

C6348939

MODEL 700TM M24

Model **SMS** TM

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: RE00141237

Serial: C6348939 Model M24 SWS Center Fire
Caliber: 7.62 NATO Produced: 12/13/1989

Repairman:

Status: Closed 2/5/2008 6:28:43 AM

Verify Repair

Address Information

Customer:

☒ Received From

Return To:

☐ Received From

Name: 1 SF

1 SF

Address 1: DEPARTMENT OF THE ARMY

DEPARTMENT OF THE ARMY

Address 2: BOX 339500 MS 78

PO Box:

BOX 339500 MS 78

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

Code	Desc	Qty
A007	With Stud	3
A057	Fit and Rear Sgt Base	1

Repair Search

Refresh

Close

nagletj

2/7/2008

4:18 PM

CAPS

NUM

INS

SDRL

start

11 M

My ...

Arm...

2 A...

Gov'...

Ada...

SAP...

4:18 PM

Serial Number: C6348939

Model: M24 SWS



RE00141237

EQUIPMENT INSPECTION AND MAINTENANCE WORKSHEET

For use of this form, see DA PAM 738-750 and 738-751; the proponent agency is DCSLOG

1. ORGANIZATION

2. NOMENCLATURE AND MODEL

M-24

3. REGISTRATION/SERIAL/NSN

C 622542

4a. MILES

b. HOURS

c. ROUNDS
FIREDd. HOT
STARTS

5. DATE

6. TYPE INSPECTION

TECHNICAL INSP

7.

APPLICABLE REFERENCE

TM NUMBER

TM DATE

TM NUMBER

TM DATE

COLUMN a - Enter TM item number.

COLUMN b - Enter the applicable condition status symbol.

COLUMN c - Enter deficiencies and shortcomings.

COLUMN d - Show corrective action for deficiency or shortcoming listed in Column c.

COLUMN e - Individual ascertaining completed corrective action initial in this column.

STATUS SYMBOLS

"X" - Indicates a deficiency in the equipment that places it in an inoperable status.

CIRCLED "X" - Indicates a deficiency, however, the equipment may be operated under specific limitations as directed by higher authority or as prescribed locally, until corrective action can be accomplished.

HORIZONTAL DASH "(-)" - Indicates that a required inspection, component replacement, maintenance operation check, or test flight is due but has not been accomplished, or an overdue MWO has not been accomplished.

DIAGONAL "(/)" - Indicates a material defect other than a deficiency which must be corrected to increase efficiency or to make the item completely serviceable.

LAST NAME INITIAL IN BLACK, BLUE-BLACK INK, OR PENCIL - Indicates that a completely satisfactory condition exists.

FOR AIRCRAFT - Status symbols will be recorded in red.

ALL INSPECTIONS AND EQUIPMENT CONDITIONS RECORDED ON THIS FORM HAVE BEEN DETERMINED IN ACCORDANCE WITH DIAGNOSTIC PROCEDURES AND STANDARDS IN THE TM CITED HEREON.

8a. SIGNATURE (Person(s) performing inspection)

Aem

8b. TIME

1

9a. SIGNATURE (Maintenance Supervisor)

A. Drab

9b. TIME

10. MANHOURS
REQUIREDTM
ITEM
NO.
aSTATUS
bDEFICIENCIES AND SHORTCOMINGS
cCORRECTIVE ACTION
dINITIAL
WHEN
CORRECTED
e

Round count Loss

Return to Remington
due to "LOSS" of
Round count

A. Drab

1ST SFG (A)
DS/GS ARMS SHOP
FT. LEWIS, WA

BARBER - M24 0042091
**AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS**

2.50 LBS (plus or minus 0.50 LBS)
3.00 LBS (plus or minus 0.75 LBS)
4.00 LBS (plus or minus 1.00 LBS)

DATE 2-6-08

TESTER TRW

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.21	2.33		2.53	
PULL #2	2.47	2.26		2.32	
PULL #3	2.51	2.24		2.19	
PULL #4	2.33	2.26		2.25	
PULL #5	2.33	2.43		2.25	
TOTAL	11.85	11.52		11.54	
AVERAGE	2.37	2.30		2.30	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.12	3.22		
PULL #2	3.08	3.35		
PULL #3	3.10	3.40		
PULL #4	3.14	3.13		
PULL #5	3.10	3.22		
TOTAL	15.54	16.32		
AVERAGE	3.10	3.26		

	4.00 LBS INITIAL	4.00 LBS AFTER 20 CYCLES	MAX SETTING GREATER THAN 4 LBS	RESET TO 4 LBS FOR TARGET & ACCURACY
PULL #1	4.26	4.17		4.50
PULL #2	4.37	4.12		4.32
PULL #3	4.27	4.22		4.31
PULL #4	4.26	4.18		4.39
PULL #5	4.28	4.22		4.26
TOTAL	21.44	20.91		21.78
AVERAGE	4.28	4.18		4.35

DEPARTMENT OF THE ARMY
3RD BATTALION 1ST SPECIAL FORCES GROUP (AIRBORNE)
FORT LEWIS, WASHINGTON 98433

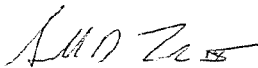
AOSO-SFI-TB

13 December 2007

MEMORANDUM FOR RECORD

SUBJECT: M-24 SWS, turn in for new barrel.

1. SFODA 1311 request M-24 SWS, serial number C6225412 be returned to Remington for new barrel due to existing barrel exceeding 10,000 rounds.


GERALD D. TUCK
CPT, SF
Detachment commander

USAPPC V1.10

DEPARTMENT OF THE ARMY
3RD BATTALION 1ST SPECIAL FORCES GROUP (AIRBORNE)
FORT LEWIS, WASHINGTON 98433

AOSO-SFI-TB

13 December 2007

MEMORANDUM FOR RECORD

SUBJECT: M-24 SWS, turn in for new barrel.

1. SFODA 1311 request M-24 SWS, serial number C6348939 be returned to Remington for new barrel due to existing barrel exceeding 10,000 rounds.



GERALD D. TUCK
CPT, SF
Detachment commander

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6348939.___0
FILE DATE AND TIME: 02/26/2008 09:20

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:	0.027
The Average Point of Impact of the Five Target Set:	0.028
The Average Mean Radius of the Five Target Set:	0.725
The Distance from POA to Centroid Target #1:	0.194
The Distance from Centroid Target #2 to Centroid Target #1:	0.230
The Distance from Centroid Target #3 to Centroid Target #1:	0.302
The Distance from Centroid Target #4 to Centroid Target #1:	0.357
The Distance from Centroid Target #5 to Centroid Target #1:	0.202

BARBER - M24 0042096

SERIAL NUMBER: C6348939. __0

TARGET NUMBER: 1

FILE DATE: 02/26/2008

FILE TIME: 09:20

POINT#	X	Y
1:	-1.376	1.013
2:	-0.392	-0.646
3:	-0.621	-0.535
4:	-0.760	-0.380
5:	-0.404	-0.066
6:	0.313	-0.180
7:	0.701	0.153
8:	0.410	0.744
9:	0.278	0.560
10:	0.221	0.380

