

C6349038

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

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: RE00150673

 Serial: C6349038 Model M24 SW/S Center Fire
 Caliber: 7.62 NATO Produced: 06/19/1990

Repairman:

Status: Closed 9/9/2008 10:48:53 AM

Verify Repair

Address Information

Customer:

☒ Received From

Return To:

☐ Received From

Name: HHC 2/8

HHC 2/8

Address 1: BARKELEY AVE

BARKELEY AVE

Address 2: BLDG 2160

PO Box:

BLDG 2160

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: NN

Fax:

Email:

Comments:

Received Condition

Fair

Condition

Notes:

CSR

Notes:

Accessories Received

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

Repair Search

Refresh

Close

nagletj

9/10/2008

10:29 AM

CAPS

NUM

INS

SCRL


 Serial:
 Number: C6349038

Model: M24 SWS



RE00150673

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

R & E NUMBER 150673
 SERIAL NUMBER C6349038
 LOG-IN DATE 9-9-08

OPERATION #	OPERATION NAME	DATE	INITIAL
500	DIS-ASSEMBLE GUN	10-23-08	RTZ
505	RE-BARREL	10-24-08	RTZ
560	ASSEMBLE	10-24-08	RTZ
600	PROOF	10-27-08	SPD
605	CHECK HEADSPACE	10-27-08	SPD
610	DIS-ASSEMBLE GUN	10-27-08	SPD
612	MAGNAFLUX	10/28/08	RTZ
510	DRILL AND TAP	10-28-08	SP
615	ROLLMARK CALIBER	10/29/08	RT
618	ROTO-BLAST		
620	APPLY COATINGS	10 31	
625	FINAL ASSEMBLY	11-4-08	RTZ
640	FUNCTION TEST AND	PASS	FAIL
650	TARGET	PASS	FAIL
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
670	FINAL INSPECTION	11-7-08	TC
	A) HEADSPACE	12-4-08	SPD
		12-4-08	SPD
	B) TRIGGER PULL	2.70 2.71 2.75 2.66 2.64	12-4-08 SPD
	C) SAFETY ON FORCE	30 30 30	12-4-08 SPD
	D) SAFETY OFF FORCE	60 60 60	12-4-08 SPD
	E) FIRING PIN INDENT	.023 .023 .023	12-4-08 SPD
690	PACK	4/2/09	FM

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6349038.__0
FILE DATE AND TIME: 11/07/2008 13:48

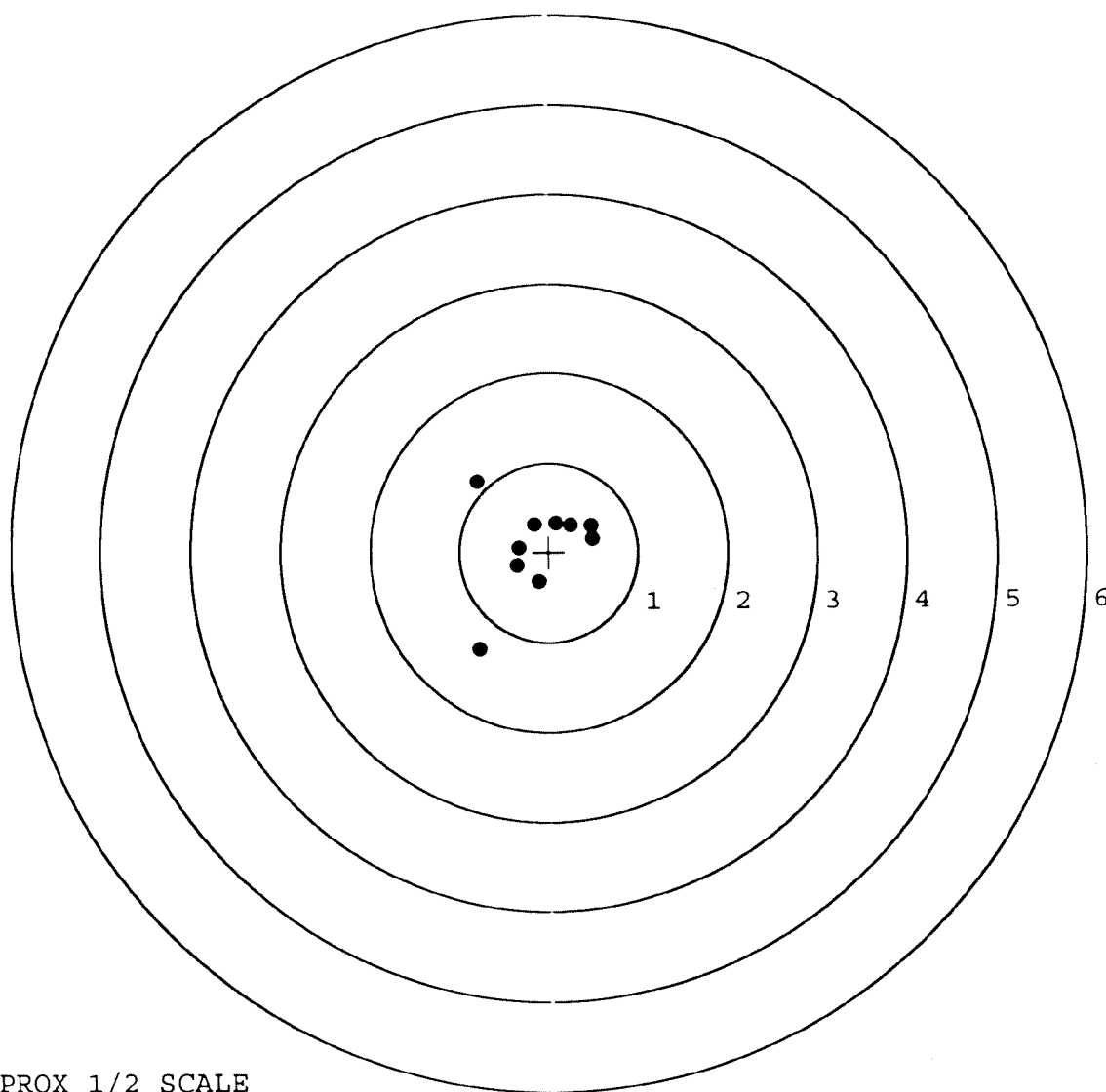
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.083
The Average Y Centroid of the Five Target Set:	0.017
The Average Point of Impact of the Five Target Set:	0.085
The Average Mean Radius of the Five Target Set:	0.618
The Distance from POA to Centroid Target #1:	0.141
The Distance from Centroid Target #2 to Centroid Target #1:	0.175
The Distance from Centroid Target #3 to Centroid Target #1:	0.137
The Distance from Centroid Target #4 to Centroid Target #1:	0.246
The Distance from Centroid Target #5 to Centroid Target #1:	0.138

SERIAL NUMBER: C6349038. __0
 TARGET NUMBER: 1
 FILE DATE: 11/07/2008
 FILE TIME: 13:48

POINT#	X	Y
1:	-0.783	-1.076
2:	-0.799	0.796
3:	0.491	0.149
4:	0.478	0.295
5:	0.250	0.300
6:	0.086	0.321
7:	-0.166	0.307
8:	-0.337	0.047
9:	-0.355	-0.147
10:	-0.115	-0.332

X CENTROID: -0.125
 Y CENTROID: 0.066
 POA TO CENTROID: 0.141
 HORZ SPREAD: 1.290
 VERT SPREAD: 1.872
 GROUP SPREAD: 1.872
 MIN RADIUS: 0.213
 MAX RADIUS: 1.318
 MEAN RADIUS: 0.552
 # IN 1 IN DIAMETER: 6
 # IN 2 IN DIAMETER: 9
 # in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6349038. 0

