

G-653 5223
Replaces
C-652 3313

Arms Services Repair & Estimate System
BARBER - M24 0089805

File Add Repair Estimate Repair Expedite Repair Inquiry Repair Tools CSR Tools Reports Table Maintenance System Maintenance Help

Repair Inquiry

Repair Number: **RE00068108** Serial: C6523313 Model 700 Center Fire Caliber: 7 Repairman: _____
 Verify Repair 62 NATO M/24 SWS Status: Closed 7/28/2003 11:17:16 AM

Address Information

Customer: _____ Received From: _____ Return To: _____ Received From: _____
 Name: **USPFO FOR ARK** **USPFO FOR ARK**
 Address 1: **CAMP J T ROBINSON** **CAMP J T ROBINSON**
 Address 2: _____ PO Box: _____ PO Box: _____
 City: **NORTH LITTLE ROCK** **NORTH LITTLE ROCK**
 State: **AR** Zip Code: **72119** Country: **US** State: **AR** Zip Code: **72119** Country: **US**

FFL: ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐

Contact / Condition	Problems	Estimate	History / Status	Shipping / Billing												
Contact Information Phone: _____ Fax: _____ Email: _____ Comments: _____	Received Condition Fair Condition Notes: _____ CSR Notes: _____	Accessories Received <table border="1"> <thead> <tr> <th>Code</th> <th>Desc</th> <th>Qty</th> </tr> </thead> <tbody> <tr> <td>A007</td> <td>With Stud</td> <td>3</td> </tr> <tr> <td>A017</td> <td>Scope Base</td> <td>1</td> </tr> <tr> <td>C000</td> <td>FRONT AND REAR B.</td> <td>1</td> </tr> </tbody> </table>	Code	Desc	Qty	A007	With Stud	3	A017	Scope Base	1	C000	FRONT AND REAR B.	1		
Code	Desc	Qty														
A007	With Stud	3														
A017	Scope Base	1														
C000	FRONT AND REAR B.	1														

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

negletj 7/28/2003 12:46 PM CAPS NUM INS SCRL
 start 6:00 AM 4:00 PM Arms Sg. My E. Mail 2:00 PM Post Sg. 12:46 PM

Serial Number: **C6523313**

Model: **700**



RE00068108

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6523313.___0
FILE DATE AND TIME: 08/20/2003 06:39

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.025
The Average Y Centroid of the Five Target Set:	-0.010
The Average Point of Impact of the Five Target Set:	0.027
The Average Mean Radius of the Five Target Set:	0.781
The Distance from POA to Centroid Target #1:	0.095
The Distance from Centroid Target #2 to Centroid Target #1:	0.294
The Distance from Centroid Target #3 to Centroid Target #1:	0.056
The Distance from Centroid Target #4 to Centroid Target #1:	0.227
The Distance from Centroid Target #5 to Centroid Target #1:	0.223

SERIAL NUMBER: C6523313. __0

TARGET NUMBER: 1

FILE DATE: 08/20/2003

FILE TIME: 06:39

POINT#	X	Y
1:	1.032	-1.171
2:	0.068	-1.002
3:	-0.636	-0.197
4:	-0.867	-0.091
5:	-1.050	0.633
6:	-0.506	0.833
7:	1.176	0.533
8:	0.350	0.634
9:	0.151	0.444
10:	0.027	0.295

X CENTROID: -0.026

Y CENTROID: 0.091

POA TO CENTROID: 0.095

HORZ SPREAD: 2.226

VERT SPREAD: 2.004

GROUP SPREAD: 2.755

MIN RADIUS: 0.211

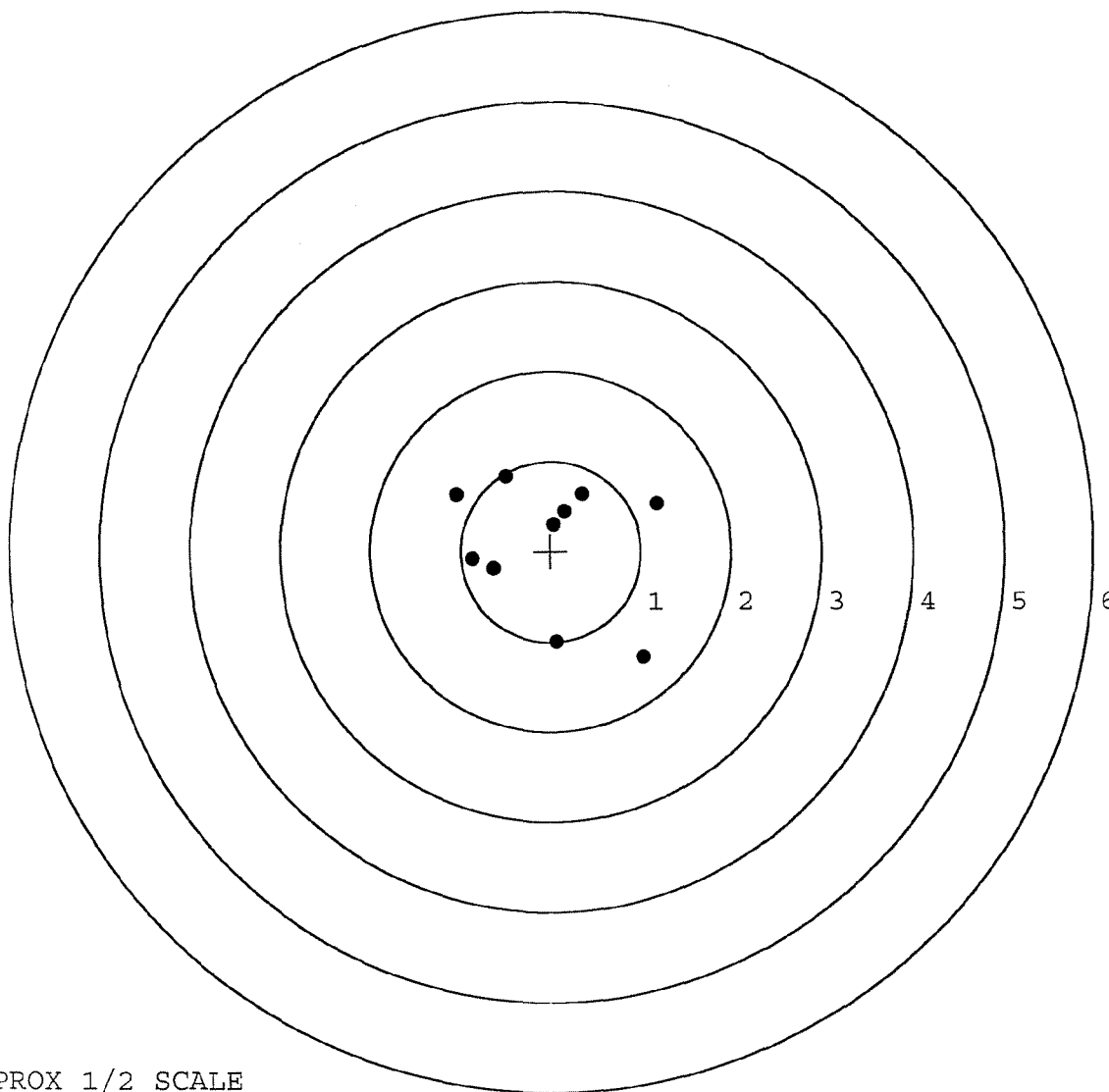
MAX RADIUS: 1.647

MEAN RADIUS: 0.887

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6523313. __0

TARGET NUMBER: 2

FILE DATE: 08/20/2003

FILE TIME: 06:39

X CENTROID: 0.142

Y CENTROID: -0.151

POA TO CENTROID: 0.207

HORZ SPREAD: 1.509

VERT SPREAD: 1.768

GROUP SPREAD: 1.769

MIN RADIUS: 0.179

MAX RADIUS: 0.916

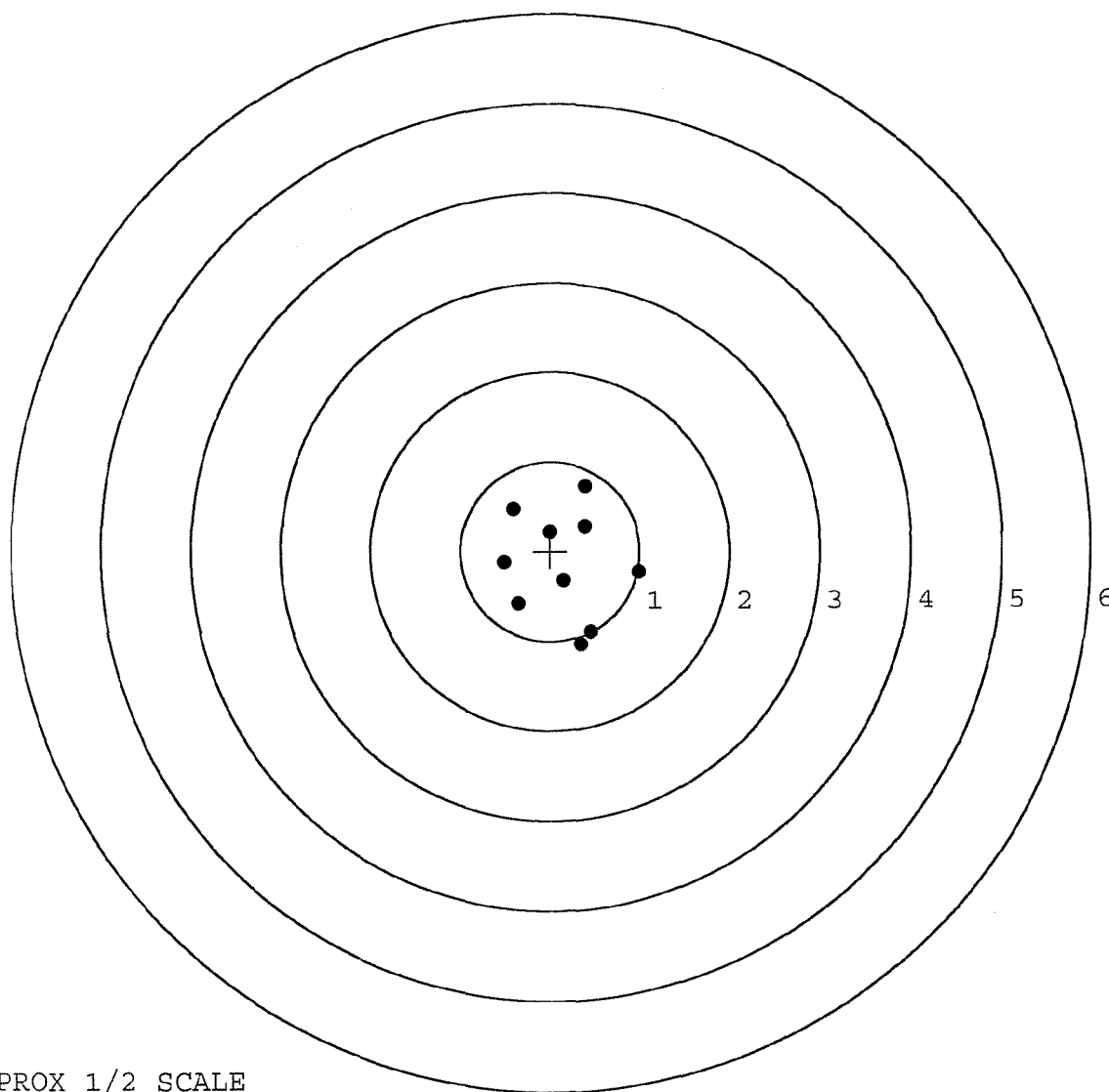
MEAN RADIUS: 0.672

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.992	-0.240
2:	0.448	-0.897
3:	0.346	-1.038
4:	0.153	-0.330
5:	-0.366	-0.585
6:	-0.517	-0.124
7:	-0.001	0.217
8:	-0.415	0.475
9:	0.391	0.730
10:	0.385	0.280