X CENTROID: -0.163

Y CENTROID: 0.104

POA TO CENTROID: 0.194

HORZ SPREAD: 2.077

VERT SPREAD: 1.659

GROUP SPREAD: 2.248

MIN RADIUS: 0.295

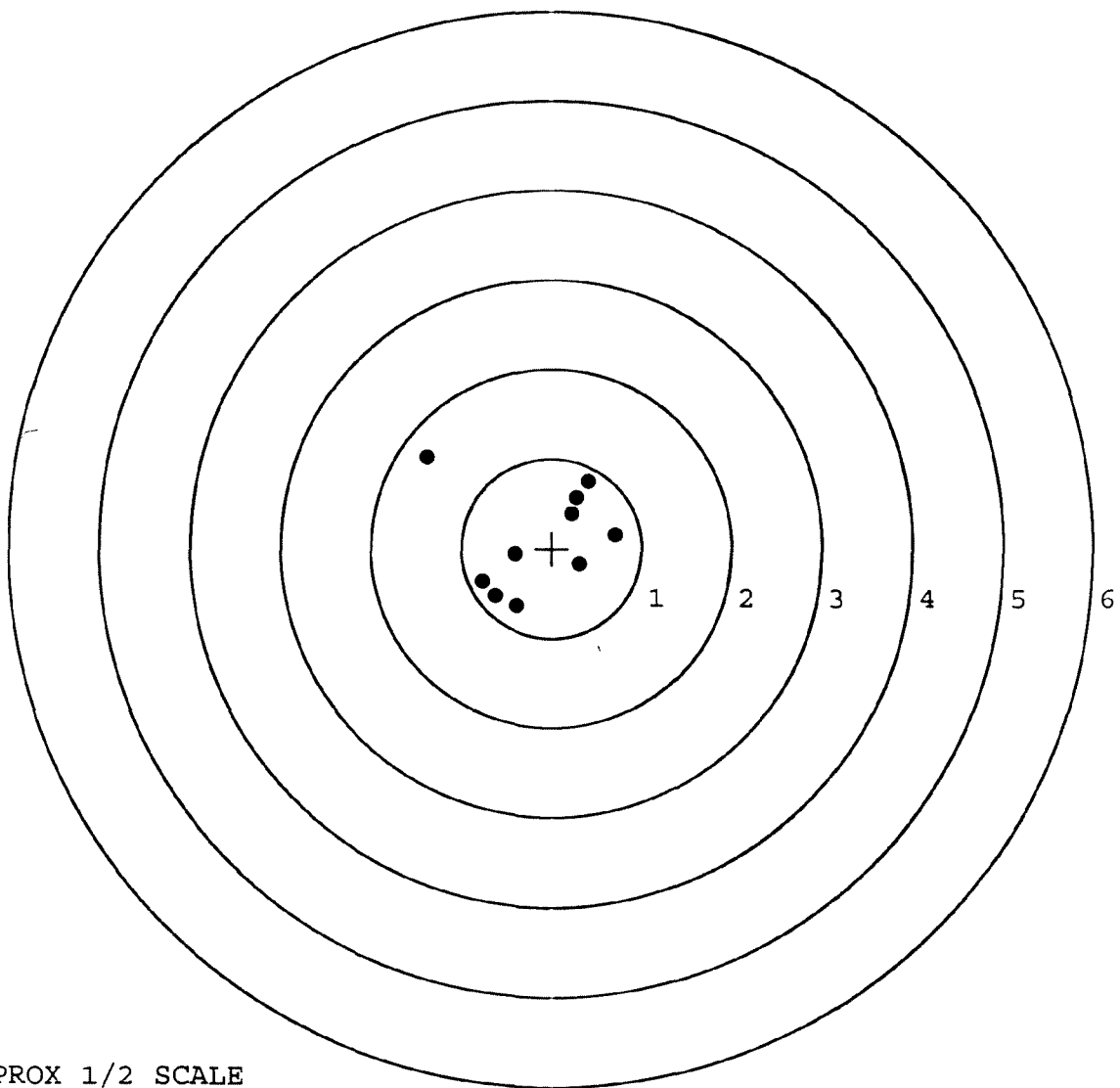
MAX RADIUS: 1.516

MEAN RADIUS: 0.754

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

BARBER - M24 0042097

SERIAL NUMBER: C6348939. __0

TARGET NUMBER: 2

FILE DATE: 02/26/2008

FILE TIME: 09:20

POINT#	X	Y
--------	---	---

1:	-0.636	-0.062
----	--------	--------

2:	-0.436	-0.473
----	--------	--------

3:	0.477	-0.606
----	-------	--------

4:	0.151	-0.364
----	-------	--------

5:	0.199	-0.108
----	-------	--------

6:	0.139	0.277
----	-------	-------

7:	-0.255	0.696
----	--------	-------

8:	0.198	1.593
----	-------	-------

9:	1.352	-1.244
----	-------	--------

10:	-0.696	2.227
-----	--------	-------

X CENTROID: 0.049

Y CENTROID: 0.194

POA TO CENTROID: 0.200

HORZ SPREAD: 2.048

VERT SPREAD: 3.471

GROUP SPREAD: 4.030

MIN RADIUS: 0.122

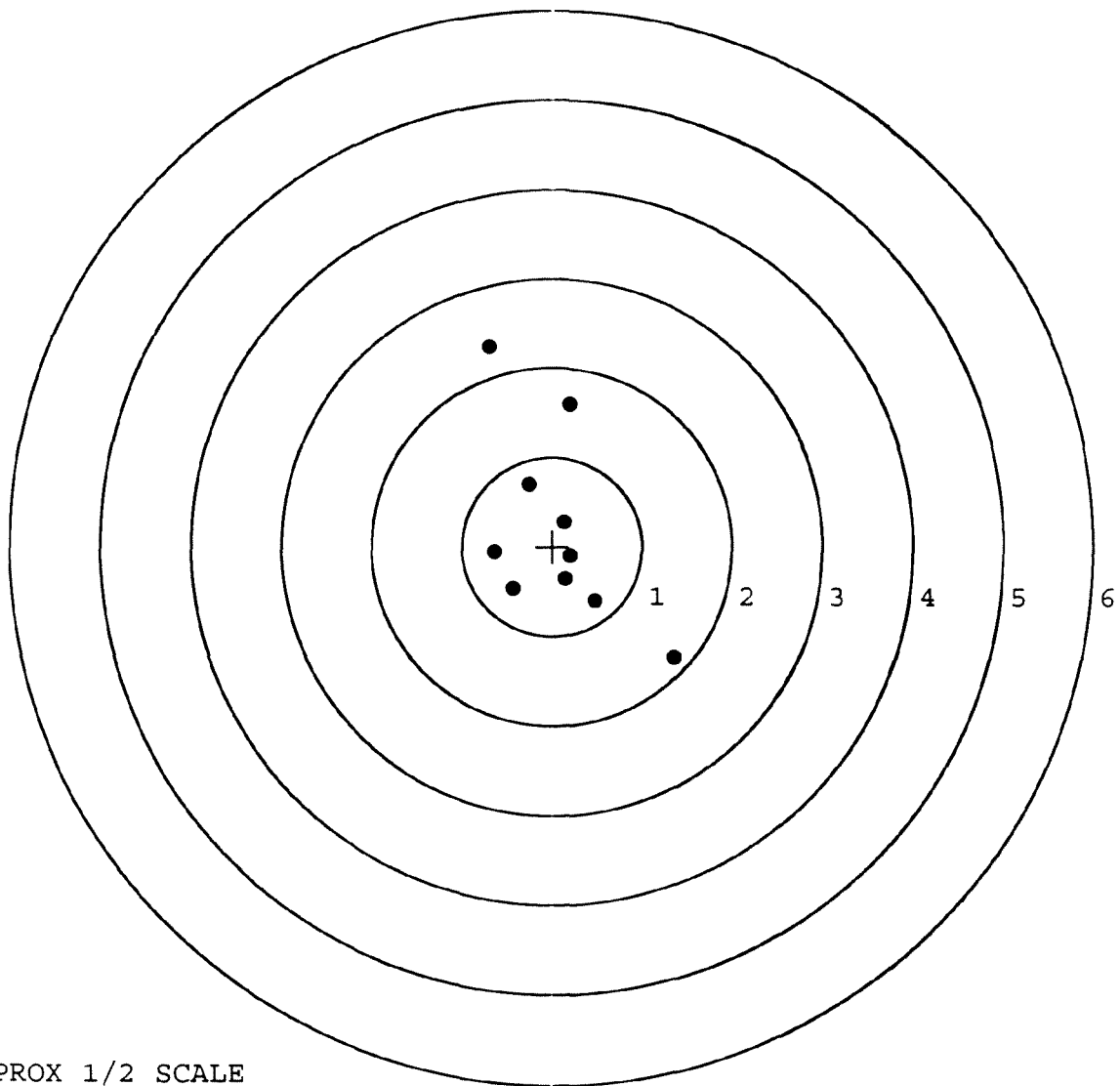
MAX RADIUS: 2.166

MEAN RADIUS: 0.959

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 8



TARGET APPROX 1/2 SCALE

BARBER - M24 0042098

SERIAL NUMBER: C6348939. __0

TARGET NUMBER: 3

FILE DATE: 02/26/2008

FILE TIME: 09:20

POINT#	X	Y
1:	-1.612	-0.262
2:	-0.919	-0.771
3:	1.310	-0.617
4:	1.105	0.001
5:	0.258	-0.681
6:	0.153	-0.326
7:	-0.059	0.028
8:	0.226	0.388
9:	-0.485	0.359
10:	-0.205	0.247

