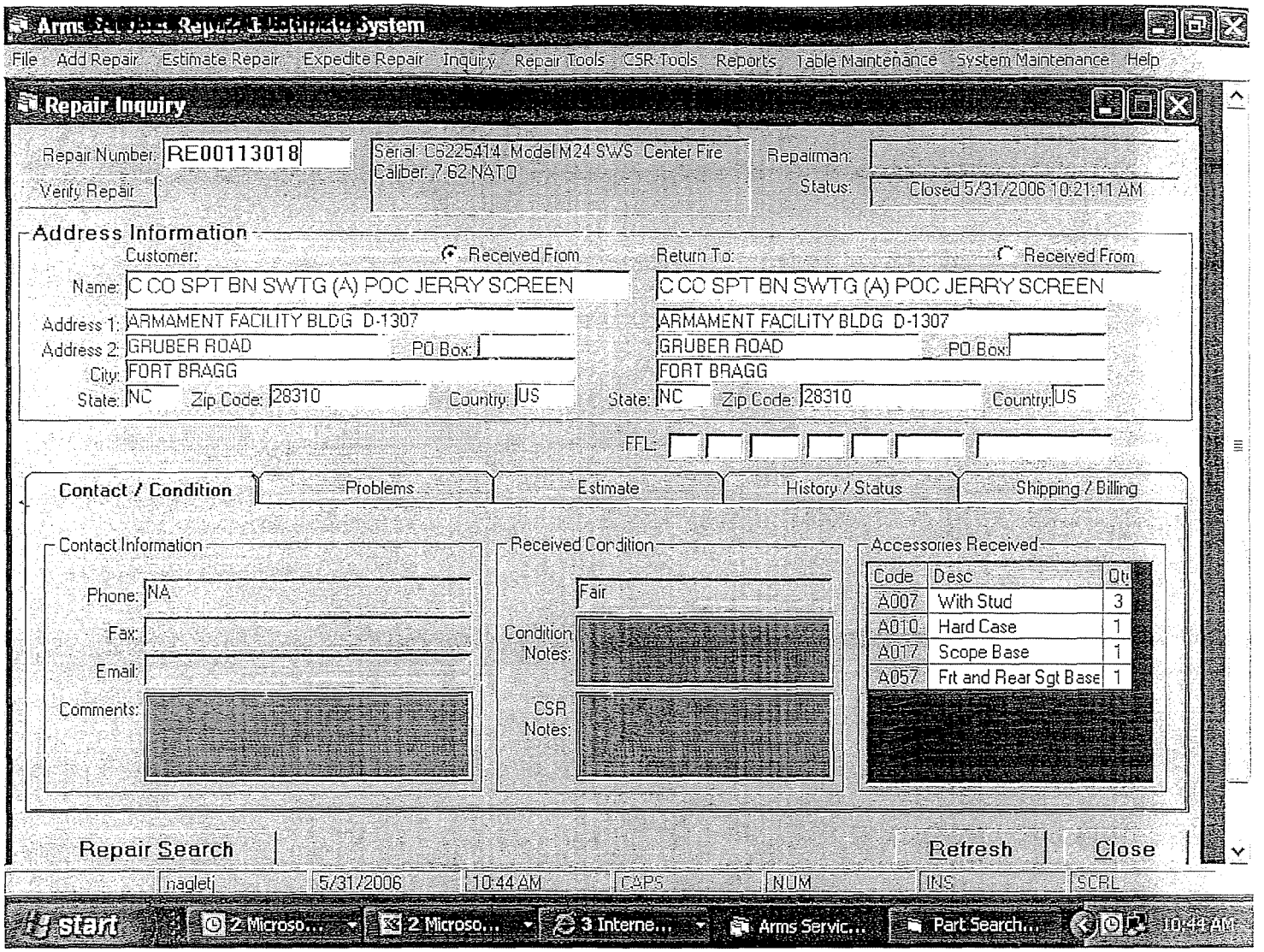
G657730S
Replaced
C.622544



G6577305

Serial Number: C6225414

Model: M24 SWS

RE00113018

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFOMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6577305.__0
FILE DATE AND TIME: 07/05/2006 08:12

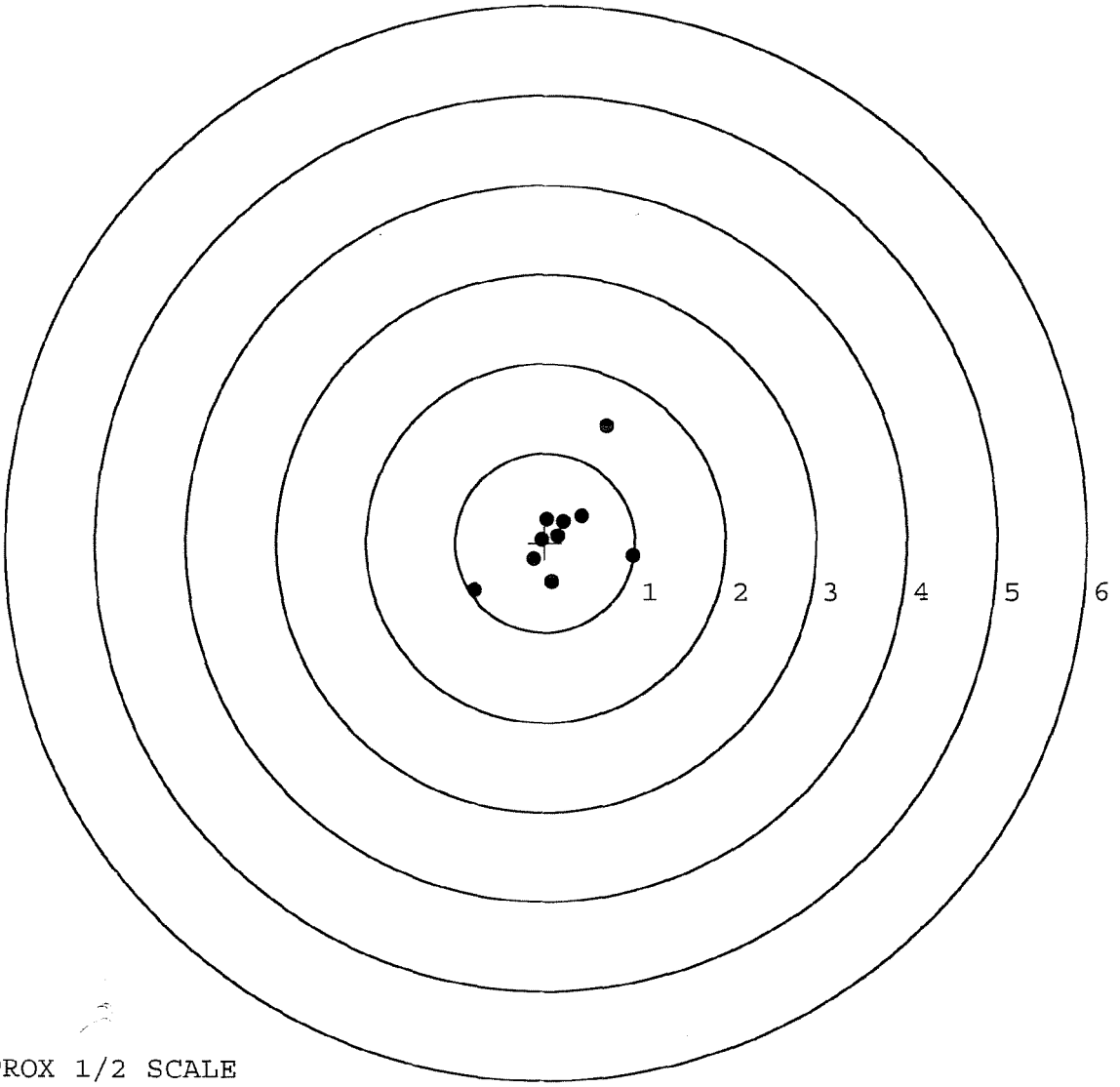
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.002
The Average Y Centroid of the Five Target Set:	0.031
The Average Point of Impact of the Five Target Set:	0.031
The Average Mean Radius of the Five Target Set:	0.752
The Distance from POA to Centroid Target #1:	0.183
The Distance from Centroid Target #2 to Centroid Target #1:	0.412
The Distance from Centroid Target #3 to Centroid Target #1:	0.266
The Distance from Centroid Target #4 to Centroid Target #1:	0.241
The Distance from Centroid Target #5 to Centroid Target #1:	0.182

SERIAL NUMBER: G6577305.__0
TARGET NUMBER: 1
FILE DATE: 07/05/2006
FILE TIME: 08:12

X CENTROID:	0.159
Y CENTROID:	0.090
POA TO CENTROID:	0.183
HORZ SPREAD:	1.766
VERT SPREAD:	1.844
GROUP SPREAD:	2.357
MIN RADIUS:	0.022
MAX RADIUS:	1.327
MEAN RADIUS:	0.517
# IN 1 IN DIAMETER:	6
# IN 2 IN DIAMETER:	8
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	0.683	1.309
2:	0.981	-0.147
3:	0.086	-0.442
4:	-0.785	-0.535
5:	-0.123	-0.189
6:	0.202	0.239
7:	0.024	0.261
8:	-0.034	0.038
9:	0.411	0.294
10:	0.142	0.076



