

C6349045

MODEL 700TM M24

Model **SWS** TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

Repair Inquiry

Repair Number: RE00112531

Serial: C6349045 Model M24 SWS Center Fire
Caliber: 7.62 NATO Produced: 03/19/1990

Repairman:

Status:

Closed 5/18/2006 9:47:16 AM

Address Information

Customer:

☒ Received From

Return To:

☐ Received From

Name: 225TH BSB (SSA)

225TH BSB (SSA)

Address 1: ATTN CW3 FUJIHARA (808-655-0211)

ATTN CW3 FUJIHARA (808-655-0211)

Address 2: BLDG 1670 MELICHAMP ST

PO Box:

BLDG 1670 MELICHAMP ST.

PO Box:

City: SCHOFIELD BARRACKS

SCHOFIELD BARRACKS

State: HI

Zip Code: 96857

Country: US

State: HI

Zip Code: 96857

Country: US

FPL:

Contact / Condition

Problems

Estimate

History / Status

Shipping / Billing

Contact information

Phone: NA

Fax:

Email:

Comments:

Received Condition

Fair

Condition
Notes:CSR
Notes:

Accessories Received

Code	Desc	Qty
A057	Frt and Rear Sgt Base	1

Repair Search

Refresh

Close

naglet

5/23/2006

7:21 AM

CAPS

NUM

INS

SCRL

start

2 Micr...

Microsof...

2 Inter...

Part Sea...

Arms Se...

7:21 AM

Serial Number: C6349045

Model: M24 SWS



RE00112531

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50 LBS (plus or minus 0.50 LBS)

3.00 LBS (plus or minus 0.75 LBS)

4.00 LBS (plus or minus 1.00 LBS)

DATE 5-5-06

TESTER R.P.

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	260	245		248	
PULL #2	245	241		252	
PULL #3	251	247		240	
PULL #4	234	242		240	
PULL #5	241	246		246	
TOTAL	1231	1221		1226	
AVERAGE	246	244		245	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	308	317		
PULL #2	318	316		
PULL #3	322	320		
PULL #4	316	301		
PULL #5	318	312		
TOTAL	1582	1566		
AVERAGE	316	313		

	4.00 LBS INITIAL	4.00 LBS AFTER 20 CYCLES	MAX SETTING GREATER THAN 4 LBS	RESET TO 4 LBS FOR TARGET & ACCURACY
PULL #1	408	406		407
PULL #2	408	399		406
PULL #3	408	417		395
PULL #4	396	400		408
PULL #5	409	415		403
TOTAL	2029	2037		2019
AVERAGE	405	407		403

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6349045.___0

FILE DATE AND TIME: 11/13/2006 23:17

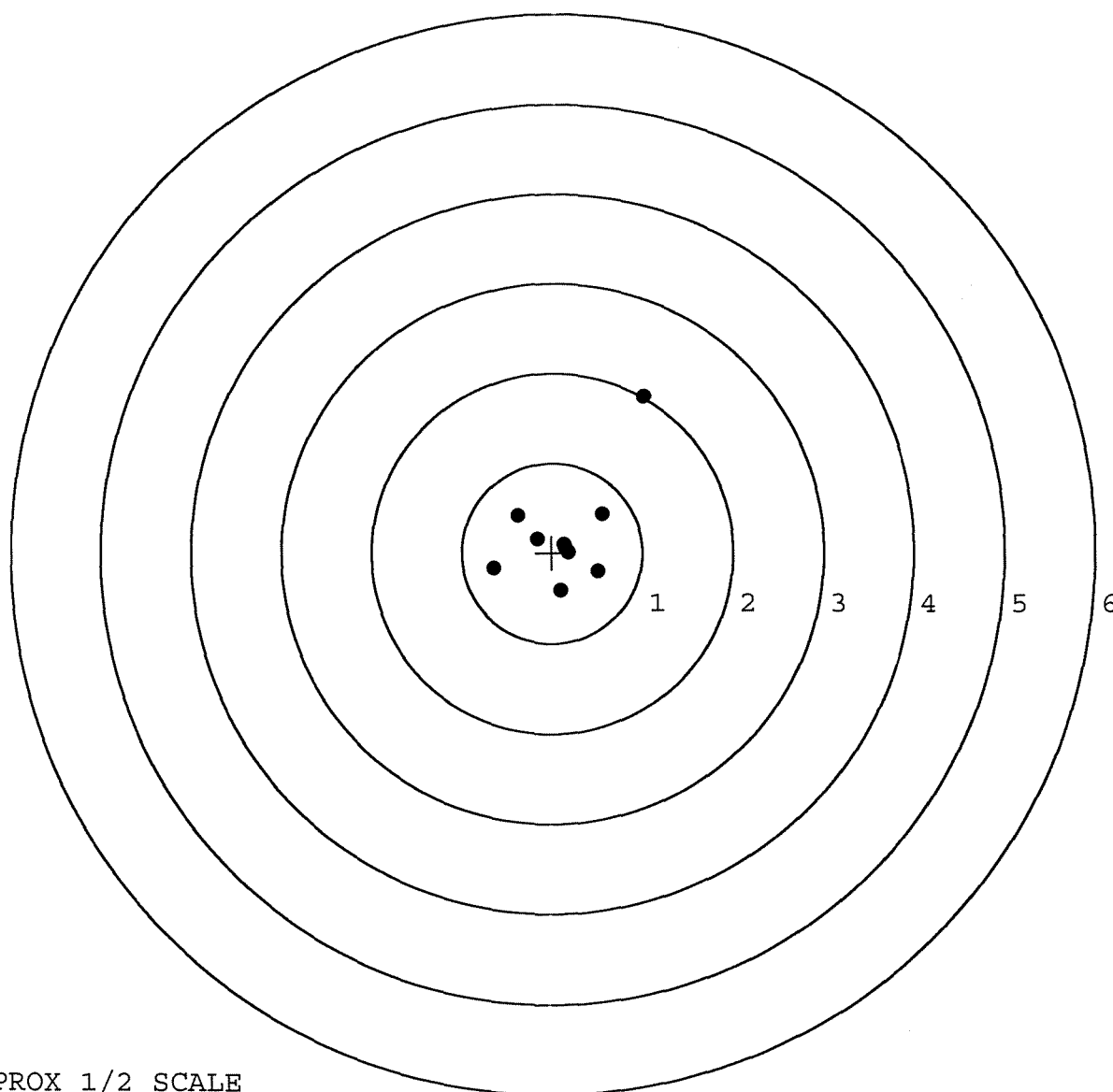
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.052
The Average Y Centroid of the Five Target Set:	0.076
The Average Point of Impact of the Five Target Set:	0.092
The Average Mean Radius of the Five Target Set:	0.646
The Distance from POA to Centroid Target #1:	0.252
The Distance from Centroid Target #2 to Centroid Target #1:	0.265
The Distance from Centroid Target #3 to Centroid Target #1:	0.312
The Distance from Centroid Target #4 to Centroid Target #1:	0.217
The Distance from Centroid Target #5 to Centroid Target #1:	0.406

SERIAL NUMBER: C6349045. __0
TARGET NUMBER: 1
FILE DATE: 11/13/2006
FILE TIME: 23:17

X CENTROID: 0.144
Y CENTROID: 0.207
POA TO CENTROID: 0.252
HORZ SPREAD: 1.653
VERT SPREAD: 2.169
GROUP SPREAD: 2.534
MIN RADIUS: 0.114
MAX RADIUS: 1.761
MEAN RADIUS: 0.565
IN 1 IN DIAMETER: 5
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 9

POINT#	X	Y
1:	1.003	1.744
2:	-0.381	0.413
3:	-0.163	0.148
4:	0.137	0.093
5:	0.554	0.430
6:	0.510	-0.208
7:	0.106	-0.425
8:	-0.650	-0.177
9:	0.182	0.001
10:	0.147	0.049

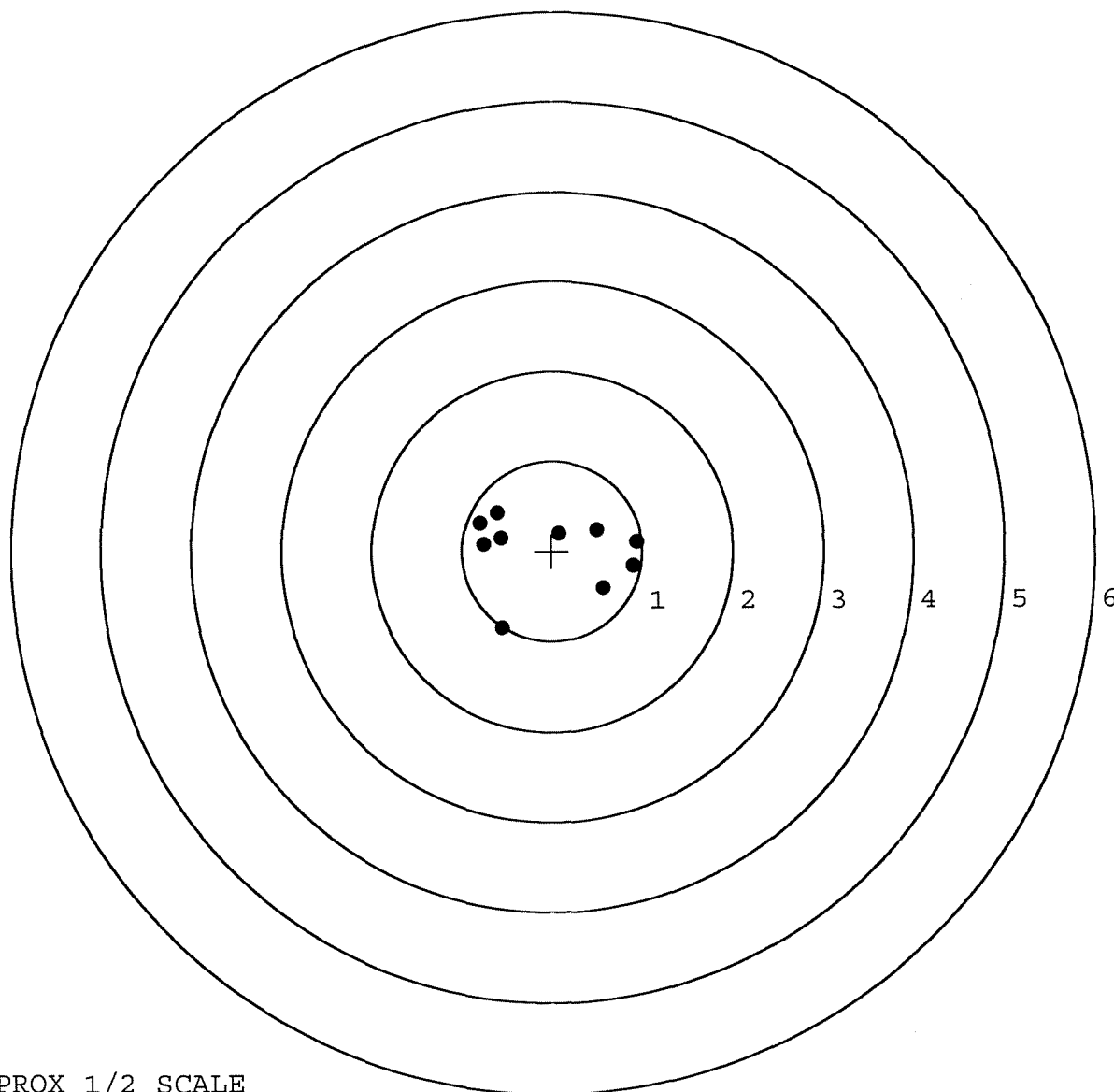


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6349045. __0
TARGET NUMBER: 2
FILE DATE: 11/13/2006
FILE TIME: 23:17

