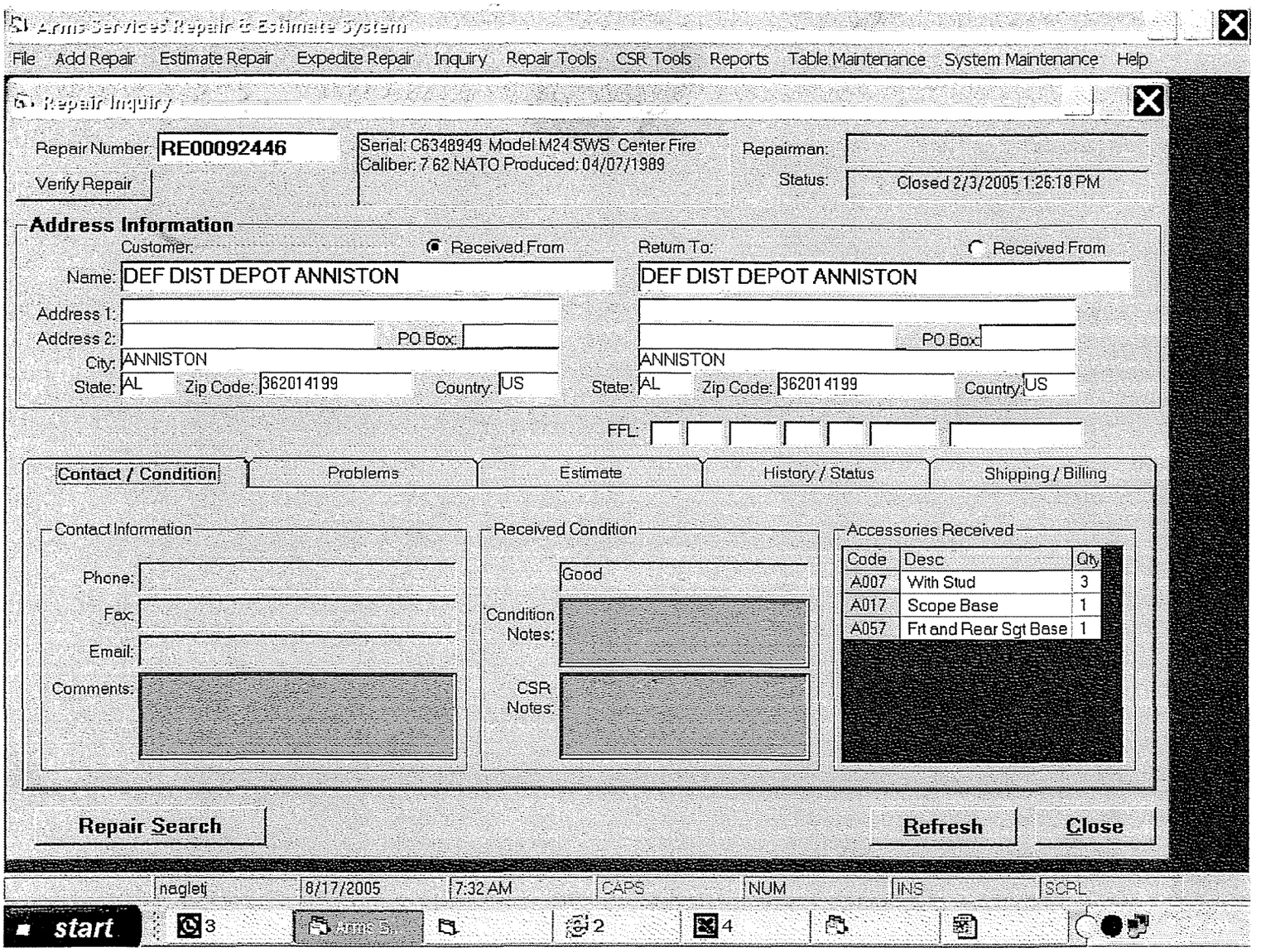
GG3C0985
Replaced
C-C34 8949



G6360985 (New)

Serial Number: C6348949

Model: M24 SWS

RE00092446

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFOMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6360985.__0
FILE DATE AND TIME: 08/30/2005 11:01

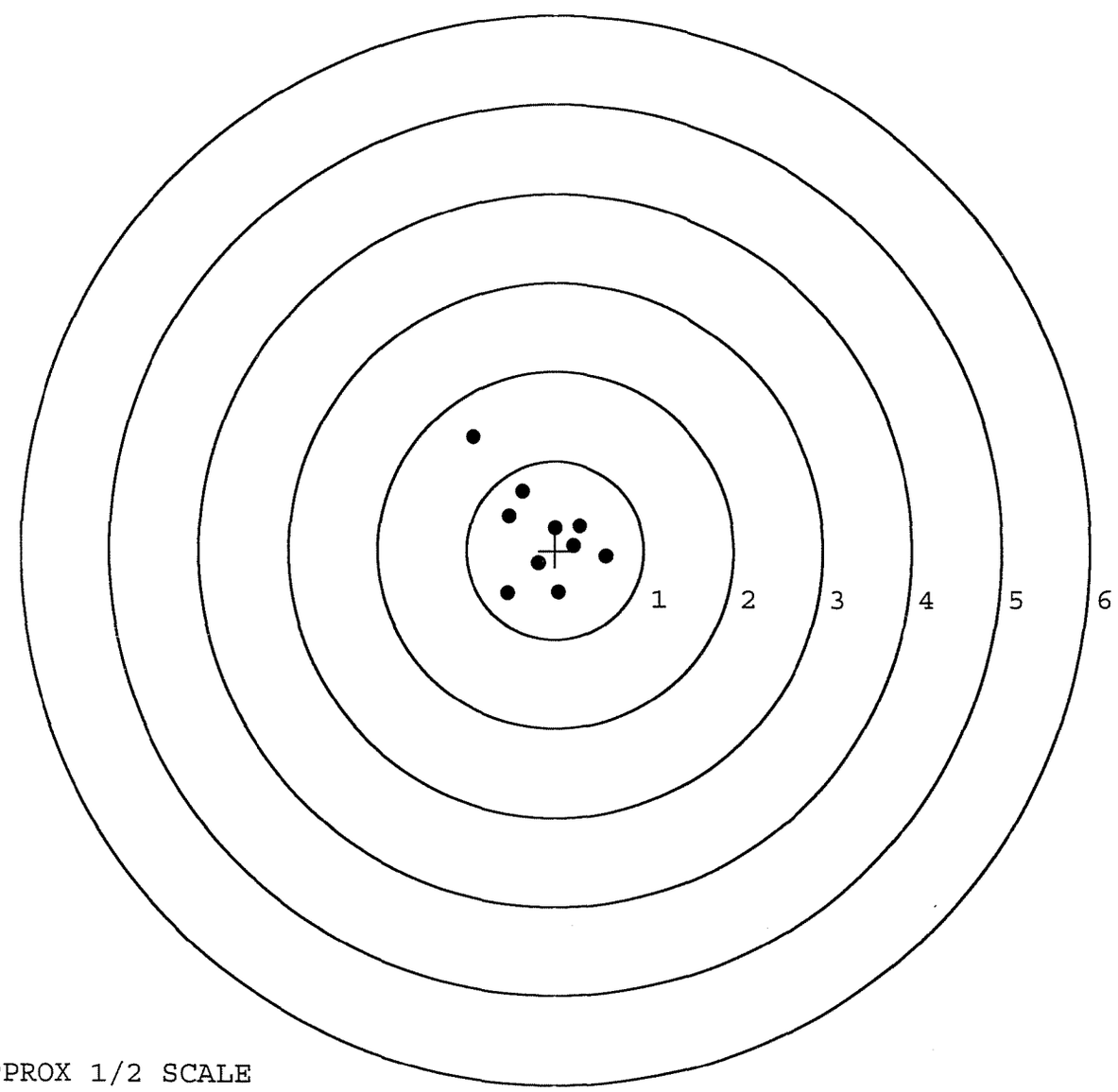
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.082
The Average Y Centroid of the Five Target Set:	-0.051
The Average Point of Impact of the Five Target Set:	0.097
The Average Mean Radius of the Five Target Set:	0.901
The Distance from POA to Centroid Target #1:	0.227
The Distance from Centroid Target #2 to Centroid Target #1:	0.325
The Distance from Centroid Target #3 to Centroid Target #1:	0.446
The Distance from Centroid Target #4 to Centroid Target #1:	0.409
The Distance from Centroid Target #5 to Centroid Target #1:	0.053

