

C6225559

MODEL 700TM M24

Model 700 M24TM

Action _____

Barrel Length _____

Capacity _____

Order No. 5716

*Includes 1 in chamber.

Remington

Army Services Repair & Estimate System
BARBER - M24-0051445

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

Repair Inquiry

Repair Number: **RE00084768** Serial: C6225559 Model: M24 SWS Center Fire Caliber: 7.62 NATO Repairman: Status: Closed 9/10/2004 7:38:14 AM

Verify Repair

Address Information

Customer: ☒ Received From Return To: ☐ Received From

Name: **TRANSPORTATION OFFICER** **TRANSPORTATION OFFICER**

Address 1: **FRANCES WEATHINGTON** **FRANCES WEATHINGTON**

Address 2: **DEF DIST DEPOT** **DEF DIST DEPOT** PO Box: **PO Box**

City: **ANNISTON** **ANNISTON**

State: **AL** Zip Code: **36201** Country: **US** State: **AL** Zip Code: **36201** Country: **US**

FFL ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐

Contact / Condition Problems Estimate History / Status Shipping / Billing

Contact Information

Phone:

Fax:

Email:

Comments:

Received Condition

Fair

Condition Notes:

CSR Notes:

Accessories Received

Code	Desc	Qty
A007	With Studs	3
A010	Hard Case	1
A017	Scope Bases	3
A026	Scope	1
A055	Deployment Kit	1

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

modetj 9/10/2004 8:06 AM CAPS NUM INS SCRL

start 3 4 2

Serial Number: **C6225559**

Model: **M24 SWS**

RE00084768

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6225559.___0
FILE DATE AND TIME: 10/06/2004 11:06

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

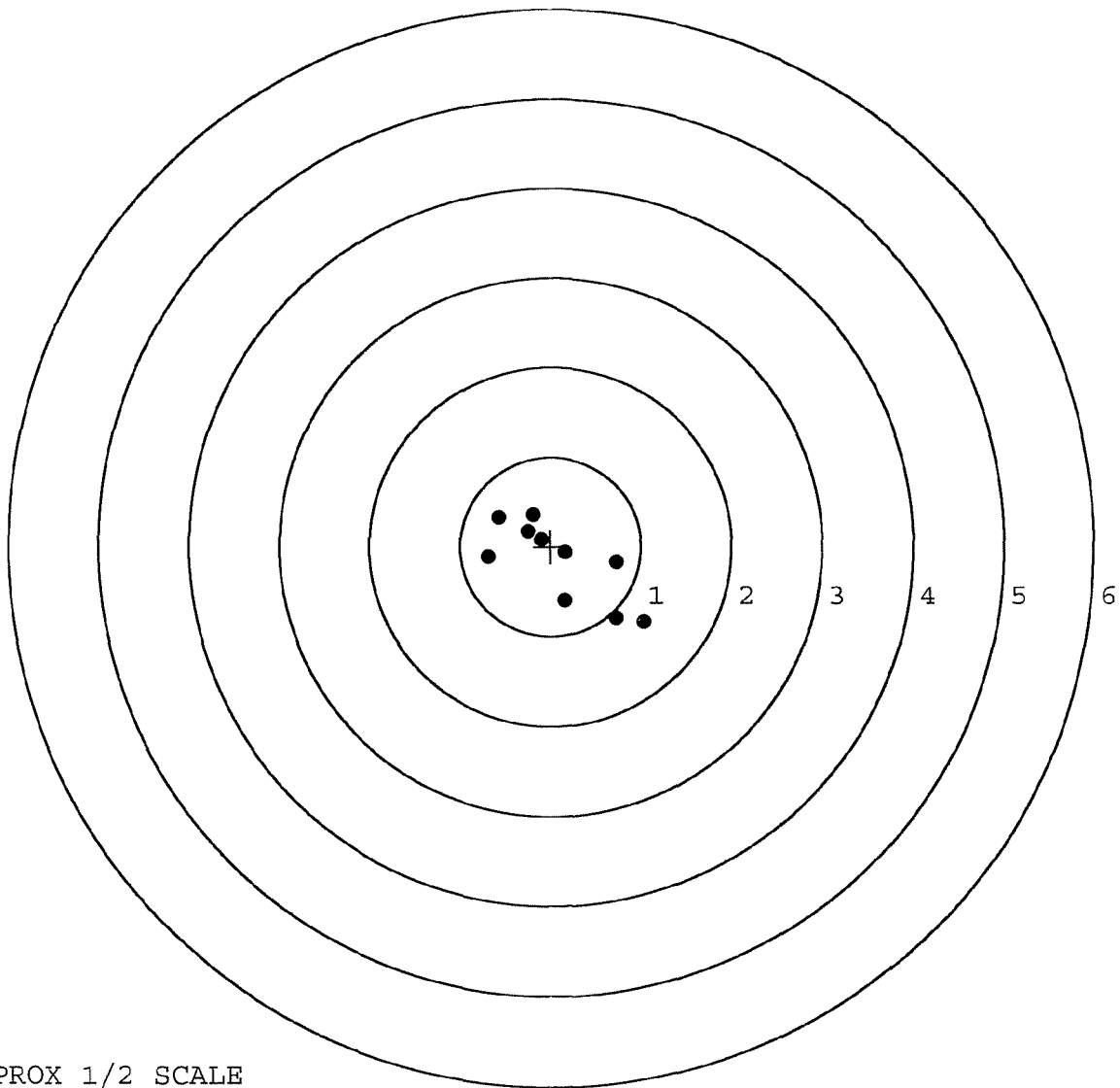
The Average X Centroid of the Five Target Set:	0.046
The Average Y Centroid of the Five Target Set:	-0.081
The Average Point of Impact of the Five Target Set:	0.093
The Average Mean Radius of the Five Target Set:	0.576
The Distance from POA to Centroid Target #1:	0.195
The Distance from Centroid Target #2 to Centroid Target #1:	0.193
The Distance from Centroid Target #3 to Centroid Target #1:	0.208
The Distance from Centroid Target #4 to Centroid Target #1:	0.089
The Distance from Centroid Target #5 to Centroid Target #1:	0.107

BARBER - M24 0051447

SERIAL NUMBER: C6225559. __ 0
 TARGET NUMBER: 1
 FILE DATE: 10/06/2004
 FILE TIME: 11:06

POINT#	X	Y
1:	1.031	-0.848
2:	0.724	-0.803
3:	0.729	-0.178
4:	0.154	-0.607
5:	0.164	-0.068
6:	-0.103	0.080
7:	-0.194	0.359
8:	-0.578	0.327
9:	-0.692	-0.119
10:	-0.257	0.169