X CENTROID: -0.023

Y CENTROID: -0.163

POA TO CENTROID: 0.165

HORZ SPREAD: 2.922

VERT SPREAD: 1.159

GROUP SPREAD: 2.943

MIN RADIUS: 0.195

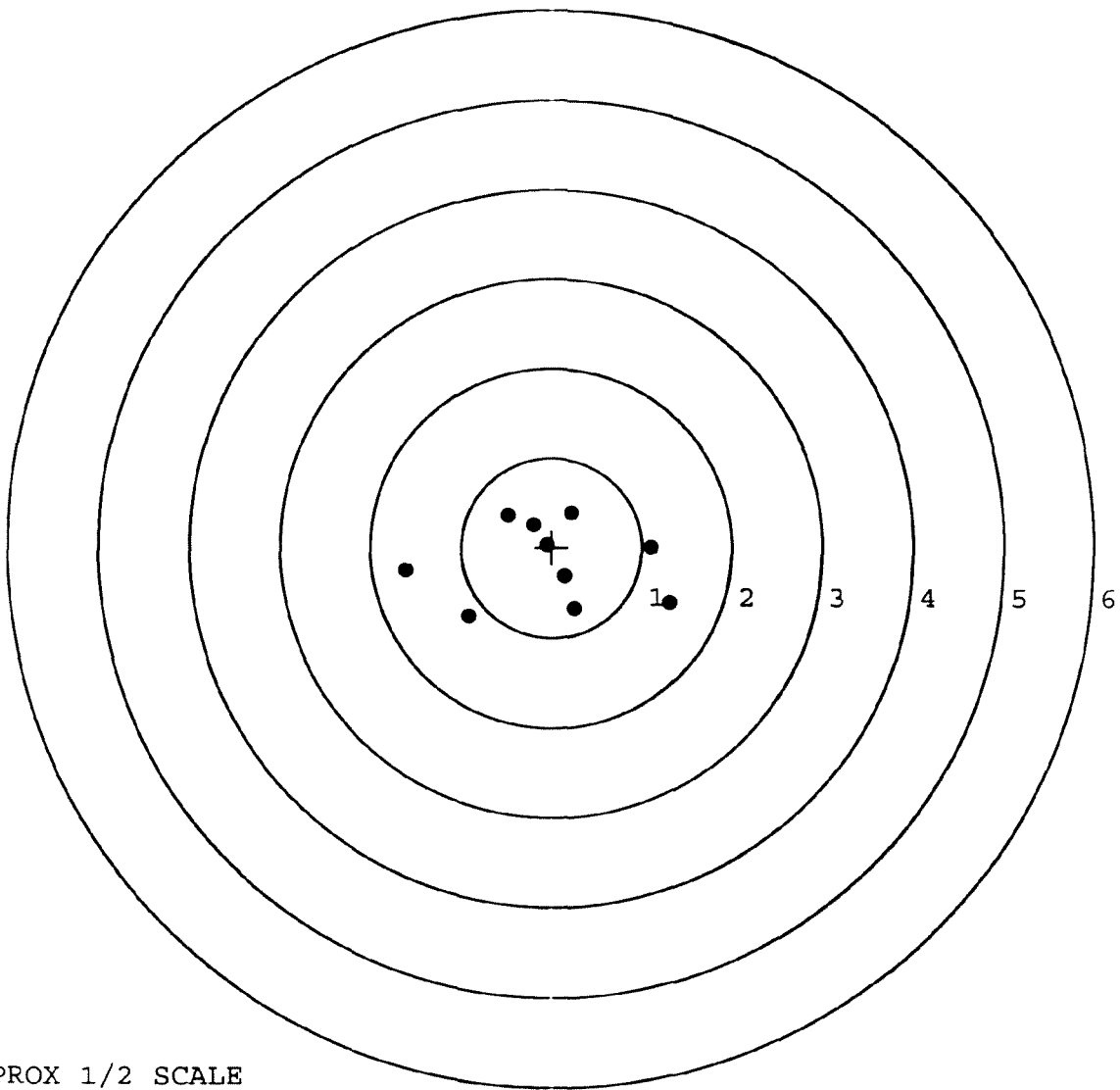
MAX RADIUS: 1.592

MEAN RADIUS: 0.800

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

BARBER - M24 0042099

SERIAL NUMBER: C6348939. __0

TARGET NUMBER: 4

FILE DATE: 02/26/2008

FILE TIME: 09:20

POINT#	X	Y
1:	1.389	-0.250
2:	0.480	0.748
3:	0.438	0.348
4:	0.115	0.268
5:	0.156	0.078
6:	-0.425	0.061
7:	-0.465	-0.220
8:	-0.141	-0.290
9:	-0.212	-0.665
10:	-0.032	-1.073

X CENTROID: 0.130

Y CENTROID: -0.100

POA TO CENTROID: 0.164

HORZ SPREAD: 1.854

VERT SPREAD: 1.821

GROUP SPREAD: 1.854

MIN RADIUS: 0.179

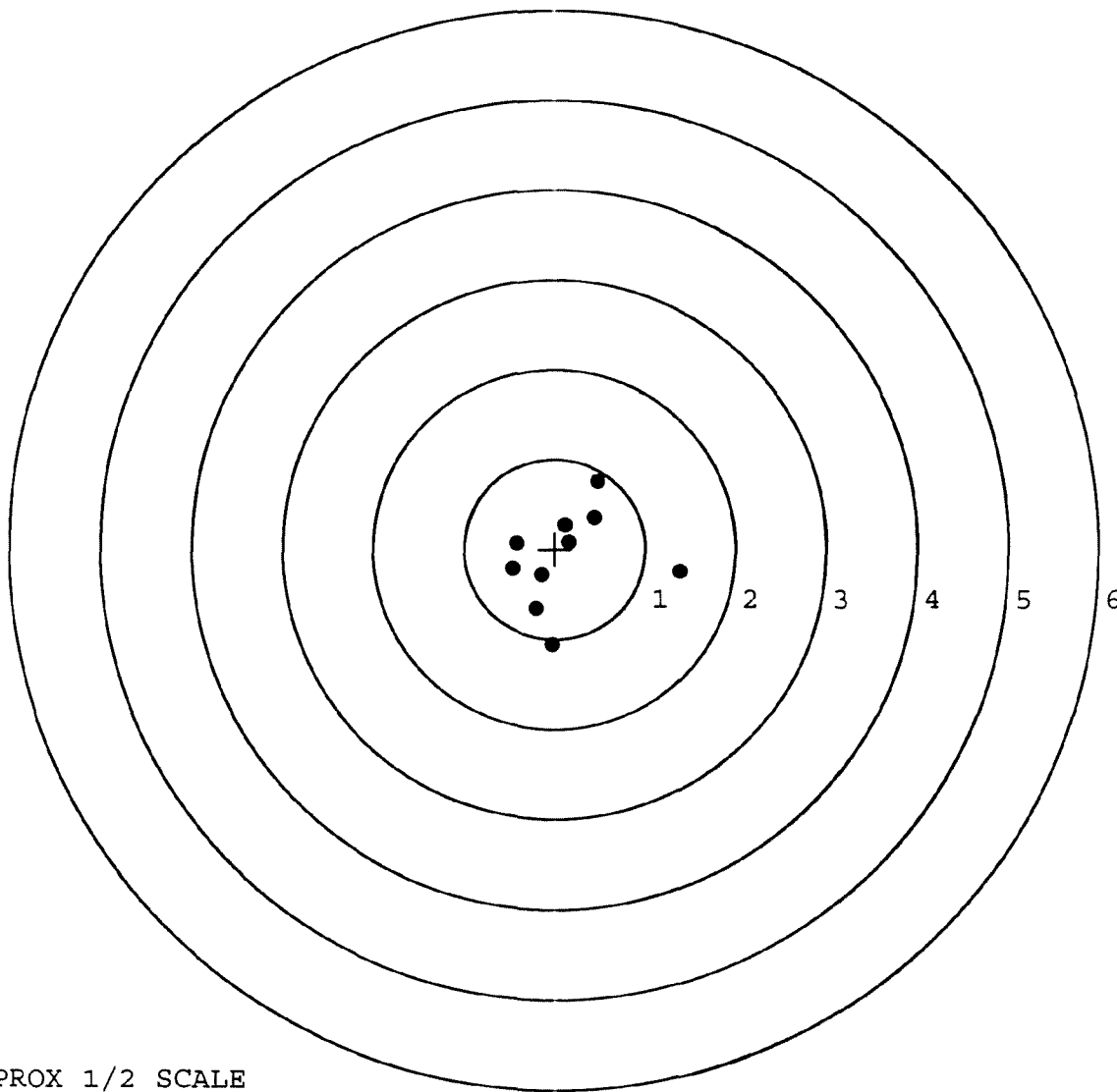
MAX RADIUS: 1.268

MEAN RADIUS: 0.644

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

BARBER - M24 0042100

SERIAL NUMBER: C6348939. __0

TARGET NUMBER: 5

FILE DATE: 02/26/2008

FILE TIME: 09:20

POINT#	X	Y
1:	-0.477	0.780
2:	0.087	0.700
3:	0.386	0.490
4:	0.205	0.264
5:	0.430	-0.613
6:	-0.278	0.064
7:	0.096	0.147
8:	-0.267	-0.329
9:	0.163	-0.347
10:	0.044	-0.156