SERIAL NUMBER: G6360985.__0
TARGET NUMBER: 1
FILE DATE: 08/30/2005
FILE TIME: 11:01

X CENTROID:	-0.144
Y CENTROID:	0.176
POA TO CENTROID:	0.227
HORZ SPREAD:	1.500
VERT SPREAD:	1.753
GROUP SPREAD:	2.009
MIN RADIUS:	0.166
MAX RADIUS:	1.345
MEAN RADIUS:	0.582
# IN 1 IN DIAMETER:	5
# IN 2 IN DIAMETER:	9
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	0.578	-0.063
2:	0.283	0.276
3:	0.208	0.060
4:	0.001	0.258
5:	0.036	-0.475
6:	-0.190	-0.142
7:	-0.539	-0.480
8:	-0.521	0.392
9:	-0.373	0.663
10:	-0.922	1.273

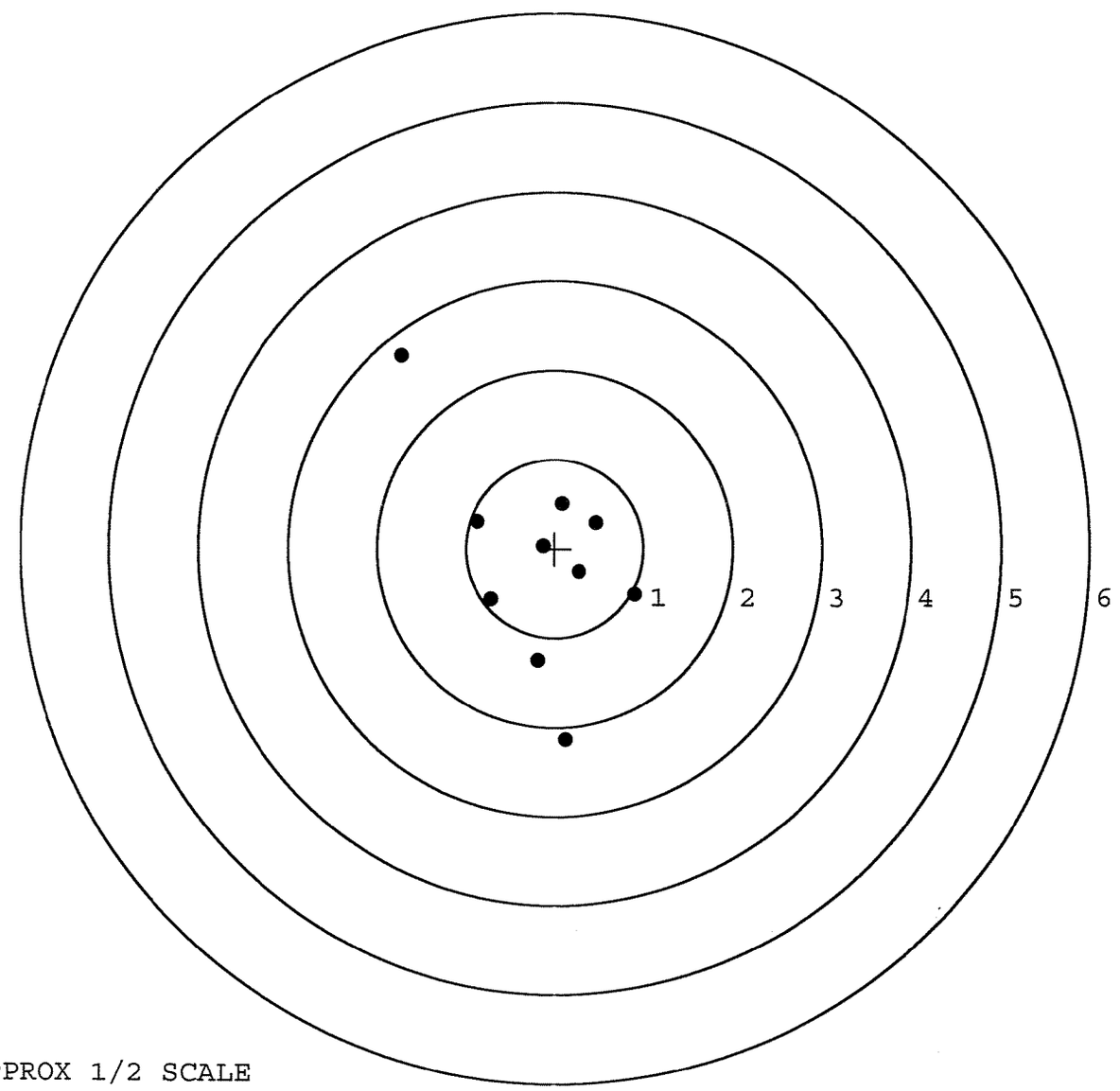


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6360985.__0
TARGET NUMBER: 2
FILE DATE: 08/30/2005
FILE TIME: 11:01

X CENTROID:	-0.179
Y CENTROID:	-0.147
POA TO CENTROID:	0.231
HORZ SPREAD:	2.635
VERT SPREAD:	4.304
GROUP SPREAD:	4.686
MIN RADIUS:	0.180
MAX RADIUS:	2.785
MEAN RADIUS:	1.070
# IN 1 IN DIAMETER:	2
# IN 2 IN DIAMETER:	6
# in 3 IN DIAMETER:	8

POINT#	X	Y
1:	0.121	-2.140
2:	-0.188	-1.257
3:	-0.714	-0.577
4:	0.903	-0.524
5:	0.275	-0.262
6:	-0.133	0.027
7:	-0.869	0.304
8:	0.470	0.289
9:	0.081	0.505
10:	-1.732	2.164

