

C6225110

MODEL 700™ M24

Model 700 M24™

Action

Barrel Length

Capacity

Order No. 5715

*Includes 1 in chamber.

Remington

Address Information

1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41	42	43	44	45	46	47	48	49	50	51	52	53	54	55	56	57	58	59	60	61	62	63	64	65	66	67	68	69	70	71	72	73	74	75	76	77	78	79	80	81	82	83	84	85	86	87	88	89	90	91	92	93	94	95	96	97	98	99	100
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Repair Search

Refresh

Close

Serial Number: C6225 1 1 0

Model: M24 SWS



RE00092854

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6225110.___0
FILE DATE AND TIME: 06/24/2005 08:05

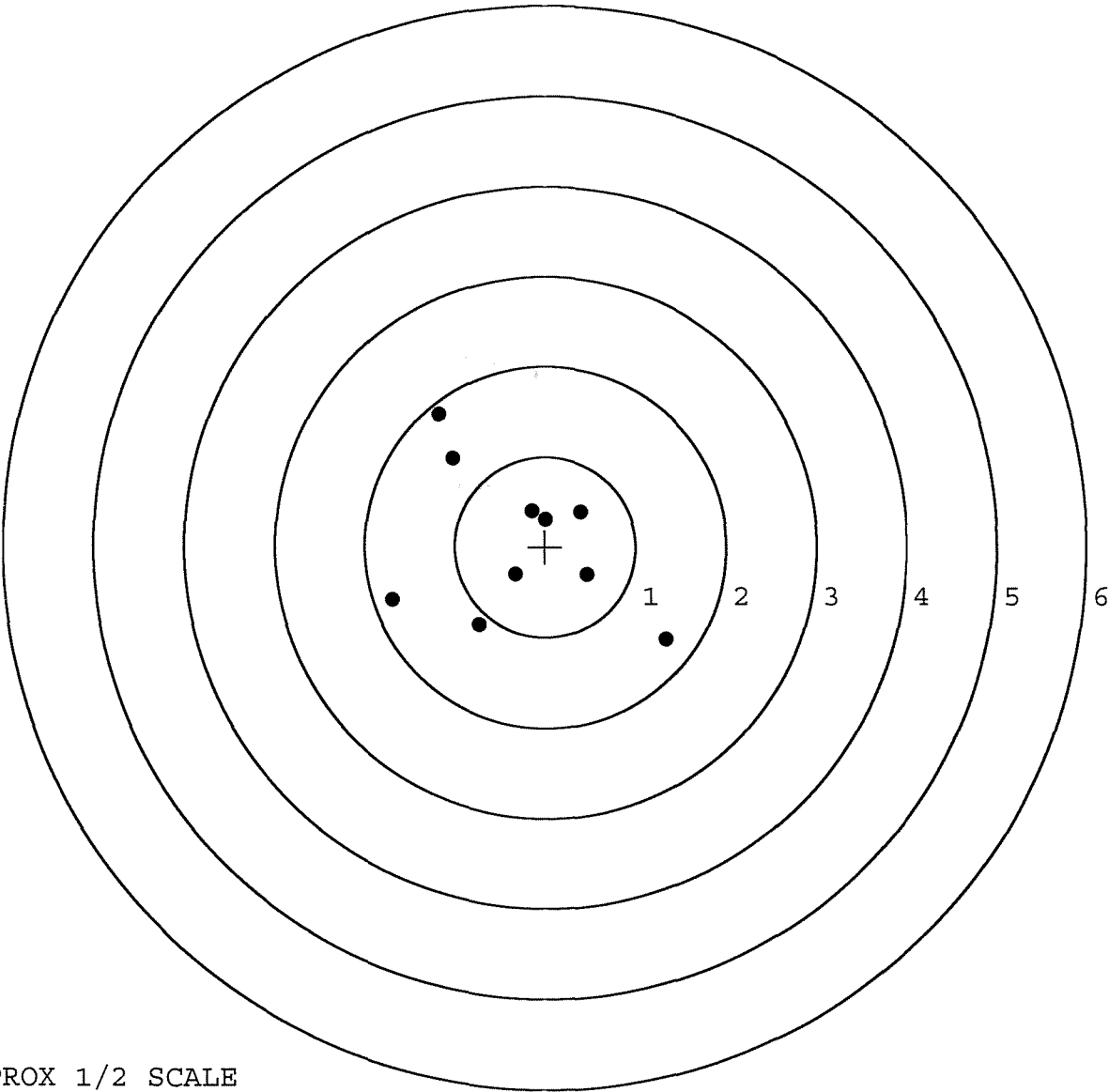
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.080
The Average Y Centroid of the Five Target Set:	-0.099
The Average Point of Impact of the Five Target Set:	0.127
The Average Mean Radius of the Five Target Set:	0.804
The Distance from POA to Centroid Target #1:	0.297
The Distance from Centroid Target #2 to Centroid Target #1:	0.285
The Distance from Centroid Target #3 to Centroid Target #1:	0.365
The Distance from Centroid Target #4 to Centroid Target #1:	0.367
The Distance from Centroid Target #5 to Centroid Target #1:	0.341

SERIAL NUMBER: C6225110. __0
TARGET NUMBER: 1
FILE DATE: 06/24/2005
FILE TIME: 08:05

POINT#	X	Y
1:	1.334	-1.030
2:	0.466	-0.307
3:	0.388	0.392
4:	-0.006	0.302
5:	-0.152	0.398
6:	-0.332	-0.309
7:	-0.735	-0.873
8:	-1.698	-0.599
9:	-1.025	0.974
10:	-1.186	1.466

X CENTROID: -0.295
Y CENTROID: 0.041
POA TO CENTROID: 0.297
HORZ SPREAD: 3.032
VERT SPREAD: 2.496
GROUP SPREAD: 3.547
MIN RADIUS: 0.352
MAX RADIUS: 1.949
MEAN RADIUS: 1.010
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 5
in 3 IN DIAMETER: 7

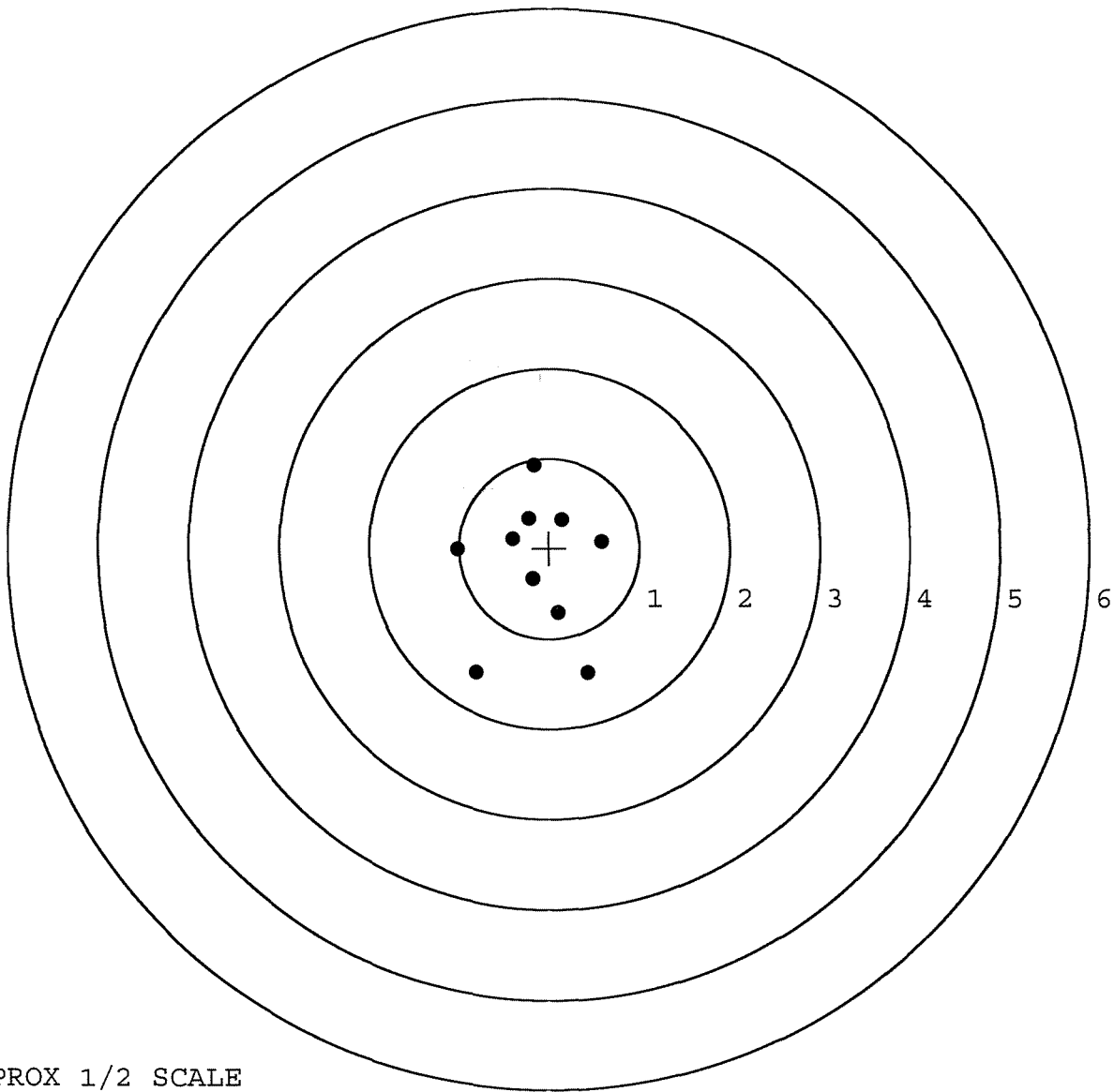


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6225110. __0
TARGET NUMBER: 2
FILE DATE: 06/24/2005
FILE TIME: 08:05

X CENTROID: -0.155
Y CENTROID: -0.208
POA TO CENTROID: 0.260
HORZ SPREAD: 1.601
VERT SPREAD: 2.298
GROUP SPREAD: 2.386
MIN RADIUS: 0.140
MAX RADIUS: 1.338
MEAN RADIUS: 0.770
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.585	0.079
2:	0.135	0.315
3:	-0.167	0.923
4:	-0.229	0.331
5:	-0.401	0.105
6:	-1.016	-0.023
7:	-0.182	-0.345
8:	0.098	-0.714
9:	0.432	-1.375
10:	-0.810	-1.375

