C625306

MODEL 700™ M24

Model 700 M24™

Action

Barrel Length

Capacity

Order No. 5716

*Includes 1 in chamber.

Remington

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: RE00085928
Verify Repair

Serial: C6225306 Model: M24 SWS Center Fire Caliber: 7.62 NATO

Repairman:
Status: Closed 10/4/2004 10:55:07 AM

Address Information

Customer	Received From	Return To	Received From
Name:	TRANSPORTATION OFFICER	TRANSPORTATION OFFICER	
Address 1:	SENSITIVE STORAGE	SENSITIVE STORAGE	
Address 2:	BLDG 9660 PO Box:	BLDG 9660 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 5516
Fax:
Email:
Comments:

Received Condition

Fair
Condition Notes:
CSR Notes:

Accessories Received

Code	Desc	Qty
A007	With Studs	3
A017	Scope Bases	3

Repair Search | Refresh | Close

neglet | 10/4/2004 | 11:25 AM | CAPS | NUM | INS | SCRL

start | 3 | 4

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFOMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6225306.__0
FILE DATE AND TIME: 11/06/2004 05:13

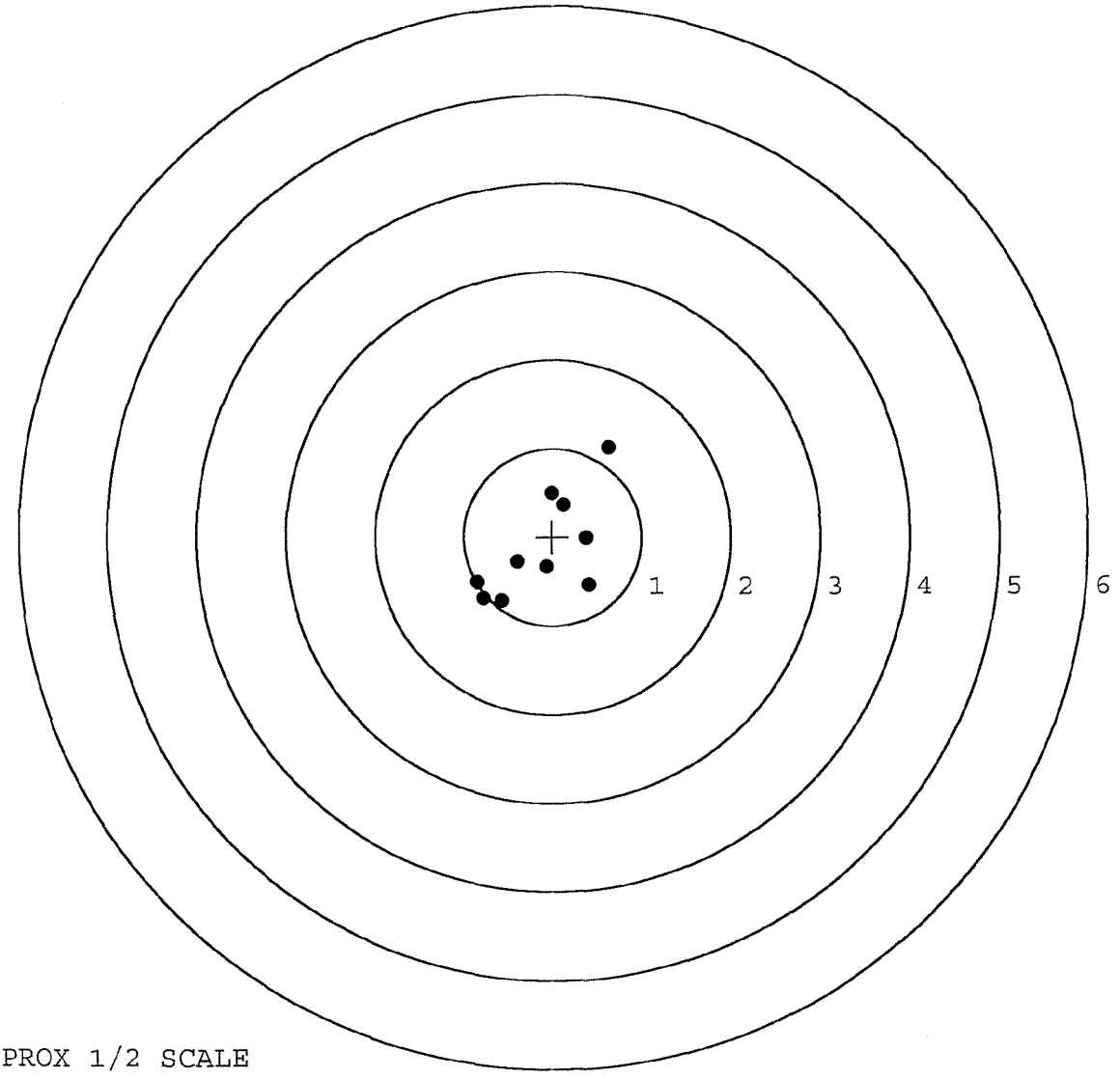
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.158
The Average Y Centroid of the Five Target Set:	0.223
The Average Point of Impact of the Five Target Set:	0.274
The Average Mean Radius of the Five Target Set:	0.577
The Distance from POA to Centroid Target #1:	0.168
The Distance from Centroid Target #2 to Centroid Target #1:	1.550
The Distance from Centroid Target #3 to Centroid Target #1:	0.374
The Distance from Centroid Target #4 to Centroid Target #1:	0.149
The Distance from Centroid Target #5 to Centroid Target #1:	0.228

SERIAL NUMBER: C6225306.__0
TARGET NUMBER: 1
FILE DATE: 11/06/2004
FILE TIME: 05:13

X CENTROID:	-0.113
Y CENTROID:	-0.124
POA TO CENTROID:	0.168
HORZ SPREAD:	1.483
VERT SPREAD:	1.735
GROUP SPREAD:	2.221
MIN RADIUS:	0.223
MAX RADIUS:	1.360
MEAN RADIUS:	0.673
# IN 1 IN DIAMETER:	2
# IN 2 IN DIAMETER:	9
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	0.632	1.014
2:	0.126	0.363
3:	-0.014	0.500
4:	0.382	-0.011
5:	0.412	-0.544
6:	-0.067	-0.342
7:	-0.395	-0.280
8:	-0.576	-0.721
9:	-0.782	-0.699
10:	-0.851	-0.517

