

G6285915
Replac
C-6348830

Remington®		VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.	
M/24 7.62 NATO (RIFLE ONLY) BOLT ACTION CENTERFIRE RIFLE 24" BARREL 7.62 NATO		SERIAL NO. J G6285915	
Made in Ilion, NY Reg. U.S. Pat & tm. Off. Marca Registrada Marque Deposee.		46 ORDER NO. 25732	
			26PX
5732 G6285915			

M/24 7.62 NATO (RIFLE ONLY)
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO

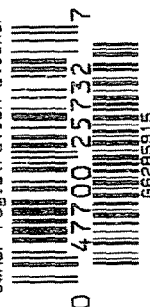
- INSTRUCTION BOOK 3518

46 FORM 200348

proof of purchase



owner registration sticker



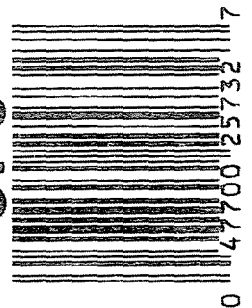
ORDER NO. 25732

BARREL LENGTH 24"

CAPACITY 5

G6285915

UPC



Repair Inquiry

Repair Number: RE00133011

Serial: C6285915 Model M24 SWS Center Fire
Caliber: 7.62 NATO Produced: 08/12/1988

Repairman:

Verify Repair

High Priority

Status:

Closed 8/21/2007 11:40:01 AM

Address Information

Customer:

Received From

Return To:

Received From

Name: CTRP 2/101 CAV

CTRP 2/101 CAV

Address 1: 27 MASTEN AVE

27 MASTEN AVE

Address 2: PO Box:

PO Box:

City: BUFFALO

BUFFALO

State: NY

Zip Code: 14204

Country: US

State: NY

Zip Code: 14204

Country: US

FFL:

Contact / Condition

Problems

Estimate

History / Status

Shipping / Billing

Contact Information

Phone: NN

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
A026	Scope	1
A057	Fit and Rear Sgt Base	1
D000	SCOPE CASE	1

Repair Search

Refresh

Close

naglelj

8/22/2007

7:52 AM

CAPS

NUM

INS

SCRL



Inbox - Micr...

Calendar - M...

FW: Restrict...

Arms Service...

7:52 AM

Deployment Kit

Serial Number: G6285915

Model: M24 SWS



RE00133011

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6285915.__0
FILE DATE AND TIME: 09/07/2007 11:18

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.062
The Average Y Centroid of the Five Target Set:	-0.035
The Average Point of Impact of the Five Target Set:	0.071
The Average Mean Radius of the Five Target Set:	0.623
The Distance from POA to Centroid Target #1:	0.185
The Distance from Centroid Target #2 to Centroid Target #1:	0.263
The Distance from Centroid Target #3 to Centroid Target #1:	0.491
The Distance from Centroid Target #4 to Centroid Target #1:	0.068
The Distance from Centroid Target #5 to Centroid Target #1:	0.420

BARBER - M24 0156495

SERIAL NUMBER: G6285915. __ 0

TARGET NUMBER: 1

FILE DATE: 09/07/2007

FILE TIME: 11:18

POINT#	X	Y
1:	0.663	0.577
2:	-0.224	0.724
3:	-0.736	-0.064
4:	-0.517	-0.101
5:	-0.292	0.193
6:	0.087	0.107
7:	0.488	-0.062
8:	0.614	-0.167
9:	0.663	0.104
10:	0.166	0.297

X CENTROID: 0.091

Y CENTROID: 0.161

POA TO CENTROID: 0.185

HORZ SPREAD: 1.399

VERT SPREAD: 0.891

GROUP SPREAD: 1.539

MIN RADIUS: 0.054

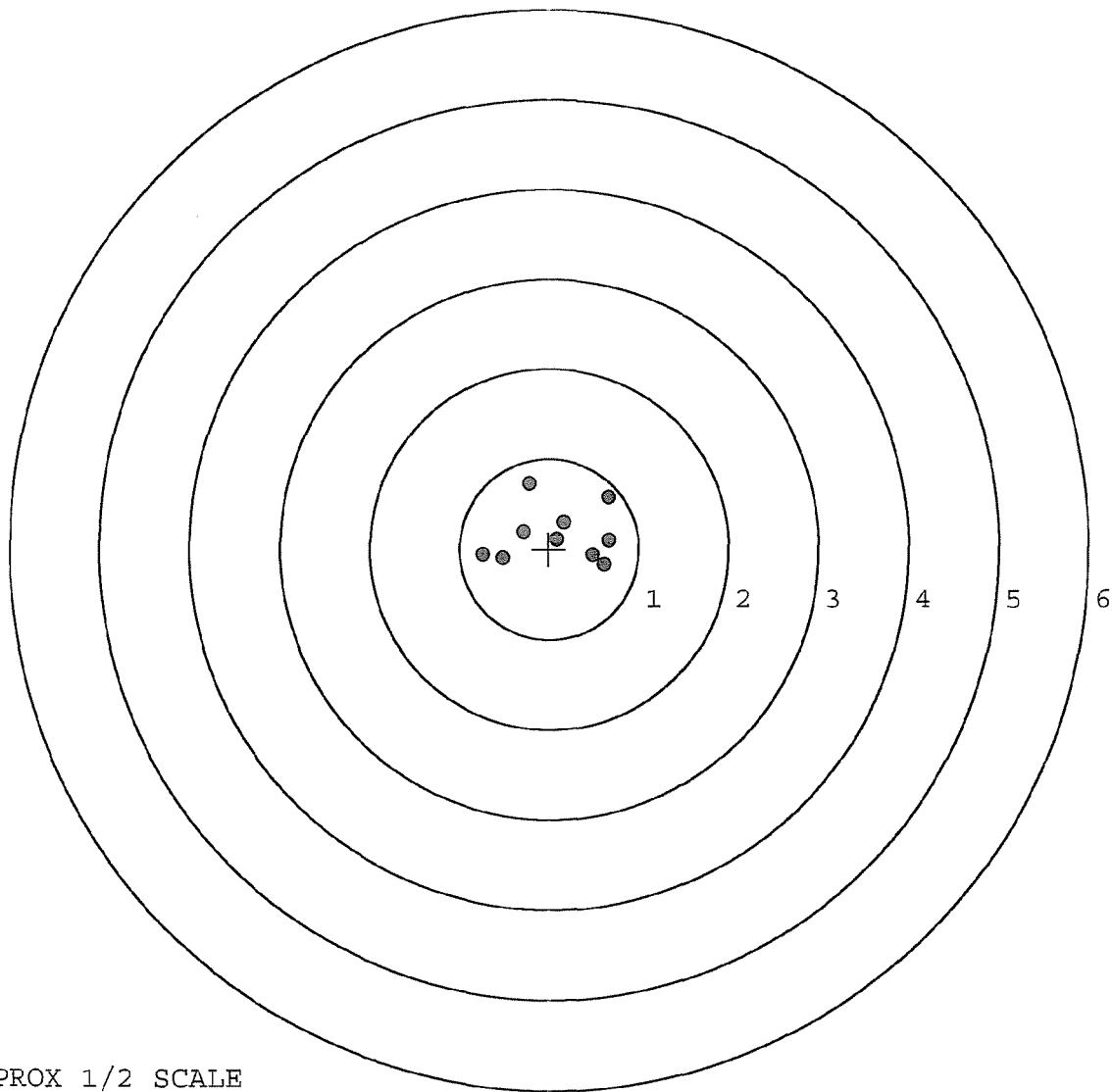
MAX RADIUS: 0.857

MEAN RADIUS: 0.511

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10

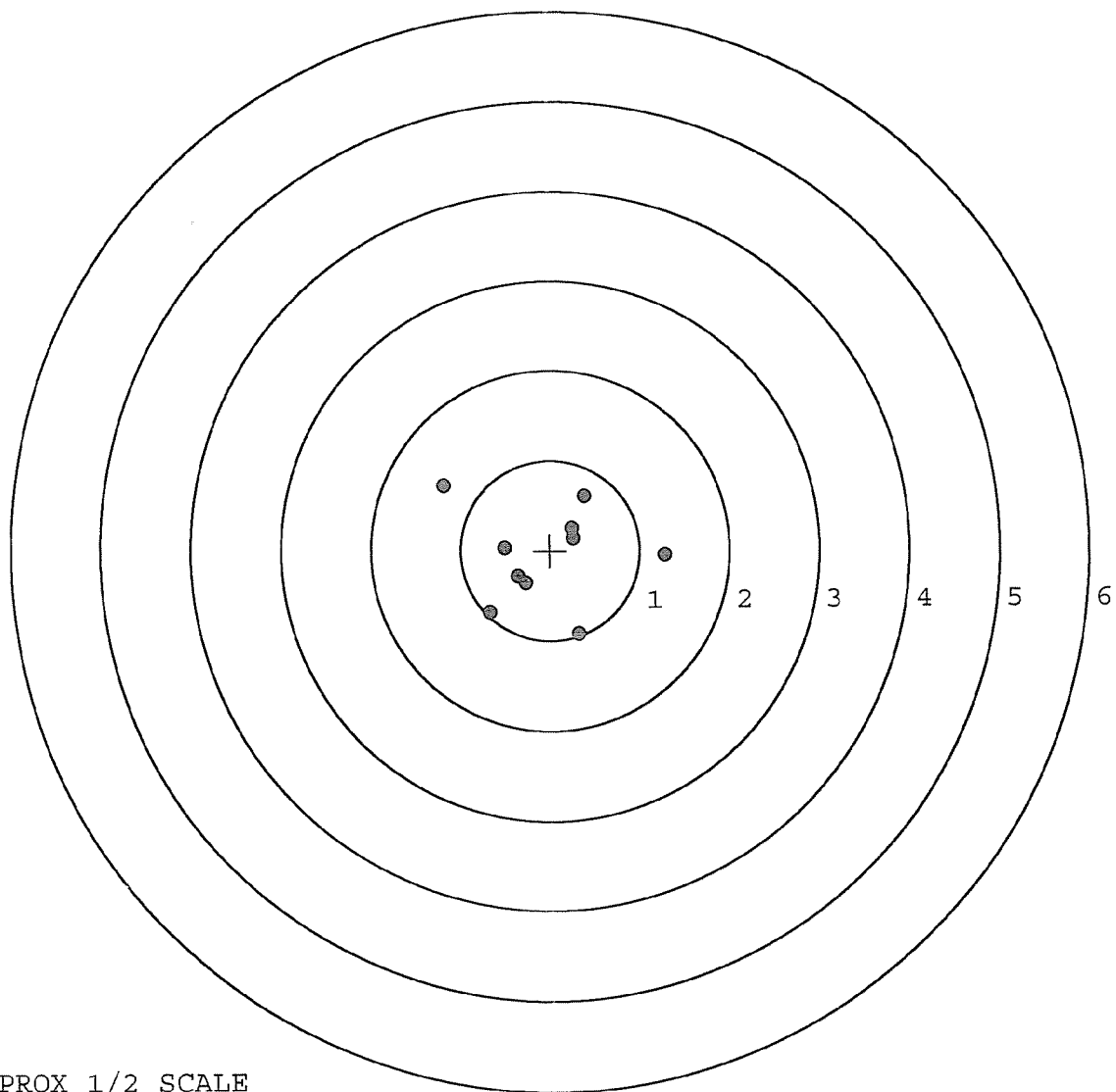


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6285915. __0
 TARGET NUMBER: 2
 FILE DATE: 09/07/2007
 FILE TIME: 11:18