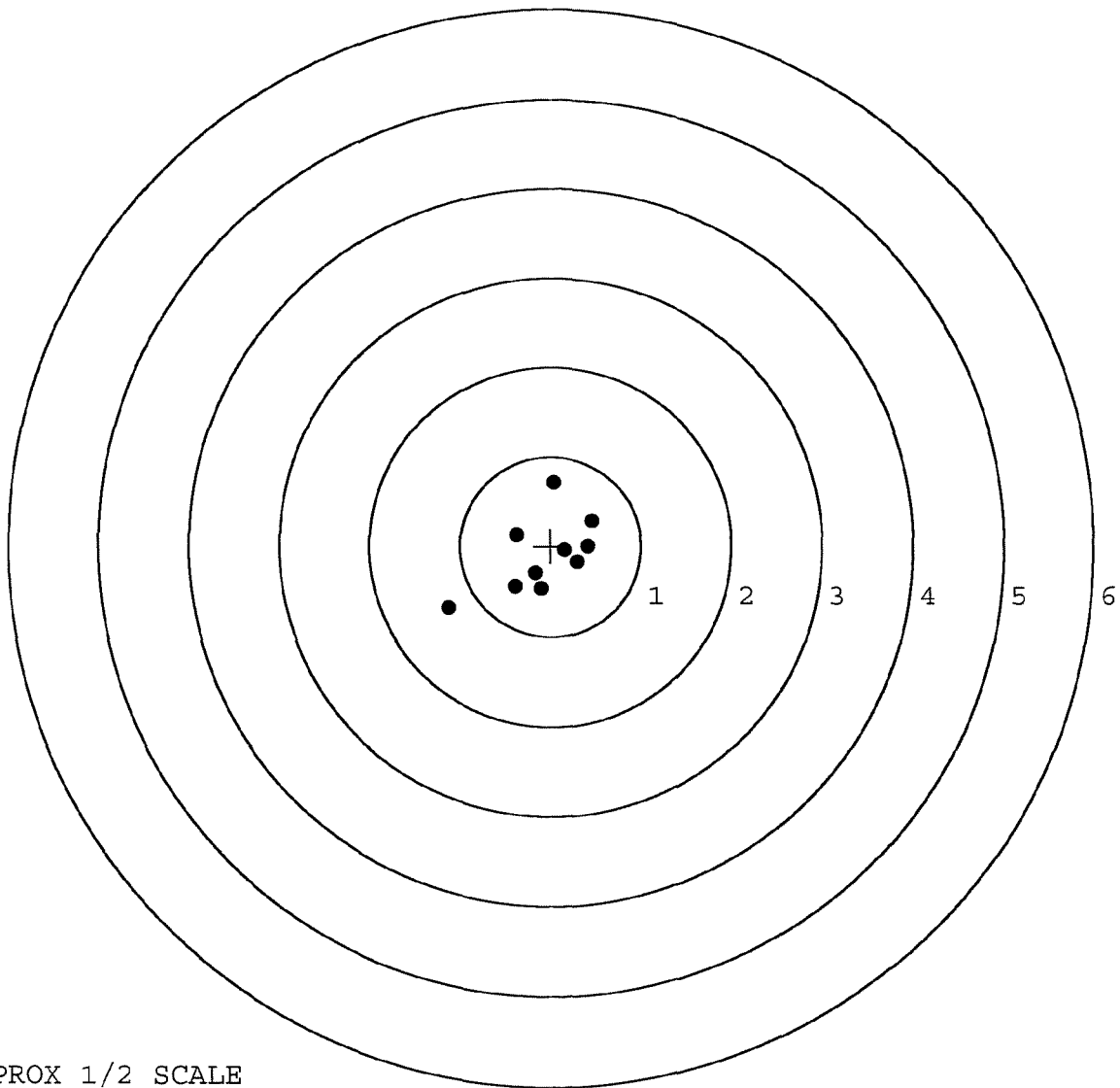
X CENTROID: 0.098
 Y CENTROID: -0.169
 POA TO CENTROID: 0.195
 HORZ SPREAD: 1.723
 VERT SPREAD: 1.207
 GROUP SPREAD: 1.992
 MIN RADIUS: 0.121
 MAX RADIUS: 1.154
 MEAN RADIUS: 0.628
 # IN 1 IN DIAMETER: 4
 # IN 2 IN DIAMETER: 9
 # in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

BARBER - M24 0051448

SERIAL NUMBER: C6225559. __0	POINT#	X	Y
TARGET NUMBER: 2	1:	-1.131	-0.688
FILE DATE: 10/06/2004	2:	-0.384	0.125
FILE TIME: 11:06	3:	0.034	0.712
	4:	0.454	0.286
X CENTROID: -0.083	5:	0.156	-0.053
Y CENTROID: -0.102	6:	0.294	-0.177
POA TO CENTROID: 0.132	7:	0.419	-0.003
HORZ SPREAD: 1.585	8:	-0.167	-0.301
VERT SPREAD: 1.400	9:	-0.399	-0.451
GROUP SPREAD: 1.860	10:	-0.111	-0.475
MIN RADIUS: 0.215			
MAX RADIUS: 1.200			
MEAN RADIUS: 0.526			
# IN 1 IN DIAMETER: 6			
# IN 2 IN DIAMETER: 9			
# in 3 IN DIAMETER: 10			



