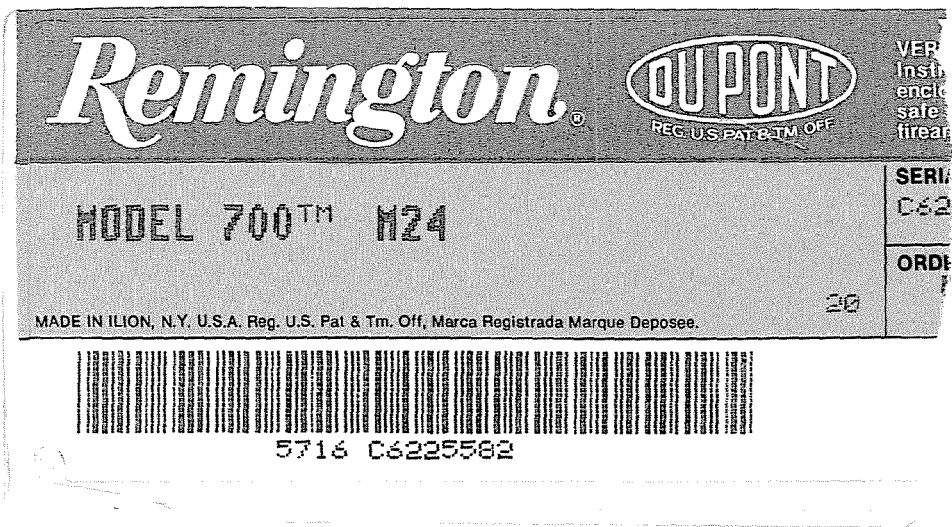


Gr. 653 5219
Reg 1000
C: 622 5582



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: **RE00112697**

Serial: C6225582 Model M24 SV/S Center Fire
Caliber: 7.62 NATO

Repairman:

Status: Closed 5/23/2006 11:37:32 AM

Address Information

Customer:

☒ Received From

Return To:

☐ Received From

Name: DEPARTMENT OF THE ARMY

DEPARTMENT OF THE ARMY

Address 1: A COMPANY 2ND BATTALION

A COMPANY 2ND BATTALION

Address 2: 7TH SPECIAL FORCES GROUP

PO Box:

7TH SPECIAL FORCES GROUP

PO Box:

City: FORT BRAGG

FORT BRAGG

State: NC

Zip Code: 28310

Country: US

State: NC

Zip Code: 28310

Country: US

FFL:

Contact / Condition

Problems

Estimate

History / Status

Shipping / Billing

Contact Information

Phone: NA

Fax:

Email:

Comments:

Received Condition

Fair

Condition

Notes:

CSR

Notes:

Accessories Received

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

Repair Search

Refresh

Close

maglel

5/23/2006

1:24 PM

CAPS

NUM

INS

SCRL

start

3 Micros...

2 Micros...

3 Intern...

Part Searc...

Arms Servi...

1:24 PM

G/653 5219 (Nau)

Serial Number:

C6225582

Model: M24 SWS



RE00112697

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6535219.___0

FILE DATE AND TIME: 06/06/2006 07:48

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.014
The Average Y Centroid of the Five Target Set:	-0.110
The Average Point of Impact of the Five Target Set:	0.111
The Average Mean Radius of the Five Target Set:	0.720
The Distance from POA to Centroid Target #1:	0.148
The Distance from Centroid Target #2 to Centroid Target #1:	0.275
The Distance from Centroid Target #3 to Centroid Target #1:	0.463
The Distance from Centroid Target #4 to Centroid Target #1:	0.381
The Distance from Centroid Target #5 to Centroid Target #1:	0.323

SERIAL NUMBER: G6535219. 0

TARGET NUMBER: 1

FILE DATE: 06/06/2006

FILE TIME: 07:48

POINT#	X	Y
1:	0.015	-1.015
2:	-1.071	-0.113
3:	-1.183	0.649
4:	1.098	1.124
5:	0.061	0.448
6:	-0.360	0.254
7:	0.043	-0.180
8:	0.589	-0.432
9:	0.023	0.327
10:	-0.111	0.114

