

G 6590200
Replaced
G 6236245

Repair Inquiry

Repair Number: RE00140413

Serial: G6590200 Model M24 SWS Center Fire
Caliber: 7.62 NATO

Repairman:

Verify Repair

High Priority

Status:

Closed 1/22/2008 3:15:38 PM

Address Information

Customer:

☒ Received From

Return To:

☐ Received From

Name: TRANSPORTATION DIV, DFEL

TRANSPORTATION DIV, DFEL

Address 1: 6759 MITCHELL AVENUE

6759 MITCHELL AVENUE

Address 2: BLDG 1836

PO Box:

BLDG 1836

PO Box:

City: FORT BENNING

FORT BENNING

State: GA

Zip Code: 31905

Country: US

State: GA

Zip Code: 31905

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
A057	Fit and Rear Sgt Base	1
D000	BI POD ALL BROKEN	1

nagletj

1/23/2008

1:05 PM

NUM



Serial Number: **G6590200**
 Model: **M24 SWS**

RE00140413

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6590200.__0
FILE DATE AND TIME: 02/11/2008 14:33

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.105
The Average Y Centroid of the Five Target Set:	0.014
The Average Point of Impact of the Five Target Set:	0.106
The Average Mean Radius of the Five Target Set:	0.794
The Distance from POA to Centroid Target #1:	0.227
The Distance from Centroid Target #2 to Centroid Target #1:	0.234
The Distance from Centroid Target #3 to Centroid Target #1:	0.062
The Distance from Centroid Target #4 to Centroid Target #1:	0.575
The Distance from Centroid Target #5 to Centroid Target #1:	0.438

SERIAL NUMBER: G6590200. __ 0

TARGET NUMBER: 1

FILE DATE: 02/11/2008

FILE TIME: 14:33

POINT#	X	Y
1:	1.404	-0.562
2:	0.746	0.109
3:	0.564	-0.032
4:	0.300	0.182
5:	0.460	-0.658
6:	0.074	-0.374
7:	-0.662	-0.045
8:	-0.960	0.566
9:	-0.630	1.492
10:	-1.045	1.575

X CENTROID: 0.025

Y CENTROID: 0.225

POA TO CENTROID: 0.227

HORZ SPREAD: 2.449

VERT SPREAD: 2.233

GROUP SPREAD: 3.250

MIN RADIUS: 0.278

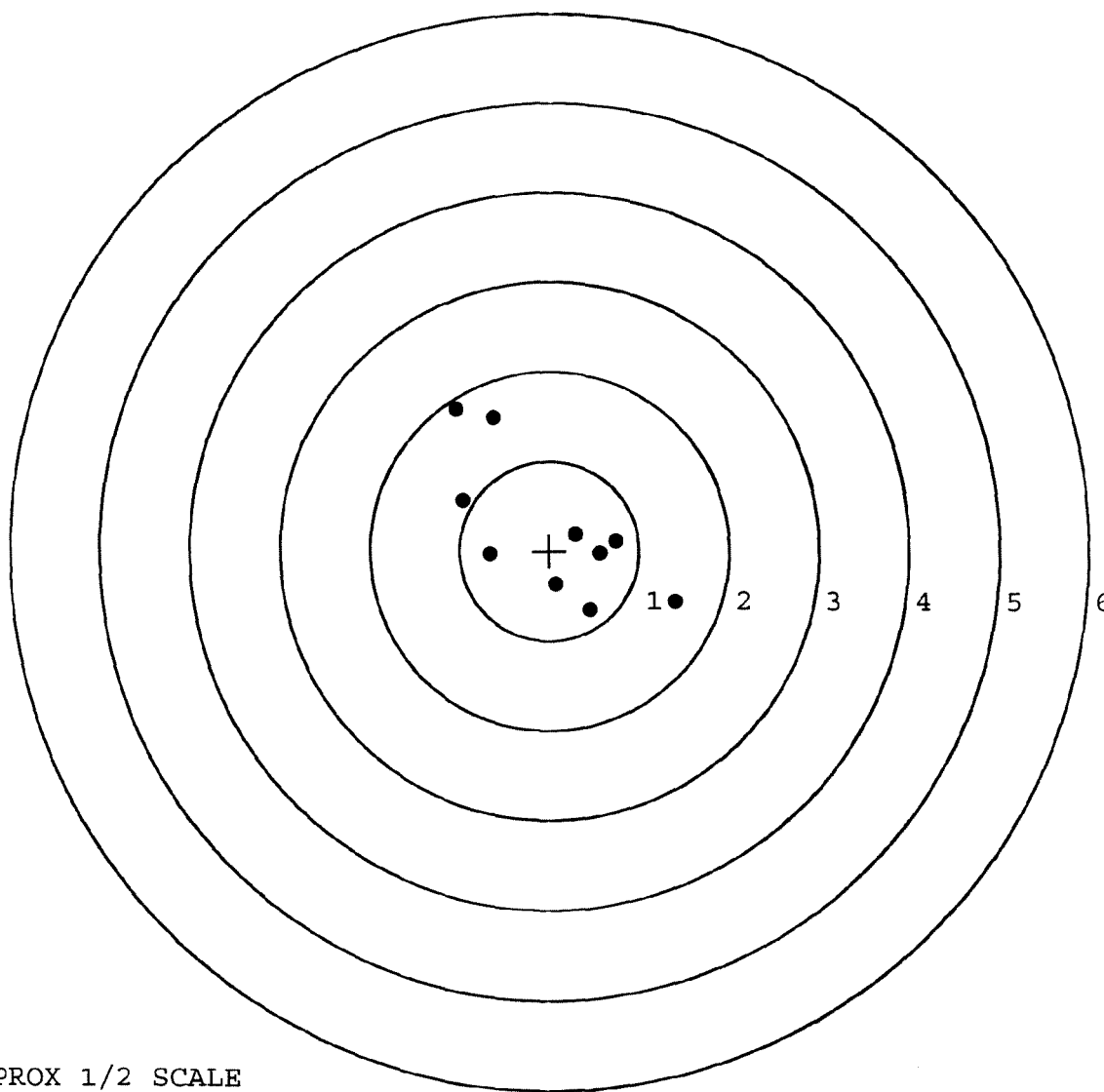
MAX RADIUS: 1.722

MEAN RADIUS: 0.971

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 8

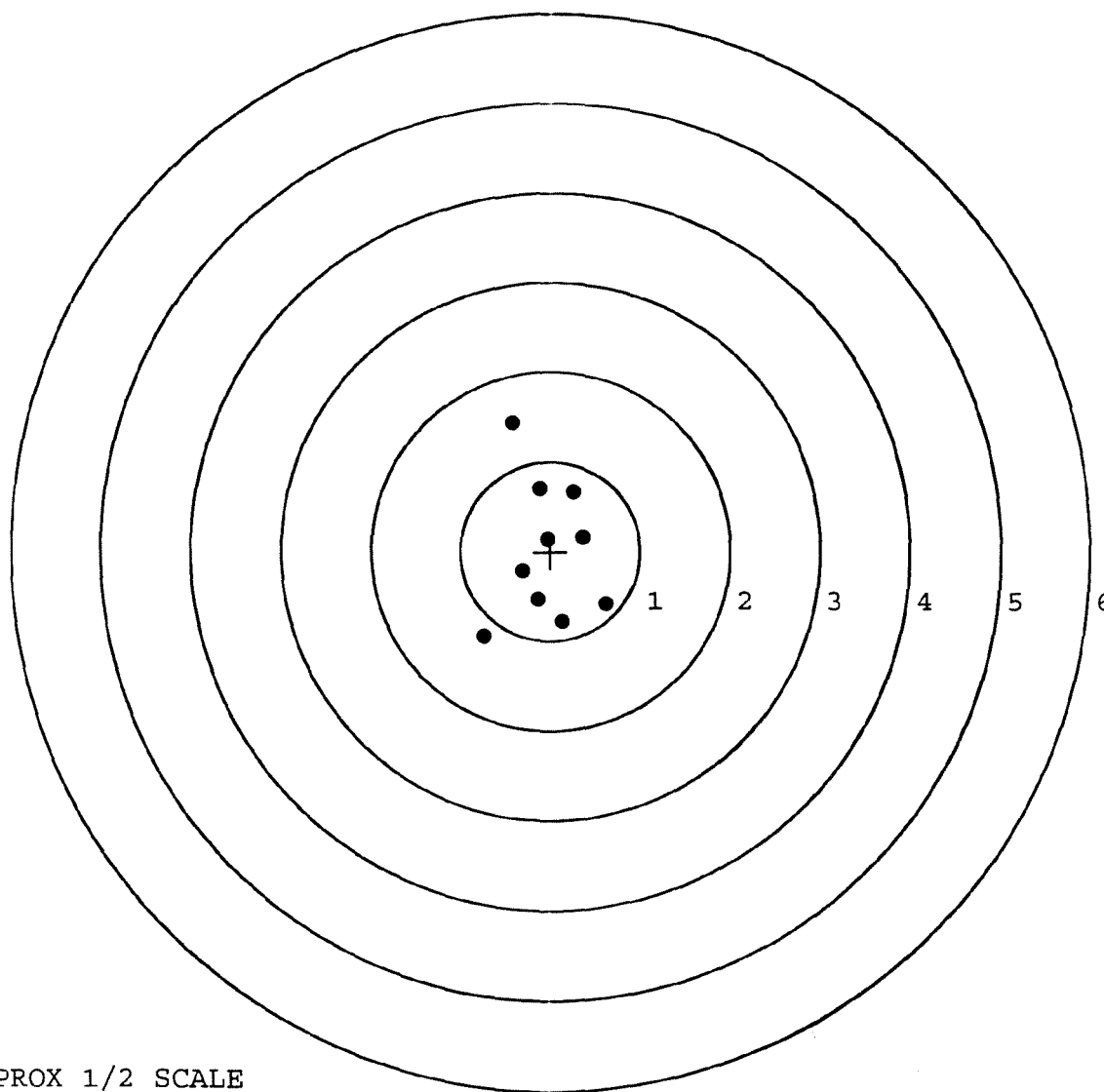


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590200. __0
 TARGET NUMBER: 2
 FILE DATE: 02/11/2008
 FILE TIME: 14:33

POINT#	X	Y
1:	0.623	-0.593
2:	0.134	-0.787
3:	-0.134	-0.537
4:	-0.311	-0.223
5:	-0.738	-0.955
6:	0.366	0.158
7:	-0.027	0.135
8:	0.255	0.666
9:	-0.121	0.705
10:	-0.426	1.429

X CENTROID: -0.038
 Y CENTROID: 0.000
 POA TO CENTROID: 0.038
 HORZ SPREAD: 1.361
 VERT SPREAD: 2.384
 GROUP SPREAD: 2.404
 MIN RADIUS: 0.136
 MAX RADIUS: 1.481
 MEAN RADIUS: 0.726
 # IN 1 IN DIAMETER: 3
 # IN 2 IN DIAMETER: 8
 # in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590200. 0

TARGET NUMBER: 3

FILE DATE: 02/11/2008

FILE TIME: 14:33

POINT#	X	Y
1:	0.945	0.504
2:	0.629	0.433
3:	0.450	0.401
4:	-0.104	0.578
5:	-0.242	0.680
6:	0.242	1.058
7:	-1.036	0.082
8:	-0.316	-0.067
9:	-0.718	-0.498
10:	0.047	-0.412

X CENTROID: -0.010

Y CENTROID: 0.276

POA TO CENTROID: 0.276

HORZ SPREAD: 1.981

VERT SPREAD: 1.556

GROUP SPREAD: 1.942

MIN RADIUS: 0.316

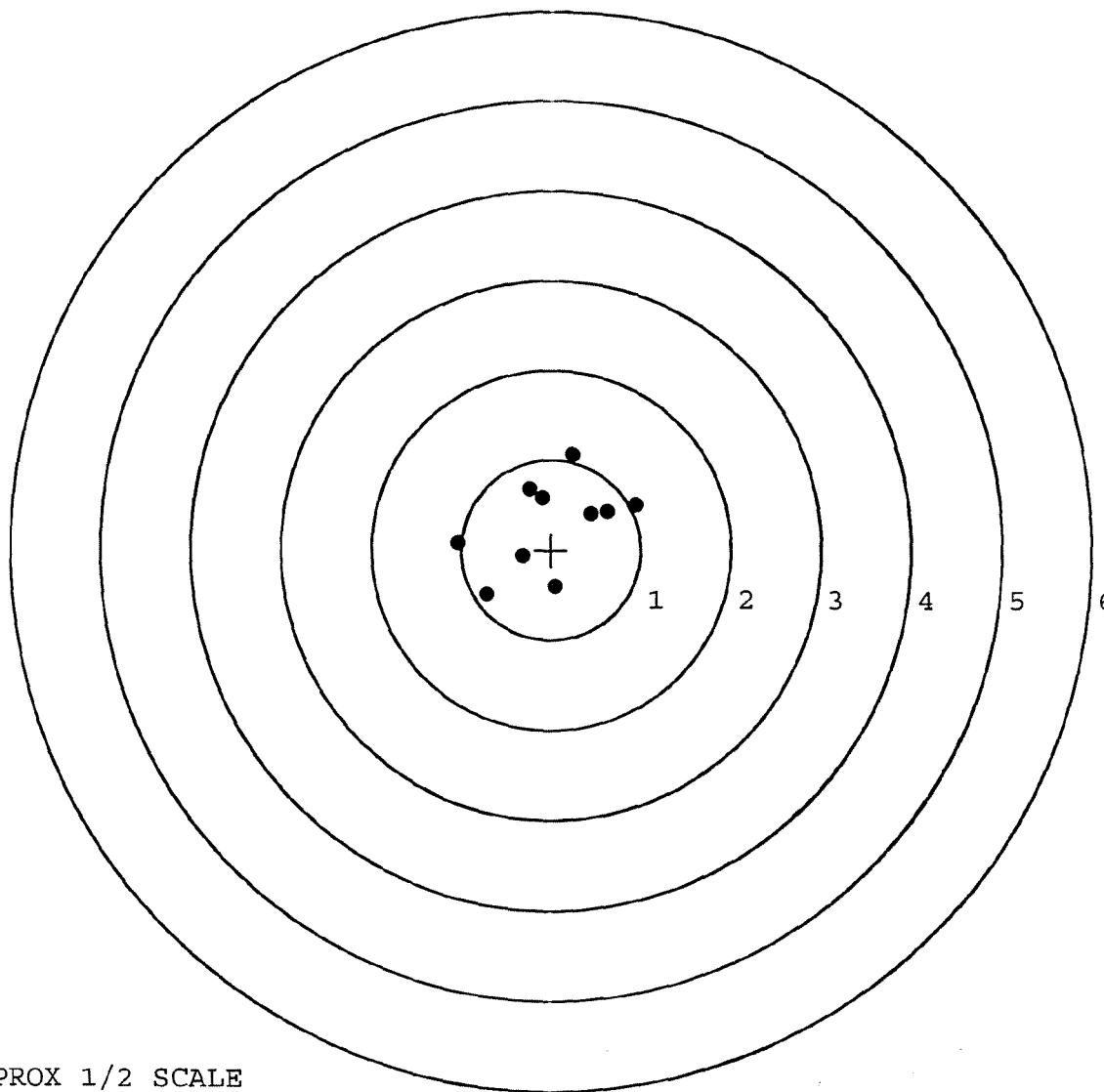
MAX RADIUS: 1.049

MEAN RADIUS: 0.696

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590200. __0

TARGET NUMBER: 4

FILE DATE: 02/11/2008

FILE TIME: 14:33

POINT#	X	Y
1:	1.553	-1.175
2:	0.457	-1.186
3:	-0.230	-1.481
4:	0.155	-0.374
5:	-0.098	-0.322
6:	1.187	-0.095
7:	0.942	0.203
8:	0.182	0.463
9:	-0.286	0.510
10:	-0.875	0.652

