G-6360 875
Rupkee
C.6225308

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: RE00085934 | Serial: C6225308 Model M24 SWS Center Fire Caliber: 7.62 NATO | Repairman: | Status: Closed 10/4/2004 10:56:39 AM

Verify Repair

Address Information

	Customer (Received From)	Return To (Received From)
Name	TRANSPORTATION OFFICER	TRANSPORTATION OFFICER
Address 1	SENSITIVE STORAGE	SENSITIVE STORAGE
Address 2	BLDG 9660 PO Box:	BLDG 9660 PO Box:
City	FORT LEWIS	FORT LEWIS
State / Zip Code / Country	WA 98433 US	WA 98433 US

FFL:

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

Contact Information

Phone: 253 967 5516
Fax:
Email:
Comments:

Received Condition

Fair
Condition Notes:
CSR Notes:

Accessories Received

Code	Desc	Qty
A007	With Studs	3
A017	Scope Base	3

Repair Search | Refresh | Close

negleij | 10/4/2004 | 11:26 AM | CAPS | NUM | INS | SCRL

start | 3 | 4

G6360875 (New)

Serial Number: C6225308

Model: M24 SWS

RE00085934

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFOMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6360875.__0
FILE DATE AND TIME: 11/08/2004 02:52

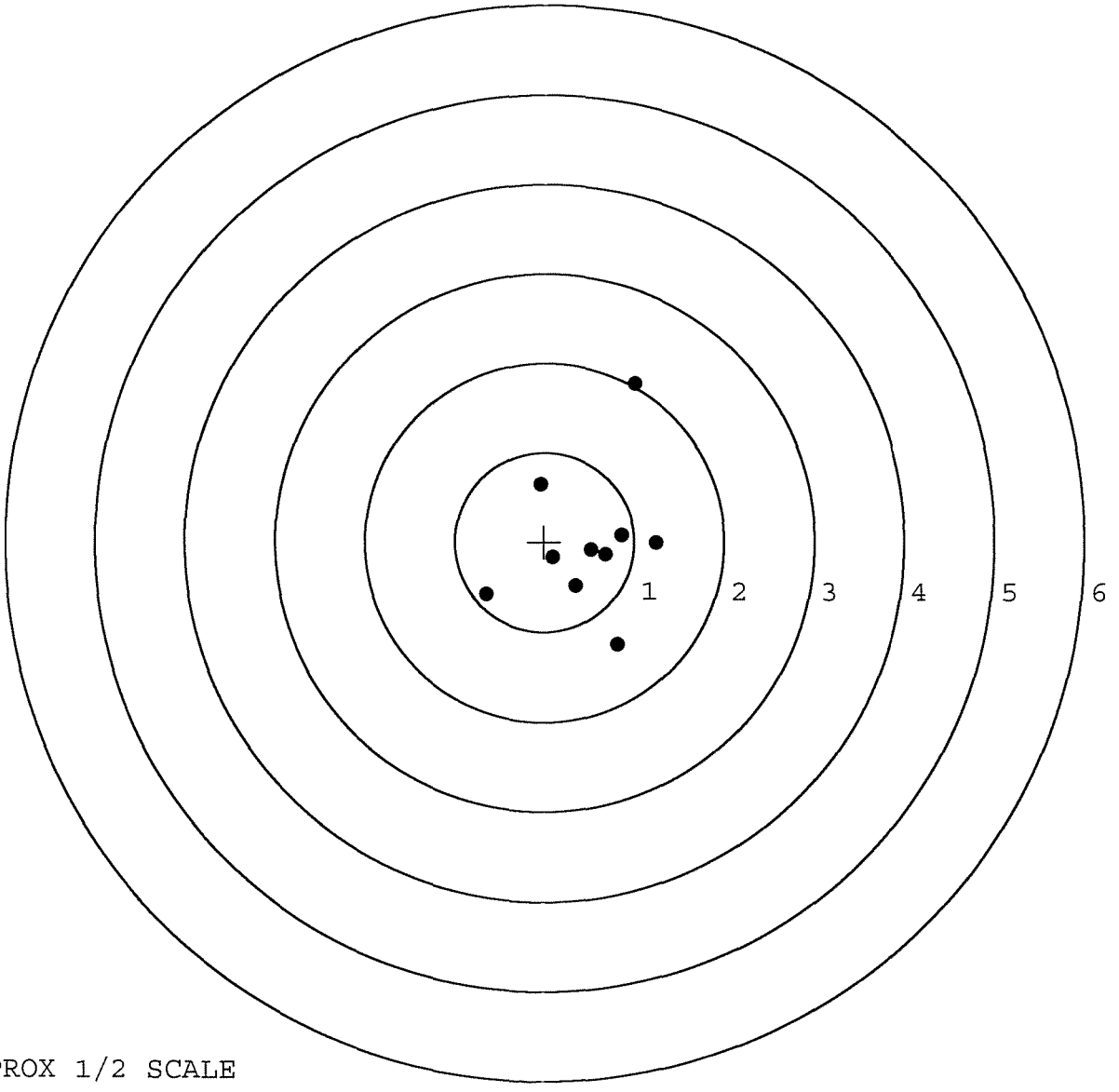
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.220
The Average Y Centroid of the Five Target Set:	0.030
The Average Point of Impact of the Five Target Set:	0.222
The Average Mean Radius of the Five Target Set:	0.657
The Distance from POA to Centroid Target #1:	0.488
The Distance from Centroid Target #2 to Centroid Target #1:	0.491
The Distance from Centroid Target #3 to Centroid Target #1:	0.317
The Distance from Centroid Target #4 to Centroid Target #1:	0.401
The Distance from Centroid Target #5 to Centroid Target #1:	0.275

SERIAL NUMBER: G6360875.__0
TARGET NUMBER: 1
FILE DATE: 11/08/2004
FILE TIME: 02:52

X CENTROID:	0.487
Y CENTROID:	-0.017
POA TO CENTROID:	0.488
HORZ SPREAD:	1.896
VERT SPREAD:	2.915
GROUP SPREAD:	2.921
MIN RADIUS:	0.081
MAX RADIUS:	1.860
MEAN RADIUS:	0.754
# IN 1 IN DIAMETER:	5
# IN 2 IN DIAMETER:	7
# in 3 IN DIAMETER:	9

POINT#	X	Y
1:	1.001	1.770
2:	-0.045	0.644
3:	-0.653	-0.590
4:	0.094	-0.175
5:	0.350	-0.495
6:	0.520	-0.092
7:	0.681	-0.146
8:	0.864	0.074
9:	1.243	-0.019
10:	0.817	-1.145

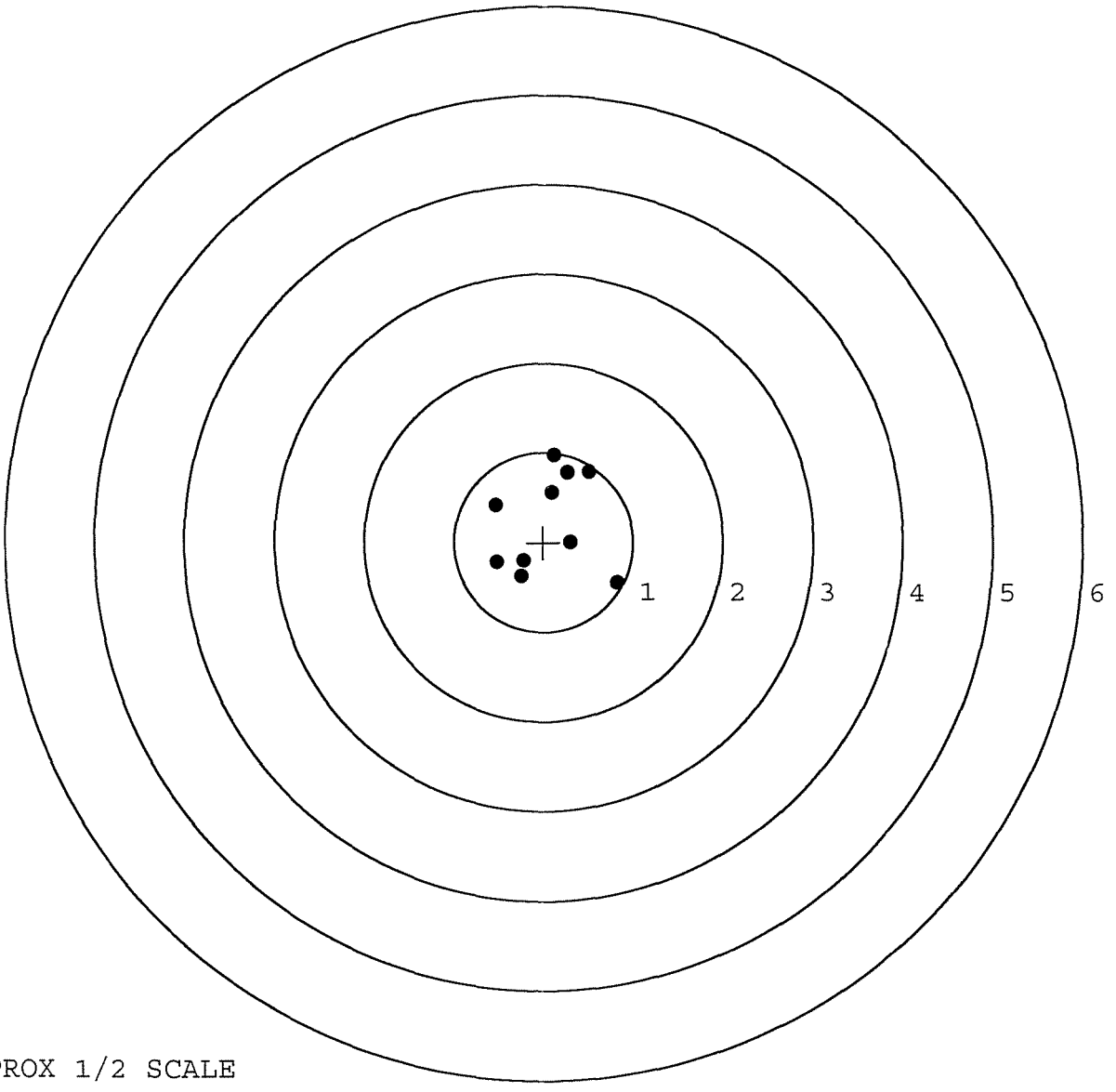


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6360875.__0
TARGET NUMBER: 2
FILE DATE: 11/08/2004
FILE TIME: 02:52

