

UPC



0 47700 25716 7

C6702850

*INCLUDES 1 IN CHAMBER

CAPACITY*

5716

ORDER NO.

BARREL LENGTH

GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6702850

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		5/1/92	RW
600	Proof		5/1/92	RW
607	Check Headspace		5/1/92	RW
610	Dis-assemble Gun		5/1/92	RW
612	Magnaflux Barrel Action	MAY	5 1992	KCD
	Magnaflux Bolt	MAY	5 1992	KCD
615	Rollmark Caliber	MAY	5 1992	CS
617	Drill and Tap Sight Holes	MAY	5 1992	LB
618	Polish Barrel	MAY	5 1992	WB
620	Apply Coatings (Barrel Action)		6-10-92	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		6/13/92	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		6/13/92	RW
	C) Inspect Ejector Hole for Chamfer		6/13/92	RW
	D) Oil Firing Pin Ass'y		6/13/92	RW
	E) Adjust Trigger Pull to Min Setting and Stake		6/17/92	RW

Op. #	BARBER - M24 0105317 OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6.5	6.5	6.5			6/17/92	RW
	G) Safety Off Force	3.5	3.5	3.5			6/17/92	RW
	H) Trigger Pull Test & Retainability						6/17/92	RW
	I) Firing Pin Indent	.0225	.022	.022			6/17/92	RW
	J) Assemble Stock						6/17/92	RW
	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						6/17/92	RW
	P) Detach & Attach Scope 20 Times						6/17/92	RW
640	Gallery Target & Test						6-23-92	DH
	A) Time						6-23-92	DH
	B) Malfunctions						6-23-92	DH
	C) Pierced Primers						6-23-92	DH
	D) Optical Clarity of Scope						6-23-92	DH
645	Inspect for Live Ammo						6-23-92	DH
655	Final Inspection							
	A) Headspace						6/23/92	RW
	B) Trigger Pull	2.71	2.68	2.65	2.61	2.50	6/23/92	RW
	C) Function						6/23/92	RW
660	Pack							

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6702850

DATE 6/17/92

TESTER RW

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.54	2.62	2.43	2.71	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.62	2.59	2.69	2.68	
PULL #3	2.64	2.57	2.67	2.65	
PULL #4	2.65	2.54	2.72	2.61	
PULL #5	2.58	2.59	2.75	2.50	
TOTAL	13.03	129.1	13.26	13.15	
AVG.	2.61	2.58	2.65	2.63	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.19	3.37		
PULL #2	3.16	3.40		
PULL #3	3.29	3.33		
PULL #4	3.28	3.29		
PULL #5	3.27	3.37		
TOTAL	16.19	16.76		
AVG.	3.24	3.35		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.20	4.24		4.10
PULL #2	4.15	4.16		4.20
PULL #3	4.16	4.20		4.19
PULL #4	4.10	4.19		4.24
PULL #5	4.20	4.26		4.26
TOTAL	20.81	21.05		20.99
AVG.	4.16	4.21		4.19

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6702850
25 Jun 1992

CENTROIDAL DISTANCES

0 TO	1	.139703
1 TO	2	.0902441
1 TO	3	.155077
1 TO	4	.27319
1 TO	5	.364671

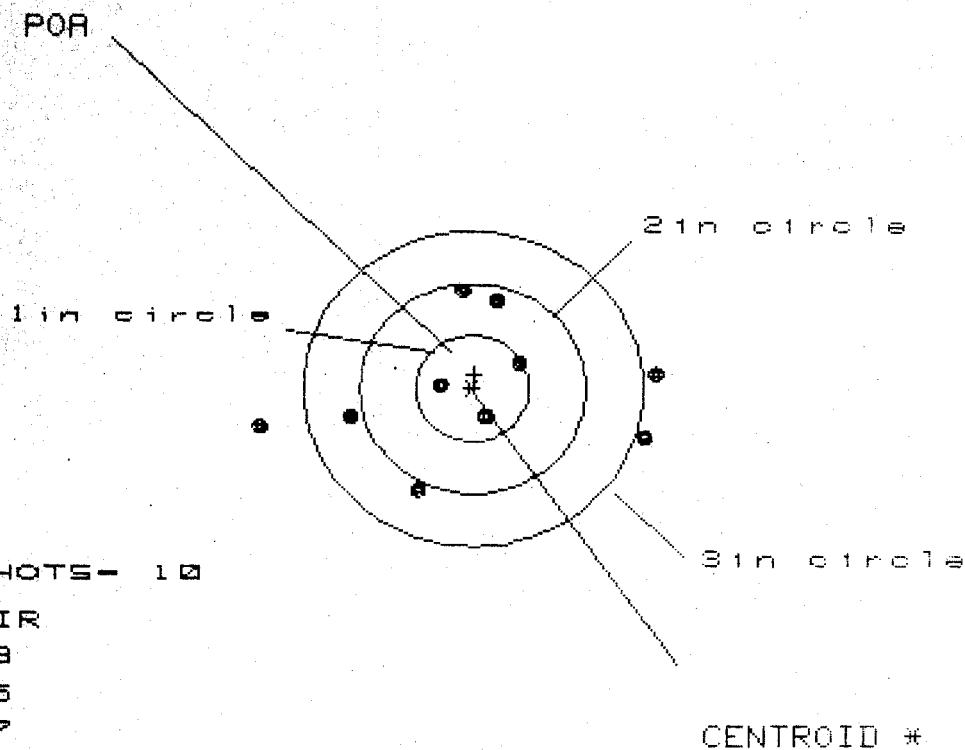
45 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0068
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0043
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .00032346
THE AMR FOR THIS RIFLE IS: 1.051