POINT#	X	Y
1:	0.381	0.604
2:	-1.186	0.723
3:	-0.513	0.031
4:	0.246	0.250
5:	0.256	0.137
6:	-0.362	-0.289
7:	-0.276	-0.363
8:	-0.680	-0.687
9:	0.314	-0.933
10:	1.276	-0.060

X CENTROID: -0.054
 Y CENTROID: -0.059
 POA TO CENTROID: 0.080
 HORZ SPREAD: 2.462
 VERT SPREAD: 1.656
 GROUP SPREAD: 2.584
 MIN RADIUS: 0.367
 MAX RADIUS: 1.375
 MEAN RADIUS: 0.736
 # IN 1 IN DIAMETER: 5
 # IN 2 IN DIAMETER: 8
 # in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

BARBER - M24 0156497

SERIAL NUMBER: G6285915. __0

TARGET NUMBER: 3

FILE DATE: 09/07/2007

FILE TIME: 11:18

POINT#	X	Y
--------	---	---

1:	-1.082	0.466
----	--------	-------

2:	-0.982	-0.215
----	--------	--------

3:	-0.528	-0.117
----	--------	--------

4:	-0.685	-0.473
----	--------	--------

5:	-0.265	-0.591
----	--------	--------

6:	-0.202	-0.471
----	--------	--------

7:	-0.173	-0.322
----	--------	--------

8:	0.738	-0.827
----	-------	--------

9:	0.651	-0.143
----	-------	--------

10:	0.416	0.431
-----	-------	-------

X CENTROID: -0.211

Y CENTROID: -0.226

POA TO CENTROID: 0.309

HORZ SPREAD: 1.820

VERT SPREAD: 1.293

GROUP SPREAD: 2.233

MIN RADIUS: 0.103

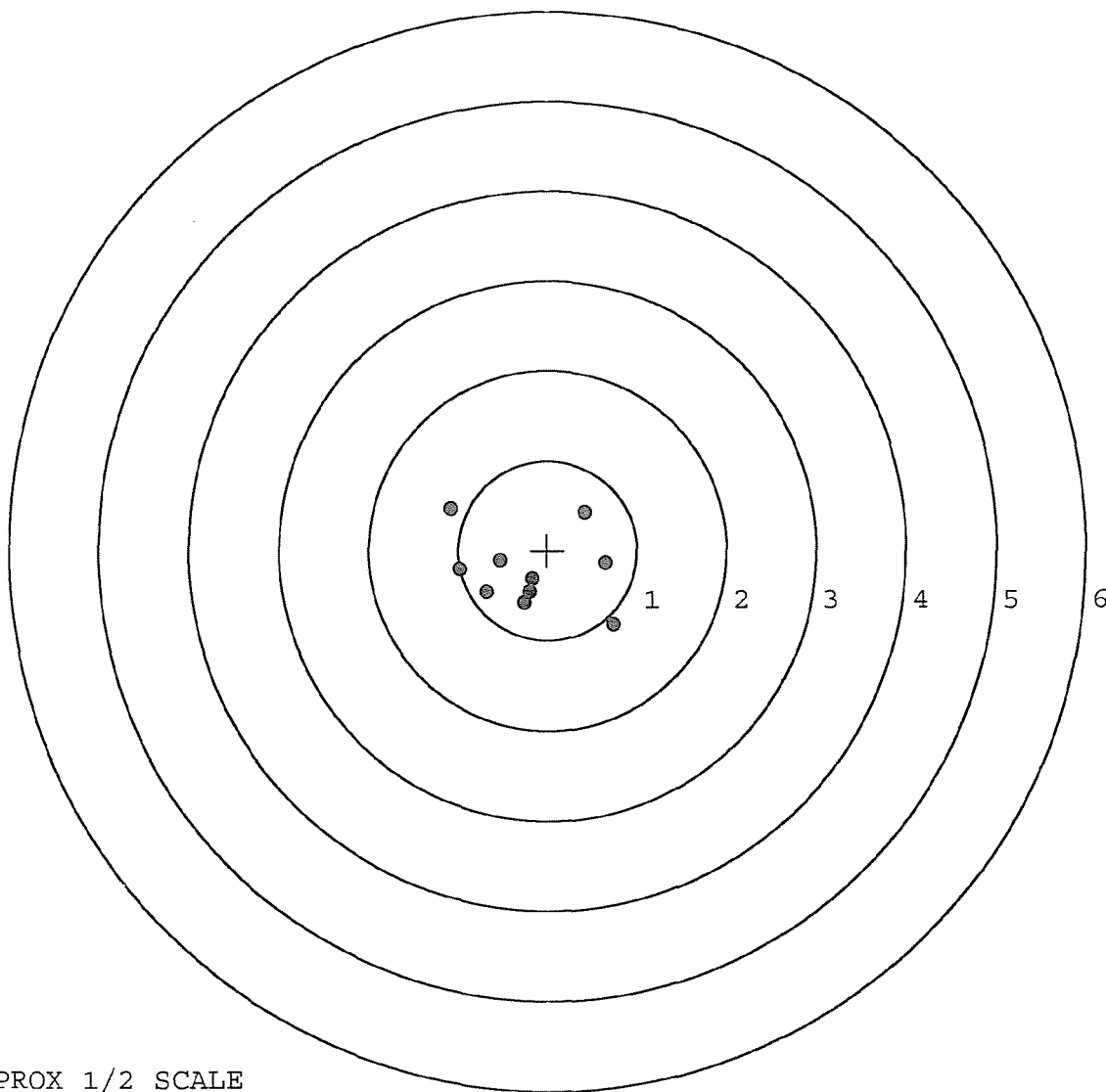
MAX RADIUS: 1.123

MEAN RADIUS: 0.637

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

BARBER - M24 0156498

SERIAL NUMBER: G6285915. __0

TARGET NUMBER: 4

FILE DATE: 09/07/2007

FILE TIME: 11:18

POINT#	X	Y
1:	0.344	0.521
2:	0.213	0.280
3:	-0.222	0.458
4:	-0.410	0.449
5:	-0.179	0.286
6:	-0.411	-0.040
7:	0.241	-0.133
8:	0.020	-0.413
9:	0.506	-0.366
10:	0.348	0.071

X CENTROID: 0.045

Y CENTROID: 0.111

POA TO CENTROID: 0.120

HORZ SPREAD: 0.917

VERT SPREAD: 0.934

GROUP SPREAD: 1.226

MIN RADIUS: 0.238

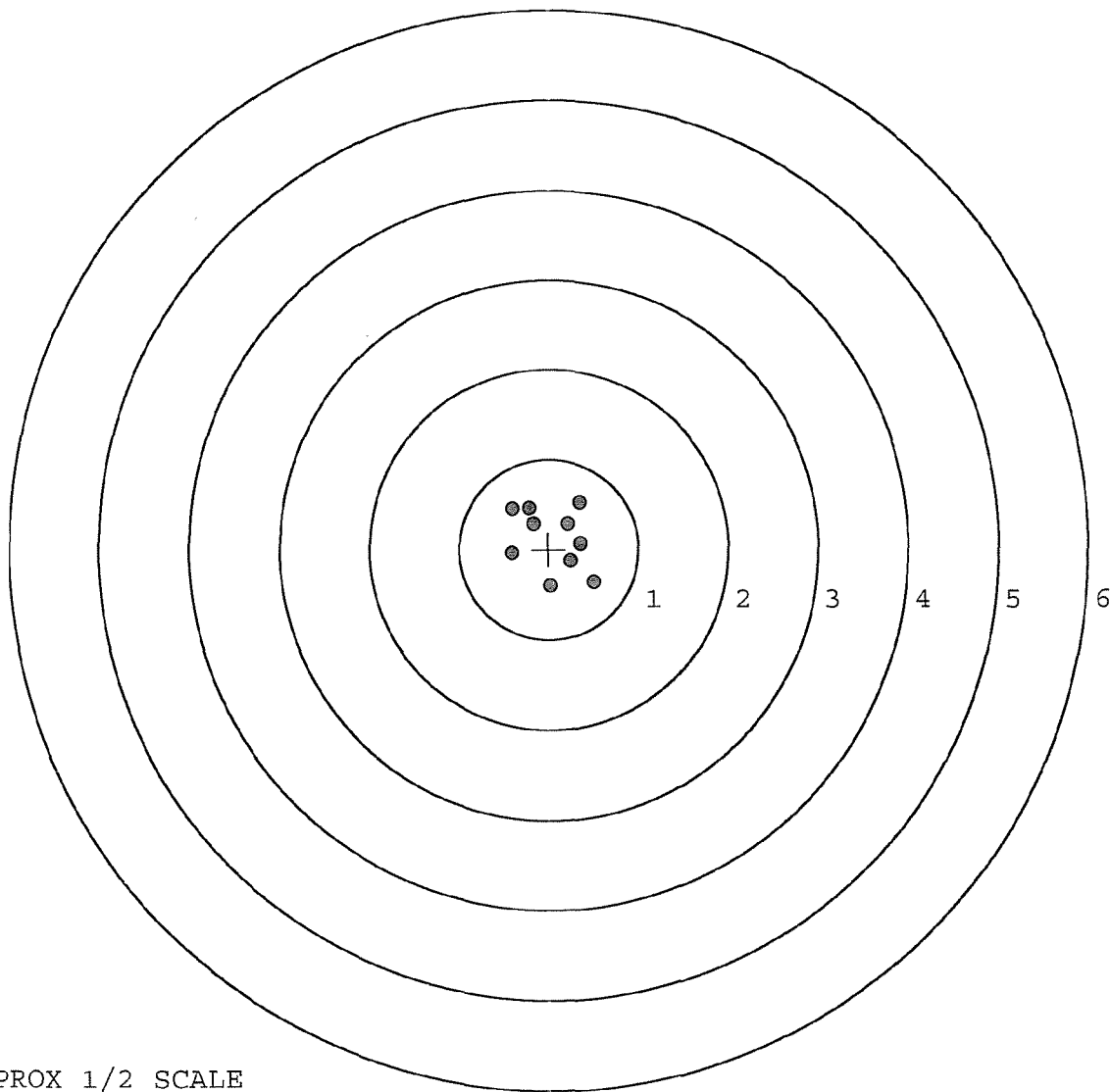
MAX RADIUS: 0.664

MEAN RADIUS: 0.432

IN 1 IN DIAMETER: 6

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

BARBER - M24 0156499

SERIAL NUMBER: G6285915. __0

TARGET NUMBER: 5

FILE DATE: 09/07/2007

FILE TIME: 11:18

POINT#	X	Y
1:	0.322	0.907
2:	-0.223	0.409
3:	-0.331	-0.053
4:	-0.764	0.101
5:	-0.969	-0.392
6:	-0.382	-0.199
7:	-0.778	-1.440
8:	-0.293	-1.059
9:	0.592	-0.199
10:	1.033	0.315

