

C6349073

MODEL 700TM M24

Model SWS TM

Action _____

Barrel Length _____

Capacity _____

Order No. 5716

*Includes 1 in chamber.

Remington

Repair Inquiry

Repair Number: RE00128535

Serial: C6349073 Model M24 SWS Center Fire
Caliber: 7.62 NATO

Repairman:

Status: New 4/24/2007 7:48:39 AM

Verify Repair

Address Information

Customer:

Received From

Return To:

Received From

Name: ISSD ARMSROOM

ISSD ARMSROOM

Address 1: 8TH DESERT STORM

8TH DESERT STORM

Address 2: BLDG 5210 BAY DOOR #30

PO Box:

BLDG 5210 BAY DOOR #30

PO Box:

City: FORT CAMPBELL

FORT CAMPBELL

State: KY

Zip Code: 42223

Country: US

State: KY

Zip Code: 42223

Country: US

FFL:

Contact / Condition

Problems

Estimate

History / Status

Shipping / Billing

Contact Information

Phone: NN

Fax:

Email:

Comments:

Received Condition

Fair

Condition
Notes:CSR
Notes:

Accessories Received

Code	Desc	Qty
A007	With Stud	3
A010	Hard Case	1
A017	Scope Base	1
A026	Scope	1
A045	Bi Pod	1
A057	Fit and Rear Sgt Base	1

Repair Search

Refresh

Close

nagletj

4/24/2007

8:10 AM

CAPS

NUM

INS

SCRL

start

3 Mi...

5 In...

Arms ...

Part ...

6 Mi...

2 W...

8:10 AM

Serial
Number:

C6349073

Model: M24 SWS



RE00128535

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6349073.__0
FILE DATE AND TIME: 06/01/2007 15:40

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.056
The Average Y Centroid of the Five Target Set:	-0.027
The Average Point of Impact of the Five Target Set:	0.062
The Average Mean Radius of the Five Target Set:	0.580
The Distance from POA to Centroid Target #1:	0.175
The Distance from Centroid Target #2 to Centroid Target #1:	0.409
The Distance from Centroid Target #3 to Centroid Target #1:	0.220
The Distance from Centroid Target #4 to Centroid Target #1:	0.166
The Distance from Centroid Target #5 to Centroid Target #1:	0.352

SERIAL NUMBER: C6349073. __0

TARGET NUMBER: 1

FILE DATE: 06/01/2007

FILE TIME: 15:40

POINT#	X	Y
1:	0.143	0.362
2:	0.469	-0.073
3:	-0.089	0.089
4:	-0.304	0.034
5:	-0.267	-0.264
6:	-0.092	-0.320
7:	-0.251	-0.407
8:	-0.196	-0.741
9:	0.834	-1.667
10:	1.140	1.915

