

G6695394

Replaces

E6413530

Repair Inquiry

Repair Number: RE00140415

Serial: E6413530 Model M24 SWS Center Fire
Caliber: 7.62 NATO

Repairman:

Status: Closed 1/22/2008 3:15:21 PM

Verify Repair

High Priority

Address Information

Customer:

☒ Received From

Return To:

☐ Received From

Name: TRANSPORTATION DIV, DFEL

TRANSPORTATION DIV, DFEL

Address 1: 6759 MITCHELL AVENUE

6759 MITCHELL AVENUE

Address 2: BLDG 1836

PO Box:

BLDG 1836

PO Box:

City: FORT BENNING

FORT BENNING

State: GA

Zip Code: 31905

Country: US

State: GA

Zip Code: 31905

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
A057	Fit and Rear Sgt Base	1
D000	BI POD ALL BROKEN	1

nagletj

1/23/2008

1:05 PM

NUM

NEW G-6695394

Serial Number: **E6413530**

Model: **M24 SWS**



RE00140415

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6695394. 0

FILE DATE AND TIME: 02/11/2008 14:20

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.013
The Average Y Centroid of the Five Target Set:	-0.040
The Average Point of Impact of the Five Target Set:	0.042
The Average Mean Radius of the Five Target Set:	0.751
The Distance from POA to Centroid Target #1:	0.033
The Distance from Centroid Target #2 to Centroid Target #1:	0.083
The Distance from Centroid Target #3 to Centroid Target #1:	0.171
The Distance from Centroid Target #4 to Centroid Target #1:	0.157
The Distance from Centroid Target #5 to Centroid Target #1:	0.092

BARBER - M24 0179778

SERIAL NUMBER: G6695394. __0

TARGET NUMBER: 1

FILE DATE: 02/11/2008

FILE TIME: 14:20

POINT#	X	Y
1:	1.316	-0.779
2:	1.306	-0.143
3:	0.613	0.128
4:	0.472	0.582
5:	0.054	0.234
6:	-0.207	-0.291
7:	-0.429	-0.108
8:	-0.441	-0.008
9:	-1.305	0.106
10:	-1.700	0.213

X CENTROID: -0.032

Y CENTROID: -0.007

POA TO CENTROID: 0.033

HORZ SPREAD: 3.016

VERT SPREAD: 1.361

GROUP SPREAD: 3.175

MIN RADIUS: 0.256

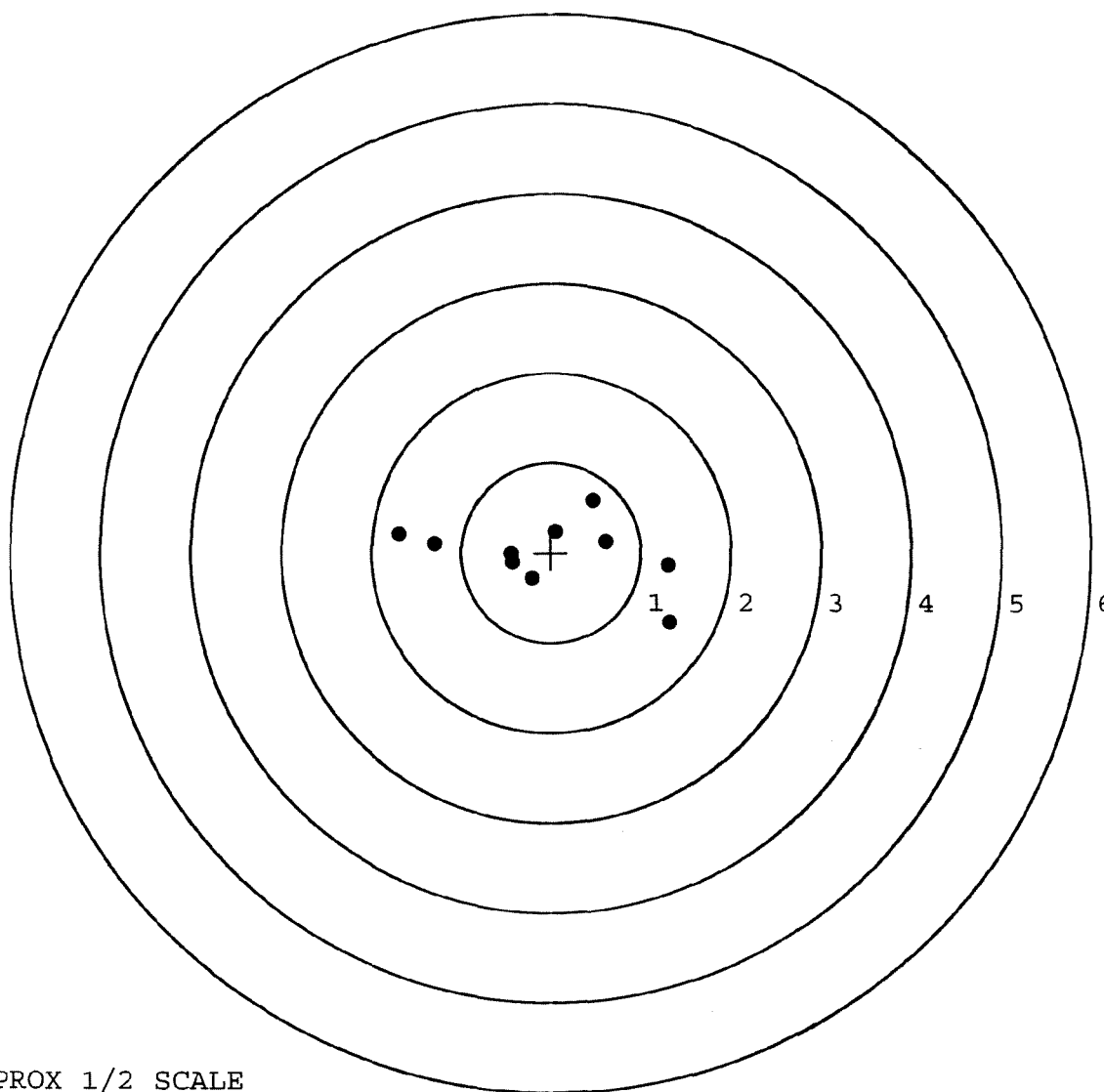
MAX RADIUS: 1.682

MEAN RADIUS: 0.870

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 8



TARGET APPROX 1/2 SCALE

BARBER - M24 0179779

SERIAL NUMBER: G6695394. __ 0

TARGET NUMBER: 2

FILE DATE: 02/11/2008

FILE TIME: 14:20

POINT#	X	Y
1:	1.089	0.223
2:	0.033	0.706
3:	-0.387	0.591
4:	-0.305	-0.075
5:	-0.423	0.098
6:	-0.666	-0.031
7:	0.065	-0.343
8:	0.375	-0.448
9:	0.204	-0.815
10:	-0.955	-0.487

X CENTROID: -0.097

Y CENTROID: -0.058

POA TO CENTROID: 0.113

HORZ SPREAD: 2.044

VERT SPREAD: 1.521

GROUP SPREAD: 2.164

MIN RADIUS: 0.209

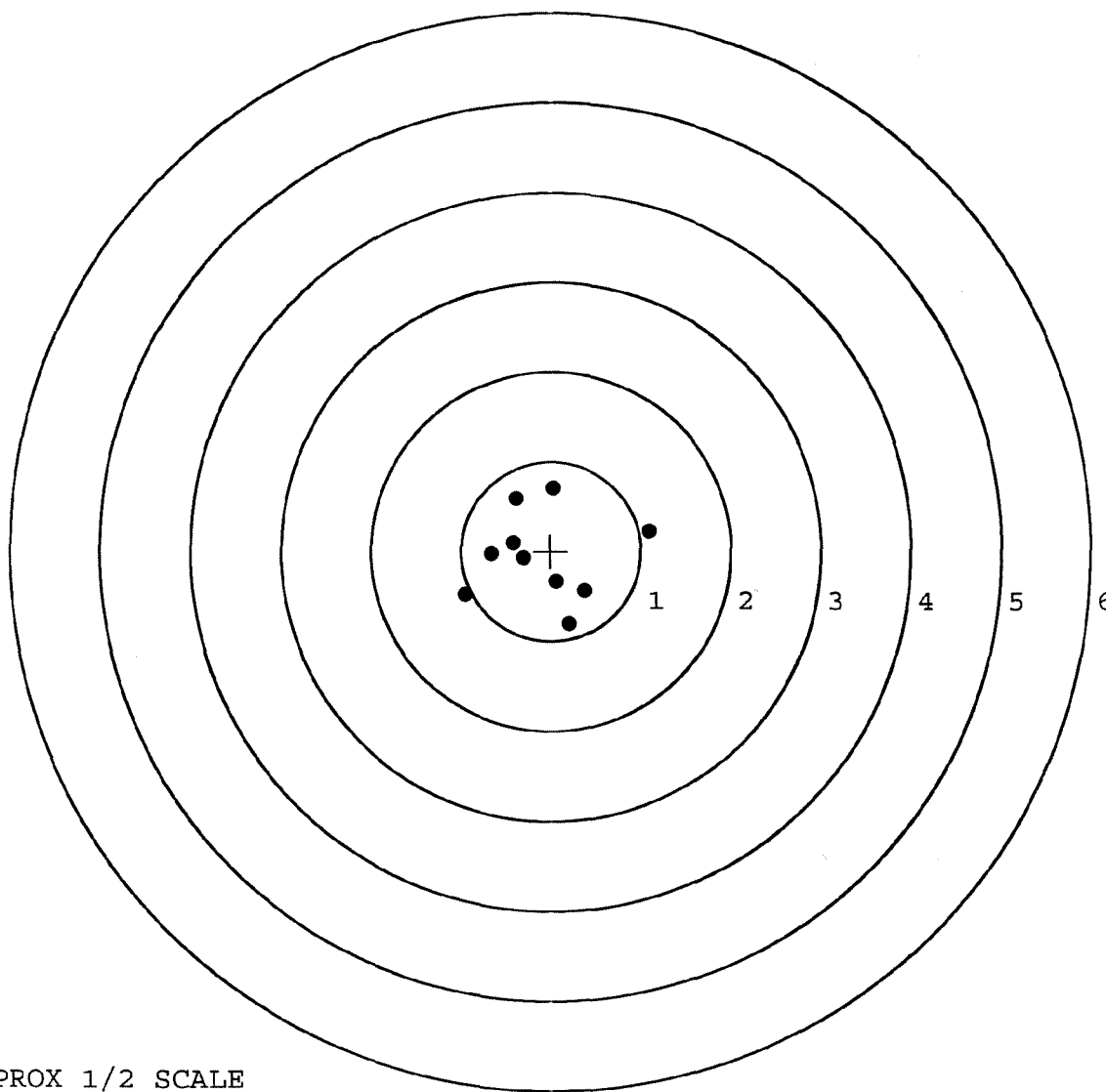
MAX RADIUS: 1.219

MEAN RADIUS: 0.656

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

BARBER - M24 0179780

SERIAL NUMBER: G6695394. 0

TARGET NUMBER: 3

FILE DATE: 02/11/2008

FILE TIME: 14:20

POINT#	X	Y
1:	-0.450	0.665
2:	-0.995	-0.244
3:	-0.578	-0.081
4:	-0.234	-0.157
5:	-0.356	-0.753
6:	0.031	-0.807
7:	0.478	-0.466
8:	0.315	-0.161
9:	0.403	0.071
10:	0.487	0.256

