

06348944

MODEL 700 TM M24



RECORDS CONTROL SCHEDULE

RECORDS CATEGORY OR TITLE:

873 - APPROVAL FOR ATTENDANCE AT

TECHNICAL MEETINGS

COPY "O" (OFFICIAL) ☒ "X" (EXTRA) ☐

TOTAL RETENTION: UNTIL SUPERSEDED

OR OBSOLETE

GS-11050 Rev. 8/78

Repair Inquiry

Repair Number: **RE00087147**Serial: C6348944 Model: M24 SWS Center Fire
Caliber: 7.62 NATO

Repairman:

Status:

Closed 10/27/2004 2:48:58 PM

Address Information

Customer:

☒ Received From

Return To:

☐ Received From

Name: TRANSPORTATION DIV DFEL

TRANSPORTATION DIV DFEL

Address 1: BLDG 1836

BLDG 1836

Address 2: 6759 MITCHELL AVE

PO Box:

6759 MITCHELL AVE

PO Box:

City: FORT BENNING

FORT BENNING

State: GA

Zip Code: 31905

Country: US

State: GA

Zip Code: 31905

Country: US

FFL

Contact / Condition

Problems

Estimate

History / Status

Shipping / Billing

Contact Information

Phone:

Fax:

Email:

Comments:

Received Condition

Good

Condition:
Notes:CSR:
Notes:

Accessories Received

Code	Desc	Qty
A007	With Stud	3
A010	Hard Case	1
A017	Scope Base	1
C000	F AND R SGT BASES	1

Repair Search

Refresh

Close

nagletj

10/27/2004

3:31 PM

CAPS

NUM

INS

SCPL

start

2

ATTN: BARBER

3

2

Serial Number: **C6348944**Model: **M24 SWS****RE00087147**

R & E NUMBER	87147		
SERIAL NUMBER	C-6348944		
LOG-IN DATE	10-27-04		
INSPECT AND VERIFY:			
OPERATION #	OPERATION NAME	DATE	INITIAL
550	DIS-ASSEMBLE GUN	11-2-04	RA
560 A	RE-BARREL	N/A	RA
B	DRILL AND TAP		
575	ASSEMBLE		
600	PROOF		
605	CHECK HEADSPACE		
610	DIS-ASSEMBLE GUN		
612	MAGNAFLUX		
615	ROLLMARK CALIBER		
618	ROTO-BLAST	11-6-04	LB
620	APPLY COATINGS	11/9	HP
625 A	FINAL ASSEMBLY	11-19-04	RL
B	TRIGGER PULL TEST	N/A	N/A
C	SAFETY "ON" FORCE		
D	SAFETY "OFF" FORCE		
E	FIRING PIN INDENT		
640	TARGET		
655	FINAL INSPECT	11-23-04	AC
660	PACK	11/24/04	RA
		SHIP DATE	
QAR INSPECTION DATE			

Parts/Repairs 800-243-9700
Fax 336-548-7801

www.remington.com info@remington.com

**REPAIR
DOCUMENT****REPAIR
DOCUMENT**

Repair Order Number RE00057379 Account # - R-	Description/Serial Number C6348944 Model 700 Center Fire Caliber: 7.62 NATO M-24 (SWS)	Date Received - 12/12/2002 Estimate Date - Current Date - 12/13/2002
Customer USAIC DFEL SUPPLY DIV BLDG 490 FORT BENNING. GA 31905 US	Return To USAIC DFEL SUPPLY DIV BLDG 490 FORT BENNING. GA 31905 US	
Phone (H) Phone (W)	Fax Email	

Problems	
Reported	Found
M993 REFURBISH	

Technician's Comments	
Condition	REC'D IN HARD CASE W/ OTHER GUN.

Serial Number:	C6348944	
Model:	700	
Material #	Material	intv (Y/N)
Total:	 RE00057379	

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6348944.___0

FILE DATE AND TIME: 01/16/2003 14:25

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.058
The Average Y Centroid of the Five Target Set:	-0.033
The Average Point of Impact of the Five Target Set:	0.067
The Average Mean Radius of the Five Target Set:	0.528
The Distance from POA to Centroid Target #1:	0.243
The Distance from Centroid Target #2 to Centroid Target #1:	0.274
The Distance from Centroid Target #3 to Centroid Target #1:	0.253
The Distance from Centroid Target #4 to Centroid Target #1:	0.251
The Distance from Centroid Target #5 to Centroid Target #1:	0.195

SERIAL NUMBER: C6348944. __0

TARGET NUMBER: 1

FILE DATE: 01/16/2003

FILE TIME: 14:25

X CENTROID: -0.118

Y CENTROID: -0.212

POA TO CENTROID: 0.243

HORZ SPREAD: 0.804

VERT SPREAD: 1.618

GROUP SPREAD: 1.630

MIN RADIUS: 0.200

MAX RADIUS: 1.044

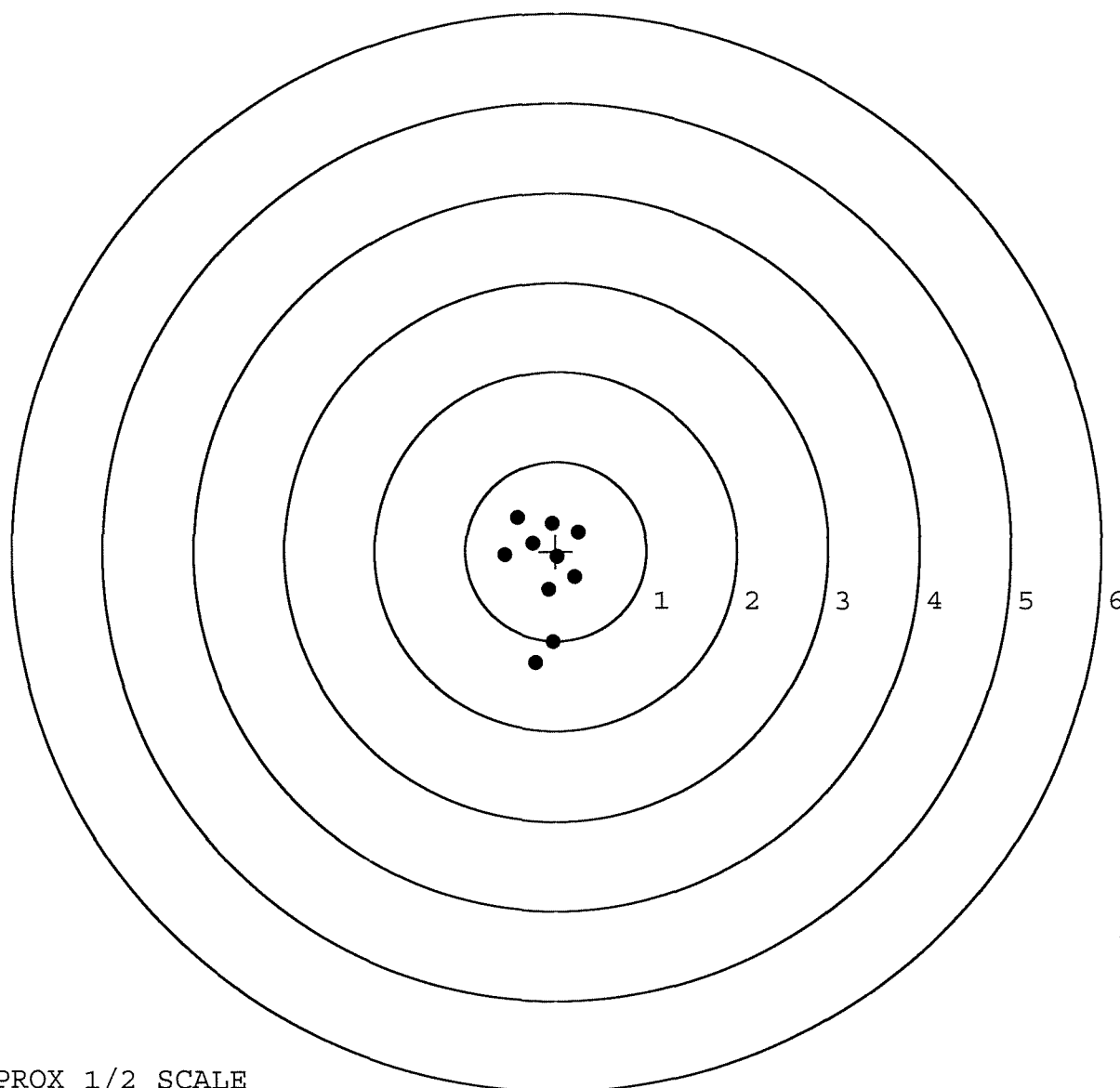
MEAN RADIUS: 0.516

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.035	-1.014
2:	-0.233	-1.250
3:	-0.562	-0.047
4:	-0.081	-0.433
5:	0.213	-0.293
6:	0.242	0.213
7:	-0.047	0.308
8:	-0.429	0.368
9:	-0.259	0.088
10:	0.015	-0.062



