G 6521189
Replace
C. 6525250

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: RE00105570
Verify Repair
Serial: C6225250 Model: M24 SWS Center Fire Caliber: 7.62 NATO Produced: 12/20/1988
Repairman:
Status: Closed 12/27/2005 8:02:11 AM

Address Information

Customer: (Received From)	Return To: (Received From)
Name: DEPARTMENT OF THE ARMY	DEPARTMENT OF THE ARMY
Address 1: SGT J LENDOWSKI	SGT J LENDOWSKI
Address 2: 2ND DIV DR BLDG 3279 PO Box:	2ND DIV DR BLDG 3279 PO Box:
City: FORT LEWIS	FORT LEWIS
State: WA Zip Code: 98433 Country: US	State: WA Zip Code: 98433 Country: US

FFL:

Contact / Condition | Problems | Estimate | History / Status | Shipping / Billing

Contact Information

Phone: 253.967.3690
Fax:
Email: justin.lendowski@us.army.mil
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
A042	Adjustable Butt Pad	1
A057	Frt and Rear Sgt Base	2

Repair Search | Refresh | Close

neglelj | 12/27/2005 | 8:26 AM | CAPS | NUM | INS | SCRL

start

C6521189 (New)

Serial Number: ~~C6225250~~

Model: M24 SWS

RE00105570

DEPARTMENT OF THE ARMY
I TROOP, 3D SQUADRON, 2D CAVALRY REGIMENT
BLDG 3279, 2D DIVISION RD
FORT LEWIS, WASHINGTON 98433

REPLY TO
ATTENTION OF

105570

AFZH-CC-I

12 DEC 2005

MEMORANDUM FOR REMINGTON ARMS COMPANY

SUBJECT: M-24 Sniper Rifle

1. Enclosed is our M24 SWS (Remington model 700). We were issued the rifle through our military issuing system and the barrel is well worn. It has fired more than the maximum of 5,000 rounds and needs to be replaced. This causes the minute of angle to be off which in turn affects accuracy.

2. I understand Remington has a contract with the government to repair such deficiencies. As a sniper team leader it is very difficult to accomplish our training or a mission without the required equipment. We are a new unit standing up and are looking to get deployed within the year. We appreciate and thank you for any help or support you can provide. If you have any questions you can contact me at 253-967-3690, or e-mail me at justin.lendowski@us.army.mil. Thank you.

Seal 390007
390006

JUSTIN L. LENDOWSKI
SGT, IN
Sniper Team Leader

ROBERT J. FRINK
2LT, IN
Executive Officer

Printed on Recycled Paper

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 11-08-05

TESTER S.F.

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.51	2.64		2.42	
PULL #2	2.48	2.63		2.53	
PULL #3	2.41	2.38		2.46	
PULL #4	2.56	2.50		2.54	
PULL #5	2.67	2.49		2.44	
TOTAL	12.63	12.64		12.39	
AVERAGE	2.53	2.52		2.48	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	2.98	3.06		
PULL #2	3.08	2.80		
PULL #3	3.11	2.94		
PULL #4	3.09	2.94		
PULL #5	3.04	2.96		
TOTAL	15.30	14.70		
AVERAGE	3.06	2.94		

	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	3.82	4.18		4.00
PULL #2	3.92	4.22		4.13
PULL #3	4.04	4.15		3.83
PULL #4	4.08	4.12		3.88
PULL #5	4.07	4.14		3.98
TOTAL	19.93	20.81		19.82
AVERAGE	3.99	4.16		3.96

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFOMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6521189.__0
FILE DATE AND TIME: 01/11/2006 09:41

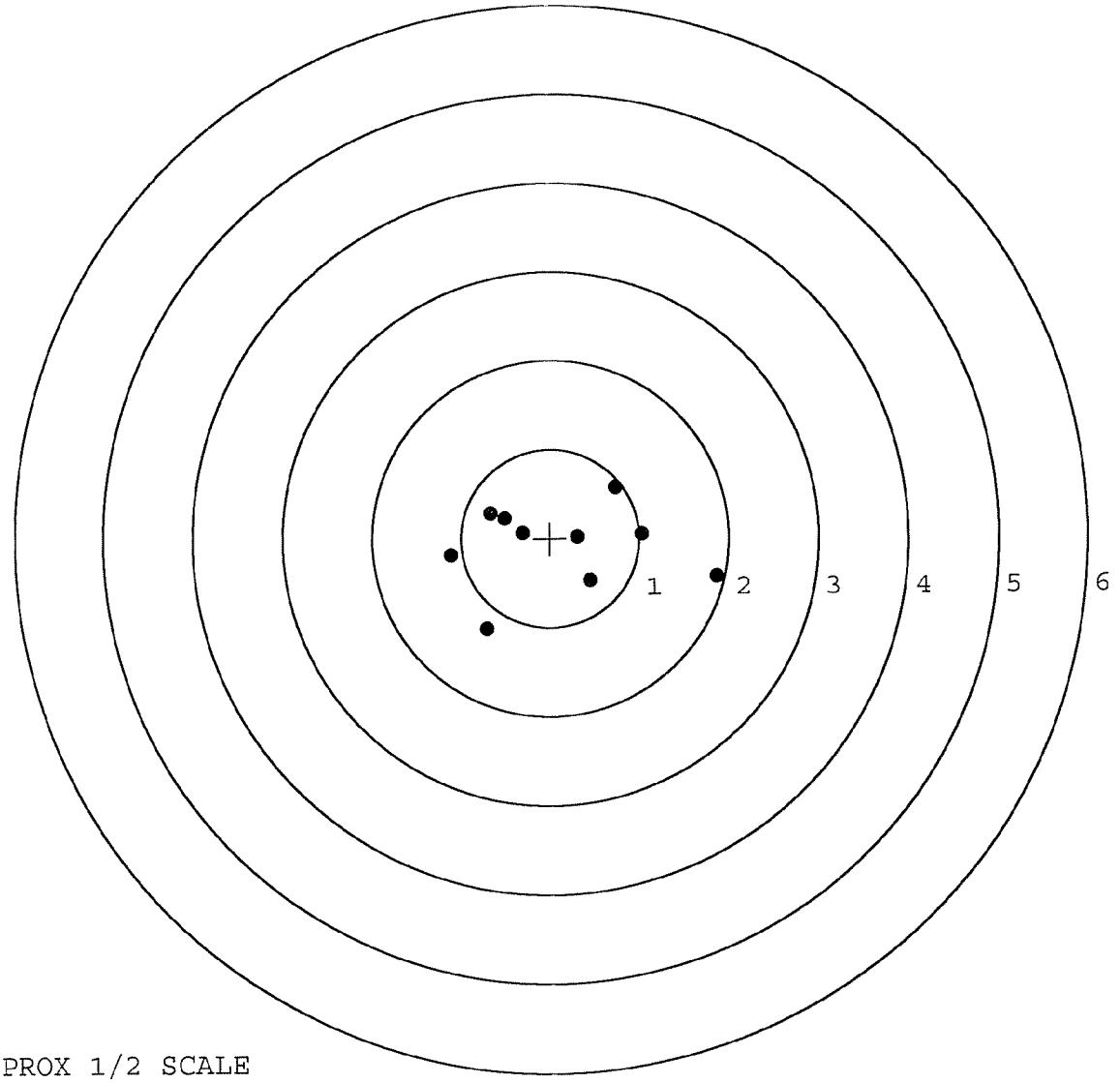
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.026
The Average Y Centroid of the Five Target Set:	-0.016
The Average Point of Impact of the Five Target Set:	0.030
The Average Mean Radius of the Five Target Set:	0.792
The Distance from POA to Centroid Target #1:	0.140
The Distance from Centroid Target #2 to Centroid Target #1:	0.115
The Distance from Centroid Target #3 to Centroid Target #1:	0.260
The Distance from Centroid Target #4 to Centroid Target #1:	0.223
The Distance from Centroid Target #5 to Centroid Target #1:	0.252

SERIAL NUMBER: G6521189.__0
TARGET NUMBER: 1
FILE DATE: 01/11/2006
FILE TIME: 09:41

X CENTROID:	0.106
Y CENTROID:	-0.092
POA TO CENTROID:	0.140
HORZ SPREAD:	2.980
VERT SPREAD:	1.586
GROUP SPREAD:	2.991
MIN RADIUS:	0.229
MAX RADIUS:	1.790
MEAN RADIUS:	0.886
# IN 1 IN DIAMETER:	2
# IN 2 IN DIAMETER:	7
# in 3 IN DIAMETER:	9

POINT#	X	Y
1:	1.861	-0.443
2:	1.029	0.041
3:	0.740	0.571
4:	0.309	0.015
5:	0.449	-0.479
6:	-0.311	0.063
7:	-0.509	0.229
8:	-0.673	0.289
9:	-1.119	-0.186
10:	-0.715	-1.015