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6523313. __0

TARGET NUMBER: 3

FILE DATE: 08/20/2003

FILE TIME: 06:39

X CENTROID: -0.001

Y CENTROID: 0.040

POA TO CENTROID: 0.040

HORZ SPREAD: 1.786

VERT SPREAD: 1.701

GROUP SPREAD: 1.897

MIN RADIUS: 0.223

MAX RADIUS: 1.162

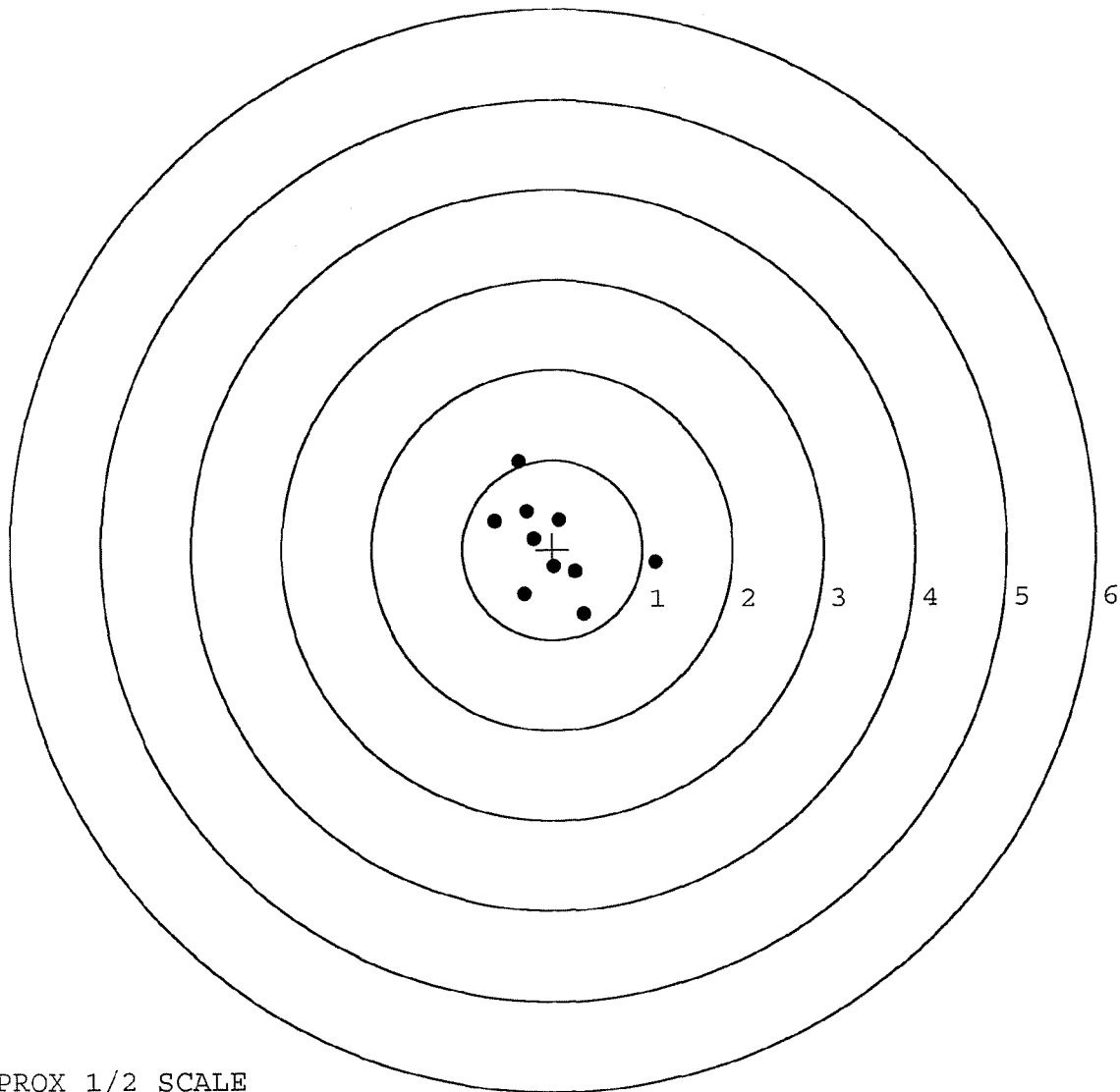
MEAN RADIUS: 0.595

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	1.145	-0.150
2:	0.345	-0.716
3:	-0.315	-0.496
4:	-0.641	0.325
5:	-0.293	0.429
6:	-0.375	0.985
7:	0.067	0.333
8:	-0.207	0.126
9:	0.247	-0.243
10:	0.018	-0.189



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6523313. __0

TARGET NUMBER: 4

FILE DATE: 08/20/2003

FILE TIME: 06:39

POINT#	X	Y
1:	1.190	0.055
2:	0.267	-0.405
3:	0.261	-1.176
4:	-0.251	-1.096
5:	-0.751	-0.732
6:	0.015	0.198
7:	-0.269	0.188
8:	-0.640	0.466
9:	-0.140	1.126
10:	0.373	0.036