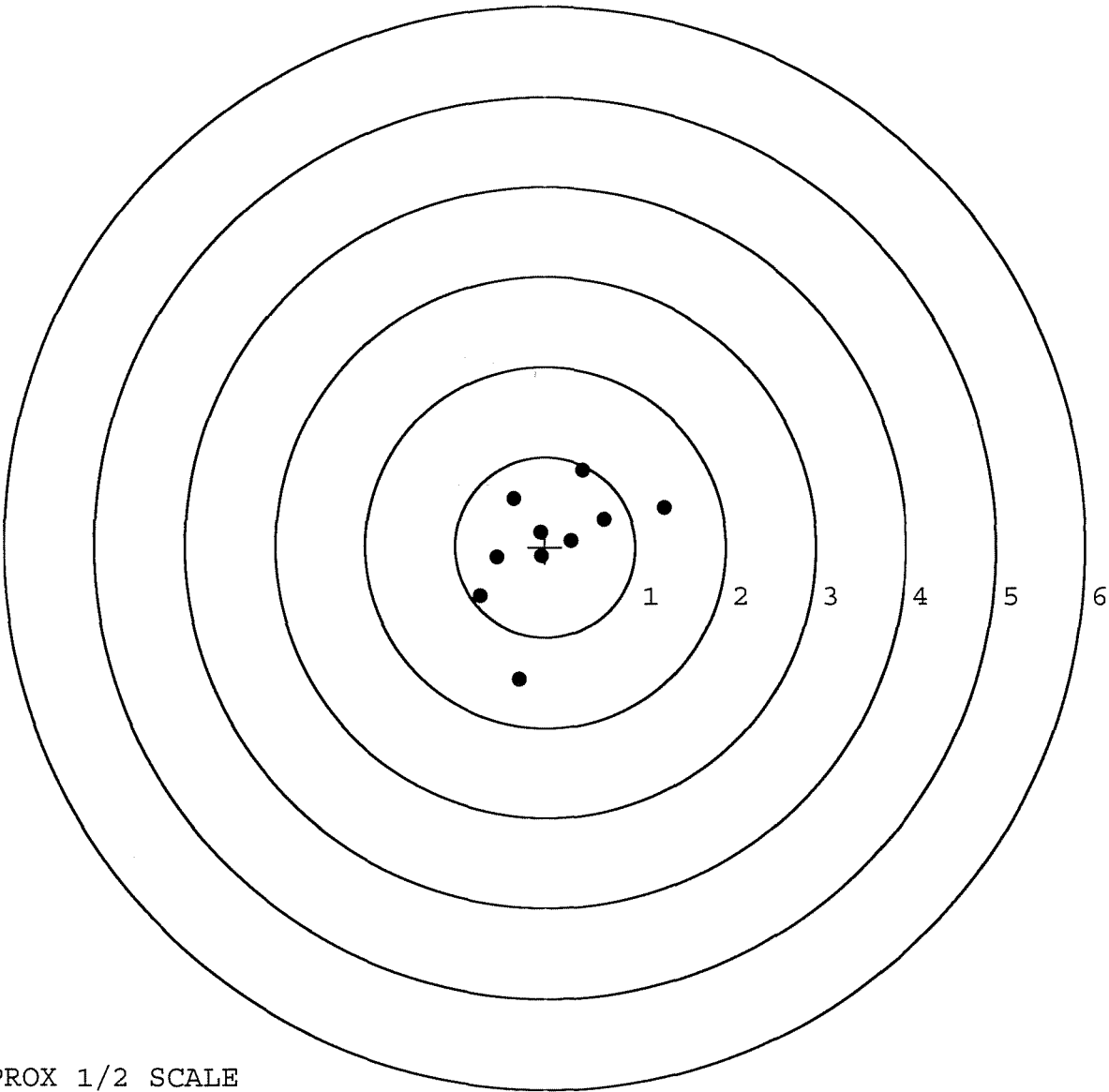


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6225110. __0
TARGET NUMBER: 3
FILE DATE: 06/24/2005
FILE TIME: 08:05

POINT#	X	Y
1:	1.316	0.436
2:	0.418	0.856
3:	0.651	0.312
4:	0.288	0.072
5:	-0.048	0.160
6:	-0.041	-0.105
7:	-0.350	0.535
8:	-0.534	-0.119
9:	-0.721	-0.552
10:	-0.290	-1.473

X CENTROID: 0.069
Y CENTROID: 0.012
POA TO CENTROID: 0.070
HORZ SPREAD: 2.037
VERT SPREAD: 2.329
GROUP SPREAD: 2.495
MIN RADIUS: 0.161
MAX RADIUS: 1.528
MEAN RADIUS: 0.725
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 9

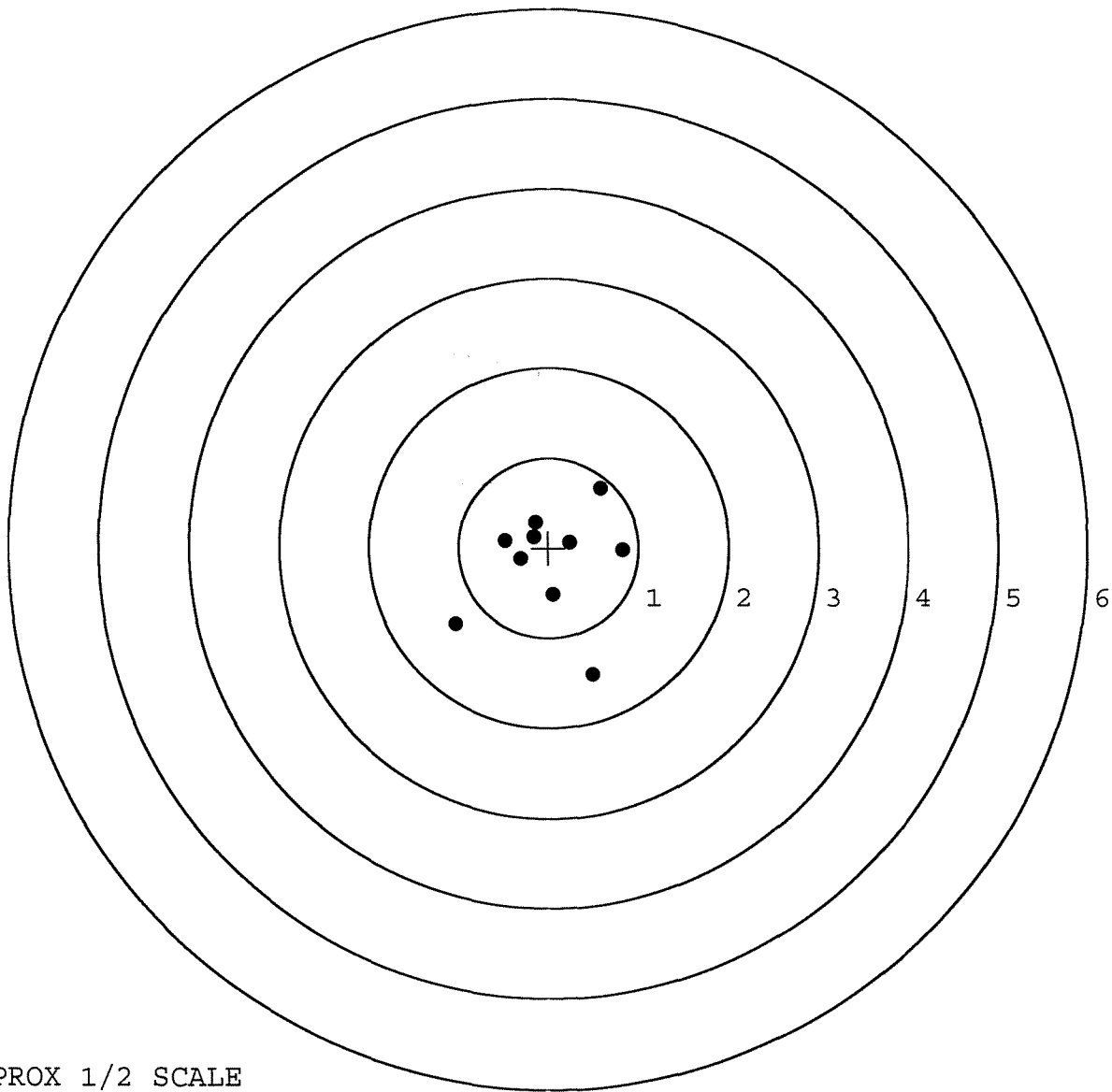


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6225110. 0
TARGET NUMBER: 4
FILE DATE: 06/24/2005
FILE TIME: 08:05

X CENTROID: 0.005
Y CENTROID: -0.171
POA TO CENTROID: 0.171
HORZ SPREAD: 1.858
VERT SPREAD: 2.082
GROUP SPREAD: 2.084
MIN RADIUS: 0.319
MAX RADIUS: 1.329
MEAN RADIUS: 0.679
IN 1 IN DIAMETER: 5
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.490	-1.409
2:	0.051	-0.523
3:	0.826	-0.022
4:	0.236	0.065
5:	0.576	0.673
6:	-1.032	-0.856
7:	-0.144	0.281
8:	-0.160	0.121
9:	-0.311	-0.124
10:	-0.484	0.080

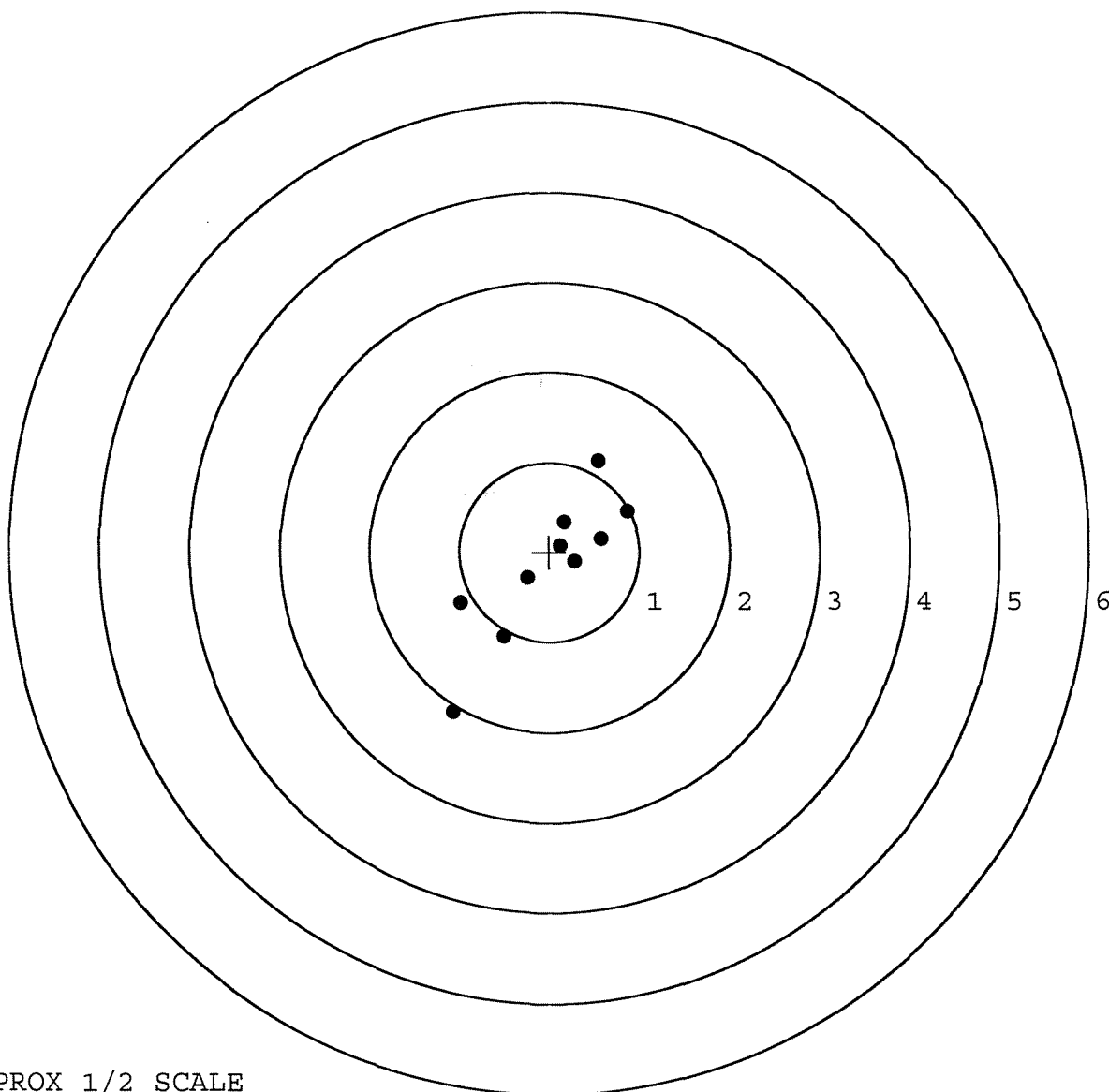


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6225110. 0
TARGET NUMBER: 5
FILE DATE: 06/24/2005
FILE TIME: 08:05

