

C5348715

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.



Remington®

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

DU PONT
REG. U.S. PAT. & TM. OFF.

MODEL 700™ H24

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

Ø1

SERIAL NO.	C6348715
ORDER NO.	5716



5716 C6348715

UPC



0 47700 25716 7



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: RE00133336

Serial: C6348715 Model M24 SWS Center Fire
Caliber: 308

Repairman:

Verify Repair

Status:

Closed 8/28/2007 1:49:21 PM

Address Information

Customer:

Received From

Return To:

Received From

Name: FB4484 305 APS/TRTC

FB4484 305 APS/TRTC

Address 1: 1757 VANDENBERG AVE

1757 VANDENBERG AVE

Address 2: PO Box:

PO Box:

City: MCGUIRE AFB

MCGUIRE AFB

State: NJ

Zip Code: 08641-5270

Country: US

State: NJ

Zip Code: 08641-5270

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	Qt
A007	With Stud	3
A010	Hard Case	1
A016	Scope Rings	2
A017	Scope Base	1
A026	Scope	1
B000	DEPLOYMENT KIT	1
B001	SCOPE CASE	1
R002	FRONT REAR BASE	1

Repair Search

Refresh

Close

nagletj

8/28/2007

2:11 PM

CAPS

NUM

INS

SCRL

start

3 Mi...

5 Int...

Micros...

Part S...

Arms ...

SAP L...

2:11 PM

Serial Number: C6348715

Model: M24 SWS



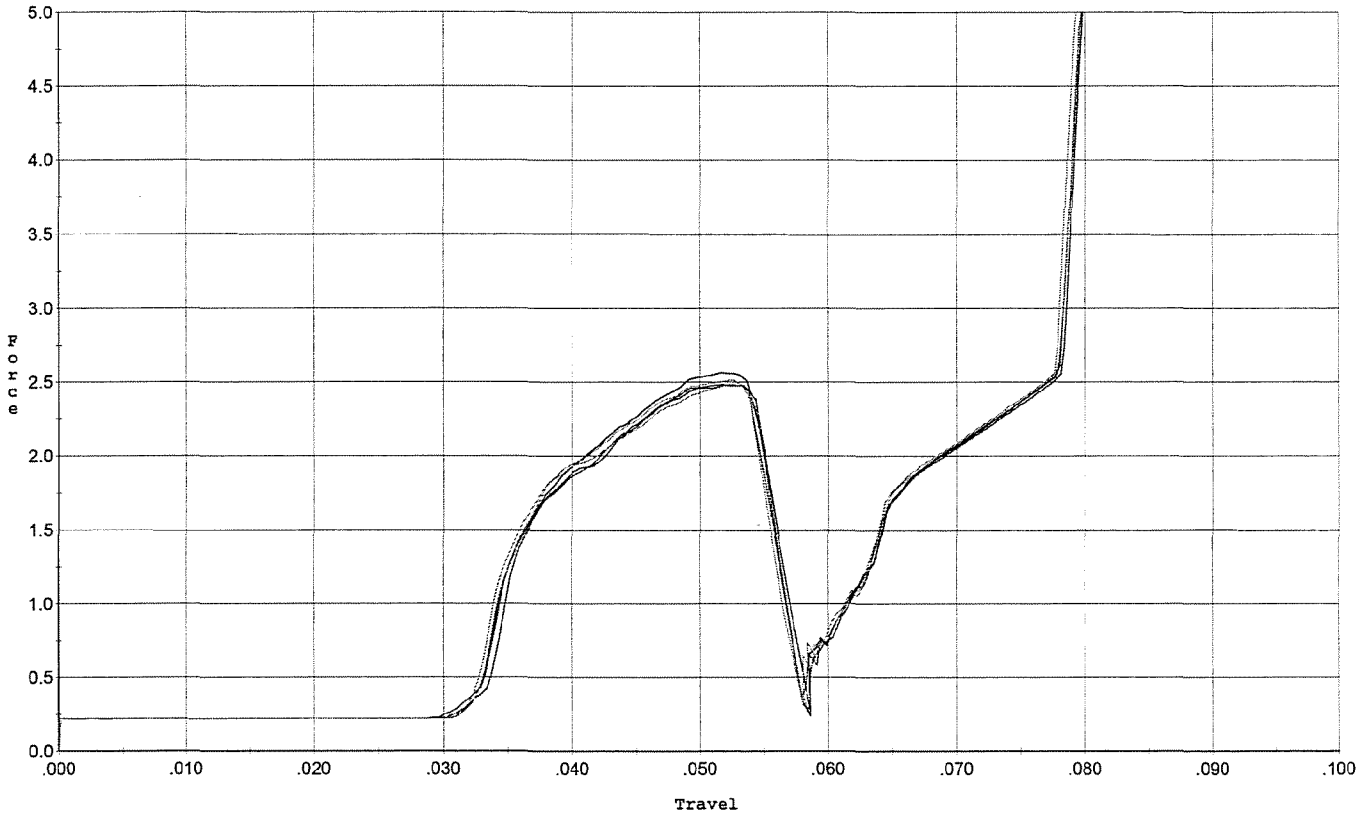
RE00133336

CONVERT TO
M24A2's (USAF
PROPERTY)

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 10/20/07

Model: M/24
Serial No: Form #F005
Trigger: 2.5 lbs. ini. +/- .50 lbs.



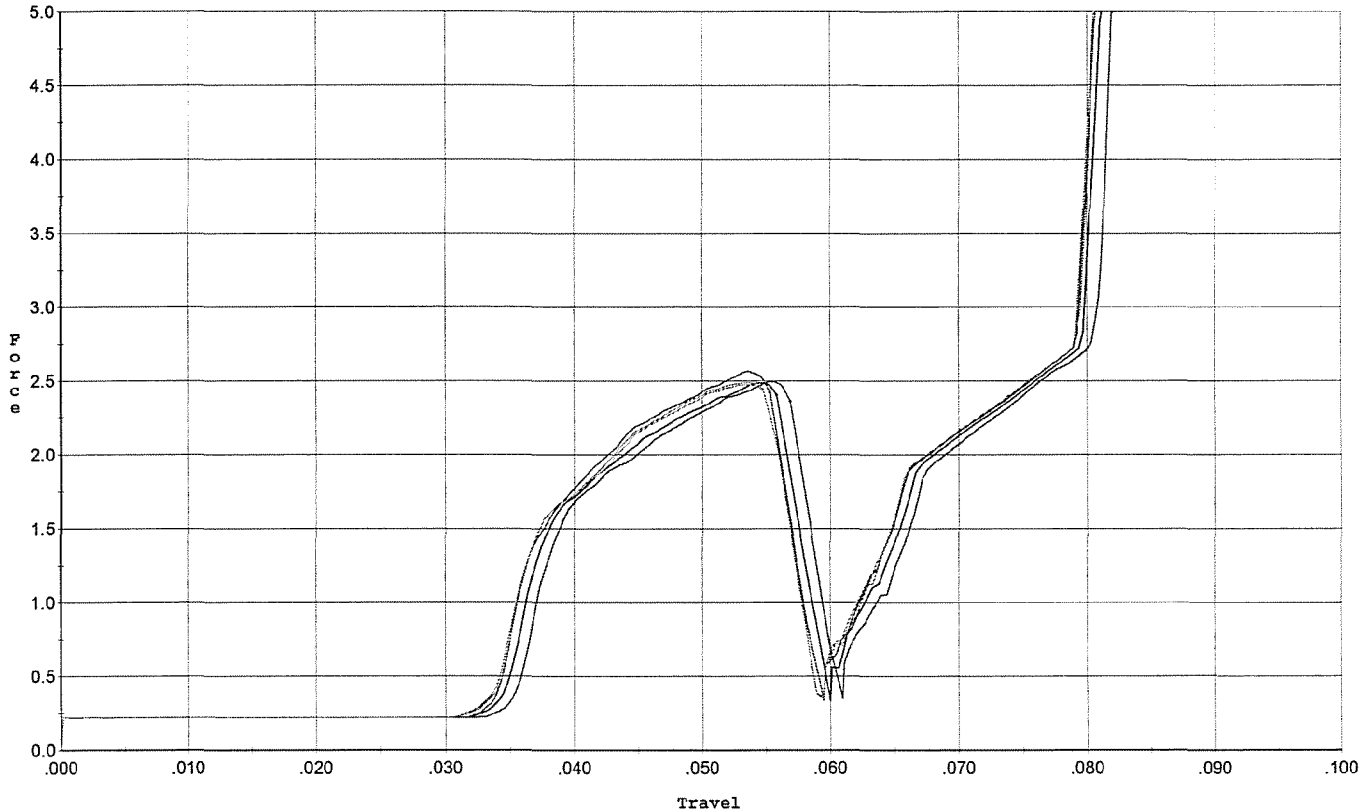
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.475	0.054	0.034	0.032	0.051		Set Trigger
2	2.564	0.055	0.033	0.031	0.053		Set Trigger
3	2.483	0.056	0.033	0.031	0.052		Set Trigger
4	2.512	0.054	0.032	0.032	0.051		Set Trigger
5	2.489	0.055	0.033	0.031	0.052		Set Trigger

Avg 2.50

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 10/20/07

Model: M/24
 Serial No: Form #F005
 Trigger: 2.5 lbs. after 50 cycles +/- .50 lbs.



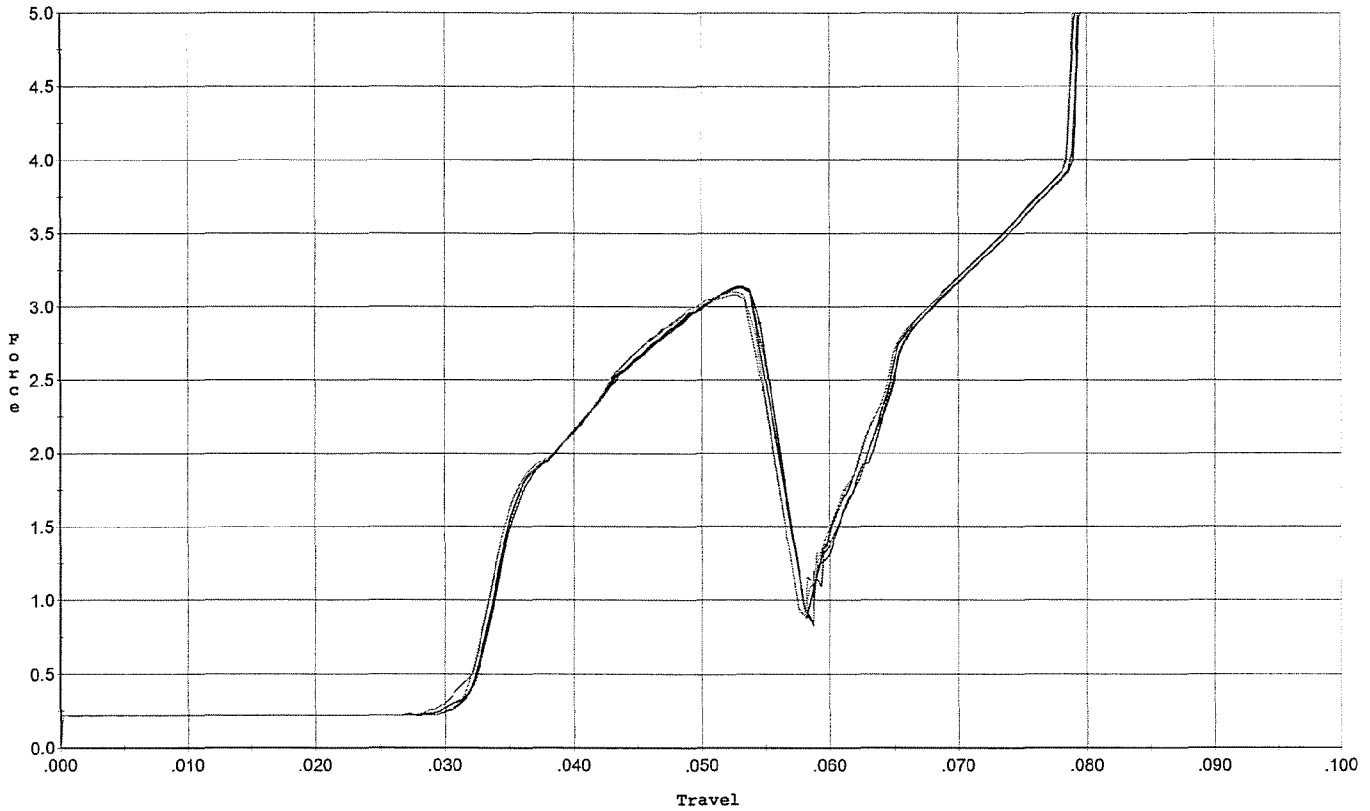
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.495	0.057	0.035	0.031	0.051		Set Trigger
2	2.487	0.056	0.035	0.031	0.051		Set Trigger
3	2.566	0.055	0.034	0.031	0.052		Set Trigger
4	2.474	0.056	0.034	0.031	0.051		Set Trigger
5	2.488	0.056	0.034	0.031	0.052		Set Trigger

AVG 2.50

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 10/20/07

Model: M/24
 Serial No: Form #F005
 Trigger: 3.0 lbs. ini. +/- .75 lbs.



