

FORM



UPC



0 47700 25716 2

C6649214

INCLUDES 1 IN CHAMBER

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

M2400066484

Arms Services Repair & Estimate System

File Add Repair Estimate Repair Expedite Repair Inquiry Repair Tools CSR Tools Reports Table Maintenance System Maintenance Help

Repair Inquiry

Repair Number: RE00146047

Serial: C6649214 Model M24 SWS Center Fire
Caliber: 7.62 NATO

Repairman:

Status: Closed 6/3/2008 9:50:50 AM

Verify Repair

Address Information

Customer:

☒ Received From

Return To:

☐ Received From

Name: INSTALLATION SERIALIZATION OFFICER

INSTALLATION SERIALIZATION OFFICER

Address 1: BLDG 7920

BLDG 7920

Address 2:

PO Box:

PO Box:

City: FT. RILEY

FT. RILEY

State: KS

Zip Code: 66442

Country: US

State: KS

Zip Code: 66442

Country: US

FFL:

Contact / Condition

Problems

Estimate

History / Status

Shipping / Billing

Contact Information

Phone: NN

Fax:

Email:

Comments:

Received Condition

Fair

Condition

Notes:

CSR

Notes:

Accessories Received

Code	Desc	QTY
A006	Sling Strap	1
A007	With Stud	3
A008	With Swivel	2
A010	Hard Case	1
A017	Scope Base	1
A026	Scope	1
A045	Bi Pod	1
A055	Deployment Kit	1

Repair Search

Refresh

Close

nagletj

6/3/2008

12:57 PM

754%

NUM



Number: C6649214

Model: M24 SWS



RE00146047

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

R & E NUMBER <u>146 047</u>			
SERIAL NUMBER <u>C10649214</u>			
LOG-IN DATE <u>6-3-08</u>			

OPERATION #	OPERATION NAME	DATE	INITIAL
500	DIS-ASSEMBLE GUN	5-18-09	RTZ
505	RE-BARREL	5-26-09	RTZ
420	ASSEMBLE	5-26-09	RTZ
440	PROOF	5-26-09	RTZ
460	CHECK HEADSPACE	5-26-09	RTZ
470	DIS-ASSEMBLE GUN	5-26-09	RTZ
480	MAGNAFLUX	5-30-09	(N)
510	DRILL AND TAP	5-27-09	SP
500	ROLLMARK CALIBER	6-1-09	RT
520	GOFF BLAST BBL / REC	6-1-09	D4D
530 & 540	APPLY COATINGS	6-5-09	RTZ
560	FINAL ASSEMBLY	6-4-09	RTZ
640	FUNCTION TEST AND	6-4-09	RTZ
650	TARGET	6-4-09	RTZ
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	6-4-09 RT
670	FINAL INSPECTION		
	A) HEADSPACE	PASS FAIL	6-5-09 RTZ
	B) TRIGGER PULL		
		215 273 273 273 271	6-5-09 RTZ
680	F) SAFETY ON FORCE	4.0 4.0 4.0	6-5-09 RTZ
	G) SAFETY OFF FORCE	6.0 6.0 5.0	6-5-09 RTZ
	I) FIRING PIN INDENT	.021 .021 .021	6-5-09 RTZ
690	PACK		6-5-09 RTZ

F006 REV 1/2009

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6649214.___1
FILE DATE AND TIME: , 06/05/2009 07:29

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:	-0.011
The Average Point of Impact of the Five Target Set:	0.110
The Average Mean Radius of the Five Target Set:	0.607
The Distance from POA to Centroid Target #1:	0.208
The Distance from Centroid Target #2 to Centroid Target #1:	0.348
The Distance from Centroid Target #3 to Centroid Target #1:	0.185
The Distance from Centroid Target #4 to Centroid Target #1:	0.318
The Distance from Centroid Target #5 to Centroid Target #1:	0.136

SERIAL NUMBER: C6649214. __1

TARGET NUMBER: 1

FILE DATE: 06/05/2009

FILE TIME: 07:29

POINT#	X	Y
1:	0.369	1.906
2:	-0.001	1.016
3:	0.416	0.696
4:	0.602	0.302
5:	0.424	0.194
6:	0.080	-0.196
7:	0.095	-0.498
8:	0.079	-0.900
9:	-0.464	-0.540
10:	-0.578	-0.167

X CENTROID: 0.102

Y CENTROID: 0.181

POA TO CENTROID: 0.208

HORZ SPREAD: 1.180

VERT SPREAD: 2.806

GROUP SPREAD: 2.821

MIN RADIUS: 0.322

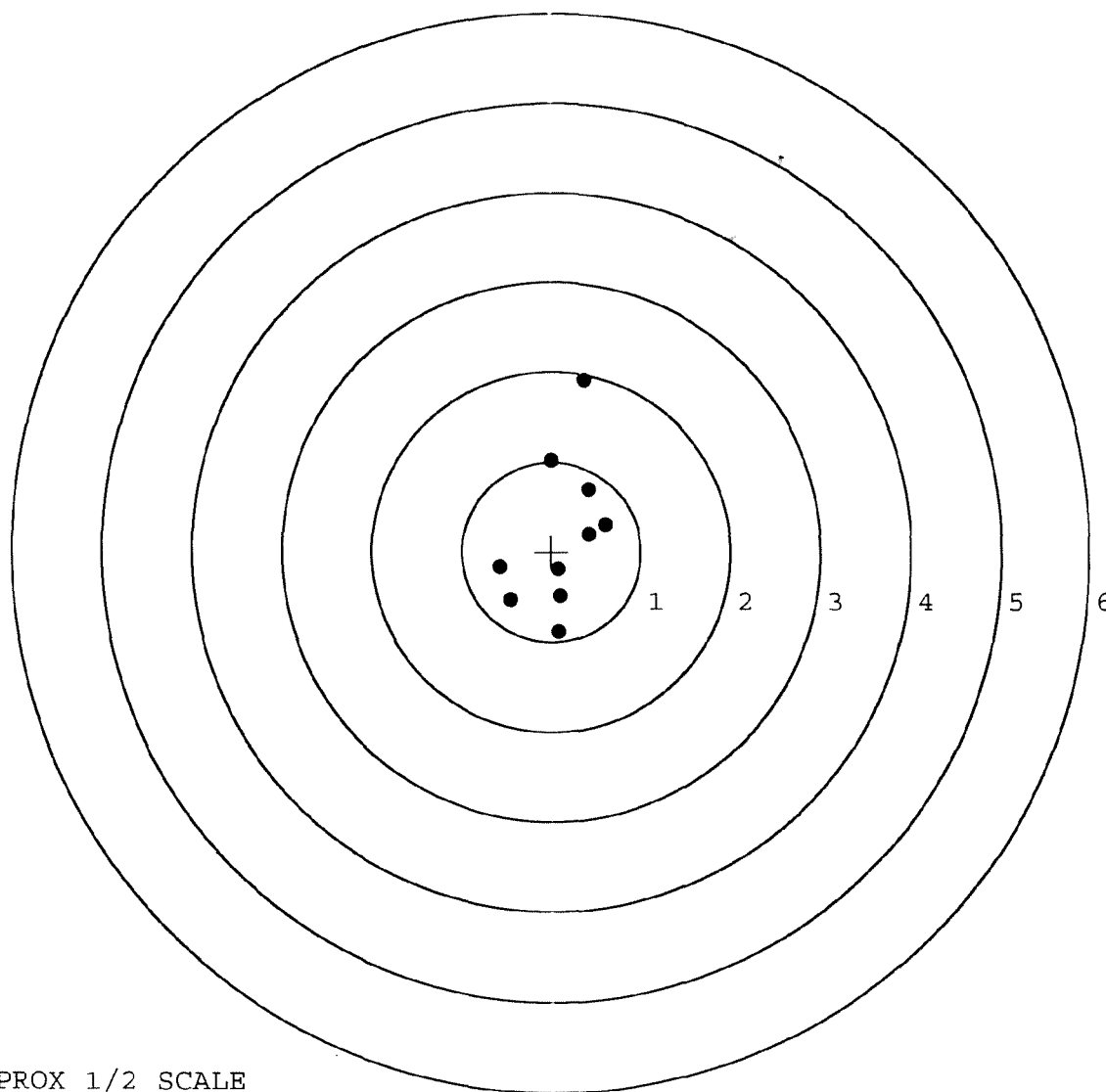
MAX RADIUS: 1.745

MEAN RADIUS: 0.785

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 9

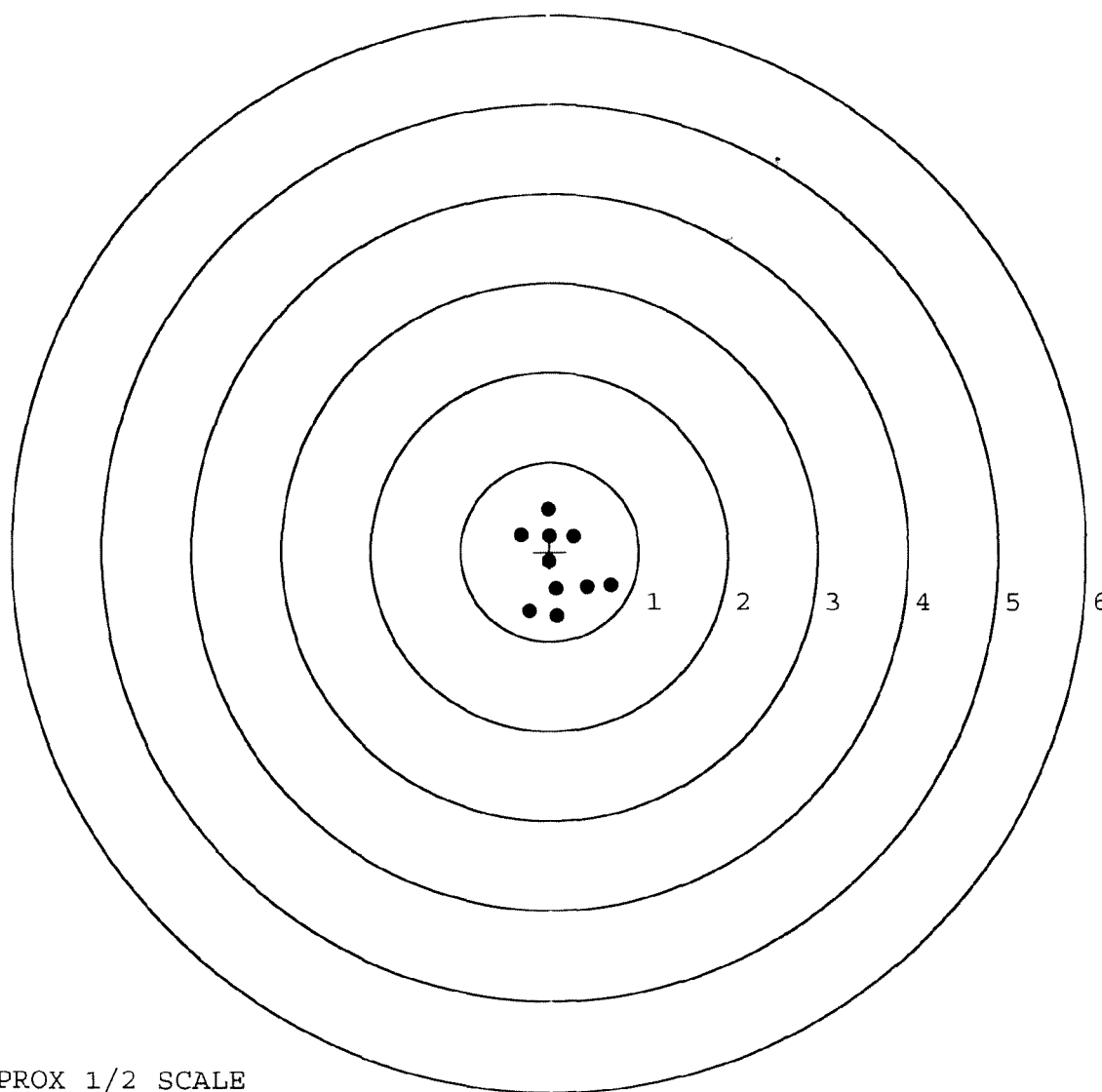


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6649214. __1
TARGET NUMBER: 2
FILE DATE: 06/05/2009
FILE TIME: 07:29

X CENTROID: 0.093
Y CENTROID: -0.166
POA TO CENTROID: 0.190
HORZ SPREAD: 1.009
VERT SPREAD: 1.201
GROUP SPREAD: 1.206
MIN RADIUS: 0.114
MAX RADIUS: 0.654
MEAN RADIUS: 0.447
IN 1 IN DIAMETER: 5
IN 2 IN DIAMETER: 10
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.235	-0.665
2:	0.683	-0.373
3:	0.416	-0.388
4:	0.072	-0.415
5:	-0.007	-0.110
6:	0.268	0.171
7:	-0.026	0.477
8:	-0.326	0.188
9:	0.002	0.175
10:	0.079	-0.724

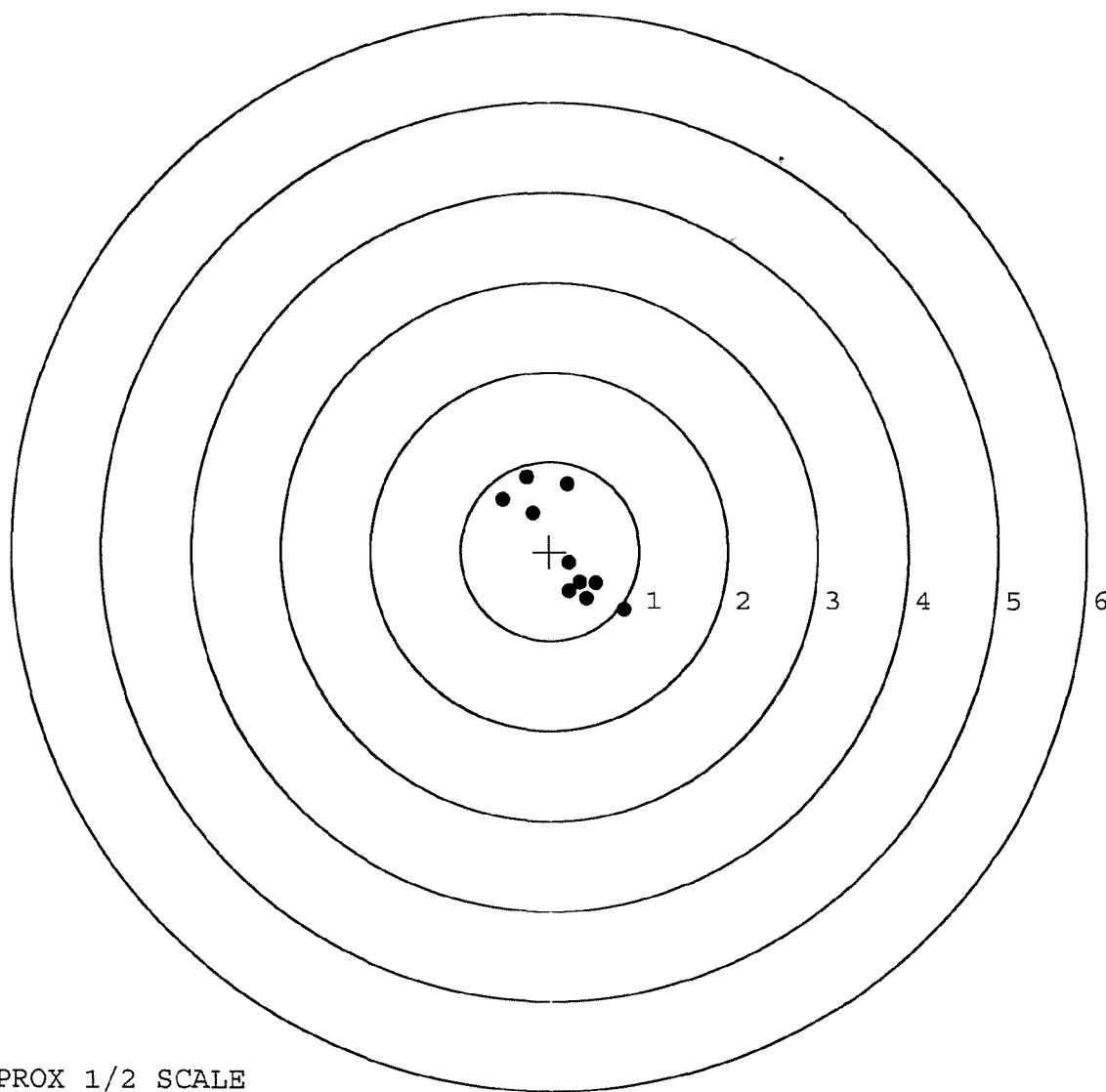


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6649214. __1
TARGET NUMBER: 3
FILE DATE: 06/05/2009
FILE TIME: 07:29

POINT#	X	Y
1:	0.194	0.751
2:	-0.262	0.823
3:	-0.529	0.574
4:	-0.199	0.433
5:	0.830	-0.655
6:	0.413	-0.533
7:	0.517	-0.360
8:	0.219	-0.447
9:	0.338	-0.353
10:	0.219	-0.128

X CENTROID: 0.174
Y CENTROID: 0.011
POA TO CENTROID: 0.174
HORZ SPREAD: 1.359
VERT SPREAD: 1.478
GROUP SPREAD: 1.838
MIN RADIUS: 0.146
MAX RADIUS: 0.934
MEAN RADIUS: 0.616
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 10
in 3 IN DIAMETER: 10

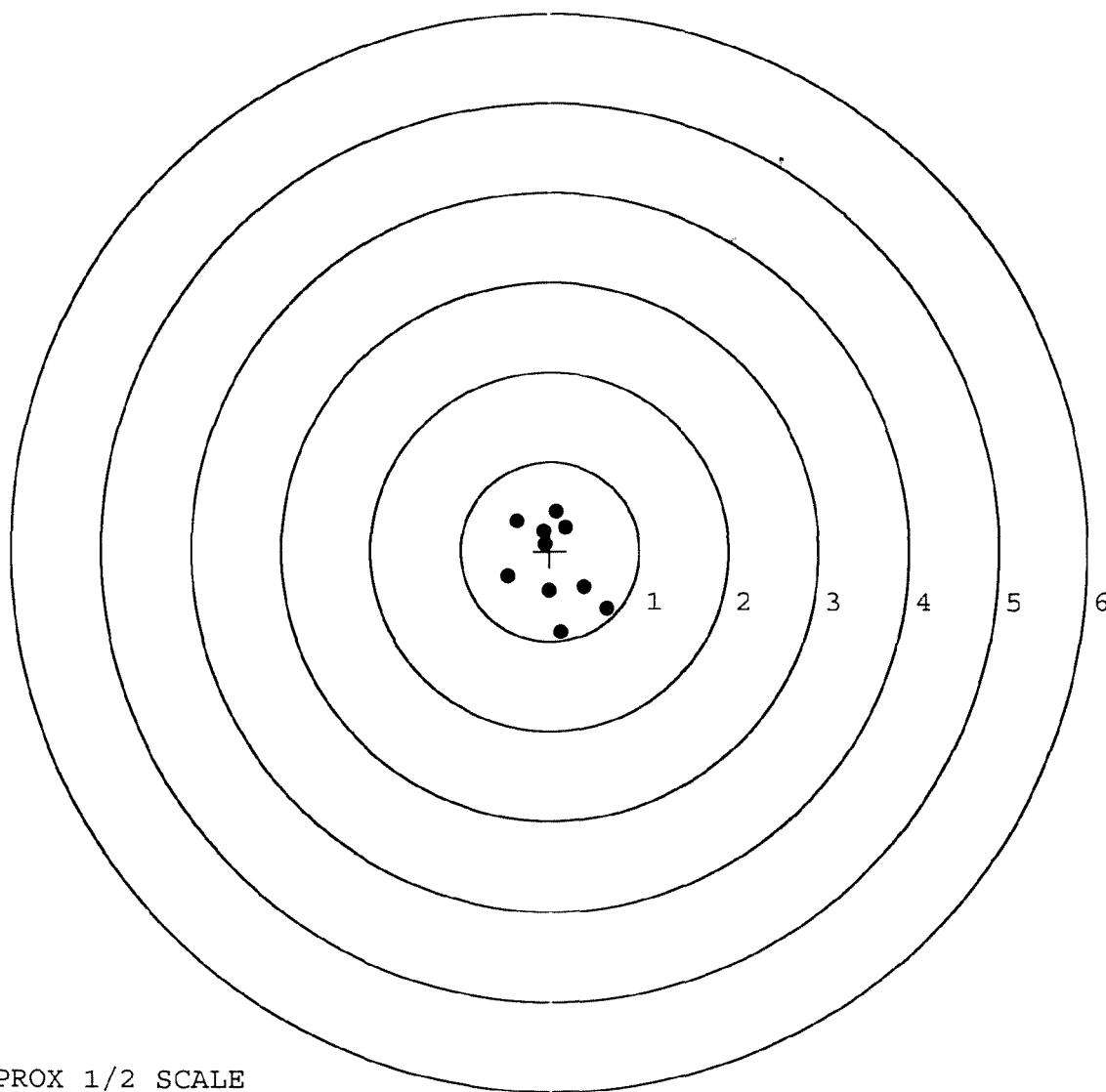


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6649214. __1
TARGET NUMBER: 4
FILE DATE: 06/05/2009
FILE TIME: 07:29

POINT#	X	Y
1:	0.115	-0.902
2:	0.635	-0.640
3:	0.384	-0.394
4:	-0.016	-0.441
5:	-0.478	-0.282
6:	-0.376	0.338
7:	-0.056	0.079
8:	0.173	0.262
9:	0.073	0.446
10:	-0.067	0.226

X CENTROID: 0.039
Y CENTROID: -0.131
POA TO CENTROID: 0.136
HORZ SPREAD: 1.113
VERT SPREAD: 1.348
GROUP SPREAD: 1.407
MIN RADIUS: 0.230
MAX RADIUS: 0.784
MEAN RADIUS: 0.507
IN 1 IN DIAMETER: 5
IN 2 IN DIAMETER: 10
in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6649214. __1

TARGET NUMBER: 5

FILE DATE: 06/05/2009

FILE TIME: 07:29

POINT#	X	Y
1:	1.140	0.294
2:	0.825	-0.178
3:	0.500	-0.497
4:	-0.525	1.026
5:	-0.918	0.289
6:	-0.451	0.040
7:	-0.100	-0.287
8:	0.186	0.264
9:	-0.010	-0.056
10:	0.743	-0.388

X CENTROID: 0.139

Y CENTROID: 0.051

POA TO CENTROID: 0.148

HORZ SPREAD: 2.058

VERT SPREAD: 1.523

GROUP SPREAD: 1.899

MIN RADIUS: 0.183

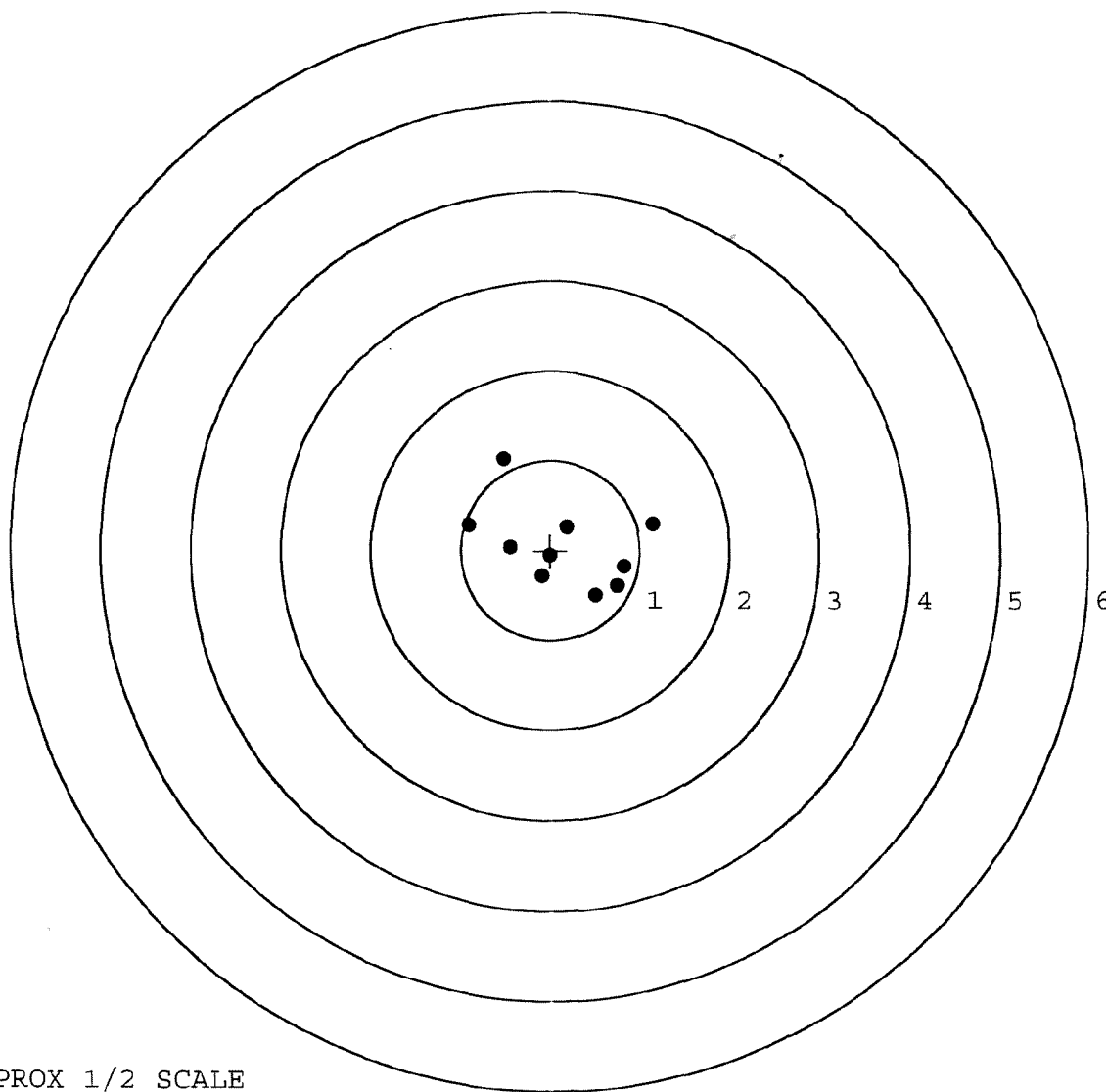
MAX RADIUS: 1.180

MEAN RADIUS: 0.682

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

Soft Case

~~Soft~~
Deployment KIT

Soft Case

Shing

Arms Services Repair & Estimate System

File Add Repair Estimate Repair Expedite Repair Inquiry Repair Tools CSR Tools Reports Table Maintenance System Maintenance Help

Repair Inquiry

Repair Number: RE00133021

Serial: C6649214 Model M24 SWS Center Fire
Caliber: 7.62 NATO

Repairman:

Verify Repair

High Priority

Status:

Closed 8/22/2007 7:13:48 AM

Address Information

Customer:

Received From

Return To:

Received From

Name: TRANSPORTATION OFFICER

TRANSPORTATION OFFICER

Address 1: XR WOK8 USA ROCK ISL ARSENAL

XR WOK8 USA ROCK ISL ARSENAL

Address 2: BLDG 299 GILLESPIE AVE BECK

PO Box:

BLDG 299 GILLESPIE AVE BECK

PO Box:

City: ROCK ISLAND

ROCK ISLAND

State: IL

Zip Code: 61299

Country: US

State: IL

Zip Code: 61299

Country: US

FFL:

Contact / Condition

Problems

Estimate

History / Status

Shipping / Billing

Contact Information

Phone: NN

Fax:

Email:

Comments:

Received Condition

Fair

Condition
Notes:CSR
Notes:

Accessories Received

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

Repair Search

Refresh

Close

nagletj

8/22/2007

7:53 AM

CAPS

NUM

INS

SCRL



Inbox - Micr...