TARGET APPROX 1/2 SCALE

BARBER - M24 0051449

SERIAL NUMBER: C6225559. __0

TARGET NUMBER: 3

FILE DATE: 10/06/2004

FILE TIME: 11:06

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

1:	1.534	0.206
----	-------	-------

2:	0.568	0.073
----	-------	-------

3:	0.115	0.267
----	-------	-------

4:	-0.160	-0.344
----	--------	--------

5:	-0.717	-0.045
----	--------	--------

6:	-0.326	0.185
----	--------	-------

7:	-0.015	0.081
----	--------	-------

8:	-0.191	-0.073
----	--------	--------

9:	-0.550	-0.016
----	--------	--------

10:	-0.273	-0.193
-----	--------	--------

X CENTROID: -0.002

Y CENTROID: 0.014

POA TO CENTROID: 0.014

HORZ SPREAD: 2.251

VERT SPREAD: 0.611

GROUP SPREAD: 2.265

MIN RADIUS: 0.068

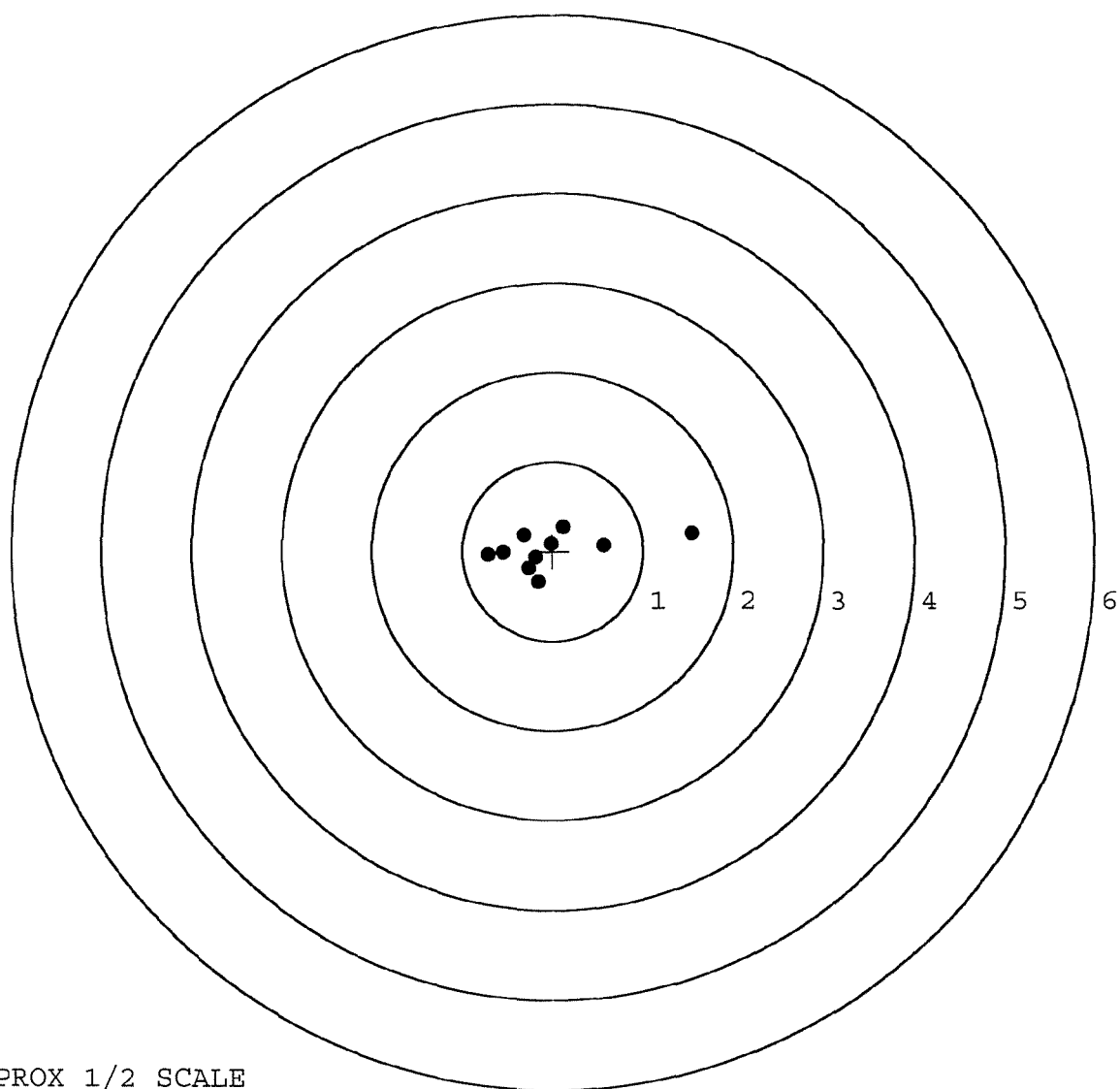
MAX RADIUS: 1.547

MEAN RADIUS: 0.504

IN 1 IN DIAMETER: 6

IN 2 IN DIAMETER: 9

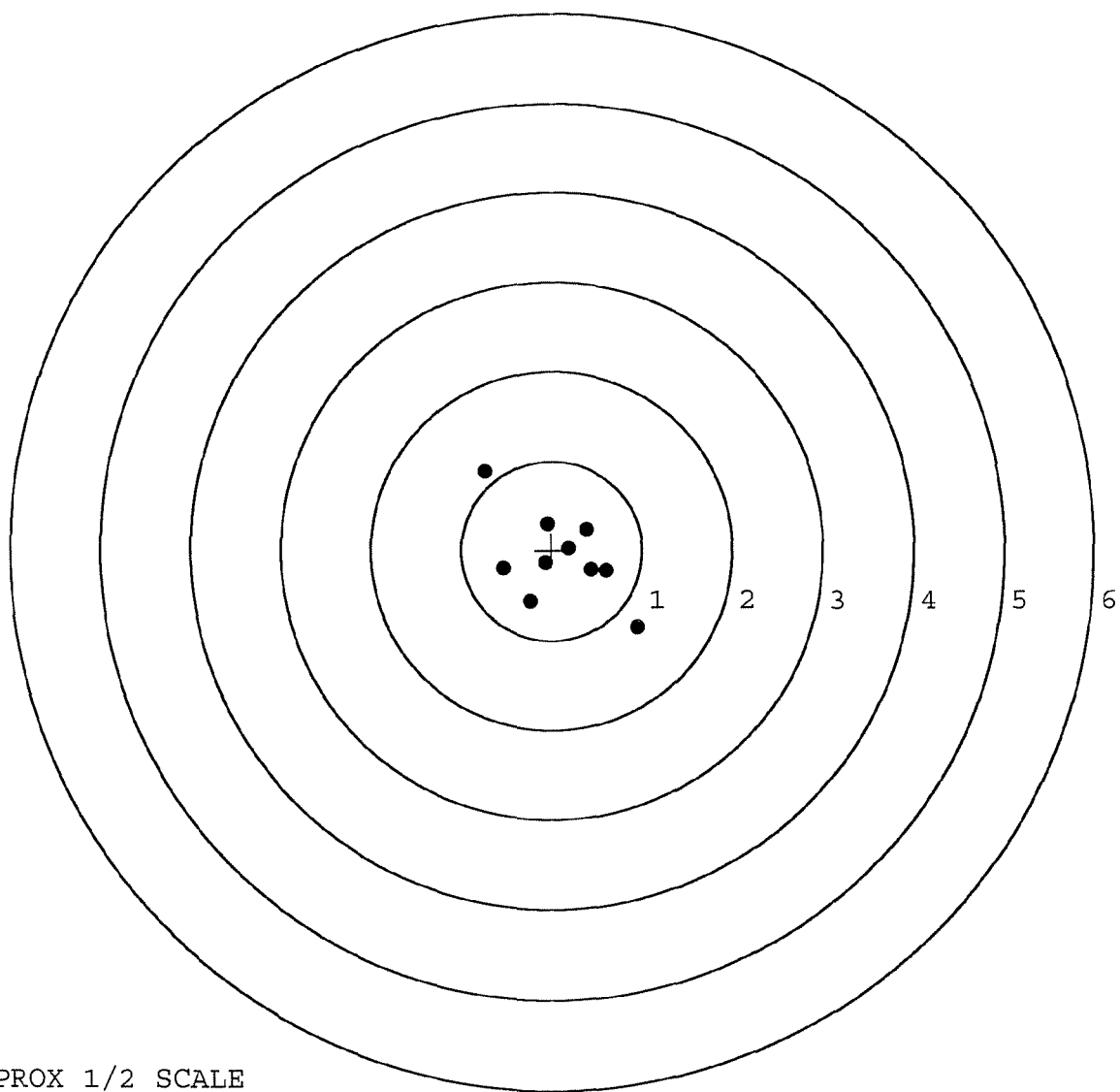
in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

BARBER - M24 0051450

SERIAL NUMBER: C6225559.____0	POINT#	X	Y
TARGET NUMBER: 4	1:	0.948	-0.857
FILE DATE: 10/06/2004	2:	-0.240	-0.570
FILE TIME: 11:06	3:	-0.538	-0.211
	4:	0.602	-0.228
X CENTROID: 0.093	5:	0.434	-0.219
Y CENTROID: -0.080	6:	-0.735	0.882
POA TO CENTROID: 0.123	7:	0.383	0.228
HORZ SPREAD: 1.683	8:	-0.067	-0.145
VERT SPREAD: 1.739	9:	0.189	0.023
GROUP SPREAD: 2.420	10:	-0.047	0.295
MIN RADIUS: 0.141			
MAX RADIUS: 1.269			
MEAN RADIUS: 0.570			
# IN 1 IN DIAMETER: 5			
# IN 2 IN DIAMETER: 8			
# in 3 IN DIAMETER: 10			



TARGET APPROX 1/2 SCALE

BARBER - M24 0051451

SERIAL NUMBER: C6225559. __0

TARGET NUMBER: 5

FILE DATE: 10/06/2004

FILE TIME: 11:06

POINT#	X	Y
1:	1.110	0.077
2:	0.607	-0.758
3:	0.521	0.332
4:	0.066	1.048
5:	-0.108	-0.772
6:	-0.526	-0.253
7:	-0.832	-0.139
8:	0.300	-0.201
9:	-0.013	-0.164
10:	0.129	0.177