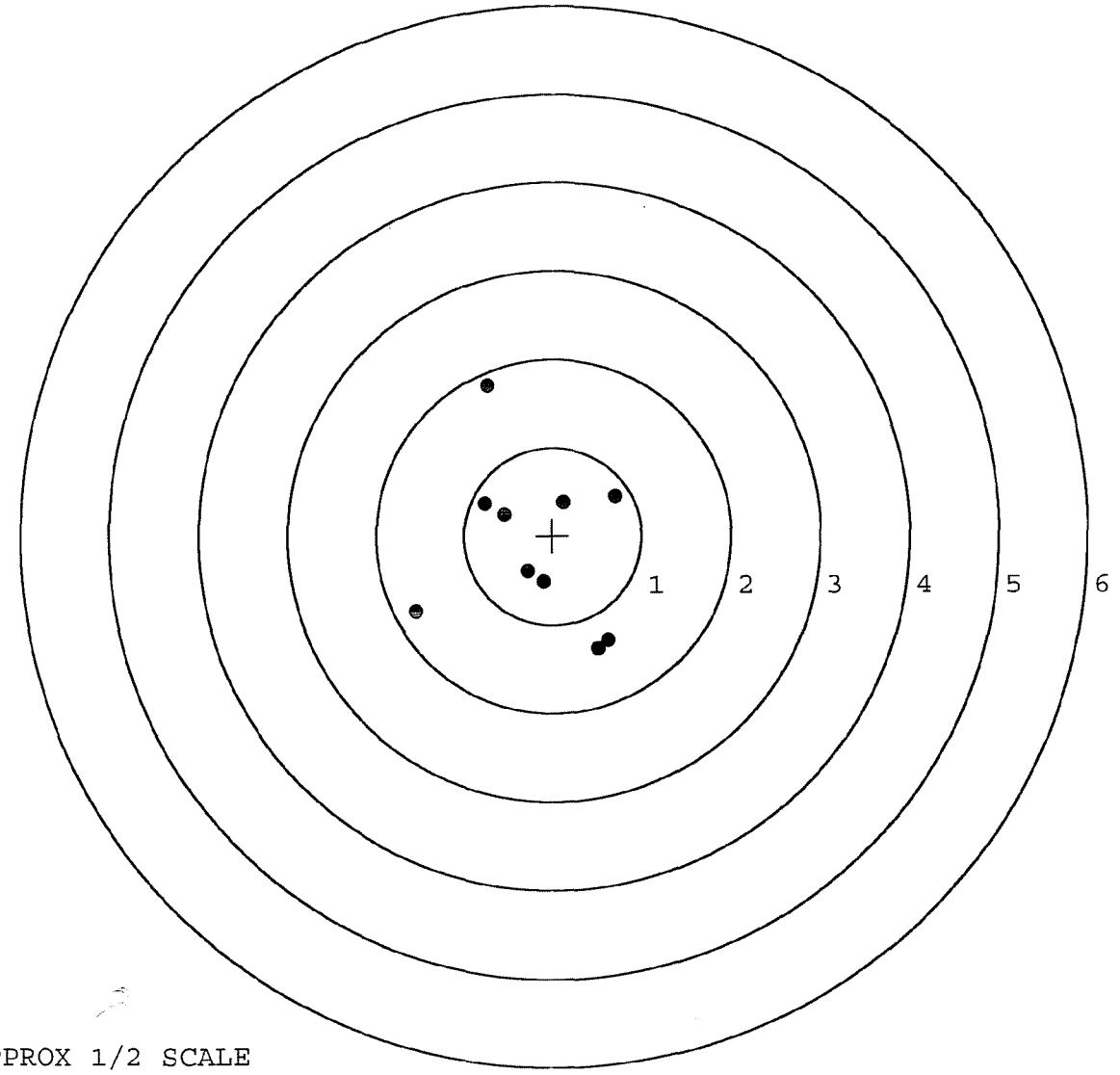
TARGET APPROX 1/2 SCALE

BARBER - M24 0088206

SERIAL NUMBER: G6577305.__0
TARGET NUMBER: 2
FILE DATE: 07/05/2006
FILE TIME: 08:12

X CENTROID:	-0.201
Y CENTROID:	-0.111
POA TO CENTROID:	0.230
HORZ SPREAD:	2.254
VERT SPREAD:	2.971
GROUP SPREAD:	3.228
MIN RADIUS:	0.306
MAX RADIUS:	1.891
MEAN RADIUS:	0.976
# IN 1 IN DIAMETER:	3
# IN 2 IN DIAMETER:	5
# in 3 IN DIAMETER:	8

POINT#	X	Y
1:	0.632	-1.175
2:	0.520	-1.269
3:	0.704	0.448
4:	0.125	0.376
5:	-0.553	0.239
6:	-0.767	0.362
7:	-1.550	-0.859
8:	-0.741	1.702
9:	-0.283	-0.405
10:	-0.100	-0.524

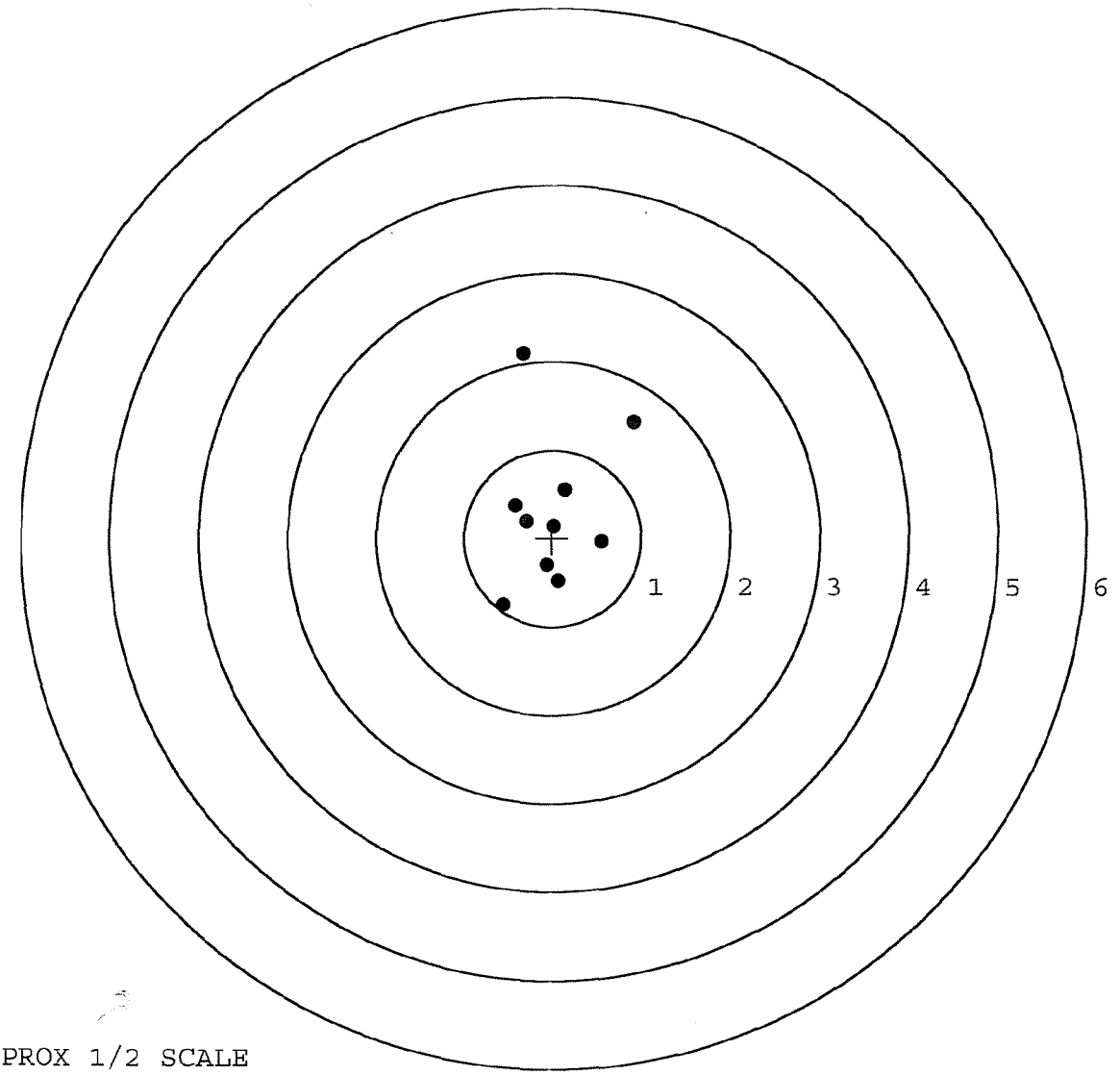


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6577305.__0
TARGET NUMBER: 3
FILE DATE: 07/05/2006
FILE TIME: 08:12

X CENTROID:	0.002
Y CENTROID:	0.305
POA TO CENTROID:	0.305
HORZ SPREAD:	1.473
VERT SPREAD:	2.852
GROUP SPREAD:	2.860
MIN RADIUS:	0.169
MAX RADIUS:	1.817
MEAN RADIUS:	0.766
# IN 1 IN DIAMETER:	4
# IN 2 IN DIAMETER:	7
# in 3 IN DIAMETER:	9

POINT#	X	Y
1:	0.913	1.319
2:	-0.343	2.089
3:	0.555	-0.039
4:	0.143	0.553
5:	-0.560	-0.763
6:	-0.426	0.364
7:	-0.295	0.189
8:	0.025	0.137
9:	-0.063	-0.311
10:	0.067	-0.490