X CENTROID: -0.026
Y CENTROID: -0.168
POA TO CENTROID: 0.170
HORZ SPREAD: 1.930
VERT SPREAD: 2.798
GROUP SPREAD: 3.231
MIN RADIUS: 0.251
MAX RADIUS: 1.921
MEAN RADIUS: 0.835
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 6
in 3 IN DIAMETER: 9

POINT#	X	Y
1:	0.861	0.457
2:	0.546	1.017
3:	-1.069	-1.781
4:	-0.511	-0.950
5:	-0.989	-0.576
6:	-0.243	-0.294
7:	0.579	0.149
8:	0.280	-0.111
9:	0.124	0.072
10:	0.162	0.336



TARGET APPROX 1/2 SCALE

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

R & E NUMBER	92854		
SERIAL NUMBER	C6225110		
LOG-IN DATE	2-10-05		
INSPECT AND VERIFY:			
OPERATION #	OPERATION NAME	DATE	INITIAL
550	DIS-ASSEMBLE GUN	5-26-05	RTZ
560 A	RE-BARREL	6-6-05	RTZ
B	DRILL AND TAP	6-8-05	TRW
575	ASSEMBLE	6-6-05	RTZ
600	PROOF	6-7-05	AC
605	CHECK HEADSPACE	6-7-05	AC
610	DIS-ASSEMBLE GUN	6-7-05	RTZ
612	MAGNAFLUX	6/9/05	unk
615	ROLLMARK CALIBER	6-9-05	CW
618	ROTO-BLAST	6-10-05	KB
620	APPLY COATINGS	6-13-05	CW
625 A	FINAL ASSEMBLY	6-23-05	RTZ
B	TRIGGER PULL TEST		
C	SAFETY "ON" FORCE	6-28-05	AC
D	SAFETY "OFF" FORCE	6-28-05	AC
E	FIRING PIN INDENT	6-28-05	AC
640	TARGET	6-24-05	TRW
655	FINAL INSPECT	6-28-05	AC
660	PACK	7-12-05	DA
		SHIP DATE	
QAR INSPECTION DATE			

INTERCHANGEABILITY

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6225110

OP. #	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and Stock	QUALITY AUDIT	9 12 88	FB
600	Proof		9 19 88	RW
607	Check Headspace		9 19 88	RW
610	Dis-assemble Gun		9 19 88	RW
612	Magnaflux Barrel Action		9 22 88	RK
	Magnaflux Bolt		9 22 88	RK
615	Rollmark Caliber		10/12/88	WC
617	Drill and Tap Sight Holes		10/12/88	FB
618	Polish Barrel		10/12/88	WT
620	Apply Coatings (Barrel Action)		10-31-88	TJA
	Apply Coating (Bolt)		10-31-88	TJA
625	Final Assembly A) Clean inside of Bolt Assembly		11/15/88	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		11/15/88	RW
	C) Inspect Ejector Hole for Chamfer		11/15/88	RW
	D) Oil Firing Pin Ass'y		11/15/88	RW
	E) Adjust Trigger Pull to Min Setting and Stake		15 NOV 88	JS

op. #	OP. NAME	READINGS					DATE	INITIAL
625 cont.	F) Safety On Force	5	5	4			17 NOV 88	JS
	G) Safety Off Force	3	3	3			17 NOV 88	JS
	H) Trigger Pull Test & Retainability						15 NOV 88	JS
	I) Firing Pin Indent	.021	.0215	.0215			17 NOV 88	JS
	J) Assemble Stock						11/17/88	RW
	K) Assemble Swivel Studs						6 Dec 88	JS
	L) Attach Front and Rear Sight Assemblies						12/6/88	RW
	M) Iron Sight Alignment						12/6/88	RW
	N) Detach Front & Rear Sights & place in numbered container						12/6/88	RW
	O) Attach Scope to Rifle						1/28/88	WB
	P) Detach & Attach Scope 20 Times						1/29/88	WB
640	Gallery Target & Test	69 R	83 L				12/5/88	DH
	A) Time							
	B) Malfunctions							
	C) Pierced Primers							
	D) Optical Clarity of Scope						12/5/88	DH
645	Inspect for Live Ammo						12/5/88	DH
655	Final Inspection							
	A) Headspace						6 Dec 88	JS
	B) Trigger Pull	255	268	270	268	265	6 Dec 88	JS
	C) Function						6 Dec 88	JS
660	Pack						12/15/88	RW

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#
3.00# + .75#
4.00# + 1.00#

SERIAL NO. C6225110

DATE 15 NOV 88

TESTER KJS

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.29	2.30	2.30	2.55	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.18	2.25	2.34	2.68	
PULL #3	2.27	2.24	2.28	2.70	
PULL #4	2.23	2.28	2.29	2.68	
PULL #5	2.25	2.28	2.27	2.65	
TOTAL	11.22	11.35	11.48	13.26	
AVG.	2.244	2.27	2.296	2.652	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.08	3.08		
PULL #2	3.07	3.09		
PULL #3	3.05	3.08		
PULL #4	3.06	3.12		
PULL #5	3.12	3.12		
TOTAL	15.38	15.49		
AVG.	3.076	3.098		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.11	4.16		4.15
PULL #2	4.08	4.24		4.09
PULL #3	4.14	4.19		4.16
PULL #4	4.19	4.18		4.16
PULL #5	4.16	4.16		4.18
TOTAL	20.68	20.93		20.64
AVG.	4.136	4.186		4.128

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6225110

CENTROIDAL DISTANCES

0 TO	1	.628797
1 TO	2	1.12432
1 TO	3	.250521
1 TO	4	.513741
1 TO	5	.889351

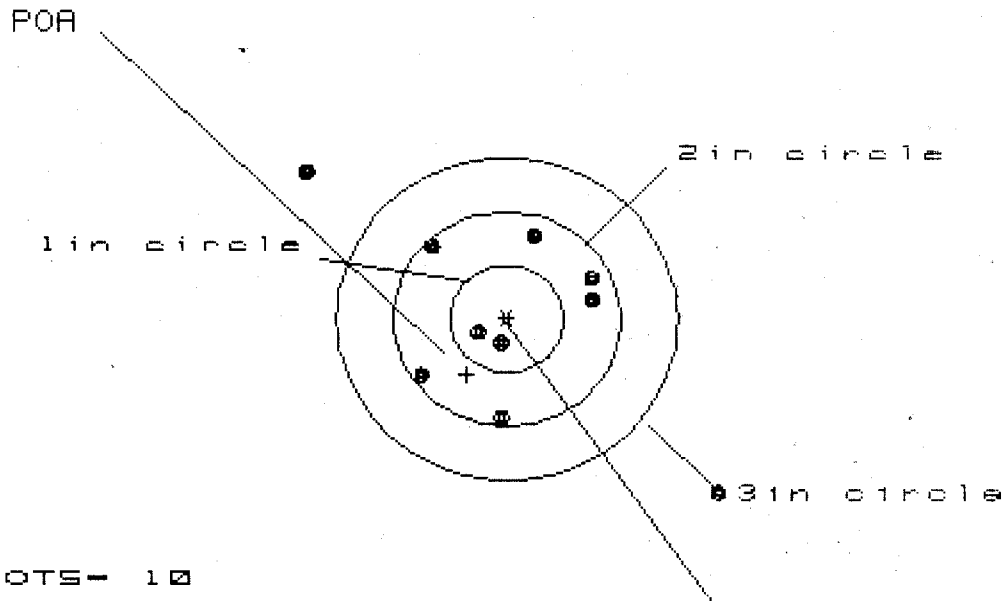
5
4
3
2
←----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1644
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .3256
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .36475
THE AMR FOR THIS RIFLE IS: .9648

6 Dec 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C6225110

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 8

3 in = 8

HS= 3.678

VS= 2.992

GS= 4.741

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.891	.979	.781
MINIMUM X	-1.787	-1.576	-.788
MAXIMUM Y	1.338	1.154	.787
MINIMUM Y	-1.654	-1.103	-.959
CENTROID X	.355	.144	.342
CENTROID Y	.519	.703	.559
POA TO CENTROID in.	.629	.718	.655
MIN RADIUS	.229	.293	.265
MEAN RADIUS	1.052	.894	.724
MAX RADIUS	2.513	1.954	.961
HORIZONTAL SPREAD	3.678	2.555	1.569
VERTICAL SPREAD	2.992	2.257	1.746
EXTREME SPREAD	4.741	2.827	1.790
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	8		
NUMBER IN THREE INCH CIRCLE =	8		