X CENTROID: -0.031
Y CENTROID: 0.008
POA TO CENTROID: 0.032
HORZ SPREAD: 1.750
VERT SPREAD: 1.287
GROUP SPREAD: 1.782
MIN RADIUS: 0.219
MAX RADIUS: 1.012
MEAN RADIUS: 0.731
IN 1 IN DIAMETER: 1
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.610	0.431
2:	-0.566	0.147
3:	-0.760	0.084
4:	-0.806	0.319
5:	0.080	0.197
6:	0.495	0.238
7:	0.944	0.103
8:	0.900	-0.169
9:	0.573	-0.414
10:	-0.558	-0.856

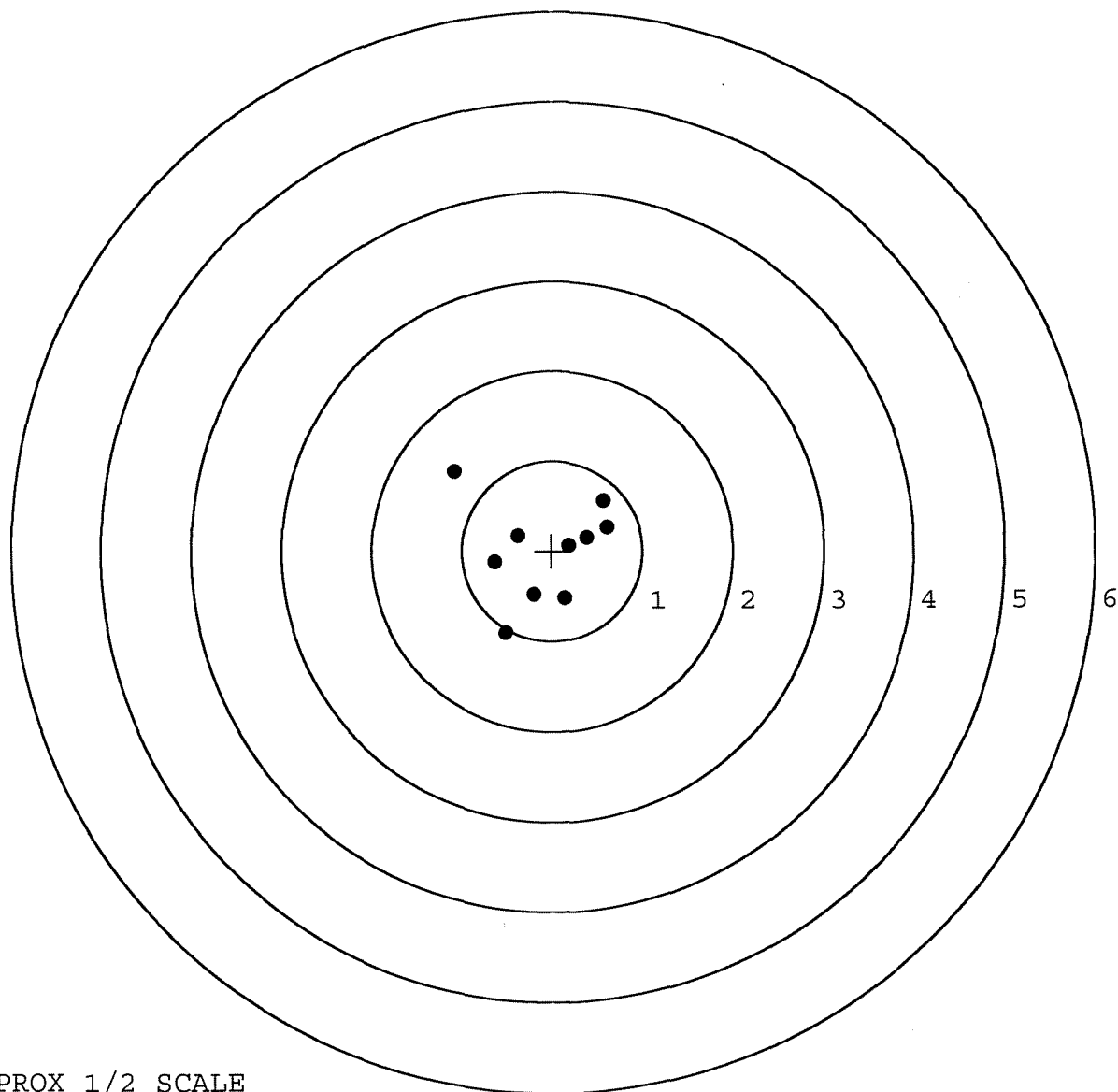


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6349045. __0
TARGET NUMBER: 3
FILE DATE: 11/13/2006
FILE TIME: 23:17

X CENTROID: -0.092
Y CENTROID: 0.003
POA TO CENTROID: 0.092
HORZ SPREAD: 1.696
VERT SPREAD: 1.791
GROUP SPREAD: 1.879
MIN RADIUS: 0.285
MAX RADIUS: 1.328
MEAN RADIUS: 0.671
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-1.086	0.884
2:	-0.374	0.170
3:	-0.639	-0.125
4:	-0.204	-0.491
5:	0.140	-0.532
6:	-0.517	-0.907
7:	0.188	0.057
8:	0.389	0.153
9:	0.610	0.266
10:	0.570	0.558

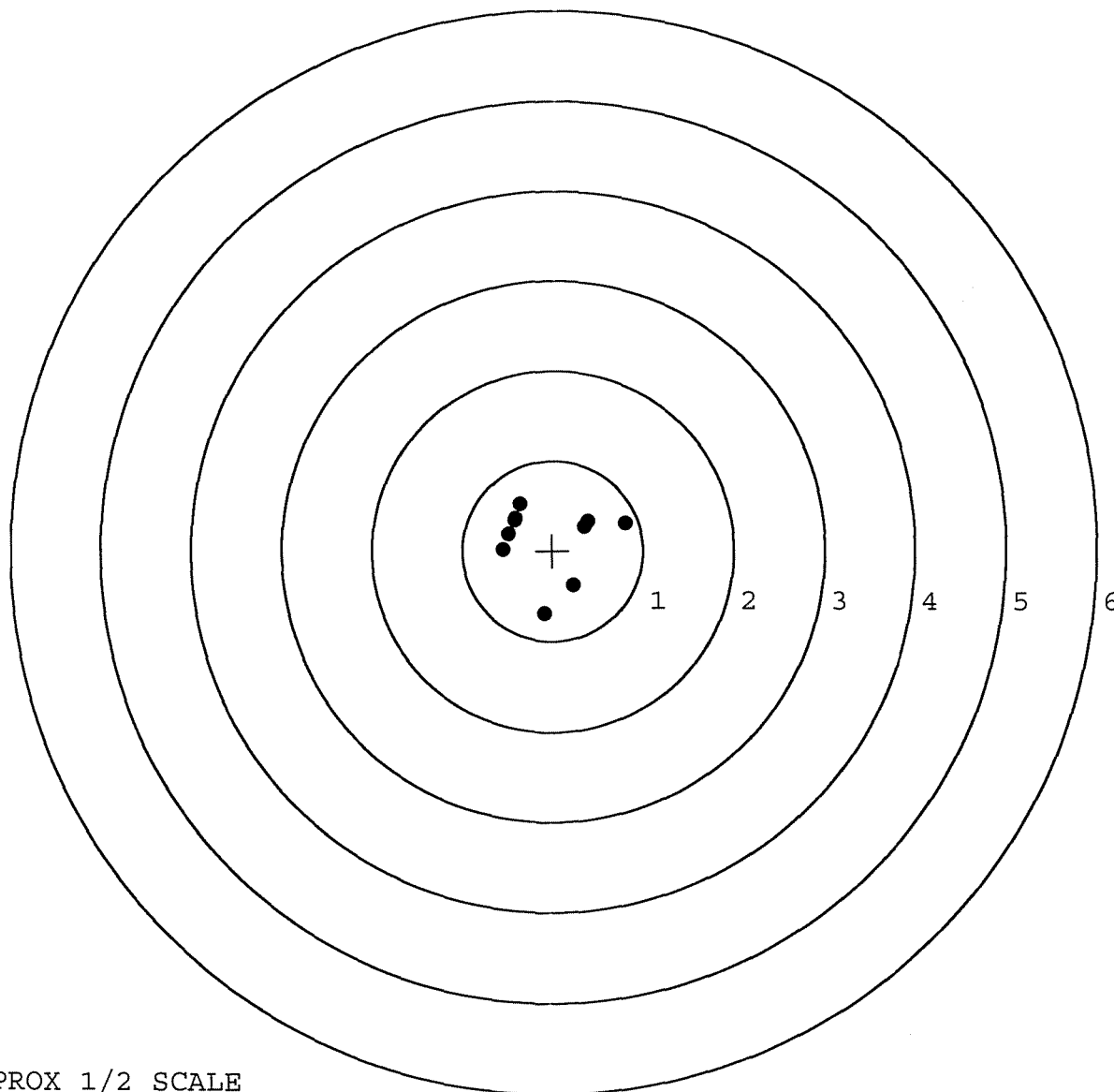


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6349045. __0
TARGET NUMBER: 4
FILE DATE: 11/13/2006
FILE TIME: 23:17