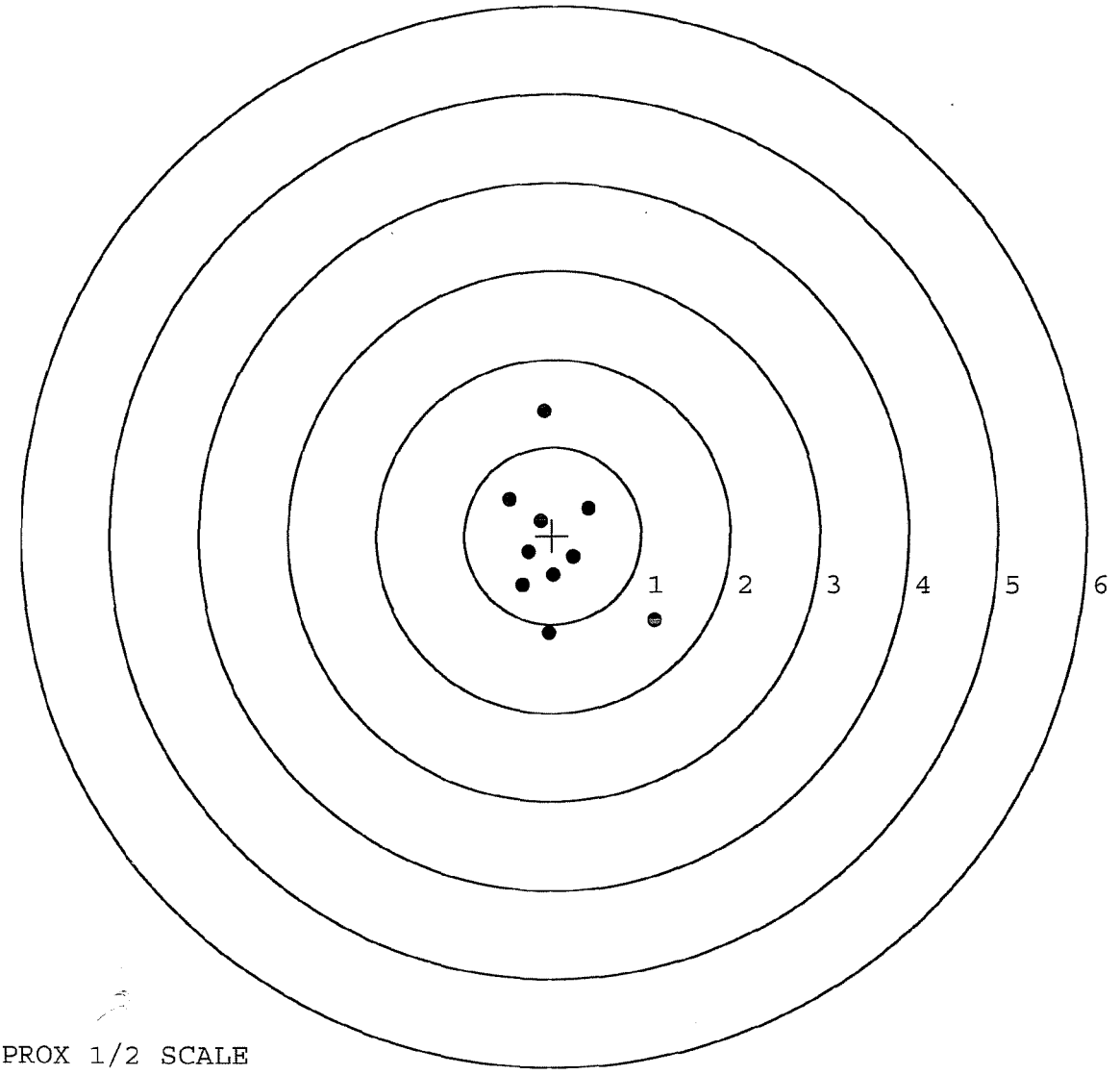
TARGET APPROX 1/2 SCALE

BARBER - M24 0088208

SERIAL NUMBER: G6577305.__0
TARGET NUMBER: 4
FILE DATE: 07/05/2006
FILE TIME: 08:12

X CENTROID:	0.045
Y CENTROID:	-0.122
POA TO CENTROID:	0.130
HORZ SPREAD:	1.642
VERT SPREAD:	2.509
GROUP SPREAD:	2.676
MIN RADIUS:	0.228
MAX RADIUS:	1.536
MEAN RADIUS:	0.702
# IN 1 IN DIAMETER:	4
# IN 2 IN DIAMETER:	8
# in 3 IN DIAMETER:	9

POINT#	X	Y
1:	1.154	-0.955
2:	-0.027	-1.102
3:	0.239	-0.242
4:	0.404	0.304
5:	-0.135	0.163
6:	-0.488	0.406
7:	-0.103	1.407
8:	-0.272	-0.190
9:	0.018	-0.448
10:	-0.338	-0.565

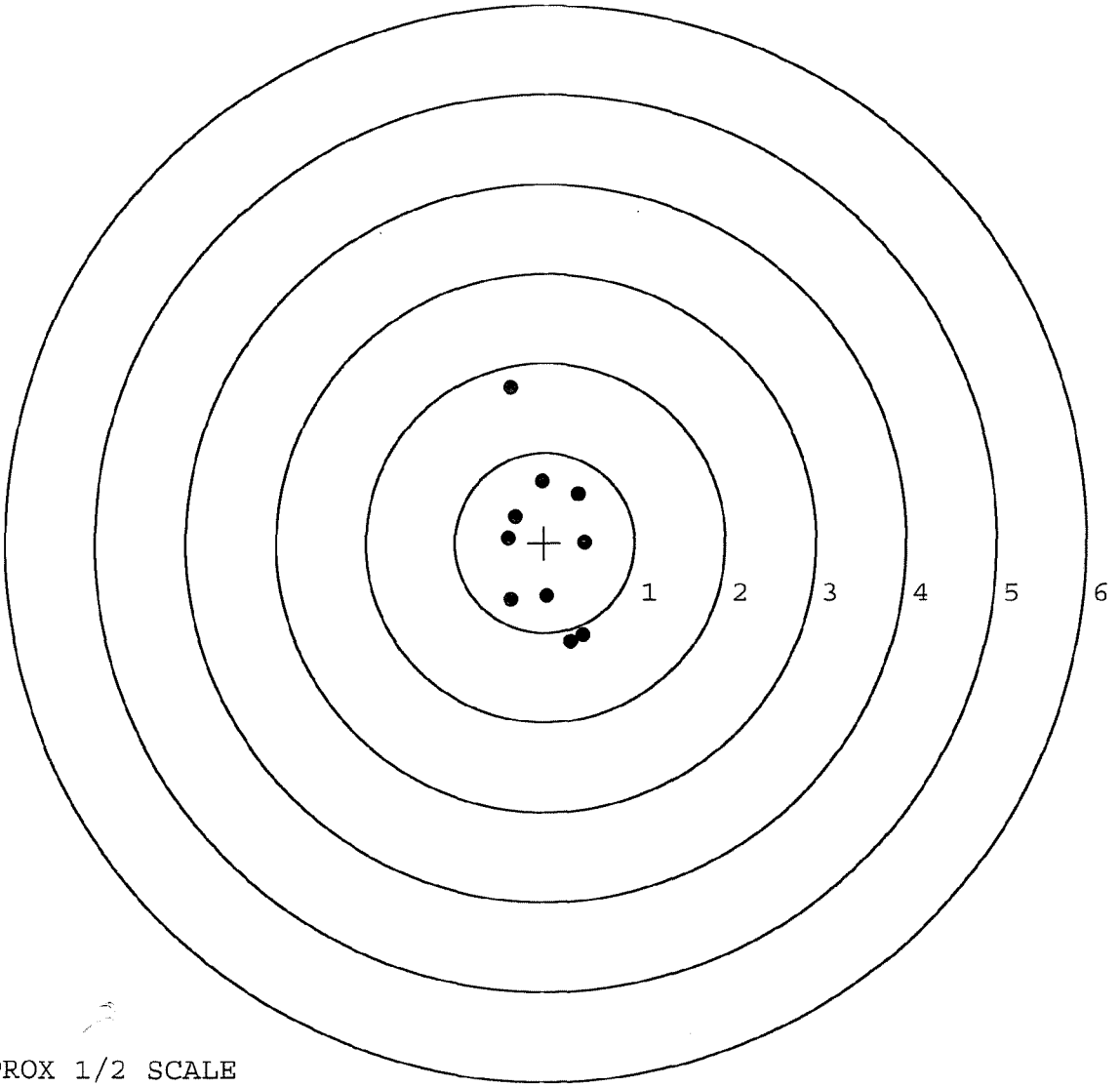


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6577305.__0
TARGET NUMBER: 5
FILE DATE: 07/05/2006
FILE TIME: 08:12

X CENTROID:	0.006
Y CENTROID:	-0.009
POA TO CENTROID:	0.010
HORZ SPREAD:	0.849
VERT SPREAD:	2.829
GROUP SPREAD:	2.911
MIN RADIUS:	0.411
MAX RADIUS:	1.776
MEAN RADIUS:	0.800
# IN 1 IN DIAMETER:	3
# IN 2 IN DIAMETER:	7
# in 3 IN DIAMETER:	9

POINT#	X	Y
1:	-0.388	1.723
2:	0.428	-1.033
3:	0.299	-1.106
4:	0.031	-0.599
5:	-0.374	-0.639
6:	0.448	0.009
7:	-0.401	0.053
8:	-0.330	0.288
9:	0.372	0.540
10:	-0.028	0.678



TARGET APPROX 1/2 SCALE

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

R & E NUMBER	113018	C6577305 (New)
SERIAL NUMBER	C6225414	
LOG-IN DATE	5-30-06	

OPERATION #	OPERATION NAME		DATE	INITIAL
500	DIS-ASSEMBLE GUN		6-16-06	RTL
505	RE-BARREL		6-20-06	RTL
420	ASSEMBLE		6-20-06	RTL
440	PROOF	MAGNA-FLUX INSPECTED JUN 2 3 2006	6-20-06	TRW
460	CHECK HEADSPACE		6-20-06	TRW
470	DIS-ASSEMBLE GUN		6-21-06	RTL
480	MAGNAFLUX	OPERATOR	6/23/06	
510	DRILL AND TAP		6-22-06	TRW
500	ROLLMARK CALIBER		6-22-06	CW
520	GOFF BLAST BBL / REC		6-23-06	LB
530 & 540	APPLY COATINGS		6/28/06	
560	FINAL ASSEMBLY		7-5-06	RTL
640	FUNCTION TEST AND	(PASS) FAIL	7-5-06	TRW
650	TARGET	(PASS) FAIL	7-5-06	TRW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION N/A		
	MALFUNCTION	CORRECTION	7-5-06	R.P.
670	FINAL INSPECTION		7-6-06	AC
	A) HEADSPACE	(PASS) FAIL	7-6-06	AC
	B) TRIGGER PULL (+/- .5 LBS, MIN 2.50 LBS, MAX 4.0 LBS)	N/A		
680	F) SAFETY ON FORCE (2 LBS MIN, 10 LBS MAX)	8 lbs 8 lbs 8 lbs		AC
	G) SAFETY OFF FORCE (2 LBS MIN)	3 lbs 3 lbs 3 lbs		AC
	I) FIRING PIN INDENT (.020)	.022 .022 .022		
690	PACK		7-10-06	