X CENTROID: -0.090

Y CENTROID: 0.118

POA TO CENTROID: 0.148

HORZ SPREAD: 2.281

VERT SPREAD: 2.139

GROUP SPREAD: 2.497

MIN RADIUS: 0.022

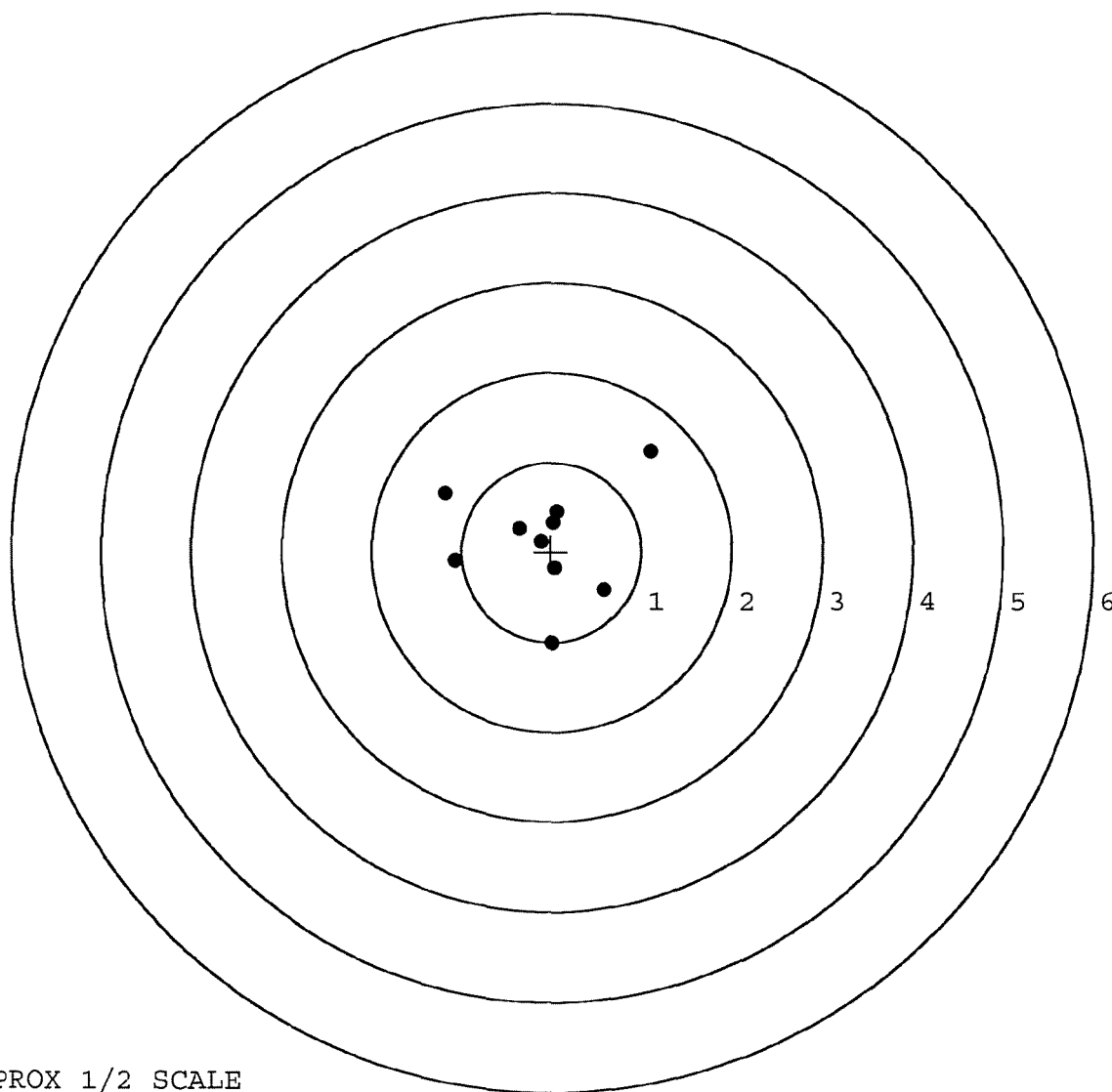
MAX RADIUS: 1.557

MEAN RADIUS: 0.704

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 9

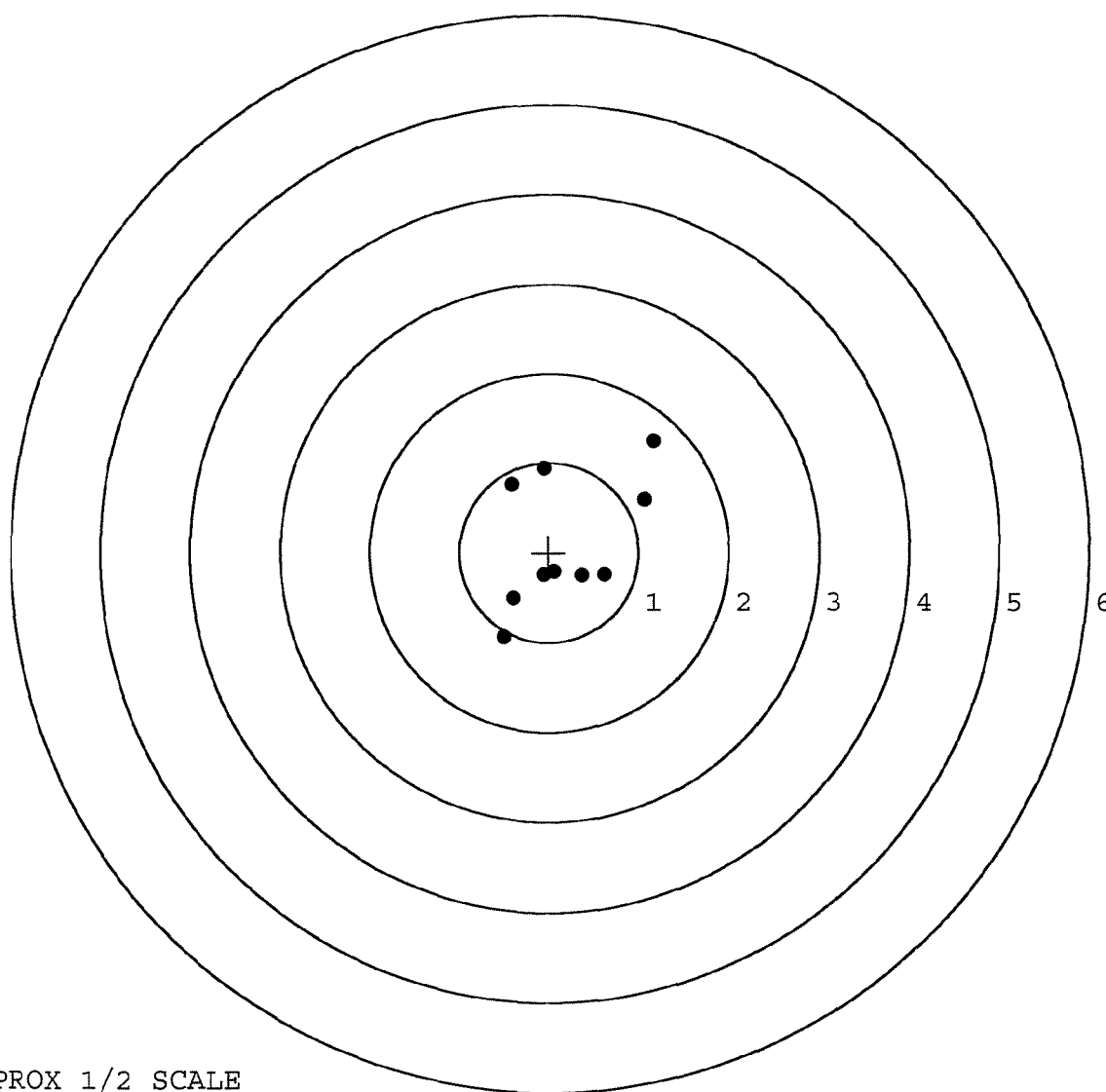


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6535219. __0
 TARGET NUMBER: 2
 FILE DATE: 06/06/2006
 FILE TIME: 07:48

POINT#	X	Y
1:	1.064	0.587
2:	1.156	1.245
3:	-0.056	0.935
4:	-0.416	0.751
5:	0.624	-0.243
6:	0.373	-0.256
7:	0.060	-0.214
8:	-0.060	-0.250
9:	-0.395	-0.514
10:	-0.499	-0.952

X CENTROID: 0.185
 Y CENTROID: 0.109
 POA TO CENTROID: 0.215
 HORZ SPREAD: 1.655
 VERT SPREAD: 2.197
 GROUP SPREAD: 2.751
 MIN RADIUS: 0.346
 MAX RADIUS: 1.494
 MEAN RADIUS: 0.810
 # IN 1 IN DIAMETER: 3
 # IN 2 IN DIAMETER: 7
 # in 3 IN DIAMETER: 10



