

C6225086

MODEL 700™ M24

Model 700 M24™

Action

Barrel Length

Capacity

Order No. 5716

*Includes 1 in chamber.

Remington

BBL - 96003
BOIT - 96005

FINAL Inspection

S.N. C6225086

DATE REC'D: 10-8-00

DATE RET'D:

AUDITOR: CK

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:

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

R & E NUMBER <u>14843</u>			
SERIAL NUMBER <u>C6225086</u>			
LOG-IN DATE <u>10-3-00</u>			
INSPECT AND VERIFY:			
OPERATION #	OPERATION NAME	DATE	INITIAL
550	DIS-ASSEMBLE GUN	10-6-00	CK
560 A	RE-BARREL AT CUSTOM SHOP		
B	DRILL AND TAP		
C	POLISH		
575	ASSEMBLE		
600	PROOF	10-16-00	RW
605	CHECK HEADSPACE	10-16-00	CK
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		
D	SAFETY "OFF" FORCE		
E	FIRING PIN INDENT		
640	TARGET	11-3-00	RW
655	FINAL INSPECT	11-6-00	CK
660	PACK		
		SHIP DATE	
		QAR INSPECTION DATE	

Remington Test Lab, Ilion, N.Y.

Centroidal distance calculations for Rifle # c6225086
3 Nov 2000

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .015
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.223
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .223504

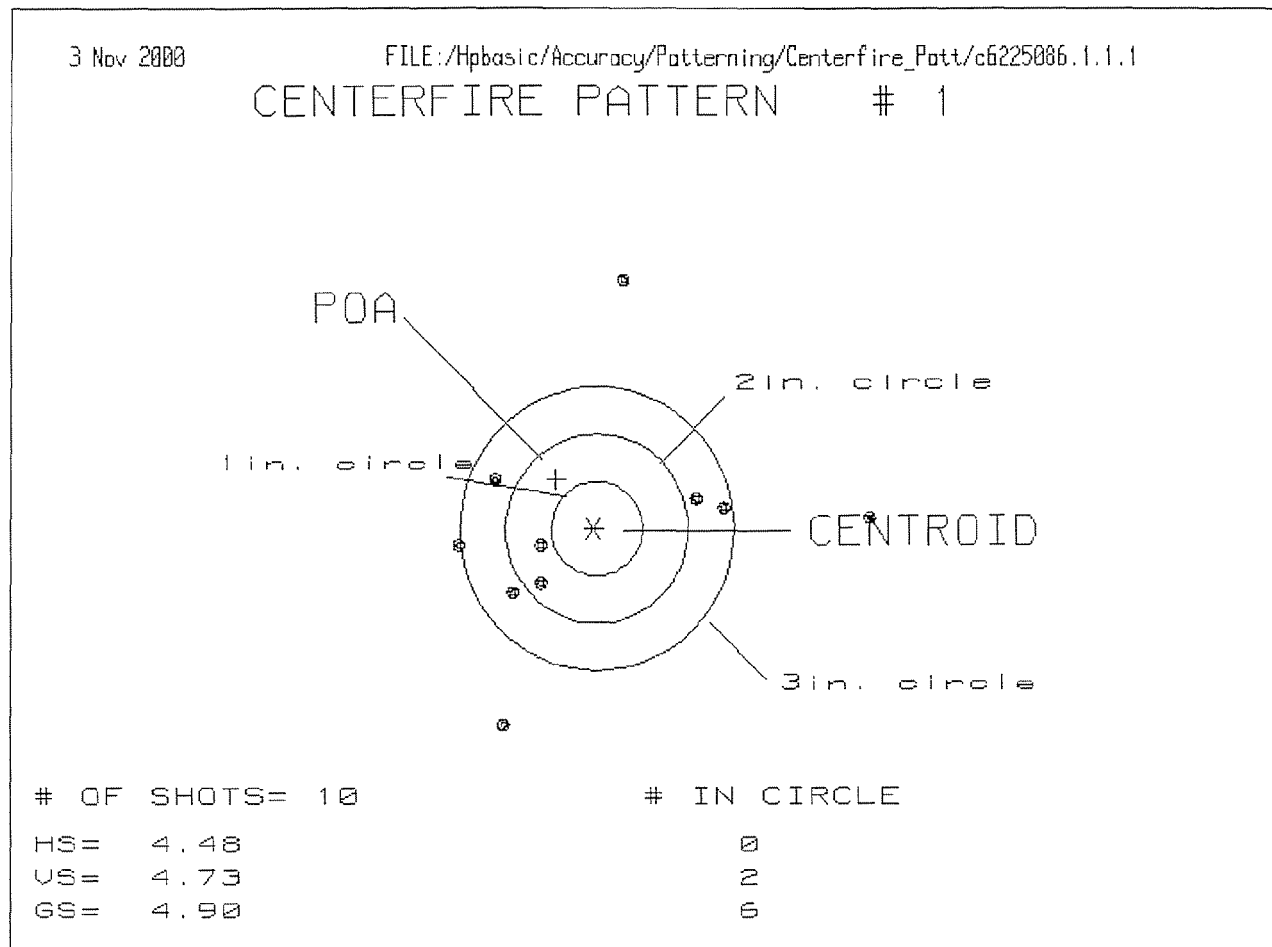
THE AMR FOR THIS RIFLE IS: 1.283

CENTROIDAL DISTANCES

0 TO	1	.667648
1 TO	2	.57956
1 TO	3	.61298
1 TO	4	.662559
1 TO	5	.795108

4 2 <----POA
5 3
1

PATTERN #: 1
 POA TO CENTROID: .668
 MIN RADIUS : .617
 MEAN RADIUS : 1.583
 MAX RADIUS : 2.977
 CENTROID X : .415
 CENTROID Y : -.523

