G 664 5310
Rupheen
G 635 1092

Arms Service 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: RE00130078

Verify Repair

Serial: G6391094 Model M24 SWS Center Fire
Caliber: 7.62 NATO

Repairman:

Status: New 6/6/2007 7:20:36 AM

Address Information

Customer: (Received From)		Return To: (Received From)	
Name:	DEPARTMENT OF THE ARMY SUPPLY OFFICER		DEPARTMENT OF THE ARMY SUPPLY OFFICER
Address 1:	DOL SISA BLDG 9660 BAY A		DOL SISA BLDG 9660 BAY A
Address 2:	BOX 339500 MS 181 PO Box:		BOX 339500 MS 181 PO Box:
City:	FORT LEWIS		FORT LEWIS
State:	WA Zip Code: 98433 Country: US	State:	WA Zip Code: 98433 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
D000	FRONT BASE	1

Repair Search | Refresh | Close

nagleti | 6/6/2007 | 8:10 AM | CAPS | NUM | INS | SCRL

start | 4 Mi... | 4 In... | Arms ... | Part ... | 2 Mi... | 2 S... | 8:10 AM

Serial Number: ~~G6391094~~

Model: M24 SWS

"NEW" G6645310

RE00130078

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFOMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6645310.__0
FILE DATE AND TIME: 07/20/2007 23:03

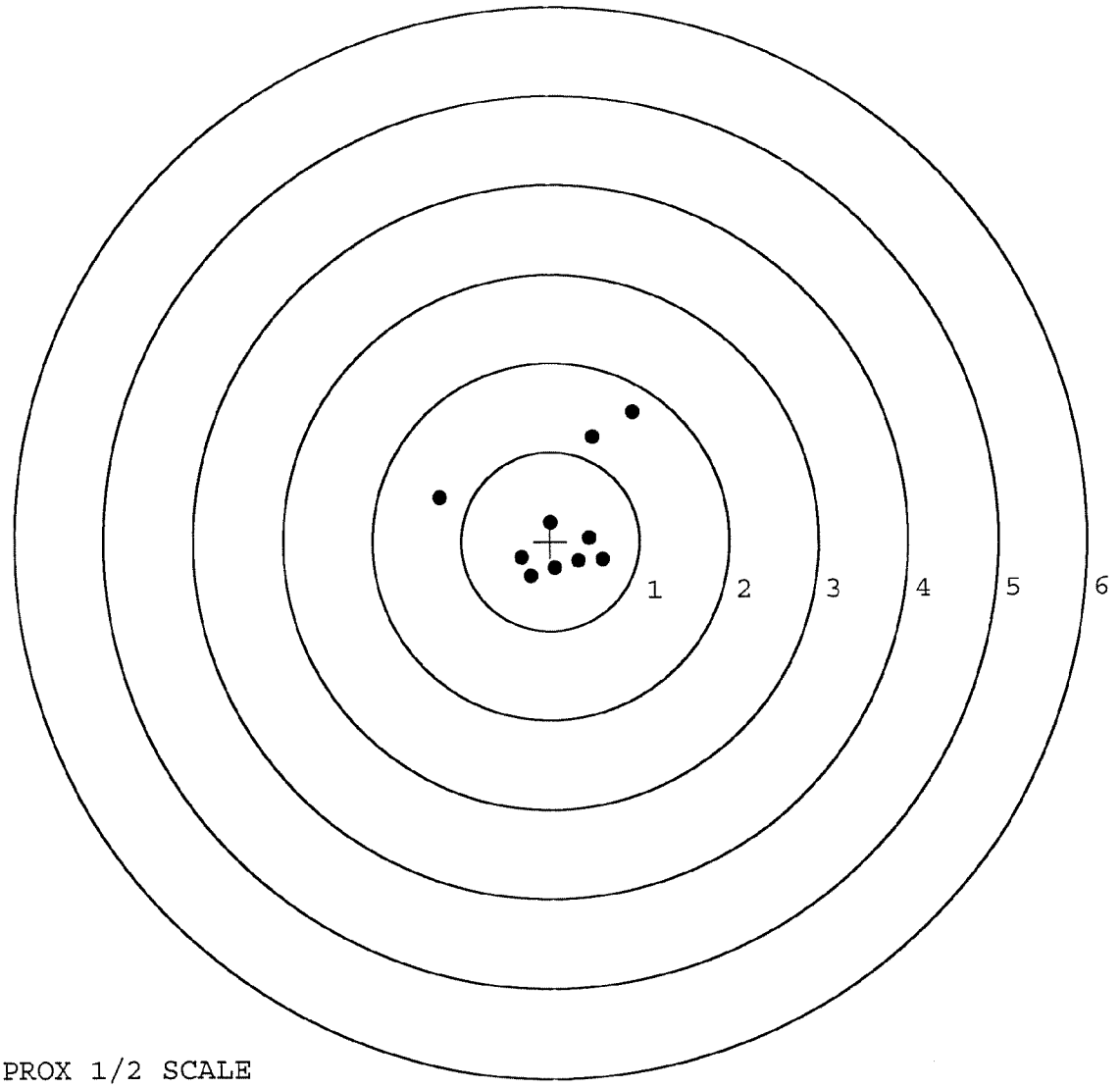
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.060
The Average Y Centroid of the Five Target Set:	0.042
The Average Point of Impact of the Five Target Set:	0.074
The Average Mean Radius of the Five Target Set:	0.713
The Distance from POA to Centroid Target #1:	0.226
The Distance from Centroid Target #2 to Centroid Target #1:	0.445
The Distance from Centroid Target #3 to Centroid Target #1:	0.237
The Distance from Centroid Target #4 to Centroid Target #1:	0.349
The Distance from Centroid Target #5 to Centroid Target #1:	0.191

SERIAL NUMBER: G6645310.__0
TARGET NUMBER: 1
FILE DATE: 07/20/2007
FILE TIME: 23:03

X CENTROID:	0.101
Y CENTROID:	0.203
POA TO CENTROID:	0.226
HORZ SPREAD:	2.175
VERT SPREAD:	1.831
GROUP SPREAD:	2.369
MIN RADIUS:	0.107
MAX RADIUS:	1.487
MEAN RADIUS:	0.726
# IN 1 IN DIAMETER:	3
# IN 2 IN DIAMETER:	7
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	0.486	1.163
2:	0.932	1.436
3:	-0.006	0.211
4:	0.438	0.034
5:	0.588	-0.210
6:	0.317	-0.222
7:	0.049	-0.306
8:	-0.226	-0.395
9:	-0.325	-0.180
10:	-1.243	0.496

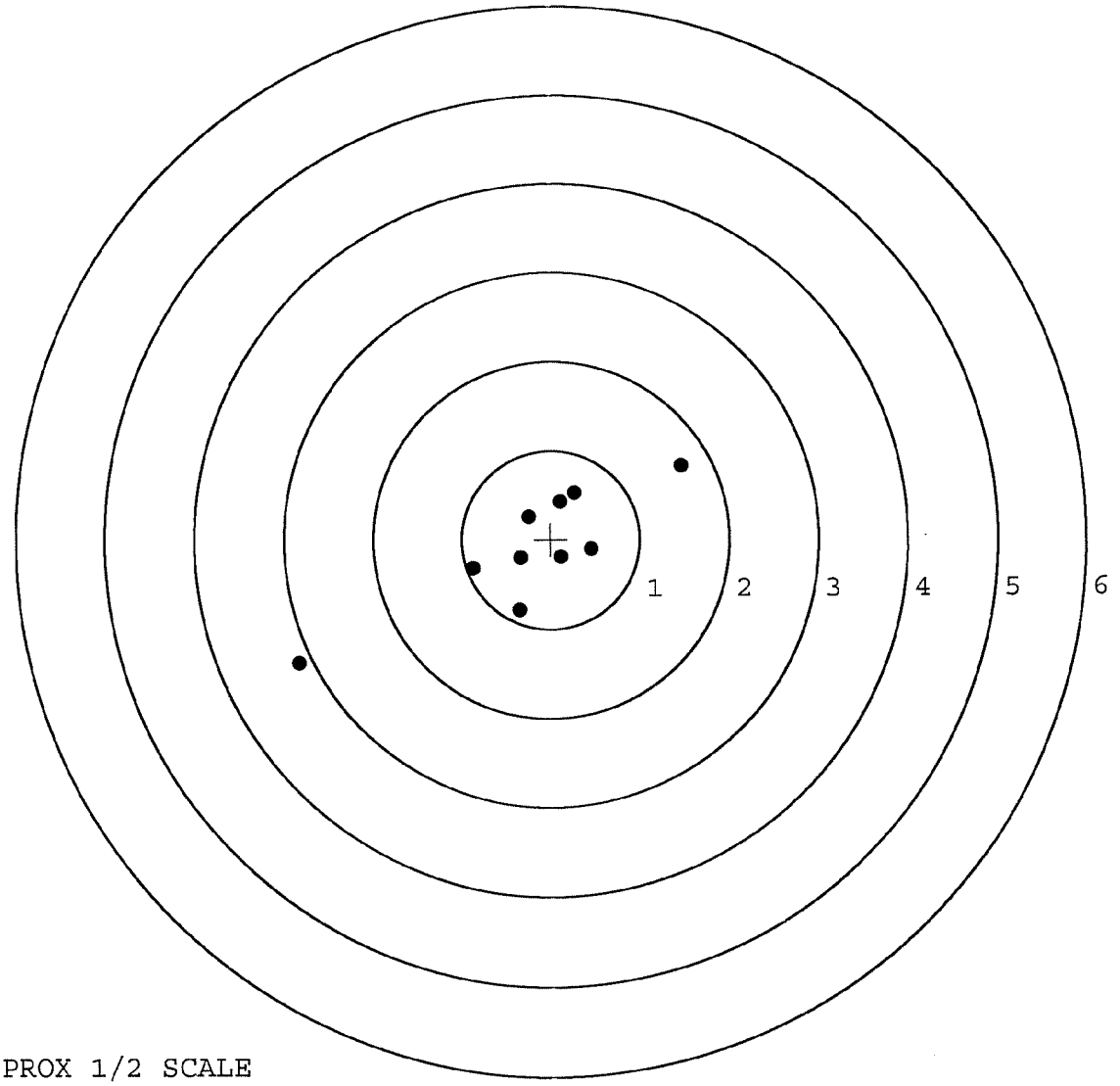


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6645310.__0
TARGET NUMBER: 2
FILE DATE: 07/20/2007
FILE TIME: 23:03

X CENTROID:	-0.226
Y CENTROID:	-0.099
POA TO CENTROID:	0.247
HORZ SPREAD:	4.301
VERT SPREAD:	2.192
GROUP SPREAD:	4.827
MIN RADIUS:	0.162
MAX RADIUS:	2.907
MEAN RADIUS:	0.919
# IN 1 IN DIAMETER:	3
# IN 2 IN DIAMETER:	8
# in 3 IN DIAMETER:	8

POINT#	X	Y
1:	0.268	0.525
2:	0.109	0.421
3:	-0.250	0.257
4:	0.114	-0.206
5:	0.457	-0.119
6:	1.461	0.821
7:	-0.356	-0.788
8:	-0.346	-0.208
9:	-0.878	-0.326
10:	-2.840	-1.371



