

G6738638
Replaces
C6587574

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: **RE00166306** Serial: C6587574 Model M24 SWS Center Fire Repairman: _____
 Verify Repair Caliber: 7.62 NATO Produced: 12/19/1990 Status: Closed 4/15/2009 5:16:10 AM

Address Information

Customer: ☒ Received From Return To: ☐ Received From

Name: **DEPARTMENT OF THE ARMY** **DEPARTMENT OF THE ARMY**

Address 1: **1-23 INFANTRY REGIMENT** **1-23 INFANTRY REGIMENT**

Address 2: **BOX 339500 MS 81** PO Box: _____ **BOX 339500 MS 81** 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: NN Fax: _____ Email: _____ Comments: _____	Received Condition Fair: _____ Condition Notes: _____ CSR Notes: _____	Accessories Received <table border="1"> <thead> <tr> <th>Code</th> <th>Desc</th> <th>Qty</th> </tr> </thead> <tbody> <tr> <td>A007</td> <td>With Stud</td> <td>3</td> </tr> <tr> <td>A008</td> <td>With Swivel</td> <td>2</td> </tr> <tr> <td>A010</td> <td>Hard Case</td> <td>1</td> </tr> <tr> <td>A017</td> <td>Scope Base</td> <td>1</td> </tr> <tr> <td>A026</td> <td>Scope</td> <td>1</td> </tr> <tr> <td>A045</td> <td>Bi Pod</td> <td>1</td> </tr> <tr> <td>D000</td> <td>FRONT SIGHT BASE</td> <td>1</td> </tr> </tbody> </table>	Code	Desc	Qty	A007	With Stud	3	A008	With Swivel	2	A010	Hard Case	1	A017	Scope Base	1	A026	Scope	1	A045	Bi Pod	1	D000	FRONT SIGHT BASE	1		
Code	Desc	Qty																										
A007	With Stud	3																										
A008	With Swivel	2																										
A010	Hard Case	1																										
A017	Scope Base	1																										
A026	Scope	1																										
A045	Bi Pod	1																										
D000	FRONT SIGHT BASE	1																										

Repair Search Refresh Close Refresh Close Close

magle 4/15/2009 7:27 AM CAPS NUM INS SCRL

Start 6 Microsoft Office Google News - Win... 9 Microsoft Office Arms Services Rep Part Search by Mat... 7:27 AM

G 673 863 8

FP ASSY
Flash suppressor

C6587574

Model: **M24 SWS**



RE00166306

INSPECTION CHECKLIST - REPAIRS

CONTRACT #: W52H09-07-C-0207

ISSUED 10/1/2007

R & E NUMBER

1166306

SERIAL NUMBER

C6587574

C6738638

LOG-IN DATE

4-14-09

OPERATION #	OPERATION NAME	DATE	INITIAL
500	DIS-ASSEMBLE GUN	4-16-09	RT
505	RE-BARREL	4-21-09	RT
420	ASSEMBLE	4-21-09	RT
440	PROOF	4-21-09	W/W
460	CHECK HEADSPACE	4-21-09	W/W
470	DIS-ASSEMBLE GUN	4-21-09	RT
480	MAGNAFLUX	4-24-09	JD
510	DRILL AND TAP	4-21-09	SP
500	ROLLMARK CALIBER	4-27-09	RT
520	GOFF BLAST BBL / REC	4-28	W/W
530 & 540	APPLY COATINGS	4-30	W/W
560	FINAL ASSEMBLY	5-1-09	RT
640	FUNCTION TEST AND	PASS	FAIL
650	TARGET	PASS	FAIL
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
670	FINAL INSPECTION	5-4-09	TAR
	A) HEADSPACE	PASS	FAIL
	B) TRIGGER PULL	2.56 2.52 2.45 2.48 2.43 5-4-09	W/W
680	F) SAFETY ON FORCE	4.0 4.0 4.0 5-6-09	W/W
	G) SAFETY OFF FORCE	5.0 5.0 5.0 5-6-09	W/W
	I) FIRING PIN INDENT	.022 .022 .022 5-6-09	W/W
690	PACK	5-15-09	F/W

F006 REV 1/2009

MAINTENANCE REQUEST For use of this form, see DA PAM 738-750 and 738-751; the proponent agency is DCSLOG				PAGE NO	NO OF PAGES	REQUIREMENT CONTROL SYMBOL CSGLD-1047(R1)
SECTION I - CUSTOMER DATA				SECTION II - MAINTENANCE ACTIVITY DATA		
1a. UIC CUSTOMER WASKT	1b. CUSTOMER UNIT NAME HHC5-291N	1c. PHONE NO 253-9662	3a. WORK ORDER NUMBER (WON)		3b. SHOP	3c. PHONE NO
2a. SAMS-2 UIC/SAMS-I/TDA	2b. UTILIZATION CODE	2c. MCSR	4a. UIC SUPPORT UNIT		4b. SUPPORT UNIT NAME	
SECTION III - EQUIPMENT DATA						
5. TYPE MNT REQ CODE	6. ID	7. NSN 1005012402136	15a. FAILURE DETECTED DURING/WHEN DISCOVERED CODE (Enter code) See DA Pamphlets 738-750 and 738-751			
8. MODEL Rifle 7.62mm			15b. FIRST INDICATION OF TROUBLE/HOW RECOGNIZED CODE (Enter Code) See DA Pamphlets 738-750 and 738-751		16. MILES/KILOMETERS/HOURS/ROUNDS M K	
9. NOUN SNIPER M24					H R	
10a. ORG WON/DOC NO		10b. EIC				
11. SERIAL NUMBER 6587574	12. QTY 00001	13. PD	17. PROJECT CODE (if assigned)	18. ACCOUNT PROCESSING CODE	19. IN WARRANTY? (enter Y or N)	20. ADMIN NO
14. MALFUNCTION DESCRIPTION (for DSU, GSU/AVIM, DEPOT use)			21. REIMBURSABLE CUSTOMER (if Intransit customer enter Y or N)			
			22. LEVEL OF WORK		23. SIGNATURE	
24. DESCRIBE DEFICIENCIES OR SYMPTOMS ON THE BASIS OF COMPLETE CHECKOUT AND DIAGNOSTIC PROCEDURES IN EQUIPMENT TM (Do not prescribe repairs)						
25. REMARKS						
PREPARATION INSTRUCTIONS FOR THIS PAGE						
SECTION I Block 1a. Enter UIC of submitting organization. Block 1b. Enter name of submitting organization. Block 1c. Enter number to be called when maint. is completed. Block 2a. Enter UIC of supporting SAMS-2/SAMS-I/TDA if work is requested while intransit and away from your support maintenance unit. Block 2b. Enter utilization code. See DA Pamphlets 738-750 and 738-751. Block 2c. Enter "Y" if reportable under AR 700-138. If not, leave blank.			SECTION III (Cont'd) Block 12. Enter the quantity of items being submitted. Block 13. Enter the maintenance priority designator determined from DA PAM 710-2-1. Block 14. For DSU, GSU/AVIM, DEPOT use. Block 15a. Enter the code that most accurately describes when the fault or deficiency was detected. See DA Pamphlets 738-750 and 738-751. Block 15b. Select one. Enter the code. See DA Pamphlets 738-750 and 738-751. Block 16. Enter the accumulated usage data in blocks, when equipment is subject to usage reporting. Block 17. Enter the project code if one has been assigned. If not, leave blank. Block 18. See DA Pamphlets 738-750 and 738-751. Block 19. Enter "Y" or "N" to indicate whether equipment is still under manufacturer's warranty. Block 20. Enter the admin number assigned for property control purposes for the equipment being submitted. Block 21. For DSU/GSU/AVIM/Depot use. Block 22. Enter level of work performed "O" for UNIT LEVEL/AVUM, "F" for DSU/AVIM, "H" for GSU, "D" for DEPOT, "K" for contractor or "L" for Spc Rpr Act. Block 23. Enter the signature of the CO or the CO's designated representative when the priority designator is 01-10. For priority designators 11-15, leave blank. Block 24. Enter a brief description of the deficiencies or symptoms that you feel require attention at this level of maint. Block 25. Self-explanatory.			
SECTION II Leave blank. To be completed by the support maintenance DSU/GSU/AVIM/DEPOT.						
SECTION III Block 5. Enter the Type Maintenance Request Code. See DA Pamphlets 738-750 and 738-751. Block 6. Enter ID associated with block 7. See DA Pamphlets 738-750 and 738-751. Block 7. Enter the NSN or stock number of the item being submitted. Block 8. Enter model of item being submitted. Block 9. Enter noun/nomenclature of item being submitted. Block 10a. Enter Work Order Number (WON)/DOC NO assigned when item is submitted. Otherwise, leave blank. Block 10b. Enter End Item Code. See AMDF. Block 11. Enter serial number of item being submitted.						
34a. SUBMITTED BY Bishop, Kendrick	35a. ACCEPTED BY	35c. DATE	Block 34a. Enter first initial and last name of submitter. Block 34b. Enter ordinal date submitted (YYDDD). Block 35a. Enter first initial and last name of person accepting maint. request. Block 35b. Enter the initial status. See DA Pamphlets 738-750 and 738-751. Block 35c. Enter ordinal date accepted (YYDDD). Block 35d. Enter military time.			
34b. DATE	35b. STATUS	35d. TIME				

DA FORM 2407, JUL 94

PREVIOUS EDITIONS OF DA FORM 2407 AND DA FORM 5504 ARE OBSOLETE

RECEIPT COPY 1

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6738638.___0
FILE DATE AND TIME: 05/04/2009 12:52

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

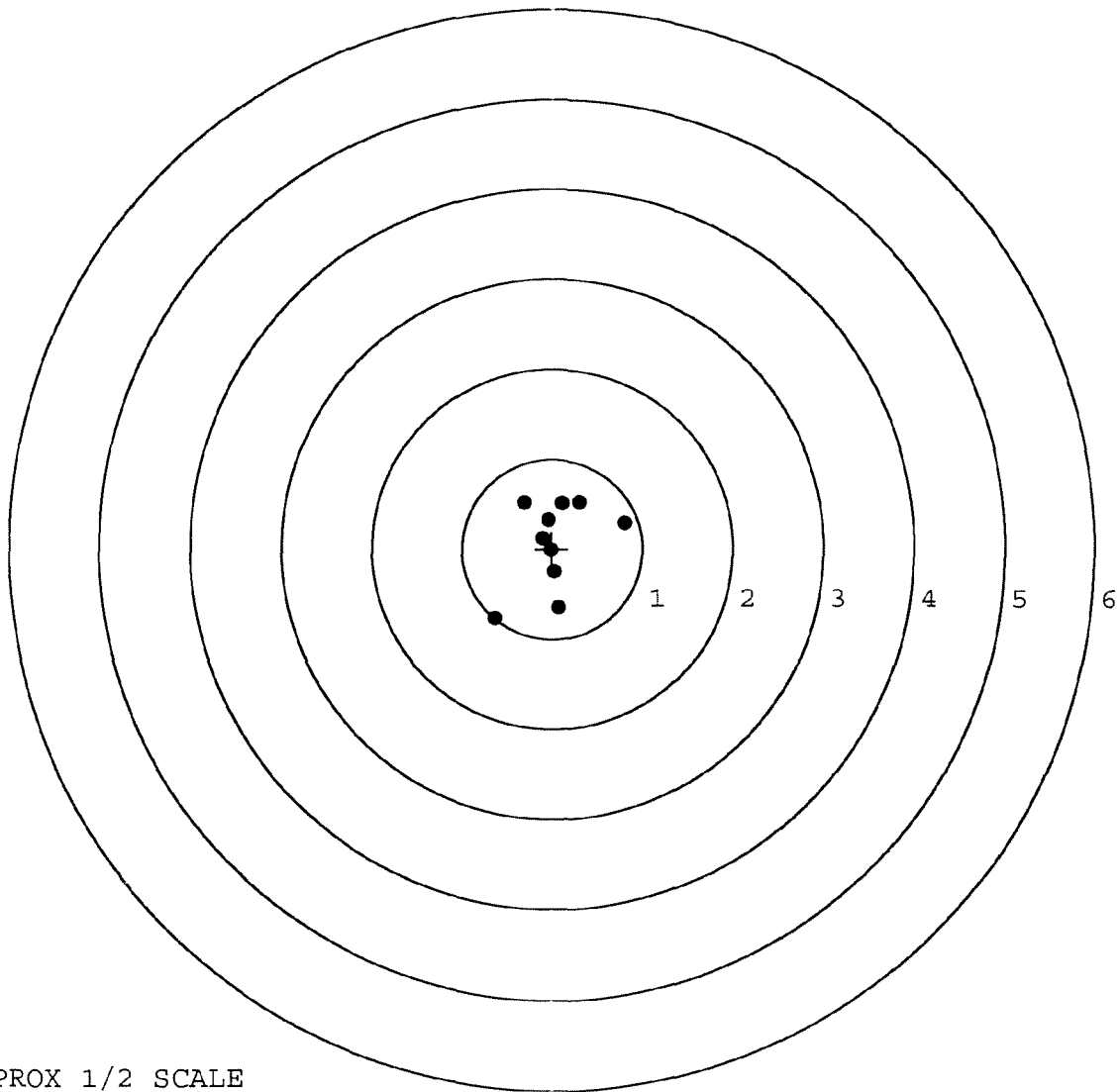
The Average X Centroid of the Five Target Set:	-0.010
The Average Y Centroid of the Five Target Set:	-0.147
The Average Point of Impact of the Five Target Set:	0.148
The Average Mean Radius of the Five Target Set:	0.654
The Distance from POA to Centroid Target #1:	0.063
The Distance from Centroid Target #2 to Centroid Target #1:	0.036
The Distance from Centroid Target #3 to Centroid Target #1:	0.327
The Distance from Centroid Target #4 to Centroid Target #1:	0.238
The Distance from Centroid Target #5 to Centroid Target #1:	0.565

BARBER - M24 0001529

SERIAL NUMBER: G6738638. __0
 TARGET NUMBER: 1
 FILE DATE: 05/04/2009
 FILE TIME: 12:52

POINT#	X	Y
1:	-0.011	-0.014
2:	0.033	-0.255
3:	0.078	-0.655
4:	-0.635	-0.775
5:	-0.102	0.119
6:	-0.044	0.321
7:	-0.312	0.516
8:	0.114	0.511
9:	0.304	0.524
10:	0.803	0.293

X CENTROID: 0.023
 Y CENTROID: 0.059
 POA TO CENTROID: 0.063
 HORZ SPREAD: 1.438
 VERT SPREAD: 1.299
 GROUP SPREAD: 1.791
 MIN RADIUS: 0.080
 MAX RADIUS: 1.062
 MEAN RADIUS: 0.497
 # IN 1 IN DIAMETER: 5
 # IN 2 IN DIAMETER: 9
 # in 3 IN DIAMETER: 10



