

G686 8465
Replaces
C6225525

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: RE00169255

Serial: C6225525 Model M24 SWS Center Fire
Caliber: 7.62 NATO

Repairman:

Status:

Closed 6/8/2009 11:24:33 AM

Verify Repair

Address Information

Customer:

☒ Received From

Return To:

☐ Received From

Name: B CO 2/7

B CO 2/7

Address 1: SFG (A)

SFG (A)

Address 2:

PO Box:

PO Box:

City: FORT BRAGG

FORT BRAGG

State: NC

Zip Code: 28310

Country: US

State: NC

Zip Code: 28310

Country: US

FPL:

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
A057	Fit and Rear Sgt Base	1
D0C0	MARS RAIL	1

Repair Search

Refresh

Close

nodelj

6/8/2009

12:04 PM

C&PS

NUM

JMS

SCRL



G 686 8465 New

Serial Number: ~~C6225525~~

Model: M24 SWS



RE00169255

M-24
INSPECTION CHECKLIST - REPAIRS
CONTRACT #: W52H09-07-C-0207
ISSUED 10/1/2007

R & E NUMBER <u>169255</u>					
SERIAL NUMBER <u>C6225525 C6868465</u>					
LOG-IN DATE <u>6-8-09</u>					
OPERATION #	OPERATION NAME		DATE	INITIAL	
500	DIS-ASSEMBLE GUN		6-9-09	RTZ	
505	RE-BARREL		6-11-09	RTZ	
420	ASSEMBLE		6-11-09	RTZ	
440	PROOF		6-11-09	SPD	
460	CHECK HEADSPACE		6-11-09	SPD	
470	DIS-ASSEMBLE GUN		6-11-09	SPD	
480	MAGNAFLUX		6/13/09	(D)	
510	DRILL AND TAP		6-12-09	SP	
500	ROLLMARK CALIBER		6/16/09	RT	
520	GOFF BLAST BBL / REC		6/16	SP	
530 & 540	APPLY COATINGS		6/17		
560	FINAL ASSEMBLY		6-18-09	RTZ	
640	FUNCTION TEST AND	PASS FAIL	6/22/09	R.B.	
650	TARGET	PASS FAIL	6/22/09	R.B.	
	MALFUNCTION	CORRECTION			
	MALFUNCTION	CORRECTION		6/22/09	TOUR
	MALFUNCTION	CORRECTION			
	MALFUNCTION	CORRECTION			
670	FINAL INSPECTION				
	A) HEADSPACE	PASS FAIL	6-22-09	SP	
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	2.75 2.68 2.70 2.64 2.70	6-22-09 L.H.	
680	F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX	4° 4° 4°	6-22-09 L.H.	
	G) SAFETY OFF FORCE	2 LBS MIN	5° 5° 5°	6-22-09 L.H.	
	I) FIRING PIN INDENT	.020	.004 .004 .004	6-22-09 L.H.	
690	PACK		6/23/09	RTZ	

F006 REV 1/2009

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6868465.__0

FILE DATE AND TIME: 06/22/2009 14:49

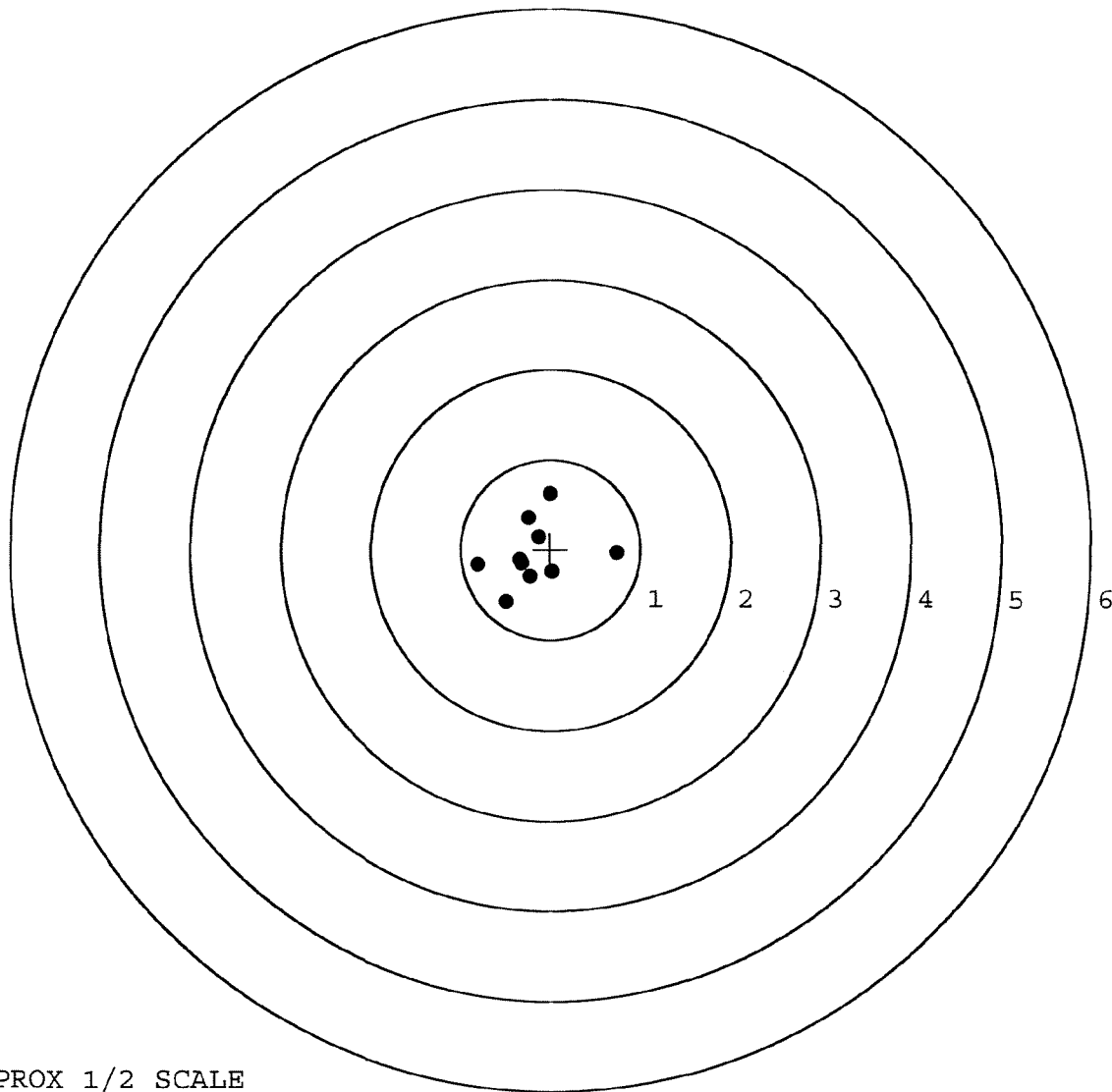
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.052
The Average Y Centroid of the Five Target Set:	0.019
The Average Point of Impact of the Five Target Set:	0.055
The Average Mean Radius of the Five Target Set:	0.481
The Distance from POA to Centroid Target #1:	0.192
The Distance from Centroid Target #2 to Centroid Target #1:	0.360
The Distance from Centroid Target #3 to Centroid Target #1:	0.192
The Distance from Centroid Target #4 to Centroid Target #1:	0.103
The Distance from Centroid Target #5 to Centroid Target #1:	0.266

SERIAL NUMBER: G6868465.____0
TARGET NUMBER: 1
FILE DATE: 06/22/2009
FILE TIME: 14:49

POINT#	X	Y
1:	-0.012	0.620
2:	-0.250	0.355
3:	0.737	-0.046
4:	-0.136	0.142
5:	-0.346	-0.114
6:	-0.812	-0.172
7:	-0.500	-0.582
8:	-0.229	-0.303
9:	0.026	-0.251
10:	-0.326	-0.160

X CENTROID: -0.185
Y CENTROID: -0.051
POA TO CENTROID: 0.192
HORZ SPREAD: 1.549
VERT SPREAD: 1.202
GROUP SPREAD: 1.554
MIN RADIUS: 0.173
MAX RADIUS: 0.922
MEAN RADIUS: 0.438
IN 1 IN DIAMETER: 6
IN 2 IN DIAMETER: 10
in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6868465. __0

TARGET NUMBER: 2

FILE DATE: 06/22/2009

FILE TIME: 14:49

POINT#	X	Y
1:	0.109	0.574
2:	0.291	0.609
3:	0.236	0.334
4:	0.725	0.013
5:	0.568	-0.137
6:	-0.532	-0.201
7:	-0.444	0.270
8:	-0.926	0.558
9:	0.270	0.065
10:	0.303	0.041