X CENTROID: 0.039

Y CENTROID: 0.100

POA TO CENTROID: 0.107

HORZ SPREAD: 0.907

VERT SPREAD: 1.393

GROUP SPREAD: 1.662

MIN RADIUS: 0.074

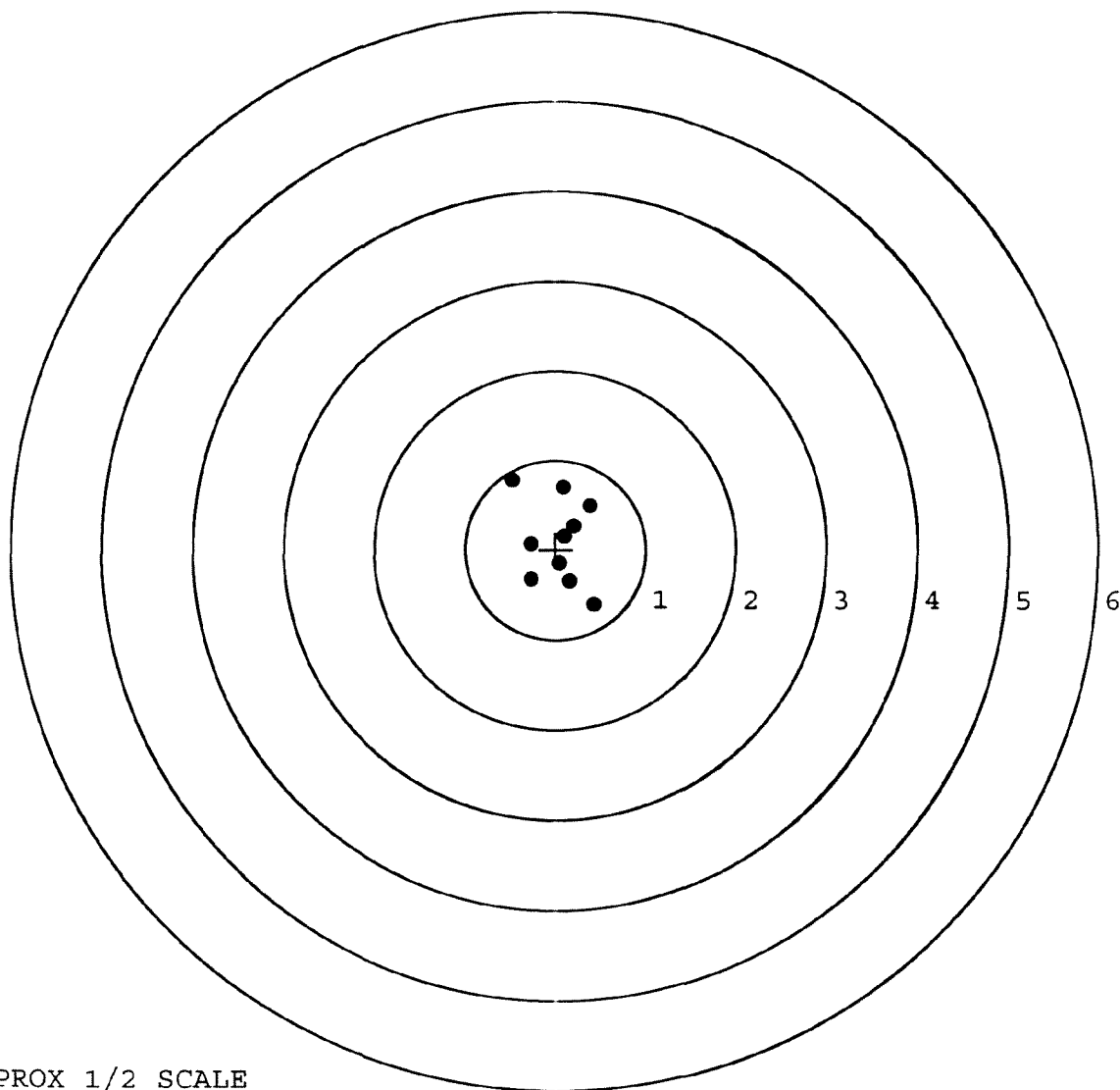
MAX RADIUS: 0.854

MEAN RADIUS: 0.466

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

BARBER - M24 0042101 M-24 INSPECTION CHECKLIST
CONTRACT #: DAAE-2002-C-0149

R & E NUMBER 141237
SERIAL NUMBER C6348939
LOG-IN DATE 2-5-08

OPERATION #	OPERATION NAME	DATE	INITIAL
500	DIS-ASSEMBLE GUN	2-11-08	RTZ
505	RE-BARREL	2-11-08	J.P.D.
560	ASSEMBLE	2-12-08	J.P.D.
600	PROOF	2-12-08	TRW
605	CHECK HEADSPACE	2-12-08	TRW
610	DIS-ASSEMBLE GUN	2-12-08	J.P.D.
612	MAGNAFLUX	2/13/08	mmu
510	DRILL AND TAP	2-12-08	TRW
615	ROLLMARK CALIBER	2-12-08	CW
618	ROTO-BLAST	2-14-08	DG
620	APPLY COATINGS	2-19-08	CR
625	FINAL ASSEMBLY	2-20-08	J.P.D.
640	FUNCTION TEST AND	2-21-08	TRW
650	TARGET	2-21-08	TRW
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
670	FINAL INSPECTION	2-21-08	RP
	A) HEADSPACE	2-25-08	DA
	B) TRIGGER PULL	2.41 2.28 2.25 2.20 2.26 2.25 08	DA
680	F) SAFETY ON FORCE	5.2 5.2 5.5 2-25-08	DA
	G) SAFETY OFF FORCE	4.5 5.2 4.5 2-25-08	DA
	I) FIRING PIN INDENT	.021 .023 .023 2-25-08	DA
690	PACK	2-29-08	DA

The screenshot displays the "Arms Services Repair & Estimate System" window. The title bar includes standard Windows icons and the application name. The menu bar contains: File, Add Repair, Estimate Repair, Expedite Repair, Inquiry, Repair Tools, CSR Tools, Reports, Table Maintenance, System Maintenance, Help.

The main window is titled "Repair Inquiry". It features several input fields and sections:

- Repair Number:** RE00052614
- Serial:** D6349939 Model 700 Center Fire Caliber: 7.62 NATO M-24 [SWS]
- Repairman:** [Empty field]
- Status:** Closed 9/19/02 2:48:10 PM
- Verify Repair:** [Button]

Address Information:

- Customer:** Received From (Selected) Return To: Received From
- Name:** A CO
- Address 1:** 3/1 SFG (A)
- Address 2:** PD Box: [Empty field]
- City:** FORT BRAGG
- State:** NC **Zip Code:** 28310 **Country:** US

FFL: [Five empty checkboxes]

Tabs: Contact / Condition, Problems, Estimate, History / Status, Shipping / Billing

Contact Information:

- Phone:** [Empty field]
- Fax:** [Empty field]
- Email:** [Empty field]
- Comments:** [Empty text area]

Received Condition:

- Poor:** [Empty field]
- Condition Notes:** [Empty text area]
- CSR Notes:** [Empty text area]

Accessories Received:

Code	Desc	Qty
A007	With Stud	1
X	FRT & REAR SGT BA	1

[Empty rows follow in the table]

Buttons: Repair Search, Refresh, Close

Taskbar: naglel | 9/19/02 | 3:24 PM | C4P5 | NUM | INS | SERL | Start | [Icons] | 3:24 PM