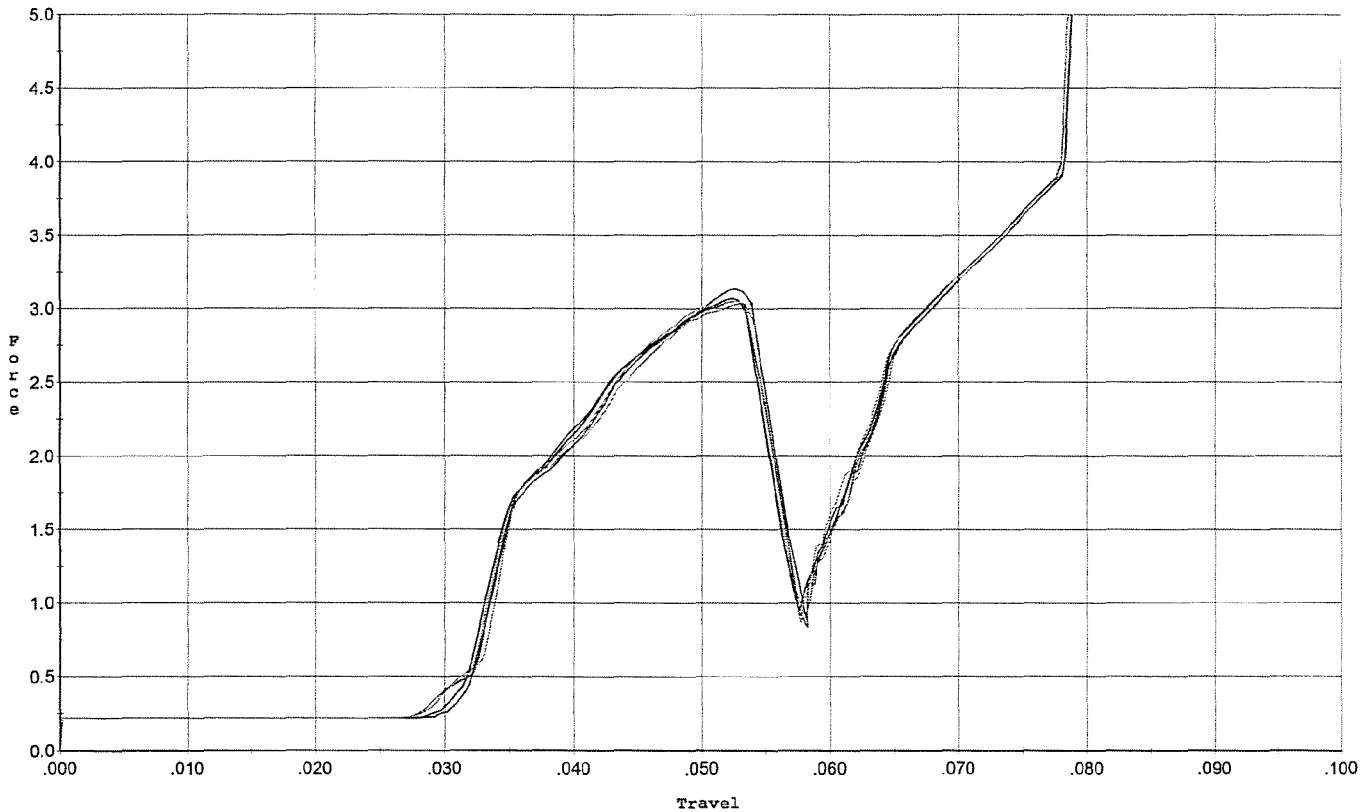
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.135	0.055	0.032	0.030	0.062		Set Trigger
2	3.139	0.056	0.032	0.030	0.063		Set Trigger
3	3.131	0.055	0.032	0.030	0.062		Set Trigger
4	3.100	0.054	0.033	0.030	0.062		Set Trigger
5	3.080	0.055	0.032	0.030	0.062		Set Trigger

Avg 3.11

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 10/20/07

Model: M/24
 Serial No: Form #F005
 Trigger: 3.0 lbs. after 20 cycles +/- .75 lbs.



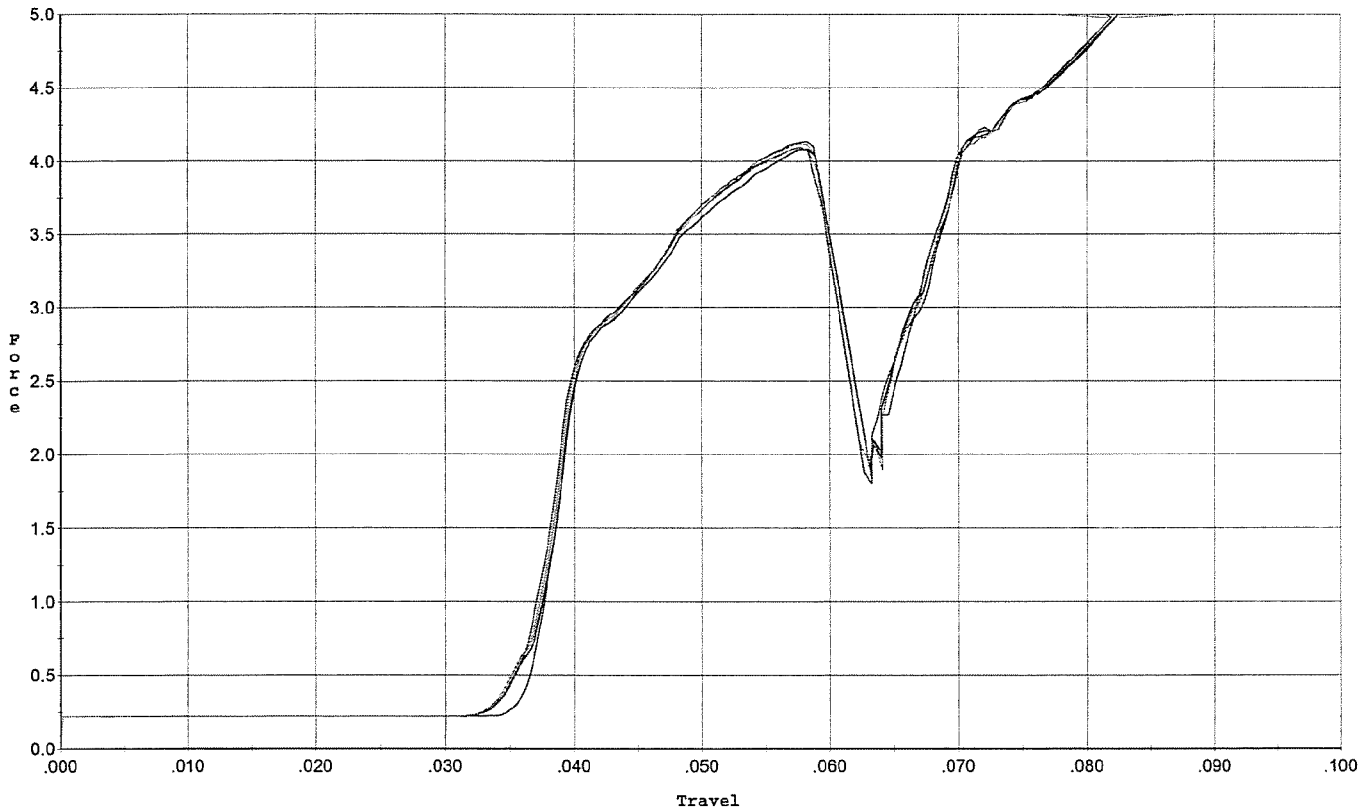
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.133	0.054	0.032	0.030	0.061		Set Trigger
2	3.069	0.053	0.032	0.030	0.060		Set Trigger
3	3.048	0.055	0.033	0.030	0.061		Set Trigger
4	3.049	0.053	0.032	0.030	0.060		Set Trigger
5	3.032	0.054	0.033	0.030	0.060		Set Trigger

Avg 3.06

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 10/20/07

Model: M/24
 Serial No: Form #F005
 Trigger: 4.0 lbs. ini. +/- 1.0 lbs.



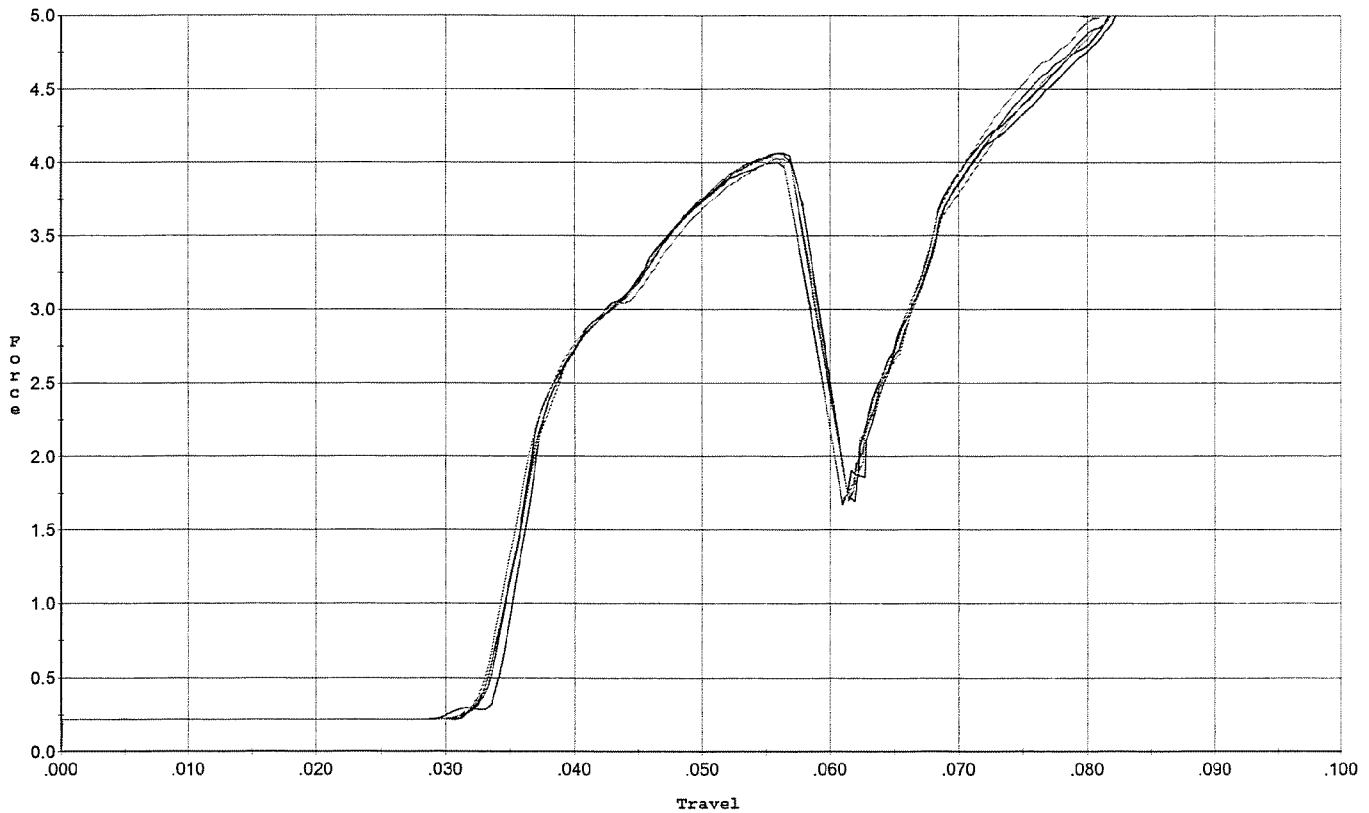
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.136	0.061	0.036	0.028	0.088		Set Trigger
2	4.081	0.061	0.035	0.028	0.087		Set Trigger
3	4.092	0.059	0.035	0.028	0.086		Set Trigger
4	4.091	0.059	0.035	0.028	0.085		Set Trigger
5	4.118	0.061	0.035	0.028	0.089		Set Trigger

AVG 4.10

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 10/20/07

Model: M/24
 Serial No: Form #F005
 Trigger: 4.0 lbs. after 20 cycles +/- 1.0 lbs.



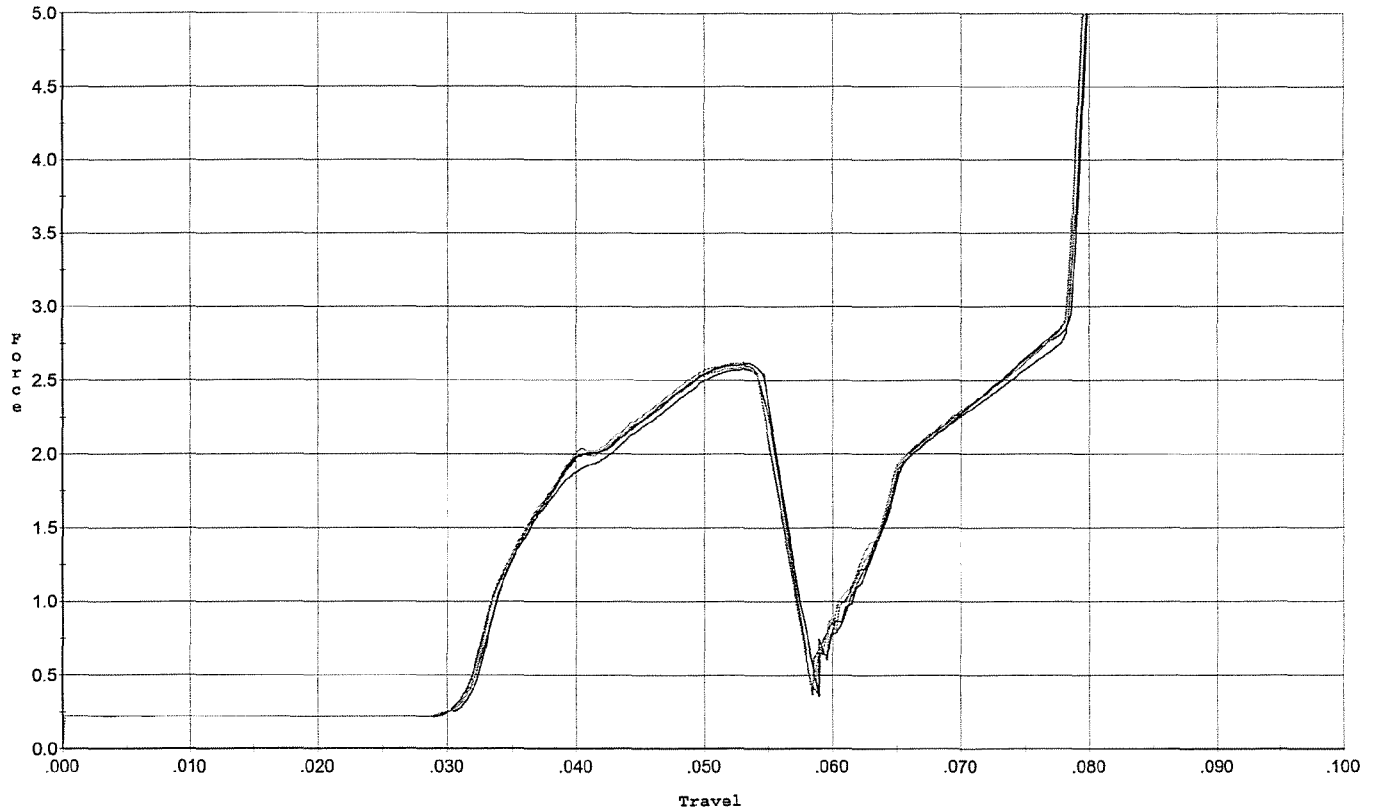
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.066	0.058	0.034	0.028	0.085		Set Trigger
2	3.999	0.058	0.033	0.028	0.085		Set Trigger
3	4.065	0.057	0.033	0.028	0.083		Set Trigger
4	4.038	0.059	0.032	0.028	0.086		Set Trigger
5	4.026	0.059	0.033	0.028	0.086		Set Trigger