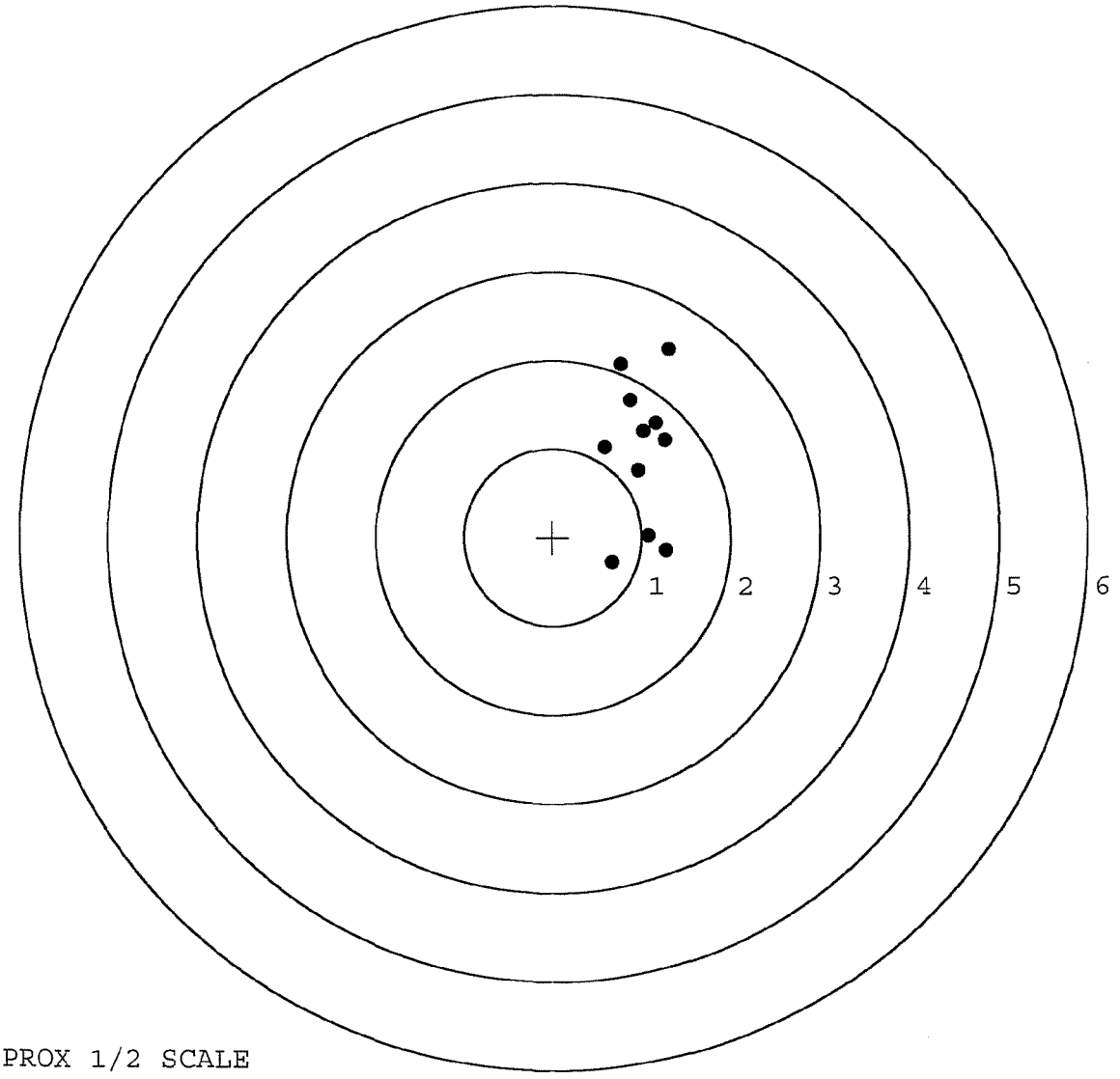


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6225306.__0
TARGET NUMBER: 2
FILE DATE: 11/06/2004
FILE TIME: 05:13

X CENTROID:	0.993
Y CENTROID:	0.961
POA TO CENTROID:	1.382
HORZ SPREAD:	0.715
VERT SPREAD:	2.409
GROUP SPREAD:	2.490
MIN RADIUS:	0.209
MAX RADIUS:	1.288
MEAN RADIUS:	0.702
# IN 1 IN DIAMETER:	5
# IN 2 IN DIAMETER:	7
# in 3 IN DIAMETER:	11

POINT#	X	Y
1:	0.954	0.756
2:	1.298	2.124
3:	0.763	1.954
4:	0.871	1.553
5:	1.160	1.290
6:	1.018	1.197
7:	1.255	1.095
8:	0.583	1.018
9:	1.075	0.024
10:	1.279	-0.151
11:	0.668	-0.285

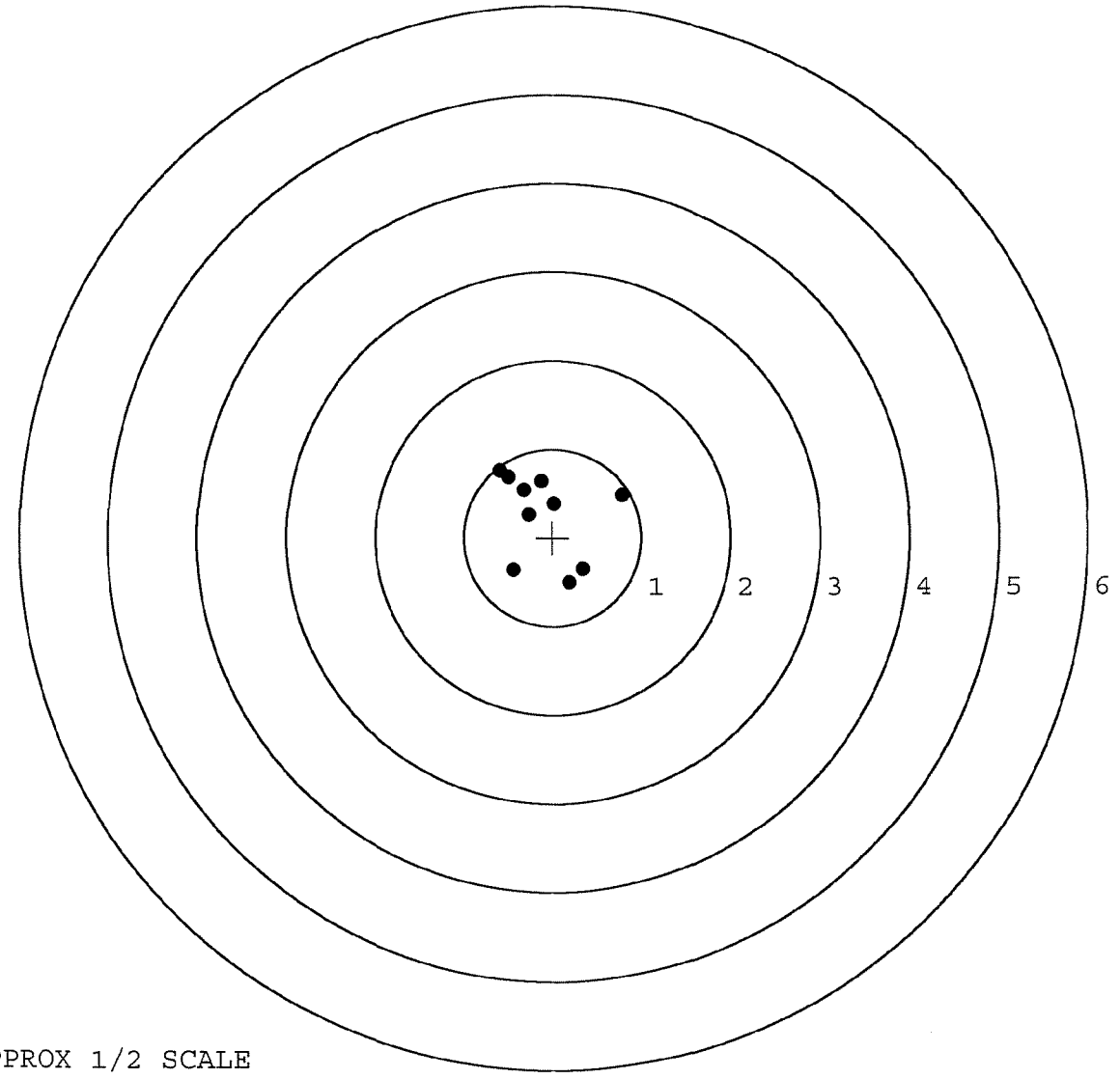


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6225306.__0
TARGET NUMBER: 3
FILE DATE: 11/06/2004
FILE TIME: 05:13

X CENTROID:	-0.094
Y CENTROID:	0.250
POA TO CENTROID:	0.267
HORZ SPREAD:	1.376
VERT SPREAD:	1.268
GROUP SPREAD:	1.492
MIN RADIUS:	0.172
MAX RADIUS:	0.906
MEAN RADIUS:	0.559
# IN 1 IN DIAMETER:	4
# IN 2 IN DIAMETER:	10
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	0.782	0.480
2:	0.343	-0.354
3:	0.189	-0.513
4:	-0.443	-0.372
5:	0.013	0.385
6:	-0.267	0.259
7:	-0.139	0.636
8:	-0.327	0.539
9:	-0.496	0.685
10:	-0.594	0.755