F006 REV 5/2006

BARREL ASSEMBLY

_____ BARREL

_____ RECEIVER

_____ FRONT SIGHT BASE

_____ REAR SIGHT BASE

_____ SCREWS

_____ FINISH

SCOPE ASSEMBLY

_____ SCOPE

_____ SCOPE RINGS

_____ MOUNTING SCREWS

_____ MOUNTING BASE

_____ SCREWS

_____ FINISH

_____ CLARITY

STOCK ASSEMBLY

_____ STOCK

_____ SLING SWIVEL STUDS

_____

_____ BUTT PATE

_____ LOCK NUTS

_____ BARREL CLEARANCE

_____ COLOR / FINISH

SYSTEM CASE

_____ SCOPE CASE

_____ IRON SIGHTS

_____ DEPLOYMENT KIT

TRIGGER ASSEMBLY

_____ SAFETY OPERATION

_____ RE-SET TO FACTORY SPECS

COMMENTS: _____

F006 REV 5/2006

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6225414
11 Jan 1994

CENTROIDAL DISTANCES

Ø	TO	1	.136561
1	TO	2	1.06293
1	TO	3	.378847
1	TO	4	.50813
1	TO	5	.711018

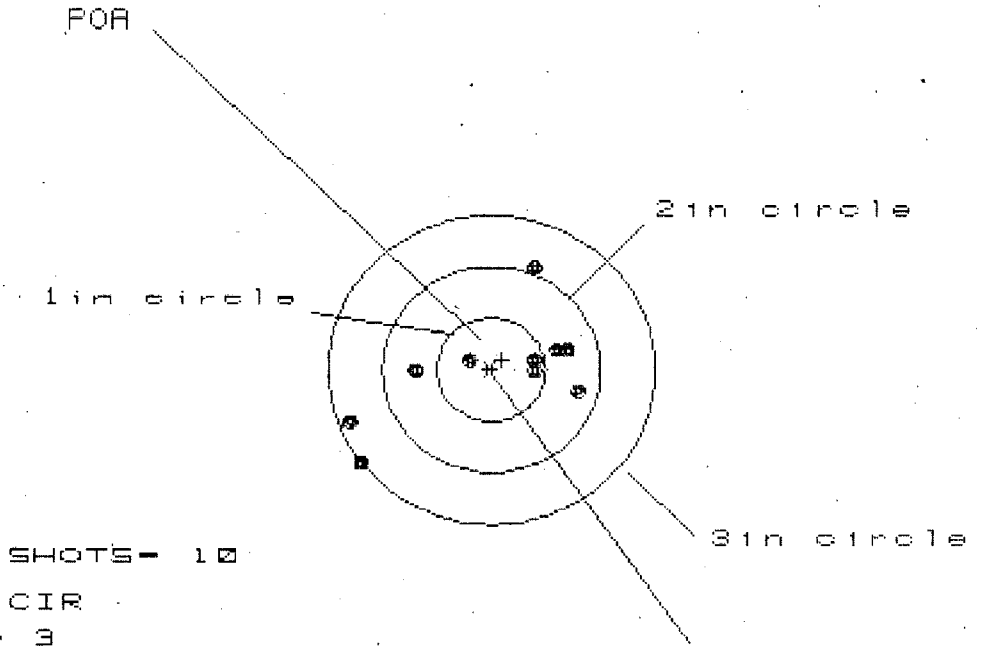
$\bar{d}_{35}^{2}$ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .2694
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1472
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .306992

THE AMR FOR THIS RIFLE IS: .8666

11 Jan 1994 FILE:/PATTERNING/CENTERFIRE_PATT/C6225414

CENTERFIRE PATTERNS # 1

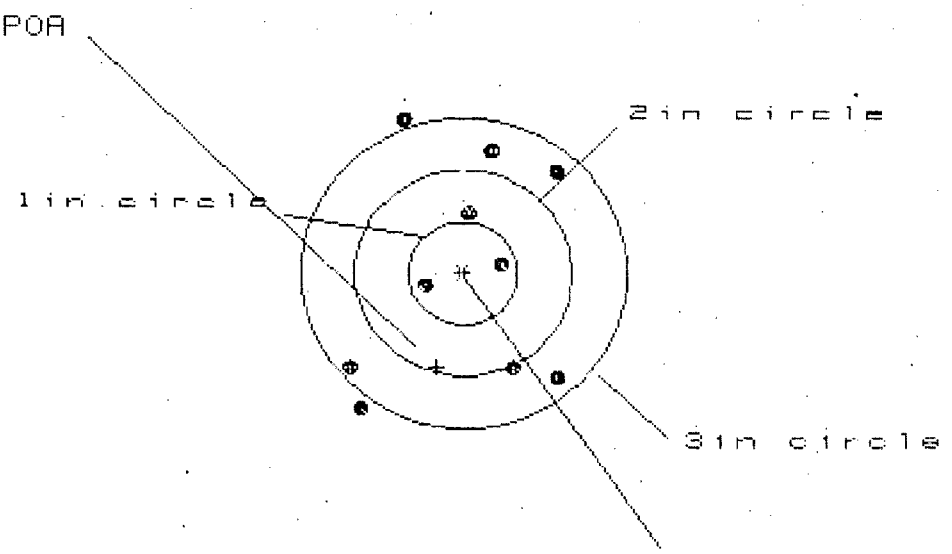


# OF SHOTS= 10
# IN CIR
1in = 3
2in = 7
3in = 10
HS= 2.059
VS= 1.896
GS= 2.502

PATTERN #	:	ES		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.804	.670	.496
MINIMUM X	:	-1.255	-1.389	-1.021
MAXIMUM Y	:	1.029	.933	.861
MINIMUM Y	:	-.867	-.574	-.370
CENTROID X	:	-.100	.034	.208
CENTROID Y	:	-.093	.003	.075
POA TO CENTROID in.	:	.136	.034	.221
MIN RADIUS	:	.212	.268	.161
MEAN RADIUS	:	.789	.670	.509
MAX RADIUS	:	1.485	1.503	1.032
HORIZONTAL SPREAD	:	2.059	2.059	1.517
VERTICAL SPREAD	:	1.896	1.507	1.231
EXTREME SPREAD	:	2.502	2.259	1.532
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

11 Jan 1994 FILE:/PATTERNING/CENTERFIRE_PATT/C6225414

CENTERFIRE PATTERNS # 2



OF SHOTS= 10.

IN CIR.

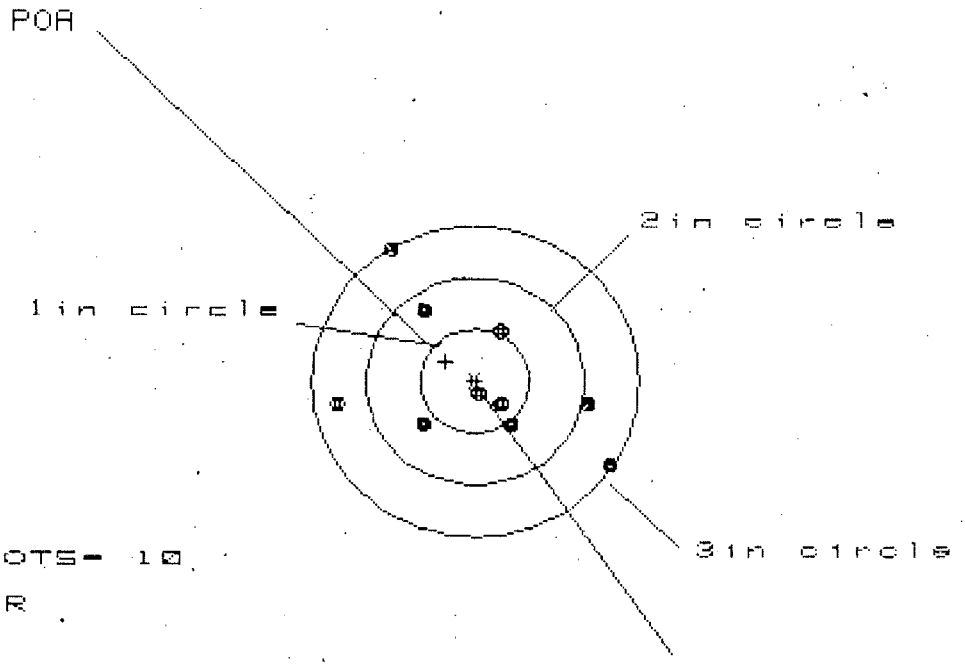
1in = 2
2in = 3
3in = 8

HS= 1.935
VS= 2.797
GS= 2.915

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.879	.775	.698
MINIMUM X	:	-1.056	-1.160	-1.236
MAXIMUM Y	:	1.473	1.326	1.236
MINIMUM Y	:	-1.324	-1.202	-1.036
CENTROID X	:	.249	.353	.429
CENTROID Y	:	.911	1.058	.892
POA TO CENTROID in.	:	.944	1.115	.990
MIN RADIUS	:	.321	.276	.202
MEAN RADIUS	:	1.072	.989	.925
MAX RADIUS	:	1.622	1.553	1.510
HORIZONTAL SPREAD	:	1.935	1.935	1.935
VERTICAL SPREAD	:	2.797	2.528	2.272
EXTREME SPREAD	:	2.915	2.884	2.671
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		8	

