

G-6664 5614
Replicas
C-649 9812

Repair Inquiry

Repair Number: RE00130273

Serial: C6499812 Model M24 SWS Center Fire
Caliber: 7.62 NATO Produced: 02/05/1990

Repairman:

Verify Repair

Status:

New 6/12/2007 2:30:07 PM

Address Information

Customer:

Received From

Return To:

Received From

Name: HERNANDEZ, EZEKIEL

HERNANDEZ, EZEKIEL

Address 1: 10224 N RIVER RIDGE LOOP

10224 N RIVER RIDGE LOOP

Address 2: PO Box:

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: 315 772 6930

Fax:

Email:

Comments:

Received Condition

Fair

Condition
Notes:CSR
Notes:

Accessories Received

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

Repair Search

Refresh

Close

nagletj

6/19/2007

7:44 AM

CAPS

NUM

INS

SCRL

start

Inbox - Microso...

Calendar - Micr...

Calendar - Micr...

Arms Services ...

7:44 AM

C6645614 (New)

~~C6499812~~

Model: M24 SWS



RE00130273

C-6498812

Not C-6499812

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6645614.___0
FILE DATE AND TIME: 06/26/2007 10:03

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

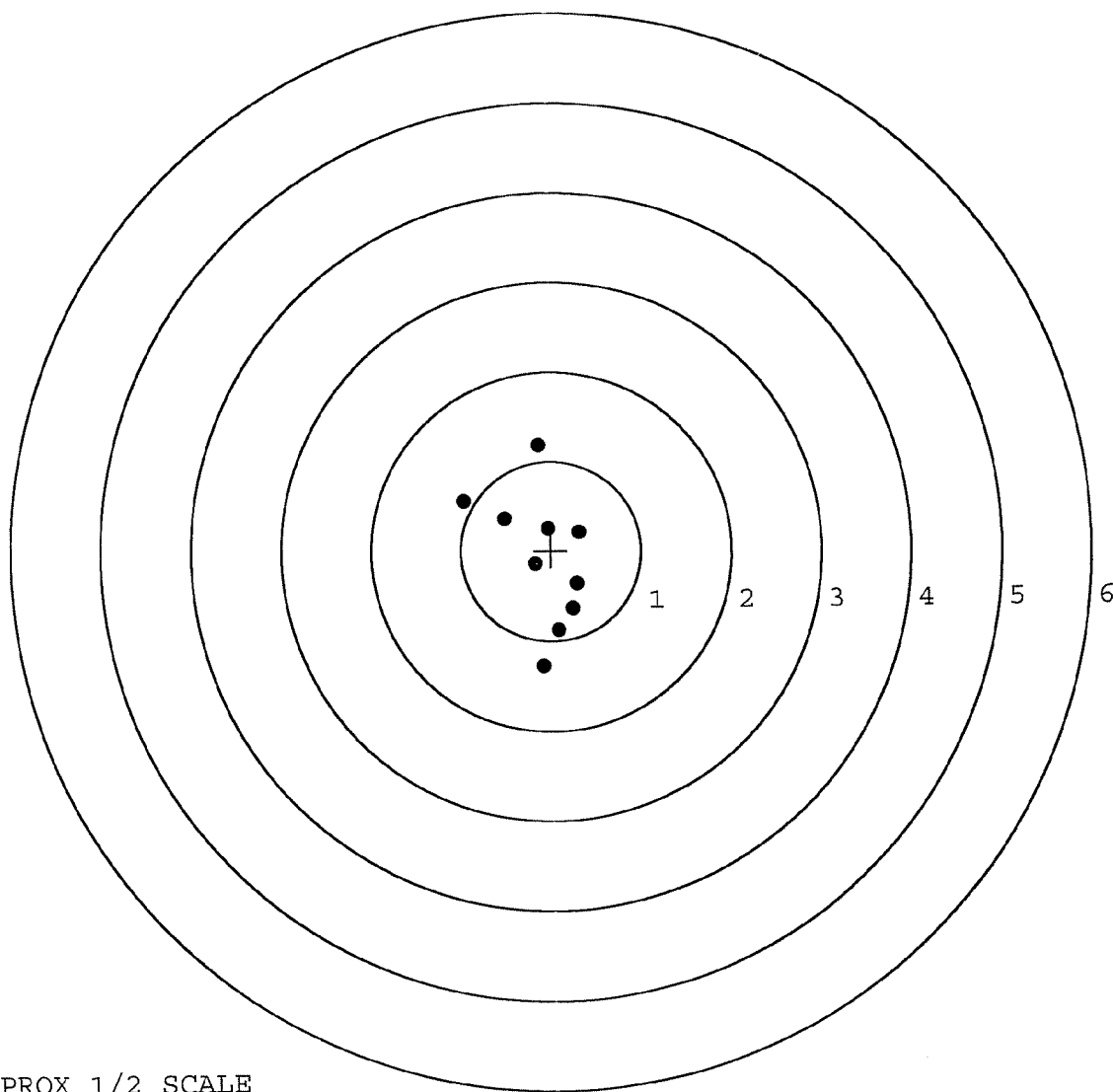
The Average X Centroid of the Five Target Set:	-0.099
The Average Y Centroid of the Five Target Set:	-0.048
The Average Point of Impact of the Five Target Set:	0.110
The Average Mean Radius of the Five Target Set:	0.800
The Distance from POA to Centroid Target #1:	0.124
The Distance from Centroid Target #2 to Centroid Target #1:	0.120
The Distance from Centroid Target #3 to Centroid Target #1:	0.191
The Distance from Centroid Target #4 to Centroid Target #1:	0.129
The Distance from Centroid Target #5 to Centroid Target #1:	0.065

SERIAL NUMBER: G6645614. __0
TARGET NUMBER: 1
FILE DATE: 06/26/2007
FILE TIME: 10:03

X CENTROID: -0.098
Y CENTROID: -0.076
POA TO CENTROID: 0.124
HORZ SPREAD: 1.275
VERT SPREAD: 2.469
GROUP SPREAD: 2.469
MIN RADIUS: 0.111
MAX RADIUS: 1.260
MEAN RADIUS: 0.707

IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.096	-1.285
2:	0.080	-0.882
3:	0.246	-0.642
4:	0.292	-0.367
5:	-0.180	-0.150
6:	0.314	0.211
7:	-0.028	0.251
8:	-0.513	0.363
9:	-0.133	1.184
10:	-0.961	0.561



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6645614.___0

TARGET NUMBER: 2

FILE DATE: 06/26/2007

FILE TIME: 10:03

X CENTROID: -0.002

Y CENTROID: -0.004

POA TO CENTROID: 0.005

HORZ SPREAD: 2.240

VERT SPREAD: 1.805

GROUP SPREAD: 2.308

MIN RADIUS: 0.603

MAX RADIUS: 1.496

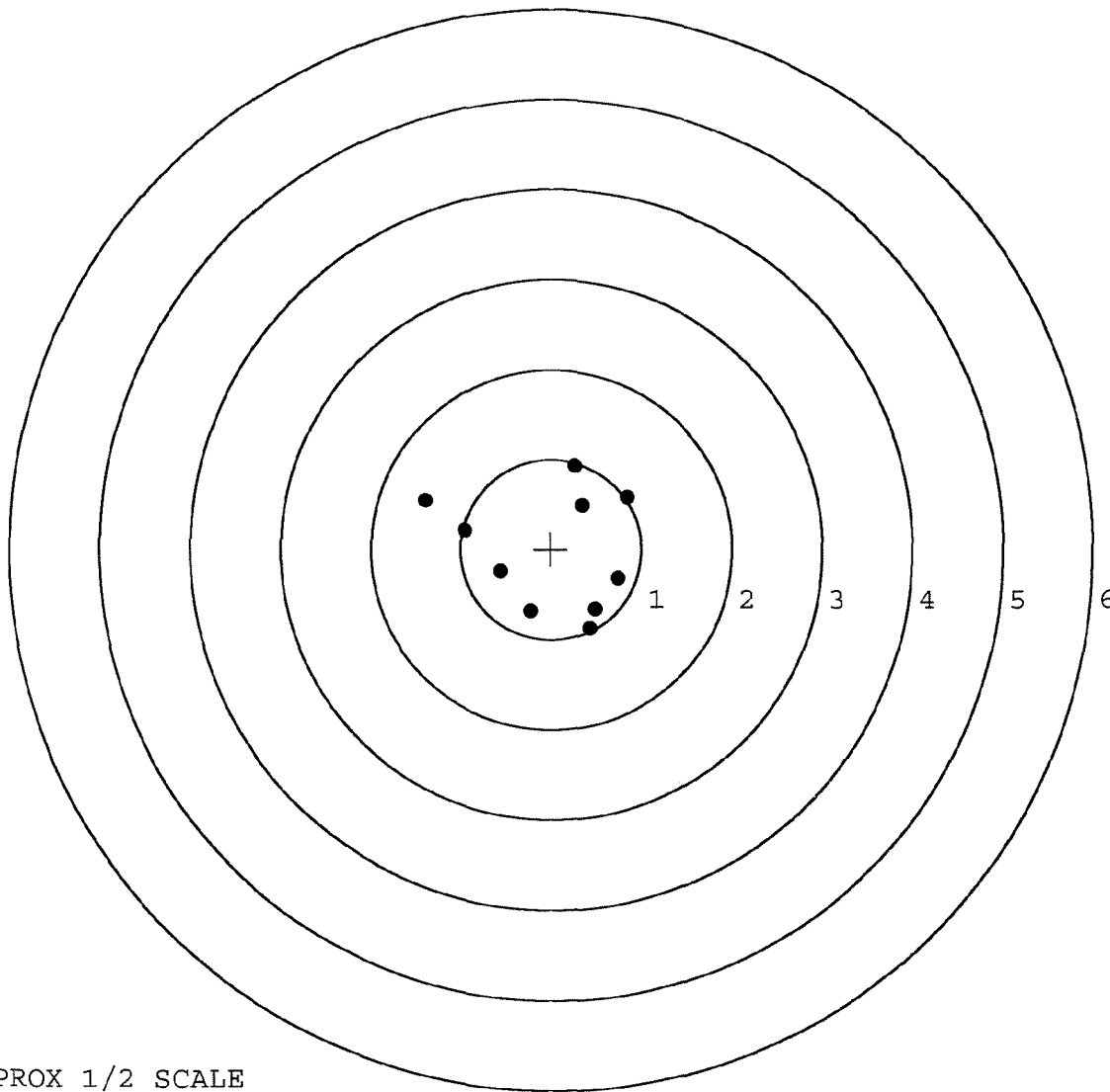
MEAN RADIUS: 0.901

IN 1 IN DIAMETER: 0

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.271	0.931
2:	0.347	0.488
3:	0.845	0.582
4:	-1.395	0.541
5:	-0.959	0.212
6:	-0.557	-0.249
7:	-0.231	-0.688
8:	0.428	-0.874
9:	0.492	-0.661
10:	0.740	-0.326