Calendar - M...

FW: Restrict...

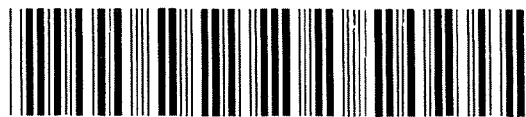
Arms Service...

7:53 AM

Serial
Number:

C6649214

Model: M24 SWS

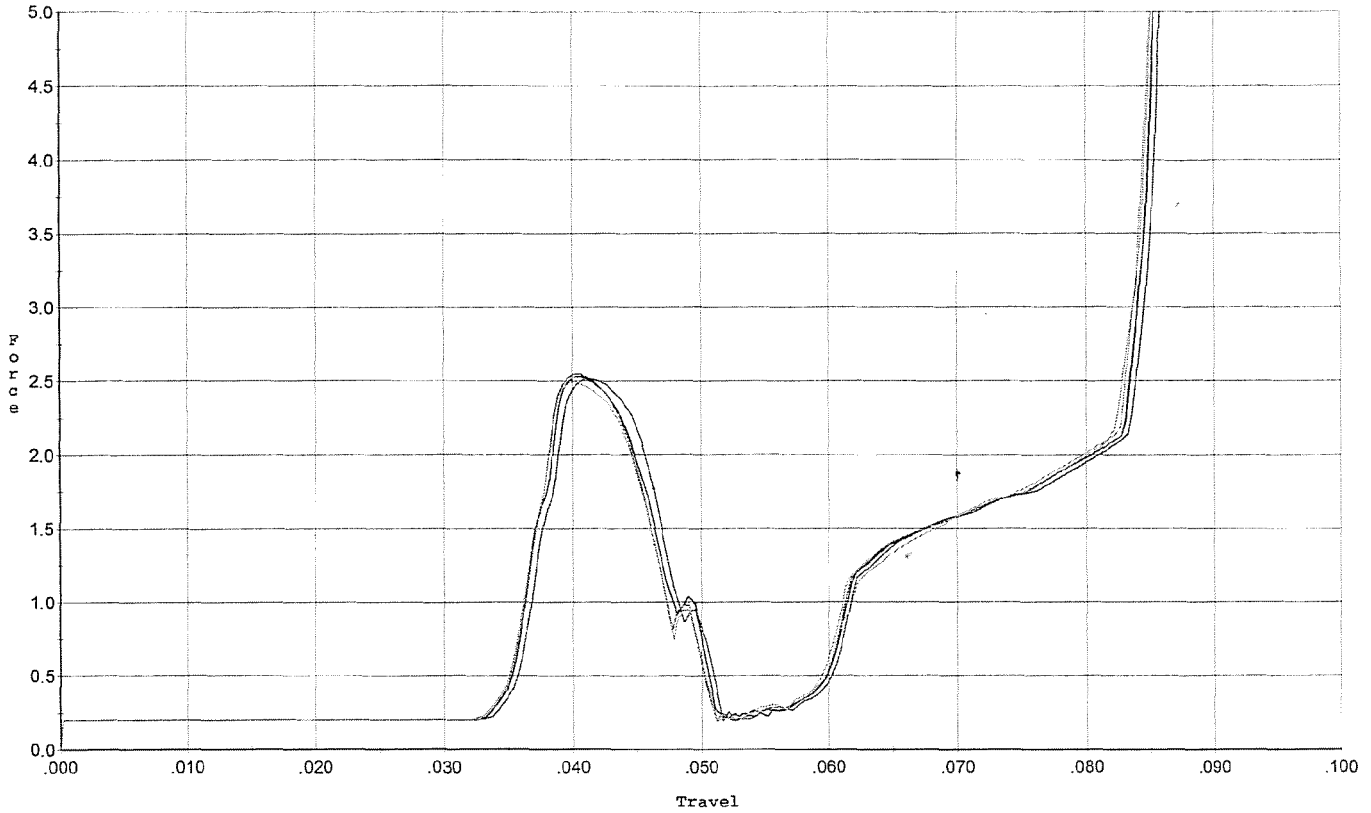


RE00133021

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: R. Putch 9/27/07

Model: M/24
Serial No: Form #F005
Trigger: 2.5 lbs. ini. +/- .50 lbs.



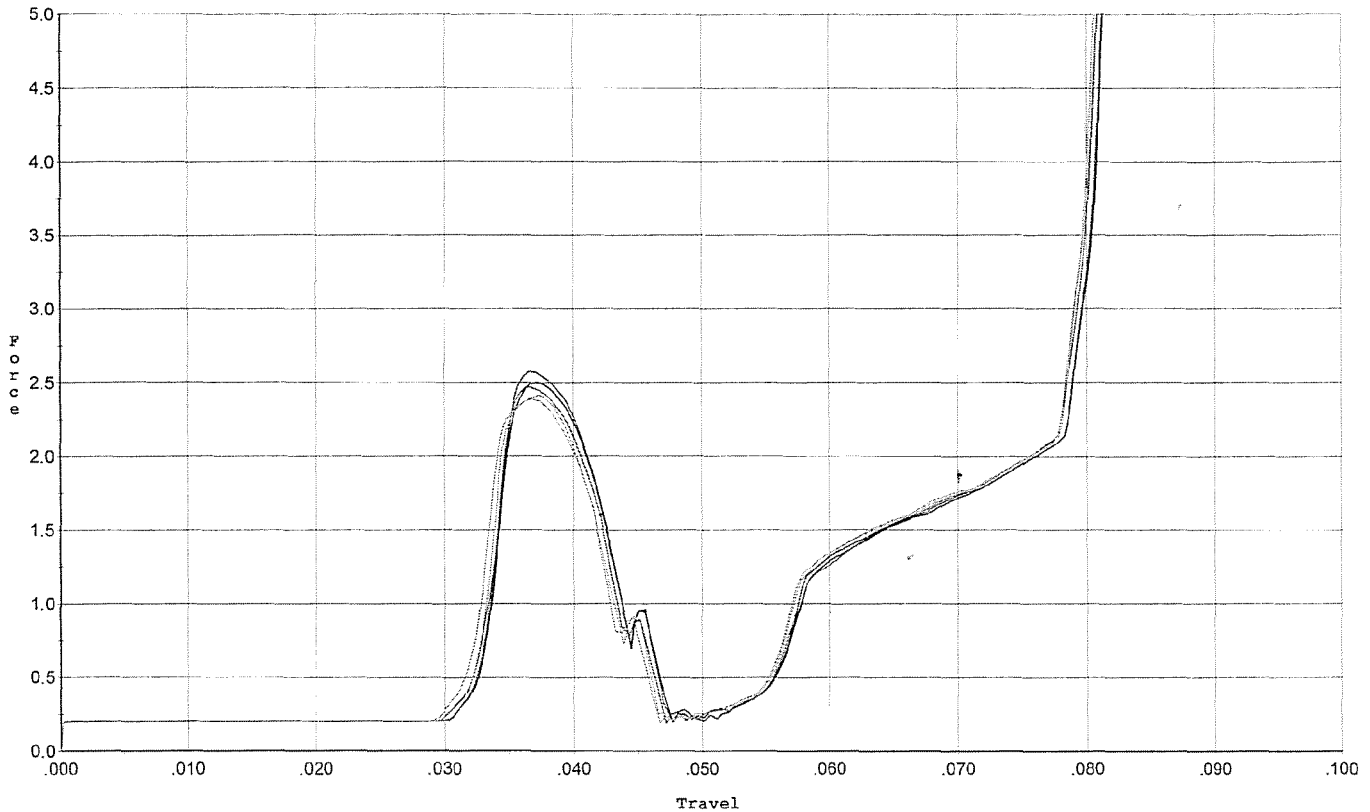
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.515	0.046	0.035	0.043	0.030		Set Trigger
2	2.530	0.049	0.035	0.040	0.033		Set Trigger
3	2.545	0.046	0.035	0.043	0.030		Set Trigger
4	2.525	0.046	0.035	0.043	0.030		Set Trigger
5	2.491	0.046	0.035	0.043	0.030		Set Trigger

Avg 2.52

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 9/27/07

Model: M/24
Serial No: Form #F005
Trigger: 2.5 lbs. after 50 cycles +/- .50 lbs.



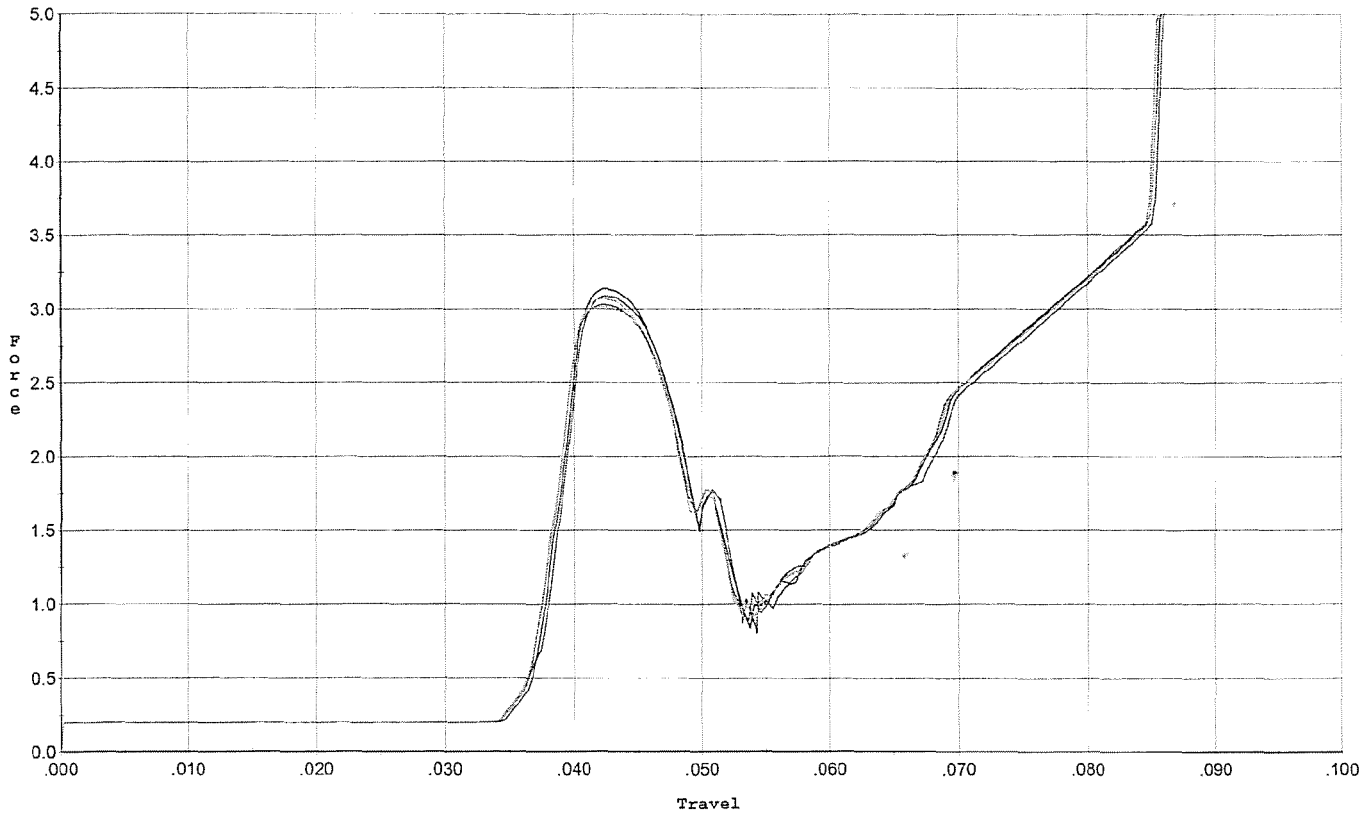
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.572	0.043	0.032	0.045	0.028		Set Trigger
2	2.504	0.043	0.032	0.045	0.028		Set Trigger
3	2.469	0.042	0.031	0.045	0.026		Set Trigger
4	2.388	0.045	0.032	0.041	0.029		Set Trigger
5	2.417	0.042	0.030	0.046	0.027		Set Trigger

Avg 2.47

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 9/27/07

Model: M/24
Serial No: Form #F005
Trigger: 3.0 lbs. ini. +/- .75 lbs.



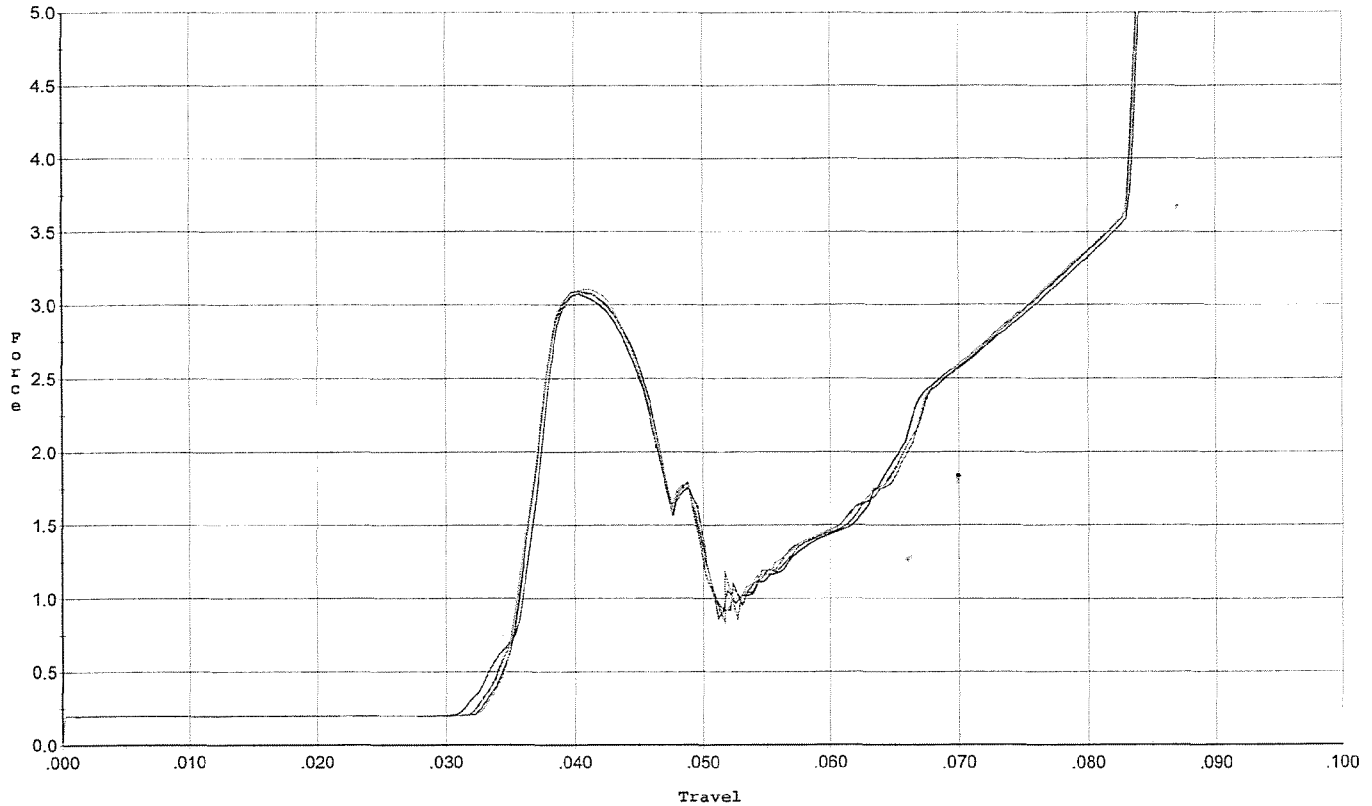
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.085	0.051	0.036	0.039	0.041		Set Trigger
2	3.133	0.048	0.036	0.040	0.037		Set Trigger
3	3.033	0.047	0.036	0.040	0.036		Set Trigger
4	3.070	0.051	0.036	0.039	0.041		Set Trigger
5	3.015	0.051	0.036	0.039	0.041		Set Trigger

Avg 3.06

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: R. Putch 9/27/07

Model: M/24
Serial No: Form #F005
Trigger: 3.0 lbs. after 20 cycles +/- .75 lbs.



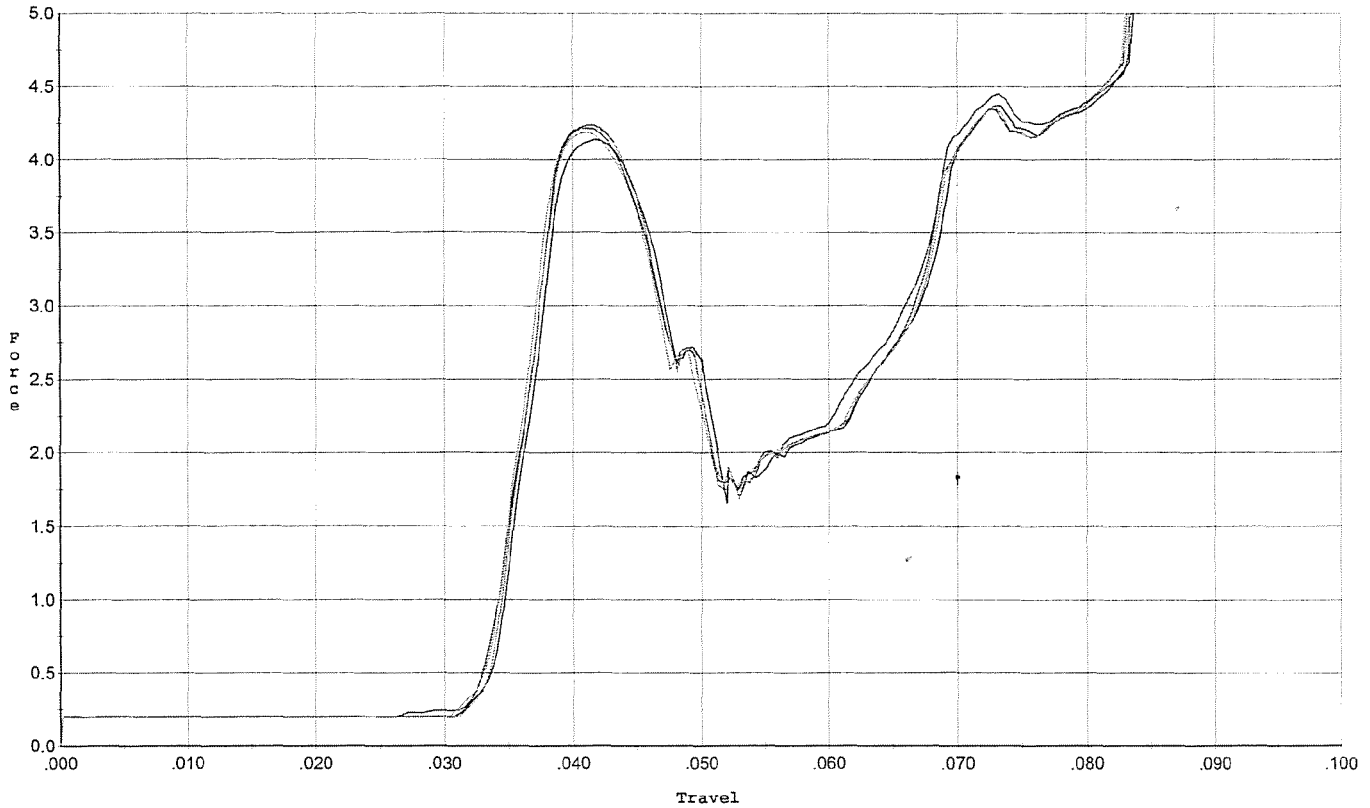
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.082	0.050	0.033	0.038	0.042		Set Trigger
2	3.073	0.046	0.033	0.039	0.037		Set Trigger
3	3.089	0.049	0.033	0.038	0.041		Set Trigger
4	3.072	0.046	0.033	0.039	0.037		Set Trigger
5	3.104	0.046	0.033	0.039	0.038		Set Trigger

Avg 3.08

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 9/27/07

Model: M/24
Serial No: Form #F005
Trigger: 4.0 lbs. ini. +/- 1.0 lbs.



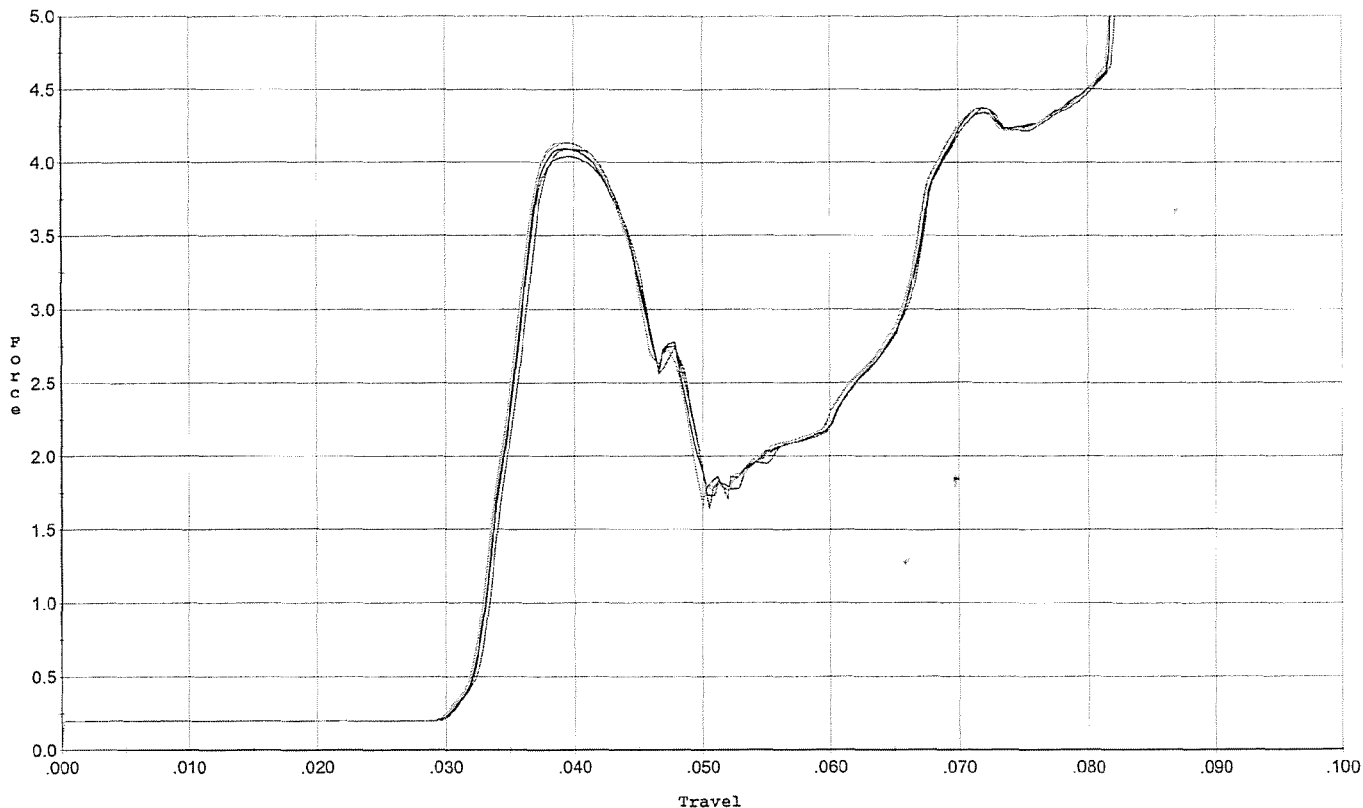
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.212	0.049	0.032	0.036	0.059		Set Trigger
2	4.134	0.050	0.033	0.036	0.059		Set Trigger
3	4.235	0.049	0.033	0.036	0.059		Set Trigger
4	4.218	0.049	0.033	0.036	0.058		Set Trigger
5	4.185	0.046	0.033	0.037	0.052		Set Trigger

Avg 4.19

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 9/27/07

Model: M/24
Serial No: Form #F005
Trigger: 4.0 lbs. after 20 cycles +/- 1.0 lbs.



