

G-6285915
Replace
C-6348830

Remington®

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

M/24 7.62 NATO (RIFLE ONLY)
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO

SERIAL NO. **J**
G6285915

ORDER NO.
25732

46

Made in Ilion, NY Reg. U.S. Pat. & tm. Off. Marca Registrada Marque Deposee.



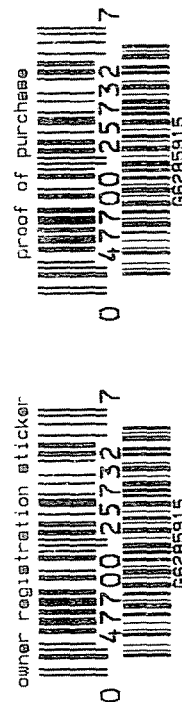
5732 G6285915

26PX

M/24 7.62 NATO (RIFLE ONLY)
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO

- INSTRUCTION BOOK 3518

46 FORM 200348

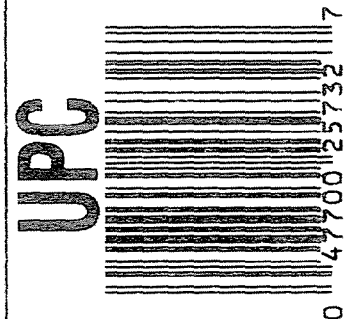


ORDER NO. 25732

BARREL LENGTH 24"

CAPACITY 5

G6285915



08/22/07 07:52:24

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: RE00133011

Serial: C6285915 Model M24 SWS Center Fire
Caliber: 7.62 NATO Produced: 08/12/1988

Repairman:

Verify Repair

High Priority

Status:

Closed 8/21/2007 11:40:01 AM

Address Information

Customer:	Received From	Return To:	Received From
Name: C TRP 2/101 CAV		C TRP 2/101 CAV	
Address 1: 27 MASTEN AVE		27 MASTEN AVE	
Address 2:	PO Box:		PO Box:
City: BUFFALO		BUFFALO	
State: NY Zip Code: 14204 Country: US		State: NY Zip Code: 14204 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
A057	Fit and Rear Sgt Base	1
D000	SCOPE CASE	1

Repair Search

Refresh

Close

naglej

8/22/2007

7:52 AM

C4PS

NUM

INS

SCRL

start

Inbox - Micr...

Calendar - M...

FW: Restrict...

Arms Service...

7:52 AM

Deployment Kit

Serial Number: G6285915

Model: M24 SWS



RE00133011

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

M2400156532

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6285915.___0
FILE DATE AND TIME: 09/07/2007 11:18

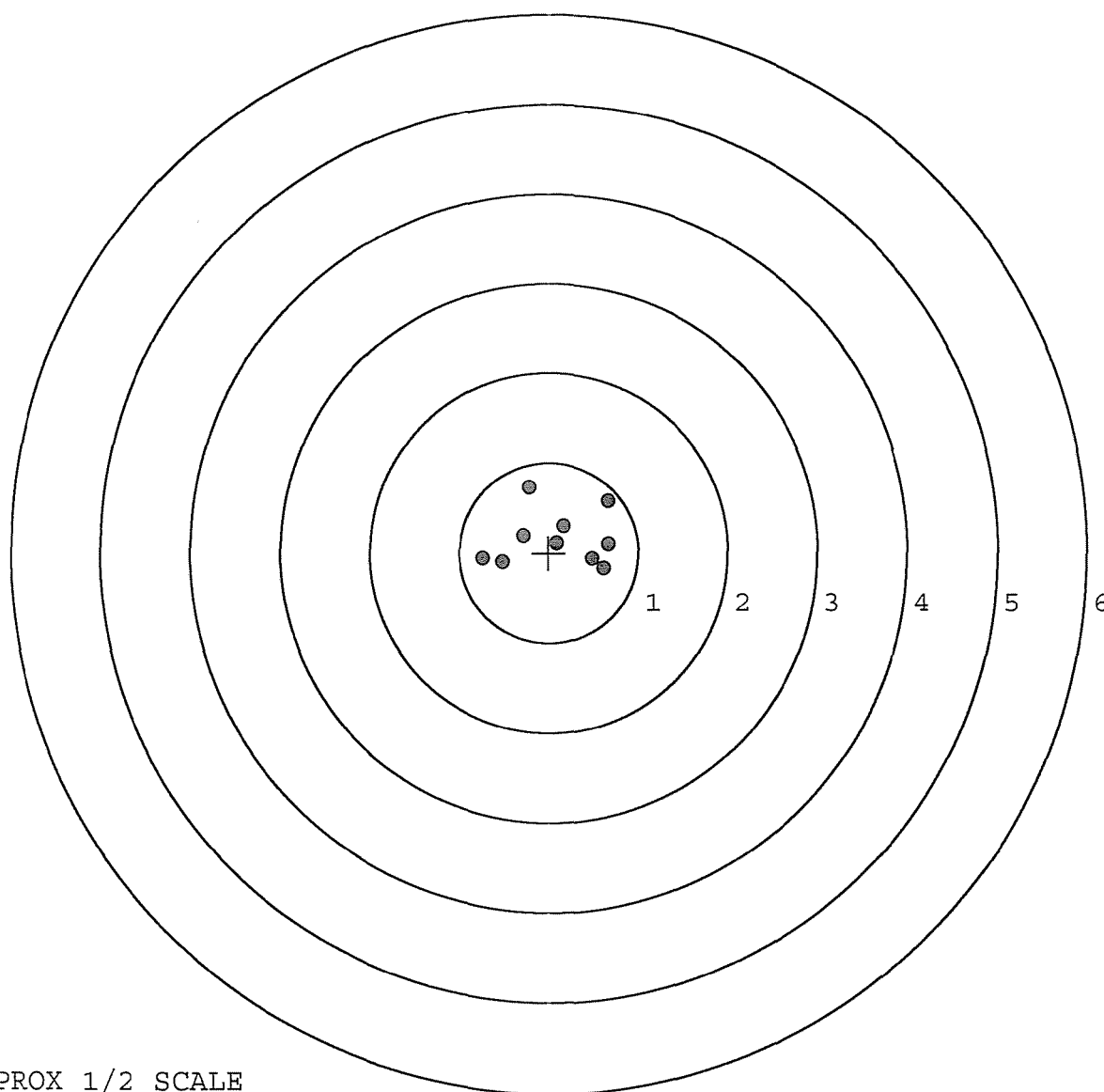
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.062
The Average Y Centroid of the Five Target Set:	-0.035
The Average Point of Impact of the Five Target Set:	0.071
The Average Mean Radius of the Five Target Set:	0.623
The Distance from POA to Centroid Target #1:	0.185
The Distance from Centroid Target #2 to Centroid Target #1:	0.263
The Distance from Centroid Target #3 to Centroid Target #1:	0.491
The Distance from Centroid Target #4 to Centroid Target #1:	0.068
The Distance from Centroid Target #5 to Centroid Target #1:	0.420

SERIAL NUMBER: G6285915. __0
TARGET NUMBER: 1
FILE DATE: 09/07/2007
FILE TIME: 11:18

X CENTROID: 0.091
Y CENTROID: 0.161
POA TO CENTROID: 0.185
HORZ SPREAD: 1.399
VERT SPREAD: 0.891
GROUP SPREAD: 1.539
MIN RADIUS: 0.054
MAX RADIUS: 0.857
MEAN RADIUS: 0.511
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 10
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.663	0.577
2:	-0.224	0.724
3:	-0.736	-0.064
4:	-0.517	-0.101
5:	-0.292	0.193
6:	0.087	0.107
7:	0.488	-0.062
8:	0.614	-0.167
9:	0.663	0.104
10:	0.166	0.297

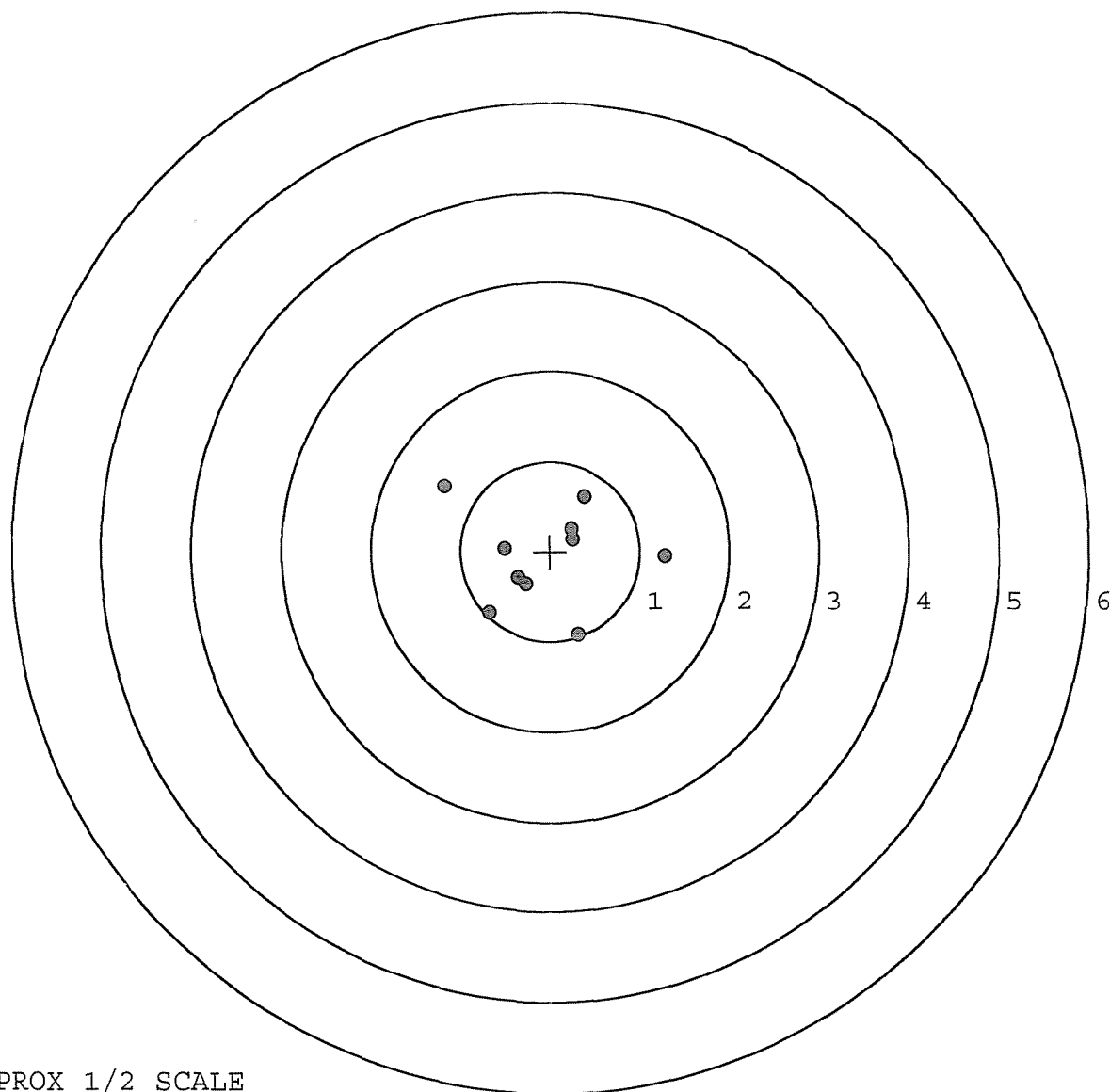


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6285915. __0
TARGET NUMBER: 2
FILE DATE: 09/07/2007
FILE TIME: 11:18