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6645614. 0

TARGET NUMBER: 3

FILE DATE: 06/26/2007

FILE TIME: 10:03

X CENTROID: -0.268

Y CENTROID: 0.011

POA TO CENTROID: 0.268

HORZ SPREAD: 2.872

VERT SPREAD: 2.043

GROUP SPREAD: 3.226

MIN RADIUS: 0.366

MAX RADIUS: 1.663

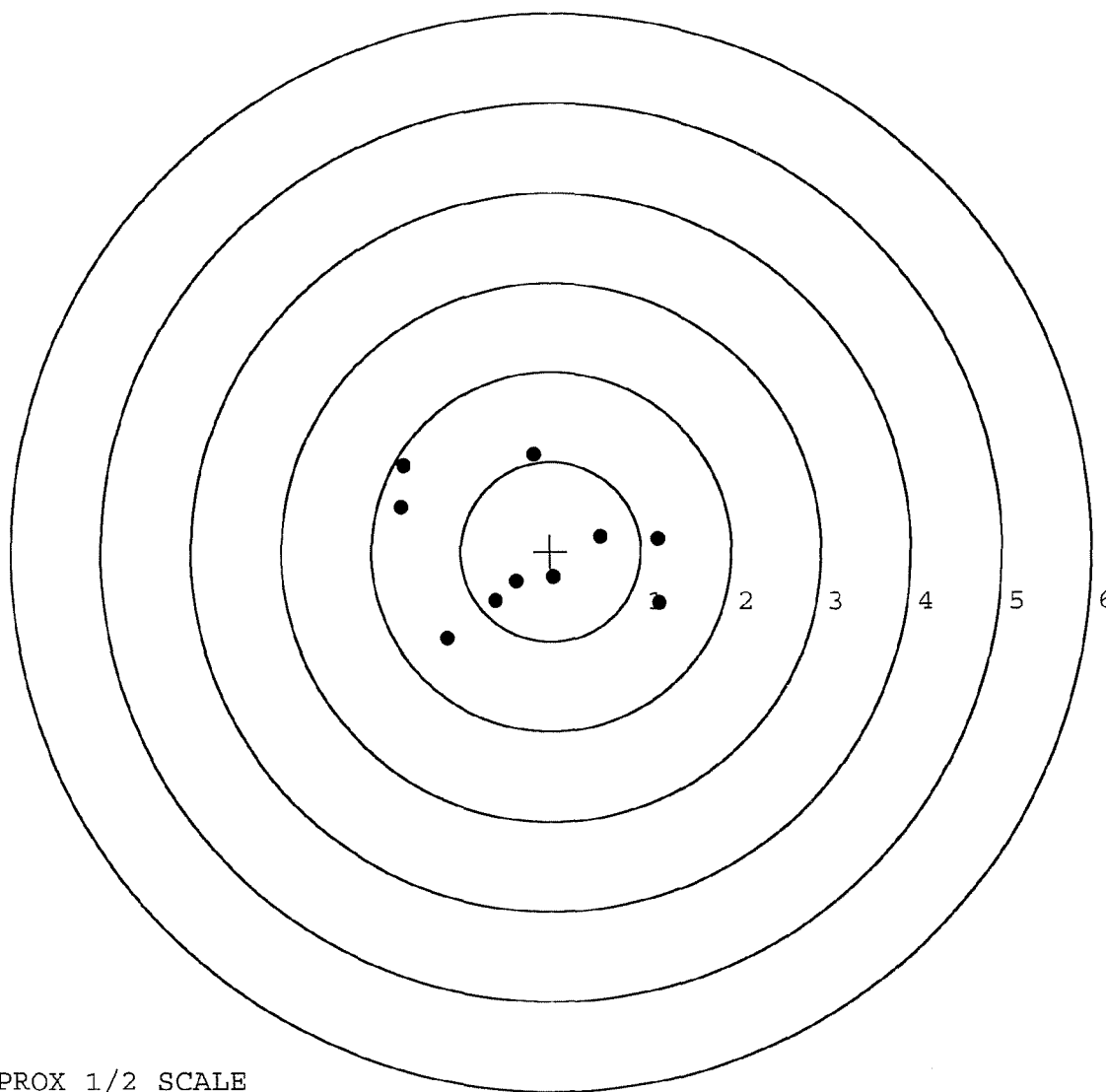
MEAN RADIUS: 1.086

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 4

in 3 IN DIAMETER: 8

POINT#	X	Y
1:	1.200	-0.579
2:	1.184	0.141
3:	0.551	0.168
4:	0.031	-0.289
5:	-0.381	-0.337
6:	-0.615	-0.550
7:	-1.157	-0.969
8:	-0.182	1.074
9:	-1.638	0.954
10:	-1.672	0.496



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6645614. __ 0

TARGET NUMBER: 4

FILE DATE: 06/26/2007

FILE TIME: 10:03

X CENTROID: 0.031

Y CENTROID: -0.068

POA TO CENTROID: 0.075

HORZ SPREAD: 2.434

VERT SPREAD: 1.376

GROUP SPREAD: 2.559

MIN RADIUS: 0.167

MAX RADIUS: 1.414

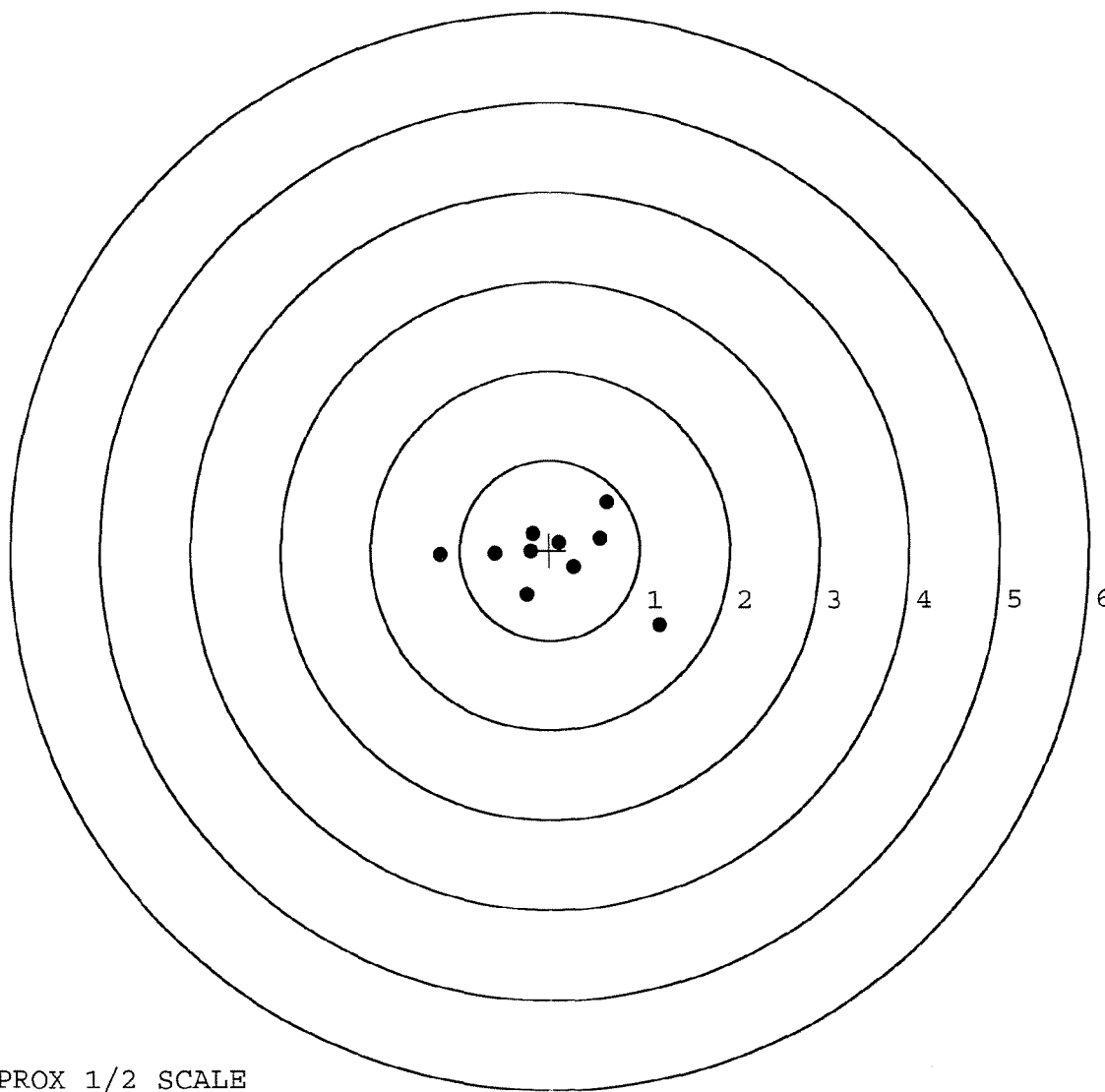
MEAN RADIUS: 0.626

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.191	0.186
2:	0.110	0.080
3:	-0.207	-0.020
4:	-0.255	-0.497
5:	-0.613	-0.034
6:	-1.216	-0.047
7:	0.639	0.539
8:	0.555	0.138
9:	0.272	-0.185
10:	1.218	-0.837



