

G-6535242

Replaced

C-6611730

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6535242.___0
FILE DATE AND TIME: 06/15/2006 16:30

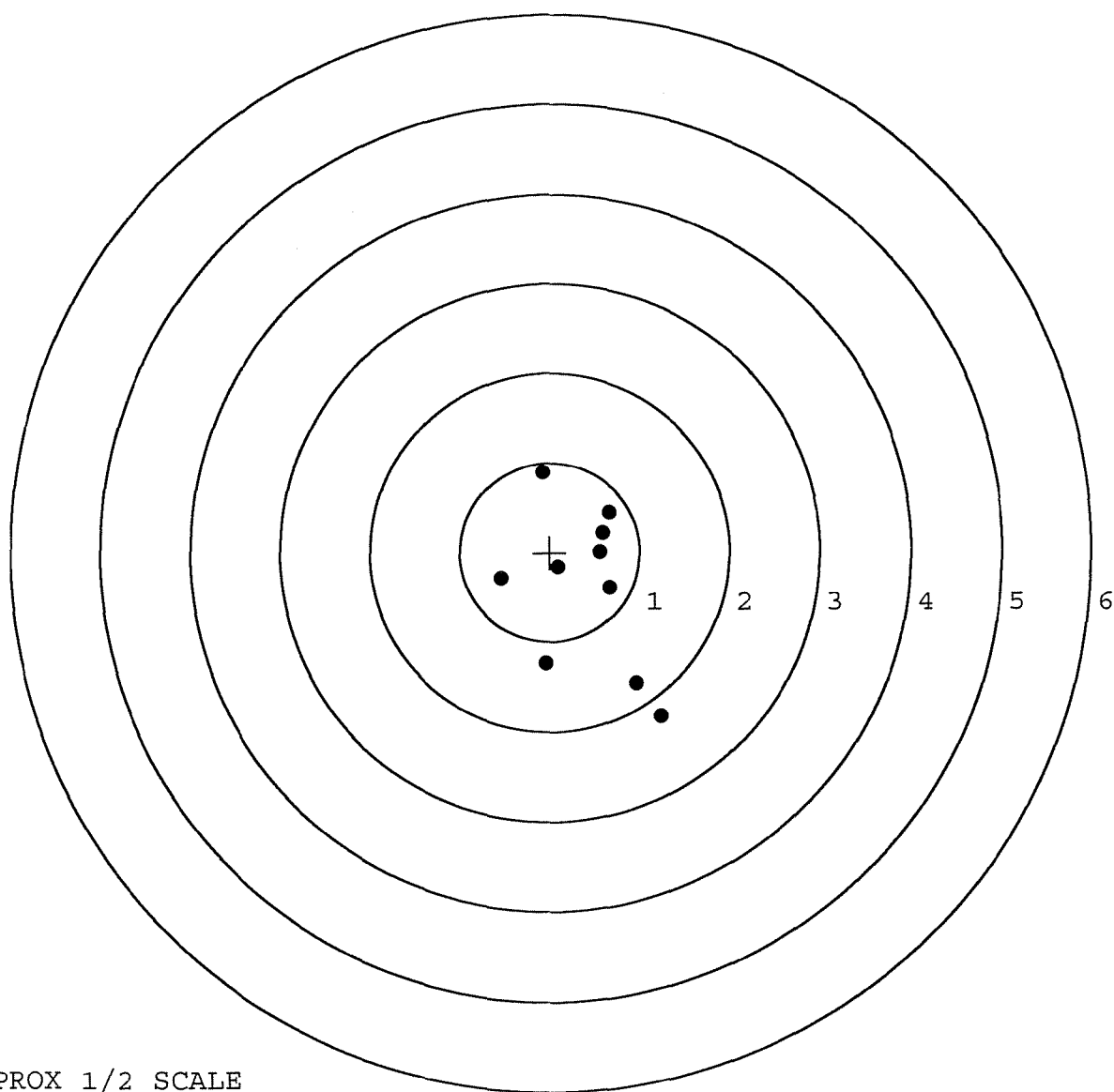
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.026
The Average Y Centroid of the Five Target Set:	-0.010
The Average Point of Impact of the Five Target Set:	0.028
The Average Mean Radius of the Five Target Set:	0.789
The Distance from POA to Centroid Target #1:	0.563
The Distance from Centroid Target #2 to Centroid Target #1:	0.847
The Distance from Centroid Target #3 to Centroid Target #1:	0.809
The Distance from Centroid Target #4 to Centroid Target #1:	0.569
The Distance from Centroid Target #5 to Centroid Target #1:	0.578

SERIAL NUMBER: G6535242.___0
TARGET NUMBER: 1
FILE DATE: 06/15/2006
FILE TIME: 16:30

X CENTROID: 0.411
Y CENTROID: -0.386
POA TO CENTROID: 0.563
HORZ SPREAD: 1.786
VERT SPREAD: 2.719
GROUP SPREAD: 3.027
MIN RADIUS: 0.262
MAX RADIUS: 1.665
MEAN RADIUS: 0.875
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 9

POINT#	X	Y
1:	-0.088	0.891
2:	0.664	0.452
3:	0.591	0.216
4:	0.559	-0.005
5:	-0.543	-0.299
6:	0.088	-0.173
7:	0.673	-0.394
8:	-0.049	-1.253
9:	0.970	-1.463
10:	1.243	-1.828



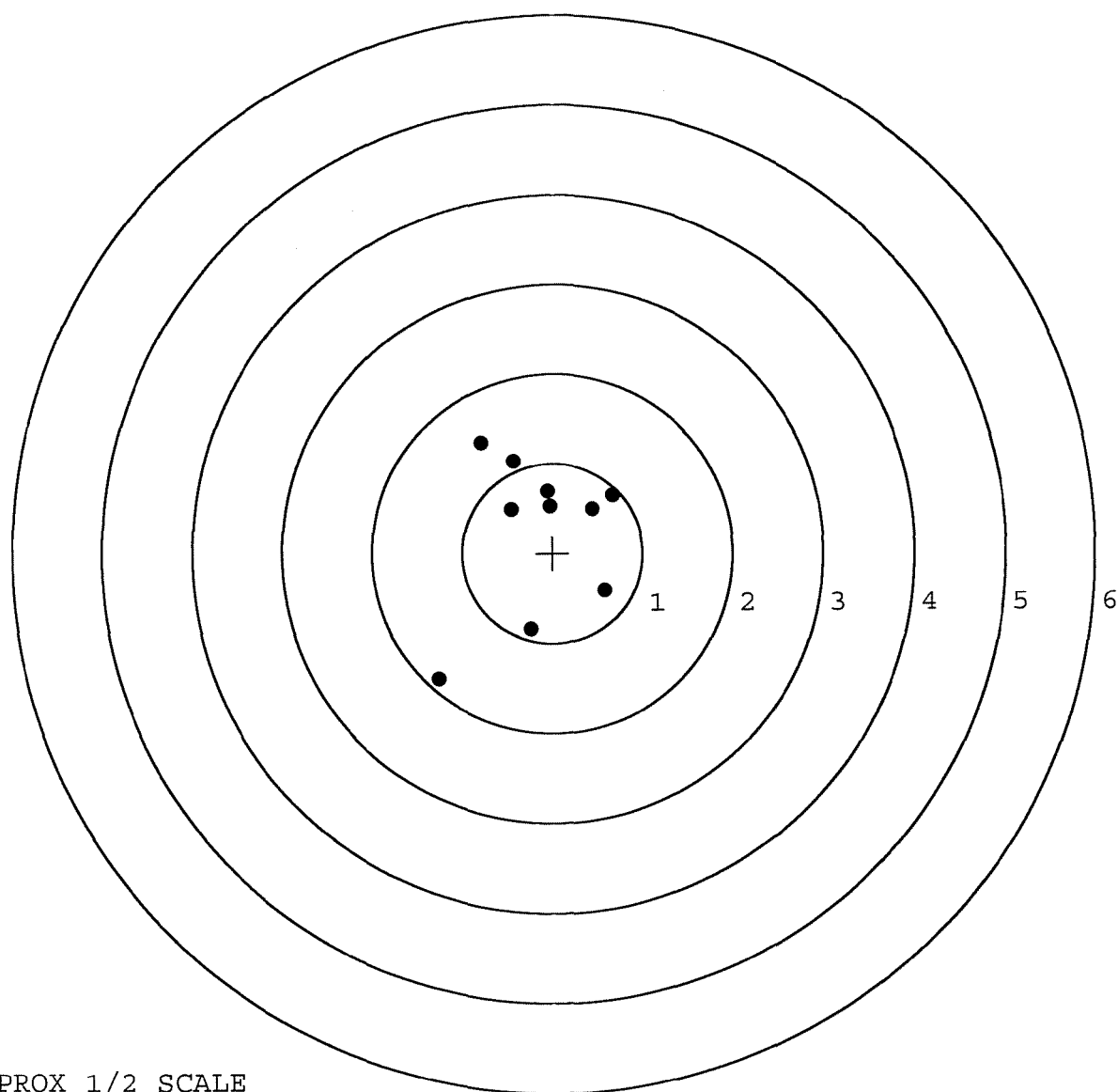
TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6535242.___0
TARGET NUMBER: 2
FILE DATE: 06/15/2006
FILE TIME: 16:30