X CENTROID: 0.125

Y CENTROID: -0.065

POA TO CENTROID: 0.141

HORZ SPREAD: 1.942

VERT SPREAD: 1.820

GROUP SPREAD: 1.885

MIN RADIUS: 0.170

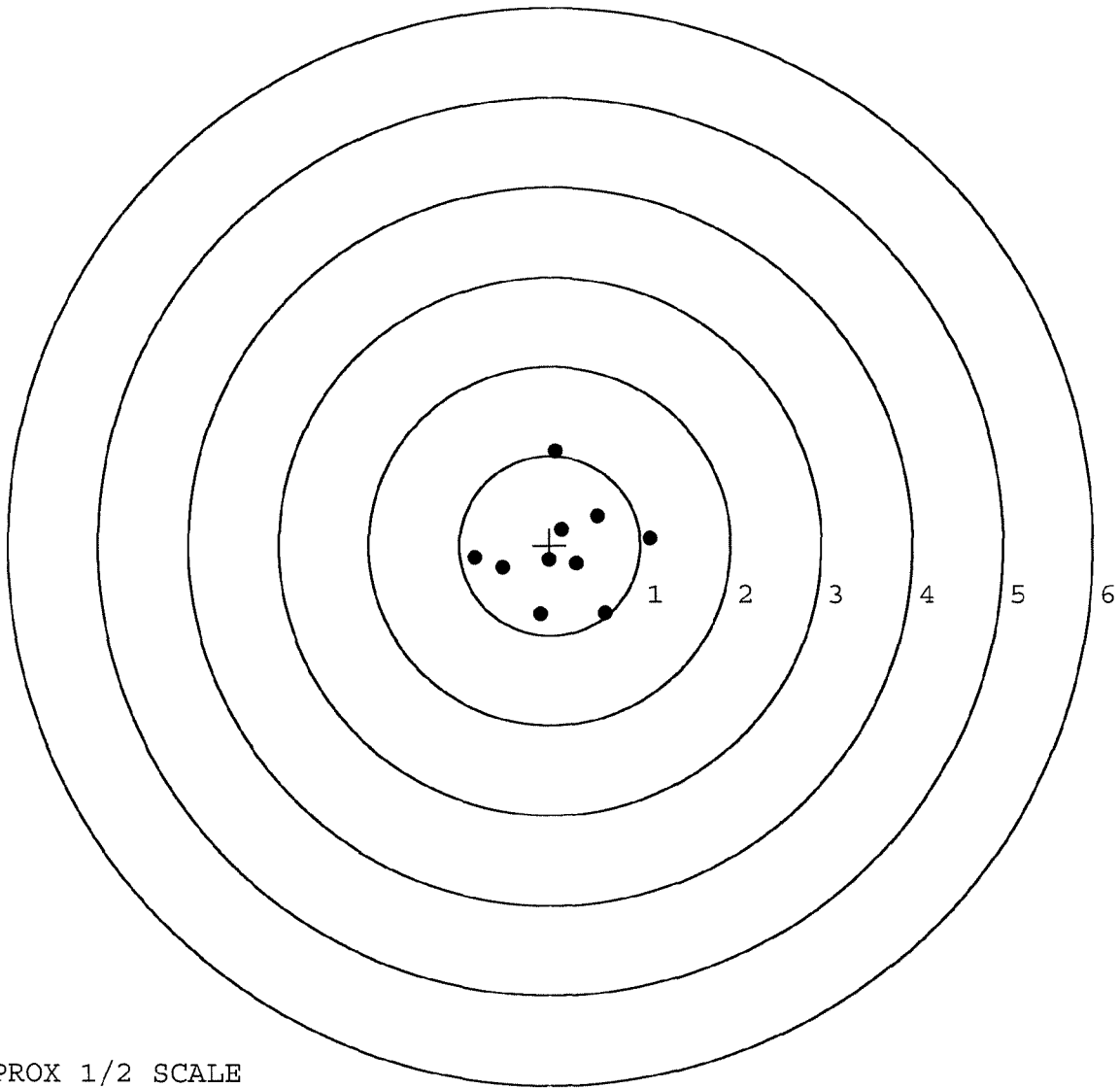
MAX RADIUS: 1.115

MEAN RADIUS: 0.653

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

BARBER - M24 0051452 CONTRACT #: DAAE-20-02-D-0127

BARBER - M24 **M2400051491**

GUN SERIAL #

C6225559

33
44 SCALE #
1193

OP. #	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and Stock	9 12	8 8	FB
500	Proof	9 19	8 8	RW
507	Check Headspace	9 19	8 8	RW
510	Dis-assemble Gun	9 19	8 8	RW
512	Magnaflux Barrel Action		9-22-88	P/C.
	Magnaflux Bolt		9-22-88	P/C.
515	Rollmark Caliber		10/12	WC
517	Drill and Tap Sight Holes		10/12	FB
518	Polish Barrel		10/30	NT
520	Apply Coatings (Barrel Action)		10-31-88	TJA
	Apply Coating (Bolt)		10-31-88	TJA
525	Final Assembly			
	A) Clean inside of Bolt Assembly		11/15/88	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		11/15/88	RW
	C) Inspect Ejector Hole for Chamfer		11/15/88	RW
	D) Oil Firing Pin Ass'y		11/15/88	RW
	E) Adjust Trigger Pull to Min Setting and Stake		11/15/88	RW

BARBER - M24 0051454							
op. #	OP. NAME	READINGS				DATE	INITIAL
625 cont.	F) Safety On Force	5	4.5	4.5		16/10/88	JS
	G) Safety Off Force	3	2.5	2.5		16/10/88	JS
	H) Trigger Pull Test & Retainability					15/10/88	JS
	I) Firing Pin Indent	.021	.021	.0205		16/10/88	JS
	J) Assemble Stock					11/17/88	RW
	K) Assemble Swivel Studs					6/Dec/88	JS
	L) Attach Front and Rear Sight Assemblies					11/30/88	WCB
	M) Iron Sight Alignment					11/30/88	WCB
	N) Detach Front & Rear Sights & place in numbered container					11/30/88	WCB
	O) Attach Scope to Rifle					11/30/88	WCB
	P) Detach & Attach Scope 20 Times					11/30/88	WCB
640	Gallery Target & Test	63 R	89 L			12/5/88	D/H
	A) Time						
	B) Malfunctions						
	C) Pierced Primers						
	D) Optical Clarity of Scope					12/5/88	D/H
645	Inspect for Live Ammo					12/5/88	D/H
655	Final Inspection						
	A) Headspace					6/Dec/88	JS
	B) Trigger Pull	2.34	2.18	2.36	2.27	2.41	5/Dec/88
	C) Function					6/Dec/88	JS
660	Pack					12/15/88	RW

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6225559

DATE 15 NOV 88

TESTER RJD

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.42	2.32	2.46	2.34	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.37	2.41	2.46	2.18	
PULL #3	2.33	2.19	2.53	2.36	
PULL #4	2.45	2.20	2.37	2.27	
PULL #5	2.34	2.21	2.56	2.47	
TOTAL	11.91	11.33	12.38	11.62	
AVG.	2.382	2.266	2.476	2.324	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.13	3.01		
PULL #2	3.12	3.14		
PULL #3	3.14	3.11		
PULL #4	3.18	3.15		
PULL #5	3.21	3.11		
TOTAL	15.78	15.52		
AVG.	3.156	3.104		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.25	4.14		4.05
PULL #2	4.26	4.14		4.18
PULL #3	4.26	4.17		4.15
PULL #4	4.22	4.17		4.07
PULL #5	4.24	4.16		4.05
TOTAL	21.23	20.78		20.50
AVG.	4.246	4.156		4.10

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C665559

CENTROIDAL DISTANCES

0 TO	1	.76742
1 TO	2	.425011
1 TO	3	.936481
1 TO	4	.508398
1 TO	5	.583953

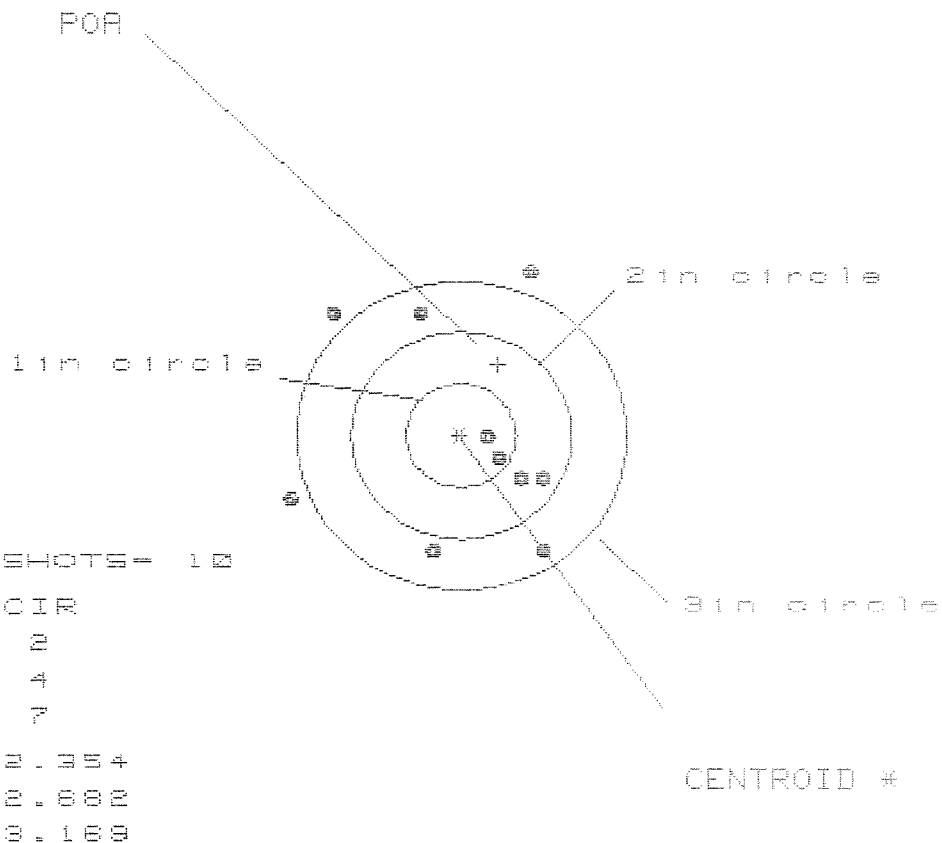
3
4
1
2
5
←----FOR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1083
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.3478
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .36442
THE AMR FOR THIS RIFLE IS: .9806

