

C6349083

MODEL 700™ M24

Model **S&S**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

Arms Services Repair & Estimate System

File Add Repair Estimate Repair Expedite Repair Inquiry Repair Tools CSR Tools Reports Table Maintenance System Maintenance Help

Repair Inquiry

Repair Number: **RE00136235**

Serial: C6349083 Model M24 SWS Center Fire
Caliber: 7.62 NATO

Repairman:

Status:

Closed 11/2/2007 10:17:37 AM

Address Information

Customer:

☒ Received From

Return To:

☐ Received From

Name: **BARRY MOBERLY**

BARRY MOBERLY

Address 1: **L-3 COMMUNICATIONS**

L-3 COMMUNICATIONS

Address 2: **5749 BRIAR HILL RD BLDG 221**

PO Box:

5749 BRIAR HILL RD BLDG 221

PO Box:

City: **LEXINGTON**

LEXINGTON

State: **KY**

Zip Code: **40516**

Country: **US**

State: **KY**

Zip Code: **40516**

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
A008	With Swivel	3
A010	Hard Case	1
A026	Scope	1
A055	Deployment Kit	1
D000	SCOPE CASE	1

Repair Search

Refresh

Close

nagletj

11/2/2007

1:14 PM

CAPS

NUM

INS

SCRL

start

2 Mi...

5 Int...

4 Mi...

Part S...

longo...

Arms ...

1:14 PM

Serial Number: **C6349083**

Model: **M24 SWS**



RE00136235

INSPECTION CHECKLIST - REPAIRS
CONTRACT #: W52H09-07-C-0207

R & E NUMBER	136235		
SERIAL NUMBER	C6349083		
LOG-IN DATE	11-20-07		

OPERATION #	OPERATION NAME	DATE	INITIAL
500	DIS-ASSEMBLE GUN	7-8-08	RTZ
505	RE-BARREL	7-9-08	RTZ
420	ASSEMBLE	7-10-08	RTZ
440	PROOF	7-10-08	SD
460	CHECK HEADSPACE	7-10-08	SD
470	DIS-ASSEMBLE GUN	7-11-08	RTZ
480	MAGNAFLUX	7/15/08	(RB)
510	DRILL AND TAP	7-11-08	SP
500	ROLLMARK CALIBER	7/15/08	RT
520	GOFF BLAST BBL / REC	2-17	LM
530 & 540	APPLY COATINGS	7-22-08	RTZ
560	FINAL ASSEMBLY	7-22-08	RTZ
640	FUNCTION TEST AND	9-3-08	SP
650	TARGET	9-3-08	SP
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
670	FINAL INSPECTION	9-3-08	RTZ
	A) HEADSPACE	9-8-08	TC
	B) TRIGGER PULL	236 234 238 231 231 9-8-08	RSN
680	F) SAFETY ON FORCE	2.5 2.5 2.5 9-8-08	TC
	G) SAFETY OFF FORCE	3.5 3.5 3.5 9-8-08	TC
	I) FIRING PIN INDENT	.024 .023 .024 9-8-08	TC
690	PACK	9-11-08	TC

F006 REV 5/2006

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6349083.__0
FILE DATE AND TIME: 09/04/2008 12:20

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.202
The Average Y Centroid of the Five Target Set:	-0.013
The Average Point of Impact of the Five Target Set:	0.202
The Average Mean Radius of the Five Target Set:	0.606
The Distance from POA to Centroid Target #1:	0.402
The Distance from Centroid Target #2 to Centroid Target #1:	0.419
The Distance from Centroid Target #3 to Centroid Target #1:	0.095
The Distance from Centroid Target #4 to Centroid Target #1:	0.479
The Distance from Centroid Target #5 to Centroid Target #1:	0.227

SERIAL NUMBER: C6349083. __0

TARGET NUMBER: 1

FILE DATE: 09/04/2008

FILE TIME: 12:20

POINT#	X	Y
1:	0.871	-0.517
2:	0.463	-0.315
3:	0.107	-0.257
4:	0.539	0.523
5:	-0.223	-0.152
6:	-0.857	-0.617
7:	-0.796	-0.349
8:	-1.431	-0.632
9:	-1.416	-0.197
10:	-0.729	0.489

X CENTROID: -0.347

Y CENTROID: -0.202

POA TO CENTROID: 0.402

HORZ SPREAD: 2.302

VERT SPREAD: 1.155

GROUP SPREAD: 2.309

MIN RADIUS: 0.134

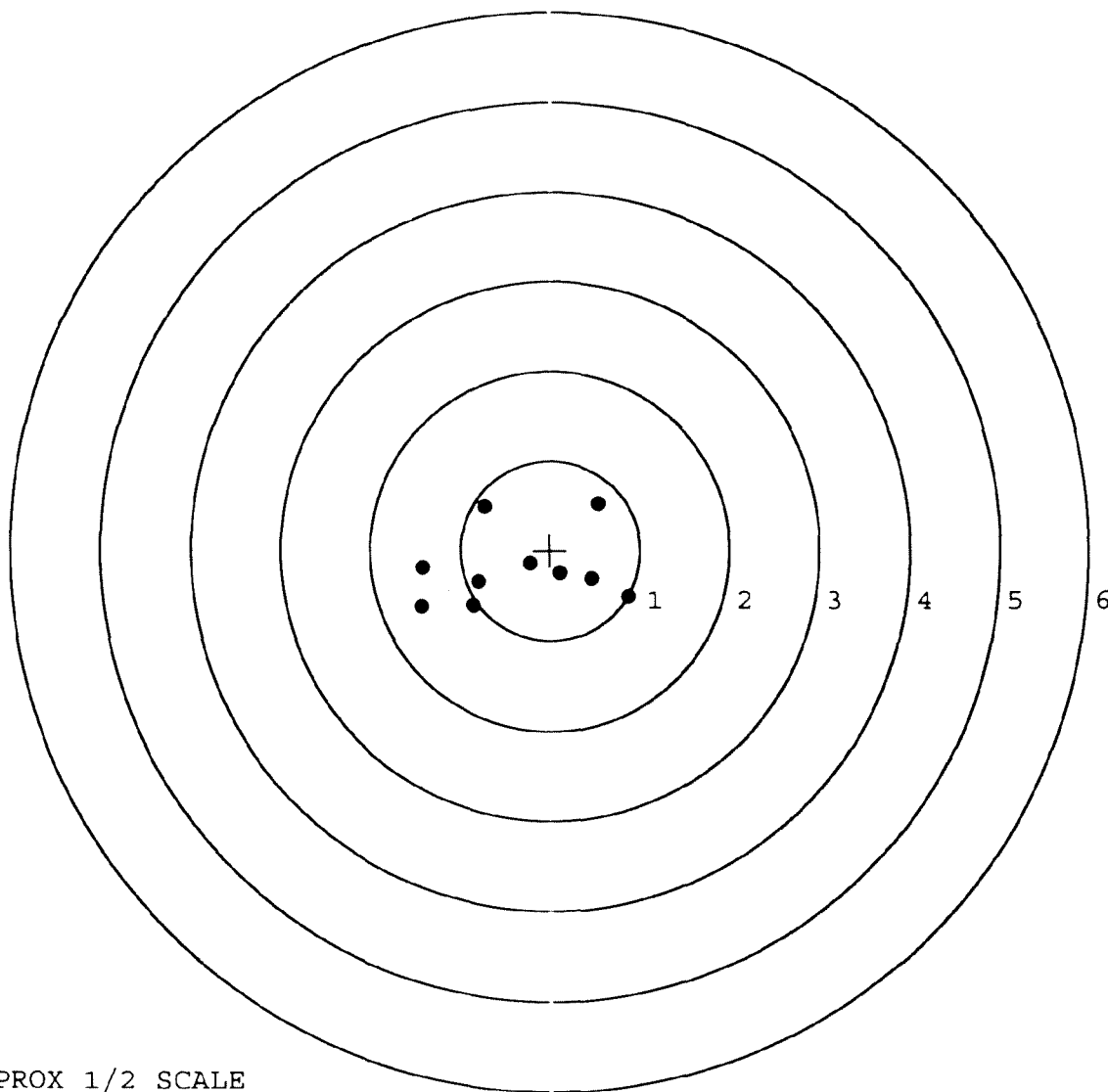
MAX RADIUS: 1.258

MEAN RADIUS: 0.797

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6349083. 0

TARGET NUMBER: 2

FILE DATE: 09/04/2008

FILE TIME: 12:20

POINT#	X	Y
1:	0.430	-1.001
2:	-0.544	-0.641
3:	-0.252	-0.188
4:	0.130	-0.194
5:	0.433	-0.075
6:	0.406	0.684
7:	0.231	0.396
8:	0.046	0.783
9:	-0.404	0.745
10:	-1.149	0.591