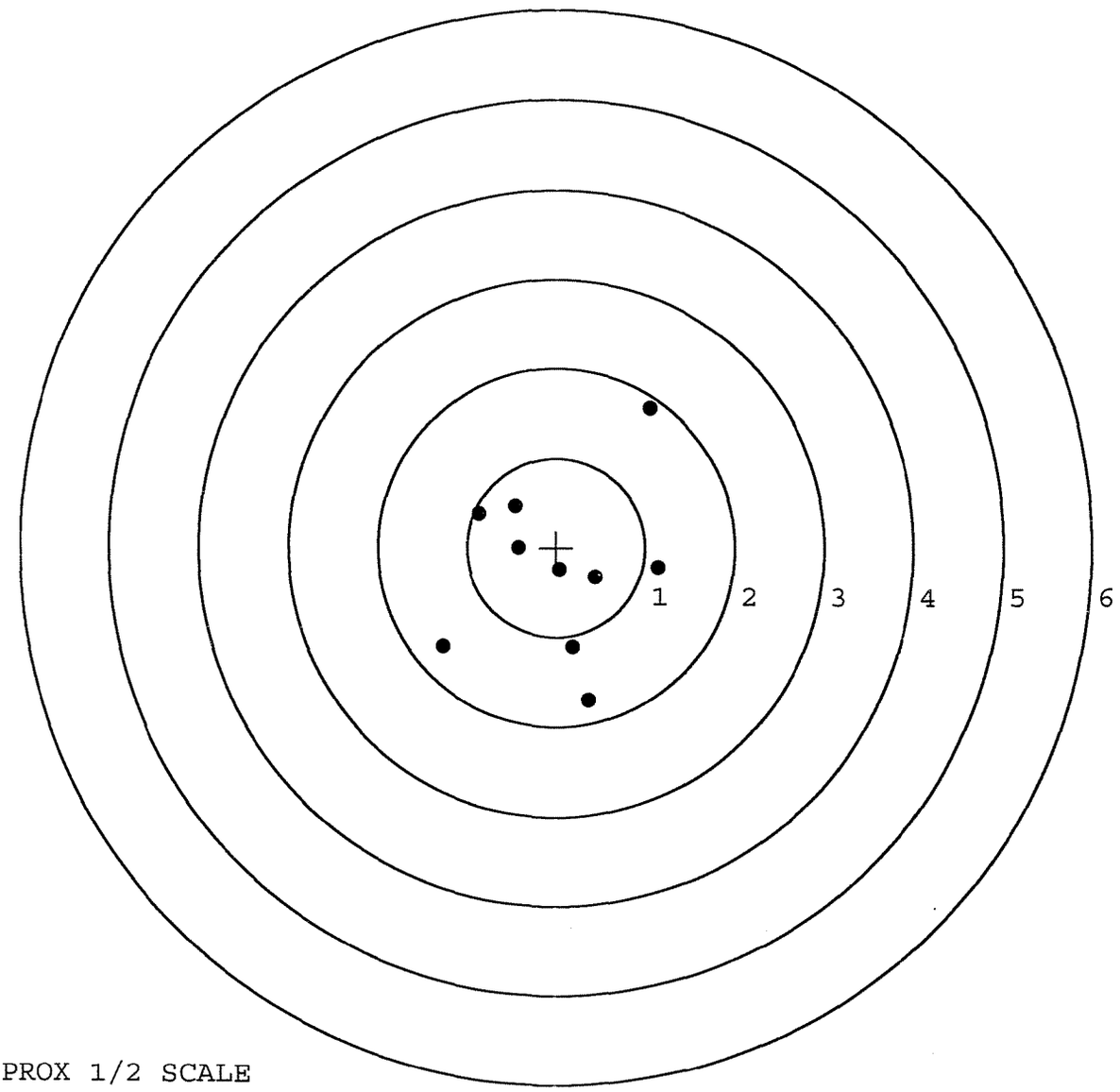


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6360985.__0
TARGET NUMBER: 3
FILE DATE: 08/30/2005
FILE TIME: 11:01

X CENTROID:	0.023
Y CENTROID:	-0.237
POA TO CENTROID:	0.238
HORZ SPREAD:	2.413
VERT SPREAD:	3.267
GROUP SPREAD:	3.536
MIN RADIUS:	0.019
MAX RADIUS:	2.067
MEAN RADIUS:	1.004
# IN 1 IN DIAMETER:	3
# IN 2 IN DIAMETER:	5
# in 3 IN DIAMETER:	7

POINT#	X	Y
1:	0.375	-1.712
2:	0.187	-1.116
3:	-1.268	-1.113
4:	1.145	-0.230
5:	0.447	-0.336
6:	0.035	-0.251
7:	-0.422	-0.010
8:	-0.456	0.461
9:	-0.866	0.383
10:	1.053	1.555

