

G-659 0091
Frophaceo
C.652 2248

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: RE00144838

Serial: G6590091 Model M24 SWS Center Fire
Caliber: 7.62 NATO

Repairman:

Verify Repair

Status:

Closed 4/24/2008 10:56:26 AM

Address Information

Customer:

☒ Received From

Return To:

☐ Received From

Name: B/210TH BSB

B/210TH BSB

Address 1: 2 BCT

2 BCT

Address 2: 10 TH MTN DIV

PO Box:

10 TH MTN DIV

PO Box:

City: FORT DRUM

FORT DRUM

State: NY

Zip Code: 13602

Country: US

State: NY

Zip Code: 13602

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
A008	With Swivel	2
A010	Hard Case	1
A026	Scope	1
A057	Frt and Rear Sgt Base	1

nagletj

4/24/2008

12:26 PM

CAPS

NUM

H start

4 Micros...

The Asso...

2 Micros...

SAP Logo...

Arms Ser...

Serial Number: G6590091

Model: M24 SWS



RE00144838

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6590091.__1
FILE DATE AND TIME: 05/23/2008 05:41

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.018
The Average Y Centroid of the Five Target Set:	0.100
The Average Point of Impact of the Five Target Set:	0.102
The Average Mean Radius of the Five Target Set:	0.664
The Distance from POA to Centroid Target #1:	0.219
The Distance from Centroid Target #2 to Centroid Target #1:	0.174
The Distance from Centroid Target #3 to Centroid Target #1:	0.112
The Distance from Centroid Target #4 to Centroid Target #1:	0.212
The Distance from Centroid Target #5 to Centroid Target #1:	0.190

SERIAL NUMBER: G6590091.___1

TARGET NUMBER: 1

FILE DATE: 05/23/2008

FILE TIME: 05:41

X CENTROID: -0.061

Y CENTROID: 0.210

POA TO CENTROID: 0.219

HORZ SPREAD: 1.541

VERT SPREAD: 2.151

GROUP SPREAD: 2.240

MIN RADIUS: 0.261

MAX RADIUS: 1.489

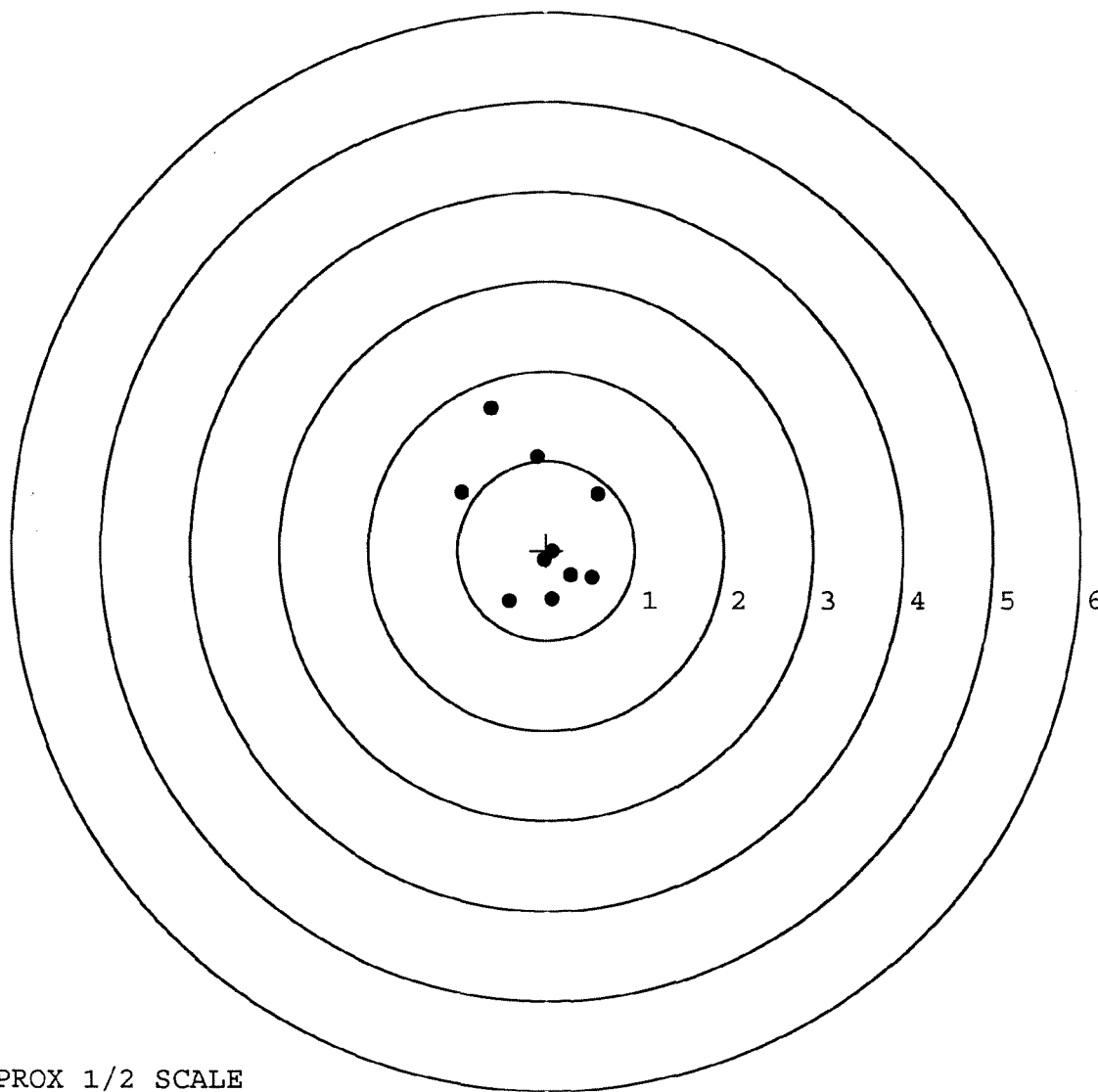
MEAN RADIUS: 0.765

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.583	0.631
2:	-0.104	1.045
3:	-0.958	0.644
4:	-0.625	1.588
5:	0.518	-0.303
6:	0.279	-0.274
7:	0.072	-0.014
8:	-0.021	-0.108
9:	0.064	-0.543
10:	-0.422	-0.563

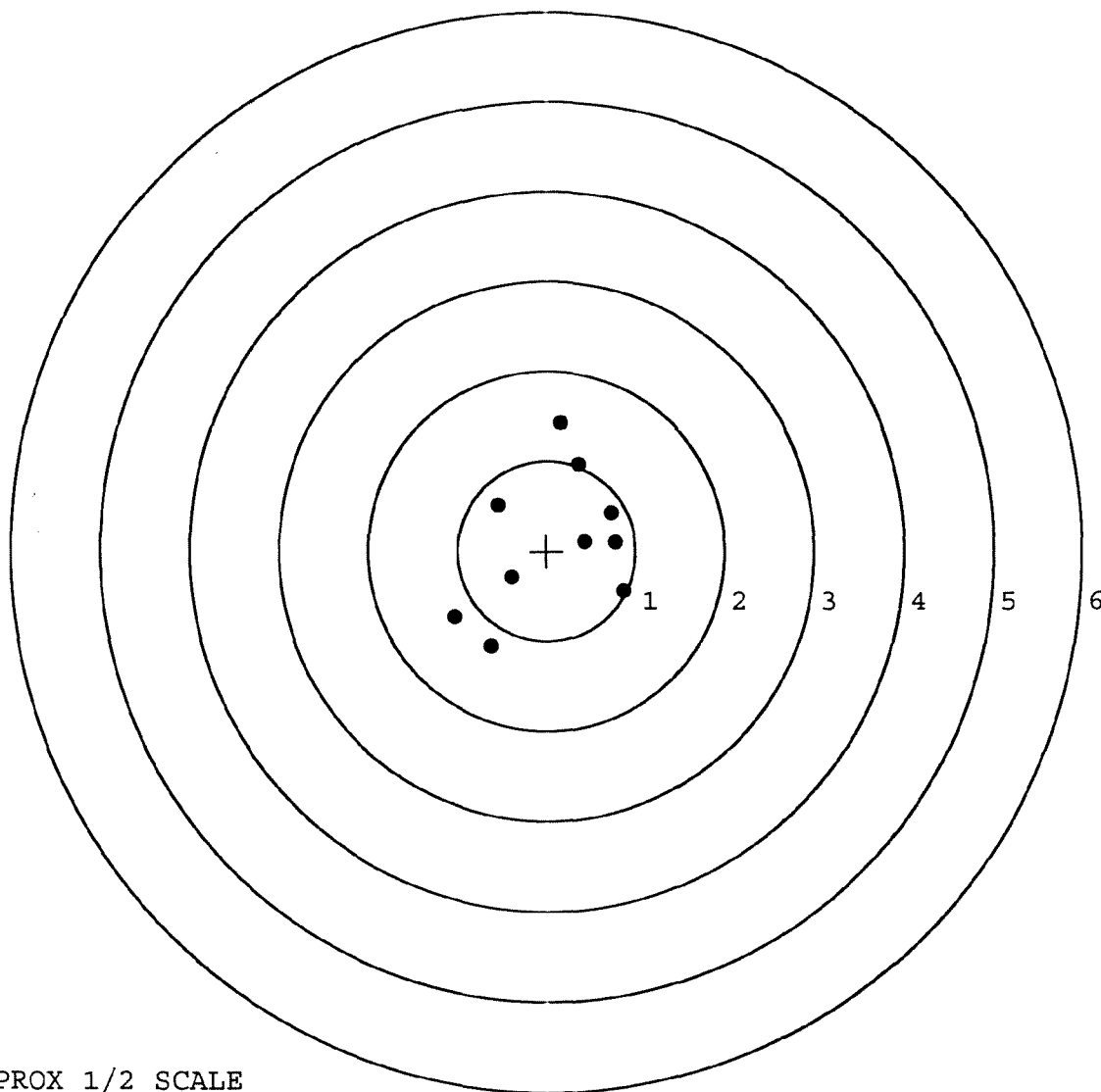


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590091.___1
TARGET NUMBER: 2
FILE DATE: 05/23/2008
FILE TIME: 05:41

X CENTROID: 0.070
Y CENTROID: 0.097
POA TO CENTROID: 0.120
HORZ SPREAD: 1.900
VERT SPREAD: 2.482
GROUP SPREAD: 2.472
MIN RADIUS: 0.363
MAX RADIUS: 1.393
MEAN RADIUS: 0.910
IN 1 IN DIAMETER: 1
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.861	-0.452
2:	0.776	0.104
3:	0.720	0.426
4:	0.433	0.107
5:	0.364	0.962
6:	0.159	1.417
7:	-0.549	0.511
8:	-0.398	-0.295
9:	-1.039	-0.745
10:	-0.624	-1.065