X CENTROID: -0.054
Y CENTROID: -0.059
POA TO CENTROID: 0.080
HORZ SPREAD: 2.462
VERT SPREAD: 1.656
GROUP SPREAD: 2.584
MIN RADIUS: 0.367
MAX RADIUS: 1.375
MEAN RADIUS: 0.736
IN 1 IN DIAMETER: 5
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.381	0.604
2:	-1.186	0.723
3:	-0.513	0.031
4:	0.246	0.250
5:	0.256	0.137
6:	-0.362	-0.289
7:	-0.276	-0.363
8:	-0.680	-0.687
9:	0.314	-0.933
10:	1.276	-0.060

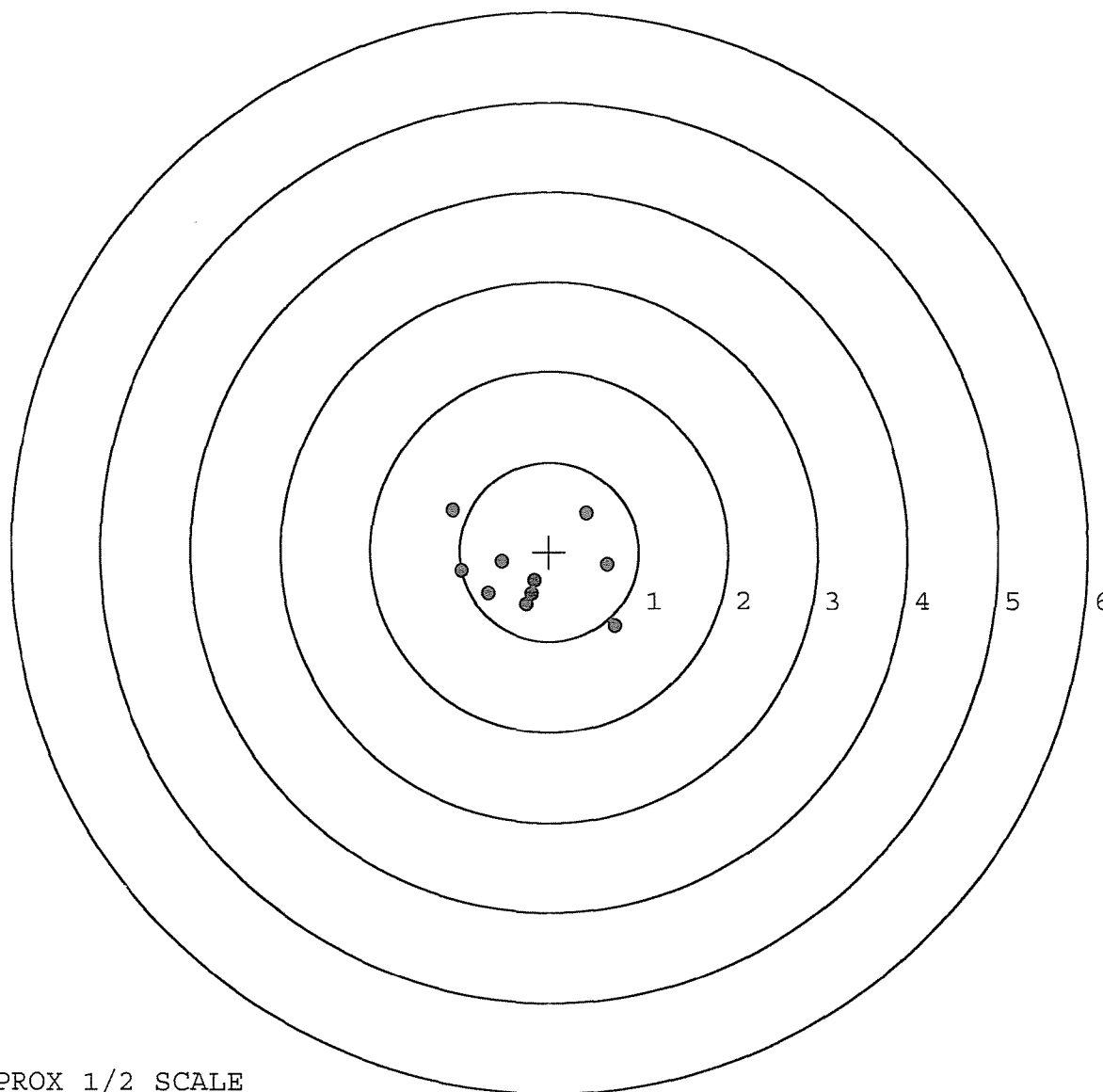


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6285915.___0
TARGET NUMBER: 3
FILE DATE: 09/07/2007
FILE TIME: 11:18

X CENTROID: -0.211
Y CENTROID: -0.226
POA TO CENTROID: 0.309
HORZ SPREAD: 1.820
VERT SPREAD: 1.293
GROUP SPREAD: 2.233
MIN RADIUS: 0.103
MAX RADIUS: 1.123
MEAN RADIUS: 0.637
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-1.082	0.466
2:	-0.982	-0.215
3:	-0.528	-0.117
4:	-0.685	-0.473
5:	-0.265	-0.591
6:	-0.202	-0.471
7:	-0.173	-0.322
8:	0.738	-0.827
9:	0.651	-0.143
10:	0.416	0.431

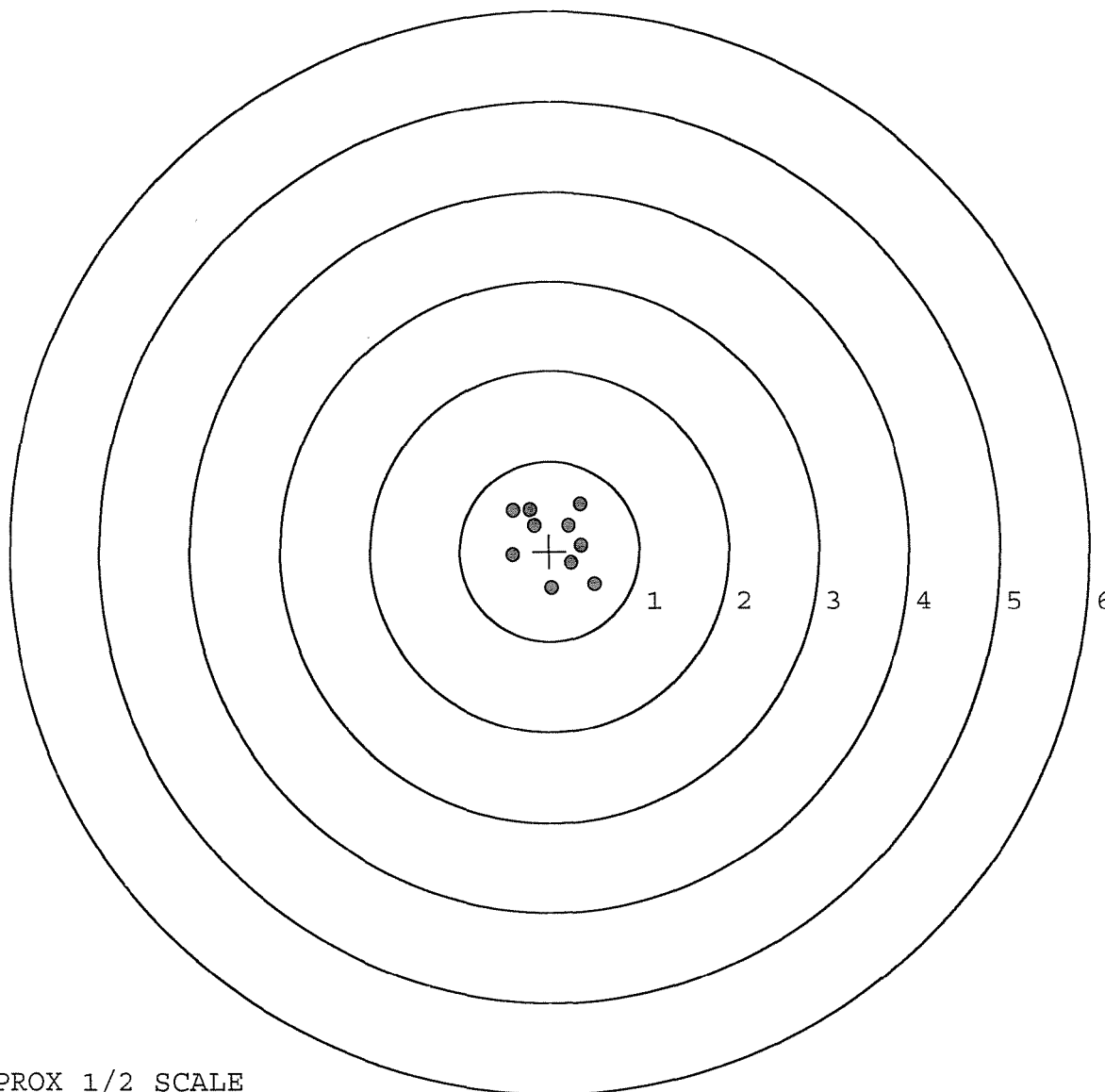


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6285915. __0
 TARGET NUMBER: 4
 FILE DATE: 09/07/2007
 FILE TIME: 11:18

X CENTROID: 0.045
 Y CENTROID: 0.111
 POA TO CENTROID: 0.120
 HORZ SPREAD: 0.917
 VERT SPREAD: 0.934
 GROUP SPREAD: 1.226
 MIN RADIUS: 0.238
 MAX RADIUS: 0.664
 MEAN RADIUS: 0.432
 # IN 1 IN DIAMETER: 6
 # IN 2 IN DIAMETER: 10
 # in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.344	0.521
2:	0.213	0.280
3:	-0.222	0.458
4:	-0.410	0.449
5:	-0.179	0.286
6:	-0.411	-0.040
7:	0.241	-0.133
8:	0.020	-0.413
9:	0.506	-0.366
10:	0.348	0.071