X CENTROID: -0.160
Y CENTROID: 0.240
POA TO CENTROID: 0.288
HORZ SPREAD: 1.930
VERT SPREAD: 2.639
GROUP SPREAD: 2.817
MIN RADIUS: 0.305
MAX RADIUS: 1.981
MEAN RADIUS: 0.879

IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 9

POINT#	X	Y
1:	-0.788	1.233
2:	-0.437	1.023
3:	-0.461	0.482
4:	-0.061	0.680
5:	-0.037	0.519
6:	0.442	0.493
7:	0.667	0.646
8:	0.581	-0.420
9:	-0.247	-0.853
10:	-1.263	-1.406



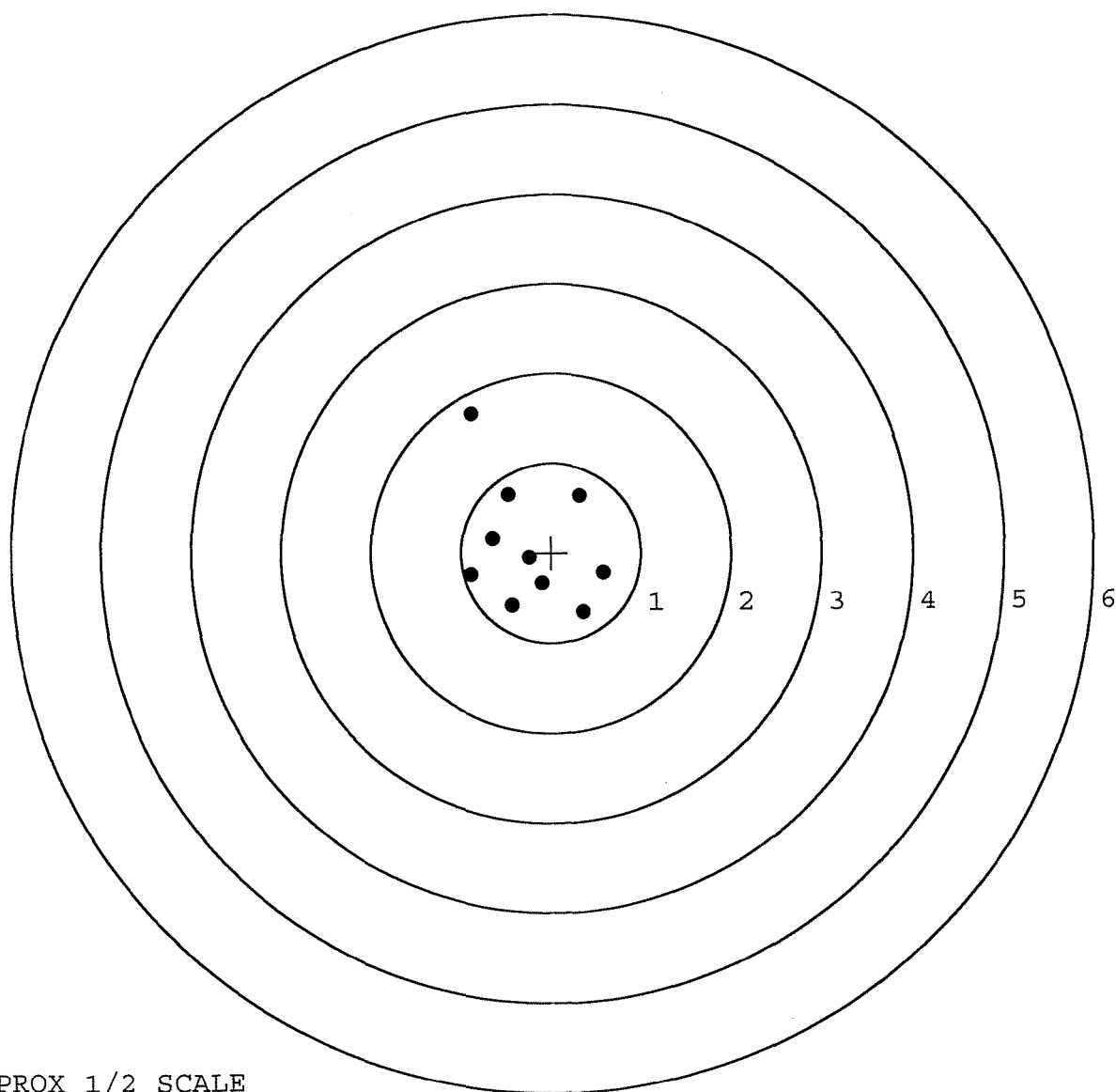
TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6535242. __0
TARGET NUMBER: 3
FILE DATE: 06/15/2006
FILE TIME: 16:30

X CENTROID: -0.245
Y CENTROID: 0.088
POA TO CENTROID: 0.261
HORZ SPREAD: 1.478
VERT SPREAD: 2.215
GROUP SPREAD: 2.543
MIN RADIUS: 0.145
MAX RADIUS: 1.598
MEAN RADIUS: 0.728

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

POINT#	X	Y
1:	-0.892	1.549
2:	-0.486	0.648
3:	0.317	0.638
4:	-0.647	0.165
5:	-0.888	-0.243
6:	-0.249	-0.057
7:	-0.445	-0.590
8:	-0.108	-0.343
9:	0.358	-0.666
10:	0.586	-0.225



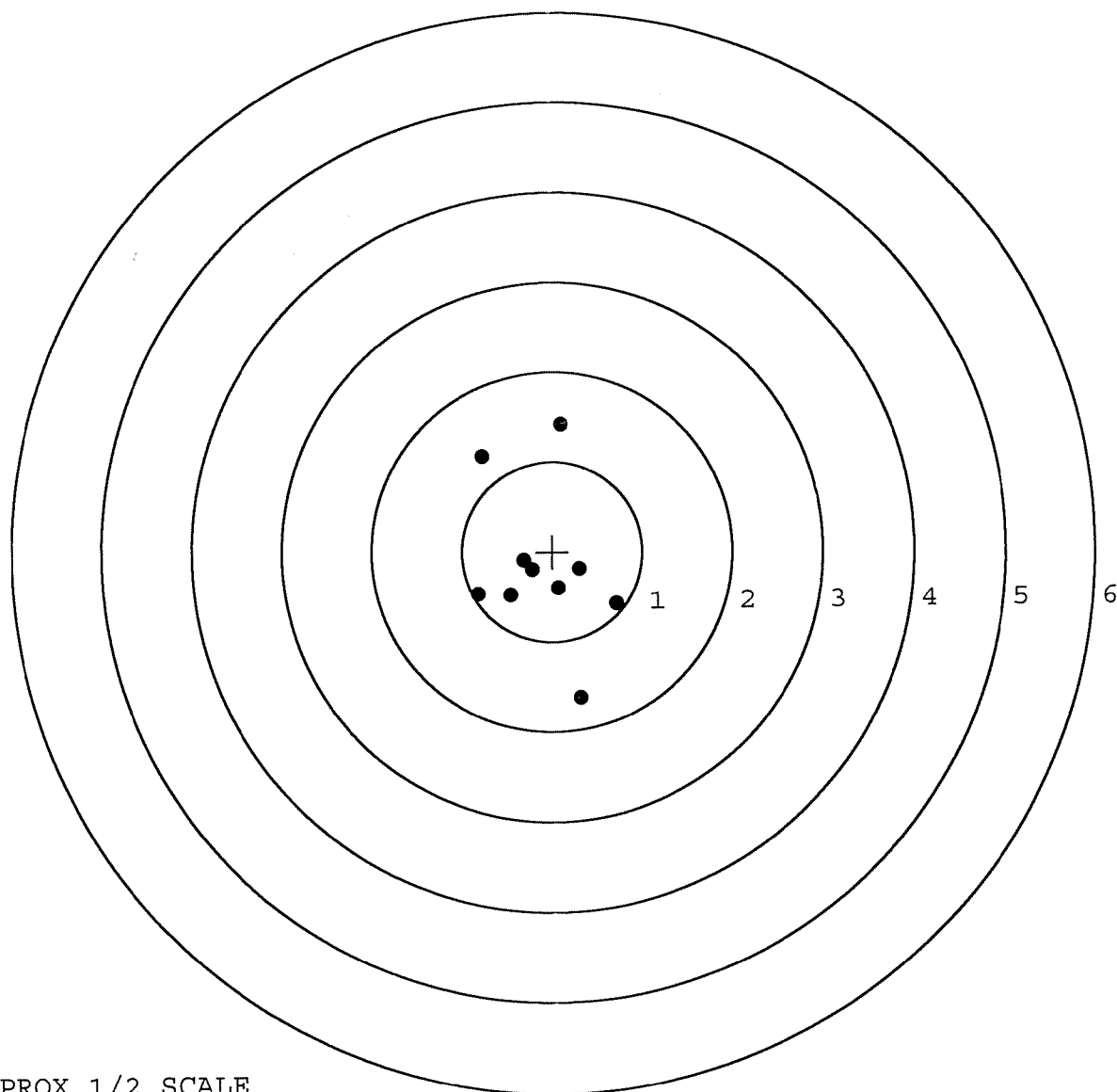
TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6535242. __0
TARGET NUMBER: 4
FILE DATE: 06/15/2006
FILE TIME: 16:30