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6348944. __0

TARGET NUMBER: 2

FILE DATE: 01/16/2003

FILE TIME: 14:25

X CENTROID: 0.033

Y CENTROID: 0.017

POA TO CENTROID: 0.037

HORZ SPREAD: 1.188

VERT SPREAD: 3.045

GROUP SPREAD: 3.262

MIN RADIUS: 0.066

MAX RADIUS: 1.984

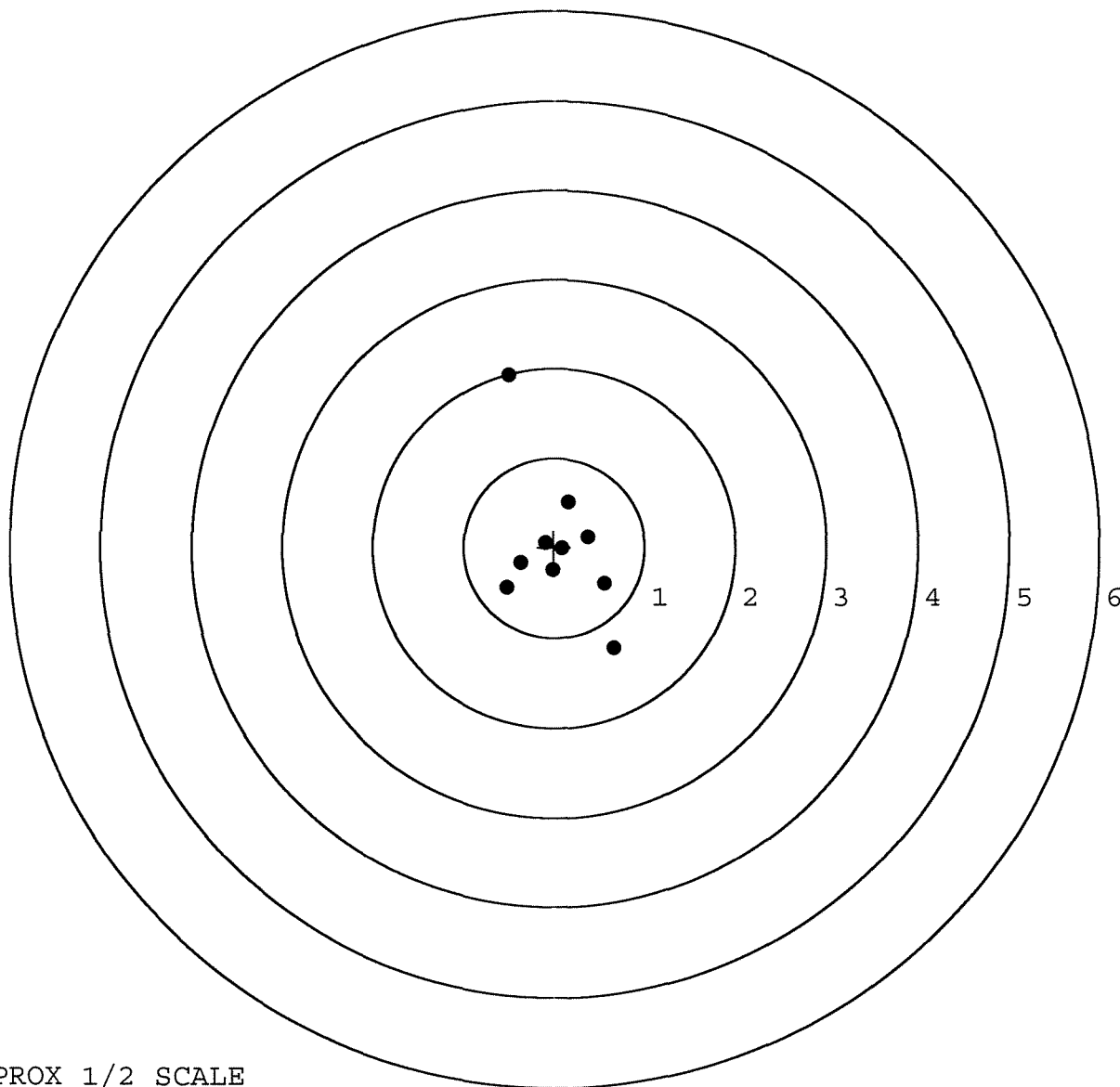
MEAN RADIUS: 0.647

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 9

POINT#	X	Y
1:	0.664	-1.119
2:	0.556	-0.403
3:	-0.506	1.926
4:	0.376	0.114
5:	0.158	0.507
6:	-0.524	-0.447
7:	-0.367	-0.179
8:	-0.015	-0.259
9:	-0.099	0.050
10:	0.088	-0.019



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6348944. __0

TARGET NUMBER: 3

FILE DATE: 01/16/2003

FILE TIME: 14:25

X CENTROID: -0.126

Y CENTROID: 0.041

POA TO CENTROID: 0.133

HORZ SPREAD: 1.865

VERT SPREAD: 1.104

GROUP SPREAD: 1.930

MIN RADIUS: 0.062

MAX RADIUS: 1.102

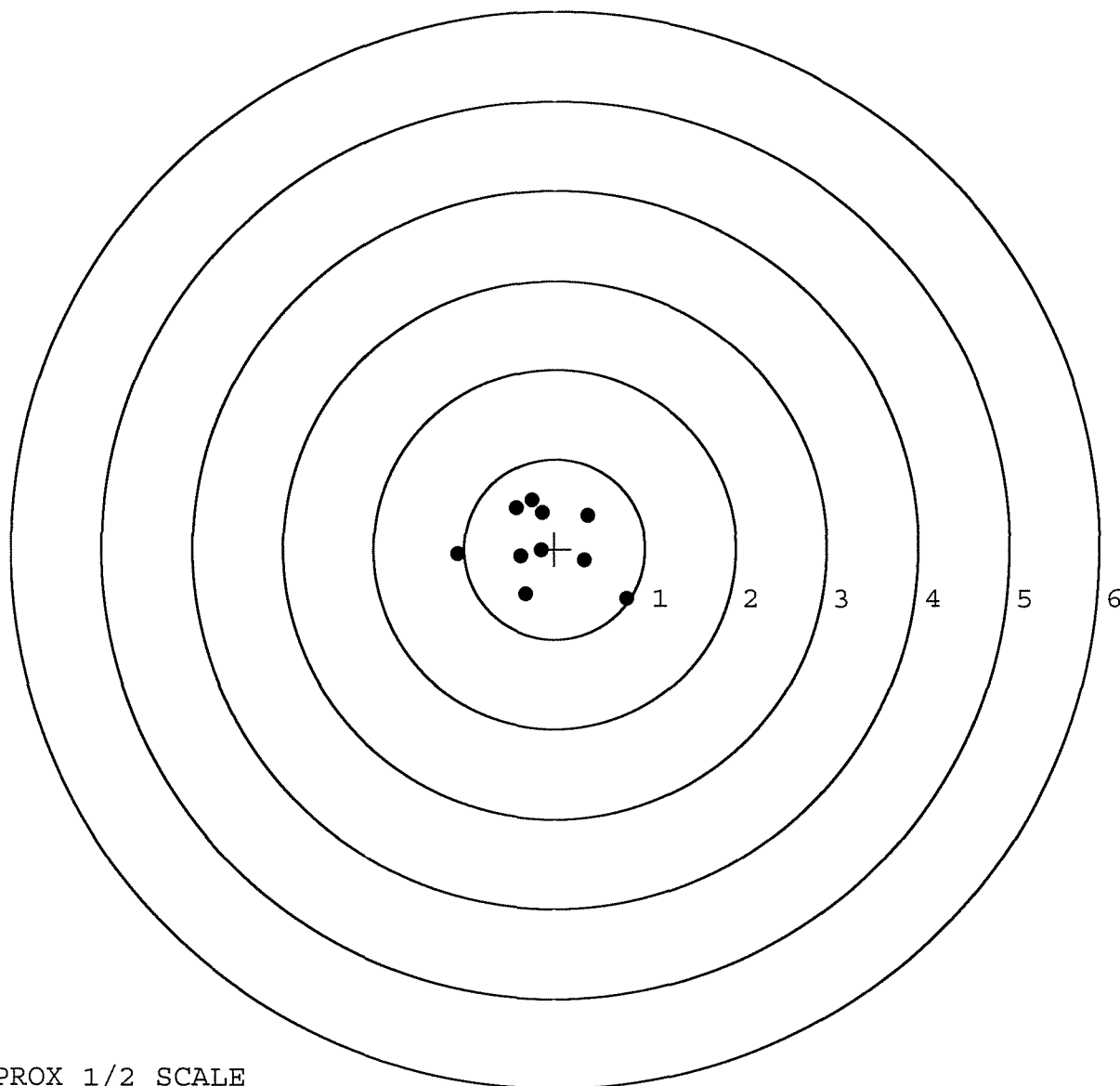
MEAN RADIUS: 0.543

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.797	-0.560
2:	-0.325	-0.501
3:	0.330	-0.130
4:	0.360	0.368
5:	-0.150	-0.016
6:	-0.378	-0.084
7:	-1.068	-0.062
8:	-0.143	0.402
9:	-0.428	0.449
10:	-0.258	0.544