X CENTROID: -0.090

Y CENTROID: -0.168

POA TO CENTROID: 0.190

HORZ SPREAD: 1.482

VERT SPREAD: 1.472

GROUP SPREAD: 1.564

MIN RADIUS: 0.144

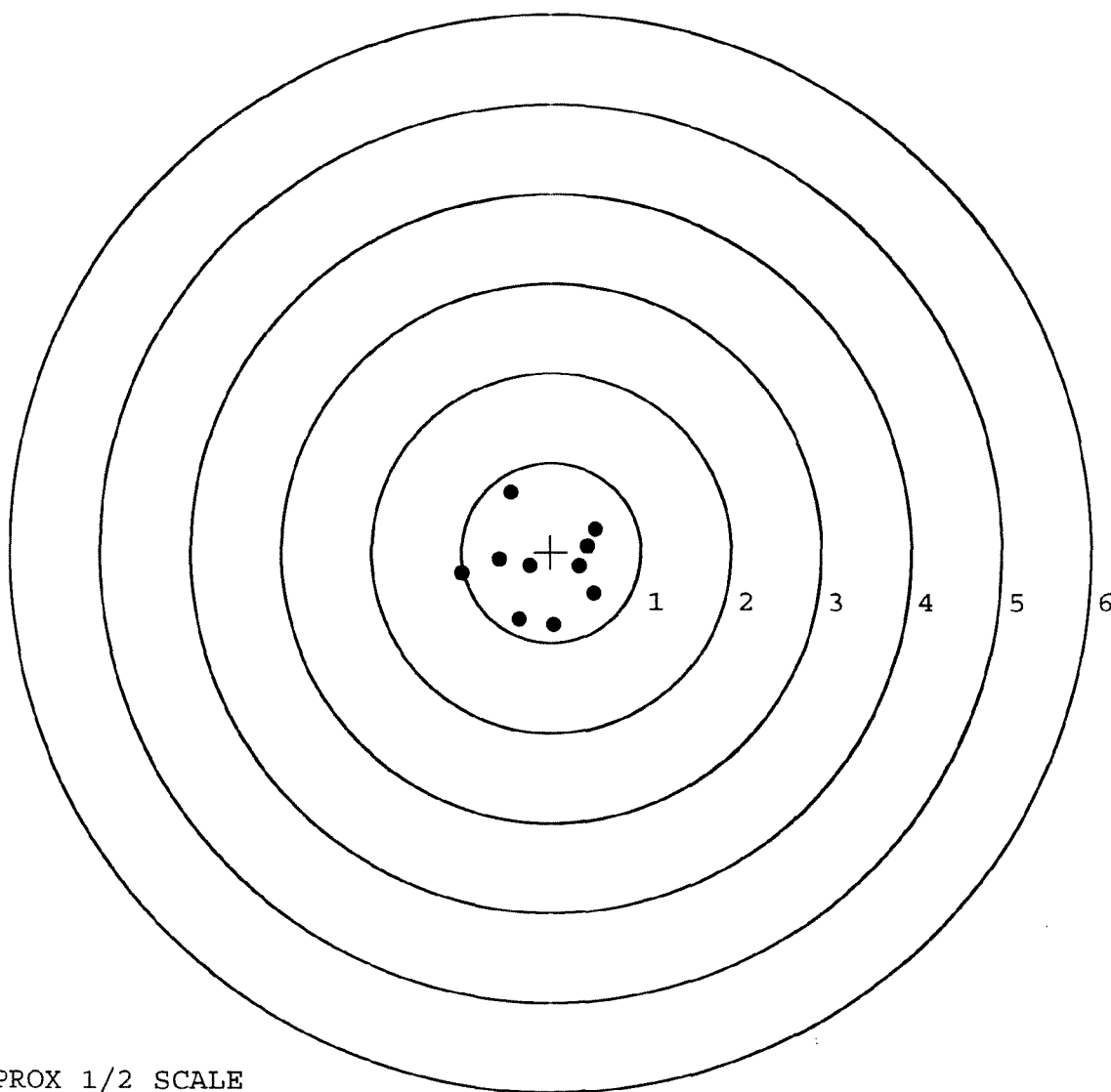
MAX RADIUS: 0.908

MEAN RADIUS: 0.606

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10



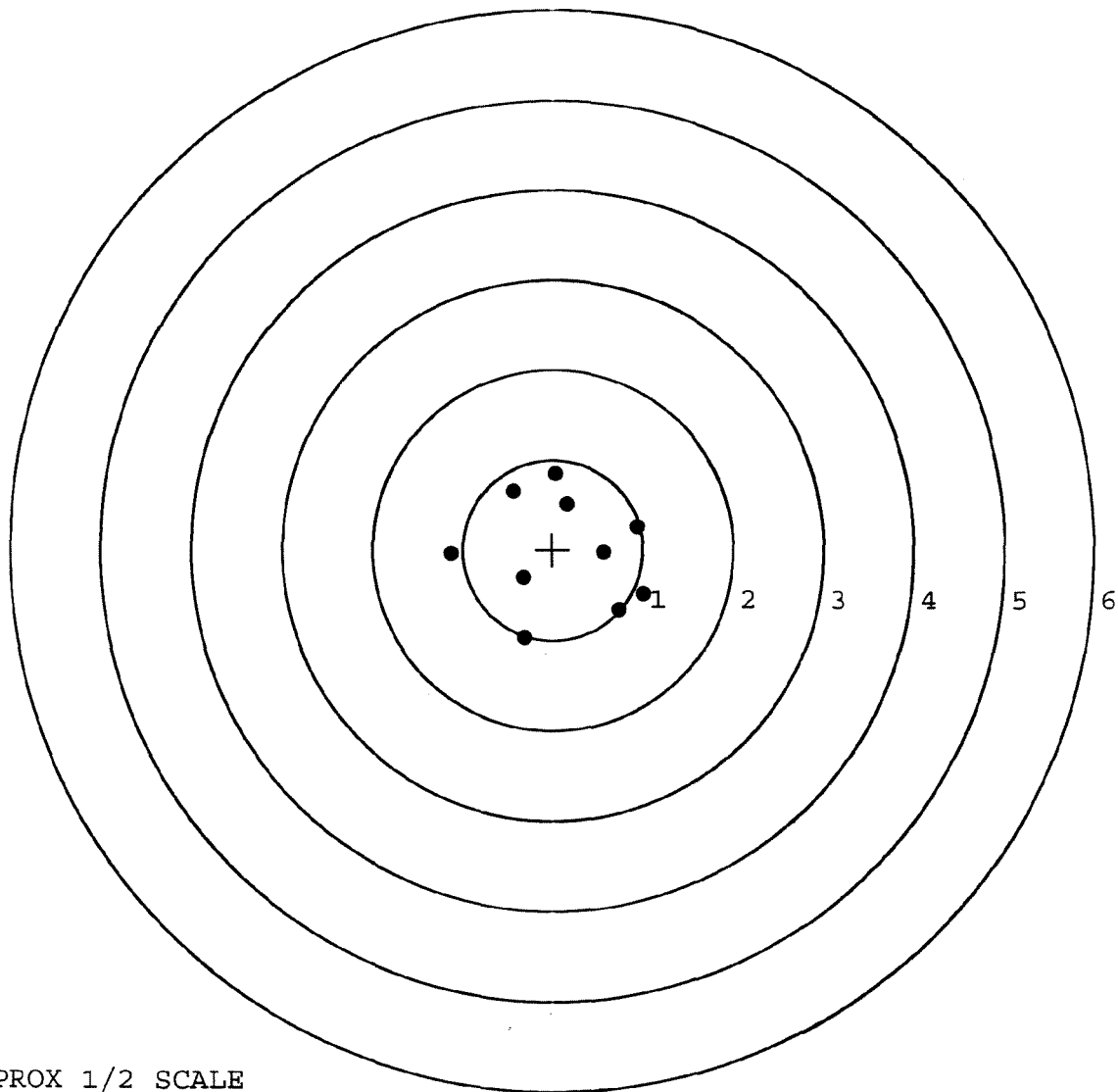
TARGET APPROX 1/2 SCALE

BARBER - M24 0179781

SERIAL NUMBER: G6695394. __ 0
 TARGET NUMBER: 4
 FILE DATE: 02/11/2008
 FILE TIME: 14:20

POINT#	X	Y
1:	1.003	-0.496
2:	0.737	-0.668
3:	0.570	-0.030
4:	0.936	0.257
5:	0.165	0.506
6:	0.035	0.846
7:	-0.440	0.647
8:	-0.325	-0.315
9:	-1.131	-0.050
10:	-0.314	-0.975

X CENTROID: 0.124
 Y CENTROID: -0.028
 POA TO CENTROID: 0.127
 HORZ SPREAD: 2.134
 VERT SPREAD: 1.821
 GROUP SPREAD: 2.180
 MIN RADIUS: 0.446
 MAX RADIUS: 1.255
 MEAN RADIUS: 0.831
 # IN 1 IN DIAMETER: 1
 # IN 2 IN DIAMETER: 8
 # in 3 IN DIAMETER: 10



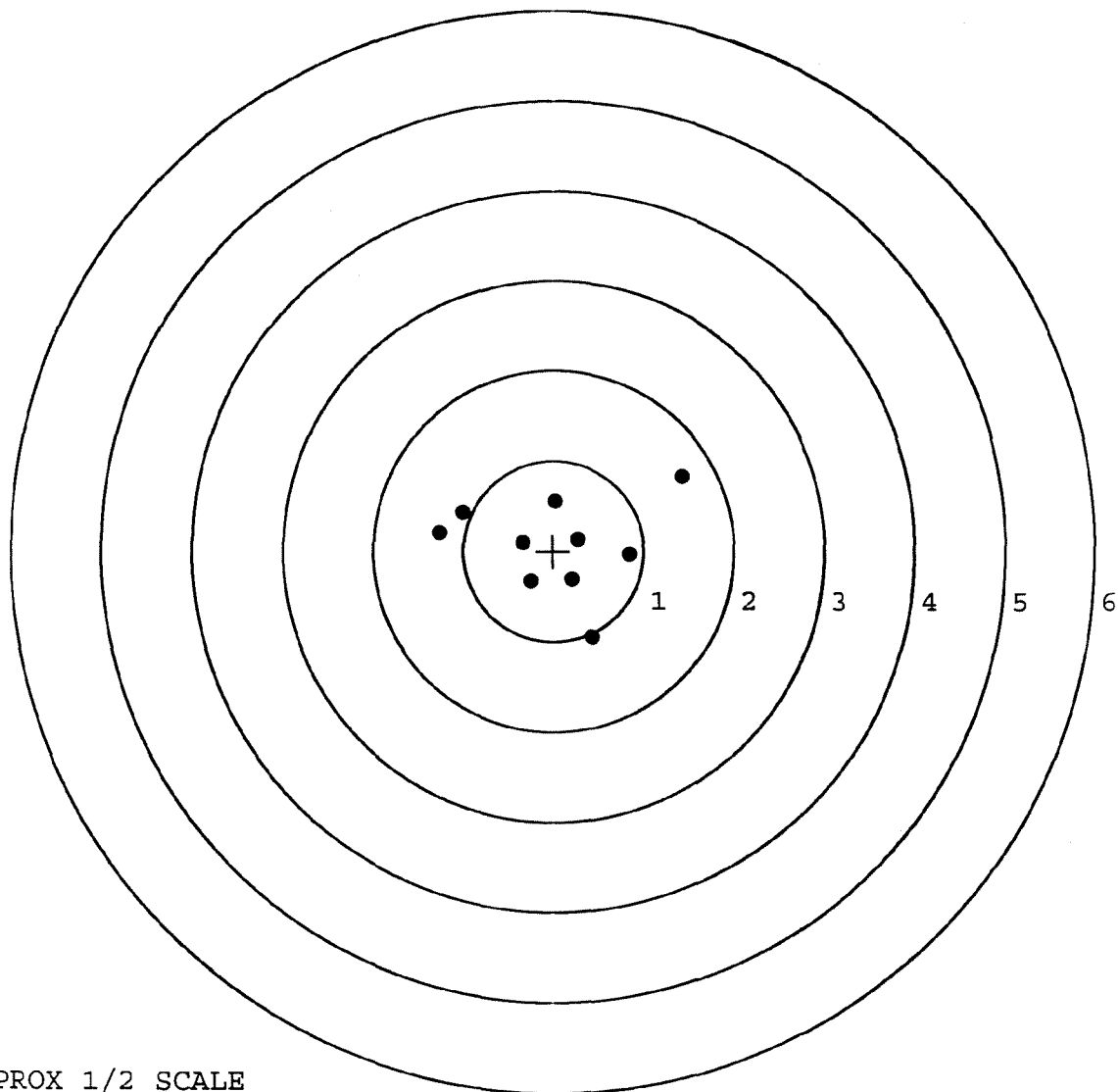
TARGET APPROX 1/2 SCALE

BARBER - M24 0179782

SERIAL NUMBER: G6695394. 0
 TARGET NUMBER: 5
 FILE DATE: 02/11/2008
 FILE TIME: 14:20

POINT#	X	Y
1:	0.428	-0.954
2:	0.840	-0.035
3:	1.421	0.821
4:	0.211	-0.316
5:	0.272	0.132
6:	0.024	0.548
7:	-0.344	0.097
8:	-0.251	-0.336
9:	-1.010	0.428
10:	-1.270	0.203

X CENTROID: 0.032
 Y CENTROID: 0.059
 POA TO CENTROID: 0.067
 HORZ SPREAD: 2.691
 VERT SPREAD: 1.775
 GROUP SPREAD: 2.761
 MIN RADIUS: 0.251
 MAX RADIUS: 1.584
 MEAN RADIUS: 0.792
 # IN 1 IN DIAMETER: 5
 # IN 2 IN DIAMETER: 6
 # in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

R & E NUMBER		00140415	
SERIAL NUMBER		E 6413530 NEW G-6695394	
LOG-IN DATE		1-22-08	
OPERATION #	OPERATION NAME	DATE	INITIAL
500	DIS-ASSEMBLE GUN	1-28-08	R.P.D.
505	RE-BARREL	1-28-08	R.P.D.
560	ASSEMBLE	1-30-08	TRW
600	PROOF	1-30-08	TRW
605	CHECK HEADSPACE	1-30-08	TRW
610	DIS-ASSEMBLE GUN	1-30-08	R.P.D.
612	MAGNAFLUX	2-1-08	JG
510	DRILL AND TAP	1-30-08	TRW
615	ROLLMARK CALIBER	1-30-08	CW
618	ROTO-BLAST	2-4-08	LY
620	APPLY COATINGS	2-6-08	CM
625	FINAL ASSEMBLY	2-6-08	R.P.D.
640	FUNCTION TEST AND	(PASS) FAIL	2-8-08 TRW
650	TARGET	(PASS) FAIL	2-8-08 TRW
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	2-8-08 R.P.
670	FINAL INSPECTION	2-12-08	DA
	A) HEADSPACE	(PASS) FAIL	2-12-08 DA
	B) TRIGGER PULL	253 2153 2.44 253 2-18-08 230	DA
680	F) SAFETY ON FORCE	6.2 6.2 6.50 2-12-08	DA
	G) SAFETY OFF FORCE	3.25 3.2 3.25 2-12-08	DA
	I) FIRING PIN INDENT	.022 .0215 .021 2-12-08	DA
690	PACK	2-19-08	FM

Repair Inquiry

Repair Number: RE00083409

Serial: E6413530 Model: M24 SWS Center Fire
Caliber: 7.62 NATO

Repairman:

Verify Repair

Status:

Closed 8/3/2004 12:41:09 PM

Address Information

Customer:

Received From

Return To:

Received From

Name: TRANSPORTATION DIV DFEL

TRANSPORTATION DIV DFEL

Address 1: BLDG 1836

BLDG 1836

Address 2: 6759 MITCHELL AVE

PO Box:

6759 MITCHELL AVE

PO Box:

City: FORT BENNING

FORT BENNING

State: GA

Zip Code: 31905

Country: US

State: GA

Zip Code: 31905

Country: US

FFL:

Contact / Condition

Problems

Estimate

History / Status

Shipping / Billing

Date	Code	User ID	Desc1
8/3/2004 11:37:1	New	urtzdj	Repair Added
8/3/2004 12:41:0	Closed	urtzdj	Closed at Expedite

☐ Shipping Hold☐ InterFace Hold☐ Estimate Sent☐ Parts Received☐ Passed Inspection☐ Return As Received☐ Has been Approved☐ Internal Repair

Current Status

Closed

8/3/2004 12:41:09 PM

urtzdj

Sniper Systems

Repair Location

ILN

Current Location

ILN

Transfer Number

Repair Search

Refresh

Close

eglandit

8/4/2004

8:26 AM

CAPS

NUM

INS

SCRL

start

Inbo...

DMS...

2.5...

SAP...

Displ...

Micr...

Arm...

8:26 AM

Serial Number:

E6413530

Model: M24 SWS



RE00083409

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: E6413530.___0
FILE DATE AND TIME: 06/25/2003 07:01

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.034
The Average Y Centroid of the Five Target Set:	0.065
The Average Point of Impact of the Five Target Set:	0.073
The Average Mean Radius of the Five Target Set:	0.695
The Distance from POA to Centroid Target #1:	0.257
The Distance from Centroid Target #2 to Centroid Target #1:	0.314
The Distance from Centroid Target #3 to Centroid Target #1:	0.603
The Distance from Centroid Target #4 to Centroid Target #1:	0.351
The Distance from Centroid Target #5 to Centroid Target #1:	0.232

BARBER - M24 0179786

SERIAL NUMBER: E6413530. __0

TARGET NUMBER: 1

FILE DATE: 06/25/2003

FILE TIME: 07:01

POINT#	X	Y
1:	0.986	2.060
2:	-0.236	1.410
3:	-0.191	0.608
4:	0.115	0.434
5:	-0.244	0.022
6:	-0.991	-0.087
7:	-1.032	-0.255
8:	-0.835	-1.249
9:	-0.282	-1.137
10:	0.352	-0.781

