

G 659 0130
Replaced
C-664 9210

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: RE00133020

Serial: C6649210 Model M24 SWS Center Fire
Caliber: 7.62 NATO

Repairman:

Verify Repair

High Priority

Status:

Closed 8/22/2007 7:13:53 AM

Address Information

Customer:

Received From

Return To:

Received From

Name: TRANSPORTATION OFFICER

TRANSPORTATION OFFICER

Address 1: XR WOK8 USA ROCK ISL ARSENAL

XR WOK8 USA ROCK ISL ARSENAL

Address 2: BLDG 299 GILLESPIE AVE BECK

PO Box:

BLDG 299 GILLESPIE AVE BECK

PO Box:

City: ROCK ISLAND

ROCK ISLAND

State: IL

Zip Code: 61299

Country: US

State: IL

Zip Code: 61299

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
A017	Scope Base	1
A057	Fit and Rear Sgt Base	1

Repair Search

Refresh

Close

naglej

8/22/2007

7:53 AM

CAPS

NUM

INS

SCRL



Inbox - Micr...

Calendar - M...

FW: Restrict...

Arms Service...

7:53 AM

G6590130 (New)

Serial Number: ~~C6649210~~

Model: M24 SWS



RE00133020

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6590130.__0
FILE DATE AND TIME: 09/21/2007 13:10

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.031
The Average Y Centroid of the Five Target Set:	0.006
The Average Point of Impact of the Five Target Set:	0.031
The Average Mean Radius of the Five Target Set:	0.755
The Distance from POA to Centroid Target #1:	0.107
The Distance from Centroid Target #2 to Centroid Target #1:	0.038
The Distance from Centroid Target #3 to Centroid Target #1:	0.116
The Distance from Centroid Target #4 to Centroid Target #1:	0.260
The Distance from Centroid Target #5 to Centroid Target #1:	0.304

BARBER - M24 0165130

SERIAL NUMBER: G6590130. 0

TARGET NUMBER: 1

FILE DATE: 09/21/2007

FILE TIME: 13:10

POINT#	X	Y
1:	0.013	0.552
2:	-0.532	0.548
3:	-0.549	0.181
4:	-0.980	-0.247
5:	0.171	-0.207
6:	0.416	-0.358
7:	0.332	-0.686
8:	1.120	0.122
9:	0.745	-0.019
10:	-0.581	1.169

X CENTROID: 0.015

Y CENTROID: 0.105

POA TO CENTROID: 0.107

HORZ SPREAD: 2.100

VERT SPREAD: 1.855

GROUP SPREAD: 2.068

MIN RADIUS: 0.349

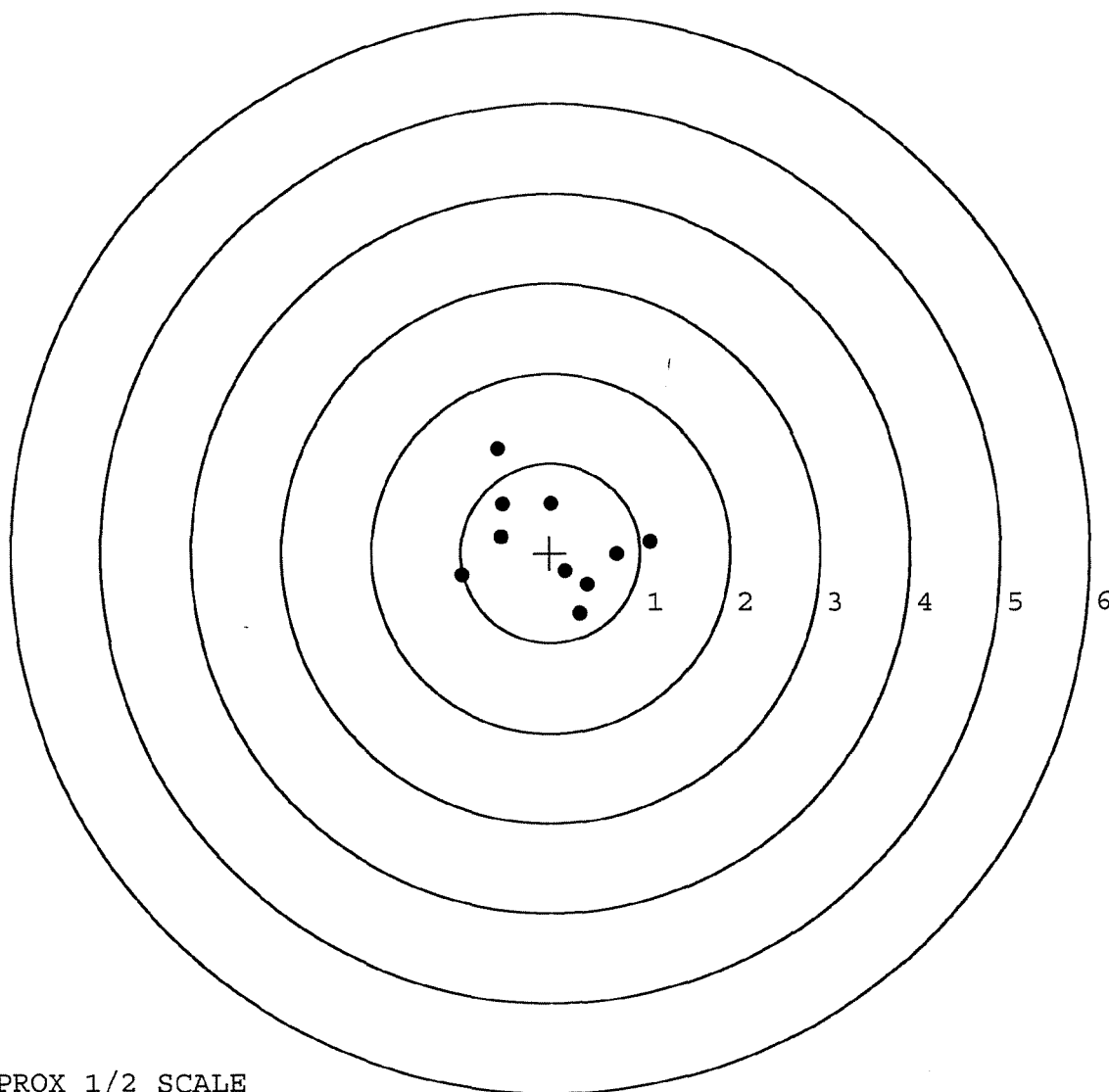
MAX RADIUS: 1.219

MEAN RADIUS: 0.765

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

BARBER - M24 0165131

SERIAL NUMBER: G6590130. __0

TARGET NUMBER: 2

FILE DATE: 09/21/2007

FILE TIME: 13:10

POINT#	X	Y
1:	0.416	1.041
2:	-0.471	0.793
3:	-0.788	0.630
4:	0.818	-0.751
5:	0.491	-0.523
6:	0.785	0.176
7:	0.435	-0.032
8:	-0.065	0.023
9:	-0.356	-0.106
10:	-0.740	-0.288

X CENTROID: 0.052

Y CENTROID: 0.096

POA TO CENTROID: 0.110

HORZ SPREAD: 1.606

VERT SPREAD: 1.792

GROUP SPREAD: 2.118

MIN RADIUS: 0.138

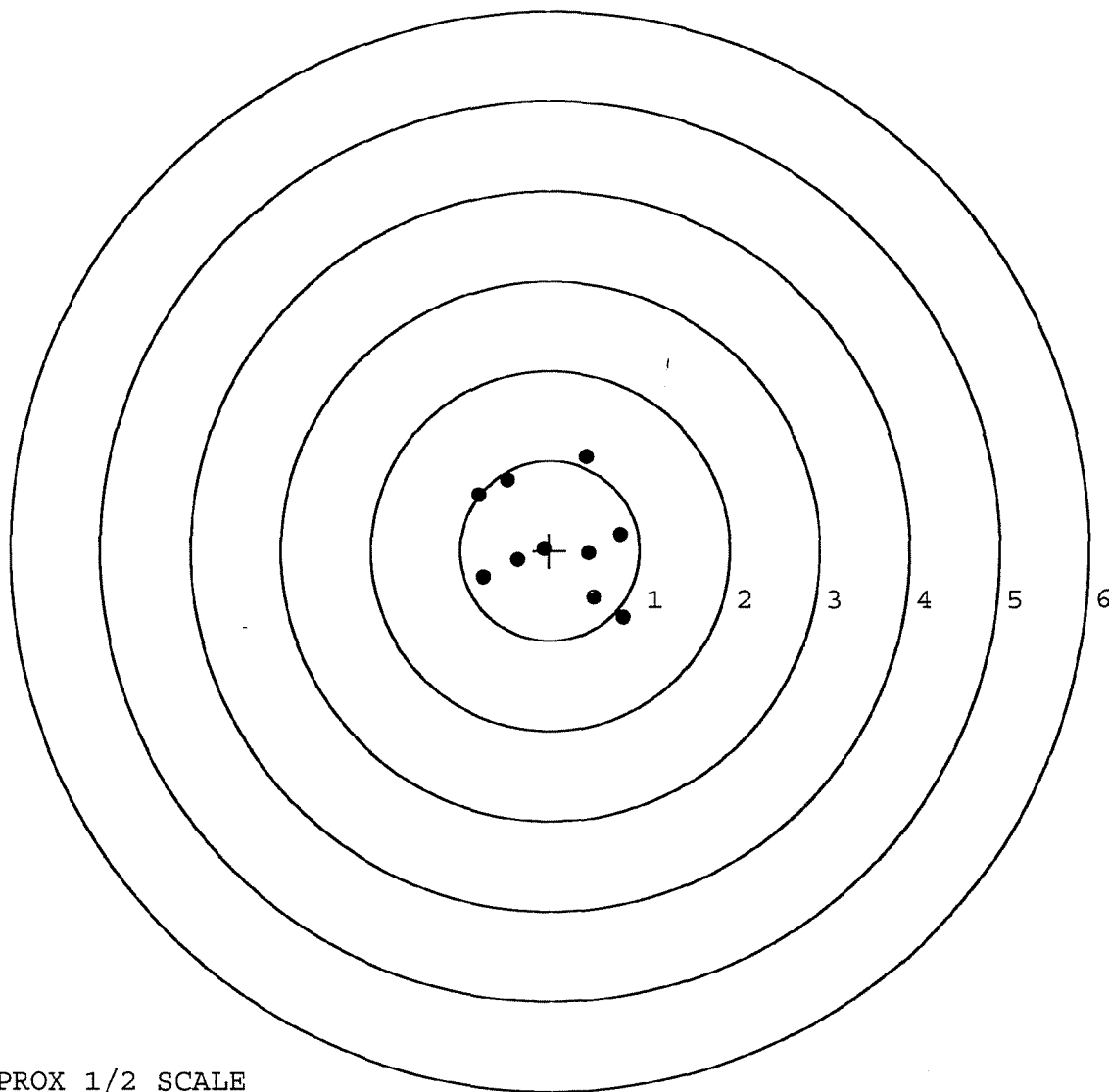
MAX RADIUS: 1.142

MEAN RADIUS: 0.740

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10



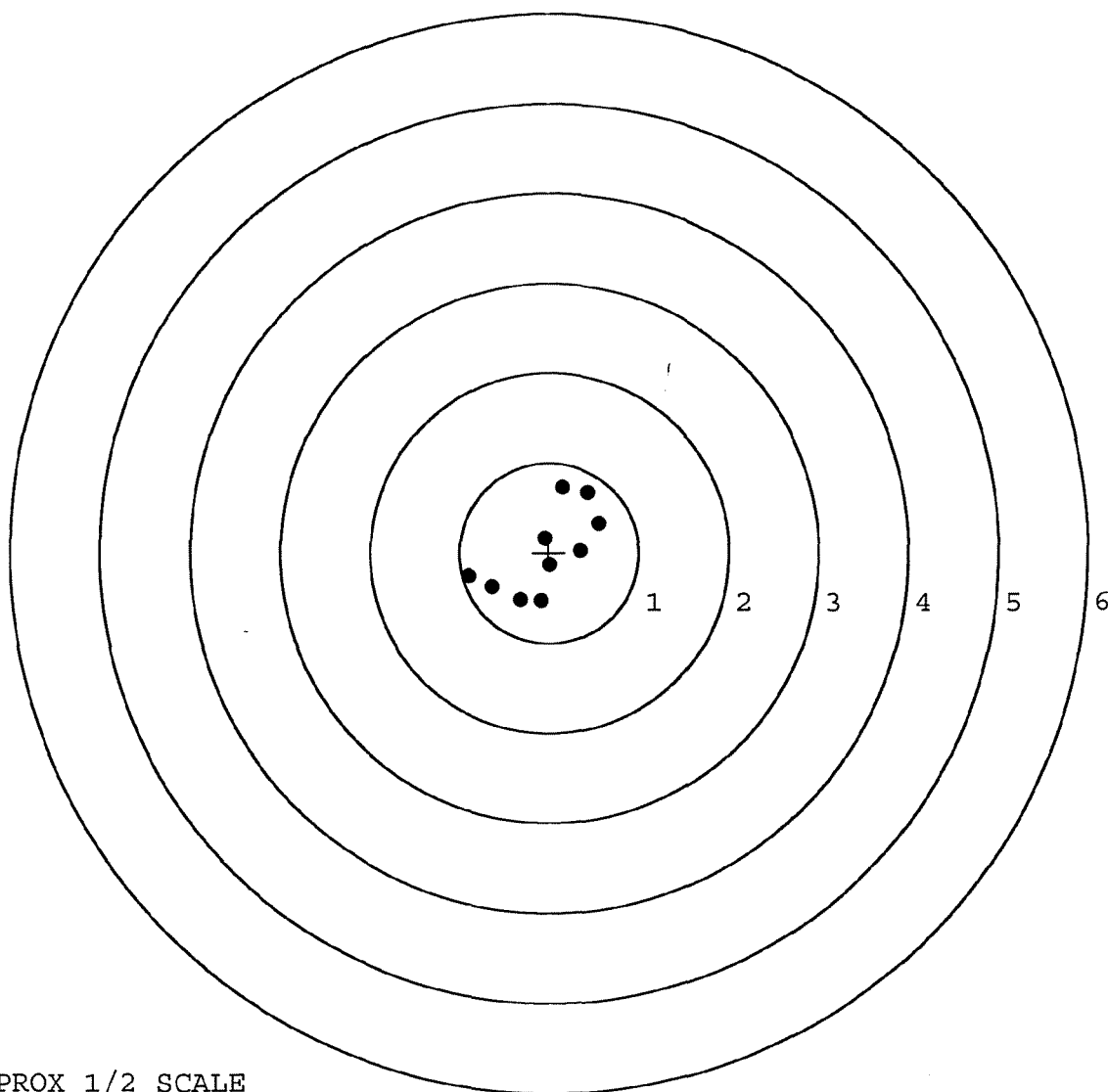
TARGET APPROX 1/2 SCALE

BARBER - M24 0165132

SERIAL NUMBER: G6590130. __0
 TARGET NUMBER: 3
 FILE DATE: 09/21/2007
 FILE TIME: 13:10

POINT#	X	Y
1:	0.156	0.720
2:	0.439	0.672
3:	0.558	0.328
4:	0.354	0.028
5:	-0.044	0.164
6:	0.012	-0.135
7:	-0.090	-0.535
8:	-0.326	-0.525
9:	-0.634	-0.377
10:	-0.894	-0.257

X CENTROID: -0.047
 Y CENTROID: 0.008
 POA TO CENTROID: 0.048
 HORZ SPREAD: 1.452
 VERT SPREAD: 1.255
 GROUP SPREAD: 1.625
 MIN RADIUS: 0.155
 MAX RADIUS: 0.888
 MEAN RADIUS: 0.570
 # IN 1 IN DIAMETER: 3
 # IN 2 IN DIAMETER: 10
 # in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

BARBER - M24 0165133

SERIAL NUMBER: G6590130. __0

TARGET NUMBER: 4

FILE DATE: 09/21/2007

FILE TIME: 13:10

POINT#	X	Y
1:	-0.883	1.209
2:	0.153	0.736
3:	0.086	0.068
4:	0.645	0.311
5:	1.096	0.144
6:	0.888	-0.873
7:	0.327	-1.784
8:	-0.261	-0.597
9:	-0.657	-0.591
10:	-0.600	-0.088

