

G 6590169
Ryphar
C-622549

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: RE00146049

Serial: G6590169 Model M24 SWS Center Fire
Caliber: 7.62 NATO

Repairman:

Verify Repair

Status: Closed 6/3/2008 9:50:39 AM

Address Information

Customer:

☒ Received From

Return To:

☐ Received From

Name: INSTALLATION SERIALIZATION OFFICER

INSTALLATION SERIALIZATION OFFICER

Address 1: BLDG 7920

BLDG 7920

Address 2: PO Box:

PO Box:

City: FT. RILEY

FT. RILEY

State: KS Zip Code: 66442

Country: US

State: KS Zip Code: 66442

Country: US

FFL:

Contact / Condition

Problems

Estimate

History / Status

Shipping / Billing

Contact Information

Received Condition

Accessories Received

Phone: NN

Fax:

Email:

Comments:

Fair

Condition
Notes:CSR
Notes:

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

Repair Search

Refresh

Close

nagletj

6/3/2008

12:58 PM

CAPS

NUM

JNS

LOCK



Number: G6590169

Model: M24 SWS



RE00146049

INSPECTION CHECKLIST - REPAIRS

CONTRACT #: W52H09-07-C-0207

ISSUED 10/1/2007

R & E NUMBER

146049

SERIAL NUMBER

G6590169

LOG-IN DATE

6-3-09

OPERATION #	OPERATION NAME	DATE	INITIAL
500	DIS-ASSEMBLE GUN	5-21-09	RTZ
505	RE-BARREL	5-26-09	RTZ
420	ASSEMBLE	5-26-09	RTZ
440	PROOF	5-26-09	RTZ
460	CHECK HEADSPACE	5-26-09	RTZ
470	DIS-ASSEMBLE GUN	5-26-09	RTZ
480	MAGNAFLUX	5-26-09	RTZ
510	DRILL AND TAP	5-27-09	RTZ
500	ROLLMARK CALIBER	6/1/09	RT
520	GOFF BLAST BBL / REC	6-1-09	DLWD
530 & 540	APPLY COATINGS	6/1/09	RTZ
560	FINAL ASSEMBLY	6-4-09	RTZ
640	FUNCTION TEST AND	6/5/09	RB
650	TARGET	6/5/09	RB
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
670	FINAL INSPECTION	6/5/09	TGR
	A) HEADSPACE	6-5-09	RTZ
	B) TRIGGER PULL	2.44 2.41 2.38 2.42 2.44	6-5-09 RTZ
680	F) SAFETY ON FORCE	4.0 4.0 4.0	6-5-09 RTZ
	G) SAFETY OFF FORCE	5.0 5.0 5.0	6-5-09 RTZ
	I) FIRING PIN INDENT	.021 .021 .021	6-5-09 RTZ
690	PACK	6/5/09	RTZ

F006 REV 1/2009

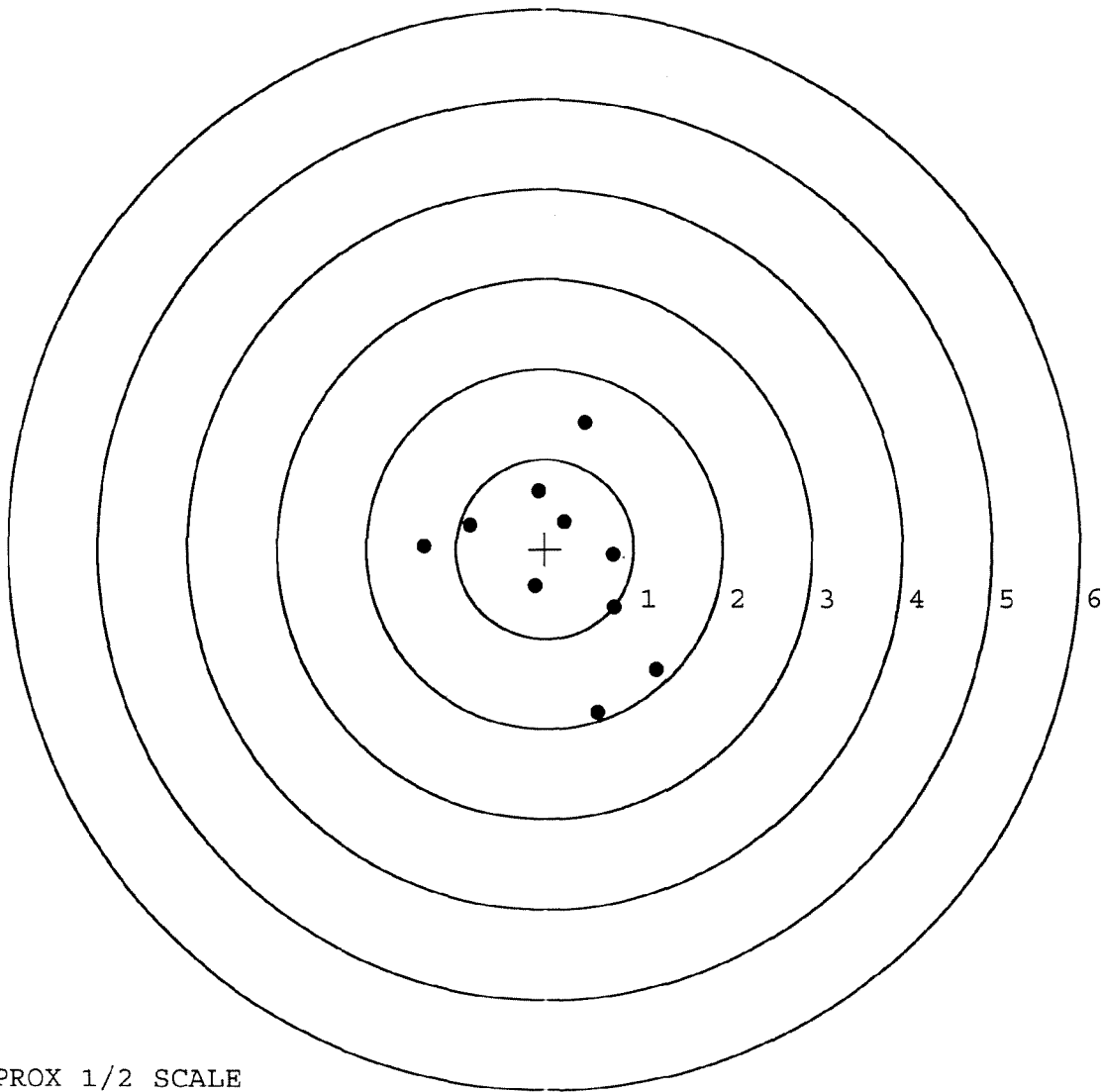
SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6590169.__0
FILE DATE AND TIME: 10/15/2007 14:33

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.035
The Average Y Centroid of the Five Target Set:	-0.068
The Average Point of Impact of the Five Target Set:	0.077
The Average Mean Radius of the Five Target Set:	0.826
The Distance from POA to Centroid Target #1:	0.233
The Distance from Centroid Target #2 to Centroid Target #1:	0.309
The Distance from Centroid Target #3 to Centroid Target #1:	0.235
The Distance from Centroid Target #4 to Centroid Target #1:	0.408
The Distance from Centroid Target #5 to Centroid Target #1:	0.320

SERIAL NUMBER: G6590169. __0	POINT#	X	Y
TARGET NUMBER: 1	1:	1.258	-1.349
FILE DATE: 10/15/2007	2:	0.587	-1.825
FILE TIME: 14:33	3:	0.779	-0.648
	4:	0.768	-0.065
X CENTROID: 0.166	5:	0.215	0.313
Y CENTROID: -0.163	6:	-0.078	0.646
POA TO CENTROID: 0.233	7:	-0.117	-0.418
HORZ SPREAD: 2.611	8:	-0.845	0.268
VERT SPREAD: 3.238	9:	-1.353	0.031
GROUP SPREAD: 3.241	10:	0.449	1.413
MIN RADIUS: 0.381			
MAX RADIUS: 1.714			
MEAN RADIUS: 1.065			
# IN 1 IN DIAMETER: 2			
# IN 2 IN DIAMETER: 5			
# in 3 IN DIAMETER: 6			