TARGET NUMBER: 2

FILE DATE: 11/07/2008

FILE TIME: 13:48

X CENTROID: -0.258

Y CENTROID: -0.048

POA TO CENTROID: 0.263

HORZ SPREAD: 1.874

VERT SPREAD: 1.845

GROUP SPREAD: 2.630

MIN RADIUS: 0.106

MAX RADIUS: 1.392

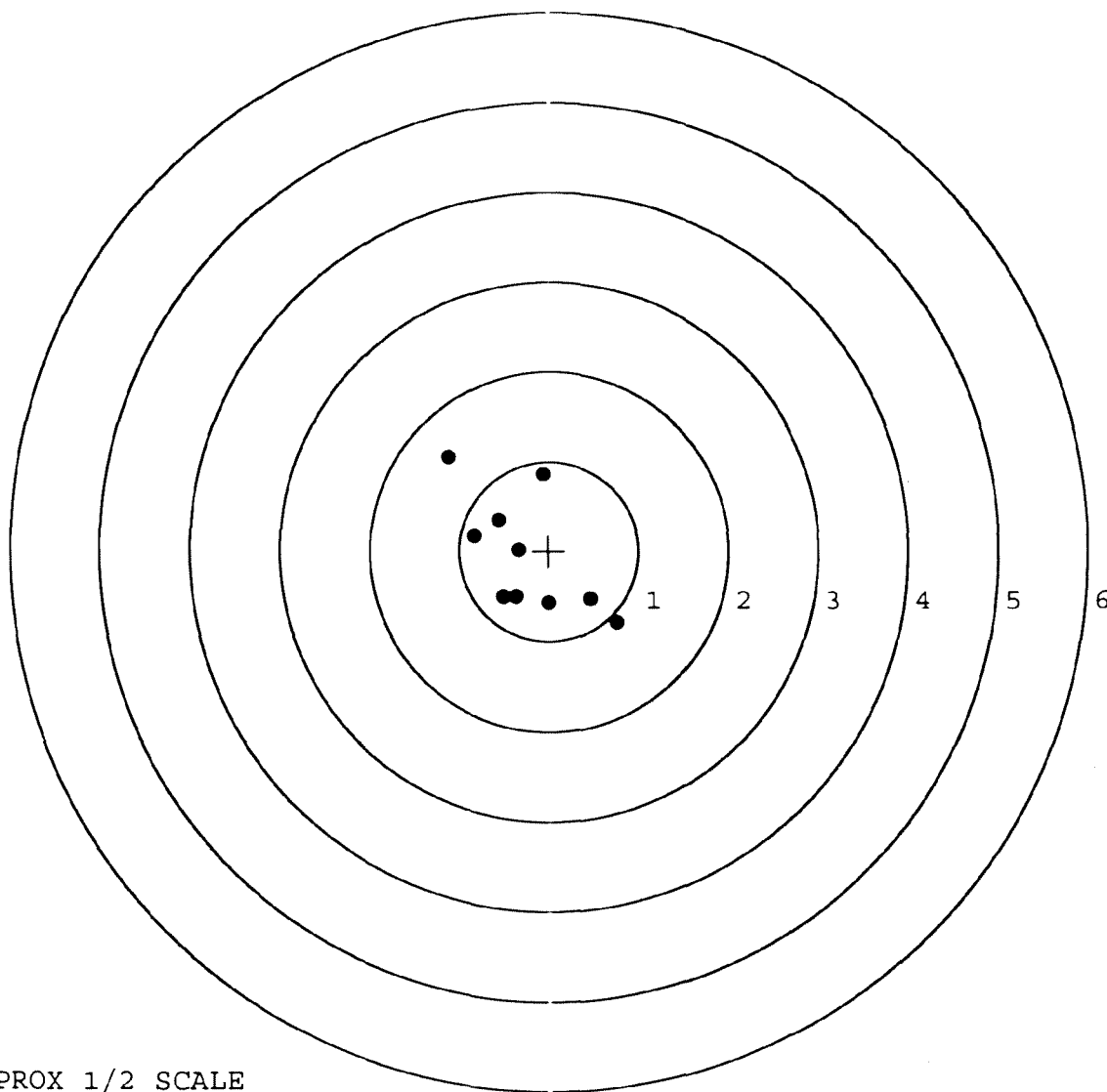
MEAN RADIUS: 0.726

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-1.116	1.049
2:	-0.061	0.855
3:	0.758	-0.796
4:	0.464	-0.534
5:	-0.012	-0.584
6:	-0.372	-0.508
7:	-0.509	-0.508
8:	-0.832	0.179
9:	-0.565	0.349
10:	-0.340	0.020



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6349038. __0

TARGET NUMBER: 3

FILE DATE: 11/07/2008

FILE TIME: 13:48

POINT#	X	Y
1:	-0.323	-0.657
2:	0.197	-0.676
3:	0.148	-0.420
4:	-0.299	-0.076
5:	-0.592	0.623
6:	-0.182	0.613
7:	0.658	0.244
8:	0.263	0.335
9:	0.172	0.251
10:	0.066	0.209