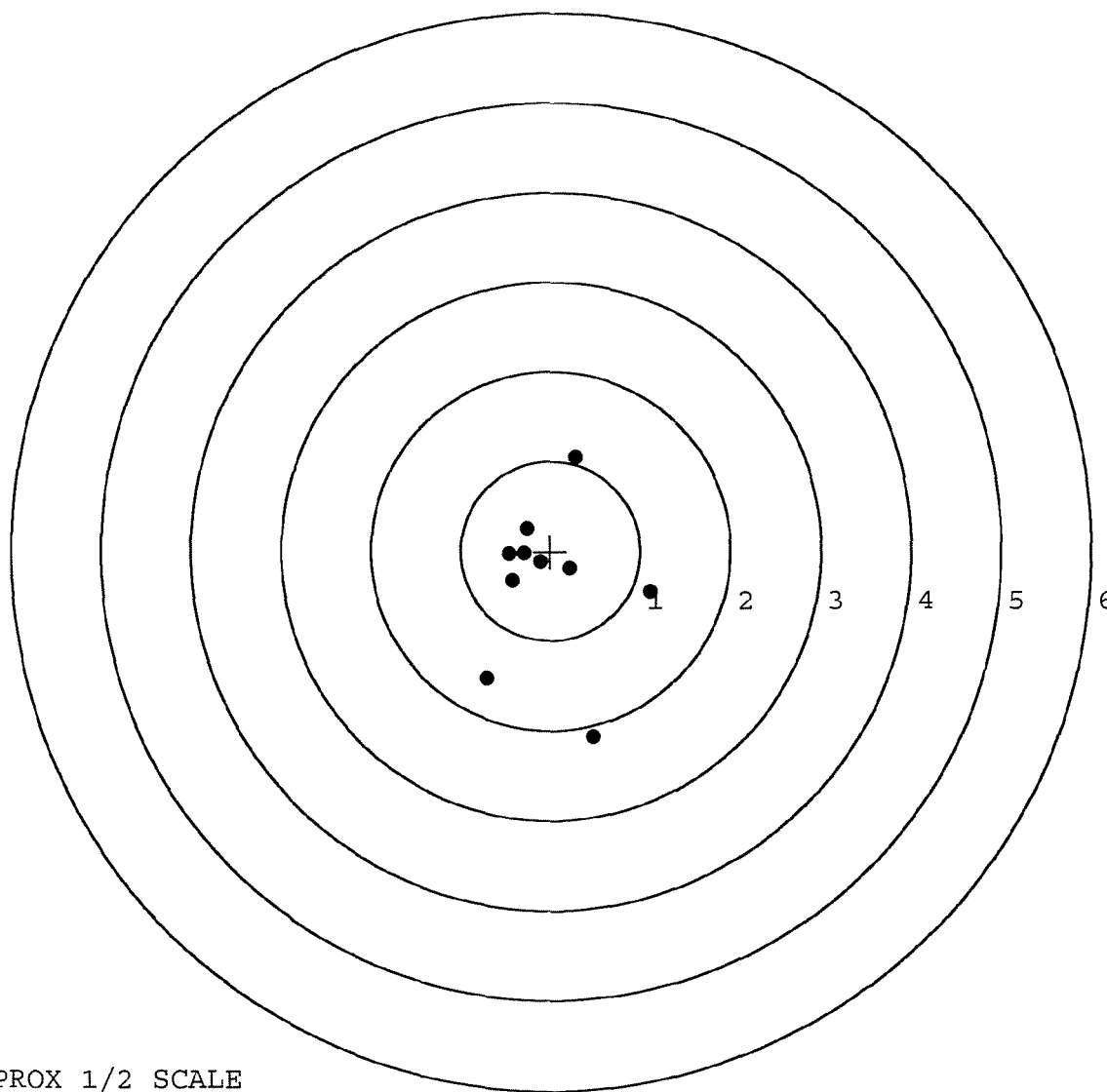
TARGET APPROX 1/2 SCALE

BARBER - M24 0089745

SERIAL NUMBER: G6535219. __0
 TARGET NUMBER: 3
 FILE DATE: 06/06/2006
 FILE TIME: 07:48

POINT#	X	Y
1:	0.487	-2.080
2:	-0.701	-1.427
3:	1.108	-0.455
4:	0.276	1.043
5:	0.214	-0.199
6:	-0.262	0.252
7:	-0.455	-0.036
8:	-0.426	-0.339
9:	-0.108	-0.118
10:	-0.288	-0.031

X CENTROID: -0.016
 Y CENTROID: -0.339
 POA TO CENTROID: 0.339
 HORZ SPREAD: 1.809
 VERT SPREAD: 3.123
 GROUP SPREAD: 3.130
 MIN RADIUS: 0.240
 MAX RADIUS: 1.812
 MEAN RADIUS: 0.814
 # IN 1 IN DIAMETER: 4
 # IN 2 IN DIAMETER: 6
 # in 3 IN DIAMETER: 9



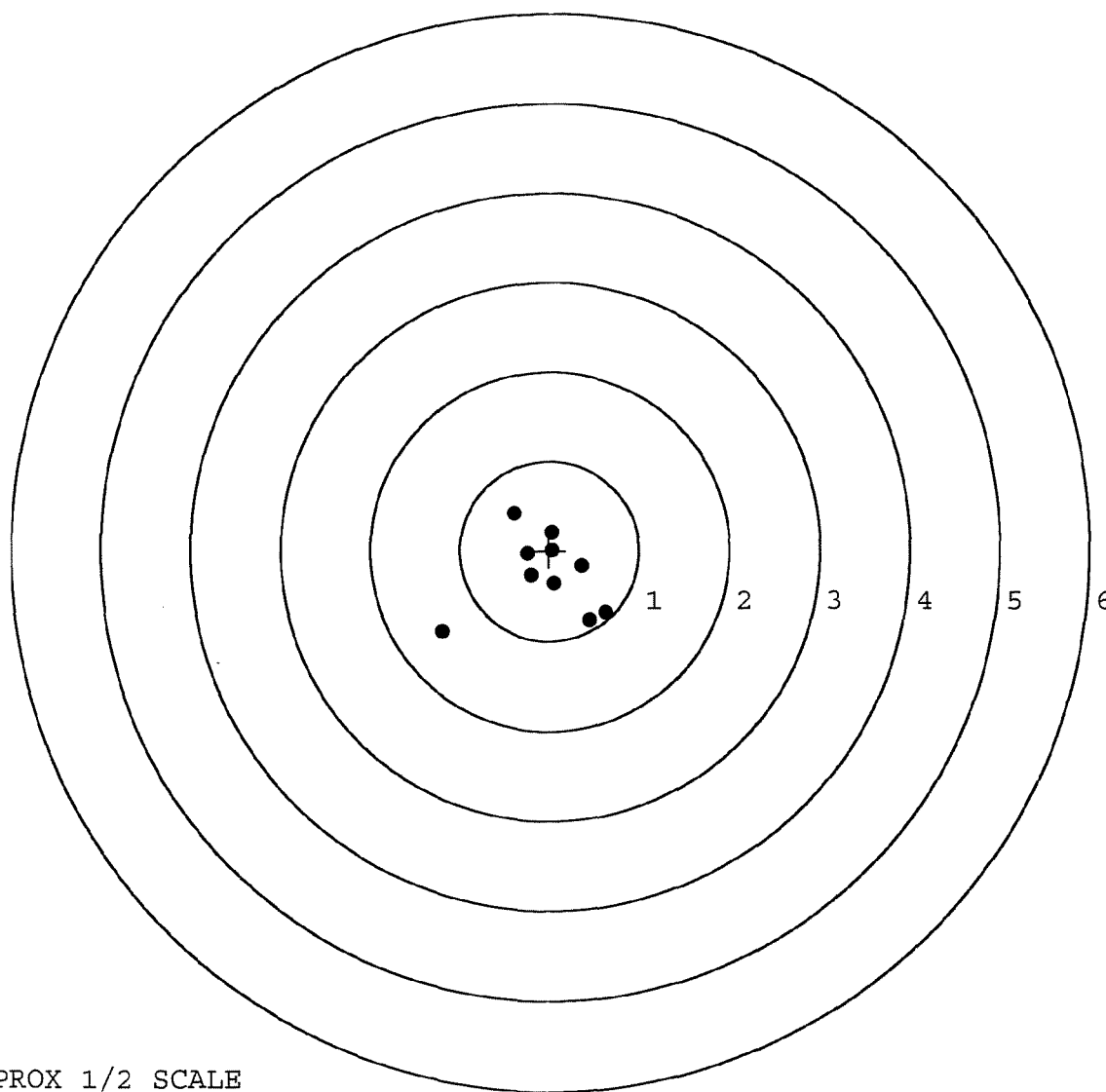
TARGET APPROX 1/2 SCALE

BARBER - M24 0089746

SERIAL NUMBER: G6535219. __0
 TARGET NUMBER: 4
 FILE DATE: 06/06/2006
 FILE TIME: 07:48

POINT#	X	Y
1:	0.633	-0.684
2:	0.455	-0.778
3:	-1.190	-0.905
4:	-0.395	0.413
5:	0.037	0.203
6:	0.361	-0.175
7:	0.057	-0.368
8:	-0.206	-0.277
9:	-0.241	-0.037
10:	0.039	0.001