23 Jun 1992

FILE:/PATTERNING/CENTERFIRE_PATT/C6702850

CENTERFIRE PATTERNS # 1



PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.621	1.410	1.471
MINIMUM X	-1.898	-1.319	-1.142
MAXIMUM Y	.978	.933	.944
MINIMUM Y	-.925	-.970	-.959
CENTROID X	-.014	.197	.020
CENTROID Y	-.139	-.094	-.105
POA TO CENTROID in.	.140	.218	.107
MIN RADIUS	.280	.278	.301
MEAN RADIUS	1.013	.904	.819
MAX RADIUS	1.941	1.413	1.549
HORIZONTAL SPREAD	3.519	2.729	2.613
VERTICAL SPREAD	1.903	1.903	1.903
EXTREME SPREAD	3.561	2.754	2.622
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	7		

23 Jun 1992

FILE: /PATTERNING/CENTERFIRE_PATT/C6702850

CENTERFIRE PATTERNS # 2

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS- 10

IN CIR

1 in = 2

2 in = 6

3 in = 9

HS= 2.774

VS= 2.493

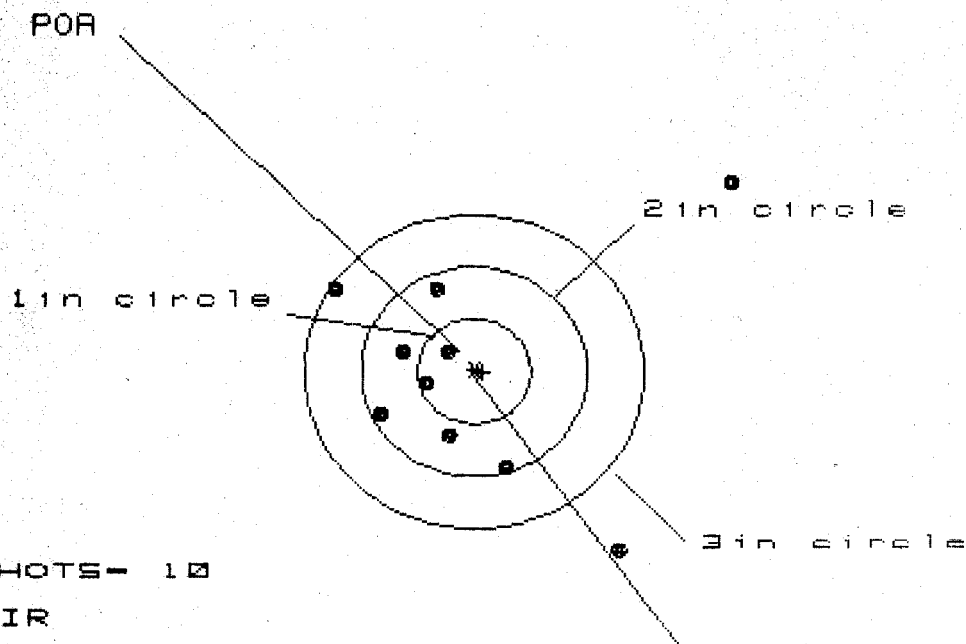
GS= 2.828

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.409	1.460	1.099
MINIMUM X	:	-1.365	-1.314	-1.131
MAXIMUM Y	:	1.559	.989	1.049
MINIMUM Y	:	-.934	-.760	-.700
CENTROID X	:	.006	-.045	-.228
CENTROID Y	:	-.051	-.225	-.285
POA TO CENTROID in.	:	.052	.229	.365
MIN RADIUS	:	.425	.246	.174
MEAN RADIUS	:	1.025	.929	.814
MAX RADIUS	:	1.624	1.538	1.303
HORIZONTAL SPREAD	:	2.774	2.774	2.230
VERTICAL SPREAD	:	2.493	1.749	1.749
EXTREME SPREAD	:	2.828	2.828	2.335
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=			9