X CENTROID: 0.079

Y CENTROID: -0.147

POA TO CENTROID: 0.167

HORZ SPREAD: 1.979

VERT SPREAD: 2.993

GROUP SPREAD: 3.228

MIN RADIUS: 0.215

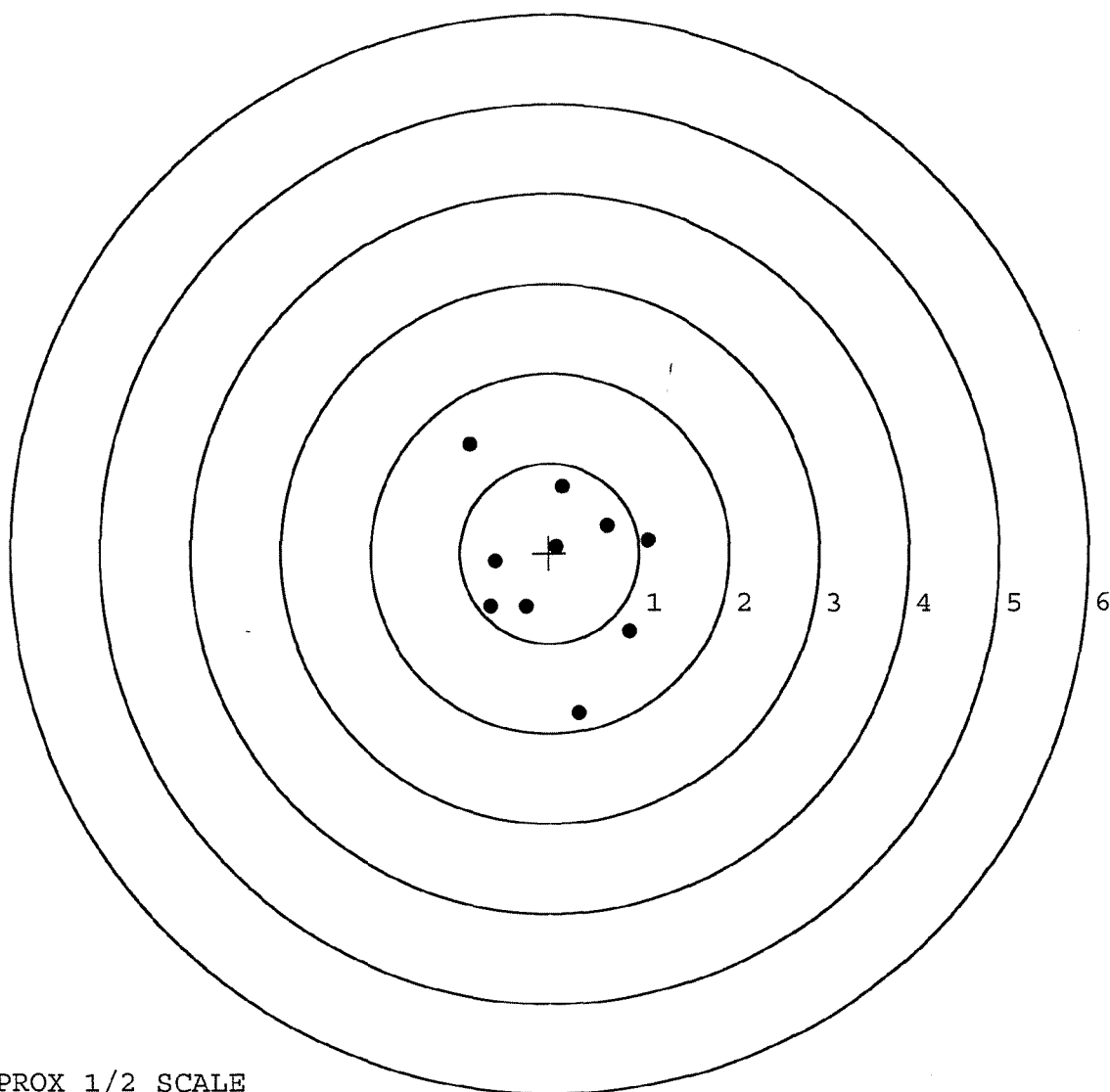
MAX RADIUS: 1.662

MEAN RADIUS: 0.940

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 8



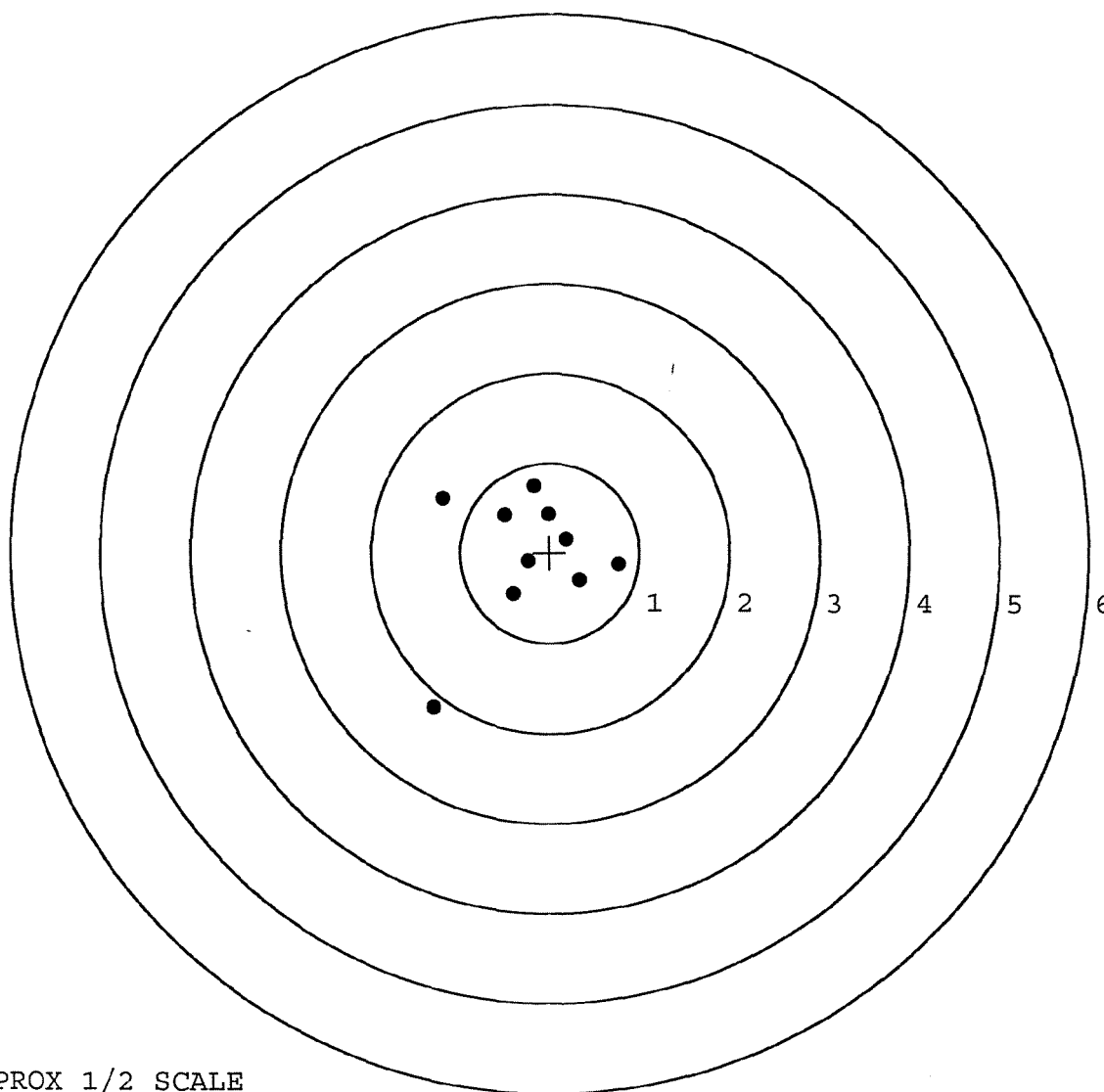
TARGET APPROX 1/2 SCALE

BARBER - M24 0165134

SERIAL NUMBER: G6590130. __0
 TARGET NUMBER: 5
 FILE DATE: 09/21/2007
 FILE TIME: 13:10

POINT#	X	Y
1:	-1.198	0.613
2:	-0.176	0.743
3:	-0.506	0.420
4:	-0.020	0.430
5:	0.186	0.159
6:	0.772	-0.130
7:	0.339	-0.304
8:	-0.243	-0.097
9:	-0.407	-0.454
10:	-1.296	-1.707

X CENTROID: -0.255
 Y CENTROID: -0.033
 POA TO CENTROID: 0.257
 HORZ SPREAD: 2.068
 VERT SPREAD: 2.450
 GROUP SPREAD: 2.694
 MIN RADIUS: 0.065
 MAX RADIUS: 1.972
 MEAN RADIUS: 0.761
 # IN 1 IN DIAMETER: 3
 # IN 2 IN DIAMETER: 7
 # in 3 IN DIAMETER: 9

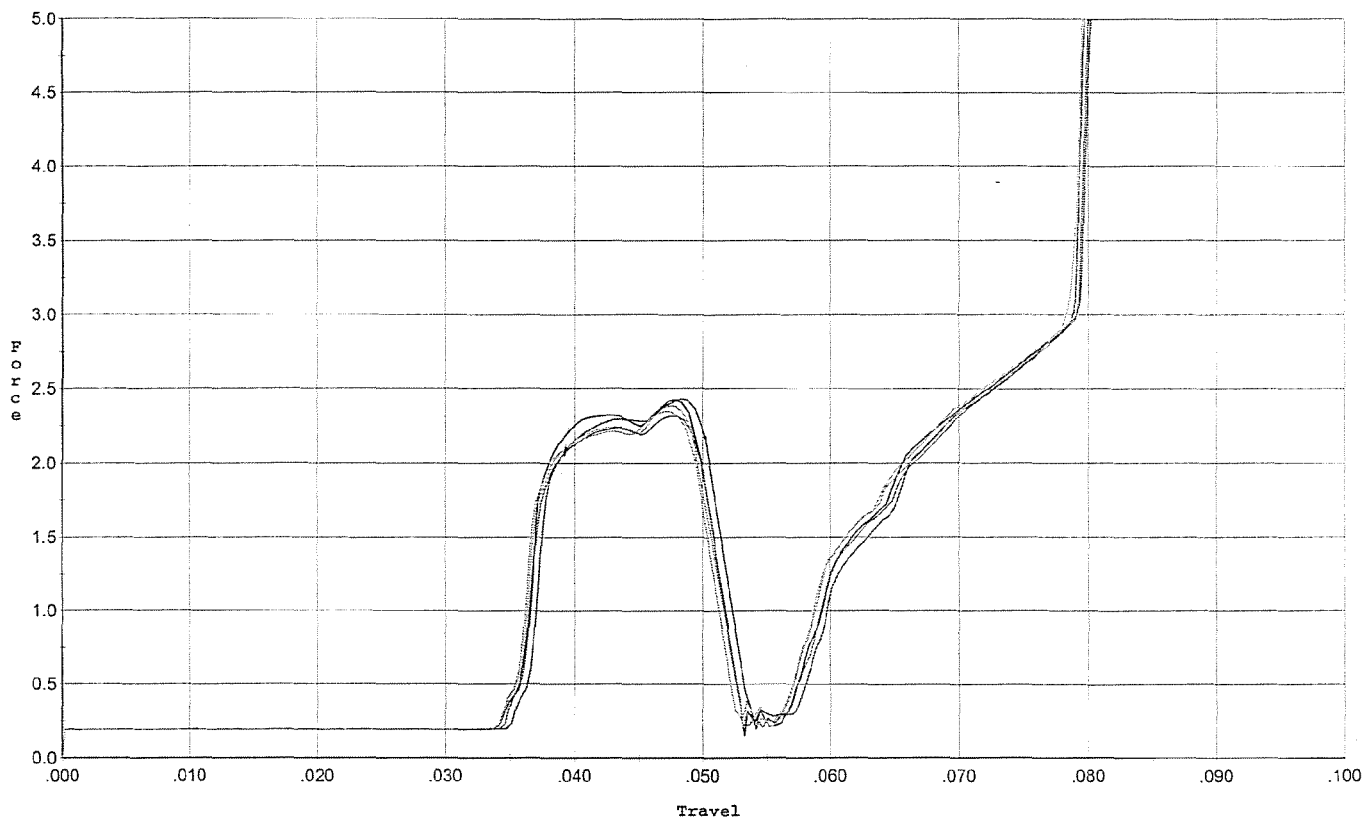


TARGET APPROX 1/2 SCALE

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 9/8/07

Model: M/24
 Serial No: Form #F005
 Trigger: 2.5 lbs. ini. +/- .50 lbs.



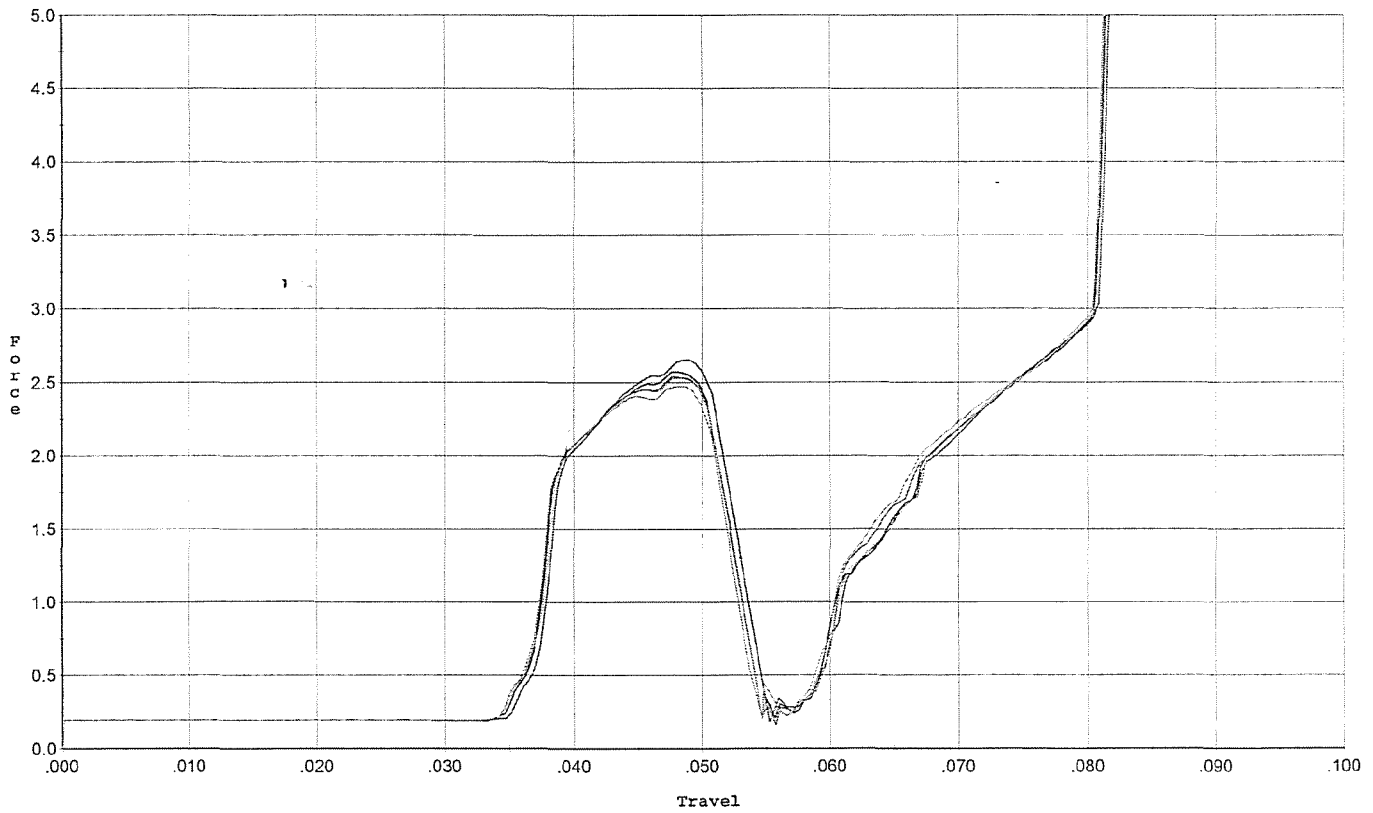
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.431	0.050	0.035	0.036	0.038		Set Trigger
2	2.427	0.050	0.035	0.036	0.039		Set Trigger
3	2.318	0.050	0.035	0.036	0.037		Set Trigger
4	2.347	0.049	0.034	0.036	0.037		Set Trigger
5	2.383	0.051	0.035	0.036	0.039		Set Trigger

Avg 2.38

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 9/8/07

Model: M/24
 Serial No: Form #F005
 Trigger: 2.5 lbs. after 50 cycles +/- .50 lbs.



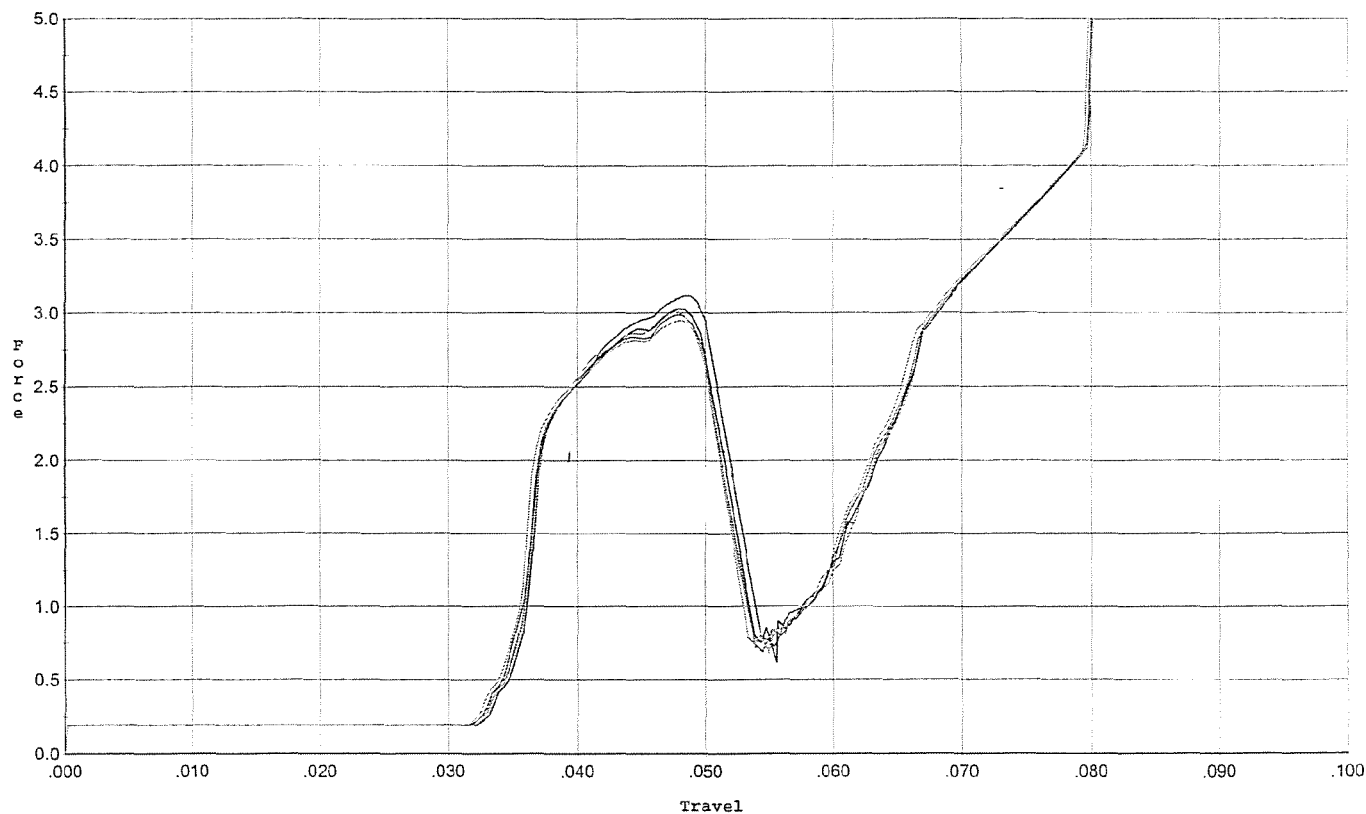
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.654	0.053	0.036	0.036	0.042		Set Trigger
2	2.572	0.052	0.035	0.036	0.041		Set Trigger
3	2.539	0.052	0.035	0.036	0.041		Set Trigger
4	2.536	0.052	0.035	0.036	0.041		Set Trigger
5	2.474	0.051	0.035	0.036	0.040		Set Trigger

AVG 2.55

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 9/8/07

Model: M/24
Serial No: Form #F005
Trigger: 3.0 lbs. ini. +/- .75 lbs.



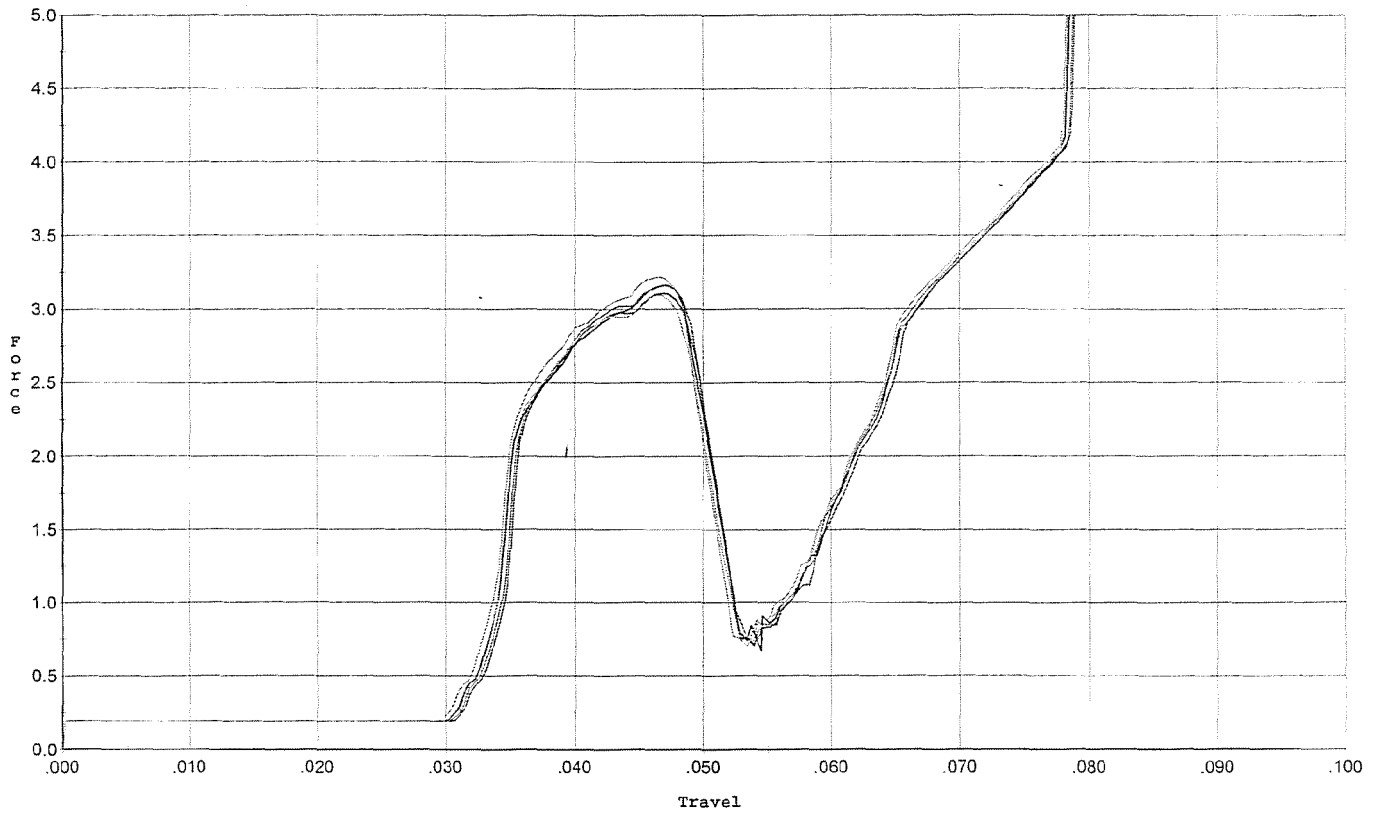
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.115	0.052	0.033	0.034	0.051		Set Trigger
2	3.028	0.051	0.033	0.035	0.049		Set Trigger
3	2.990	0.050	0.033	0.035	0.047		Set Trigger
4	2.950	0.050	0.033	0.035	0.046		Set Trigger
5	3.006	0.050	0.033	0.035	0.048		Set Trigger

Avg 3.01

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 9/8/07

Model: M/24
 Serial No: Form #F005
 Trigger: 3.0 lbs. after 20 cycles +/- .75 lbs.