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6348944. __0

TARGET NUMBER: 4

FILE DATE: 01/16/2003

FILE TIME: 14:25

X CENTROID: -0.055

Y CENTROID: 0.031

POA TO CENTROID: 0.064

HORZ SPREAD: 1.946

VERT SPREAD: 0.758

GROUP SPREAD: 1.947

MIN RADIUS: 0.083

MAX RADIUS: 1.213

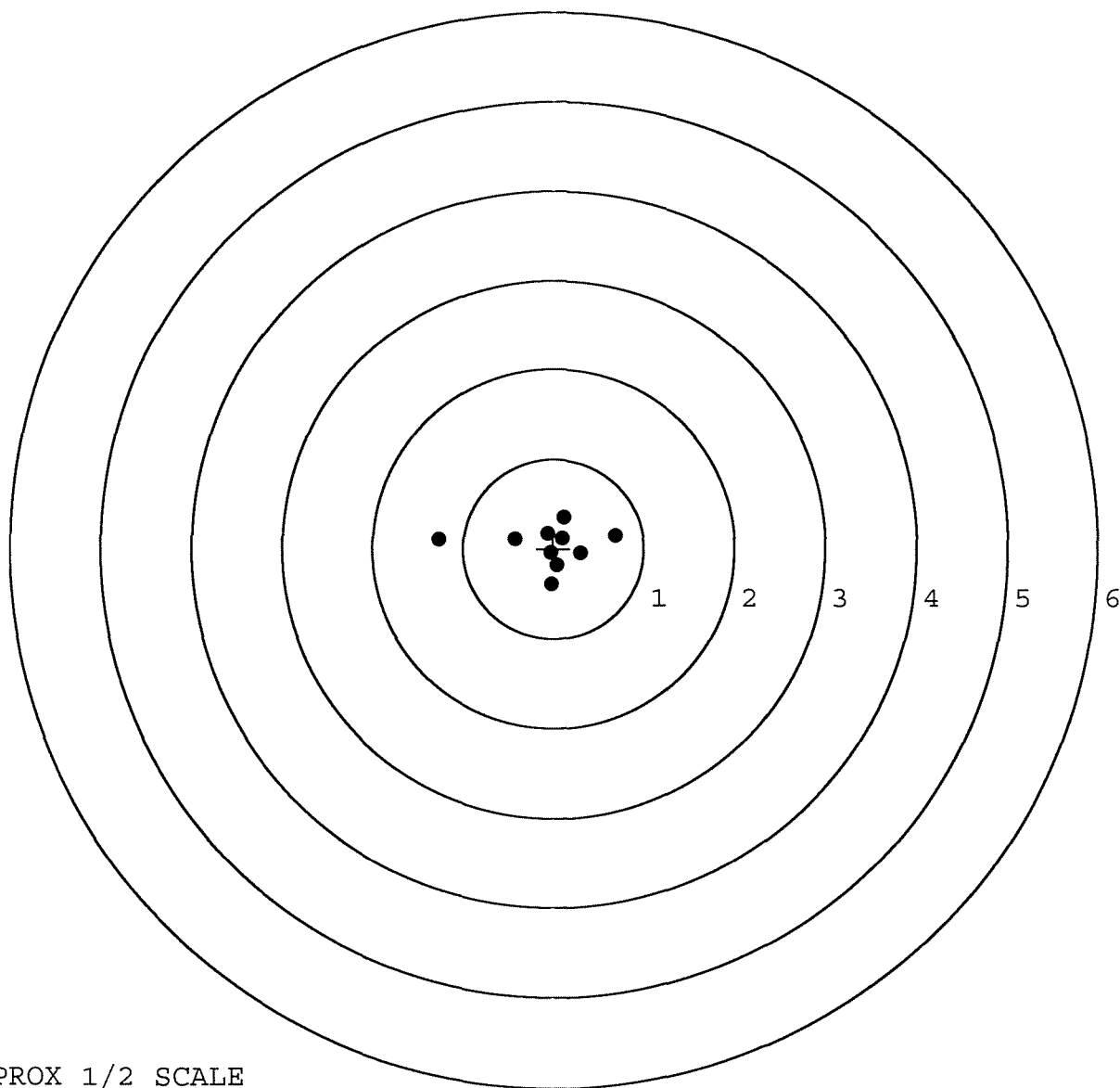
MEAN RADIUS: 0.415

IN 1 IN DIAMETER: 8

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.680	0.152
2:	-1.266	0.105
3:	-0.023	-0.405
4:	-0.422	0.112
5:	0.119	0.353
6:	-0.066	0.167
7:	-0.030	-0.048
8:	0.306	-0.050
9:	0.106	0.118
10:	0.042	-0.193

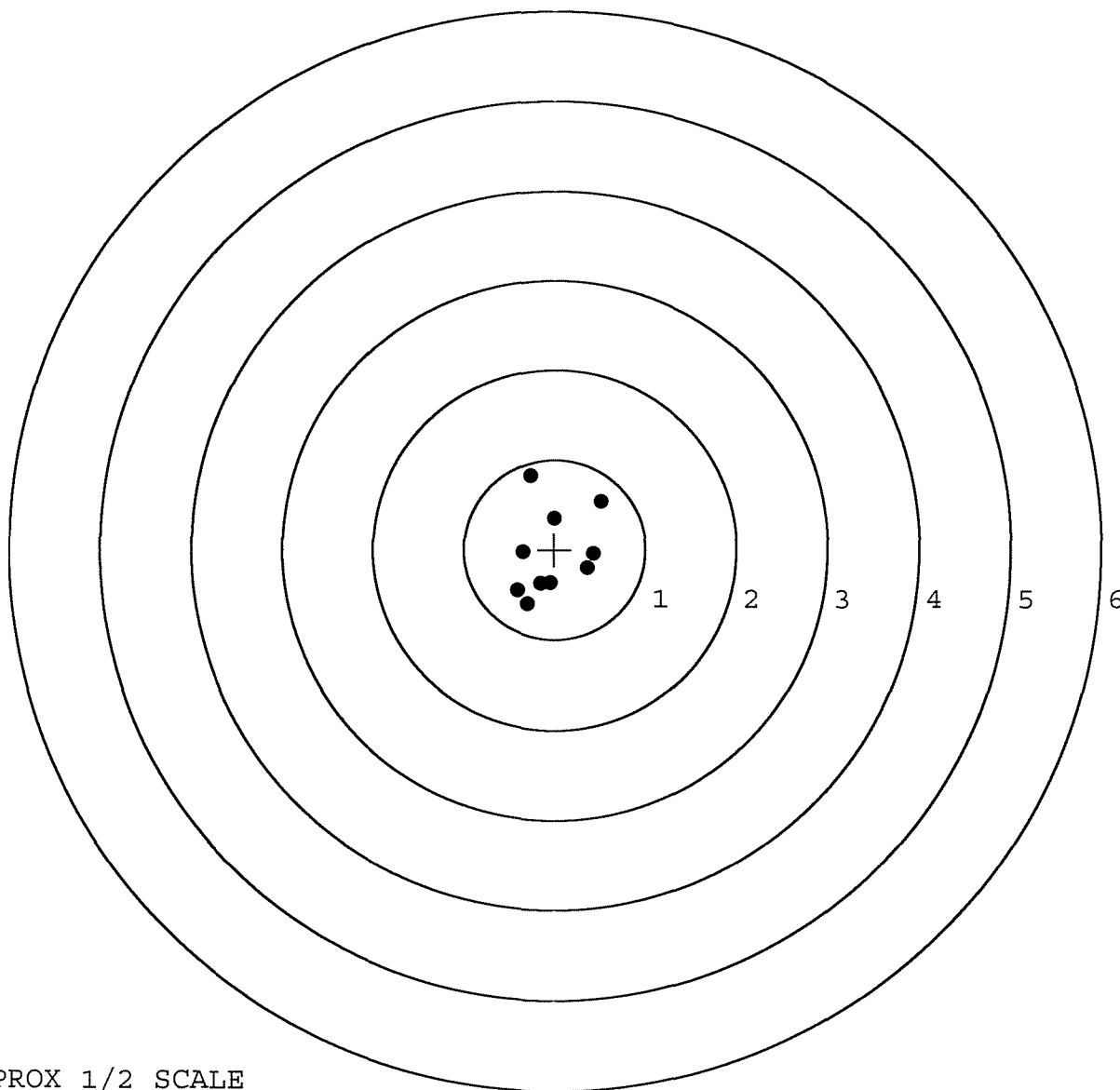


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6348944. __0
 TARGET NUMBER: 5
 FILE DATE: 01/16/2003
 FILE TIME: 14:25

X CENTROID: -0.025
 Y CENTROID: -0.041
 POA TO CENTROID: 0.048
 HORZ SPREAD: 0.918
 VERT SPREAD: 1.431
 GROUP SPREAD: 1.431
 MIN RADIUS: 0.328
 MAX RADIUS: 0.899
 MEAN RADIUS: 0.518
 # IN 1 IN DIAMETER: 6
 # IN 2 IN DIAMETER: 10
 # in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.509	0.535
2:	-0.010	0.352
3:	-0.269	0.824
4:	-0.353	-0.033
5:	0.430	-0.049
6:	0.361	-0.211
7:	-0.049	-0.375
8:	-0.409	-0.463
9:	-0.301	-0.607
10:	-0.155	-0.383



TARGET APPROX 1/2 SCALE

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

DATE 1-02-03

TESTER TRW

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.61	2.45		2.51	MIN. SETTING
PULL #2	2.53	2.44		2.43	NO AVG. OF 5
PULL #3	2.52	2.40		2.33	READINGS ACCEPT
PULL #4	2.53	2.42		2.44	ABLE LESS THAN
PULL #5	2.46	2.37		2.42	
TOTAL	12.65	12.08		12.13	
AVG.	2.53	2.41		2.42	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.07	3.18		
PULL #2	3.14	3.04		
PULL #3	3.15	3.09		
PULL #4	3.12	2.97		
PULL #5	3.18	3.14		
TOTAL	15.66	15.42		
AVG.	3.13	3.08		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# & ACCU
PULL #1	4.11	4.03		4.14
PULL #2	4.05	4.33		4.21
PULL #3	4.01	4.40		4.23
PULL #4	4.05	4.39		4.16
PULL #5	4.04	4.42		4.18
TOTAL	20.26	21.57		20.92
AVG.	4.05	4.31		4.18

SERIAL # C6348944 INSPECTED BY: RTL
DATE REC'D: 12-12-02 DATE RET'D: 1-16-03

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	57379		
SERIAL NUMBER	C6348944		
LOG-IN DATE	12-12-02		
INSPECT AND VERIFY:			
OPERATION #	OPERATION NAME	DATE	INITIAL
550	DIS-ASSEMBLE GUN	1-2-03	RTL
560 A	RE-BARREL	1-3-03	DA
B	DRILL AND TAP	1-7-03	TRW
575	ASSEMBLE	1-7-03	RL
600	PROOF	1-7-03	RW
605	CHECK HEADSPACE	1-7-03	RW
610	DIS-ASSEMBLE GUN	1-7-03	RW
612	MAGNAFLUX	1-8-03	JD
615	ROLLMARK CALIBER	1-7-03	RW
618	ROTO-BLAST	1-8-03	RL
620	APPLY COATINGS	1-10	TA
625 A	FINAL ASSEMBLY	1-14-03	RL
B	TRIGGER PULL TEST	1-16-03	TRW
C	SAFETY "ON" FORCE	1-16-03	TRW
D	SAFETY "OFF" FORCE	1-16-03	TRW
E	FIRING PIN INDENT		
640	TARGET	1-15-03	AC
655	FINAL INSPECT	1-16-03	RL
660	PACK	1/16/03	DA
		SHIP DATE	
	QAR INSPECTION DATE		

Remington Test Lab, Ilion, N.Y.