23 Jun 1992

FILE:/PATTERNING/CENTERFIRE_PATT/C6702850

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 7

3 in = 8

HS= 3.458

VS= 3.542

GS= 3.807

CENTROID #

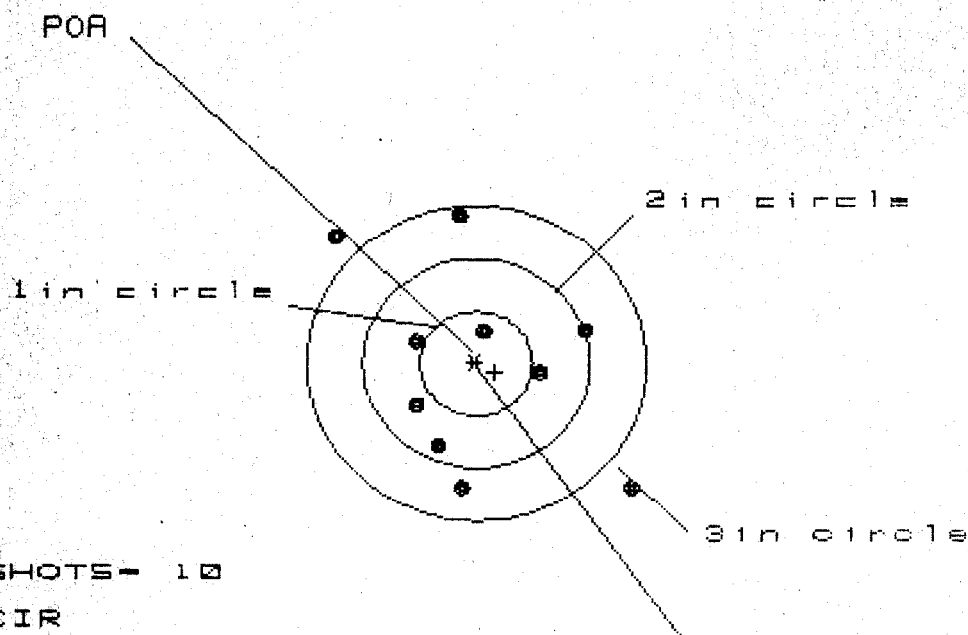
PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.257	1.494	.723
MINIMUM X	:	-1.201	-.951	-.764
MAXIMUM Y	:	1.812	.961	.770
MINIMUM Y	:	-1.730	-1.529	-.866
CENTROID X	:	-.074	-.324	-.511
CENTROID Y	:	.004	-.197	-.006
POA TO CENTROID in.	:	.074	.379	.511
MIN RADIUS	:	.308	.164	.124
MEAN RADIUS	:	1.108	.820	.604
MAX RADIUS	:	2.894	2.138	1.128
HORIZONTAL SPREAD	:	3.458	2.445	1.487
VERTICAL SPREAD	:	3.542	2.490	1.636
EXTREME SPREAD	:	3.807	3.490	2.211
NUMBER IN ONE INCH CIRCLE =	:	2		
NUMBER IN TWO INCH CIRCLE =	:	7		
NUMBER IN THREE INCH CIRCLE =	:	8		

23 Jun 1992

FILE:/PATTERNING/CENTERFIRE_PATT/C6702850

CENTERFIRE PATTERNS

4



OF SHOTS - 10

IN CIR

1 in = 1

2 in = 6

3 in = 8

HS = 2.573

VS = 2.639

GS = 3.487

CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.351	1.071	.937
MINIMUM X	:	-1.222	-1.071	-.549
MAXIMUM Y	:	1.459	1.328	1.458
MINIMUM Y	:	-1.180	-1.284	-1.154
CENTROID X	:	-.166	-.316	-.182
CENTROID Y	:	.088	.219	.089
POA TO CENTROID in.	:	.187	.384	.202
MIN RADIUS	:	.359	.335	.364
MEAN RADIUS	:	1.008	.911	.824
MAX RADIUS	:	1.794	1.494	1.462
HORIZONTAL SPREAD	:	2.573	2.142	1.486
VERTICAL SPREAD	:	2.639	2.612	2.612
EXTREME SPREAD	:	3.487	2.613	2.613
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

28 Jan 1982

FILE:/PATTERNING/CENTERFIRE_PATT/06702350

CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 3

2in = 4

3in = 7

HS = 2.959

VS = 2.956

GS = 4.122

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.527	1.316	1.158
MINIMUM X	:	-1.432	-1.262	-1.232
MAXIMUM Y	:	1.494	1.370	1.219
MINIMUM Y	:	-1.462	-1.296	-1.447
CENTROID X	:	.282	.112	.270
CENTROID Y	:	.074	-.062	.059
POA TO CENTROID in.	:	.292	.145	.276
MIN RADIUS	:	.040	.226	.055
MEAN RADIUS	:	1.099	1.011	.860
MAX RADIUS	:	2.136	1.748	1.513
HORIZONTAL SPREAD	:	2.959	2.578	2.390
VERTICAL SPREAD	:	2.956	2.666	2.666
EXTREME SPREAD	:	4.122	3.043	2.863
NUMBER IN ONE INCH CIRCLE =	:	3		
NUMBER IN TWO INCH CIRCLE =	:	4		
NUMBER IN THREE INCH CIRCLE =	:	7		

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

BARBER - M24 0105324 05363

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: RE00135885

Serial: C6702850 Model M24 SWS Center Fire
Caliber: 7.62 NATO Produced: 10/19/1992

Repairman:

Verify Repair

Status: Closed 10/26/2007 8:26:41 AM

Address Information

Customer:

Received From

Return To:

Received From

Name: US ARDEC RDECOM

US ARDEC RDECOM

Address 1: ROUTE 15 (973-724-4031)

ROUTE 15 (973-724-4031)

Address 2: BLDG. 34 NORTH

PO Box:

BLDG. 34 NORTH

PO Box:

City: PICATINNY ARSENAL

PICATINNY ARSENAL

State: NJ

Zip Code: 07806

Country: US

State: NJ

Zip Code: 07806

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
A017	Scope Base	1
A057	Fit and Rear Sgt Base	1

