

G 641 4351
Raphed
C: 622 5496

04/24/08 12:25:36

Arms Services Repair & Estimate System

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

Repair InquiryRepair Number: **RE00144831**Serial: G6414351 Model M24 SWS Center Fire
Caliber: 7.62 NATO

Repairman:

Status: Closed 4/24/2008 10:56:52 AM

Verify Repair

Address Information

Customer:

☒ Received From

Return To:

☐ Received From

Name: B/210TH BSB

B/210TH BSB

Address 1: 2 BCT

2 BCT

Address 2: 10 TH MTN DIV

PO Box:

10 TH MTN DIV

PO Box:

City: FORT DRUM

FORT DRUM

State: NY

Zip Code: 13602

Country: US

State: NY

Zip Code: 13602

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	2
A010	Hard Case	1
A026	Scope	1
A057	Frt and Rear Sgt Base	1

naglej

4/24/2008

12:25 PM

NUM

start

4 Micros...

The Asso...

2 Micros...

SAP Logo...

Arms Ser...

Serial Number: **G6414351**Model: **M24 SWS****RE00144831**

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6414351.___0
FILE DATE AND TIME: 05/20/2008 22:22

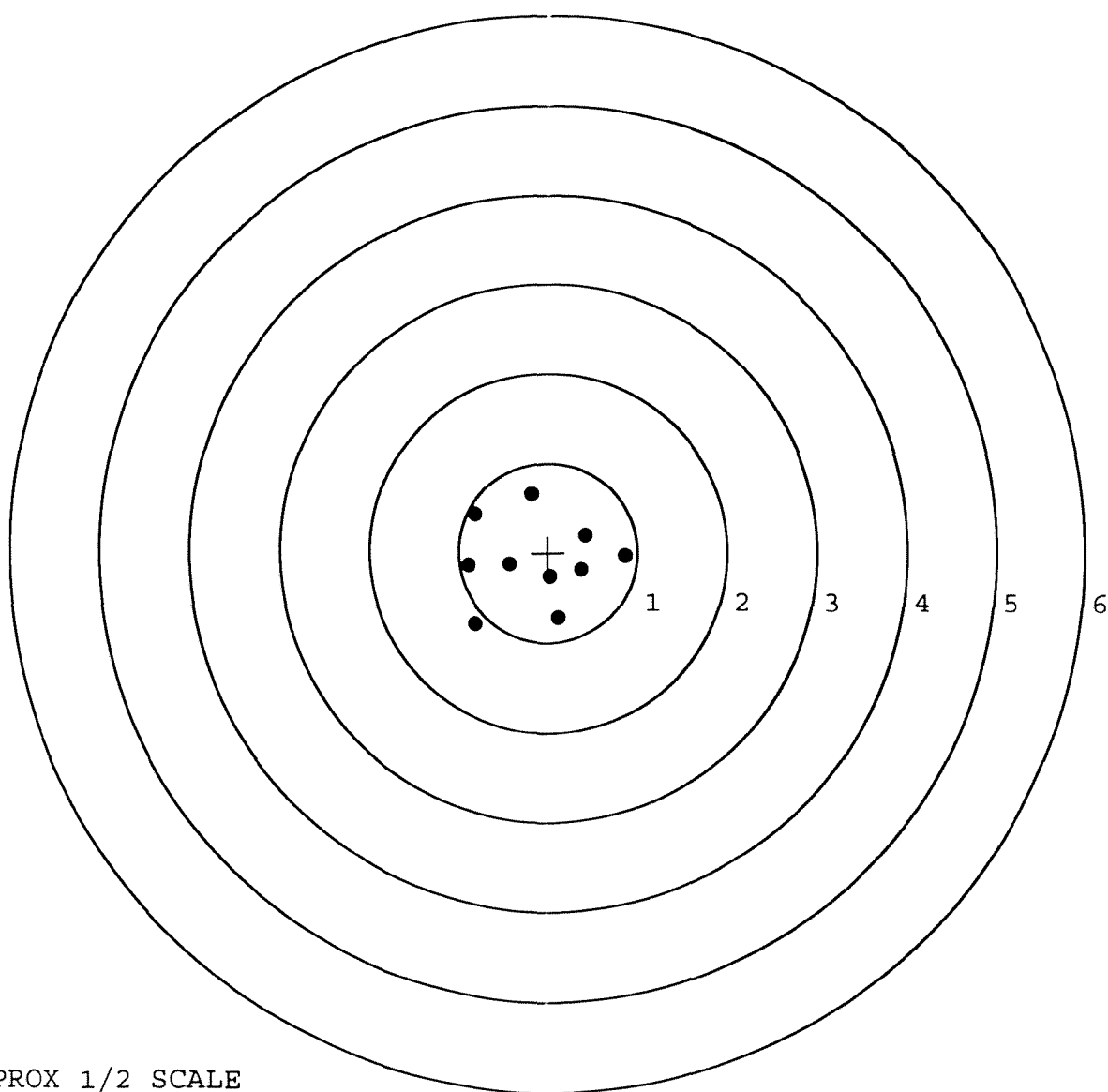
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.100
The Average Y Centroid of the Five Target Set:	0.001
The Average Point of Impact of the Five Target Set:	0.100
The Average Mean Radius of the Five Target Set:	0.704
The Distance from POA to Centroid Target #1:	0.171
The Distance from Centroid Target #2 to Centroid Target #1:	0.144
The Distance from Centroid Target #3 to Centroid Target #1:	0.263
The Distance from Centroid Target #4 to Centroid Target #1:	0.274
The Distance from Centroid Target #5 to Centroid Target #1:	0.143

SERIAL NUMBER: C6414351.___0
TARGET NUMBER: 1
FILE DATE: 05/20/2008
FILE TIME: 22:22

X CENTROID: -0.132
Y CENTROID: -0.110
POA TO CENTROID: 0.171
HORZ SPREAD: 1.753
VERT SPREAD: 1.462
GROUP SPREAD: 1.839
MIN RADIUS: 0.222
MAX RADIUS: 0.998
MEAN RADIUS: 0.670
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 10
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.184	0.650
2:	-0.819	0.414
3:	-0.432	-0.139
4:	-0.889	-0.155
5:	-0.807	-0.812
6:	0.422	0.188
7:	0.864	-0.045
8:	0.376	-0.199
9:	0.024	-0.268
10:	0.126	-0.730

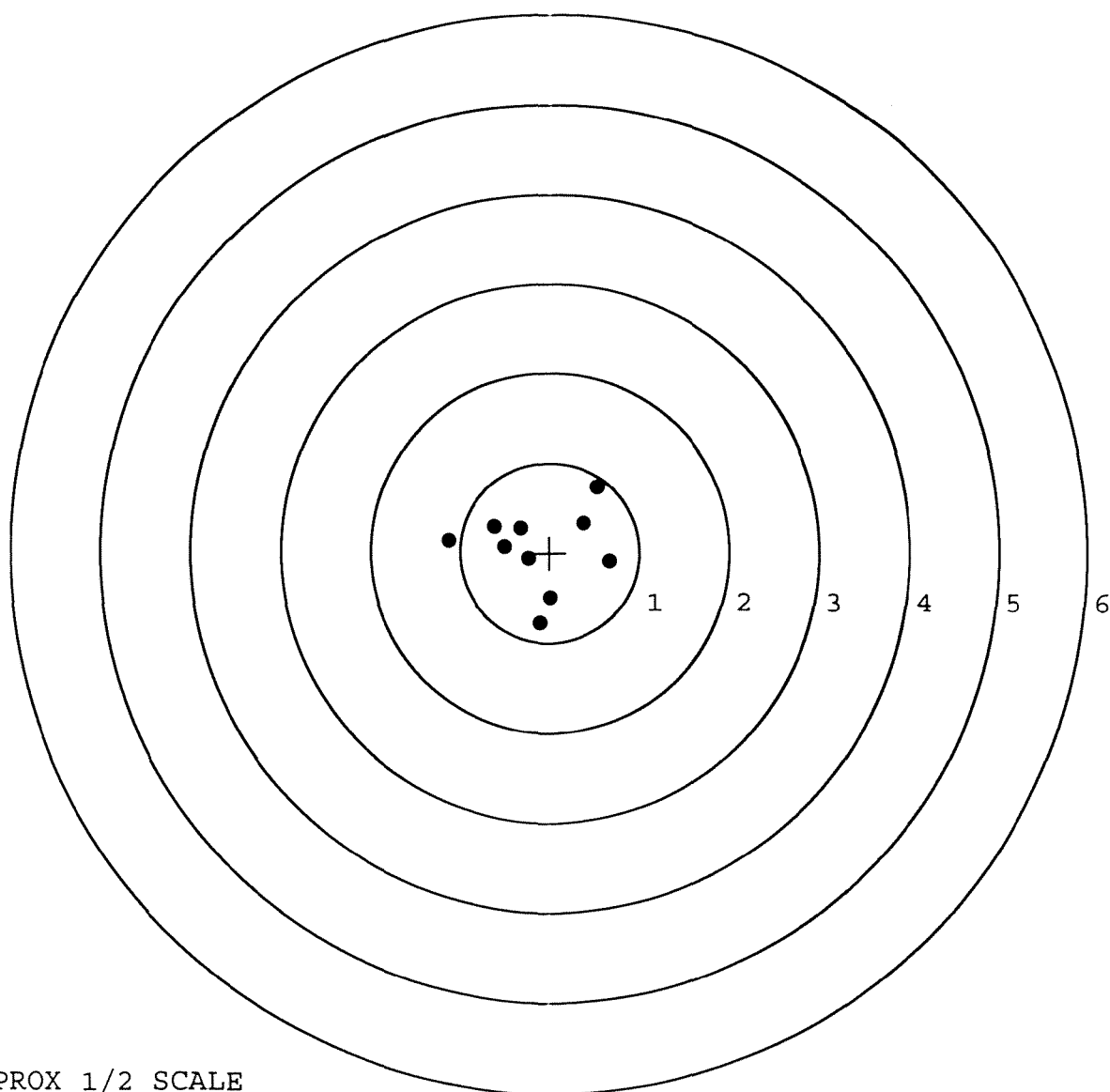


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6414351. __0
TARGET NUMBER: 2
FILE DATE: 05/20/2008
FILE TIME: 22:22

X CENTROID: -0.131
Y CENTROID: 0.035
POA TO CENTROID: 0.135
HORZ SPREAD: 1.800
VERT SPREAD: 1.511
GROUP SPREAD: 1.814
MIN RADIUS: 0.142
MAX RADIUS: 1.002
MEAN RADIUS: 0.611
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.539	0.726
2:	0.382	0.326
3:	-0.616	0.285
4:	-0.504	0.063
5:	-0.234	-0.063
6:	-1.129	0.126
7:	0.009	-0.502
8:	-0.101	-0.785
9:	0.671	-0.101
10:	-0.326	0.273