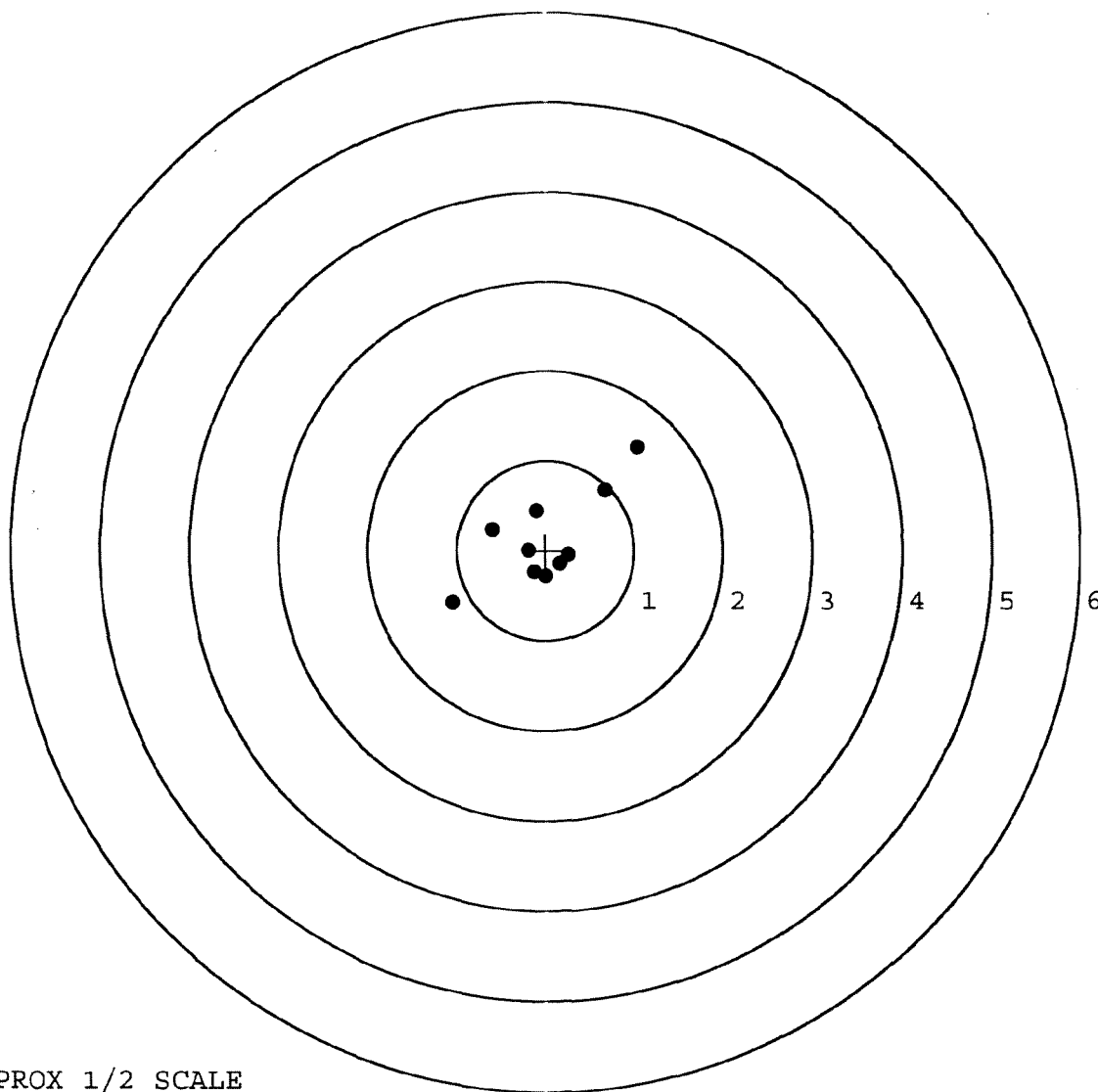


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590091. __1
TARGET NUMBER: 3
FILE DATE: 05/23/2008
FILE TIME: 05:41

X CENTROID: 0.003
Y CENTROID: 0.119
POA TO CENTROID: 0.119
HORZ SPREAD: 2.086
VERT SPREAD: 1.729
GROUP SPREAD: 2.709
MIN RADIUS: 0.233
MAX RADIUS: 1.457
MEAN RADIUS: 0.620
IN 1 IN DIAMETER: 6
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	1.035	1.148
2:	0.672	0.677
3:	-0.108	0.445
4:	-0.602	0.234
5:	-1.051	-0.581
6:	-0.196	-0.002
7:	0.256	-0.051
8:	0.000	-0.288
9:	-0.132	-0.244
10:	0.161	-0.148

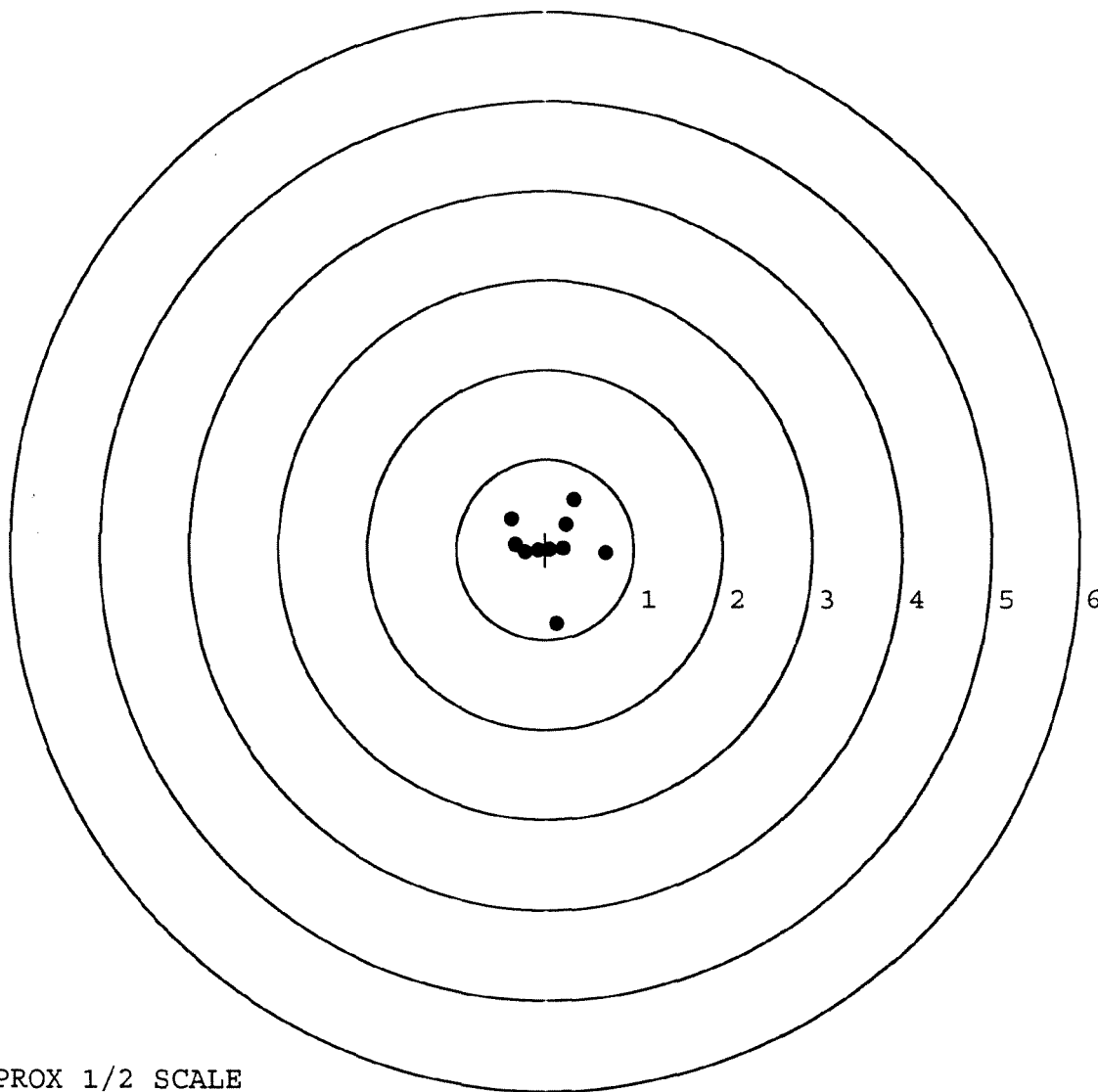


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590091. __1
TARGET NUMBER: 4
FILE DATE: 05/23/2008
FILE TIME: 05:41

X CENTROID: 0.057
Y CENTROID: 0.035
POA TO CENTROID: 0.067
HORZ SPREAD: 1.071
VERT SPREAD: 1.391
GROUP SPREAD: 1.405
MIN RADIUS: 0.036
MAX RADIUS: 0.869
MEAN RADIUS: 0.395
IN 1 IN DIAMETER: 6
IN 2 IN DIAMETER: 10
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.123	-0.832
2:	0.684	-0.039
3:	0.324	0.559
4:	-0.387	0.342
5:	0.232	0.277
6:	0.203	0.016
7:	0.048	0.000
8:	-0.344	0.066
9:	-0.229	-0.033
10:	-0.081	-0.009



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590091.___1

TARGET NUMBER: 5

FILE DATE: 05/23/2008

FILE TIME: 05:41

X CENTROID: 0.022

Y CENTROID: 0.040

POA TO CENTROID: 0.045

HORZ SPREAD: 1.806

VERT SPREAD: 1.170

GROUP SPREAD: 1.827

MIN RADIUS: 0.049

MAX RADIUS: 1.063

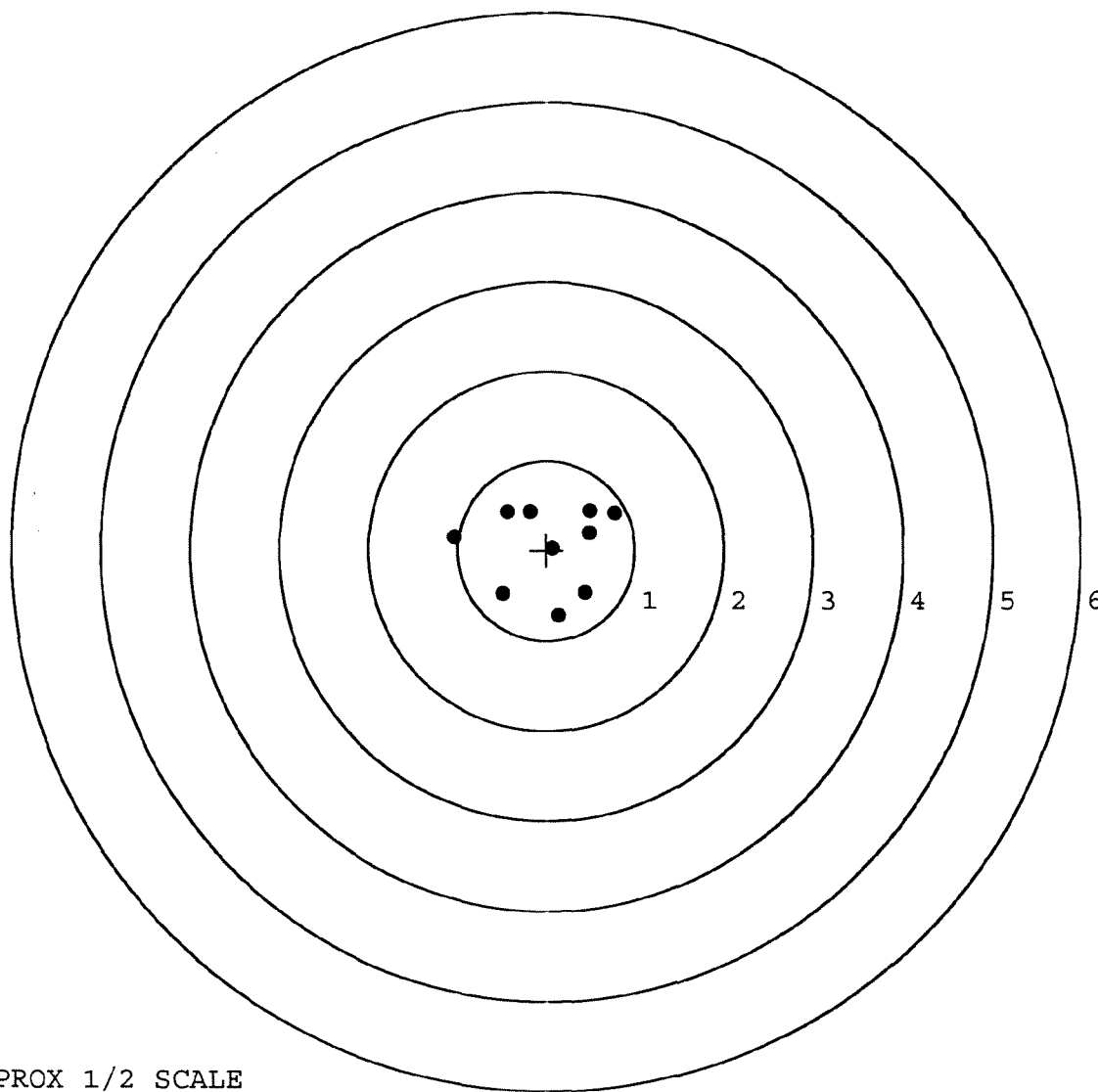
MEAN RADIUS: 0.628

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.438	-0.473
2:	0.136	-0.727
3:	0.067	0.020
4:	-0.498	-0.481
5:	-0.192	0.430
6:	-0.442	0.427
7:	-1.036	0.143
8:	0.770	0.416
9:	0.492	0.443
10:	0.486	0.198