X CENTROID:	0.059
Y CENTROID:	0.223
POA TO CENTROID:	0.231
HORZ SPREAD:	1.361
VERT SPREAD:	1.417
GROUP SPREAD:	1.613
MIN RADIUS:	0.332
MAX RADIUS:	1.018
MEAN RADIUS:	0.631
# IN 1 IN DIAMETER:	2
# IN 2 IN DIAMETER:	9
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	0.513	0.781
2:	0.272	0.779
3:	0.094	0.555
4:	0.118	0.969
5:	-0.537	0.417
6:	-0.523	-0.224
7:	-0.222	-0.212
8:	-0.253	-0.383
9:	0.824	-0.448
10:	0.303	-0.002

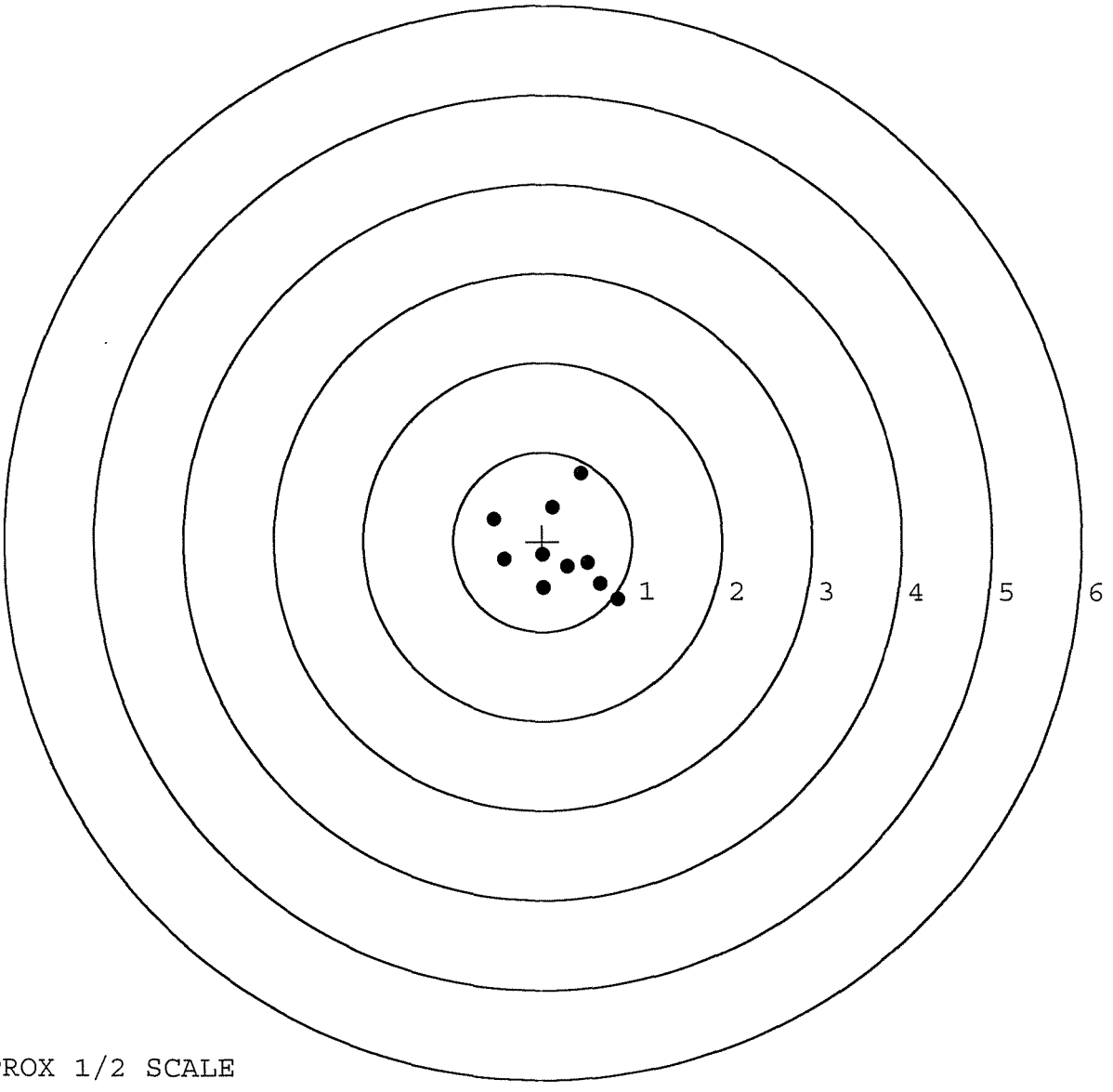


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6360875.__0
TARGET NUMBER: 3
FILE DATE: 11/08/2004
FILE TIME: 02:52

X CENTROID:	0.185
Y CENTROID:	-0.111
POA TO CENTROID:	0.215
HORZ SPREAD:	1.393
VERT SPREAD:	1.407
GROUP SPREAD:	1.467
MIN RADIUS:	0.192
MAX RADIUS:	0.908
MEAN RADIUS:	0.546
# IN 1 IN DIAMETER:	5
# IN 2 IN DIAMETER:	10
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	0.429	0.764
2:	0.113	0.382
3:	-0.549	0.253
4:	-0.431	-0.201
5:	-0.004	-0.147
6:	0.016	-0.520
7:	0.280	-0.285
8:	0.504	-0.245
9:	0.644	-0.467
10:	0.844	-0.643

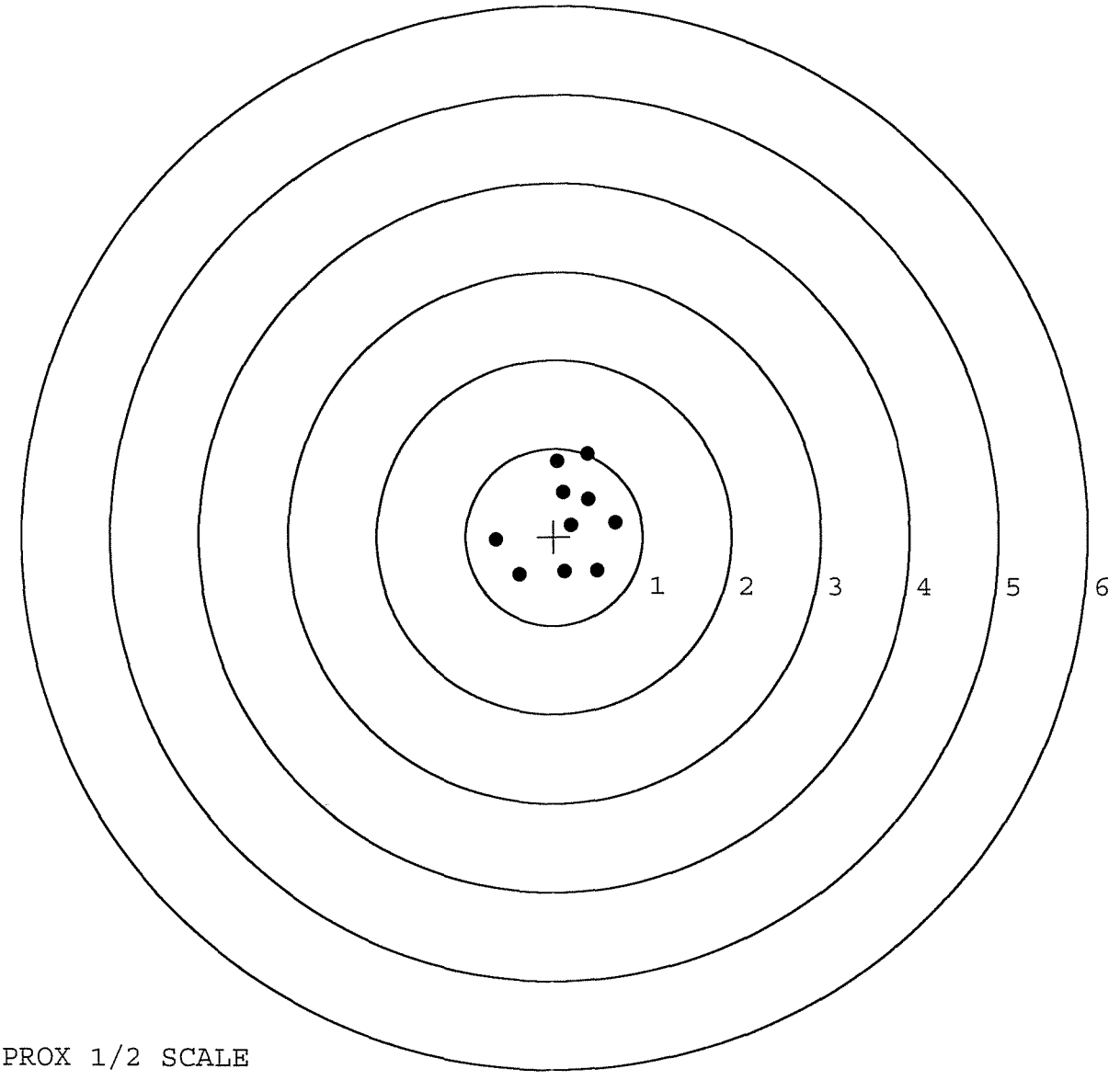


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6360875.__0
TARGET NUMBER: 4
FILE DATE: 11/08/2004
FILE TIME: 02:52

X CENTROID:	0.136
Y CENTROID:	0.177
POA TO CENTROID:	0.223
HORZ SPREAD:	1.349
VERT SPREAD:	1.367
GROUP SPREAD:	1.420
MIN RADIUS:	0.074
MAX RADIUS:	0.819
MEAN RADIUS:	0.565
# IN 1 IN DIAMETER:	3
# IN 2 IN DIAMETER:	10
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	0.040	0.859
2:	0.106	0.501
3:	0.381	0.422
4:	0.194	0.131
5:	0.695	0.161
6:	0.491	-0.381
7:	0.126	-0.395
8:	-0.391	-0.428
9:	-0.654	-0.040
10:	0.374	0.939