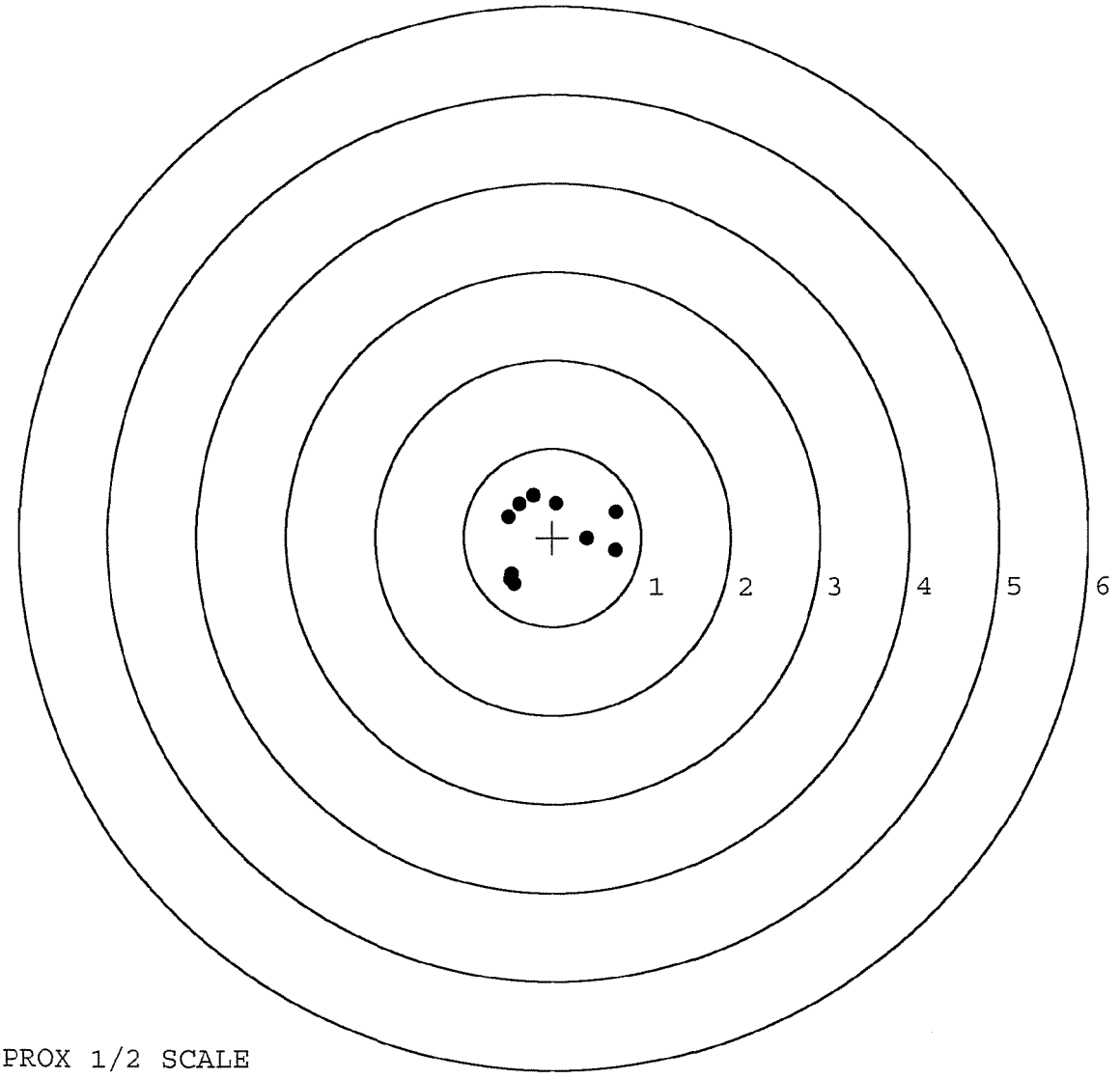


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6225306.__0
TARGET NUMBER: 4
FILE DATE: 11/06/2004
FILE TIME: 05:13

X CENTROID:	-0.062
Y CENTROID:	0.016
POA TO CENTROID:	0.064
HORZ SPREAD:	1.214
VERT SPREAD:	0.993
GROUP SPREAD:	1.417
MIN RADIUS:	0.379
MAX RADIUS:	0.825
MEAN RADIUS:	0.578
# IN 1 IN DIAMETER:	5
# IN 2 IN DIAMETER:	10
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	0.039	0.381
2:	-0.225	0.472
3:	-0.386	0.374
4:	-0.496	0.227
5:	-0.475	-0.480
6:	0.391	-0.014
7:	0.710	-0.147
8:	0.718	0.284
9:	-0.463	-0.413
10:	-0.436	-0.521

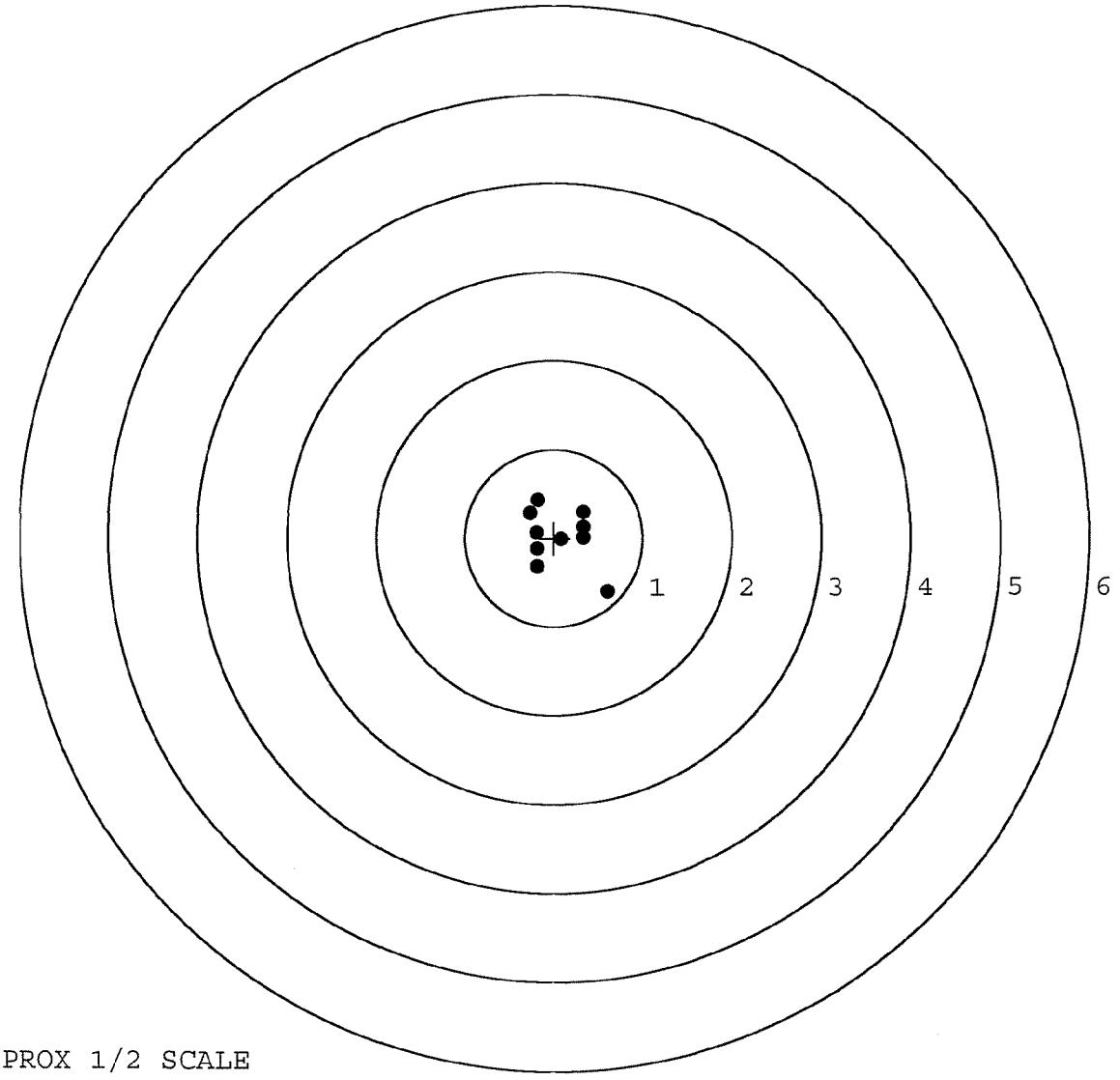


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6225306.__0
TARGET NUMBER: 5
FILE DATE: 11/06/2004
FILE TIME: 05:13

X CENTROID:	0.068
Y CENTROID:	0.013
POA TO CENTROID:	0.070
HORZ SPREAD:	0.869
VERT SPREAD:	1.033
GROUP SPREAD:	1.296
MIN RADIUS:	0.033
MAX RADIUS:	0.820
MEAN RADIUS:	0.370
# IN 1 IN DIAMETER:	9
# IN 2 IN DIAMETER:	10
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	-0.175	0.428
2:	-0.261	0.280
3:	-0.196	0.065
4:	-0.190	-0.126
5:	-0.192	-0.332
6:	0.081	-0.017
7:	0.336	0.012
8:	0.336	0.130
9:	0.338	0.296
10:	0.608	-0.605



TARGET APPROX 1/2 SCALE

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

R & E NUMBER	85928		
SERIAL NUMBER	C622 5306		
LOG-IN DATE	10-4-04		
INSPECT AND VERIFY:			
OPERATION #	OPERATION NAME	DATE	INITIAL
550	DIS-ASSEMBLE GUN	10-13-04	RTC
560 A	RE-BARREL	10-14-04	RTC
B	DRILL AND TAP	10-19-04	TRW
575	ASSEMBLE	10-15-04	RTC
600	PROOF	10-18-04	RTC
605	CHECK HEADSPACE	10-18-04	RTC
610	DIS-ASSEMBLE GUN	10-19-04	RTC
612	MAGNAFLUX		
615	ROLLMARK CALIBER	10/20/04	JS
618	ROTO-BLAST	10-22-04	LB
620	APPLY COATINGS	10/26/04	MP
625 A	FINAL ASSEMBLY		
B	TRIGGER PULL TEST		
C	SAFETY "ON" FORCE		
D	SAFETY "OFF" FORCE		
E	FIRING PIN INDENT		
640	TARGET	11-6-04	RTC
655	FINAL INSPECT	11-8-04	RTC
660	PACK	11-8-04	MA
		SHIP DATE	
	QAR INSPECTION DATE		