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6645614. __0

TARGET NUMBER: 5

FILE DATE: 06/26/2007

FILE TIME: 10:03

X CENTROID: -0.157

Y CENTROID: -0.103

POA TO CENTROID: 0.188

HORZ SPREAD: 1.869

VERT SPREAD: 1.499

GROUP SPREAD: 2.055

MIN RADIUS: 0.185

MAX RADIUS: 1.138

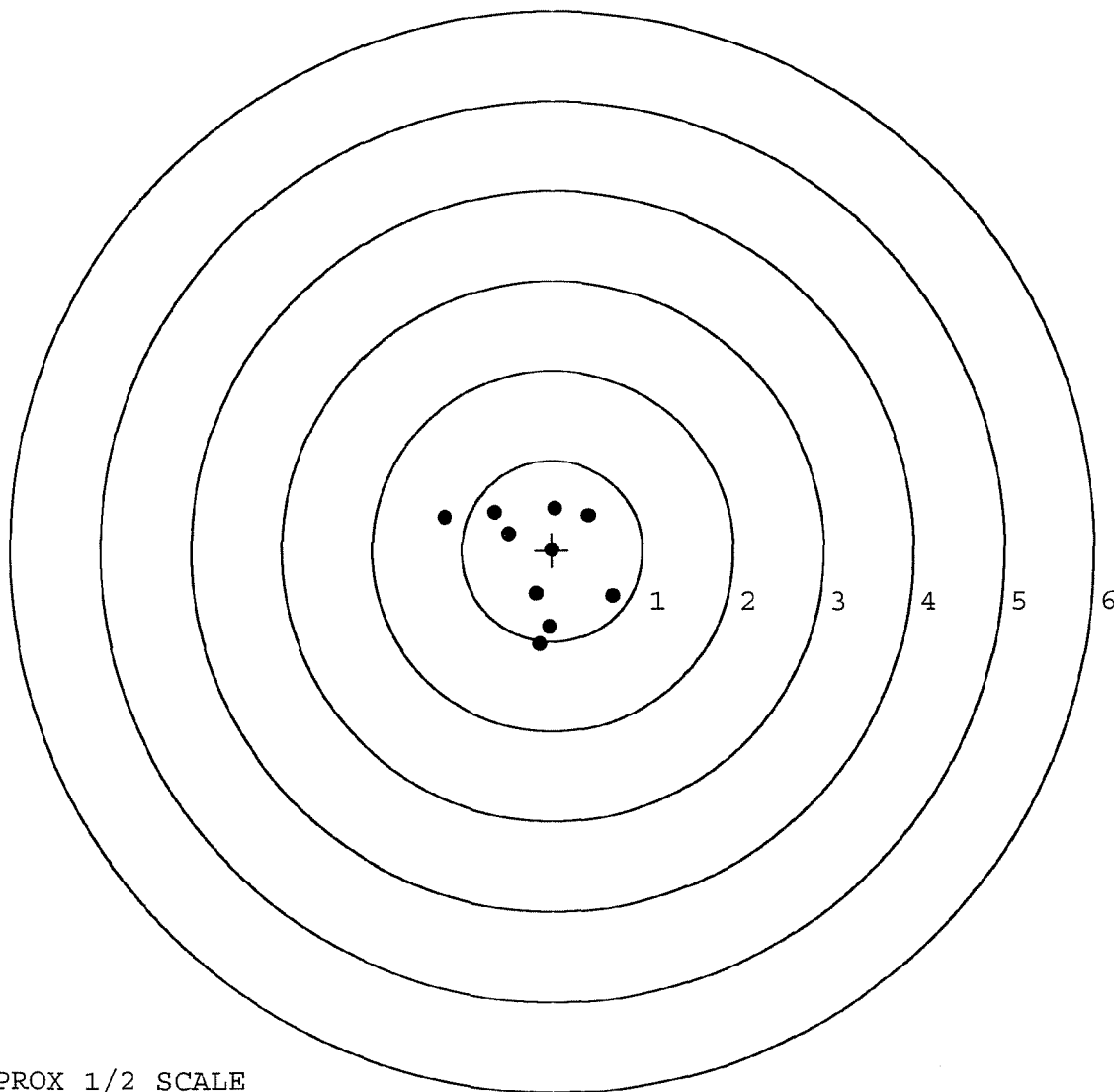
MEAN RADIUS: 0.679

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.001	-0.004
2:	0.406	0.389
3:	0.031	0.465
4:	-0.484	0.183
5:	-0.639	0.426
6:	-1.197	0.361
7:	0.672	-0.494
8:	-0.145	-1.034
9:	-0.036	-0.844
10:	-0.181	-0.476



TARGET APPROX 1/2 SCALE

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

R & E NUMBER		130273		66645614(Nue)	
SERIAL NUMBER		C6499812			
LOG-IN DATE		6-12-07			
OPERATION #	OPERATION NAME		DATE	INITIAL	
500	DIS-ASSEMBLE GUN		6-13-07	RJL	
505	RE-BARREL		6-15-07	RJL	
560	ASSEMBLE		6-18-07	RJL	
600	PROOF		6-18-07	TRW	
605	CHECK HEADSPACE		6-18-07	TRW	
610	DIS-ASSEMBLE GUN		6-18-07	RJL	
612	MAGNAFLUX	OPERATOR Wms	6-18-07	Wms	
510	DRILL AND TAP		6-18-07	SD	
615	ROLLMARK CALIBER		6-19-07	CW	
618	ROTO-BLAST		6-19-07	DS	
620	APPLY COATINGS		6-21-07	BS	
625	FINAL ASSEMBLY		6-26-07	RJL	
640	FUNCTION TEST AND	PASS FAIL	6-26-07	TRW	
650	TARGET	PASS FAIL	6-26-07	TRW	
	MALFUNCTION	CORRECTION			
	MALFUNCTION	CORRECTION			
	MALFUNCTION	CORRECTION			
	MALFUNCTION	CORRECTION			
670	FINAL INSPECTION		6-26-07	RJL	
	A) HEADSPACE	PASS FAIL	6-26-07	RJL	
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	280 289 268 2.72 2.74 6-26-07	DA	
680	F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX	4.5 4.5 4.5 6-26-07	DA	
	G) SAFETY OFF FORCE	2 LBS MIN	2.5 2.5 2.5 6-26-07	DA	
	I) FIRING PIN INDENT	.020	.024 .0245 .0245 6-26-07	DA	
690	PACK		6-26-07	DA	

Repair Inquiry

Repair Number: RE00062688

Serial: C6498812 Model 700 Center Fire Caliber:
308 SWS CAMO

Repairman:

Verify Repair

Status:

New 3/6/2003 12:15:48 PM

Address Information

Customer:

☒ Received From

Return To:

☐ Received From

Name: SFC TIMOTHY RADER

SFC TIMOTHY RADER

Address 1: HHC 2/22IN

HHC 2/22IN

Address 2: PO Box:

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: 315 772 3393

Fax:

Email:

Comments:

Received Condition

Fair

Condition
Notes:CSR
Notes:

Accessories Received

Code	Desc	Qty
A007	With Stud	1
A017	Scope Base	1
A026	Scope	1
B000	FRONT AND REAR B.	1
B100	DEPLOYMENT KIT	1

Repair Search

Refresh

Close

naglej

3/6/2003

12:39 PM

CAPS

NUM

INS

SOFI

start

3 Microsoft

my Exalt - Mo

Part Search by

Create Product

Arms Services

12:39 PM

Serial Number: C6498812

Model: 700



RE00062688

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6498812.___0
FILE DATE AND TIME: 03/21/2003 22:32

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.009
The Average Y Centroid of the Five Target Set:	0.006
The Average Point of Impact of the Five Target Set:	0.010
The Average Mean Radius of the Five Target Set:	0.773
The Distance from POA to Centroid Target #1:	0.179
The Distance from Centroid Target #2 to Centroid Target #1:	0.258
The Distance from Centroid Target #3 to Centroid Target #1:	0.188
The Distance from Centroid Target #4 to Centroid Target #1:	0.263
The Distance from Centroid Target #5 to Centroid Target #1:	0.276

SERIAL NUMBER: C6498812.___0

TARGET NUMBER: 1

FILE DATE: 03/21/2003

FILE TIME: 22:32

X CENTROID: 0.005

Y CENTROID: -0.179

POA TO CENTROID: 0.179

HORZ SPREAD: 1.673

VERT SPREAD: 3.033

GROUP SPREAD: 3.083

MIN RADIUS: 0.261

MAX RADIUS: 1.975

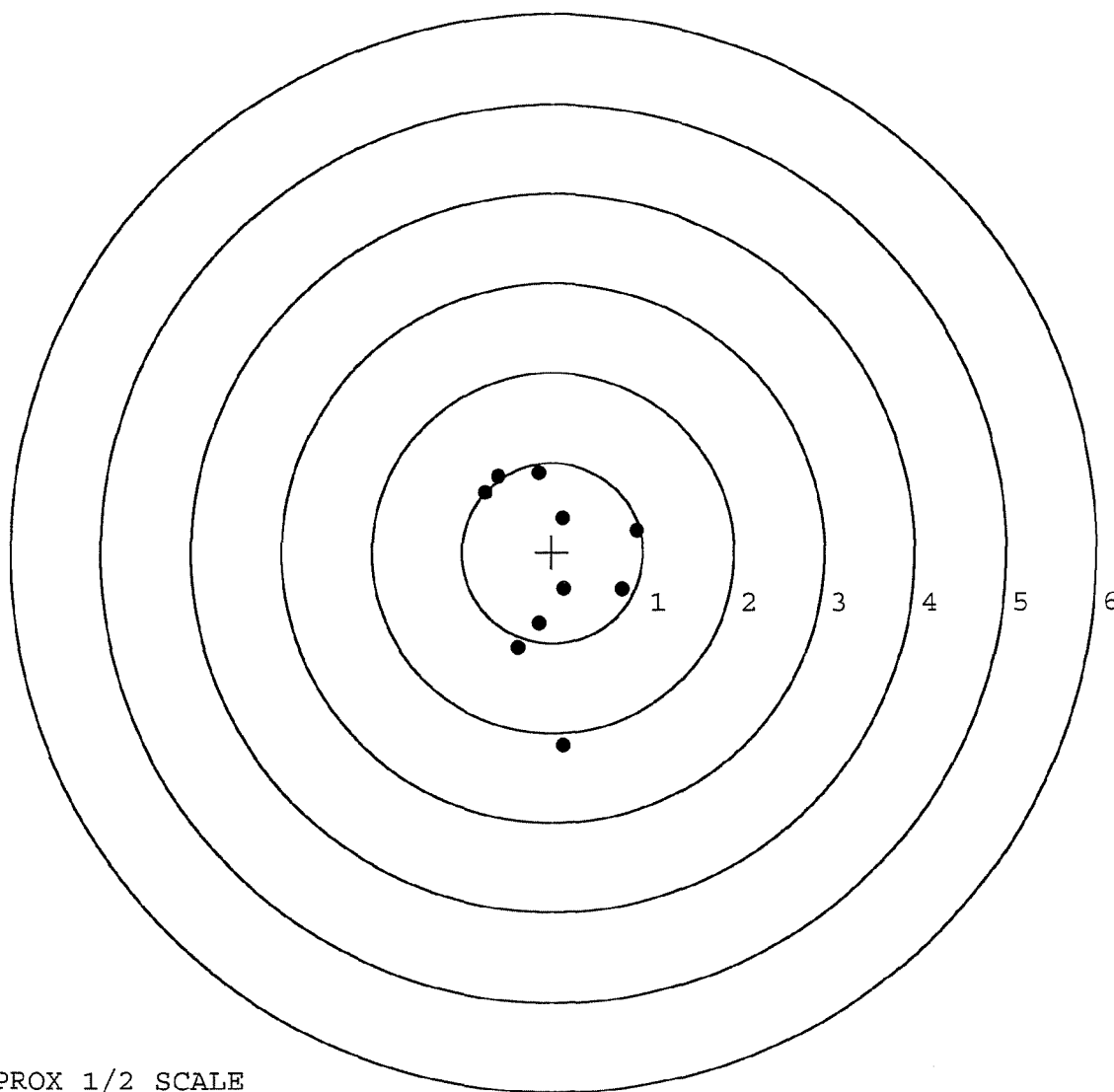
MEAN RADIUS: 0.960

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 5

in 3 IN DIAMETER: 9

POINT#	X	Y
1:	0.121	-2.150
2:	-0.381	-1.055
3:	-0.147	-0.789
4:	0.128	-0.409
5:	0.772	-0.408
6:	0.927	0.243
7:	0.119	0.379
8:	-0.150	0.883
9:	-0.595	0.849
10:	-0.746	0.671