X CENTROID: 0.060

Y CENTROID: 0.213

POA TO CENTROID: 0.221

HORZ SPREAD: 1.651

VERT SPREAD: 0.810

GROUP SPREAD: 1.739

MIN RADIUS: 0.214

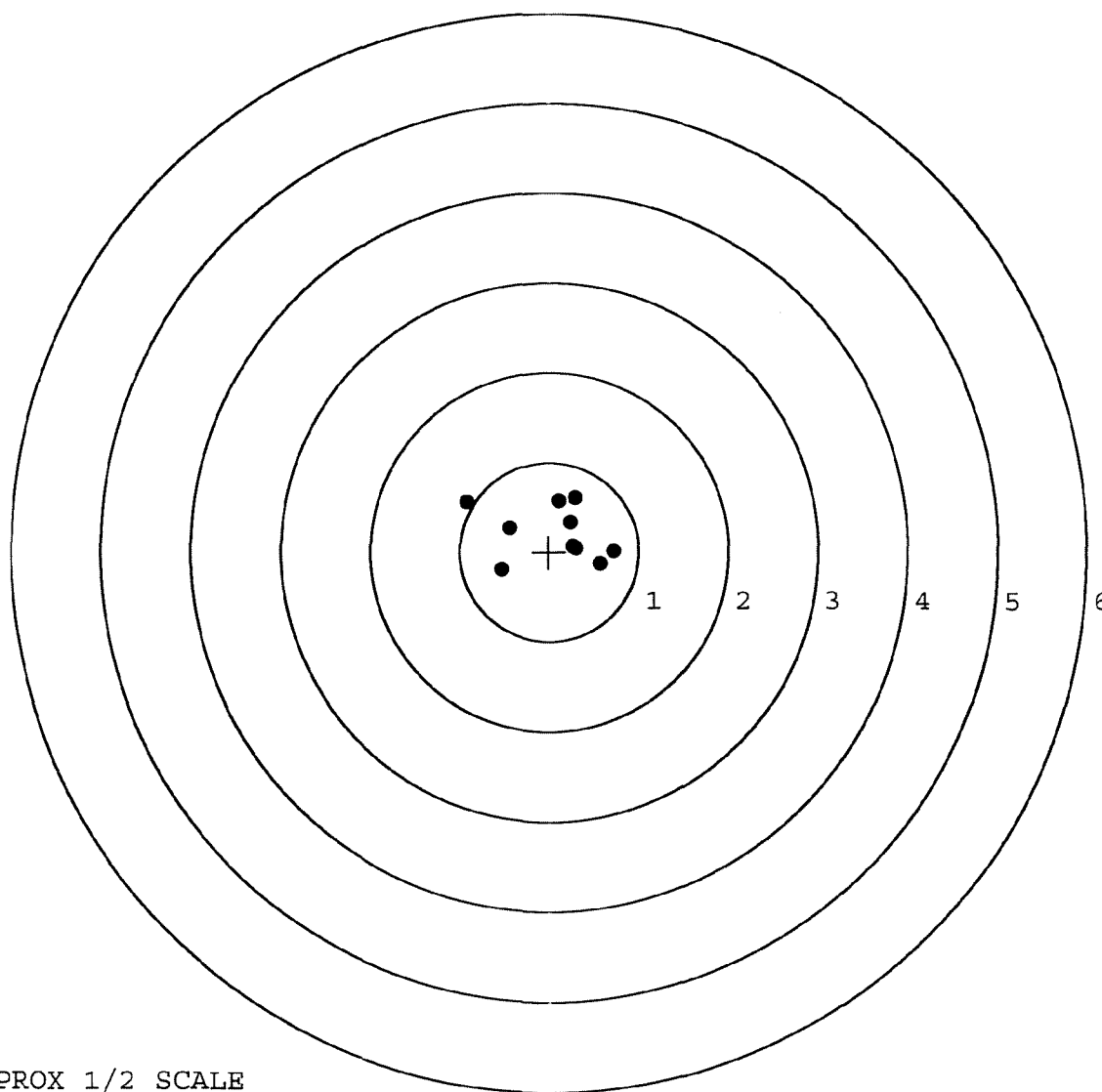
MAX RADIUS: 1.045

MEAN RADIUS: 0.518

IN 1 IN DIAMETER: 5

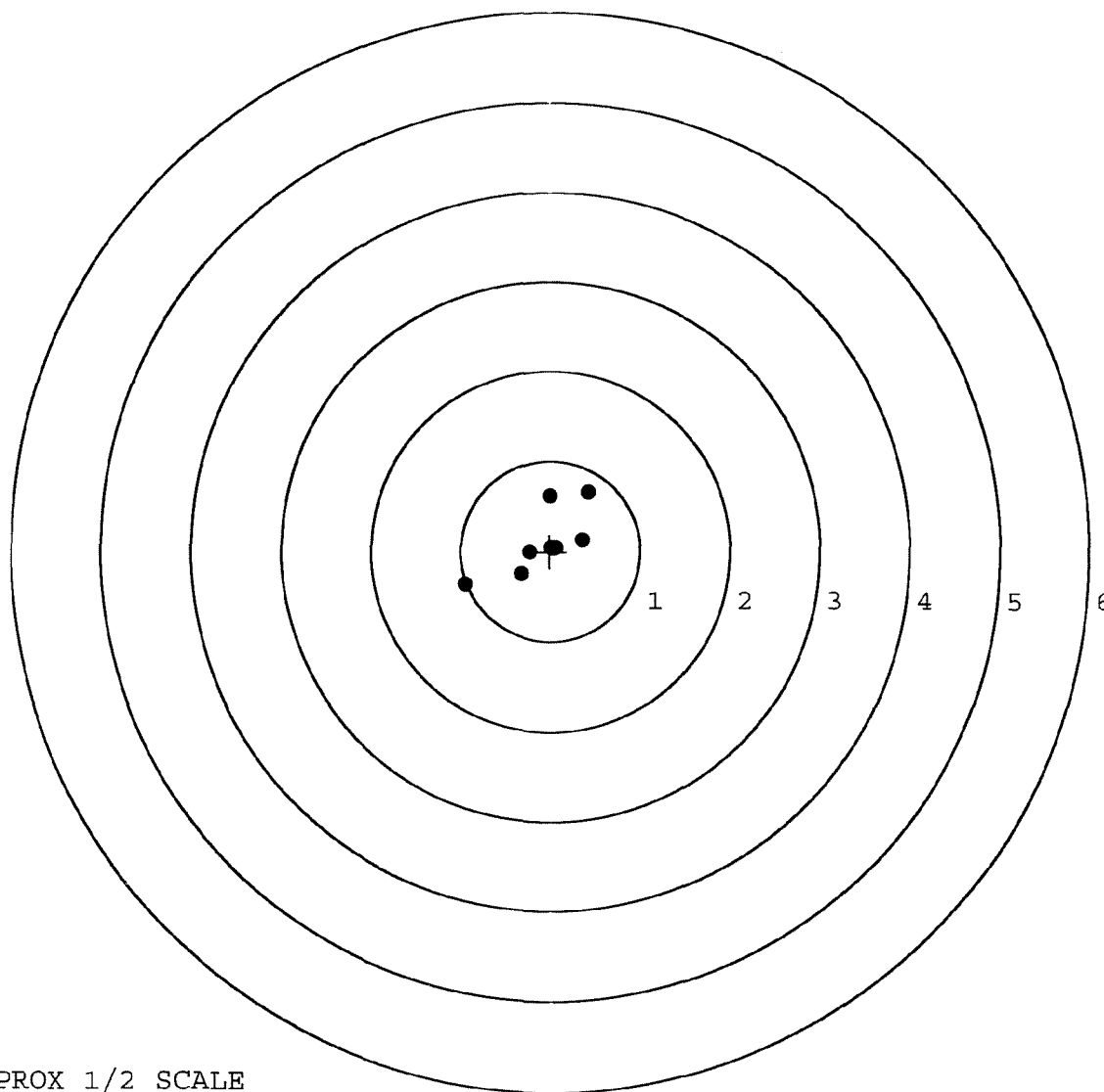
IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6868465. __0	POINT#	X	Y
TARGET NUMBER: 3	1:	0.423	0.654
FILE DATE: 06/22/2009	2:	-0.003	0.614
FILE TIME: 14:49	3:	0.354	0.128
	4:	-0.227	-0.010
X CENTROID: -0.057	5:	-0.324	-0.254
Y CENTROID: 0.093	6:	-0.947	-0.368
POA TO CENTROID: 0.109	7:	0.023	0.041
HORZ SPREAD: 1.370	8:	0.043	0.038
VERT SPREAD: 1.022	9:	0.067	0.040
GROUP SPREAD: 1.709	10:	0.020	0.042
MIN RADIUS: 0.092			
MAX RADIUS: 1.002			
MEAN RADIUS: 0.375			
# IN 1 IN DIAMETER: 7			
# IN 2 IN DIAMETER: 9			
# in 3 IN DIAMETER: 10			