TARGET APPROX 1/2 SCALE

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

R & E NUMBER <u>144838</u>			
SERIAL NUMBER <u>G6590091</u>			
LOG-IN DATE <u>4-24-08</u>			

OPERATION #	OPERATION NAME	DATE	INITIAL
500	DIS-ASSEMBLE GUN	5-5-08	RTZ
505	RE-BARREL	5-6-08	RTZ
560	ASSEMBLE	5-6-08	RTZ
600	PROOF	5-7-08	TRW
605	CHECK HEADSPACE	5-7-08	TRW
610	DIS-ASSEMBLE GUN	5-7-08	RTZ
612	MAGNAFLUX	5-9-08	unus
510	DRILL AND TAP	5-7-08	TRW
615	ROLLMARK CALIBER	5-7-08	CW
618	ROTO-BLAST	5-9-08	DG
620	APPLY COATINGS	5-19-08	unus
625	FINAL ASSEMBLY	5-22-08	RTZ
640	FUNCTION TEST AND	5-22-08	SD
650	TARGET	5-22-08	SD
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
670	FINAL INSPECTION	5-22-08	RP
	A) HEADSPACE	5-27-08	Fm
	B) TRIGGER PULL	5-27-08	Fm
	F) SAFETY ON FORCE	5-27-08	Fm
	G) SAFETY OFF FORCE	5-27-08	Fm
	I) FIRING PIN INDENT	5-27-08	Fm
690	PACK	5-29-08	Fm

Repair Inquiry

Repair Number: RE00125505

Serial: C6522248 Model M24 SWS Center Fire
Caliber: 308

Repairman:

Status:

Closed 2/20/2007 8:29:28 AM

Verify Repair

Address Information

Customer:

Received From

Return To:

Received From

Name: TRAFFIC MGMT OFFICE TRT

TRAFFIC MGMT OFFICE TRT

Address 1: 505 ATLANTIC STREET

505 ATLANTIC STREET

Address 2: 436 APS TRTD ROOM 107

PO Box:

436 APS TRTD ROOM 107

PO Box:

City: DOVER AFB

DOVER AFB

State: DE

Zip Code: 19902

Country: US

State: DE

Zip Code: 19902

Country: US

FFL:

Contact / Condition

Problems

Estimate

History / Status

Shipping / Billing

Contact Information

Phone: 302 677 4337

Fax:

Email:

Comments:

Received Condition

Fair

Condition
Notes:CSR
Notes:

Accessories Received

Code	Desc	Qty
A006	Sling Strap	1
A007	With Stud	3
A010	Hard Case	1
B000	SPOTTING SCOPE	1
B001	SCOPE CASE	1
B002	DEPLOYMENT KIT	1
B003	FRONT AND REAR E	2

Repair Search

Refresh

Close

nagletj

2/20/2007

10:45 AM

CAPS

NUM

INS

SCRL

Start

2 Mi...

4 In...

Arms...

Part...

25...

2 Mi...

10:45 AM

From
Dover AFB.Serial
Number:

C6522248

Model: M24 SWS



RE00125505

Send back APO, AE 09391
 XR W4GG Small Arms Support Center
 Operation IRAQ Freedom
 A.P.O. AE 09391
 W918X70260055

3/12/07

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6590091.___0
FILE DATE AND TIME: 03/08/2007 23:37

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.108
The Average Y Centroid of the Five Target Set:	-0.092
The Average Point of Impact of the Five Target Set:	0.142
The Average Mean Radius of the Five Target Set:	0.683
The Distance from POA to Centroid Target #1:	0.059
The Distance from Centroid Target #2 to Centroid Target #1:	0.080
The Distance from Centroid Target #3 to Centroid Target #1:	0.060
The Distance from Centroid Target #4 to Centroid Target #1:	0.655
The Distance from Centroid Target #5 to Centroid Target #1:	0.358

SERIAL NUMBER: G6590091. __0

TARGET NUMBER: 1

FILE DATE: 03/08/2007

FILE TIME: 23:37

POINT#	X	Y
1:	-0.463	-0.673
2:	-0.053	-0.409
3:	0.584	0.140
4:	0.366	0.621
5:	0.211	0.312
6:	0.162	-0.004
7:	0.062	0.281
8:	-0.104	0.079
9:	-0.210	0.146
10:	-0.487	0.096

X CENTROID: 0.007

Y CENTROID: 0.059

POA TO CENTROID: 0.059

HORZ SPREAD: 1.071

VERT SPREAD: 1.294

GROUP SPREAD: 1.537

MIN RADIUS: 0.113

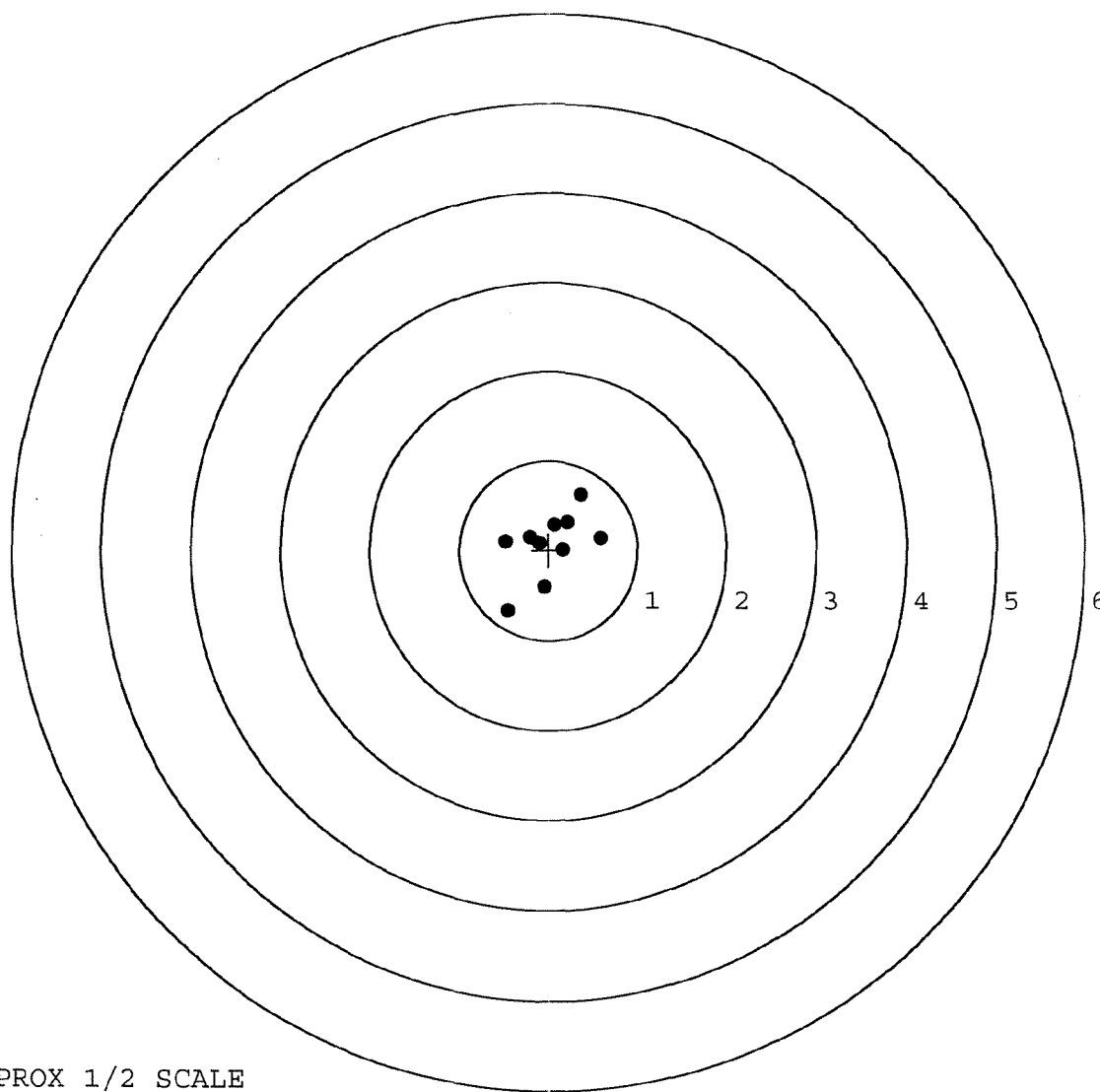
MAX RADIUS: 0.870

MEAN RADIUS: 0.415

IN 1 IN DIAMETER: 7

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590091. __0

TARGET NUMBER: 2

FILE DATE: 03/08/2007

FILE TIME: 23:37

POINT#	X	Y
1:	-0.275	0.430
2:	0.290	0.743
3:	-0.076	0.138
4:	0.139	0.102
5:	0.722	0.083
6:	0.885	-0.372
7:	-0.400	-0.245
8:	-0.731	-0.733
9:	-0.025	0.181
10:	0.323	0.115