Scope # 1275

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6225306

OP.#	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and stock	8	9/88	FB
600	Proof	9	7/88	RW
607	Check Headspace	9	7/88	RW
610	Dis-assemble gun	9	7/88	RW
612	Magnaflux Barrel Action		9-14-88	pfc.
	Magnaflux Bolt		9-14-88	pfc.
615	Rollmark Caliber			
617	Drill & Tap Sight Holes			
618	Polish Barrel			
620	Apply Coatings (Barrel Action)		10-31-88	TJA
	Apply Coatings (Bolt)		1031-88	TJA
625	Final Assembly A)Clean inside of Bolt Assembly		11/9/88	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		11/9/88	RW
	C) Inspect Ejector Hole for Chamfer		11/9/88	RW

OVER

OP.#		READINGS	DATE	INITIAL
625 cont.	D) Oil Firing Pin Ass'y		11/9/88	RW
	E) Adjust Trigger Pull to Min. Setting and Stake		9 NOV 88	JH
	F) Safety on Force	5 5 5	11 NOV 88	JH
	G) Safety off Force	3 3 3	11 NOV 88	JH
	H) Trigger Pull Test & Retainabilty		9 NOV 88	JH
	I) Firing Pin Indent	.0205 .0205 .0205	11 NOV 88	JH
	J) Assemble Stock		11/15/88	RW
	K) Assemble Swivel Studs		30 NOV 88	JH
	L) Attach Front & Rear Sight Assemblies		11/15/88	RW
	M) Iron Sight Alignment		11/15/88	RW
	N) Detach Front & Rear Sights & place in numbered container		11/15/88	RW
	0) Attach Scope to Rifle		11/16/88	WB
	P) Detach & Attach Scope 20 times		11/16/88	WB
640	Gallery Target & Test	53 R 100 L	11/16/88	DH
	A) Optical Clearity of Scope		11/16/88	DH
645	Inspect for Live Ammo		11/16/88	DH
655	Final Inspection A) Headspace		30 NOV 88	JH
	B) Trigger Pull		30 NOV 88	JH
	C) Function		30 NOV 88	JH
660	Pack		14 Dec 88	JH.

0.2

SWS TRIGGER PULL TEST

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

SERIAL NO. C622.5306

DATE 11-9-88

TESTER J.Z.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.46	2.42	2.45	2.71	MIN. SETTING,
PULL #2	2.44	2.33	2.41	2.68	NO AVG. OF 5
PULL #3	2.39	2.30	2.42	2.36	READINGS ACCEPT-
PULL #4	2.44	2.24	2.42	2.60	ABLE LESS THAN 2#
PULL #5	2.42	2.36	2.50	2.60	
TOTAL	12.15	11.65	12.20	12.97	
AVG.	2.43	2.33	2.44	2.594	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.15	3.15		
PULL #2	3.11	3.22		
PULL #3	3.18	3.16		
PULL #4	3.15	3.12		
PULL #5	3.18	3.22		
TOTAL	15.77	15.87		
AVG.	3.154	3.174		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.21	4.10		4.13
PULL #2	4.07	4.13		4.12
PULL #3	4.19	4.13		4.15
PULL #4	4.13	4.13		4.20
PULL #5	4.15	4.17		4.14
TOTAL	20.75	20.66		20.74
AVG.	4.15	4.132		4.148

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6225306

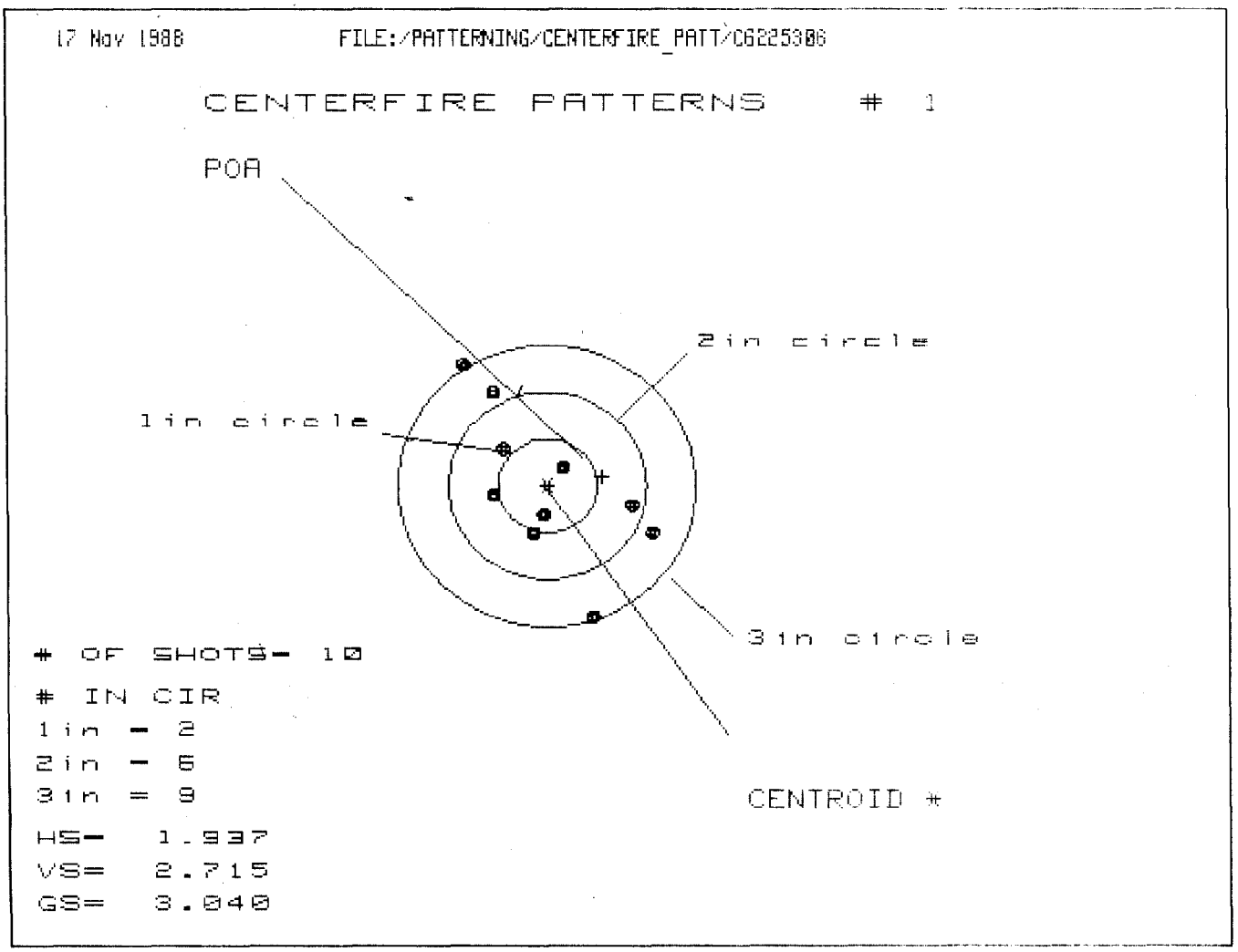
CENTROIDAL DISTANCES

Ø	TO	1	.563761
1	TO	2	.747916
1	TO	3	.661007
1	TO	4	.438846
1	TO	5	.697672

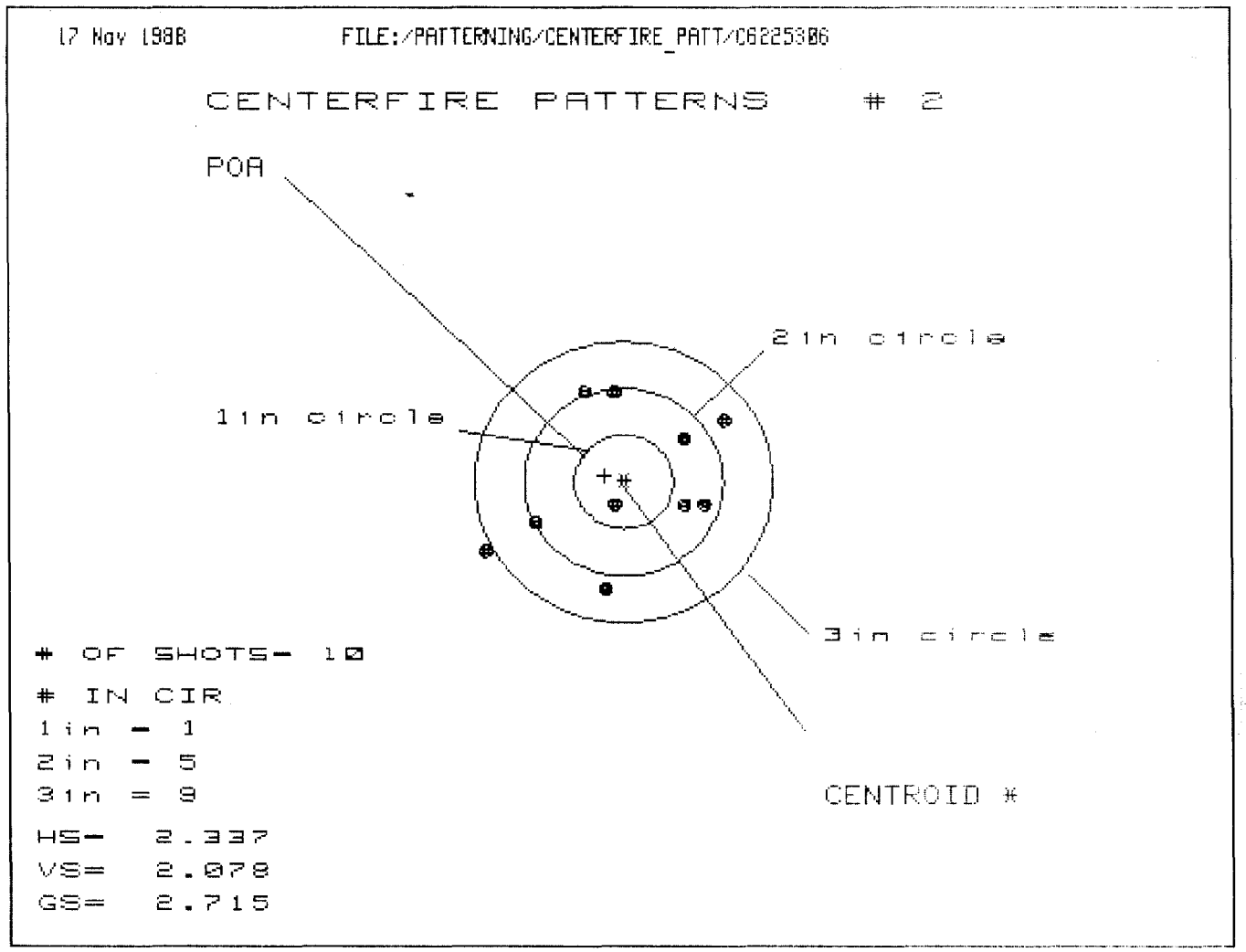
1 4 5 2 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0594
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0162
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0615695