X CENTROID: -0.067

Y CENTROID: 0.110

POA TO CENTROID: 0.129

HORZ SPREAD: 1.582

VERT SPREAD: 1.784

GROUP SPREAD: 2.242

MIN RADIUS: 0.351

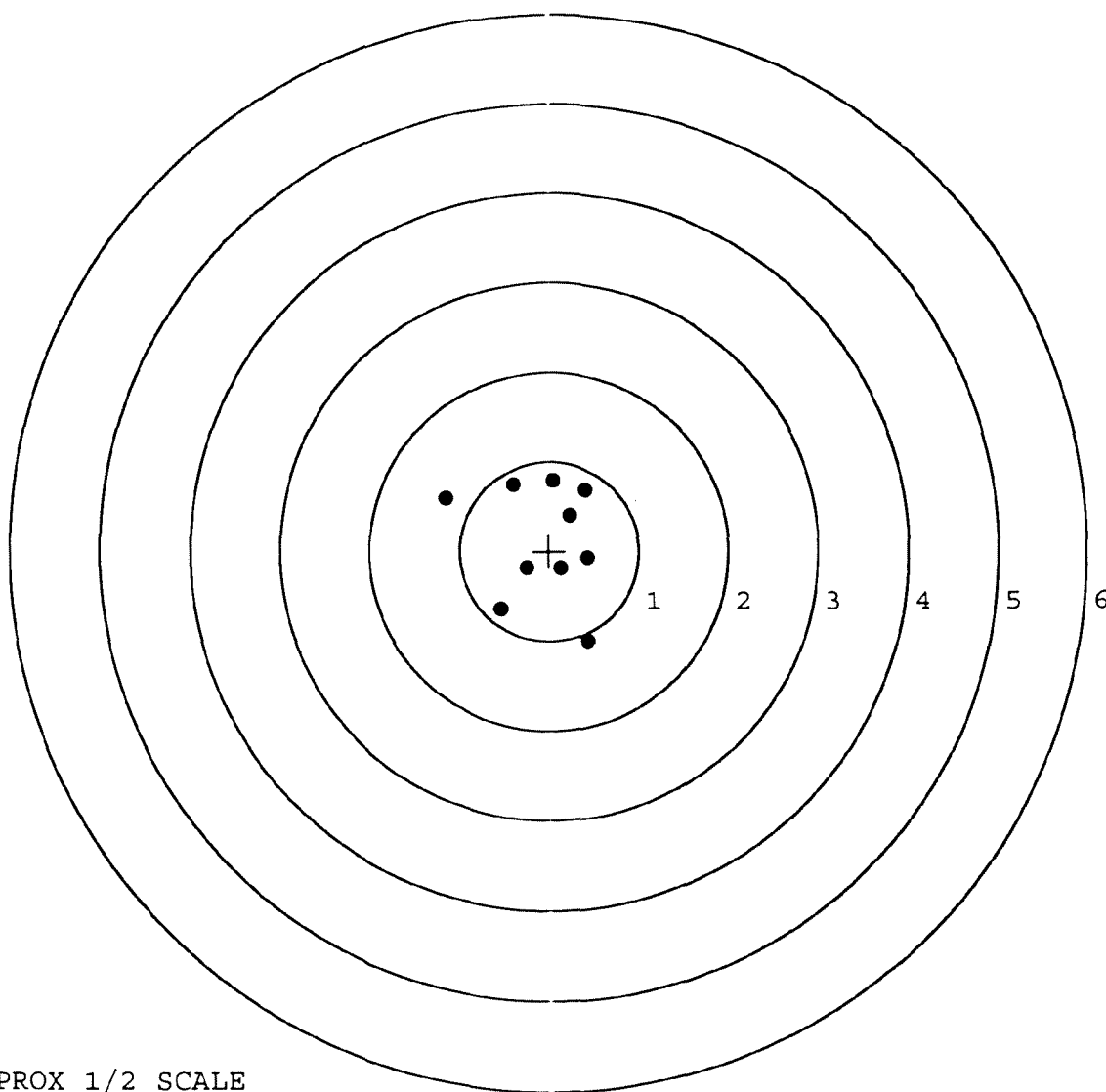
MAX RADIUS: 1.217

MEAN RADIUS: 0.710

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6349083. __0

TARGET NUMBER: 3

FILE DATE: 09/04/2008

FILE TIME: 12:20

POINT#	X	Y
1:	0.394	-0.385
2:	0.126	-0.458
3:	-0.098	-0.306
4:	-0.259	-0.222
5:	-0.362	-0.149
6:	-0.249	0.222
7:	-0.191	0.502
8:	-0.273	0.231
9:	-0.800	-0.527
10:	-1.243	-0.132

X CENTROID: -0.295

Y CENTROID: -0.122

POA TO CENTROID: 0.320

HORZ SPREAD: 1.637

VERT SPREAD: 1.029

GROUP SPREAD: 1.656

MIN RADIUS: 0.072

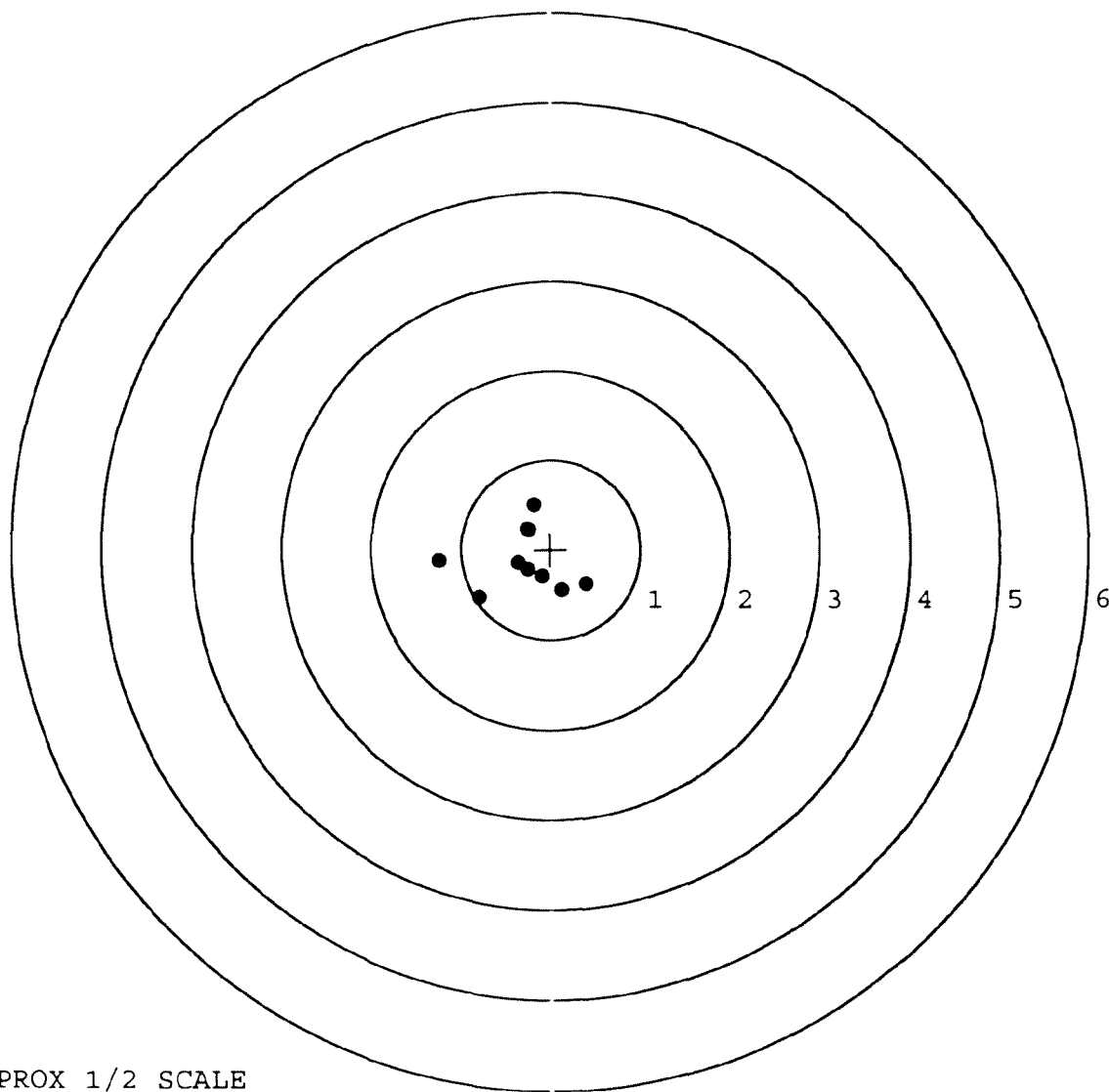
MAX RADIUS: 0.948

MEAN RADIUS: 0.465

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6349083. __0

TARGET NUMBER: 4

FILE DATE: 09/04/2008

FILE TIME: 12:20

POINT#	X	Y
1:	-0.744	-1.085
2:	-0.346	-0.549
3:	0.004	-0.303
4:	0.539	0.011
5:	0.423	0.193
6:	0.142	0.264
7:	0.192	0.503
8:	0.089	0.717
9:	-0.102	0.800
10:	-0.220	0.751