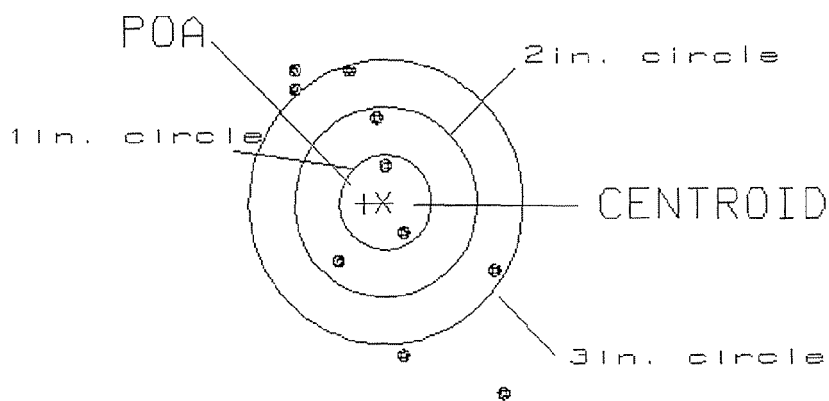


PATTERN #: ☐ 2 ☐
 POA TO CENTROID: .203
 MIN RADIUS : .425
 MEAN RADIUS : 1.271
 MAX RADIUS : 2.384
 CENTROID X : .202
 CENTROID Y : .016

3 Nov 2000

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6225086.1.1.1

CENTERFIRE PATTERN # 2



OF SHOTS= 10

IN CIRCLE

HS= 2.31
 VS= 3.40
 GS= 4.10

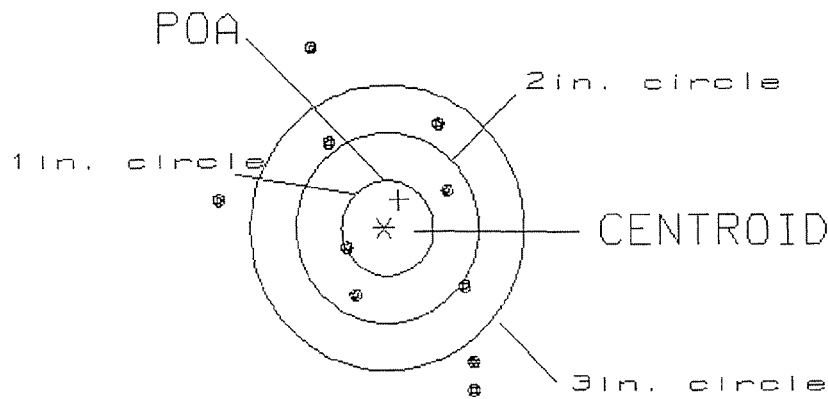
2
 4
 6

PATTERN #: 3
 POA TO CENTROID: .333
 MIN RADIUS : .441
 MEAN RADIUS : 1.295
 MAX RADIUS : 2.017
 CENTROID X : -.154
 CENTROID Y : -.295

3 Nov 2000

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6225006.1.1.1

CENTERFIRE PATTERN # 3



OF SHOTS= 10

IN CIRCLE

HS= 2.85

1

VS= 3.57

3

GS= 3.97

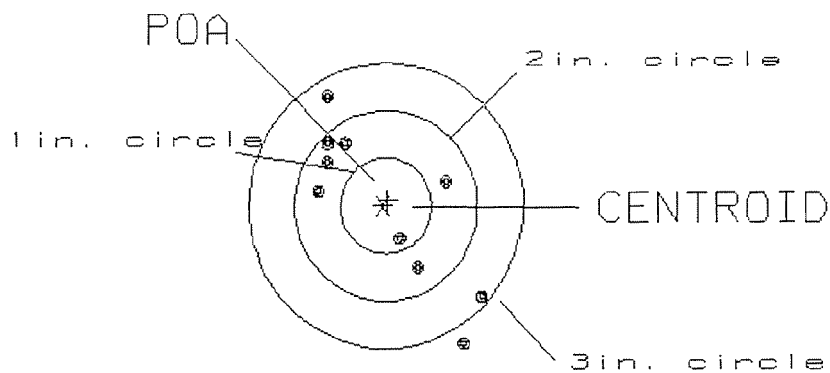
6

PATTERN #: 4
 POA TO CENTROID: .076
 MIN RADIUS : .368
 MEAN RADIUS : .943
 MAX RADIUS : 1.653
 CENTROID X : -.053
 CENTROID Y : -.054