Centroidal distance calculations for Rifle # c6348944
7 Feb 2000

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .047
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1236
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .132234

THE AMR FOR THIS RIFLE IS: 1.226

CENTROIDAL DISTANCES

0 TO	1	.286225
1 TO	2	.177767
1 TO	3	.499625
1 TO	4	.668205
1 TO	5	.139714

2+ 3⁴ <----POA
1
5

PATTERN #: 1

POA TO CENTROID: .287

MIN RADIUS : .309

MEAN RADIUS : 1.214

MAX RADIUS : 2.915

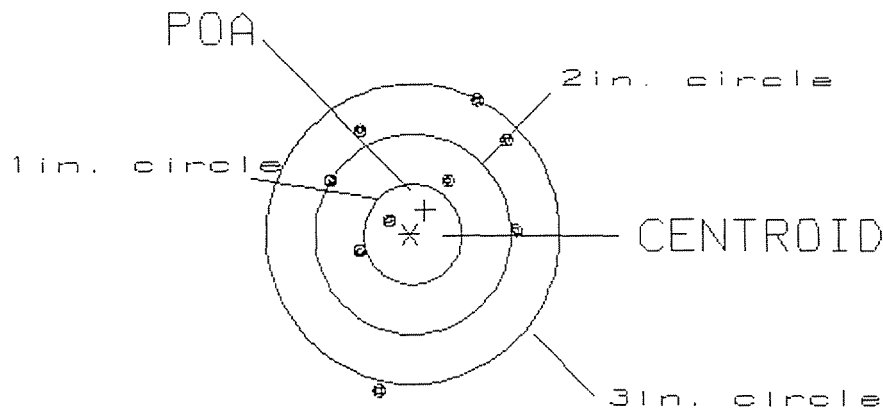
CENTROID X : -.159

CENTROID Y : -.238

7 Feb 2000

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6348944

CENTERFIRE PATTERN # 1



OF SHOTS= 10

IN CIRCLE

HS= 1.96

1

VS= 4.28

3

GS= 4.40

7

PATTERN #: ☐ 2 ☐

POA TO CENTROID: .148

MIN RADIUS : .477

MEAN RADIUS : 1.089

MAX RADIUS : 1.960

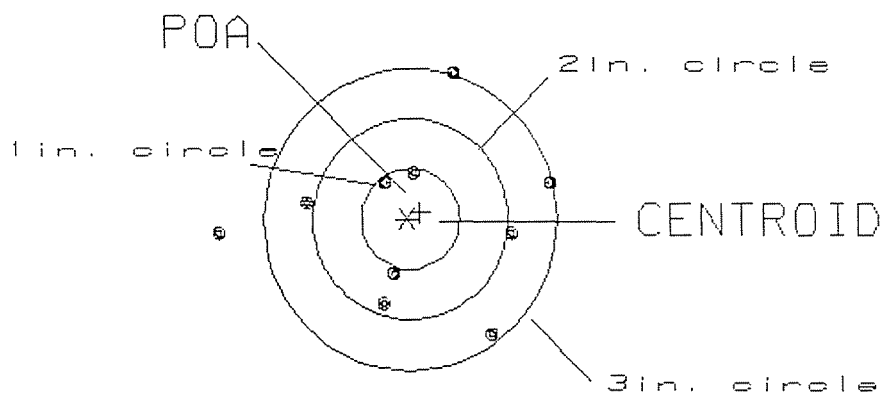
CENTROID X : -.134

CENTROID Y : -.062

7 Feb 2000

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6348944

CENTERFIRE PATTERN # 2



OF SHOTS= 10

IN CIRCLE

HS= 3.39

2

VS= 2.60

4

GS= 3.43

9

PATTERN #: 3

POA TO CENTROID: .304

MIN RADIUS : .149

MEAN RADIUS : 1.440

MAX RADIUS : 2.648

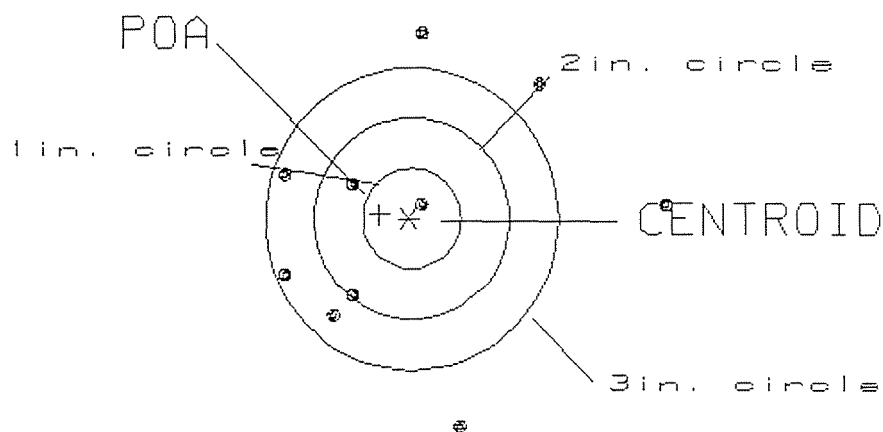
CENTROID X : .301

CENTROID Y : -.043

7 Feb 2000

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6348944

CENTERFIRE PATTERN # 3



OF SHOTS= 10

IN CIRCLE

HS= 3.96

1

VS= 3.97

3

GS= 4.02

6

PATTERN #: ☐ 4 ☐

POA TO CENTROID: .430

MIN RADIUS : .373

MEAN RADIUS : 1.429

MAX RADIUS : 2.563

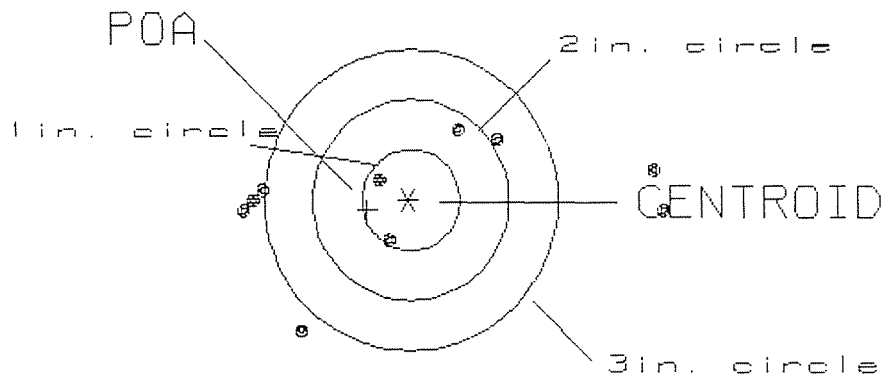
CENTROID X : .418

CENTROID Y : .099

7 Feb 2000

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6348944

CENTERFIRE PATTERN # 4



OF SHOTS= 10

IN CIRCLE

HS= 4.26

2

VS= 2.04

3

GS= 4.26

5

PATTERN #: 1 5

POA TO CENTROID: .420

MIN RADIUS : .167

MEAN RADIUS : .958

MAX RADIUS : 2.545

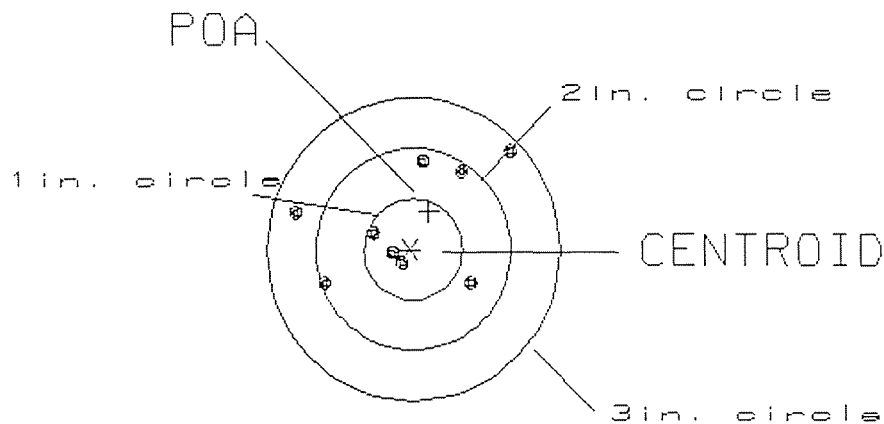
CENTROID X : -.191

CENTROID Y : -.374

7 Feb 2000

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6348944

CENTERFIRE PATTERN # 5



OF SHOTS= 10

IN CIRCLE

HS= 2.16

3

VS= 3.45

7

GS= 3.47

9

M-24

CONTRACT # DAAA09-92-C-0834

R&E NO.

