

G6577140

Replaced

C. 622 5375

00299

5091



C6725375

MOD. _____ GA. CAL. _____ GUN # _____

# TEST	DATE	MALFUNCTION/DEFECT	ASSEM. #
WB	1st	OE	
	2nd	Clean Ejector Aie tested ok 10/12/88	RW
	3rd		
	4th		
		FUNCTION	

RD 6654

Rev 1



TEST INIT. ACTION TO CORRECT		ASSEM. #
PROOF		
TEST		
TGT		
PROOF		
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6225375

OPERATION		DATE	INT
#	NAME		
575-580	ASSEMBLY	1/22	FB
600	PROOF	1/28/88	RL
615	MAGNAFLUX BARREL	2/18/88	P/C
	MAGNAFLUX BOLT	3/13/88	P/C
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 #

C6225375

SCOPE # 1199

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		8/30/88	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/30/88	RW
	C) Inspect Ejector Hole for Chamfer		8/30/88	RW

OVER

C-622,5375						
OP.#		READINGS			DATE	INITIAL
625 cont.	D) Oil Firing Pin Ass'y				8/30/88	RW
	E) Adjust Trigger Pull to Min. Setting and Stake				30 Aug 88	J.U. + R.S.
	F) Safety on Force	8	8	8	30 Aug 88	J.U. + R.S.
	G) Safety off Force	3	3	3	30 Aug 88	J.U. + R.S.
	H) Trigger Pull Test & Retainability				30 Aug 88	J.U. + R.S.
	I) Firing Pin Indent	.022	.022	.022	30 Aug 88	J.U. + R.S.
	J) Assemble Stock				9/26/88	RW
	K) Assemble Swivel Studs				10-12-88	R.S.
	L) Attach Front & Rear Sight Assemblies				9/26/88	RW
	M) Iron Sight Alignment				9/26/88	RW
	N) Detach Front & Rear Sights & place in numbered container				9/26/88	RW
	O) Attach Scope to Rifle				10/3/88	RW
	P) Detach & Attach Scope 20 times				10/4/88	J.S.
640	Gallery Target & Test	61 R	94 L		10/7/88	W.B.
	A) Optical Clarity of Scope				10/7/88	W.B.
645	Inspect for Live Ammo				10/7/88	W.B.
655	Final Inspection					
	A) Headspace				10-12-88	R.S.
	B) Trigger Pull				10-12-88	R.S.
	C) Function				10-12-88	R.S.
660	Pack	OK			10/20/88	W.B.

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6225375

DATE 29 Aug 88

TESTER J. G. + J. S.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.53	2.56	2.53	2.73	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.47	2.55	2.57	2.60	
PULL #3	2.56	2.54	2.54	2.57	
PULL #4	2.53	2.54	2.51	2.51	
PULL #5	2.55	2.54	2.53	2.60	
TOTAL	12.64	12.73	12.68	13.01	
AVG.	2.528	2.546	2.536	2.602	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.15	3.10		
PULL #2	3.22	3.07		
PULL #3	3.21	3.09		
PULL #4	3.21	3.08		
PULL #5	3.23	3.01		
TOTAL	16.02	15.35		
AVG.	3.204	3.07		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.09	4.06		4.11
PULL #2	4.02	4.07		4.11
PULL #3	4.07	4.05		4.15
PULL #4	4.11	4.11		4.15
PULL #5	3.95	4.15		3.99
TOTAL	20.22	20.44		20.51
AVG.	4.044	4.088		4.102

7 Oct 1988

FILE:/PATTERNING/CENTERFIRE_PATT/06225375

CENTERFIRE PATTERNS # 1

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 8

HS= 3.765

VS= 2.359

GS= 4.332

PATTERN #

:

1

SHOTS (BEST OF)

:

10

9

8

MAXIMUM X

:

2.056

1.532

1.347

MINIMUM X

:

-1.709

-1.481

-1.758

MAXIMUM Y

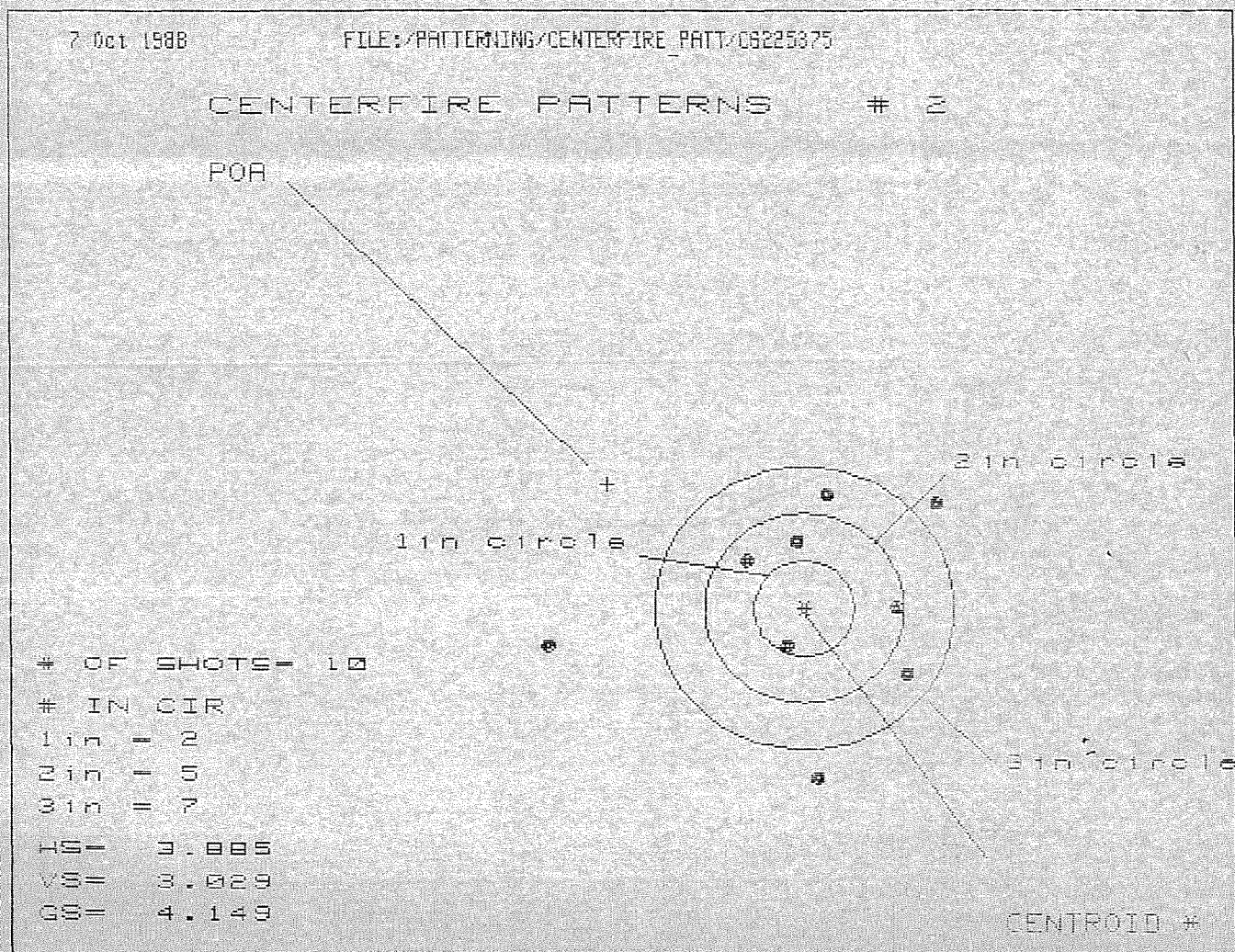
:

1.000

1.100

1.100

MINIMUM Y	:	-1.066	-1.161	-1.011
CENTROID X	:	.405	.177	.362
CENTROID Y	:	-1.187	-1.092	-1.242
POA TO CENTROID in.	:	1.254	1.107	1.294
MIN RADIUS	:	.242	.125	.198
MEAN RADIUS	:	1.121	.979	.850
MAX RADIUS	:	2.224	1.905	1.362
HORIZONTAL SPREAD	:	3.765	3.013	2.105
VERTICAL SPREAD	:	2.359	2.359	2.148
EXTREME SPREAD	:	4.332	3.388	2.434
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	



PATTERN # : 2

SHOTS (BEST OF) : 10 9 8

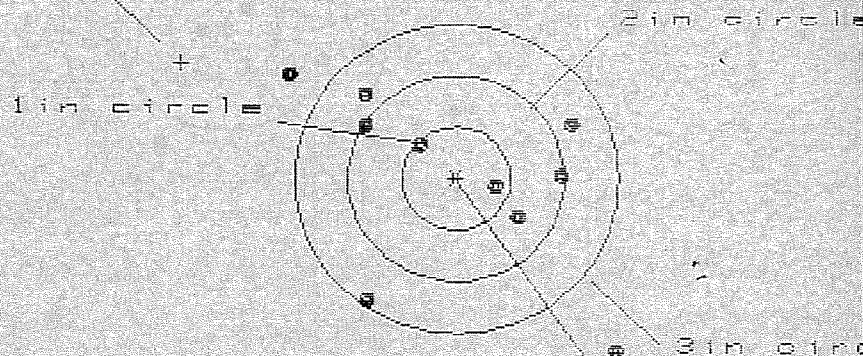
MAXIMUM X	:	1.308	1.021	1.006
MINIMUM X	:	-2.577	-1.883	-1.898
MAXIMUM Y	:	1.248	1.204	.975
MINIMUM Y	:	-1.781	-1.825	-.968
CENTROID X	:	1.975	2.262	2.277
CENTROID Y	:	-1.308	-1.264	-1.035
POA TO CENTROID in.:	:	2.369	2.591	2.501
MIN RADIUS	:	.405	.626	.622
MEAN RADIUS	:	1.191	1.026	.914
MAX RADIUS	:	2.608	1.829	1.278
HORIZONTAL SPREAD	:	3.885	1.904	1.904
VERTICAL SPREAD	:	3.029	3.029	1.943
EXTREME SPREAD	:	4.149	3.062	2.091
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		7	