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6868465. 0

TARGET NUMBER: 4

FILE DATE: 06/22/2009

FILE TIME: 14:49

POINT#	X	Y
1:	-0.250	0.769
2:	-0.674	0.393
3:	-0.733	0.107
4:	-0.407	-0.072
5:	0.049	-0.498
6:	0.359	-0.524
7:	0.269	0.465
8:	0.140	-0.266
9:	0.047	-0.075
10:	0.004	-0.010

X CENTROID: -0.120

Y CENTROID: 0.029

POA TO CENTROID: 0.123

HORZ SPREAD: 1.092

VERT SPREAD: 1.293

GROUP SPREAD: 1.429

MIN RADIUS: 0.130

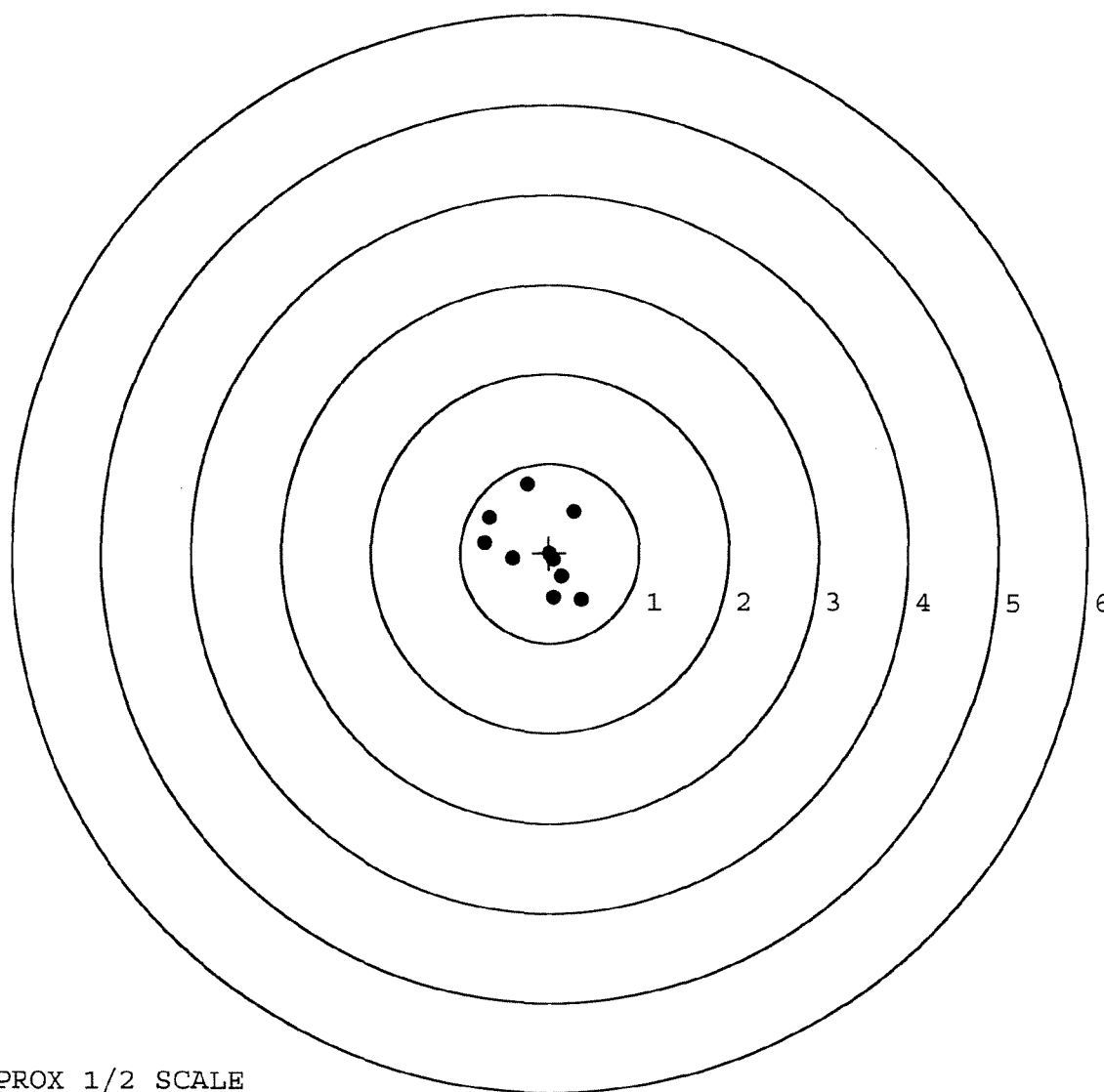
MAX RADIUS: 0.751

MEAN RADIUS: 0.493

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6868465. __0

TARGET NUMBER: 5

FILE DATE: 06/22/2009

FILE TIME: 14:49

POINT#	X	Y
--------	---	---

1:	-0.360	0.802
----	--------	-------

2:	-0.164	0.552
----	--------	-------

3:	0.478	0.100
----	-------	-------

4:	0.792	-0.869
----	-------	--------

5:	-0.695	-0.500
----	--------	--------

6:	-0.374	-0.500
----	--------	--------

7:	-0.076	-0.369
----	--------	--------

8:	0.150	-0.410
----	-------	--------

9:	0.362	-0.340
----	-------	--------

10:	0.320	-0.342
-----	-------	--------

X CENTROID: 0.043

Y CENTROID: -0.188

POA TO CENTROID: 0.193

HORZ SPREAD: 1.487

VERT SPREAD: 1.671

GROUP SPREAD: 2.030

MIN RADIUS: 0.217

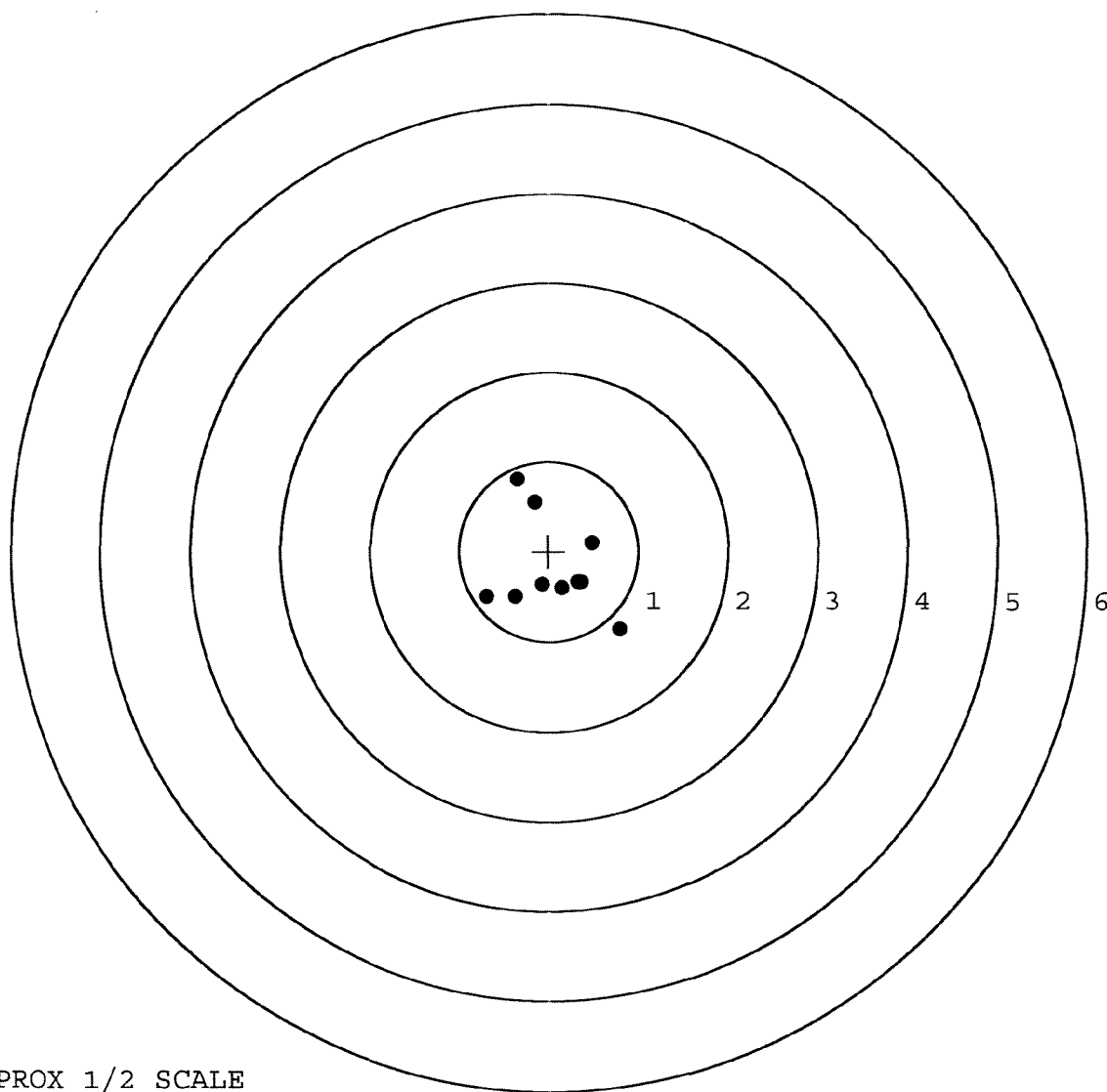
MAX RADIUS: 1.069

MEAN RADIUS: 0.583

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

RECEIVING AND ESTIMATING REPORT

COMMENTS

M24

ORDER
R 96-13364

INITIAL FPS	CUSTOMER ORDER NO. 11354					
DATE RECEIVED 05/30/96	DATE OPENED 05/30/96	DATE CODE BJ 1-89	SERIAL NUMBER C6225525	NEW SERIAL NUMBER	MODEL AND GRADE 700 7.62	NATO
ACCESSORIES W/STUDS		SCOPE BASE				