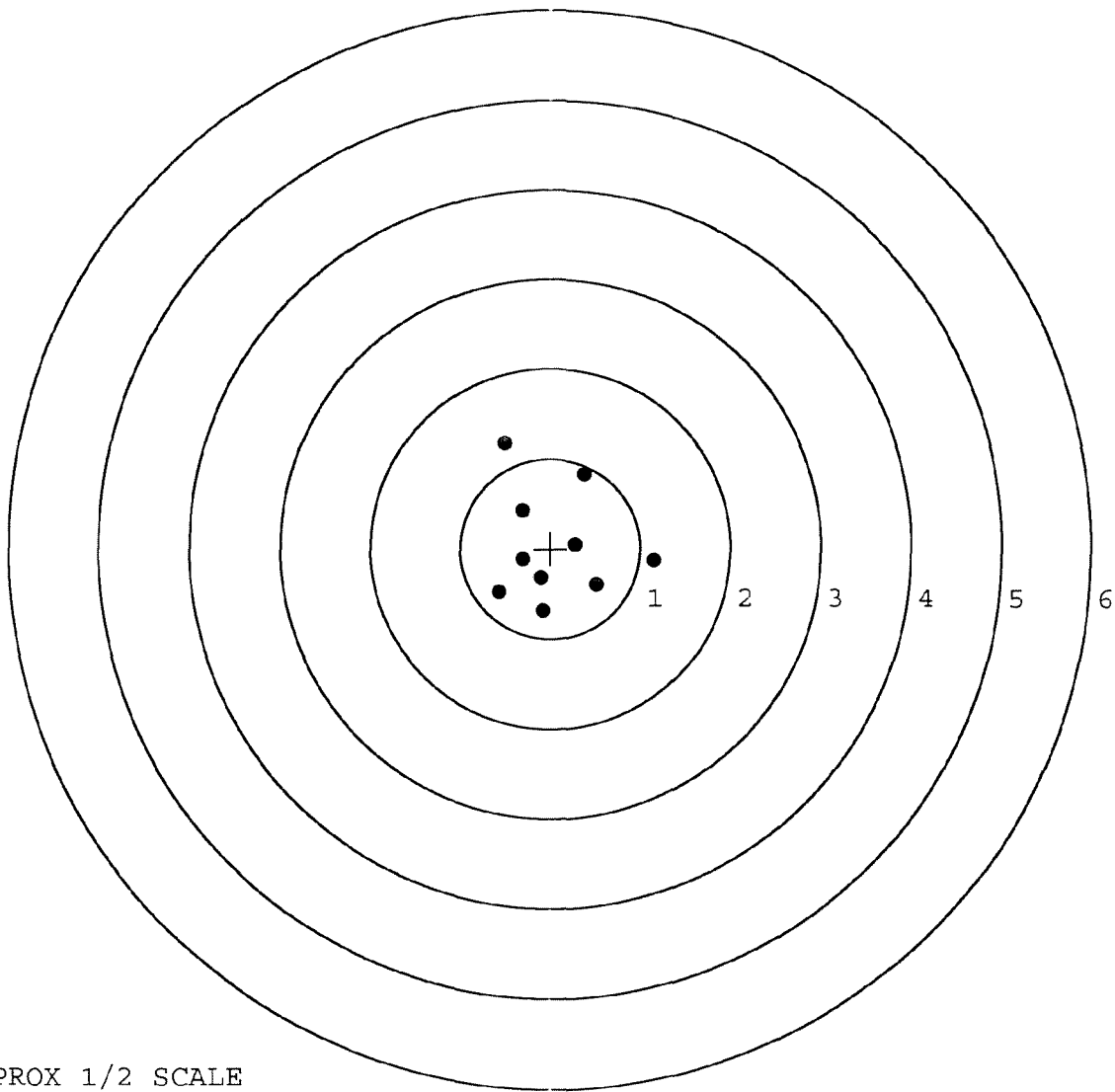
TARGET APPROX 1/2 SCALE

BARBER - M24 0001530

SERIAL NUMBER: G6738638. __0
 TARGET NUMBER: 2
 FILE DATE: 05/04/2009
 FILE TIME: 12:52

POINT#	X	Y
1:	1.154	-0.139
2:	0.519	-0.405
3:	-0.084	-0.695
4:	-0.573	-0.491
5:	-0.102	-0.327
6:	-0.306	-0.124
7:	0.278	0.050
8:	-0.313	0.422
9:	0.384	0.832
10:	-0.510	1.172

X CENTROID: 0.045
 Y CENTROID: 0.029
 POA TO CENTROID: 0.054
 HORZ SPREAD: 1.727
 VERT SPREAD: 1.867
 GROUP SPREAD: 2.118
 MIN RADIUS: 0.234
 MAX RADIUS: 1.270
 MEAN RADIUS: 0.698
 # IN 1 IN DIAMETER: 3
 # IN 2 IN DIAMETER: 8
 # in 3 IN DIAMETER: 10



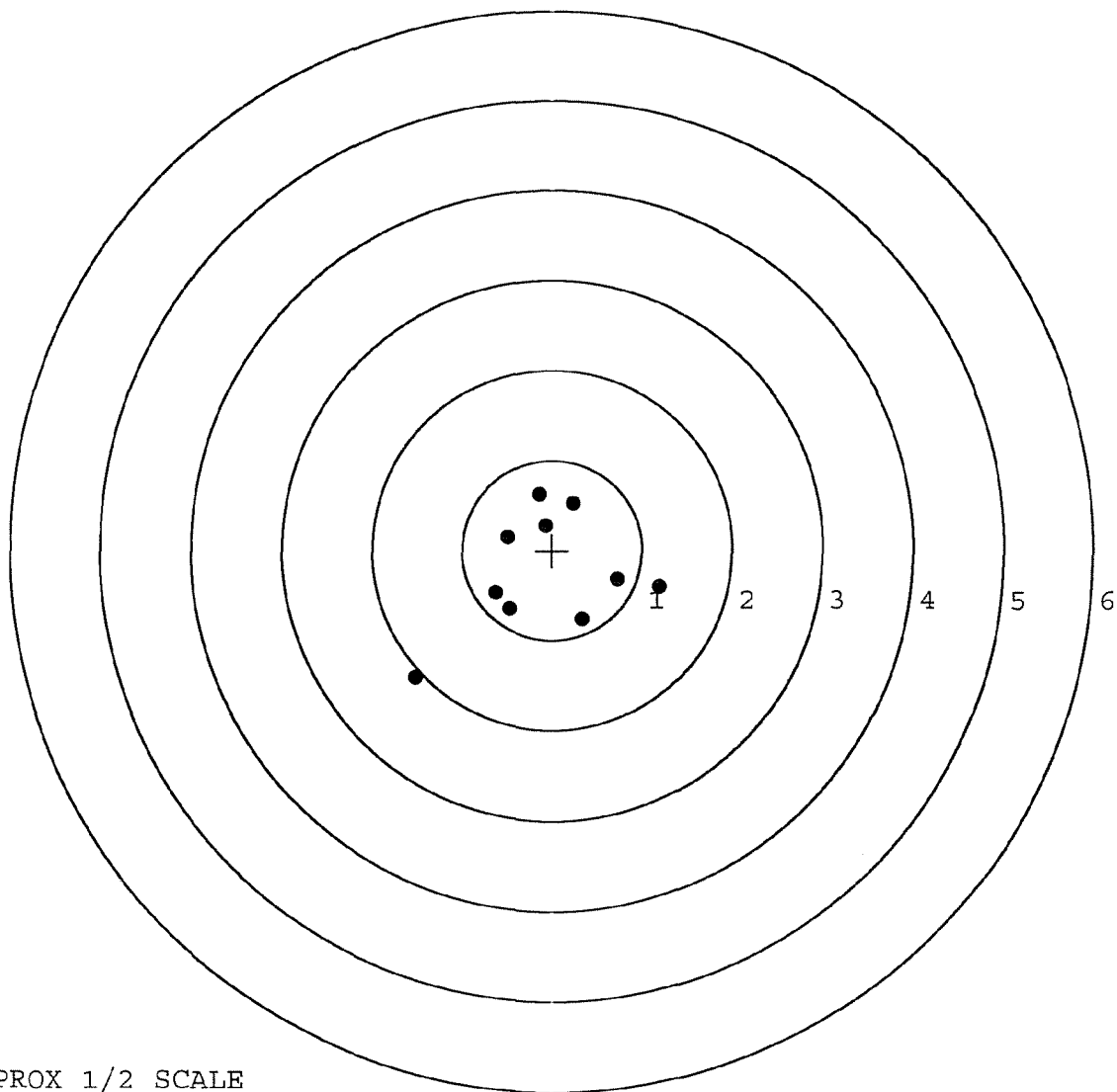
TARGET APPROX 1/2 SCALE

BARBER - M24 0001531

SERIAL NUMBER: G6738638. __0
 TARGET NUMBER: 3
 FILE DATE: 05/04/2009
 FILE TIME: 12:52

POINT#	X	Y
1:	0.237	0.526
2:	-0.078	0.274
3:	-0.146	0.625
4:	-0.471	-0.656
5:	-0.623	-0.477
6:	-0.497	0.141
7:	-1.522	-1.432
8:	0.336	-0.773
9:	0.730	-0.325
10:	1.198	-0.413

X CENTROID: -0.084
 Y CENTROID: -0.251
 POA TO CENTROID: 0.265
 HORZ SPREAD: 2.720
 VERT SPREAD: 2.057
 GROUP SPREAD: 2.905
 MIN RADIUS: 0.525
 MAX RADIUS: 1.861
 MEAN RADIUS: 0.860
 # IN 1 IN DIAMETER: 0
 # IN 2 IN DIAMETER: 8
 # in 3 IN DIAMETER: 9



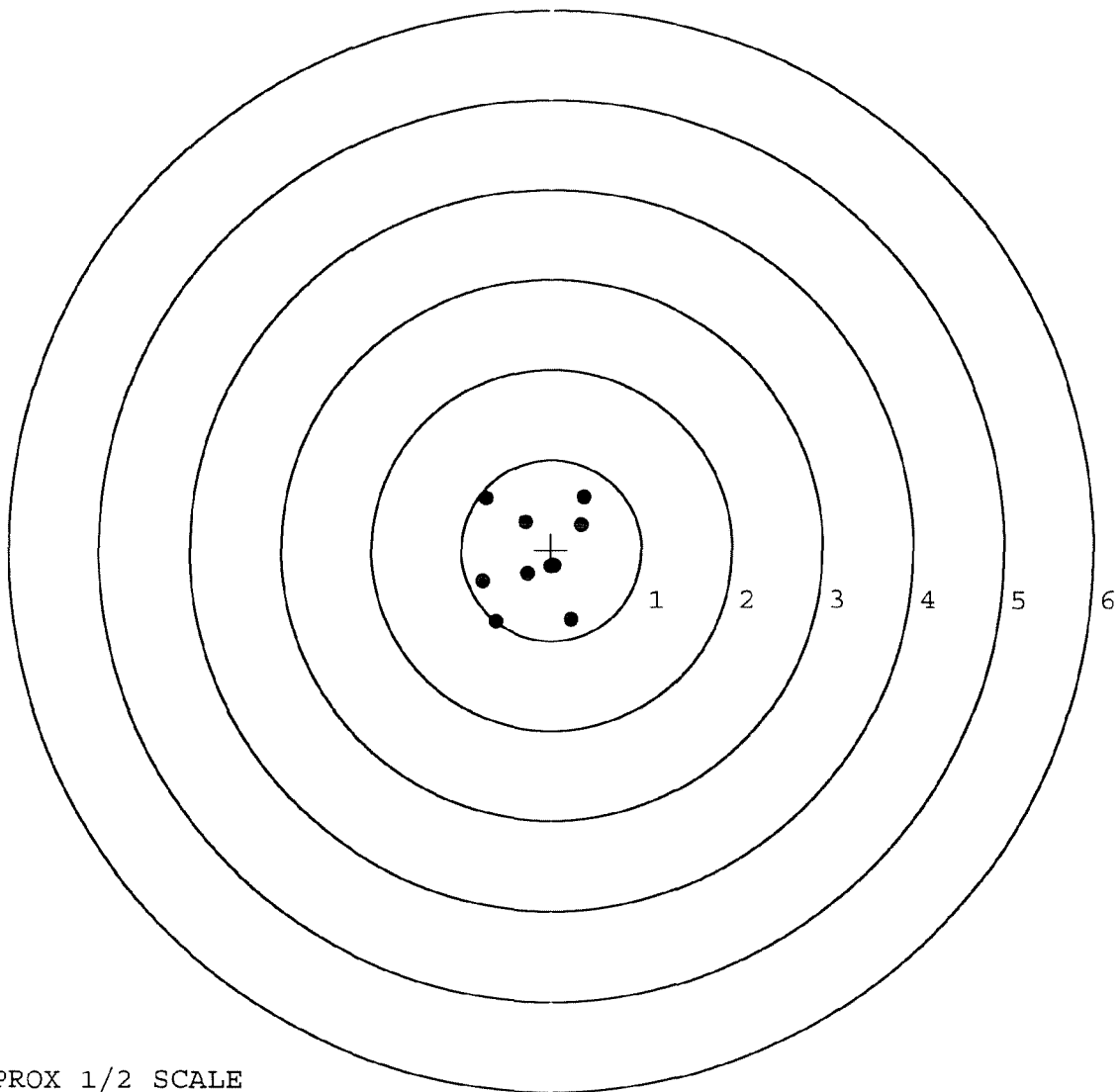
TARGET APPROX 1/2 SCALE

BARBER - M24 0001532

SERIAL NUMBER: G6738638. 0
 TARGET NUMBER: 4
 FILE DATE: 05/04/2009
 FILE TIME: 12:52

POINT#	X	Y
1:	0.331	0.276
2:	0.366	0.593
3:	-0.293	0.310
4:	-0.730	0.570
5:	-0.765	-0.356
6:	-0.261	-0.266
7:	0.000	-0.183
8:	0.035	-0.175
9:	0.223	-0.771
10:	-0.617	-0.798

X CENTROID: -0.171
 Y CENTROID: -0.080
 POA TO CENTROID: 0.189
 HORZ SPREAD: 1.131
 VERT SPREAD: 1.391
 GROUP SPREAD: 1.703
 MIN RADIUS: 0.200
 MAX RADIUS: 0.861
 MEAN RADIUS: 0.567
 # IN 1 IN DIAMETER: 4
 # IN 2 IN DIAMETER: 10
 # in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