7 Oct 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C6225375

CENTERFIRE PATTERNS # 3

POA



OF SHOTS= 10

IN CIR

1in = 2

2in = 4

3in = 8

HS= 3.028

VS= 2.626

GS= 4.008

CENTROID

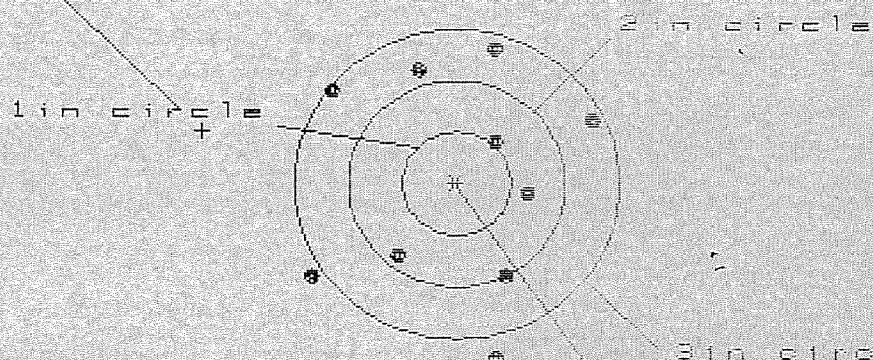
PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.491	1.204	1.033
MINIMUM X	-1.537	-1.371	-0.864
MAXIMUM Y	.984	.802	.783
MINIMUM Y	-1.642	-1.359	-1.259
CENTROID X	2.538	2.372	2.543
CENTROID Y	-1.127	-.945	-1.045
POA TO CENTROID in.	2.777	2.553	2.750
MIN RADIUS	.372	.238	.401
MEAN RADIUS	1.139	1.001	.914
MAX RADIUS	2.218	1.588	1.500
HORIZONTAL SPREAD	3.028	2.575	1.897
VERTICAL SPREAD	2.626	2.161	2.042
EXTREME SPREAD	4.008	2.679	2.528
NUMBER IN ONE INCH CIRCLE	=	2	
NUMBER IN TWO INCH CIRCLE	=	4	
NUMBER IN THREE INCH CIRCLE	=	8	

7 Oct 1988

FILE:/PATTERNING/CENTERFIRE_PATT/CS225325

CENTERFIRE PATTERNS # 4

POA



OF SHOTS - 10

IN CIR

1 in = 2

2 in = 4

3 in = 8

HS = 2.636

VS = 3.046

GS = 3.056

CENTROID *

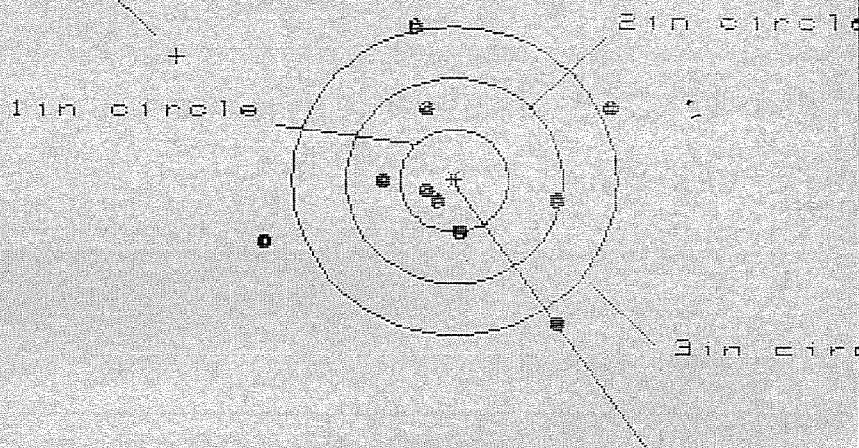
PATTERN #	:	4	157
SHOTS (BEST OF)	:	10	9
MAXIMUM X	:	1.250	1.285
MINIMUM X	:	-1.386	-1.351
MAXIMUM Y	:	1.311	1.118
MINIMUM Y	:	-1.735	-1.126
CENTROID X	:	2.347	2.312
CENTROID Y	:	-.509	-.316
POA TO CENTROID in.	:	2.402	2.334
MIN RADIUS	:	.514	.422
MEAN RADIUS	:	1.182	1.102
MAX RADIUS	:	1.763	1.759
HORIZONTAL SPREAD	:	2.636	2.636
VERTICAL SPREAD	:	3.046	2.244
EXTREME SPREAD	:	3.056	3.050
NUMBER IN ONE INCH CIRCLE	=	0	0
NUMBER IN TWO INCH CIRCLE	=	4	4
NUMBER IN THREE INCH CIRCLE	=	8	8

7 Oct 1988

FILE:/PATTERNING/CENTERFIRE_PATT/08225375

CENTERFIRE PATTERNS # 5

POA



OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 8

HS- 3.193

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.465	1.273	1.367
MINIMUM X	:	-1.728	-.809	-.715
MAXIMUM Y	:	1.529	1.464	1.285
MINIMUM Y	:	-1.362	-1.427	-.774
CENTROID X	:	2.557	2.749	2.635
CENTROID Y	:	-1.207	-1.142	-.963
POA TO CENTROID in.	:	2.828	2.977	2.824
MIN RADIUS	:	.253	.455	.461
MEAN RADIUS	:	1.016	.958	.868
MAX RADIUS	:	1.825	1.614	1.453
HORIZONTAL SPREAD	:	3.193	2.082	2.082
VERTICAL SPREAD	:	2.891	2.891	2.059
EXTREME SPREAD	:	3.455	3.189	2.243
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		6	

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # .06225375

CENTROIDAL DISTANCES

0 TO	1	1.25419
1 TO	2	1.57466
1 TO	3	2.13384
1 TO	4	2.05695
1 TO	5	2.15209

+ (----POA
4
1 2 3

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: 1.9644
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -1.0676
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: 2.23576
THE AMR FOR THIS RIFLE IS: 1.13

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6225375

OP. #	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and Stock		2/12/92	RW
600	Proof		2/12/92	RW
607	Check Headspace		2/12/92	RW
610	Dis-assemble Gun		2/12/92	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		2/25/92	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		2/25/92	RW
	C) Inspect Ejector Hole for Chamfer		2/25/92	RW
	D) Oil Firing Pin Ass'y		2/25/92	RW
	E) Adjust Trigger Pull to Min Setting and Stake			

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			2/26/92	RW
	G) Safety Off Force	3	3	3			2/26/92	RW
	H) Trigger Pull Test & Retainability							
	I) Firing Pin Indent	.020	.020	.020			2/26/92	RW
	J) Assemble Stock						2/25/92	RW
	K) Assemble Swivel Studs							
	L) Attach Front and Rear Sight Assemblies						2/25/92	RW
	M) Iron Sight Alignment						2/25/92	RW
	N) Detach Front & Rear Sights & place in numbered container							
	O) Attach Scope to Rifle							
	P) Detach & Attach Scope 20 Times							
640	Gallery Target & Test						2-26-92	DH
	A) Time						2-26-92	DH
	B) Malfunctions						2-26-92	DH
	C) Pierced Primers						2-26-92	DH
	D) Optical Clarity of Scope						2-26-92	DH
645	Inspect for Live Ammo						2-26-92	DH
655	Final Inspection							
	A) Headspace						2/26/92	RW
	B) Trigger Pull	2.47	2.59	2.65	2.64	2.65	2/26/92	RW
	C) Function						2/26/92	RW
660	Pack							

RECEIVING AND ESTIMATING REPORT

COMMENTS

ORDER
R 92-03441

INITIAL CUSTOMER ORDER NO.

JJM 67786

M24

DATE RECEIVED

DATE OPENED

DATE CODE

SERIAL NUMBER

NEW SERIAL NUMBER

MODEL AND GRADE

01/28/92

01/28/92

KI 5-88

C6225375

700

7.62

NATO

ACCESSORIES

W/STUDS

SCOPE BASE

FROM:

SHIP TO:

CO D 2ND BN 1ST SPWAR TNG GP
C/O CPT M K STEPHENSON
FT BRAGG NC 28307CO D 2ND BN 1ST SPWAR TNG GP
C/O CPT M K STEPHENSON
FT BRAGG NC
28307

CUST NO: 046771 C/D.D.

ACCOUNT NUMBER

ACCOUNT NUMBER N/C

WRITE ☐

CLEAN/TEST

FROM DATE

ESTIMATED

VIA

DOOR

GUN CONDITION

☐ NEW☐ LIGHTLY WORN☐ WORN☐ VERY WORN☐ UNREPAIRABLE

REPAIR CHARGE

EXCISE

TAX

INSURANCE

UPS

PARCEL POST

TOTAL

CUSTOMER CONCERN

AMMO

FUNCTION

FINISH

ACCURACY

FIT

INSPECT

CYCLE

A1

B1

TRIGGER GROUP

B2

BOLT ASSY.

B3

BARREL ASSY.

B4

D1

E3

F3

REC. ASSY.