01 Jan 1994 FILE:/PATTERNING/CENTERFIRE_PATT/C6225414

CENTERFIRE PATTERNS # 3



# OF SHOTS= 10
# IN CIR
1in = 2
2in = 6
3in = 9
HS= 2.497
VS= 2.162
GS= 2.929

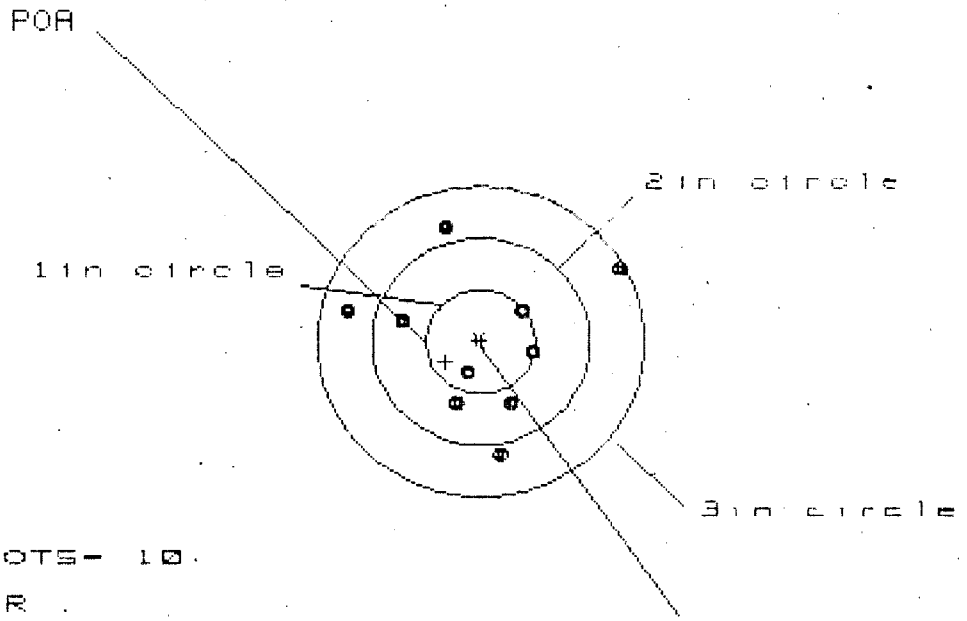
PATTERN # : 31

SHOTS (BEST OF) :	10	9	8
MAXIMUM X :	1.191	1.104	1.122
MINIMUM X :	-1.306	-1.393	-1.255
MAXIMUM Y :	1.319	.844	.757
MINIMUM Y :	-.843	-.696	-.363
CENTROID X :	.267	.354	.216
CENTROID Y :	-.187	-.334	-.247
POA TO CENTROID in.:	.326	.487	.328
MIN RADIUS :	.142	.096	.092
MEAN RADIUS :	.845	.734	.674
MAX RADIUS :	1.535	1.396	1.268
HORIZONTAL SPREAD :	2.497	2.497	2.377
VERTICAL SPREAD :	2.162	1.540	1.120
EXTREME SPREAD :	2.929	2.569	2.377

NUMBER IN ONE INCH CIRCLE = 2
NUMBER IN TWO INCH CIRCLE = 6
NUMBER IN THREE INCH CIRCLE = 9

11 Jan 1994 FILE:/PATTERNING/CENTERFIRE_PATT/C6225414

CENTERFIRE PATTERNS # 4

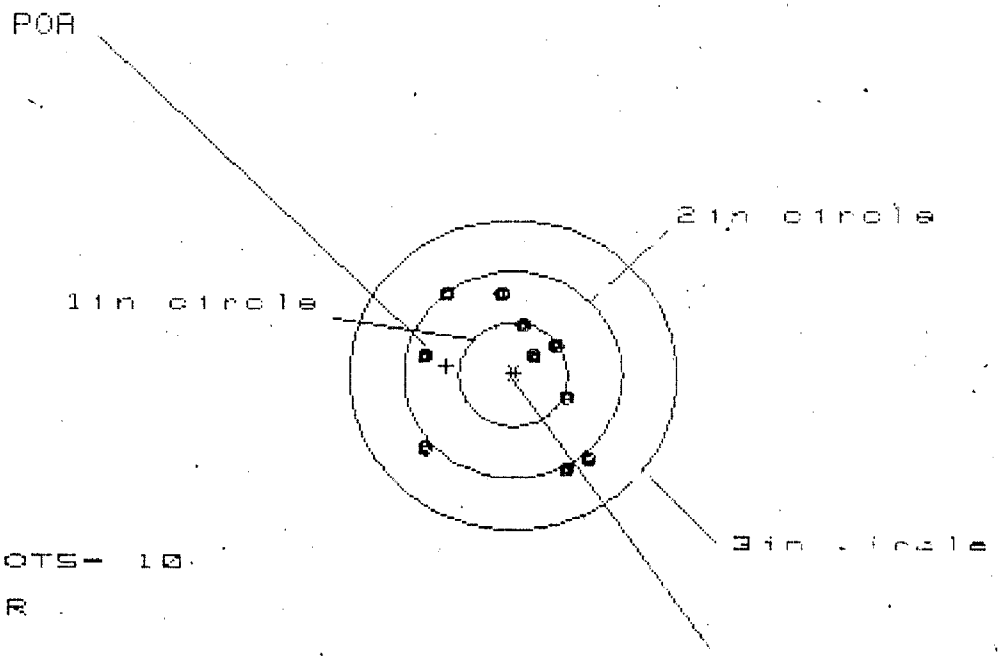


# OF SHOTS= 10.
# IN CIR.
1in = 2
2in = 6
3in = 10
HS= 2.454
VS= 2.236
GS= 2.490

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.255	.657	.525
MINIMUM X	:	-1.199	-1.060	-.748
MAXIMUM Y	:	1.127	1.207	1.254
MINIMUM Y	:	-1.109	-1.029	-.982
CENTROID X	:	.320	.181	.313
CENTROID Y	:	.193	.113	.066
POA TO CENTROID in.	:	.374	.213	.320
MIN RADIUS	:	.287	.175	.179
MEAN RADIUS	:	.837	.755	.687
MAX RADIUS	:	1.446	1.216	1.285
HORIZONTAL SPREAD	:	2.454	1.717	1.273
VERTICAL SPREAD	:	2.236	2.236	2.236
EXTREME SPREAD	:	2.490	2.279	2.279
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	

11 Jan 1994 FILE:/PATTERNING/CENTERFIRE_PATT/C8225414

CENTERFIRE PATTERNS # 5



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

HS= 1.506
VS= 1.735
GS= 2.063

PATTERN #	:	[redacted]	
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.694	.604	.494
MINIMUM X	:	-.812	-.885	-.889
MAXIMUM Y	:	.797	.717	.605
MINIMUM Y	:	-.938	-1.018	-1.130
CENTROID X	:	.611	.701	.625
CENTROID Y	:	-.088	-.008	.104
POA TO CENTROID in.	:	.617	.701	.634
MIN RADIUS	:	.216	.096	.161
MEAN RADIUS	:	.754	.683	.621
MAX RADIUS	:	1.084	1.088	1.220
HORIZONTAL SPREAD	:	1.506	1.489	1.303
VERTICAL SPREAD	:	1.735	1.735	1.735
EXTREME SPREAD	:	2.063	2.063	2.038
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

BARBER M24 0088218

RECEIVING AND ESTIMATING REPORT

COMMENTS: WOG 3 OF 7 M-24 ATTN: FRED MARTIN W/ADJUSTABLE RECOIL PAD

ORDER: R 93-26581

INITIAL	CUSTOMER ORDER NO.
FPS	8326

DATE RECEIVED	DATE OPENED	DATE CODE	SERIAL NUMBER	NEW SERIAL NUMBER	MODEL AND GRADE
12/09/93	12/09/93	OL 7-91	C6225414		700 7.62 NATO

ACCESSORIES: W/STUDS SCOPE BASE

FROM:

U. S. ARMY
THOMPSON, ALLAN R
CO. D 2ND BN. 1ST SWTG
FT BRAGG NC 28307

SHIP TO:

U. S. ARMY
THOMPSON, ALLAN R
CO. D 2ND BN. 1ST SWTG
FT BRAGG NC 28307

CUST NO:088383 C.O.D

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

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: Replace Barrel ASSy

PARTS:
Barrel Assy - 96003
Front Sight Mounting Base - 96011

W52 A09401 H229

COMMENTS:
Rezinc - Scope Base & Swivel Studs.
Repowder Coat - FloorPlate /Atch, Trigger Guard & Rear Sight Base.

REPAIRMAN	PROOF	CLEAN	TEST	TARGET	PATTERN
RW	✓	✓	✓	✓	
GALLERY TESTER	**DATE**	**DATE**	**DATE**	**DATE**	**DATE**
RW	12/16/93	12/29/93	12/29/93	12/29/93	

OFFICE COPY

RD6925 REV. 1/92

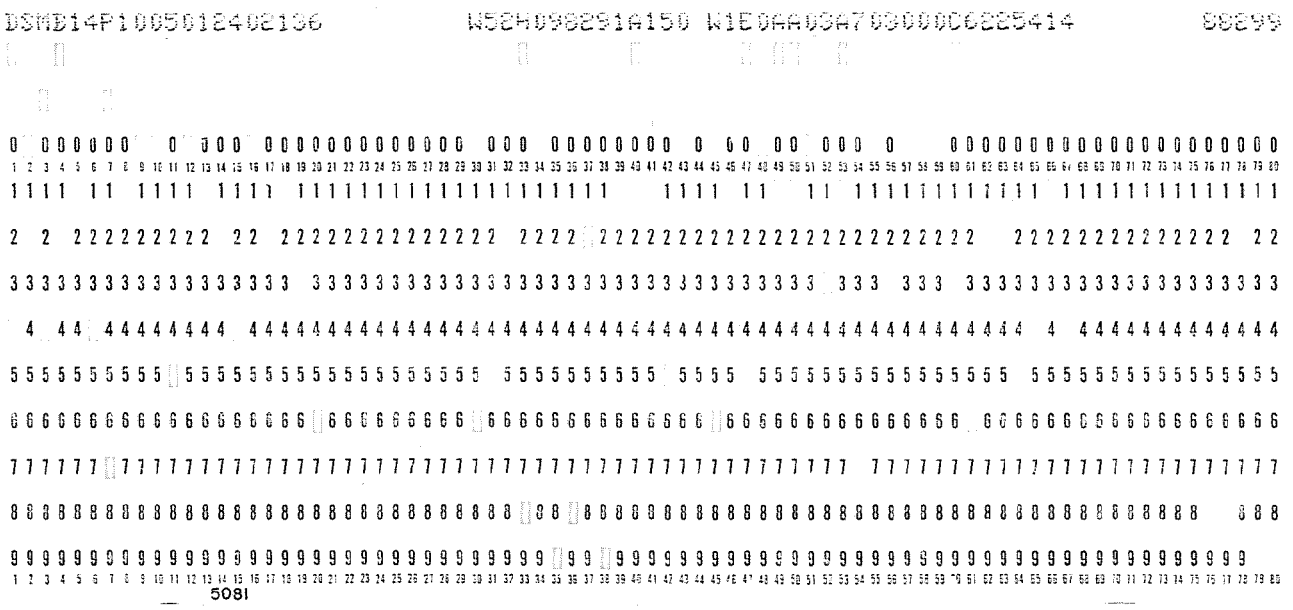
M-24

CONTRACT # DAAA21-87-C-0086 New Barrel

GUN SERIAL # C6225414

OP. #	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and Stock		12/16/93	RW
600	Proof		12/16/93	RW
607	Check Headspace		12/16/93	RW
610	Dis-assemble Gun		12/16/93	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		12/28/93	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		12/28/93	RW
	C) Inspect Ejector Hole for Chamfer		12/28/93	RW
	D) Oil Firing Pin Ass'y		12/28/93	RW
	E) Adjust Trigger Pull to Min Setting and Stake			

op. #	OP. NAME	READINGS	DATE	INIT
5 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		12/29/93	RW
	A) Time			
	B) Malfunctions			
	C) Pierced Primers			
	D) Optical Clearity of Scope			
645	Inspect for Live Ammo		12/29/93	RW
655	Final Inspection A) Headspace		1/3/94	RW
	B) Trigger Pull	2.71 | 2.70 | 2.60 | 2.64 | 2.63	1/3/94	RW
	C) Function		1/3/94	RW
660	Pack			