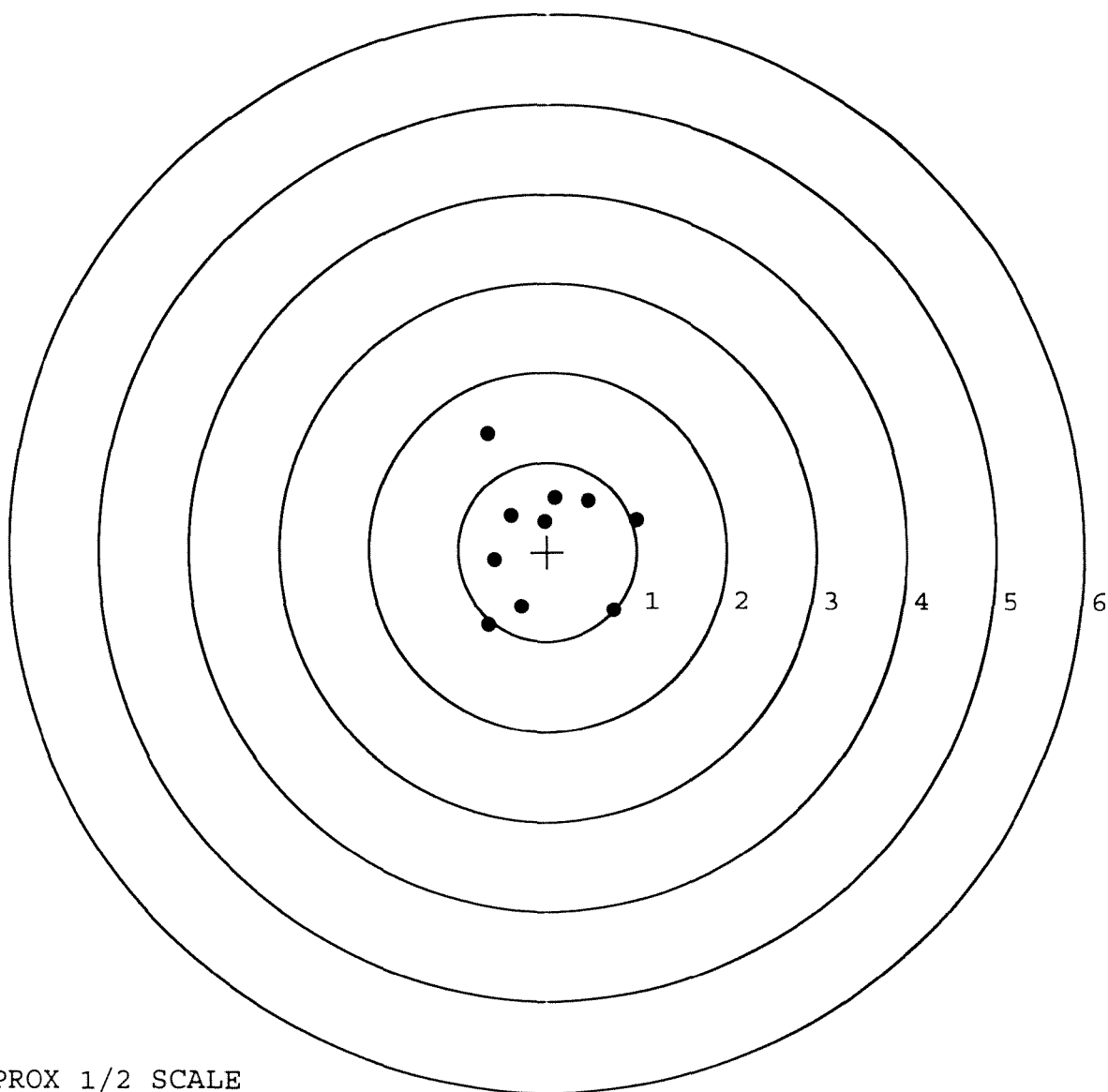
TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6414351. __0
TARGET NUMBER: 3
FILE DATE: 05/20/2008
FILE TIME: 22:22

X CENTROID: -0.032
Y CENTROID: 0.134
POA TO CENTROID: 0.138
HORZ SPREAD: 1.664
VERT SPREAD: 2.137
GROUP SPREAD: 2.427
MIN RADIUS: 0.203
MAX RADIUS: 1.333
MEAN RADIUS: 0.784

IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 6
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.668	1.306
2:	0.463	0.565
3:	0.087	0.604
4:	-0.030	0.337
5:	-0.400	0.396
6:	-0.587	-0.101
7:	0.996	0.348
8:	0.753	-0.661
9:	-0.286	-0.620
10:	-0.650	-0.831

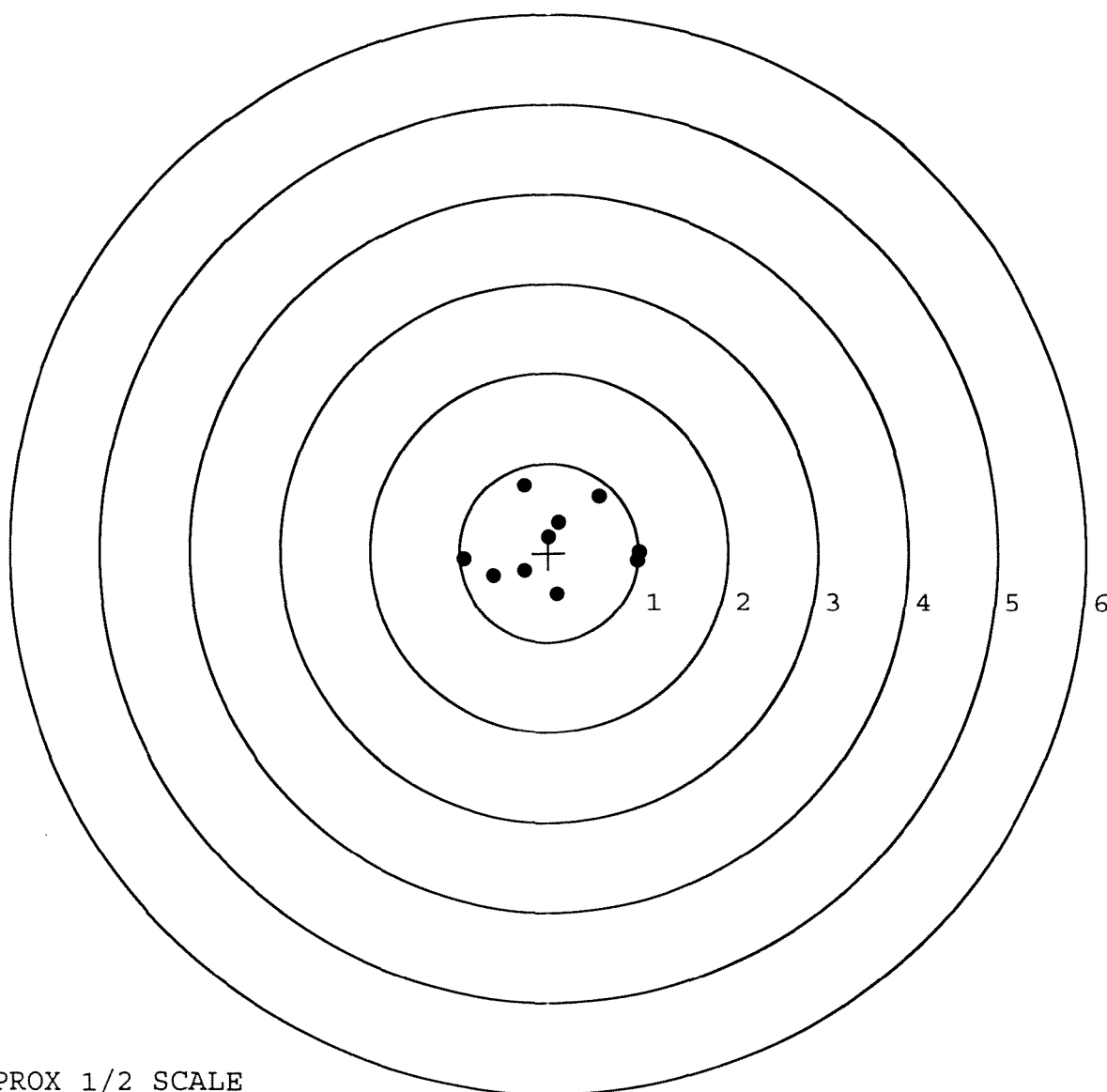


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6414351. __0
TARGET NUMBER: 4
FILE DATE: 05/20/2008
FILE TIME: 22:22

X CENTROID: 0.067
Y CENTROID: 0.080
POA TO CENTROID: 0.104
HORZ SPREAD: 1.962
VERT SPREAD: 1.214
GROUP SPREAD: 1.964
MIN RADIUS: 0.120
MAX RADIUS: 1.032
MEAN RADIUS: 0.654
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.270	0.749
2:	0.568	0.625
3:	0.114	0.340
4:	0.000	0.179
5:	-0.273	-0.203
6:	-0.615	-0.265
7:	-0.952	-0.086
8:	0.096	-0.465
9:	1.010	0.010
10:	0.990	-0.087

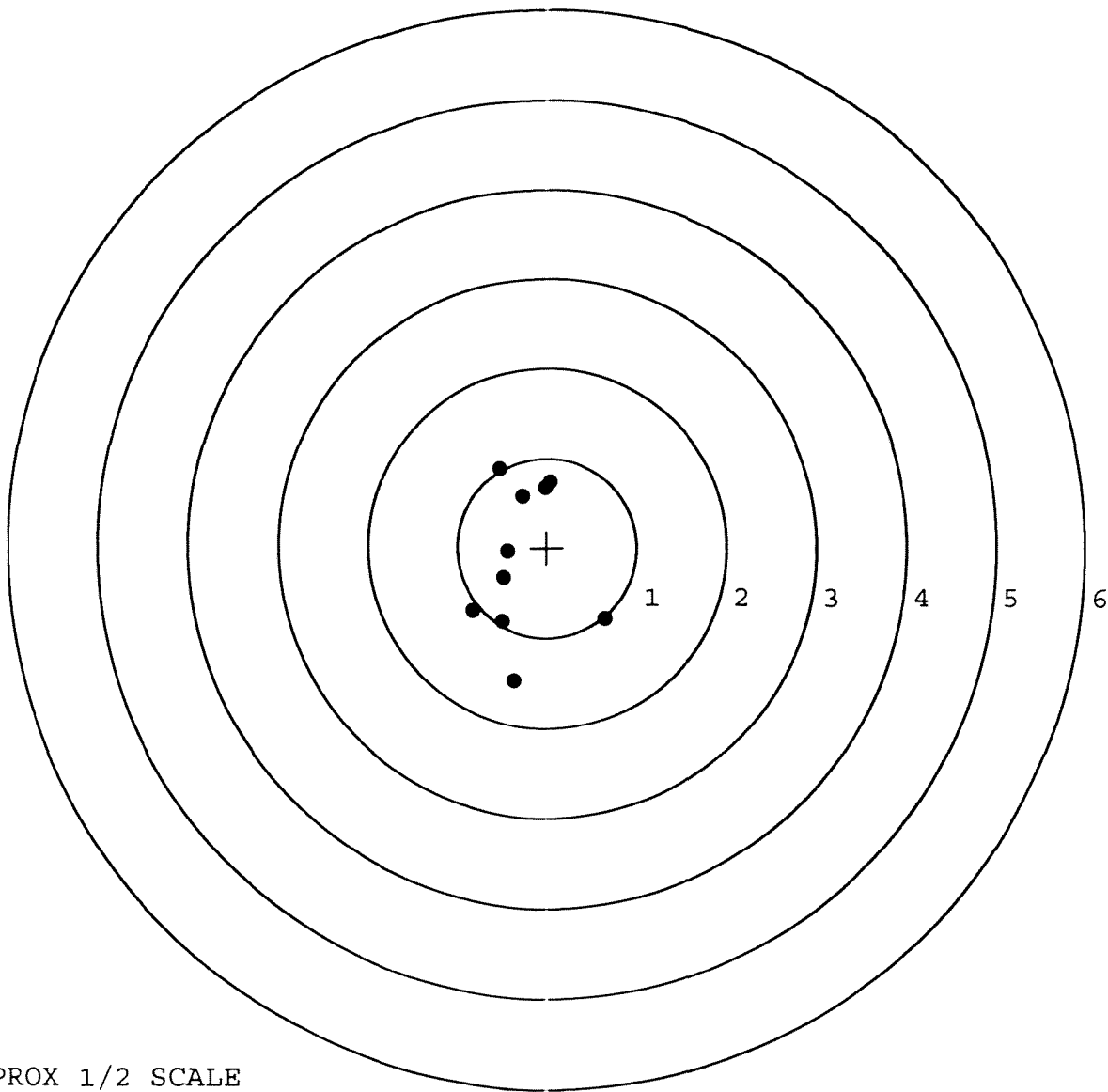


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6414351. __0
TARGET NUMBER: 5
FILE DATE: 05/20/2008
FILE TIME: 22:22

X CENTROID: -0.273
Y CENTROID: -0.132
POA TO CENTROID: 0.303
HORZ SPREAD: 1.482
VERT SPREAD: 2.359
GROUP SPREAD: 2.364
MIN RADIUS: 0.188
MAX RADIUS: 1.349
MEAN RADIUS: 0.802
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.522	0.881
2:	-0.269	0.577
3:	-0.019	0.671
4:	-0.437	-0.041
5:	-0.485	-0.334
6:	-0.831	-0.709
7:	-0.494	-0.824
8:	-0.367	-1.478
9:	0.651	-0.799
10:	0.046	0.736



