

G-6360882
Replaced
E 6413612

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: **RE00092124** Serial: E6413612 Model M24 SWS Center Fire Caliber: 7.62 NATO Repairman: Status: Closed 1/31/2005 9:36:34 AM

Verify Repair

Address Information

Customer: ☒ Received From Return To: ☐ Received From

Name: **DEPARTMENT OF THE ARMY COMM** **DEPARTMENT OF THE ARMY COMM**

Address 1: **HHC 1 505 PIR** **HHC 1 505 PIR**

Address 2: PO Box: PO Box:

City: **FORT BRAGG** **FORT BRAGG**

State: **NC** Zip Code: **28307** Country: **US** State: **NC** Zip Code: **28307** Country: **US**

FFL: ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐

Contact / Condition **Problems** **Estimate** **History / Status** **Shipping / Billing**

Contact Information

Phone: **N/A**

Fax:

Email:

Comments:

Received Condition

Condition: **Good**

Condition Notes:

CSR Notes:

Accessories Received

Code	Desc	Qty
A007	With Stud	3
A010	Hard Case	1
A017	Scope Base	1
A026	Scope	1
A057	Frt and Rear Sgt Base	1

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

negletj 2/7/2005 10:42 AM CAPS NUM INS SCPL

start 3 2

G 636 0882 (New)

Serial Number: **E6413612**

Model: **M24 SWS**



RE00092124

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6360882.____0
FILE DATE AND TIME: 02/28/2005 07:56

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.087
The Average Y Centroid of the Five Target Set:	-0.020
The Average Point of Impact of the Five Target Set:	0.089
The Average Mean Radius of the Five Target Set:	0.974
The Distance from POA to Centroid Target #1:	0.390
The Distance from Centroid Target #2 to Centroid Target #1:	0.275
The Distance from Centroid Target #3 to Centroid Target #1:	0.288
The Distance from Centroid Target #4 to Centroid Target #1:	0.585
The Distance from Centroid Target #5 to Centroid Target #1:	0.496

BARBER - M24 0083192

SERIAL NUMBER: G6360882. __0

TARGET NUMBER: 1

FILE DATE: 02/28/2005

FILE TIME: 07:56

X CENTROID: 0.372

Y CENTROID: 0.117

POA TO CENTROID: 0.390

HORZ SPREAD: 2.726

VERT SPREAD: 2.217

GROUP SPREAD: 3.018

MIN RADIUS: 0.357

MAX RADIUS: 1.795

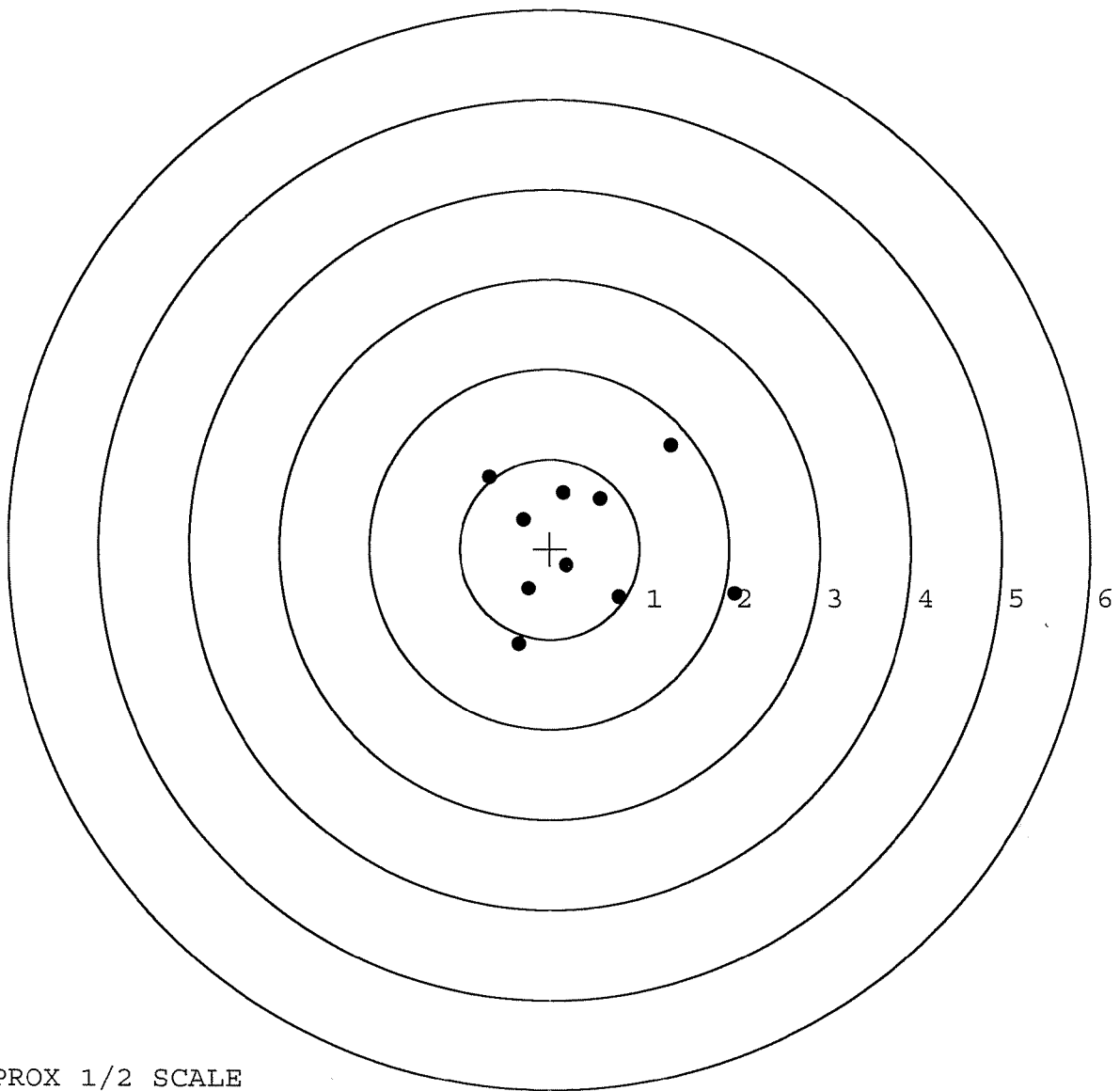
MEAN RADIUS: 0.909

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.773	-0.534
2:	-0.348	-1.060
3:	-0.242	-0.445
4:	0.183	-0.186
5:	0.564	0.557
6:	0.564	0.554
7:	0.151	0.620
8:	-0.296	0.323
9:	-0.668	0.797
10:	1.349	1.157
11:	2.058	-0.499