Serial Number: C6348939

Model: 700



RE00052614

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6348939.___0

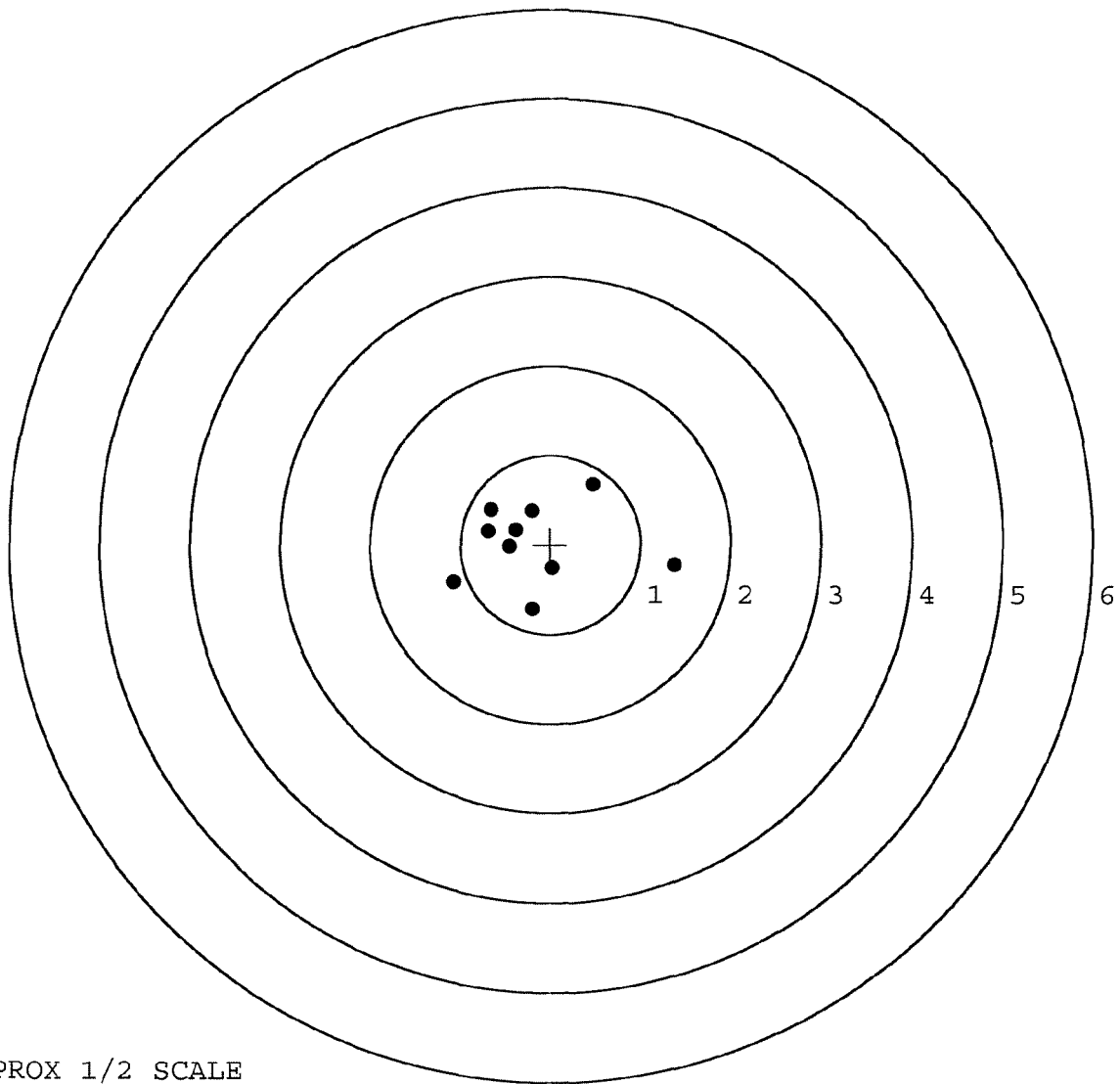
FILE DATE AND TIME: 10/11/2002 13:57

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.128
The Average Y Centroid of the Five Target Set:	-0.099
The Average Point of Impact of the Five Target Set:	0.162
The Average Mean Radius of the Five Target Set:	0.610
The Distance from POA to Centroid Target #1:	0.183
The Distance from Centroid Target #2 to Centroid Target #1:	0.101
The Distance from Centroid Target #3 to Centroid Target #1:	0.161
The Distance from Centroid Target #4 to Centroid Target #1:	0.198
The Distance from Centroid Target #5 to Centroid Target #1:	0.163

BARBER - M24 0042104

SERIAL NUMBER: C6348939. __0	POINT#	X	Y
TARGET NUMBER: 1	1:	1.378	-0.220
FILE DATE: 10/11/2002	2:	0.468	0.677
FILE TIME: 13:57	3:	-0.204	-0.720
	4:	0.022	-0.262
X CENTROID: -0.183	5:	-1.079	-0.421
Y CENTROID: 0.011	6:	-0.663	0.392
POA TO CENTROID: 0.183	7:	-0.699	0.148
HORZ SPREAD: 2.457	8:	-0.207	0.376
VERT SPREAD: 1.397	9:	-0.387	0.164
GROUP SPREAD: 2.465	10:	-0.456	-0.020
MIN RADIUS: 0.255			
MAX RADIUS: 1.578			
MEAN RADIUS: 0.662			
# IN 1 IN DIAMETER: 4			
# IN 2 IN DIAMETER: 9			
# in 3 IN DIAMETER: 9			



TARGET APPROX 1/2 SCALE

BARBER - M24 0042105

SERIAL NUMBER: C6348939. __0

TARGET NUMBER: 2

FILE DATE: 10/11/2002

FILE TIME: 13:57

POINT#	X	Y
--------	---	---

1:	-0.182	-0.879
----	--------	--------

2:	-0.371	-0.803
----	--------	--------

3:	-0.665	-0.037
----	--------	--------

4:	-0.590	0.546
----	--------	-------

5:	-0.312	-0.115
----	--------	--------

6:	-0.139	-0.315
----	--------	--------

7:	-0.141	0.564
----	--------	-------

8:	0.170	0.334
----	-------	-------

9:	0.567	0.271
----	-------	-------

10:	0.455	-0.252
-----	-------	--------

X CENTROID: -0.121

Y CENTROID: -0.069

POA TO CENTROID: 0.139

HORZ SPREAD: 1.232

VERT SPREAD: 1.443

GROUP SPREAD: 1.482

MIN RADIUS: 0.197

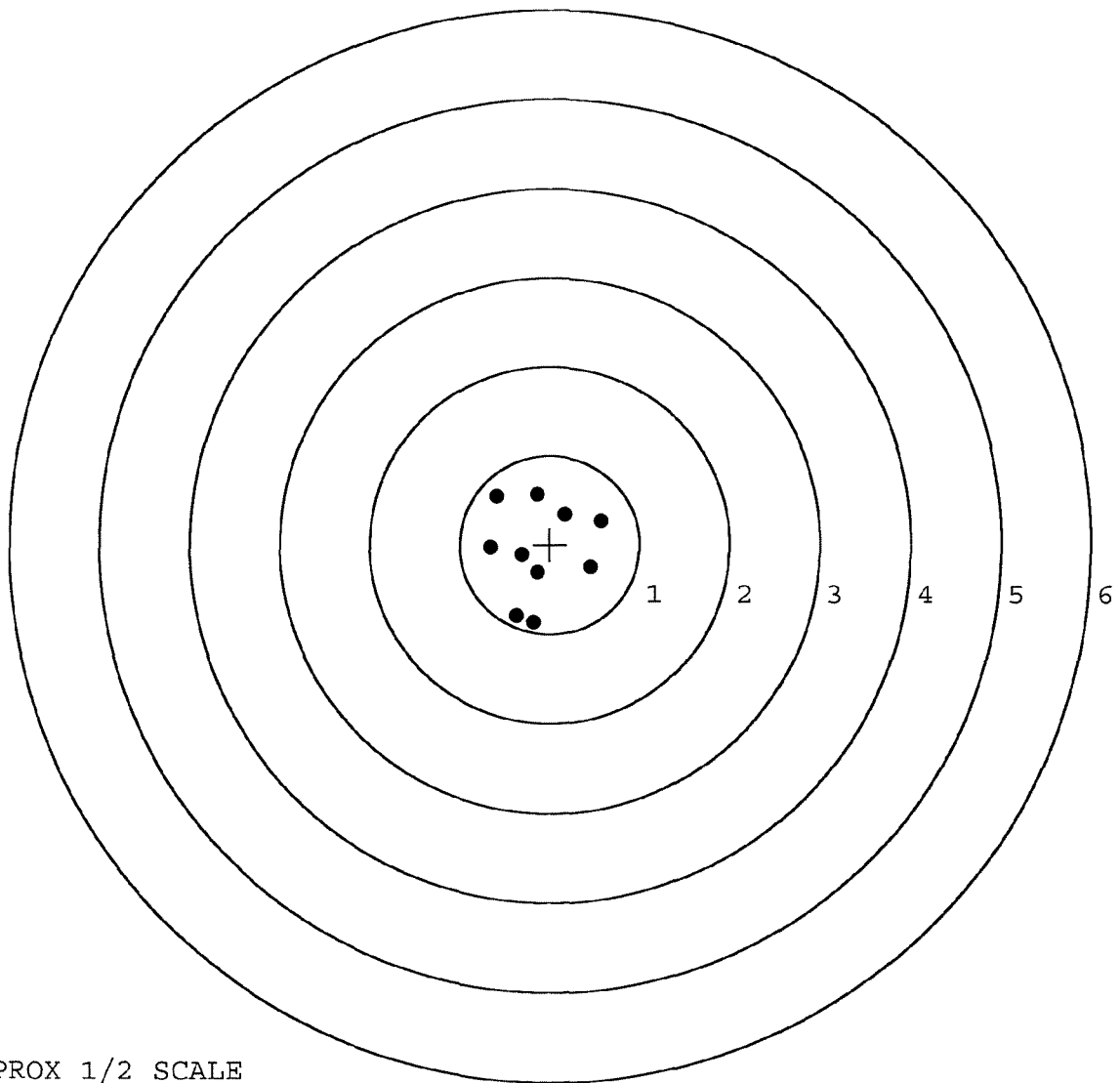
MAX RADIUS: 0.813

MEAN RADIUS: 0.585

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

BARBER - M24 0042106

SERIAL NUMBER: C6348939. __0

TARGET NUMBER: 3

FILE DATE: 10/11/2002

FILE TIME: 13:57

POINT#	X	Y
1:	0.607	-0.682
2:	0.362	-0.073
3:	0.162	-0.564
4:	-0.605	-0.817
5:	-1.127	-0.520
6:	-0.495	-0.209
7:	0.159	0.685
8:	-0.116	0.811
9:	-0.099	0.078
10:	-0.137	-0.116