TARGET APPROX 1/2 SCALE

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

R & E NUMBER 00144831
SERIAL NUMBER G6414351
LOG-IN DATE 4-24-08

OPERATION #	OPERATION NAME		DATE	INITIAL
500	DIS-ASSEMBLE GUN		5-2-08	RP
505	RE-BARREL		5-6-08	RTZ
560	ASSEMBLE		5-6-08	RTZ
600	PROOF	MAGNA - FLUX	5-7-08	TRW
605	CHECK HEADSPACE	MAY 09 2008	5-7-08	TRW
610	DIS-ASSEMBLE GUN		5-7-08	RTZ
612	MAGNAFLUX	OPERATOR <u>unmg</u>	5/9/08	unmg
510	DRILL AND TAP		5-7-08	TRW
615	ROLLMARK CALIBER		5-7-08	CW
618	ROTO-BLAST		5-9-08	DG
620	APPLY COATINGS		5/19/08	UN
625	FINAL ASSEMBLY		5-20-08	RTZ
640	FUNCTION TEST AND	PASS FAIL	5-20-08	SD
650	TARGET	PASS FAIL	5-20-08	SD
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION	5-20-08	RP
670	FINAL INSPECTION		5/22/08	FM
	A) HEADSPACE	PASS FAIL	5/22/08	FM
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	2.73 2.58 2.57 2.52 2.59 5-22-08	TRW
680	F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX	5.5 5.5 5.5 5/22/08	FM
	G) SAFETY OFF FORCE	2 LBS MIN	3.5 3.5 3.5 5/22/08	FM
	I) FIRING PIN INDENT	.020	.023 .023 .025 5/22/08	FM
690	PACK		5/27/08	FM

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: **RE00092468** Serial: C6225476 Model: M24 SWS Center Fire Caliber: 7.62 NATO Produced: 10/26/1998 Repairman: Status: Closed 2/4/2005 9:37:54 AM

Verify Repair

Address Information

Customer: ☒ Received From Return To: ☐ Received From

Name: DEF DIST DEPOT ANNISTON DEF DIST DEPOT ANNISTON

Address 1: Address 2: PO Box: PO Box:

City: ANNISTON ANNISTON

State: AL Zip Code: 362014199 Country: US State: AL Zip Code: 362014199 Country: US

FFL: ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐

Contact / Condition Problems Estimate History / Status Shipping / Billing

Contact Information: Phone: Fax: Email: Comments:

Received Condition: Good Condition Notes: CSR Notes:

Accessories Received:

Code	Desc	Qty
A007	With Stud	3
A010	Hard Case	1
A017	Scope Base	1
A026	Scope	1
A057	Frt and Rear Sgt Base	1

Repair Search Refresh Close

hagletj 2/7/2005 11:27 AM CAPS NUM INS SCRL

start 3 Arms Services R 3

66414351

Serial Number: **C6225476**

Model: **M24 SWS**



RE00092468

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6414351.___0
FILE DATE AND TIME: 05/02/2005 06:50

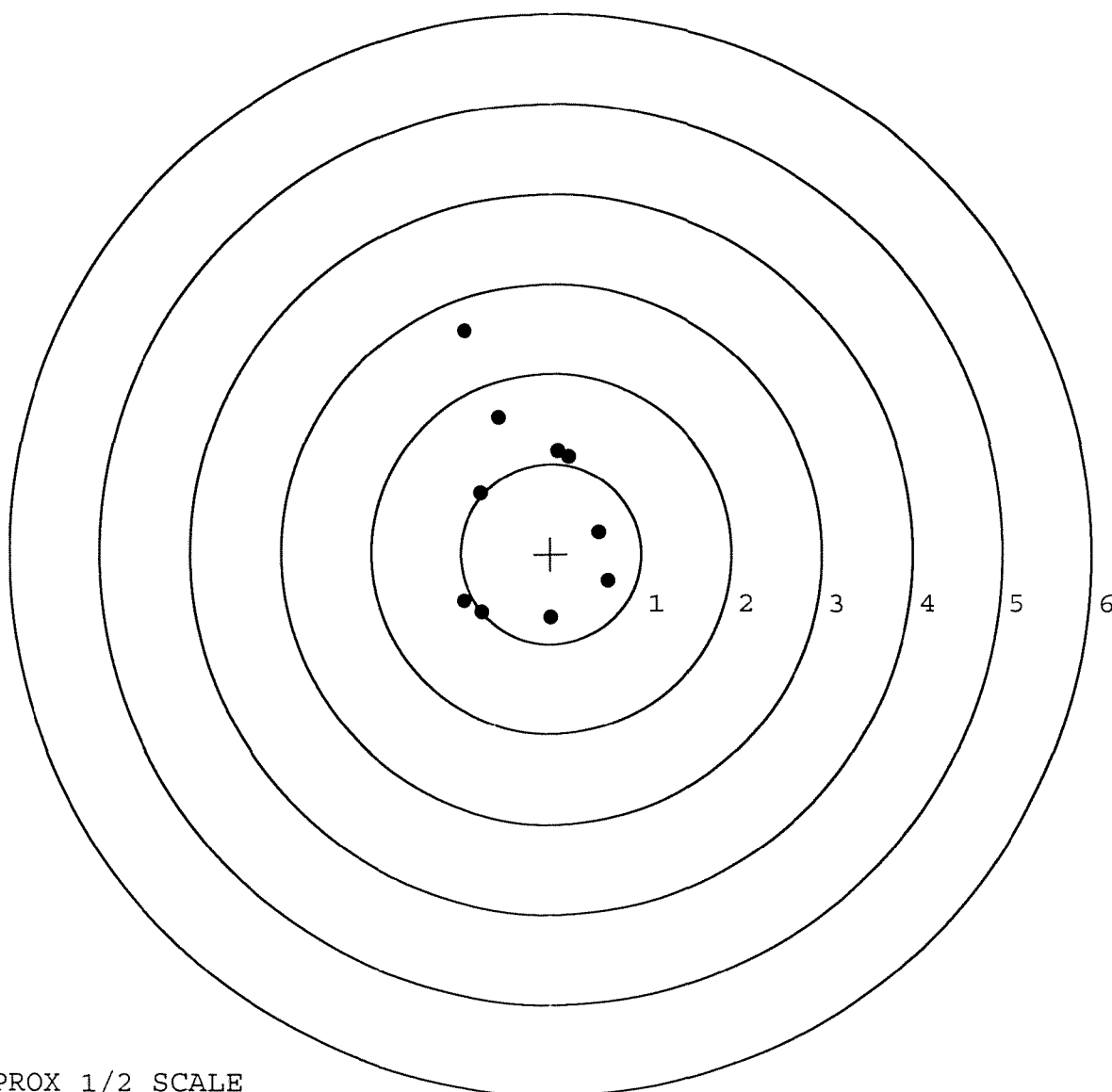
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.023
The Average Y Centroid of the Five Target Set:	0.282
The Average Point of Impact of the Five Target Set:	0.283
The Average Mean Radius of the Five Target Set:	1.169
The Distance from POA to Centroid Target #1:	0.554
The Distance from Centroid Target #2 to Centroid Target #1:	0.369
The Distance from Centroid Target #3 to Centroid Target #1:	0.722
The Distance from Centroid Target #4 to Centroid Target #1:	0.363
The Distance from Centroid Target #5 to Centroid Target #1:	0.460

SERIAL NUMBER: G6414351. __0
TARGET NUMBER: 1
FILE DATE: 05/02/2005
FILE TIME: 06:50

X CENTROID: -0.258
Y CENTROID: 0.490
POA TO CENTROID: 0.554
HORZ SPREAD: 1.601
VERT SPREAD: 3.182
GROUP SPREAD: 3.323
MIN RADIUS: 0.546
MAX RADIUS: 2.104
MEAN RADIUS: 1.096
IN 1 IN DIAMETER: 0
IN 2 IN DIAMETER: 4
in 3 IN DIAMETER: 9

POINT#	X	Y
1:	0.639	-0.303
2:	0.535	0.234
3:	-0.005	-0.709
4:	-0.763	-0.658
5:	-0.962	-0.538
6:	0.206	1.078
7:	0.083	1.142
8:	-0.774	0.668
9:	-0.581	1.510
10:	-0.961	2.473

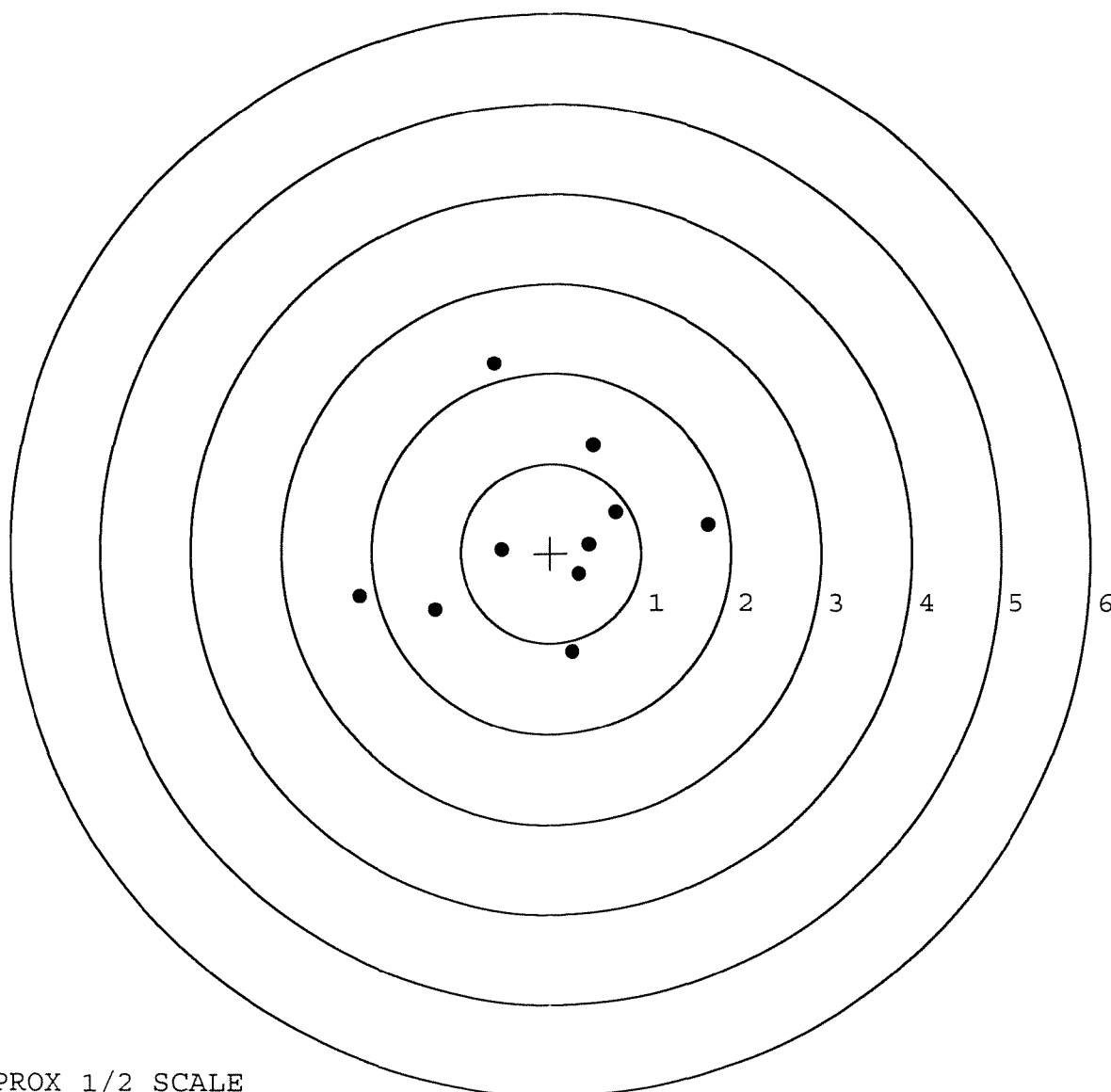


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6414351. __0
TARGET NUMBER: 2
FILE DATE: 05/02/2005
FILE TIME: 06:50