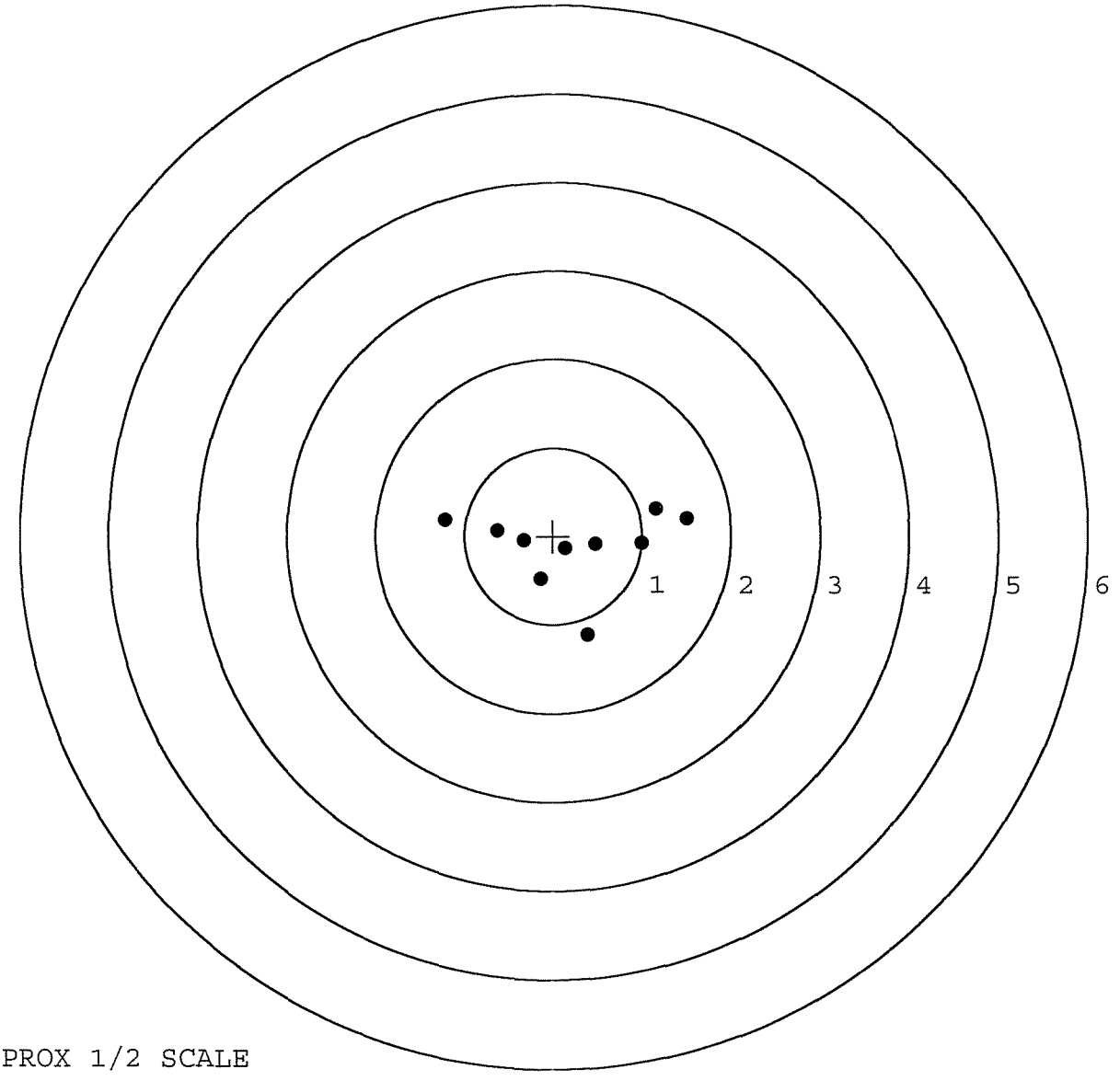


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6360875.__0
TARGET NUMBER: 5
FILE DATE: 11/08/2004
FILE TIME: 02:52

X CENTROID:	0.233
Y CENTROID:	-0.123
POA TO CENTROID:	0.264
HORZ SPREAD:	2.720
VERT SPREAD:	1.435
GROUP SPREAD:	2.720
MIN RADIUS:	0.099
MAX RADIUS:	1.481
MEAN RADIUS:	0.790
# IN 1 IN DIAMETER:	2
# IN 2 IN DIAMETER:	6
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	-1.215	0.188
2:	-0.630	0.060
3:	-0.330	-0.053
4:	-0.141	-0.493
5:	0.136	-0.143
6:	0.474	-0.092
7:	0.387	-1.125
8:	0.996	-0.084
9:	1.151	0.310
10:	1.505	0.200



TARGET APPROX 1/2 SCALE

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

R & E NUMBER			
SERIAL NUMBER	~~C622~~ 5308	6636087 5 (New)	
LOG-IN DATE	10-4-04		
INSPECT AND VERIFY:			
OPERATION #	OPERATION NAME	DATE	INITIAL
550	DIS-ASSEMBLE GUN	10-13-04	RTL
560 A	RE-BARREL	10-14-04	RTL
B	DRILL AND TAP	10-19-04	TRW
575	ASSEMBLE	10-15-04	RTL
600	PROOF	10-18-04	RTL
605	CHECK HEADSPACE	10-18-04	RTL
610	DIS-ASSEMBLE GUN	10-19-04	RTL
612	MAGNAFLUX	OPERATOR	
615	ROLLMARK CALIBER	10/20/04	KB
618	ROTO-BLAST	10-22-04	LTS
620	APPLY COATINGS	10/26/04	HP
625 A	FINAL ASSEMBLY	11-1-04	RTL
B	TRIGGER PULL TEST		
C	SAFETY "ON" FORCE		
D	SAFETY "OFF" FORCE		
E	FIRING PIN INDENT		
640	TARGET	11-1-04	RTL
655	FINAL INSPECT	11-8-04	RTL
660	PACK	11-8-04	DM
		SHIP DATE	
	QAR INSPECTION DATE		

RECEIVING AND ESTIMATING REPORT

R 95-21275

INITIAL	CUSTOMER ORDER NO.		
JJM		SNIPER M-24	

DATE RECEIVED	DATE OPENED	DATE CODE	SERIAL NUMBER	NEW SERIAL NUMBER	MODEL AND GRADE
08/28/95	08/29/95		C6225308		700 7.62 NATO

ACCESSORIES W/STUDS SCOPE BASE

FROM:

CDR
HHC 2/175 RGR
ATTN RAY FULLER
FT LEWIS WA 98433

SHIP TO:

CDR
HHC 2/175 RGR
ATTN RAY FULLER
FT LEWIS WA
98433

CUST NO: 124922 C.O.D

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	

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 Bolt Handle Broken

PARTS

Bolt Assy - 96005

W55H09 5348 #226

COMMENTS

REPAIRMAN	PROOF	CLEAN	TEST	TARGET	PATTERN
RW	✓	✓	✓		
GALLERY TESTER	**DATE**	**DATE**	**DATE**	**DATE**	**DATE**
RW	9/1/95	9/2/95	9/2/95		

OFFICE COPY

RD6925 REV. 1/94

For use of this form, see DA PAM 738-750; the proponent agency is DCSLOG. CSGLD-1047(R1)

SECTION I – EQUIPMENT DATA

CONTROL NUMBER	WORK ORDER NUMBER	WESDC	ORG PD	PD AUTHENTICATION
	BAR 9001		02	DBZ

WORK REQUEST / MWO / WARRANTY CLAIM	1a. ORGANIZATION	b. LOCATION	c. UNIT IDENT CODE
[X] WORK REQUEST [ ] MWO [ ] WARRANTY CLAIM	HHC 2d Bn 75th RGR RGT	Ft Lewis Wa 98433-5700	WH3MAA

2. SERIAL NO.	3. NOUN NOMENCLATURE	4. LINE NO.	5. MODEL	6. NATIONAL STOCK NUMBER
C622-5308	7.62mm SWS		M24	1005-01-240-2136

7. MAINTENANCE ACTIVITY	a. LEVEL	8. UTILIZATION CODE	9. MCSR ITEM	a. ERC	b. PACING ITEM	10. HOURS	11. MILES	12. ROUNDS	13. STARTS
Remington Arms									

14. FAILURE DETECTED DURING *(Select one · use √ or X)*

[ ] A Scheduled Maintenance [ ] C Test [ ] E Storage [ ] G Flight
[ ] B Handling [X] D Normal Op [ ] F Inspection [ ] H Other

15. FIRST INDICATION OF TROUBLE *(Select one · use √ or X)*

[X] 068 Inoperative [ ] 258 Overheating [ ] 790 Out of Adjustment
[ ] 008 Noisy [ ] 387 Low Performance [ ] Other

16. DESCRIBE DEFICIENCIES OR SYMPTOMS ON THE BASIS OF COMPLETE CHECKOUT AND DIAGNOSTIC PROCEDURE IN EQUIPMENT TM *(Do not prescribe repairs)*

Bolt Handle Broke During Live Fire Sniper Training

16a. REMARKS

POC: Mr Ray Fuller WG-10
Bn Armorer Tele. Nu. 967-8055

SECTION II – WORK ACCOMPLISHED

17a. REPAIR ORGANIZATION/ACTIVITY	c. UNIT IDENT CODE	18. TYPE ORGANIZATION/ACTIVITY ACCOMPLISHING WORK *(Select one · use √ or X)*	19. AMS ACCOUNT CODE
b. LOCATION		[ ] 1 TOE [ ] 2 TD [ ] 3 CONTRACTOR	

20a. ACT CODE	FAILURE CODE b	c. COMPONENT/PART NOUN, SVC, OR MWO NO. d. CB CODE	e. REF DESIGNATOR	f. MFR CODE	MANHOURS (Hrs & tenths) g	NATIONAL STOCK NUMBER h	PART SOURCE CODE i	QTY j	PARTS COST k

l. TOTAL MANHOURS	m. TOTAL MANHOURS COST	n. TOTAL PARTS COST
	$	$

21. DELAY *(Select one)* [ ] 1 Parts [ ] 2 Manpower [ ] 3 Facilities [ ] 4 Funds [ ] 5 Tools

22. [ ] DATA TRANSCRIBED

23. SUBMITTED BY	24. RECEIVED BY	25. WORK STARTED BY	26. INSPECTED BY	27. ACCEPTED BY	28. DISPOSITION *(Select one)*
Ray Fuller					[ ] A To User [ ] C Salvaged [ ] B To Stock [ ] D Evacuated
JULIAN DATE	JULIAN DATE	JULIAN DATE	JULIAN DATE	JULIAN DATE	

BARBER - M24 0084318

PACKING LIST

PACKED BY: MrRay Fuller WG-10 Bn Armorer

1. NO. BOXES: 1

2a. REQUISITION NO.:

2b. ORDER NO.:

3. END ITEM: 7.62mm SWS M24

4. DATE: 24 Aug 1995

5. PAGE 1 OF 1 PAGES

BOX NO. (a)	CONTENTS - STOCK NUMBER AND NOMENCLATURE (b)	UNIT OF ISSUE (c)	QUANTITIES REQUIRED: INITIAL OPERATION (d)	QUANTITIES REQUIRED: RUNNING SPARES (e)	QUANTITIES REQUIRED: TOTAL (f)
1	7.62mm SWS M24 Serial Nos. C622-5329 C622-5308	Ea			2

6. THIS CERTIFIES THAT ITEMS LISTED HEREON ARE WITHIN THE SPECIFIED BOXES

TYPED NAME AND TITLE: Ray Fuller WG-10 Bn Armorer

SIGNATURE: Ray Fuller

DD FORM 1 SEP 70 1750

Sws/Repair

Final Inspection

S/N: C6275308	DATE REC'D: 8/28/95	DATE RET'D:

AUDITOR: RW

Item:
Barrel Assy.
- ✓ Barrel
- ✓ Receiver
- ✓ Front Sight Block
- ✓ Rear Sight Block
- ✓ Screws
- ✓ Finish

Item:
Stock Assy.
- ✓ Stock
- ✓ Sling Swivel Studs
- ✓ Adjustable Butt Plate
- ✓ Lock Nuts
- ✓ Barrel Clearance
- ✓ Color/Finish

Scope Assy.
- ___ Scope
- ___ Scope Rings
- ___ Mounting Screws
- ___ Mounting Base
- ___ Screws
- ___ Finish
- ___ Looseness
- ___ Clarity

Systems Case
- ___ Scope Case
- ___ Iron Sights
- ___ Deployment Kit

Trigger
- ✓ Safety Operation
- ✓ Set
- ___

Misc.
- ___ DD-250
- ___ Bar Code
- ___ Packaging

Comments: _____

RECEIVING AND ESTIMATING REPORT

R 94-24900

INITIAL	CUSTOMER ORDER NO.	
FPS		M24 SNIPER PAINTED CAMO W/SCOPE MOUNTS

DATE RECEIVED	DATE OPENED	DATE CODE	SERIAL NUMBER	NEW SERIAL NUMBER	MODEL AND GRADE
08/29/94	08/30/94	DI 9-88	C6225398		700 7.62 NATO

ACCESSORIES W/STUDS

FROM:

DEPT OF THE ARMY
B CO ARMS
2/75 RANGER BATTALION
FT LEWIS WA 98433

SHIP TO:

DEPT OF THE ARMY
B CO ARMS
2/75 RANGER BATTALION
FT LEWIS WA
98433

CUST NO:062072 C.O.D.

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	

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 New Barrel

PARTS

Barrel 96093
Mag Spring 15677

COMMENTS

Repowder Coat Trigger Guard Assy Front & Rear Sight Base Reticle Scope Base & Rings & Swivel Studs

REPAIRMAN	PROOF	CLEAN	TEST	TARGET	PATTERN
RW	✓	✓	✓	✓	
GALLERY TESTER	**DATE**	**DATE**	**DATE**	**DATE**	**DATE**
RW	9/1/94	9/13/94	9/13/94	9/13/94	

OFFICE COPY

RD6925 REV. 1/94

PACKING LIST	PACKED BY: Mr. Ray Fuller WG-10 Bn. Armorer.	1. NO. BOXES: 1	2a. REQUISITION NO.: 94237
			2b. ORDER NO.
3. END ITEM: 7.62 mm M24 Sniper Weapons System (SWS)			4. DATE: 26 July 1994
			5. PAGE 1 OF 1 PAGES

BOX NO. (a)	CONTENTS - STOCK NUMBER AND NOMENCLATURE (b)	UNIT OF ISSUE (c)	QUANTITIES REQUIRED: INITIAL OPERATION (d)	RUNNING SPARES (e)	TOTAL (f)
	7.62 mm M24 Sniper Weapon System (SWS) Serial No. C6225308	Ea			1
	NSN: 1005-01-240-2136				
	Note: All Optic Scope Ring Mounts Packed				

6. THIS CERTIFIES THAT ITEMS LISTED HEREON ARE WITHIN THE SPECIFIED BOXES

TYPED NAME AND TITLE	SIGNATURE
Ray Fuller WG-10 Bn Armorer	Ray Fuller

DD FORM 1 SEP 70 1750

MAINTENANCE REQUEST

For use of this form, see DA PAM 738-750; the proponent agency is DCSLOG

PAGE NO.	NO. OF PAGES	REQUIREMENTS CONTROL SYMBOL
1		CSGLD - 1047(R1)

SECTION I - EQUIPMENT DATA

CONTROL NUMBER	WORK ORDER NO.	WESDC	ORG. PD	PD AUTHENTICATION
	94237		02	[signature] CPT, IN

- [X] Work Request
- [ ] MWO
- [ ] Warranty Claim

1A. ORGANIZATION	B. LOCATION	C. UNIT IDENT CODE
Bn Arms HHC 2/75 Rgr Rgt.	Fort Lewis Wa	WH3MAA

2. SERIAL NO.	3. NOUN NOMENCLATURE	4. LINE NO.	5. MODEL	6. NATIONAL STOCK NUMBER
C6225308	M24 SWS		M24	1005-01-240-2136

7A. MAINTENANCE ACTIVITY	B. LEVEL	8. UTILIZATION CODE	9A. MCSR ITEM	9B. ERC	9C. PACING ITEM	10. HOURS	11. MILES	12. ROUNDS	13. STARTS
Remington Arms Co Custom Shop									

14. FAILURE DETECTED DURING *(Select one - use ✓ or X)*

- [ ] A Sch. Main.
- [ ] B Handling
- [X] C Test
- [ ] D Normal Op
- [ ] E Storage
- [ ] F Inspection
- [ ] G Flight
- [ ] H Other

15. FIRST INDICATION OF TROUBLE *(Select one - use ✓ or X)*

- [ ] 068 Inoperative
- [ ] 008 Noisy
- [ ] 258 Overheating
- [ ] 387 Low Performance
- [ ] 790 Out of Adjustment
- [X] Other

16A. DESCRIBE DEFICIENCIES OR SYMPTOMS ON THE BASIS OF COMPLETE CHECKOUT AND DIAGNOSTIC PROCEDURE IN EQUIPMENT TM *(Do not prescribe repairs).*

This weapon has fired over 10,000 Rds. During Bench Rest Test Fire at 200/300 yds, groups were obtained exceeding the criteria of 2.6" @ 200 & 3.8" at 300 Yds. (5-10 Shot Group type) The criteria was provided by Mr Jim Glenn ARDEC DSN 880-7071

B. REMARKS

Request Re Barreling and Complete Weapon Recoutouring.

SECTION II - WORK ACCOMPLISHED

17A. REPAIR ORGANIZATION/ACTIVITY	C. UNIT IDENT. CODE	18. TYPE ORGANIZATION/ACTIVITY ACCOMPLISHING WORK *(Select one - use ✓ or X)*	19. AMS ACCT. CODE
B. LOCATION		[ ] 1 TOE [ ] 2 TD [ ] 3 Contractor	

20A. ACT. CODE	B. FAILURE CODE	C. COMPONENT/PART NOUN, SVC, OR MWO NO. (1) CB CODE	(2) REF DESIGN.	(3) MFR. CODE	D. MANHOURS *(Hrs. & tenths)*	E. NATIONAL STOCK NUMBER	F. PART SOURCE CODE	G. QTY.	H. PARTS COST
					.				$
					.				$
					.				$
					.				$
					.				$
					.				$
					.				$
					.				$
					.				$
				I. TOTAL MANHOURS		J. TOTAL MANHOURS COST $		K. TOTAL PARTS COST $	

21. DELAY *(Select One)* [ ] 1 Parts [ ] 2 Manpower [ ] 3 Facilities [ ] 4 Funds [ ] 5 Tools

22. [ ] Data Transcribed

23. SUBMITTED BY	24. RECEIVED BY	25. WORK STARTED BY	26. INSPECTED BY	27. ACCEPTED BY	28. DISPOSITION *(Select One)*
Ray Fuller					[ ] A To User [ ] B To Stock [ ] C Salvaged [ ] D Evacuated [ ] E Cannibalization
JULIAN DATE 4235	JULIAN DATE	JULIAN DATE	JULIAN DATE	JULIAN DATE	

Final Inspection

S/N: C6225308	DATE REC'D: 8/29/94	DATE RET'D:

AUDITOR: RW

Item:
BARREL ASSY.
- ✓ BARREL
- ✓ RECEIVER
- ✓ FRONT SIGHT BLOCK
- ✓ REAR SIGHT BLOCK
- ✓ SCREWS
- ✓ FINISH

Item:
STOCK ASSY.
- ✓ STOCK
- ✓ SLING SWIVEL STUDS
- ✓ ADJUSTABLE BUTT PLATE
- ✓ LOCK NUTS
- ✓ BARREL CLEARANCE
- ✓ COLOR/FINISH

SCOPE ASSY.
- ___ SCOPE
- ✓ SCOPE RINGS
- ✓ MOUNTING SCREWS
- ✓ MOUNTING BASE
- ✓ SCREWS
- ✓ FINISH
- ___ LOOSENESS
- ___ CLARITY

SYSTEMS CASE
- ___ SCOPE CASE
- ___ IRON SIGHTS
- ___ DEPLOYMENT KIT

TRIGGER
- ✓ SAFETY OPERATION
- ✓ SET
- ___

MISC.
- ___ DD-250
- ___ BAR CODE
- ___ PACKAGING

COMMENTS: _____

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6225308
15 Sep 1994

CENTROIDAL DISTANCES

Ø	TO	1	.131
1	TO	2	.155926
1	TO	3	.110603
1	TO	4	.20601
1	TO	5	.247881

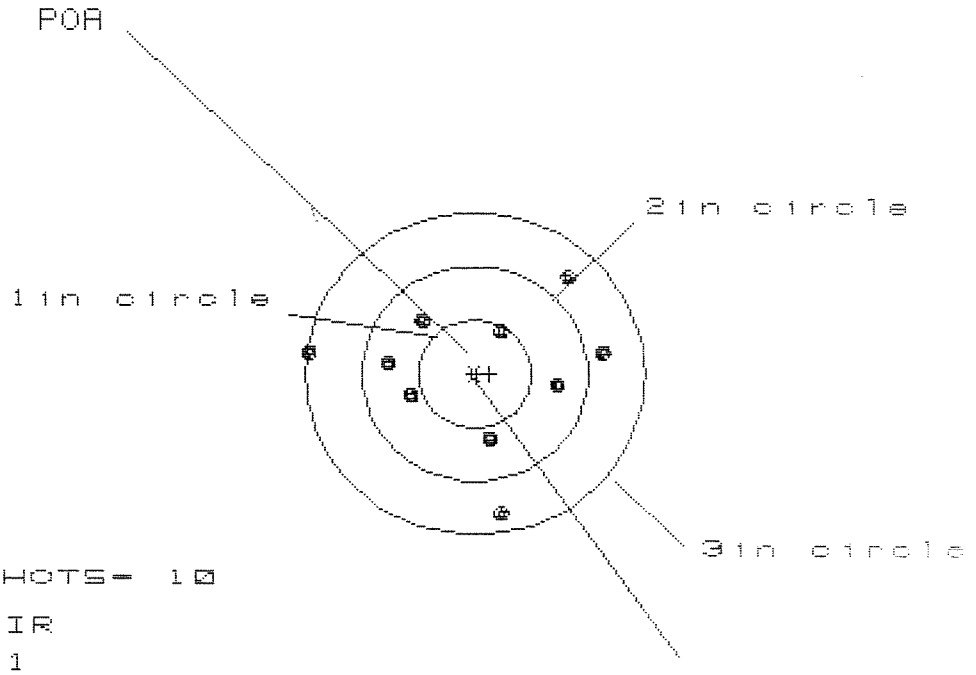
<----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0386
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0022
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0386626