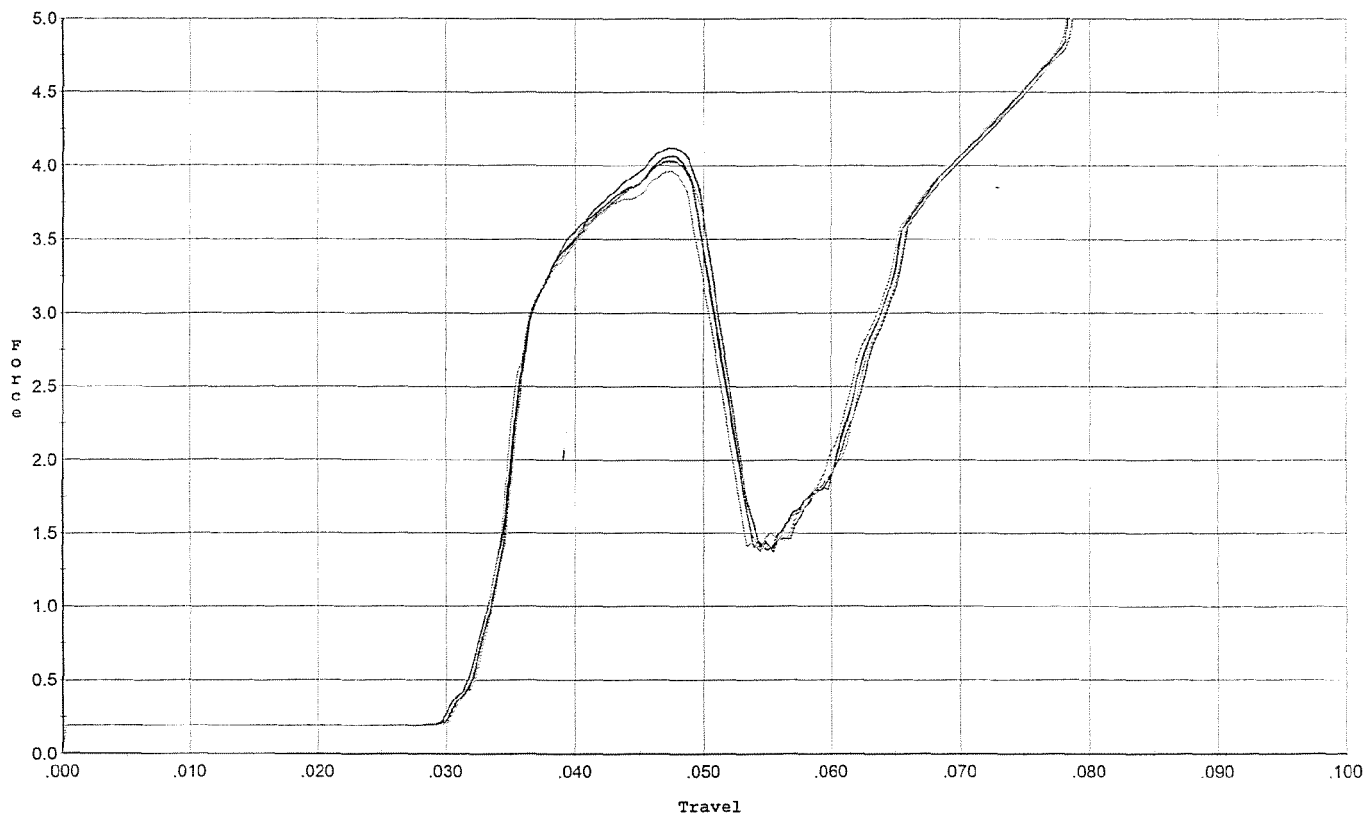
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.109	0.049	0.032	0.034	0.050		Set Trigger
2	3.166	0.050	0.031	0.034	0.052		Set Trigger
3	3.164	0.049	0.031	0.034	0.051		Set Trigger
4	3.096	0.049	0.031	0.034	0.050		Set Trigger
5	3.219	0.048	0.031	0.034	0.051		Set Trigger

Avg 3.15

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: R. Putch 9/8/07

Model: M/24
Serial No: Form #F005
Trigger: 4.0 lbs. ini. +/- 1.0 lbs.



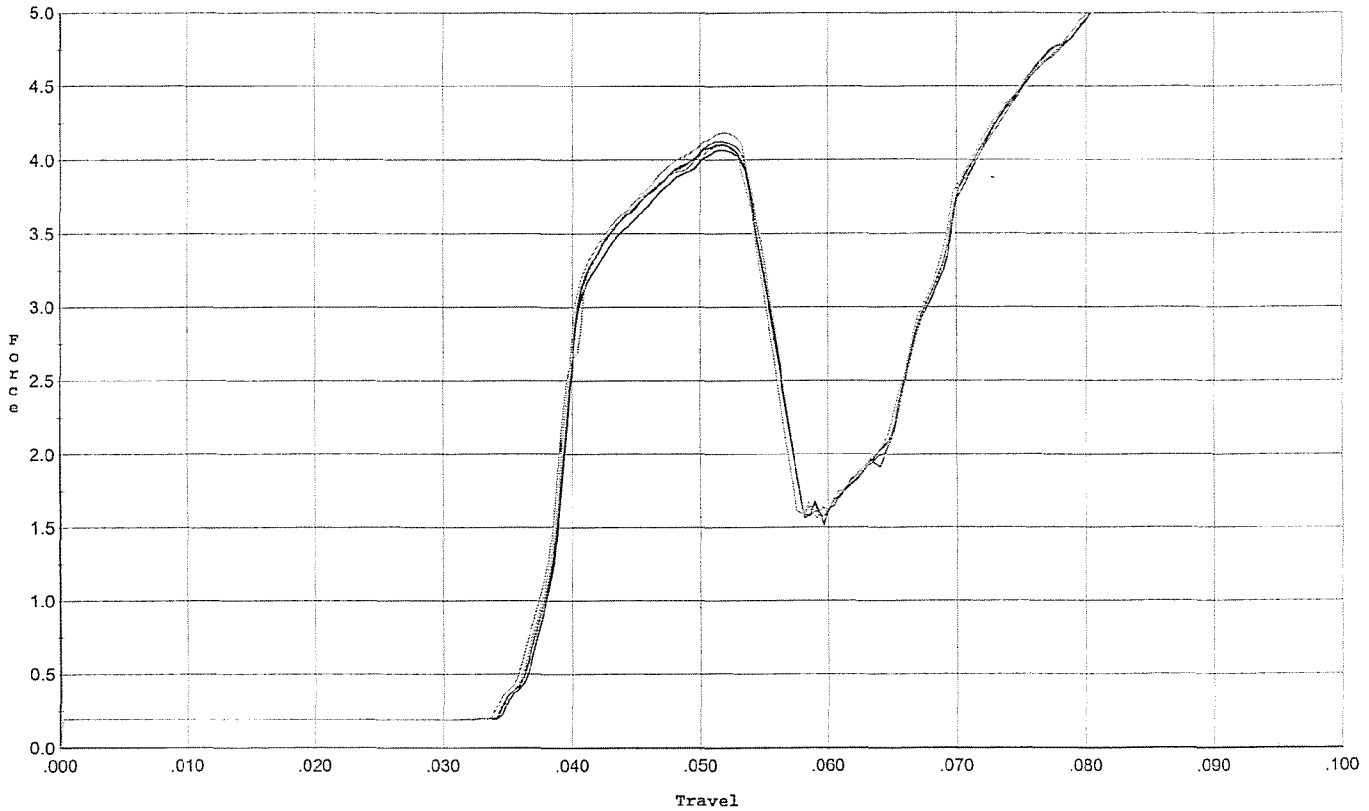
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.120	0.050	0.031	0.032	0.067		Set Trigger
2	4.062	0.049	0.030	0.032	0.065		Set Trigger
3	4.034	0.051	0.031	0.032	0.068		Set Trigger
4	4.025	0.050	0.031	0.032	0.066		Set Trigger
5	3.966	0.051	0.031	0.032	0.066		Set Trigger

AVG 4.04

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 9/8/07

Model: M/24
 Serial No: Form #F005
 Trigger: 4.0 lbs. after 20 cycles +/- 1.0 lbs.



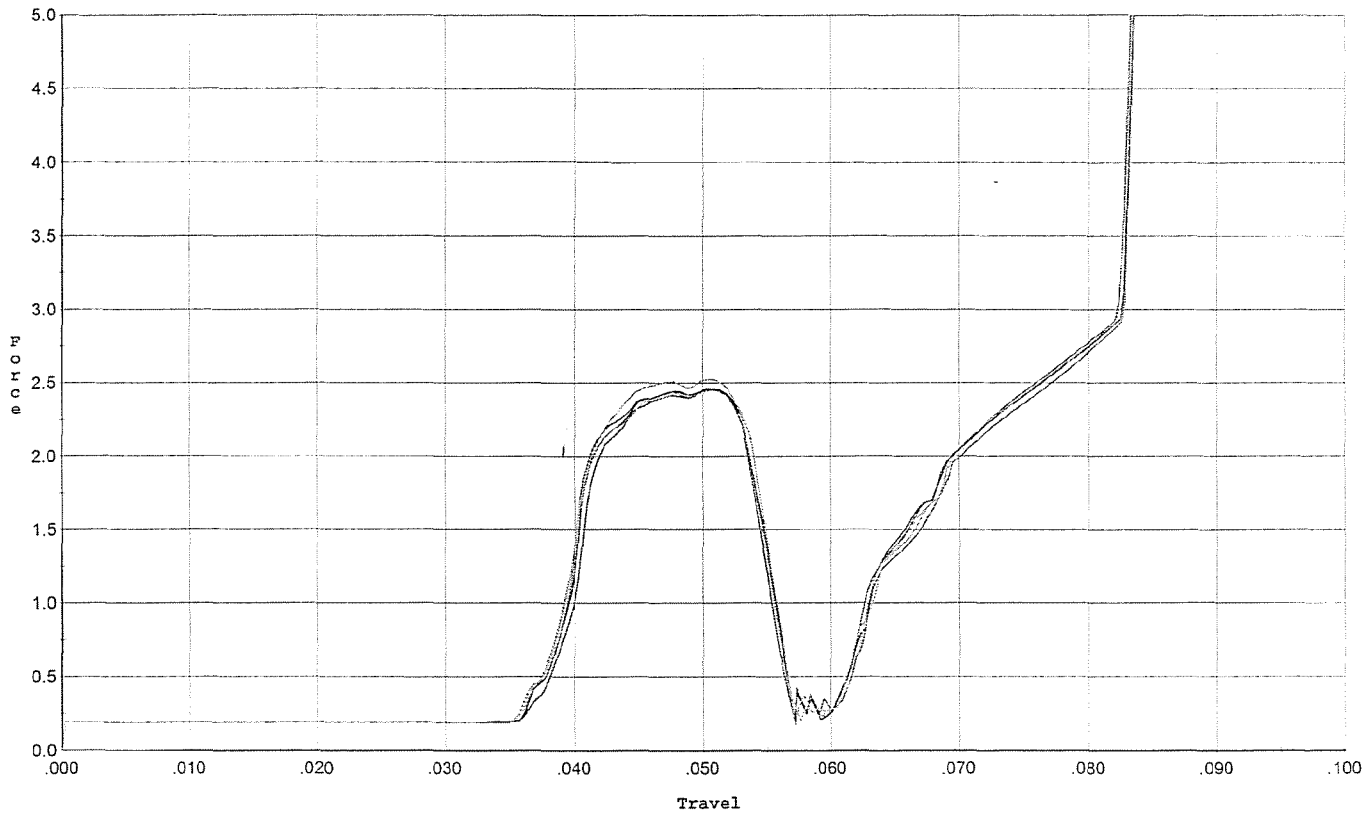
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.104	0.056	0.035	0.032	0.071		Set Trigger
2	4.066	0.055	0.035	0.032	0.070		Set Trigger
3	4.127	0.055	0.035	0.032	0.071		Set Trigger
4	4.182	0.055	0.035	0.032	0.072		Set Trigger
5	4.097	0.054	0.034	0.032	0.069		Set Trigger

AVG 4.11

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 9/8/07

Model: M/24
 Serial No: Form #F005
 Trigger: reset to 2.5 lbs. +/- .50 lbs. for final test



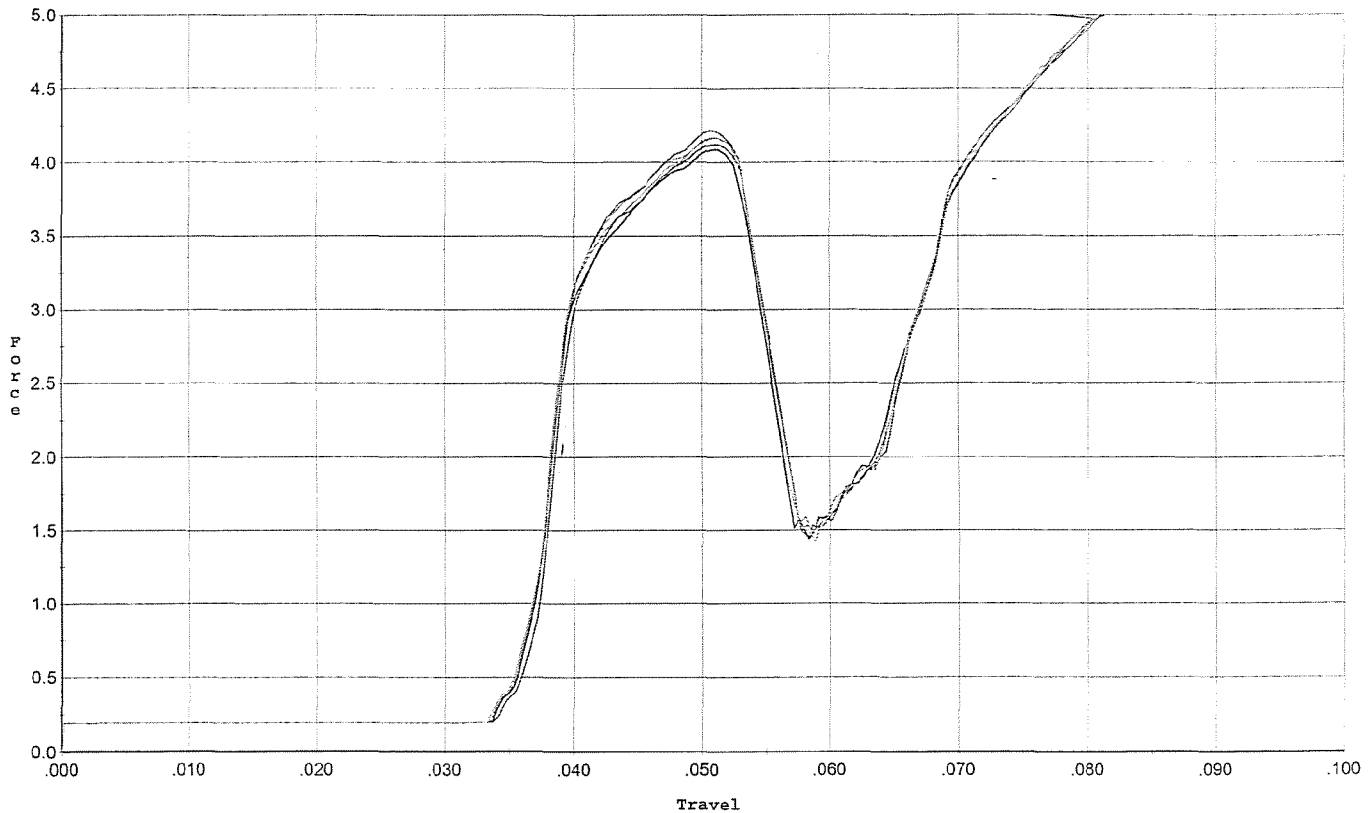
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.458	0.053	0.037	0.036	0.040		Set Trigger
2	2.458	0.055	0.036	0.036	0.043		Set Trigger
3	2.458	0.055	0.036	0.036	0.043		Set Trigger
4	2.460	0.054	0.036	0.036	0.043		Set Trigger
5	2.525	0.053	0.036	0.036	0.042		Set Trigger

Avg 2.47

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putsch 9/8/07

Model: M/24
 Serial No: Form #F005
 Trigger: set to 4.0 lbs. +/- 1.0 lbs. for target & accuracy



#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.121	0.053	0.035	0.033	0.068		Set Trigger
2	4.085	0.054	0.034	0.032	0.069		Set Trigger
3	4.212	0.055	0.034	0.032	0.074		Set Trigger
4	4.167	0.053	0.034	0.033	0.070		Set Trigger
5	4.165	0.053	0.034	0.032	0.070		Set Trigger

Avg 4.15

R & E NUMBER

133020

SERIAL NUMBER

C6649210

C659013 (New)

LOG-IN DATE

8-22-07

OPERATION #	OPERATION NAME	DATE	INITIAL
500	DIS-ASSEMBLE GUN	9-10-07	RTZ
505	RE-BARREL	9-11-07	LR
560	ASSEMBLE	9-11-07	RTZ
600	PROOF	9-12-07	TRW
605	CHECK HEADSPACE	9-12-07	TRW
610	DIS-ASSEMBLE GUN	9-12-07	RTZ
612	MAGNAFLUX	9-13-07	JB
510	DRILL AND TAP	9-12-07	FM
615	ROLLMARK CALIBER	9-12-07	CW
618	ROTO-BLAST	9-12-07	PG
620	APPLY COATINGS	9-14-07	RB
625	FINAL ASSEMBLY	9-20-07	RTZ
640	FUNCTION TEST AND	(PASS) FAIL	9-21-07 TRW
650	TARGET	(PASS) FAIL	9-21-07 TRW
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
670	FINAL INSPECTION		9-21-07 DR
	A) HEADSPACE	(PASS) FAIL	9-21-07 TRW
	B) TRIGGER PULL	2.43 2.43 2.34 2.36 2.30 9-21-07	DA
680	F) SAFETY ON FORCE	5.5 5.5 5.5 9-21-07	DA
	G) SAFETY OFF FORCE	3.5 3.5 3.5 9-21-07	DA
	I) FIRING PIN INDENT	.024 .024 .0235 9-21-07	DA
690	PACK	9-24-07	DA

Remington		DU PONT REG. U.S. PAT. & TM. OFF.	VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.
MODEL 700™ M24		SERIAL NO. C6649210	
		20	ORDER NO. 5716
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat & Tm. Off, Marca Registrada Marque Deposee.			



5716 C6649210

ORDER 5716
MODEL 700™ M24
UPC



0 47700 25716 7

ORDER 5716
MODEL 700™ M24
UPC



0 47700 25716 7

GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6649210

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	10 1	9 1	RW
600	Proof	10 1	9 1	RW
607	Check Headspace	10 1	9 1	RW
610	Dis-assemble Gun	10 1	9 1	RW
612	Magnaflux Barrel Action		OCT 10 1991	KR
	Magnaflux Bolt		OCT 10 1991	KR
615	Rollmark Caliber		OCT 10 1991	JS
617	Drill and Tap Sight Holes		OCT 10 1991	LB
618	Polish Barrel		10/15/91	WB
620	Apply Coatings (Barrel Action)		11/25/91	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		11/11/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		11/14/91	RW
	C) Inspect Ejector Hole for Chamfer		11/14/91	RW
	D) Oil Firing Pin Ass'y		11/14/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		12/30/91	WB

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4 1/4	4 1/4	4 1/4			12/31/91	WB
	G) Safety Off Force	2 1/2	2 1/2	2 1/2			12/31/91	WB
	H) Trigger Pull Test & Retainability						12/30/91	WB
	I) Firing Pin Indent	.0215	.0215	.0215			12/31/91	WB
	J) Assemble Stock						1/2/92	RW
	K) Assemble Swivel Studs						1-3-92	JH
	L) Attach Front and Rear Sight Assemblies						1/2/92	RW
	M) Iron Sight Alignment						1/2/92	RW
	N) Detach Front & Rear Sights & place in numbered container						1/2/92	RW
	O) Attach Scope to Rifle						1/2/92	RW
	P) Detach & Attach Scope 20 Times						1/2/92	RW
640	Gallery Target & Test						1-3-92	AC
	A) Time						1-3-92	AC
	B) Malfunctions						1-3-92	AC
	C) Pierced Primers						1-3-92	AC
	D) Optical Clarity of Scope						1-3-92	AC
645	Inspect for Live Ammo						1-3-92	AC
655	Final Inspection							
	A) Headspace						1-3-92	JH
	B) Trigger Pull	238	238	236	238	235	1-3-92	DH
	C) Function						1-3-92	JH
660	Pack						2-25-92	W

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6649210
3 Jan 1992

CENTROIDAL DISTANCES

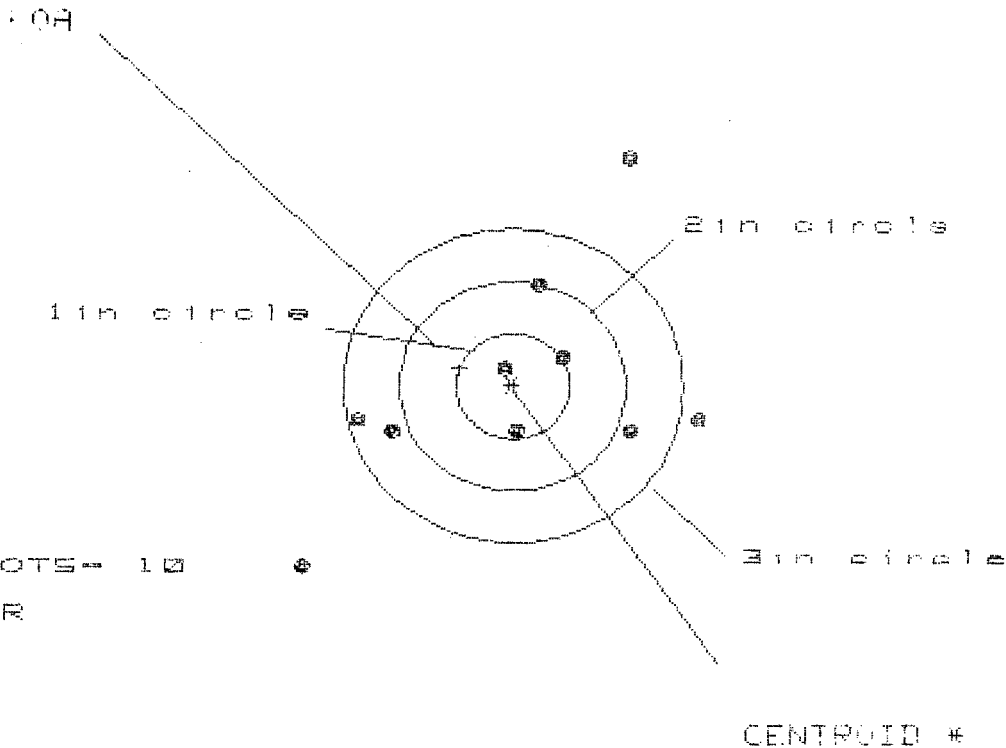
0 TO	1	.500707
1 TO	2	.145527
1 TO	3	.385576
1 TO	4	.844361
1 TO	5	.18813