BARBER - M24 0001533

SERIAL NUMBER: G6738638. __0

TARGET NUMBER: 5

FILE DATE: 05/04/2009

FILE TIME: 12:52

POINT#	X	Y
1:	0.311	0.171
2:	0.065	-0.078
3:	-0.112	0.261
4:	-0.413	-0.259
5:	-0.348	-0.998
6:	-0.555	-0.812
7:	0.344	-1.156
8:	0.769	-0.703
9:	1.180	-0.809
10:	0.126	-0.562

X CENTROID: 0.137

Y CENTROID: -0.494

POA TO CENTROID: 0.513

HORZ SPREAD: 1.735

VERT SPREAD: 1.417

GROUP SPREAD: 1.735

MIN RADIUS: 0.068

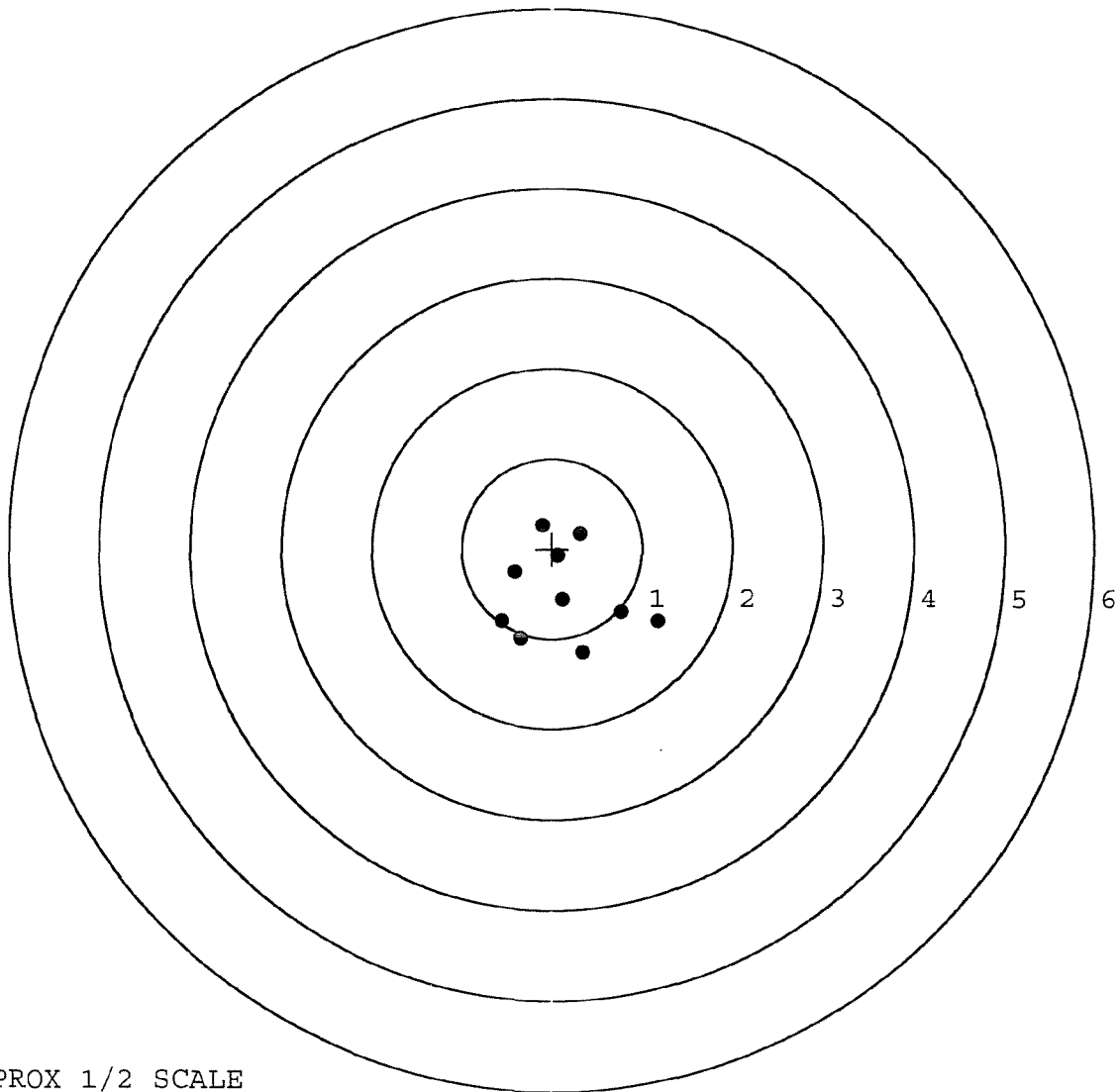
MAX RADIUS: 1.090

MEAN RADIUS: 0.648

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

Repair Inquiry

Repair Number: RE00100608

Serial: C6587574 Model: M24 SWS Center Fire
Caliber: 7.62 NATO

Repairman:

Verify Repair

Status:

Closed 9/6/2005 1:50:42 PM

Address Information

Customer: ☒ Received From Return To ☒ Received From

Name: MATERIAL MOVEMENT SECTION MATERIAL MOVEMENT SECTION

Address 1: BLDG 9630 BLDG 9630

Address 2: RAINIER AVE P.O. Box: RAINIER AVE P.O. Box

City: FORT LEWIS FORT LEWIS

State: WA Zip Code: 98433 Country: US State: WA Zip Code: 98433 Country: US

FPL:

Contact / Condition

Problems

Estimate

History / Status

Shipping / Billing

Contact Information

Phone: NA

Fax:

Email:

Comments:

Received Condition

Fair

Condition
Notes:CSR
Notes:

Accessories Received

Code	Desc	Qty
A007	With Studs	3
A010	Hard Case	1
A017	Scope Base	1
A026	Scope w/Case	1
A057	Fit and Rear Sgt Base	2

Repair Search

Refresh

Close

logoff

9/6/2005

1:53 PM

CAPS

NUM

INS

SCAL

start

5

2

5

Arms Services

Serial Number: C6587574

Model: M24 SWS

RE00100608

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6587574.__1
FILE DATE AND TIME: 09/20/2005 11:19

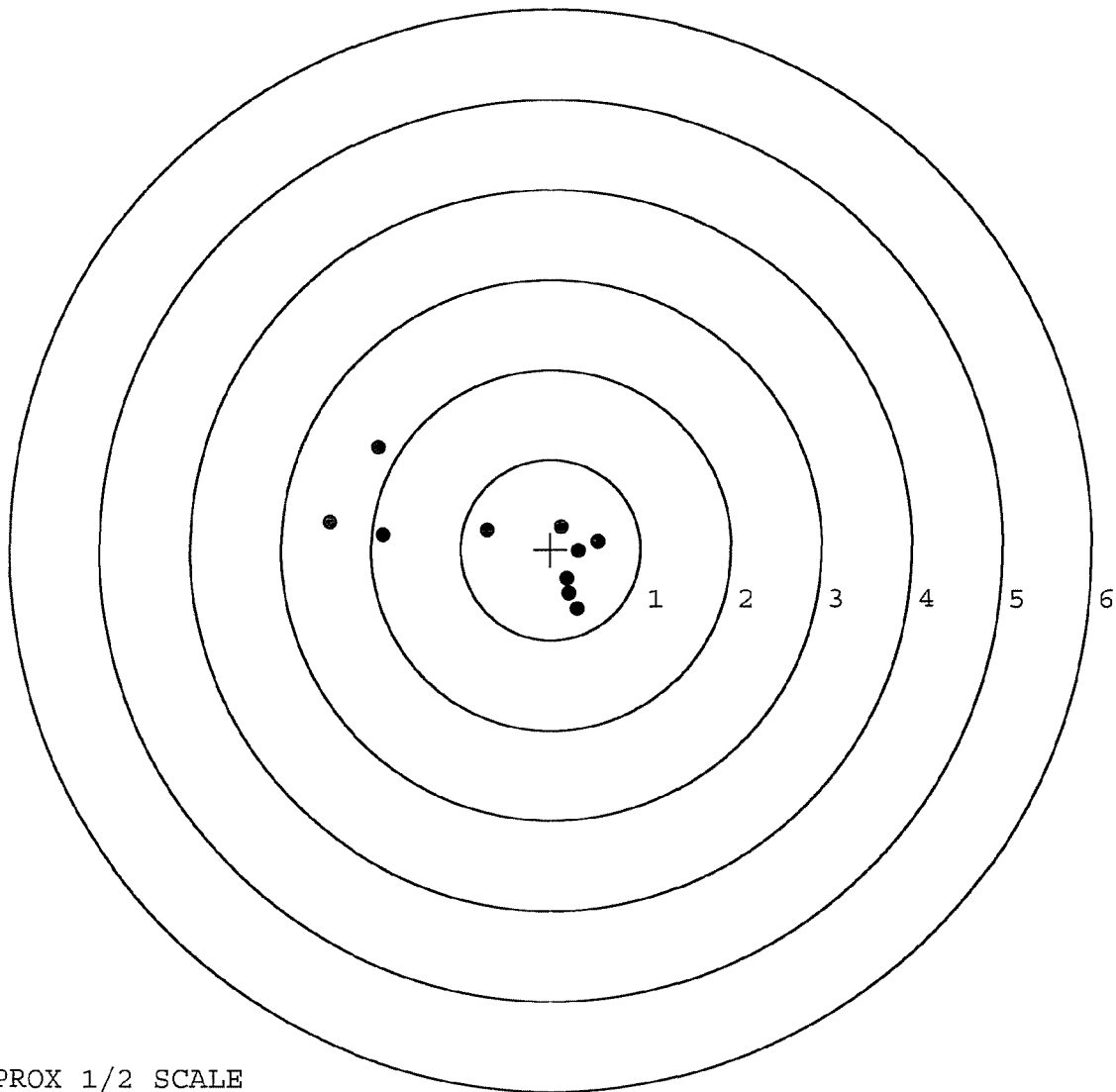
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.000
The Average Y Centroid of the Five Target Set:	0.015
The Average Point of Impact of the Five Target Set:	0.015
The Average Mean Radius of the Five Target Set:	0.947
The Distance from POA to Centroid Target #1:	0.538
The Distance from Centroid Target #2 to Centroid Target #1:	0.796
The Distance from Centroid Target #3 to Centroid Target #1:	0.600
The Distance from Centroid Target #4 to Centroid Target #1:	0.568
The Distance from Centroid Target #5 to Centroid Target #1:	0.746

SERIAL NUMBER: C6587574. __1
 TARGET NUMBER: 1
 FILE DATE: 09/20/2005
 FILE TIME: 11:19

POINT#	X	Y
1:	0.300	-0.666
2:	0.205	-0.493
3:	0.185	-0.328
4:	0.523	0.084
5:	0.308	-0.022
6:	0.117	0.249
7:	-0.719	0.208
8:	-1.876	0.157
9:	-2.466	0.291
10:	-1.922	1.132

X CENTROID: -0.535
 Y CENTROID: 0.061
 POA TO CENTROID: 0.538
 HORZ SPREAD: 2.989
 VERT SPREAD: 1.798
 GROUP SPREAD: 2.996
 MIN RADIUS: 0.236
 MAX RADIUS: 1.945
 MEAN RADIUS: 1.071
 # IN 1 IN DIAMETER: 1
 # IN 2 IN DIAMETER: 5
 # in 3 IN DIAMETER: 8



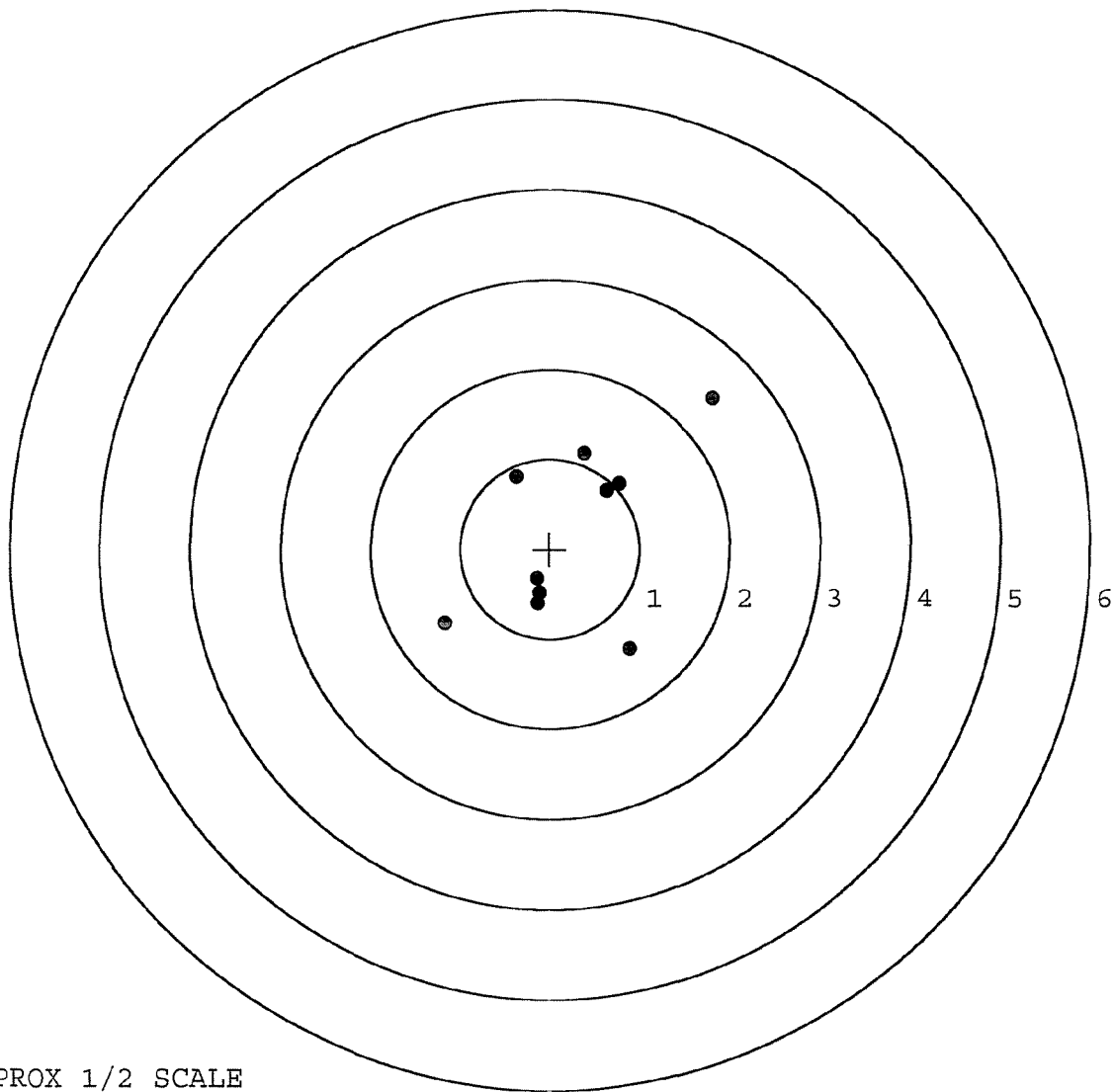
TARGET APPROX 1/2 SCALE

BARBER - M24 0001537

SERIAL NUMBER: C6587574. __1
 TARGET NUMBER: 2
 FILE DATE: 09/20/2005
 FILE TIME: 11:19

POINT#	X	Y
1:	0.891	-1.116
2:	-0.135	-0.601
3:	-0.116	-0.493
4:	-0.142	-0.328
5:	-1.168	-0.831
6:	0.777	0.721
7:	0.639	0.650
8:	0.386	1.065
9:	-0.372	0.806
10:	1.803	1.675