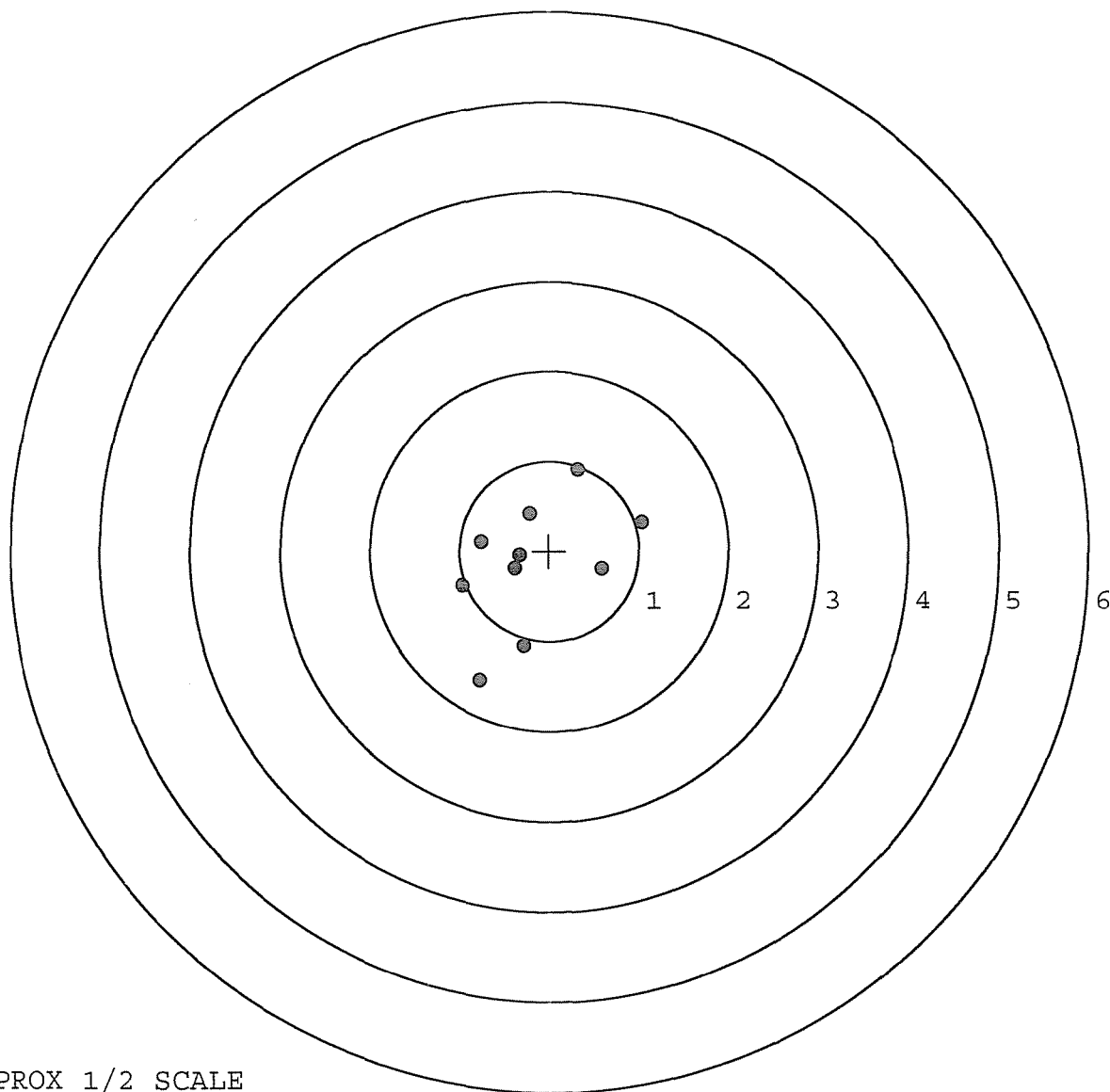


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6285915. __0
TARGET NUMBER: 5
FILE DATE: 09/07/2007
FILE TIME: 11:18

X CENTROID: -0.179
Y CENTROID: -0.161
POA TO CENTROID: 0.241
HORZ SPREAD: 2.002
VERT SPREAD: 2.347
GROUP SPREAD: 2.592
MIN RADIUS: 0.186
MAX RADIUS: 1.412
MEAN RADIUS: 0.800
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.322	0.907
2:	-0.223	0.409
3:	-0.331	-0.053
4:	-0.764	0.101
5:	-0.969	-0.392
6:	-0.382	-0.199
7:	-0.778	-1.440
8:	-0.293	-1.059
9:	0.592	-0.199
10:	1.033	0.315



TARGET APPROX 1/2 SCALE

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

R & E NUMBER		133011		
SERIAL NUMBER		G6285915 G6285915 ^{TRW}		
LOG-IN DATE		7-21-07		

OPERATION #	OPERATION NAME	DATE	INITIAL
500	DIS-ASSEMBLE GUN	7-22-07	RTZ
505	RE-BARREL	8-23-07	RTZ
560	ASSEMBLE	8-23-07	RTZ
600	PROOF	8/23/07	man
605	CHECK HEADSPACE	8/23/07	man
610	DIS-ASSEMBLE GUN	8-25-07	RTZ
612	MAGNAFLUX	8-30-07	J.B.
510	DRILL AND TAP	8-27-07	TRW
615	ROLLMARK CALIBER	8-28-07	CW
618	ROTO-BLAST	8-30-07	LY
620	APPLY COATINGS	8/31/07	RB
625	FINAL ASSEMBLY		
640	FUNCTION TEST AND	(PASS) FAIL	9-7-07 TRW
650	TARGET	(PASS) FAIL	9-7-07 TRW
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
670	FINAL INSPECTION		9-7-07 DK
	A) HEADSPACE	(PASS) FAIL	9-11-07 RTZ
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	2.87 2.80 2.79 2.78 2.81 9-10-07 DA
680	F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX	8.0 8.0 8.0 9-10-07 Fm
	G) SAFETY OFF FORCE	2 LBS MIN	3.0 3.0 3.0 9-10-07 Fm
	I) FIRING PIN INDENT	.020	.023 .023 .022 9-10-07 Fm
690	PACK		9-11-07 DA

Repair Inquiry

Repair Number: RE00072945

Serial: C6348830 Model 700 Center Fire Caliber: 7
62 NATO M24 SWS

Repairman:

Verify Repair

Status:

Closed 11/13/2003 6:46:37 AM

Address Information

Customer:

☒ Received From

Return To:

☐ Received From

Name: HHC 105TH INF

HHC 105TH INF

Address 1: 27TH BDE WTU2TO

27TH BDE WTU2TO

Address 2: WASHINGTON AVE

PO Box:

WASHINGTON AVE

PO Box:

City: SCHENECTADY

SCHENECTADY

State: NY

Zip Code: 12345

Country: US

State: NY

Zip Code: 12345

Country: US

FFL:

Contact / Condition

Problems

Estimate

History / Status

Shipping / Billing

Contact Information

Phone: 518 220 4120

Fax:

Email:

Comments: DOOR GUN#005037

Received Condition

Good

Condition:

NO CAMO

Notes:

CSR:

Notes:

Accessories Received

Code	Desc	Qty
A006	Sling Strap	1
A007	With Studs	3
A008	With Swivels	2
A017	Scope Base	1
A026	Scope	1
A042	Adjustable Butt Pad	1

Repair Search

Refresh

Close

naglej

11/13/2003

7:02 AM

CAPS

NUM

INS

SCRL

start

4 Micro

2 Micro

3 Inter

Arms Ser...

Pat. Ser...

Label

7:02 AM

Serial Number:

C6348830

Model: 700



RE00072945

Receipt Of Firearm(s) Delivered to the Plant for Repair
Firearm Checked For Live Ammunition ☒

File 005037

Delivery Date 11 / 12 / 03

Customer Name (Print) HHC 1/10.5 Inf 27th BDE WTU2TO

Address Washington Ave Schenectady State N.Y. Zip _____

Phone Number (518) - 220-4120

Fireman Description Model M-24 SWS Cal./Ga. .308

Serial Number C6348830 / 890133

Stock/ Fore-end Condition circle the description

(Excellent, Good, Fair, Poor, Fancy, Plain, Synthetic, Wood)

Comments on Stock/ Fore-end condition _____

Metal Condition circle the description

(Excellent, Good, Fair, Poor, Fancy, Plain Stainless Steel)

Comments on Metal condition _____

Barrel Type (VT. Rib; Plain; Deer; Stainless Steel) Barrel length _____

List additional accessories IE Scope, Sling, Gun case and description:

W/ M3A scope # 890133 w/ sling

Customer request: Re-barrel

Return Process Return to Clark St. Ent. ☐ Return via UPS ☐

customer will pick-up SFC Rich Gauthier CSMS-A CAMP 914-788-7368

By signing this receipt the person delivering the firearm understands to be the only person to receive the firearm upon completion of repairs.

Signature John F. Nether Date 11 / 12 / 03
person delivering firearm

Signature Catherine Attali Date 11 / 12 / 03
security officer

Signature Calvin Schmitt Date 11 / 12 / 03
arms service / CSR

Customer Pick Up Verification

I certify, I am the person whom delivered the above described firearm to the
Remington Ilion plant for repair and may lawfully possess a firearm in New York State.

Signature _____ Date ____ / ____ / ____
person receiving firearm must be the same who delivered

Signature _____ Date ____ / ____ / ____
security officer or other witness returning the firearm

Receipt Of Firearm. Doc
Rev. 6/4/03

ARM SERVICE COPY

Remington.

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

M2400156541

DATE: 20031107

MAINTENANCE REQUEST

DA FORM 5998-E

----- CUSTOMER DATA -----
UIC: WTUZT8 - HHC 1/105TH INF
UTIL CODE: 7

PHONE: (518)220-4129

----- ACTIVITY DATA -----
SUP WON: CSMS A
SUP UIC: QCC99A

PHONE: 734-7298
SHOP SEC: *W*

----- EQUIPMENT DATA -----

TYPE MNT REQ: 1 ID: A NSN: 1005012402136 MODEL: M24 SWS

NOUN: RIFLE 7.62MM SNIP SER NUM: C6348830-890133 QTY: 00001

ORG WON: TUZT01320367 PRIORITY: 03 FAILURE DETECTED: H

MI/KM: ----- HOURS: ----- ROUNDS: -----

IN WARRANTY: ----- LEVEL OF WORK: F ADMIN NUM: -----

DEFICIENCY: RE-BARREL WEAPON

PD AUTHENTICATING SIGNATURE: *[Signature]*

----- SIGNATURE DATA -----

SUBMITTED BY: *[Signature]* ORD DATE: 3311 MIL TIME: -----

ACCEPTED BY: ----- STATUS: ----- ORD DATE: ----- MIL TIME: -----

----- ACTION DATA -----

WORK STARTED BY: ----- STATUS: ----- ORD DATE: ----- MIL TIME: -----

INSPECTED BY: ----- STATUS: ----- ORD DATE: ----- MIL TIME: -----

PICKED UP BY: ----- STATUS: ----- ORD DATE: ----- MIL TIME: -----

----- COMPLETION DATA -----

QTY RPR: ----- QTY CONDEMNED: ----- NRTS: -----

EVAC WON: ----- EVAC UNIT NAME: -----

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

R & E NUMBER	72945		
SERIAL NUMBER	C634-8830		G628 5915 NEW
LOG-IN DATE	12-18-03		
INSPECT AND VERIFY:			
OPERATION #	OPERATION NAME	DATE	INITIAL
550	DIS-ASSEMBLE GUN	12-18-03	RTL
560 A	RE-BARREL		
B	DRILL AND TAP		
575	ASSEMBLE		
600	PROOF		
605	CHECK HEADSPACE		
610	DIS-ASSEMBLE GUN		
612	MAGNAFLUX		
615	ROLLMARK CALIBER		
618	ROTO-BLAST		
620	APPLY COATINGS		
625 A	FINAL ASSEMBLY		
B	TRIGGER PULL TEST		
C	SAFETY "ON" FORCE		
D	SAFETY "OFF" FORCE		
E	FIRING PIN INDENT		
640	TARGET	12-19-03	AC
655	FINAL INSPECT	12-22-03	RTL
660	PACK	12/22/03	DA
		SHIP DATE	
QAR INSPECTION DATE			