X CENTROID: 0.011

Y CENTROID: 0.045

POA TO CENTROID: 0.046

HORZ SPREAD: 1.250

VERT SPREAD: 1.299

GROUP SPREAD: 1.520

MIN RADIUS: 0.173

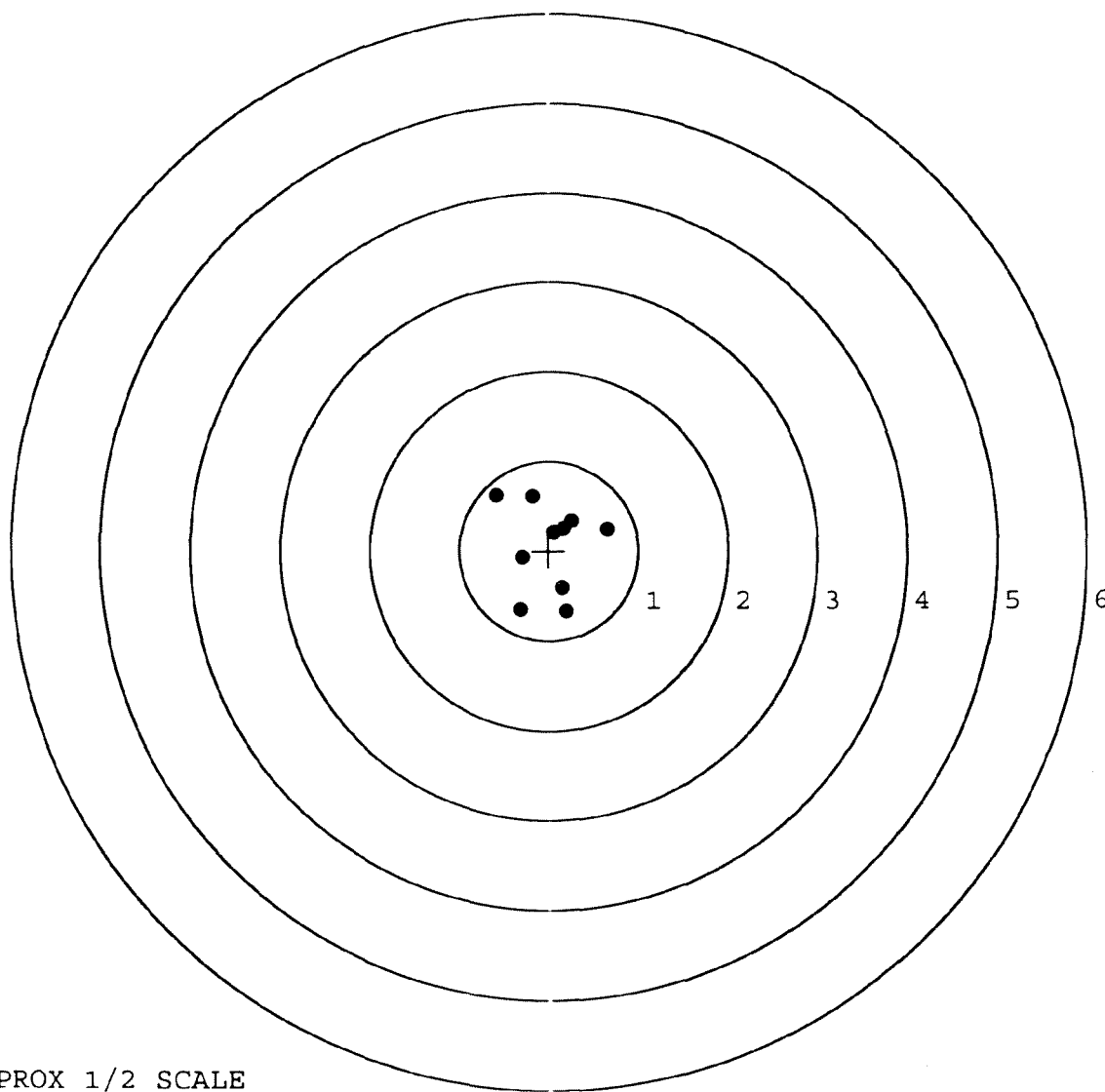
MAX RADIUS: 0.835

MEAN RADIUS: 0.527

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6349038. 0

TARGET NUMBER: 4

FILE DATE: 11/07/2008

FILE TIME: 13:48

X CENTROID: -0.007

Y CENTROID: -0.150

POA TO CENTROID: 0.150

HORZ SPREAD: 1.286

VERT SPREAD: 2.263

GROUP SPREAD: 2.470

MIN RADIUS: 0.111

MAX RADIUS: 1.472

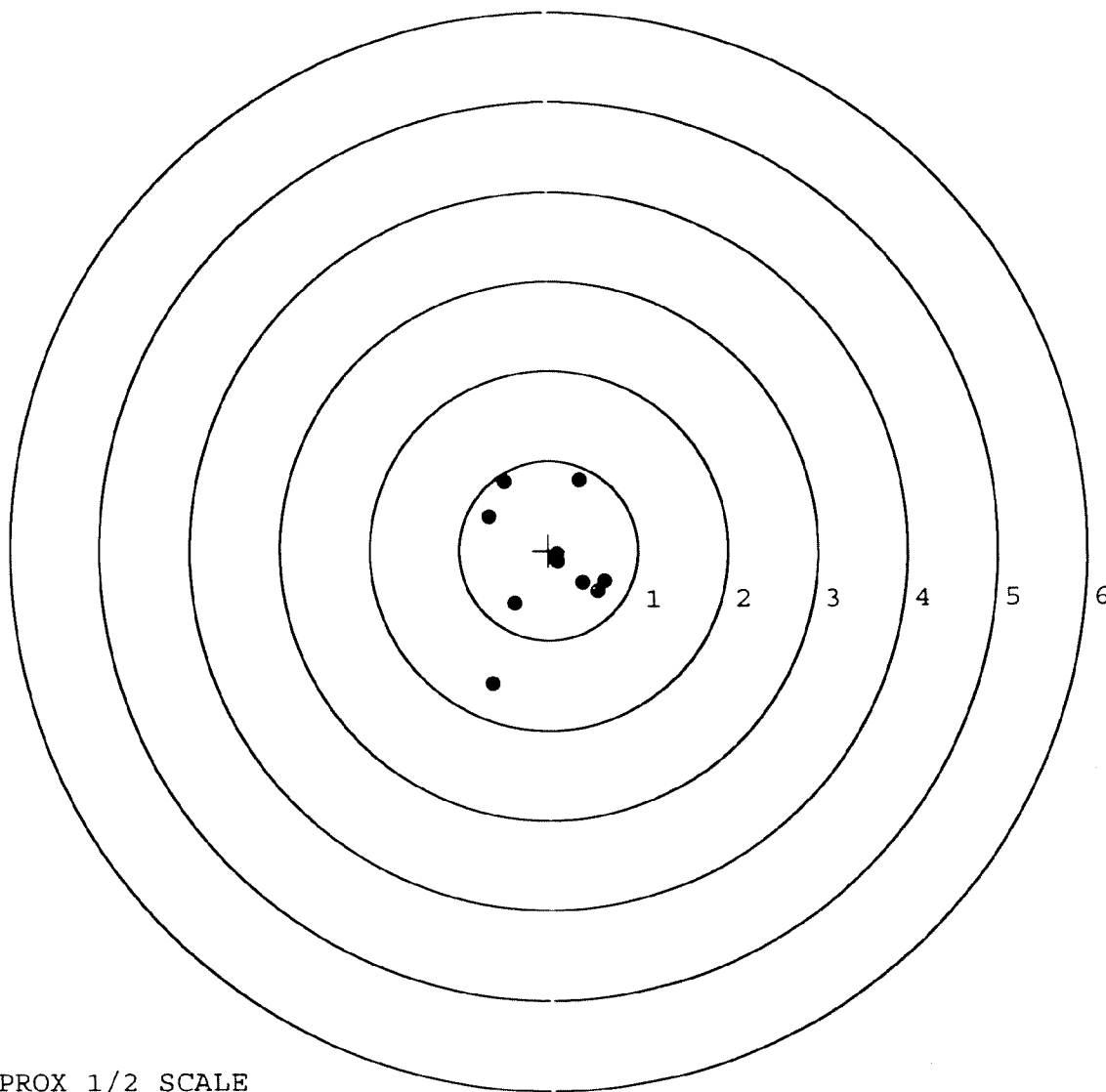
MEAN RADIUS: 0.694

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.636	-1.481
2:	-0.383	-0.599
3:	-0.662	0.384
4:	-0.492	0.767
5:	0.353	0.782
6:	0.624	-0.347
7:	0.547	-0.465
8:	0.382	-0.365
9:	0.103	-0.133
10:	0.094	-0.045



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6349038. 0

TARGET NUMBER: 5

FILE DATE: 11/07/2008

FILE TIME: 13:48

X CENTROID: -0.037

Y CENTROID: 0.173

POA TO CENTROID: 0.177

HORZ SPREAD: 1.320

VERT SPREAD: 1.332

GROUP SPREAD: 1.874

MIN RADIUS: 0.195

MAX RADIUS: 1.041

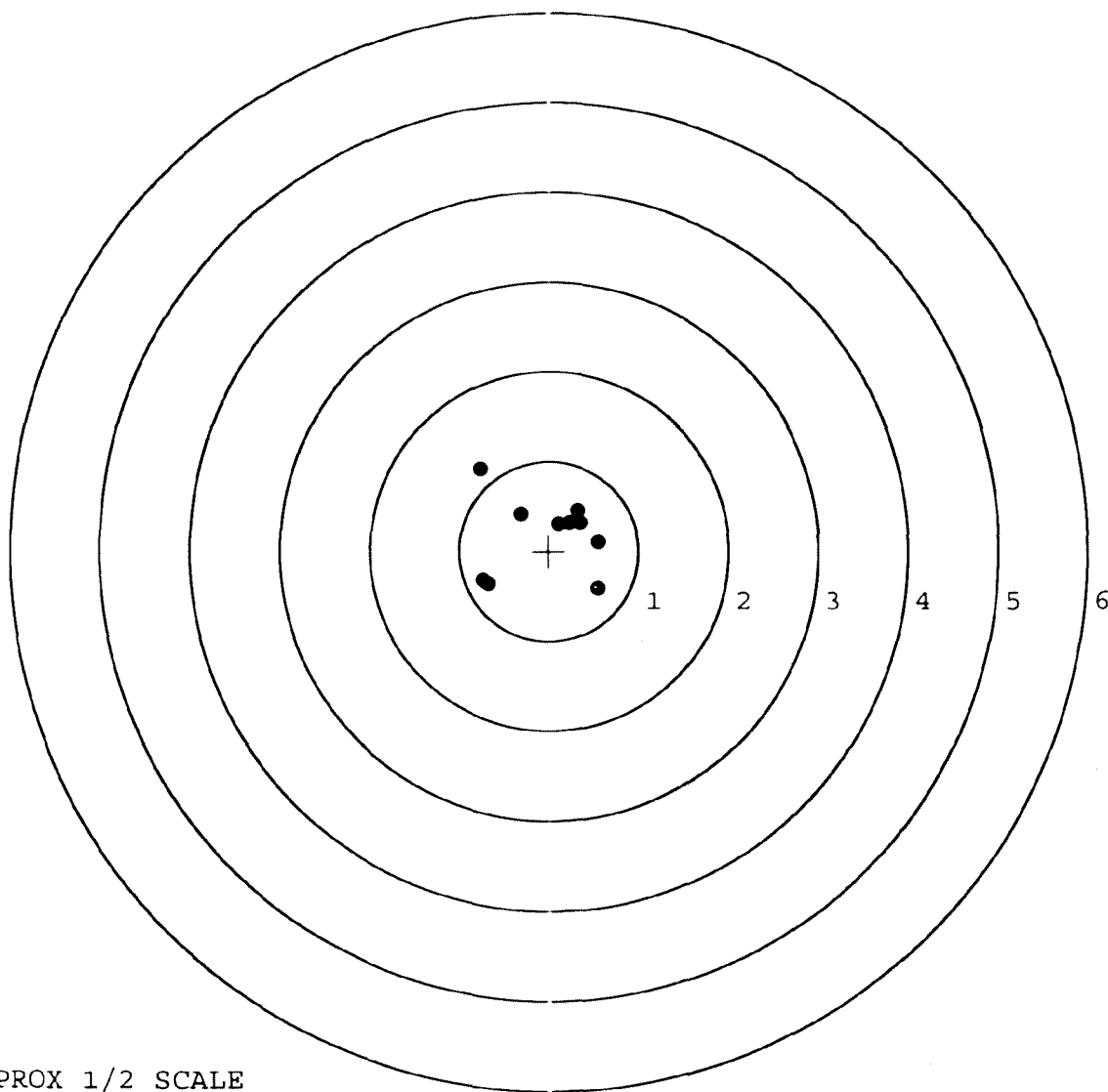
MEAN RADIUS: 0.590

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.765	0.918
2:	-0.319	0.420
3:	-0.736	-0.323
4:	-0.678	-0.360
5:	0.553	-0.414
6:	0.555	0.110
7:	0.350	0.315
8:	0.324	0.448
9:	0.232	0.316
10:	0.110	0.301