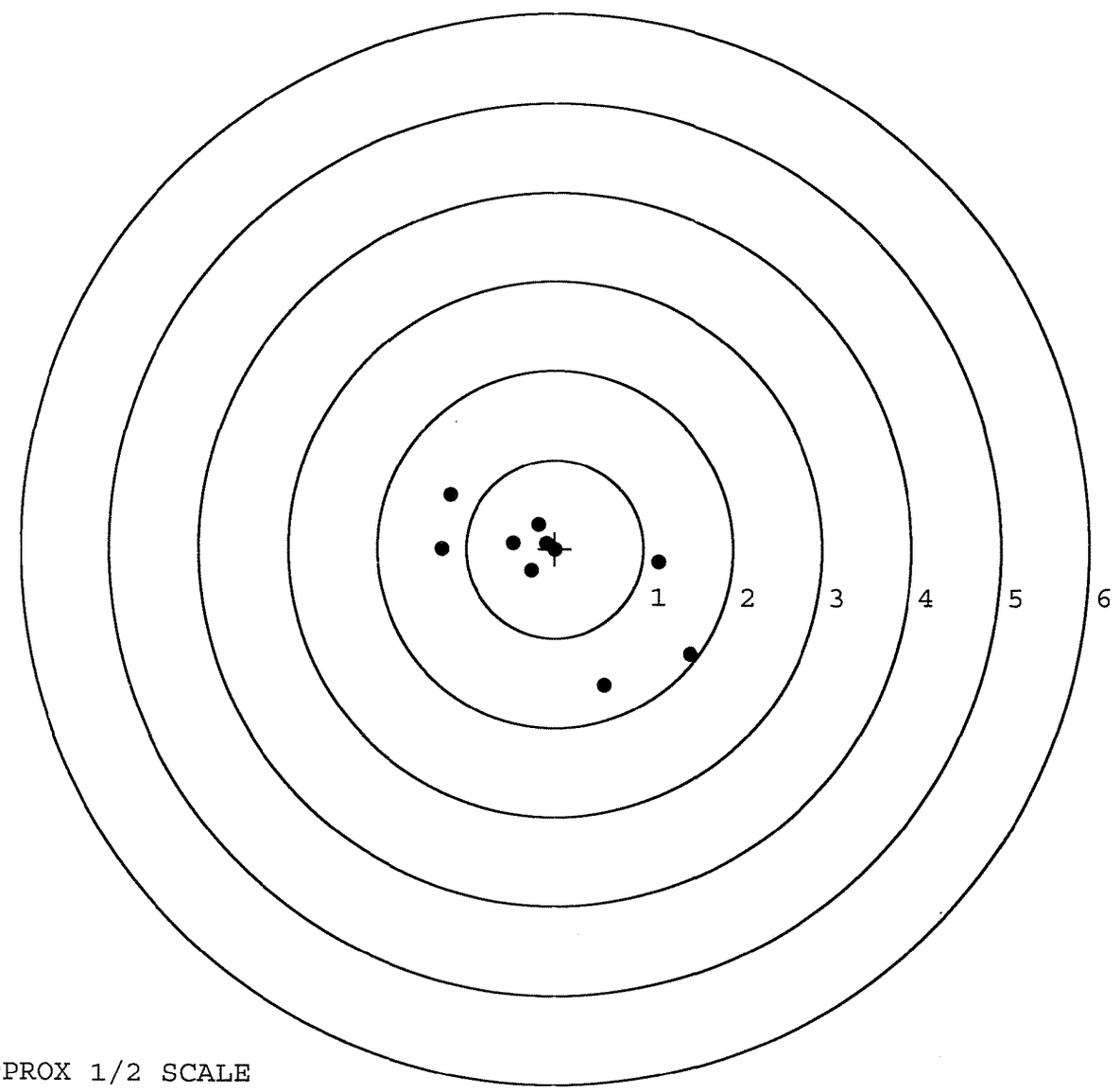


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6360985.__0
TARGET NUMBER: 4
FILE DATE: 08/30/2005
FILE TIME: 11:01

X CENTROID:	-0.020
Y CENTROID:	-0.214
POA TO CENTROID:	0.215
HORZ SPREAD:	2.804
VERT SPREAD:	2.141
GROUP SPREAD:	3.246
MIN RADIUS:	0.198
MAX RADIUS:	1.826
MEAN RADIUS:	0.891
# IN 1 IN DIAMETER:	3
# IN 2 IN DIAMETER:	5
# in 3 IN DIAMETER:	9

POINT#	X	Y
1:	1.526	-1.186
2:	0.561	-1.528
3:	1.171	-0.158
4:	0.005	-0.018
5:	-0.095	0.055
6:	-0.184	0.269
7:	-0.467	0.062
8:	-1.278	-0.002
9:	-1.176	0.613
10:	-0.263	-0.248

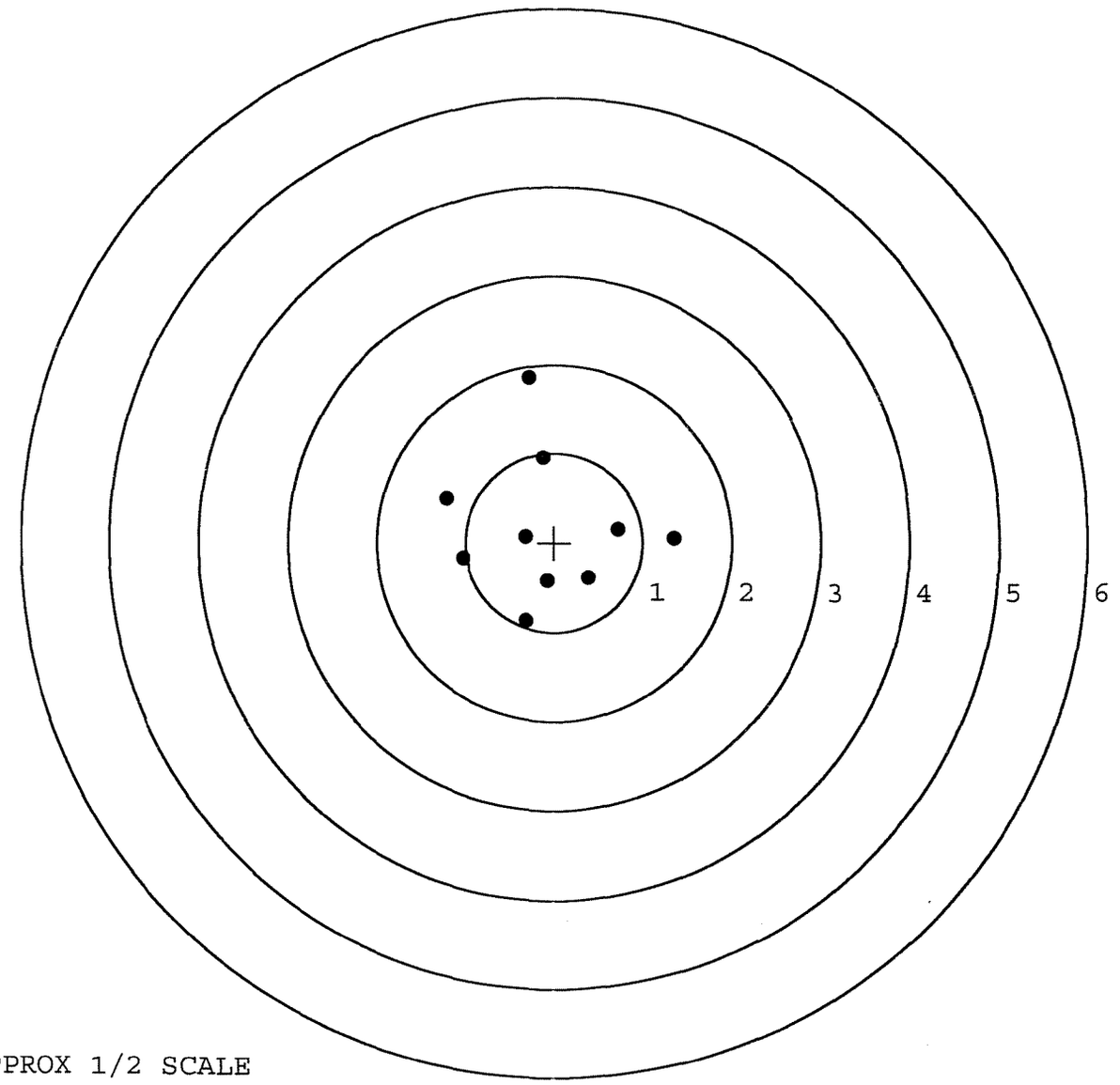


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6360985.__0
TARGET NUMBER: 5
FILE DATE: 08/30/2005
FILE TIME: 11:01

X CENTROID:	-0.092
Y CENTROID:	0.167
POA TO CENTROID:	0.191
HORZ SPREAD:	2.565
VERT SPREAD:	2.726
GROUP SPREAD:	2.726
MIN RADIUS:	0.255
MAX RADIUS:	1.694
MEAN RADIUS:	0.958
# IN 1 IN DIAMETER:	1
# IN 2 IN DIAMETER:	5
# in 3 IN DIAMETER:	9

POINT#	X	Y
1:	1.347	0.048
2:	0.725	0.151
3:	0.395	-0.397
4:	-0.074	-0.430
5:	-0.318	-0.876
6:	-0.326	0.066
7:	-1.032	-0.176
8:	-1.218	0.487
9:	-0.127	0.951
10:	-0.291	1.850