X CENTROID: 0.139

Y CENTROID: -0.107

POA TO CENTROID: 0.175

HORZ SPREAD: 1.444

VERT SPREAD: 3.582

GROUP SPREAD: 3.595

MIN RADIUS: 0.301

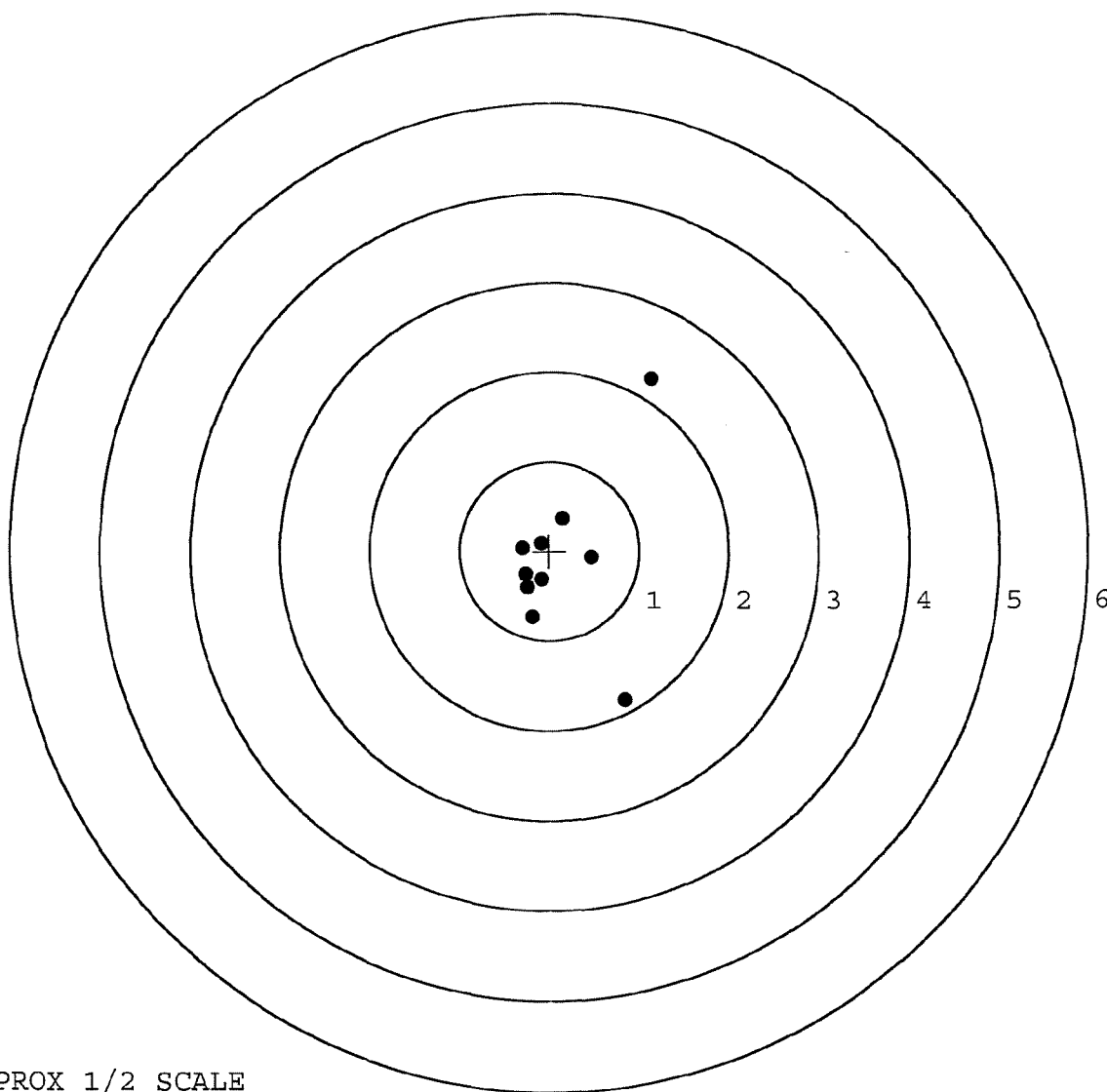
MAX RADIUS: 2.257

MEAN RADIUS: 0.749

IN 1 IN DIAMETER: 7

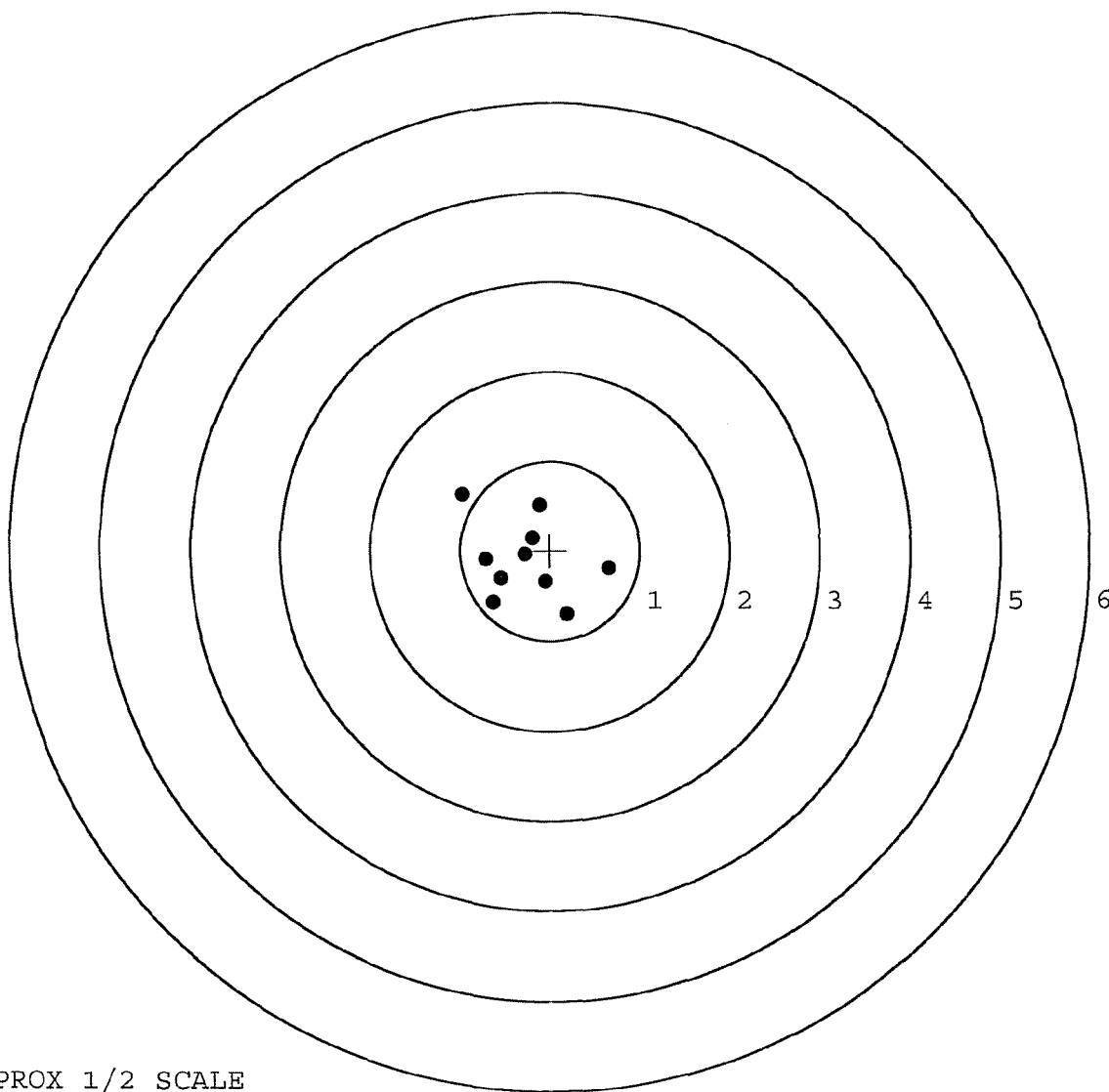
IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 8



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6349073. __0	POINT#	X	Y
TARGET NUMBER: 2	1:	-0.123	0.511
FILE DATE: 06/01/2007	2:	-0.199	0.145
FILE TIME: 15:40	3:	-0.714	-0.098
	4:	-0.549	-0.307
X CENTROID: -0.270	5:	-0.284	-0.043
Y CENTROID: -0.099	6:	-0.055	-0.347
POA TO CENTROID: 0.287	7:	0.657	-0.197
HORZ SPREAD: 1.633	8:	0.180	-0.713
VERT SPREAD: 1.345	9:	-0.635	-0.575
GROUP SPREAD: 1.831	10:	-0.976	0.632
MIN RADIUS: 0.058			
MAX RADIUS: 1.017			
MEAN RADIUS: 0.537			
# IN 1 IN DIAMETER: 5			
# IN 2 IN DIAMETER: 9			
# in 3 IN DIAMETER: 10			



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6349073. __0

TARGET NUMBER: 3

FILE DATE: 06/01/2007

FILE TIME: 15:40

POINT#	X	Y
1:	-0.838	0.217
2:	-1.541	-0.425
3:	0.362	0.126
4:	-0.026	0.021
5:	-0.198	0.036
6:	-0.255	-0.228
7:	-0.056	-0.454
8:	0.812	-0.197
9:	1.038	-0.031
10:	-0.102	0.013