4 #215 <-----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .2366
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.129
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .269402
THE SCORE FOR THIS RIFLE IS: 1.098

FILE:/PATTERNING/CENTERFIRE_PATT/06649210

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1in = 3

2in = 3

3in = 7

HS= 3.532

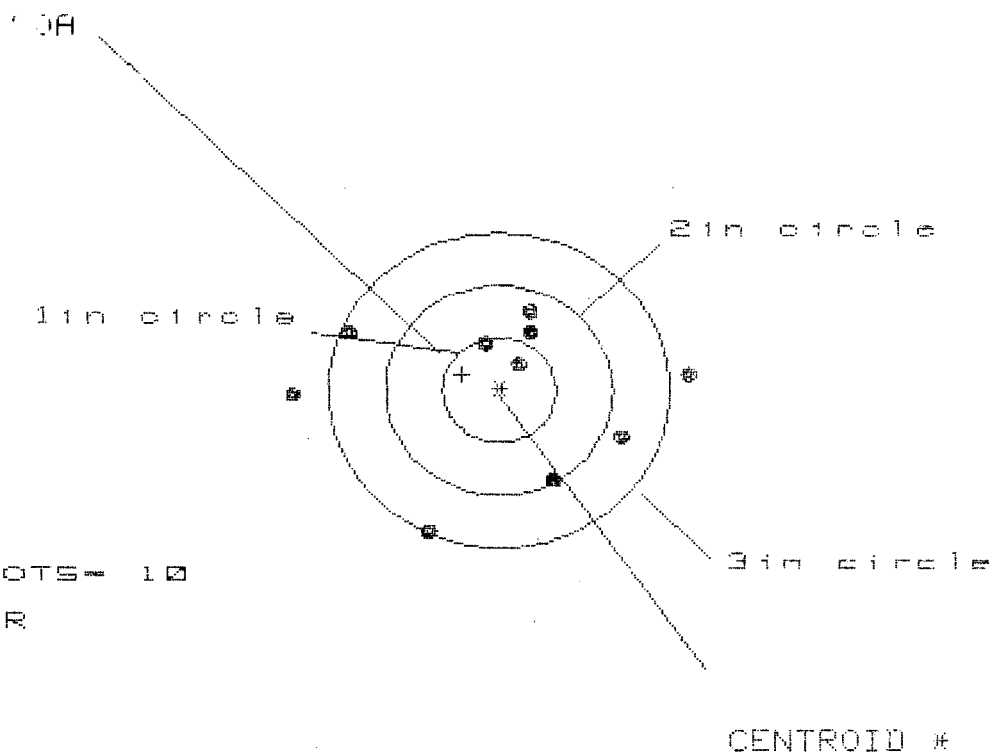
VS= 3.970

GS= 4.893

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.669	1.463	1.562
MINIMUM X	-1.863	-1.607	-1.509
MAXIMUM Y	2.227	2.033	1.048
MINIMUM Y	-1.743	-1.655	-1.401
CENTROID X	.468	.674	.576
CENTROID Y	-.178	.016	-.208
CHORD CENTROID IN.	.500	.675	.623
MAX SPREAD	.228	.227	.327
MIN SPREAD	1.253	1.086	.938
MAX SPREAD	2.551	2.182	1.586
MIN SPREAD	3.532	3.070	3.070
MAX SPREAD	3.970	2.688	1.449
MIN SPREAD	4.893	3.506	3.070
1 INCH CIRCLE	= 3		
2 INCH CIRCLE	= 3		
3 INCH CIRCLE	= 7		

FILE:/PATTERNING/CENTERFIRE_PATT/C6649210

CENTERFIRE PATTERNS # 2

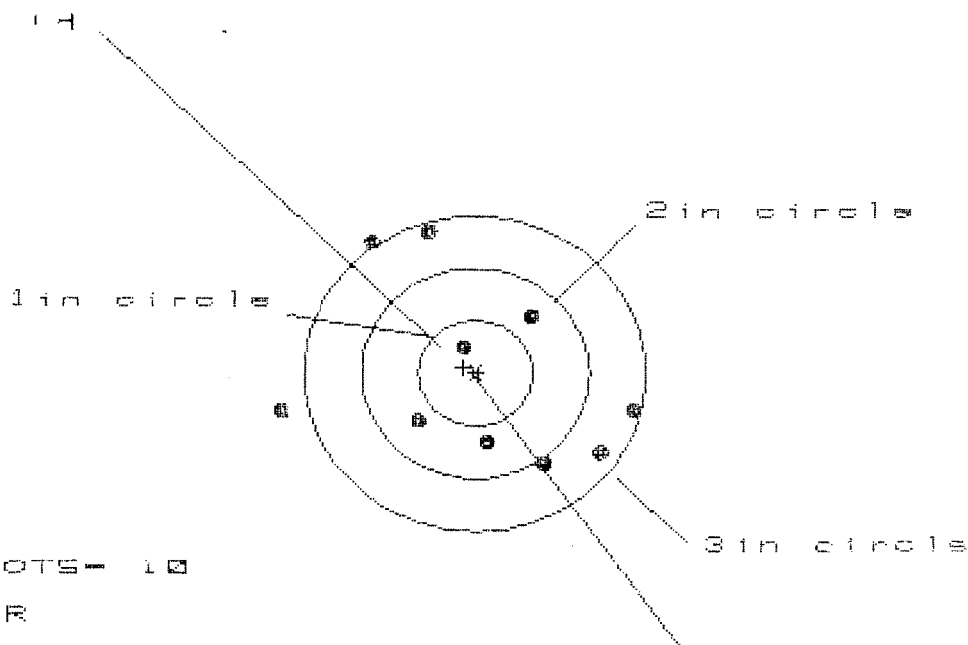


OF SHOTS- 10
IN CIR
1in = 2
2in = 5
3in = 8
HS= 3.436
VS= 2.115
GS= 3.443

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.626	1.425	1.006
MINIMUM X	:	-1.810	-1.501	-1.323
MAXIMUM Y	:	.770	.760	.774
MINIMUM Y	:	-1.345	-1.355	-1.341
CENTROID X	:	.325	.526	.348
CENTROID Y	:	-.151	-.141	-.155
1 INCH CENTROID IN.	:	.358	.544	.380
2 INCH CENTROID	:	.289	.233	.280
3 INCH CENTROID	:	1.062	.950	.895
1 INCH G.S.	:	1.812	1.579	1.481
2 INCH G.S.	:	3.436	2.926	2.328
3 INCH G.S.	:	2.115	2.115	2.115
4 INCH G.S.	:	3.443	2.950	2.500
1 INCH CIRCLE	=		2	
2 INCH CIRCLE	=		5	
3 INCH CIRCLE	=		8	

FILE:/PATTERNING/CENTERFIRE_PATT/06849210

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 1

2in = 4

3in = 8

HS= 3.125

VS= 2.157

GS= 3.125

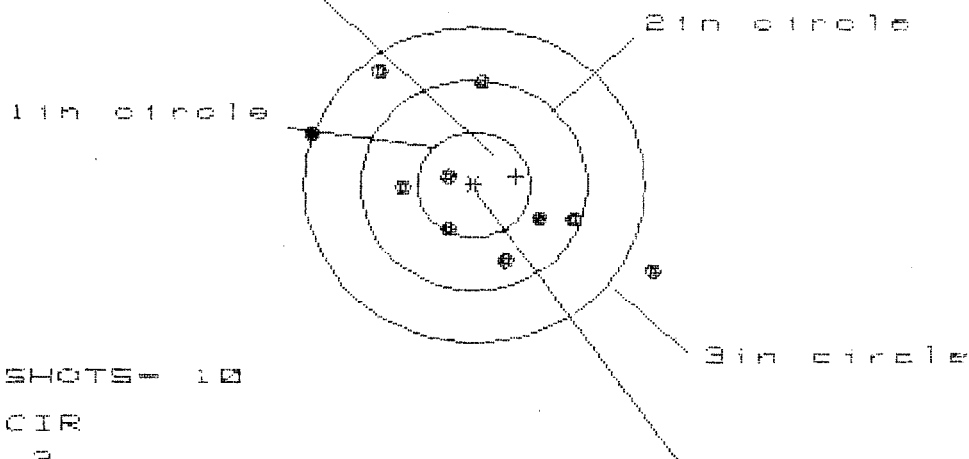
CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.405	1.214	1.075
MINIMUM X	:	-1.720	-1.109	-.856
MAXIMUM Y	:	1.321	1.276	1.430
MINIMUM Y	:	-.836	-.881	-.727
CENTROID X	:	.105	.296	.435
CENTROID Y	:	-.048	-.003	-.157
MAXIMUM ENVELOPE IN.	:	.116	.296	.463
MINIMUM ENVELOPE	:	.248	.332	.535
MAXIMUM ENVELOPE	:	1.088	1.005	.906
MINIMUM ENVELOPE	:	1.766	1.656	1.526
MAXIMUM ENVELOPE	:	3.125	2.323	1.931
MINIMUM ENVELOPE	:	2.157	2.157	2.157
MAXIMUM ENVELOPE	:	3.125	2.845	2.572
1 INCH CIRCLE	=	1		
2 INCH CIRCLE	=	4		
3 INCH CIRCLE	=	8		

FILE:/PATTERNING/CENTERFIRE_PATT/06649210

CENTERFIRE PATTERNS

4



OF SHOTS= 10

IN CIR

1in = 2

2in = 7

3in = 8

HS= 3.045

VS= 1.917

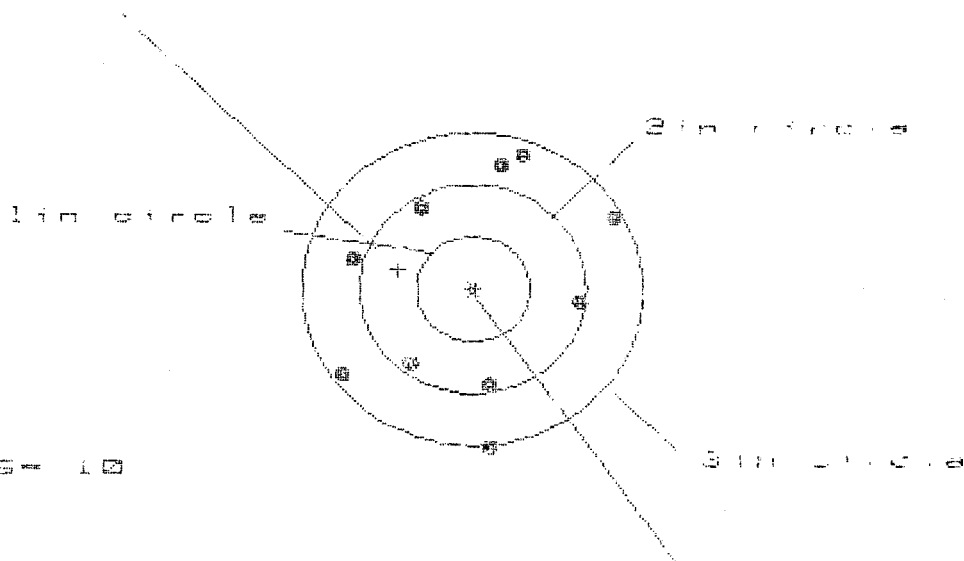
GS= 3.287

CENTROID *

PATTERN #	:	4		
10 IS (BEST OF)	:	10	9	8
1- INCH	:	1.601	1.031	.873
2- INCH	:	-1.444	-1.266	-.880
3- INCH	:	1.125	1.037	1.082
4- INCH	:	-.792	-.784	-.739
5- INCH	:	-.371	-.549	-.391
6- INCH	:	-.083	.005	-.040
7- INCH	:	.081	.549	.393
8- INCH	:	.240	.060	.213
9- INCH	:	.919	.803	.739
10- INCH	:	1.787	1.315	1.345
11- INCH	:	3.045	2.297	1.673
12- INCH	:	1.917	1.821	1.821
13- INCH	:	3.287	2.435	2.238
14- INCH	:			
15- INCH	:			
16- INCH	:			
17- INCH	:			
18- INCH	:			
19- INCH	:			
20- INCH	:			
21- INCH	:			
22- INCH	:			
23- INCH	:			
24- INCH	:			
25- INCH	:			
26- INCH	:			
27- INCH	:			
28- INCH	:			
29- INCH	:			
30- INCH	:			
31- INCH	:			
32- INCH	:			
33- INCH	:			
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45- INCH	:			
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63- INCH	:			
64- INCH	:			
65- INCH	:			
66- INCH	:			
67- INCH	:			
68- INCH	:			
69- INCH	:			
70- INCH	:			
71- INCH	:			
72- INCH	:			
73- INCH	:			
74- INCH	:			
75- INCH	:			
76- INCH	:			
77- INCH	:			
78- INCH	:			
79- INCH	:			
80- INCH	:			
81- INCH	:			
82- INCH	:			
83- INCH	:			
84- INCH	:			
85- INCH	:			
86- INCH	:			
87- INCH	:			
88- INCH	:			
89- INCH	:			
90- INCH	:			
91- INCH	:			
92- INCH	:			
93- INCH	:			
94- INCH	:			
95- INCH	:			
96- INCH	:			
97- INCH	:			
98- INCH	:			
99- INCH	:			
100- INCH	:			

FILE: PATTERNING/CENTERFIRE_PATT/C8649210

CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1 in = 0

2 in = 4

3 in = 9

1st = 2.400

2nd = 2.792

3rd = 2.811

CENTER #

FILE

5

OF

10

9

8

1.284

1.384

1.132

-1.117

-1.096

-0.938

1.235

1.062

1.126

-1.557

-1.128

-1.064

.656

.636

.473

-1.185

-1.012

-1.070

.682

.636

.479

.876

.732

.697

1.168

1.111

1.058

1.568

1.454

1.291

2.400

2.408

2.064

2.792

2.190

2.190

2.811

2.811

2.811

FILE

0

1st

4

2nd

9

SWS TRIGGER PULL TEST

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

SERIAL NO. C6649210
DATE 12/30/91
TESTER WB

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.44	2.28	2.37	2.38	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.47	2.27	2.28	2.38	
PULL #3	2.37	2.32	2.32	2.36	
PULL #4	2.46	2.26	2.31	2.38	
PULL #5	2.41	2.24	2.35	2.35	
TOTAL	12.15	11.37	11.63		
AVG.	2.43	2.27	2.33		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.05	3.07		
PULL #2	3.08	3.06		
PULL #3	3.07	3.05		
PULL #4	3.00	3.06		
PULL #5	3.09	3.00		
TOTAL	15.29	15.24		
AVG.	3.06	3.05		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.03	4.07		4.14
PULL #2	4.05	4.00		4.15
PULL #3	4.06	3.93		4.19
PULL #4	4.07	4.00		4.18
PULL #5	4.05	4.05		4.16
TOTAL	20.26	20.05		20.82
AVG.	4.05	4.01		4.16

GUN SERIAL # C6649102

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	7 2 9 1		RW
600	Proof	7 2 9 1		RW
607	Check Headspace	7 2 9 1		RW
610	Dis-assemble Gun	7 2 9 1		RW
612	Magnaflux Barrel Action		JUL 22 1991	GS
	Magnaflux Bolt		JUL 22 1991	GS
615	Rollmark Caliber		JUL 22 1991	GS
617	Drill and Tap Sight Holes		JUL 22 1991	LB
618	Polish Barrel		7/28/91	WB
620	Apply Coatings (Barrel Action)		7-8-91	LB
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		8/9/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/9/91	RW
	C) Inspect Ejector Hole for Chamfer		8/9/91	RW
	D) Oil Firing Pin Ass'y		8/9/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		8/21/91	JS

BARBER - M24 0165155		READINGS					DATE	INIT
op. #	OP. NAME							
625 cont.	F) Safety On Force	5	5	5	5	5	8/21/91	JK
	G) Safety Off Force	4	4	4	4	4	8/21/91	JK
	H) Trigger Pull Test & Retainability						8/21/91	JK
	I) Firing Pin Indent	.022	.023	.0235			8/21/91	JK
	J) Assemble Stock						8/21/91	RW
	K) Assemble Swivel Studs							
	L) Attach Front and Rear Sight Assemblies						8/21/91	RW
	M) Iron Sight Alignment						8/21/91	RW
	N) Detach Front & Rear Sights & place in numbered container						8/21/91	RW
	O) Attach Scope to Rifle						8/21/91	RW
	P) Detach & Attach Scope 20 Times						8/21/91	RW
640	Gallery Target & Test						8-22-91	NF
	A) Time						"	NF
	B) Malfunctions						"	NF
	C) Pierced Primers						"	NF
	D) Optical Clarity of Scope						"	NF
645	Inspect for Live Ammo						8-22-91	NF
655	Final Inspection						8-23-91	DH
	A) Headspace							
	B) Trigger Pull	2.17	2.19	2.16	2.29	2.26	8-23-91	JK
	C) Function						8-23-91	DH
660	Pack							

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

SERIAL NO C-6649102
DATE 8/21/91
TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.55	2.39	2.54	2.17	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.55	2.46	2.50	2.19	
PULL #3	2.56	2.43	2.48	2.16	
PULL #4	2.60	2.54	2.44	2.29	
PULL #5	2.49	2.49	2.46	2.26	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.59	3.53		
PULL #2	3.29	3.48		
PULL #3	3.49	3.46		
PULL #4	3.52	3.48		
PULL #5	3.25	3.49		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.41	4.28		4.60
PULL #2	4.28	4.48		4.61
PULL #3	4.49	4.56		4.25
PULL #4	4.57	4.62		4.64
PULL #5	4.54	4.48		4.65
TOTAL				
AVG.				

SWS ENDURANCE TEST REPORT

SERIAL NO. CGG49102 SHOOTER RON QUAYLE DATE 8-26-91

AMMO CODE	AMMO TYPE	RDS.	RESULTS	OBSERVATIONS
7.62	60		OK	OK TARGET + test
7.62	60		OK	OK
7.62	60		OK	OK
7.62	60		OK	OK
7.62	60		OK	OK
7.62	60		OK	OK
7.62	60		OK	OK
7.62	20		OK	OK
	440			
7.62	60		test and target	Aug 29, 1991 AC
	500			
7.62	60		OK	OK
7.62	60		OK	OK
	620		OK	8-27-91
7.62	60		OK	None
7.62	60		OK	None
7.62	60		OK	None
7.62	60		OK	None
7.62	60		OK	None
7.62	60		OK	None
7.62	60		OK	None
TOTAL	1040			
7.62	60		OK	None

SWS ENDURANCE TEST REPORT

SERIAL NO. C6649102 SHOOTER RON GUAYLE DATE 8/29/91

AMMO CODE	AMMO TYPE	RDS.	RESULTS	OBSERVATIONS
	7.62	60	OK	None
	7.62	60	OK	None
	7.62	60	OK	None
	7.62	60	OK	None
	7.62	60	OK	None
	7.62	60	OK	None
TOTAL Done 1460			AS OF 8/29/91	
	7.62	60	OK	None
	7.62	60	OK	None
	7.62	60	OK	None
	7.62	60	OK	None
	7.62	60	OK	None
	7.62	60	OK	None
	7.62	60	OK	None
TOTAL 1880			AS OF 8/30/91	
	7.62	60	OK	None
	7.62	60	OK	None
	7.62	60	OK	None
	7.62	60	OK	None
	7.62	60	OK	None
	7.62	60	OK	None

SWS ENDURANCE TEST REPORT

 SERIAL NO. C6649102 SHOOTER W. Teichert DATE 9/3/91

AMMO CODE	AMMO TYPE	RDS.	RESULTS	OBSERVATIONS
	7.62	60	OK	None
	7.62	60	OK	None
	7.62	60	OK	None
	7.62	20	OK	None
560	Total	2440	as of 1st shift	9-3-91
	7.62	60	OK	None
	total	2500	as of 9/3/91	
	7.62	60	OK	None 9-4-91
	7.62	60	OK	None
	Total	2620	— 9-4-91	
	7.62	60	OK	None
	7.62	60	OK	None
	7.62	60	OK	None
	7.62	60	OK	None
	7.62	60	OK	None
	7.62	60	OK	None
	7.62	60	OK	None
	7.62	60	OK	None
	Total	3100	End of 2nd shift -	9/4/91

SWS ENDURANCE TEST REPORT

SERIAL NO. C6648102 SHOOTER W. T. Searcy DATE 8-5-91

AMMO CODE	AMMO TYPE	RDS.	RESULTS	OBSERVATIONS
	7.62	60	OK	OK Test
	7.62	60	OK	OK test ^{extensive drops}
	7.62	60	OK	OK test " ^{shell}
	7.62	60	OK	OK Test " ^{at times}
	7.62	60	OK	OK test "
	7.62	60	OK	OK test "
360	total	<u>3460</u>		
	7.62	60	OK	OK test - (E.D.S.) ^{at times}
	7.62	60	OK	OK test
	7.62	60	OK	OK test - (E.D.S. at times)
	7.62	60	OK	OK test - (" " ")
	7.62	60	OK	OK test - (" " ")
	7.62	60	OK	OK test - (" " ")
	7.62	60	OK	OK test - (" " ")
	7.62	20	OK	OK test
440	total	<u>3900</u>	End of 2 nd shift -	9-5-91
	7.62	60	OK	OK test Replaced Extra
	7.62	60	OK	OK test @ 3900 rds
	7.62	60	OK	OK test ^{grip}
	7.62	60	OK	OK test
	7.62	60	OK	OK test