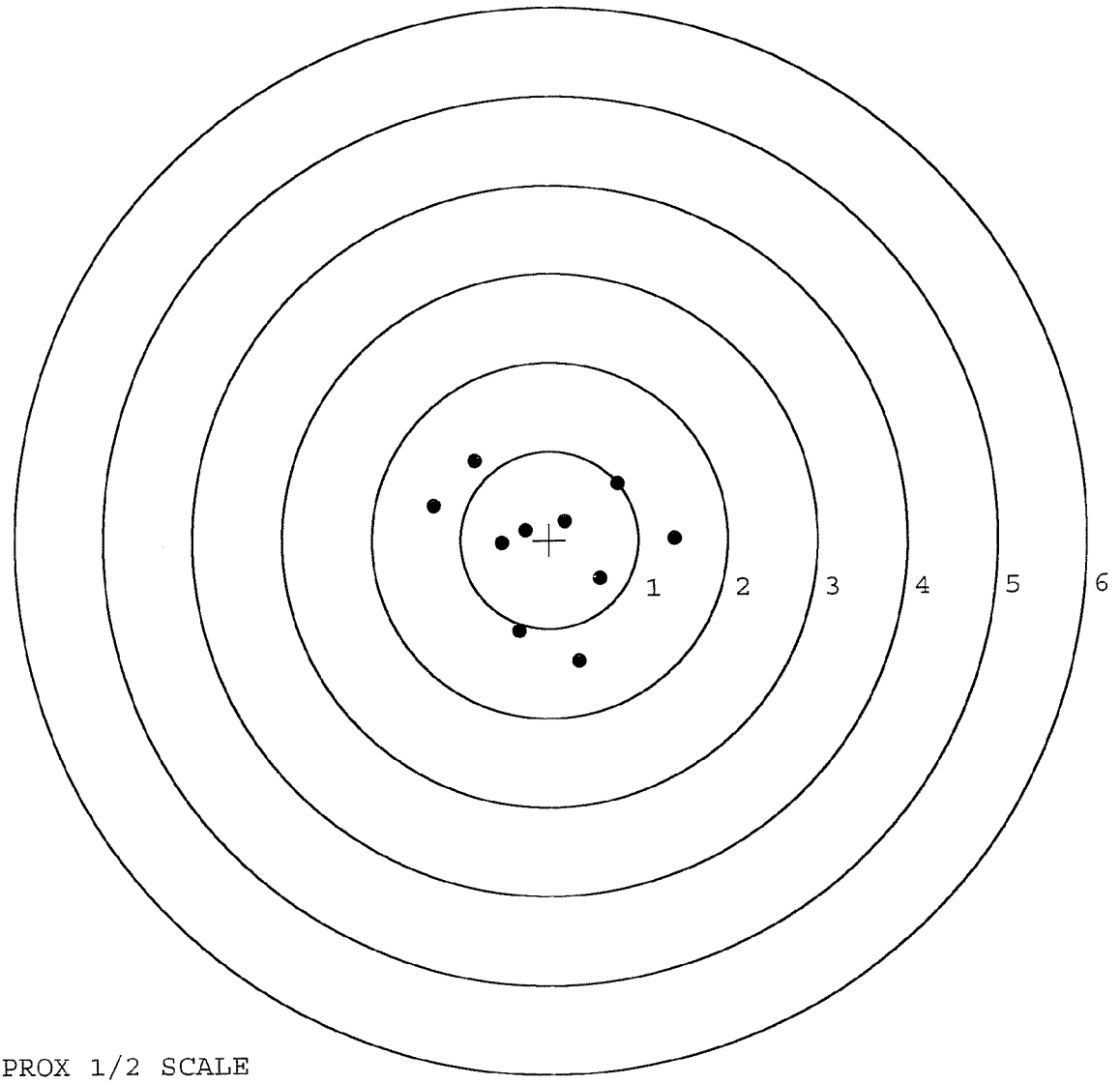


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6521189.__0
TARGET NUMBER: 2
FILE DATE: 01/11/2006
FILE TIME: 09:41

X CENTROID:	-0.005
Y CENTROID:	-0.063
POA TO CENTROID:	0.063
HORZ SPREAD:	2.704
VERT SPREAD:	2.267
GROUP SPREAD:	2.732
MIN RADIUS:	0.317
MAX RADIUS:	1.407
MEAN RADIUS:	0.934
# IN 1 IN DIAMETER:	2
# IN 2 IN DIAMETER:	4
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	0.327	-1.371
2:	-0.346	-1.029
3:	0.571	-0.441
4:	1.400	0.005
5:	0.771	0.629
6:	0.174	0.213
7:	-0.273	0.107
8:	-0.535	-0.036
9:	-0.840	0.896
10:	-1.304	0.396

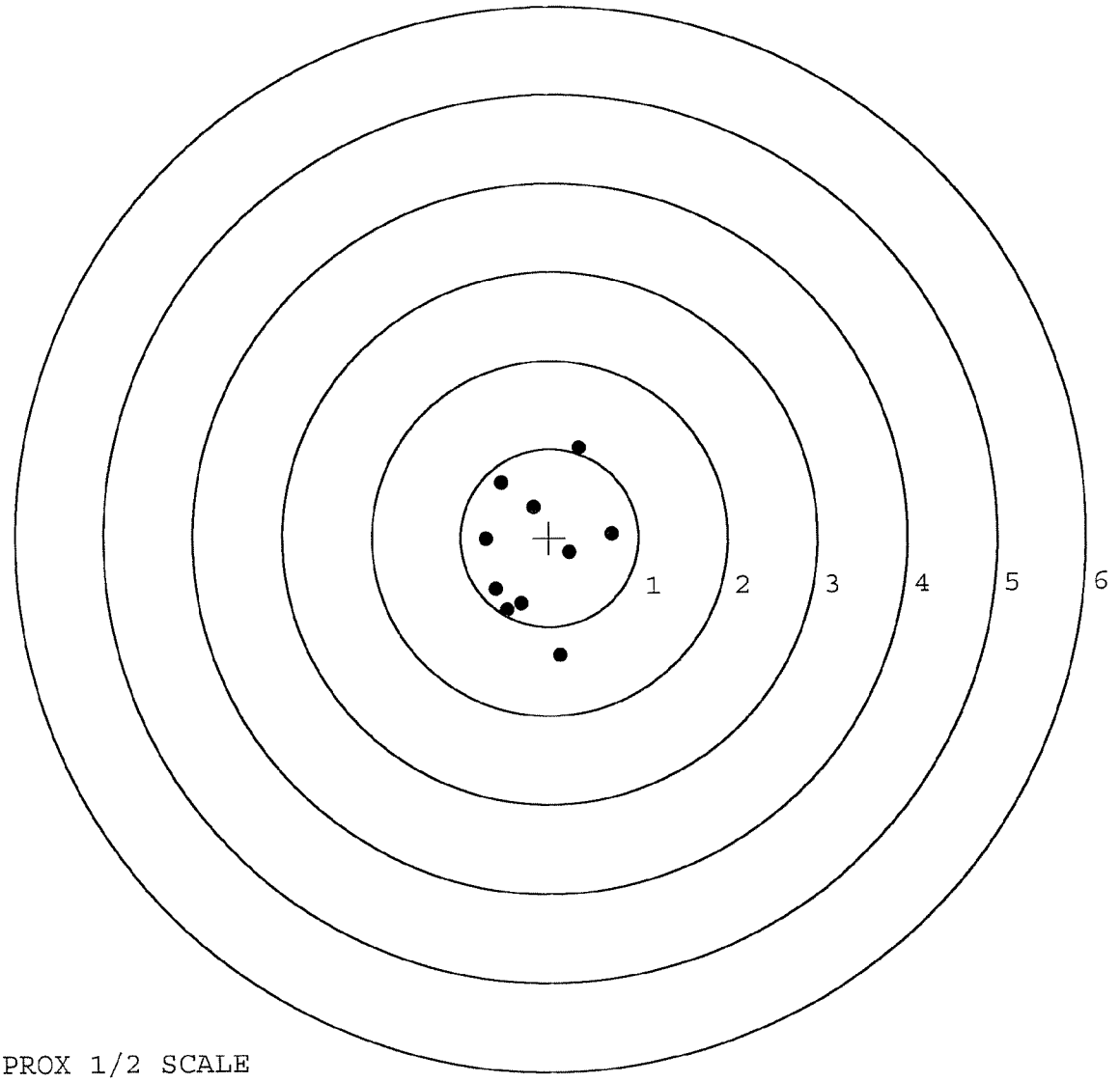


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6521189.__0
TARGET NUMBER: 3
FILE DATE: 01/11/2006
FILE TIME: 09:41

X CENTROID:	-0.144
Y CENTROID:	-0.163
POA TO CENTROID:	0.218
HORZ SPREAD:	1.418
VERT SPREAD:	2.340
GROUP SPREAD:	2.351
MIN RADIUS:	0.373
MAX RADIUS:	1.269
MEAN RADIUS:	0.764
# IN 1 IN DIAMETER:	1
# IN 2 IN DIAMETER:	8
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	0.118	-1.332
2:	-0.322	-0.746
3:	-0.608	-0.574
4:	-0.481	-0.807
5:	0.229	-0.172
6:	0.704	0.039
7:	0.346	1.008
8:	-0.538	0.624
9:	-0.177	0.341
10:	-0.714	-0.009