X CENTROID: 0.299

Y CENTROID: -0.281

POA TO CENTROID: 0.410

HORZ SPREAD: 2.428

VERT SPREAD: 2.133

GROUP SPREAD: 3.039

MIN RADIUS: 0.171

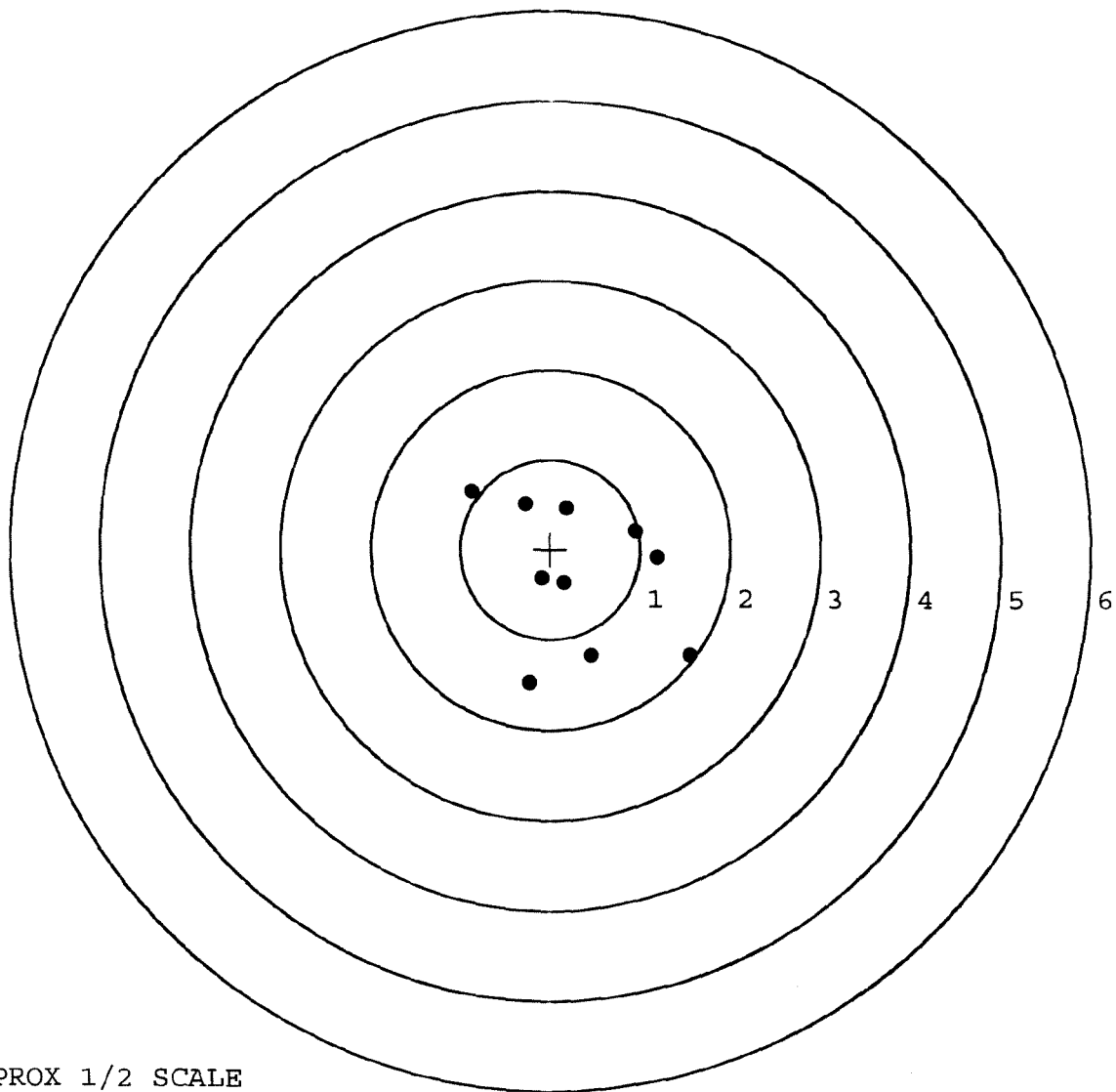
MAX RADIUS: 1.541

MEAN RADIUS: 0.929

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590200. 0

TARGET NUMBER: 5

FILE DATE: 02/11/2008

FILE TIME: 14:33

POINT#	X	Y
1:	0.632	-1.767
2:	-0.445	-0.620
3:	0.111	-0.645
4:	0.258	-0.216
5:	0.052	-0.221
6:	-0.192	0.755
7:	0.633	0.433
8:	0.727	0.240
9:	0.438	0.134
10:	0.272	0.392

X CENTROID: 0.249

Y CENTROID: -0.151

POA TO CENTROID: 0.291

HORZ SPREAD: 1.172

VERT SPREAD: 2.522

GROUP SPREAD: 2.653

MIN RADIUS: 0.065

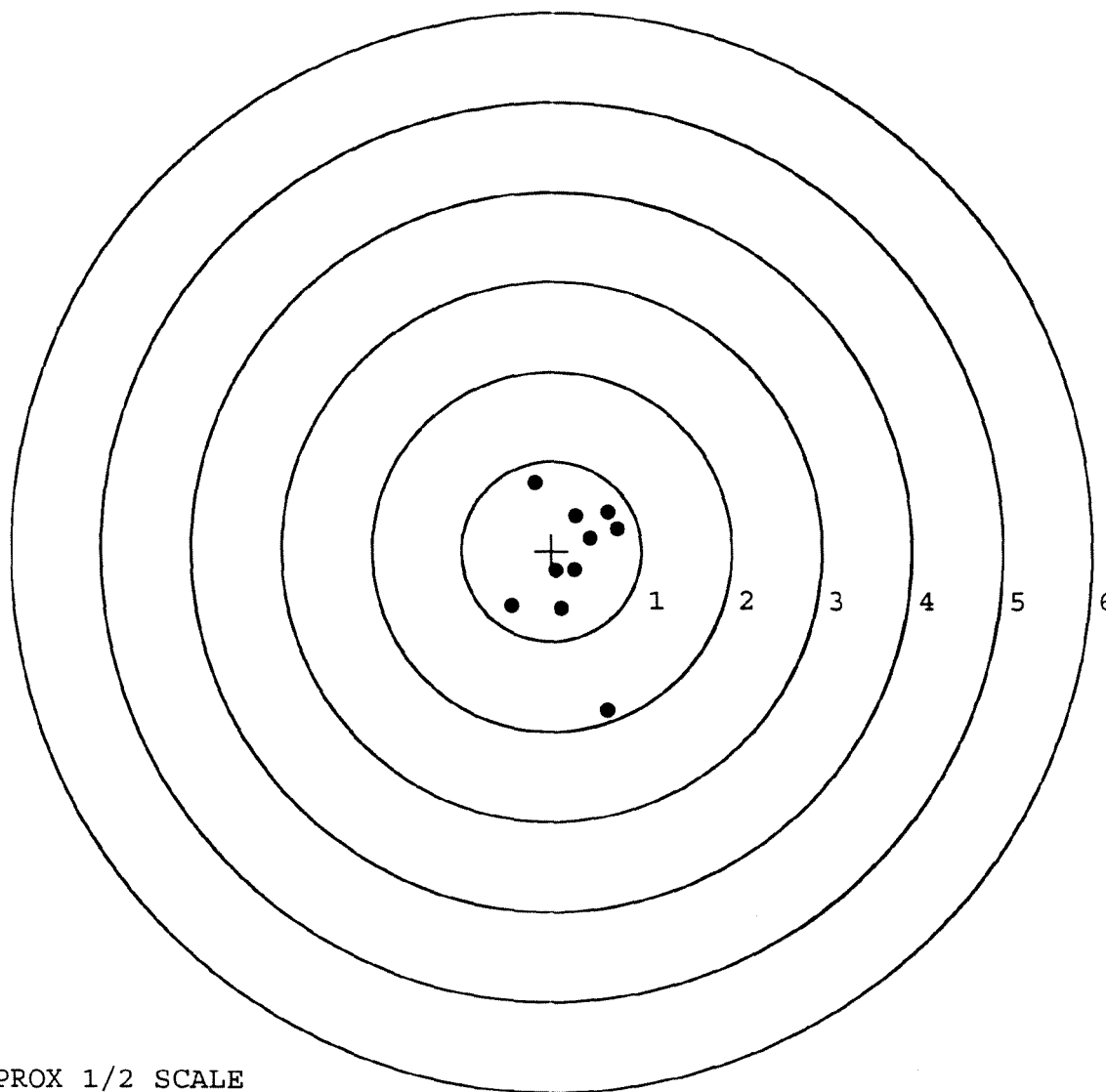
MAX RADIUS: 1.660

MEAN RADIUS: 0.650

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

R & E NUMBER 00140413SERIAL NUMBER 66590200LOG-IN DATE 1-22-08

OPERATION #	OPERATION NAME	DATE	INITIAL
500	DIS-ASSEMBLE GUN	1-24-08	S.P.D.
505	RE-BARREL	1-25-08	S.P.D.
560	ASSEMBLE	1-30-08	TRW
600	PROOF	1-30-08	TRW
605	CHECK HEADSPACE	1-30-08	TRW
610	DIS-ASSEMBLE GUN	1-30-08	S.P.D.
612	MAGNAFLUX	2-1-08	JB
510	DRILL AND TAP	1-30-08	TRW
615	ROLLMARK CALIBER	1-30-08	CW
618	ROTO-BLAST	2-4-08	HY
620	APPLY COATINGS	2-6-08	CM
625	FINAL ASSEMBLY	2-7-08	RTZ
640	FUNCTION TEST AND	2-8-08	TRW
650	TARGET	2-8-08	TRW
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
670	FINAL INSPECTION	2-12-08	DA
	A) HEADSPACE	PASS FAIL	2-12-08 DA
	B) TRIGGER PULL	2.83 2.86 2.79 2.94 2.87 2-12-08	DA
680	F) SAFETY ON FORCE	4.5 4.5 4.5 2-12-08	DA
	G) SAFETY OFF FORCE	3.5 2.5 2.5 2-12-08	DA
	I) FIRING PIN INDENT	.021 .021 .020 2-12-08	DA
690	PACK	2-19-08	FM

Repair Inquiry

Repair Number: RE00118095

Serial: G6236245 Model M24 SWS Center Fire
Caliber: 7.62 NATO

Repairman:

Verify Repair

Status:

Closed 9/28/2006 8:41:42 AM

Address Information

Customer:

☒ Received From

Return To:

☐ Received From

Name: TRANSPORTATION DIVISION, DFEL

TRANSPORTATION DIVISION, DFEL

Address 1: 6759 MITCHELL AVENUE

6759 MITCHELL AVENUE

Address 2: BLDG 1836

PO Box:

BLDG 1836

PO Box:

City: FORT BENNING

FORT BENNING

State: GA

Zip Code: 31905

Country: US

State: GA

Zip Code: 31905

Country: US

FFL:

Contact / Condition

Problems

Estimate

History / Status

Shipping / Billing

Contact Information

Phone: NA

Fax:

Email:

Comments:

Received Condition

Poor

Condition
Notes:CSR
Notes:

Accessories Received

Code	Desc	Qty
A007	With Stud	3
A010	Hard Case	1
A017	Scope Base	1
A026	Scope	1
A045	Bi Pod	1
A057	Front and Rear Sgt Base	1

Repair Search

Refresh

Close

nagletj

9/28/2006

8:48 AM

CAPS

NUM

INS

SCPL

start

3 M.

3 M.

5 I.

Par...

Sto...

Mo...

Ar...

8:48 AM

Serial Number:

~~G6236245~~

Model: M24 SWS



RE00118095

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6590200.___0
FILE DATE AND TIME: 10/11/2006 01:14

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.064
The Average Y Centroid of the Five Target Set:	-0.017
The Average Point of Impact of the Five Target Set:	0.066
The Average Mean Radius of the Five Target Set:	0.683
The Distance from POA to Centroid Target #1:	0.237
The Distance from Centroid Target #2 to Centroid Target #1:	0.273
The Distance from Centroid Target #3 to Centroid Target #1:	0.242
The Distance from Centroid Target #4 to Centroid Target #1:	0.414
The Distance from Centroid Target #5 to Centroid Target #1:	0.270

SERIAL NUMBER: G6590200. __ 0

TARGET NUMBER: 1

FILE DATE: 10/11/2006

FILE TIME: 01:14

POINT#	X	Y
1:	0.863	-1.237
2:	0.802	-0.716
3:	0.299	-0.488
4:	-0.811	1.225
5:	-0.317	0.188
6:	-0.746	0.173
7:	-0.650	-0.121
8:	-0.406	-0.272
9:	-0.315	-0.454
10:	-0.278	-0.085

X CENTROID: -0.156

Y CENTROID: -0.179

POA TO CENTROID: 0.237

HORZ SPREAD: 1.674

VERT SPREAD: 2.462

GROUP SPREAD: 2.977

MIN RADIUS: 0.154

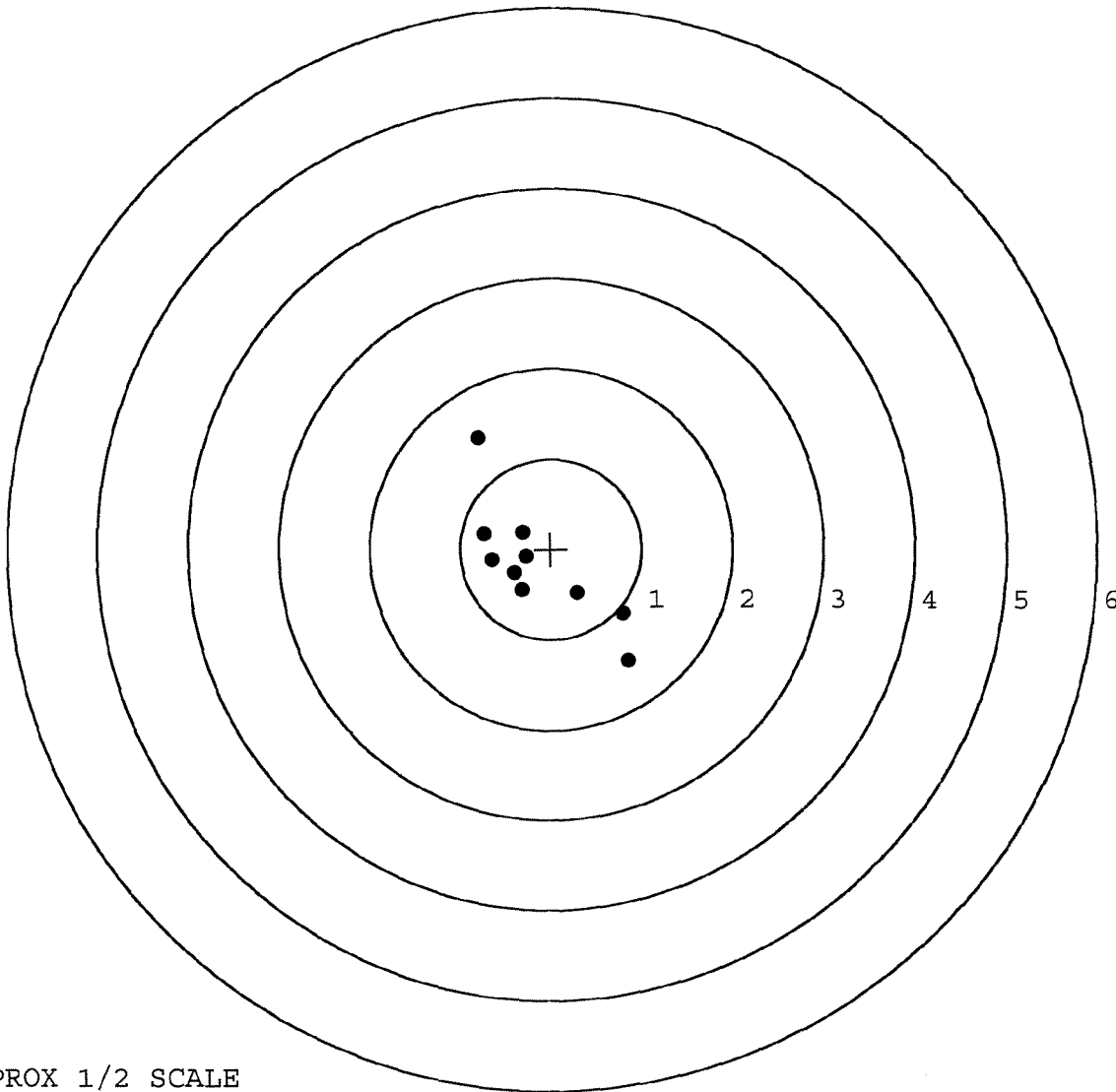
MAX RADIUS: 1.549

MEAN RADIUS: 0.699

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

BARBER - M24 0166600

SERIAL NUMBER: G6590200. __ 0

TARGET NUMBER: 2

FILE DATE: 10/11/2006

FILE TIME: 01:14

POINT#	X	Y
1:	-1.099	-0.625
2:	0.781	-0.642
3:	0.427	-0.243
4:	0.198	-0.303
5:	0.346	0.433
6:	-0.174	0.109
7:	-0.202	0.257
8:	-0.139	0.451
9:	-0.458	0.729
10:	-0.797	0.736