DSMB14P100501240Z106 W52HU98291A150 W1E0HAU0A70000D6825414 88899
5081

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6225414

OPERATION #	OPERATION NAME	DATE	INT
575-580	ASSEMBLY	2 26	EB
600	PROOF	29	RW
615	MAGNAFLUX BARREL	5/13/88	pjl
	MAGNAFLUX BOLT	5/13/88	pjl.
620	COATING	5/16/88	JA
625-630	FINAL ASSEMBLY		
635	TEST		
640	TARGET		
	FIRING PIN INDENT		
660	PACK		

SCOPE # 1171

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6225414

OP.#	OP. NAME	READINGS	DATE	INITIAI
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 & Tap Sight Holes			
618	Polish Barrel			
620	Apply Coatings (Barrel Action)			
	Apply Coatings (Bolt)			
625	Final Assembly A)Clean inside of Bolt Assembly		8/29/88	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/29/88	RW
	C) Inspect Ejector Hole for Chamfer		8/29/88	RW

OVER

OP.#		READINGS	DATE	INITIAL
625 cont.	D) Oil Firing Pin Ass'y		8/29/88	RW
	E) Adjust Trigger Pull to Min. Setting and Stake		29aug88	JH+RS
	F) Safety on Force	4.25 | 5 | 4.75	29aug88	JH+RS
	G) Safety off Force	3 | 3 | 3	29aug88	JH+RS
	H) Trigger Pull Test & Retainabilty		29aug88	JH+RS
	I) Firing Pin Indent	.023 | .023 | .023	29aug88	JH+RS
	J) Assemble Stock		9/23/88	RW
	K) Assemble Swivel Studs		10-6-88	RS
	L) Attach Front & Rear Sight Assemblies		9/23/88	RW
	M) Iron Sight Alignment		9/23/88	RW
	N) Detach Front & Rear Sights & place in numbered container		9/23/88	RW
	O) Attach Scope to Rifle		10/3/88	RW
	P) Detach & Attach Scope 20 times		10/3/88	RW
640	Gallery Target & Test	53 R 102 L	10/4/88	JES
	A) Optical Clearity of Scope		10/4/88	RW
645	Inspect for Live Ammo		10/4/88	RW
655	Final Inspection A) Headspace		10-6-88	RS
	B) Trigger Pull		10-6-88	RS
	C) Function		10-6-88	RS
660	Pack		10-20-88	RS

SWS TRIGGER PULL TEST

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

SERIAL NO. C6225414

DATE 29aug88

TESTER J.A. + D.S.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.68	2.66	2.56	2.73	MIN. SETTING,
PULL #2	2.61	2.63	2.70	2.39	NO AVG. OF 5
PULL #3	2.80	2.58	2.75	2.43	READINGS ACCEPT-
PULL #4	2.56	2.69	2.80	2.54	ABLE LESS THAN 2#
PULL #5	2.53	2.56	2.77	2.32	
TOTAL	13.18	13.12	13.58	12.41	
AVG.	2.636	2.624	2.716	2.48	

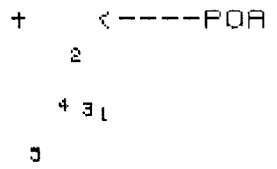
	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.10	3.15		
PULL #2	3.05	3.03		
PULL #3	3.11	3.07		
PULL #4	3.14	3.08		
PULL #5	3.18	3.10		
TOTAL	15.58	15.43		
AVG.	3.116	3.086		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.17	3.97	4.21	4.39
PULL #2	4.18	3.96	4.18	4.20
PULL #3	4.14	3.95	4.22	4.25
PULL #4	4.12	4.02	4.26	4.19
PULL #5	4.10	4.01	4.23	4.27
TOTAL	20.71	19.81	21.10	21.30
AVG.	4.142	3.962	4.22	4.26

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6225414

CENTROIDAL DISTANCES

0	TO	1	2.35501
1	TO	2	1.21228
1	TO	3	.292308
1	TO	4	.764477
1	TO	5	1.44244

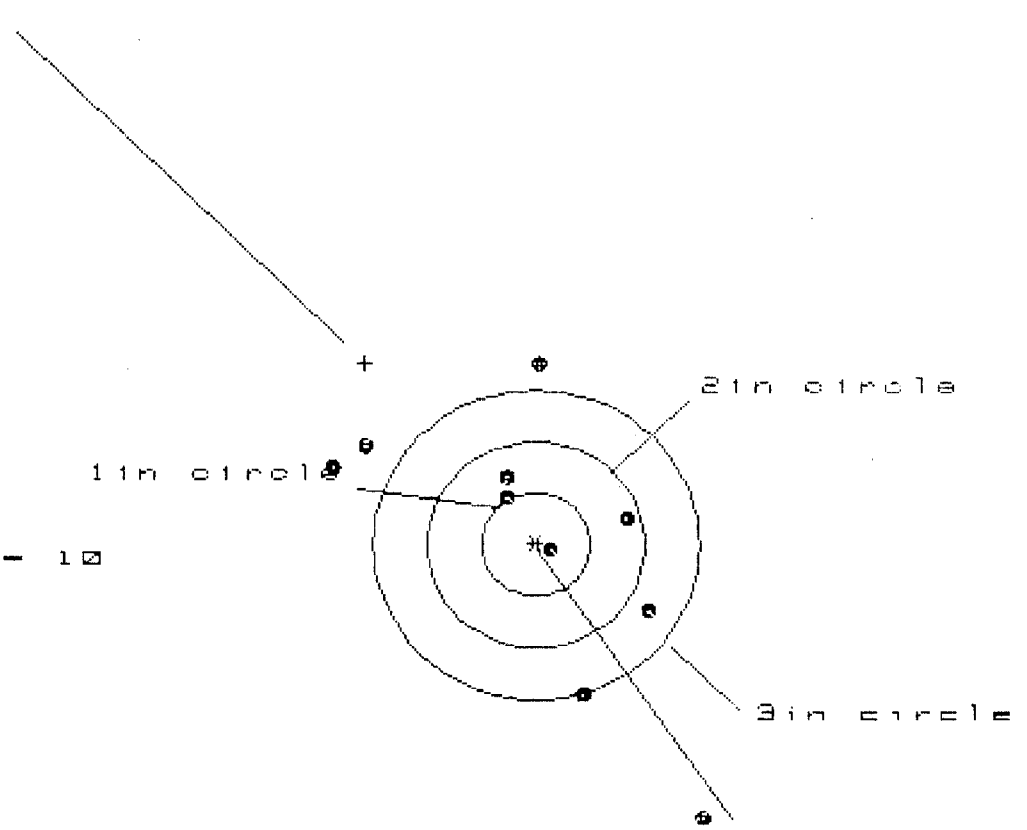


THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: 1.0148
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -1.6224
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: 1.91364

THE AMR FOR THIS RIFLE IS: 1.303

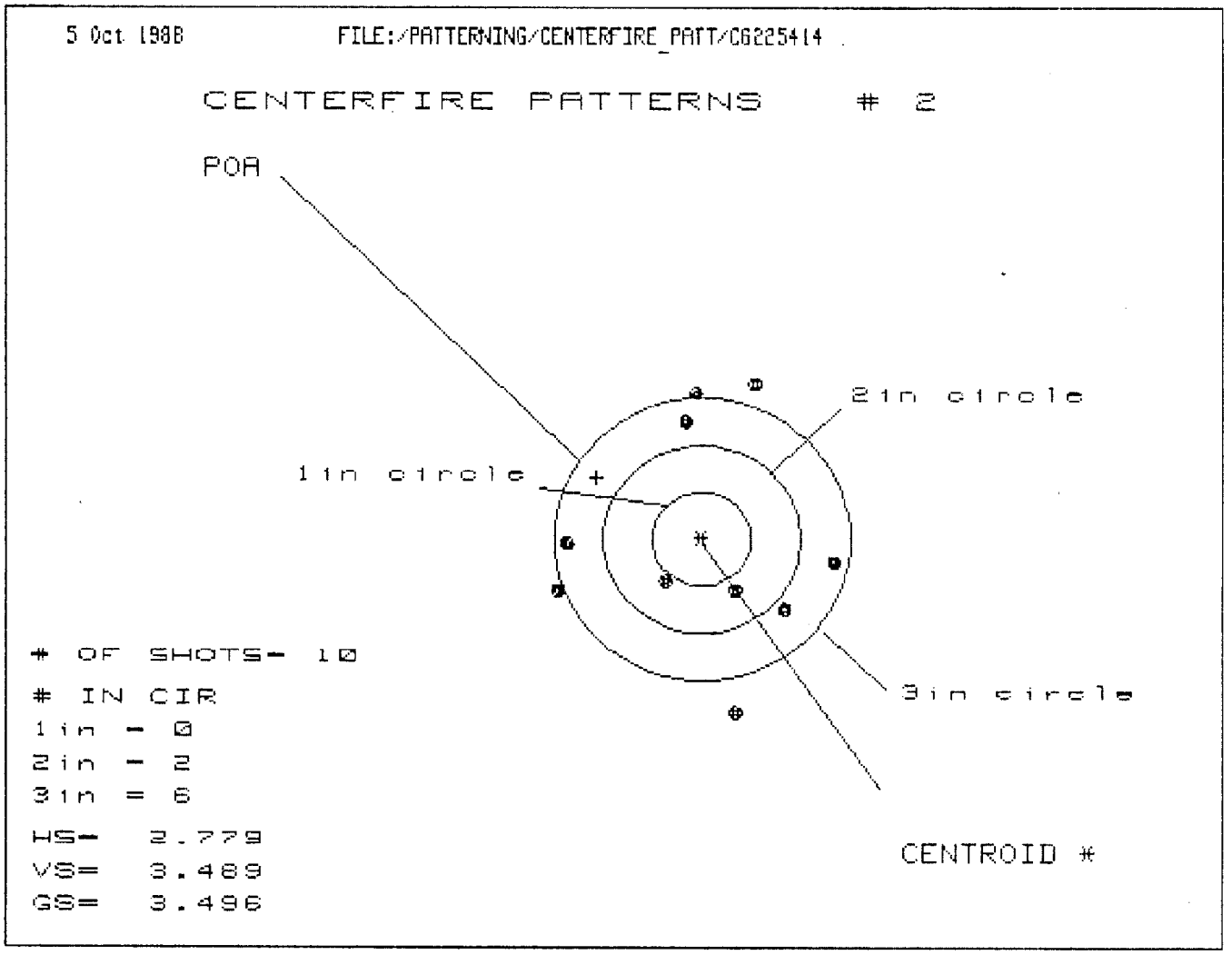
5 Oct 1988 FILE:/PATTERNING/CENTERFIRE_PATT/C6225414

