

C6522207

MODEL 700TM M24

Model **SMS**TM

Action _____

Barrel Length _____

Capacity _____

Order No. **5716**

*Includes 1 in chamber.



Repair Inquiry

Repair Number: RE00147456

Serial: C6522207 Model M24 SWS Center Fire
Caliber: 7.62 NATO

Repairman:

Verify Repair

Status: Closed 7/9/2008 12:37:33 PM

Address Information

Customer:

☒ Received From

Return To:

☐ Received From

Name: 4/4 ID ATTN: POST ARMS ROOM

4/4 ID ATTN: POST ARMS ROOM

Address 1: POC: BARRY COKER CENT RECEIVING POINT

POC: BARRY COKER CENT RECEIVING POINT

Address 2: 4885 CHILES AVENUE

PO Box:

4885 CHILES AVENUE

PO Box:

City: FT CARSON

FT CARSON

State: CO

Zip Code: 80913

Country: US

State: CO

Zip Code: 80913

Country: US

FFL:

Contact / Condition

Problems

Estimate

History / Status

Shipping / Billing

Contact Information

Received Condition:

Accessories Received:

Phone: NN

Fair

Fax:

Condition:

Email:

Notes:

Comments:

CSR:

Notes:

Code	Desc	Qty
A007	With Stud	3
A008	With Swivel	1
A010	Hard Case	1
A026	Scope	1
D000	MARS RAIL	1

Repair Search

Refresh

Close

naglej

7/9/2008

3:37 PM

CAPS

NUM

INS

SCRL



3:37 PM

Number: **C6522207**
 Model: **M24 SWS**

RE00147456

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

OPERATION #	OPERATION NAME	DATE	INITIAL
500	DIS-ASSEMBLE GUN		
505	RE-BARREL		
560	ASSEMBLE		
600	DIS-ASSEMBLE		
605	CHECK HEADSPACE		
610	DIS-ASSEMBLE GUN		
612	MAGNAFLUX		
510	DRILL AND TAP		
615	ROLLMARK CALIBER		
618	ROTO-BLAST		
620	APPLY COATINGS		
625	FINAL ASSEMBLY		
640	FUNCTION TEST AND	(PASS) FAIL	7-17-08 TRW
650	TARGET	(PASS) FAIL	7-17-08 TRW
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
670	FINAL INSPECTION		
	A) HEADSPACE	(PASS) FAIL	7/17/08 MED 7/18/08 FM 7/18/08 FM
	B) TRIGGER PULL		
	MIN 2.50 LBS MAX 4.0 LBS		
680	F) SAFETY ON FORCE	5 5.5 5	7/18/08 FM
	G) SAFETY OFF FORCE	3.5 3.5 3	7/18/08 FM
	I) FIRING PIN INDENT	.022 .022 .022	7/18/08 FM
690	PACK		7/18/08 FM

MAINTENANCE REQUEST For use of this form, see DA PAM 750-8; the proponent agency is DCS, G-4.				PAGE NO	NO OF PAGES	REQUIREMENT CONTROL SYMBOL CSGLD-1047(R1)	
SECTION I - CUSTOMER DATA				SECTION II - MAINTENANCE ACTIVITY DATA			
1a. UIC CUSTOMER WADJTO	1b. CUSTOMER UNIT NAME HHS 2512	1c. PHONE NO 6-632	3a. WORK ORDER NUMBER (WOM)		3b. SHOP	3c. PHONE NO	
2a. SAMS-2 UIC/SAMS-ITDA	2b. UTILIZATION CODE	2c. MCSR	4a. UIC SUPPORT UNIT		4b. SUPPORT UNIT NAME		
SECTION III - EQUIPMENT DATA							
5. TYPE MNT REQ CODE	6. ID	7. NSN	15a. FAILURE DETECTED DURING/WHEN DISCOVERED CODE (Enter code) See DA Pamphlets 738-750 and 738-751				
8. MODEL M24	10. SERIAL NUMBER 66522207		15b. FIRST INDICATION OF TROUBLE/HOW RECOGNIZED CODE (Enter Code) See DA Pamphlets 738-750 and 738-751		16. MILES/KILOMETERS/HOURS/ROUNDS		
9. NOUN 7.62 bolt ACTION sniper rifle	10b. EIC 466		17. PROJECT CODE (if assigned)		18. ACCOUNT PROCESSING CODE		
10a. ORG WOM/DOC NO	12. QTY 01		19. IN WARRANTY? (enter Y or N)		20. ADMIN NO		
11. SERIAL NUMBER		13. PD 02	21. REIMBURSABLE CUSTOMER (if Intransit customer enter Y or N)		22. LEVEL OF WORK		
14. MALFUNCTION DESCRIPTION (for DSU, GSU/AVIM, DEPOT use)		23. SIGNATURE Cg					
24. DESCRIBE DEFICIENCIES OR SYMPTOMS ON THE BASIS OF COMPLETE CHECKOUT AND DIAGNOSTIC PROCEDURES IN EQUIPMENT TM (Do not prescribe repairs) reset							
25. REMARKS							
PREPARATION INSTRUCTIONS FOR THIS PAGE							
SECTION I				SECTION III (Cont'd)			
Block 1a. Enter UIC of submitting organization. Block 1b. Enter name of submitting organization. Block 1c. Enter number to be called when maint. is completed. Block 2a. Enter UIC of supporting SAMS-2/SAMS-ITDA if work is requested while intransit and away from your support maintenance unit. Block 2b. Enter utilization code. See DA Pamphlets 738-750 and 738-751. Block 2c. Enter "Y" if reportable under AR 700-138. If not, leave blank.				Block 12. Enter the quantity of items being submitted. Block 13. Enter the maintenance priority designator determined from DA PAM 710-2-1. Block 14. For DSU, GSU/AVIM, DEPOT use. Block 15a. Enter the code that most accurately describes when the fault or deficiency was detected. See DA Pamphlets 738-750 and 738-751. Block 15b. Select one. Enter the code. See DA Pamphlets 738-750 and 738-751. Block 16. Enter the accumulated usage data in blocks, when equipment is subject to usage reporting. Block 17. Enter the project code if one has been assigned. If not, leave blank. Block 18. See DA Pamphlets 738-750 and 738-751. Block 19. Enter "Y" or "N" to indicate whether equipment is still under manufacturer's warranty. Block 20. Enter the admin number assigned for property control purposes for the equipment being submitted. Block 21. For DSU/GSU/AVIM/Depot use. Block 22. Enter level of work performed "O" for UNIT LEVEL/AVUM, "F" for DSU/AVIM, "H" for GSU, "D" for DEPOT, "K" for contractor or "L" for Spc Rpr Act. Block 23. Enter the signature of the CO or the CO's designated representative when the priority designator is 01-10. For priority designators 11-15, leave blank. Block 24. Enter a brief description of the deficiencies or symptoms that you feel require attention at this level of maint. Block 25. Self-explanatory.			
SECTION II							
Leave blank. To be completed by the support maintenance DSU/GSU/AVIM/DEPOT.							
SECTION III							
Block 5. Enter the Type Maintenance Request Code. See DA Pamphlets 738-750 and 738-751. Block 6. Enter ID associated with block 7. See DA Pamphlets 738-750 and 738-751. Block 7. Enter the NSN or stock number of the item being submitted. Block 8. Enter model of item being submitted. Block 9. Enter noun/nomenclature of item being submitted. Block 10a. Enter Work Order Number (WOM)/DOC NO assigned when item is submitted. Otherwise, leave blank. Block 10b. Enter End Item Code. See AMDF. Block 11. Enter serial number of item being submitted.							
34a. SUBMITTED BY C-P	35a. ACCEPTED BY	35c. DATE	Block 34a. Enter first initial and last name of submitter. Block 34b. Enter ordinal date submitted (YYDDD). Block 35a. Enter first initial and last name of person accepting maint. request. Block 35b. Enter the initial status. See DA Pamphlets 738-750 and 738-751. Block 35c. Enter ordinal date accepted (YYDDD). Block 35d. Enter military time.				
34b. DATE 27 JUL 03	35b. STATUS	35d. TIME					