B5

D2

E4

F4

WOOD

C1

D3

E5

F5

METAL

C2

MAIN FAULT

• New BARREL

• New STOCK

PARTS

COMMENTS

REPAIRMAN

PROOF

CLEAN

TEST

TARGET

PATTERN

GALLERY TESTER

DATE

DATE

DATE

DATE

DATE

OFFICE COPY

RD6925 REV. 8/91

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

M240085954

(PLEASE PRINT CLEARLY)

RETURN:

- ☐ Clark Street Entrance
☒ Via US Mail or UPS

FIREARMS DELIVERED TO PLANT

FILE NO 006778

DATE 1/27/92

OWNER'S NAME: EPT STEPHENSON

OWNER'S ADDRESS: Co D 2nd Bn 1st SF

FT Bragg NC

ZIP:

PHONE: 919 396 7330

FIREARM

MODEL: M-24

CHECK FOR AMMUNITION ☒

GAUGE: 308 Cal

SERIAL # C6225375

CONDITION:

WOOD

GOOD

FAIR

POOR

FANCY

PLAIN

METAL

GOOD

FAIR

POOR

FANCY

PLAIN

BARREL

VT. RIB

PLAIN

DEER RSS

ACCESSORIES:

SCOPE: YES

NO

(BRAND NAME/POWER)

SLING: YES

NO

GUN CASE: YES

NO

(HARD - SOFT)

EXTRA BBL FOR GUN MENTIONED ABOVE:

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

CUSTOMER REQUEST: Replace Barrel

SIGNATURE: David E. [Signature]

(Person delivering firearm to Plant)

DATE: 27 JAN 92

SIGNATURE: [Signature]

(Security Officer)

DATE: 1/27/92

SIGNATURE: [Signature]

(Firearm picked up by)

DATE: 1-28-92

Arm Service Copy

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06225375
26 Feb 1992

CENTROIDAL DISTANCES

0 TO	1	.290338
1 TO	2	.642966
1 TO	3	.602466
1 TO	4	.228423
1 TO	5	.131381

PT² (---)FOR

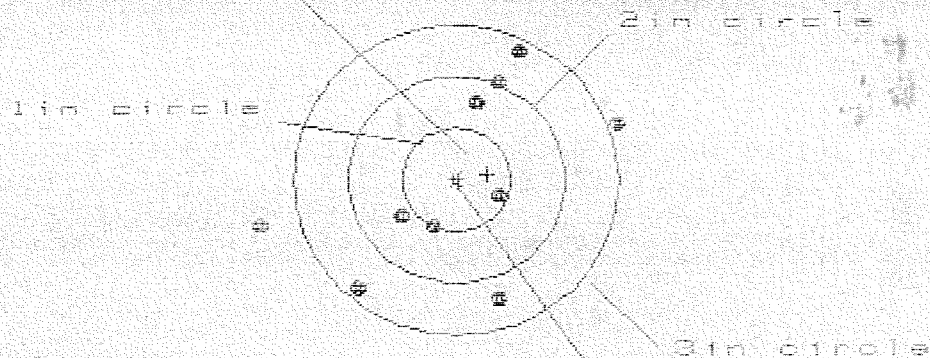
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0266
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .113
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .116089
THE AMR FOR THIS RIFLE IS: 1.18

26 Feb 1992

FILE:/PATTERNING/CENTERFIRE_PATT/08225375

CENTERFIRE PATTERNS # 1

FOR



OF SHOTS= 10

IN CIR

1in = 2

2in = 4

3in = 8

HS= 3.257

VS= 2.398

GS= 3.415

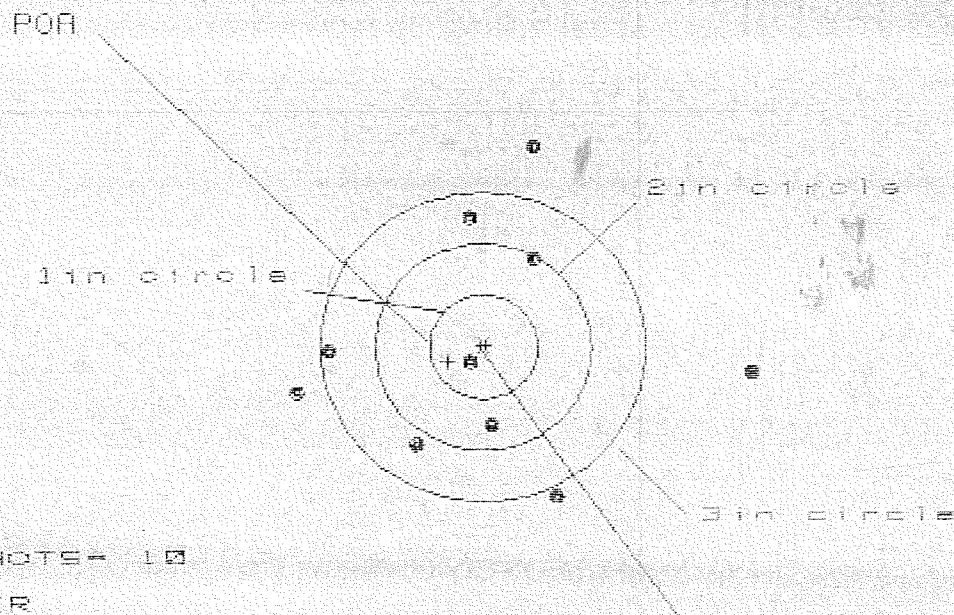
CENTROID *

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.457	1.257	.586
MINIMUM X	:	-1.800	-1.141	-.984
MAXIMUM Y	:	1.272	1.222	1.288
MINIMUM Y	:	-1.117	-1.168	-1.102
CENTROID X	:	-.286	-.086	-.243
CENTROID Y	:	-.050	-.000	-.066
FOR TO CENTROID in.	:	.290	.086	.261
MIN RADIUS	:	.413	.279	.367
MEAN RADIUS	:	1.068	.967	.984
MAX RADIUS	:	1.856	1.602	1.445
HORIZONTAL SPREAD	:	3.257	2.398	1.570
VERTICAL SPREAD	:	2.398	2.398	2.398
EXTREME SPREAD	:	3.415	2.910	2.823
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	

26 Feb 1992

FILE: PATTERNING/CENTERFIRE_PATT/C8225375

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1in = 1

2in = 3

3in = 6

HS= 4.191

VS= 3.314

GS= 4.197

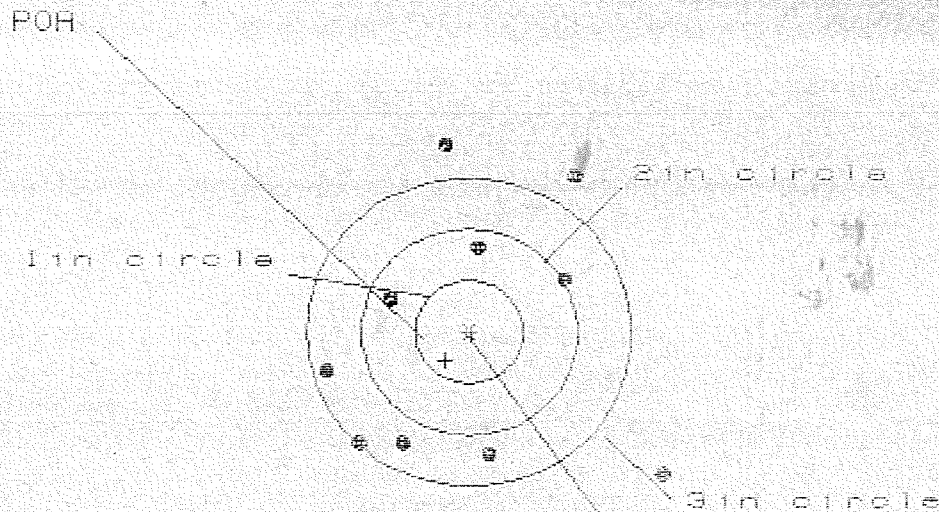
CENTROID #

PATTERN #	#	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.432	.922	1.009
MINIMUM X	:	-1.759	-1.489	-1.402
MAXIMUM Y	:	1.910	1.884	1.484
MINIMUM Y	:	-1.404	-1.430	-1.195
CENTROID X	:	.327	.057	-.030
CENTROID Y	:	.144	.170	-.065
POR TO CENTROID in.	:	.350	.179	.072
MIN RADIUS	:	.198	.229	.238
MEAN RADIUS	:	1.353	1.212	1.079
MAX RADIUS	:	2.443	2.009	1.584
HORIZONTAL SPREAD	:	4.191	2.411	2.411
VERTICAL SPREAD	:	3.314	3.314	2.679
EXTREME SPREAD	:	4.197	3.322	2.794
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		6	