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590169. 0

TARGET NUMBER: 2

FILE DATE: 10/15/2007

FILE TIME: 14:33

X CENTROID: -0.062

Y CENTROID: 0.045

POA TO CENTROID: 0.077

HORZ SPREAD: 1.832

VERT SPREAD: 2.000

GROUP SPREAD: 2.074

MIN RADIUS: 0.275

MAX RADIUS: 1.156

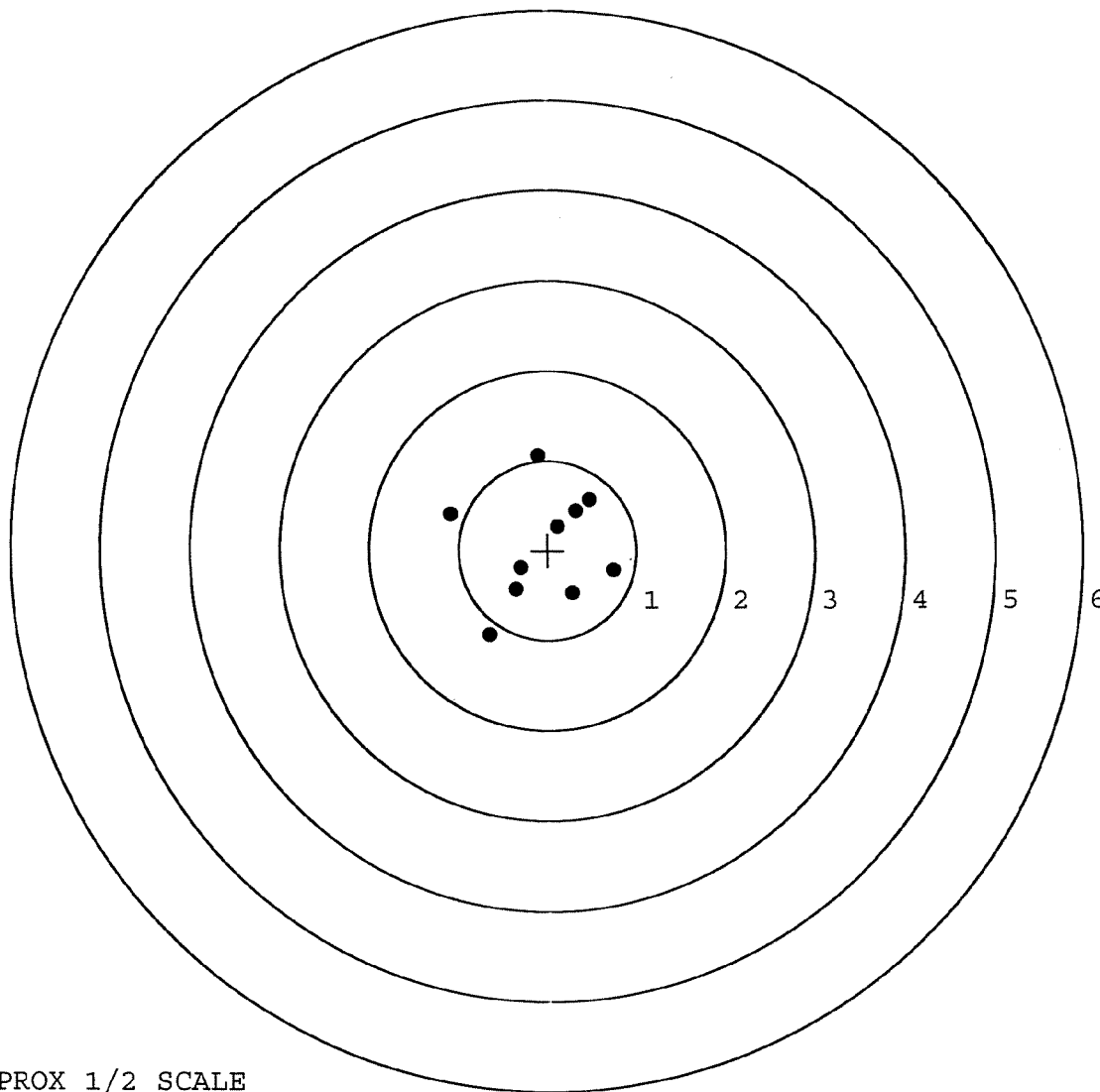
MEAN RADIUS: 0.721

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.107	1.054
2:	-1.093	0.408
3:	0.469	0.567
4:	0.317	0.441
5:	0.107	0.262
6:	0.739	-0.222
7:	0.277	-0.475
8:	-0.310	-0.198
9:	-0.364	-0.439
10:	-0.656	-0.946



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590169. 0

TARGET NUMBER: 3

FILE DATE: 10/15/2007

FILE TIME: 14:33

X CENTROID: -0.059

Y CENTROID: -0.229

POA TO CENTROID: 0.236

HORZ SPREAD: 1.805

VERT SPREAD: 2.512

GROUP SPREAD: 2.863

MIN RADIUS: 0.315

MAX RADIUS: 1.774

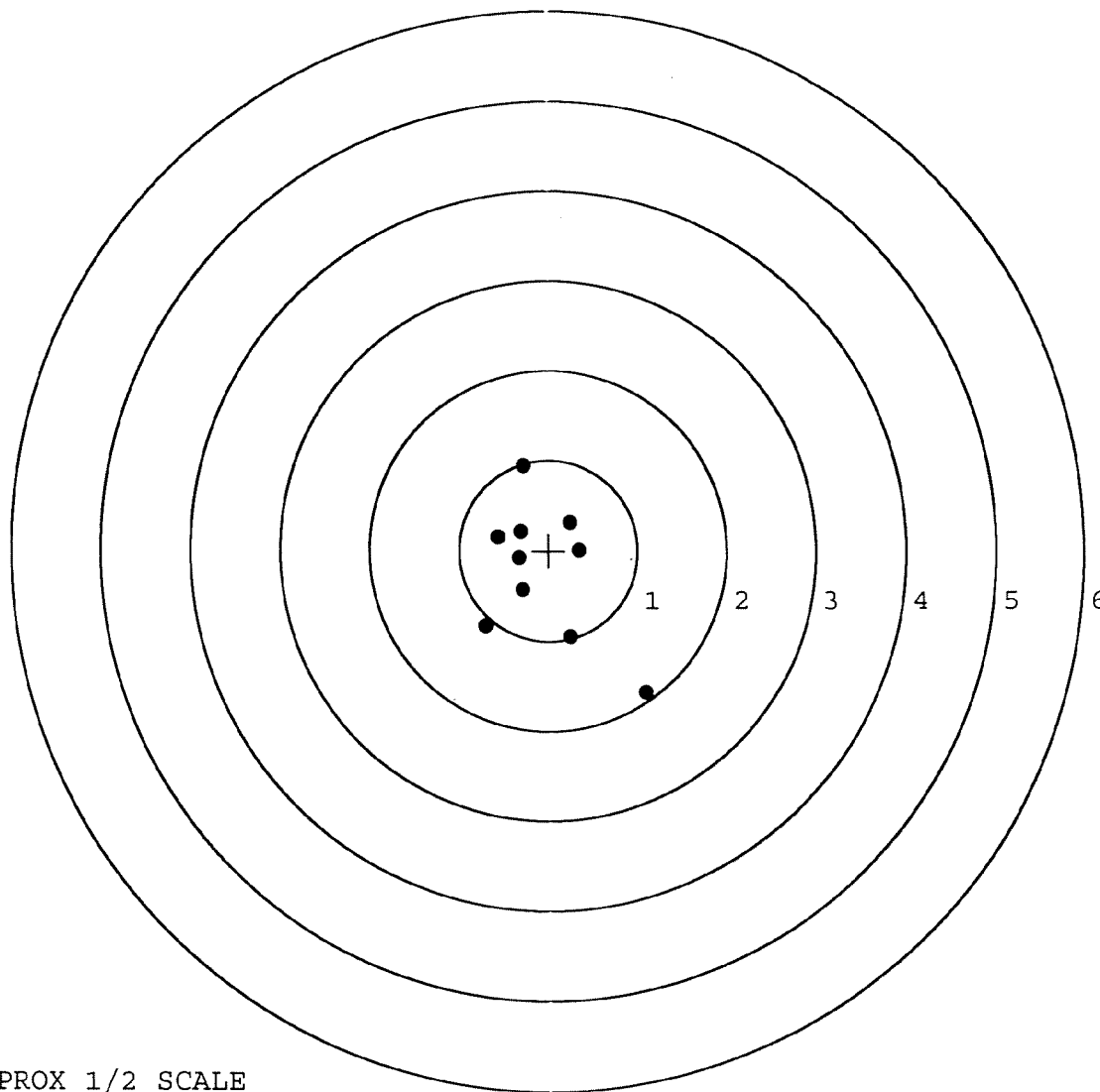
MEAN RADIUS: 0.749

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 9

POINT#	X	Y
1:	1.092	-1.578
2:	0.242	-0.954
3:	-0.713	-0.835
4:	0.346	-0.002
5:	0.246	0.307
6:	-0.282	0.934
7:	-0.568	0.150
8:	-0.339	-0.083
9:	-0.298	-0.437
10:	-0.319	0.210



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590169. 0

TARGET NUMBER: 4

FILE DATE: 10/15/2007

FILE TIME: 14:33

X CENTROID: -0.064

Y CENTROID: 0.173

POA TO CENTROID: 0.185

HORZ SPREAD: 1.675

VERT SPREAD: 3.104

GROUP SPREAD: 3.305

MIN RADIUS: 0.235

MAX RADIUS: 1.767

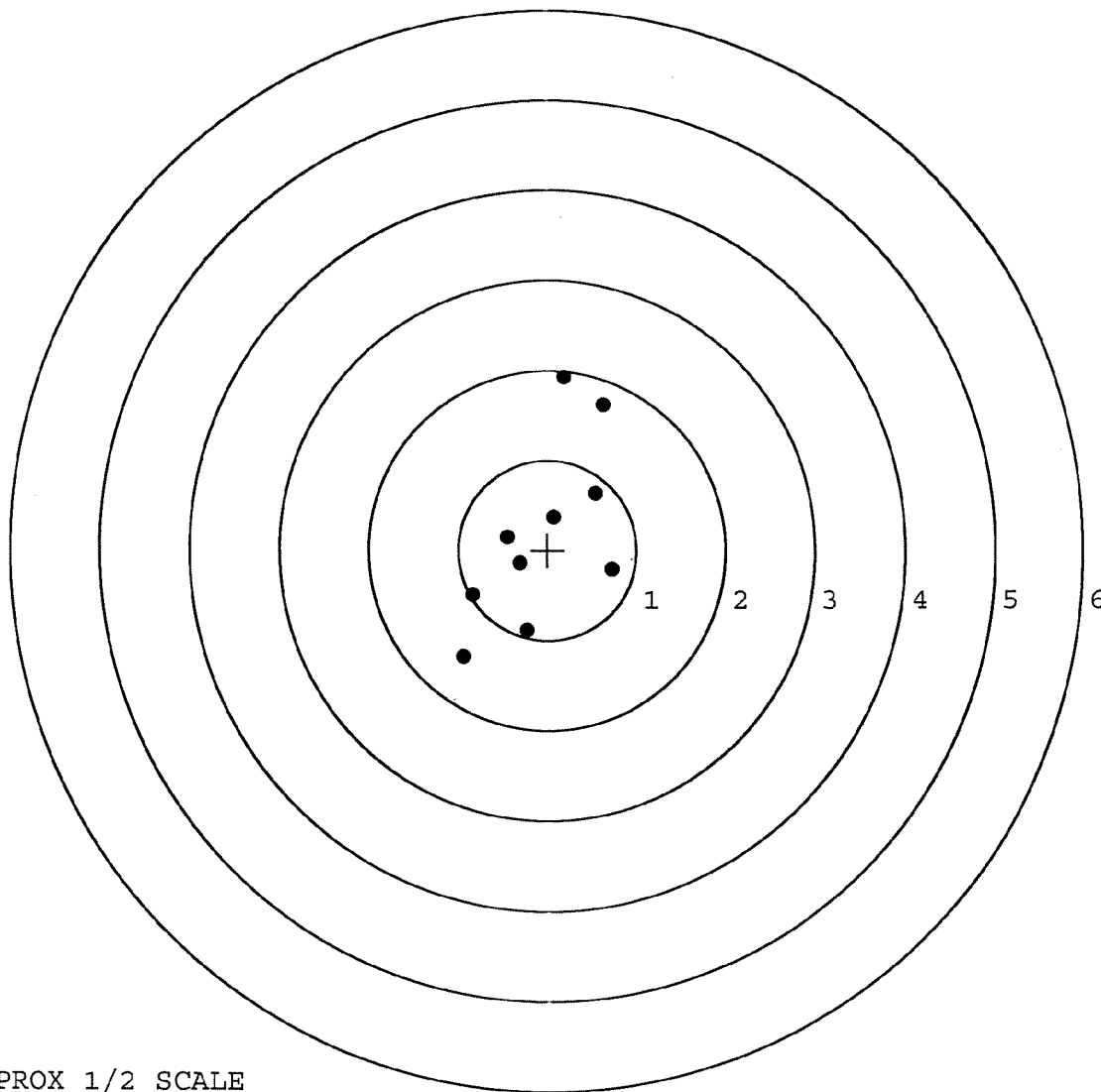
MEAN RADIUS: 0.978

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 5

in 3 IN DIAMETER: 7

POINT#	X	Y
1:	0.726	-0.219
2:	0.545	0.628
3:	0.073	0.364
4:	-0.318	-0.152
5:	-0.457	0.145
6:	-0.844	-0.495
7:	-0.236	-0.896
8:	-0.949	-1.182
9:	0.633	1.617
10:	0.187	1.922