X CENTROID: 0.256
 Y CENTROID: 0.155
 POA TO CENTROID: 0.299
 HORZ SPREAD: 2.971
 VERT SPREAD: 2.791
 GROUP SPREAD: 3.887
 MIN RADIUS: 0.626
 MAX RADIUS: 2.169
 MEAN RADIUS: 1.076
 # IN 1 IN DIAMETER: 0
 # IN 2 IN DIAMETER: 7
 # in 3 IN DIAMETER: 8



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6587574. __1

TARGET NUMBER: 3

FILE DATE: 09/20/2005

FILE TIME: 11:19

POINT#	X	Y
1:	0.682	-0.270
2:	0.498	-0.180
3:	0.512	0.076
4:	0.367	-0.946
5:	0.155	-0.602
6:	-0.024	0.526
7:	-0.188	0.154
8:	-0.603	0.326
9:	-0.497	-0.116
10:	-0.409	0.274

X CENTROID: 0.049

Y CENTROID: -0.076

POA TO CENTROID: 0.090

HORZ SPREAD: 1.285

VERT SPREAD: 1.472

GROUP SPREAD: 1.600

MIN RADIUS: 0.330

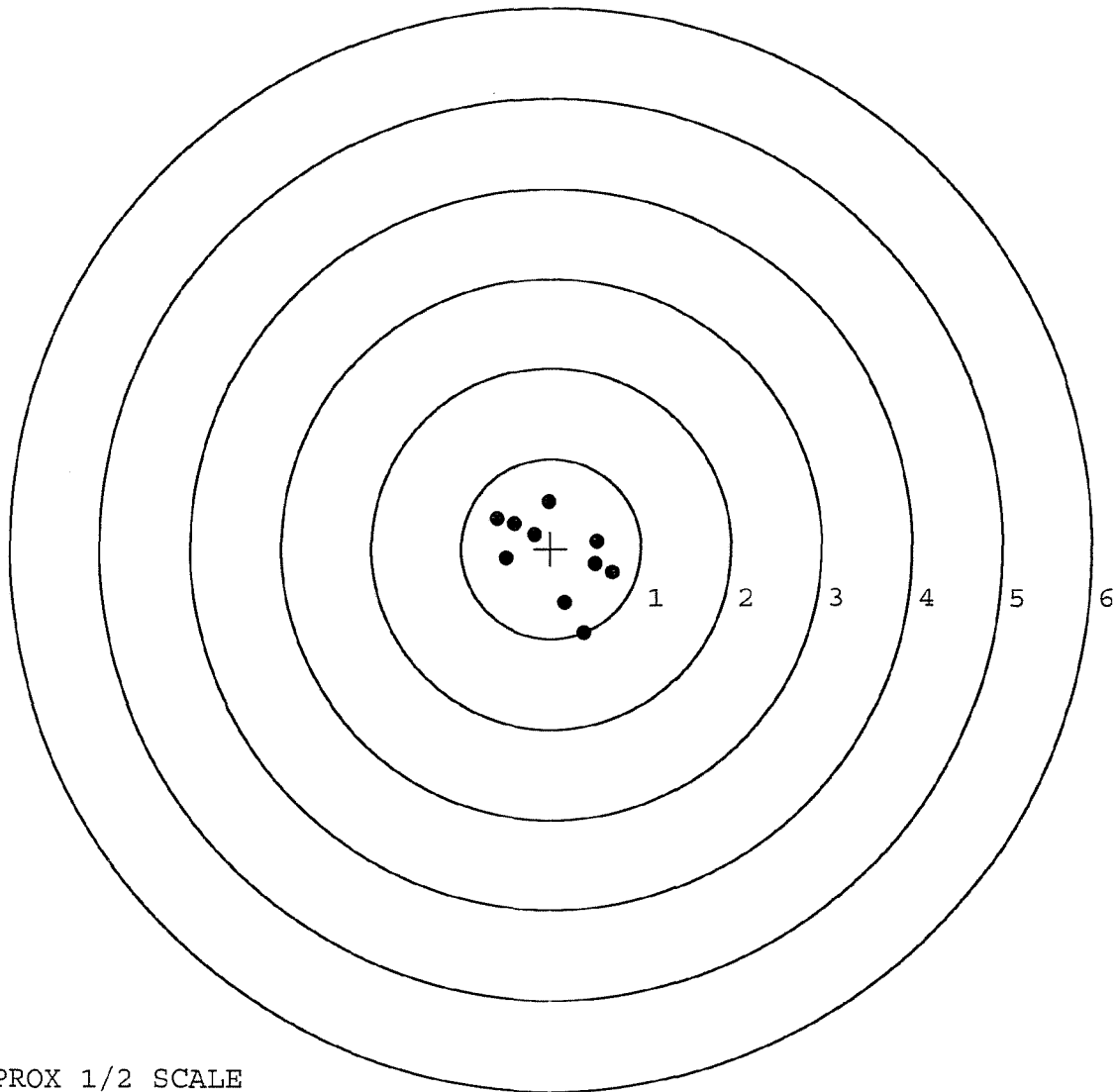
MAX RADIUS: 0.926

MEAN RADIUS: 0.590

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10

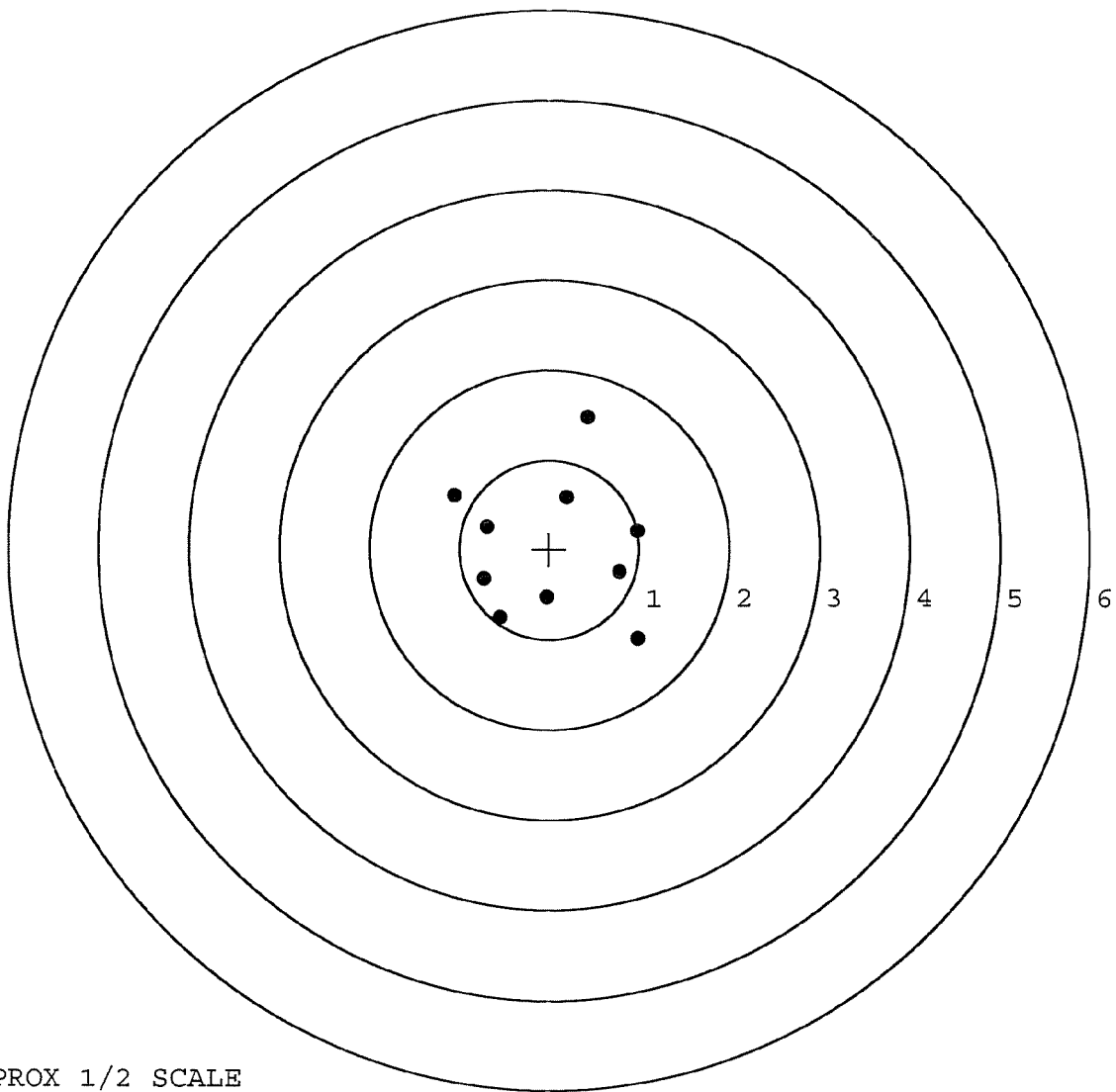


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6587574. __1
 TARGET NUMBER: 4
 FILE DATE: 09/20/2005
 FILE TIME: 11:19

POINT#	X	Y
1:	0.988	-0.995
2:	0.783	-0.259
3:	0.982	0.202
4:	0.432	1.476
5:	0.194	0.581
6:	-0.027	-0.539
7:	-0.551	-0.763
8:	-0.728	-0.338
9:	-0.700	0.248
10:	-1.056	0.603

X CENTROID: 0.032
 Y CENTROID: 0.022
 POA TO CENTROID: 0.038
 HORZ SPREAD: 2.044
 VERT SPREAD: 2.471
 GROUP SPREAD: 2.533
 MIN RADIUS: 0.564
 MAX RADIUS: 1.508
 MEAN RADIUS: 0.964
 # IN 1 IN DIAMETER: 0
 # IN 2 IN DIAMETER: 7
 # in 3 IN DIAMETER: 9



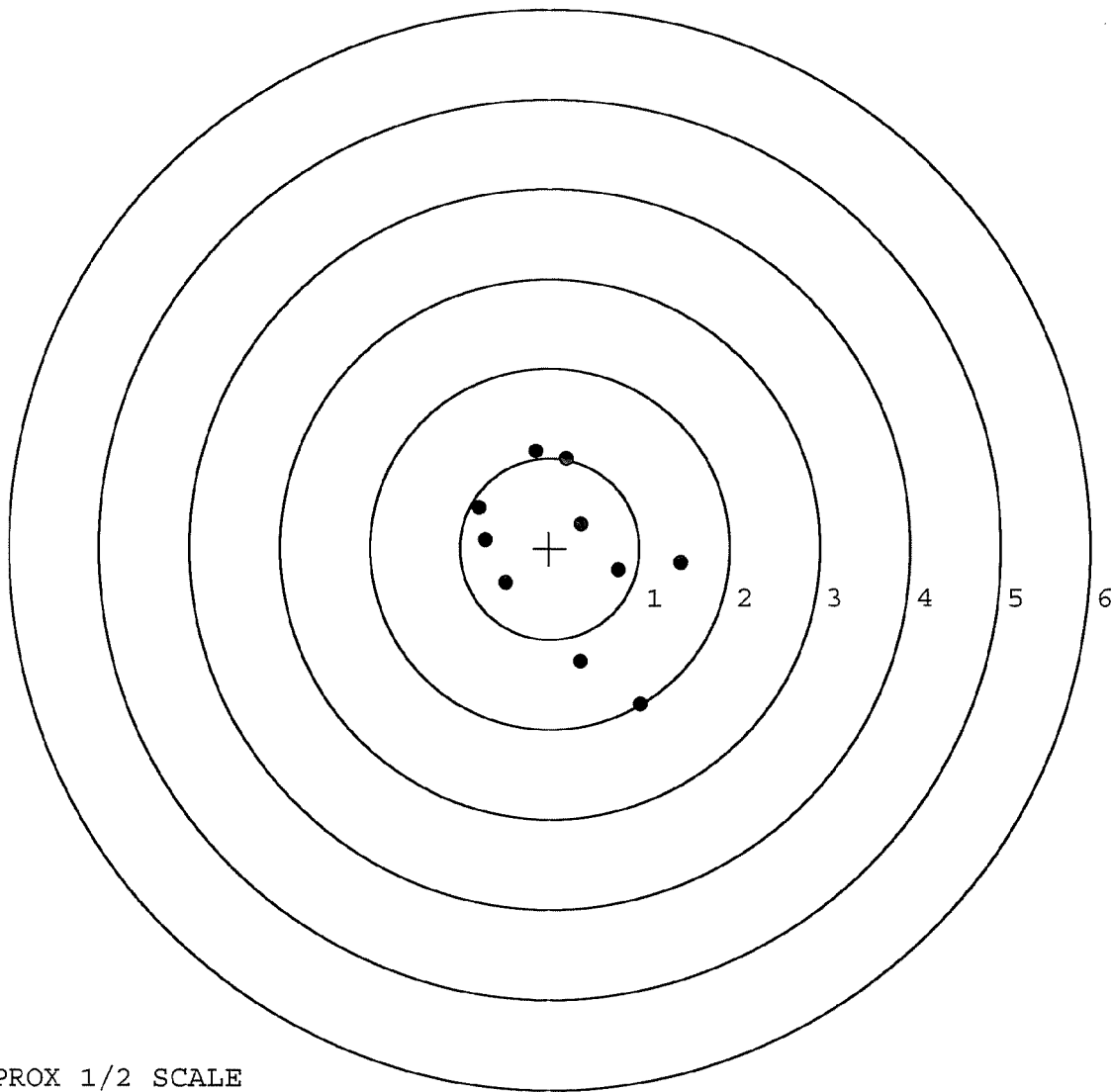
TARGET APPROX 1/2 SCALE

BARBER - M24 0001540

SERIAL NUMBER: C6587574. __1
 TARGET NUMBER: 5
 FILE DATE: 09/20/2005
 FILE TIME: 11:19

POINT#	X	Y
1:	1.013	-1.727
2:	0.345	-1.248
3:	0.765	-0.244
4:	1.460	-0.160
5:	0.353	0.270
6:	0.190	0.999
7:	-0.158	1.080
8:	-0.792	0.448
9:	-0.719	0.097
10:	-0.492	-0.385