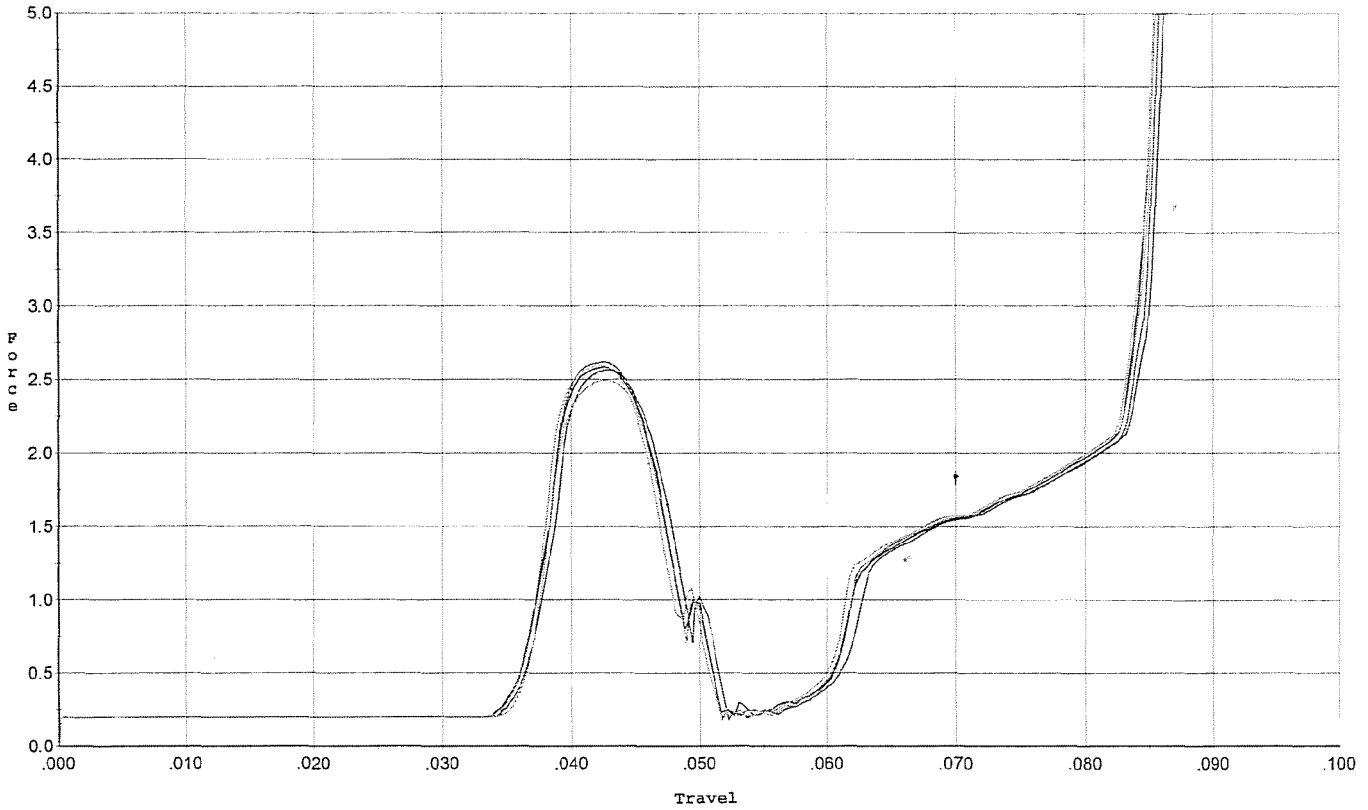
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.038	0.049	0.032	0.035	0.059		Set Trigger
2	4.090	0.048	0.031	0.035	0.057		Set Trigger
3	4.086	0.049	0.032	0.036	0.058		Set Trigger
4	4.136	0.048	0.032	0.035	0.058		Set Trigger
5	4.131	0.048	0.031	0.035	0.058		Set Trigger

Avg 4.09

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: R. Putch 9/27/07

Model: M/24
Serial No: Form #F005
Trigger: reset to 2.5 lbs. +/- .50 lbs. for final test



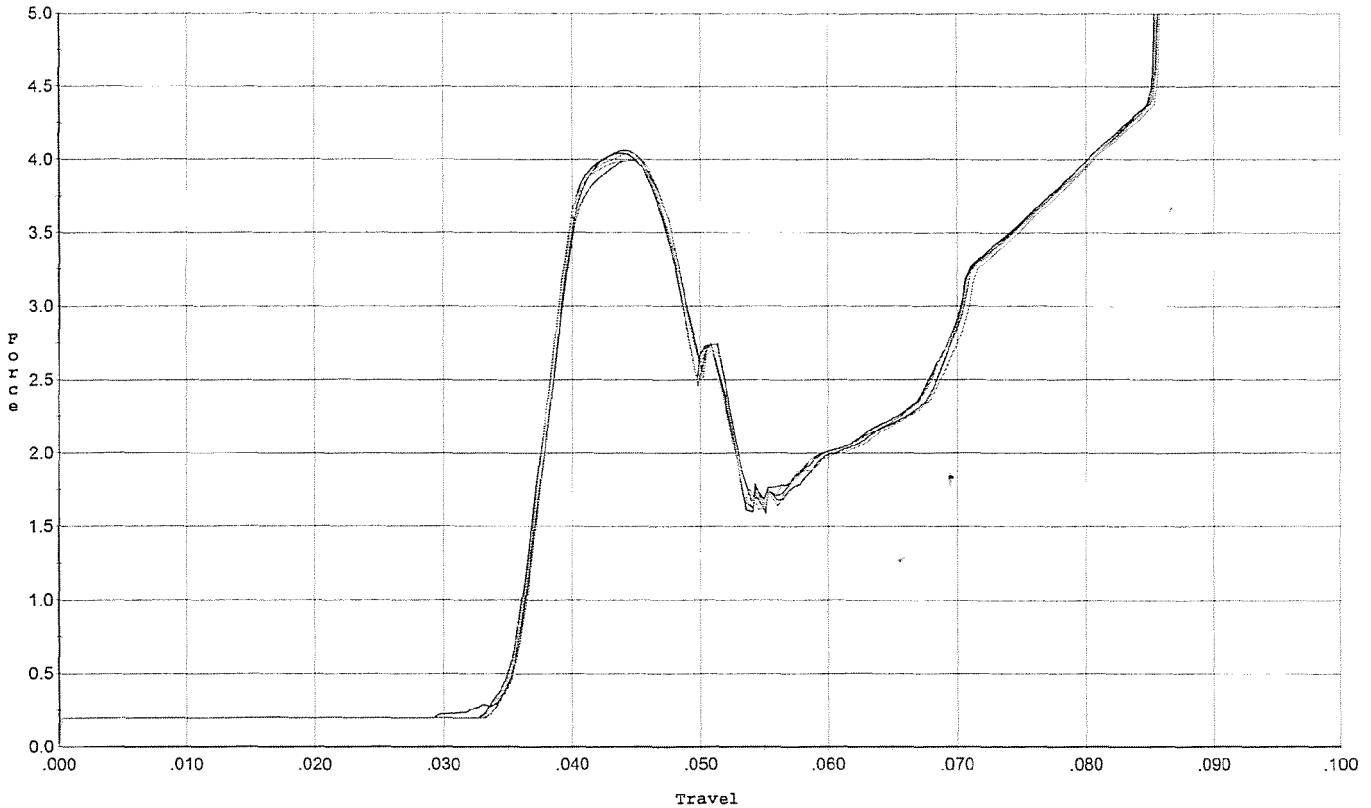
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.565	0.047	0.036	0.042	0.031		Set Trigger
2	2.585	0.047	0.035	0.042	0.031		Set Trigger
3	2.619	0.047	0.035	0.042	0.031		Set Trigger
4	2.595	0.046	0.035	0.043	0.030		Set Trigger
5	2.495	0.047	0.036	0.042	0.030		Set Trigger

Avg 2.57

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 9/27/07

Model: M/24
Serial No: Form #F005
Trigger: set to 4.0 lbs. +/- 1.0 lbs. for target & accuracy



#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.059	0.051	0.035	0.037	0.059		Set Trigger
2	4.042	0.052	0.034	0.037	0.059		Set Trigger
3	3.995	0.048	0.034	0.039	0.050		Set Trigger
4	3.991	0.048	0.035	0.038	0.051		Set Trigger
5	4.042	0.051	0.034	0.037	0.058		Set Trigger

Avg 4.02

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6649214.__0
FILE DATE AND TIME: 10/16/2007 12:42

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.042
The Average Y Centroid of the Five Target Set:	0.010
The Average Point of Impact of the Five Target Set:	0.043
The Average Mean Radius of the Five Target Set:	0.636
The Distance from POA to Centroid Target #1:	0.102
The Distance from Centroid Target #2 to Centroid Target #1:	0.242
The Distance from Centroid Target #3 to Centroid Target #1:	0.270
The Distance from Centroid Target #4 to Centroid Target #1:	0.210
The Distance from Centroid Target #5 to Centroid Target #1:	0.210

SERIAL NUMBER: C6649214. __0

TARGET NUMBER: 1

FILE DATE: 10/16/2007

FILE TIME: 12:42

X CENTROID: 0.098

Y CENTROID: -0.029

POA TO CENTROID: 0.102

HORZ SPREAD: 2.256

VERT SPREAD: 1.819

GROUP SPREAD: 2.200

MIN RADIUS: 0.344

MAX RADIUS: 1.278

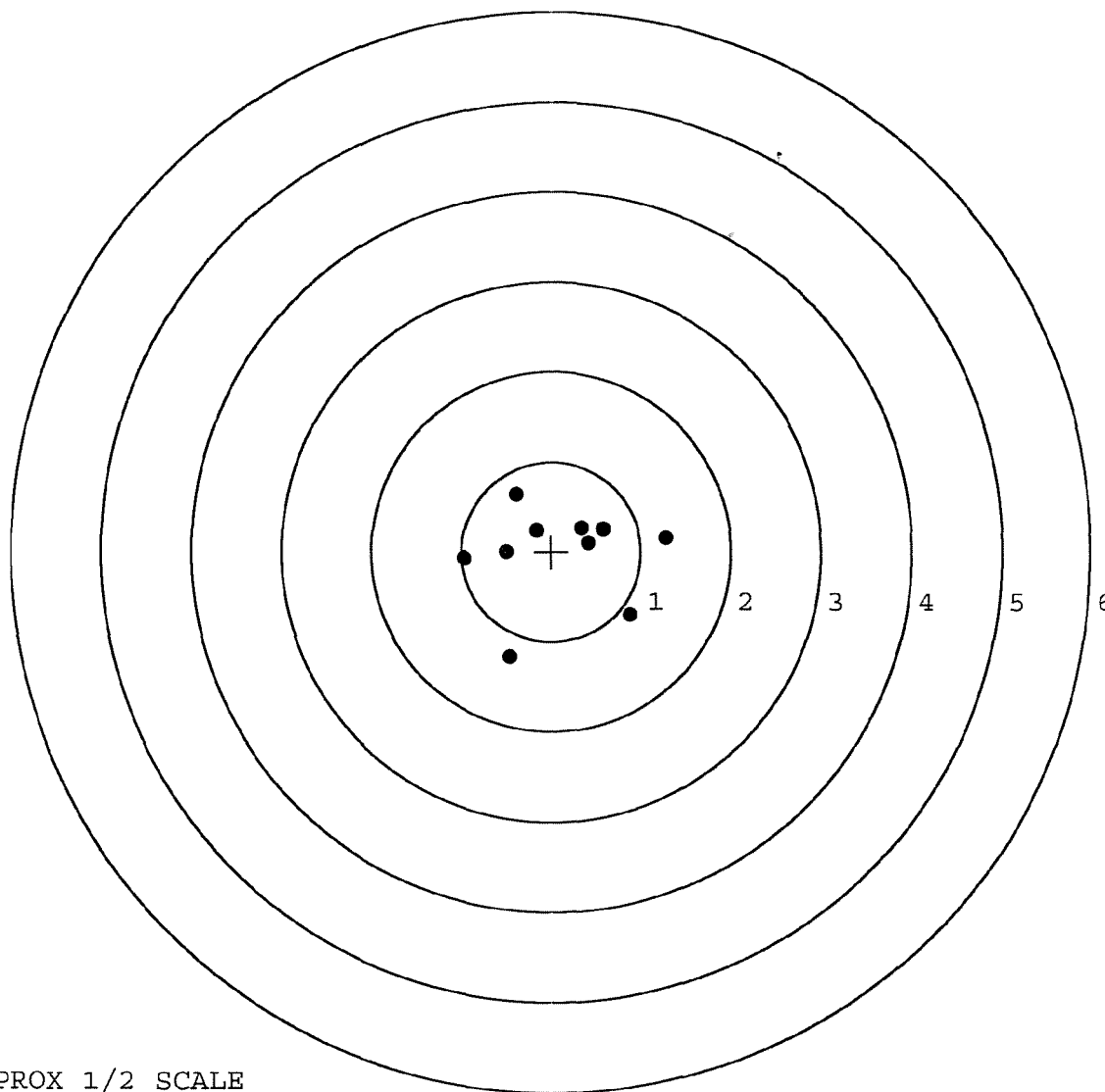
MEAN RADIUS: 0.767

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	1.285	0.155
2:	0.877	-0.701
3:	-0.466	-1.177
4:	0.574	0.255
5:	0.334	0.267
6:	-0.171	0.236
7:	-0.399	0.642
8:	-0.501	-0.004
9:	-0.971	-0.074
10:	0.414	0.106



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6649214.___0

TARGET NUMBER: 2

FILE DATE: 10/16/2007

FILE TIME: 12:42

X CENTROID: 0.031

Y CENTROID: 0.203

POA TO CENTROID: 0.206

HORZ SPREAD: 1.685

VERT SPREAD: 2.094

GROUP SPREAD: 2.361

MIN RADIUS: 0.207

MAX RADIUS: 1.656

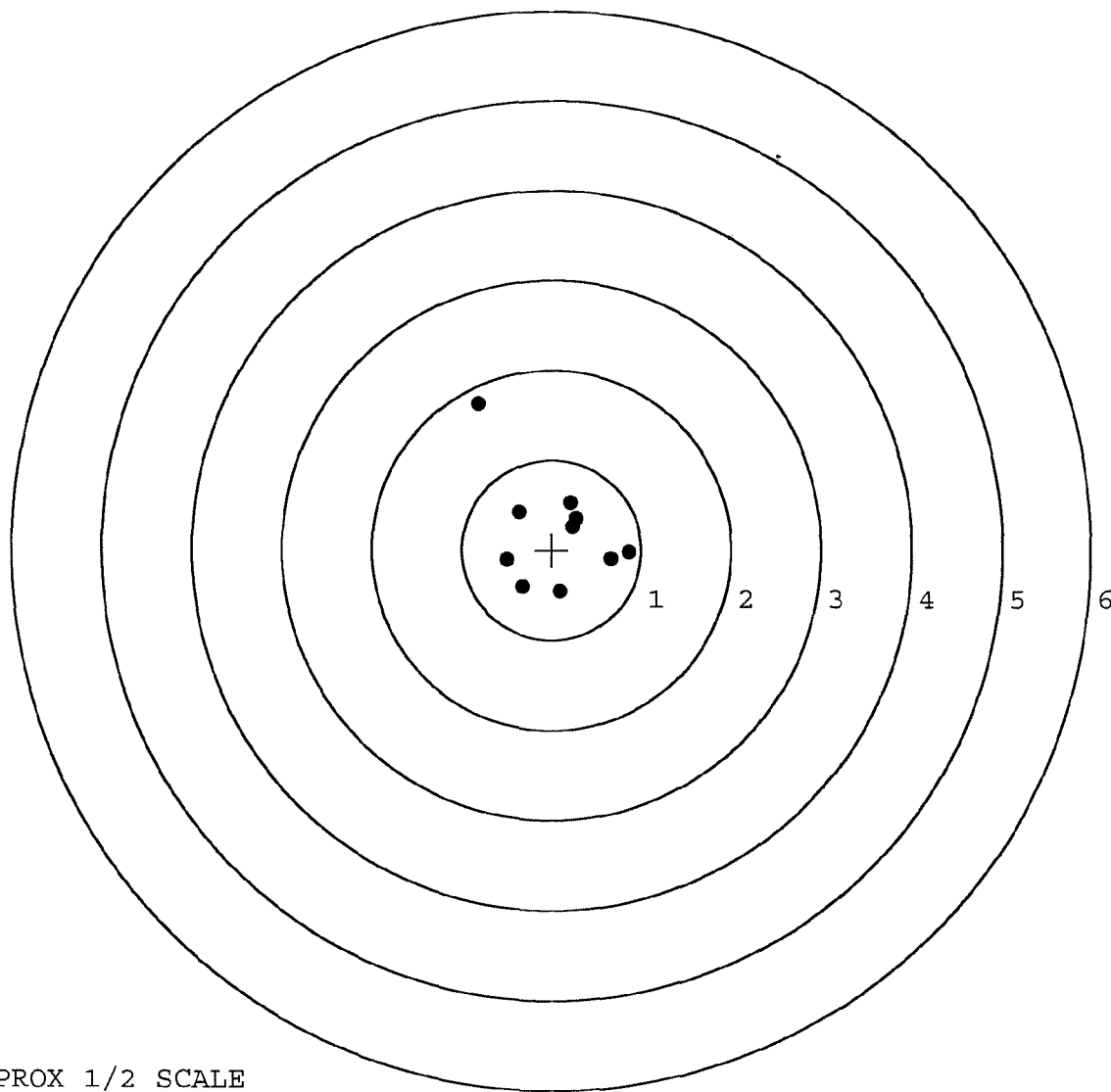
MEAN RADIUS: 0.655

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 9

POINT#	X	Y
1:	0.866	-0.030
2:	0.661	-0.106
3:	0.232	0.256
4:	0.212	0.522
5:	-0.367	0.424
6:	-0.503	-0.114
7:	-0.327	-0.418
8:	0.088	-0.470
9:	-0.819	1.624
10:	0.272	0.344



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6649214.___0

TARGET NUMBER: 3

FILE DATE: 10/16/2007

FILE TIME: 12:42

X CENTROID: -0.169

Y CENTROID: 0.012

POA TO CENTROID: 0.170

HORZ SPREAD: 1.987

VERT SPREAD: 1.216

GROUP SPREAD: 2.032

MIN RADIUS: 0.056

MAX RADIUS: 1.175

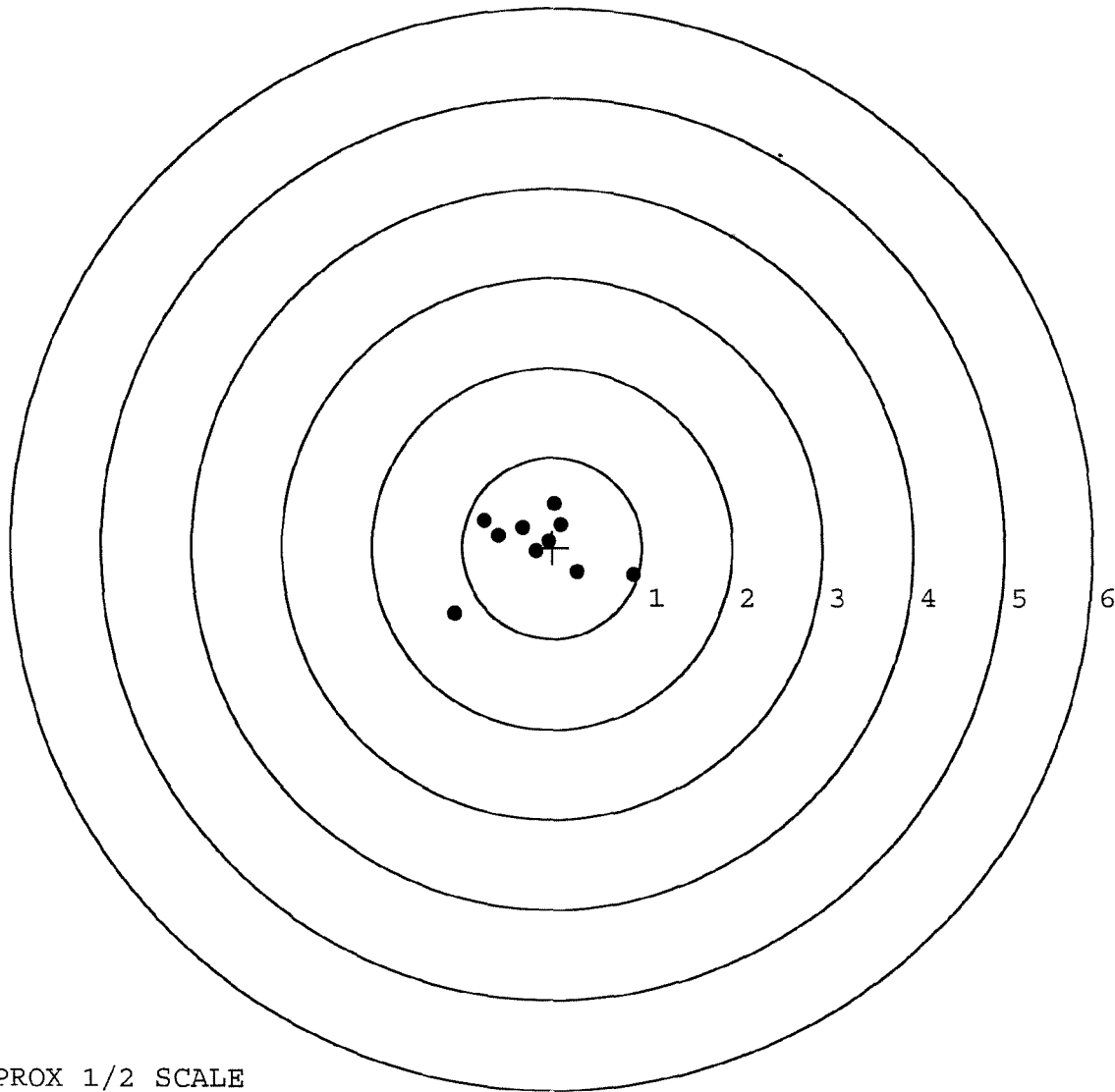
MEAN RADIUS: 0.525

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.905	-0.305
2:	0.280	-0.268
3:	-1.082	-0.728
4:	-0.755	0.295
5:	-0.597	0.137
6:	-0.334	0.220
7:	0.024	0.488
8:	0.090	0.254
9:	-0.044	0.070
10:	-0.181	-0.043