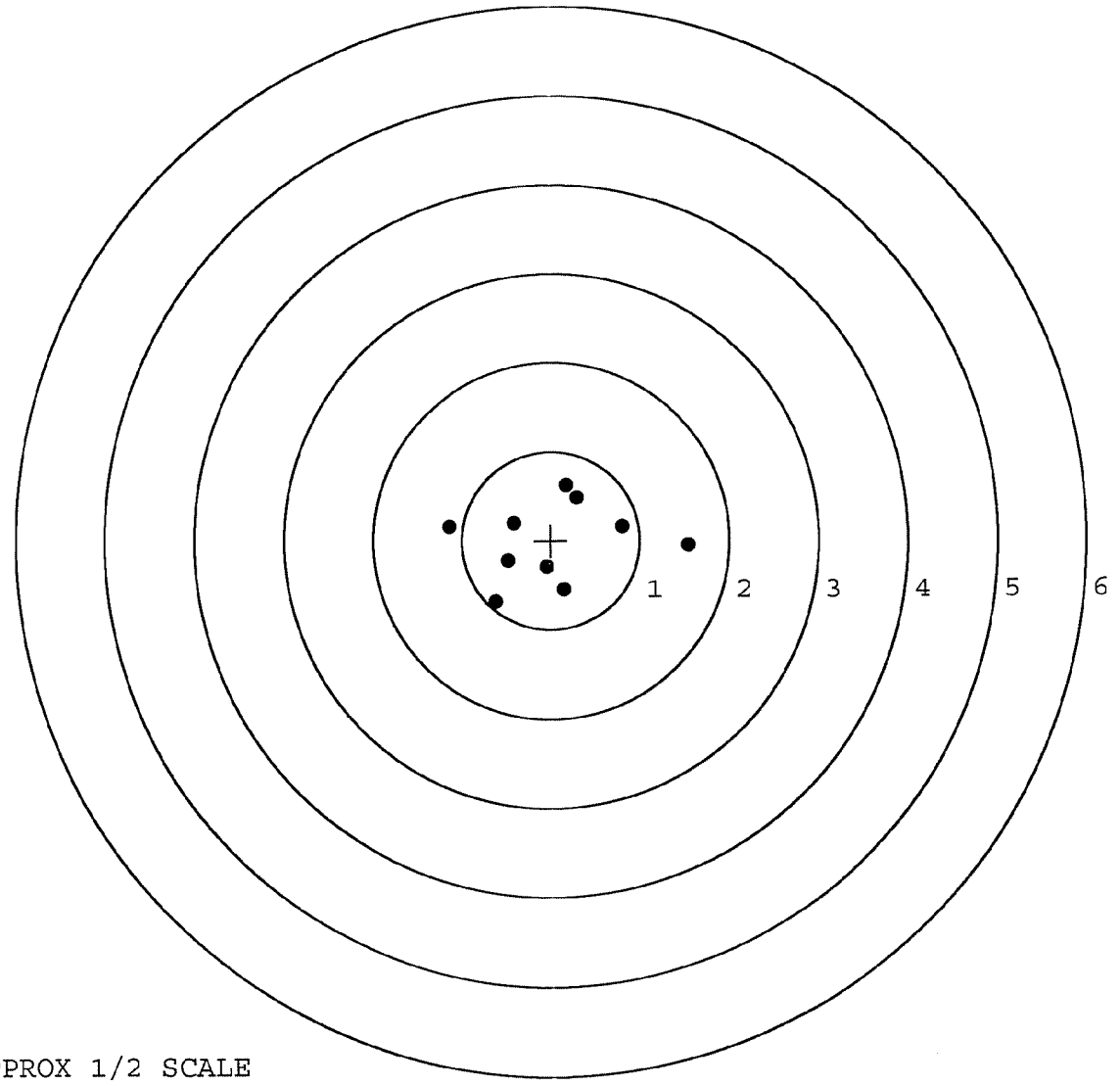
TARGET APPROX 1/2 SCALE

BARBER - M24 0171243

SERIAL NUMBER: G6645310.__0
TARGET NUMBER: 3
FILE DATE: 07/20/2007
FILE TIME: 23:03

X CENTROID:	0.025
Y CENTROID:	-0.022
POA TO CENTROID:	0.034
HORZ SPREAD:	2.690
VERT SPREAD:	1.310
GROUP SPREAD:	2.699
MIN RADIUS:	0.292
MAX RADIUS:	1.520
MEAN RADIUS:	0.755
# IN 1 IN DIAMETER:	2
# IN 2 IN DIAMETER:	8
# in 3 IN DIAMETER:	9

POINT#	X	Y
1:	0.175	0.622
2:	0.295	0.485
3:	0.803	0.157
4:	1.545	-0.060
5:	0.148	-0.557
6:	-0.047	-0.305
7:	-0.480	-0.232
8:	-0.414	0.195
9:	-0.625	-0.688
10:	-1.145	0.164

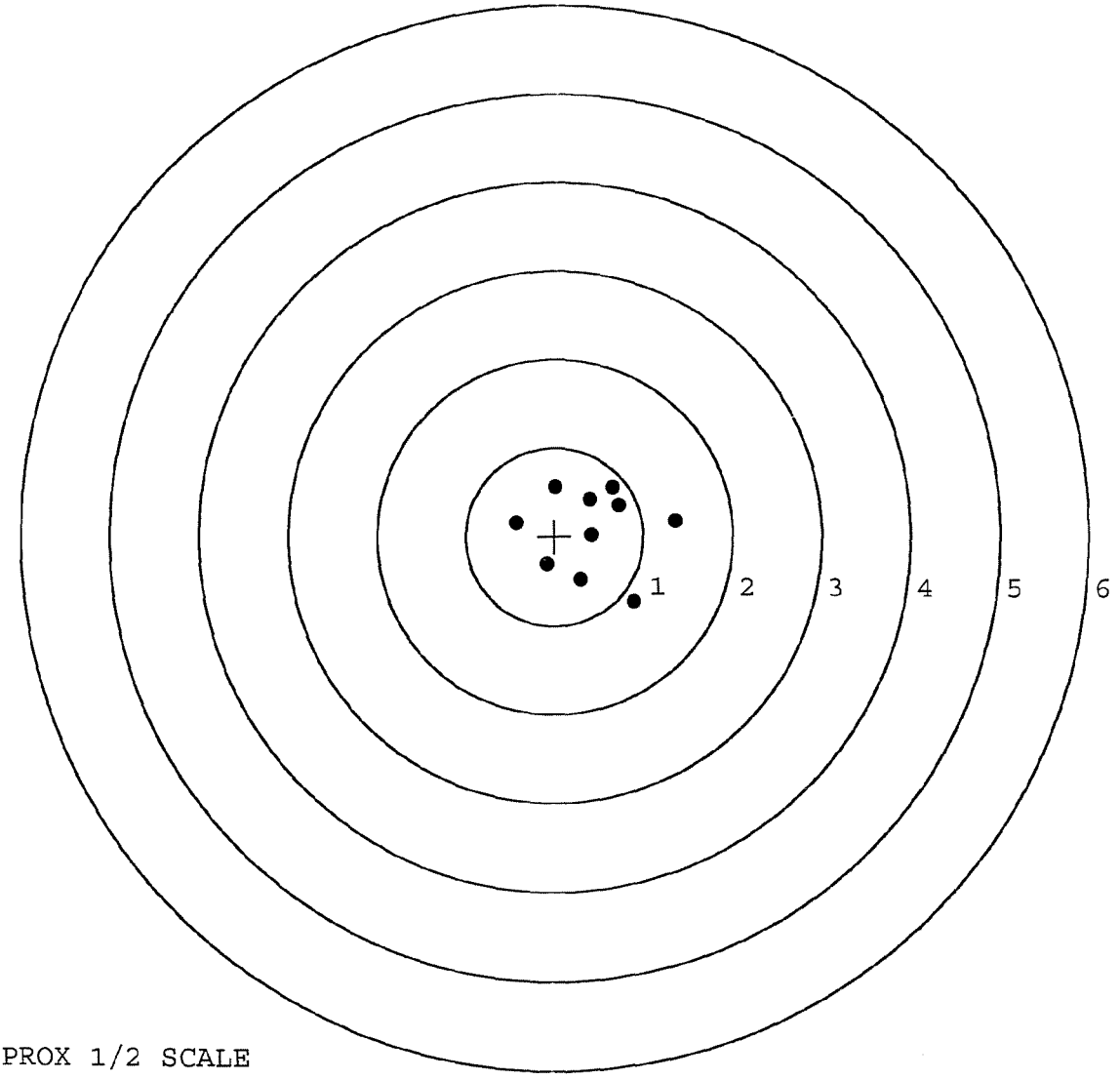


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6645310.__0
TARGET NUMBER: 4
FILE DATE: 07/20/2007
FILE TIME: 23:03

X CENTROID:	0.424
Y CENTROID:	0.071
POA TO CENTROID:	0.430
HORZ SPREAD:	1.799
VERT SPREAD:	1.286
GROUP SPREAD:	1.799
MIN RADIUS:	0.057
MAX RADIUS:	0.942
MEAN RADIUS:	0.595
# IN 1 IN DIAMETER:	3
# IN 2 IN DIAMETER:	10
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	0.005	0.555
2:	1.360	0.184
3:	0.897	-0.728
4:	0.304	-0.481
5:	0.424	0.014
6:	-0.090	-0.317
7:	-0.439	0.148
8:	0.653	0.558
9:	0.406	0.420
10:	0.725	0.357