X CENTROID: 0.196
 Y CENTROID: -0.087
 POA TO CENTROID: 0.215
 HORZ SPREAD: 2.252
 VERT SPREAD: 2.807
 GROUP SPREAD: 3.041
 MIN RADIUS: 0.390
 MAX RADIUS: 1.832
 MEAN RADIUS: 1.036
 # IN 1 IN DIAMETER: 1
 # IN 2 IN DIAMETER: 4
 # in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

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

R & E NUMBER	100608		
SERIAL NUMBER	06587374		
LOG-IN DATE	9-6-05		
INSPECT AND VERIFY:			
OPERATION #	OPERATION NAME	DATE	INITIAL
550	DIS-ASSEMBLE GUN	9-7-05	RTJ
560 A	RE-BARREL	9-8-05	RTJ
B	DRILL AND TAP	9-12-05	TRW
575	ASSEMBLE	9-8-05	RTJ
600	PROOF	9-8-05	RTJ
605	CHECK HEADSPACE	9-8-05	RTJ
610	DIS-ASSEMBLE GUN	9-9-05	RTJ
612	MAGNAFLUX	9-12-05	WMS
615	ROLLMARK CALIBER	9-12-05	CW
618	ROTO-BLAST	9-13-05	LB
620	APPLY COATINGS	9-14-05	RTJ
625 A	FINAL ASSEMBLY	9-15-05	RTJ
B	TRIGGER PULL TEST		
C	SAFETY "ON" FORCE	9-21-05	Ac
D	SAFETY "OFF" FORCE	9-21-05	Ac
E	FIRING PIN INDENT	9-21-05	Ac
640	TARGET	9-20-05	TRW
655	FINAL INSPECT	9-21-05	Ac
660	PACK	9-22-05	RA
		SHIP DATE	
QAR INSPECTION DATE			

Arm BARBER M24 0001542 System

File Add Repair Estimate Repair Expedite Repair Inquiry Repair Tools CSR Tools Reports Table Maintenance System Maintenance Help

Repair Inquiry

Repair Number: **RE00069393** Serial: C6587574 Model 700 Center Fire Caliber: 7 Repairman:
 Verify Repair 62 NATO M/24 SWS Status: New 9/2/2003 6:50:49 AM

Address Information

Customer: ☒ Received From Return To: ☐ Received From

Name: **HHC 5-20 IN SNIPER SECTION** **HHC 5-20 IN SNIPER SECTION**

Address 1: **SSG HORTON CHRIS** **SSG HORTON CHRIS**

Address 2: PO Box: 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 1800 Fax: Email: Comments:	Received Condition Good Condition Notes: CSR Notes:	Accessories Received <table border="1"> <thead> <tr> <th>Code</th> <th>Desc</th> <th>Qty</th> </tr> </thead> <tbody> <tr> <td>A007</td> <td>With Stud</td> <td>3</td> </tr> <tr> <td>A010</td> <td>Hard Case</td> <td>1</td> </tr> <tr> <td>A017</td> <td>Scope Base</td> <td>1</td> </tr> <tr> <td>A026</td> <td>Scope</td> <td>1</td> </tr> <tr> <td>C000</td> <td>FRT AND REAR BASI</td> <td>1</td> </tr> <tr> <td>C001</td> <td>DEPLOYMENT CASE</td> <td>1</td> </tr> <tr> <td>C002</td> <td>SCOPE CASE</td> <td>1</td> </tr> </tbody> </table>			Code	Desc	Qty	A007	With Stud	3	A010	Hard Case	1	A017	Scope Base	1	A026	Scope	1	C000	FRT AND REAR BASI	1	C001	DEPLOYMENT CASE	1	C002	SCOPE CASE	1
Code	Desc	Qty																										
A007	With Stud	3																										
A010	Hard Case	1																										
A017	Scope Base	1																										
A026	Scope	1																										
C000	FRT AND REAR BASI	1																										
C001	DEPLOYMENT CASE	1																										
C002	SCOPE CASE	1																										

Repair Search **Refresh** **Close**

nagletj 9/2/2003 7:32 AM CAPS NUM INS SCRL

start 3 Icons Part Search My E-File Arms Servi... 2 Icons 7:32 AM

Serial Number: **C6587574**

Model: **700**



RE00069393

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6587574.___0

FILE DATE AND TIME: 09/17/2003 06:45

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.007
The Average Y Centroid of the Five Target Set:	-0.008
The Average Point of Impact of the Five Target Set:	0.011
The Average Mean Radius of the Five Target Set:	0.655
The Distance from POA to Centroid Target #1:	0.205
The Distance from Centroid Target #2 to Centroid Target #1:	0.209
The Distance from Centroid Target #3 to Centroid Target #1:	0.277
The Distance from Centroid Target #4 to Centroid Target #1:	0.263
The Distance from Centroid Target #5 to Centroid Target #1:	0.311

BARBER - M24 0001544

SERIAL NUMBER: C6587574. __0

TARGET NUMBER: 1

FILE DATE: 09/17/2003

FILE TIME: 06:45

X CENTROID: -0.129

Y CENTROID: 0.159

POA TO CENTROID: 0.205

HORZ SPREAD: 1.761

VERT SPREAD: 1.300

GROUP SPREAD: 2.159

MIN RADIUS: 0.169

MAX RADIUS: 1.303

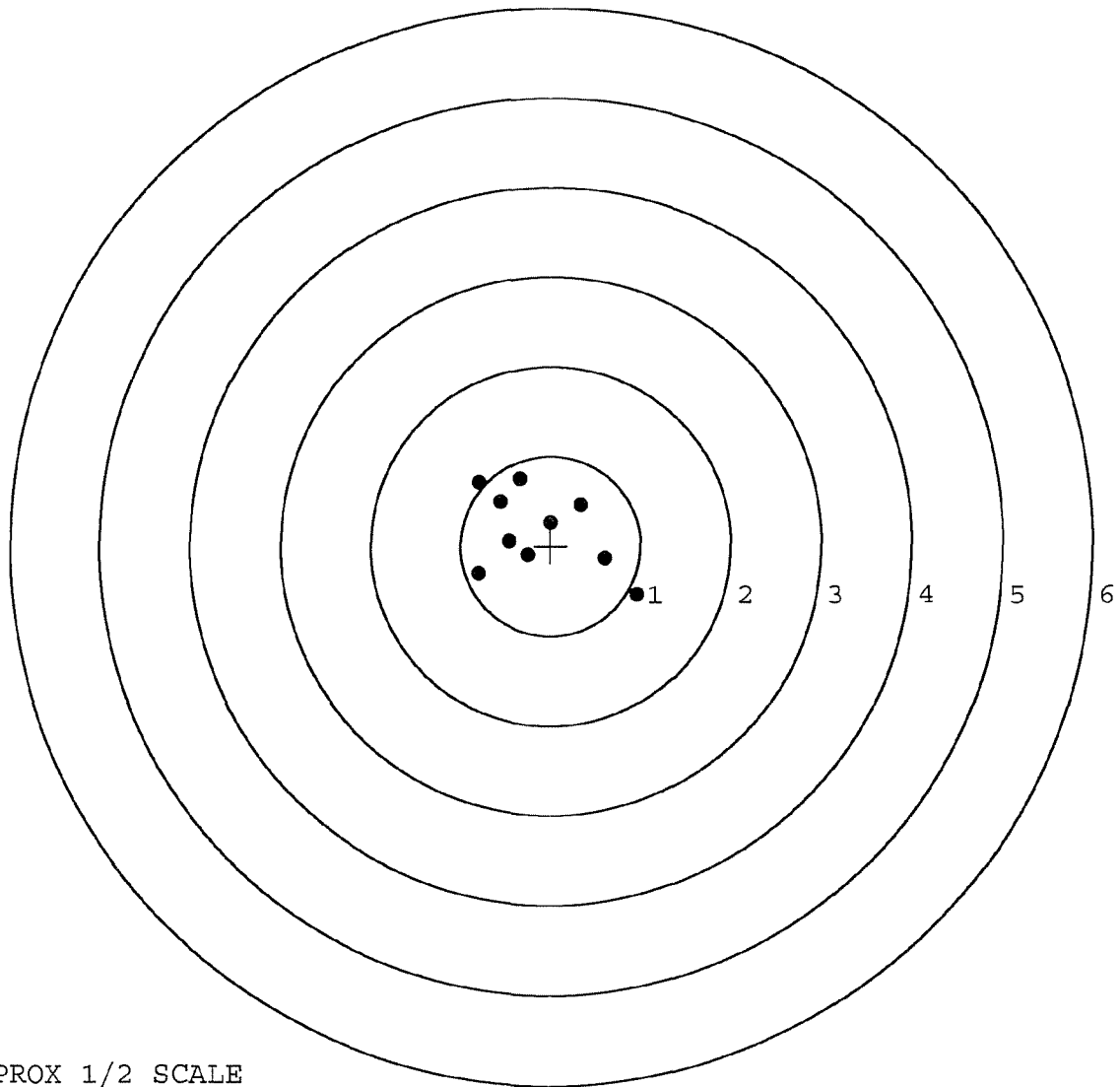
MEAN RADIUS: 0.631

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.962	-0.553
2:	0.612	-0.146
3:	0.338	0.458
4:	-0.799	-0.317
5:	-0.251	-0.101
6:	-0.462	0.047
7:	0.003	0.264
8:	-0.341	0.747
9:	-0.796	0.701
10:	-0.556	0.487



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6587574. __0

TARGET NUMBER: 2

FILE DATE: 09/17/2003

FILE TIME: 06:45

POINT#	X	Y
1:	0.362	-0.330
2:	0.452	-0.195
3:	-0.539	0.351
4:	-0.197	-0.401
5:	-0.342	-0.692
6:	-0.491	-0.506
7:	-0.542	-0.373
8:	0.260	0.508
9:	0.457	0.760
10:	0.036	0.513