DA FORM 2407, JUL 94

PREVIOUS EDITIONS OF DA FORM 2407 AND DA FORM 5504 ARE OBSOLETE

RECEIPT COPY 1

BARBER - M24 0003014
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: **RE00108320** Serial: C6522207 Model M24 SWS Center Fire
 Verify Repair **High Priority** Caliber: 7.62 NATO Repairman: Status: Closed 2/13/2006 2:28:06 PM

Address Information

Customer: ☒ Received From Return To: ☐ Received From
 Name: B CO 2 BSB SHOP OFFICE B CO 2 BSB SHOP OFFICE
 Address 1: 2D BDE 21.D 2D BDE 21.D
 Address 2: PO Box: PO Box:
 City: FORT CARSON FORT CARSON
 State: CO Zip Code: 80913 Country: US State: CO Zip Code: 80913 Country: US
 FFL: ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐

Contact / Condition Problems Estimate History / Status Shipping / Billing

Contact Information

Phone: 719 524 5365
 Fax:
 Email:
 Comments:

Received Condition

Fair
 Condition Notes:
 CSR Notes:

Accessories Received

Code	Desc	Qty
A007	With Stud	3
A016	Scope Rings	2
A017	Scope Base	1
A026	Scope	1
A057	Frt and Rear Sgt Base	1

Repair Search **Refresh** **Close**

naglet 2/13/2006 3:18 PM CAPS NUM INS SERIAL

start Inbox - M... Arms Serv... 3 Intern... Part Search... Microsoft ... 3:18 PM

Serial Number: **C6522207**

Model: **M24 SWS**



RE00108320

BARBER - M24 0003015

MAINTENANCE REQUEST For use of this form, see DA PAM 750-8; the proponent agency is DCS, G-4.				PAGE NO	NO OF PAGES	REQUIREMENT CONTROL SYMBOL CSGLD-1047(R7)	
SECTION I - CUSTOMER DATA				SECTION II - MAINTENANCE ACTIVITY DATA			
1a. UIC CUSTOMER WAFB-0	1b. CUSTOMER UNIT NAME Bldg 2 BSB	1c. PHONE NO 524 1927	3a. WORK ORDER NUMBER (WON)		3b. SHOP	3c. PHONE NO	
2a. SAMS-2 UIC/SAMS-I/TDA	2b. UTILIZATION CODE	2c. MCSR	4a. UIC SUPPORT UNIT		4b. SUPPORT UNIT NAME		
SECTION III - EQUIPMENT DATA							
5. TYPE MNT REQ CODE	6. ID	7. NSN	15a. FAILURE DETECTED DURING/WHEN DISCOVERED CODE (Enter code) See DA Pamphlets 738-750 and 738-751				
8. MODEL m24			15b. FIRST INDICATION OF TROUBLE/HOW RECOGNIZED CODE (Enter Code) See DA Pamphlets 738-750 and 738-751		16. MILES/KILOMETERS/HOURS/ROUNDS M K		
9. NOUN Rifle 7.62					H R		
10a. ORG WON/DOC NO WTFB 265222 07	10b. EIC			17. PROJECT CODE (if assigned)	18. ACCOUNT PROCESSING CODE	19. IN WARRANTY? (enter Y or N)	20. ADMIN NO
11. SERIAL NUMBER 265222 07	12. QTY	13. PD	21. REIMBURSABLE CUSTOMER (if Intransit customer enter Y or N)				
14. MALFUNCTION DESCRIPTION (for DSU, GSU/AVIM, DEPOT use)			22. LEVEL OF WORK		23. SIGNATURE		
24. DESCRIBE DEFICIENCIES OR SYMPTOMS ON THE BASIS OF COMPLETE CHECKOUT AND DIAGNOSTIC PROCEDURES IN EQUIPMENT TM (Do not prescribe repairs)							
25. REMARKS Upgrade A2							
PREPARATION INSTRUCTIONS FOR THIS PAGE							
SECTION I				SECTION III (Cont'd)			
Block 1a. Enter UIC of submitting organization. Block 1b. Enter name of submitting organization. Block 1c. Enter number to be called when maint. is completed. Block 2a. Enter UIC of supporting SAMS-2/SAMS-I/TDA if work is requested while intransit and away from your support maintenance unit. Block 2b. Enter utilization code. See DA Pamphlets 738-750 and 738-751. Block 2c. Enter "Y" if reportable under AR 700-138. If not, leave blank.				Block 12. Enter the quantity of items being submitted. Block 13. Enter the maintenance priority designator determined from DA PAM 710-2-1. Block 14. For DSU, GSU/AVIM, DEPOT use. Block 15a. Enter the code that most accurately describes when the fault or deficiency was detected. See DA Pamphlets 738-750 and 738-751. Block 15b. Select one. Enter the code. See DA Pamphlets 738-750 and 738-751. Block 16. Enter the accumulated usage data in blocks, when equipment is subject to usage reporting. Block 17. Enter the project code if one has been assigned. If not, leave blank. Block 18. See DA Pamphlets 738-750 and 738-751. Block 19. Enter "Y" or "N" to indicate whether equipment is still under manufacturer's warranty. Block 20. Enter the admin number assigned for property control purposes for the equipment being submitted. Block 21. For DSU/GSU/AVIM/Depot use. Block 22. Enter level of work performed "O" for UNIT LEVEL/AVUM, "F" for DSU/AVIM, "H" for GSU, "D" for DEPOT, "K" for contractor or "L" for Spc Rpr Act. Block 23. Enter the signature of the CO or the CO's designated representative when the priority designator is 01-10. For priority designators 11-15, leave blank. Block 24. Enter a brief description of the deficiencies or symptoms that you feel require attention at this level of maint. Block 25. Self-explanatory.			
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34b. DATE	35b. STATUS	35d. TIME					

DA FORM 2407, JUL 94

PREVIOUS EDITIONS OF DA FORM 2407 AND DA FORM 5504 ARE OBSOLETE

RECEIPT COPY 1

[illegible]

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6522207.___0
FILE DATE AND TIME: 04/25/2006 05:51

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.016
The Average Y Centroid of the Five Target Set:	0.061
The Average Point of Impact of the Five Target Set:	0.063
The Average Mean Radius of the Five Target Set:	0.651
The Distance from POA to Centroid Target #1:	0.177
The Distance from Centroid Target #2 to Centroid Target #1:	0.368
The Distance from Centroid Target #3 to Centroid Target #1:	0.123
The Distance from Centroid Target #4 to Centroid Target #1:	0.118
The Distance from Centroid Target #5 to Centroid Target #1:	0.660

