

C6498878

73

MODEL 700™ M24

Model **SWS**™

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

Remington

Repair Inquiry

Repair Number: RE00128531

Serial: C6498878 Model M24 SWS Center Fire
Caliber: 7.62 NATO

Repairman:

Status:

New 4/24/2007 7:36:14 AM

Address Information

Customer:

Received From

Return To:

Received From

Name: ISSD ARMSROOM

ISSD ARMSROOM

Address 1: 8TH DESERT STORM

8TH DESERT STORM

Address 2: BLDG 5210 BAY DOOR #30 PO Box:

BLDG 5210 BAY DOOR #30 PO Box:

City: FORT CAMPBELL

FORT CAMPBELL

State: KY

Zip Code: 42223

Country: US

State: KY

Zip Code: 42223

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
A010	Hard Case	1
A017	Scope Base	1
A026	Scope	1
A045	Bi Pod	1
A057	Frt and Rear Sgt Base	1

Repair Search

Refresh

Close

naglej

4/24/2007

8:09 AM

CAPS

NUM

INS

SCRL

Serial
Number:

C6498878

Model: M24 SWS



RE00128531

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6498878.___0
FILE DATE AND TIME: 06/04/2007 15:18

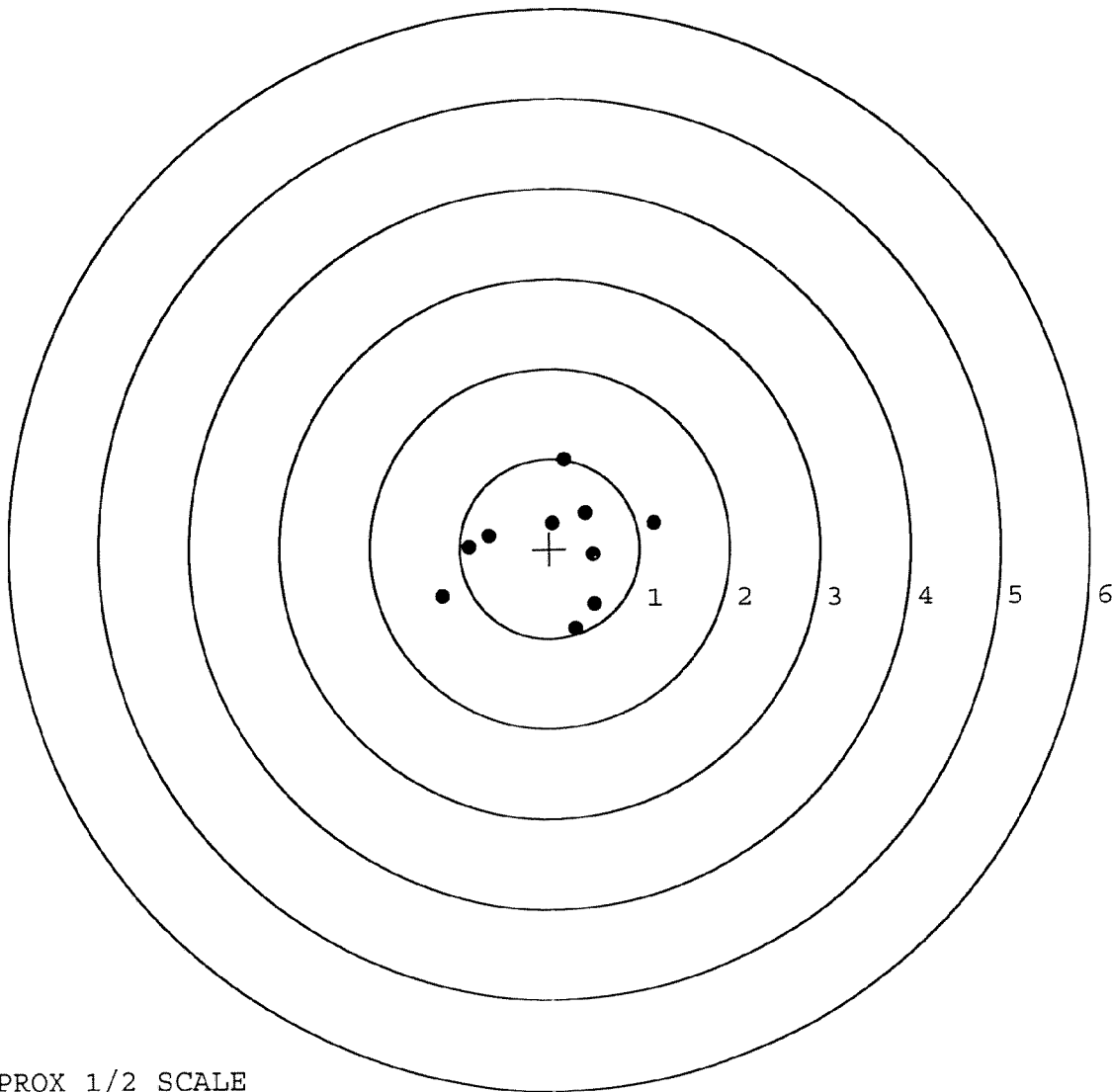
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.013
The Average Y Centroid of the Five Target Set:	-0.061
The Average Point of Impact of the Five Target Set:	0.062
The Average Mean Radius of the Five Target Set:	0.634
The Distance from POA to Centroid Target #1:	0.027
The Distance from Centroid Target #2 to Centroid Target #1:	0.362
The Distance from Centroid Target #3 to Centroid Target #1:	0.092
The Distance from Centroid Target #4 to Centroid Target #1:	0.250
The Distance from Centroid Target #5 to Centroid Target #1:	0.144

SERIAL NUMBER: C6498878. 0
 TARGET NUMBER: 1
 FILE DATE: 06/04/2007
 FILE TIME: 15:18

POINT#	X	Y
1:	0.288	-0.896
2:	0.498	-0.622
3:	0.484	-0.071
4:	1.156	0.286
5:	0.172	0.988
6:	-1.197	-0.535
7:	-0.895	0.026
8:	-0.677	0.151
9:	0.037	0.290
10:	0.406	0.398

X CENTROID: 0.027
 Y CENTROID: 0.002
 POA TO CENTROID: 0.027
 HORZ SPREAD: 2.353
 VERT SPREAD: 1.884
 GROUP SPREAD: 2.492
 MIN RADIUS: 0.289
 MAX RADIUS: 1.337
 MEAN RADIUS: 0.816
 # IN 1 IN DIAMETER: 2
 # IN 2 IN DIAMETER: 8
 # in 3 IN DIAMETER: 10