X CENTROID: -0.045
 Y CENTROID: -0.261
 POA TO CENTROID: 0.265
 HORZ SPREAD: 1.823
 VERT SPREAD: 1.318
 GROUP SPREAD: 1.836
 MIN RADIUS: 0.148
 MAX RADIUS: 1.314
 MEAN RADIUS: 0.536
 # IN 1 IN DIAMETER: 6
 # IN 2 IN DIAMETER: 9
 # in 3 IN DIAMETER: 10

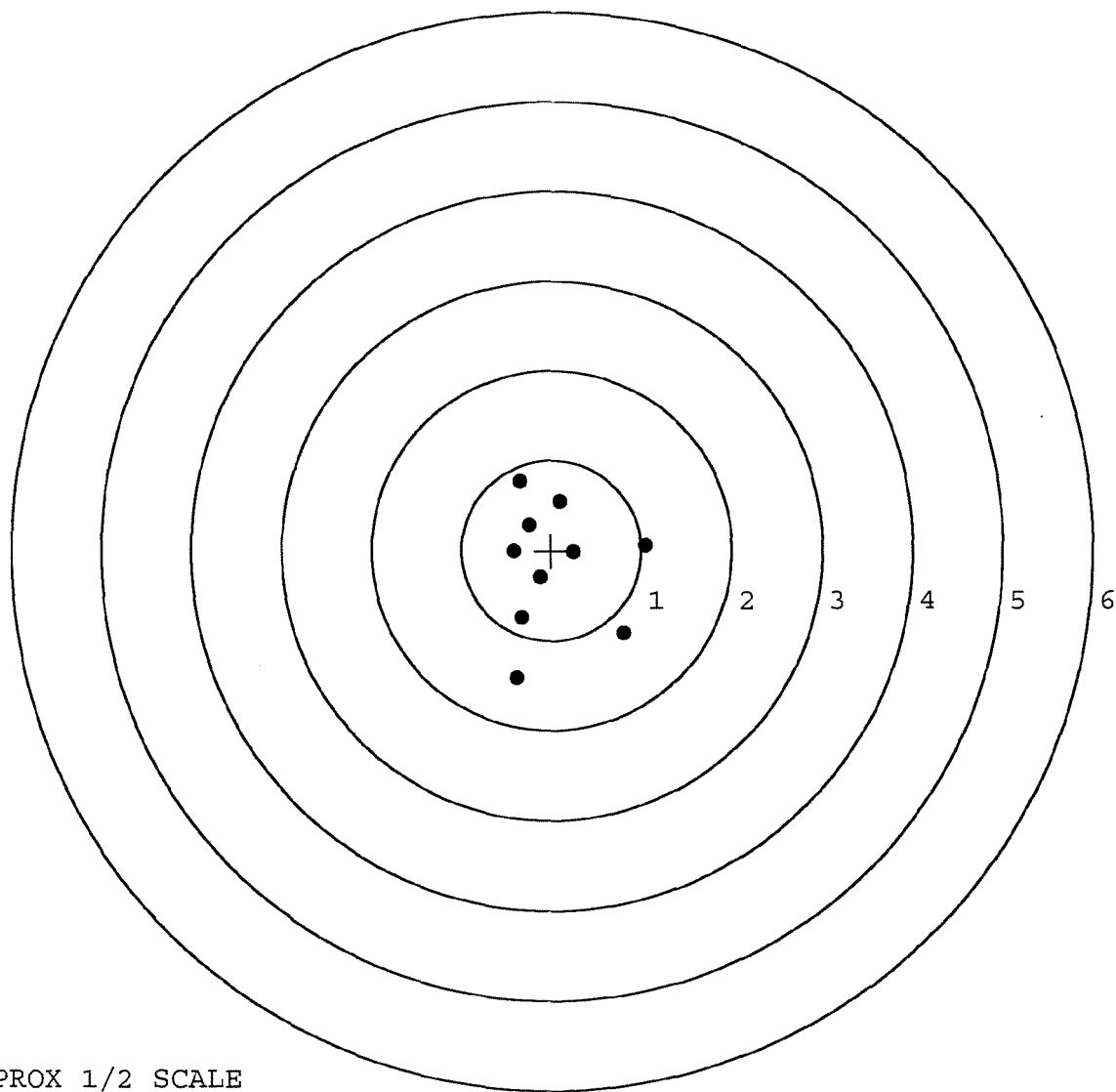


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6535219. __0
 TARGET NUMBER: 5
 FILE DATE: 06/06/2006
 FILE TIME: 07:48

POINT#	X	Y
1:	0.813	-0.918
2:	1.049	0.058
3:	-0.374	-1.423
4:	-0.326	-0.752
5:	0.099	0.543
6:	-0.349	0.765
7:	-0.247	0.276
8:	-0.419	-0.014
9:	0.250	-0.022
10:	-0.123	-0.305

X CENTROID: 0.037
 Y CENTROID: -0.179
 POA TO CENTROID: 0.183
 HORZ SPREAD: 1.468
 VERT SPREAD: 2.188
 GROUP SPREAD: 2.188
 MIN RADIUS: 0.204
 MAX RADIUS: 1.310
 MEAN RADIUS: 0.733
 # IN 1 IN DIAMETER: 3
 # IN 2 IN DIAMETER: 6
 # in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

BARBER - M24 0089748
**AVERAGE PULL FORCE BETWEEN
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 5-5-06

 TESTER R.P.