BARBER - M24 0003018

SERIAL NUMBER: C6522207. __ 0

TARGET NUMBER: 1

FILE DATE: 04/25/2006

FILE TIME: 05:51

POINT#	X	Y
1:	0.981	-0.016
2:	0.462	-0.262
3:	0.442	0.348
4:	0.223	0.553
5:	0.028	-0.460
6:	-0.100	-0.439
7:	-0.274	-0.343
8:	-0.673	-0.758
9:	-0.517	-0.330
10:	-0.785	-0.048

X CENTROID: -0.021

Y CENTROID: -0.176

POA TO CENTROID: 0.177

HORZ SPREAD: 1.766

VERT SPREAD: 1.311

GROUP SPREAD: 1.813

MIN RADIUS: 0.275

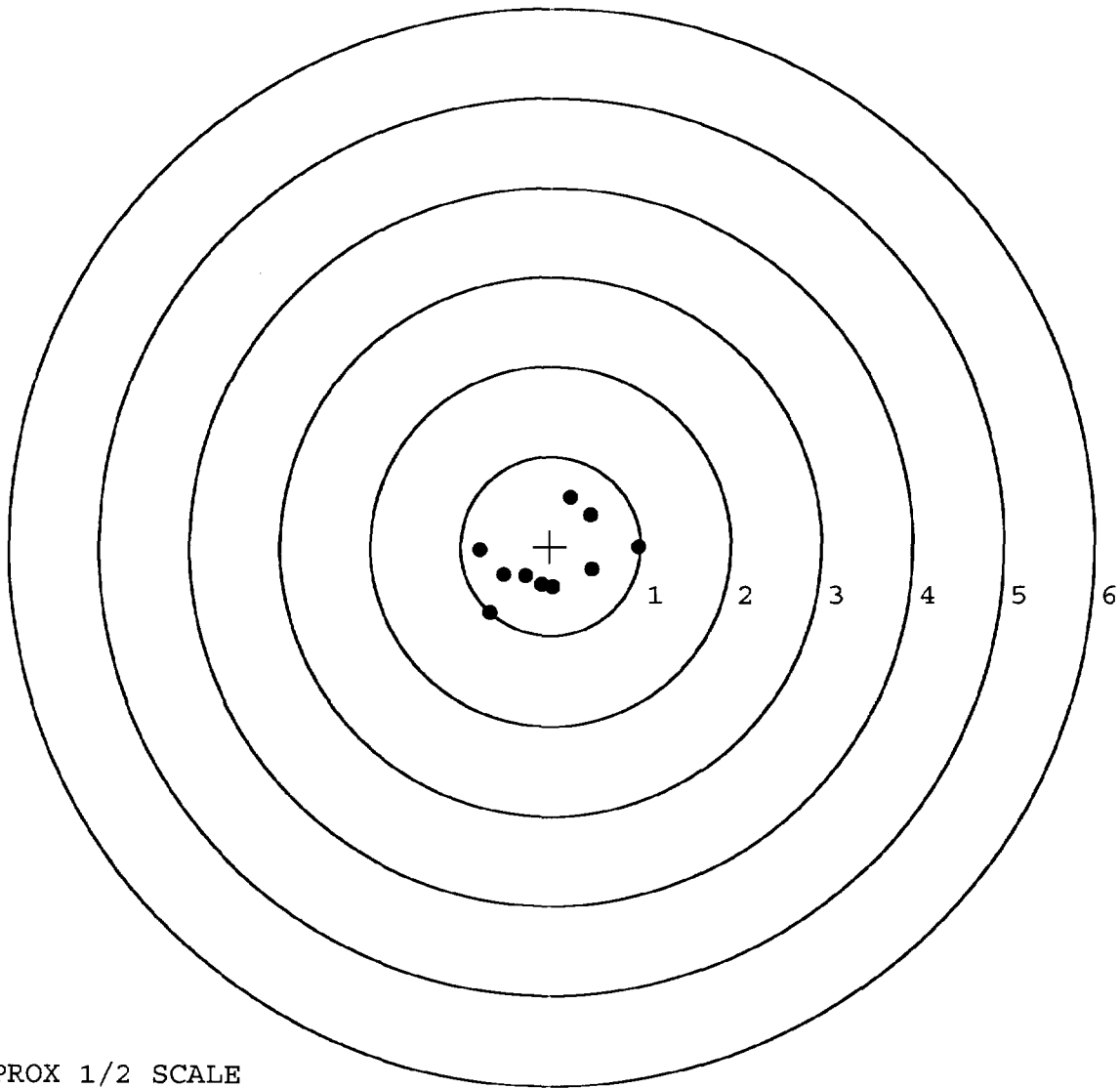
MAX RADIUS: 1.015

MEAN RADIUS: 0.601

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

BARBER - M24 0003019

SERIAL NUMBER: C6522207. __ 0

TARGET NUMBER: 2

FILE DATE: 04/25/2006

FILE TIME: 05:51

POINT#	X	Y
1:	0.454	0.546
2:	0.093	0.663
3:	-0.067	0.294
4:	-0.563	-0.026
5:	-1.298	0.960
6:	-0.140	1.231
7:	0.123	-0.249
8:	-0.233	-0.432
9:	0.075	-0.502
10:	0.147	-0.763