3 Nov 2000

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6225086.1.1.1

CENTERFIRE PATTERN # 4



OF SHOTS= 10

IN CIRCLE

HS= 1.80
 VS= 2.61
 GS= 2.99

1
 7
 9

PATTERN #: 5

POA TO CENTROID: .424

MIN RADIUS : .565

MEAN RADIUS : 1.322

MAX RADIUS : 2.636

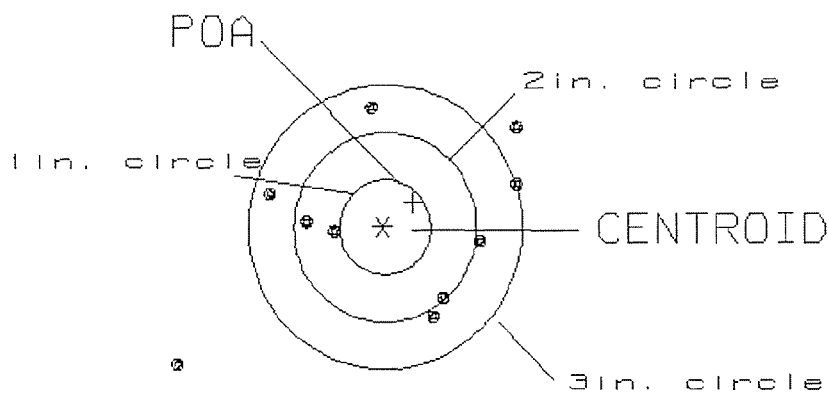
CENTROID X : -.335

CENTROID Y : -.259

3 Nov 2000

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6225006.1.1.1

CENTERFIRE PATTERN # 5



OF SHOTS= 10

IN CIRCLE

HS= 3.69

0

VS= 2.68

2

GS= 4.46

7

M-24

SCORE #
1174

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6225086

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

OVER

OP.#		READINGS	DATE	INITIAL
625	D) Oil Firing Pin Ass'y		1/2/88	RW
cont.	E) Adjust Trigger Pull to Min. Setting and Stake		2/10/88	JS
	F) Safety on Force	5 5 5	2/10/88	JS
	G) Safety off Force	3 3 3	2/10/88	JS
	H) Trigger Pull Test & Retainability		2/10/88	JS
	I) Firing Pin Indent	1021 10215 1021	2/10/88	JS
	J) Assemble Stock		11/7/88	RW
	K) Attach Front & Rear Sight Assemblies		11/7/88	RW
	L) Iron Sight Alignment		11/7/88	RW
	M) Detach Front & Rear Sights & place in numbered container		11/7/88	RW
	N) Attach Scope to Rifle		11/7/88	RW
	O) Detach & Attach Scope 20 times		11/7/88	W.B.
640	Gallery Target & Test	44 R 111L	11-8-88	AC
	A) Optical Clarity of Scope	OK	11-8-88	AC
645	Inspect for Live Ammo	NONE	11-8-88	AC
655	Final Inspection A) Headspace		29 Nov 88	JS
	B) Trigger Pull	2.51 2.47 2.37	2.51 2.43	JS
	C) Function		29 Nov 88	JS
	D) Assemble Swivel Studs		29 Nov 88	JS
660	Pack		15 Dec 88	JS

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6225086

DATE 2/16/88

TESTER R.S.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.41	2.33	2.33	2.51	MIN. SETTING,
PULL #2	2.39	2.33	2.33	2.47	NO AVG. OF 5
PULL #3	2.37	2.29	2.32	2.37	READINGS ACCEPT-
PULL #4	2.34	2.30	2.33	2.51	ABLE LESS THAN 2#
PULL #5	2.35	2.32	2.32	2.43	
TOTAL	11.86	11.57	11.63	12.29	
AVG.	2.372	2.314	2.326	2.458	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.17	3.15		
PULL #2	3.06	3.05		
PULL #3	3.15	3.11		
PULL #4	3.06	3.10		
PULL #5	3.11	3.13		
TOTAL	15.55	15.54		
AVG.	3.11	3.108		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.15	4.15		4.13
PULL #2	4.06	4.10		4.10
PULL #3	4.12	4.13		4.07
PULL #4	4.13	4.13		4.10
PULL #5	4.14	4.12		4.10
TOTAL	20.60	20.63		20.50
AVG.	4.12	4.106		4.10

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6225086

CENTROIDAL DISTANCES

0 TO	1	.707314
1 TO	2	.735445
1 TO	3	.855398
1 TO	4	1.11217
1 TO	5	.833169

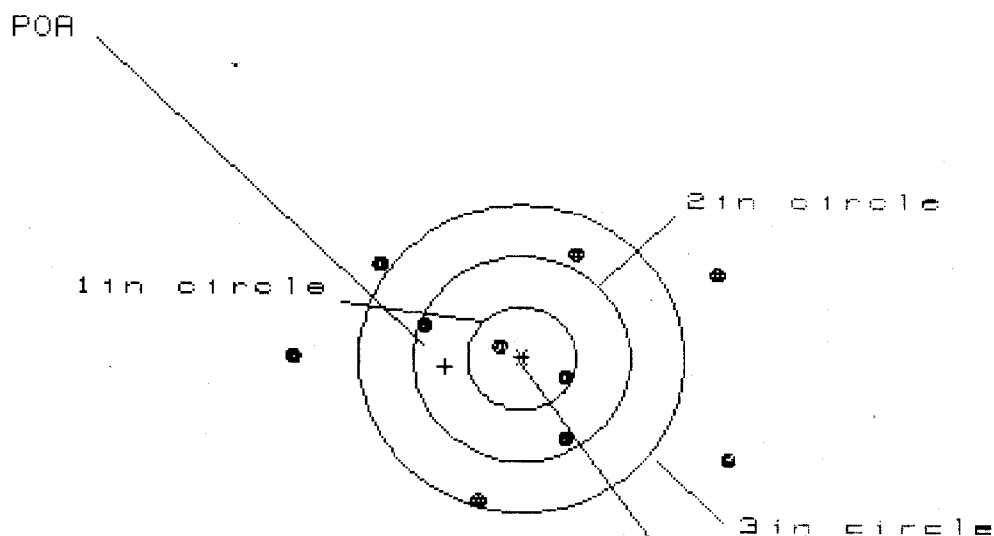
$\frac{4}{5}$ 1 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0296
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .2236
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .225551
THE AMR FOR THIS RIFLE IS: .9998

8 Nov 1988

FILE:/PATTERNING/CENTERFIRE_PATT/08225086

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 2

2in = 4

3in = 6

HS= 3.950

VS= 2.365

GS= 4.077

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.853	1.620	1.756
MINIMUM X	:	-2.097	-1.488	-1.285
MAXIMUM Y	:	.972	.978	.859
MINIMUM Y	:	-1.393	-1.387	-1.506
CENTROID X	:	.703	.936	.733
CENTROID Y	:	.078	.073	.192
POA TO CENTROID in.	:	.707	.938	.758
MIN RADIUS	:	.243	.224	.212
MEAN RADIUS	:	1.273	1.174	1.066
MAX RADIUS	:	2.097	1.881	1.904
HORIZONTAL SPREAD	:	3.950	3.108	3.041
VERTICAL SPREAD	:	2.365	2.365	2.365
EXTREME SPREAD	:	4.077	3.632	3.144
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		6	