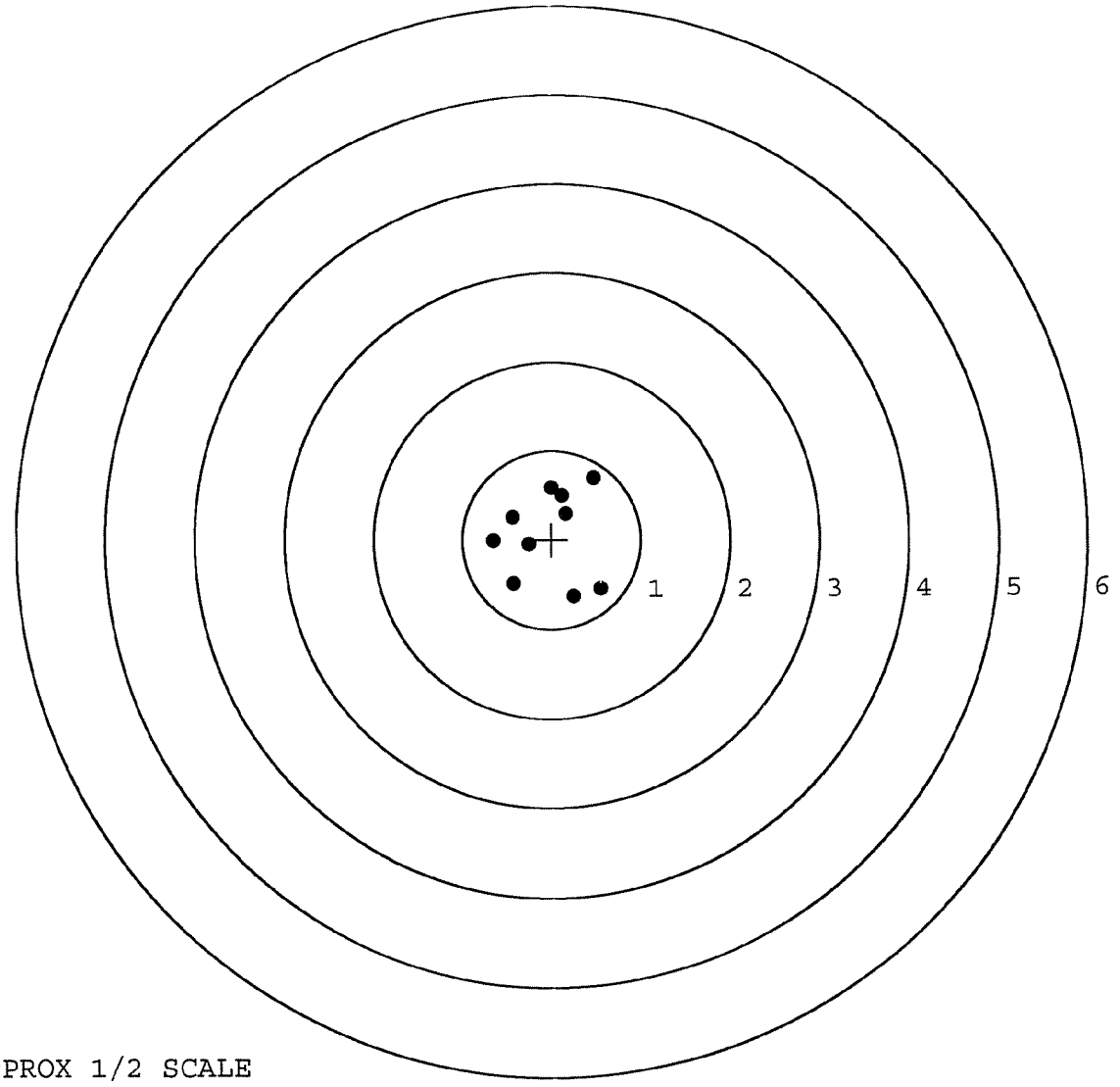
TARGET APPROX 1/2 SCALE

BARBER - M24 0171245

SERIAL NUMBER: G6645310.__0
TARGET NUMBER: 5
FILE DATE: 07/20/2007
FILE TIME: 23:03

X CENTROID:	-0.023
Y CENTROID:	0.058
POA TO CENTROID:	0.062
HORZ SPREAD:	1.206
VERT SPREAD:	1.326
GROUP SPREAD:	1.323
MIN RADIUS:	0.262
MAX RADIUS:	0.835
MEAN RADIUS:	0.571
# IN 1 IN DIAMETER:	4
# IN 2 IN DIAMETER:	10
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	0.474	0.689
2:	0.000	0.586
3:	0.160	0.289
4:	-0.435	0.256
5:	-0.659	-0.008
6:	-0.259	-0.055
7:	-0.430	-0.488
8:	0.247	-0.637
9:	0.547	-0.552
10:	0.125	0.500



TARGET APPROX 1/2 SCALE

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

R & E NUMBER 00130078

SERIAL NUMBER ~~G6391094~~ "NEW" G6645310

LOG-IN DATE 6-6-07

OPERATION #	OPERATION NAME		DATE	INITIAL
500	DIS-ASSEMBLE GUN		7-11-07	A.D.D.
505	RE-BARREL		7-13-07	RTL
560	ASSEMBLE		7-16-07	TRW
600	PROOF		7-16-07	TRW
605	CHECK HEADSPACE		7-16-07	TRW
610	DIS-ASSEMBLE GUN		7-16-07	RTL
612	MAGNAFLUX	MAGNA-FLUX NR OPERATOR [illegible]	7/17/07	[illegible]
510	DRILL AND TAP		7-16-07	TRW
615	ROLLMARK CALIBER		7-16-07	CW
618	ROTO-BLAST		7-17-07	LB
620	APPLY COATINGS		7-18-07	CM
625	FINAL ASSEMBLY		7-20-07	RTL
640	FUNCTION TEST AND	(PASS) FAIL	7-20-07	TRW
650	TARGET	(PASS) FAIL	7-20-07	TRW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION	7-20-07	[illegible]
670	FINAL INSPECTION			
	A) HEADSPACE	PASS FAIL	7-24-07	DA
	B) TRIGGER PULL (+/- .5 LBS, MIN 2.50 LBS, MAX 4.0 LBS)	2.89 2.91 2.89 2.86 2.89	7-23-07	DA
680	F) SAFETY ON FORCE (2 LBS MIN, 10 LBS MAX)	5 4.5 4.5	7-23-07	DA
	G) SAFETY OFF FORCE (2 LBS MIN)	2 2 2	7-23-07	DA
	I) FIRING PIN INDENT (.020)	.023 .023 .022	7-23-07	DA
690	PACK		7-25-07	DA

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: RE00085921
Verify Repair
Serial: C6225529 Model: M24 SWS Center Fire Caliber: 7.62 NATO
Repairman:
Status: Closed 10/4/2004 10:52:17 AM

Address Information

Customer:	Received From	Return To:	Received From
Name:	TRANSPORTATION OFFICER	TRANSPORTATION OFFICER	
Address 1:	SENSITIVE STORAGE	SENSITIVE STORAGE	
Address 2:	BLDG 9660 PO Box:	BLDG 9660 PO Box:	
City:	FORT LEWIS	FORT LEWIS	
State:	WA Zip Code: 98433 Country: US	State: WA Zip Code: 98433 Country: US	

FFL:

Contact / Condition | Problems | Estimate | History / Status | Shipping / Billing

Contact Information

Phone: 253 967 5516
Fax:
Email:
Comments:

Received Condition

Fair
Condition Notes:
CSR Notes:

Accessories Received

Code	Desc	Qty
A007	With Studs	3
A017	Scope Bases	3

Repair Search | Refresh | Close

negletj | 10/4/2004 | 11:26 AM | CAPS | NUM | INS | SCRL

start | 3 | 4

RTL

G639/098 (New)

C6225529

Serial Number: C6225529

Model: M24 SWS

RE00085921

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

R & E NUMBER	8592(		
SERIAL NUMBER	~~C622~~5529	C639 1094 (New)	
LOG-IN DATE	10-4-04		
INSPECT AND VERIFY:			
OPERATION #	OPERATION NAME	DATE	INITIAL
550	DIS-ASSEMBLE GUN	10-4-04	RTL
560 A	RE-BARREL	10-5-04	
B	DRILL AND TAP	10-19-04	TRW
575	ASSEMBLE	10-15-04	RTL
600	PROOF	10-18-04	RTL
605	CHECK HEADSPACE	10-18-04	RTL
610	DIS-ASSEMBLE GUN	10-19-04	RTL
612	MAGNAFLUX		
615	ROLLMARK CALIBER	10/20/04	JB
618	ROTO-BLAST	10-22-04	LB
620	APPLY COATINGS	10/26/04	HP
625 A	FINAL ASSEMBLY	11-3-04	RTL
B	TRIGGER PULL TEST		
C	SAFETY "ON" FORCE		
D	SAFETY "OFF" FORCE		
E	FIRING PIN INDENT		
640	TARGET	11-8-04	TRW
655	FINAL INSPECT	11-8-04	RTL
660	PACK	11-9-04	DA
		SHIP DATE	
	QAR INSPECTION DATE		

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFOMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6391094.__0
FILE DATE AND TIME: 11/08/2004 07:53

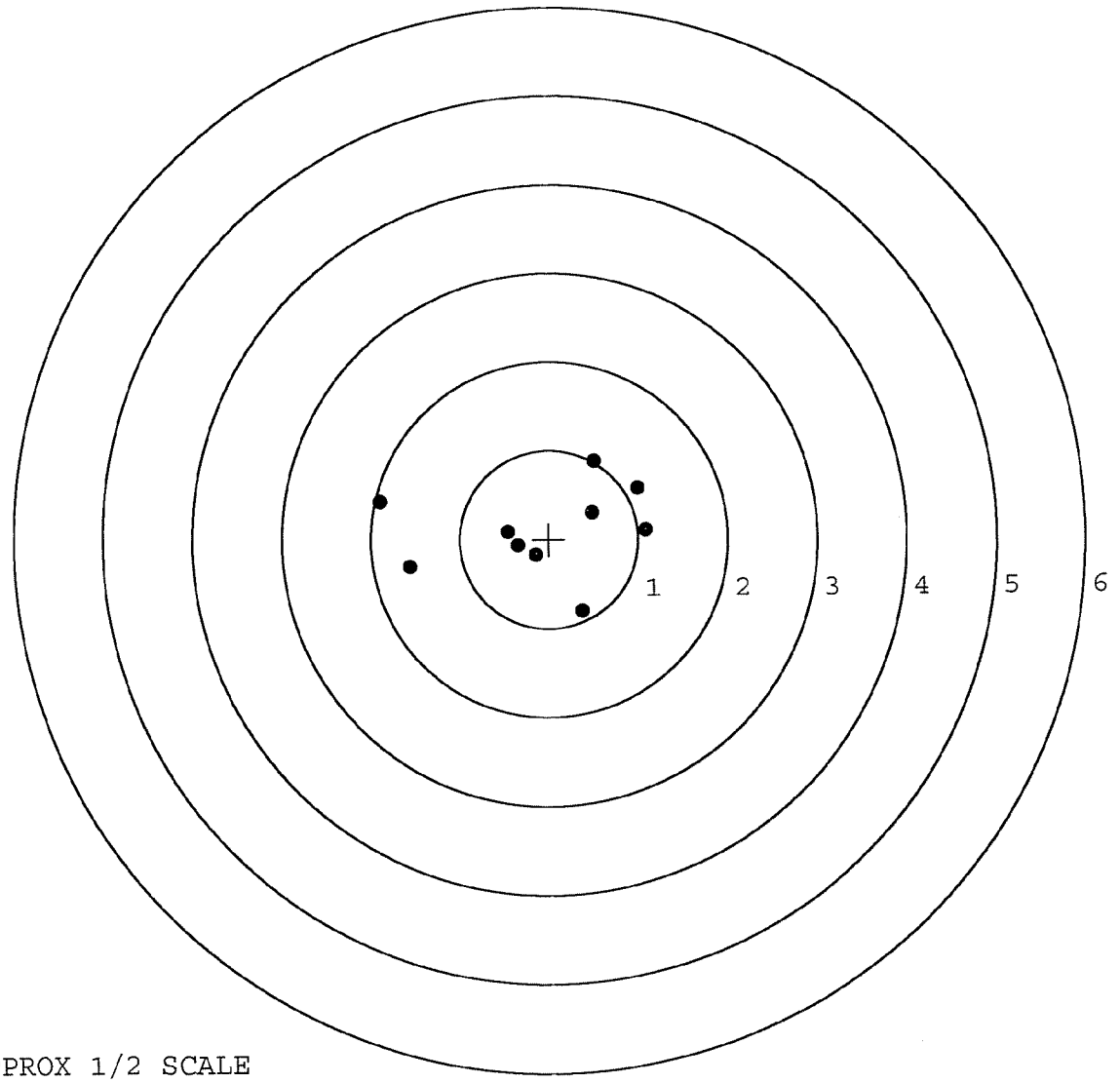
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.045
The Average Y Centroid of the Five Target Set:	-0.013
The Average Point of Impact of the Five Target Set:	0.047
The Average Mean Radius of the Five Target Set:	0.789
The Distance from POA to Centroid Target #1:	0.141
The Distance from Centroid Target #2 to Centroid Target #1:	0.111
The Distance from Centroid Target #3 to Centroid Target #1:	0.304
The Distance from Centroid Target #4 to Centroid Target #1:	0.243
The Distance from Centroid Target #5 to Centroid Target #1:	0.142

SERIAL NUMBER: G6391094.__0
TARGET NUMBER: 1
FILE DATE: 11/08/2004
FILE TIME: 07:53

X CENTROID:	-0.097
Y CENTROID:	0.102
POA TO CENTROID:	0.141
HORZ SPREAD:	2.978
VERT SPREAD:	1.687
GROUP SPREAD:	2.997
MIN RADIUS:	0.283
MAX RADIUS:	1.830
MEAN RADIUS:	0.931
# IN 1 IN DIAMETER:	3
# IN 2 IN DIAMETER:	5
# in 3 IN DIAMETER:	8