X CENTROID: -0.141

Y CENTROID: 0.172

POA TO CENTROID: 0.222

HORZ SPREAD: 1.752

VERT SPREAD: 1.994

GROUP SPREAD: 2.249

MIN RADIUS: 0.142

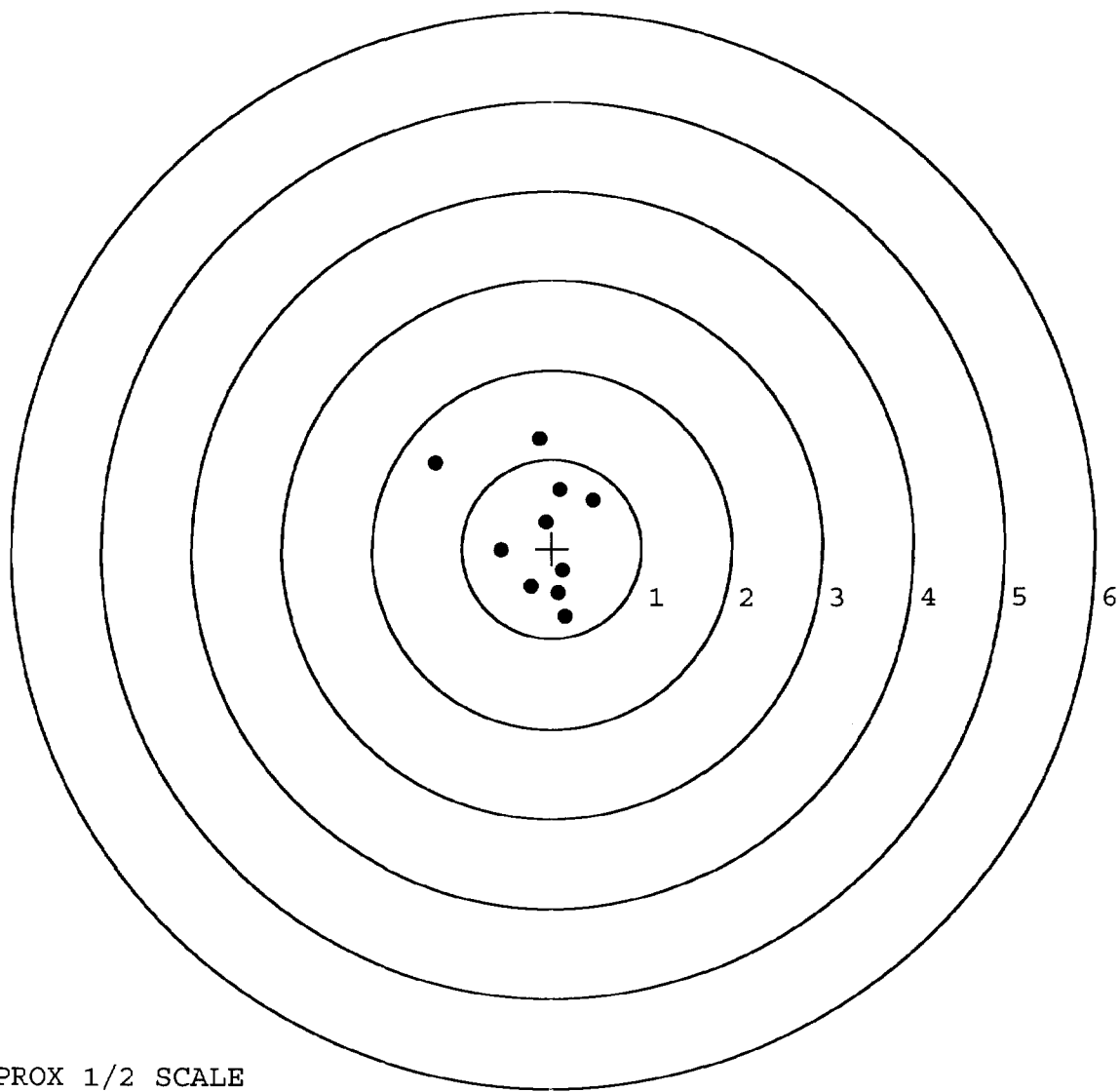
MAX RADIUS: 1.400

MEAN RADIUS: 0.711

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10



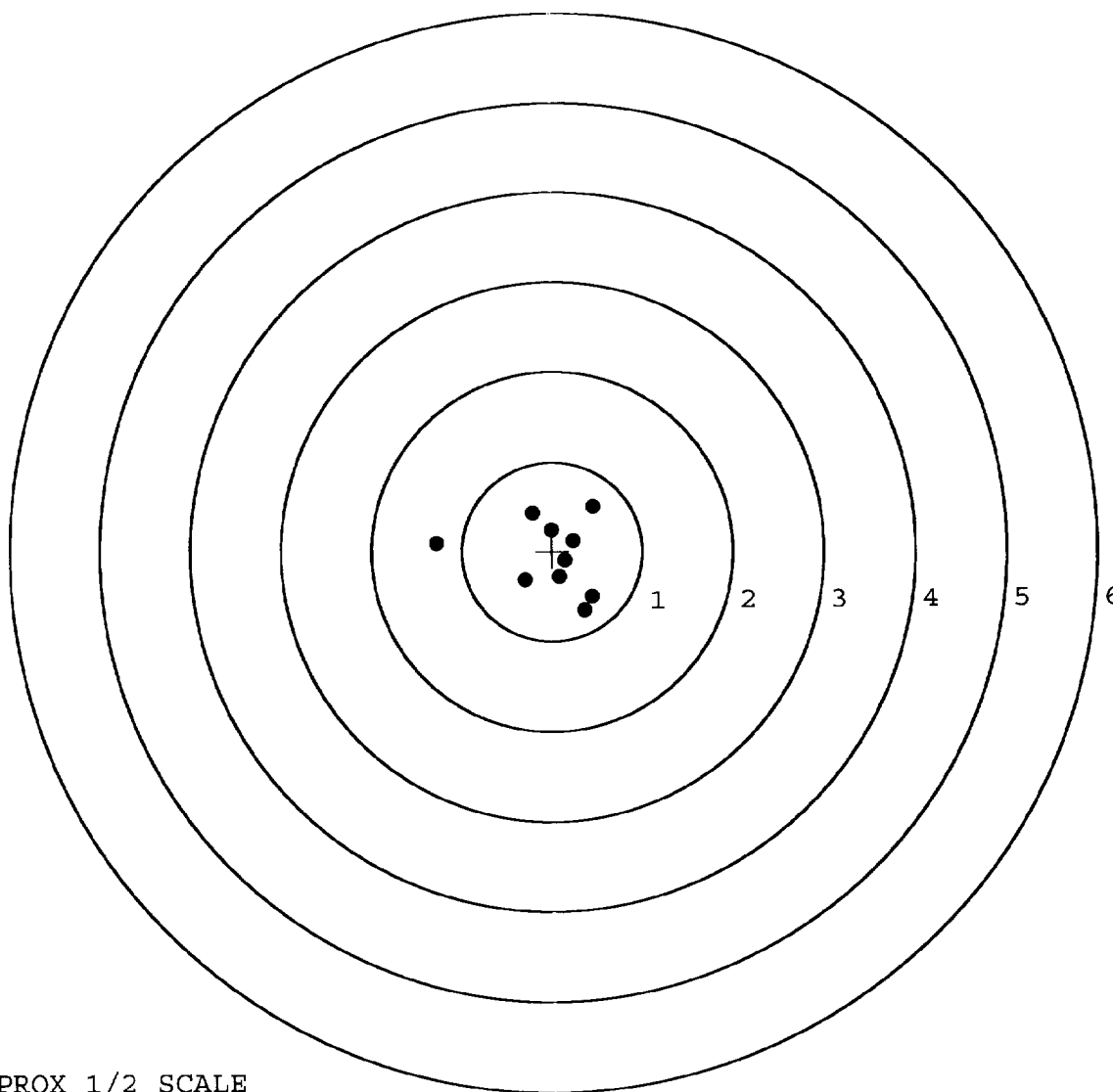
TARGET APPROX 1/2 SCALE

BARBER - M24 0003020

SERIAL NUMBER: C6522207. __0
 TARGET NUMBER: 3
 FILE DATE: 04/25/2006
 FILE TIME: 05:51

POINT#	X	Y
1:	0.460	0.496
2:	-0.215	0.429
3:	-1.281	0.096
4:	-0.013	0.235
5:	0.236	0.117
6:	0.144	-0.113
7:	0.084	-0.290
8:	0.445	-0.510
9:	0.359	-0.666
10:	-0.304	-0.321

X CENTROID: -0.009
 Y CENTROID: -0.053
 POA TO CENTROID: 0.053
 HORZ SPREAD: 1.741
 VERT SPREAD: 1.162
 GROUP SPREAD: 1.829
 MIN RADIUS: 0.164
 MAX RADIUS: 1.281
 MEAN RADIUS: 0.529
 # IN 1 IN DIAMETER: 5
 # IN 2 IN DIAMETER: 9
 # in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

BARBER - M24 0003021

SERIAL NUMBER: C6522207. __ 0

TARGET NUMBER: 4

FILE DATE: 04/25/2006

FILE TIME: 05:51

POINT#	X	Y
1:	0.587	-1.029
2:	0.334	-0.787
3:	0.620	-0.035
4:	0.192	0.840
5:	-0.719	0.112
6:	-0.047	0.417
7:	0.068	-0.048
8:	0.020	-0.427
9:	-0.334	-0.068
10:	-0.117	0.126