X CENTROID: -0.112
Y CENTROID: -0.160
POA TO CENTROID: 0.195
HORZ SPREAD: 1.535
VERT SPREAD: 3.037
GROUP SPREAD: 3.044
MIN RADIUS: 0.123
MAX RADIUS: 1.582
MEAN RADIUS: 0.775

IN 1 IN DIAMETER: 5
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 8

POINT#	X	Y
1:	-0.769	1.062
2:	0.104	1.408
3:	-0.823	-0.471
4:	-0.472	-0.481
5:	-0.321	-0.095
6:	0.066	-0.407
7:	0.302	-0.194
8:	0.712	-0.586
9:	0.311	-1.629
10:	-0.227	-0.202

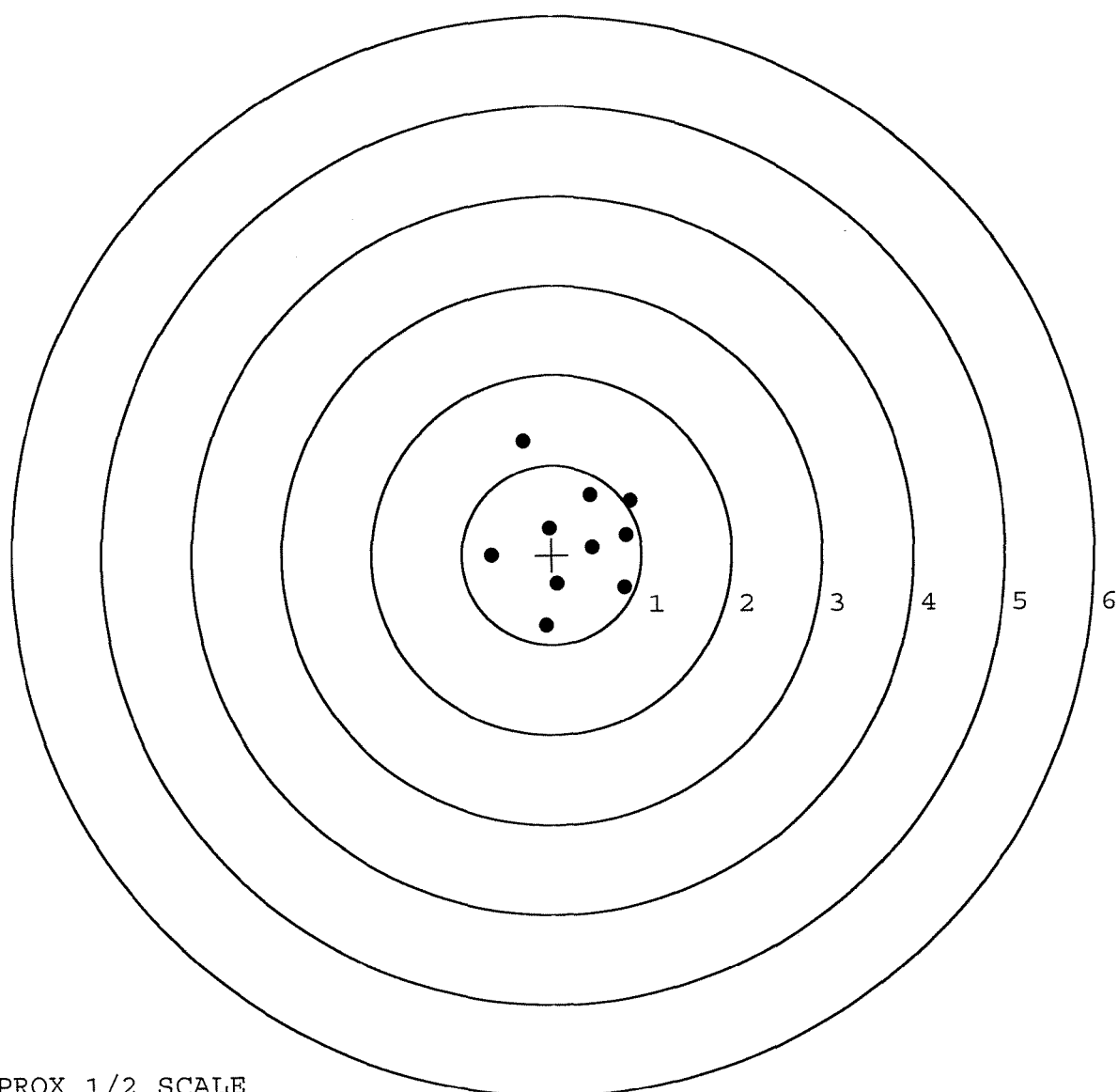


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6535242.___0
TARGET NUMBER: 5
FILE DATE: 06/15/2006
FILE TIME: 16:30

X CENTROID: 0.236
Y CENTROID: 0.166
POA TO CENTROID: 0.288
HORZ SPREAD: 1.539
VERT SPREAD: 2.062
GROUP SPREAD: 2.078
MIN RADIUS: 0.233
MAX RADIUS: 1.233
MEAN RADIUS: 0.690
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.322	1.265
2:	0.428	0.671
3:	0.872	0.603
4:	0.824	0.222
5:	0.456	0.089
6:	-0.035	0.295
7:	-0.667	-0.004
8:	0.058	-0.323
9:	0.813	-0.363
10:	-0.068	-0.797



TARGET APPROX 1/2 SCALE

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

10 of 10

R & E NUMBER	00113111		Markmanship Training Center	
SERIAL NUMBER	06611730		G6535242	
LOG-IN DATE	6-1-06			
OPERATION #	OPERATION NAME		DATE	INITIAL
500	DIS-ASSEMBLE GUN		6-5-06	A
505	RE-BARREL		6-6-06	A
560	ASSEMBLE		6-6-06	A
600	PROOF	MAGNA-FLUX	6-7-06	R.P.
605	CHECK HEADSPACE	INSPECTED	6-7-06	R.P.
610	DIS-ASSEMBLE GUN	JUN 19 2006	6-7-06	A
612	MAGNAFLUX	OPERATOR <u>APD</u>	6-9-06	APD
510	DRILL AND TAP		6-8-06	TRW
615	ROLLMARK CALIBER		6-9-06	CW
618	ROTO-BLAST		6-9-06	LB
620	APPLY COATINGS		6/13/06	RB
625	FINAL ASSEMBLY		6-14-06	A
640	FUNCTION TEST AND	PASS FAIL	6-15-06	R.P.D.
650	TARGET	PASS FAIL	6-15-06	R.P.D.
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
670	FINAL INSPECTION		6-14-06	mjh
	A) HEADSPACE	PASS FAIL	6-14-06	mjh
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS		
680	F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX	7 lbs. 7 lbs. 7 lbs. 6-14-06	mjh
	G) SAFETY OFF FORCE	2 LBS MIN	4 lbs. 4 lbs. 4 lbs. 6-14-06	mjh
	I) FIRING PIN INDENT	.020	-023 -023 -023 6-14-06	mjh
690	PACK		7-5-06	DA

Repair Number:	RE00068098	Serial: C6611730 Model 700 Center Fire Caliber: 7	Repairman:	
Verify Repair		62 NATO M/24 SWS	Status:	Closed 7/28/2003 11:16:28 AM

Address Information Customer: _____ Received From: _____ Name: <u>USPFO FOR ARK</u> Address 1: <u>CAMP J T ROBINSON</u> Address 2: _____ PO Box: _____ City: <u>NORTH LITTLE ROCK</u> State: <u>AR</u> Zip Code: <u>72119</u> Country: <u>US</u>	Return To: _____ Received From: _____ <u>USPFO FOR ARK</u> <u>CAMP J T ROBINSON</u> _____ PO Box: _____ <u>NORTH LITTLE ROCK</u> State: <u>AR</u> Zip Code: <u>72119</u> Country: <u>US</u>
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[illegible]