8 Nov 1988

FILE:/PATTERNING/CENTERFIRE_PATT/06225006

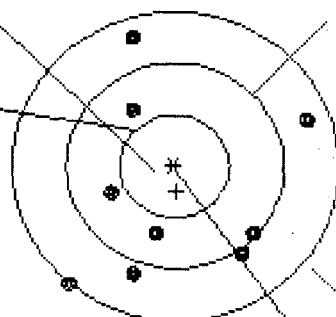
CENTERFIRE PATTERNS # 2

POA

1 in circle

2 in circle

3 in circle



OF SHOTS- 10

IN CIR

1 in - 0

2 in - 4

3 in - 8

HS- 2.251

VS- 3.311

GS- 3.580

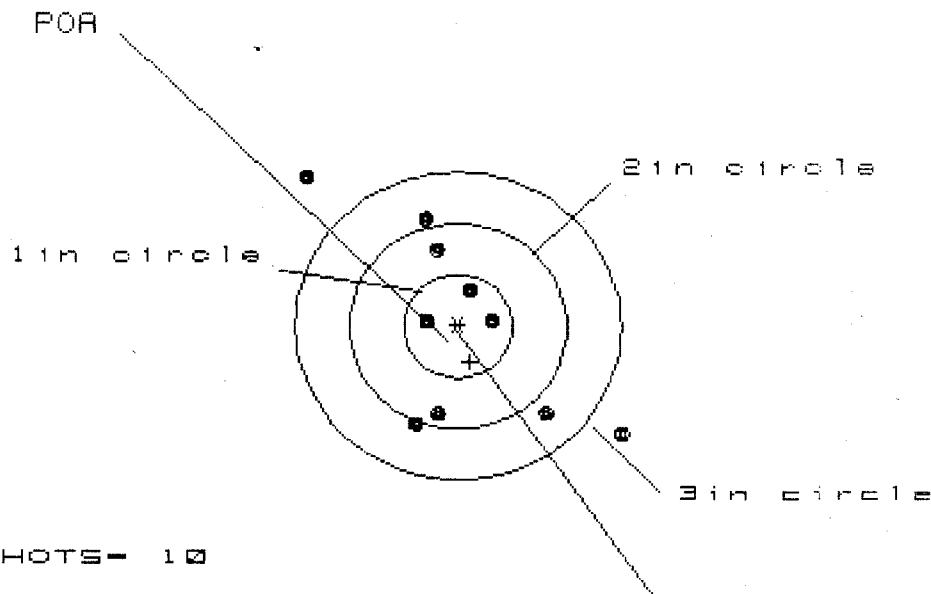
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.216	1.252	1.127
MINIMUM X	-1.035	-.999	-.627
MAXIMUM Y	2.181	1.536	1.425
MINIMUM Y	-1.130	-.887	-.872
CENTROID X	-.013	-.049	.076
CENTROID Y	.246	.003	.114
POA TO CENTROID in.	.246	.049	.137
MIN RADIUS	.581	.401	.548
MEAN RADIUS	1.134	.962	.931
MAX RADIUS	2.206	1.583	1.513
HORIZONTAL SPREAD	2.251	2.251	1.754
VERTICAL SPREAD	3.311	2.423	2.297
EXTREME SPREAD	3.580	2.775	2.387
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	8		

8 Nov 1988

FILE:/PATTERNING/CENTERFIRE_PATT/06225086

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in - 3

2in - 5

3in - 8

HS- 2.926

VS- 2.452

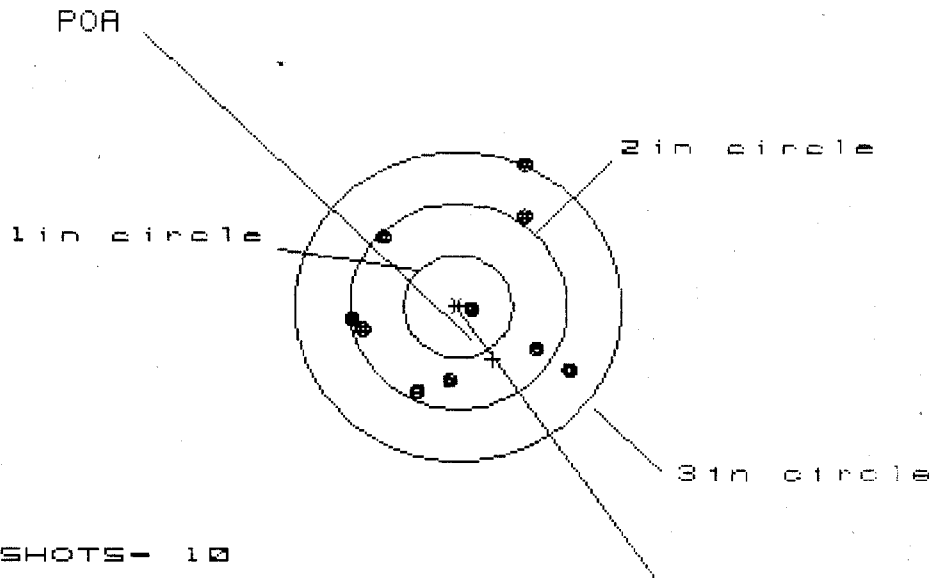
GS- 3.818

PATTERN #	3	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.529	1.374	.776
MINIMUM X	-1.397	-.531	-.359
MAXIMUM Y	1.431	1.199	1.091
MINIMUM Y	-1.021	-.862	-.943
CENTROID X	-.108	.047	-.125
CENTROID Y	.350	.191	.299
POA TO CENTROID in.	.367	.197	.324
MIN RADIUS	.268	.224	.275
MEAN RADIUS	.972	.866	.740
MAX RADIUS	2.000	1.622	1.135
HORIZONTAL SPREAD	2.926	1.905	1.135
VERTICAL SPREAD	2.452	2.061	2.034
EXTREME SPREAD	3.818	2.775	2.185
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	8		