6 Dec 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C6225110

CENTERFIRE PATTERNS # 2

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS- 10

IN CIR

1 in - 2

2 in - 5

3 in - 9

HS- 2.074

VS= 3.474

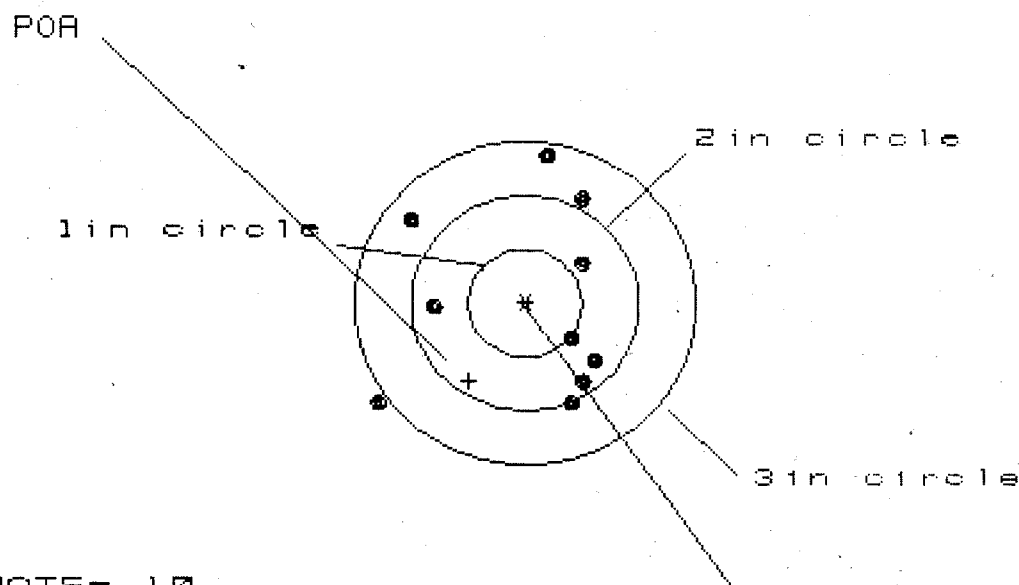
GS= 3.476

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.993	.955	.922
MINIMUM X	:	-1.081	-1.119	-1.152
MAXIMUM Y	:	1.308	1.067	.661
MINIMUM Y	:	-2.166	-1.006	-.872
CENTROID X	:	.474	.512	.545
CENTROID Y	:	-.599	-.358	-.492
POA TO CENTROID in.	:	.764	.625	.734
MIN RADIUS	:	.440	.239	.368
MEAN RADIUS	:	1.029	.847	.819
MAX RADIUS	:	2.194	1.178	1.242
HORIZONTAL SPREAD	:	2.074	2.074	2.074
VERTICAL SPREAD	:	3.474	2.073	1.533
EXTREME SPREAD	:	3.476	2.311	2.311
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

6 Dec 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C6225110

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in - 1

2in - 5

3in - 9

HS- 1.875

VS= 2.276

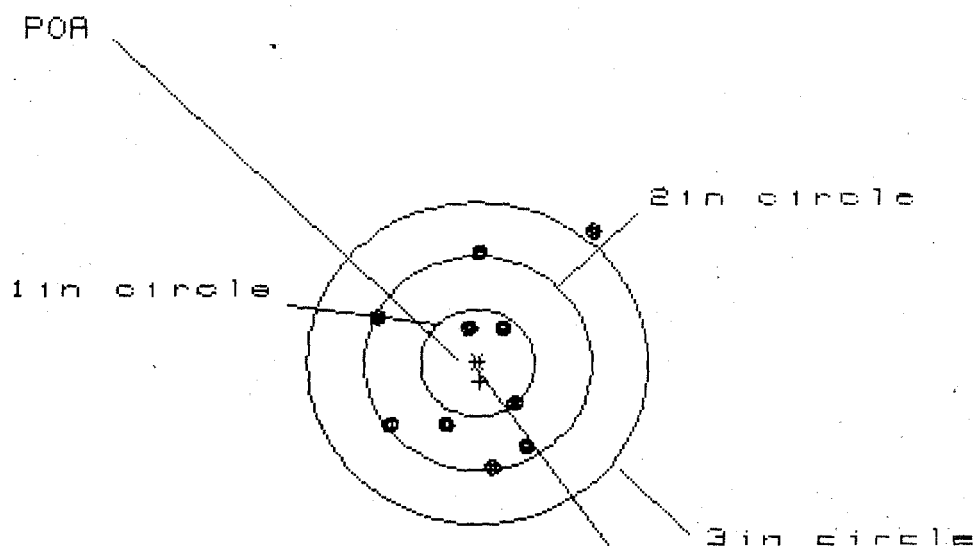
GS= 2.730

PATTERN #	:	3	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.561	.415	.420
MINIMUM X	:	-1.314	-1.167	-1.162
MAXIMUM Y	:	1.342	1.238	1.009
MINIMUM Y	:	-.934	-1.036	-.881
CENTROID X	:	.499	.645	.640
CENTROID Y	:	.724	.828	.673
POA TO CENTROID in.	:	.879	1.049	.928
MIN RADIUS	:	.484	.452	.345
MEAN RADIUS	:	.993	.903	.836
MAX RADIUS	:	1.612	1.327	1.403
HORIZONTAL SPREAD	:	1.875	1.582	1.582
VERTICAL SPREAD	:	2.276	2.274	1.890
EXTREME SPREAD	:	2.730	2.285	2.204
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

6 Dec 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C6225110

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 8

3 in = 9

HS= 1.846

VS= 2.153

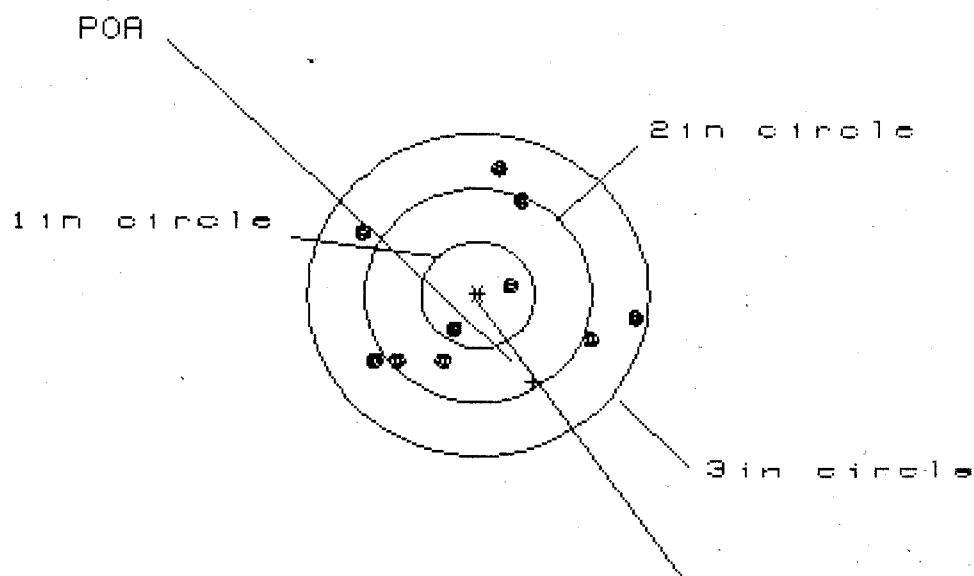
GS= 2.505

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.988	.498	.511
MINIMUM X	:	-.858	-.748	-.735
MAXIMUM Y	:	1.198	1.180	.704
MINIMUM Y	:	-.955	-.822	-.674
CENTROID X	:	-.022	-.132	-.145
CENTROID Y	:	.170	.037	-.111
POA TO CENTROID in.	:	.171	.137	.182
MIN RADIUS	:	.337	.465	.367
MEAN RADIUS	:	.821	.729	.653
MAX RADIUS	:	1.553	1.185	1.018
HORIZONTAL SPREAD	:	1.846	1.246	1.246
VERTICAL SPREAD	:	2.153	2.002	1.378
EXTREME SPREAD	:	2.505	2.006	1.707
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	

6 Dec 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C6225110

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR.

1in = 2

2in = 5

3in = 10

HS= 2.442

VS= 1.842

GS= 2.582

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	1.425
MINIMUM X	-1.017
MAXIMUM Y	1.210
MINIMUM Y	-.632
CENTROID X	-.484
CENTROID Y	.814
POA TO CENTROID in.	.947
MIN RADIUS	.249
MEAN RADIUS	.929
MAX RADIUS	1.449
HORIZONTAL SPREAD	2.442
VERTICAL SPREAD	1.842
EXTREME SPREAD	2.582
NUMBER IN ONE INCH CIRCLE =	2
NUMBER IN TWO INCH CIRCLE =	5
NUMBER IN THREE INCH CIRCLE =	10

INTERCHANGEABILITY

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6225110

CENTROIDAL DISTANCES

0	TO	1	.159028
1	TO	2	.0876926
1	TO	3	.196987
1	TO	4	.39368
1	TO	5	.145121

43 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0044
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0688
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0689406
THE AMR FOR THIS RIFLE IS: .7352

INTERCHANGEABILITY

13 Dec 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C6225110.1

CENTERFIRE PATTERNS

1

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS - 10

IN CIR

1 in = 1

2 in = 6

3 in = 9

HS = 2.355

VS = 2.245

GS = 2.749

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.190	1.061	.927
MINIMUM X	-1.165	-1.070	-.571
MAXIMUM Y	1.011	.873	.756
MINIMUM Y	-1.234	-.938	-.929
CENTROID X	.129	.258	.392
CENTROID Y	-.093	.045	.162
POA TO CENTROID in.	.158	.262	.424
MIN RADIUS	.292	.287	.368
MEAN RADIUS	.885	.766	.675
MAX RADIUS	1.697	1.423	.946
HORIZONTAL SPREAD	2.355	2.131	1.498
VERTICAL SPREAD	2.245	1.811	1.685
EXTREME SPREAD	2.749	2.305	1.719
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	9		

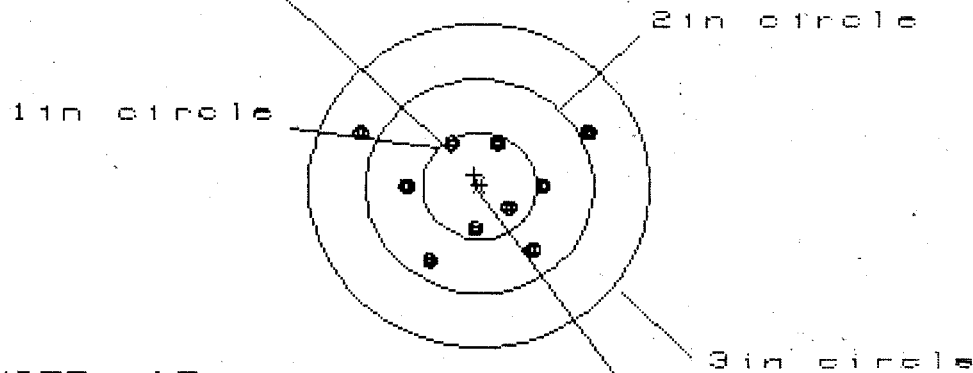
13 Dec 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C6225110.1

CENTERFIRE PATTERNS

2

POA



OF SHOTS- 10

IN CIR.