X CENTROID: -0.056
Y CENTROID: 0.123
POA TO CENTROID: 0.135
HORZ SPREAD: 1.356
VERT SPREAD: 1.221
GROUP SPREAD: 1.390
MIN RADIUS: 0.425
MAX RADIUS: 0.881
MEAN RADIUS: 0.553
IN 1 IN DIAMETER: 5
IN 2 IN DIAMETER: 10
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.365	0.519
2:	-0.425	0.334
3:	-0.552	0.008
4:	0.349	0.269
5:	0.804	0.313
6:	0.237	-0.388
7:	-0.087	-0.702
8:	-0.490	0.185
9:	-0.419	0.357
10:	0.390	0.332

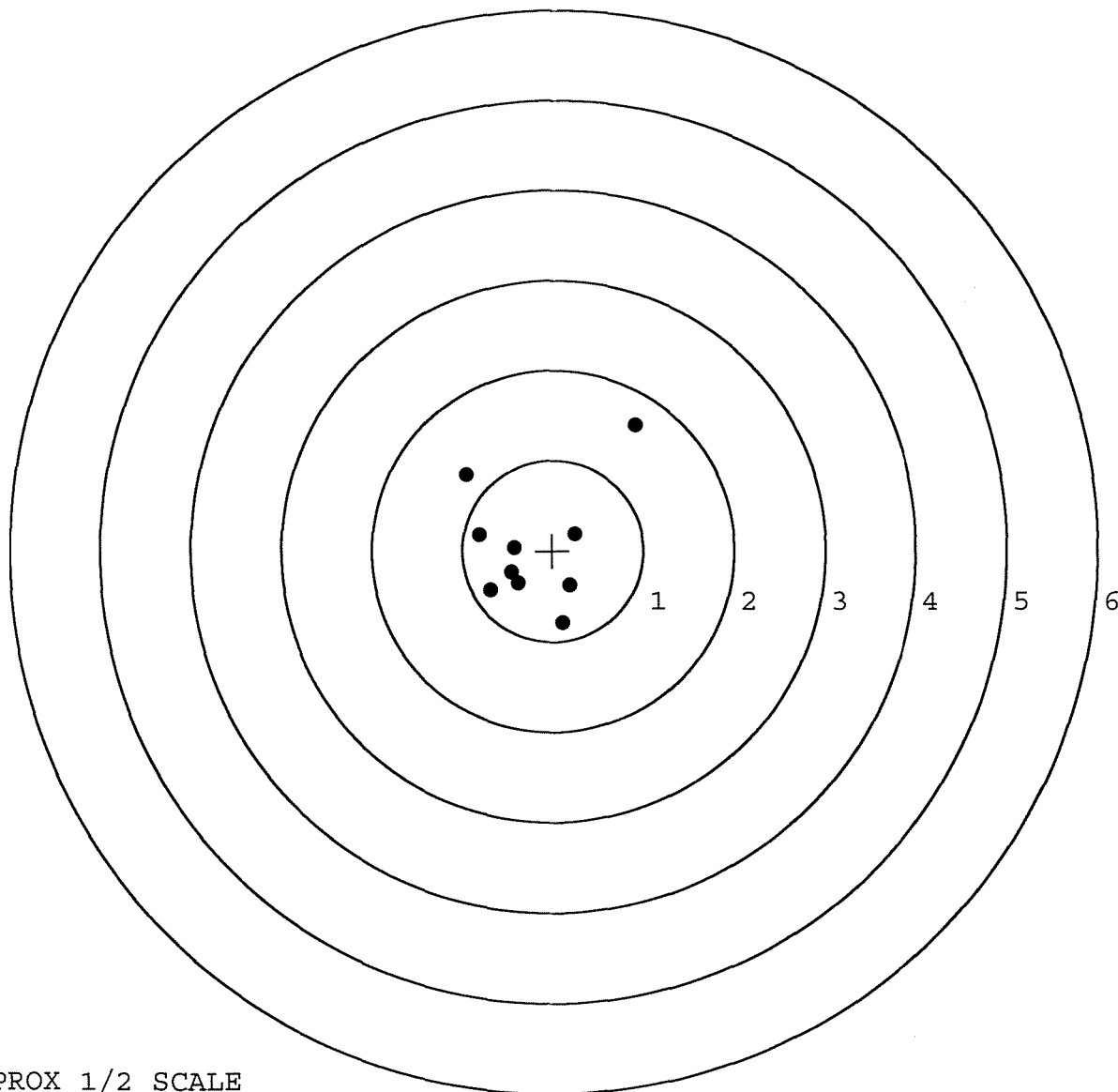


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6349045.___0
TARGET NUMBER: 5
FILE DATE: 11/13/2006
FILE TIME: 23:17

X CENTROID: -0.225
Y CENTROID: 0.038
POA TO CENTROID: 0.228
HORZ SPREAD: 1.864
VERT SPREAD: 2.188
GROUP SPREAD: 2.425
MIN RADIUS: 0.200
MAX RADIUS: 1.765
MEAN RADIUS: 0.710
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 9

POINT#	X	Y
1:	-0.954	0.835
2:	-0.810	0.168
3:	-0.425	0.033
4:	-0.382	-0.365
5:	-0.687	-0.435
6:	0.118	-0.798
7:	0.189	-0.384
8:	0.248	0.185
9:	0.910	1.390
10:	-0.457	-0.246



TARGET APPROX 1/2 SCALE

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6349045.___0
FILE DATE AND TIME: 06/07/2006 17:54

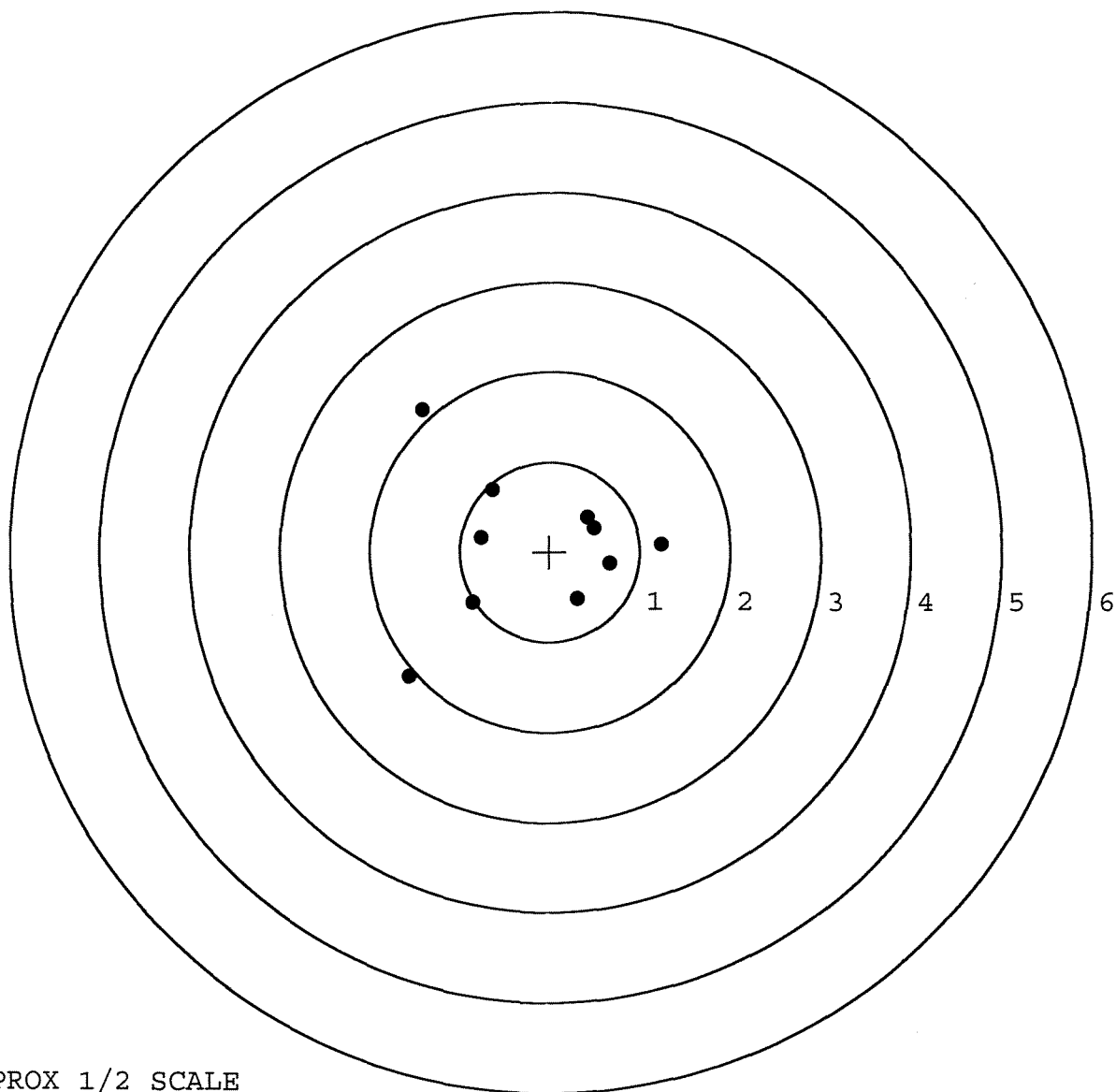
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.020
The Average Y Centroid of the Five Target Set:	0.093
The Average Point of Impact of the Five Target Set:	0.095
The Average Mean Radius of the Five Target Set:	0.928
The Distance from POA to Centroid Target #1:	0.219
The Distance from Centroid Target #2 to Centroid Target #1:	0.322
The Distance from Centroid Target #3 to Centroid Target #1:	0.351
The Distance from Centroid Target #4 to Centroid Target #1:	0.408
The Distance from Centroid Target #5 to Centroid Target #1:	0.275

SERIAL NUMBER: C6349045. __0
TARGET NUMBER: 1
FILE DATE: 06/07/2006
FILE TIME: 17:54

X CENTROID: -0.212
Y CENTROID: 0.052
POA TO CENTROID: 0.219
HORZ SPREAD: 2.791
VERT SPREAD: 2.965
GROUP SPREAD: 3.156
MIN RADIUS: 0.558
MAX RADIUS: 1.973
MEAN RADIUS: 1.071
IN 1 IN DIAMETER: 0
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 8