POINT#	X	Y
1:	0.374	-0.810
2:	1.082	0.103
3:	0.995	0.572
4:	0.488	0.295
5:	0.519	0.877
6:	-0.152	-0.175
7:	-0.353	-0.068
8:	-0.462	0.089
9:	-1.565	-0.299
10:	-1.896	0.438

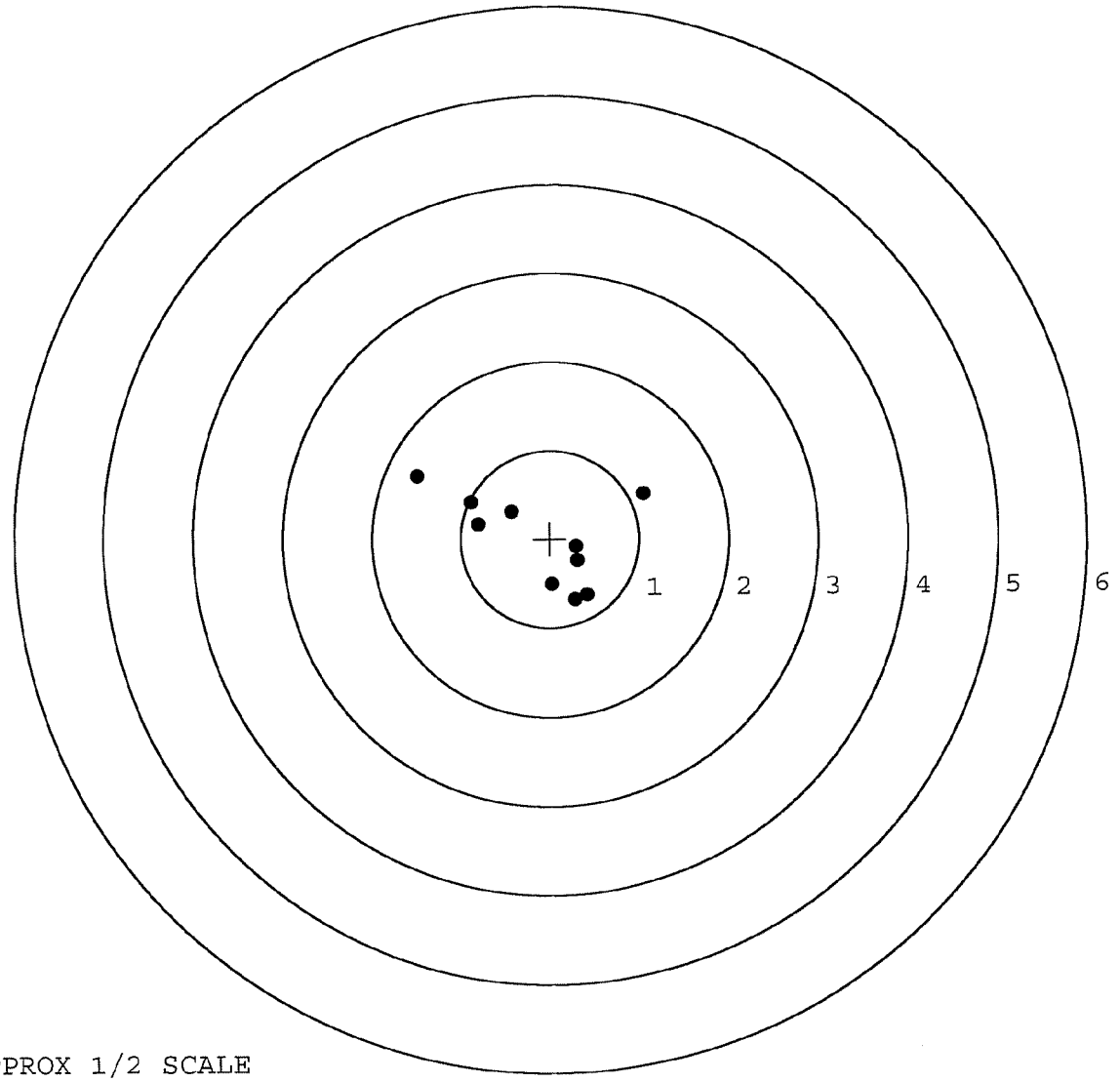


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6391094.__0
TARGET NUMBER: 2
FILE DATE: 11/08/2004
FILE TIME: 07:53

X CENTROID:	-0.122
Y CENTROID:	-0.006
POA TO CENTROID:	0.123
HORZ SPREAD:	2.534
VERT SPREAD:	1.416
GROUP SPREAD:	2.543
MIN RADIUS:	0.430
MAX RADIUS:	1.548
MEAN RADIUS:	0.793
# IN 1 IN DIAMETER:	2
# IN 2 IN DIAMETER:	8
# in 3 IN DIAMETER:	9

POINT#	X	Y
1:	1.047	0.506
2:	-1.487	0.724
3:	-0.881	0.425
4:	-0.802	0.167
5:	-0.433	0.310
6:	0.299	-0.092
7:	0.313	-0.253
8:	0.417	-0.639
9:	0.021	-0.515
10:	0.282	-0.692

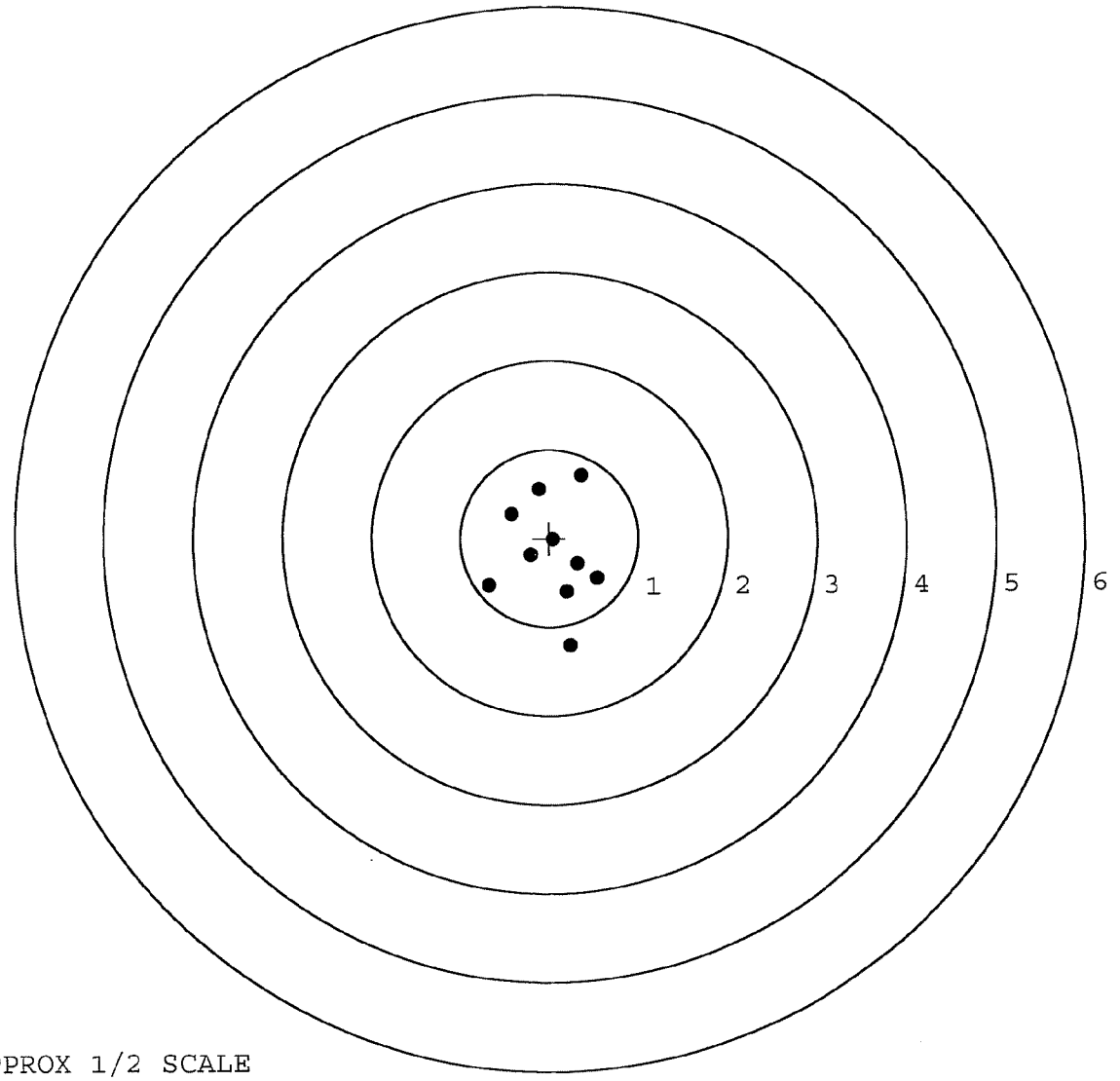


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6391094.__0
TARGET NUMBER: 3
FILE DATE: 11/08/2004
FILE TIME: 07:53

X CENTROID:	0.026
Y CENTROID:	-0.176
POA TO CENTROID:	0.178
HORZ SPREAD:	1.223
VERT SPREAD:	1.926
GROUP SPREAD:	1.931
MIN RADIUS:	0.162
MAX RADIUS:	1.060
MEAN RADIUS:	0.596
# IN 1 IN DIAMETER:	4
# IN 2 IN DIAMETER:	9
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	0.238	-1.215
2:	-0.685	-0.531
3:	-0.426	0.278
4:	-0.115	0.557
5:	0.370	0.711
6:	0.044	-0.015
7:	-0.220	-0.190
8:	0.316	-0.293
9:	0.538	-0.455
10:	0.197	-0.607

