

G 657 7305-
Replace
E-6225414

-Address Information

FEL

Repair Search

Refresh

Close

naqlet	5/31/2006	10:44 AM	CAPS	NUM	INS	SCR
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G657 7305

Serial Number: **C6225414**

Model: M24 SWS



RE00113018

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6577305.__0

FILE DATE AND TIME: 07/05/2006 08:12

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.002
The Average Y Centroid of the Five Target Set:	0.031
The Average Point of Impact of the Five Target Set:	0.031
The Average Mean Radius of the Five Target Set:	0.752
The Distance from POA to Centroid Target #1:	0.183
The Distance from Centroid Target #2 to Centroid Target #1:	0.412
The Distance from Centroid Target #3 to Centroid Target #1:	0.266
The Distance from Centroid Target #4 to Centroid Target #1:	0.241
The Distance from Centroid Target #5 to Centroid Target #1:	0.182

SERIAL NUMBER: G6577305. 0

TARGET NUMBER: 1

FILE DATE: 07/05/2006

FILE TIME: 08:12

POINT#	X	Y
1:	0.683	1.309
2:	0.981	-0.147
3:	0.086	-0.442
4:	-0.785	-0.535
5:	-0.123	-0.189
6:	0.202	0.239
7:	0.024	0.261
8:	-0.034	0.038
9:	0.411	0.294
10:	0.142	0.076