X CENTROID: -0.112

Y CENTROID: 0.090

POA TO CENTROID: 0.144

HORZ SPREAD: 1.880

VERT SPREAD: 1.378

GROUP SPREAD: 1.880

MIN RADIUS: 0.065

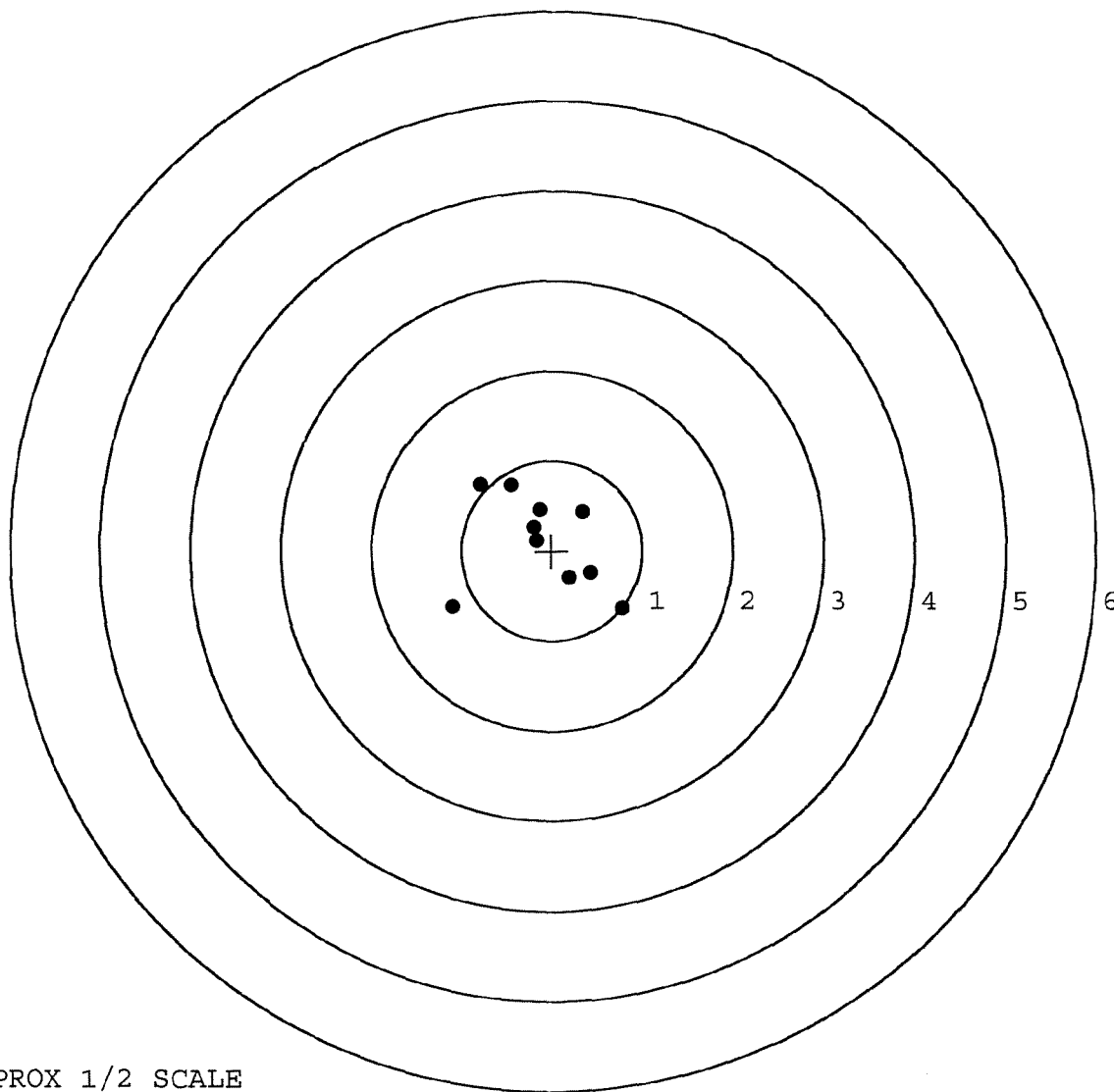
MAX RADIUS: 1.219

MEAN RADIUS: 0.636

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590200. __ 0

TARGET NUMBER: 3

FILE DATE: 10/11/2006

FILE TIME: 01:14

POINT#	X	Y
1:	0.249	-1.569
2:	0.693	0.507
3:	0.144	-0.412
4:	-0.152	-0.487
5:	-0.314	-0.061
6:	-0.646	0.255
7:	-0.046	0.385
8:	-0.488	0.443
9:	-0.535	0.815
10:	-0.993	0.695

X CENTROID: -0.209

Y CENTROID: 0.057

POA TO CENTROID: 0.216

HORZ SPREAD: 1.686

VERT SPREAD: 2.384

GROUP SPREAD: 2.582

MIN RADIUS: 0.158

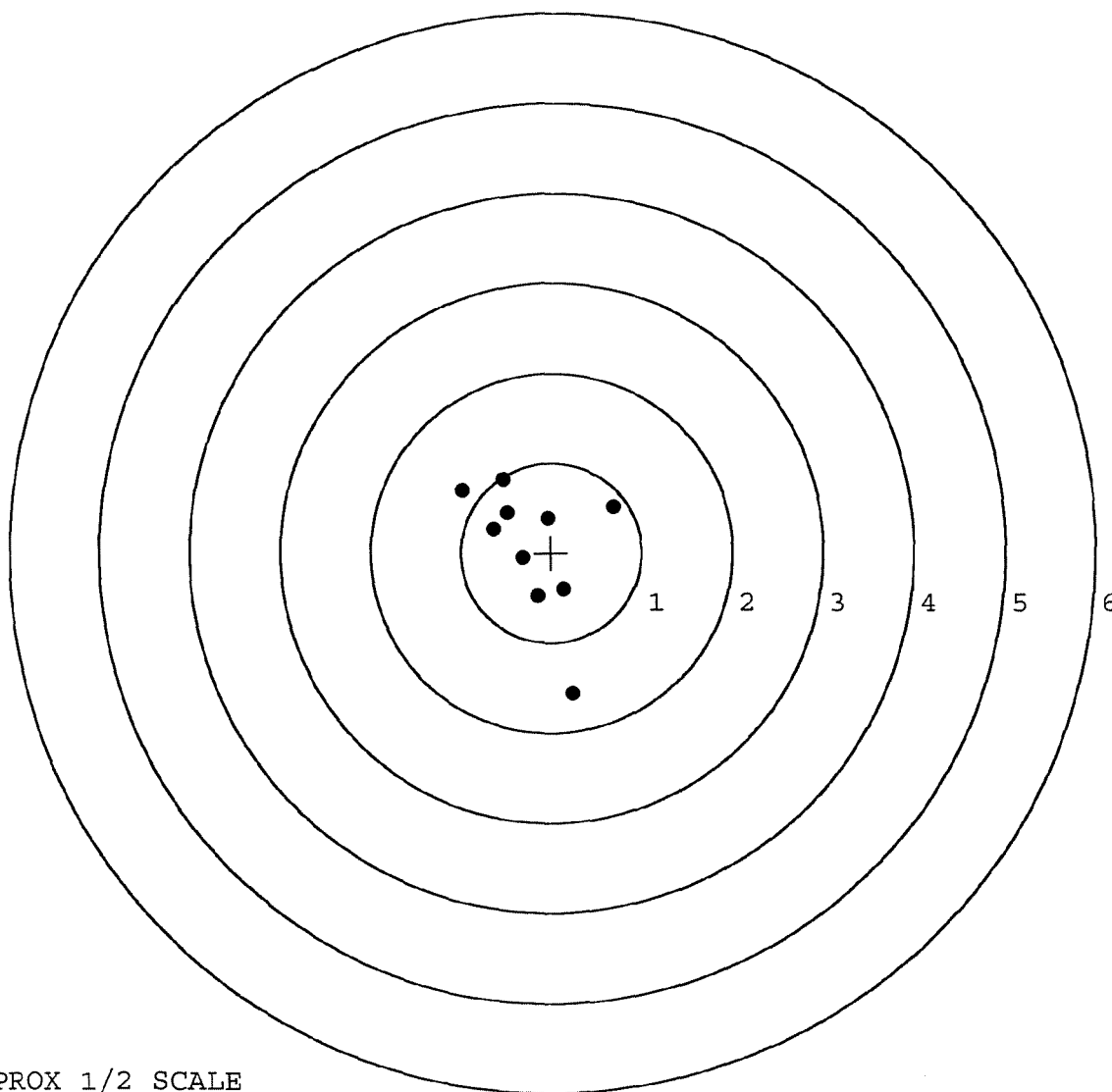
MAX RADIUS: 1.689

MEAN RADIUS: 0.715

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 9

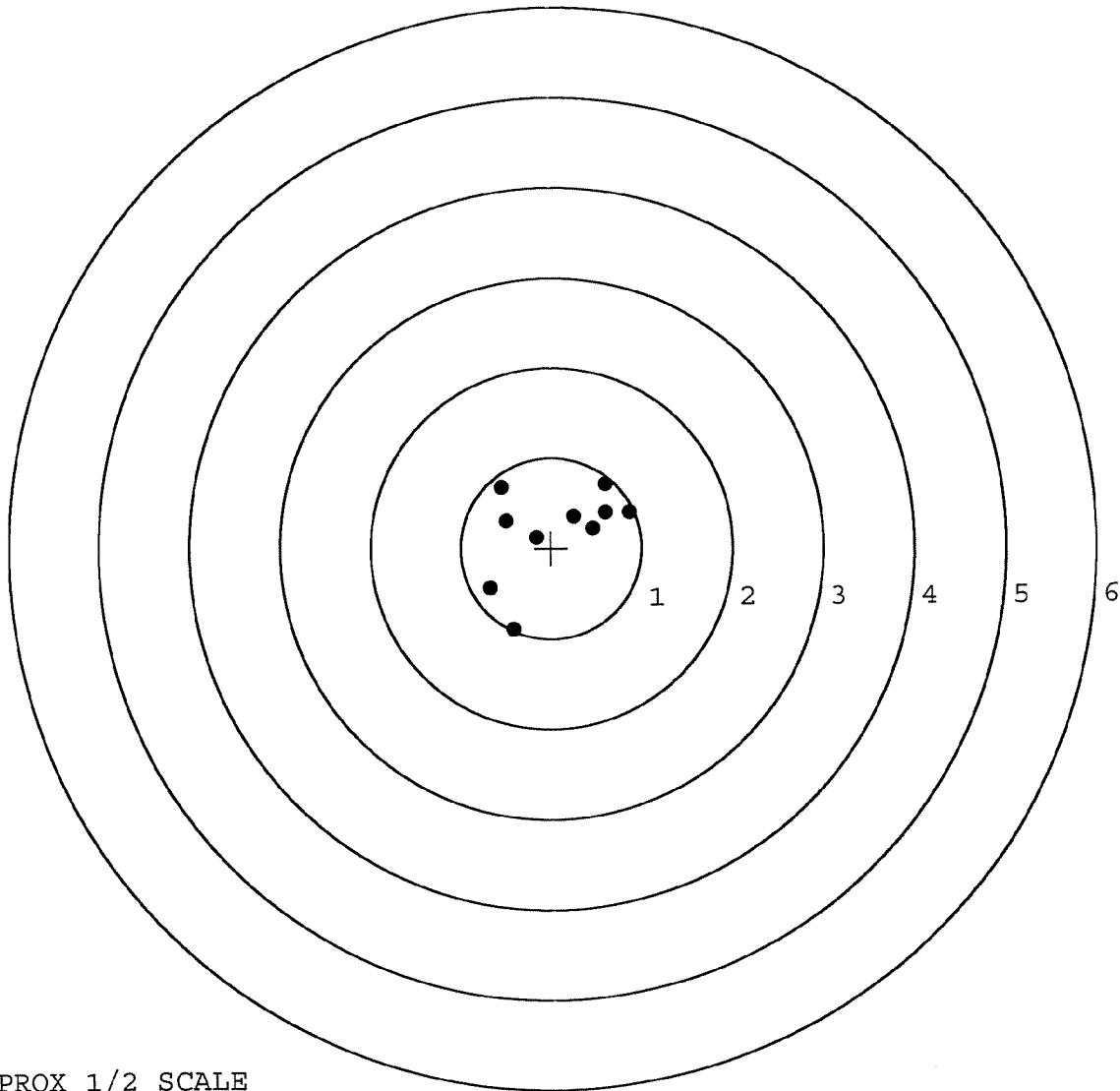


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590200. __0
 TARGET NUMBER: 4
 FILE DATE: 10/11/2006
 FILE TIME: 01:14

POINT#	X	Y
1:	-0.425	-0.895
2:	-0.676	-0.439
3:	-0.553	0.675
4:	-0.494	0.304
5:	-0.161	0.115
6:	0.601	0.703
7:	0.873	0.391
8:	0.259	0.349
9:	0.462	0.219
10:	0.602	0.387

X CENTROID: 0.049
 Y CENTROID: 0.181
 POA TO CENTROID: 0.187
 HORZ SPREAD: 1.549
 VERT SPREAD: 1.598
 GROUP SPREAD: 1.899
 MIN RADIUS: 0.220
 MAX RADIUS: 1.176
 MEAN RADIUS: 0.657
 # IN 1 IN DIAMETER: 3
 # IN 2 IN DIAMETER: 9
 # in 3 IN DIAMETER: 10

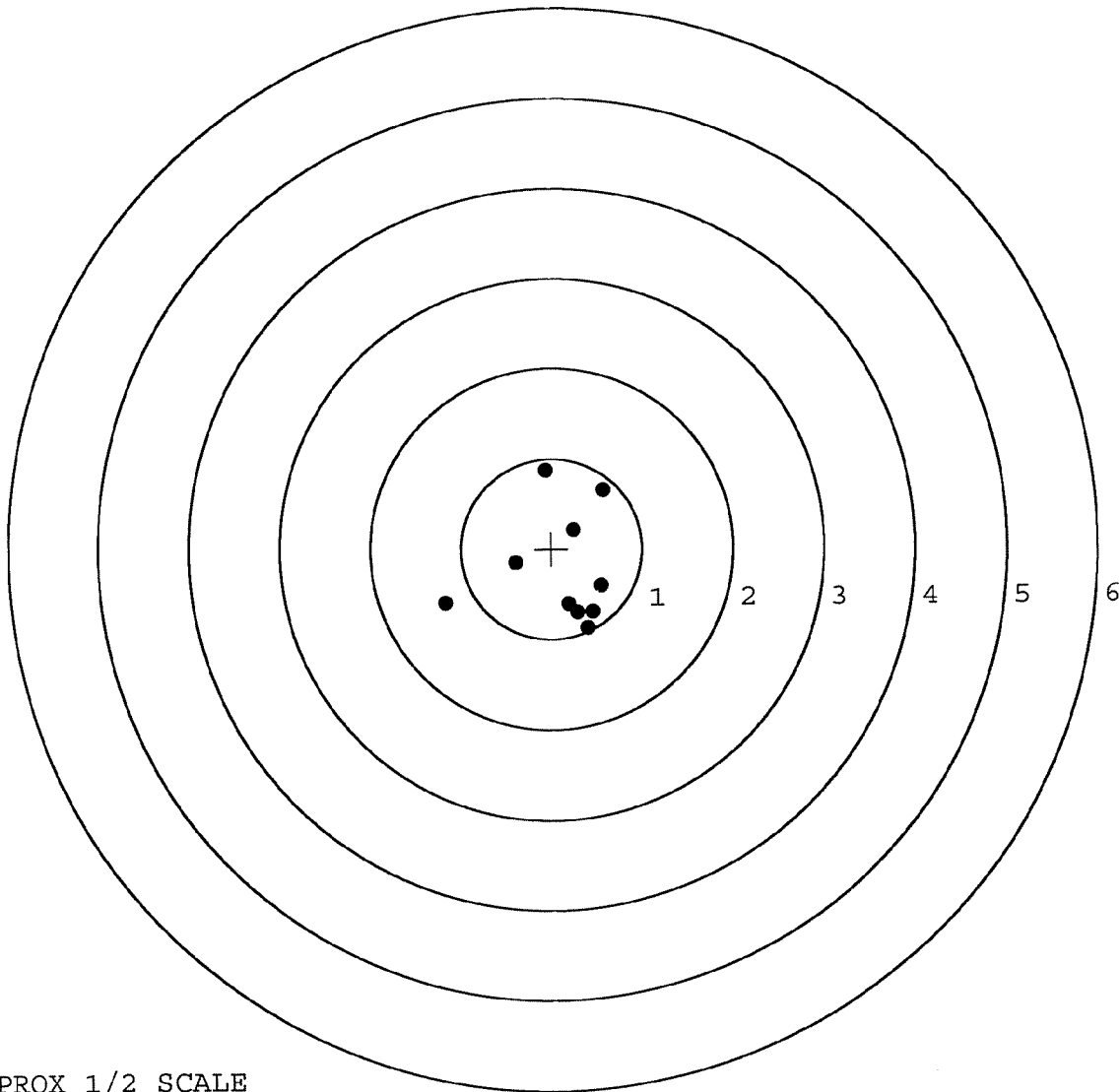


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590200. __ 0
 TARGET NUMBER: 5
 FILE DATE: 10/11/2006
 FILE TIME: 01:14

POINT#	X	Y
1:	0.578	0.649
2:	-0.060	0.867
3:	0.250	0.209
4:	-0.398	-0.156
5:	-1.177	-0.598
6:	0.193	-0.617
7:	0.549	-0.419
8:	0.456	-0.703
9:	0.403	-0.884
10:	0.288	-0.713

X CENTROID: 0.108
 Y CENTROID: -0.236
 POA TO CENTROID: 0.260
 HORZ SPREAD: 1.755
 VERT SPREAD: 1.751
 GROUP SPREAD: 2.153
 MIN RADIUS: 0.390
 MAX RADIUS: 1.335
 MEAN RADIUS: 0.710
 # IN 1 IN DIAMETER: 3
 # IN 2 IN DIAMETER: 7
 # in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

BARBER - M24 0166604AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50 LBS (plus or minus 0.50 LBS)

3.00 LBS (plus or minus 0.75 LBS)

4.00 LBS (plus or minus 1.00 LBS)

DATE 9-30-06TESTER RP

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	259	247		253	
PULL #2	250	255		250	
PULL #3	247	240		247	
PULL #4	256	250		244	
PULL #5	257	254		250	
TOTAL	1269	1246		1244	
AVERAGE	253	249		248	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	302	321		
PULL #2	298	324		
PULL #3	296	316		
PULL #4	304	325		
PULL #5	306	326		
TOTAL	1506	1612		
AVERAGE	301	322		

	4.00 LBS INITIAL	4.00 LBS AFTER 20 CYCLES	MAX SETTING GREATER THAN 4 LBS	RESET TO 4 LBS FOR TARGET & ACCURACY
PULL #1	415	421		403
PULL #2	416	405		402
PULL #3	409	405		402
PULL #4	414	407		399
PULL #5	410	411		412
TOTAL	2064	2049		2018
AVERAGE	412	409		403

DATE: 20060911

MAINTENANCE REQUEST

DA FORM 5990-E

----- CUSTOMER DATA -----

UIC: W2L58L
UTIL CODE: 0

HHC 2/29 INF. REGT.