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	241	240		257	
PULL #2	246	240		250	
PULL #3	249	240		253	
PULL #4	247	245		259	
PULL #5	251	242		255	
TOTAL	1234	1207		1274	
AVERAGE	246	241		254	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	323	305		
PULL #2	317	313		
PULL #3	325	290		
PULL #4	322	316		
PULL #5	329	304		
TOTAL	1616	1528		
AVERAGE	323	305		

	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	417	402		401
PULL #2	405	394		399
PULL #3	397	398		397
PULL #4	405	407		405
PULL #5	401	395		396
TOTAL	2025	1996		1998
AVERAGE	405	399		399

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

R & E NUMBER	112697			
SERIAL NUMBER	C6225582		C6535219 (New)	
LOG-IN DATE	5-23-06			
OPERATION #	OPERATION NAME		DATE	INITIAL
500	DIS-ASSEMBLE GUN		5-24-06	RTZ
505	RE-BARREL		5-26-06	RTZ
560	ASSEMBLE		5-30-06	RTZ
600	PROOF	MAGNA-FLUX INSPECTED	5-30-06	TRW
605	CHECK HEADSPACE		5-30-06	TRW
610	DIS-ASSEMBLE GUN	JUN 02 2006	6-1-06	RTZ
612	MAGNAFLUX	OPERATOR <u>APD</u>	6-2-06	APD
510	DRILL AND TAP		6-1-06	TRW
615	ROLLMARK CALIBER		6-2-06	CW
618	ROTO-BLAST		6-2-06	CB
620	APPLY COATINGS		6/5/06	TS
625	FINAL ASSEMBLY		6-6-06	RTZ
640	FUNCTION TEST AND	PASS FAIL	6-6-06	TRW
650	TARGET	PASS FAIL	6-6-06	TRW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION	6-6-06	R.P.
670	FINAL INSPECTION		6-8-06	AC
	A) HEADSPACE	PASS FAIL	6-8-06	AC
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	6-8-06	DA
		2.75 2.87 2.81 2.82 2.84		
680	F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX	6-8-06	DA
		6.0 6.0 6.0		
	G) SAFETY OFF FORCE	2 LBS MIN	6-8-06	DA
		3.0 3.0 3.0		
	I) FIRING PIN INDENT	.020	6-8-06	DA
		1.024 1.022 1.024		
690	PACK		6-8-06	DA

BBL - 96003

Ams 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: RE00008600

Serial: C6225582 Model 700 Center Fire Caliber:
7.62 M-24 (SWS)

Repairman:

Status:

Closed 4/27/00 9:25:35 AM

Verify Repair

Address Information

Customer:

Received From

Return To:

Received From

Name: 2/7TH SPECIAL FORCES GROUP (A)

2/7TH SPECIAL FORCES GROUP (A)

Address 1: ATTN: S4, BLDG. E-3323

ATTN: S4, BLDG. E-3323

Address 2: PO Box:

PO Box:

City: FORT BRAGG

FORT BRAGG

State: NC Zip Code: 28310

Country: US

State: NC Zip Code: 28310

Country: US

FFL:

Contact / Condition

Problems

Estimate

History / Status

Shipping / Billing

Contact Information

Phone:

Fax:

Email:

Comments:

Received Condition

Poor

Condition
Notes:CSR
Notes:

Accessories Received

Code	Desc	Qty
A007	With Stud, & SWIVEL	2
A016	Scope Mounts	2
A017	Scope Base	1
A026	Scope	1
XXX	W/ BI-POD	1

Repair Search

Refresh

Close

naglelj

4/27/00

12:51 PM

CAPS

NUM

INS

SCRL



12:51 PM

Serial:
Number:

C6225582

Model: 700



RE00008600

Scope S/H 88-0538

Bi-pod

M-24 INSPECTION CHECKLIST
CONTRACT #: DAAE-20-97-C-242

[illegible]

Final Inspection

S.N.	DATE REC'D:	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-1250
- ☐ 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:

Remington Test Lab, Ilion, N.Y.

Centroidal distance calculations for Rifle # c6225582
22 Jul 2000

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0926

THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0366

THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0995707

THE AM FOR THIS RIFLE IS: 1.042

CENTROIDAL DISTANCES

0 TO 1	.196901
1 TO 2	.170857
2 TO 3	.257241
3 TO 4	.526047
4 TO 5	.360272

$$\begin{matrix} & 1 \\ & + \\ & 3 \\ 4 & 5 \end{matrix} \leftarrow \text{POA}$$

REMINGTON CENTERFIRE ACCURACY TEST

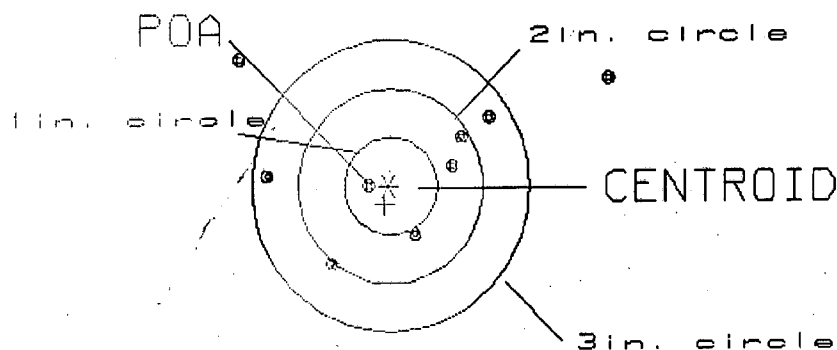
REMINGTON TEST LAB, ILION, N.Y.

PATTERN #: 010
 POA TO CENTROID: .197
 MIN RADIUS : .246
 MEAN RADIUS : 1.380
 MAX RADIUS : 2.958
 CENTROID X : .039
 CENTROID Y : .193

21 Jul 2000

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6225502

CENTERFIRE PATTERN # 1



OF SHOTS= 10

IN CIRCLE

HS= 3.93

1

VS= 4.05

4

GS= 5.19

7

REMINGTON CENTERFIRE ACCURACY TEST

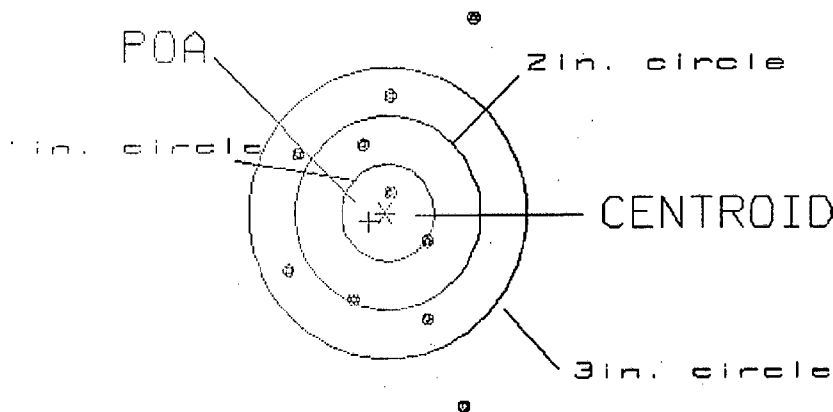
REMINGTON TEST LAB, ILION, N.Y.