X CENTROID: -0.067
Y CENTROID: 0.174
POA TO CENTROID: 0.186
HORZ SPREAD: 3.884
VERT SPREAD: 3.211
GROUP SPREAD: 3.969
MIN RADIUS: 0.492
MAX RADIUS: 2.179
MEAN RADIUS: 1.236
IN 1 IN DIAMETER: 1
IN 2 IN DIAMETER: 4
in 3 IN DIAMETER: 7

POINT#	X	Y
1:	1.745	0.318
2:	0.242	-1.103
3:	0.317	-0.240
4:	0.432	0.096
5:	0.722	0.455
6:	0.473	1.204
7:	-0.632	2.108
8:	-1.291	-0.641
9:	-2.139	-0.500
10:	-0.541	0.040

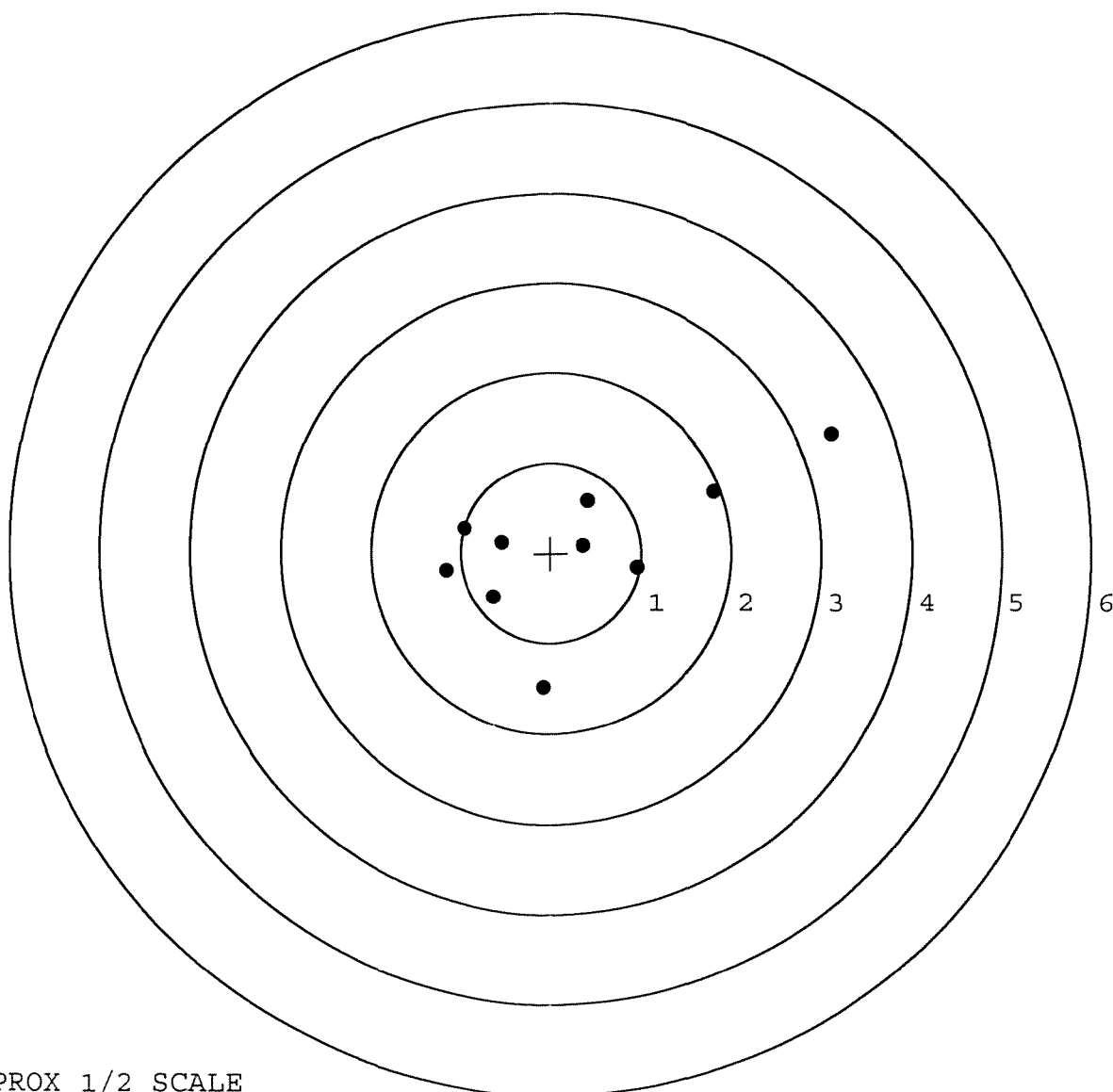


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6414351. __0
 TARGET NUMBER: 3
 FILE DATE: 05/02/2005
 FILE TIME: 06:50

X CENTROID: 0.328
 Y CENTROID: 0.069
 POA TO CENTROID: 0.335
 HORZ SPREAD: 4.266
 VERT SPREAD: 2.814
 GROUP SPREAD: 4.528
 MIN RADIUS: 0.041
 MAX RADIUS: 3.044
 MEAN RADIUS: 1.228
 # IN 1 IN DIAMETER: 1
 # IN 2 IN DIAMETER: 4
 # in 3 IN DIAMETER: 6

POINT#	X	Y
1:	3.105	1.316
2:	1.806	0.674
3:	0.955	-0.162
4:	-0.081	-1.498
5:	0.366	0.084
6:	0.419	0.577
7:	-0.541	0.124
8:	-0.635	-0.492
9:	-1.161	-0.203
10:	-0.955	0.269

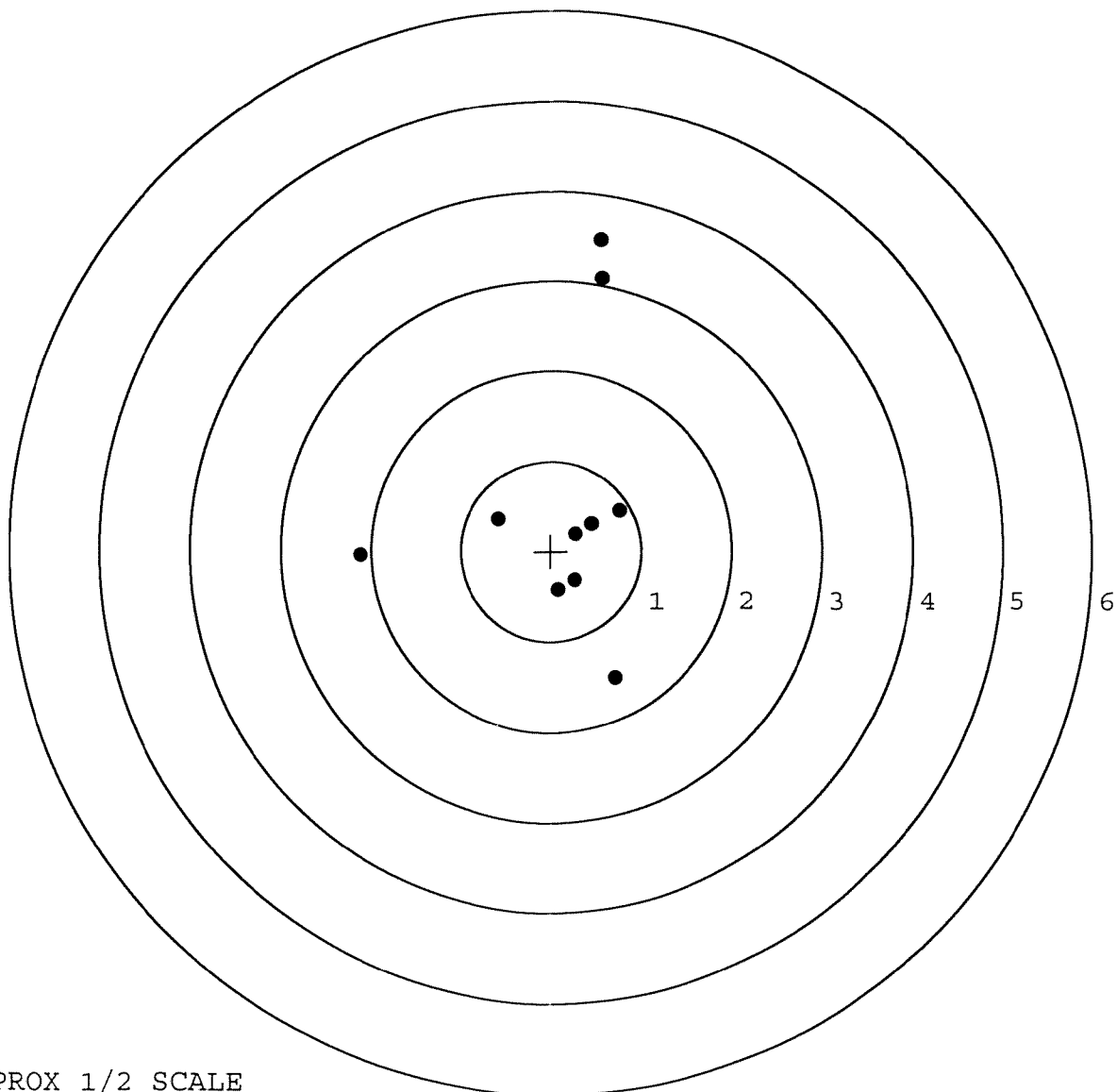


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6414351. __0
TARGET NUMBER: 4
FILE DATE: 05/02/2005
FILE TIME: 06:50

X CENTROID: 0.098
Y CENTROID: 0.556
POA TO CENTROID: 0.565
HORZ SPREAD: 2.885
VERT SPREAD: 4.856
GROUP SPREAD: 4.859
MIN RADIUS: 0.408
MAX RADIUS: 2.931
MEAN RADIUS: 1.392
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 6
in 3 IN DIAMETER: 6

POINT#	X	Y
1:	0.719	-1.405
2:	0.082	-0.427
3:	0.268	-0.326
4:	0.761	0.448
5:	0.459	0.303
6:	0.276	0.189
7:	-0.583	0.357
8:	-2.124	-0.054
9:	0.570	3.025
10:	0.555	3.451