1in = 4

2in = 8

3in = 10

HS= 2.010

VS= 1.202

GS= 2.010

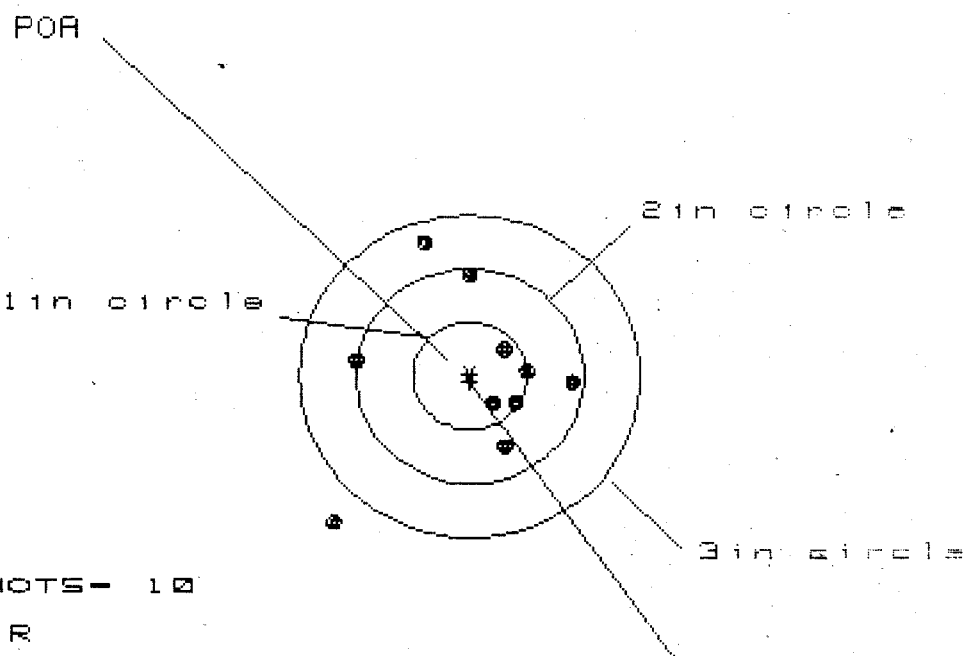
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.976	.862	.559
MINIMUM X	:	-1.034	-.762	-.655
MAXIMUM Y	:	.537	.591	.546
MINIMUM Y	:	-.665	-.605	-.531
CENTROID X	:	.042	.157	.050
CENTROID Y	:	-.104	-.164	-.238
POA TO CENTROID in.	:	.112	.227	.243
MIN RADIUS	:	.280	.156	.212
MEAN RADIUS	:	.671	.599	.539
MAX RADIUS	:	1.165	1.045	.719
HORIZONTAL SPREAD	:	2.010	1.624	1.214
VERTICAL SPREAD	:	1.202	1.196	1.077
EXTREME SPREAD	:	2.010	1.882	1.300
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	

13 Dec 1988

FILE:/PATTERNING/CENTERFIRE_PATT/06225110.1

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 3

2in = 7

3in = 9

HS= 2.148

VS= 2.560

GS= 2.678

CENTROID *

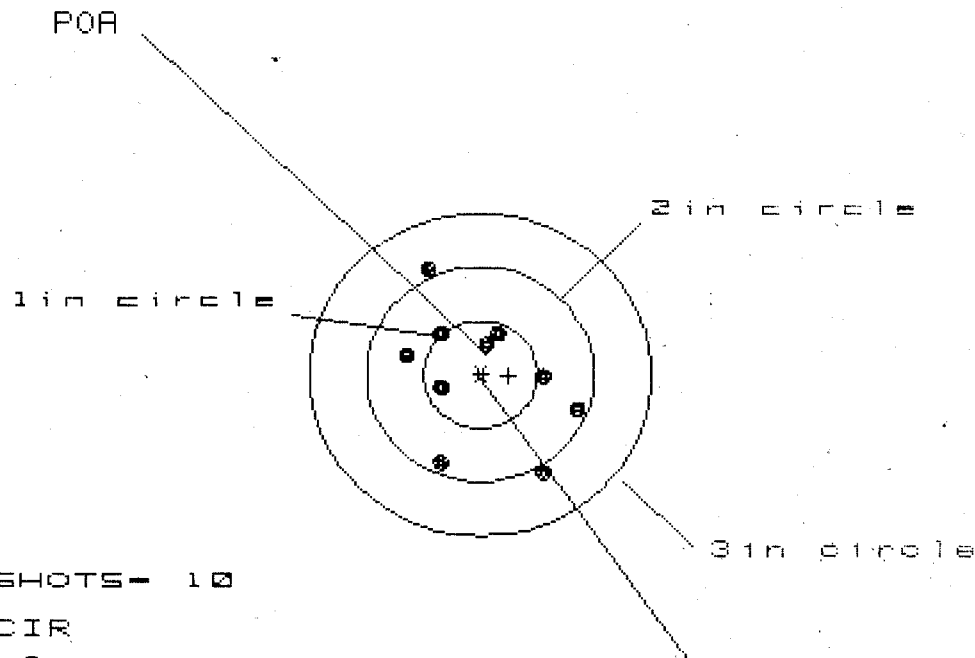
PATTERN #	:	3	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.950	.817	.749
MINIMUM X	:	-1.198	-1.170	-1.238
MAXIMUM Y	:	1.208	1.057	.951
MINIMUM Y	:	-1.352	-.844	-.712
CENTROID X	:	-.001	.132	.200
CENTROID Y	:	.055	.206	.073
POA TO CENTROID in.	:	.055	.244	.213
MIN RADIUS	:	.335	.190	.254
MEAN RADIUS	:	.851	.707	.606
MAX RADIUS	:	1.807	1.190	1.242
HORIZONTAL SPREAD	:	2.148	1.987	1.987
VERTICAL SPREAD	:	2.560	1.901	1.662
EXTREME SPREAD	:	2.678	2.015	1.991
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

INTERCHANGEABILITY

13 Dec 1988

FILE://PATTERNING/CENTERFIRE_PATT/08225110.1

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 8

3 in = 10

HS= 1.544

VS= 1.893

GS= 2.160

PATTERN #	:	4	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.876	.941	.892
MINIMUM X	:	-.668	-.603	-.652
MAXIMUM Y	:	.963	.860	.388
MINIMUM Y	:	-.930	-.943	-.835
CENTROID X	:	-.249	-.314	-.265
CENTROID Y	:	.017	.120	.012
POA TO CENTROID in.	:	.250	.336	.265
MIN RADIUS	:	.306	.240	.314
MEAN RADIUS	:	.680	.610	.580
MAX RADIUS	:	1.097	1.046	.958
HORIZONTAL SPREAD	:	1.544	1.544	1.544
VERTICAL SPREAD	:	1.893	1.803	1.223
EXTREME SPREAD	:	2.160	1.875	1.647
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	

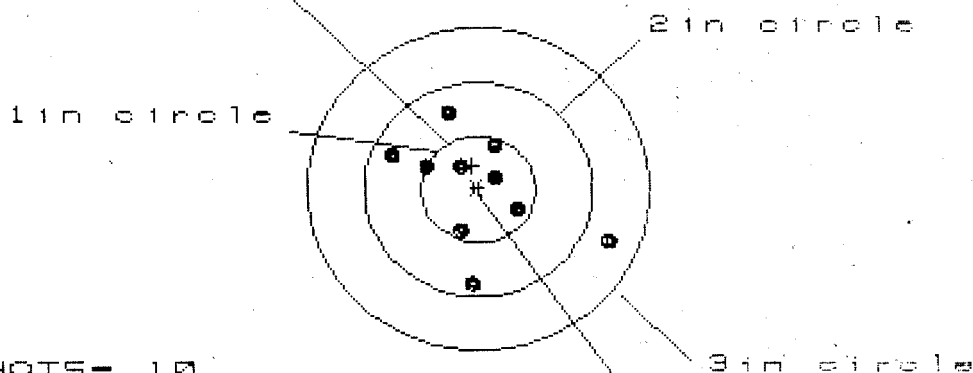
INTERCHANGEABILITY

13 Dec 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C6225110.1

CENTERFIRE PATTERNS # 5

POA



OF SHOTS- 10

IN CIR

1in - 6

2in - 9

3in - 10

HS- 1.874

VS- 1.589

GS- 2.016

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.160	.514	.518
MINIMUM X	-.714	-.585	-.581
MAXIMUM Y	.724	.671	.557
MINIMUM Y	-.865	-.918	-.594
CENTROID X	.057	-.072	-.076
CENTROID Y	-.219	-.166	-.052
POA TO CENTROID in.	.226	.181	.092
MIN RADIUS	.177	.148	.061
MEAN RADIUS	.589	.497	.419
MAX RADIUS	1.253	.918	.641
HORIZONTAL SPREAD	1.874	1.099	1.099
VERTICAL SPREAD	1.589	1.589	1.151
EXTREME SPREAD	2.016	1.597	1.200
NUMBER IN ONE INCH CIRCLE =		6	
NUMBER IN TWO INCH CIRCLE =		9	
NUMBER IN THREE INCH CIRCLE =		10	

RECEIVING AND ESTIMATING REPORT

R93-17669

INITIAL

CUSTOMER ORDER NO.

ATTN: FRED MARTIN

M-24 W/ULTRA 10X-M3A SCOPE

FPS

DATE RECEIVED

DATE OPENED

DATE CODE

SERIAL NUMBER

NEW SERIAL NUMBER

MODEL AND GRADE

08/25/93

08/25/93

DI 9-88

C6225110

700 7.62

NATO

ACCESSORIES

W/STUDS

W/SWIVELS

SOFT CASE

SCOPE MNTS

SCOPE BASE

FROM:

SHIP TO:

DEPT OF THE ARMY
B CO. 5TH BATTALION 20TH INF.
UNIT 15096

APO SAN FRANCISCO CA 96224

DEPT OF THE ARMY
B CO. 5TH BATTALION 20TH INF.
UNIT 15096

APO SAN FRANCISCO CA 96224

CUST NO:082642 C.O.D

ACCOUNT NUMBER

ACCOUNT NUMBER N/C

WRITE ☐

PROM. DATE

ESTIMATED

VIA

P188580706

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

Scope lens Cracked Moisture Inside of Scope
Trigger Broken, Finish Worn

ARTS

COMMENTS

Barrel Assy - 96002
Trigger Assy - 96024

ReZinc - Scope Base, Scope R
Swivels & Swivel Studs.
Re powder coat - Floor plate, lat
Trigger Guard, Front & Rear
Sight Bases

REPAIRMAN

PROOF

CLEAN

TEST

TARGET

PATTERN

GALLERY TESTER

DATE

DATE

DATE

DATE

DATE

OFFICE COPY

RD6925 REV. 1/92

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER

M2400049233

DA Label 18, Mar 83
Edition of Apr 59 will be used until exhausted.

DEPARTMENT OF THE ARMY

COMMANDER
B 5-20 IN (M)
APO AP 92246

OFFICIAL BUSINESS
PENALTY FOR PRIVATE USE, \$300

REMINGTON ARMS CO INC
14 HOEFLER AVE
ILION NY 13357

CERTIFIED

P 188 580 706

MAIL

DA Label 18, Mar 83
Edition of Apr 69 will be used until exhausted.