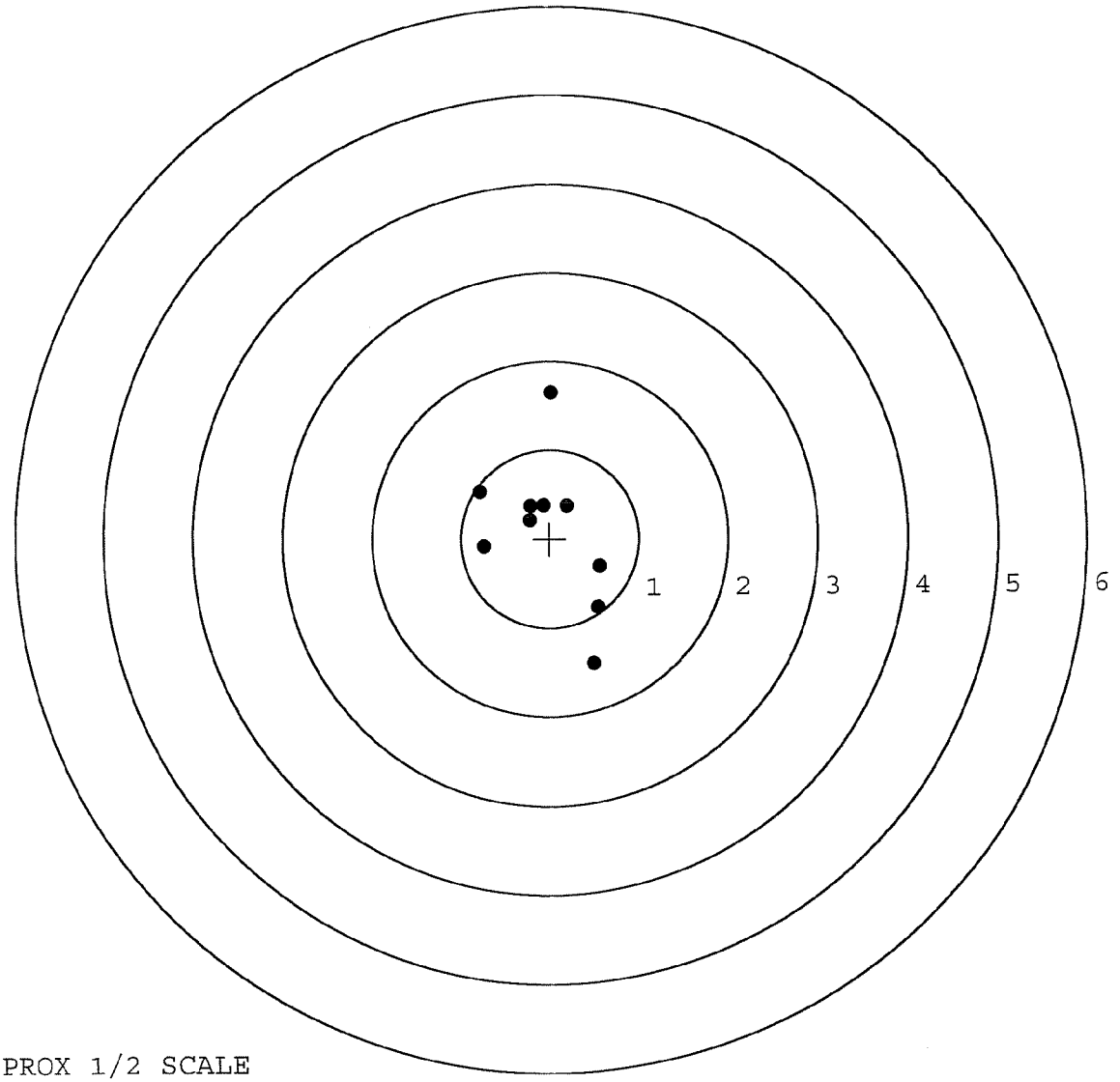


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6521189.__0
TARGET NUMBER: 4
FILE DATE: 01/11/2006
FILE TIME: 09:41

X CENTROID:	-0.022
Y CENTROID:	0.092
POA TO CENTROID:	0.094
HORZ SPREAD:	1.343
VERT SPREAD:	3.054
GROUP SPREAD:	3.089
MIN RADIUS:	0.233
MAX RADIUS:	1.585
MEAN RADIUS:	0.772
# IN 1 IN DIAMETER:	4
# IN 2 IN DIAMETER:	7
# in 3 IN DIAMETER:	8

POINT#	X	Y
1:	0.489	-1.409
2:	0.543	-0.774
3:	0.562	-0.320
4:	0.022	1.645
5:	-0.781	0.537
6:	-0.742	-0.083
7:	-0.224	0.207
8:	-0.214	0.372
9:	-0.068	0.374
10:	0.194	0.368

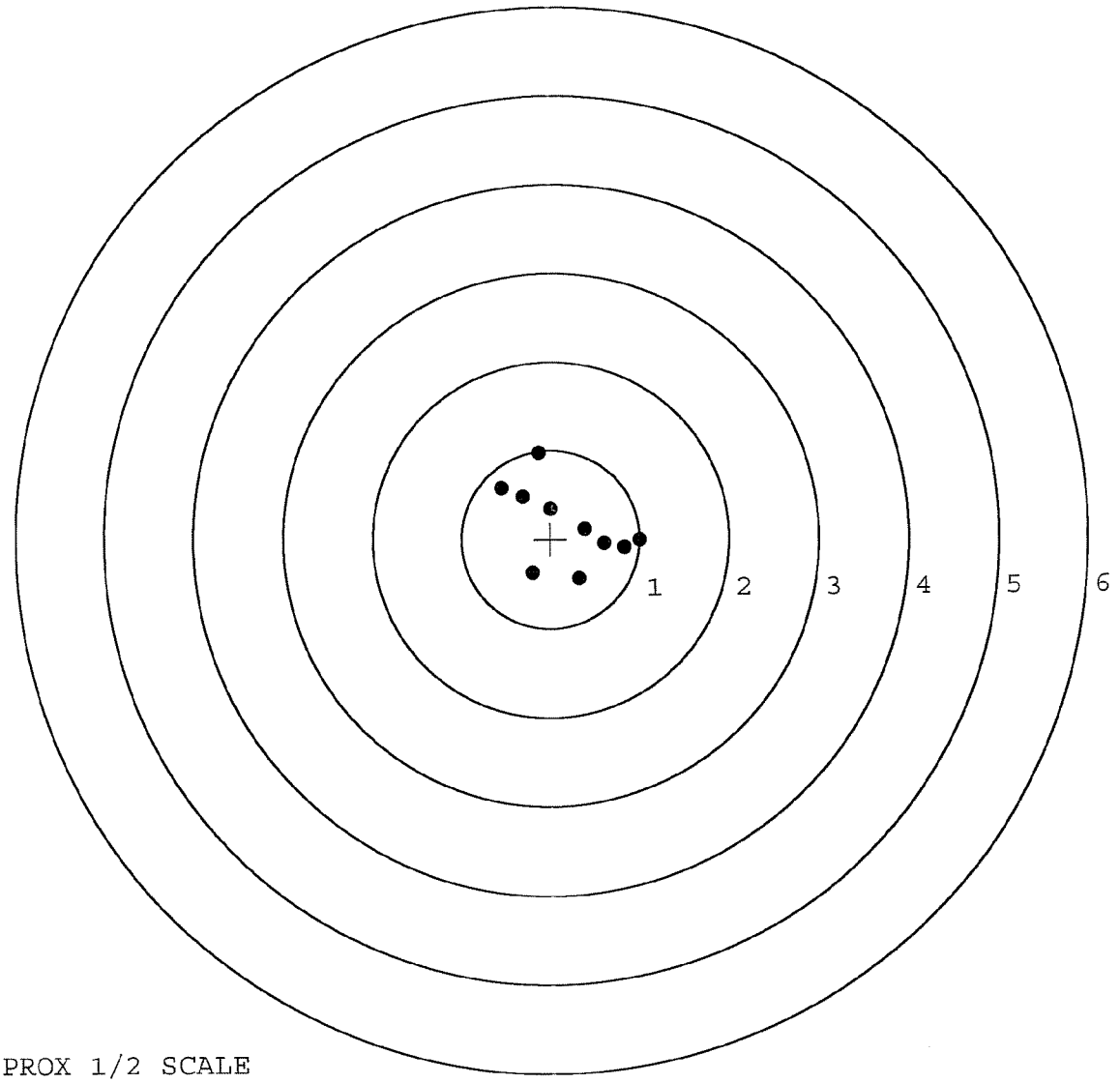


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6521189.__0
TARGET NUMBER: 5
FILE DATE: 01/11/2006
FILE TIME: 09:41

X CENTROID:	0.194
Y CENTROID:	0.145
POA TO CENTROID:	0.242
HORZ SPREAD:	1.552
VERT SPREAD:	1.424
GROUP SPREAD:	1.510
MIN RADIUS:	0.196
MAX RADIUS:	0.889
MEAN RADIUS:	0.606
# IN 1 IN DIAMETER:	3
# IN 2 IN DIAMETER:	10
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	1.000	-0.026
2:	0.829	-0.104
3:	0.606	-0.058
4:	0.387	0.109
5:	-0.003	0.339
6:	-0.310	0.476
7:	-0.552	0.575
8:	-0.133	0.972
9:	-0.204	-0.382
10:	0.322	-0.452



TARGET APPROX 1/2 SCALE

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

R & E NUMBER	105570			
SERIAL NUMBER	~~C022525~~	G0521189 (New)		
LOG-IN DATE	12-29-05			

OPERATION #	OPERATION NAME		DATE	INITIAL
500	DIS-ASSEMBLE GUN		12-29-05	RTL
505	RE-BARREL		1-4-06	RTL
560	ASSEMBLE		1-4-06	RTL
600	PROOF	MAGNA-FLUX INSPECTED JAN 06 2006	1-4-06	AC
605	CHECK HEADSPACE		1-4-06	AC
610	DIS-ASSEMBLE GUN		1-4-06	AC
612	MAGNAFLUX	OPERATOR [illegible]	1/6/06	[illegible]
510	DRILL AND TAP		1-5-06	TRW
615	ROLLMARK CALIBER		1-6-06	CW
618	ROTO-BLAST		1-6-06	LB
620	APPLY COATINGS		1/10	HP
625	FINAL ASSEMBLY		1-11-06	RTL
640	FUNCTION TEST AND	PASS FAIL	1-11-06	TRW
650	TARGET	PASS FAIL	1-11-06	TRW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION N/A		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION	1-11-06	TRW
670	FINAL INSPECTION		1-11-06	AC
	A) HEADSPACE	PASS FAIL	1-11-06	AC
	B) TRIGGER PULL (+/- .5 LBS, MIN 2.50 LBS, MAX 4.0 LBS)	2.56 2.65 2.48 2.69 2.58		AC
680	F) SAFETY ON FORCE (2 LBS MIN 10 LBS)	8 lbs 8 lbs 8 lbs		AC
	G) SAFETY OFF FORCE (2 LBS MAX)	3 lbs 3 lbs 3 lbs		AC
	I) FIRING PIN INDENT (.020)	.023 .023 .023		AC
690	PACK		1-18-06	[illegible]

M-24

CONTRACT # DAAA21-87-C-0086

New Bolt

GUN SERIAL # C1622525O

OPERATION #	OPERATION NAME	DATE	INT
575-580	ASSEMBLY	2 26	PG
600	PROOF	29	RW
615	MAGNAFLUX BARREL	5/13/88	PJR
	MAGNAFLUX BOLT	5/13/88	PJR
620	COATING	10/31/88	TJA
625-630	FINAL ASSEMBLY		
635	TEST		
640	TARGET		
	FIRING PIN INDENT		
660	PACK		