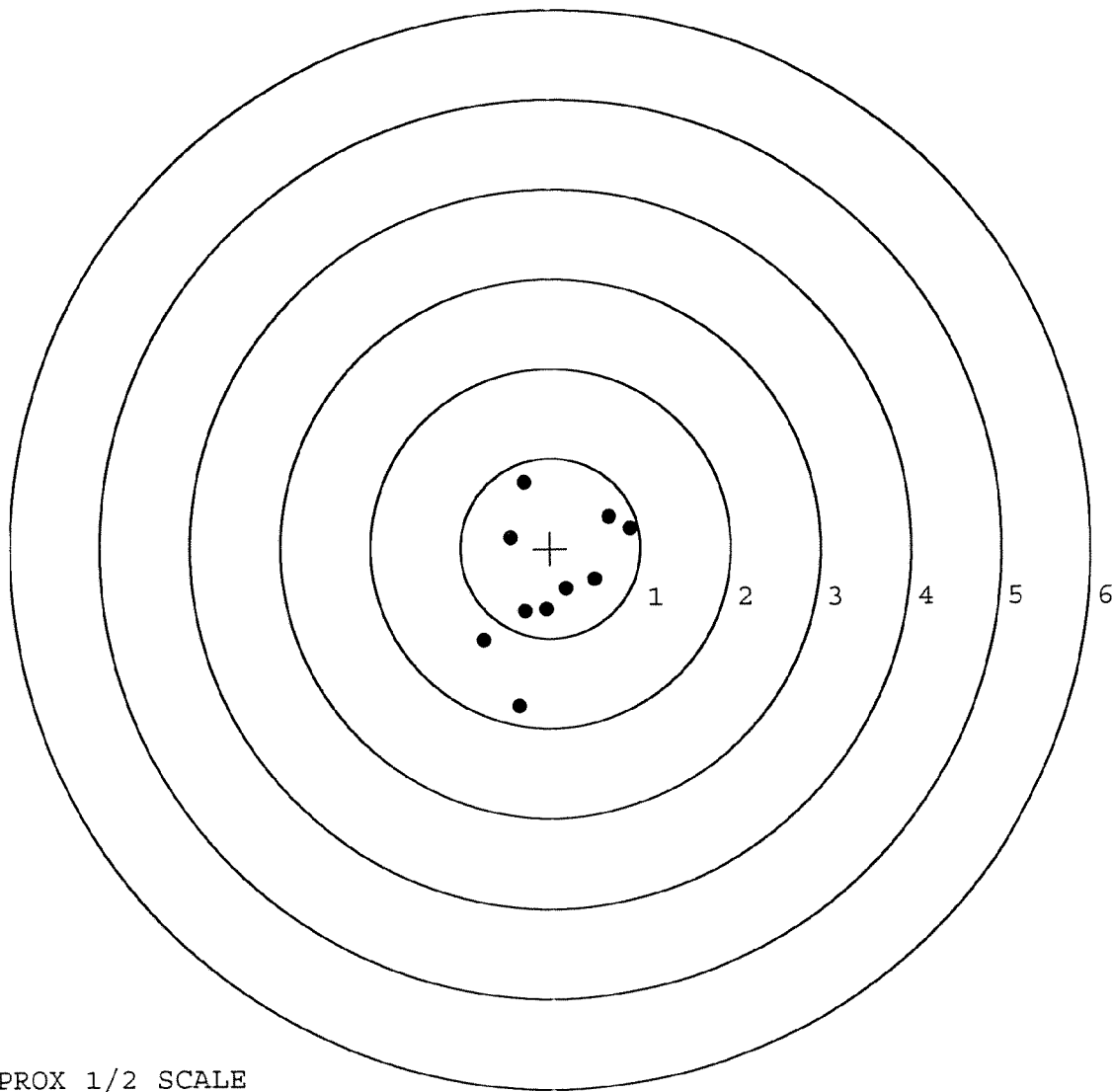


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6498878. __0
 TARGET NUMBER: 2
 FILE DATE: 06/04/2007
 FILE TIME: 15:18

POINT#	X	Y
1:	0.886	0.210
2:	0.647	0.340
3:	-0.292	0.728
4:	-0.445	0.114
5:	0.488	-0.350
6:	0.174	-0.451
7:	-0.052	-0.682
8:	-0.281	-0.705
9:	-0.740	-1.032
10:	-0.350	-1.765

X CENTROID: 0.003
 Y CENTROID: -0.359
 POA TO CENTROID: 0.359
 HORZ SPREAD: 1.626
 VERT SPREAD: 2.493
 GROUP SPREAD: 2.494
 MIN RADIUS: 0.194
 MAX RADIUS: 1.449
 MEAN RADIUS: 0.768
 # IN 1 IN DIAMETER: 4
 # IN 2 IN DIAMETER: 6
 # in 3 IN DIAMETER: 10

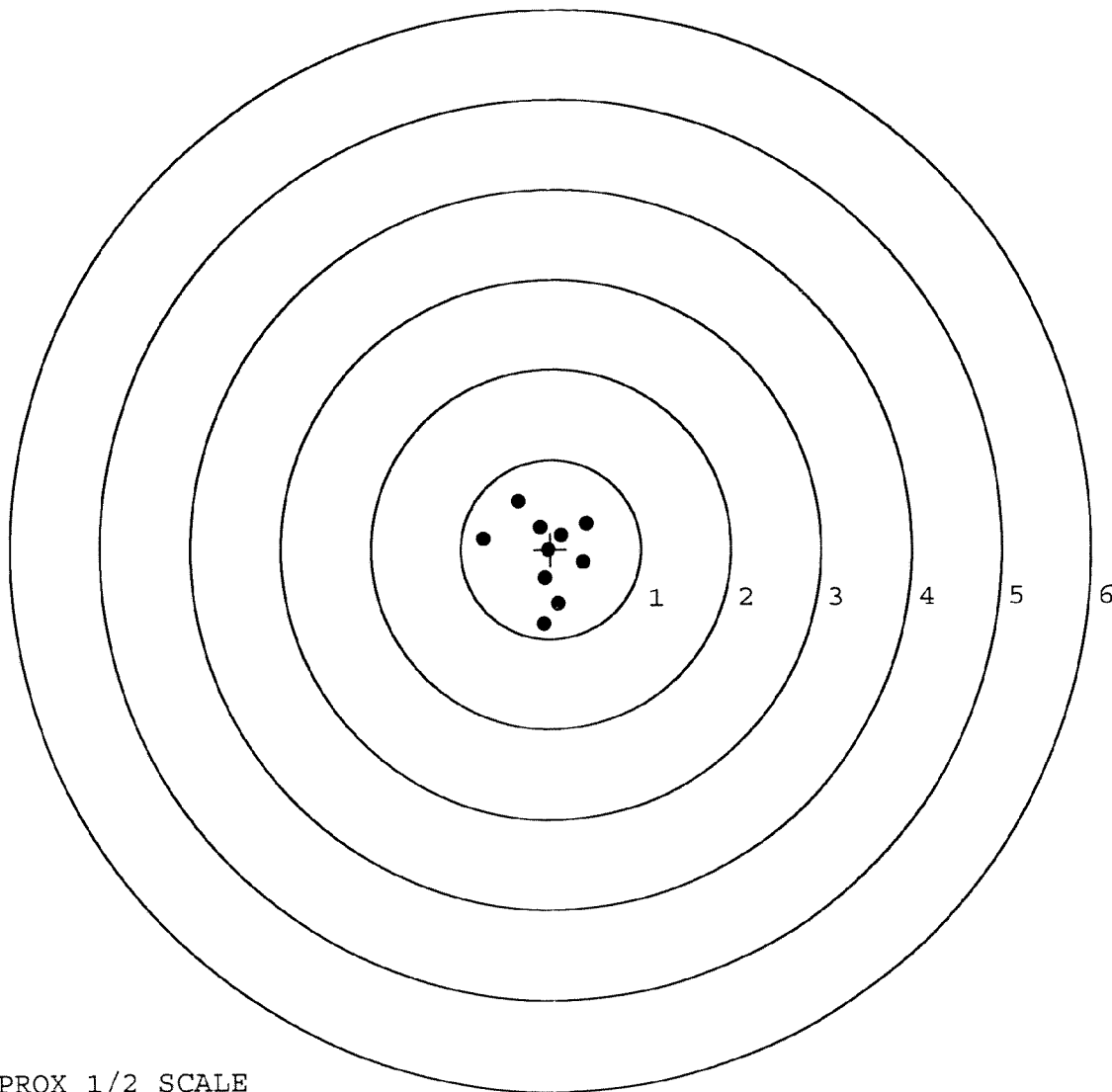


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6498878. __0
 TARGET NUMBER: 3
 FILE DATE: 06/04/2007
 FILE TIME: 15:18

POINT#	X	Y
1:	0.361	-0.150
2:	0.401	0.284
3:	-0.355	0.543
4:	-0.749	0.121
5:	-0.117	0.248
6:	0.122	0.159
7:	-0.028	-0.007
8:	-0.073	-0.325
9:	0.085	-0.608
10:	-0.085	-0.835

X CENTROID: -0.044
 Y CENTROID: -0.057
 POA TO CENTROID: 0.072
 HORZ SPREAD: 1.150
 VERT SPREAD: 1.378
 GROUP SPREAD: 1.404
 MIN RADIUS: 0.052
 MAX RADIUS: 0.779
 MEAN RADIUS: 0.463
 # IN 1 IN DIAMETER: 5
 # IN 2 IN DIAMETER: 10
 # in 3 IN DIAMETER: 10