X CENTROID: -0.179

Y CENTROID: -0.161

POA TO CENTROID: 0.241

HORZ SPREAD: 2.002

VERT SPREAD: 2.347

GROUP SPREAD: 2.592

MIN RADIUS: 0.186

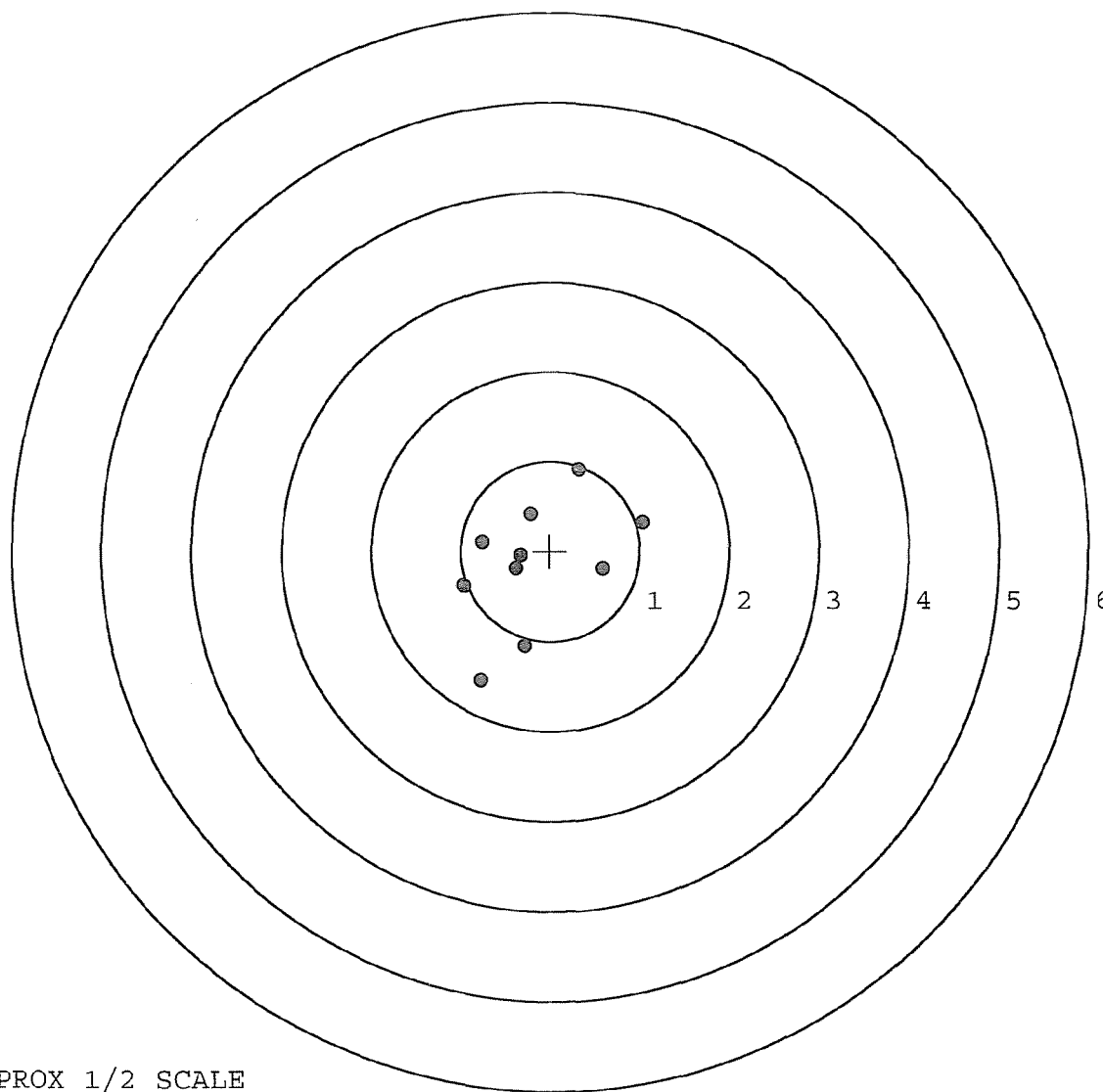
MAX RADIUS: 1.412

MEAN RADIUS: 0.800

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

R & E NUMBER

133011

SERIAL NUMBER

~~G6285915~~

G6285915

TRW

LOG-IN DATE

7-21-07

OPERATION #	OPERATION NAME	DATE	INITIAL
500	DIS-ASSEMBLE GUN	7-22-07	RTZ
505	RE-BARREL	8-23-07	RTZ
560	ASSEMBLE	8-23-07	RTZ
600	PROOF	8/23/07	mon
605	CHECK HEADSPACE	8/23/07	mon
610	DIS-ASSEMBLE GUN	8-25-07	RTZ
612	MAGNAFLUX	8-30-07	JB
510	DRILL AND TAP	8-27-07	TRW
615	ROLLMARK CALIBER	8-28-07	CW
618	ROTO-BLAST	8-30-07	LY
620	APPLY COATINGS	8/31/07	RB
625	FINAL ASSEMBLY		
640	FUNCTION TEST AND	PASS FAIL 9-7-07	TRW
650	TARGET	PASS FAIL 9-7-07	TRW
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
670	FINAL INSPECTION	9-7-07	DA
	A) HEADSPACE	PASS FAIL 9-11-07	RTZ
	B) TRIGGER PULL	2.87 2.80 2.79 2.78 2.81 9-10-07	DA
680	F) SAFETY ON FORCE	8.0 8.0 8.0 9-10-07	Fm
	G) SAFETY OFF FORCE	3.0 3.0 3.0 9-10-07	Fm
	I) FIRING PIN INDENT	.023 .023 .022 9-10-07	Fm
690	PACK	9-11-07	DA

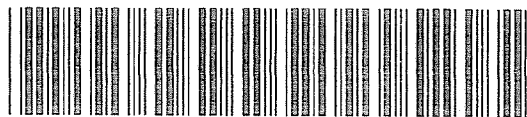
naglelj
11/13/2003
7:02 AM
CAPS
NUM
INS
SCPL

C 628 5915

Serial Number:

C6348830

Model: 700



RE00072945

Receipt Of Firearm(s) Delivered to the Plant for Repair
Firearm Checked For Live Ammunition ☒

File 005037

Delivery Date 11 / 12 / 03

Customer Name (Print) HHC 1/105 Inf 27th BDE WTU2TO

Address Washington Ave Schenectady State N.Y. Zip _____

Phone Number (518) - 220-4120

Fireman Description Model M-24 SWS Cal./Ga. .308

Serial Number C6348830 / 890133

Stock/ Fore-end Condition circle the description

(Excellent, Good, Fair, Poor, Fancy, Plain, Synthetic, Wood)

Comments on Stock/ Fore-end condition _____

Metal Condition circle the description

(Excellent, Good, Fair, Poor, Fancy, Plain Stainless Steel)

Comments on Metal condition _____

Barrel Type (VT. Rib; Plain; Deer; Stainless Steel) Barrel length _____

List additional accessories IE Scope, Sling, Gun case and description:

W/ M3A scope # 890133 w/ sling

Customer request: Re-barrel

Return Process Return to Clark St. Ent. ☐ Return via UPS ☐

customer will pick-up SFC Rich Southern CSMS-H CAMP 914-788-7368

By signing this receipt the person delivering the firearm understands to be the only person to receive the firearm upon completion of repairs.

Signature John F. Neeth Date 11 / 12 / 03
person delivering firearm

Signature Catherine Attali Date 11 / 12 / 03
security officer

Signature Calvin Schott Date 11 / 12 / 03
arms service / CSR

Customer Pick Up Verification

I certify, I am the person whom delivered the above described firearm to the Remington Ilion plant for repair and may lawfully possess a firearm in New York State.

Signature _____ Date ____ / ____ / ____
person receiving firearm must be the same who delivered

Signature _____ Date ____ / ____ / ____
security officer or other witness returning the firearm

Receipt Of Firearm. Doc
Rev. 6/4/03

ARM SERVICE COPY

Remington.

DATE: 20031107

MAINTENANCE REQUEST

DA FORM 5990-E

----- CUSTOMER DATA -----
UIC: WTUZT8 HHC 1/105TH INF PHONE: (518)220-4120
UTIL CODE: 7

----- ACTIVITY DATA -----
SUP WON: CSMS A PHONE: 734-7298
SUP UIC: QCC99A SHOP SEC:

----- EQUIPMENT DATA -----

TYPE MNT REQ: 1 ID: A ASN: 1905012402136 MODEL: M24 SWS

NOUN: RIFLE 7.62MM SNIP SER NUM: C6348838-890133 QTY: 99661

ORG WON: TUZT01320367 PRIORITY: 03 FAILURE DETECTED: H

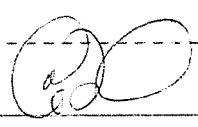
MI/KM: ----- HOURS: ----- ROUNDS:

IN WARRANTY: LEVEL OF WORK: F ADMIN NUM:

DEFICIENCY: RE-BARREL WEAPON

PD AUTHENTICATING SIGNATURE: 

----- SIGNATURE DATA -----

SUBMITTED BY:  ORD DATE: 3311 MIL TIME: _____

ACCEPTED BY: _____ STATUS: _____ ORD DATE: _____ MIL TIME: _____

----- ACTION DATA -----

WORK STARTED BY: _____ STATUS: _____ ORD DATE: _____ MIL TIME: _____

INSPECTED BY: _____ STATUS: _____ ORD DATE: _____ MIL TIME: _____

PICKED UP BY: _____ STATUS: _____ ORD DATE: _____ MIL TIME: _____

----- COMPLETION DATA -----

QTY RPR: _____ QTY CONDEMNED: _____ NRTS: _____

EVAC WON: _____ EVAC UNIT NAME: _____

R & E NUMBER	72945		
SERIAL NUMBER	C628 5915 NCW		
LOG-IN DATE	12-18-03		
INSPECT AND VERIFY:			
OPERATION #	OPERATION NAME	DATE	INITIAL
550	DIS-ASSEMBLE GUN	12-18-03	RTL
560 A	RE-BARREL		
B	DRILL AND TAP		
575	ASSEMBLE		
600	PROOF		
605	CHECK HEADSPACE		
610	DIS-ASSEMBLE GUN		
612	MAGNAFLUX		
615	ROLLMARK CALIBER		
618	ROTO-BLAST		
620	APPLY COATINGS		
625 A	FINAL ASSEMBLY		
B	TRIGGER PULL TEST		
C	SAFETY "ON" FORCE		
D	SAFETY "OFF" FORCE		
E	FIRING PIN INDENT		
640	TARGET	12-19-03	AC
655	FINAL INSPECT	12-22-03	RTL
660	PACK	12/22/03	DA
		SHIP DATE	
	QAR INSPECTION DATE		

INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # 66285915

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		11-14-02	RL
600	PROOF		11-18-02	K
607	CHECK HEADSPACE	MAGNA - FLUX INSPECTED	11-18-02	A
610	DIS-ASSEMBLE GUN		11-19-02	RL
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	2002 RL OPERATION		
615	ROLLMARK CALIBER		11-22-02	SB
617	DRILL AND TAP SIGHT HOLES		11-22-02	TRW
620	APPLY COATINGS (BARREL ACTION)		12-5	TA
	(BOLT)		12-5	TA
625	FINAL ASSEMBLY			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		5-14-02	RL
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		5-14-02	RL
	C) INSPECT EJECTOR HOLE FOR CHAMFER		5-14-02	RL
	D) OIL FIRING PIN ASSEMBLY		5-14-02	RL
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS		6-20-03	TRW

OP #	OPERATION NAME	READINGS	DATE	INITIAL
625	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>6.75</u> <u>6.75</u> <u>6.75</u>	6-20-03	TRLW
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>2.25</u> <u>2.5</u> <u>2.0</u>	6-20-03	TRLW
	H) TRIGGER PULL TEST AND RETAINABILITY		6-30-03	RTL
	I) FIRING PIN INDENT .020 MIN	<u>.0235</u> <u>.0235</u> <u>.023</u>	6-20-03	TRLW
	J) ASSEMBLE STOCK		5-16-03	RLW
	K) ASSEMBLE SWIVEL STUDS		6-30-03	RTL
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		6-30-03	RTL
	M) IRON SIGHT ALIGNMENT		6-30-03	RTL
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		6-30-03	RTL
640	GALLERY TEST AND TARGET	PASS FAIL	5-19-03	TRLW
	MALFUNCTION	CORRECTION	5-19-03	TRLW
	MALFUNCTION	CORRECTION	5-19-03	TRLW
	MALFUNCTION	CORRECTION	5-19-03	TRLW
	MALFUNCTION	CORRECTION	5-19-03	TRLW
645	INSPECT FOR LIVE AMMO		5-19-03	TRLW
655	FINAL INSPECTION A) HEADSPACE		6-30-03	RTL
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.89</u> <u>2.79</u> <u>2.71</u> <u>2.79</u> <u>2.80</u>	6-20-03	TRLW
	C) FUNCTION		6-30-03	RTL
660	PACK		6-30-03	19A

2.50# + .50#
 3.00# + .75#
 4.00# + 1.00#

DATE 12-9-02

TESTER TRW

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.62	2.68		2.62	MIN. SETTING,
PULL #2	2.51	2.64		2.65	NO AVG. OF 5
PULL #3	2.34	2.62		2.58	READINGS ACCEPT
PULL #4	2.29	2.60		2.31	ABLE LESS THAN
PULL #5	2.35	2.59		2.54	
TOTAL	12.11	13.13		12.70	
AVG.	2.42	2.62		2.54	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.35	3.32		
PULL #2	3.30	3.33		
PULL #3	3.17	3.39		
PULL #4	3.15	3.37		
PULL #5	3.17	3.28		
TOTAL	16.14	16.69		
AVG.	3.22	3.33		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# TARGET & ACCU
PULL #1	4.15	4.37		4.44
PULL #2	4.01	4.32		4.24
PULL #3	4.05	4.25		4.22
PULL #4	4.03	4.14		4.07
PULL #5	3.99	4.17		4.26
TOTAL	20.23	21.25		21.23
AVG.	4.04	4.25		4.24

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6285915.__0

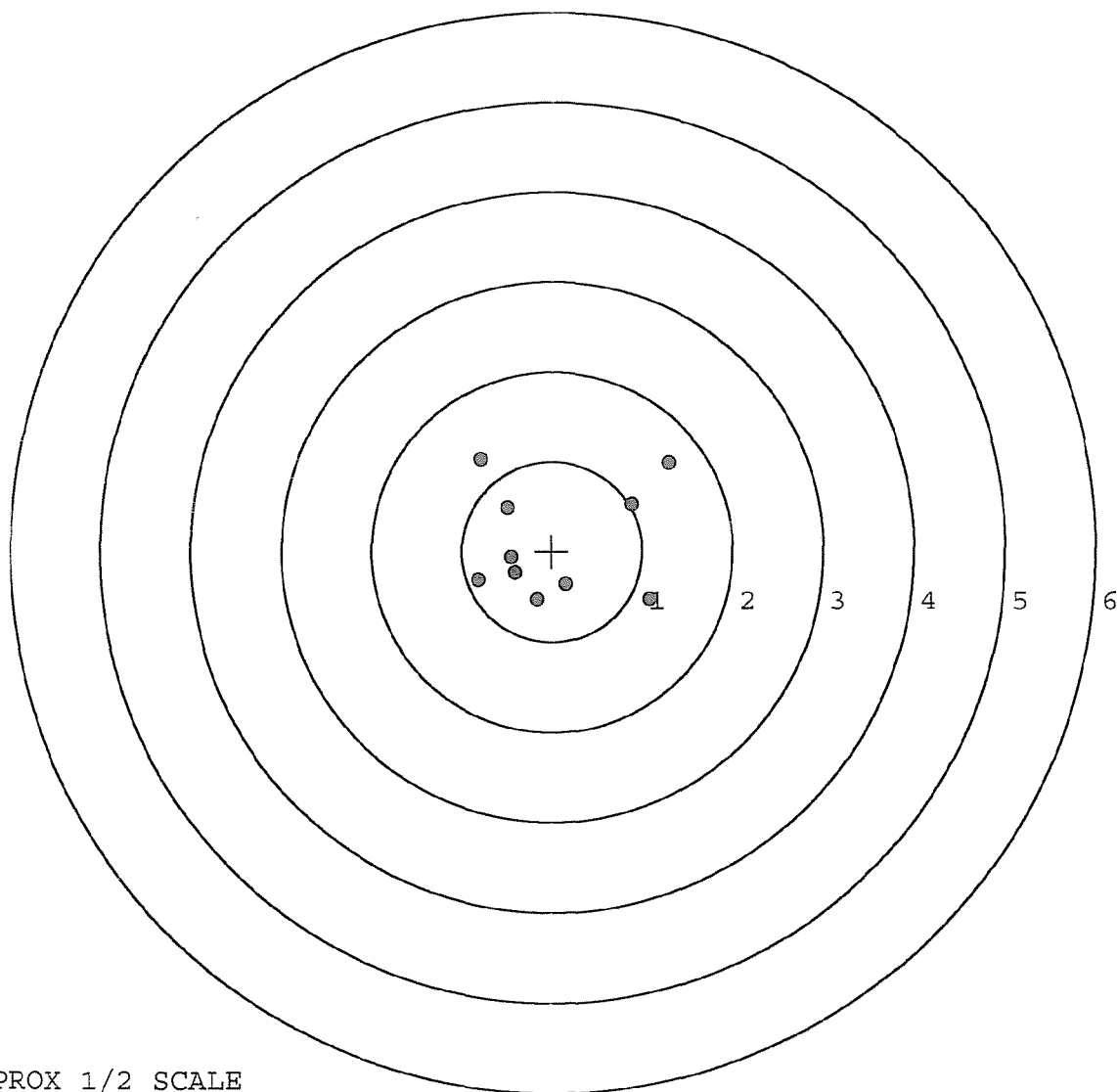
FILE DATE AND TIME: 05/19/2003 06:10

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.081
The Average Y Centroid of the Five Target Set:	0.113
The Average Point of Impact of the Five Target Set:	0.139
The Average Mean Radius of the Five Target Set:	0.933
The Distance from POA to Centroid Target #1:	0.097
The Distance from Centroid Target #2 to Centroid Target #1:	0.194
The Distance from Centroid Target #3 to Centroid Target #1:	0.142
The Distance from Centroid Target #4 to Centroid Target #1:	0.074
The Distance from Centroid Target #5 to Centroid Target #1:	0.120

BARBER - M24 0156509

SERIAL NUMBER: G6285915. 0	POINT#	X	Y
TARGET NUMBER: 1	1:	1.084	-0.538
FILE DATE: 05/19/2003	2:	0.884	0.525
FILE TIME: 06:10	3:	1.288	0.980
	4:	-0.791	1.024
X CENTROID: 0.029	5:	-0.495	0.485
Y CENTROID: 0.092	6:	-0.450	-0.072
POA TO CENTROID: 0.097	7:	-0.815	-0.324
HORZ SPREAD: 2.103	8:	-0.163	-0.544
VERT SPREAD: 1.568	9:	0.157	-0.368
GROUP SPREAD: 2.474	10:	-0.407	-0.245
MIN RADIUS: 0.478			
MAX RADIUS: 1.540			
MEAN RADIUS: 0.877			
# IN 1 IN DIAMETER: 1			
# IN 2 IN DIAMETER: 7			
# in 3 IN DIAMETER: 9			



TARGET APPROX 1/2 SCALE

BARBER - M24 0156510

SERIAL NUMBER: G6285915. 0

TARGET NUMBER: 2

FILE DATE: 05/19/2003

FILE TIME: 06:10

POINT#	X	Y
1:	-0.474	-1.717
2:	0.606	-0.302
3:	0.359	-0.238
4:	-0.052	-0.353
5:	0.041	0.351
6:	1.228	0.180
7:	1.892	0.813
8:	1.616	0.976
9:	-1.228	1.411
10:	-1.814	0.278