6 Dec 1988

FILE:/PATTERNING/CENTERFIRE_PATT/08225559

CENTERFIRE PATTERNS # 1



PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.775	.852	.664
MINIMUM X	:	-1.579	-1.502	-1.235
MAXIMUM Y	:	1.575	1.404	1.346
MINIMUM Y	:	-1.107	-.932	-.990
CENTROID X	:	-.342	-.419	-.231
CENTROID Y	:	-.687	-.862	-.804
POA TO CENTROID in.	:	.767	.958	.837
MIN RADIUS	:	.237	.348	.157
MEAN RADIUS	:	1.094	1.016	.880
MAX RADIUS	:	1.719	1.751	1.827
HORIZONTAL SPREAD	:	2.354	2.354	1.899
VERTICAL SPREAD	:	2.682	2.336	2.336
EXTREME SPREAD	:	3.169	3.007	3.007
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	4		
NUMBER IN THREE INCH CIRCLE	=	7		

8 Dec 1966

FILE:/PATTERNING/CENTERFIRE_PATT/C8225553

CENTERFIRE PATTERNS # 2

POR

1 in circle

2 in circle

3 in circle

OF SHOTS = 10

IN CIR

1 in = 2

2 in = 7

3 in = 8

HS = 2.809

VS = 2.724

GS = 3.135

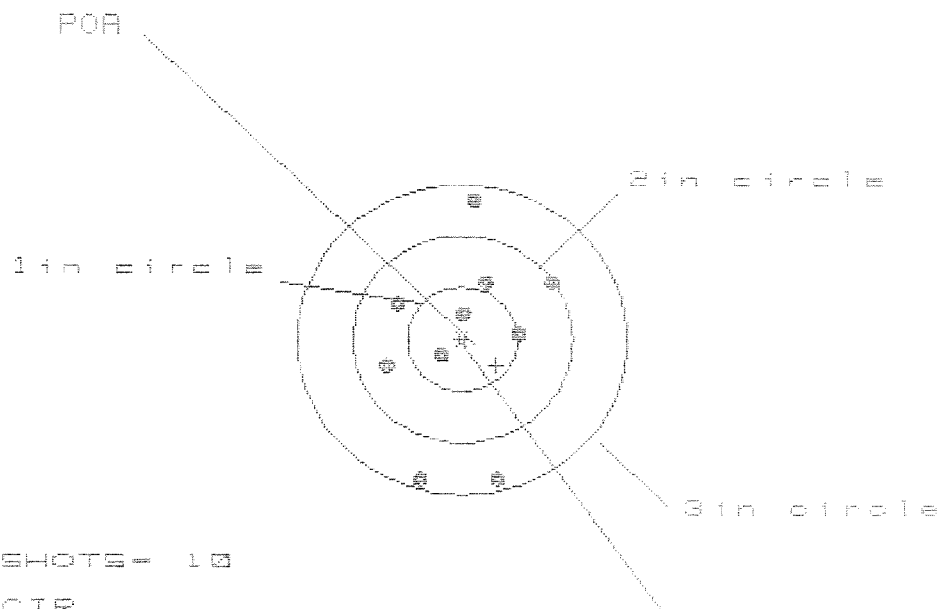
CENTROID *

PATTERN #	:	2	3	4
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.842	.624	.666
MINIMUM X	:	-1.967	-.946	-.904
MAXIMUM Y	:	1.398	1.486	.578
MINIMUM Y	:	-1.326	-1.238	-1.052
CENTROID X	:	.083	.301	.259
CENTROID Y	:	-.690	-.778	-.964
POR TO CENTROID in.	:	.695	.834	.998
MIN RADIUS	:	.186	.340	.388
MEAN RADIUS	:	.941	.785	.677
MAX RADIUS	:	2.121	1.525	1.071
HORIZONTAL SPREAD	:	2.809	1.570	1.570
VERTICAL SPREAD	:	2.724	2.724	1.630
EXTREME SPREAD	:	3.135	2.733	1.946
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	7		
NUMBER IN THREE INCH CIRCLE	=	8		

6 Dec 1988

FILE:/PATTERNING/CENTERFIRE_PATT/CAP25558

CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1 in = 2

2 in = 7

3 in = 10

HS = 1.521

VS = 2.709

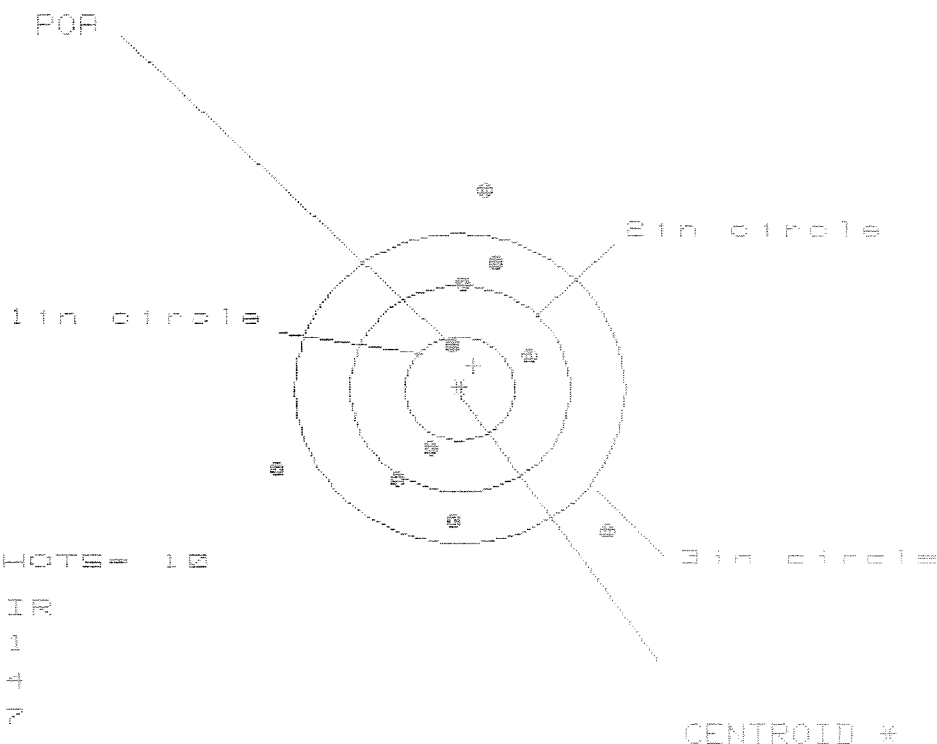
GS = 2.749

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.811	.765	.803
MINIMUM X	-.710	-.756	-.718
MAXIMUM Y	1.347	1.196	1.007
MINIMUM Y	-1.362	-1.513	-1.590
CENTROID X	-.312	-.266	-.304
CENTROID Y	.249	.400	.589
POA TO CENTROID in.	.399	.480	.663
MIN RADIUS	.269	.117	.077
MEAN RADIUS	.824	.728	.605
MAX RADIUS	1.419	1.542	1.009
HORIZONTAL SPREAD	1.521	1.521	1.521
VERTICAL SPREAD	2.709	2.709	1.597
EXTREME SPREAD	2.749	2.723	1.779
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	10		

6 Dec 1988

FILE:/PATTERNING/CENTERFIRE_PATT/08225558

CENTERFIRE PATTERNS # 4



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 4

3 in = 7

HS = 3.071

VS = 3.342

GS = 3.529

PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.373	.821	.870
MINIMUM X	-1.698	-1.546	-1.497
MAXIMUM Y	1.927	1.769	1.294
MINIMUM Y	-1.415	-1.478	-1.256
CENTROID X	-.132	-.284	-.333
CENTROID Y	-.224	-.066	-.288
POA TO CENTROID in.	.260	.292	.440
MIN RADIUS	.445	.290	.474
MEAN RADIUS	1.217	1.117	1.027
MAX RADIUS	1.972	1.813	1.661
HORIZONTAL SPREAD	3.071	2.367	2.367
VERTICAL SPREAD	3.342	3.247	2.551
EXTREME SPREAD	3.529	3.332	2.875
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	7		