X CENTROID: -0.080

Y CENTROID: -0.092

POA TO CENTROID: 0.122

HORZ SPREAD: 2.579

VERT SPREAD: 0.671

GROUP SPREAD: 2.609

MIN RADIUS: 0.107

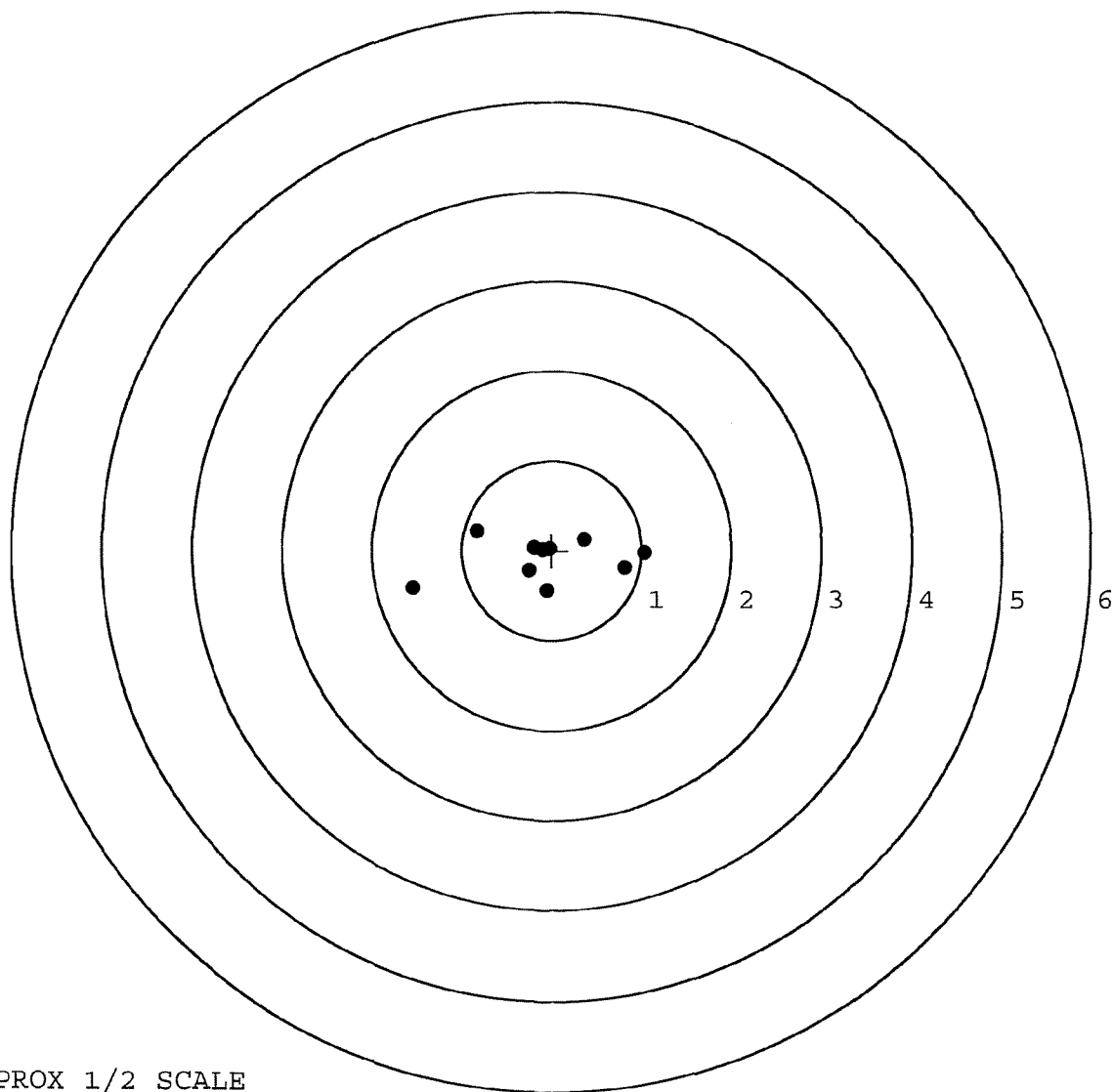
MAX RADIUS: 1.498

MEAN RADIUS: 0.582

IN 1 IN DIAMETER: 6

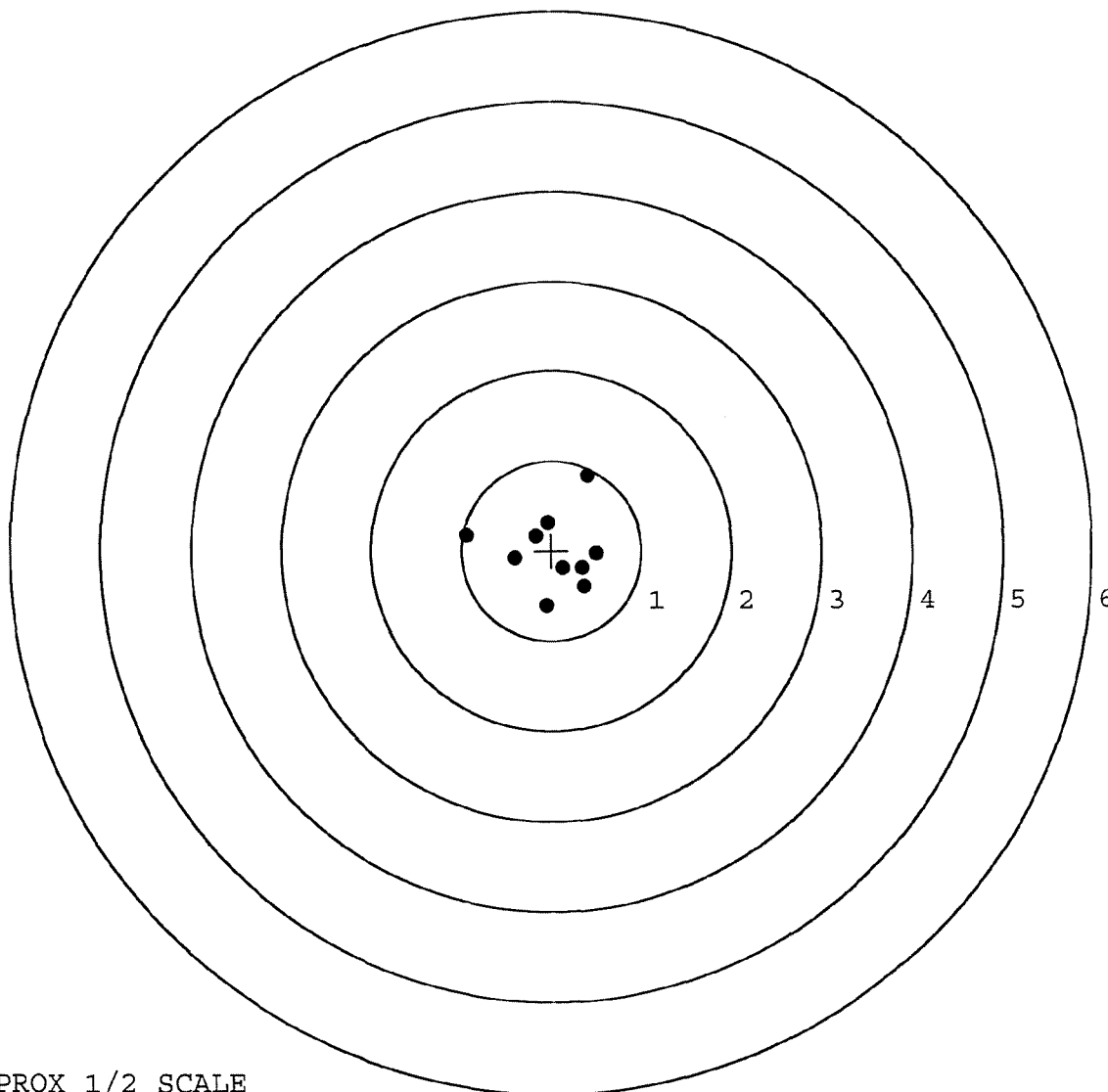
IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6349073. __0	POINT#	X	Y
TARGET NUMBER: 4	1:	0.405	0.835
FILE DATE: 06/01/2007	2:	-0.053	0.311
FILE TIME: 15:40	3:	-0.174	0.161
	4:	-0.409	-0.083
X CENTROID: 0.010	5:	-0.943	0.177
Y CENTROID: -0.003	6:	-0.061	-0.617
POA TO CENTROID: 0.010	7:	0.125	-0.199
HORZ SPREAD: 1.447	8:	0.362	-0.398
VERT SPREAD: 1.452	9:	0.342	-0.191
GROUP SPREAD: 1.500	10:	0.504	-0.028
MIN RADIUS: 0.227			
MAX RADIUS: 0.970			
MEAN RADIUS: 0.514			
# IN 1 IN DIAMETER: 6			
# IN 2 IN DIAMETER: 10			
# in 3 IN DIAMETER: 10			



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6349073. 0

TARGET NUMBER: 5

FILE DATE: 06/01/2007

FILE TIME: 15:40

POINT#	X	Y
1:	-0.952	0.449
2:	-0.444	0.213
3:	-0.127	0.293
4:	-0.351	0.131
5:	-0.026	-0.118
6:	0.129	-0.109
7:	0.352	0.136
8:	0.663	-0.068
9:	-0.324	-0.382
10:	0.289	1.143