X CENTROID: 0.217

Y CENTROID: 0.140

POA TO CENTROID: 0.259

HORZ SPREAD: 3.706

VERT SPREAD: 3.128

GROUP SPREAD: 3.744

MIN RADIUS: 0.275

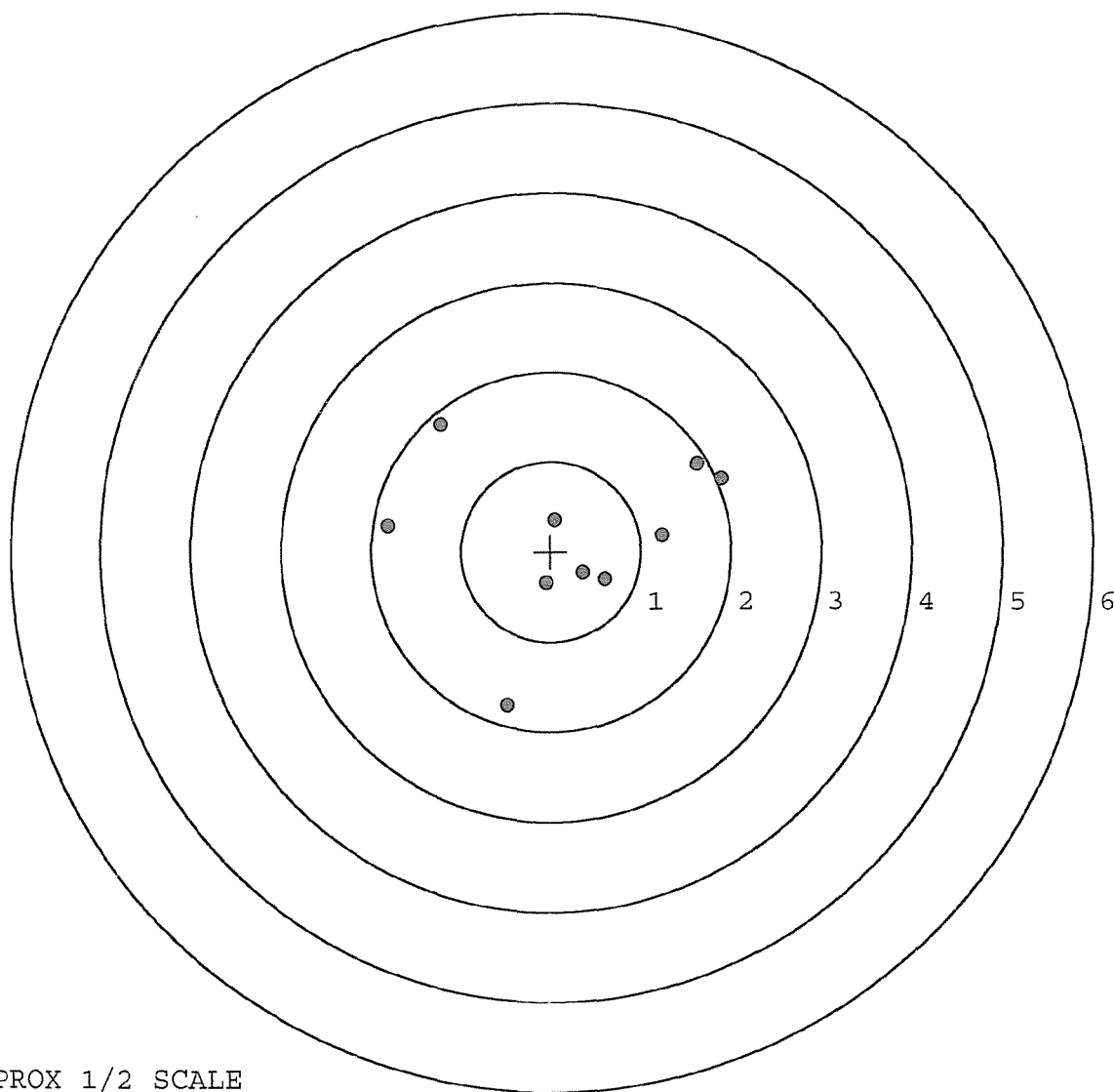
MAX RADIUS: 2.036

MEAN RADIUS: 1.222

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 4

in 3 IN DIAMETER: 5



TARGET APPROX 1/2 SCALE

BARBER - M24 0156511

SERIAL NUMBER: G6285915. __0

TARGET NUMBER: 3

FILE DATE: 05/19/2003

FILE TIME: 06:10

POINT#	X	Y
1:	0.964	-0.617
2:	1.616	1.233
3:	0.206	0.613
4:	-0.320	0.225
5:	-0.608	0.420
6:	-0.487	0.837
7:	-0.812	-0.228
8:	0.253	-0.369
9:	0.468	-0.110
10:	0.077	-0.140

X CENTROID: 0.136

Y CENTROID: 0.186

POA TO CENTROID: 0.231

HORZ SPREAD: 2.428

VERT SPREAD: 1.850

GROUP SPREAD: 2.834

MIN RADIUS: 0.332

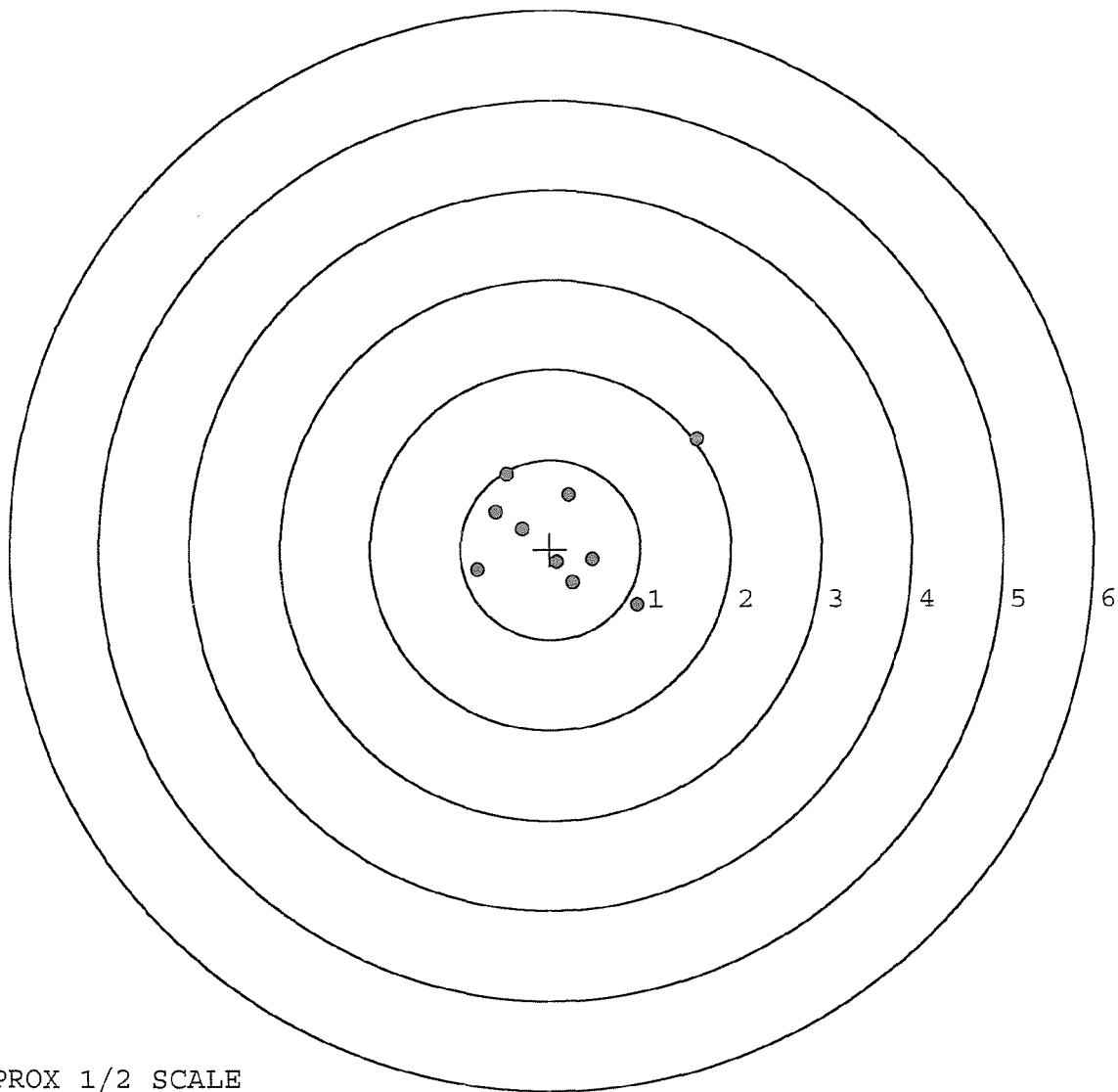
MAX RADIUS: 1.813

MEAN RADIUS: 0.792

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 9



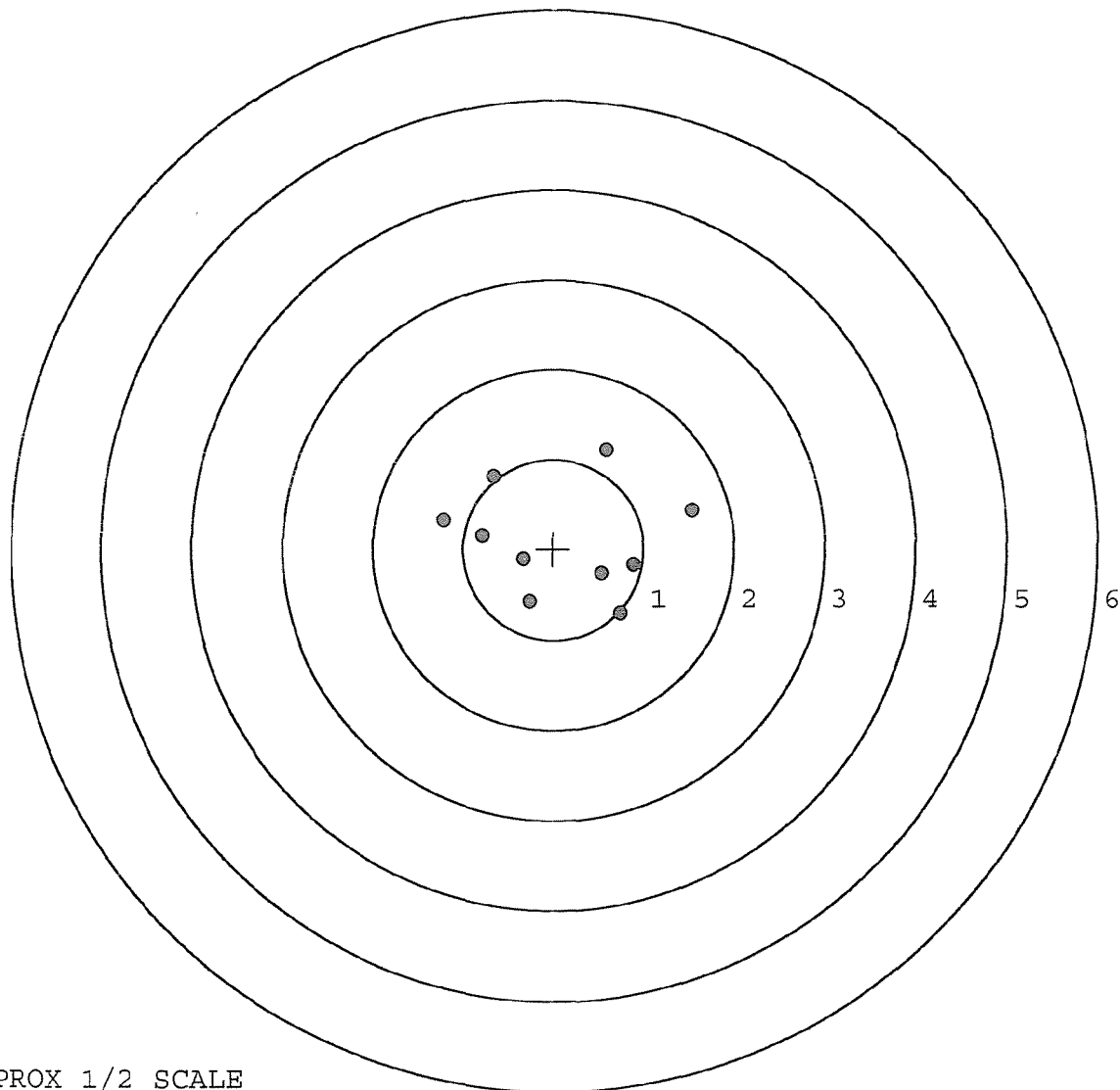
TARGET APPROX 1/2 SCALE

BARBER - M24 0156512

SERIAL NUMBER: G6285915. __0
 TARGET NUMBER: 4
 FILE DATE: 05/19/2003
 FILE TIME: 06:10

POINT#	X	Y
1:	1.528	0.439
2:	0.590	1.107
3:	0.893	-0.176
4:	0.536	-0.272
5:	0.741	-0.707
6:	-0.263	-0.584
7:	-0.327	-0.117
8:	-0.792	0.152
9:	-1.217	0.319
10:	-0.661	0.807