DEPARTMENT OF THE ARMY

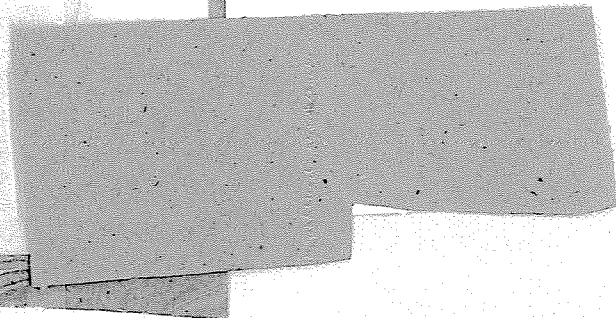
COMMANDER
B 5-20 IN (M)
APO AP 92246

OFFICIAL BUSINESS
PENALTY FOR PRIVATE USE, \$300

REMINGTON ARMS CO INC
14 HOFELER AVE
ILION NY 13357

PSFC SHEPARD

Ronald Shepherd



REQ. SINGLE LINE ITEM										REQUISITION SYSTEM DOCUMENT (MECHANICAL)										DD FORM 1348m 1 MAR 74 EDITION OF 1 APR 71 MAY BE USED									
REQ. IDENT. NO.										REQ. IDENT. NO.										REQ. IDENT. NO.									
REQ. IDENT. NO.										REQ. IDENT. NO.										REQ. IDENT. NO.									
A0E										1005-01-240-2136										EA 000001									
W T4WTU										311880102 N W A4FB0										MILSTRIP EXCESS REPORT:									
4WV										THIS WEAPON IS NOT EXCESS. THIS WEAPON IS FOR REPAIR AND RETURN										POC: 1LT ROGERS 730-2469									
3 T										R95387										7.62 MM M24 RIFLE SNIPER WEAPON SYSTEM									
										SN: C6225110																			

REQUISITION SYSTEM DOCUMENT (MECHANICAL)										REQUISITION SYSTEM DOCUMENT (ELECTRONIC)									
DOCUMENT IDENTIFIER										DOCUMENT IDENTIFIER									
STOCK NUMBER										STOCK NUMBER									
QUANTITY										QUANTITY									
FUND										FUND									
PROJECT										PROJECT									
PROR										PROR									
VARIABLE DATA ELEMENTS										VARIABLE DATA ELEMENTS									
DEPENDENT ON										DEPENDENT ON									
DOCUMENT IDENTIFIER CODE										DOCUMENT IDENTIFIER CODE									
FTE										1005-01-240-2136									
EA 00001																			
WT4WTU										31880101									
N W A4FB0										MILSTRIP EXCESS REPORT:									
4WV										THIS WEAPON IS NOT EXCESS. THIS									
										WEAPON IS FOR REPAIR & RETURN									
										POC: 1LT ROGERS, 730-2469									
3 T										R95387									
										7.62MM M24 RIFLE SNIPER WEAPON SYSTEM									
										SN: C6225110									

DD FORM 1348-1 MAR 74 EDITION OF 1 APR 71 MAY BE USED

U.S. Government Printing Office: 1989-244-058

1		2		3		4		5		6		7		8		9		10		11		12		13		14		15		16		17		18		19		20		21		22		23		24		25		26		27		28		29		30		31		32		33		34		35		36		37		38		39		40		41		42		43		44		45		46		47		48		49		50		51		52		53		54		55		56		57		58		59		60		61		62		63		64		65		66		67		68		69		70		71		72		73		74		75		76		77		78		79		80	
DOC. IDENT.		RI FROM		M & S		STOCK NUMBER		FSC		NIIN		ADD		QUANTITY		DOCUMENT NUMBER		REQUISITIONER		DATE		SERIAL		SUPPLEMENTARY ADDRESS		FUND		DISTRIBUTION		PROJECT		POLICY		REQ'D DEL DATE		ADVANCE		RI		UNIT PRICE		DOLLARS		CTS.																																																																																																																			
FTE						1005-01-240-2136								00001		W T4WTU31880101								WA4FB0																						5,145.00																																																																																																																	
SHIPPED FROM B-5/20 INF BN CAMP CASEY, KOREA APO AP 96224																SHIP TO CDR, US ARMY ARMAMENT, MUNITIONS & CHEMICAL CMD. ATTN: AMSMC-PCS-NB ROCK ISLAND, ILL., 61299-6000																MARK FOR		PROJECT										TOTAL PRICE		DOLLARS		CTS.																																																																																																															
WAREHOUSE LOCATION																TYPE OF CARGO		UNIT PACK		UNIT WEIGHT		UNIT CUBE		UFC		NMFC		FREIGHT RATE		DOCUMENT DATE		MAT COND		QUANTITY																																																																																																																													
SUBSTITUTE DATA (ITEM ORIGINALLY REQUESTED)																FREIGHT CLASSIFICATION NOMENCLATURE																																																																																																																																															
T																U SN: C6225110 EIC: 4WV																																																																																																																																															
W																X 7.62MM m24 SNIPER WEAPON SYSTEM																																																																																																																																															
SELECTED BY AND DATE																TYPE OF CONTAINER(S)				TOTAL WEIGHT				RECEIVED BY AND DATE																INSPECTED BY AND DATE																																																																																																																							
1																2				3				7																8																																																																																																																							
PACKED BY AND DATE																NO. OF CONTAINER(S)				TOTAL CUBE				WAREHOUSED BY AND DATE																WAREHOUSE LOCATION																																																																																																																							
4																5				6				9																10																																																																																																																							
REMARKS																																																																																																																																																															
MILSTRIP EXCESS REPORTS: (THIS WEAPON IS NOT EXCESS)																																																																																																																																																															
THIS WEAPON IS FOR REPAIR AND RETURN TO UNIT POC: 1LT ROGERS																																																																																																																																																															
AA FIRST DESTINATION ADDRESS																CC DATE SHIPPED																																																																																																																																															
11																12																																																																																																																																															
13 TRANSPORTATION CHARGEABLE TO																14 BILLING, AWD, OR RECEIVER'S SIGNATURE (AND DATE)																																																																																																																																															

DD Form 1348-1, SEP 87

Jun 86 edition may be used.

FORM APPROVED. OMB NO. 0704-0188

DOD SINGLE LINE ITEM RELEASE/RECEIPT DOCUMENT

DOD SINGLE LINE ITEM RELEASE/RECEIPT DOCUMENT

DEPARTMENT OF THE ARMY
B Company, 5th Battalion, 20th Infantry (M)
Unit 15096
APO AP 96224

EAIDID - BC

05 AUG 93

MEMORANDUM FOR RECORD

SUB: Packing List for M24 SWS, Serial # C6225110.

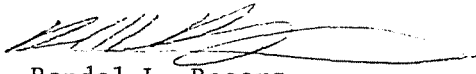
01. This memorandum is submitted in lieu of DD Form 1750, Packing List.

02. The following items are being shipped with the M24 SWS:

- 01. Rifle, M24, ser.# C6225110
- 02. Scope, ser.# 881288
- 03. Rifle Case, soft
- 04. Forms: DD 1750 (substitute memorandum), DA 2404, DA 2407,
Shipping Authorization from AMCCOM, AOE (DD 1348m and DD 1348-1)
FTE (DD 1348m and DD 1348-1), and a cover memorandum.

03. POC is: COMMANDER
B 5-20 IN (M)
APO AP 96224

tel: 001-82-351-869-2472



Randel L. Rogers
1LT IN
Executive Officer

DEPARTMENT OF THE ARMY
B Company, 5th Battalion, 20th Infantry (M)
Unit 15096
APO AP 96224

EAIDID - BC

04 AUG 93

MEMORANDUM FOR RECORD

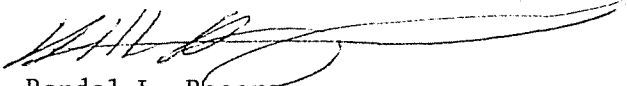
SUB: Turn-in for Repair of M24 SWS, ser.# C6225110

01. The enclosed M24 SWS is being shipped to the Remington Arms factory for repair in accordance with the operator's manual (TM 9-1005-306-10, C3) and a directive from AMCCOM (doc. # WT4WTU31880101).

02. The enclosed rifle is not excess, it is shipped for repair and return to this unit.

03. POC is CPT William S. McCallister
Commander
B 5-20 IN (M)
APO AP 96224

tel: 001-82-351-869-2472, commercial.



Randel L. Rogers
1LT IN
Executive Officer

MAINTENANCE REQUEST				PAGE NO. 1	NO. OF PAGES 1	REQUIREMENTS CONTROL SYMBOL CSGLD - 1047(R1)			
For use of this form, see DA PAM 738-750; the proponent agency is DCSLOG									
SECTION I - EQUIPMENT DATA									
CONTROL NUMBER		WORK ORDER NO.		WESDC		ORG. PD 02		PD AUTHENTICATION 	
☐ Work Request ☐ MWO ☒ Warranty Claim		1A. ORGANIZATION B CO 5-20 IN (M) APO AP 96224		B. LOCATION APO AP 96224			C. UNIT IDENT CODE WA4FBO		
2. SERIAL NO. C6225110		3. NOUN NOMENCLATURE Sniper Weapon System		4. LINE NO. R95387		5. MODEL M24		6. NATIONAL STOCK NUMBER 1005-01-240-2136	
7A. MAINTENANCE ACTIVITY 702d MSB		B. LEVEL		8. UTILIZATION CODE		9A. MCSR ITEM		9B. ERC	
14. FAILURE DETECTED DURING (Select one - use ☒ or X)					15. FIRST INDICATION OF TROUBLE (Select one - use ☒ or X)				
☐ A Sch. Main. ☐ C Test ☐ E Storage ☐ G Flight ☐ B Handling ☒ D Normal Op ☐ F Inspection ☐ H Other					☒ 068 Inoperative ☐ 258 Overheating ☐ 790 Out of Adjustment ☐ 008 Noisy ☐ 387 Low Performance ☐ Other				
16A. DESCRIBE DEFICIENCIES OR SYMPTOMS ON THE BASIS OF COMPLETE CHECKOUT AND DIAGNOSTIC PROCEDURE IN EQUIPMENT TM (Do not prescribe repairs).									
01. Cracked scope, moisture inside I have reviewed the circumstances surrounding the									
02. Missing minor components damage to the above item & find no evidence of									
03. Finish worn off metal parts negligence or misconduct.									
B. REMARKS									
04. Trigger Broken William S. McCallister									
POC is 1LT Rogers, CPT IN									
011-82-351-869-2470 Commanding									
SECTION II - WORK ACCOMPLISHED									
17A. REPAIR ORGANIZATION/ACTIVITY				C. UNIT IDENT. CODE		18. TYPE ORGANIZATION/ACTIVITY ACCOMPLISHING WORK (Select one - use ☒ or X)		19. AMS ACCT. CODE	
B. LOCATION						☐ 1 TOE ☐ 2 TD ☐ 3 Contractor			
20A. ACT. CODE	B. FAILURE CODE	C. COMPONENT/PART NOUN, SVC, OR MWO NO.			D. MANHOURS (Hrs. & tenths)	E. NATIONAL STOCK NUMBER	F. PART SOURCE CODE	G. QTY.	H. PARTS COST
		(1) CB CODE	(2) REF DESIGN.	(3) MFR. CODE					
					.				\$
					.				\$
					.				\$
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					.				\$
					.				\$
					.				\$
					.				\$
					.				\$
					.				\$
					.				\$
					.				\$
					I. TOTAL MANHOURS	J. TOTAL MANHOURS COST \$	K. TOTAL PARTS COST \$		
21. DELAY (Select One)									
☐ 1 Parts ☐ 2 Manpower ☐ 3 Facilities ☐ 4 Funds ☐ 5 Tools									
22. ☐ Data Transcribed									
23. SUBMITTED BY		24. RECEIVED BY		25. WORK STARTED BY		26. INSPECTED BY		27. ACCEPTED BY	
JULIAN DATE		JULIAN DATE		JULIAN DATE		JULIAN DATE		JULIAN DATE	
28. DISPOSITION (Select One)									
☐ A To User ☐ D Evacuated ☐ B To Stock ☐ E Cannibalization ☐ C Salvaged									

DEPARTMENT OF THE ARMY
B Company, 5th Battalion, 20th Infantry (M)
Unit 15096
APO AP 96224

EAIDID - BC

05 AUG 93

MEMORANDUM FOR RECORD

SUB: Packing List for M24 SWS, Serial # C6225110.