Scope # 1787

M-24

CONTRACT # DAAA21-87-C-0086 New Bolt

GUN SERIAL # C6225250

OP. #	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and Stock	9 12 88		FB
600	Proof	9 19 88		RW
607	Check Headspace	9 19 88		RW
610	Dis-assemble Gun	9 19 88		RW
612	Magnaflux Barrel Action		9 22 88	pfc.
	Magnaflux Bolt		9 22 88	pfc.
615	Rollmark Caliber			
617	Drill and Tap Sight Holes			
618	Polish Barrel			
620	Apply Coatings (Barrel Action)		10-31-88	TJA
	Apply Coating (Bolt)		10-31-88	TJA
625	Final Assembly A) Clean inside of Bolt Assembly		11/4/88	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		11/4/88	RW
	C) Inspect Ejector Hole for Chamfer		11/4/88	RW
	D) Oil Firing Pin Ass'y		11/4/88	RW
	E) Adjust Trigger Pull to Min Setting and Stake		11/6/88	RW

op. #	OP. NAME	READINGS	DATE	INITIAL
625 cont.	F) Safety On Force	5 | 5 | 5	8/NOV88	GS
	G) Safety Off Force	3.5 | 3.5 | 3.5	8/NOV 88	GS
	H) Trigger Pull Test & Retainability		7/NOV88	JL
	I) Firing Pin Indent	.0205 | .0205 | .0205	8/NOV88	GS
	J) Assemble Stock		11/10/88	RW
	K) Assemble Swivel Studs		29/NOV 88	GS
	L) Attach Front and Rear Sight Assemblies		11/10/88	RW
	M) Iron Sight Alignment		11/10/88	RW
	N) Detach Front & Rear Sights & place in numbered container		11/10/88	RW
	O) Attach Scope to Rifle		11/10/88	RW
	P) Detach & Attach Scope 20 Times		11/NOV88	GS
640	Gallery Target & Test	57 R 94L		AC
	A) Time		11-11-88	
	B) Malfunctions			
	C) Pierced Primers			
	D) Optical Clearity of Scope	OK	11-11-88	AC
645	Inspect for Live Ammo	none	11-11-88	AC
655	Final Inspection A) Headspace		29/NOV 88	GS
	B) Trigger Pull	2.54 | 2.50 | 2.50 | 2.50 | 2.48	29/NOV88	GS
	C) Function		29/NOV88	GS
660	Pack		15Dec88	GS

SWS TRIGGER PULL TEST

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

SERIAL NO. C 6225250

DATE 11-7-88

TESTER J.H.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.53	2.36	2.48	2.54	MIN. SETTING,
PULL #2	2.31	2.33	2.48	2.50	NO AVG. OF 5
PULL #3	2.32	2.35	2.48	2.50	READINGS ACCEPT-
PULL #4	2.37	2.37	2.46	2.50	ABLE LESS THAN 2#
PULL #5	2.28	2.40	2.48	2.48	
TOTAL	11.81	11.80	12.38	12.52	
AVG.	2.362	2.36	2.476	2.504	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.34	3.32		
PULL #2	3.36	3.30		
PULL #3	3.40	3.39		
PULL #4	3.39	3.40		
PULL #5	3.39	3.39		
TOTAL	16.88	16.74		
AVG.	3.375	3.348		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.19	4.26		4.24
PULL #2	4.23	4.30		4.30
PULL #3	4.22	4.30		4.32
PULL #4	4.26	4.33		4.19
PULL #5	4.24	4.37		4.25
TOTAL	21.14	21.55		21.30
AVG.	4.228	4.312		4.250

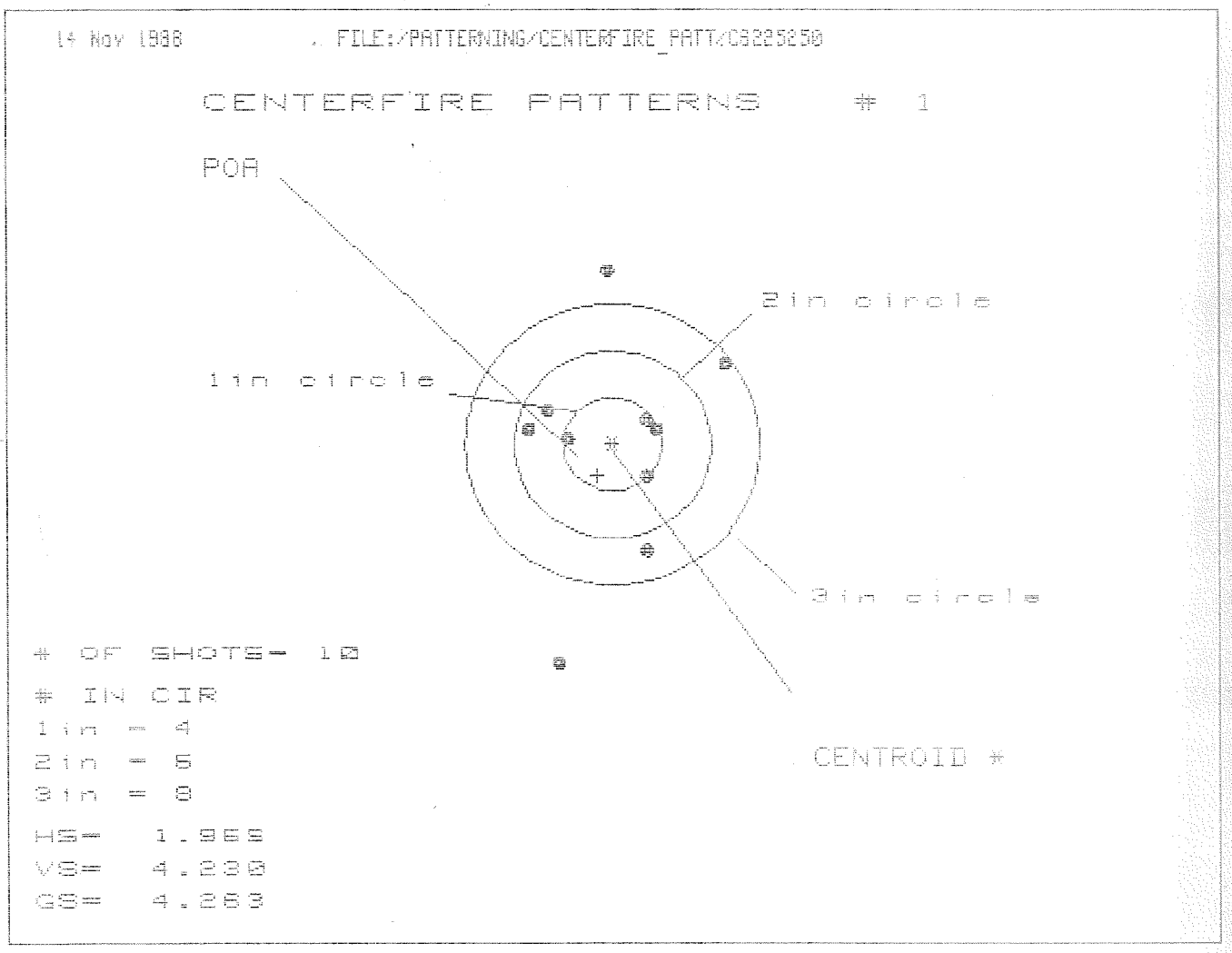
CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6225250

CENTROIDAL DISTANCES

0	TO	1	.365978
1	TO	2	.81963
1	TO	3	.671658
1	TO	4	.586085
1	TO	5	.416163

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .3582
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0364
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .360045

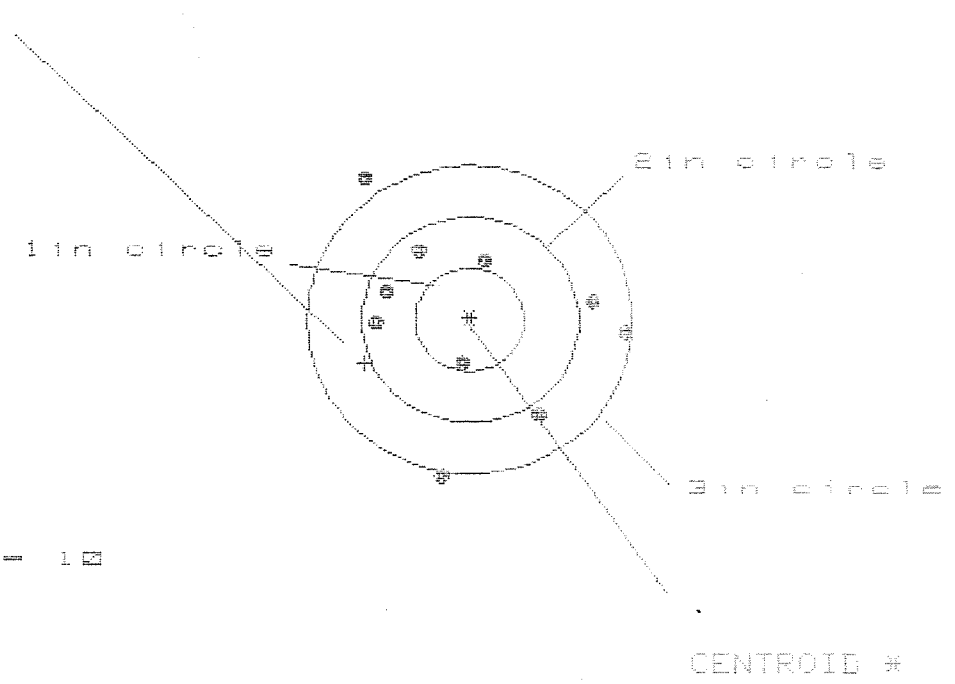
THE AMR FOR THIS RIFLE IS: .983



PATTERN #	:	[redacted]		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.111	1.045	1.029
MINIMUM X	:	-.859	-.924	-.940
MAXIMUM Y	:	1.867	1.604	.781
MINIMUM Y	:	-2.363	-1.375	-1.175
CENTROID X	:	.154	.219	.235
CENTROID Y	:	.332	.595	.394
POA TO CENTROID in.	:	.366	.634	.459
MIN RADIUS	:	.426	.297	.324
MEAN RADIUS	:	1.031	.854	.739
MAX RADIUS	:	2.437	1.689	1.292
HORIZONTAL SPREAD	:	1.969	1.969	1.969
VERTICAL SPREAD	:	4.230	2.979	1.956
EXTREME SPREAD	:	4.263	3.008	2.096
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