X CENTROID: 0.159

Y CENTROID: 0.090

POA TO CENTROID: 0.183

HORZ SPREAD: 1.766

VERT SPREAD: 1.844

GROUP SPREAD: 2.357

MIN RADIUS: 0.022

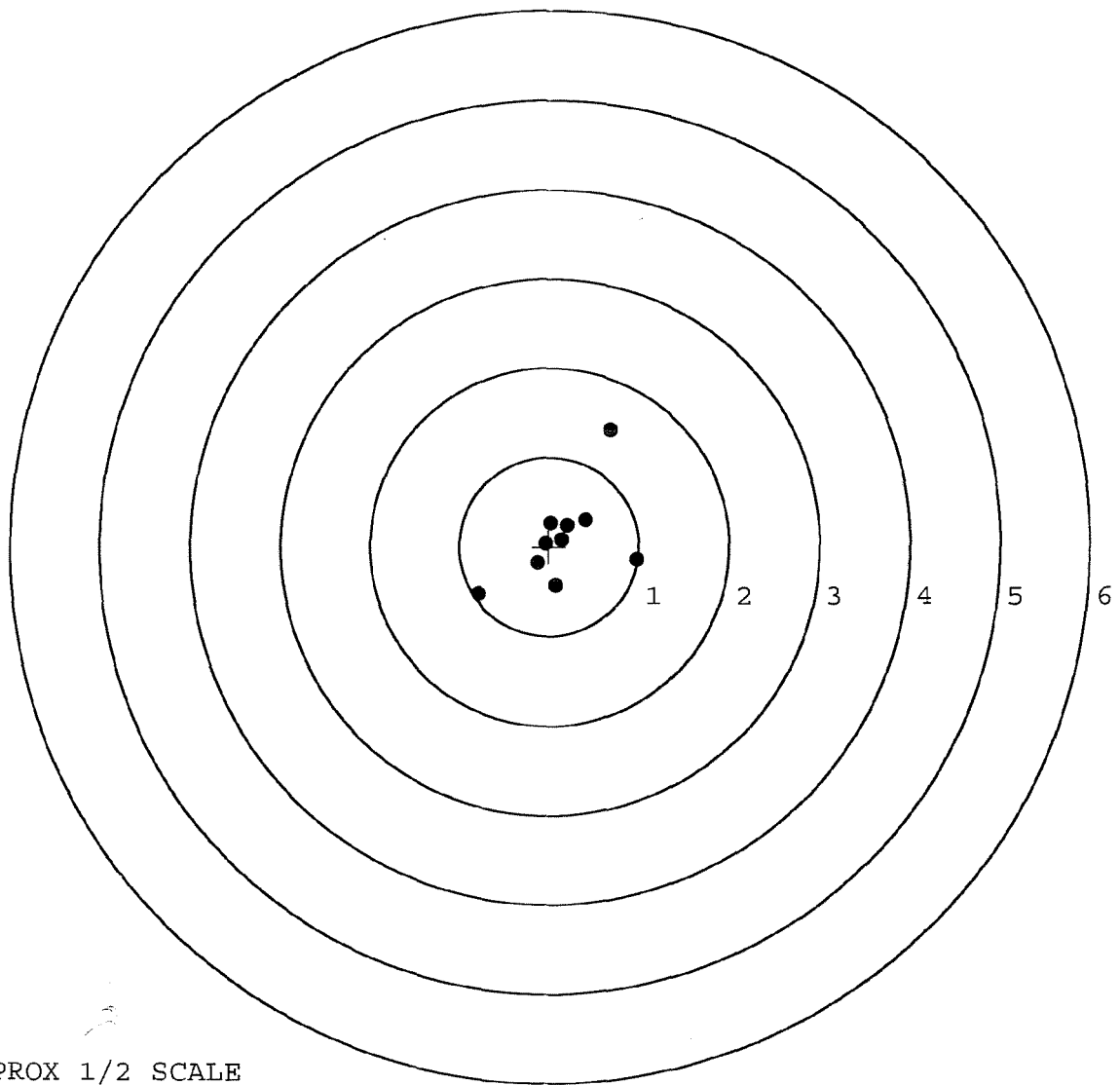
MAX RADIUS: 1.327

MEAN RADIUS: 0.517

IN 1 IN DIAMETER: 6

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10

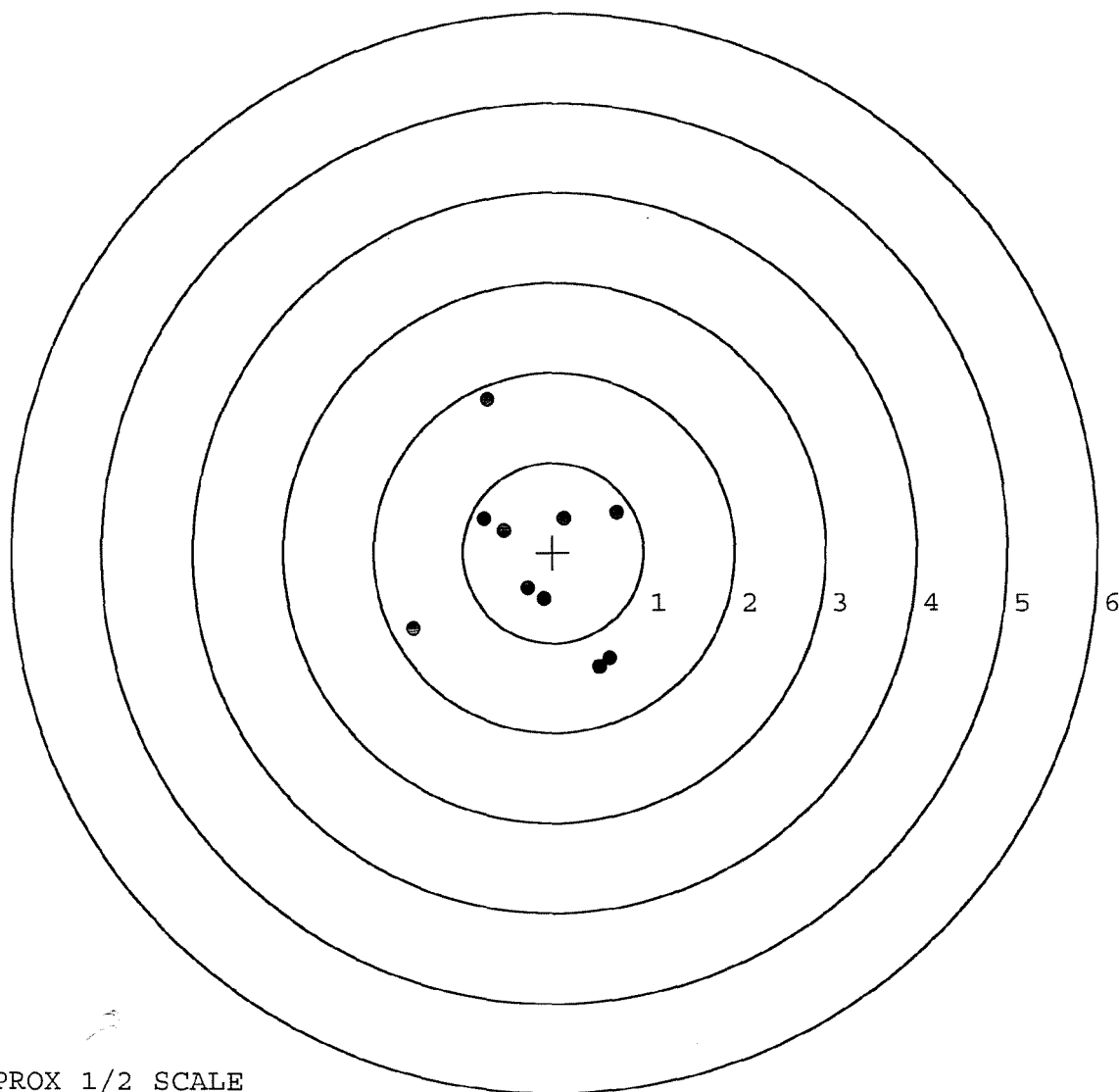


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6577305. __0
TARGET NUMBER: 2
FILE DATE: 07/05/2006
FILE TIME: 08:12

POINT#	X	Y
1:	0.632	-1.175
2:	0.520	-1.269
3:	0.704	0.448
4:	0.125	0.376
5:	-0.553	0.239
6:	-0.767	0.362
7:	-1.550	-0.859
8:	-0.741	1.702
9:	-0.283	-0.405
10:	-0.100	-0.524

X CENTROID: -0.201
Y CENTROID: -0.111
POA TO CENTROID: 0.230
HORZ SPREAD: 2.254
VERT SPREAD: 2.971
GROUP SPREAD: 3.228
MIN RADIUS: 0.306
MAX RADIUS: 1.891
MEAN RADIUS: 0.976
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 5
in 3 IN DIAMETER: 8