Repair Search

Refresh

Close

nagletj

10/29/2007

10:57 AM

CAPS

NUM

INS

SCRL



Serial Number: C6702850

Model: M24 SWS



RE00135885

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6702850.__0

FILE DATE AND TIME: 12/13/2007 13:08

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.038
The Average Y Centroid of the Five Target Set:	-0.059
The Average Point of Impact of the Five Target Set:	0.070
The Average Mean Radius of the Five Target Set:	0.641
The Distance from POA to Centroid Target #1:	0.147
The Distance from Centroid Target #2 to Centroid Target #1:	0.135
The Distance from Centroid Target #3 to Centroid Target #1:	0.041
The Distance from Centroid Target #4 to Centroid Target #1:	0.200
The Distance from Centroid Target #5 to Centroid Target #1:	0.235

SERIAL NUMBER: C6702850. 0

TARGET NUMBER: 1

FILE DATE: 12/13/2007

FILE TIME: 13:08

X CENTROID: 0.045

Y CENTROID: -0.140

POA TO CENTROID: 0.147

HORZ SPREAD: 2.370

VERT SPREAD: 3.156

GROUP SPREAD: 3.238

MIN RADIUS: 0.206

MAX RADIUS: 1.732

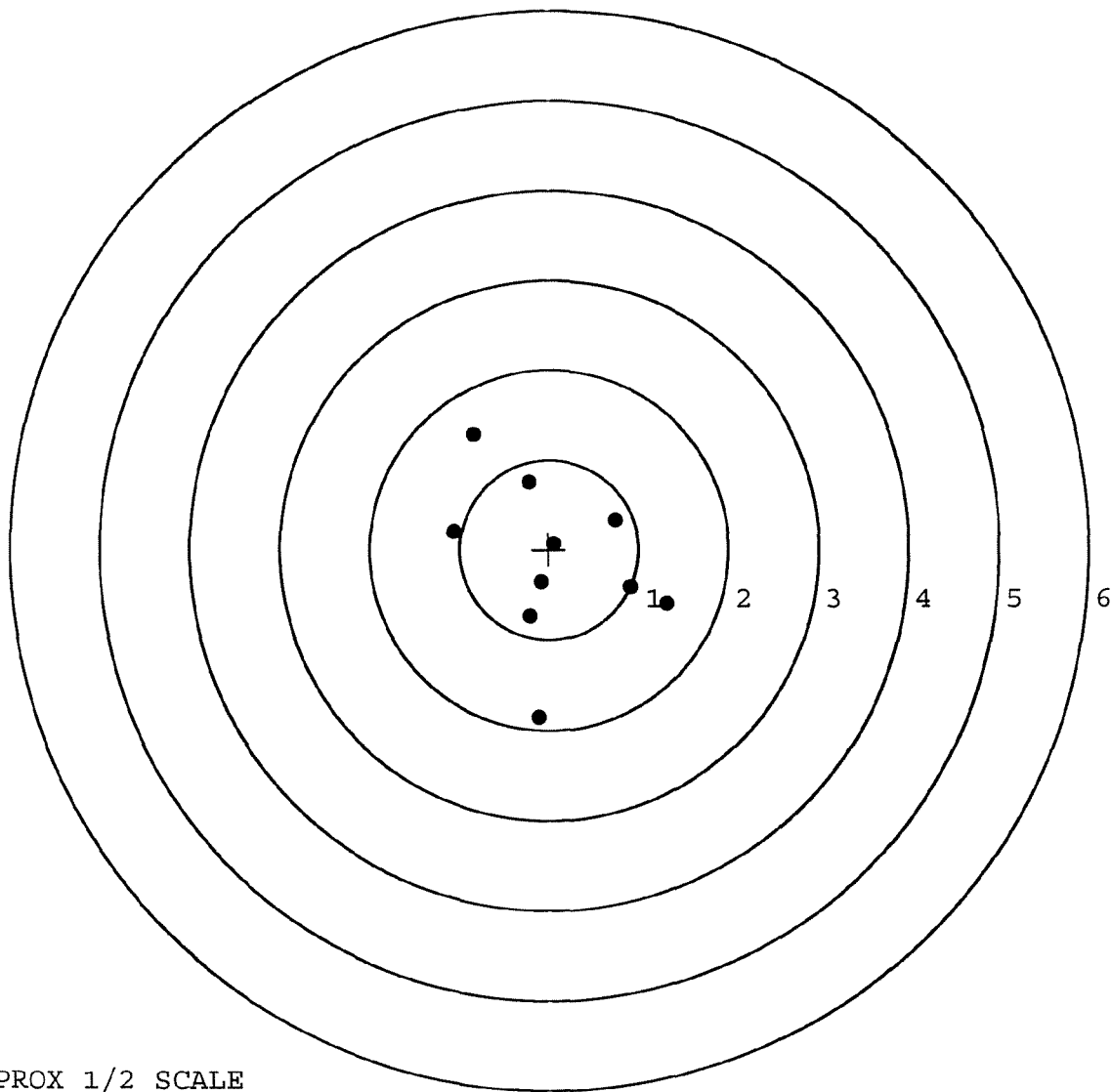
MEAN RADIUS: 0.974

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 8

POINT#	X	Y
1:	-0.122	-1.864
2:	1.309	-0.616
3:	0.907	-0.429
4:	-0.215	-0.751
5:	-0.092	-0.369
6:	0.054	0.066
7:	0.742	0.321
8:	-0.846	1.292
9:	-0.223	0.747
10:	-1.061	0.201