THE AMR FOR THIS RIFLE IS: .909



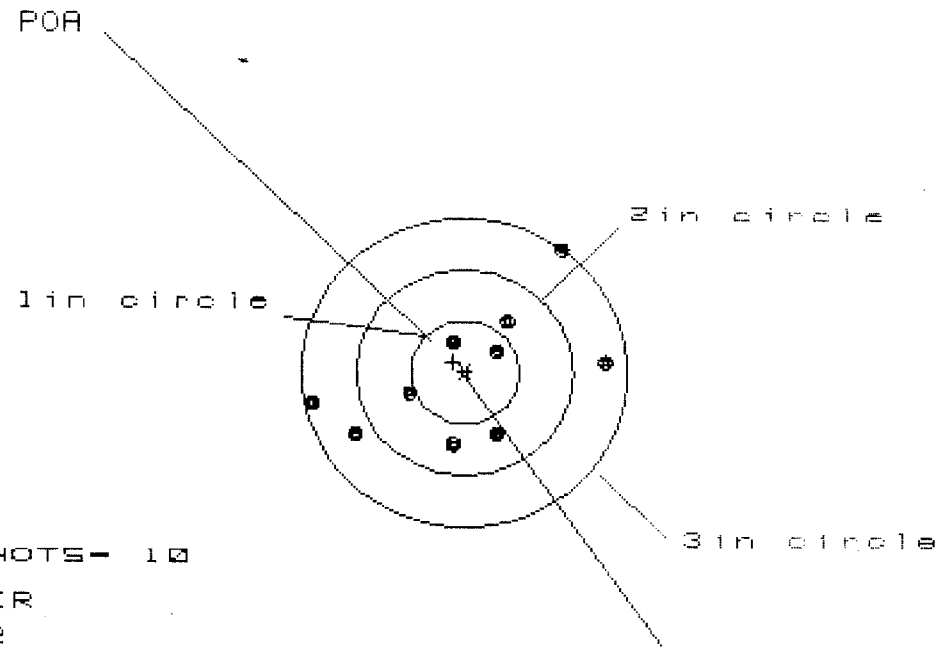
PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.048	.949	.996
MINIMUM X	:	-.889	-.613	-.566
MAXIMUM Y	:	1.319	1.101	.945
MINIMUM Y	:	-1.396	-1.250	-.513
CENTROID X	:	-.555	-.456	-.503
CENTROID Y	:	-.099	-.245	-.089
POA TO CENTROID in.	:	.564	.518	.511
MIN RADIUS	:	.257	.147	.248
MEAN RADIUS	:	.843	.750	.672
MAX RADIUS	:	1.591	1.306	1.121
HORIZONTAL SPREAD	:	1.937	1.562	1.562
VERTICAL SPREAD	:	2.715	2.351	1.458
EXTREME SPREAD	:	3.040	2.546	2.126
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	



PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.973	.822	.782
MINIMUM X	:	-1.364	-1.069	-.966
MAXIMUM Y	:	.957	.875	.946
MINIMUM Y	:	-1.121	-1.203	-1.132
CENTROID X	:	.192	.343	.240
CENTROID Y	:	-.062	.020	-.051
POA TO CENTROID in.	:	.201	.344	.246
MIN RADIUS	:	.256	.407	.289
MEAN RADIUS	:	.944	.857	.837
MAX RADIUS	:	1.548	1.256	1.161
HORIZONTAL SPREAD	:	2.337	1.891	1.749
VERTICAL SPREAD	:	2.078	2.078	2.078
EXTREME SPREAD	:	2.715	2.173	2.088
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

17 Nov 1988 FILE:/PATTERNING/CENTERFIRE_PATT/C6225306

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

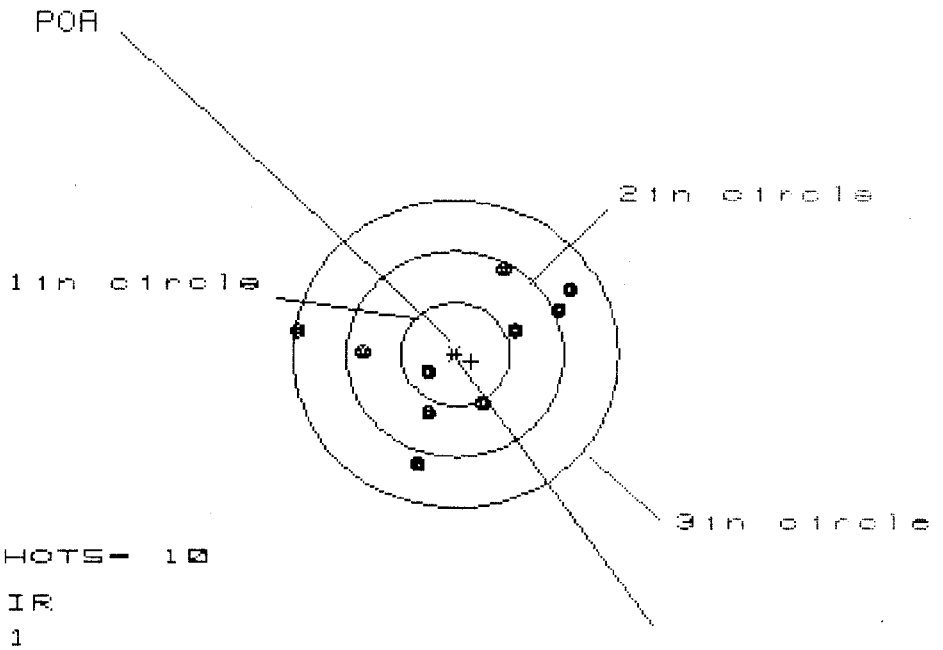
# IN CIR
1in = 2
2in = 6
3in = 10

HS= 2.675
VS= 1.881
GS= 2.708

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.269	1.365	1.202
MINIMUM X	:	-1.406	-1.310	-1.084
MAXIMUM Y	:	1.219	.637	.623
MINIMUM Y	:	-.662	-.527	-.541
CENTROID X	:	.106	.010	.173
CENTROID Y	:	-.102	-.237	-.223
POA TO CENTROID in.	:	.147	.237	.282
MIN RADIUS	:	.333	.455	.382
MEAN RADIUS	:	.861	.787	.708
MAX RADIUS	:	1.497	1.380	1.216
HORIZONTAL SPREAD	:	2.675	2.675	2.286
VERTICAL SPREAD	:	1.881	1.164	1.164
EXTREME SPREAD	:	2.708	2.693	2.379
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	