8 Nov 1988

FILE:/PATTERNING/CENTERFIRE_PATT/CG225086

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 6

3 in = 9

HS= 2.065

VS= 2.239

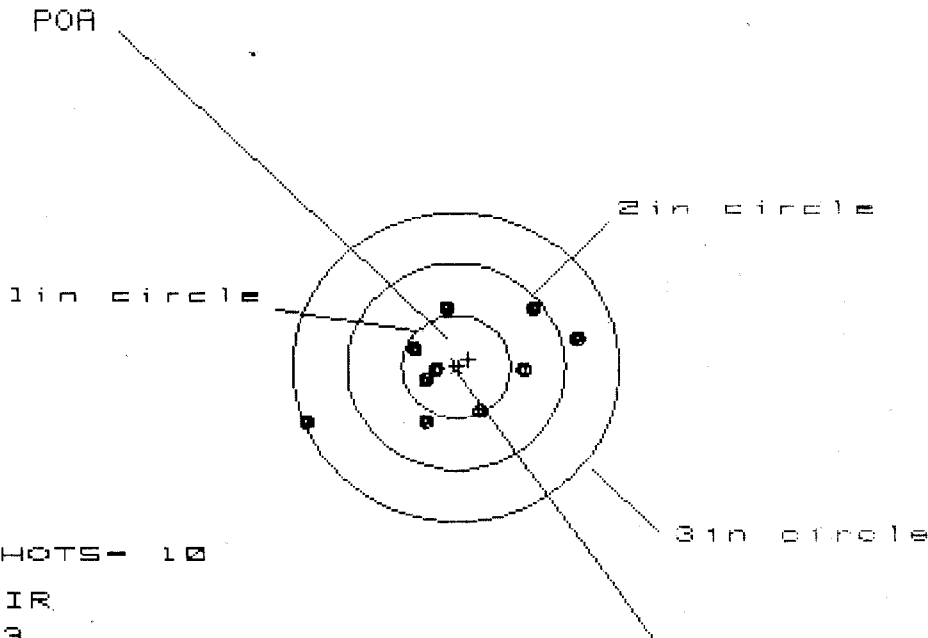
GS= 2.460

PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.035	1.103	.938
MINIMUM X	-1.030	-.962	-.824
MAXIMUM Y	1.396	1.040	.977
MINIMUM Y	-.843	-.688	-.751
CENTROID X	-.318	-.386	-.524
CENTROID Y	.519	.364	.427
POA TO CENTROID in.	.609	.530	.676
MIN RADIUS	.120	.230	.332
MEAN RADIUS	.936	.853	.805
MAX RADIUS	1.523	1.238	1.269
HORIZONTAL SPREAD	2.065	2.065	1.762
VERTICAL SPREAD	2.239	1.728	1.728
EXTREME SPREAD	2.460	2.167	2.004
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	9		

B May 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C6225086

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in - 3

2 in - 8

3 in - 10

HS- 2.551

VS- 1.122

GS- 2.661

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.154	.999	.668
MINIMUM X	:	-1.397	-.580	-.456
MAXIMUM Y	:	.617	.564	.592
MINIMUM Y	:	-.505	-.558	-.530
CENTROID X	:	-.116	.039	-.086
CENTROID Y	:	-.075	-.023	-.051
POA TO CENTROID in.	:	.138	.045	.100
MIN RADIUS	:	.179	.339	.211
MEAN RADIUS	:	.684	.610	.529
MAX RADIUS	:	1.476	1.025	.852
HORIZONTAL SPREAD	:	2.551	1.579	1.124
VERTICAL SPREAD	:	1.122	1.122	1.122
EXTREME SPREAD	:	2.661	1.631	1.437
NUMBER IN ONE INCH CIRCLE =			3	
NUMBER IN TWO INCH CIRCLE =			8	
NUMBER IN THREE INCH CIRCLE =			10	

RECEIVING AND ESTIMATING REPORT

COMMENTS

ORDER
R 94-22616

M-24 ATTN: FRED MARTIN/PAINTED OUTSIDE SHOP

INITIAL FPS	CUSTOMER ORDER NO.					
DATE RECEIVED 08/01/94	DATE OPENED 08/02/94	DATE CODE DI 9-88	SERIAL NUMBER C6225086	NEW SERIAL NUMBER	MODEL AND GRADE 700 7.62	NATO
ACCESSORIES W/STUDS		SCOPE MNTS		SCOPE BASE		

FROM:

DEPT OF THE ARMY
B CO ARMS
2/75 RANGER BATTALION
FT LEWIS

WA 98433

SHIP TO:

DEPT OF THE ARMY
B CO ARMS
2/75 RANGER BATTALION
FT LEWIS

WA 98433

CUST NO: 062072 C.O.D L

ACCOUNT NUMBER	ACCOUNT NUMBER N/C	WRITE ☐	PROM. DATE	ESTIMATED	VIA UPS
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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

New Barrel

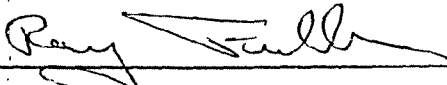
PARTS	COMMENTS
Barrel - 96003	Repairer Coat Trigger Guard Assy, Front + Rear Sight Bases ReZinc Scope Base, Rings + Swivel Studs
W52 H09 4221 H227	
REPAIRMAN	PROOF
GALLERY TESTER	DATE
DATE	DATE
DATE	DATE
DATE	DATE
DATE	DATE