SWS ENDURANCE TEST REPORT

SERIAL NO. C6649102 SHOOTER W Teichert DATE 9-6-91

AMMO CODE	AMMO TYPE	RDS.	RESULTS	OBSERVATIONS
	7.62	60	OK	OK test
	7.62	60	OK	OK test
420	7.62 4320			W-7 9/6/91
	7.62	60	OK	OK test
	7.62	60	OK	OK test
	7.62	60	OK	OK test
	Total	4500	as of 9/6/91	
	7.62	4560	+++ OK	12+
	7.62	60	OK	OK test
	7.62	60	OK	OK test
	7.62	60	OK	OK test
	7.62	60	OK	OK test
	Total	4800	End of 2 nd shift	9-6-91
	7.62	60	OK	none
	7.62	60	OK	none
	7.62	20	OK	none
	TOTAL	4940		
	9-7-91	60	DP target & test	
		5000	TOTAL	Magnapuff
	7.62	60	OK	none
	7.62	60	OK	OK test
	7.62	60	OK	OK test

SWS ENDURANCE TEST REPORT

SERIAL NO. C6649102 SHOOTER K. Connell DATE 9-9-91

AMMO CODE	AMMO TYPE	RDS.	RESULTS	OBSERVATIONS
	7.62	60	ok	ok test
	7.62	60	ok	ok test
	7.62	60	ok	ok test
	7.62	60	ok	ok test
	7.62	60	ok	ok test
	7.62	60	ok	ok test
	7.62	60	ok	ok test
	7.62	60	ok	ok test
	7.62	60	ok	ok test
	7.62	60	ok	ok test
	7.62	60	ok	ok test
	7.62	60	ok	ok test
900	Total	5900	as of End 2 nd shift	9-9-91
	7.62	60	ok	ok test
	7.62	60	ok	ok test
	7.62	60	ok	ok test
	7.62	60	ok	ok test
	7.62	60	ok	ok test
	7.62	60	ok	ok test
	7.62	60	ok	ok test
	7.62	60	ok	ok test
540	7.62	60	ok	ok test
		6440	1st shift	9-10-91

SWS ENDURANCE TEST REPORT

SERIAL NO. C 6649102 SHOOTER Kevin Carroll DATE 9-10-91

AMMO CODE	AMMO TYPE	RDS.	RESULTS	OBSERVATIONS
	7.62	60	ok	ok test
	7.62	60	ok	ok test
	7.62	60	ok	ok test
	7.62	60	ok	ok test
	7.62	60	ok	ok test
	7.62	60	ok	ok test
	7.62	60	ok	ok test
	7.62	60	ok	ok test
	7.62	60	ok	ok test
	7.62	60	ok	ok test
	7.62	60	ok	ok test
	7.62	60	ok	ok test
	7.62	60	ok	ok test
	7.62	60	ok	ok test
	7.62	60	ok	ok test
	7.62	40	ok	ok test
880	Total	7320	End 2 nd shift	9-10-91
	7.62	60	ok	ok test
	7.62	60	ok	ok test
	7.62	60	ok	ok test
180		7500	1st shift	9/11/91

SWS ENDURANCE TEST REPORT

 SERIAL NO. C6649102 SHOOTER K. Connell DATE 9/11/91

AMMO CODE	AMMO TYPE	RDS.	RESULTS	OBSERVATIONS
	7.62	60	OK	OK test
	7.62	60	OK	OK test
	7.62	60	OK	OK test
	7.62	60	OK	OK test
	7.62	60	OK	OK test
	7.62	60	OK	OK test
	7.62	60	OK	OK test
	7.62	60	OK	OK test
	7.62	60	OK	OK test
	7.62	60	OK	OK test
600		8100	end 1st shift	9/11/91
	7.62	60	OK	OK test
	7.62	60	OK	OK test
	7.62	60	OK	OK test
	7.62	60	OK	OK test
	7.62	60	OK	OK test
	7.62	60	OK	OK test
	7.62	60	OK	OK test
	7.62	60	OK	OK test
	7.62	60	OK	OK test
	7.62	60	OK	OK test
	7.62	60	OK	OK test
	7.62	60	OK	OK test

SWS ENDURANCE TEST REPORT

SERIAL NO. C6649102 SHOOTER K. O'Connell DATE 9/11/91

AMMO CODE	AMMO TYPE	RDS.	RESULTS	OBSERVATIONS
	7.62	60	ok	ok test
	7.62	60	ok	ok test
	7.62	<u>60</u>	ok	ok test
840	Total	8940	End 2 nd shift -	9/11/91
	7.62	60	ok	ok test
	7.62	60	ok	ok test
	7.62	60	ok	ok test
	7.62	60	ok	ok test
	7.62	60	ok	ok test
	7.62	60	ok	ok test
	7.62	60	ok	ok test
	7.62	60	ok	ok test
	7.62	60	ok	ok test
	7.62	60	ok	ok test
	7.62	60	ok	ok test
	7.62	<u>60</u>	ok	ok test
660	Total	9600	End 2 nd shift -	9/12/91
	7.62	60	ok	ok test
	7.62	60	ok	ok test
	7.62	60	ok	ok test
	7.62	60	ok	ok test
	7.62	60	ok	ok test
	7.62	60	ok	ok test
	7.62	<u>40</u>	ok	ok test
400		10,000	completed 9/13/91	1st shift

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06649102
22 Aug 1991

0 RDS

CENTROIDAL DISTANCES

0 TO	1	.337085
1 TO	2	.509245
1 TO	3	.179536
1 TO	4	.405031
1 TO	5	.193313

219 <----POB

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0988
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.057
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .114063

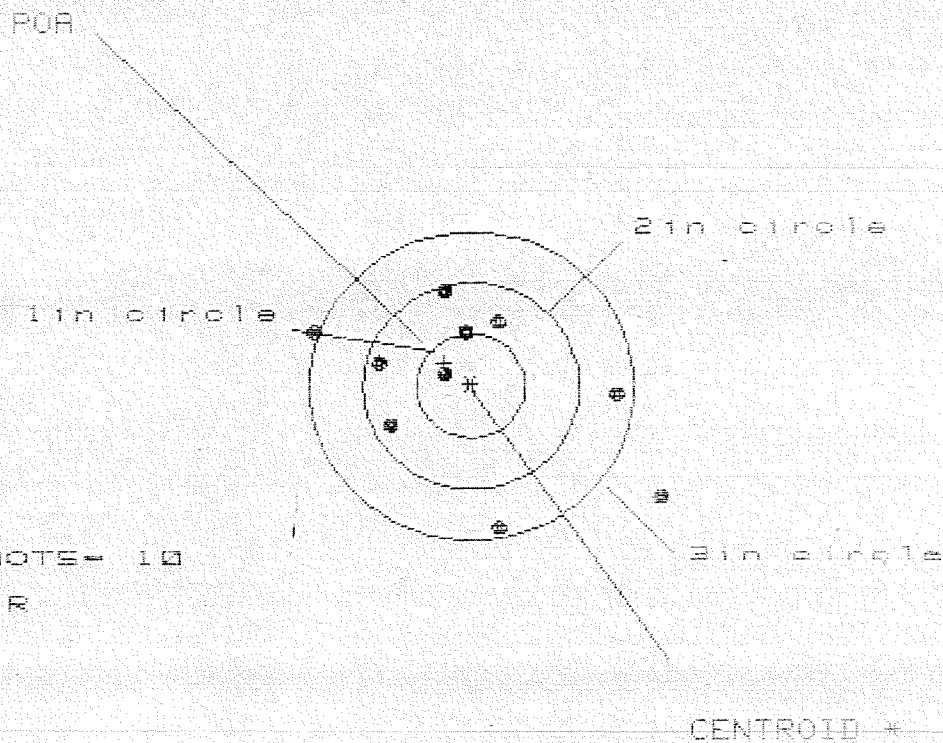
THE AMR FOR THIS RIFLE IS: .9628

28 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6549102

KUS

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1in = 2

2in = 6

3in = 8

HS = 3.169

VS = 2.248

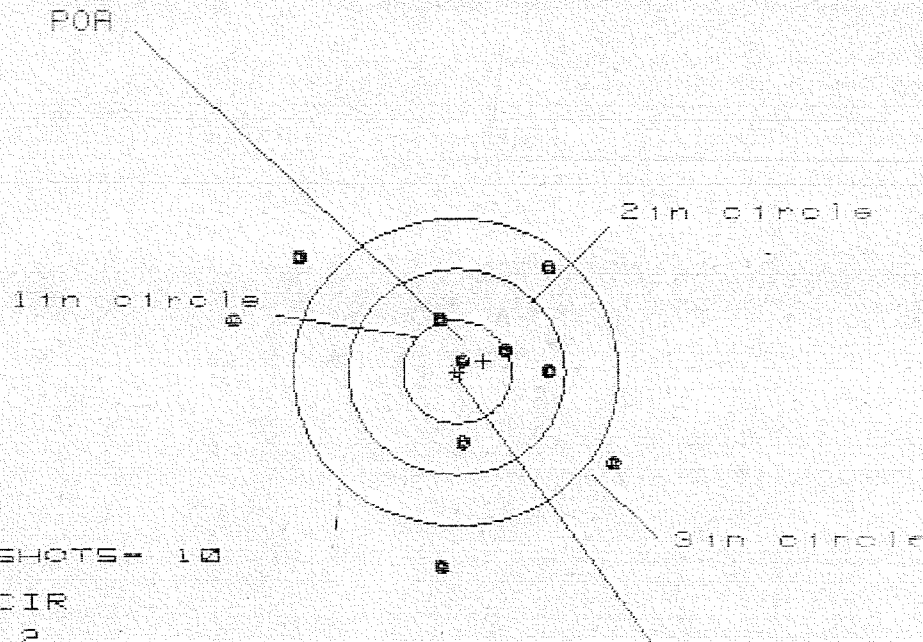
GS = 3.566

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.738	1.512	1.357
MINIMUM X	-1.431	-1.238	-1.821
MAXIMUM Y	.880	.759	.811
MINIMUM Y	-1.367	-1.489	-1.437
CENTROID X	.251	.058	.213
CENTROID Y	-.225	-.104	-.156
POA TO CENTROID in.	.338	.119	.264
MIN RADIUS	.262	.033	.196
MEAN RADIUS	1.034	.848	.820
MAX RADIUS	2.055	1.559	1.469
HORIZONTAL SPREAD	3.169	2.750	2.178
VERTICAL SPREAD	2.248	2.248	2.248
EXTREME SPREAD	3.566	2.818	2.316
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	8		

22 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08649102

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 6

CENTROID *

HS= 3.477

VS= 2.928

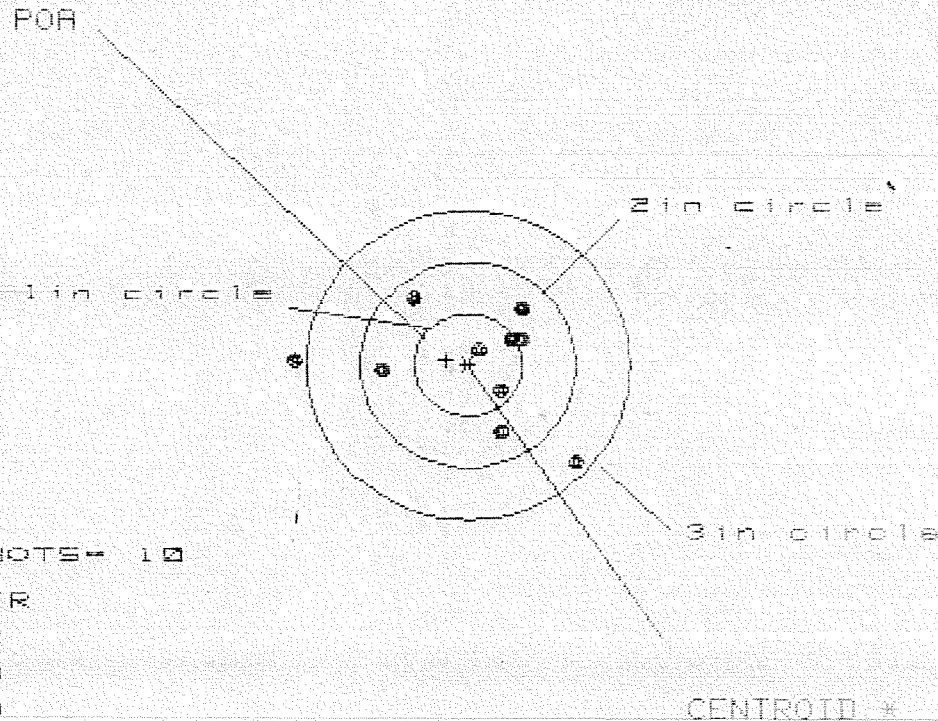
GS= 3.747

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.463	1.239	1.195
MINIMUM X	:	-2.014	-1.704	-1.748
MAXIMUM Y	:	1.064	1.118	.891
MINIMUM Y	:	-1.864	-1.810	-1.083
CENTROID X	:	-.246	-.022	.022
CENTROID Y	:	-.114	-.168	.059
POA TO CENTROID in.	:	.271	.169	.063
MIN RADIUS	:	.124	.194	.160
MEAN RADIUS	:	1.155	1.023	.880
MAX RADIUS	:	2.072	2.037	1.962
HORIZONTAL SPREAD	:	3.477	2.943	2.943
VERTICAL SPREAD	:	2.928	2.928	1.974
EXTREME SPREAD	:	3.747	3.544	3.544
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		6	

22 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8649102

CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1 in = 2

2 in = 8

3 in = 9

HS = 2.591

VS = 1.539

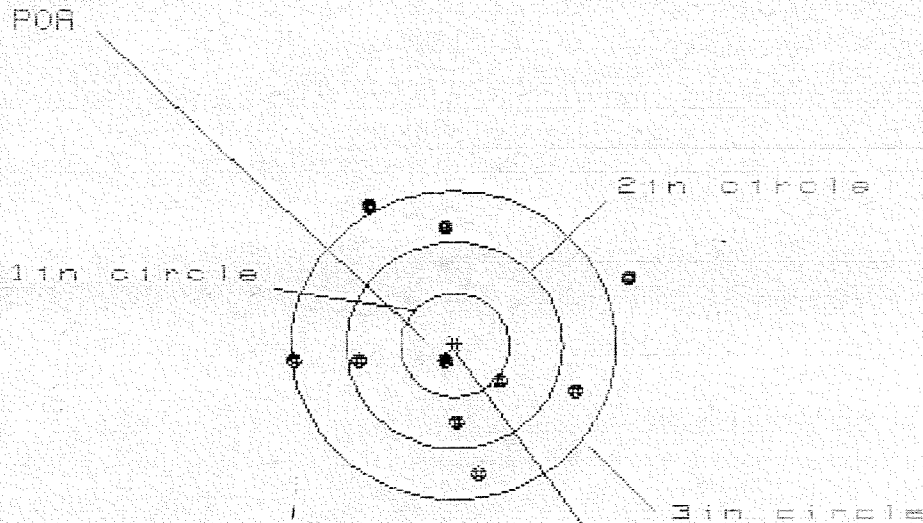
GS = 2.758

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.960	.779	.412
MINIMUM X	:	-1.631	-.940	-.942
MAXIMUM Y	:	.605	.607	.490
MINIMUM Y	:	-.934	-.932	-.774
CENTROID X	:	.203	.384	.286
CENTROID Y	:	-.052	-.054	.063
POA TO CENTROID in.	:	.209	.387	.293
MIN RADIUS	:	.139	.174	.024
MEAN RADIUS	:	.754	.623	.534
MAX RADIUS	:	1.631	1.215	.957
HORIZONTAL SPREAD	:	2.591	1.719	1.254
VERTICAL SPREAD	:	1.539	1.539	1.264
EXTREME SPREAD	:	2.758	2.142	1.496
NUMBER IN ONE INCH CIRCLE =			2	
NUMBER IN TWO INCH CIRCLE =			8	
NUMBER IN THREE INCH CIRCLE =			9	

22 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649102

CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1in = 1

2in = 4

3in = 8

HS= 3.033

VS= 2.582

GS= 3.124

CENTROID *

PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.565	1.271	1.195
MINIMUM X	-1.468	-1.294	-1.370
MAXIMUM Y	1.309	1.381	1.419
MINIMUM Y	-1.273	-1.201	-1.028
CENTROID X	.084	-.089	-.013
CENTROID Y	.144	.072	-.101
POA TO CENTROID in.	.167	.115	.102
MIN RADIUS	.198	.152	.065
MEAN RADIUS	1.066	.978	.867
MAX RADIUS	1.695	1.510	1.419
HORIZONTAL SPREAD	3.033	2.565	2.565
VERTICAL SPREAD	2.582	2.582	2.447
EXTREME SPREAD	3.124	2.782	2.587
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	8		

22 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8649102

CENTERFIRE PATTERNS # 5

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS- 10

IN CIR

1 in = 2

2 in = 8

3 in = 10

HS= 1.922

VS= 1.857

GS= 2.212

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.211	1.321	.659
MINIMUM X	:	-.711	-.601	-.436
MAXIMUM Y	:	.946	.845	.852
MINIMUM Y	:	-.911	-.882	-.875
CENTROID X	:	.202	.092	-.073
CENTROID Y	:	-.038	.063	.056
POA TO CENTROID in.	:	.206	.112	.092
MIN RADIUS	:	.224	.180	.143
MEAN RADIUS	:	.805	.788	.583
MAX RADIUS	:	1.344	1.322	1.096
HORIZONTAL SPREAD	:	1.922	1.922	1.095
VERTICAL SPREAD	:	1.857	1.727	1.727
EXTREME SPREAD	:	2.212	2.065	1.928
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6649102
28 Aug 1991

500 RDS

CENTROIDAL DISTANCES

0 TO	1	.710158
1 TO	2	.474444
1 TO	3	.615813
1 TO	4	.95498
1 TO	5	.585355

5.4
1.2+ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.2844
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .2934
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .408616

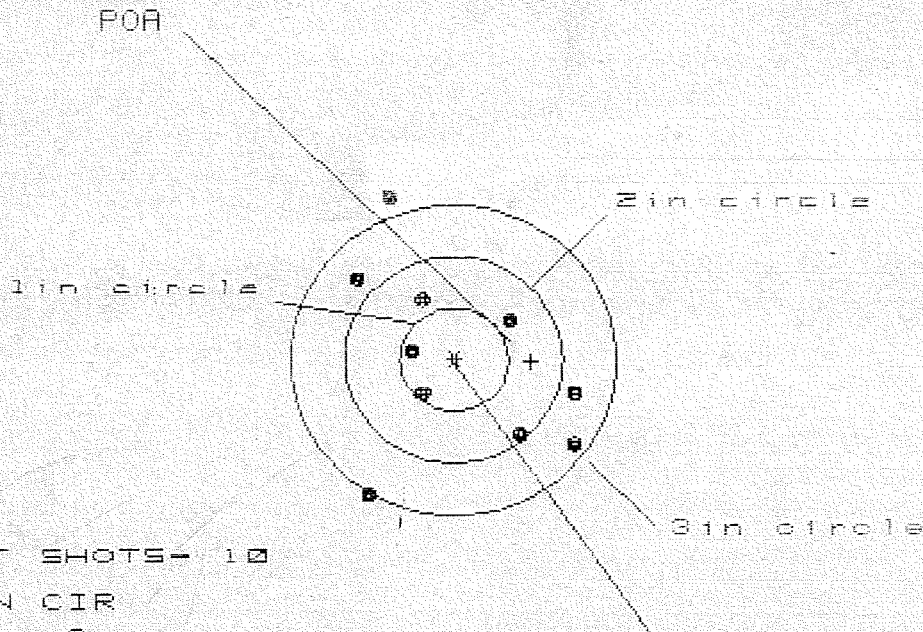
THE AMR FOR THIS RIFLE IS: .8792

27 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06649102.1

Endurance 60W

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 5

3 in = 8

HS= 1.980

VS= 2.893

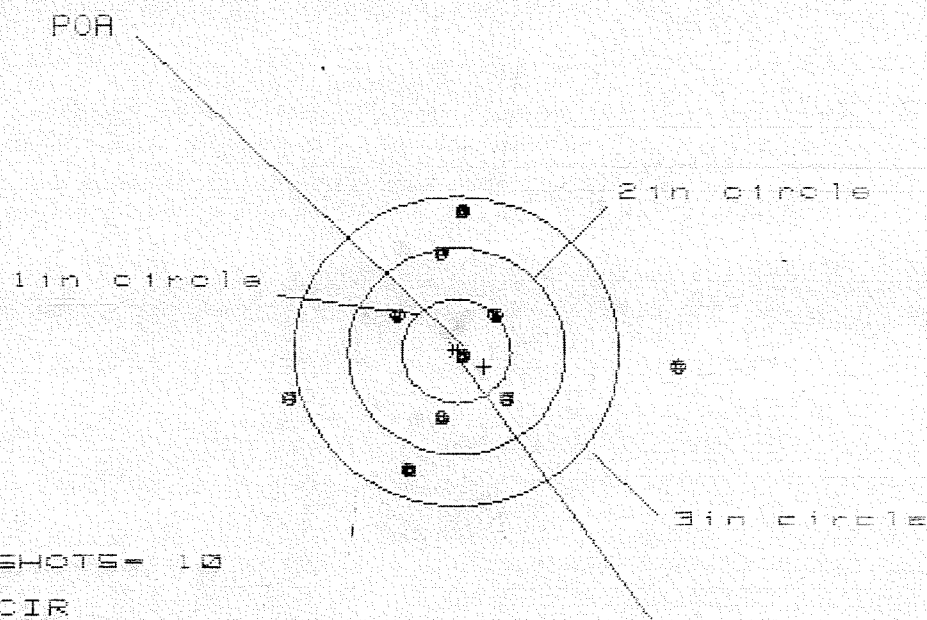
GS= 2.906

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.125	1.055	.944
MINIMUM X	-.855	-.925	-1.036
MAXIMUM Y	1.569	.982	.838
MINIMUM Y	-1.324	-1.150	-.749
CENTROID X	-.710	-.640	-.529
CENTROID Y	.015	-.159	-.016
POA TO CENTROID in.	.710	.659	.529
MIN RADIUS	.416	.432	.509
MEAN RADIUS	1.003	.923	.845
MAX RADIUS	1.693	1.452	1.333
HORIZONTAL SPREAD	1.980	1.980	1.980
VERTICAL SPREAD	2.893	2.132	1.587
EXTREME SPREAD	2.906	2.499	2.499
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	8		

