

C6225494

MODEL 700™ M24

Model 700 M24™

Action

Barrel Length

Capacity

Order No. 5715

*Includes 1 in chamber.



Repair Inquiry

Repair Number: RE00156488

Verify Repair

Serial: C6225494 Model M24 SWS Center Fire
Caliber: 7.62 NATO Produced: 12/20/1988

Repairman:

Status:

Closed 12/6/2008 7:41:52 AM

Address Information

Customer:

☒ Received From

Return To:

☐ Received From

Name: DEPARTMENT OF THE ARMY SUPPLY OFFICER

DEPARTMENT OF THE ARMY SUPPLY OFFICER

Address 1: DOL SISA BLDG 9660 BAY A

DOL SISA BLDG 9660 BAY A

Address 2: BOX 339500 MAIL STOP 181

PO Box:

BOX 339500 MAIL STOP 181

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
A008	With Swivel	2
A010	Hard Case SYS	1
A017	Scope Base	1
D000	THRED PROTECTOF	1

Repair Search

Refresh

Close

nagletj

12/8/2008

12:28 PM

CAPS

NUM

INS

SCRL



Serial Number: C6225494

Model: M24 SWS



RE00156488

Slings
Bi-Pod
Thred Protect

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

R & E NUMBER 156488
 SERIAL NUMBER CL0223494
 LOG-IN DATE 12-6-08

OPERATION #	OPERATION NAME	DATE	INITIAL
500	DIS-ASSEMBLE GUN	12-10-08	RTZ
505	RE-BARREL	12-10-08	RTZ
560	ASSEMBLE	12-10-08	RTZ
600	PROOF	12-15-08	J.P.D.
605	CHECK HEADSPACE	12-15-08	J.P.D.
610	DIS-ASSEMBLE GUN	12-15-08	J.P.D.
612	MAGNAFLUX	12-10-08	(X)
510	DRILL AND TAP	12-16-08	J
615	ROLLMARK CALIBER	1/5	TR
618	ROTO-BLAST	1/7	—
620	APPLY COATINGS	1-9-09	RTZ
625	FINAL ASSEMBLY		
640	FUNCTION TEST AND	PASS FAIL	1-9-09 J.P.D.
650	TARGET	PASS FAIL	1-9-09 J.P.D.
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
670	FINAL INSPECTION		1-9-09 RP
	A) HEADSPACE	PASS FAIL	1-12-09 L.N.
	B) TRIGGER PULL	2.22 2.20 2.20 2.19 2.24	1-12-09 TR
680	F) SAFETY ON FORCE	49 40 40	1-12-09 L.N.
	G) SAFETY OFF FORCE	50 50 50	1-12-09 L.N.
	I) FIRING PIN INDENT	.023 .023 .023	1-12-09 L.N.
690	PACK		1/12/09 FM

SERIAL NUMBER: C6225494. 1

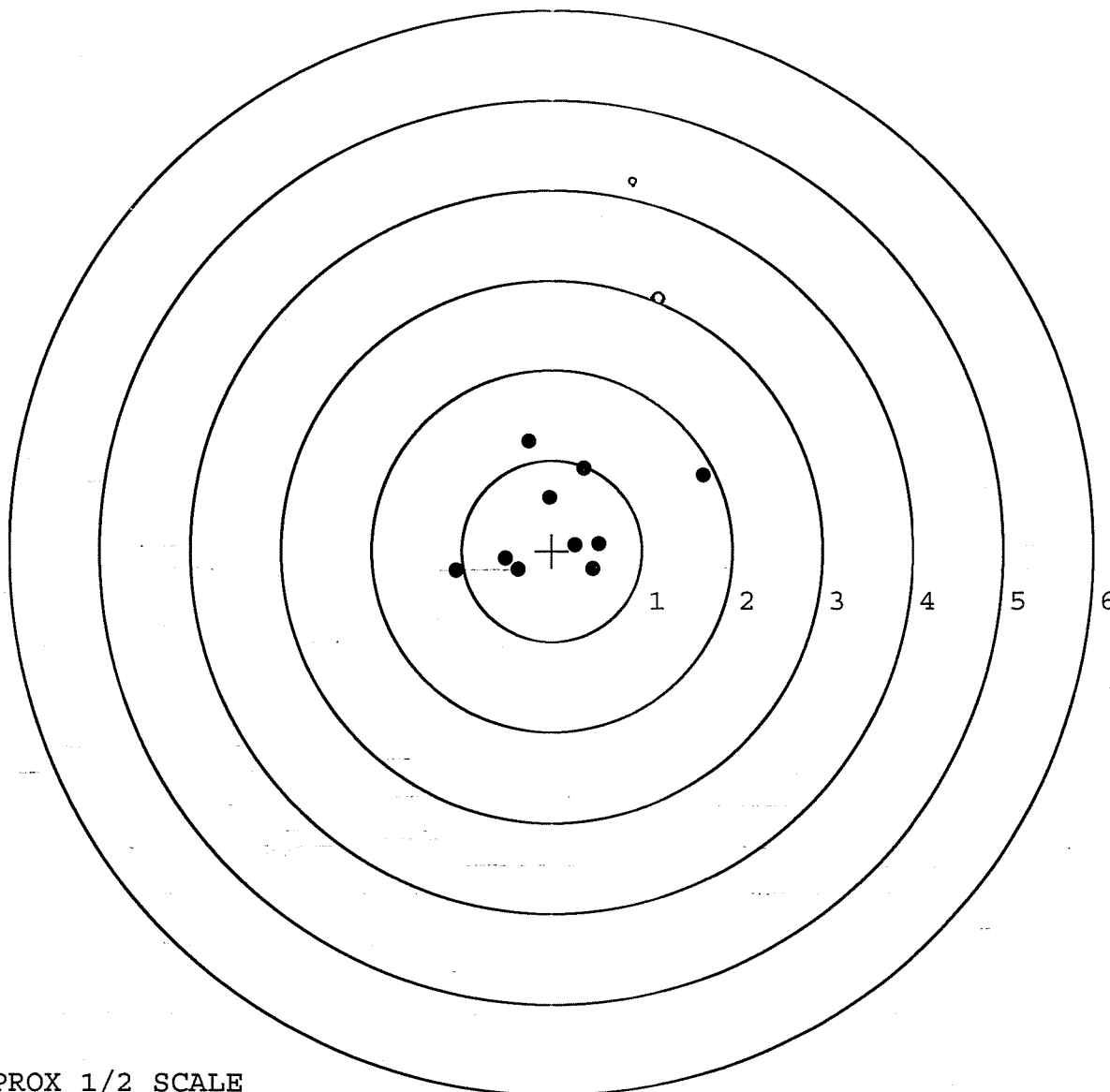
TARGET NUMBER: 1

FILE DATE: 01/12/2009

FILE TIME: 08:08

X CENTROID: 0.103
 Y CENTROID: 0.297
 POA TO CENTROID: 0.314
 HORZ SPREAD: 2.745
 VERT SPREAD: 1.431
 GROUP SPREAD: 2.943
 MIN RADIUS: 0.278
 MAX RADIUS: 1.666
 MEAN RADIUS: 0.770
 # IN 1 IN DIAMETER: 3
 # IN 2 IN DIAMETER: 8
 # in 3 IN DIAMETER: 9

POINT#	X	Y
1:	-1.066	-0.223
2:	-0.514	-0.092
3:	-0.374	-0.207
4:	0.459	-0.204
5:	0.255	0.064
6:	0.525	0.080
7:	0.355	0.910
8:	1.679	0.838
9:	-0.258	1.208
10:	-0.028	0.593