01. This memorandum is submitted in lieu of DD Form 1750, Packing List.

02. The following items are being shipped with the M24 SWS:

- 01. Rifle, M24, ser.# C6225110
- 02. Scope, ser.# 881288
- 03. Rifle Case, soft
- 04. Forms: DD 1750 (substitute memorandum), DA 2404, DA 2407,
Shipping Authorization from AMCCOM, AOE (DD 1348m and DD 1348-1)
FTE (DD 1348m and DD 1348-1), and a cover memorandum.

03. POC is: COMMANDER
B 5-20 IN (M)
APO AP 96224

tel: 001-82-351-869-2472


Randel L. Rogers
1LT IN
Executive Officer

DEPARTMENT OF THE ARMY
B Company, 5th Battalion, 20th Infantry (M)
Unit 15096
APO AP 96224

EAIDID - BC

04 AUG 93

MEMORANDUM FOR RECORD

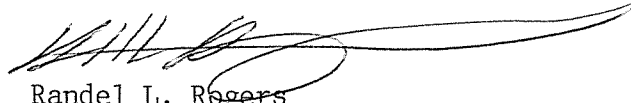
SUB: Turn-in for Repair of M24 SWS, ser.# C6225110

01. The enclosed M24 SWS is being shipped to the Remington Arms factory for repair in accordance with the operator's manual (TM 9-1005-306-10, C3) and a directive from AMCCOM (doc. # WT4WTU31880101).

02. The enclosed rifle is not excess, it is shipped for repair and return to this unit.

03. POC is CPT William S. McCallister
Commander
B 5-20 IN (M)
APO AP 96224

tel: 001-82-351-869-2472, commercial.



Randel L. Rogers
1LT IN
Executive Officer

CMD: M
PR B CO 5TH BN 20TH INF
APO AP 96224-0357

PMN

12 OF A01CM1J024R
93195

SUBJECT: EXCEPTION DATA
DOCUMENT NUMBER WT4WTU31880101

1. FOR MATERIEL RETURN TX: FTR/B14/2/1005012402136 /EA/00001/
WT4WTU31880101/ /WA4FB0/D/GA/ / /13/195/TD/B14/ /F/D/N/0514500
IS BEING RETURNED WITH THE FOLLOWING EXCEPTION DATA:
SHIP TO REMINGTON ARMS CO INC
14 HOEFER AVE
ILION NY 13357

2. POINT OF CONTACT FOR THIS ACTION IS TARA MCANDREWS_____
AUTOVON 7936216_____

(NAME AND TITLE)

CF: NJ6TM

CMD: M
PR B CO 5TH BN 20TH INF
APO AP 96224-0357

PMN

12 OF A01CMLJ024R
93195

SUBJECT: EXCEPTION DATA
DOCUMENT NUMBER WT4WTU31880101

1. FOR MATERIEL RETURN TX: FTR/B14/2/1005012402136 /EA/00001/
WT4WTU31880101/ /WA4FB0/D/GA/ / /13/195/TD/B14/ /F/D/N/0514500
IS BEING RETURNED WITH THE FOLLOWING EXCEPTION DATA:
SHIP TO REMINGTON ARMS CO INC
14 HOEFER AVE
ILION NY 13357

2. POINT OF CONTACT FOR THIS ACTION IS TARA MCANDREWS _____
AUTOVON 7936216 _____

(NAME AND TITLE)

CF: NJ6TM

DA FORM 2404
1 APR 79

Replaces edition of 1 Jan 64, which will be used

[illegible]

NOTICE OF REJECTION

PURCHASED COMPONENTS

TO: PURCHASING DEPARTMENT, 52-2H

DATE REC'D 93 Aug 26

NAME OF VENDOR: Leupold & Stevens

Ser No
PART NO. 88-1288 DRAWING NO. _____

NAME OF PART: 10X ULTRA Scope

PURCHASE ORDER NO. _____ QUANTITY REC'D 1 R/S NO. _____

REASON FOR REJECTION: Moisture In Housing/Scope Tube

Please Retn. To Vendor VIA O'NIGHT

AFTER REPAIR HAVE RETURNED TO REM

SAME

Fred E. Martin

PURCHASED PARTS ENGINEER

INSPECTION DEPARTMENT

THIS FORM NOT VALID UNLESS CO-SIGNED BY ENGINEER.

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#
3.00# + .75#
4.00# + 1.00#

SERIAL NO. 06225110

DATE 9/11/93

TESTER RW

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.38	2.40	2.71	2.44	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.41	2.42	2.76	2.46	
PULL #3	2.39	2.41	2.75	2.49	
PULL #4	2.40	2.45	2.75	2.48	
PULL #5	2.43	2.48	2.71	2.46	
TOTAL	12.01	12.16	13.68	12.31	
AVG.	2.40	2.43	2.74	2.46	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.12	3.17		
PULL #2	3.10	3.20		
PULL #3	3.05	3.15		
PULL #4	3.08	3.13		
PULL #5	3.00	3.26		
TOTAL	15.35	15.91		
AVG.	3.07	3.18		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.20	4.08		4.45
PULL #2	4.16	4.19		4.41
PULL #3	4.09	4.08		4.48
PULL #4	4.11	4.11		4.46
PULL #5	4.23	4.09		4.45
TOTAL	20.79	20.55		22.25
AVG.	4.18	4.11		4.45

Final Inspection

In: C6225/10

DATE REC'D: 8/25/93

DATE RET'D:

EDITOR:

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☒ SETComments: Scope Returned
to Vendor for Repair.

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6225110
13 Sep 1993

CENTROIDAL DISTANCES

0 TO	1	.183003
1 TO	2	.306624
1 TO	3	.138221
1 TO	4	.54595
1 TO	5	.331857

4
2.5 <----POA

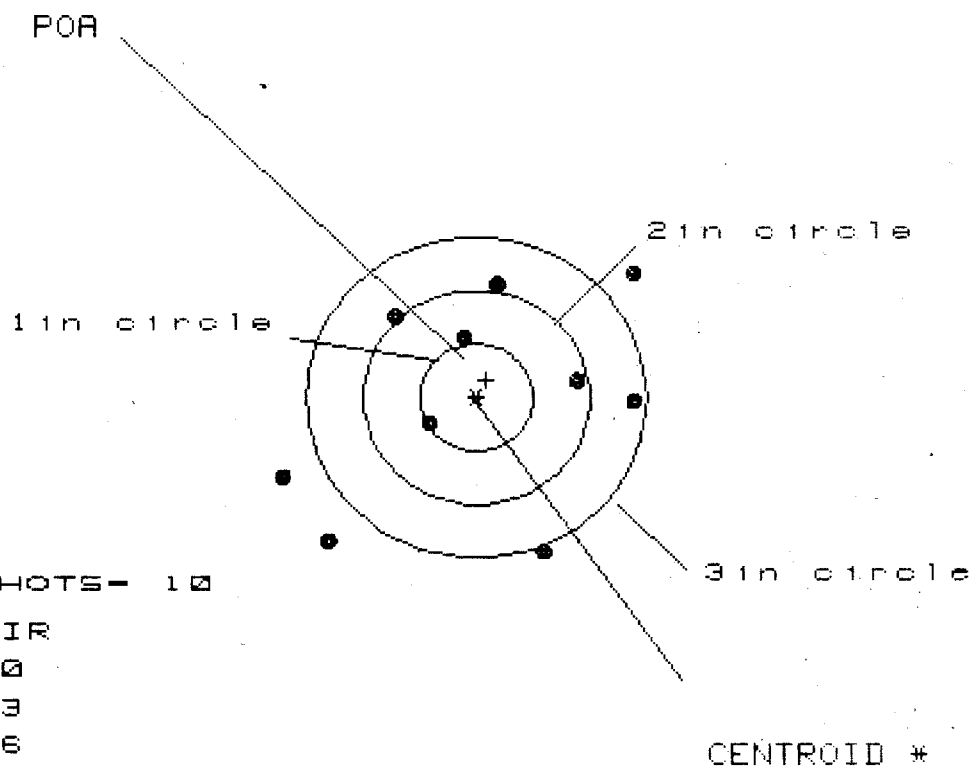
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1126
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .064
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .129517

THE AMR FOR THIS RIFLE IS: 1.034

13 Sep 1993

FILE:/PATTERNING/CENTERFIRE_PATT/C6225110

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 0

2 in = 3

3 in = 6

HS= 3.069

VS= 2.614

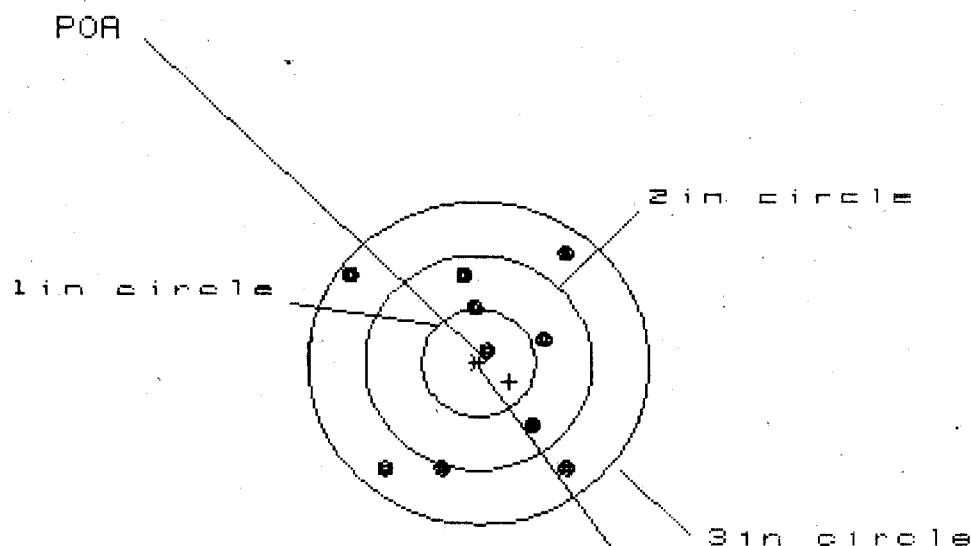
GS= 3.721

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.386	1.237	1.357
MINIMUM X	-1.683	-1.832	-1.677
MAXIMUM Y	1.200	1.052	1.061
MINIMUM Y	-1.414	-1.562	-1.430
CENTROID X	-.087	.062	-.093
CENTROID Y	-.161	-.013	-.145
POA TO CENTROID in.	.183	.063	.172
MIN RADIUS	.521	.519	.524
MEAN RADIUS	1.257	1.162	1.104
MAX RADIUS	1.889	2.022	1.827
HORIZONTAL SPREAD	3.069	3.069	3.034
VERTICAL SPREAD	2.614	2.614	2.491
EXTREME SPREAD	3.721	3.613	3.112
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	3		
NUMBER IN THREE INCH CIRCLE =	6		