26 Feb 1992

FILE:/PATTERNING/CENTERFIRE_PATT/C8225325

CENTERFIRE PATTERNS # 3



* OF SHOTS = 10

IN CIR

1in = 0

2in = 2

3in = 7

HS= 3.005

VS= 3.205

GS= 3.771

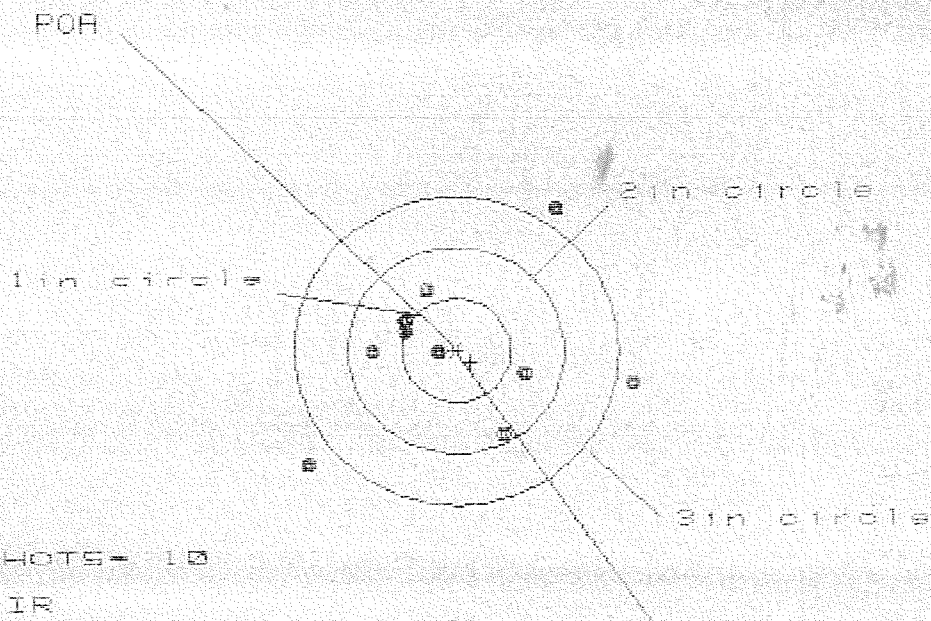
CENTROID *

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.765	1.209	1.205
MINIMUM X	:	-1.330	-1.133	-1.137
MAXIMUM Y	:	1.869	1.721	1.603
MINIMUM Y	:	-1.336	-1.321	-1.106
CENTROID X	:	.220	.023	.027
CENTROID Y	:	.277	.425	.210
POA TO CENTROID (in.)	:	.353	.426	.212
MIN RADIUS	:	.777	.580	.692
MEAN RADIUS	:	1.383	1.260	1.191
MAX RADIUS	:	2.214	1.840	2.005
HORIZONTAL SPREAD	:	3.095	2.342	2.340
VERTICAL SPREAD	:	3.205	3.042	2.789
EXTREME SPREAD	:	3.771	3.305	3.365
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		2	
NUMBER IN THREE INCH CIRCLE	=		7	

26 Feb 1992

FILE: \PATTERNING\CENTERFIRE_PATT\08225375

CENTERFIRE PATTERNS # 4



OF SHOTS = 10

IN CIR

1 in = 2

2 in = 7

3 in = 7

HS = 2.935

VS = 2.564

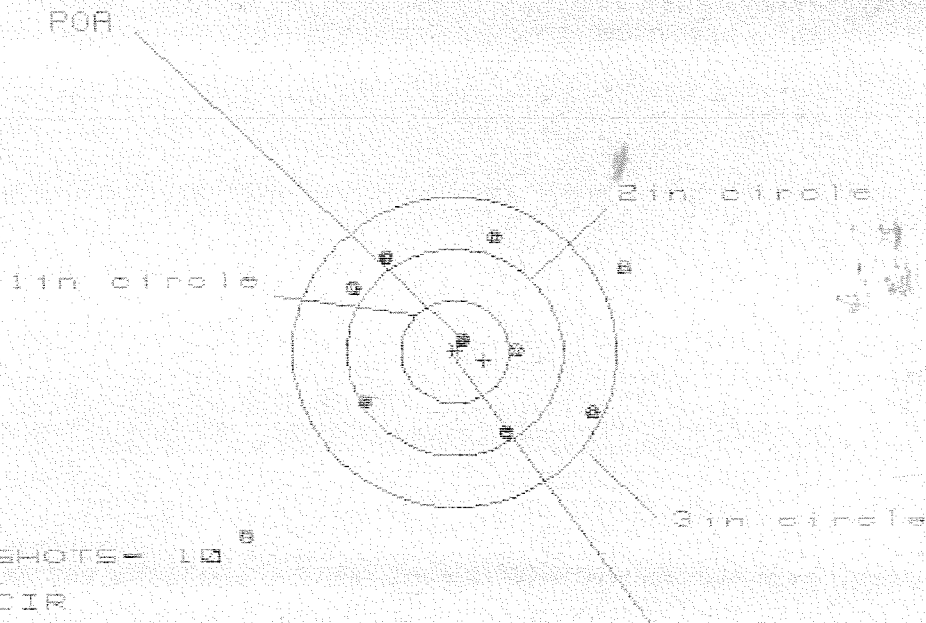
GS = 3.448

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.590	1.440	1.542
MINIMUM X	:	-1.345	-.937	-.835
MAXIMUM Y	:	1.432	1.367	.605
MINIMUM Y	:	-1.132	-.891	-.728
CENTROID X	:	-.127	.023	-.079
CENTROID Y	:	.114	.239	.076
FOR TO CENTROID in.	:	.170	.240	.109
MIN RADIUS	:	.189	.363	.239
MEAN RADIUS	:	.932	.865	.743
MAX RADIUS	:	1.758	1.538	1.559
HORIZONTAL SPREAD	:	2.935	2.377	2.377
VERTICAL SPREAD	:	2.564	2.198	1.383
EXTREME SPREAD	:	3.448	2.387	2.387
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		7	

26 Feb 1932

FILE: PATTERNING/CENTERFIRE_PATT/C8825375

CENTERFIRE PATTERNS # 5



HS = 3.473
VS = 2.894
GS = 4.323

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.577	1.366	1.180
MINIMUM X	:	-1.896	-1.119	-1.948
MAXIMUM Y	:	1.105	.906	.380
MINIMUM Y	:	-1.789	-.949	-.876
CENTROID X	:	-.267	-.056	-.227
CENTROID Y	:	.080	.279	.206
POA TO CENTROID in.	:	.278	.284	.306
MIN RADIUS	:	.082	.217	.050
MEAN RADIUS	:	1.166	.986	.900
MAX RADIUS	:	2.607	1.486	1.384
HORIZONTAL SPREAD	:	3.473	2.485	2.128
VERTICAL SPREAD	:	2.894	1.855	1.855
EXTREME SPREAD	:	4.323	2.718	2.450
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	

Remington Test Lab, Ilion, N.Y.

Centroidal distance calculations for Rifle # C6225375

4 Mar 1997

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1406

THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0604

THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .153025

THE AMR FOR THIS RIFLE IS: 1.021

CENTROIDAL DISTANCES

0 TO	1	.33333
1 TO	2	.406277
1 TO	3	.891338
1 TO	4	.565008
1 TO	5	.62119

5
4 2+ 1 <----POA

3

PATTERN #: 010

POA TO CENTROID: .334

MIN RADIUS : .490

MEAN RADIUS : .929

MAX RADIUS : 1.519

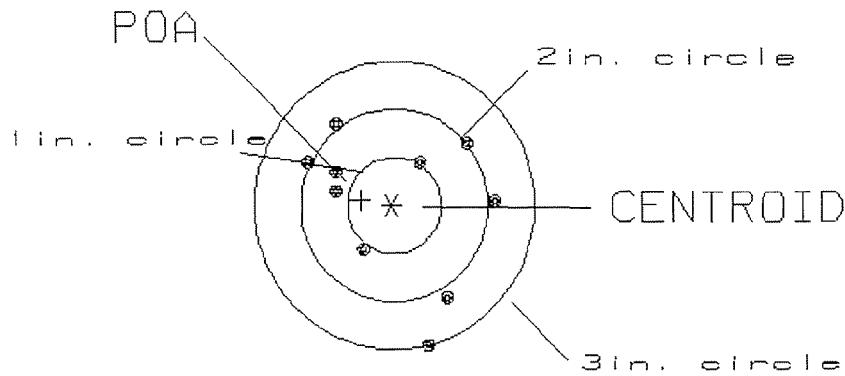
CENTROID X : .330

CENTROID Y : -.047

4 Mar 1997

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/C6225375

CENTERFIRE PATTERN # 1



OF SHOTS= 10

IN CIRCLE

HS= 2.06

1

VS= 2.33

4

GS= 2.56

9

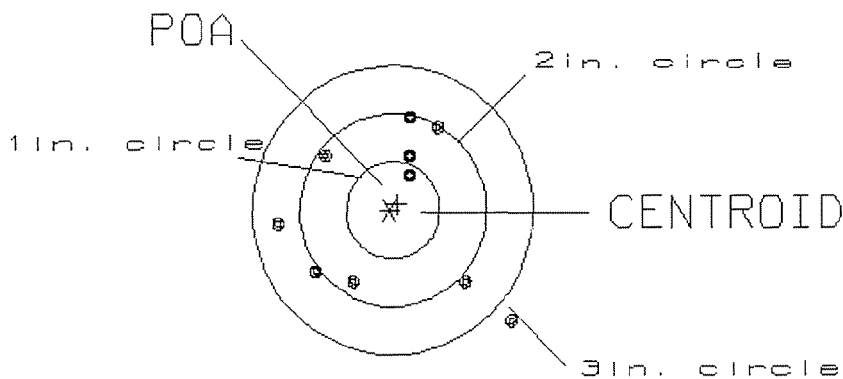
PATTERN #: 2

POA TO CENTROID: .098
 MIN RADIUS : .438
 MEAN RADIUS : .981
 MAX RADIUS : 1.726
 CENTROID X : -.076
 CENTROID Y : -.062

4 Mar 1997

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/C6225375

CENTERFIRE PATTERN # 2



OF SHOTS= 10

IN CIRCLE

HS= 2.51
 VS= 2.10
 GS= 2.71

1
 5
 9

REMINGTON CENTERFIRE ACCURACY TEST

REMINGTON TEST LAB, ILION, N.Y.