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6702850. __0

TARGET NUMBER: 2

FILE DATE: 12/13/2007

FILE TIME: 13:08

X CENTROID: -0.009

Y CENTROID: -0.016

POA TO CENTROID: 0.019

HORZ SPREAD: 1.319

VERT SPREAD: 1.635

GROUP SPREAD: 1.711

MIN RADIUS: 0.301

MAX RADIUS: 0.954

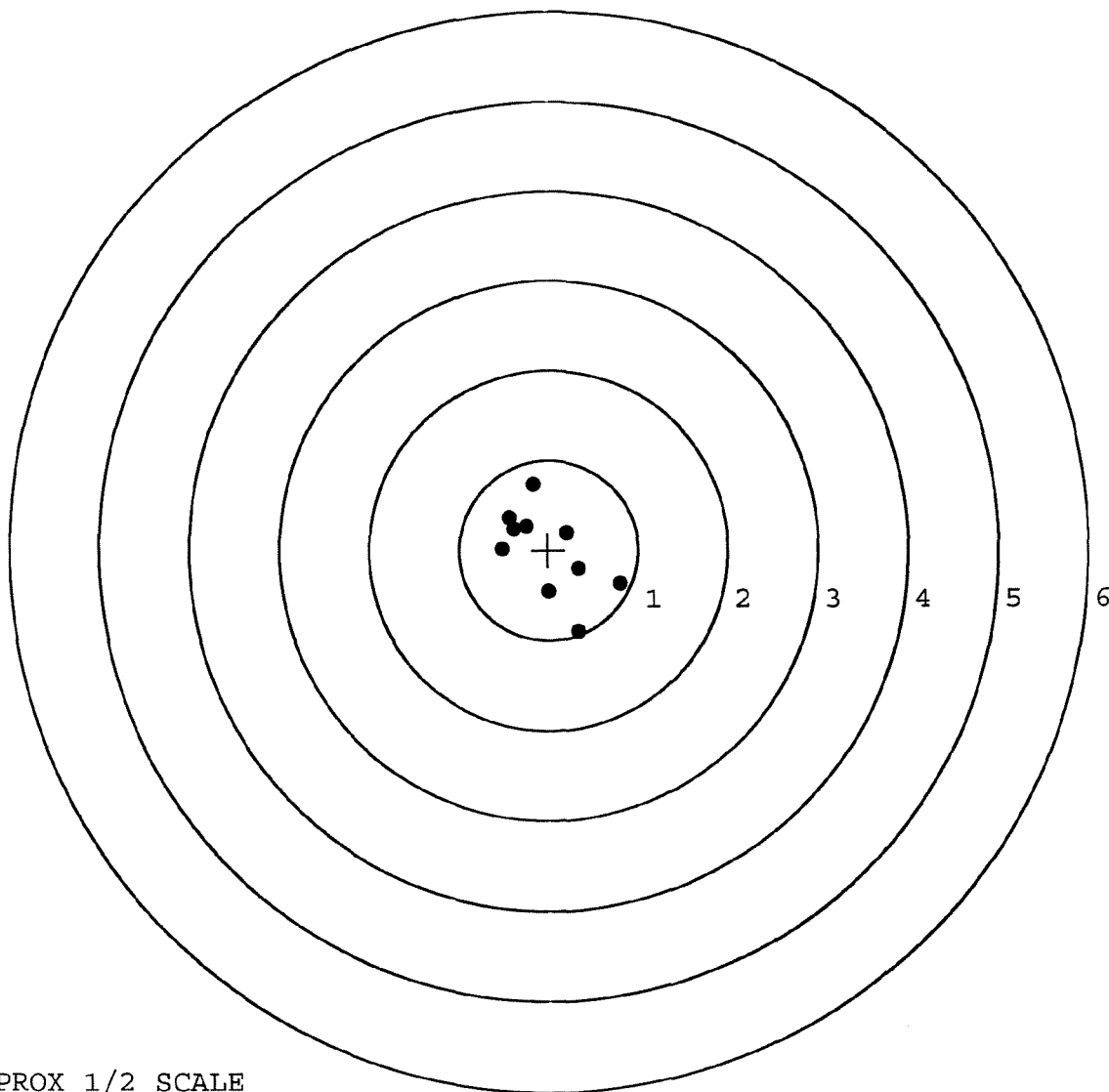
MEAN RADIUS: 0.567

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.332	-0.907
2:	0.000	-0.472
3:	0.805	-0.385
4:	0.334	-0.207
5:	0.206	0.194
6:	-0.514	0.019
7:	-0.247	0.265
8:	-0.445	0.365
9:	-0.171	0.728
10:	-0.390	0.236