X CENTROID: 0.085

Y CENTROID: 0.044

POA TO CENTROID: 0.096

HORZ SPREAD: 1.616

VERT SPREAD: 1.476

GROUP SPREAD: 1.795

MIN RADIUS: 0.079

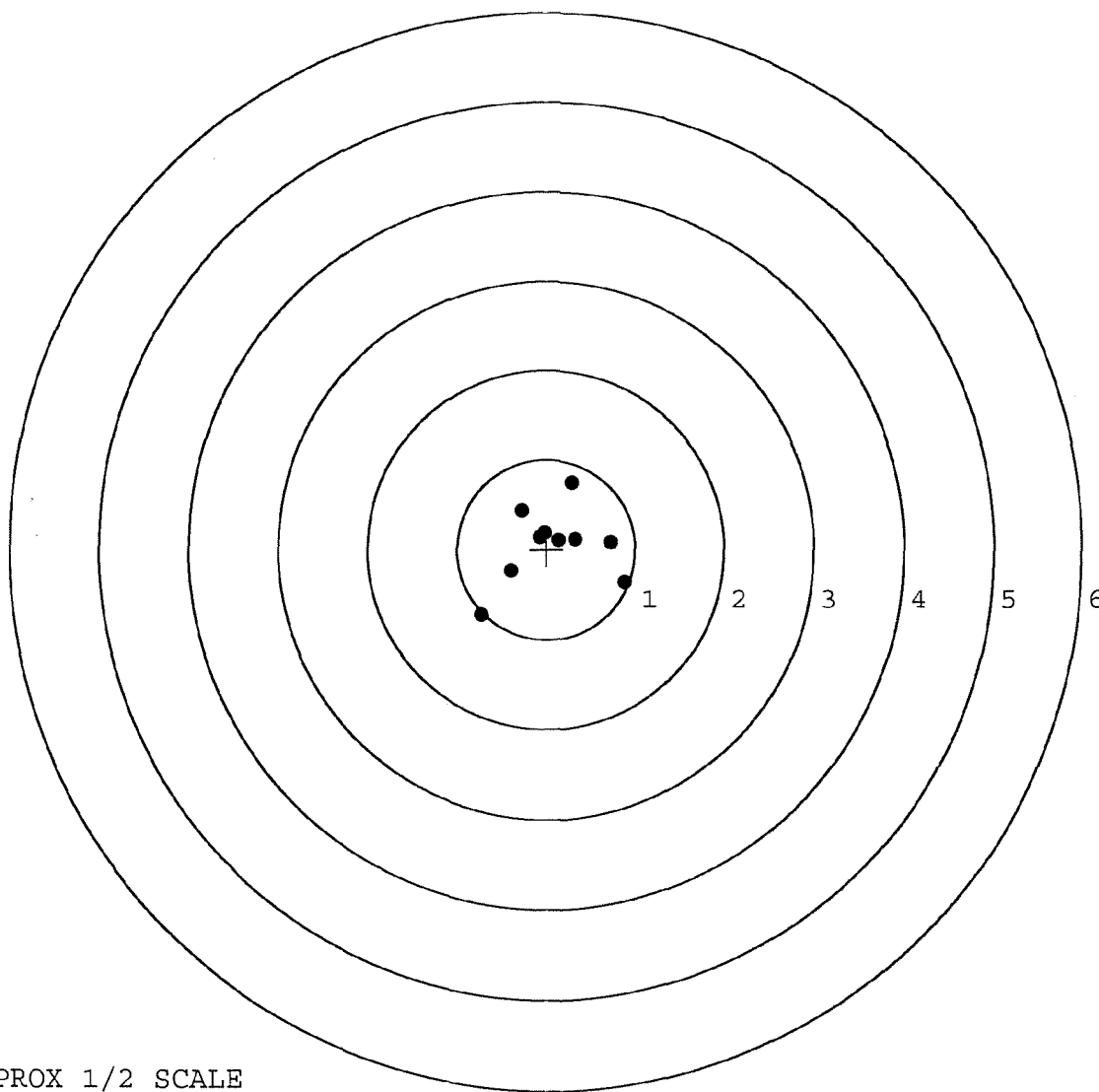
MAX RADIUS: 1.127

MEAN RADIUS: 0.518

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590091. __0

TARGET NUMBER: 3

FILE DATE: 03/08/2007

FILE TIME: 23:37

POINT#	X	Y
1:	-0.828	0.438
2:	0.432	1.160
3:	0.631	0.396
4:	0.769	-0.003
5:	0.275	0.038
6:	0.012	0.270
7:	0.061	-0.068
8:	-0.328	0.022
9:	-0.004	-0.490
10:	-0.484	-0.796

X CENTROID: 0.054

Y CENTROID: 0.097

POA TO CENTROID: 0.111

HORZ SPREAD: 1.597

VERT SPREAD: 1.956

GROUP SPREAD: 2.160

MIN RADIUS: 0.165

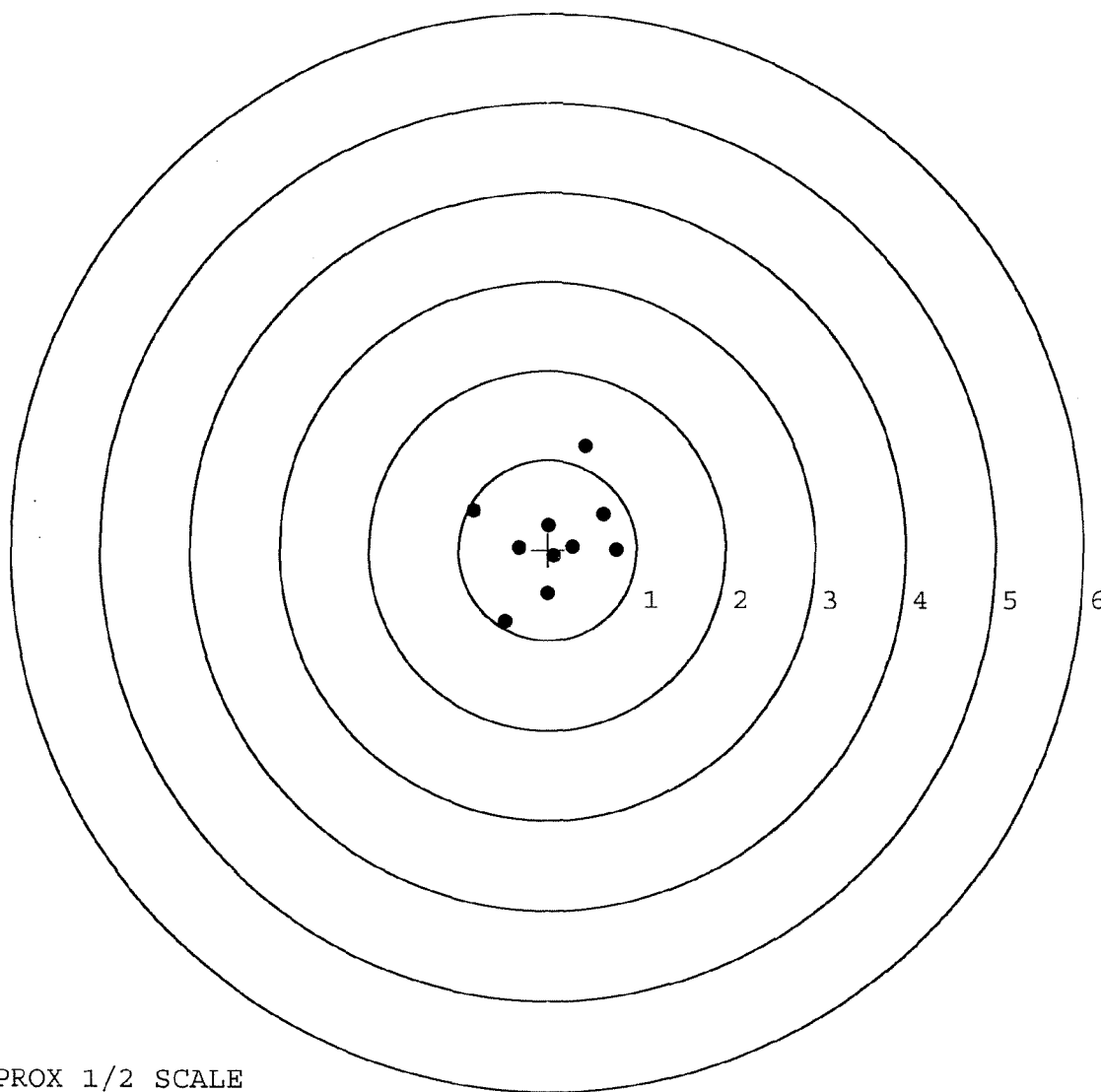
MAX RADIUS: 1.129

MEAN RADIUS: 0.604

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590091. __0

TARGET NUMBER: 4

FILE DATE: 03/08/2007

FILE TIME: 23:37

POINT#	X	Y
1:	-0.128	1.136
2:	0.317	0.511
3:	-0.134	0.411
4:	-0.053	0.185
5:	-0.255	-0.021
6:	-0.233	-0.417
7:	0.315	-0.519
8:	1.888	-1.126
9:	1.578	-1.538
10:	1.648	-2.414

X CENTROID: 0.494

Y CENTROID: -0.379

POA TO CENTROID: 0.623

HORZ SPREAD: 2.143

VERT SPREAD: 3.550

GROUP SPREAD: 3.969

MIN RADIUS: 0.227

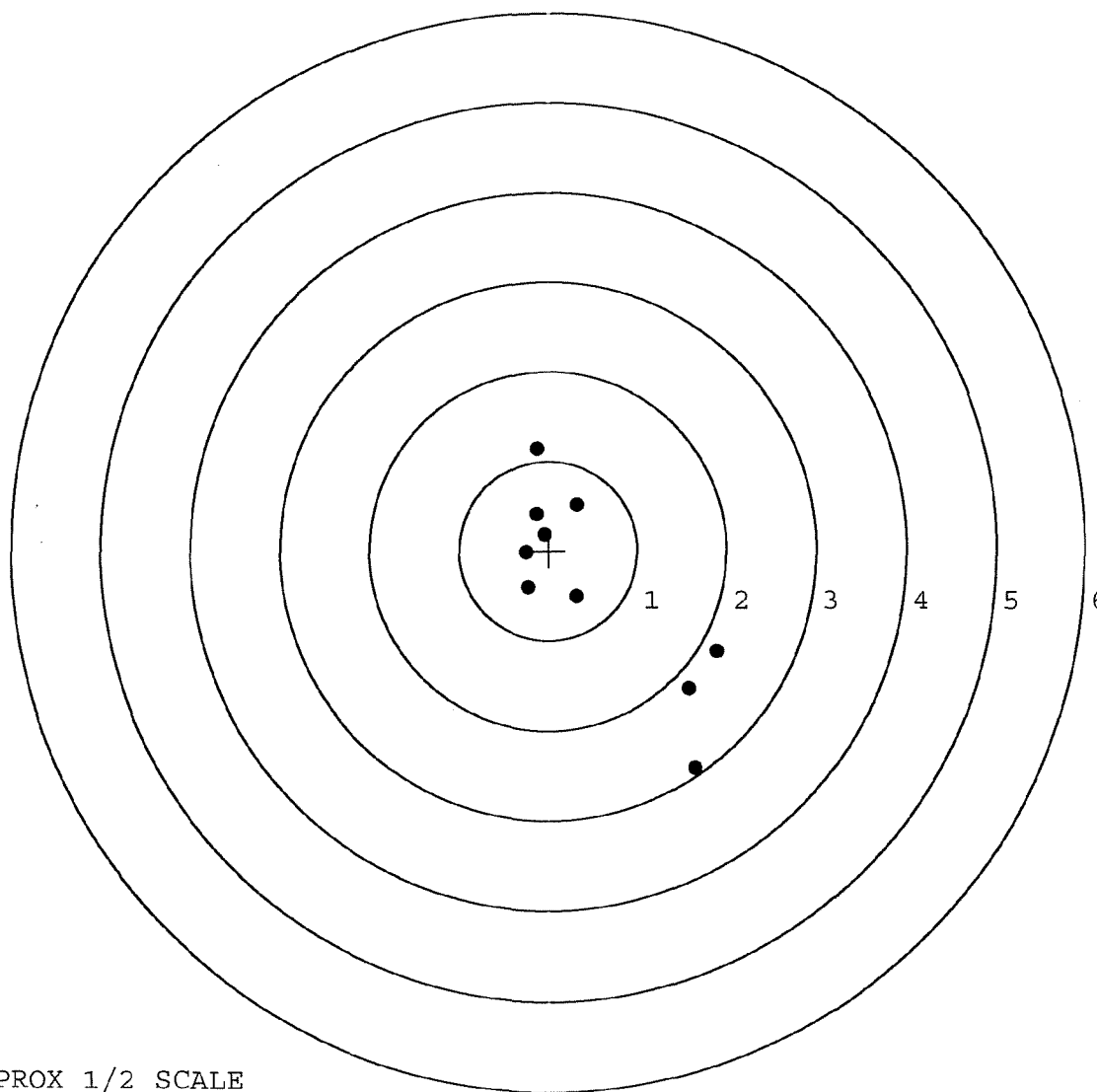
MAX RADIUS: 2.339

MEAN RADIUS: 1.163

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 5

in 3 IN DIAMETER: 6



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590091. __0

TARGET NUMBER: 5

FILE DATE: 03/08/2007

FILE TIME: 23:37

POINT#	X	Y
1:	-0.566	0.513
2:	0.076	0.427
3:	0.672	0.576
4:	-0.590	-0.070
5:	-0.464	-0.166
6:	0.056	-0.371
7:	0.532	-0.356
8:	-0.063	-0.924
9:	-0.212	-1.190
10:	-0.462	-1.262