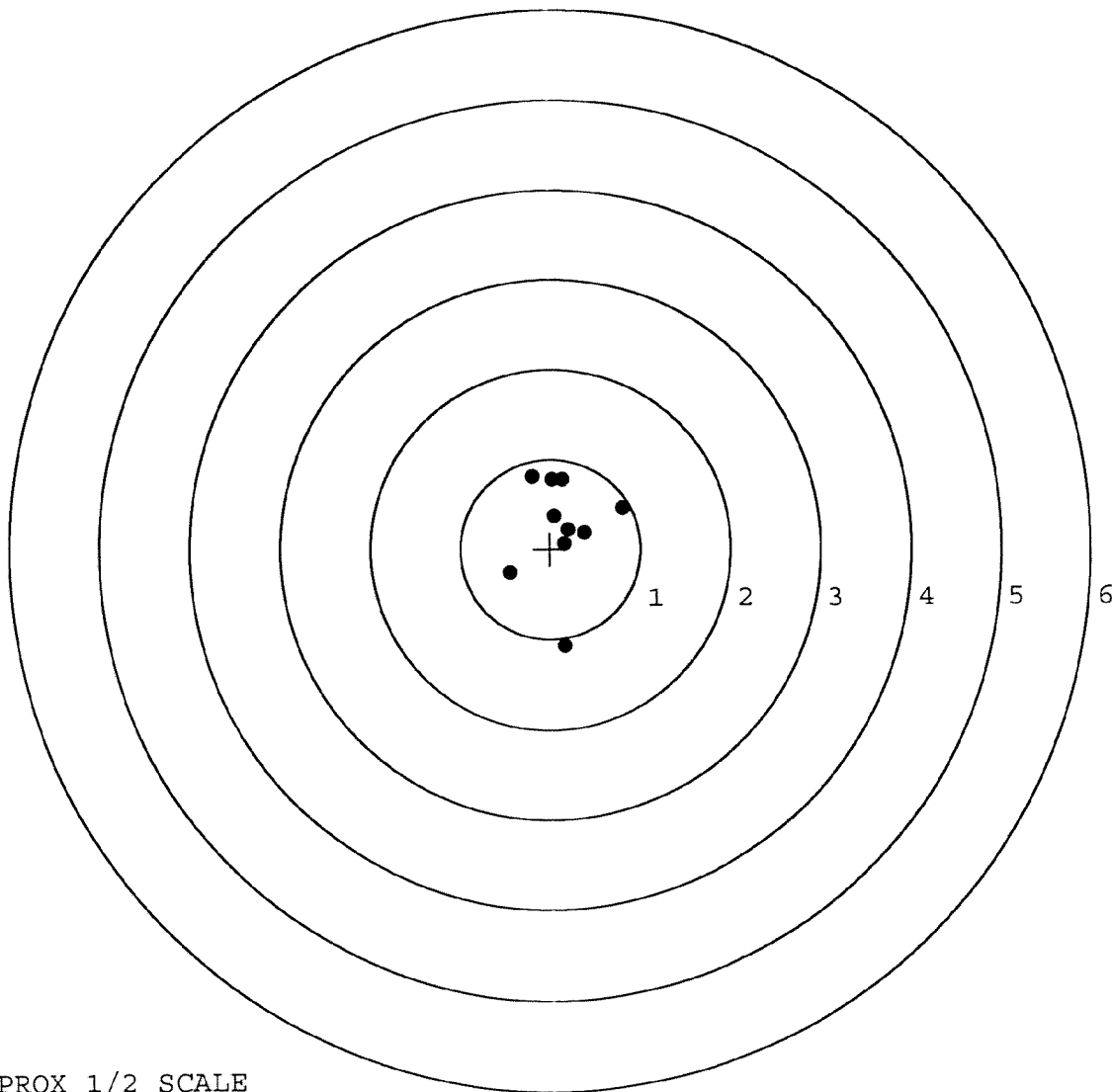


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6498878. 0
 TARGET NUMBER: 4
 FILE DATE: 06/04/2007
 FILE TIME: 15:18

POINT#	X	Y
1:	0.166	-1.081
2:	-0.450	-0.263
3:	0.800	0.453
4:	0.146	0.779
5:	-0.195	0.811
6:	0.049	0.367
7:	0.382	0.186
8:	0.162	0.055
9:	0.200	0.219
10:	0.031	0.774

X CENTROID: 0.129
 Y CENTROID: 0.230
 POA TO CENTROID: 0.264
 HORZ SPREAD: 1.250
 VERT SPREAD: 1.892
 GROUP SPREAD: 1.926
 MIN RADIUS: 0.072
 MAX RADIUS: 1.312
 MEAN RADIUS: 0.521
 # IN 1 IN DIAMETER: 4
 # IN 2 IN DIAMETER: 9
 # in 3 IN DIAMETER: 10

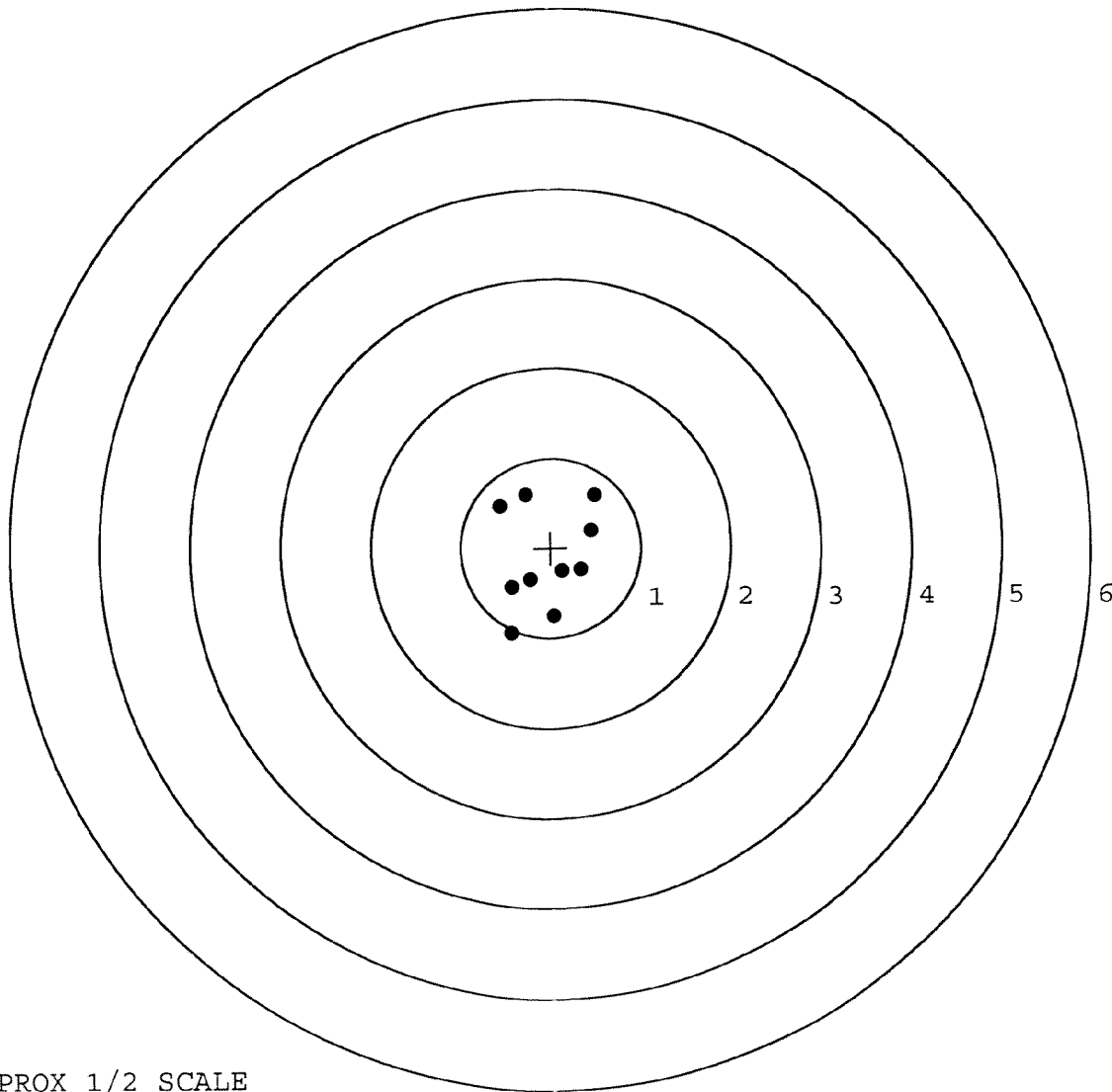


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6498878. __0
 TARGET NUMBER: 5
 FILE DATE: 06/04/2007
 FILE TIME: 15:18