X CENTROID: -0.236

Y CENTROID: 0.103

POA TO CENTROID: 0.257

HORZ SPREAD: 2.018

VERT SPREAD: 3.309

GROUP SPREAD: 3.777

MIN RADIUS: 0.081

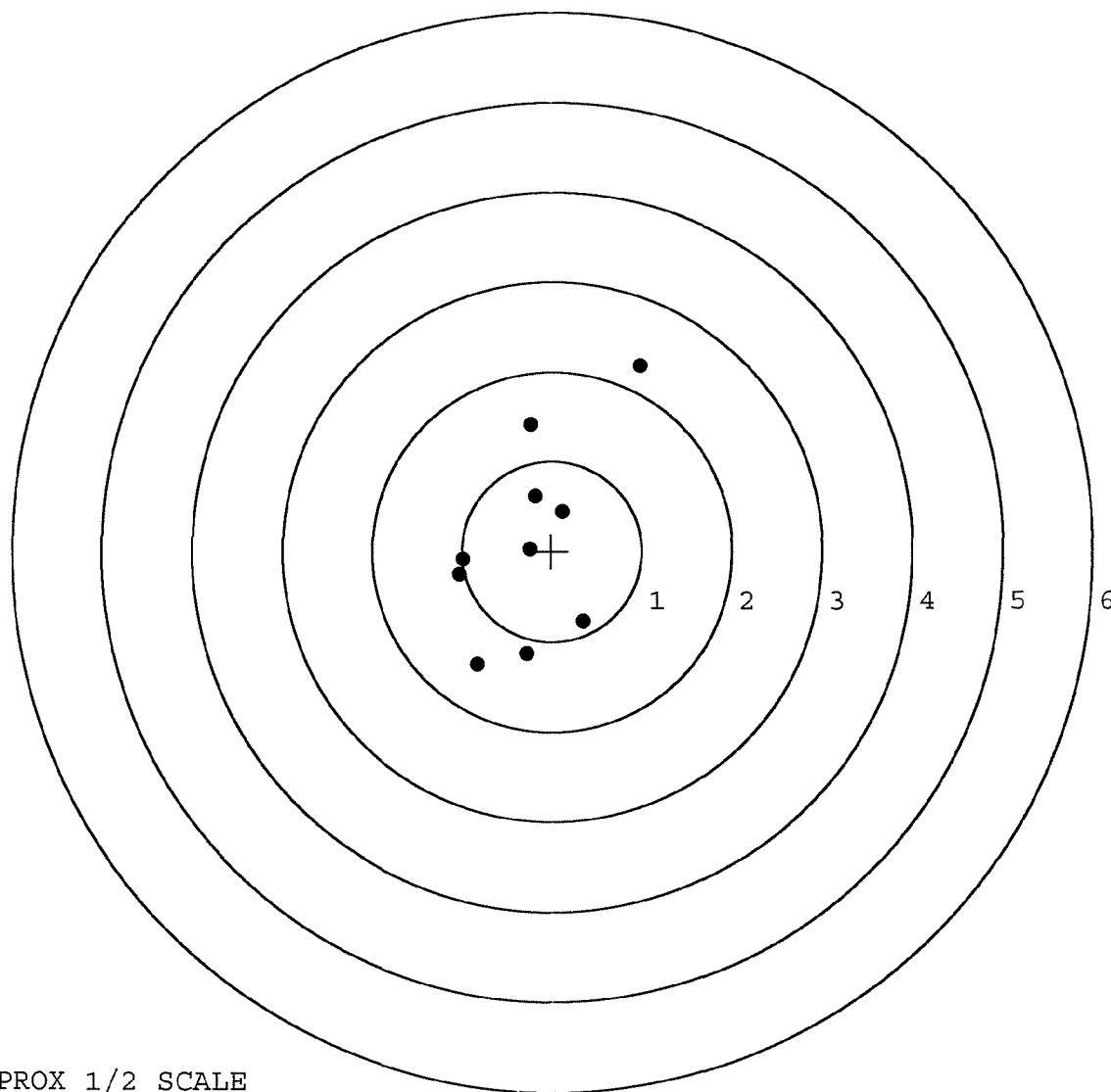
MAX RADIUS: 2.308

MEAN RADIUS: 1.012

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 5

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: E6413530. __ 0

TARGET NUMBER: 2

FILE DATE: 06/25/2003

FILE TIME: 07:01

POINT#	X	Y
1:	0.256	2.185
2:	0.200	1.040
3:	0.015	0.400
4:	0.260	0.222
5:	0.813	-0.416
6:	-0.398	-0.940
7:	-0.302	-0.447
8:	-0.281	-0.025
9:	-0.457	0.539
10:	0.008	0.404

X CENTROID: 0.011

Y CENTROID: 0.296

POA TO CENTROID: 0.296

HORZ SPREAD: 1.270

VERT SPREAD: 3.125

GROUP SPREAD: 3.193

MIN RADIUS: 0.104

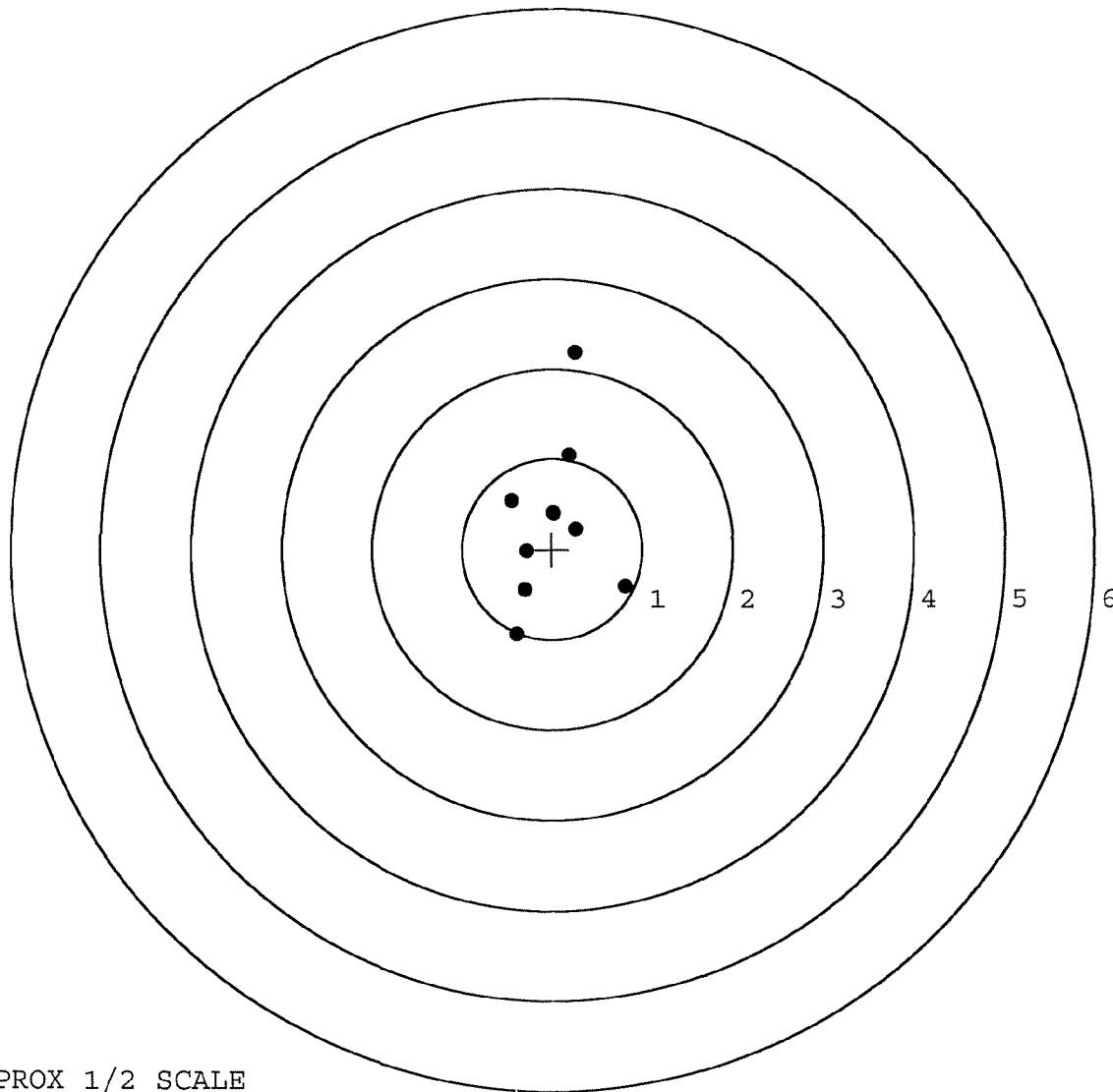
MAX RADIUS: 1.905

MEAN RADIUS: 0.729

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: E6413530. 0

TARGET NUMBER: 3

FILE DATE: 06/25/2003

FILE TIME: 07:01

POINT#	X	Y
1:	0.223	0.718
2:	0.624	0.416
3:	0.643	-0.127
4:	0.280	-0.144
5:	0.285	-0.144
6:	0.215	0.036
7:	0.288	0.348
8:	0.605	-0.304
9:	0.605	-0.304
10:	-0.196	-0.574

X CENTROID: 0.357

Y CENTROID: -0.008

POA TO CENTROID: 0.357

HORZ SPREAD: 0.839

VERT SPREAD: 1.292

GROUP SPREAD: 1.358

MIN RADIUS: 0.149

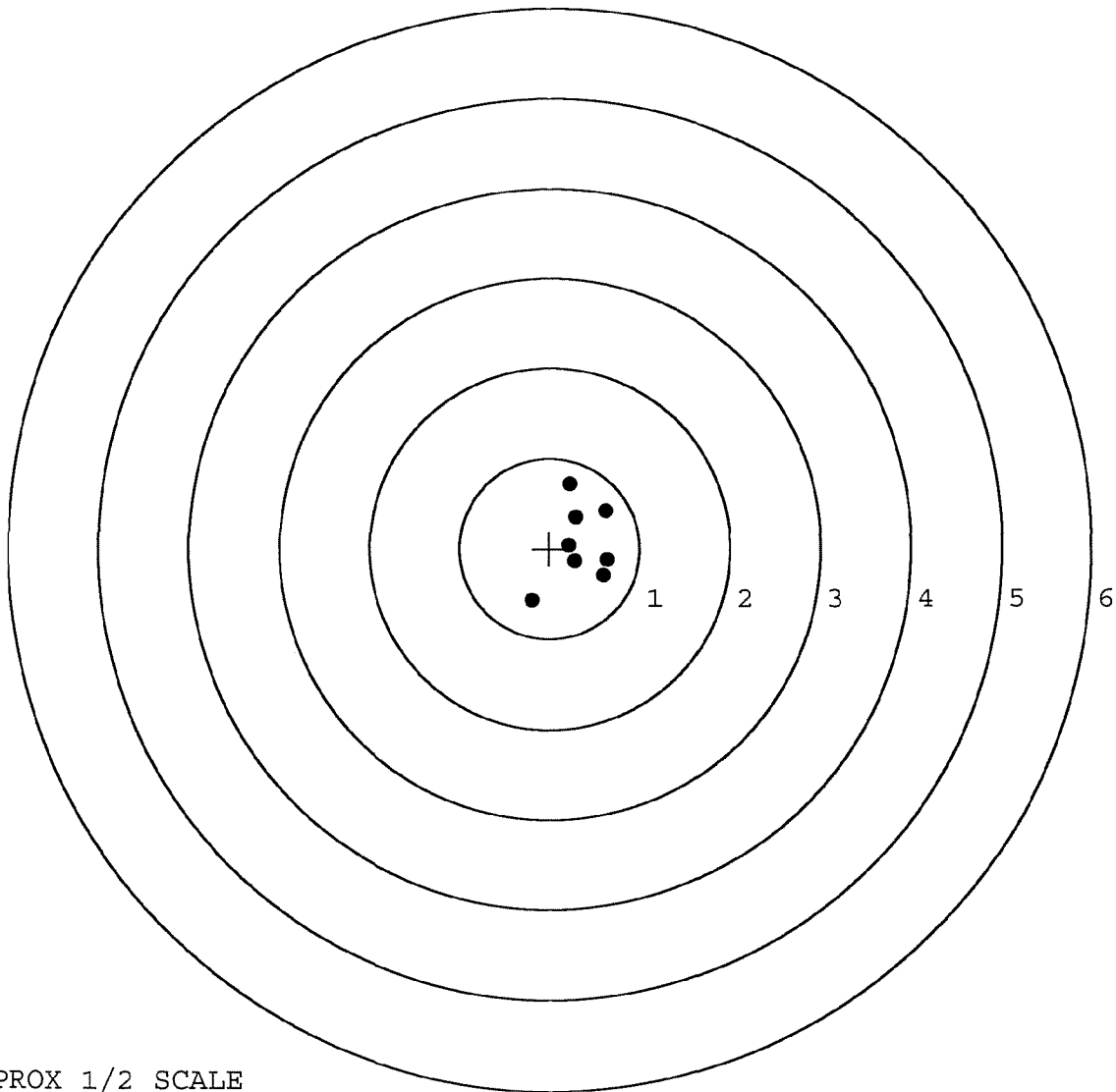
MAX RADIUS: 0.792

MEAN RADIUS: 0.393

IN 1 IN DIAMETER: 7

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: E6413530. 0

TARGET NUMBER: 4

FILE DATE: 06/25/2003

FILE TIME: 07:01

POINT#	X	Y
1:	-0.837	0.302
2:	-0.238	0.484
3:	0.013	0.464
4:	1.018	0.231
5:	0.988	-0.156
6:	0.424	-0.125
7:	-0.008	-0.567
8:	-0.267	-0.156
9:	-0.594	-0.288
10:	-0.006	-1.208

X CENTROID: 0.049

Y CENTROID: -0.102

POA TO CENTROID: 0.113

HORZ SPREAD: 1.855

VERT SPREAD: 1.692

GROUP SPREAD: 1.766

MIN RADIUS: 0.321

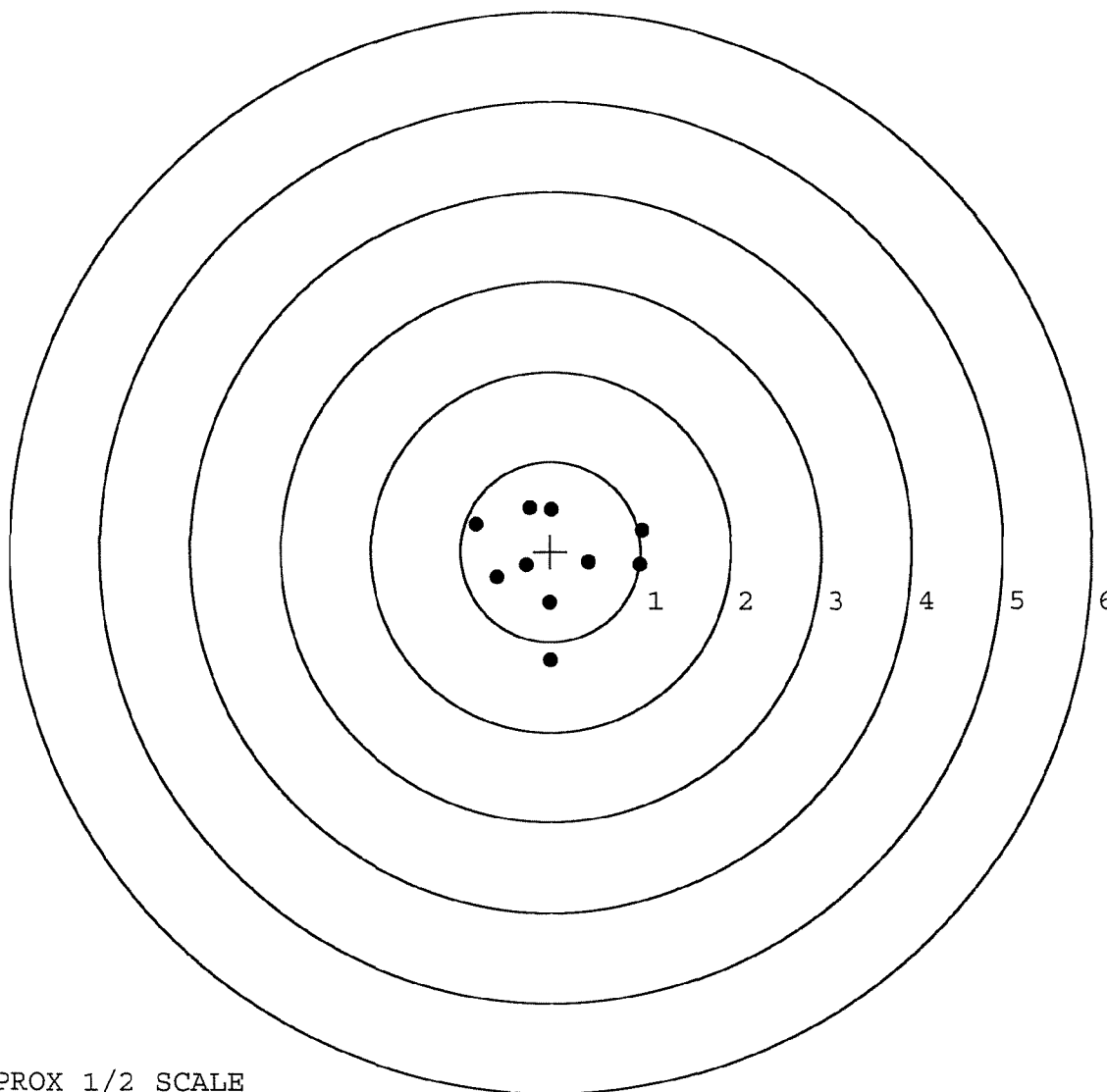
MAX RADIUS: 1.107

MEAN RADIUS: 0.710

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: E6413530. __0

TARGET NUMBER: 5

FILE DATE: 06/25/2003

FILE TIME: 07:01

POINT#	X	Y
1:	-0.160	0.914
2:	0.023	0.818
3:	0.677	0.153
4:	0.485	0.183
5:	0.254	0.102
6:	0.438	-0.778
7:	-0.931	-0.530
8:	-0.320	0.000
9:	-0.400	-0.201
10:	-0.199	-0.295