X CENTROID: -0.079

Y CENTROID: 0.169

POA TO CENTROID: 0.186

HORZ SPREAD: 1.615

VERT SPREAD: 1.525

GROUP SPREAD: 1.644

MIN RADIUS: 0.133

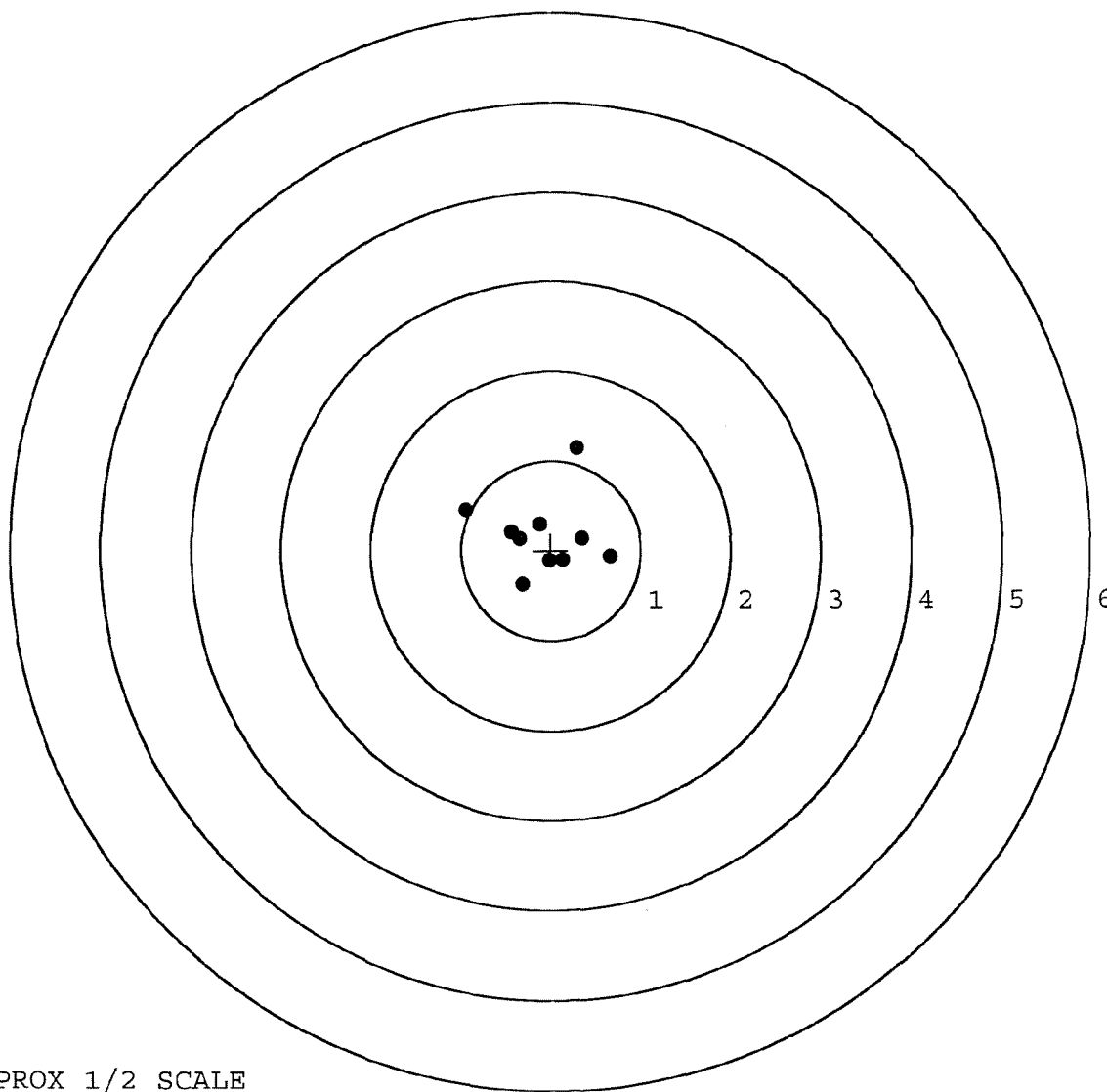
MAX RADIUS: 1.041

MEAN RADIUS: 0.519

IN 1 IN DIAMETER: 6

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

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

R & E NUMBER	128535		
SERIAL NUMBER	C6349073		
LOG-IN DATE	4-24-07		
OPERATION #	OPERATION NAME	DATE	INITIAL
500	DIS-ASSEMBLE GUN	5-16-07	RTZ
505	RE-BARREL	5-18-07	RTZ
560	ASSEMBLE	5-18-07	RTZ
600	PROOF	5-18-07	TRW
605	CHECK HEADSPACE	5-18-07	TRW
610	DIS-ASSEMBLE GUN	5-21-07	RTZ
612	MAGNAFLUX	5-21-07	TRW
510	DRILL AND TAP	5-21-07	TRW
615	ROLLMARK CALIBER	5-21-07	CW
618	ROTO-BLAST	5-22-07	UB
620	APPLY COATINGS	5-24-07	W
625	FINAL ASSEMBLY	5-31-07	RTZ
640	FUNCTION TEST AND	PASS FAIL 6-1-07	TRW
650	TARGET	PASS FAIL 6-1-07	TRW
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
670	FINAL INSPECTION	6-1-07	TRW
	A) HEADSPACE	PASS FAIL 6-7-07	RTZ
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	2.77 2.73 2.84 2.88 2.91 6-4-07 DA
680	F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX	4.5 4.5 4.5 6-4-07 DA
	G) SAFETY OFF FORCE	2 LBS MIN	2.5 2.5 2.5 6-4-07 DA
	I) FIRING PIN INDENT	.020	.0245 .024 .024 6-4-07 DA
690	PACK		6-8-07 DA

Cco 93A

MAINTENANCE REQUEST				PAGE NO.	NO. OF PAGES	REQUIREMENTS CONTROL SYMBOL			
For use of this form, see DA PAM 738-750; the proponent agency is DCSLOG				1	1	CSGLD - 1047(R1)			
SECTION I - EQUIPMENT DATA									
CONTROL NUMBER		WORK ORDER NO.		WESDC		ORG PD		PD AUTHENTICATION	
☐ Work Request ☐ MWO ☒ Warranty Claim		1A. ORGANIZATION Cco 3/5 SFG (A)		B. LOCATION Ft Campbell Ky 42223			C. UNIT IDENT CODE WHOGCC		
2. SERIAL NO. 6349073		3. NOUN NOMENCLATURE 7.62 Sniper Rifle m24		4. LINE NO. R95387		5. MODEL		6. NATIONAL STOCK NUMBER 1005-01-240-2136	
7A. MAINTENANCE ACTIVITY IMO		B. LEVEL		8. UTILIZATION CODE		9A. MCSR ITEM		9B. ERC	
								10. HOURS	
								11. MILES	
								12. ROUNDS	
								13. STARTS	
14. FAILURE DETECTED DURING (Select one - use ☒ or X)					15. FIRST INDICATION OF TROUBLE (Select one - use ☒ or X)				
☐ A Sch. Main. ☐ C Test ☐ E Storage ☐ G Flight ☐ B Handling ☐ D Normal Op ☐ F Inspection ☒ H Other					☐ 058 Inoperative ☐ 258 Overheating ☐ 790 Out of Adjustment ☐ 008 Noisy ☐ 387 Low Performance ☒ Other				
16A. DESCRIBE DEFICIENCIES OR SYMPTOMS ON THE BASIS OF COMPLETE CHECKOUT AND DIAGNOSTIC PROCEDURE IN EQUIPMENT TM (Do not prescribe repairs) 5,400 Rnds Fired									
B. REMARKS W52H095-345H-245									
PREPARATION INSTRUCTIONS (Prior to using this form, read DA PAM 738-750 for detailed preparation instructions)									
1. Place a "✓" or an "X" in the box for the type of action required. 2. Enter the WESDC if the item is Materiel Condition Status Reportable. 3. Enter the priority designator as determined from the urgency of need and force activity designator. 4. The Unit Commander, Chief of TDA activity or their designated representative will authenticate, by signature, a priority of 01 through 08. 5. Block 1A. Enter the name of the organization submitting the request. 6. Block 1B. Enter the unit submitting the request; units overseas enter APO only. 7. Block 1C. Enter the unit identification code of the unit in block 1A. 8. Block 2. Enter the equipment serial number. For ammunition, enter the lot number. For administrative-use vehicles, enter the USA registration number. 9. Block 3. Enter the noun abbreviation of the item. 10. Block 4. Enter the item line number, if applicable. 11. Block 5. Enter the model number. 12. Block 6. Enter the National Stock Number of the item listed in Block 3.					13. Block 7. Enter the name of the support activity. 14. Block 7A. Enter the symbol of the maintenance category (O, F, H, D, or L). 15. Block 8. Enter the utilization code. 16. Block 9A. Enter the word "yes" if the item is Materiel Condition Status Reportable. 17. Block 9B. Enter the equipment readiness code, if applicable. 18. Block 9C. Enter the word "yes" if the item is a pacing item. 19. Block 10. Enter the hour reading, if applicable. 20. Block 11. Enter the mileage from the odometer, if applicable. 21. Block 12. Enter the total rounds fired, if applicable. 22. Block 13. For turbine engines, enter the number of hot starts. 23. Block 14. Enter a "✓" or "X" in the proper block. 24. Block 15. Enter a "✓" or "X" in the proper block. 25. Block 16. Describe briefly the fault or symptoms needing correction.				
23. SUBMITTED BY 		24. RECEIVED BY							
JULIAN DATE		JULIAN DATE							

DA FORM 2407, AUG 88

EDITION OF MAY 81 MAY BE USED

RECEIPT COPY 1

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

M2400107244

MAINTENANCE REQUEST				PAGE NO.	NO OF PAGES	REQUIREMENTS CONTROL SYMBOL	
For use of this form, see DA PAM 738-750; the proponent agency is DCSLOG				1	1	CSGLD - 1047(R1)	
SECTION I - EQUIPMENT DATA							
CONTROL NUMBER		WORK ORDER NO.		WESDC		ORG. PD	
☐ Work Request ☐ MWO ☒ Warranty Claim		1A. ORGANIZATION <i>Cco 3/5 SFG (A)</i>		B. LOCATION <i>Ft. Campbell Ky 42223</i>		C. UNIT IDENT CODE <i>WH0660</i>	
2. SERIAL NO. <i>66349073</i>		3. NOUN NOMENCLATURE <i>7.62 Sniper Rifle M24</i>		4. LINE NO. <i>R95387</i>		5. MODEL	
6. NATIONAL STOCK NUMBER <i>1005-01-240-2136</i>							
7A. MAINTENANCE ACTIVITY <i>IMO</i>		B. LEVEL	8. UTILIZATION CODE	9A. MCSR ITEM	9B. ERC	9C. PACING ITEM	10. HOURS
							11. MILES
							12. ROUNDS
							13. STARTS
14. FAILURE DETECTED DURING (Select one - use ☒ or X)				15. FIRST INDICATION OF TROUBLE (Select one - use ☒ or X)			
☐ A Sch. Main. ☐ C Test ☐ E Storage ☐ G Flight ☐ B Handling ☐ D Normal Op ☐ F Inspection ☒ H Other				☐ 068 Inoperative ☐ 258 Overheating ☐ 790 Out of Adjustment ☐ 008 Noisy ☐ 387 Low Performance ☒ Other			
16A. DESCRIBE DEFICIENCIES OR SYMPTOMS ON THE BASIS OF COMPLETE CHECKOUT AND DIAGNOSTIC PROCEDURE IN EQUIPMENT TM (Do not prescribe repairs). <i>5,400 RUDS Fired</i>							
B. REMARKS <i>W52 H095345 H045</i>							
SECTION II - WORK ACCOMPLISHED							
17A. REPAIR ORGANIZATION/ACTIVITY			C. UNIT IDENT. CODE		18. TYPE ORGANIZATION/ACTIVITY ACCOMPLISHING WORK (Select one - use ☒ or X)		19. AMS ACCT CODE
B. LOCATION					☐ 1 TOE ☐ 2 TD ☐ 3 Contractor		
20A. ACT. CODE	B. FAILURE CODE	C. COMPONENT/PART NOUN, SVC, OR MWO NO.			D. MANHOURS (Hrs. & tenths)	E. NATIONAL STOCK NUMBER	F. PART SOURCE CODE
		(1) CB CODE	(2) REF DESIGN	(3) MFR. CODE			G. QTY.
							H. PARTS COST
							\$
							\$
							\$
							\$
							\$
							\$
							\$
							\$
							\$
							\$
							\$
							\$
I. TOTAL MANHOURS					J. TOTAL MANHOURS COST		K. TOTAL PARTS COST
					\$		\$
21. DELAY (Select One) ☐ 1 Parts ☐ 2 Manpower ☐ 3 Facilities ☐ 4 Funds ☐ 5 Tools							
22. Data Transcribed							
23. SUBMITTED BY <i>James J. [Signature]</i>		24. RECEIVED BY		25. WORK STARTED BY		26. INSPECTED BY	
27. ACCEPTED BY							
JULIAN DATE		JULIAN DATE		JULIAN DATE		JULIAN DATE	
28. DISPOSITION (Select One)							
☐ A To User ☐ D Evacuated ☐ B To Stock ☐ E Cannibalization ☐ C Salvaged							