X CENTROID: 0.060

Y CENTROID: -0.090

POA TO CENTROID: 0.108

HORZ SPREAD: 1.339

VERT SPREAD: 1.869

GROUP SPREAD: 1.910

MIN RADIUS: 0.043

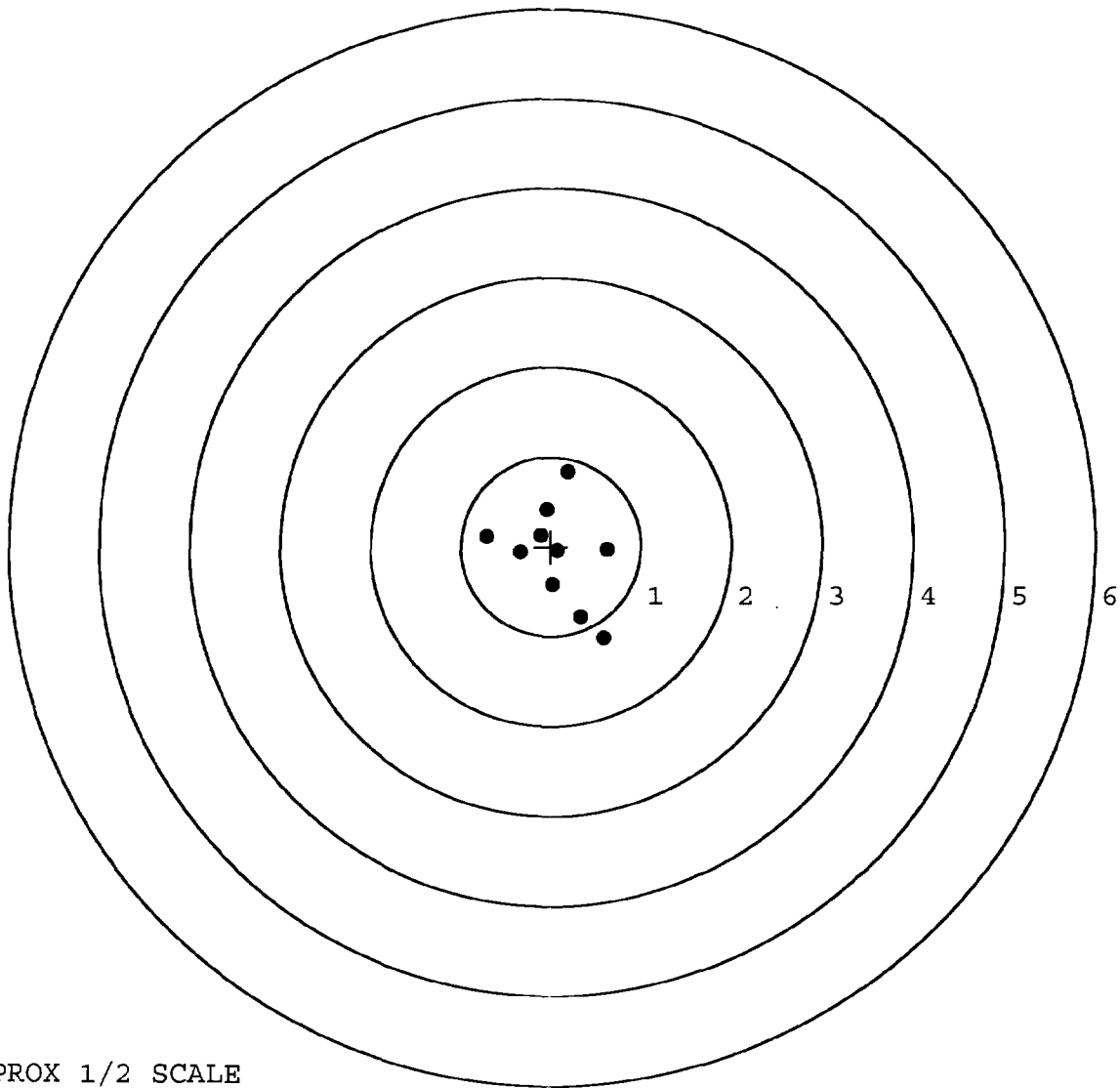
MAX RADIUS: 1.077

MEAN RADIUS: 0.571

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

BARBER - M24 0003022

SERIAL NUMBER: C6522207. __0

TARGET NUMBER: 5

FILE DATE: 04/25/2006

FILE TIME: 05:51

POINT#	X	Y
1:	0.725	1.852
2:	0.572	1.753
3:	-0.103	1.131
4:	0.828	0.660
5:	-0.086	0.322
6:	0.460	0.065
7:	0.005	0.003
8:	0.003	-0.306
9:	-0.094	-0.665
10:	-0.393	-0.324