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6577305. 0

TARGET NUMBER: 3

FILE DATE: 07/05/2006

FILE TIME: 08:12

POINT#	X	Y
--------	---	---

1:	0.913	1.319
----	-------	-------

2:	-0.343	2.089
----	--------	-------

3:	0.555	-0.039
----	-------	--------

4:	0.143	0.553
----	-------	-------

5:	-0.560	-0.763
----	--------	--------

6:	-0.426	0.364
----	--------	-------

7:	-0.295	0.189
----	--------	-------

8:	0.025	0.137
----	-------	-------

9:	-0.063	-0.311
----	--------	--------

10:	0.067	-0.490
-----	-------	--------

X CENTROID: 0.002

Y CENTROID: 0.305

POA TO CENTROID: 0.305

HORZ SPREAD: 1.473

VERT SPREAD: 2.852

GROUP SPREAD: 2.860

MIN RADIUS: 0.169

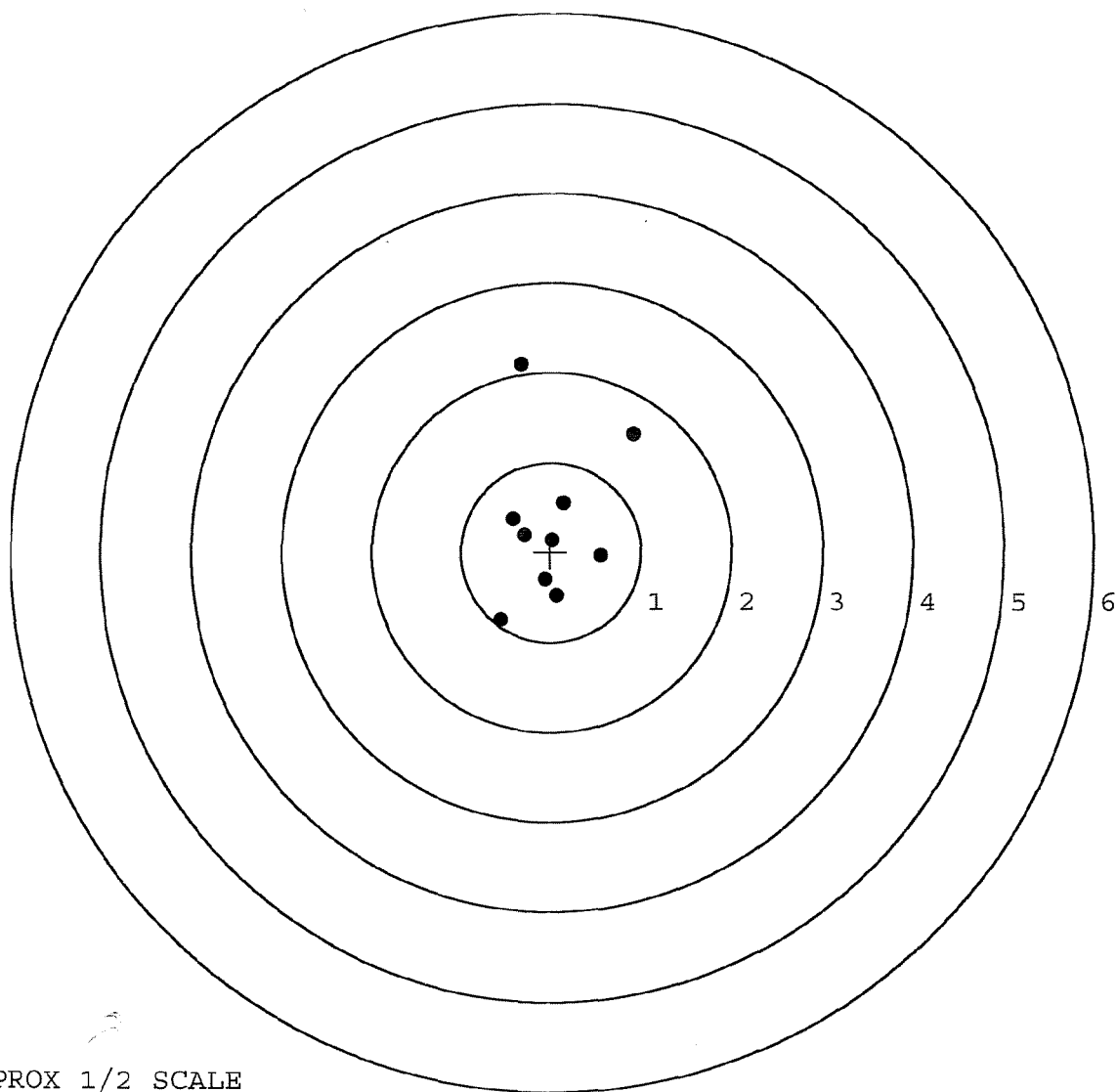
MAX RADIUS: 1.817

MEAN RADIUS: 0.766

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6577305. 0

TARGET NUMBER: 4

FILE DATE: 07/05/2006

FILE TIME: 08:12

POINT#	X	Y
--------	---	---

1:	1.154	-0.955
----	-------	--------

2:	-0.027	-1.102
----	--------	--------

3:	0.239	-0.242
----	-------	--------

4:	0.404	0.304
----	-------	-------

5:	-0.135	0.163
----	--------	-------

6:	-0.488	0.406
----	--------	-------

7:	-0.103	1.407
----	--------	-------

8:	-0.272	-0.190
----	--------	--------

9:	0.018	-0.448
----	-------	--------

10:	-0.338	-0.565
-----	--------	--------

X CENTROID: 0.045

Y CENTROID: -0.122

POA TO CENTROID: 0.130

HORZ SPREAD: 1.642

VERT SPREAD: 2.509

GROUP SPREAD: 2.676

MIN RADIUS: 0.228

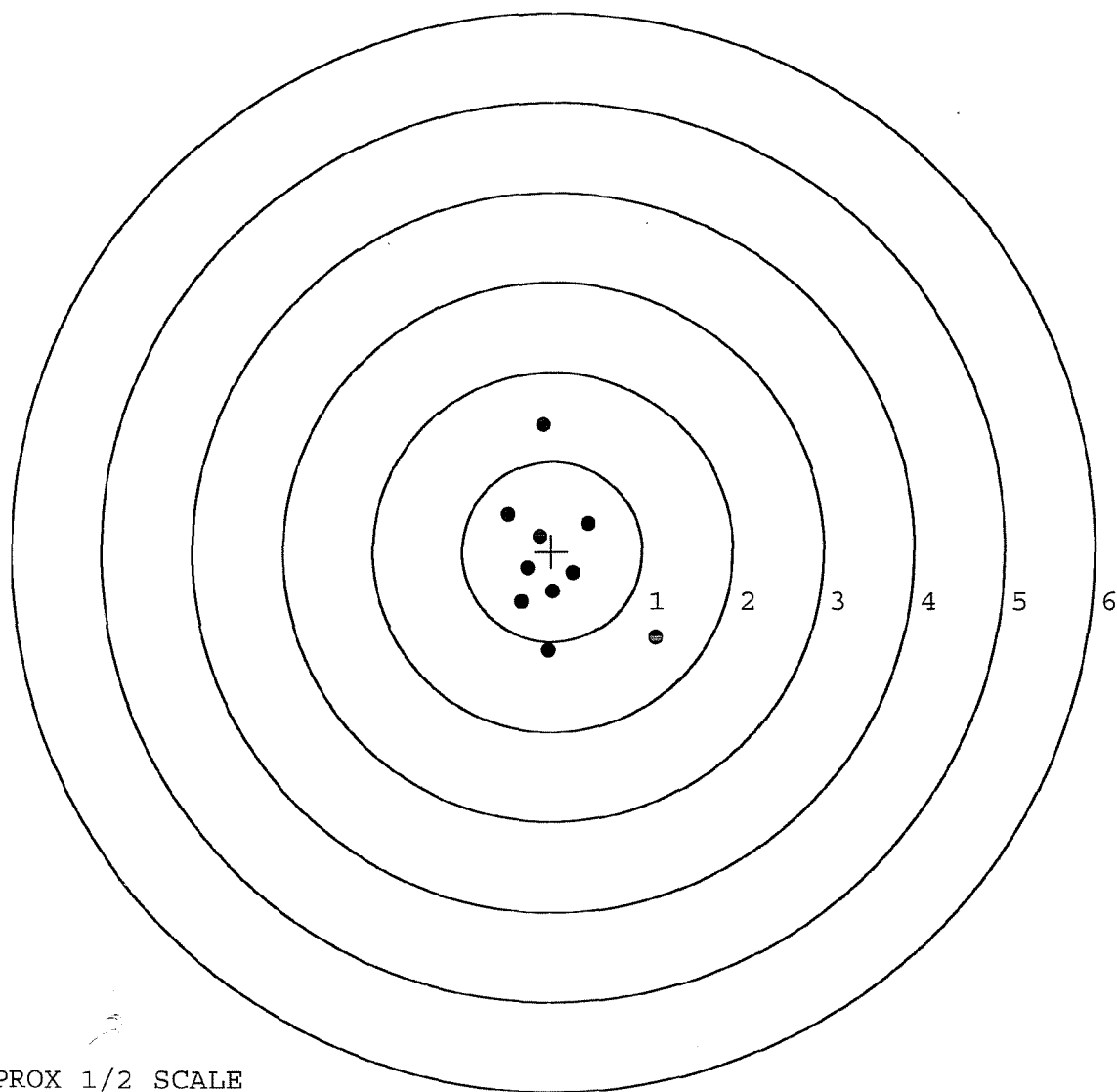
MAX RADIUS: 1.536

MEAN RADIUS: 0.702

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6577305. 0

TARGET NUMBER: 5

FILE DATE: 07/05/2006

FILE TIME: 08:12

POINT#	X	Y
1:	-0.388	1.723
2:	0.428	-1.033
3:	0.299	-1.106
4:	0.031	-0.599
5:	-0.374	-0.639
6:	0.448	0.009
7:	-0.401	0.053
8:	-0.330	0.288
9:	0.372	0.540
10:	-0.028	0.678