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6649214.___0

TARGET NUMBER: 4

FILE DATE: 10/16/2007

FILE TIME: 12:42

X CENTROID: -0.104

Y CENTROID: 0.028

POA TO CENTROID: 0.108

HORZ SPREAD: 2.209

VERT SPREAD: 1.331

GROUP SPREAD: 2.268

MIN RADIUS: 0.113

MAX RADIUS: 1.630

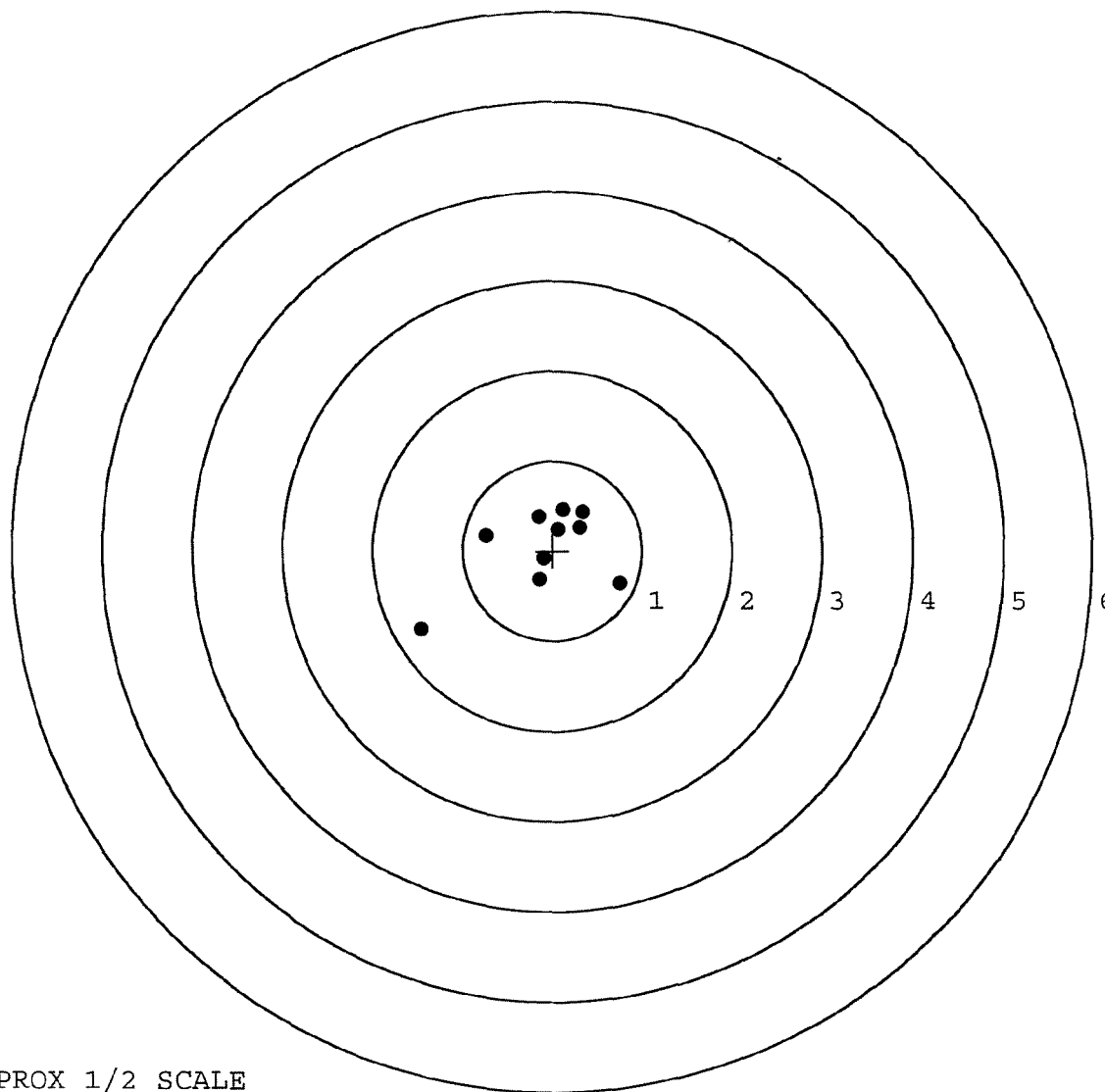
MEAN RADIUS: 0.585

IN 1 IN DIAMETER: 6

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 9

POINT#	X	Y
1:	-1.461	-0.875
2:	0.748	-0.362
3:	-0.153	-0.328
4:	-0.105	-0.085
5:	-0.736	0.167
6:	0.336	0.429
7:	0.302	0.259
8:	0.118	0.456
9:	0.062	0.239
10:	-0.154	0.377

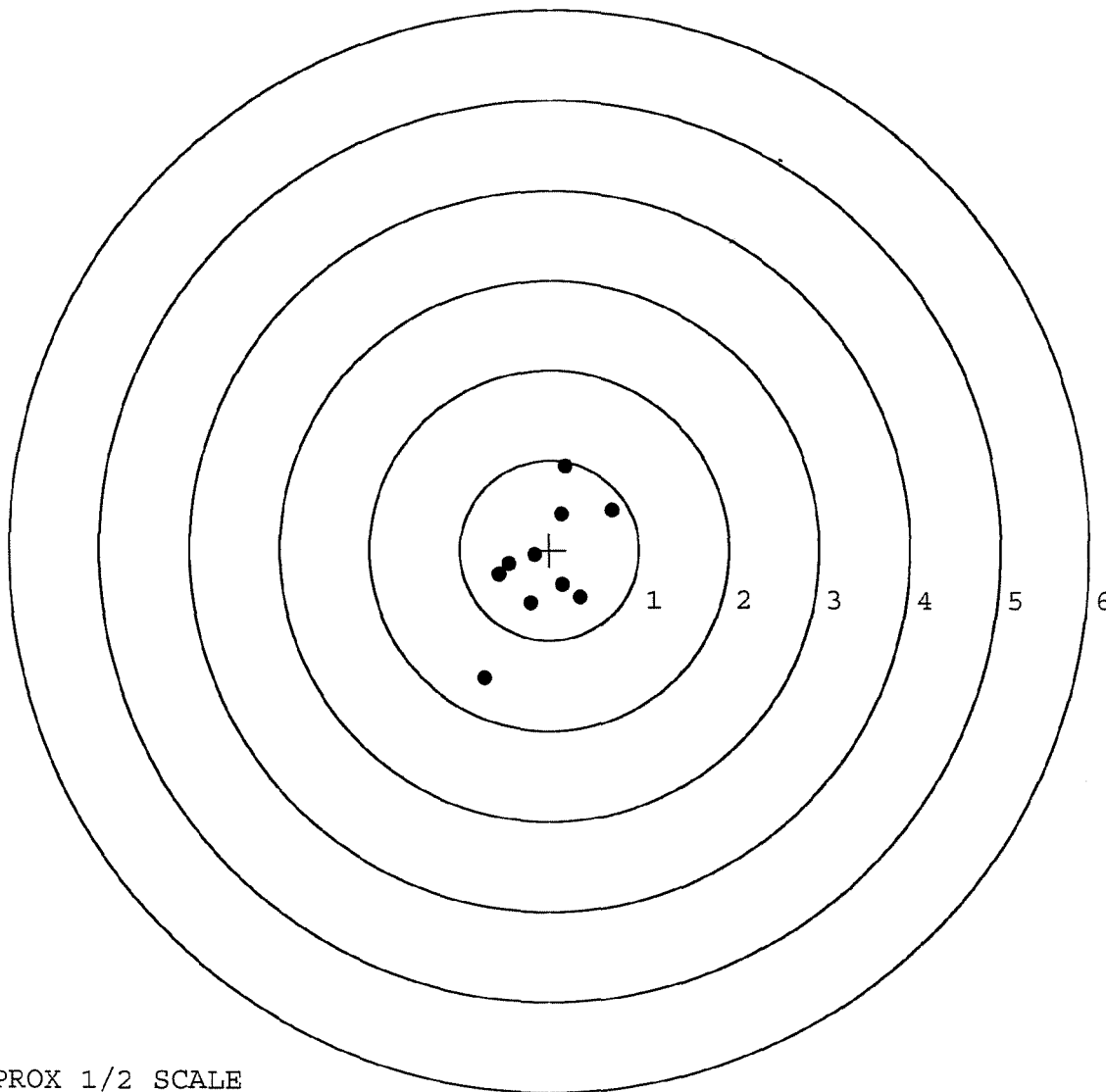


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6649214. __0
TARGET NUMBER: 5
FILE DATE: 10/16/2007
FILE TIME: 12:42

X CENTROID: -0.064
Y CENTROID: -0.164
POA TO CENTROID: 0.176
HORZ SPREAD: 1.424
VERT SPREAD: 2.359
GROUP SPREAD: 2.525
MIN RADIUS: 0.155
MAX RADIUS: 1.422
MEAN RADIUS: 0.650
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.173	-0.054
2:	0.699	0.450
3:	0.176	0.937
4:	0.132	0.404
5:	0.343	-0.532
6:	0.146	-0.391
7:	-0.216	-0.591
8:	-0.725	-1.422
9:	-0.566	-0.275
10:	-0.454	-0.162



TARGET APPROX 1/2 SCALE

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

R & E NUMBER <u>133021</u>			
SERIAL NUMBER <u>C6649214</u>			
LOG-IN DATE <u>8-22-07</u>			

OPERATION #	OPERATION NAME	DATE	INITIAL
500	DIS-ASSEMBLE GUN	10-1-07	RTZ
505	RE-BARREL	10-3-07	RTZ
560	ASSEMBLE	10-3-07	RTZ
600	PROOF	10-4-07	TRW
605	CHECK HEADSPACE	10-4-07	TRW
610	DIS-ASSEMBLE GUN	10-5-07	RTZ
612	MAGNAFLUX	10/5/07	mmg
510	DRILL AND TAP	10-5-07	FM
615	ROLLMARK CALIBER	10-5-07	CW
618	ROTO-BLAST	10-8-07	Zy
620	APPLY COATINGS	10/9/07	RTZ
625	FINAL ASSEMBLY	10-15-07	RTZ
640	FUNCTION TEST AND	PASS FAIL 10-16-07	TRW
650	TARGET	PASS FAIL 10-16-07	TRW
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
670	FINAL INSPECTION	10-16-07	DR
	A) HEADSPACE	PASS FAIL 10-22-07	RTZ
	B) TRIGGER PULL	268 255 245 280 247 10/19/07	mm
680	F) SAFETY ON FORCE	4.25 4.2 4.25 10-22-07	DA
	G) SAFETY OFF FORCE	3.5 3.5 3.5 10-22-07	DA
	I) FIRING PIN INDENT	1022 1022 1022 10-22-07	DA
690	PACK	10-23-07	DA

Remington



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

MODEL 700 TM M24

SERIAL NO.
C6649214

ORDER NO.
5716

20

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



5716 C6649214

ORDER **5716**
MODEL 700 TM M24
UPC



0 47700 25716 7

ORDER **5716**
MODEL 700 TM M24
UPC



0 47700 25716 7

GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6649214

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	10 1 91		RW
600	Proof	10 1 91		RW
607	Check Headspace	10 1 91		RW
610	Dis-assemble Gun	10 1 91		RW
612	Magnaflux Barrel Action		OCT 10 1991	KR
	Magnaflux Bolt		OCT 10 1991	KR
615	Rollmark Caliber		OCT 10 1991	LS
617	Drill and Tap Sight Holes		OCT 10 1991	LB
618	Polish Barrel		10/25/91	WB
620	Apply Coatings (Barrel Action)		11/2/91	1/5
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		11/11/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		11/11/91	RW
	C) Inspect Ejector Hole for Chamfer		11/11/91	RW
	D) Oil Firing Pin Ass'y		11/11/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		12/30/91	WB

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	3 3/4	3 1/2	3 1/2			12/31/91	WB
	G) Safety Off Force	2 1/2	2 1/2	2 1/4			12/31/91	WB
	H) Trigger Pull Test & Retainability						12/30/91	WB
	I) Firing Pin Indent	021.5	020.5	021			12/31/91	WB
	J) Assemble Stock						1/3/92	RW
	K) Assemble Swivel Studs						1-7-92	WB
	L) Attach Front and Rear Sight Assemblies						1/3/92	RW
	M) Iron Sight Alignment						1/3/92	RW
	N) Detach Front & Rear Sights & place in numbered container						1/3/92	RW
	O) Attach Scope to Rifle						1/3/92	RW
	P) Detach & Attach Scope 20 Times						1/3/92	RW
640	Gallery Target & Test						1-6-92	AC
	A) Time						1-6-92	AC
	B) Malfunctions						1-6-92	AC
	C) Pierced Primers						1-6-92	AC
	D) Optical Clarity of Scope						1-6-92	AC
645	Inspect for Live Ammo						1-6-92	AC
655	Final Inspection A) Headspace						1-7-92	WB
	B) Trigger Pull	2.37	2.30	2.30	2.31	2.26	1/7/92	RW
	C) Function						1-7-92	WB
660	Pack						2-25-92	WB

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06649214
6 Jan 1992

CENTROIDAL DISTANCES

0 TO 1	.183142
1 TO 2	.993552
1 TO 3	.086885
1 TO 4	.5441
1 TO 5	.327886

15 2 X----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .164
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1568
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .226897
THE AMR FOR THIS RIFLE IS: 1.045

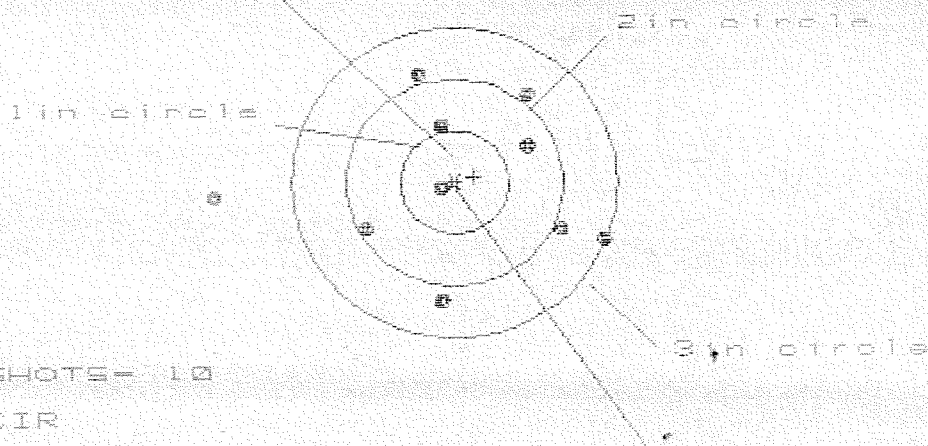
6 Jan 1982

FILE: PATTERNING/CENTERFIRE_PATT/C8648214

CENTERFIRE PATTERNS

1

POA



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 4

3 in = 9

HS= 3.519

VS= 2.143

GS= 3.545

CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.336	1.094	.891
MINIMUM X	-2.183	-1.037	-.900
MAXIMUM Y	1.020	1.003	.927
MINIMUM Y	-1.123	-1.140	-1.216
CENTROID X	-.175	.067	-.070
CENTROID Y	-.054	-.037	.039
POA TO CENTROID IN.	.183	.077	.080
MIN RADIUS	.103	.345	.235
MEAN RADIUS	1.042	.907	.842
MAX RADIUS	2.188	1.249	1.243
HORIZONTAL SPREAD	3.519	2.131	1.792
VERTICAL SPREAD	2.143	2.143	2.143
EXTREME SPREAD	3.545	2.344	2.154
NUMBER IN ONE INCH CIRCLE	= 1		
NUMBER IN TWO INCH CIRCLE	= 4		
NUMBER IN THREE INCH CIRCLE	= 9		

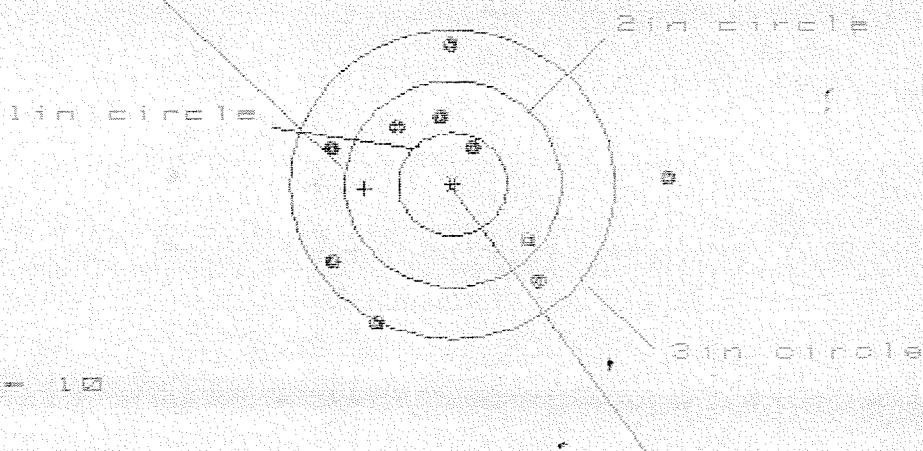
6 Jan 1992

FILE/PATTERNING/CENTERFIRE_PATT/C6649214

CENTERFIRE PATTERNS

2

POB



OF SHOTS= 10

IN CIR

1in = 1

2in = 4

3in = 9

HS= 3.076

VS= 2.664

GS= 3.180

CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.989	.988	.927
MINIMUM X	:	-1.087	-.866	-.927
MAXIMUM Y	:	1.367	1.369	1.207
MINIMUM Y	:	-1.297	-1.295	-1.054
CENTROID X	:	.814	.593	.654
CENTROID Y	:	.041	.039	.201
POB TO CENTROID in.	:	.815	.594	.685
MIN RADIUS	:	.400	.520	.367
MEAN RADIUS	:	1.116	1.005	.918
MAX RADIUS	:	1.989	1.386	1.404
HORIZONTAL SPREAD	:	3.076	1.954	1.854
VERTICAL SPREAD	:	2.664	2.664	2.261
EXTREME SPREAD	:	3.180	2.756	2.389
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		9	

6 Jan 1992

FILE:/PATTERNING/CENTERFIRE_PATT/C6649214

CENTERFIRE PATTERNS # 3

POA

1in circle

2in circle

3in circle

OF SHOTS= 10

IN CIR

1in = 3

2in = 6

3in = 9

HS= 1.601

VS= 2.860

GS= 2.965

CENTROID *

PATTERN #

:

3

SHOTS (BEST OF)

:

10

9

8

MAXIMUM X

:

.950

.878

.887

MINIMUM X

:

-.651

-.723

-.715

MAXIMUM Y

:

1.282

1.187

.732

MINIMUM Y

:

-1.578

-1.284

-1.146

CENTROID X

:

-.157

-.885

-.094

CENTROID Y

:

-.139

.036

-.102

POA TO CENTROID in.

:

.210

.093

.138

MIN RADIUS

:

.032

.198

.066

MEAN RADIUS

:

.867

.757

.785

MAX RADIUS

:

1.705

1.474

1.350

HORIZONTAL SPREAD

:

1.601

1.601

1.601

VERTICAL SPREAD

:

2.860

2.391

1.878

EXTREME SPREAD

:

2.965

2.518

2.468

NUMBER IN ONE INCH CIRCLE =

3

NUMBER IN TWO INCH CIRCLE =

6

NUMBER IN THREE INCH CIRCLE =

9

6 Jan 1992

FILE:/PATTERNING/CENTERFIRE_PATT/C6649214

CENTERFIRE PATTERNS

4

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS- 10

IN CIR

1 in = 0

2 in = 3

3 in = 7

HS= 2.544

VS= 2.737

GS= 3.050

PATTERN #

4

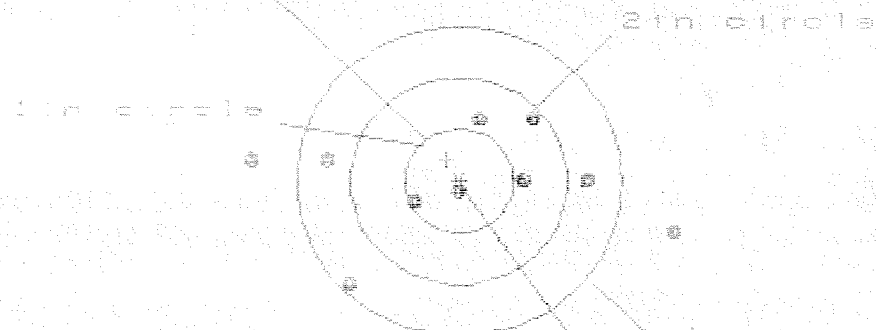
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.373	1.248	1.112
MINIMUM X	-1.166	-1.110	-0.954
MAXIMUM Y	1.218	1.049	0.930
MINIMUM Y	-1.519	-0.958	-0.891
CENTROID X	.223	.353	.197
CENTROID Y	-.425	-.256	-.137
POA TO CENTROID in.	.480	.436	.240
MIN RADIUS	.522	.313	.327
MEAN RADIUS	1.142	1.010	.930
MAX RADIUS	1.915	1.573	1.289
HORIZONTAL SPREAD	2.544	2.358	2.066
VERTICAL SPREAD	2.737	2.007	1.821
EXTREME SPREAD	3.050	3.050	2.571
NUMBER IN ONE INCH CIRCLE =		0	
NUMBER IN TWO INCH CIRCLE =		3	
NUMBER IN THREE INCH CIRCLE =		7	

8 Jan 1992

FILE:/PATTERNING/CENTERFIRE_PATT/C8849214

CENTERFIRE PATTERNS # 5

POA



OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 8

HS- 3.898

VS- 1.684

GS- 3.554

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.970	1.405	1.192
MINIMUM X	:	-1.928	-1.709	-1.238
MAXIMUM Y	:	.647	.597	.617
MINIMUM Y	:	-1.037	-1.087	-1.067
CENTROID X	:	.115	-.104	.110
CENTROID Y	:	-.207	-.157	-.177
POA TO CENTROID in	:	.237	.183	.208
MIN RADIUS	:	.122	.279	.152
MEAN RADIUS	:	1.060	.964	.832
MAX RADIUS	:	2.021	1.716	1.435
HORIZONTAL SPREAD	:	3.898	3.114	2.420
VERTICAL SPREAD	:	1.684	1.684	1.684
EXTREME SPREAD	:	3.954	3.118	2.428
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C6649214

DATE 12/30/91

TESTER W/B

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.54	2.32	2.43		MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.57	2.41	2.36		
PULL #3	2.58	2.36	2.36		
PULL #4	2.39	2.46	2.36		
PULL #5	2.37	2.47	2.36		
TOTAL	12.45	12.02	11.87		
AVG.	2.49	2.40	2.37		

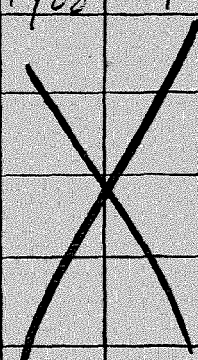
	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.02	3.00		
PULL #2	3.02	3.04		
PULL #3	3.02	3.08		
PULL #4	3.09	3.12		
PULL #5	3.14	2.95		
TOTAL	15.29	15.19		
AVG.	3.06	3.04		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.10	4.00		4.23
PULL #2	4.13	4.01		4.31
PULL #3	4.01	4.00		4.30
PULL #4	4.21	4.06		4.17
PULL #5	4.04	4.05		4.13
TOTAL	20.49	20.12		21.14
AVG.	4.10	4.02		4.23

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6225254

OPERATION		DATE	INT
#	NAME		
575-580	ASSEMBLY	2 26	FB
600	PROOF	29	Ru
615	MAGNAFLUX BARREL	5/13/88	PPE.
	MAGNAFLUX BOLT	5/13/88	PPE.
620	COATING	8/1/88	TJA
625-630	FINAL ASSEMBLY		
635	TEST		
640	TARGET		
	FIRING PIN INDENT		
660	PACK		

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6225254

Lot #1

10/88

OP.#	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and stock			
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		8/23/88	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/23/88	RW
	C) Inspect Ejector Hole for Chamfer		8/23/88	RW

OVER

OP.#		READINGS	DATE	INITIAL
625 cont.	D) Oil Firing Pin Ass'y		8/23/88	RW
	E) Adjust Trigger Pull to Min. Setting and Stake		25 Aug 88	J.U. + J.S.
	F) Safety on Force	6.5 6 6	25 Aug 88	J.U. + J.S.
	G) Safety off Force	3 3 3.5	25 Aug 88	J.U. + J.S.
	H) Trigger Pull Test & Retainability		25 Aug 88	J.U. + J.S.
	I) Firing Pin Indent	.022 .0225 .0225	25 Aug 88	J.U. + J.S.
	J) Assemble Stock		8/25/88	RW
	K) Assemble Swivel Studs			
	L) Attach Front & Rear Sight Assemblies		8/25/88	RW
	M) Iron Sight Alignment		9/2/88	RW
	N) Detach Front & Rear Sights & place in numbered container		9/2/88	RW
	O) Attach Scope to Rifle	48 R 107 L 48 E		
	P) Detach & Attach Scope 20 times		9/8/88	V.B.
640	Gallery Target & Test		9/12/88	AC
	A) Optical Clarity of Scope	OK		
645	Inspect for Live Ammo		9/12/88	AC
655	Final Inspection			
	A) Headspace			
	B) Trigger Pull	Set at 4# during test		
	C) Function			
660	Pack			

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

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

SERIAL NO. C6225254

DATE 25 Aug. 88

TESTER J. P. + D. S.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#	COMMENTS
PULL #1	2.48	2.66	2.63	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.41	2.65	2.57	
PULL #3	2.56	2.60	2.56	
PULL #4	2.46	2.62	2.61	
PULL #5	2.53	2.60	2.58	
TOTAL	12.44	13.13	12.95	
AVG.	2.488	2.626	2.59	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.15	3.17		
PULL #2	3.16	3.05		
PULL #3	3.11	3.12		
PULL #4	3.19	3.09		
PULL #5	3.11	3.17		
TOTAL	15.72	15.60		
AVG.	3.144	3.12		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.23	4.14		4.42
PULL #2	4.19	4.20		4.43
PULL #3	4.19	4.21		4.40
PULL #4	4.25	4.20		4.36
PULL #5	4.18	4.22		4.37
TOTAL	21.04	20.97		21.98
AVG.	4.208	4.194		4.396

ENDURANCE TEST GUN # C-6225254

QP 0041

PART NUMBER 96005

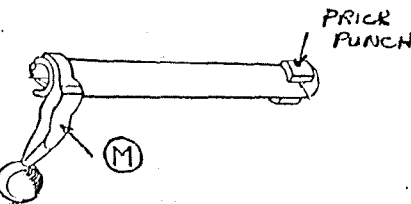
MAGNETIC PARTICLE INSPECTION

PART NAME Final Bolt Assem. MATERIAL Bolt Head-8640, Bolt Body 1140M, Bolt

OPERATION NUMBER 615

METHOD	SINGLE PARTS			MULTIPLE PARTS		
	HEAD SHOT	CENTRAL CONDUCTOR	COIL SHOT	HEAD SHOT	CENTRAL CONDUCTOR	COIL SHOT IN BASKET
NON-FLUORESCENT CONTINUOUS WET						
FLUORESCENT CONTINUOUS WET	Yes		Yes			
NON-FLUORESCENT RESIDUAL WET						
FLUORESCENT RESIDUAL WET						

SKETCH AND/OR REMARKS



600-800-Head Shot
900-1100-Coil Shot

APPROVAL:

INSP. _____ LEV III _____
DATE: _____ DATE: _____

ACCEPTANCE STANDARD

STEEL STAMP ON Prick punch O.D. large locking lug (Left)

OTHER & letter "M" circled on Bolt Handle

PROCEDURE:

1. All parts must be cleaned before testing.
2. All parts shall be satisfactorily demagnetized after all magnetization has been completed.
3. The magnetic substance shall be completely removed from all parts after inspection and demagnetization.
4. All accepted parts must be marked with a mangaflex stamp, acid etch, or ink stamp. (If the part is too small or is a critical part, contact inspection supervisor).
5. Parts having indications not acceptable shall be segregated and identified, and are to be reviewed by Metallurgy and inspection groups.
6. All areas to be inspected 100%.
7. Inspection to be performed by a certified Level I, acceptance or rejection of product will be done by a certified Level II, or Level III.