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6498812. 0

TARGET NUMBER: 2

FILE DATE: 03/21/2003

FILE TIME: 22:32

X CENTROID: 0.101

Y CENTROID: 0.060

POA TO CENTROID: 0.118

HORZ SPREAD: 1.429

VERT SPREAD: 2.026

GROUP SPREAD: 2.296

MIN RADIUS: 0.282

MAX RADIUS: 1.272

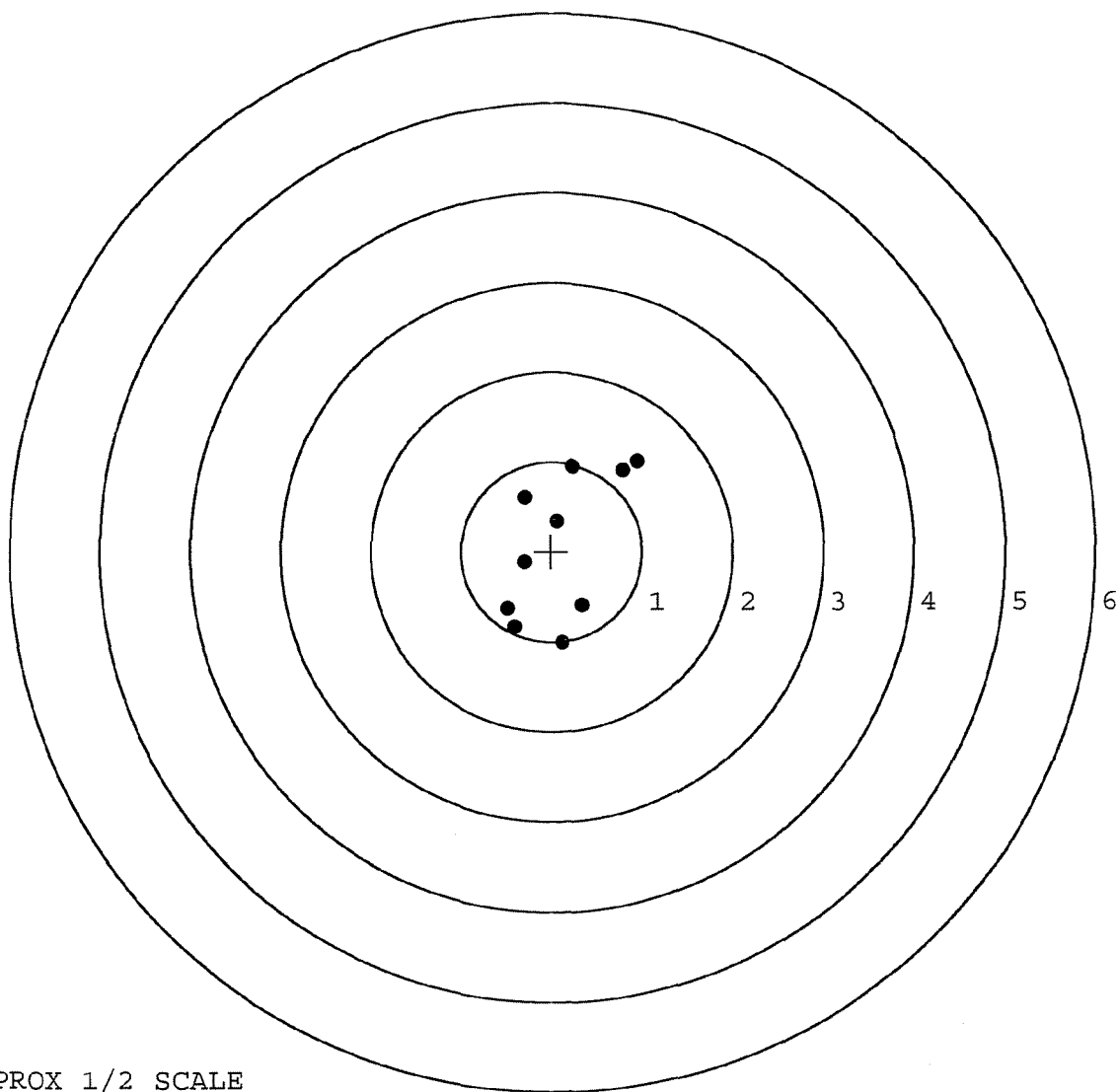
MEAN RADIUS: 0.838

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.126	-1.015
2:	0.340	-0.599
3:	-0.411	-0.840
4:	-0.482	-0.638
5:	-0.295	-0.120
6:	0.065	0.340
7:	-0.300	0.604
8:	0.237	0.952
9:	0.787	0.910
10:	0.947	1.011

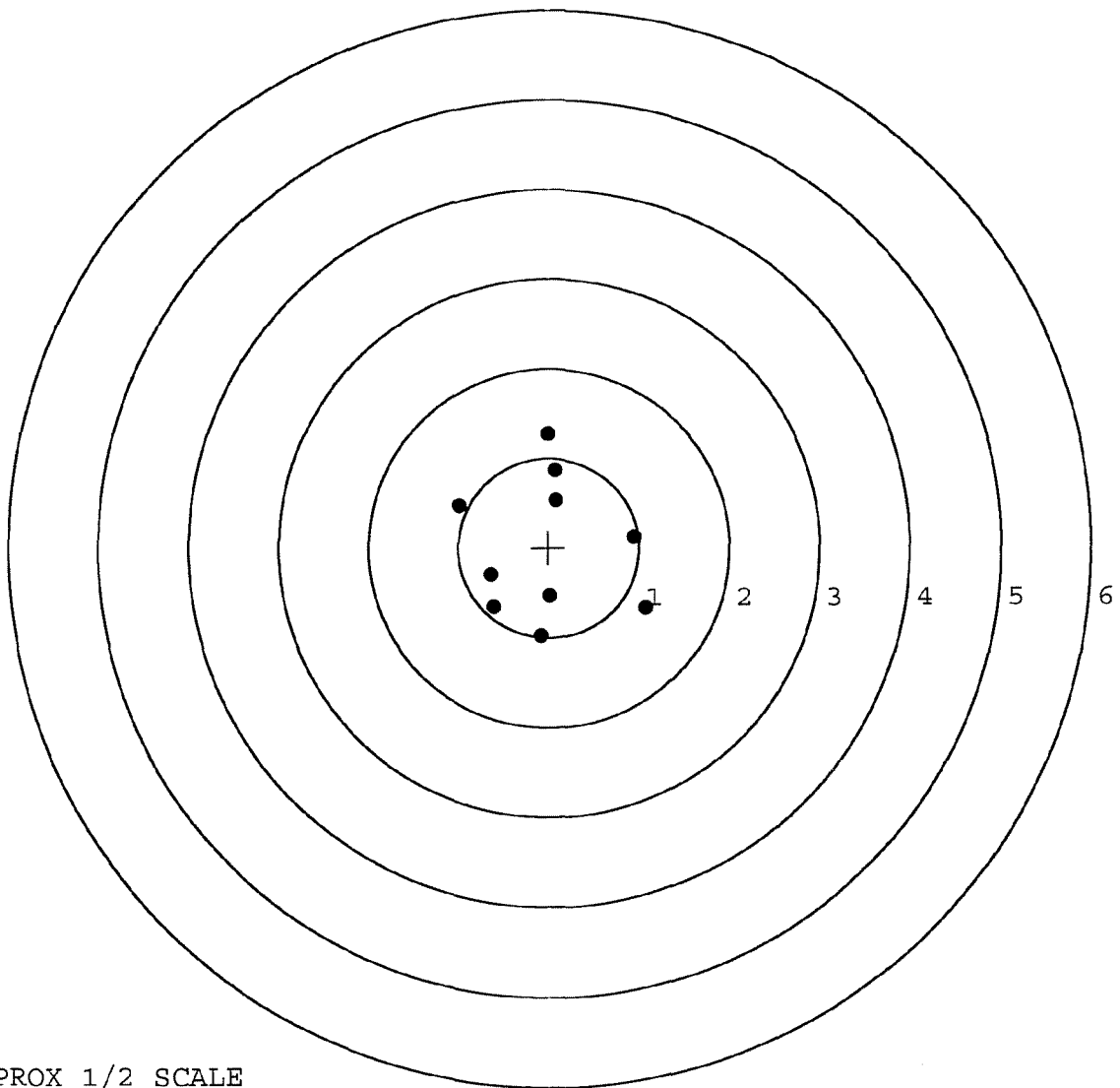


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6498812. __0
TARGET NUMBER: 3
FILE DATE: 03/21/2003
FILE TIME: 22:32

X CENTROID: -0.015
Y CENTROID: 0.008
POA TO CENTROID: 0.017
HORZ SPREAD: 2.054
VERT SPREAD: 2.262
GROUP SPREAD: 2.353
MIN RADIUS: 0.531
MAX RADIUS: 1.281
MEAN RADIUS: 0.912
IN 1 IN DIAMETER: 0
IN 2 IN DIAMETER: 6
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	1.067	-0.679
2:	-0.088	-0.990
3:	0.018	-0.541
4:	0.944	0.120
5:	-0.609	-0.663
6:	-0.637	-0.303
7:	-0.987	0.469
8:	0.084	0.530
9:	0.075	0.865
10:	-0.012	1.272