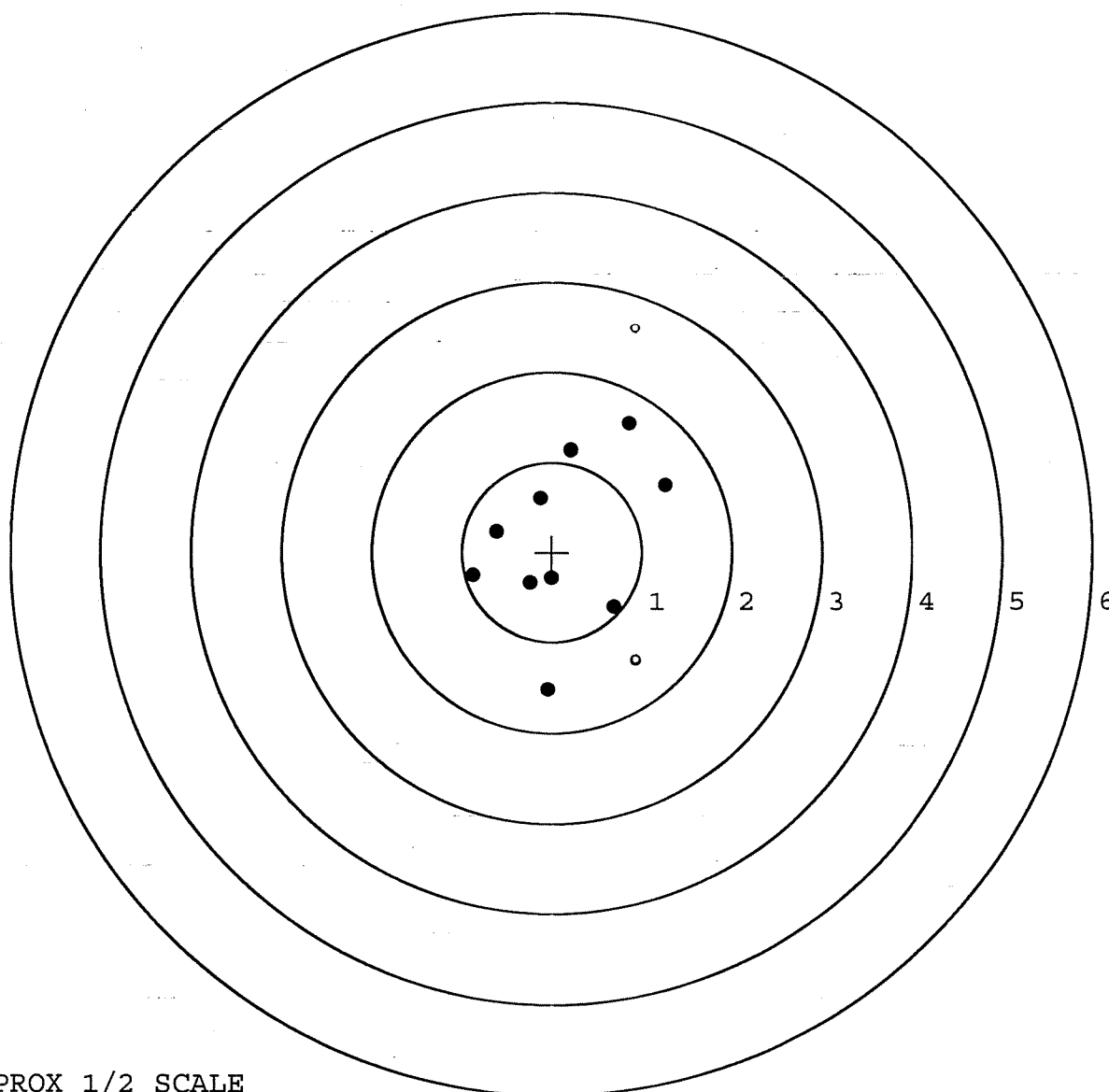


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6225494. 1
 TARGET NUMBER: 2
 FILE DATE: 01/12/2009
 FILE TIME: 08:08

POINT#	X	Y
1:	0.209	1.135
2:	0.855	1.433
3:	1.257	0.747
4:	-0.129	0.604
5:	-0.615	0.227
6:	-0.875	-0.257
7:	-0.244	-0.341
8:	-0.013	-0.288
9:	0.688	-0.617
10:	-0.049	-1.531

X CENTROID: 0.108
 Y CENTROID: 0.111
 POA TO CENTROID: 0.155
 HORZ SPREAD: 2.132
 VERT SPREAD: 2.964
 GROUP SPREAD: 3.099
 MIN RADIUS: 0.417
 MAX RADIUS: 1.650
 MEAN RADIUS: 0.976
 # IN 1 IN DIAMETER: 1
 # IN 2 IN DIAMETER: 5
 # in 3 IN DIAMETER: 8



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6225494. 1

TARGET NUMBER: 3

FILE DATE: 01/12/2009

FILE TIME: 08:08

X CENTROID: -0.043

Y CENTROID: -0.057

POA TO CENTROID: 0.072

HORZ SPREAD: 1.556

VERT SPREAD: 2.235

GROUP SPREAD: 2.241

MIN RADIUS: 0.199

MAX RADIUS: 1.320

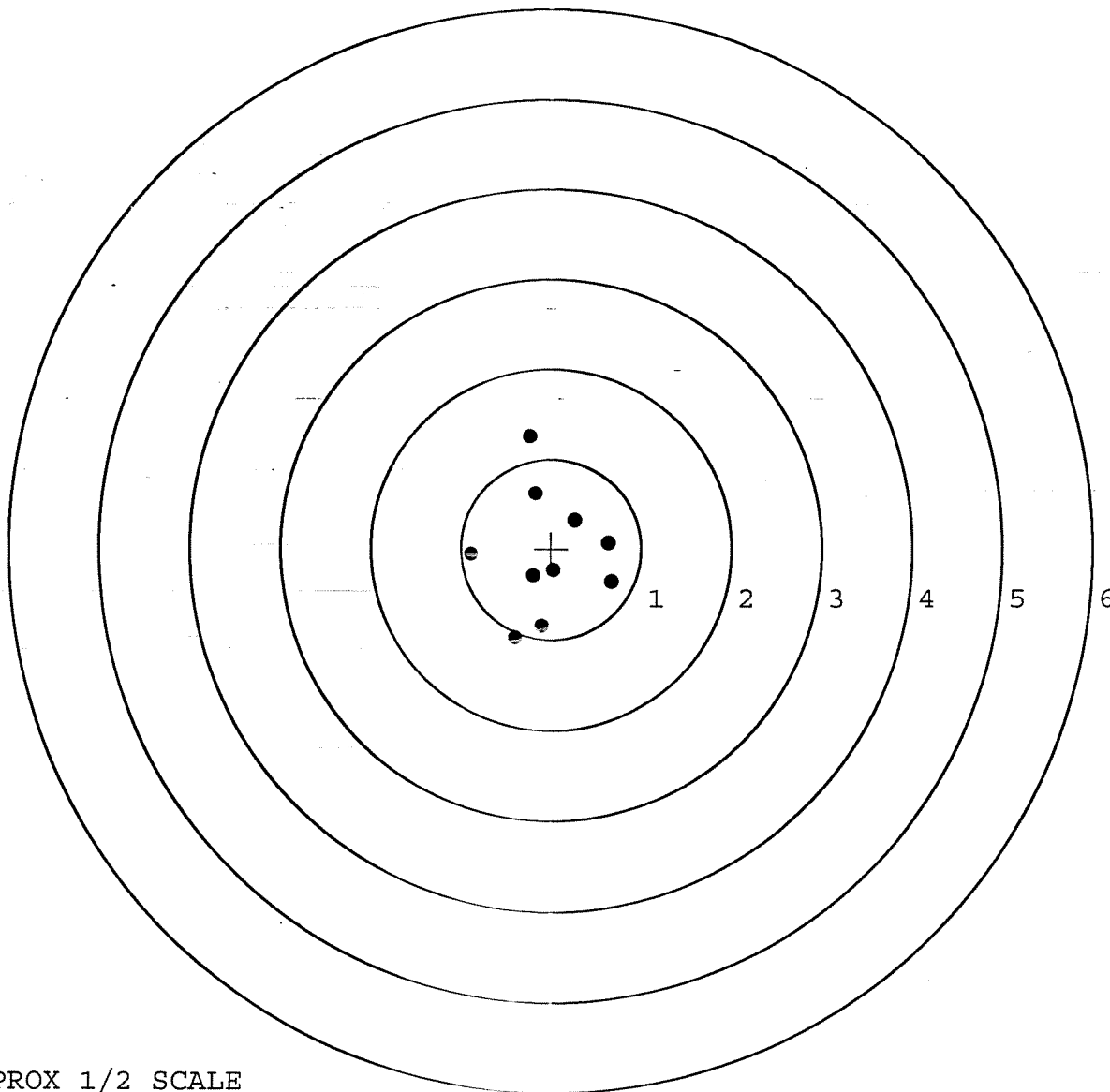
MEAN RADIUS: 0.710

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.238	1.249
2:	-0.180	0.619
3:	0.265	0.319
4:	0.634	0.063
5:	0.668	-0.367
6:	0.025	-0.244
7:	-0.202	-0.305
8:	-0.888	-0.064
9:	-0.111	-0.854
10:	-0.406	-0.986

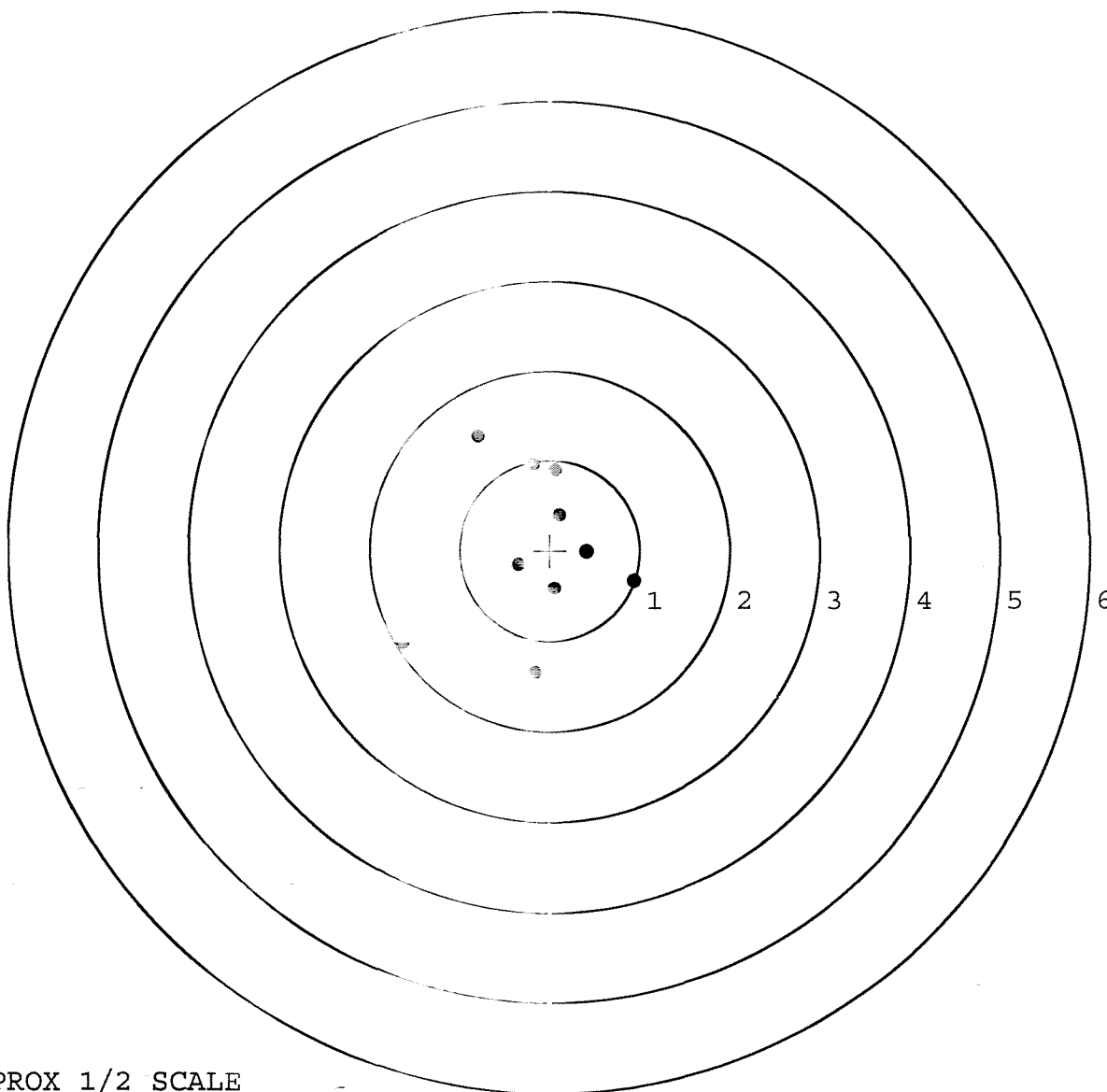


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6225494. 1
 TARGET NUMBER: 4
 FILE DATE: 01/12/2009
 FILE TIME: 08:08