Bolt Handle is not included
in Magnetic Particle Inspection.
It is checked for strength at
another operation.
No indications on the Bolt Head.
Lug area.

USE BACK SIDE OF THIS CARD TO RECORD EACH LOT INSPECTED.
ALL BLOCKS MUST BE PROPERLY FILLED IN.

1.1 - 1.4
LEV III.
INSP. _____

Peter J. Corn
9-21-88

FORM QP-0041-1

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

M2400066524

DATE	MFG. ORDER NO.	QUANTITY	SERIAL #	QUANTITY OF PARTS	
				ACCEPTED	REJECTED
9-21-88 <i>PJL.</i>		1 ENDURANCE GUN AT 2500 Rds	BOLT ASSEM. C-6225254	1-OK	
9-30-88 <i>PJL.</i>		1 ENDURANCE GUN AT 5000 Rd	BOLT ASSEM. C-6225254	1-OK	
10-3-88 <i>PJL.</i>		1 ENDURANCE GUN AT 6000 Rds	BOLT ASSEM. C-6225254	1-OK	
10-5-88 <i>PJL.</i>		1 ENDURANCE GUN AT 7000 Rds	BOLT ASSEM. C-6225254	1-OK	
10-11-88 <i>PA PJL.</i>		1 ENDURANCE GUN AT 8000 Rd	BOLT ASSEM. C-6225254	1-OK	
10-12-88 <i>PJL.</i>		1 ENDURANCE GUN AT 9000 Rds	BOLT ASSEM. C-6225254	1-OK	
10-17-88 <i>P.J. Cross</i>		1 ENDURANCE GUN AT 10,000 Rd	BOLT ASSEM. C-6225254	1-OK	

ENDURANCE TEST GUN SERIAL # C-6225254

QP 0041

PART NUMBER 96002

MAGNETIC PARTICLE INSPECTION

PART NAME Final Bbl.Assem. MATERIAL Bbl. Rem.Spec.#155-Rec.Spec.4137M

OPERATION NUMBER 615

METHOD	SINGLE PARTS			MULTIPLE PARTS		
	HEAD SHOT	CENTRAL	CONDUCTOR	HEAD SHOT	CENTRAL	CONDUCTOR
	HEAD SHOT	CONDUCTOR	COIL SHOT	HEAD SHOT	COIL SHOT	IN BASKET
						AMPERES

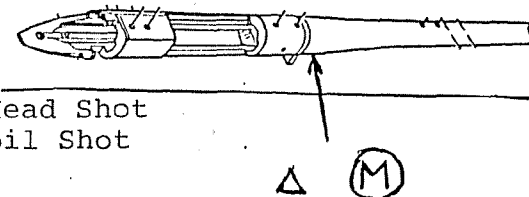
SKETCH AND/OR REMARKS

NON-FLUORESCENT
CONTINUOUS WET

FLUORESCENT
CONTINUOUS WET Yes

Yes (2 Overlapping)

900-1100-Head Shot
600-800-Coil Shot



NON-FLUORESCENT
RESIDUAL WET

FLUORESCENT
RESIDUAL WET

APPROVAL:

INSP. _____ LEV III _____
DATE: _____ DATE: _____

ACCEPTANCE STANDARD

STEEL STAMP ON. Triangular stamp (Δ) and letter "M" circled

OTHER Location-right side near Receiver.

PROCEDURE:

1. All parts must be cleaned before testing.
2. All parts shall be satisfactorily demagnetized after all magnetization has been completed.
3. The magnetic substance shall be completely removed from all parts after inspection and demagnetization.
4. All accepted parts must be marked with a mangaflux stamp, acid etch, or ink stamp (If the part is too small or is a critical part, contact inspection supervisor).
5. Parts having indications not acceptable shall be segregated and identified, and are to be reviewed by Metallurgy and inspection groups.
6. All areas to be inspected 100%.
7. Inspection to be performed by a certified Level I, acceptance or rejection of product will be done by a certified Level II, or Level III.

No Indications acceptable in the
Locking Lug area of Receiver or
chamber area of Bbl.

USE BACK SIDE OF THIS CARD TO RECORD EACH LOT INSPECTED.

ALL BLOCKS MUST BE PROPERLY FILLED IN.

LEV III.
INSP. _____

Peter J. Con
9-21-AP

FORM QP-0041-1

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER

M2400066526

KINZER V. REMINGTON

DATE	MFG. ORDER NO.	QUANTITY	SERIAL #	QUANTITY OF PARTS ACCEPTED	REJECTED
9-21-88 <i>pjl.</i>		1 ENDURANCE GUN AT 2500 Rds	C-6225254	1-OK	
9-30-88 <i>pjl.</i>		1 ENDURANCE GUN AT 5000 RDS	C-6225254	1-OK	
10-3-88 <i>pjl.</i>		1 ENDURANCE GUN AT 6000 Rds.	C-6225254	1-OK	
10-5-88 <i>pjl.</i>		1 ENDURANCE GUN AT 7000 Rds	C-6225254	1-OK	
10-11-88 <i>pjl.</i>		1 ENDURANCE GUN AT 8000 Rds	C-6225254	1-OK	
10-12-88 <i>pjl.</i>		1 ENDURANCE GUN AT 9000 Rds	C-6225254	1-OK	
10-17-88 <i>P.T. CROSS</i>		1 ENDURANCE GUN AT 10,000 Rds	C-6225254	1-OK	

1

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06225254

CENTROIDAL DISTANCES

Ø TO	1	1.26702
1 TO	2	1.2664
1 TO	3	1.13502
1 TO	4	.987662
1 TO	5	.639766

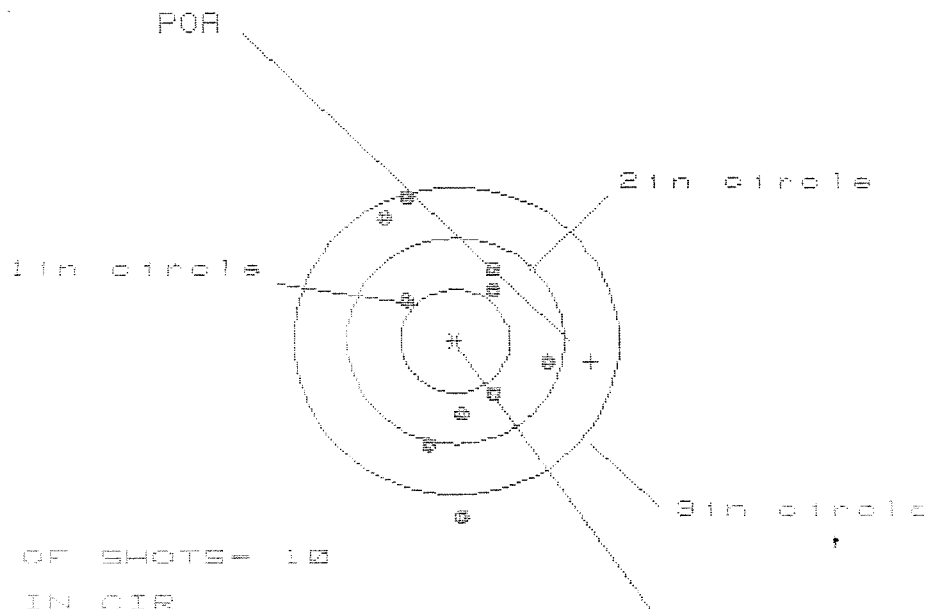
1 5 4
2
-----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.8316
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0246
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .831964
THE AMR FOR THIS RIFLE IS: 1.265

12 Sep 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C6225254A

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1 in = 0

2 in = 6

3 in = 9

HS= 1.515

VS= 3.045

GS= 3.087

CENTROID *

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.827	.829	.767
MINIMUM X	:	-.688	-.686	-.748
MAXIMUM Y	:	1.344	1.155	1.145
MINIMUM Y	:	-1.701	-1.153	-1.089
CENTROID X	:	-1.250	-1.252	-1.190
CENTROID Y	:	.207	.396	.252
POR TO CENTROID in.	:	1.267	1.313	1.216
MIN RADIUS	:	.567	.472	.532
MEAN RADIUS	:	.953	.862	.800
MAX RADIUS	:	1.701	1.255	1.368
HORIZONTAL SPREAD	:	1.515	1.515	1.515
VERTICAL SPREAD	:	3.045	2.308	2.154
EXTREME SPREAD	:	3.087	2.316	2.189
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6225254

CENTROIDAL DISTANCES

0	TO	1	1.26702
1	TO	2	1.2664
1	TO	3	1.13501
1	TO	4	.967662
1	TO	5	95.2087

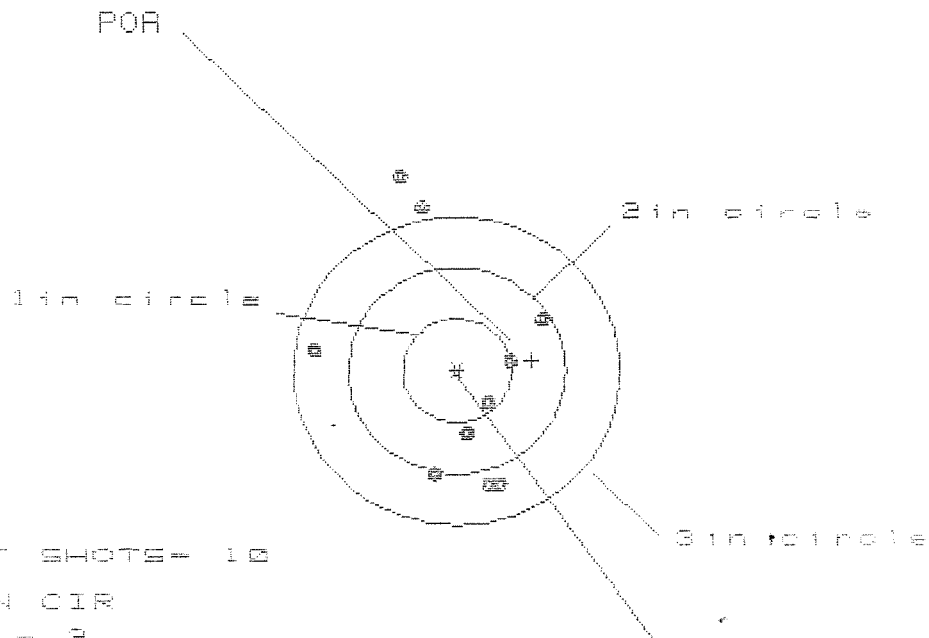
1 4
2 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.8316
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -19.0052
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: 19.0234
THE AMP FOR THIS RIFLE IS: 1.205

12 Sep 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C6225254A

CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1 in = 2

2 in = 4

3 in = 0

HSE= 2.130

VS= 3.063

GS= 3.199

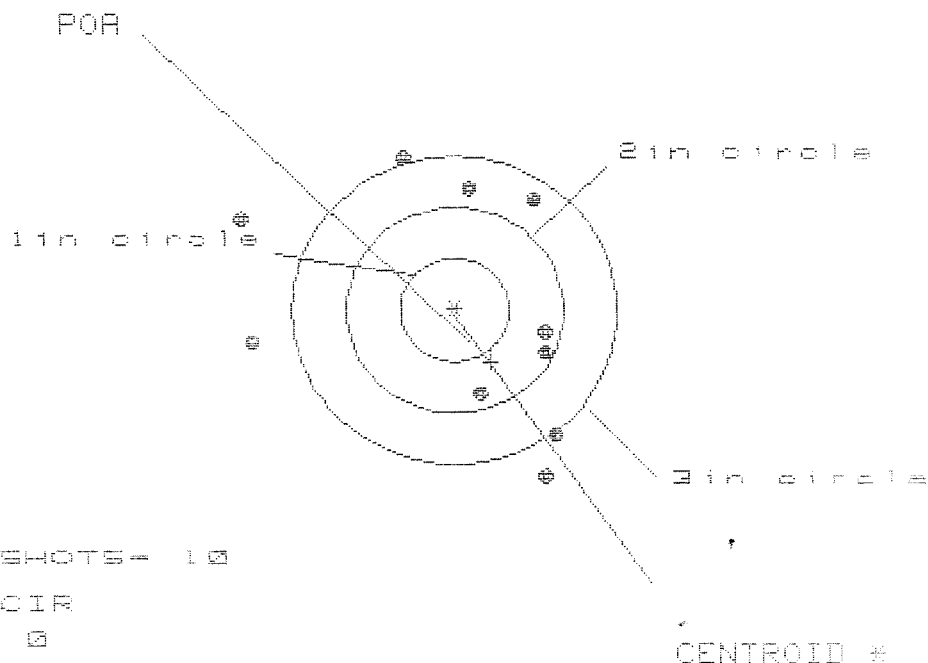
CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.806	.745	.698
MINIMUM X	:	-1.324	-1.385	-1.432
MAXIMUM Y	:	1.929	1.789	.894
MINIMUM Y	:	-1.134	-.920	-.696
CENTROID X	:	-.686	-.625	-.578
CENTROID Y	:	-.095	-.309	-.533
POA TO CENTROID in.	:	.693	.698	.786
MIN RADIUS	:	.412	.235	.205
MEAN RADIUS	:	1.084	.914	.736
MAX RADIUS	:	2.005	1.829	1.578
HORIZONTAL SPREAD	:	2.130	2.130	2.130
VERTICAL SPREAD	:	3.063	2.709	1.590
EXTREME SPREAD	:	3.199	2.797	2.176
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	

12 Sep 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C6225254A

CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1 in = 0

2 in = 3

3 in = 5

HS= 2.836

VS= 3.050

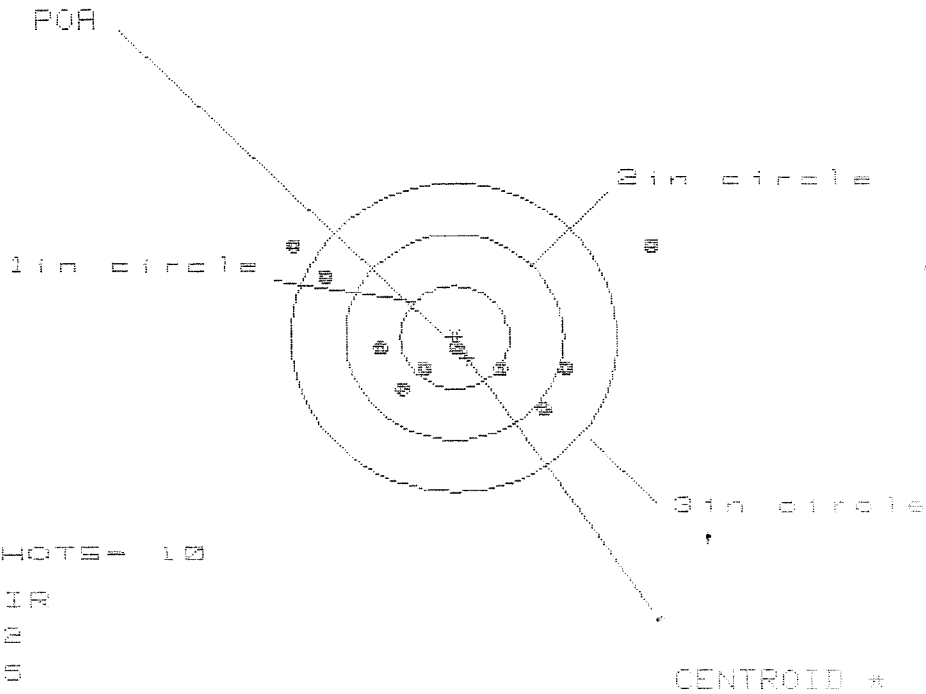
GS= 3.716

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.899	.684	.417
MINIMUM X	:	-1.937	-2.132	-.990
MAXIMUM Y	:	1.456	1.554	1.529
MINIMUM Y	:	-1.594	-1.496	-1.521
CENTROID X	:	-.331	-.116	.151
CENTROID Y	:	.510	.412	.437
POA TO CENTROID in.	:	.608	.428	.462
MIN RADIUS	:	.802	.572	.319
MEAN RADIUS	:	1.396	1.257	1.084
MAX RADIUS	:	2.126	2.141	1.821
HORIZONTAL SPREAD	:	2.836	2.816	1.467
VERTICAL SPREAD	:	3.050	3.050	3.050
EXTREME SPREAD	:	3.716	3.334	3.334
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		5	

12 Sep 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C6225254A

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1 in = 2

2 in = 5

3 in = 3

HS= 3.329

VS= 1.609

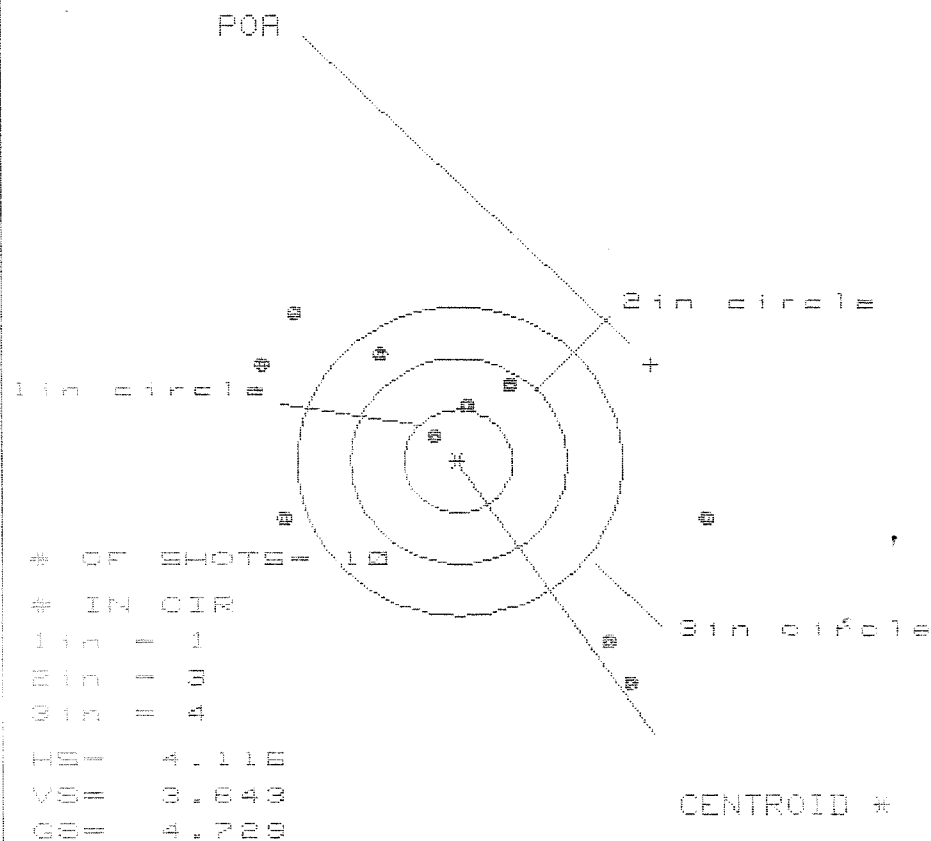
GS= 3.329

PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	1.817
MINIMUM X	-1.512
MAXIMUM Y	.873
MINIMUM Y	-.736
CENTROID X	-.115
CENTROID Y	.202
POR TO CENTROID in.	.233
MIN RADIUS	.152
MEAN RADIUS	.970
MAX RADIUS	2.016
HORIZONTAL SPREAD	3.329
VERTICAL SPREAD	1.609
EXTREME SPREAD	3.329
NUMBER IN ONE INCH CIRCLE	= 2
NUMBER IN TWO INCH CIRCLE	= 5
NUMBER IN THREE INCH CIRCLE	= 3

12 Sep 1988

FILE:/PATTERNING/CENTERFIRE_PATT/06225254A

CENTERFIRE PATTERNS # 2



PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.322	2.493	1.856
MINIMUM X	:	-1.794	-1.623	-1.312
MAXIMUM Y	:	1.480	1.240	1.137
MINIMUM Y	:	-2.163	-1.972	-2.075
CENTROID X	:	-1.776	-1.947	-2.258
CENTROID Y	:	-.945	-.705	-.682
POA TO CENTROID in.	:	2.012	2.070	2.337
MIN RADIUS	:	.344	.060	.268
MEAN RADIUS	:	1.616	1.404	1.233
MAX RADIUS	:	2.651	2.626	2.784
HORIZONTAL SPREAD	:	4.116	4.116	3.168
VERTICAL SPREAD	:	3.643	3.212	3.212
EXTREME SPREAD	:	4.729	4.381	4.298
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		4	

2

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6225254

CENTROIDAL DISTANCES

0 TO	1	.936673
1 TO	2	.952647
1 TO	3	.655626
1 TO	4	.800615
1 TO	5	.993712

avg 1 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .3844
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1192
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .326987
THE AMP FOR THIS RIFLE IS: .9516

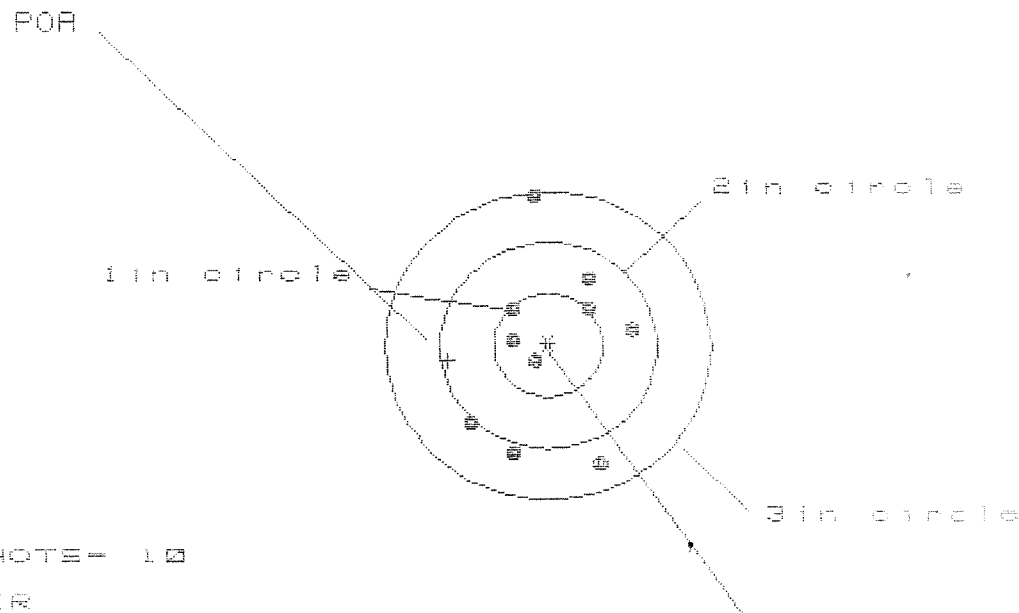
ENDURANCE RIFLE @ 500 RDS

AVG. CENTROID DIFFERENCE FROM START TO
500 ROUND LEVEL = 1.1 inches

14 Sep 1988

FILE:/PATTERNING/CENTERFIRE_PATT/END5005254

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1 in = 3

2 in = 6

3 in = 10

HM= 1.584

VM= 2.531

GM= 2.593

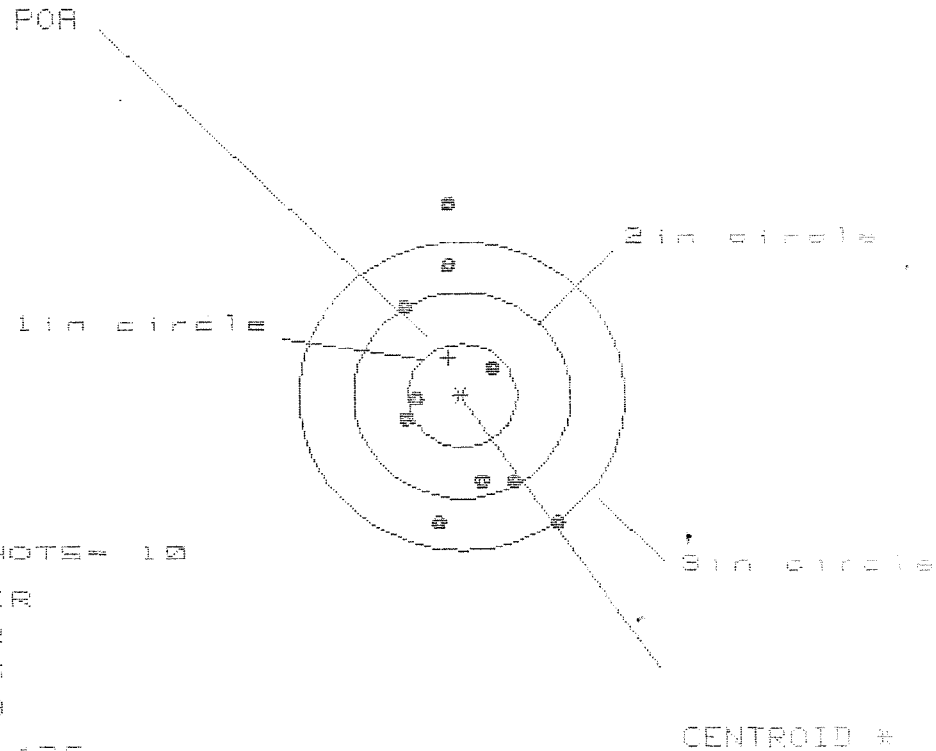
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.809	.861	.861
MINIMUM X	-.775	-.783	-.723
MAXIMUM Y	1.438	.852	.736
MINIMUM Y	-1.093	-.934	-.996
CENTROID X	.926	.934	.874
CENTROID Y	.141	-.018	.098
POR TO CENTROID in.	.936	.934	.880
MIN RADIUS	.208	.135	.144
MEAN RADIUS	.803	.734	.669
MAX RADIUS	1.440	1.050	1.040
HORIZONTAL SPREAD	1.584	1.584	1.584
VERTICAL SPREAD	2.531	1.786	1.732
EXTREME SPREAD	2.593	1.861	1.861
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		10	