X CENTROID: -0.002

Y CENTROID: 0.130

POA TO CENTROID: 0.130

HORZ SPREAD: 1.283

VERT SPREAD: 1.885

GROUP SPREAD: 1.991

MIN RADIUS: 0.197

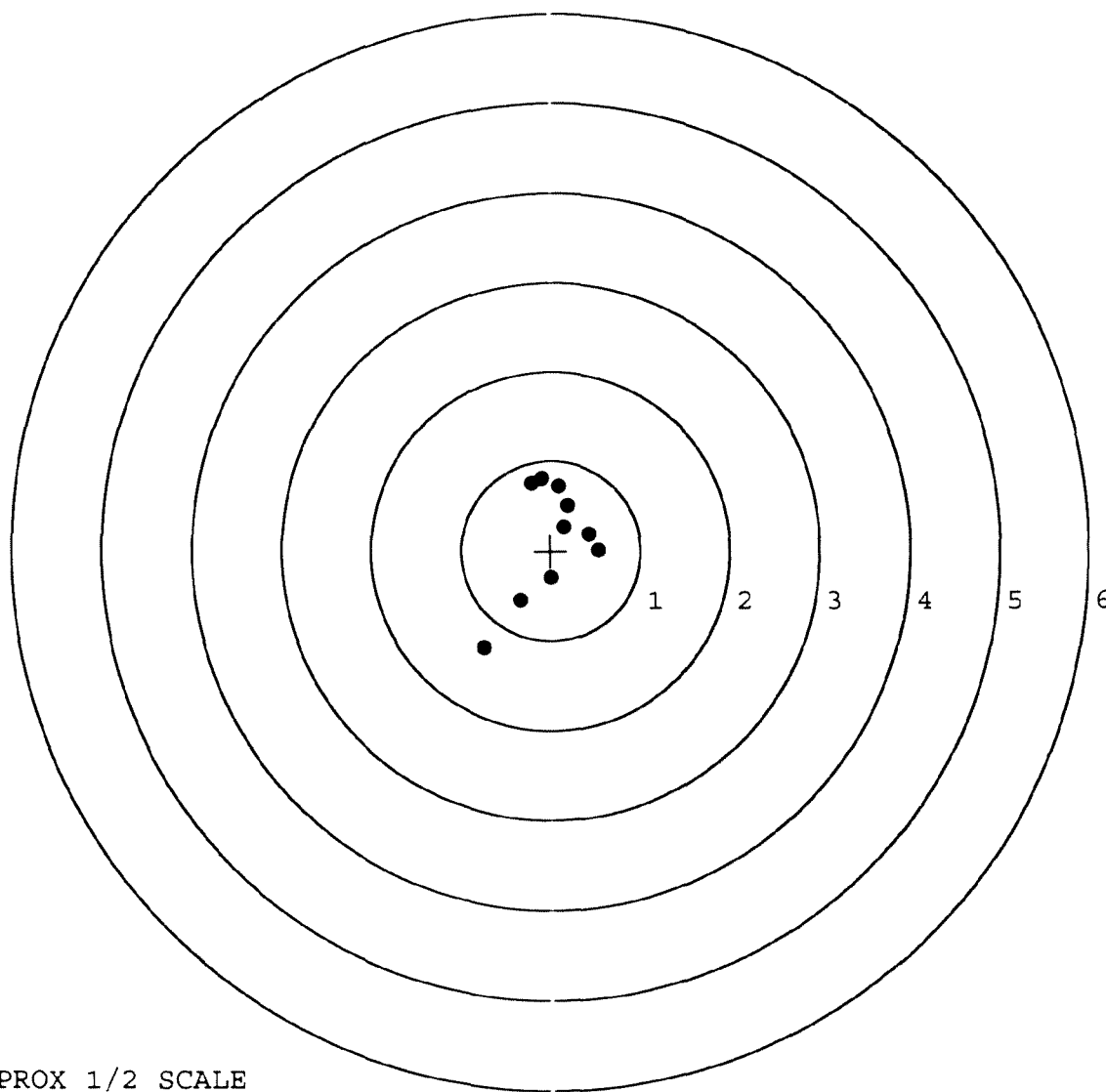
MAX RADIUS: 1.424

MEAN RADIUS: 0.615

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6349083. __0

TARGET NUMBER: 5

FILE DATE: 09/04/2008

FILE TIME: 12:20

X CENTROID: -0.298

Y CENTROID: 0.019

POA TO CENTROID: 0.298

HORZ SPREAD: 1.440

VERT SPREAD: 1.119

GROUP SPREAD: 1.469

MIN RADIUS: 0.115

MAX RADIUS: 1.029

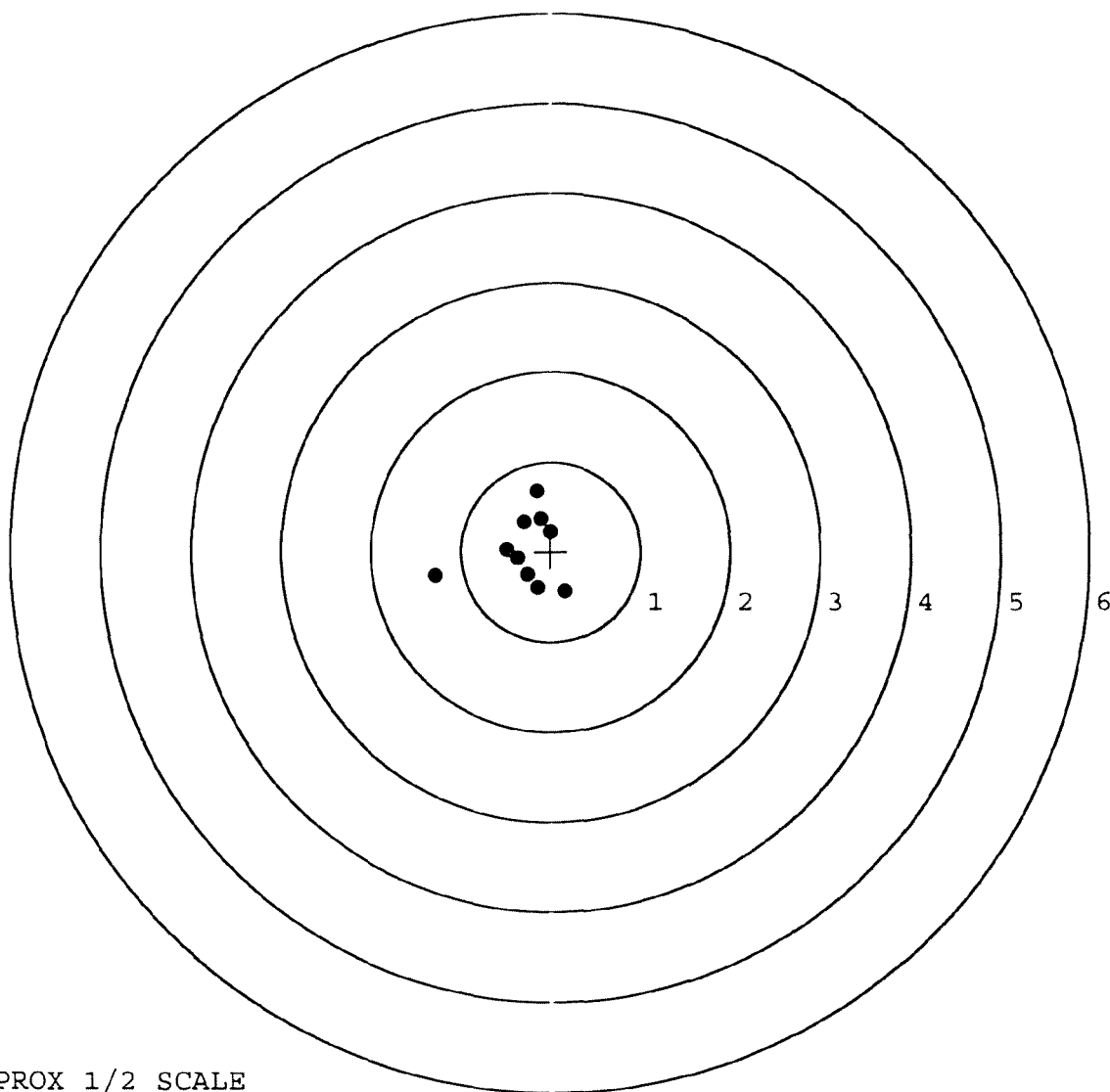
MEAN RADIUS: 0.446

IN 1 IN DIAMETER: 7

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.154	-0.445
2:	-0.149	-0.404
3:	-0.266	-0.258
4:	-0.372	-0.069
5:	-0.489	0.028
6:	-1.286	-0.267
7:	0.000	0.224
8:	-0.301	0.339
9:	-0.112	0.367
10:	-0.158	0.674



TARGET APPROX 1/2 SCALE

INTERCHANGEABILITY

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

66349083

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	A
610	Dis-assemble Gun	4 12	90	RW
612	Magnaflux Barrel Action	4-19-90		KCR
	Magnaflux Bolt	4-19-90		KCR
615	Rollmark Caliber	4-19-90		GL
617	Drill and Tap Sight Holes		4/27/90	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		5/16/90	RL

op. #	OP. NAME	READINGS			DATE	INIT
625 cont.	F) Safety On Force	4	4	4	5/17/90	gfl
	G) Safety Off Force	3	3	3	5/17/90	gfl
	H) Trigger Pull Test & Retainability				5/16/90	gfl
	I) Firing Pin Indent	.023	.023	.023	5/17/90	gfl
	J) Assemble Stock				5/17/90	Rw
	K) Assemble Swivel Studs				25 May 90	gfl
	L) Attach Front and Rear Sight Assemblies				5/17/90	Rw
	M) Iron Sight Alignment				5/17/90	Rw
	N) Detach Front & Rear Sights & place in numbered container				5/17/90	Rw
	O) Attach Scope to Rifle				5/18/90	Rw
	P) Detach & Attach Scope 20 Times				5/18/90	Rw
640	Gallery Target & Test				5-18-90	DH
	A) Time				5-18-90	DH
	B) Malfunctions				5-18-90	DH
	C) Pierced Primers				5-18-90	DH
	D) Optical Clarity of Scope				5-18-90	DH
645	Inspect for Live Ammo				5-18-90	DH
655	Final Inspection					
	A) Headspace				25 May 90	gfl
	B) Trigger Pull	271	267	271	25 May 90	gfl
	C) Function				25 May 90	gfl
660	Pack				6-20-90	DH