17 Nov 1988 FILE:/PATTERNING/CENTERFIRE_PATT/CS225306

CENTERFIRE PATTERNS # 4

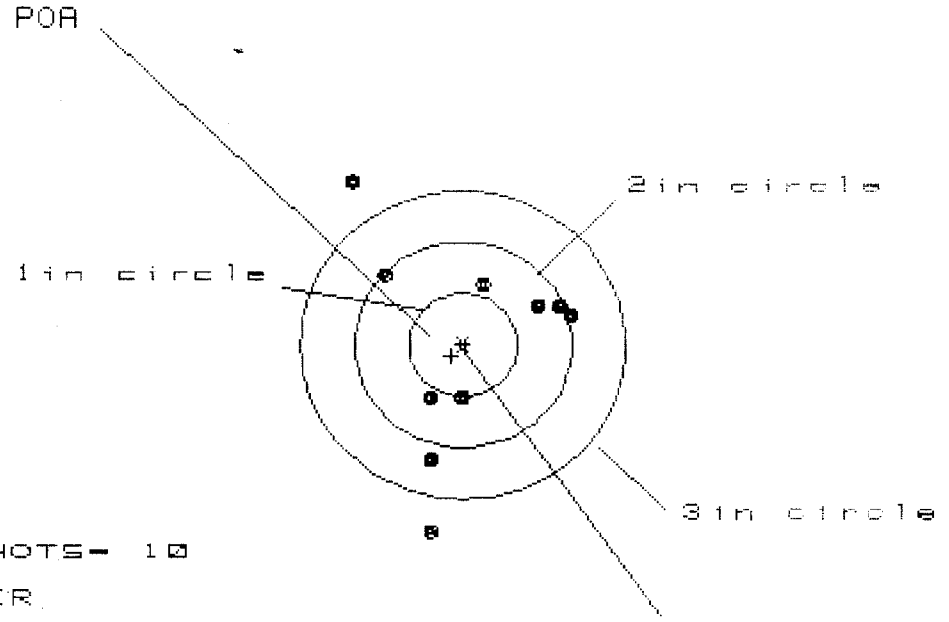


# OF SHOTS= 10
# IN CIR
1in = 1
2in = 6
3in = 10
HS= 2.460
VS= 1.933
GS= 2.502

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.025	.865	.872
MINIMUM X	:	-1.435	-1.041	-.933
MAXIMUM Y	:	.844	.867	.952
MINIMUM Y	:	-1.089	-1.066	-.981
CENTROID X	:	-.150	.010	-.098
CENTROID Y	:	.070	.047	-.038
POA TO CENTROID in.	:	.165	.048	.105
MIN RADIUS	:	.339	.427	.341
MEAN RADIUS	:	.874	.797	.743
MAX RADIUS	:	1.449	1.171	1.051
HORIZONTAL SPREAD	:	2.460	1.906	1.805
VERTICAL SPREAD	:	1.933	1.933	1.933
EXTREME SPREAD	:	2.502	2.209	2.083
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	

17 Nov 1988 FILE:/PATTERNING/CENTERFIRE_PATT/C8225306

CENTERFIRE PATTERNS # 5



# OF SHOTS= 10
# IN CIR
1in = 1
2in = 6
3in = 8
HS= 1.969
VS= 3.422
GS= 3.485

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.969	.858	.802
MINIMUM X	:	-1.000	-.773	-.829
MAXIMUM Y	:	1.630	.859	.658
MINIMUM Y	:	-1.792	-1.611	-1.157
CENTROID X	:	.110	.221	.277
CENTROID Y	:	.112	-.069	.132
POA TO CENTROID in.	:	.157	.231	.307
MIN RADIUS	:	.475	.332	.538
MEAN RADIUS	:	1.023	.908	.792
MAX RADIUS	:	1.912	1.673	1.253
HORIZONTAL SPREAD	:	1.969	1.631	1.631
VERTICAL SPREAD	:	3.422	2.470	1.815
EXTREME SPREAD	:	3.485	2.491	1.924
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

BARBER - M24 0012425

RECEIVING AND ESTIMATING REPORT

COMMENTS: M-24 SNIPER

ORDER: R 94-24904

INITIAL	CUSTOMER ORDER NO.
JJM	

DATE RECEIVED	DATE OPENED	DATE CODE	SERIAL NUMBER	NEW SERIAL NUMBER	MODEL AND GRADE
08/29/94	08/30/94	DI 9-88	CC6225306		700 7.62 NATO

ACCESSORIES: SCOPE MNTS SCOPE BASE

FROM:

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

SHIP TO:

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

CUST NO:062072 C.O.D.

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

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

REPAIR CHARGE	
EXCISE	
TAX	
INSURANCE	
UPS	
PARCEL POST	
TOTAL	

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

MAIN FAULT: New Barrel

PARTS

Barrel 96003
Mag Spring 15677

COMMENTS

Repowder Coat Trigger Guard Assy, Front & Rear Sight Bases Redinc Scope Base, Rings, & Swivel Studs

REPAIRMAN	PROOF	CLEAN	TEST	TARGET	PATTERN
RW	✓	✓	✓	2	
GALLERY TESTER	DATE	DATE	DATE	DATE	DATE
RW	9/1/94	9/12/94	9/12/94	9/12/94	

OFFICE COPY

RD6925 REV. 1/94

BARBER - M24 0012426

PACKING LIST

PACKED BY	1. NO. BOXES	2a. REQUISITION NO.
Mr. Ray Fuller WG-10 Bn. Armorer.	1	94239
		2b. ORDER NO.

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

4. DATE: 26 July 1994

5. PAGE 1 OF 1 PAGES

BOX NO. (a)	CONTENTS - STOCK NUMBER AND NOMENCLATURE (b)	UNIT OF ISSUE (c)	QUANTITIES REQUIRED: INITIAL OPERATION (d)	QUANTITIES REQUIRED: RUNNING SPARES (e)	QUANTITIES REQUIRED: TOTAL (f)
1	7.62 mm M24 Sniper Weapon System (SWS) Serial No. C6225306 NSN: 1005-01-240-2136	Ea			1

REGISTERED MAIL
R 768 625 193

Note: All Optic Scope Ring Mounts Packed

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

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

DD FORM 1 SEP 70 1750

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

BARBER - M24 0012426 M2400012465

MAINTENANCE REQUEST

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

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

SECTION I - EQUIPMENT DATA

CONTROL NUMBER	WORK ORDER NO.	WESDC	ORG. PD	PD AUTHENTICATION
	94239		02	CPT, IN

- [X] Work Request
- [ ] MWO
- [ ] Warranty Claim

1A. ORGANIZATION	B. LOCATION	C. UNIT IDENT CODE
Bn Arms HHC 2/75 RGR Rgt.	Fort Lewis Wa	WH3MAA

2. SERIAL NO.	3. NOUN NOMENCLATURE	4. LINE NO.	5. MODEL	6. NATIONAL STOCK NUMBER
C6225306	M24 SWS		M24	1005-01-240-2136

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

14. FAILURE DETECTED DURING *(Select one - use ✓ or X)*

- [ ] A Sch. Main.
- [ ] B Handling
- [X] C Test
- [ ] D Normal Op
- [ ] E Storage
- [ ] F Inspection
- [ ] G Flight
- [ ] H Other

15. FIRST INDICATION OF TROUBLE *(Select one - use ✓ or X)*

- [ ] 068 Inoperative
- [ ] 008 Noisy
- [ ] 258 Overheating
- [ ] 387 Low Performance
- [ ] 790 Out of Adjustment
- [X] Other

16A. DESCRIBE DEFICIENCIES OR SYMPTOMS ON THE BASIS OF COMPLETE CHECKOUT AND DIAGNOSTIC PROCEDURE IN EQUIPMENT TM *(Do not prescribe repairs).*

This weapon has fired over 10,000 Rds. During Bench Rest Test Fire at 200/300 Yds, groups were shot exceeding the criteria of 2.6" at 200 & 3.8" at 300 Yds CS-105 Lot Groups. This criteria was provided to by Mr Jim Gleason ARDEC DSN 880-7071

B. REMARKS

Request Re Barreling and Complete Weapon Reconditioning.