TARGET APPROX 1/2 SCALE

Repair Inquiry

Repair Number: **RE00088673**Serial: C6349038 Model M24 SWS Center Fire
Caliber: 7 62 NATO

Repairman:

Verify Repair

Status:

Closed 12/1/2004 5:57:25 AM

Address Information

Customer:

☒ Received From

Return To:

☐ Received FromName: **TRANSPORTATION OFFICER****TRANSPORTATION OFFICER**Address 1: **BLDG 49015 CRSP UPSTAIRS****BLDG 49015 CRSP UPSTAIRS**Address 2: **SANTA FE AVE**

PO Box:

SANTA FE AVE

PO Box:

City: **FORT HOOD****FORT HOOD**State: **TX**Zip Code: **76544**Country: **US**State: **TX**Zip Code: **76544**Country: **US**

FFL

Contact / Condition

Problems

Estimate

History / Status

Shipping / Billing

Contact Information

Phone:

Fax:

Email:

Comments:

Received Condition

Good

Condition
Notes:CSR
Notes:

Accessories Received

Code	Desc	Qty
A007	With Stud	3
A010	Hard Case	1
A017	Scope Base	1
A026	Scope	1
A045	Bi Pod	1
C000	FRT AND REAR SGT	1

Repair Search

Refresh

Close

naglej

12/1/2004

7:26 AM

CAPS

NUM

INS

SCRL

start

3

Arms Services

3

2

Serial Number: **C6349038**
 Model: **M24 SWS**
RE00088673

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6349038.___0
FILE DATE AND TIME: 12/13/2004 08:51

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.070
The Average Y Centroid of the Five Target Set:	-0.086
The Average Point of Impact of the Five Target Set:	0.111
The Average Mean Radius of the Five Target Set:	0.810
The Distance from POA to Centroid Target #1:	0.124
The Distance from Centroid Target #2 to Centroid Target #1:	0.110
The Distance from Centroid Target #3 to Centroid Target #1:	0.064
The Distance from Centroid Target #4 to Centroid Target #1:	0.110
The Distance from Centroid Target #5 to Centroid Target #1:	0.198

SERIAL NUMBER: C6349038. __0

TARGET NUMBER: 1

FILE DATE: 12/13/2004

FILE TIME: 08:51

POINT#	X	Y
1:	0.838	-1.345
2:	0.868	-0.677
3:	0.475	-0.417
4:	-0.373	-0.665
5:	0.345	0.778
6:	0.024	0.484
7:	0.076	0.203
8:	-0.487	0.273
9:	-1.056	0.837
10:	0.057	-0.447

X CENTROID: 0.077

Y CENTROID: -0.098

POA TO CENTROID: 0.124

HORZ SPREAD: 1.924

VERT SPREAD: 2.182

GROUP SPREAD: 2.889

MIN RADIUS: 0.301

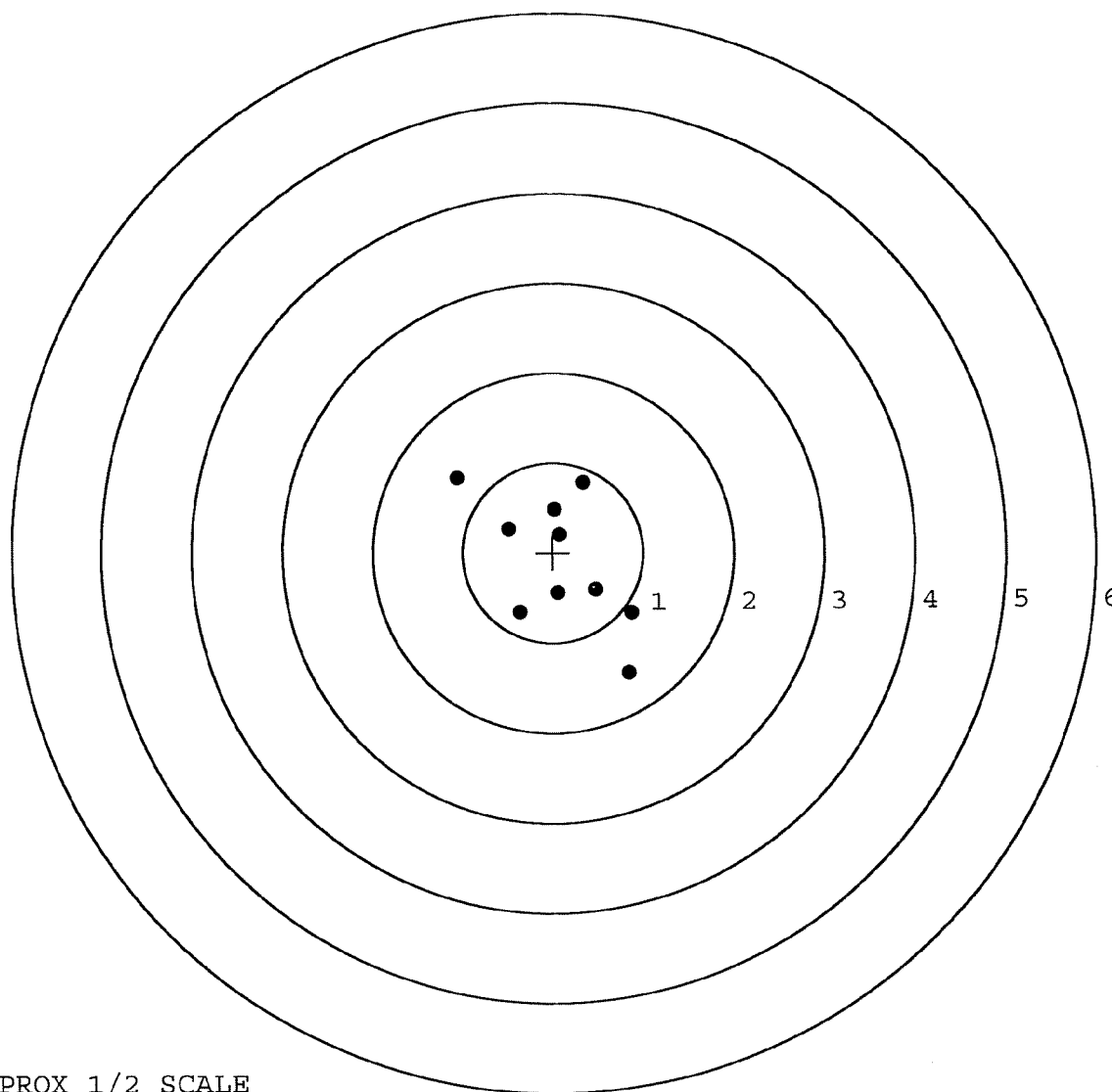
MAX RADIUS: 1.468

MEAN RADIUS: 0.797

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6349038. __0

TARGET NUMBER: 2

FILE DATE: 12/13/2004

FILE TIME: 08:51

POINT#	X	Y
1:	0.651	-0.793
2:	0.445	-0.190
3:	0.231	0.293
4:	-0.036	0.745
5:	-0.554	0.365
6:	-0.682	-0.670
7:	-0.146	-0.605
8:	-0.086	-0.402
9:	-0.075	-0.223
10:	0.127	-0.147