RECEIVING AND ESTIMATING REPORT

COMMENTS

ORDER
R 95-30909

INITIAL CUSTOMER ORDER NO. W/LEUPOLD 10X SCOPE

JJM

SCOPE 88-0556

DATE RECEIVED	DATE OPENED	DATE CODE	SERIAL NUMBER	NEW SERIAL NUMBER	MODEL AND GRADE
12/04/95	12/05/95		C6349073		700 7.62 NATO

ACCESSORIES HARD CASE SCOPE MNTS SCOPE BASE

FROM:

SHIP TO:

TRANSPORTATION OFFICE
FT CAMPBELL

KY 42223

TRANSPORTATION OFFICE
FT CAMPBELLKY
42223

Night Vision Base

CUST NO: 087942 C.O.D.L.

ACCOUNT NUMBER

ACCOUNT NUMBER N/C

WRITE ☐

PROM. DATE

ESTIMATED

VIA

UPS

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

PARTS

COMMENTS

Barrel - 96003
Stock - 96018
Mag Spring - 15677

Re powder Coat Trigger Guard
ASSY, Front & Rear Sight Bases
Reticle Scope Base, Rings &
Swivel Studs

Scope Sent back to Vendor
to be Checked

REPAIRMAN

PROOF

CLEAN

TEST

TARGET

PATTERN

GALLERY TESTER

DATE

DATE

DATE

DATE

DATE

OFFICE COPY

RD6925 REV. 1/94

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

M2400107246

New Barrel

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6349073

OP. #	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and Stock		12/24/95	RW
600	Proof		12/21/95	RW
607	Check Headspace		12/21/95	RW
610	Dis-assemble Gun		12/21/95	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		1/5/96	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		1/5/96	RW
	C) Inspect Ejector Hole for Chamfer		1/5/96	RW
	D) Oil Firing Pin Ass'y		1/5/96	RW
	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							
640	Gallery Target & Test						1/8/96	RW
	A) Time							
	B) Malfunctions							
	C) Pierced Primers							
	D) Optical Clarity of Scope							
645	Inspect for Live Ammo						1/8/96	RW
655	Final Inspection A) Headspace						1/10/96	RW
	B) Trigger Pull	2.15	2.10	2.15	2.25	2.24	1/10/96	RW
	C) Function						1/10/96	RW
660	Pack							

Final Inspection

Sn: C6349073

DATE REC'D: 12/04/95

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:

CENTROIDAL DISTANCES

0	TO	1	.864751
1	TO	2	.666521
1	TO	3	.215281
1	TO	4	.546759
1	TO	5	.393412

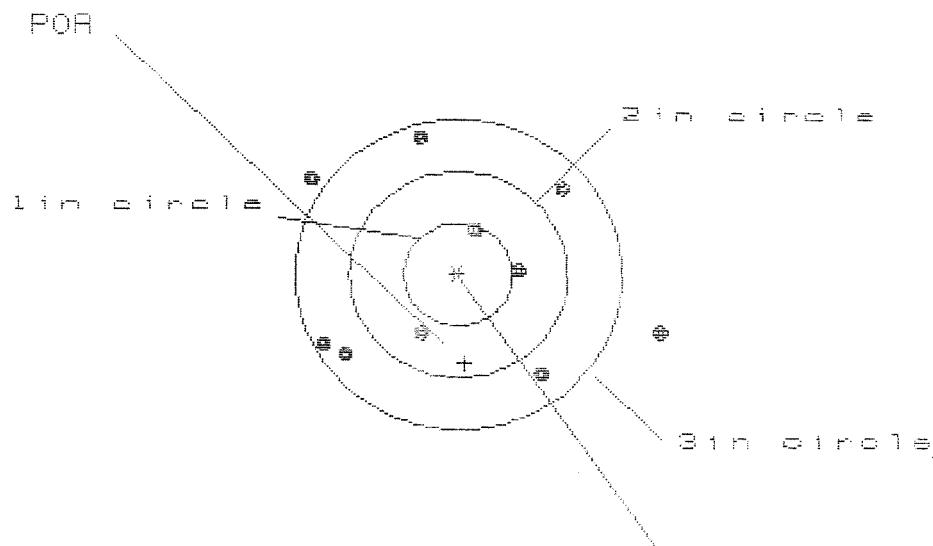
$\frac{d}{dt} \left(\frac{\partial L}{\partial \dot{x}} \right) = \frac{\partial L}{\partial x}$

M2400107250

7 Jan 1908

FILE:/PATTERNING/CENTERFIRE_PATT/C8349073

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 3

3 in = 8

HS = 2.197

VS = 2.261

CS = 3.543

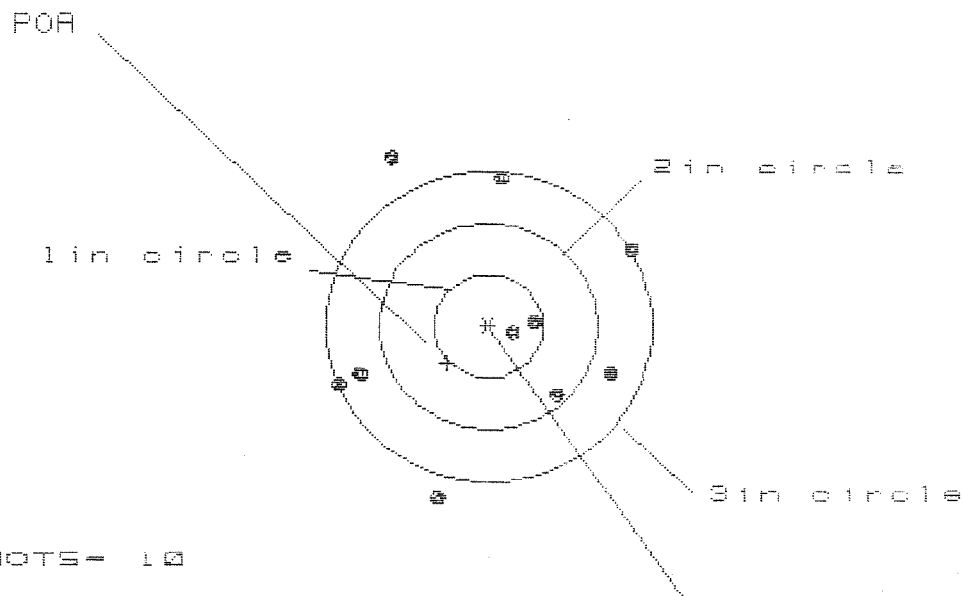
CENTROID *

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.858	1.203	1.061
MINIMUM X	:	-1.339	-1.132	-1.207
MAXIMUM Y	:	1.296	1.232	1.343
MINIMUM Y	:	-0.965	-1.029	-0.918
CENTROID X	:	-0.055	-0.262	-0.120
CENTROID Y	:	.863	.927	.816
POR TO CENTROID in.	:	.865	.963	.825
MIN RADIUS	:	.437	.490	.504
MEAN RADIUS	:	1.185	1.101	1.036
MAX RADIUS	:	1.945	1.439	1.368
HORIZONTAL SPREAD	:	3.197	2.335	2.268
VERTICAL SPREAD	:	2.261	2.261	2.261
EXTREME SPREAD	:	3.543	2.867	2.713
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		8	