Shipping / Billing

Accessories Received

Comments:

Condition
Notes:

CSR
Notes:

Code	Desc	Qty
A007	With Stud	3
A017	Scope Base	1
C000	FRONT AND REAR B.	1

Repair Search

Refresh

Close

naqletj	7/28/2003	12:47 PM	CAPS	NUM	INS	SCRL
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Serial Number: C6611730
Model: 700



RE00068098

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

R & E NUMBER	68098		
SERIAL NUMBER	C6611730		
LOG-IN DATE	7-28-03		
INSPECT AND VERIFY:			
OPERATION #	OPERATION NAME	DATE	INITIAL
550	DIS-ASSEMBLE GUN	7-30-03	RTL
560 A	RE-BARREL	8-7-03	RTL
B	DRILL AND TAP	8-11-03	TRW
575	ASSEMBLE	8-11-03	RTL
600	PROOF	8-11-03	AC
605	CHECK HEADSPACE	8-11-03	AC
610	DIS-ASSEMBLE GUN	8-11-03	RTL
612	MAGNAFLUX		
615	ROLLMARK CALIBER	8-12-03	SB
618	ROTO-BLAST	8-13-03	JB
620	APPLY COATINGS	8-14	TA
625 A	FINAL ASSEMBLY		
B	TRIGGER PULL TEST		
C	SAFETY "ON" FORCE		
D	SAFETY "OFF" FORCE		
E	FIRING PIN INDENT		
640	TARGET	8-18-03	TRW
655	FINAL INSPECT	8-20-03	RTL
660	PACK	8-20-03	RTA
		SHIP DATE	
	QAR INSPECTION DATE		

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6611730.___0
FILE DATE AND TIME: 08/18/2003 06:38

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

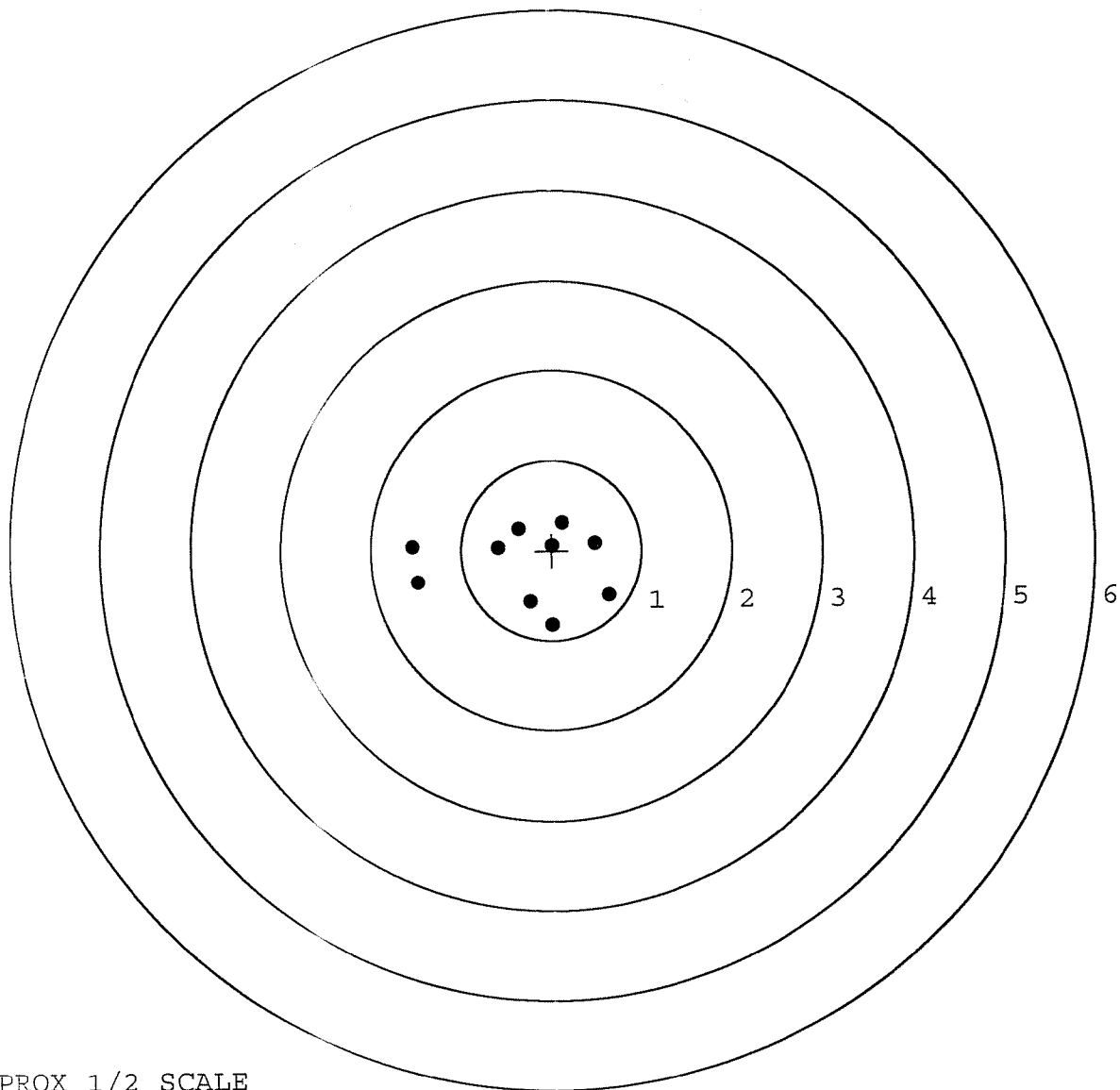
The Average X Centroid of the Five Target Set:	-0.069
The Average Y Centroid of the Five Target Set:	-0.111
The Average Point of Impact of the Five Target Set:	0.131
The Average Mean Radius of the Five Target Set:	0.602
The Distance from POA to Centroid Target #1:	0.334
The Distance from Centroid Target #2 to Centroid Target #1:	0.294
The Distance from Centroid Target #3 to Centroid Target #1:	0.284
The Distance from Centroid Target #4 to Centroid Target #1:	0.249
The Distance from Centroid Target #5 to Centroid Target #1:	0.365

SERIAL NUMBER: C6611730.___0
TARGET NUMBER: 1
FILE DATE: 08/18/2003
FILE TIME: 06:38

X CENTROID: -0.300
Y CENTROID: -0.147
POA TO CENTROID: 0.334
HORZ SPREAD: 2.182
VERT SPREAD: 1.141
GROUP SPREAD: 2.249
MIN RADIUS: 0.353
MAX RADIUS: 1.260
MEAN RADIUS: 0.719

IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.637	-0.496
2:	-0.004	-0.831
3:	-0.243	-0.572
4:	-1.483	-0.351
5:	-1.545	0.047
6:	-0.600	0.039
7:	-0.369	0.242
8:	0.005	0.056
9:	0.119	0.310
10:	0.486	0.085