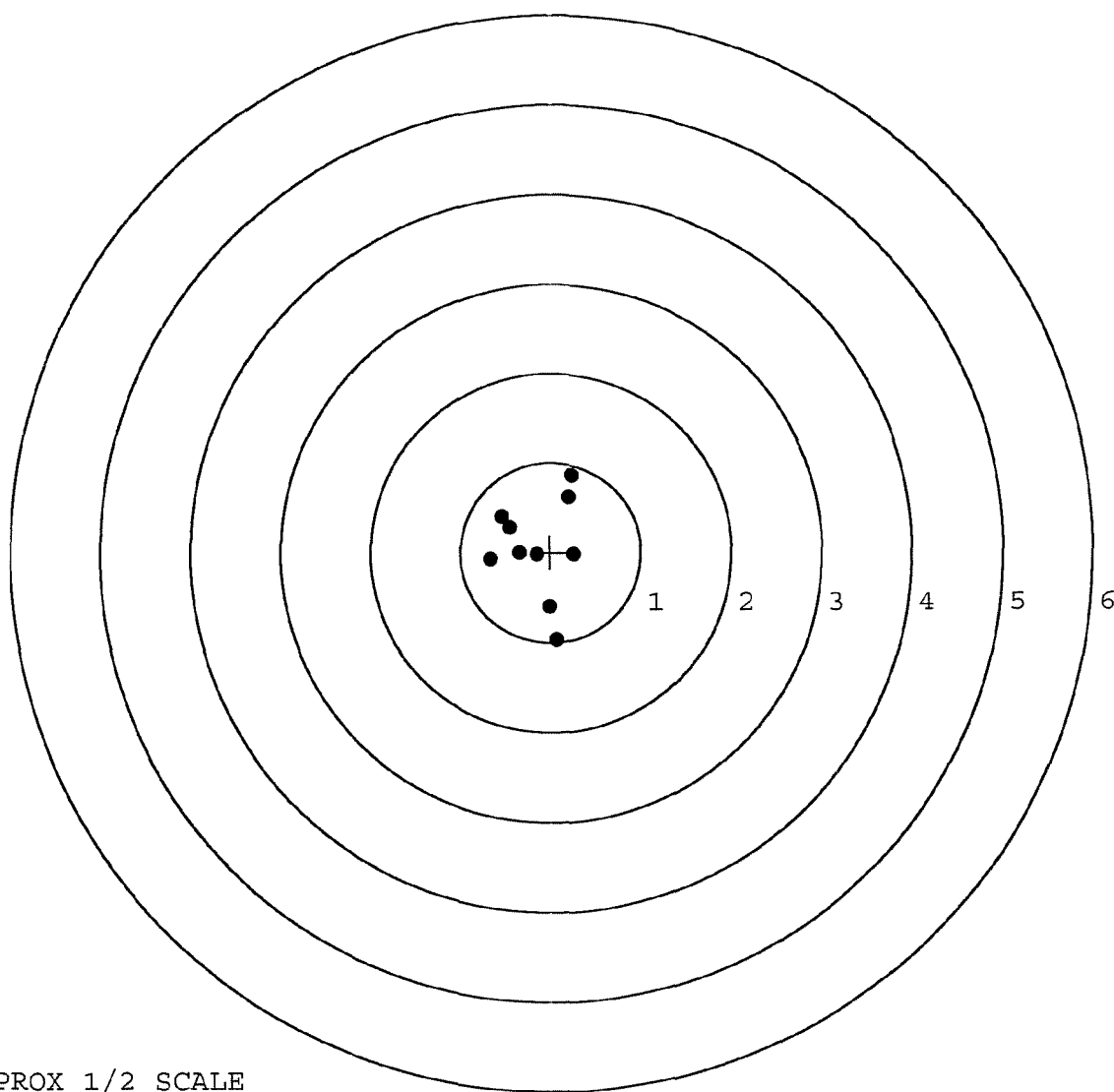


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6498812. __0
TARGET NUMBER: 4
FILE DATE: 03/21/2003
FILE TIME: 22:32

X CENTROID: -0.140
Y CENTROID: 0.041
POA TO CENTROID: 0.146
HORZ SPREAD: 0.925
VERT SPREAD: 1.835
GROUP SPREAD: 1.842
MIN RADIUS: 0.071
MAX RADIUS: 1.040
MEAN RADIUS: 0.543
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.070	-0.977
2:	-0.011	-0.612
3:	0.261	-0.032
4:	0.204	0.615
5:	0.234	0.858
6:	-0.153	-0.028
7:	-0.344	-0.008
8:	-0.664	-0.075
9:	-0.455	0.279
10:	-0.542	0.395



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6498812. __0

TARGET NUMBER: 5

FILE DATE: 03/21/2003

FILE TIME: 22:32

POINT#	X	Y
1:	-0.090	-1.046
2:	0.665	0.716
3:	0.814	1.146
4:	-0.025	0.531
5:	-0.073	0.446
6:	0.042	0.081
7:	-0.146	-0.348
8:	-0.125	-0.102
9:	-0.462	-0.309
10:	-0.548	-0.143

X CENTROID: 0.005

Y CENTROID: 0.097

POA TO CENTROID: 0.097

HORZ SPREAD: 1.362

VERT SPREAD: 2.192

GROUP SPREAD: 2.371

MIN RADIUS: 0.040

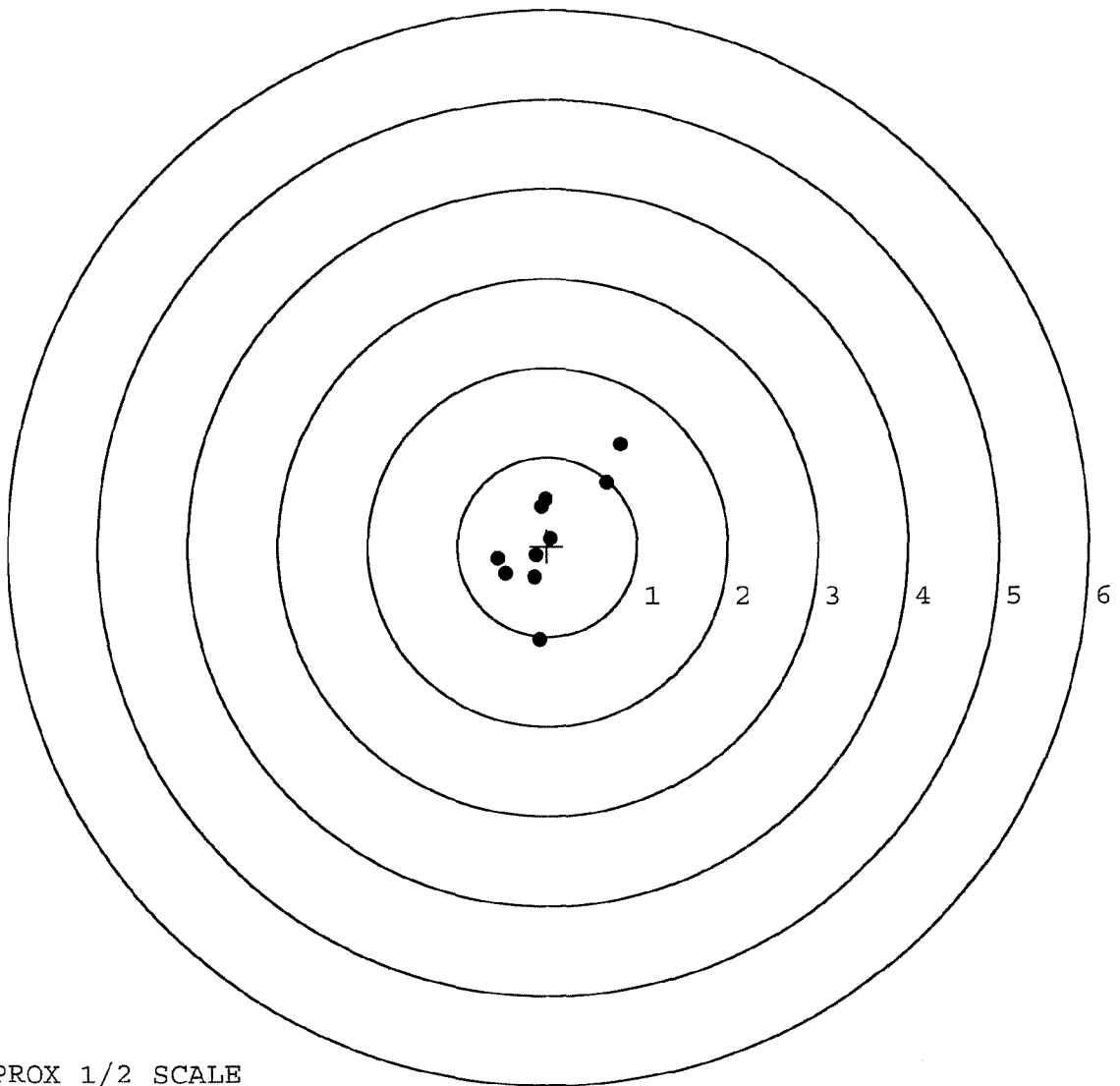
MAX RADIUS: 1.324

MEAN RADIUS: 0.614

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

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

R & E NUMBER	C 26 88		
SERIAL NUMBER	C 649 8812		
LOG-IN DATE	3/6/03		
INSPECT AND VERIFY:			
OPERATION #	OPERATION NAME	DATE	INITIAL
550	DIS-ASSEMBLE GUN	3/7/03	RTL
560 A	RE-BARREL	3-11-03	RTL
B	DRILL AND TAP	3-12-03	TRW
575	ASSEMBLE	3-11-03	RTL
600	PROOF	3-11-03	AC
605	CHECK HEADSPACE	3-11-03	AC
610	DIS-ASSEMBLE GUN	3-11-03	RTL
612	MAGNAFLUX OPERATOR		
615	ROLLMARK CALIBER	3-11-03	RTL
618	ROTO-BLAST	3-14-03	DG
620	APPLY COATINGS	3-18	TA
625 A	FINAL ASSEMBLY	3-19-03	RU
B	TRIGGER PULL TEST		
C	SAFETY "ON" FORCE		
D	SAFETY "OFF" FORCE		
E	FIRING PIN INDENT		
640	TARGET	3-20-03	RU
655	FINAL INSPECT	3-24-03	RTL
660	PACK	3-21-03	JA
		SHIP DATE	
QAR INSPECTION DATE			

Remington®



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

MODEL 700™ H24

SERIAL NO.

C6498812

ORDER NO.