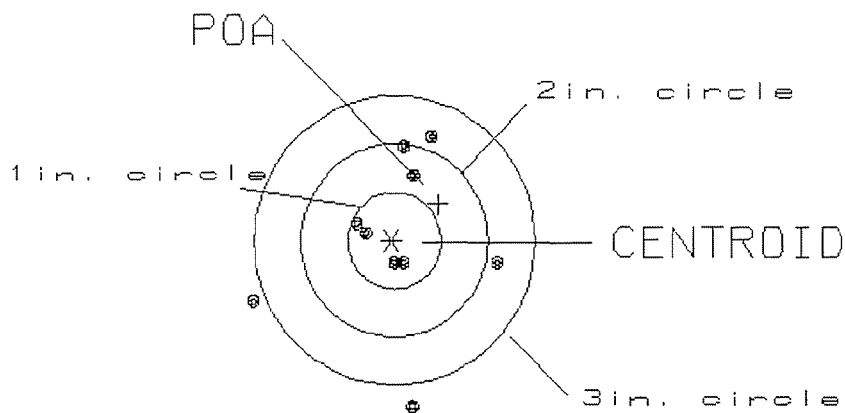
PATTERN #: 3

POA TO CENTROID: .624
 MIN RADIUS : .222
 MEAN RADIUS : .847
 MAX RADIUS : 1.707
 CENTROID X : -.498
 CENTROID Y : -.377

4 Mar 1997

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/C6225375

CENTERFIRE PATTERN # 3



OF SHOTS= 10

IN CIRCLE

HS= 2.64
 US= 2.74
 GS= 2.74

4
 6
 8

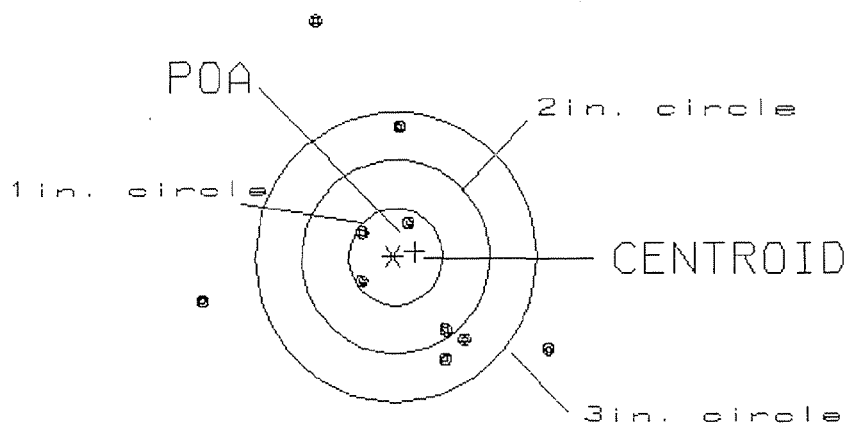
PATTERN #: 04

POA TO CENTROID: .240
 MIN RADIUS : .331
 MEAN RADIUS : 1.233
 MAX RADIUS : 2.553
 CENTROID X : -.235
 CENTROID Y : -.050

4 Mar 1997

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/C6225375

CENTERFIRE PATTERN # 4



OF SHOTS= 10

IN CIRCLE

HS= 3.69
 VS= 3.49
 GS= 4.17

3
 4
 7

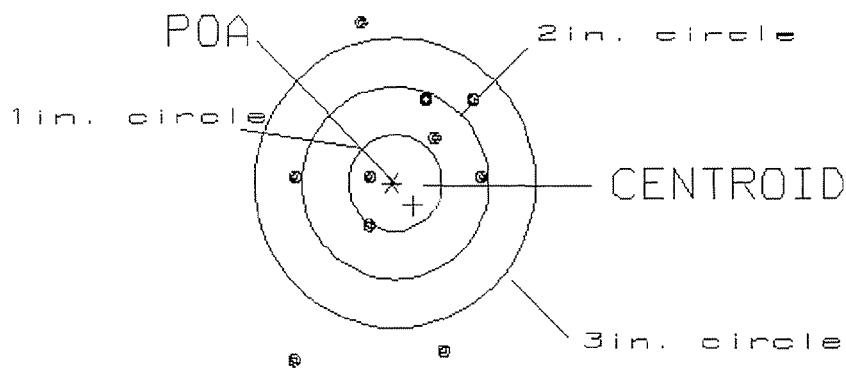
PATTERN #: 050

POA TO CENTROID: .324
 MIN RADIUS : .320
 MEAN RADIUS : 1.114
 MAX RADIUS : 2.112
 CENTROID X : -.224
 CENTROID Y : .234

4 Mar 1997

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/C6225375

CENTERFIRE PATTERN # 5



OF SHOTS= 10

IN CIRCLE

HS= 2.06
 VS= 3.50
 GS= 3.56

2
 5
 7

RECEIVING AND ESTIMATING REPORT

COMMENTS

ORDER
R 97-01369

INITIAL CUSTOMER ORDER NO.

JIM 011788

SNIPER M-24
W/LEUPOLD 10X SCOPE

DATE RECEIVED

DATE OPENED

DATE CODE

SERIAL NUMBER

NEW SERIAL NUMBER

MODEL AND GRADE

01/17/97

01/17/97

LM 2-92

C6225375

700

7.62

NATO

ACCESSORIES

SCOPE MNTS

SCOPE BASE... W/STUDS

FROM:

SHIP TO:

DEPT OF THE ARMY
D CO 2ND BN 1ST SWTG (A)
FT BRAGG NC 28307DEPT OF THE ARMY
D CO 2ND BN 1ST SWTG (A)
FT BRAGG NC
28307

CUST NO: 135960 C.O.D.

ACCOUNT NUMBER

ACCOUNT NUMBER N/C

WRITE ☐

PROM. DATE

ESTIMATED

VIA

DOOR

GUN CONDITION

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

REPAIR CHARGE

EXCISE

TAX

INSURANCE

UPS

PARCEL POST

TOTAL

CUSTOMER CONCERN

AMMO

FUNCTION

FINISH

ACCURACY

FIT

INSPECT

CYCLE

A1

B1

TRIGGER GROUP

B2

E1

F1

BOLT ASSY.

B3

E2

F2

BARREL ASSY.

B4

D1

E3

F3

REC. ASSY.

B5

D2

E4

F4

WOOD

C1

D3

E5

F5

METAL

C2

MAIN FAULT

W524097063 #545

PARTS

COMMENTS

Barrel - 96003
Mag Spring - 96013Repeater Coat - Trigger Guard
Assy, Front & Rear Sight Base
Reticle, Scope Base, Rings
& Survival Studs

REPAIRMAN

PROOF

CLEAN

TEST

TARGET

PATTERN

GALLERY TESTER

DATE

DATE

DATE

DATE

DATE

OFFICE COPY

RD6925 REV. 11/95

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

M2400085968

PAYMENT:

Mastercard / Visa (circle one)

Card #:

Exp. Date:

Signature

RETURN:

☐ Clark Street Entrance☐ Via US Mail or UPS

(PLEASE PRINT CLEARLY)

FIREARMS DELIVERED TO PLANT

FILE Nº 011788DATE 1/16/97CUSTOMER NAME: FT Bragg NCADDRESS: D-2- 1st SWTG (A)ZIP: 28317PHONE: 910 432 9771

FIREARM

MODEL: M-24

CHECK FOR AMMUNITION

GAUGE: _____

SERIAL # L6225375

CONDITION:

WOOD GOOD FAIR POOR FANCY PLAIN

METAL GOOD FAIR POOR FANCY PLAIN

BARREL VT. RIB PLAIN DEER RSS

ACCESSORIES:

SCOPE: YES NO

(BRAND NAME/POWER) Leopold

SLING: YES NO

GUN CASE: YES NO

(HARD-SOFT)

EXTRA BBL FOR GUN MENTIONED ABOVE:

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

CUSTOMER REQUEST: ATT Fred MARTINSIGNATURE: [Signature]
(Person delivering firearm to Plant)DATE: 16 JAN 97SIGNATURE: [Signature]
(Security Officer)DATE: 1/16/97SIGNATURE: [Signature]
(Firearm picked up by)

DATE: _____

Arm Service Copy

21 DAY TURN - AROUND

New Barrel

M-24

CONTRACT # DAAA09-92-C-0834

R&E NO.

SERIAL NO. *C6225375*

LOG IN DATE: / /

DATE

INIT.

INSPECT & VERIFY:

OP. #	OP. NAME
550	DIS-ASSEMBLE GUN
560 A	RE-BARREL AT CUSTOM SHOP
B	DRILL & TAP
C	POLISH
575	ASSEMBLE
600	PROOF
605	CHECK HEADSPACE
610	DIS-ASSEMBLE
612	MAGNAFLUX
615	ROLLMARK CALIBER
618	ROTO-BLAST
620	APPLY COATINGS
625 A	FINAL ASSEMBLY
B	TRIGGER PULL TEST
C	SAFETY ON FORCE
D	SAFETY OFF FORCE
E	FIRING PIN INDENT
640	TARGET
655	FINAL INSPECT
660	PACK

1/20/97 RW
3/3/97 RW

2/27/97 RW
3/3/97 RW

QAR INSPECTION

SHIP DATE

Final Inspection

S.N. C6225375

DATE REC'D: 1/17/97

DATE RET'D:

AUDITOR: RW

Item:

Barrel Assy.

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

Scope Assy.

☐ Scope☐ Scope Rings☐ Mounting Screws☒ Mounting Base☐ Screws☐ Finish☐ Looseness☐ CLARITY

Misc.

☐ DD-250☐ BAR CODE☐ PACKAGING

Item:

Stock Assy.