X CENTROID: -0.155
 Y CENTROID: 0.021
 POA TO CENTROID: 0.156
 HORZ SPREAD: 2.567
 VERT SPREAD: 2.608
 GROUP SPREAD: 2.657
 MIN RADIUS: 0.263
 MAX RADIUS: 1.806
 MEAN RADIUS: 0.934
 # IN 1 IN DIAMETER: 3
 # IN 2 IN DIAMETER: 6
 # in 3 IN DIAMETER: 9

POINT#	X	Y
1:	-0.795	1.261
2:	-0.183	0.960
3:	0.063	0.892
4:	0.109	0.394
5:	0.411	-0.014
6:	0.937	-0.337
7:	0.051	-0.426
8:	-0.351	-0.155
9:	-0.163	-1.347
10:	-1.630	-1.021

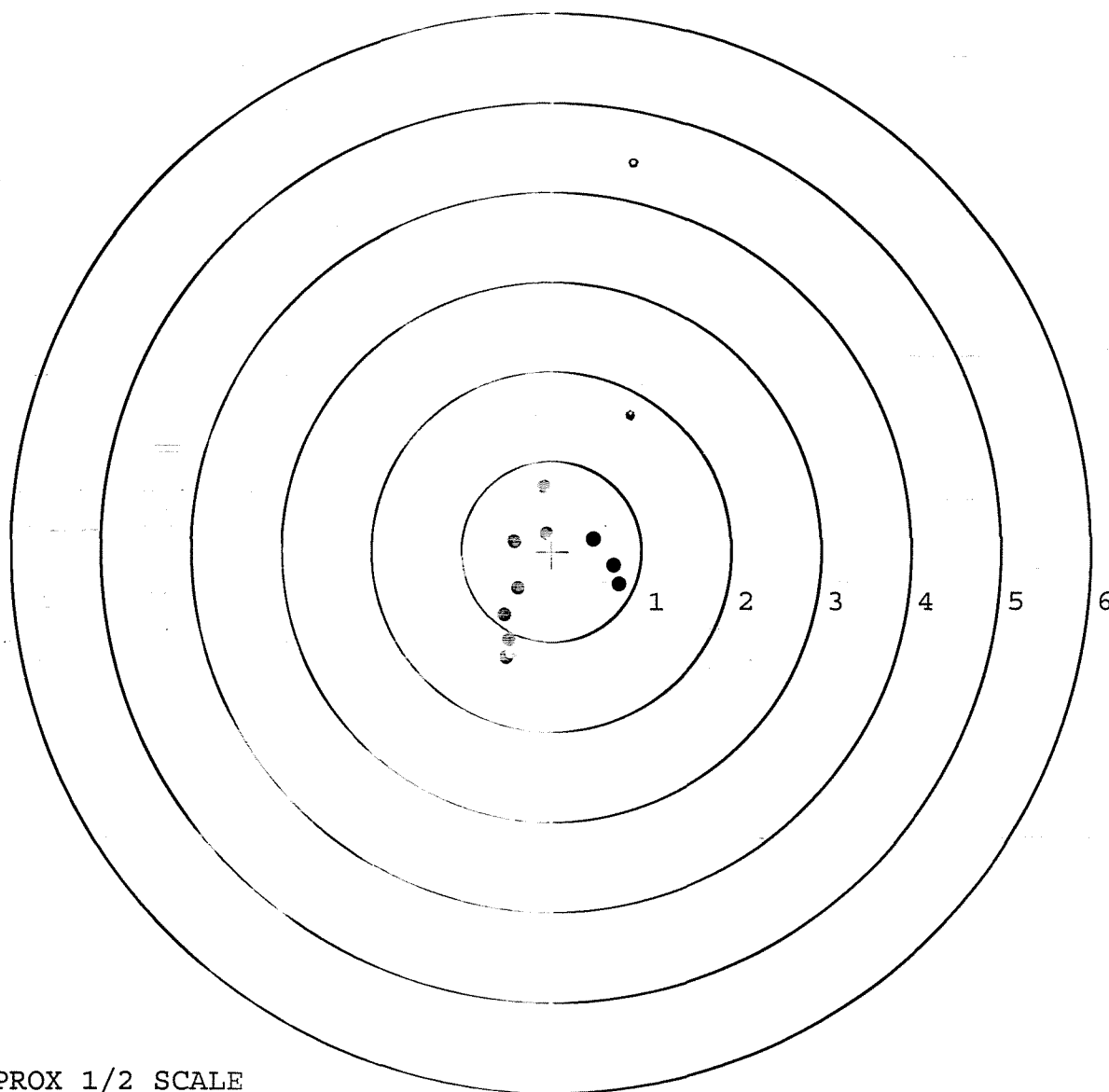


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6225494. 1
 TARGET NUMBER: 5
 FILE DATE: 01/12/2009
 FILE TIME: 08:08

X CENTROID: -0.055
 Y CENTROID: -0.262
 POA TO CENTROID: 0.267
 HORZ SPREAD: 1.281
 VERT SPREAD: 1.893
 GROUP SPREAD: 1.941
 MIN RADIUS: 0.350
 MAX RADIUS: 1.022
 MEAN RADIUS: 0.703
 # IN 1 IN DIAMETER: 2
 # IN 2 IN DIAMETER: 9
 # in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.748	-0.363
2:	0.690	-0.160
3:	0.461	0.139
4:	-0.082	0.718
5:	-0.054	0.196
6:	-0.415	0.113
7:	-0.513	-1.175
8:	-0.478	-0.981
9:	-0.533	-0.703
10:	-0.376	-0.401



TARGET APPROX 1/2 SCALE

Repair Inquiry

Repair Number: **RE00124988**

Serial: C6225494 Model M24 SWS Center Fire

Repairman:

Verify Repair

Status:

New 2/7/2007 9:36:11 AM

Address Information

Customer:

☒ Received From

Return To:

☐ Received From

Name: **SGT. CHRISTOPHER SMITH**

SGT. CHRISTOPHER SMITH

Address 1: **HHC 1-38 INFANTRY SNIPERS**

HHC 1-38 INFANTRY SNIPERS

Address 2: **BLDG 3227 2ND DIV. RD.**

PO Box:

BLDG 3227 2ND DIV. RD.

PO Box:

City: **FT. LEWIS**

FT. 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: **NA**

Fax:

Email:

Comments:

Received Condition

Fair

Condition

Notes:

CSR

Notes:

Accessories Received

Code	Desc	Qty
A007	With Stud	3
A010	Hard Case	1
A017	Scope Base	1

Repair Search

Refresh

Close

nagletj

2/7/2007

11:45 AM

CRPS

NUM

TMS

SCRL

Serial Number: **C6225494**
 Model: **M24 SWS**

RE00124988

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6225494.___0
FILE DATE AND TIME: 02/26/2007 23:05

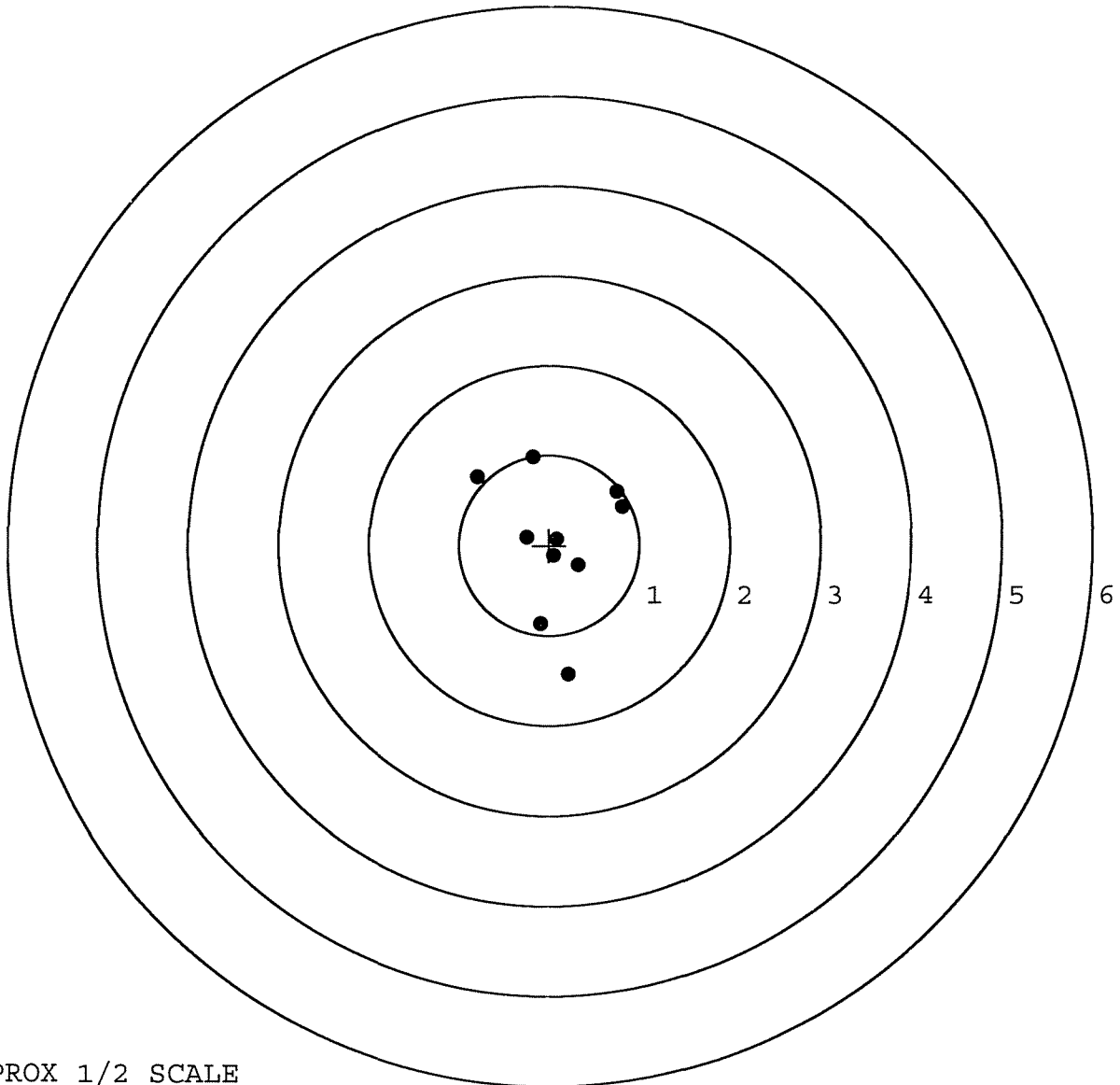
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.029
The Average Y Centroid of the Five Target Set:	-0.005
The Average Point of Impact of the Five Target Set:	0.029
The Average Mean Radius of the Five Target Set:	0.788
The Distance from POA to Centroid Target #1:	0.094
The Distance from Centroid Target #2 to Centroid Target #1:	0.210
The Distance from Centroid Target #3 to Centroid Target #1:	0.225
The Distance from Centroid Target #4 to Centroid Target #1:	0.155
The Distance from Centroid Target #5 to Centroid Target #1:	0.304