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 8-18-05

TESTER MW

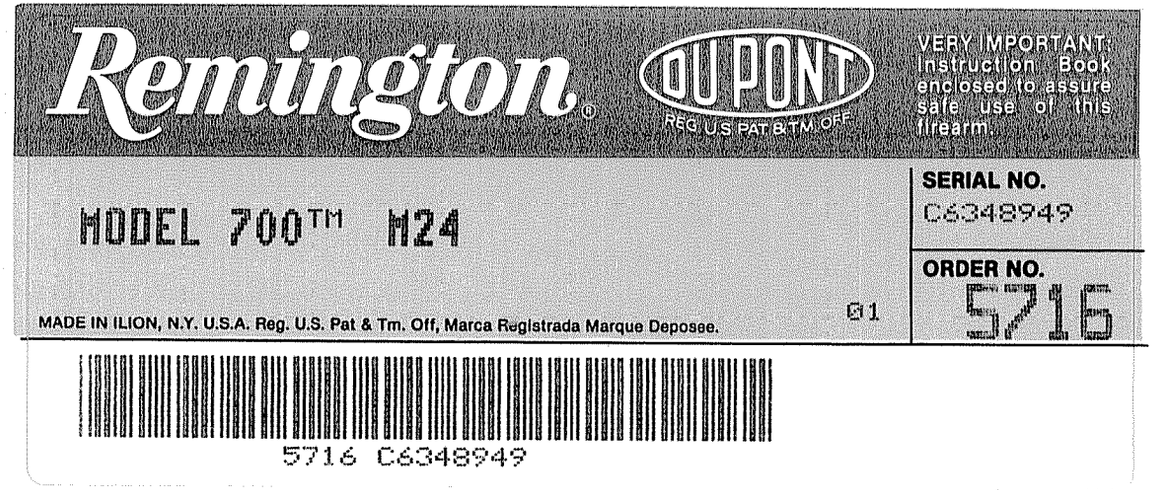
	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.28	2.16		2.20	
PULL #2	2.23	2.13		2.56	
PULL #3	2.18	2.08		2.49	
PULL #4	2.32	2.04		2.32	
PULL #5	2.26	2.39		2.67	
TOTAL	11.27	10.80		12.24	
AVERAGE	2.25	2.16		2.44	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.18	3.36		
PULL #2	3.25	3.42		
PULL #3	3.37	3.32		
PULL #4	3.59	3.27		
PULL #5	3.30	3.18		
TOTAL	16.69	16.55		
AVERAGE	3.33	3.31		

	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	4.29	4.54		4.74
PULL #2	4.07	4.40		4.79
PULL #3	4.55	4.32		4.76
PULL #4	4.15	4.34		4.79
PULL #5	4.15	3.84		4.81
TOTAL	21.21	21.44		23.89
AVERAGE	4.24	4.28		4.77

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

R & E NUMBER	92446		
SERIAL NUMBER	~~C6348949~~	C-6360985	New
LOG-IN DATE	2-3-05		
INSPECT AND VERIFY:			
OPERATION #	OPERATION NAME	DATE	INITIAL
550	DIS-ASSEMBLE GUN	8-18-05	RTZ
560 A	RE-BARREL	8-23-05	RTZ
B	DRILL AND TAP	8-25-05	TRW
575	ASSEMBLE	8-24-05	RTZ
600	PROOF	8-24-05	~~AE~~
605	CHECK HEADSPACE	8-24-05	AE
610	DIS-ASSEMBLE GUN	8-25-05	RTZ
612	MAGNAFLUX	8/25/05	[illegible]
615	ROLLMARK CALIBER	8-25-05	CW
618	ROTO-BLAST	8-26-05	LB
620	APPLY COATINGS	8/29/05	RTZ
625 A	FINAL ASSEMBLY	8-30-05	RTZ
B	TRIGGER PULL TEST	9-1-05	AE
C	SAFETY "ON" FORCE	9-1-05	AE
D	SAFETY "OFF" FORCE	9-1-05	AE
E	FIRING PIN INDENT	9-1-05	AE
640	TARGET	8-30-05	TRW
655	FINAL INSPECT	9-1-05	AE
660	PACK	9-2-05	RTZ
		SHIP DATE	
	QAR INSPECTION DATE		



M-24

Scope 0575

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6348949

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	9 26 89		RW
600	Proof	9 26 89		RW
607	Check Headspace	9 26 89		RW
610	Dis-assemble Gun	9 26 89		RW
612	Magnaflux Barrel Action	9/29/89		KCR
	Magnaflux Bolt	9/29/89		KCR
615	Rollmark Caliber	9/29/89		[illegible]
7	Drill and Tap Sight Holes	9 29 89		JB
618	Polish Barrel RB	9 29 89		BT
620	Apply Coatings (Barrel Action)		10-11-89	TH
	Apply Coating (Bolt)		10-11-89	TH
625	Final Assembly A) Clean inside of Bolt Assembly		10/12/89	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/12/89	RW
	C) Inspect Ejector Hole for Chamfer		10/12/89	RW
	D) Oil Firing Pin Ass'y		10/12/89	RW
	E) Adjust Trigger Pull to Min Setting and Stake		10/26/89	GS

op. #	OP. NAME	READINGS			DATE	INIT
625 cont.	F) Safety On Force	5	5	5	10/27/89	JH
	G) Safety Off Force	4	4	4	10/27/89	JH
	H) Trigger Pull Test & Retainability				26Oct89	JS
	I) Firing Pin Indent	.022	.0215	.0225	10/27/89	JH
	J) Assemble Stock				10/27/89	RW
	K) Assemble Swivel Studs				31Oct89	JS
	L) Attach Front and Rear Sight Assemblies				10/27/89	RW
	M) Iron Sight Alignment				10/27/89	RW
	N) Detach Front & Rear Sights & place in numbered container				10/27/89	RW
	O) Attach Scope to Rifle				10/27/89	JH
	P) Detach & Attach Scope 20 Times				10/27/89	JH
640	Gallery Target & Test				10-30-89	AC
	A) Time				10-30-89	AC
	B) Malfunctions				10-30-89	AC
	C) Pierced Primers				10-30-89	AC
	D) Optical Clearity of Scope				10-30-89	AC
645	Inspect for Live Ammo				10-30-89	AC
655	Final Inspection A) Headspace				31Oct89	JS
	B) Trigger Pull	253	257	262	263	258	31Oct89	JS
	C) Function				31Oct89	JS
660	Pack				18Dec89	JS

SWS TRIGGER PULL TEST

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

SERIAL NO. C634 8949
DATE 12 NOV 90
TESTER GD

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	238	234		275	MIN. SETTING,
PULL #2	229	230		273	NO AVG. OF 5
PULL #3	209	229		268	READINGS ACCEPT-
PULL #4	226	229		268	ABLE LESS THAN 2#
PULL #5	226	227		269	
TOTAL	1148	1147			
AVG.	2.296	2.294			

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	293	264		
PULL #2	288	260		
PULL #3	287	253		
PULL #4	286	257		
PULL #5	285	250		
TOTAL	1439	1384		
AVG.	2.878	2.768		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	382	382		
PULL #2	377	371		
PULL #3	371	375		
PULL #4	374	372		
PULL #5	368	372		
TOTAL	1862	1878		
AVG.	3724	3756		

