RADIUS	:	2.219	2.149	1.775
HORIZONTAL SPREAD	:	3.341	2.533	2.533
VERTICAL SPREAD	:	3.821	3.821	2.528
EXTREME SPREAD	:	3.824	3.824	3.095
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	5		
NUMBER IN THREE INCH CIRCLE	=	7		

2 Jan 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C6225068.1

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 3

2in = 5

3in = 8

HS= 2.749

VS= 2.929

GS= 3.334

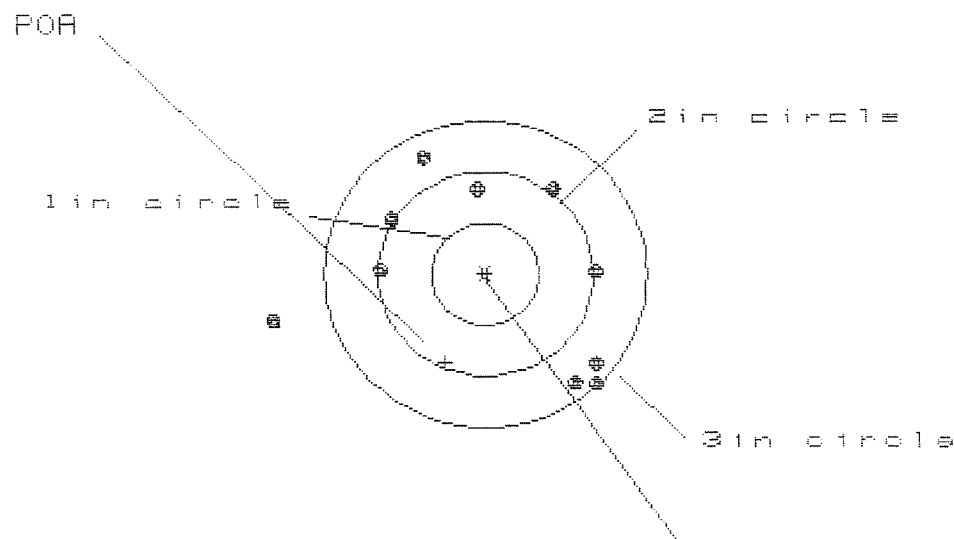
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.432	.915	.909
MINIMUM X	:	-1.317	-1.158	-1.114
MAXIMUM Y	:	1.638	1.495	.726
MINIMUM Y	:	-1.290	-.751	-.564
CENTROID X	:	.067	-.092	-.136
CENTROID Y	:	.940	1.083	.896
POA TO CENTROID in.	:	.942	1.087	.906
MIN RADIUS	:	.288	.419	.493
MEAN RADIUS	:	.969	.888	.796
MAX RADIUS	:	1.928	1.534	1.279
HORIZONTAL SPREAD	:	2.749	2.073	2.073
VERTICAL SPREAD	:	2.929	2.246	1.290
EXTREME SPREAD	:	3.334	2.703	2.310
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

2 Jan 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C8225068.1

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 0

2 in = 2

3 in = 8

HS= 3.014

VS= 2.237

GS= 3.075

CENTROID #

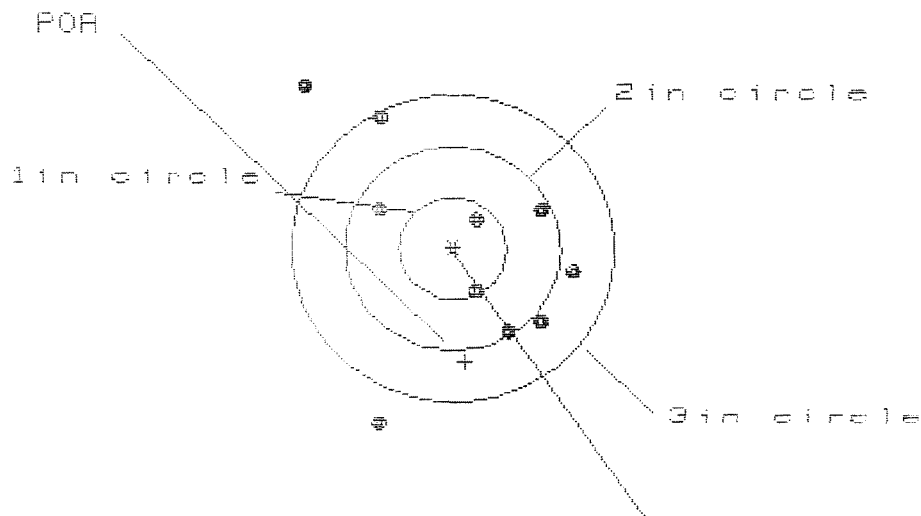
PATTERN #

	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.044	.825	.927
MINIMUM X	-1.970	-1.190	-1.088
MAXIMUM Y	1.144	1.094	.951
MINIMUM Y	-1.093	-1.143	-1.253
CENTROID X	.375	.594	.492
CENTROID Y	.865	.915	1.058
POA TO CENTROID in.	.943	1.091	1.166
MIN RADIUS	.886	.811	.722
MEAN RADIUS	1.243	1.133	1.076
MAX RADIUS	2.021	1.405	1.425
HORIZONTAL SPREAD	3.014	2.015	2.015
VERTICAL SPREAD	2.237	2.237	2.204
EXTREME SPREAD	3.075	2.753	2.591
NUMBER IN ONE INCH CIRCLE	=	0	
NUMBER IN TWO INCH CIRCLE	=	2	
NUMBER IN THREE INCH CIRCLE	=	8	

2 Jan 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C8225088.1

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 5

3 in = 7

HS= 2.519

VS= 3.316

GS= 3.389

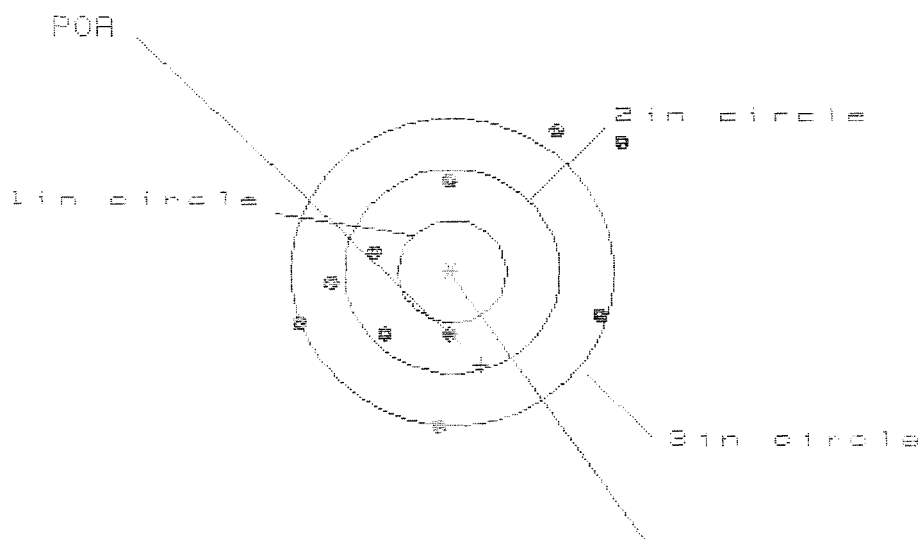
CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.120	.965	.858
MINIMUM X	:	-1.399	-.887	-.994
MAXIMUM Y	:	1.625	1.507	1.318
MINIMUM Y	:	-1.691	-1.510	-.843
CENTROID X	:	-.116	.039	.146
CENTROID Y	:	1.113	.932	1.121
POA TO CENTROID in.	:	1.119	.933	1.131
MIN RADIUS	:	.347	.261	.312
MEAN RADIUS	:	1.118	.960	.847
MAX RADIUS	:	2.144	1.742	1.643
HORIZONTAL SPREAD	:	2.519	1.852	1.852
VERTICAL SPREAD	:	3.316	3.017	2.161
EXTREME SPREAD	:	3.389	3.017	2.563
NUMBER IN ONE INCH CIRCLE =			2	
NUMBER IN TWO INCH CIRCLE =			5	
NUMBER IN THREE INCH CIRCLE =			7	