7 Jan 1988

FILE:/PATTERNING/CENTERFIRE_PATT/CS349073

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 2

2in = 3

3in = 8

HS= 2.667

VS= 3.290

ES= 3.309

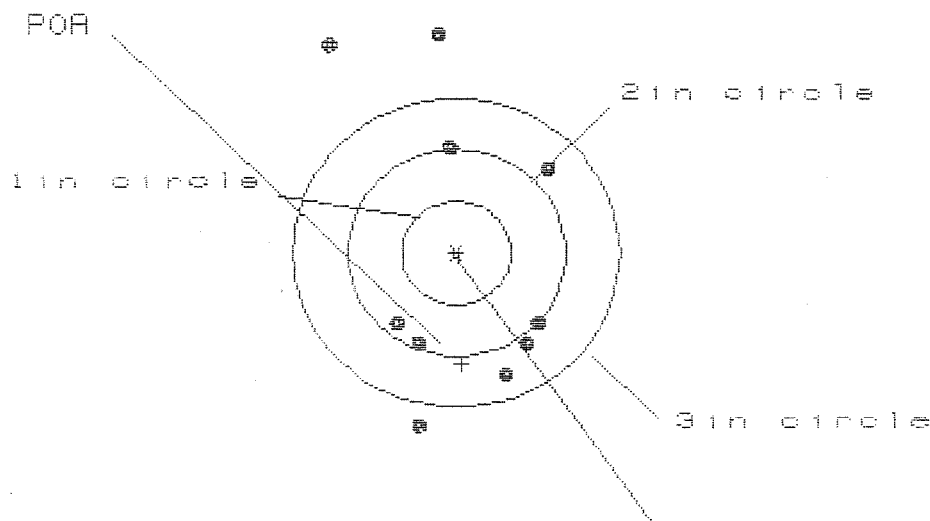
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.301	1.208	1.137
MINIMUM X	:	-1.366	-1.459	-1.530
MAXIMUM Y	:	1.592	1.661	1.471
MINIMUM Y	:	-1.698	-1.521	-1.640
CENTROID X	:	.380	.473	.544
CENTROID Y	:	.358	.181	.371
POA TO CENTROID in.	:	.522	.506	.659
MIN RADIUS	:	.270	.191	.133
MEAN RADIUS	:	1.212	1.112	1.021
MAX RADIUS	:	1.796	1.661	1.648
HORIZONTAL SPREAD	:	2.667	2.667	2.667
VERTICAL SPREAD	:	3.290	3.182	2.111
EXTREME SPREAD	:	3.309	3.231	2.970
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		8	

7 Jan 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C6849073

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 0

2 in = 3

3 in = 7

HS= 2.018

VS= 3.880

GS= 3.891

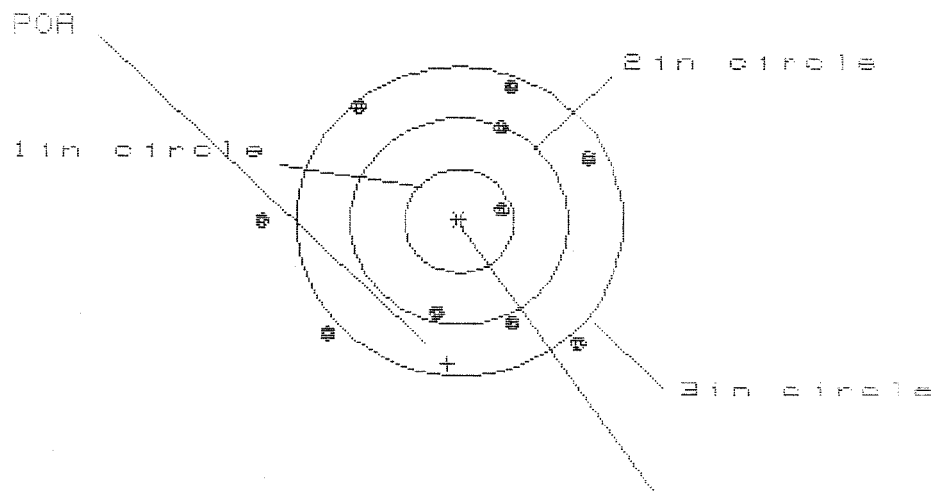
CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.848	.718	.688
MINIMUM X	:	-1.170	-.636	-.666
MAXIMUM Y	:	2.156	2.384	1.513
MINIMUM Y	:	-1.724	-1.496	-1.198
CENTROID X	:	-.044	.086	.116
CENTROID Y	:	1.078	.850	.552
POA TO CENTROID in.	:	1.079	.855	.564
MIN RADIUS	:	.809	.753	.593
MEAN RADIUS	:	1.356	1.181	.944
MAX RADIUS	:	2.363	2.396	1.530
HORIZONTAL SPREAD	:	2.018	1.354	1.354
VERTICAL SPREAD	:	3.880	3.880	2.711
EXTREME SPREAD	:	3.891	3.891	2.820
NUMBER IN ONE INCH CIRCLE =	:		0	
NUMBER IN TWO INCH CIRCLE =	:		3	
NUMBER IN THREE INCH CIRCLE =	:		7	

7 Jan 1988

FILE:/PATTERNING/CENTERFIRE_PATT/08349073

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

CENTROID *

IN CIR

1 in = 1

2 in = 3

3 in = 7

HS= 2.978

VS= 2.486

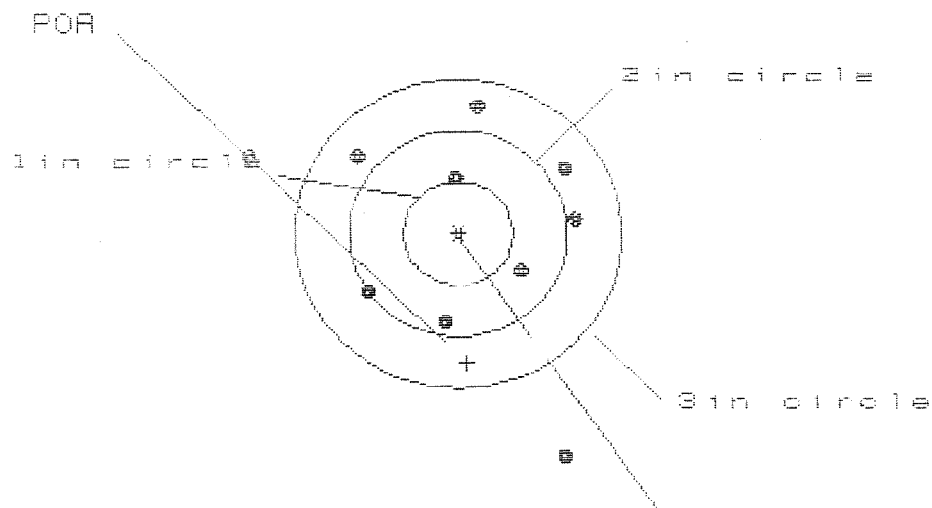
GS= 3.105

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.211	1.015	1.128
MINIMUM X	:	-1.767	-1.369	-1.256
MAXIMUM Y	:	1.321	1.324	1.178
MINIMUM Y	:	-1.165	-1.162	-1.227
CENTROID X	:	.117	.313	.200
CENTROID Y	:	1.382	1.379	1.525
POA TO CENTROID in.	:	1.387	1.415	1.538
MIN RADIUS	:	.341	.155	.261
MEAN RADIUS	:	1.250	1.155	1.119
MAX RADIUS	:	1.767	1.745	1.756
HORIZONTAL SPREAD	:	2.978	2.384	2.384
VERTICAL SPREAD	:	2.486	2.486	2.405
EXTREME SPREAD	:	3.105	3.063	2.950
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		7	

7 Jan 1988

FILE:/PATTERNING/CENTERFIRE_PATT/08349003

CENTERFIRE PATTERNS # 5



OF SHOTS = 10

IN CIR

1 in = 0

2 in = 3

3 in = 8

HS = 2.990

VS = 3.413

CS = 4.058

CENTROID #

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	1.104
MINIMUM X	-1.886
MAXIMUM Y	1.234
MINIMUM Y	-2.179
CENTROID X	-.073
CENTROID Y	1.256
POR TO CENTROID in.	1.258
MIN RADIUS	.505
MEAN RADIUS	1.210
MAX RADIUS	2.374
HORIZONTAL SPREAD	2.990
VERTICAL SPREAD	3.413
EXTREME SPREAD	4.058
NUMBER IN ONE INCH CIRCLE	0
NUMBER IN TWO INCH CIRCLE	3
NUMBER IN THREE INCH CIRCLE	8




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

REG. U.S. PAT. & TM. OFF.