5716

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

01



5716 C6498812

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6498812

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	5 9	90	RW
600	Proof	5 9	90	RW
607	Check Headspace	5 9	90	RW
610	Dis-assemble Gun	5	90	RW
612	Magnaflux Barrel Action	5-15-90		KER
	Magnaflux Bolt	5-15-90		KER
615	Rollmark Caliber	5-15-90		GS
617	Drill and Tap Sight Holes		5/17/90	KB
618	Polish Barrel <i>RB</i>		5/17/90	WB
620	Apply Coatings (Barrel Action)		5-25-90	1A
	Apply Coating (Bolt)			1B
625	Final Assembly A) Clean inside of Bolt Assembly		5/25/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/25/90	RW
	C) Inspect Ejector Hole for Chamfer		5/25/90	RW
	D) Oil Firing Pin Ass'y		5/25/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		6-1-90	RU

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4 1/4	4 1/4	4 1/4			6/1/90	WLB
	G) Safety Off Force	2	2	2			6/1/90	WLB
	H) Trigger Pull Test & Retainability						6-1-90	JH
	I) Firing Pin Indent	.0245	.025	.0245			6/1/90	WLB
	J) Assemble Stock						6/4/90	RW
	K) Assemble Swivel Studs						6-6-90	JS
	L) Attach Front and Rear Sight Assemblies						6/4/90	RW
	M) Iron Sight Alignment						6/4/90	RW
	N) Detach Front & Rear Sights & place in numbered container						6/4/90	RW
	O) Attach Scope to Rifle						6/4/90	WLB
	P) Detach & Attach Scope 20 Times						6/4/90	WLB
640	Gallery Target & Test						6-5-90	DH
	A) Time						6-5-90	DH
	B) Malfunctions						6-5-90	DH
	C) Pierced Primers						6-5-90	DH
	D) Optical Clarity of Scope						6-5-90	DH
645	Inspect for Live Ammo						6-5-90	DH
655	Final Inspection						6-8-90	JS
	A) Headspace						6-8-90	JS
	B) Trigger Pull	264	252	251	252	249	6-6-90	JS
	C) Function						6-6-90	JS
660	Pack						6-9-90	DH

SWS TRIGGER PULL TEST

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

SERIAL NO. C6498812
DATE 6-1-90
TESTER J2L

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.31	2.27	2.30	2.64	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.04	2.25	2.25	2.52	
PULL #3	2.38	2.32	2.36	2.51	
PULL #4	2.30	2.33	2.30	2.52	
PULL #5	2.36	2.37	2.24	2.49	
TOTAL	11.39	11.54	11.45		
AVG.	2.278	2.308	2.29		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.26	3.35		
PULL #2	3.55	3.29		
PULL #3	3.50	3.36		
PULL #4	3.52	3.35		
PULL #5	3.55	3.39		
TOTAL	17.36	16.74		
AVG.	3.472	3.348		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.33	4.16		4.24
PULL #2	4.33	4.26		4.15
PULL #3	4.41	4.25		4.22
PULL #4	4.50	4.32		4.28
PULL #5	4.24	4.31		4.35
TOTAL	21.81	21.30		21.24
AVG.	4.362	4.26		4.248

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6498812
6 Jun 1990

CENTROIDAL DISTANCES

Ø TO	1	.585069
1 TO	2	.363815
1 TO	3	.924881
1 TO	4	.479355
1 TO	5	.623699

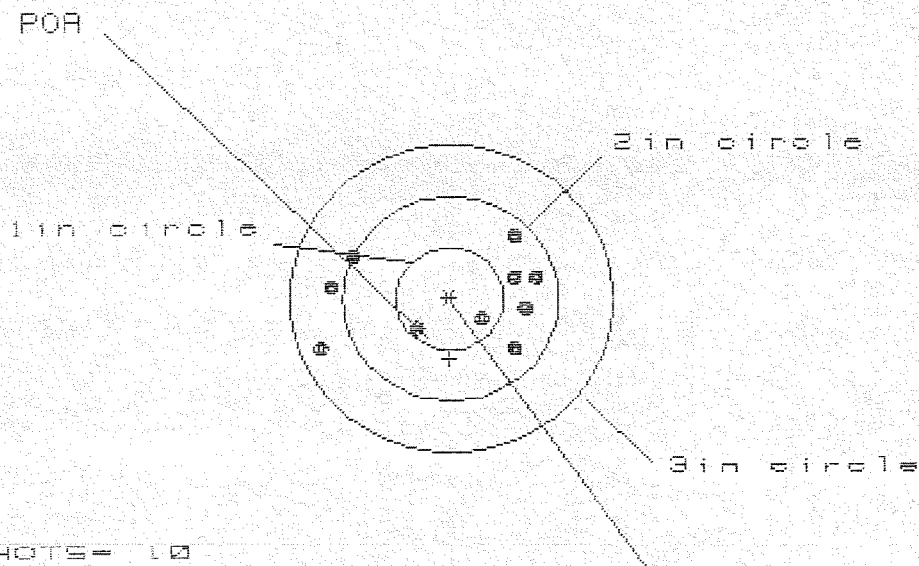
$\frac{1}{5} \times 3 \times \text{----POA}$

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .2716
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .2842
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .3398
THE AMR FOR THIS RIFLE IS: .8036

6 Jun 1990

FILE:/PATTERNING/CENTERFIRE_PATT/CG498012

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1 in = 2

2 in = 7

3 in = 10

HS= 1.940

VS= 1.131

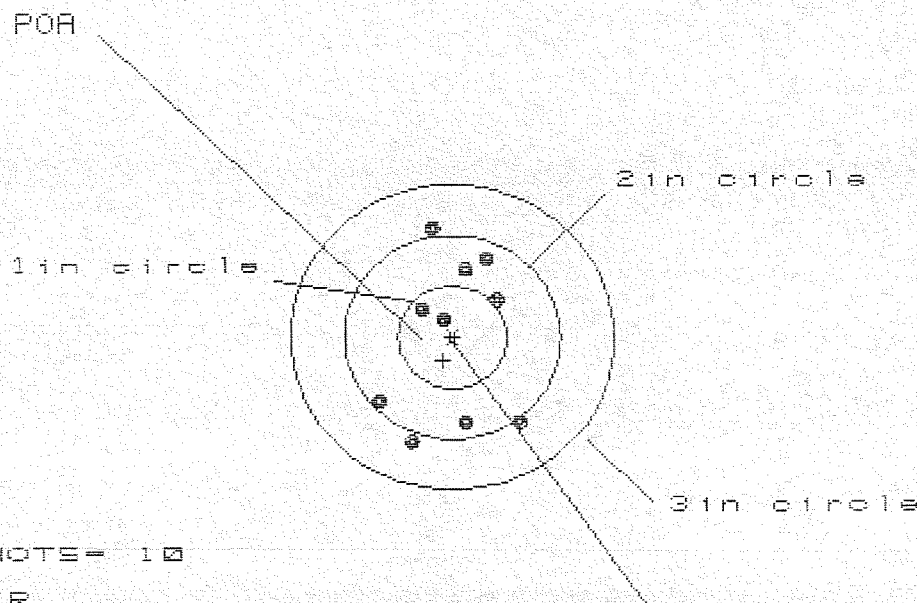
GS= 2.079

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.765	.635	.482
MINIMUM X	:	-1.175	-1.226	-1.228
MAXIMUM Y	:	.607	.549	.553
MINIMUM Y	:	-.524	-.582	-.578
CENTROID X	:	.009	.139	.292
CENTROID Y	:	.585	.643	.639
POA TO CENTROID in.	:	.585	.658	.703
MIN RADIUS	:	.350	.276	.201
MEAN RADIUS	:	.789	.701	.583
MAX RADIUS	:	1.285	1.226	1.282
HORIZONTAL SPREAD	:	1.940	1.861	1.710
VERTICAL SPREAD	:	1.131	1.131	1.131
EXTREME SPREAD	:	2.079	1.866	1.830
NUMBER IN ONE INCH CIRCLE =			2	
NUMBER IN TWO INCH CIRCLE =			7	
NUMBER IN THREE INCH CIRCLE =			10	

5 Jun 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C8498812

CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1in = 2

2in = 7

3in = 10

HS = 1.252

VS = 2.084

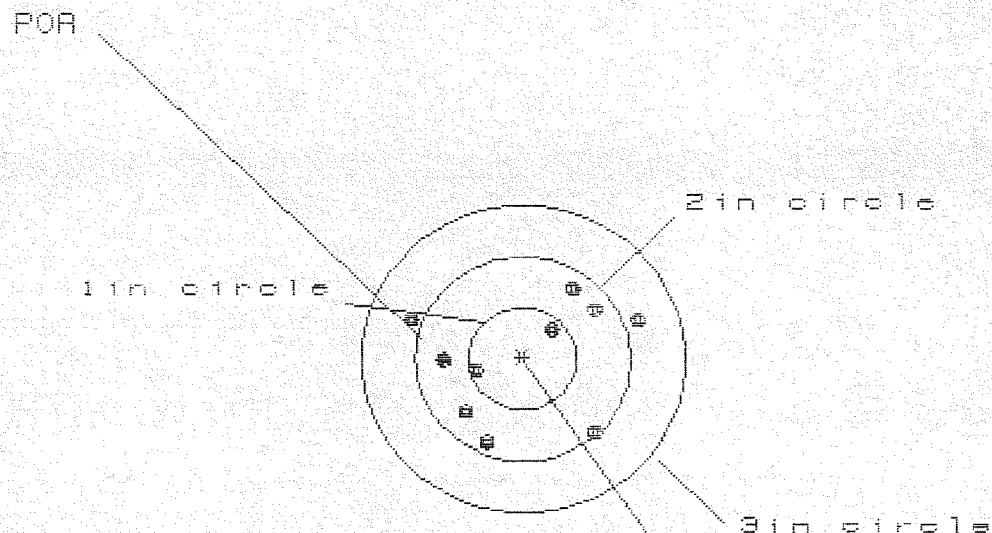
CS = 2.093

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.597	.582	.538
MINIMUM X	:	-.655	-.670	-.714
MAXIMUM Y	:	1.086	.871	.761
MINIMUM Y	:	-.998	-.877	-.825
CENTROID X	:	.084	.099	.143
CENTROID Y	:	.229	.108	.218
POA TO CENTROID in.	:	.244	.147	.260
MIN RADIUS	:	.174	.284	.224
MEAN RADIUS	:	.749	.723	.673
MAX RADIUS	:	1.095	.944	.973
HORIZONTAL SPREAD	:	1.252	1.252	1.252
VERTICAL SPREAD	:	2.084	1.748	1.586
EXTREME SPREAD	:	2.093	1.873	1.661
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