2 Jan 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C6225068.1

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 0

2in = 4

3in = 7

HS= 2.028

VS= 2.028

GS= 3.534

CENTROID #

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.619	1.589	1.748
MINIMUM X	-1.409	-1.230	-1.081
MAXIMUM Y	1.412	1.553	1.202
MINIMUM Y	-1.484	-1.343	-1.149
CENTROID X	-1.274	-1.433	-1.602
CENTROID Y	.911	.770	.576
POA TO CENTROID in.	.951	.894	.833
MIN RADIUS	.614	.509	.389
MEAN RADIUS	1.251	1.109	.950
MAX RADIUS	2.057	1.954	1.749
HORIZONTAL SPREAD	3.028	2.829	2.829
VERTICAL SPREAD	2.896	2.896	2.351
EXTREME SPREAD	3.534	3.128	2.833
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	7		

PAYMENT:
Mastercard / Visa (circle one)

Card #: _____

Exp. Date: _____

Signature: _____

RETURN:

☐ Clark Street Entrance☒ Via US Mail or UPS

(PLEASE PRINT CLEARLY)

FIREARMS DELIVERED TO PLANT

FILE NO 007081DATE 6/20/92CUSTOMER NAME: DAVID HUSKINS

REMINGTON EMPLOYEE:

ADDRESS: COMPANY DYES ☐ NO ☒

EMPLOYEE # _____

ZIP: 2ND BTL. 1ST. SWTG

DEPT. # _____

PHONE: FORT BRAGG, N.C.

FIREARM

MODEL: M24

CHECK FOR AMMUNITION

GAUGE: .762SERIAL # 26225068

CONDITION:

WOOD

GOOD

FAIR

POOR

FANCY

PLAIN

METAL

GOOD

FAIR

POOR

FANCY

PLAIN

BARREL

VT. RIB

PLAIN

DEER RSS

ACCESSORIES: 871163SCOPE: YES

NO

(BRAND NAME/POWER) M3A-10

SLING: YES

NO

SCOPE

GUN CASE: YES

NO

(HARD - SOFT)

EXTRA BBL FOR GUN MENTIONED ABOVE:

OTHER (Note in this area items missing or added from orig. equipment)

CUSTOMER REQUEST: RE BARRELEDSIGNATURE: David S. Huskins
(Person delivering firearm to Plant)DATE: 6/20/92SIGNATURE: Alp Oguner
(Security Officer)DATE: 6/20/92SIGNATURE: J. Langens
(Firearm picked up by)DATE: 6/21/92

Arm Service Copy

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6225068
28 Jul 1992

CENTROIDAL DISTANCES

0 TO	1	.39152
1 TO	2	.142215
1 TO	3	.383803
1 TO	4	.467402
1 TO	5	.456885

ga <----FOR

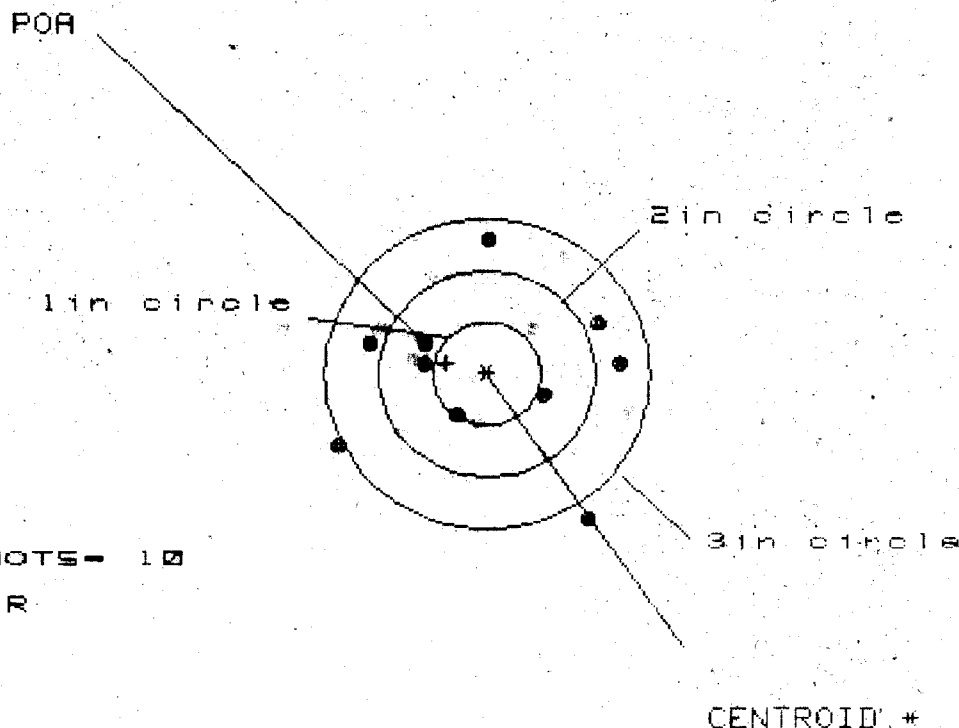
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1058
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1792
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .208102