X CENTROID: -0.013

Y CENTROID: -0.163

POA TO CENTROID: 0.163

HORZ SPREAD: 1.333

VERT SPREAD: 1.538

GROUP SPREAD: 1.684

MIN RADIUS: 0.087

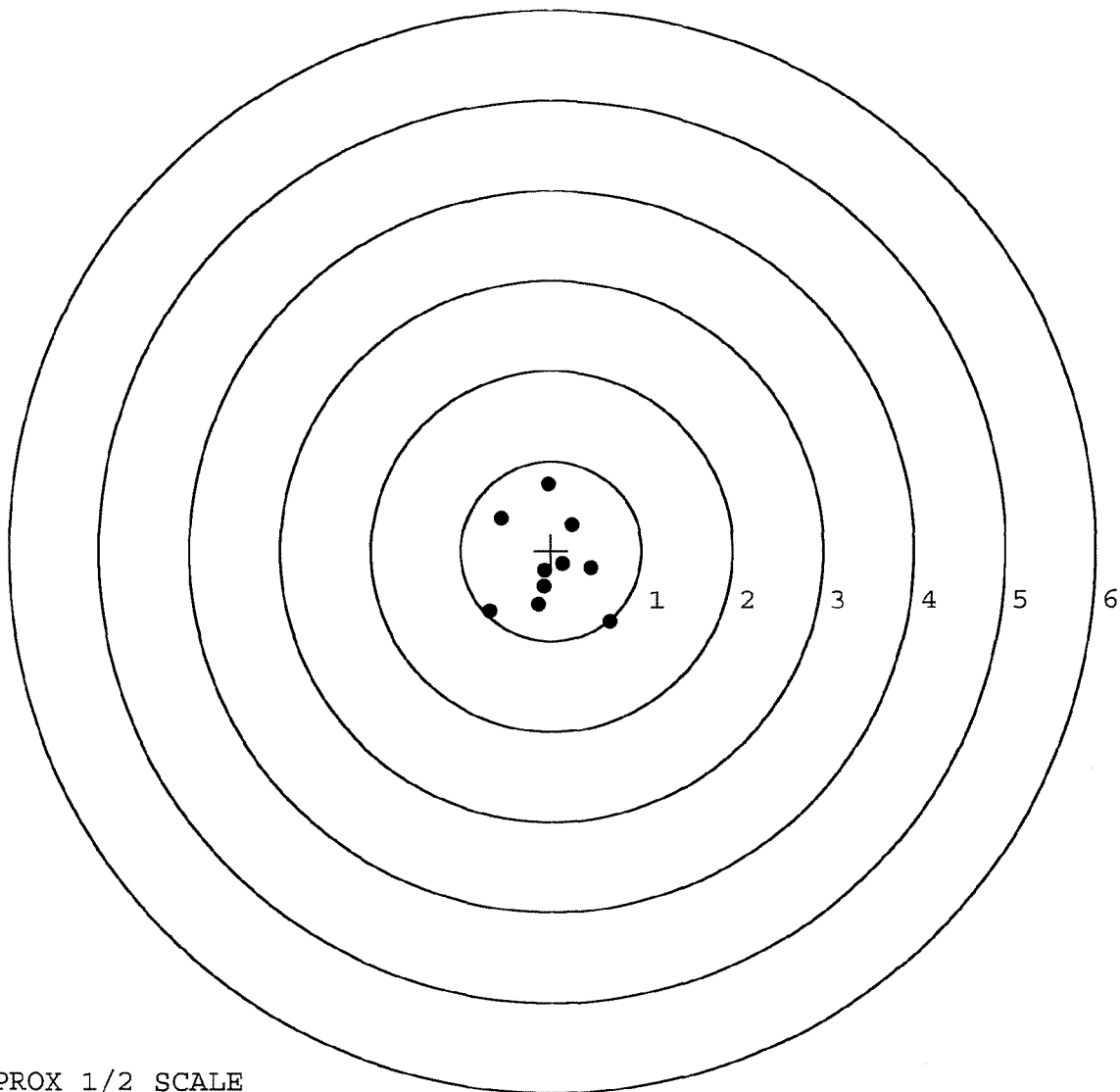
MAX RADIUS: 0.915

MEAN RADIUS: 0.533

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10

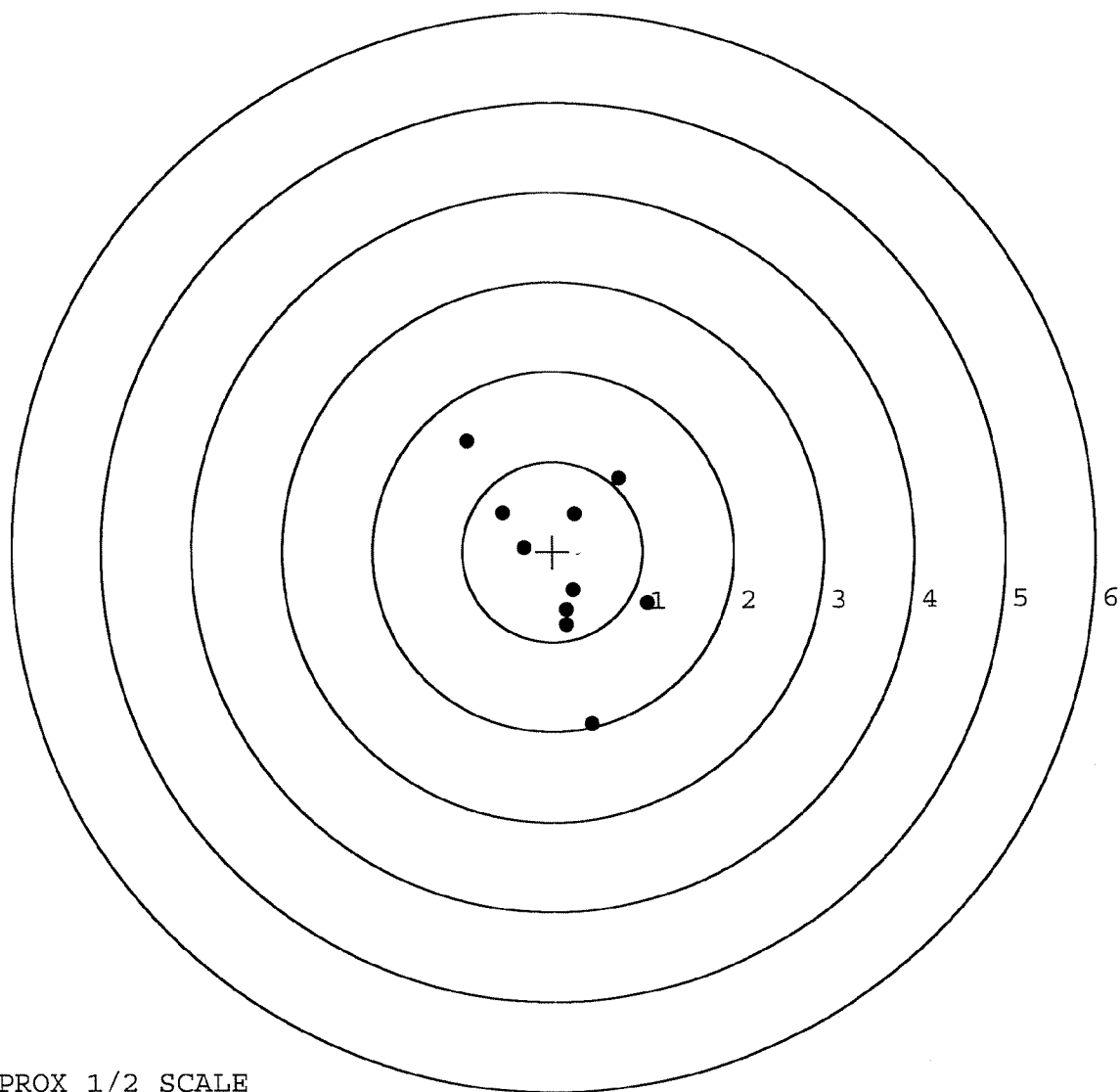


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6349038. 0
 TARGET NUMBER: 3
 FILE DATE: 12/13/2004
 FILE TIME: 08:51

POINT#	X	Y
1:	1.048	-0.581
2:	0.735	0.807
3:	0.251	0.423
4:	-0.319	0.043
5:	-0.551	0.436
6:	-0.940	1.233
7:	0.229	-0.427
8:	0.159	-0.650
9:	0.157	-0.816
10:	0.429	-1.923

X CENTROID: 0.120
 Y CENTROID: -0.145
 POA TO CENTROID: 0.188
 HORZ SPREAD: 1.988
 VERT SPREAD: 3.156
 GROUP SPREAD: 3.440
 MIN RADIUS: 0.302
 MAX RADIUS: 1.804
 MEAN RADIUS: 0.913
 # IN 1 IN DIAMETER: 2
 # IN 2 IN DIAMETER: 6
 # in 3 IN DIAMETER: 8