POINT#	X	Y
1:	-0.645	0.691
2:	-0.761	0.155
3:	-1.423	1.573
4:	0.414	0.384
5:	0.490	0.261
6:	0.667	-0.132
7:	1.234	0.081
8:	0.311	-0.532
9:	-0.854	-0.572
10:	-1.557	-1.392

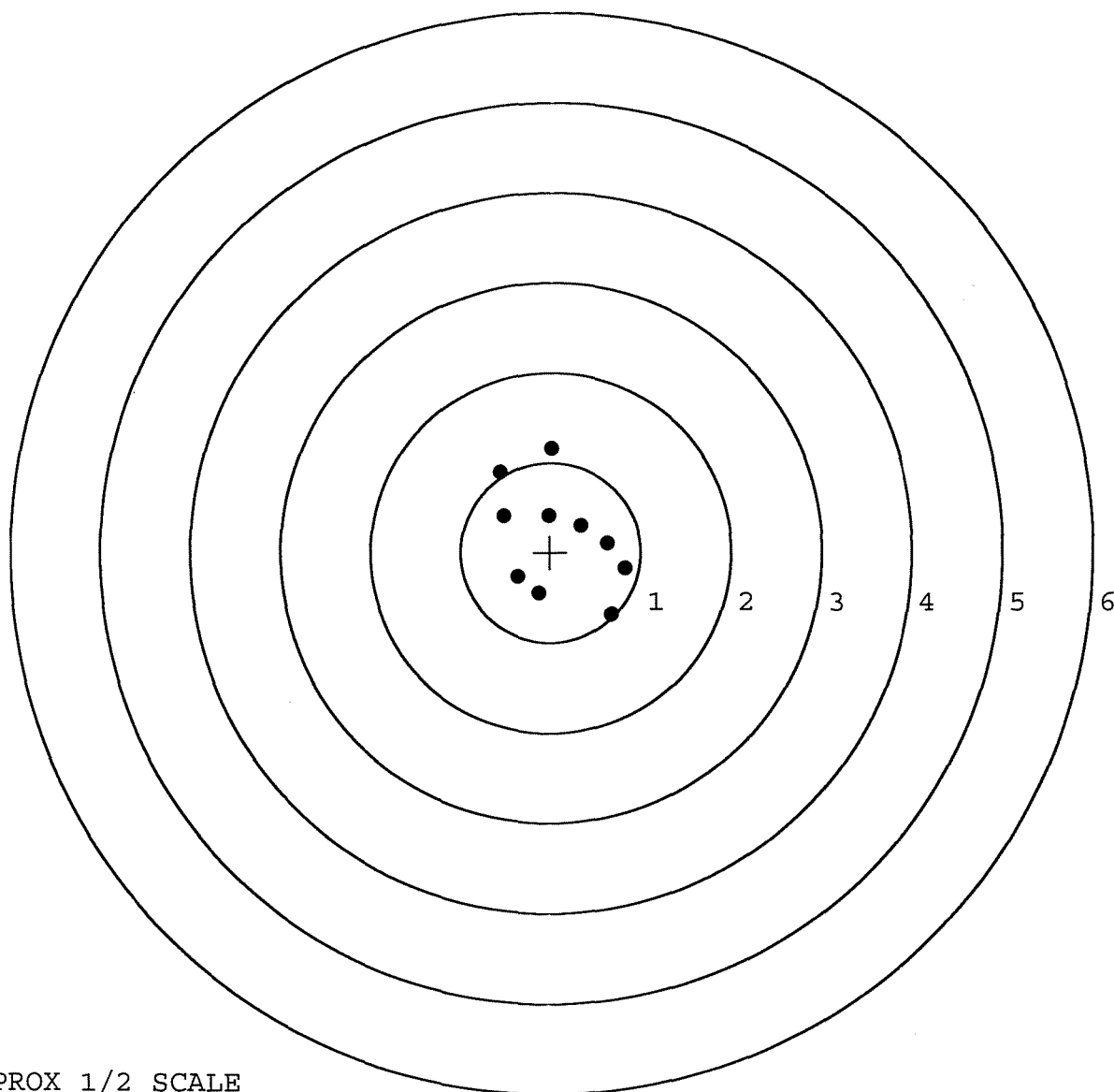


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6349045. __0
TARGET NUMBER: 2
FILE DATE: 06/07/2006
FILE TIME: 17:54

X CENTROID: 0.090
Y CENTROID: 0.164
POA TO CENTROID: 0.187
HORZ SPREAD: 1.389
VERT SPREAD: 1.854
GROUP SPREAD: 2.018
MIN RADIUS: 0.270
MAX RADIUS: 1.045
MEAN RADIUS: 0.690
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.009	1.159
2:	-0.560	0.893
3:	-0.524	0.404
4:	-0.023	0.409
5:	0.339	0.296
6:	0.634	0.105
7:	0.829	-0.182
8:	0.686	-0.695
9:	-0.128	-0.466
10:	-0.362	-0.286

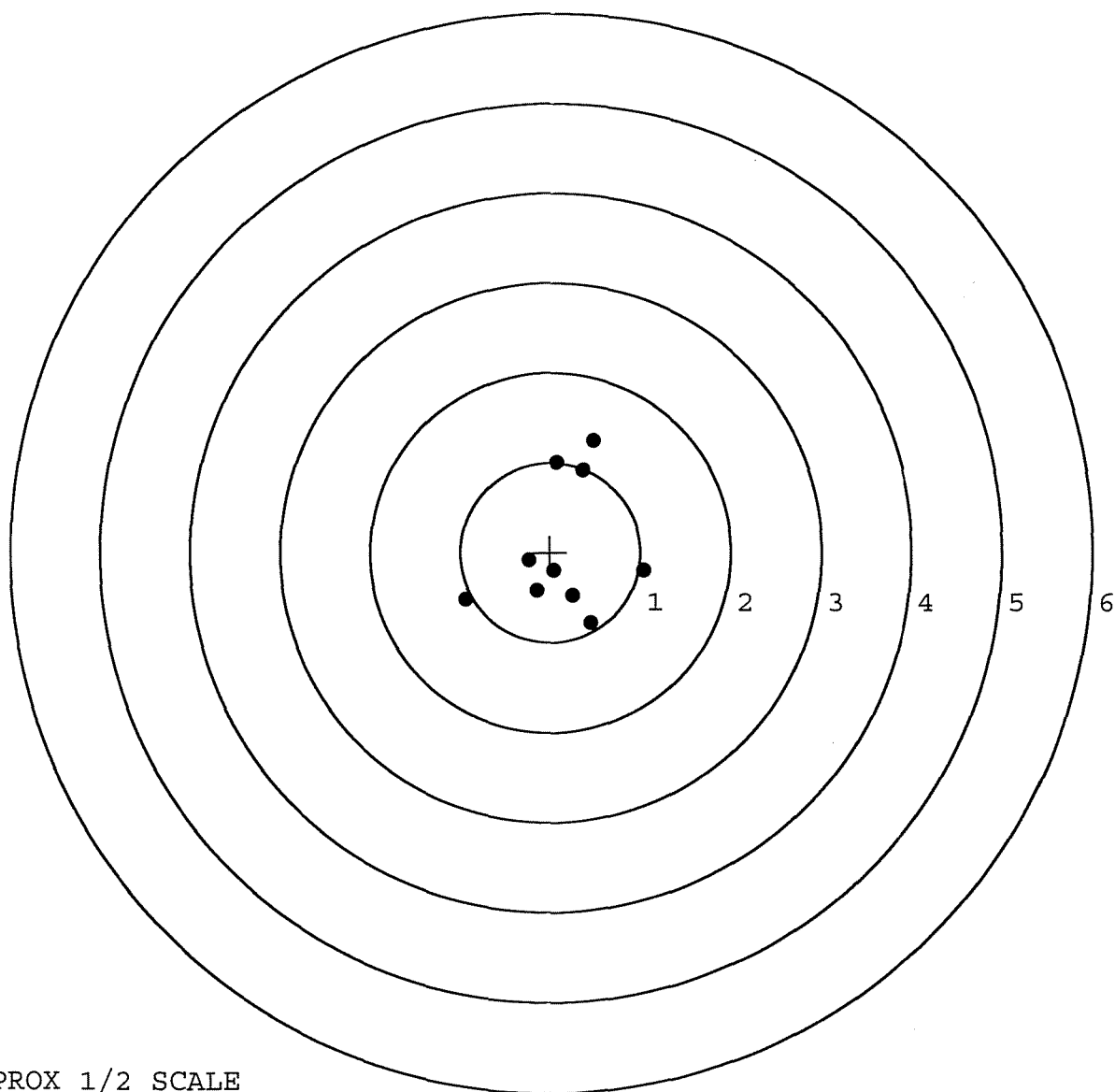


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6349045. 0
TARGET NUMBER: 3
FILE DATE: 06/07/2006
FILE TIME: 17:54

X CENTROID: 0.139
Y CENTROID: 0.044
POA TO CENTROID: 0.145
HORZ SPREAD: 1.971
VERT SPREAD: 2.036
GROUP SPREAD: 2.266
MIN RADIUS: 0.268
MAX RADIUS: 1.247
MEAN RADIUS: 0.791
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.069	1.005
2:	0.366	0.919
3:	0.474	1.245
4:	1.034	-0.200
5:	0.457	-0.791
6:	0.254	-0.482
7:	0.046	-0.208
8:	-0.141	-0.433
9:	-0.235	-0.091
10:	-0.937	-0.528