27 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06649102.1

CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1 in = 2

2 in = 6

3 in = 8

HS = 3.573

VS = 2.442

GS = 3.584

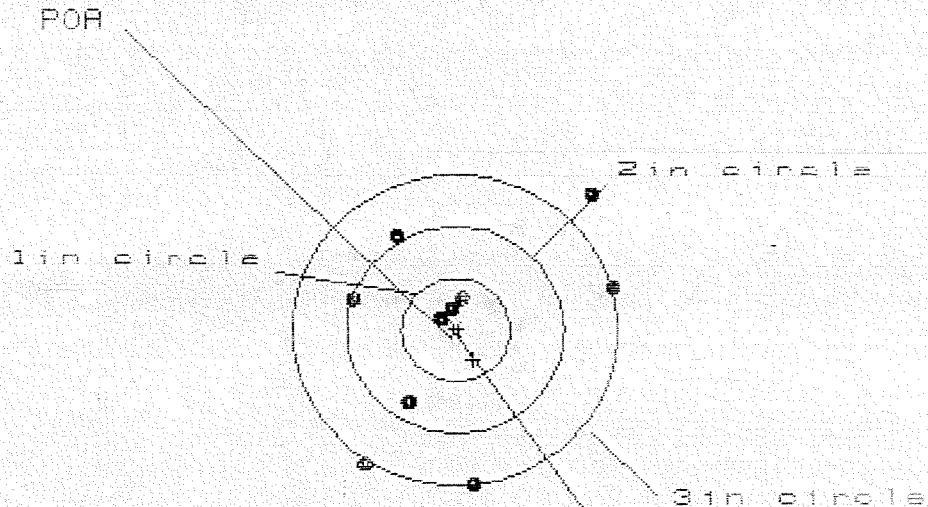
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.025	.676	.511
MINIMUM X	:	-1.548	-1.323	-.529
MAXIMUM Y	:	1.331	1.310	1.248
MINIMUM Y	:	-1.111	-1.132	-1.194
CENTROID X	:	-.254	-.479	-.314
CENTROID Y	:	.146	.166	.228
POA TO CENTROID in.	:	.293	.507	.388
MIN RADIUS	:	.059	.261	.160
MEAN RADIUS	:	.969	.862	.763
MAX RADIUS	:	2.034	1.411	1.270
HORIZONTAL SPREAD	:	3.573	1.999	1.040
VERTICAL SPREAD	:	2.442	2.442	2.442
EXTREME SPREAD	:	3.584	2.512	2.512
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

27 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/CG649182 1

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1in = 3

2in = 4

3in = 8

HS= 2.473

VS= 2.763

GS= 3.237

CENTROID *

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.497	1.632	.533
MINIMUM X	:	-.976	-.841	-.637
MAXIMUM Y	:	1.284	1.011	1.074
MINIMUM Y	:	-1.479	-1.336	-1.273
CENTROID X	:	-.159	-.294	-.498
CENTROID Y	:	.290	.147	.084
POA TO CENTROID in.	:	.331	.329	.505
MIN RADIUS	:	.172	.250	.374
MEAN RADIUS	:	.979	.900	.801
MAX RADIUS	:	1.765	1.710	1.380
HORIZONTAL SPREAD	:	2.473	2.473	1.170
VERTICAL SPREAD	:	2.763	2.347	2.347
EXTREME SPREAD	:	3.237	2.812	2.453
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	

27 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06649102.1

CENTERFIRE PATTERNS # 4

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS- 10

IN CIR

1 in = 5

2 in = 8

3 in = 10

HS= 2.332

VS= 1.298

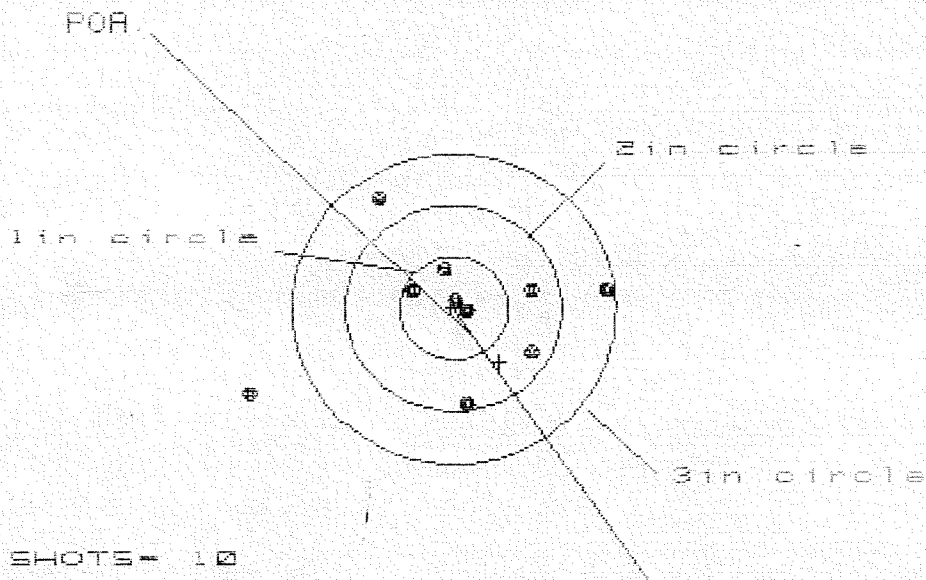
GS= 2.373

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.121	.986	.329
MINIMUM X	:	-1.211	-.909	-.786
MAXIMUM Y	:	.699	.759	.780
MINIMUM Y	:	-.599	-.539	-.518
CENTROID X	:	.115	.250	.127
CENTROID Y	:	.496	.436	.415
POA TO CENTROID in.	:	.509	.502	.434
MIN RADIUS	:	.132	.046	.137
MEAN RADIUS	:	.622	.507	.452
MAX RADIUS	:	1.327	1.000	.826
HORIZONTAL SPREAD	:	2.332	1.895	1.114
VERTICAL SPREAD	:	1.298	1.298	1.298
EXTREME SPREAD	:	2.373	1.895	1.298
NUMBER IN ONE INCH CIRCLE	=		5	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	

27 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06645102.1

CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1 in = 4

2 in = 7

3 in = 9

HS= 3.310

VS= 1.939

GS= 3.457

CENTROID *

PATTERN #	5	5	5
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.450	1.243	.641
MINIMUM X	-1.860	-.885	-.729
MAXIMUM Y	1.053	.967	.984
MINIMUM Y	-.886	-.972	-.955
CENTROID X	-.414	-.207	-.363
CENTROID Y	.520	.606	.589
POA TO CENTROID in.	.665	.641	.692
MIN RADIUS	.096	.087	.056
MEAN RADIUS	.823	.677	.579
MAX RADIUS	2.014	1.310	1.225
HORIZONTAL SPREAD	3.310	2.128	1.370
VERTICAL SPREAD	1.939	1.939	1.939
EXTREME SPREAD	3.457	2.283	2.094
NUMBER IN ONE INCH CIRCLE =		4	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		9	

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6649102
7 Sep 1991

4500 RDS

CENTROIDAL DISTANCES

0 TO	1	.272132
1 TO	2	.195673
1 TO	3	.445243
1 TO	4	.28878
1 TO	5	.316836

#5
3 1 (----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1752
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .022
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .176576
THE AMR FOR THIS RIFLE IS: .7952

7 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6B49102.1.1

CENTERFIRE PATTERNS # 1

POR

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS = 10

IN CIR

1in = 2

2in = 9

3in = 10

HS = 1.542

VS = 1.279

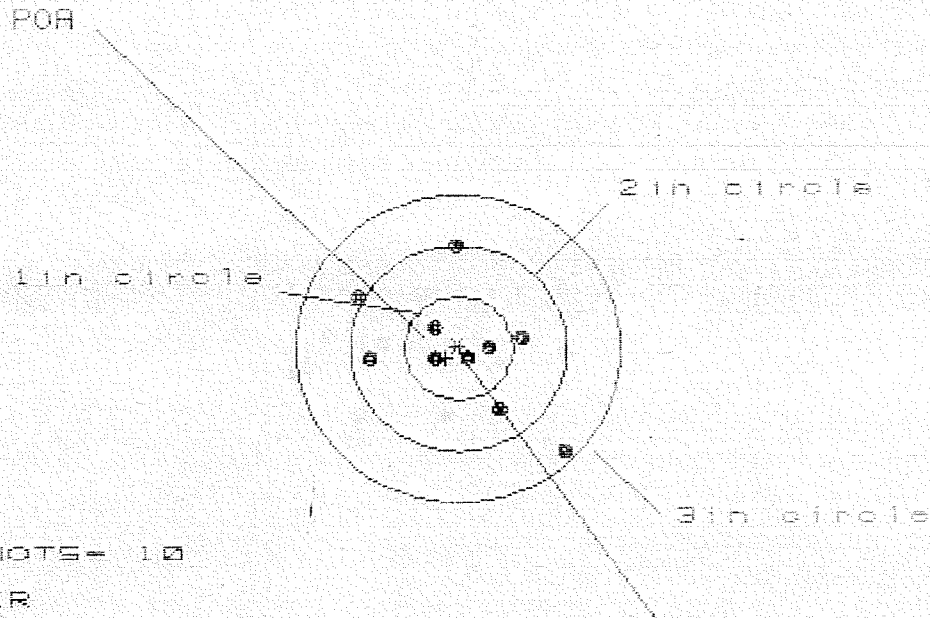
GS = 1.648

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	9
MAXIMUM X	.931	.913	.656
MINIMUM X	-.611	-.508	-.394
MAXIMUM Y	.676	.727	.695
MINIMUM Y	-.603	-.552	-.584
CENTROID X	.270	.167	.053
CENTROID Y	-.034	-.085	-.053
POR TO CENTROID in.	.272	.187	.075
MIN RADIUS	.443	.342	.333
MEAN RADIUS	.699	.637	.585
MAX RADIUS	1.037	.948	.933
HORIZONTAL SPREAD	1.542	1.421	1.050
VERTICAL SPREAD	1.279	1.279	1.279
EXTREME SPREAD	1.648	1.648	1.443
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	9		
NUMBER IN THREE INCH CIRCLE =	10		

7 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06549102.1.1

CENTERFIRE PATTERNS. # 2



OF SHOTS= 10

IN CIR

1 in = 4

2 in = 7

3 in = 10

HS= 1.816

VS= 1.951

GS= 2.322

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.931	.711	.613
MINIMUM X	:	-.885	-.781	-.888
MAXIMUM Y	:	1.005	.899	.949
MINIMUM Y	:	-.946	-.689	-.639
CENTROID X	:	.122	.018	.116
CENTROID Y	:	.094	.200	.150
POA TO CENTROID in.	:	.154	.200	.190
MIN RADIUS	:	.126	.213	.182
MEAN RADIUS	:	.647	.573	.521
MAX RADIUS	:	1.328	.904	.949
HORIZONTAL SPREAD	:	1.816	1.492	1.421
VERTICAL SPREAD	:	1.951	1.588	1.588
EXTREME SPREAD	:	2.322	1.641	1.628
NUMBER IN ONE INCH CIRCLE =			4	
NUMBER IN TWO INCH CIRCLE =			7	
NUMBER IN THREE INCH CIRCLE =			10	

7 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08649102.1.1

CENTERFIRE PATTERNS # 3

POA

1 in circle

2 in circle

3 in circle

OF SHOTS= 10

IN CIR

1 in = 2

2 in = 5

3 in = 8

HS= 3.170

VS= 2.268

GS= 3.357

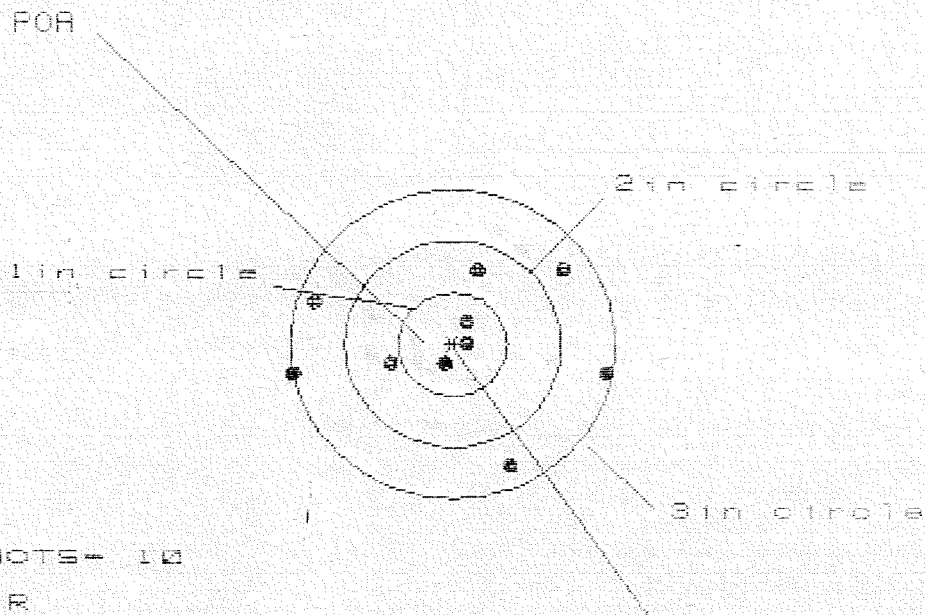
CENTROID *

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.808	1.323	1.381
MINIMUM X	:	-1.362	-1.161	-1.103
MAXIMUM Y	:	.661	.566	.353
MINIMUM Y	:	-1.607	-1.702	-.430
CENTROID X	:	-.030	-.231	-.289
CENTROID Y	:	-.363	-.268	-.055
POA TO CENTROID in.	:	.364	.354	.294
MIN RADIUS	:	.120	.302	.306
MEAN RADIUS	:	1.030	.899	.766
MAX RADIUS	:	2.001	1.764	1.386
HORIZONTAL SPREAD	:	3.170	2.484	2.484
VERTICAL SPREAD	:	2.268	2.268	.783
EXTREME SPREAD	:	3.357	2.652	2.490
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

7 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649182.1.1

CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1in = 3

2in = 5

3in = 10

HS= 2.828

VS= 1.860

GS= 2.828

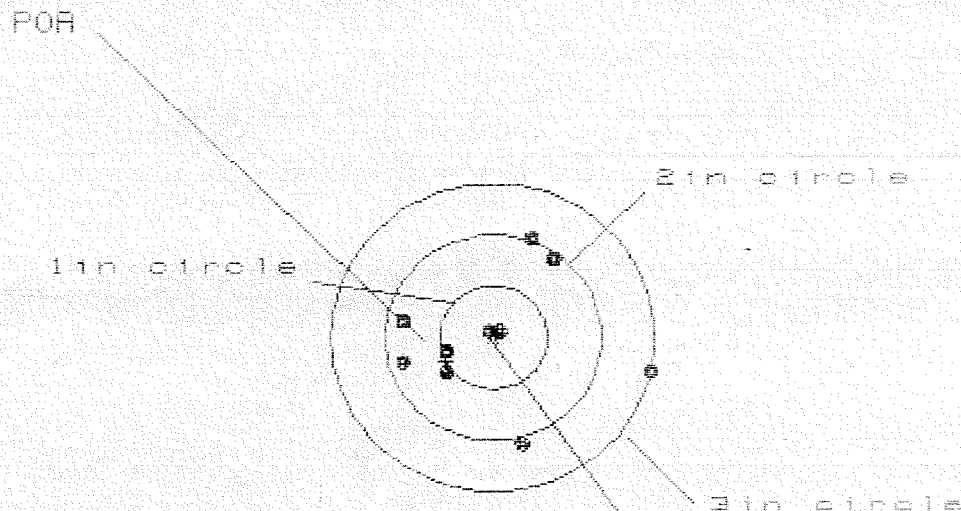
CENTROID *

PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.401	1.242	.979
MINIMUM X	-1.427	-1.468	-1.313
MAXIMUM Y	.713	.680	.638
MINIMUM Y	-1.147	-1.180	-1.222
CENTROID X	.075	.234	.079
CENTROID Y	.179	.212	.254
POR TO CENTROID in.	.194	.316	.266
MIN RADIUS	.128	.060	.106
MEAN RADIUS	.861	.785	.708
MAX RADIUS	1.457	1.509	1.348
HORIZONTAL SPREAD	2.828	2.710	2.292
VERTICAL SPREAD	1.860	1.860	1.860
EXTREME SPREAD	2.828	2.796	2.383
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	10		

7 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8649102.1.1

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 3

2in = 7

3in = 8

HS= 2.332

VS= 1.921

GS= 2.354

CENTROID *

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.467	.728	.779
MINIMUM X	-.865	-.702	-.651
MAXIMUM Y	.934	.896	.768
MINIMUM Y	-.987	-1.025	-.472
CENTROID X	.439	.276	.225
CENTROID Y	.234	.272	.400
POA TO CENTROID in.	.490	.388	.459
MIN RADIUS	.095	.084	.174
MEAN RADIUS	.739	.625	.577
MAX RADIUS	1.585	1.104	.971
HORIZONTAL SPREAD	2.332	1.430	1.430
VERTICAL SPREAD	1.921	1.921	1.240
EXTREME* SPREAD	2.354	1.925	1.722
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		9	

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06649102
7 Sep 1991

5000 RDS

CENTROIDAL DISTANCES

0 TO	1	.330218
1 TO	2	.424421
1 TO	3	.21422
1 TO	4	.437371
1 TO	5	.315978

4.1 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .071
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0186
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0733959

THE AMR FOR THIS RIFLE IS: 1.004

7 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8649182.1.1.1

CENTERFIRE PATTERNS

1

POA

1in circle

2in circle

3in circle

OF SHOTS = 10

IN CIR

1in = 1

2in = 4

3in = 9

HS = 2.769

VS = 2.184

GS = 2.970

CENTROID *

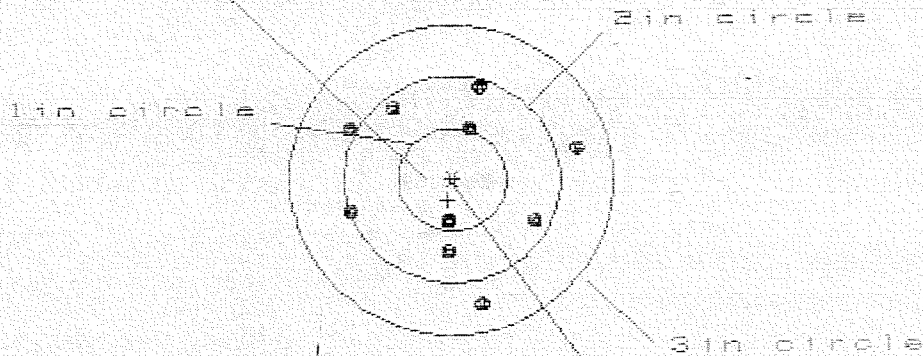
PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.330	1.170	1.031
MINIMUM X	-1.439	-0.879	-0.733
MAXIMUM Y	1.176	1.064	0.984
MINIMUM Y	-1.008	-0.940	-1.020
CENTROID X	0.300	0.460	0.314
CENTROID Y	-0.138	-0.026	0.054
POA TO CENTROID in.	0.330	0.461	0.318
MIN RADIUS	0.087	0.140	0.213
MEAN RADIUS	0.991	0.905	0.840
MAX RADIUS	1.757	1.335	1.256
HORIZONTAL SPREAD	2.769	2.049	1.764
VERTICAL SPREAD	2.184	2.004	2.004
EXTREME SPREAD	2.970	2.384	2.384
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	9		