THE AMR FOR THIS RIFLE IS: 1.024

28 Jul 1992

FILE:/PATTERNING/CENTERFIRE_PATT/06225068

CENTERFIRE PATTERNS # 1



OF SHOTS - 10

IN CIR

1in = 1

2in = 4

3in = 8

HS = 2.617

VS = 2.677

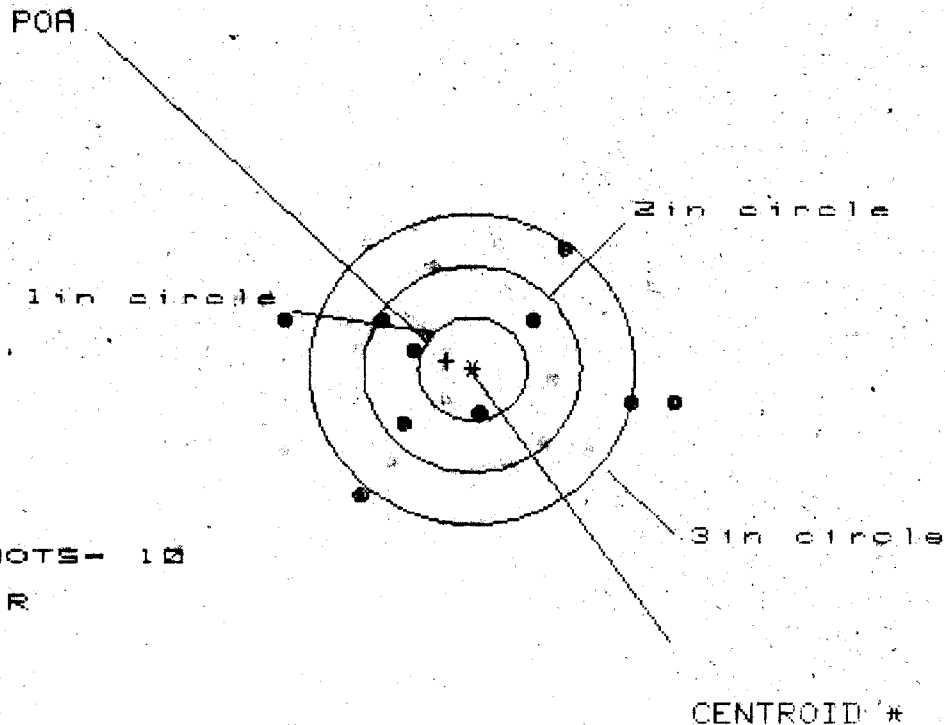
GS = 2.823

PATTERN #	:			
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.270	1.376	1.221
MINIMUM X	:	-1.347	-1.241	-1.136
MAXIMUM Y	:	1.328	1.179	1.072
MINIMUM Y	:	-1.349	-.851	-.620
CENTROID X	:	.378	.272	.427
CENTROID Y	:	-.102	.047	.154
POA TO CENTROID in.	:	.391	.276	.454
MIN RADIUS	:	.440	.482	.631
MEAN RADIUS	:	1.028	.941	.892
MAX RADIUS	:	1.652	1.505	1.232
HORIZONTAL SPREAD	:	2.617	2.617	2.357
VERTICAL SPREAD	:	2.677	2.030	1.692
EXTREME SPREAD	:	2.823	2.736	2.363
NUMBER IN ONE INCH CIRCLE =	:		1	
NUMBER IN TWO INCH CIRCLE =	:		4	
NUMBER IN THREE INCH CIRCLE =	:		8	

28 Jul 1992

FILE: PATTERNING/CENTERFIRE_PATT/C6225068

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 5

HS= 3.655

VS= 2.481

GS= 3.745

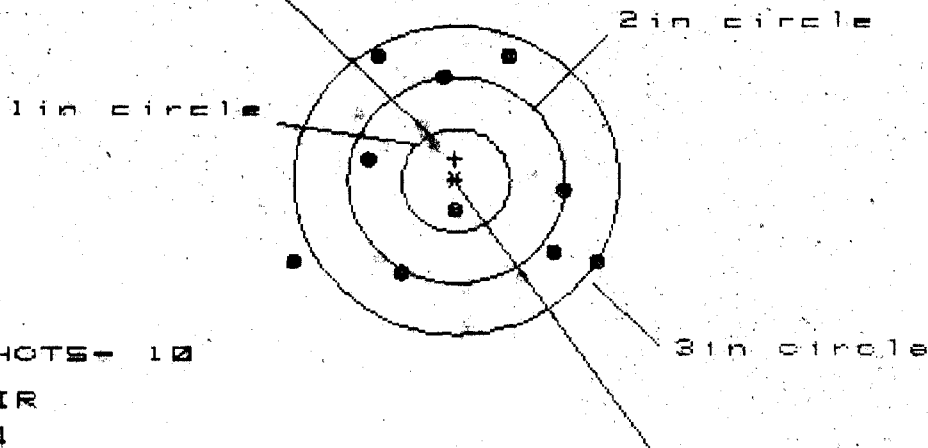
PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.883	1.697	1.501
MINIMUM X	:	-1.772	-1.562	-1.072
MAXIMUM Y	:	1.225	1.192	1.253
MINIMUM Y	:	-1.256	-1.289	-1.228
CENTROID X	:	.238	.028	.224
CENTROID Y	:	-.077	-.044	-.105
POA TO CENTROID in.	:	.250	.052	.247
MIN RADIUS	:	.456	.384	.432
MEAN RADIUS	:	1.192	1.084	1.019
MAX RADIUS	:	1.907	1.737	1.630
HORIZONTAL SPREAD	:	3.655	3.259	2.573
VERTICAL SPREAD	:	2.481	2.481	2.481
EXTREME SPREAD	:	3.745	3.370	3.172
NUMBER IN ONE INCH CIRCLE	=	1	5	5
NUMBER IN TWO INCH CIRCLE	=	5	5	5
NUMBER IN THREE INCH CIRCLE	=	5	5	5