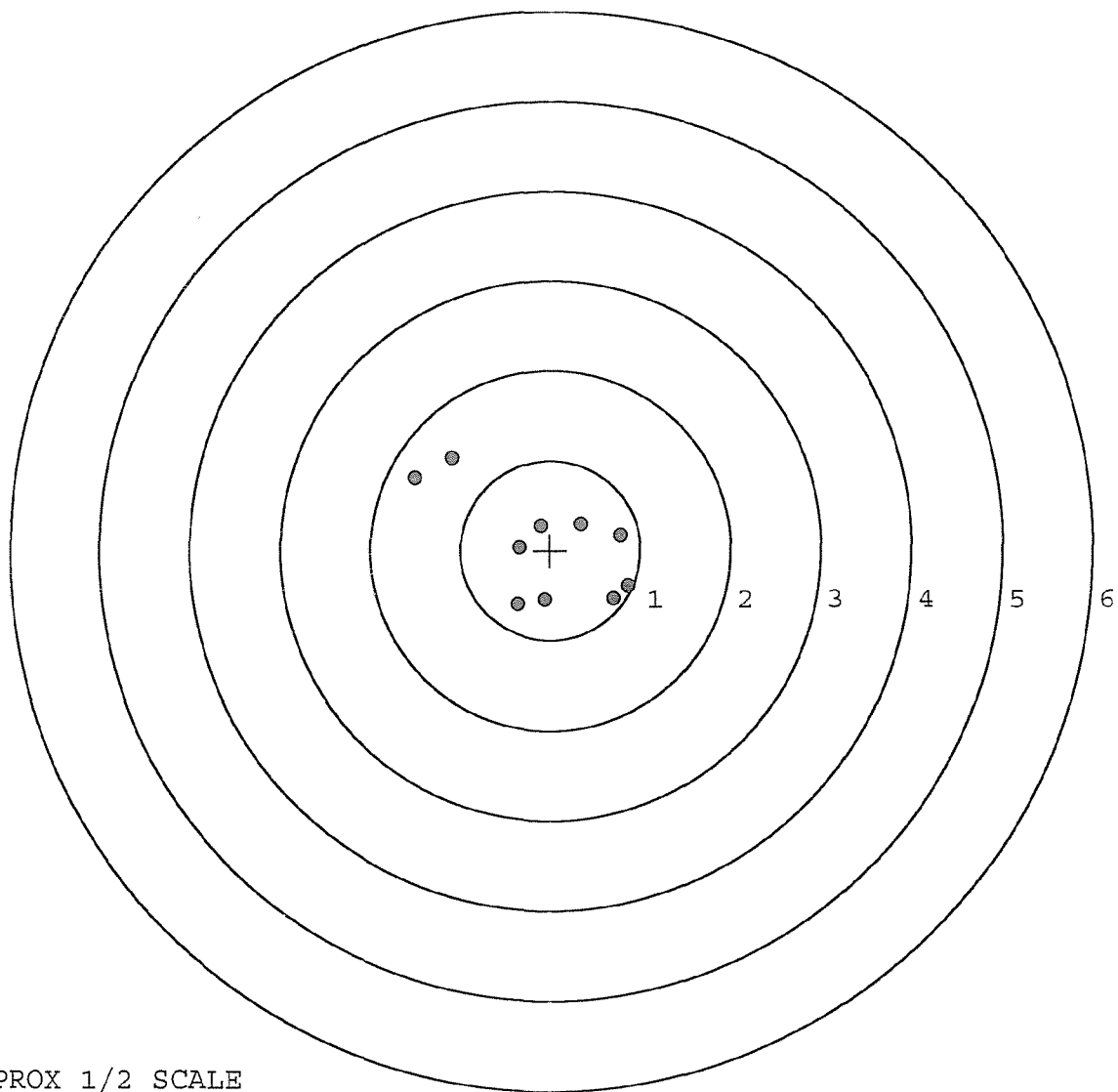
X CENTROID: 0.103
 Y CENTROID: 0.097
 POA TO CENTROID: 0.141
 HORZ SPREAD: 2.745
 VERT SPREAD: 1.814
 GROUP SPREAD: 2.748
 MIN RADIUS: 0.480
 MAX RADIUS: 1.466
 MEAN RADIUS: 0.955
 # IN 1 IN DIAMETER: 1
 # IN 2 IN DIAMETER: 5
 # in 3 IN DIAMETER: 10



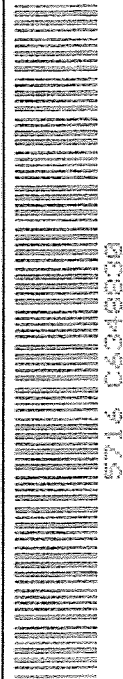
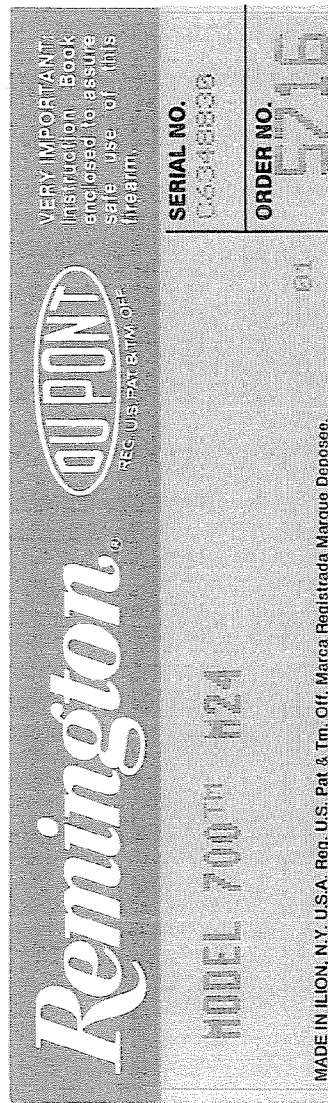
TARGET APPROX 1/2 SCALE

BARBER - M24 0156513

SERIAL NUMBER: G6285915. __0	POINT#	X	Y
TARGET NUMBER: 5	1:	0.704	-0.546
FILE DATE: 05/19/2003	2:	0.864	-0.404
FILE TIME: 06:10	3:	0.774	0.172
	4:	0.334	0.298
X CENTROID: -0.082	5:	-0.113	0.278
Y CENTROID: 0.049	6:	-0.064	-0.554
POA TO CENTROID: 0.096	7:	-1.100	1.021
HORZ SPREAD: 2.377	8:	-0.346	0.029
VERT SPREAD: 1.629	9:	-0.364	-0.608
GROUP SPREAD: 2.666	10:	-1.513	0.803
MIN RADIUS: 0.231			
MAX RADIUS: 1.617			
MEAN RADIUS: 0.822			
# IN 1 IN DIAMETER: 3			
# IN 2 IN DIAMETER: 7			
# in 3 IN DIAMETER: 9			



TARGET APPROX 1/2 SCALE



CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6348830

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	9 14	89	RW
600	Proof	9 14	89	RW
607	Check Headspace	9 14	89	RW
610	Dis-assemble Gun	9 14	89	RW
612	Magnaflux Barrel Action	9-14-	89	KCR
	Magnaflux Bolt	9-14	89	KCR
615	Rollmark Caliber		9/5/89	GS
7	Drill and Tap Sight Holes	9 15	89	FB
618	Polish Barrel	9 15	89	BT
620	Apply Coatings (Barrel Action)		9-25-89	TJA
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		10/2/89	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/2/89	RW
	C) Inspect Ejector Hole for Chamfer		10/2/89	RW
	D) Oil Firing Pin Ass'y		10/2/89	RW
	E) Adjust Trigger Pull to Min Setting and Stake		3/2/89	GS

BARBER - M24 0156516

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			10/4/89	JS
	G) Safety Off Force	3	3	3			10/4/89	JS
	H) Trigger Pull Test & Retainability						3 Oct 89	JS
	I) Firing Pin Indent	.0205	.021	.020			10/4/89	JS
	J) Assemble Stock						10/4/89	JS
	K) Assemble Swivel Studs						6 Oct 89	JS
	L) Attach Front and Rear Sight Assemblies						10/4/89	JS
	M) Iron Sight Alignment						10/4/89	JS
	N) Detach Front & Rear Sights & place in numbered container						10/4/89	JS
	O) Attach Scope to Rifle						10/4/89	JS
	P) Detach & Attach Scope 20 Times						10/4/89	JS
640	Gallery Target & Test						10-4-89	AC
	A) Time						10-4-89	AC
	B) Malfunctions						10-4-89	AC
	C) Pierced Primers						10-4-89	AC
	D) Optical Clarity of Scope						10-4-89	AC
645	Inspect for Live Ammo						10-4-89	AC
655	Final Inspection							
	A) Headspace						6 Oct 89	JS
	B) Trigger Pull	272	273	273	250	246	6 Oct 89	JS
	C) Function						6 Oct 89	JS
660	Pack						15 Dec 89	JS

SWS TRIGGER PULL TEST

BARBER - M24 0156517

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. 4639 38830DATE 13 MAR 90TESTER Q28

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	250	235		219	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	241	242		223	
PULL #3	239	241		219	
PULL #4	240	238		221	
PULL #5	240	240		225	
TOTAL	1210	1196			
AVG.	242	2392			

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	284	291		
PULL #2	297	255		
PULL #3	298	272		
PULL #4	297	301		
PULL #5	293	289		
TOTAL	1469	1408		
AVG.	2938	2816		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	392	380		
PULL #2	380	369		
PULL #3	383	378		
PULL #4	385	381		
PULL #5	382	380		
TOTAL	1922	1888		
AVG.	3834	3776		