X CENTROID: -0.129

Y CENTROID: -0.141

POA TO CENTROID: 0.191

HORZ SPREAD: 1.734

VERT SPREAD: 1.628

GROUP SPREAD: 1.762

MIN RADIUS: 0.026

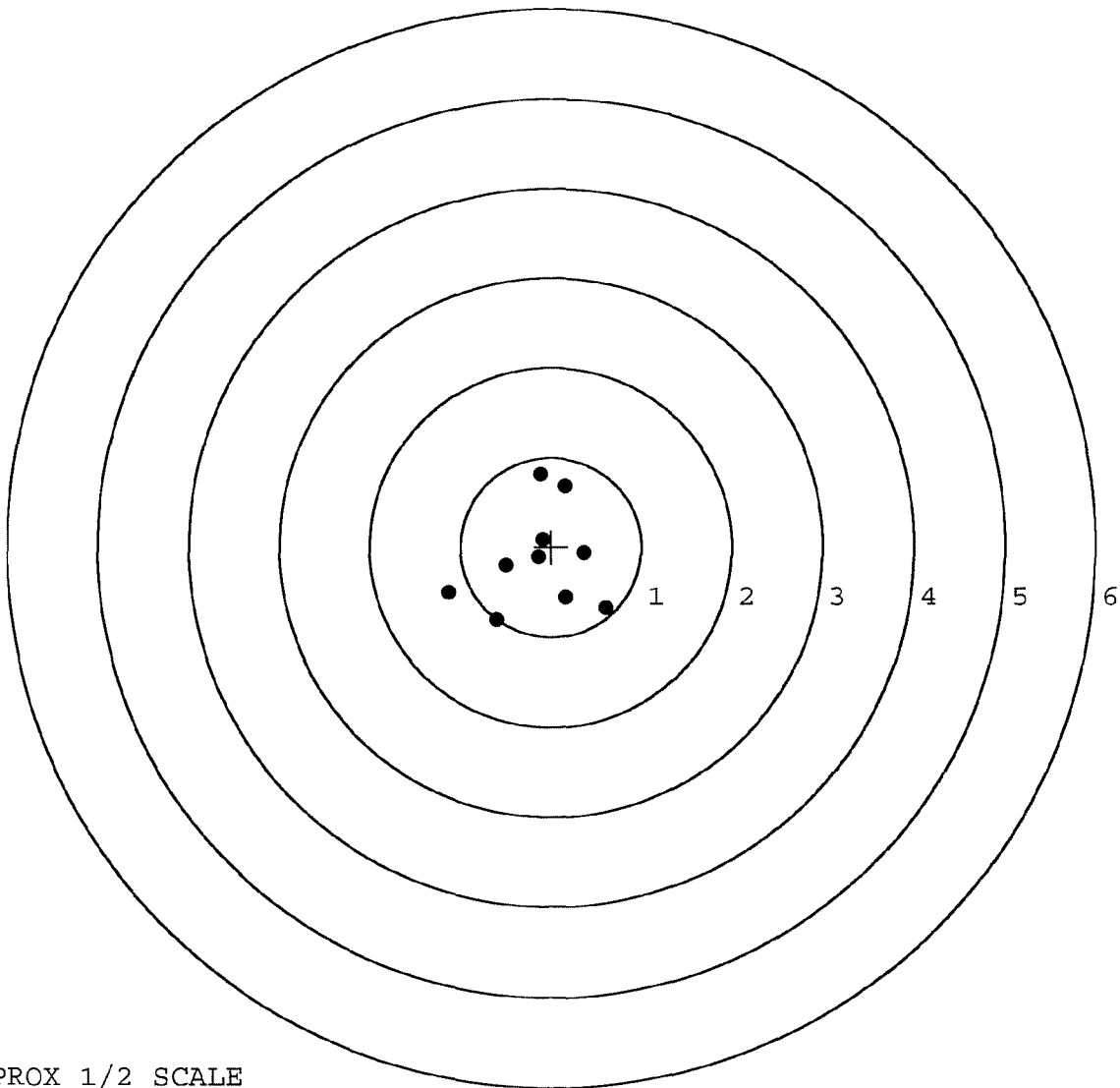
MAX RADIUS: 1.068

MEAN RADIUS: 0.626

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10



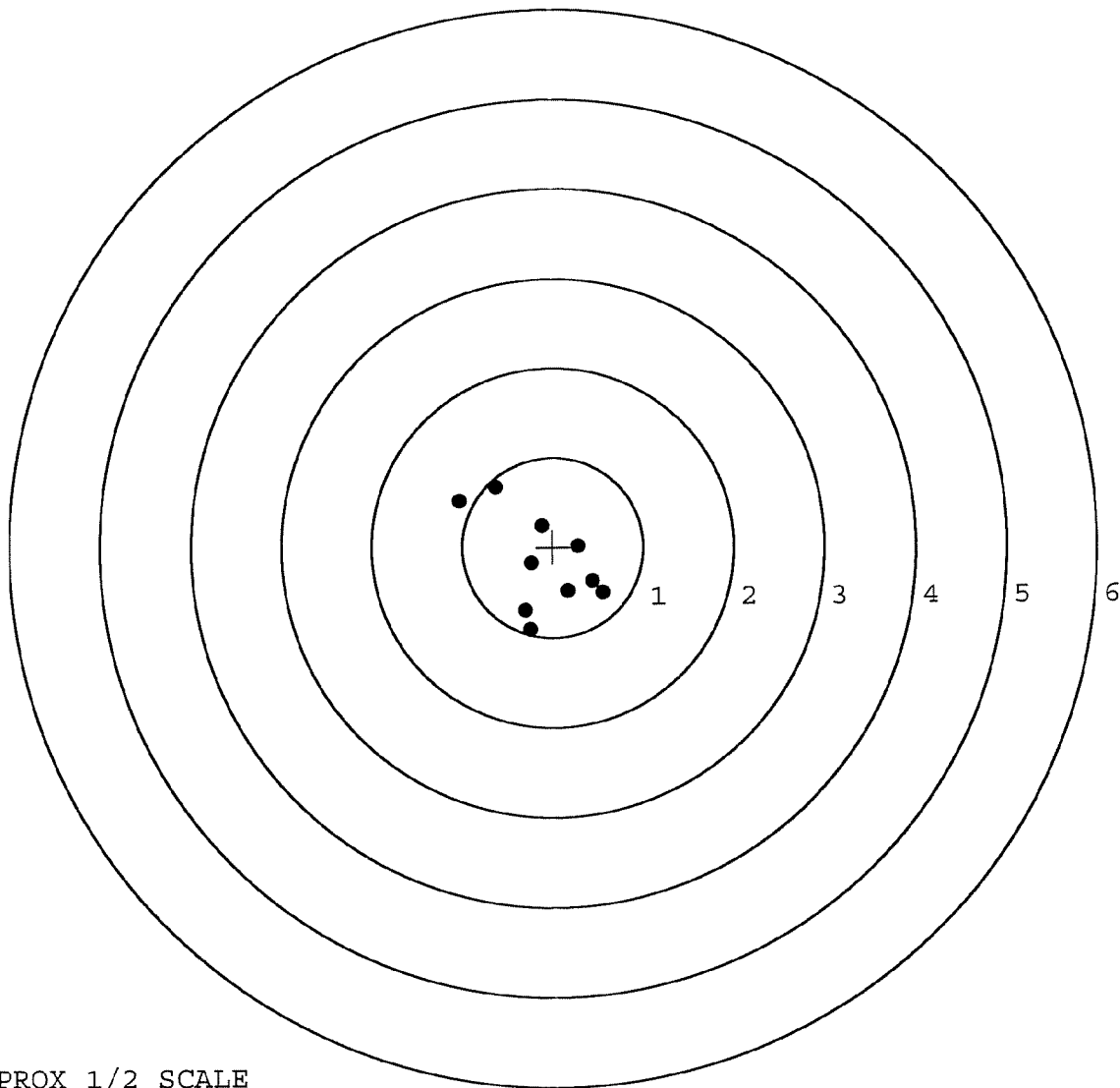
TARGET APPROX 1/2 SCALE

BARBER - M24 0042107

SERIAL NUMBER: C6348939. __ 0
 TARGET NUMBER: 4
 FILE DATE: 10/11/2002
 FILE TIME: 13:57

POINT#	X	Y
1:	0.550	-0.511
2:	0.436	-0.381
3:	0.164	-0.487
4:	-0.257	-0.919
5:	-0.313	-0.700
6:	-0.243	-0.182
7:	-0.122	0.234
8:	0.277	0.009
9:	-0.631	0.667
10:	-1.027	0.518

X CENTROID: -0.117
 Y CENTROID: -0.175
 POA TO CENTROID: 0.210
 HORZ SPREAD: 1.577
 VERT SPREAD: 1.586
 GROUP SPREAD: 1.883
 MIN RADIUS: 0.127
 MAX RADIUS: 1.144
 MEAN RADIUS: 0.617
 # IN 1 IN DIAMETER: 4
 # IN 2 IN DIAMETER: 9
 # in 3 IN DIAMETER: 10