26 Jul 1992

FILE:/PATTERNING/CENTERFIRE_PATT/CG225068

CENTERFIRE PATTERNS # 3

POA



+ OF SHOTS - 10

IN CIR

1in = 1

2in = 4

3in = 5

HS = 2.774

VS = 2.133

GS = 2.848

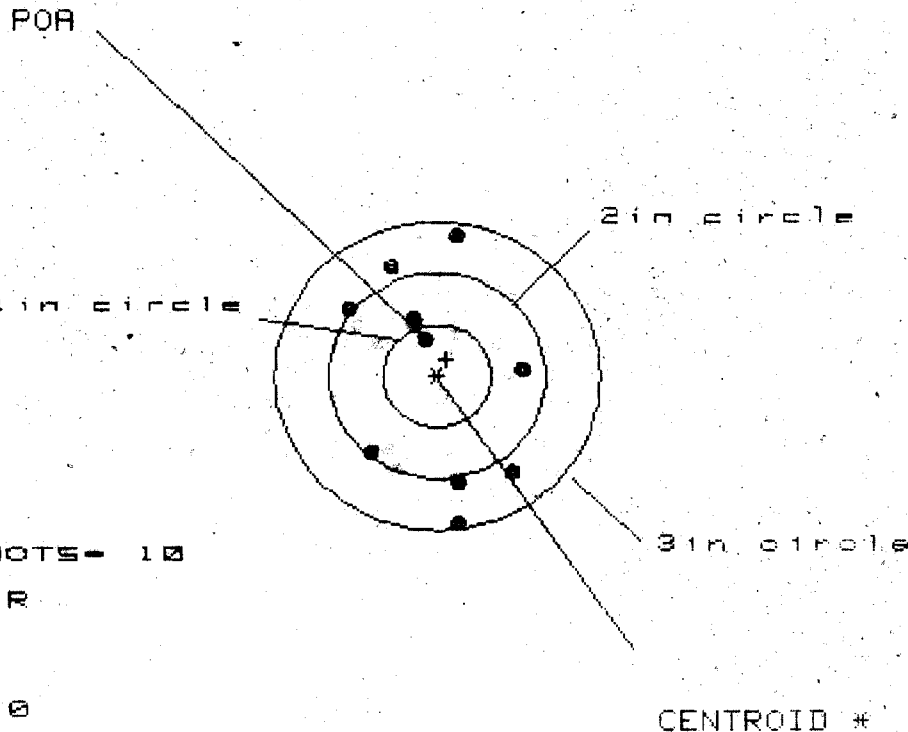
CENTROID *

PATTERN #		10	9	8
SHOTS (BEST OF)		10	9	8
MAXIMUM X		1.249	1.080	.914
MINIMUM X		-1.525	-.936	-.801
MAXIMUM Y		1.216	1.130	1.015
MINIMUM Y		-.917	-1.003	-1.118
CENTROID X		.010	.179	.044
CENTROID Y		-.211	-.125	-.010
POA TO CENTROID in.		.212	.218	.045
MIN RADIUS		.247	.358	.446
MEAN RADIUS		1.104	1.032	.977
MAX RADIUS		1.713	1.436	1.262
HORIZONTAL SPREAD		2.774	2.016	1.715
VERTICAL SPREAD		2.133	2.133	2.133
EXTREME SPREAD		2.848	2.841	2.471
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	

28 Jul 1992

FILE:/PATTERNING/CENTERFIRE_PATT/C6225068

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 1

2in = 4

3in = 10

HS= 1.605

VS= 2.771

GS= 2.771

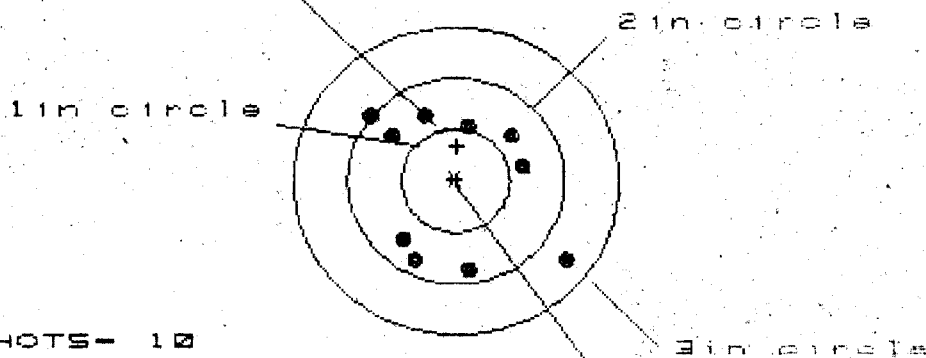
PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.826	.847	.879
MINIMUM X	-.779	-.758	-.726
MAXIMUM Y	1.339	1.179	1.070
MINIMUM Y	-1.432	-1.187	-1.039
CENTROID X	-.085	-.106	-.138
CENTROID Y	-.166	-.006	-.154
POA TO CENTROID in.	.186	.107	.207
MIN RADIUS	.399	.238	.380
MEAN RADIUS	.993	.910	.887
MAX RADIUS	1.446	1.253	1.150
HORIZONTAL SPREAD	1.605	1.605	1.605
VERTICAL SPREAD	2.771	2.366	2.109
EXTREME SPREAD	2.771	2.367	2.249
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	10		

28 Jul 1992

FILE:/PATTERNING/CENTERFIRE_PATT/C6225068

CENTERFIRE PATTERNS # 5

POB



OF SHOTS- 10

IN CIR

1in - 0

2in - 9

3in = 10

HS= 1.798

VS= 1.498

GS= 2.253

CENTROID #

PATTERN #			
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.034	.748	.667
MINIMUM X	-.764	-.650	-.529
MAXIMUM Y	.626	.545	.605
MINIMUM Y	-.872	-.953	-.885
CENTROID X	-.012	-.126	-.045
CENTROID Y	-.340	-.259	-.327
POB TO CENTROID in.	.340	.288	.330
MIN RADIUS	.555	.515	.550
MEAN RADIUS	.804	.736	.722
MAX RADIUS	1.267	.990	.905
HORIZONTAL SPREAD	1.798	1.398	1.196
VERTICAL SPREAD	1.498	1.498	1.490
EXTREME SPREAD	2.253	1.756	1.551
NUMBER IN ONE INCH CIRCLE	=	0	
NUMBER IN TWO INCH CIRCLE	=	9	
NUMBER IN THREE INCH CIRCLE	=	10	

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # *C6225068*

OP. #	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and Stock		<i>7/9/92</i>	<i>RW</i>
600	Proof		<i>7/9/92</i>	<i>RW</i>
607	Check Headspace		<i>7/9/92</i>	<i>RW</i>
610	Dis-assemble Gun		<i>7/9/92</i>	<i>RW</i>
612	Magnaflux Barrel Action			
	Magnaflux Bolt			
615	Rollmark Caliber			
617	Drill and Tap Sight Holes		<i>7/9/92</i>	<i>RW</i>
618	Polish Barrel			
620	Apply Coatings (Barrel Action)			
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly			
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head			
	C) Inspect Ejector Hole for Chamfer			
	D) Oil Firing Pin Ass'y			
	E) Adjust Trigger Pull to Min Setting and Stake			

op. #	OP. NAME	READINGS			DATE	INIT
625 cont.	F) Safety On Force					
	G) Safety Off Force					
	H) Trigger Pull Test & Retainability					
	I) Firing Pin Indent					
	J) Assemble Stock					
	K) Assemble Swivel Studs					
	L) Attach Front and Rear Sight Assemblies					
	M) Iron Sight Alignment					
	N) Detach Front & Rear Sights & place in numbered container					
	O) Attach Scope to Rifle					
	P) Detach & Attach Scope 20 Times					
640	Gallery Target & Test				7-28-92	A
	A) Time				11	A
	B) Malfunctions				11	A
	C) Pierced Primers				11	A
	D) Optical Clarity of Scope				11	A
645	Inspect for Live Ammo				7-28-92	A
655	Final Inspection					
	A) Headspace					
	B) Trigger Pull					
	C) Function					
660	Pack					

08299

5081

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6225068

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

SCOPE # 1105

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6225068

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

OVER

C6225068

OP.#		READINGS	DATE	INITIAL
625 cont.	D) Oil Firing Pin Ass'y		9/8/88	RW
	E) Adjust Trigger Pull to Min. Setting and Stake		8 Sept 88	J.U. + J.S.
	F) Safety on Force	6 6 6	8 Sept 88	J.U. + J.S.
	G) Safety off Force	4 4 4	8 Sept 88	J.U. + J.S.
	H) Trigger Pull Test & Retainability		8 Sept 88	J.U. + J.S.
	I) Firing Pin Indent	.021 .0205 .021	8 Sept 88	J.U. + J.S.
	J) Assemble Stock		9/20/88	RW
	K) Assemble Swivel Studs		10-10-88	J.S.
	L) Attach Front & Rear Sight Assemblies		9/20/88	RW
	M) Iron Sight Alignment		9/20/88	RW
	N) Detach Front & Rear Sights & place in numbered container		9/20/88	RW
	O) Attach Scope to Rifle		10/3/88	RW
	P) Detach & Attach Scope 20 times		10/4/88	J.S.
640	Gallery Target & Test	69 R 86 L	10/7/88	W.B.
	A) Optical Clarity of Scope		10/7/88	W.B.
645	Inspect for Live Ammo		10/7/88	W.B.
655	Final Inspection			
	A) Headspace		10-10-88	J.S.
	B) Trigger Pull		10-10-88	J.S.
	C) Function		10-10-88	J.S.
660	Pack		10-21-88	J.S.