14 Nov 1988 FILE:/PATTERNING/CENTERFIRE_PATT/C0225250

CENTERFIRE PATTERNS # 2

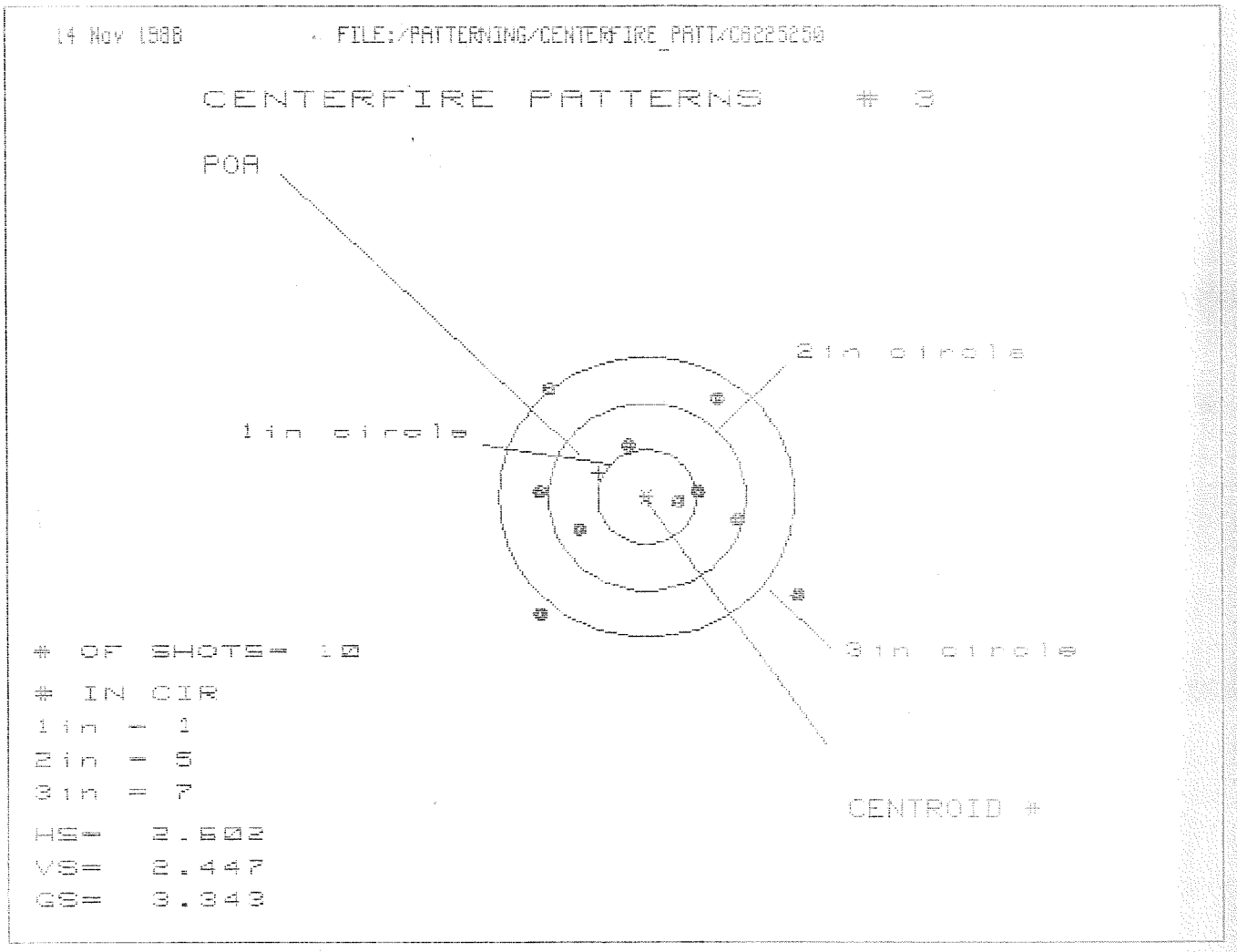


OF SHOTS= 10

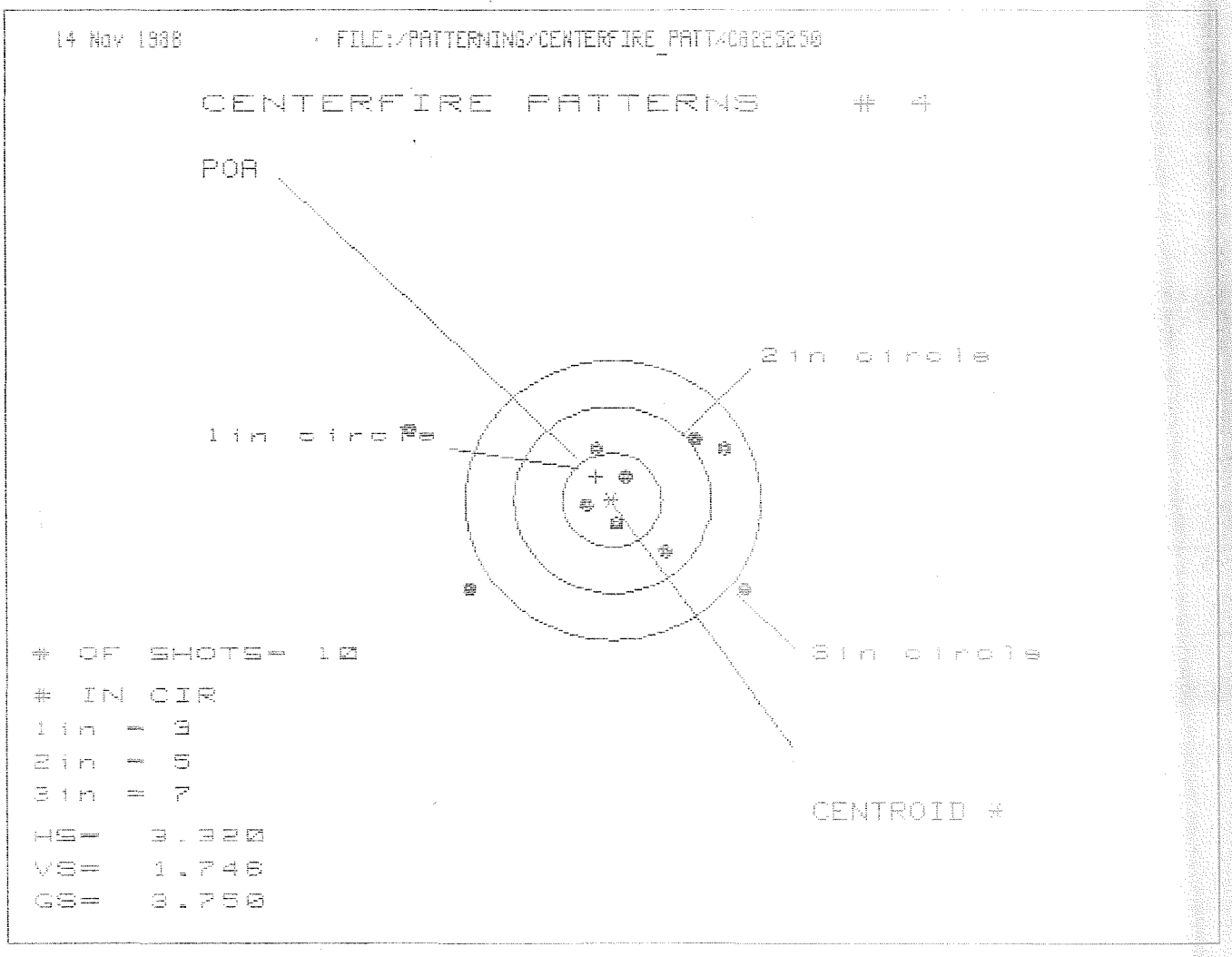
# IN CIR
1in = 1
2in = 5
3in = 8

HS= 2.340
VS= 2.943
GS= 3.025

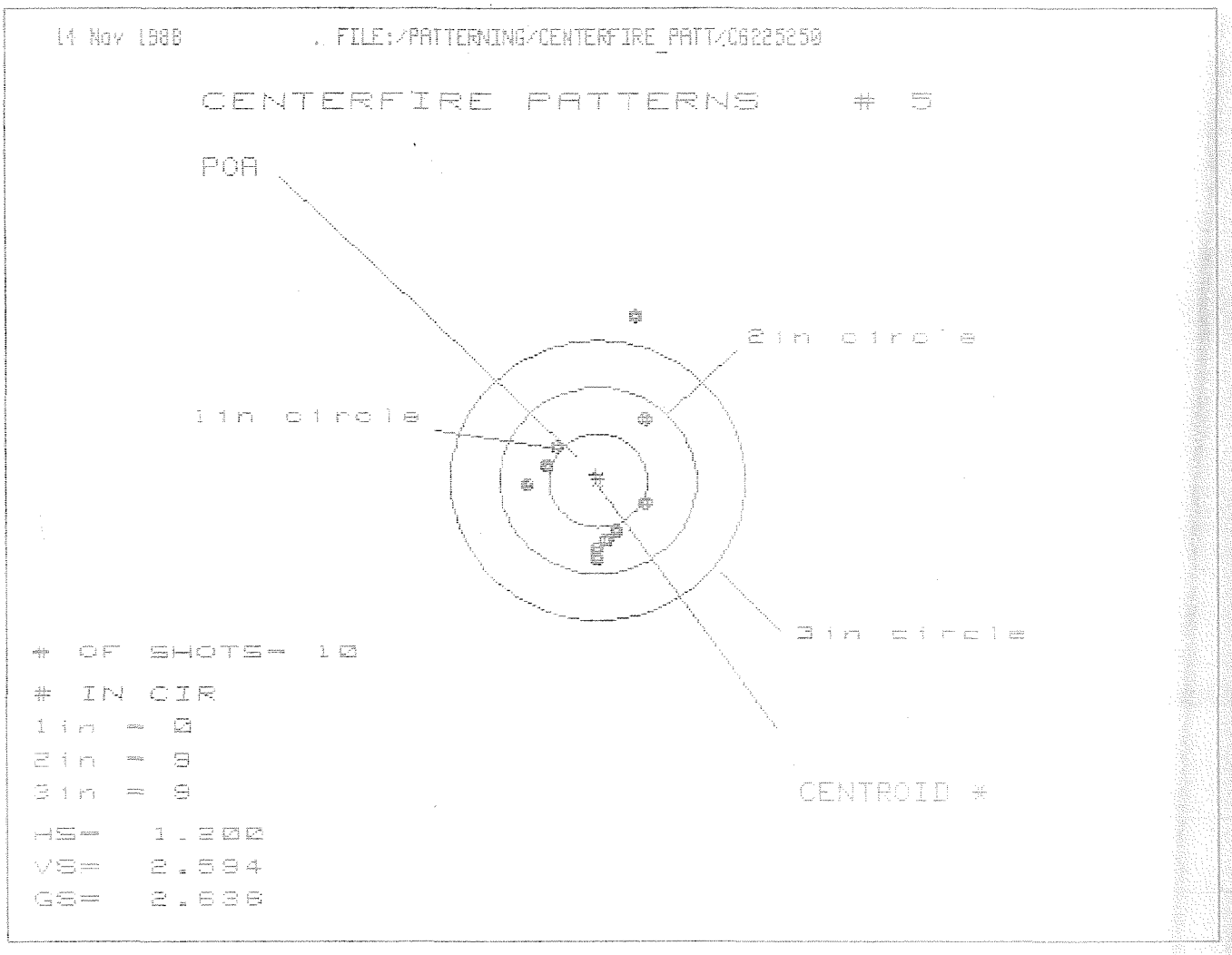
PATTERN #	:	#2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.420	1.318	1.277
MINIMUM X	:	-.920	-1.007	-1.048
MAXIMUM Y	:	1.410	.819	.647
MINIMUM Y	:	-1.533	-1.376	-.964
CENTROID X	:	.969	1.071	1.112
CENTROID Y	:	.419	.262	.434
POA TO CENTROID in.	:	1.056	1.103	1.193
MIN RADIUS	:	.422	.293	.467
MEAN RADIUS	:	1.039	.963	.898
MAX RADIUS	:	1.684	1.413	1.289
HORIZONTAL SPREAD	:	2.340	2.325	2.325
VERTICAL SPREAD	:	2.943	2.195	1.611
EXTREME SPREAD	:	3.025	2.329	2.329
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	



PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.479	1.106	.987
MINIMUM X	:	-1.123	-.959	-1.047
MAXIMUM Y	:	1.200	1.079	.908
MINIMUM Y	:	-1.247	-1.368	-.654
CENTROID X	:	.484	.320	.439
CENTROID Y	:	-.253	-.132	.609
POA TO CENTROID in.	:	.546	.346	.441
MIN RADIUS	:	.334	.441	.290
MEAN RADIUS	:	1.064	.973	.858
MAX RADIUS	:	1.839	1.670	1.285
HORIZONTAL SPREAD	:	2.602	2.065	2.034
VERTICAL SPREAD	:	2.447	2.447	1.562
EXTREME SPREAD	:	3.343	2.913	2.363
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		7	



PATTERN #	:	[redacted]		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.296	1.072	.861
MINIMUM X	:	-2.024	-1.687	-.708
MAXIMUM Y	:	.753	.709	.596
MINIMUM Y	:	-.993	-.910	-1.020
CENTROID X	:	.164	.388	.599
CENTROID Y	:	-.254	-.337	-.224
POA TO CENTROID in.	:	.302	.515	.640
MIN RADIUS	:	.224	.248	.375
MEAN RADIUS	:	1.002	.866	.736
MAX RADIUS	:	2.159	1.917	1.335
HORIZONTAL SPREAD	:	3.320	2.759	1.569
VERTICAL SPREAD	:	1.746	1.619	1.616
EXTREME SPREAD	:	3.750	3.008	2.151
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		7	



PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.526	.573	.629
MINIMUM X	:	-.674	-.627	-.556
MAXIMUM Y	:	1.801	.847	.691
MINIMUM Y	:	-.793	-.593	-.487
CENTROID X	:	.020	-.027	-.098
CENTROID Y	:	-.062	-.262	-.368
POA TO CENTROID in.	:	.065	.263	.381
MIN RADIUS	:	.509	.345	.319
MEAN RADIUS	:	.779	.613	.541
MAX RADIUS	:	1.849	1.022	.771
HORIZONTAL SPREAD	:	1.200	1.200	1.185
VERTICAL SPREAD	:	2.594	1.440	1.178
EXTREME SPREAD	:	2.636	1.552	1.264
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		9	
NUMBER IN THREE INCH CIRCLE	=		9	

RECEIVING AND ESTIMATING REPORT

COMMENTS: M-24 ATTN: FRED MARTIN/PAINTED OUTSIDE SHOP

ORDER: R 94-22614

INITIAL	CUSTOMER ORDER NO.
FPS	

DATE RECEIVED	DATE OPENED	DATE CODE	SERIAL NUMBER	NEW SERIAL NUMBER	MODEL AND GRADE
08/01/94	08/02/94	KI 5-88	C6225250		700 7.62 NATO

ACCESSORIES: W/STUDS SCOPE MNTS SCOPE BASE

FROM:

DEPT OF THE ARMY