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590169. 0

TARGET NUMBER: 5

FILE DATE: 10/15/2007

FILE TIME: 14:33

X CENTROID: -0.153

Y CENTROID: -0.168

POA TO CENTROID: 0.227

HORZ SPREAD: 1.728

VERT SPREAD: 0.876

GROUP SPREAD: 1.830

MIN RADIUS: 0.258

MAX RADIUS: 0.974

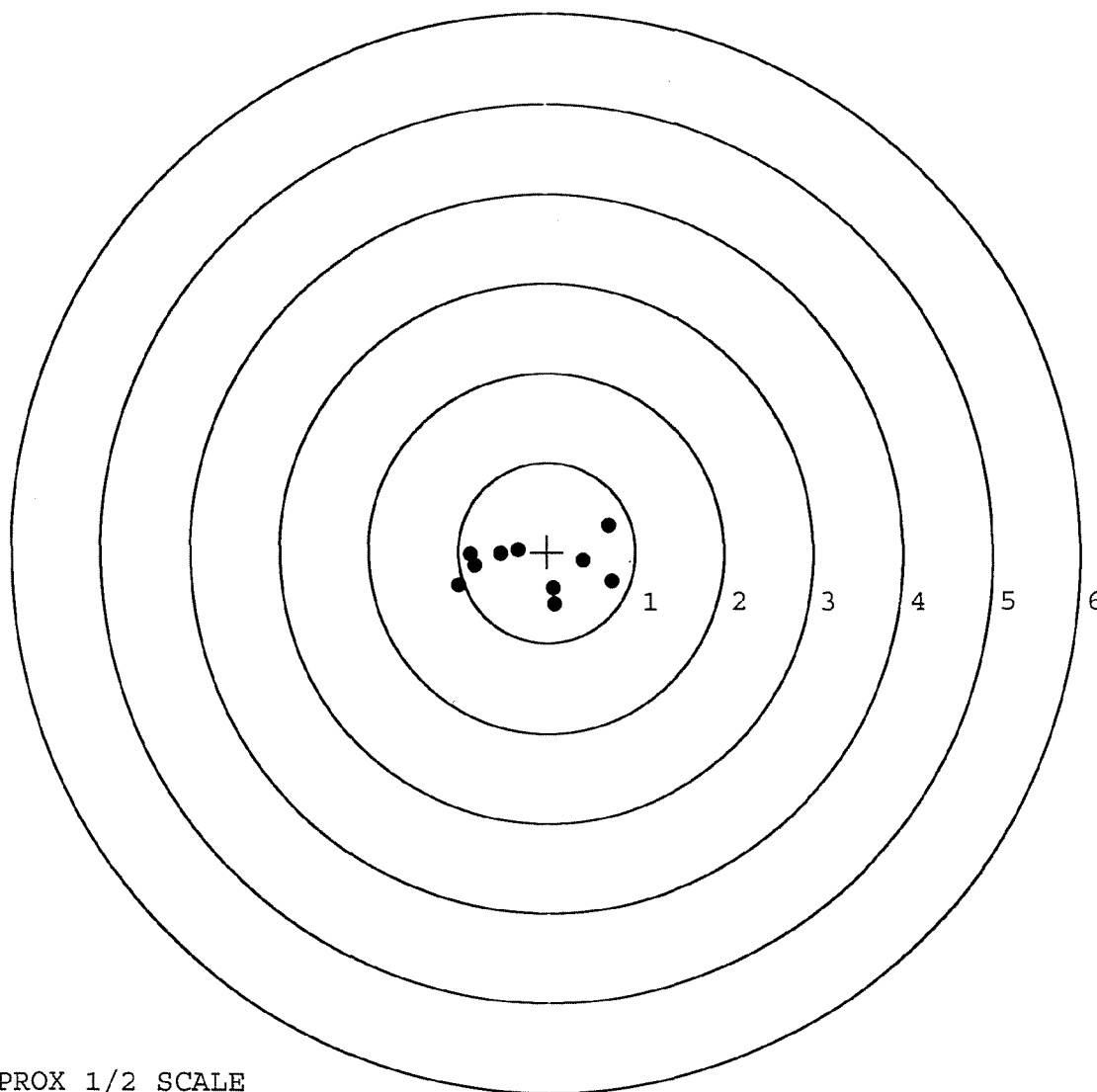
MEAN RADIUS: 0.616

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.728	-0.332
2:	0.411	-0.097
3:	0.703	0.295
4:	0.067	-0.408
5:	0.086	-0.581
6:	-0.327	0.023
7:	-0.525	-0.022
8:	-0.862	-0.027
9:	-0.816	-0.155
10:	-1.000	-0.375



TARGET APPROX 1/2 SCALE

Scope Case
Deployment Kit
Soft Case
Ching

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: RE00133025

Serial: C6225491 Model M24 SWS Center Fire
Caliber: 7.62 NATO Produced: 12/20/1988

Repairman:

Verify Repair

High Priority

Status:

Closed 8/22/2007 7:13:32 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

7:54 AM

CAPS

NUM

INS

SCRL

start

Inbox - Mic...

Calendar - M...

FW: Restrict...

Arms Service...

7:54 AM

Serial Number: ~~C6225491~~

Model: M24 SWS



RE00133025

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6590169.___0
FILE DATE AND TIME: 10/15/2007 14:33

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.035
The Average Y Centroid of the Five Target Set:	-0.068
The Average Point of Impact of the Five Target Set:	0.077
The Average Mean Radius of the Five Target Set:	0.826
The Distance from POA to Centroid Target #1:	0.233
The Distance from Centroid Target #2 to Centroid Target #1:	0.309
The Distance from Centroid Target #3 to Centroid Target #1:	0.235
The Distance from Centroid Target #4 to Centroid Target #1:	0.408
The Distance from Centroid Target #5 to Centroid Target #1:	0.320

SERIAL NUMBER: G6590169. 0

TARGET NUMBER: 1

FILE DATE: 10/15/2007

FILE TIME: 14:33

X CENTROID: 0.166

Y CENTROID: -0.163

POA TO CENTROID: 0.233

HORZ SPREAD: 2.611

VERT SPREAD: 3.238

GROUP SPREAD: 3.241

MIN RADIUS: 0.381

MAX RADIUS: 1.714

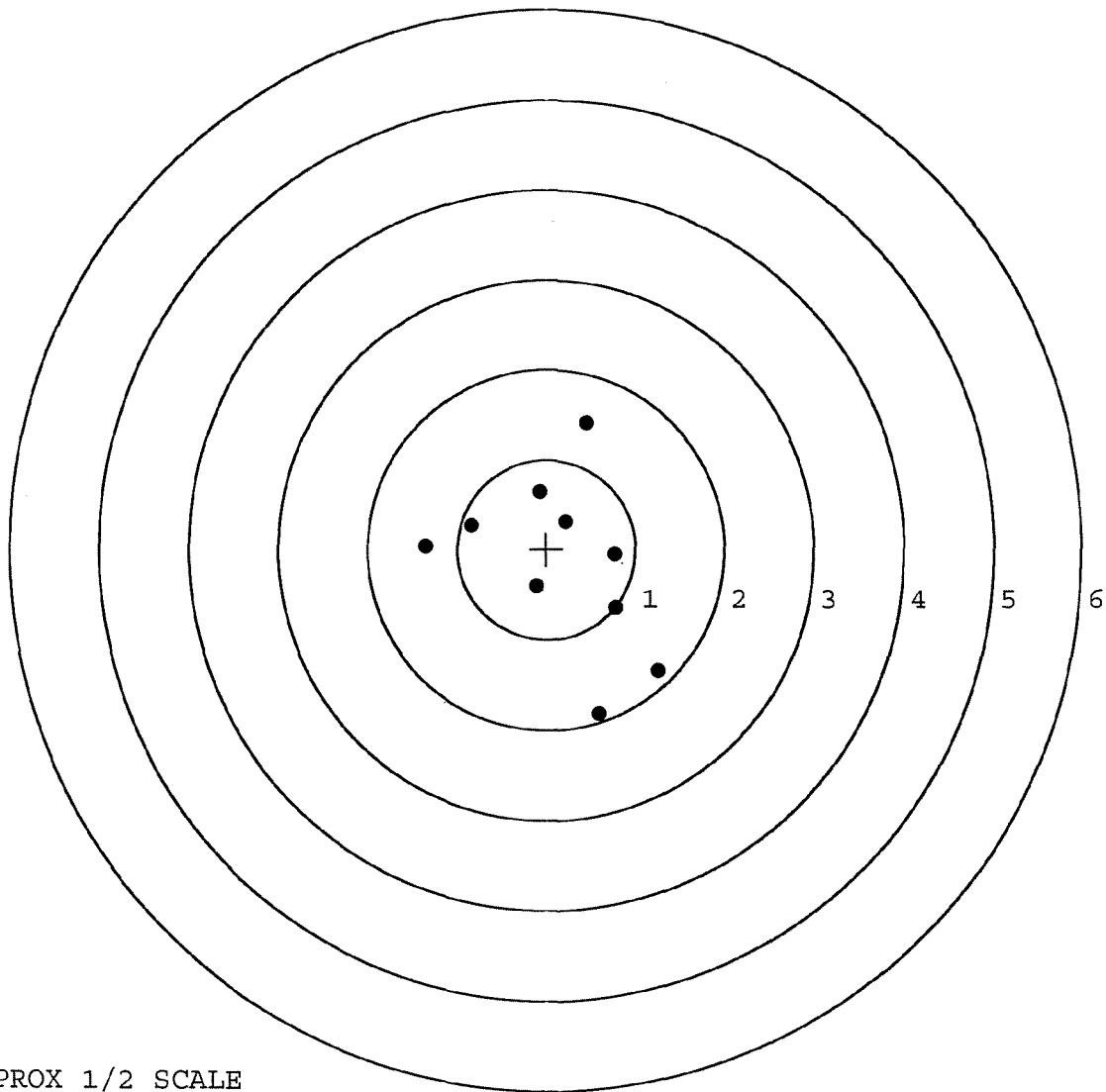
MEAN RADIUS: 1.065

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 5

in 3 IN DIAMETER: 6

POINT#	X	Y
1:	1.258	-1.349
2:	0.587	-1.825
3:	0.779	-0.648
4:	0.768	-0.065
5:	0.215	0.313
6:	-0.078	0.646
7:	-0.117	-0.418
8:	-0.845	0.268
9:	-1.353	0.031
10:	0.449	1.413