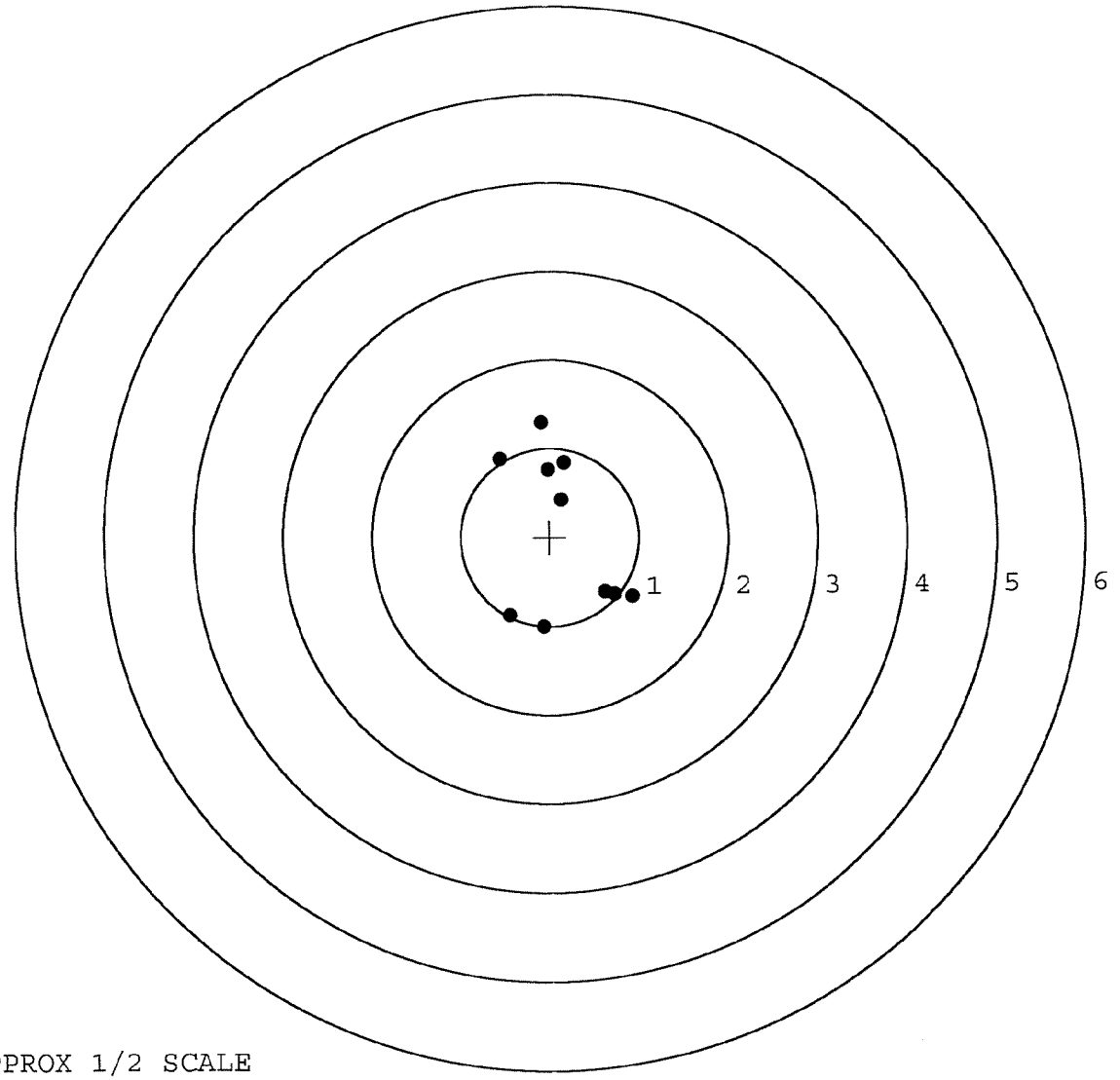


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6391094.__0
TARGET NUMBER: 4
FILE DATE: 11/08/2004
FILE TIME: 07:53

X CENTROID:	0.137
Y CENTROID:	0.036
POA TO CENTROID:	0.142
HORZ SPREAD:	1.479
VERT SPREAD:	2.304
GROUP SPREAD:	2.304
MIN RADIUS:	0.381
MAX RADIUS:	1.275
MEAN RADIUS:	0.920
# IN 1 IN DIAMETER:	1
# IN 2 IN DIAMETER:	5
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	0.922	-0.672
2:	0.614	-0.614
3:	-0.075	-1.013
4:	-0.458	-0.874
5:	-0.087	1.291
6:	-0.557	0.882
7:	0.167	0.835
8:	0.140	0.417
9:	-0.019	0.756
10:	0.722	-0.645

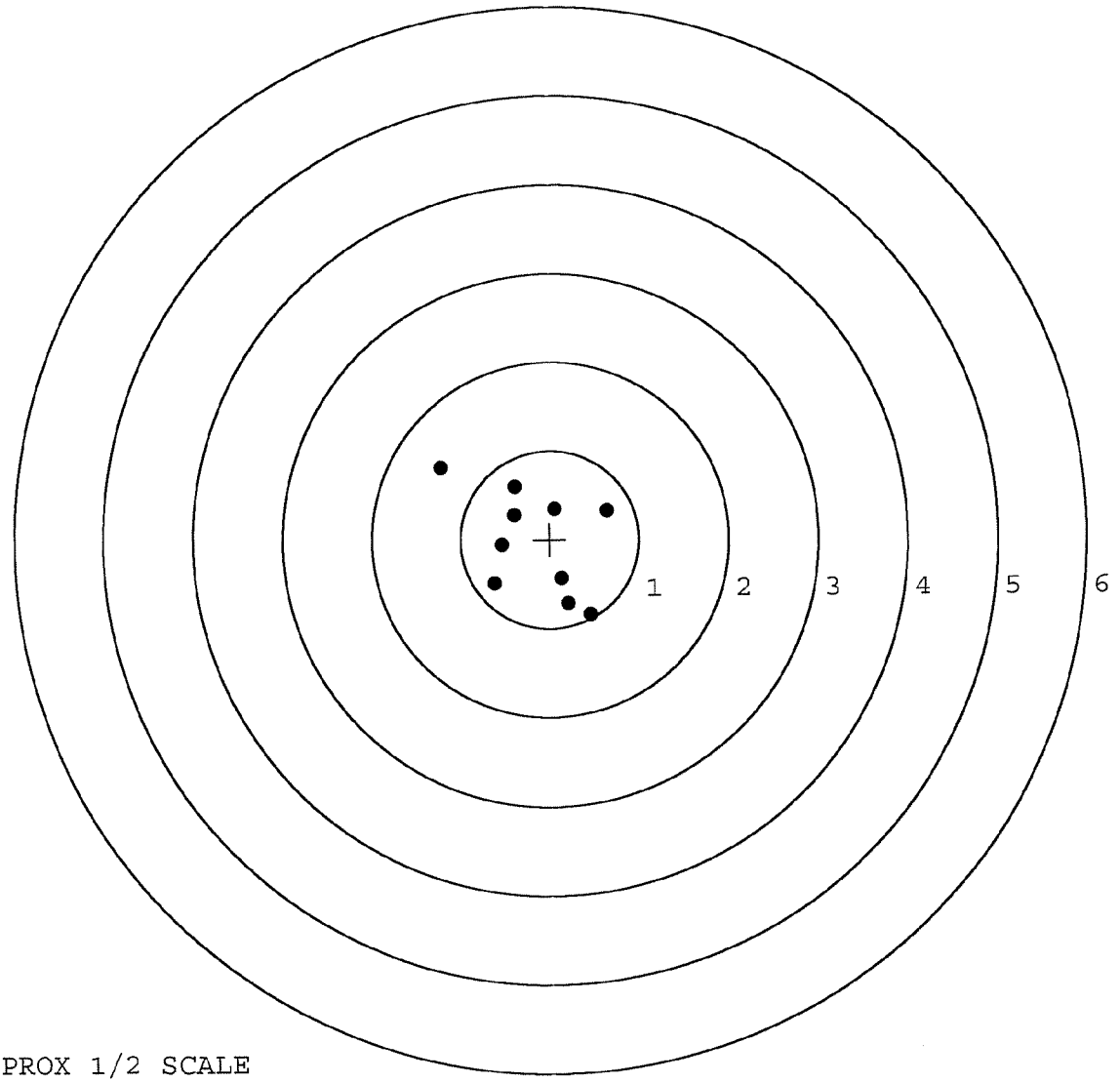


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6391094.__0
TARGET NUMBER: 5
FILE DATE: 11/08/2004
FILE TIME: 07:53

X CENTROID:	-0.167
Y CENTROID:	-0.022
POA TO CENTROID:	0.168
HORZ SPREAD:	1.864
VERT SPREAD:	1.672
GROUP SPREAD:	2.369
MIN RADIUS:	0.372
MAX RADIUS:	1.351
MEAN RADIUS:	0.707
# IN 1 IN DIAMETER:	3
# IN 2 IN DIAMETER:	8
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	0.454	-0.852
2:	0.210	-0.721
3:	0.139	-0.444
4:	0.640	0.325
5:	0.057	0.341
6:	-0.390	0.598
7:	-0.394	0.275
8:	-0.536	-0.065
9:	-0.623	-0.494
10:	-1.224	0.820



TARGET APPROX 1/2 SCALE

BARBER - M24 0171255

RECEIVING AND ESTIMATING REPORT

COMMENTS: M-24 SNIPER

ORDER: R 94-24908

INITIAL	CUSTOMER ORDER NO.
FFS	

DATE RECEIVED	DATE OPENED	DATE CODE	SERIAL NUMBER	NEW SERIAL NUMBER	MODEL AND GRADE
08/29/94	08/30/94	DI 9-88	C6225529		700 7.62 NATO

ACCESSORIES: W/STUDS SCOPE MNTS SCOPE BASE

FROM:

DEPT OF THE ARMY
B CO ARMS
2/75 RANGER BATTALION
FT LEWIS WA 98433

SHIP TO:

DEPT OF THE ARMY
B CO ARMS
2/75 RANGER BATTALION
FT LEWIS WA 98433

CUST NO:062072 C.O.D.

ACCOUNT NUMBER	ACCOUNT NUMBER N/C	WRITE ☐	PROM. DATE	ESTIMATED	VIA
					R768625192

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: New Barrel

PARTS

Barrel 96003
Mag Spring 15677

COMMENTS

Repainder Coat Trigger Guard Assy Front & Rear Sight Bases Rezind Scope Base, Rings & Swivel Studs

REPAIRMAN	PROOF	CLEAN	TEST	TARGET	PATTERN
RW	✓	✓	✓	✓	
GALLERY TESTER	**DATE**	**DATE**	**DATE**	**DATE**	**DATE**
RW	9/1/94	9/13/94	9/13/94	9/13/94	

OFFICE COPY

RD6925 REV. 1/94

PACKING LIST

PACKED BY: Mr. Ray Fuller WG-10 Br. Armorer

1. NO. BOXES: 1

2a. REQUISITION NO.: EY295

2b. ORDER NO.:

3. END ITEM: 7.62mm M24 Sniper Weapons System (SWS)

4. DATE: 26 July 1994

5. PAGE 1 OF 1 PAGES

BOX NO. (a)	CONTENTS - STOCK NUMBER AND NOMENCLATURE (b)	UNIT OF ISSUE (c)	QUANTITIES REQUIRED: UNIT DIVISION (d)	QUANTITIES REQUIRED: INTERMEDIATE (e)	QUANTITIES REQUIRED: TOTAL (f)
	7.62mm M24 Sniper Weapon System (SWS) Serial No 00225529	Ea			1
	NSN: 1005-01-240-8136				
	Date: 91 Optic Scope Ring Mounts Packed				

REGISTERED MAIL R 748 625 192

6. I CERTIFICATE THAT THE LISTED HEREON ARE WITHIN THE SPECIFIED BOUNDS

TYPED NAME AND TITLE: Ray Fuller WG-10 Br. Armorer

SIGNATURE: Ray Fuller

DD FORM 1750

MAINTENANCE REQUEST

For use of this form, see DA PAM 738-750; the proponent agency is DCSLOG

PAGE NO 1 | NO. OF PAGES | REQUIREMENTS CONTROL SYMBOL CSGLD - 1047(R1)

SECTION I - EQUIPMENT DATA

CONTROL NUMBER	WORK ORDER NO	WESDC	ORG. PD	PD AUTHENTICATION
	94245		02	[signature]

	1A. ORGANIZATION	B. LOCATION	C. UNIT IDENT CODE
☒ Work Request ☐ MWO ☐ Warranty Claim	Bn Armr HHC 2/75 RGR RGT	Fort Lewis Wa	WH3MA9

2. SERIAL NO	3. NOUN NOMENCLATURE	4. LINE NO	5. MODEL	6. NATIONAL STOCK NUMBER
C6225529	M24 SWS		M24	1005-01-240-2136

7A. MAINTENANCE ACTIVITY	B. LEVEL	8. UTILIZATION CODE	9A. MOSR ITEM	9B. EIC	9C. PACING ITEM	10. HOURS	11. MILES	12. ROUNDS	13. STARTS
Remington Arms Co. [illegible]									

14. FAILURE DETECTED DURING (Select one - use ✓ or X)

☐ A Bch. Main. ☒ C Test ☐ E Storage ☐ D Flight ☐ B Handling ☐ G Normal Op ☐ F Inspection ☐ H Other

15. FIRST INDICATION OF TROUBLE (Select one - use ✓ or X)

☐ 065 Inoperative ☐ 255 Overheating ☐ 290 Out of Adjustment ☐ 608 Noisy ☐ 382 Low Performance ☒ Other

16A. DESCRIBE DEFICIENCIES OR SYMPTOMS ON THE BASIS OF COMPLETE CHECKOUT AND DIAGNOSTIC PROCEDURE IN EQUIPMENT TM (Do not prescribe repairs)

This weapon has fired 13,000 rds. During Barrel Test Fire at 200/300 yds groups were not exceeding the criteria of 2.6" at 200 & 3.8" at 300 yds (5-10 shot groups). The criteria was provided by Mr. Jim Glass ARDCE DSN 880-7071

B. REMARKS

Request Re Barreling and Complete Weapon Reconditioning.