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06348830
4 Oct 1989

CENTROIDAL DISTANCES

0 TO	1	.542403
1 TO	2	.177553
1 TO	3	.364642
1 TO	4	.272943
1 TO	5	.361006

+33 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .5634
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1852
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .593859
THE AMR FOR THIS RIFLE IS: .9796

* Oct 1988

FILE: \PATTERNING\CENTERFIRE_PATT\08340830

CENTERFIRE PATTERNS # 1

POR

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS= 10

IN CIR

1in = 0

2in = 4

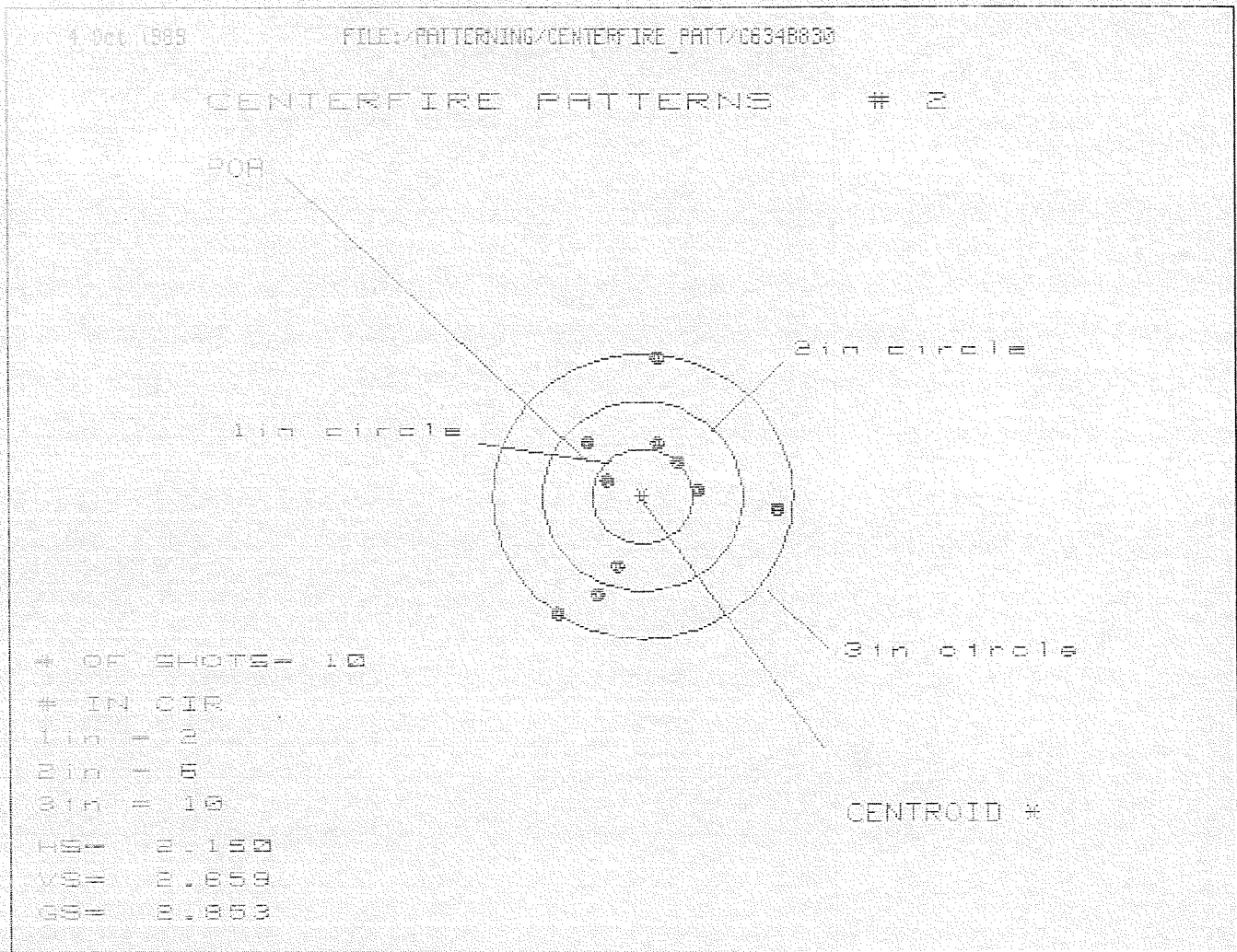
3in = 10

HS= 2.525

VS= 2.526

GS= 2.679

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.120	.964	.857
MINIMUM X	-1.405	-1.257	-1.364
MAXIMUM Y	1.313	1.311	1.150
MINIMUM Y	-1.213	-1.215	-1.000
CENTROID X	.435	.591	.698
CENTROID Y	-.324	-.322	-.170
POR TO CENTROID in.	.542	.673	.719
MIN RADIUS	.519	.478	.628
MEAN RADIUS	1.057	.997	.916
MAX RADIUS	1.405	1.489	1.427
HORIZONTAL SPREAD	2.525	2.221	2.221
VERTICAL SPREAD	2.526	2.526	2.159
EXTREME SPREAD	2.679	2.679	2.294
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	10		



PATTERN #	2		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.297	1.203	1.214
MINIMUM X	-.853	-.644	-.633
MAXIMUM Y	1.451	1.317	.539
MINIMUM Y	-1.208	-1.139	-.974
CENTROID X	.354	.448	.438
CENTROID Y	-.166	-.032	-.197
POB TO CENTROID IN.	.391	.449	.486
MIN RADIUS	.374	.286	.417
MEAN RADIUS	.385	.792	.740
MAX RADIUS	1.478	1.320	1.220
HORIZONTAL SPREAD	2.150	1.847	1.847
VERTICAL SPREAD	2.659	2.456	1.563
EXTREME SPREAD	2.853	2.542	1.981
NUMBER IN ONE INCH CIRCLE	=	2	
NUMBER IN TWO INCH CIRCLE	=	6	
NUMBER IN THREE INCH CIRCLE	=	10	

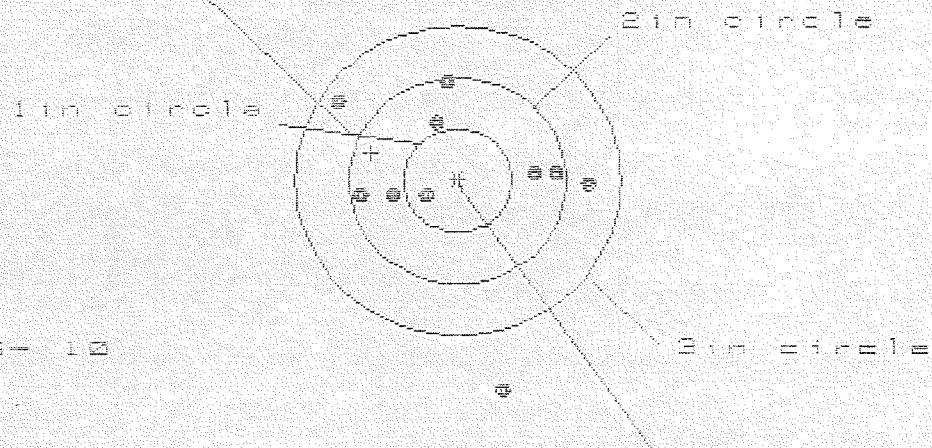
4 DEC 1985

FILE:/PATTERNING/CENTERFIRE_PATT/06346830

CENTERFIRE PATTERNS

3

FOR



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 7

3 in = 9

HS= 2.222

VS= 3.028

GS= 3.155

CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.168	1.211	1.085
MINIMUM X	-1.054	-1.011	-0.996
MAXIMUM Y	.969	.741	.805
MINIMUM Y	-2.059	-.365	-.301
CENTROID X	.795	.752	.878
CENTROID Y	-.266	-.038	-.102
FOR TO CENTROID in.	.839	.752	.864
MIN RADIUS	.325	.355	.469
MEAN RADIUS	.966	.808	.772
MAX RADIUS	2.096	1.233	1.098
HORIZONTAL SPREAD	2.222	2.222	2.081
VERTICAL SPREAD	3.028	1.106	1.106
EXTREME SPREAD	3.155	2.344	2.085
NUMBER IN ONE INCH CIRCLE	=	1	
NUMBER IN TWO INCH CIRCLE	=	7	
NUMBER IN THREE INCH CIRCLE	=	9	

9 Oct 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C834B830

CENTERFIRE PATTERNS

4

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS = 10

IN CIR

1 in = 1

2 in = 5

3 in = 8

HS = 2.907

VS = 2.345

CS = 3.022

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.089	.886	.651
MINIMUM X	:	-1.819	-1.757	-1.646
MAXIMUM Y	:	1.259	1.230	1.091
MINIMUM Y	:	-1.086	-1.115	-1.194
CENTROID X	:	.508	.711	.600
CENTROID Y	:	-.061	-.032	.107
POA TO CENTROID in.	:	.512	.711	.609
MIN RADIUS	:	.272	.258	.398
MEAN RADIUS	:	1.074	.970	.912
MAX RADIUS	:	1.837	1.441	1.295
HORIZONTAL SPREAD	:	2.907	1.643	1.297
VERTICAL SPREAD	:	2.345	2.345	2.284
EXTREME SPREAD	:	3.022	2.860	2.521
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

4 Oct 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C8346830

CENTERFIRE PATTERNS # 5

POB

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS= 10

IN CIR

1 in = 2

2 in = 6

3 in = 7

HS= 2.639

VS= 2.628

GS= 3.184

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.259	1.306	1.139
MINIMUM X	:	-1.380	-1.333	-1.741
MAXIMUM Y	:	1.724	.988	.899
MINIMUM Y	:	-.904	-.713	-.755
CENTROID X	:	.725	.678	.845
CENTROID Y	:	-.109	-.300	-.211
POB TO CENTROID in.	:	.733	.742	.871
MIN RADIUS	:	.145	.311	.189
MEAN RADIUS	:	.916	.822	.721
MAX RADIUS	:	1.773	1.512	1.366
HORIZONTAL SPREAD	:	2.639	2.639	1.880
VERTICAL SPREAD	:	2.628	1.701	1.654
EXTREME SPREAD	:	3.184	2.639	2.504
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		7	