7 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649102.1.1.1

CENTERFIRE PATTERNS # 2

POR



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 7

3 in = 10

HS= 2.090

VS= 2.093

GS= 2.155

CENTROID +

PATTERN #	2	2	2
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.130	1.156	.950
MINIMUM X	-.950	-.924	-.779
MAXIMUM Y	.885	.751	.773
MINIMUM Y	-1.208	-.814	-.792
CENTROID X	.042	.016	-.129
CENTROID Y	.199	.333	.311
POR TO CENTROID in.	.204	.334	.337
MIN RADIUS	.417	.436	.526
MEAN RADIUS	.876	.829	.776
MAX RADIUS	1.232	1.170	1.056
HORIZONTAL SPREAD	2.080	2.080	1.729
VERTICAL SPREAD	2.093	1.565	1.565
EXTREME SPREAD	2.155	2.155	1.889
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	10		

7 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06549102.1.1.1

CENTERFIRE PATTERNS # 3

POA

1in circle

2in circle

3in circle

OF SHOTS= 10

IN CIR

1in = 1

2in = 7

3in = 9

CENTROID *

HS= 3.293

VS= 2.059

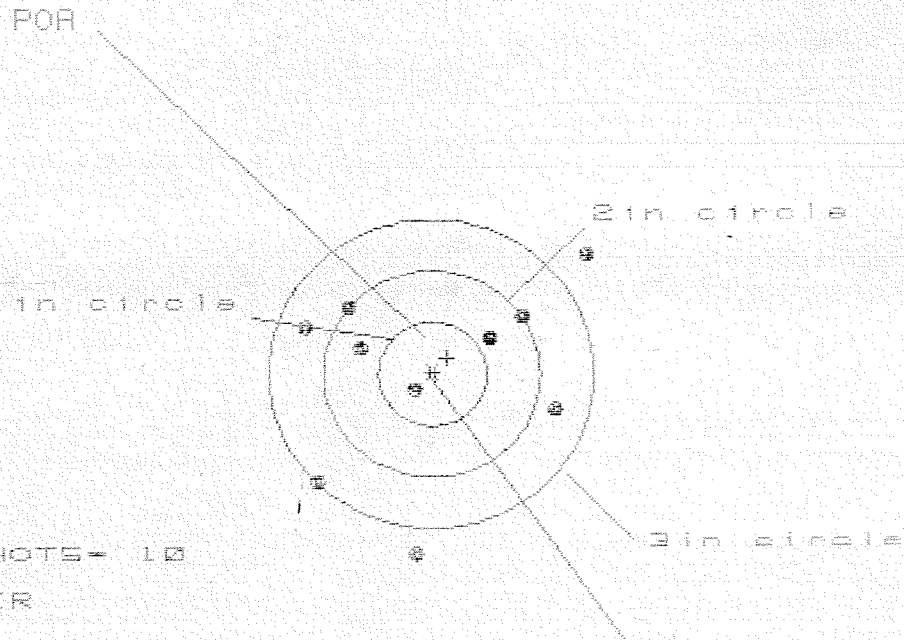
GS= 3.692

PATTERN #	3		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	2.345	1.154	1.089
MINIMUM X	-.948	-.687	-.752
MAXIMUM Y	1.150	1.040	.954
MINIMUM Y	-.909	-.781	-.867
CENTROID X	.109	-.152	-.087
CENTROID Y	-.041	-.169	-.083
POA TO CENTROID in.	.116	.227	.121
MIN RADIUS	.242	.374	.410
MEAN RADIUS	.974	.727	.716
MAX RADIUS	2.612	1.232	1.143
HORIZONTAL SPREAD	3.293	1.841	1.841
VERTICAL SPREAD	2.059	1.821	1.821
EXTREME SPREAD	3.692	2.014	1.999
NUMBER IN ONE INCH CIRCLE	=	1	
NUMBER IN TWO INCH CIRCLE	=	7	
NUMBER IN THREE INCH CIRCLE	=	9	

7 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PAIT/C6649182.1.1.1

CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1in = 1

2in = 4

3in = 7

HS= 2.583

VS= 2.912

GS= 3.358

CENTROID #

PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.415	1.300	1.298
MINIMUM X	-1.168	-1.011	-1.013
MAXIMUM Y	1.193	.765	.566
MINIMUM Y	-1.719	-1.586	-1.086
CENTROID X	-.137	-.294	-.292
CENTROID Y	-.156	-.289	-.090
POA TO CENTROID in.	.207	.412	.306
MIN RADIUS	.224	.062	.254
MEAN RADIUS	1.102	1.002	.913
MAX RADIUS	1.051	1.587	1.447
HORIZONTAL SPREAD	2.583	2.311	2.311
VERTICAL SPREAD	2.912	2.351	1.652
EXTREME SPREAD	3.358	2.512	2.512
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	7		

7 Sep 1991

FILE: PATTERNING/CENTERFIRE_PATT/C6649102.1.1.1

CENTERFIRE PATTERNS # 5

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS= 10

IN CIR

1 in = 1

2 in = 6

3 in = 7

HS= 3.641

VS= 2.356

GS= 3.701

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	2.323	1.084	1.049
MINIMUM X	-1.318	-1.060	-1.095
MAXIMUM Y	1.507	1.487	1.751
MINIMUM Y	-1.849	-1.869	-1.683
CENTROID X	.041	-.217	-.132
CENTROID Y	.043	.063	.123
POA TO CENTROID in.	.059	.228	.218
MIN RADIUS	.329	.494	.517
MEAN RADIUS	1.076	.930	.850
MAX RADIUS	2.330	1.514	1.291
HORIZONTAL SPREAD	3.641	2.144	2.144
VERTICAL SPREAD	2.356	2.356	1.484
EXTREME SPREAD	3.701	2.481	2.323
NUMBER IN ONE INCH CIRCLE	=	1	
NUMBER IN TWO INCH CIRCLE	=	6	
NUMBER IN THREE INCH CIRCLE	=	7	

RECEIVING AND ESTIMATING REPORT

COMMENTS

ORDER
R 95-06296

INITIAL JIM	CUSTOMER ORDER NO.		W/LEUPOLD ULTRA 10X-M3A SCOPE M-24 SNIPER			
DATE RECEIVED 02/06/95	DATE OPENED 02/21/95	DATE CODE EL 10-91	SERIAL NUMBER C6649210	NEW SERIAL NUMBER	MODEL AND GRADE 700 7.62	NATO
ACCESSORIES SCOPE MNTS		SCOPE BASE		HARD CASE	W/STUDS	

FROM:

SHIP TO:

MARKSMANSHIP TRNG UNIT
CAMP ROBINSON BLDG 4901
ATTN SUPPLY SECTION
N LITTLE ROCK AR 72118

MARKSMANSHIP TRNG UNIT
CAMP ROBINSON BLDG 4901
ATTN SUPPLY SECTION
N LITTLE ROCK AR 72118

CUST NO: 115537 C.O.D.L

ACCOUNT NUMBER	ACCOUNT NUMBER N/C	WRITE ☐	PROM. DATE	ESTIMATED 2/21/95	VIA UPS
----------------	--------------------	--------------------------------	------------	----------------------	------------

GUN CONDITION

- ☐ NEW
☐ LIGHTLY WORN
☒ WORN
☐ VERY WORN
☐ UNREPAIRABLE
☐ MARRED

REPAIR CHARGE

EXCISE

TAX

INSURANCE

UPS

PARCEL POST

TOTAL

W81LRM

CUSTOMER CONCERN	AMMO	FUNCTION	FINISH	ACCURACY	FIT	INSPECT
CYCLE	A1	B1				
TRIGGER GROUP		B2			E1	F1
BOLT ASSY.	Bolt Handle	Broken, Rear Sight Base				F2 missing
BARREL ASSY.		B4	D1	E3	F3	
REC. ASSY.		B5	D2	E4	F4	
WOOD			C1	D3	E5	F5
METAL			C2			

MAIN FAULT

Bolt Handle Broken

PARTS

COMMENTS

96005 Bolt Assy Trigger Assy Altered outside
96016 Rear Sight mounting Base of Factory Trigger pull Adjusting
96031 Trigger pull Adj Spring Spring Cut OFF.

~~W52H09 5055 #227~~
W52H09 5054 #226

REPAIRMAN RW	PROOF ✓	CLEAN ✓	TEST ✓	TARGET	PATTERN
GALLERY TESTER RW	DATE 2/21/95	DATE 2/21/95	DATE 2/21/95	DATE	DATE

OFFICE COPY

RD6925 REV. 1/94

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

BARBER - M24 M24090165229

NATIONAL GUARD MARKSMANSHIP TRAINING UNIT
CAMP ROBINSON, BLDG 4900
NORTH LITTLE ROCK, AR 72118-2200

MTU-ARM

30 January 1995

MEMORANDUM FOR Remington Arms Company Inc., ATTN: Fabricated Products Dept., 14
Hoefler Avenur, Ilion, NY 13357-1816

SUBJECT: Malfunction on M24 Sniper System

Sir, As per the conversation with Mike Lopez of Rock Island Arsenal on the 29th of August, 1994. I am returning this M-24 SWS, as per his instructions to your factory to be repaired. Mr. Lopez advised that I should write a memo explaining the circumstances during the failure of the bolt on the M-24.

During a Sniper School conducted by my unit the National Guard Marksmanship Training Unit, a student was issued this M-24 SWS, Ser No. C6649210. During a Known Distance Firing Exercise he was coached by one of the Sniper instructors who observed and related the following events to me. As the student loaded the round and fired it he observed the student without any extra strain or effort attempt to rotate the bolt handle upward at which time the handle seperated from the bolt body. I was immediately notified and the weapon was brought to me for removal of the bolt and fired case. After removal I inspected the bolt assembly for possible cause of failure and noticed some rust accumulated between bolt handle and/body. I also noted the the silver solder did not completely flow onto the handles mating surface. I don't know if rust was a contributing factor, but it would appear that the bolt handle lifted or was not seated properly during the silver solder operation. As an owner of a number of Remington 700's I have never seen this type of failure before and am curious if this is a common problem, or just a one-in-a-million occurrence.

Thank you for your time and would appreciate your correspondence concerning this matter.



ALLEN S. BACON
SSG, ARNG
Gunsmith/Machinist

MAINTENANCE REQUEST				PAGE NO.	NO. OF PAGES	REQUIREMENT CONTROL SYMBOL	CONTROL NUMBER
For use of this form, see PAM 738-750; the proponent agency is DCSLOG							
SECTION I - CUSTOMER DATA				SECTION II - MAINTENANCE ACTIVITY DATA			
1a. UIC CUSTOMER W 7 L 0 A A		1b. CUSTOMER UNIT NAME NG MC		1c. PHONE NO. 791-9543		3a. WORK ORDER NUMBER (WON)	
2a. IF INTRANSIT CUSTOMER, ENTER DATA IN BLOCKS 2b. AND 2c.		2b. SAMS-2 UIC		2c. UTILIZATION CODE		3b. SHOT	
4a. UIC SUPPORT				4b. SUPPORT UNIT NAME			
SECTION III - EQUIPMENT DATA							
5. TYPE MNT REQ CODE		6. ID		7. NSN		15. FAILURE DETECTED DURING (Select one - use / or X)	
						☐ A Scheduled Maintenance ☐ B Handling ☐ C Test ☐ D Normal OP ☐ E Storage ☐ F Inspection ☐ G Flight ☐ H Other ☐ J Calibration	
8. MODEL M 24 SWS		9. NOUN RIFLE M-24 SWS		16a. MILES/KILOMETERS (enter / or X) MI KM		16b. HOURS	
10a. ORG WON		10b. EIC		16c. ROUNDS			
11. SERIAL NUMBER C 6649210		12. QTY 01		13. PD 08		16d. LANDINGS	
14. Malfunction description (for DSU/GSU use)		16e. AUTO-ROTATIONS		17. PROJECT CODE (if assigned)		18. ACCOUNT PROCESSING CODE	
24. DESCRIBE DEFICIENCIES OR SYMPTOMS ON THE BASIS OF COMPLETE CHECKOUT AND DIAGNOSTIC PROCEDURE IN EQUIPMENT TM (Do not prescribe repairs)		19. IN WARRANTY? (enter Y or N)		20. LEVEL OF WORK (Select one - use / or X)		21. BUMPER NO./TAIL NO.	
		☐ O Unit Level ☐ F Intermediate Direct Spt		☐ H Intermediate General Spt ☐ D Direct Spt		22. REIMBURSABLE CUSTOMER? (If Intransit Customer, enter Y or N)	
24a. REMARKS BOLT HANDLE BROKEN OFF		23. PD AUTHENTICATING SIGNATURE (Payroll Signature)					

PREPARATION INSTRUCTIONS FOR THIS PAGE

SECTION I

- (1) Block 1a. Enter UIC of submitting organization.
- (2) Block 1b. Enter name of submitting organization.
- (3) Block 1c. Enter number to be called when maintenance is completed.
- (4) Block 2b. Enter UIC of supporting SAMS-2 if work is requested while in-transit and away from your support maintenance unit.
- (5) Block 2c. Enter equipment utilization code under which Materiel Condition Status is reported. See SAMS Codes and Tables.

SECTION II

Leave blank. To be completed by the support maintenance DSU/GSU.

SECTION III

- (1) Block 5. Enter the Type Maintenance Request Code. See SAMS Codes and Tables.
- (2) Block 6. Enter ID associated with block 7. See SAMS Codes and Tables.
- (3) Block 7. Enter the NSN or stock number of the item being submitted.
- (4) Block 8. Enter model of item being submitted.
- (5) Block 9. Enter noun/nomenclature of item being submitted.
- (6) Block 10a. Enter Work Order Number (WON) assigned when item submitted is reportable for MCSR. Otherwise, leave blank.
- (7) Block 10b. Enter EIC (left justify).
- (8) Block 11. Enter serial number of item being submitted.
- (9) Block 12. Enter the quantity of items being submitted.
- (10) Block 13. Enter the maintenance priority designator determined from SAMS Codes and Tables.

SECTION III (cont'd)

- (11) Block 14. Leave Blank.
- (12) Block 15. Select one. Use a / or X to indicate when failure was detected.
- (13) Block 16. Enter the accumulated usage data in block 16a through 16c, when equipment is subject to usage reporting.
- (14) Block 17. Enter the project code if one has been assigned. If not, leave blank.
- (15) Block 18. Leave blank (for DSU/GSU use.)
- (16) Block 19. Enter a "Y" or "N" to indicate whether equipment is still under manufacturer's warranty.
- (17) Block 20. Select one. Use a / or X to indicate the level of work to be performed on equipment submitted. See SAMS Codes and Tables.
- (18) Block 21. Enter the bumper number or admin number assigned for property control purposes to the equipment being submitted.
- (19) Block 22. Leave blank (for DSU/GSU use.)
- (20) Block 23. Enter the payroll signature of the CO or the CO's designated representative when the priority designator is 01 - 10. For priority designators 11 - 15, leave blank.
- (21) Block 24. Enter a brief description of the deficiencies or symptoms that you feel require attention at this level of maintenance.
- (22) Block 24a. Self-explanatory.

Block 34a. Enter signature of submitter.

Block 34b. Enter Ordinal Date submitted (YYDDD).

Block 35a. Enter signature of person accepting the maintenance request.

Block 35b. Enter the status.

Block 35c. Enter Ordinal Date accepted (YYDDD).

Block 35d. Enter Military Time.

34a. SUBMITTED BY <i>[Signature]</i>		35a. ACCEPTED BY	
34b. ORD. DATE 97244	35b. STA	35c. ORD DATE	35d. MIL TIME

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6649210

OP. #	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and Stock			
600	Proof		2/21/95	RW
607	Check Headspace			
610	Dis-assemble Gun			
612	Magnaflux Barrel Action			
	Magnaflux Bolt		2/21/95	RW
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		2/21/95	RW
	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 0165195 OP. NAME	READINGS	DATE	INIT
625 cont.	F) Safety On Force			
	G) Safety Off Force			
	H) Trigger Pull Test & Retainability			
	I) Firing Pin Indent			
	J) Assemble Stock			
	K) Assemble Swivel Studs			
	L) Attach Front and Rear Sight Assemblies			
	M) Iron Sight Alignment			
	N) Detach Front & Rear Sights & place in numbered container			
	O) Attach Scope to Rifle			
	P) Detach & Attach Scope 20 Times			
640	Gallery Target & Test			
	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			
	C) Function			
660	Pack			

Final Inspection

Sn: C6649219

DATE REC'D: 2/6/95

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-250☐ 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: Trigger Assy

Altered outside of Factory

Trigger Pull Spring Cut
OFF.

Arms Services Repair & Estimate System
BARBER - M24 0165197
File Add Repair Estimate Repair Expedite Repair Inquiry Repair Tools CSR Tools Reports Table Maintenance System Maintenance Help

Repair Inquiry

Repair Number: **RE00059327** Serial: C6649210 Model 700 Center Fire Caliber: 7.62 NATO M-24 (SWS) Repairman: Status: Closed 1/10/2003 8:27:01 AM
Verify Repair

Address Information
Customer: Received From Return To: Received From
Name: **TRANSPORTATION OFFICER** **TRANSPORTATION OFFICER**
Address 1: **USPFO FOR ARKANSAS ARMY NAT GUARD** **USPFO FOR ARKANSAS ARMY NAT GUARD**
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: Fax: Email: Comments: 	Received Condition Poor 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>1</td> </tr> <tr> <td>A017</td> <td>Scope Base</td> <td>1</td> </tr> <tr> <td>X</td> <td>FRT & REAR SGT BA</td> <td>1</td> </tr> </tbody> </table>			Code	Desc	Qty	A007	With Stud	1	A017	Scope Base	1	X	FRT & REAR SGT BA	1
Code	Desc	Qty														
A007	With Stud	1														
A017	Scope Base	1														
X	FRT & REAR SGT BA	1														

Repair Search Refresh Close

neglelj 1/10/2003 9:36 AM CAPS NUM INS SCFL
start 2 Micro 2 Micro Arms Ser... My Docu... My Exe... 2 S.F.L... 9:36 AM

Serial Number: **C6649210**
Model: **700**

RE00059327

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6649210.___0
FILE DATE AND TIME: 01/29/2003 15:04

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.047
The Average Y Centroid of the Five Target Set:	-0.113
The Average Point of Impact of the Five Target Set:	0.123
The Average Mean Radius of the Five Target Set:	0.534
The Distance from POA to Centroid Target #1:	0.141
The Distance from Centroid Target #2 to Centroid Target #1:	0.185
The Distance from Centroid Target #3 to Centroid Target #1:	0.060
The Distance from Centroid Target #4 to Centroid Target #1:	0.056
The Distance from Centroid Target #5 to Centroid Target #1:	0.088

SERIAL NUMBER: C6649210. __0

TARGET NUMBER: 1

FILE DATE: 01/29/2003

FILE TIME: 15:04

X CENTROID: -0.039

Y CENTROID: -0.135

POA TO CENTROID: 0.141

HORZ SPREAD: 1.188

VERT SPREAD: 0.740

GROUP SPREAD: 1.237

MIN RADIUS: 0.095

MAX RADIUS: 0.714

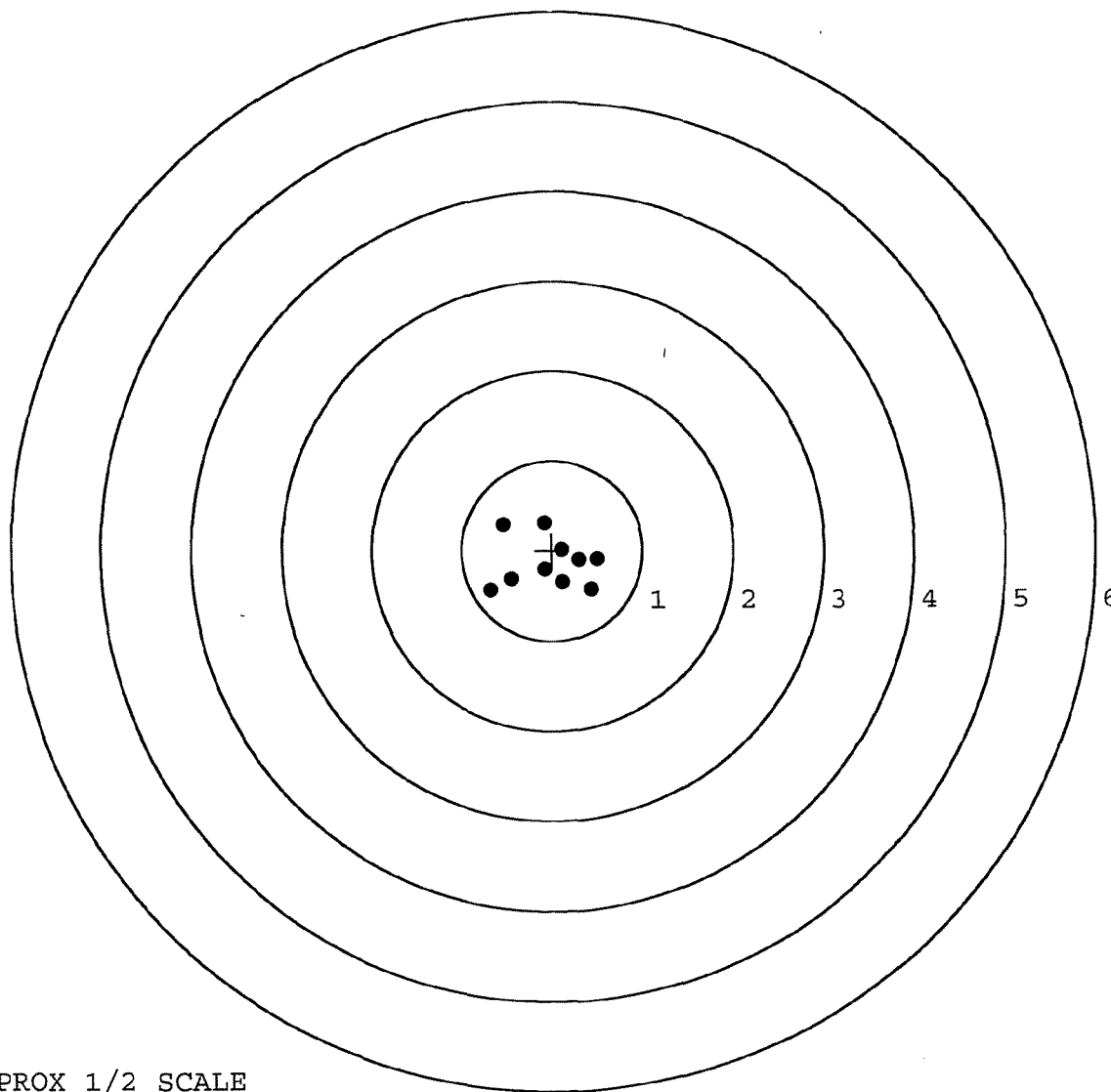
MEAN RADIUS: 0.428

IN 1 IN DIAMETER: 6

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.449	-0.317
2:	-0.686	-0.437
3:	-0.545	0.293
4:	-0.090	0.303
5:	0.502	-0.094
6:	0.434	-0.432
7:	0.115	-0.358
8:	0.302	-0.100
9:	0.107	0.010
10:	-0.083	-0.219