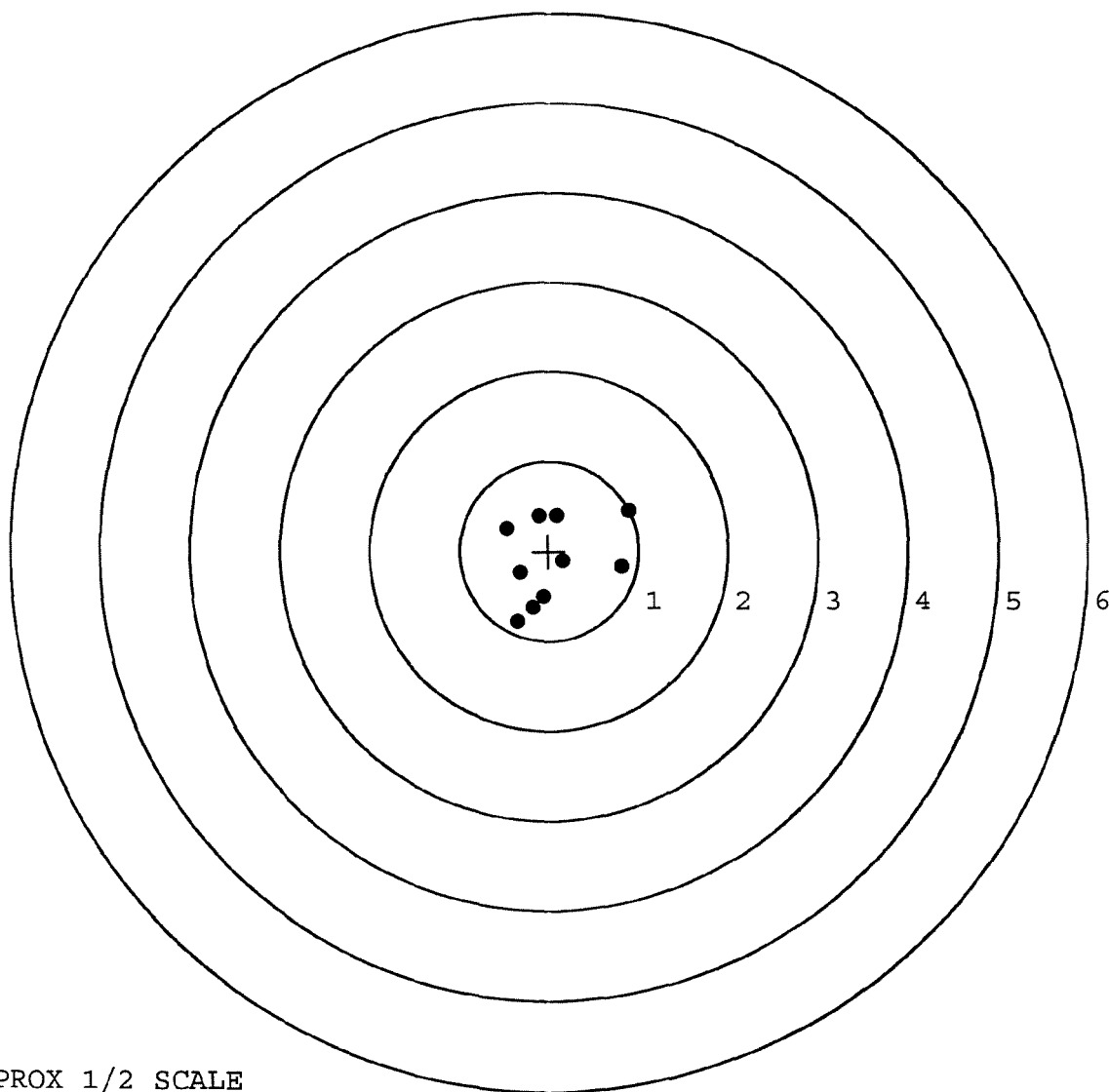
TARGET APPROX 1/2 SCALE

BARBER - M24 0105329

SERIAL NUMBER: C6702850. __0
 TARGET NUMBER: 3
 FILE DATE: 12/13/2007
 FILE TIME: 13:08

POINT#	X	Y
1:	0.815	-0.179
2:	0.888	0.449
3:	0.090	0.394
4:	-0.117	0.391
5:	-0.477	0.251
6:	0.155	-0.109
7:	-0.322	-0.246
8:	-0.055	-0.514
9:	-0.174	-0.639
10:	-0.348	-0.792

X CENTROID: 0.046
 Y CENTROID: -0.099
 POA TO CENTROID: 0.109
 HORZ SPREAD: 1.365
 VERT SPREAD: 1.241
 GROUP SPREAD: 1.752
 MIN RADIUS: 0.110
 MAX RADIUS: 1.005
 MEAN RADIUS: 0.573
 # IN 1 IN DIAMETER: 4
 # IN 2 IN DIAMETER: 9
 # in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

BARBER - M24 0105330

SERIAL NUMBER: C6702850. __0

TARGET NUMBER: 4

FILE DATE: 12/13/2007

FILE TIME: 13:08

POINT#	X	Y
1:	-1.127	0.449
2:	-0.003	0.649
3:	0.469	0.462
4:	-0.114	-0.600
5:	-0.509	-0.691
6:	0.323	-0.170
7:	0.019	0.156
8:	-0.056	-0.072
9:	-0.383	-0.491
10:	0.123	-0.050