FROM:

DEPT OF THE ARMS
HSC, 2ND. BN 7TH SFG (A)
FT BRAGG NC 28307

SHIP TO:

DEPT OF THE ARMS
HSC, 2ND. BN 7TH SFG (A)
FT BRAGG NC 28307

CUST NO: 143691 C.O.D.

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

GUN CONDITION

- ☐ NEW
☐ LIGHTLY WORN
☐ WORN
☐ VERY WORN
☐ UNREPAIRABLE
☐ MARRED

REPAIR CHARGE

EXCISE

TAX

INSURANCE

UPS

PARCEL POST

TOTAL

CUSTOMER CONCERN	AMMO	FUNCTION	FINISH	ACCURACY	FIT	INSPECT
CYCLE	A1	B1				
TRIGGER GROUP		B2			E1	F1
BOLT ASSY.		B3			E2	F2
BARREL ASSY.		B4		D1	E3	F3
REC. ASSY.		B5		D2	E4	F4
WOOD			C1	D3	E5	F5
METAL			C2			

MAIN FAULT

PARTS

Barrel - 96003

COMMENTS

Repowder Coat - Trigger Guard Assy,
Front & Rear Sight Bases
Re-line Scope Base & Swivel
Studs

REPAIRMAN RW	PROOF RW	CLEAN ✓	TEST K	TARGET K	PATTERN
GALLERY TESTER RW	DATE 6/6/96	DATE 6/8/96	DATE 6/18/96	DATE 6/18/96	DATE

OFFICE COPY

RD6925 REV. 1/94

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

M2400094951

PAYMENT:

Mastercard / Visa (circle one)

Card #:

Exp. Date:

Signature

RETURN:

- ☐ Clark Street Entrance
☐ Via US Mail or UPS

(PLEASE PRINT CLEARLY)

FIREARMS DELIVERED TO PLANT

FILE

011354

DATE

05-29-96

CUSTOMER NAME:

ADDRESS:

ZIP:

PHONE:

FIREARM

MODEL:

GAUGE:

SERIAL #

REMINGTON EMPLOYEE:

YES ☐ NO ☒

EMPLOYEE #

DEPT. #

CHECK FOR AMMUNITION

CONDITION:

WOOD	GOOD	FAIR	POOR	FANCY	PLAIN
METAL	GOOD	FAIR	POOR	FANCY	PLAIN
BARREL	VT. RIB	PLAIN	DEER RSS		

ACCESSORIES:

SCOPE: YES NO (BRAND NAME/POWER)

SLING: YES NO GUN CASE: YES NO (HARD - SOFT)

EXTRA BBL FOR GUN MENTIONED ABOVE:

OTHER (Note in this area items missing or added from orig. equipment)

CUSTOMER REQUEST:

SIGNATURE:

(Person delivering firearm to Plant)

DATE:

SIGNATURE:

(Security Officer)

DATE:

SIGNATURE:

(Firearm picked up by)

DATE:

Arm Service Copy

MAINTENANCE REQUEST				PAGE NO.	NO. OF PAGES	REQUIREMENTS CONTROL SYMBOL CSGLD - 1047(R1)	
For use of this form, see DA PAM 738-750; the proponent agency is DCSLOG							
SECTION I - EQUIPMENT DATA							
CONTROL NUMBER		WORK ORDER NO.		WESDC	ORG. PD 02	PD AUTHENTICATION 	
☒ Work Request ☐ MWO ☐ Warranty Claim		1A. ORGANIZATION HSC, 2/7 SFG(A) FT. BRAGG, NC 28307		B. LOCATION BLDG E-3928 FT. BRAGG, NC 28307		C. UNIT IDENT CODE WH00DO	
2. SERIAL NO. C6225525		3. NOUN NOMENCLATURE RIFLE, SNIPER		4. LINE NO.	5. MODEL M24	6. NATIONAL STOCK NUMBER 1005-240-2136	
7A. MAINTENANCE ACTIVITY	B. LEVEL	8. UTILIZATION CODE	9A. MCSR ITEM	9B. SRC D	9C. PACING ITEM	10. HOURS	11. MILES
						12. ROUNDS	13. STARTS
14. FAILURE DETECTED DURING (Select one - use ☒ or X) ☐ A Sch. Main. ☐ C Test ☐ E Storage ☐ G Flight ☐ B Handling ☒ D Normal Op ☐ F Inspection ☐ H Other				15. FIRST INDICATION OF TROUBLE (Select one - use ☒ or X) ☐ 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) DUE TO THE NUMBER OF ROUNDS FIRED, THE BARREL NEEDS REPLACED							
B. REMARKS REBARREL AND RETURN REQUESTED. POC IS CPT BURNS AT (910) 432-5208							
PREPARATION INSTRUCTIONS (Prior to using this form, read DA PAM 738-750 for detailed preparation instructions)							
1. Place a "✓" or an "X" in the box for the type of action required. 2. Enter the WESDC if the item is Materiel Condition Status Reportable. 3. Enter the priority designator as determined from the urgency of need and force activity designator. 4. The Unit Commander, Chief of TDA activity or their designated representative will authenticate, by signature, a priority of 01 through 08. 5. Block 1A. Enter the name of the organization submitting the request. 6. Block 1B. Enter the unit submitting the request; units overseas enter APO only. 7. Block 1C. Enter the unit identification code of the unit in block 1A. 8. Block 2. Enter the equipment serial number. For ammunition, enter the lot number. For administrative-use vehicles, enter the USA registration number. 9. Block 3. Enter the noun abbreviation of the item. 10. Block 4. Enter the item line number, if applicable. 11. Block 5. Enter the model number. 12. Block 6. Enter the National Stock Number of the item listed in Block 3.				13. Block 7. Enter the name of the support activity. 14. Block 7A. Enter the symbol of the maintenance category (O, F, H, D, or L). 15. Block 8. Enter the utilization code. 16. Block 9A. Enter the word "yes" if the item is Materiel Condition Status Reportable. 17. Block 9B. Enter the equipment readiness code, if applicable. 18. Block 9C. Enter the word "yes" if the item is a pacing item. 19. Block 10. Enter the hour reading, if applicable. 20. Block 11. Enter the mileage from the odometer, if applicable. 21. Block 12. Enter the total rounds fired, if applicable. 22. Block 13. For turbine engines, enter the number of hot starts. 23. Block 14. Enter a "✓" or "X" in the proper block. 24. Block 15. Enter a "✓" or "X" in the proper block. 25. Block 16. Describe briefly the fault or symptoms needing correction.			
23. SUBMITTED BY		24. RECEIVED BY					
JULIAN DATE		JULIAN DATE					

MAINTENANCE REQUEST					PAGE NO		NO. OF PAGES		REQUIREMENTS CONTROL SYMBOL CSGLD - 1047(R1)																
For use of this form, see DA PAM 738-750, the proponent agency is DCSLOG																									
SECTION I - EQUIPMENT DATA																									
CONTROL NUMBER		WORK ORDER NO.			WESDC		ORG PD		PD AUTHENTICATION																
☒ Work Request ☐ MWO ☐ Warranty Claim		1A. ORGANIZATION HSC, 2/1 SFG(A) FT. BRAGG, NC 28307			B. LOCATION CLUE E-3928 FT. BRAGG, NC 28307			C. UNIT IDENT CODE WH00 DO																	
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14. FAILURE DETECTED DURING (Select one - use ☒ or X) <table style="width:100%;"> <tr> <td>☐ A Sch. Main.</td> <td>☐ C Test</td> <td>☐ E Storage</td> <td>☐ G Flight</td> </tr> <tr> <td>☐ B Handling</td> <td>☒ D Normal Op</td> <td>☐ F Inspection</td> <td>☐ H Other</td> </tr> </table>					☐ A Sch. Main.	☐ C Test	☐ E Storage	☐ G Flight	☐ B Handling	☒ D Normal Op	☐ F Inspection	☐ H Other	15. FIRST INDICATION OF TROUBLE (Select one - use ☒ or X) <table style="width:100%;"> <tr> <td>☐ 068 Inoperative</td> <td>☐ 258 Overheating</td> <td>☐ 790 Out of Adjustment</td> </tr> <tr> <td>☐ 008 Noisy</td> <td>☐ 387 Low Performance</td> <td>☒ Other</td> </tr> </table>							☐ 068 Inoperative	☐ 258 Overheating	☐ 790 Out of Adjustment	☐ 008 Noisy	☐ 387 Low Performance	☒ Other
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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.	H. PARTS COST															
		(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		22. Data Transcribed																		
23. SUBMITTED BY		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																	