SWS TRIGGER PULL TEST

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

SERIAL NO. 06349083
DATE 5/16/90
TESTER JU

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.53	2.22	2.30	2.71	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.28	2.28	2.36	2.67	
PULL #3	2.36	2.26	2.40	2.71	
PULL #4	2.16	2.23	2.23	2.66	
PULL #5	2.32	2.29	2.41	2.76	
TOTAL	11.65	11.28	11.70		
AVG.	2.33	2.256	2.34		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.50	3.45		
PULL #2	3.50	3.44		
PULL #3	3.52	3.53		
PULL #4	3.43	3.33		
PULL #5	3.52	3.40		
TOTAL	17.47	17.15		
AVG.	3.494	3.43		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.33	4.35		4.36
PULL #2	4.23	4.34		4.39
PULL #3	4.34	4.48		4.34
PULL #4	4.30	4.42		4.40
PULL #5	4.36	4.38		4.39
TOTAL	21.56	21.97		21.88
AVG.	4.312	4.394		4.376

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6349083
18 May 1990

CENTROIDAL DISTANCES

0 TO	1	.676062
1 TO	2	.80733
1 TO	3	.903687
1 TO	4	.933197
1 TO	5	.925352

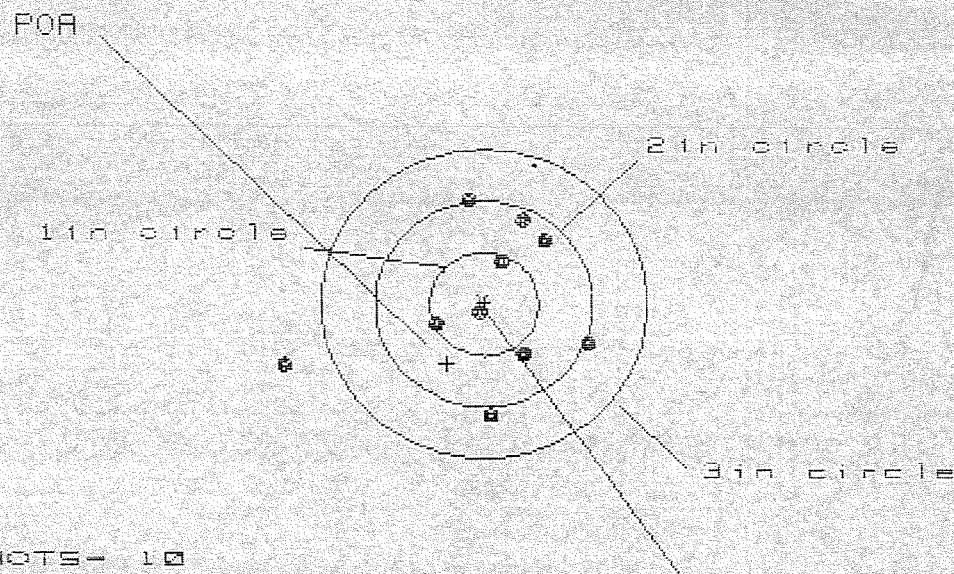
1
+₅ <----POB

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0554
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0374
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0668425
THE AMR FOR THIS RIFLE IS: .9116

18 May 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C63490B3

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 3

2in = 7

3in = 9

HS= 2.813

VS= 2.028

GS= 2.827

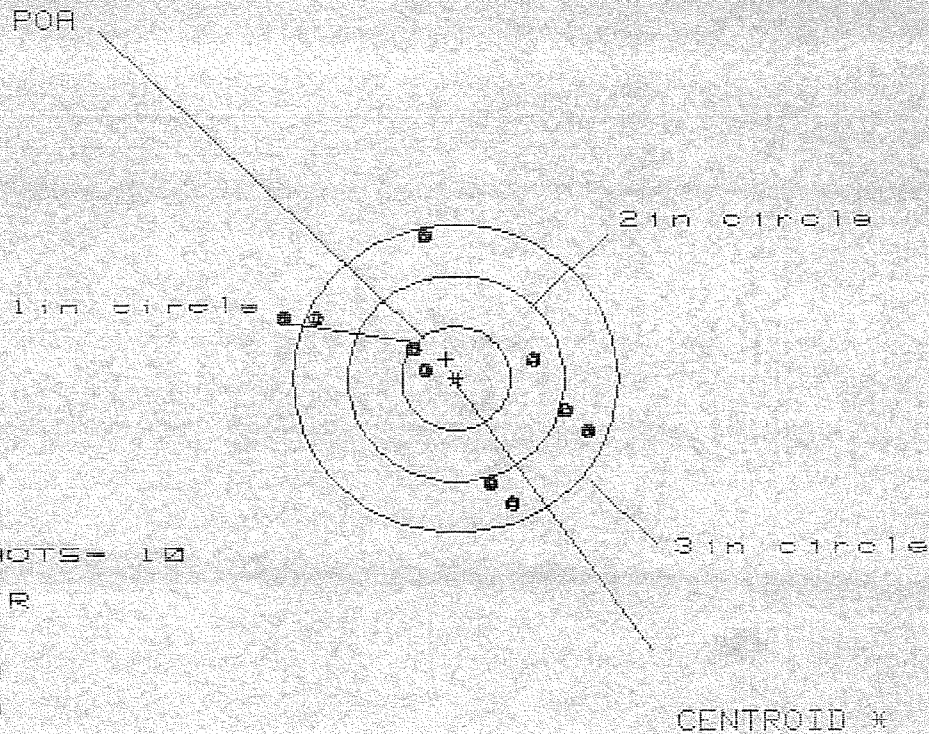
CENTROID #

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.943	.735	.717
MINIMUM X	:	-1.870	-.604	-.622
MAXIMUM Y	:	.969	.899	.758
MINIMUM Y	:	-1.059	-1.129	-.706
CENTROID X	:	.344	.551	.569
CENTROID Y	:	.582	.652	.793
POA TO CENTROID in.	:	.676	.854	.976
MIN RADIUS	:	.073	.278	.180
MEAN RADIUS	:	.833	.694	.623
MAX RADIUS	:	1.974	1.138	.909
HORIZONTAL SPREAD	:	2.813	1.339	1.339
VERTICAL SPREAD	:	2.028	2.028	1.464
EXTREME SPREAD	:	2.827	2.044	1.735
NUMBER IN ONE INCH CIRCLE =			3	
NUMBER IN TWO INCH CIRCLE =			7	
NUMBER IN THREE INCH CIRCLE =			9	

18 May 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6349083

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1 in = 2

2 in = 3

3 in = 5

HS= 2.749

VS= 2.635

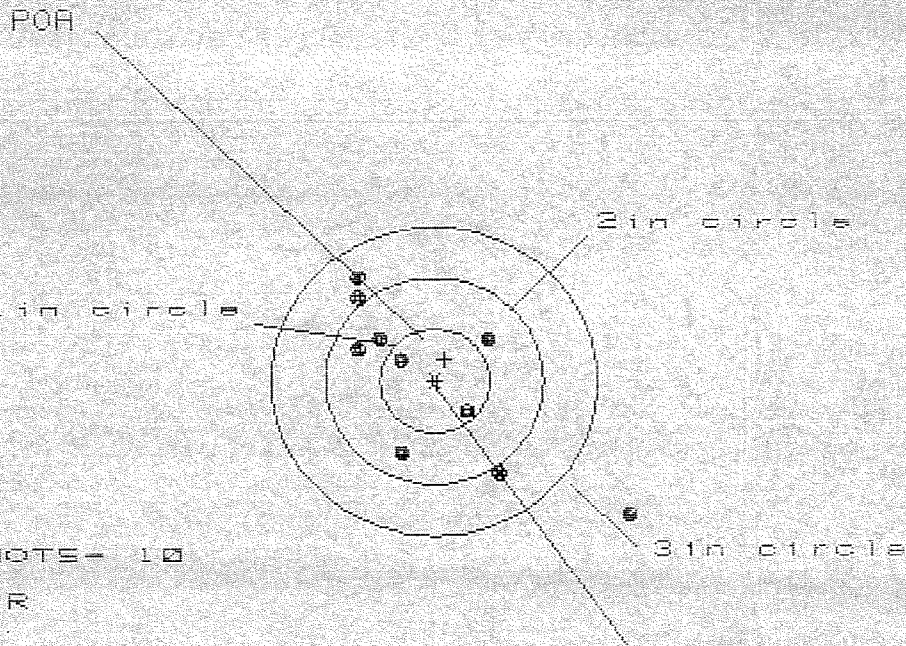
CS= 2.957

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.169	.994	.815
MINIMUM X	:	-1.580	-1.435	-.731
MAXIMUM Y	:	1.377	1.440	1.524
MINIMUM Y	:	-1.258	-1.195	-1.111
CENTROID X	:	.089	.264	.443
CENTROID Y	:	-.184	-.247	-.331
POA TO CENTROID in.	:	.204	.361	.553
MIN RADIUS	:	.245	.431	.502
MEAN RADIUS	:	1.071	.995	.899
MAX RADIUS	:	1.678	1.585	1.639
HORIZONTAL SPREAD	:	2.749	2.429	1.546
VERTICAL SPREAD	:	2.635	2.635	2.635
EXTREME SPREAD	:	2.957	2.740	2.740
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		9	