M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # 66285915

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		11-14-02	RL
600	PROOF		11-18-02	A
607	CHECK HEADSPACE	MAGNA-FLUX	11-18-02	A
610	DIS-ASSEMBLE GUN	INSPECTED	11-19-02	RL
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	OPERATOR <u>RL</u>		
615	ROLLMARK CALIBER		11-22-02	SB
617	DRILL AND TAP SIGHT HOLES		11-22-02	TRW
620	APPLY COATINGS (BARREL ACTION)		12-5	TA
	(BOLT)		12-5	TA
625	FINAL ASSEMBLY		5-14-02	RL
	A) CLEAN INSIDE OF BOLT ASSEMBLY			
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		5-14-02	RL
	C) INSPECT EJECTOR HOLE FOR CHAMFER		5-14-02	RL
	D) OIL FIRING PIN ASSEMBLY		5-14-02	RL
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS		6-20-03	TRW

OP #	OPERATION NAME	READINGS	DATE	INITIAL
625	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>6.75</u> <u>6.75</u> <u>6.75</u>	6-20-03	TRW
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>2.25</u> <u>2.5</u> <u>2.0</u>	6-20-03	TRW
	H) TRIGGER PULL TEST AND RETAINABILITY		6-30-03	RTL
	I) FIRING PIN INDENT .020 MIN	<u>.0235</u> <u>.0235</u> <u>.023</u>	6-20-03	TRW
	J) ASSEMBLE STOCK		5-16-03	RW
	K) ASSEMBLE SWIVEL STUDS		6-30-03	RTL
	L) ATTACH FRONT AND REAR SIGHT ASSYS		6-30-03	RTL
	M) IRON SIGHT ALIGNMENT		6-30-03	RTL
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		6-30-03	RTL
640	GALLERY TEST AND TARGET	PASS FAIL	5-18-03	TRW
	MALFUNCTION	CORRECTION	5-19-03	TRW
	MALFUNCTION	CORRECTION	5-19-03	TRW
	MALFUNCTION	CORRECTION	5-19-03	TRW
	MALFUNCTION	CORRECTION	5-19-03	TRW
645	INSPECT FOR LIVE AMMO		5-19-03	TRW
655	FINAL INSPECTION A) HEADSPACE		6-30-03	RTL
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.89</u> <u>2.79</u> <u>2.71</u> <u>2.79</u> <u>2.80</u>	6-20-03	TRW
	C) FUNCTION		6-30-03	RTL
660	PACK		6-30-03	DA

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

DATE 12-9-02

TESTER TRW

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.62	2.68		2.62	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT ABLE LESS THAN
PULL #2	2.51	2.64		2.65	
PULL #3	2.34	2.62		2.58	
PULL #4	2.29	2.60		2.31	
PULL #5	2.35	2.59		2.54	
TOTAL	12.11	13.13		12.70	
AVG.	2.42	2.62		2.54	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.35	3.32		
PULL #2	3.30	3.33		
PULL #3	3.17	3.39		
PULL #4	3.15	3.37		
PULL #5	3.17	3.28		
TOTAL	16.14	16.69		
AVG.	3.22	3.33		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# TARGET & ACCU
PULL #1	4.15	4.37		4.44
PULL #2	4.01	4.32		4.24
PULL #3	4.05	4.25		4.22
PULL #4	4.03	4.14		4.07
PULL #5	3.99	4.17		4.26
TOTAL	20.23	21.25		21.23
AVG.	4.04	4.25		4.24

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6285915.___0
FILE DATE AND TIME: 05/19/2003 06:10

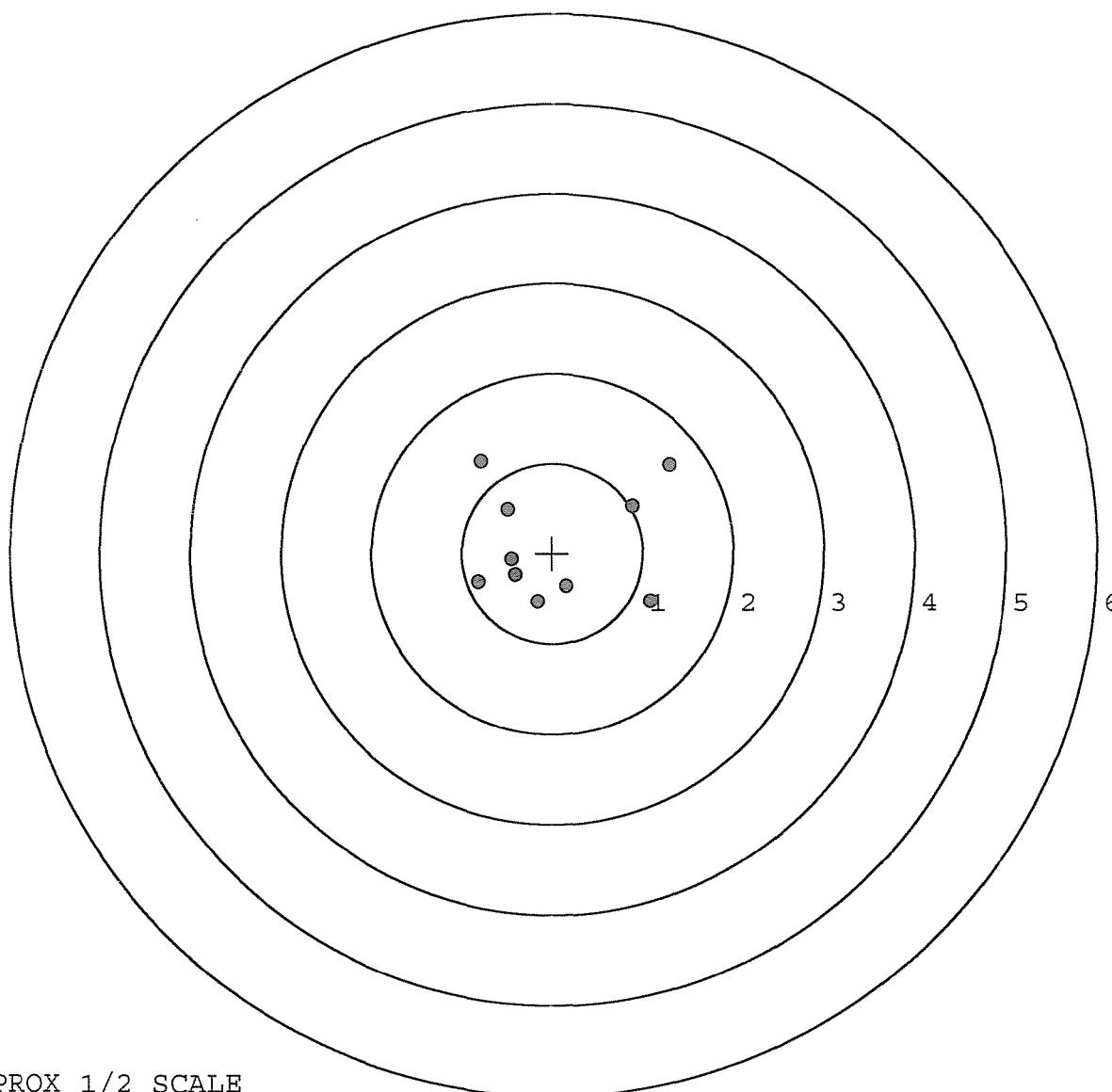
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.081
The Average Y Centroid of the Five Target Set:	0.113
The Average Point of Impact of the Five Target Set:	0.139
The Average Mean Radius of the Five Target Set:	0.933
The Distance from POA to Centroid Target #1:	0.097
The Distance from Centroid Target #2 to Centroid Target #1:	0.194
The Distance from Centroid Target #3 to Centroid Target #1:	0.142
The Distance from Centroid Target #4 to Centroid Target #1:	0.074
The Distance from Centroid Target #5 to Centroid Target #1:	0.120

SERIAL NUMBER: G6285915. __0
TARGET NUMBER: 1
FILE DATE: 05/19/2003
FILE TIME: 06:10

X CENTROID: 0.029
Y CENTROID: 0.092
POA TO CENTROID: 0.097
HORZ SPREAD: 2.103
VERT SPREAD: 1.568
GROUP SPREAD: 2.474
MIN RADIUS: 0.478
MAX RADIUS: 1.540
MEAN RADIUS: 0.877
IN 1 IN DIAMETER: 1
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 9

POINT#	X	Y
1:	1.084	-0.538
2:	0.884	0.525
3:	1.288	0.980
4:	-0.791	1.024
5:	-0.495	0.485
6:	-0.450	-0.072
7:	-0.815	-0.324
8:	-0.163	-0.544
9:	0.157	-0.368
10:	-0.407	-0.245

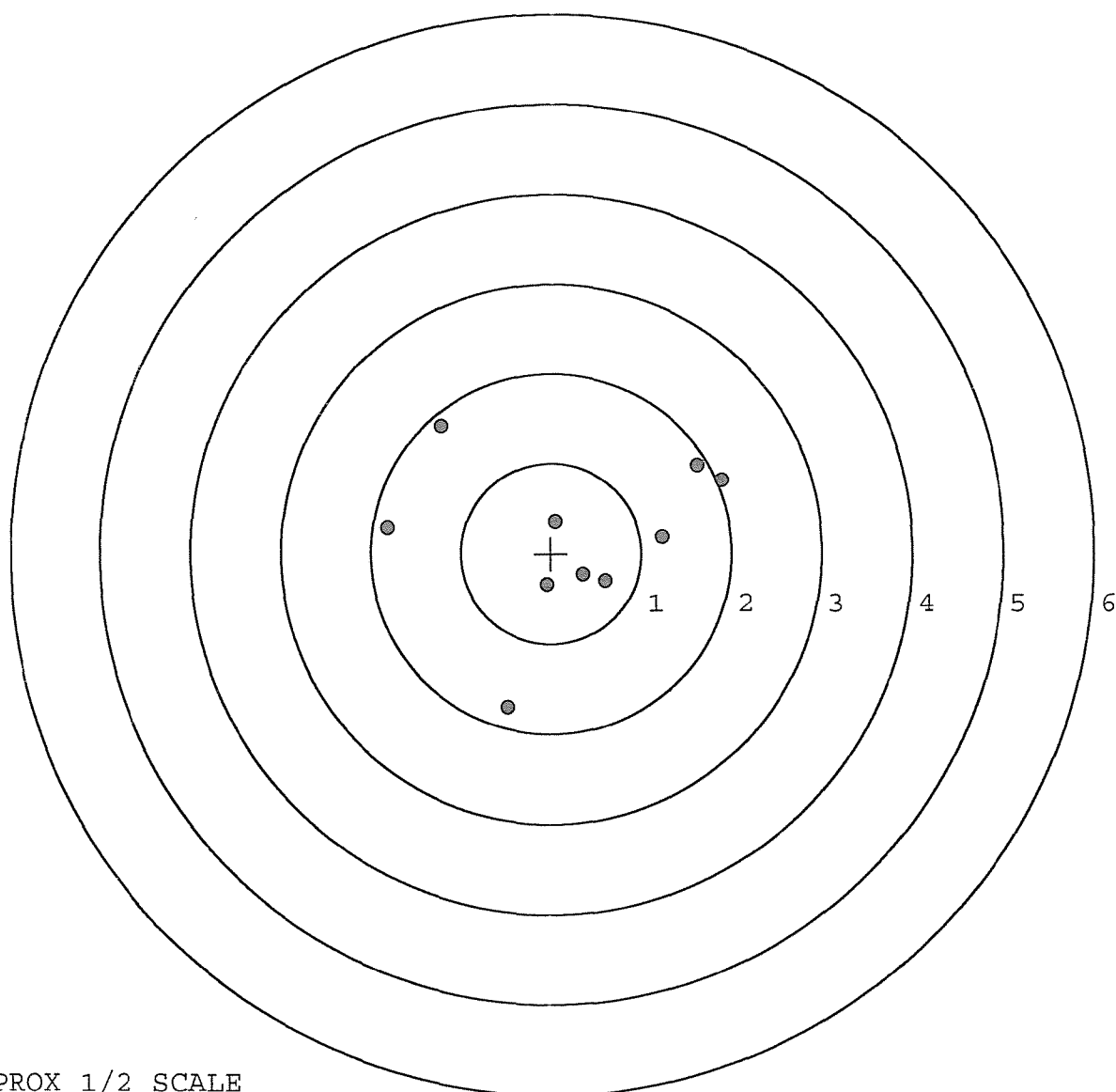


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6285915. __0
TARGET NUMBER: 2
FILE DATE: 05/19/2003
FILE TIME: 06:10