X CENTROID: -0.013

Y CENTROID: 0.037

POA TO CENTROID: 0.039

HORZ SPREAD: 1.608

VERT SPREAD: 1.692

GROUP SPREAD: 1.747

MIN RADIUS: 0.275

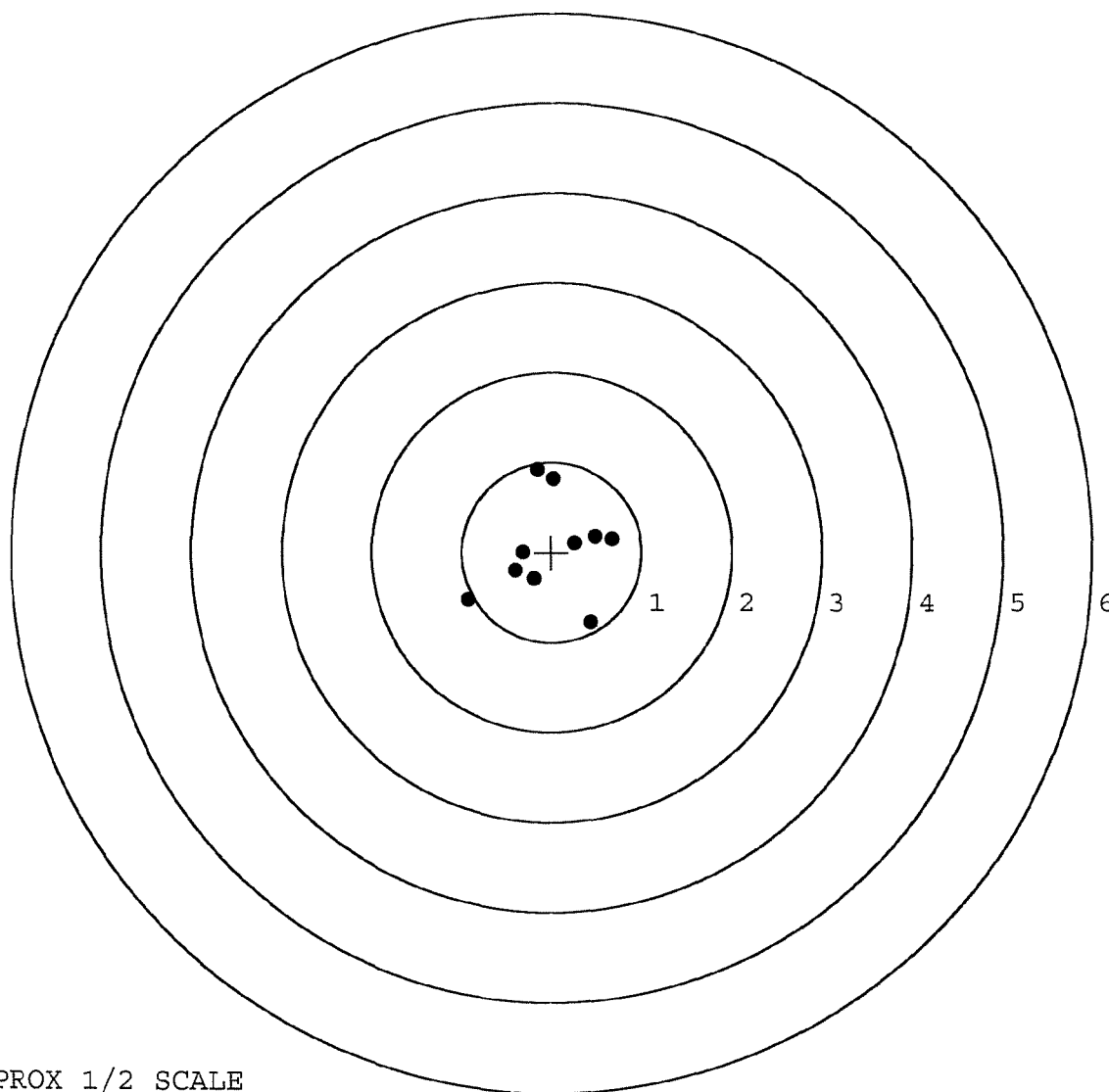
MAX RADIUS: 1.079

MEAN RADIUS: 0.632

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10



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)

SERIAL NO.

DATE

TESTER

7-19-04

TRW

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.24	2.13		2.29	
PULL #2	2.46	2.23		2.23	
PULL #3	2.41	2.39		2.26	
PULL #4	2.47	2.16		2.19	
PULL #5	2.39	2.33		2.19	
TOTAL	11.97	11.24		11.16	
AVERAGE	2.39	2.24		2.23	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.21	3.30		
PULL #2	3.31	3.34		
PULL #3	3.31	3.38		
PULL #4	3.34	3.36		
PULL #5	3.36	3.33		
TOTAL	16.53	16.71		
AVERAGE	3.30	3.34		

	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	4.32	4.27		4.64
PULL #2	4.33	4.18		4.33
PULL #3	4.33	4.15		4.41
PULL #4	4.27	4.09		4.38
PULL #5	4.27	4.11		4.44
TOTAL	21.49	20.80		22.20
AVERAGE	4.29	4.16		4.44

R & E NUMBER	83409		
SERIAL NUMBER	E6413530		
LOG-IN DATE	8-3-04		
INSPECT AND VERIFY:			
OPERATION #	OPERATION NAME	DATE	INITIAL
550	DIS-ASSEMBLE GUN	8-9-04	RTL
560 A	RE-BARREL	8-9-04	RTL
B	DRILL AND TAP	8-9-04	TRW
575	ASSEMBLE MAGNA-FLUX	8-10-04	RTL
600	PROOF INSPECTED	8-10-04	RTL
605	CHECK HEADSPACE 11 2004	8-10-04	RTL
610	DIS-ASSEMBLE GUN	8-10-04	RTL
612	MAGNAFLUX OPERATOR		
615	ROLLMARK CALIBER		
618	ROTO-BLAST	8/12/04	DG
620	APPLY COATINGS	8/12	HP
625 A	FINAL ASSEMBLY	8-16-04	RLW
B	TRIGGER PULL TEST	8-24-04	RTL
C	SAFETY "ON" FORCE	8-24-04	RTL
D	SAFETY "OFF" FORCE	8-24-04	RTL
E	FIRING PIN INDENT		
640	TARGET	8-23-04	AC
655	FINAL INSPECT	8-24-04	RTL
660	PACK	9/24/04	RA
		SHIP DATE	
QAR INSPECTION DATE			

Repair Inquiry

Repair Number: RE00066085

Serial: C6225249 Model 700 Center Fire Caliber: 7
62 NATO M24 SWS

Repairman:

Verify Repair

Status:

Closed 6/2/2003 11:22:55 AM

Address Information

Customer:

☒ Received From

Return To:

☐ Received From

Name: SUPPLY DIVISION US AIC

SUPPLY DIVISION US AIC

Address 1: BLDG 400

BLDG 400

Address 2:

PO Box

PO Box

City: FORT BENNING

FORT BENNING

State: GA

Zip Code: 31905

Country: US

State: GA

Zip Code: 31905

Country: US

FFL:

Contact / Condition

Problems

Estimate

History / Status

Shipping / Billing

Contact Information

Phone:

Fax:

Email:

Comments:

Received Condition

Fair

Condition
Notes:CSR
Notes:

Accessories Received

Code	Desc	Qty
A007	With Studs	3
A010	Hard Case	1
A017	Scope Base	2
A026	Scope	1
X001	Front Sgt Base	1

Repair Search

Refresh

Close

naglej

6/2/2003

11:46 AM

CAPS

NUM

INS

SCFL

start

5 Micros...

2 S&PGL...

Arms Servi...

Part Search...

14-M-Excel...

3 Micros...

11:46 AM

Serial Number:

C6225249

Model: 700



RE00066085

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: E6413530.___0

FILE DATE AND TIME: 06/25/2003 07:01

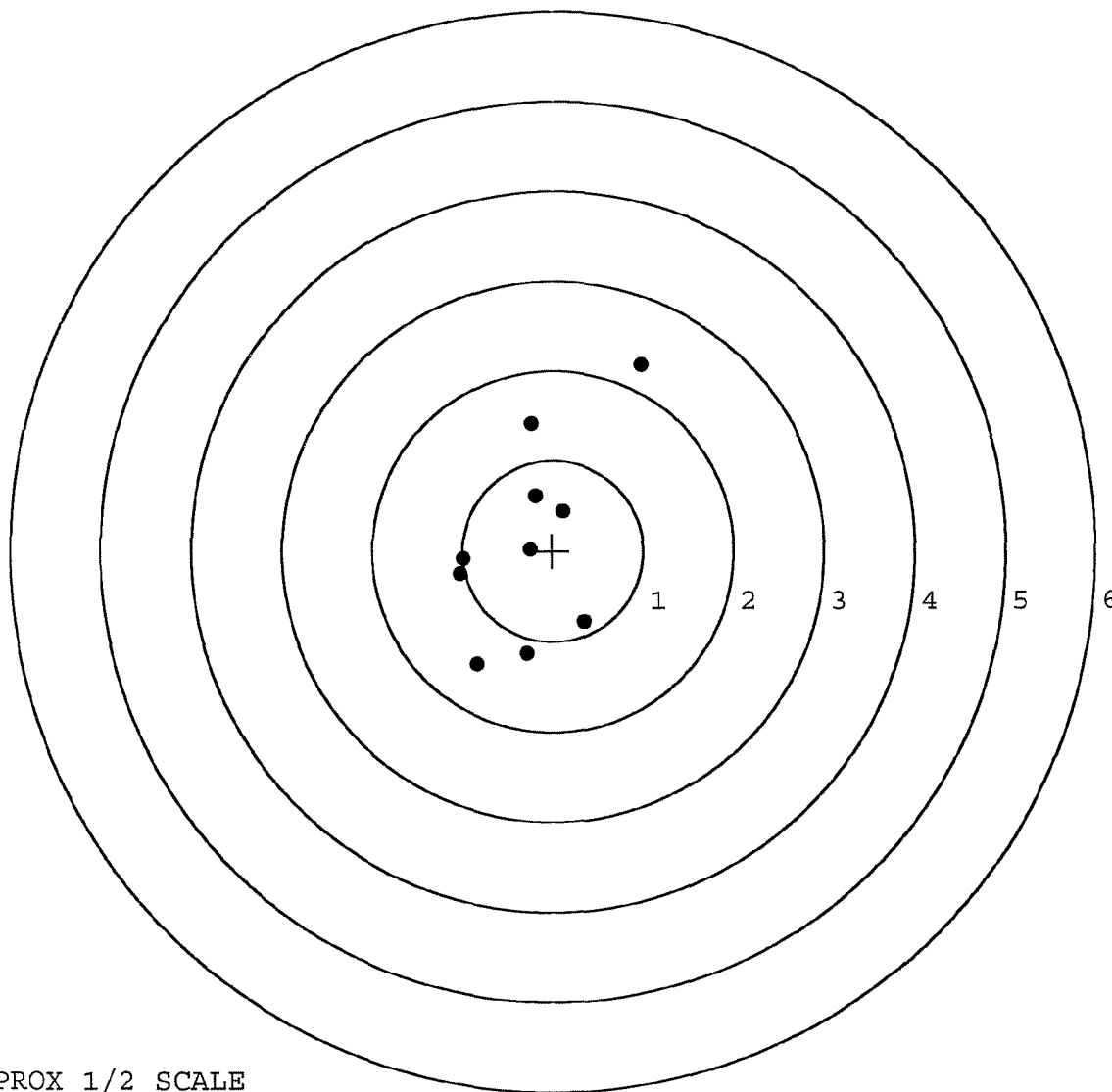
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.034
The Average Y Centroid of the Five Target Set:	0.065
The Average Point of Impact of the Five Target Set:	0.073
The Average Mean Radius of the Five Target Set:	0.695
The Distance from POA to Centroid Target #1:	0.257
The Distance from Centroid Target #2 to Centroid Target #1:	0.314
The Distance from Centroid Target #3 to Centroid Target #1:	0.603
The Distance from Centroid Target #4 to Centroid Target #1:	0.351
The Distance from Centroid Target #5 to Centroid Target #1:	0.232

SERIAL NUMBER: E6413530. __0
 TARGET NUMBER: 1
 FILE DATE: 06/25/2003
 FILE TIME: 07:01

POINT#	X	Y
1:	0.986	2.060
2:	-0.236	1.410
3:	-0.191	0.608
4:	0.115	0.434
5:	-0.244	0.022
6:	-0.991	-0.087
7:	-1.032	-0.255
8:	-0.835	-1.249
9:	-0.282	-1.137
10:	0.352	-0.781

X CENTROID: -0.236
 Y CENTROID: 0.103
 POA TO CENTROID: 0.257
 HORZ SPREAD: 2.018
 VERT SPREAD: 3.309
 GROUP SPREAD: 3.777
 MIN RADIUS: 0.081
 MAX RADIUS: 2.308
 MEAN RADIUS: 1.012
 # IN 1 IN DIAMETER: 2
 # IN 2 IN DIAMETER: 5
 # in 3 IN DIAMETER: 9

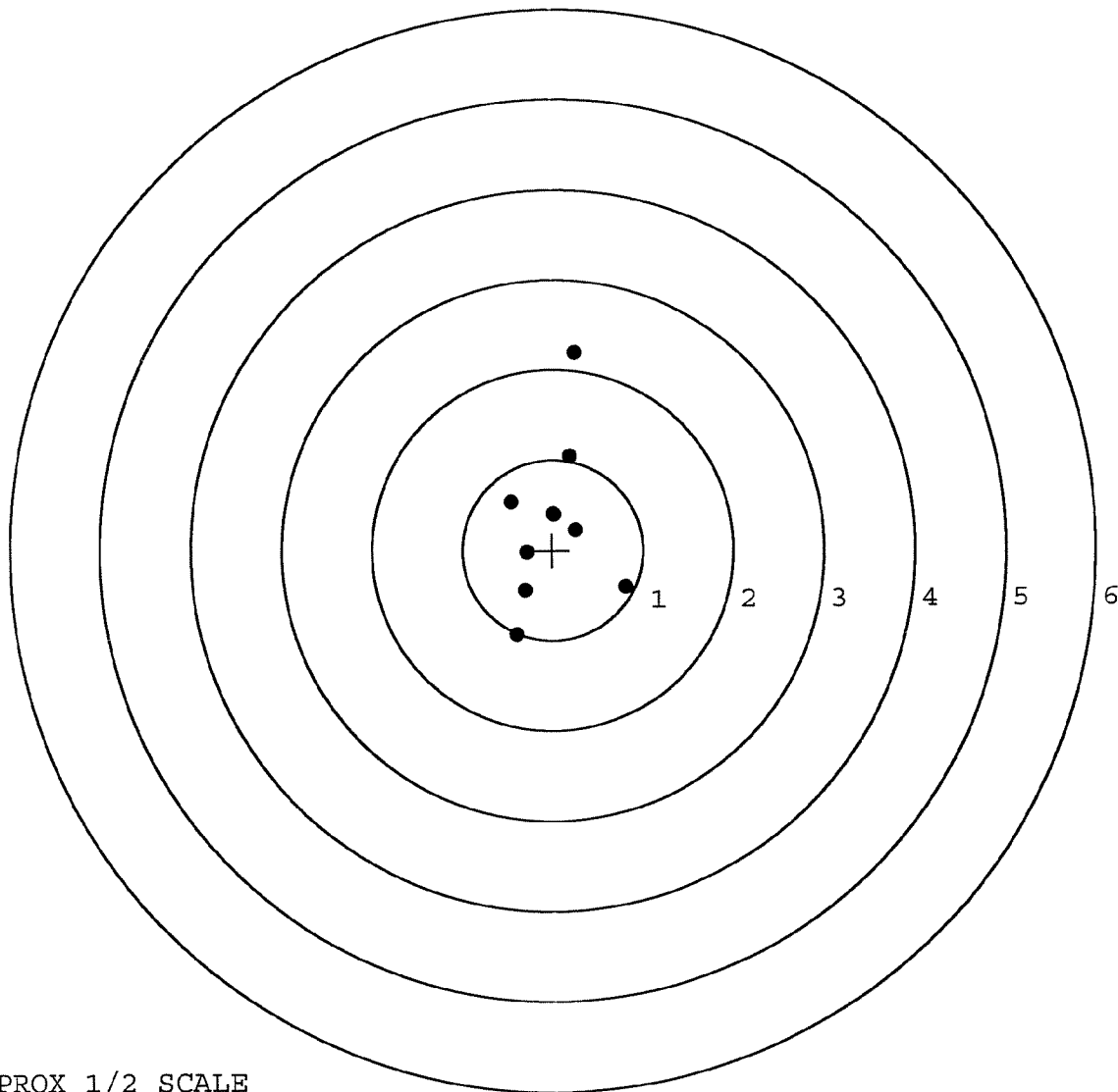


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: E6413530. 0
 TARGET NUMBER: 2
 FILE DATE: 06/25/2003
 FILE TIME: 07:01