POINT#	X	Y
1:	0.488	0.582
2:	0.449	0.192
3:	-0.278	0.596
4:	-0.566	0.467
5:	0.337	-0.253
6:	0.128	-0.262
7:	0.037	-0.761
8:	-0.232	-0.357
9:	-0.438	-0.444
10:	-0.446	-0.948

X CENTROID: -0.052
 Y CENTROID: -0.119
 POA TO CENTROID: 0.130
 HORZ SPREAD: 1.054
 VERT SPREAD: 1.544
 GROUP SPREAD: 1.793
 MIN RADIUS: 0.230
 MAX RADIUS: 0.918
 MEAN RADIUS: 0.601
 # IN 1 IN DIAMETER: 3
 # IN 2 IN DIAMETER: 10
 # in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

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

R & E NUMBER		128531	
SERIAL NUMBER		C10498828	
LOG-IN DATE		4-24-07	
OPERATION #	OPERATION NAME	DATE	INITIAL
500	DIS-ASSEMBLE GUN	5-15-07	RTZ
505	RE-BARREL	5-18-07	RTZ
560	ASSEMBLE	5-18-07	RTZ
600	PROOF	5-18-07	TRW
605	CHECK HEADSPACE	5-18-07	TRW
610	DIS-ASSEMBLE GUN	5-21-07	RTZ
612	MAGNAFLUX	5-21-07	unus
510	DRILL AND TAP	5-21-07	TRW
615	ROLLMARK CALIBER	5-21-07	CW
618	ROTO-BLAST	5-22-07	LB
620	APPLY COATINGS	5-24-07	W
625	FINAL ASSEMBLY	6-1-07	RTZ
640	FUNCTION TEST AND	(PASS) FAIL	6-4-07 TRW
650	TARGET	(PASS) FAIL	6-4-07 TRW
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
670	FINAL INSPECTION		6-4-07 FM
	A) HEADSPACE	(PASS) FAIL	6-7-07 RTZ
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS 289 290 288 291 290 6-5-07	DA
680	F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX 4.5 4.0 4.5 6-5-07	DA
	G) SAFETY OFF FORCE	2 LBS MIN 3.0 3.0 3.0 6-5-07	DA
	I) FIRING PIN INDENT	.020 .024 .023 .023 6-5-07	DA
690	PACK		6-8-07 DA

375
8
41500
12
30

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

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

MODEL 700™ M24

SERIAL NO.
C6498878

ORDER NO.
5716

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

UPC

0 47700 25716 7

5716 C6498878

Cco 91A

MAINTENANCE REQUEST				PAGE NO. 1	NO. OF PAGES 1	REQUIREMENTS CONTROL SYMBOL CSGLD - 1047(R1)	
For use of this form, see DA PAM 738-750; the proponent agency is DCSLOG							
SECTION I - EQUIPMENT DATA							
CONTROL NUMBER		WORK ORDER NO.		WESDC	ORG. PD	PD AUTHENTICATION X	
☐ Work Request ☐ MWO ☒ Warranty Claim		1A. ORGANIZATION Dco 3/5		B. LOCATION Ft. Campbell Ky 42223		C. UNIT IDENT CODE WHOGPO	
2. SERIAL NO. CG498878		3. NOUN NOMENCLATURE 7.62mm Sniper Weapon M24		4. LINE NO.		5. MODEL	
6. NATIONAL STOCK NUMBER 1005-01-240-2136							
7A. MAINTENANCE ACTIVITY Imo		B. LEVEL O		8. UTILIZATION CODE Ø		9A. MCSR ITEM	
				9B. ERC		9C. PACING ITEM	
				10. HOURS		11. MILES	
				12. ROUNDS		13. STARTS	
14. FAILURE DETECTED DURING (Select one - use ☒ or X)				15. FIRST INDICATION OF TROUBLE (Select one - use ☒ or X)			
☐ A Sch. Main. ☐ C Test ☐ E Storage ☐ G Flight ☐ B Handling ☐ D Normal Op ☐ F Inspection ☒ H Other				☐ 068 Inoperative ☐ 258 Overheating ☐ 790 Out of Adjustment ☐ 008 Noisy ☐ 387 Low Performance ☒ Other			
16A. DESCRIBE DEFICIENCIES OR SYMPTOMS ON THE BASIS OF COMPLETE CHECKOUT AND DIAGNOSTIC PROCEDURE IN EQUIPMENT TM (Do not prescribe repairs) 5500 Rains Fired							
B. REMARKS W 52 H 095 345 #246							
PREPARATION INSTRUCTIONS (Prior to using this form, read DA PAM 738-750 for detailed preparation instructions)							
1. Place a "✓" or an "X" in the box for the type of action required. 2. Enter the WESDC if the item is Materiel Condition Status Reportable. 3. Enter the priority designator as determined from the urgency of need and force activity designator. 4. The Unit Commander, Chief of TDA activity or their designated representative will authenticate, by signature, a priority of 01 through 08. 5. Block 1A. Enter the name of the organization submitting the request. 6. Block 1B. Enter the unit submitting the request; units overseas enter APO only. 7. Block 1C. Enter the unit identification code of the unit in block 1A. 8. Block 2. Enter the equipment serial number. For ammunition, enter the lot number. For administrative-use vehicles, enter the USA registration number. 9. Block 3. Enter the noun abbreviation of the item. 10. Block 4. Enter the item line number, if applicable. 11. Block 5. Enter the model number. 12. Block 6. Enter the National Stock Number of the item listed in Block 3.				13. Block 7. Enter the name of the support activity. 14. Block 7A. Enter the symbol of the maintenance category (O, F, H, D, or L). 15. Block 8. Enter the utilization code. 16. Block 9A. Enter the word "yes" if the item is Materiel Condition Status Reportable. 17. Block 9B. Enter the equipment readiness code, if applicable. 18. Block 9C. Enter the word "yes" if the item is a pacing item. 19. Block 10. Enter the hour reading, if applicable. 20. Block 11. Enter the mileage from the odometer, if applicable. 21. Block 12. Enter the total rounds fired, if applicable. 22. Block 13. For turbine engines, enter the number of hot starts. 23. Block 14. Enter a "✓" or "X" in the proper block. 24. Block 15. Enter a "✓" or "X" in the proper block. 25. Block 16. Describe briefly the fault or symptoms needing correction.			
23. SUBMITTED BY Tony J. [Signature]		24. RECEIVED BY					
JULIAN DATE		JULIAN DATE					

DA FORM 2407, AUG 88

EDITION OF MAY 81 MAY BE USED

RECEIPT COPY 1

New Barrel

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # *C6498878*

OP. #	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and Stock		<i>12/21/95</i>	<i>RW</i>
600	Proof		<i>12/21/95</i>	<i>RW</i>
607	Check Headspace		<i>12/21/95</i>	<i>RW</i>
610	Dis-assemble Gun		<i>12/21/95</i>	<i>RW</i>
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		<i>1/5/96</i>	<i>RW</i>
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		<i>1/5/96</i>	<i>RW</i>
	C) Inspect Ejector Hole for Chamfer		<i>1/5/96</i>	<i>RW</i>
	D) Oil Firing Pin Ass'y		<i>1/5/96</i>	<i>RW</i>
	E) Adjust Trigger Pull to Min Setting and Stake			

op. #	BARBER - M24 0009402 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						1/8/96	RW
	A) Time							
	B) Malfunctions							
	C) Pierced Primers							
	D) Optical Clarity of Scope							
645	Inspect for Live Ammo						1/8/96	RW
655	Final Inspection A) Headspace						1/10/96	RW
	B) Trigger Pull	2.93	2.86	2.93	2.85	2.94	1/10/96	RW
	C) Function						1/10/96	RW
660	Pack							

Final Inspection

Sn: C648878

DATE REC'D: 12/04/95

DATE RET'D:

Auditor: RW

Item:

Barrel Assy.