X CENTROID: 0.217
Y CENTROID: 0.140
POA TO CENTROID: 0.259
HORZ SPREAD: 3.706
VERT SPREAD: 3.128
GROUP SPREAD: 3.744
MIN RADIUS: 0.275
MAX RADIUS: 2.036
MEAN RADIUS: 1.222
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 4
in 3 IN DIAMETER: 5

POINT#	X	Y
1:	-0.474	-1.717
2:	0.606	-0.302
3:	0.359	-0.238
4:	-0.052	-0.353
5:	0.041	0.351
6:	1.228	0.180
7:	1.892	0.813
8:	1.616	0.976
9:	-1.228	1.411
10:	-1.814	0.278

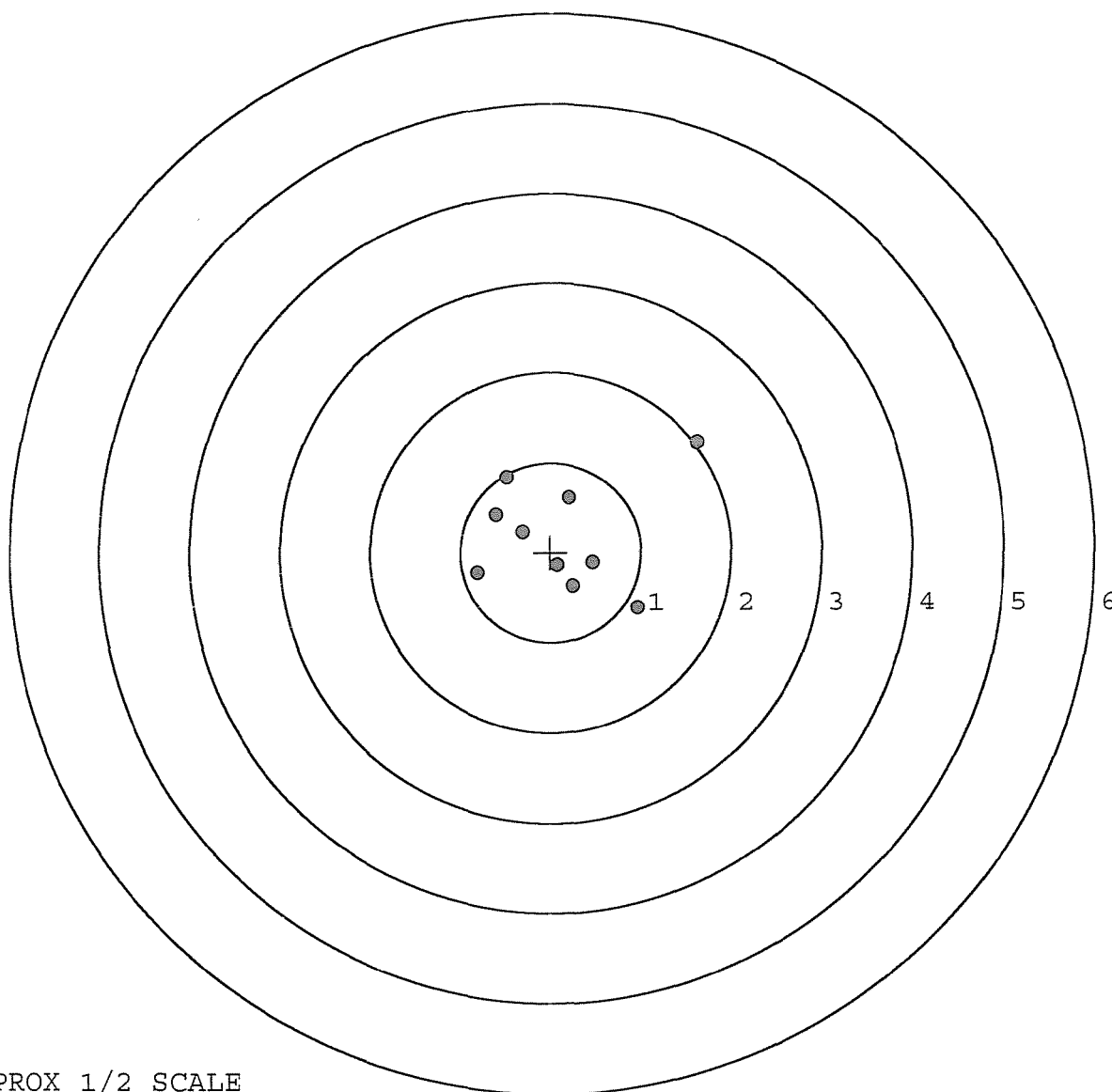


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6285915. __0
TARGET NUMBER: 3
FILE DATE: 05/19/2003
FILE TIME: 06:10

X CENTROID: 0.136
Y CENTROID: 0.186
POA TO CENTROID: 0.231
HORZ SPREAD: 2.428
VERT SPREAD: 1.850
GROUP SPREAD: 2.834
MIN RADIUS: 0.332
MAX RADIUS: 1.813
MEAN RADIUS: 0.792
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 9

POINT#	X	Y
1:	0.964	-0.617
2:	1.616	1.233
3:	0.206	0.613
4:	-0.320	0.225
5:	-0.608	0.420
6:	-0.487	0.837
7:	-0.812	-0.228
8:	0.253	-0.369
9:	0.468	-0.110
10:	0.077	-0.140

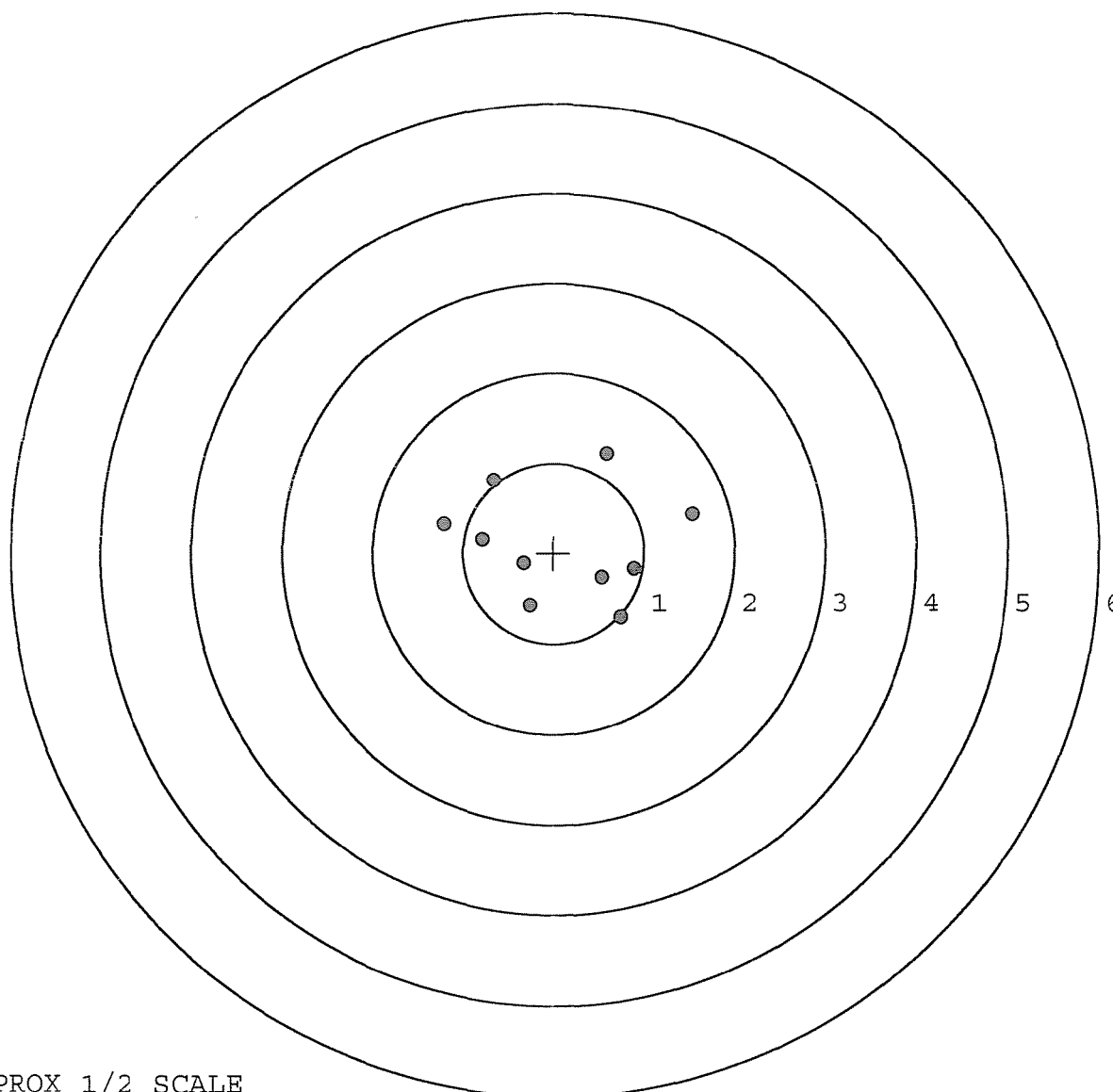


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6285915. __0
TARGET NUMBER: 4
FILE DATE: 05/19/2003
FILE TIME: 06:10

X CENTROID: 0.103
Y CENTROID: 0.097
POA TO CENTROID: 0.141
HORZ SPREAD: 2.745
VERT SPREAD: 1.814
GROUP SPREAD: 2.748
MIN RADIUS: 0.480
MAX RADIUS: 1.466
MEAN RADIUS: 0.955
IN 1 IN DIAMETER: 1
IN 2 IN DIAMETER: 5
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	1.528	0.439
2:	0.590	1.107
3:	0.893	-0.176
4:	0.536	-0.272
5:	0.741	-0.707
6:	-0.263	-0.584
7:	-0.327	-0.117
8:	-0.792	0.152
9:	-1.217	0.319
10:	-0.661	0.807