X CENTROID: 0.006

Y CENTROID: -0.134

POA TO CENTROID: 0.134

HORZ SPREAD: 1.941

VERT SPREAD: 2.302

GROUP SPREAD: 2.337

MIN RADIUS: 0.332

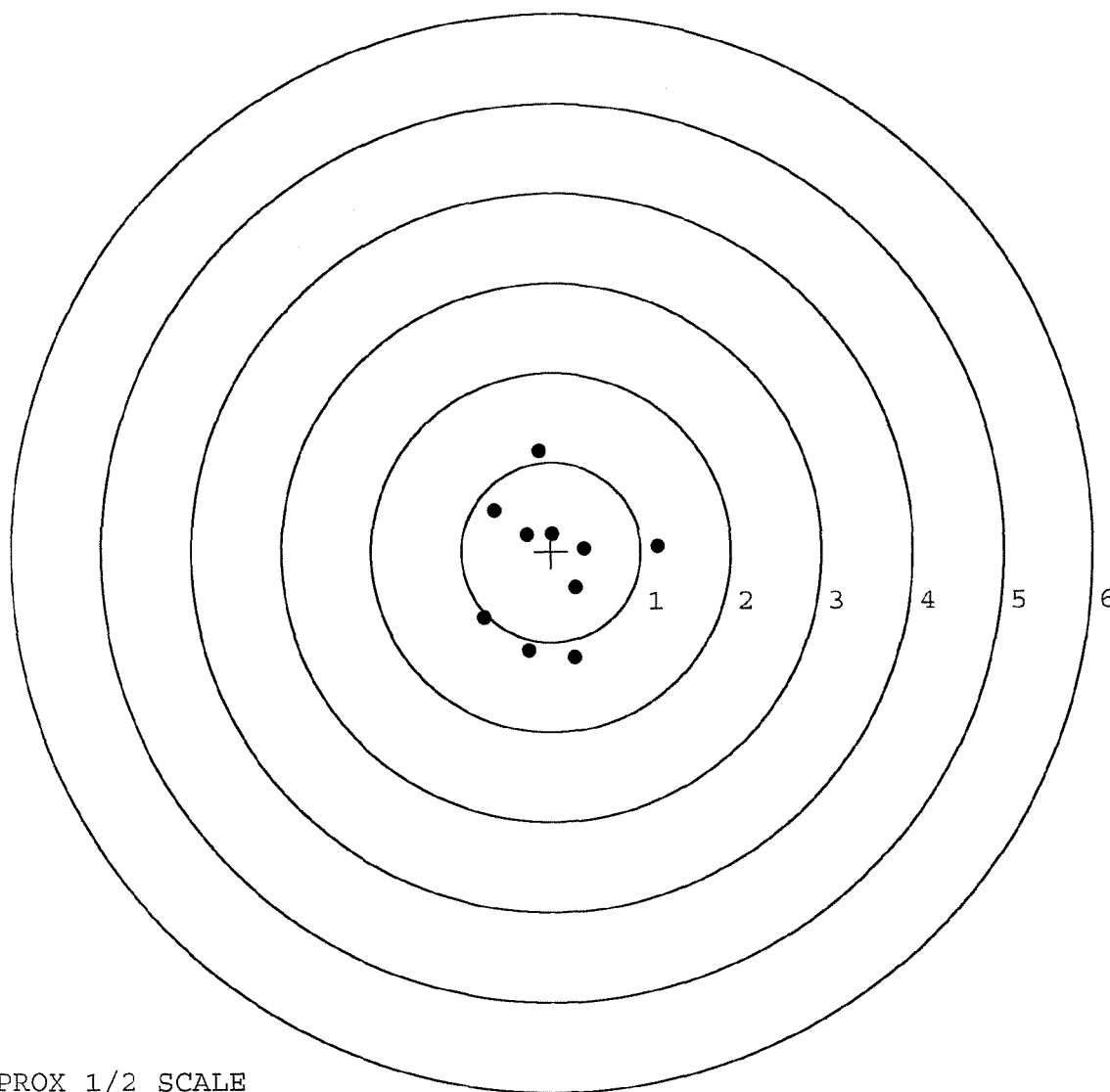
MAX RADIUS: 1.268

MEAN RADIUS: 0.792

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6523313. __0

TARGET NUMBER: 5

FILE DATE: 08/20/2003

FILE TIME: 06:39

X CENTROID: -0.248

Y CENTROID: 0.103

POA TO CENTROID: 0.269

HORZ SPREAD: 2.041

VERT SPREAD: 2.315

GROUP SPREAD: 2.425

MIN RADIUS: 0.439

MAX RADIUS: 1.328

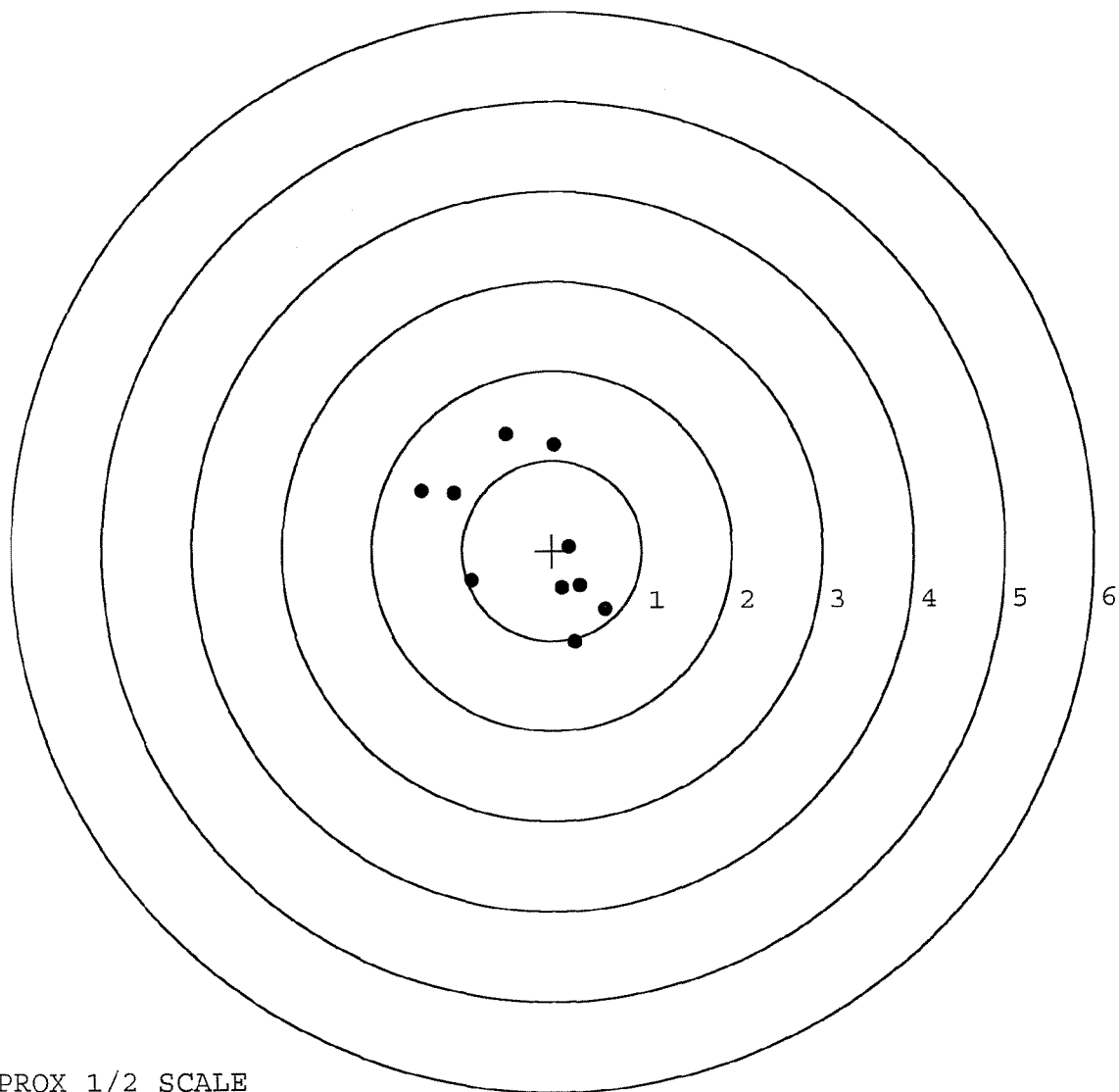
MEAN RADIUS: 0.959

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 5

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.588	-0.648
2:	0.247	-1.016
3:	0.108	-0.417
4:	0.187	0.045
5:	-0.894	-0.320
6:	-1.091	0.640
7:	-1.453	0.661
8:	-0.510	1.299
9:	0.027	1.177
10:	0.309	-0.386



TARGET APPROX 1/2 SCALE

BARBER - M24 0089812 M-24 INSPECTION CHECKLIST
CONTRACT #: DAAE-20-02-D-0127

R & E NUMBER	68108		
SERIAL NUMBER	C6523313		
LOG-IN DATE	7-28-03		
INSPECT AND VERIFY:			
OPERATION #	OPERATION NAME	DATE	INITIAL
550	DIS-ASSEMBLE GUN	7-29-03	RTL
560 A	RE-BARREL	8-7-03	RTL
B	DRILL AND TAP	8-11-03	TRW
575	ASSEMBLE MAGNA-FLUX	8-11-03	RTL
600	PROOF INSPECTED	8-11-03	AC
605	CHECK HEADSPACE	8-11-03	AC
610	DIS-ASSEMBLE GUN	8-11-03	RTL
612	MAGNAFLUX		
615	ROLLMARK CALIBER	8-12-03	SB
618	ROTO-BLAST	8-13-03	JB
620	APPLY COATINGS	8-14	TH
625 A	FINAL ASSEMBLY	8-18-03	RTL
B	TRIGGER PULL TEST		
C	SAFETY "ON" FORCE		
D	SAFETY "OFF" FORCE		
E	FIRING PIN INDENT		
640	TARGET	8-20-03	TRW
655	FINAL INSPECT	8-22-03	TRW
660	PACK	8-25-03	TH
		SHIP DATE	
	QAR INSPECTION DATE		

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6523313
8 Nov 1990

CENTROIDAL DISTANCES

0 TO	1	.0806226
1 TO	2	.157115
1 TO	3	.169956
1 TO	4	.194612
1 TO	5	.127122

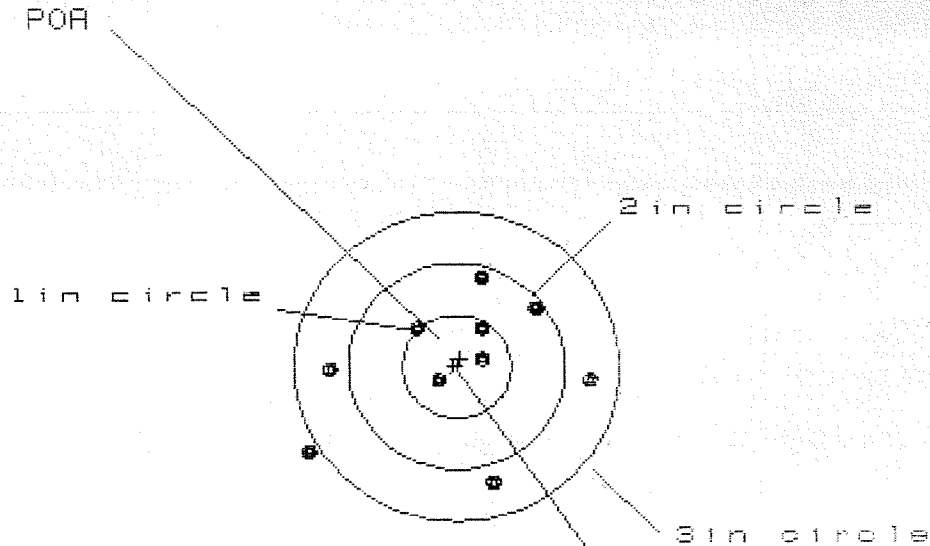
✱ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0452
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0368
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0582862
THE AMR FOR THIS RIFLE IS: .8076

8 Nov 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6523313

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 4

2 in = 6

3 in = 9

HS= 2.544

VS= 1.988

GS= 2.646

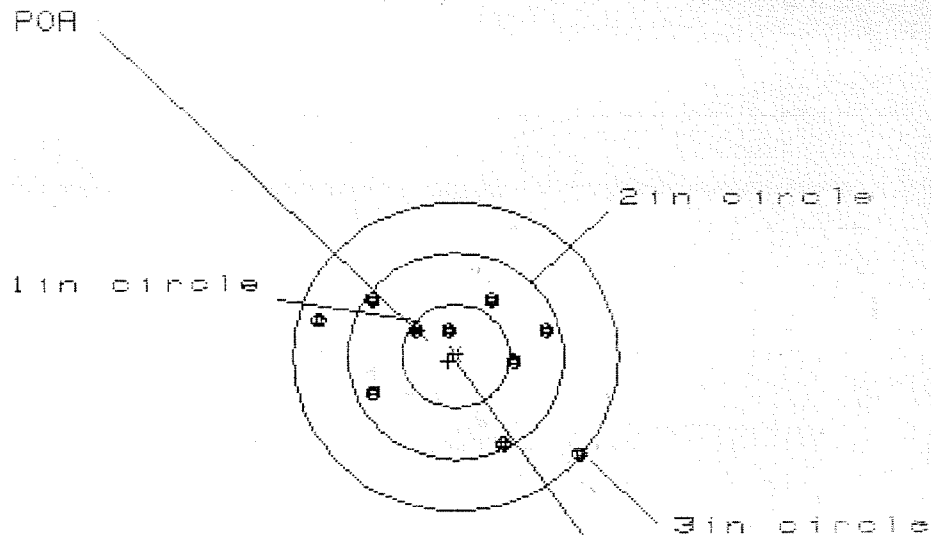
CENTROID #

PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.209	1.061	.708
MINIMUM X	:	-1.335	-1.291	-1.159
MAXIMUM Y	:	.883	.791	.768
MINIMUM Y	:	-1.105	-1.197	-1.220
CENTROID X	:	-.032	.116	-.016
CENTROID Y	:	-.074	.018	.041
POA TO CENTROID in.	:	.080	.118	.044
MIN RADIUS	:	.222	.082	.217
MEAN RADIUS	:	.827	.712	.666
MAX RADIUS	:	1.569	1.299	1.261
HORIZONTAL SPREAD	:	2.544	2.352	1.867
VERTICAL SPREAD	:	1.988	1.988	1.988
EXTREME SPREAD	:	2.646	2.353	1.990
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

8 Nov 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6523313

CENTERFIRE PATTERNS # 2



OF SHOTS - 10

IN CIR

1 in - 2

2 in - 8

3 in = 10

HS= 2.398

VS= 1.511

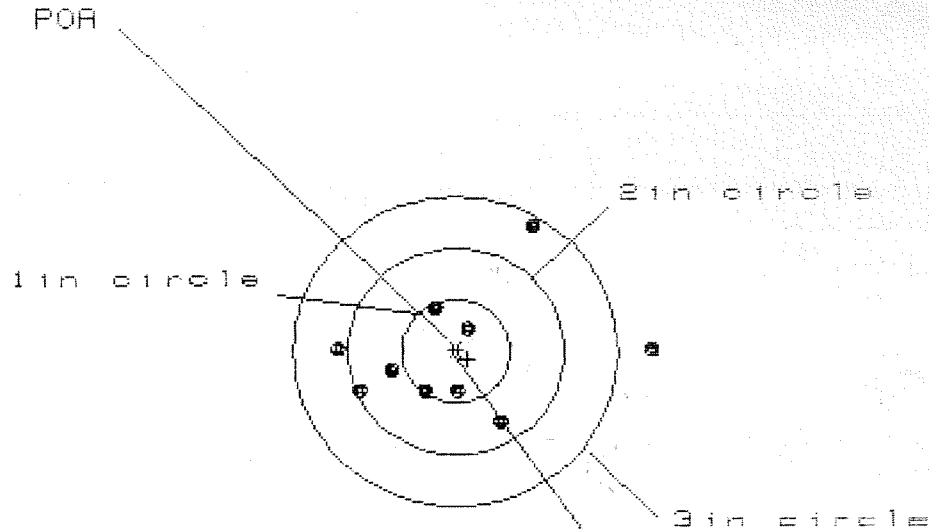
GS= 2.707

PATTERN #	2	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.151	.972	.832
MINIMUM X	-1.247	-1.119	-.782
MAXIMUM Y	.585	.482	.510
MINIMUM Y	-.926	-.925	-.897
CENTROID X	.067	-.061	.079
CENTROID Y	.048	.151	.123
POA TO CENTROID in.	.083	.163	.146
MIN RADIUS	.235	.129	.172
MEAN RADIUS	.822	.721	.668
MAX RADIUS	1.478	1.142	.976
HORIZONTAL SPREAD	2.398	2.091	1.614
VERTICAL SPREAD	1.511	1.407	1.407
EXTREME SPREAD	2.707	2.094	1.813
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	8		
NUMBER IN THREE INCH CIRCLE =	10		