X CENTROID: 0.192

Y CENTROID: 0.449

POA TO CENTROID: 0.488

HORZ SPREAD: 1.221

VERT SPREAD: 2.517

GROUP SPREAD: 2.647

MIN RADIUS: 0.305

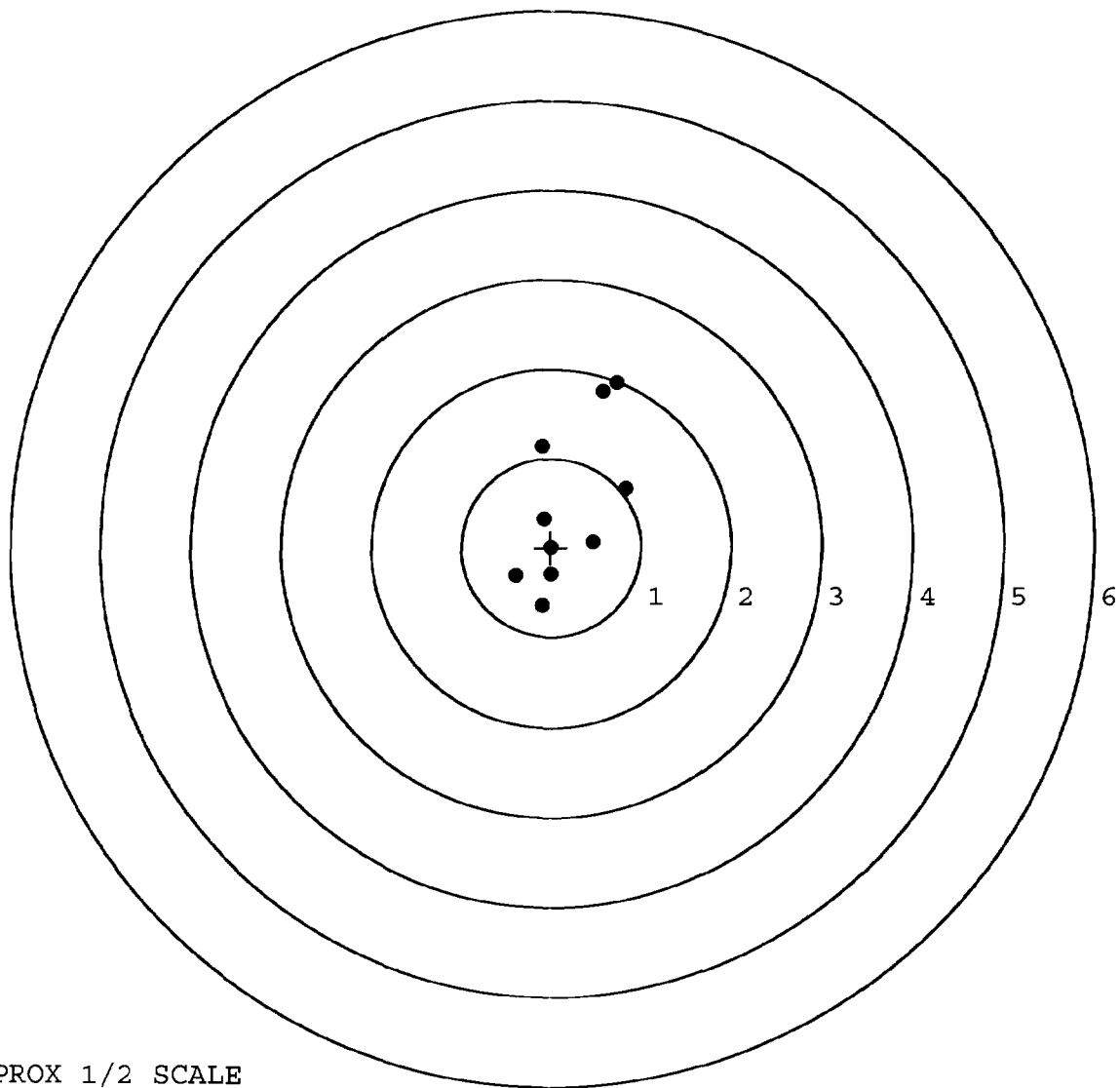
MAX RADIUS: 1.501

MEAN RADIUS: 0.843

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50 LBS (plus or minus 0.50 LBS)

3.00 LBS (plus or minus 0.75 LBS)

4.00 LBS (plus or minus 1.00 LBS)

DATE 4-18-06

TESTER R.P.

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	246	259		252	
PULL #2	248	254		246	
PULL #3	242	259		245	
PULL #4	248	249		246	
PULL #5	240	259		250	
TOTAL	1224	1280		1239	
AVERAGE	244	256		247	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	304	322		
PULL #2	324	318		
PULL #3	323	295		
PULL #4	315	326		
PULL #5	324	326		
TOTAL	1590	1587		
AVERAGE	318	317		

	4.00 LBS INITIAL	4.00 LBS AFTER 20 CYCLES	MAX SETTING GREATER THAN 4 LBS	RESET TO 4 LBS FOR TARGET & ACCURACY
PULL #1	423	403		417
PULL #2	414	402		407
PULL #3	416	396		404
PULL #4	410	404		402
PULL #5	411	401		405
TOTAL	2074	2006		2035
AVERAGE	414	401		407

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

5049

R & E NUMBER	108320				
SERIAL NUMBER	06522207				
LOG-IN DATE	2-13-06				
OPERATION #	OPERATION NAME		DATE	INITIAL	
500	DIS-ASSEMBLE GUN		2-15-06	RTZ	
505	RE-BARREL		4-13-06	RTZ	
560	ASSEMBLE		4-17-06	RTZ	
600	PROOF MAGNA-FLUX		4-19-06	RTZ	
605	CHECK HEADSPACE		4-19-06	RTZ	
610	DIS-ASSEMBLE GUN		4-19-06	RTZ	
612	MAGNAFLUX		4-20-06	APD	
510	DRILL AND TAP		N/A 4-20-06	TRW	
615	ROLLMARK CALIBER		4-20-06	LB	
618	ROTO-BLAST		4-20-06	HP	
620	APPLY COATINGS				
625	FINAL ASSEMBLY		4-25-06	RTZ	
640	FUNCTION TEST AND	PASS	FAIL	4-25-06	TRW
650	TARGET	PASS	FAIL	4-25-06	TRW
	MALFUNCTION	CORRECTION			
	MALFUNCTION	CORRECTION			
	MALFUNCTION	CORRECTION			
	MALFUNCTION	CORRECTION			
670	FINAL INSPECTION				
	A) HEADSPACE	PASS	FAIL	4-25-06	RTZ
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS			
		2.5 3.5 2.4 2.4 2.25	4-25-06	TRW	
680	F) SAFETY ON FORCE	2 LBS MIN 10 LBS			
		6.5 6.5 6.5	4-25-06	TRW	
	G) SAFETY OFF FORCE	2 LBS			
		3.0 3.0 3.0	4-25-06	TRW	
	I) FIRING PIN INDENT	.020			
		.0225 .0215 .0225	4-25-06	TRW	
690	PACK		4-26-06	DA	

Remington [®]		DUPONT REG. U.S. PAT. & TM. OFF.	VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.
MODEL 700 TM H24		SERIAL NO. C6522207	ORDER NO. 5716
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat & Tm. Off, Marca Registrada Marque Deposee.		01	



5716 C6522207

UPC



0 47700 25716 7

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06522207
7 Sep 1990

CENTROIDAL DISTANCES

0 TO	1	.0353553
1 TO	2	.229539
1 TO	3	.287835
1 TO	4	.418007
1 TO	5	.476508

$\frac{S_2}{S_1}$ <----POA

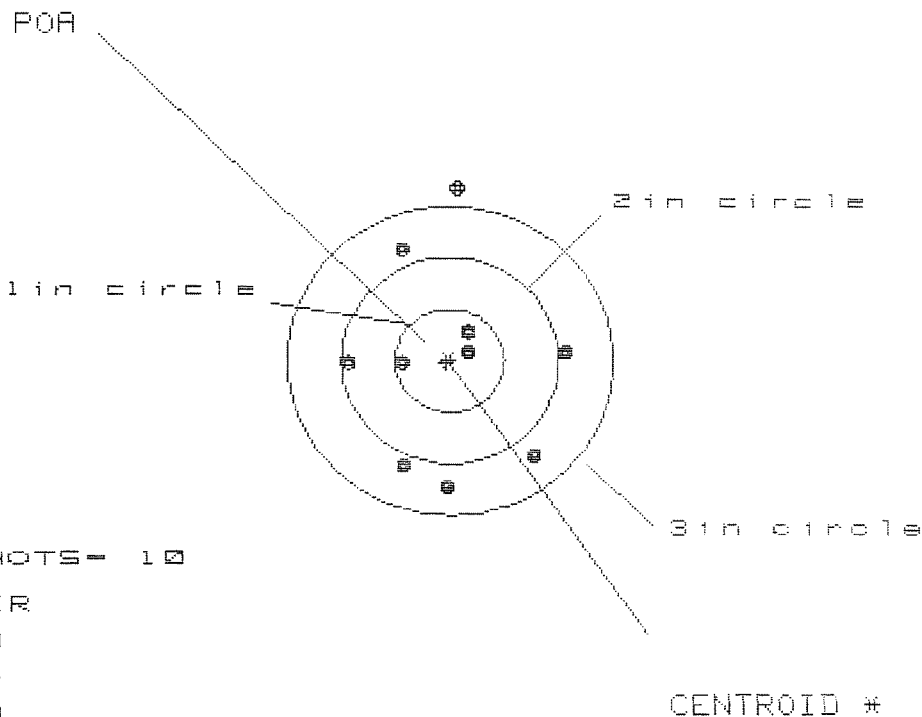
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0672
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .2602
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .268738