PHONE: (706) 544-1450

----- ACTIVITY DATA -----

SUP WON:
SUP UIC: W6CR07

ITT

PHONE: 544-8635
SHOP SEC:

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

TYPE MNT REQ: 1 ID: A NSN: 1005012402136 MODEL: M24RIFLE

NOUN: RIFLE 7.62MM SNIP SER NUM: G6236245 / 881195 QTY: 00001

ORG WON: 2L58L1601268 PRIORITY: 03 FAILURE DETECTED: F

MI/KM: 000000

HOURS: -----

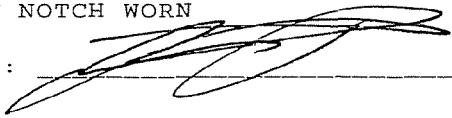
ROUNDS:

IN WARRANTY: N

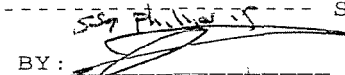
LEVEL OF WORK: F

ADMIN NUM: S-29

DEFICIENCY: FIRING PIN NOTCH WORN

PD AUTHENTICATING SIGNATURE: 

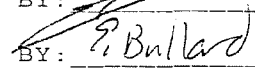
----- SIGNATURE DATA -----

SUBMITTED BY: 

ORD

DATE: 06256

MIL TIME: 1110

ACCEPTED BY: 

STATUS: A

ORD DATE: 06256

MIL TIME: 1110

----- 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: _____

575-8183
SSg PhillipsWC W6GIA64
APO m9wm
DC
TC WAR
K4AB

INSPECTION CHECKLIST - REPAIRS

CONTRACT #: DAAE-20-02-C-0149

R & E NUMBER	118097		
SERIAL NUMBER	66236245 66590200 (New)		
LOG-IN DATE	9-28-06		
OPERATION #	OPERATION NAME	DATE	INITIAL
500	DIS-ASSEMBLE GUN	9-30-06	RTL
505	RE-BARREL	10-4-06	RTL
420	ASSEMBLE	10-4-06	RTL
440	PROOF	MAGNA-FLUX INSPECTED 10-4-06	TRW
460	CHECK HEADSPACE	10-4-06	TRW
470	DIS-ASSEMBLE GUN	10-4-06	RTL
480	MAGNAFLUX	OPERATOR (PPD)	PPD
510	DRILL AND TAP	10-5-06	SD
500	ROLLMARK CALIBER	10-6-06	RP
520	GOFF BLAST BBL / REC	10-6-06	LB
530 & 540	APPLY COATINGS	10-9-06	ES
560	FINAL ASSEMBLY	10-10-06	RTL
640	FUNCTION TEST AND	PASS FAIL	10-10-06 P.P.D.
650	TARGET	PASS FAIL	10-10-06 P.P.D.
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
670	FINAL INSPECTION		10-18-06 RTL
	A) HEADSPACE	PASS FAIL	10-18-06 RTL
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	2.26 2.30 2.20 2.28 2.28 10-20-06 DA
680	F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX	6.0 6.0 6.0 10-12-06 DA
	G) SAFETY OFF FORCE	2 LBS MIN	2.5 2.5 2.5 10-12-06 DA
	I) FIRING PIN INDENT	.020	10-21 10-20 10-21 10-12-06 DA
690	PACK		10-19-06 DA

F006 REV 5/2006

BARBER - M24 0166607 FINAL INSPECTION CHECKLIST

BARREL ASSEMBLY

BARREL

RECEIVER

FRONT SIGHT BASE

REAR SIGHT BASE

SCREWS

FINISH

SCOPE ASSEMBLY

SCOPE

SCOPE RINGS

MOUNTING SCREWS

MOUNTING BASE

SCREWS

FINISH

CLARITY

STOCK ASSEMBLY

STOCK

SLING SWIVEL STUDS

BUTT PATE

LOCK NUTS

BARREL CLEARANCE

COLOR / FINISH

SYSTEM CASE

SCOPE CASE

IRON SIGHTS

DEPLOYMENT KIT

TRIGGER ASSEMBLY

SAFETY OPERATION

RE-SET TO FACTORY
SPECS

COMMENTS: _____

F006 REV 5/2006

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: **RE00089338** Serial: G6236245 Model: M24 SWS Center Fire Caliber: 7.62 NATO Produced: 08/11/2003 Repairman: Status: Closed 12/10/2004 9:33:38 AM

Verify Repair

Address Information

Customer: ☒ Received From Return To: ☐ Received From

Name: **TRANSPORTATION DIV DFEL** **TRANSPORTATION DIV DFEL**

Address 1: **BLDG 1836** **BLDG 1836**

Address 2: **6759 MITCHELL AVE** **6759 MITCHELL AVE** PO Box: PO Box:

City: **FORT BENNING** **FORT BENNING**

State: **GA** Zip Code: **31905** Country: **US** State: **GA** Zip Code: **31905** Country: **US**

FFL: ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐

Contact / Condition Problems Estimate History / Status Shipping / Billing

Contact Information

Phone:

Fax:

Email:

Comments:

Received Condition

Condition: **Good**

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	Frt and Rear Sgt Base	1

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

maglet 12/11/2004 8:59 AM CAPS NUM INS SCPL

start 3 5

Serial Number: **G6236245**

Model: **M24 SWS**



RE00089338

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6236245.__1
FILE DATE AND TIME: 01/05/2005 11:09

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.049
The Average Y Centroid of the Five Target Set:	-0.080
The Average Point of Impact of the Five Target Set:	0.094
The Average Mean Radius of the Five Target Set:	0.751
The Distance from POA to Centroid Target #1:	0.258
The Distance from Centroid Target #2 to Centroid Target #1:	0.445
The Distance from Centroid Target #3 to Centroid Target #1:	0.066
The Distance from Centroid Target #4 to Centroid Target #1:	0.180
The Distance from Centroid Target #5 to Centroid Target #1:	0.304

SERIAL NUMBER: G6236245. __1

TARGET NUMBER: 1

FILE DATE: 01/05/2005

FILE TIME: 11:09

POINT#	X	Y
1:	0.839	-0.923
2:	0.731	-0.685
3:	0.553	-0.883
4:	0.624	-0.465
5:	-0.605	0.148
6:	-1.254	0.140
7:	-0.116	0.031
8:	0.046	0.215
9:	0.188	0.491
10:	-0.897	-0.651

X CENTROID: 0.011

Y CENTROID: -0.258

POA TO CENTROID: 0.258

HORZ SPREAD: 2.093

VERT SPREAD: 1.414

GROUP SPREAD: 2.347

MIN RADIUS: 0.316

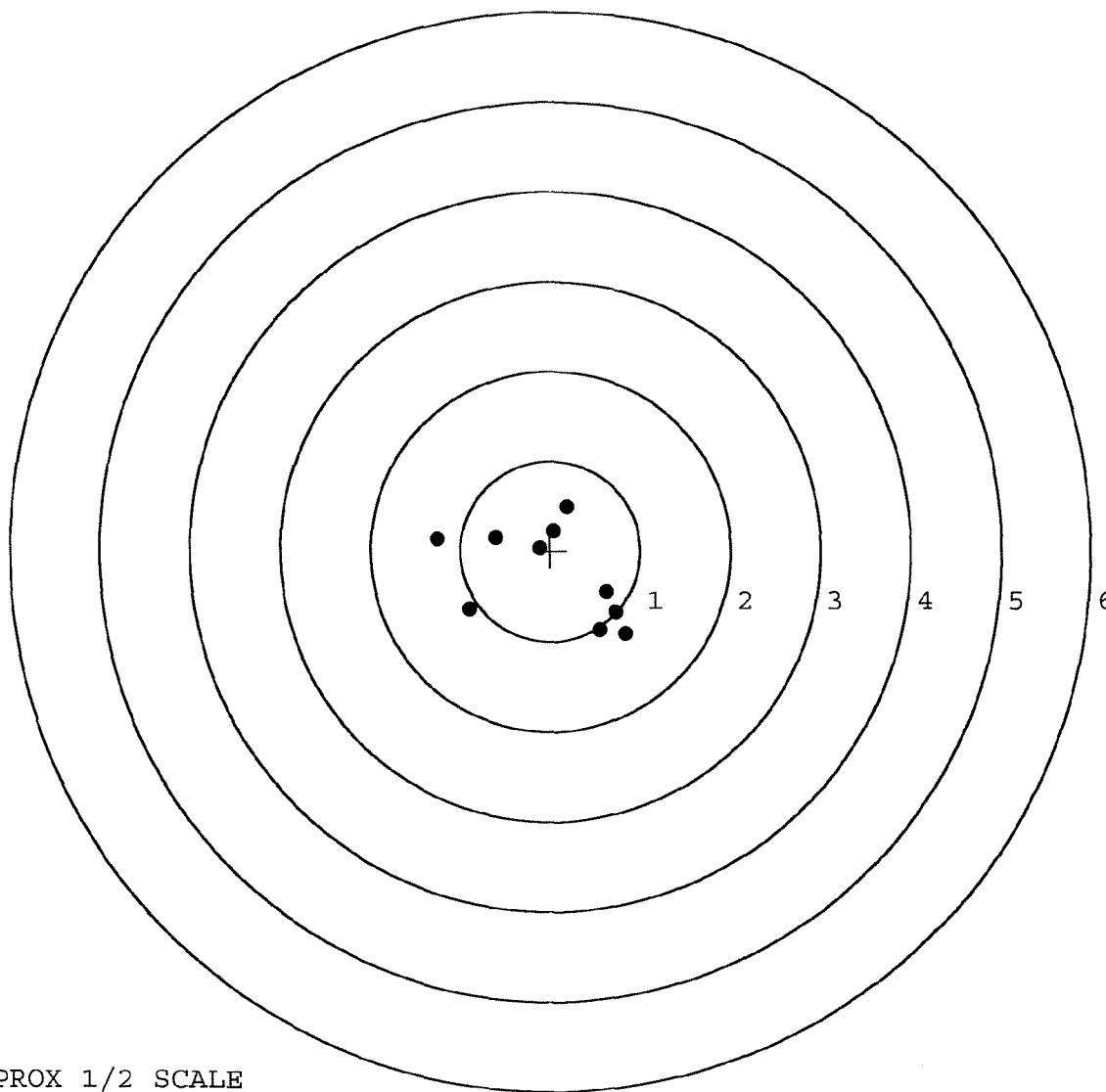
MAX RADIUS: 1.326

MEAN RADIUS: 0.799

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6236245. __1

TARGET NUMBER: 2

FILE DATE: 01/05/2005

FILE TIME: 11:09

X CENTROID: -0.156

Y CENTROID: 0.154

POA TO CENTROID: 0.219

HORZ SPREAD: 2.292

VERT SPREAD: 2.542

GROUP SPREAD: 2.633

MIN RADIUS: 0.063

MAX RADIUS: 1.572

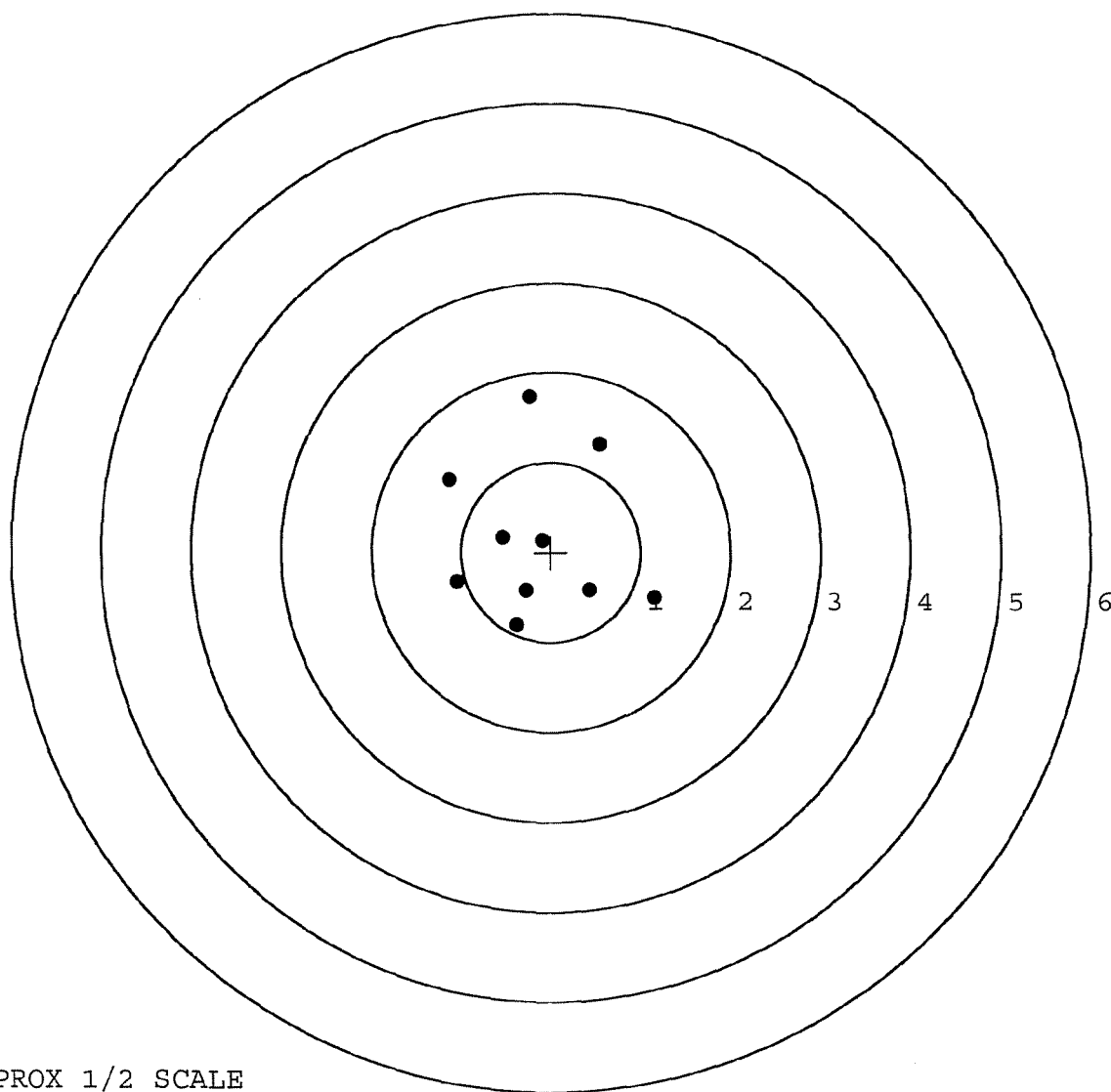
MEAN RADIUS: 0.935

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 5

in 3 IN DIAMETER: 9

POINT#	X	Y
1:	1.156	-0.509
2:	0.437	-0.421
3:	-0.374	-0.818
4:	-0.279	-0.430
5:	-0.095	0.138
6:	-0.534	0.169
7:	-1.045	-0.327
8:	-1.136	0.813
9:	0.547	1.199
10:	-0.239	1.724