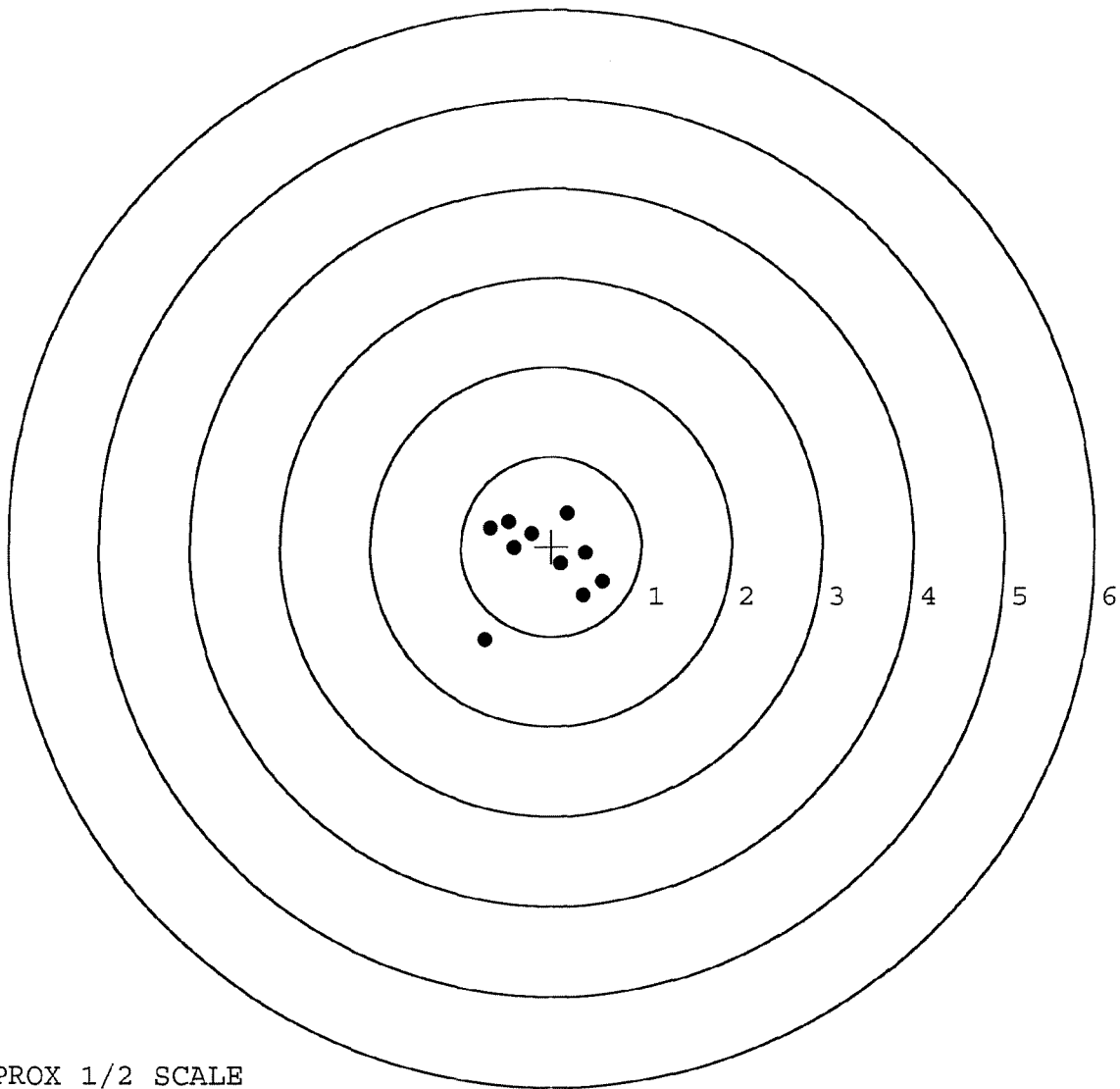
TARGET APPROX 1/2 SCALE

BARBER - M24 0042108

SERIAL NUMBER: C6348939. __0
 TARGET NUMBER: 5
 FILE DATE: 10/11/2002
 FILE TIME: 13:57

POINT#	X	Y
1:	-0.738	-1.041
2:	0.570	-0.390
3:	0.354	-0.544
4:	0.108	-0.187
5:	0.383	-0.073
6:	0.180	0.378
7:	-0.222	0.145
8:	-0.411	-0.017
9:	-0.679	0.210
10:	-0.476	0.277

X CENTROID: -0.093
 Y CENTROID: -0.124
 POA TO CENTROID: 0.155
 HORZ SPREAD: 1.308
 VERT SPREAD: 1.419
 GROUP SPREAD: 1.690
 MIN RADIUS: 0.211
 MAX RADIUS: 1.121
 MEAN RADIUS: 0.557
 # IN 1 IN DIAMETER: 4
 # IN 2 IN DIAMETER: 9
 # in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

Final Inspection

IN: CW48939

DATE REC'D: 9/19/02

DATE RET'D: 10/14/02

EDITOR

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:

R & E NUMBER	52614		
SERIAL NUMBER	C6348939		
LOG-IN DATE	9/19/02		
INSPECT AND VERIFY:			
OPERATION #	OPERATION NAME	DATE	INITIAL
550	DIS-ASSEMBLE GUN	9/23/02	RL
560 A	RE-BARREL	9/23/02	RL
B	DRILL AND TAP	9-23-02	AC
575	ASSEMBLE	9/24/02	RL
600	PROOF	9-25-02	AC
605	CHECK HEADSPACE	9-25-02	AC
610	DIS-ASSEMBLE GUN	SEP 27 2002 9/24/02	RL
612	MAGNAFLUX	9/27/02	RL
615	ROLLMARK CALIBER	9/27/02	TRW
618	ROTO-BLAST	9/30/02	KO
620	APPLY COATINGS	10-5	TRW
625 A	FINAL ASSEMBLY	10/8/02	RL
B	TRIGGER PULL TEST		
C	SAFETY "ON" FORCE		
D	SAFETY "OFF" FORCE		
E	FIRING PIN INDENT		
640	TARGET	10-10-02	TRW
655	FINAL INSPECT	10-14-02	RL
660	PACK	10-15-02	TRW
		SHIP DATE	
		QAR INSPECTION DATE	

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

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

MODEL 700TM M24

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

SERIAL NO.
C6348939

ORDER NO.
5716

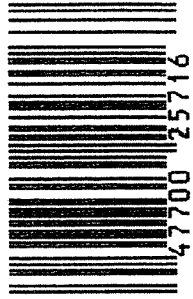
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MADE IN ILLION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.



5716 C6348939

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6348939

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	QUALITY ASSURANCE	10-9 89	RW
600	Proof		10-9 89	AC
607	Check Headspace		10-9 89	RW
610	Dis-assemble Gun		10-9 89	RW
612	Magnaflux Barrel Action	REJECT	11/2/89	WCR
	Magnaflux Bolt		11/2/89	WCR
615	Rollmark Caliber			
7	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 0042113						
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					
	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					
	C) Function					
660	Pack					

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6348939

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	11-8	89	RW
600	Proof	11-8	89	RW
607	Check Headspace	11-8	89	RW
610	Dis-assemble Gun	11-8	89	RW
612	Magnaflux Barrel Action	11-9-89		KCR
	Magnaflux Bolt	11-9-89		KCR
615	Rollmark Caliber		11/9/89	GS
617	Drill and Tap Sight Holes	11 9	89	FB
618	Polish Barrel RB	11 9	89	BT
620	Apply Coatings (Barrel Action)		11-17-89	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		11/27/89	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		11/27/89	RW
	C) Inspect Ejector Hole for Chamfer		11/27/89	RW
	D) Oil Firing Pin Ass'y		11/27/89	RW
	E) Adjust Trigger Pull to Min Setting and Stake		4 Dec 89	JS

BARBER - M24 0042115

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	7	5	5			4 Dec 89	JLH
	G) Safety Off Force	4	4	4			4 Dec 89	JLH
	H) Trigger Pull Test & Retainability						4 Dec 89	JLH
	I) Firing Pin Indent	.021	.021	.021			4 Dec 89	JLH
	J) Assemble Stock						12/4/89	RW
	K) Assemble Swivel Studs						6 Dec 89	JLH
	L) Attach Front and Rear Sight Assemblies						12/4/89	RW
	M) Iron Sight Alignment						12/4/89	RW
	N) Detach Front & Rear Sights & place in numbered container						12/4/89	RW
	O) Attach Scope to Rifle						5 Dec 89	JLH
	P) Detach & Attach Scope 20 Times						5 Dec 89	JLH
640	Gallery Target & Test						12-5-89	DH
	A) Time						12-5-89	DH
	B) Malfunctions						12-5-89	DH
	C) Pierced Primers						12-5-89	DH
	D) Optical Clarity of Scope						12-5-89	DH
645	Inspect for Live Ammo						12-5-89	DH
655	Final Inspection							
	A) Headspace						6 Dec 89	JLH
	B) Trigger Pull	2.53	2.38	2.34	2.39	2.31	6 Dec 89	JLH
	C) Function						6 Dec 89	JLH
660	Pack						18 Dec 89	JLH

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6348939

DATE 3/30/90

TESTER DH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#	COMMENTS
PULL #1	2.39	2.14	2.33	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.33	2.34	2.24	
PULL #3	2.38	2.44	2.19	
PULL #4	2.37	2.36	2.20	
PULL #5	2.35	2.38	2.19	
TOTAL	11.82	11.66	11.15	
AVG.	2.36	2.33	2.23	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.21	3.32		
PULL #2	3.27	3.27		
PULL #3	3.22	3.26		
PULL #4	3.12	3.32		
PULL #5	3.02	3.23		
TOTAL	15.84	16.40		
AVG.	3.16	3.28		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.28	4.78		
PULL #2	4.23	4.10		
PULL #3	4.19	4.04		
PULL #4	4.15	4.22		
PULL #5	4.20	4.19		
TOTAL	21.05	20.73		
AVG.	4.21	4.14		