POINT#	X	Y
1:	0.256	2.185
2:	0.200	1.040
3:	0.015	0.400
4:	0.260	0.222
5:	0.813	-0.416
6:	-0.398	-0.940
7:	-0.302	-0.447
8:	-0.281	-0.025
9:	-0.457	0.539
10:	0.008	0.404

X CENTROID: 0.011
 Y CENTROID: 0.296
 POA TO CENTROID: 0.296
 HORZ SPREAD: 1.270
 VERT SPREAD: 3.125
 GROUP SPREAD: 3.193
 MIN RADIUS: 0.104
 MAX RADIUS: 1.905
 MEAN RADIUS: 0.729
 # IN 1 IN DIAMETER: 4
 # IN 2 IN DIAMETER: 7
 # in 3 IN DIAMETER: 9



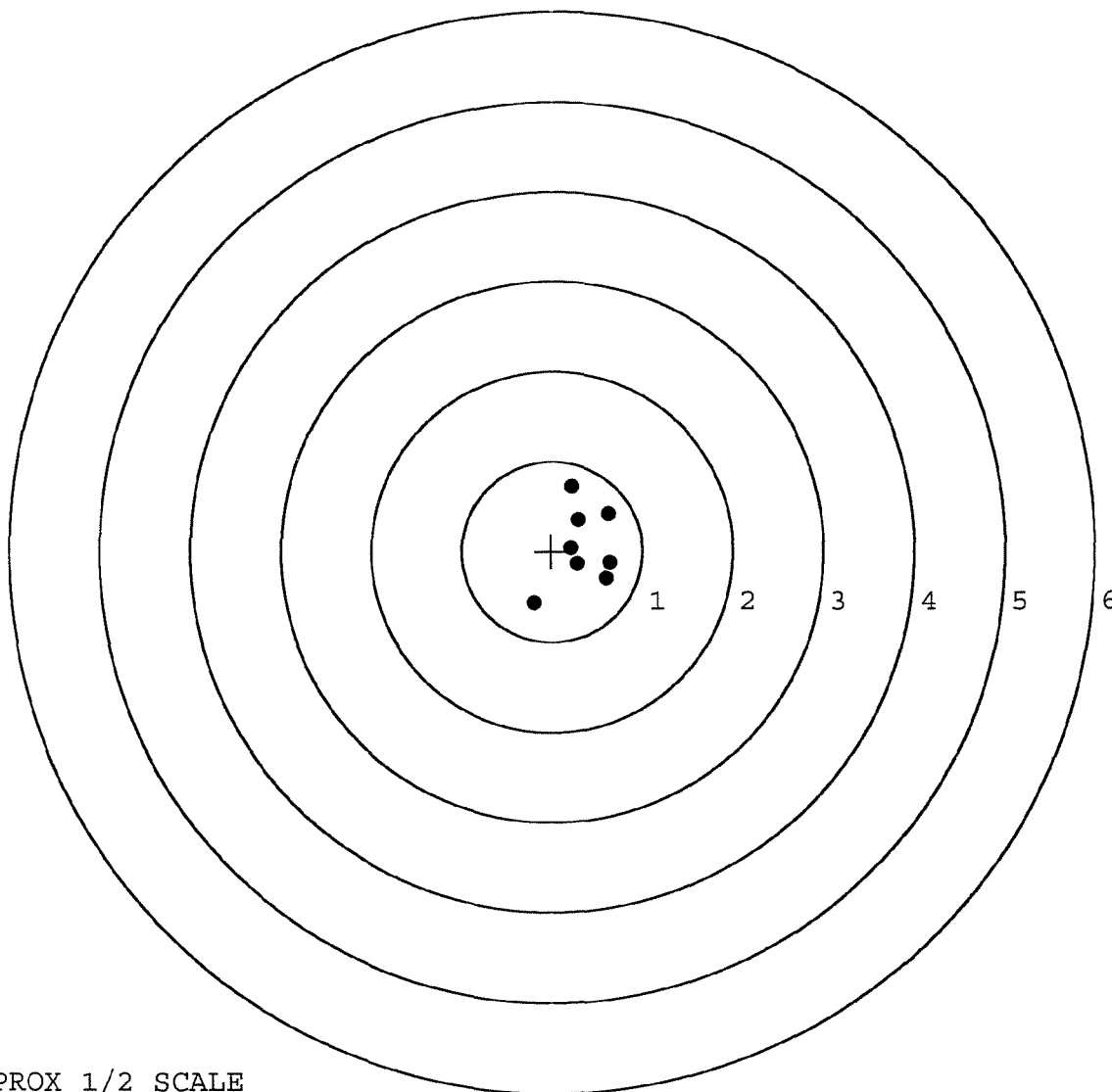
TARGET APPROX 1/2 SCALE

BARBER - M24 0179797

SERIAL NUMBER: E6413530. __0
 TARGET NUMBER: 3
 FILE DATE: 06/25/2003
 FILE TIME: 07:01

POINT#	X	Y
1:	0.223	0.718
2:	0.624	0.416
3:	0.643	-0.127
4:	0.280	-0.144
5:	0.285	-0.144
6:	0.215	0.036
7:	0.288	0.348
8:	0.605	-0.304
9:	0.605	-0.304
10:	-0.196	-0.574

X CENTROID: 0.357
 Y CENTROID: -0.008
 POA TO CENTROID: 0.357
 HORZ SPREAD: 0.839
 VERT SPREAD: 1.292
 GROUP SPREAD: 1.358
 MIN RADIUS: 0.149
 MAX RADIUS: 0.792
 MEAN RADIUS: 0.393
 # IN 1 IN DIAMETER: 7
 # IN 2 IN DIAMETER: 10
 # in 3 IN DIAMETER: 10

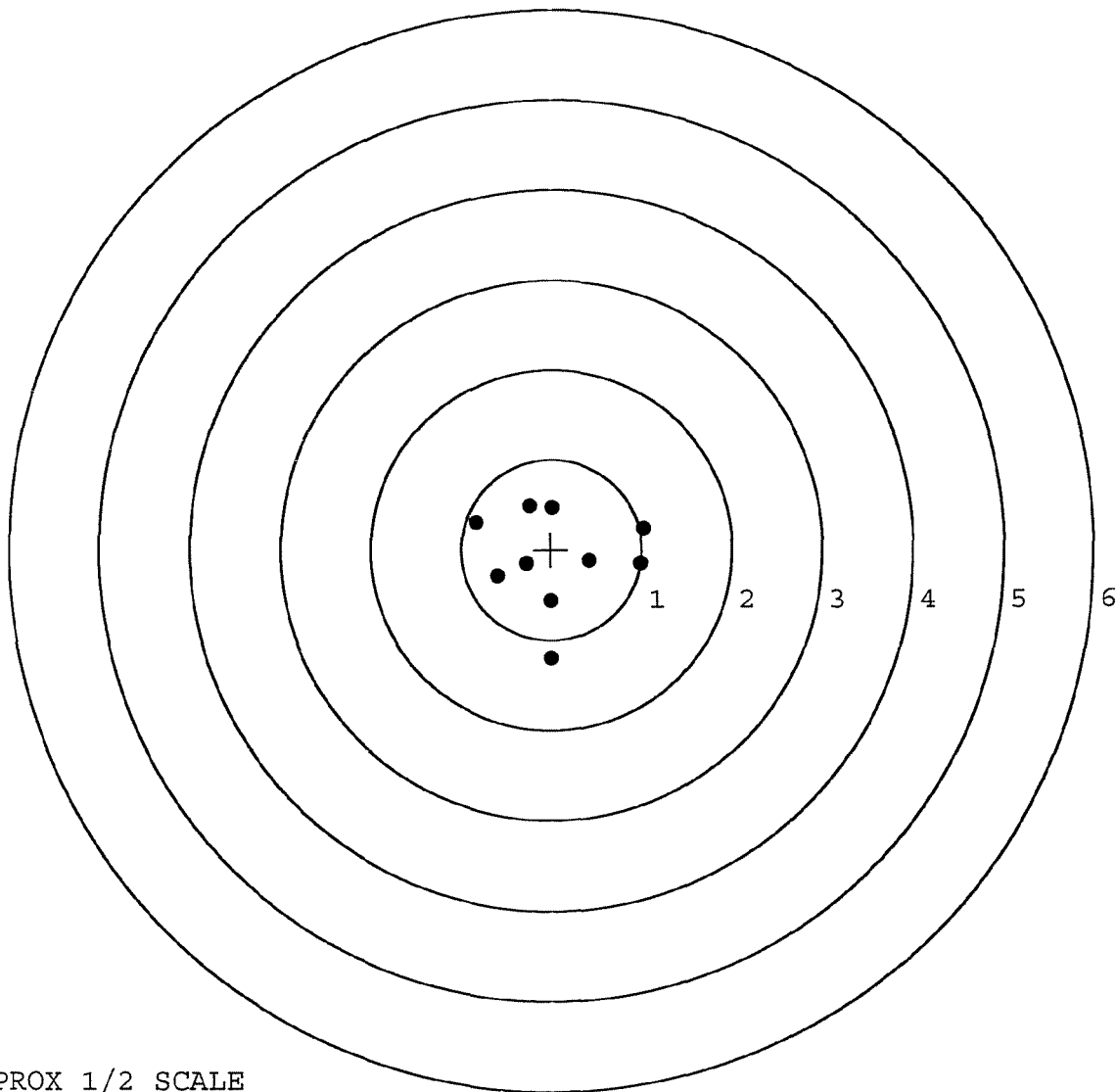


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: E6413530. __0
 TARGET NUMBER: 4
 FILE DATE: 06/25/2003
 FILE TIME: 07:01

POINT#	X	Y
1:	-0.837	0.302
2:	-0.238	0.484
3:	0.013	0.464
4:	1.018	0.231
5:	0.988	-0.156
6:	0.424	-0.125
7:	-0.008	-0.567
8:	-0.267	-0.156
9:	-0.594	-0.288
10:	-0.006	-1.208

X CENTROID: 0.049
 Y CENTROID: -0.102
 POA TO CENTROID: 0.113
 HORZ SPREAD: 1.855
 VERT SPREAD: 1.692
 GROUP SPREAD: 1.766
 MIN RADIUS: 0.321
 MAX RADIUS: 1.107
 MEAN RADIUS: 0.710
 # IN 1 IN DIAMETER: 3
 # IN 2 IN DIAMETER: 8
 # in 3 IN DIAMETER: 10



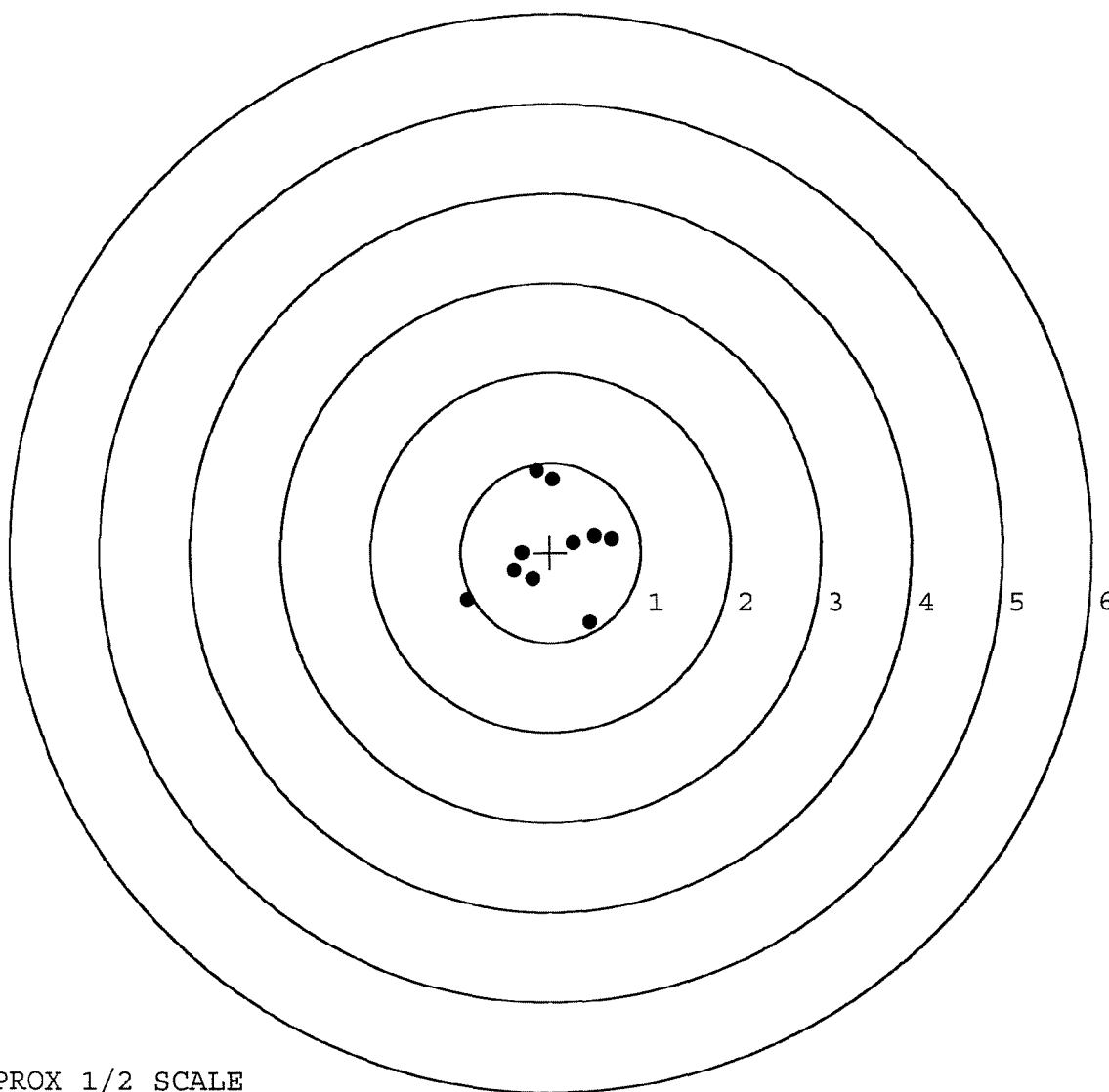
TARGET APPROX 1/2 SCALE

BARBER - M24 0179799

SERIAL NUMBER: E6413530. __0
 TARGET NUMBER: 5
 FILE DATE: 06/25/2003
 FILE TIME: 07:01

POINT#	X	Y
1:	-0.160	0.914
2:	0.023	0.818
3:	0.677	0.153
4:	0.485	0.183
5:	0.254	0.102
6:	0.438	-0.778
7:	-0.931	-0.530
8:	-0.320	0.000
9:	-0.400	-0.201
10:	-0.199	-0.295