SECTION II - WORK ACCOMPLISHED

17A. REPAIR ORGANIZATION/ACTIVITY	C. UNIT IDENT. CODE	18. TYPE ORGANIZATION/ACTIVITY ACCOMPLISHING WORK *(Select one - use ✓ or X)*	19. AMS ACCT. CODE
B. LOCATION		[ ] 1 TOE [ ] 2 TD [ ] 3 Contractor	

20A. ACT. CODE	B. FAILURE CODE	C. COMPONENT/PART NOUN, SVC, OR MWO NO. (1) CB CODE	(2) REF DESIGN.	(3) MFR. CODE	D. MANHOURS *(Hrs. & tenths)*	E. NATIONAL STOCK NUMBER	F. PART SOURCE CODE	G. QTY.	H. PARTS COST
					.				$
					.				$
					.				$
					.				$
					.				$
					.				$
					.				$
					.				$
					.				$

I. TOTAL MANHOURS	J. TOTAL MANHOURS COST	K. TOTAL PARTS COST
	$	$

21. DELAY *(Select One)* [ ] 1 Parts [ ] 2 Manpower [ ] 3 Facilities [ ] 4 Funds [ ] 5 Tools

22. [ ] Data Transcribed

23. SUBMITTED BY	24. RECEIVED BY	25. WORK STARTED BY	26. INSPECTED BY	27. ACCEPTED BY
Ray Fuller				
JULIAN DATE 4235	JULIAN DATE	JULIAN DATE	JULIAN DATE	JULIAN DATE

28. DISPOSITION *(Select One)*

- [ ] A To User
- [ ] B To Stock
- [ ] C Salvaged
- [ ] D Evacuated
- [ ] E Cannibalization

DA FORM 2407, AUG 88 EDITION OF MAY 81 MAY BE USED NMP COPY 2

SWS/Repair

Final Inspection

Sn: C6225306 | Date Rec'd: 8/29/94 | Date Ret'd:

Auditor: RW

Item:

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

Item:

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

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

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

Trigger
- ___ Safety Operation
- ___ Set
- ___

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

Comments: _____

M-24

CONTRACT # DAAA21-87-C-0086 New Barrel

GUN SERIAL # C6225306

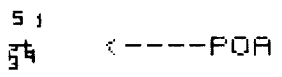
OP. #	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and Stock		9/1/94	RW
600	Proof		9/1/94	RW
607	Check Headspace		9/1/94	RW
610	Dis-assemble Gun		9/1/94	RW
612	Magnaflux Barrel Action			
	Magnaflux Bolt			
615	Rollmark Caliber			
617	Drill and Tap Sight Holes			
618	Polish Barrel			
620	Apply Coatings (Barrel Action)			
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		9/12/94	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		9/12/94	RW
	C) Inspect Ejector Hole for Chamfer		9/12/94	RW
	D) Oil Firing Pin Ass'y		9/12/94	RW
	E) Adjust Trigger Pull to Min Setting and Stake			

op. #	OP. NAME	READINGS	DATE	INIT
625 cont.	F) Safety On Force			
	G) Safety Off Force			
	H) Trigger Pull Test & Retainability			
	I) Firing Pin Indent			
	J) Assemble Stock			
	K) Assemble Swivel Studs			
	L) Attach Front and Rear Sight Assemblies			
	M) Iron Sight Alignment			
	N) Detach Front & Rear Sights & place in numbered container			
	O) Attach Scope to Rifle			
	P) Detach & Attach Scope 20 Times			
640	Gallery Target & Test		9/12	WB OK
	A) Time		9/12	BB OK
	B) Malfunctions		9/12	BB OK
	C) Pierced Primers		9/12	BB OK
	D) Optical Clearity of Scope		9/12	BB OK
645	Inspect for Live Ammo		9/12/94	RW
655	Final Inspection A) Headspace		9/14/94	RW
	B) Trigger Pull	2.27 2.29 2.29 2.26 2.29	9/14/94	RW
	C) Function		9/14/94	RW
660	Pack			

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6225306
15 Sep 1994

CENTROIDAL DISTANCES

Ø	TO	1	.561
1	TO	2	.737749
1	TO	3	.943445
1	TO	4	.669893
1	TO	5	.386412

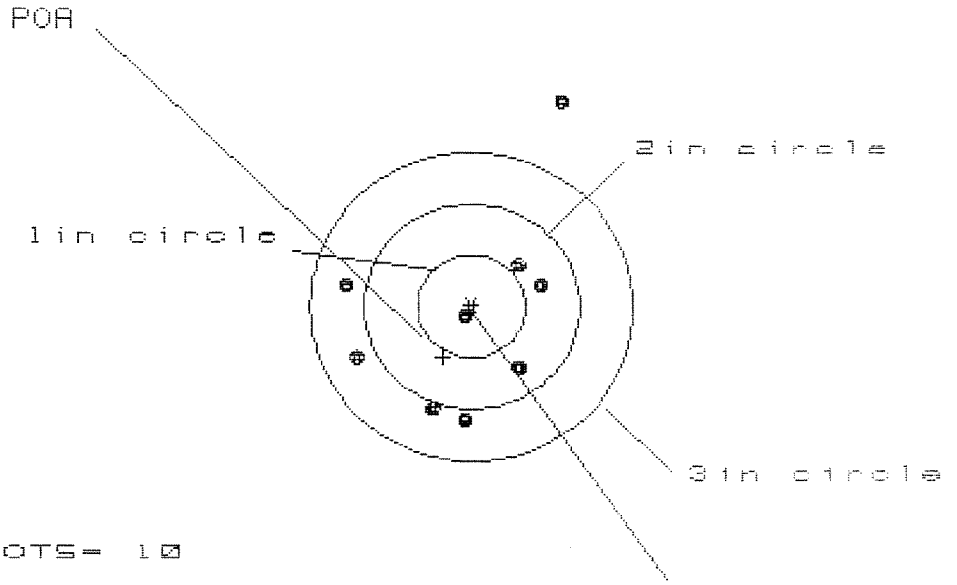


THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.039
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0974
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .104918

THE AMR FOR THIS RIFLE IS: .9152

15 Sep 1994 FILE:/PATTERNING/CENTERFIRE_PATT/C8225306

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

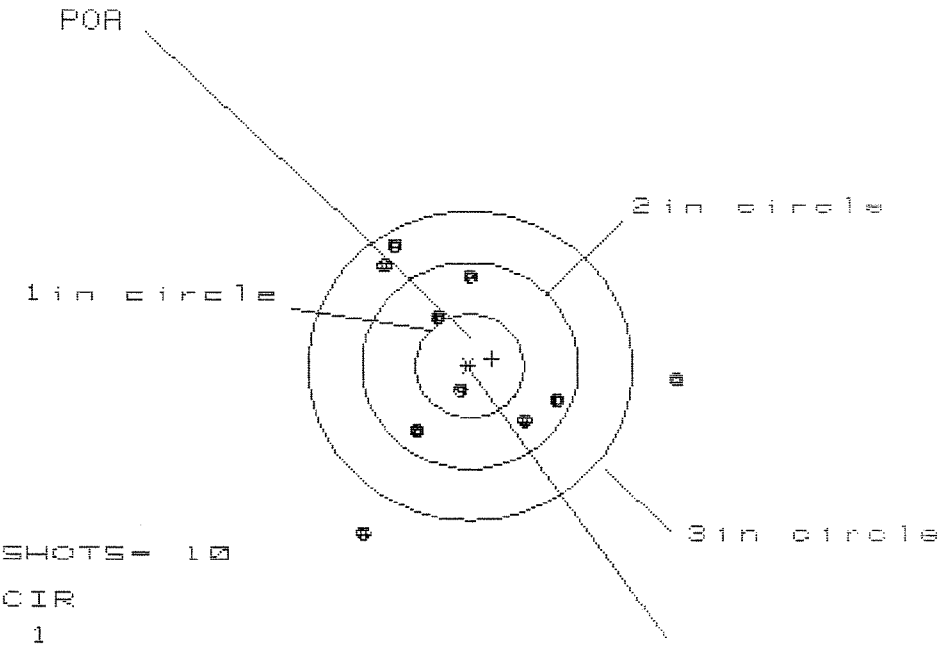
# IN CIR
1in = 1
2in = 5
3in = 9

HS= 1.985
VS= 3.151
GS= 3.279

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	
MAXIMUM X	:	.815	.686	.551
MINIMUM X	:	-1.170	-1.080	-1.062
MAXIMUM Y	:	2.042	.651	.701
MINIMUM Y	:	-1.109	-.882	-.88[illegible]
CENTROID X	:	.264	.174	.30[illegible]
CENTROID Y	:	.495	.268	.218
POA TO CENTROID in.	:	.561	.320	.378
MIN RADIUS	:	.158	.112	.221
MEAN RADIUS	:	.936	.778	.720
MAX RADIUS	:	2.198	1.152	1.089
HORIZONTAL SPREAD	:	1.985	1.766	1.613
VERTICAL SPREAD	:	3.151	1.533	1.53[illegible]
EXTREME SPREAD	:	3.279	1.791	1.77[illegible]
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