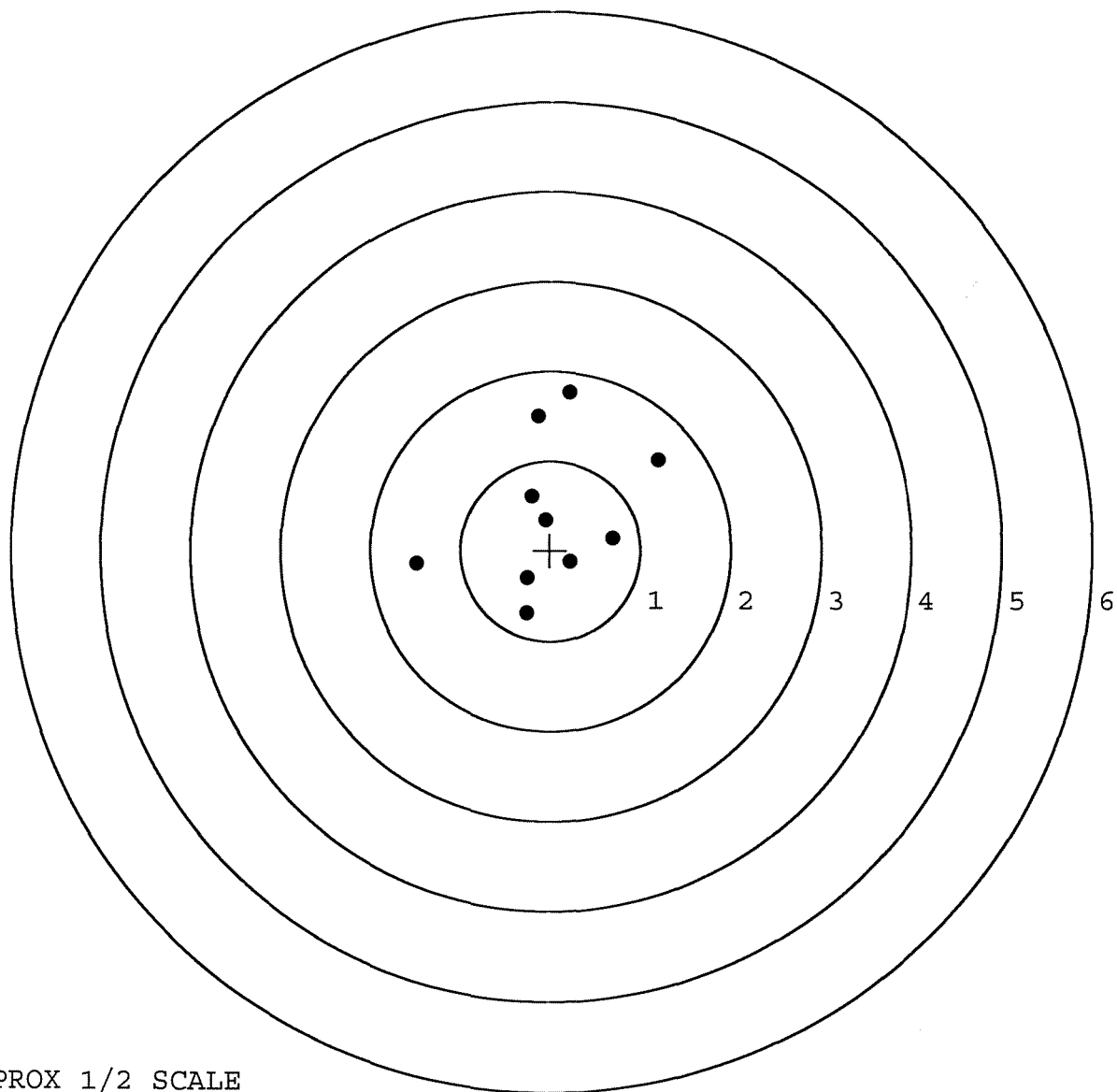


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6349045. __0
TARGET NUMBER: 4
FILE DATE: 06/07/2006
FILE TIME: 17:54

X CENTROID: -0.010
Y CENTROID: 0.406
POA TO CENTROID: 0.406
HORZ SPREAD: 2.677
VERT SPREAD: 2.461
GROUP SPREAD: 2.918
MIN RADIUS: 0.084
MAX RADIUS: 1.575
MEAN RADIUS: 0.899
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 5
in 3 IN DIAMETER: 9

POINT#	X	Y
1:	0.209	1.762
2:	-0.146	1.499
3:	-0.208	0.601
4:	-0.057	0.337
5:	1.193	1.012
6:	0.694	0.137
7:	0.220	-0.130
8:	-0.254	-0.312
9:	-0.263	-0.699
10:	-1.484	-0.149

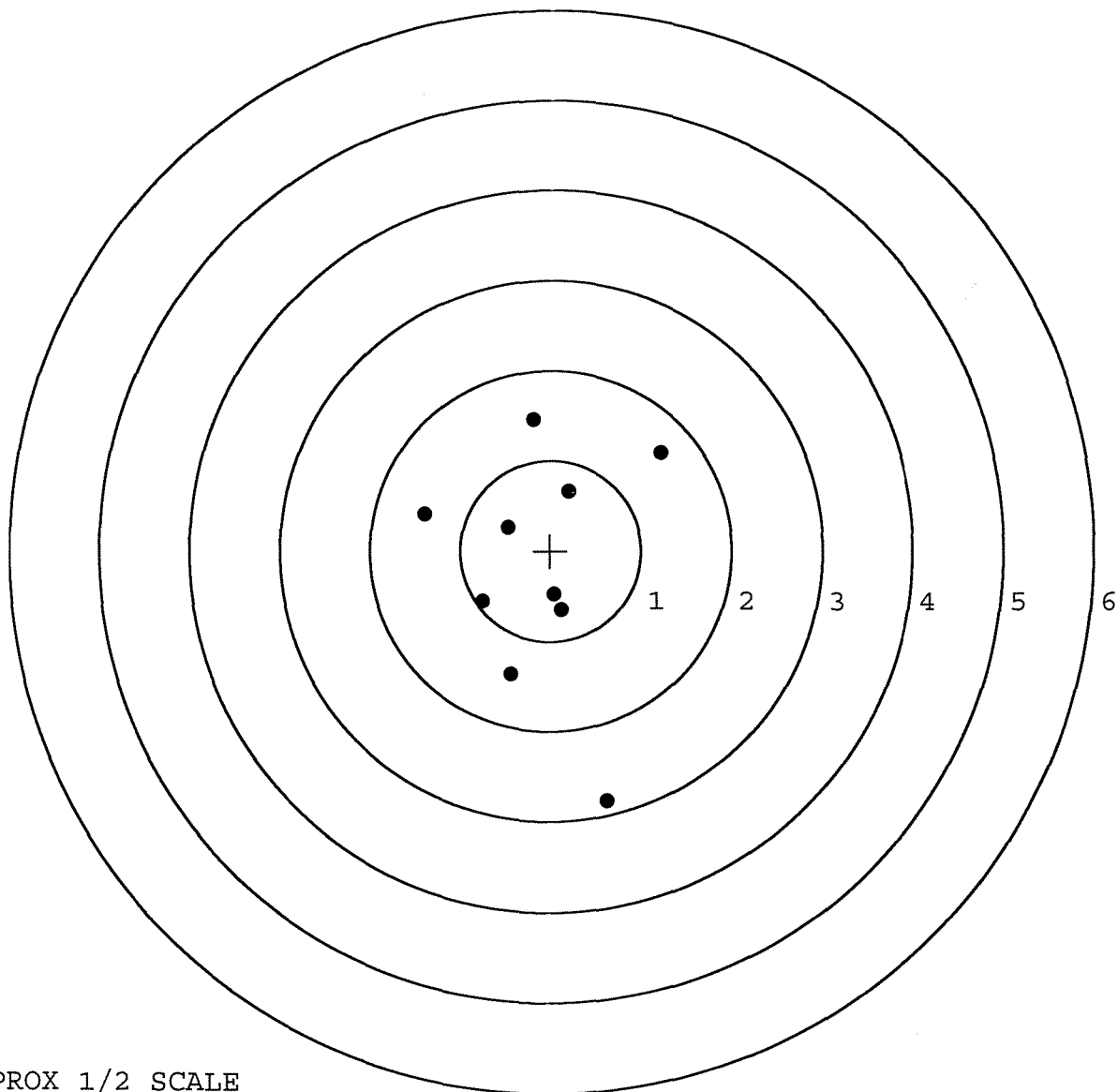


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6349045.____0
TARGET NUMBER: 5
FILE DATE: 06/07/2006
FILE TIME: 17:54

X CENTROID: -0.104
Y CENTROID: -0.202
POA TO CENTROID: 0.227
HORZ SPREAD: 2.607
VERT SPREAD: 4.227
GROUP SPREAD: 4.310
MIN RADIUS: 0.320
MAX RADIUS: 2.684
MEAN RADIUS: 1.190
IN 1 IN DIAMETER: 1
IN 2 IN DIAMETER: 5
in 3 IN DIAMETER: 7

POINT#	X	Y
1:	0.129	-0.659
2:	-0.438	-1.371
3:	-1.397	0.402
4:	-0.200	1.447
5:	0.204	0.659
6:	0.044	-0.485
7:	0.640	-2.780
8:	-0.757	-0.564
9:	-0.478	0.255
10:	1.210	1.081



TARGET APPROX 1/2 SCALE

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

R & E NUMBER	112531			
SERIAL NUMBER	06349045			
LOG-IN DATE	5-18-06			
OPERATION #	OPERATION NAME	DATE	INITIAL	
500	DIS-ASSEMBLE GUN	5-23-06	RTZ	
505	RE-BARREL	5-26-06	RTZ	
560	ASSEMBLE	5-30-06	RTZ	
600	PROOF	MAGNA-FLUX INSPECTED	TRW	
605	CHECK HEADSPACE	5-30-06	TRW	
610	DIS-ASSEMBLE GUN	JUN 02 2006	RTZ	
612	MAGNAFLUX	OPERATOR <i>APD</i>	6-2-06 APD	
510	DRILL AND TAP	MAGNA-FLUX INSPECTED	6-1-06 TRW	
615	ROLLMARK CALIBER	9-20-06 CW	6-2-06 CW	
618	ROTO-BLAST	SEP 20 2006	6-2-06 LB	
620	APPLY COATINGS	OPERATOR <i>WMB</i> 9/22/06 RB	6-5-06 RB	
625	FINAL ASSEMBLY		6-7-06 RTZ	
640	FUNCTION TEST AND	PASS 11-13-06 TRW	6-7-06 R.P.D.	
650	TARGET	PASS 11-13-06 TRW	6-7-06 R.P.D.	
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
670	FINAL INSPECTION	11-13-06 TRW	6-22-06 N/A	
	A) HEADSPACE	PASS 11-13-06 TRW	6-22-06 N/A	
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	2.45 2.42 2.50 2.37 2.43 6-22-06 N/A	
680	F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX	7 lbs 7 lbs 7 lbs 6-22-06 N/A	
	G) SAFETY OFF FORCE	2 LBS MIN	3 lbs 3 lbs 3 lbs 6-22-06 N/A	
	I) FIRING PIN INDENT	.020	.022 .023 .022 6-22-06 N/A	
690	PACK		11-15-06 DR	

Remington[®]



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

MODEL 700TM H24

SERIAL NO.
C6349045

ORDER NO.
5716

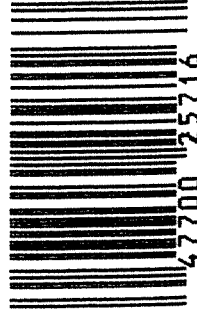
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MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.