X CENTROID: -0.013
 Y CENTROID: 0.037
 POA TO CENTROID: 0.039
 HORZ SPREAD: 1.608
 VERT SPREAD: 1.692
 GROUP SPREAD: 1.747
 MIN RADIUS: 0.275
 MAX RADIUS: 1.079
 MEAN RADIUS: 0.632
 # IN 1 IN DIAMETER: 4
 # IN 2 IN DIAMETER: 9
 # in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL # FL6413530INSPECTED BY: RJLDATE REC'D: 6-2-03DATE RET'D: 6-26-03

ITEM

BARREL ASSEMBLY

☒ BARREL
☒ RECEIVER
☒ FRONT SIGHT BASE
☒ REAR SIGHT BASE
☒ SCREWS
☒ FINISH

SCOPE ASSEMBLY

☒ SCOPE
☒ SCOPE RINGS
☒ MOUNTING SCREWS
☒ MOUNTING BASE
☒ SCREWS
☒ FINISH
☒ CLARITY

ITEM

STOCK ASSEMBLY

☒ STOCK
☒ SLING AWIVEL STUDS
☒ ADJUSTABLE
☒ BUTT PLATE
☒ LOCK NUTS
☒ BARREL CLEARANCE
☒ COLOR / FINISH

SYSTEMS CASE

☒ SCOPE CASE
☒ IRON SIGHTS
☒ DEPLOYMENT KIT

TRIGGER ASSEMBLY

☒ SAFETY OPERATION
☒ RE-SET TO FACTORY SPECS

COMMENTS:

R & E NUMBER	66085		
SERIAL NUMBER	66225249 E6043530 (New)		
LOG-IN DATE	6-2-03		
INSPECT AND VERIFY:			
OPERATION #	OPERATION NAME	DATE	INITIAL
550	DIS-ASSEMBLE GUN	6-4-03	RTL
560 A	RE-BARREL	6-5-03	RTL
B	DRILL AND TAP	6-5-03	TRW
575	ASSEMBLE	6-5-03	RTL
600	PROOF	6-5-03	AC
605	CHECK HEADSPACE	6-5-03	AC
610	DIS-ASSEMBLE GUN	6-5-03	RTL
612	MAGNAFLUX		
615	ROLLMARK CALIBER	6-17-03	JS
618	ROTO-BLAST	6-17-03	JB
620	APPLY COATINGS	6-19-03	TA
625 A	FINAL ASSEMBLY	6-24-03	RTL
B	TRIGGER PULL TEST		
C	SAFETY "ON" FORCE		
D	SAFETY "OFF" FORCE		
E	FIRING PIN INDENT		
640	TARGET	6-25-03	AC
655	FINAL INSPECT	6-26-03	RTL
660	PACK	6-26-03	199A
		SHIP DATE	
	QAR INSPECTION DATE		

10/88 GUN
BARBER - M24 0179802
REWORKED 8/89

NEW BARREL
M-24

SCORE #
87-1160

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6225249

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		APR 23 1991	RW
600	Proof		APR 23 1991	RW
607	Check Headspace		APR 23 1991	RW
610	Dis-assemble Gun		APR 23 1991	RW
612	Magnaflux Barrel Action		APR 24 1991	KCR
	Magnaflux Bolt		APR 24 1991	KCR
615	Rollmark Caliber		APR 24 1991	GL
617	Drill and Tap Sight Holes		APR 25 1991	FB
618	Polish Barrel		APR 25 1991	WB
620	Apply Coatings (Barrel Action)		APR 26 1991	TJA
	Apply Coating (Bolt)		APR 26 1991	TJA
625	Final Assembly A) Clean inside of Bolt Assembly		5/7/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/7/91	RW
	C) Inspect Ejector Hole for Chamfer		5/7/91	RW
	D) Oil Firing Pin Ass'y		5/7/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		5-9-91	DH

BARBER - M24 0179803		READINGS					DATE	INIT
op. #	OP. NAME							
625 cont.	F) Safety On Force	7	6	6			5-10-91	AC
	G) Safety Off Force	4	4	4			5-10-91	AC
	H) Trigger Pull Test & Retainability						5-9-91	D/H
	I) Firing Pin Indent	.20	.20	.21			5-10-91	AC
	J) Assemble Stock						5/11/91	RW
	K) Assemble Swivel Studs						5/11/91	RW
	L) Attach Front and Rear Sight Assemblies						5/11/91	RW
	M) Iron Sight Alignment						5/11/91	RW
	N) Detach Front & Rear Sights & place in numbered container						5/11/91	RW
	O) Attach Scope to Rifle						5/11/91	RW
	P) Detach & Attach Scope 20 Times						5/11/91	RW
640	Gallery Target & Test						5/11/91	KT
	A) Time						"	KT
	B) Malfunctions						"	KT
	C) Pierced Primers						"	KT
	D) Optical Clarity of Scope						"	KT
645	Inspect for Live Ammo						5/11/91	KT
655	Final Inspection							
	A) Headspace						5/13/91	RW
	B) Trigger Pull	2.24	2.29	2.29	2.30	2.34	5/13/91	JLL
	C) Function						5/13/91	RW
660	Pack						5/18/91	W.B

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C6225249

DATE 5-9-91

TESTER D/H

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.44	2.48	2.61	2.24	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.43	2.56	2.77	2.29	
PULL #3	2.48	2.59	2.75	2.29	
PULL #4	2.31	2.59	2.69	2.30	
PULL #5	2.42	2.62	2.48	2.34	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.15	3.06		
PULL #2	3.18	3.11		
PULL #3	3.10	3.17		
PULL #4	3.15	3.16		
PULL #5	3.14	3.17		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.22	4.31		4.17
PULL #2	4.29	4.26		4.09
PULL #3	4.27	4.25		4.21
PULL #4	4.17	4.30		4.21
PULL #5	4.24	4.29		4.20
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6225249
11 May 1991

CENTROIDAL DISTANCES

0 TO 1	.448074
1 TO 2	.476064
1 TO 3	.691874
1 TO 4	.571399
1 TO 5	.489102

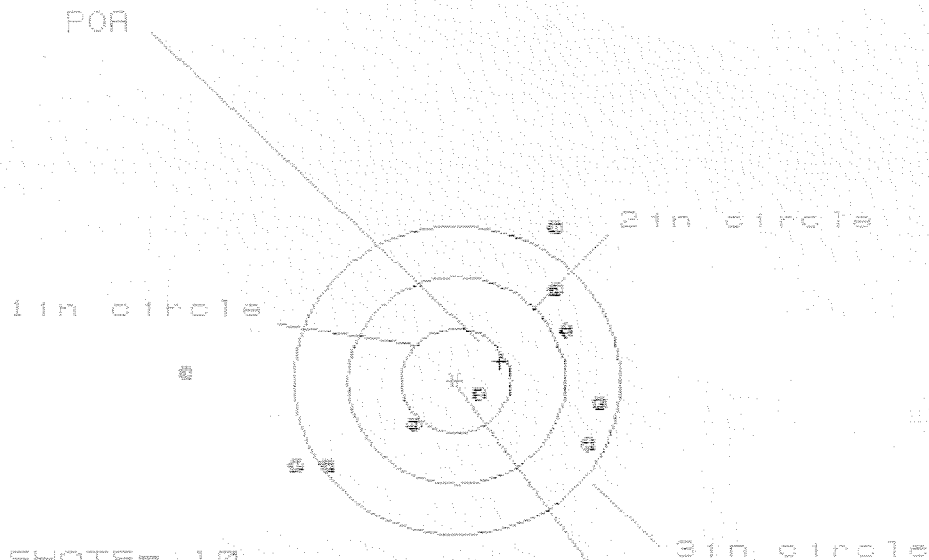
1 7 4 ----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0266
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0408
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0487052
THE AMR FOR THIS RIFLE IS: .944

11 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6225249

CENTERFIRE PATTERNS # 1



OF SHOTS - 10

IN CIR

1 in = 1

2 in = 2

3 in = 7

HE = 3.737

VS = 2.243

GS = 3.747

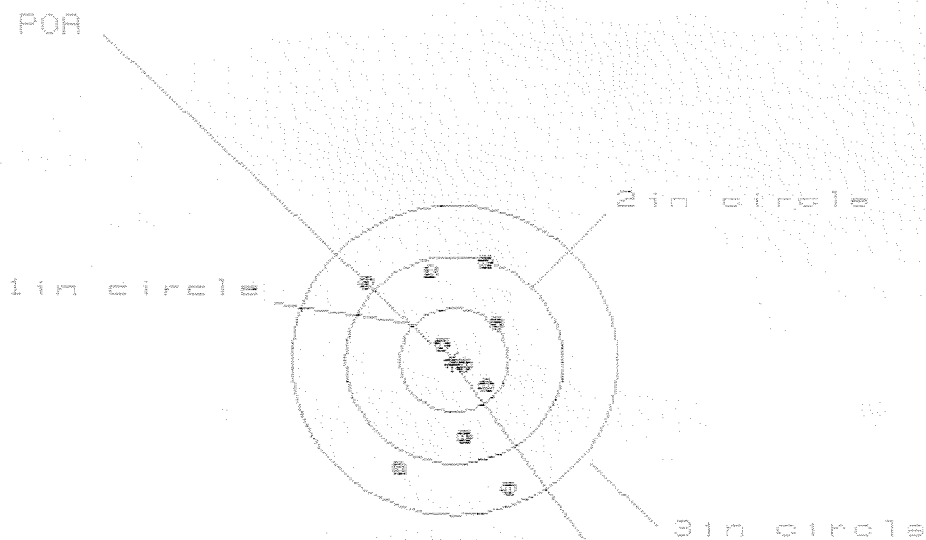
PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.282	1.009	1.091
MINIMUM X	-2.455	-1.774	-1.692
MAXIMUM Y	1.446	1.454	1.116
MINIMUM Y	-1.797	-1.789	-1.687
CENTROID X	-1.409	-1.136	-1.219
CENTROID Y	-1.183	-1.191	-1.373
POA TO CENTROID in.	.448	.235	.422
MIN RADIUS	.185	.141	.102
MEAN RADIUS	1.308	1.136	1.070
MAX RADIUS	2.456	1.937	1.793
HORIZONTAL SPREAD	3.737	2.783	2.783
VERTICAL SPREAD	2.243	2.243	1.723
EXTREME SPREAD	3.747	3.300	2.977
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	2		
NUMBER IN THREE INCH CIRCLE =	7		

11 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6225249

CENTERFIRE PATTERNS

2



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 6

3 in = 10

HS= 1.305

VS= 2.185

GS= 2.375

PATTERN #

2

SHOTS (BEST OF)

10

9

8

MAXIMUM X

.528

.428

.368

MINIMUM X

-.785

-.728

-.788

MAXIMUM Y

.983

.849

.708

MINIMUM Y

-1.282

-1.133

-.974

CENTROID X

.010

-.047

.013

CENTROID Y

.043

.177

.319

POA TO CENTROID in.

.045

.183

.319

MIN RADIUS

.089

.050

.132

MEAN RADIUS

.736

.665

.591

MAX RADIUS

1.310

1.233

.979

HORIZONTAL SPREAD

1.305

1.156

1.156

VERTICAL SPREAD

2.185

1.982

1.681

EXTREME SPREAD

2.375

2.137

1.727

NUMBER IN ONE INCH CIRCLE =

3

NUMBER IN TWO INCH CIRCLE =

6

NUMBER IN THREE INCH CIRCLE =

10

11 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6225249

CENTERFIRE PATTERNS

3

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= 3.186

VS= 1.795

GS= 3.254

CENTROID #

PATTERN #

5

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.338	1.133	.681
MINIMUM X	-1.848	-1.202	-1.060
MAXIMUM Y	.907	.851	.864
MINIMUM Y	-.888	-.944	-.931
CENTROID X	.180	.385	.243
CENTROID Y	.180	.236	.223
POA TO CENTROID in.	.254	.452	.330
MIN RADIUS	.206	.109	.131
MEAN RADIUS	.877	.722	.673
MAX RADIUS	1.916	1.214	1.072
HORIZONTAL SPREAD	3.186	2.335	1.741
VERTICAL SPREAD	1.795	1.795	1.795
EXTREME SPREAD	3.254	2.351	1.877
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		9	

11 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06225249

CENTERFIRE PATTERNS

4

POA

1in circle

2in circle

3in circle

CENTROID #

OF SHOTS= 10

IN CIR

1in = 3

2in = 5

3in = 8

HS= 1.987

VS= 3.714

CS= 3.714

PATTERN #

21

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.279

1.235

1.174

MINIMUM X

-.708

-.752

-.813

MAXIMUM Y

1.617

1.384

1.289

MINIMUM Y

-2.097

-1.112

-.939

CENTROID X

.120

.164

.225

CENTROID Y

.033

.266

.093

POA TO CENTROID in.

.125

.312

.243

MIN RADIUS

.241

.172

.273

MEAN RADIUS

1.025

.898

.812

MAX RADIUS

2.134

1.467

1.347

HORIZONTAL SPREAD

1.987

1.987

1.987

VERTICAL SPREAD

3.714

2.496

2.148

EXTREME SPREAD

3.714

2.609

2.489

NUMBER IN ONE INCH CIRCLE =

3

NUMBER IN TWO INCH CIRCLE =

5

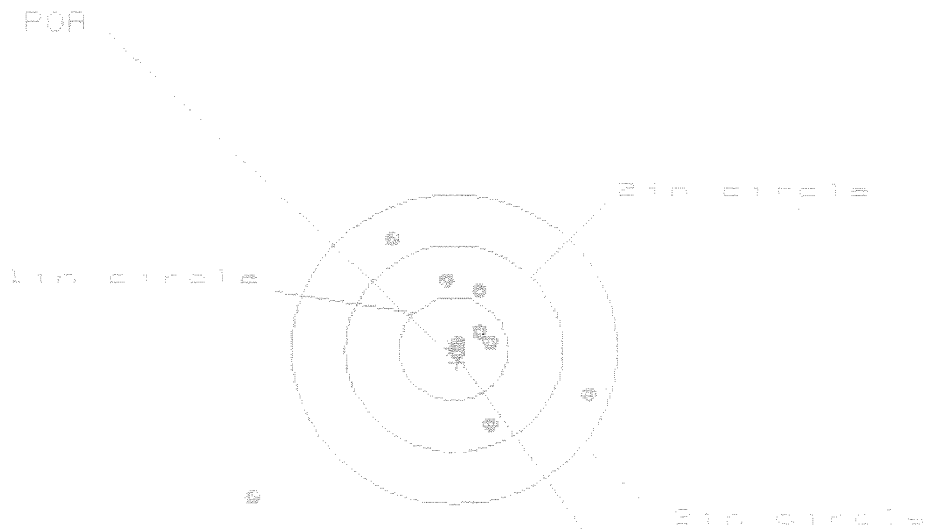
NUMBER IN THREE INCH CIRCLE =

8

11 May 1981

FILE: PATTERNING/CENTERFIRE_PATT-08120243

CENTERFIRE PATTERNS # 5



OF SHOTS = 10

IN CIR

1 in = 4

2 in = 7

3 in = 9

HE = 0.072

VE = 0.563

ED = 0.006

PATTERN #

SHOTS (BEST OF)

	10	9	8
MAXIMUM X	1.154	.985	.297
MINIMUM X	-1.878	-1.749	-.625
MAXIMUM Y	1.090	.933	.859
MINIMUM Y	-1.413	-.885	-.959
CENTROID X	-.034	.175	.052
CENTROID Y	.131	.288	.362
POA TO CENTROID in.	.135	.337	.355
MIN RADIUS	.039	.043	.152
MEAN RADIUS	.774	.549	.481
MAX RADIUS	2.350	1.196	1.063
HORIZONTAL SPREAD	3.072	1.734	.929
VERTICAL SPREAD	2.503	1.818	1.818
EXTREME SPREAD	3.225	2.307	2.039
NUMBER IN ONE INCH CIRCLE =		4	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		9	

PAGE NO.