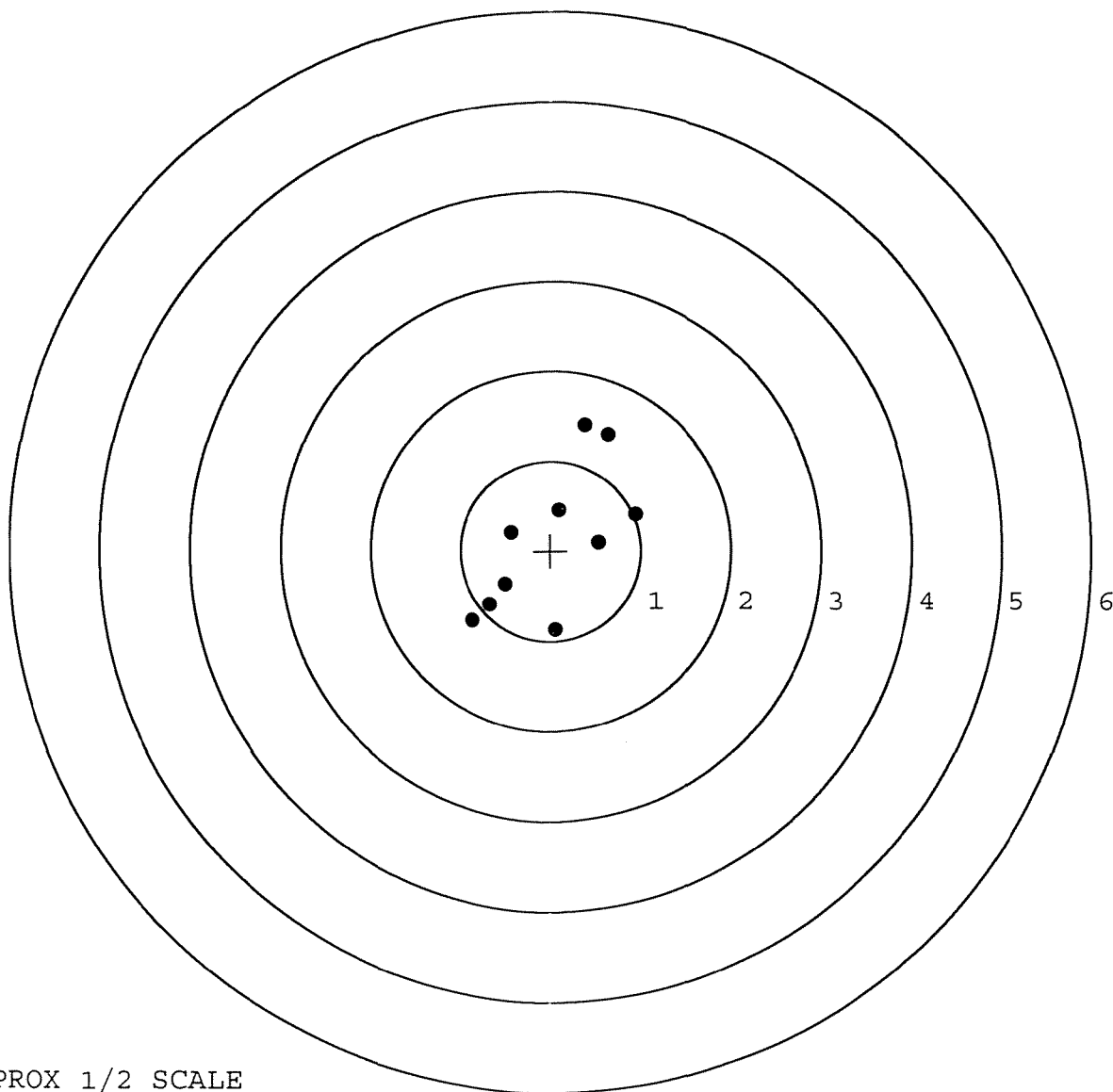


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6414351. __0
 TARGET NUMBER: 5
 FILE DATE: 05/02/2005
 FILE TIME: 06:50

X CENTROID: 0.017
 Y CENTROID: 0.121
 POA TO CENTROID: 0.122
 HORZ SPREAD: 1.817
 VERT SPREAD: 2.276
 GROUP SPREAD: 2.511
 MIN RADIUS: 0.337
 MAX RADIUS: 1.328
 MEAN RADIUS: 0.892
 # IN 1 IN DIAMETER: 2
 # IN 2 IN DIAMETER: 6
 # in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.059	-0.880
2:	0.538	0.088
3:	0.944	0.406
4:	0.634	1.290
5:	0.385	1.396
6:	0.098	0.448
7:	-0.435	0.201
8:	-0.503	-0.372
9:	-0.680	-0.594
10:	-0.873	-0.777



TARGET APPROX 1/2 SCALE

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

R & E NUMBER	92468		
SERIAL NUMBER	C60223476	66414351	
LOG-IN DATE	2-4-05		
INSPECT AND VERIFY:			
OPERATION #	OPERATION NAME	DATE	INITIAL
550	DIS-ASSEMBLE GUN	4-4-05	RTZ
560 A	RE-BARREL	4-7-05	RTZ
B	DRILL AND TAP	4-11-05	TRW
575	ASSEMBLE	4-7-05	RTZ
600	PROOF	4-8-05	AC
605	CHECK HEADSPACE	4-8-05	AC
610	DIS-ASSEMBLE GUN	4-19-05	RTZ
612	MAGNAFLUX	OPERATOR	BS
615	ROLLMARK CALIBER	4-12-05	CW
618	ROTO-BLAST	4-18-05	LB
620	APPLY COATINGS	4-25-05	WJ
625 A	FINAL ASSEMBLY	4-28-05	RTZ
B	TRIGGER PULL TEST		
C	SAFETY "ON" FORCE	5-3-05	AC
D	SAFETY "OFF" FORCE	5-3-05	AC
E	FIRING PIN INDENT	5-3-05	AC
640	TARGET	5-2-05	AC
655	FINAL INSPECT	5-3-05	AC
660	PACK	5-5-05	DA
		SHIP DATE	
		QAR INSPECTION DATE	

00299

5091

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6225476

OPERATION		DATE	INT
#	NAME		
575-580	ASSEMBLY 2	26	F.B.
600	PROOF		RW
615	MAGNAFLUX BARREL	5/13/88	P/E.
	MAGNAFLUX BOLT	5/13/88	P/E.
620	COATING	8/1/88	TJA
625-630	FINAL ASSEMBLY		
635	TEST		
640	TARGET		
	FIRING PIN INDENT		
660	PACK		

SCOPE # 1095

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6225476

OP.#	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and stock			
600	Proof			
607	Check Headspace			
610	Dis-assemble gun			
612	Magnaflux Barrel Action			
	Magnaflux Bolt			
615	Rollmark Caliber			
617	Drill & Tap Sight Holes			
618	Polish Barrel			
620	Apply Coatings (Barrel Action)			
	Apply Coatings (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/25/88	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/25/88	RW
	C) Inspect Ejector Hole for Chamfer		8/25/88	RW

OVER

OP.#		READINGS	DATE	INITIAL
625 cont.	D) Oil Firing Pin Ass'y		8/25/88	RW
	E) Adjust Trigger Pull to Min. Setting and Stake		25aug88	J.U. + J.S.
	F) Safety on Force	4 4 4	25aug88	J.U. + J.S.
	G) Safety off Force	2.75 3 3	25aug88	J.U. + J.S.
	H) Trigger Pull Test & Retainability		25aug88	J.U. + J.S.
	I) Firing Pin Indent	.0225 .0225 .0225	25aug88	J.U. + J.S.
	J) Assemble Stock		9/26/88	RW
	K) Assemble Swivel Studs		16-88	J.S.
	L) Attach Front & Rear Sight Assemblies		9/26/88	RW
	M) Iron Sight Alignment		9/26/88	RW
	N) Detach Front & Rear Sights & place in numbered container		9/26/88	RW
	O) Attach Scope to Rifle		10/1/88	RW
	P) Detach & Attach Scope 20 times		10-1-88	J.S.
640	Gallery Target & Test	45R 110L	10/3/88	W.B.
	A) Optical Clarity of Scope		10/3/88	W.B.
645	Inspect for Live Ammo		10/3/88	A.C. & J.S.
655	Final Inspection A) Headspace		10-6-88	J.S.
	B) Trigger Pull		10-6-88	J.S.
	C) Function		10-6-88	J.S.
660	Pack		10-20-88	J.S.

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6225476

DATE 25 Aug 88

TESTER J. D. F. S.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.48	2.18	2.13	2.71	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.46	2.26	2.06	2.73	
PULL #3	2.22	2.20	2.11	2.80	
PULL #4	2.53	2.22	2.24	2.68	
PULL #5	2.54	2.13	2.13	2.92	
TOTAL	12.23	10.99	10.67	13.84	
AVG.	2.446	2.198	2.134	2.768	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.09	3.08		
PULL #2	3.02	3.00		
PULL #3	3.14	3.00		
PULL #4	3.00	3.01		
PULL #5	3.04	3.01		
TOTAL	15.29	15.10		
AVG.	3.058	3.02		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.12	4.14		4.01
PULL #2	4.19	4.16		3.93
PULL #3	4.19	4.14		3.96
PULL #4	4.16	4.13		3.96
PULL #5	4.19	4.17		3.96
TOTAL	20.85	20.74		19.82
AVG.	4.17	4.148		3.964

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6225476

CENTROIDAL DISTANCES

0 TO	1	1.65963
1 TO	2	.666694
1 TO	3	.586042
1 TO	4	1.40018
1 TO	5	1.09264

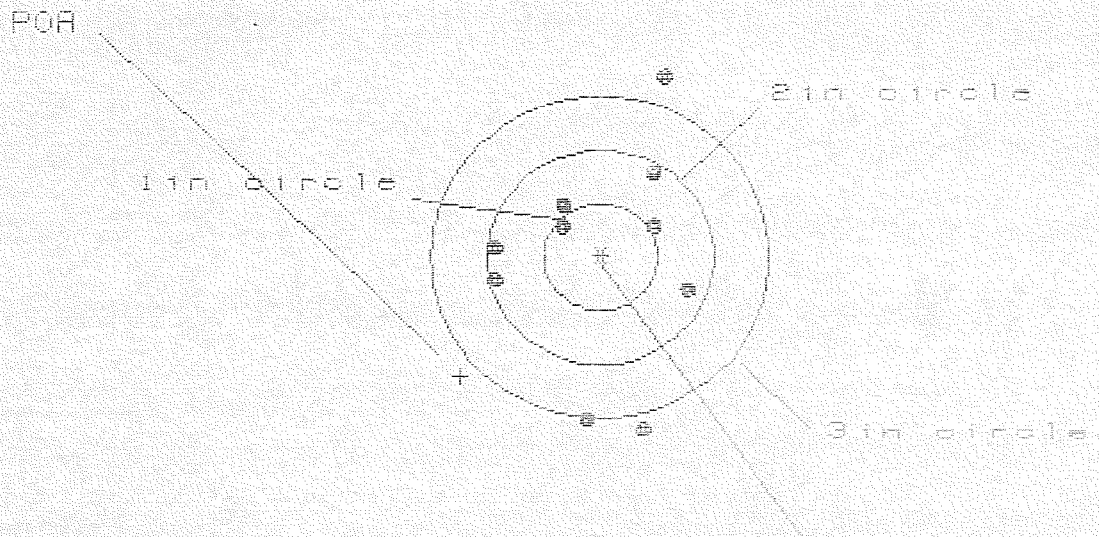
1
2
+ 5 (----POA
4

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: 1.0702
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .3954
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: 1.14091
THE AMR FOR THIS RIFLE IS: .9804

5 Oct 1988

FILE:/PATTERNING/CENTERFIRE_PATT/06225476

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 1

2in = 7

3in = 8

HS= 1.748

VS= 3.274

GS= 3.279

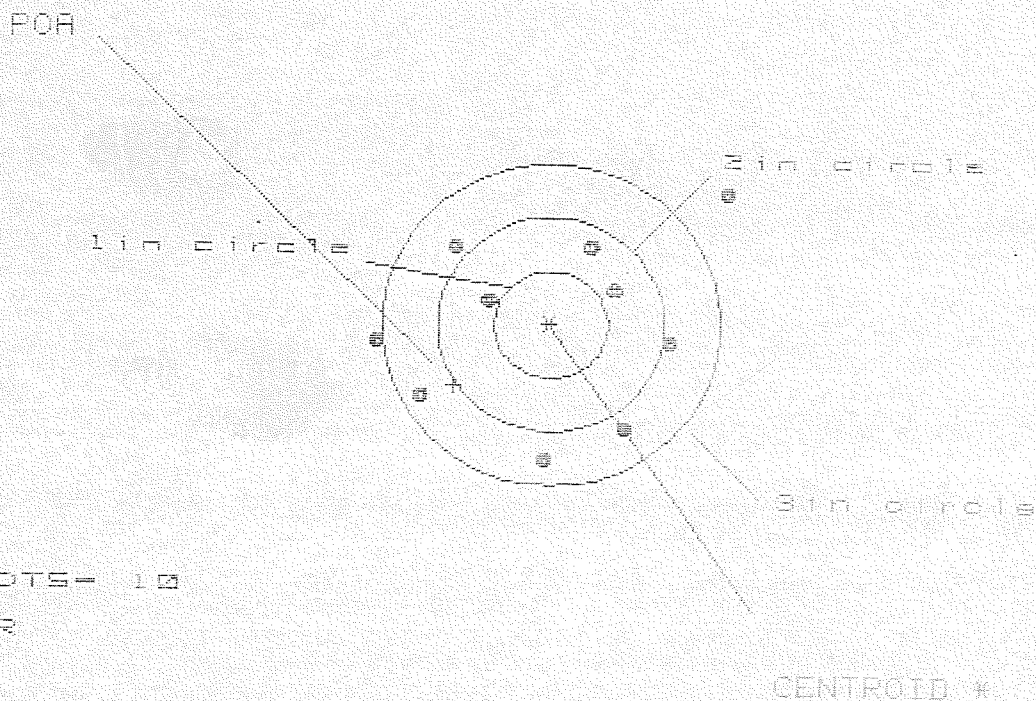
CENTROID *

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.793	.856	.911
MINIMUM X	:	-.955	-.892	-.837
MAXIMUM Y	:	1.691	1.003	.829
MINIMUM Y	:	-1.583	-1.395	-1.460
CENTROID X	:	1.232	1.169	1.114
CENTROID Y	:	1.112	.924	1.098
POA TO CENTROID in.	:	1.660	1.490	1.564
MIN RADIUS	:	.420	.520	.345
MEAN RADIUS	:	1.015	.944	.832
MAX RADIUS	:	1.784	1.464	1.460
HORIZONTAL SPREAD	:	1.748	1.748	1.748
VERTICAL SPREAD	:	3.274	2.398	2.289
EXTREME SPREAD	:	3.279	2.401	2.374
NUMBER IN ONE INCH CIRCLE =		1		
NUMBER IN TWO INCH CIRCLE =		7		
NUMBER IN THREE INCH CIRCLE =		8		