5716 C6349045

LPC



0 47700 25716 7

RC13
replaced

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6349045

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		12-20 89	RW
600	Proof		12-20 89	A
607	Check Headspace		12-20 89	A
610	Dis-assemble Gun		12-20 89	RW
612	Magnaflux Barrel Action		1-5-90	KCR
	Magnaflux Bolt		1-5-90	
615	Rollmark Caliber		1/3/90	JS
17	Drill and Tap Sight Holes		1/8/90	FJB
618	Polish Barrel JS		1/9/90	WB
620	Apply Coatings (Barrel Action)		1-15-90	TJA
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		1/17/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		1/17/90	RW
	C) Inspect Ejector Hole for Chamfer		1/17/90	RW
	D) Oil Firing Pin Ass'y		1/17/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		2/2/90	JS

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			1-22-90	RL
	G) Safety Off Force	3	3	3			1-22-90	RL
	H) Trigger Pull Test & Retainability						22/1/90	RL
	I) Firing Pin Indent	.0215	.021	.0215			1-22-90	RL
	J) Assemble Stock						1/24/90	RL
	K) Assemble Swivel Studs						1/24/90	WB
	L) Attach Front and Rear Sight Assemblies						1/26/90	RL
	M) Iron Sight Alignment						1/26/90	RL
	N) Detach Front & Rear Sights & place in numbered container						1/26/90	RL
	O) Attach Scope to Rifle						1/31/90	WB
	P) Detach & Attach Scope 20 Times						3/6/90	WB
640	Gallery Target & Test						3-7-90	A
	A) Time						"	A
	B) Malfunctions						"	A
	C) Pierced Primers						"	A
	D) Optical Clarity of Scope						"	A
645	Inspect for Live Ammo						3-7-90	A
655	Final Inspection						3/12/90	WB
	A) Headspace							
	B) Trigger Pull	2.32	2.25	2.25	2.21	2.26	3/12/90	G.S.
	C) Function						3/12/90	WB
660	Pack						20 March 90	RL

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6349045DATE 22 Jan 90TESTER JRS

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.30	2.64	2.24	2.32	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.04	2.13	2.17	2.25	
PULL #3	2.42	2.26	2.23	2.25	
PULL #4	2.46	2.21	2.16	2.21	
PULL #5	2.48	2.24	2.19	2.26	
TOTAL	11.70	11.48	10.99		
AVG.	2.34	2.296	2.198		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.03	2.94		
PULL #2	2.87	2.85		
PULL #3	2.91	2.87		
PULL #4	2.88	2.80		
PULL #5	2.97	2.99		
TOTAL	14.66	14.41		
AVG.	2.932	2.882		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	3.99	4.03		3.83
PULL #2	3.97	4.02		3.93
PULL #3	4.03	3.98		4.02
PULL #4	4.02	3.99		4.10
PULL #5	3.99	3.92		4.04
TOTAL	20.00	19.94		19.92
AVG.	4.00	3.988		3.984

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6349045
8 Mar 1990

CENTROIDAL DISTANCES

0 TO	1	.256844
1 TO	2	.231225
1 TO	3	.240227
1 TO	4	.800478
1 TO	5	.142302

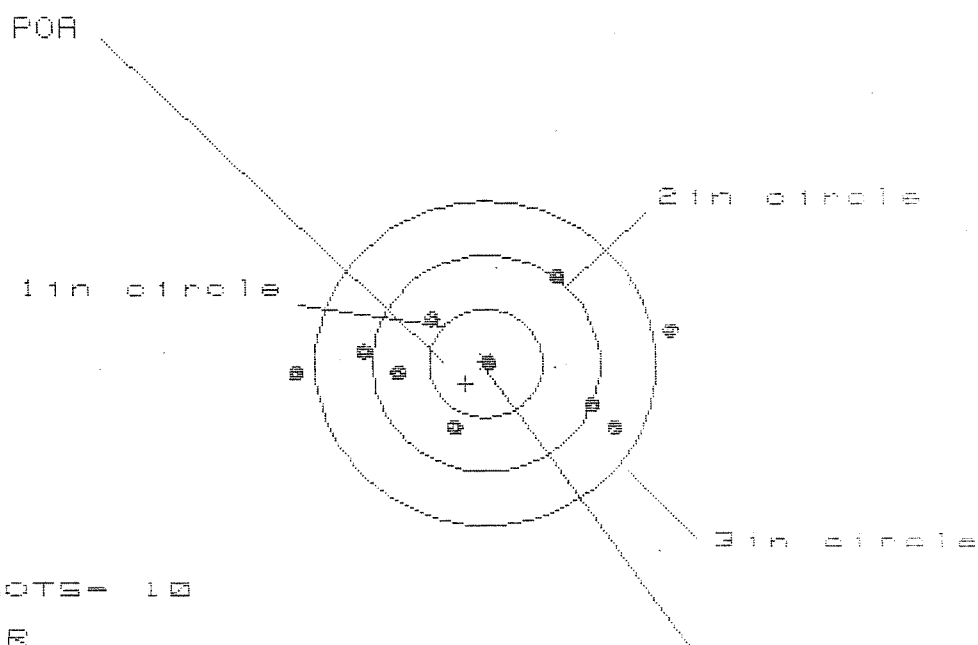
4 $\bar{x}$ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0834
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.001
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .083406
THE AMR FOR THIS RIFLE IS: .9552

7 Mar 1998

FILE:/PATTERNING/CENTERFIRE_PATT/08349045

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 8

HS= 3.321

VS= 1.383

GS= 3.345

CENTROID *

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.673	1.263	1.080
MINIMUM X	:	-1.648	-1.462	-1.106
MAXIMUM Y	:	.794	.831	.829
MINIMUM Y	:	-.589	-.552	-.554
CENTROID X	:	.175	-.011	.172
CENTROID Y	:	.188	.151	.153
POA TO CENTROID in.	:	.257	.151	.230
MIN RADIUS	:	.032	.172	.012
MEAN RADIUS	:	.974	.878	.795
MAX RADIUS	:	1.707	1.462	1.214
HORIZONTAL SPREAD	:	3.321	2.725	2.186
VERTICAL SPREAD	:	1.383	1.383	1.383
EXTREME SPREAD	:	3.345	2.776	2.298
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

7 Mar 1998

FILE:/PATTERNING/CENTERFIRE_PATT/08349045

CENTERFIRE PATTERNS

2

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS- 10

IN CIR

1 in = 1

2 in = 3

3 in = 7

HS= 2.831

VS= 1.996

GS= 3.356

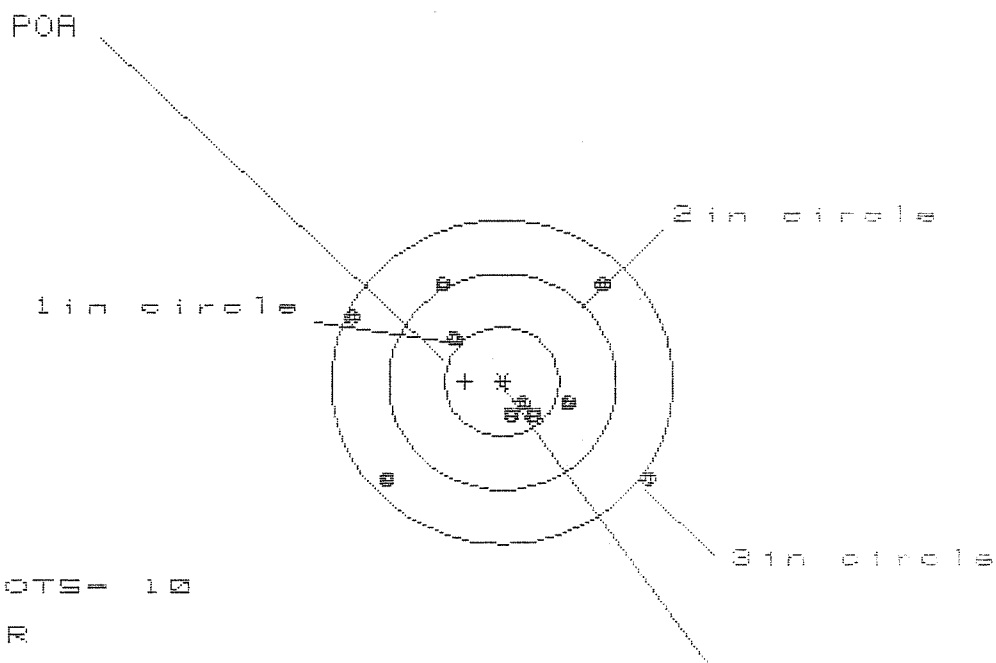
PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.306	1.136	1.278
MINIMUM X	:	-1.525	-1.084	-.942
MAXIMUM Y	:	1.041	.935	1.029
MINIMUM Y	:	-.955	-1.061	-.967
CENTROID X	:	.311	.481	.339
CENTROID Y	:	.001	.107	.013
POA TO CENTROID in.	:	.311	.492	.339
MIN RADIUS	:	.051	.250	.081
MEAN RADIUS	:	1.101	1.047	.963
MAX RADIUS	:	1.798	1.468	1.527
HORIZONTAL SPREAD	:	2.831	2.220	2.220
VERTICAL SPREAD	:	1.996	1.996	1.996
EXTREME SPREAD	:	3.356	2.899	2.899
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		7	