DA FORM 2407, AUG 88

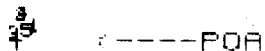
EDITION OF MAY 81 MAY BE USED

CONTROL COPY 3

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06225525
17 Apr 1900

CENTROIDAL DISTANCES

0 TO	1	.443898
1 TO	2	.320339
1 TO	3	.401299
1 TO	4	.315357
1 TO	5	.144941

3
----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1424
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .353
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .38064
THE AMR FOR THIS RIFLE IS: .905

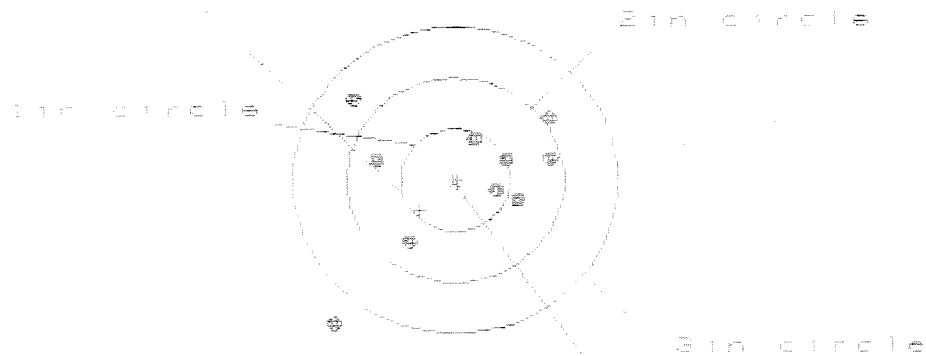
17 Apr 1988

FILE://PATTERNING/CENTERFIRE_PATT/08225585

CENTERFIRE PATTERNS

1

FOR



OF SHOTS= 10

IN CIR

1 in = 2

2 in = 7

3 in = 9

HS= 2.063

VS= 2.200

GS= 2.930

CENTROID +

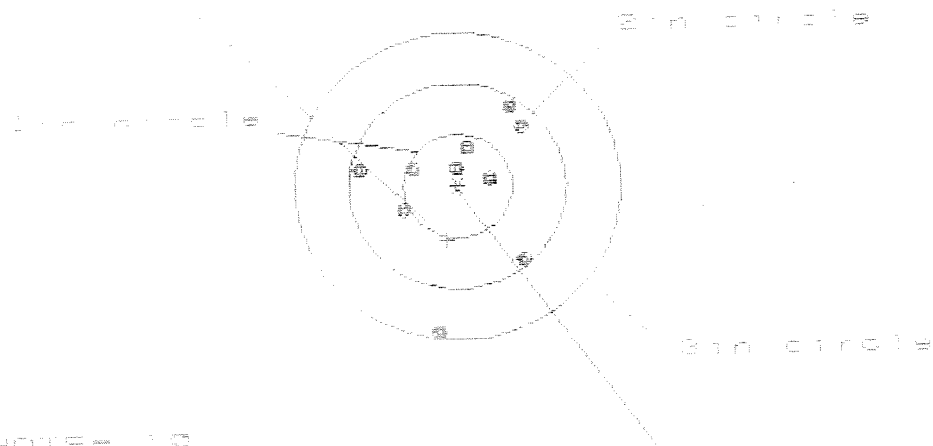
PATTERN #			
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.891	.761	.623
MINIMUM X	-1.171	-1.106	-.952
MAXIMUM Y	.770	.610	.557
MINIMUM Y	-1.439	-.807	-.731
CENTROID X	.329	.459	.597
CENTROID Y	.298	.458	.382
POA TO CENTROID (in.)	.444	.648	.789
MIN RADIUS	.345	.235	.196
MEAN RADIUS	.805	.675	.557
MAX RADIUS	1.856	1.263	.995
HORIZONTAL SPREAD	2.063	1.867	1.575
VERTICAL SPREAD	2.209	1.417	1.268
EXTREME SPREAD	2.930	1.896	1.824
NUMBER IN ONE INCH CIRCLE	=	2	
NUMBER IN TWO INCH CIRCLE	=	7	
NUMBER IN THREE INCH CIRCLE	=	9	

17 Apr 1988

FILE/PATTERNING/CENTERFIRE_PATT/08225585

CENTERFIRE PATTERNS # 2

FOR



OF SHOTS- 10

IN CIR

1 in = 4

2 in = 9

3 in = 10

HS= 1.481

VS= 2.189

GS= 2.312

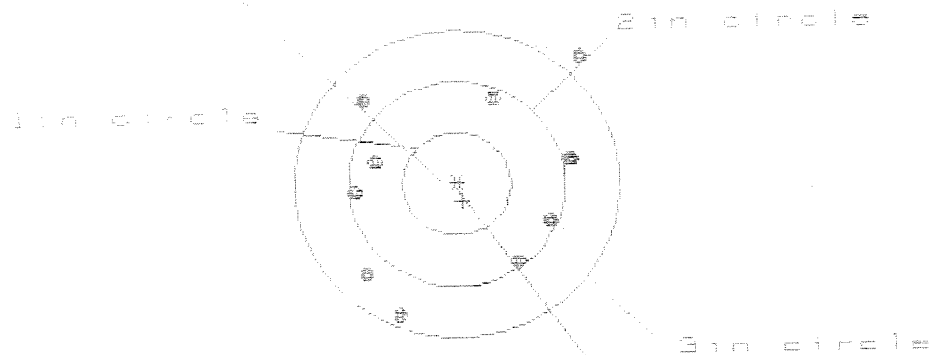
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.601	.574	.633
MINIMUM X	-.880	-.907	-.848
MAXIMUM Y	.804	.650	.487
MINIMUM Y	-1.385	-.886	-.804
CENTROID X	.105	.132	.073
CENTROID Y	.527	.681	.599
FOR TO CENTROID	.537	.693	.604
MIN RADIUS	.135	.059	.060
MEAN RADIUS	.685	.569	.543
MAX RADIUS	1.407	1.044	1.010
HORIZONTAL SPREAD	1.481	1.481	1.481
VERTICAL SPREAD	2.189	1.536	1.291
EXTREME SPREAD	2.312	1.695	1.695
NUMBER IN ONE INCH CIRCLE	=	4	
NUMBER IN TWO INCH CIRCLE	=	9	
NUMBER IN THREE INCH CIRCLE	=	10	

17 Apr 1998

FILE:/PATTERNING/CENTERFIRE_PAT1/08225525

CENTERFIRE PATTERNS # 3 FOR



OF SHOTS= 10
 # IN CIR
 1in = 5
 2in = 5
 3in = 9
 1E= 2.628
 2E= 2.518
 3E= 3.019

CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.113	1.216	1.162
MINIMUM X	-.912	-.788	-.842
MAXIMUM Y	1.258	.981	.841
MINIMUM Y	-1.288	-1.128	-.913
CENTROID X	-.051	-.175	-.121
CENTROID Y	.169	.038	.178
POA TO CENTROID in.	.177	.177	.209
MIN RADIUS	.778	.731	.713
MEAN RADIUS	1.112	1.034	1.004
MAX RADIUS	1.588	1.283	1.286
HORIZONTAL SPREAD	2.025	2.004	2.004
VERTICAL SPREAD	2.518	2.101	1.754
EXTREME SPREAD	3.019	2.282	2.282
NUMBER IN ONE INCH CIRCLE =	5	5	5
NUMBER IN TWO INCH CIRCLE =	5	5	5
NUMBER IN THREE INCH CIRCLE =	9	9	9