SERIAL NO.

C6348944

LOG IN DATE: / /		DATE	INIT.
INSPECT & VERIFY:			
OP. #	OP. NAME		
550	DIS-ASSEMBLE GUN		
560 A	RE-BARREL AT CUSTOM SHOP		
B	DRILL & TAP		
C	POLISH		
575	ASSEMBLE		
600	PROOF	12-12-99	RW
605	CHECK HEADSPACE	12-12-99	RW
610	DIS-ASSEMBLE		
612	MAGNAFLUX		
615	ROLLMARK CALIBER		
618	ROTO-BLAST		
620	APPLY COATINGS		
625 A	FINAL ASSEMBLY		
B	TRIGGER PULL TEST		
C	SAFETY ON FORCE		
D	SAFETY OFF FORCE		
E	FIRING PIN INDENT		
640	TARGET	2-2-00	RW
655	FINAL INSPECT	2-8-00	RW
660	PACK		

QAR INSPECTION

SHIP DATE

Final Inspection

Sn: C6348944

DATE REC'D: 10-18-99

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:

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C634 8944

DATE _____

TESTER _____

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.55	2.48	2.50		MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.45	2.58	2.45		
PULL #3	2.53	2.47	2.51		
PULL #4	2.57	2.43	2.54		
PULL #5	2.28	2.54	2.40		
TOTAL	12.38	12.50	12.40		
AVG.	2.476	2.5	2.48		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.50	3.38		
PULL #2	3.28	3.44		
PULL #3	3.36	3.15		
PULL #4	3.32	3.11		
PULL #5	3.44	3.42		
TOTAL	16.90	16.50		
AVG.	3.38	3.3		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.14	4.29		4.27
PULL #2	4.52	4.31		4.57
PULL #3	4.42	4.49		4.41
PULL #4	4.43	4.43		4.38
PULL #5	4.44	4.48		4.45
TOTAL	21.95	21.99		22.08
AVG.	4.39	4.398		4.416

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

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

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

MODEL 700™ M24

SERIAL NO.
06048944

ORDER NO.
5716

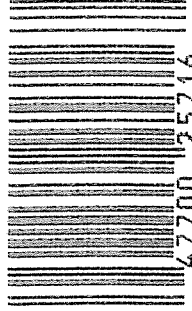
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.

01



5716 06048944

UPC



0 47700 25716 7

GUN SERIAL # C6348944

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	10-9	89	RW
600	Proof	10-9	89	RW
607	Check Headspace	10-9	89	RW
610	Dis-assemble Gun	10-9	89	RW
612	Magnaflux Barrel Action		11/2/89	KCR
	Magnaflux Bolt		11/2/89	KCR
615	Rollmark Caliber		11/2/89	G.S.
7	Drill and Tap Sight Holes			
618	Polish Barrel			
620	Apply Coatings (Barrel Action)		11-3-89	TJA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		11/6/89	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		11/6/89	RW
	C) Inspect Ejector Hole for Chamfer		11/6/89	RW
	D) Oil Firing Pin Ass'y		11/6/89	RW
	E) Adjust Trigger Pull to Min Setting and Stake		14/6/89	JS

op. #	OP. NAME	READINGS			DATE	INIT	
625 cont.	F) Safety On Force	6	6	6	11-14-89	JH	
	G) Safety Off Force	3	3	3	11-14-89	JH	
	H) Trigger Pull Test & Retainability				14 Nov 89	JH	
	I) Firing Pin Indent	.0225	.0225	.0225	11-14-89	JH	
	J) Assemble Stock				11/15/89	RW	
	K) Assemble Swivel Studs				27 Nov 89	JH	
	L) Attach Front and Rear Sight Assemblies				11/15/89	RW	
	M) Iron Sight Alignment				11/15/89	RW	
	N) Detach Front & Rear Sights & place in numbered container				11/15/89	RW	
	O) Attach Scope to Rifle				15 Nov 89	JH	
	P) Detach & Attach Scope 20 Times				15 Nov 89	JH	
640	Gallery Target & Test				11-16-89	DH	
	A) Time				11-16-89	DH	
	B) Malfunctions				11-16-89	DH	
	C) Pierced Primers				11-16-89	DH	
	D) Optical Clarity of Scope				11-16-89	DH	
645	Inspect for Live Ammo				11-16-89	DH	
655	Final Inspection						
	A) Headspace				27 Nov 89	JH	
	B) Trigger Pull	266	278	275	266	2.82	27 Nov 89
	C) Function				27 Nov 89	JH	
660	Pack				15 Dec 89	JH	

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6348944
16 Nov 1989

CENTROIDAL DISTANCES

0 TO	1	.480833
1 TO	2	.290396
1 TO	3	.44041
1 TO	4	.715268
1 TO	5	.52

$\frac{4}{5}$ $\frac{3}{4}$ $\frac{2}{1}$ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1442
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0854
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .167591
THE AMR FOR THIS RIFLE IS: .957

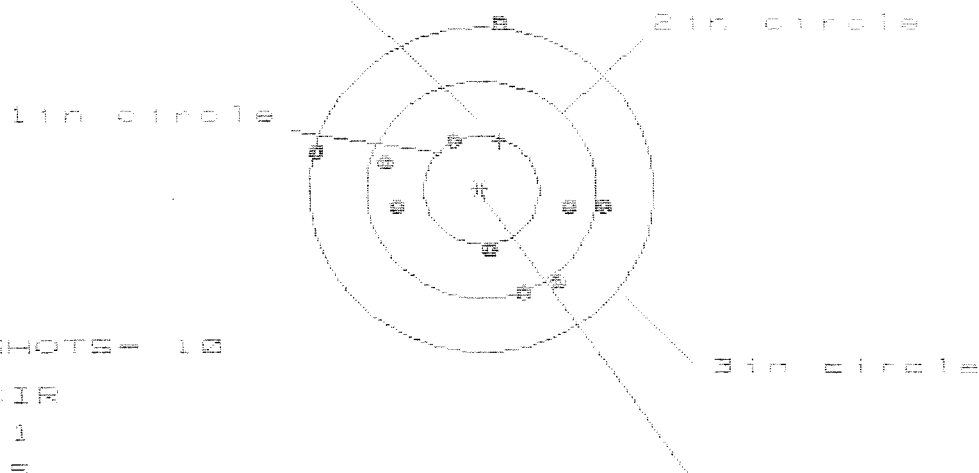
16 Nov 1985

FILE:/PATTERNING/CENTERFIRE_PATT/06348944

CENTERFIRE PATTERNS

1

POA



OF SHOTS = 10

IN CIR

1in = 1

2in = 5

3in = 4

HS = 0.459

VS = 0.529

GS = 0.540

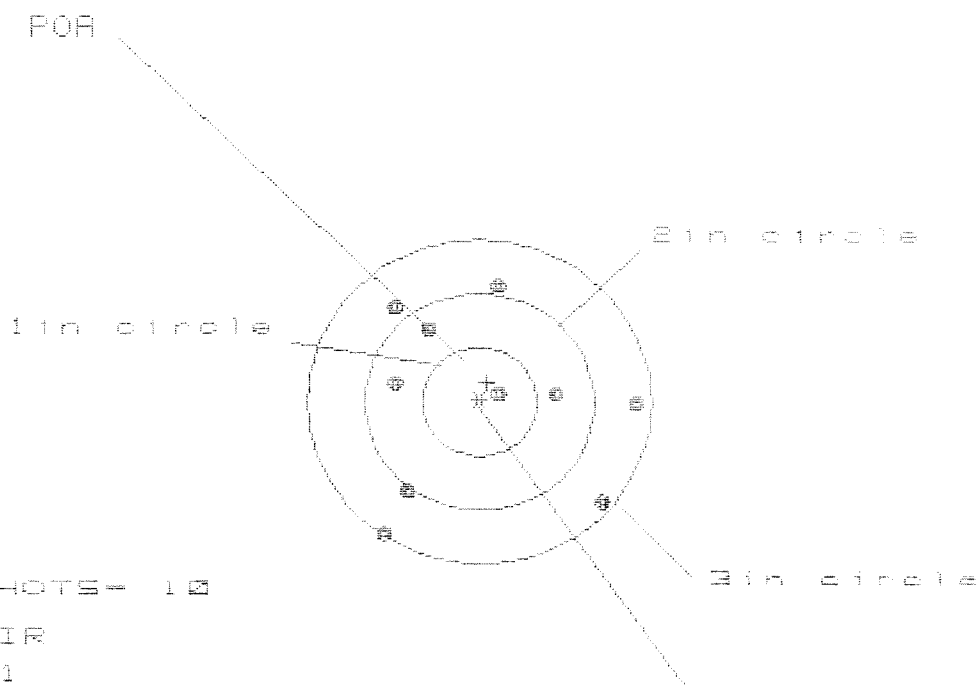
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.049	1.066	.893
MINIMUM X	-1.404	-1.387	-.997
MAXIMUM Y	1.572	.596	.668
MINIMUM Y	-.957	-.782	-.710
CENTROID X	-.164	-.181	-.008
CENTROID Y	-.452	-.627	-.699
POA TO CENTROID in.	.481	.652	.699
MIN RADIUS	.463	.351	.257
MEAN RADIUS	.962	.872	.764
MAX RADIUS	1.580	1.502	1.133
HORIZONTAL SPREAD	2.453	2.453	1.890
VERTICAL SPREAD	2.529	1.378	1.378
EXTREME SPREAD	2.540	2.505	1.932
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	9		