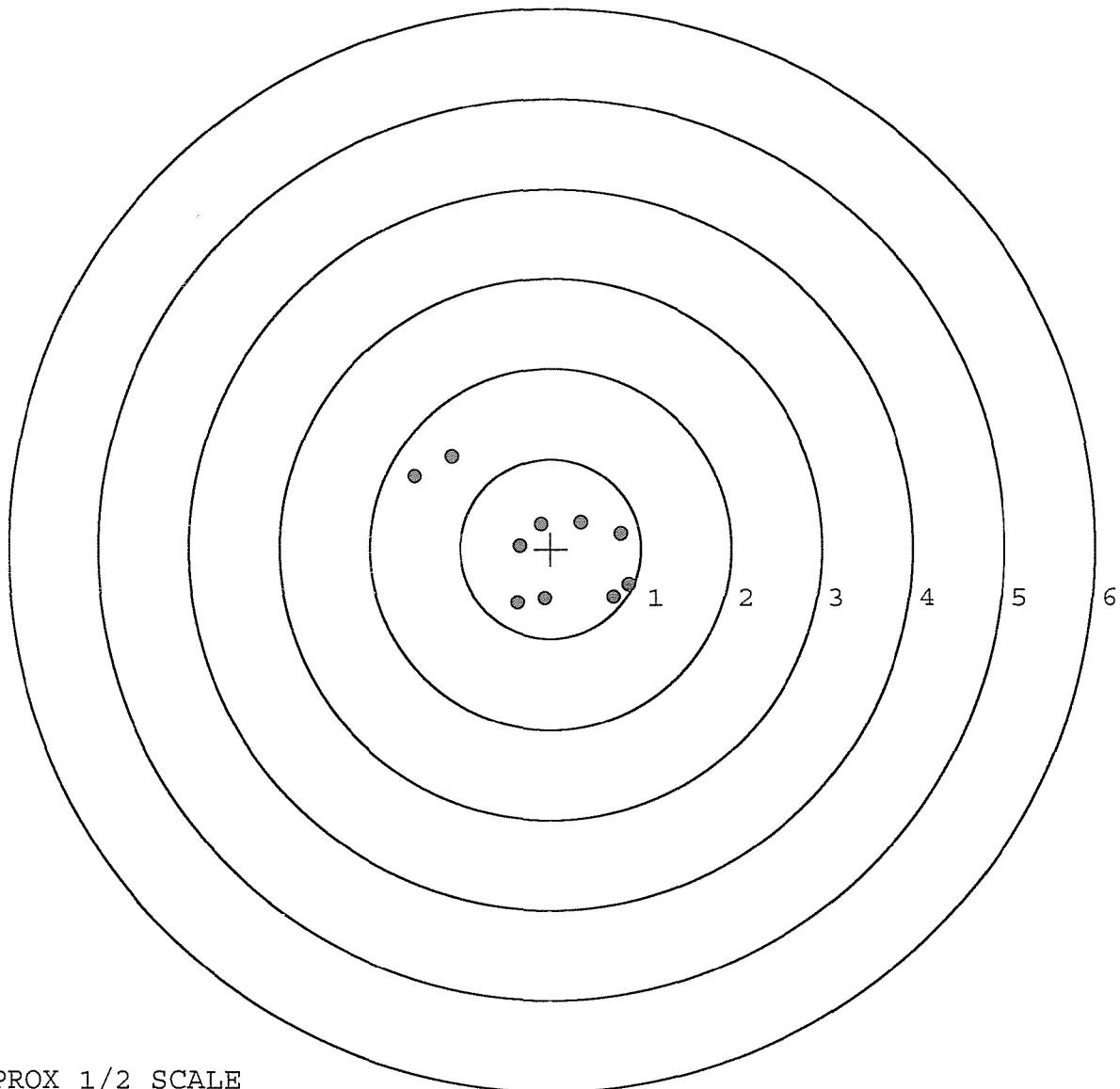


TARGET APPROX 1/2 SCALE

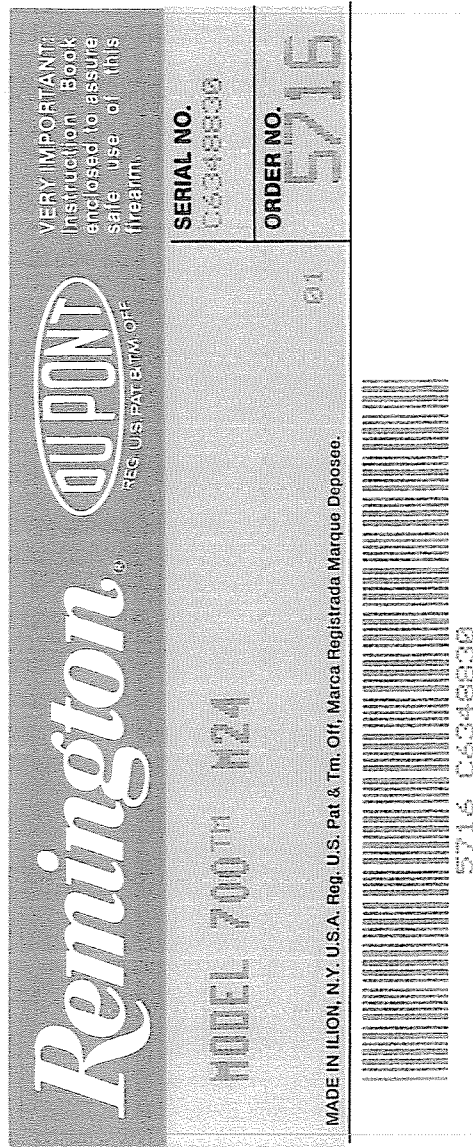
SERIAL NUMBER: G6285915. __0
TARGET NUMBER: 5
FILE DATE: 05/19/2003
FILE TIME: 06:10

X CENTROID: -0.082
Y CENTROID: 0.049
POA TO CENTROID: 0.096
HORZ SPREAD: 2.377
VERT SPREAD: 1.629
GROUP SPREAD: 2.666
MIN RADIUS: 0.231
MAX RADIUS: 1.617
MEAN RADIUS: 0.822
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 9

POINT#	X	Y
1:	0.704	-0.546
2:	0.864	-0.404
3:	0.774	0.172
4:	0.334	0.298
5:	-0.113	0.278
6:	-0.064	-0.554
7:	-1.100	1.021
8:	-0.346	0.029
9:	-0.364	-0.608
10:	-1.513	0.803



TARGET APPROX 1/2 SCALE



INTERCHANGEABILITY

M-24

CONTRACT # DAAA21-87-C-0086

Score 0133

GUN SERIAL # C6348830

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	9 14	89	RW
600	Proof	9 14	89	RW
607	Check Headspace	9 14	89	RW
610	Dis-assemble Gun	9 14	89	RW
612	Magnaflux Barrel Action	9-14-	89	KCR
	Magnaflux Bolt	9-14-	89	KCR
615	Rollmark Caliber		9/15/89	GS
7	Drill and Tap Sight Holes	9 15	89	LB
618	Polish Barrel	9 15	89	BT
620	Apply Coatings (Barrel Action)		9-25-89	TJA
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		11/2/89	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/2/89	RW
	C) Inspect Ejector Hole for Chamfer		10/2/89	RW
	D) Oil Firing Pin Ass'y		10/2/89	RW
	E) Adjust Trigger Pull to Min Setting and Stake		3/2/89	GS

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			10/4/89	JS
	G) Safety Off Force	3	3	3			10/4/89	JS
	H) Trigger Pull Test & Retainability						3 Oct 89	JS
	I) Firing Pin Indent	.0205	.021	.020			10/4/89	JS
	J) Assemble Stock						10/4/89	RW
	K) Assemble Swivel Studs						6 Oct 89	JS
	L) Attach Front and Rear Sight Assemblies						10/4/89	RW
	M) Iron Sight Alignment						10/4/89	RW
	N) Detach Front & Rear Sights & place in numbered container						10/4/89	RW
	O) Attach Scope to Rifle						10/4/89	JS
	P) Detach & Attach Scope 20 Times						10/4/89	JS
640	Gallery Target & Test						10-4-89	AC
	A) Time						10-4-89	AC
	B) Malfunctions						10-4-89	AC
	C) Pierced Primers						10-4-89	AC
	D) Optical Clarity of Scope						10-4-89	AC
645	Inspect for Live Ammo						10-4-89	AC
655	Final Inspection A) Headspace						6 Oct 89	JS
	B) Trigger Pull	278	283	273	250	246	6 Oct 89	JS
	C) Function						6 Oct 89	JS
660	Pack						15 Dec 89	JS

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. 1639 ~~388~~ 30

DATE 13 MAR 90

TESTER Q28

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	250	235		219	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	241	242		223	
PULL #3	239	241		219	
PULL #4	240	238		227	
PULL #5	240	240		225	
TOTAL	1210	1196			
AVG.	242	2392			

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	284	291		
PULL #2	297	255		
PULL #3	298	272		
PULL #4	297	301		
PULL #5	293	289		
TOTAL	1469	1408		
AVG.	2938	2816		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	392	380		
PULL #2	380	369		
PULL #3	383	378		
PULL #4	385	381		
PULL #5	382	380		
TOTAL	1922	1888		
AVG.	3854	3776		

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06348830
4 OCT 1989

CENTROIDAL DISTANCES

0 TO	1	.542403
1 TO	2	.177553
1 TO	3	.364642
1 TO	4	.272943
1 TO	5	.361006

+85 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .5634
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1852
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .593859
THE AMR FOR THIS RIFLE IS: .9796

4 Oct 1988

FILE: PATTERNING/CENTERFIRE_PATT/C634B0030

CENTERFIRE PATTERNS

1

POA

1 in circle

2 in circle

3 in circle

CENTROID #

* OF SHOTS= 10

IN CIR

1 in = 0

2 in = 4

3 in = 10

HS= 2.525

VS= 2.526

GS= 2.679

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.120	.964	.857
MINIMUM X	-1.405	-1.257	-1.364
MAXIMUM Y	1.313	1.311	1.159
MINIMUM Y	-1.213	-1.215	-1.000
CENTROID X	.435	.591	.698
CENTROID Y	-.324	-.322	-.170
POA TO CENTROID in.	.542	.673	.719
MIN RADIUS	.519	.478	.628
MEAN RADIUS	1.057	.997	.916
MAX RADIUS	1.405	1.489	1.427
HORIZONTAL SPREAD	2.525	2.221	2.221
VERTICAL SPREAD	2.526	2.526	2.159
EXTREME SPREAD	2.679	2.679	2.294
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	10		

4 Oct 1985

FILE:/PATTERNING/CENTERFIRE_PATT/C834B898

CENTERFIRE PATTERNS

2

POB

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS= 10

IN CIR

1in = 2

2in = 6

3in = 10

HS= 2.150

VS= 2.659

GS= 2.853

PATTERN #	:	2	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.297	1.203	1.214
MINIMUM X	:	-.853	-.644	-.633
MAXIMUM Y	:	1.451	1.317	1.589
MINIMUM Y	:	-1.208	-1.139	-.974
CENTROID X	:	.354	.448	.438
CENTROID Y	:	-.166	-.032	-.197
POB TO CENTROID in.	:	.391	.449	.490
MIN RADIUS	:	.374	.286	.417
MEAN RADIUS	:	.885	.792	.740
MAX RADIUS	:	1.478	1.320	1.220
HORIZONTAL SPREAD	:	2.150	1.847	1.847
VERTICAL SPREAD	:	2.659	2.456	1.563
EXTREME SPREAD	:	2.853	2.542	1.981
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	6		
NUMBER IN THREE INCH CIRCLE	=	10		