6 Dec 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C8225559

CENTERFIRE PATTERNS # 5

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS = 10

IN CIR

1 in = 2

2 in = 9

3 in = 9

HE = 1.625

VS = 2.544

GS = 2.551

PATTERN #	5	5	5
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.864	.838	.921
MINIMUM X	-.762	-.788	-.795
MAXIMUM Y	1.737	.842	.789
MINIMUM Y	-.787	-.592	-.645
CENTROID X	.159	.184	.101
CENTROID Y	-.387	-.582	-.529
POA TO CENTROID in.	.418	.611	.539
MIN RADIUS	.285	.280	.332
MEAN RADIUS	.827	.694	.685
MAX RADIUS	1.772	1.008	.982
HORIZONTAL SPREAD	1.626	1.626	1.626
VERTICAL SPREAD	2.544	1.434	1.434
EXTREME SPREAD	2.551	1.755	1.753
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		9	
NUMBER IN THREE INCH CIRCLE =		9	

RECEIVED BARBER M24 1005 14620RT

COMMENTS

ORDER
R 94-14106

INITIAL CUSTOMER ORDER NO.

FPS

M24 W/ULTRA 10XM3A SCOPE

DATE RECEIVED

DATE OPENED

DATE CODE

SERIAL NUMBER

NEW SERIAL NUMBER

MODEL AND GRADE

04/22/94

04/25/94

DI 9-88

C6225559

700 7.62

NATO

ACCESSORIES

SLING STRAP

W/STUDS

W/SWIVELS

SCOPE MNTS

SCOPE BASE

FROM:

SHIP TO:

CDR, US ARMY ARMAMENT,
MUNITION & CHEMICAL CMD
ATTN: AMSMC-PCS-NB
ROCK ISLAND

IL 61299

CDR, US ARMY ARMAMENT,
MUNITION & CHEMICAL CMD
ATTN: AMSMC-PCS-NB
ROCK ISLAND

IL

61299

CUST NO: 096460 CLO.D

ACCOUNT NUMBER

ACCOUNT NUMBER N/C

WRITE ☐

PROM. DATE

ESTIMATED

VIA

R724976541

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

Front Sight Base Body Bolt Release Broken,
Butt plate loose, New Barrel

PARTS

COMMENTS

Barrel - 96003
Front Sight mounting Base - 18844

Re Zinc - Scope Base, Scope
Rings, Swivels & Swivel Studs.
Re Powder Coat - Floor plate,
Latch, Trigger Guard & Rear
Sight Base.
Repair Butt plate.

REPAIRMAN

PROOF

CLEAN

TEST

TARGET

PATTERN

GALLERY TESTER

DATE

DATE

DATE

DATE

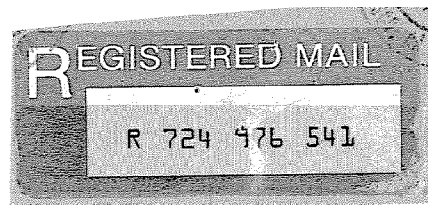
DATE

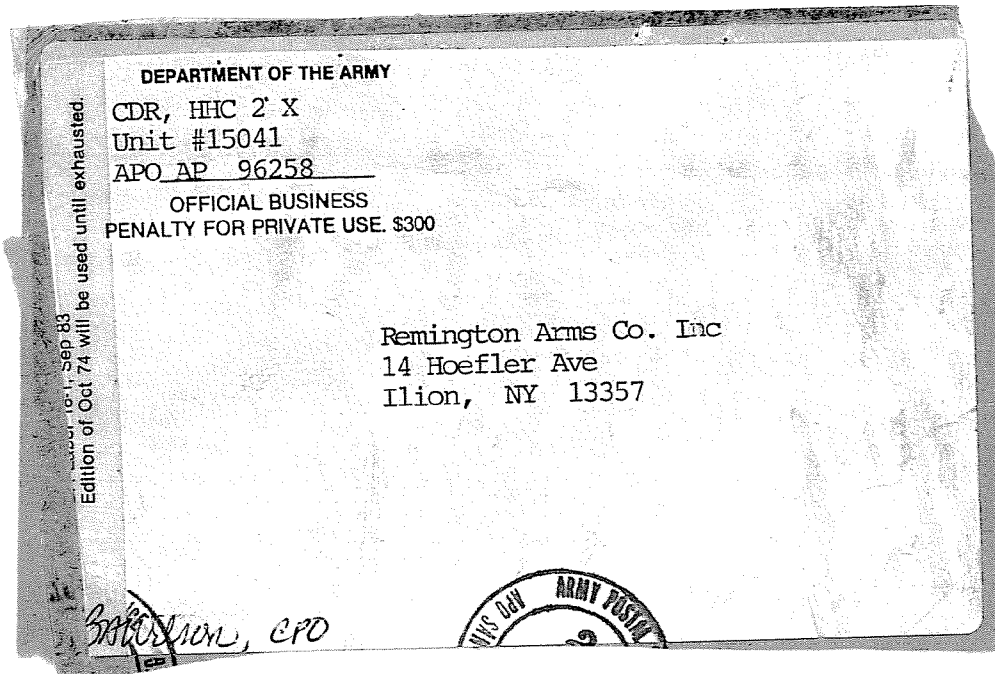
OFFICE COPY

RD6925 REV. 1/94

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

BARBER - M24 005140051501





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DA FORM 2785-1, APR 76

DOC IDENT		ROUT IDENT		FSC		NIN		ADD		QUANTITY		REQ REQUISITIONER		DATE		SERIAL		SUPPLEMENTARY ADDRESS		FUND		DISTRIBUTION		PROJECT		PRIORITY		REQ DEL DATE		ADV STAT																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																	
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BARBER - M24 0051467

94- 5- 4 : 11:49 :

HQ 210 G3 TNG / FI :# 4

EQUIPMENT INSPECTION AND MAINTENANCE WORKSHEET							
For use of this form, see DA PAM 750-709 and 750-761; the proponent agency is DCSLOG.							
1. ORGANIZATION 2X HMC 210				2. NOMENCLATURE AND MODEL M24 Sniper Rifle			
3. REGISTRATION/SERIAL/NSN C6225559	4. MILES	5. HOUR	6. ROUNDS FIRED Feds	7. NOT STARTS	8. DATE 13 Dec 93	9. TYPE INSPECTION TI	
APPLICABLE REFERENCE							
TM NUMBER		TM DATE		TM NUMBER		TM DATE	
COLUMN a - Enter TM Item number.				COLUMN d - Show corrective action for deficiency or shortcoming listed in Column c.			
COLUMN b - Enter the applicable condition status symbol.				COLUMN e - Individual ascertainably completed corrective action initial in this column.			
COLUMN c - Enter deficiencies and shortcomings.							
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.							
10. SIGNATURE (Person performing inspection) Sp. TIME				11. SIGNATURE (Maintenance Supervisor)		12. TIME	
13. MANHOURS REQUIRED							
TM ITEM NO.	STATUS	DEFICIENCIES AND SHORTCOMINGS		CORRECTIVE ACTION		INITIAL WHEN CORRECTED	
	/	Front Sight Post [®]					
		Base broken					
	/	Bolt release will not allow bolt to come out of weapon		This equipment is classified Code (E) (AW 725 50)			
	X	Butt plate base, weapon has had over 1500 rounds fired through it and should have been replaced at 1000.					