CENTERFIRE PATTERNS # 1

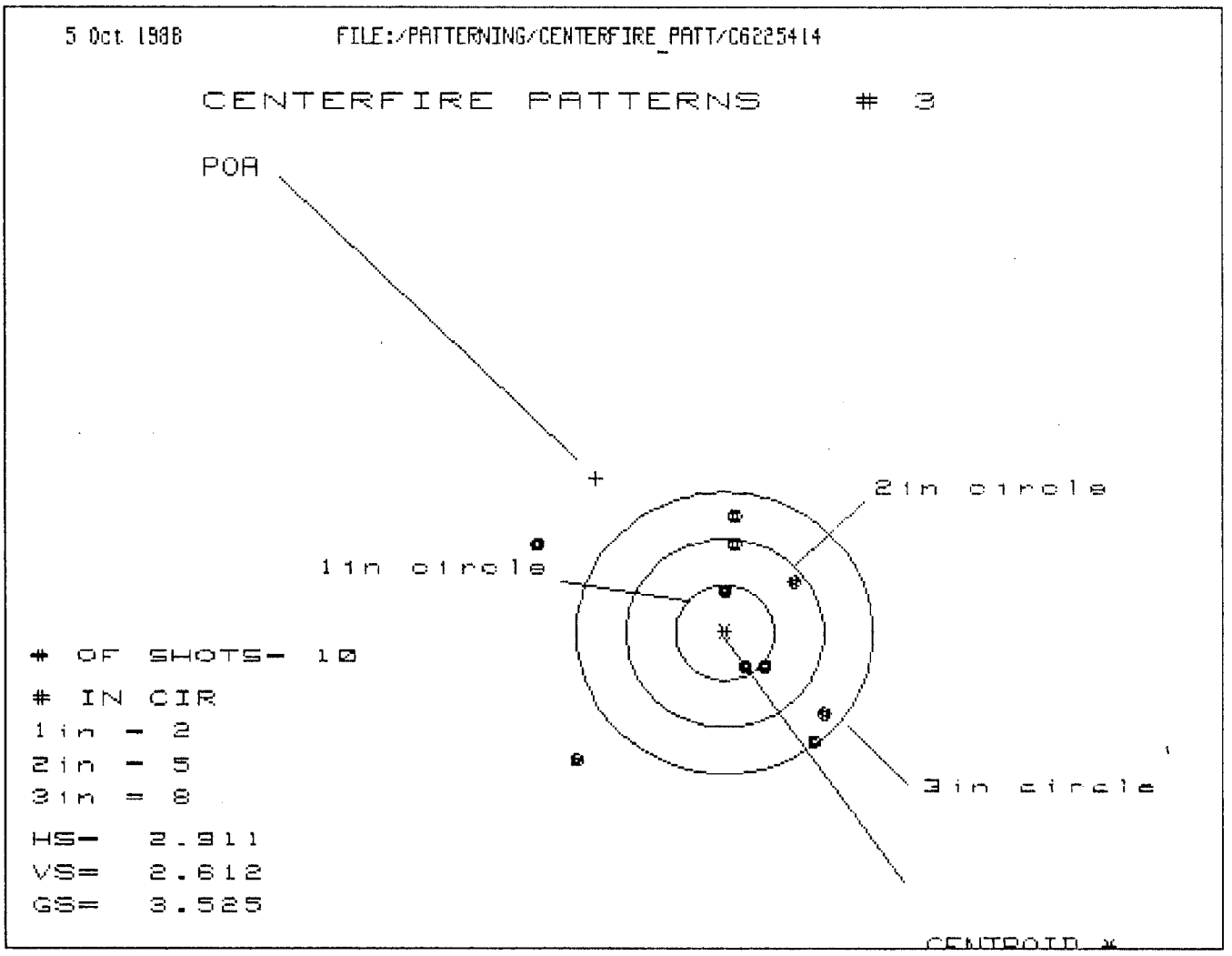


# OF SHOTS= 10
# IN CIR
1in = 1
2in = 4
3in = 5
HS= 3.349
VS= 4.375
GS= 4.768

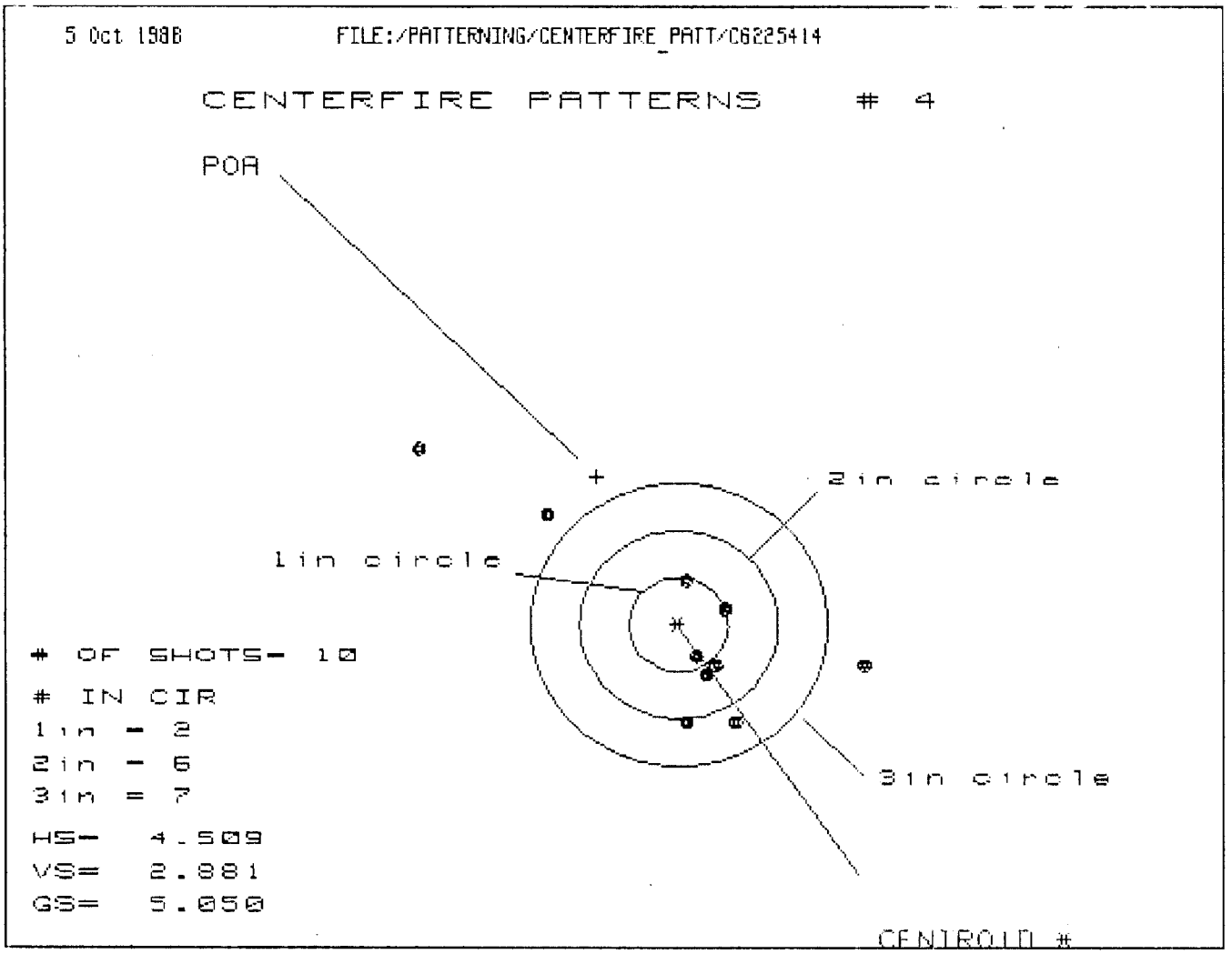
PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.514	1.251	1.042
MINIMUM X	:	-1.835	-1.666	-1.601
MAXIMUM Y	:	1.747	1.455	1.514
MINIMUM Y	:	-2.628	-1.740	-1.681
CENTROID X	:	1.567	1.398	1.607
CENTROID Y	:	-1.758	-1.466	-1.525
POA TO CENTROID in.	:	2.355	2.026	2.215
MIN RADIUS	:	.129	.195	.323
MEAN RADIUS	:	1.357	1.127	1.046
MAX RADIUS	:	3.033	1.853	1.768
HORIZONTAL SPREAD	:	3.349	2.917	2.643
VERTICAL SPREAD	:	4.375	3.195	3.195
EXTREME SPREAD	:	4.768	3.236	3.221
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		5	