THE AMR FOR THIS RIFLE IS: .8574

15 Sep 1994 FILE:/PATTERNING/CENTERFIRE_PATT/C6225308

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

# IN CIR
1in = 1
2in = 6
3in = 10

HS= 2.520
VS= 2.216
GS= 2.521

PATTERN # : 1

SHOTS (BEST OF) :	10	9	8
MAXIMUM X :	1.091	.932	.935
MINIMUM X :	-1.429	-.920	-.916
MAXIMUM Y :	.872	.889	.723
MINIMUM Y :	-1.344	-1.327	-.776
CENTROID X :	-.131	.028	.025
CENTROID Y :	-.000	-.017	.149
POA TO CENTROID in.:	.131	.033	.151
MIN RADIUS :	.466	.408	.256
MEAN RADIUS :	.905	.838	.758
MAX RADIUS :	1.437	1.327	1.017
HORIZONTAL SPREAD :	2.520	1.852	1.852
VERTICAL SPREAD :	2.216	2.216	1.499
EXTREME SPREAD :	2.521	2.319	1.858

NUMBER IN ONE INCH CIRCLE = 1
NUMBER IN TWO INCH CIRCLE = 6
NUMBER IN THREE INCH CIRCLE = 10

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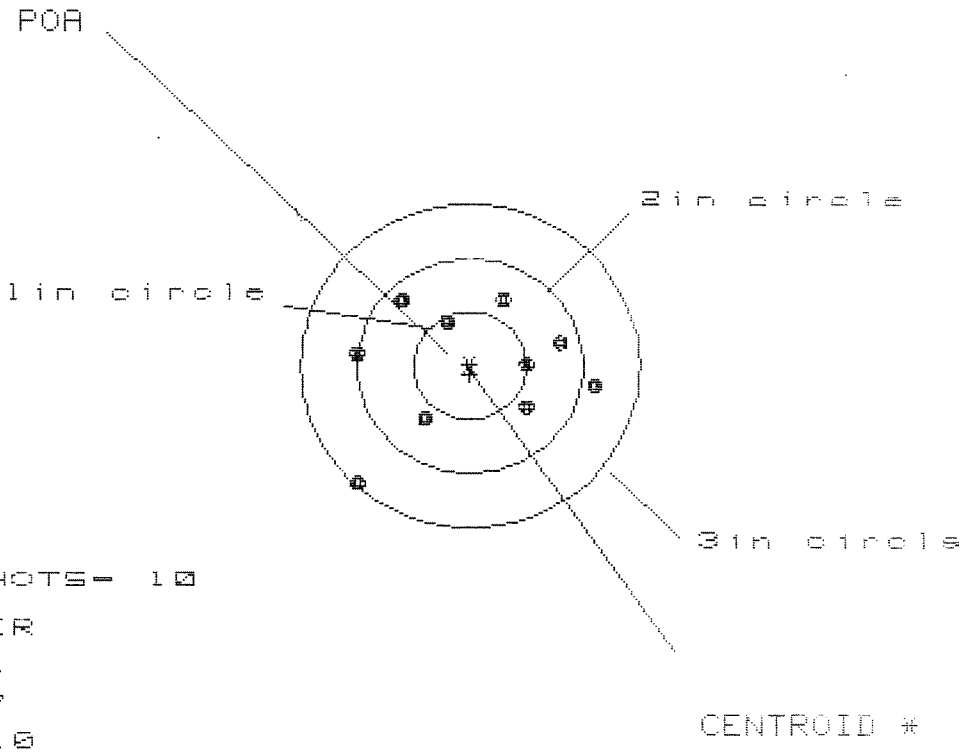
CENTERFIRE PATTERNS # 2



OF SHOTS= 10

# IN CIR
1in = 1
2in = 7
3in = 10

HS= 2.123
VS= 1.696
GS= 2.288

PATTERN # : 2

SHOTS (BEST OF) :	10	9	8
MAXIMUM X :	1.091	.976	.812
MINIMUM X :	-1.032	-1.114	-.992
MAXIMUM Y :	.662	.547	.510
MINIMUM Y :	-1.034	-.625	-.662
CENTROID X :	.001	.116	-.006
CENTROID Y :	.083	.198	.235
POA TO CENTROID in.:	.083	.229	.235
MIN RADIUS :	.421	.407	.292
MEAN RADIUS :	.836	.741	.703
MAX RADIUS :	1.461	1.115	.992
HORIZONTAL SPREAD :	2.123	2.090	1.804
VERTICAL SPREAD :	1.696	1.172	1.172
EXTREME SPREAD :	2.288	2.118	1.807
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		10	

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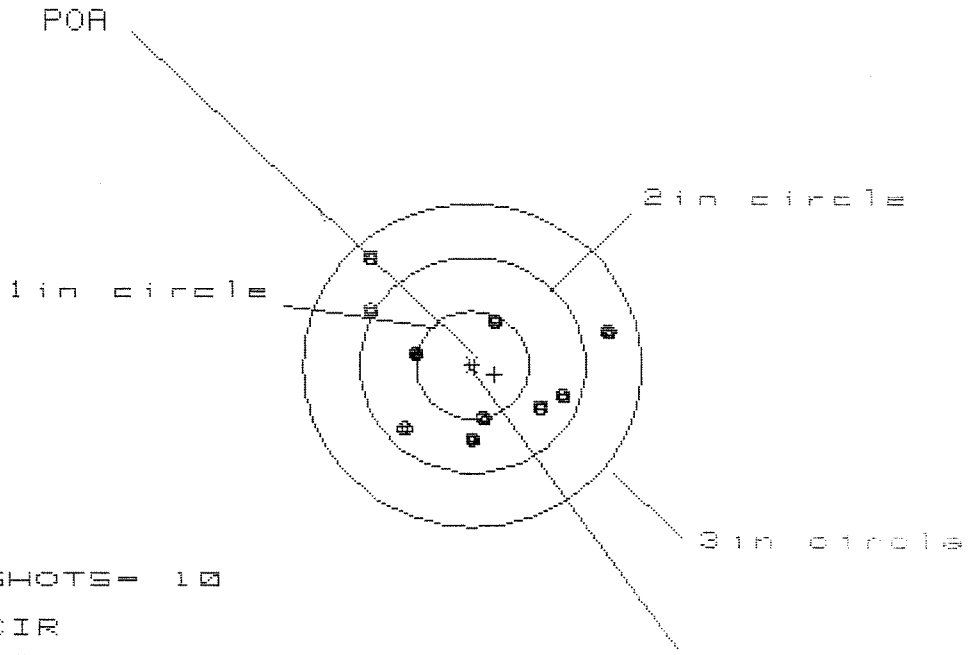
CENTERFIRE PATTERNS # 3



OF SHOTS= 10

# IN CIR
1in = 0
2in = 7
3in = 10

HS= 2.171
VS= 1.649
GS= 2.269

PATTERN #	:	3	
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.243	1.140	.856
MINIMUM X	:	-.928	-1.031	-.888
MAXIMUM Y	:	1.001	.603	.660
MINIMUM Y	:	-.648	-.537	-.480
CENTROID X	:	-.198	-.095	-.238
CENTROID Y	:	.088	-.023	-.080
POA TO CENTROID in.	:	.217	.098	.251
MIN RADIUS	:	.505	.395	.366
MEAN RADIUS	:	.827	.744	.671
MAX RADIUS	:	1.365	1.227	1.106
HORIZONTAL SPREAD	:	2.171	2.171	1.744
VERTICAL SPREAD	:	1.649	1.140	1.140
EXTREME SPREAD	:	2.269	2.176	1.909
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

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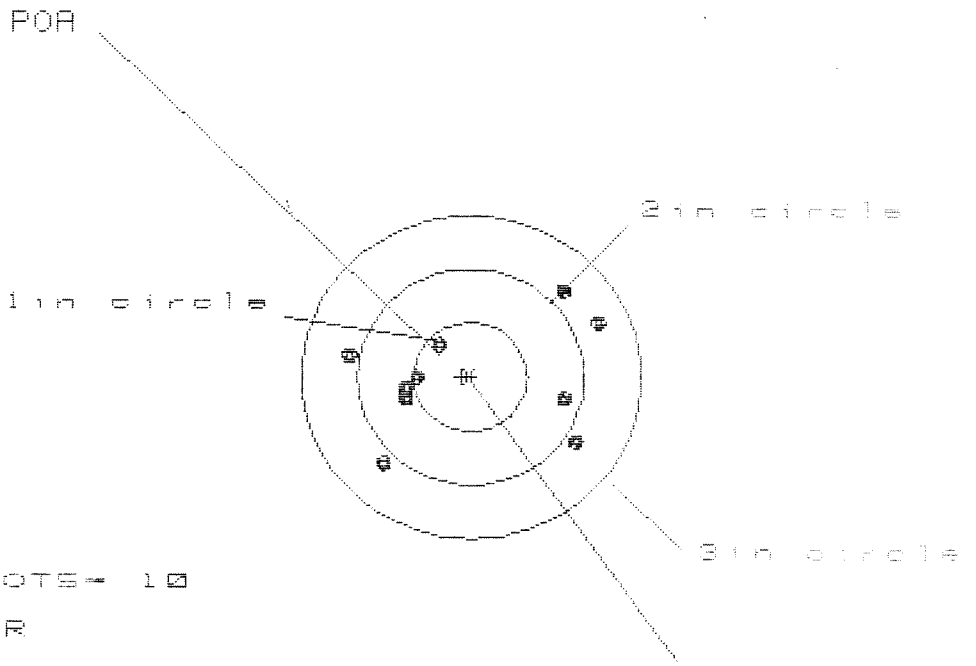
CENTERFIRE PATTERNS # 4