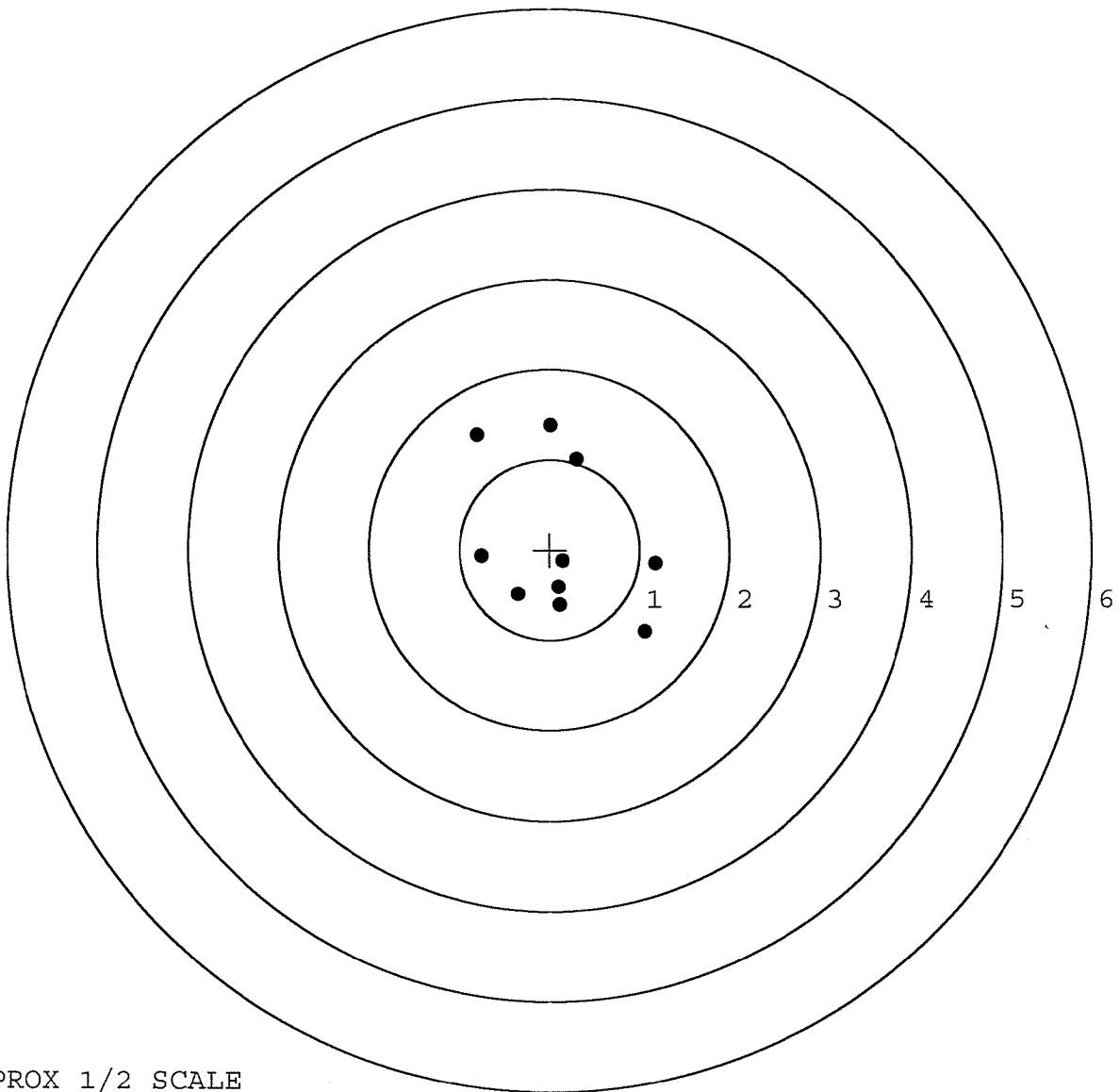
TARGET APPROX 1/2 SCALE

BARBER - M24 0083193

SERIAL NUMBER: G6360882. __0
TARGET NUMBER: 2
FILE DATE: 02/28/2005
FILE TIME: 07:56

POINT#	X	Y
1:	1.056	-0.911
2:	1.174	-0.150
3:	0.098	-0.417
4:	0.113	-0.619
5:	0.144	-0.124
6:	-0.354	-0.494
7:	-0.758	-0.071
8:	0.304	1.004
9:	0.010	1.378
10:	-0.804	1.270

X CENTROID: 0.098
Y CENTROID: 0.087
POA TO CENTROID: 0.131
HORZ SPREAD: 1.978
VERT SPREAD: 2.289
GROUP SPREAD: 2.866
MIN RADIUS: 0.216
MAX RADIUS: 1.488
MEAN RADIUS: 0.924
IN 1 IN DIAMETER: 1
IN 2 IN DIAMETER: 6
in 3 IN DIAMETER: 10



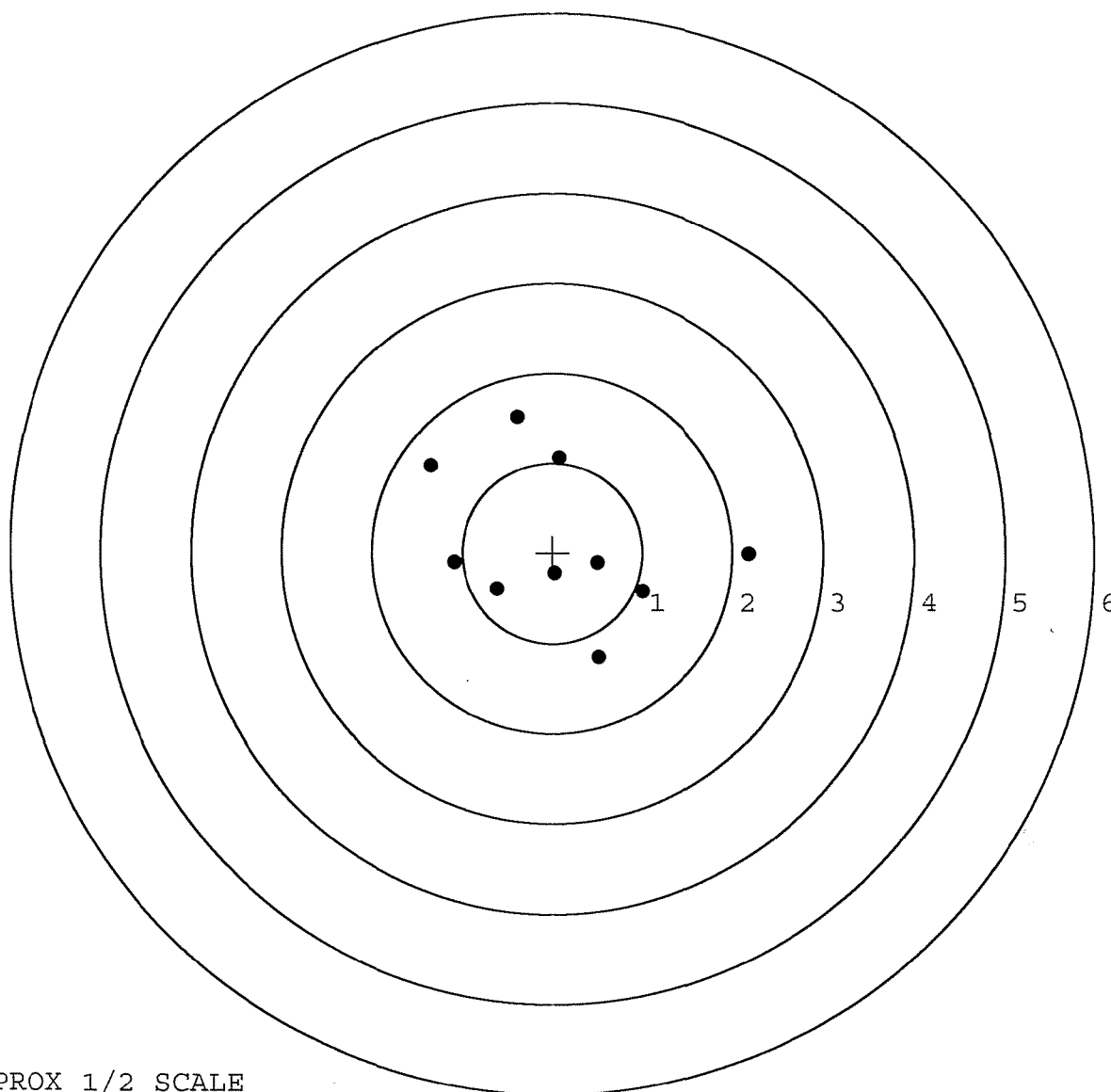
TARGET APPROX 1/2 SCALE

BARBER - M24 0083194

SERIAL NUMBER: G6360882. __0
 TARGET NUMBER: 3
 FILE DATE: 02/28/2005
 FILE TIME: 07:56

POINT#	X	Y
1:	2.177	-0.015
2:	1.006	-0.427
3:	0.502	-0.119
4:	0.025	-0.233
5:	0.516	-1.159
6:	-0.619	-0.404
7:	-1.093	-0.110
8:	-1.350	0.969
9:	0.075	1.059
10:	-0.399	1.510

X CENTROID: 0.084
 Y CENTROID: 0.107
 POA TO CENTROID: 0.136
 HORZ SPREAD: 3.527
 VERT SPREAD: 2.669
 GROUP SPREAD: 3.662
 MIN RADIUS: 0.345
 MAX RADIUS: 2.097
 MEAN RADIUS: 1.150
 # IN 1 IN DIAMETER: 2
 # IN 2 IN DIAMETER: 4
 # in 3 IN DIAMETER: 8