OFFICE COPY

RD6925 REV. 1/94

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

M2400048632

PACKING LIST		PACKED BY <i>Mr. Ray Fuller</i> <i>WG-10 Bn. Armorer</i>		1. NO. BOXES <i>1</i>		2a. REQUISITION NO. <i>92071</i>	
3. END ITEM <i>7.62mm M24 Sniper Weapons System (SW5)</i>		4. DATE <i>26 July 1994</i>		2b. ORDER NO.		5. PAGE <i>1</i> OF <i>1</i> PAGES	
				QUANTITIES REQUIRED			
BOX NO. (a)	CONTENTS - STOCK NUMBER AND NOMENCLATURE (b)	UNIT OF ISSUE (c)	INITIAL OPERATION (d)	RUNNING SPARES (e)	TOTAL (f)		
	<i>7.62mm M24 Sniper Weapon System (SW5) Serial No. C6225086</i> <i>NSN: 1005-01-240-2136</i> <i>Note: All Optic Scope Ring mounts Packed</i>	<i>Ea</i>			<i>1</i>		
6. THIS CERTIFIES THAT ITEMS LISTED HEREON ARE WITHIN THE SPECIFIED BOXES							
TYPED NAME AND TITLE <i>Ray Fuller WG-10 Bn. Armorer</i>			SIGNATURE 				

DD FORM 1750
1 SEP 70

DA FORM 2407
MAY 81

NMP COPY 2

M2400048634

Final Inspection

In: C6225086 DATE REC'D: 8/1/94 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: _____

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6225086
18 Aug 1994

CENTROIDAL DISTANCES

0 TO 1	.137888
1 TO 2	.200232
1 TO 3	.396275
1 TO 4	.666168
1 TO 5	.112539

←----POA

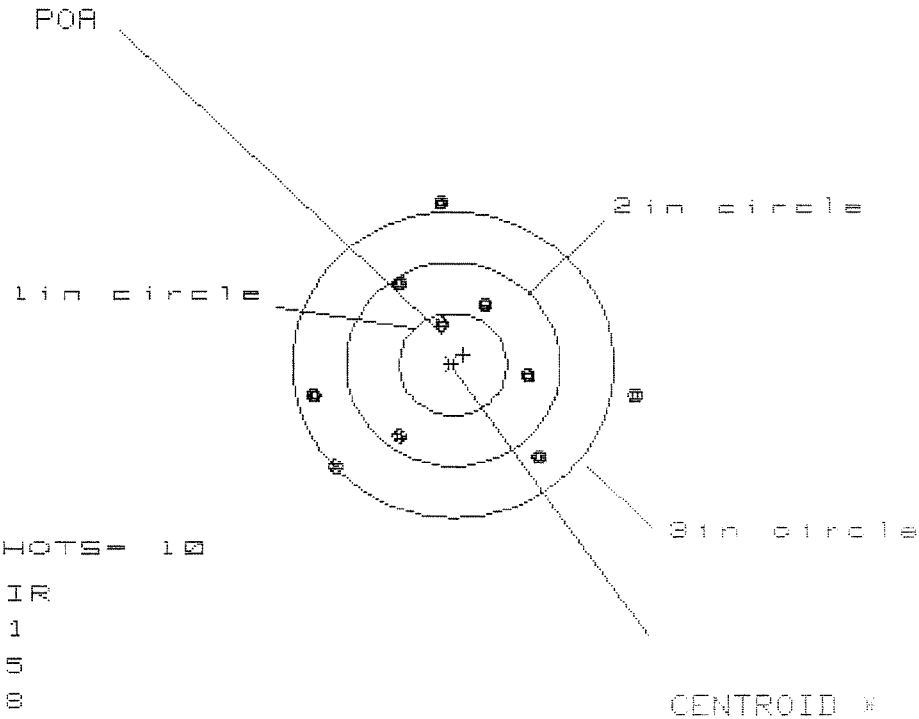
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0308
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.313
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .3145

THE AMR FOR THIS RIFLE IS: 1.107

18 Aug 1994

FILE:/PATTERNING/CENTERFIRE_PATT/08225086

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 5

3 in = 8

HS= 2.993

VS= 2.578

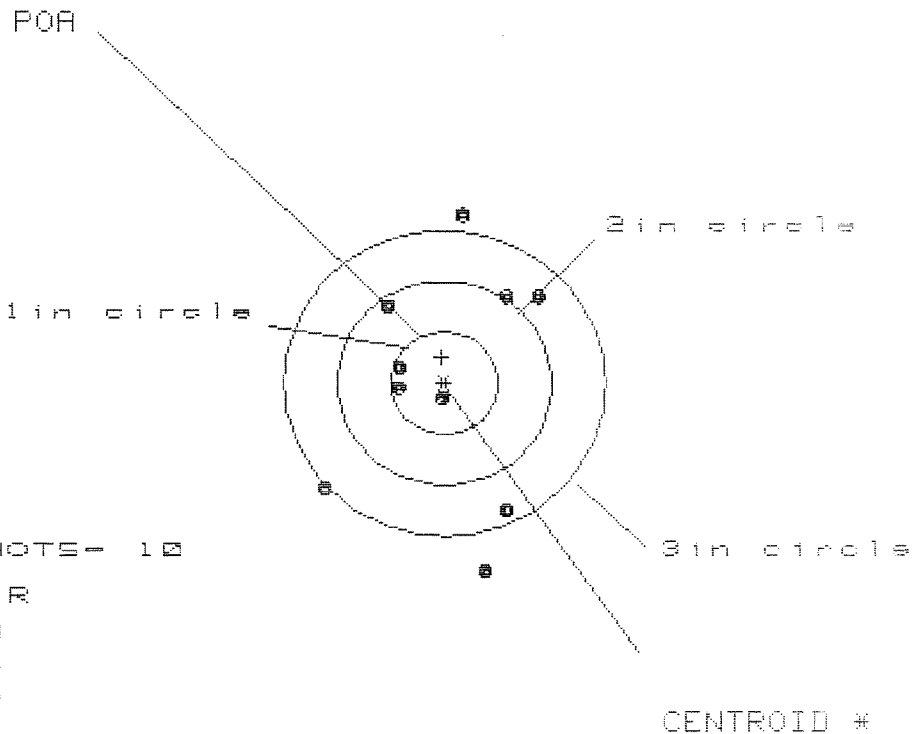
GS= 2.994

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.699	1.034	1.039
MINIMUM X	-1.294	-1.105	-1.100
MAXIMUM Y	1.601	1.573	.952
MINIMUM Y	-.977	-1.005	-.809
CENTROID X	-.098	-.287	-.292
CENTROID Y	-.097	-.069	-.265
POA TO CENTROID in.	.138	.295	.394
MIN RADIUS	.394	.365	.559
MEAN RADIUS	1.092	1.013	.948
MAX RADIUS	1.718	1.573	1.259
HORIZONTAL SPREAD	2.993	2.139	2.139
VERTICAL SPREAD	2.578	2.578	1.761
EXTREME SPREAD	2.994	2.738	2.204
NUMBER IN ONE INCH CIRCLE	= 1		
NUMBER IN TWO INCH CIRCLE	= 5		
NUMBER IN THREE INCH CIRCLE	= 8		