6 Jun 1998

FILE:/PATTERNING/CENTERFIRE_PATT/CG438812

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1 in = 2

2 in = 8

3 in = 10

HS= 2.128

VS= 1.571

GS= 2.128

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.061	.942	.679
MINIMUM X	:	-1.067	-.822	-.704
MAXIMUM Y	:	.737	.777	.829
MINIMUM Y	:	-.834	-.794	-.742
CENTROID X	:	.735	.854	.736
CENTROID Y	:	.012	-.029	-.081
POA TO CENTROID in.	:	.735	.854	.740
MIN RADIUS	:	.348	.324	.414
MEAN RADIUS	:	.806	.769	.724
MAX RADIUS	:	1.128	1.030	.949
HORIZONTAL SPREAD	:	2.128	1.764	1.383
VERTICAL SPREAD	:	1.571	1.571	1.571
EXTREME SPREAD	:	2.128	1.861	1.770
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	

6 Jun 1938

FILE:/PATTERNING/CENTERFIRE_PATT/08438812

CENTERFIRE PATTERNS

4

POA

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 0

2 in = 6

3 in = 10

HS= 2.193

VS= 2.174

GS= 2.262

CENTROID *

PATTERN #

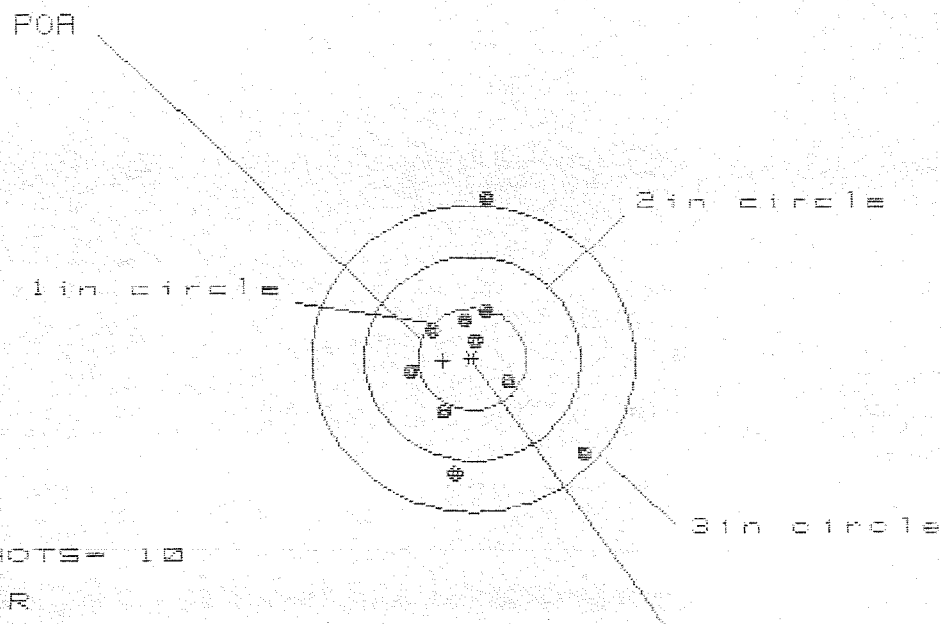
4

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.137	1.214	1.202
MINIMUM X	-1.056	-.979	-.927
MAXIMUM Y	1.094	1.084	1.157
MINIMUM Y	-1.080	-.958	-.885
CENTROID X	.259	.182	.030
CENTROID Y	.176	.054	-.019
POA TO CENTROID in.	.313	.190	.036
MIN RADIUS	.532	.397	.332
MEAN RADIUS	.950	.882	.778
MAX RADIUS	1.297	1.350	1.202
HORIZONTAL SPREAD	2.193	2.193	2.029
VERTICAL SPREAD	2.174	2.042	2.042
EXTREME SPREAD	2.262	2.262	2.142
NUMBER IN ONE INCH CIRCLE =		0	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		10	

6 Jun 1998

FILE:/PATTERNING/CENTERFIRE_PATT/CS498812

CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1in = 4

2in = 7

3in = 9

LS= 1.603

VS= 2.719

CS= 2.735

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.056	1.065	.461
MINIMUM X	:	-.547	-.538	-.405
MAXIMUM Y	:	1.575	.668	.573
MINIMUM Y	:	-1.144	-.969	-1.064
CENTROID X	:	.271	.262	.129
CENTROID Y	:	.019	-.156	-.061
POA TO CENTROID in.	:	.272	.305	.142
MIN RADIUS	:	.196	.341	.307
MEAN RADIUS	:	.724	.643	.525
MAX RADIUS	:	1.577	1.310	1.066
HORIZONTAL SPREAD	:	1.603	1.603	.866
VERTICAL SPREAD	:	2.719	1.637	1.637
EXTREME SPREAD	:	2.735	1.862	1.667
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

Final Inspection

Sn: C6498812

DATE REC'D: 5/15/95

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:

M-24

CONTRACT # DAAA21-87-C-0086

New Barrel
&
Stock

GUN SERIAL #

C6498812

OP. #	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and Stock		5/30/95	RW
600	Proof		5/30/95	RW
607	Check Headspace		5/30/95	RW
610	Dis-assemble Gun		5/30/95	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		6/3/95	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		6/3/95	RW
	C) Inspect Ejector Hole for Chamfer		6/3/95	RW
	D) Oil Firing Pin Ass'y		6/3/95	RW
	E) Adjust Trigger Pull to Min Setting and Stake			

op. #	OP. NAME	READINGS <i>C 6498812</i>	DATE	INIT
625 cont.	F) Safety On Force			
	G) Safety Off Force			
	H) Trigger Pull Test & Retainability			
	I) Firing Pin Indent			
	J) Assemble Stock		<i>6/3/95</i>	<i>RW</i>
	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		<i>6/5/95</i>	<i>RW</i>
	A) Time			
	B) Malfunctions			
	C) Pierced Primers			
	D) Optical Clarity of Scope			
645	Inspect for Live Ammo		<i>6/5/95</i>	<i>RW</i>
655	Final Inspection			
	A) Headspace		<i>6/9/95</i>	<i>RW</i>
	B) Trigger Pull			
	C) Function		<i>6/9/95</i>	<i>RW</i>
660	Pack			

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06498812
11 Jul 1995

CENTROIDAL DISTANCES

0 TO	1	.252448
1 TO	2	.570323
1 TO	3	.288034
1 TO	4	.256416
1 TO	5	.189613

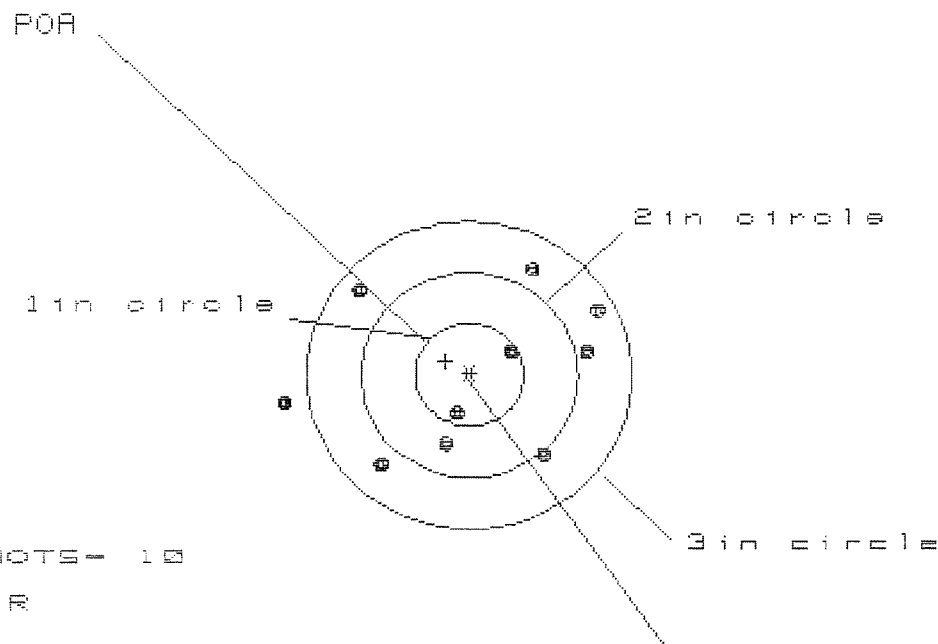
$\bar{x}_1$ <----POI

THE AV. COORDINATE FOR THIS RIFLE IS: .1098
THE AV. COORDINATE FOR THIS RIFLE IS: .0422
THE RES. LARGE POI RADIUS FOR THIS RIFLE IS: .11763
THE AME FOR THIS RIFLE IS: 1.056

11 Jul 1995

FILE:/PATTERNING/CENTERFIRE_PATT/CS498812

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 2

2in = 3

3in = 8

HS= 2.918

VS= 1.841

GS= 3.045

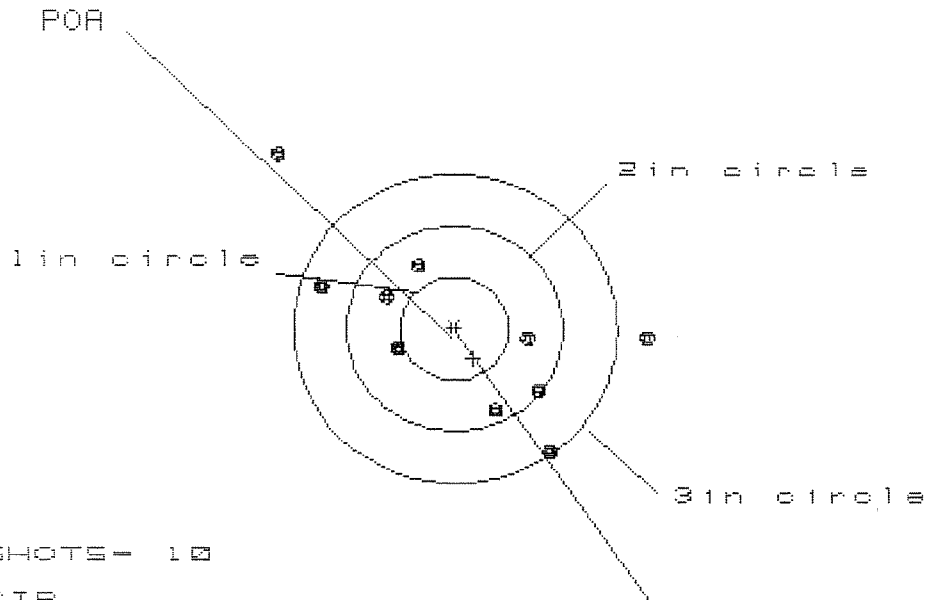
CENTROID *

PATTERN #	:	1	2	3
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.218	1.029	1.027
MINIMUM X	:	-1.700	-1.220	-1.092
MAXIMUM Y	:	.981	.951	1.022
MINIMUM Y	:	-.860	-.890	-.819
CENTROID X	:	.217	.406	.278
CENTROID Y	:	-.129	-.099	-.170
POA TO CENTROID Y	:	.253	.418	.325
MIN RADIUS	:	.374	.278	.367
MEAN RADIUS	:	1.037	.939	.903
MAX RADIUS	:	1.722	1.458	1.395
HORIZONTAL SPREAD	:	2.918	2.249	2.119
VERTICAL SPREAD	:	1.841	1.841	1.841
EXTREME SPREAD	:	3.045	2.475	2.357
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	3		
NUMBER IN THREE INCH CIRCLE	=	9		