X CENTROID: -0.102

Y CENTROID: -0.282

POA TO CENTROID: 0.300

HORZ SPREAD: 1.262

VERT SPREAD: 1.838

GROUP SPREAD: 2.160

MIN RADIUS: 0.181

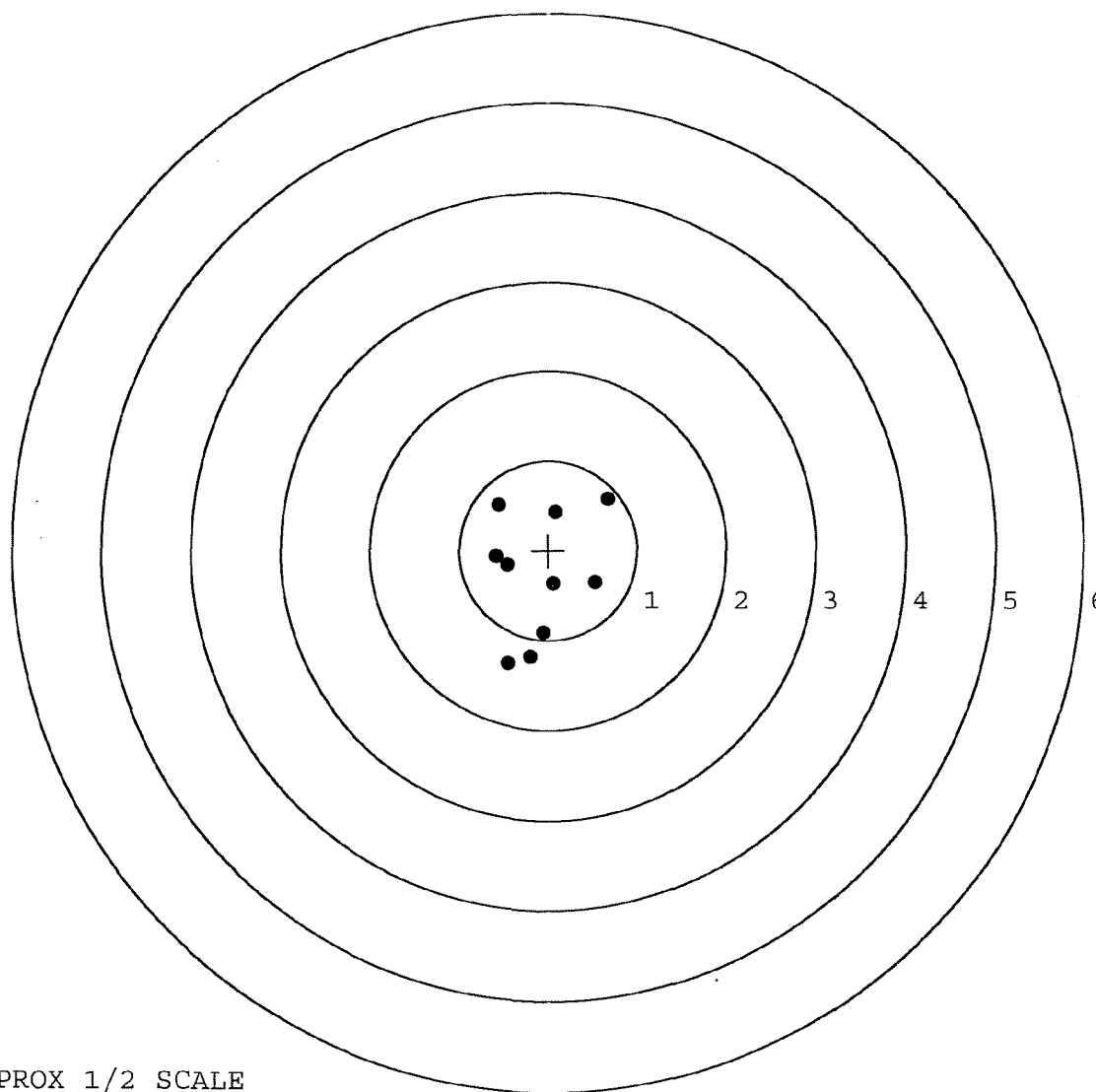
MAX RADIUS: 1.156

MEAN RADIUS: 0.714

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

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

R & E NUMBER	125505			
SERIAL NUMBER	C6522248		C6590091 (K/U)	
LOG-IN DATE	2-20-07			
OPERATION #	OPERATION NAME		DATE	INITIAL
500	DIS-ASSEMBLE GUN		2-21-07	RTZ
505	RE-BARREL		2-21-07	RTZ
560	ASSEMBLE		2-21-07	RTZ
600	PROOF		2-21-07	TRW
605	CHECK HEADSPACE	INSPECTED	2-21-07	TRW
610	DIS-ASSEMBLE GUN	FEB 22 2007	2-21-07	RTZ
612	MAGNAFLUX	OPERATOR <u>APD</u>	2-22-07	APD
510	DRILL AND TAP		2-21-07	TRW
615	ROLLMARK CALIBER		2-21-07	CW
618	ROTO-BLAST		2-22-07	LB
620	APPLY COATINGS		3-1-07	W7
625	FINAL ASSEMBLY		2-7-07	RTZ
640	FUNCTION TEST AND	(PASS) FAIL	3-8-07	SD
650	TARGET	(PASS) FAIL	3-8-07	SD
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
670	FINAL INSPECTION		3-12-07	RTZ
	A) HEADSPACE	(PASS) FAIL	3-12-07	RTZ
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	2.65 2.56 2.65 2.76 2.79 3.9-07	TRW
680	F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX	5.0 5.0 5.0 3.9-07	TRW
	G) SAFETY OFF FORCE	2 LBS MIN	2.5 2.25 2.5 3.9-07	TRW
	I) FIRING PIN INDENT	.020	.0235 .0225 .0225 3.9-07	TRW
690	PACK		3-12-07	DA

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

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

MODEL 700™ H24

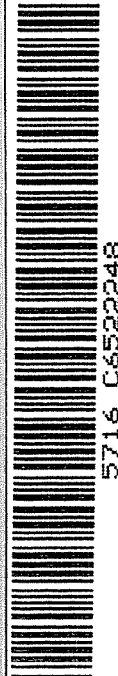
SERIAL NO. C6522248

ORDER NO. 5716

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

Ø1

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



UPC



Serial Number: C6522248
Model: M24 SWS

RE00106036

[illegible]

DA FORM 2407, JUL 94

CONTROL COPY 3

7200
7201

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

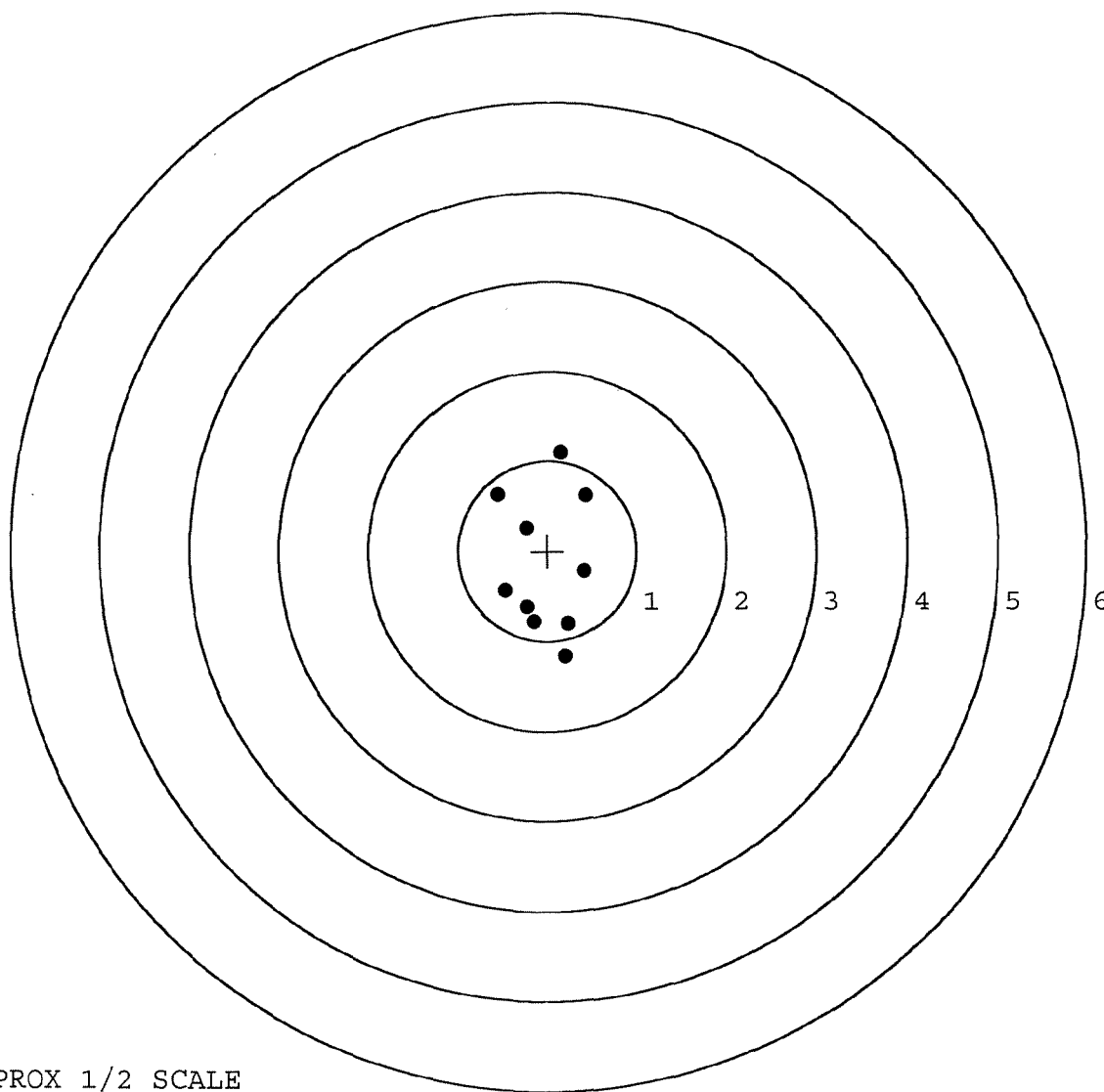
FIREARM SERIAL NUMBER / DATASET NAME: C6522248.___0
FILE DATE AND TIME: 01/17/2006 11:28

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.002
The Average Y Centroid of the Five Target Set:	-0.039
The Average Point of Impact of the Five Target Set:	0.039
The Average Mean Radius of the Five Target Set:	0.869
The Distance from POA to Centroid Target #1:	0.148
The Distance from Centroid Target #2 to Centroid Target #1:	0.223
The Distance from Centroid Target #3 to Centroid Target #1:	0.565
The Distance from Centroid Target #4 to Centroid Target #1:	0.106
The Distance from Centroid Target #5 to Centroid Target #1:	0.270