SERIAL NUMBER: C6225494. __0
 TARGET NUMBER: 1
 FILE DATE: 02/26/2007
 FILE TIME: 23:05

POINT#	X	Y
1:	-0.798	0.755
2:	-0.185	0.978
3:	0.749	0.595
4:	0.812	0.430
5:	-0.097	-0.877
6:	0.217	-1.439
7:	0.323	-0.224
8:	0.049	-0.119
9:	0.086	0.068
10:	-0.249	0.088

X CENTROID: 0.091
 Y CENTROID: 0.026
 POA TO CENTROID: 0.094
 HORZ SPREAD: 1.610
 VERT SPREAD: 2.417
 GROUP SPREAD: 2.450
 MIN RADIUS: 0.043
 MAX RADIUS: 1.470
 MEAN RADIUS: 0.711
 # IN 1 IN DIAMETER: 4
 # IN 2 IN DIAMETER: 8
 # in 3 IN DIAMETER: 10

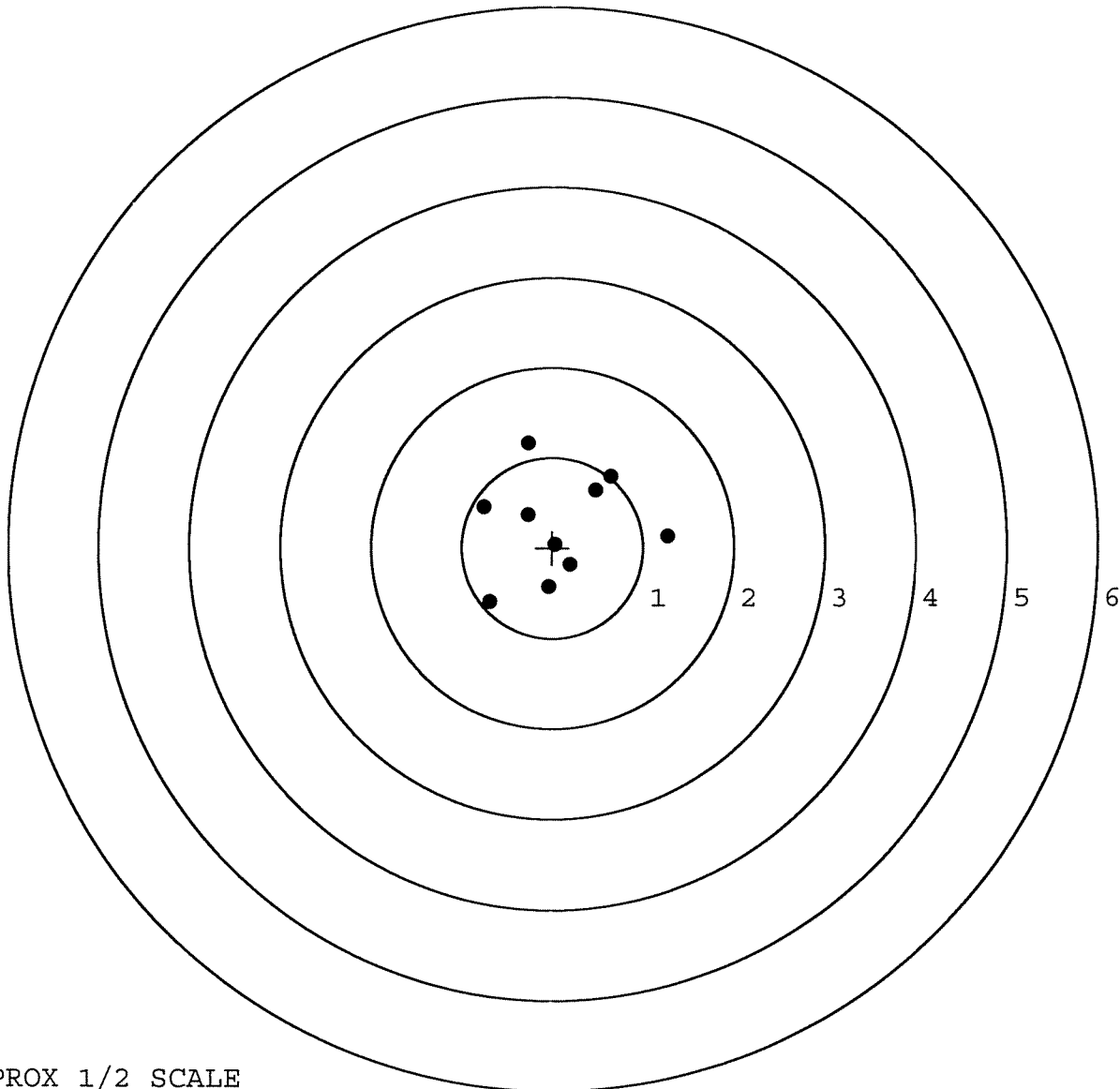


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6225494. __0
 TARGET NUMBER: 2
 FILE DATE: 02/26/2007
 FILE TIME: 23:05

X CENTROID: 0.059
 Y CENTROID: 0.234
 POA TO CENTROID: 0.241
 HORZ SPREAD: 2.025
 VERT SPREAD: 1.764
 GROUP SPREAD: 2.089
 MIN RADIUS: 0.197
 MAX RADIUS: 1.215
 MEAN RADIUS: 0.723
 # IN 1 IN DIAMETER: 3
 # IN 2 IN DIAMETER: 8
 # in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.273	1.160
2:	0.479	0.638
3:	0.645	0.790
4:	1.269	0.129
5:	-0.756	0.448
6:	-0.687	-0.604
7:	-0.042	-0.436
8:	-0.273	0.364
9:	0.031	0.038
10:	0.197	-0.192