THE AMR FOR THIS RIFLE IS: 1.086

7 Sep 1988

FILE:/PATTERNING/CENTERFIRE_PATT/06522207

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 4

3 in = 3

HS= 1.980

VS= 2.917

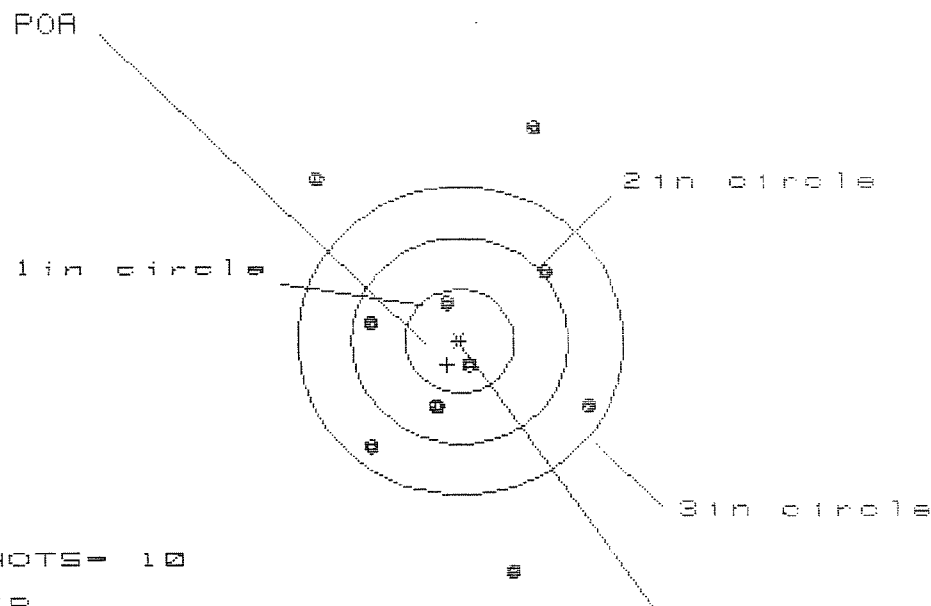
GS= 2.920

PATTERN #	:	1	2	3
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.085	1.091	1.191
MINIMUM X	:	-.895	-.889	-.789
MAXIMUM Y	:	1.720	1.238	1.148
MINIMUM Y	:	-1.197	-1.006	-1.096
CENTROID X	:	.031	.025	-.075
CENTROID Y	:	.017	-.174	-.084
POA TO CENTROID in.	:	.036	.176	.113
MIN RADIUS	:	.193	.315	.332
MEAN RADIUS	:	.926	.841	.794
MAX RADIUS	:	1.721	1.319	1.208
HORIZONTAL SPREAD	:	1.980	1.980	1.980
VERTICAL SPREAD	:	2.917	2.244	2.244
EXTREME SPREAD	:	2.920	2.325	2.278
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		9	

7 Sep 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6522207

CENTERFIRE PATTERNS # 2



OF SHOTS - 10

IN CIR

1 in = 2

2 in = 4

3 in = 7

HS = 2.477

VS = 4.266

QS = 4.271

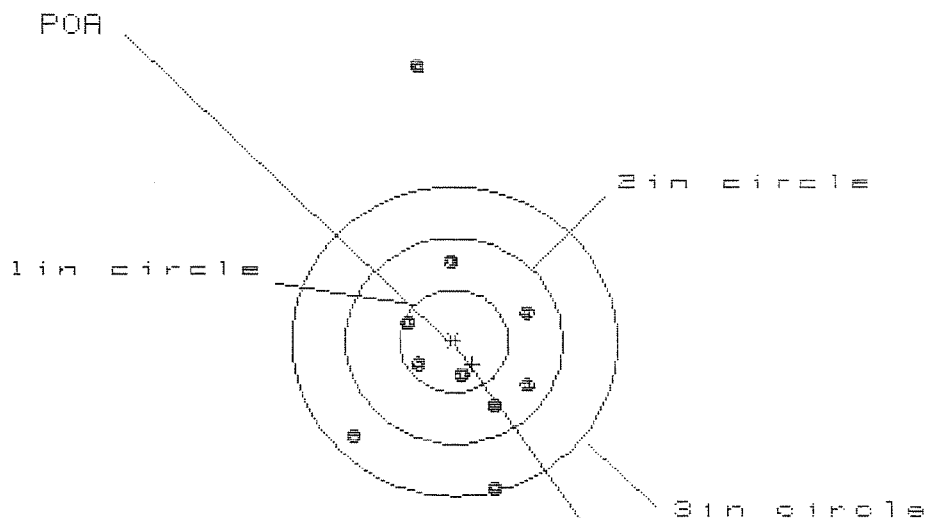
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.194	1.248	1.341
MINIMUM X	:	-1.283	-1.229	-1.136
MAXIMUM Y	:	2.082	1.839	1.607
MINIMUM Y	:	-2.184	-1.275	-1.045
CENTROID X	:	.119	.065	-.028
CENTROID Y	:	.229	.472	.242
POA TO CENTROID in.	:	.258	.476	.243
MIN RADIUS	:	.296	.106	.309
MEAN RADIUS	:	1.231	1.121	.981
MAX RADIUS	:	2.236	1.984	1.968
HORIZONTAL SPREAD	:	2.477	2.477	2.477
VERTICAL SPREAD	:	4.266	3.114	2.652
EXTREME SPREAD	:	4.271	3.474	3.353
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		7	

7 Sep 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6522207

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 7

3 in = 9

HS= 1.629

VS= 4.137

GS= 4.207

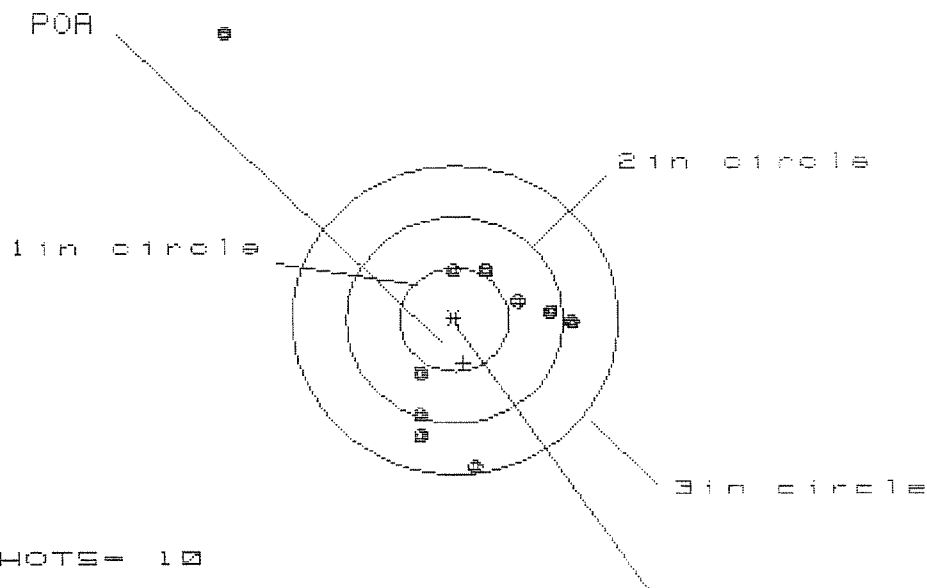
PATTERN #	3		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.693	.652	.695
MINIMUM X	-.936	-.977	-.934
MAXIMUM Y	2.700	1.075	.933
MINIMUM Y	-1.437	-1.137	-.773
CENTROID X	-.169	-.128	-.171
CENTROID Y	.224	-.076	.066
POA TO CENTROID in.	.280	.149	.183
MIN RADIUS	.281	.023	.126
MEAN RADIUS	.965	.715	.654
MAX RADIUS	2.726	1.188	1.212
HORIZONTAL SPREAD	1.629	1.629	1.629
VERTICAL SPREAD	4.137	2.212	1.706
EXTREME SPREAD	4.207	2.256	1.987
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		9	