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590169. 0

TARGET NUMBER: 2

FILE DATE: 10/15/2007

FILE TIME: 14:33

X CENTROID: -0.062

Y CENTROID: 0.045

POA TO CENTROID: 0.077

HORZ SPREAD: 1.832

VERT SPREAD: 2.000

GROUP SPREAD: 2.074

MIN RADIUS: 0.275

MAX RADIUS: 1.156

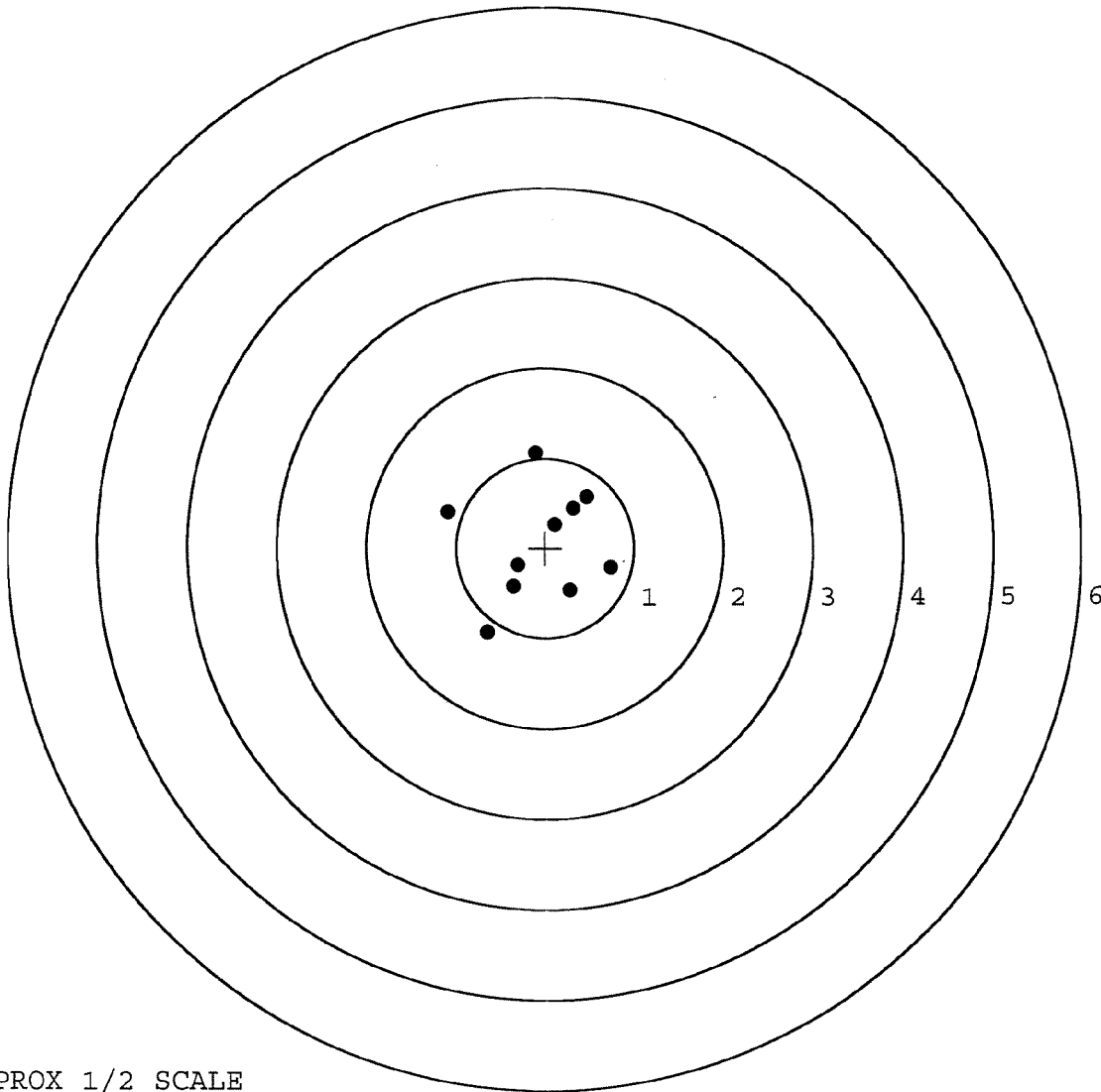
MEAN RADIUS: 0.721

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.107	1.054
2:	-1.093	0.408
3:	0.469	0.567
4:	0.317	0.441
5:	0.107	0.262
6:	0.739	-0.222
7:	0.277	-0.475
8:	-0.310	-0.198
9:	-0.364	-0.439
10:	-0.656	-0.946



TARGET APPROX 1/2 SCALE

BARBER - M24 0165999

SERIAL NUMBER: G6590169. __0

TARGET NUMBER: 3

FILE DATE: 10/15/2007

FILE TIME: 14:33

X CENTROID: -0.059

Y CENTROID: -0.229

POA TO CENTROID: 0.236

HORZ SPREAD: 1.805

VERT SPREAD: 2.512

GROUP SPREAD: 2.863

MIN RADIUS: 0.315

MAX RADIUS: 1.774

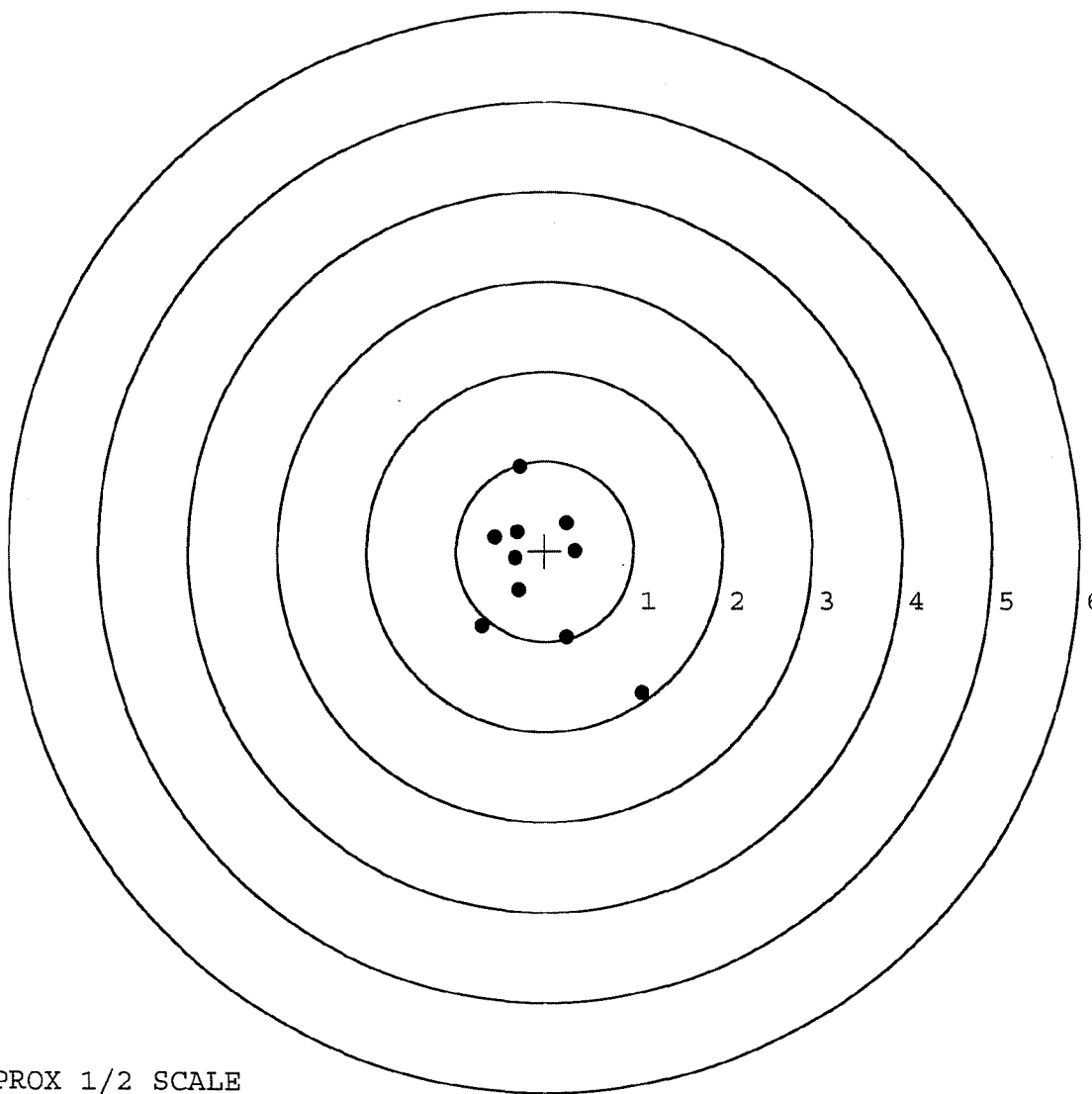
MEAN RADIUS: 0.749

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 9

POINT#	X	Y
1:	1.092	-1.578
2:	0.242	-0.954
3:	-0.713	-0.835
4:	0.346	-0.002
5:	0.246	0.307
6:	-0.282	0.934
7:	-0.568	0.150
8:	-0.339	-0.083
9:	-0.298	-0.437
10:	-0.319	0.210