Avg 4.03

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 10/20/07

Model: M/24
Serial No: Form #F005
Trigger: reset to 2.5 lbs. +/- .50 lbs. for final test



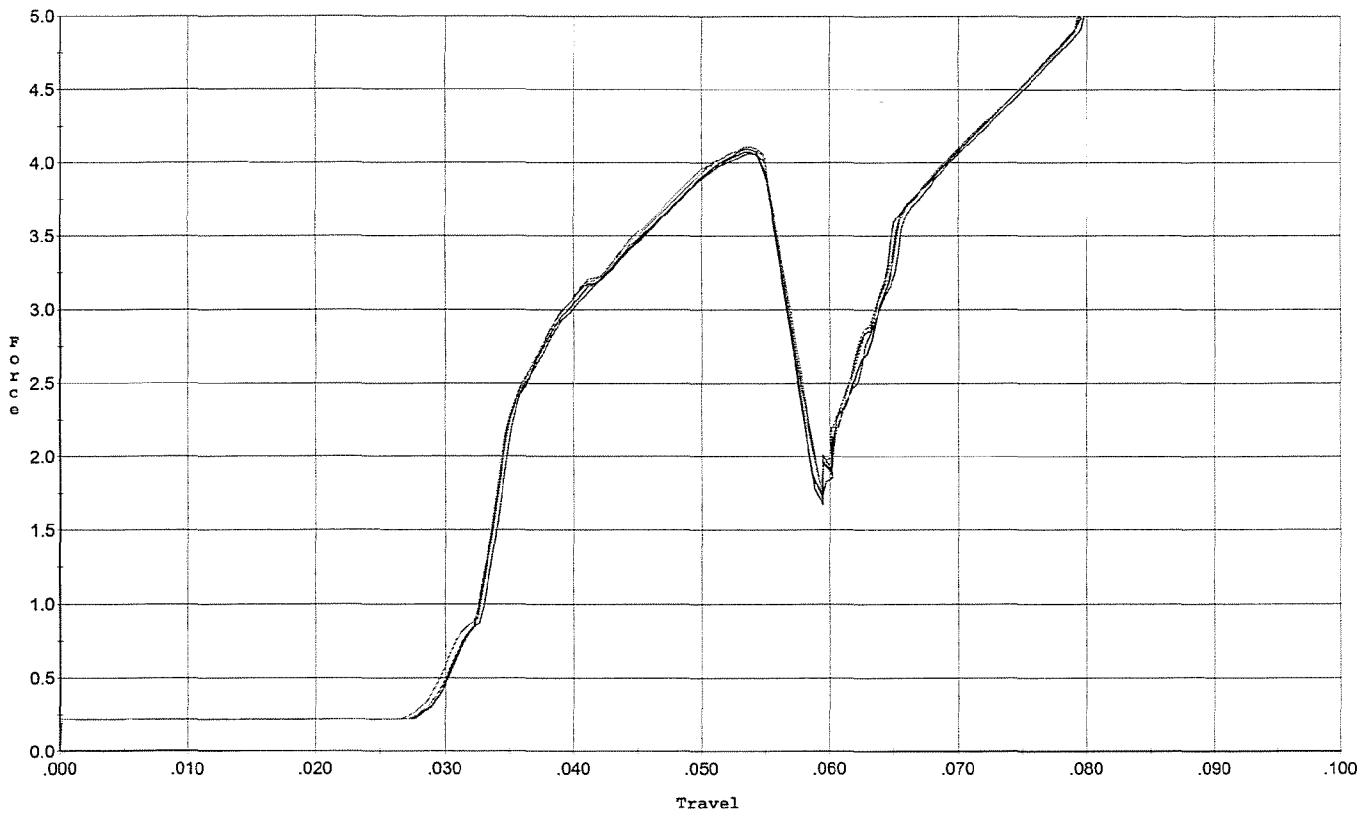
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.572	0.055	0.032	0.031	0.054		Set Trigger
2	2.618	0.055	0.032	0.031	0.054		Set Trigger
3	2.605	0.054	0.031	0.031	0.053		Set Trigger
4	2.612	0.056	0.032	0.031	0.056		Set Trigger
5	2.586	0.056	0.032	0.031	0.055		Set Trigger

Avg 2.59

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: R. Putch 10/20/07

Model: M/24
Serial No: Form #F005
Trigger: set to 4.0 lbs. +/- 1.0 lbs. for target & accuracy



#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.090	0.055	0.030	0.028	0.085		Set Trigger
2	4.072	0.055	0.030	0.028	0.084		Set Trigger
3	4.064	0.055	0.030	0.028	0.084		Set Trigger
4	4.103	0.057	0.030	0.028	0.089		Set Trigger
5	4.107	0.055	0.029	0.028	0.085		Set Trigger

Avg 4.08

APD PE v1.10

NMP COPY 2

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6348715.__0
FILE DATE AND TIME: 10/31/2007 21:48

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.150
The Average Y Centroid of the Five Target Set:	-0.031
The Average Point of Impact of the Five Target Set:	0.153
The Average Mean Radius of the Five Target Set:	0.665
The Distance from POA to Centroid Target #1:	0.115
The Distance from Centroid Target #2 to Centroid Target #1:	0.111
The Distance from Centroid Target #3 to Centroid Target #1:	0.248
The Distance from Centroid Target #4 to Centroid Target #1:	0.197
The Distance from Centroid Target #5 to Centroid Target #1:	0.259

BARBER - M24 0062150

SERIAL NUMBER: C6348715. __0

TARGET NUMBER: 1

FILE DATE: 10/31/2007

FILE TIME: 21:48

POINT#	X	Y
1:	0.626	0.892
2:	0.010	0.744
3:	-0.042	0.394
4:	0.122	0.246
5:	-0.380	0.223
6:	-0.569	0.235
7:	-0.021	-0.396
8:	0.327	-0.626
9:	-0.118	-0.814
10:	0.904	-0.139

X CENTROID: 0.086

Y CENTROID: 0.076

POA TO CENTROID: 0.115

HORZ SPREAD: 1.473

VERT SPREAD: 1.706

GROUP SPREAD: 1.861

MIN RADIUS: 0.174

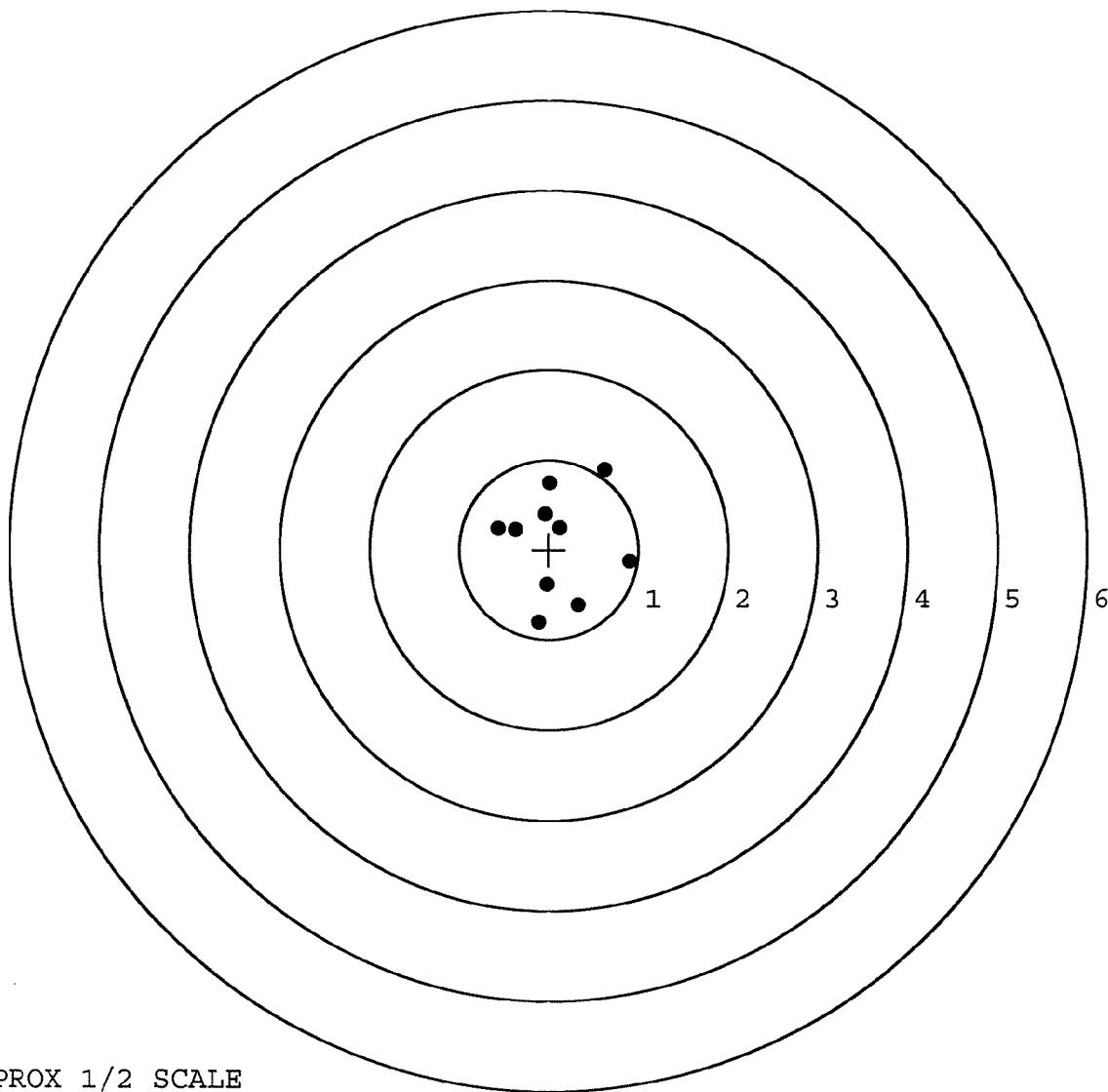
MAX RADIUS: 0.979

MEAN RADIUS: 0.632

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

BARBER - M24 0062151

SERIAL NUMBER: C6348715. __0

TARGET NUMBER: 2

FILE DATE: 10/31/2007

FILE TIME: 21:48

POINT#	X	Y
1:	0.847	0.405
2:	1.097	0.250
3:	0.334	0.432
4:	0.274	0.161
5:	0.024	0.075
6:	-0.036	-0.117
7:	0.322	-0.817
8:	-0.967	-0.718
9:	-0.878	-0.101
10:	0.209	0.144

X CENTROID: 0.123

Y CENTROID: -0.029

POA TO CENTROID: 0.126

HORZ SPREAD: 2.064

VERT SPREAD: 1.249

GROUP SPREAD: 2.280

MIN RADIUS: 0.143

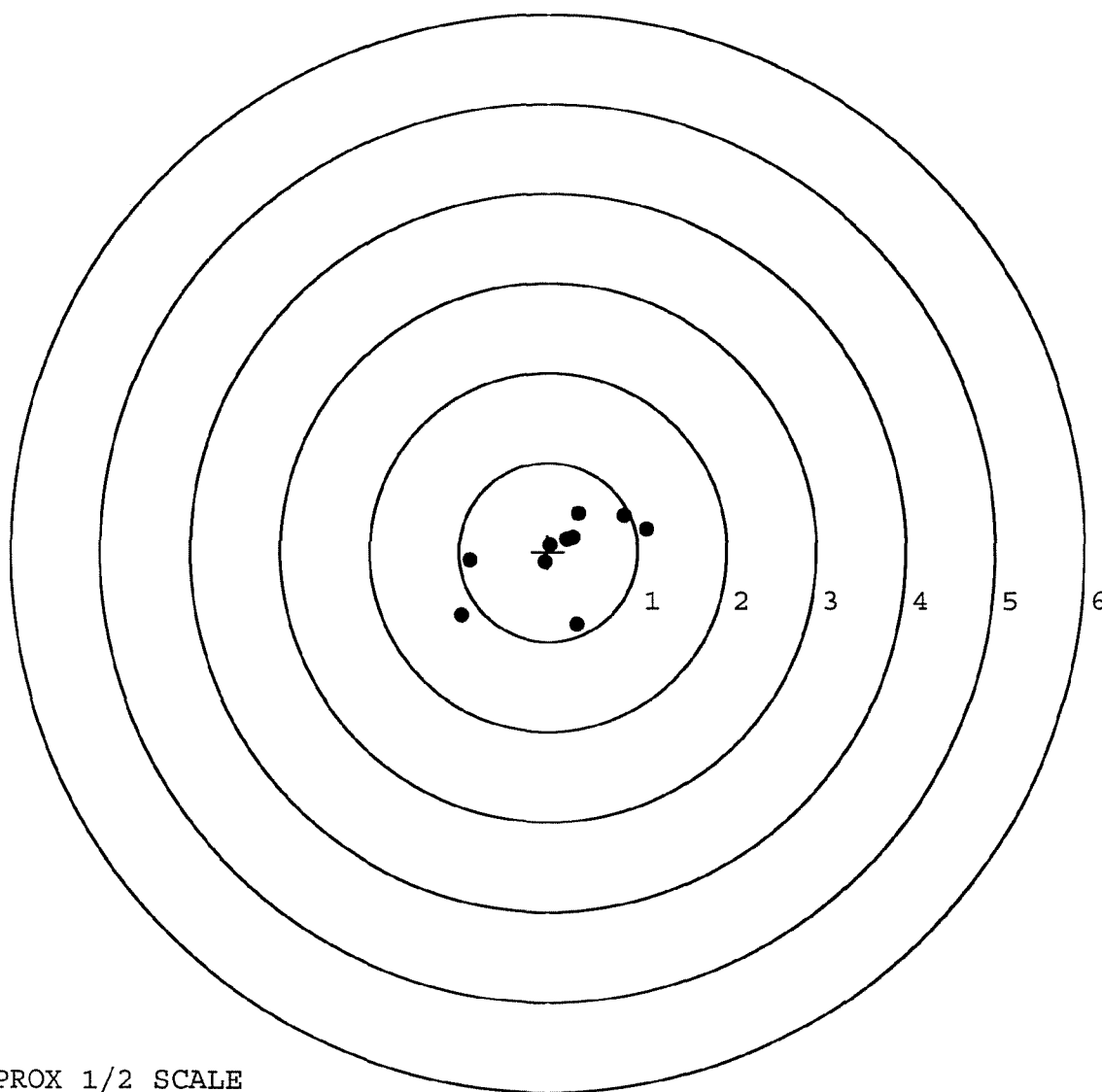
MAX RADIUS: 1.289

MEAN RADIUS: 0.623

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

BARBER - M24 0062152

SERIAL NUMBER: C6348715. __0

TARGET NUMBER: 3

FILE DATE: 10/31/2007

FILE TIME: 21:48

POINT#	X	Y
1:	-0.092	0.350
2:	-0.172	0.023
3:	-0.395	0.323
4:	0.180	-0.401
5:	0.316	-0.151
6:	0.540	0.088
7:	0.782	-0.244
8:	1.217	-0.194
9:	1.204	0.692
10:	-0.242	0.211