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 4

3 in = 7

HS= 1.947

VS= 3.504

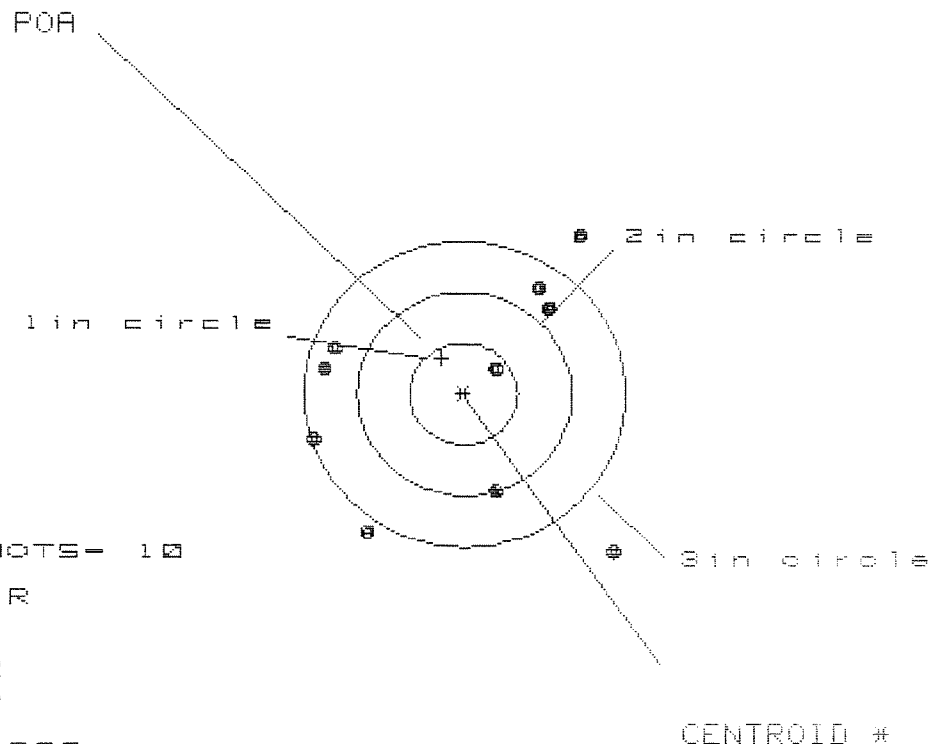
GS= 3.512

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.835	.880	.906
MINIMUM X	:	-1.112	-1.067	-1.041
MAXIMUM Y	:	1.663	1.458	.834
MINIMUM Y	:	-1.841	-1.413	-1.230
CENTROID X	:	.025	-.020	-.046
CENTROID Y	:	-.255	-.050	-.233
POA TO CENTROID in.	:	.256	.054	.237
MIN RADIUS	:	.147	.356	.189
MEAN RADIUS	:	1.055	.946	.864
MAX RADIUS	:	1.885	1.643	1.490
HORIZONTAL SPREAD	:	1.947	1.947	1.947
VERTICAL SPREAD	:	3.504	2.871	2.064
EXTREME SPREAD	:	3.512	2.992	2.701
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		7	