8 Nov 1990

FILE:/PATTERNING/CENTERFIRE_PATT/C8523313

CENTERFIRE PATTERNS # 3



OF SHOTS - 10

IN CIR

1 in = 3

2 in = 6

3 in = 9

HS = 2.878

VS = 1.933

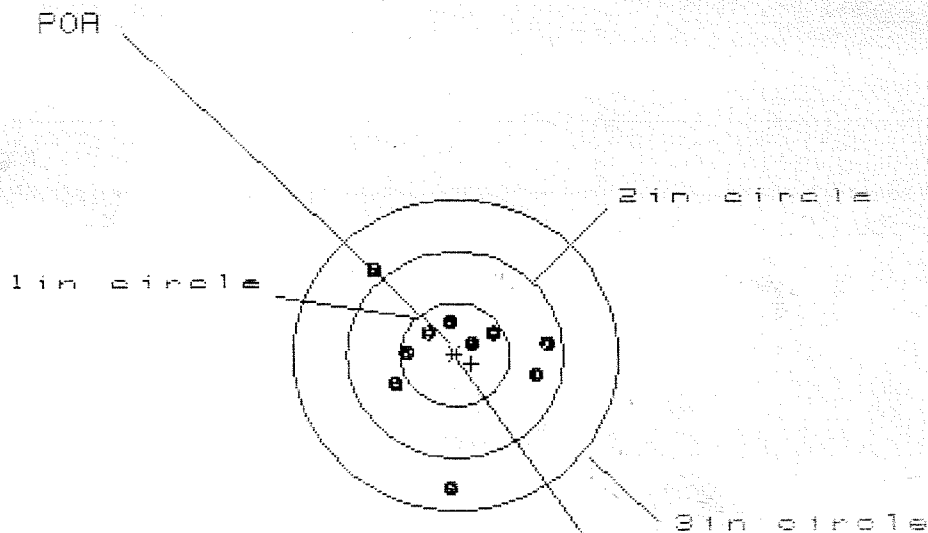
GS = 2.879

PATTERN #	3	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.829	.931	.773
MINIMUM X	-1.049	-.846	-.730
MAXIMUM Y	1.236	1.235	.623
MINIMUM Y	-.697	-.698	-.544
CENTROID X	-.110	-.313	-.429
CENTROID Y	.077	.078	-.076
POA TO CENTROID in.	.134	.322	.436
MIN RADIUS	.246	.369	.192
MEAN RADIUS	.836	.690	.545
MAX RADIUS	1.829	1.546	.945
HORIZONTAL SPREAD	2.878	1.777	1.503
VERTICAL SPREAD	1.933	1.933	1.167
EXTREME SPREAD	2.879	2.332	1.686
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	9		

8 Nov 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6523313

CENTERFIRE PATTERNS # 4



OF SHOTS - 10

IN CIR

1 in = 5

2 in = 8

3 in = 10

HS = 1.655

VS = 2.086

GS = 2.217

CENTROID *

PATTERN #	4
SHOTS (BEST OF)	10
MAXIMUM X	.868
MINIMUM X	-.787
MAXIMUM Y	.823
MINIMUM Y	-1.263
CENTROID X	-.147
CENTROID Y	.083
POA TO CENTROID in.	.169
MIN RADIUS	.184
MEAN RADIUS	.617
MAX RADIUS	1.264
HORIZONTAL SPREAD	1.655
VERTICAL SPREAD	2.086
EXTREME SPREAD	2.217
NUMBER IN ONE INCH CIRCLE =	5
NUMBER IN TWO INCH CIRCLE =	8
NUMBER IN THREE INCH CIRCLE =	10

8 Nov 1930

FILE:/PATTERNING/CENTERFIRE_PATT/C8523313

CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 0

2in = 5

3in = 10

HS= 2.448

VS= 1.297

GS= 2.452

CENTROID #

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	1.088
MINIMUM X	-1.368
MAXIMUM Y	.675
MINIMUM Y	-.622
CENTROID X	-.004
CENTROID Y	.050
POA TO CENTROID in.	.050
MIN RADIUS	.555
MEAN RADIUS	.936
MAX RADIUS	1.392
HORIZONTAL SPREAD	2.448
VERTICAL SPREAD	1.297
EXTREME SPREAD	2.452
NUMBER IN ONE INCH CIRCLE	= 0
NUMBER IN TWO INCH CIRCLE	= 5
NUMBER IN THREE INCH CIRCLE	= 10

INTERCHANGEABILITY

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6523313
12 Dec 1990

CENTROIDAL DISTANCES

0 TO	1	.194589
1 TO	2	.21346
1 TO	3	.286435
1 TO	4	.266101
1 TO	5	.397634

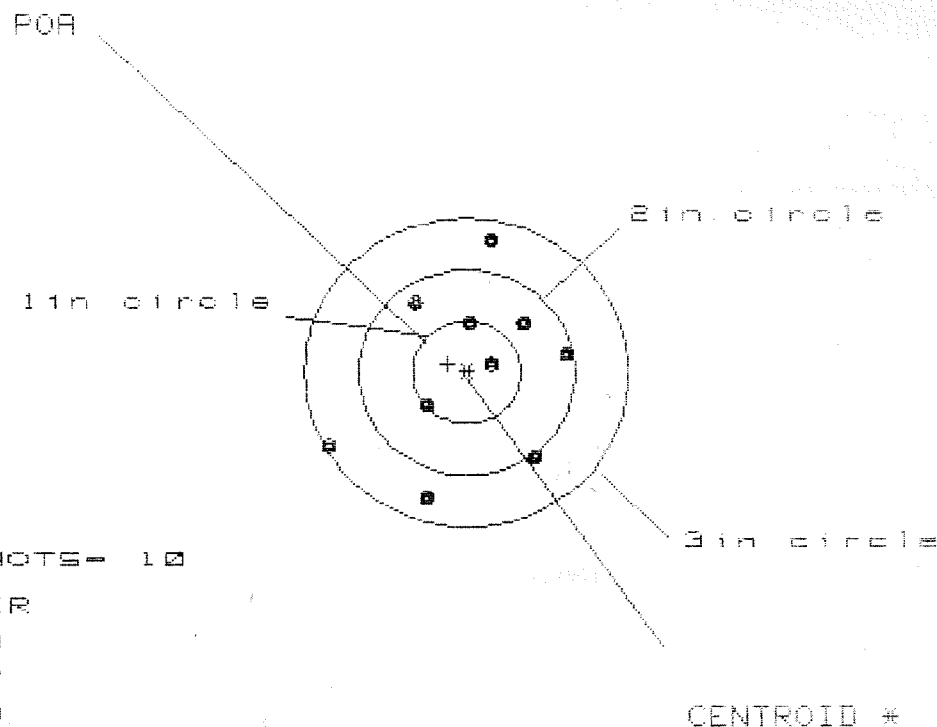
4 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0256
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1344
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .136816
THE AMR FOR THIS RIFLE IS: .8000

12 Dec 1998

FILE:/PATTERNING/CENTERFIRE_PATT/06523313

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 7

3 in = 9

HS= 2.218

VS= 2.542

GS= 2.629

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.894	.747	.679
MINIMUM X	:	-1.324	-.584	-.652
MAXIMUM Y	:	1.286	1.202	1.034
MINIMUM Y	:	-1.256	-1.340	-1.063
CENTROID X	:	.176	.323	.391
CENTROID Y	:	-.083	.001	.169
POA TO CENTROID in.	:	.194	.323	.426
MIN RADIUS	:	.262	.093	.133
MEAN RADIUS	:	.869	.758	.642
MAX RADIUS	:	1.524	1.448	1.123
HORIZONTAL SPREAD	:	2.218	1.331	1.331
VERTICAL SPREAD	:	2.542	2.542	2.097
EXTREME SPREAD	:	2.629	2.629	2.120
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

12 Dec 1980

FILE:/PATTERNING/CENTERFIRE_PATT/08523313

CENTERFIRE PATTERNS # 2

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 1

2in = 7

3in = 8

HS= 1.770

VS= 2.329

GS= 2.570

CENTROID #

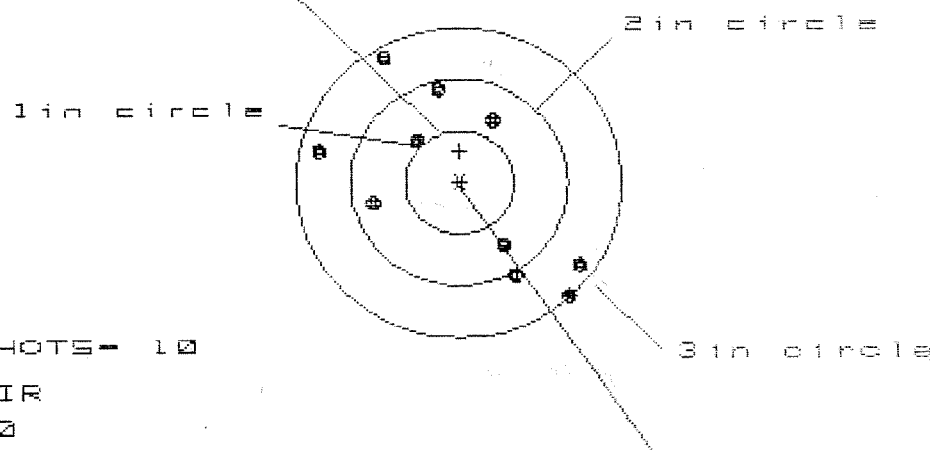
PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.013	1.095	.781
MINIMUM X	:	-.757	-.675	-.538
MAXIMUM Y	:	1.356	1.092	.990
MINIMUM Y	:	-.973	-.823	-.686
CENTROID X	:	-.026	-.108	-.245
CENTROID Y	:	-.152	-.302	-.200
POA TO CENTROID in.	:	.154	.321	.316
MIN RADIUS	:	.388	.298	.299
MEAN RADIUS	:	.863	.764	.673
MAX RADIUS	:	1.544	1.370	.990
HORIZONTAL SPREAD	:	1.770	1.770	1.319
VERTICAL SPREAD	:	2.329	1.915	1.676
EXTREME SPREAD	:	2.570	2.257	1.772
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

12 Dec 1990

FILE:/PATTERNING/CENTERFIRE_PATT/06523313

CENTERFIRE PATTERNS # 3

POA



OF SHOTS- 10

IN CIR

1 in = 0

2 in = 5

3 in = 10

HS= 2.381

VS= 2.245

GS= 2.813

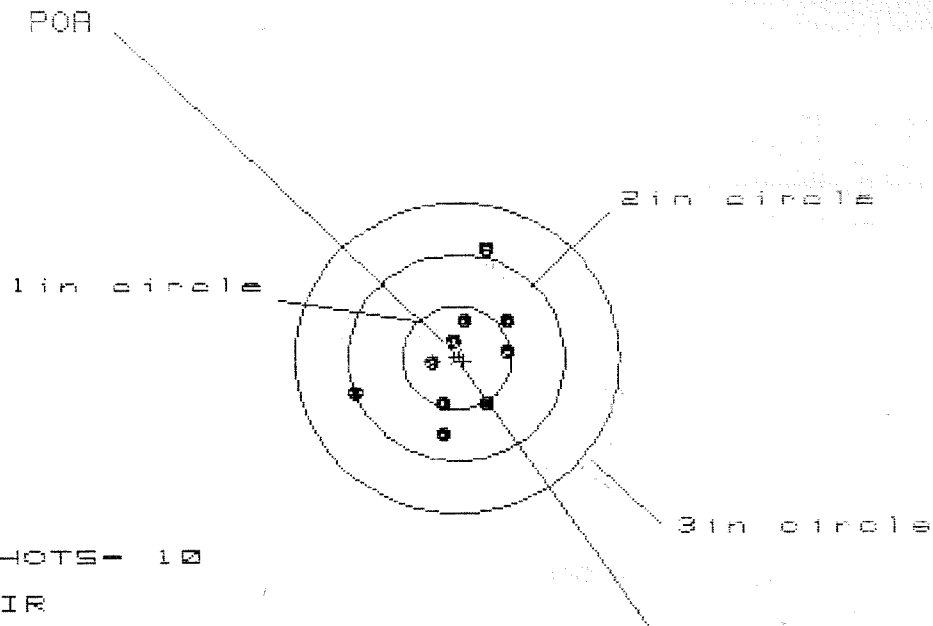
CENTROID *

PATTERN #	3	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.135	1.243	1.165
MINIMUM X	-1.246	-1.138	-1.216
MAXIMUM Y	1.173	1.054	.939
MINIMUM Y	-1.072	-.995	-.864
CENTROID X	-.005	-.112	-.034
CENTROID Y	-.305	-.186	-.317
POA TO CENTROID in.	.305	.217	.319
MIN RADIUS	.549	.389	.541
MEAN RADIUS	1.024	.953	.926
MAX RADIUS	1.442	1.521	1.383
HORIZONTAL SPREAD	2.381	2.381	2.381
VERTICAL SPREAD	2.245	2.049	1.803
EXTREME SPREAD	2.813	2.685	2.624
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	10		