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

Systems Case

☒ Scope Case☐ IRON SIGHTS☐ Deployment Kit

Trigger

☒ SAFETY OPERATION☒ SET

Comments: _____

Repair Number: RE00112968	Serial: C6225375 Model M24 SWS Center Fire Caliber: 7.62 NATO Produced: 10/26/1988	Repairman:	Status: New 5/30/2006 10:53:03 AM															
Address Information																		
Customer: ☐ Received From		Return To: ☐ Received From																
Name: C CO SPT BN SWTG (A) POC JERRY SCREEN		C CO SPT BN SWTG (A) POC JERRY SCREEN																
Address 1: ARMAMENT FACILITY BLDG D-1307		ARMAMENT FACILITY BLDG D-1307																
Address 2: GRUBER ROAD PO Box:		GRUBER ROAD PO Box:																
City: FORT BRAGG		FORT BRAGG																
State: NC Zip Code: 28310 Country: US		State: NC Zip Code: 23310 Country: US																
FFL: ☐ ☐ ☐ ☐ ☐ ☐																		
Contact / Condition Problems Estimate History / Status Shipping / Billing																		
Contact Information		Received Condition																
Phone: NA		Fair																
Fax:		Condition Notes:																
Email:		CSR Notes:																
Comments:																		
Accessories Received																		
<table border="1"><thead><tr><th>Code</th><th>Desc</th><th>Qty</th></tr></thead><tbody><tr><td>A007</td><td>With Stud</td><td>3</td></tr><tr><td>A010</td><td>Hard Case</td><td>1</td></tr><tr><td>A017</td><td>Scope Base</td><td>1</td></tr><tr><td>A057</td><td>Frt and Rear Sgt Base</td><td>1</td></tr></tbody></table>				Code	Desc	Qty	A007	With Stud	3	A010	Hard Case	1	A017	Scope Base	1	A057	Frt and Rear Sgt Base	1
Code	Desc	Qty																
A007	With Stud	3																
A010	Hard Case	1																
A017	Scope Base	1																
A057	Frt and Rear Sgt Base	1																
Repair Search		Refresh Close																
naglelj		5/31/2006 10:28 AM CAPS NUM INS SCRL																

start 2 Micros... 2 Micros... 3 Intern... Arms Ser... Part Sear... 10:28 AM

C657 7140 (New)

Serial Number: **C6225375**

Model: M24 SWS

RE00112968

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6577140.__0

FILE DATE AND TIME: 06/29/2006 17:53

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

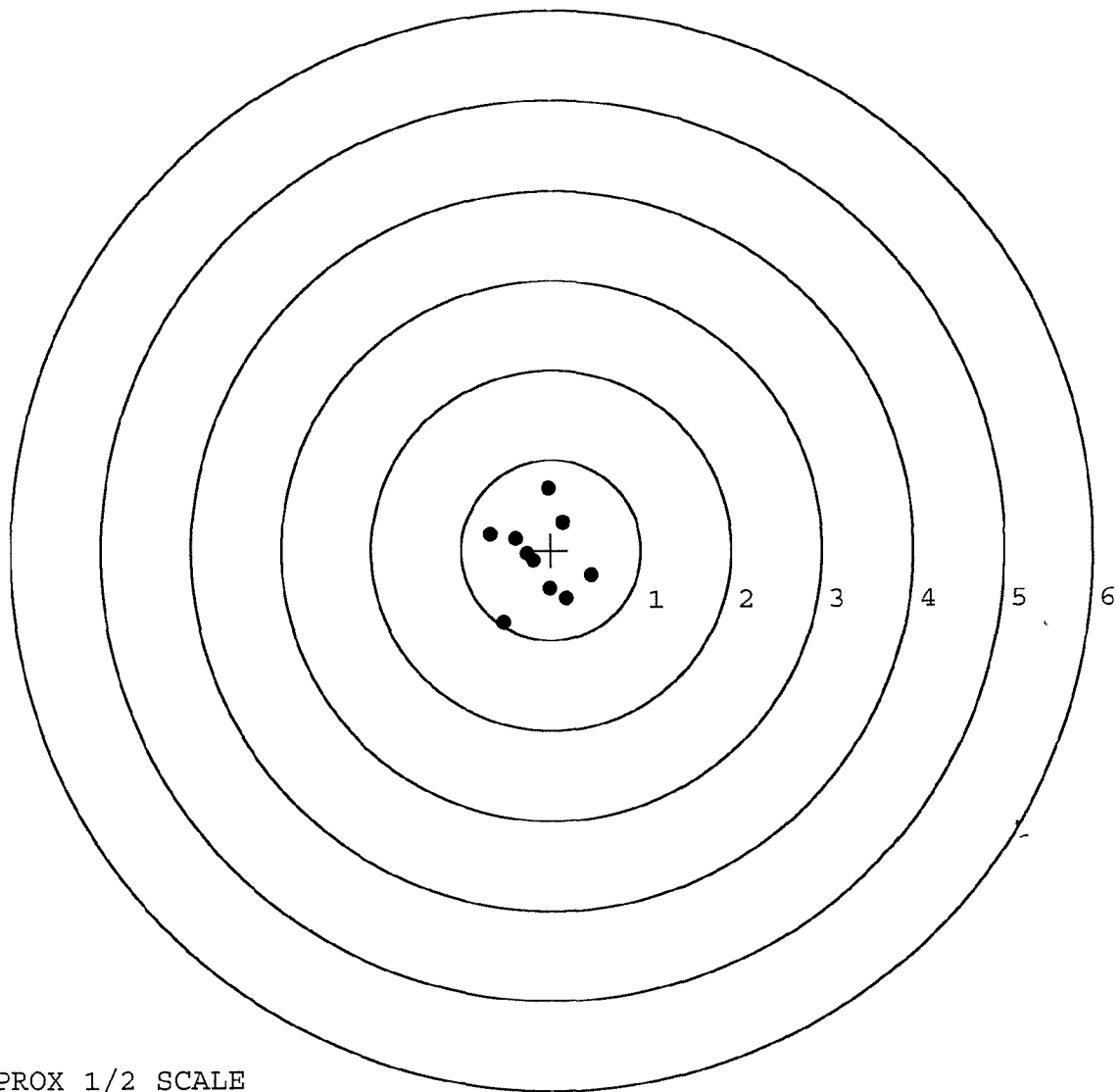
The Average X Centroid of the Five Target Set:	-0.219
The Average Y Centroid of the Five Target Set:	-0.083
The Average Point of Impact of the Five Target Set:	0.234
The Average Mean Radius of the Five Target Set:	0.578
The Distance from POA to Centroid Target #1:	0.166
The Distance from Centroid Target #2 to Centroid Target #1:	0.264
The Distance from Centroid Target #3 to Centroid Target #1:	0.326
The Distance from Centroid Target #4 to Centroid Target #1:	0.045
The Distance from Centroid Target #5 to Centroid Target #1:	0.262

SERIAL NUMBER: G6577140. __0
TARGET NUMBER: 1
FILE DATE: 06/29/2006
FILE TIME: 17:53

X CENTROID: -0.139
Y CENTROID: -0.092
POA TO CENTROID: 0.166
HORZ SPREAD: 1.126
VERT SPREAD: 1.495
GROUP SPREAD: 1.576
MIN RADIUS: 0.067
MAX RADIUS: 0.823
MEAN RADIUS: 0.476

IN 1 IN DIAMETER: 5
IN 2 IN DIAMETER: 10
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.038	0.683
2:	0.132	0.309
3:	-0.674	0.186
4:	-0.399	0.127
5:	-0.201	-0.117
6:	-0.019	-0.429
7:	0.168	-0.546
8:	0.452	-0.278
9:	-0.537	-0.812
10:	-0.271	-0.044