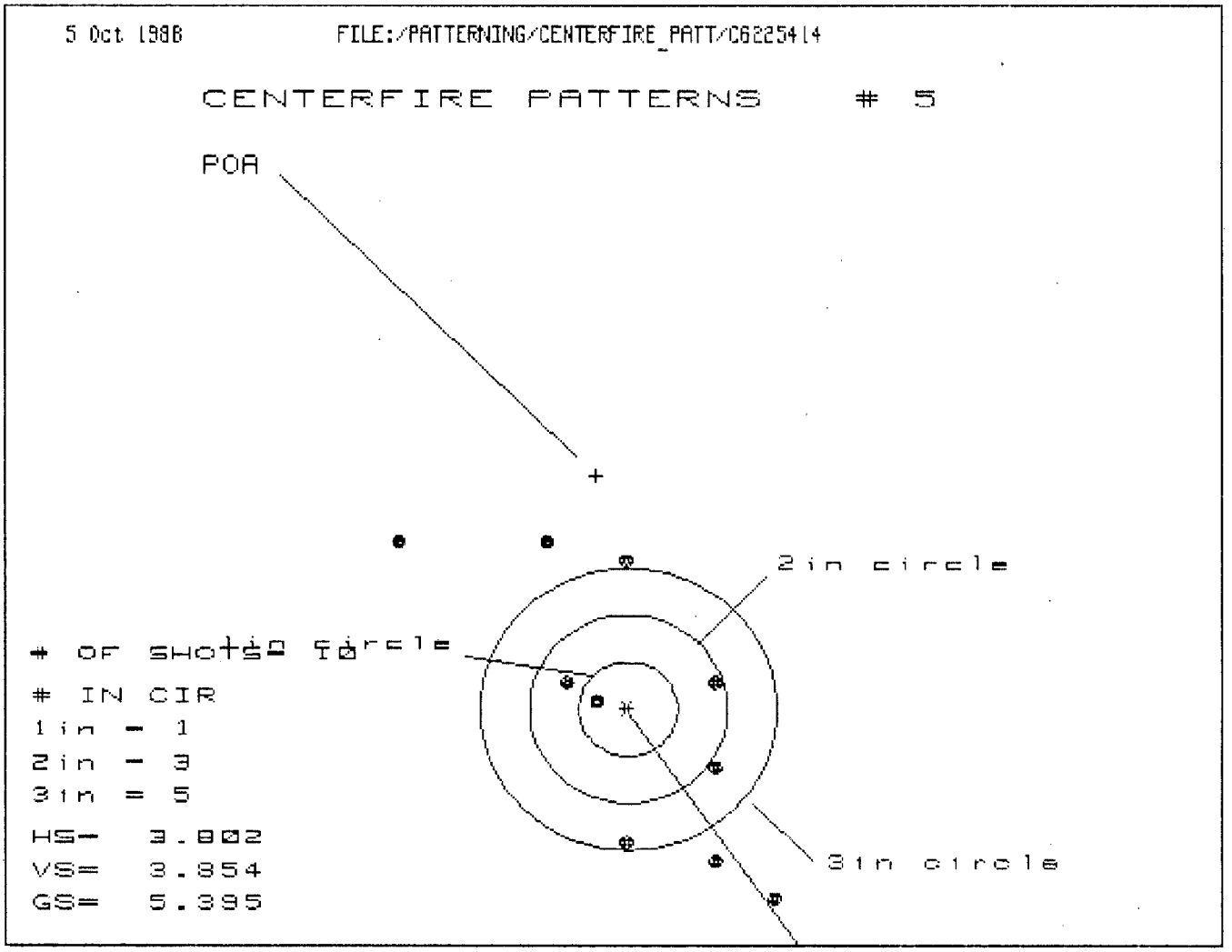
PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.335	1.374	1.451
MINIMUM X	:	-1.444	-1.405	-1.328
MAXIMUM Y	:	1.667	1.465	1.575
MINIMUM Y	:	-1.821	-.965	-.782
CENTROID X	:	1.064	1.025	.948
CENTROID Y	:	-.655	-.452	-.635
POA TO CENTROID in.	:	1.249	1.120	1.141
MIN RADIUS	:	.595	.742	.544
MEAN RADIUS	:	1.314	1.260	1.189
MAX RADIUS	:	1.856	1.604	1.576
HORIZONTAL SPREAD	:	2.779	2.779	2.779
VERTICAL SPREAD	:	3.489	2.430	2.357
EXTREME SPREAD	:	3.496	3.017	2.796
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		2	
NUMBER IN THREE INCH CIRCLE	=		6	



PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.999	.787	.567
MINIMUM X	:	-1.912	-1.758	-.417
MAXIMUM Y	:	1.257	1.361	1.205
MINIMUM Y	:	-1.355	-1.251	-1.176
CENTROID X	:	1.297	1.509	1.729
CENTROID Y	:	-1.646	-1.750	-1.594
POA TO CENTROID in.	:	2.096	2.311	2.352
MIN RADIUS	:	.400	.248	.448
MEAN RADIUS	:	1.151	.995	.834
MAX RADIUS	:	2.129	2.158	1.285
HORIZONTAL SPREAD	:	2.911	2.545	.984
VERTICAL SPREAD	:	2.612	2.612	2.381
EXTREME SPREAD	:	3.525	3.082	2.531
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	



PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.870	1.577	.474
MINIMUM X	:	-2.639	-1.630	-1.433
MAXIMUM Y	:	1.868	1.344	1.319
MINIMUM Y	:	-1.013	-.806	-.831
CENTROID X	:	.826	1.119	.922
CENTROID Y	:	-1.570	-1.777	-1.752
POA TO CENTROID in.	:	1.774	2.100	1.980
MIN RADIUS	:	.378	.124	.175
MEAN RADIUS	:	1.163	.803	.733
MAX RADIUS	:	3.233	2.113	1.948
HORIZONTAL SPREAD	:	4.509	3.207	1.907
VERTICAL SPREAD	:	2.881	2.150	2.150
EXTREME SPREAD	:	5.050	3.559	2.874
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		7	



PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.499	1.243	.806
MINIMUM X	:	-2.303	-1.119	-.963
MAXIMUM Y	:	1.792	1.989	1.755
MINIMUM Y	:	-2.062	-1.865	-1.671
CENTROID X	:	.320	.576	.420
CENTROID Y	:	-2.483	-2.680	-2.446
POA TO CENTROID in.	:	2.504	2.741	2.482
MIN RADIUS	:	.320	.624	.417
MEAN RADIUS	:	1.531	1.372	1.235
MAX RADIUS	:	2.902	2.282	2.002
HORIZONTAL SPREAD	:	3.802	2.362	1.769
VERTICAL SPREAD	:	3.854	3.854	3.426
EXTREME SPREAD	:	5.395	4.520	3.856
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		5	

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6225414

OP. #	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and Stock	JUL 2 9	1991	RW
600	Proof	JUL 2 9	1991	RW
607	Check Headspace	JUL 2 9	1991	RW
610	Dis-assemble Gun	JUL 2 9	1991	RW
612	Magnaflux Barrel Action	JUL 3 0	1991	KCR
	Magnaflux Bolt	JUL 3 0	1991	KCR
615	Rollmark Caliber	JUL 3 0	1991	CS
617	Drill and Tap Sight Holes	JUL 3 0	1991	FB
618	Polish Barrel	JUL 3 1	1991	WB
620	Apply Coatings (Barrel Action)	AUG 1	1991	TJA
	Apply Coating (Bolt)	AUG 1	1991	TJA.
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			

op. #	BARBER M24 0088233	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		9-25-91	DH
	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		9/23/91	KT
	A) Time		" "	KT
	B) Malfunctions		" "	KT
	C) Pierced Primers		" "	KT
	D) Optical Clearity of Scope		" "	KT
645	Inspect for Live Ammo		9/23/91	KT
655	Final Inspection A) Headspace		9-25-91	DH
	B) Trigger Pull	2.54 2.59 2.71 2.50 2.63	9/24/91	JH
	C) Function		9-25-91	DH
660	Pack		9/24/91	WB

RECEIVING AND ESTIMATING REPORT

BARBER - M24 0088234

CUST NO: 046771 C.O.D

COMMENTS: M-24 SNIPER

INITIAL	CUSTOMER ORDER NO.
JJM	006257

DATE RECEIVED	DATE OPENED	DATE CODE	SERIAL NUMBER	MODEL AND GRADE	ORDER
07/29/91	07/29/91	KI 5-88	C6225414	700 7.62 NATO	R 91-14516

ACCESSORIES: W/STUDS SCOPE BASE

FROM:

CO D 2ND BN 1ST SPWAR TNG GP
C/O CPT M K STEPHENSON
FT BRAGG NC 28307
USA

SHIP TO:

CO D 2ND BN 1ST SPWAR TNG GP
C/O CPT M K STEPHENSON
FT BRAGG NC
USA 28307

ACCOUNT NUMBER	ACCOUNT NUMBER N/C		PROM. DATE	ESTIMATED	VIA
		WRITE ☐ CLEAN/TEST			DOOR

REPAIR CHARGE	TAX	INSURANCE	UPS	PARCEL POST	TOTAL

GUN CONDITION: ☐ NEW ☐ SLIGHTLY WORN ☑ VERY WORN ☐ MISUSED ☐ MARRED

CUSTOMER'S REQUEST

1) NEW BARREL
2) RE POWDER COAT TRIGGER GUARD ASSY
3) CLEAN FIRE CONTROL

MAIN FAULT

PARTS

REPAIRMAN	PROOF	CLEAN	TEST	TARGET	PATTERN
RW	✓	KT	KT	KT	
GALLERY TESTER	**DATE**	**DATE**	**DATE**	**DATE**	**DATE**
KT	7/29/91	Sept 23	Sept 23	Sept 29	

OFFICE COPY

RD6925 REV. 7/90