X CENTROID: 0.006

Y CENTROID: -0.009

POA TO CENTROID: 0.010

HORZ SPREAD: 0.849

VERT SPREAD: 2.829

GROUP SPREAD: 2.911

MIN RADIUS: 0.411

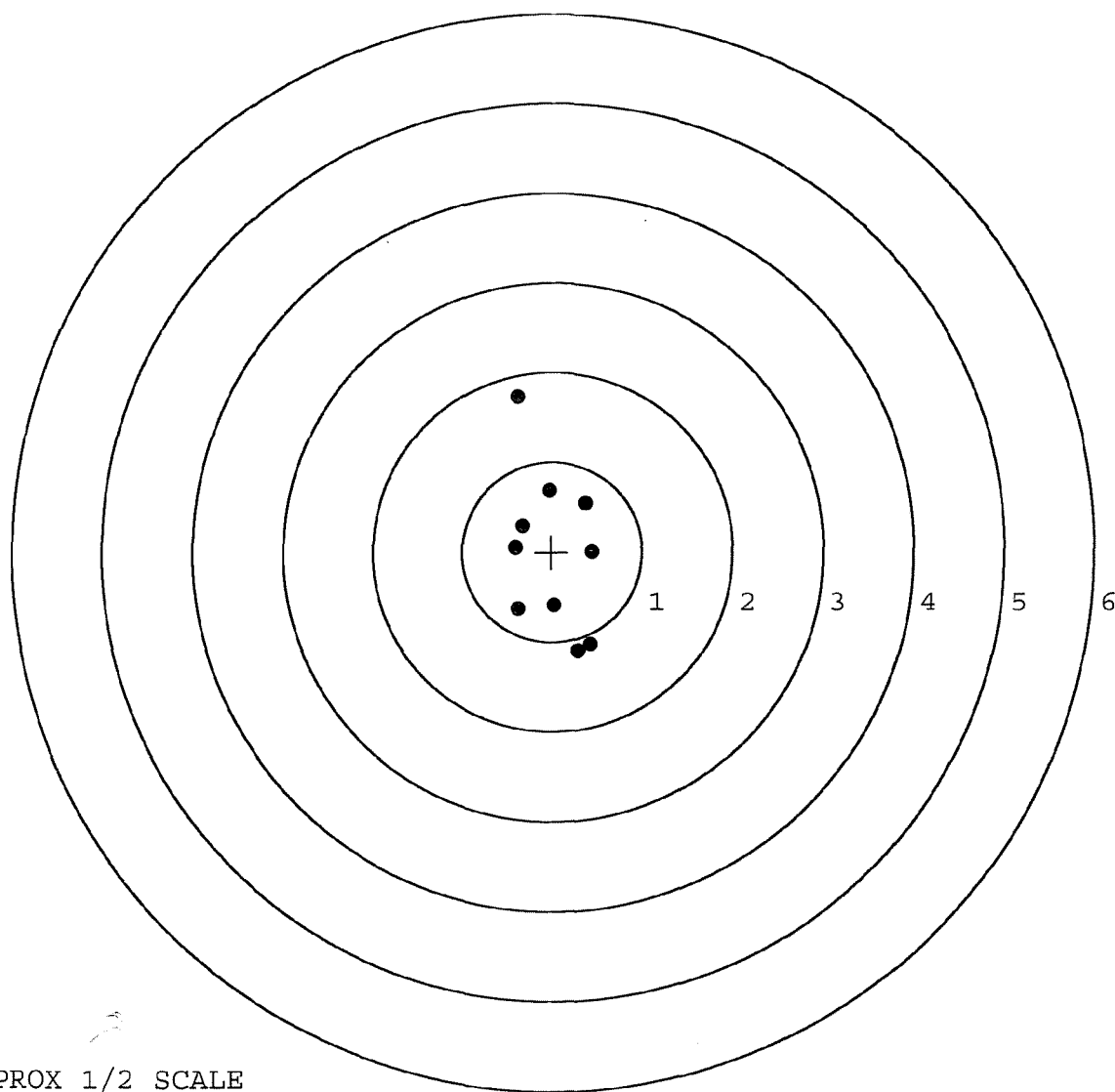
MAX RADIUS: 1.776

MEAN RADIUS: 0.800

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

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

R & E NUMBER	113018	66577305 (New)		
SERIAL NUMBER	C6225414			
LOG-IN DATE	5-30-06			
OPERATION #	OPERATION NAME		DATE	INITIAL
500	DIS-ASSEMBLE GUN		6-16-06	RTZ
505	RE-BARREL		6-20-06	RTZ
420	ASSEMBLE		6-20-06	RTZ
440	PROOF	MAGNA-FLUX	6-20-06	TRW
460	CHECK HEADSPACE	INSPECTED	6-20-06	TRW
470	DIS-ASSEMBLE GUN	JUN 23 2006	6-21-06	RTZ
480	MAGNAFLUX	OPERATOR <i>cmw</i>	6/23/06	<i>cmw</i>
510	DRILL AND TAP		6-22-06	TRW
500	ROLLMARK CALIBER		6-22-06	AW
520	GOFF BLAST BBL / REC		6-23-06	LB
530 & 540	APPLY COATINGS		6/28/06	TRW
560	FINAL ASSEMBLY		7-5-06	RTZ
640	FUNCTION TEST AND	PASS FAIL	7-5-06	TRW
650	TARGET	PASS FAIL	7-5-06	TRW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION	7-5-06	R.P.
670	FINAL INSPECTION		7-6-06	AC
	A) HEADSPACE	PASS FAIL	7-6-06	AC
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	N/A	
680	F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX	8 lbs 8 lbs 8 lbs	
	G) SAFETY OFF FORCE	2 LBS MIN	3 lbs 3 lbs 3 lbs	
	I) FIRING PIN INDENT	.020	.022 .022 .022	
690	PACK		7-10-06	BA

F006 REV 5/2006

FINAL INSPECTION CHECKLIST

BARREL ASSEMBLY

BARREL

RECEIVER

FRONT SIGHT BASE

REAR SIGHT BASE

SCREWS

FINISH

SCOPE ASSEMBLY

SCOPE

SCOPE RINGS

MOUNTING SCREWS

MOUNTING BASE

SCREWS

FINISH

CLARITY

STOCK ASSEMBLY

STOCK

SLING SWIVEL STUDS

BUTT PATE

LOCK NUTS

BARREL CLEARANCE

COLOR / FINISH

SYSTEM CASE

SCOPE CASE

IRON SIGHTS

DEPLOYMENT KIT

TRIGGER ASSEMBLY

SAFETY OPERATION

RE-SET TO FACTORY
SPECS

COMMENTS: _____

F006 REV 5/2006

FIG 1

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6225414
11 Jan 1994

CENTROIDAL DISTANCES

0 TO 1	.136561
1 TO 2	1.06293
1 TO 3	.378847
1 TO 4	.50813
1 TO 5	.711018

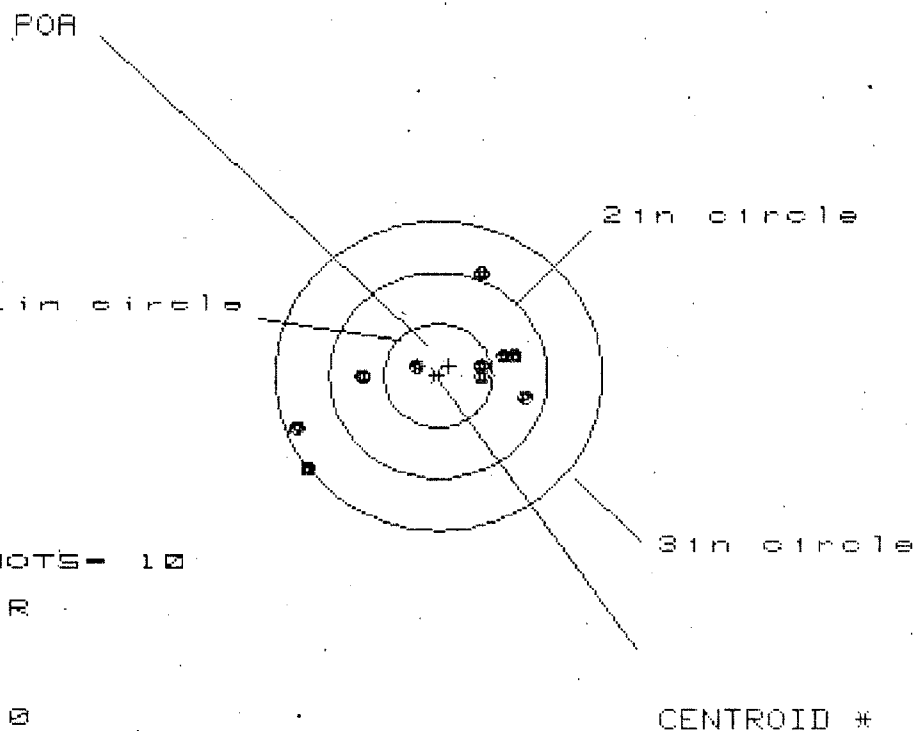
2
0.5 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .2694
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1472
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .006992
THE AMR FOR THIS RIFLE IS: .8666

11 Jan 1934

FILE:/PATTERNING/CENTERFIRE_PATT/C8225414

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 3

2in = 7

3in = 10

HS= 2.059

VS= 1.896

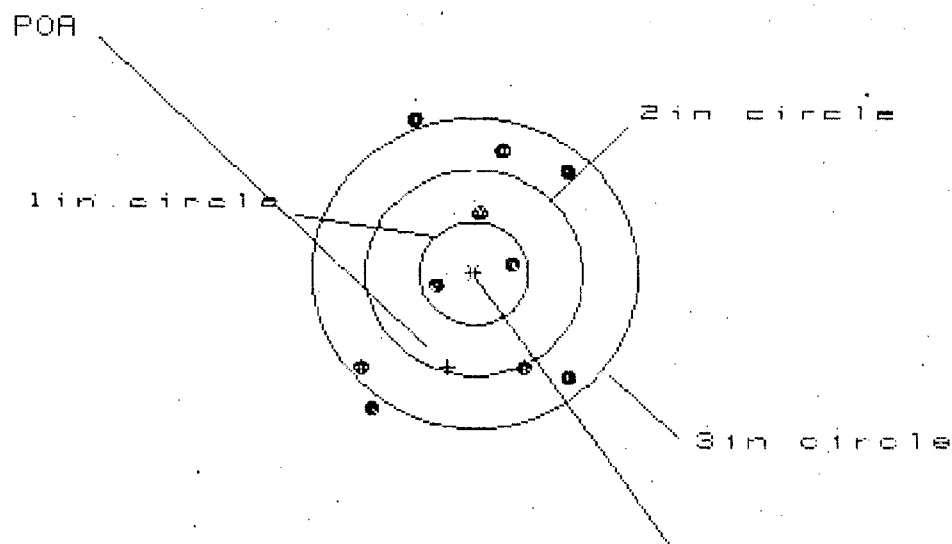
GS= 2.502

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.804	.670	.496
MINIMUM X	:	-1.255	-1.389	-1.021
MAXIMUM Y	:	1.029	.933	.861
MINIMUM Y	:	-.867	-.574	-.370
CENTROID X	:	-.100	.034	.208
CENTROID Y	:	-.093	.003	.075
POA TO CENTROID in.	:	.136	.034	.221
MIN RADIUS	:	.212	.268	.161
MEAN RADIUS	:	.789	.670	.509
MAX RADIUS	:	1.485	1.503	1.032
HORIZONTAL SPREAD	:	2.059	2.059	1.517
VERTICAL SPREAD	:	1.896	1.507	1.231
EXTREME SPREAD	:	2.502	2.259	1.532
NUMBER IN ONE INCH CIRCLE =	:	3		
NUMBER IN TWO INCH CIRCLE =	:	7		
NUMBER IN THREE INCH CIRCLE =	:	10		

11 Jan 1994

FILE:/PATTERNING/CENTERFIRE_PATT/C6225414

CENTERFIRE PATTERNS # 2



OF SHOTS- 10.