SECTION II - WORK ACCOMPLISHED

17A. REPAIR ORGANIZATION-ACTIVITY	C. UNIT IDENT CODE	18. TYPE ORGANIZATION-ACTIVITY ACCOMPLISHING WORK (Select one - use ✓ or X)	19. AMS ACCT CODE
B. LOCATION		☐ 1 TDA ☐ 2 TO ☐ 3 Contractor	

20A. ACT CODE	B. FAILURE CODE	C. COMPONENT/PART NOUN, SYC, OR MWO NO. (1) CB CODE	(2) REF DESIGN	(3) MFR. CODE	D. MANHOURS (Hrs. & Tenths)	E. NATIONAL STOCK NUMBER	F. PART SOURCE CODE	G. QTY	H. PARTS COST
					.				$
					.				$
					.				$
					.				$
					.				$
					.				$
					.				$
					.				$
					.				$

I. TOTAL MANHOURS | J. TOTAL MANHOURS COST $ | K. TOTAL PARTS COST $

21. DELAY (Select One) ☐ 1 Parts ☐ 2 Manpower ☐ 3 Facilities ☐ 4 Funds ☐ 5 Tools | 22. | Date Transmitted

23. SUBMITTED BY	24. RECEIVED BY	25. WORK STARTED BY	26. INSPECTED BY	27. ACCEPTED BY	28. DISPOSITION (Select One)
Ray Fallon					☐ A To User ☐ D Evacuated
JULIAN DATE 4235	JULIAN DATE	JULIAN DATE	JULIAN DATE	JULIAN DATE	☐ B To Stock ☐ E Condemnation ☐ C Salvaged

DA FORM 2407, AUG 88 EDITION OF MAY 81 MAY BE USED NMP COPY 2

SWS/Repair

Final Inspection

Sn: C6225529 | Date Rec'd: 8/29/94 | Date Ret'd:

Auditor: MW

Item:

Barrel Assy.
- ✓ Barrel
- ✓ Receiver
- ✓ Front Sight Block
- ✓ Rear Sight Block
- ✓ Screws
- ✓ Finish

Item:

Stock Assy.
- ✓ Stock
- ✓ Sling Swivel Studs
- ✓ Adjustable Butt Plate
- ✓ Lock Nuts
- ✓ Barrel Clearance
- ✓ Color/Finish

Scope Assy.
- ___ Scope
- ✓ Scope Rings
- ✓ Mounting Screws
- ✓ Mounting Base
- ✓ Screws
- ✓ Finish
- ✓ Looseness
- ___ Clarity

Systems Case
- ___ Scope Case
- ___ Iron Sights
- ___ Deployment Kit

Trigger
- ✓ Safety Operation
- ✓ Set
- ___

Misc.
- ___ DD-250
- ___ Bar Code
- ___ Packaging

Comments: _____

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6225529
15 Sep 1994

CENTROIDAL DISTANCES

0	TO	1	.288979
1	TO	2	.304532
1	TO	3	.630849
1	TO	4	.293956
1	TO	5	.214853

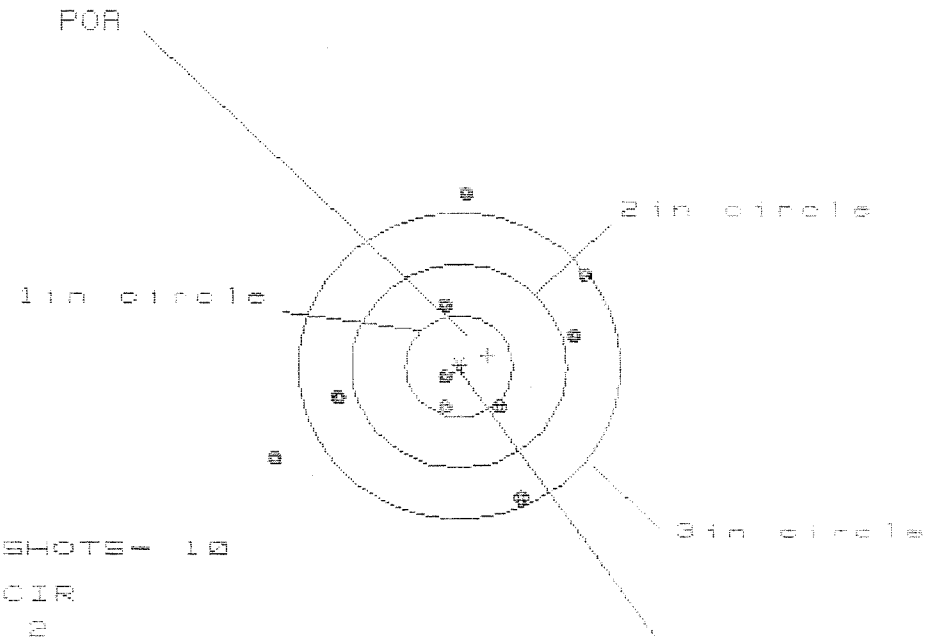
<----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0438
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0456
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0632302

THE AMR FOR THIS RIFLE IS: 1.005

15 Sep 1994 FILE:/PATTERNING/CENTERFIRE_PATT/08225503

CENTERFIRE PATTERNS # 1

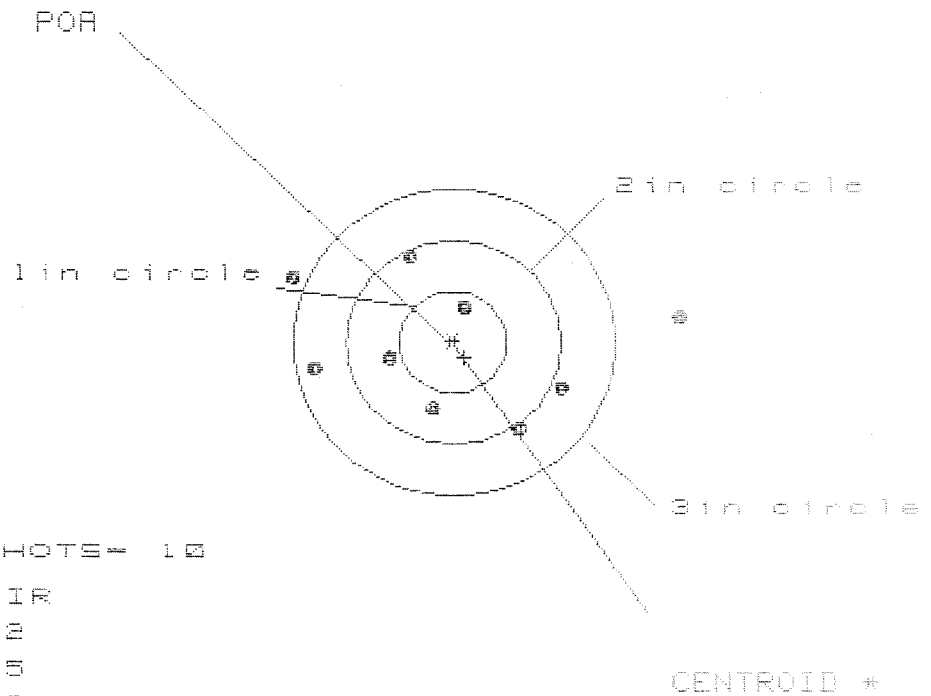


# OF SHOTS= 10
# IN CIR
1in = 2
2in = 4
3in = 8
HS= 2.953
VS= 3.022
GS= 3.454

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.215	1.022	1.013
MINIMUM X	:	-1.738	-1.336	-1.345
MAXIMUM Y	:	1.691	1.587	.955
MINIMUM Y	:	-1.331	-1.435	-1.236
CENTROID X	:	-.270	-.077	-.068
CENTROID Y	:	-.103	.001	-.198
POA TO CENTROID in.	:	.289	.077	.209
MIN RADIUS	:	.178	.397	.349
MEAN RADIUS	:	1.075	.986	.879
MAX RADIUS	:	1.972	1.589	1.392
HORIZONTAL SPREAD	:	2.953	2.358	2.358
VERTICAL SPREAD	:	3.022	3.022	2.191
EXTREME SPREAD	:	3.454	3.051	2.622
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	

15 Sep 1994 FILE:/PATTERNING/CENTERFIRE_PATT/08225520

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

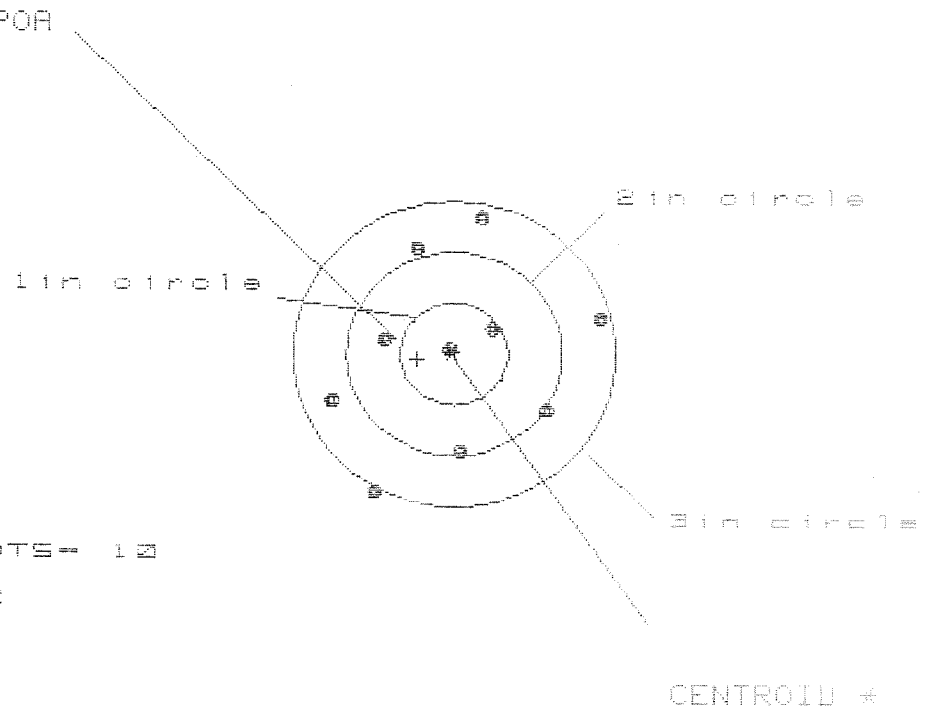
# IN CIR
1in = 2
2in = 5
3in = 8

HS= 3.668
VS= 1.668
GS= 3.689

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.141	1.273	1.112
MINIMUM X	:	-1.527	-1.289	-1.263
MAXIMUM Y	:	.832	.858	.940
MINIMUM Y	:	-.836	-.810	-.728
CENTROID X	:	-.102	-.340	-.179
CENTROID Y	:	.151	.125	.043
POA TO CENTROID in.	:	.182	.362	.184
MIN RADIUS	:	.351	.355	.476
MEAN RADIUS	:	1.026	.885	.809
MAX RADIUS	:	2.154	1.444	1.271
HORIZONTAL SPREAD	:	3.668	2.562	2.375
VERTICAL SPREAD	:	1.668	1.668	1.668
EXTREME SPREAD	:	3.689	2.797	2.388
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