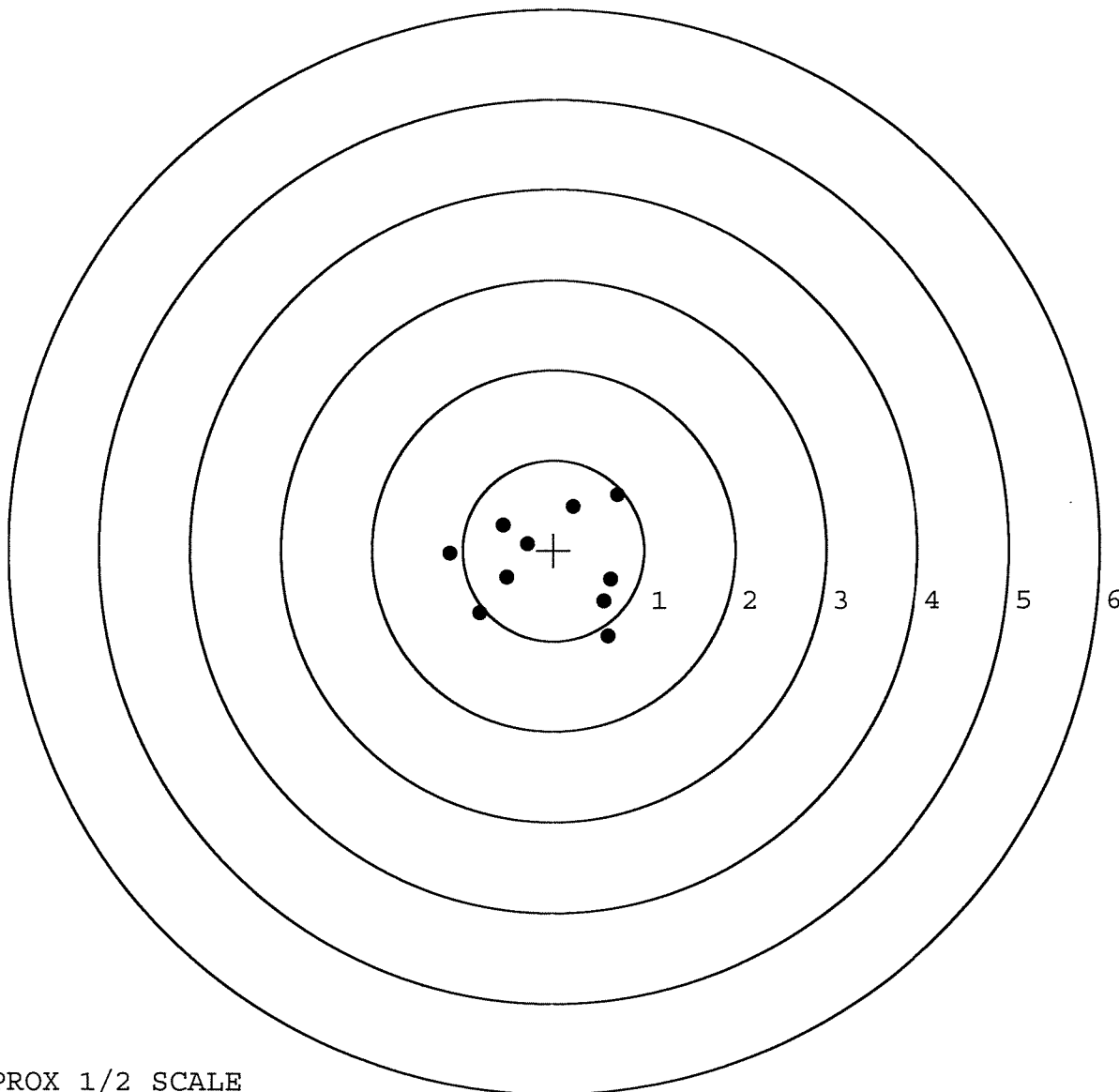


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6225494. __0
 TARGET NUMBER: 3
 FILE DATE: 02/26/2007
 FILE TIME: 23:05

X CENTROID: -0.060
 Y CENTROID: -0.142
 POA TO CENTROID: 0.154
 HORZ SPREAD: 1.848
 VERT SPREAD: 1.568
 GROUP SPREAD: 1.968
 MIN RADIUS: 0.312
 MAX RADIUS: 1.089
 MEAN RADIUS: 0.773
 # IN 1 IN DIAMETER: 2
 # IN 2 IN DIAMETER: 7
 # in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.704	0.620
2:	0.219	0.486
3:	-0.554	0.274
4:	-0.288	0.071
5:	-0.515	-0.301
6:	-0.810	-0.695
7:	-1.144	-0.041
8:	0.629	-0.323
9:	0.558	-0.562
10:	0.603	-0.948

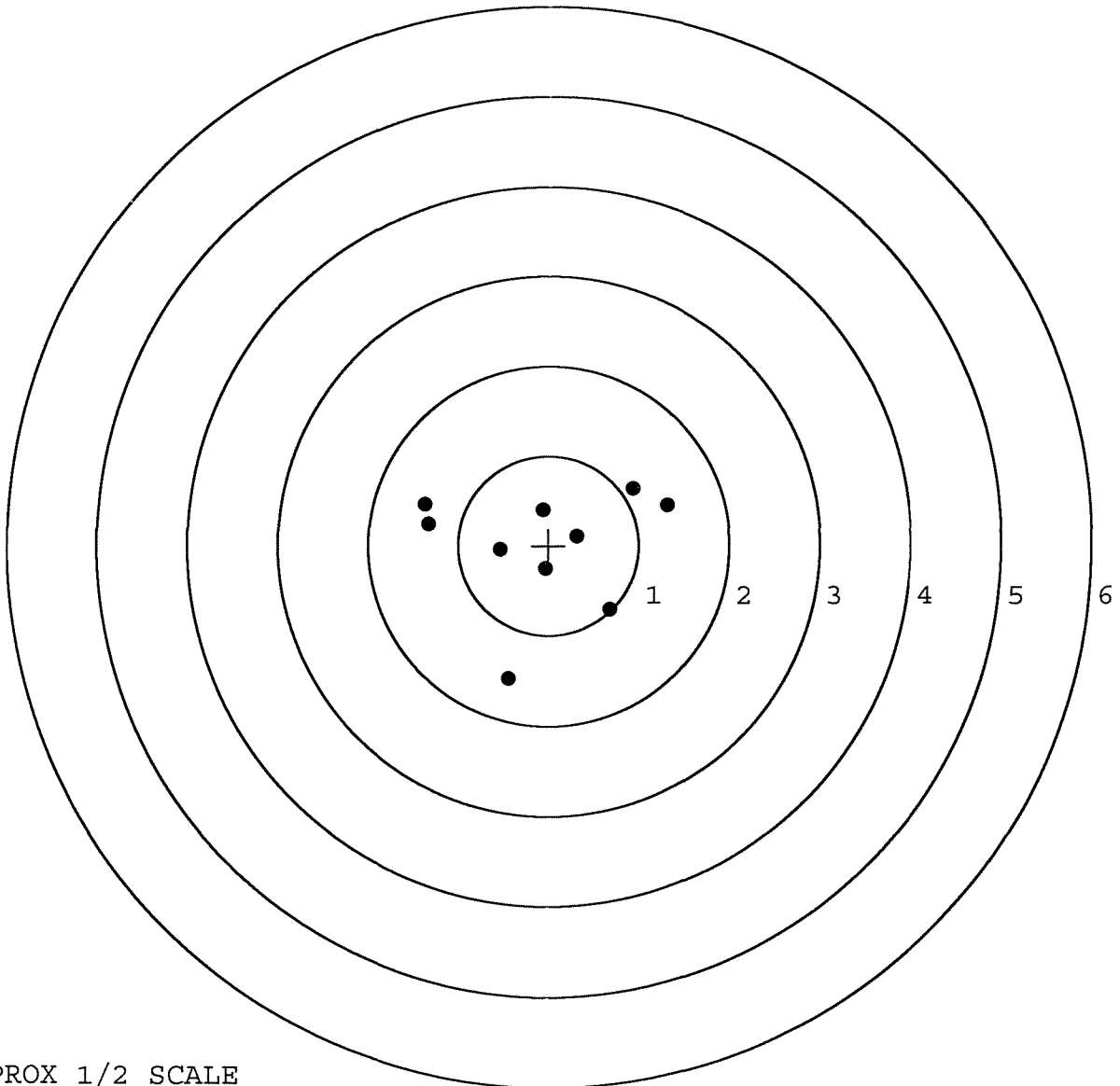


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6225494. __0
 TARGET NUMBER: 4
 FILE DATE: 02/26/2007
 FILE TIME: 23:05

POINT#	X	Y
1:	1.308	0.450
2:	0.932	0.636
3:	-0.073	0.395
4:	0.317	0.104
5:	-0.038	-0.261
6:	-0.537	-0.049
7:	0.684	-0.717
8:	-0.441	-1.483
9:	-1.340	0.236
10:	-1.380	0.455

X CENTROID: -0.057
 Y CENTROID: -0.023
 POA TO CENTROID: 0.061
 HORZ SPREAD: 2.688
 VERT SPREAD: 2.119
 GROUP SPREAD: 2.607
 MIN RADIUS: 0.238
 MAX RADIUS: 1.509
 MEAN RADIUS: 0.941
 # IN 1 IN DIAMETER: 4
 # IN 2 IN DIAMETER: 4
 # in 3 IN DIAMETER: 9

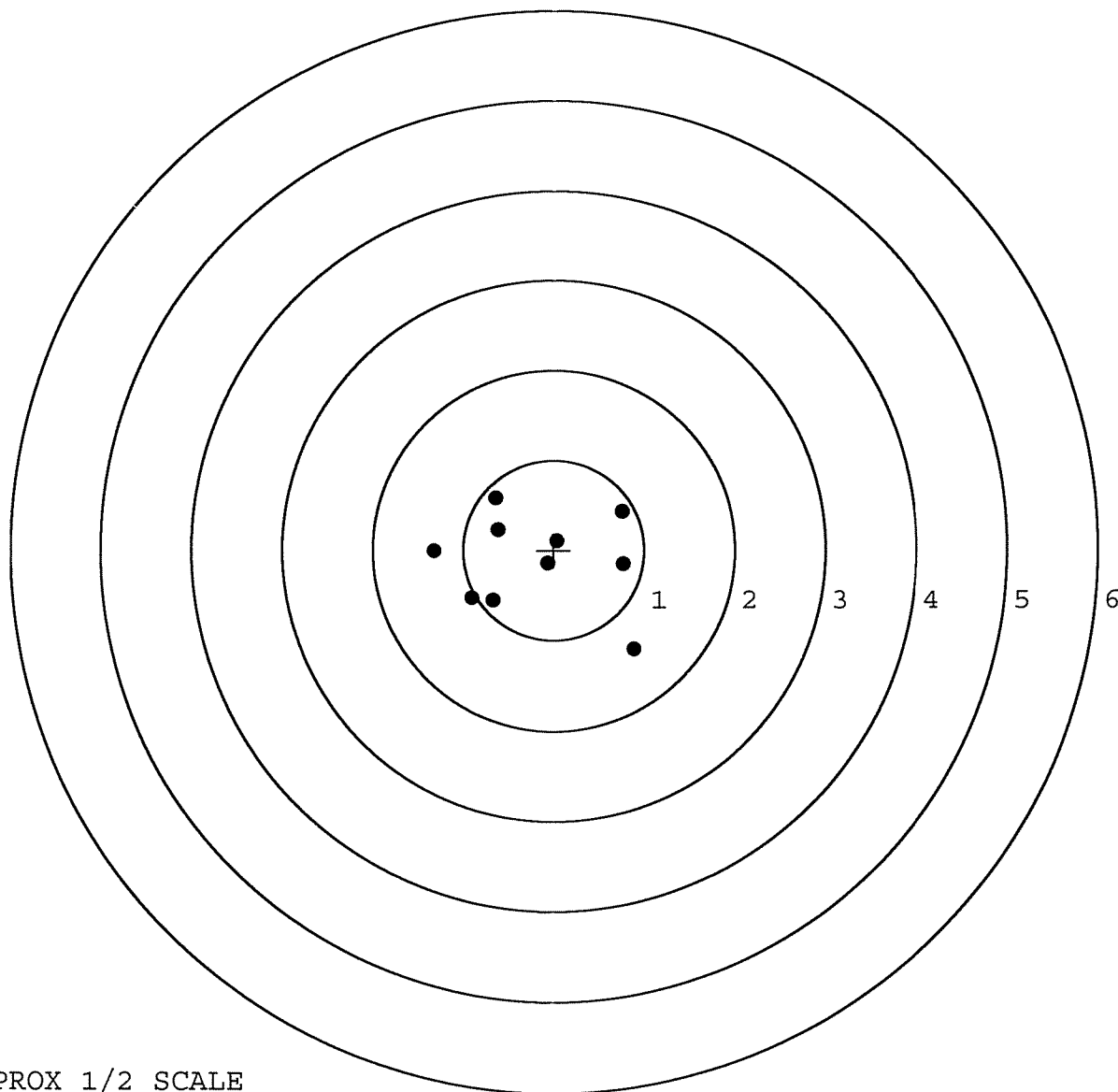


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6225494. __0
 TARGET NUMBER: 5
 FILE DATE: 02/26/2007
 FILE TIME: 23:05