OF SHOTS= 10

# IN CIR
1in = 1
2in = 5
3in = 10

HS= 2.270
VS= 1.581
GS= 2.307

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.162	1.047	1.166
MINIMUM X	:	-1.108	-.979	-.860
MAXIMUM Y	:	.795	.851	.514
MINIMUM Y	:	-.786	-.730	-.623
CENTROID X	:	.075	-.054	-.173
CENTROID Y	:	-.002	-.058	-.165
POA TO CENTROID in.	:	.075	.079	.239
MIN RADIUS	:	.439	.392	.317
MEAN RADIUS	:	.875	.797	.698
MAX RADIUS	:	1.267	1.281	1.235
HORIZONTAL SPREAD	:	2.270	2.026	2.026
VERTICAL SPREAD	:	1.581	1.581	1.137
EXTREME SPREAD	:	2.307	2.234	2.179
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		10	

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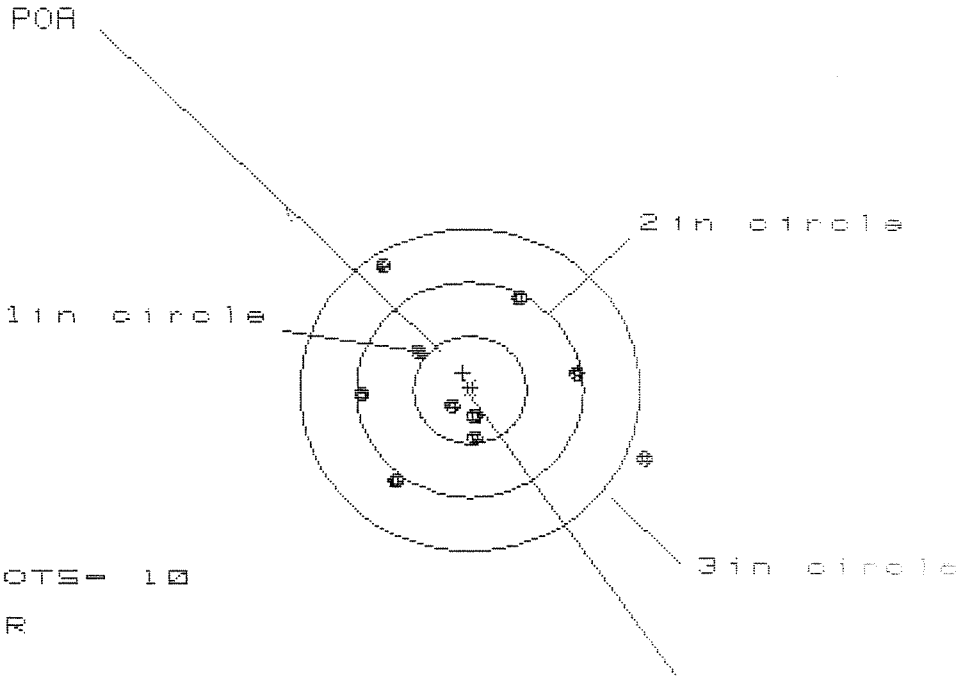
CENTERFIRE PATTERNS # 5



OF SHOTS= 10

# IN CIR
1in = 3
2in = 7
3in = 9

HS= 2.507
VS= 2.008
GS= 2.918

PATTERN # : 5

SHOTS (BEST OF) :	10	9	8
MAXIMUM X :	1.518	1.079	1.006
MINIMUM X :	-.989	-.821	-.894
MAXIMUM Y :	1.164	1.090	.873
MINIMUM Y :	-.844	-.918	-.782
CENTROID X :	.060	-.108	-.036
CENTROID Y :	-.158	-.084	-.220
POA TO CENTROID in.:	.169	.137	.223
MIN RADIUS :	.212	.210	.100
MEAN RADIUS :	.844	.748	.652
MAX RADIUS :	1.659	1.236	1.022
HORIZONTAL SPREAD :	2.507	1.900	1.900
VERTICAL SPREAD :	2.008	2.008	1.655
EXTREME SPREAD :	2.918	2.011	1.962

NUMBER IN ONE INCH CIRCLE = 3
NUMBER IN TWO INCH CIRCLE = 7
NUMBER IN THREE INCH CIRCLE = 9

M-24

CONTRACT # DAAA21-87-C-0086 New Barrel

GUN SERIAL # C6225308

OP. #	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and Stock		9/1/94	RW
600	Proof		9/1/94	RW
607	Check Headspace		9/1/94	RW
610	Dis-assemble Gun		9/1/94	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		9/2/94	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		9/12/94	RW
	C) Inspect Ejector Hole for Chamfer		9/12/94	RW
	D) Oil Firing Pin Ass'y		9/12/94	RW
	E) Adjust Trigger Pull to Min Setting and Stake			

op. #	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		9/12/94	WB
	A) Time		9/12/94	WB
	B) Malfunctions		9/12/94	WB
	C) Pierced Primers		9/12/94	WB
	D) Optical Clearity of Scope		9/12/94	WB
645	Inspect for Live Ammo		9/12/94	RW
655	Final Inspection A) Headspace		9/14/94	RW
	B) Trigger Pull	2.49 2.64 2.36 2.42 2.44	9/14/94	RW
	C) Function		9/12/94	RW
660	Pack			

1028

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6225308

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		7/88	RW
612	Magnaflux Barrel Action		9-14-88	RJC
	Magnaflux Bolt		9-14-88	RJC
615	Rollmark Caliber			
617	Drill & Tap Sight Holes			
618	Polish Barrel			
620	Apply Coatings (Barrel Action)		10-31-88	TJA
	Apply Coatings (Bolt)		10-31-88	TJA
625	Final Assembly A)Clean inside of Bolt Assembly		11/4/88	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		11/4/88	RW
	C) Inspect Ejector Hole for Chamfer		11/4/88	RW

OVER

OP.#		READINGS	DATE	INITIALS
625 cont.	D) Oil Firing Pin Ass'y		11/4/88	RW
	E) Adjust Trigger Pull to Min. Setting and Stake		7 NOV 88	JH
	F) Safety on Force	5 | 5 | 5	8 NOV 88	JH
	G) Safety off Force	3 | 3 | 3	8 NOV 88	JH
	H) Trigger Pull Test & Retainabilty		7 NOV 88	JH
	I) Firing Pin Indent	.0205 | .0205 | .021	8 NOV 88	JH
	J) Assemble Stock		11/10/88	RW
	K) Assemble Swivel Studs		30 NOV 88	JH
	L) Attach Front & Rear Sight Assemblies		11/10/88	RW
	M) Iron Sight Alignment		11/10/88	RW
	N) Detach Front & Rear Sights & place in numbered container		11/10/88	RW
	0) Attach Scope to Rifle		11/11/88	RW
	P) Detach & Attach Scope 20 times		11 NOV 88	JH
640	Gallery Target & Test	62 R 91L	11-11-88	AC
	A) Optical Clearity of Scope		11-11-88	JH
645	Inspect for Live Ammo		11-11-88	JH
655	Final Inspection A) Headspace		30 NOV 88	JH
	B) Trigger Pull		30 NOV 88	JH
	C) Function		30 NOV 88	JH
660	Pack		14 Dec 88	RH

SWS TRIGGER PULL TEST

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

SERIAL NO. C 622 5308

DATE 11-7-88

TESTER D.U.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.50	2.56	2.72	2.45	MIN. SETTING,
PULL #2	2.52	2.47	2.58	2.35	NO AVG. OF 5
PULL #3	2.47	2.48	2.44	2.33	READINGS ACCEPT-
PULL #4	2.46	2.51	2.55	2.37	ABLE LESS THAN 2#
PULL #5	2.41	2.37	2.45	2.28	
TOTAL	12.36	12.39	12.74	11.68	
AVG.	2.472	2.478	2.548	2.336	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.06	2.94		
PULL #2	2.95	3.09		
PULL #3	3.05	3.07		
PULL #4	3.09	3.08		
PULL #5	2.93	3.11		
TOTAL	15.08	15.29		
AVG.	3.016	3.058		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.18	4.00		4.28
PULL #2	4.00	4.03		4.36
PULL #3	4.03	3.98		4.36
PULL #4	4.01	4.06		4.32
PULL #5	4.09	4.14		4.34
TOTAL	20.31	20.21		21.66
AVG.	4.062	4.042		4.332