15 Sep 1994 FILE:/PATTERNING/CENTERFIRE_PATT/08225529

CENTERFIRE PATTERNS # 9



OF SHOTS= 10

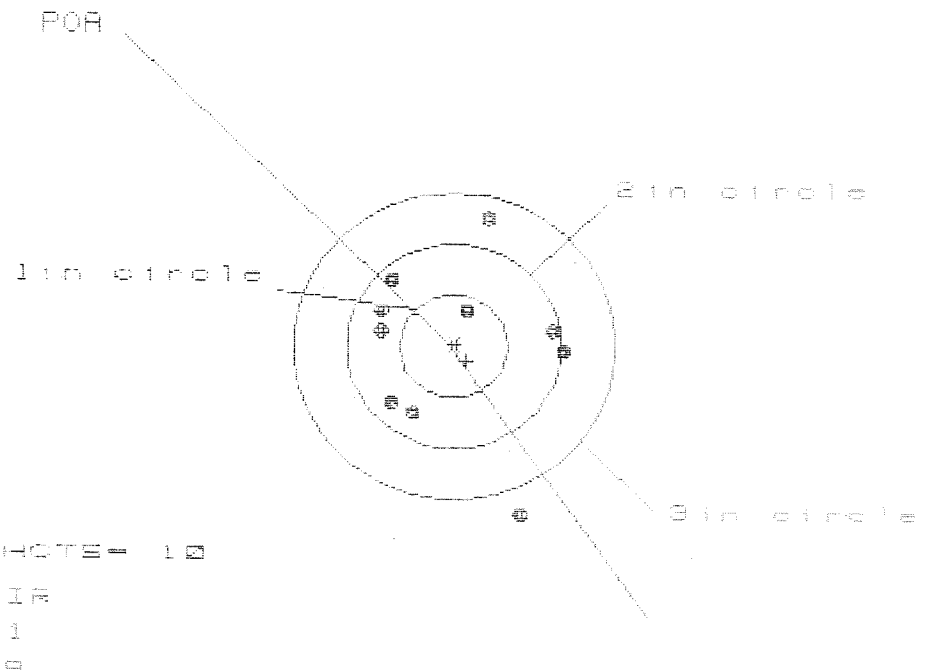
# IN CIR
1in = 2
2in = 5
3in = 9

HS= 2.571
VS= 2.704
GS= 2.895

PATTERN #	:	9		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.385	1.302	.934
MINIMUM X	:	-1.186	-1.269	-1.106
MAXIMUM Y	:	1.394	1.249	1.272
MINIMUM Y	:	-1.310	-1.071	-1.048
CENTROID X	:	.341	.424	.201
CENTROID Y	:	.054	.199	.176
POA TO CENTROID in.	:	.345	.469	.315
MIN RADIUS	:	.100	.146	.047
MEAN RADIUS	:	.986	.918	.852
MAX RADIUS	:	1.507	1.424	1.324
HORIZONTAL SPREAD	:	2.571	2.571	2.040
VERTICAL SPREAD	:	2.704	2.320	2.320
EXTREME SPREAD	:	2.895	2.702	2.401
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

15 Sep 1994 FILE:/PATTERNING/CENTERFIRE_PATT/08225523

CENTERFIRE PATTERNS # 4



OF SHOTS= 10

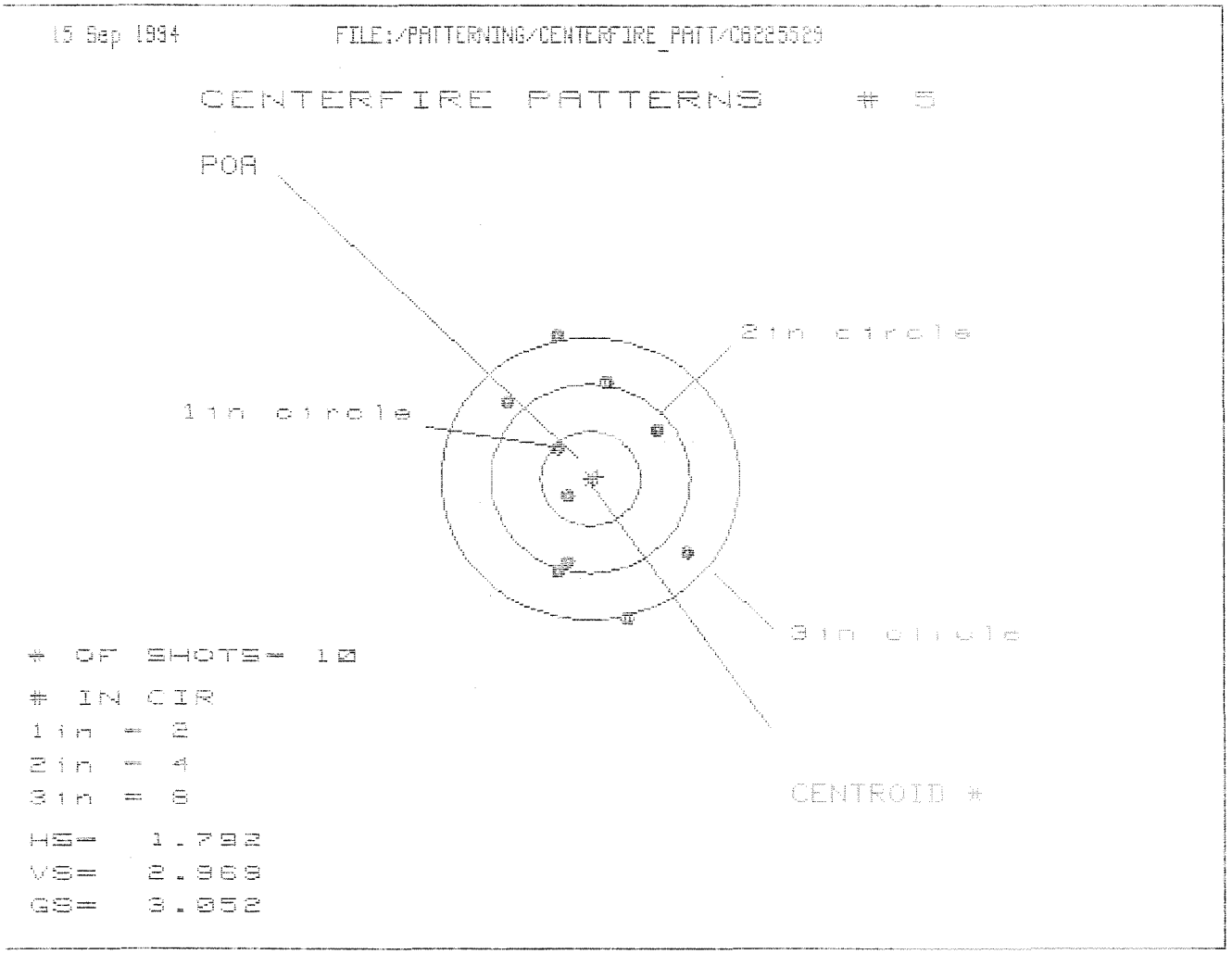
IN CIR
1 in = 1
2 in = 8
3 in = 9

HS= 1.696
VS= 2.988
GS= 3.453

PATTERN # : [redacted]

SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.975	1.046	1.095
MINIMUM X	:	-.721	-.650	-.681
MAXIMUM Y	:	1.259	1.073	.681
MINIMUM Y	:	-1.677	-.843	-.739
CENTROID X	:	.117	-.188	-.237
CENTROID Y	:	.148	.304	.280
POA TO CENTROID in.	:	.189	.383	.310
MIN RADIUS	:	.414	.296	.428
MEAN RADIUS	:	.934	.805	.759
MAX RADIUS	:	1.793	1.142	1.104
HORIZONTAL SPREAD	:	1.696	1.696	1.696
VERTICAL SPREAD	:	2.936	1.910	1.290
EXTREME SPREAD	:	2.953	2.055	1.716

NUMBER IN ONE INCH CIRCLE = 1
NUMBER IN TWO INCH CIRCLE = 8
NUMBER IN THREE INCH CIRCLE = 9



PATTERN #	:	[redacted]		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.981	.942	.983
MINIMUM X	:	-.811	-.850	-.809
MAXIMUM Y	:	1.491	1.178	1.014
MINIMUM Y	:	-1.478	-1.313	-.957
CENTROID X	:	-.071	-.032	-.073
CENTROID Y	:	-.022	-.187	-.023
POA TO CENTROID in.	:	.074	.190	.076
MIN RADIUS	:	.303	.258	.301
MEAN RADIUS	:	1.005	.937	.874
MAX RADIUS	:	1.530	1.352	1.286
HORIZONTAL SPREAD	:	1.792	1.792	1.792
VERTICAL SPREAD	:	2.969	2.491	1.971
EXTREME SPREAD	:	3.052	2.619	2.411
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	4		
NUMBER IN THREE INCH CIRCLE	=	8		

M-24

CONTRACT # DAAA21-87-C-0086 New Barrel

GUN SERIAL # C6225529

OP. #	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and Stock		9/1/94	RW
600	Proof		9/1/94	RW
607	Check Headspace		9/1/94	RW
610	Dis-assemble Gun		9/1/94	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		9/12/94	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		9/12/94	RW
	C) Inspect Ejector Hole for Chamfer		9/12/94	RW
	D) Oil Firing Pin Ass'y		9/12/94	RW
	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		9/13	WB
	A) Time		9/13	WB
	B) Malfunctions		9/13	WB
	C) Pierced Primers		9/13	WB
	D) Optical Clearity of Scope		9/13	WB
645	Inspect for Live Ammo		9/13/94	RW
655	Final Inspection A) Headspace		9/14/94	RW
	B) Trigger Pull	2.43 2.45 2.49 2.51 2.51	9/14/94	RW
	C) Function		9/14/94	RW
660	Pack			

Scope # 1769

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6225529

OP.#	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and stock		8 9/88	FB
600	Proof		9 7/88	RW
607	Check Headspace		9 7/88	RW
610	Dis-assemble gun		9 7/88	RW
612	Magnaflux Barrel Action		9-14-88	RJE
	Magnaflux Bolt		9-14-88	RJE
615	Rollmark Caliber			
617	Drill & Tap Sight Holes			
618	Polish Barrel			
620	Apply Coatings (Barrel Action)		10-31-88	TJA
	Apply Coatings (Bolt)		10-31-88	TJA
625	Final Assembly A)Clean inside of Bolt Assembly		11/2/88	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		11/2/88	RW
	C) Inspect Ejector Hole for Chamfer		11/2/88	RW

OVER

OP.#		READINGS	DATE	INITIAL
625 cont.	D) Oil Firing Pin Ass'y		11/2/88	RW
	E) Adjust Trigger Pull to Min. Setting and Stake		2 NOV 88	GS
	F) Safety on Force	5.5 | 5 | 5	2 NOV 88	G.S.
	G) Safety off Force	4 | 4 | 3	2 NOV 88	GS
	H) Trigger Pull Test & Retainabilty		2 NOV 88	GS.
	I) Firing Pin Indent	.0205 | .0205 | .021	2 NOV 88	GS.
	J) Assemble Stock		11/7/88	RW
	K) Assemble Swivel Studs		29 NOV 88	GS
	L) Attach Front & Rear Sight Assemblies		11/7/88	RW
	M) Iron Sight Alignment		11/7/88	RW
	N) Detach Front & Rear Sights & place in numbered container		11/7/88	RW
	0) Attach Scope to Rifle		11/8/88	RW
	P) Detach & Attach Scope 20 times		8 NOV 88	G.S.
640	Gallery Target & Test	59 R 92 L	11-10-88	A.C.
	A) Optical Clearity of Scope	OK	11-10-88	A.C.
645	Inspect for Live Ammo	NONE	11-10-88	A.C.
655	Final Inspection A) Headspace		29 NOV 88	GS
	B) Trigger Pull		29 NOV 88	GS
	C) Function		29 NOV 88	GS
660	Pack		15 Dec 88	GS