24 3

COPY 2

Final Inspection

In: C6225559

DATE REC'D: 4/22/94

DATE RET'D: ~~4/22/94~~

EDITOR: PW

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: _____

CONTRACT # DAAA21-87-C-0086

New Barrel

GUN SERIAL # C6225559

OP. #	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and Stock		4/27/94	RW
600	Proof		4/27/94	RW
607	Check Headspace		4/27/94	RW
610	Dis-assemble Gun		4/27/94	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		5/24/94	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/24/94	RW
	C) Inspect Ejector Hole for Chamfer		5/24/94	RW
	D) Oil Firing Pin Ass'y		5/24/94	RW
	E) Adjust Trigger Pull to Min Setting and Stake		5/24/94	RW

op. #	BARBER - M24 0051472 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						5/24/94	RW
	A) Time							
	B) Malfunctions							
	C) Pierced Primers							
	D) Optical Clarity of Scope							
645	Inspect for Live Ammo						5/24/94	RW
655	Final Inspection							
	A) Headspace						5/24/94	RW
	B) Trigger Pull	2.29	2.23	2.25	2.23	2.31	5/24/94	RW
	C) Function						5/24/94	RW
660	Pack							

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6225559
14 Jun 1994

CENTROIDAL DISTANCES

Ø TO	1	.403134
1 TO	2	.475067
1 TO	3	.480935
1 TO	4	.744829
1 TO	5	.189874

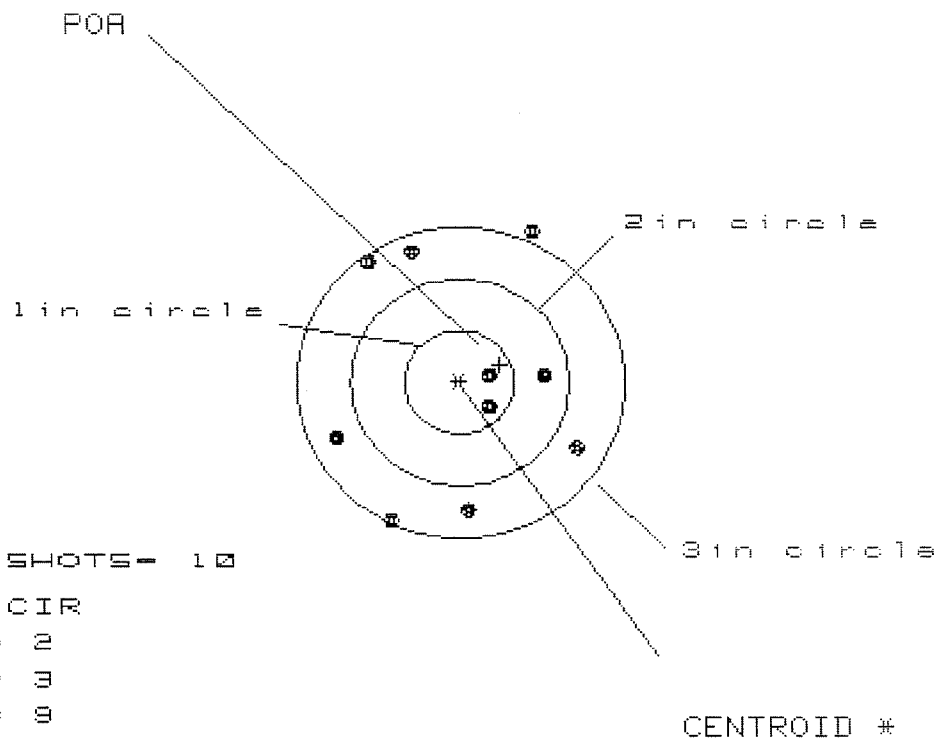
$\frac{2}{5} + 4$ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.11
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0904
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .14238
THE AMR FOR THIS RIFLE IS: 1.009

14 Jun 1994

FILE:/PATTERNING/CENTERFIRE_PATT/C8225559

CENTERFIRE PATTERNS # 1



OF SHOTS - 10

IN CIR

1 in - 2

2 in - 3

3 in - 9

HS - 2.191

VS - 2.754

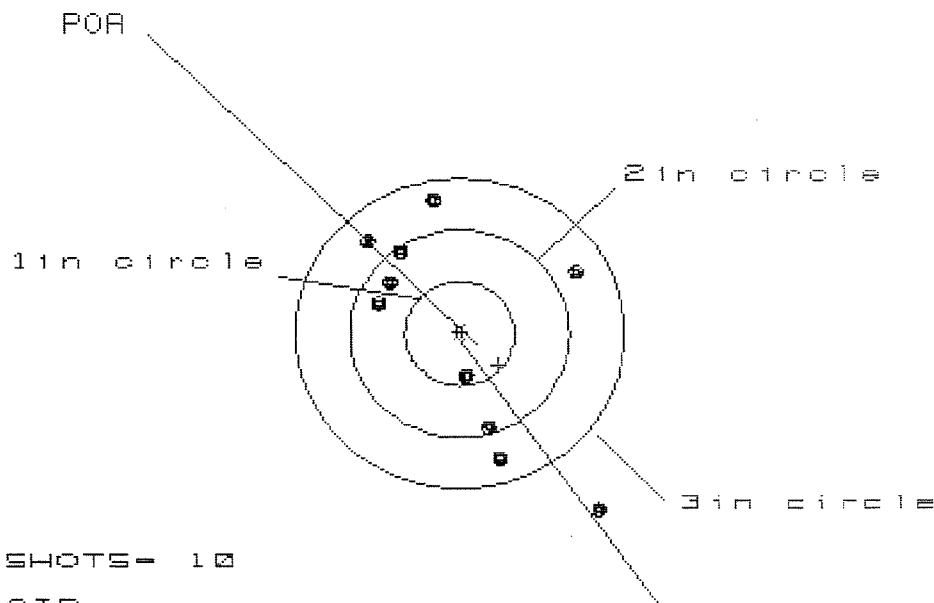
GS - 3.019

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.062	1.131	1.063
MINIMUM X	-1.129	-1.060	-1.129
MAXIMUM Y	1.426	1.384	1.237
MINIMUM Y	-1.328	-1.169	-1.239
CENTROID X	-.366	-.435	-.366
CENTROID Y	-.169	-.328	-.181
POA TO CENTROID in.	.403	.545	.409
MIN RADIUS	.252	.302	.257
MEAN RADIUS	1.073	1.021	.963
MAX RADIUS	1.555	1.486	1.400
HORIZONTAL SPREAD	2.191	2.191	2.191
VERTICAL SPREAD	2.754	2.553	2.476
EXTREME SPREAD	3.019	2.560	2.552
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	3		
NUMBER IN THREE INCH CIRCLE =	9		

14 Jun 1994

FILE:/PATTERNING/CENTERFIRE_PATT/C6225553

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 5

3 in = 9

HS= 2.111

VS= 3.013

GS= 3.369

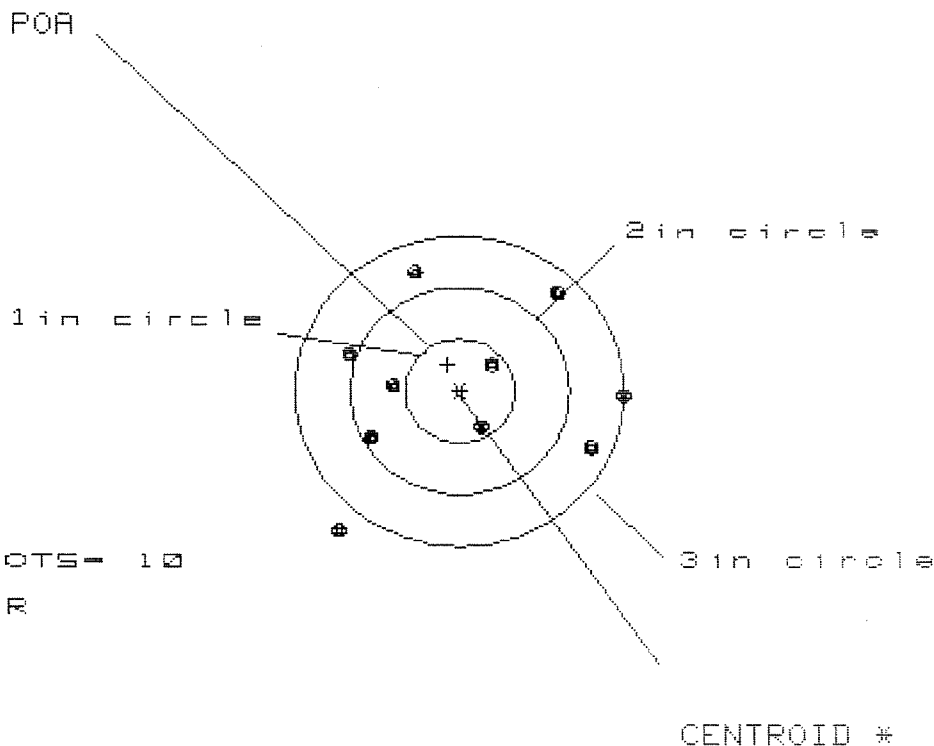
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.244	1.218	1.202
MINIMUM X	:	-.867	-.729	-.745
MAXIMUM Y	:	1.272	1.079	.824
MINIMUM Y	:	-1.741	-1.390	-1.255
CENTROID X	:	-.358	-.496	-.480
CENTROID Y	:	.306	.499	.364
POA TO CENTROID in.	:	.471	.704	.603
MIN RADIUS	:	.404	.530	.483
MEAN RADIUS	:	1.104	.948	.931
MAX RADIUS	:	2.139	1.481	1.349
HORIZONTAL SPREAD	:	2.111	1.947	1.947
VERTICAL SPREAD	:	3.013	2.469	2.079
EXTREME SPREAD	:	3.369	2.550	2.420
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