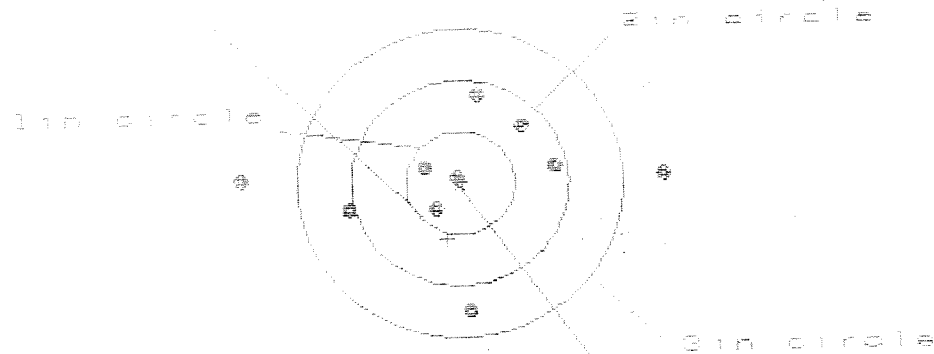
17 Apr 1988

FILE:/PATTERNING/CENTERFIRE_PATT/08223525

CENTERFIRE PATTERNS

4

POB



OF SHOTS= 12

IN CIR

1 in = 3

2 in = 5

3 in = 8

HS= 3.847

VS= 2.106

GS= 3.847

CENTROID *

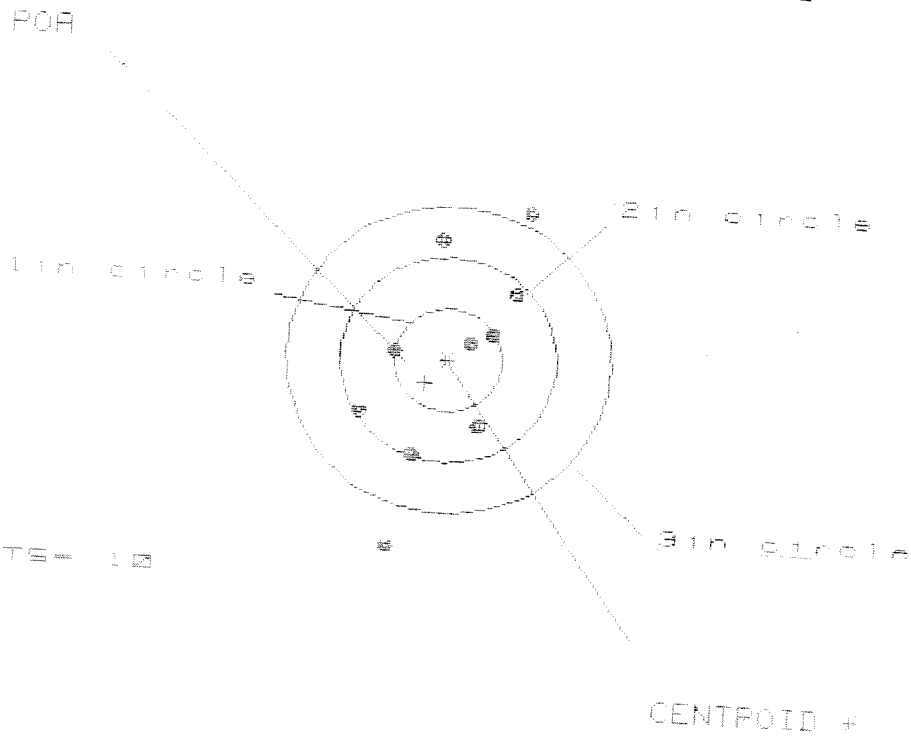
PATTERN #

	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.864	1.644	.847
MINIMUM X	-1.983	-1.224	-1.019
MAXIMUM Y	.816	.819	.821
MINIMUM Y	-1.290	-1.288	-1.285
CENTROID X	.128	.348	.143
CENTROID Y	.541	.539	.536
POB TO CENTROID in.	.556	.642	.555
MIN RADIUS	.890	.258	.099
MEAN RADIUS	.953	.858	.713
MAX RADIUS	1.983	1.644	1.286
HORIZONTAL SPREAD	3.847	2.868	1.866
VERTICAL SPREAD	2.106	2.106	2.106
EXTREME SPREAD	3.847	2.884	2.109
NUMBER IN ONE INCH CIRCLE	=	3	
NUMBER IN TWO INCH CIRCLE	=	6	
NUMBER IN THREE INCH CIRCLE	=	8	

17 Apr 1988

FILE: PATTERNING/CENTERFIRE_PATT/08225525

CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1in = 2

2in = 7

3in = 8

HS= 1.469

VS= 3.317

GS= 3.516

PATTERN #

5

SHOTS (BEST OF)	10	9	8
MAXIMUM X	.654	.597	.590
MINIMUM X	-.815	-.972	-.797
MAXIMUM Y	1.508	1.307	1.136
MINIMUM Y	-1.809	-1.113	-.950
CENTROID X	.201	.258	.183
CENTROID Y	.230	.431	.268
POA TO CENTROID in.	.305	.502	.324
MIN RADIUS	.249	.129	.240
MEAN RADIUS	.940	.811	.733
MAX RADIUS	1.880	1.437	1.138
HORIZONTAL SPREAD	1.469	1.469	1.387
VERTICAL SPREAD	3.317	2.420	2.086
EXTREME SPREAD	3.516	2.601	2.098
NUMBER IN ONE INCH CIRCLE	=	2	
NUMBER IN TWO INCH CIRCLE	=	7	
NUMBER IN THREE INCH CIRCLE	=	8	

21 DAY TURN - AROUND

M-24
CONTRACT # DAAA09-92-C-0834

Barrel

R&E NO.

SERIAL NO. *C6225525*

LOG IN DATE: <i>5/30/96</i>		DATE	INIT.
INSPECT & VERIFY:			
OP. #	OP. NAME		
550	DIS-ASSEMBLE GUN		
560 A	RE-BARREL AT CUSTOM SHOP		
B	DRILL & TAP		
C	POLISH		
575	ASSEMBLE		
600	PROOF	<i>6/6/96</i>	<i>RW</i>
605	CHECK HEADSPACE	<i>6/6/96</i>	<i>RW</i>
610	DIS-ASSEMBLE		
612	MAGNAFLUX		
615	ROLLMARK CALIBER		
618	ROTO-BLAST		
620	APPLY COATINGS		
625 A	FINAL ASSEMBLY	<i>6/18/96</i>	<i>RW</i>
B	TRIGGER PULL TEST		
C	SAFETY ON FORCE		
D	SAFETY OFF FORCE		
E	FIRING PIN INDENT		
640	TARGET	<i>6/18/96</i>	<i>RW</i>
655	FINAL INSPECT	<i>6/20/96</i>	<i>RW</i>
660	PACK		

QAR INSPECTION

SHIP DATE

Final Inspection

Sn: C6225525

DATE REC'D: 5/30/76

DATE RET'D:

AUDITOR: RW

Item:

Barrel Assy.

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

Scope Assy.

☐ Scope☐ Scope Rings☒ Mounting Screws☒ Mounting Base☐ Screws☐ Finish☐ Looseness☐ CLARITY

Misc.

☐ DD-250☐ BAR CODE☐ PACKAGING

Item:

Stock Assy.

☒ STOCK☒ Sling Swivel Studs☒ ADJUSTABLE BUTT PLATE☒ LOCK NUTS☒ BARREL CLEARANCE☒ COLOR/FINISH

Systems Case

☐ Scope Case☐ Iron Sights☐ Deployment Kit

Trigger

☒ SAFETY OPERATION☒ SET

Comments:

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6225525

OP. #	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and Stock	12 9	88	RW
600	Proof	12 9	88	RW
607	Check Headspace	12 9	88	RW
610	Dis-assemble Gun	12 9	88	RW
612	Magnaflux Barrel Action		12-22-88	RW
	Magnaflux Bolt		1-3-89	RW
615	Rollmark Caliber		4/23/89	W.A.C.
617	Drill and Tap Sight Holes	1 3	89	FB
618	Polish Barrel	12 2	88	WJT
620	Apply Coatings (Barrel Action)		1-18-89	TSA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		1/19/89	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		1/19/89	RW
	C) Inspect Ejector Hole for Chamfer		1/19/89	RW
	D) Oil Firing Pin Ass'y		1/19/89	RW
	E) Adjust Trigger Pull to Min Setting and Stake		1/19/89	RW

op. #	OP. NAME	READINGS			DATE	INITIAL
625 cont.	F) Safety On Force	4	5	5	25 Jan 89	JL
	G) Safety Off Force	3	3	3	25 Jan 89	JL
	H) Trigger Pull Test & Retainability				19 Jan 89	JL
	I) Firing Pin Indent	.022	.0215	.022	25 Jan 89	JL
	J) Assemble Stock				1/26/89	RW
	K) Assemble Swivel Studs				1/26/89	RW
	L) Attach Front and Rear Sight Assemblies				1/26/89	RW
	M) Iron Sight Alignment				1/26/89	RW
	N) Detach Front & Rear Sights & place in numbered container				1/26/89	RW
	O) Attach Scope to Rifle				1/26/89	RW
	P) Detach & Attach Scope 20 Times				1/27/89	WB
640	Gallery Target & Test	63 R	89L		1/31/89	K
	A) Time					K
	B) Malfunctions		NONE			K
	C) Pierced Primers		NONE			K
	D) Optical Clarity of Scope		OK		1/31/89	K
645	Inspect for Live Ammo		NONE		1/31/89	K
655	Final Inspection					
	A) Headspace				1 Feb 89	JL
	B) Trigger Pull	2.12	2.18	2.19	1 Feb 89	JL
	C) Function				1 Feb 89	JL
660	Pack				23 Mar 89	JL