5 Oct 1988

FILE:/PATTERNING/CENTERFIRE_PATT/06225476

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1 in = 0

2 in = 3

3 in = 8

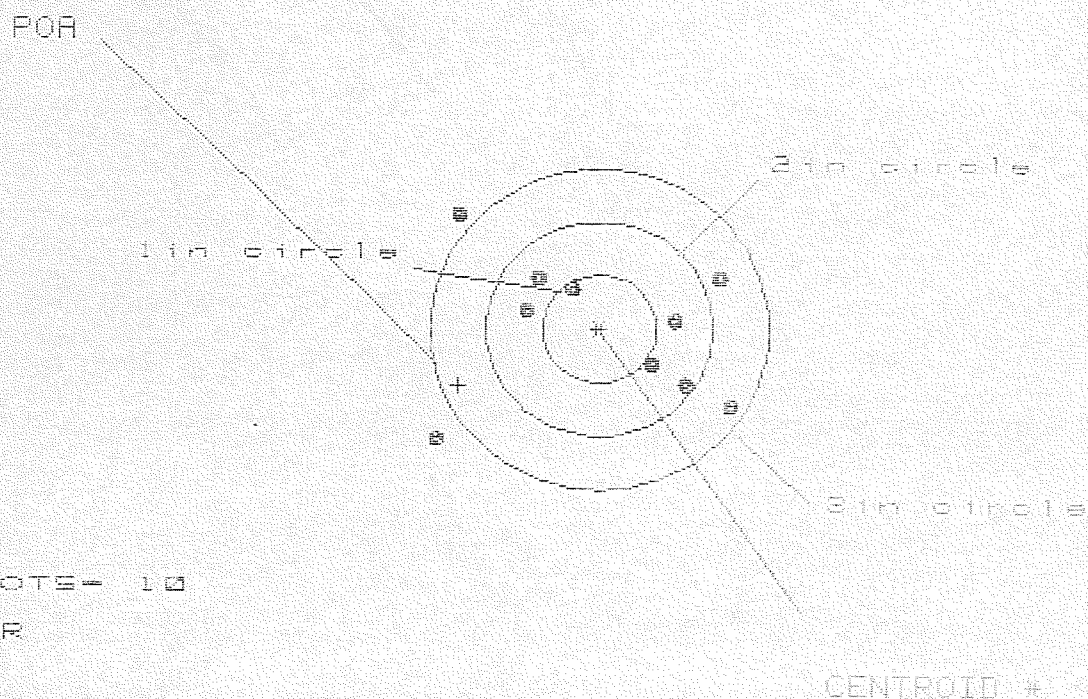
HS= 3.079

VS= 2.581

GS= 3.418

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.514	1.268	1.090
MINIMUM X	:	-1.565	-1.397	-1.190
MAXIMUM Y	:	1.282	.867	.860
MINIMUM Y	:	-1.299	-1.157	-1.164
CENTROID X	:	.848	.690	.855
CENTROID Y	:	.567	.425	.432
POA TO CENTROID in.	:	1.020	.802	.958
MIN RADIUS	:	.588	.536	.663
MEAN RADIUS	:	1.160	1.067	1.011
MAX RADIUS	:	1.984	1.398	1.285
HORIZONTAL SPREAD	:	3.079	2.665	2.283
VERTICAL SPREAD	:	2.581	2.024	2.024
EXTREME SPREAD	:	3.418	2.665	2.328
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		8	

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 6

3 in = 8

HS= 2.591

VS= 2.108

GS= 3.043

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.173	1.015	.837
MINIMUM X	-1.418	-1.421	-.947
MAXIMUM Y	1.103	.991	.500
MINIMUM Y	-1.005	-.833	-.709
CENTROID X	1.239	1.397	1.575
CENTROID Y	.526	.638	.514
POA TO CENTROID in.	1.346	1.536	1.656
MIN RADIUS	.411	.450	.319
MEAN RADIUS	.990	.888	.751
MAX RADIUS	1.738	1.733	1.097

	1	2	3
HORIZONTAL SPREAD	2.591	2.436	1.784
VERTICAL SPREAD	2.108	1.824	1.209
EXTREME SPREAD	3.043	3.043	2.108
NUMBER IN ONE INCH CIRCLE =	1	6	8
NUMBER IN TWO INCH CIRCLE =	6	8	8
NUMBER IN THREE INCH CIRCLE =	8	8	8

5 Oct 1988

FILE://PATTERNING/CENTERFIRE_PATT/06225476

CENTERFIRE PATTERNS

4

POR

1 in circle

2 in circle

2 in circle

CENTROID *

OF SHOTS- 10

IN CIR

1 in = 2

2 in = 8

3 in = 9

HS= 2.886

VS= 1.475

GS= 2.887

PATTERN #

:

4

SHOTS (BEST OF)

:

10

9

8

MAXIMUM X

:

1.897

.926

.829

MINIMUM X

:

-.989

-.778

-.693

MAXIMUM Y

:

.857

.789

.710

MINIMUM Y

:

-.618

-.632

-.669

CENTROID X

:

.929

.718

.815

CENTROID Y

:

-.255

-.187

-.108

POR TO CENTROID in.:

:

.963

.742

.822

MIN RADIUS

:

.244

.458

.330

MEAN RADIUS

:

.865

.720

.671

MAX RADIUS

:

1.995

1.026

.956

HORIZONTAL SPREAD

:

2.886

1.704

1.512

VERTICAL SPREAD

:

1.475

1.421

1.379

EXTREME SPREAD

:

2.887

2.019

1.856

NUMBER IN ONE INCH CIRCLE =

2

NUMBER IN TWO INCH CIRCLE =

8

NUMBER IN THREE INCH CIRCLE =

9

5 Oct 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C6825478

CENTERFIRE PATTERNS

5

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS= 10

IN CIR

1 in = 0

2 in = 9

3 in = 9

HS= 2.581

VS= 2.141

GS= 3.006

PATTERN #

5

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.765	.780	.749
MINIMUM X	-.816	-.620	-.651
MAXIMUM Y	1.161	.760	.666
MINIMUM Y	-.980	-.851	-.945
CENTROID X	1.103	.907	.938
CENTROID Y	.027	-.102	-.008
POA TO CENTROID in.	1.104	.913	.938
MIN RADIUS	.501	.463	.529
MEAN RADIUS	.872	.703	.683
MAX RADIUS	2.112	.900	.991
HORIZONTAL SPREAD	2.581	1.400	1.400
VERTICAL SPREAD	2.141	1.611	1.611
EXTREME SPREAD	3.006	1.646	1.646
NUMBER IN ONE INCH CIRCLE =		0	
NUMBER IN TWO INCH CIRCLE =		9	
NUMBER IN THREE INCH CIRCLE =		9	

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6225476

OP. #	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and Stock		2/12/92	RW
600	Proof		2/12/92	RW
607	Check Headspace		2/12/92	RW
610	Dis-assemble Gun		2/12/92	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			
	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	3.5	4	4			2/26/92	RW
	G) Safety Off Force	2.5	2.5	2.5			2/26/92	RW
	H) Trigger Pull Test & Retainability							
	I) Firing Pin Indent	.0215	.022	.021			2/26/92	RW
	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						2-21-92	✓
	A) Time						2-21-92	✓
	B) Malfunctions						2-21-92	✓
	C) Pierced Primers						2-21-92	✓
	D) Optical Clarity of Scope						2-21-92	✓
645	Inspect for Live Ammo						2-21-92	✓
655	Final Inspection							
	A) Headspace						2/26/92	RW
	B) Trigger Pull	2.46	2.49	2.45	2.41	2.44	2/25/92	FW
	C) Function						2/26/92	RW
660	Pack							

RECEIVING AND ESTIMATING REPORT

COMMENTS

ORDER
R 92-03445

INITIAL CUSTOMER ORDER NO.

JJM 67686

M24

DATE RECEIVED

DATE OPENED

DATE CODE

SERIAL NUMBER

NEW SERIAL NUMBER

MODEL AND GRADE

01/28/92

01/28/92

KI 5-88

C6225476

700

7.62

NATO

ACCESSORIES

W/STUDS

SCOPE BASE

FROM:

CO D 2ND BN 1ST SPWAR TNG GP

C/O CPT M K STEPHENSON

FT BRAGG

NC 28307

SHIP TO:

CO D 2ND BN 1ST SPWAR TNG GP

C/O CPT M K STEPHENSON

FT BRAGG

NC

28307

CUST NO: 046771 CJO.DL

ACCOUNT NUMBER

ACCOUNT NUMBER N/C

WRITE ☐

CLEAN/TEST

PROM. DATE

ESTIMATED

VIA

DOOR

GUN CONDITION

☐ NEW☐ LIGHTLY WORN☐ WORN☐ VERY WORN☐ UNREPAIRABLE

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

o New Barrel

PARTS

COMMENTS

REPAIRMAN

PROOF

CLEAN

TEST

TARGET

PATTERN

GALLERY TESTER

DATE

DATE

DATE

DATE

DATE

OFFICE COPY

RD6925 REV. 8/91

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

M2400150800

(PLEASE PRINT CLEARLY)

RETURN:

☐ Clark Street Entrance☒ Via US Mail or UPS

FIREARMS DELIVERED TO PLANT

FILE NO. 006768

DATE 1/27/92

OWNER'S NAME: CPT M.K. STEPHENSON REMINGTON EMPLOYEE:

OWNER'S ADDRESS: Co D 2nd BN 1st SWTG YES ☐ NO ☐

FT. BRAGG, NC EMPLOYEE # _____

DEPT. # _____

ZIP: 28307-5000

PHONE: (919) 396-7330

FIREARM MODEL: M24

CHECK FOR AMMUNITION ☒

GAUGE: 308

SERIAL # 06225476

CONDITION:

WOOD GOOD FAIR POOR FANCY PLAINMETAL GOOD FAIR POOR FANCY PLAINBARREL VT. RIB PLAIN DEER RSS

ACCESSORIES:

SCOPE: YES NO (BRAND NAME/POWER) _____SLING: YES NO GUN CASE: YES NO (HARD - SOFT)

EXTRA BBL FOR GUN MENTIONED ABOVE:

OTHER (Note in this area items missing or added from orig. equipment)

CUSTOMER REQUEST: REBARREL - Replace present barrel.