16 May 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C63490B3

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 2

2in = 6

3in = 9

HS= 2.552

VS= 2.239

GS= 3.395

CENTROID #

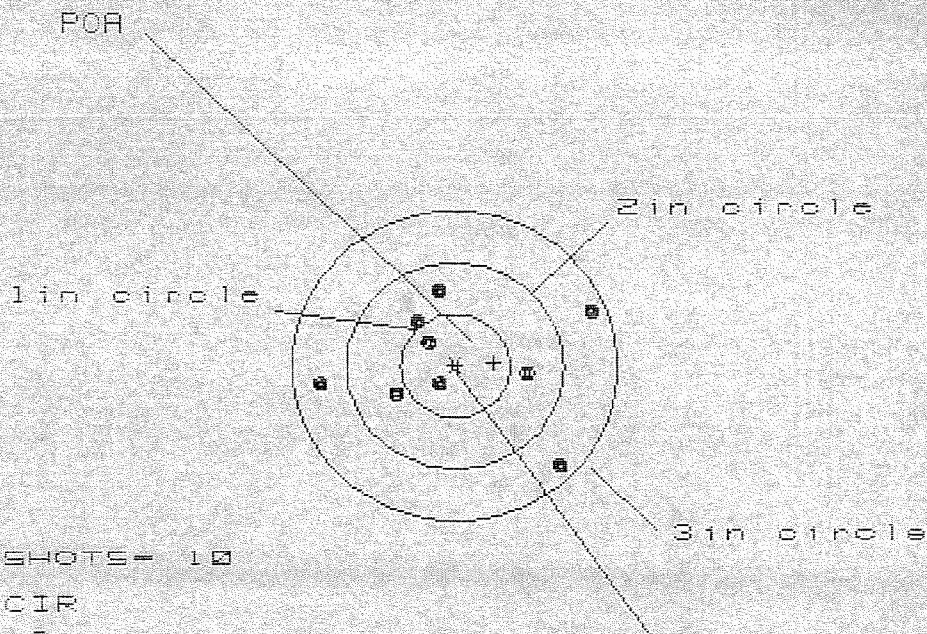
PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.809	.751	.683
MINIMUM X	:	-.743	-.542	-.565
MAXIMUM Y	:	.996	.858	.755
MINIMUM Y	:	-1.243	-.985	-.878
CENTROID X	:	-.093	-.294	-.226
CENTROID Y	:	-.209	-.071	-.178
POA TO CENTROID in.	:	.229	.302	.288
MIN RADIUS	:	.367	.123	.244
MEAN RADIUS	:	.911	.709	.687
MAX RADIUS	:	2.195	1.239	1.112
HORIZONTAL SPREAD	:	2.552	1.293	1.248
VERTICAL SPREAD	:	2.239	1.843	1.633
EXTREME SPREAD	:	3.395	2.251	2.055
NUMBER IN ONE INCH CIRCLE =			2	
NUMBER IN TWO INCH CIRCLE =			6	
NUMBER IN THREE INCH CIRCLE =			9	

18 May 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6349063

CENTERFIRE PATTERNS

4



OF SHOTS= 10

IN CIR

1in = 3

2in = 7

3in = 10

HS= 2.462

VS= 1.749

GS= 2.541

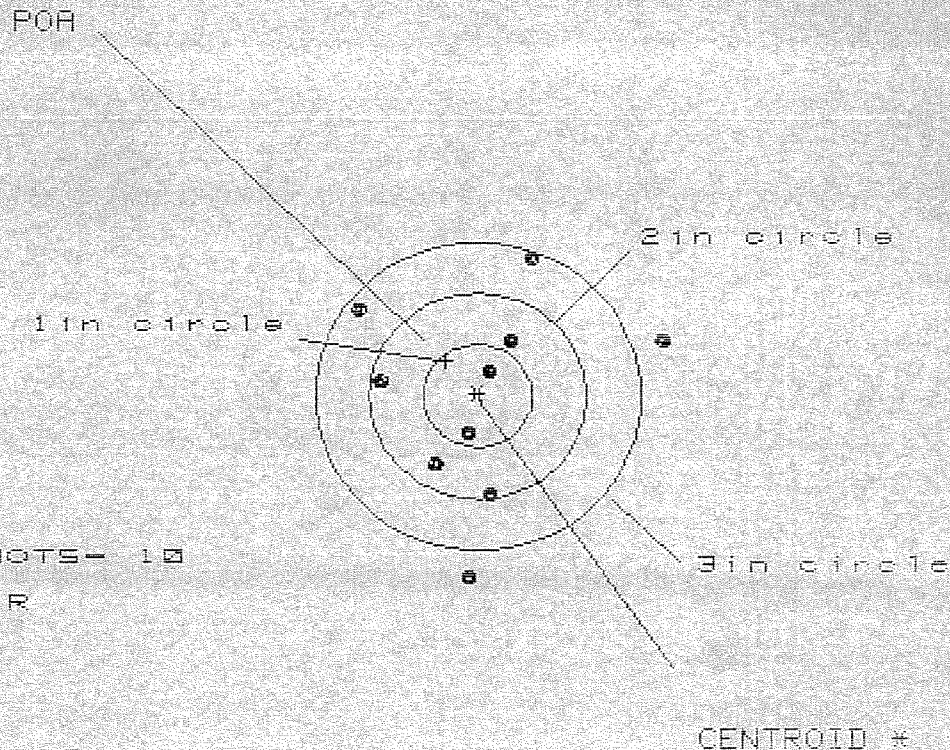
CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.213	1.315	.951
MINIMUM X	:	-1.249	-1.147	-.982
MAXIMUM Y	:	.750	.639	.685
MINIMUM Y	:	-.999	-.380	-.334
CENTROID X	:	-.357	-.459	-.624
CENTROID Y	:	-.034	.077	.031
POA TO CENTROID in.	:	.359	.466	.625
MIN RADIUS	:	.207	.139	.132
MEAN RADIUS	:	.727	.631	.513
MAX RADIUS	:	1.358	1.367	1.005
HORIZONTAL SPREAD	:	2.462	2.462	1.933
VERTICAL SPREAD	:	1.749	1.019	1.019
EXTREME SPREAD	:	2.541	2.541	1.934
NUMBER IN ONE INCH CIRCLE =			3	
NUMBER IN TWO INCH CIRCLE =			7	
NUMBER IN THREE INCH CIRCLE =			10	

16 May 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6349003

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 2

2in = 6

3in = 8

HS= 2.786

VS= 3.112

CS= 3.172

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.677	1.663	.673
MINIMUM X	:	-1.109	-1.123	-.916
MAXIMUM Y	:	1.357	1.162	1.202
MINIMUM Y	:	-1.755	-1.111	-1.071
CENTROID X	:	.294	.308	.101
CENTROID Y	:	-.342	-.147	-.187
POA TO CENTROID in.	:	.451	.342	.212
MIN RADIUS	:	.276	.096	.295
MEAN RADIUS	:	1.016	.919	.820
MAX RADIUS	:	1.760	1.693	1.378
HORIZONTAL SPREAD	:	2.786	2.786	1.589
VERTICAL SPREAD	:	3.112	2.273	2.273
EXTREME SPREAD	:	3.172	2.805	2.310
NUMBER IN ONE INCH CIRCLE =			2	
NUMBER IN TWO INCH CIRCLE =			6	
NUMBER IN THREE INCH CIRCLE =			8	

INTERCHANGEABILITY

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6349083
18 Jun 1990

CENTROIDAL DISTANCES

0 TO	1	.224154
1 TO	2	.129553
1 TO	3	.550684
1 TO	4	.642111
1 TO	5	.218653

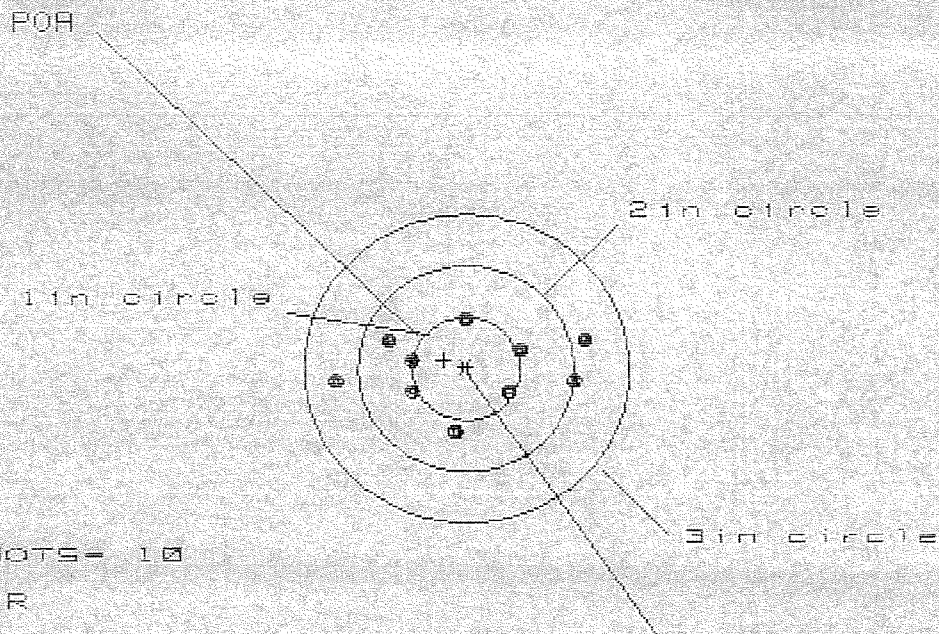
$\begin{matrix} 3 \\ \text{te} \\ 4 \end{matrix}$ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1236
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0834
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .149106
THE AMR FOR THIS RIFLE IS: .9612