NO. OF PAGES

REQUIREMENTS CONTROL SYMBOL
CSGLD - 1047(R1)

SECTION I - EQUIPMENT DATA

16A. DESCRIBE DEFICIENCIES OR SYMPTOMS ON THE BASIS OF COMPLETE CHECKOUT AND DIAGNOSTIC PROCEDURE IN EQUIPMENT TM (Do not prescribe repairs)

See Attached 2404, check the whole weapon system

B. REMARKS

SECTION II - WORK ACCOMPLISHED

17A. REPAIR ORGANIZATION/ACTIVITY MAINT DIV, DOI						C. UNIT IDENT. CODE			18. TYPE ORGANIZATION/ACTIVITY ACCOMPLISHING WORK (Select one - use ✓ or X)			19. AMS ACCT. CODE				
B. LOCATION FT BENNING, GA 31905									☐ 1 TOE ☐ 2 TD ☐ 3 Contractor							
20A. ACT. CODE		B. FAILURE CODE		C. COMPONENT/PART NOUN, SVC, OR MWO NO.			D. MANHOURS (Hrs. & tenths)		E. NATIONAL STOCK NUMBER		F. PART SOURCE CODE		G. QTY.		H. PARTS COST	
(1) CB CODE		(2) REF DESIGN.		(3) MFR. CODE												
							.								\$	
							.								\$	
							.								\$	
							.								\$	
							.								\$	
							.								\$	
							.								\$	
							.								\$	
							.		RX REPARABLE EX						\$	
							.		BENCH STOCK						\$	
							.		OTHER PARTS						\$	
							I. TOTAL MANHOURS		J. TOTAL MANHOURS COST \$		K. TOTAL PARTS COST \$					
21. DELAY (Select One)		☐ 1 Parts		☐ 2 Manpower		☐ 3 Facilities		☐ 4 Funds		☐ 5 Tools		22.		Data Transcribed		
23. SUBMITTED BY <i>[Signature]</i>		24. RECEIVED BY		25. WORK STARTED BY		26. INSPECTED BY		27. ACCEPTED BY		28. DISPOSITION (Select One)						
										☐ A To User ☐ D Evacuated ☐ B To Stock ☐ E Cannibalization ☐ C Salvaged						
JULIAN DATE		JULIAN DATE		JULIAN DATE		JULIAN DATE		JULIAN DATE								

RECEIVING AND ESTIMATING REPORT

INITIAL		CUSTOMER ORDER NO.		COMMENTS			
# B #				WOG 1 OF 4/MODEL M24/RECEIVED W BOLT #6225300 W LEUFOLD SCOPE 10 POWER			
DATE RECEIVED	DATE OPENED	DATE CODE	SERIAL NUMBER	MODEL AND GRADE		ORDER	
04/05/89	04/10/89	KI 5-88	C6225249	9999	7.62 NATO	R 89-11999	
ACCESSORIES NO SLING STRAP W/STUDS W/SWIVELS							

FROM:

MAINTENANCE DIVISION USAIC
ATT ATZB-DL-MA-Q BLDG 228
FORT BENNING GA 31905-5174

SHIP TO:

MAINTENANCE DIVISION USAIC
ATT ATZB-DL-MA-Q BLDG 228
FORT BENNING GA

31905-5174

ACCOUNT NUMBER	ACCOUNT NUMBER N/C	WRITE ☐	PROM. DATE	ESTIMATED	VIA
					UPS

REPAIR CHARGE	TAX	INSURANCE	UPS	PARCEL POST	TOTAL

GUN CONDITION:

☐ NEW☐ SLIGHTLY WORN☒ VERY WORN☐ MISUSED☐ MARRED

CUSTOMER'S REQUEST

BARREL COATING SCRATCHES OFF
BE FIT STOCK TO BARREL ACTION

MAIN FAULT

1) STRIP & APPLY NEW BARREL COATING

MISSING PARTS IN DEPLOYMENT
KIT REPLACED.

2) TOUCH-UP TRIGGER GUARD & FLOOR PLATE

3) REPAIR & FIT STOCK TO BARREL ACTION

4) CLEAN & TEST TRIGGER ASSEMBLY

5) CLEAN COMPONENT CARRYING CASE

1- 96106 - M16 CLEANING BRUSH

1- 16935 - CHAMBER BRUSH

1- 96042 - SCOPE DIAL DUST COVER

1- 96114 - BORE BRUSH

1- 96115 - OIL BOTTLE

1- 96116 - CLEANING PATCHES

1- 96053 - LENS CLEANING KIT.

REPAIRMAN	PROOF	CLEAN	TEST	TARGET	PATTERN
RW		DH	DH	DH	DH
GALLERY TESTER	DATE	DATE	DATE	DATE	DATE
DH-OK		4/11/89	4/11/89	4/11/89	4/11/89

RD6925 REV. 6/88

OFFICE COPY

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C 6725249

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock			
600	Proof			
607	Check Headspace			
610	Dis-assemble Gun			
612	Magnaflux Barrel Action			
	Magnaflux Bolt			
615	Rollmark Caliber			
617	Drill and Tap Sight Holes			
618	Polish Barrel RB		2/24/89	W.B
620	Apply Coatings (Barrel Action)		2/25/89	TA
	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		2/28/89	J.C

op. #	BARBER - M24 0179816 OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force							
	G) Safety Off Force							
	H) Trigger Pull Test & Retainability						7/28/89	AC
	I) Firing Pin Indent							
	J) Assemble Stock						7/21/89	RW
	K) Assemble Swivel Studs						8/1/89	WB
	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							
	A) Time							
	B) Malfunctions							
	C) Pierced Primers							
	D) Optical Clarity of Scope							
645	Inspect for Live Ammo							
655	Final Inspection						8/1/89	AS
	A) Headspace							
	B) Trigger Pull	2.85	2.87	2.19	2.52	2.72	7/2/89	AS
	C) Function						7/2/89	AS
660	Pack						7/2/89	WB

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C6225249

DATE 28 July 89

TESTER J.W.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & ³⁰ TO RESET 2.50#		COMMENTS
PULL #1	2.70		2.68	2.85	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.73		2.77	2.87	
PULL #3	2.68		2.69	2.19	
PULL #4	2.62		2.66	2.53	
PULL #5	2.69		2.72	2.29	
TOTAL	13.32		13.52	12.72	
AVG.	2.664		2.704	2.544	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1				
PULL #2				
PULL #3				
PULL #4				
PULL #5				
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.24			
PULL #2	4.25			
PULL #3	4.28			
PULL #4	4.15			
PULL #5	4.28			
TOTAL	21.20			
AVG.	4.24			

[illegible]

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C 6225249

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock			
600	Proof			
607	Check Headspace			
610	Dis-assemble Gun			
612	Magnaflux Barrel Action			
	Magnaflux Bolt			
615	Rollmark Caliber			
617	Drill and Tap Sight Holes			
618	Polish Barrel			
620	Apply Coatings (Barrel Action)		4/7/89	TJA
	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			

op. #	BARBER - M24 0179820 OP. NAME	READINGS	DATE	INIT
625 cont.	F) Safety On Force			
	G) Safety Off Force			
	H) Trigger Pull Test & Retainability			
	I) Firing Pin Indent			
	J) Assemble Stock			
	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	79 R 76E SIGHT-IN #	DH	4/11/89
	A) Time	91-10 SHOT GROUPS		
	B) Malfunctions		DH	4/11/89
	C) Pierced Primers		H	4/11/89
	D) Optical Clarity of Scope			89
645	Inspect for Live Ammo		DH	4/11/89
655	Final Inspection A) Headspace		12 Apr 89	952
	B) Trigger Pull	244 2.60 2.67 2.62 2.56	12 Apr 89	958
	C) Function		12 Apr 89	958
660	Pack			

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

SERIAL NO. C6225249
DATE 10 April 89
TESTER JSB

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.37	2.19			MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.56	2.25			
PULL #3	2.40	2.26			
PULL #4	2.67	2.24			
PULL #5	2.58	2.26			
TOTAL	12.58	11.20			
AVG.	2.516	2.24			

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1				
PULL #2				
PULL #3				
PULL #4				
PULL #5				
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1				
PULL #2				
PULL #3				
PULL #4				
PULL #5				
TOTAL				
AVG.				

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # *C6225-249*

OPERATION		DATE	INT
#	NAME		
575-580	ASSEMBLY	1/22	FB
600	PROOF	1/28/88	RW
615	MAGNAFLUX BARREL	2/18/88	P/C
	MAGNAFLUX BOLT	5/13/88	P/C
620	COATING	8/11/88	TJA
625-630	FINAL ASSEMBLY		
635	TEST		
640	TARGET		
	FIRING PIN INDENT		
660	PACK		

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6225249

OP. #	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and stock	QUALITY AUDIT		
600	Proof			
607	Check Headspace			
610	Dis-assemble gun			
612	Magnaflux Barrel Action			
	Magnaflux Bolt			
615	Rollmark Caliber			
617	Drill & Tap Sight Holes			
618	Polish Barrel			
620	Apply Coatings (Barrel Action)			
	Apply Coatings (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/23/88	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/23/88	RW
	C) Inspect Ejector Hole for Chamfer		8/23/88	RW

OVER

OP.#		READINGS	DATE	INITIAL
625 cont.	D) Oil Firing Pin Ass'y		8/23/88	RW
	E) Adjust Trigger Pull to Min. Setting and Stake		25aug88	J.W. + R.S.
	F) Safety on Force	5.25 5.25 5.5	25aug88	J.W. + R.S.
	G) Safety off Force	4 3 3.25	25aug88	J.W. + R.S.
	H) Trigger Pull Test & Retainabilty		25aug88	J.W. + R.S.
	I) Firing Pin Indent	.022 .022 .022	25aug88	J.W. + R.S.
	J) Assemble Stock		8/25/88	RW
	K) Assemble Swivel Studs			
	L) Attach Front & Rear Sight Assemblies		8/25/88	RW
	M) Iron Sight Alignment		9/2/88	RW
	N) Detach Front & Rear Sights & place in numbered container		9/2/88	RW
	O) Attach Scope to Rifle	75 R 80L 48E	9/2/88	RW
	P) Detach & Attach Scope 20 times		9/8/88	W.B.
640	Gallery Target & Test	13:20	9/9/88	D.H.
	A) Optical Clarity of Scope	OK	9/9/88	D.H.
645	Inspect for Live Ammo		9/10/88	W.B.
655	Final Inspection			
	A) Headspace	ok	9/24/88	J.P.
	B) Trigger Pull	ok	9/24/88	J.P.
	C) Function	ok	9/24/88	J.P.
660	Pack		10-21-88	J.S.

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C0225249

DATE 25 Aug. 88

TESTER J.C. + B.S.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.60	2.61	2.80	2.79	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.56	2.56	2.90	2.75	
PULL #3	2.56	2.67	2.79	2.78	
PULL #4	2.47	2.54	2.76	2.78	
PULL #5	2.60	2.61	2.80	2.75	
TOTAL	12.79	12.99	14.05	13.85	
AVG.	2.558	2.598	2.81	2.77	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.16	3.31		
PULL #2	3.29	3.18		
PULL #3	3.22	3.22		
PULL #4	3.22	3.23		
PULL #5	3.27	3.29		
TOTAL	16.16	16.23		
AVG.	3.232	3.246		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.22	4.27		4.10
PULL #2	4.15	4.23		4.10
PULL #3	4.18	4.12		4.07
PULL #4	4.12	4.07		4.08
PULL #5	4.11	4.16		4.14
TOTAL	20.78	20.85		20.49
AVG.	4.156	4.17		4.098

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6225249

CENTROIDAL DISTANCES

0	TO	1	2.54985
1	TO	2	.156719
1	TO	3	1.88325
1	TO	4	1.127
1	TO	5	.997212
3		4	
5		21	

+ <----POB

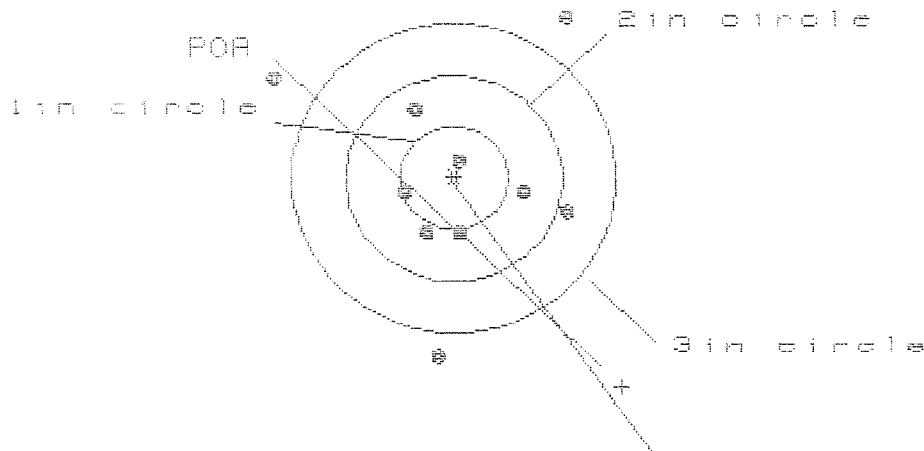
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -2.0524
 THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: 2.5656
 THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: 3.28552
 THE AMR FOR THIS RIFLE IS: .8956

AMR = 0.90

3 Sep 1988

FILE://PATTERNING/CENTERFIRE_PATT/08225249

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1 in = 2

2 in = 6

3 in = 7

HS = 2.765

VS = 3.321

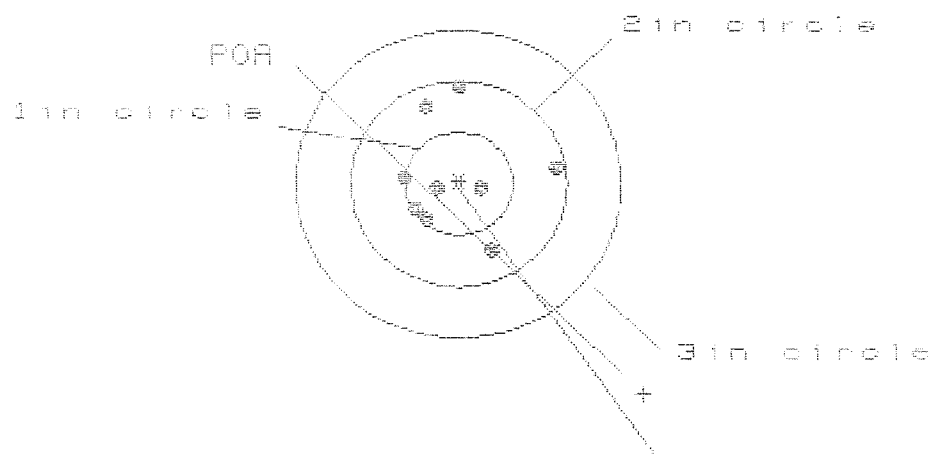
GS = 3.540

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.082	.895	.995
MINIMUM X	-1.683	-.665	-.553
MAXIMUM Y	1.563	1.670	1.007
MINIMUM Y	-1.758	-1.651	-1.442
CENTROID X	-1.543	-1.356	-1.463
CENTROID Y	2.030	1.923	1.714
POA TO CENTROID in.	2.558	2.353	2.257
MIN RADIUS	.192	.308	.220
MEAN RADIUS	.993	.880	.729
MAX RADIUS	1.939	1.895	1.458
HORIZONTAL SPREAD	2.765	1.560	1.548
VERTICAL SPREAD	3.321	3.321	2.449
EXTREME SPREAD	3.540	3.540	2.455
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	7		