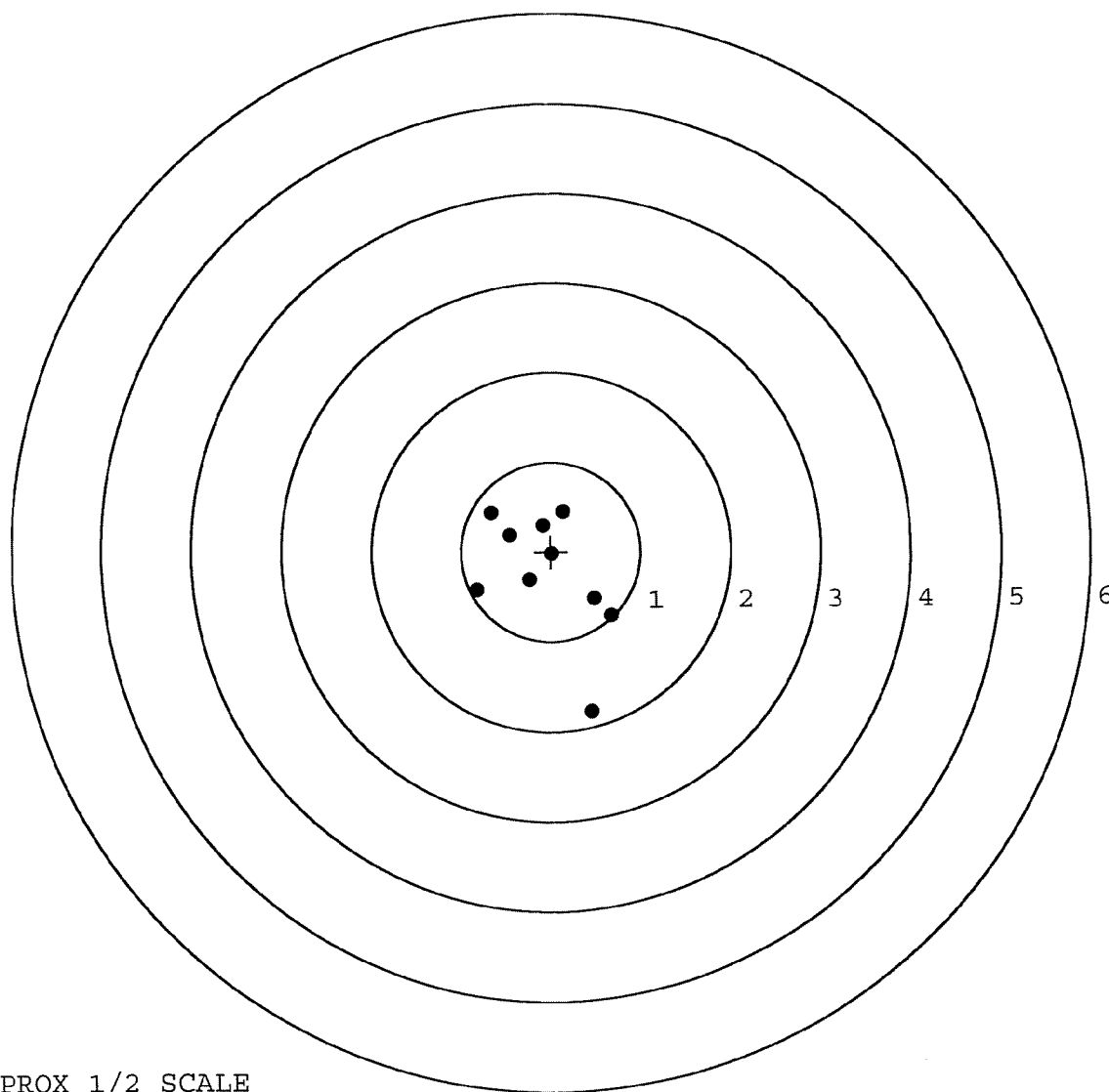


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6236245. __1
 TARGET NUMBER: 3
 FILE DATE: 01/05/2005
 FILE TIME: 11:09

POINT#	X	Y
1:	0.446	-1.780
2:	0.670	-0.720
3:	0.481	-0.528
4:	-0.829	-0.424
5:	-0.660	0.445
6:	-0.454	0.187
7:	0.145	0.447
8:	-0.093	0.294
9:	0.012	-0.021
10:	-0.243	-0.316

X CENTROID: -0.053
 Y CENTROID: -0.242
 POA TO CENTROID: 0.247
 HORZ SPREAD: 1.499
 VERT SPREAD: 2.227
 GROUP SPREAD: 2.485
 MIN RADIUS: 0.205
 MAX RADIUS: 1.617
 MEAN RADIUS: 0.708
 # IN 1 IN DIAMETER: 2
 # IN 2 IN DIAMETER: 9
 # in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6236245. __1

TARGET NUMBER: 4

FILE DATE: 01/05/2005

FILE TIME: 11:09

X CENTROID: 0.048

Y CENTROID: -0.083

POA TO CENTROID: 0.096

HORZ SPREAD: 1.813

VERT SPREAD: 1.720

GROUP SPREAD: 2.120

MIN RADIUS: 0.213

MAX RADIUS: 1.416

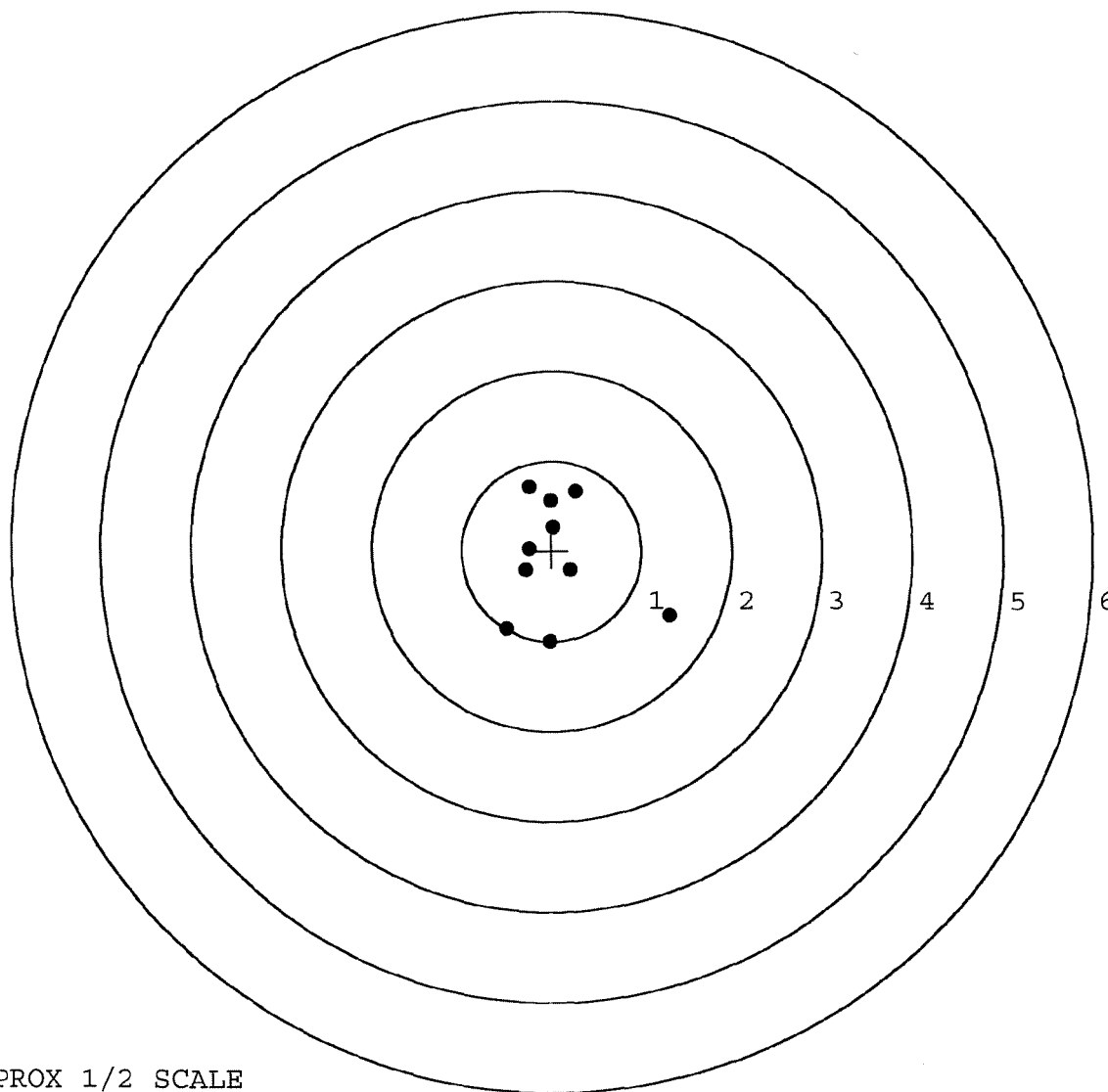
MEAN RADIUS: 0.683

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	1.310	-0.725
2:	0.213	-0.217
3:	-0.019	-1.011
4:	-0.503	-0.873
5:	-0.293	-0.219
6:	-0.252	0.026
7:	0.025	0.266
8:	0.271	0.664
9:	-0.252	0.709
10:	-0.018	0.555



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6236245. __1

TARGET NUMBER: 5

FILE DATE: 01/05/2005

FILE TIME: 11:09

X CENTROID: -0.095

Y CENTROID: 0.026

POA TO CENTROID: 0.099

HORZ SPREAD: 1.480

VERT SPREAD: 1.726

GROUP SPREAD: 1.990

MIN RADIUS: 0.171

MAX RADIUS: 1.167

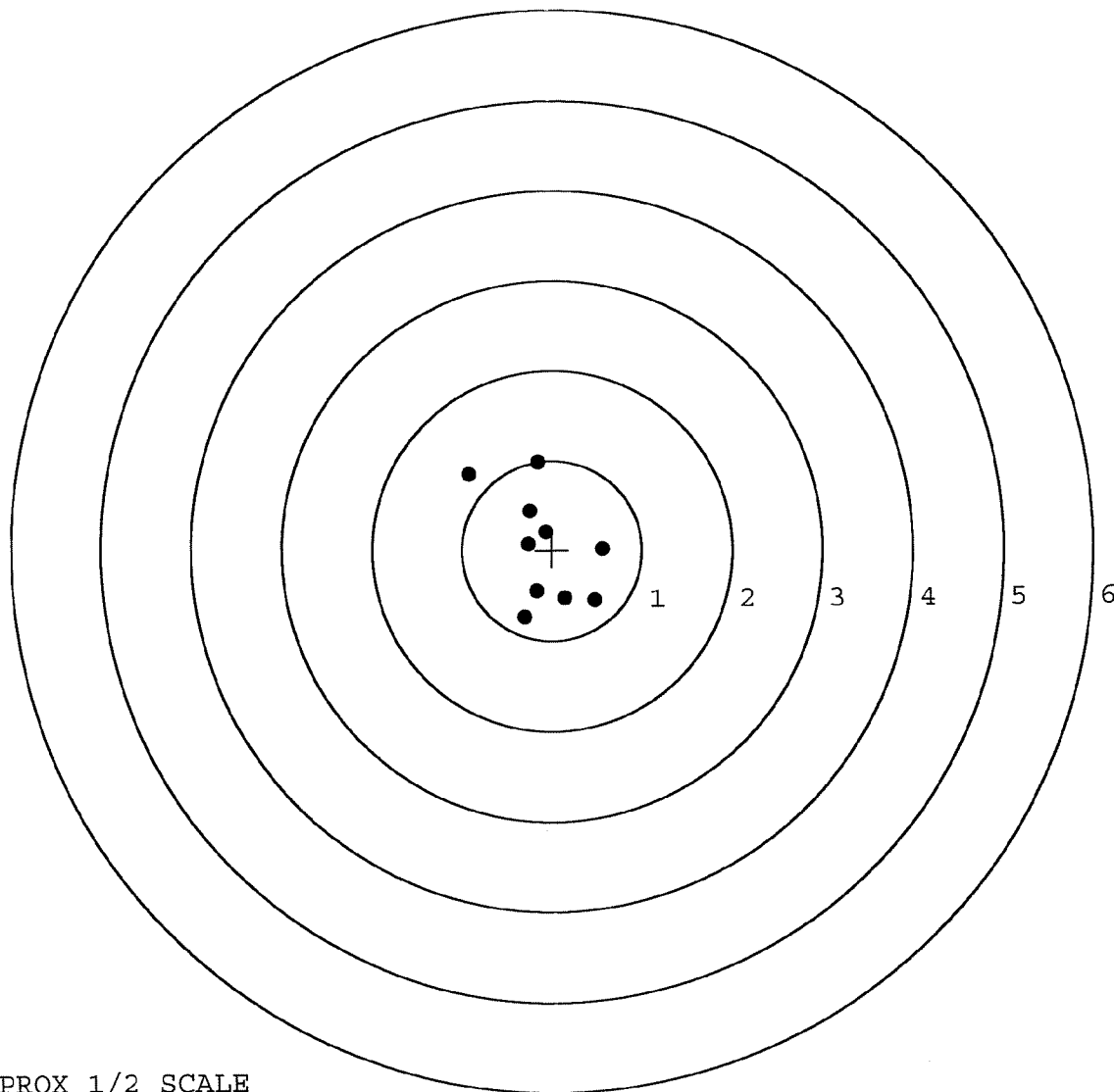
MEAN RADIUS: 0.630

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.563	0.010
2:	0.478	-0.564
3:	0.141	-0.540
4:	-0.177	-0.456
5:	-0.310	-0.741
6:	-0.917	0.855
7:	-0.153	0.985
8:	-0.245	0.441
9:	-0.071	0.202
10:	-0.260	0.071



TARGET APPROX 1/2 SCALE

R & E NUMBER	89338		
SERIAL NUMBER	G6236245		
LOG-IN DATE	12-10-04		
INSPECT AND VERIFY:			
OPERATION #	OPERATION NAME	DATE	INITIAL
550	DIS-ASSEMBLE GUN	12-13-04	RTZ
560 A	RE-BARREL	12-14-04	RTZ
B	DRILL AND TAP	12-16-04	TRW
575	ASSEMBLE	12-15-04	RTZ
600	PROOF	12-15-04	RTZ
605	CHECK HEADSPACE	12-15-04	RTZ
610	DIS-ASSEMBLE GUN	12-16-04	RTZ
612	MAGNAFLUX	OPERATOR	BSJ
615	ROLLMARK CALIBER	12-17-04	CW
618	ROTO-BLAST	12-27-04	LB
620	APPLY COATINGS	12/28/04	HP
625 A	FINAL ASSEMBLY	12-29-04	RR
B	TRIGGER PULL TEST	N/A	
C	SAFETY "ON" FORCE		
D	SAFETY "OFF" FORCE		
E	FIRING PIN INDENT		
640	TARGET	1-5-05	TRW
655	FINAL INSPECT	1-5-05	AC
660	PACK	1-5-05	DA
		SHIP DATE	
QAR INSPECTION DATE			

INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6236245

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		10/7/02	RL
600	PROOF		10/7/02	RL
607	CHECK HEADSPACE	MAGNA - FLUX	10/7/02	RL
610	DIS-ASSEMBLE GUN	INSPECTED	10/7/02	RL
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	OCT 8 2002 OPERATOR <u>Rel</u>		
615	ROLLMARK CALIBER		10/9/02	RL
617	DRILL AND TAP SIGHT HOLES		10/1 9/02	TRW
620	APPLY COATINGS (BARREL ACTION)		10-17	TA
	(BOLT)		10-17	TA
625	FINAL ASSEMBLY			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		5-13-03	A
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		5-13-03	A
	C) INSPECT EJECTOR HOLE FOR CHAMFER		5-13-03	A
	D) OIL FIRING PIN ASSEMBLY		5-13-03	A
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS		5-13-03	RL

OP #	OPERATION NAME	READINGS	DATE	INITIAL
625	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	5 5.0 5.0 5.0	7/8/03	DA
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	2.0 2.0 2.0	7/8/03	DA
	H) TRIGGER PULL TEST AND RETAINABILITY		7/8/03	DA
	I) FIRING PIN INDENT .020 MIN	.021 .023 .0250	7/8/03	DA
	J) ASSEMBLE STOCK		5-14-03	RW
	K) ASSEMBLE SWIVEL STUDS		7-24-03	RJL
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		7-24-03	RJL
	M) IRON SIGHT ALIGNMENT		7-24-03	RJL
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		7-24-03	RJL
640	GALLERY TEST AND TARGET	PASS FAIL	5-29-03	A
	MALFUNCTION	CORRECTION	5-29-03	A
	MALFUNCTION	CORRECTION	5-29-03	A
	MALFUNCTION	CORRECTION	5-29-03	A
	MALFUNCTION	CORRECTION	5-29-03	A
645	INSPECT FOR LIVE AMMO		5-29-03	A
655	FINAL INSPECTION A) HEADSPACE		7/24/03	RW
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	2.64 2.72 2.89 2.90 2.89	7-8/03	DA
	C) FUNCTION		7/24/03	RW
660	PACK		8/7/03	DA

AVERAGE PULL FORCE BETWEEN

SERIAL NO.