7 Mar 1998

FILE:/PATTERNING/CENTERFIRE_PATT/08349045

CENTERFIRE PATTERNS

3



OF SHOTS= 10

IN CIR

1in = 3

2in = 5

3in = 9

HS= 2.602

VS= 1.831

GS= 2.980

CENTROID *

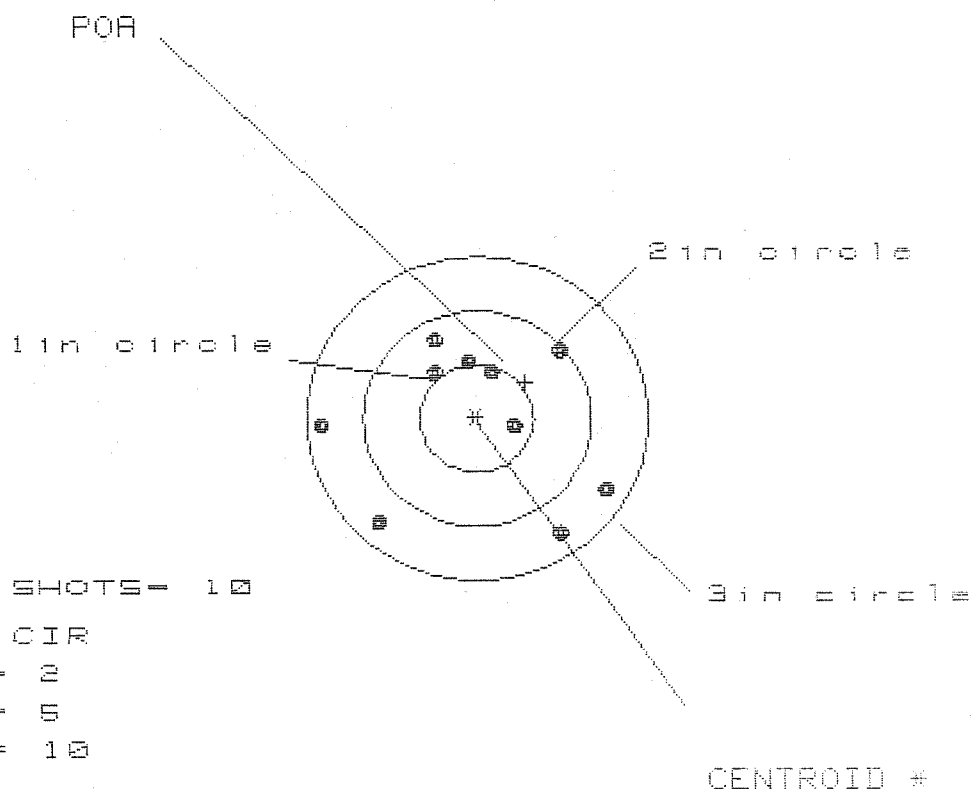
PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	1.235
MINIMUM X	-1.367
MAXIMUM Y	.942
MINIMUM Y	-.889
CENTROID X	.322
CENTROID Y	-.002
POA TO CENTROID in.	.322
MIN RADIUS	.265
MEAN RADIUS	.885
MAX RADIUS	1.503
HORIZONTAL SPREAD	2.602
VERTICAL SPREAD	1.831
EXTREME SPREAD	2.980
NUMBER IN ONE INCH CIRCLE =	3
NUMBER IN TWO INCH CIRCLE =	5
NUMBER IN THREE INCH CIRCLE =	9

7 Mar 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6349045

CENTERFIRE PATTERNS

4



OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 10

HS= 2.487

VS= 1.815

GS= 2.544

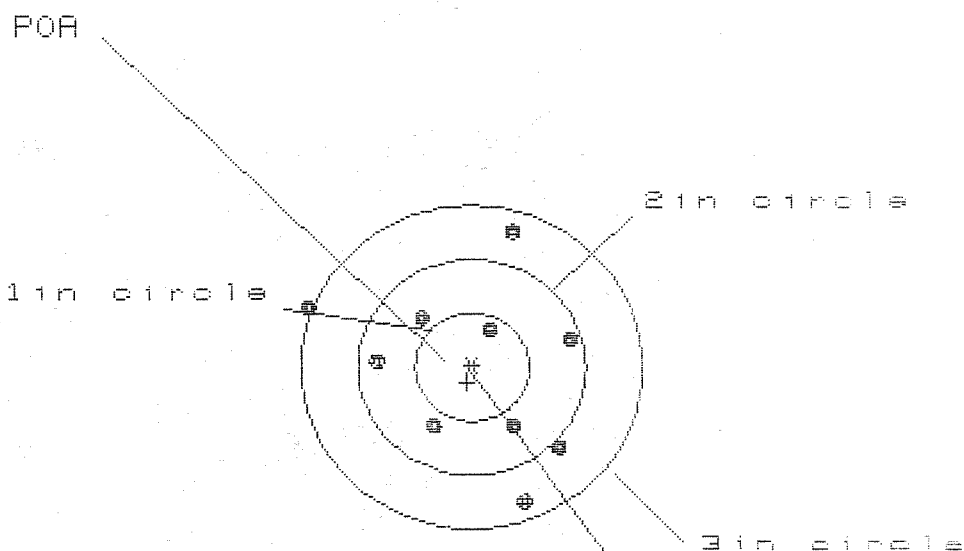
PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.130	.979	.711
MINIMUM X	-1.357	-1.018	-.896
MAXIMUM Y	.757	.745	.663
MINIMUM Y	-1.058	-1.070	-1.152
CENTROID X	-.431	-.280	-.402
CENTROID Y	-.335	-.323	-.241
POA TO CENTROID in.	.546	.427	.469
MIN RADIUS	.372	.226	.343
MEAN RADIUS	.903	.831	.766
MAX RADIUS	1.362	1.400	1.375
HORIZONTAL SPREAD	2.487	1.997	1.607
VERTICAL SPREAD	1.815	1.815	1.815
EXTREME SPREAD	2.544	2.222	2.222
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	10		

7 Mar 1998

FILE:/PATTERNING/CENTERFIRE_PATT/06349045

CENTERFIRE PATTERNS

5



OF SHOTS- 10

IN CIR

1in = 1

2in = 6

3in = 9

HS= 2.286

VS= 2.475

GS= 2.565

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.895	.741	.775
MINIMUM X	:	-1.391	-.954	-.920
MAXIMUM Y	:	1.235	1.298	1.151
MINIMUM Y	:	-1.240	-1.177	-.782
CENTROID X	:	.040	.194	.160
CENTROID Y	:	.143	.080	.227
POA TO CENTROID in.	:	.149	.210	.278
MIN RADIUS	:	.429	.452	.310
MEAN RADIUS	:	.913	.838	.781
MAX RADIUS	:	1.501	1.314	1.176
HORIZONTAL SPREAD	:	2.286	1.695	1.695
VERTICAL SPREAD	:	2.475	2.475	1.933
EXTREME SPREAD	:	2.565	2.476	1.976
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

GFM

CONTRACT # DAAA21-87-C-0086

New Barrel

GUN SERIAL # C6349045

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		5/4/93	RW
600	Proof		5/4/93	RW
607	Check Headspace		5/4/93	RW
610	Dis-assemble Gun		5/4/93	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		5/14/93	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/14/93	RW
	C) Inspect Ejector Hole for Chamfer		5/14/93	RW
	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						
	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						
630	Gallery Target & Test						
	A) Time						
	B) Malfunctions						
	C) Pierced Primers						
	D) Optical Clarity of Scope						
645	Inspect for Live Ammo					5/17/93	EW
655	Final Inspection						
	A) Headspace					5/18/93	EW
	B) Trigger Pull						
	C) Function					5/17/93	EW
660	Pack						

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06349845
21 May 1993

CENTROIDAL DISTANCES

0 TO	1	.0495782
1 TO	2	.510272
1 TO	3	.756469
1 TO	4	.477151
1 TO	5	.626867

3 2
+ (----POB
t

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0718
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .009
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0723619