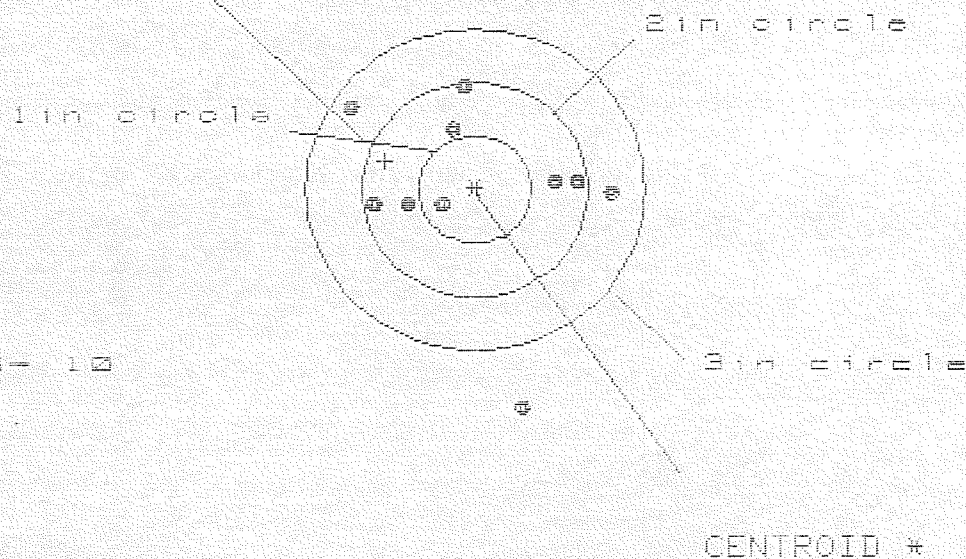
4 OCT 1985

FILE:/PATTERNING/CENTERFIRE_PATT/08346030

CENTERFIRE PATTERNS

3

POB



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 7

3 in = 9

HS= 2.222

VS= 3.028

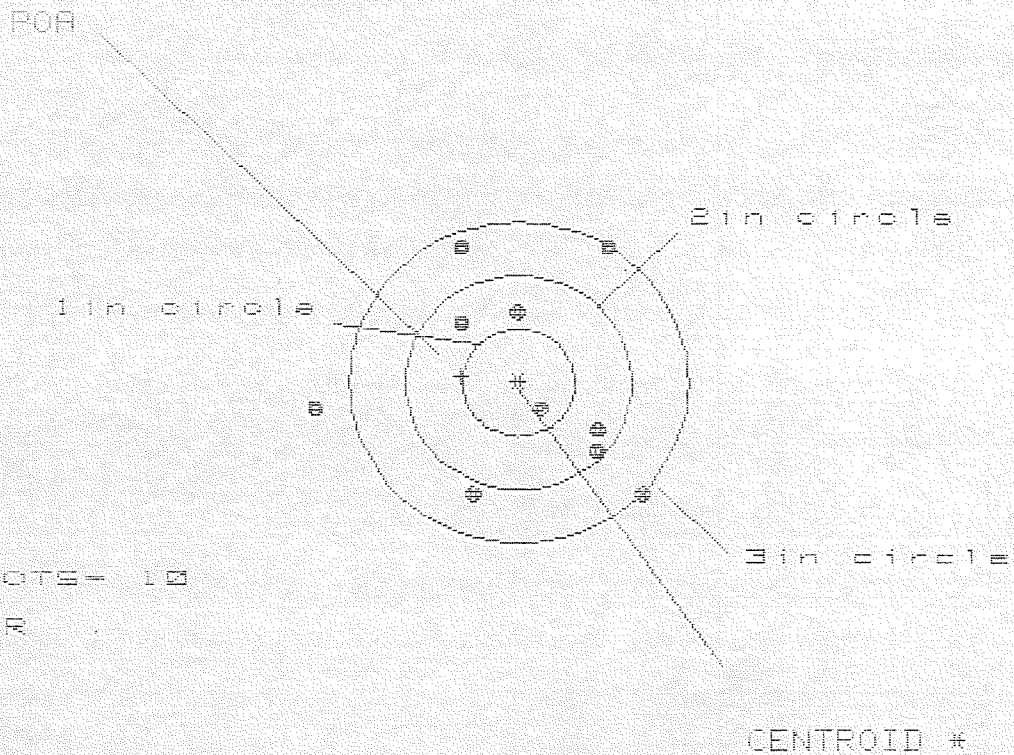
GS= 3.155

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.168	1.211	1.085
MINIMUM X	:	-1.054	-1.011	-0.996
MAXIMUM Y	:	.969	.741	.805
MINIMUM Y	:	-2.059	-.365	-.301
CENTROID X	:	.795	.752	.878
CENTROID Y	:	-.266	-.038	-.102
POB TO CENTROID in.	:	.839	.752	.884
MIN RADIUS	:	.325	.355	.469
MEAN RADIUS	:	.966	.808	.772
MAX RADIUS	:	2.096	1.233	1.098
HORIZONTAL SPREAD	:	2.222	2.222	2.081
VERTICAL SPREAD	:	3.028	1.106	1.106
EXTREME SPREAD	:	3.155	2.344	2.085
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

4 Oct 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C8348890

CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 5

3 in = 8

HS= 2.907

VS= 2.345

GS= 3.022

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.089	.886	.651
MINIMUM X	:	-1.819	-.757	-.646
MAXIMUM Y	:	1.259	1.230	1.091
MINIMUM Y	:	-1.086	-1.115	-1.194
CENTROID X	:	.508	.711	.600
CENTROID Y	:	-.061	-.032	.107
POA TO CENTROID in.	:	.512	.711	.609
MIN RADIUS	:	.272	.258	.398
MEAN RADIUS	:	1.074	.970	.912
MAX RADIUS	:	1.837	1.441	1.295
HORIZONTAL SPREAD	:	2.907	1.643	1.297
VERTICAL SPREAD	:	2.345	2.345	2.284
EXTREME SPREAD	:	3.022	2.860	2.521
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

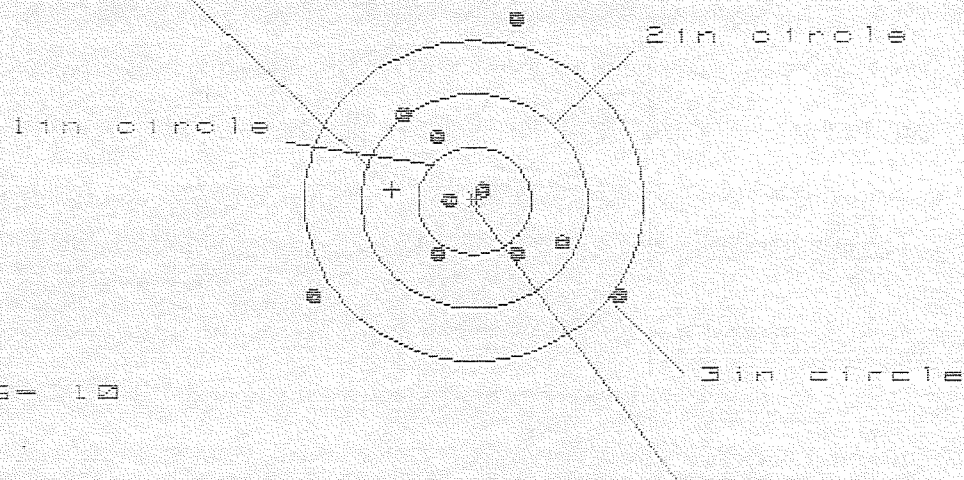
4 Oct 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C8348830

CENTERFIRE PATTERNS

5

POB



OF SHOTS= 10

IN CIR

1in = 2

2in = 6

3in = 7

HS= 2.639

VS= 2.628

GS= 3.184

CENTROID #

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.259	1.306	1.139
MINIMUM X	-1.380	-1.333	-1.741
MAXIMUM Y	1.724	.988	.899
MINIMUM Y	-.964	-.713	-.755
CENTROID X	.725	.678	.845
CENTROID Y	-.109	-.300	-.211
POB TO CENTROID in.	.733	.742	.871
MIN RADIUS	.145	.311	.189
MEAN RADIUS	.916	.822	.721
MAX RADIUS	1.773	1.512	1.366
HORIZONTAL SPREAD	2.639	2.639	1.880
VERTICAL SPREAD	2.628	1.701	1.654
EXTREME SPREAD	3.184	2.639	2.504
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		7	

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06348830
12 Dec 1989

0 TO	1	.431372
1 TO	2	.262408
1 TO	3	.40606
1 TO	4	.0880909
1 TO	5	.543242

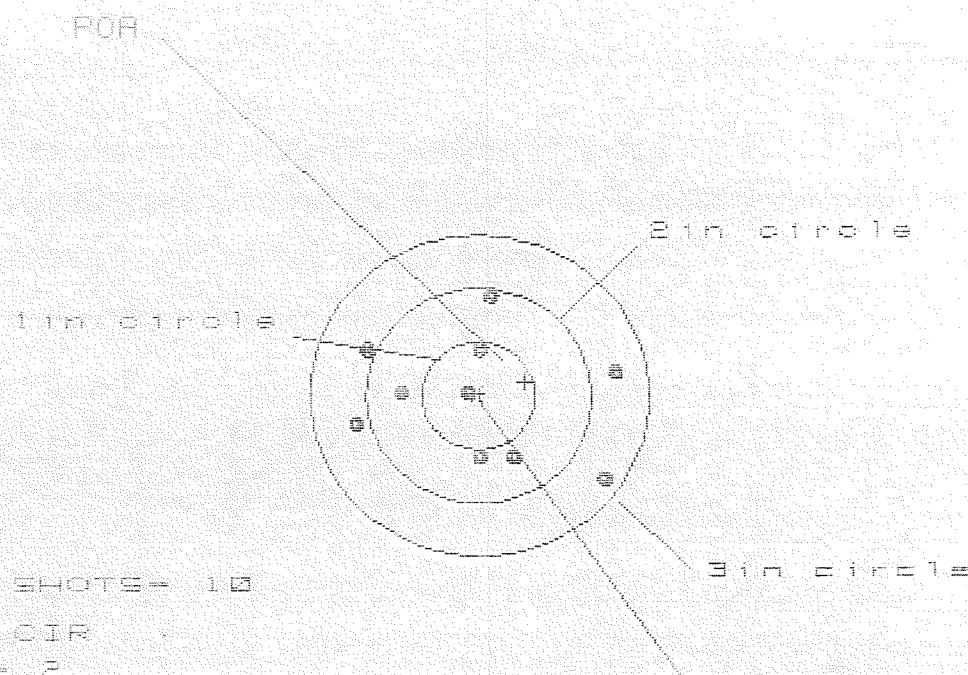
SECRET

```
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.2752
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.095
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .291136
THE AMP FOR THIS RIFLE IS: .9048
```