B CO ARMS
2/75 RANGER BATTALION
FT LEWIS WA 98433

SHIP TO:

DEPT OF THE ARMY
B CO ARMS
2/75 RANGER BATTALION
FT LEWIS WA
98433

CUST NO:062072 C.O.D

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

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: New Barrel

PARTS: Barrel - 96003

COMMENTS: Repainted Coat Trigger Guard Assy Front & Rear Sight Bases Rezink Scope Base, Rings & Swivel Studs

W52 H09 4321 #227

REPAIRMAN	PROOF	CLEAN	TEST	TARGET	PATTERN
RW	✓	✓	✓	✓	
GALLERY TESTER	**DATE**	**DATE**	**DATE**	**DATE**	**DATE**
RW	8/3/94	8/13/94	8/15/94	8/15/94	

OFFICE COPY

RB6925 REV. 1/94

PACKING LIST	PACKED BY Mr. Ray Fuller WG-10 Bn. Armorer.	1. NO. BOXES 1	2a. REQUISITION NO. 92070 2b. ORDER NO.

3. END ITEM: 7.62 mm M24 Sniper Weapons System (SWS)

4. DATE: 26 July 1994

5. PAGE 1 OF 1 PAGES

BOX NO. (a)	CONTENTS - STOCK NUMBER AND NOMENCLATURE (b)	UNIT OF ISSUE (c)	QUANTITIES REQUIRED: INITIAL OPERATION (d)	QUANTITIES REQUIRED: RUNNING SPARES (e)	QUANTITIES REQUIRED: TOTAL (f)
1	7.62 mm M24 Sniper Weapon System (SWS) Serial No. C622 5250 NSN: 1005-01-240-2136 [redacted]	Ea			1

Note: All Optic Scope Ring mounts Packed

6. THIS CERTIFIES THAT ITEMS LISTED HEREON ARE WITHIN THE SPECIFIED BOXES

TYPED NAME AND TITLE	SIGNATURE
Ray Fuller WG-10 Bn Armorer	Ray Fuller

DD FORM 1 SEP 70 1750

TYPEWRITER OR PRINT FIRMLY ON HARD SURFACE WITH HARD PENCIL OR BALLPOINT PEN

MAINTENANCE REQUEST

For use of this form, see DA PAM 738-750; the proponent agency is DCSLOG.

PAGE NO. 1 | NO. OF PAGES | REQUIREMENT CONTROL SYMBOL CSGLD-1047(R1)

SECTION I – EQUIPMENT DATA

CONTROL NUMBER	WORK ORDER NUMBER	WESDC	ORG PD	PD AUTHENTICATION
	92070		02	Adam L Rooke, 1LT, IN

[X] WORK REQUEST [ ] MWO [ ] WARRANTY CLAIM	1a. ORGANIZATION	b. LOCATION	c. UNIT IDENT CODE
	BN ARMS HHC 2nd BN 75th Ranger	Ft. Lewis WA	WH3MAA

2. SERIAL NO.	3. NOUN NOMENCLATURE	4. LINE NO.	5. MODEL	6. NATIONAL STOCK NUMBER
C6225250	M24 SWS		M24	1005-01-240-2136

7. MAINTENANCE ACTIVITY	a. LEVEL	8. UTILIZATION CODE	9. MCSR ITEM	a. ERC	b. PACING ITEM	10. HOURS	11. MILES	12. ROUNDS	13. STARTS
Remington Arms Co Custom Shop									

14. FAILURE DETECTED DURING (Select one - use ✓ or X)
[ ] A Scheduled Maintenance [X] 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 [X] Other

16. DESCRIBE DEFICIENCIES OR SYMPTOMS ON THE BASIS OF COMPLETE CHECKOUT AND DIAGNOSTIC PROCEDURE IN EQUIPMENT TM (Do not prescribe repairs)
This weapon has fired over 10,000 Rds. During Bench Rest Test fire at 200 + 300 yds, groups were shot far exceeding the criteria of 2.6" at 200 and 3.8" at 300 yds. (5-10 shot group) This criteria was provided us by Mr. Jim Glenn ARDEC DSN-880-7071.

16a. REMARKS
Request ReBarreling and complete weapon Reconditioning.