X CENTROID: 0.334

Y CENTROID: 0.070

POA TO CENTROID: 0.341

HORZ SPREAD: 1.612

VERT SPREAD: 1.093

GROUP SPREAD: 1.641

MIN RADIUS: 0.207

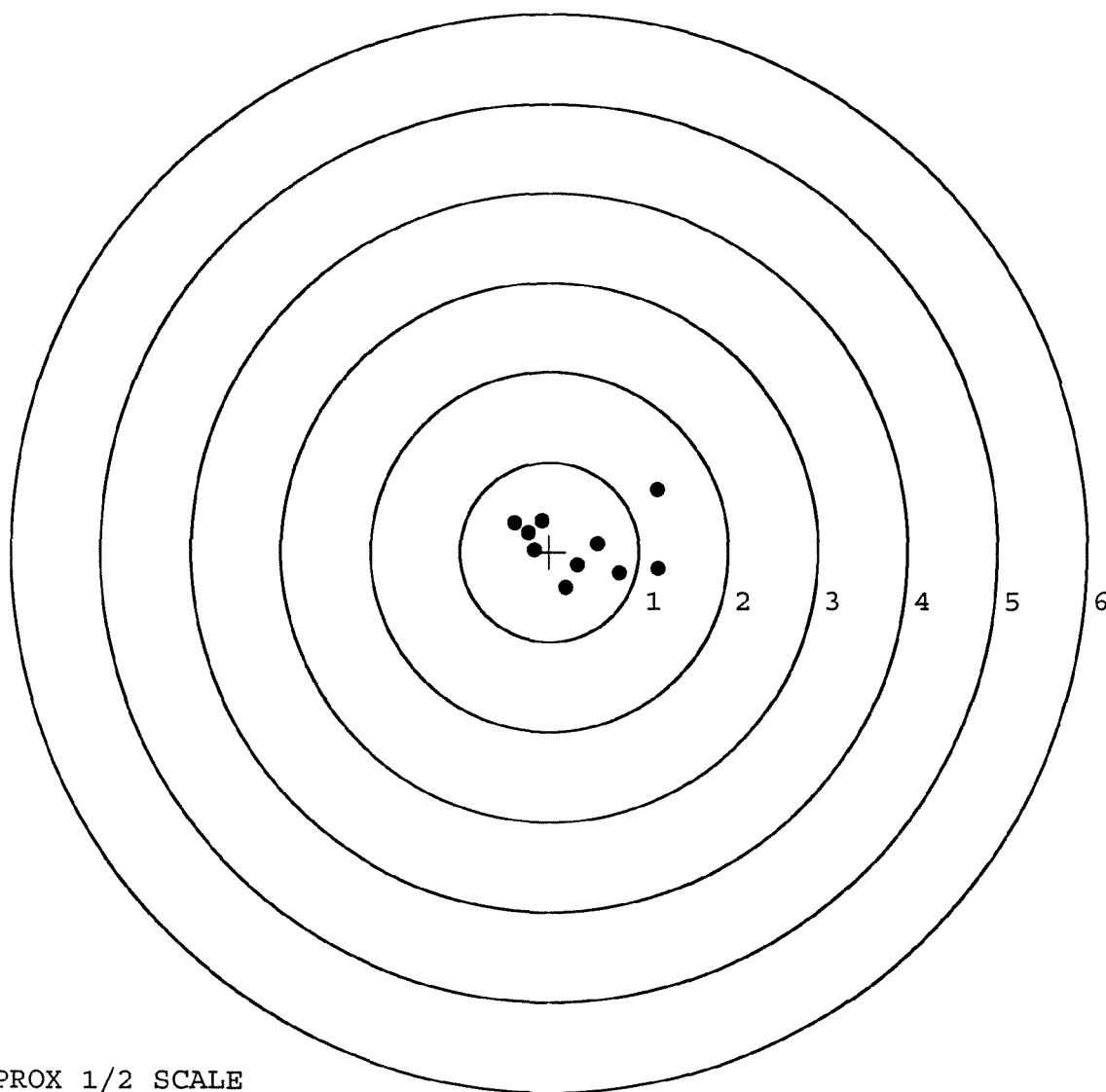
MAX RADIUS: 1.070

MEAN RADIUS: 0.584

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10



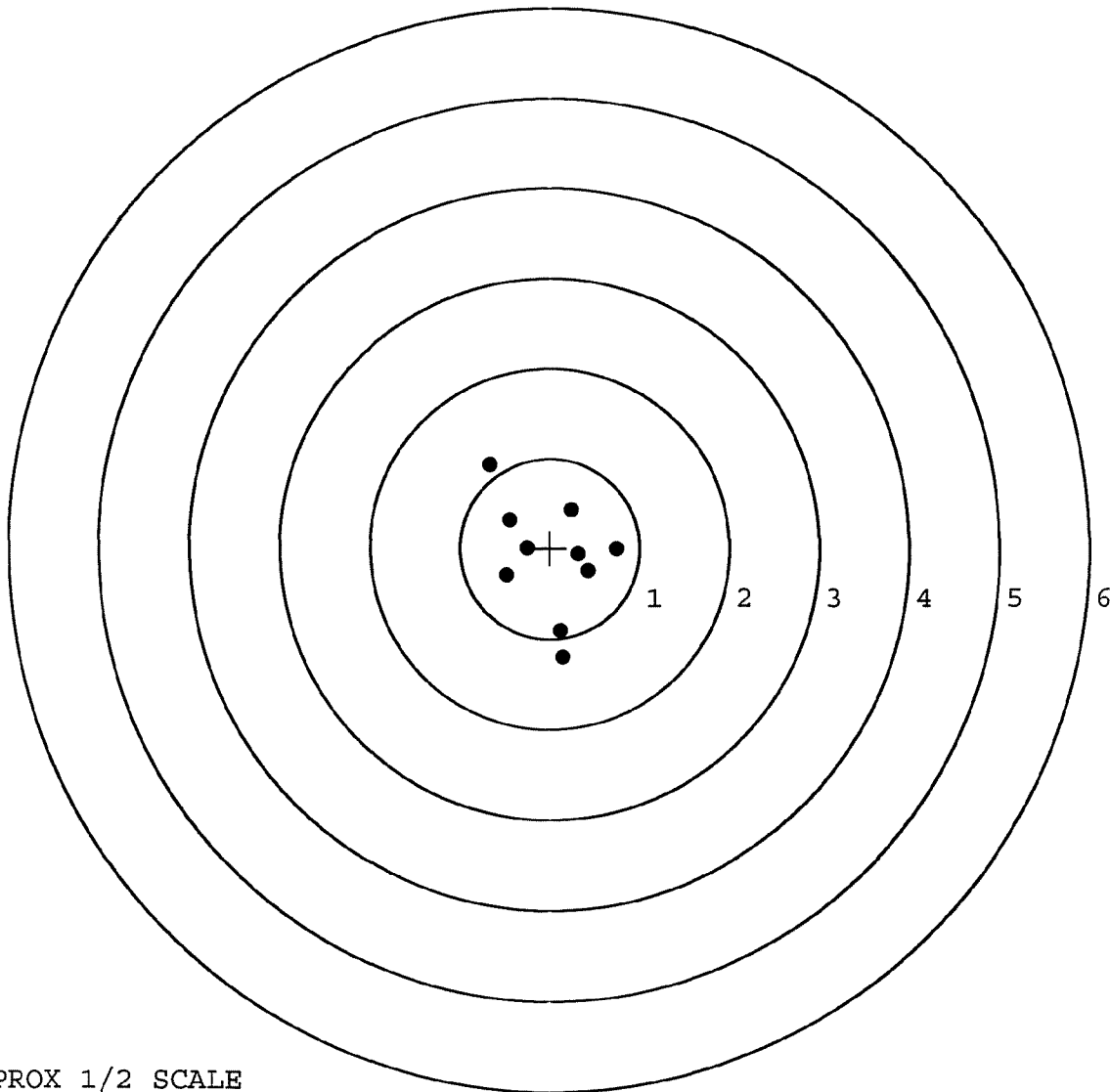
TARGET APPROX 1/2 SCALE

BARBER - M24 0062153

SERIAL NUMBER: C6348715. __0
 TARGET NUMBER: 4
 FILE DATE: 10/31/2007
 FILE TIME: 21:48

POINT#	X	Y
1:	-0.662	0.929
2:	-0.444	0.319
3:	0.253	0.427
4:	0.744	-0.013
5:	0.427	-0.259
6:	0.319	-0.072
7:	-0.258	0.005
8:	-0.483	-0.302
9:	0.123	-0.915
10:	0.150	-1.209

X CENTROID: 0.017
 Y CENTROID: -0.109
 POA TO CENTROID: 0.110
 HORZ SPREAD: 1.406
 VERT SPREAD: 2.138
 GROUP SPREAD: 2.287
 MIN RADIUS: 0.298
 MAX RADIUS: 1.240
 MEAN RADIUS: 0.668
 # IN 1 IN DIAMETER: 3
 # IN 2 IN DIAMETER: 8
 # in 3 IN DIAMETER: 10



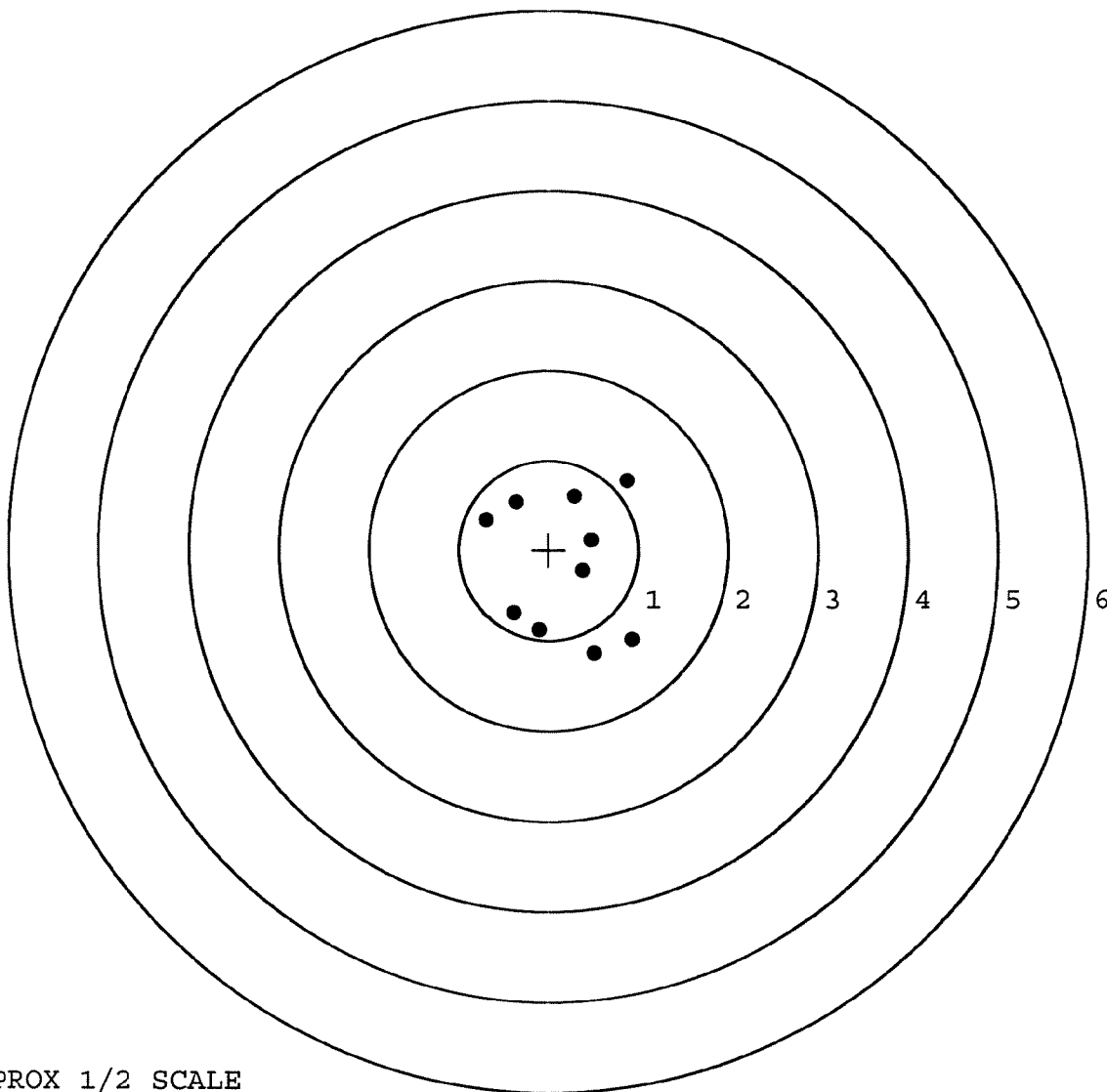
TARGET APPROX 1/2 SCALE

BARBER - M24 0062154

SERIAL NUMBER: C6348715. __0
 TARGET NUMBER: 5
 FILE DATE: 10/31/2007
 FILE TIME: 21:48

POINT#	X	Y
1:	-0.699	0.339
2:	-0.361	0.538
3:	0.288	0.605
4:	0.876	0.776
5:	0.478	0.108
6:	0.384	-0.236
7:	-0.391	-0.701
8:	-0.107	-0.892
9:	0.510	-1.148
10:	0.933	-0.996

X CENTROID: 0.191
 Y CENTROID: -0.161
 POA TO CENTROID: 0.250
 HORZ SPREAD: 1.632
 VERT SPREAD: 1.924
 GROUP SPREAD: 1.959
 MIN RADIUS: 0.207
 MAX RADIUS: 1.160
 MEAN RADIUS: 0.818
 # IN 1 IN DIAMETER: 2
 # IN 2 IN DIAMETER: 6
 # in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