X CENTROID: -0.054

Y CENTROID: -0.037

POA TO CENTROID: 0.066

HORZ SPREAD: 0.999

VERT SPREAD: 1.452

GROUP SPREAD: 1.657

MIN RADIUS: 0.391

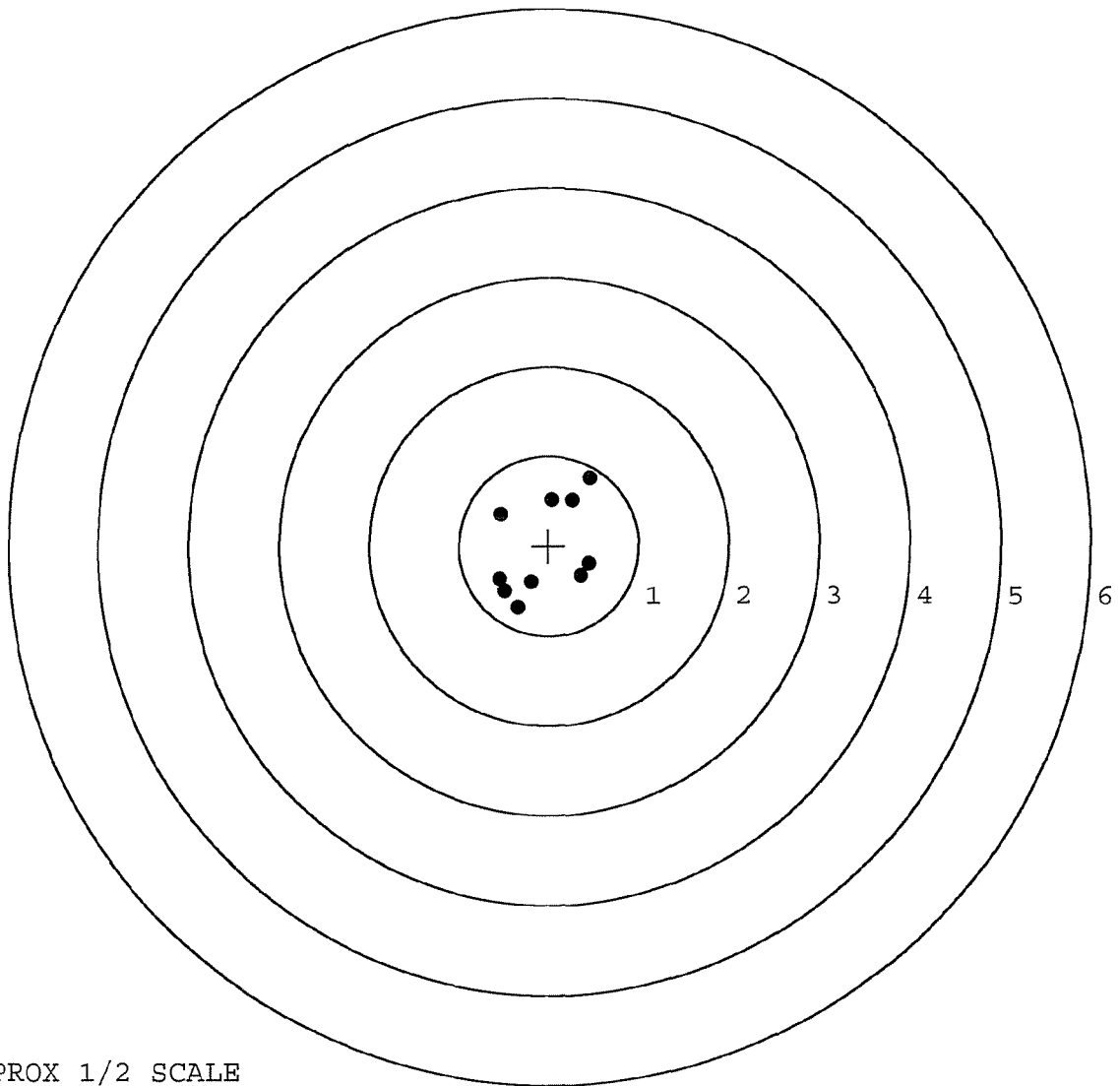
MAX RADIUS: 0.947

MEAN RADIUS: 0.613

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10

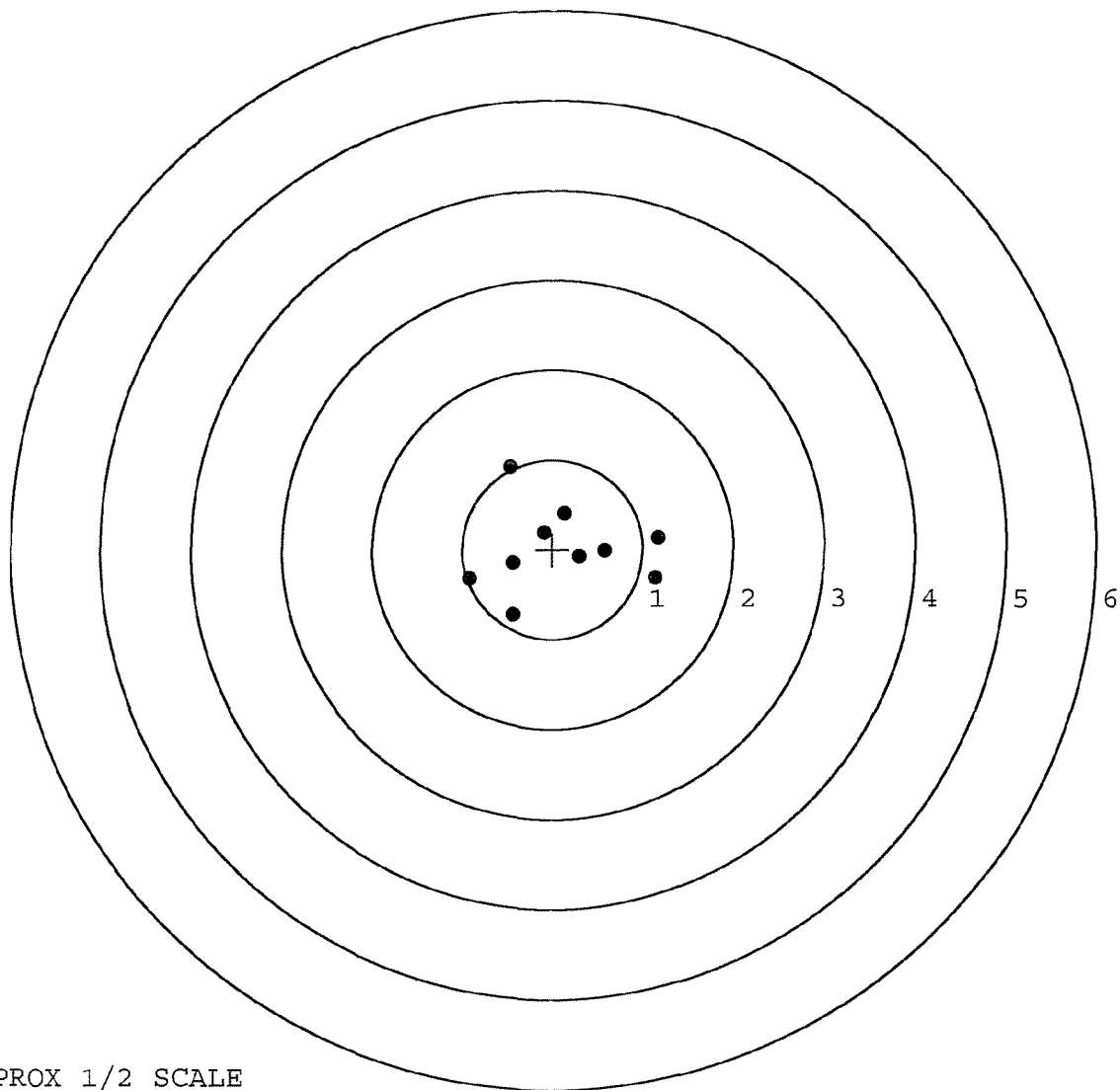


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6587574. __0
 TARGET NUMBER: 3
 FILE DATE: 09/17/2003
 FILE TIME: 06:45

POINT#	X	Y
1:	1.143	-0.321
2:	1.168	0.129
3:	0.582	-0.015
4:	0.302	-0.081
5:	-0.473	0.914
6:	0.136	0.404
7:	-0.095	0.188
8:	-0.438	-0.159
9:	-0.916	-0.334
10:	-0.437	-0.738

X CENTROID: 0.097
 Y CENTROID: -0.001
 POA TO CENTROID: 0.097
 HORZ SPREAD: 2.084
 VERT SPREAD: 1.652
 GROUP SPREAD: 2.059
 MIN RADIUS: 0.220
 MAX RADIUS: 1.094
 MEAN RADIUS: 0.717
 # IN 1 IN DIAMETER: 4
 # IN 2 IN DIAMETER: 6
 # in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

BARBER - M24 0001547

SERIAL NUMBER: C6587574. __0

TARGET NUMBER: 4

FILE DATE: 09/17/2003

FILE TIME: 06:45

POINT#	X	Y
1:	0.353	-1.031
2:	0.204	-0.778
3:	0.635	0.052
4:	0.878	0.317
5:	0.035	-0.013
6:	-0.425	-0.361
7:	-0.827	0.037
8:	-0.302	0.420
9:	0.008	-0.043
10:	-0.115	1.010

X CENTROID: 0.044

Y CENTROID: -0.039

POA TO CENTROID: 0.059

HORZ SPREAD: 1.705

VERT SPREAD: 2.041

GROUP SPREAD: 2.094

MIN RADIUS: 0.028

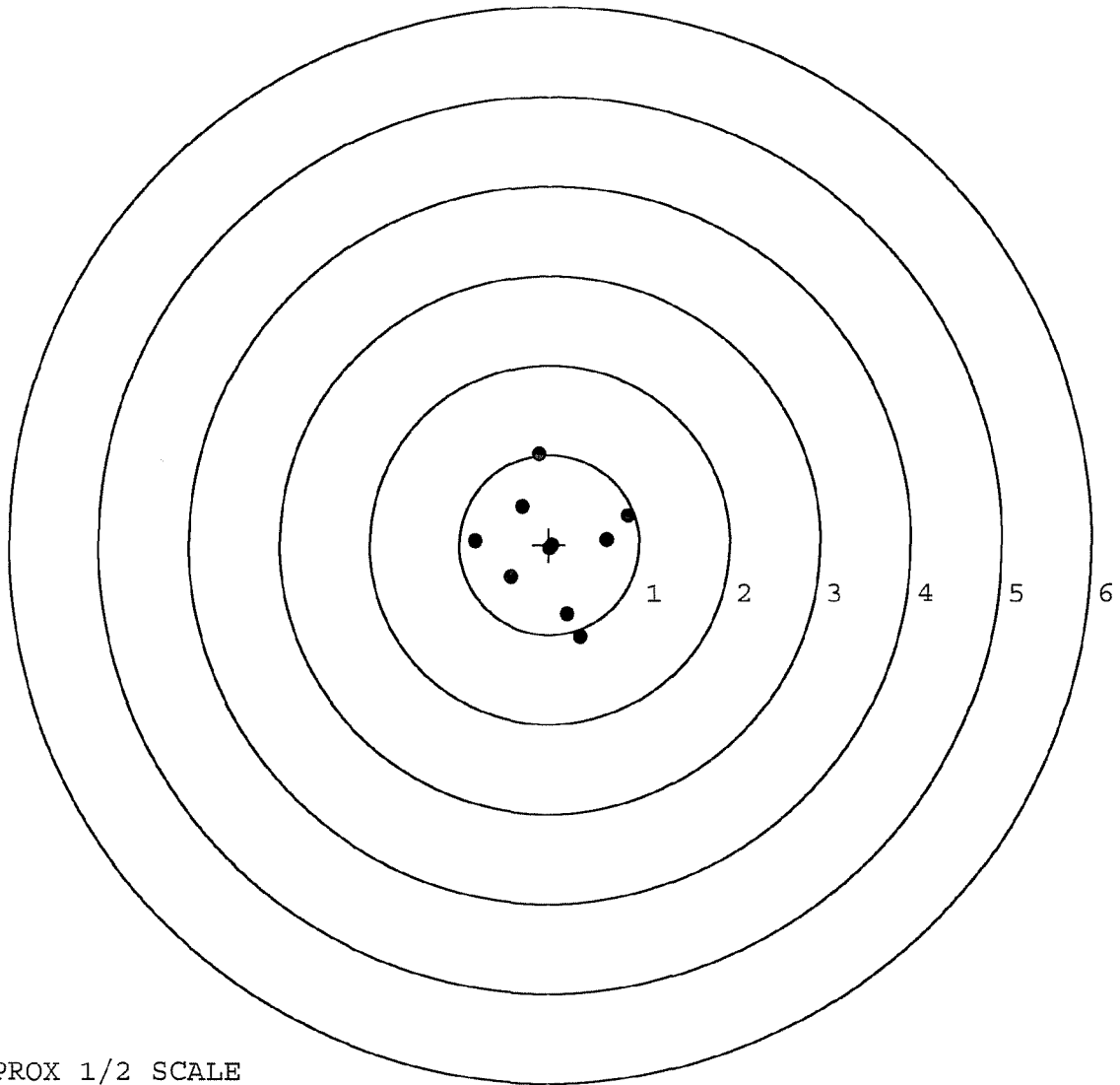
MAX RADIUS: 1.061

MEAN RADIUS: 0.644

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10



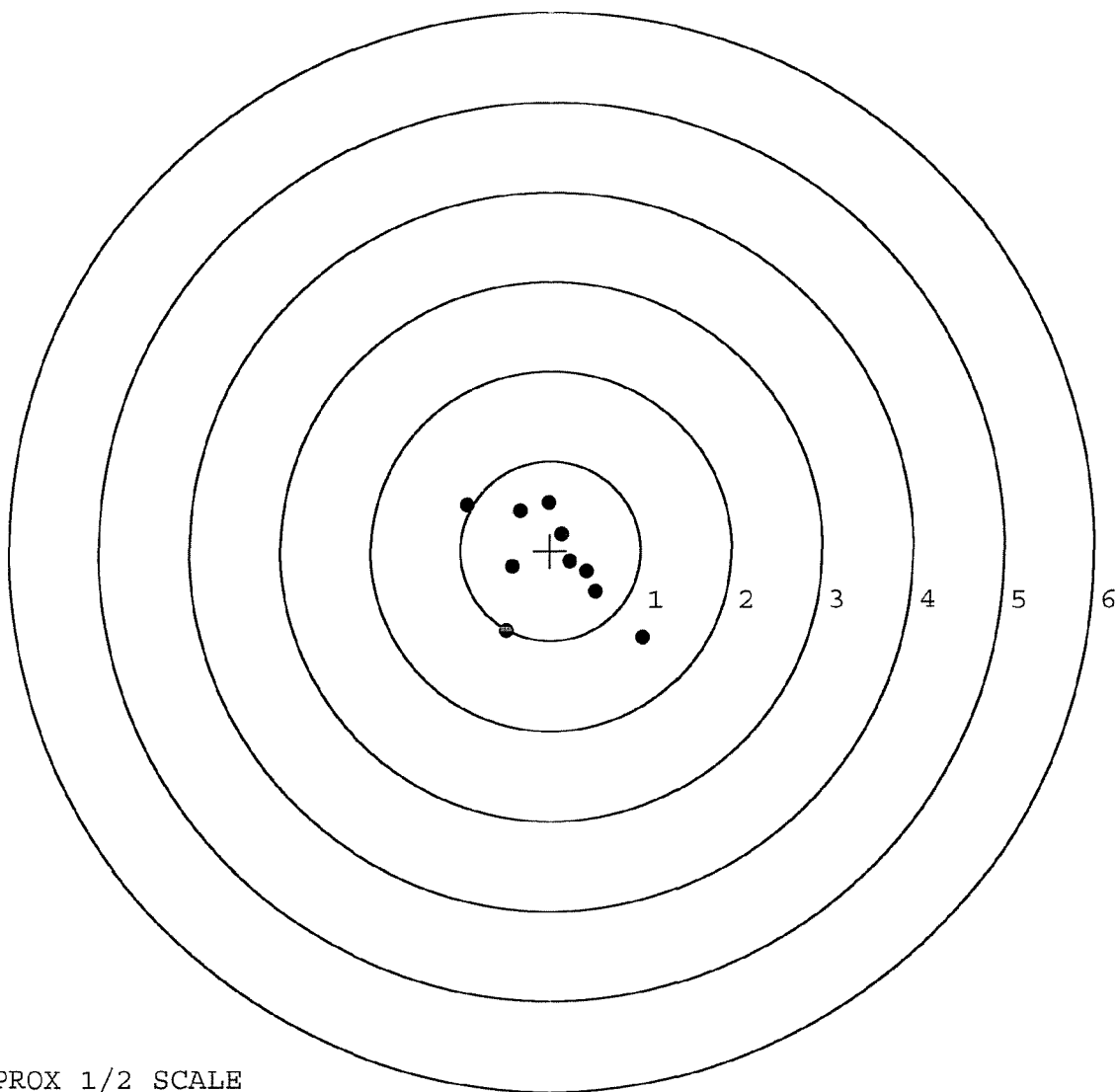
TARGET APPROX 1/2 SCALE

BARBER - M24 0001548

SERIAL NUMBER: C6587574. __0
 TARGET NUMBER: 5
 FILE DATE: 09/17/2003
 FILE TIME: 06:45

POINT#	X	Y
1:	1.021	-0.978
2:	-0.492	-0.897
3:	-0.425	-0.184
4:	-0.922	0.508
5:	-0.342	0.444
6:	-0.026	0.535
7:	0.125	0.182
8:	0.214	-0.123
9:	0.403	-0.236
10:	0.506	-0.464

X CENTROID: 0.006
 Y CENTROID: -0.121
 POA TO CENTROID: 0.121
 HORZ SPREAD: 1.943
 VERT SPREAD: 1.513
 GROUP SPREAD: 2.446
 MIN RADIUS: 0.208
 MAX RADIUS: 1.328
 MEAN RADIUS: 0.668
 # IN 1 IN DIAMETER: 4
 # IN 2 IN DIAMETER: 8
 # in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL #

C6587574

INSPECTED BY:

RTL

DATE REC'D:

9-2-03

DATE RET'D:

9-18-03

ITEM

BARREL ASSEMBLY

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

SCOPE ASSEMBLY

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

ITEM

STOCK ASSEMBLY

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

SYSTEMS CASE

☒ SCOPE CASE☒ IRON SIGHTS☒ DEPLOYMENT KIT

TRIGGER ASSEMBLY

☒ SAFETY OPERATION☒ RE-SET TO FACTORY SPECS

COMMENTS:

R & E NUMBER	069393		
SERIAL NUMBER	C6587574		
LOG-IN DATE	9-2-03		
INSPECT AND VERIFY:			
OPERATION #	OPERATION NAME	DATE	INITIAL
550	DIS-ASSEMBLE GUN	9-2-03	RW
560 A	RE-BARREL	9-4-03	RTL
B	DRILL AND TAP	9-5-03	TRW
575	ASSEMBLE	9-4-03	RTL
600	PROOF	9-4-03	AC
605	CHECK HEADSPACE	9-4-03	AC
610	DIS-ASSEMBLE GUN	9-5-03	RTL
612	MAGNAFLUX OPERATOR		
615	ROLLMARK CALIBER	9-5-03	RTL
618	ROTO-BLAST	9-10-03	JAB
620	APPLY COATINGS	9-12	TA
625 A	FINAL ASSEMBLY	9-15-03	RW
B	TRIGGER PULL TEST	9	
C	SAFETY "ON" FORCE		
D	SAFETY "OFF" FORCE		
E	FIRING PIN INDENT		
640	TARGET	9-16-03	TRW
655	FINAL INSPECT	9-18-03	RTL
660	PACK	9-24-03	TA
		SHIP DATE	
QAR INSPECTION DATE			

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

MODEL 700™ H24

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

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

SERIAL NO.
C6587574

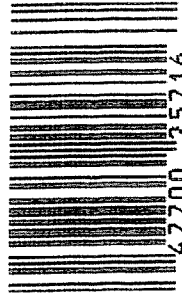
ORDER NO.
5716

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



5716 C6587574

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C 6 5 8 7 5 7 4

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		10/19/90	Kd
600	Proof		10/19/90	Kd
607	Check Headspace		10/19/90	Kd
610	Dis-assemble Gun		10/19/90	Kd
612	Magnaflux Barrel Action		10/22/90	KR
	Magnaflux Bolt		10/22/90	KR
615	Rollmark Caliber		10/22/90	JS.
617	Drill and Tap Sight Holes		10/23/90	WB
618	Polish Barrel RB		10/24/90	WB
620	Apply Coatings (Barrel Action)		11-7-90	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		11/7/90	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		11/7/90	KS
	C) Inspect Ejector Hole for Chamfer		11/7/90	KS
	D) Oil Firing Pin Ass'y		11/7/90	KS
	E) Adjust Trigger Pull to Min Setting and Stake		11-26-90	JA

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4 1/4	4 1/4	4 1/4			11/26/90	WLB
	G) Safety Off Force	2 1/2	2 1/2	2 1/2			11/26/90	WLB
	H) Trigger Pull Test & Retainability						11-26-90	JL
	I) Firing Pin Indent	.021	.0215	.0215			11/26/90	WLB
	J) Assemble Stock						11/27/90	KS
	K) Assemble Swivel Studs						11-29-90	JL
	L) Attach Front and Rear Sight Assemblies						11/27/90	KS
	M) Iron Sight Alignment						11/27/90	KS
	N) Detach Front & Rear Sights & place in numbered container						11/27/90	KS
	O) Attach Scope to Rifle						11/27/90	KS
	P) Detach & Attach Scope 20 Times						11/27/90	KS
640	Gallery Target & Test						11-28-90	AC
	A) Time						11-28-90	AC
	B) Malfunctions						11-28-90	AC
	C) Pierced Primers						11-28-90	AC
	D) Optical Clarity of Scope						11-28-90	AC
645	Inspect for Live Ammo						11-28-90	AC
655	Final Inspection							
	A) Headspace						11-29-90	JL
	B) Trigger Pull	2.47	2.61	2.51	2.64	2.70	11-29-90	JL
	C) Function						11-29-90	JL
660	Pack						12/14/90	VF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO 06587574

DATE 11-26-90

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.26	2.25	2.40	247	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.37	2.32	2.35	261	
PULL #3	2.09	2.34	2.31	251	
PULL #4	2.30	2.35	2.33	264	
PULL #5	2.35	2.36	2.39	270	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.46	3.41		
PULL #2	3.35	3.36		
PULL #3	3.35	3.48		
PULL #4	3.14	3.25		
PULL #5	3.43	3.25		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.25	4.30		4.30
PULL #2	4.36	4.42		4.34
PULL #3	4.30	4.28		4.46
PULL #4	4.29	4.46		4.33
PULL #5	4.35	4.37		4.17
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6587574
28 Nov 1990

CENTROIDAL DISTANCES

0	TO	1	.57753
1	TO	2	.676207
1	TO	3	.496912
1	TO	4	.611507
1	TO	5	.482457

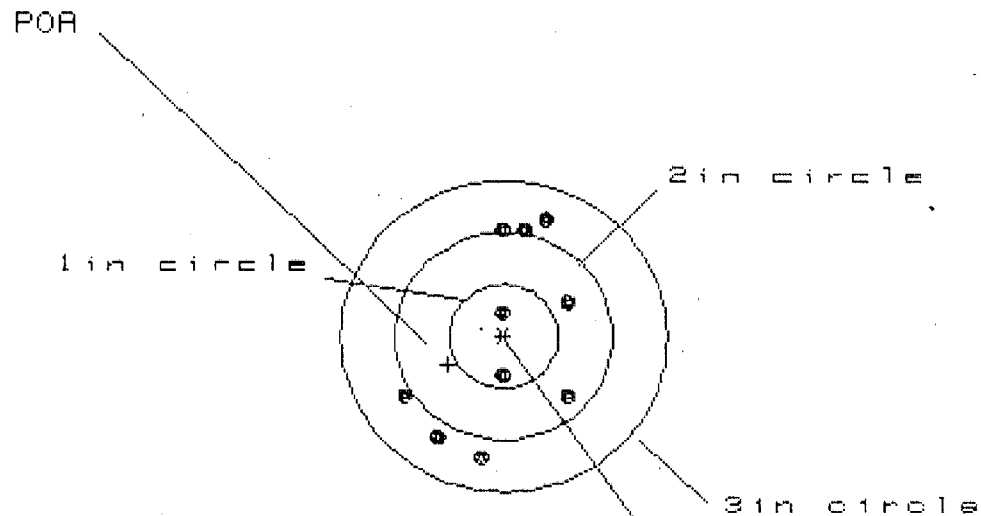
$\frac{1}{2}$ L <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1438
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .016
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .144687
THE AMR FOR THIS RIFLE IS: .8856

28 Nov 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C8587574

CENTERFIRE PATTERNS # 1



OF SHOTS - 10

IN CIR

1 in = 2

2 in = 4

3 in = 10

HS = 1.575

VS = 2.275

GS = 2.347

CENTROID *

PATTERN #	1	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.622	.601	.647
MINIMUM X	-.953	-.974	-.928
MAXIMUM Y	1.103	.972	1.037
MINIMUM Y	-1.172	-1.074	-.952
CENTROID X	.510	.531	.485
CENTROID Y	.271	.402	.280
POA TO CENTROID in.	.578	.666	.560
MIN RADIUS	.203	.071	.198
MEAN RADIUS	.877	.823	.804
MAX RADIUS	1.187	1.265	1.138
HORIZONTAL SPREAD	1.575	1.575	1.575
VERTICAL SPREAD	2.275	2.046	1.989
EXTREME SPREAD	2.347	2.294	2.112
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	10		

28 Nov 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6587574

CENTERFIRE PATTERNS # 2

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 10

HS= 2.603

VS= 2.234

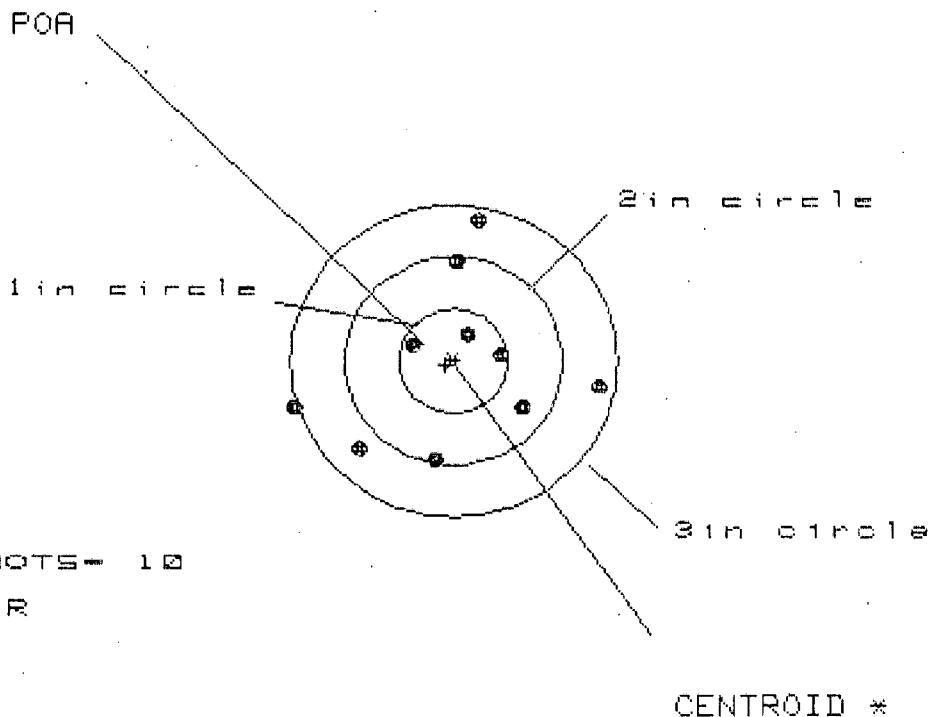
GS= 2.663

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.449	.953	.866
MINIMUM X	:	-1.154	-.993	-1.080
MAXIMUM Y	:	1.150	1.178	1.046
MINIMUM Y	:	-1.084	-1.056	-.849
CENTROID X	:	.044	-.117	-.030
CENTROID Y	:	-.219	-.247	-.115
POA TO CENTROID in.	:	.224	.274	.119
MIN RADIUS	:	.210	.348	.332
MEAN RADIUS	:	.893	.836	.761
MAX RADIUS	:	1.471	1.262	1.213
HORIZONTAL SPREAD	:	2.603	1.946	1.946
VERTICAL SPREAD	:	2.234	2.234	1.896
EXTREME SPREAD	:	2.663	2.367	2.306
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		10	

28 May 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6587574

CENTERFIRE PATTERNS # 3



OF SHOTS - 10

IN CIR

1 in = 3

2 in = 6

3 in = 9

HS = 2.820

VS = 2.311

GS = 2.826

PATTERN #	3	3	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.323	1.156	1.170
MINIMUM X	-1.497	-1.034	-1.020
MAXIMUM Y	1.341	1.296	1.116
MINIMUM Y	-0.970	-1.015	-0.853
CENTROID X	.069	.236	.222
CENTROID Y	.042	.087	-.075
POA TO CENTROID in.	.081	.251	.234
MIN RADIUS	.273	.185	.346
MEAN RADIUS	.939	.845	.797
MAX RADIUS	1.552	1.347	1.238
HORIZONTAL SPREAD	2.820	2.190	2.190
VERTICAL SPREAD	2.311	2.311	1.969
EXTREME SPREAD	2.826	2.445	2.271
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		9	

26 Nov 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6587574

CENTERFIRE PATTERNS

4

POA

1in circle

2in circle

3in circle

OF SHOTS= 10

IN CIR

1in = 1

2in = 7

3in = 10

HS= 1.856

VS= 2.011

GS= 2.319

CENTROID *

PATTERN #

4

SHOTS (BEST OF)

10

9

8

MAXIMUM X : .935

1.013

.948

MINIMUM X : -.921

-.843

-.908

MAXIMUM Y : 1.251

1.335

.598

MINIMUM Y : -.760

-.621

-.454

CENTROID X : .039

-.039

.026

CENTROID Y : -.119

-.258

-.425

POA TO CENTROID in. : .125

.261

.426

MIN RADIUS : .420

.288

.114

MEAN RADIUS : .923

.837

.723

MAX RADIUS : 1.432

1.431

1.019

HORIZONTAL SPREAD : 1.856

1.856

1.856

VERTICAL SPREAD : 2.011

1.956

1.052

EXTREME SPREAD : 2.319

2.319

1.863

NUMBER IN ONE INCH CIRCLE = 1

NUMBER IN TWO INCH CIRCLE = 7

NUMBER IN THREE INCH CIRCLE = 10

28 Nov 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6587574

CENTERFIRE PATTERNS

5

POR

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS- 10

IN CIR

1 in = 3

2 in = 7

3 in = 9

HS= 1.770

VS= 2.062

GS= 2.249

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	.991
MINIMUM X	-.779
MAXIMUM Y	1.323
MINIMUM Y	-.739
CENTROID X	.057
CENTROID Y	.105
POR TO CENTROID in.	.119
MIN RADIUS	.337
MEAN RADIUS	.796
MAX RADIUS	1.518
HORIZONTAL SPREAD	1.770
VERTICAL SPREAD	2.062
EXTREME SPREAD	2.249
NUMBER IN ONE INCH CIRCLE =	3
NUMBER IN TWO INCH CIRCLE =	7
NUMBER IN THREE INCH CIRCLE =	9

RECEIVING AND ESTIMATE REPORT

COMMENTS

ORDER
R 94-18387

INITIAL	CUSTOMER ORDER NO.	W/10X SCOPE, M-24 SNIPER, W/DEPLOYMENT KIT			
FDC	DAAA09-92-C-0834	ATTN: FRED MARTIN			
DATE RECEIVED	DATE OPENED	DATE CODE	SERIAL NUMBER	NEW SERIAL NUMBER	MODEL AND GRADE
06/11/94	06/11/94		C6587574		700 7.62 NATO
ACCESSORIES	SLING STRAP	HARD CASE	SCOPE MNTS	SCOPE BASE	

FROM:

SHIP TO:

COMMANDER (W52H094138H226)
DEFENSE DIST DEPOT ANNISTON
ATTN DDAA-UR BLDG 112
ANNISTON

AL 36201-5025

COMMANDER (W52H094138H226)
DEFENSE DIST DEPOT ANNISTON
ATTN DDAA-UR BLDG 112
ANNISTON

AL
36201-5025

CUST NO: 098397 C.O.D L

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

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	COMMENTS
✓ Barrel # 643.45	
✓ Stock Assy 471.11	
✓ Trigger Assy 173.31	
✓ Firing pin Assy 9.96	
✓ Front Sight Assy 56.75	
✓ Rear Sight Assy 231.01	
Inspect/Test/Clean 50.00	
1412.25	
REPAIRMAN	PROOF
CLEAN	TEST
TARGET	PATTERN
GALLERY TESTER	DATE
DATE	DATE
3/2	3/2