X CENTROID: -0.177
 Y CENTROID: -0.119
 POA TO CENTROID: 0.213
 HORZ SPREAD: 2.210
 VERT SPREAD: 1.676
 GROUP SPREAD: 2.462
 MIN RADIUS: 0.112
 MAX RADIUS: 1.449
 MEAN RADIUS: 0.794
 # IN 1 IN DIAMETER: 2
 # IN 2 IN DIAMETER: 7
 # in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.642	0.576
2:	-0.614	0.222
3:	-1.321	-0.015
4:	-0.906	-0.538
5:	-0.669	-0.561
6:	-0.069	-0.147
7:	0.038	0.101
8:	0.755	0.432
9:	0.770	-0.158
10:	0.889	-1.100



TARGET APPROX 1/2 SCALE

R & E NUMBER	124988		
SERIAL NUMBER	06225494		
LOG-IN DATE	2-7-07		
OPERATION #	OPERATION NAME	DATE	INITIAL
500	DIS-ASSEMBLE GUN	2-13-07	RR
505	RE-BARREL	2-16-07	RTZ
560	ASSEMBLE	2-16-07	TRW
600	PROOF	2-16-07	Fm
605	CHECK HEADSPACE	INSPECTED	Fm
610	DIS-ASSEMBLE GUN	FEB 20 2007	RTZ
612	MAGNAFLUX	OPERATOR <i>OPD</i>	2-20-07 APO
510	DRILL AND TAP	N/A	2-19-07 TRW
615	ROLLMARK CALIBER		2-19-07 CW
618	ROTO-BLAST		2-20-07 LB
620	APPLY COATINGS		2-20-07 WJ
625	FINAL ASSEMBLY		2-26-07 RTZ
640	FUNCTION TEST AND	(PASS) FAIL	2/26/07 non
650	TARGET	(PASS) FAIL	2/26/07 non
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
670	FINAL INSPECTION		2-27-07 RTZ
	A) HEADSPACE	(PASS) FAIL	2-27-07 RTZ
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	2.83 2.83 2.70 2.70 2.69 2.27.07 OA
680	F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX	6.0 5.5 6.0 2.27.07 OA
	G) SAFETY OFF FORCE	2 LBS MIN	2.5 2.5 2.5 2.27.07 OA
	I) FIRING PIN INDENT	.020	.020 .020 .020 2.27.07 OA
690	PACK		2.27.07 OA

ORDER

RECEIVING AND ESTIMATING REPORT

ORDER
99-23156

INITIAL SWS		CUSTOMER ORDER NO.		WOG 1 OF 2	
DATE RECEIVED 11/23/99	DATE OPENED 11/23/99	DATE CODE DI 9/88	SERIAL NUMBER C6225494	NEW SERIAL NUMBER	MODEL AND GRADE 700 7.62NAT M24 SWS
ACCESSORIES W/STUDS		SCOPE BASE CAMO PAINT			

FROM:

SHIP TO:

DENNA,, PAUL
HHC 1/503 INF REGT
APO SAN FRANCISCO

CA 96224

DENNA, PAUL
HHC 1/503 INF REGT
APO SAN FRANCISCO CA
96224

CUST NO: 211824 C.O.D.

ACCOUNT NUMBER		ACCOUNT NUMBER N/C		WRITE ☐		PROM. DATE		ESTIMATED		VIA UPS	
GUN CONDITION										REPAIR CHARGE	
☐ NEW										REPAIR CHARGE	
☐ LIGHTLY WORN										EXCISE	
☐ WORN										TAX	
☐ VERY WORN										INSURANCE	
☐ UNREPAIRABLE										UPS	
☐ MARRED										PARCEL POST	
										TOTAL	

CUSTOMER CONCERN	AMMO	FUNCTION	FINISH	ACCURACY	FIT	INSPECT
CYCLE	A	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

PARTS		COMMENTS					
BBL	96003						
Stock	96018						
		REPAIRMAN	PROOF	CLEAN	TEST	TARGET	PATTERN
		RW	✓	✓	✓	✓	
		GALLERY TESTER	DATE	DATE	DATE	DATE	DATE
		RW		3/16-00	3-20-00	3-20-00	

OFFICE COPY

AD6925 REV. 7/97

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER

BARBER - M24 M2490061980

Remington Arms Company, Inc. Repair Instructions

Print and complete this form and mail it, along with your firearm to:

Remington Arms Company, Inc.

14 Hoefler Ave.
Ilion, New York 13357

Name: SSG PAUL DENNA Model: M-24 SWS
 Address: HHC 1-503 INF RGT Serial #: C6225494
 City: UNIT # 15059 Date of Purchase: _____
 State: APC AP. Zip: 96224-0320 (if available, please attach a copy
 Telephone: (Day) () _____ of the proof of purchase.)
 (Night) () _____ Internet Request

Please describe the problem you are having with your firearm: _____

WEAPON SYSTEM UNDER GOVERNMENT CONTRACT.
ROUND COUNT OVER 10,000
IN NEED OF CALIBRATION AND MAINTENANCE COVERED
UNDER GOVERNMENT CONTRACT.

Optional Information

Ammo Type: _____ Brand: _____

or Handload Specification _____ Bullet Weight: _____ Shot Size: _____

Reminders:

Record your serial number - it will help reference your repair.

Properly package your unloaded firearm. Do not ship in a hard case.

If you would like to order a box, please call our Parts Department:

800-243-9700, 9am-5pm, EST.

Do not send live/loaded ammunition with your firearm.

Remove all accessories.

Back to Obtaining Repair Service

©1998- Remington Arms Company, Inc.

Remington Test Lab, Ilion, N.Y.

Centroidal distance calculations for Rifle # c6225494
23 Mar 2000

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .054
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1758
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .183907