18 Jun 1990

FILE:/PATTERNING/CENTERFIRE_PATT/06349083.1

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1in = 2

2in = 7

3in = 10

HS= 2.362

VS= 1.143

GS= 2.398

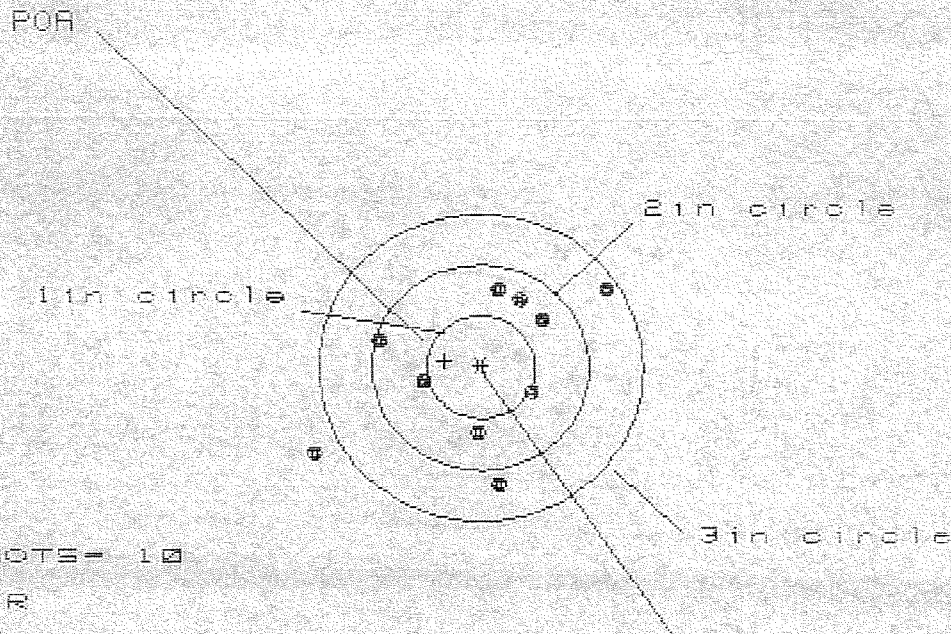
CENTROID #

PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.108	.969	1.018
MINIMUM X	:	-1.254	-.805	-.684
MAXIMUM Y	:	.490	.477	.512
MINIMUM Y	:	-.653	-.666	-.631
CENTROID X	:	.207	.346	.225
CENTROID Y	:	-.086	-.073	-.108
POA TO CENTROID IN.	:	.224	.353	.250
MIN RADIUS	:	.484	.379	.457
MEAN RADIUS	:	.748	.685	.635
MAX RADIUS	:	1.259	1.010	1.021
HORIZONTAL SPREAD	:	2.362	1.774	1.702
VERTICAL SPREAD	:	1.143	1.143	1.143
EXTREME SPREAD	:	2.398	1.774	1.754
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	7		
NUMBER IN THREE INCH CIRCLE	=	10		

16 Jun 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6349083.1

CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1 in = 0

2 in = 6

3 in = 9

HS = 2.729

VS = 1.955

GS = 3.142

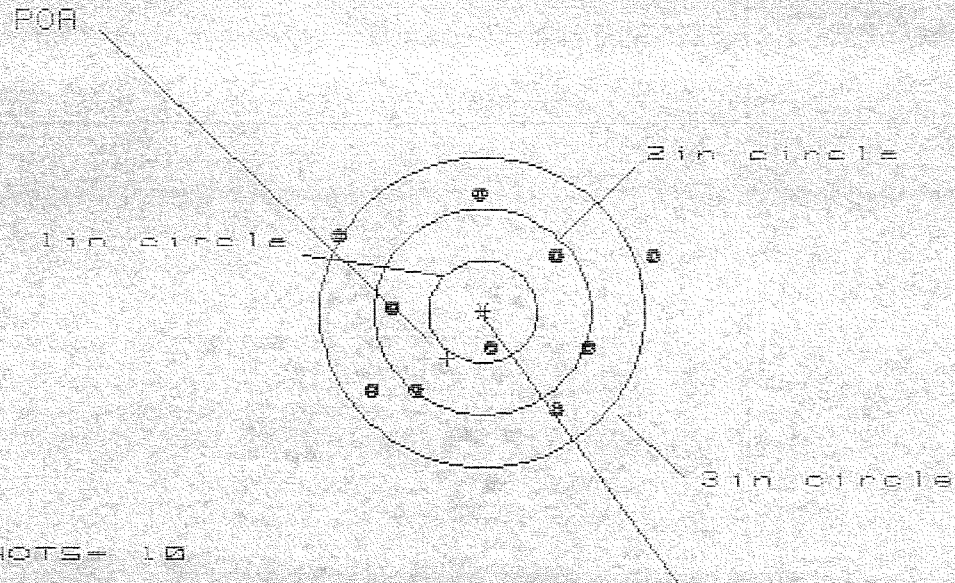
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.177	1.004	.559
MINIMUM X	:	-1.552	-1.150	-1.024
MAXIMUM Y	:	.795	.704	.784
MINIMUM Y	:	-1.159	-1.251	-1.171
CENTROID X	:	.385	.508	.382
CENTROID Y	:	-.066	.026	-.054
POA TO CENTROID in.	:	.342	.509	.386
MIN RADIUS	:	.514	.467	.518
MEAN RADIUS	:	.935	.819	.773
MAX RADIUS	:	1.758	1.251	1.176
HORIZONTAL SPREAD	:	2.729	2.154	1.583
VERTICAL SPREAD	:	1.955	1.955	1.955
EXTREME SPREAD	:	3.142	2.194	1.955
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

18 Jun 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6349083.1

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1in = 1

2in = 4

3in = 9

HS= 2.821

VS= 2.087

GS= 2.920

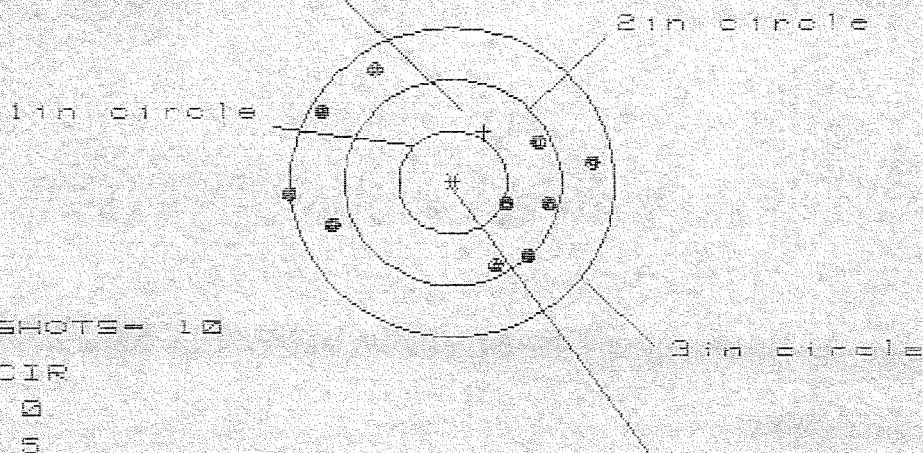
PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.540	1.129	.991
MINIMUM X	:	-1.281	-1.110	-1.045
MAXIMUM Y	:	1.179	1.239	1.339
MINIMUM Y	:	-.908	-.848	-.748
CENTROID X	:	.329	.158	.296
CENTROID Y	:	.451	.391	.291
POA TO CENTROID in.	:	.558	.421	.415
MIN RADIUS	:	.313	.344	.178
MEAN RADIUS	:	1.082	1.008	.936
MAX RADIUS	:	1.634	1.367	1.339
HORIZONTAL SPREAD	:	2.821	2.239	2.036
VERTICAL SPREAD	:	2.087	2.087	2.087
EXTREME SPREAD	:	2.920	2.532	2.202
NUMBER IN ONE INCH CIRCLE =			1	
NUMBER IN TWO INCH CIRCLE =			4	
NUMBER IN THREE INCH CIRCLE =			9	