TARGET APPROX 1/2 SCALE

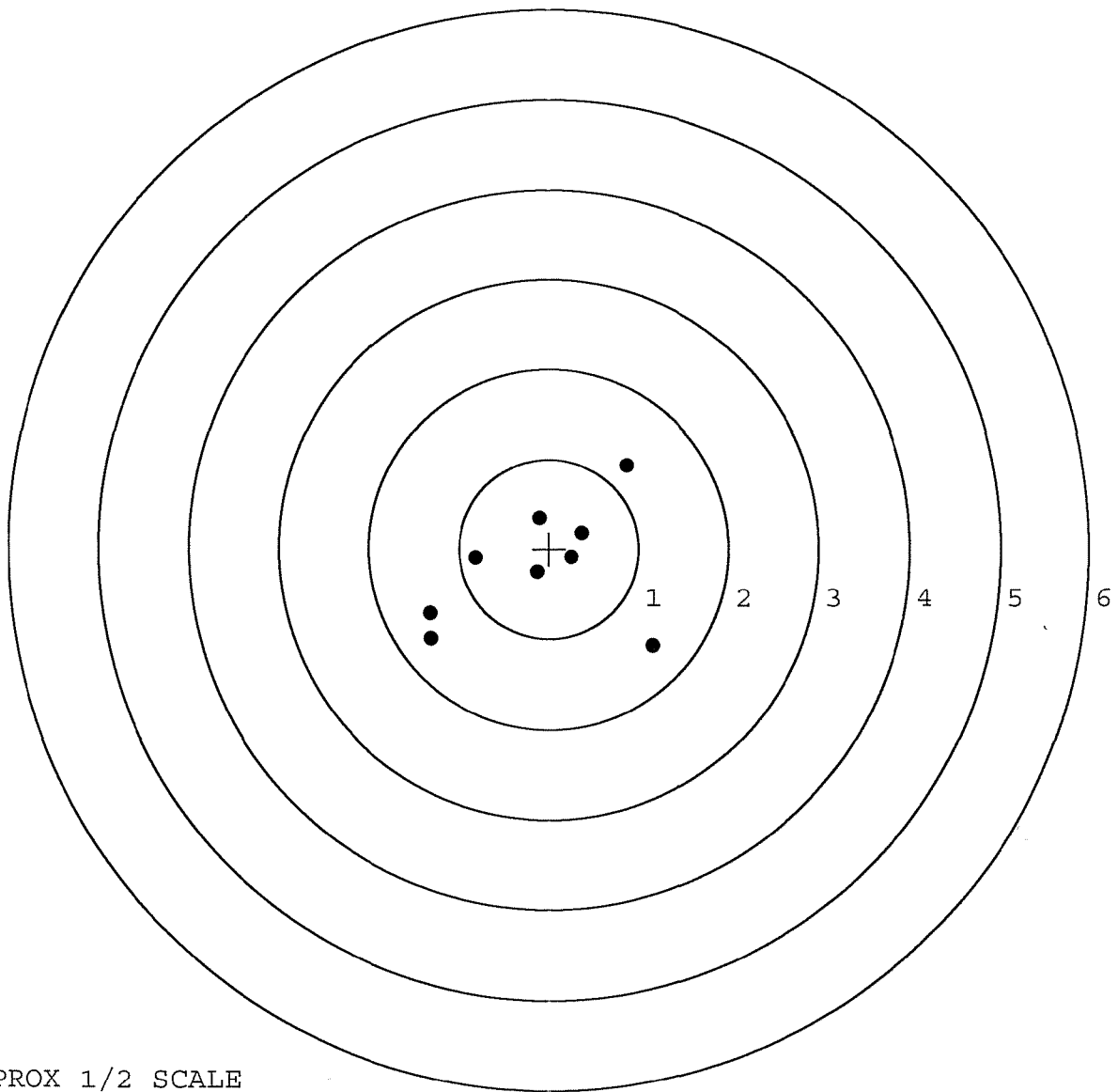
BARBER - M24 0083195

SERIAL NUMBER: G6360882. __0
TARGET NUMBER: 4
FILE DATE: 02/28/2005
FILE TIME: 07:56

X CENTROID: -0.118
Y CENTROID: -0.203
POA TO CENTROID: 0.235
HORZ SPREAD: 2.478
VERT SPREAD: 2.012
GROUP SPREAD: 2.504
MIN RADIUS: 0.064
MAX RADIUS: 1.547
MEAN RADIUS: 0.902

IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 5
in 3 IN DIAMETER: 7

POINT#	X	Y
1:	1.155	-1.082
2:	0.868	0.930
3:	-0.113	0.341
4:	-0.817	-0.104
5:	-0.138	-0.264
6:	-1.323	-0.725
7:	-1.319	-1.002
8:	0.372	0.174
9:	0.251	-0.095



TARGET APPROX 1/2 SCALE

BARBER - M24 0083196

SERIAL NUMBER: G6360882. __0

TARGET NUMBER: 5

FILE DATE: 02/28/2005

FILE TIME: 07:56

X CENTROID: -0.003

Y CENTROID: -0.209

POA TO CENTROID: 0.209

HORZ SPREAD: 3.119

VERT SPREAD: 2.439

GROUP SPREAD: 3.150

MIN RADIUS: 0.210

MAX RADIUS: 1.967

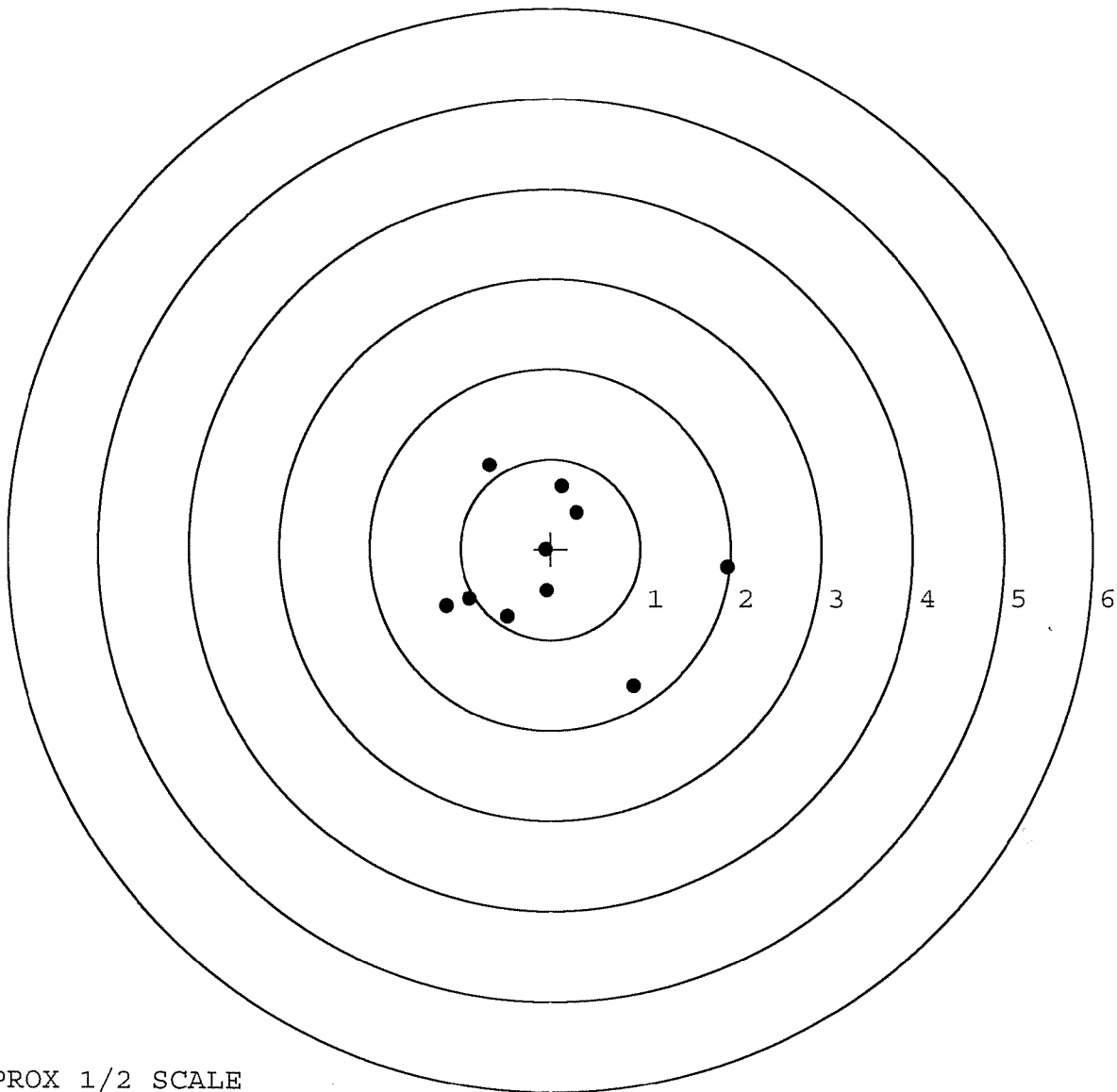
MEAN RADIUS: 0.987

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 8

POINT#	X	Y
1:	1.964	-0.201
2:	0.922	-1.508
3:	-0.678	0.931
4:	0.122	0.698
5:	0.293	0.406
6:	-0.063	-0.008
7:	-0.048	-0.462
8:	-0.482	-0.751
9:	-0.903	-0.558
10:	-1.155	-0.640



TARGET APPROX 1/2 SCALE

BARBER M24 0083107

SERIAL NO.