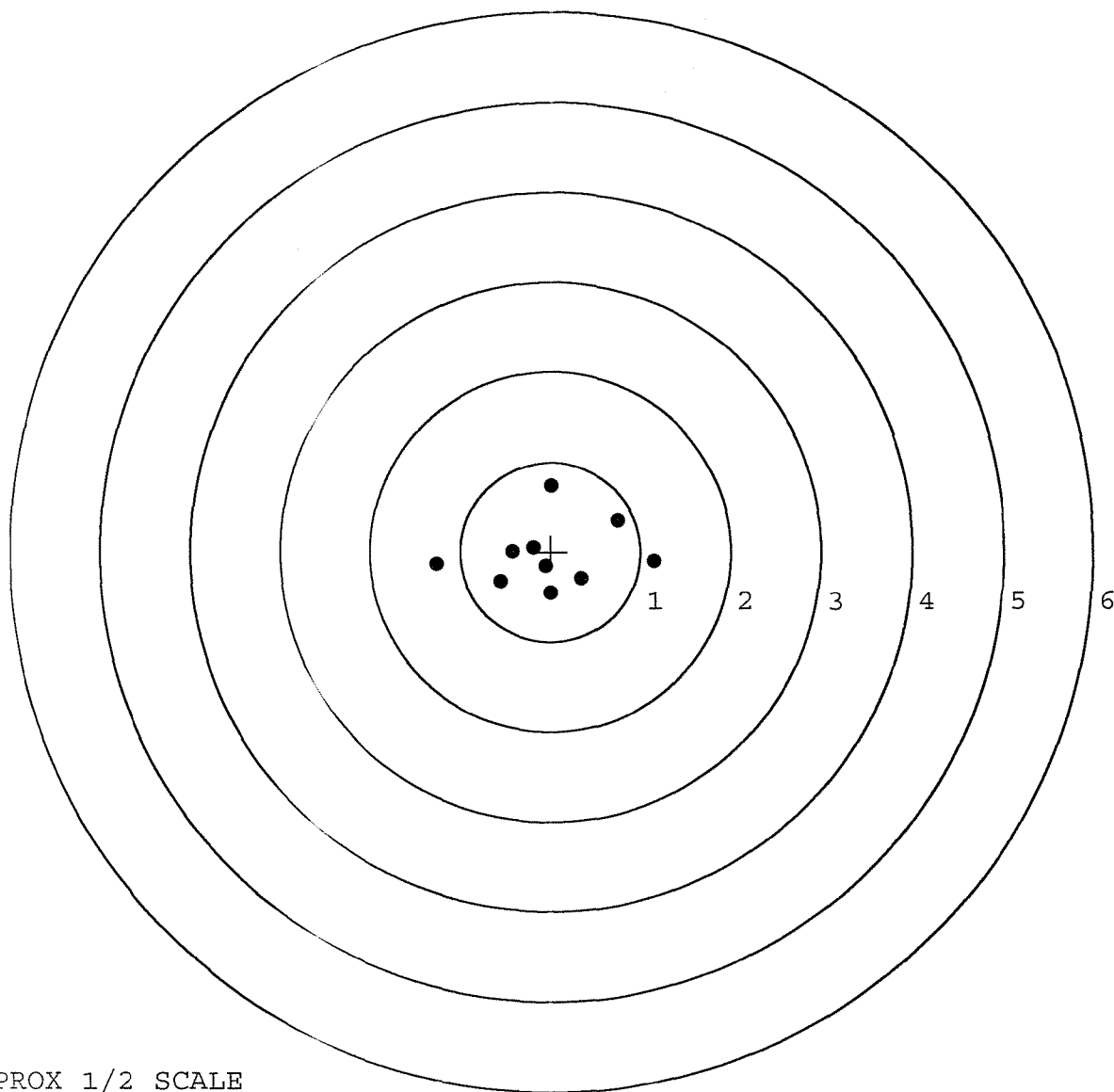
TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6611730. __0
 TARGET NUMBER: 2
 FILE DATE: 08/18/2003
 FILE TIME: 06:38

X CENTROID: -0.027
 Y CENTROID: -0.038
 POA TO CENTROID: 0.046
 HORZ SPREAD: 2.421
 VERT SPREAD: 1.204
 GROUP SPREAD: 2.421
 MIN RADIUS: 0.130
 MAX RADIUS: 1.249
 MEAN RADIUS: 0.630

IN 1 IN DIAMETER: 5
 # IN 2 IN DIAMETER: 8
 # in 3 IN DIAMETER: 10

POINT#	X	Y
1:	1.149	-0.110
2:	0.753	0.357
3:	-0.003	0.740
4:	0.346	-0.301
5:	0.006	-0.464
6:	-0.566	-0.337
7:	-1.272	-0.145
8:	-0.430	-0.002
9:	-0.194	0.049
10:	-0.061	-0.163



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6611730. 0

TARGET NUMBER: 3

FILE DATE: 08/18/2003

FILE TIME: 06:38

X CENTROID: -0.017

Y CENTROID: -0.179

POA TO CENTROID: 0.180

HORZ SPREAD: 1.621

VERT SPREAD: 1.535

GROUP SPREAD: 1.849

MIN RADIUS: 0.095

MAX RADIUS: 1.017

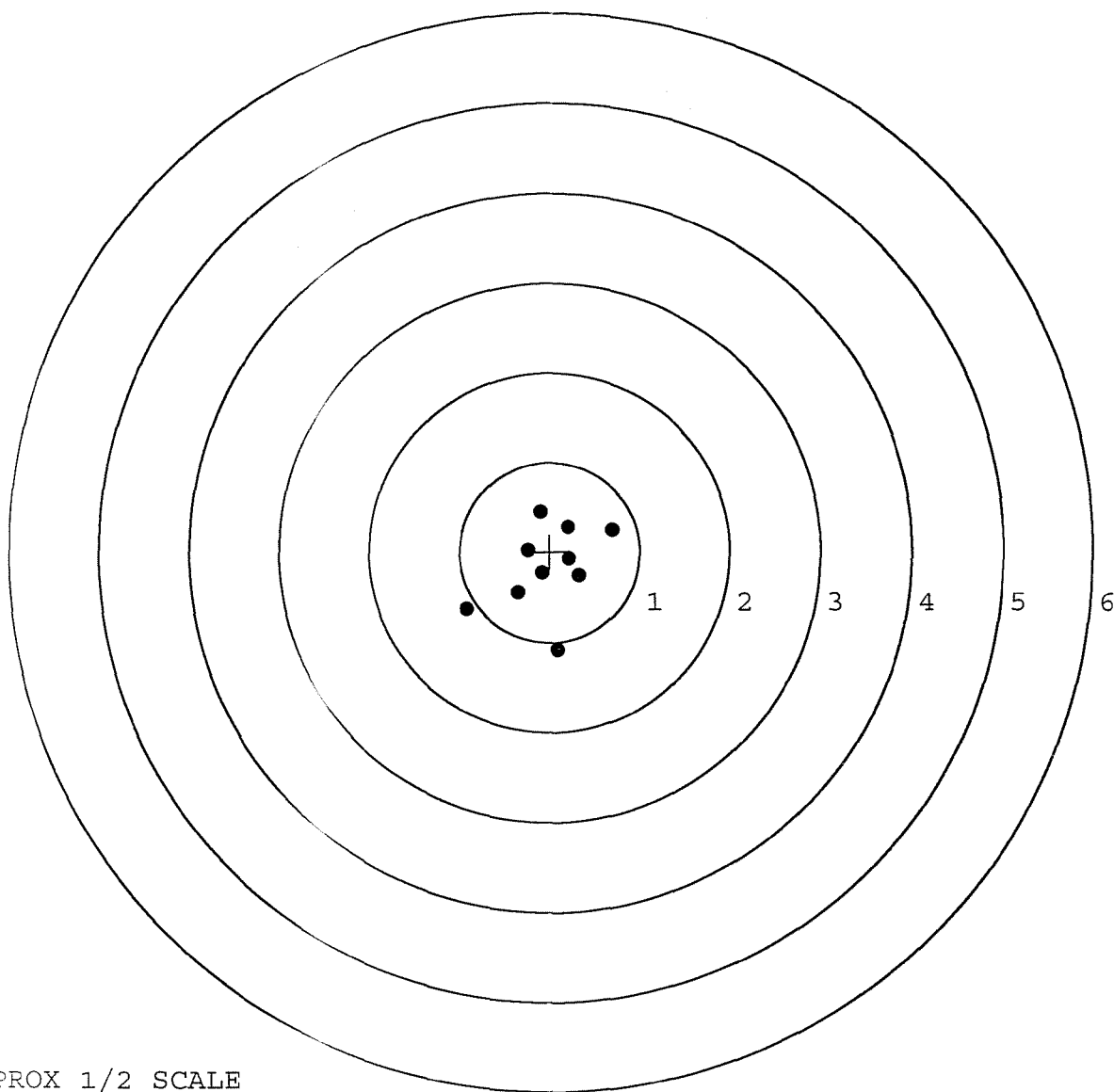
MEAN RADIUS: 0.535

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.092	-1.090
2:	-0.922	-0.643
3:	-0.354	-0.456
4:	0.333	-0.261
5:	0.699	0.247
6:	-0.111	0.445
7:	0.203	0.274
8:	-0.241	0.020
9:	0.218	-0.084
10:	-0.091	-0.239