SWS TRIGGER PULL TEST

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

SERIAL NO. 5525

DATE 8/17/90

TESTER JEP

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#	COMMENTS
PULL #1	2.47	2.47	2.50	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.11	2.44	2.45	
PULL #3	2.41	2.44	2.40	
PULL #4	2.50	2.49	2.51	
PULL #5	2.41	2.48	2.30	
TOTAL	11.90	12.32	12.16	
AVG.	2.38	2.464	2.432	

	3.00# INITIAL	3.00# AFTER 20 CYCLES	COMMENTS
PULL #1	3.19	3.27	
PULL #2	3.24	3.33	
PULL #3	3.17	3.27	
PULL #4	3.19	3.25	
PULL #5	3.34	3.29	
TOTAL	16.13	16.41	
AVG.	3.226	3.282	

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.30	4.44		4.34
PULL #2	4.70	4.27		4.32
PULL #3	4.21	4.30		4.22
PULL #4	4.10	4.35		4.36
PULL #5	4.38	4.36		4.40
TOTAL	21.01	21.77		21.64
AVG.	4.202	4.354		4.328

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06225525
2 Feb 1989

CENTROIDAL DISTANCES

0 TO	1	.613236
1 TO	2	.693311
1 TO	3	.587716
1 TO	4	.152591
1 TO	5	.321111

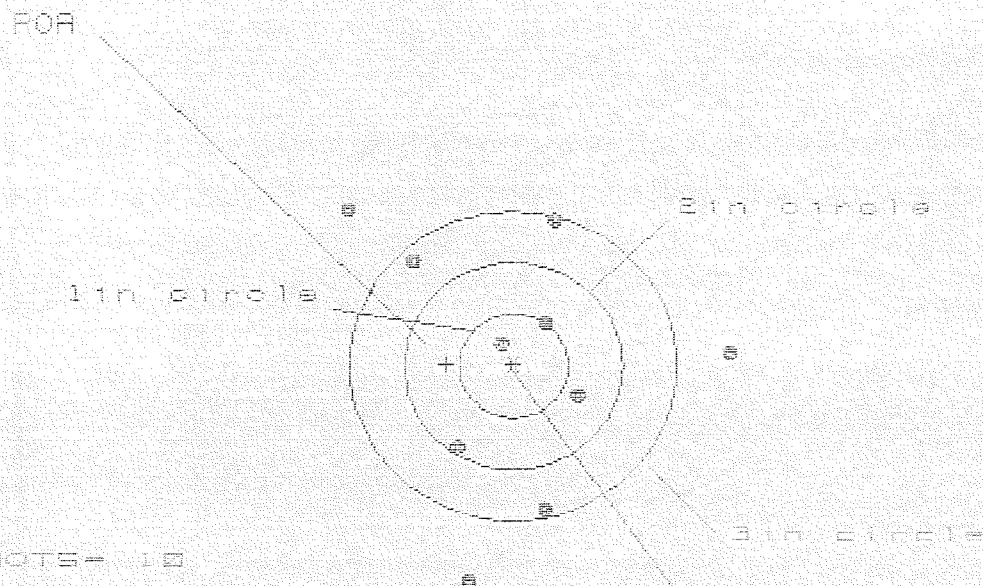
FOR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .3112
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0144
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .311533
THE AMR FOR THIS RIFLE IS: 1.044

31 Jan 1989

FILE:/PATTERNING/CENTERFIRE_PATT/CG225525

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1 in = 2

2 in = 4

3 in = 7

HS = 3.485

VS = 3.594

GS = 3.754

PATTERN #

:



SHOTS (BEST OF)

:

10

9

8

MAXIMUM X

:

1.968

1.913

1.722

MINIMUM X

:

-1.517

-1.567

-1.186

MAXIMUM Y

:

1.484

1.249

1.303

MINIMUM Y

:

-2.110

-1.634

-1.478

CENTROID X

:

.613

.663

.859

CENTROID Y

:

-1.017

.218

.062

FOR TO CENTROID in.

:

.614

.698

.861

MIN RADIUS

:

.268

.210

.341

MEAN RADIUS

:

1.291

1.165

1.061

MAX RADIUS

:

2.157

2.004

1.722

HORIZONTAL SPREAD

:

3.485

3.485

2.988

VERTICAL SPREAD

:

3.594

2.883

2.781

EXTREME SPREAD

:

3.754

3.754

3.060

NUMBER IN ONE INCH CIRCLE =

2

NUMBER IN TWO INCH CIRCLE =

4

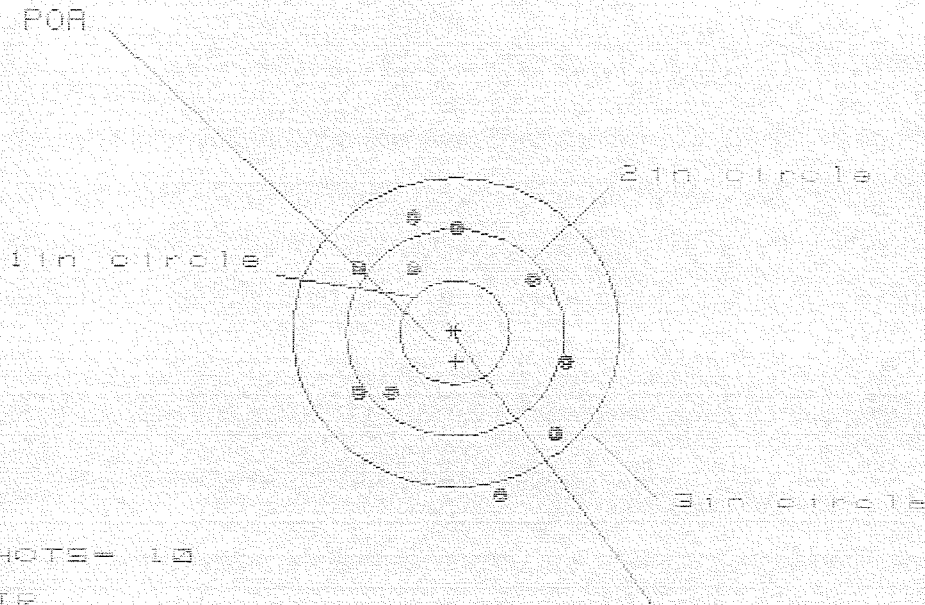
NUMBER IN THREE INCH CIRCLE =

7

31 Jan 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C8225525

CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1 in = 0

2 in = 3

3 in = 9

HS = 1.940

VS = 2.684

GS = 2.803

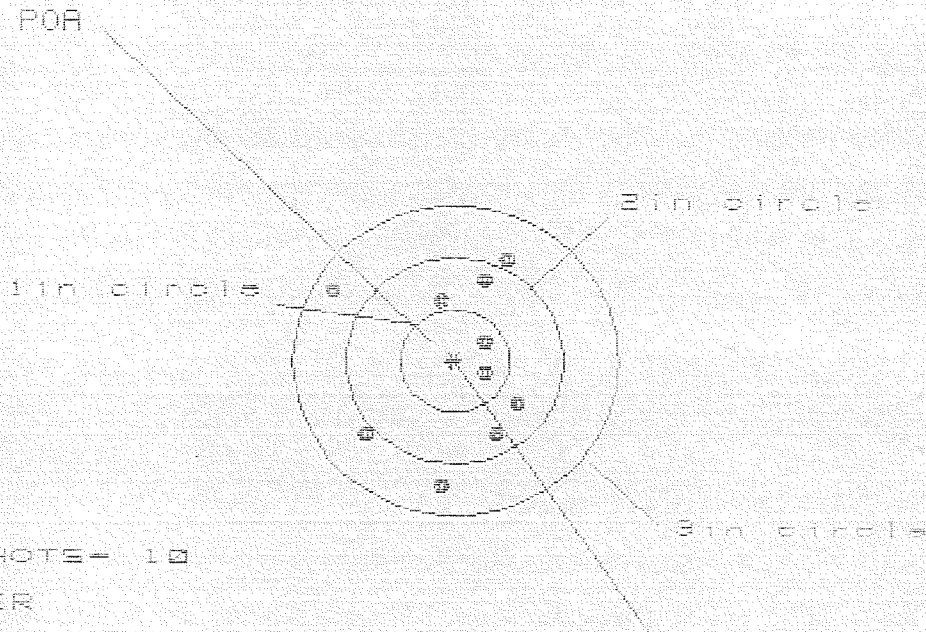
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.024	1.072	1.196
MINIMUM X	:	-0.916	-0.868	-0.744
MAXIMUM Y	:	1.121	0.947	0.805
MINIMUM Y	:	-1.563	-1.138	-0.910
CENTROID X	:	-0.013	-0.061	-0.186
CENTROID Y	:	0.281	0.455	0.597
POA TO CENTROID in.	:	0.281	0.459	0.625
MIN RADIUS	:	0.723	0.551	0.363
MEAN RADIUS	:	1.091	1.001	0.896
MAX RADIUS	:	1.622	1.511	1.352
HORIZONTAL SPREAD	:	1.940	1.940	1.940
VERTICAL SPREAD	:	2.684	2.085	1.715
EXTREME SPREAD	:	2.803	2.467	2.161
NUMBER IN ONE INCH CIRCLE =			0	
NUMBER IN TWO INCH CIRCLE =			3	
NUMBER IN THREE INCH CIRCLE =			9	