INITIAL & CYCLE TESTS

2.50 LBS (plus or minus 0.50 LBS)

3.00 LBS (plus or minus 0.75 LBS)

4.00 LBS (plus or minus 1.00 LBS)

DATE 2-8-05

TESTER TRW

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.21	2.63		2.09	
PULL #2	2.71	2.80		2.13	
PULL #3	2.48	2.60		2.15	
PULL #4	2.47	2.54		2.15	
PULL #5	2.53	2.40		2.21 TRW	
TOTAL	12.10	12.97		10.73	
AVERAGE	2.42	2.59		2.14	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.37	3.29		
PULL #2	3.40	3.21		
PULL #3	3.43	3.24		
PULL #4	3.27	3.06		
PULL #5	3.18	3.14		
TOTAL	16.65	15.94		
AVERAGE	3.33	3.18		

	4.00 LBS INITIAL	4.00 LBS AFTER 20 CYCLES	MAX SETTING GREATER THAN 4 LBS	RESET TO 4 LBS FOR TARGET & ACCURACY
PULL #1	4.22	4.28		4.63
PULL #2	4.09	4.40		4.11
PULL #3	4.14	4.39		4.11
PULL #4	4.04	4.19		4.08
PULL #5	4.10	4.47		4.18
TOTAL	20.59	21.73		21.11
AVERAGE	4.11	4.34		4.22

R & E NUMBER	92124		
SERIAL NUMBER	F6413612		C6360882
LOG-IN DATE	1-31-05		
INSPECT AND VERIFY:			
OPERATION #	OPERATION NAME	DATE	INITIAL
550	DIS-ASSEMBLE GUN	2-8-05	RTZ
560 A	RE-BARREL	2-12-05	RTZ
B	DRILL AND TAP	2-15-05	TRW
575	ASSEMBLE	2-12-05	RTZ
600	PROOF	2-14-05	AC
605	CHECK HEADSPACE	2-14-05	AC
610	DIS-ASSEMBLE GUN	2-14-05	RTZ
612	MAGNAFLUX		OPERATOR
615	ROLLMARK CALIBER	2-17-05	CW
618	ROTO-BLAST	2-17-05	LB
620	APPLY COATINGS	2/23/05	HO
625 A	FINAL ASSEMBLY	2-25-05	RTZ
B	TRIGGER PULL TEST	3-7-05	RTZ
C	SAFETY "ON" FORCE	3-7-05	RTZ
D	SAFETY "OFF" FORCE	3-7-05	RTZ
E	FIRING PIN INDENT	NA	
640	TARGET	2-28-05	K
655	FINAL INSPECT	3-7-05	RTZ
660	PACK	3-7-05	RTZ
		SHIP DATE	
		QAR INSPECTION DATE	

Arms Services Repair & Estimate System

FileAdd RepairEstimate RepairExpedite RepairInquiryRepair ToolsCSR ToolsReportsTable MaintenanceSystem MaintenanceHelp

Repair Inquiry

Repair Number:RE00023302

Verify Repair

Serial: C6225534 Model: 700 Center Fire Caliber: 7.62 NATO M-24 (SWS)

Repairman:

Status:Closed 2/20/01 2:19:51 PM

Address Information

Customer:

Received From

Name:COMMANDER HHC 3/505TH PIR

Address 1:BLDG# C7535

Address 2:

PO Box:

City:FORT BRAGG

State:NCZip Code:28310Country:US

Return To:

Received From

Name:COMMANDER HHC 3/505TH PIR

Address 1:BLDG# C7535

Address 2:

PO Box:

City:FORT BRAGG

State:NCZip Code:28310Country:US

FFL:

Contact / ConditionProblemsEstimateHistory / StatusShipping / Billing

Contact Information

Phone:

Fax:

Email:

Comments:

Received Condition

Condition:

Notes:

CSR Notes:

Accessories Received

Code	Desc	Qty
A007	With Stud	1
A010	Hard Case	1
A016	Scope Mounts	1
A017	Scope Base	1
A026	Scope	1

Repair Search

Refresh

Close

name:2/20/012:41 PMCAPSNUMINS-SCPL

StartInboxNagleMicroArmExplorPartSFBIAMag

2:41 PM

Serial Number: _____

~~C6225534~~

Model: 700



RE00023302

E 6413612

BARBER - M24 0083200

Remington Test Lab, Ilion, N.Y.

Centroidal distance calculations for Rifle # e6413612
28 Mar 2001

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: $-.0776$
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: $.0338$
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: $.0846416$

THE AMR FOR THIS RIFLE IS: $.9818$

CENTROIDAL DISTANCES

0 TO 1	.0458912
1 TO 2	.280492
1 TO 3	.270675
1 TO 4	.135871
1 TO 5	.0304138

$\begin{matrix} 3 & 4 \\ 2 & 5 \end{matrix}$ <----POA

BARBER - M24 0083201

REMINGTON CENTERFIRE ACCURACY TEST

REMINGTON TEST LAB, ILION, N.Y.

PATTERN #: ☐ 1 ☐

POA TO CENTROID: .046

MIN RADIUS : .219

MEAN RADIUS : .865

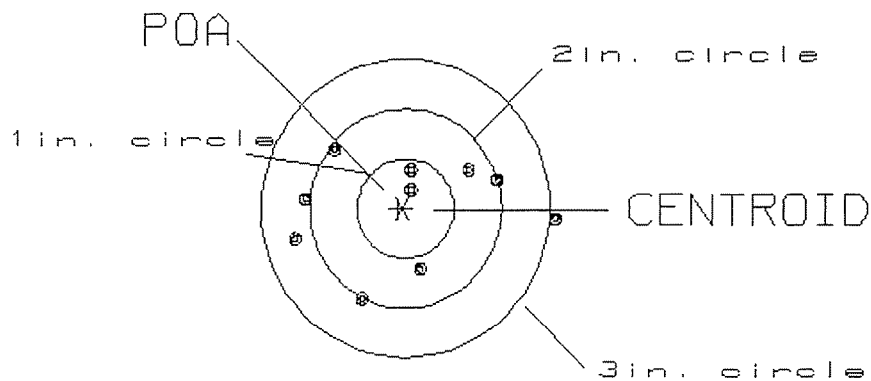
MAX RADIUS : 1.531

CENTROID X : .045

CENTROID Y : .009

28 Mar 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/e6413612

CENTERFIRE PATTERN # 1

OF SHOTS= 10

IN CIRCLE

HS= 2.67

2

VS= 1.49

6

GS= 2.68

9

BARBER - M24 0083202

REMINGTON CENTERFIRE ACCURACY TEST

REMINGTON TEST LAB, ILION, N.Y.

PATTERN #: ☐ 2 ☐

POA TO CENTROID: .235

MIN RADIUS : .258

MEAN RADIUS : 1.025

MAX RADIUS : 1.933

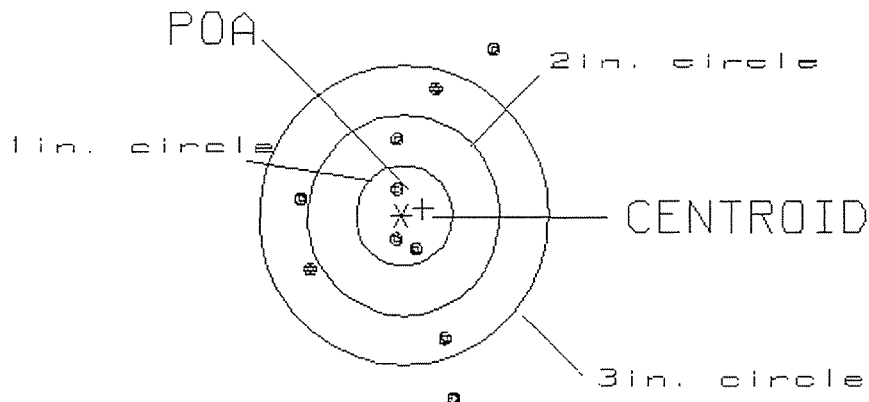
CENTROID X : -.225

CENTROID Y : -.067

28 Mar 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/e6413612

CENTERFIRE PATTERN # 2



OF SHOTS= 10

IN CIRCLE

HS= 2.02

3

VS= 3.48

4

GS= 3.50

8

REMINGTON CENTERFIRE ACCURACY TEST

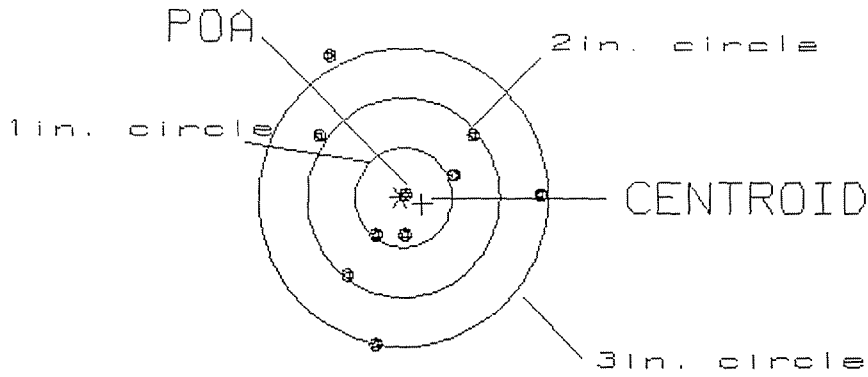
REMINGTON TEST LAB, ILION, N.Y.