PATTERN #: 0001
 POA TO CENTROID: .194
 MIN RADIUS : .225
 MEAN RADIUS : 1.154
 MAX RADIUS : 2.194
 CENTROID X : .173
 CENTROID Y : .087

2 Jul 2000

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6225582

CENTERFIRE PATTERN # 2



OF SHOTS= 10

IN CIRCLE

Hit 2.72
 Off 3.14
 On 3.34

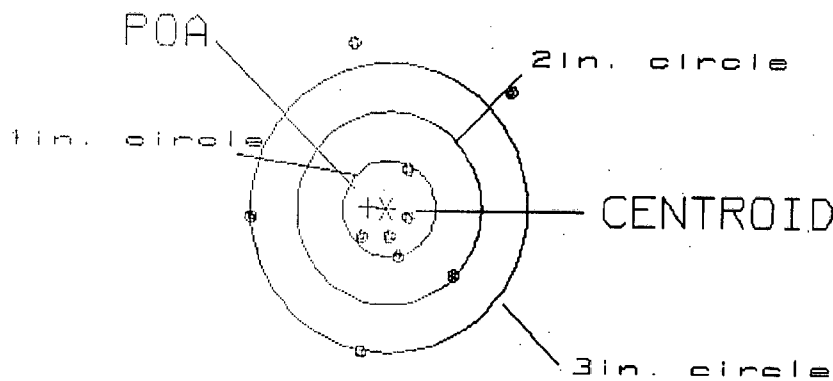
1
 4
 9

PATTERN #: 0 0 0
 POINT TO CENTROID: .197
 MIN. RADIUS: .175
 MEAN RADIUS: .939
 MAX. RADIUS: 1.818
 CENTROID X: .197
 CENTROID Y: -.010

7 Jul 2000

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6225582

CENTERFIRE PATTERN # 3



OF SHOTS= 10

IN CIRCLE

HP = 2.04
 US = 3.18
 GS = 3.18

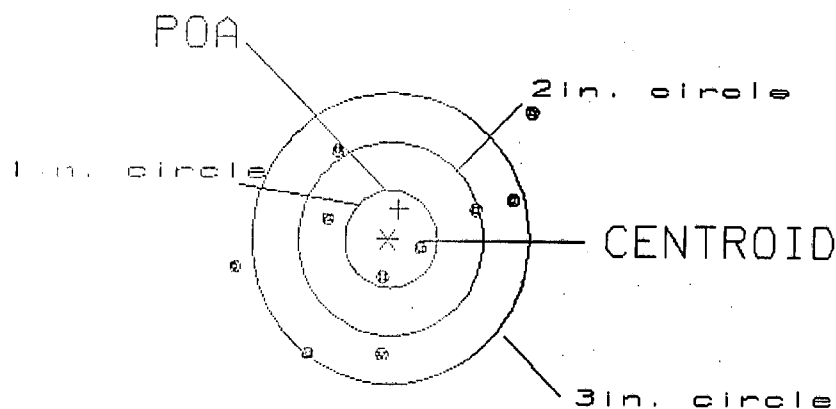
4
 6
 7

PATTERN : □ □
 POA TO CENTROID : .331
 MIN RADIUS : .338
 MEAN RADIUS : 1.115
 MAX RADIUS : 2.004
 CENTROID X : -.115
 CENTROID Y : -.310

22 Jul 2000

FILE:/Hptasic/Accuracy/Patterning/Centerfire_Patt/c6225582

CENTERFIRE PATTERN # 4



OF SHOTS= 10

IN CIRCLE

1S= 3.16
 2S= 2.00
 3S= 3.50

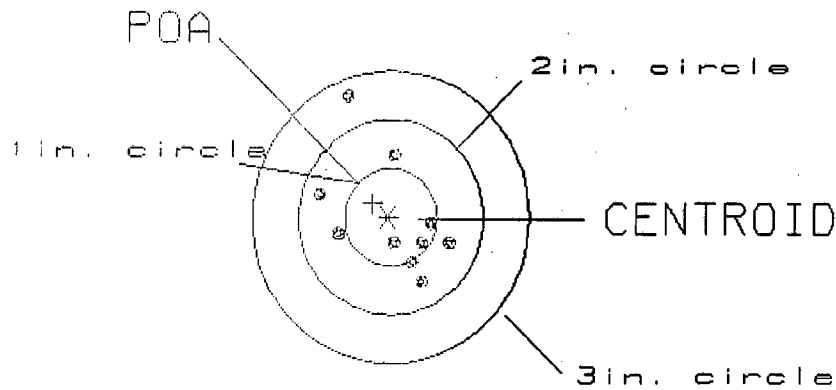
2
 4
 8

PATTERN #: ☐ 5 ☐
 POA TO CENTROID: .221
 M11 RADIUS : .237
 M12 RADIUS : .622
 M13 RADIUS : 1.328
 CENTROID X : .169
 CENTROID Y : -.143

22 Jul 2000

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6225582

CENTERFIRE PATTERN # 5



OF SHOTS= 10

IN CIRCLE

1S= 1.35

4

2S= 1.66

9

3S= 2.01

10

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6225582
23 Feb 1989

CENTROIDAL DISTANCES

0 TO	1	.165711
1 TO	2	.486186
1 TO	3	.153235
1 TO	4	.169402
1 TO	5	.371042

~~243~~ <----POA

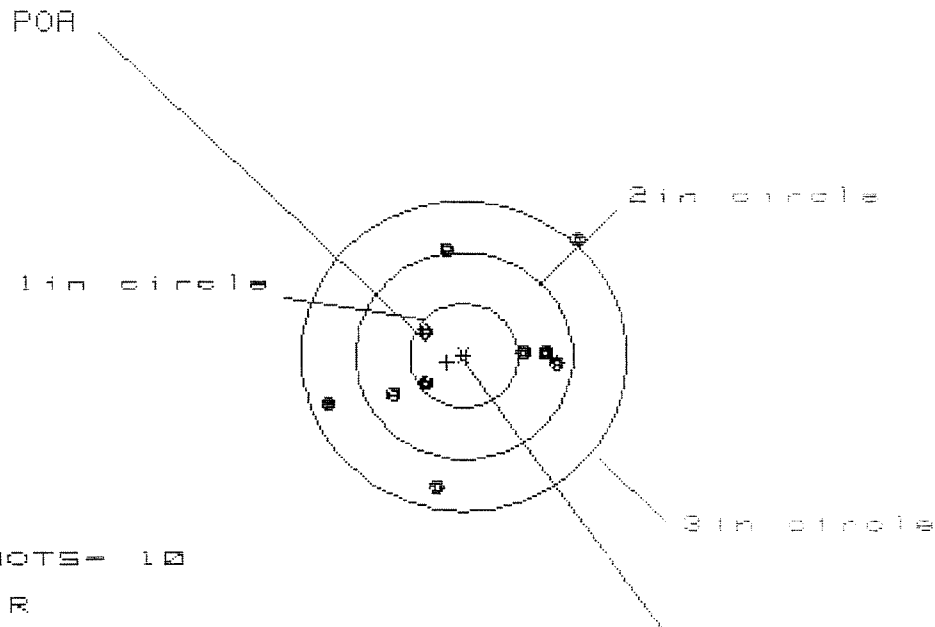
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0114
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1448
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .145248
THE AMR FOR THIS RIFLE IS: .8716