IN CIR

1 in = 2

2 in = 3

3 in = 8

HS= 1.935

VS= 2.797

GS= 2.915

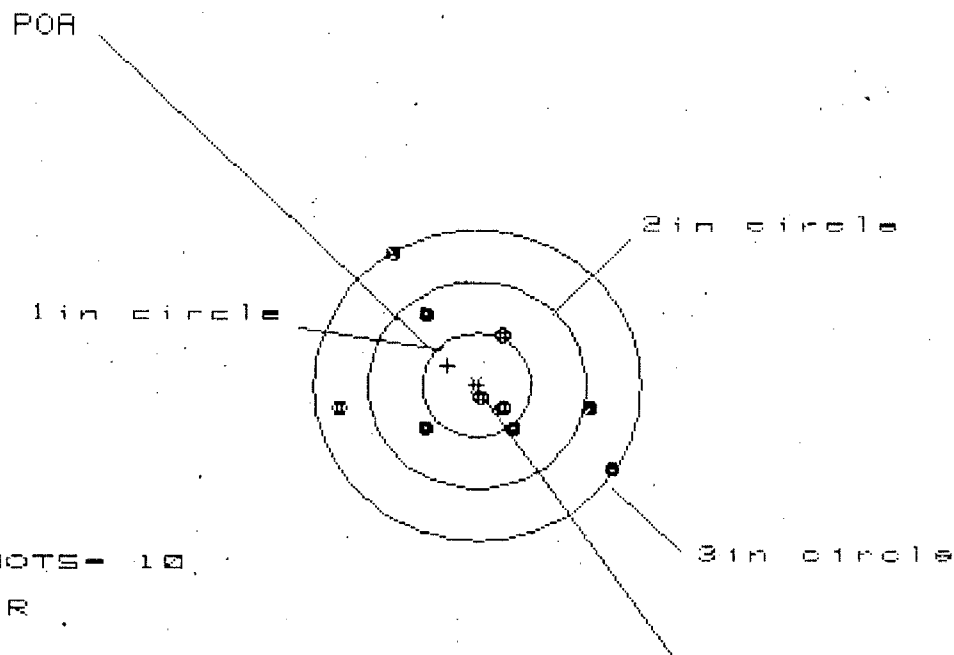
PATTERN # : 2

SHOTS (BEST OF)	10	9	8
MAXIMUM X	.879	.775	.698
MINIMUM X	-1.056	-1.160	-1.236
MAXIMUM Y	1.473	1.326	1.236
MINIMUM Y	-1.324	-1.202	-1.036
CENTROID X	.249	.353	.429
CENTROID Y	.911	1.058	.892
POA TO CENTROID ip.	.944	1.115	.990
MIN RADIUS	.321	.276	.202
MEAN RADIUS	1.072	.989	.925
MAX RADIUS	1.622	1.553	1.510
HORIZONTAL SPREAD	1.935	1.935	1.935
VERTICAL SPREAD	2.797	2.528	2.272
EXTREME SPREAD	2.915	2.884	2.671
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		3	
NUMBER IN THREE INCH CIRCLE =		8	

11 Jan 1994

FILE:/PATTERNING/CENTERFIRE_PATT/C6225414

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in - 2

2in - 6

3in - 8

HS- 2.497

VS- 2.162

GS- 2.929

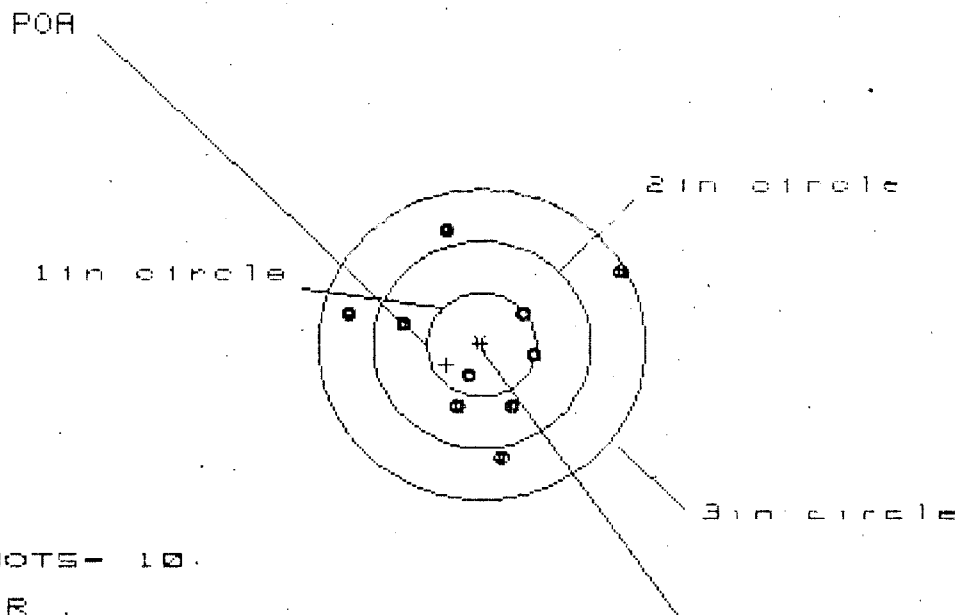
CENTROID *

PATTERN #	3	3	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.191	1.104	1.122
MINIMUM X	-1.306	-1.393	-1.255
MAXIMUM Y	1.319	.844	.757
MINIMUM Y	-.843	-.696	-.363
CENTROID X	.267	.354	.216
CENTROID Y	-.187	-.334	-.247
POR TO CENTROID in.	.326	.487	.328
MIN RADIUS	.142	.096	.092
MEAN RADIUS	.845	.734	.674
MAX RADIUS	1.535	1.396	1.268
HORIZONTAL SPREAD	2.497	2.497	2.377
VERTICAL SPREAD	2.162	1.540	1.120
EXTREME SPREAD	2.929	2.569	2.377
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		9	

11 Jan 1994

FILE:/PATTERNING/CENTERFIRE_PATT/C6825414

CENTERFIRE PATTERNS # 4



OF SHOTS- 10.

IN CIR

1in = 2

2in = 6

3in = 10

HS= 2.454

VS= 2.236

GS= 2.490

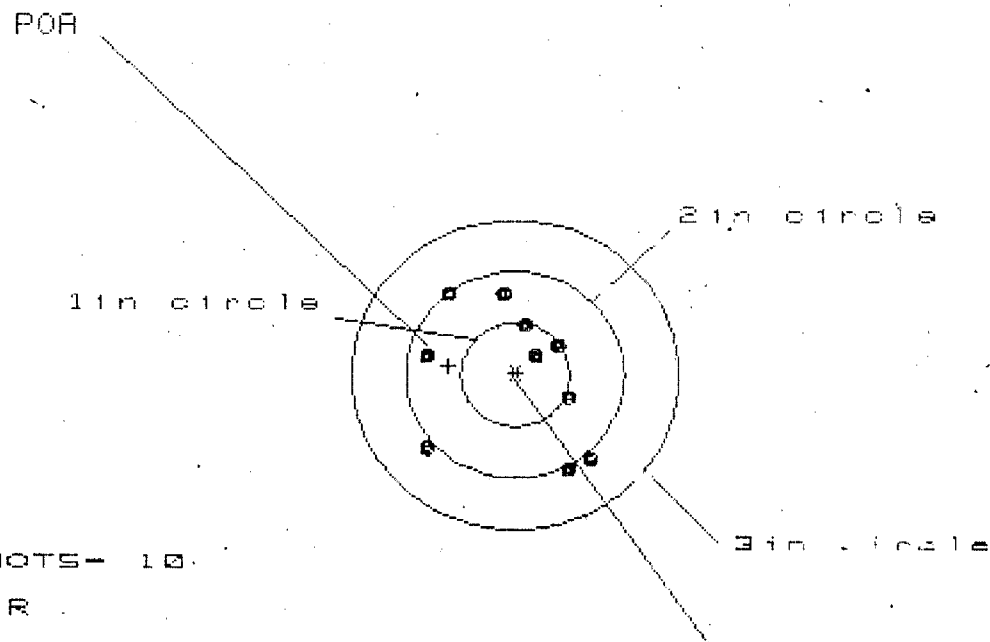
CENTROID *

PATTERN #	:	[4]		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.255	.657	.525
MINIMUM X	:	-1.199	-1.060	-.749
MAXIMUM Y	:	1.127	1.207	1.254
MINIMUM Y	:	-1.109	-1.029	-.982
CENTROID X	:	.320	.181	.313
CENTROID Y	:	.193	.113	.066
POA TO CENTROID in:	:	.374	.213	.320
MIN RADIUS	:	.287	.175	.179
MEAN RADIUS	:	.837	.755	.687
MAX RADIUS	:	1.446	1.216	1.285
HORIZONTAL SPREAD	:	2.454	1.717	1.273
VERTICAL SPREAD	:	2.236	2.236	2.236
EXTREME SPREAD	:	2.490	2.279	2.279
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	