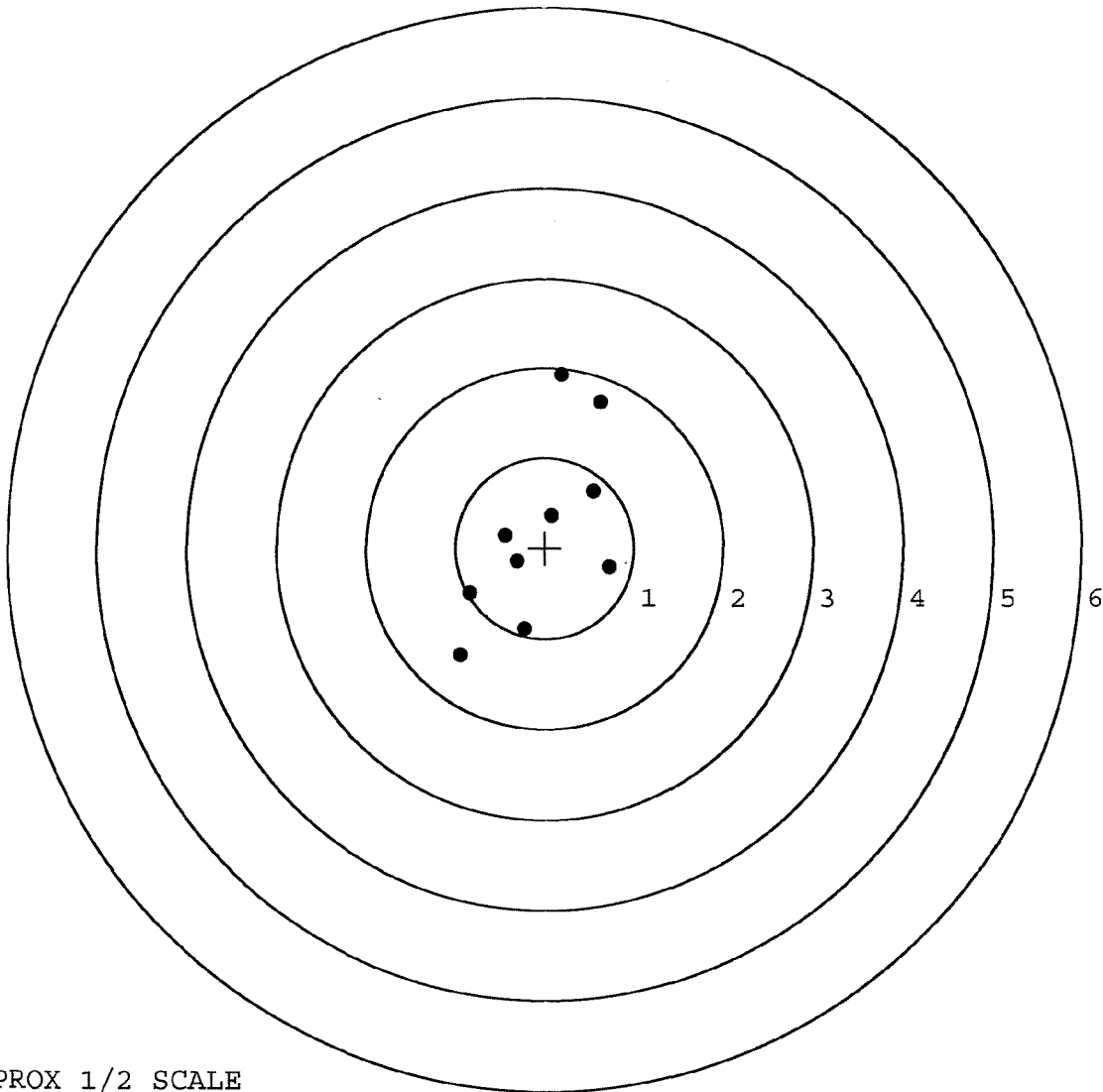
TARGET APPROX 1/2 SCALE

BARBER - M24 0166000

SERIAL NUMBER: G6590169. __0
 TARGET NUMBER: 4
 FILE DATE: 10/15/2007
 FILE TIME: 14:33

POINT#	X	Y
1:	0.726	-0.219
2:	0.545	0.628
3:	0.073	0.364
4:	-0.318	-0.152
5:	-0.457	0.145
6:	-0.844	-0.495
7:	-0.236	-0.896
8:	-0.949	-1.182
9:	0.633	1.617
10:	0.187	1.922

X CENTROID: -0.064
 Y CENTROID: 0.173
 POA TO CENTROID: 0.185
 HORZ SPREAD: 1.675
 VERT SPREAD: 3.104
 GROUP SPREAD: 3.305
 MIN RADIUS: 0.235
 MAX RADIUS: 1.767
 MEAN RADIUS: 0.978
 # IN 1 IN DIAMETER: 3
 # IN 2 IN DIAMETER: 5
 # in 3 IN DIAMETER: 7

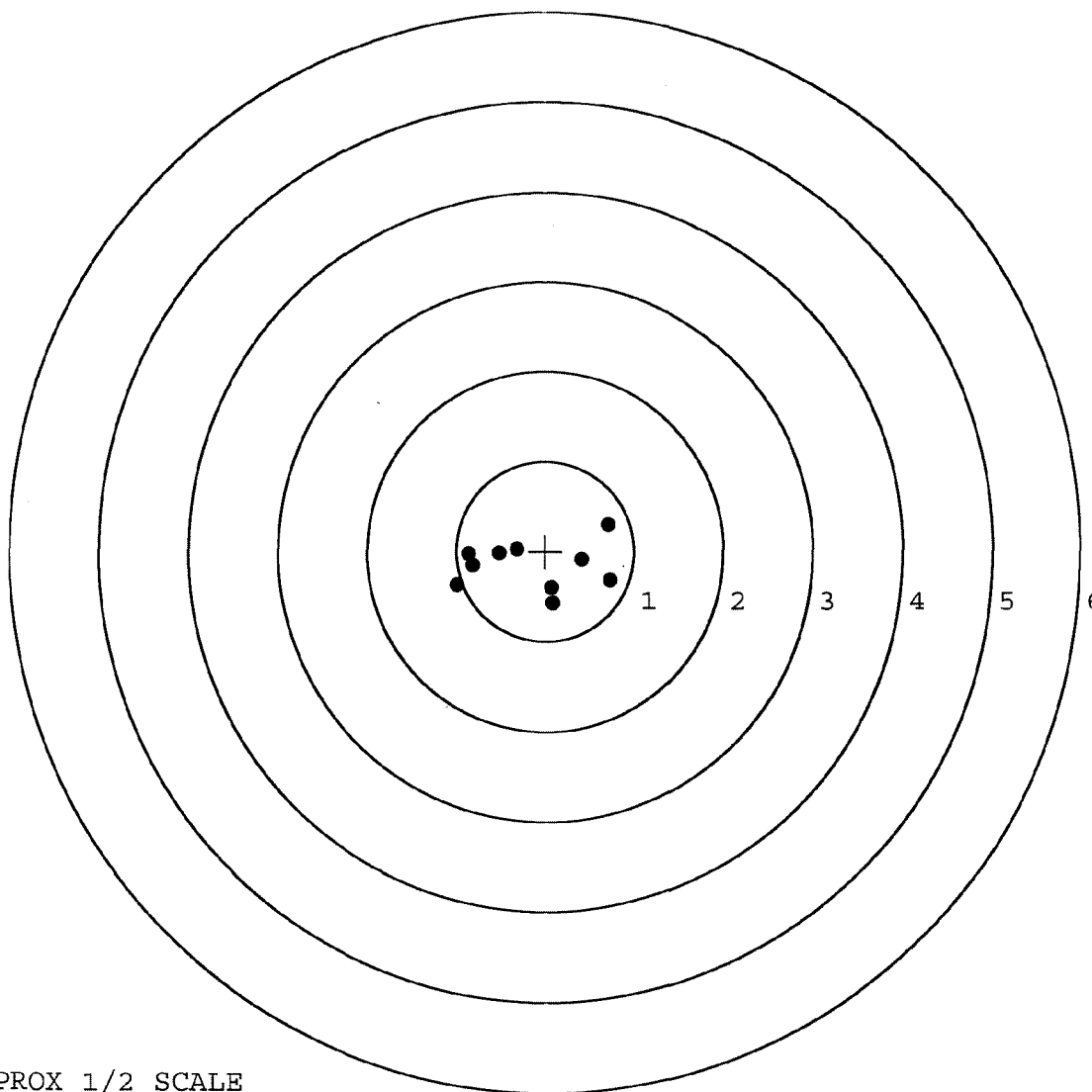


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590169. __0
 TARGET NUMBER: 5
 FILE DATE: 10/15/2007
 FILE TIME: 14:33

POINT#	X	Y
1:	0.728	-0.332
2:	0.411	-0.097
3:	0.703	0.295
4:	0.067	-0.408
5:	0.086	-0.581
6:	-0.327	0.023
7:	-0.525	-0.022
8:	-0.862	-0.027
9:	-0.816	-0.155
10:	-1.000	-0.375

X CENTROID: -0.153
 Y CENTROID: -0.168
 POA TO CENTROID: 0.227
 HORZ SPREAD: 1.728
 VERT SPREAD: 0.876
 GROUP SPREAD: 1.830
 MIN RADIUS: 0.258
 MAX RADIUS: 0.974
 MEAN RADIUS: 0.616
 # IN 1 IN DIAMETER: 4
 # IN 2 IN DIAMETER: 10
 # in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

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

R & E NUMBER

133 625

SERIAL NUMBER

~~2622491~~

(6590169 New)

LOG-IN DATE

8-22-07

OPERATION #	OPERATION NAME		DATE	INITIAL
500	DIS-ASSEMBLE GUN		10-1-07	RTZ
505	RE-BARREL		10-3-07	RTZ
560	ASSEMBLE		10-3-07	RTZ
600	PROOF	MAGNA-FLUX	10-4-07	TRW
605	CHECK HEADSPACE	UCI 05 2007	10-4-07	TRW
610	DIS-ASSEMBLE GUN		10-4-07	TRW
612	MAGNAFLUX	OPERATOR <i>unus</i>	10-5-07	unus
510	DRILL AND TAP		10-5-07	FM
615	ROLLMARK CALIBER		10-5-07	CW
618	ROTO-BLAST		10-8-07	JY
620	APPLY COATINGS		10-9-07	RS
625	FINAL ASSEMBLY		10-11-07	RTZ
640	FUNCTION TEST AND	(PASS) FAIL	10-13-07	TRW
650	TARGET	(PASS) FAIL	10-13-07	TRW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
670	FINAL INSPECTION		10-13-07	DR
	A) HEADSPACE	(PASS) FAIL	10-22-07	RTZ
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	277 283 282 263 254 10-14-07	unus
680	F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX	55 55 55 10-22-07	DA
	G) SAFETY OFF FORCE	2 LBS MIN	25 25 25 10-22-07	DA
	I) FIRING PIN INDENT	.020	1021 .021 0215 10-22-07	DA
690	PACK		10-22-07	DA

GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6225491

*Repair
New Barrel*

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		1/5/93	RW
600	Proof		1/5/93	RW
607	Check Headspace		1/5/93	RW
610	Dis-assemble Gun		1/5/93	RW
612	Magnaflux Barrel Action			
	Magnaflux Bolt			
615	Rollmark Caliber			
617	Drill and Tap Sight Holes			
618	Polish Barrel			
620	Apply Coatings (Barrel Action)			
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		1/12/93	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		1/12/93	RW
	C) Inspect Ejector Hole for Chamfer		1/12/93	RW
	D) Oil Firing Pin Ass'y		1/12/93	RW
	E) Adjust Trigger Pull to Min Setting and Stake			

BARBER - M24 0166004

op. #	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						1/13/93	RW
	A) Time							
	B) Malfunctions							
	C) Pierced Primers							
	D) Optical Clarity of Scope							
645	Inspect for Live Ammo						1/13/93	RW
655	Final Inspection							
	A) Headspace						1/13/93	RW
	B) Trigger Pull	2.28	2.26	2.25	2.24	2.24	1/13/93	RW
	C) Function						1/13/93	RW
660	Pack							