23 Feb 1989

FILE:/PATTERNING/CENTERFIRE_PATT/08225582

CENTERFIRE PATTERNS

1



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 5

3 in = 9

HS= 2.271

VS= 2.407

GS= 2.733

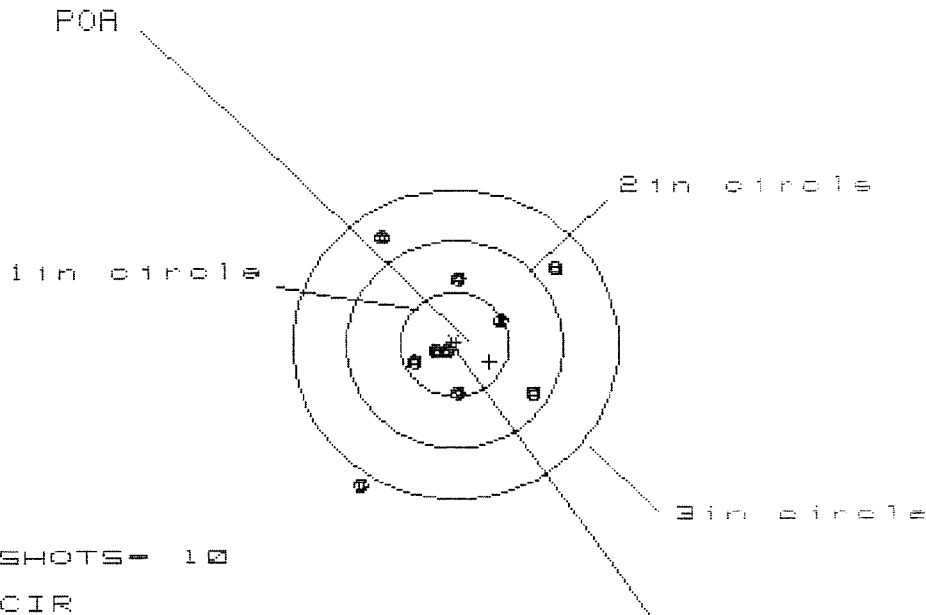
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.021	.974	.955
MINIMUM X	-1.250	-1.137	-1.156
MAXIMUM Y	1.103	1.168	1.021
MINIMUM Y	-1.304	-1.182	-1.443
CENTROID X	.152	.039	.058
CENTROID Y	.066	-.056	.091
POA TO CENTROID in.	.166	.068	.103
MIN RADIUS	.392	.228	.344
MEAN RADIUS	.896	.815	.761
MAX RADIUS	1.503	1.192	1.238
HORIZONTAL SPREAD	2.271	2.111	2.111
VERTICAL SPREAD	2.407	2.350	1.463
EXTREME SPREAD	2.733	2.351	2.136
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		9	

23 Feb 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C6225582

CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1 in = 4

2 in = 7

3 in = 9

HS = 1.776

VS = 2.443

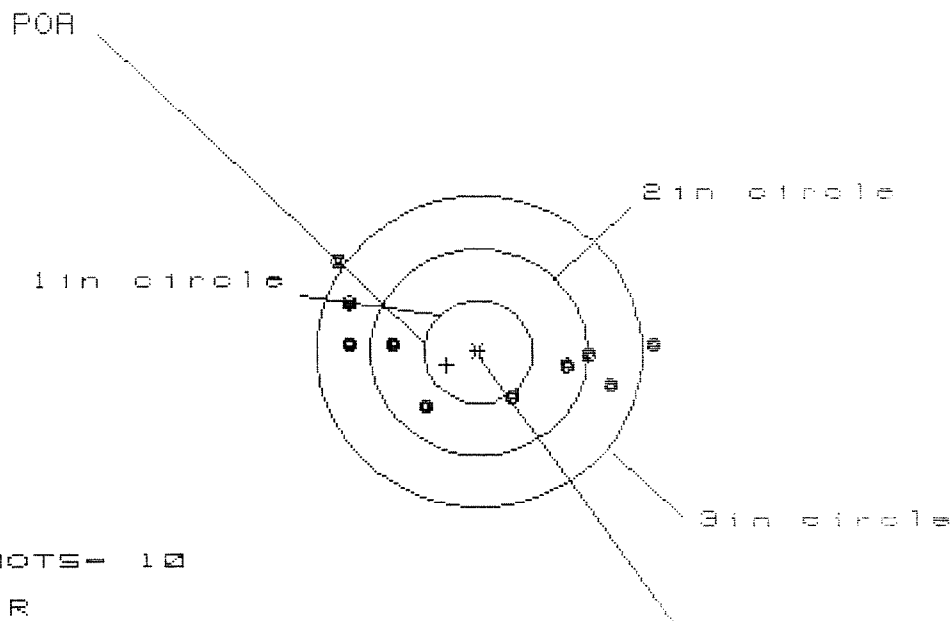
GS = 2.737

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.878	.778	.683
MINIMUM X	:	-.898	-.756	-.522
MAXIMUM Y	:	1.048	.893	.645
MINIMUM Y	:	-1.395	-.650	-.538
CENTROID X	:	-.324	-.224	-.130
CENTROID Y	:	.165	.320	.208
POA TO CENTROID in.	:	.363	.391	.245
MIN RADIUS	:	.060	.243	.251
MEAN RADIUS	:	.702	.616	.535
MAX RADIUS	:	1.659	1.170	.939
HORIZONTAL SPREAD	:	1.776	1.534	1.205
VERTICAL SPREAD	:	2.443	1.543	1.183
EXTREME SPREAD	:	2.737	2.038	1.459
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

23 Feb 1989

FILE:/PATTERNING/CENTERFIRE_PATT/08225582

CENTERFIRE PATTERNS # 3



OF SHOTS - 10

IN CIR

1 in = 0

2 in = 4

3 in = 8

HS = 2.930

VS = 1.388

GS = 3.042

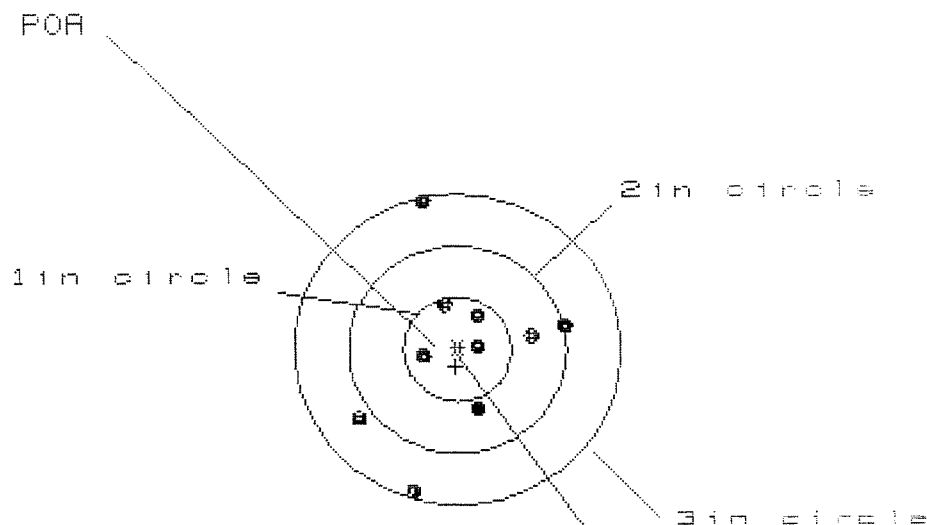
PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	1.592
MINIMUM X	-1.338
MAXIMUM Y	.873
MINIMUM Y	-.515
CENTROID X	.293
CENTROID Y	.126
POA TO CENTROID in.	.319
MIN RADIUS	.535
MEAN RADIUS	1.077
MAX RADIUS	1.598
HORIZONTAL SPREAD	2.930
VERTICAL SPREAD	1.388
EXTREME SPREAD	3.042
NUMBER IN ONE INCH CIRCLE	0
NUMBER IN TWO INCH CIRCLE	4
NUMBER IN THREE INCH CIRCLE	8