14 Sep 1988

FILE:/PATTERNING/CENTERFIRE_PATT/END05005254

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1in = 2

2in = 5

3in = 8

MS= 1.435

VS= 3.175

GS= 3.279

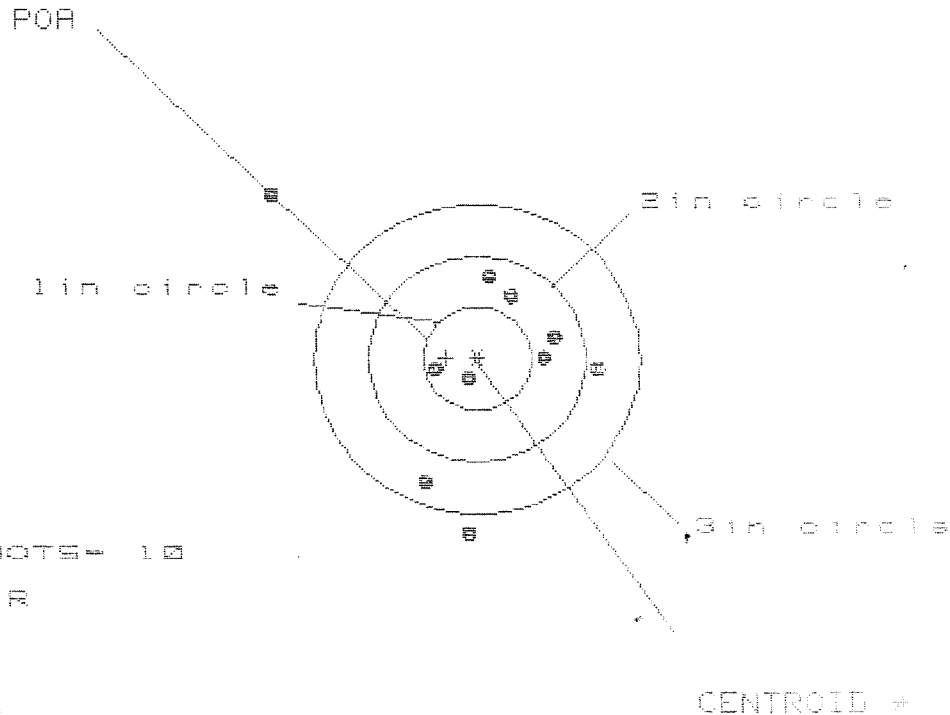
CENTROID *

PATTERN #	:	2	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.918	.900	.579
MINIMUM X	:	-.518	-.536	-.423
MAXIMUM Y	:	1.915	1.464	1.343
MINIMUM Y	:	-1.259	-1.047	-1.168
CENTROID X	:	.122	.140	.027
CENTROID Y	:	-.370	-.583	-.462
POR TO CENTROID in.	:	.390	.600	.463
MIN RADIUS	:	.368	.462	.313
MEAN RADIUS	:	1.012	.891	.821
MAX RADIUS	:	1.922	1.475	1.345
HORIZONTAL SPREAD	:	1.436	1.436	1.002
VERTICAL SPREAD	:	3.175	2.511	2.511
EXTREME SPREAD	:	3.279	2.659	2.511
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	5		
NUMBER IN THREE INCH CIRCLE	=	9		

14 Sep 1988

FILE:/PATTERNING/CENTERFIRE_PATT/END5805254

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1in = 2

2in = 6

3in = 8

HS= 3.072

VS= 3.298

GS= 3.763

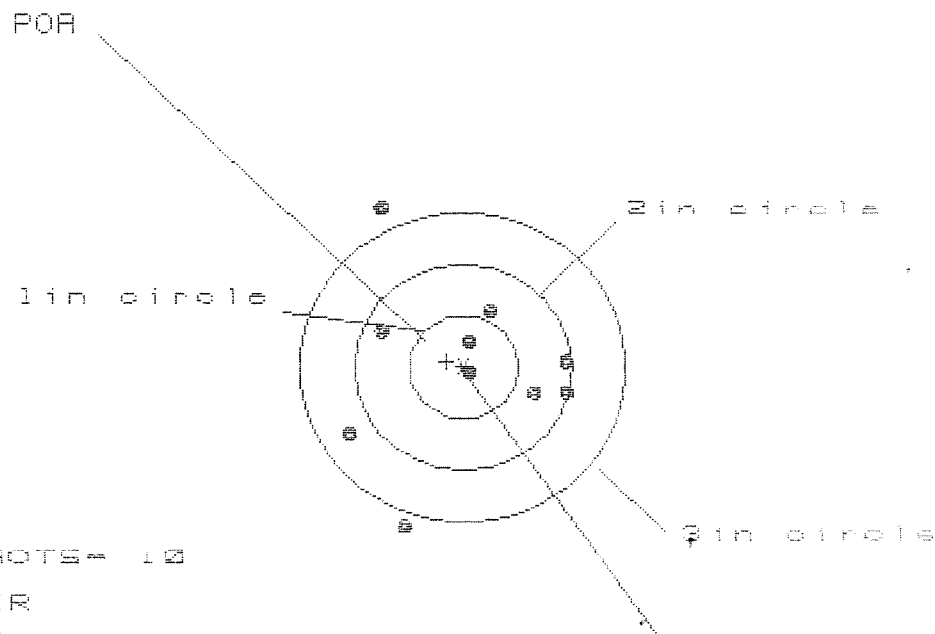
CENTROID +

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.150	.937	.696
MINIMUM X	:	-1.922	-.685	-.726
MAXIMUM Y	:	1.614	.992	.804
MINIMUM Y	:	-1.684	-1.505	-1.240
CENTROID X	:	.288	.501	.542
CENTROID Y	:	-.010	-.189	-.001
POR TO CENTROID in.	:	.288	.536	.542
MIN RADIUS	:	.230	.290	.399
MEAN RADIUS	:	1.025	.844	.720
MAX RADIUS	:	2.510	1.539	1.437
HORIZONTAL SPREAD	:	3.072	1.622	1.622
VERTICAL SPREAD	:	3.298	2.497	2.044
EXTREME SPREAD	:	3.763	2.511	2.139
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

14 Sep 1988

FILE:/PATTERNING/CENTERFIRE_PATT/END5885254

CENTERFIRE PATTERNS # 4



OF SHOTS = 10

IN CIR

1in = 2

2in = 6

3in = 8

HS = 1.887

VS = 3.073

GS = 3.081

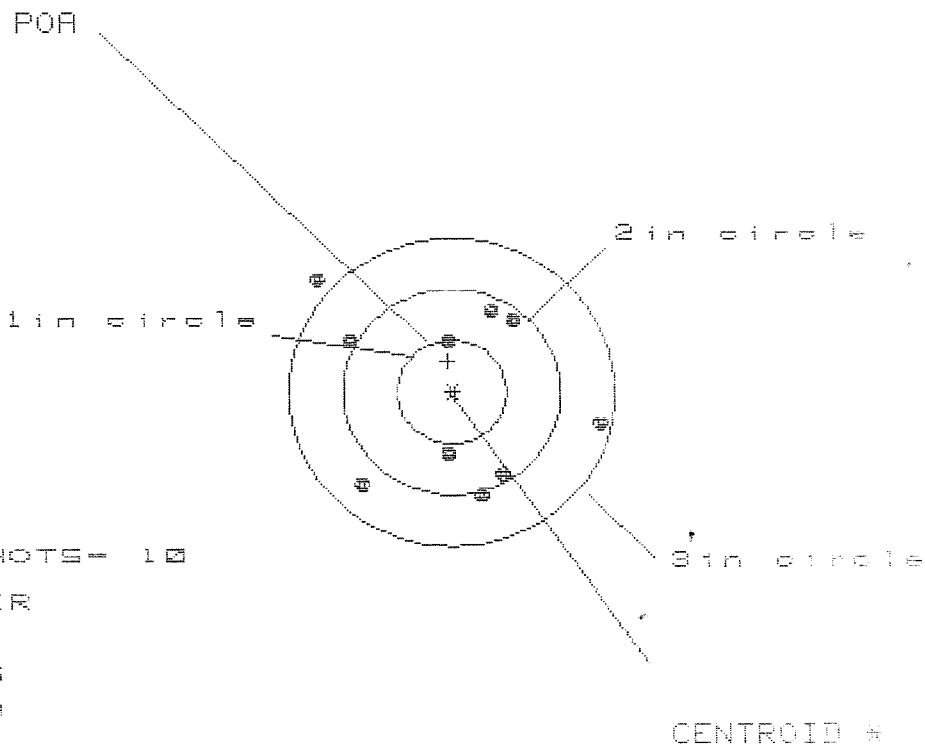
CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.982	.898	.826
MINIMUM X	:	-1.085	-1.089	-1.167
MAXIMUM Y	:	1.553	.695	.527
MINIMUM Y	:	-1.520	-1.348	-.525
CENTROID X	:	.150	.234	.311
CENTROID Y	:	-.056	-.228	-.060
FOR TO CENTROID in.	:	.160	.327	.317
MIN RADIUS	:	.085	.118	.111
MEAN RADIUS	:	.902	.816	.684
MAX RADIUS	:	1.726	1.484	1.324
HORIZONTAL SPREAD	:	1.987	1.987	1.987
VERTICAL SPREAD	:	3.073	2.043	1.152
EXTREME SPREAD	:	3.081	2.201	2.080
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

14 Sep 1988

FILE:/PATTERNING/CENTERFIRE_PATT/END5805254

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 5

3 in = 4

HSI = 2.607

VS = 2.123

GS = 2.971

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.405	1.272	.562
MINIMUM X	:	-1.202	-1.020	-.861
MAXIMUM Y	:	1.112	.882	.859
MINIMUM Y	:	-1.011	-.888	-.911
CENTROID X	:	.036	.169	.010
CENTROID Y	:	-.301	-.424	-.401
POA TO CENTROID in.	:	.303	.457	.401
MIN RADIUS	:	.500	.500	.479
MEAN RADIUS	:	1.016	.934	.883
MAX RADIUS	:	1.637	1.286	1.179
HORIZONTAL SPREAD	:	2.607	2.292	1.423
VERTICAL SPREAD	:	2.123	1.770	1.770
EXTREME SPREAD	:	2.971	2.435	2.157
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

(3)

E 4500

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 5254E4500

C622 5254

CENTROIDAL DISTANCES

0 TO	1	1.12699
1 TO	2	.914245
1 TO	3	1.29781
1 TO	4	1.01136
1 TO	5	.991146

2 49t3 <----POA

1

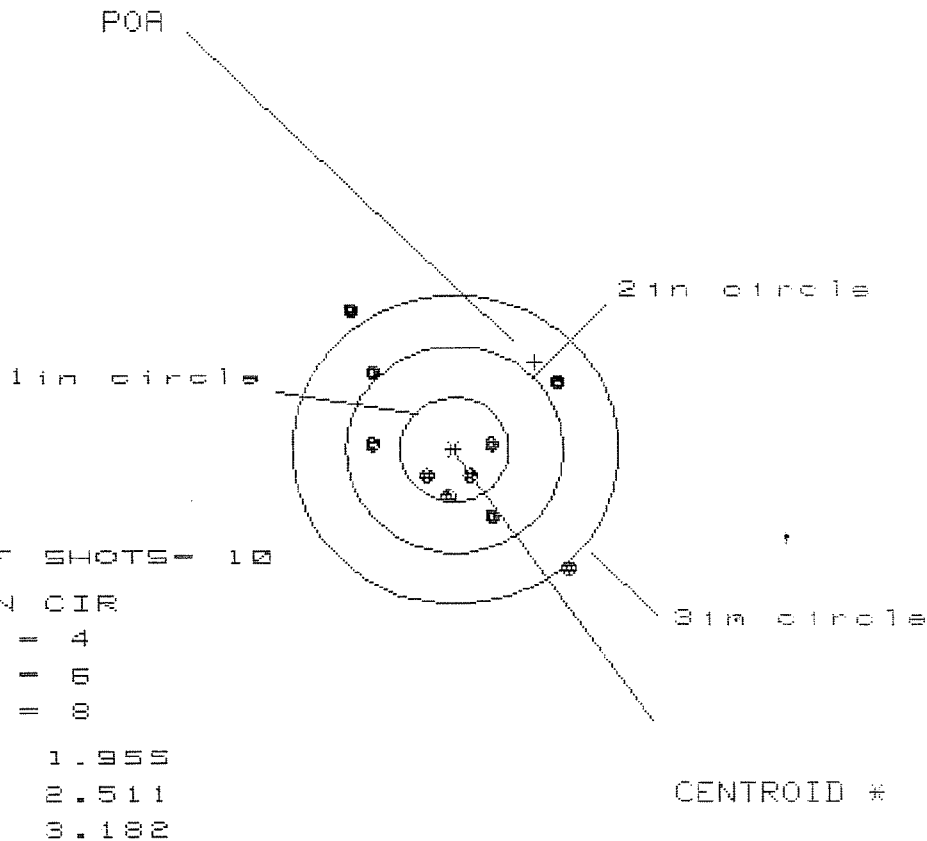
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.3714
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1598
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .404319

THE AMR FOR THIS RIFLE IS: 1.206

29 Sep 1986

FILE:/PATTERNING/CENTERFIRE_PATT/E14500

CENTERFIRE PATTERNS # 1

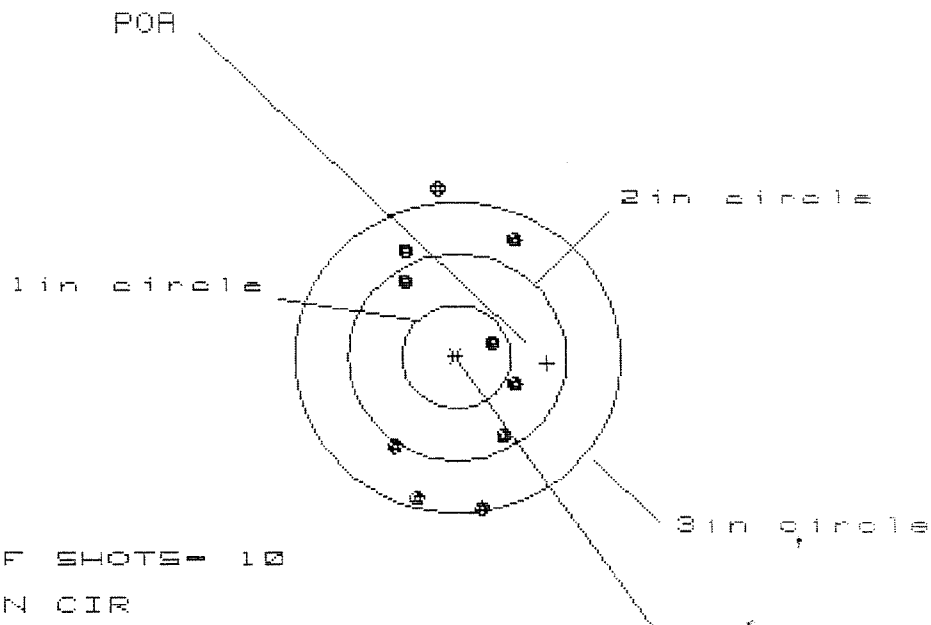


PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.044	.943	.937
MINIMUM X	:	-.911	-.892	-.774
MAXIMUM Y	:	1.338	.863	.735
MINIMUM Y	:	-1.173	-1.025	-.655
CENTROID X	:	-.740	-.639	-.757
CENTROID Y	:	-.850	-.998	-.870
POA TO CENTROID in.	:	1.127	1.185	1.153
MIN RADIUS	:	.262	.095	.250
MEAN RADIUS	:	.837	.712	.643
MAX RADIUS	:	1.618	1.393	1.148
HORIZONTAL SPREAD	:	1.955	1.835	1.711
VERTICAL SPREAD	:	2.511	1.888	1.390
EXTREME SPREAD	:	3.182	2.633	1.822
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

29 Sep 1988

FILE:/PATTERNING/CENTERFIRE_PATT/E14500

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 4

3 in = 8

HS= 1.108

VS= 3.099

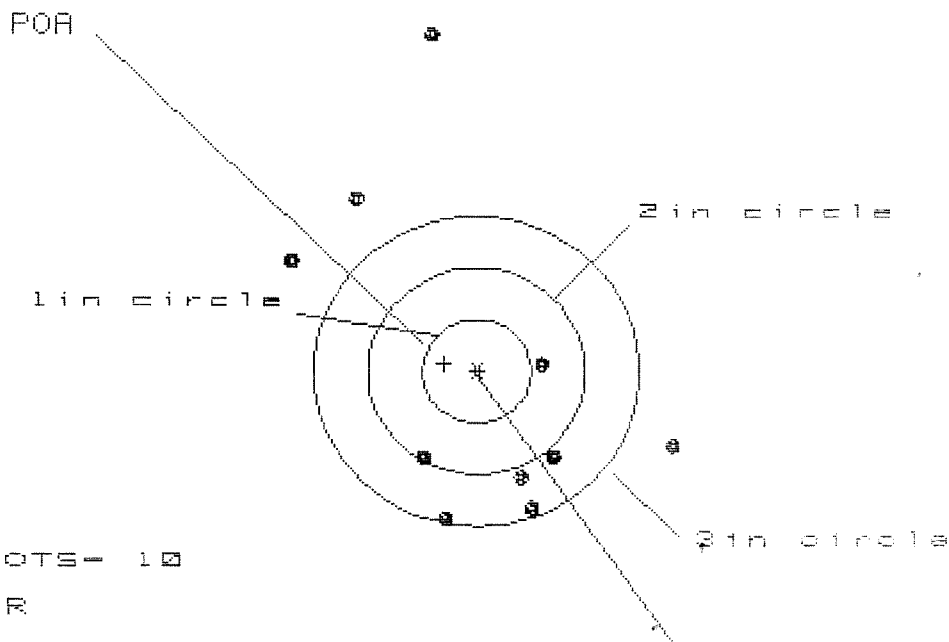
GS= 3.132

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.565	.544	.575
MINIMUM X	:	-.543	-.564	-.533
MAXIMUM Y	:	1.605	1.349	1.185
MINIMUM Y	:	-1.494	-1.315	-1.351
CENTROID X	:	-.828	-.807	-.838
CENTROID Y	:	.060	-.118	.047
POA TO CENTROID in.	:	.831	.816	.839
MIN RADIUS	:	.334	.438	.349
MEAN RADIUS	:	1.068	.995	.945
MAX RADIUS	:	1.617	1.444	1.406
HORIZONTAL SPREAD	:	1.108	1.108	1.108
VERTICAL SPREAD	:	3.099	2.664	2.535
EXTREME SPREAD	:	3.132	2.703	2.703
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	

29 Sep 1988

FILE:/PATTERNING/CENTERFIRE_PATT/E14500

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 0

2 in = 2

3 in = 6

HS= 3.492

VS= 4.671

GS= 4.674

CENTROID #

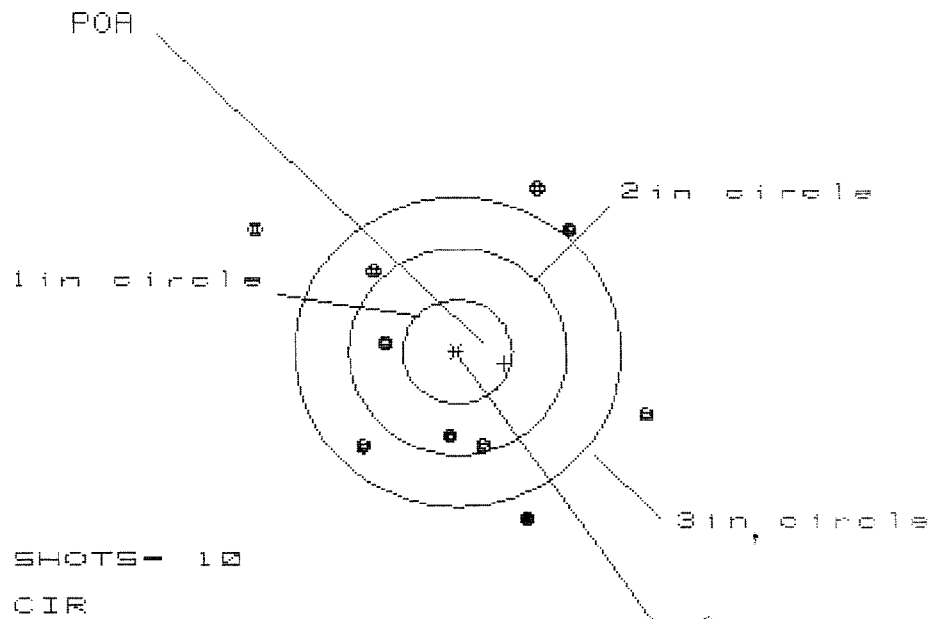
PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.774	1.726	1.586
MINIMUM X	:	-1.718	-1.766	-1.906
MAXIMUM Y	:	3.242	2.076	1.656
MINIMUM Y	:	-1.429	-1.069	-0.810
CENTROID X	:	.301	.349	.489
CENTROID Y	:	-.075	-.435	-.694
POA TO CENTROID in.	:	.310	.557	.849
MIN RADIUS	:	.581	.694	.456
MEAN RADIUS	:	1.578	1.277	1.042
MAX RADIUS	:	3.270	2.361	2.525
HORIZONTAL SPREAD	:	3.492	3.492	3.492
VERTICAL SPREAD	:	4.671	3.145	2.466
EXTREME SPREAD	:	4.674	3.919	3.919
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		2	
NUMBER IN THREE INCH CIRCLE	=		6	

29 Sep 1988

FILE:/PATTERNING/CENTERFIRE_PATT/E14580

CENTERFIRE PATTERNS

4



OF SHOTS- 10

IN CIR

1 in = 0

2 in = 3

3 in = 5

HS= 3.548

VS= 3.197

GS= 3.979

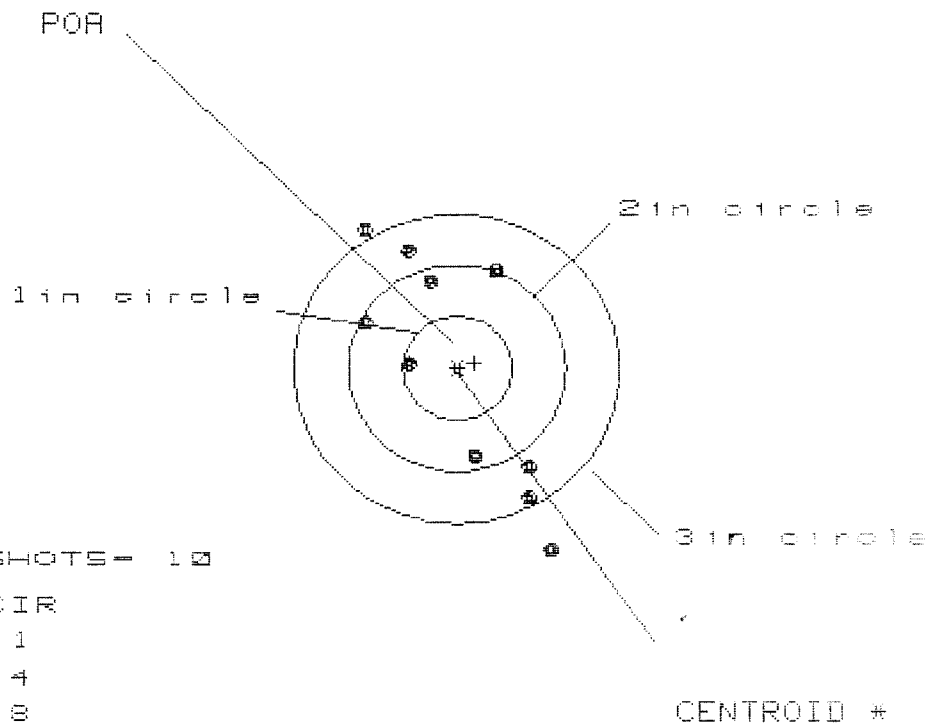
CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.712	1.508	1.056
MINIMUM X	:	-1.836	-1.095	-.987
MAXIMUM Y	:	1.620	1.752	1.692
MINIMUM Y	:	-1.577	-1.445	-1.505
CENTROID X	:	-.431	-.227	-.415
CENTROID Y	:	.113	-.019	.041
POA TO CENTROID in.	:	.445	.227	.417
MIN RADIUS	:	.724	.758	.752
MEAN RADIUS	:	1.397	1.300	1.239
MAX RADIUS	:	2.187	1.818	1.821
HORIZONTAL SPREAD	:	3.548	2.603	1.963
VERTICAL SPREAD	:	3.197	3.197	3.197
EXTREME SPREAD	:	3.979	3.197	3.197
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		5	