MODEL 700TM M24

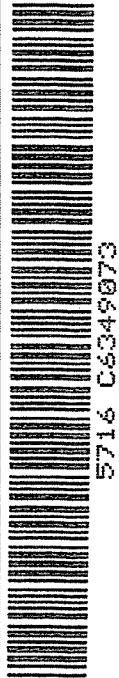
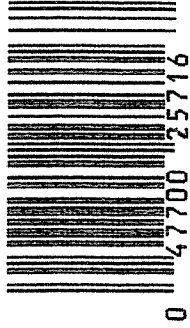
SERIAL NO.
C6349073

ORDER NO.
5716

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

01

UPC



CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6349073

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	4 12 90		RW
600	Proof	4 12 90		K
607	Check Headspace	4 12 90		K
610	Dis-assemble Gun	4 12 90		RW
612	Magnaflux Barrel Action	4-19-90		KER
	Magnaflux Bolt	4-19-90		KER
615	Rollmark Caliber	4-19-90		B.S.
617	Drill and Tap Sight Holes		4/23/90	FB
618	Polish Barrel RB		4/24/90	WB
620	Apply Coatings (Barrel Action)		4/30/90	TJA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		5/1/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/1/90	RW
	C) Inspect Ejector Hole for Chamfer		5/1/90	RW
	D) Oil Firing Pin Ass'y		5/1/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		5/1/90	WB

op. #	OP. NAME	READINGS			DATE	INIT		
625 cont.	F) Safety On Force	5 1/4	5 1/4	5	5/18/90	WB		
	G) Safety Off Force	2 1/4	2	2	5/18/90	WB		
	H) Trigger Pull Test & Retainability				5/18/90	WB		
	I) Firing Pin Indent	.024	.0235	.024	5/18/90	WB		
	J) Assemble Stock				5/19/90	RW		
	K) Assemble Swivel Studs				25 May 90	JD		
	L) Attach Front and Rear Sight Assemblies				5/19/90	RW		
	M) Iron Sight Alignment				5/19/90	RW		
	N) Detach Front & Rear Sights & place in numbered container				5/19/90	RW		
	O) Attach Scope to Rifle				5/19/90	RW		
	P) Detach & Attach Scope 20 Times				5/19/90	RW		
640	Gallery Target & Test				5-19-90	AC		
	A) Time				5-19-90	AC		
	B) Malfunctions				5-19-90	AC		
	C) Pierced Primers				5-19-90	AC		
	D) Optical Clarity of Scope				5-19-90	AC		
645	Inspect for Live Ammo				5-19-90	AC		
655	Final Inspection							
	A) Headspace				25 May 90	JD		
	B) Trigger Pull	279	273	269	272	276	25 May 90	JD
	C) Function						25 May 90	JD
660	Pack						6/20/90	JD

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06349073
21 May 1990

CENTROIDAL DISTANCES

0 TO	1	.725668
1 TO	2	.13222
1 TO	3	.720605
1 TO	4	.337627
1 TO	5	1.06598

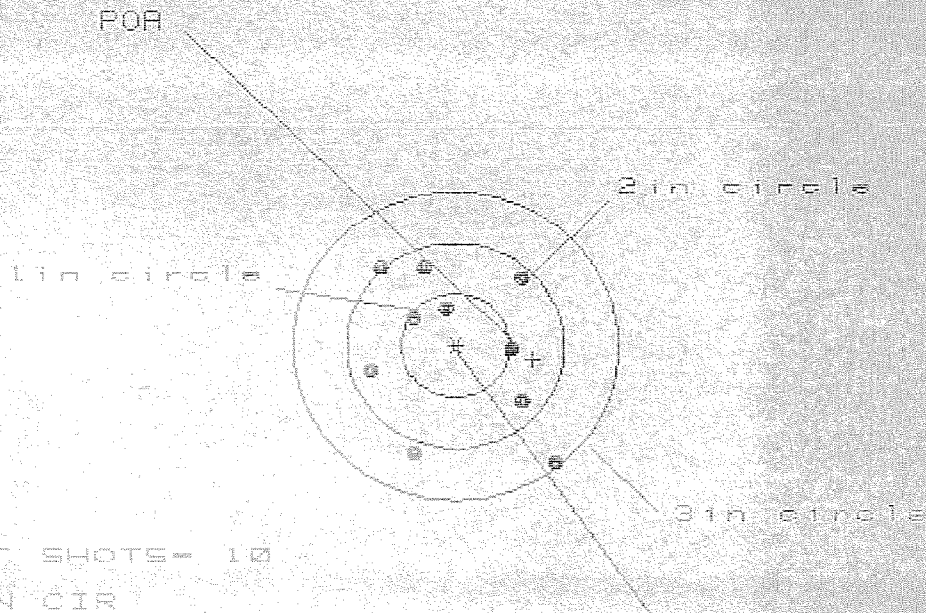
5
4 3 ←---POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.3796
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0522
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .683172
THE AMR FOR THIS RIFLE IS: .7372

21 May 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6349073

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1in = 3

2in = 7

3in = 10

HS= 1.684

VS= 1.899

GS= 2.470

CENTROID *

PATTERN #

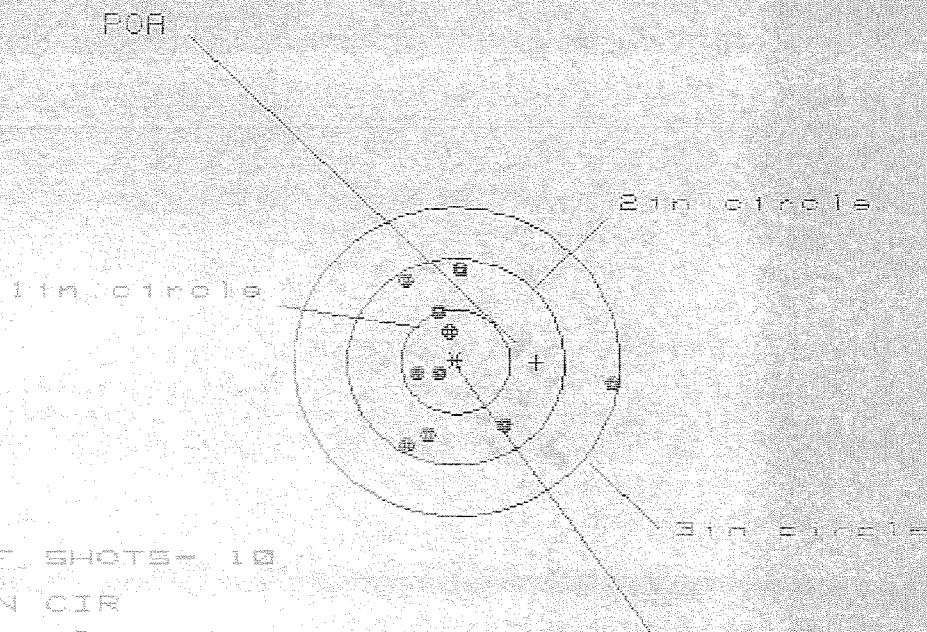
13

SHOTS (BEST OF)	10	9	8
MAXIMUM X	.888	.734	.697
MINIMUM X	-.806	-.708	-.745
MAXIMUM Y	.811	.690	.550
MINIMUM Y	-1.088	-1.116	-.811
CENTROID X	-.713	-.811	-.774
CENTROID Y	.135	.256	.396
POA TO CENTROID in.	.725	.851	.859
MIN RADIUS	.401	.283	.139
MEAN RADIUS	.824	.730	.644
MAX RADIUS	1.404	1.155	1.069
HORIZONTAL SPREAD	1.694	1.442	1.442
VERTICAL SPREAD	1.899	1.806	1.361
EXTREME SPREAD	2.470	1.914	1.902
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		10	

21 May 1990

FILE:/PATTERNING/CENTERFIRE_PATT/06349073

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 3

2in = 9

3in = 10

HS= 1.892

VS= 1.690

GS= 2.126

CENTROID *

PATTERN #

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.416	.590	.555
MINIMUM X	-.476	-.319	-.354
MAXIMUM Y	.884	.861	.963
MINIMUM Y	-.806	-.829	-.727
CENTROID X	-.742	-.899	-.884
CENTROID Y	.006	.029	-.073
POA TO CENTROID in.	.742	.899	.867
MIN RADIUS	.201	.100	.066
MEAN RADIUS	.714	.599	.563
MAX RADIUS	1.430	.888	.976
HORIZONTAL SPREAD	1.892	.909	.909
VERTICAL SPREAD	1.690	1.690	1.690
EXTREME SPREAD	2.126	1.767	1.767
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		9	
NUMBER IN THREE INCH CIRCLE =		10	

21 May 1990

FILE:/PATTERNING/CENTERFIRE_PATT/06349073

CENTERFIRE PATTERNS # 3

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS= 10

IN CIR

1in = 3

2in = 7

3in = 10

HS= 1.881

VS= 1.844

CS= 2.359

PATTERN #

3

SHOTS (BEST OF)

10

9

8

MAXIMUM X

.961

.696

.594

MINIMUM X

-.920

-.813

-.310

MAXIMUM Y

1.018

.915

.803

MINIMUM Y

-.926

-.898

-.725

CENTROID X

-.147

-.254

-.152

CENTROID Y

-.311

-.208

-.096

POA TO CENTROID in.