R & E NUMBER		133336	
SERIAL NUMBER		C6348715	
LOG-IN DATE		10-22-07 8-28-07	
OPERATION #	OPERATION NAME	DATE	INITIAL
500	DIS-ASSEMBLE GUN	10-22-07	RTZ
505	RE-BARREL	10-22-07	RTZ
560	ASSEMBLE	10-22-07	RTZ
600	PROOF	10-22-07	TRW
605	CHECK HEADSPACE	10-22-07	TRW
610	DIS-ASSEMBLE GUN	10-23-07	RTZ
612	MAGNAFLUX	10-24-07	JB
510	DRILL AND TAP		
615	ROLLMARK CALIBER	10-23-07	CW
618	ROTO-BLAST	10-24-07	RG
620	APPLY COATINGS	10-25-07	RB
625	FINAL ASSEMBLY	10-31-07	RTZ
640	FUNCTION TEST AND	PASS FAIL	10/31/07
650	TARGET	PASS FAIL	10/31/07
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
670	FINAL INSPECTION		
	A) HEADSPACE	PASS FAIL	
	B) TRIGGER PULL	2.78 2.80 2.69 2.76 2.81 11-6-07	RA
680	F) SAFETY ON FORCE	5.2 4.5 4.5 11-6-07	RA
	G) SAFETY OFF FORCE	3.5 3.2 3.2 11-6-07	RA
	I) FIRING PIN INDENT	.021 .021 .021 11-6-07	RA
690	PACK		11-30-07

Repair Inquiry

Repair Number: **RE00087786**Serial: C6348715 Model: M24 SWS Center Fire
Caliber: 7.62 NATO

Repairman:

Status:

Closed 11/11/2004 10:19:57 AM

Address Information

Customer:

☒ Received From

Return To:

☐ Received FromName: **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**

FPL:

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	FAND R SGT BASES	1

Repair Search

Refresh

Close

negletj

11/11/2004

11:22 AM

CAPS

NUM

INS

SCPL

start

3

4

4

4

4

4

4

4

4

4

Serial Number: **C6348715**
 Model: **M24 SWS**
RE00087786

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6348715.__0
FILE DATE AND TIME: 12/08/2004 07:47

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.076
The Average Y Centroid of the Five Target Set:	0.008
The Average Point of Impact of the Five Target Set:	0.076
The Average Mean Radius of the Five Target Set:	0.745
The Distance from POA to Centroid Target #1:	0.232
The Distance from Centroid Target #2 to Centroid Target #1:	0.064
The Distance from Centroid Target #3 to Centroid Target #1:	0.263
The Distance from Centroid Target #4 to Centroid Target #1:	0.347
The Distance from Centroid Target #5 to Centroid Target #1:	0.231

SERIAL NUMBER: C6348715. __0

TARGET NUMBER: 1

FILE DATE: 12/08/2004

FILE TIME: 07:47

POINT#	X	Y
1:	0.553	1.303
2:	0.371	0.821
3:	0.395	0.552
4:	0.115	0.128
5:	-0.237	0.620
6:	-0.728	0.797
7:	-1.318	-0.355
8:	-1.059	-0.763
9:	-0.329	-0.908
10:	0.204	-1.078

X CENTROID: -0.203

Y CENTROID: 0.112

POA TO CENTROID: 0.232

HORZ SPREAD: 1.871

VERT SPREAD: 2.381

GROUP SPREAD: 2.620

MIN RADIUS: 0.319

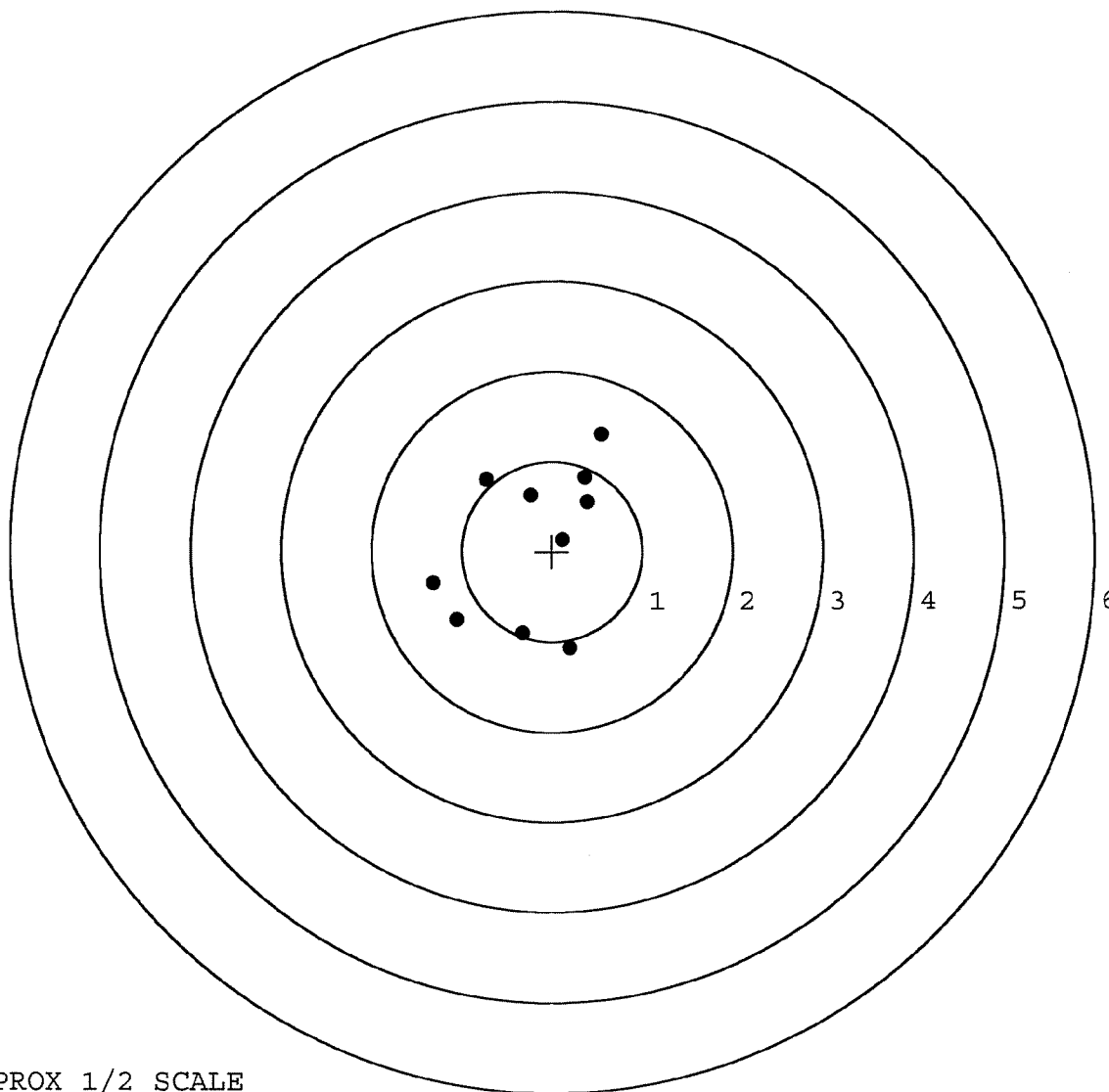
MAX RADIUS: 1.411

MEAN RADIUS: 0.947

IN 1 IN DIAMETER: 1

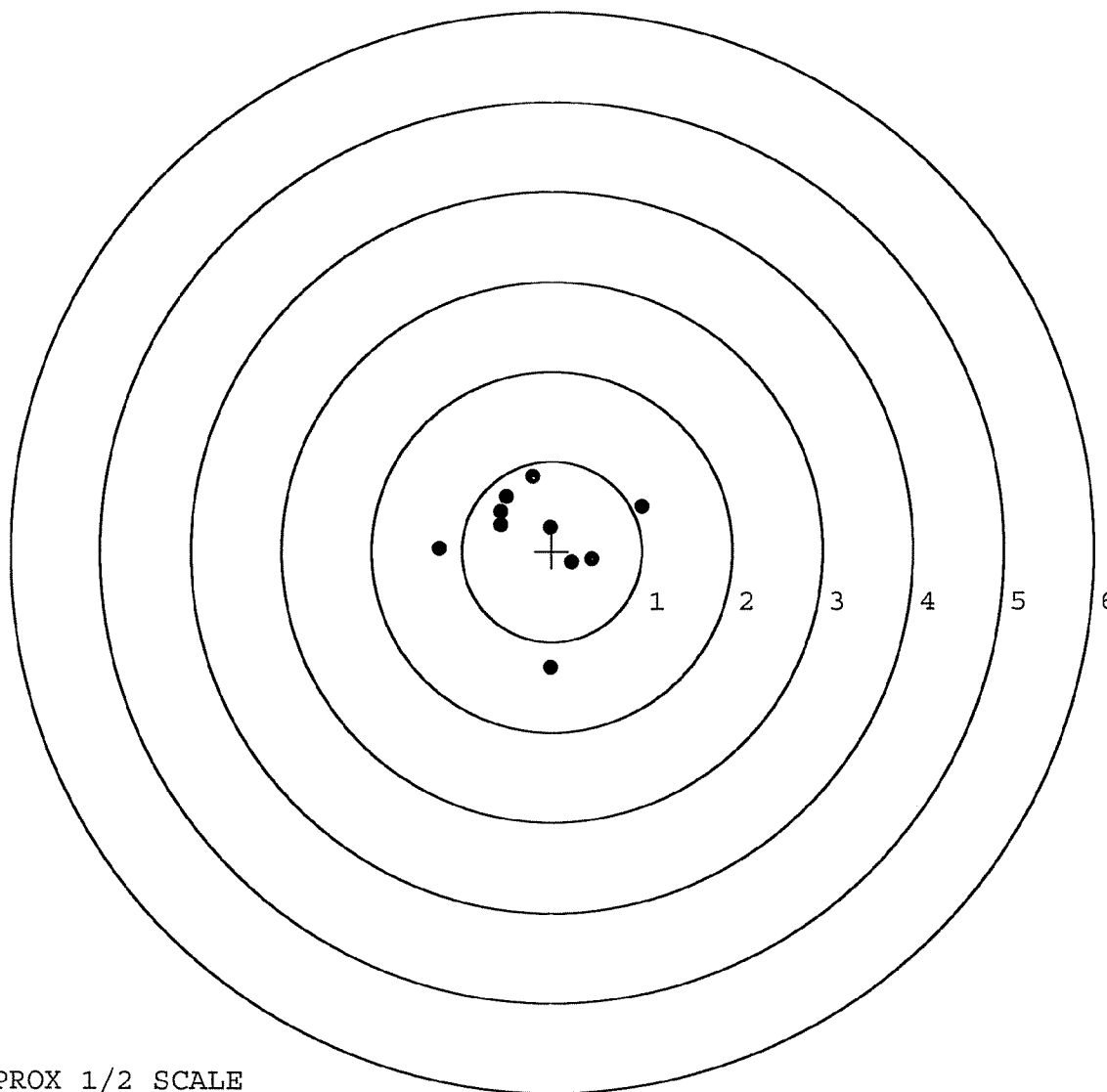
IN 2 IN DIAMETER: 5

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6348715. __0	POINT#	X	Y
TARGET NUMBER: 2	1:	-0.018	-1.289
FILE DATE: 12/08/2004	2:	0.999	0.500
FILE TIME: 07:47	3:	-0.214	0.828
	4:	-0.023	0.266
X CENTROID: -0.149	5:	0.446	-0.089
Y CENTROID: 0.145	6:	0.222	-0.124
POA TO CENTROID: 0.208	7:	-0.507	0.605
HORZ SPREAD: 2.248	8:	-0.572	0.439
VERT SPREAD: 2.117	9:	-0.572	0.288
GROUP SPREAD: 2.126	10:	-1.249	0.028
MIN RADIUS: 0.174			
MAX RADIUS: 1.440			
MEAN RADIUS: 0.725			
# IN 1 IN DIAMETER: 3			
# IN 2 IN DIAMETER: 7			
# in 3 IN DIAMETER: 10			



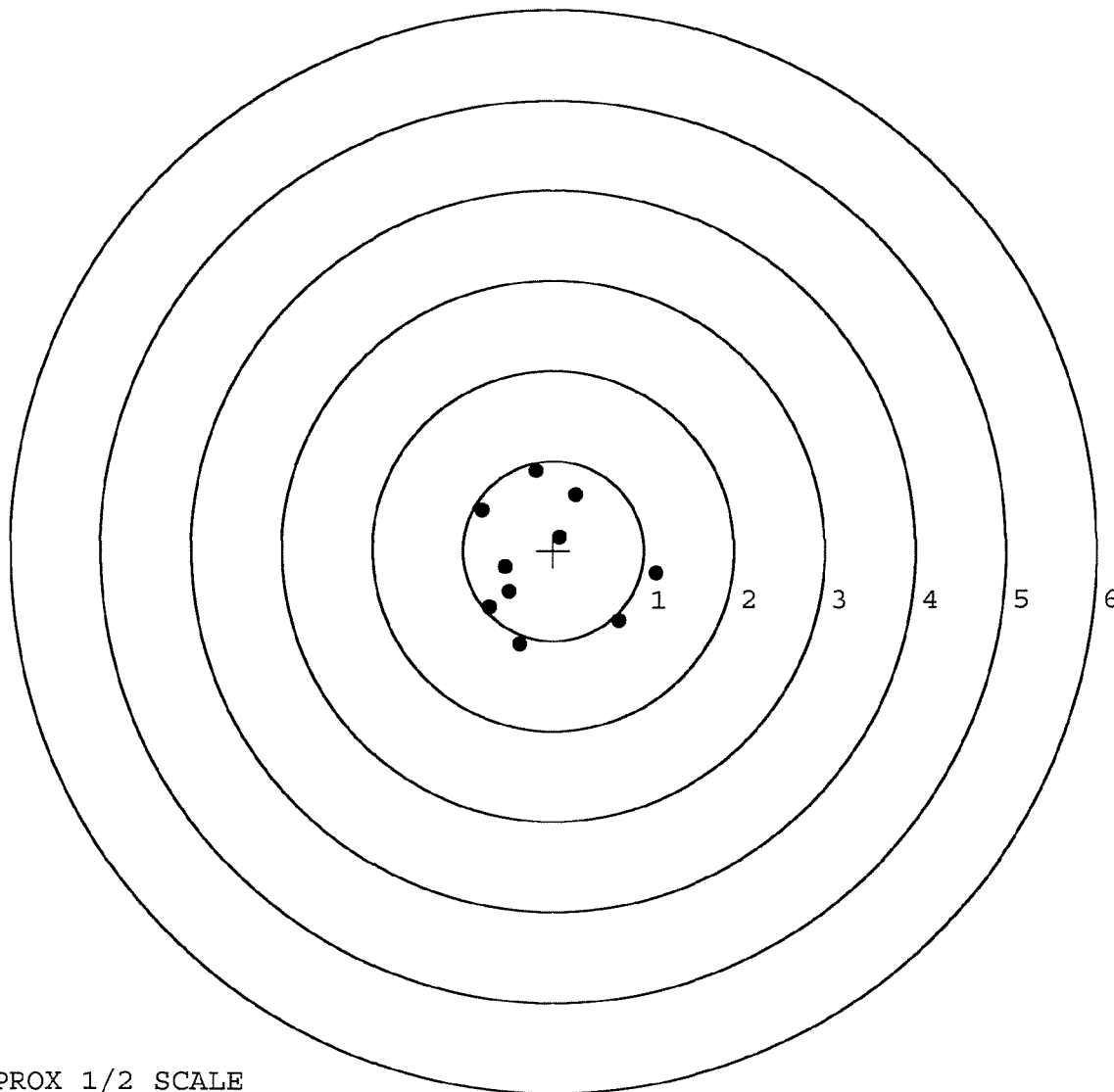
TARGET APPROX 1/2 SCALE

BARBER - M24 0062160

SERIAL NUMBER: C6348715. __0
 TARGET NUMBER: 3
 FILE DATE: 12/08/2004
 FILE TIME: 07:47

POINT#	X	Y
1:	1.134	-0.254
2:	0.727	-0.782
3:	-0.371	-1.040
4:	-0.711	-0.634
5:	-0.491	-0.465
6:	-0.534	-0.188
7:	0.073	0.149
8:	0.255	0.621
9:	-0.194	0.888
10:	-0.790	0.448