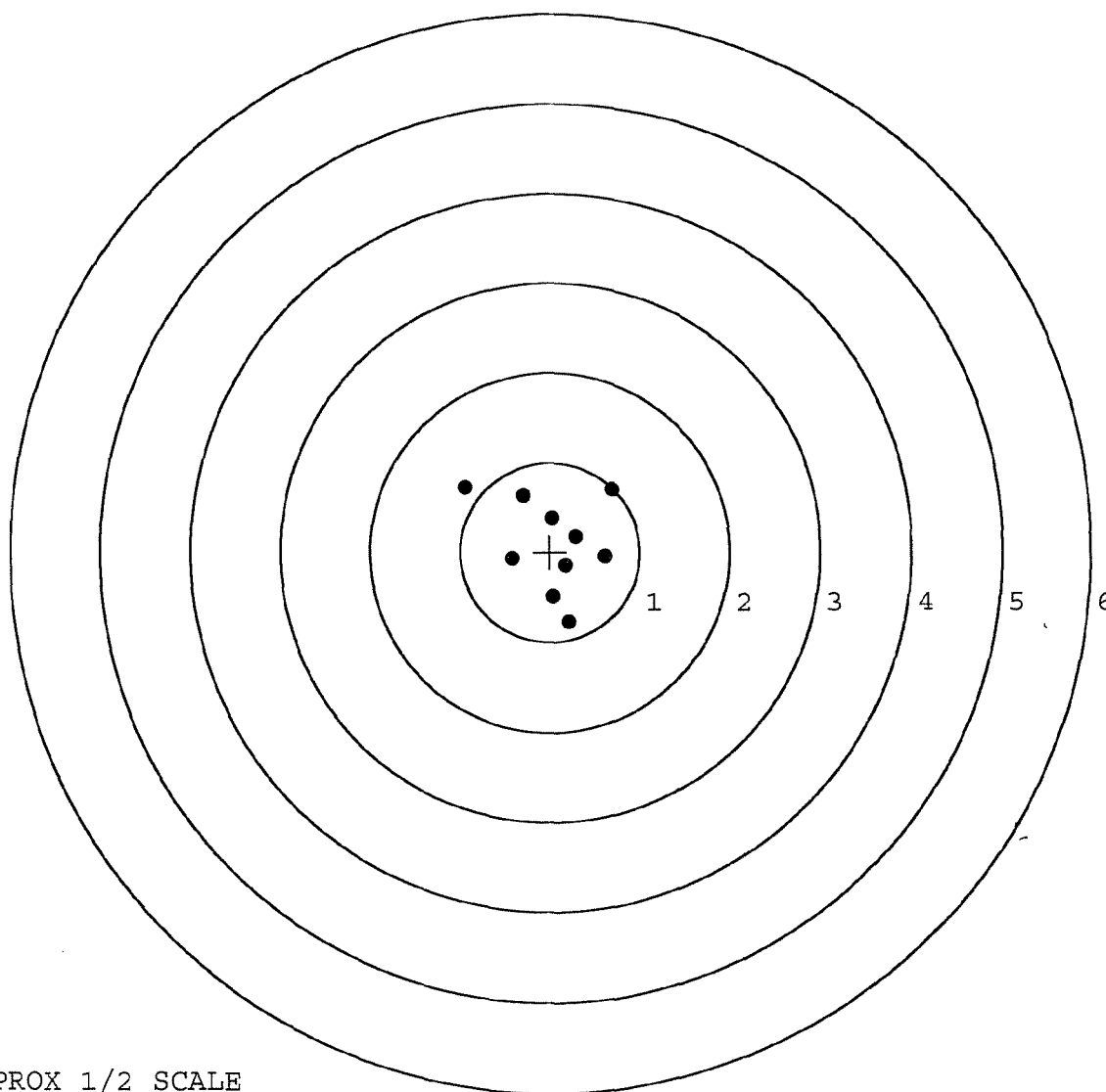
TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6577140. __0
TARGET NUMBER: 2
FILE DATE: 06/29/2006
FILE TIME: 17:53

X CENTROID: 0.037
Y CENTROID: 0.105
POA TO CENTROID: 0.111
HORZ SPREAD: 1.641
VERT SPREAD: 1.501
GROUP SPREAD: 1.905
MIN RADIUS: 0.260
MAX RADIUS: 1.164
MEAN RADIUS: 0.612

IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.953	0.716
2:	-0.306	0.631
3:	0.025	0.386
4:	0.288	0.174
5:	0.688	0.706
6:	0.615	-0.051
7:	0.176	-0.152
8:	0.046	-0.498
9:	0.220	-0.785
10:	-0.424	-0.077



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6577140. __0

TARGET NUMBER: 3

FILE DATE: 06/29/2006

FILE TIME: 17:53

X CENTROID: -0.448

Y CENTROID: -0.197

POA TO CENTROID: 0.489

HORZ SPREAD: 2.561

VERT SPREAD: 1.812

GROUP SPREAD: 2.565

MIN RADIUS: 0.140

MAX RADIUS: 1.345

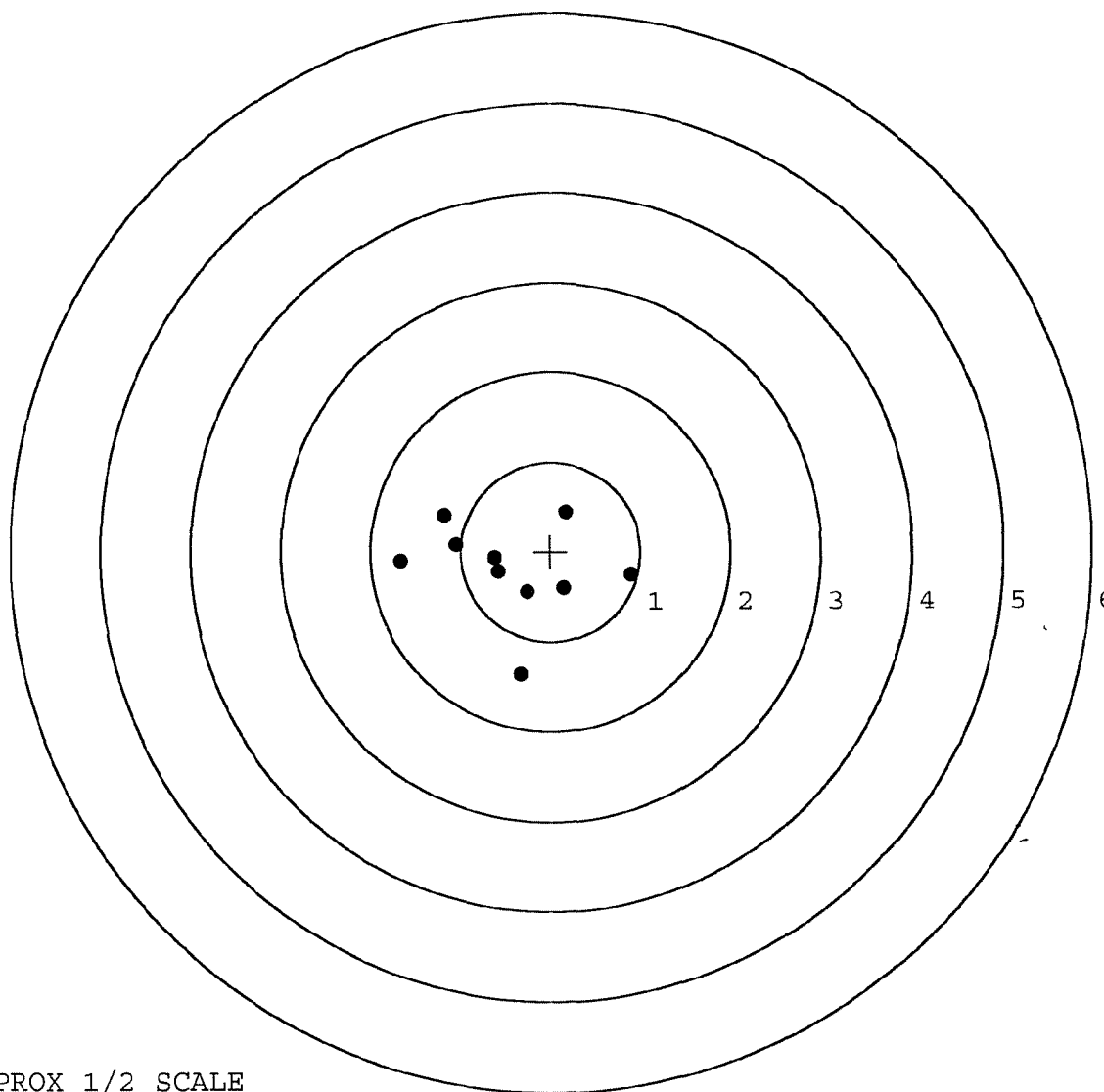
MEAN RADIUS: 0.755

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-1.181	0.406
2:	-1.047	0.075
3:	-1.665	-0.111
4:	-0.625	-0.067
5:	-0.260	-0.450
6:	0.152	-0.410
7:	0.896	-0.259
8:	0.173	0.442
9:	-0.336	-1.370
10:	-0.586	-0.221



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6577140. __0

TARGET NUMBER: 4

FILE DATE: 06/29/2006

FILE TIME: 17:53

POINT#	X	Y
1:	-1.037	0.315
2:	-0.609	-0.013
3:	-0.233	0.335
4:	0.315	0.294
5:	-0.189	-0.059
6:	-0.221	-0.284
7:	0.445	-0.271
8:	0.658	-0.156
9:	-0.725	-0.796
10:	-0.006	0.111