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 ACCOUNT CODE
b. LOCATION		[ ] 1 TOE [ ] 2 TD [ ] 3 CONTRACTOR	

20a. ACT CODE	FAILURE CODE b	c. COMPONENT/PART NOUN, SVC, OR MWO NO.	d. CB CODE	e. REF DESIGNATOR	f. MFR CODE	MANHOURS (Hrs & tenths) g	NATIONAL STOCK NUMBER h	PART SOURCE CODE i	QTY j	PARTS COST k

	l. TOTAL MANHOURS	m. TOTAL MANHOURS COST	n. 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)
Ray Fuller					[ ] A To User [ ] C Salvaged [ ] B To Stock [ ] D Evacuated [ ] E Cannibalization
JULIAN DATE 4207	JULIAN DATE	JULIAN DATE	JULIAN DATE	JULIAN DATE	

DA FORM MAY 81 2407 EDITION OF JUL 79 IS OBSOLETE. NMP COPY 2

SWS/Repair

Final Inspection

in: C6225250	DATE REC'D: 8/1/94	DATE RET'D:

AUDITOR: RW

Item:

Barrel Assy.
- ✓ Barrel
- ✓ Receiver
- ✓ Front Sight Block
- ✓ Rear Sight Block
- ✓ Screws
- ✓ Finish

Item:

Stock Assy.
- ✓ Stock
- ✓ Sling Swivel Studs
- ✓ Adjustable Butt Plate
- ✓ Lock Nuts
- ✓ Barrel Clearance
- ✓ Color/Finish

Scope Assy.
- ___ Scope
- ✓ Scope Rings
- ✓ Mounting Screws
- ✓ Mounting Base
- ✓ Screws
- ___ Finish
- ___ Looseness
- ___ Clarity

Systems Case
- ___ Scope Case
- ___ Iron Sights
- ___ Deployment Kit

Trigger
- ✓ Safety Operation
- ✓ Set
- ___

Comments: _____

Misc.
- ___ DD-250
- ___ Bar Code
- ___ Packaging

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6225250
10 Aug 1994

CENTROIDAL DISTANCES

0	TO	1	.503557
1	TO	2	.427834
1	TO	3	.574474
1	TO	4	.682739
1	TO	5	.451136

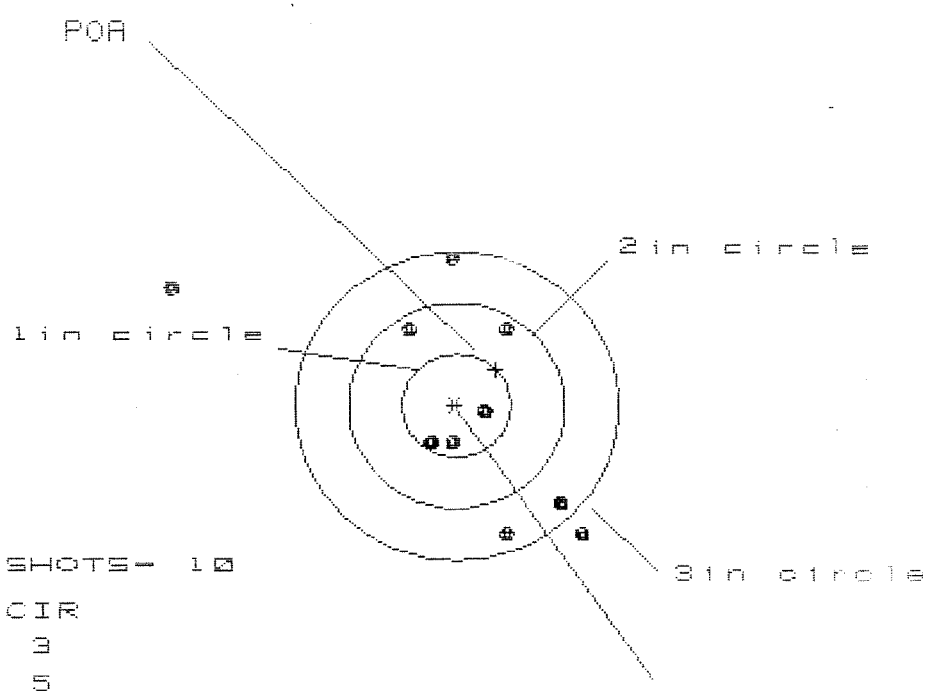
<----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0816
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0716
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .108559

THE AMR FOR THIS RIFLE IS: 1.023

18 Aug 1994 FILE:/PATTERNING/CENTERFIRE_PATT/CG225250

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

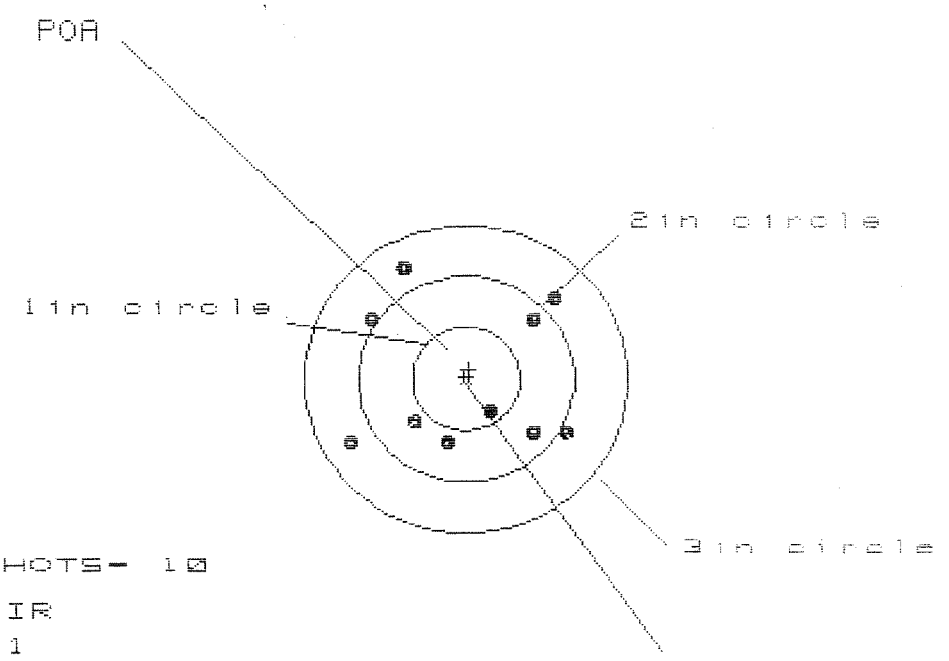
# IN CIR
1in = 3
2in = 5
3in = 8

HS= 3.792
VS= 2.733
GS= 4.517

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.141	.846	.821
MINIMUM X	:	-2.651	-.699	-.593
MAXIMUM Y	:	1.472	1.604	1.463
MINIMUM Y	:	-1.261	-1.129	-1.233
CENTROID X	:	-.363	-.068	-.174
CENTROID Y	:	-.349	-.481	-.340
POA TO CENTROID in.	:	.503	.486	.382
MIN RADIUS	:	.279	.066	.114
MEAN RADIUS	:	1.156	.921	.854
MAX RADIUS	:	2.907	1.635	1.478
HORIZONTAL SPREAD	:	3.792	1.545	1.414
VERTICAL SPREAD	:	2.733	2.733	2.696
EXTREME SPREAD	:	4.517	2.970	2.741
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

18 Aug 1994 . FILE:/PATTERNING/CENTERFIRE_PATT/CS225250

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

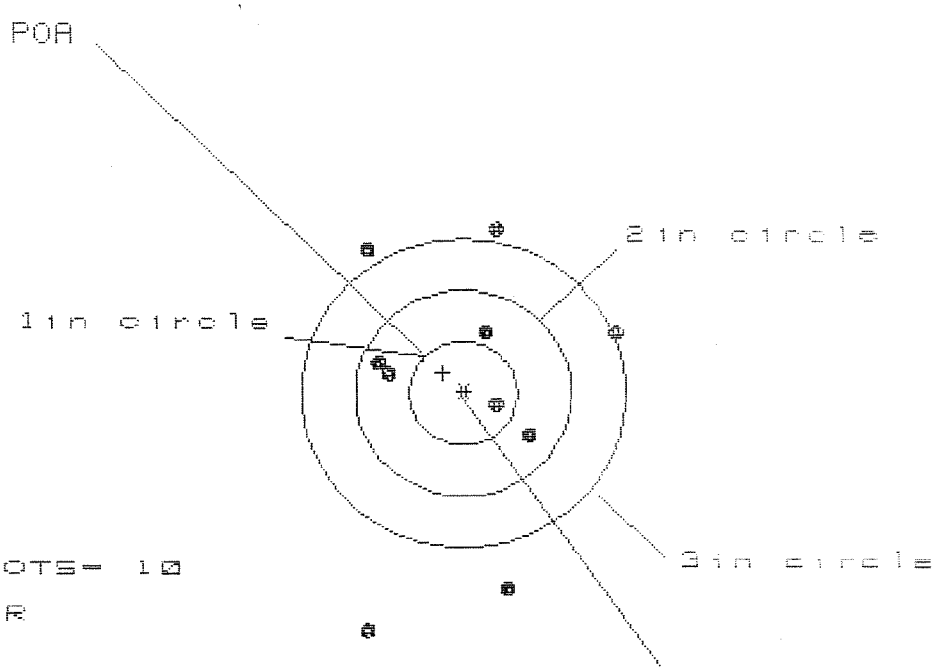
# IN CIR
1in = 1
2in = 5
3in = 10

HS= 2.041
VS= 1.711
GS= 2.436

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.955	.834	.742
MINIMUM X	:	-1.086	-.999	-1.091
MAXIMUM Y	:	1.077	1.006	.873
MINIMUM Y	:	-.634	-.684	-.558
CENTROID X	:	-.024	.097	.189
CENTROID Y	:	-.088	-.017	-.143
POA TO CENTROID in.	:	.091	.098	.237
MIN RADIUS	:	.423	.439	.299
MEAN RADIUS	:	.917	.877	.797
MAX RADIUS	:	1.258	1.249	1.248
HORIZONTAL SPREAD	:	2.041	1.833	1.833
VERTICAL SPREAD	:	1.711	1.690	1.431
EXTREME SPREAD	:	2.436	2.272	2.144
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		10	