PATTERN #: 3
 POA TO CENTROID: .230
 MIN RADIUS : .048
 MEAN RADIUS : .888
 MAX RADIUS : 1.654
 CENTROID X : -.218
 CENTROID Y : .073

28 Mar 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/e6413612

CENTERFIRE PATTERN # 3



OF SHOTS= 10

IN CIRCLE

HS= 2.24
 VS= 2.87
 GS= 2.93

2
 6
 9

REMINGTON CENTERFIRE ACCURACY TEST

REMINGTON TEST LAB, ILION, N.Y.

PATTERN #: ☐ 4 ☐

POA TO CENTROID: .122

MIN RADIUS : .603

MEAN RADIUS : 1.086

MAX RADIUS : 1.561

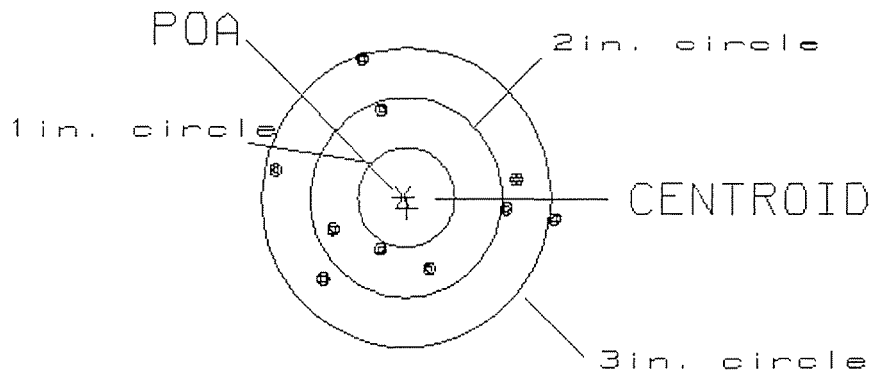
CENTROID X : -.040

CENTROID Y : .115

28 Mar 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/e6413612

CENTERFIRE PATTERN # 4



OF SHOTS= 10

IN CIRCLE

HS= 2.91

0

VS= 2.25

4

GS= 2.95

9

PATTERN #: ☐ 5 ☐

POA TO CENTROID: .063

MIN RADIUS : .458

MEAN RADIUS : 1.045

MAX RADIUS : 1.522

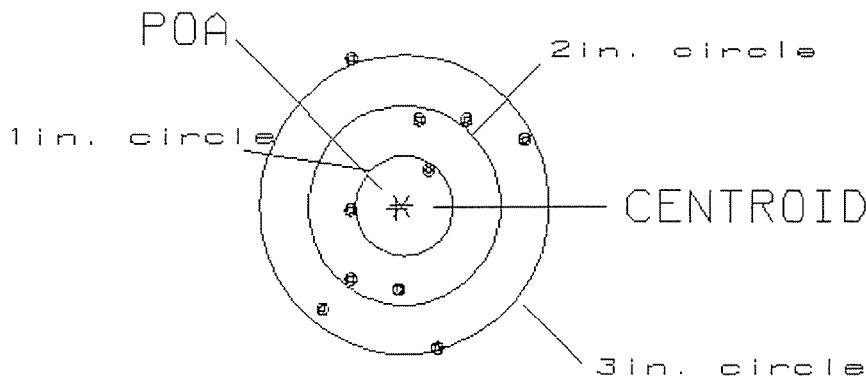
CENTROID X : .050

CENTROID Y : .039

28 Mar 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/e6413612

CENTERFIRE PATTERN # 5



OF SHOTS= 10

IN CIRCLE

HS= 2.10

1

VS= 2.85

5

GS= 2.98

9

Remington.



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

MODEL 700TM H24

SERIAL NO.
C6225534

ORDER NO.
5716

UPC



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

20



5716 C6225534

RECEIVING AND ESTIMATING REPORT

BARBER - M24 0083207

COMMENTS

ORDER

R 95-05950

INITIAL JJM	CUSTOMER ORDER NO.		WOG 1 OF 2 W/LEUPOLD 10X-M3A SCOPE M-24 SNIPER			
DATE RECEIVED 2/29/95	DATE OPENED 02/17/95	DATE CODE BJ 1-89	SERIAL NUMBER C6225534	NEW SERIAL NUMBER	MODEL AND GRADE 700 7.62	NATO
ACCESSORIES W/STUDS		SCOPE MNTS		SCOPE BASE		

FROM:

DEPT OF THE ARMY
COMMANDER
HHC 1/505 PIR
FT BRAGG

NC 28307

SHIP TO:

DEPT OF THE ARMY
COMMANDER
HHC 1/505 PIR
FT BRAGG

NC

28307

CUST NO: 115375 C.O.D.L

ACCOUNT NUMBER	ACCOUNT NUMBER N/C	WRITE ☐	PROM. DATE	ESTIMATED	VIA UPS
----------------	--------------------	--------------------------------	------------	-----------	------------

GUN CONDITION

- ☐ NEW
- ☐ LIGHTLY WORN
- ☐ WORN
- ☐ VERY WORN
- ☐ UNREPAIRABLE
- ☐ MARRED

REPAIR CHARGE

EXCISE

TAX

INSURANCE

UPS

PARCEL POST

TOTAL

W36BYM

CUSTOMER CONCERN	AMMO	FUNCTION	FINISH	ACCURACY	FIT	INSPECT
CYCLE	A1	B1				
TRIGGER GROUP		B2			E1	F1
BOLT ASSY.		B3			E2	F2
BARREL ASSY.	New Barrel			D1	E3	F3
REC. ASSY.		B5		D2	E4	F4
WOOD			C1	D3	E5	F5
METAL			C2			

MAIN FAULT

PARTS	COMMENTS
96002 - Barrel	Repowder Coat - Trigger Guard Assy. Front & Rear Sight Bases. Retain - Scope Base, Rings & Swivel Studs
W52H095055 H226	

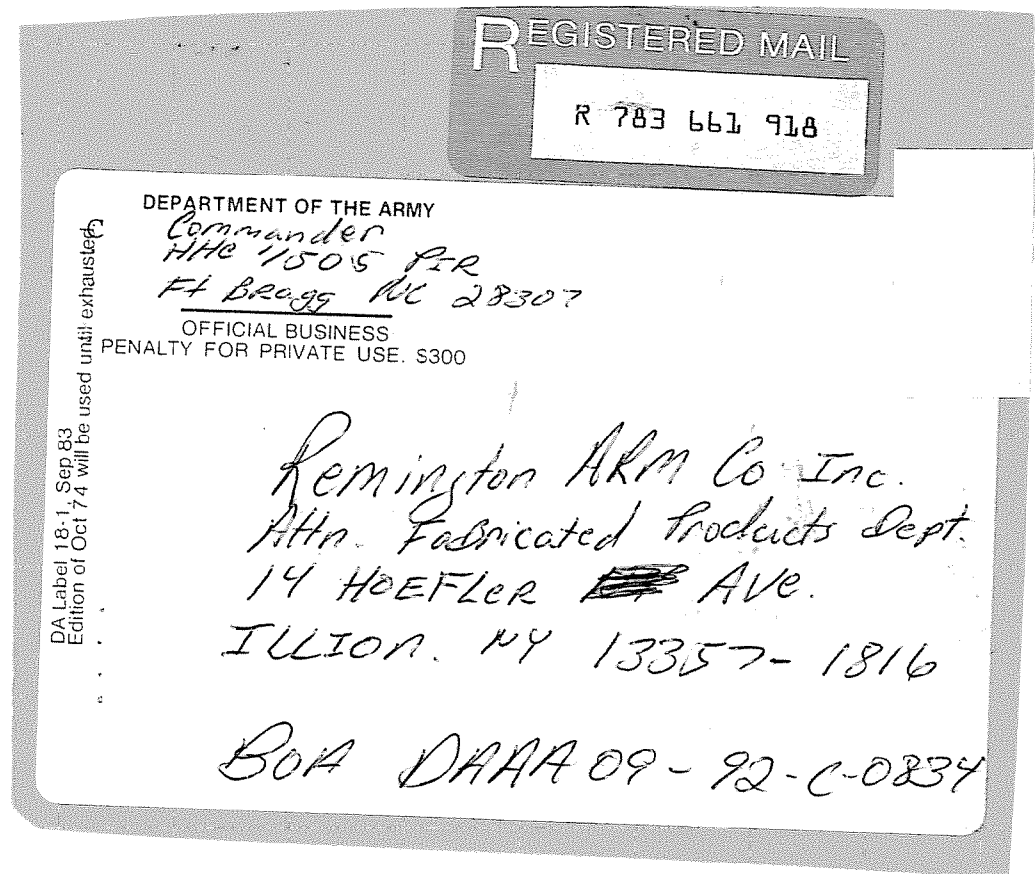
REPAIRMAN RW	PROOF ✓	CLEAN ✓	TEST ✓	TARGET ✓	PATTERN
GALLERY TESTER RW	DATE 2/20/95	DATE 3/13/95	DATE 3/13/95	DATE 3/13/95	DATE