X CENTROID: -0.126

Y CENTROID: -0.036

POA TO CENTROID: 0.131

HORZ SPREAD: 1.596

VERT SPREAD: 1.340

GROUP SPREAD: 1.596

MIN RADIUS: 0.079

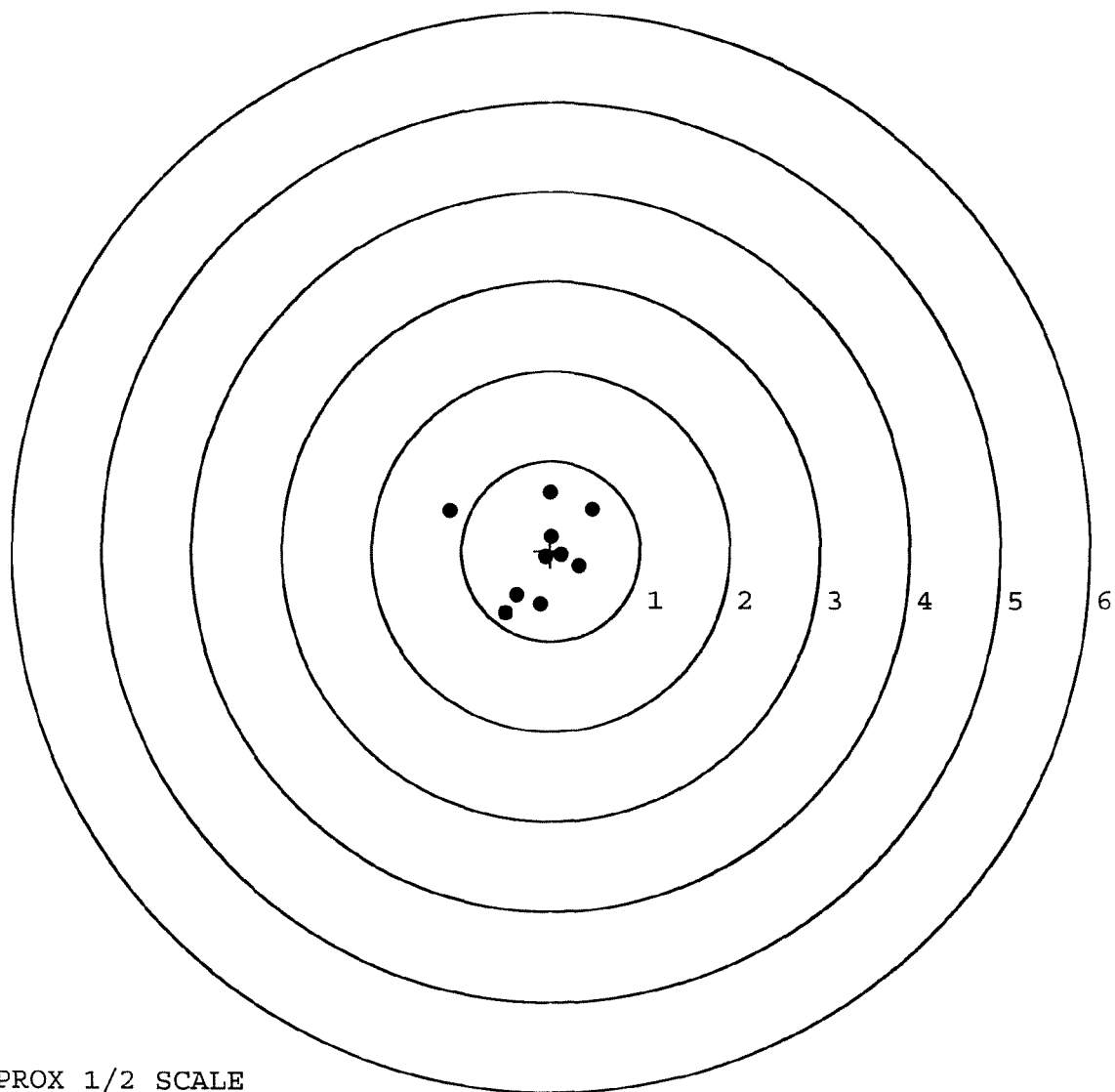
MAX RADIUS: 1.112

MEAN RADIUS: 0.547

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6702850. __0

TARGET NUMBER: 5

FILE DATE: 12/13/2007

FILE TIME: 13:08

X CENTROID: -0.145

Y CENTROID: -0.003

POA TO CENTROID: 0.145

HORZ SPREAD: 1.032

VERT SPREAD: 1.767

GROUP SPREAD: 1.771

MIN RADIUS: 0.140

MAX RADIUS: 1.062

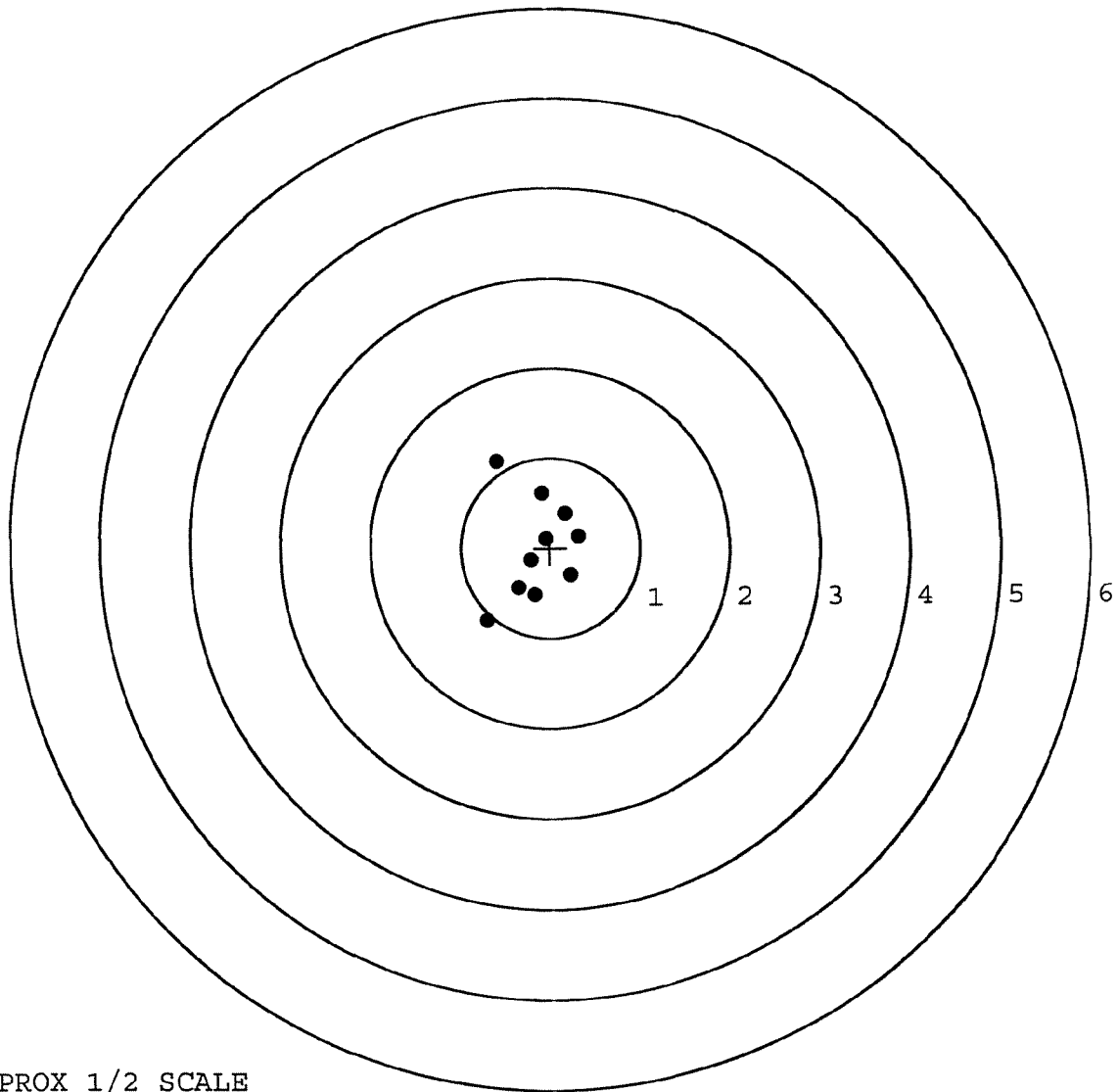
MEAN RADIUS: 0.544

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.591	0.961
2:	-0.708	-0.806
3:	-0.176	-0.525
4:	-0.358	-0.446
5:	0.230	-0.305
6:	-0.216	-0.136
7:	-0.081	0.613
8:	0.324	0.130
9:	0.179	0.383
10:	-0.053	0.103



TARGET APPROX 1/2 SCALE

R & E NUMBER <u>135885</u>			