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

Scope Assy.

☒ Scope☒ Scope Rings☒ Mounting Screws☒ Mounting Base☒ SCREWS☒ FINISH☒ Looseness☒ CLARITY

Misc.

☐ DD-250☐ BAR CODE☐ PACKAGING

Item:

Stock Assy.

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

Systems Case

☐ Scope Case☐ IRON SIGHTS☐ Deployment Kit

Trigger

☒ SAFETY OPERATION☒ SET

Comments:

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6498878
7 Jan 1988

CENTROIDAL DISTANCES

0 TO	1	1.22162
1 TO	2	.572171
1 TO	3	.269112
1 TO	4	.162754
1 TO	5	.819024

5

31

2

+ (----POA

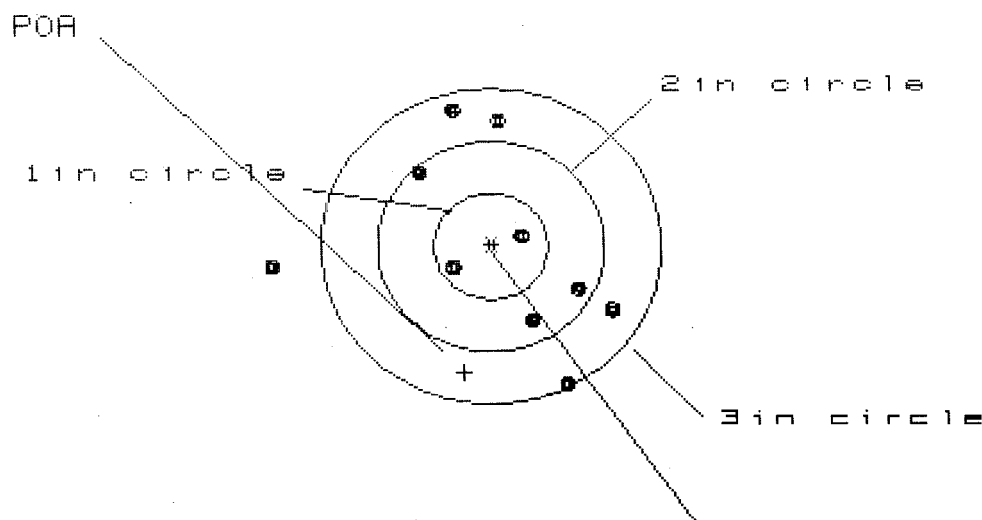
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0084
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: 1.3144
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: 1.31443

THE AMRT FOR THIS RIFLE IS: 17.029

7 Jan 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C6498878

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 5

3 in = 9

HS= 3.045

VS= 2.526

GS= 3.073

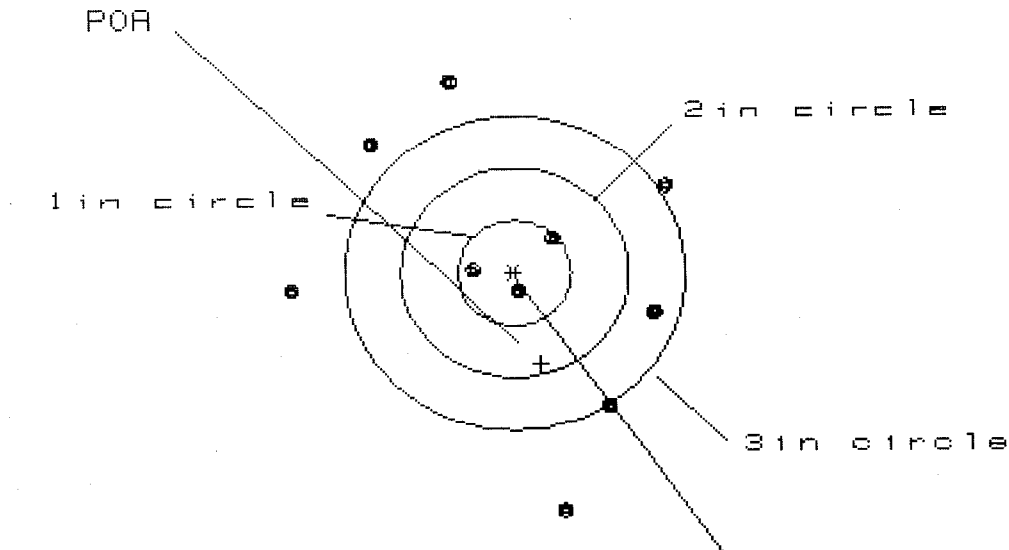
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.096	.880	.942
MINIMUM X	-1.949	-.858	-.796
MAXIMUM Y	1.265	1.243	1.083
MINIMUM Y	-1.261	-1.283	-.859
CENTROID X	.234	.450	.389
CENTROID Y	1.199	1.221	1.381
POA TO CENTROID in.	1.222	1.301	1.435
MIN RADIUS	.321	.144	.134
MEAN RADIUS	1.052	.923	.866
MAX RADIUS	1.959	1.375	1.229
HORIZONTAL SPREAD	3.045	1.738	1.738
VERTICAL SPREAD	2.526	2.526	1.942
EXTREME SPREAD	3.073	2.736	2.360
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	9		

7 Jan 1988

FILE:/PATTERNING/CENTERFIRE_PATT/06498878

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1in = 3

2in = 3

3in = 4

HS= 3.322

VS= 4.101

GS= 4.213

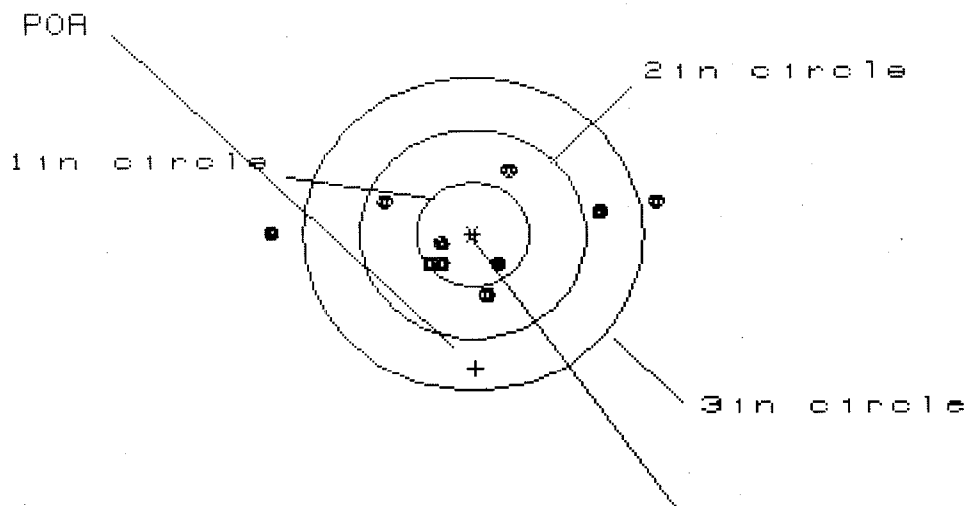
CENTROID #

PATTERN #	2	2	2
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.349	1.394	1.153
MINIMUM X	-1.973	-1.928	-1.478
MAXIMUM Y	1.805	1.549	1.500
MINIMUM Y	-2.296	-1.509	-1.558
CENTROID X	-.232	-.277	-.036
CENTROID Y	.867	1.123	1.172
POA TO CENTROID in.	.898	1.156	1.173
MIN RADIUS	.180	.339	.169
MEAN RADIUS	1.326	1.217	1.098
MAX RADIUS	2.331	1.969	1.722
HORIZONTAL SPREAD	3.322	3.322	2.631
VERTICAL SPREAD	4.101	3.058	3.058
EXTREME SPREAD	4.213	3.460	3.360
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		3	
NUMBER IN THREE INCH CIRCLE =		4	