9 Sep 1988

FILE:/PATTERNING/CENTERFIRE_PATT/06205249

CENTERFIRE PATTERNS # 2



CENTROID *

OF SHOTS = 10

IN CIR

1in = 5

2in = 10

3in = 10

HS = 1.393

VS = 1.598

GS = 1.641

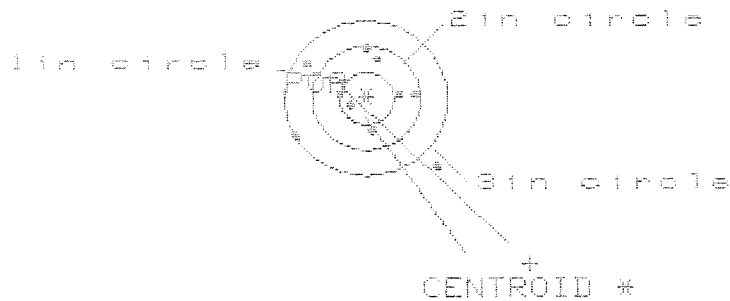
PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.905	.444	.453
MINIMUM X	-.488	-.387	-.378
MAXIMUM Y	.920	.941	.924
MINIMUM Y	-.673	-.657	-.539
CENTROID X	-1.699	-1.800	-1.809
CENTROID Y	2.045	2.024	1.906
POA TO CENTROID in.	2.659	2.708	2.627
MIN RADIUS	.227	.145	.134
MEAN RADIUS	.604	.547	.477
MAX RADIUS	.925	.944	.938
HORIZONTAL SPREAD	1.393	.831	.831
VERTICAL SPREAD	1.598	1.598	1.463
EXTREME SPREAD	1.641	1.641	1.586
NUMBER IN ONE INCH CIRCLE =	5		
NUMBER IN TWO INCH CIRCLE =	10		
NUMBER IN THREE INCH CIRCLE =	10		

9 Sep 1988

FILE:/PATTERNING/CENTERFIRE_PATT/06225249

CENTERFIRE PATTERNS

3



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 7

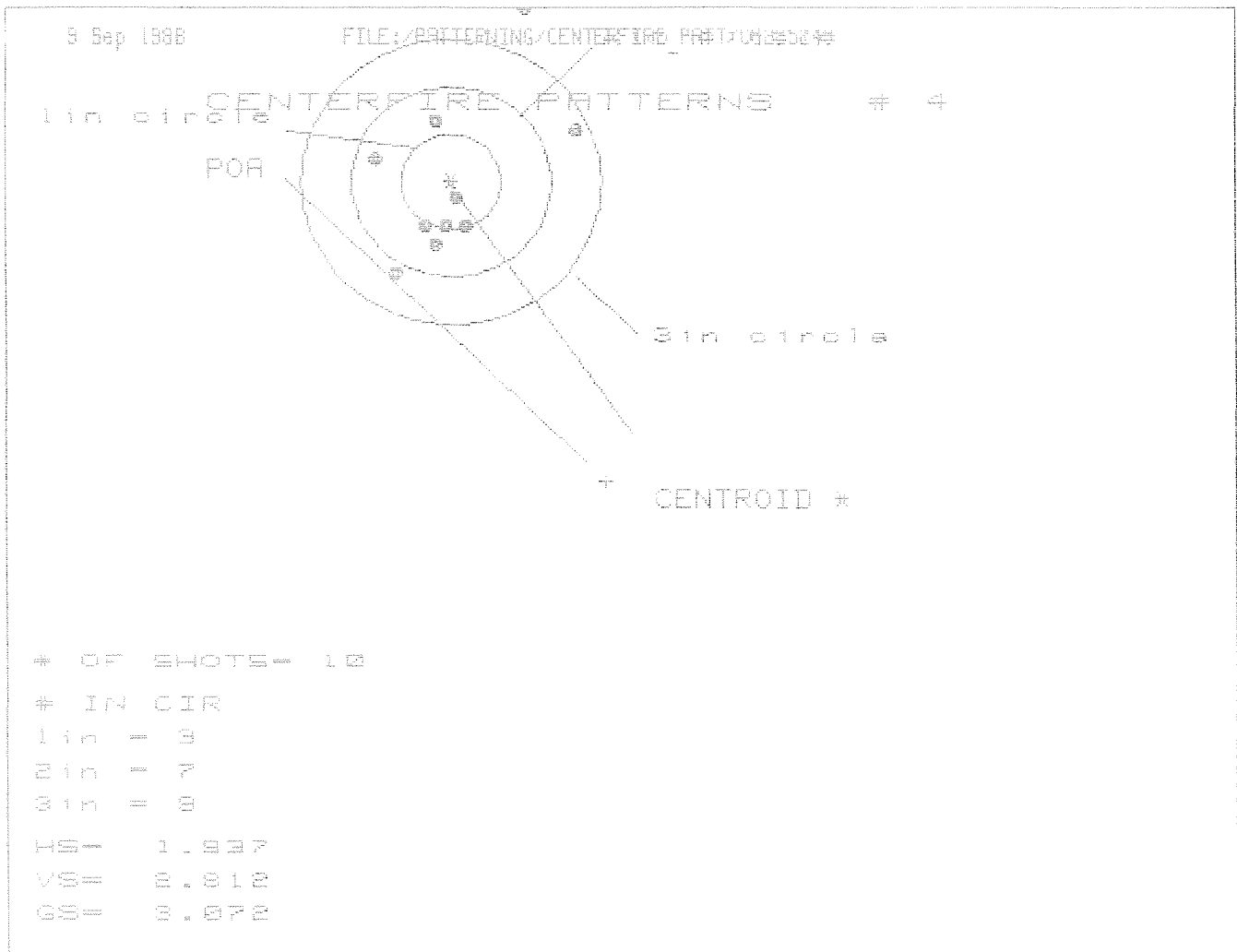
3 in = 9

HS= 2.550

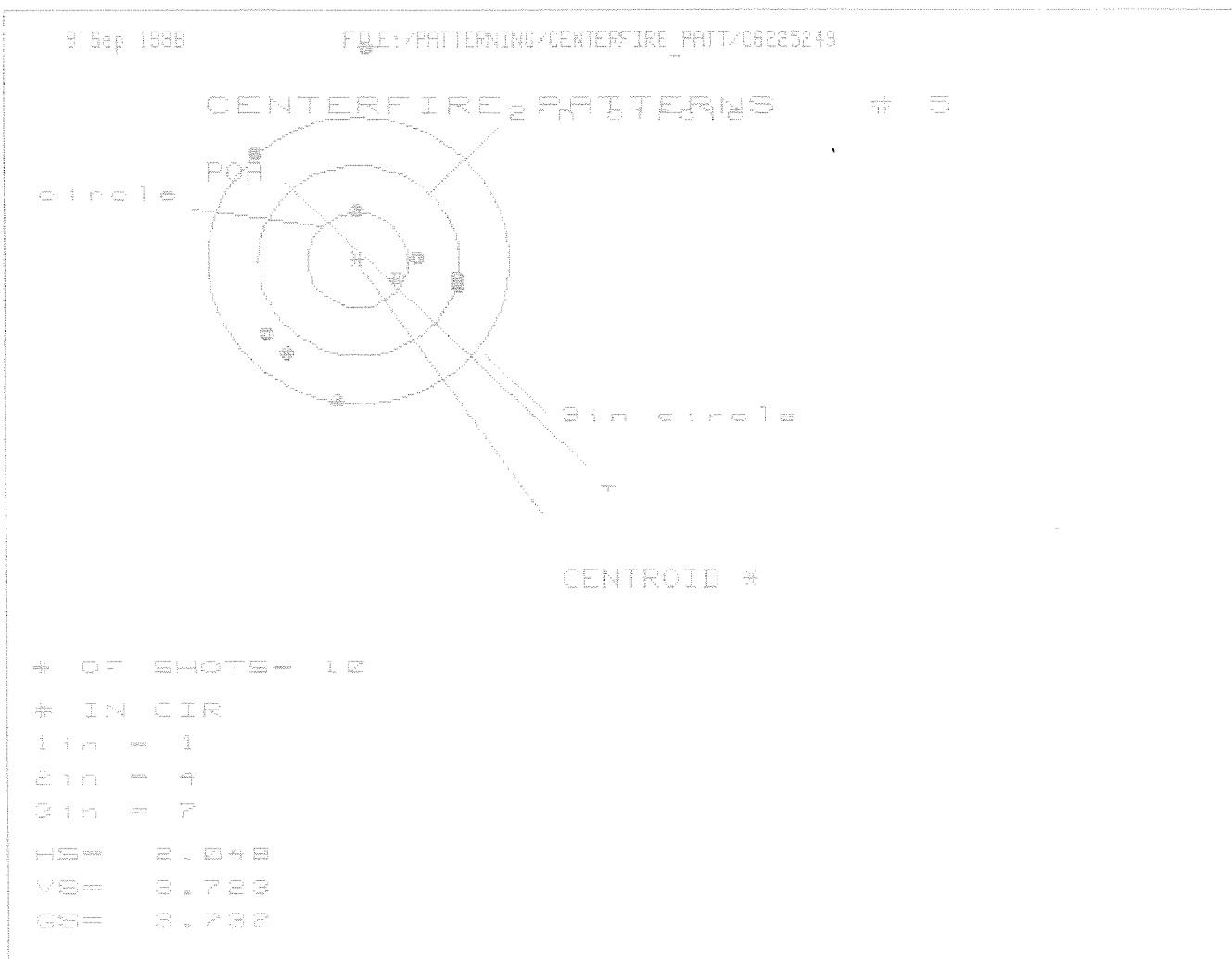
VS= 2.269

GS= 3.072

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.260	1.088	.944
MINIMUM X	-1.290	-1.150	-1.071
MAXIMUM Y	.984	.841	.735
MINIMUM Y	-1.285	-.849	-.911
CENTROID X	-3.001	-3.141	-2.997
CENTROID Y	3.222	3.365	3.471
ROR TO CENTROID in.	4.403	4.503	4.586
MIN RADIUS	.310	.285	.457
MEAN RADIUS	.938	.823	.740
MAX RADIUS	1.800	1.430	1.170
HORIZONTAL SPREAD	2.550	2.238	2.015
VERTICAL SPREAD	2.269	1.690	1.646
EXTREME SPREAD	3.072	2.382	2.106
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	9		



PATTERN #	1	4	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.198	1.276	.354
MINIMUM X	-.739	-.661	-.591
MAXIMUM Y	1.866	.820	.918
MINIMUM Y	-.946	-.739	-.641
CENTROID X	-1.548	-1.618	-1.778
CENTROID Y	3.157	2.950	2.852
POA TO CENTROID in.	3.513	3.364	3.361
MIN RADIUS	.176	.096	.197
MEAN RADIUS	.824	.611	.475
MAX RADIUS	1.994	1.496	.915
HORIZONTAL SPREAD	1.937	1.937	.855
VERTICAL SPREAD	2.812	1.559	1.559
EXTREME SPREAD	3.872	2.384	1.598
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		9	



PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.001	1.005	.675
MINIMUM X	-1.047	-1.043	-1.061
MAXIMUM Y	2.223	1.358	.917
MINIMUM Y	-1.500	-1.253	-1.083
CENTROID X	-2.479	-2.483	-2.353
CENTROID Y	2.374	2.127	1.937
POA TO CENTROID in.	3.432	3.269	3.050
MIN RADIUS	.413	.412	.389
MEAN RADIUS	1.119	.982	.871
MAX RADIUS	2.224	1.712	1.138
HORIZONTAL SPREAD	2.048	2.048	1.936
VERTICAL SPREAD	3.723	2.611	2.000
EXTREME SPREAD	3.732	2.737	2.015
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	7		

MAINTENANCE REQUEST					PAGE NO.	NO. OF PAGES	REQUIREMENTS CONTROL SYMBOL	
For use of this form, see DA PAM 738-750; the proponent agency is DCSLOG					1	1	CSGLD - 1047(R1)	
SECTION I - EQUIPMENT DATA								
CONTROL NUMBER		WORK ORDER NO.		WESDC	ORG. PD	PD AUTHENTICATION		
					03	Jungdmap		
☒ Work Request ☐ MWO ☐ Warranty Claim		1A. ORGANIZATION WEAPONS POOL B+ MAINT DIV, DOL		B. LOCATION Bldg 9106 Ft. Benning, GA 31905		C. UNIT IDENT CODE W04255		
2. SERIAL NO. C6225249		3. NOUN NOMENCLATURE Rifle Sniper		4. LINE NO. R95387	5. MODEL M24	6. NATIONAL STOCK NUMBER 1005-01-240-2136		
7A. MAINTENANCE ACTIVITY		B. LEVEL RH	8. UTILIZATION CODE RQ	9A. MCSR ITEM	9B. ERC	9C. PACING ITEM	10. HOURS	11. MILES
14. FAILURE DETECTED DURING (Select one - use ☒ or X)				15. FIRST INDICATION OF TROUBLE (Select one - use ☒ or X)				
☐ A Sch. Main. ☐ C Test ☐ E Storage ☐ G Flight ☐ B Handling ☒ D Normal Op ☐ F Inspection ☐ H Other				☐ 068 Inoperative ☐ 258 Overheating ☐ 790 Out of Adjustment ☐ 008 Noisy ☐ 387 Low Performance ☐ Other				
16A. DESCRIBE DEFICIENCIES OR SYMPTOMS ON THE BASIS OF COMPLETE CHECKOUT AND DIAGNOSTIC PROCEDURE IN EQUIPMENT TM (Do not prescribe repairs). Paint Peeling off Barrel, Stock Fibers wearing through								
B. REMARKS Reconditioning Not Done - Rifle Checked & Repaired for Function Only - Remington Arms Co Inc.								
SECTION II - WORK ACCOMPLISHED								
17A. REPAIR ORGANIZATION/ACTIVITY				C. UNIT IDENT. CODE		18. TYPE ORGANIZATION/ACTIVITY ACCOMPLISHING WORK (Select one - use ☒ or X)		19. AMS ACCT. CODE
B. LOCATION						☐ 1 TOE ☐ 2 TD ☐ 3 Contractor		
20A. ACT. CODE	B. FAILURE CODE	C. COMPONENT/PART NOUN, SVC. OR MWO NO.			D. MANHOURS (Hrs. & tenths)	E. NATIONAL STOCK NUMBER	F. PART SOURCE CODE	G. QTY.
		(1) CB CODE	(2) REF DESIGN.	(3) MFR. CODE				
								\$
								\$
								\$
								\$
								\$
								\$
								\$
								\$
								\$
								\$
								\$
I. TOTAL MANHOURS					J. TOTAL MANHOURS COST	K. TOTAL PARTS COST		
					\$	\$		
21. DELAY (Select One)								
☐ 1 Parts ☐ 2 Manpower ☐ 3 Facilities ☐ 4 Funds ☐ 5 Tools								
23. SUBMITTED BY Jungdmap		24. RECEIVED BY		25. WORK STARTED BY		26. INSPECTED BY		27. ACCEPTED BY
JULIAN DATE		JULIAN DATE		JULIAN DATE		JULIAN DATE		JULIAN DATE
28. DISPOSITION (Select One)								
☐ A To User ☐ D Evacuated ☐ B To Stock ☐ E Cannibalization ☐ C Salvaged								