SIGNATURE: [Signature]
(Person delivering firearm to Plant)

DATE: 27 JAN 92

SIGNATURE: [Signature]
(Security Officer)

DATE: 1/27/92

SIGNATURE: [Signature]
(Firearm picked up by)

DATE: 1-28-92

Arm Service Copy

CENTROIDAL DISTANCES

Figure 1

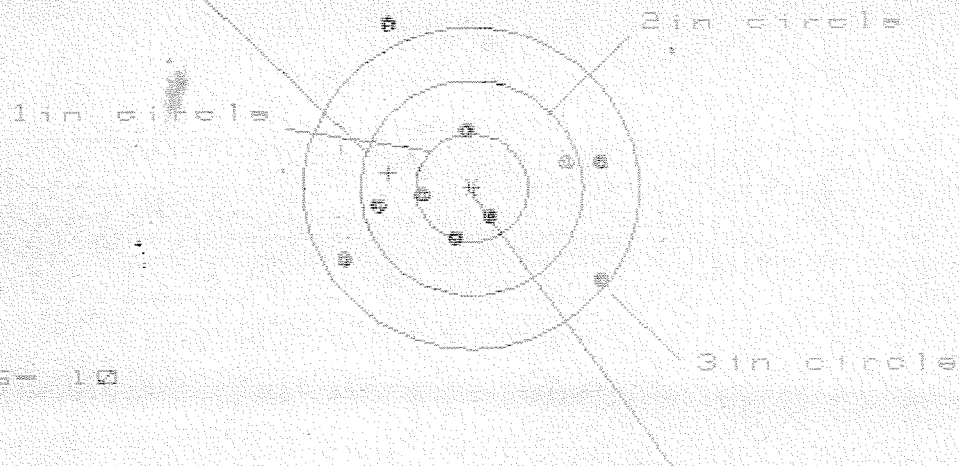
M2400150802

24 Feb 1992

FILE:/PATTERNING/CENTERFIRE_PATT/08225476

CENTERFIRE PATTERNS # 1

POA



OF SHOTS= 10

IN CIR

1in = 2

2in = 6

3in = 9

HS= 2.373

VS= 2.472

GS= 3.154

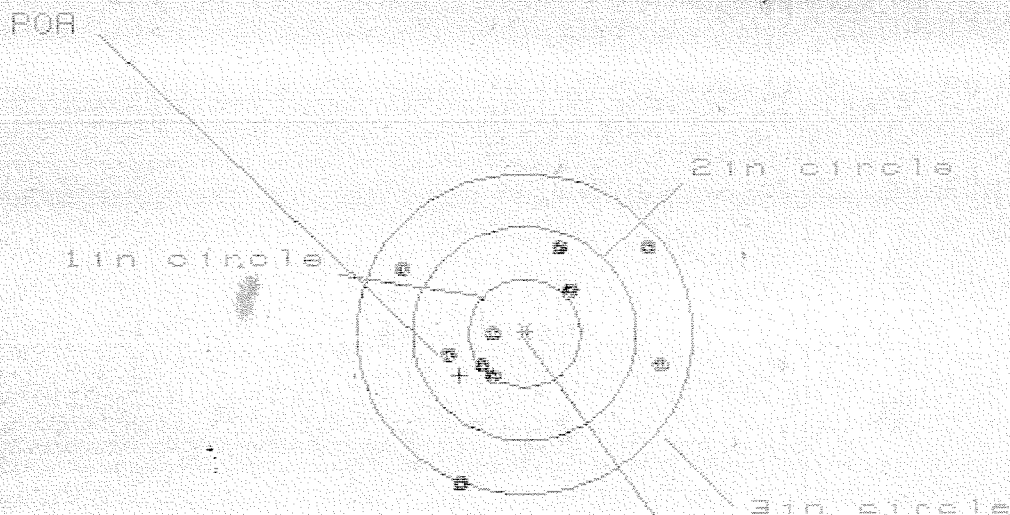
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.194	1.189	1.247
MINIMUM X	-1.179	-1.264	-1.126
MAXIMUM Y	1.573	.687	.597
MINIMUM Y	-.899	-.724	-.612
CENTROID X	.746	.831	.693
CENTROID Y	-.140	-.315	-.225
POA TO CENTROID in.	.759	.889	.728
MIN RADIUS	.289	.111	.275
MEAN RADIUS	.940	.830	.757
MAX RADIUS	1.750	1.368	1.281
HORIZONTAL SPREAD	2.373	2.373	2.373
VERTICAL SPREAD	2.472	1.411	1.289
EXTREME SPREAD	3.154	2.539	2.539
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	9		

24 Feb 1992

FILE:/PATTERNING/CENTERFIRE_PATT/08225426

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1in = 2

2in = 5

3in = 10

HS= 2.286

VS= 2.161

GS= 2.776

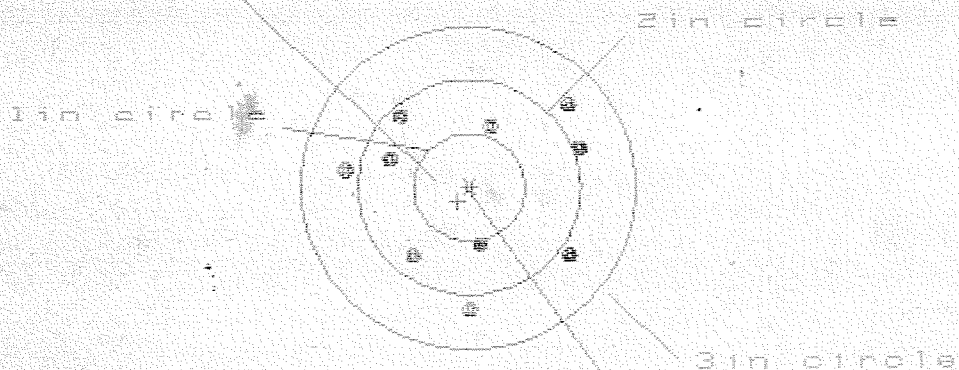
PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.233	1.168	1.304
MINIMUM X	:	-1.053	-1.118	-0.982
MAXIMUM Y	:	.794	.642	.694
MINIMUM Y	:	-1.367	-.586	-.506
CENTROID X	:	.587	.652	.516
CENTROID Y	:	.394	.546	.466
POA TO CENTROID in.	:	.707	.851	.696
MIN RADIUS	:	.282	.390	.233
MEAN RADIUS	:	.871	.809	.717
MAX RADIUS	:	1.489	1.263	1.343
HORIZONTAL SPREAD	:	2.286	2.286	2.286
VERTICAL SPREAD	:	2.161	1.228	1.200
EXTREME SPREAD	:	2.776	2.426	2.426
NUMBER IN ONE INCH CIRCLE =			2	
NUMBER IN TWO INCH CIRCLE =			6	
NUMBER IN THREE INCH CIRCLE =			10	

24 Feb 1992

FILE:/PATTERNING/CENTERFIRE_PATT/C8225476

CENTERFIRE PATTERNS # 3

POA



OF SHOTS- 10

IN CIR

1 in = 0

2 in = 5

3 in = 10

HS= 2.082

VS= 1.889

GS= 2.137

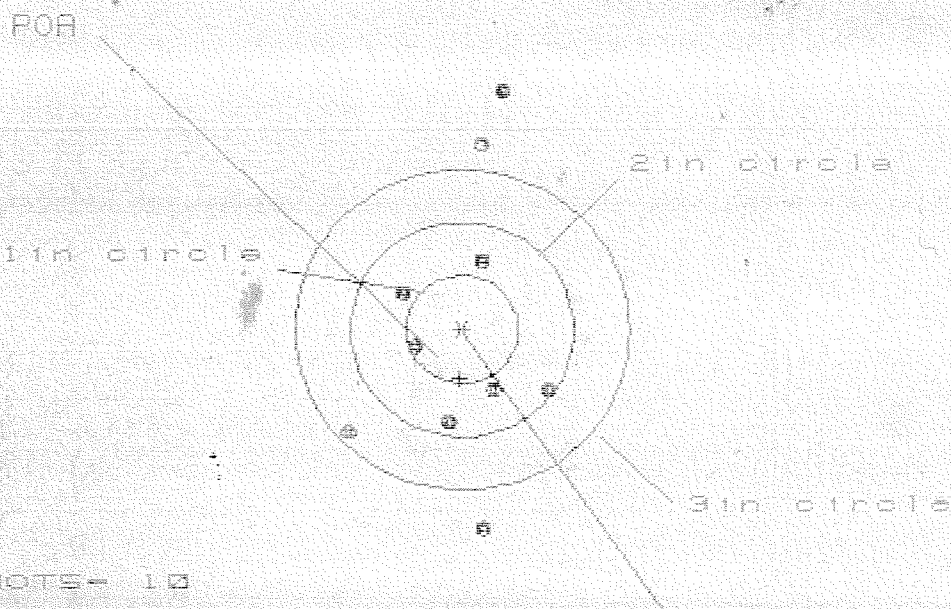
CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.952	1.047	.917
MINIMUM X	:	-1.129	-1.035	-.774
MAXIMUM Y	:	.800	.796	.826
MINIMUM Y	:	-1.089	-1.000	-.970
CENTROID X	:	.106	.012	.142
CENTROID Y	:	.131	.042	.012
POA TO CENTROID in.	:	.169	.043	.142
MIN RADIUS	:	.505	.453	.382
MEAN RADIUS	:	.916	.877	.846
MAX RADIUS	:	1.166	1.125	1.036
HORIZONTAL SPREAD	:	2.082	2.082	1.691
VERTICAL SPREAD	:	1.889	1.796	1.796
EXTREME SPREAD	:	2.137	2.137	1.983
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		10	

24 Feb 1992

FILE:/PATTERNING/CENTERFIRE_PATT/C6225476

CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1in = 1

2in = 6

3in = 7

HS= 1.781

VS= 4.184

GS= 4.189

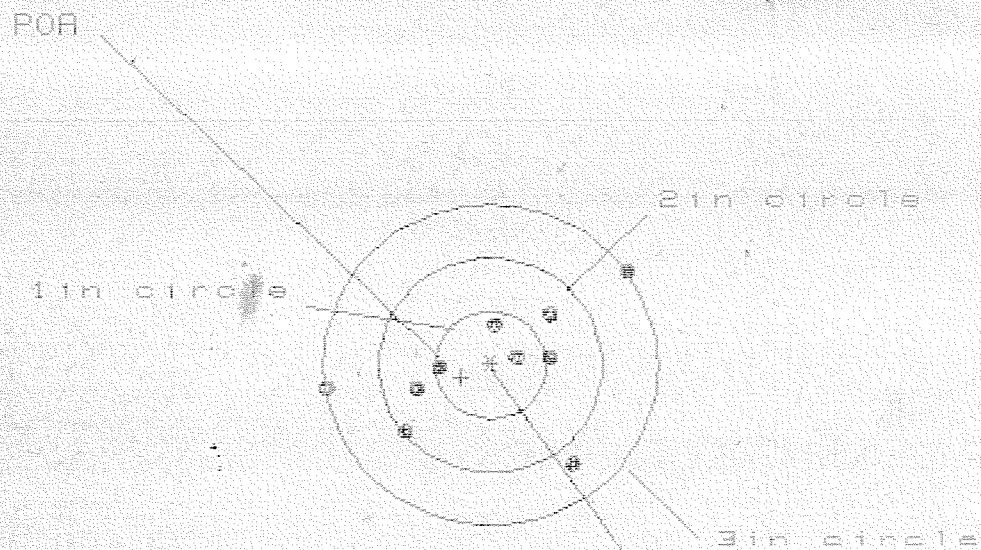
CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.797	.844	.877
MINIMUM X	:	-.984	-.937	-.904
MAXIMUM Y	:	2.283	2.022	1.816
MINIMUM Y	:	-1.901	-1.647	-.947
CENTROID X	:	.027	-.020	-.053
CENTROID Y	:	.459	.205	.411
POA TO CENTROID in.	:	.459	.205	.414
MIN RADIUS	:	.433	.366	.341
MEAN RADIUS	:	1.160	.988	.907
MAX RADIUS	:	2.321	2.037	1.837
HORIZONTAL SPREAD	:	1.781	1.781	1.781
VERTICAL SPREAD	:	4.184	3.669	2.763
EXTREME SPREAD	:	4.189	3.669	3.005
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		7	