OFFICE COPY

RD6925 REV. 1/94

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

BARBER - M24 0083207 0083246



OP. #	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and Stock		2/20/95	RW
600	Proof		2/20/95	RW
607	Check Headspace		2/20/95	RW
610	Dis-assemble Gun		2/20/95	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		3/13/95	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		3/13/95	RW
	C) Inspect Ejector Hole for Chamfer		3/13/95	RW
	D) Oil Firing Pin Ass'y		3/13/95	RW
	E) Adjust Trigger Pull to Min Setting and Stake			

op. #	BARBER - M24 0083210 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		3/13/95	RW
	A) Time			
	B) Malfunctions			
	C) Pierced Primers			
	D) Optical Clarity of Scope			
645	Inspect for Live Ammo		3/13/95	RW
655	Final Inspection			
	A) Headspace		3/14/95	RW
	B) Trigger Pull			
	C) Function		3/14/95	RW
660	Pack			

Final Inspection

Sn: C6225534 DATE REC'D: 2/2/95 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: _____

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06225534
28 Mar 1995

CENTROIDAL DISTANCES

0 TO	1	.181596
1 TO	2	.654643
1 TO	3	.309742
1 TO	4	.213841
1 TO	5	.0617171

0.000000

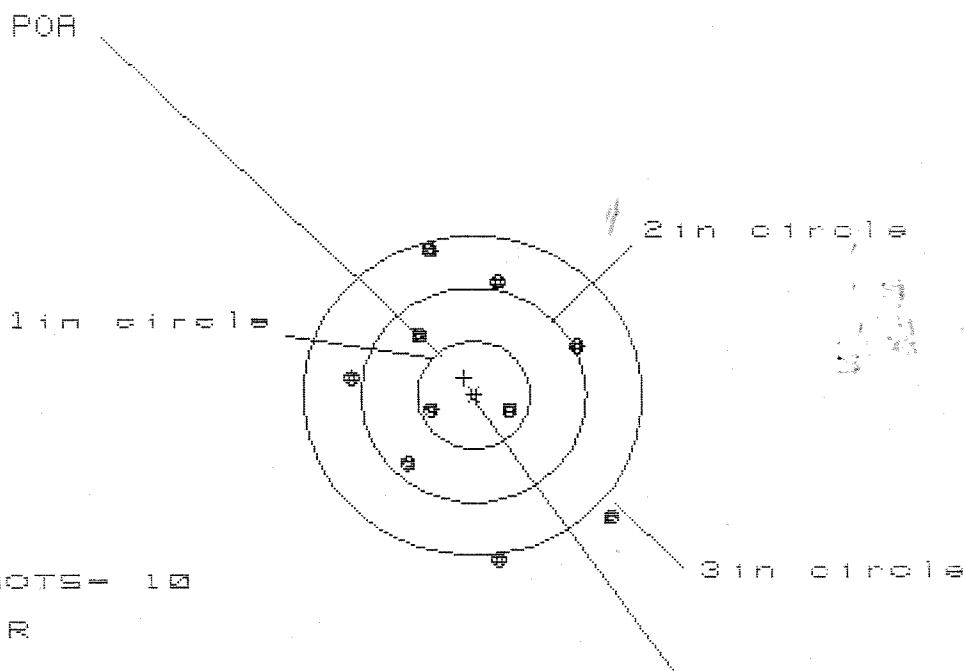
-----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .055
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0828
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0994024
THE AMR FOR THIS RIFLE IS: .966

26 Mar 1995

FILE:/PATTERNING/CENTERFIRE_PATT/08225534

CENTERFIRE PATTERNS # 1



OF SHOTS - 10

IN CIR

1 in = 2

2 in = 4

3 in = 8

HS= 2.251

VS= 2.844

GS= 2.927

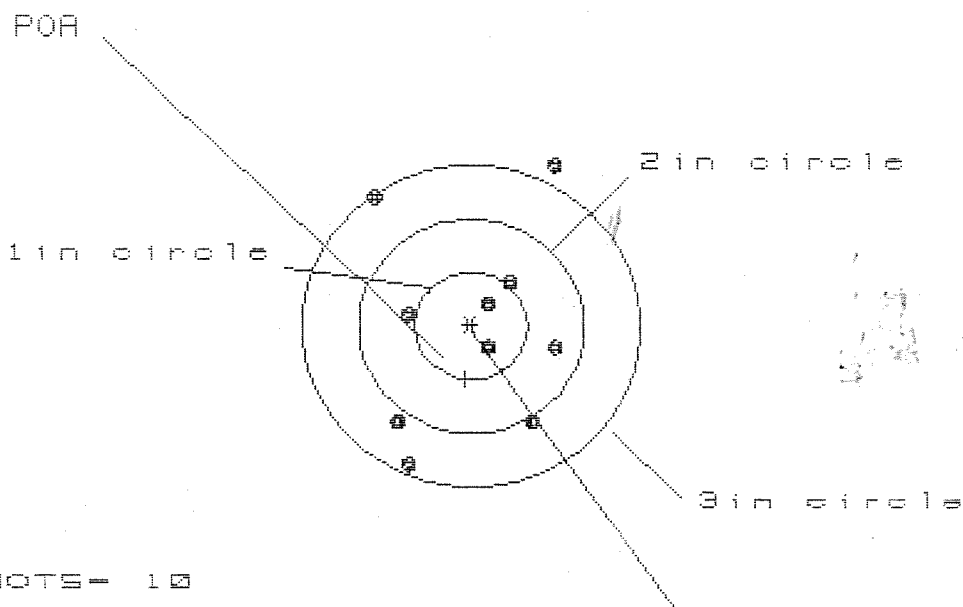
CENTROID #

PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.207	1.056	1.100
MINIMUM X	:	-1.044	-.910	-.866
MAXIMUM Y	:	1.327	1.200	.994
MINIMUM Y	:	-1.517	-1.644	-.932
CENTROID X	:	.084	-.050	-.094
CENTROID Y	:	-.161	-.034	.171
POA TO CENTROID in.	:	.182	.060	.196
MIN RADIUS	:	.332	.376	.405
MEAN RADIUS	:	1.001	.908	.799
MAX RADIUS	:	1.663	1.682	1.109
HORIZONTAL SPREAD	:	2.251	1.966	1.966
VERTICAL SPREAD	:	2.844	2.844	1.927
EXTREME SPREAD	:	2.927	2.903	1.986
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	4		
NUMBER IN THREE INCH CIRCLE	=	8		

28 Mar 1935

FILE:/PATTERNING/CENTERFIRE_PATT/C8225534

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 9

HS= 1.618

VS= 2.785

GS= 3.077

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.769	.848	.752
MINIMUM X	:	-.849	-.770	-.669
MAXIMUM Y	:	1.529	1.335	.782
MINIMUM Y	:	-1.256	-1.086	-.919
CENTROID X	:	.055	-.024	.072
CENTROID Y	:	.493	.323	.156
POA TO CENTROID in.	:	.496	.324	.172
MIN RADIUS	:	.210	.190	.184
MEAN RADIUS	:	.913	.829	.735
MAX RADIUS	:	1.687	1.541	1.105
HORIZONTAL SPREAD	:	1.618	1.618	1.421
VERTICAL SPREAD	:	2.785	2.421	1.701
EXTREME SPREAD	:	3.077	2.515	1.947
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