16 Nov 1985

FILE:\PATTERNING\CENTERFIRE_PATT\08348344

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 4

3 in = 10

HS= 2.127

VS= 2.244

GS= 2.529

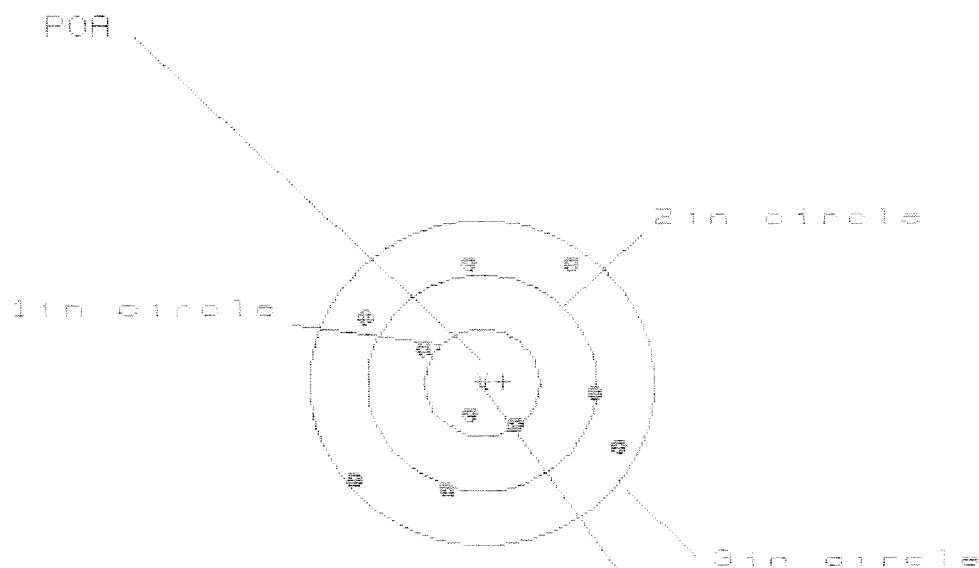
CENTROID #

PATTERN #	2	2	2
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.331	1.243	1.362
MINIMUM X	-.795	-.861	-.742
MAXIMUM Y	1.047	.914	.780
MINIMUM Y	-1.197	-1.067	-1.054
CENTROID X	-.065	.024	-.095
CENTROID Y	-.179	-.046	.088
POA TO CENTROID in.	.190	.051	.129
MIN RADIUS	.228	.136	.307
MEAN RADIUS	.993	.918	.844
MAX RADIUS	1.438	1.430	1.401
HORIZONTAL SPREAD	2.127	2.104	2.104
VERTICAL SPREAD	2.244	1.981	1.834
EXTREME SPREAD	2.529	2.529	2.243
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		4	
NUMBER IN THREE INCH CIRCLE =		10	

16 Nov 1989

FILE:/PATTERNING/CENTERFIRE_PATT/06346344

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 2

2in = 3

3in = 10

HS= 2.324

VS= 2.074

GS= 2.696

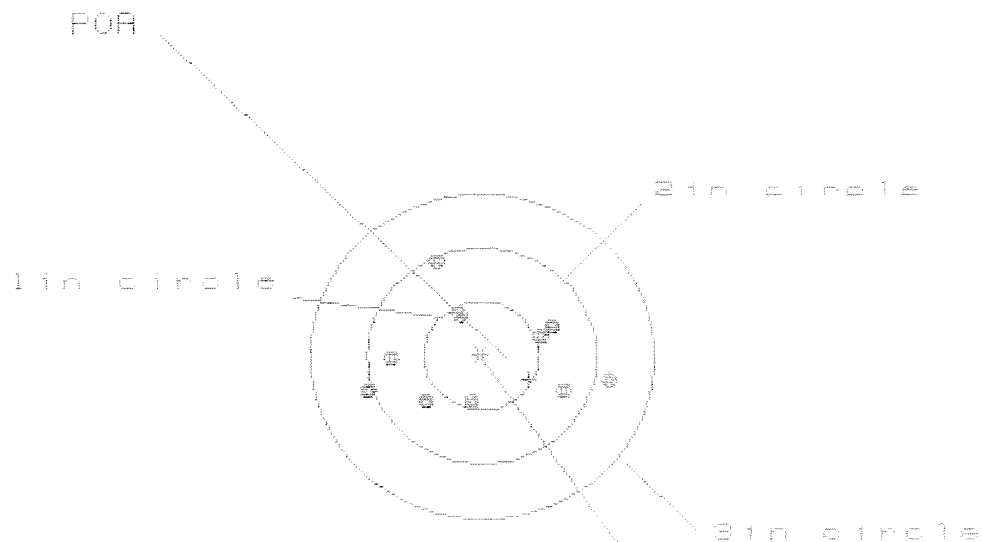
CENTROID #

PATTERN #	3	3	3
SHOTS (BEST OF)	10	9	9
MAXIMUM X	1.146	1.026	1.110
MINIMUM X	-1.078	-1.136	-1.052
MAXIMUM Y	1.100	1.004	1.127
MINIMUM Y	-.974	-1.070	-.947
CENTROID X	-.183	-.063	-.147
CENTROID Y	-.012	.084	-.039
POA TO CENTROID in.	.183	.105	.153
MIN RADIUS	.273	.419	.270
MEAN RADIUS	.968	.930	.868
MAX RADIUS	1.379	1.255	1.262
HORIZONTAL SPREAD	2.224	2.162	2.162
VERTICAL SPREAD	2.074	2.074	2.074
EXTREME SPREAD	2.696	2.491	2.491
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	3		
NUMBER IN THREE INCH CIRCLE =	10		

16 Nov 1989

FILE:/PATTERNING/CENTERFIRE_PATT/06346344

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 8

3 in = 10

HS= 2.120

VS= 1.363

GS= 2.121

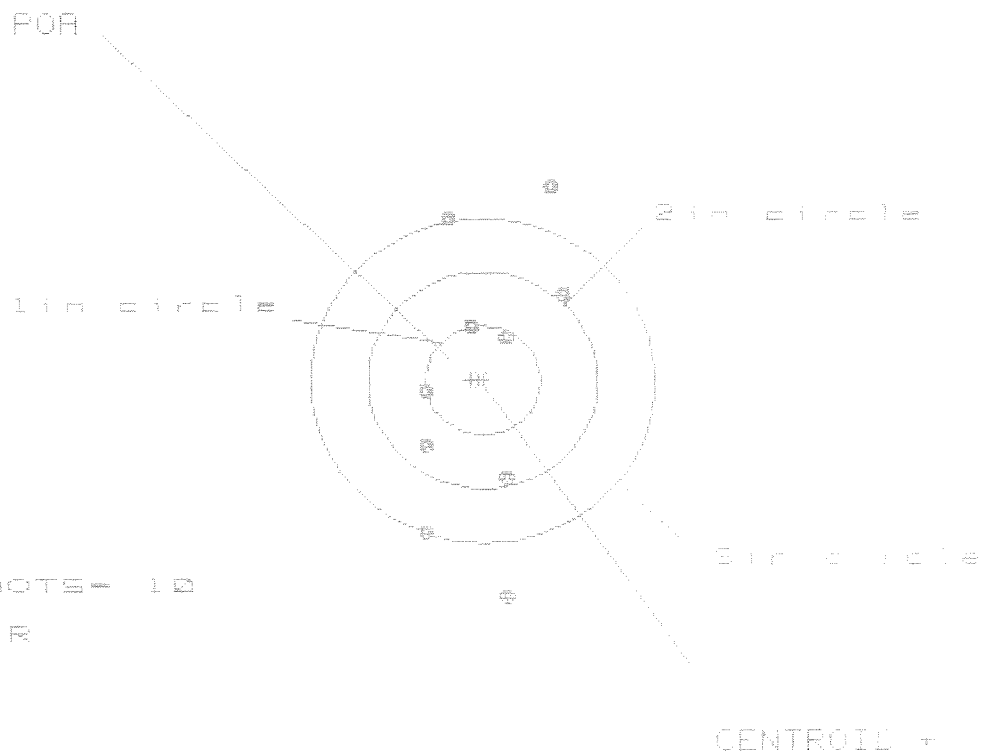
CENTROID *

PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.101	.877	.765
MINIMUM X	-1.019	-.896	-.785
MAXIMUM Y	.921	.895	.856
MINIMUM Y	-.442	-.468	-.507
CENTROID X	-.409	-.532	-.420
CENTROID Y	.220	.246	.285
POA TO CENTROID in.	.465	.586	.507
MIN RADIUS	.420	.349	.360
MEAN RADIUS	.746	.696	.658
MAX RADIUS	1.126	.949	.931
HORIZONTAL SPREAD	2.120	1.773	1.550
VERTICAL SPREAD	1.363	1.363	1.363
EXTREME SPREAD	2.121	1.773	1.655
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	8		
NUMBER IN THREE INCH CIRCLE =	10		

18 Nov 1989

FILE:/PATTERNING/CENTERFIRE_PAT 01348344

CENTERFIRE PATTERN # 5



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 5

3 in = 8

HS = 1.245

VS = 3.734

GS = 3.757

PATTERN #	5	5	5
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.731	.752	.829
MINIMUM X	-.514	-.493	-.416
MAXIMUM Y	1.759	1.539	1.427
MINIMUM Y	-1.975	-1.607	-1.414
CENTROID X	.100	.079	.022
CENTROID Y	-.004	.216	.023
POA TO CENTROID in.	.100	.230	.033
MIN RADIUS	.480	.334	.398
MEAN RADIUS	1.116	.991	.905
MAX RADIUS	1.984	1.681	1.474
HORIZONTAL SPREAD	1.245	1.245	1.245
VERTICAL SPREAD	3.734	3.146	2.841
EXTREME SPREAD	3.757	3.336	2.847
NUMBER IN ONE INCH CIRCLE =	1	1	1
NUMBER IN TWO INCH CIRCLE =	5	5	5
NUMBER IN THREE INCH CIRCLE =	8	8	8