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 2

3 in = 7

HS= 2.768

VS= 3.125

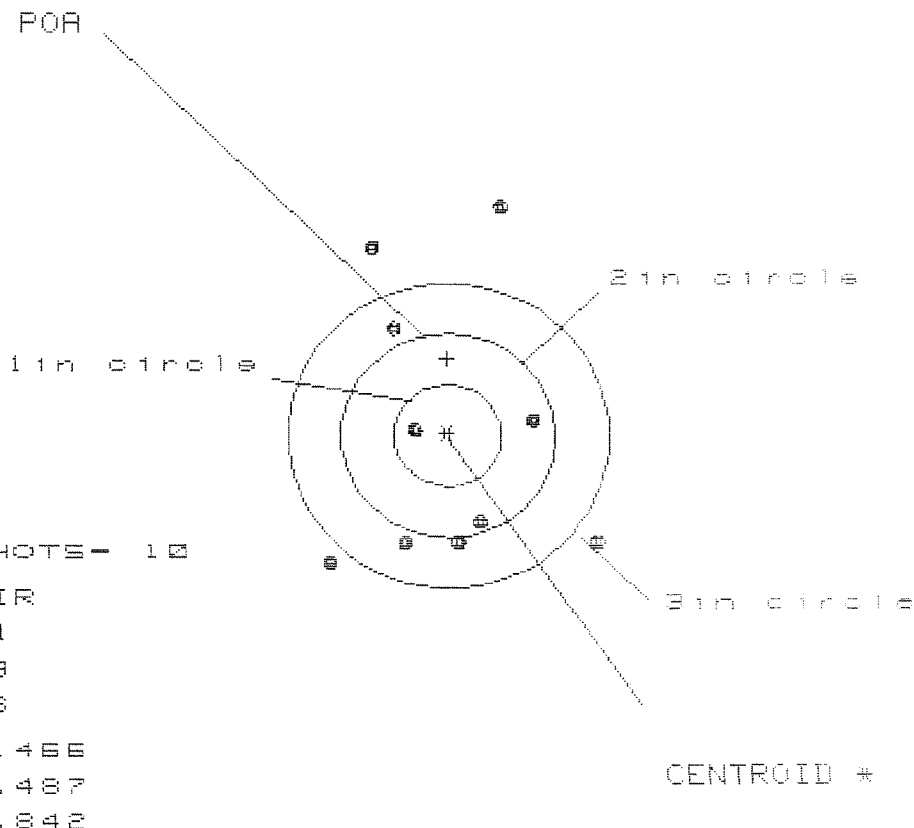
GS= 3.543

PATTERN #	3		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.409	1.221	1.132
MINIMUM X	-1.359	-1.202	-1.050
MAXIMUM Y	1.590	1.420	1.068
MINIMUM Y	-1.535	-1.547	-1.370
CENTROID X	.207	.050	-.102
CENTROID Y	-.350	-.180	-.357
POA TO CENTROID in.	.407	.187	.372
MIN RADIUS	.396	.480	.673
MEAN RADIUS	1.340	1.243	1.154
MAX RADIUS	2.083	1.872	1.487
HORIZONTAL SPREAD	2.768	2.423	2.182
VERTICAL SPREAD	3.125	2.967	2.438
EXTREME SPREAD	3.543	3.543	2.915
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		2	
NUMBER IN THREE INCH CIRCLE =		7	

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CENTERFIRE PATTERNS # 4



OF SHOTS - 10

IN CIR

1in = 1

2in = 3

3in = 6

HS = 2.466

VS = 3.487

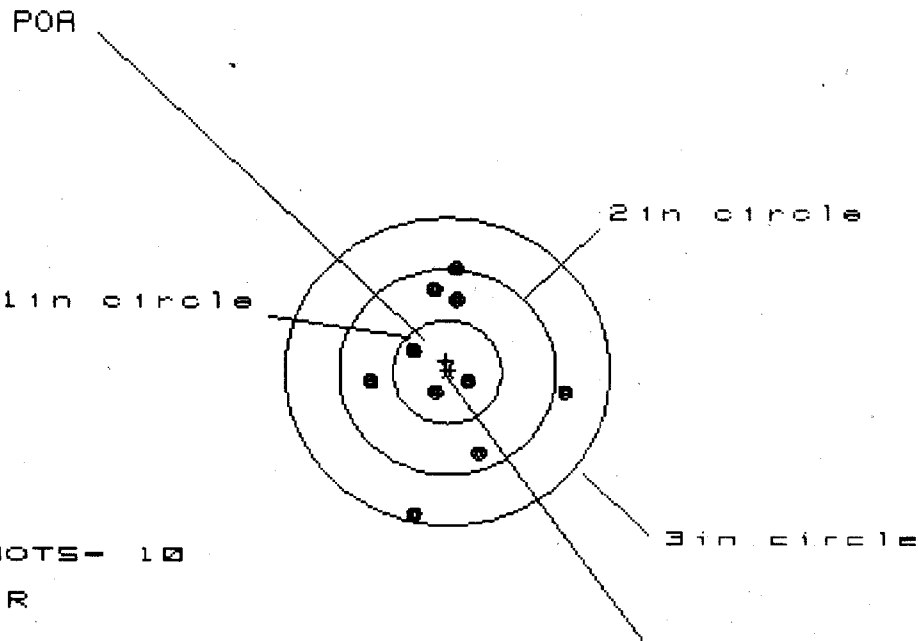
GS = 3.842

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.382	1.440	1.354
MINIMUM X	:	-1.084	-1.026	-1.112
MAXIMUM Y	:	2.237	2.073	1.522
MINIMUM Y	:	-1.250	-1.001	-0.742
CENTROID X	:	.006	-.052	.034
CENTROID Y	:	-.755	-1.004	-1.263
POA TO CENTROID in.	:	.755	1.005	1.263
MIN RADIUS	:	.314	.401	.409
MEAN RADIUS	:	1.304	1.154	.977
MAX RADIUS	:	2.299	2.185	1.614
HORIZONTAL SPREAD	:	2.466	2.466	2.466
VERTICAL SPREAD	:	3.487	3.074	2.264
EXTREME SPREAD	:	3.842	3.610	2.828
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		6	

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 3

2in = 7

3in = 10

HS= 1.752

VS= 2.393

GS= 2.425

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.050	1.015	.380
MINIMUM X	:	-.702	-.737	-.610
MAXIMUM Y	:	1.018	.865	.816
MINIMUM Y	:	-1.375	-.901	-.950
CENTROID X	:	.014	.049	-.078
CENTROID Y	:	-.108	.045	.094
POR TO CENTROID in.	:	.109	.067	.122
MIN RADIUS	:	.204	.294	.277
MEAN RADIUS	:	.743	.666	.595
MAX RADIUS	:	1.411	1.087	1.023
HORIZONTAL SPREAD	:	1.752	1.752	.990
VERTICAL SPREAD	:	2.393	1.766	1.766
EXTREME SPREAD	:	2.425	1.778	1.778
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

CONTRACT # DAAA21-87-C-0086

New Barrel

GUN SERIAL # C6225086

OP. #	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and Stock		8/3/94	RW
600	Proof		8/3/94	RW
607	Check Headspace		8/3/94	RW
610	Dis-assemble Gun		8/3/94	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		8/13/94	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/13/94	RW
	C) Inspect Ejector Hole for Chamfer		8/13/94	RW
	D) Oil Firing Pin Ass'y		8/13/94	RW
	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							
	A) Time							
	B) Malfunctions							
	C) Pierced Primers							
	D) Optical Clarity of Scope							
645	Inspect for Live Ammo							
655	Final Inspection						8/16/94	WB
	A) Headspace							
	B) Trigger Pull	2.42	2.36	2.38	2.42	2.41	8/16/94	WB
	C) Function							
660	Pack							