1 BARBER - M24 0166620

2.50# + .50#

DATE 5-5-03

3.00# + .75#

TESTER

TRW

4.00# + 1.00#

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.68	2.48		2.28	MIN. SETTING,
PULL #2	2.60	2.38		2.32	NO AVG. OF 5.
PULL #3	2.33	2.42		2.40	READINGS ACCEPT-
PULL #4	2.56	2.39		2.41	ABLE LESS THAN 2
PULL #5	2.50	2.35		2.12	
TOTAL	12.67	12.02		11.53	
AVG.	2.53	2.40		2.30	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.19	3.05		
PULL #2	3.26	3.45		
PULL #3	3.20	3.41		
PULL #4	3.18	3.33		
PULL #5	3.22	3.40		
TOTAL	16.05	16.60		
AVG.	3.21	3.32		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCUR.
PULL #1	4.32	4.06		4.22
PULL #2	4.25	4.37		4.08
PULL #3	4.26	4.41		4.07
PULL #4	4.18	4.40		4.10
PULL #5	4.26	4.20		3.94
TOTAL	21.27	21.44		20.41
AVG.	4.25	4.28		4.08

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6236245.__0
FILE DATE AND TIME: 05/29/2003 07:48

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.040
The Average Y Centroid of the Five Target Set:	-0.111
The Average Point of Impact of the Five Target Set:	0.118
The Average Mean Radius of the Five Target Set:	0.678
The Distance from POA to Centroid Target #1:	0.197
The Distance from Centroid Target #2 to Centroid Target #1:	0.160
The Distance from Centroid Target #3 to Centroid Target #1:	0.141
The Distance from Centroid Target #4 to Centroid Target #1:	0.117
The Distance from Centroid Target #5 to Centroid Target #1:	0.220

SERIAL NUMBER: G6236245. __ 0

TARGET NUMBER: 1

FILE DATE: 05/29/2003

FILE TIME: 07:48

POINT#	X	Y
1:	1.305	-0.427
2:	0.910	-0.410
3:	0.467	0.003
4:	0.230	0.579
5:	0.242	-1.081
6:	0.021	-1.182
7:	-0.440	-0.175
8:	-0.802	0.223
9:	-0.921	-0.366
10:	-0.830	0.876

X CENTROID: 0.018

Y CENTROID: -0.196

POA TO CENTROID: 0.197

HORZ SPREAD: 2.226

VERT SPREAD: 2.058

GROUP SPREAD: 2.501

MIN RADIUS: 0.459

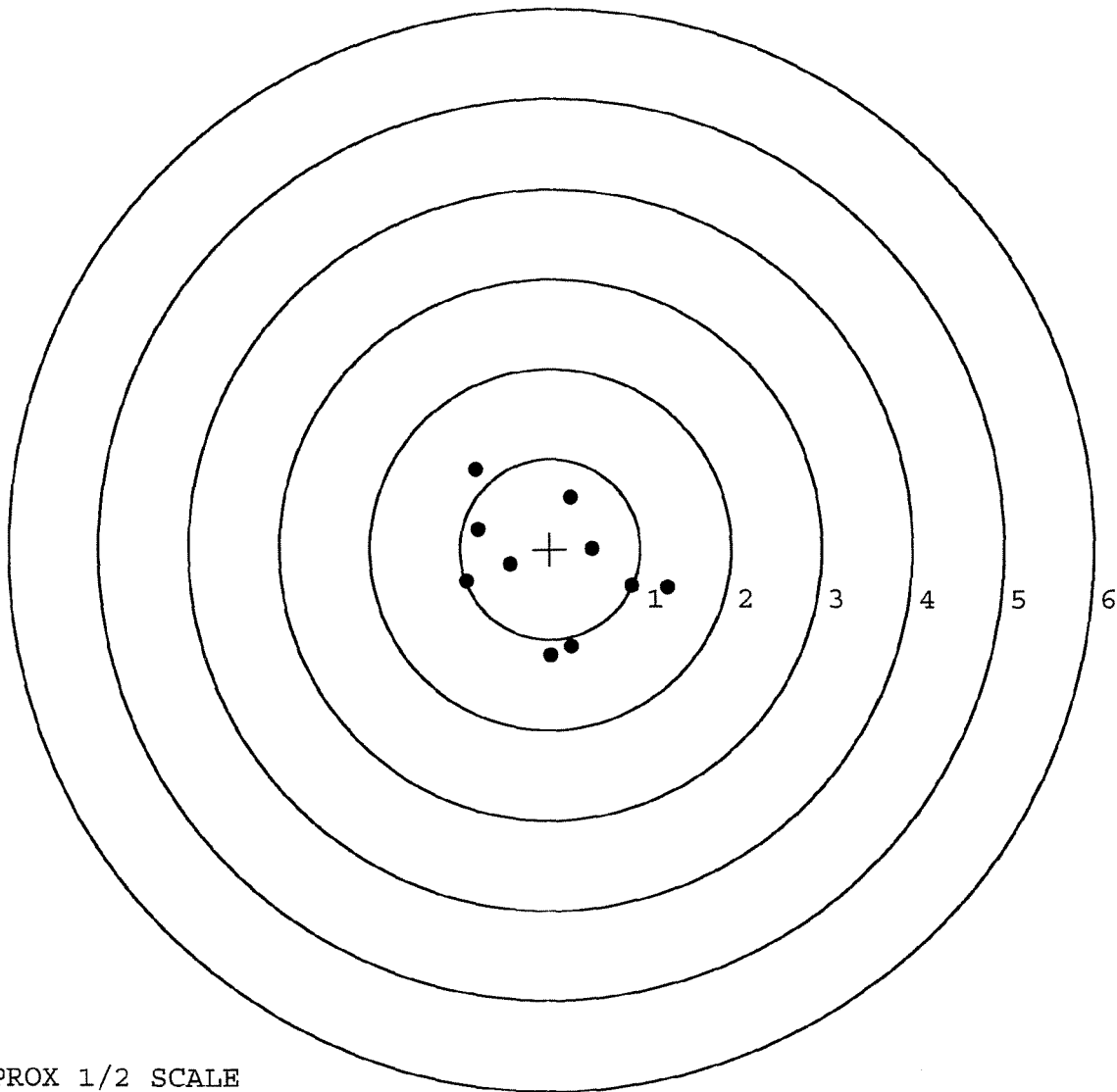
MAX RADIUS: 1.367

MEAN RADIUS: 0.912

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6236245. __0

TARGET NUMBER: 2

FILE DATE: 05/29/2003

FILE TIME: 07:48

X CENTROID: 0.079

Y CENTROID: -0.048

POA TO CENTROID: 0.093

HORZ SPREAD: 2.385

VERT SPREAD: 1.351

GROUP SPREAD: 2.406

MIN RADIUS: 0.255

MAX RADIUS: 1.241

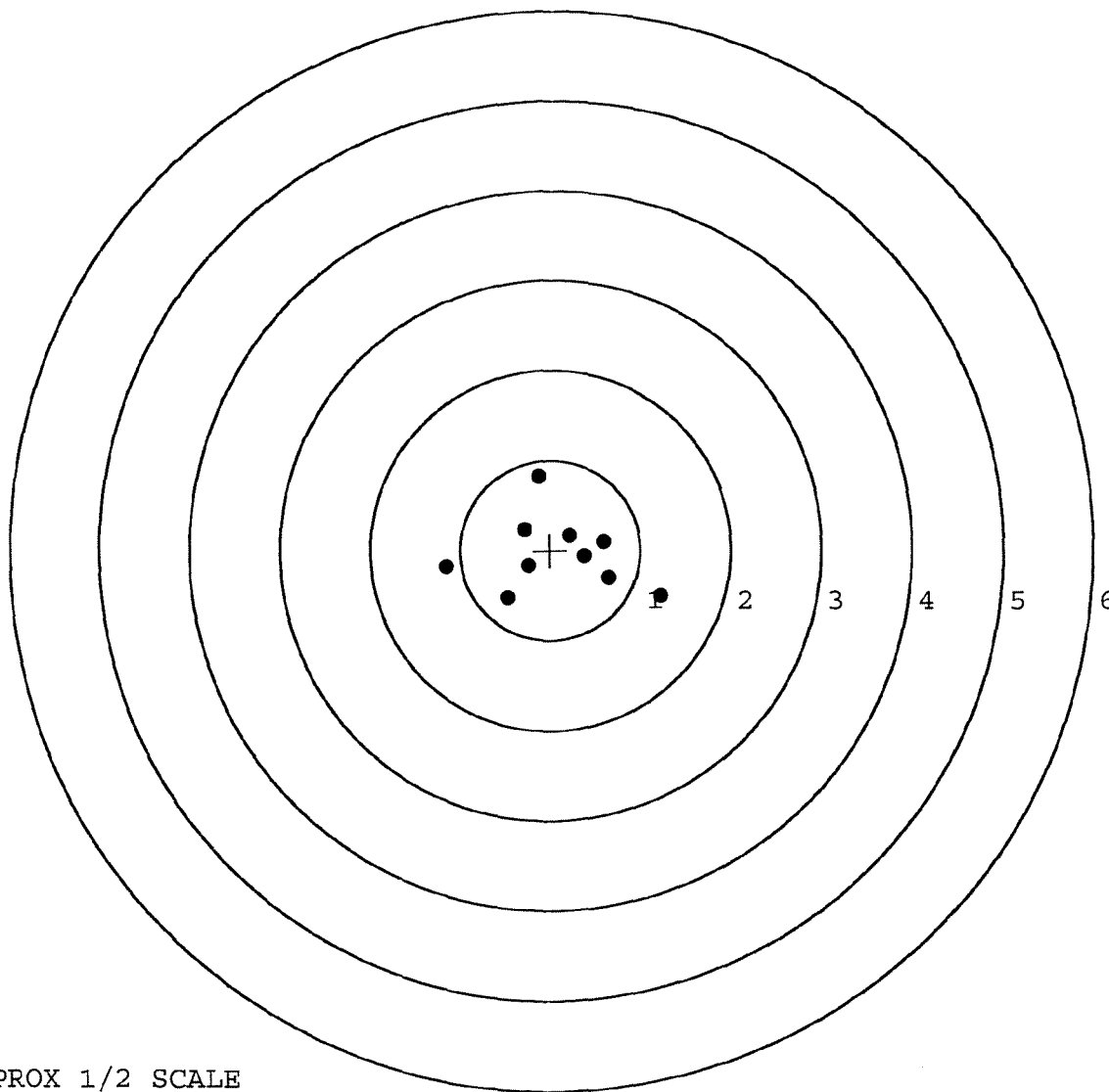
MEAN RADIUS: 0.665

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	1.231	-0.508
2:	0.652	-0.309
3:	0.598	0.096
4:	0.385	-0.073
5:	0.223	0.162
6:	-0.243	-0.180
7:	-0.470	-0.532
8:	-1.154	-0.188
9:	-0.292	0.231
10:	-0.138	0.819



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6236245. __ 0

TARGET NUMBER: 3

FILE DATE: 05/29/2003

FILE TIME: 07:48

POINT#	X	Y
1:	0.521	-0.647
2:	0.253	-0.389
3:	0.713	-0.175
4:	0.510	0.047
5:	0.012	0.540
6:	-0.460	0.698
7:	-0.325	-0.193
8:	-0.605	-0.025
9:	-0.753	-0.196
10:	-0.520	-0.482

X CENTROID: -0.065

Y CENTROID: -0.082

POA TO CENTROID: 0.105

HORZ SPREAD: 1.466

VERT SPREAD: 1.345

GROUP SPREAD: 1.665

MIN RADIUS: 0.282

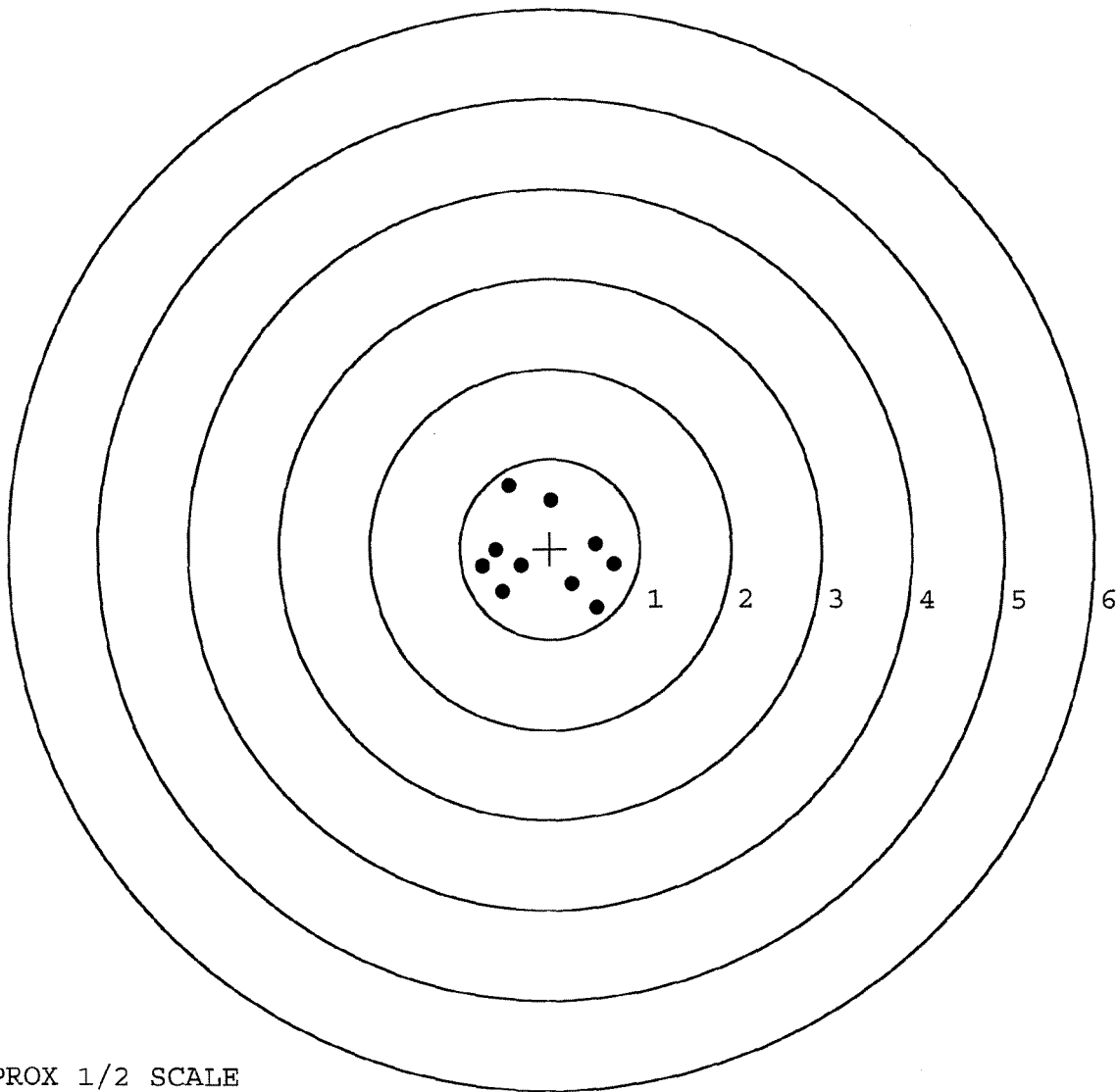
MAX RADIUS: 0.874

MEAN RADIUS: 0.626

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6236245. __ 0

TARGET NUMBER: 4

FILE DATE: 05/29/2003

FILE TIME: 07:48

POINT#	X	Y
1:	0.675	-0.416
2:	0.168	-0.995
3:	0.743	0.320
4:	0.090	0.154
5:	-0.375	0.395
6:	-0.973	0.699
7:	-0.503	-0.279
8:	0.010	-0.410
9:	-0.099	-0.063
10:	-0.141	-0.358