29 Sep 1988

FILE:/PATTERNING/CENTERFIRE_PATT/E14580

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 1

2in = 4

3in = 8

HS= 1.700

VS= 3.185

GS= 3.610

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.869	.760	.668
MINIMUM X	:	-.831	-.734	-.809
MAXIMUM Y	:	1.395	1.196	1.115
MINIMUM Y	:	-1.790	-1.404	-1.254
CENTROID X	:	-.159	-.256	-.164
CENTROID Y	:	-.047	.152	.002
POA TO CENTROID in.	:	.166	.297	.164
MIN RADIUS	:	.399	.324	.389
MEAN RADIUS	:	1.152	1.017	.984
MAX RADIUS	:	1.990	1.581	1.406
HORIZONTAL SPREAD	:	1.700	1.494	1.477
VERTICAL SPREAD	:	3.185	2.600	2.369
EXTREME SPREAD	:	3.610	2.982	2.601
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	

SWS ENDURANCE TEST REPORT

SERIAL NO. C6225254 SHOOTER DH/AC DATE 9-15-88

AMMO CODE	AMMO TYPE	RDS.	RESULTS	OBSERVATIONS
—	7.62 ^{MM} NATO	30 DH	OK	—
—	—	30 DH	OK	—
—	—	30 DH	OK	—
—	—	30 DH	OK	—
—	—	30 DH	OK	—
		30 DH	OK 9/15/88	
	7.62 mm NATO	30 AC	OK 9-16-88	—
	"	30 AC	OK	—
	"	30 AC	OK	—
	"	30 AC	OK	—
	"	30 AC	OK	—
	"	30 AC	OK	—
	"	30 AC	OK	—
	"	30 AC	OK	—
	"	30 AC	OK	—
	"	30 AC	OK	—
	"	30 AC	OK	—
	"	30 AC	OK	—
	"	30 AC	OK	—
	"	30 DH	OK	9-18-88
Total	Rounds	660		

SWS ENDURANCE TEST REPORT

SERIAL NO. C6225254 SHOOTER AC/DH DATE 7/23/88

AMMO CODE	AMMO TYPE	RDS.	RESULTS	OBSERVATIONS
	7.62 ^{MM} NATO	30 DH	OK 9/23/88	
	"	30 DH	OK	
	" "	30 DH	OK	
	" "	30 DH	OK	
	" "	30 DH	OK	
	" "	30 DH	OK 9/24/88	
	" "	30 DH	OK	
	" "	30 DH	OK	
	" "	30 DH	OK	
	" "	30 DH	OK	
	" "	30 DH	OK	
	" "	30 DH	OK	
	" "	30 DH	OK	
	7.62mm	30 AC	OK 9/26/88	NONE
	7.62mm	30 AC	OK	
	7.62mm	30 AC	OK	
	7.62mm	30 AC	OK	
	7.62mm	30 AC	OK	
	7.62mm	30 AC	OK	
	7.62mm	30 AC	OK	
	7.62mm	30 AC	OK	
total	rounds	660		

SWS ENDURANCE TEST REPORT

SERIAL NO. C6225254 SHOOTER AC. / D.H. DATE 9/26/88

AMMO CODE	AMMO TYPE	RDS.	RESULTS	OBSERVATIONS
	7.62mm Nato	30 AC	OK	NONE
	7.62mm	30 AC	OK	
	7.62mm	30 AC	OK	
	7.62mm	30 AC	OK	
	7.62mm	30 AC	OK	
	7.62mm	30 AC	OK	
	7.62mm	30 AC	OK	
	7.62mm	30 AC	OK	
	7.62mm	30 AC	OK	
	7.62mm	30 AC	OK	
	7.62mm	30 AC	OK	9/27/88
	7.62mm	30 AC	OK	NONE
	" "	30 DH	OK	
	" "	30 DH	OK	
	" "	30 DH	OK	
	" "	30 DH	OK	
	" "	30 DH	OK	
	" "	30 DH	OK	
	" "	30 DH	OK	
	" "	30 DH	OK	
		4440	OK	9/27/88
		60	OK	9/28/88
	TOTAL	4500		

SWS ENDURANCE TEST REPORT

SERIAL NO. C6225254 SHOOTER AC/DH DATE 9/30/88

AMMO CODE	AMMO TYPE	RDS.	RESULTS	OBSERVATIONS
	7.62mm	30 AC	OK	NO WE
	7.62mm	30 AC	OK	
	7.62mm	30 AC	OK	
	7.62mm	30 AC	OK	
	7.62mm	30 AC	OK	
	7.62mm	30 AC	OK	
	7.62mm	30 AC	OK	
	7.62mm	30 AC	OK	
	7.62mm	30 AC	OK	
	7.62mm	30 AC	OK	
	7.62mm	30 DH	OK	
	7.62mm	30 DH	OK	
	7.62mm	30 AC	OK	
	7.62mm	30 AC	OK	
	7.62mm	30 AC	OK	
	7.62mm	30 AC	OK	
	7.62mm	30 AC	OK	
	7.62mm	30 AC	OK	
	7.62mm	30 AC	OK	
	7.62mm	30 AC	OK	
	7.62mm	30 AC	OK	
	7.62mm	30 AC	OK	
Total Rounds 660				

SWS ENDURANCE TEST REPORT

DATE _____

[illegible]

SWS ENDURANCE TEST REPORT

SERIAL NO. C.6225254 SHOOTER AC DATE 10-14-88

AMMO CODE	AMMO TYPE	RDS.	RESULTS	OBSERVATIONS
	7.62 nato	30	OK	_____
	7.62 nato	30	OK	_____
	7.62 nato	30	OK	_____
	7.62 nato	30	OK	_____
	7.62 nato	30	OK	_____
	7.62 nato	30	OK	_____
	7.62 nato	30	OK	_____
	7.62 nato	30	OK	_____
	7.62 nato	30	OK	_____
	7.62 nato	30	OK	_____
	7.62 nato	30	OK	_____
	7.62 nato	30	OK	_____
	7.62 nato	30	OK	_____
	7.62 nato	10		_____
total	Rounds	340		
	+	660		
		1000		
	19	000		
total	10	000		

(4)

E 5000

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6225254

CENTROIDAL DISTANCES

0 TO	1	1.01786
1 TO	2	1.43684
1 TO	3	1.35192
1 TO	4	1.14032
1 TO	5	1.19202

$5^2 + 43$ <----POA

1

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .180
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1286
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .223667

THE AMR FOR THIS RIFLE IS: 1.036

Average centroid difference from 4500
to 5000 round level = 0.8 inches

30 Sep 1988

FILE:/PATTERNING/CENTERFIRE_PATT/06225254.1

CENTERFIRE PATTERNS # 1

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 8

HS= 2.785

VS= 3.313

GS= 3.355

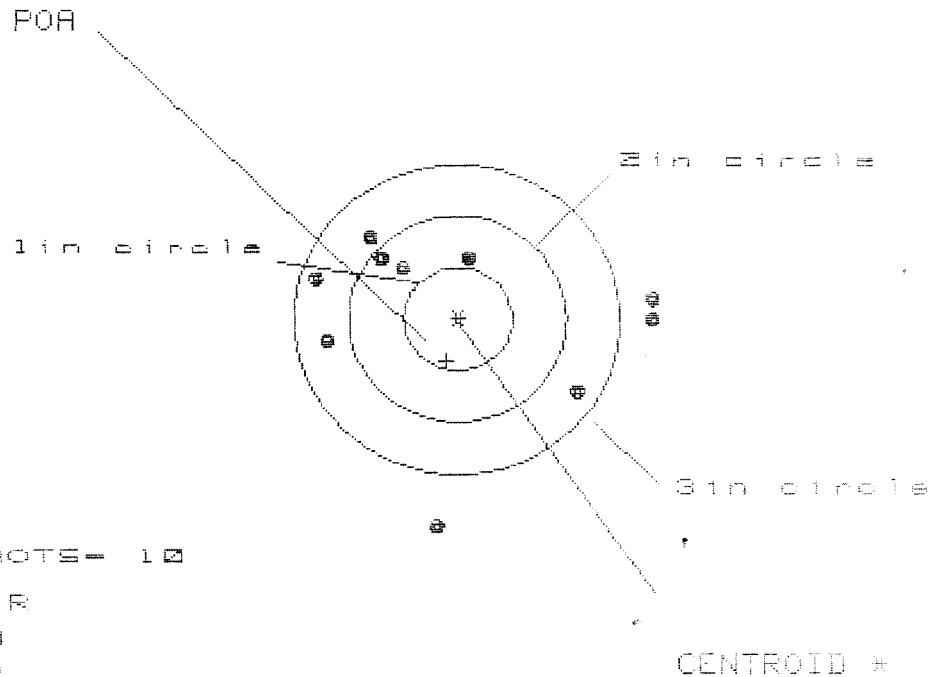
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.761	1.738	.994
MINIMUM X	-1.025	-1.048	-.831
MAXIMUM Y	1.324	1.103	1.087
MINIMUM Y	-1.989	-.803	-.819
CENTROID X	-.205	-.182	-.399
CENTROID Y	-.997	-.776	-.760
POA TO CENTROID in.	1.018	.797	.859
MIN RADIUS	.402	.430	.349
MEAN RADIUS	1.098	.974	.842
MAX RADIUS	2.000	1.742	1.269
HORIZONTAL SPREAD	2.786	2.786	1.825
VERTICAL SPREAD	3.313	1.906	1.906
EXTREME SPREAD	3.355	2.819	2.141
NUMBER IN ONE INCH CIRCLE	= 1		
NUMBER IN TWO INCH CIRCLE	= 5		
NUMBER IN THREE INCH CIRCLE	= 8		

30 Sep 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C8225254.1

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1 in = 0

2 in = 3

3 in = 7

HS= 3.089

VS= 2.871

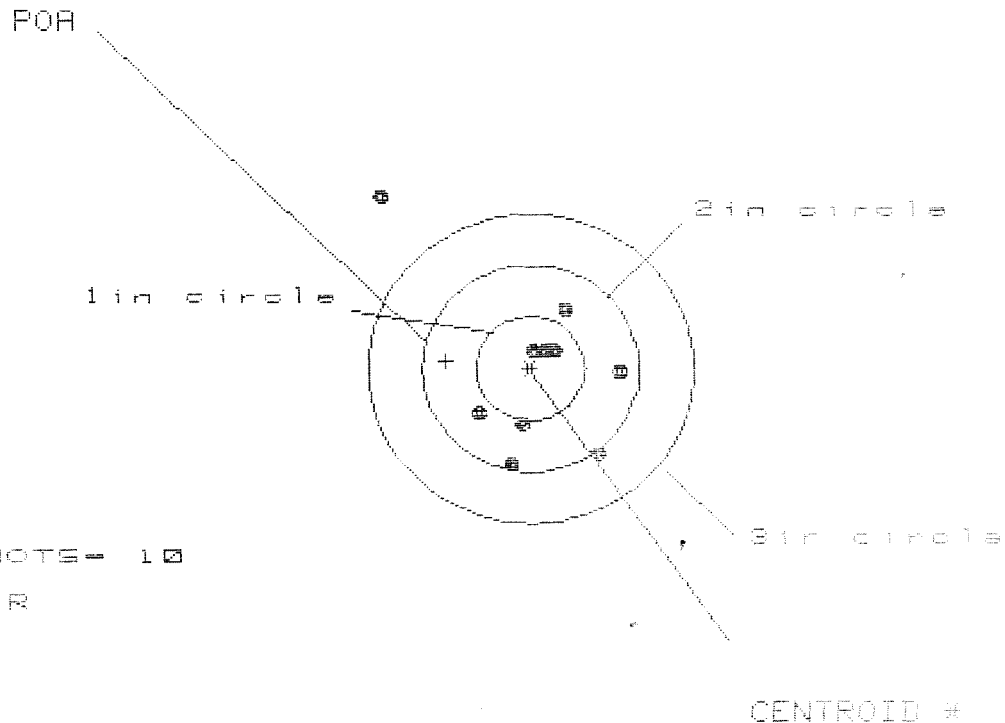
GS= 3.124

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.771	1.750	1.952
MINIMUM X	:	-1.318	-1.339	-1.121
MAXIMUM Y	:	.834	.608	.575
MINIMUM Y	:	-2.037	-.974	-1.007
CENTROID X	:	.105	.126	-.092
CENTROID Y	:	.406	.632	.665
POA TO CENTROID in.	:	.419	.645	.671
MIN RADIUS	:	.627	.401	.366
MEAN RADIUS	:	1.292	1.160	1.017
MAX RADIUS	:	2.047	1.769	1.955
HORIZONTAL SPREAD	:	3.089	3.089	3.073
VERTICAL SPREAD	:	2.871	1.582	1.582
EXTREME SPREAD	:	3.124	3.124	3.085
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		7	

30 Sep 1988

FILE:/PATTERNING/CENTERFIRE_PATT/08225254.1

CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1in = 3

2in = 3

3in = 3

HS = 2.214

VS = 2.568

GS = 3.156

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.803	.646	.699
MINIMUM X	:	-1.411	-.631	-.570
MAXIMUM Y	:	1.665	.721	.647
MINIMUM Y	:	-.903	-.718	-.792
CENTROID X	:	.780	.937	.884
CENTROID Y	:	-.071	-.256	-.181
POA TO CENTROID in.	:	.793	.971	.902
MIN RADIUS	:	.138	.342	.278
MEAN RADIUS	:	.735	.566	.526
MAX RADIUS	:	2.182	.793	.842
HORIZONTAL SPREAD	:	2.214	1.277	1.277
VERTICAL SPREAD	:	2.568	1.439	1.439
EXTREME SPREAD	:	3.156	1.538	1.538
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		9	
NUMBER IN THREE INCH CIRCLE	=		9	

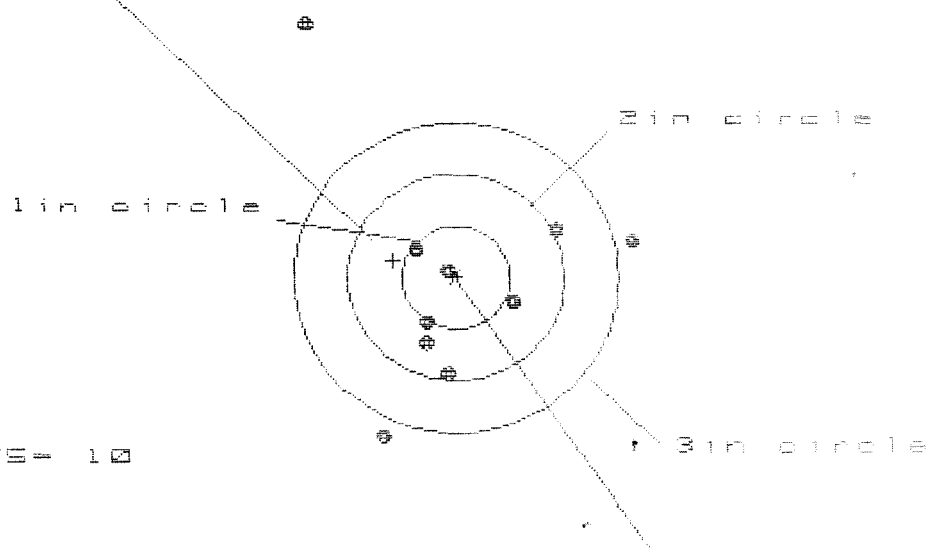
30 Sep 1988

FILE:/PATTERNING/CENTERFIRE_PATT/06225254.1

CENTERFIRE PATTERNS

4

POA



OF SHOTS= 10

IN CIR

1 in = 2

2 in = 6

3 in = 7

HS= 3.007

VS= 3.936

GS= 4.005

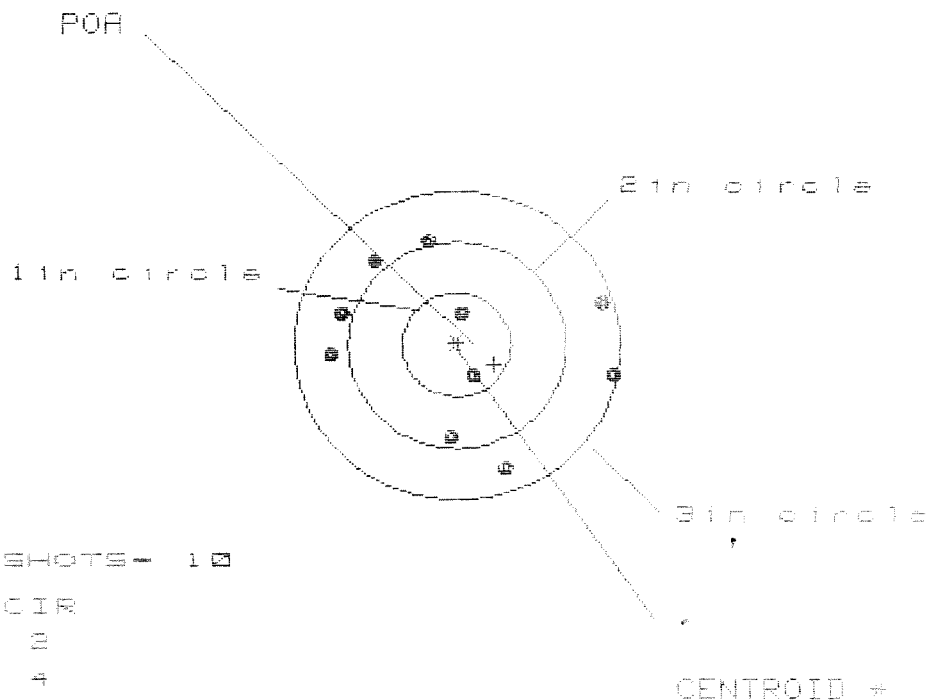
CENTROID *

PATTERN #	4
SHOTS (BEST OF)	10
MAXIMUM X	1.588
MINIMUM X	-1.419
MAXIMUM Y	2.447
MINIMUM Y	-1.489
CENTROID X	.578
CENTROID Y	-.168
POA TO CENTROID in.	.602
MIN RADIUS	.051
MEAN RADIUS	1.035
MAX RADIUS	2.829
HORIZONTAL SPREAD	3.007
VERTICAL SPREAD	3.936
EXTREME SPREAD	4.005
NUMBER IN ONE INCH CIRCLE	2
NUMBER IN TWO INCH CIRCLE	6
NUMBER IN THREE INCH CIRCLE	7

30 Sep 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C8225254.1

CENTERFIRE PATTERNS # 5



OF SHOTS - 10

IN CIR

1in = 2

2in = 4

3in = 8

HS = 2.681

VS = 2.171

GS = 2.688

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	1.482
MINIMUM X	-1.199
MAXIMUM Y	.964
MINIMUM Y	-1.207
CENTROID X	-.343
CENTROID Y	.187
POA TO CENTROID in.	.390
MIN RADIUS	.291
MEAN RADIUS	1.020
MAX RADIUS	1.505
HORIZONTAL SPREAD	2.681
VERTICAL SPREAD	2.171
EXTREME SPREAD	2.688
NUMBER IN ONE INCH CIRCLE	2
NUMBER IN TWO INCH CIRCLE	4
NUMBER IN THREE INCH CIRCLE	8

- Trigger pull set at upper limit
- No Swivels & Studs - interfere with gate - 9/11/88

Sheet 1 of 18

SWS ENDURANCE TEST REPORT

SERIAL NO. C6225254 SHOOTER AC/OH DATE 9/13/88

AMMO CODE	AMMO TYPE	RDS.	RESULTS	OBSERVATIONS
.	7.62 mm NATO	30 DH	OK	—
	7.62 mm NATO	30 AC	OK	—
	" "	30 DH	OK	—
	" "	30 AC	OK	—
	" "	30 DH	OK	—
	" "	30 AC	OK	—
	" "	30 DH	OK	—
	" "	30 AC	OK	—
	" "	30 DH	OK	—
	" "	30 AC	OK	—
	" "	30 DH	OK	—
	" "	30 AC	OK	—
	" "	30 DH	OK	—
	" "	30 AC	OK	—
	" "	20 AC	OK	—
		440	OK	— 9-14-88
	" "	D.H 60	TARGET TEST	9-14-88
	" "	30 DH	OK	9/14-88
	" "	30 AC	OK	9/14/88
	" "	30 DH	OK	—
total Rounds		590		

SWS ENDURANCE TEST REPORT

SERIAL NO. C6225254 SHOOTER AC/OH DATE 9-14-88

AMMO CODE	AMMO TYPE	RDS.	RESULTS	OBSERVATIONS
	7.62 mm Nato.	30 AC	OK	
	—	30 OH	OK	
	—	30 A.G.	OK	
	—	30 DH	OK	
	—	30 DH	OK	
	—	30 DH	OK	
	—	30 DH	OK	
	—	30 DH	OK	
	7.62 mm Nato	30 AC	OK	9-15-88
	—	30 AC	OK	
	—	30 AC	OK	
	—	30 DH	OK	
	—	30 AC	OK	
	—	30 DH	OK	
	—	30 AC	OK	
	—	30 DH	OK	
	—	30 AC	OK	
	—	30 DH	OK	
	—	30 AC	OK	
	—	30 DH	OK	
	—	30 DH	OK	
total	Rounds	660		

Repair Inquiry

Repair Number: **RE00059328**Serial: C6649214 Model 700 Center Fire Caliber:
7.62 NATO M-24 (SWS)

Repairman:

Verify Repair

Status:

Closed 1/10/2003 8:29:13 AM

Address Information

Customer:

☒ Received From

Return To:

☐ Received FromName: **TRANSPORTATION OFFICER****TRANSPORTATION OFFICER**Address 1: **USPFO FOR ARKANSAS ARMY NAT GUARD****USPFO FOR ARKANSAS ARMY NAT GUARD**Address 2: **CAMP JOSEPH T ROBINSON**

PO Box:

CAMP JOSEPH T ROBINSON

PO Box:

City: **NORTH LITTLE ROCK****NORTH LITTLE ROCK**State: **AR**Zip Code: **72199**Country: **US**State: **AR**Zip Code: **72199**Country: **US**

FFL:

Contact / Condition

Problems

Estimate

History / Status

Shipping / Billing

Contact Information

Phone:

Fax:

Email:

Comments:

Received Condition

Poor

Condition
Notes:CSR
Notes:

Accessories Received

Code	Desc	Qty
A007	With Stud	1
A017	Scope Base	1
X	FRT & REAR SGT BA	1

Repair Search

Refresh

Close

neglej

1/10/2003

9:36 AM

CAPS

NUM

INS

SCRL

start

2 Macros...

3 Macros...

Arms Servi...

My Docu...

My Exe...