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6349038. 0

TARGET NUMBER: 4

FILE DATE: 12/13/2004

FILE TIME: 08:51

X CENTROID: 0.187

Y CENTROID: -0.101

POA TO CENTROID: 0.212

HORZ SPREAD: 2.567

VERT SPREAD: 2.338

GROUP SPREAD: 3.361

MIN RADIUS: 0.283

MAX RADIUS: 1.998

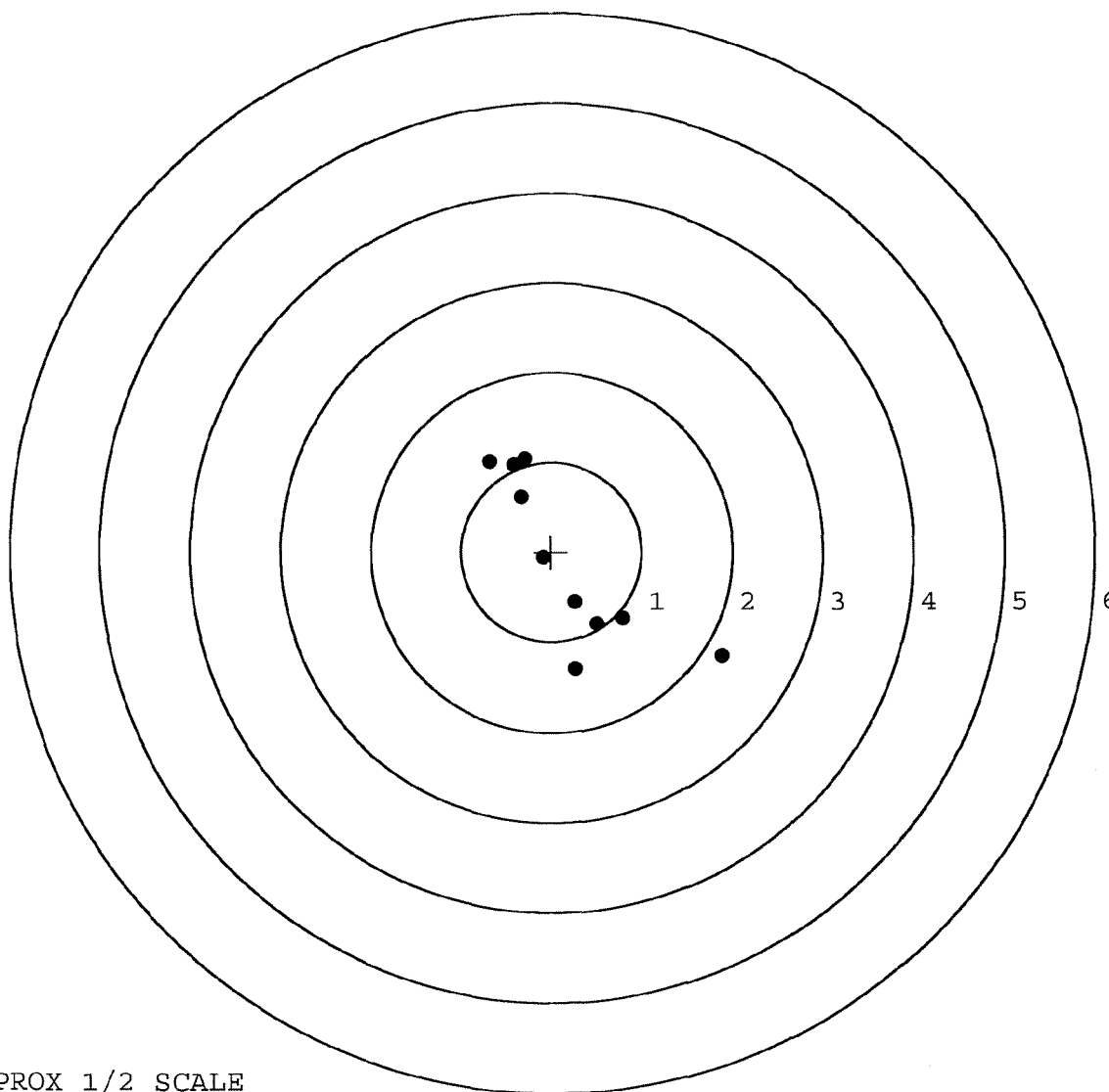
MEAN RADIUS: 1.037

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 5

in 3 IN DIAMETER: 9

POINT#	X	Y
1:	0.791	-0.744
2:	0.500	-0.804
3:	0.260	-0.566
4:	0.268	-1.302
5:	-0.093	-0.062
6:	-0.338	0.615
7:	-0.685	1.011
8:	-0.418	0.967
9:	-0.296	1.036
10:	1.882	-1.158



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6349038. 0

TARGET NUMBER: 5

FILE DATE: 12/13/2004

FILE TIME: 08:51

POINT#	X	Y
1:	-0.243	-0.976
2:	-0.336	-0.878
3:	0.230	-0.433
4:	0.280	-0.141
5:	0.616	0.257
6:	1.003	0.646
7:	-0.057	0.104
8:	-0.617	0.091
9:	-0.471	0.707
10:	-0.600	1.382

X CENTROID: -0.020

Y CENTROID: 0.076

POA TO CENTROID: 0.078

HORZ SPREAD: 1.620

VERT SPREAD: 2.358

GROUP SPREAD: 2.385

MIN RADIUS: 0.047

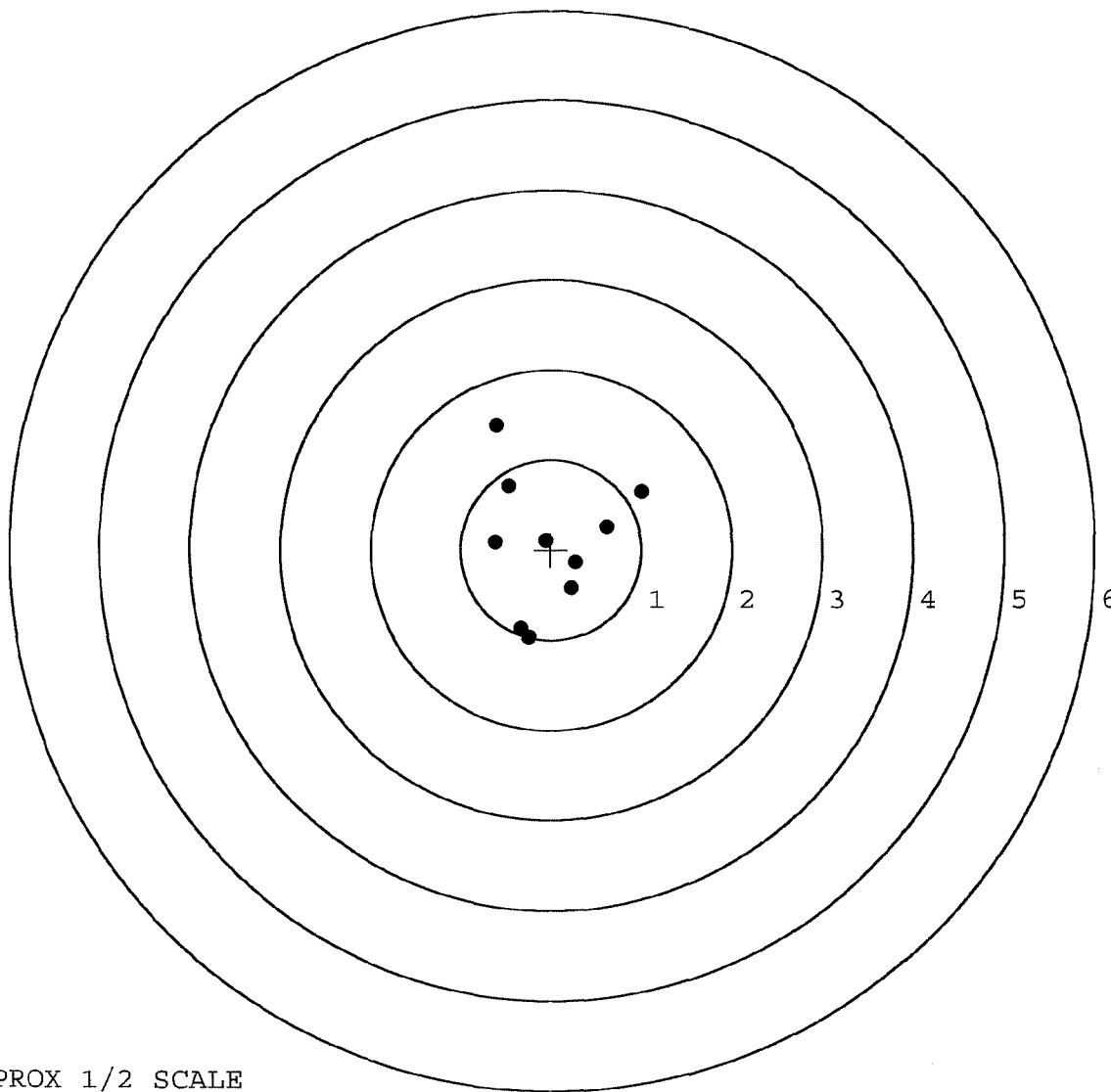
MAX RADIUS: 1.429

MEAN RADIUS: 0.770

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE M24 9106363

SERIAL NO.