12 Dec 1998

FILE:/PATTERNING/CENTERFIRE_PATT/08523313

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1 in = 5

2 in = 8

3 in = 10

HS= 1.437

VS= 1.823

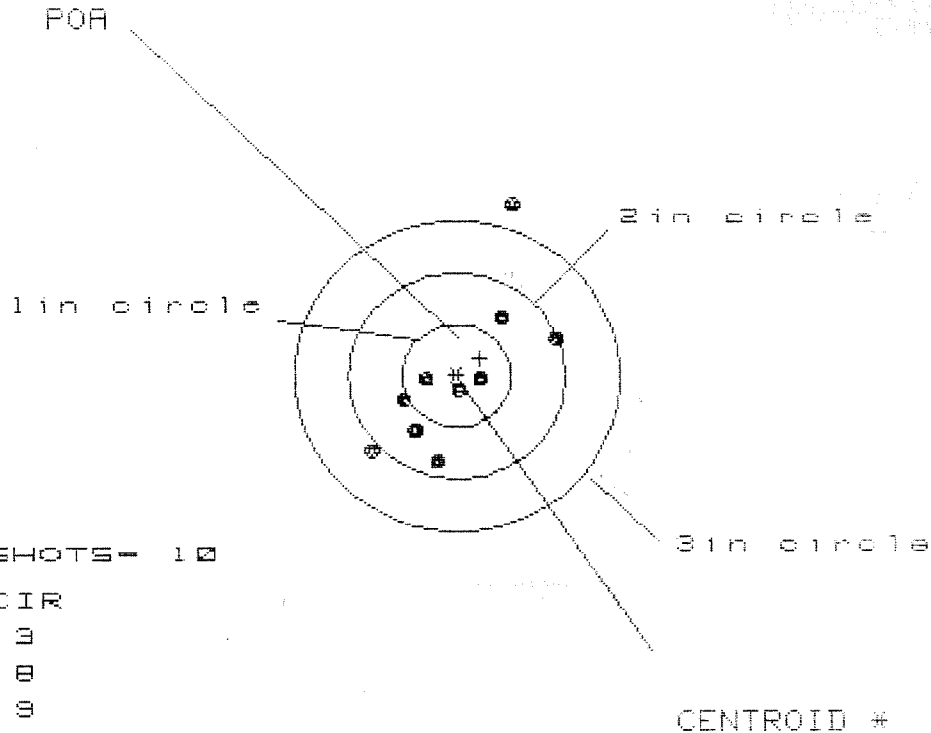
GS= 1.879

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.485	.515	.400
MINIMUM X	:	-.952	-.922	-.346
MAXIMUM Y	:	1.047	.505	.476
MINIMUM Y	:	-.776	-.660	-.689
CENTROID X	:	-.061	-.091	.024
CENTROID Y	:	.038	-.078	-.049
POA TO CENTROID in.	:	.072	.120	.055
MIN RADIUS	:	.154	.259	.260
MEAN RADIUS	:	.575	.520	.458
MAX RADIUS	:	1.081	.951	.741
HORIZONTAL SPREAD	:	1.437	1.437	.746
VERTICAL SPREAD	:	1.823	1.165	1.165
EXTREME SPREAD	:	1.879	1.562	1.282
NUMBER IN ONE INCH CIRCLE	=		5	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	

12 Dec 1998

FILE:/PATTERNING/CENTERFIRE_PATT/08523313

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 8

3 in = 9

HS= 1.623

VS= 2.485

GS= 2.670

CENTROID #

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	.876
MINIMUM X	-.747
MAXIMUM Y	1.635
MINIMUM Y	-.850
CENTROID X	-.212
CENTROID Y	-.170
POA TO CENTROID in.	.272
MIN RADIUS	.133
MEAN RADIUS	.713
MAX RADIUS	1.720
HORIZONTAL SPREAD	1.623
VERTICAL SPREAD	2.485
EXTREME SPREAD	2.670
NUMBER IN ONE INCH CIRCLE =	3
NUMBER IN TWO INCH CIRCLE =	8
NUMBER IN THREE INCH CIRCLE =	9

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. 06523313

DATE 11-6-90

TESTER JL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.31	2.45	2.22	224	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.29	2.14	2.32	227	
PULL #3	2.32	2.15	2.13	229	
PULL #4	2.32	2.18	2.15	224	
PULL #5	2.29	2.20	2.18	224	
TOTAL	11.53	11.12	11.00		
AVG.	2.306	2.224	2.2		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.17	3.33		
PULL #2	3.17	3.34		
PULL #3	3.23	3.30		
PULL #4	3.32	3.34		
PULL #5	3.36	3.14		
TOTAL	16.25	16.45		
AVG.	3.25	3.29		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.27	4.20		4.28
PULL #2	4.24	4.25		4.27
PULL #3	4.28	4.25		4.25
PULL #4	4.26	4.26		4.27
PULL #5	4.27	4.28		4.29
TOTAL	21.32	21.24		21.36
AVG.	4.264	4.248		4.272

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6523313

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	10 3 90		RW
600	Proof	10 3 90		RW
607	Check Headspace	10 3 90		RW
610	Dis-assemble Gun	10 3 90		RW
612	Magnaflux Barrel Action		10/11/90	KR
	Magnaflux Bolt		10/11/90	KR
615	Rollmark Caliber		10/11/90	LS
617	Drill and Tap Sight Holes		10/11/90	LB
618	Polish Barrel RB		10/12/90	WB
620	Apply Coatings (Barrel Action)		10-12-90	TS
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		10/22/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/22/90	RW
	C) Inspect Ejector Hole for Chamfer		10/22/90	RW
	D) Oil Firing Pin Ass'y		10/22/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		11-6-90	JS

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4 1/2	4 1/2	4 1/2			11/6/90	WB
	G) Safety Off Force	2 1/2	2 1/2	2 1/2			11/6/90	WB
	H) Trigger Pull Test & Retainability						11/4/90	JF
	I) Firing Pin Indent	10215	1021	1021			11/6/90	WB
	J) Assemble Stock						11/6/90	RW
	K) Assemble Swivel Studs						11/19/90	JS
	L) Attach Front and Rear Sight Assemblies						11/6/90	RW
	M) Iron Sight Alignment						11/6/90	RW
	N) Detach Front & Rear Sights & place in numbered container						11/6/90	RW
	O) Attach Scope to Rifle						11/6/90	RW
	P) Detach & Attach Scope 20 Times						11/6/90	RW
640	Gallery Target & Test						11/7/90	NF
	A) Time						"	NF
	B) Malfunctions						"	NF
	C) Pierced Primers						"	NF
	D) Optical Clarity of Scope						"	NF
645	Inspect for Live Ammo						11/7/90	NF
655	Final Inspection							
	A) Headspace						11/19/90	JS
	B) Trigger Pull	224	227	229	226	224	11/19/90	JS
	C) Function						11/19/90	JS
660	Pack						12/19/90	NF



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

MODEL 700TM H24

01

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

SERIAL NO.
C6523313

ORDER NO.
5716



5716 C6523313



AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C6523313

DATE 4-19-96

TESTER DA

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.80	2.48	2.56		MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.78	2.63	2.84		
PULL #3	2.38	2.62	2.90		
PULL #4	2.86	2.35	2.81		
PULL #5	2.67	2.45	2.75		
TOTAL	1349	1253	1386		
AVG.	2.69	2.50	2.77		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.22	3.28		
PULL #2	3.09	3.31		
PULL #3	3.18	3.18		
PULL #4	3.05	3.25		
PULL #5	3.11	3.12		
TOTAL	1565	1614		
AVG.	3.13	3.22		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.17	4.29		4.08
PULL #2	4.14	4.33		4.01
PULL #3	3.96	4.31		4.06
PULL #4	4.22	4.40		3.92
PULL #5	4.04	4.12		3.95
TOTAL	2053	2145		2002
AVG.	4.10	4.29		4.00

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6523313
5 Mar 1988

CENTROIDAL DISTANCES

0 TO	1	.921692
1 TO	2	.611385
1 TO	3	.573328
1 TO	4	.457962
1 TO	5	.773644

1
F¹ <----POA

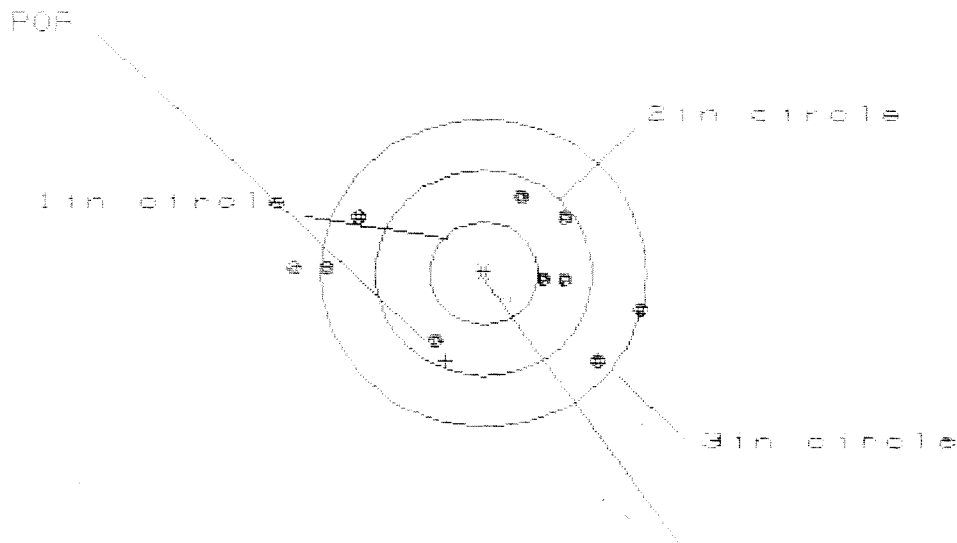
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .2736
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .4064
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .489916

THE AMR FOR THIS RIFLE IS: .9876

5 Mar 1988

FILE: \PATTERNING\CENTERFIRE_PATT\08523313

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 0

2 in = 5

3 in = 0

HS= 3.231

VS= 1.534

GS= 3.263

CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.461	1.264	.977
MINIMUM X	-1.770	-1.638	-1.480
MAXIMUM Y	.713	.724	.680
MINIMUM Y	-.821	-.810	-.854
CENTROID X	.354	.551	.393
CENTROID Y	.851	.840	.884
POA TO CENTROID in.	.922	1.005	.967
MIN RADIUS	.542	.345	.505
MEAN RADIUS	1.113	.993	.973
MAX RADIUS	1.770	1.638	1.480
HORIZONTAL SPREAD	3.231	2.902	2.457
VERTICAL SPREAD	1.534	1.534	1.534
EXTREME SPREAD	3.263	2.926	2.596
NUMBER IN ONE INCH CIRCLE	=	0	
NUMBER IN TWO INCH CIRCLE	=	5	
NUMBER IN THREE INCH CIRCLE	=	8	