BARBER - M24 M2400042292

1 2 3 4 5 6 7 8 9 10 11 12 13 14 15 16 17 18 19 20 21 22 23 24 25 26 27 28 29 30 31 32 33 34 35 36 37 38 39 40 41 42 43 44 45 46 47 48 49 50 51 52 53 54 55 56 57 58 59 60 61 62 63 64 65 66 67 68 69 70 71 72 73 74 75 76 77 78 79 80																																																																																																																																											
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DD Form 1348-1, JUL 91

PREVIOUS EDITION MAY BE USED

DOD SINGLE LINE ITEM RELEASE/RECEIPT DOCUMENT

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

CSGLD - 1047(R1)

SECTION I - EQUIPMENT DATA

CONTROL NUMBER		WORK ORDER NO.		WESDC	ORG. PD 03	PD AUTHENTICATION		
☒ Work Request ☐ MWO ☐ Warranty Claim		1A. ORGANIZATION C 29 int		B. LOCATION St Bann. 76A 31905			C. UNIT IDENT CODE	
2. SERIAL NO. C634 09614		3. NOUN NOMENCLATURE Swiper R-11		4. LINE NO. R93387	5. MODEL M24	6. NATIONAL STOCK NUMBER 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
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 ☐ 259 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).

Trigger out set and it needs adjusting

B. REMARKS

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.			D. MANHOURS (Hrs. & tenths)	E. NATIONAL STOCK NUMBER		F. PART SOURCE CODE	G. QTY.	H. PARTS COST
		(1) CB CODE	(2) REF DESIGN.	(3) MFR. CODE						
					.					\$
					.					\$
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					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		28. DISPOSITION (Select One)
										☐ A To User ☐ D Evacuated ☐ B To Stock ☐ E Cannibalization ☐ C Salvaged
JULIAN DATE		JULIAN DATE		JULIAN DATE		JULIAN DATE		JULIAN DATE		

DA FORM 2407, AUG 88

EDITION OF MAY 81 MAY BE USED

ORGANIZATION COPY 4

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER

BARBER - M24 M2400042294

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6348944

OP. #	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and Stock		5/8/96	RW
600	Proof		5/8/96	RW
607	Check Headspace		5/8/96	RW
610	Dis-assemble Gun		5/8/96	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		5/15/96	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/15/96	RW
	C) Inspect Ejector Hole for Chamfer		5/15/96	RW
	D) Oil Firing Pin Ass'y		5/15/96	RW
	E) Adjust Trigger Pull to Min Setting and Stake			

Op. #	DESCRIPTION	READINGS			DATE	INITIALS
625 cont.	F) Safety On Force					
	G) Safety Off Force					
	H) Trigger Pull Test & Retainability					
	I) Firing Pin Indent					
	J) Assemble Stock				5/15/96	RW
	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				5/14/96	AT
	A) Time					
	B) Malfunctions					
	C) Pierced Primers					
	D) Optical Clarity of Scope					
645	Inspect for Live Ammo				5/14/96	AT
655	Final Inspection					
	A) Headspace				5/14/96	RW
	B) Trigger Pull				5/14/96	RW
	C) Function				5/14/96	RW
660	Pack					

Final Inspection

Sn: C6348944

DATE REC'D: 5/3/96

DATE RET'D:

Auditor: MW

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 # C6348944
 18 Mar 1988

CEN DAL DISTANCES

0 TO	1	.590455
1 TO	2	.378112
1 TO	3	.162641
1 TO	4	.374553
1 TO	5	.470106

#3 <----POA

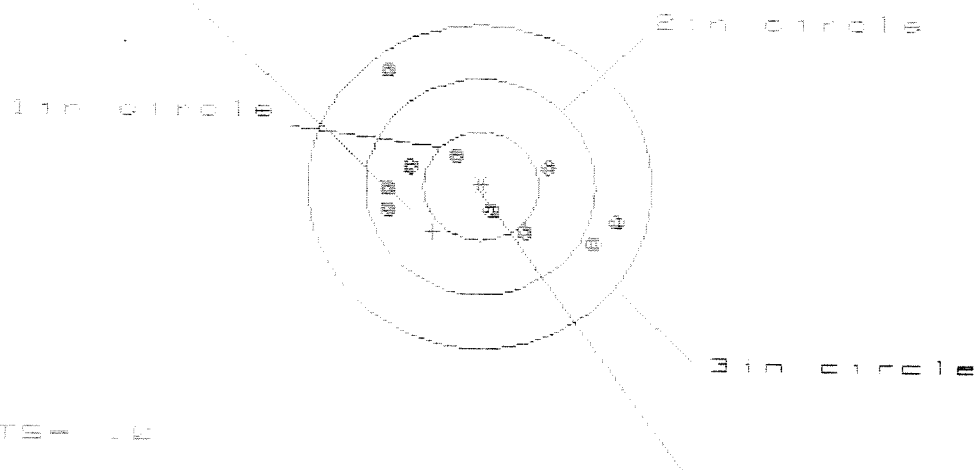
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .2404
 THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .222
 THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .327225
 THE AMP FOR THIS RIFLE IS: 1.028

16 Mar 1988

FILE:/PATTERNING/CENTERFIRE_PAT7/06348344

CENTERFIRE PATTERNS # 1

POA



OF SHOTS = 10

IN CIR

1in = 2

2in = 7

3in = 10

HS = 1.997

VS = 1.632

GS = 2.427

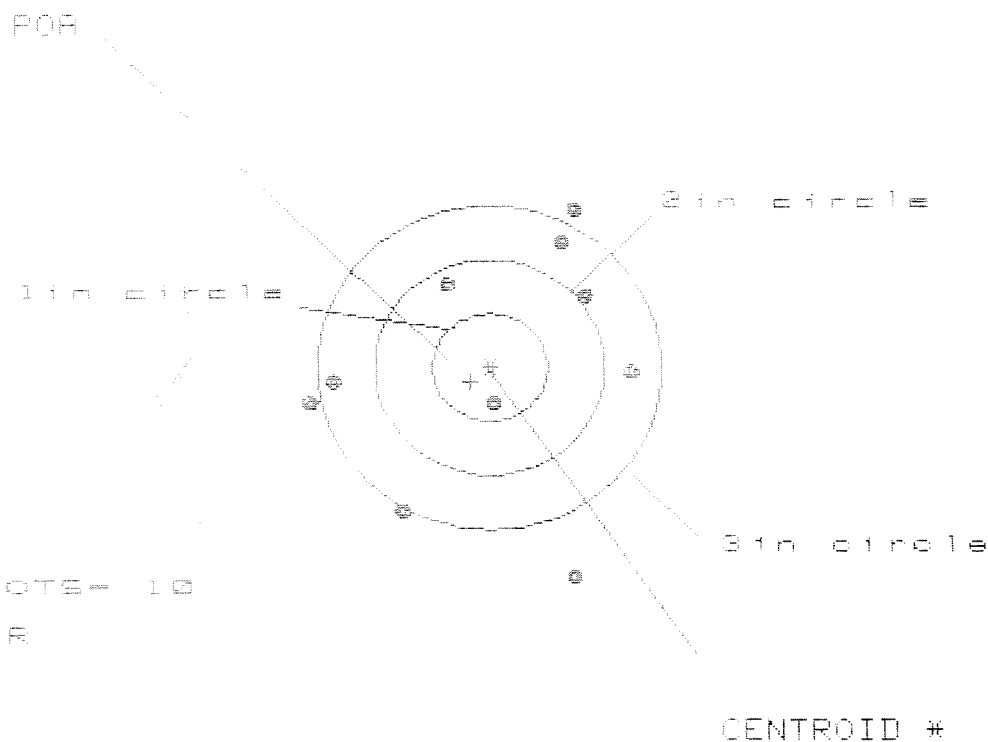
CENTROID +

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.156	1.070	1.033
MINIMUM X	-.841	-.927	-.794
MAXIMUM Y	1.119	.434	.407
MINIMUM Y	-.513	-.389	-.416
CENTROID X	.414	.500	.367
CENTROID Y	.421	.297	.324
POA TO CENTROID in.	.590	.582	.490
MIN RADIUS	.239	.089	.200
MEAN RADIUS	.778	.696	.644
MAX RADIUS	1.363	1.093	1.114
HORIZONTAL SPREAD	1.997	1.997	1.827
VERTICAL SPREAD	1.632	.823	.823
EXTREME SPREAD	2.427	2.001	1.849
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		10	