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 12-1-04

TESTER TRW

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.13	2.35		2.11	
PULL #2	2.18	2.50		2.17	
PULL #3	2.15	2.41		2.27	
PULL #4	2.14	2.40		2.22	
PULL #5	2.09	2.42		2.17	
TOTAL	10.69	12.08		10.94	
AVERAGE	2.13	2.41		2.18	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.03	3.12		
PULL #2	3.19	3.16		
PULL #3	3.22	3.21		
PULL #4	3.31	3.14		
PULL #5	3.14	3.14		
TOTAL	15.89	15.77		
AVERAGE	3.17	3.15		

	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	4.15	4.17		4.25
PULL #2	4.06	4.51		4.26
PULL #3	4.13	4.14		4.29
PULL #4	4.25	4.21		4.27
PULL #5	4.12	4.19		4.25
TOTAL	20.71	21.22		21.32
AVERAGE	4.14	4.24		4.26

R & E NUMBER	88673		
SERIAL NUMBER	C6549038		
LOG-IN DATE	12-1-04		
INSPECT AND VERIFY:			
OPERATION #	OPERATION NAME	DATE	INITIAL
550	DIS-ASSEMBLE GUN	12-1-04	RTZ
560 A	RE-BARREL	12-2-04	RTZ
B	DRILL AND TAP	12-3-04	TRW
575	ASSEMBLE	12-2-04	RTZ
600	PROOF	12-2-04	RTZ
605	CHECK HEADSPACE	12-2-04	RTZ
610	DIS-ASSEMBLE GUN	12-3-04	RTZ
612	MAGNAFLUX	OPERATOR	
615	ROLLMARK CALIBER	12-3-04	SB
618	ROTO-BLAST	12-6-04	LB
620	APPLY COATINGS	12/7	HP
625 A	FINAL ASSEMBLY	12-13-04	RTZ
B	TRIGGER PULL TEST	N/A	
C	SAFETY "ON" FORCE		
D	SAFETY "OFF" FORCE		
E	FIRING PIN INDENT		
640	TARGET	12-13-04	TRW
655	FINAL INSPECT	12-13-04	AC
660	PACK	12-18-04	OTA
		SHIP DATE	
QAR INSPECTION DATE			

MAINTENANCE REQUEST For use of this form, see DA PAM 738-750 and 738-751; the proponent agency is DCSLOG				PAGE NO	NO OF PAGES	REQUIREMENT CONTROL SYMBOL CSGLD-1047(R1)	
SECTION I - CUSTOMER DATA				SECTION II - MAINTENANCE ACTIVITY DATA			
1a. UIC CUSTOMER WASDAO	1b. CUSTOMER UNIT NAME B21 INF 410	1c. PHONE NO 287-9582	3a. WORK ORDER NUMBER (WON)		3b. SHOP	3c. PHONE NO	
2a. SAMS-2 UIC/SAMS-I/DTA		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 1005-01-178-9934		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 2.62 R&R				16. MILES/KILOMETERS/HOURS/ROUNDS H R			
10a. ORG WON/DOC NO		10b. EIC		17. PROJECT CODE (if assigned)		18. ACCOUNT PROCESSING CODE	19. IN WARRANTY? (enter Y or N)
11. SERIAL NUMBER CLB49038		12. QTY	13. PD	21. REIMBURSABLE CUSTOMER (if Intransit customer enter Y or N)		20. ADMIN NO	
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) Not Authorized							
25. REMARKS							
PREPARATION INSTRUCTIONS FOR THIS PAGE							
SECTION I 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/DTA 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. 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 (WON)/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.				SECTION III (Cont'd) 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.			
34a. SUBMITTED BY			35a. ACCEPTED BY		35c. DATE		
34b. DATE			35b. STATUS		35d. TIME		

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.

[illegible]

Remington
REG. U.S. PAT. & TM. OFF.

Model 700™ M24

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

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

UPPONT

SERIAL NO. C6349038	ORDER NO. 5716
-------------------------------	--------------------------

Ø1



5716 C6349038

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6349038

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	1 30	90	RW
600	Proof	1 30	90	A
607	Check Headspace	1 30	90	A
610	Dis-assemble Gun	1 30	90	RW
612	Magnaflux Barrel Action	2-5-90		KCR
	Magnaflux Bolt	2-5-90		
615	Rollmark Caliber	2-5-90		GS
617	Drill and Tap Sight Holes	2-5-90		FB
618	Polish Barrel WB	2-5-90		WB
620	Apply Coatings (Barrel Action)		2-7-90	TH
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		2/19/90	WB
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		2/19/90	WB
	C) Inspect Ejector Hole for Chamfer		4/18/90	RW
	D) Oil Firing Pin Ass'y		4/18/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		4/24/90	JL

BARBER - M24 0106369		READINGS					DATE	INIT
op. #	OP. NAME							
625 cont.	F) Safety On Force	4	4	4			4/23/90	RL
	G) Safety Off Force	2	2	2			4/23/90	RL
	H) Trigger Pull Test & Retainability						4/20/90	RL
	I) Firing Pin Indent	.022	.022	.022			4/23/90	RL
	J) Assemble Stock						4/23/90	RW
	K) Assemble Swivel Studs						4/30/90	WB
	L) Attach Front and Rear Sight Assemblies						4/23/90	RW
	M) Iron Sight Alignment						4/23/90	RW
	N) Detach Front & Rear Sights & place in numbered container						4/23/90	RW
	O) Attach Scope to Rifle						4/23/90	WB
	P) Detach & Attach Scope 20 Times						4/23/90	WB
640	Gallery Target & Test						4-24-90	AC
	A) Time						4-24-90	AC
	B) Malfunctions						4-24-90	AC
	C) Pierced Primers						4-24-90	AC
	D) Optical Clarity of Scope						4-24-90	AC
645	Inspect for Live Ammo						4-24-90	AC
655	Final Inspection						4/26/90	WB
	A) Headspace							
	B) Trigger Pull	2.78	2.79	2.79	2.76	2.78	4/30/90	WB
	C) Function						4/30/90	WB
660	Pack						6/19/90	D/H

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO C6349038

DATE 4/20/90

TESTER JEP

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.52	2.28	2.51	2.78	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.41	2.57	2.37	2.79	
PULL #3	2.26	2.39	2.32	2.79	
PULL #4	2.31	2.25	2.37	2.76	
PULL #5	2.31	2.22	2.41	2.78	
TOTAL	11.81	11.71	11.98		
AVG.	2.362	2.342	2.396		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.37	3.22		
PULL #2	3.31	3.24		
PULL #3	3.35	3.24		
PULL #4	3.33	3.21		
PULL #5	3.31	3.13		
TOTAL	16.67	16.10		
AVG.	3.334	3.22		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.21	4.18		4.26
PULL #2	4.22	4.35		4.26
PULL #3	4.21	4.36		4.24
PULL #4	4.20	4.31		4.30
PULL #5	4.27	4.31		4.25
TOTAL	21.11	21.51		21.31
AVG.	4.222	4.302		4.262

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6349038
24 Apr 1990

CENTROIDAL DISTANCES

0 TO	1	.237002
1 TO	2	.152463
1 TO	3	.0711688
1 TO	4	.329632
1 TO	5	.342593

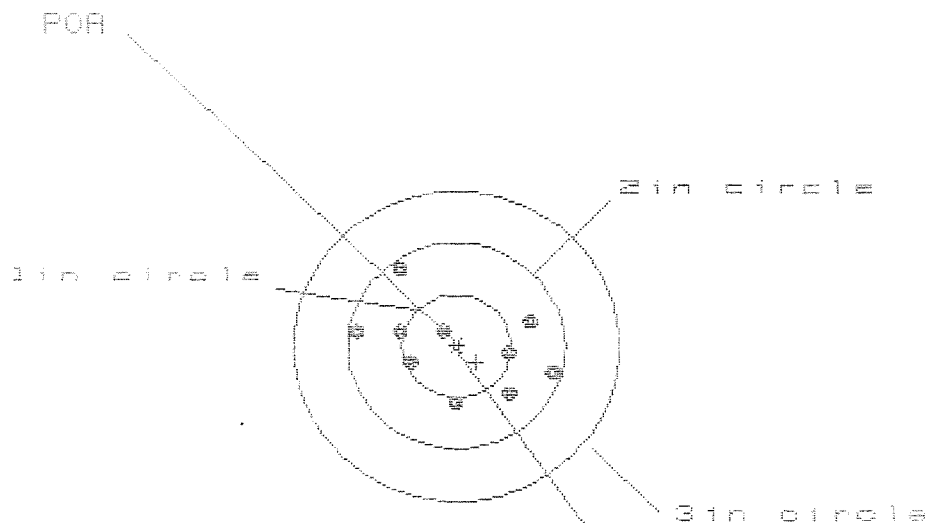
$\frac{0.4}{5}$ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1642
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .01
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .164504
THE AMR FOR THIS RIFLE IS: .7746