SERIAL NUMBER <u>C670 2850</u>			
LOG-IN DATE <u>10-26-07</u>			
OPERATION #	OPERATION NAME	DATE	INITIAL
500	DIS-ASSEMBLE GUN	11-13-07	SP
505	RE-BARREL	11-27-07	SP
560	ASSEMBLE	11-27-07	SP
600	PROOF	11-27-07	TRW
605	CHECK HEADSPACE	11-27-07	TRW
610	DIS-ASSEMBLE GUN		
612	MAGNAFLUX	12-04-07	JB
510	DRILL AND TAP	12-3-07	TRW
615	ROLLMARK CALIBER	12-3-07	CW
618	ROTO-BLAST	12-5-07	CH
620	APPLY COATINGS	12-8-07	CM
625	FINAL ASSEMBLY	12-12-07	RTZ
640	FUNCTION TEST AND	(PASS) FAIL	12-13-07 TRW
650	TARGET	(PASS) FAIL	12-13-07 TRW
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
670	FINAL INSPECTION		12-13-07 FM
	A) HEADSPACE	(PASS) FAIL	12-14-07 RA
	B) TRIGGER PULL	278 273 280 273 274	12-14-07 RA
680	F) SAFETY ON FORCE	50 45 45	12-14-07 RA
	G) SAFETY OFF FORCE	35 35 30	12-14-07 RA
	I) FIRING PIN INDENT	.022 .022 .023	12-14-07 RA
690	PACK		12-13-08 FM