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6348939
5 Dec 1989

CENTROIDAL DISTANCES

Ø TO	1	.660661
1 TO	2	.317984
1 TO	3	.419068
1 TO	4	.539796
1 TO	5	.504049

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THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .4852
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.08
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .491751
THE AMR FOR THIS RIFLE IS: .824

5 Dec 1989

FILE:/PATTERNING/CENTERFIRE_PATT/06348939

CENTERFIRE PATTERNS # 1

POA

1in circle

2in circle

3in circle

CENTROID #

OF SHOTS = 10

IN CIR

1in = 3

2in = 7

3in = 9

HE = 0.137

VS = 0.051

CS = 0.738

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.007	.881	.731
MINIMUM X	-1.130	-1.205	-.765
MAXIMUM Y	1.191	.981	.520
MINIMUM Y	-.860	-.727	-.605
CENTROID X	.552	.678	.828
CENTROID Y	-.363	-.496	-.618
POA TO CENTROID in.	.661	.840	1.034
MIN RADIUS	.173	.230	.398
MEAN RADIUS	.840	.730	.606
MAX RADIUS	1.642	1.553	.808
HORIZONTAL SPREAD	2.137	2.086	1.496
VERTICAL SPREAD	2.051	1.708	1.125
EXTREME SPREAD	2.738	2.495	1.561
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	9		

5 Dec 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C8348939

CENTERFIRE PATTERNS # 2

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS - 10

IN CIR

1in = 2

2in = 7

3in = 9

HS = 2.812

VS = 2.346

GS = 2.917

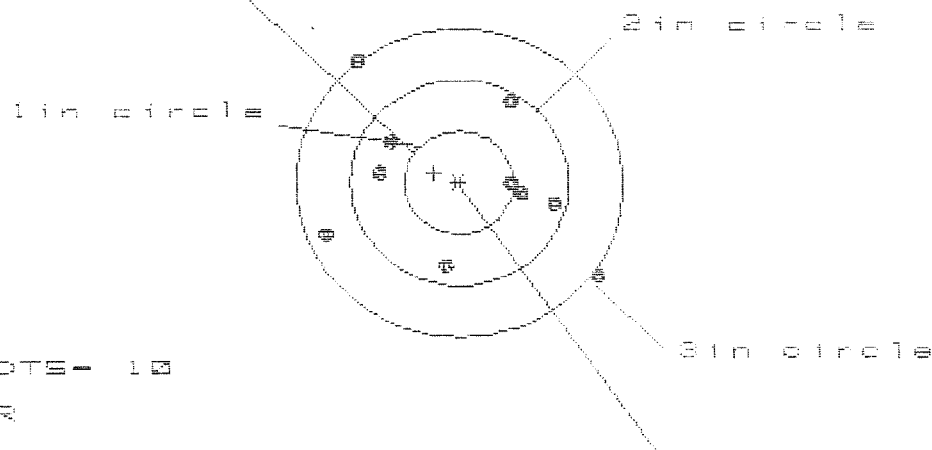
PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.989	.853	.928
MINIMUM X	-1.223	-.769	-.694
MAXIMUM Y	1.290	1.173	1.296
MINIMUM Y	-1.056	-.824	-.701
CENTROID X	.269	.405	.330
CENTROID Y	-.218	-.101	-.224
POA TO CENTROID in.	.346	.417	.399
MIN RADIUS	.322	.202	.262
MEAN RADIUS	.914	.812	.767
MAX RADIUS	1.616	1.175	1.296
HORIZONTAL SPREAD	2.212	1.622	1.622
VERTICAL SPREAD	2.346	1.997	1.997
EXTREME SPREAD	2.917	2.271	2.113
NUMBER IN ONE INCH CIRCLE	=	2	
NUMBER IN TWO INCH CIRCLE	=	7	
NUMBER IN THREE INCH CIRCLE	=	9	

5 Dec 1989

FILE:/PATTERNING/CENTERFIRE_PATT/06348933

CENTERFIRE PATTERNS # 3

POA



OF SHOTS - 10

IN CIR

1 in = 1

2 in = 7

3 in = 8

HS = 2.473

VS = 2.092

GS = 3.009

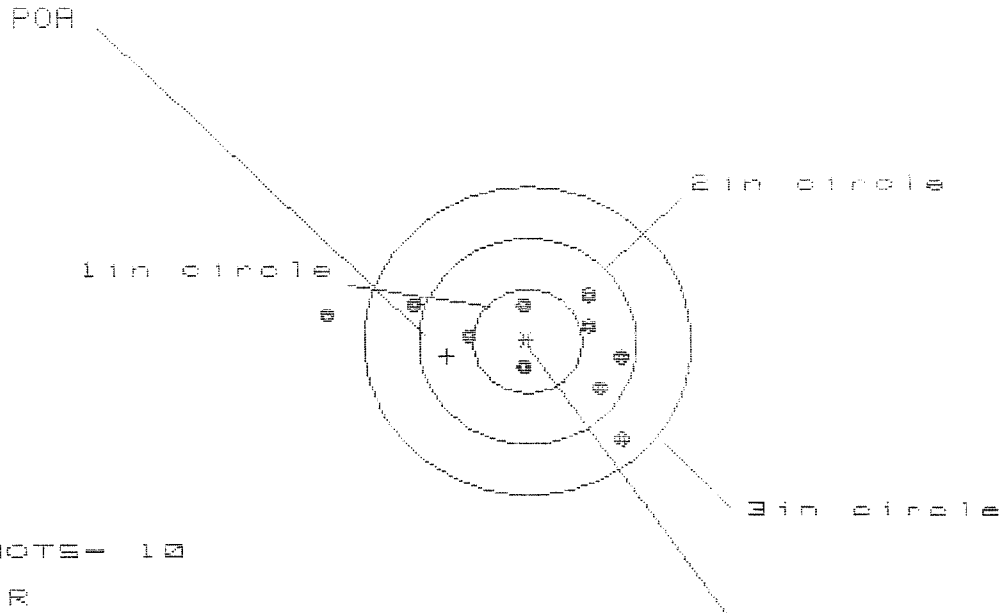
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.272	1.004	.911
MINIMUM X	-1.201	-1.060	-1.153
MAXIMUM Y	1.203	1.104	.855
MINIMUM Y	-.889	-.919	-.781
CENTROID X	.229	.088	.181
CENTROID Y	-.096	.003	-.135
POA TO CENTROID in.	.248	.088	.236
MIN RADIUS	.426	.553	.479
MEAN RADIUS	.957	.889	.818
MAX RADIUS	1.552	1.335	1.246
HORIZONTAL SPREAD	2.473	2.064	2.064
VERTICAL SPREAD	2.092	2.023	1.636
EXTREME SPREAD	3.009	2.267	2.151
NUMBER IN ONE INCH CIRCLE	=	1	
NUMBER IN TWO INCH CIRCLE	=	7	
NUMBER IN THREE INCH CIRCLE	=	9	

3 Dec 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C834B933

CENTERFIRE PATTERNS # 4



OF SHOTS - 10

IN CIR

1 in = 2

2 in = 7

3 in = 9

HSE = 2.659

VSE = 1.408

GSE = 2.917

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.848	.647	.728
MINIMUM X	:	-1.811	-1.202	-1.121
MAXIMUM Y	:	.479	.510	.398
MINIMUM Y	:	-.929	-.898	-.527
CENTROID X	:	.740	.941	.860
CENTROID Y	:	.143	.112	.224
POA TO CENTROID in.	:	.753	.947	.889
MIN RADIUS	:	.267	.329	.364
MEAN RADIUS	:	.835	.696	.641
MAX RADIUS	:	1.832	1.273	1.163
HORIZONTAL SPREAD	:	2.659	1.849	1.849
VERTICAL SPREAD	:	1.408	1.408	.925
EXTREME SPREAD	:	2.917	2.267	1.918
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

5 Dec 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C8348939

CENTERFIRE PATTERNS # 5

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS- 10

IN CIR

1 in = 5

2 in = 8

3 in = 10

HS= 1.062

VS= 1.866

GS= 1.971

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.614	.338	.344
MINIMUM X	:	-.448	-.380	-.374
MAXIMUM Y	:	.964	.712	.613
MINIMUM Y	:	-.902	-.795	-.673
CENTROID X	:	.636	.568	.562
CENTROID Y	:	.134	.027	.126
POA TO CENTROID in.	:	.650	.569	.576
MIN RADIUS	:	.149	.165	.084
MEAN RADIUS	:	.574	.506	.462
MAX RADIUS	:	1.143	.805	.748
HORIZONTAL SPREAD	:	1.062	.718	.718
VERTICAL SPREAD	:	1.866	1.507	1.286
EXTREME SPREAD	:	1.971	1.564	1.305
NUMBER IN ONE INCH CIRCLE	=		5	
NUMBER IN TWO INCH CIRCLE	=		9	
NUMBER IN THREE INCH CIRCLE	=		10	