12 Dec 1999

FILE:/PATTERNING/CENTERFIRE_PATT/C8940830.1

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1 in = 2

2 in = 6

3 in = 10

HS= 2.311

VS= 1.626

GS= 2.484

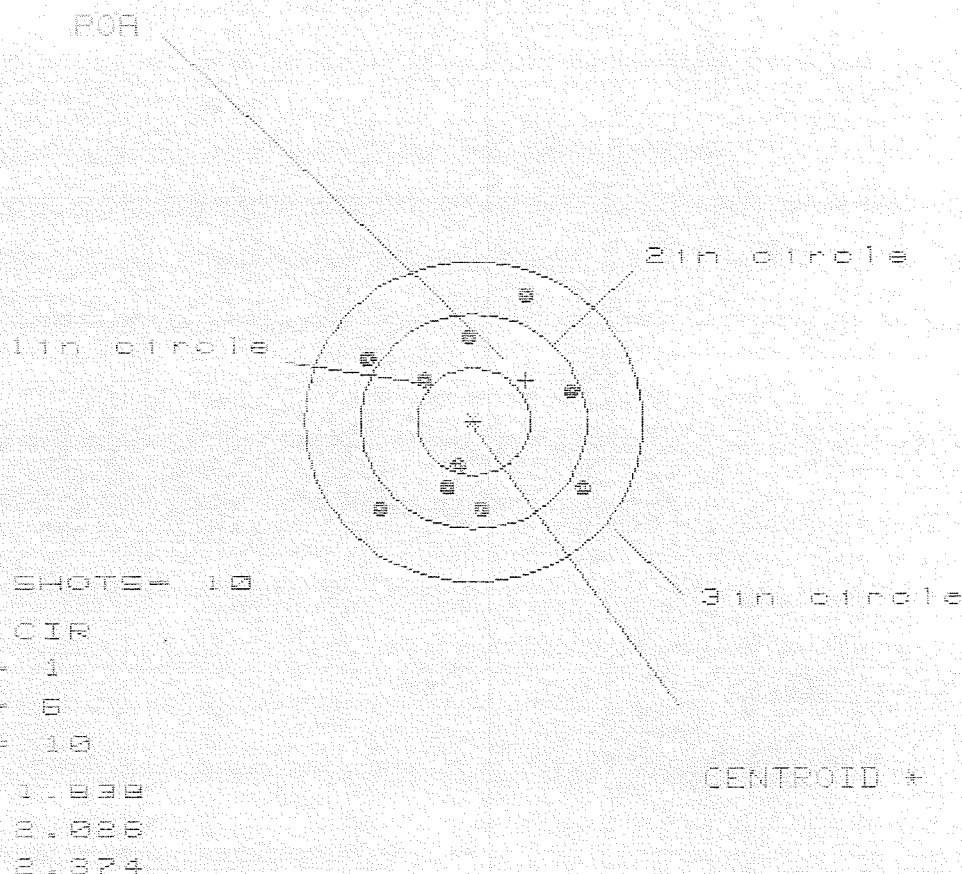
CENTROID #

PATTERN #	:			
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.242	1.369	.623
MINIMUM X	:	-1.069	-.942	-.771
MAXIMUM Y	:	.907	.828	.844
MINIMUM Y	:	-.719	-.649	-.633
CENTROID X	:	-.411	-.538	-.709
CENTROID Y	:	-.131	-.052	-.068
FOR TO CENTROID in.	:	.432	.540	.712
MIN RADIUS	:	.040	.126	.270
MEAN RADIUS	:	.816	.752	.671
MAX RADIUS	:	1.349	1.375	.951
HORIZONTAL SPREAD	:	2.311	2.311	1.394
VERTICAL SPREAD	:	1.626	1.477	1.477
EXTREME SPREAD	:	2.484	2.360	1.690
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	

12 Dec 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C6346830.1

CENTERFIRE PATTERNS # 2



PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.939	.992	1.090
MINIMUM X	:	-.899	-.846	-.721
MAXIMUM Y	:	1.199	.939	.874
MINIMUM Y	:	-.827	-.694	-.759
CENTROID X	:	-.464	-.517	-.642
CENTROID Y	:	-.388	-.521	-.456
FOR TO CENTROID in.	:	.605	.735	.787
MIN RADIUS	:	.407	.263	.309
MEAN RADIUS	:	.879	.807	.760
MAX RADIUS	:	1.293	1.121	1.143
HORIZONTAL SPREAD	:	1.838	1.838	1.811
VERTICAL SPREAD	:	2.026	1.633	1.633
EXTREME SPREAD	:	2.374	2.218	2.022
NUMBER IN ONE INCH CIRCLE =			1	
NUMBER IN TWO INCH CIRCLE =			6	
NUMBER IN THREE INCH CIRCLE =			10	

12 Dec 1999

FILE:/PATTERNING/CENTERFIRE_PATT/C0340830.1

CENTERFIRE PATTERNS # 3

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS = 10

IN CIR

1in = 1

2in = 5

3in = 10

HS = 2.375

VS = 2.032

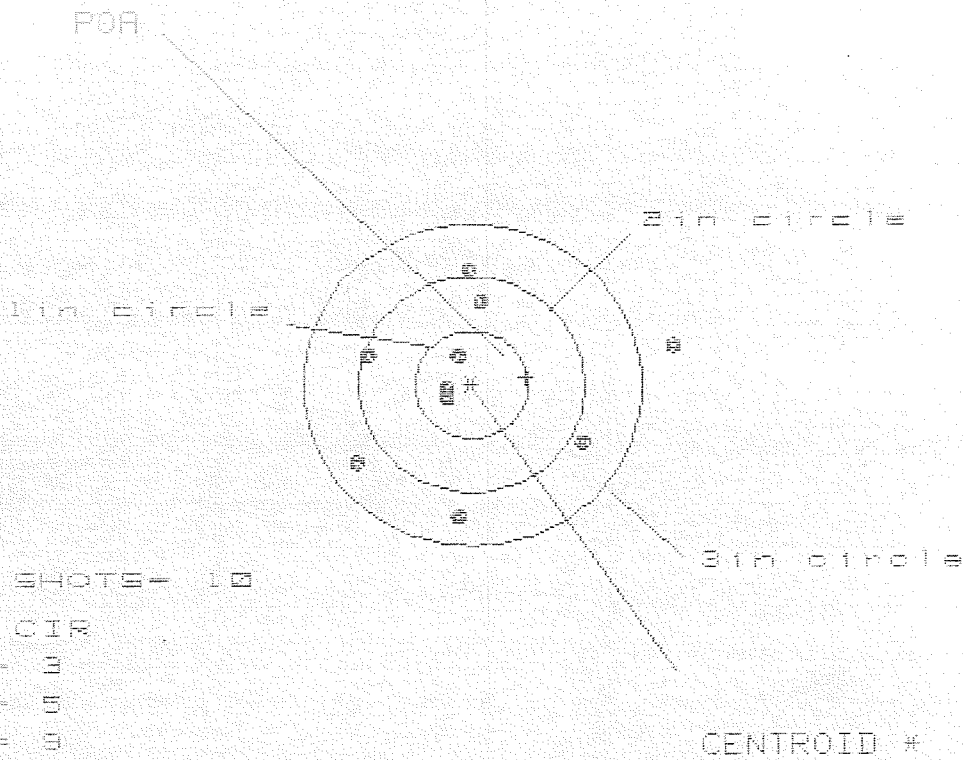
GS = 2.529

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	9
MAXIMUM X	:	1.097	.959	.950
MINIMUM X	:	-1.278	-1.416	-1.296
MAXIMUM Y	:	1.022	.937	.826
MINIMUM Y	:	-1.010	-1.095	-1.206
CENTROID X	:	-.005	.134	.014
CENTROID Y	:	-.124	-.039	.072
POA TO CENTROID in.	:	.124	.139	.073
MIN RADIUS	:	.337	.418	.527
MEAN RADIUS	:	1.021	.964	.901
MAX RADIUS	:	1.464	1.416	1.471
HORIZONTAL SPREAD	:	2.375	2.375	2.246
VERTICAL SPREAD	:	2.032	2.032	2.032
EXTREME SPREAD	:	2.529	2.529	2.394
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	5		
NUMBER IN THREE INCH CIRCLE	=	10		

12 Dec 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C8348830.1

CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1 in = 3

2 in = 5

3 in = 9

HS= 2.777

VS= 2.321

GS= 2.973

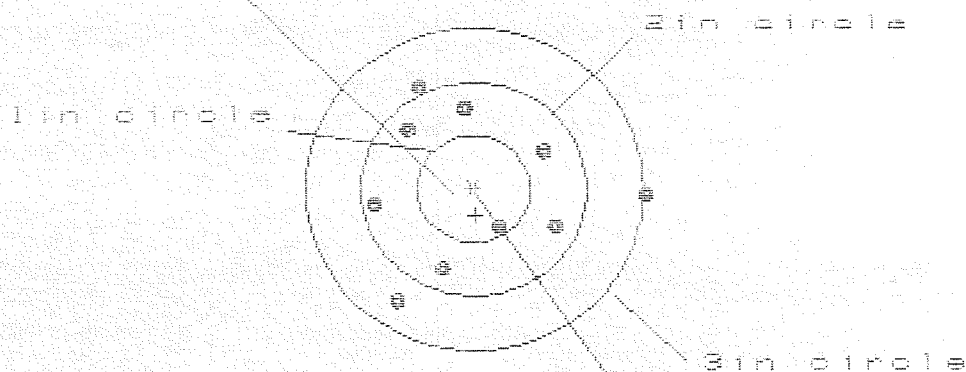
PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.729	1.172	1.175
MINIMUM X	:	-1.048	-.856	-.853
MAXIMUM Y	:	1.049	1.085	.931
MINIMUM Y	:	-1.272	-1.236	-.852
CENTROID X	:	-.479	-.671	-.674
CENTROID Y	:	-.075	-.111	.043
POA TO CENTROID in.	:	.485	.680	.675
MIN RADIUS	:	.227	.043	.159
MEAN RADIUS	:	.904	.756	.693
MAX RADIUS	:	1.760	1.288	1.362
HORIZONTAL SPREAD	:	2.777	2.028	2.028
VERTICAL SPREAD	:	2.321	2.321	1.783
EXTREME SPREAD	:	2.973	2.324	2.077
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

12 Dec 1989

FILE:/PATTERNING/CENTERFIRE_PATT/08345830.1

CENTERFIRE PATTERNS # 5

POA



OF SHOTS= 10

IN CIR

1in = 1

2in = 7

3in = 10

HS= 2.368

VS= 2.033

GS= 2.399

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.473	.928	.861
MINIMUM X	:	-.895	-.731	-.798
MAXIMUM Y	:	.953	.946	.810
MINIMUM Y	:	-1.088	-1.087	-.885
CENTROID X	:	-.017	-.181	-.114
CENTROID Y	:	.243	.250	.385
POA TO CENTROID in.	:	.243	.308	.402
MIN RADIUS	:	.381	.499	.553
MEAN RADIUS	:	.904	.834	.773
MAX RADIUS	:	1.474	1.211	.985
HORIZONTAL SPREAD	:	2.368	1.659	1.659
VERTICAL SPREAD	:	2.033	2.033	1.696
EXTREME SPREAD	:	2.399	2.041	1.818
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	