SWS TRIGGER PULL TEST

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

SERIAL NO. C6225068

DATE 8 Sept 88

TESTER J. A. 24.8

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.58	2.46	2.51	2.52	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.56	2.45	2.50	2.43	
PULL #3	2.51	2.42	2.50	2.45	
PULL #4	2.43	2.46	2.46	2.49	
PULL #5	2.43	2.50	2.43	2.46	
TOTAL	12.51	12.29	12.40	12.35	
AVG.	2.502	2.458	2.48	2.47	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.22	3.25		
PULL #2	3.27	3.24		
PULL #3	3.32	3.26		
PULL #4	3.15	3.21		
PULL #5	3.24	3.09		
TOTAL	16.20	16.05		
AVG.	3.24	3.21		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.23	4.13		4.29
PULL #2	4.23	4.17		4.28
PULL #3	4.18	4.16		4.27
PULL #4	4.19	4.24		3.96
PULL #5	4.18	4.22		4.22
TOTAL	21.01	20.92		21.02
AVG.	4.202	4.184		4.404

INTERCHANGEABILITY

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06225068

CENTROIDAL DISTANCES

0 TO	1	1.08632
1 TO	2	.351973
1 TO	3	.805437
1 TO	4	.600187
1 TO	5	.811844

$\frac{1}{2} \frac{4}{53} +$ (----POA

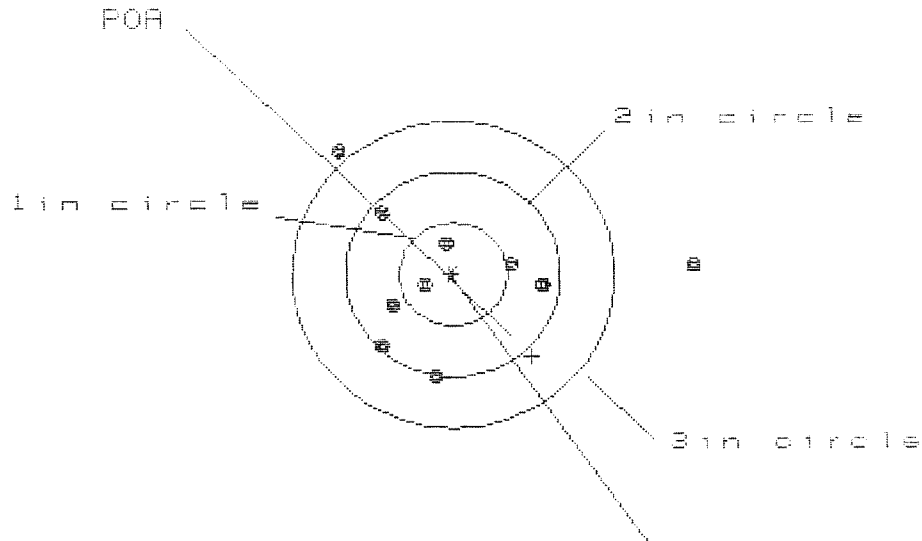
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.6032
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .3475
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .696187
THE AMR FOR THIS RIFLE IS: 1.084

INTERCHANGEABILITY

18 Oct 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C8225088.1

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1 in = 2

2 in = 5

3 in = 8

HS= 3.305

VS= 2.285

GS= 3.503

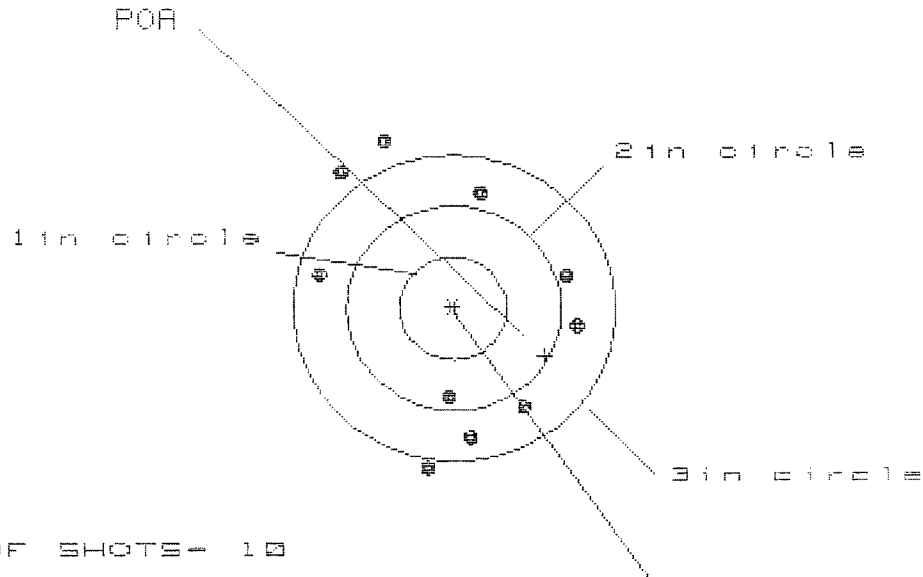
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	2.222	1.039	.934
MINIMUM X	-1.083	-.836	-.568
MAXIMUM Y	1.248	1.257	.720
MINIMUM Y	-1.037	-1.028	-.870
CENTROID X	-.736	-.983	-.878
CENTROID Y	.799	.790	.632
POA TO CENTROID in.	1.087	1.261	1.082
MIN RADIUS	.281	.064	.177
MEAN RADIUS	.945	.760	.670
MAX RADIUS	2.224	1.510	.938
HORIZONTAL SPREAD	3.305	1.875	1.502
VERTICAL SPREAD	2.285	2.285	1.590
EXTREME SPREAD	3.503	2.447	1.661
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	8		