5 Mar 1988

FILE://PATTERNING/CENTERFIRE_PATT/C6523313

CENTERFIRE PATTERNS # 2

POR

1in circle

2in circle

3in circle

OF SHOTS = 10

IN CIR

1in = 1

2in = 4

3in = 8

HO = 0.0000

VS = 1.886

GS = 0.970

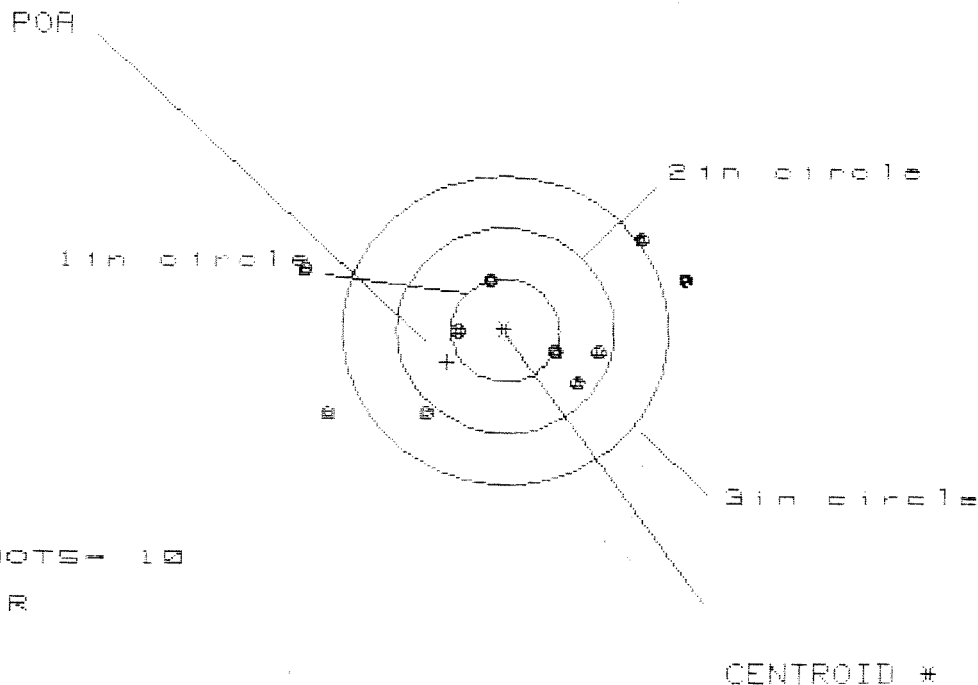
CENTROID #

PATTERN #	2
SHOTS (BEST OF)	10
MAXIMUM X	1.406
MINIMUM X	-1.514
MAXIMUM Y	.813
MINIMUM Y	-1.083
CENTROID X	.118
CENTROID Y	.287
POR TO CENTROID in.	.310
MIN RADIUS	.497
MEAN RADIUS	1.060
MAX RADIUS	1.516
HORIZONTAL SPREAD	2.920
VERTICAL SPREAD	1.896
EXTREME SPREAD	2.970
NUMBER IN ONE INCH CIRCLE	1
NUMBER IN TWO INCH CIRCLE	4
NUMBER IN THREE INCH CIRCLE	8

5 Mar 1968

FILE:/PATTERNING/CENTERFIRE_PATT/08523313

CENTERFIRE PATTERNS # 3



OF SHOTS - 10

IN CIR

1 in = 2

2 in = 5

3 in = 6

HS = 3.456

VS = 1.735

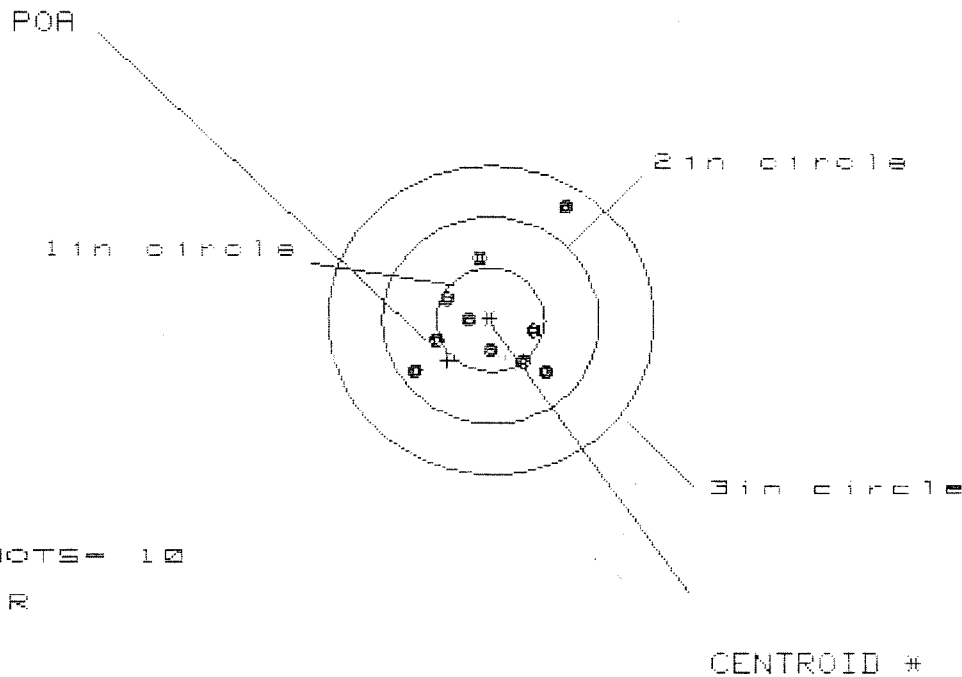
GS = 3.559

PATTERN #	3	3	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.641	1.439	1.205
MINIMUM X	-1.815	-1.873	-1.150
MAXIMUM Y	.915	.978	.886
MINIMUM Y	-.820	-.757	-.849
CENTROID X	.538	.740	.974
CENTROID Y	.308	.245	.337
POA TO CENTROID in.	.620	.780	1.031
MIN RADIUS	.424	.251	.215
MEAN RADIUS	1.122	1.002	.850
MAX RADIUS	1.902	2.014	1.430
HORIZONTAL SPREAD	3.456	3.312	2.355
VERTICAL SPREAD	1.735	1.735	1.735
EXTREME SPREAD	3.559	3.559	2.699
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	6		

5 Mar 1968

FILE:/PATTERNING/CENTERFIRE_PAT/06523313

CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1 in = 4

2 in = 9

3 in = 10

HS= 1.440

VS= 1.611

GS= 2.142

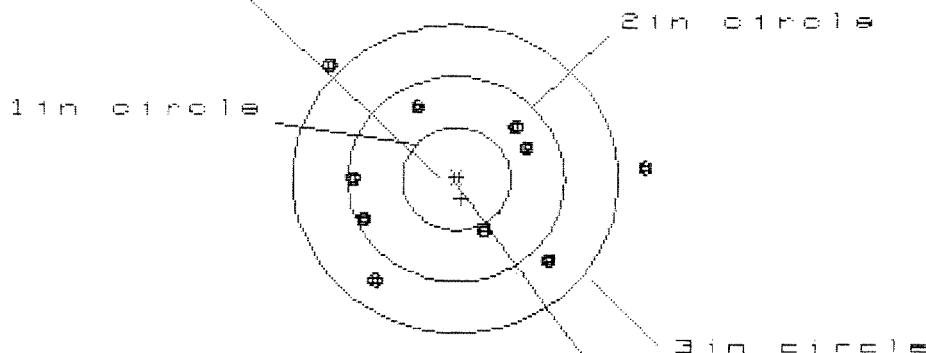
PATTERN #	:	4	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.706	.596	.514
MINIMUM X	:	-.734	-.655	-.510
MAXIMUM Y	:	1.140	.753	.713
MINIMUM Y	:	-.471	-.344	-.384
CENTROID X	:	.406	.327	.409
CENTROID Y	:	.396	.269	.309
POA TO CENTROID in.	:	.567	.424	.513
MIN RADIUS	:	.237	.175	.192
MEAN RADIUS	:	.599	.489	.459
MAX RADIUS	:	1.341	.753	.716
HORIZONTAL SPREAD	:	1.440	1.251	1.024
VERTICAL SPREAD	:	1.611	1.097	1.097
EXTREME SPREAD	:	2.142	1.264	1.241
NUMBER IN ONE INCH CIRCLE	=	4		
NUMBER IN TWO INCH CIRCLE	=	9		
NUMBER IN THREE INCH CIRCLE	=	10		

5 Mar 1900

FILE:/PATTERNING/CENTERFIRE_PATT/C6523313

CENTERFIRE PATTERNS # 5

POA



OF SHOTS- 10

IN CIR

1 in = 0

2 in = 6

3 in = 8

HS= 2.897

VS= 2.050

GS= 3.053

CENTROID *

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.777	1.014	.899
MINIMUM X	-1.120	-.923	-.858
MAXIMUM Y	1.066	1.077	.888
MINIMUM Y	-.984	-.973	-.838
CENTROID X	-.048	-.245	-.130
CENTROID Y	.190	.179	.044
POA TO CENTROID in.	.196	.303	.137
MIN RADIUS	.573	.665	.488
MEAN RADIUS	1.044	.951	.880
MAX RADIUS	1.780	1.418	1.118
HORIZONTAL SPREAD	2.897	1.937	1.757
VERTICAL SPREAD	2.050	2.050	1.726
EXTREME SPREAD	3.053	2.697	2.011
NUMBER IN ONE INCH CIRCLE =		0	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		8	

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # *C6573313*

OP. #	OP. NAME	READINGS	DATE	INITIAL
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			

op. #	BARBER - M24 0089837 OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	7	7	7			5/14/96	RW
	G) Safety Off Force	3	3	3			5/14/96	RW
	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							
	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	2.64	2.49	2.66	2.62	2.66	5/14/96	RW
	C) Function							
660	Pack							

Repair Inquiry

Repair Number: RE00113113

Serial: C6523313 Model M24 SWS Center Fire
Caliber: 7.62 NATO

Repairman:

Verify Repair

Status:

New 6/1/2006 11:09:30 AM

Address Information

Customer:

Received From

Return To:

Received From

Name: TRANSPORTATION OFFICER

TRANSPORTATION OFFICER

Address 1: USPFO FOR ARKANSAS BLDG 318

USPFO FOR ARKANSAS BLDG 318

Address 2: CAMP JOSEPH T ROBINSON

PO Box:

CAMP JOSEPH T ROBINSON

PO Box:

City: NORTH LITTLE ROCK

NORTH LITTLE ROCK

State: AR

Zip Code: 72199

Country: US

State: AR

Zip Code: 72199

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
A017	Scope Base	1
A057	Fit and Rear Sgt Base	1

Repair Search

nagletj

6/1/2006

3:10 PM

CAPS

NUM

Refresh

Close

SCRL

G 6535223

Serial Number: **C6523313**
 Model: **M24 SWS**

RE00113113

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6535223.___0
FILE DATE AND TIME: 06/20/2006 16:28

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.044
The Average Y Centroid of the Five Target Set:	0.115
The Average Point of Impact of the Five Target Set:	0.123
The Average Mean Radius of the Five Target Set:	0.940
The Distance from POA to Centroid Target #1:	0.030
The Distance from Centroid Target #2 to Centroid Target #1:	0.199
The Distance from Centroid Target #3 to Centroid Target #1:	0.201
The Distance from Centroid Target #4 to Centroid Target #1:	0.293
The Distance from Centroid Target #5 to Centroid Target #1:	0.211