THE AMR FOR THIS RIFLE IS: 1.211

CENTROIDAL DISTANCES

Ø TO	1	.362505
1 TO	2	.387249
1 TO	3	.849696
1 TO	4	.328938
1 TO	5	.593273

3
+
2 1 <----POA
4
5

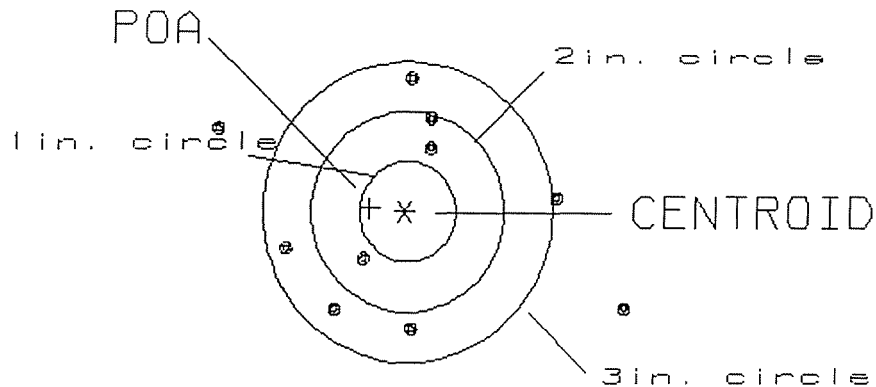
PATTERN #: ☐ 1 ☐

POA TO CENTROID: .362
 MIN RADIUS : .653
 MEAN RADIUS : 1.346
 MAX RADIUS : 2.435
 CENTROID X : .361
 CENTROID Y : -.033

23 Mar 2000

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6225494.1

CENTERFIRE PATTERN # 1



OF SHOTS= 10

IN CIRCLE

HS= 4.23

0

VS= 2.49

3

GS= 4.60

7

PATTERN #: ☐ 2 ☐

POA TO CENTROID: .144

MIN RADIUS : .325

MEAN RADIUS : .804

MAX RADIUS : 1.614

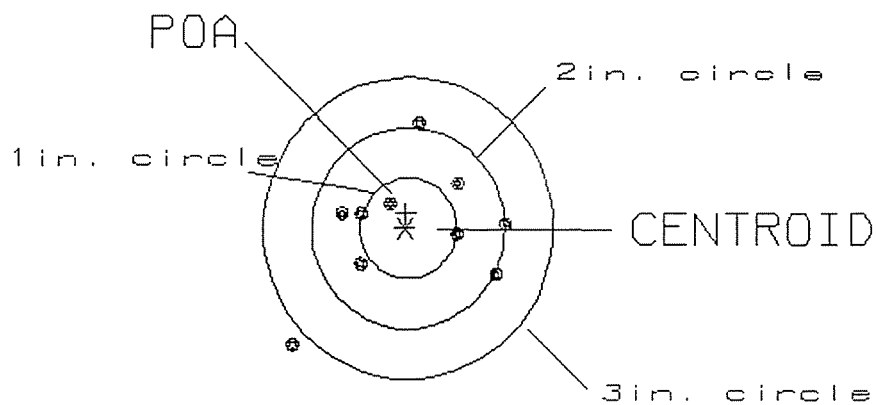
CENTROID X : -.010

CENTROID Y : -.144

23 Mar 2000

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6225494.1

CENTERFIRE PATTERN # 2



OF SHOTS= 10

IN CIRCLE

HS= 2.14

1

VS= 2.17

7

GS= 2.53

9

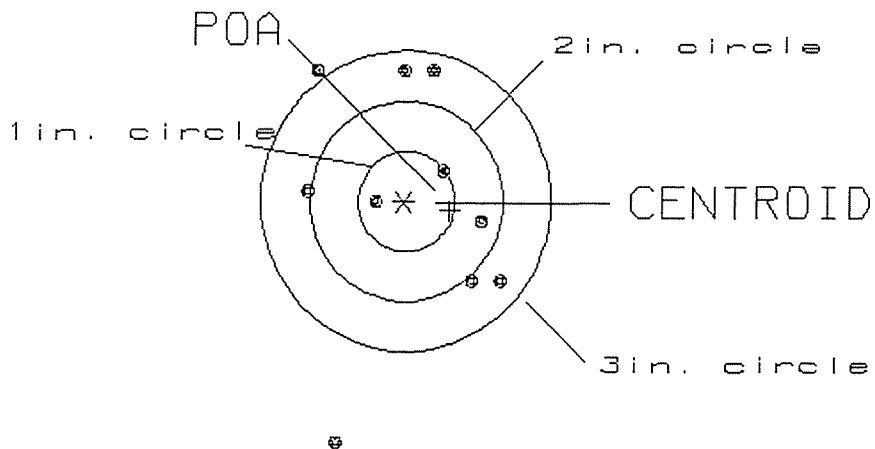
PATTERN #: ☐ 3 ☐

POA TO CENTROID: .489
 MIN RADIUS : .346
 MEAN RADIUS : 1.167
 MAX RADIUS : 2.549
 CENTROID X : -.479
 CENTROID Y : .095

23 Mar 2000

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6225494.1

CENTERFIRE PATTERN # 3



OF SHOTS= 10

IN CIRCLE

HS= 1.91
 VS= 3.78
 GS= 3.84

2
 4
 8

PATTERN #: ☐ 4 ☐

POA TO CENTROID: .575

MIN RADIUS : .604

MEAN RADIUS : 1.242

MAX RADIUS : 1.833

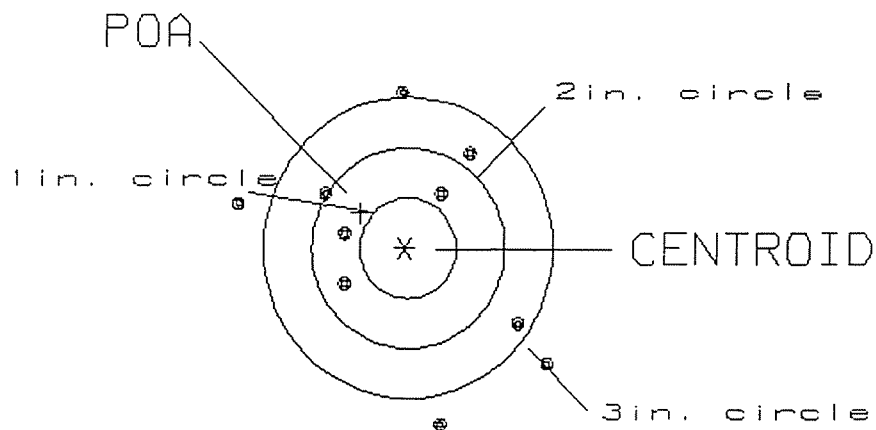
CENTROID X : .459

CENTROID Y : -.347

23 Mar 2000

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6225494.1

CENTERFIRE PATTERN # 4



OF SHOTS= 10

IN CIRCLE

HS= 3.15

0

VS= 3.21

3

GS= 3.51

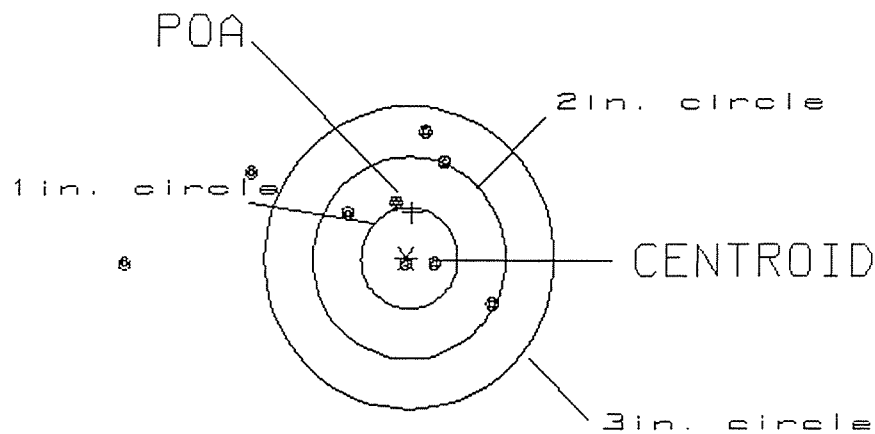
6

PATTERN #: ☐ 5 ☐
 POA TO CENTROID: .454
 MIN RADIUS : .054
 MEAN RADIUS : 1.494
 MAX RADIUS : 5.172
 CENTROID X : -.061
 CENTROID Y : -.450

23 Mar 2000

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6225494.1

CENTERFIRE PATTERN # 5



OF SHOTS= 10

IN CIRCLE

HS= 6.73

2

VS= 4.82

5

GS= 7.56

7

Final Inspection

Sn: C6225494

DATE REC'D: 11/23/99

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:

M-24

CONTRACT # DAAA09-92-C-0834

R&E NO.

SERIAL NO. C6225494

LOG IN DATE: / /

DATE

INIT.

INSPECT & VERIFY:

OP. #

OP. NAME

550

DIS-ASSEMBLE GUN

12/10/99

RW

560 A

RE-BARREL AT CUSTOM SHOP

B

DRILL & TAP

C

POLISH

575

ASSEMBLE

600

PROOF

1/20/00

RW

605

CHECK HEADSPACE

1/20/00

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

3/21/00

RW

655

FINAL INSPECT

3/23/00

RW

660

PACK

QAR INSPECTION

SHIP DATE

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6225494

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	pfe.
	Magnaflux Bolt		9-14-88	pfe
615	Rollmark Caliber			
617	Drill & Tap Sight Holes			
618	Polish Barrel			
620	Apply Coatings (Barrel Action)		10-31-88	TSA
	Apply Coatings (Bolt)		10-31-88	TSA
625	Final Assembly A) Clean inside of Bolt Assembly		11/7/88	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		11/7/88	RW
	C) Inspect Ejector Hole for Chamfer		11/7/88	RW

OVER

OP.#		READINGS	DATE	INITIAL
625	D) Oil Firing Pin Ass'y		11/2/88	RW
cont.	E) Adjust Trigger Pull to Min. Setting and Stake		8 NOV 88	ju
	F) Safety on Force	<u>5</u> <u>5</u> <u>5</u>	8 NOV 88	JS
	G) Safety off Force	<u>3</u> <u>3</u> <u>4</u>	8 NOV 88	ju
	H) Trigger Pull Test & Retainability		8 NOV 88	JS
	I) Firing Pin Indent	<u>0.020</u> <u>0.020</u> <u>0.020</u>	8 NOV 88	JS
	J) Assemble Stock		11/6/88	RW
	K) Attach Front & Rear Sight Assemblies		11/16/88	RW
	L) Iron Sight Alignment		11/16/88	RW
	M) Detach Front & Rear Sights & place in numbered container		11/16/88	RW
	N) Attach Scope to Rifle		11/16/88	WB
	O) Detach & Attach Scope 20 times		11/16/88	WB
640	Gallery Target & Test	68 R 83 L	11/18/88	DH
	A) Optical Clarity of Scope		11/18/88	DH
645	Inspect for Live Ammo		11/18/88	DH
655	Final Inspection			
	A) Headspace		1 Dec 88	JS
	B) Trigger Pull	<u>2.69</u> <u>2.70</u> <u>2.63</u>	<u>2.65</u> <u>2.69</u>	JS
	C) Function		1 Dec 88	JS
	D) Assemble Swivel Studs		1 Dec 88	JS
660	Pack		14 Dec 88	JS

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

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

SERIAL NO. C-6225494

DATE 11-8-88

TESTER JE

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.58	2.58	2.41	2.69	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.53	2.59	2.42	2.70	
PULL #3	2.43	2.55	2.40	2.63	
PULL #4	2.59	2.51	2.43	2.65	
PULL #5	2.58	2.49	2.36	2.69	
TOTAL	12.71	12.72	12.02	13.36	
AVG.	2.542	2.544	2.404	2.672	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.15	3.17		
PULL #2	3.27	3.17		
PULL #3	3.26	3.18		
PULL #4	3.29	3.16		
PULL #5	3.28	3.18		
TOTAL	16.25	15.86		
AVG.	3.250	3.172		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.05	4.09		4.26
PULL #2	4.02	4.15		4.29
PULL #3	4.17	4.16		4.28
PULL #4	4.26	4.23		4.30
PULL #5	4.20	4.22		4.28
TOTAL	20.70	20.85		21.41
AVG.	4.140	4.170		4.282