.344

.328

.180

MIN RADIUS

.231

.092

.191

MEAN RADIUS

.730

.641

.565

MAX RADIUS

1.335

1.211

.999

HORIZONTAL SPREAD

1.881

1.509

.913

VERTICAL SPREAD

1.944

1.813

1.528

EXTREME SPREAD

2.359

2.359

1.727

NUMBER IN ONE INCH CIRCLE =

3

NUMBER IN TWO INCH CIRCLE =

7

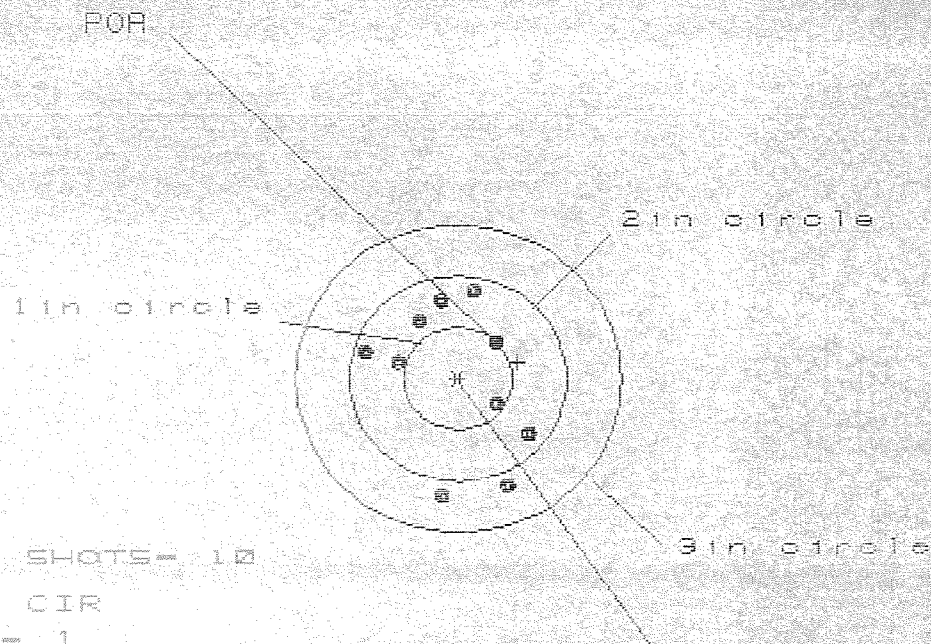
NUMBER IN THREE INCH CIRCLE =

10

21 May 1998

FILE:/PATTERNING/CENTERFIRE_PATT/CS349073

CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1in = 1

2in = 8

3in = 10

HS= 1.456

VS= 1.985

GS= 2.004

CENTROID #

PATTERN #

1

SHOTS (BEST OF)

10

9

8

MAXIMUM X

.629

.678

.667

MINIMUM X

-.827

-.778

-.789

MAXIMUM Y

.863

.742

.587

MINIMUM Y

-1.122

-1.243

-.802

CENTROID X

-.547

-.596

-.585

CENTROID Y

-.159

-.038

.117

POA TO CENTROID in.

.570

.598

.596

MIN RADIUS

.438

.480

.367

MEAN RADIUS

.776

.708

.607

MAX RADIUS

1.175

1.246

1.043

HORIZONTAL SPREAD

1.456

1.456

1.456

VERTICAL SPREAD

1.985

1.985

1.389

EXTREME SPREAD

2.004

2.004

1.652

NUMBER IN ONE INCH CIRCLE =

1

NUMBER IN TWO INCH CIRCLE =

8

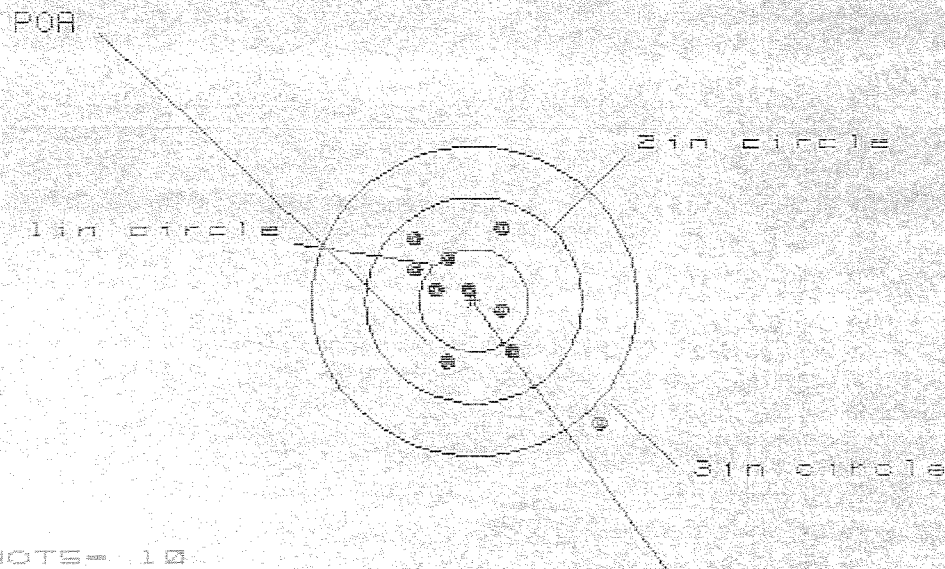
NUMBER IN THREE INCH CIRCLE =

10

21 May 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6349073

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 3

2in = 9

3in = 9

HS= 1.769

VS= 1.872

GS= 2.498

CENTROID *

PATTERN #	5	6	7
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.196	.451	.398
MINIMUM X	-.573	-.440	-.493
MAXIMUM Y	.711	.582	.643
MINIMUM Y	-1.181	-.695	-.634
CENTROID X	.251	.118	.171
CENTROID Y	.590	.719	.658
POA TO CENTROID in.	.641	.728	.680
MIN RADIUS	.090	.096	.015
MEAN RADIUS	.642	.495	.470
MAX RADIUS	1.667	.784	.742
HORIZONTAL SPREAD	1.769	.891	.891
VERTICAL SPREAD	1.872	1.277	1.277
EXTREME SPREAD	2.498	1.430	1.387
NUMBER IN ONE INCH CIRCLE =	3	3	3
NUMBER IN TWO INCH CIRCLE =	9	9	9
NUMBER IN THREE INCH CIRCLE =	9	9	9

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

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

SERIAL NO. C6349073

DATE 5/18/90

TESTER WLB

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.21	2.10	2.15	2.79	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.28	2.14	2.13	2.73	
PULL #3	2.19	2.13	2.10	2.69	
PULL #4	2.18	2.17	2.08	2.72	
PULL #5	2.19	2.12	2.13	2.76	
TOTAL	11.05	10.66	10.59		
AVG.	2.21	2.13	2.12		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.24	3.17		
PULL #2	3.23	3.18		
PULL #3	3.26	3.02		
PULL #4	3.18	3.02		
PULL #5	3.21	3.05		
TOTAL	16.12	15.44		
AVG.	3.22	3.09		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.31	4.45		3.94
PULL #2	4.44	4.53		4.19
PULL #3	4.36	4.49		4.23
PULL #4	4.39	4.57		4.20
PULL #5	4.36	4.55		4.16
TOTAL	21.86	22.59		20.72
AVG.	4.37	4.52		4.14