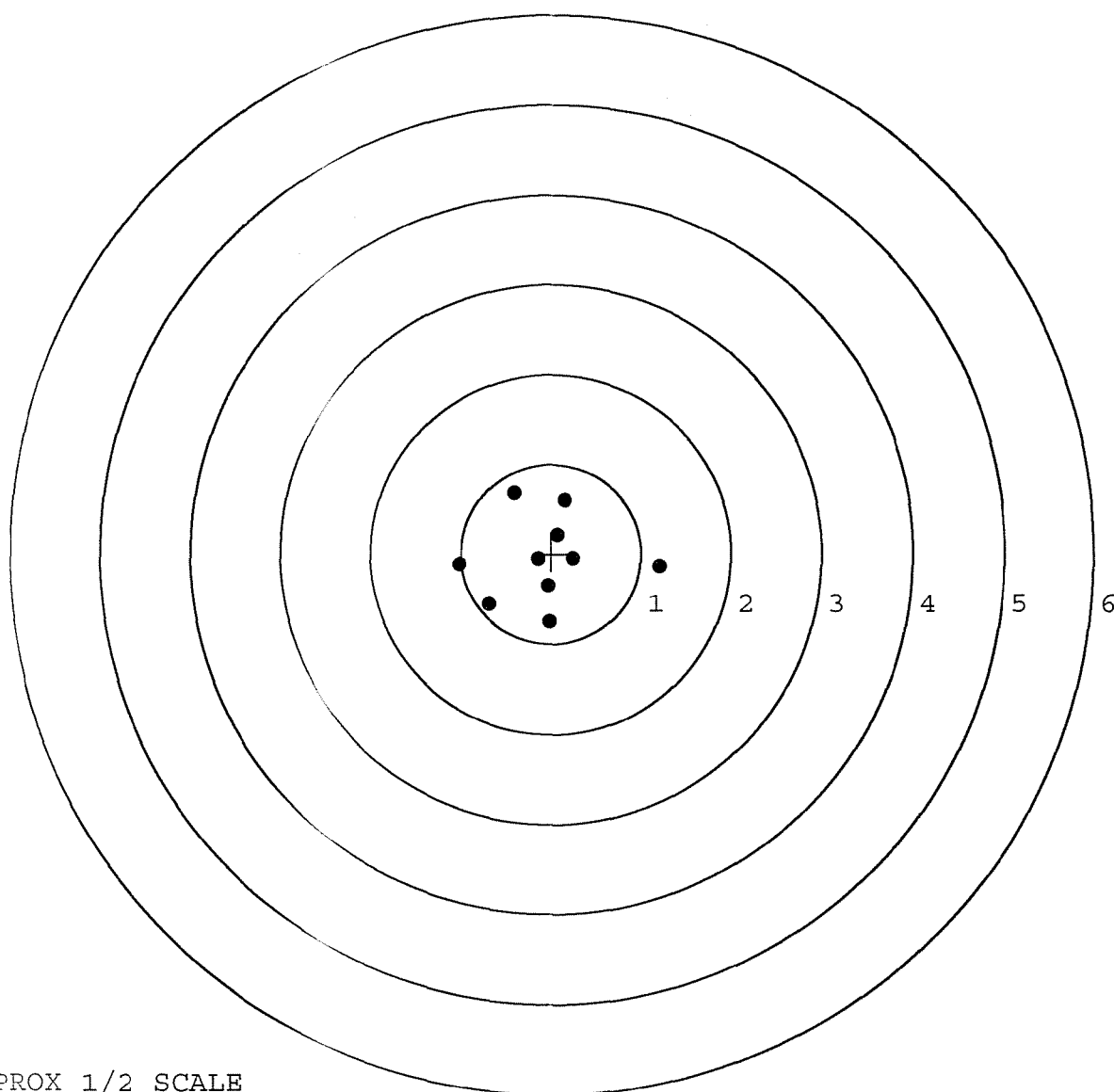
TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6611730. __0
TARGET NUMBER: 4
FILE DATE: 08/18/2003
FILE TIME: 06:38

X CENTROID: -0.067
Y CENTROID: -0.058
POA TO CENTROID: 0.089
HORZ SPREAD: 2.221
VERT SPREAD: 1.435
GROUP SPREAD: 2.221
MIN RADIUS: 0.081
MAX RADIUS: 1.276
MEAN RADIUS: 0.623

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

POINT#	X	Y
1:	1.207	-0.143
2:	-0.025	-0.760
3:	-0.688	-0.565
4:	-1.014	-0.122
5:	-0.418	0.675
6:	0.147	0.598
7:	0.243	-0.055
8:	0.069	0.207
9:	-0.147	-0.055
10:	-0.039	-0.364



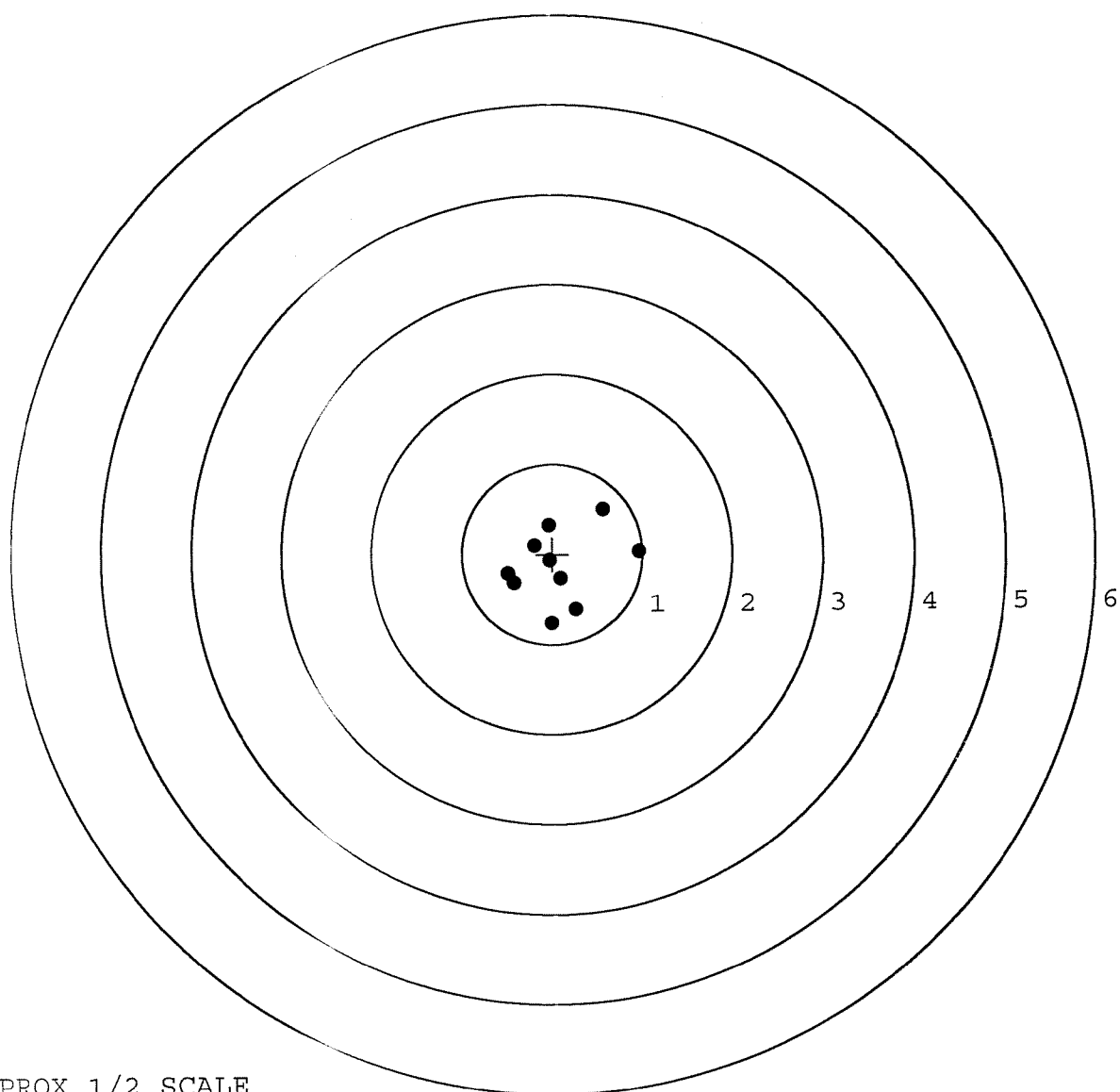
TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6611730. __0
TARGET NUMBER: 5
FILE DATE: 08/18/2003
FILE TIME: 06:38

X CENTROID: 0.065
Y CENTROID: -0.132
POA TO CENTROID: 0.148
HORZ SPREAD: 1.462
VERT SPREAD: 1.260
GROUP SPREAD: 1.482
MIN RADIUS: 0.121
MAX RADIUS: 0.913
MEAN RADIUS: 0.506

POINT#	X	Y
1:	0.266	-0.614
2:	-0.020	-0.772
3:	-0.499	-0.212
4:	0.963	0.033
5:	0.569	0.488
6:	0.093	-0.273
7:	-0.430	-0.316
8:	-0.045	0.317
9:	-0.205	0.096
10:	-0.038	-0.070

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



TARGET APPROX 1/2 SCALE

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

SERIAL # C6611730 INSPECTED BY: RTL

DATE REC'D: 7-28-03 DATE RET'D: 8-20-03

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:

Remington		 REG. U.S. PAT. & TM. OFF.	VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.
MODEL 700TM H24			SERIAL NO. C6611730
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat & Tm. Off, Marca Registrada Marque Deposee.		20	ORDER NO. 5716



5716 C6611730

UPC



0 47700 25716 7

CONTRACT # DAAA21-7-C-0086

GUN SERIAL # C6611730

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	1 10 91		Rw
600	Proof	1 10 91		Rw
607	Check Headspace	1 10 91		Rw
610	Dis-assemble Gun	1 10 91		Rw
612	Magnaflux Barrel Action		1/16/91	KR
	Magnaflux Bolt		11	KR
615	Rollmark Caliber		11	JS.
617	Drill and Tap Sight Holes	1 17 91		LB
618	Polish Barrel	1 17 91		WB
620	Apply Coatings (Barrel Action)		2/18/91	DA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		3/6/91	Rw
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		3/6/91	Rw
	C) Inspect Ejector Hole for Chamfer		3/6/91	Rw
	D) Oil Firing Pin Ass'y		3/6/91	Rw
	E) Adjust Trigger Pull to Min Setting and Stake		3/8/91	JS.