C6225491

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6225491
14 Jan 1993

CENTROIDAL DISTANCES

Ø TO	1	.647038
1 TO	2	.988104
1 TO	3	1.34387
1 TO	4	.870664
1 TO	5	.568679

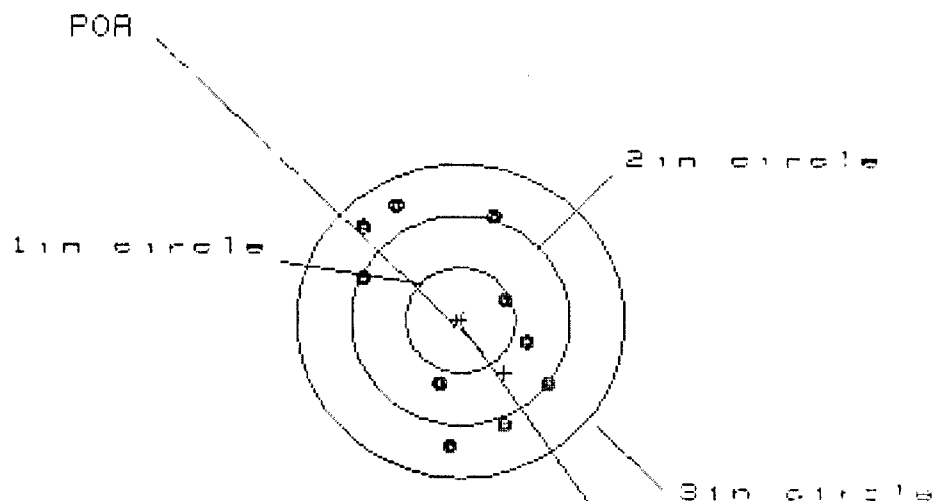
45
2 + <----POR
3

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.9614
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0476
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .962578
THE AMR FOR THIS RIFLE IS: .9752

14 Jan 1993

FILE: \PATTERNING\CENTERFIRE_PATT\06225491

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 4

3 in = 10

HDI = 1.741

VSE = 2.314

USE = 2.398

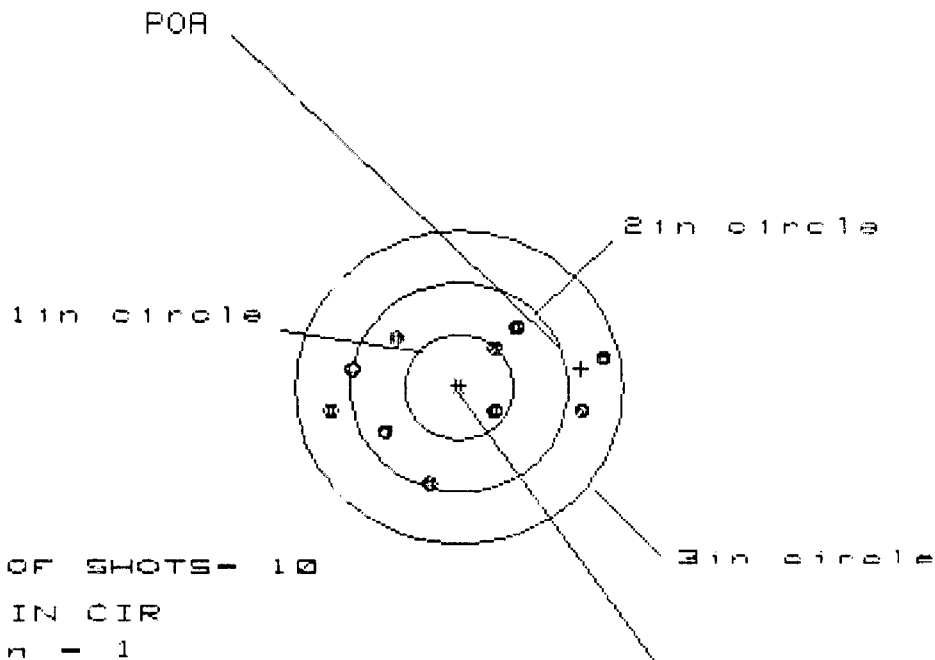
PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.817	.747	.632
MINIMUM X	:	-.924	-.994	-1.109
MAXIMUM Y	:	1.133	1.153	1.203
MINIMUM Y	:	-1.181	-1.055	-.925
CENTROID X	:	-.407	-.337	-.222
CENTROID Y	:	.503	.377	.247
POA TO CENTROID in.	:	.647	.506	.332
MIN RADIUS	:	.459	.457	.458
MEAN RADIUS	:	.964	.902	.805
MAX RADIUS	:	1.294	1.387	1.299
HORIZONTAL SPREAD	:	1.741	1.741	1.741
VERTICAL SPREAD	:	2.314	2.208	2.208
EXTREME SPREAD	:	2.398	2.317	2.235
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	4		
NUMBER IN THREE INCH CIRCLE	=	10		

14 Jan 1993

FILE:/PATTERNING/CENTERFIRE_PATT/06225491

CENTERFIRE PATTERNS

2



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 6

3 in = 10

HS = 2.530

VS = 1.512

GS = 2.570

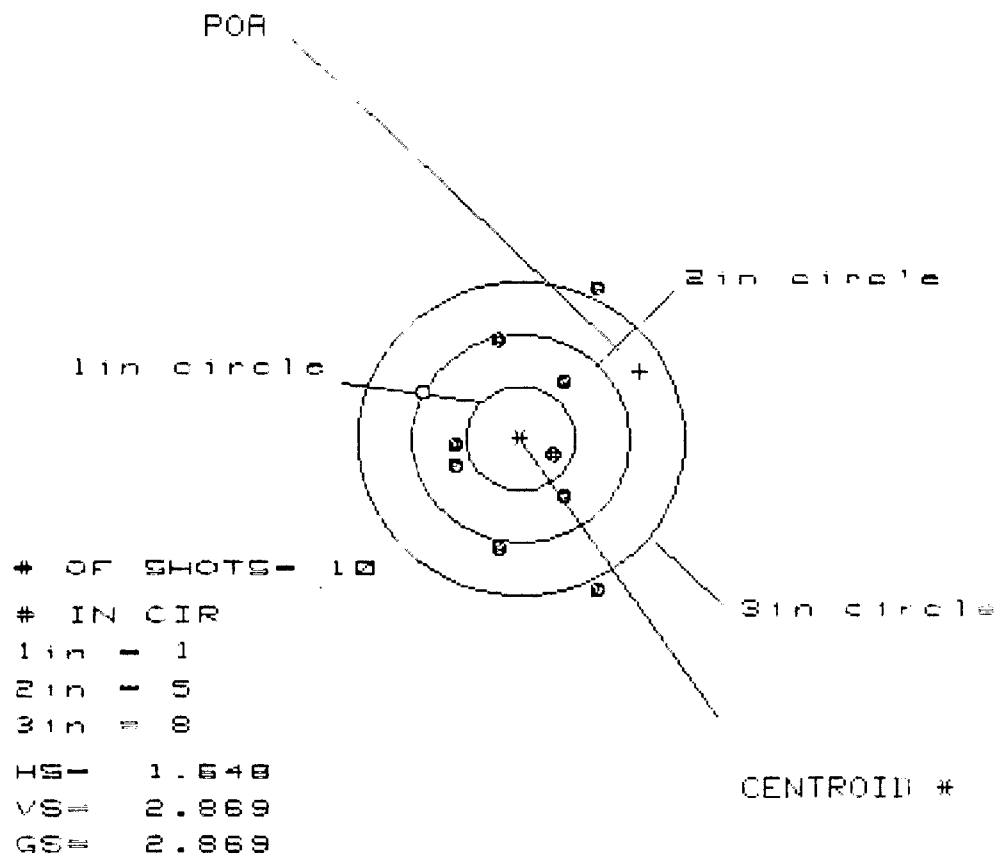
PATTERN #	:	20		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.364	1.269	1.143
MINIMUM X	:	-1.166	-1.015	-.981
MAXIMUM Y	:	.574	.601	.578
MINIMUM Y	:	-.938	-.911	-.934
CENTROID X	:	-1.122	-1.273	-1.147
CENTROID Y	:	-.179	-.206	-.183
POA TO CENTROID in.	:	1.136	1.290	1.161
MIN RADIUS	:	.423	.547	.442
MEAN RADIUS	:	.898	.836	.802
MAX RADIUS	:	1.385	1.279	1.156
HORIZONTAL SPREAD	:	2.530	2.284	2.124
VERTICAL SPREAD	:	1.512	1.512	1.512
EXTREME SPREAD	:	2.570	2.284	2.160
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	

14 Jan 1993

FILE: /PATTERNING/CENTERFIRE_PATT/06225491

CENTERFIRE PATTERNS

3

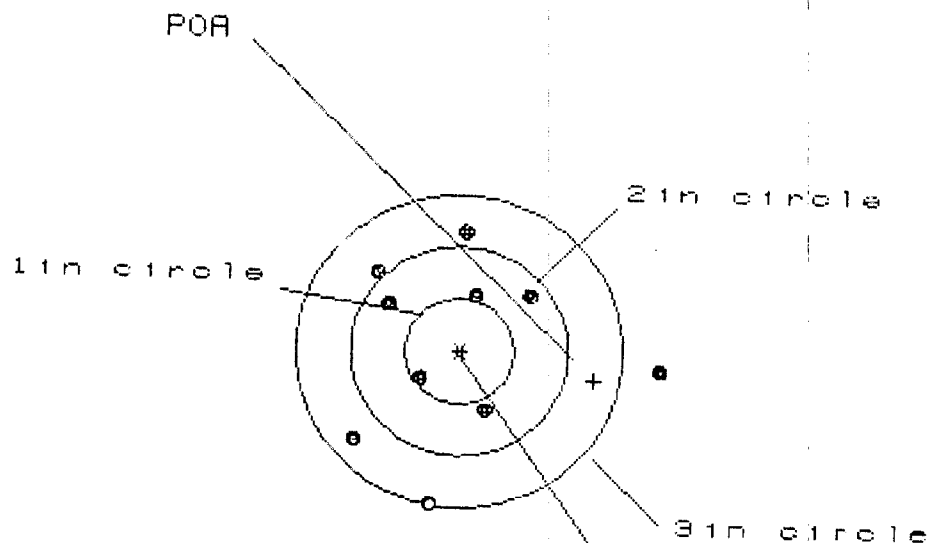


PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.733	.815	.590
MINIMUM X	-.915	-.833	-.732
MAXIMUM Y	1.452	1.155	.998
MINIMUM Y	-1.417	-1.255	-1.032
CENTROID X	-1.094	-1.176	-1.277
CENTROID Y	-.652	-.814	-.657
POA TO CENTROID in.	1.274	1.430	1.436
MIN RADIUS	.284	.342	.423
MEAN RADIUS	.917	.824	.728
MAX RADIUS	1.626	1.497	1.032
HORIZONTAL SPREAD	1.648	1.648	1.312
VERTICAL SPREAD	2.869	2.410	2.030
EXTREME SPREAD	2.869	2.577	2.030
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	8		