28 Mar 1995

FILE:/PATTERNING/CENTERFIRE_PATT/06225534

CENTERFIRE PATTERNS # 3

POA

1 in circle

2 in circle

3 in circle

OF SHOTS - 10

IN CIR

1 in = 0

2 in = 7

3 in = 10

HS = 2.238

VS = 1.782

GS = 2.443

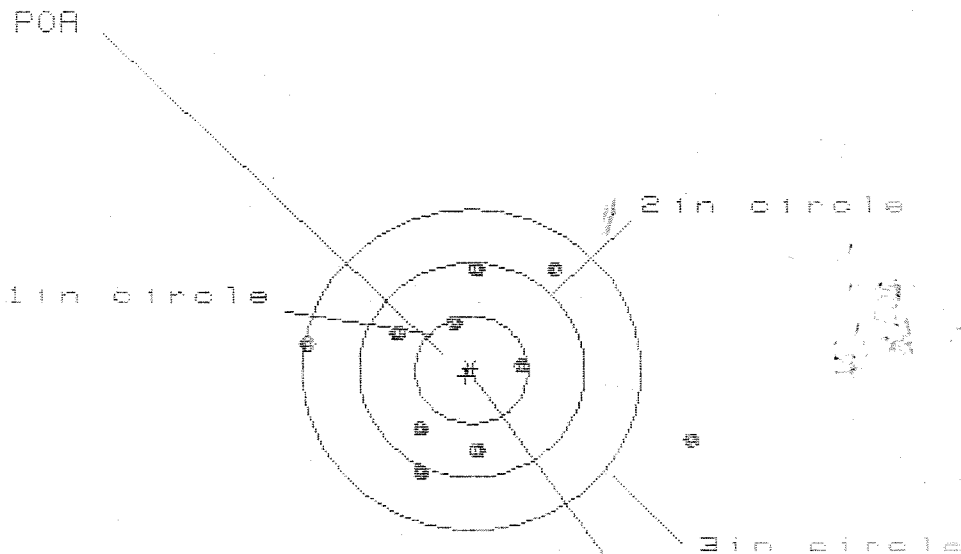
CENTROID *

PATTERN #	3	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.212	.859	.748
MINIMUM X	-1.026	-.891	-.732
MAXIMUM Y	.803	.875	.844
MINIMUM Y	-.979	-.907	-.938
CENTROID X	.036	-.099	.013
CENTROID Y	.145	.073	.104
POA TO CENTROID in.	.149	.123	.105
MIN RADIUS	.505	.453	.541
MEAN RADIUS	.871	.804	.781
MAX RADIUS	1.376	1.010	1.010
HORIZONTAL SPREAD	2.238	1.750	1.480
VERTICAL SPREAD	1.782	1.782	1.782
EXTREME SPREAD	2.443	1.939	1.939
NUMBER IN ONE INCH CIRCLE =		0	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		10	

28 Mar 1995

FILE:/PATTERNING/CENTERFIRE_PATT/CS225534

CENTERFIRE PATTERNS # 4



OF SHOTS = 10

IN CIR

1in = 1

2in = 5

3in = 8

HS = 3.389

VS = 1.921

GS = 3.512

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.895	.947	.787
MINIMUM X	-1.494	-1.284	-.598
MAXIMUM Y	.943	.868	.891
MINIMUM Y	-.978	-1.053	-1.030
CENTROID X	.056	-.154	.006
CENTROID Y	.051	.126	.103
POA TO CENTROID in.	.076	.199	.104
MIN RADIUS	.493	.409	.459
MEAN RADIUS	.987	.849	.788
MAX RADIUS	2.010	1.296	1.189
HORIZONTAL SPREAD	3.389	2.231	1.385
VERTICAL SPREAD	1.921	1.921	1.921
EXTREME SPREAD	3.512	2.336	2.238
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	8		

28 Mar 1995

FILE:/PATTERNING/CENTERFIRE_PATT/C8225534

CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 0

2in = 5

3in = 7

HS= 3.329

VS= 2.614

GS= 3.330

CENTROID *

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	1.642
MINIMUM X	-1.687
MAXIMUM Y	1.050
MINIMUM Y	-1.564
CENTROID X	.044
CENTROID Y	-.114
POA TO CENTROID in.	.122
MIN RADIUS	.567
MEAN RADIUS	1.058
MAX RADIUS	1.688
HORIZONTAL SPREAD	3.329
VERTICAL SPREAD	2.614
EXTREME SPREAD	3.330
NUMBER IN ONE INCH CIRCLE	0
NUMBER IN TWO INCH CIRCLE	5
NUMBER IN THREE INCH CIRCLE	7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C 6725534

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock			
600	Proof			
607	Check Headspace			
610	Dis-assemble Gun			
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			
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head			
	C) Inspect Ejector Hole for Chamfer			
	D) Oil Firing Pin Ass'y			
	E) Adjust Trigger Pull to Min Setting and Stake		7-23-91	981

BARBER - M24 0083219

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force							
	G) Safety Off Force							
	H) Trigger Pull Test & Retainability						7-23-91	XY
	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	15 RPs Test					7-24-91	D/H
	A) Time							
	B) Malfunctions							
	C) Pierced Primers							
	D) Optical Clarity of Scope							
645	Inspect for Live Ammo							
655	Final Inspection							
	A) Headspace							
	B) Trigger Pull	2.30	2.34	2.28	2.30	2.32	7-26-91	XY
	C) Function							
660	Pack							

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

SERIAL NO. C-6226534DATE 7-23-91TESTER JP

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.45	2.60	2.48	2.30	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.41	2.52	2.60	2.34	
PULL #3	2.45	2.50	2.55	2.28	
PULL #4	2.46	2.49	2.48	2.30	
PULL #5	2.49	2.51	2.46	2.32	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.21	3.55		
PULL #2	3.22	3.66		
PULL #3	3.54	3.65		
PULL #4	3.60	3.49		
PULL #5	3.59	3.40		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.18	4.46		4.48
PULL #2	4.40	4.48		4.50
PULL #3	4.36	4.50		4.38
PULL #4	4.40	4.53		4.55
PULL #5	4.41	4.51		4.56
TOTAL				
AVG.				

MAINTENANCE REQUEST						PAGE NO		NO OF PAGES		REQUIREMENTS CONTROL SYMBOL CSGLD - 1047(R1)			
For use of this form, see DA PAM 738-750; the proponent agency is DCSLOG													
SECTION I - EQUIPMENT DATA													
CONTROL NUMBER		WORK ORDER NO.			WESDC		ORG. PD		PD AUTHENTICATION <i>[Signature]</i>				
☐ Work Request ☐ MWO ☒ Warranty Claim		1A. ORGANIZATION <i>D20782 Maint</i>			B. LOCATION <i>#1 BRAGG NC</i>				C. UNIT IDENT CODE <i>W44400</i>				
2. SERIAL NO. <i>C6225534</i>		3. NOUN NOMENCLATURE <i>M24 K 11 7162</i>			4. LINE NO. <i>N/A</i>		5. MODEL		6. NATIONAL STOCK NUMBER <i>104-01-240 21-6</i>				
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) ☐ A Sch. Main. ☐ C Test ☐ E Storage ☐ G Flight ☐ B Handling ☐ D Normal Op ☐ F Inspection ☐ H Other													
15. FIRST INDICATION OF TROUBLE (Select one - use ☒ or X) ☐ 068 Inoperative ☐ 258 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). <i>Port and fuel system replaced</i>													
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) ☐ 1 TOE ☐ 2 TD ☐ 3 Contractor				19. AMS ACCT CODE			
B. LOCATION													
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									
					.					\$			
					.					\$			
					.					\$			
					.					\$			
					.					\$			
					.					\$			
					.					\$			
					.					\$			
					.					\$			
					.					\$			
					.					\$			
					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 <i>[Signature]</i>		24. RECEIVED BY		25. WORK STARTED BY		26. INSPECTED BY		27. ACCEPTED BY		28. DISPOSITION (Select One)			
JULIAN DATE <i>11/14</i>		JULIAN DATE		JULIAN DATE		JULIAN DATE		JULIAN DATE		☐ A To User ☐ D Evacuated ☐ B To Stock ☐ E Cannibalized ☐ C Salvaged			

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6225534

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	12 9	8 8	RW
600	Proof	12 9	8 8	RW
607	Check Headspace	12 9	8 8	RW
610	Dis-assemble Gun	12 9	8 8	RW
612	Magnaflux Barrel Action		12 22 88	Pfc.
	Magnaflux Bolt		1-3-89	Pfc.
615	Rollmark Caliber		12/22/88	WBC
617	Drill and Tap Sight Holes	12 9	8 8	FB
618	Polish Barrel	12 2	8 8	WJD
620	Apply Coatings (Barrel Action)		1/16/89	JA
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		2/7/89	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		2/7/89	RW
	C) Inspect Ejector Hole for Chamfer		2/7/89	RW
	D) Oil Firing Pin Ass'y		2/7/89	RW
	E) Adjust Trigger Pull to Min Setting and Stake		7/26/89	JS

op. #	BARBER - M24 0083224 OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	4	4			10/26/89	JS
	G) Safety Off Force	3	3	3			10/26/89	JS
	H) Trigger Pull Test & Retainability						7/26/89	JS
	I) Firing Pin Indent	.021	.0215	.022			10/26/89	JS
	J) Assemble Stock						3/1/89	RW
	K) Assemble Swivel Studs						7/26/89	JS
	L) Attach Front and Rear Sight Assemblies						3/1/89	RW
	M) Iron Sight Alignment						3/1/89	RW
	N) Detach Front & Rear Sights & place in numbered container						3/1/89	RW
	O) Attach Scope to Rifle						3/3/89	RW
	P) Detach & Attach Scope 20 Times						3/3/89	WVB
640	Gallery Target & Test	75 R	79 L				3/6/89	DH
	A) Time						3/6/89	DH
	B) Malfunctions						3/6/89	DH
	C) Pierced Primers						3/6/89	DH
	D) Optical Clarity of Scope						3/6/89	DH
645	Inspect for Live Ammo						3/6/89	DH
655	Final Inspection A) Headspace						7/26/89	JS
	B) Trigger Pull	2.69	2.75	2.75	2.75	2.64	7/26/89	JS
	C) Function						7/26/89	JS
660	Pack						22/26/89	JS