24 Feb 1992

FILE:/PATTERNING/CENTERFIRE_PATT/06225476

CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1in = 3

2in = 7

3in = 9

HS= 2.700

VS= 1.821

GS= 2.932

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.257	.838	.675
MINIMUM X	:	-1.443	-1.303	-1.767
MAXIMUM Y	:	.929	.579	.565
MINIMUM Y	:	-.891	-.788	-.802
CENTROID X	:	.267	.127	.290
CENTROID Y	:	.119	.016	.030
POA TO CENTROID in.	:	.292	.128	.291
MIN RADIUS	:	.266	.364	.290
MEAN RADIUS	:	.820	.740	.654
MAX RADIUS	:	1.564	1.308	1.048
HORIZONTAL SPREAD	:	2.700	2.141	1.442
VERTICAL SPREAD	:	1.821	1.367	1.367
EXTREME SPREAD	:	2.932	2.246	1.674
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6225476
26 Feb 1992

CENTROIDAL DISTANCES

0 TO 1	.667659
1 TO 2	.666731
1 TO 3	.652798
1 TO 4	.795759
1 TO 5	.635813

σ_2 ← FOR
1

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .2044
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.125
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .239592
THE AMR FOR THIS RIFLE IS: 1.289

26 Feb 1992

FILE: PATTERNING/CENTERFIRE_PATT/C8225476.1

CENTERFIRE PATTERNS

1

POB

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 1

2 in = 3

3 in = 7

HS= 3.485

VS= 2.957

GS= 3.857

CENTROID *

PATTERN #

1

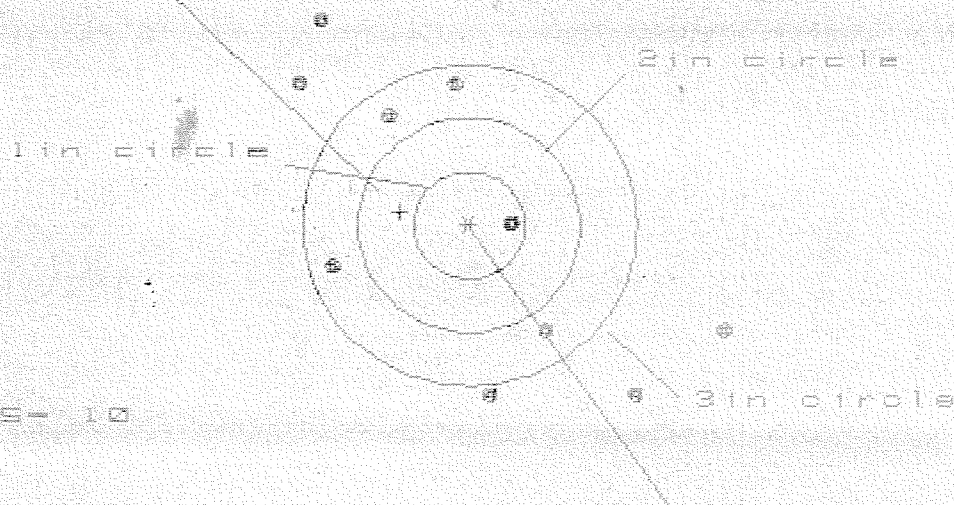
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.360	1.505	1.421
MINIMUM X	:	-1.125	-.863	-.947
MAXIMUM Y	:	1.252	1.183	.962
MINIMUM Y	:	-1.706	-1.774	-.815
CENTROID X	:	.200	-.062	.022
CENTROID Y	:	-.637	-.568	-.347
POB TO CENTROID in.	:	.667	.572	.347
MIN RADIUS	:	.322	.583	.559
MEAN RADIUS	:	1.316	1.172	1.062
MAX RADIUS	:	2.438	1.897	1.510
HORIZONTAL SPREAD	:	3.485	2.368	2.368
VERTICAL SPREAD	:	2.957	2.957	1.777
EXTREME SPREAD	:	3.857	3.186	2.696
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		7	

26 Feb 1992

FILE:/PATTERNING/CENTERFIRE_PATT/C8225476.J

CENTERFIRE PATTERNS # 2

POA



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 1

3 in = 5

HS= 3.839

VS= 3.508

GS= 4.686

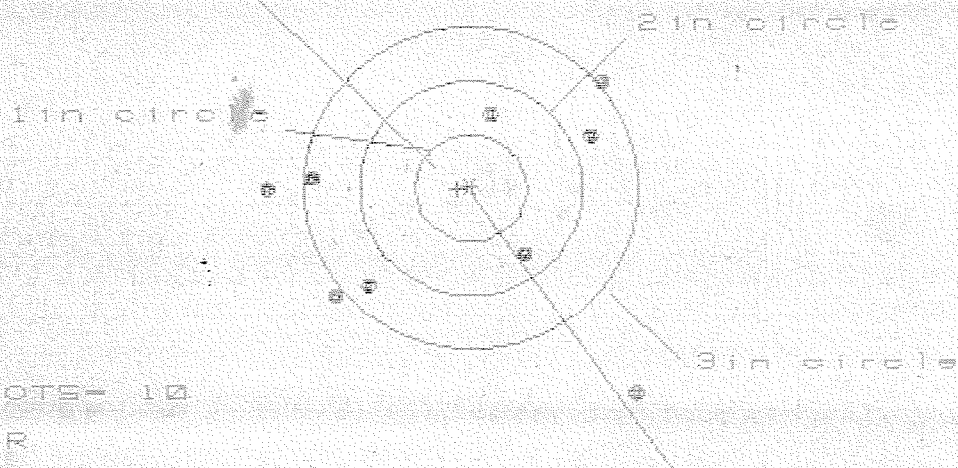
PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.300	1.699	1.561
MINIMUM X	:	-1.539	-1.284	-1.422
MAXIMUM Y	:	1.924	1.813	1.401
MINIMUM Y	:	-1.584	-1.695	-1.468
CENTROID X	:	.621	.366	.504
CENTROID Y	:	-.120	-.009	-.236
POA TO CENTROID in.	:	.633	.366	.557
MIN RADIUS	:	.335	.605	.460
MEAN RADIUS	:	1.586	1.472	1.375
MAX RADIUS	:	2.507	2.374	2.118
HORIZONTAL SPREAD	:	3.839	2.983	2.983
VERTICAL SPREAD	:	3.508	3.508	2.869
EXTREME SPREAD	:	4.686	4.464	4.113
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		1	
NUMBER IN THREE INCH CIRCLE	=		5	

26 Feb 1992

FILE:/PATTERNING/CENTERFIRE_PATT/C8225476.J

CENTERFIRE PATTERNS # 3

POA



OF SHOTS= 10

IN CIR

1in = 0

2in = 2

3in = 5

HS= 3.259

VS= 4.331

GS= 4.367

CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.468	1.568	1.492
MINIMUM X	:	-1.791	-1.691	-1.495
MAXIMUM Y	:	2.377	1.212	1.000
MINIMUM Y	:	-1.954	-1.690	-0.997
CENTROID X	:	.121	.021	-.175
CENTROID Y	:	.011	-.254	-.042
POA TO CENTROID in.	:	.122	.254	.180
MIN RADIUS	:	.718	.686	.876
MEAN RADIUS	:	1.532	1.403	1.270
MAX RADIUS	:	2.543	2.386	1.797
HORIZONTAL SPREAD	:	3.259	3.259	2.987
VERTICAL SPREAD	:	4.331	2.902	1.997
EXTREME SPREAD	:	4.367	3.882	3.132
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		2	
NUMBER IN THREE INCH CIRCLE	=		5	

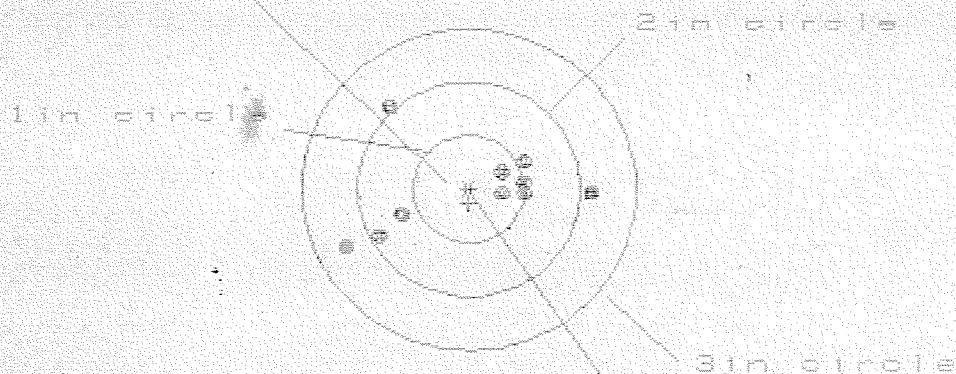
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CENTERFIRE PATTERNS

4

POB



OF SHOTS- 10

IN CIR

1in = 3

2in = 7

3in = 10

HS= 2.153

VS= 1.264

GS= 2.217

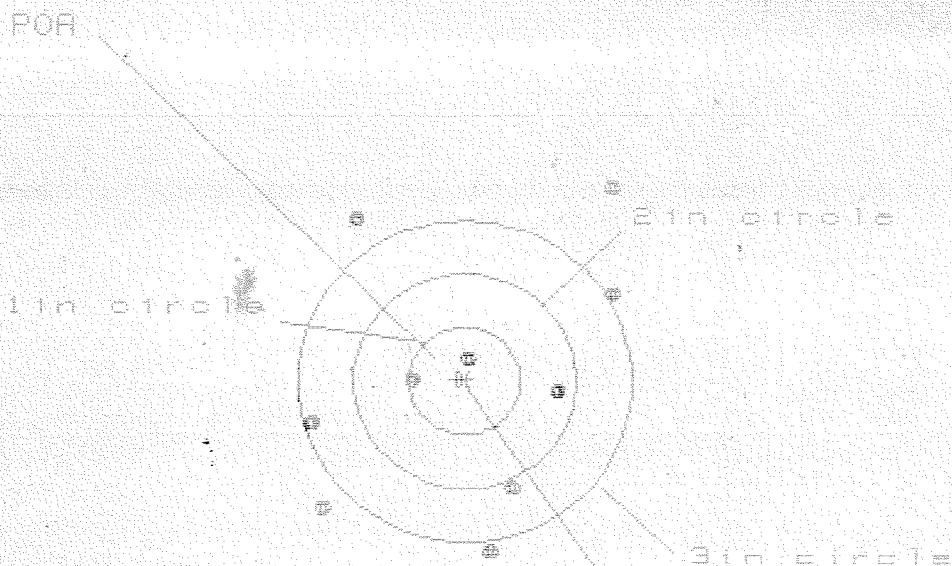
CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.070	.948	.529
MINIMUM X	:	-1.093	-.939	-.821
MAXIMUM Y	:	.763	.707	.698
MINIMUM Y	:	-.501	-.465	-.474
CENTROID X	:	.007	.128	.010
CENTROID Y	:	.135	.191	.200
POB TO CENTROID in.	:	.135	.230	.200
MIN RADIUS	:	.324	.206	.317
MEAN RADIUS	:	.713	.614	.604
MAX RADIUS	:	1.203	1.114	1.019
HORIZONTAL SPREAD	:	2.163	1.887	1.350
VERTICAL SPREAD	:	1.264	1.172	1.172
EXTREME SPREAD	:	2.217	1.969	1.521
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1in = 1

2in = 3

3in = 5

HS= 2.705

VS= 3.381

GS= 3.996

CENTROID #

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.344	1.491	1.387
MINIMUM X	-1.361	-1.214	-1.318
MAXIMUM Y	1.831	1.698	1.179
MINIMUM Y	-1.550	-1.347	-1.135
CENTROID X	.073	-.074	.030
CENTROID Y	-.014	-.217	-.429
POR TO CENTROID in.	.074	.229	.430
MIN RADIUS	.228	.402	.604
MEAN RADIUS	1.298	1.180	1.086
MAX RADIUS	2.256	1.888	1.821
HORIZONTAL SPREAD	2.705	2.705	2.705
VERTICAL SPREAD	3.381	3.045	2.314
EXTREME SPREAD	3.996	3.279	3.279
NUMBER IN ONE INCH CIRCLE	= 1		
NUMBER IN TWO INCH CIRCLE	= 3		
NUMBER IN THREE INCH CIRCLE	= 5		