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			3/8/91	WB
	G) Safety Off Force	2 1/2	2 1/2	2 1/2			3/8/91	WB
	H) Trigger Pull Test & Retainability						3/8/91	MF
	I) Firing Pin Indent	.023	.023	.023			3/8/91	WB
	J) Assemble Stock						4/4/91	RW
	K) Assemble Swivel Studs						4-8-91	D/H
	L) Attach Front and Rear Sight Assemblies						4/4/91	RW
	M) Iron Sight Alignment						4/4/91	RW
	N) Detach Front & Rear Sights & place in numbered container						4/4/91	RW
	O) Attach Scope to Rifle						4/4/91	RW
	P) Detach & Attach Scope 20 Times						4/4/91	RW
640	Gallery Target & Test						4-5-91	D/H
	A) Time						4-5-91	D/H
	B) Malfunctions						4-5-91	D/H
	C) Pierced Primers						4-5-91	D/H
	D) Optical Clarity of Scope						4-5-91	D/H
645	Inspect for Live Ammo						4-5-91	D/H
655	Final Inspection						4-8-91	D/H
	A) Headspace						4-8-91	D/H
	B) Trigger Pull	2.23	2.20	2.15	2.20	2.20	4/8/91	MF
	C) Function						4-8-91	D/H
660	Pack						6-19-91	RF

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

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

SERIAL NO. C6611730

DATE 3-8-91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.37	2.24	2-30	2.23	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.26	2.23	2-28	2.20	
PULL #3	2.29	2.22	2-34	2.15	
PULL #4	2.22	2.34	2-30	2.20	
PULL #5	2.27	2.35	2-30	2.20	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.40	3.39		
PULL #2	3.37	3.42		
PULL #3	3.19	3.22		
PULL #4	3.29	3.34		
PULL #5	3.41	3.39		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.27	4.40		4.17
PULL #2	4.11	4.41		4.40
PULL #3	4.19	4.39		4.40
PULL #4	4.44	4.35		4.40
PULL #5	4.24	4.41		4.33
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611730
5 Apr 1991

CENTROIDAL DISTANCES

0 TO	1	.129757
1 TO	2	.0733757
1 TO	3	.149883
1 TO	4	.390386
1 TO	5	.127142

←----FOR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0258
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0506
THE AVERAGE AVERAGE RADIUS FOR THIS RIFLE IS: .0567979
THE AVERAGE THIS RIFLE IS: .9826

5 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8611730

CENTERFIRE PATTERNS # 1

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 0

2in = 6

3in = 10

HS= 2.120

VS= 1.990

GS= 2.415

CENTROID *

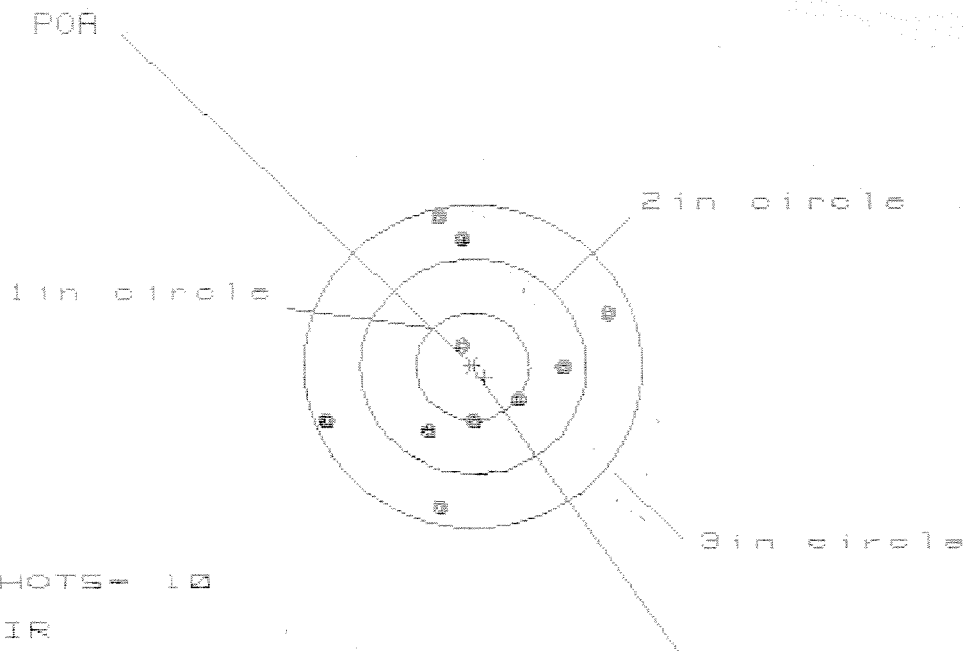
PATTERN #

SHOTS (BEST OF)	10	9	8
MAXIMUM X	.962	1.044	1.021
MINIMUM X	-1.158	-1.076	-1.099
MAXIMUM Y	1.199	1.325	.865
MINIMUM Y	-.791	-.665	-.500
CENTROID X	-.031	-.113	-.090
CENTROID Y	.126	.000	-.165
POA TO CENTROID in.	.130	.113	.188
MIN RADIUS	.593	.445	.359
MEAN RADIUS	.943	.877	.796
MAX RADIUS	1.351	1.337	1.102
HORIZONTAL SPREAD	2.120	2.120	2.120
VERTICAL SPREAD	1.990	1.990	1.365
EXTREME SPREAD	2.415	2.149	2.128
NUMBER IN ONE INCH CIRCLE =		0	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		10	

5 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8611730

CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1in = 1

2in = 5

3in = 10

HS = 2.485

VS = 2.767

GS = 2.767

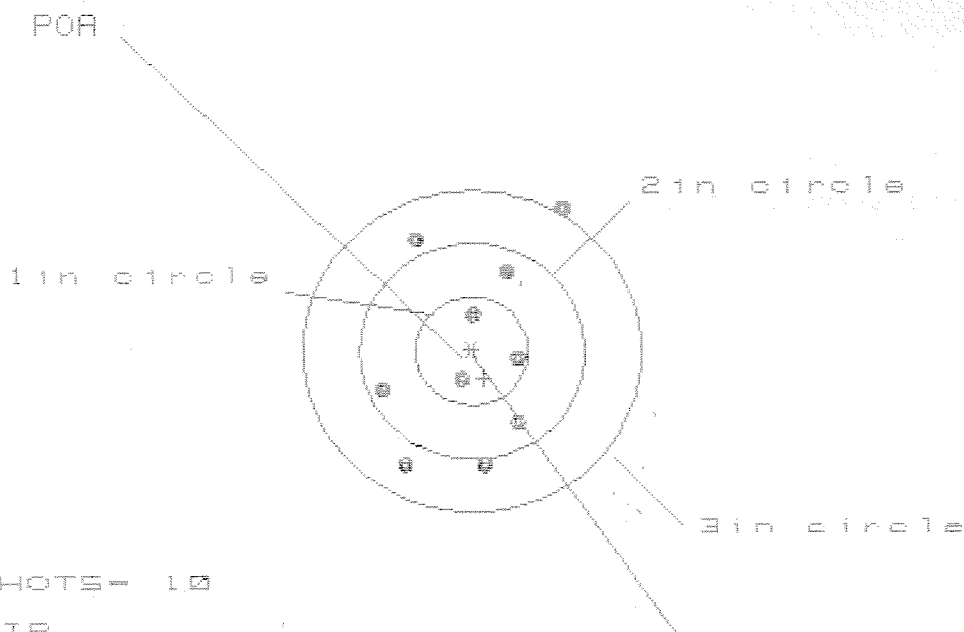
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.206	1.172	1.129
MINIMUM X	:	-1.279	-1.313	-1.356
MAXIMUM Y	:	1.437	1.340	1.194
MINIMUM Y	:	-1.330	-1.170	-.603
CENTROID X	:	-.101	-.067	-.024
CENTROID Y	:	.104	-.056	.090
POA TO CENTROID in.	:	.145	.088	.093
MIN RADIUS	:	.222	.348	.270
MEAN RADIUS	:	.953	.874	.831
MAX RADIUS	:	1.469	1.348	1.430
HORIZONTAL SPREAD	:	2.485	2.485	2.485
VERTICAL SPREAD	:	2.767	2.510	1.797
EXTREME SPREAD	:	2.767	2.653	2.653
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		10	