15 Sep 1994 FILE:/PATTERNING/CENTERFIRE_PATT/C6225306

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

# IN CIR
1in = 1
2in = 6
3in = 8

HS= 2.884
VS= 2.710
GS= 3.227

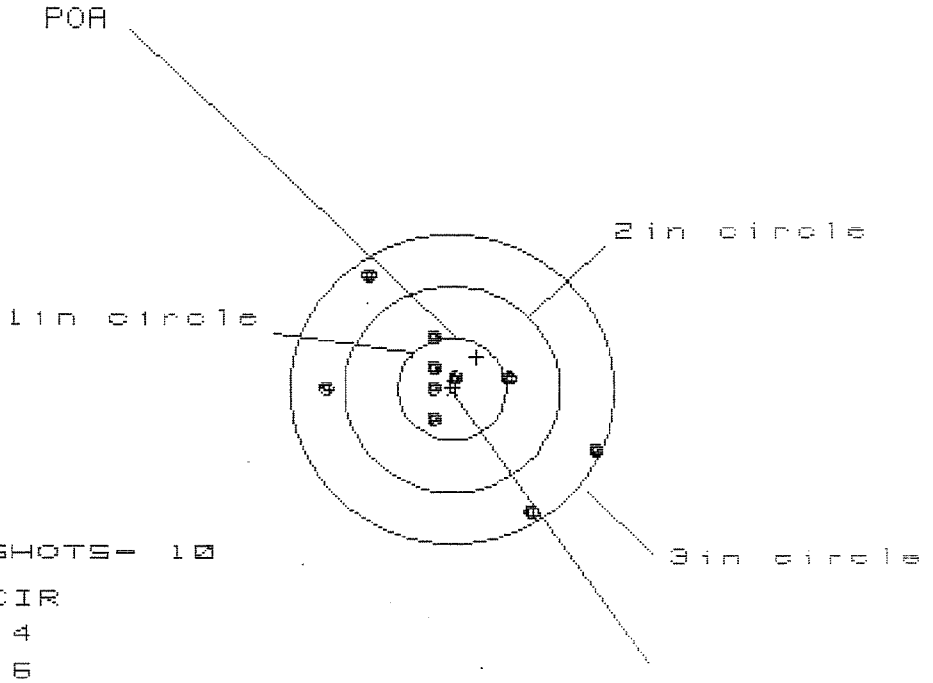
PATTERN # : 2

SHOTS (BEST OF) :	10	9	8
MAXIMUM X :	1.915	1.041	.946
MINIMUM X :	-.969	-.756	-.668
MAXIMUM Y :	1.128	1.113	.913
MINIMUM Y :	-1.582	-1.597	-.880
CENTROID X :	-.208	-.421	-.326
CENTROID Y :	-.072	-.057	.143
POA TO CENTROID in.:	.220	.425	.356
MIN RADIUS :	.239	.264	.326
MEAN RADIUS :	1.048	.940	.816
MAX RADIUS :	1.920	1.767	1.070
HORIZONTAL SPREAD :	2.884	1.797	1.614
VERTICAL SPREAD :	2.710	2.710	1.793
EXTREME SPREAD :	3.227	2.726	2.084

NUMBER IN ONE INCH CIRCLE = 1
NUMBER IN TWO INCH CIRCLE = 6
NUMBER IN THREE INCH CIRCLE = 8

15 Sep 1994 FILE:/PATTERNING/CENTERFIRE_PATT/C0225306

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

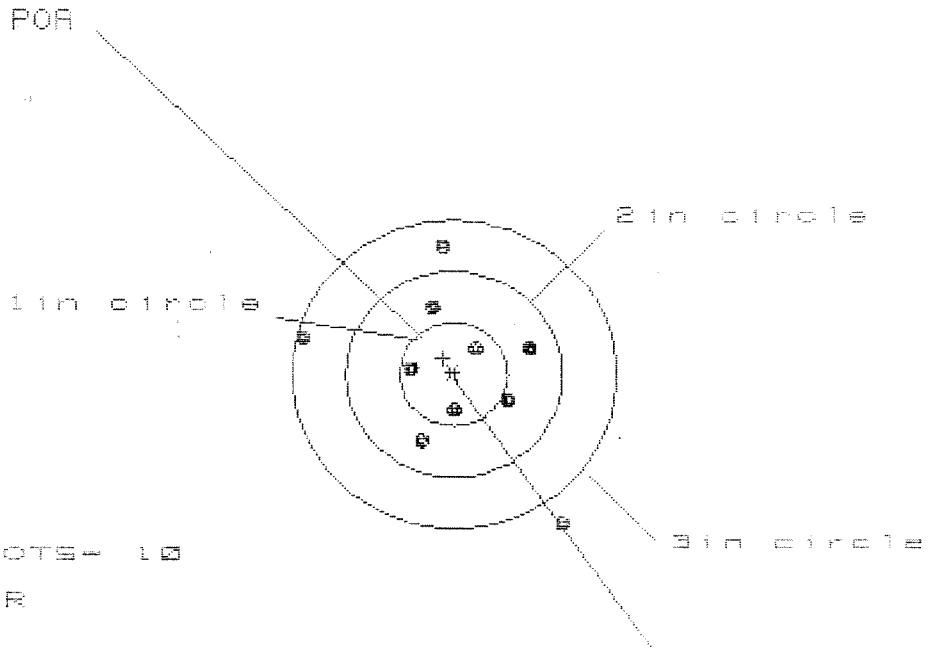
# IN CIR
1in = 4
2in = 6
3in = 10

HS= 2.435
VS= 2.302
GS= 2.705

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.298	.825	.807
MINIMUM X	:	-1.137	-.993	-.890
MAXIMUM Y	:	1.106	1.046	.889
MINIMUM Y	:	-1.196	-1.256	-.538
CENTROID X	:	-.228	-.372	-.475
CENTROID Y	:	-.310	-.250	-.092
POA TO CENTROID in.	:	.385	.448	.484
MIN RADIUS	:	.079	.043	.032
MEAN RADIUS	:	.728	.627	.520
MAX RADIUS	:	1.407	1.503	1.016
HORIZONTAL SPREAD	:	2.435	1.818	1.697
VERTICAL SPREAD	:	2.302	2.302	1.427
EXTREME SPREAD	:	2.705	2.705	1.701
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	

15 Sep 1994 FILE:/PATTERNING/CENTERFIRE_PATT/C82253B6

CENTERFIRE PATTERNS # 4



OF SHOTS= 10

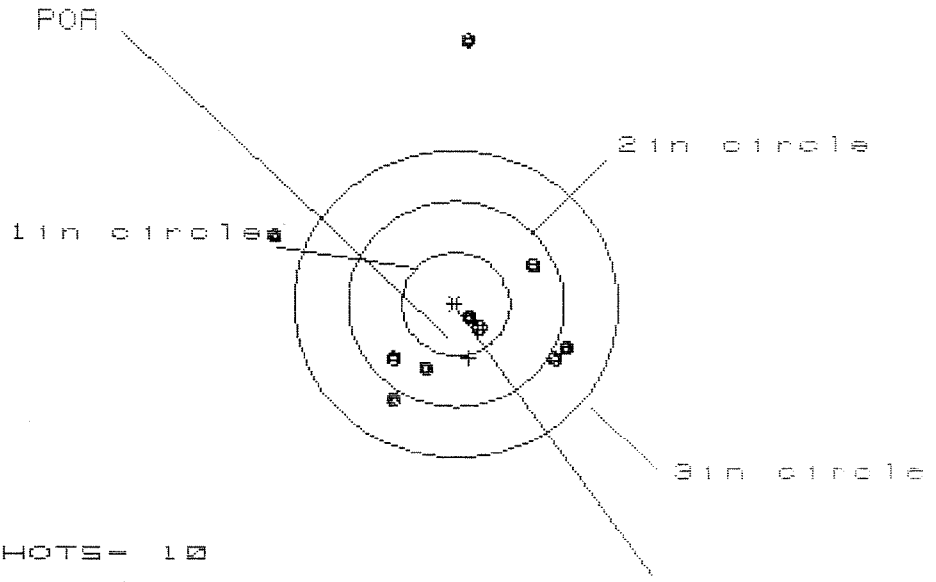
# IN CIR
1in = 3
2in = 7
3in = 9

HS= 2.409
VS= 2.697
GS= 3.012

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.044	.842	.685
MINIMUM X	:	-1.365	-1.249	-.434
MAXIMUM Y	:	1.218	1.054	1.074
MINIMUM Y	:	-1.479	-.839	-.819
CENTROID X	:	.098	-.018	.139
CENTROID Y	:	-.154	.010	-.010
POA TO CENTROID in.	:	.183	.020	.139
MIN RADIUS	:	.305	.288	.192
MEAN RADIUS	:	.825	.712	.622
MAX RADIUS	:	1.810	1.260	1.088
HORIZONTAL SPREAD	:	2.409	2.091	1.119
VERTICAL SPREAD	:	2.697	1.893	1.893
EXTREME SPREAD	:	3.012	2.095	1.902
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

15 Sep 1994 FILE:/PATTERNING/CENTERFIRE_PATT/CG225306

CENTERFIRE PATTERNS # 5



OF SHOTS= 10

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

HS= 2.723
VS= 3.427
GS= 3.486

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.042	1.053	.845
MINIMUM X	:	-1.681	-1.670	-.738
MAXIMUM Y	:	2.538	.910	.746
MINIMUM Y	:	-.889	-.607	-.493
CENTROID X	:	-.121	-.132	.076
CENTROID Y	:	.528	.246	.133
POA TO CENTROID in.	:	.542	.280	.153
MIN RADIUS	:	.190	.141	.132
MEAN RADIUS	:	1.039	.793	.631
MAX RADIUS	:	2.540	1.901	.917
HORIZONTAL SPREAD	:	2.723	2.723	1.583
VERTICAL SPREAD	:	3.427	1.517	1.239
EXTREME SPREAD	:	3.486	2.926	1.774
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	