18 Jun 1990

FILE:/PATTERNING/CENTERFIRE_PATT/06349003.1

CENTERFIRE PATTERNS # 4

POB



OF SHOTS= 10

IN CIR

1in = 0

2in = 5

3in = 9

HS= 2.757

VS= 1.954

GS= 2.775

CENTROID #

PATTERN #	4	4	4
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.246	1.078	.907
MINIMUM X	-1.511	-1.365	-1.411
MAXIMUM Y	1.127	1.117	1.202
MINIMUM Y	-.827	-.837	-.752
CENTROID X	-.288	-.120	.051
CENTROID Y	-.495	-.485	-.570
POB TO CENTROID in.	.572	.499	.572
MIN RADIUS	.551	.397	.206
MEAN RADIUS	1.086	.997	.862
MAX RADIUS	1.514	1.527	1.583
HORIZONTAL SPREAD	2.757	2.443	2.318
VERTICAL SPREAD	1.954	1.954	1.954
EXTREME SPREAD	2.775	2.488	2.395
NUMBER IN ONE INCH CIRCLE =	0	0	0
NUMBER IN TWO INCH CIRCLE =	5	5	5
NUMBER IN THREE INCH CIRCLE =	9	9	9

18 Jun 1990

FILE:/PATTERNING/CENTERFIRE_PATT/CG349083.1

CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

OF SHOTS= 10

IN CIR

1in = 0

2in = 6

3in = 10

HS= 2.376

VS= 1.864

GS= 2.429

CENTROID #

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.267	1.396	1.302
MINIMUM X	-1.109	-0.980	-1.074
MAXIMUM Y	1.033	1.119	1.001
MINIMUM Y	-0.831	-0.745	-0.605
CENTROID X	0.035	-0.094	-0.008
CENTROID Y	-0.221	-0.307	-0.447
POA TO CENTROID in.	0.224	0.321	0.447
MIN RADIUS	0.551	0.504	0.340
MEAN RADIUS	0.955	0.883	0.782
MAX RADIUS	1.393	1.396	1.309
HORIZONTAL SPREAD	2.376	2.376	2.376
VERTICAL SPREAD	1.864	1.864	1.606
EXTREME SPREAD	2.429	2.429	2.429
NUMBER IN ONE INCH CIRCLE =		0	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		10	

RECEIVING AND ESTIMATING REPORT

COMMENTS

ORDER

R 94-18170

INITIAL
FDC CUSTOMER ORDER NO.
DAAA09-92-C-0834W/10X SCOPE, M-24 SNIPER, W/DEPLOYMENT KIT
ATTN: FRED MARTIN

SCOPE 90-0660

DATE RECEIVED 06/10/94	DATE OPENED 06/10/94	DATE CODE	SERIAL NUMBER C6349083	NEW SERIAL NUMBER	MODEL AND GRADE 700 7-62 NATO
ACCESSORIES SLING STRAP		HARD CASE		SCOPE MNTS	SCOPE BASE

FROM:

COMMANDER (W52H094138H226)
DEFENSE DIST DEPOT ANNISTON
ATTN DDAA-UR BLDG 112
ANNISTON

AL 36201-5025

SHIP TO:

COMMANDER (W52H094138H226)
DEFENSE DIST DEPOT ANNISTON
ATTN DDAA-UR BLDG 112
ANNISTONAL
36201-5025

CUST NO: 098397 CJO.D

ACCOUNT NUMBER

ACCOUNT NUMBER N/C

WRITE ☐

PROM. DATE

ESTIMATED

VIA

FRT

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 \$643.45
✓ Stock 471.11
Trigger Assy 173.31
CTI 50.00
1337.84

REPAIRMAN	PROOF	CLEAN	TEST	TARGET	PATTERN
		/	A	A	

GALLERY TESTER	DATE	DATE	DATE	DATE	DATE
			3/1	3/1	

OFFICE COPY

RD6925 REV. 1/94

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

M2400107481

SWS TRIGGER PULL TEST

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

SERIAL NO. C6349083

DATE 2-16-96

TESTER DA

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#	COMMENTS
PULL #1	2.67	2.34	2.74	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.79	2.55	2.46	
PULL #3	2.77	2.83	2.52	
PULL #4	2.72	2.82	2.63	
PULL #5	2.65	2.71	2.57	
TOTAL	13.60	13.25	12.92	
AVG.	2.72	2.65	2.58	

	3.00# INITIAL	3.00# AFTER 20 CYCLES	COMMENTS
PULL #1	3.02	3.01	
PULL #2	3.15	3.00	
PULL #3	3.20	3.00	
PULL #4	3.11	3.05	
PULL #5	3.35	3.06	
TOTAL	15.83		
AVG.	3.16		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.40	4.43		4.34
PULL #2	4.26	4.50		4.41
PULL #3	4.22	4.34		4.37
PULL #4	4.24	4.50		4.29
PULL #5	4.47	4.44		4.31
TOTAL	21.59	22.21		21.72
AVG.	4.31	4.44		4.34

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6349083

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	6	6	6			3/7	AC
	G) Safety Off Force	3	3	3			3/7	AC
	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	2.66	2.60	2.64	2.62	2.63	3/1/96	WB
	C) Function							
660	Pack							

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6349883
2 Jan 1980

CENTROIDAL DISTANCES

0 TO	1	.540649
1 TO	2	.197203
1 TO	3	.180967
1 TO	4	.394088
1 TO	5	.0363456

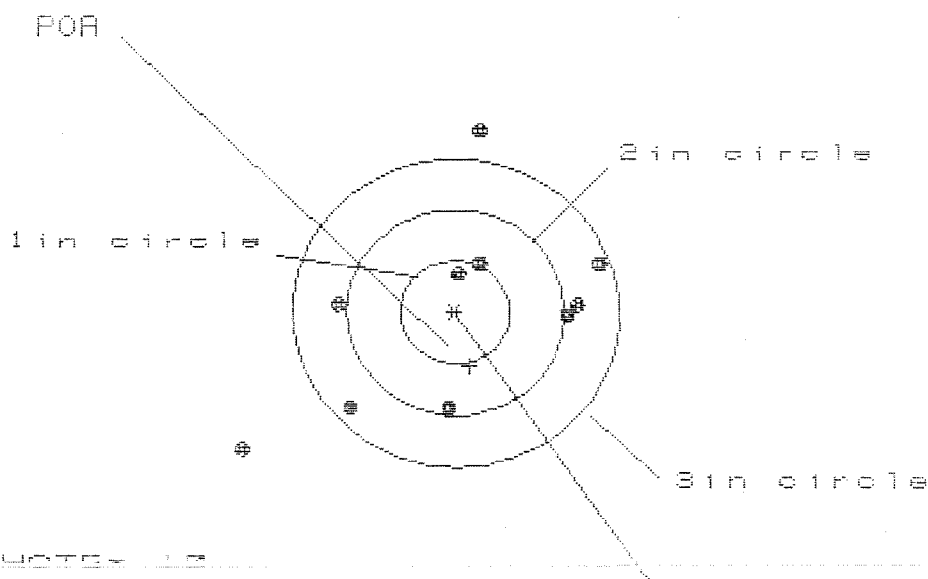
$\frac{1}{5}$
+ <----POB

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1754
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .6516
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .674793
THE AMR FOR THIS RIFLE IS: 1.084

2 Jan 1988

FILE:/PATTERNING/CENTERFIRE_PATT/06345083

CENTERFIRE PATTERNS # 1



OF SHOTS IN

IN CIR

1 in = 1

2 in = 4

3 in = 8

HS = 3.288

VS = 3.052

GS = 3.755

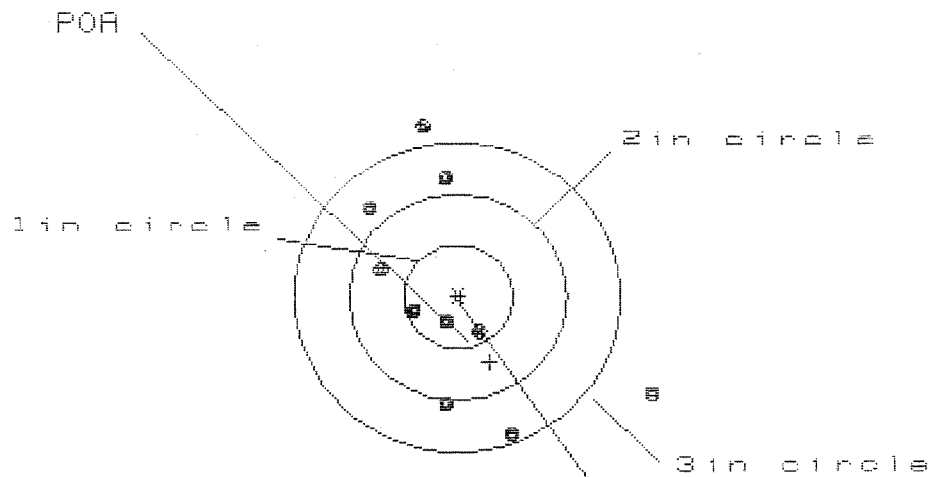
CENTROID *

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.333	1.116	1.119
MINIMUM X	:	-1.947	-1.262	-1.259
MAXIMUM Y	:	1.767	1.624	.562
MINIMUM Y	:	-1.285	-1.113	-.910
CENTROID X	:	-.125	.092	.089
CENTROID Y	:	.526	.669	.466
POA TO CENTROID in.	:	.541	.675	.474
MIN RADIUS	:	.329	.291	.447
MEAN RADIUS	:	1.185	1.011	.946
MAX RADIUS	:	2.333	1.624	1.460
HORIZONTAL SPREAD	:	3.288	2.378	2.378
VERTICAL SPREAD	:	3.052	2.737	1.472
EXTREME SPREAD	:	3.755	2.976	2.667
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	