14 Jan 1993

FILE:/PATTERNING/CENTERFIRE_PATT/C6225491

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 9

HS= 2.810

VS= 2.552

GS= 2.885

CENTROID *

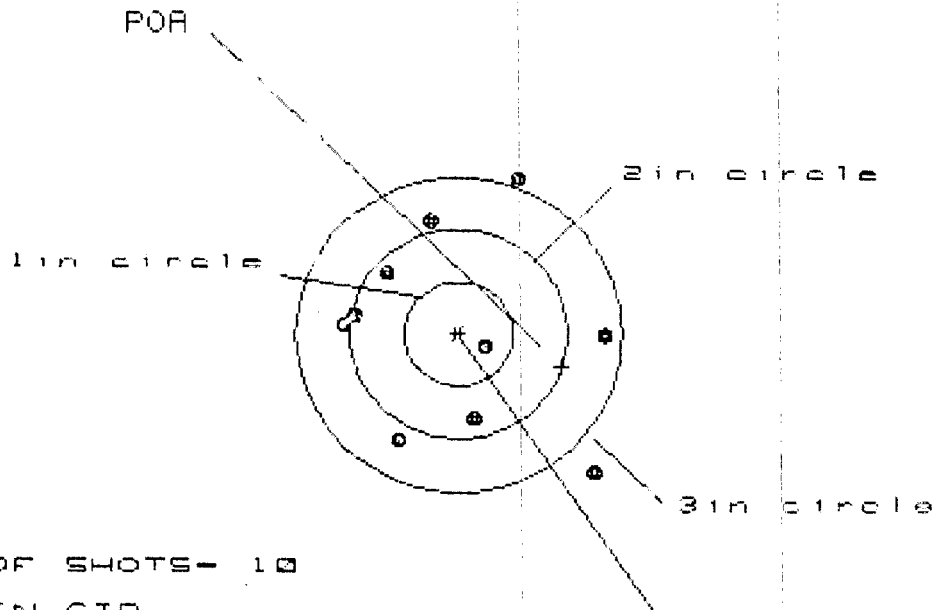
PATTERN #	:	4	9	8
SHOTS (BEST OF)	:	10		
MAXIMUM X	:	1.885	.857	.848
MINIMUM X	:	-.925	-.715	-.724
MAXIMUM Y	:	1.111	1.089	.906
MINIMUM Y	:	-1.441	-1.463	-1.058
CENTROID X	:	-1.241	-1.451	-1.442
CENTROID Y	:	.253	.275	.458
POA TO CENTROID in.	:	1.267	1.477	1.513
MIN RADIUS	:	.452	.339	.462
MEAN RADIUS	:	.997	.873	.777
MAX RADIUS	:	1.896	1.465	1.282
HORIZONTAL SPREAD	:	2.810	1.572	1.572
VERTICAL SPREAD	:	2.552	2.552	1.964
EXTREME SPREAD	:	2.885	2.573	2.191
NUMBER IN ONE INCH CIRCLE =	:	1		
NUMBER IN TWO INCH CIRCLE =	:	5		
NUMBER IN THREE INCH CIRCLE =	:	9		

14 Jan 1993

FILE: PATTERNING/CENTERFIRE_PATT/C6225491

CENTERFIRE PATTERNS

5



OF SHOTS - 10

IN CIR

1 in = 1

2 in = 4

3 in = 8

HS = 2.388

VS = 2.809

GS = 2.901

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.307	1.447	1.531
MINIMUM X	-1.081	-.941	-.857
MAXIMUM Y	1.471	1.322	1.108
MINIMUM Y	-1.338	-1.166	-1.001
CENTROID X	-.943	-1.083	-1.167
CENTROID Y	.313	.462	.297
POA TO CENTROID in.	.994	1.177	1.204
MIN RADIUS	.270	.472	.467
MEAN RADIUS	1.100	1.001	.921
MAX RADIUS	1.837	1.484	1.551
HORIZONTAL SPREAD	2.388	2.388	2.388
VERTICAL SPREAD	2.809	2.488	2.109
EXTREME SPREAD	2.901	2.722	2.388
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	8		

RECEIVING AND ESTIMATING REPORT

COMMENTS

ORDER

R92-28112

INITIAL CUSTOMER ORDER NO.

M24 W/ULTRA 10X-M3A SCOPE

W/BI POD & ADJUSTABLE RECOIL PAD

FPS

DATE RECEIVED

DATE OPENED

DATE CODE

SERIAL NUMBER

NEW SERIAL NUMBER

MODEL AND GRADE

12/21/92

12/21/92

DI 9-88

C6225491

700 7.62

NATO/SWS

ACCESSORIES

W/STUDS

HARD CASE

SCOPE MNTS

SCOPE BASE

FROM:

SHIP TO:

CDR, 1ST BN 75TH RANGER REGT

ATTN CPT CHINN

AORG-FB-ACO

HAAF

GA 31409

CDR, 1ST BN 75TH RANGER REGT

ATTN CPT CHINN

AORG-FB-ACO

HAAF

GA

31409

ACCOUNT NUMBER

ACCOUNT NUMBER N/C

WRITE ☐

CLEAN/TEST

PROM. DATE

ESTIMATED

VIA

UPS

GUN CONDITION

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

REPAIR CHARGE

EXCISE

TAX

INSURANCE

UPS

PARCEL POST

TOTAL

CUSTOMER CONCERN

AMMO

FUNCTION

FINISH

ACCURACY

FIT

INSPECT

CYCLE

A1

B1

TRIGGER GROUP

B2

E1

F1

BOLT ASSY.

B3

E2

F2

BARREL ASSY.

B4

D1

E3

F3

REC. ASSY.

B5

D2

E4

F4

WOOD

C1

D3

E5

F5

METAL

C2

MAIN FAULT

ARTS

COMMENTS

REPAIRMAN

PROOF

CLEAN

TEST

TARGET

PATTERN

GALLERY TESTER

DATE

DATE

DATE

DATE

DATE

OFFICE COPY

RD6925 REV. 1/92

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

BARBER - M24 M2400166051

MAINTENANCE REQUEST

PAGE NO.

NO. OF PAGES

REQUIREMENT CONTROL SYMBOL
CSGLD-1047(R1)

SECTION I – EQUIPMENT DATA

16a. REMARKS

SECTION II – WORK ACCOMPLISHED

1	TOTAL MANHOURS	
---	----------------	--

m. TOTAL MANHOURS COST	
------------------------	--

n. TOTAL PARTS COST	
---------------------	--

					S		S				
21. DELAY (Select one)		☒ 1 Parts		☒ 2 Manpower		☒ 3 Facilities		☒ 4 Funds		☒ 5 Tools	
23. SUBMITTED BY		24. RECEIVED BY		25. WORK STARTED BY		26. INSPECTED BY		27. ACCEPTED BY		28. DISPOSITION (Select one)	
JULIAN DATE		JULIAN DATE		JULIAN DATE		JULIAN DATE		JULIAN DATE		☒ A To User ☐ C Salvaged ☐ B To Stock ☐ D Evacuated ☐ E Cannibalization	

EDITION OF JUL 79 IS OBSOLETE.

BARBER - M24 0168943 66052

DA FORM 2404
1 APR 79

BARBER - M24 6168914 66053

Score #
1266

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6225491

OP. #	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and Stock	9 12	8 8	FB
600	Proof	9 19	8 8	RW
607	Check Headspace	9 19	8 8	RW
610	Dis-assemble Gun	9 19	8 8	RW
612	Magnaflux Barrel Action		9 22 88	PFL
	Magnaflux Bolt		9 22 88	PFL
615	Rollmark Caliber		10/12	WC
617	Drill and Tap Sight Holes		10/12	FB
618	Polish Barrel		10/7-20	WT
620	Apply Coatings (Barrel Action)		10-24-88	TJA
	Apply Coating (Bolt)		10-31-88	TJA
625	Final Assembly A) Clean inside of Bolt Assembly		11/14/88	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		11/14/88	RW
	C) Inspect Ejector Hole for Chamfer		11/14/88	RW
	D) Oil Firing Pin Ass'y		11/14/88	RW
	E) Adjust Trigger Pull to Min Setting and Stake		12/10/88	LS

op. #	OP. NAME	READINGS					DATE	INITIAL
625 cont.	F) Safety On Force	5	5	5			17 Nov 88	JS
	G) Safety Off Force	3	3	3			17 Nov 88	JS
	H) Trigger Pull Test & Retainability						14 Nov 88	JS
	I) Firing Pin Indent	.020	.020	.020			17 Nov 88	JS
	J) Assemble Stock						11/17/88	RW
	K) Assemble Swivel Studs						1 Dec 88	JS
	L) Attach Front and Rear Sight Assemblies						11/17/88	RW
	M) Iron Sight Alignment						11/17/88	RW
	N) Detach Front & Rear Sights & place in numbered container						11/17/88	RW
	O) Attach Scope to Rifle						11/17/88	WB
	P) Detach & Attach Scope 20 Times						11/17/88	WB
640	Gallery Target & Test	55 R		97 L			11-28-88	AC
	A) Time							
	B) Malfunctions			NONE				
	C) Pierced Primers			NONE				
	D) Optical Clarity of Scope			OK			11-28-88	AC
645	Inspect for Live Ammo			NONE			11-28-88	AC
655	Final Inspection							
	A) Headspace						1 Dec 88	JS
	B) Trigger Pull	2.55	2.47	2.48	2.48	2.48	1 Dec 88	JS
	C) Function						1 Dec 88	JS
660	Pack						15 Dec 88	JS

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C6225491DATE 14 NOV 88TESTER JSS

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.22	2.28	2.17	2.55	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.25	2.33	2.18	2.47	
PULL #3	2.23	2.24	2.20	2.48	
PULL #4	2.26	2.23	2.23	2.48	
PULL #5	2.24	2.32	2.16	2.48	
TOTAL	11.20	11.40	10.94	12.46	
AVG.	2.24	2.28	2.188	2.492	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.36	3.31		
PULL #2	3.31	3.30		
PULL #3	3.28	3.30		
PULL #4	3.33	3.31		
PULL #5	3.29	3.29		
TOTAL	16.57	16.51		
AVG.	3.314	3.302		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.20	4.12		4.01
PULL #2	4.14	4.14		4.06
PULL #3	4.09	4.13		3.99
PULL #4	4.18	4.15		3.93
PULL #5	4.19	4.16		3.97
TOTAL	20.80	20.70		19.96
AVG.	4.16	4.14		3.992