7 Jan 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C6438878

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 4

2 in = 7

3 in = 8

HS= 3.329

VS= 1.119

GS= 3.341

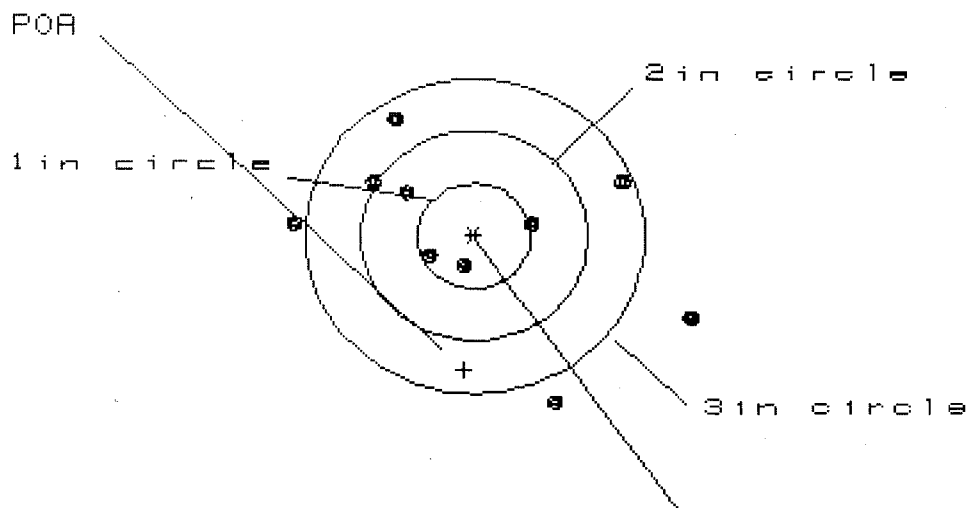
CENTROID *

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.581	1.387	1.123
MINIMUM X	:	-1.748	-.931	-.758
MAXIMUM Y	:	.571	.575	.615
MINIMUM Y	:	-.548	-.544	-.504
CENTROID X	:	-.021	.173	.000
CENTROID Y	:	1.285	1.281	1.241
POA TO CENTROID in.	:	1.285	1.292	1.241
MIN RADIUS	:	.287	.288	.296
MEAN RADIUS	:	.809	.720	.584
MAX RADIUS	:	1.749	1.423	1.161
HORIZONTAL SPREAD	:	3.329	2.318	1.881
VERTICAL SPREAD	:	1.119	1.119	1.119
EXTREME SPREAD	:	3.341	2.318	1.883
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		8	

7 Jan 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C6498878

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

CENTROID #

IN CIR

1 in = 3

2 in = 4

3 in = 7

HS= 3.482

VS= 2.713

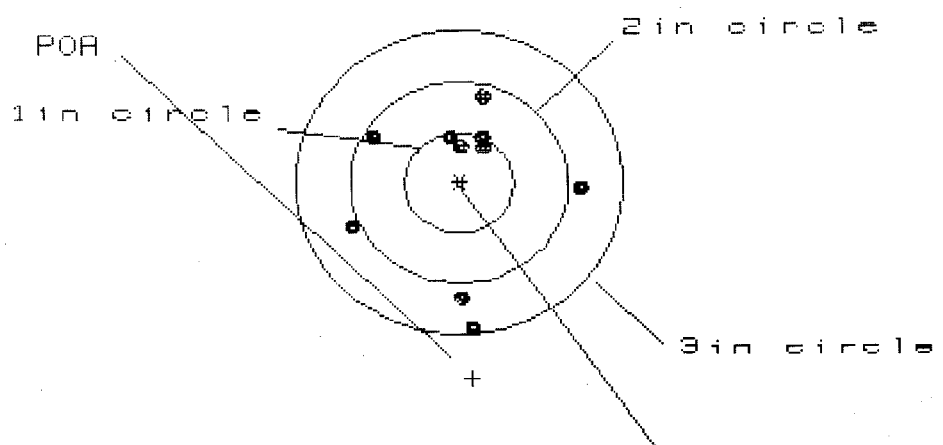
GS= 3.602

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.874	1.501	1.622
MINIMUM X	:	-1.608	-1.400	-1.279
MAXIMUM Y	:	1.119	1.031	.820
MINIMUM Y	:	-1.594	-1.682	-.552
CENTROID X	:	.094	-.114	-.235
CENTROID Y	:	1.282	1.370	1.581
POA TO CENTROID in.	:	1.285	1.375	1.598
MIN RADIUS	:	.285	.350	.273
MEAN RADIUS	:	1.119	.980	.838
MAX RADIUS	:	2.037	1.938	1.637
HORIZONTAL SPREAD	:	3.482	2.901	2.901
VERTICAL SPREAD	:	2.713	2.713	1.372
EXTREME SPREAD	:	3.602	3.098	2.929
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		7	

7 Jan 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C6498878

CENTERFIRE PATTERNS # 5



CENTROID *

OF SHOTS- 10

IN CIR

1in - 3

2in - 6

3in - 10

HS= 2.151

VS= 2.388

GS= 2.390

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.139	1.152	.371
MINIMUM X	:	-1.012	-.999	-.855
MAXIMUM Y	:	.904	.739	.717
MINIMUM Y	:	-1.484	-1.270	-1.292
CENTROID X	:	-.117	-.130	-.274
CENTROID Y	:	1.939	2.104	2.126
POA TO CENTROID in.	:	1.943	2.108	2.144
MIN RADIUS	:	.364	.199	.226
MEAN RADIUS	:	.837	.701	.645
MAX RADIUS	:	1.489	1.270	1.301
HORIZONTAL SPREAD	:	2.151	2.151	1.226
VERTICAL SPREAD	:	2.388	2.009	2.009
EXTREME SPREAD	:	2.390	2.185	2.020
NUMBER IN ONE INCH CIRCLE =	:		3	
NUMBER IN TWO INCH CIRCLE =	:		6	
NUMBER IN THREE INCH CIRCLE =	:		10	

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6498878

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	5 9	90	RW
600	Proof	5 9	90	RW
607	Check Headspace	5 9	90	RW
610	Dis-assemble Gun	5 9	90	RW
612	Magnaflux Barrel Action	5-15-90		KCR
	Magnaflux Bolt	5-15-90		KCR
615	Rollmark Caliber	5-15-90		BS
617	Drill and Tap Sight Holes		5/17/90	FB
618	Polish Barrel RB		5/17/90	WB
620	Apply Coatings (Barrel Action)		5-25-90	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		5/25/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/25/90	RW
	C) Inspect Ejector Hole for Chamfer		5/25/90	RW
	D) Oil Firing Pin Ass'y		5/25/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		4/5/90	RM

BARBER - M24 0009411

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4 1/4	4 1/2	4 1/2			6/7/90	WB
	G) Safety Off Force	2	2	2			6/7/90	WB
	H) Trigger Pull Test & Retainability						6/5/90	DL
	I) Firing Pin Indent	.022	.0217	.0222			6/7/90	WB
	J) Assemble Stock						6/11/90	RW
	K) Assemble Swivel Studs						6/14/90	RU
	L) Attach Front and Rear Sight Assemblies						6/11/90	RW
	M) Iron Sight Alignment						6/11/90	RW
	N) Detach Front & Rear Sights & place in numbered container						6/11/90	RW
	O) Attach Scope to Rifle						6/11/90	WB
	P) Detach & Attach Scope 20 Times						6/11/90	WB
640	Gallery Target & Test						6-12-90	KA
	A) Time						"	KA
	B) Malfunctions						"	KA
	C) Pierced Primers						"	KA
	D) Optical Clarity of Scope						"	KA
645	Inspect for Live Ammo						6-12-90	KA
655	Final Inspection							
	A) Headspace						4/14/90	RM
	B) Trigger Pull	2.50	2.53	2.59	2.60	2.60	6-14-90	RU
	C) Function						4/14/90	DL
660	Pack						6-20-90	DA