2 Jan 1988

FILE:/PATTERNING/CENTERFIRE_PATT/08349083

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1in = 3

2in = 4

3in = 8

HS= 2.563

VS= 2.936

GS= 3.308

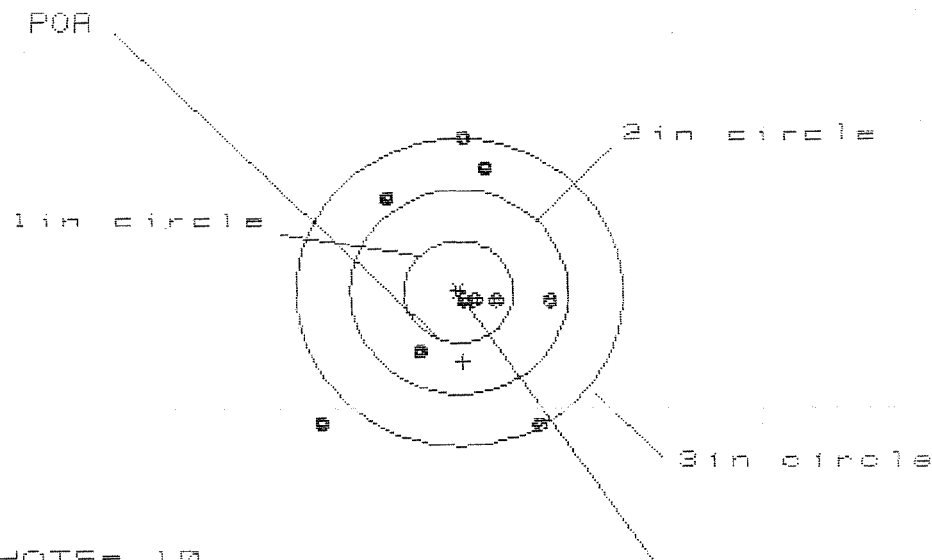
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.773	.687	.677
MINIMUM X	:	-.790	-.593	-.603
MAXIMUM Y	:	1.630	1.524	1.284
MINIMUM Y	:	-1.306	-1.412	-1.222
CENTROID X	:	-.290	-.487	-.477
CENTROID Y	:	.634	.740	.550
POA TO CENTROID in.	:	.697	.886	.728
MIN RADIUS	:	.211	.305	.148
MEAN RADIUS	:	1.026	.898	.777
MAX RADIUS	:	2.017	1.571	1.397
HORIZONTAL SPREAD	:	2.563	1.280	1.280
VERTICAL SPREAD	:	2.936	2.936	2.506
EXTREME SPREAD	:	3.308	3.036	2.571
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	

2 Jan 1988

FILE://PATTERNING/CENTERFIRE_PATT/C63490B3

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 5

3 in = 8

HS= 2.147

VS= 2.810

GS= 3.024

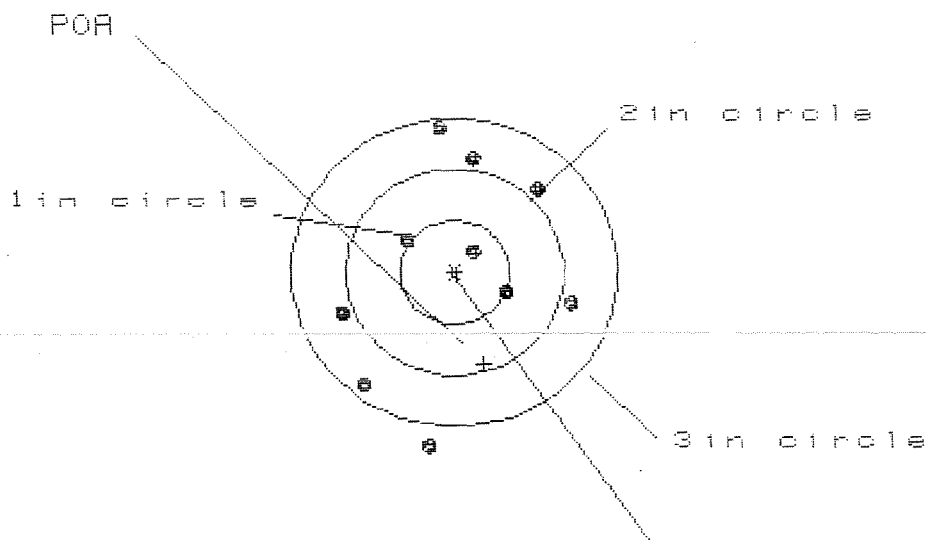
CENTROID #

PATTERN #	3	3	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.869	.727	.800
MINIMUM X	-1.278	-.759	-.686
MAXIMUM Y	1.481	1.340	1.156
MINIMUM Y	-1.329	-1.470	-.940
CENTROID X	-.035	.107	.034
CENTROID Y	.683	.824	1.008
POA TO CENTROID in.	.684	.831	1.008
MIN RADIUS	.100	.225	.416
MEAN RADIUS	.931	.838	.778
MAX RADIUS	1.799	1.580	1.159
HORIZONTAL SPREAD	2.147	1.486	1.486
VERTICAL SPREAD	2.810	2.810	2.096
EXTREME SPREAD	3.024	2.904	2.133
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	8		

2 Jan 1968

FILE:/PATTERNING/CENTERFIRE_PATT/C6349063

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 1

2in = 3

3in = 9

HS= 2.050

VS= 3.194

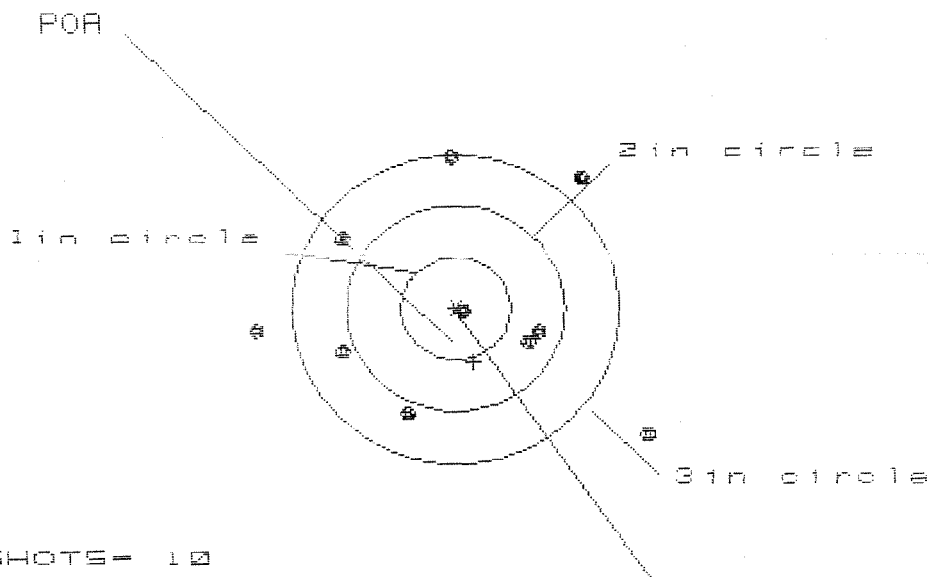
GS= 3.194

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.024	1.002	.977
MINIMUM X	:	-1.026	-1.048	-1.073
MAXIMUM Y	:	1.453	1.259	1.030
MINIMUM Y	:	-1.741	-1.332	-1.174
CENTROID X	:	-.266	-.244	-.219
CENTROID Y	:	.894	1.088	.930
POA TO CENTROID in.	:	.933	1.115	.956
MIN RADIUS	:	.263	.138	.206
MEAN RADIUS	:	1.038	.924	.884
MAX RADIUS	:	1.752	1.604	1.491
HORIZONTAL SPREAD	:	2.050	2.050	2.050
VERTICAL SPREAD	:	3.194	2.591	2.204
EXTREME SPREAD	:	3.194	2.681	2.567
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		9	

2 Jan 1988

FILE://PATTERNING/CENTERFIRE_PATT/C6349083

CENTERFIRE PATTERNS # 5



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 3

3 in = 7

HS = 3.622

VS = 2.717

GS = 3.772

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.771	1.358	1.152
MINIMUM X	:	-1.851	-1.655	-1.072
MAXIMUM Y	:	1.461	1.322	1.279
MINIMUM Y	:	-1.256	-1.193	-1.236
CENTROID X	:	-.161	-.357	-.151
CENTROID Y	:	.521	.660	.703
POR TO CENTROID in.	:	.545	.751	.719
MIN RADIUS	:	.068	.295	.182
MEAN RADIUS	:	1.240	1.154	1.060
MAX RADIUS	:	2.171	1.700	1.598
HORIZONTAL SPREAD	:	3.622	3.013	2.224
VERTICAL SPREAD	:	2.717	2.515	2.515
EXTREME SPREAD	:	3.772	3.363	2.863
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		7	