SERIAL NUMBER: C6522248. 0
TARGET NUMBER: 1
FILE DATE: 01/17/2006
FILE TIME: 11:28

	POINT#	X	Y
X CENTROID:	1:	0.206	-1.172
Y CENTROID:	2:	0.234	-0.811
POA TO CENTROID:	3:	-0.148	-0.789
HORZ SPREAD:	4:	-0.237	-0.624
VERT SPREAD:	5:	-0.479	-0.441
GROUP SPREAD:	6:	0.415	-0.220
MIN RADIUS:	7:	-0.245	0.256
MAX RADIUS:	8:	-0.562	0.625
MEAN RADIUS:	9:	0.433	0.619
# IN 1 IN DIAMETER:	10:	0.145	1.093
# IN 2 IN DIAMETER:			
# IN 3 IN DIAMETER:			



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6522248. __0

TARGET NUMBER: 2

FILE DATE: 01/17/2006

FILE TIME: 11:28

X CENTROID: 0.106

Y CENTROID: 0.035

POA TO CENTROID: 0.112

HORZ SPREAD: 1.124

VERT SPREAD: 1.927

GROUP SPREAD: 2.087

MIN RADIUS: 0.266

MAX RADIUS: 1.220

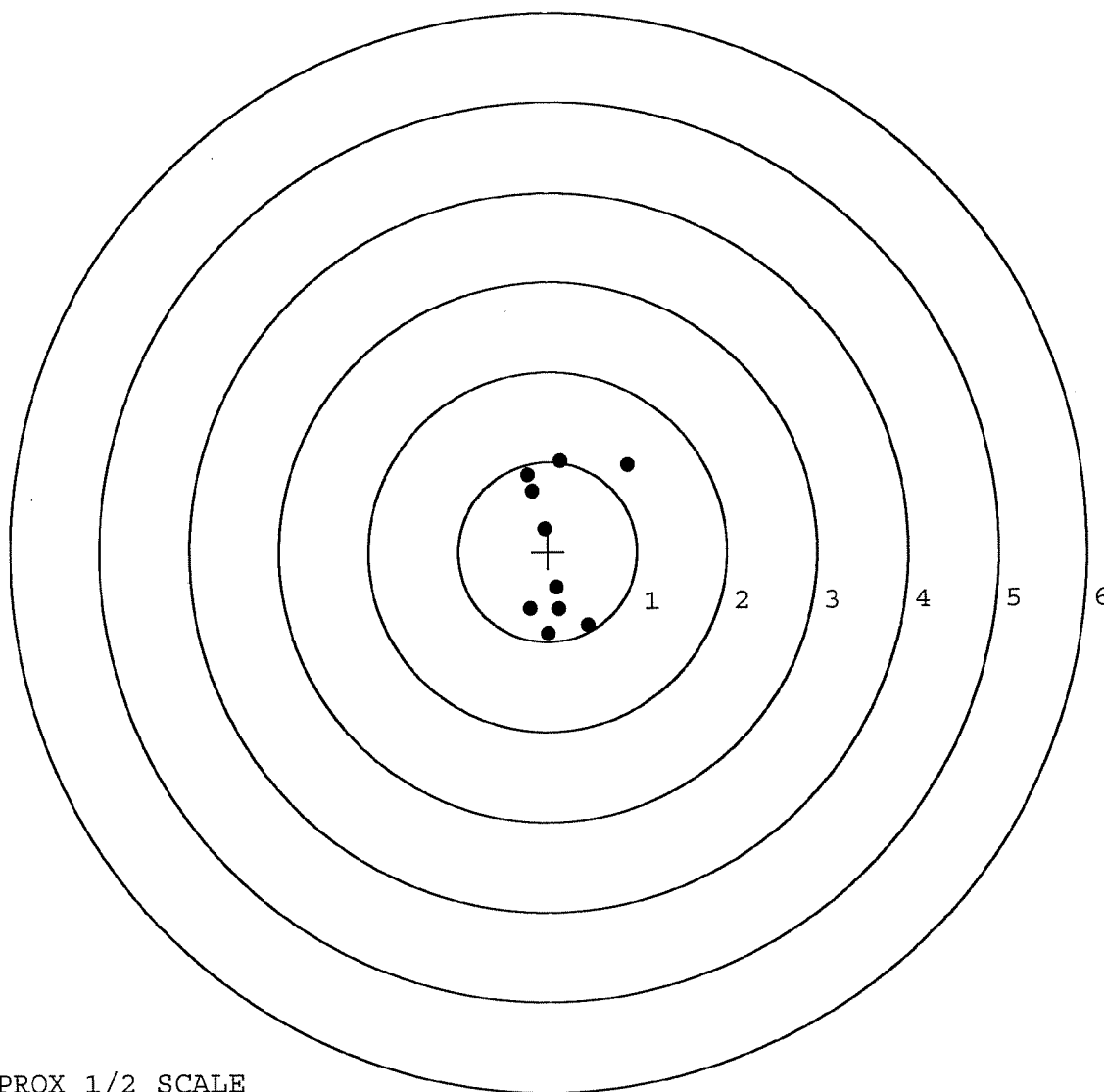
MEAN RADIUS: 0.778

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.895	0.965
2:	0.143	1.008
3:	-0.229	0.859
4:	-0.174	0.676
5:	-0.037	0.259
6:	0.452	-0.820
7:	0.095	-0.398
8:	-0.002	-0.919
9:	-0.201	-0.637
10:	0.120	-0.645



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6522248. __0

TARGET NUMBER: 3

FILE DATE: 01/17/2006

FILE TIME: 11:28

X CENTROID: -0.126

Y CENTROID: 0.409

POA TO CENTROID: 0.428

HORZ SPREAD: 1.551

VERT SPREAD: 3.194

GROUP SPREAD: 3.284

MIN RADIUS: 0.107

MAX RADIUS: 1.972

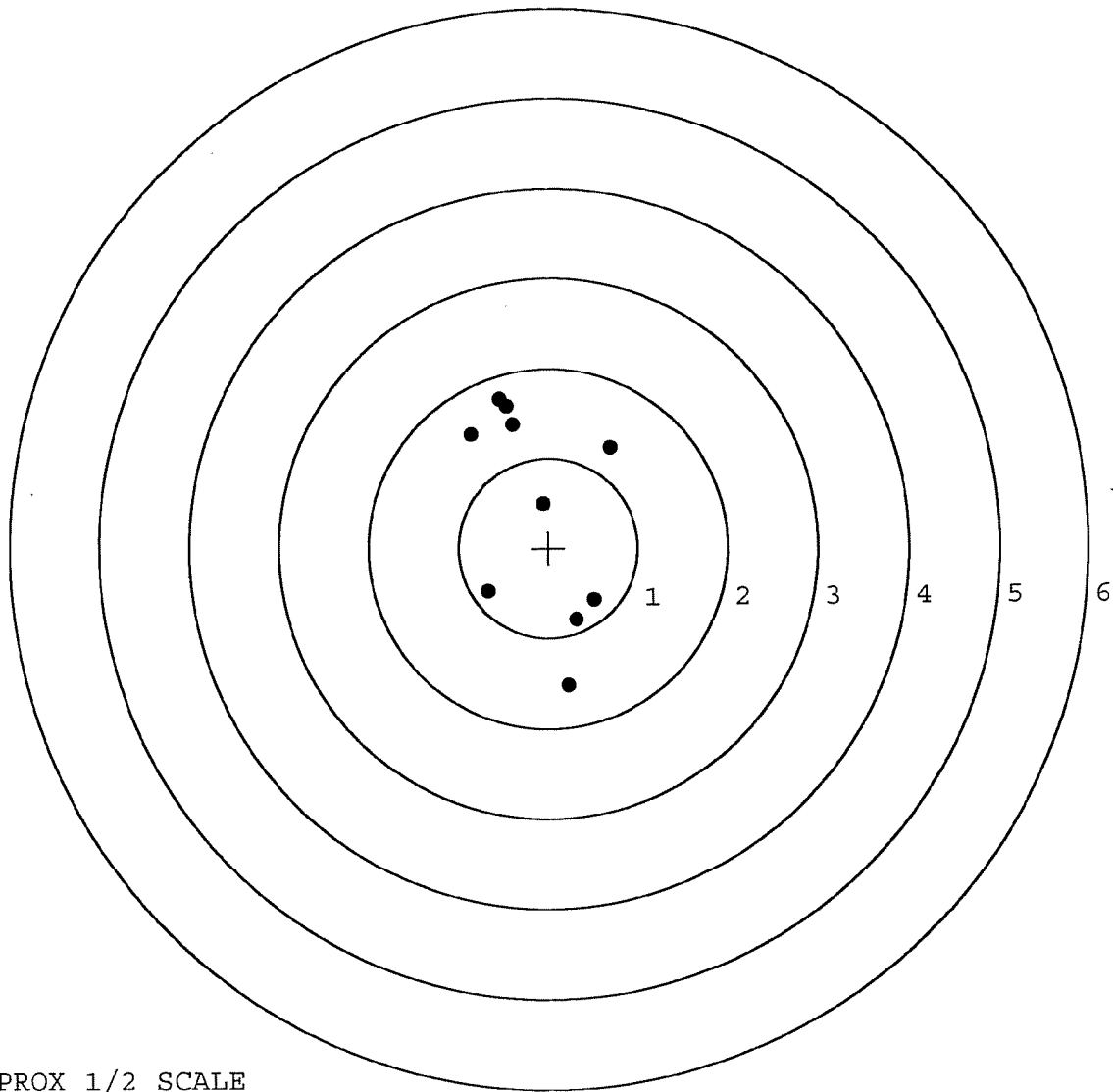
MEAN RADIUS: 1.135

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 1

in 3 IN DIAMETER: 9

POINT#	X	Y
1:	0.220	-1.533
2:	0.310	-0.803
3:	0.511	-0.586
4:	0.695	1.116
5:	-0.058	0.491
6:	-0.677	-0.482
7:	-0.856	1.269
8:	-0.396	1.375
9:	-0.464	1.580
10:	-0.545	1.661



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6522248. __0

TARGET NUMBER: 4

FILE DATE: 01/17/2006

FILE TIME: 11:28

POINT#	X	Y
1:	1.185	-0.859
2:	0.953	0.466
3:	-0.454	0.537
4:	-1.115	-0.582
5:	-0.519	-0.140
6:	-0.325	0.003
7:	-0.050	-0.374
8:	0.186	0.129
9:	0.318	-0.074
10:	0.391	0.111