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#
3.00# + .75#
4.00# + 1.00#

SERIAL NO. C6498878DATE 6-5-90TESTER JU

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.36	2.42	2.39	2.50	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.20	2.41	2.40	2.53	
PULL #3	2.48	2.39	2.36	2.59	
PULL #4	2.48	2.39	2.36	2.60	
PULL #5	2.51	2.33	2.35	2.60	
TOTAL	12.09	11.94	11.86		
AVG.	2.42	2.388	2.372		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.21	3.32		
PULL #2	3.19	3.33		
PULL #3	3.32	3.37		
PULL #4	3.33	3.21		
PULL #5	3.35	3.39		
TOTAL	16.40	16.73		
AVG.	3.28	3.346		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.33	4.16		4.38
PULL #2	4.32	4.22		4.45
PULL #3	4.33	4.20		4.38
PULL #4	4.31	4.15		4.43
PULL #5	4.39	4.20		4.42
TOTAL	21.68	20.93		22.06
AVG.	4.336	4.186		4.412

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6498878
13 Jun 1990

CENTROIDAL DISTANCES

0 TO	1	.715839
1 TO	2	.682015
1 TO	3	.382655
1 TO	4	.399344
1 TO	5	.199379

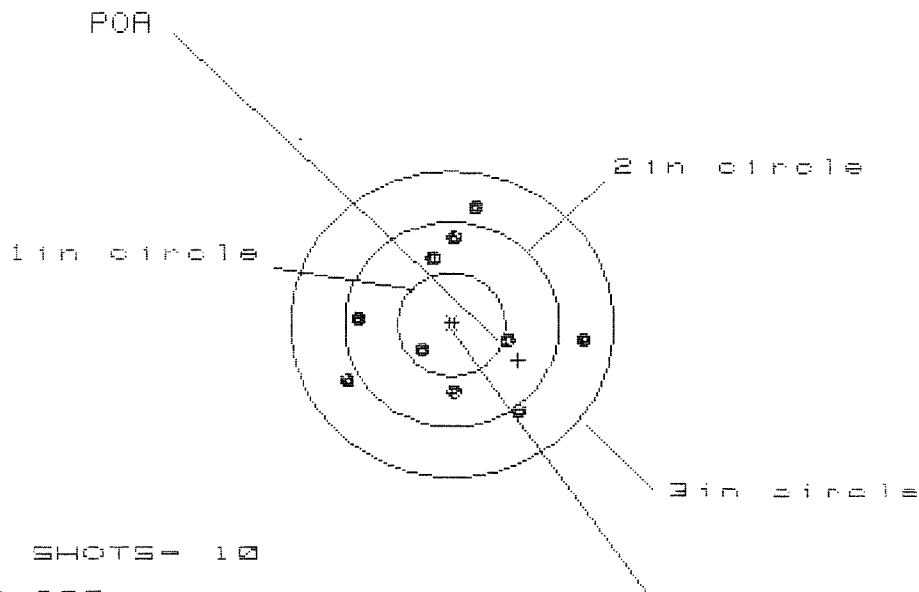
$\frac{1}{2} \frac{b}{a} +$ (---POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.5342
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0942
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .542442
THE AMR FOR THIS RIFLE IS: .7886

13 Jun 1998

FILE:/PATTERNING/CENTERFIRE_PATT/CS498878

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1 in = 2

2 in = 6

3 in = 10

HS= 2.210

VS= 1.915

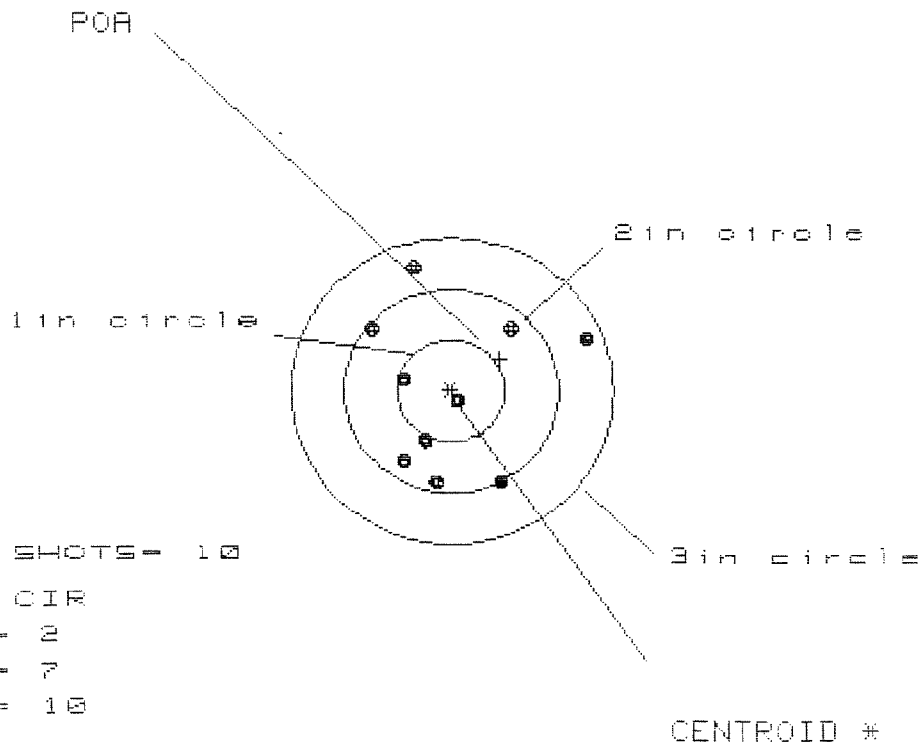
GS= 2.238

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.189	.725	.614
MINIMUM X	-1.021	-.889	-.903
MAXIMUM Y	1.106	1.088	1.022
MINIMUM Y	-.809	-.827	-.893
CENTROID X	-.625	-.757	-.646
CENTROID Y	.349	.367	.433
POA TO CENTROID in.	.715	.841	.778
MIN RADIUS	.432	.359	.478
MEAN RADIUS	.842	.792	.758
MAX RADIUS	1.200	1.134	1.084
HORIZONTAL SPREAD	2.210	1.614	1.517
VERTICAL SPREAD	1.915	1.915	1.915
EXTREME SPREAD	2.238	2.021	1.958
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	10		

13 Jun 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C8496878

CENTERFIRE PATTERNS # 2



OF SHOTS - 10

IN CIR

1 in = 2

2 in = 7

3 in = 10

HS = 2.030

VS = 2.074

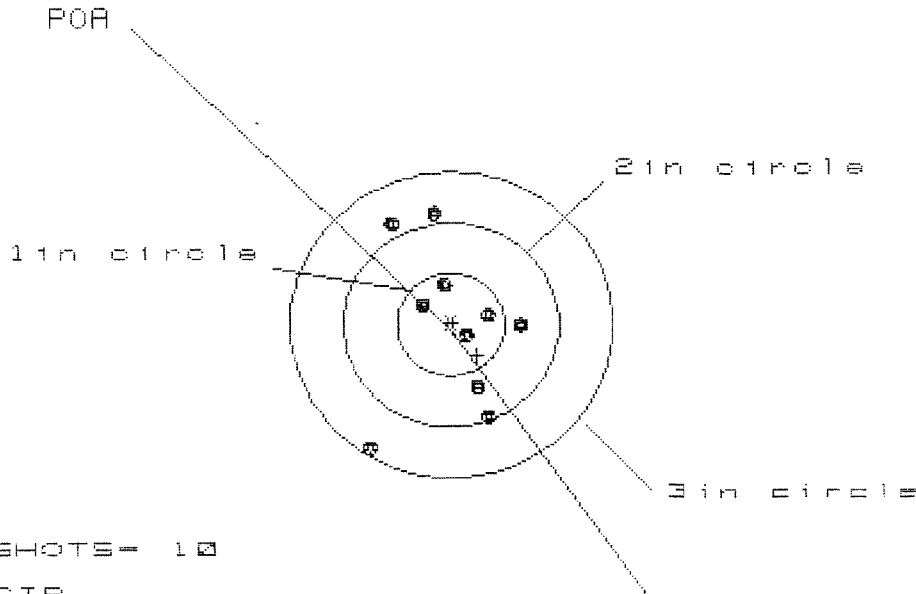
GS = 2.222

PATTERN #	2
SHOTS (BEST OF)	10
MAXIMUM X	1.238
MINIMUM X	-.792
MAXIMUM Y	1.188
MINIMUM Y	-.886
CENTROID X	-.457
CENTROID Y	-.312
POA TO CENTROID in.	.554
MIN RADIUS	.140
MEAN RADIUS	.824
MAX RADIUS	1.343
HORIZONTAL SPREAD	2.030
VERTICAL SPREAD	2.074
EXTREME SPREAD	2.222
NUMBER IN ONE INCH CIRCLE	2
NUMBER IN TWO INCH CIRCLE	7
NUMBER IN THREE INCH CIRCLE	10