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6225494

CENTROIDAL DISTANCES

0 TO	1	1.029
1 TO	2	.390483
1 TO	3	.222032
1 TO	4	.427551
1 TO	5	.436818

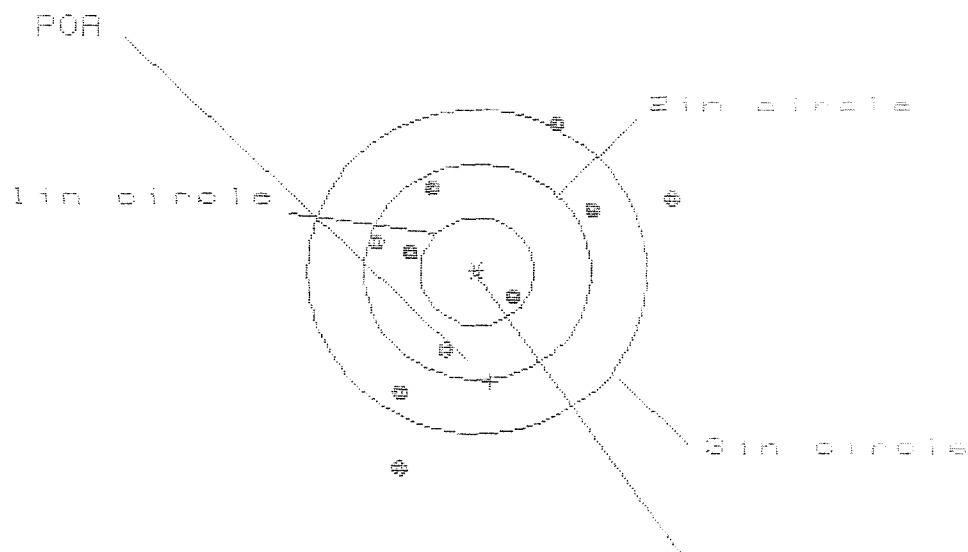
132
3
+ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .069
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .8592
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .861966
THE AMR FOR THIS RIFLE IS: .9452

28 Nov 1988

FILE:/PATTERNING/CENTERFIRE_PATT/08225484

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 5

3 in = 7

HS = 2.648

VS = 3.127

GS = 3.492

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.738	1.657	1.689
MINIMUM X	-.910	-.991	-.784
MAXIMUM Y	1.346	1.148	1.210
MINIMUM Y	-1.781	-1.284	-1.222
CENTROID X	-.111	-.030	-.237
CENTROID Y	1.023	1.221	1.159
POA TO CENTROID in.	1.029	1.221	1.183
MIN RADIUS	.353	.467	.487
MEAN RADIUS	1.134	1.046	.924
MAX RADIUS	1.923	1.729	1.475
HORIZONTAL SPREAD	2.648	2.648	1.873
VERTICAL SPREAD	3.127	2.432	2.432
EXTREME SPREAD	3.492	3.013	2.812
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	7		

28 May 1988

FILE:/PATTERNING/CENTERFIRE_PATT/CG223454

CENTERFIRE PATTERNS

2

POR

1 in circle

2 in circle

3 in circle

OF SHOTS = 10

IN CIR

1 in = 4

2 in = 10

3 in = 10

HS = 1.904

VS = 1.085

GS = 1.908

CENTROID #

PATTERN #

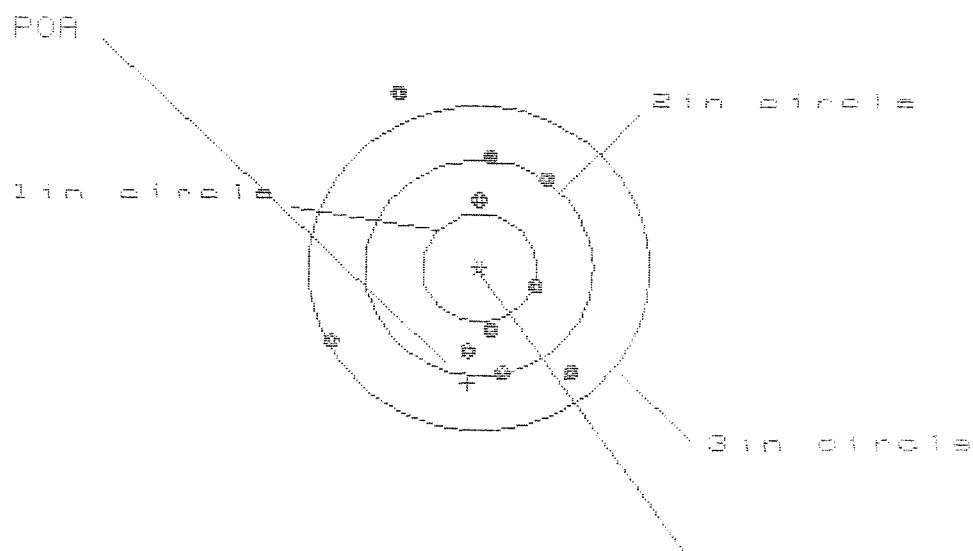
2

SHOTS (BEST OF)	10	9	8
MAXIMUM X	.979	1.000	.898
MINIMUM X	-.925	-.816	-.755
MAXIMUM Y	.714	.712	.695
MINIMUM Y	-.371	-.373	-.390
CENTROID X	.275	.166	.268
CENTROID Y	.964	.966	.983
POR TO CENTROID in.	1.003	.980	1.019
MIN RADIUS	.332	.295	.352
MEAN RADIUS	.650	.597	.573
MAX RADIUS	.979	1.035	.942
HORIZONTAL SPREAD	1.904	1.816	1.653
VERTICAL SPREAD	1.085	1.085	1.085
EXTREME SPREAD	1.908	1.820	1.727
NUMBER IN ONE INCH CIRCLE =	4		
NUMBER IN TWO INCH CIRCLE =	10		
NUMBER IN THREE INCH CIRCLE =	10		

28 Nov 1988

FILE:/PATTERNING/CENTERFIRE_PATT/08225434

CENTERFIRE PATTERNS # 3



OF SHOTS - 10

IN CIR

1 in = 1

2 in = 5

3 in = 9

HS = 2.170

VS = 2.560

GS = 2.984

CENTROID *

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.835	.753	.576
MINIMUM X	:	-1.335	-1.417	-.413
MAXIMUM Y	:	1.597	1.198	1.143
MINIMUM Y	:	-.963	-.786	-.841
CENTROID X	:	.106	.188	.365
CENTROID Y	:	1.070	.893	.948
POA TO CENTROID in.	:	1.076	.912	1.016
MIN RADIUS	:	.492	.372	.286
MEAN RADIUS	:	1.012	.890	.798
MAX RADIUS	:	1.760	1.485	1.150
HORIZONTAL SPREAD	:	2.170	2.170	.989
VERTICAL SPREAD	:	2.560	1.984	1.984
EXTREME SPREAD	:	2.984	2.446	2.081
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

28 Nov 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C8225484

CENTERFIRE PATTERNS

4

POA

1 in circle

2 in circle

3 in circle

OF SHOTS = 10

IN CIR

1 in = 3

2 in = 6

3 in = 9

HS = 2.397

VS = 3.563

GS = 3.799

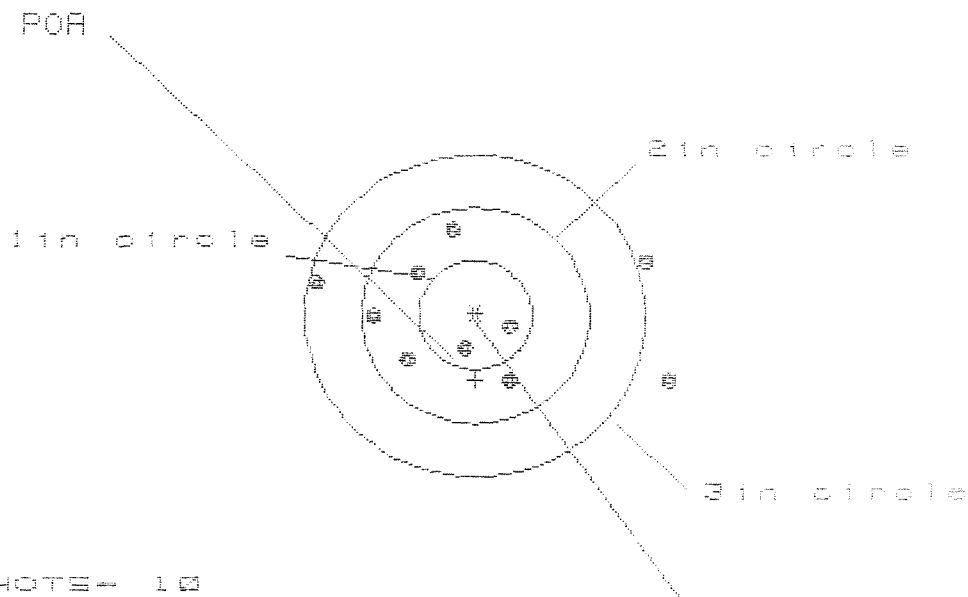
CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.423	1.315	.748
MINIMUM X	:	-.974	-.895	-.730
MAXIMUM Y	:	2.207	.977	.996
MINIMUM Y	:	-1.356	-1.111	-1.091
CENTROID X	:	.077	.185	.020
CENTROID Y	:	.639	.394	.374
POA TO CENTROID in.	:	.644	.435	.375
MIN RADIUS	:	.359	.099	.240
MEAN RADIUS	:	1.014	.807	.731
MAX RADIUS	:	2.412	1.325	1.235
HORIZONTAL SPREAD	:	2.397	2.210	1.478
VERTICAL SPREAD	:	3.563	2.088	2.088
EXTREME SPREAD	:	3.799	2.358	2.253
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

28 Nov 1988

FILE://PATTERNING/CENTERFIRE_PATT/06225494

CENTERFIRE PATTERNS # 5



OF SHOTS = 10

IN CIR

1in = 2

2in = 7

3in = 8

HS = 3.104

VS = 1.381

GS = 3.225

CENTROID *

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.728	1.679	1.685
MINIMUM X	-1.384	-1.193	-1.983
MAXIMUM Y	.758	.689	.745
MINIMUM Y	-.623	-.621	-.565
CENTROID X	-.002	-.193	-.482
CENTROID Y	.600	.669	.613
POA TO CENTROID in.	.600	.696	.733
MIN RADIUS	.303	.407	.432
MEAN RADIUS	.916	.791	.642
MAX RADIUS	1.829	1.737	1.012
HORIZONTAL SPREAD	3.104	2.872	1.669
VERTICAL SPREAD	1.381	1.310	1.310
EXTREME SPREAD	3.225	2.884	1.828
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	8		