2 SAP L...

9:36 AM

Serial Number: **C6649214**Model: **700****RE00059328**

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

SERIAL # C 60649214 INSPECTED BY: RTL

DATE REC'D: 1-10-03 DATE RET'D: 1-30-03

ITEM

BARREL ASSEMBLY

☒ BARREL
☒ RECEIVER
☒ FRONT SIGHT BASE
☒ REAR SIGHT BASE
☒ SCREWS
☒ FINISH

SCOPE ASSEMBLY

☐ SCOPE
☐ SCOPE RINGS
☐ MOUNTING SCREWS
☐ MOUNTING BASE
☐ SCREWS
☐ FINISH
☐ CLARITY

ITEM

STOCK ASSEMBLY

☒ STOCK
☒ SLING AWIVEL STUDS
☒ ADJUSTABLE
☒ BUTT PLATE
☒ LOCK NUTS
☒ BARREL CLEARANCE
☒ COLOR / FINISH

SYSTEMS CASE

☐ SCOPE CASE
☐ IRON SIGHTS
☐ DEPLOYMENT KIT

TRIGGER ASSEMBLY

☒ SAFETY OPERATION
☒ RE-SET TO FACTORY SPECS

COMMENTS:

INITIAL & CYCLE TESTS
 2.50# ± .50#
 3.00# ± .75#
 4.00# ± 1.00#

DATE 1-13-03

TESTER TRW

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.44	2.40		2.17	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT ABLE LESS THAN
PULL #2	2.45	2.22		2.19	
PULL #3	2.50	2.20		2.18	
PULL #4	2.46	2.19		2.16	
PULL #5	2.45	2.20		2.17	
TOTAL	12.30	11.21		10.87	
AVG.	2.46	2.24		2.17	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.13	3.17		
PULL #2	3.09	3.09		
PULL #3	3.08	3.04		
PULL #4	3.02	3.05		
PULL #5	3.04	3.08		
TOTAL	15.36	15.43		
AVG.	3.07	3.08		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# & TARGET & ACCU
PULL #1	4.12	4.44		4.12
PULL #2	4.30	4.28		4.08
PULL #3	4.38	4.29		4.10
PULL #4	4.36	4.30		4.16
PULL #5	4.34	4.28		4.17
TOTAL	21.50	21.59		20.63
AVG.	4.30	4.31		4.12

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6649214.___0
FILE DATE AND TIME: 01/29/2003 15:08

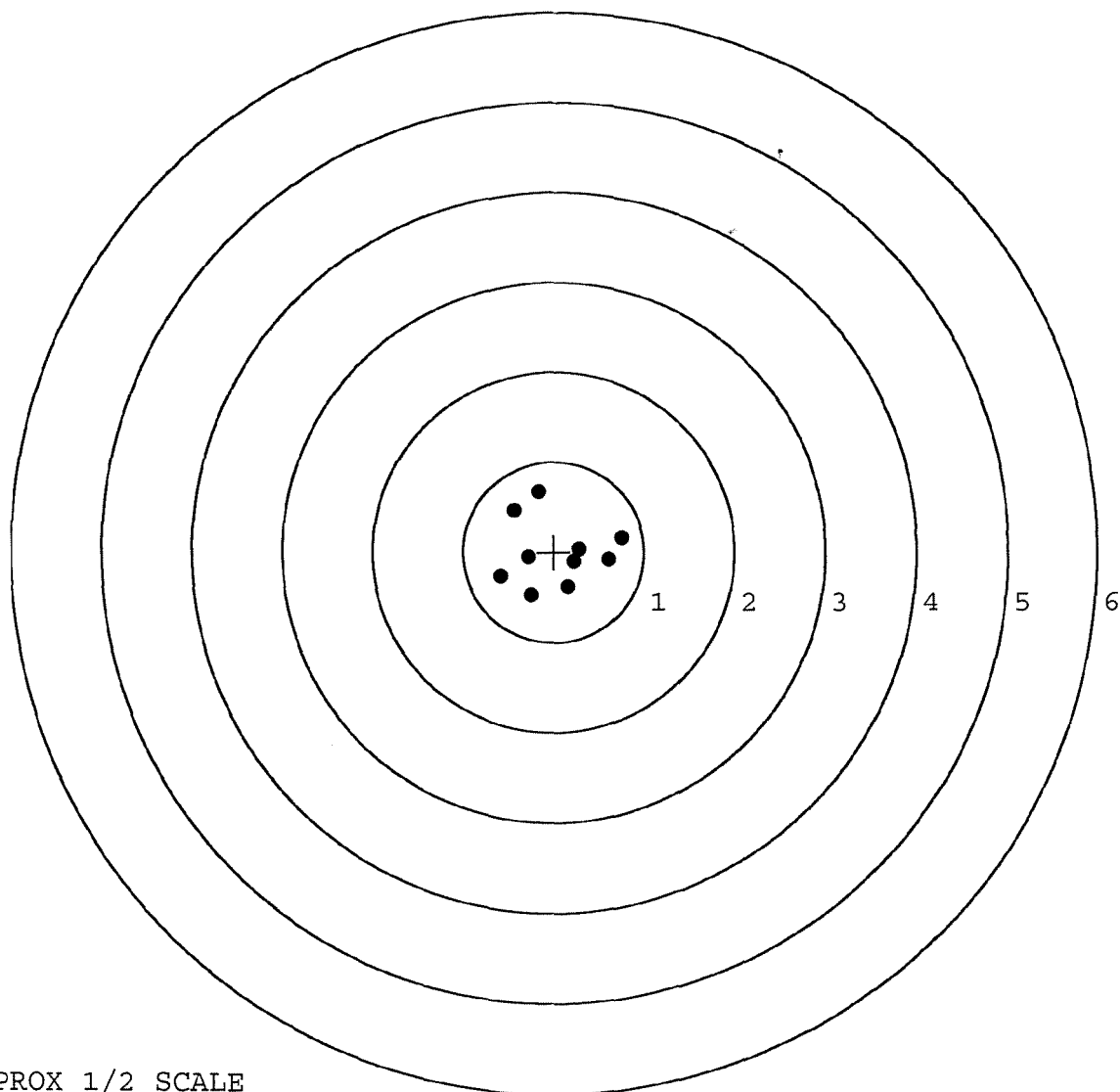
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.070
The Average Y Centroid of the Five Target Set:	-0.052
The Average Point of Impact of the Five Target Set:	0.087
The Average Mean Radius of the Five Target Set:	0.611
The Distance from POA to Centroid Target #1:	0.032
The Distance from Centroid Target #2 to Centroid Target #1:	0.127
The Distance from Centroid Target #3 to Centroid Target #1:	0.225
The Distance from Centroid Target #4 to Centroid Target #1:	0.182
The Distance from Centroid Target #5 to Centroid Target #1:	0.162

SERIAL NUMBER: C6649214. __0
TARGET NUMBER: 1
FILE DATE: 01/29/2003
FILE TIME: 15:08

X CENTROID: 0.030
Y CENTROID: -0.010
POA TO CENTROID: 0.032
HORZ SPREAD: 1.344
VERT SPREAD: 1.144
GROUP SPREAD: 1.411
MIN RADIUS: 0.218
MAX RADIUS: 0.746
MEAN RADIUS: 0.511
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 10
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.757	0.158
2:	0.613	-0.092
3:	0.282	0.027
4:	0.225	-0.107
5:	0.156	-0.387
6:	-0.248	-0.481
7:	-0.286	-0.066
8:	-0.167	0.663
9:	-0.445	0.456
10:	-0.587	-0.271

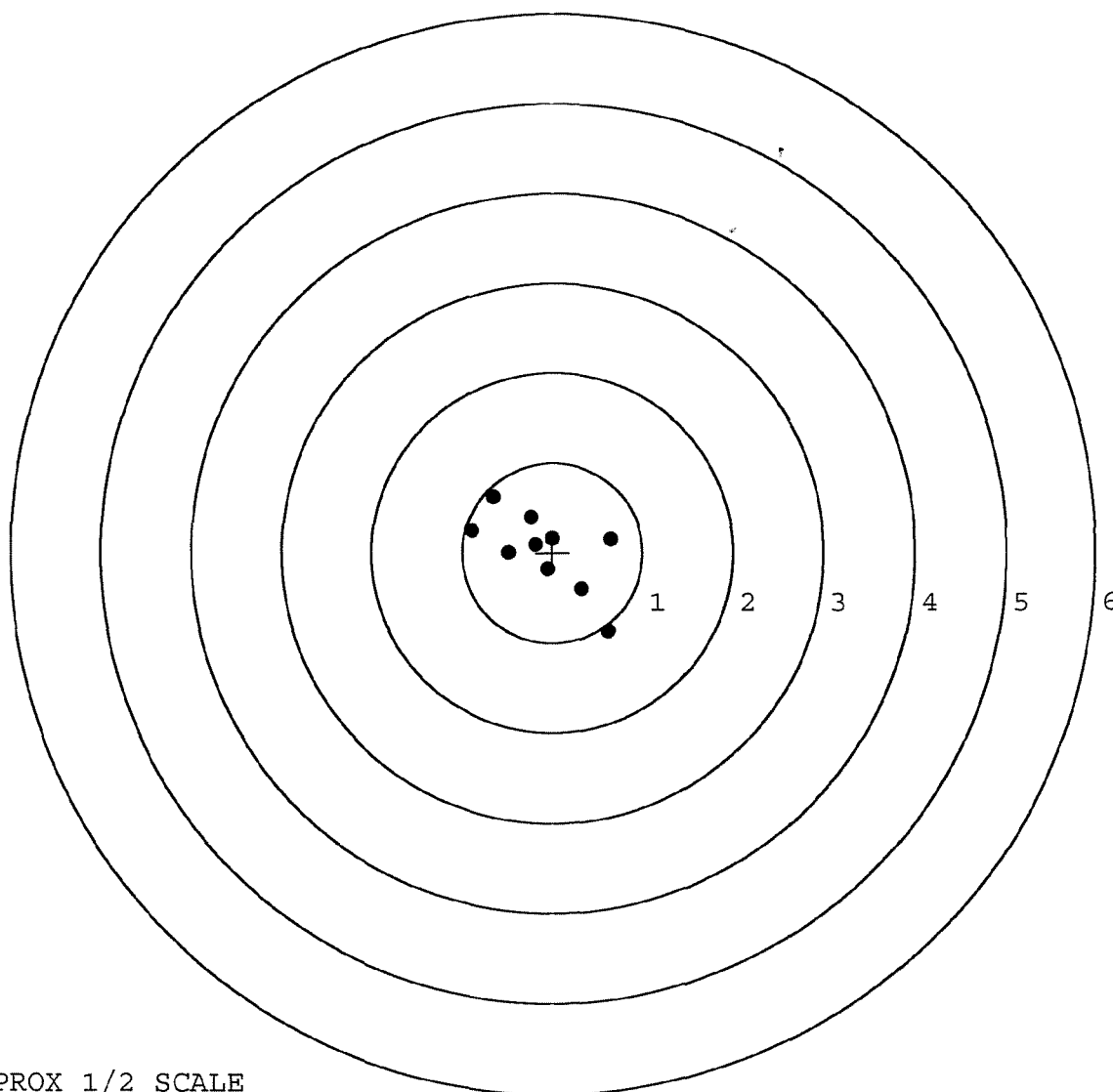


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6649214. __0
TARGET NUMBER: 2
FILE DATE: 01/29/2003
FILE TIME: 15:08

X CENTROID: -0.093
Y CENTROID: 0.020
POA TO CENTROID: 0.095
HORZ SPREAD: 1.544
VERT SPREAD: 1.500
GROUP SPREAD: 1.973
MIN RADIUS: 0.118
MAX RADIUS: 1.146
MEAN RADIUS: 0.545
IN 1 IN DIAMETER: 5
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.623	-0.875
2:	0.652	0.149
3:	0.322	-0.405
4:	-0.658	0.625
5:	-0.892	0.252
6:	-0.488	-0.004
7:	-0.245	0.395
8:	-0.006	0.159
9:	-0.055	-0.189
10:	-0.187	0.092



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6649214. 0

TARGET NUMBER: 3

FILE DATE: 01/29/2003

FILE TIME: 15:08

X CENTROID: -0.190

Y CENTROID: 0.035

POA TO CENTROID: 0.193

HORZ SPREAD: 1.606

VERT SPREAD: 2.484

GROUP SPREAD: 2.782

MIN RADIUS: 0.338

MAX RADIUS: 1.548

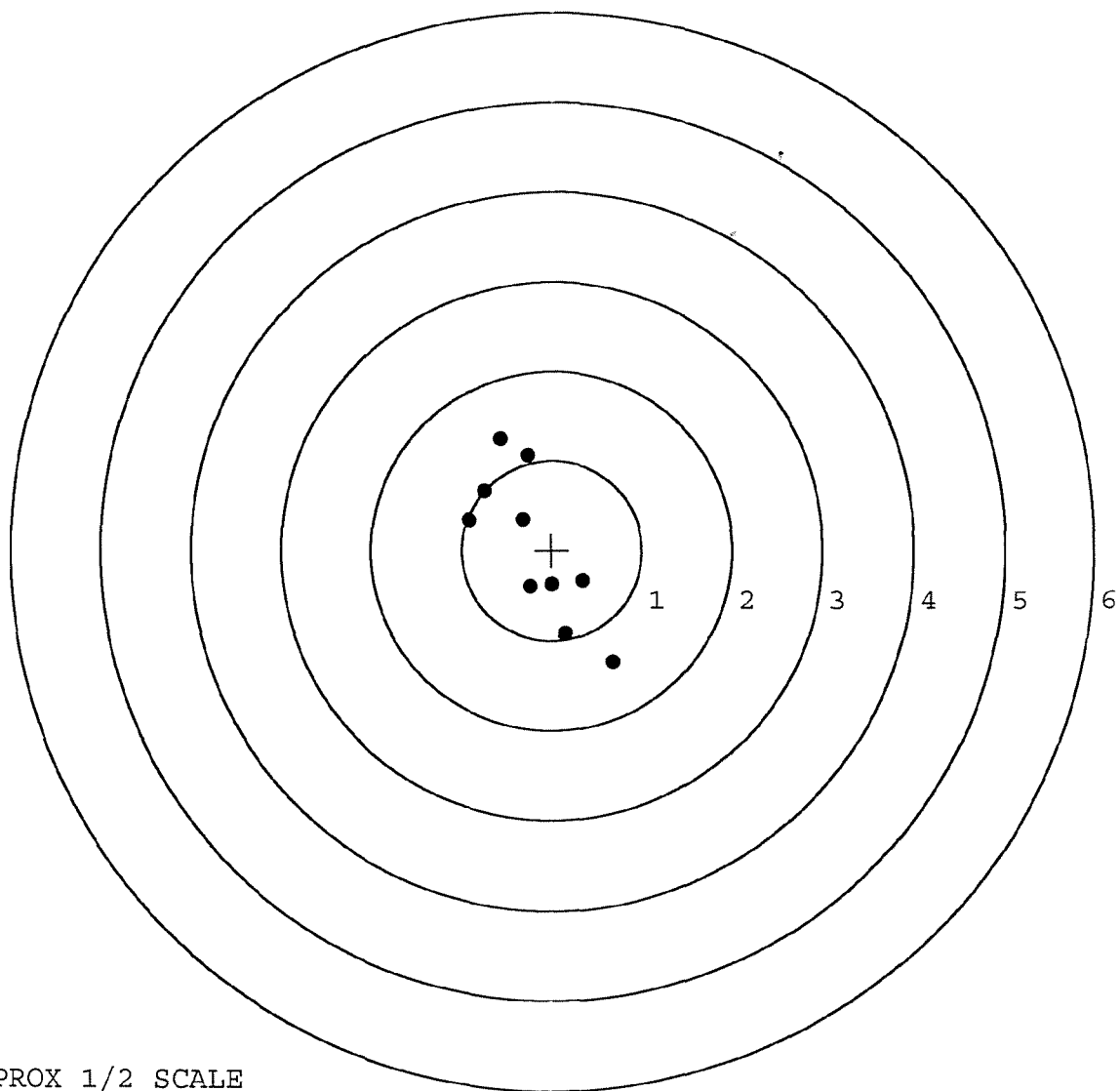
MEAN RADIUS: 0.838

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 9

POINT#	X	Y
1:	0.685	-1.242
2:	0.152	-0.928
3:	0.343	-0.337
4:	-0.001	-0.383
5:	-0.244	-0.402
6:	-0.328	0.343
7:	-0.752	0.663
8:	-0.921	0.334
9:	-0.267	1.055
10:	-0.568	1.242

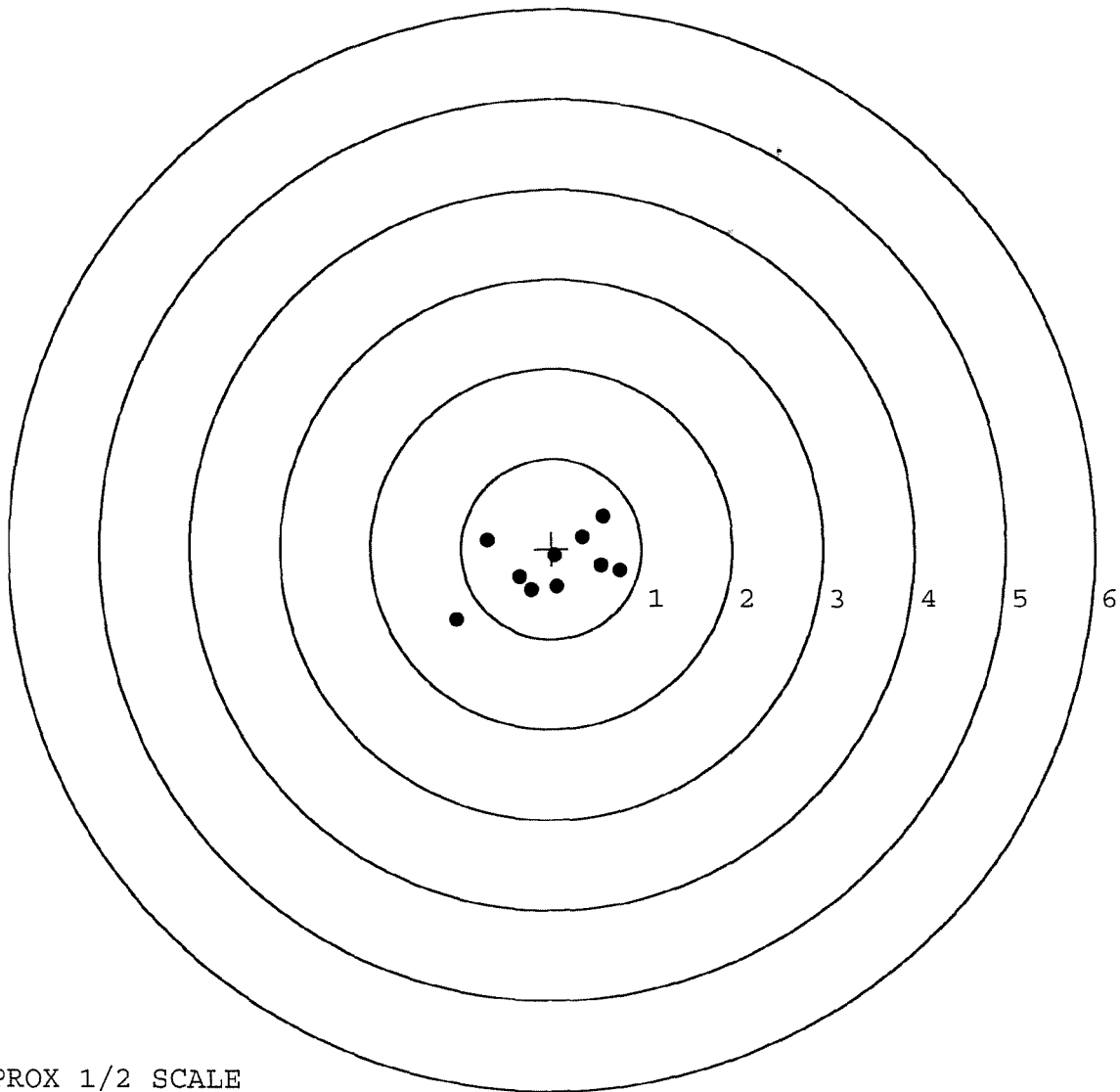


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6649214. 0
TARGET NUMBER: 4
FILE DATE: 01/29/2003
FILE TIME: 15:08

X CENTROID: -0.002
Y CENTROID: -0.189
POA TO CENTROID: 0.189
HORZ SPREAD: 1.802
VERT SPREAD: 1.160
GROUP SPREAD: 1.990
MIN RADIUS: 0.118
MAX RADIUS: 1.208
MEAN RADIUS: 0.563
IN 1 IN DIAMETER: 5
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.755	-0.242
2:	0.548	-0.182
3:	0.570	0.365
4:	0.038	-0.078
5:	0.060	-0.425
6:	-0.222	-0.456
7:	-0.358	-0.311
8:	-0.708	0.098
9:	-1.047	-0.795
10:	0.341	0.137



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6649214. __0

TARGET NUMBER: 5

FILE DATE: 01/29/2003

FILE TIME: 15:08

POINT#	X	Y
1:	0.443	-0.729
2:	0.734	-0.215
3:	0.479	0.063
4:	-0.006	-0.271
5:	-0.357	-0.626
6:	-0.145	0.230
7:	-0.322	0.321
8:	-0.224	0.566
9:	-0.621	0.023
10:	-0.925	-0.499

X CENTROID: -0.094

Y CENTROID: -0.114

POA TO CENTROID: 0.148

HORZ SPREAD: 1.659

VERT SPREAD: 1.295

GROUP SPREAD: 1.683

MIN RADIUS: 0.180

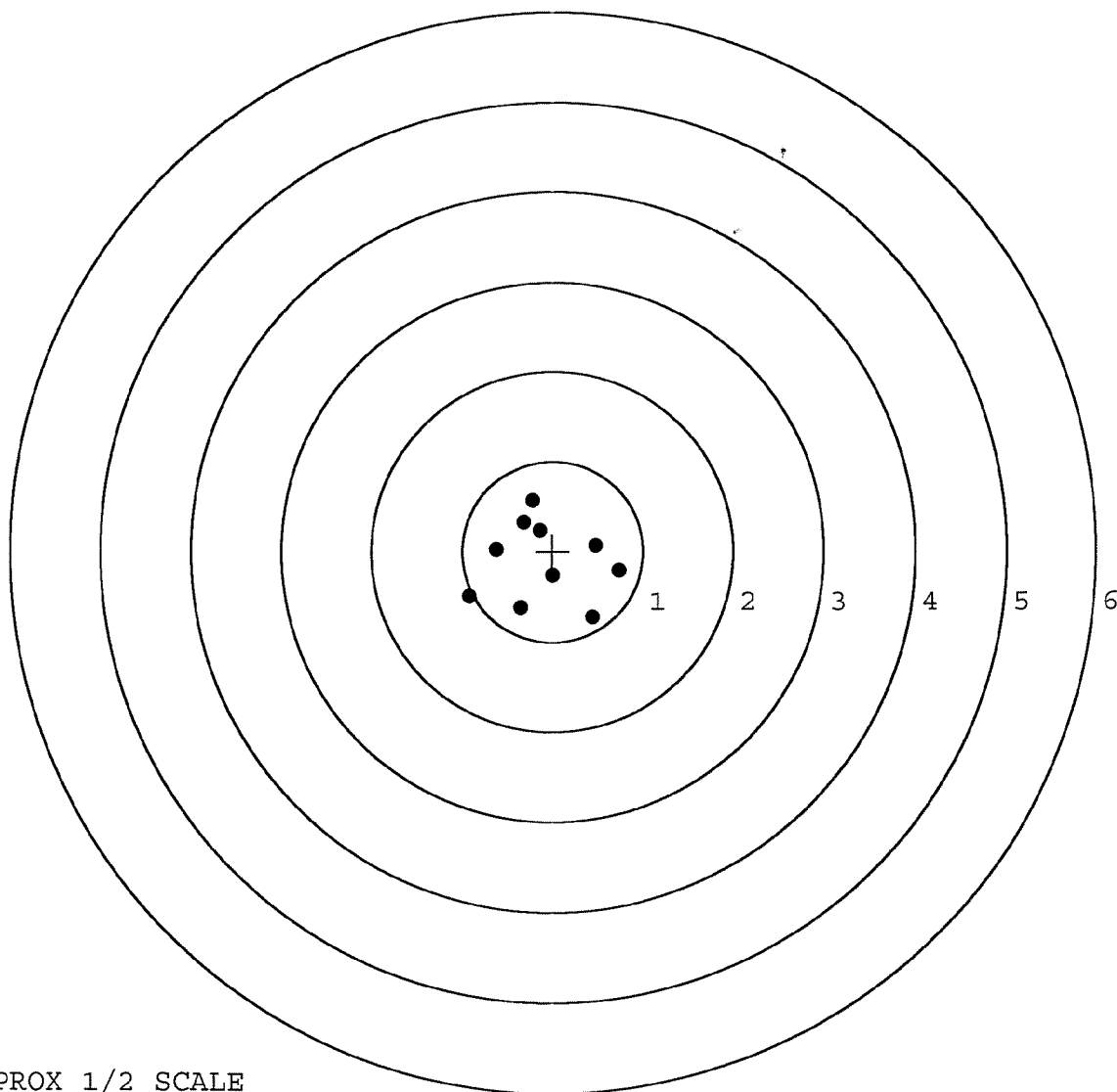
MAX RADIUS: 0.916

MEAN RADIUS: 0.600

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

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

R & E NUMBER	00059 328		
SERIAL NUMBER	C-6649214		
LOG-IN DATE	1-10-03		
INSPECT AND VERIFY:			
OPERATION #	OPERATION NAME	DATE	INITIAL
550	DIS-ASSEMBLE GUN	1-14-03	RW
560 A	RE-BARREL	1-14-03	RA
B	DRILL AND TAP	1-20-03	TRLW
575	ASSEMBLE	1-15-03	RL
600	PROOF	1-16-03	RW
605	CHECK HEADSPACE	1-16-03	RW
610	DIS-ASSEMBLE GUN	1-16-03	RW
612	MAGNAFLUX		
615	ROLLMARK CALIBER		
618	ROTO-BLAST	1-21-03	JH
620	APPLY COATINGS	1-22	IA
625 A	FINAL ASSEMBLY	1/23/03	RW
B	TRIGGER PULL TEST	1-29-03	RL
C	SAFETY "ON" FORCE	1-29-03	RL
D	SAFETY "OFF" FORCE	1-29-03	RL
E	FIRING PIN INDENT	1-29-03	RL
640	TARGET	1-28-03	TRLW
655	FINAL INSPECT	1-30-03	RTL
660	PACK	1-30-03	RA
		SHIP DATE	
	QAR INSPECTION DATE		