13 Sep 1993

FILE:/PATTERNING/CENTERFIRE_PATT/C6225110

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in - 2

2 in - 5

3 in - 10

HS- 1.936

VS= 2.048

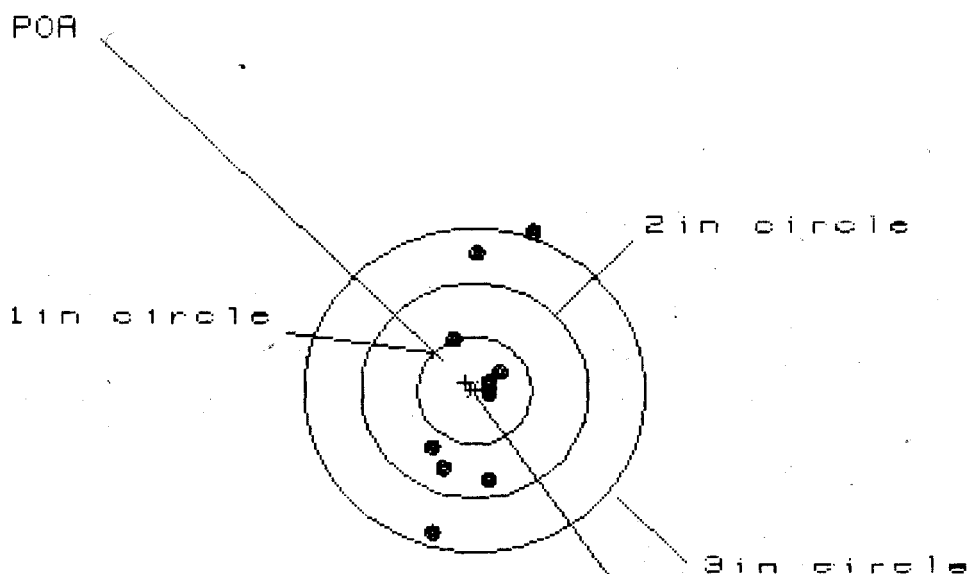
GS= 2.662

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.775	.646	.523
MINIMUM X	:	-1.161	-.977	-.577
MAXIMUM Y	:	1.046	1.141	1.028
MINIMUM Y	:	-1.002	-.907	-1.020
CENTROID X	:	-.274	-.145	-.022
CENTROID Y	:	.177	.082	.195
POA TO CENTROID in.	:	.326	.166	.197
MIN RADIUS	:	.169	.281	.269
MEAN RADIUS	:	.914	.853	.768
MAX RADIUS	:	1.439	1.332	1.169
HORIZONTAL SPREAD	:	1.936	1.623	1.100
VERTICAL SPREAD	:	2.048	2.048	2.048
EXTREME SPREAD	:	2.662	2.611	2.322
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		10	

13 Sep 1993

FILE: PATTERNING/CENTERFIRE_PATT/C6225110

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 4

2in = 7

3in = 9

HS= .859

VS= 2.809

GS= 2.937

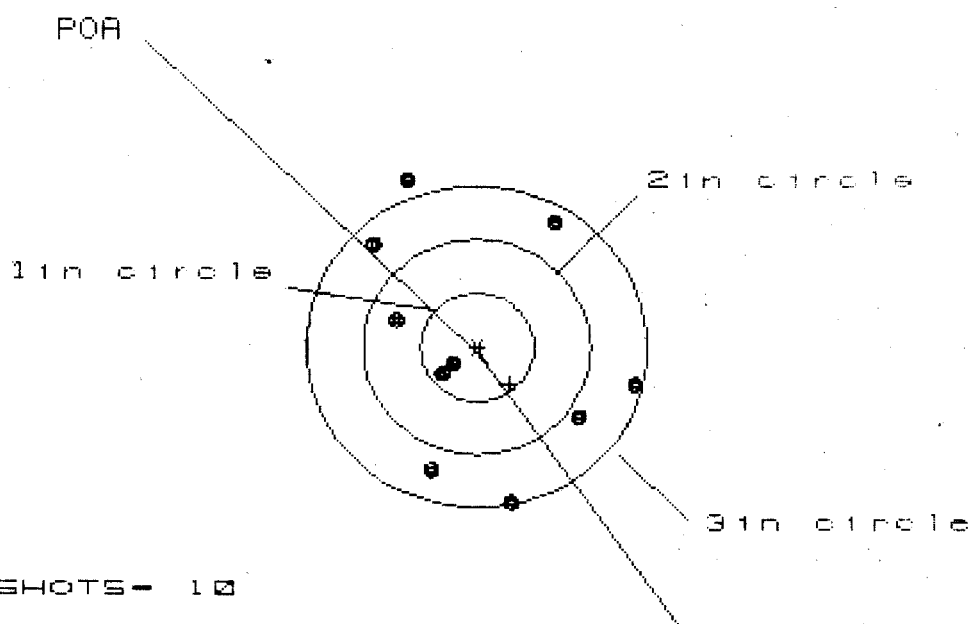
CENTROID #

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.472	.290	.248
MINIMUM X	:	-.387	-.334	-.350
MAXIMUM Y	:	1.450	1.425	1.275
MINIMUM Y	:	-1.359	-1.198	-.848
CENTROID X	:	.078	.025	.067
CENTROID Y	:	-.080	-.241	-.091
POA TO CENTROID in.	:	.111	.242	.113
MIN RADIUS	:	.148	.273	.161
MEAN RADIUS	:	.757	.679	.581
MAX RADIUS	:	1.525	1.427	1.276
HORIZONTAL SPREAD	:	.859	.624	.598
VERTICAL SPREAD	:	2.809	2.623	2.123
EXTREME SPREAD	:	2.937	2.655	2.126
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

13 Sep 1993

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 2

2in = 3

3in = 5

HS= 2.338

VS= 2.995

GS= 3.133

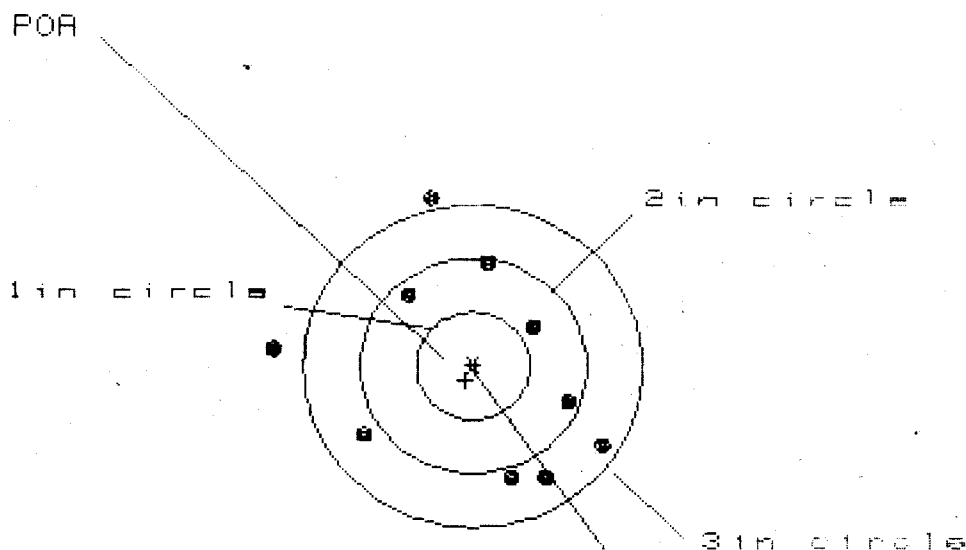
CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.407	1.336	1.363
MINIMUM X	:	-.931	-1.002	-.975
MAXIMUM Y	:	1.579	1.324	1.169
MINIMUM Y	:	-1.416	-1.241	-1.103
CENTROID X	:	-.292	-.221	-.248
CENTROID Y	:	.345	.170	.325
POA TO CENTROID in.	:	.452	.279	.408
MIN RADIUS	:	.244	.254	.267
MEAN RADIUS	:	1.092	1.007	.976
MAX RADIUS	:	1.702	1.487	1.394
HORIZONTAL SPREAD	:	2.338	2.338	2.338
VERTICAL SPREAD	:	2.995	2.565	2.272
EXTREME SPREAD	:	3.133	2.645	2.645
NUMBER IN ONE INCH CIRCLE =	:		2	
NUMBER IN TWO INCH CIRCLE =	:		3	
NUMBER IN THREE INCH CIRCLE =	:		9	

13 Sep 1993

FILE:/PATTERNING/CENTERFIRE_PATT/C6225110

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 0

2in = 4

3in = 8

HS= 2.919

VS= 2.603

GS= 3.054

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.122	.922	.851
MINIMUM X	:	-1.797	-1.152	-1.223
MAXIMUM Y	:	1.542	1.566	1.152
MINIMUM Y	:	-1.060	-1.037	-.842
CENTROID X	:	.065	.265	.336
CENTROID Y	:	.134	.110	-.086
POA TO CENTROID in.	:	.149	.287	.347
MIN RADIUS	:	.612	.487	.616
MEAN RADIUS	:	1.148	1.044	.943
MAX RADIUS	:	1.809	1.666	1.285
HORIZONTAL SPREAD	:	2.919	2.074	2.074
VERTICAL SPREAD	:	2.603	2.603	1.993
EXTREME SPREAD	:	3.054	2.737	2.114
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	

CONTRACT # DAAA21-87-C-0086

New Barrel

GUN SERIAL # C6225110

OP. #	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and Stock		8/26/93	RW
600	Proof		8/26/93	RW
607	Check Headspace		8/26/93	RW
610	Dis-assemble Gun		8/26/93	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		9/13/93	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		9/13/93	RW
	C) Inspect Ejector Hole for Chamfer		9/13/93	RW
	D) Oil Firing Pin Ass'y		9/13/93	RW
	E) Adjust Trigger Pull to Min Setting and Stake		9/13/93	RW

Op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force							
	G) Safety Off Force							
	H) Trigger Pull Test & Retainability						9/13/93	Rw
	I) Firing Pin Indent							
	J) Assemble Stock							
	K) Assemble Swivel Studs							
	L) Attach Front and Rear Sight Assemblies							
	M) Iron Sight Alignment							
	N) Detach Front & Rear Sights & place in numbered container							
	O) Attach Scope to Rifle							
	P) Detach & Attach Scope 20 Times							
640	Gallery Target & Test						9/13/93	Rw
	A) Time							
	B) Malfunctions							
	C) Pierced Primers							
	D) Optical Clarity of Scope							
645	Inspect for Live Ammo						9/13/93	Rw
655	Final Inspection						9/13/93	Rw
	A) Headspace						9/13/93	Rw
	B) Trigger Pull	2.44	2.46	2.49	2.48	2.46	9/13/93	Rw
	C) Function						9/13/93	Rw
660	Pack							