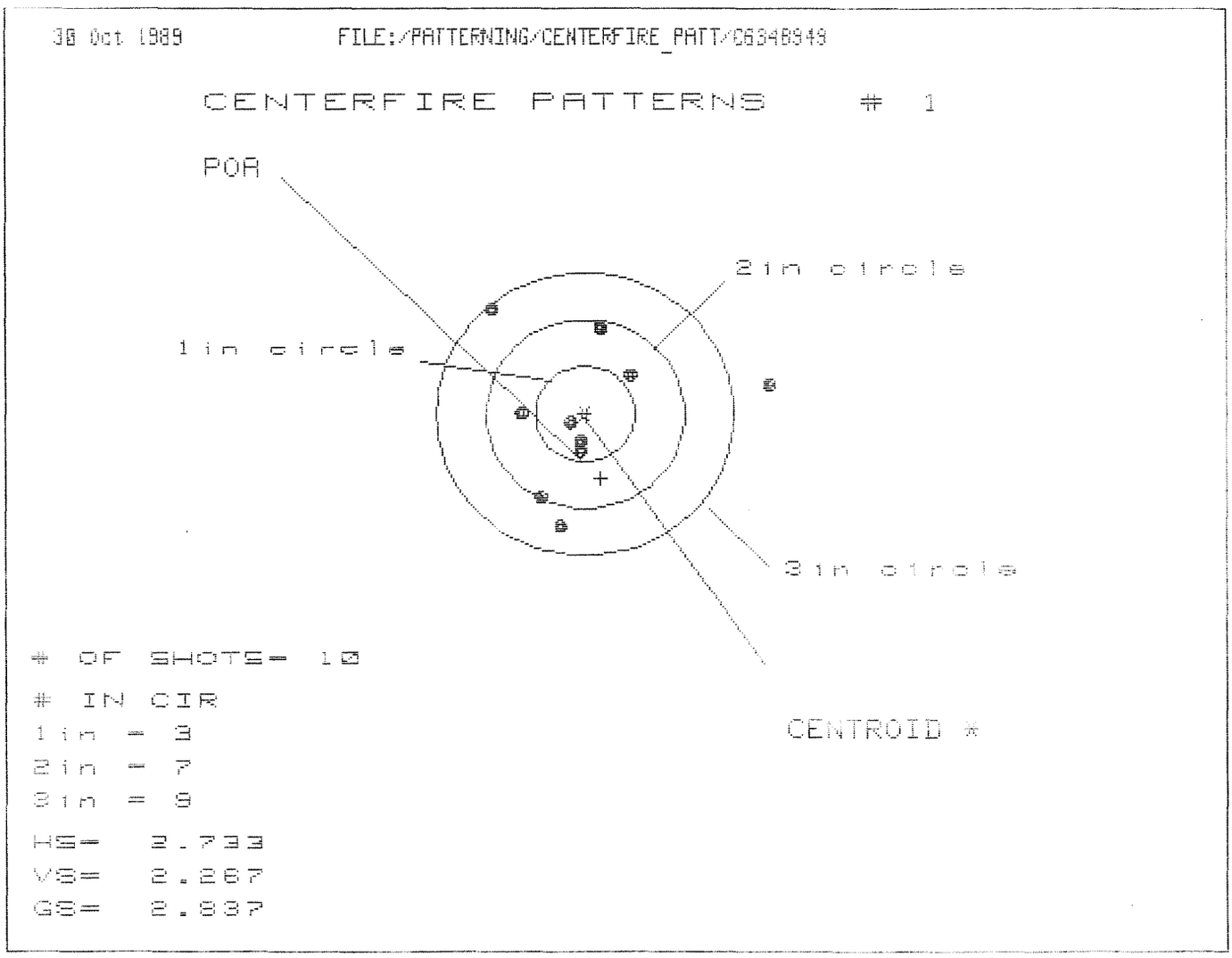
CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6348949
30 Oct 1989

CENTROIDAL DISTANCES

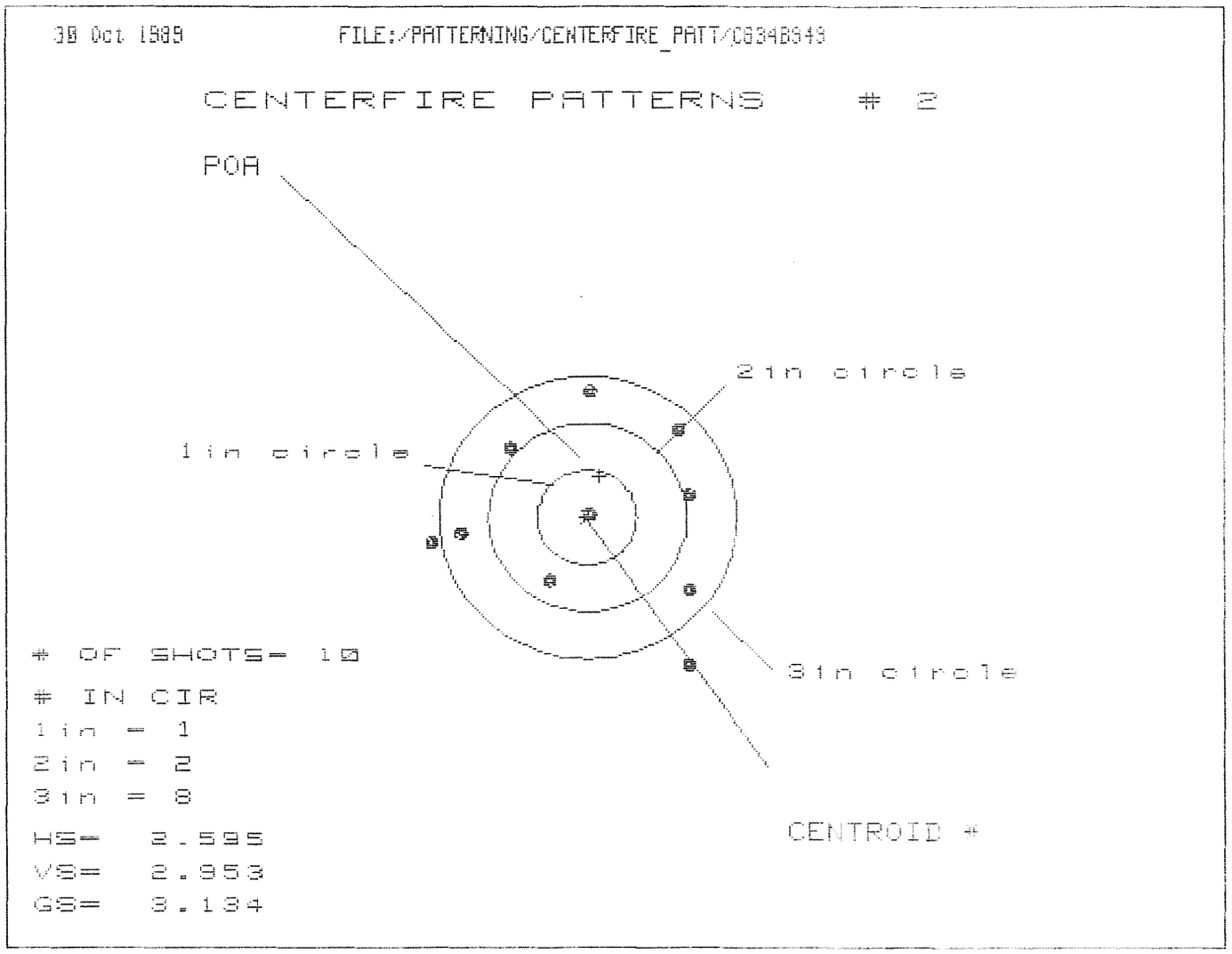
0	TO	1	.704268
1	TO	2	1.12448
1	TO	3	.899669
1	TO	4	.926835
1	TO	5	.697266