24 Apr 1998

FILE:/PATTERNING/CENTERFIRE_PATT/08349038

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 2

2in = 10

3in = 10

HS= 1.810

VS= 1.319

GS= 1.850

CENTROID *

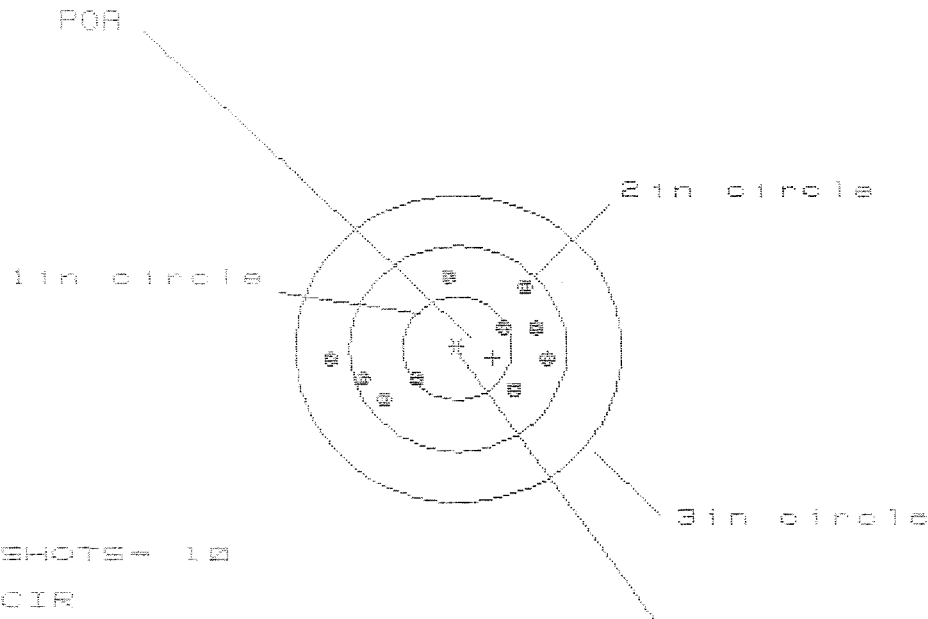
PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.869	.765	.690
MINIMUM X	-.941	-.599	-.654
MAXIMUM Y	.779	.791	.389
MINIMUM Y	-.540	-.528	-.430
CENTROID X	-.181	-.077	-.002
CENTROID Y	.153	.141	.043
POB TO CENTROID in.	.238	.161	.043
MIN RADIUS	.212	.302	.330
MEAN RADIUS	.636	.600	.538
MAX RADIUS	.947	.992	.711
HORIZONTAL SPREAD	1.810	1.364	1.344
VERTICAL SPREAD	1.319	1.319	.819
EXTREME SPREAD	1.850	1.723	1.415
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	10		
NUMBER IN THREE INCH CIRCLE =	10		

24 Apr 1990

FILE:/PATTERNING/CENTERFIRE_PATT/C8345030

CENTERFIRE PATTERNS

2



OF SHOTS = 10

IN CIR

1in = 2

2in = 8

3in = 10

HS = 1.996

VS = 1.172

GS = 1.996

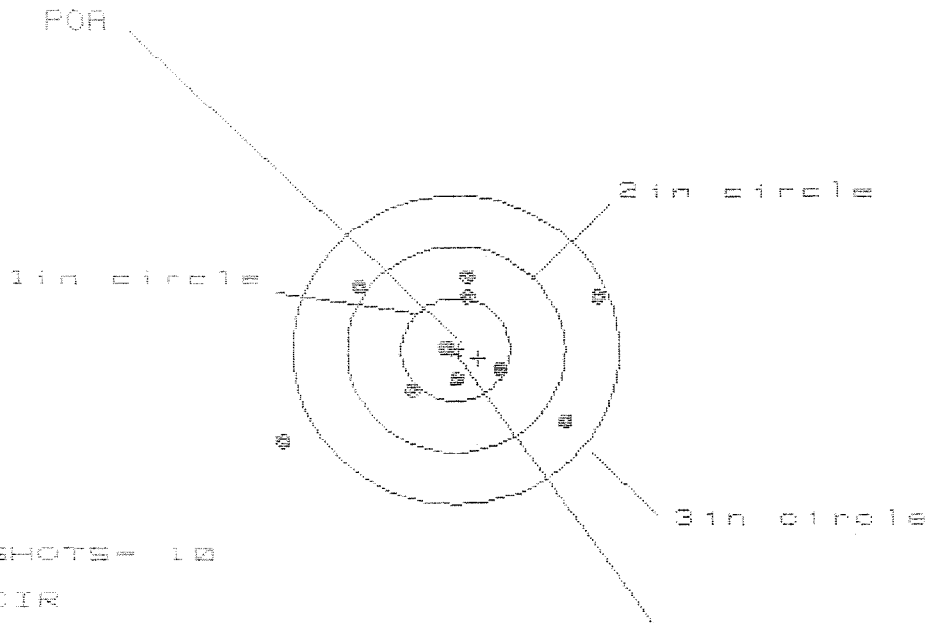
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.842	.713	.592
MINIMUM X	-1.155	-.973	-.890
MAXIMUM Y	.698	.687	.645
MINIMUM Y	-.474	-.485	-.527
CENTROID X	-.322	-.193	-.072
CENTROID Y	.095	.106	.148
POA TO CENTROID in.	.335	.220	.164
MIN RADIUS	.463	.351	.235
MEAN RADIUS	.767	.704	.634
MAX RADIUS	1.159	1.029	1.035
HORIZONTAL SPREAD	1.996	1.686	1.482
VERTICAL SPREAD	1.172	1.172	1.172
EXTREME SPREAD	1.996	1.729	1.655
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		9	
NUMBER IN THREE INCH CIRCLE =		10	

24 Apr 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C8349038

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 6

3 in = 1

HE= 2.866

VS= 1.672

GS= 3.218

CENTROID #

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.265	1.087	1.086
MINIMUM X	-1.681	-1.116	-1.981
MAXIMUM Y	.768	.658	.714
MINIMUM Y	-.912	-.783	-.726
CENTROID X	-.285	-.027	-.163
CENTROID Y	.086	.188	.132
POR TO CENTROID in.	.222	.190	.209
MIN RADIUS	.091	.261	.120
MEAN RADIUS	.819	.708	.623
MAX RADIUS	1.843	1.209	1.241
HORIZONTAL SPREAD	2.866	2.203	1.987
VERTICAL SPREAD	1.672	1.441	1.441
EXTREME SPREAD	3.218	2.345	2.345
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	9		

24 Apr 1998

FILE:/PATTERNING/CENTERFIRE_PATT/08345038

CENTERFIRE PATTERNS # 4

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS= 10

IN CIR

1in = 2

2in = 6

3in = 10

HS= 1.699

VS= 2.024

GS= 2.076

PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.849	.898	.798
MINIMUM X	-.858	-.801	-.798
MAXIMUM Y	1.017	.905	.968
MINIMUM Y	-1.007	-.861	-.798
CENTROID X	.035	-.015	.085
CENTROID Y	-.096	.016	-.047
POA TO CENTROID in.	.102	.022	.097
MIN RADIUS	.374	.496	.410
MEAN RADIUS	.820	.784	.757
MAX RADIUS	1.182	1.121	1.004
HORIZONTAL SPREAD	1.699	1.699	1.588
VERTICAL SPREAD	2.024	1.766	1.766
EXTREME SPREAD	2.076	2.063	1.862
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	10		

24 Apr 1990

FILE:/PATTERNING/CENTERFIRE_PATT/CG349030

CENTERFIRE PATTERNS

5

POA

1 in circle

2 in circle

3 in circle

OF SHOTS = 10

IN CIR

1 in = 2

2 in = 7

3 in = 9

HS = 2.8330

VS = 1.838

CS = 2.893

CENTROID *

PATTERN #

5

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.413	.739	.581
MINIMUM X	-1.417	-1.260	-.766
MAXIMUM Y	.772	.835	.839
MINIMUM Y	-1.066	-1.003	-.999
CENTROID X	-.148	-.305	-.147
CENTROID Y	-.188	-.251	-.255
POA TO CENTROID, in.	.239	.395	.294
MIN RADIUS	.265	.295	.201
MEAN RADIUS	.831	.752	.661
MAX RADIUS	1.522	1.261	1.011
HORIZONTAL SPREAD	2.830	1.999	1.347
VERTICAL SPREAD	1.838	1.838	1.838
EXTREME SPREAD	2.893	2.090	1.839
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	9		