25 Nov 1988

FILE:/PATTERNING/CENTERFIRE_PATT/08235491

CENTERFIRE PATTERNS # 1

POR

1 in circle

3 in circle

5 in circle

CENTROID *

OF SHOTS = 10

IN CIR

1 in = 1

2 in = 4

3 in = 5

HM = 0.001

VM = 0.000

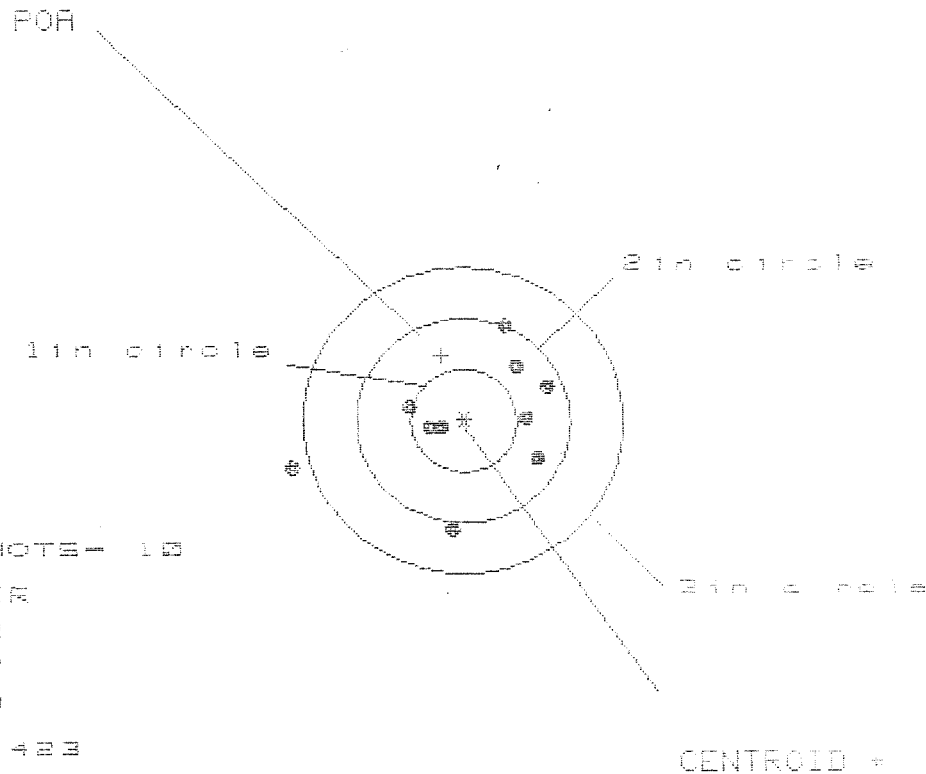
GS = 4.100

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.958	1.751	1.944
MINIMUM X	-1.863	-2.058	-1.865
MAXIMUM Y	1.192	1.296	1.182
MINIMUM Y	-1.011	-0.987	-0.880
CENTROID X	.755	.962	.769
CENTROID Y	-.950	-1.054	-.940
POR TO CENTROID in.	1.214	1.427	1.214
MIN RADIUS	.388	.224	.390
MEAN RADIUS	1.400	1.265	1.237
MAX RADIUS	2.082	2.236	2.012
HORIZONTAL SPREAD	3.821	3.809	3.809
VERTICAL SPREAD	2.203	2.203	2.062
EXTREME SPREAD	4.102	4.027	3.911
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	5		

29 Nov 1988

FILE: \PATTERNING\CENTERFIRE_PATT\06220451

CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1in = 2

2in = 7

3in = 9

ME = 2.422

VS = 2.031

GS = 2.545

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.810	.631	.594
MINIMUM X	:	-1.613	-.697	-.734
MAXIMUM Y	:	.960	.909	.768
MINIMUM Y	:	-1.071	-1.122	-.577
CENTROID X	:	.214	.393	.430
CENTROID Y	:	-.637	-.586	-.445
POA TO CENTROID in.	:	.672	.706	.619
MIN RADIUS	:	.269	.362	.345
MEAN RADIUS	:	.783	.672	.599
MAX RADIUS	:	1.679	1.159	.778
HORIZONTAL SPREAD	:	2.423	1.328	1.328
VERTICAL SPREAD	:	2.031	2.031	1.345
EXTREME SPREAD	:	2.545	2.080	1.389
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

29 Nov 1988

FILE:/PATTERNING/CENTERFIRE_PATT/06225481

CENTERFIRE PATTERNS # 3

POA

1 in circle

2 in circle

3 in circle

CENTROID #

OF SHOTS= 10

IN CIR

1 in = 1

2 in = 4

3 in = 9

HSE= 2.871

VSE= 2.266

GSE= 3.074

PATTERN #

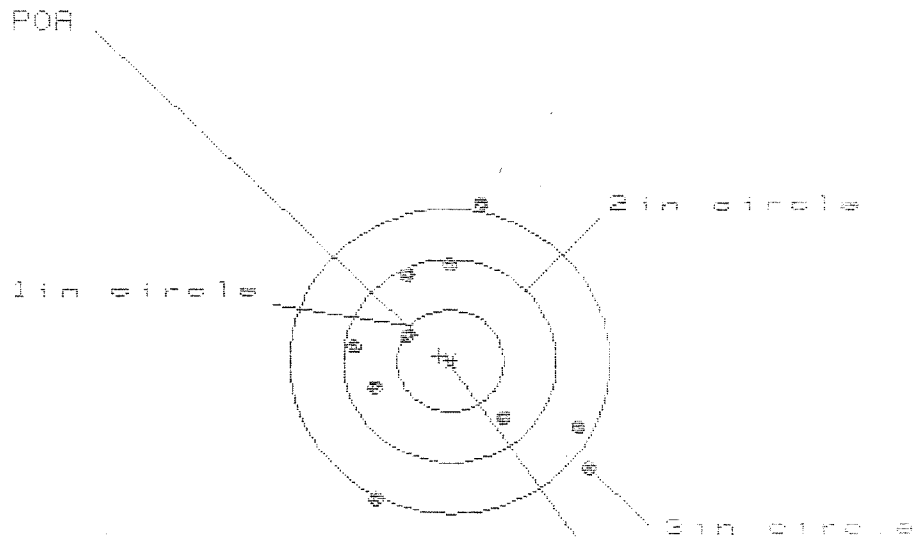
3

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.415	1.253	1.169
MINIMUM X	-1.456	-1.073	-1.157
MAXIMUM Y	.876	.795	.611
MINIMUM Y	-1.390	-1.471	-1.028
CENTROID X	.407	.569	.653
CENTROID Y	-.240	-.167	.017
POA TO CENTROID in.	.477	.593	.653
MIN RADIUS	.302	.451	.425
MEAN RADIUS	1.105	1.033	.918
MAX RADIUS	1.629	1.618	1.547
HORIZONTAL SPREAD	2.871	2.326	2.326
VERTICAL SPREAD	2.266	2.266	1.639
EXTREME SPREAD	3.074	2.775	2.631
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		4	
NUMBER IN THREE INCH CIRCLE =		9	

29 Nov 1988

FILE:/PATTERNING/CENTERFIRE_PATT/08225451

CENTERFIRE PATTERNS # 4



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 6

3 in = 7

HSE = 2.246

VSE = 2.888

ESE = 3.059

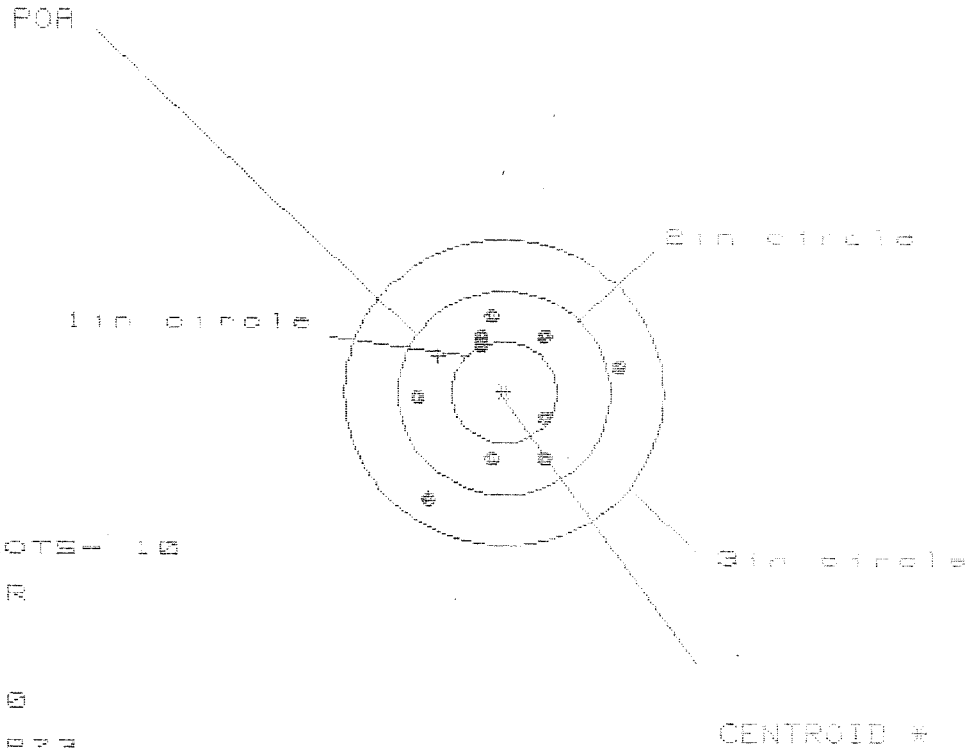
CENTROID #

PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.295	1.312	1.367
MINIMUM X	-.951	-.807	-.752
MAXIMUM Y	1.543	1.425	1.030
MINIMUM Y	-1.345	-1.463	-1.284
CENTROID X	.103	-.041	-.096
CENTROID Y	-.048	.070	-.108
POA TO CENTROID in.	.114	.081	.145
MIN RADIUS	.487	.302	.396
MEAN RADIUS	1.096	.992	.928
MAX RADIUS	1.673	1.569	1.470
HORIZONTAL SPREAD	2.246	2.119	2.119
VERTICAL SPREAD	2.888	2.888	2.314
EXTREME SPREAD	3.059	3.059	2.426
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		7	

29 Nov 1988

FILE:/PATTERNING/CENTERFIRE_PATT/08225491

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 5

3 in = 10

HS= 1.873

VS= 1.805

QS= 2.204

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.032	.948	.452
MINIMUM X	-.841	-.925	-.866
MAXIMUM Y	.750	.633	.649
MINIMUM Y	-1.054	-.766	-.750
CENTROID X	.618	.702	.583
CENTROID Y	-.356	-.239	-.255
POA TO CENTROID in.	.714	.741	.636
MIN RADIUS	.476	.433	.376
MEAN RADIUS	.754	.675	.633
MAX RADIUS	1.295	.956	.873
HORIZONTAL SPREAD	1.873	1.873	1.258
VERTICAL SPREAD	1.805	1.399	1.399
EXTREME SPREAD	2.204	1.869	1.485
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		8	
NUMBER IN THREE INCH CIRCLE =		10	