X CENTROID: -0.040

Y CENTROID: -0.095

POA TO CENTROID: 0.104

HORZ SPREAD: 1.716

VERT SPREAD: 1.694

GROUP SPREAD: 2.042

MIN RADIUS: 0.067

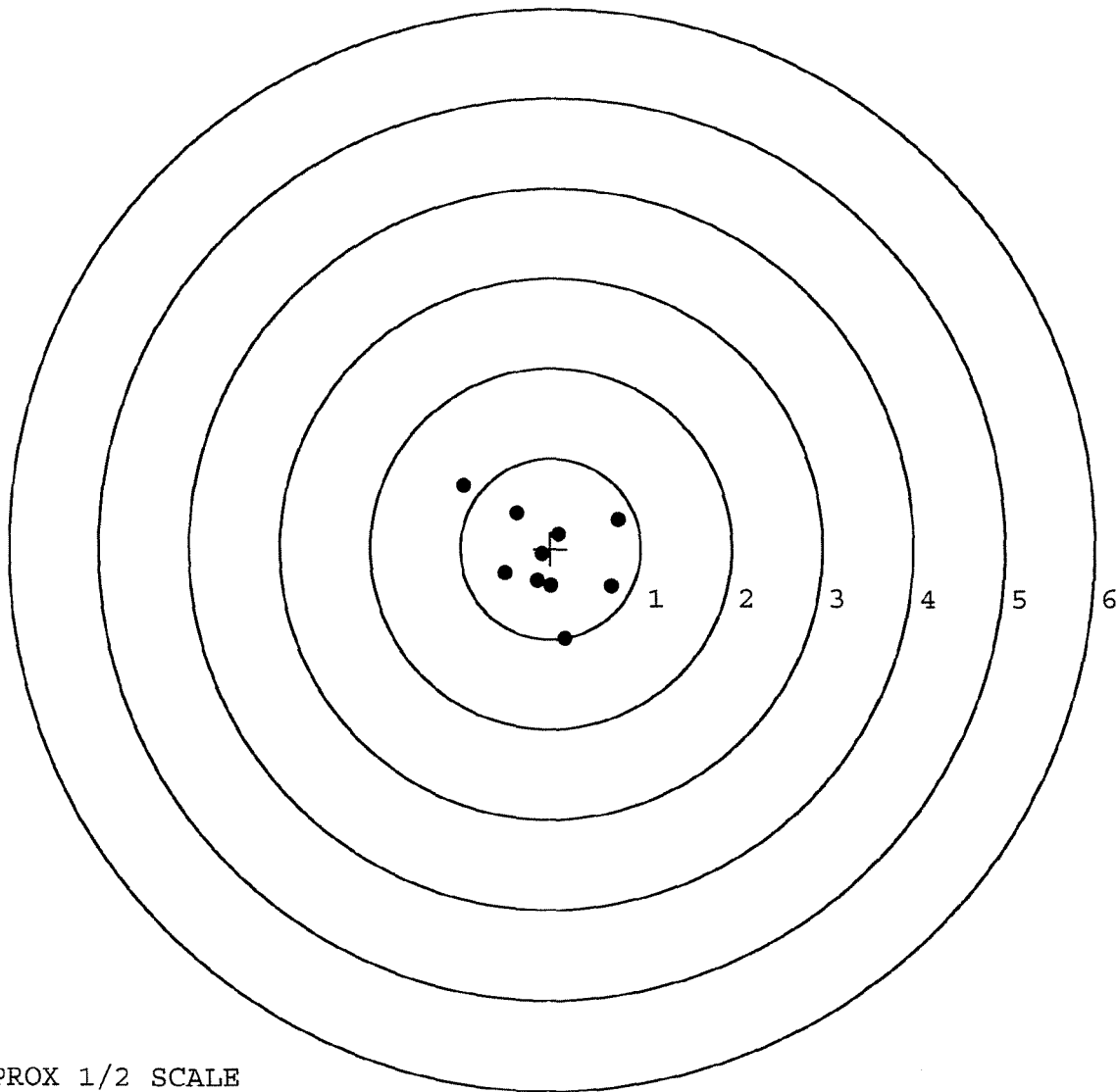
MAX RADIUS: 1.225

MEAN RADIUS: 0.586

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6236245. __0

TARGET NUMBER: 5

FILE DATE: 05/29/2003

FILE TIME: 07:48

POINT#	X	Y
1:	-0.213	-0.950
2:	0.534	-0.430
3:	0.281	0.013
4:	0.189	0.443
5:	-1.869	-0.245
6:	-0.504	0.098
7:	-0.417	-0.135
8:	-0.187	0.016
9:	0.071	0.121
10:	0.189	-0.255

X CENTROID: -0.193

Y CENTROID: -0.132

POA TO CENTROID: 0.234

HORZ SPREAD: 2.403

VERT SPREAD: 1.393

GROUP SPREAD: 2.410

MIN RADIUS: 0.149

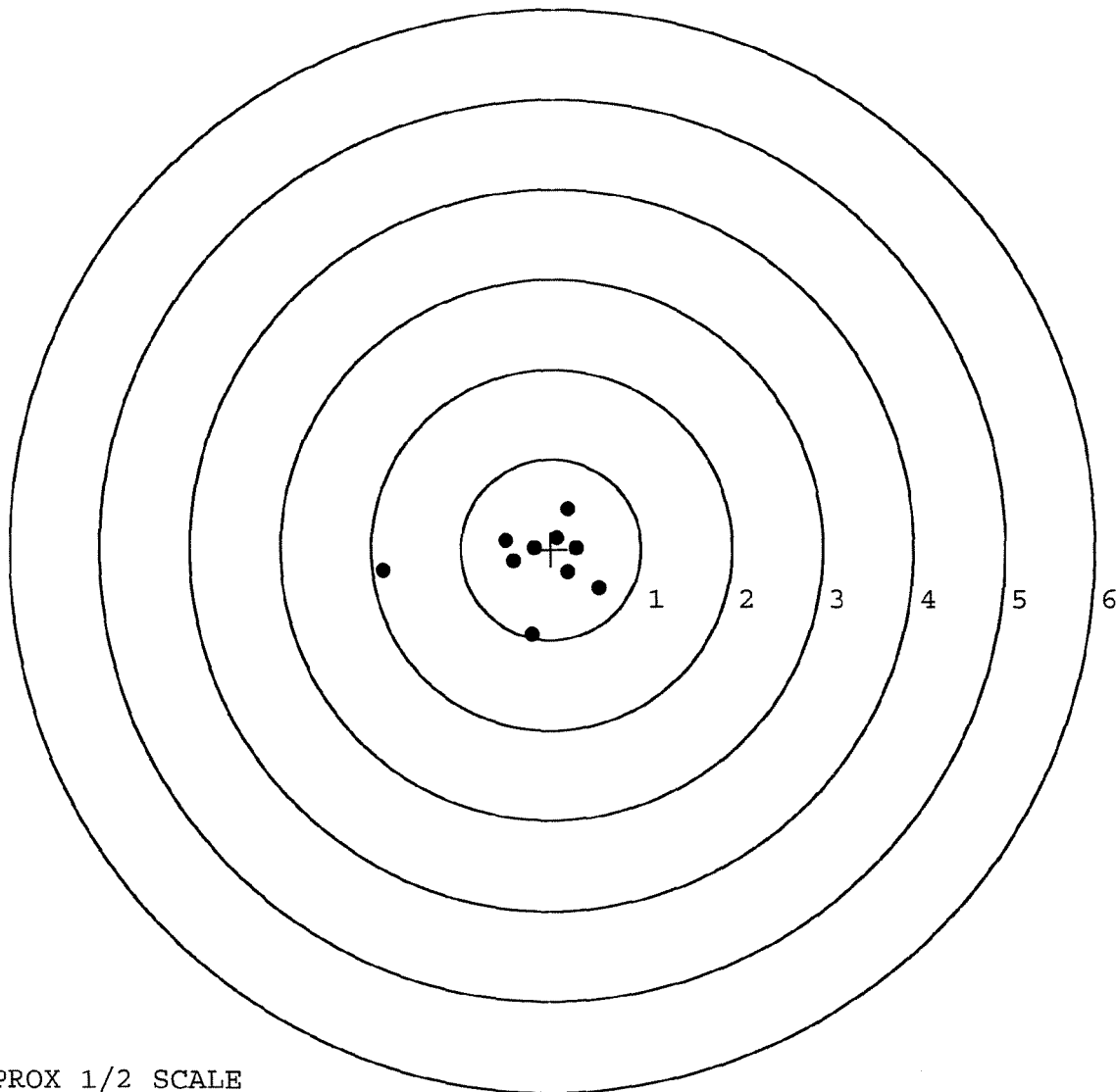
MAX RADIUS: 1.680

MEAN RADIUS: 0.600

IN 1 IN DIAMETER: 6

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 9



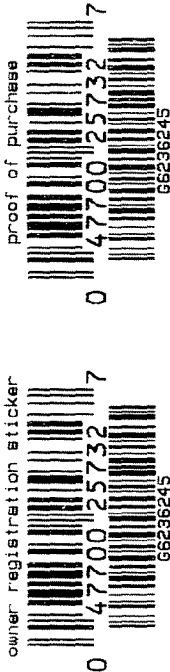
TARGET APPROX 1/2 SCALE

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 G6236245	
46		ORDER NO. 25732	
Made in Ilion, NY Reg. U.S. Pat & tm. Off. Marca Registrada Marque Deposee.		11WX	
			
5732 G6236245			

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

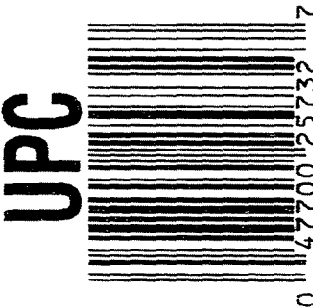
- INSTRUCTION BOOK 3518

46 FORM 200348



ORDER NO.	25732
BARREL LENGTH	24"
CAPACITY	5

G6236245



BARBER - M24 0166630

Remington Test Lab, Ilion, N.Y.

Centroidal distance calculations for Rifle # c6349154
22 Aug 2000

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1234
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.3076
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .331429

THE AMR FOR THIS RIFLE IS: 1.111

CENTROIDAL DISTANCES

0	TO	1	.235476
1	TO	2	.470287
1	TO	3	.307293
1	TO	4	.493223
1	TO	5	.430205

1 + <----POA
3 2
4

REMINGTON CENTERFIRE ACCURACY TEST

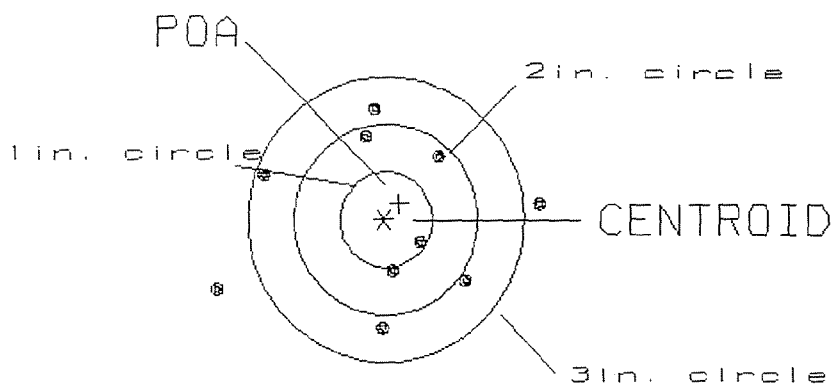
REMINGTON TEST LAB, ILION, N.Y.

PATTERN #: 1
 POA TO CENTROID: .235
 MIN RADIUS : .412
 MEAN RADIUS : 1.124
 MAX RADIUS : 1.970
 CENTROID X : -.168
 CENTROID Y : -.165

22 Aug 2000

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6349154.1

CENTERFIRE PATTERN # 1



OF SHOTS= 10

IN CIRCLE

HS= 3.52

1

VS= 2.35

4

GS= 3.62

8

BARBER - M24 0166632

REMINGTON CENTERFIRE ACCURACY TEST

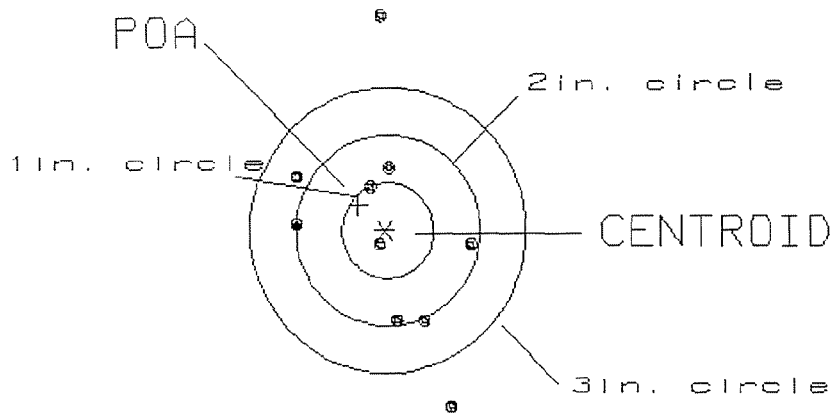
REMINGTON TEST LAB, ILION, N.Y.

PATTERN #: 0020
POA TO CENTROID: .391
MIN RADIUS : .143
MEAN RADIUS : 1.063
MAX RADIUS : 2.251
CENTROID X : .293
CENTROID Y : -.258

22 Aug 2000

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6349154.1

CENTERFIRE PATTERN # 2



OF SHOTS= 10

IN CIRCLE

HS= 1.87
VS= 4.11
GS= 4.19

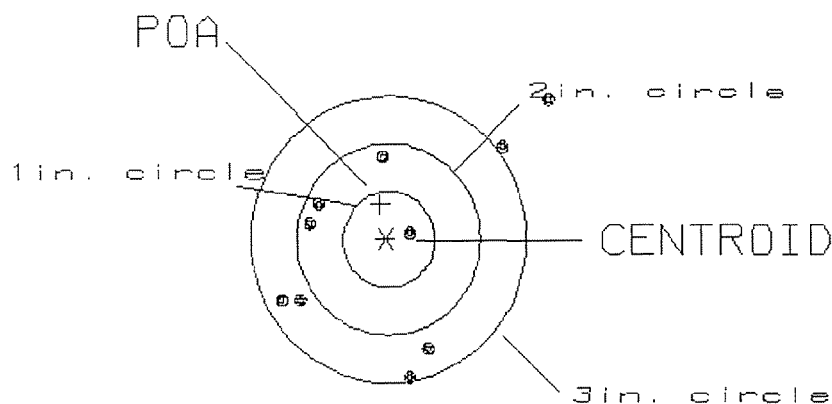
1
6
9

PATTERN #: 3
 POA TO CENTROID: .369
 MIN RADIUS : .228
 MEAN RADIUS : 1.182
 MAX RADIUS : 2.250
 CENTROID X : .067
 CENTROID Y : -.363

22 Aug 2000

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6349154.1

CENTERFIRE PATTERN # 3



OF SHOTS= 10

IN CIRCLE

HS= 2.92

1

VS= 2.90

4

GS= 3.58

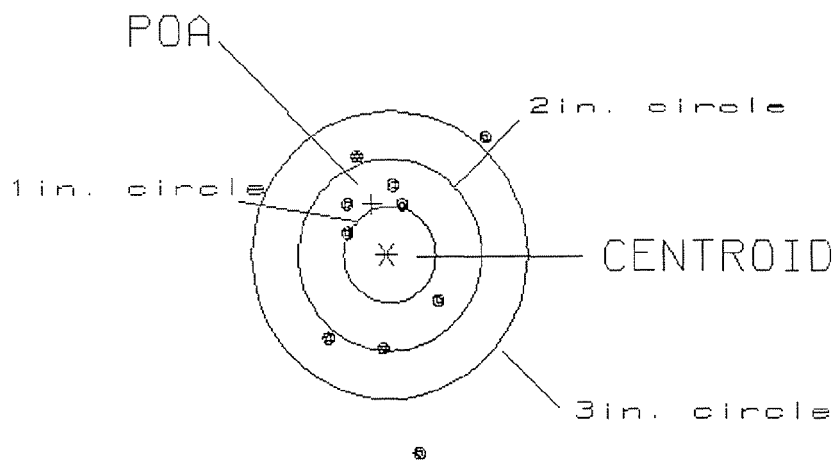
8

PATTERN #: 4
 POA TO CENTROID: .553
 MIN RADIUS : .533
 MEAN RADIUS : 1.012
 MAX RADIUS : 2.092
 CENTROID X : .167
 CENTROID Y : -.527

22 Aug 2000

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6349154.1

CENTERFIRE PATTERN # 4



OF SHOTS= 10

IN CIRCLE

HS= 1.70

0

VS= 3.29

6

GS= 3.37

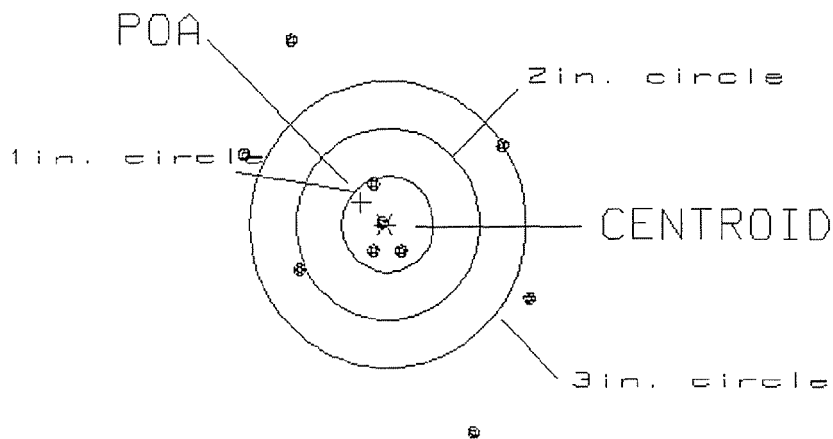
8

PATTERN #: 5
 POA TO CENTROID: .343
 MIN RADIUS : .094
 MEAN RADIUS : 1.174
 MAX RADIUS : 2.315
 CENTROID X : .258
 CENTROID Y : -.225