X CENTROID: -0.090
 Y CENTROID: -0.126
 POA TO CENTROID: 0.155
 HORZ SPREAD: 1.924
 VERT SPREAD: 1.928
 GROUP SPREAD: 2.048
 MIN RADIUS: 0.320
 MAX RADIUS: 1.231
 MEAN RADIUS: 0.808
 # IN 1 IN DIAMETER: 2
 # IN 2 IN DIAMETER: 7
 # in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

BARBER - M24 0062161

SERIAL NUMBER: C6348715. __0

TARGET NUMBER: 4

FILE DATE: 12/08/2004

FILE TIME: 07:47

POINT#	X	Y
1:	1.033	-0.829
2:	0.019	-0.755
3:	-1.000	0.407
4:	-0.587	-0.480
5:	0.750	0.442
6:	0.511	0.133
7:	0.204	0.080
8:	-0.119	-0.073
9:	0.106	0.490
10:	0.194	0.238

X CENTROID: 0.111

Y CENTROID: -0.035

POA TO CENTROID: 0.116

HORZ SPREAD: 2.033

VERT SPREAD: 1.319

GROUP SPREAD: 2.379

MIN RADIUS: 0.148

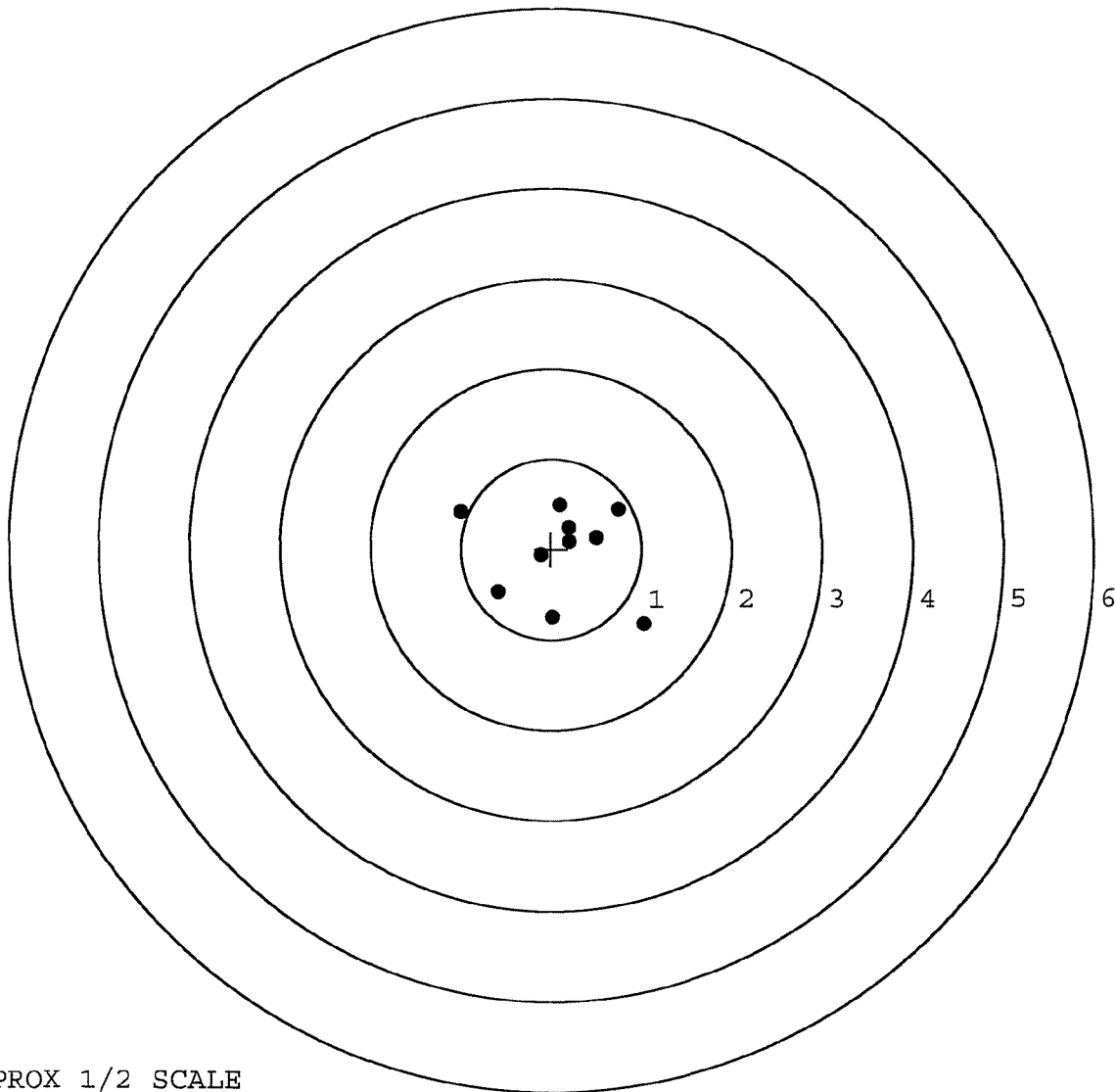
MAX RADIUS: 1.217

MEAN RADIUS: 0.639

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10



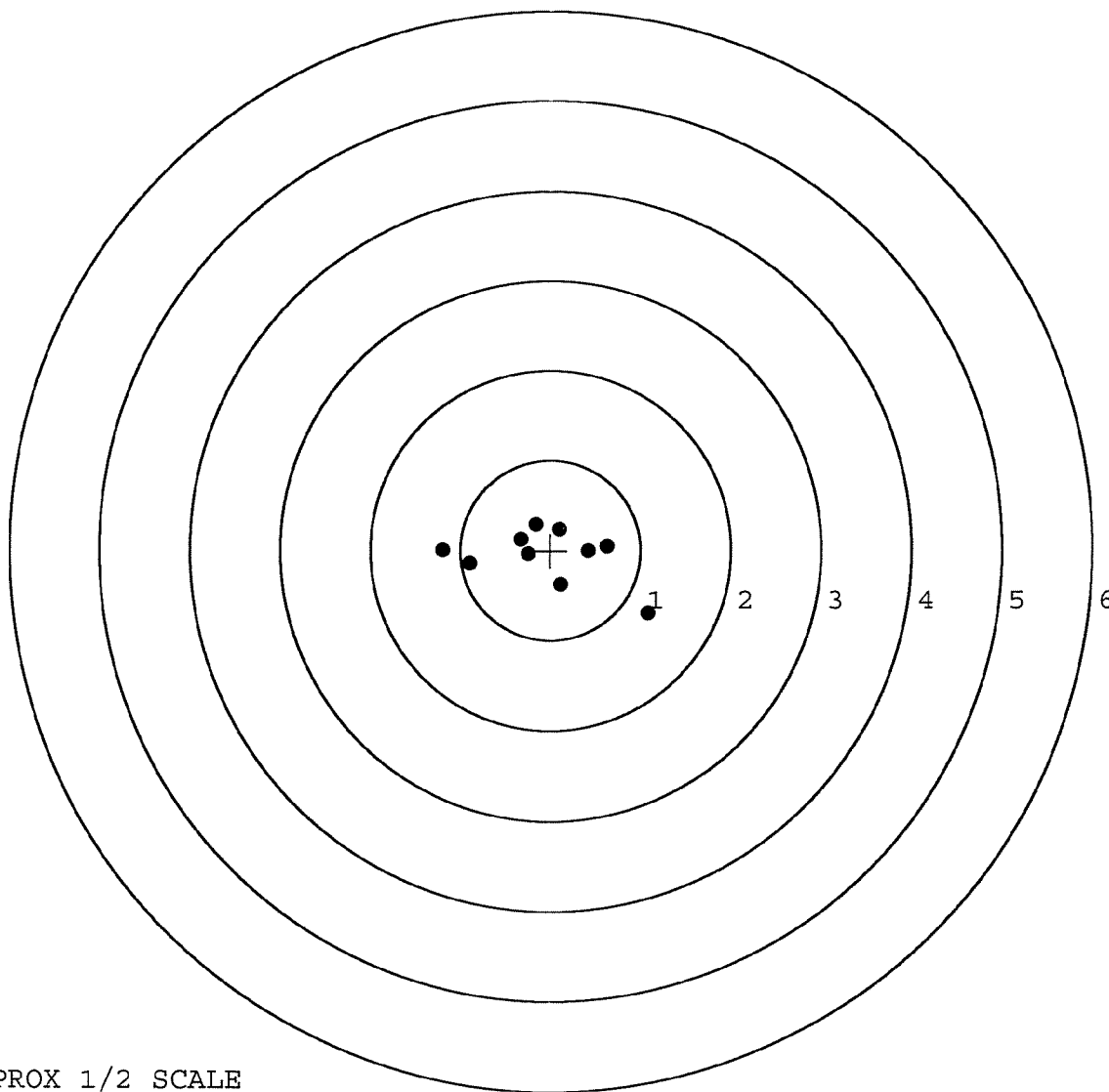
TARGET APPROX 1/2 SCALE

BARBER - M24 0062162

SERIAL NUMBER: C6348715. __0
 TARGET NUMBER: 5
 FILE DATE: 12/08/2004
 FILE TIME: 07:47

POINT#	X	Y
1:	1.086	-0.702
2:	-0.895	-0.150
3:	-1.196	0.005
4:	0.630	0.049
5:	0.426	-0.013
6:	0.104	0.236
7:	-0.163	0.291
8:	-0.329	0.124
9:	-0.250	-0.042
10:	0.119	-0.386

X CENTROID: -0.047
 Y CENTROID: -0.059
 POA TO CENTROID: 0.075
 HORZ SPREAD: 2.282
 VERT SPREAD: 0.993
 GROUP SPREAD: 2.389
 MIN RADIUS: 0.204
 MAX RADIUS: 1.303
 MEAN RADIUS: 0.607
 # IN 1 IN DIAMETER: 6
 # IN 2 IN DIAMETER: 8
 # in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

FINAL INSPECTION CHECKLIST M-24 REPAIRS

CONTRACT #: DAAE-20-02-D-0127

SERIAL # <u>C 6348715</u>		INSPECTED BY: <u>AC</u>	
DATE REC'D: <u>11-11-04</u>		DATE RET'D: <u>12-9-04</u>	
ITEM		ITEM	
BARREL ASSEMBLY		STOCK ASSEMBLY	
☒	BARREL	☒	STOCK
☒	RECEIVER	☒	SLING AWIVEL STUDS
☐	FRONT SIGHT BASE	☒	ADJUSTABLE
☐	REAR SIGHT BASE	☒	BUTT PLATE
☐	SCREWS	☒	LOCK NUTS
☒	FINISH	☒	BARREL CLEARANCE
☐		☒	COLOR / FINISH
SCOPE ASSEMBLY		SYSTEMS CASE	
☐	SCOPE	☐	SCOPE CASE
☐	SCOPE RINGS	☐	IRON SIGHTS
☐	MOUNTING SCREWS	☐	DEPLOYMENT KIT
☐	MOUNTING BASE		
☐	SCREWS		
☐	FINISH		
☐	CLARITY		
		TRIGGER ASSEMBLY	
		☒	SAFETY OPERATION
		☒	RE-SET TO FACTORY SPECS
		COMMENTS:	

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

R & E NUMBER	87786		Supp. # 4380
SERIAL NUMBER	06348215		
LOG-IN DATE	11-11-04		
INSPECT AND VERIFY:			
OPERATION #	OPERATION NAME	DATE	INITIAL
550	DIS-ASSEMBLE GUN	11-15-04	RTL
560 A	RE-BARREL	11-16-04	RTL
B	DRILL AND TAP		
575	ASSEMBLE	11-16-04	RTL
600	PROOF	11-16-04	RTL
605	CHECK HEADSPACE	11-16-04	RTL
610	DIS-ASSEMBLE GUN	11-17-04	RTL
612	MAGNAFLUX		
615	ROLLMARK CALIBER	11-18-04	SB/CW
618	ROTO-BLAST	11-30-04	LB
620	APPLY COATINGS	12-1-04	HP
625 A	FINAL ASSEMBLY	12-7-04	RTL
B	TRIGGER PULL TEST	N/A	
C	SAFETY "ON" FORCE		
D	SAFETY "OFF" FORCE		
E	FIRING PIN INDENT		
640	TARGET	12-8-04	TRW
655	FINAL INSPECT	12-8-04	AC
660	PACK	12-9-04	DA
		SHIP DATE	
	QAR INSPECTION DATE		

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6348715

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	10-9	89	RW
600	Proof	10-9	89	A
607	Check Headspace	10-9	89	RW
610	Dis-assemble Gun	10-9	89	RW
612	Magnaflux Barrel Action	10/31/89		KCR
	Magnaflux Bolt	10/31/89		KCR
615	Rollmark Caliber		10/31/89	CS
7	Drill and Tap Sight Holes		10/31/89	FB
618	Polish Barrel RB		10/31/89	WB
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 NOV 89	928