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6225308

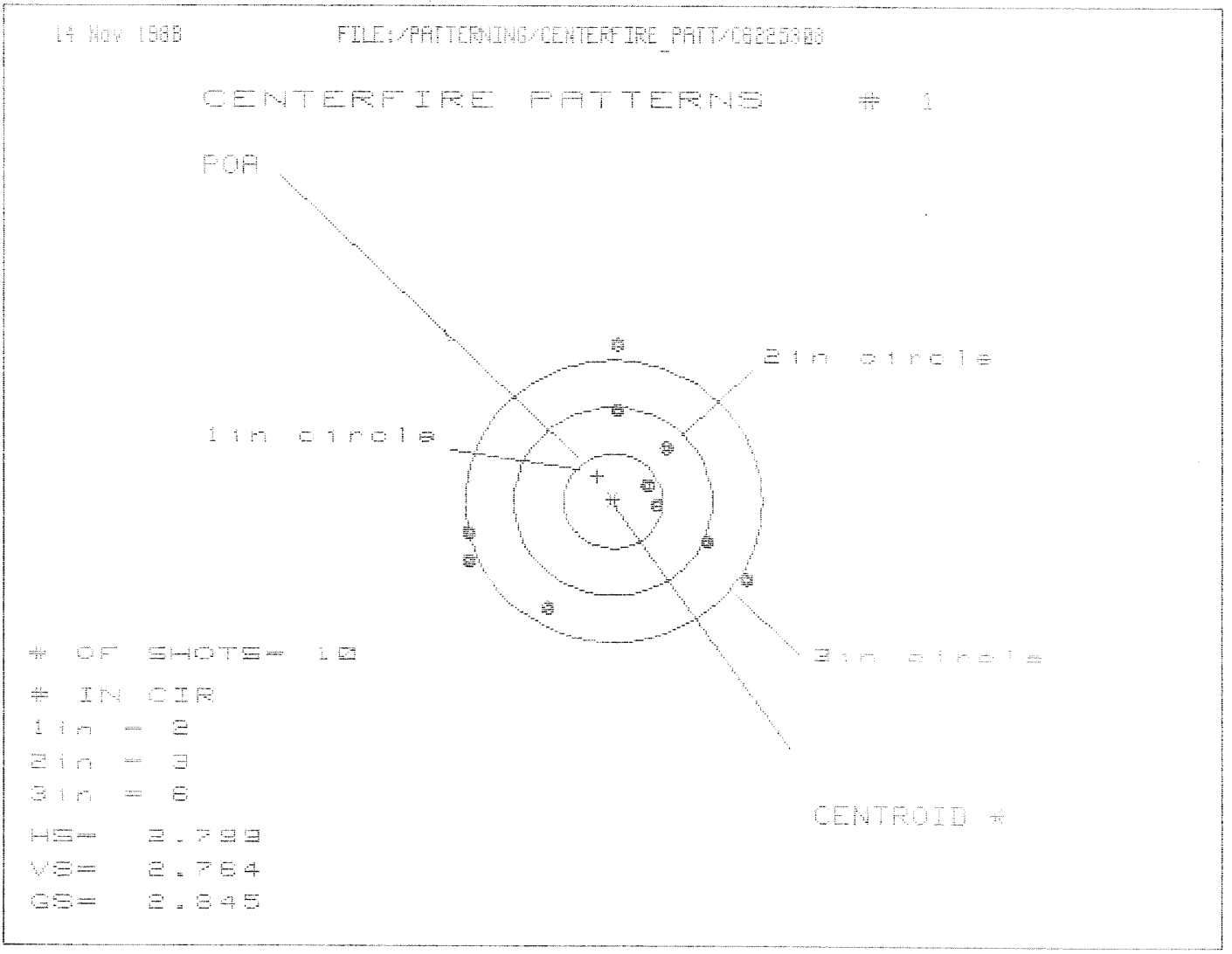
CENTROIDAL DISTANCES

0	TO	1	.313338
1	TO	2	.272868
1	TO	3	.060407
1	TO	4	.265113
1	TO	5	.458402

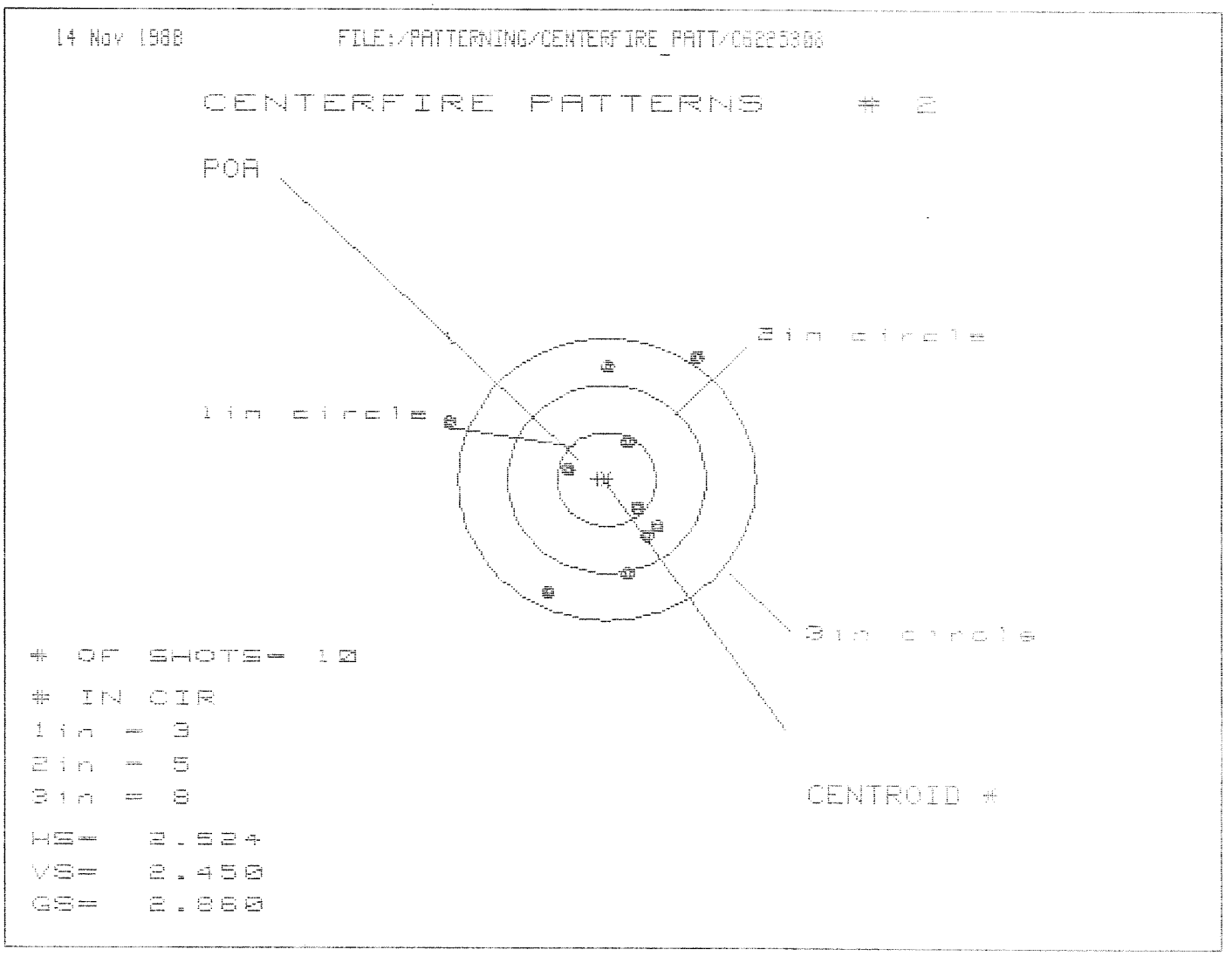
<---POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .146
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.2584
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .296794