X CENTROID: 0.057

Y CENTROID: -0.078

POA TO CENTROID: 0.097

HORZ SPREAD: 2.300

VERT SPREAD: 1.396

GROUP SPREAD: 2.317

MIN RADIUS: 0.244

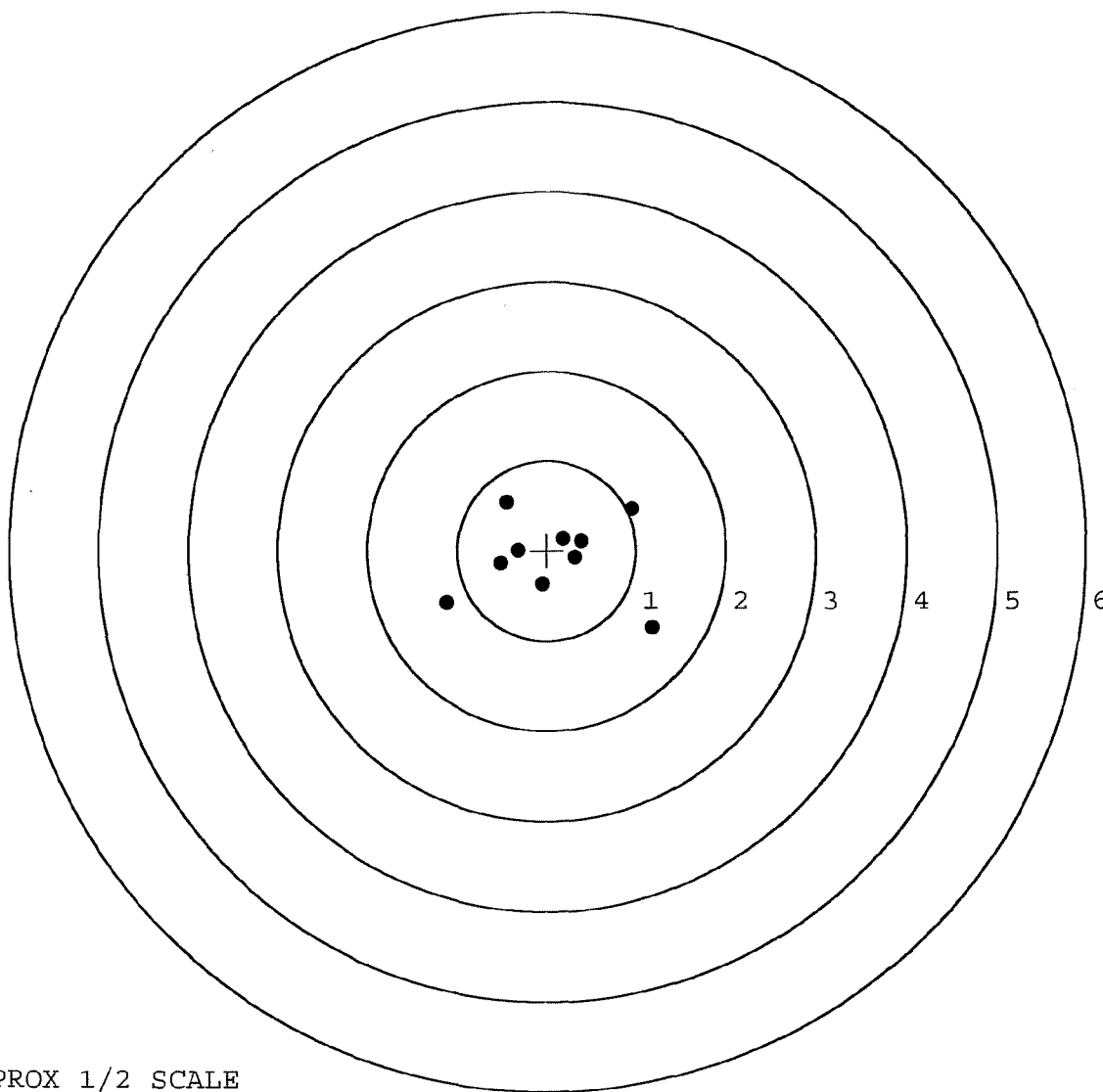
MAX RADIUS: 1.372

MEAN RADIUS: 0.667

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10

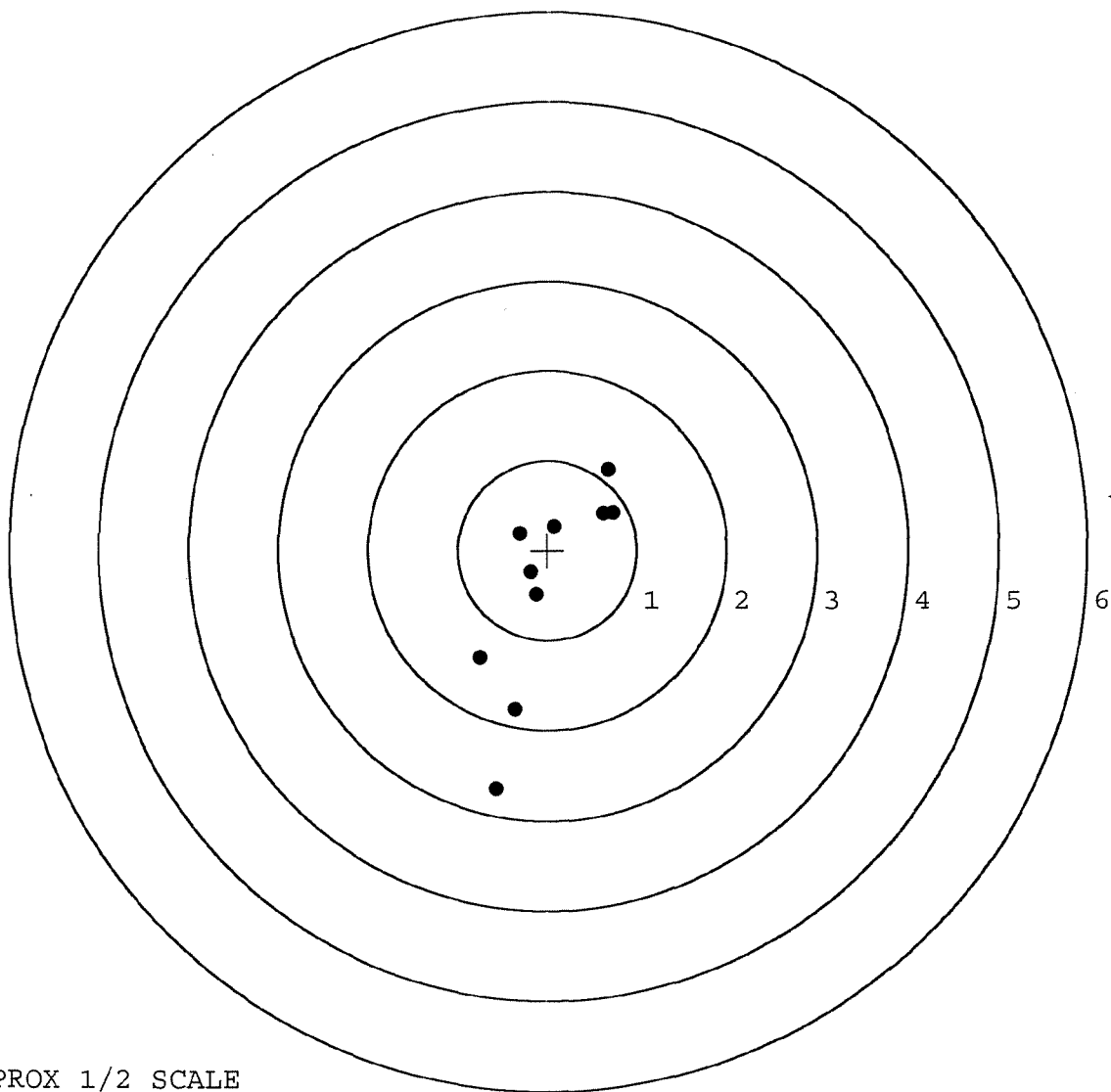


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6522248. 0
TARGET NUMBER: 5
FILE DATE: 01/17/2006
FILE TIME: 11:28

POINT#	X	Y
1:	0.624	0.420
2:	0.727	0.422
3:	0.675	0.906
4:	0.072	0.265
5:	-0.316	0.187
6:	-0.188	-0.243
7:	-0.127	-0.498
8:	-0.753	-1.198
9:	-0.362	-1.775
10:	-0.571	-2.648

X CENTROID: -0.022
Y CENTROID: -0.416
POA TO CENTROID: 0.417
HORZ SPREAD: 1.480
VERT SPREAD: 3.554
GROUP SPREAD: 3.766
MIN RADIUS: 0.133
MAX RADIUS: 2.298
MEAN RADIUS: 1.018
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 4
in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

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

R & E NUMBER	106036			
SERIAL NUMBER	C6522248			
LOG-IN DATE	1-4-06			
OPERATION #	OPERATION NAME		DATE	INITIAL
500	DIS-ASSEMBLE GUN		1-6-06	RTL
505	RE-BARREL		1-6-06	RTL
560	ASSEMBLE		1-6-06	RTL
600	PROOF	MAGNA-FLUX REQUESTED JAN 10 2006	1-6-06	BG
605	CHECK HEADSPACE		1-6-06	AC
610	DIS-ASSEMBLE GUN		1-6-06	AC
612	MAGNAFLUX	OF SATOR <u>unsub</u>	1/10/06	unsub
510	DRILL AND TAP		1-10-06	TRW
615	ROLLMARK CALIBER		1-10-06	CW
618	ROTO-BLAST		1-10-06	LB
620	APPLY COATINGS		1/11	HK
625	FINAL ASSEMBLY		1-16-06	RTL
640	FUNCTION TEST AND	PASS FAIL	1-17-06	TRW
650	TARGET	PASS FAIL		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION	1-17-06	TRW
670	FINAL INSPECTION		1-23-06	Ac
	A) HEADSPACE	PASS FAIL	1-23-06	Ac
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS		N/A
680	F) SAFETY ON FORCE	2 LBS MIN 10 LBS	4 lbs. 4 lbs. 4 lbs.	A
	G) SAFETY OFF FORCE	2 LBS MIN	3 lbs. 3 lbs. 3 lbs.	A
	I) FIRING PIN INDENT	.020		
690	PACK		1-24-06	NA

CAR TCC

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6522248

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		8-21-90	RB
600	Proof		8-21-90	RB
607	Check Headspace		8-21-90	RB
610	Dis-assemble Gun		8-21-90	RB
612	Magnaflux Barrel Action	New BBL 8/22/90	8/23/90	KCR
	Magnaflux Bolt		8/22/90	KCR
615	Rollmark Caliber		8/22/90	GS.
617	Drill and Tap Sight Holes		8/22/90	FB
618	Polish Barrel RB		8/22/90	WB
620	Apply Coatings (Barrel Action)		8/30/90	TA
	Apply Coating (Bolt)			TA
625	Final Assembly A) Clean inside of Bolt Assembly		8/31/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/31/90	RW
	C) Inspect Ejector Hole for Chamfer		8/31/90	RW
	D) Oil Firing Pin Ass'y		8/31/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		9/15/90	WB

Op. #	OP. NAME	READINGS					DATE	INIT
635 ht.	F) Safety On Force	4	4	4			9/15/90	928
	G) Safety Off Force	3	3	3			9/15/90	928
	H) Trigger Pull Test & Retainability						9/15/90	W.B
	I) Firing Pin Indent	.225	.023	.023			9/15/90	928
	J) Assemble Stock						9/15/90	RW
	K) Assemble Swivel Studs						9/15/90	928
	L) Attach Front and Rear Sight Assemblies						9/15/90	RW
	M) Iron Sight Alignment						9/15/90	RW
	N) Detach Front & Rear Sights & place in numbered container						9/15/90	RW
	O) Attach Scope to Rifle						9/15/90	RW
	P) Detach & Attach Scope 20 Times						9/15/90	RW
640	Gallery Target & Test						9/16/90	KT
	A) Time						9/16/90	KT
	B) Malfunctions						9/16/90	KT
	C) Pierced Primers						9/16/90	KT
	D) Optical Clarity of Scope						9/16/90	KT
645	Inspect for Live Ammo						9/16/90	KT
655	Final Inspection						9/17/90	928
	A) Headspace						9/17/90	928
	B) Trigger Pull	2.12	2.15	2.02	2.08	2.06	9/17/90	928
	C) Function						9/17/90	928
660	Pack						9/19/90	DA

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6522748

DATE 9/15/90

TESTER WB

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.52	2.55	2.39	2.12	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.50	2.40	2.35	2.15	
PULL #3	2.50	2.43	2.33	2.02	
PULL #4	2.47	2.38	2.30	2.08	
PULL #5	2.54	2.37	2.27	2.06	
TOTAL	12.53	12.13	11.64	10.43	
AVG.	2.51	2.43	2.33	2.086	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.13	3.11		
PULL #2	3.13	3.07		
PULL #3	3.08	3.03		
PULL #4	3.11	3.01		
PULL #5	3.10	3.11		
TOTAL	15.55	15.33		
AVG.	3.11	3.07		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.09	4.01		4.07
PULL #2	4.05	4.05		4.19
PULL #3	4.07	4.06		4.14
PULL #4	4.08	4.00		4.22
PULL #5	4.03	3.95		4.20
TOTAL	20.32	20.07		20.82
AVG.	4.07	4.01		4.16