11 Jan 1994

FILE:/PATTERNING/CENTERFIRE_PATT/C6225414

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 2

2in = 7

3in = 10

HS= 1.506

VS= 1.735

GS= 2.063

CENTROID +

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.694	.604	.494
MINIMUM X	-.812	-.885	-.609
MAXIMUM Y	.797	.717	.605
MINIMUM Y	-.938	-1.018	-1.130
CENTROID X	.611	.701	.625
CENTROID Y	-.088	-.008	.104
POA TO CENTROID in.	.617	.701	.634
MIN RADIUS	.216	.096	.161
MEAN RADIUS	.754	.683	.621
MAX RADIUS	1.084	1.088	1.220
HORIZONTAL SPREAD	1.506	1.489	1.303
VERTICAL SPREAD	1.735	1.735	1.735
EXTREME SPREAD	2.063	2.063	2.038
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		10	

RECEIVING AND ESTIMATING REPORT

COMMENTS

ORDER

R 93-26581

INITIAL FPS	CUSTOMER ORDER NO. 8326	WOG 3 OF 7 M-24 ATTN: FRED MARTIN W/ADJUSTABLE RECOIL PAD			
DATE RECEIVED 12/09/93	DATE OPENED 12/09/93	DATE CODE DL 7-91	SERIAL NUMBER C6225414	NEW SERIAL NUMBER	MODEL AND GRADE 700 7.62 NATO
ACCESSORIES W/STUDS		SCOPE BASE			

FROM:

SHIP TO:

U. S. ARMY
THOMPSON, ALLAN R
CO. D 2ND BN. 1ST SWTG
FT BRAGG

NC 28307

U. S. ARMY
THOMPSON, ALLAN R
CO. D 2ND BN. 1ST SWTG
FT BRAGG NC
28307

CUST NO: 088383 C.O.D

ACCOUNT NUMBER	ACCOUNT NUMBER N/C	PROM. DATE	ESTIMATED	VIA DOOR
----------------	--------------------	------------	-----------	-------------

GUN CONDITION	REPAIR CHARGE
☐ NEW	EXCISE
☐ LIGHTLY WORN	TAX
☐ WORN	INSURANCE
☐ VERY WORN	UPS
☐ UNREPAIRABLE	PARCEL POST
☐ MARRED	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

Replace Barrel Assy

PARTS COMMENTS

Barrel Assy - 96003
Front Sight mounting Base - 96011

Re zinc - Scope Base & Swivel
Studs.
Repowder Coat - Floor plate, latch,
trigger Guard & Rear Sight Base.

W52 A09401 H229

REPAIRMAN Rw	PROOF ✓	CLEAN ✓	TEST ✓	TARGET ✓	PATTERN
GALLERY TESTER Rw	DATE 12/16/93	DATE 12/29/93	DATE 12/29/93	DATE 12/29/93	DATE

OFFICE COPY

RD6925 REV. 1/92

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

M2400088257

CONTRACT # DAAA21-87-C-0086

New Barrel

GUN SERIAL #

C6225414

OP. #	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and Stock		12/16/93	RW
600	Proof		12/16/93	RW
607	Check Headspace		12/16/93	RW
610	Dis-assemble Gun		12/16/93	RW
612	Magnaflux Barrel Action			
	Magnaflux Bolt			
615	Rollmark Caliber			
617	Drill and Tap Sight Holes			
618	Polish Barrel			
620	Apply Coatings (Barrel Action)			
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		12/28/93	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		12/28/93	RW
	C) Inspect Ejector Hole for Chamfer		12/28/93	RW
	D) Oil Firing Pin Ass'y		12/28/93	RW
	E) Adjust Trigger Pull to Min Setting and Stake		12/28/93	RW

op. #	OP. NAME	READINGS					DATE	INIT
5 cont.	F) Safety On Force							
	G) Safety Off Force							
	H) Trigger Pull Test & Retainability							
	I) Firing Pin Indent							
	J) Assemble Stock							
	K) Assemble Swivel Studs							
	L) Attach Front and Rear Sight Assemblies							
	M) Iron Sight Alignment							
	N) Detach Front & Rear Sights & place in numbered container							
	O) Attach Scope to Rifle							
	P) Detach & Attach Scope 20 Times							
640	Gallery Target & Test						12/29/93	RW
	A) Time							
	B) Malfunctions							
	C) Pierced Primers							
	D) Optical Clarity of Scope							
645	Inspect for Live Ammo						12/29/93	RW
655	Final Inspection							
	A) Headspace						1/3/94	RW
	B) Trigger Pull	2.71	2.70	2.60	2.64	2.63	1/3/94	RW
	C) Function						1/3/94	RW
660	Pack							

000000

5081

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # *C6225414*

OPERATION		DATE	INT
#	NAME		
575-580	ASSEMBLY	<i>2 26</i>	<i>FB</i>
600	PROOF	<i>29</i>	<i>Ru</i>
615	MAGNAFLUX BARREL	<i>5/13/88</i>	<i>Pfe</i>
	MAGNAFLUX BOLT	<i>5/13/88</i>	<i>Pfe.</i>
620	COATING	<i>8/14/82</i>	<i>JA</i>
625-630	FINAL ASSEMBLY		
635	TEST		
640	TARGET		
	FIRING PIN INDENT		
660	PACK		

SCOPE #
1171

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6225414

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		8/29/88	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/29/88	RW
	C) Inspect Ejector Hole for Chamfer		8/29/88	RW

OVER

OP.#		READINGS	DATE	INITIAL
625 cont.	D) Oil Firing Pin Ass'y		8/29/88	RW
	E) Adjust Trigger Pull to Min. Setting and Stake		29 Aug 88	JU + 92.8
	F) Safety on Force	4.25 5 4.75	29 Aug 88	JU + 92.8
	G) Safety off Force	3 3 3	29 Aug 88	JU + 92.8
	H) Trigger Pull Test & Retainability		29 Aug 88	JU + 92.8
	I) Firing Pin Indent	.023 .023 .023	29 Aug 88	JU + 92.8
	J) Assemble Stock		9/23/88	RW
	K) Assemble Swivel Studs		10-6-88	92.8
	L) Attach Front & Rear Sight Assemblies		9/23/88	RW
	M) Iron Sight Alignment		9/23/88	RW
	N) Detach Front & Rear Sights & place in numbered container		9/23/88	RW
	O) Attach Scope to Rifle		10/3/88	RW
	P) Detach & Attach Scope 20 times		10/3/88	JU
640	Gallery Target & Test	53 R 102 L	10/4/88	JES
	A) Optical Clarity of Scope		10/4/88	JU
645	Inspect for Live Ammo		10/4/88	JU
655	Final Inspection			
	A) Headspace		10-6-88	92.8
	B) Trigger Pull		10-6-88	92.8
	C) Function		10-6-88	92.8
660	Pack		10-20-88	92.8

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

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

SERIAL NO. C6225414

DATE 29 Aug 88

TESTER J. G. + R. S.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.68	2.66	2.56	2.73	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.61	2.63	2.70	2.39	
PULL #3	2.80	2.58	2.75	2.43	
PULL #4	2.56	2.69	2.80	2.54	
PULL #5	2.53	2.56	2.77	2.32	
TOTAL	13.18	13.12	13.58	12.41	
AVG.	2.636	2.624	2.716	2.48	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.10	3.15		
PULL #2	3.05	3.03		
PULL #3	3.11	3.07		
PULL #4	3.14	3.08		
PULL #5	3.18	3.10		
TOTAL	15.58	15.43		
AVG.	3.116	3.086		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.17	3.97	4.21	4.39
PULL #2	4.18	3.96	4.18	4.20
PULL #3	4.14	3.95	4.22	4.25
PULL #4	4.12	4.02	4.26	4.19
PULL #5	4.10	4.01	4.23	4.27
TOTAL	20.71	19.81	21.10	21.30
AVG.	4.142	3.962	4.22	4.26