TARGET APPROX 1/2 SCALE

BARBER - M24 0165200

SERIAL NUMBER: C6649210. __0

TARGET NUMBER: 2

FILE DATE: 01/29/2003

FILE TIME: 15:04

POINT#	X	Y
1:	0.564	0.280
2:	-0.172	-0.724
3:	-0.370	-0.375
4:	-0.304	-0.153
5:	-0.141	0.140
6:	-0.125	0.376
7:	0.172	0.302
8:	0.357	0.278
9:	0.046	0.354
10:	0.034	-0.031

X CENTROID: 0.006

Y CENTROID: 0.045

POA TO CENTROID: 0.045

HORZ SPREAD: 0.934

VERT SPREAD: 1.100

GROUP SPREAD: 1.245

MIN RADIUS: 0.081

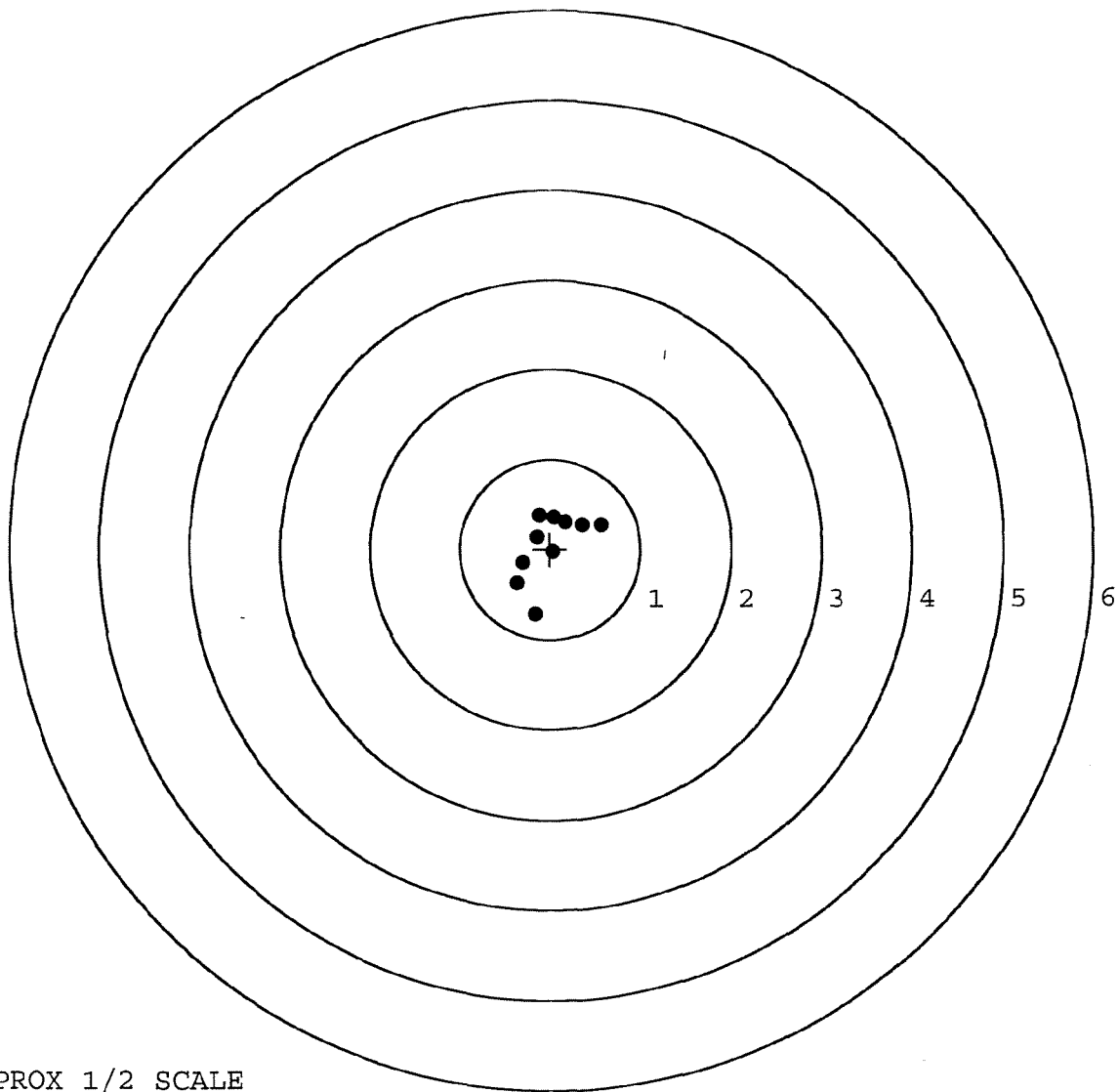
MAX RADIUS: 0.789

MEAN RADIUS: 0.398

IN 1 IN DIAMETER: 7

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6649210. 0

TARGET NUMBER: 3

FILE DATE: 01/29/2003

FILE TIME: 15:04

X CENTROID: -0.097

Y CENTROID: -0.151

POA TO CENTROID: 0.179

HORZ SPREAD: 1.699

VERT SPREAD: 1.325

GROUP SPREAD: 1.815

MIN RADIUS: 0.323

MAX RADIUS: 1.278

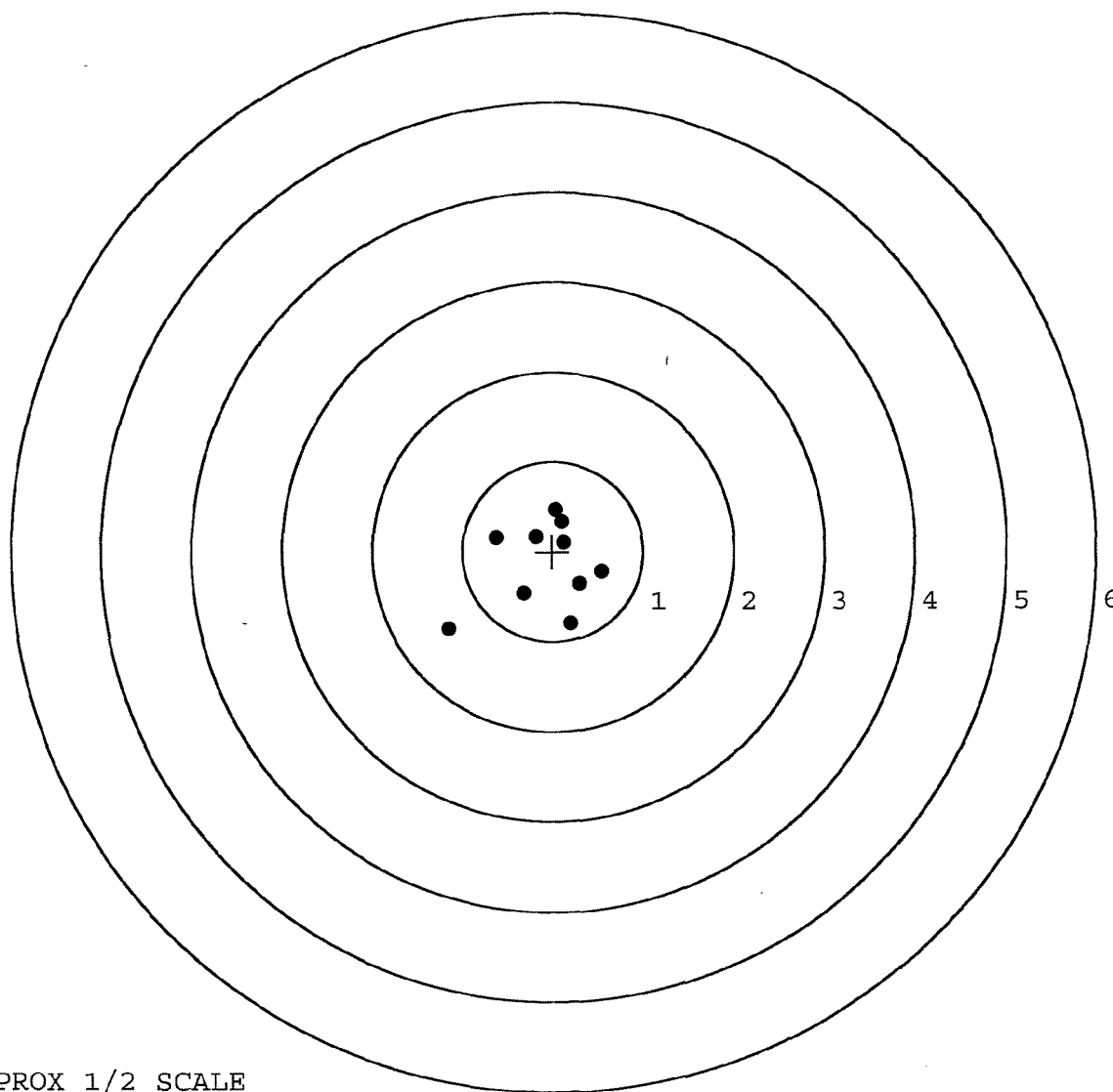
MEAN RADIUS: 0.590

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.206	-0.803
2:	-0.325	-0.470
3:	-1.157	-0.864
4:	0.542	-0.225
5:	0.302	-0.356
6:	-0.623	0.156
7:	0.128	0.104
8:	-0.183	0.161
9:	0.104	0.329
10:	0.037	0.461



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6649210. 0

TARGET NUMBER: 4

FILE DATE: 01/29/2003

FILE TIME: 15:04

POINT#	X	Y
1:	0.077	-0.872
2:	-0.762	-0.676
3:	0.044	0.676
4:	-0.298	0.716
5:	-0.283	0.113
6:	-0.308	-0.268
7:	0.302	-0.195
8:	0.502	-0.177
9:	0.339	-0.456
10:	0.522	-0.406

X CENTROID: 0.013

Y CENTROID: -0.154

POA TO CENTROID: 0.155

HORZ SPREAD: 1.284

VERT SPREAD: 1.588

GROUP SPREAD: 1.574

MIN RADIUS: 0.291

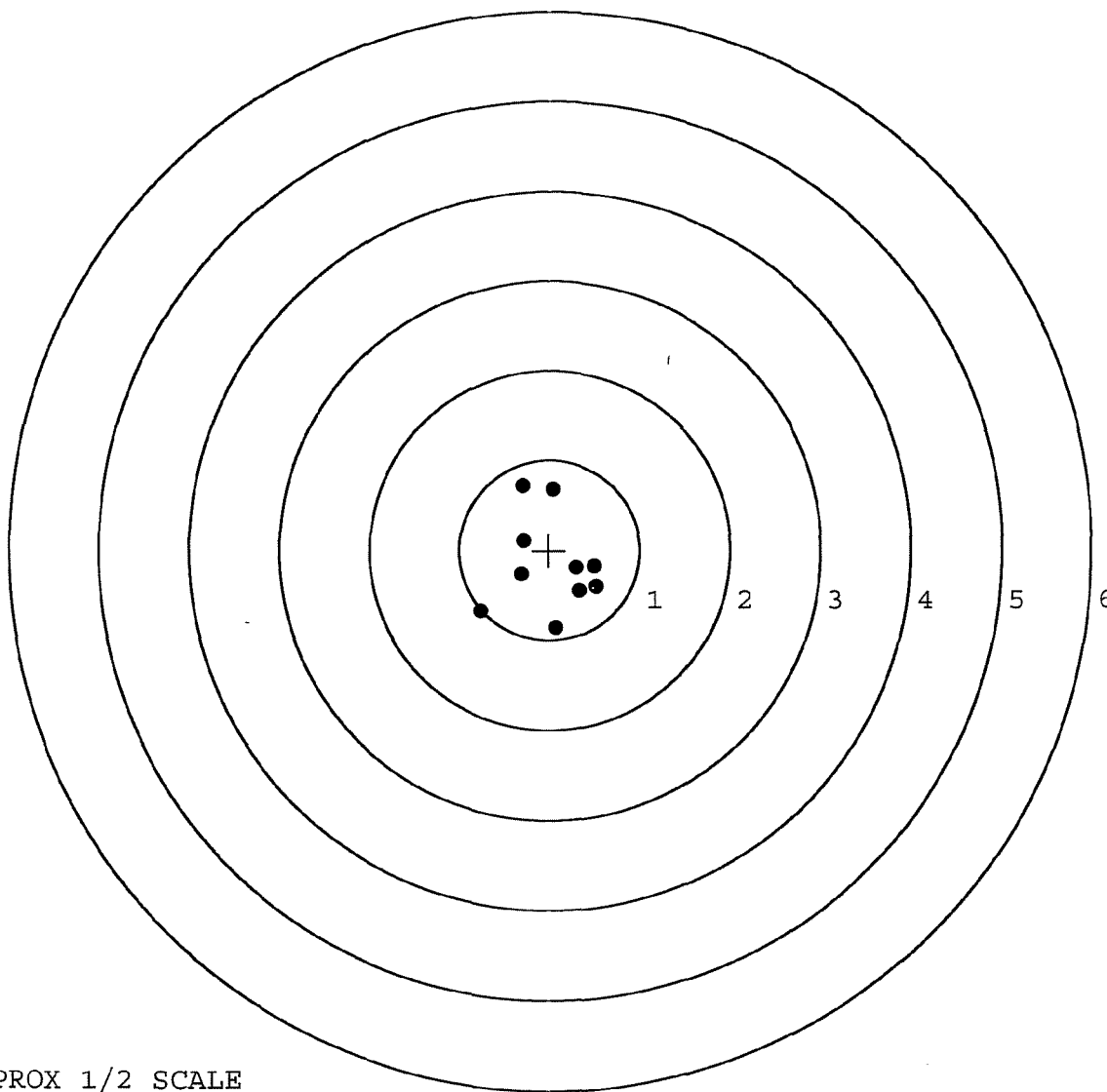
MAX RADIUS: 0.935

MEAN RADIUS: 0.594

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

BARBER - M24 0165203

SERIAL NUMBER: C6649210. 0

TARGET NUMBER: 5

FILE DATE: 01/29/2003

FILE TIME: 15:04

POINT#	X	Y
1:	0.744	-0.677
2:	0.344	-1.179
3:	-0.278	-0.824
4:	0.284	0.279
5:	-1.013	-0.041
6:	-0.669	0.066
7:	-0.161	-0.335
8:	-0.123	0.010
9:	-0.129	0.364
10:	-0.206	0.642

X CENTROID: -0.121

Y CENTROID: -0.169

POA TO CENTROID: 0.208

HORZ SPREAD: 1.757

VERT SPREAD: 1.821

GROUP SPREAD: 1.902

MIN RADIUS: 0.170

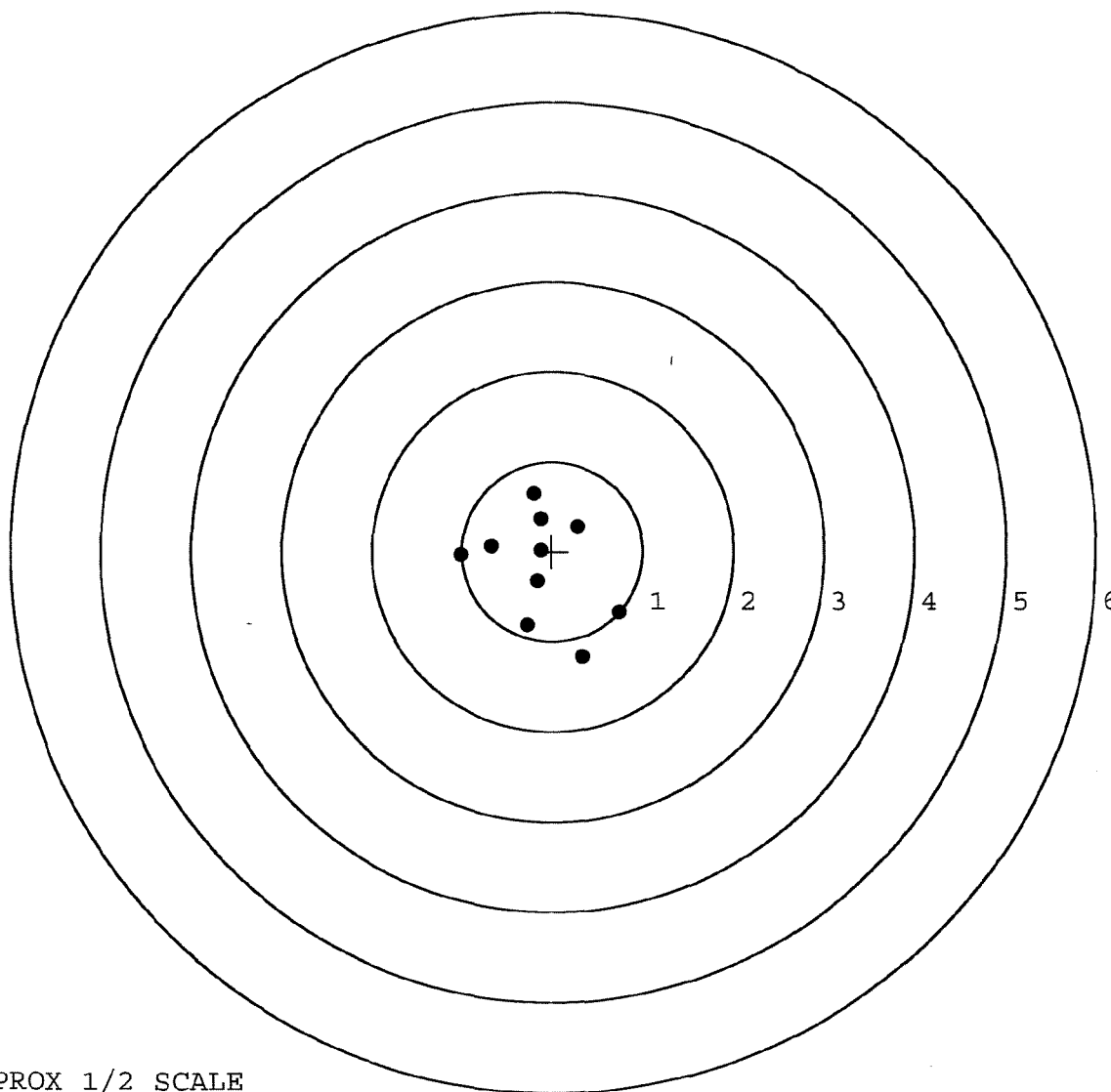
MAX RADIUS: 1.111

MEAN RADIUS: 0.659

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

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

R & E NUMBER	00059327		
SERIAL NUMBER	C-6049210		
LOG-IN DATE	1-10-03		
INSPECT AND VERIFY:			
OPERATION #	OPERATION NAME	DATE	INITIAL
550	DIS-ASSEMBLE GUN	1-14-03	RW
560 A	RE-BARREL	1-14-03	DA
B	DRILL AND TAP	1-20-03	TRW
575	ASSEMBLE MAGNA-FLUX	1-15-03	RL
600	PROOF INSPECTED	1-16-03	RW
605	CHECK HEADSPACE 1-17-2003	1-16-03	RW
610	DIS-ASSEMBLE GUN	1-16-03	RW
612	MAGNAFLUX OPERATOR <i>RA</i>		
615	ROLLMARK CALIBER		
618	ROTO-BLAST	1-21-03	<i>RA</i>
620	APPLY COATINGS	1-22	<i>RA</i>
625 A	FINAL ASSEMBLY	1-23-03	RW
B	TRIGGER PULL TEST		
C	SAFETY "ON" FORCE		
D	SAFETY "OFF" FORCE		
E	FIRING PIN INDENT		
640	TARGET	1-28-03	<i>AC</i>
655	FINAL INSPECT	1-29-03	<i>RA</i>
660	PACK	1-29-03	<i>DA</i>
		SHIP DATE	
	QAR INSPECTION DATE		