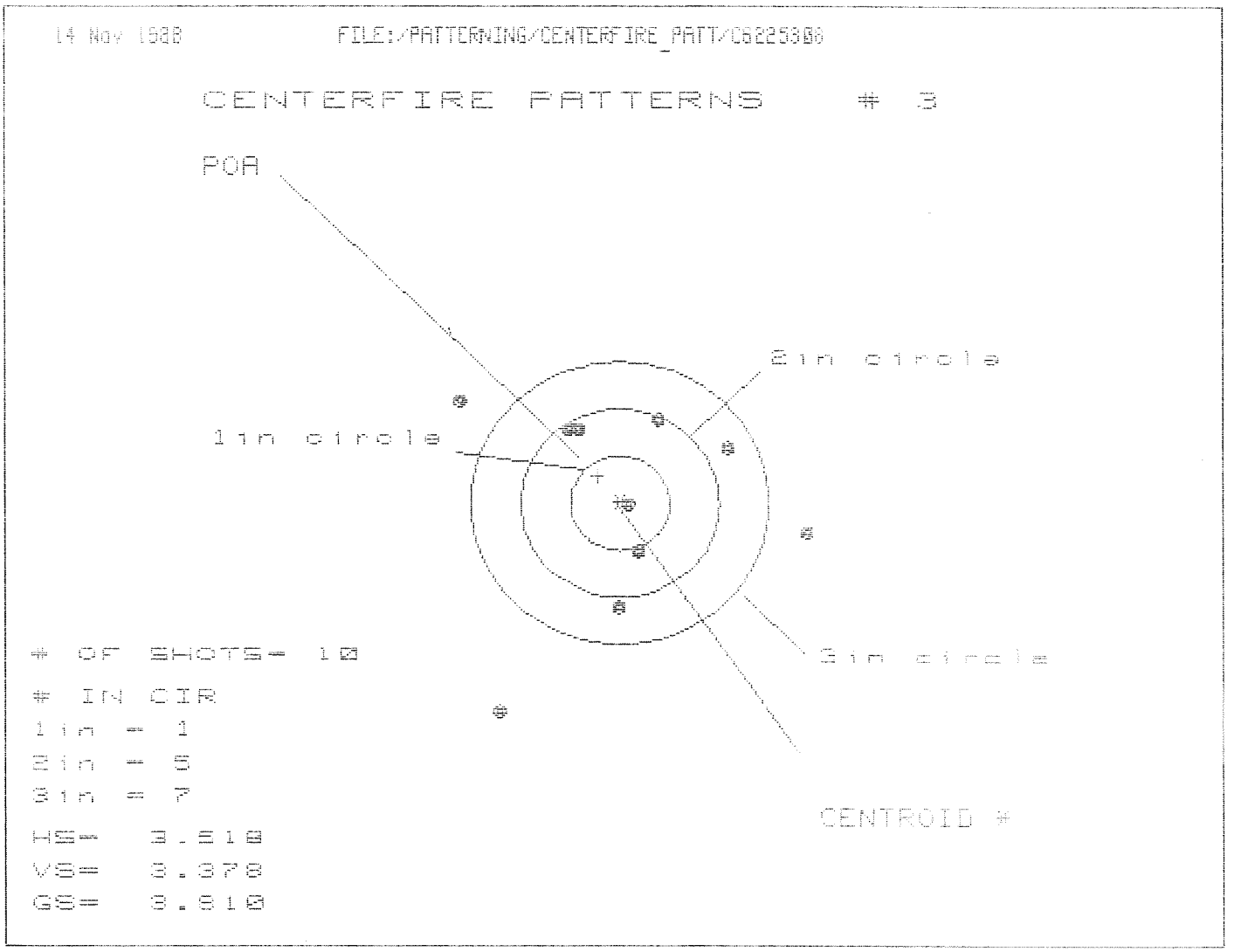
THE AMR FOR THIS RIFLE IS: 1.1



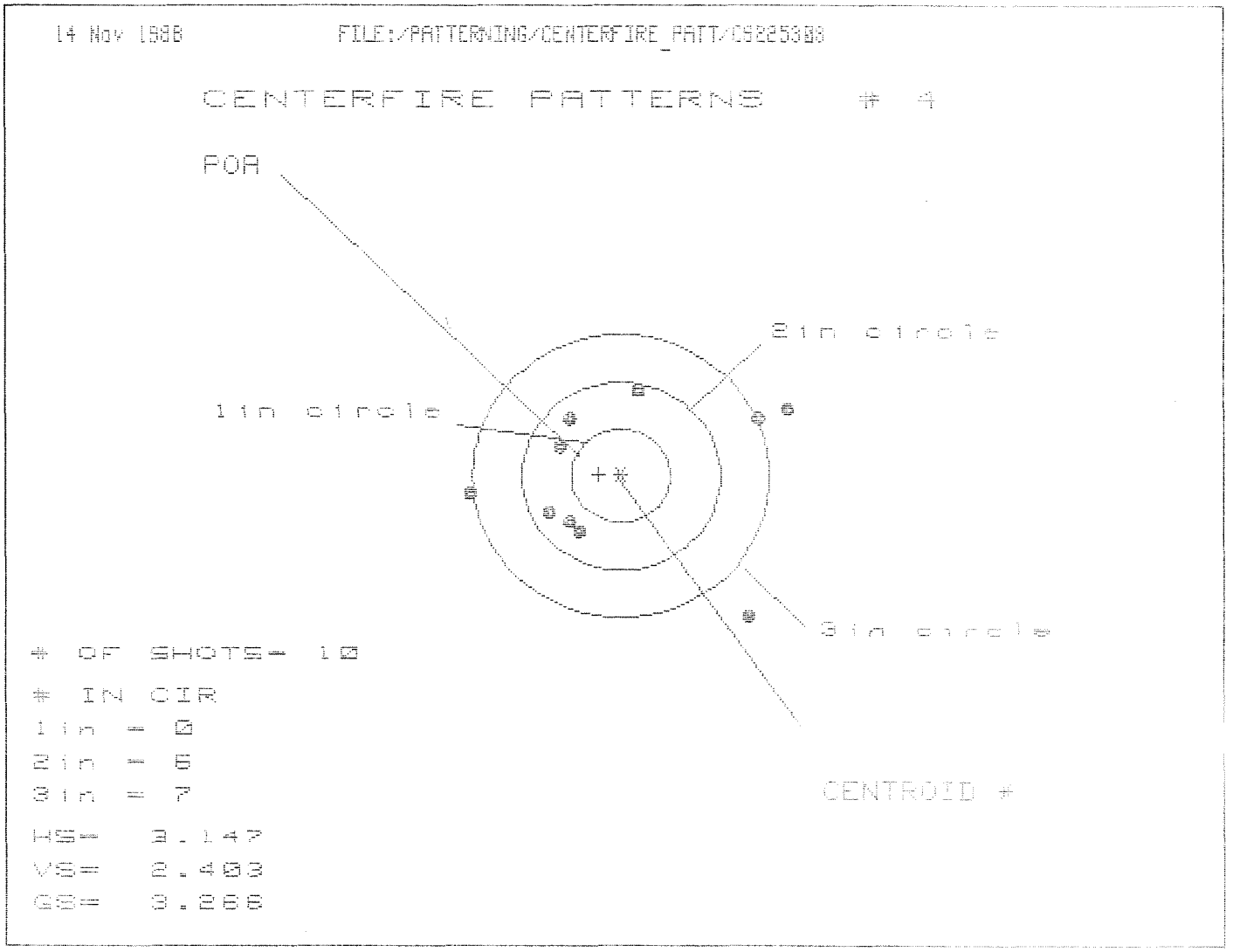
PATTERN #	:	[redacted]		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.299	1.304	1.117
MINIMUM X	:	-1.500	-1.495	-1.670
MAXIMUM Y	:	1.673	1.199	1.142
MINIMUM Y	:	-1.091	-.905	-.962
CENTROID X	:	.159	.154	.341
CENTROID Y	:	-.270	-.456	-.399
POA TO CENTROID in.	:	.314	.482	.525
MIN RADIUS	:	.394	.483	.288
MEAN RADIUS	:	1.131	1.076	.958
MAX RADIUS	:	1.674	1.564	1.684
HORIZONTAL SPREAD	:	2.799	2.799	2.787
VERTICAL SPREAD	:	2.764	2.104	2.104
EXTREME SPREAD	:	2.845	2.835	2.835
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		6	



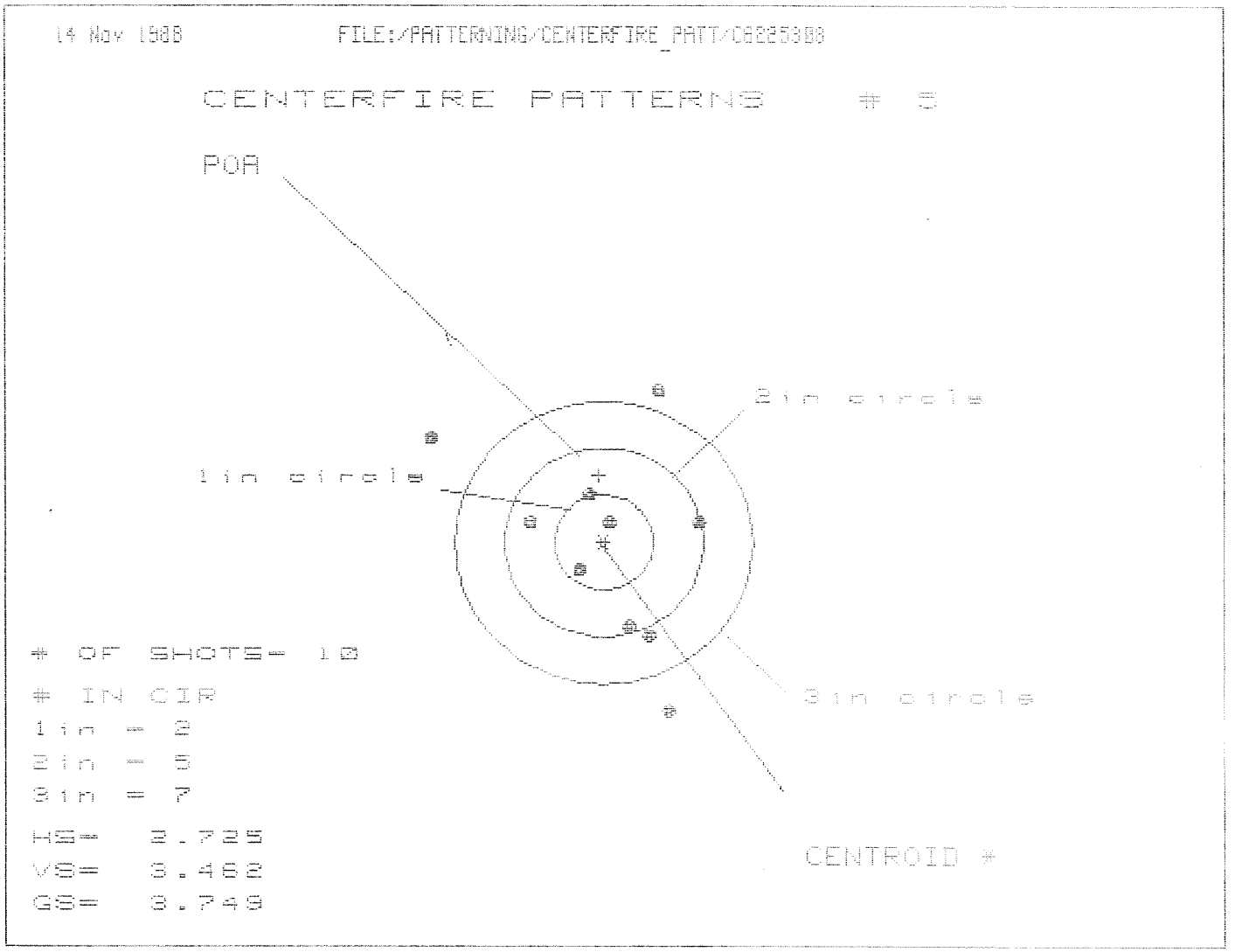
PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.917	.738	.300
MINIMUM X	:	-1.607	-.737	-.644
MAXIMUM Y	:	1.272	1.340	1.403
MINIMUM Y	:	-1.178	-1.110	-.942
CENTROID X	:	.090	.269	.176
CENTROID Y	:	-.006	-.074	-.242
POA TO CENTROID in.	:	.090	.279	.299
MIN RADIUS	:	.346	.240	.250
MEAN RADIUS	:	.931	.810	.700
MAX RADIUS	:	1.721	1.530	1.407
HORIZONTAL SPREAD	:	2.524	1.475	1.024
VERTICAL SPREAD	:	2.450	2.450	2.345
EXTREME SPREAD	:	2.860	2.860	2.407
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	



PATTERN #	:	[redacted]		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.932	1.796	1.203
MINIMUM X	:	-1.586	-1.722	-1.497
MAXIMUM Y	:	1.122	.871	.797
MINIMUM Y	:	-2.256	-1.340	-1.413
CENTROID X	:	.216	.352	.127
CENTROID Y	:	-.290	-.039	.034
POA TO CENTROID in.	:	.362	.354	.132
MIN RADIUS	:	.105	.225	.353
MEAN RADIUS	:	1.232	1.059	.944
MAX RADIUS	:	2.564	1.930	1.696
HORIZONTAL SPREAD	:	3.518	3.518	2.700
VERTICAL SPREAD	:	3.378	2.211	2.211
EXTREME SPREAD	:	3.810	3.810	2.751
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		7	



PATTERN #	:	[redacted]		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.634	1.773	1.722
MINIMUM X	:	-1.513	-1.374	-1.153
MAXIMUM Y	:	.875	.705	.773
MINIMUM Y	:	-1.528	-.714	-.646
CENTROID X	:	.220	.081	-.140
CENTROID Y	:	-.012	.158	.090
POA TO CENTROID in.	:	.221	.178	.167
MIN RADIUS	:	.702	.526	.372
MEAN RADIUS	:	1.148	1.012	.843
MAX RADIUS	:	1.975	1.854	1.792
HORIZONTAL SPREAD	:	3.147	3.147	2.875
VERTICAL SPREAD	:	2.403	1.419	1.419
EXTREME SPREAD	:	3.266	3.266	2.973
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		7	



PATTERN #	:	[redacted]		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.979	.785	.838
MINIMUM X	:	-1.746	-.922	-.869
MAXIMUM Y	:	1.648	1.770	1.558
MINIMUM Y	:	-1.814	-1.692	-1.057
CENTROID X	:	.045	.239	.186
CENTROID Y	:	-.714	-.836	-.624
POA TO CENTROID in.	:	.715	.869	.651
MIN RADIUS	:	.199	.365	.163
MEAN RADIUS	:	1.057	.958	.829
MAX RADIUS	:	2.062	1.811	1.619
HORIZONTAL SPREAD	:	2.725	1.707	1.707
VERTICAL SPREAD	:	3.462	3.462	2.615
EXTREME SPREAD	:	3.749	3.462	2.616
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		7	