18 Oct 1988

FILE:/PATTERNING/CENTERFIRE_PATT/08225068.1

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 0

2 in = 1

3 in = 7

HS= 2.402

VS= 3.213

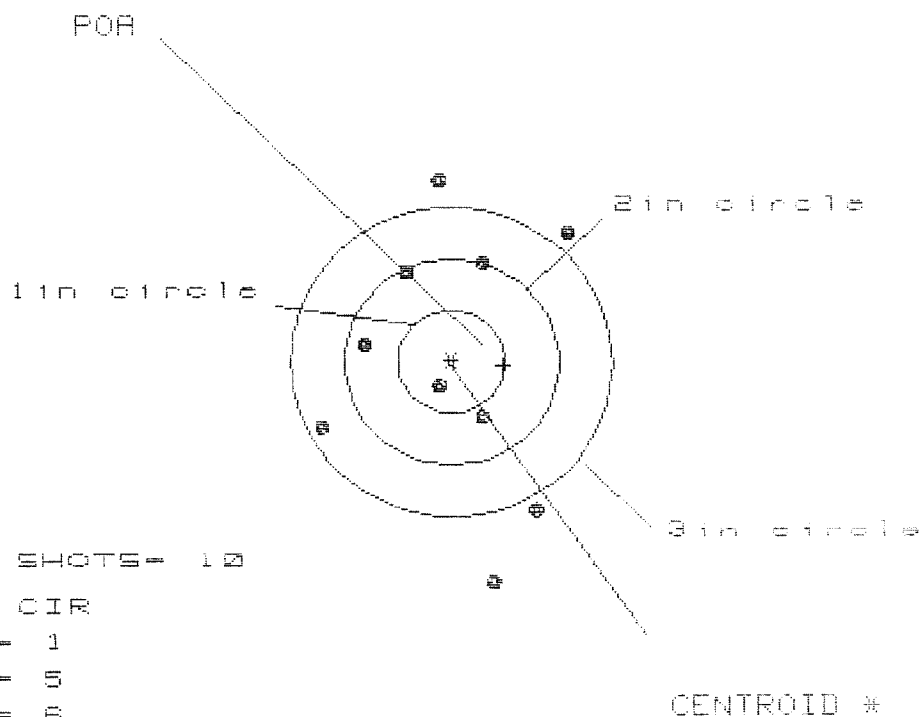
GS= 3.237

PATTERN #	2	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.143	1.069	.930
MINIMUM X	-1.259	-1.333	-1.472
MAXIMUM Y	1.626	1.533	1.552
MINIMUM Y	-1.587	-1.406	-1.215
CENTROID X	-.850	-.776	-.637
CENTROID Y	.466	.285	.094
POA TO CENTROID in.	.970	.827	.644
MIN RADIUS	.866	.690	.539
MEAN RADIUS	1.304	1.217	1.075
MAX RADIUS	1.759	1.893	1.613
HORIZONTAL SPREAD	2.402	2.402	2.402
VERTICAL SPREAD	3.213	2.939	2.767
EXTREME SPREAD	3.237	3.036	2.822
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	1		
NUMBER IN THREE INCH CIRCLE =	7		

18 Oct 1988

FILE:/PATTERNING/CENTERFIRE_PATT/08225068.1

CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 5

3 in = 6

HS = 2.323

VS = 3.908

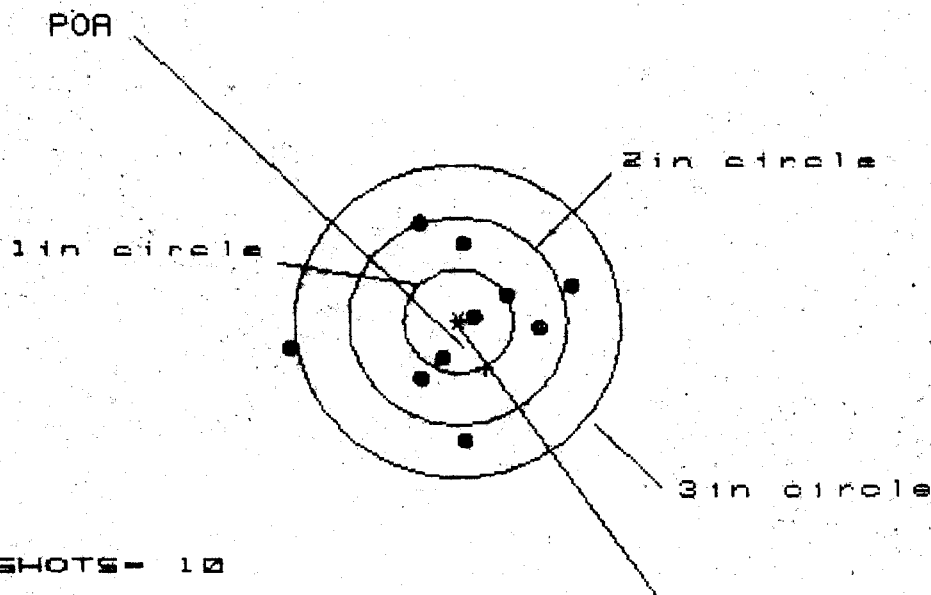
GS = 3.940

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.120	1.159	1.144
MINIMUM X	:	-1.203	-1.164	-1.179
MAXIMUM Y	:	1.744	1.503	1.214
MINIMUM Y	:	-2.164	-1.626	-1.438
CENTROID X	:	-.484	-.523	-.508
CENTROID Y	:	.034	.275	.087
POA TO CENTROID in.	:	.485	.591	.516
MIN RADIUS	:	.253	.455	.284
MEAN RADIUS	:	1.222	1.101	1.034
MAX RADIUS	:	2.193	1.804	1.668
HORIZONTAL SPREAD	:	2.323	2.323	2.323
VERTICAL SPREAD	:	3.908	3.129	2.652
EXTREME SPREAD	:	3.940	3.255	3.032
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	5		
NUMBER IN THREE INCH CIRCLE	=	6		