31 Jan 1989

FILE:/PATTERNING/CENTERFIRE_PATT/06225585

CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1 in = 2

2 in = 6

3 in = 10

HS = 1.688

VS = 2.179

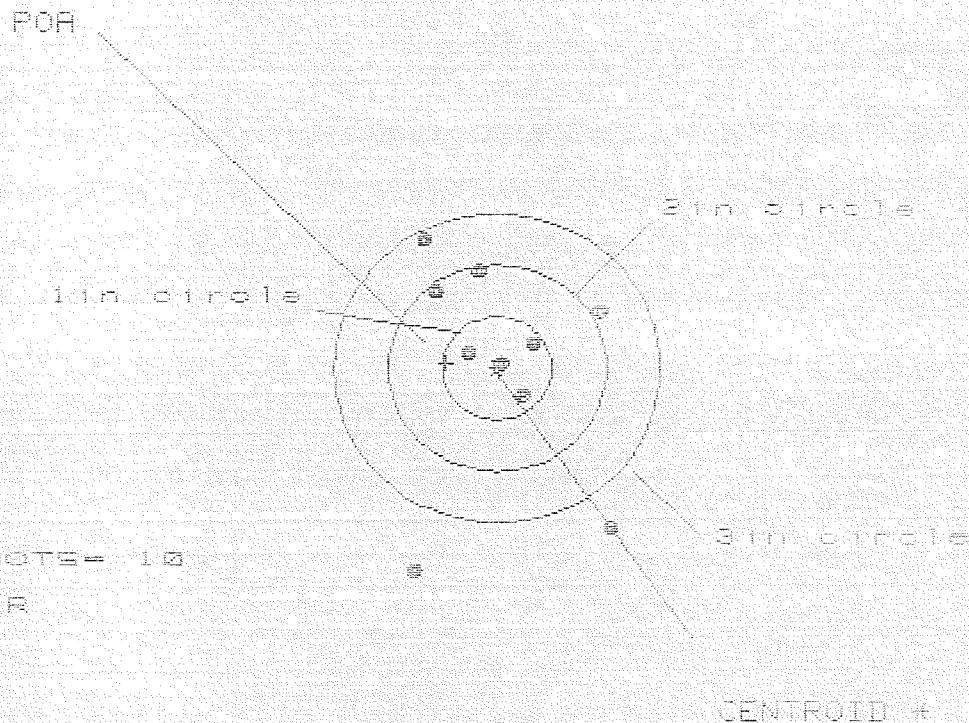
GS = 2.280

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.555	.429	.392
MINIMUM X	:	-1.133	-.927	-.964
MAXIMUM Y	:	.938	1.013	.867
MINIMUM Y	:	-1.241	-1.166	-.832
CENTROID X	:	.026	.152	.189
CENTROID Y	:	.012	-.063	.083
POA TO CENTROID in.	:	.029	.164	.205
MIN RADIUS	:	.253	.116	.166
MEAN RADIUS	:	.824	.739	.658
MAX RADIUS	:	1.316	1.202	1.273
HORIZONTAL SPREAD	:	1.688	1.356	1.356
VERTICAL SPREAD	:	2.179	2.179	1.699
EXTREME SPREAD	:	2.280	2.280	2.144
NUMBER IN ONE INCH CIRCLE =			2	
NUMBER IN TWO INCH CIRCLE =			6	
NUMBER IN THREE INCH CIRCLE =			10	

31 Jan 1985

FILE:/PATTERNING/CENTERFIRE_PATT/08225525

CENTERFIRE PATTERNS # 4



OF SHOTS = 10

IN CIR

1 in = 4

2 in = 6

3 in = 8

HS = 1.036

VS = 3.260

GS = 3.307

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.060	.974	.938
MINIMUM X	:	-.776	-.716	-.594
MAXIMUM Y	:	1.278	1.058	.835
MINIMUM Y	:	-1.982	-1.784	-.692
CENTROID X	:	.463	.549	.427
CENTROID Y	:	-.045	.175	.398
POA TO CENTROID IN.	:	.465	.576	.584
MTN RADIUS	:	.038	.206	.407
MEAN RADIUS	:	.943	.788	.634
MAX RADIUS	:	2.129	2.033	1.024
HORIZONTAL SPREAD	:	1.936	1.690	1.533
VERTICAL SPREAD	:	3.260	2.842	1.527
EXTREME SPREAD	:	3.307	3.307	1.753
NUMBER IN ONE INCH CIRCLE =			4	
NUMBER IN TWO INCH CIRCLE =			6	
NUMBER IN THREE INCH CIRCLE =			8	

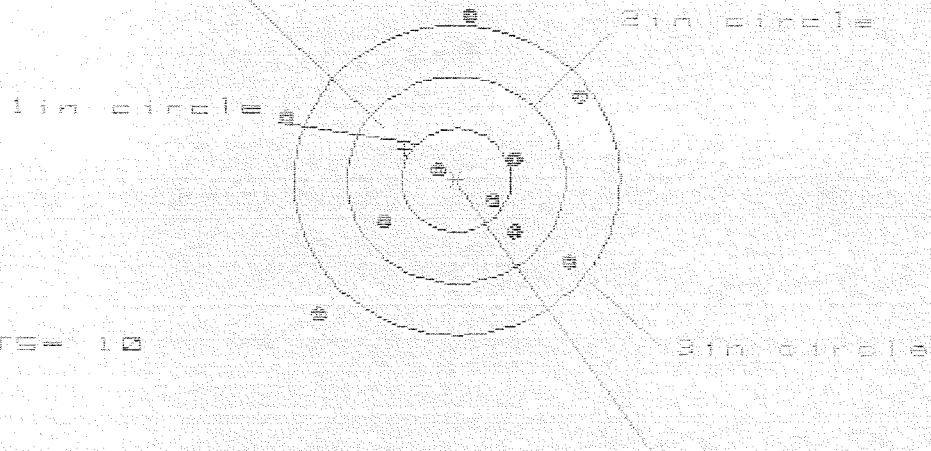
31 Jan 1989

FILE: \PATTERNING\CENTERFIRE_PATT\08223525

CENTERFIRE PATTERNS

5

POA



OF SHOTS= 10

IN CIR

1 in = 2

2 in = 5

3 in = 3

HS= 2.735

VS= 2.926

GS= 3.246

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.142	.997	.779
MINIMUM X	:	-1.593	-1.738	-1.070
MAXIMUM Y	:	1.613	1.467	1.525
MINIMUM Y	:	-1.313	-1.967	-1.909
CENTROID X	:	.467	.612	.830
CENTROID Y	:	-.303	-.157	-.215
POA TO CENTROID In.	:	.557	.632	.957
MIN RADIUS	:	.221	.310	.204
MEAN RADIUS	:	1.071	.972	.829
MAX RADIUS	:	1.852	1.800	1.548
HORIZONTAL SPREAD	:	2.735	2.735	1.849
VERTICAL SPREAD	:	2.926	2.434	2.434
EXTREME SPREAD	:	3.246	3.035	2.625
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		7	



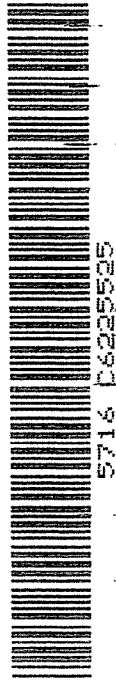

VERY IMPORTANT:
Instruction Book
enclosed to assure
safe use of this
firearm.

MODEL 700TM H24

SERIAL NO.
D6225525

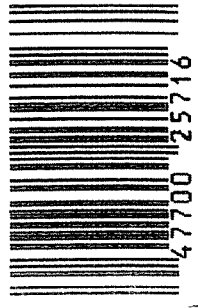
ORDER NO.
5716

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



5716 D6225525

UPC



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2/23