BARBER - M24 0062166								
op. #	OP. NAME	READINGS			DATE	INIT		
625 cont.	F) Safety On Force	4	4	4	11-14-89	JEL		
	G) Safety Off Force	2	2	2	11-14-89	JEL		
	H) Trigger Pull Test & Retainability				14 NOV 89	LS2		
	I) Firing Pin Indent	.021	.021	.0215	11-14-89	JEL		
	J) Assemble Stock				12/15/89	RW		
	K) Assemble Swivel Studs				11 DEC 89	JDS		
	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	JDS		
	P) Detach & Attach Scope 20 Times				15 NOV 89	JDS		
640	Gallery Target & Test				11-17-89	DH		
	A) Time				11-17-89	DH		
	B) Malfunctions				11-17-89	DH		
	C) Pierced Primers				11-17-89	DH		
	D) Optical Clarity of Scope				11-17-89	DH		
645	Inspect for Live Ammo				11-17-89	DH		
655	Final Inspection							
	A) Headspace				11 DEC 89	JDS		
	B) Trigger Pull	2.78	2.52	2.56	2.53	2.82	11 DEC 89	JDS
	C) Function						11 DEC 89	JDS
660	Pack						15 DEC 89	JDS

Malfunction: SHAVES BRASS & DONT EJECT

CORRECTIVE ACTION: REAM EJECTOR HOLE
POLISH EJECTOR

FUNCTION: 100 Rd TEST OK D.H. 12/9/89

TEST INIT. ACTION TO CORRECT		ASSEM. #
PROOF	Ream Ejector hole Polish Ejector 12/8/89.	Ru
TEST		
TGT		
PROOF	shot OK 12-9-89	DH
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		

MOD. _____		GA. CAL. _____	GUN # _____	ASSEM. # _____
#	DATE	MALFUNCTION/DEFECT		
	1st	<i>shell burst don't eject</i>		
	11/17/89			
	2nd			
	3rd			
	4th			
		FUNCTION _____		RD 6654 Rev 1

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

SERIAL NO. C634 8715
DATE 13 MAR 90
TESTER JD

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#	COMMENTS
PULL #1	240	238	228	MIN. SETTING,
PULL #2	238	234	225	NO AVG. OF 5
PULL #3	236	232	222	READINGS ACCEPT-
PULL #4	241	234	224	ABLE LESS THAN 2#
PULL #5	236	212	230	
TOTAL	1191	1130		
AVG.	2382	2260		

	3.00# INITIAL	3.00# AFTER 20 CYCLES	COMMENTS
PULL #1	339	360	
PULL #2	361	367	
PULL #3	360	361	
PULL #4	364	363	
PULL #5	364	361	
TOTAL	1788	1812	
AVG.	3576	3624	

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	410	407		
PULL #2	411	407		
PULL #3	410	403		
PULL #4	397	407		
PULL #5	384	401		
TOTAL	2012	2026		
AVG.	4024	4052		

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06348715
17 Nov 1989

CENTROIDAL DISTANCES

0 TO	1	.19965
1 TO	2	.483343
1 TO	3	.513919
1 TO	4	.574528
1 TO	5	.502415

4.5
25 <----POA

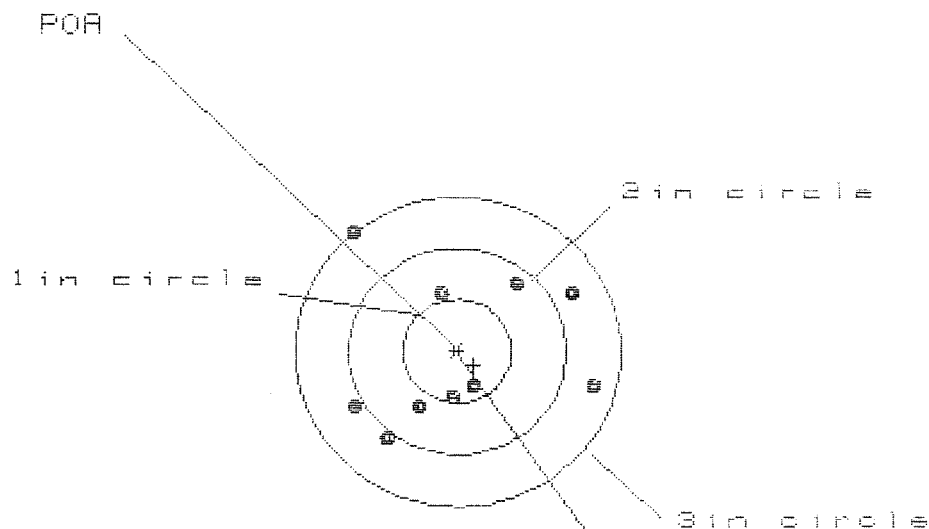
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1864
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0548
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .194288

THE AMR FOR THIS RIFLE IS: .8866

17 Nov 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C634B715

CENTERFIRE PATTERNS # 1



OF SHOTS - 10

IN CIR

1 in = 2

2 in = 5

3 in = 10

HS = 2.204

VS = 1.959

GS = 2.614

CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.255	1.155	1.136
MINIMUM X	-.949	-1.049	-.905
MAXIMUM Y	1.133	.743	.716
MINIMUM Y	-.826	-.700	-.727
CENTROID X	-.148	-.048	-.192
CENTROID Y	.134	.008	.035
POA TO CENTROID in.	.200	.048	.195
MIN RADIUS	.318	.169	.256
MEAN RADIUS	.900	.814	.757
MAX RADIUS	1.450	1.232	1.336
HORIZONTAL SPREAD	2.204	2.204	2.041
VERTICAL SPREAD	1.959	1.443	1.443
EXTREME SPREAD	2.614	2.347	2.347
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	10		

17 Nov 1989

FILE:/PATTERNING/CENTERFIRE_PATT/0834B715

CENTERFIRE PATTERNS # 2

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS - 10

IN CIR

1 in = 3

2 in = 3

3 in = 9

HS = 1.815

VS = 2.718

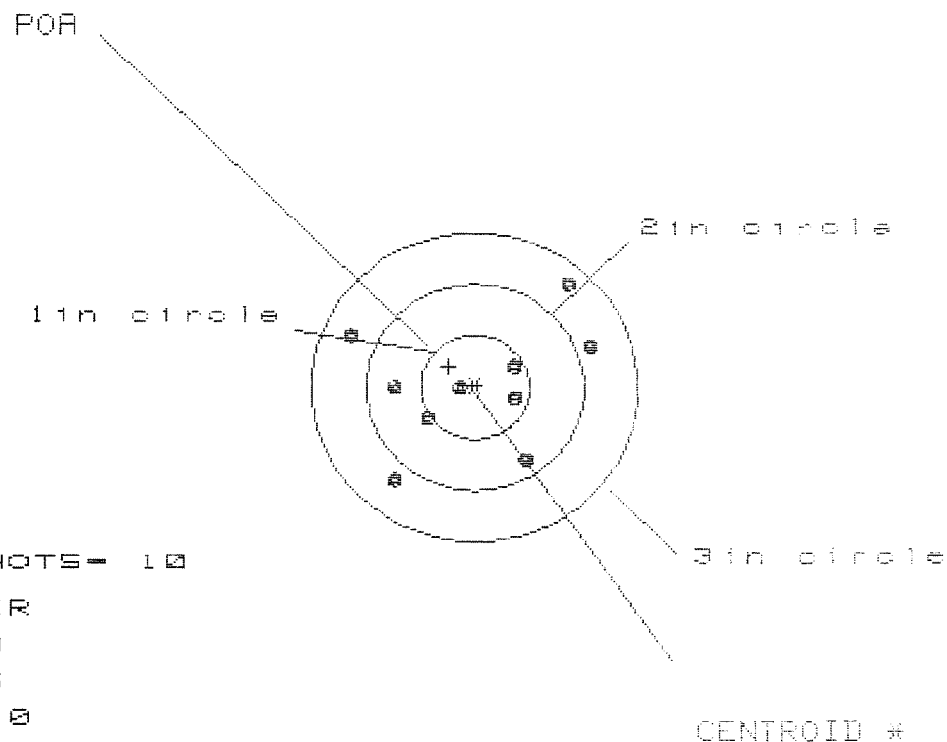
GS = 2.879

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.963	.928	.835
MINIMUM X	:	-.852	-.887	-.980
MAXIMUM Y	:	1.033	.846	.686
MINIMUM Y	:	-1.685	-1.279	-.885
CENTROID X	:	.170	.206	.299
CENTROID Y	:	-.230	-.043	.117
POA TO CENTROID in.	:	.286	.210	.321
MIN RADIUS	:	.284	.271	.319
MEAN RADIUS	:	.977	.888	.813
MAX RADIUS	:	1.714	1.480	1.160
HORIZONTAL SPREAD	:	1.815	1.815	1.815
VERTICAL SPREAD	:	2.718	2.125	1.491
EXTREME SPREAD	:	2.879	2.570	2.244
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		9	

17 Nov 1989

FILE:/PATTERNING/CENTERFIRE_PATT/06346715

CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1in = 3

2in = 6

3in = 10

HS = 2.177

VS = 1.934

GS = 2.506

PATTERN #	:	3	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.083	1.182	1.058
MINIMUM X	:	-1.094	-.995	-.789
MAXIMUM Y	:	.990	.637	.562
MINIMUM Y	:	-.944	-.834	-.754
CENTROID X	:	.240	.141	.265
CENTROID Y	:	-.203	-.313	-.393
POA TO CENTROID in.	:	.314	.344	.474
MIN RADIUS	:	.139	.091	.229
MEAN RADIUS	:	.793	.717	.660
MAX RADIUS	:	1.331	1.277	1.198
HORIZONTAL SPREAD	:	2.177	2.177	1.847
VERTICAL SPREAD	:	1.934	1.471	1.316
EXTREME SPREAD	:	2.506	2.219	2.219
NUMBER IN ONE INCH CIRCLE =	:	3		
NUMBER IN TWO INCH CIRCLE =	:	6		
NUMBER IN THREE INCH CIRCLE =	:	10		

17 Nov 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C8348715

CENTERFIRE PATTERNS

4

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS- 10

IN CIR

1 in = 2

2 in = 7

3 in = 10

HS= 2.034

VS= 2.493

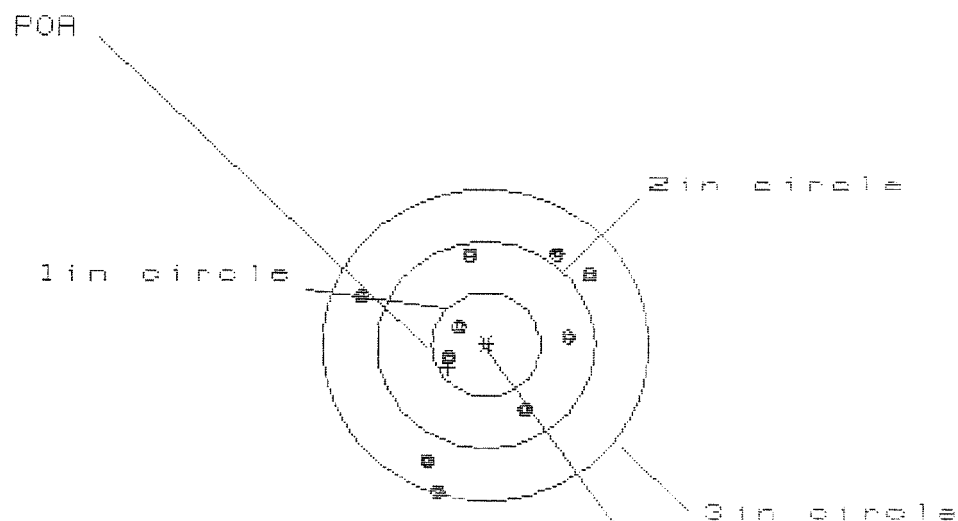
GS= 2.515

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.566	.403	.426
MINIMUM X	:	-1.468	-1.041	-1.018
MAXIMUM Y	:	1.327	1.335	.707
MINIMUM Y	:	-1.166	-1.158	-.991
CENTROID X	:	.323	.486	.463
CENTROID Y	:	-.195	-.203	-.370
POA TO CENTROID in.	:	.377	.527	.593
MIN RADIUS	:	.104	.267	.245
MEAN RADIUS	:	.831	.742	.661
MAX RADIUS	:	1.470	1.348	1.021
HORIZONTAL SPREAD	:	2.034	1.444	1.444
VERTICAL SPREAD	:	2.493	2.493	1.698
EXTREME SPREAD	:	2.515	2.515	1.744
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

17 Nov 1989

FILE:/PATTERNING/CENTERFIRE_PATT/08348715

CENTERFIRE PATTERNS # 5



OF SHOTS - 10

IN CIR

1 in = 2

2 in = 5

3 in = 10

HS = 2.156

VS = 2.304

GS = 2.528

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.002	.957	.807
MINIMUM X	:	-1.154	-1.199	-.696
MAXIMUM Y	:	.923	.770	.815
MINIMUM Y	:	-1.381	-1.314	-1.269
CENTROID X	:	.347	.392	.542
CENTROID Y	:	.220	.373	.328
POA TO CENTROID in.	:	.411	.541	.633
MIN RADIUS	:	.283	.263	.418
MEAN RADIUS	:	.932	.865	.816
MAX RADIUS	:	1.438	1.423	1.447
HORIZONTAL SPREAD	:	2.156	2.156	1.503
VERTICAL SPREAD	:	2.304	2.084	2.084
EXTREME SPREAD	:	2.528	2.379	2.379
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		10	