18 Oct 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C6225068.1

CENTERFIRE PATTERNS # 4



* OF SHOTS- 10

* IN CIR

1 in = 3

2 in = 6

3 in = 9

HE = 2.669

VS = 2.056

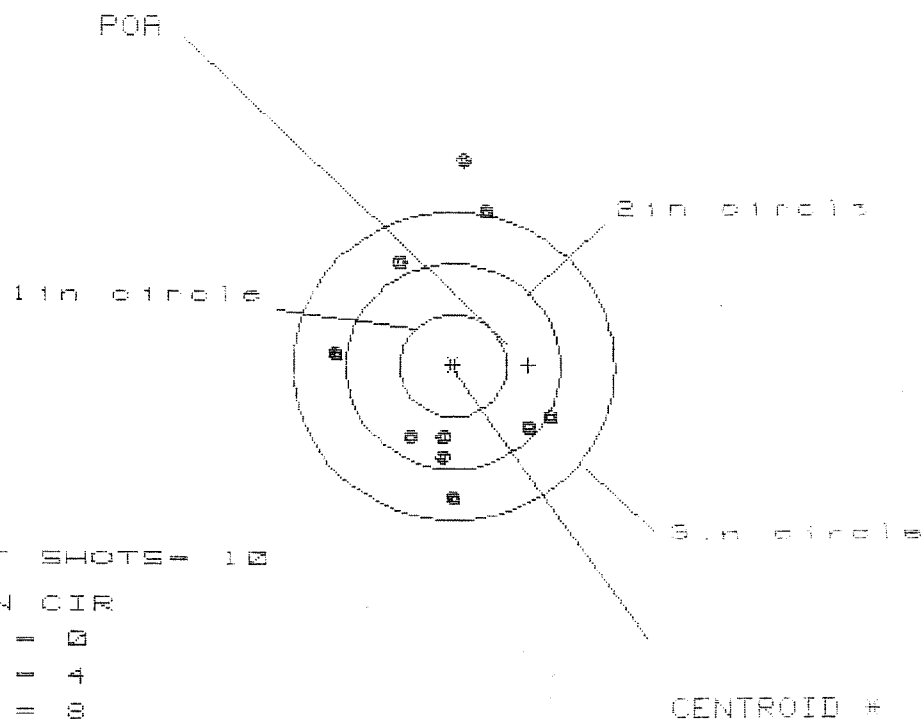
GS = 2.735

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.086	.910	.695
MINIMUM X	:	-1.583	-.557	-.444
MAXIMUM Y	:	.953	.926	.967
MINIMUM Y	:	-1.103	-1.130	-1.089
CENTROID X	:	-.247	-.071	-.184
CENTROID Y	:	.451	.478	.437
POA TO CENTROID in.	:	.514	.483	.474
MIN RADIUS	:	.175	.061	.134
MEAN RADIUS	:	.811	.690	.662
MAX RADIUS	:	1.602	1.138	1.089
HORIZONTAL SPREAD	:	2.669	1.467	1.139
VERTICAL SPREAD	:	2.056	2.056	2.056
EXTREME SPREAD	:	2.735	2.098	2.098
NUMBER IN ONE INCH CIRCLE =	:	3	6	9
NUMBER IN TWO INCH CIRCLE =	:	6	9	9
NUMBER IN THREE INCH CIRCLE =	:	9	9	9

18 Oct 1988

FILE:/PATTERNING/CENTERFIRE_PATT/1810098.1

CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1 in = 0

2 in = 4

3 in = 8

HS= 2.028

VS= 3.243

GS= 3.243

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	.929
MINIMUM X	-1.099
MAXIMUM Y	1.971
MINIMUM Y	-1.272
CENTROID X	-.699
CENTROID Y	-.012
POA TO CENTROID in.	.700
MIN RADIUS	.669
MEAN RADIUS	1.139
MAX RADIUS	1.973
HORIZONTAL SPREAD	2.028
VERTICAL SPREAD	3.243
EXTREME SPREAD	3.243
NUMBER IN ONE INCH CIRCLE =	0
NUMBER IN TWO INCH CIRCLE =	4
NUMBER IN THREE INCH CIRCLE =	8

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6225068

CENTROIDAL DISTANCES

0 TO	1	1.10926
1 TO	2	.2565
1 TO	3	.39491
1 TO	4	.904545
1 TO	5	.336786

† <----POA
†³

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1024
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.9962
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: 1.00145

THE AMR FOR THIS RIFLE IS: 1.02

7 Oct 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C8225068

CENTERFIRE PATTERNS # 1

POA

1 in circle

2 in circle

3 in circle

OF SHOTS = 10

IN CIR

1 in = 3

2 in = 6

3 in = 7

HS = 2.428

VS = 4.000

GS = 4.166

CENTROID *

PATTERN #	:	1	2	3
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.489	1.384	.417
MINIMUM X	:	-.939	-.803	-.630
MAXIMUM Y	:	2.078	1.791	.905
MINIMUM Y	:	-1.931	-1.700	-1.476
CENTROID X	:	-.171	-.066	-.239
CENTROID Y	:	-1.096	-1.327	-1.551
POA TO CENTROID in.	:	1.109	1.328	1.569
MIN RADIUS	:	.168	.204	.227
MEAN RADIUS	:	1.045	.885	.682
MAX RADIUS	:	2.280	2.263	1.499
HORIZONTAL SPREAD	:	2.428	2.187	1.047
VERTICAL SPREAD	:	4.000	3.491	2.381
EXTREME SPREAD	:	4.166	3.723	2.418
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		7	

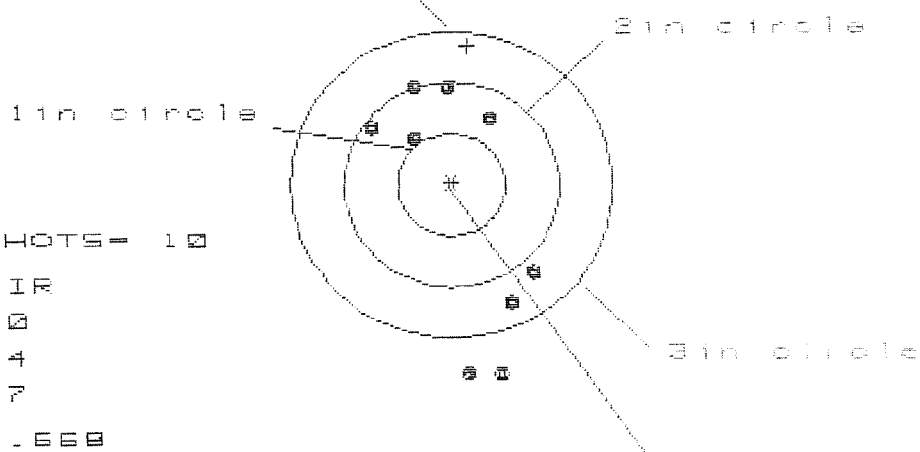
7 Oct 1988

FILE:/PATTERNING/CENTERFIRE_PATT/06225058

CENTERFIRE PATTERNS

2

POA



OF SHOTS = 10

IN CIR

1in = 0

2in = 4

3in = 7

HS = 1.668

VS = 3.918

GS = 4.135

CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.719	.614	.657
MINIMUM X	:	-.949	-.800	-.757
MAXIMUM Y	:	2.088	1.233	1.037
MINIMUM Y	:	-1.830	-1.599	-1.795
CENTROID X	:	-.155	-.050	-.093
CENTROID Y	:	-1.352	-1.583	-1.387
POA TO CENTROID in.	:	1.360	1.584	1.390
MIN RADIUS	:	.539	.789	.605
MEAN RADIUS	:	1.245	1.147	1.046
MAX RADIUS	:	2.293	1.608	1.797
HORIZONTAL SPREAD	:	1.668	1.414	1.414
VERTICAL SPREAD	:	3.918	2.832	2.832
EXTREME SPREAD	:	4.135	2.902	2.866
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		7	