18 Mar 1968

FILE:/PATTERNING/CENTERFIRE_PATT/06348944

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 1

2in = 2

3in = 6

HS= 3.837

VS= 3.401

GS= 3.402

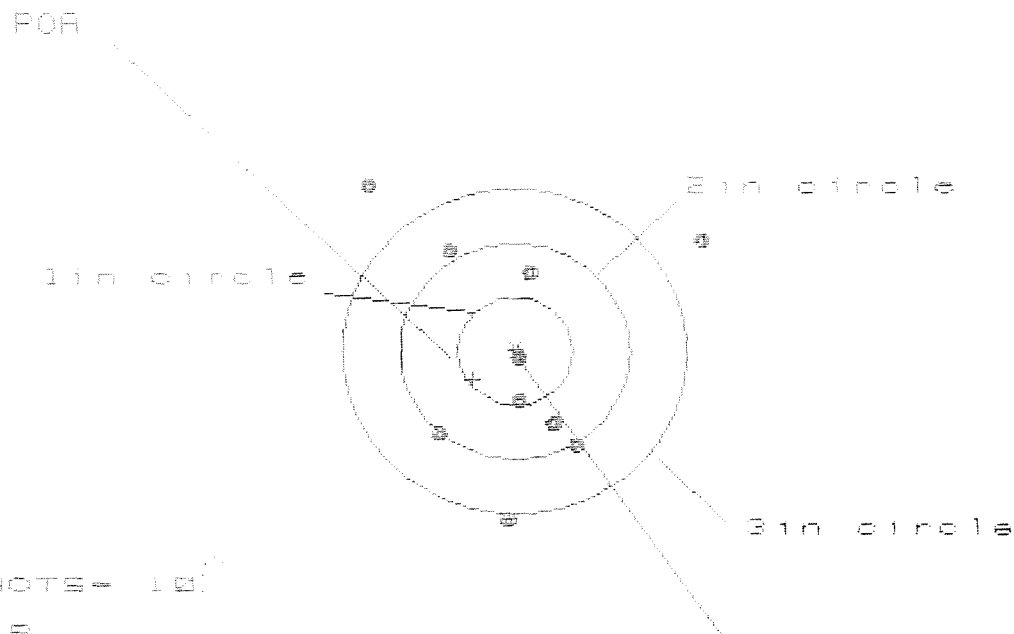
PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.235	1.319	1.130
MINIMUM X	:	-1.602	-1.518	-1.503
MAXIMUM Y	:	1.488	1.276	1.204
MINIMUM Y	:	-1.913	-1.576	-1.648
CENTROID X	:	.169	.085	.274
CENTROID Y	:	.133	.345	.417
POA TO CENTROID in.	:	.215	.356	.499
MIN RADIUS	:	.368	.593	.650
MEAN RADIUS	:	1.325	1.228	1.150
MAX RADIUS	:	2.059	1.730	1.878
HORIZONTAL SPREAD	:	2.837	2.837	2.633
VERTICAL SPREAD	:	3.401	2.852	2.852
EXTREME SPREAD	:	3.402	3.215	3.215
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	2		
NUMBER IN THREE INCH CIRCLE	=	6		

18 Mar 1988

FILE:/PATTERNING/CENTERFIRE_PATT/08348844

CENTERFIRE PATTERNS

3



OF SHOTS = 18

IN CIR

1in = 1

2in = 5

3in = 7

HS = 2.879

VS = 3.108

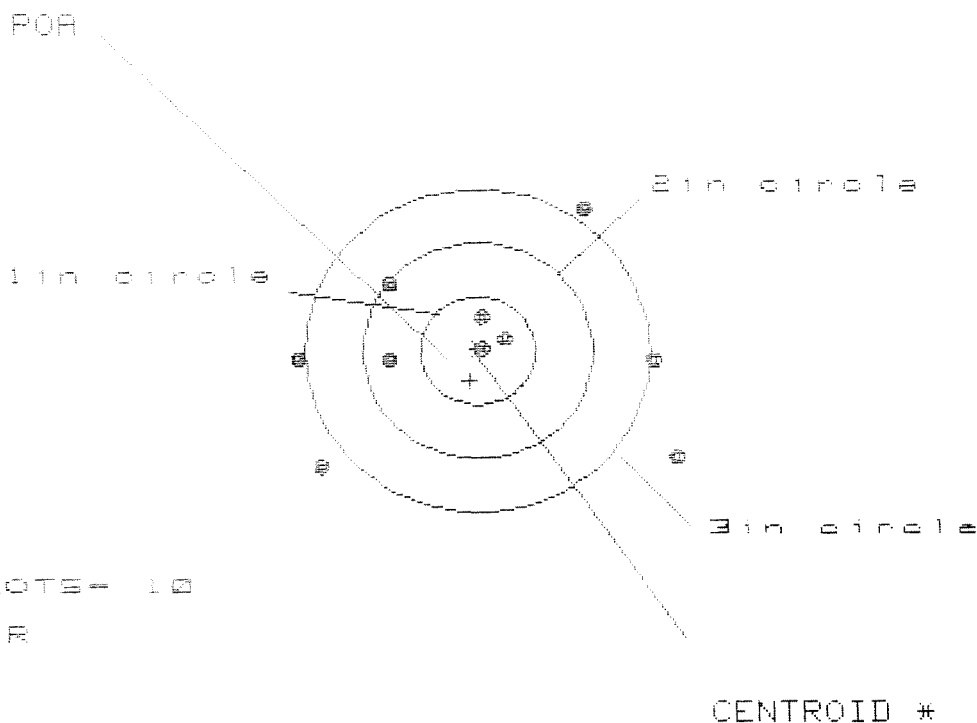
GS = 3.345

CENTROID #

PATTERN #	3	3	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.589	1.446	.545
MINIMUM X	-1.290	-.851	-.671
MAXIMUM Y	1.578	1.180	1.266
MINIMUM Y	-1.530	-1.355	-1.207
CENTROID X	.368	.511	.331
CENTROID Y	.265	.090	-.058
POA TO CENTROID in.	.454	.519	.336
MIN RADIUS	.095	.144	.193
MEAN RADIUS	1.063	.917	.767
MAX RADIUS	2.038	1.866	1.374
HORIZONTAL SPREAD	2.879	2.297	1.216
VERTICAL SPREAD	3.108	2.535	2.473
EXTREME SPREAD	3.345	3.020	2.527
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	7		

CENTERFIRE PATTERNS

4



OF SHOTS= 10

IN CIR

1 in = 3

2 in = 4

3 in = 6

HE= 2.228

VE= 2.463

GE= 3.438

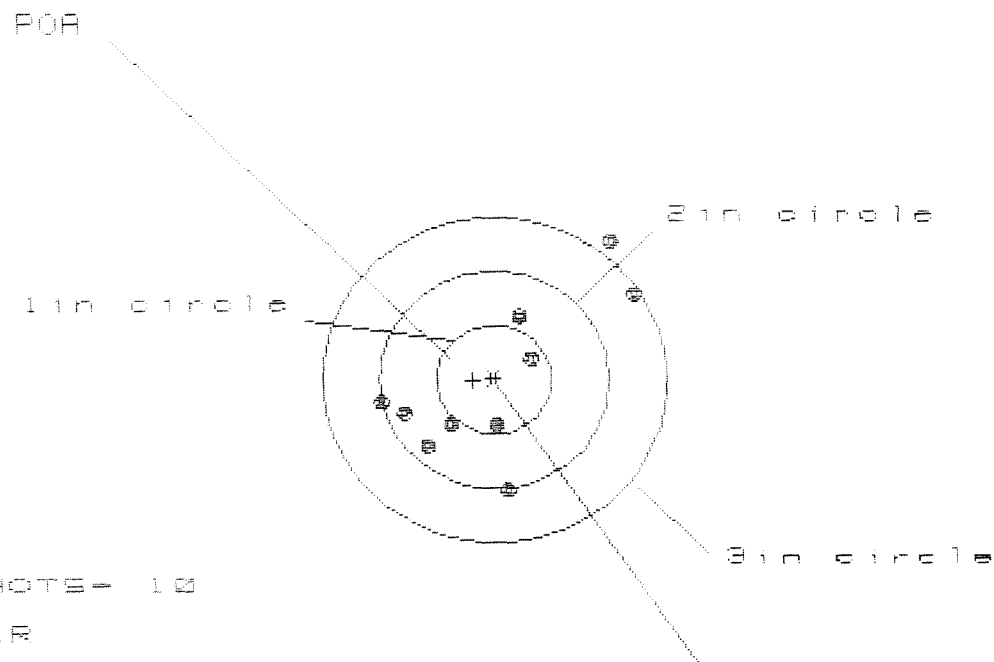
PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.735	1.690	1.547
MINIMUM X	-1.593	-1.400	-1.543
MAXIMUM Y	1.338	1.228	1.074
MINIMUM Y	-1.125	-1.235	-.389
CENTROID X	.067	-.126	.017
CENTROID Y	.280	.390	.544
POA TO CENTROID in.	.288	.409	.544
MIN RADIUS	.036	.253	.078
MEAN RADIUS	1.087	.984	.868
MAX RADIUS	1.997	1.698	1.591
HORIZONTAL SPREAD	3.328	3.090	3.090
VERTICAL SPREAD	2.463	2.463	1.463
EXTREME SPREAD	3.439	3.335	3.091
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	6		

18 Mar 1968

FILE: \PATTERNING\CENTERFIRE_PATT\08348944

CENTERFIRE PATTERNS

5



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 7

3 in = 9

HS= 2.206

VS= 2.292

GS= 2.535

CENTROID #

PATTERN #	5	5	5
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.185	1.296	.623
MINIMUM X	-1.021	-.910	-.748
MAXIMUM Y	1.320	.975	.850
MINIMUM Y	-.972	-.826	-.704
CENTROID X	.184	.073	-.089
CENTROID Y	.011	-.135	-.257
POA TO CENTROID in.	.184	.154	.272
MIN RADIUS	.406	.300	.216
MEAN RADIUS	.888	.761	.601
MAX RADIUS	1.655	1.622	.989
HORIZONTAL SPREAD	2.206	2.206	1.371
VERTICAL SPREAD	2.292	1.801	1.554
EXTREME SPREAD	2.535	2.440	1.563
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	9		