14 Jun 1994

FILE:/PATTERNING/CENTERFIRE_PATT/C6225559

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 4

3 in = 9

HS= 2.513

VS= 2.533

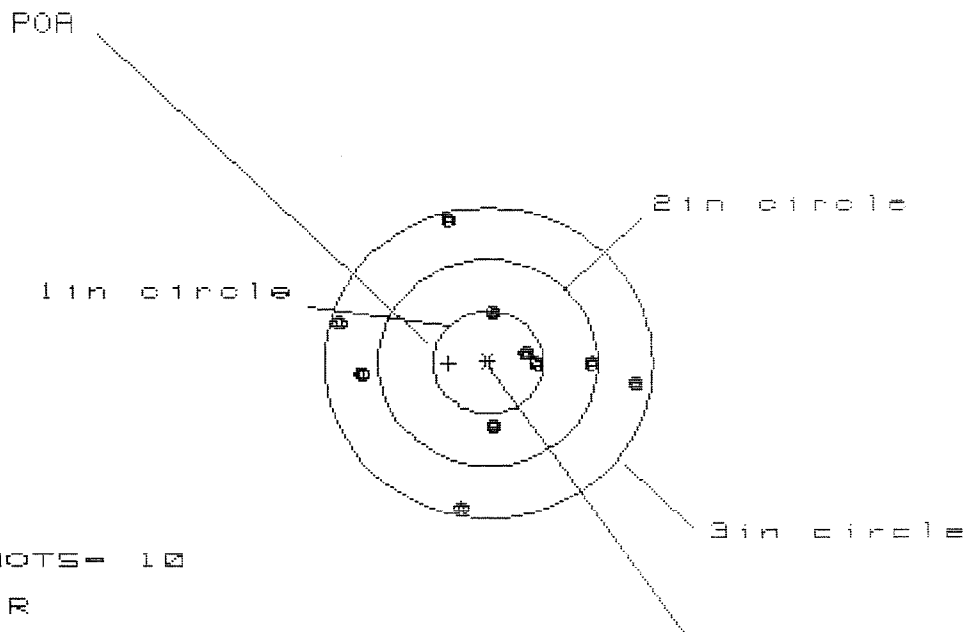
GS= 3.035

PATTERN #	3		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.443	1.325	1.198
MINIMUM X	-1.070	-1.153	-.988
MAXIMUM Y	1.146	.991	.973
MINIMUM Y	-1.387	-.673	-.691
CENTROID X	.107	.225	.060
CENTROID Y	-.256	-.101	-.083
POA TO CENTROID in.	.277	.247	.102
MIN RADIUS	.352	.230	.391
MEAN RADIUS	1.033	.944	.888
MAX RADIUS	1.752	1.333	1.383
HORIZONTAL SPREAD	2.513	2.478	2.186
VERTICAL SPREAD	2.533	1.664	1.664
EXTREME SPREAD	3.035	2.500	2.347
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		4	
NUMBER IN THREE INCH CIRCLE =		9	

14 Jun 1994

FILE:/PATTERNING/CENTERFIRE_PATT/C6225559

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 5

3 in = 10

HS= 2.728

VS= 2.817

GS= 2.819

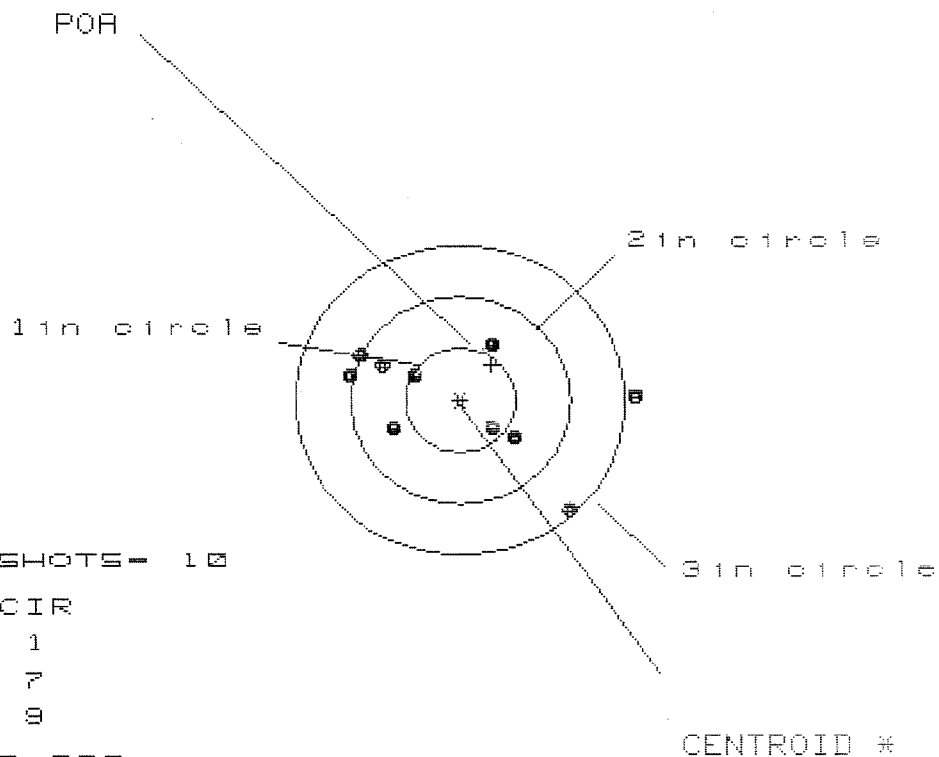
CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.335	1.298	1.119
MINIMUM X	:	-1.393	-1.430	-1.343
MAXIMUM Y	:	1.419	.683	.746
MINIMUM Y	:	-1.398	-1.240	-1.177
CENTROID X	:	.357	.394	.573
CENTROID Y	:	.010	-.148	-.211
POA TO CENTROID in.	:	.357	.421	.610
MIN RADIUS	:	.310	.336	.270
MEAN RADIUS	:	.960	.894	.780
MAX RADIUS	:	1.457	1.517	1.348
HORIZONTAL SPREAD	:	2.728	2.728	2.462
VERTICAL SPREAD	:	2.817	1.923	1.923
EXTREME SPREAD	:	2.819	2.785	2.465
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		10	

14 Jun 1994

FILE:/PATTERNING/CENTERFIRE_PATT/C8225553

CENTERFIRE PATTERNS # 5



OF SHOTS - 10

IN CIR

1 in = 1

2 in = 7

3 in = 9

HS = 2.583

VS = 1.606

GS = 2.589

CENTROID *

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	1.593
MINIMUM X	-.990
MAXIMUM Y	.586
MINIMUM Y	-1.020
CENTROID X	-.290
CENTROID Y	-.343
POA TO CENTROID in.	.449
MIN RADIUS	.394
MEAN RADIUS	.874
MAX RADIUS	1.595
HORIZONTAL SPREAD	2.583
VERTICAL SPREAD	1.606
EXTREME SPREAD	2.589
NUMBER IN ONE INCH CIRCLE =	1
NUMBER IN TWO INCH CIRCLE =	7
NUMBER IN THREE INCH CIRCLE =	9