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

SERIAL NO. 5534
DATE 3-31-90
TESTER JEP

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#	COMMENTS
PULL #1	2.50	2.40	2.49	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.50	2.43	2.44	
PULL #3	2.46	2.38	2.43	
PULL #4	2.41	2.42	2.40	
PULL #5	2.38	2.42	2.38	
TOTAL	12.25	12.05	12.14	
AVG.	2.45	2.41	2.428	

	3.00# INITIAL	3.00# AFTER 20 CYCLES	COMMENTS
PULL #1	3.25	3.34	
PULL #2	3.18	3.36	
PULL #3	3.39	3.33	
PULL #4	3.34	3.30	
PULL #5	3.33	3.32	
TOTAL	16.49	16.65	
AVG.	3.298	3.33	

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.44	4.13		
PULL #2	4.37	4.20		
PULL #3	4.32	4.22		
PULL #4	4.38	4.16		
PULL #5	4.04	4.15		
TOTAL	21.55	20.86		
AVG.	4.31	4.172		

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C622534
8 Mar 1989

CENTROIDAL DISTANCES

0 TO	1	.300042
1 TO	2	.153473
1 TO	3	.196023
1 TO	4	.439355
1 TO	5	.148967

400 (----POB

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .175
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1484
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .204354
THE AMR FOR THIS RIFLE IS: .365

6 Mar 1989

FILE: /PATTERNING/CENTERFIRE_PATT/08225534

CENTERFIRE PATTERNS # 1

POA

1 in circle

2 in circle

3 in circle

* OF SHOTS = 10

* IN CIR

1 in = 2

2 in = 7

3 in = 10

HE = 2.502

VS = 2.104

GS = 2.665

CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.297	.900	.898
MINIMUM X	-1.205	-1.061	-1.071
MAXIMUM Y	1.320	1.243	.822
MINIMUM Y	-.784	-.861	-.705
CENTROID X	.243	.099	.109
CENTROID Y	.176	.252	.096
POA TO CENTROID IN.	.300	.270	.145
MIN RADIUS	.173	.313	.325
MEAN RADIUS	.862	.805	.729
MAX RADIUS	1.468	1.246	1.115
HORIZONTAL SPREAD	2.502	1.961	1.961
VERTICAL SPREAD	2.104	2.104	1.527
EXTREME SPREAD	2.665	2.109	2.363
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		10	

8 Mar 1989

FILE:/PATTERNING/CENTERFIRE_PATT/08223534

CENTERFIRE PATTERNS # 2

FOR

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS = 10

IN CIR

1 IN 2

2 IN 6

3 IN 10

HS = 2.145

VS = 2.521

ES = 2.766

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.013	1.083	.950
MINIMUM X	-1.132	-1.062	-.847
MAXIMUM Y	1.286	.881	.802
MINIMUM Y	-1.235	-1.092	-.982
CENTROID X	.316	.246	.379
CENTROID Y	.311	.168	.058
FOR TO CENTROID in.	.444	.298	.383
MIN RADIUS	.160	.237	.217
MEAN RADIUS	.842	.772	.660
MAX RADIUS	1.431	1.380	1.166
HORIZONTAL SPREAD	2.145	2.145	1.797
VERTICAL SPREAD	2.521	1.973	1.784
EXTREME SPREAD	2.766	2.402	2.006
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		10	

8 Mar 1989

FILE: /PATTERNING/CENTERFIRE_PATT/08283534

CENTERFIRE PATTERNS # 3

POA

1 in circle

2 in circle

3 in circle

CENTROID *

* OF SHOTS - 10

IN CIR

1 in = 3

2 in = 6

3 in = 10

HS = 2.363

VS = 2.593

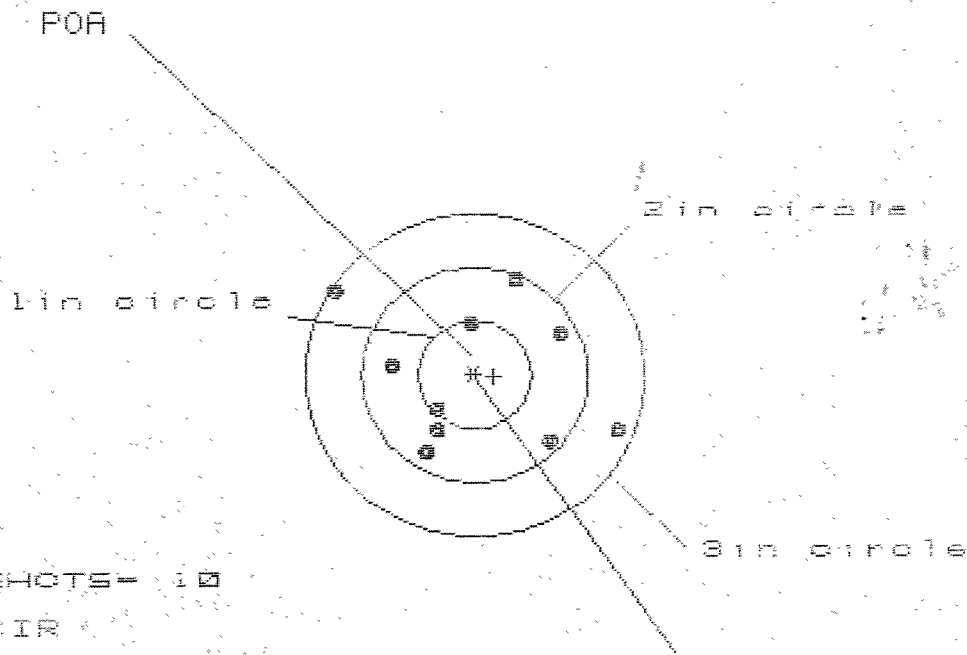
GS = 2.753

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.145	1.195	1.049
MINIMUM X	:	-1.218	-1.168	-.671
MAXIMUM Y	:	1.165	1.007	1.075
MINIMUM Y	:	-1.428	-.801	-.733
CENTROID X	:	.387	.337	.493
CENTROID Y	:	.043	.201	.123
POA TO CENTROID in.	:	.390	.392	.501
MIN RADIUS	:	.096	.248	.142
MEAN RADIUS	:	.897	.845	.770
MAX RADIUS	:	1.498	1.439	1.280
HORIZONTAL SPREAD	:	2.363	2.363	1.720
VERTICAL SPREAD	:	2.593	1.808	1.808
EXTREME SPREAD	:	2.753	2.719	2.425
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	

8 Mar 1989

FILE:/PATTERNING/CENTERFIRE PATT 06225534

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 2

2in = 7

3in = 10

HS= 2.475

VS= 1.648

GS= 2.789

CENTROID *

PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.248	1.112	.792
MINIMUM X	-1.227	-.830	-.691
MAXIMUM Y	.936	1.023	.972
MINIMUM Y	-.712	-.625	-.676
CENTROID X	-.165	-.029	-.168
CENTROID Y	.013	-.074	-.023
POA TO CENTROID in.	.166	.080	.170
MIN RADIUS	.446	.501	.425
MEAN RADIUS	.863	.797	.725
MAX RADIUS	1.458	1.185	1.040
HORIZONTAL SPREAD	2.475	1.942	1.483
VERTICAL SPREAD	1.648	1.648	1.648
EXTREME SPREAD	2.789	2.025	1.846
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		10	

8 Mar 1983

FILE:/PATTERNING/CENTERFIRE_PATT/08323334

CENTERFIRE PATTERNS # 5

POA

1 in circle

2 in circle

3 in circle

* OF SHOTS- 10

* IN CIR

1 in = 3

2 in = 5

3 in = 10

HS= 2.302

VS= 2.351

GS= 2.355

CENTROID *

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.225	1.223	.822
MINIMUM X	-1.077	-1.079	-.926
MAXIMUM Y	1.232	.905	.910
MINIMUM Y	-1.119	-.982	-.977
CENTROID X	.094	.096	-.057
CENTROID Y	.159	.022	.017
POA TO CENTROID in.	.185	.099	.059
MIN RADIUS	.161	.217	.296
MEAN RADIUS	.861	.807	.767
MAX RADIUS	1.232	1.285	1.186
HORIZONTAL SPREAD	2.302	2.302	1.753
VERTICAL SPREAD	2.351	1.887	1.887
EXTREME SPREAD	2.355	2.332	2.142
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		10	