13 Jun 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6498878

CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1in = 4

2in = 7

3in = 10

HS = 1.374

VS = 2.382

GS = 2.457

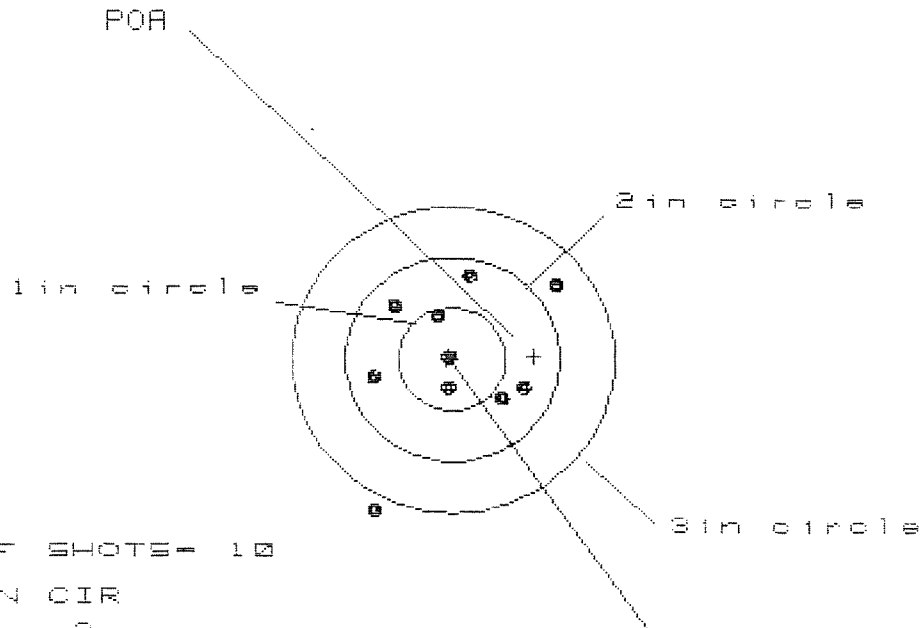
CENTROID *

PATTERN #	:	3	
SHOTS (BEST OF)	:	10	9
MAXIMUM X	:	.660	.581
MINIMUM X	:	-.714	-.630
MAXIMUM Y	:	1.136	.997
MINIMUM Y	:	-1.246	-1.005
CENTROID X	:	-.245	-.166
CENTROID Y	:	.384	.443
POA TO CENTROID in.	:	.391	.473
MIN RADIUS	:	.147	.220
MEAN RADIUS	:	.727	.633
MAX RADIUS	:	1.436	1.080
HORIZONTAL SPREAD	:	1.374	1.211
VERTICAL SPREAD	:	2.382	2.002
EXTREME SPREAD	:	2.457	2.101
NUMBER IN ONE INCH CIRCLE	=	4	
NUMBER IN TWO INCH CIRCLE	=	7	
NUMBER IN THREE INCH CIRCLE	=	10	

13 Jun 1998

FILE:/PATTERNING/CENTERFIRE_PATT/06496878

CENTERFIRE PATTERNS # 4



OF SHOTS = 10

IN CIR

1in = 3

2in = 8

3in = 9

CENTROID #

HS = 1.652

VS = 2.238

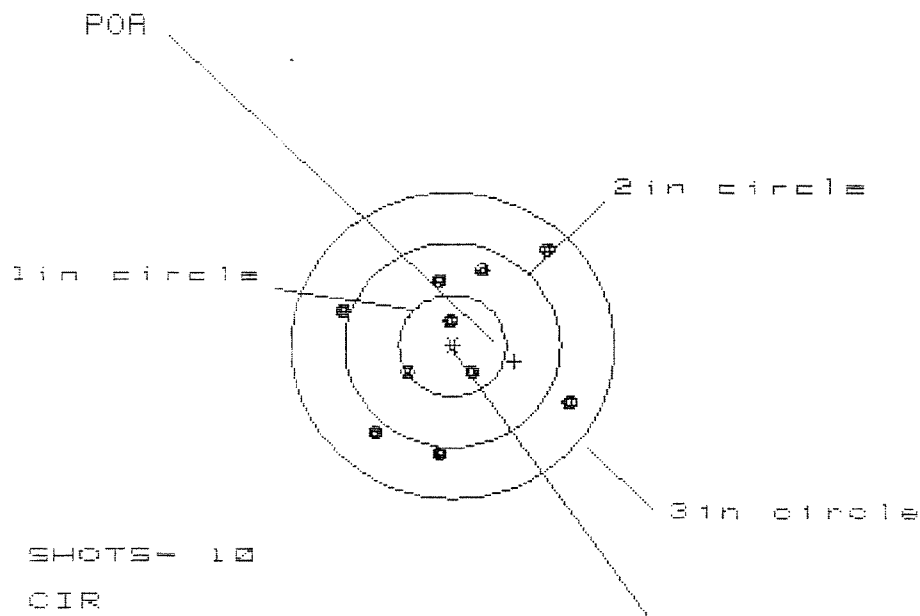
GS = 2.723

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.917	.838	.650
MINIMUM X	:	-.735	-.814	-.709
MAXIMUM Y	:	.797	.637	.711
MINIMUM Y	:	-1.440	-.553	-.479
CENTROID X	:	-.765	-.686	-.791
CENTROID Y	:	-.025	.135	.061
POA TO CENTROID in.	:	.765	.699	.793
MIN RADIUS	:	.035	.144	.065
MEAN RADIUS	:	.714	.617	.546
MAX RADIUS	:	1.604	1.023	.773
HORIZONTAL SPREAD	:	1.652	1.652	1.359
VERTICAL SPREAD	:	2.238	1.190	1.190
EXTREME SPREAD	:	2.723	1.915	1.376
NUMBER IN ONE INCH CIRCLE =			3	
NUMBER IN TWO INCH CIRCLE =			8	
NUMBER IN THREE INCH CIRCLE =			9	

13 Jun 1988

FILE:/PATTERNING/CENTERFIRE_PATT/06498878

CENTERFIRE PATTERNS # 5



OF SHOTS - 10

IN CIR

1 in = 2

2 in = 5

3 in = 10

HS = 2.108

VS = 1.967

GS = 2.436

CENTROID #

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.079	1.181	.480
MINIMUM X	-1.029	-.927	-.780
MAXIMUM Y	.935	.818	.760
MINIMUM Y	-1.032	-.928	-.986
CENTROID X	-.579	-.681	-.828
CENTROID Y	.155	.051	.109
POA TO CENTROID in.	.599	.683	.835
MIN RADIUS	.294	.342	.298
MEAN RADIUS	.836	.779	.710
MAX RADIUS	1.309	1.267	.994
HORIZONTAL SPREAD	2.108	2.108	1.260
VERTICAL SPREAD	1.967	1.746	1.746
EXTREME SPREAD	2.436	2.299	1.843
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	10		