7 Oct 1988

FILE://PATTERNING/CENTERFIRE_PATT/06225068

CENTERFIRE PATTERNS # 3

FOR

1 in circle

2 in circle

3 in circle

CENTROID #

OF SHOTS- 10

IN CIR

1 in = 2

2 in = 6

3 in = 8

HS= 2.251

VS= 3.625

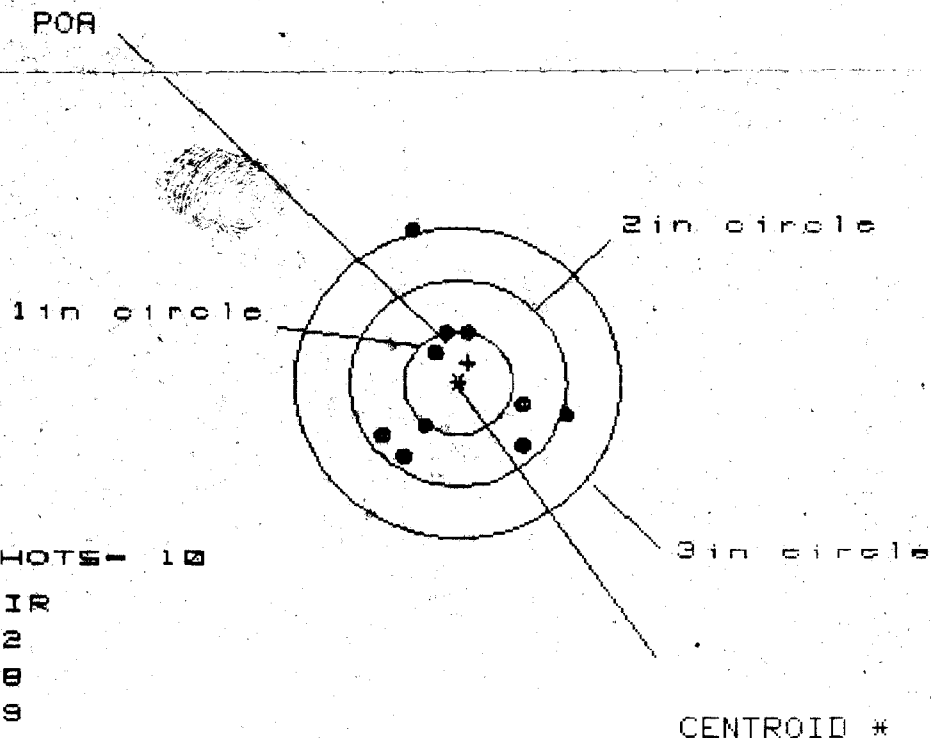
GS= 3.724

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.993	.837	.868
MINIMUM X	:	-1.258	-1.147	-1.116
MAXIMUM Y	:	2.044	.983	.014
MINIMUM Y	:	-1.581	-1.354	-.989
CENTROID X	:	.184	.073	.042
CENTROID Y	:	-.923	-1.150	-.981
POA TO CENTROID in.	:	.941	1.152	.982
MIN RADIUS	:	.135	.227	.057
MEAN RADIUS	:	.980	.843	.739
MAX RADIUS	:	2.273	1.377	1.277
HORIZONTAL SPREAD	:	2.251	1.984	1.984
VERTICAL SPREAD	:	3.625	2.337	1.803
EXTREME SPREAD	:	3.724	2.337	2.095
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

7 Oct 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C6225068

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 8

3 in = 9

HS= 1.681

VS= 2.165

GS= 2.355

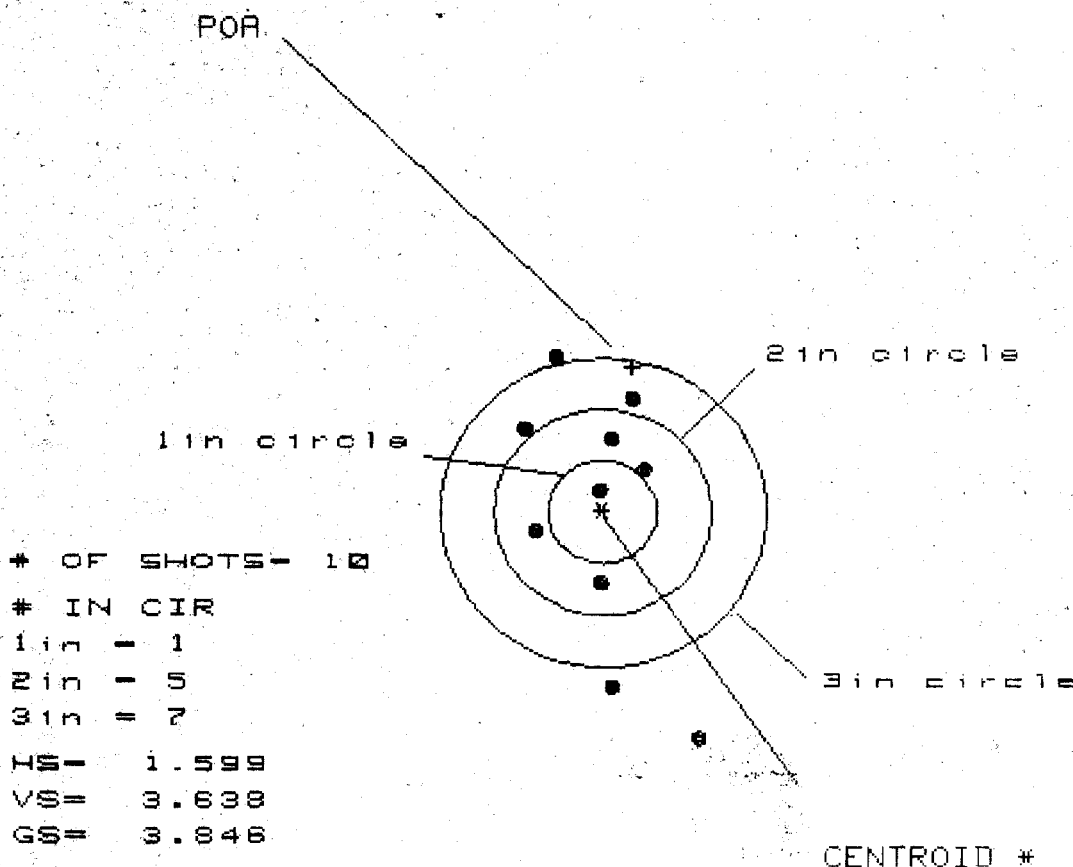
PATTERN #	:			
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.985	.939	.653
MINIMUM X	:	-.696	-.742	-.624
MAXIMUM Y	:	1.491	.696	.675
MINIMUM Y	:	-.674	-.509	-.529
CENTROID X	:	-.091	-.045	-.163
CENTROID Y	:	-.195	-.360	-.340
POA TO CENTROID in.	:	.215	.363	.377
MIN RADIUS	:	.388	.463	.393
MEAN RADIUS	:	.773	.681	.632
MAX RADIUS	:	1.546	.954	.819
HORIZONTAL SPREAD	:	1.681	1.681	1.277
VERTICAL SPREAD	:	2.165	1.205	1.205
EXTREME SPREAD	:	2.355	1.690	1.329
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	

7 Oct 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C8225068

CENTERFIRE PATTERNS

5



PATTERN #	:			
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.870	.515	.542
MINIMUM X	:	-.729	-.633	-.606
MAXIMUM Y	:	1.501	1.263	1.018
MINIMUM Y	:	-2.137	-1.961	-1.139
CENTROID X	:	-.279	-.375	-.402
CENTROID Y	:	-1.415	-1.177	-.932
POA TO CENTROID in.	:	1.442	1.236	1.015
MIN RADIUS	:	.185	.073	.309
MEAN RADIUS	:	1.056	.858	.701
MAX RADIUS	:	2.307	1.975	1.143
HORIZONTAL SPREAD	:	1.599	1.148	1.148
VERTICAL SPREAD	:	3.638	3.224	2.157
EXTREME SPREAD	:	3.846	3.262	2.185
NUMBER IN ONE INCH CIRCLE =			1	
NUMBER IN TWO INCH CIRCLE =			5	
NUMBER IN THREE INCH CIRCLE =			7	