11 JUL 1995

FILE:/PATTERNING/CENTERFIRE_PATT/C6498012

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 0

2 in = 6

3 in = 8

HS= 3.415

VS= 2.889

GS= 3.876

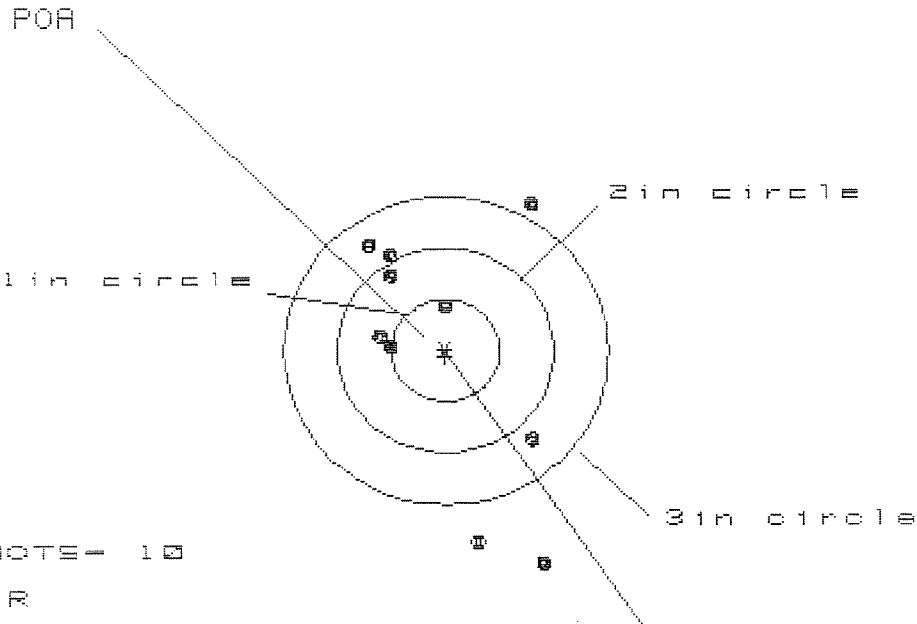
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.761	1.578	.893
MINIMUM X	:	-1.654	-1.420	-1.223
MAXIMUM Y	:	1.719	.787	.797
MINIMUM Y	:	-1.170	-.979	-.969
CENTROID X	:	-.171	.012	-.185
CENTROID Y	:	.289	.098	.088
POA TO CENTROID in.	:	.336	.098	.205
MIN RADIUS	:	.572	.483	.513
MEAN RADIUS	:	1.141	.976	.891
MAX RADIUS	:	2.386	1.579	1.373
HORIZONTAL SPREAD	:	3.415	2.998	2.116
VERTICAL SPREAD	:	2.889	1.766	1.766
EXTREME SPREAD	:	3.876	3.046	2.648
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

11 JUL 1995

FILE:/PATTERNING/CENTERFIRE_PATT/C649B012

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 2

2in = 4

3in = 7

HS= 1.587

VS= 3.453

GS= 3.490

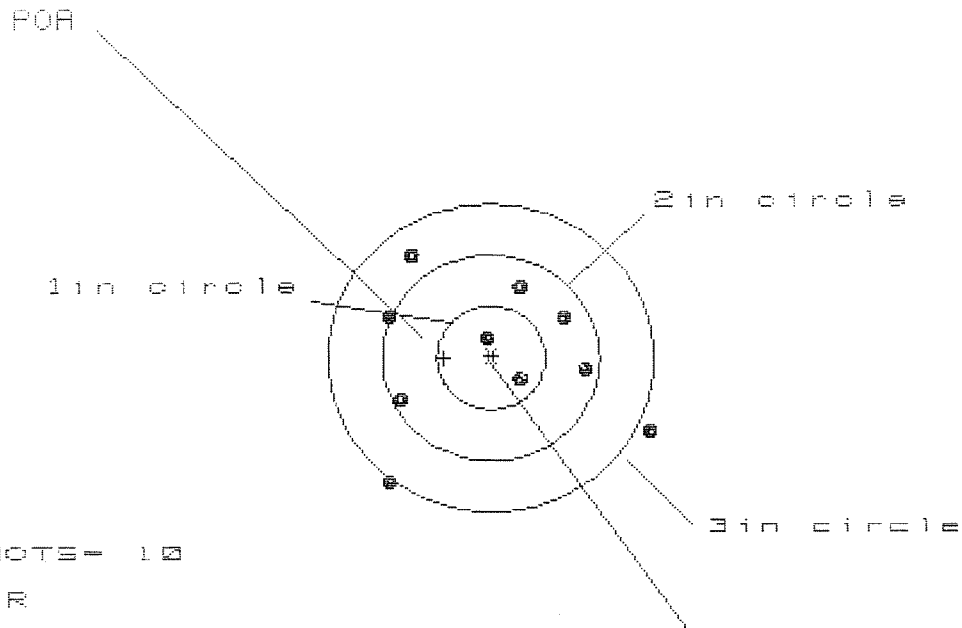
PATTERN #	3	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.883	.934	.987
MINIMUM X	-.704	-.606	-.553
MAXIMUM Y	1.431	1.206	.941
MINIMUM Y	-2.022	-2.121	-1.317
CENTROID X	.004	-.094	-.147
CENTROID Y	.062	.287	.552
POA TO CENTROID in.	.062	.302	.571
MIN RADIUS	.393	.200	.188
MEAN RADIUS	1.163	.965	.760
MAX RADIUS	2.207	2.164	1.596
HORIZONTAL SPREAD	1.587	1.540	1.540
VERTICAL SPREAD	3.453	3.327	2.258
EXTREME SPREAD	3.490	3.365	2.403
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		4	
NUMBER IN THREE INCH CIRCLE =		7	

11 Jul 1995

FILE:/PATTERNING/CENTERFIRE_PATT/CG43B812

CENTERFIRE PATTERNS

4



OF SHOTS= 10

IN CIR

1in = 2

2in = 6

3in = 9

HS= 2.397

VS= 2.218

GS= 2.799

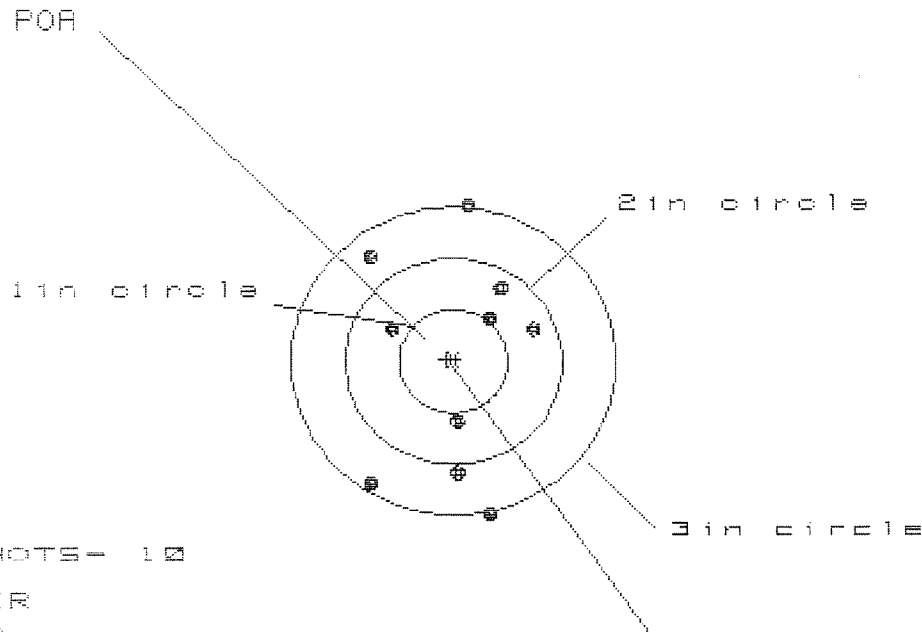
CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.430	1.044	.950
MINIMUM X	:	-.967	-.808	-.902
MAXIMUM Y	:	1.025	.943	.784
MINIMUM Y	:	-1.193	-1.275	-.665
CENTROID X	:	.435	.276	.370
CENTROID Y	:	.006	.008	.247
POA TO CENTROID in.	:	.435	.290	.445
MIN RADIUS	:	.168	.192	.107
MEAN RADIUS	:	.926	.854	.743
MAX RADIUS	:	1.607	1.478	1.052
HORIZONTAL SPREAD	:	2.397	1.852	1.852
VERTICAL SPREAD	:	2.218	2.218	1.449
EXTREME SPREAD	:	2.799	2.237	1.999
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

11 Jul 1995

FILE:/PATTERNING/CENTERFIRE_PATT/0649B812

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 0

2in = 5

3in = 10

HS= 1.506

VS= 2.924

GS= 2.934

CENTROID #

PATTERN #	:	5	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.728	.738	.781
MINIMUM X	:	-.778	-.768	-.725
MAXIMUM Y	:	1.486	1.155	.996
MINIMUM Y	:	-1.438	-1.273	-1.207
CENTROID X	:	.064	.054	.011
CENTROID Y	:	-.017	-.182	-.023
POA TO CENTROID in.	:	.066	.190	.025
MIN RADIUS	:	.551	.413	.578
MEAN RADIUS	:	1.014	.959	.900
MAX RADIUS	:	1.489	1.363	1.408
HORIZONTAL SPREAD	:	1.506	1.506	1.506
VERTICAL SPREAD	:	2.924	2.428	2.203
EXTREME SPREAD	:	2.934	2.653	2.296
NUMBER IN ONE INCH CIRCLE	=	0	0	0
NUMBER IN TWO INCH CIRCLE	=	5	5	5
NUMBER IN THREE INCH CIRCLE	=	10	10	10