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6225414

CENTROIDAL DISTANCES

0 TO	1	2.35501
1 TO	2	1.21228
1 TO	3	.292308
1 TO	4	.764477
1 TO	5	1.44244

+ <----POI
2
+ 3 1
5

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: 1.0148
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -1.6224
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: 1.91364

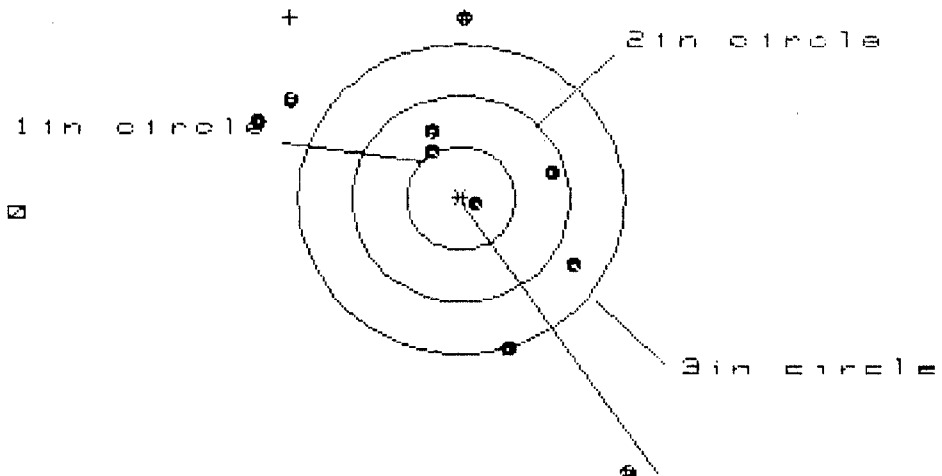
THE AMR FOR THIS RIFLE IS: 1.303

5 Oct 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C6225414

CENTERFIRE PATTERNS # 1

POA



OF SHOTS - 10

IN CIR

1in - 1

2in - 4

3in - 5

HS - 3.349

VS - 4.375

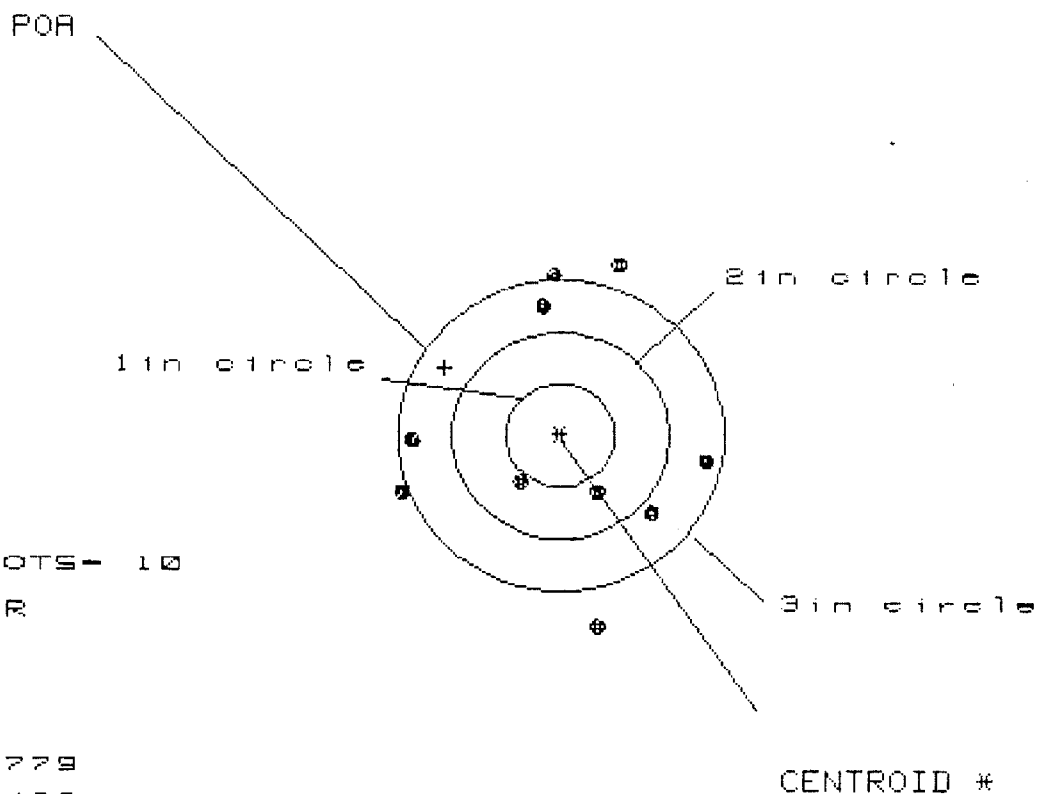
GS - 4.768

PATTERN #	:	1	2	3
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.514	1.251	1.042
MINIMUM X	:	-1.835	-1.666	-1.601
MAXIMUM Y	:	1.747	1.455	1.514
MINIMUM Y	:	-2.628	-1.740	-1.681
CENTROID X	:	1.567	1.398	1.607
CENTROID Y	:	-1.758	-1.466	-1.525
POA TO CENTROID in.	:	2.355	2.026	2.215
MIN RADIUS	:	.129	.195	.323
MEAN RADIUS	:	1.357	1.127	1.046
MAX RADIUS	:	3.033	1.853	1.768
HORIZONTAL SPREAD	:	3.349	2.917	2.643
VERTICAL SPREAD	:	4.375	3.195	3.195
EXTREME SPREAD	:	4.768	3.236	3.221
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	4		
NUMBER IN THREE INCH CIRCLE	=	5		

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FILE: \PATTERNING\CENTERFIRE_PATT\CG225414

CENTERFIRE PATTERNS # 2



OF SHOTS - 10

IN CIR

1in = 0

2in = 2

3in = 6

HS = 2.779

VS = 3.489

GS = 3.496

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.335	1.374	1.451
MINIMUM X	:	-1.444	-1.405	-1.328
MAXIMUM Y	:	1.667	1.465	1.575
MINIMUM Y	:	-1.821	-0.965	-0.782
CENTROID X	:	1.064	1.025	0.948
CENTROID Y	:	-0.655	-0.452	-0.635
POA TO CENTROID in.	:	1.249	1.120	1.141
MIN RADIUS	:	0.595	0.742	0.544
MEAN RADIUS	:	1.314	1.260	1.189
MAX RADIUS	:	1.856	1.604	1.576
HORIZONTAL SPREAD	:	2.779	2.779	2.779
VERTICAL SPREAD	:	3.489	2.430	2.357
EXTREME SPREAD	:	3.496	3.017	2.796
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		2	
NUMBER IN THREE INCH CIRCLE	=		6	

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FILE:/PATTERNING/CENTERFIRE_PATT/C6225414