OFFICE COPY

RD6925 REV. 1/94

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

BARBER - M24 0001987

M2498001600

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6587574

DATE 2-13-96

TESTER RA

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#	COMMENTS
PULL #1	2.76	2.74	2.74	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.49	2.67	2.66	
PULL #3	2.58	2.73	2.65	
PULL #4	2.46	2.67	2.64	
PULL #5	2.46	2.69	2.64	
TOTAL	12.76	13.50	13.33	
AVG.	2.55	2.70	2.66	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.23	3.24		
PULL #2	3.11	3.17		
PULL #3	3.05	3.18		
PULL #4	3.09	3.12		
PULL #5	3.03	3.00		
TOTAL	15.51	15.73		
AVG.	3.10	3.14		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.20	4.16		4.24
PULL #2	4.07	4.19		4.16
PULL #3	4.05	4.18		4.00
PULL #4	4.04	4.12		4.01
PULL #5	4.01	4.14		3.80
TOTAL	20.37	20.79		20.21
AVG.	4.07	4.15		4.04

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6587574

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

BARBER - M24 0001564		READINGS			DATE	INIT		
op. #	OP. NAME							
625 cont.	F) Safety On Force	4½	4½	4½	3/7	HL		
	G) Safety Off Force	2½	2½	2½	3/7	HL		
	H) Trigger Pull Test & Retainability							
	I) Firing Pin Indent	.020	.0205	.020	3/7	HL		
	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							
	A) Time							
	B) Malfunctions							
	C) Pierced Primers							
	D) Optical Clarity of Scope							
645	Inspect for Live Ammo							
655	Final Inspection							
	A) Headspace							
	B) Trigger Pull	2.65	2.67	2.61	2.55	2.57	3/7/96	WB
	C) Function							
660	Pack							

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06587574
4 Jan 1980

CENTROIDAL DISTANCES

0 TO	1	.861047
1 TO	2	.336006
1 TO	3	.384433
1 TO	4	.189264
1 TO	5	.20303

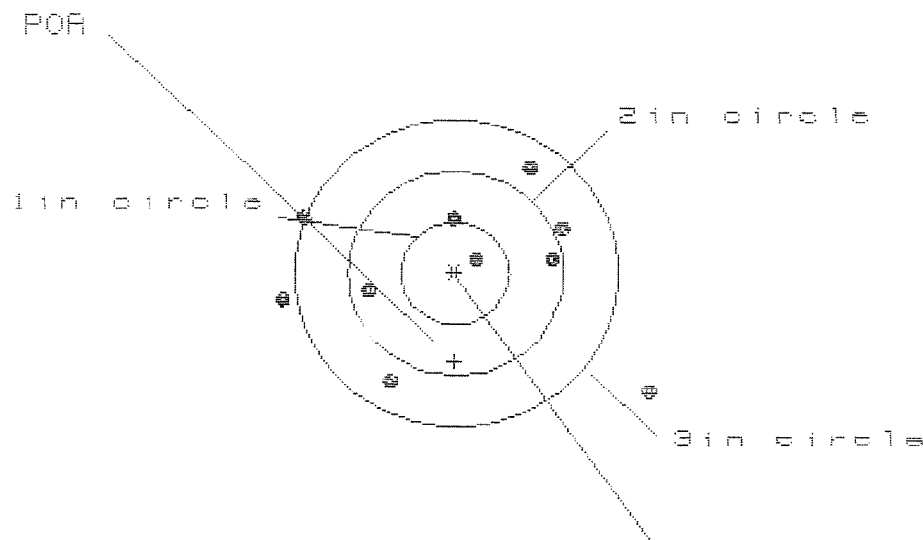
5
0.12

+ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0282
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .7516
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .752129

THE AMP FOR THIS RIFLE IS: .9332

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in - 1

2 in - 4

3 in - 8

HS= 3.372

VS= 2.223

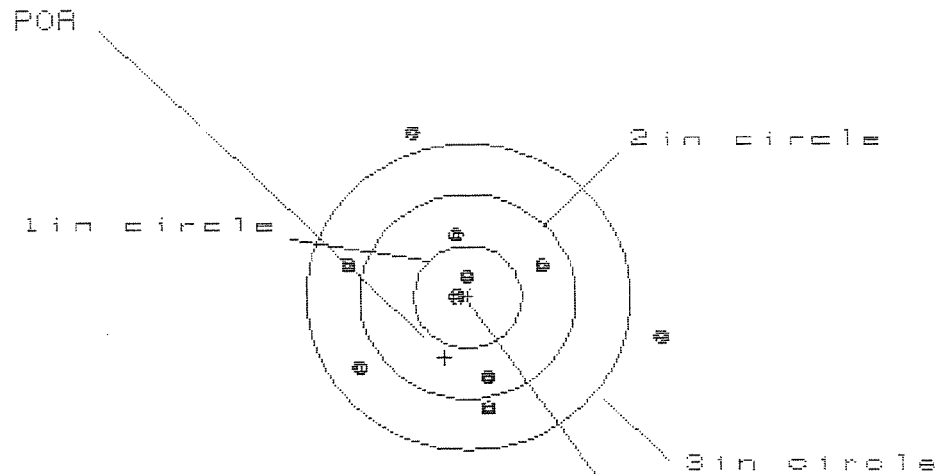
GS= 3.568

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.747	1.194	1.015
MINIMUM X	-1.625	-1.430	-1.392
MAXIMUM Y	1.059	.930	.877
MINIMUM Y	-1.164	-1.220	-1.272
CENTROID X	.009	-.185	-.006
CENTROID Y	.861	.990	1.042
POA TO CENTROID in.	.861	1.007	1.043
MIN RADIUS	.175	.346	.188
MEAN RADIUS	1.134	1.022	.924
MAX RADIUS	2.100	1.490	1.429
HORIZONTAL SPREAD	3.372	2.624	2.407
VERTICAL SPREAD	2.223	2.150	2.150
EXTREME SPREAD	3.568	2.714	2.532
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =		4	
NUMBER IN THREE INCH CIRCLE =			8

4 Jan 1968

FILE:/PATTERNING/CENTERFIRE_PATT/06587574

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1 in = 2

2 in = 5

3 in = 8

HS= 2.898

VS= 2.676

GS= 2.983

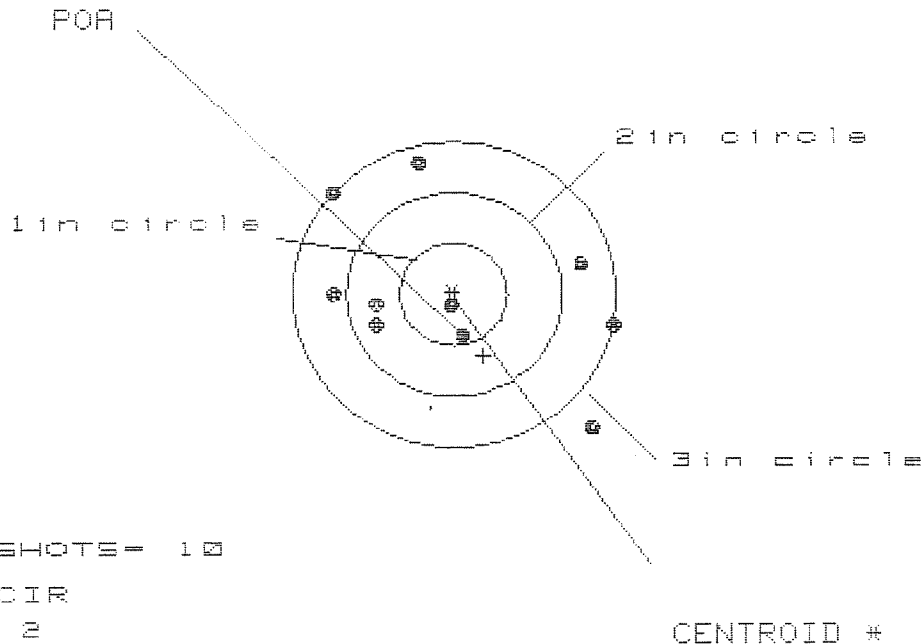
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.763	.911	.876
MINIMUM X	:	-1.135	-.939	-.974
MAXIMUM Y	:	1.582	1.538	.710
MINIMUM Y	:	-1.094	-1.138	-.946
CENTROID X	:	.209	.013	.048
CENTROID Y	:	.591	.635	.443
POA TO CENTROID in.	:	.627	.535	.445
MIN RADIUS	:	.147	.058	.201
MEAN RADIUS	:	.947	.836	.761
MAX RADIUS	:	1.806	1.563	1.072
HORIZONTAL SPREAD	:	2.898	1.850	1.850
VERTICAL SPREAD	:	2.676	2.676	1.656
EXTREME SPREAD	:	2.983	2.757	1.947
NUMBER IN ONE INCH CIRCLE =			2	
NUMBER IN TWO INCH CIRCLE =			5	
NUMBER IN THREE INCH CIRCLE =			8	

4 Jan 1968

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CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1 in = 2

2 in = 4

3 in = 8

HS = 2.590

VS = 2.588

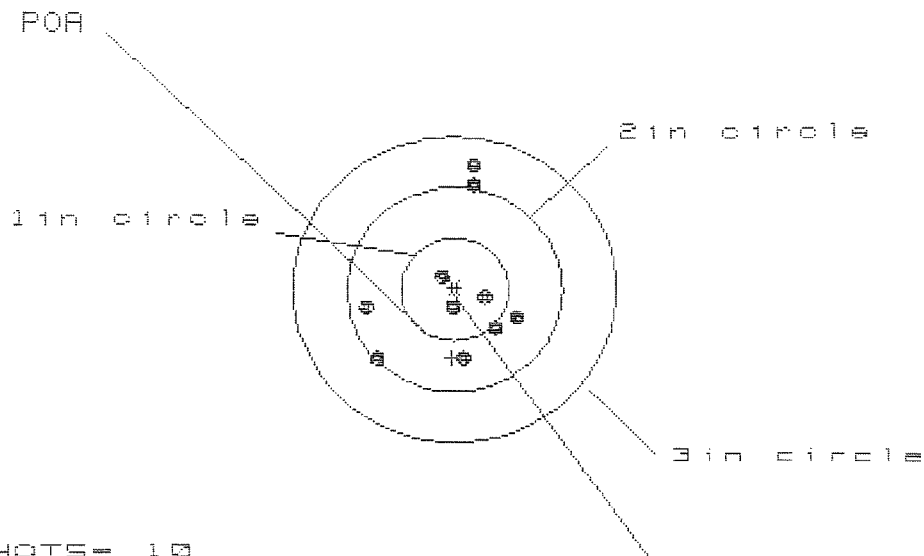
GS = 3.274

PATTERN #	3		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.434	1.570	1.445
MINIMUM X	-1.156	-1.020	-1.145
MAXIMUM Y	1.277	1.131	1.233
MINIMUM Y	-1.311	-0.540	-0.438
CENTROID X	-0.276	-0.412	-0.287
CENTROID Y	.603	.749	.647
POA TO CENTROID in.	.663	.855	.708
MIN RADIUS	.067	.262	.113
MEAN RADIUS	1.039	.960	.897
MAX RADIUS	1.795	1.644	1.496
HORIZONTAL SPREAD	2.590	2.590	2.590
VERTICAL SPREAD	2.588	1.671	1.671
EXTREME SPREAD	3.274	2.879	2.616
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		4	
NUMBER IN THREE INCH CIRCLE =		9	

4 Jan 1988

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CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1in = 4

2in = 8

3in = 10

HS= 1.401

VS= 1.936

GS= 2.155

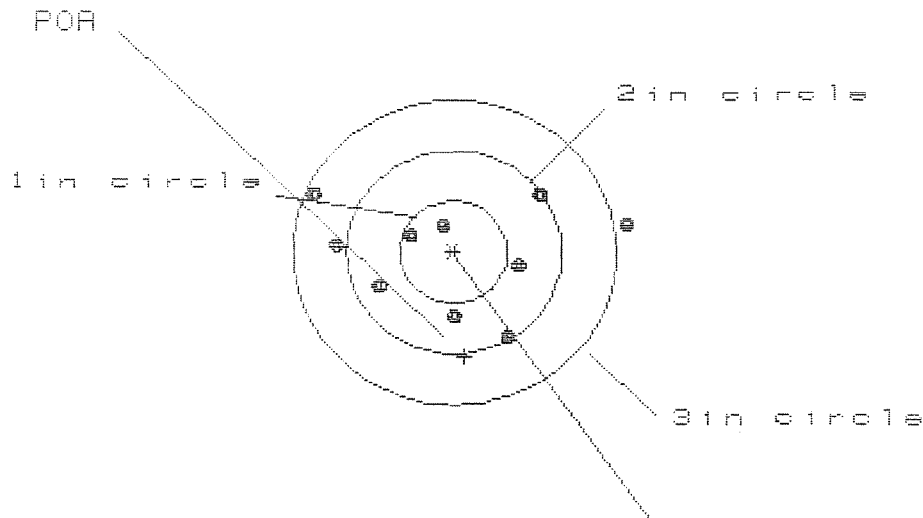
CENTROID #

PATTERN #	4
SHOTS (BEST OF)	10
MAXIMUM X	.536
MINIMUM X	-.865
MAXIMUM Y	1.244
MINIMUM Y	-.692
CENTROID X	.019
CENTROID Y	.672
POA TO CENTROID in.	.672
MIN RADIUS	.164
MEAN RADIUS	.667
MAX RADIUS	1.264
HORIZONTAL SPREAD	1.401
VERTICAL SPREAD	1.936
EXTREME SPREAD	2.155
NUMBER IN ONE INCH CIRCLE =	4
NUMBER IN TWO INCH CIRCLE =	8
NUMBER IN THREE INCH CIRCLE =	10

4 Jan 1968

FILE:/PATTERNING/CENTERFIRE_PATT/06587574

CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1 in = 2

2 in = 7

3 in = 9

HS= 2.898

VS= 1.367

GS= 2.913

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.650	1.006	.873
MINIMUM X	:	-1.248	-1.065	-1.091
MAXIMUM Y	:	.534	.561	.629
MINIMUM Y	:	-.833	-.806	-.736
CENTROID X	:	-.102	-.285	-.152
CENTROID Y	:	1.031	1.004	.934
POA TO CENTROID in.	:	1.036	1.044	.946
MIN RADIUS	:	.321	.254	.397
MEAN RADIUS	:	.879	.767	.715
MAX RADIUS	:	1.667	1.204	1.108
HORIZONTAL SPREAD	:	2.898	2.071	1.964
VERTICAL SPREAD	:	1.307	1.307	1.065
EXTREME SPREAD	:	2.913	2.199	2.012
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	