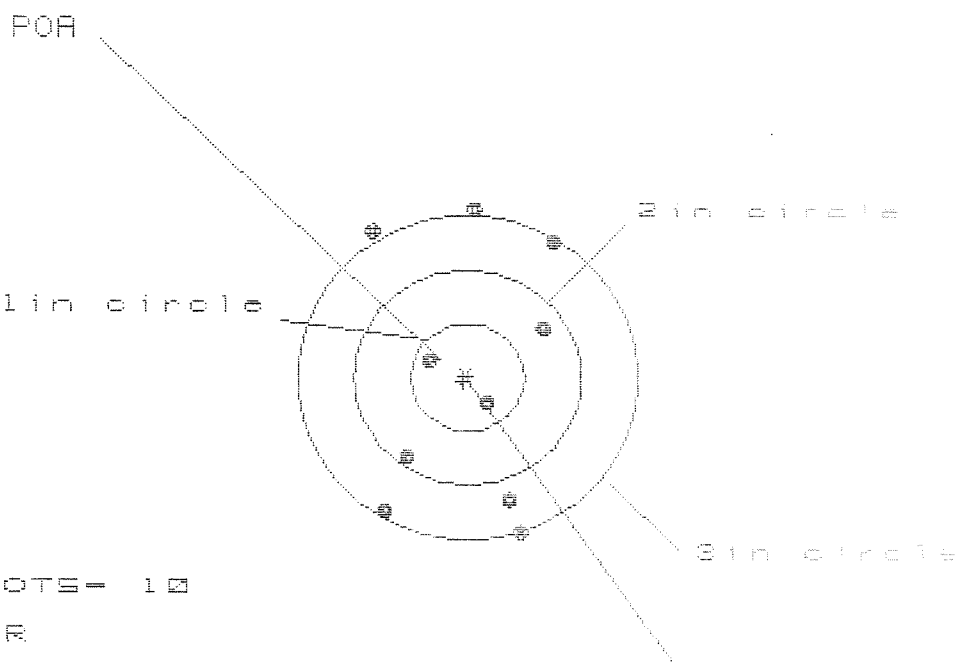
THE AMR FOR THIS RIFLE IS: 1.003

21 May 1993

FILE:/PATTERNING/CENTERFIRE_PATT/08349045

CENTERFIRE PATTERNS

1



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 4

3 in = 7

HS= 1.570

VS= 3.024

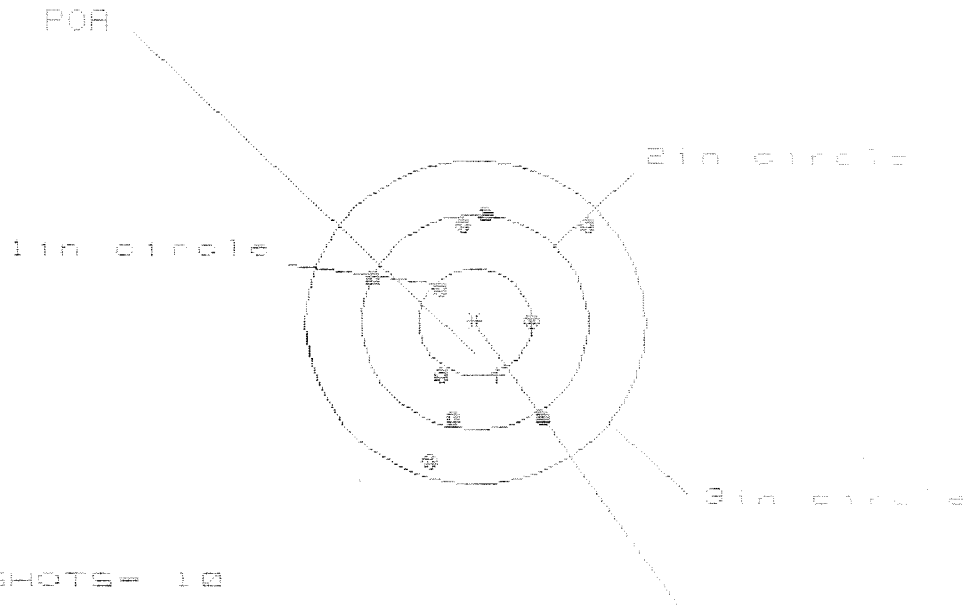
GS= 3.088

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.805	.709	.708
MINIMUM X	-.865	-.836	-.837
MAXIMUM Y	1.559	1.707	1.585
MINIMUM Y	-1.465	-1.317	-1.103
CENTROID X	.033	.129	.130
CENTROID Y	.037	-.111	-.325
POA TO CENTROID in.	.049	.170	.350
MIN RADIUS	.283	.109	.114
MEAN RADIUS	1.124	1.049	.944
MAX RADIUS	1.588	1.707	1.736
HORIZONTAL SPREAD	1.670	1.545	1.545
VERTICAL SPREAD	3.024	3.024	2.688
EXTREME SPREAD	3.088	3.046	2.919
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	7		

21 May 1993

FILE:/PATTERNING/CENTERFIRE_PAT/08349043

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1 in = 2

2 in = 6

3 in = 10

HS= 1.948

VS= 2.301

GS= 2.562

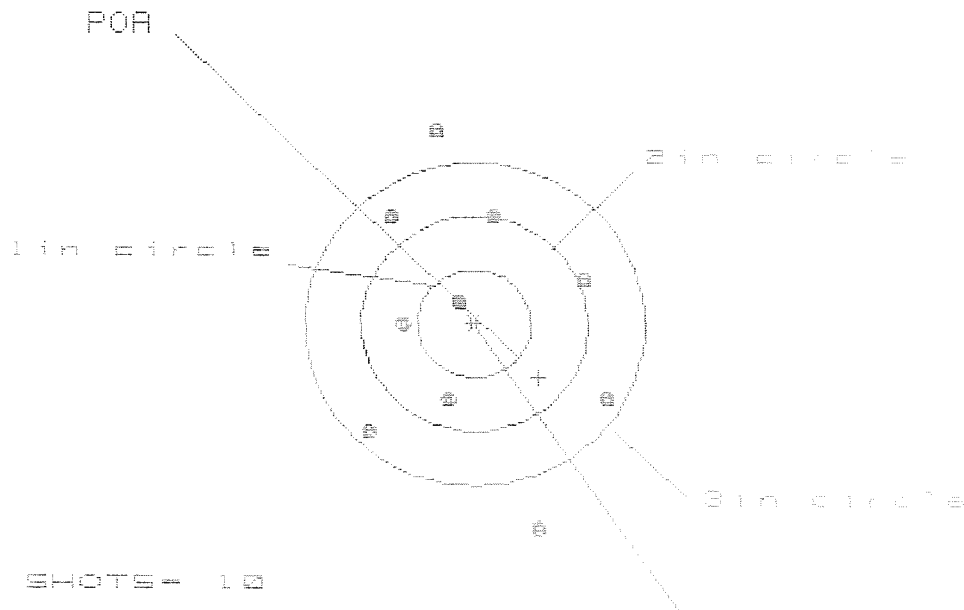
CENTROID +

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.034	.659	.626
MINIMUM X	:	-.914	-.799	-.832
MAXIMUM Y	:	1.049	1.147	1.003
MINIMUM Y	:	-1.252	-1.154	-.949
CENTROID X	:	-.194	-.309	-.276
CENTROID Y	:	.494	.396	.540
POA TO CENTROID in.	:	.531	.502	.506
MIN RADIUS	:	.440	.461	.352
MEAN RADIUS	:	.918	.857	.806
MAX RADIUS	:	1.360	1.184	1.137
HORIZONTAL SPREAD	:	1.948	1.458	1.458
VERTICAL SPREAD	:	2.301	2.301	1.952
EXTREME SPREAD	:	2.562	2.359	1.994
NUMBER IN ONE INCH CIRCLE =			2	
NUMBER IN TWO INCH CIRCLE =			6	
NUMBER IN THREE INCH CIRCLE =			10	

21 May 1993

FILE:/PATTERNING/CENTERFIRE_PATT/L8349045

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 3

3 in = 6

HS= 2.073

VS= 3.615

GS= 3.715

CENTROID +

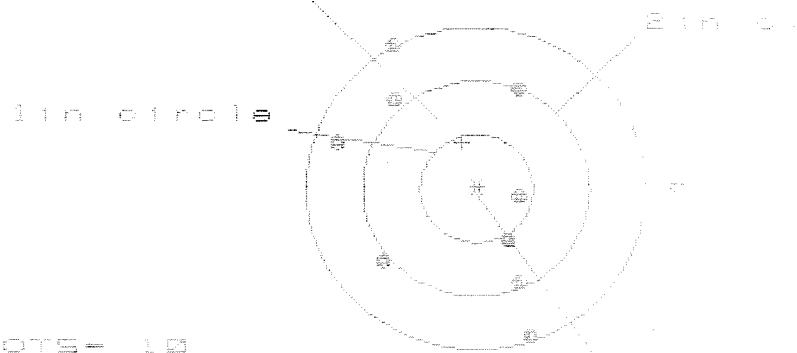
PATTERN #	1	3	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.146	1.209	1.181
MINIMUM X	-1.927	-1.864	-1.892
MAXIMUM Y	1.755	1.549	1.988
MINIMUM Y	-1.860	-1.232	-1.035
CENTROID X	-1.566	-1.629	-1.801
CENTROID Y	.499	.705	1.112
POA TO CENTROID in.	.754	.945	.789
MIN RADIUS	.212	.039	.186
MEAN RADIUS	1.130	1.004	.941
MAX RADIUS	1.945	1.565	1.397
HORIZONTAL SPREAD	2.073	2.073	2.073
VERTICAL SPREAD	3.615	2.781	2.027
EXTREME SPREAD	3.715	2.873	2.511
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		3	
NUMBER IN THREE INCH CIRCLE =		8	

21 May 1993

FILE:/PATTERNING/CENTERFIRE_PAT_0145

CENTERFIRE PATTERNING

FOR



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 4

3 in = 5

HS= 3.019

VS= 2.609

GS= 3.047

PATTERN #

4

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.762

.619

1.047

MINIMUM X

-1.257

-1.062

-1.153

MAXIMUM Y

1.288

1.291

1.067

MINIMUM Y

-1.321

-1.318

-1.157

CENTROID X

.126

-.069

.002

CENTROID Y

-.431

-.434

-.595

FOR TO CENTROID in.

.449

.439

.560

MIN RADIUS

.426

.618

.500

MEAN RADIUS

1.094

1.022

.945

MAX RADIUS

1.762

1.457

1.286

HORIZONTAL SPREAD

3.019

1.681

1.681

VERTICAL SPREAD

2.609

2.609

2.224

GREME SPREAD

3.047

1.807

1.427

NUMBER IN ONE INCH CIRCLE =

1

NUMBER IN TWO INCH CIRCLE =

4

NUMBER IN THREE INCH CIRCLE =

5

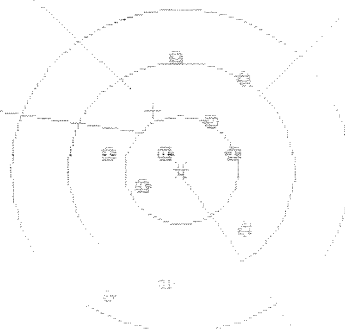
21 May 1993

FILED PATTERNING/CENTER FIRE 1045045

CENTERFIRE PATTERN

POA

1 in circle



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 6

3 in = 10

HS= 1.154

VS= 2.186

GS= 2.301

CENTROID

PATTERN #

5

SHOTS (BEST OF)	10	9	8
MAXIMUM X	.556	.489	.463
MINIMUM X	-.598	-.665	-.611
MAXIMUM Y	1.064	.939	.801
MINIMUM Y	-1.127	-1.181	-1.056
CENTROID X	.277	.305	.277
CENTROID Y	-.554	-.429	-.429
POA TO CENTROID INCH	.604	.529	.464
MIN RADIUS	.259	.240	.262
MEAN RADIUS	.751	.677	.596
MAX RADIUS	1.271	1.200	1.067
HORIZONTAL SPREAD	1.154	1.154	1.154
VERTICAL SPREAD	2.186	2.186	2.186
EXTREME SPREAD	2.301	2.301	2.301
NUMBER IN ONE INCH CIRCLE =	3	3	3
NUMBER IN TWO INCH CIRCLE =	6	6	6
NUMBER IN THREE INCH CIRCLE =	10	10	10

WARNING: Unauthorized persons removing, defacing, or destroying this tag may be subject to a fine of not more than \$1,000 or imprisonment for not more than one year or both. (18 USC 1361)

FSN, PART NO. AND ITEM DESCRIPTION

1005-01-240-2136
M24

UNSERVICEABLE (REPARABLE)
TAG - MATERIEL

INSPECTION ACTIVITY

NAIC 4/22 INF

CONDITION

CODE
F

REASON FOR REPARABLE CONDITION

BARREL SERVICE

SERIAL NO./LOT NO.

C63490415/891256

UNIT OF

ISSUE

EA

CONTRACT OR PURCHASE

ORDER NO.

QUANTITY

1

REMOVED FROM

10

Dol Maint Div 3017

INSPECTOR'S NAME OR STAMP AND DATE

12 MAR 93

Inspected By

JUL 7. Amos

REMARKS

NETS

DD FORM 1577-2, 1 OCT 66
* U.S. GPO: 1965-487-343