CENTERFIRE PATTERNS # 3

POA

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 2

2 in = 5

3 in = 8

HS= 2.911

VS= 2.612

GS= 3.525

CENTROID *

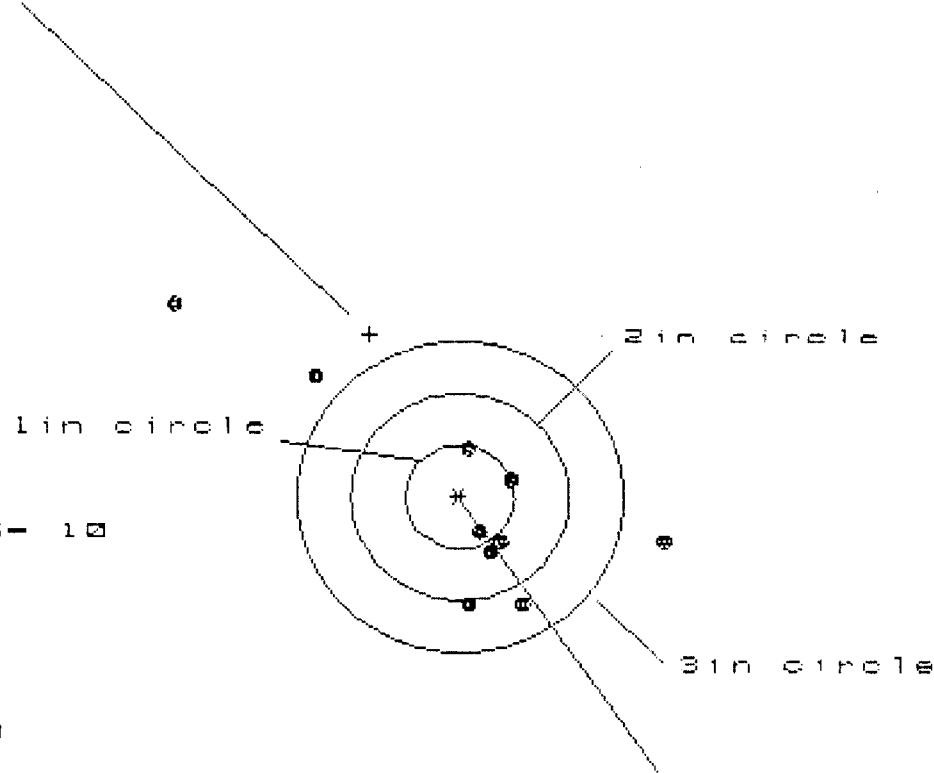
PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.999	.787	.567
MINIMUM X	:	-1.912	-1.758	-.417
MAXIMUM Y	:	1.257	1.361	1.205
MINIMUM Y	:	-1.355	-1.251	-1.176
CENTROID X	:	1.297	1.509	1.729
CENTROID Y	:	-1.646	-1.750	-1.594
POA TO CENTROID in.	:	2.096	2.311	2.352
MIN RADIUS	:	.400	.248	.448
MEAN RADIUS	:	1.151	.995	.834
MAX RADIUS	:	2.129	2.158	1.285
HORIZONTAL SPREAD	:	2.911	2.545	.984
VERTICAL SPREAD	:	2.612	2.612	2.381
EXTREME SPREAD	:	3.525	3.082	2.531
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS # 4

POA



OF SHOTS - 10

IN CIR

1in = 2

2in = 6

3in = 7

HS = 4.509

VS = 2.881

GS = 5.050

CENTROID #

PATTERN #	:	4	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.870	1.577	.474
MINIMUM X	:	-2.639	-1.630	-1.433
MAXIMUM Y	:	1.868	1.344	1.319
MINIMUM Y	:	-1.013	-.806	-.831
CENTROID X	:	.826	1.119	.922
CENTROID Y	:	-1.570	-1.777	-1.752
POA TO CENTROID in.	:	1.774	2.100	1.980
MIN RADIUS	:	.378	.124	.175
MEAN RADIUS	:	1.163	.803	.733
MAX RADIUS	:	3.233	2.113	1.948
HORIZONTAL SPREAD	:	4.509	3.207	1.907
VERTICAL SPREAD	:	2.881	2.150	2.150
EXTREME SPREAD	:	5.050	3.559	2.874
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	6		
NUMBER IN THREE INCH CIRCLE	=	7		

5 Oct 1988

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CENTERFIRE PATTERNS # 5

POA

OF SHOTS TO TARGET =

IN CIR

1 in = 1

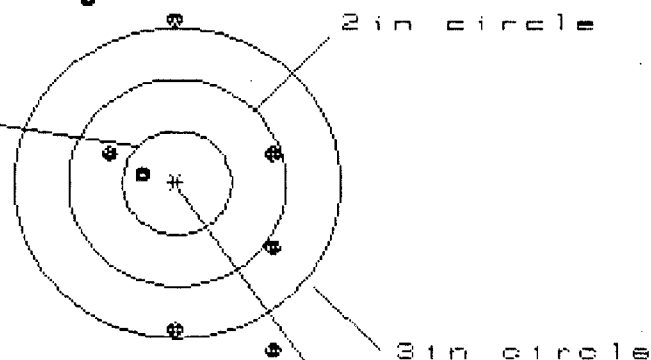
2 in = 3

3 in = 5

HS= 3.802

VS= 3.854

GS= 5.395



PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.499	1.243	1.806
MINIMUM X	:	-2.303	-1.119	-1.963
MAXIMUM Y	:	1.792	1.989	1.755
MINIMUM Y	:	-2.062	-1.865	-1.671
CENTROID X	:	.320	.576	.420
CENTROID Y	:	-2.483	-2.680	-2.446
POA TO CENTROID in.	:	2.504	2.741	2.482
MIN RADIUS	:	.320	.624	.417
MEAN RADIUS	:	1.531	1.372	1.235
MAX RADIUS	:	2.902	2.282	2.002
HORIZONTAL SPREAD	:	3.802	2.362	1.769
VERTICAL SPREAD	:	3.854	3.854	3.426
EXTREME SPREAD	:	5.395	4.520	3.856
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		5	

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C 6225414

OP. #	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and Stock		JUL 29 1991	RW
600	Proof		JUL 29 1991	RW
607	Check Headspace		JUL 29 1991	RW
610	Dis-assemble Gun		JUL 29 1991	RW
612	Magnaflux Barrel Action		JUL 30 1991	KCR
	Magnaflux Bolt		JUL 30 1991	KCR
615	Rollmark Caliber		JUL 30 1991	CS
617	Drill and Tap Sight Holes		JUL 30 1991	FB
618	Polish Barrel		JUL 31 1991	WB
620	Apply Coatings (Barrel Action)		AUG 1 1991	TJA
	Apply Coating (Bolt)		AUG 1 1991	TJA
625	Final Assembly A) Clean inside of Bolt Assembly			
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head			
	C) Inspect Ejector Hole for Chamfer			
	D) Oil Firing Pin Ass'y			
	E) Adjust Trigger Pull to Min Setting and Stake			

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force							
	G) Safety Off Force							
	H) Trigger Pull Test & Retainability							
	I) Firing Pin Indent							
	J) Assemble Stock							
	K) Assemble Swivel Studs						9-25-91	DH
	L) Attach Front and Rear Sight Assemblies							
	M) Iron Sight Alignment							
	N) Detach Front & Rear Sights & place in numbered container							
	O) Attach Scope to Rifle							
	P) Detach & Attach Scope 20 Times							
640	Gallery Target & Test						9/23/91	GT
	A) Time						"	1-4
	B) Malfunctions						"	1-4
	C) Pierced Primers						"	1-4
	D) Optical Clarity of Scope						"	1-4
645	Inspect for Live Ammo						9/23/91	1-4
655	Final Inspection							
	A) Headspace						9-25-91	DH
	B) Trigger Pull	2.54	2.59	2.71	2.58	2.63	9/24/91	94
	C) Function						9-25-91	DH
660	Pack						9/25/91	WB

RECEIVING AND ESTIMATING REPORT

CUST NO: 046771 C.O.D

COMMENTS
M-24 SNIPER

INITIAL
JJM

CUSTOMER ORDER NO.
006257

DATE RECEIVED
07/29/91

DATE OPENED
07/29/91

DATE CODE
KI 5-88

SERIAL NUMBER
C6225414

MODEL AND GRADE
700 7.62

NATO

ORDER
R 91-14516

ACCESSORIES
W/STUDS SCOPE BASE

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

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

ACCOUNT NUMBER

ACCOUNT NUMBER N/C

WRITE ☐

CLEAN/TEST

PROM. DATE

ESTIMATED

VIA

DOOR

REPAIR CHARGE

TAX

INSURANCE

UPS

PARCEL POST

TOTAL

GUN CONDITION:

☐ NEW

☐ SLIGHTLY WORN

☒ VERY WORN

☐ MISUSED

☐ MARRED

CUSTOMER'S REQUEST

- 1) NEW BARREL
- 2) RE POWDER CONT TRIGGER GUARD ASSY
- 3) CLEAN LINE CONTROL

MAIN FAULT

PARTS

REPAIRMAN
RW

PROOF
✓

CLEAN
KT

TEST
KT

TARGET
KT

PATTERN

GALLERY TESTER
KT

DATE
7/29/91

DATE
Sept 23

DATE
Sept 23

DATE
Sept 23

DATE

OFFICE COPY

RD6925 REV. 7/90

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

M2400088273