SERIAL NUMBER: G6535223. __0

TARGET NUMBER: 1

FILE DATE: 06/20/2006

FILE TIME: 16:28

X CENTROID: 0.000

Y CENTROID: 0.030

POA TO CENTROID: 0.030

HORZ SPREAD: 2.220

VERT SPREAD: 2.150

GROUP SPREAD: 2.660

MIN RADIUS: 0.325

MAX RADIUS: 1.644

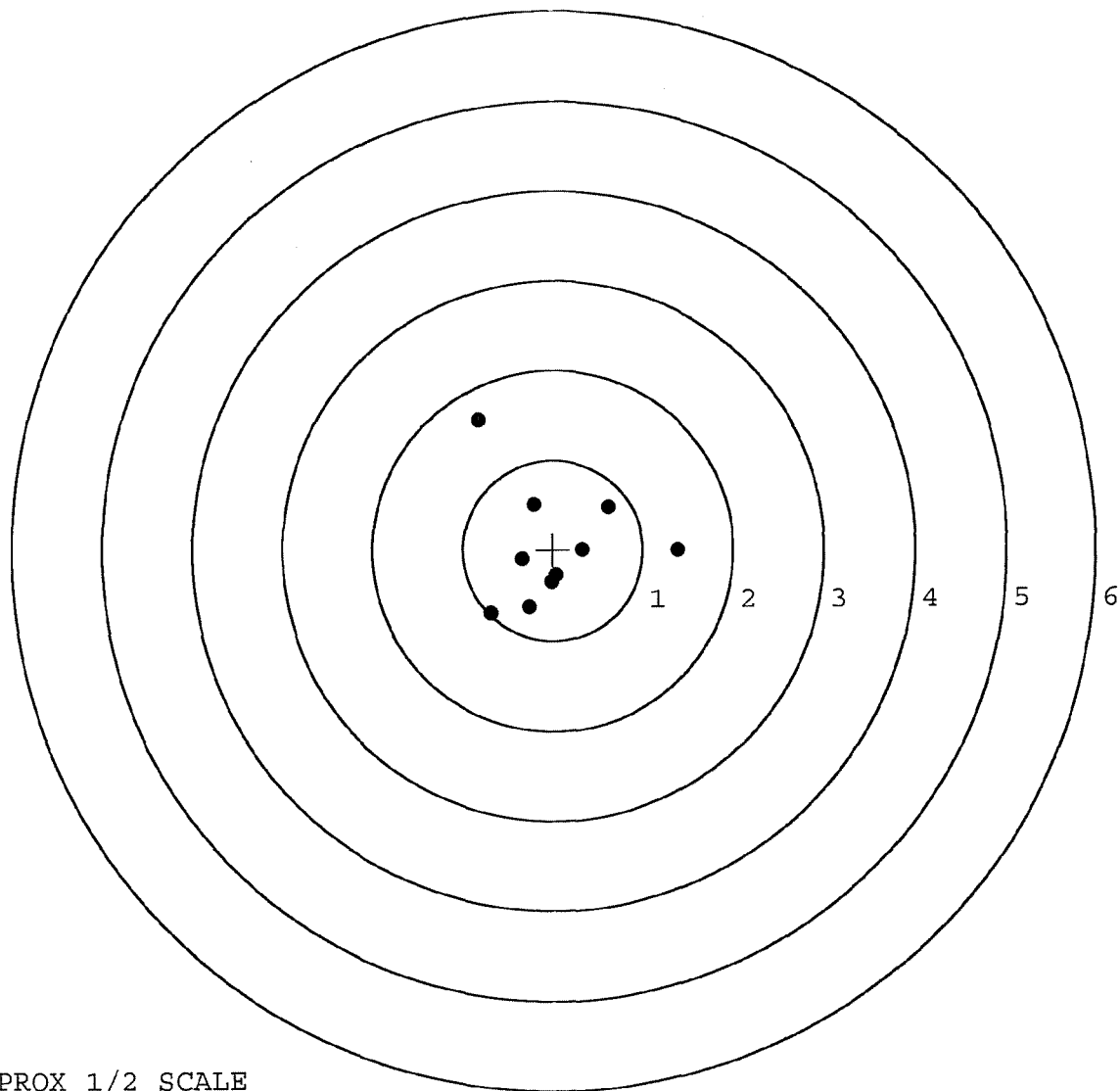
MEAN RADIUS: 0.747

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 9

POINT#	X	Y
1:	-0.695	-0.701
2:	-0.273	-0.640
3:	0.040	-0.293
4:	-0.343	-0.110
5:	0.327	-0.005
6:	1.390	-0.017
7:	0.615	0.476
8:	-0.216	0.505
9:	-0.830	1.449
10:	-0.016	-0.364



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6535223. 0

TARGET NUMBER: 2

FILE DATE: 06/20/2006

FILE TIME: 16:28

X CENTROID: 0.017

Y CENTROID: -0.168

POA TO CENTROID: 0.169

HORZ SPREAD: 1.605

VERT SPREAD: 2.566

GROUP SPREAD: 2.566

MIN RADIUS: 0.304

MAX RADIUS: 1.810

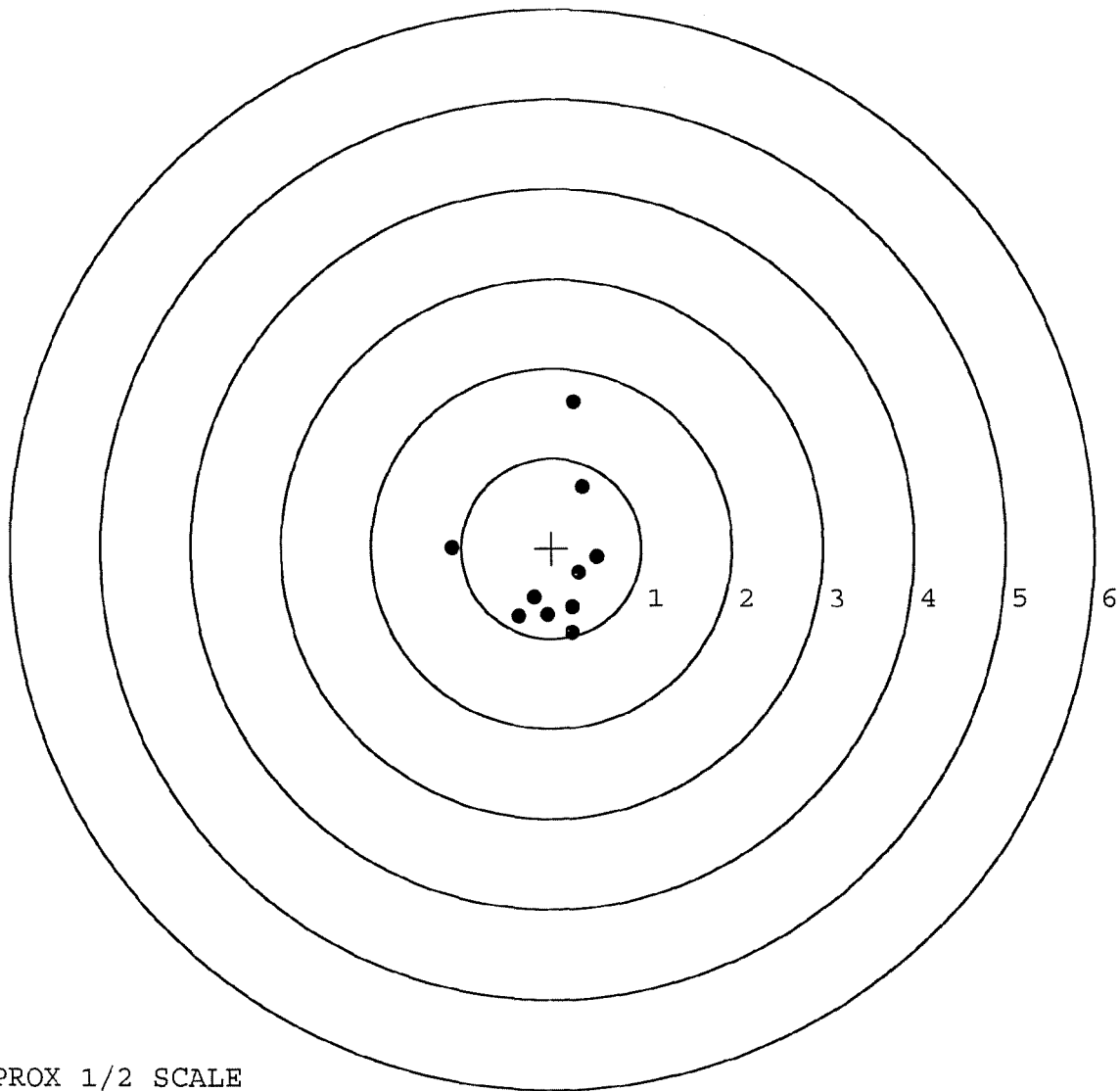
MEAN RADIUS: 0.769

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 9

POINT#	X	Y
1:	0.240	1.628
2:	0.346	0.686
3:	0.503	-0.095
4:	0.302	-0.273
5:	-1.102	0.004
6:	0.239	-0.647
7:	-0.192	-0.547
8:	-0.362	-0.758
9:	0.234	-0.938
10:	-0.041	-0.744



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6535223. 0

TARGET NUMBER: 3

FILE DATE: 06/20/2006

FILE TIME: 16:28

X CENTROID: 0.021

Y CENTROID: 0.230

POA TO CENTROID: 0.231

HORZ SPREAD: 1.689

VERT SPREAD: 2.061

GROUP SPREAD: 2.306

MIN RADIUS: 0.350

MAX RADIUS: 1.416

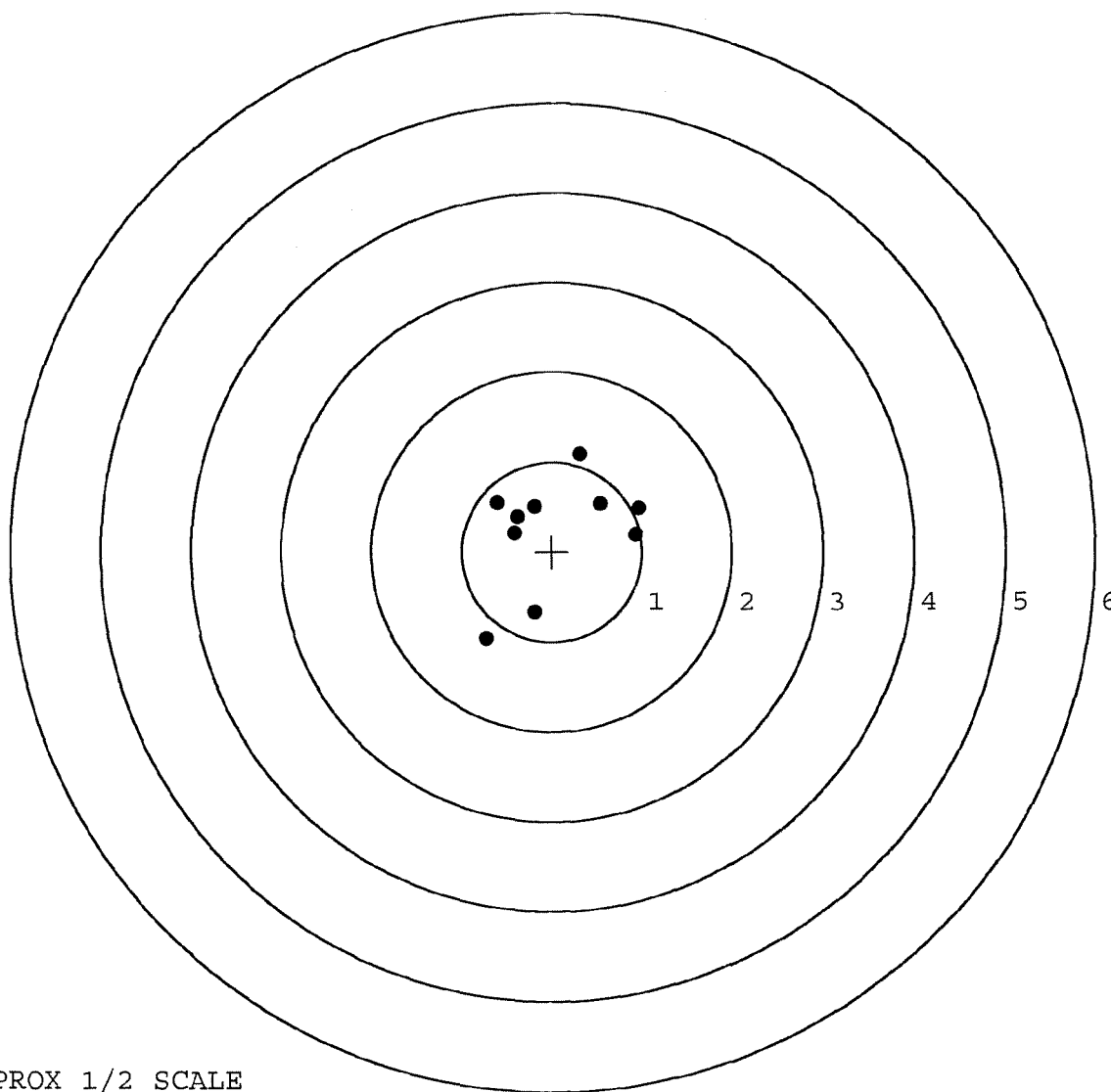
MEAN RADIUS: 0.767

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.725	-0.973
2:	-0.191	-0.675
3:	-0.414	0.202
4:	-0.199	0.502
5:	-0.610	0.545
6:	0.310	1.088
7:	0.536	0.535
8:	0.964	0.488
9:	0.929	0.194
10:	-0.388	0.393