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06522248
16 Sep 1990

CENTROIDAL DISTANCES

0 TO	1	.203214
1 TO	2	.303165
1 TO	3	.419547
1 TO	4	.209122
1 TO	5	.0686003

0.0000

<----FOR

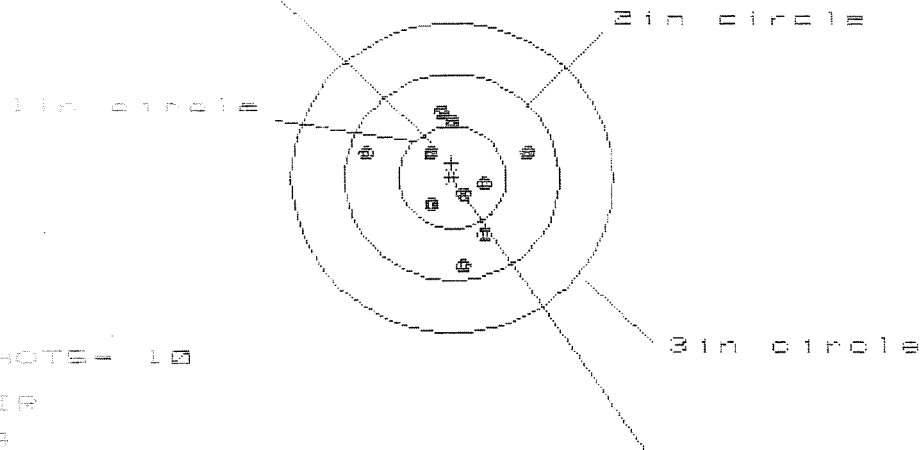
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0222
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0132
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0258279
THE AOR FOR THIS RIFLE IS: .8376

16 Sep 1988

FILE:/PATTERNING/CENTERFIRE_PATT/08522248

CENTERFIRE PATTERNS # 1

POA



* OF SHOTS= 10

* IN CIR

1in = 4

2in = 10

3in = 10

RS= 1.510

VS= 1.404

GS= 1.510

CENTROID #

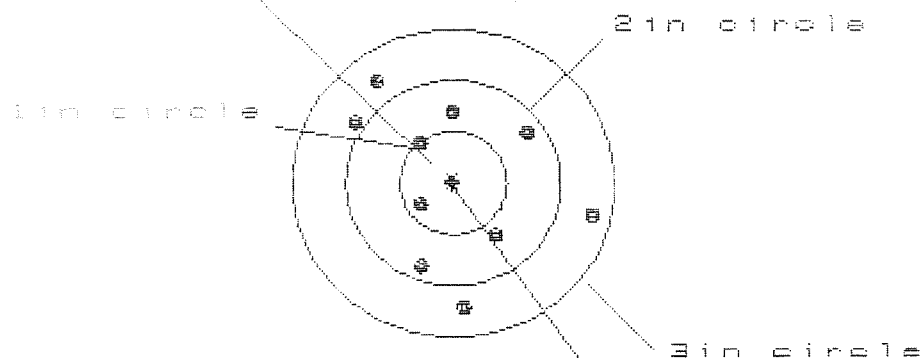
PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.670	.577	.572
MINIMUM X	:	-.840	-.285	-.290
MAXIMUM Y	:	.598	.626	.528
MINIMUM Y	:	-.806	-.778	-.668
CENTROID X	:	.005	.098	.104
CENTROID Y	:	-.145	-.173	-.076
POA TO CENTROID IN.	:	.145	.199	.128
MIN RADIUS	:	.165	.137	.226
MEAN RADIUS	:	.531	.484	.449
MAY RADIUS	:	.875	.780	.690
HORIZONTAL SPREAD	:	1.510	.862	.862
VERTICAL SPREAD	:	1.404	1.404	1.197
EXTREME SPREAD	:	1.510	1.409	1.245
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		10	
NUMBER IN THREE INCH CIRCLE	=		10	

16 Sep 1998

FILE:/PATTERNING/CENTERFIRE_PATT/06522248

CENTERFIRE PATTERNS # 2

POP



OF SHOTS = 10

IN CIR

1in = 1

2in = 6

3in = 10

HS = 2.878

VS = 2.214

GS = 2.447

CENTROID #

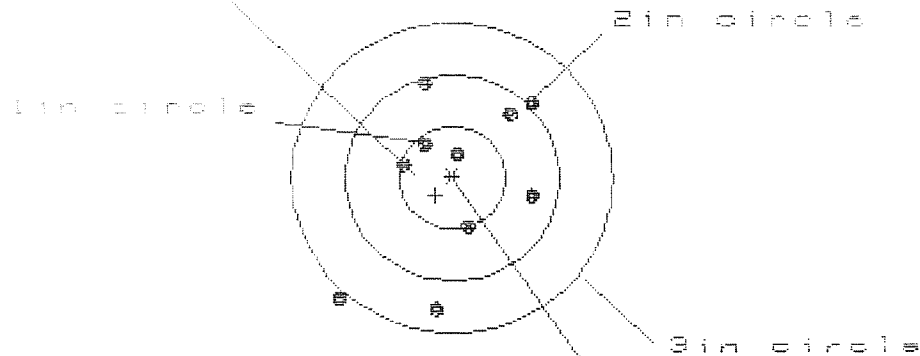
PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.325	.854	.889
MINIMUM X	-.950	-.803	-.768
MAXIMUM Y	.981	.944	.785
MINIMUM Y	-1.234	-1.270	-.975
CENTROID X	.010	-.137	-.172
CENTROID Y	.004	.041	.200
POD TO CENTROID in.	.011	.143	.264
MIN RADIUS	.420	.345	.239
MEAN RADIUS	.892	.821	.740
MAX RADIUS	1.364	1.301	.981
HORIZONTAL SPREAD	2.275	1.657	1.657
VERTICAL SPREAD	2.214	2.214	1.768
EXTREME SPREAD	2.447	2.361	1.870
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		10	

16 Sep 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C8522248

CENTERFIRE PATTERNS # 3

PCR



* OF SHOTS = 10

* IN CIR

1 in = 4

2 in = 7

3 in = 9

MS = 1.728

VS = 2.225

ES = 2.588

CENTROID *

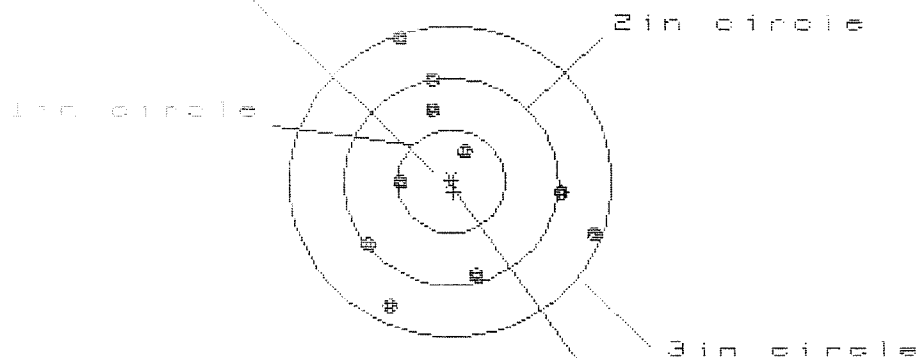
PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.716	.603	.566
MINIMUM X	:	-1.012	-.578	-.615
MAXIMUM Y	:	.954	.825	.650
MINIMUM Y	:	-1.271	-1.400	-.729
CENTROID X	:	.158	.270	.307
CENTROID Y	:	.172	.301	.476
PCR TO CENTROID in.	:	.233	.405	.567
MIN RADIUS	:	.216	.097	.133
MEAN RADIUS	:	.796	.684	.576
MAX RADIUS	:	1.540	1.431	.760
HORIZONTAL SPREAD	:	1.728	1.181	1.181
VERTICAL SPREAD	:	2.225	2.225	1.379
EXTREME SPREAD	:	2.588	2.230	1.449
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

18 Sep 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C8522248

CENTERFIRE PATTERNS # 4

FOR



OF SHOTS= 10

IN CIR

1in = 1

2in = 5

3in = 10

HS= 2.110

VS= 2.585

GS= 2.815

CENTROID #

PATTERN #	4		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.340	1.188	1.147
MINIMUM X	-.770	-.621	-.662
MAXIMUM Y	1.349	1.289	1.144
MINIMUM Y	-1.236	-1.296	-1.134
CENTROID X	-.026	-.175	-.134
CENTROID Y	.103	.163	.001
FOR TO CENTROID in.	.106	.239	.134
MIN RADIUS	.276	.315	.414
MEAN RADIUS	.978	.907	.861
MAX RADIUS	1.443	1.374	1.238
HORIZONTAL SPREAD	2.110	1.809	1.809
VERTICAL SPREAD	2.585	2.585	2.278
EXTREME SPREAD	2.615	2.588	2.314
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		10	

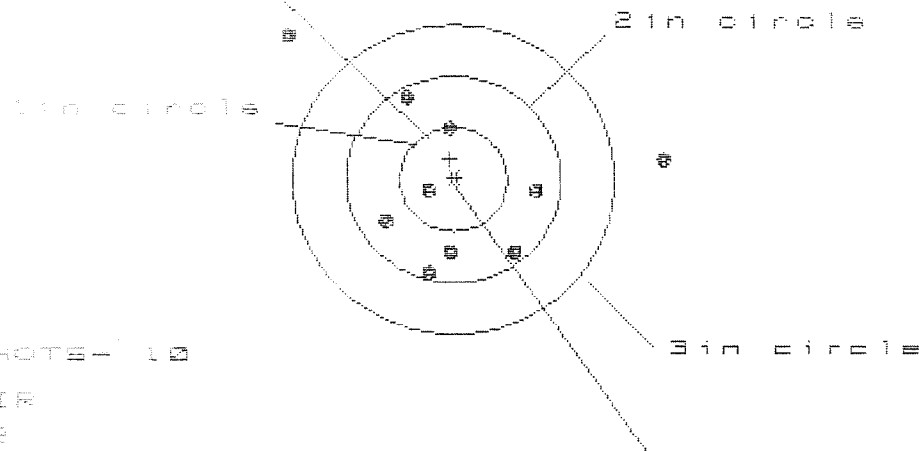
18 Sep 1998

FILE:/PATTERNING/CENTERFIRE_PATT/08522248

CENTERFIRE PATTERNS

5

POB



OF SHOTS- 10

1 in CIR

1 in = 2

2 in = 8

3 in = 8

HS= 2.521

VS= 2.341

ES= 3.708

CENTROID *

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.976	1.807	.838
MINIMUM X	-1.525	-.806	-.580
MAXIMUM Y	1.439	1.003	1.051
MINIMUM Y	-.902	-.743	-.695
CENTROID X	.036	.205	-.021
CENTROID Y	-.200	-.359	-.407
POB TO CENTROID in.	.203	.414	.408
MIN RADIUS	.309	.441	.224
MEAN RADIUS	.991	.857	.686
MAX RADIUS	2.096	1.847	1.122
HORIZONTAL SPREAD	3.501	2.613	1.418
VERTICAL SPREAD	2.341	1.746	1.746
EXTREME SPREAD	3.706	2.686	1.795
NUMBER IN ONE INCH CIRCLE	=	2	
NUMBER IN TWO INCH CIRCLE	=	8	
NUMBER IN THREE INCH CIRCLE	=	8	