23 Feb 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C62255B2

CENTERFIRE PATTERNS

4



OF SHOTS - 10

IN CIR

1in = 4

2in = 6

3in = 9

HS = 1.946

VS = 2.813

GS = 2.815

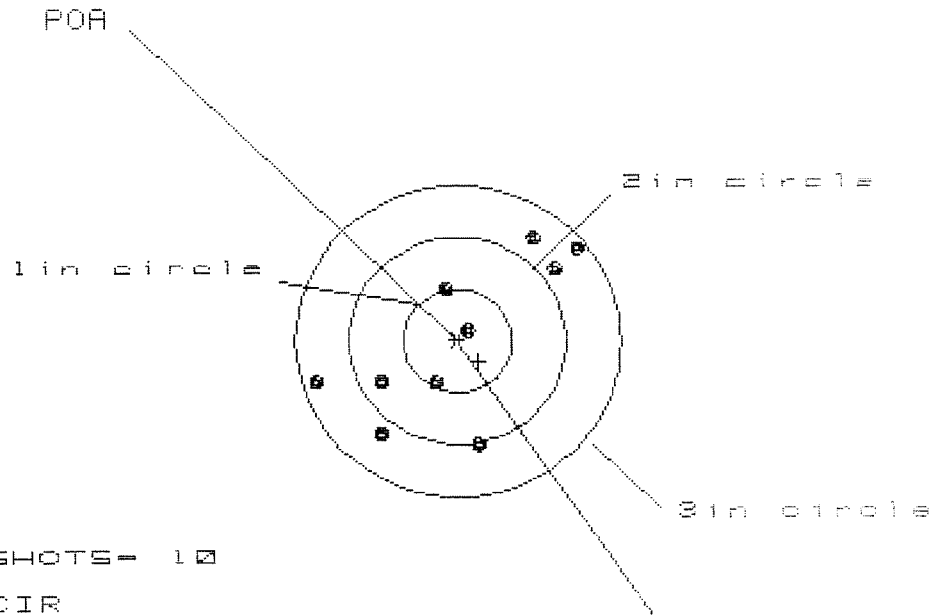
CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.016	.975	.913
MINIMUM X	:	-.930	-.971	-1.033
MAXIMUM Y	:	1.458	.556	.406
MINIMUM Y	:	-1.355	-1.193	-.704
CENTROID X	:	.016	.057	.119
CENTROID Y	:	.167	.005	.155
POA TO CENTROID in.	:	.168	.057	.195
MIN RADIUS	:	.206	.265	.115
MEAN RADIUS	:	.780	.709	.594
MAX RADIUS	:	1.502	1.294	1.250
HORIZONTAL SPREAD	:	1.946	1.946	1.946
VERTICAL SPREAD	:	2.813	1.749	1.110
EXTREME SPREAD	:	2.815	2.190	2.179
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

23 Feb 1989

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CENTERFIRE PATTERNS # 5



OF SHOTS = 10

IN CIR

1 in = 3

2 in = 4

3 in = 10

HS = 2.407

VS = 2.021

GS = 2.721

CENTROID *

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.104	1.014	.866
MINIMUM X	-1.303	-1.180	-.741
MAXIMUM Y	.977	1.075	1.039
MINIMUM Y	-1.044	-.946	-.982
CENTROID X	-.194	-.317	-.169
CENTROID Y	.200	.102	.138
POA TO CENTROID in.	.278	.333	.219
MIN RADIUS	.077	.233	.121
MEAN RADIUS	.903	.838	.785
MAX RADIUS	1.412	1.341	1.227
HORIZONTAL SPREAD	2.407	2.194	1.607
VERTICAL SPREAD	2.021	2.021	2.021
EXTREME SPREAD	2.721	2.431	2.285
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		4	
NUMBER IN THREE INCH CIRCLE =		10	

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. 5582

DATE _____

TESTER _____

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#	COMMENTS
PULL #1	2.36	2.18	2.06	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.32	2.08	2.14	
PULL #3	2.34	2.06	2.16	
PULL #4	2.32	2.06	2.08	
PULL #5	2.26	2.08	2.13	
TOTAL	11.60	10.46	10.57	
AVG.	2.32	2.09	2.11	

	3.00# INITIAL	3.00# AFTER 20 CYCLES	COMMENTS
PULL #1	3.12	3.12	
PULL #2	3.06	3.00	
PULL #3	3.08	3.05	
PULL #4	3.12	3.03	
PULL #5	3.11	3.01	
TOTAL	15.49	15.21	
AVG.	3.09	3.04	

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.26	4.33		
PULL #2	4.24	4.29		
PULL #3	4.22	4.26		
PULL #4	4.23	4.23		
PULL #5	4.31	4.15		
TOTAL	21.26	21.26		
AVG.	4.25	4.25		

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6225582

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	12 9 88		RW
600	Proof	12 9 88		RW
607	Check Headspace	12 9 88		RW
610	Dis-assemble Gun	12 9 88		RW
612	Magnaflux Barrel Action		12/22/88	SP.
	Magnaflux Bolt		1/3/89	SP.
615	Rollmark Caliber		12/22/88	MSC
617	Drill and Tap Sight Holes	1 3 89		FB
618	Polish Barrel	12 2 88		WPT
620	Apply Coatings (Barrel Action)		1/16/89	15X
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		2/14/89	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		2/14/89	RW
	C) Inspect Ejector Hole for Chamfer		2/14/89	RW
	D) Oil Firing Pin Ass'y		2/14/89	RW
	E) Adjust Trigger Pull to Min Setting and Stake		14 Feb 89	GD

op. #	BARBER - M24 0089767 OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	5	5			17 Feb 89	JS
	G) Safety Off Force	3	3	3			17 Feb 89	JS
	H) Trigger Pull Test & Retainability						14 Feb 89	JS
	I) Firing Pin Indent	.0205	.021	.021			17 Feb 89	JS
	J) Assemble Stock						2/23/89	RW
	K) Assemble Swivel Studs						24 Feb 89	JS
	L) Attach Front and Rear Sight Assemblies						2/23/89	RW
	M) Iron Sight Alignment						2/23/89	RW
	N) Detach Front & Rear Sights & place in numbered container						2/23/89	RW
	O) Attach Scope to Rifle						23 Feb 89	JS
	P) Detach & Attach Scope 20 Times						23 Feb 89	JS
640	Gallery Target & Test	92 R	80 L				2/23/89	K
	A) Time						1	AC
	B) Malfunctions					NONE	1	AC
	C) Pierced Primers					NONE	1	AC
	D) Optical Clarity of Scope					OK	2/23/89	AC
645	Inspect for Live Ammo					NONE	2/23/89	AC
655	Final Inspection A) Headspace						24 Feb 89	JS
	B) Trigger Pull	2.46	2.31	2.33	2.09	2.41	24 Feb 89	JS
	C) Function						24 Feb 89	JS
660	Pack						23 Mar 89	JS