INTERCHANGEABILITY

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6348715
12 Dec 1989

CENTROIDAL DISTANCES

0 TO	1	.369769
1 TO	2	.1336
1 TO	3	.480751
1 TO	4	.411005
1 TO	5	.253444

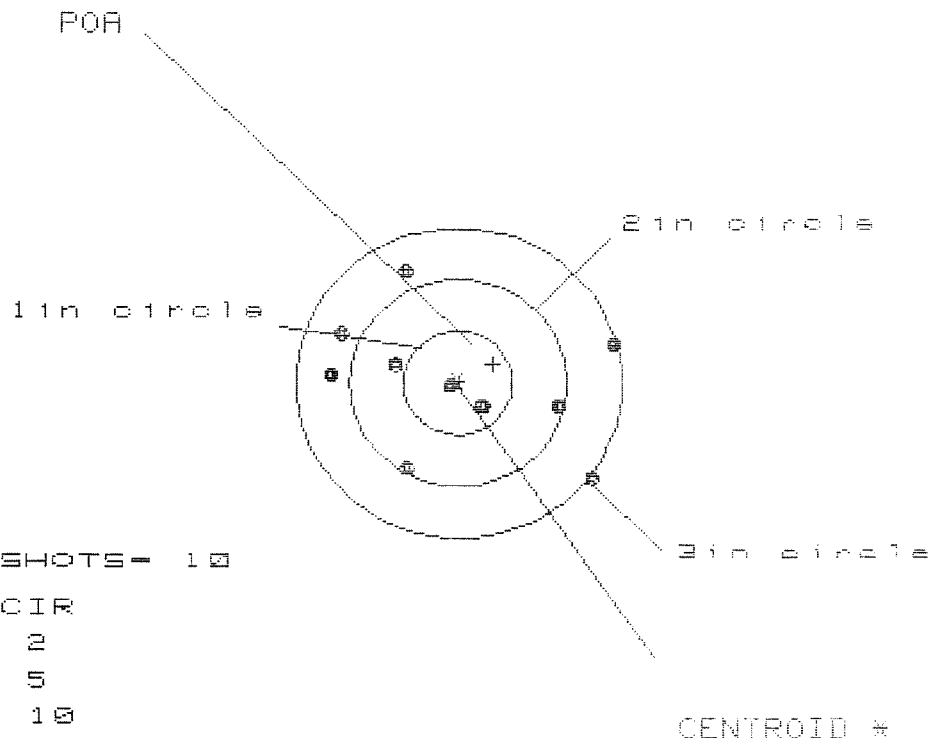
 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.2026
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0632
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .21229
THE AMR FOR THIS RIFLE IS: .8748

12 Dec 1989

FILE:/PATTERNING/CENTERFIRE_PATT/CS34B715.1

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 10

HS= 2.619

VS= 2.004

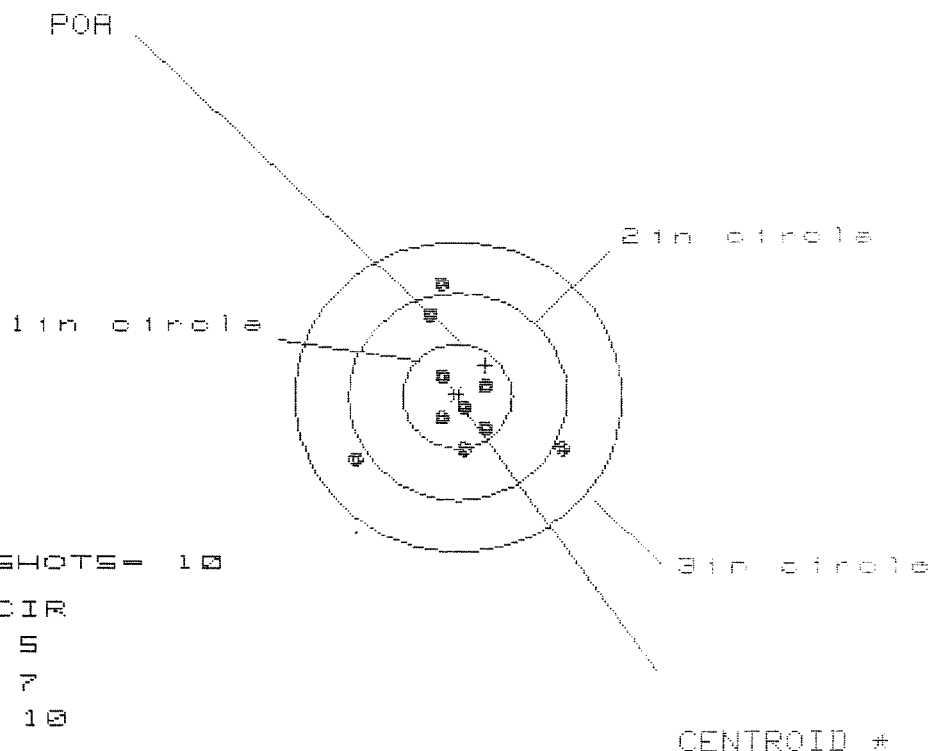
GS= 2.661

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.446	1.579	1.279
MINIMUM X	-1.173	-1.040	-.843
MAXIMUM Y	1.104	1.003	1.032
MINIMUM Y	-.901	-.965	-.936
CENTROID X	-.323	-.456	-.653
CENTROID Y	-.180	-.079	-.108
POA TO CENTROID in.	.370	.463	.662
MIN RADIUS	.038	.134	.253
MEAN RADIUS	.942	.878	.769
MAX RADIUS	1.496	1.596	1.307
HORIZONTAL SPREAD	2.619	2.619	2.122
VERTICAL SPREAD	2.004	1.968	1.968
EXTREME SPREAD	2.661	2.630	2.142
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	10		

12 Dec 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C8348715.1

CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1 in = 5

2 in = 7

3 in = 10

HS = 1.934

VS = 1.647

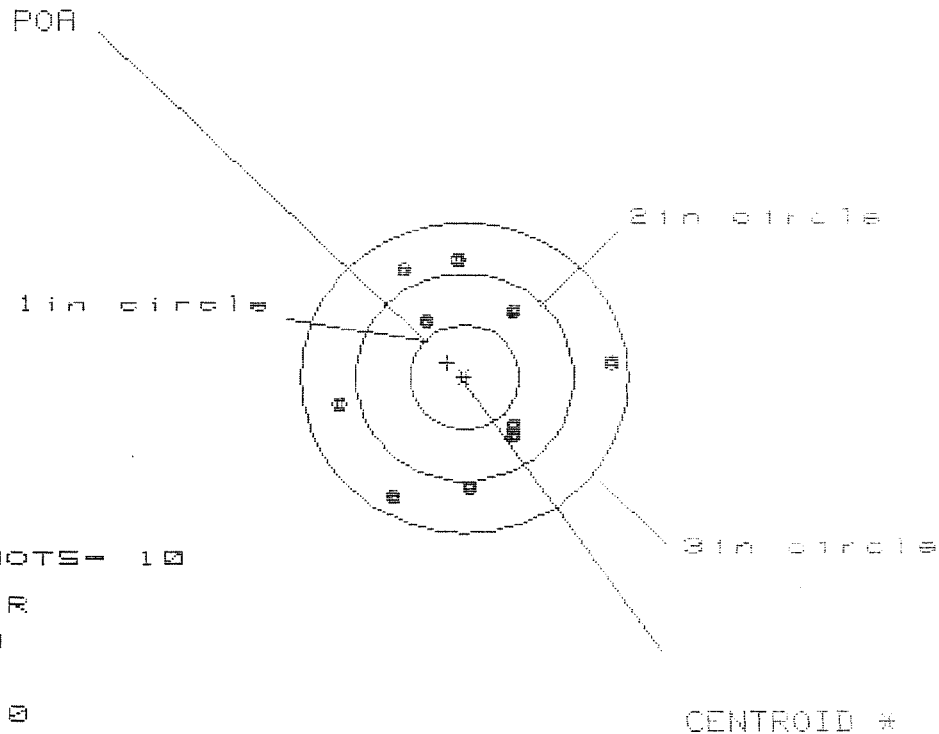
GS = 1.955

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.979	.352	.246
MINIMUM X	:	-.955	-.846	-.233
MAXIMUM Y	:	1.086	1.027	.949
MINIMUM Y	:	-.561	-.620	-.656
CENTROID X	:	-.255	-.364	-.258
CENTROID Y	:	-.295	-.236	-.158
POA TO CENTROID in.	:	.390	.433	.303
MIN RADIUS	:	.130	.173	.178
MEAN RADIUS	:	.589	.544	.473
MAX RADIUS	:	1.113	1.049	.957
HORIZONTAL SPREAD	:	1.934	1.198	.479
VERTICAL SPREAD	:	1.647	1.647	1.685
EXTREME SPREAD	:	1.955	1.846	1.617
NUMBER IN ONE INCH CIRCLE =			5	
NUMBER IN TWO INCH CIRCLE =			7	
NUMBER IN THREE INCH CIRCLE =			10	

12 Dec 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C834B715.1

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in - 0

2 in - 4

3 in - 10

HS= 2.442

VS= 2.304

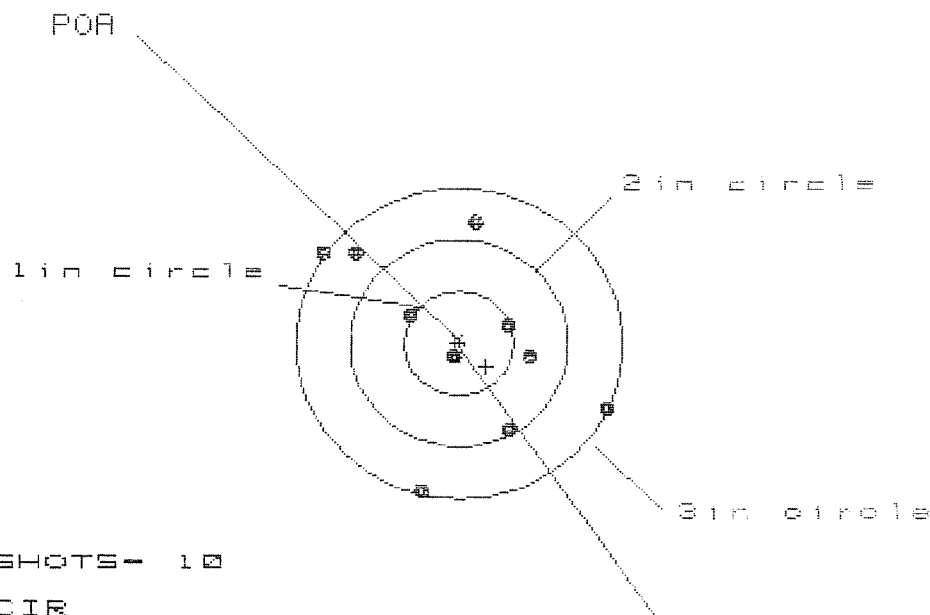
GS= 2.476

PATTERN #	3	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.336	.623	.555
MINIMUM X	-1.106	-.958	-1.026
MAXIMUM Y	1.182	1.197	1.059
MINIMUM Y	-1.122	-1.107	-1.163
CENTROID X	.156	.008	.076
CENTROID Y	-.139	-.154	-.016
POA TO CENTROID in.	.209	.154	.078
MIN RADIUS	.603	.549	.456
MEAN RADIUS	.986	.945	.889
MAX RADIUS	1.343	1.235	1.172
HORIZONTAL SPREAD	2.442	1.581	1.581
VERTICAL SPREAD	2.304	2.304	2.222
EXTREME SPREAD	2.476	2.401	2.224
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	10		

12 Dec 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C8348715.1

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 5

3 in = 9

HS= 2.575

VS= 2.597

GS= 2.963

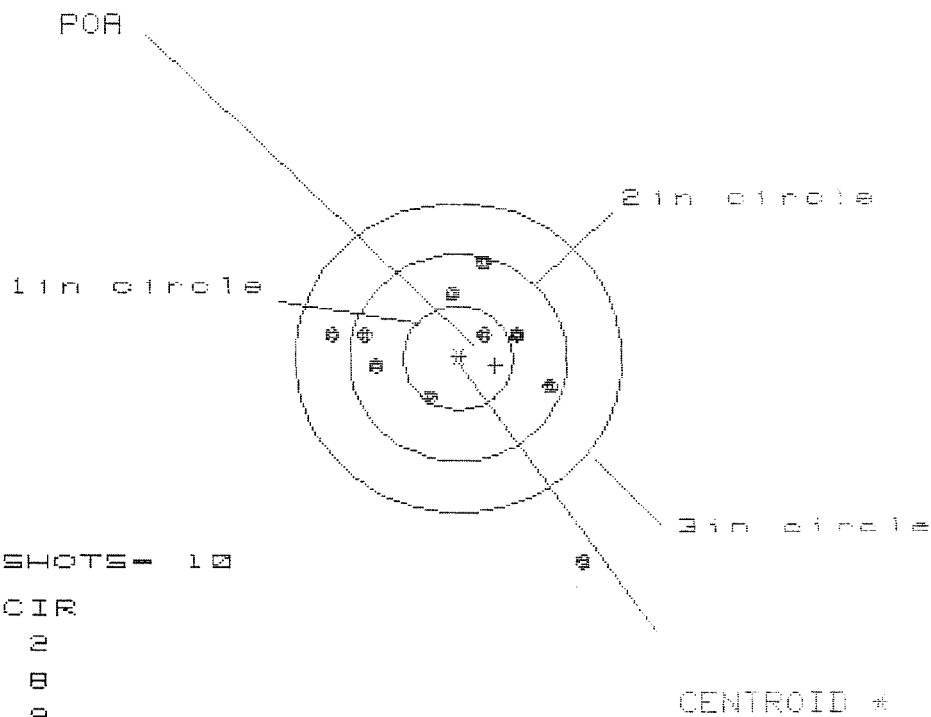
CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.347	1.309	.782
MINIMUM X	:	-1.228	-1.266	-1.102
MAXIMUM Y	:	1.134	.972	.873
MINIMUM Y	:	-1.463	-1.020	-1.119
CENTROID X	:	-.253	-.215	-.379
CENTROID Y	:	.225	.387	.486
POA TO CENTROID in.	:	.338	.443	.617
MIN RADIUS	:	.170	.332	.287
MEAN RADIUS	:	.959	.895	.812
MAX RADIUS	:	1.501	1.530	1.242
HORIZONTAL SPREAD	:	2.575	2.575	1.884
VERTICAL SPREAD	:	2.597	1.992	1.992
EXTREME SPREAD	:	2.963	2.963	2.356
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

12 Dec 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C8348715.1

CENTERFIRE PATTERNS # 5



OF SHOTS - 10

IN CIR

1 in = 2

2 in = 8

3 in = 9

HS = 2.354

VS = 2.889

GS = 3.187

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.165	.936	.884
MINIMUM X	:	-1.189	-1.060	-.829
MAXIMUM Y	:	.957	.742	.743
MINIMUM Y	:	-1.932	-.555	-.554
CENTROID X	:	-.338	-.467	-.335
CENTROID Y	:	.073	.288	.287
POA TO CENTROID in.	:	.346	.549	.441
MIN RADIUS	:	.360	.411	.279
MEAN RADIUS	:	.898	.715	.655
MAX RADIUS	:	2.256	1.863	.948
HORIZONTAL SPREAD	:	2.354	1.996	1.633
VERTICAL SPREAD	:	2.889	1.297	1.297
EXTREME SPREAD	:	3.187	2.059	1.722
NUMBER IN ONE INCH CIRCLE =			2	
NUMBER IN TWO INCH CIRCLE =			8	
NUMBER IN THREE INCH CIRCLE =			9	