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0875
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0212
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0901288

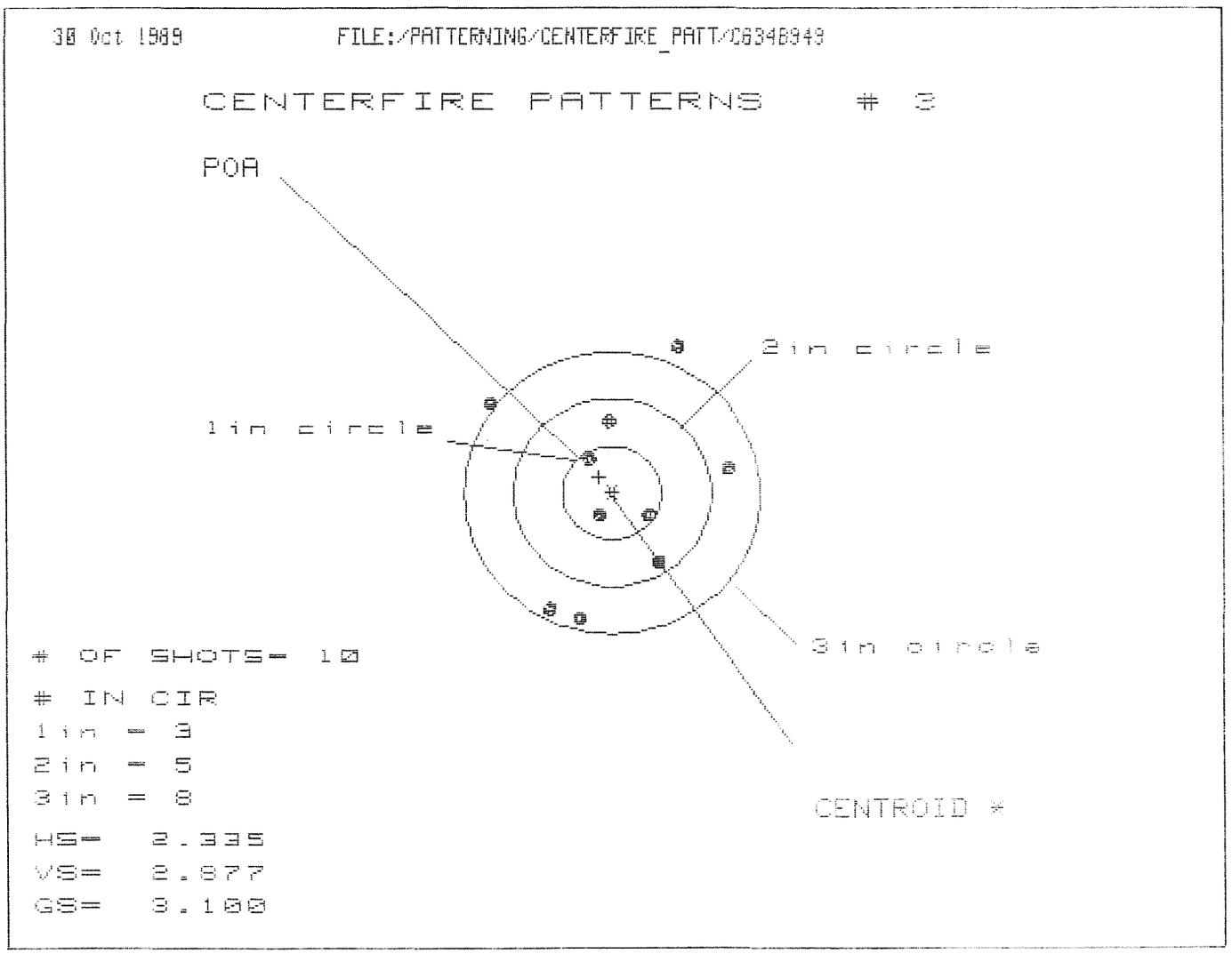
THE AMR FOR THIS RIFLE IS: 1.067



PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.810	.645	.554
MINIMUM X	:	-.922	-.721	-.495
MAXIMUM Y	:	1.100	1.137	1.130
MINIMUM Y	:	-1.167	-1.130	-.988
CENTROID X	:	-.155	-.356	-.266
CENTROID Y	:	.687	.650	.508
POA TO CENTROID in.	:	.705	.741	.573
MIN RADIUS	:	.119	.092	.127
MEAN RADIUS	:	.846	.709	.595
MAX RADIUS	:	1.842	1.347	1.154
HORIZONTAL SPREAD	:	2.733	1.366	1.050
VERTICAL SPREAD	:	2.267	2.267	2.118
EXTREME SPREAD	:	2.837	2.374	2.145
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	



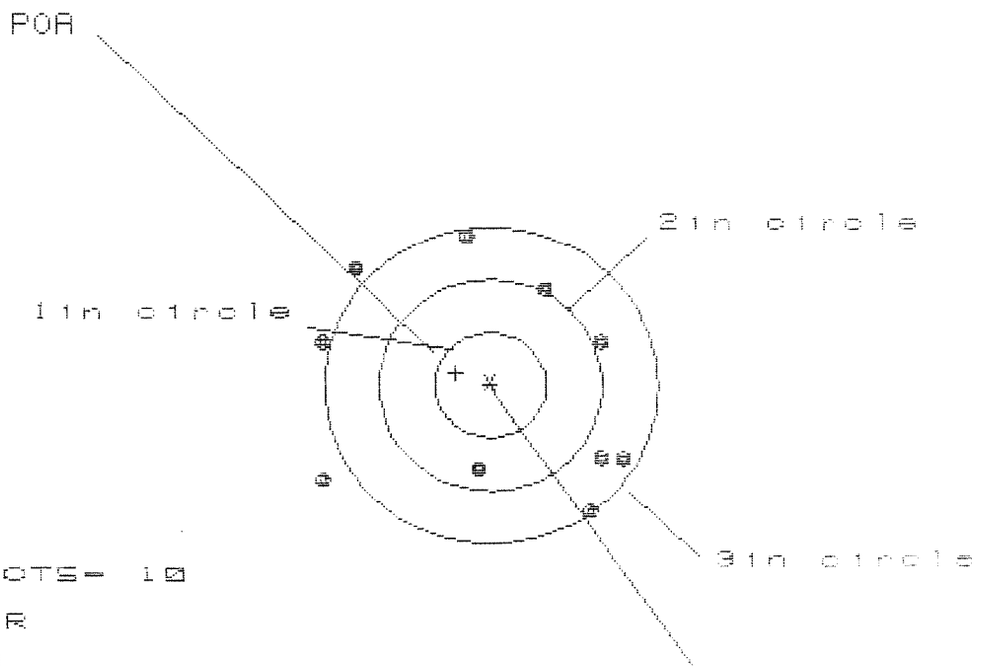
PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.042	1.125	.946
MINIMUM X	:	-1.553	-1.437	-1.319
MAXIMUM Y	:	1.361	1.184	1.134
MINIMUM Y	:	-1.592	-.897	-.947
CENTROID X	:	-.122	-.238	-.059
CENTROID Y	:	-.437	-.260	-.210
POA TO CENTROID in.	:	.454	.353	.218
MIN RADIUS	:	.081	.143	.165
MEAN RADIUS	:	1.151	1.057	.994
MAX RADIUS	:	1.903	1.493	1.371
HORIZONTAL SPREAD	:	2.595	2.562	2.265
VERTICAL SPREAD	:	2.953	2.081	2.081
EXTREME SPREAD	:	3.134	2.710	2.408
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		2	
NUMBER IN THREE INCH CIRCLE	=		8	



PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.124	1.193	1.050
MINIMUM X	:	-1.211	-1.142	-.702
MAXIMUM Y	:	1.583	1.125	1.056
MINIMUM Y	:	-1.294	-1.119	-.978
CENTROID X	:	.131	.062	.205
CENTROID Y	:	-.166	-.341	-.482
POA TO CENTROID in.	:	.211	.347	.524
MIN RADIUS	:	.273	.084	.177
MEAN RADIUS	:	.990	.889	.783
MAX RADIUS	:	1.700	1.603	1.186
HORIZONTAL SPREAD	:	2.335	2.335	1.752
VERTICAL SPREAD	:	2.877	2.244	2.034
EXTREME SPREAD	:	3.100	2.442	2.299
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

30 Oct 1989 FILE:/PATTERNING/CENTERFIRE_PATT/C6346343

CENTERFIRE PATTERNS # 4



OF SHOTS= 10

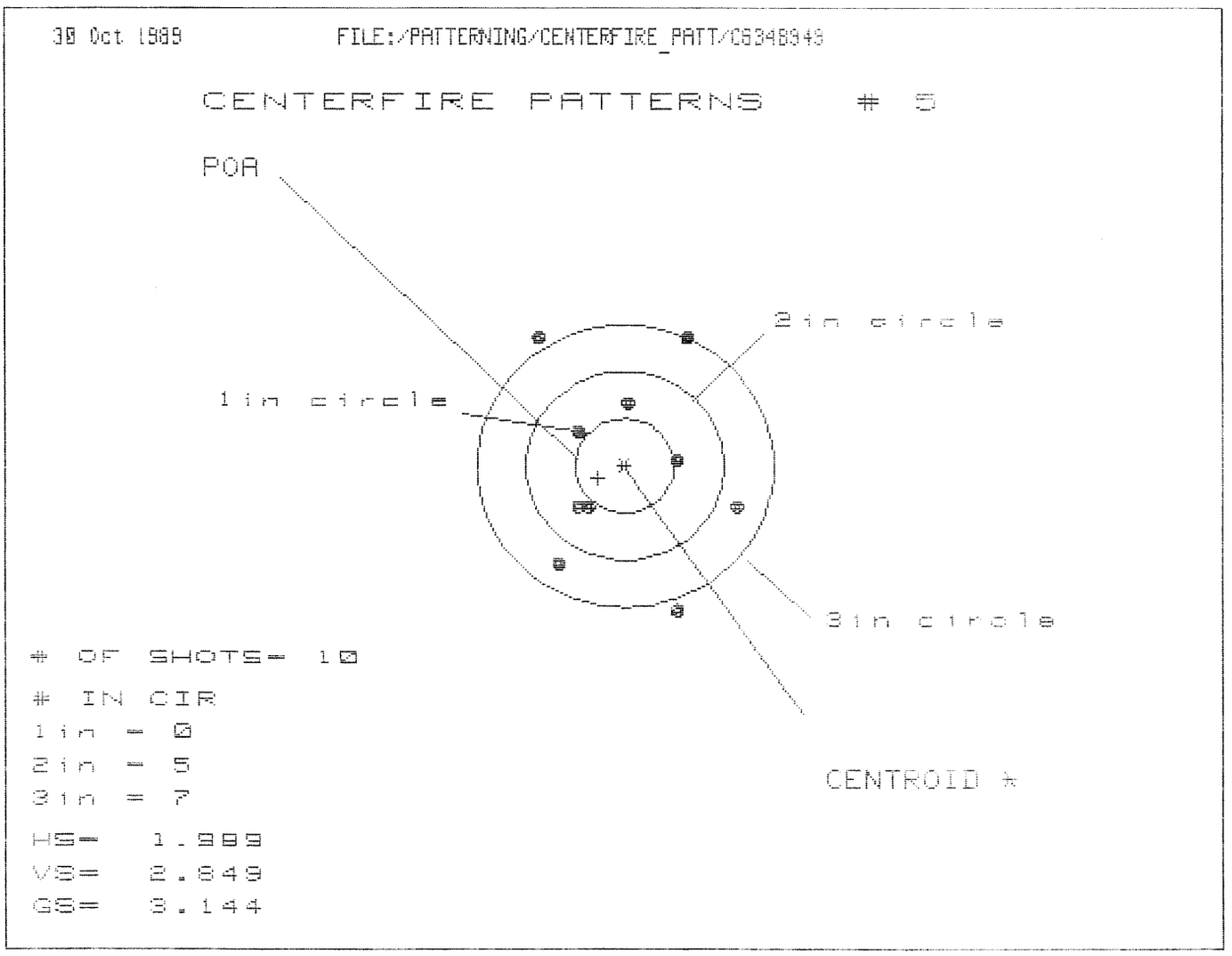
# IN CIR
1in = 0
2in = 1
3in = 7

HS= 2.676
VS= 2.603
GS= 3.129

PATTERN # : 4

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.164	.996	.826
MINIMUM X	-1.512	-1.668	-1.838
MAXIMUM Y	1.390	1.291	1.421
MINIMUM Y	-1.213	-1.312	-1.182
CENTROID X	.313	.481	.651
CENTROID Y	-.113	-.014	-.144
POA TO CENTROID in.	.333	.481	.667
MIN RADIUS	.751	.844	.781
MEAN RADIUS	1.328	1.255	1.161
MAX RADIUS	1.755	1.710	1.892
HORIZONTAL SPREAD	2.676	2.664	2.664
VERTICAL SPREAD	2.603	2.603	2.603
EXTREME SPREAD	3.129	3.129	2.882

NUMBER IN ONE INCH CIRCLE = 0
NUMBER IN TWO INCH CIRCLE = 1
NUMBER IN THREE INCH CIRCLE = 7



PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.147	1.054	1.103
MINIMUM X	:	-.842	-.776	-.727
MAXIMUM Y	:	1.364	1.515	1.348
MINIMUM Y	:	-1.485	-1.333	-1.054
CENTROID X	:	.271	.364	.315
CENTROID Y	:	.135	-.017	.150
POA TO CENTROID in.	:	.302	.365	.349
MIN RADIUS	:	.538	.489	.493
MEAN RADIUS	:	1.019	.950	.881
MAX RADIUS	:	1.603	1.620	1.485
HORIZONTAL SPREAD	:	1.989	1.830	1.830
VERTICAL SPREAD	:	2.849	2.848	2.402
EXTREME SPREAD	:	3.144	2.854	2.755
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		7	