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6535223. 0

TARGET NUMBER: 4

FILE DATE: 06/20/2006

FILE TIME: 16:28

X CENTROID: -0.188

Y CENTROID: 0.254

POA TO CENTROID: 0.317

HORZ SPREAD: 1.576

VERT SPREAD: 4.006

GROUP SPREAD: 4.081

MIN RADIUS: 0.511

MAX RADIUS: 2.546

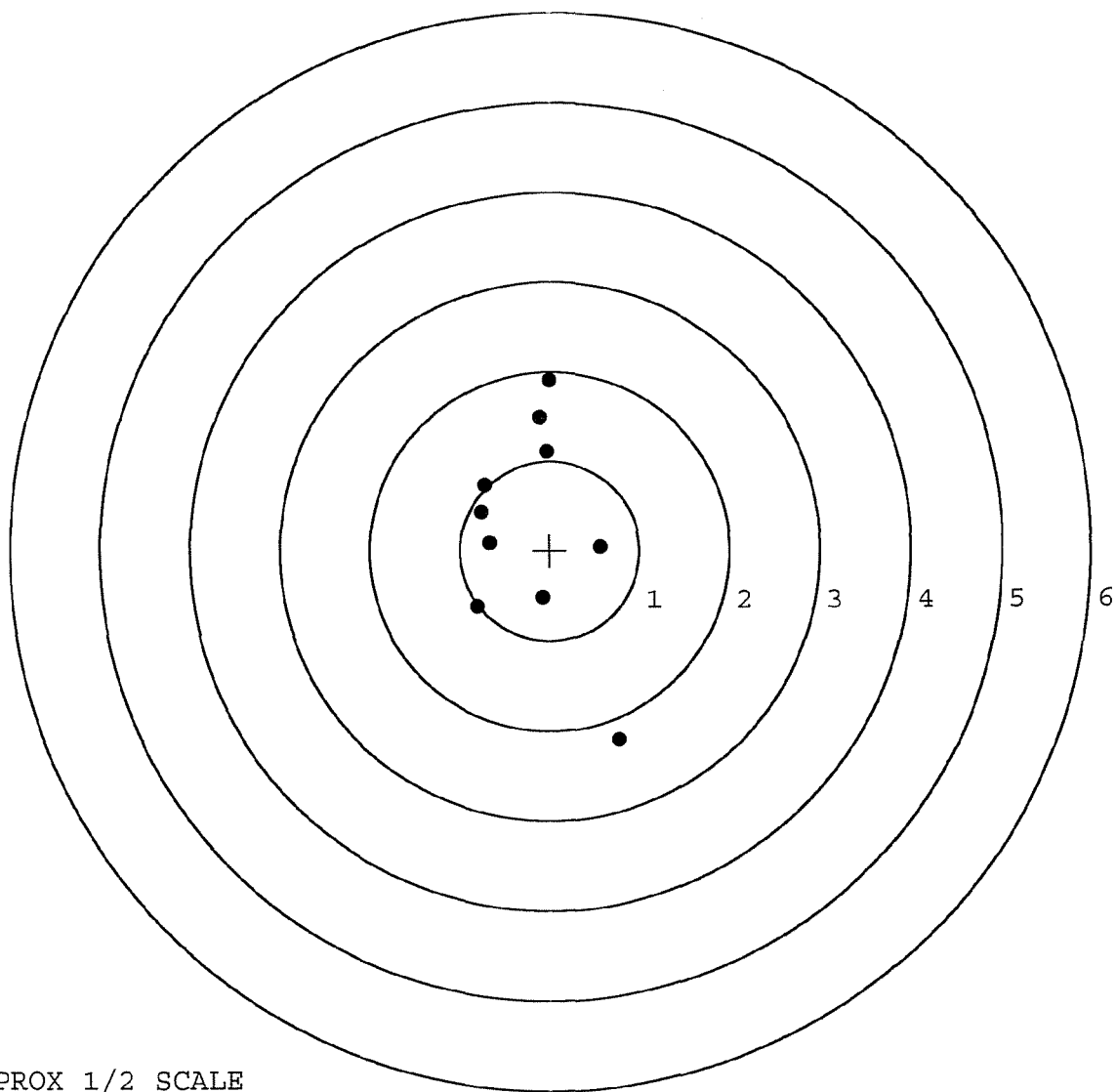
MEAN RADIUS: 1.078

IN 1 IN DIAMETER: 0

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 8

POINT#	X	Y
1:	0.769	-2.105
2:	-0.807	-0.624
3:	-0.086	-0.528
4:	0.564	0.041
5:	-0.673	0.093
6:	-0.763	0.437
7:	-0.725	0.734
8:	-0.037	1.103
9:	-0.116	1.493
10:	-0.009	1.901



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6535223. __0

TARGET NUMBER: 5

FILE DATE: 06/20/2006

FILE TIME: 16:28

X CENTROID: -0.068

Y CENTROID: 0.230

POA TO CENTROID: 0.240

HORZ SPREAD: 2.588

VERT SPREAD: 4.767

GROUP SPREAD: 4.777

MIN RADIUS: 0.504

MAX RADIUS: 2.813

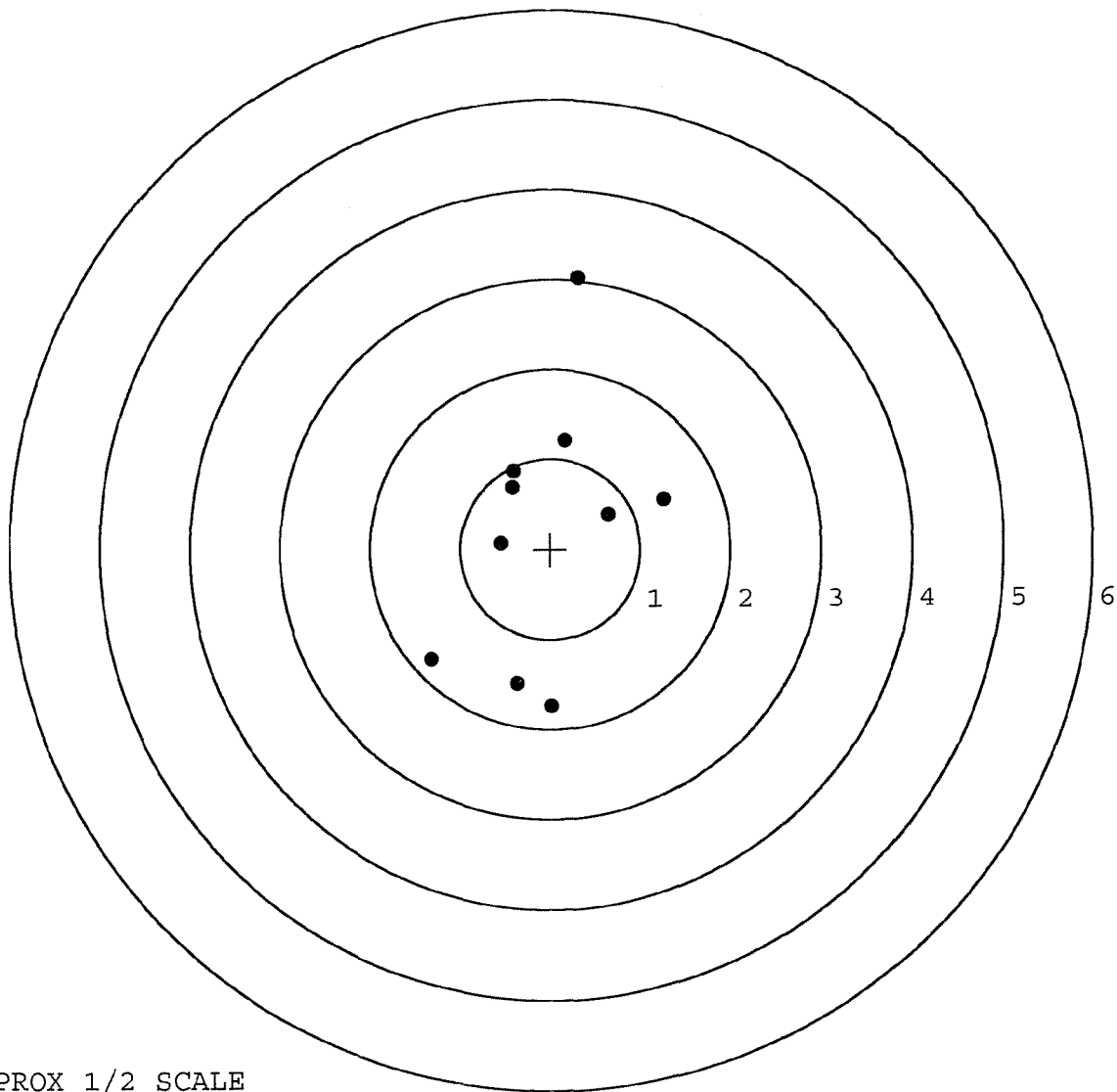
MEAN RADIUS: 1.337

IN 1 IN DIAMETER: 0

IN 2 IN DIAMETER: 4

in 3 IN DIAMETER: 6

POINT#	X	Y
1:	0.009	-1.751
2:	-0.375	-1.497
3:	-1.326	-1.222
4:	1.262	0.545
5:	0.643	0.386
6:	-0.547	0.071
7:	-0.423	0.681
8:	0.168	1.206
9:	0.318	3.016
10:	-0.411	0.863



TARGET APPROX 1/2 SCALE

50110

R & E NUMBER	00113113		Marksmanship Training Center	
SERIAL NUMBER	C 6523313		G 6535223	
LOG-IN DATE	6-1-06			
OPERATION #	OPERATION NAME		DATE	INITIAL
500	DIS-ASSEMBLE GUN		6-5-06	AC
505	RE-BARREL		6-6-06	AC
560	ASSEMBLE		6-6-06	AC
600	PROOF	MAGNA-FLUX INSPECTED JUN 03 2006	6-7-06	R.P.
605	CHECK HEADSPACE		6-7-06	R.P.
610	DIS-ASSEMBLE GUN		6-7-06	AC
612	MAGNAFLUX	OPERATOR <u>APD</u>	6-9-06	APD
510	DRILL AND TAP		6-8-06	TRW
615	ROLLMARK CALIBER		6-9-06	CW
618	ROTO-BLAST		6-9-06	LB
620	APPLY COATINGS		6-13-06	FB
625	FINAL ASSEMBLY		6-19-06	L.P.D.
640	FUNCTION TEST AND	PASS FAIL	6-20-06	MTM
650	TARGET	PASS FAIL	6-20-06	MTM
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION N/A		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
670	FINAL INSPECTION		6-24-06	MTM
	A) HEADSPACE	PASS FAIL	6-24-06	MTM
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS		
680	F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX	10 lbs 10 lbs 10 lbs 6-24-06	MTM
	G) SAFETY OFF FORCE	2 LBS MIN	5 lbs 5 lbs 5 lbs 6-24-06	MTM
	I) FIRING PIN INDENT	.020	.020 .021 .021 6-24-06	MTM
690	PACK		7-5-06	RA