22 Aug 2000

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6349154.1

CENTERFIRE PATTERN # 5



OF SHOTS= 10

IN CIRCLE

HS= 3.13

4

VS= 4.07

4

GS= 4.50

5

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

R & E NUMBER		8587	
SERIAL NUMBER		C6349154	
LOG-IN DATE		4-24-00	
INSPECT AND VERIFY:			
OPERATION #	OPERATION NAME	DATE	INITIAL
550	DIS-ASSEMBLE GUN	4-24-00	RW
560 A	RE-BARREL AT CUSTOM SHOP		
B	DRILL AND TAP		
C	POLISH		
575	ASSEMBLE		
600	PROOF	5-2-00	RW
605	CHECK HEADSPACE	5-2-00	RW
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	8-21-00	RW
655	FINAL INSPECT	8-22-00	RW
660	PACK		
		SHIP DATE	
QAR INSPECTION DATE			

Final Inspection

S.D. C6349154

DATE REC'D: 4-24-00

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:

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C634 9154

DATE 12 MAR 90

TESTER JD

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	217	237		229	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	221	227		231	
PULL #3	218	227		232	
PULL #4	221	232		233	
PULL #5	214	226		220	
TOTAL	1091	1149			
AVG.	218.2	229.8			

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.13	3.17		
PULL #2	3.09	3.15		
PULL #3	3.11	3.11		
PULL #4	3.06	3.12		
PULL #5	3.13	3.07		
TOTAL	15.52	15.59		
AVG.	3.104	3.118		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.37	4.19		
PULL #2	4.25	4.19		
PULL #3	4.26	4.14		
PULL #4	4.05	4.09		
PULL #5	4.19	3.95		
TOTAL	21.12	20.56		
AVG.	4.224	4.112		

Remington® **DUPONT** REG. U.S. PAT. & TM. OFF.

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

MODEL 700™ H24

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

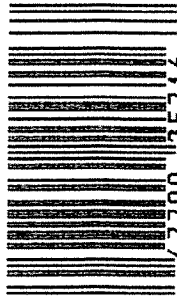
SERIAL NO. 06349154	ORDER NO. 5716
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Ø1



5716 06349154

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6349154

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	9 26	89	RW
600	Proof	9 26	89	RW
607	Check Headspace	9 26	89	RW
610	Dis-assemble Gun	9 26	89	RW
612	Magnaflux Barrel Action	REJECTED 9/29/89		KCR
	Magnaflux Bolt	9/29/89		KCR
615	Rollmark Caliber			
7	Drill and Tap Sight Holes			
618	Polish Barrel			
620	Apply Coatings (Barrel Action)			
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly			
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head			
	C) Inspect Ejector Hole for Chamfer			
	D) Oil Firing Pin Ass'y			
	E) Adjust Trigger Pull to Min Setting and Stake			

op. #	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			

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6349154

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	10-9	89	RW
600	Proof	10-9	89	A
607	Check Headspace	10-9	89	RW
610	Dis-assemble Gun	10-9	89	RW
612	Magnaflux Barrel Action		11/2/89	KCK
	Magnaflux Bolt		11/2/89	KCK
615	Rollmark Caliber		11/2/89	GS
7	Drill and Tap Sight Holes			
618	Polish Barrel			
620	Apply Coatings (Barrel Action)		11-3-89	TJA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		11-7-89	A
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		11-7-89	A
	C) Inspect Ejector Hole for Chamfer		11-7-89	A
	D) Oil Firing Pin Ass'y		11-7-89	A
	E) Adjust Trigger Pull to Min Setting and Stake		10/16/89	GS

BARBER - M24 0166643							
op. #	OP. NAME	READINGS			DATE	INIT	
625 cont.	F) Safety On Force	5	5	5	10 Nov 89	JS	
	G) Safety Off Force	3	3	3	10 Nov 89	JS	
	H) Trigger Pull Test & Retainability				10 Nov 89	JS	
	I) Firing Pin Indent	1021	1021	1022	10 Nov 89	JS	
	J) Assemble Stock				11-16-89	K	
	K) Assemble Swivel Studs				28 Nov 89	JS	
	L) Attach Front and Rear Sight Assemblies				11-16-89	K	
	M) Iron Sight Alignment				11-16-89	AP	
	N) Detach Front & Rear Sights & place in numbered container				11-16-89	AC	
	O) Attach Scope to Rifle				16 Nov 89	JS	
	P) Detach & Attach Scope 20 Times				16 Nov 89	JS	
640	Gallery Target & Test				11-27-89	D/H	
	A) Time				11-27-89	D/H	
	B) Malfunctions				11-27-89	D/H	
	C) Pierced Primers				11-27-89	D/H	
	D) Optical Clarity of Scope				11-27-89	D/H	
645	Inspect for Live Ammo				11-27-89	D/H	
655	Final Inspection						
	A) Headspace				28 Nov 89	JS	
	B) Trigger Pull	235	231	239	239	237	28 Nov 89
	C) Function				28 Nov 89	JS	
660	Pack				15 Dec 89	JS	

CENTROIDAL DISTANCE CALCULATIONS
 FOR RIFLE # C6349154
 27 Nov 1989

CENTROIDAL DISTANCES

0 TO	1	.149482
1 TO	2	.363034
1 TO	3	.29274
1 TO	4	.122332
1 TO	5	.261276

σ^2 $\sum$ ---- POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .05
 THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0212
 THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0543087
 THE AMR FOR THIS RIFLE IS: .9894

27 Nov 1989

FILE:/PATTERNING/CENTERFIRE_PATT/06048154

CENTERFIRE PATTERNS

1

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 2

2in = 6

3in = 10

HS= 2.088

VS= 1.675

GS= 2.314

CENTROID *

PATTERN #	:	1	2	3
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.054	.939	.832
MINIMUM X	:	-1.034	-.855	-.731
MAXIMUM Y	:	.851	.930	.840
MINIMUM Y	:	-.824	-.745	-.835
CENTROID X	:	.021	.136	.243
CENTROID Y	:	-.148	-.227	-.137
POA TO CENTROID in.	:	.150	.265	.279
MIN RADIUS	:	.287	.290	.430
MEAN RADIUS	:	.865	.818	.781
MAX RADIUS	:	1.254	1.120	1.030
HORIZONTAL SPREAD	:	2.088	1.794	1.563
VERTICAL SPREAD	:	1.675	1.675	1.675
EXTREME SPREAD	:	2.314	1.967	1.967
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	

27 Nov 1989

FILE:/PATTERNING/CENTERFIRE_PATT/06345154

CENTERFIRE PATTERNS # 2

POA

1in circle

2in circle

3in circle

OF SHOTS= 10

IN CIR

1in = 1

2in = 3

3in = 8

HS= 2.831

VS= 2.777

GS= 2.927

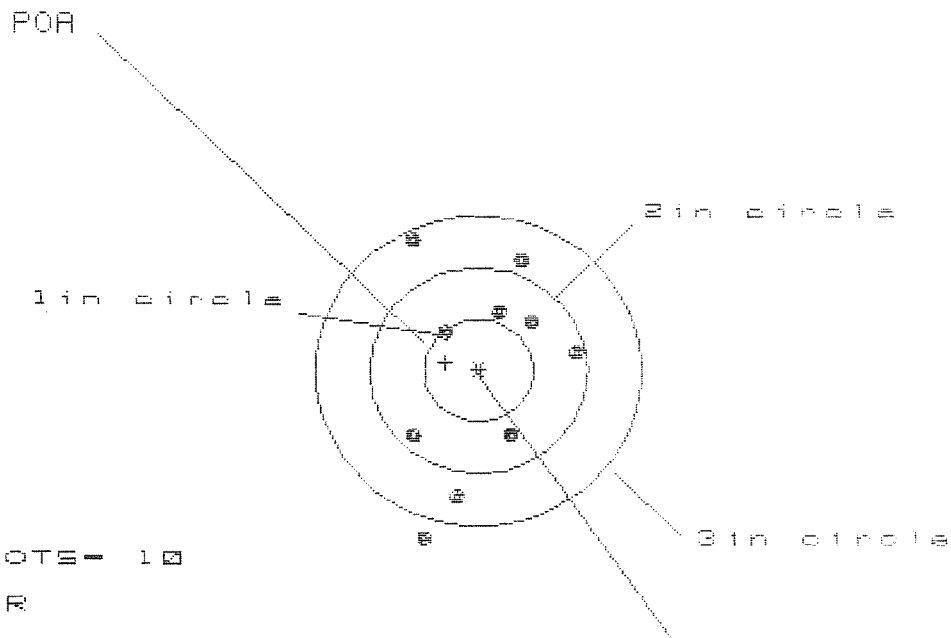
CENTROID *

PATTERN #	:	2
SHOTS (BEST OF)	:	10
MAXIMUM X	:	1.233
MINIMUM X	:	-1.588
MAXIMUM Y	:	1.531
MINIMUM Y	:	-1.246
CENTROID X	:	.134
CENTROID Y	:	.197
POA TO CENTROID in.	:	.238
MIN RADIUS	:	.292
MEAN RADIUS	:	1.128
MAX RADIUS	:	1.640
HORIZONTAL SPREAD	:	2.821
VERTICAL SPREAD	:	2.777
EXTREME SPREAD	:	2.927
NUMBER IN ONE INCH CIRCLE	=	1
NUMBER IN TWO INCH CIRCLE	=	3
NUMBER IN THREE INCH CIRCLE	=	8

27 Nov 1989

FILE:/PATTERNING/CENTERFIRE_PATT/06049154

CENTERFIRE PATTERNS # 3



OF SHOTS - 10

IN CIR

1 in = 1

2 in = 6

3 in = 9

HS = 1.509

VS = 2.881

GS = 2.888

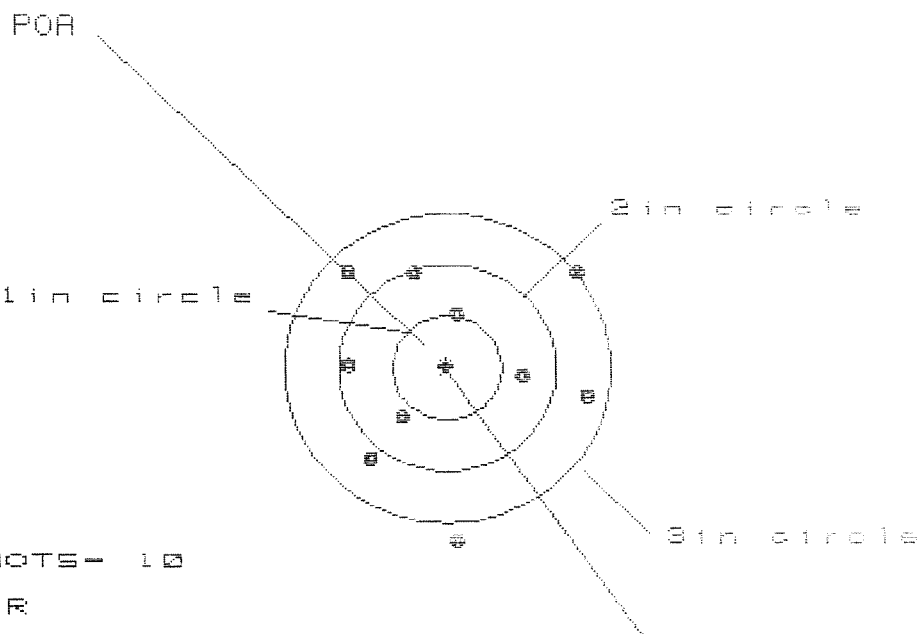
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.856	.885	.717
MINIMUM X	-.653	-.704	-.768
MAXIMUM Y	1.301	1.125	1.094
MINIMUM Y	-1.588	-1.378	-1.237
CENTROID X	.385	.356	.444
CENTROID Y	-.077	.099	-.042
POA TO CENTROID in.	.315	.370	.446
MIN RADIUS	.474	.383	.539
MEAN RADIUS	.980	.872	.819
MAX RADIUS	1.645	1.397	1.278
HORIZONTAL SPREAD	1.509	1.509	1.485
VERTICAL SPREAD	2.881	2.503	2.321
EXTREME SPREAD	2.888	2.547	2.393
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	9		

27 Nov 1989

FILE:/PATTERNING/CENTERFIRE_PATT/06345154

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1 in = 0

2 in = 5

3 in = 9

HS= 2.190

VS= 2.568

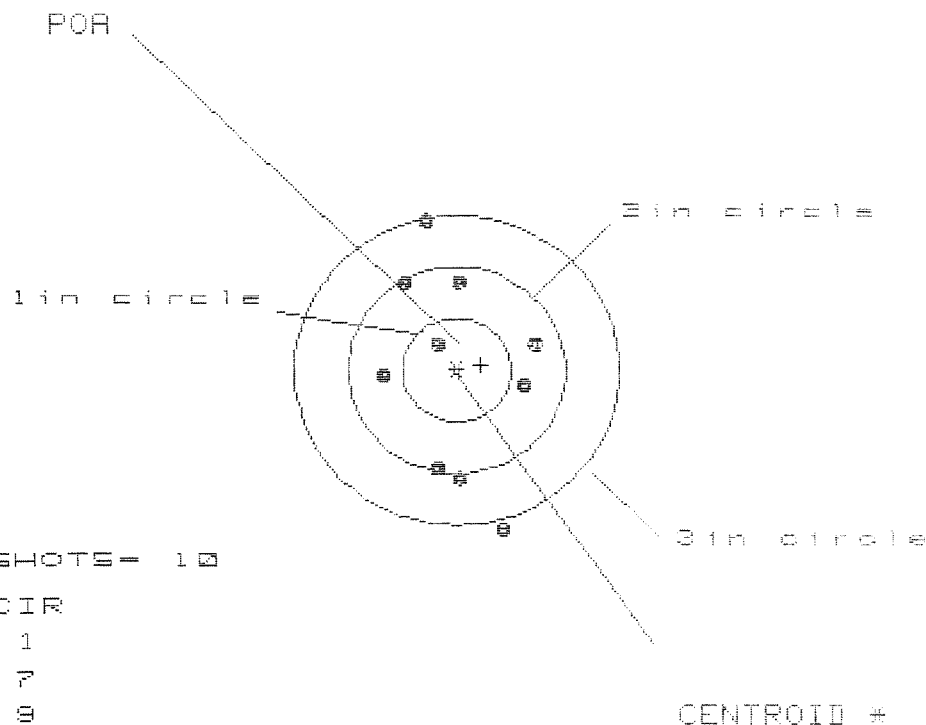
GS= 2.774

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.244	1.251	1.401
MINIMUM X	:	-.946	-.939	-.789
MAXIMUM Y	:	.917	.733	.821
MINIMUM Y	:	-1.651	-1.046	-.958
CENTROID X	:	.012	.005	-.145
CENTROID Y	:	-.026	.158	.070
POA TO CENTROID in.	:	.028	.158	.161
MIN RADIUS	:	.563	.382	.509
MEAN RADIUS	:	1.052	.966	.901
MAX RADIUS	:	1.652	1.386	1.447
HORIZONTAL SPREAD	:	2.190	2.190	2.190
VERTICAL SPREAD	:	2.568	1.779	1.779
EXTREME SPREAD	:	2.774	2.558	2.444
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

27 Nov 1989

FILE:/PATTERNING/CENTERFIRE_PATT/08349154

CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 7

3 in = 9

HS= 1.432

VS= 2.954

GS= 3.034

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.714	.764	.740
MINIMUM X	:	-.718	-.668	-.692
MAXIMUM Y	:	1.436	1.267	.855
MINIMUM Y	:	-1.518	-1.227	-1.069
CENTROID X	:	-.222	-.272	-.248
CENTROID Y	:	-.052	.117	-.042
POR TO CENTROID in.	:	.228	.296	.252
MIN RADIUS	:	.301	.140	.278
MEAN RADIUS	:	.922	.821	.771
MAX RADIUS	:	1.584	1.281	1.069
HORIZONTAL SPREAD	:	1.432	1.432	1.432
VERTICAL SPREAD	:	2.954	2.494	1.924
EXTREME SPREAD	:	3.034	2.504	1.960
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	