18 Aug 1994 FILE:/PATTERNING/CENTERFIRE_PATT/CB225250

CENTERFIRE PATTERNS # 3

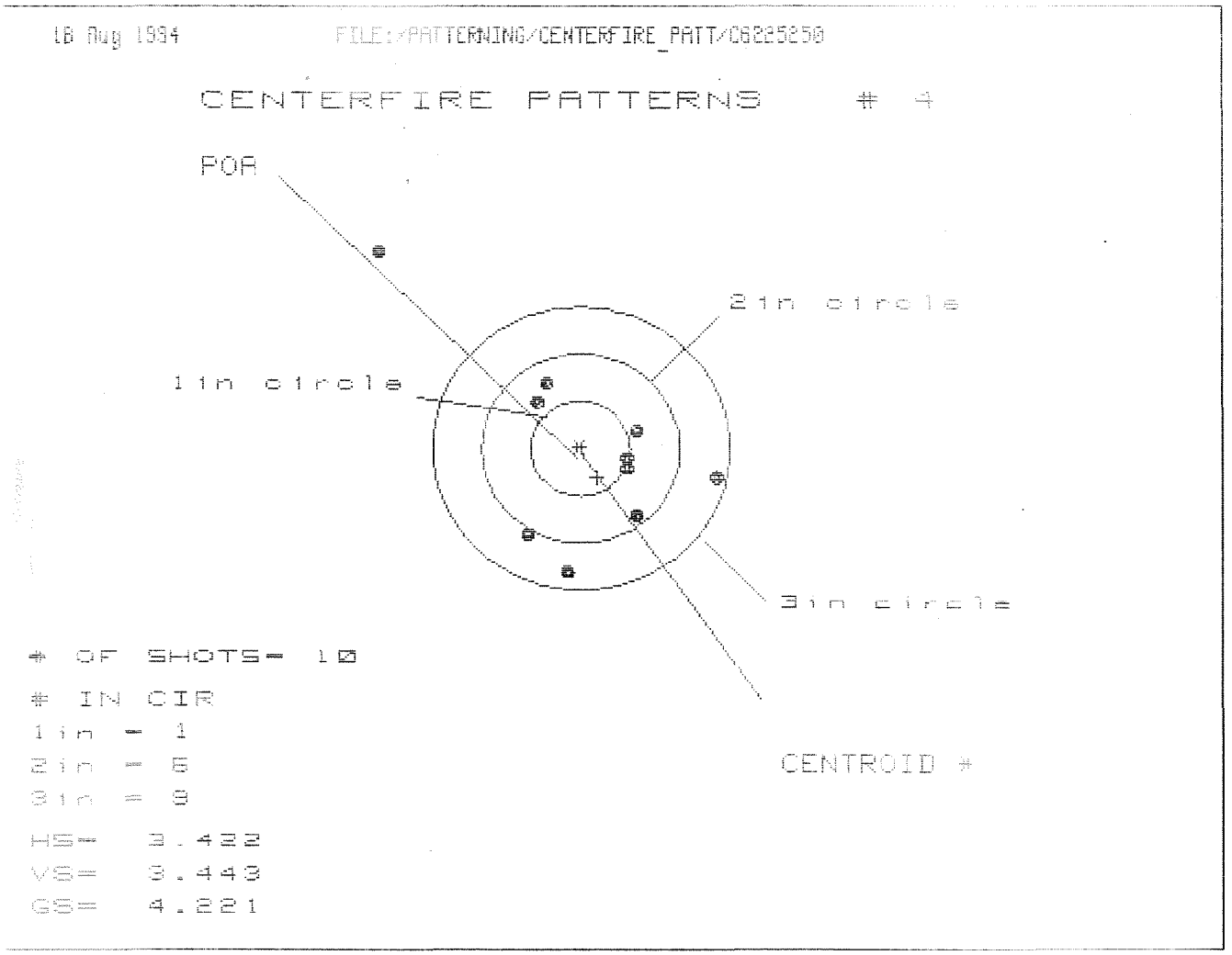


OF SHOTS= 10

# IN CIR
1in = 1
2in = 5
3in = 5

HS= 2.249
VS= 3.874
GS= 4.063

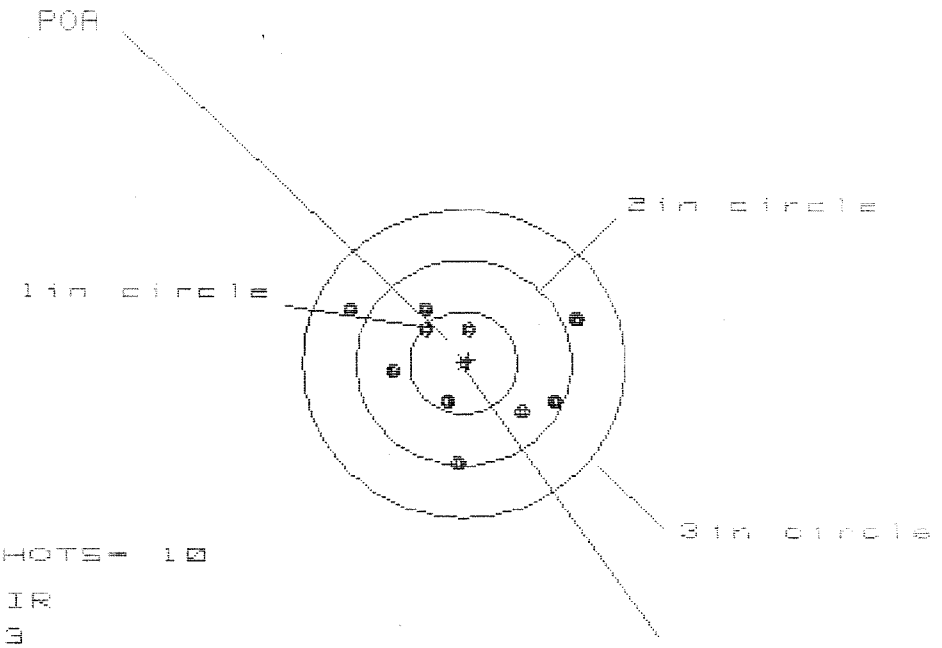
PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.383	1.286	1.321
MINIMUM X	:	-.866	-.941	-.907
MAXIMUM Y	:	1.619	1.368	1.093
MINIMUM Y	:	-2.255	-2.202	-.918
CENTROID X	:	.191	.288	.254
CENTROID Y	:	-.197	.054	.329
POA TO CENTROID in.	:	.274	.293	.416
MIN RADIUS	:	.321	.362	.159
MEAN RADIUS	:	1.242	1.075	.911
MAX RADIUS	:	2.416	2.219	1.325
HORIZONTAL SPREAD	:	2.249	2.227	2.227
VERTICAL SPREAD	:	3.874	3.570	2.011
EXTREME SPREAD	:	4.063	3.570	2.341
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		5	



PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.416	1.193	.524
MINIMUM X	:	-2.006	-.758	-.609
MAXIMUM Y	:	2.131	.910	.896
MINIMUM Y	:	-1.312	-1.075	-1.088
CENTROID X	:	-.167	.056	-.093
CENTROID Y	:	.305	.068	.062
POA TO CENTROID in.	:	.348	.088	.124
MIN RADIUS	:	.455	.205	.349
MEAN RADIUS	:	1.068	.789	.759
MAX RADIUS	:	2.926	1.198	1.107
HORIZONTAL SPREAD	:	3.422	1.951	1.133
VERTICAL SPREAD	:	3.443	1.985	1.985
EXTREME SPREAD	:	4.221	2.052	1.999
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

18 Aug 1994 FILE:/PATTERNING/CENTERFIRE_PATT/C8225250

CENTERFIRE PATTERNS # 5



OF SHOTS= 10

# IN CIR
1in = 3
2in = 8
3in = 10

HS= 2.107
VS= 1.517
GS= 2.111

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.091	.917	.805
MINIMUM X	:	-1.016	-.894	-.596
MAXIMUM Y	:	.569	.617	.694
MINIMUM Y	:	-.948	-.900	-.823
CENTROID X	:	-.045	-.167	-.055
CENTROID Y	:	-.029	-.077	-.154
POA TO CENTROID in.	:	.054	.184	.163
MIN RADIUS	:	.343	.274	.225
MEAN RADIUS	:	.734	.671	.619
MAX RADIUS	:	1.175	1.084	.850
HORIZONTAL SPREAD	:	2.107	1.811	1.401
VERTICAL SPREAD	:	1.517	1.517	1.517
EXTREME SPREAD	:	2.111	2.051	1.541
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	

CONTRACT # DAAA21-87-C-0086 New Barrel

GUN SERIAL # C6225250

OP. #	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and Stock		8/3/94	RW
600	Proof		8/5/94	RW
607	Check Headspace		8/3/94	RW
610	Dis-assemble Gun		8/3/94	RW
612	Magnaflux Barrel Action			
	Magnaflux Bolt			
615	Rollmark Caliber			
617	Drill and Tap Sight Holes			
618	Polish Barrel			
620	Apply Coatings (Barrel Action)			
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/13/94	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/13/94	RW
	C) Inspect Ejector Hole for Chamfer		8/13/94	RW
	D) Oil Firing Pin Ass'y		8/13/94	RW
	E) Adjust Trigger Pull to Min Setting and Stake			RW

op. #	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		8/16/94	Rw
	A) Time			
	B) Malfunctions			
	C) Pierced Primers			
	D) Optical Clearity of Scope			
645	Inspect for Live Ammo		8/16/94	Rw
655	Final Inspection A) Headspace		8/16/94	Rw
	B) Trigger Pull	2.46 | 2.33 | 2.32 | 2.37 | 2.43	8/16/94	Rw
	C) Function		8/16/94	Rw
660	Pack			