5 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8611730

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in - 3

2in - 5

3in - 9

HS= 1.673

VS= 2.389

GS= 2.782

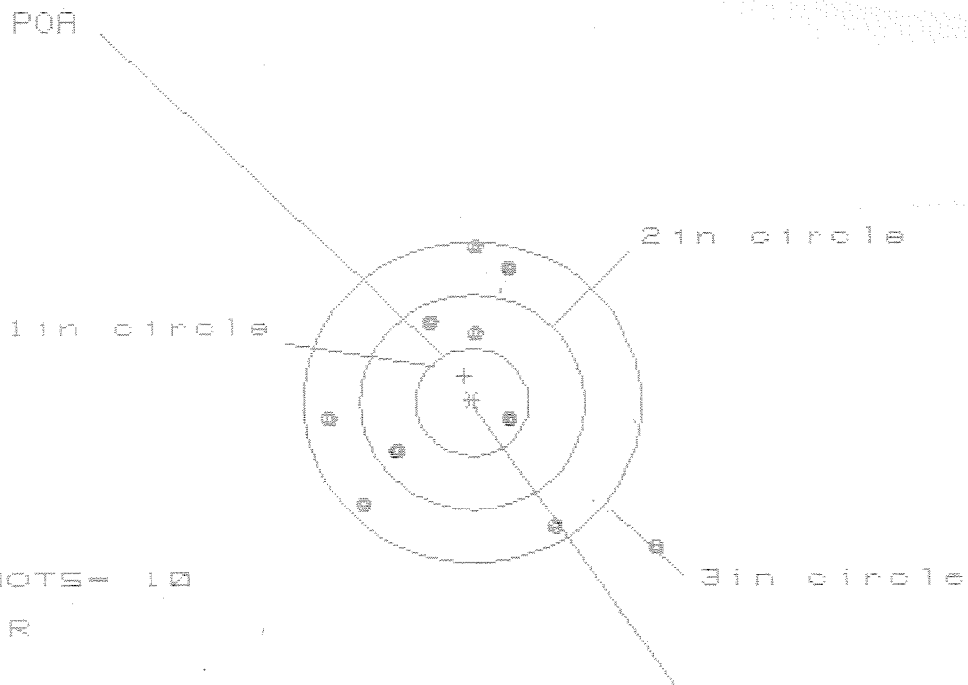
CENTROID *

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.831	.517	.454
MINIMUM X	:	-.842	-.750	-.813
MAXIMUM Y	:	1.294	1.232	1.114
MINIMUM Y	:	-1.095	-.951	-1.000
CENTROID X	:	-.102	-.194	-.131
CENTROID Y	:	.258	.114	.233
POA TO CENTROID in.	:	.277	.225	.267
MIN RADIUS	:	.322	.157	.288
MEAN RADIUS	:	.869	.779	.739
MAX RADIUS	:	1.538	1.293	1.202
HORIZONTAL SPREAD	:	1.673	1.267	1.267
VERTICAL SPREAD	:	2.389	2.183	2.113
EXTREME SPREAD	:	2.782	2.187	2.187
NUMBER IN ONE INCH CIRCLE =			3	
NUMBER IN TWO INCH CIRCLE =			6	
NUMBER IN THREE INCH CIRCLE =			9	

5 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611730

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 1

2in = 4

3in = 9

HS= 2.861

VS= 2.774

GS= 3.194

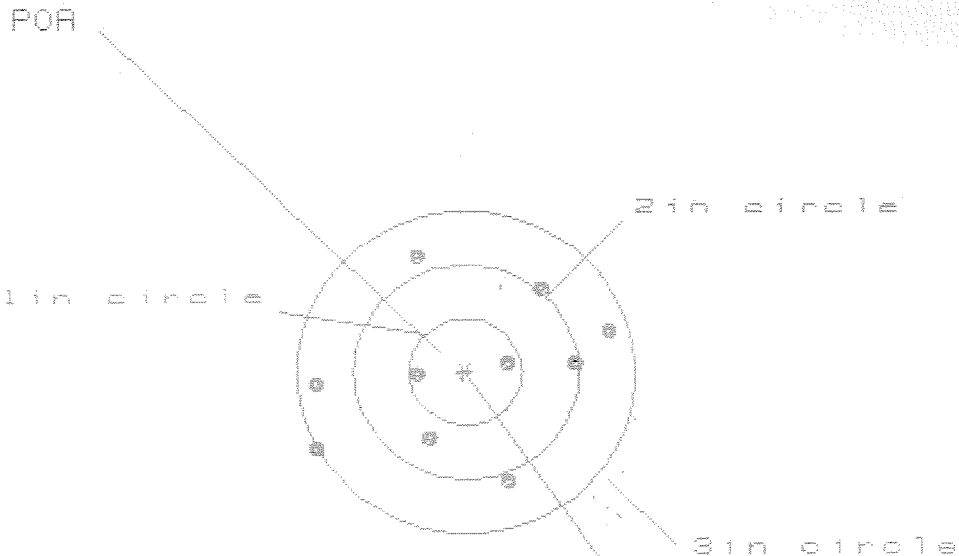
CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.634	.945	.974
MINIMUM X	:	-1.227	-1.045	-1.016
MAXIMUM Y	:	1.442	1.294	1.270
MINIMUM Y	:	-1.332	-1.297	-1.135
CENTROID X	:	.074	-.108	-.137
CENTROID Y	:	-.250	-.102	-.264
POA TO CENTROID in.	:	.260	.148	.297
MIN RADIUS	:	.366	.551	.567
MEAN RADIUS	:	1.149	1.016	.977
MAX RADIUS	:	2.109	1.605	1.496
HORIZONTAL SPREAD	:	2.861	1.990	1.990
VERTICAL SPREAD	:	2.774	2.591	2.405
EXTREME SPREAD	:	3.194	2.687	2.584
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		9	

5 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6811730

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in - 2

2in - 3

3in = 10

HS= 2.614

VS= 2.117

GS= 2.815

CENTROID *

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.305	1.160	1.013
MINIMUM X	-1.309	-1.454	-1.309
MAXIMUM Y	1.098	1.020	1.055
MINIMUM Y	-1.019	-1.097	-1.062
CENTROID X	.031	.176	.031
CENTROID Y	.015	.093	.058
POA TO CENTROID in.	.035	.199	.065
MIN RADIUS	.401	.271	.404
MEAN RADIUS	.999	.930	.895
MAX RADIUS	1.479	1.461	1.313
HORIZONTAL SPREAD	2.614	2.614	2.322
VERTICAL SPREAD	2.117	2.117	2.117
EXTREME SPREAD	2.815	2.649	2.326
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	3		
NUMBER IN THREE INCH CIRCLE =	10		

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS
2.50# ± .50#
3.00# ± .75#
4.00# ± 1.00#

SERIAL NO. C6611730
DATE 10-26-95
TESTER DA

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.63	2.53	2.62		MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.64	2.70	2.54		
PULL #3	2.53	2.41	2.48		
PULL #4	2.57	2.48	2.53		
PULL #5	2.53	2.54	2.87		
TOTAL	12.90	12.66	13.04		
AVG.	2.58	2.53	2.60		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.01	3.07		
PULL #2	2.90	3.09		
PULL #3	2.98	3.00		
PULL #4	2.85	3.10		
PULL #5	2.90	3.10		
TOTAL	14.64	15.36		
AVG.	2.92	3.07		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.02	4.32	4.13	
PULL #2	4.34	4.34	4.18	
PULL #3	4.34	4.07	4.14	
PULL #4	4.38	4.16	3.85	
PULL #5	4.23	4.02	3.89	
TOTAL	21.31	20.91	20.19	
AVG.	4.26	4.18	4.03	

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6611730

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 and Tap Sight Holes			
618	Polish Barrel			
620	Apply Coatings (Barrel Action)			
	Apply Coating (Bolt)			
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	4 1/2	5	5			12/7	WB
	G) Safety Off Force	2 1/2	2 1/2	2 1/2			12/7	WB
	H) Trigger Pull Test & Retainability							
	I) Firing Pin Indent							
	J) Assemble Stock							
	K) Assemble Swivel Studs							
	L) Attach Front and Rear Sight Assemblies							
	M) Iron Sight Alignment							
	N) Detach Front & Rear Sights & place in numbered container							
	O) Attach Scope to Rifle							
	P) Detach & Attach Scope 20 Times							
640	Gallery Target & Test							
	A) Time							
	B) Malfunctions							
	C) Pierced Primers							
	D) Optical Clarity of Scope							
645	Inspect for Live Ammo							
655	Final Inspection							
	A) Headspace							
	B) Trigger Pull	2.82	2.77	2.73	2.72	2.62	12/7	WB
	C) Function							
660	Pack							