X CENTROID: -0.160

Y CENTROID: -0.052

POA TO CENTROID: 0.169

HORZ SPREAD: 1.695

VERT SPREAD: 1.131

GROUP SPREAD: 1.759

MIN RADIUS: 0.030

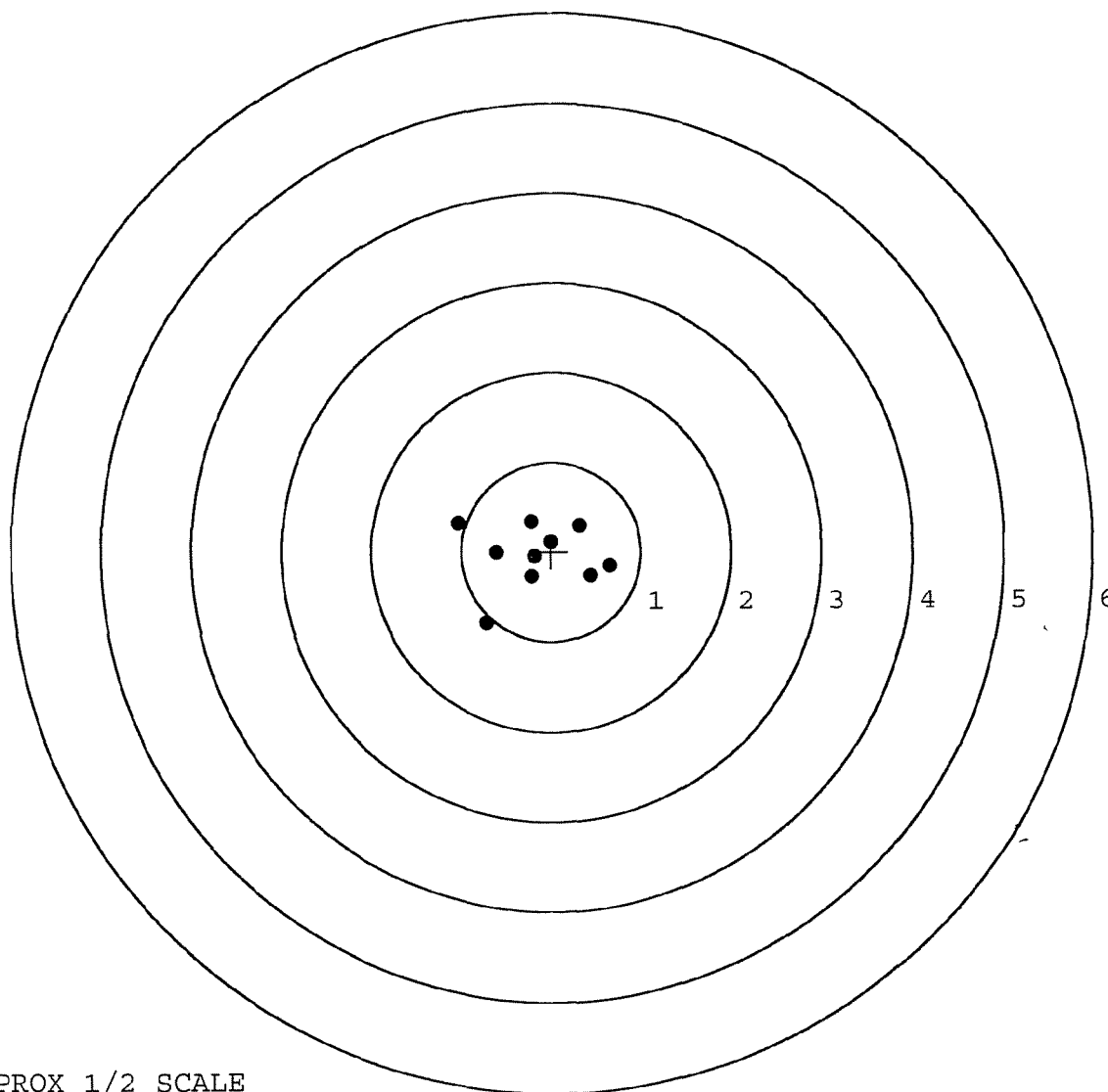
MAX RADIUS: 0.951

MEAN RADIUS: 0.528

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6577140. __0

TARGET NUMBER: 5

FILE DATE: 06/29/2006

FILE TIME: 17:53

POINT#	X	Y
1:	-0.608	0.449
2:	-0.696	0.176
3:	-0.322	0.163
4:	0.486	-0.211
5:	-0.051	-0.568
6:	-0.255	-0.499
7:	-0.467	-0.556
8:	-0.595	-0.566
9:	-1.230	-0.149
10:	-0.130	-0.013

X CENTROID: -0.387

Y CENTROID: -0.177

POA TO CENTROID: 0.426

HORZ SPREAD: 1.716

VERT SPREAD: 1.017

GROUP SPREAD: 1.717

MIN RADIUS: 0.305

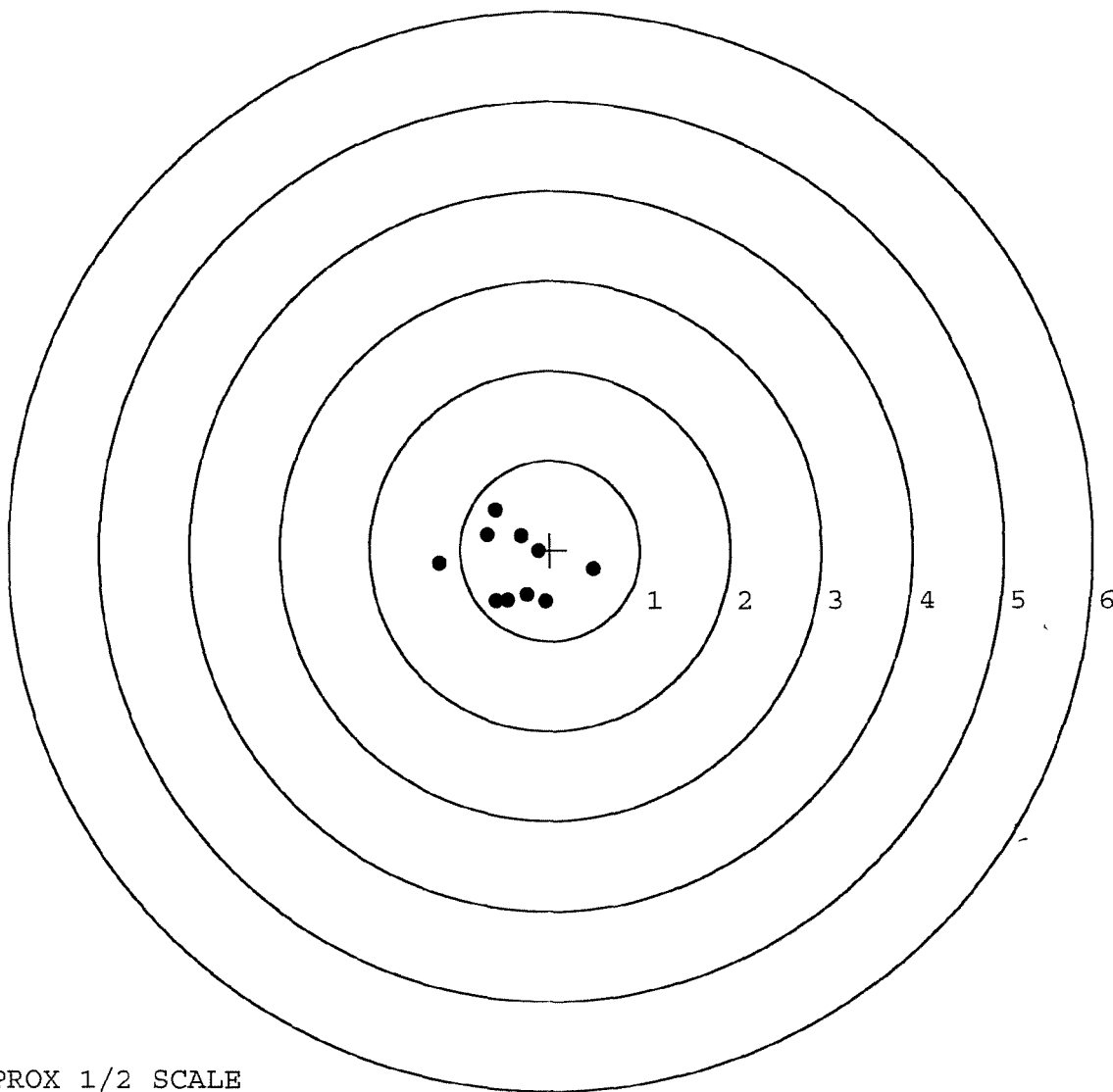
MAX RADIUS: 0.873

MEAN RADIUS: 0.519

IN 1 IN DIAMETER: 6

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

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

R & E NUMBER	112968	C6577140 (New)	
SERIAL NUMBER	C6225375		
LOG-IN DATE	5-30-06		
OPERATION #	OPERATION NAME	DATE	INITIAL
500	DIS-ASSEMBLE GUN	6-15-06	RTZ
505	RE-BARREL	6-20-06	RTZ
420	ASSEMBLE	6-20-06	RTZ
440	PROOF	MAGNA-FLUX INSPECTED 6-20-06	TRW
460	CHECK HEADSPACE	6-20-06	TRW
470	DIS-ASSEMBLE GUN	6-21-06	RTZ
480	MAGNAFLUX	6-23-06	unus
510	DRILL AND TAP	6-22-06	TRW
500	ROLLMARK CALIBER	6-22-06	CW
520	GOFF BLAST BBL / REC	6-23-06	LB
530 & 540	APPLY COATINGS	6-28-06	RS
560	FINAL ASSEMBLY	6-29-06	RTZ
640	FUNCTION TEST AND	(PASS) FAIL	6-29-06 MTM
650	TARGET	(PASS) FAIL	6-29-06 MTM
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
670	FINAL INSPECTION		7-5-06 AC
	A) HEADSPACE	(PASS) FAIL	7-5-06 AC
	B) TRIGGER PULL	N/A AC	
		+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	
680	F) SAFETY ON FORCE	5 lbs 5 lbs 5 lbs AC	
		2 LBS MIN 10 LBS MAX	
	G) SAFETY OFF FORCE	3 lbs 3 lbs 3 lbs AC	
		2 LBS MIN	
	I) FIRING PIN INDENT	.023 .023 .023 AC	
690	PACK	8-3-06 DA	

F006 REV 5/2006

FINAL INSPECTION CHECKLIST

BARREL ASSEMBLY _____ BARREL _____ RECEIVER _____ FRONT SIGHT BASE _____ REAR SIGHT BASE _____ SCREWS _____ FINISH	STOCK ASSEMBLY _____ STOCK _____ SLING SWIVEL STUDS _____ BUTT PATE _____ LOCK NUTS _____ BARREL CLEARANCE _____ COLOR / FINISH
SCOPE ASSEMBLY _____ SCOPE _____ SCOPE RINGS _____ MOUNTING SCREWS _____ MOUNTING BASE _____ SCREWS _____ FINISH _____ CLARITY	SYSTEM CASE _____ SCOPE CASE _____ IRON SIGHTS _____ DEPLOYMENT KIT TRIGGER ASSEMBLY _____ SAFETY OPERATION _____ RE-SET TO FACTORY SPECS
COMMENTS: _____	

F006 REV 5/2006