INTERCHANGEABILITY

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06348838
12 Dec 1989

CENTROIDAL DISTANCES

0 TO 1	.431372
1 TO 2	.262408
1 TO 3	.40606
1 TO 4	.0880909
1 TO 5	.543242

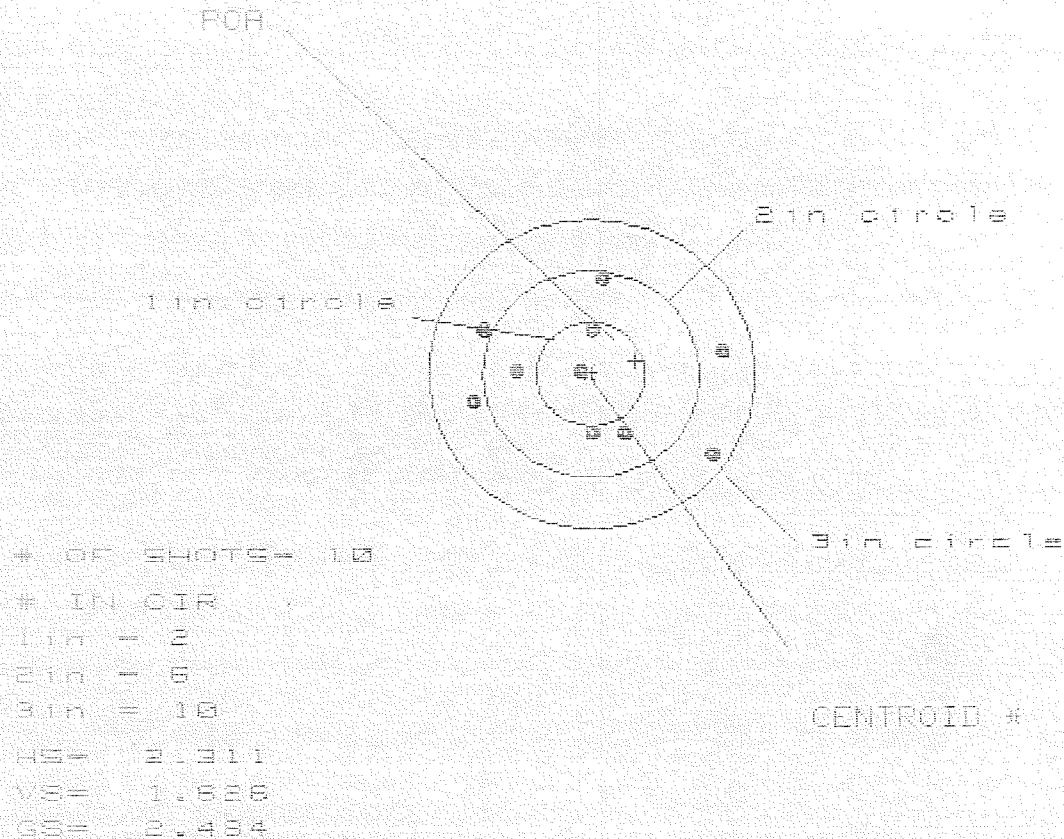
24 900 <----POB

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.2752
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.095
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .291136
THE AMR FOR THIS RIFLE IS: .9048

12 Dec 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C334B830.J

CENTERFIRE PATTERNS # 1

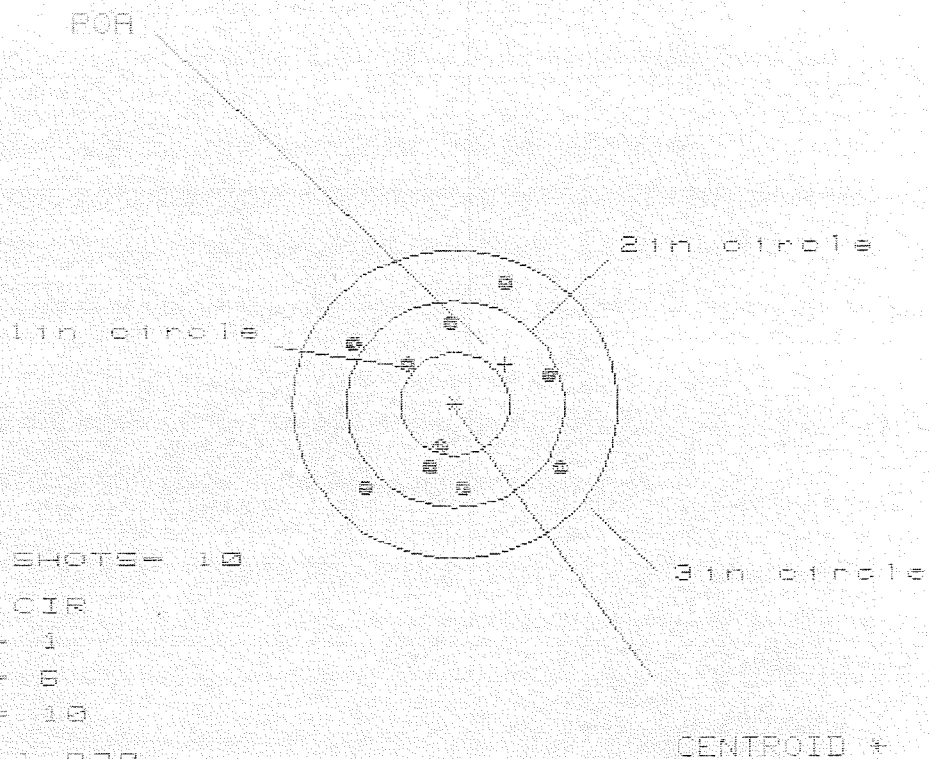


PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.242	1.369	.623
MINIMUM X	-1.069	-.942	-.771
MAXIMUM Y	.907	.828	.844
MINIMUM Y	-.719	-.649	-.633
CENTROID X	-.411	-.538	-.709
CENTROID Y	-.131	-.052	-.068
POA TO CENTROID in.	.432	.540	.712
MIN RADIUS	.040	.126	.270
MEAN RADIUS	.816	.752	.671
MAX RADIUS	1.349	1.375	.951
HORIZONTAL SPREAD	2.311	2.311	1.394
VERTICAL SPREAD	1.626	1.477	1.477
EXTREME SPREAD	2.484	2.360	1.690
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	10		

12 Dec 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C634B830.1

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 6

3 in = 10

HS= 1.838

VS= 2.026

CS= 2.374

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.939	.992	1.098
MINIMUM X	-.899	-.846	-.721
MAXIMUM Y	1.199	.939	.874
MINIMUM Y	-.827	-.694	-.759
CENTROID X	-.464	-.517	-.642
CENTROID Y	-.388	-.521	-.456
POA TO CENTROID in.	.605	.735	.787
MIN RADIUS	.407	.263	.300
MEAN RADIUS	.879	.807	.760
MAX RADIUS	1.293	1.121	1.143
HORIZONTAL SPREAD	1.838	1.838	1.811
VERTICAL SPREAD	2.026	1.633	1.633
EXTREME SPREAD	2.374	2.218	2.022
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	10		

12 Dec 1989

FILE: PATTERNING/CENTERFIRE_PATT/CG348838.1

CENTERFIRE PATTERNS # 3

POB

1 in circle

2 in circle

3 in circle

CENTROID #

OF SHOTS = 12

IN CIR

1 in = 1

2 in = 5

3 in = 10

HS = 2.375

VS = 2.032

ES = 2.529

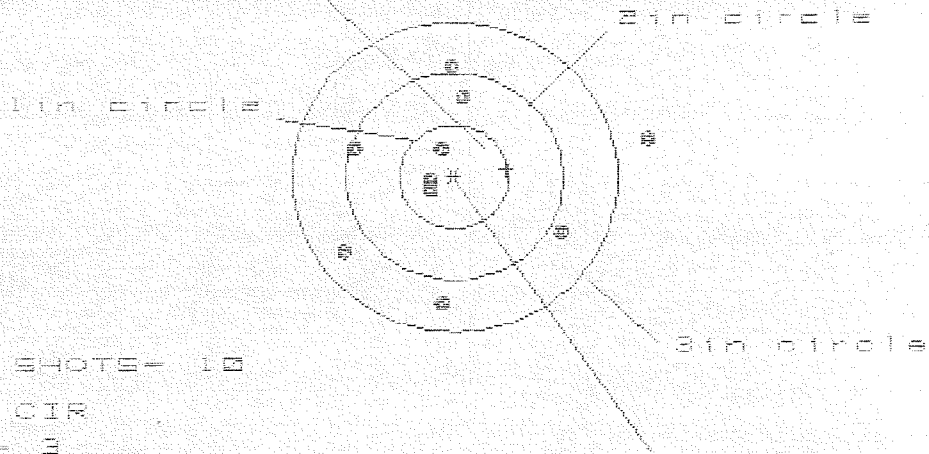
PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.097	.959	.950
MINIMUM X	-1.278	-1.416	-1.296
MAXIMUM Y	1.022	.937	.826
MINIMUM Y	-1.010	-1.095	-1.206
CENTROID X	-.005	.134	.014
CENTROID Y	-.124	-.039	.072
POB TO CENTROID in.	.124	.139	.073
MIN RADIUS	.337	.418	.527
MEAN RADIUS	1.021	.964	.901
MAX RADIUS	1.464	1.416	1.471
HORIZONTAL SPREAD	2.375	2.375	2.246
VERTICAL SPREAD	2.032	2.032	2.032
EXTREME SPREAD	2.529	2.529	2.394
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	10		

12 Feb 1989

FILE: PATTERNING/CENTERFIRE_PATT/C3348830.1

CENTERFIRE PATTERNS # 4

FOR



OF SHOTS = 10

IN CIR

1 in = 3

2 in = 5

3 in = 2

HS = 2.777

VS = 2.321

GS = 2.973

CENTROID #

PATTERN #	4	5	6
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.729	1.172	1.175
MINIMUM X	-1.048	-.856	-.853
MAXIMUM Y	1.049	1.085	.931
MINIMUM Y	-1.272	-1.236	-.852
CENTROID X	-.479	-.671	-.674
CENTROID Y	-.075	-.111	.043
FOR TO CENTROID in.	.485	.680	.675
MIN RADIUS	.227	.043	.159
MEAN RADIUS	.904	.756	.693
MAX RADIUS	1.760	1.238	1.362
HORIZONTAL SPREAD	2.777	2.028	2.028
VERTICAL SPREAD	2.321	2.321	1.783
EXTREME SPREAD	2.973	2.324	2.077
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		9	

12 Dec 1989

FTIF:/PATTERNING/CENTERFIRE_PATT/08340830.1

CENTERFIRE PATTERNS # 5

POA

1 in circle

2 in circle

3 in circle

OF SHOTS= 10

IN CIR

1 in = 1

2 in = 7

3 in = 10

HC= 2.368

VS= 2.033

GS= 2.000

CENTROID *

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.473	.928	.861
MINIMUM X	-.895	-.731	-.798
MAXIMUM Y	.953	.946	.810
MINIMUM Y	-1.088	-1.087	-.885
CENTROID X	-.017	-.181	-.114
CENTROID Y	.243	.250	.385
POA TO CENTROID in.	.243	.308	.402
MIN RADIUS	.381	.499	.553
MEAN RADIUS	.904	.834	.773
MAX RADIUS	1.474	1.211	.985
HORIZONTAL SPREAD	2.368	1.659	1.659
VERTICAL SPREAD	2.033	2.033	1.696
EXTREME SPREAD	2.399	2.041	1.818
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	10		