7 Sep 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6522287

CENTERFIRE PATTERNS

4



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 5

3 in = 9

HS= 3.217

VS= 4.196

GS= 4.792

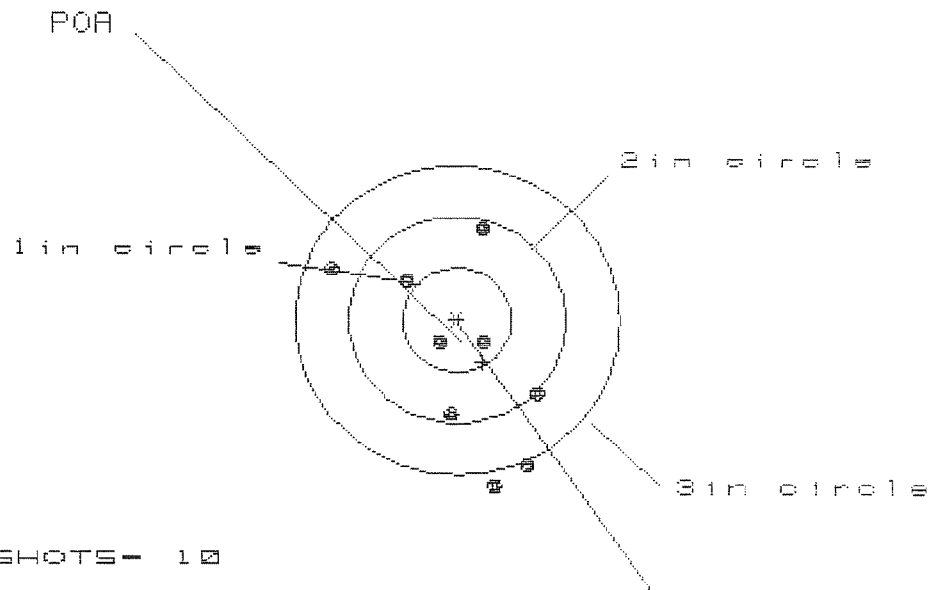
CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.106	.871	.867
MINIMUM X	:	-2.111	-.586	-.590
MAXIMUM Y	:	2.785	.776	.639
MINIMUM Y	:	-1.411	-1.102	-.903
CENTROID X	:	-.080	.155	.159
CENTROID Y	:	.420	.111	.248
POA TO CENTROID in.	:	.428	.190	.295
MIN RADIUS	:	.467	.614	.512
MEAN RADIUS	:	1.125	.812	.755
MAX RADIUS	:	3.495	1.102	1.057
HORIZONTAL SPREAD	:	3.217	1.457	1.457
VERTICAL SPREAD	:	4.196	1.878	1.541
EXTREME SPREAD	:	4.792	1.891	1.775
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

7 Sep 1998

FILE:/PATTERNING/CENTERFIRE_PATT/06522287

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 6

3 in = 7

HS= 1.866

VS= 5.046

GS= 5.097

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.700	.659	.698
MINIMUM X	:	-1.166	-1.207	-1.168
MAXIMUM Y	:	3.404	1.238	1.080
MINIMUM Y	:	-1.642	-1.264	-1.226
CENTROID X	:	-.237	-.196	-.235
CENTROID Y	:	.411	.033	.191
POA TO CENTROID in.	:	.474	.199	.302
MIN RADIUS	:	.215	.249	.127
MEAN RADIUS	:	1.185	.886	.812
MAX RADIUS	:	3.424	1.459	1.391
HORIZONTAL SPREAD	:	1.866	1.866	1.860
VERTICAL SPREAD	:	5.046	2.502	2.396
EXTREME SPREAD	:	5.097	2.625	2.625
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		7	

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6522207

DATE 9-4-90

TESTER WB

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.47	2.23	2.47	2.18	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.38	2.20	2.37	2.09	
PULL #3	2.42	2.33	2.29	2.05	
PULL #4	2.47	2.34	2.19	2.25	
PULL #5	2.32	2.28	2.20	2.11	
TOTAL	12.06	11.38	11.52		
AVG.	2.41	2.27	2.30		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.22	3.44		
PULL #2	3.36	3.51		
PULL #3	3.24	3.46		
PULL #4	3.40	3.43		
PULL #5	3.25	3.44		
TOTAL	16.47	17.28		
AVG.	3.29	3.47		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.16	4.17		4.35
PULL #2	4.17	4.15		4.23
PULL #3	4.13	4.08		4.17
PULL #4	3.96	4.23		4.32
PULL #5	4.04	4.18		4.21
TOTAL	20.46	20.81		21.28
AVG.	4.09	4.16		4.256

C.A.H. TWC

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6522207

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		8-21-90	DB
600	Proof		8-21-90	DB
607	Check Headspace		8-21-90	DB
610	Dis-assemble Gun		8-21-90	DB
612	Magnaflux Barrel Action		8/22/90	KCR
	Magnaflux Bolt		8/22/90	KCR
615	Rollmark Caliber		8/22/90	GB
617	Drill and Tap Sight Holes			
618	Polish Barrel			
620	Apply Coatings (Barrel Action)		8-30-90	TW
	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		9/4/90	WB

op. #	OP. NAME	READINGS			DATE	INIT	
605 at.	F) Safety On Force	4 1/4	4 1/4	4 1/4	9/4/90	WB	
	G) Safety Off Force	7 1/4	7 1/4	7 1/4	9/4/90	WB	
	H) Trigger Pull Test & Retainability				9/4/90	WB	
	I) Firing Pin Indent	.021	.021	.021	9/4/90	WB	
	J) Assemble Stock				9/4/90	KS	
	K) Assemble Swivel Studs				9/8/90	928	
	L) Attach Front and Rear Sight Assemblies				9/4/90	KS	
	M) Iron Sight Alignment				9/4/90	KS	
	N) Detach Front & Rear Sights & place in numbered container				9/4/90	KS	
	O) Attach Scope to Rifle				9/4/90	KS	
	P) Detach & Attach Scope 20 Times				9/4/90	KS	
640	Gallery Target & Test				9/6/90	AF	
	A) Time				9/6/90	AF	
	B) Malfunctions				9/6/90	AF	
	C) Pierced Primers				9/6/90	AF	
	D) Optical Clarity of Scope				9/6/90	AF	
645	Inspect for Live Ammo				9/6/90	AF	
655	Final Inspection						
	A) Headspace				9/8/90	928	
	B) Trigger Pull	218	209	205	225	217	9/8/90
	C) Function				9/8/90	928	
660	Pack				9/9/90	DA	