SWS TRIGGER PULL TEST

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

SERIAL NO. C6225529

DATE 1/20/88

TESTER J.A. [illegible]

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.42	2.27	2.33	2.48	MIN. SETTING,
PULL #2	2.35	2.31	2.31	2.42	NO AVG. OF 5
PULL #3	2.31	2.32	2.32	2.41	READINGS ACCEPT-
PULL #4	2.30	2.27	2.31	2.40	ABLE LESS THAN 2#
PULL #5	2.33	2.30	2.31	2.30	
TOTAL	11.71	11.47	11.58	12.01	
AVG.	2.342	2.294	2.316	2.414	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.21	3.07		
PULL #2	3.17	3.18		
PULL #3	3.01	3.19		
PULL #4	3.17	3.19		
PULL #5	3.18	3.22		
TOTAL	15.74	15.85		
AVG.	3.148	3.17		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.23	4.19		4.26
PULL #2	4.23	4.20		4.35
PULL #3	4.23	4.22		4.37
PULL #4	4.22	4.21		4.34
PULL #5	4.22	4.22		4.35
TOTAL	21.13	21.04		21.67
AVG.	4.226	4.208		4.334

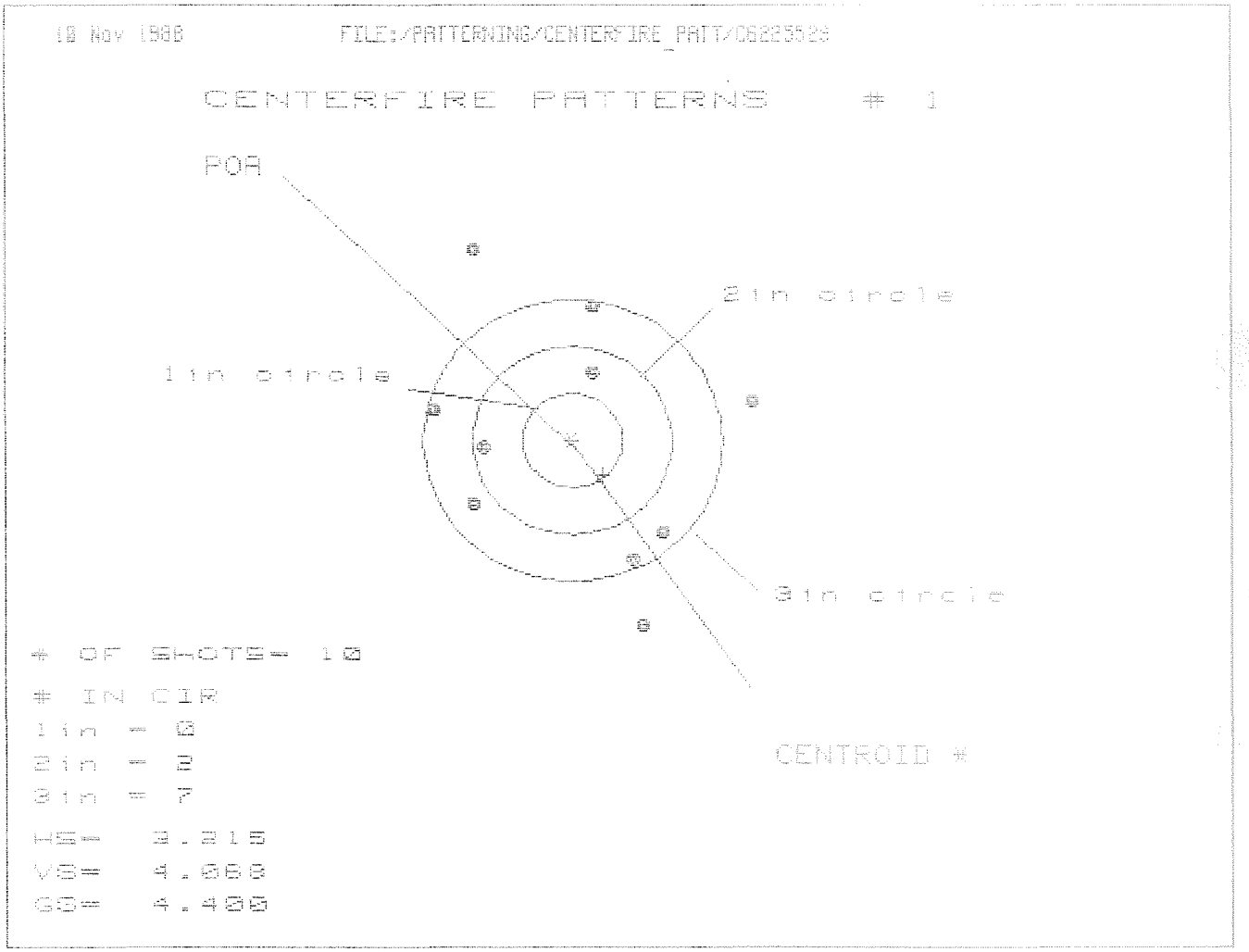
CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6225529

CENTROIDAL DISTANCES

0	TO	1	.477326
1	TO	2	.520739
1	TO	3	.550281
1	TO	4	1.42123
1	TO	5	.661852

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0056
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .8132
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .8153227

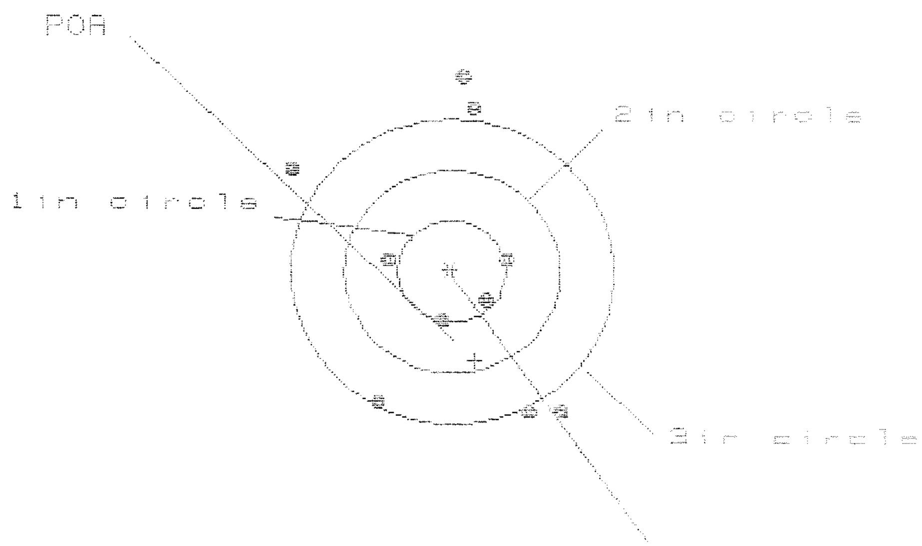
THE AMR FOR THIS RIFLE IS: 1.078



PATTERN #	:	[redacted]		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.853	1.743	1.816
MINIMUM X	:	-1.362	-1.472	-1.399
MAXIMUM Y	:	2.079	1.670	1.450
MINIMUM Y	:	-1.989	-1.758	-1.264
CENTROID X	:	-.304	-.194	-.267
CENTROID Y	:	.368	.137	.357
POA TO CENTROID in.	:	.478	.238	.446
MIN RADIUS	:	.796	1.012	.800
MEAN RADIUS	:	1.488	1.388	1.311
MAX RADIUS	:	2.302	1.871	1.878
HORIZONTAL SPREAD	:	3.215	3.215	3.215
VERTICAL SPREAD	:	4.068	3.428	2.714
EXTREME SPREAD	:	4.400	3.468	3.217
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		2	
NUMBER IN THREE INCH CIRCLE	=		7	

18 Nov 1988 FILE:/PATTERNING/CENTERFIRE_PATT/C6225529

CENTERFIRE PATTERNS # 2



CENTROID *

OF SHOTS= 10

IN CIR
1 in = 3
2 in = 4
3 in = 5

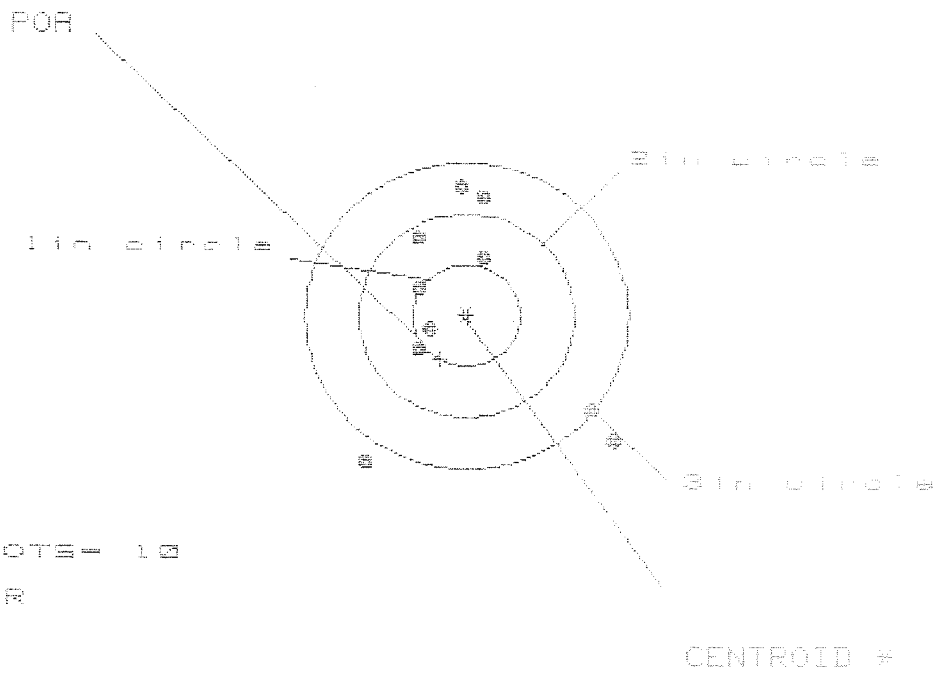
HS= 2.530
VS= 3.290
GS= 3.496

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.049	1.060	.877
MINIMUM X	:	-1.481	-1.470	-.820
MAXIMUM Y	:	1.915	1.831	1.990
MINIMUM Y	:	-1.375	-1.163	-1.004
CENTROID X	:	-.209	-.220	-.037
CENTROID Y	:	.880	.668	.509
POA TO CENTROID in.	:	.905	.703	.511
MIN RADIUS	:	.408	.282	.183
MEAN RADIUS	:	1.211	1.096	.955
MAX RADIUS	:	1.917	1.941	1.990
HORIZONTAL SPREAD	:	2.530	2.530	1.697
VERTICAL SPREAD	:	3.290	2.994	2.994
EXTREME SPREAD	:	3.496	3.496	3.097

NUMBER IN ONE INCH CIRCLE = 3
NUMBER IN TWO INCH CIRCLE = 4
NUMBER IN THREE INCH CIRCLE = 5

10 Nov 1988 FILE:/PATTERNING/CENTERFIRE_PATT/C8825529

CENTERFIRE PATTERNS # 3



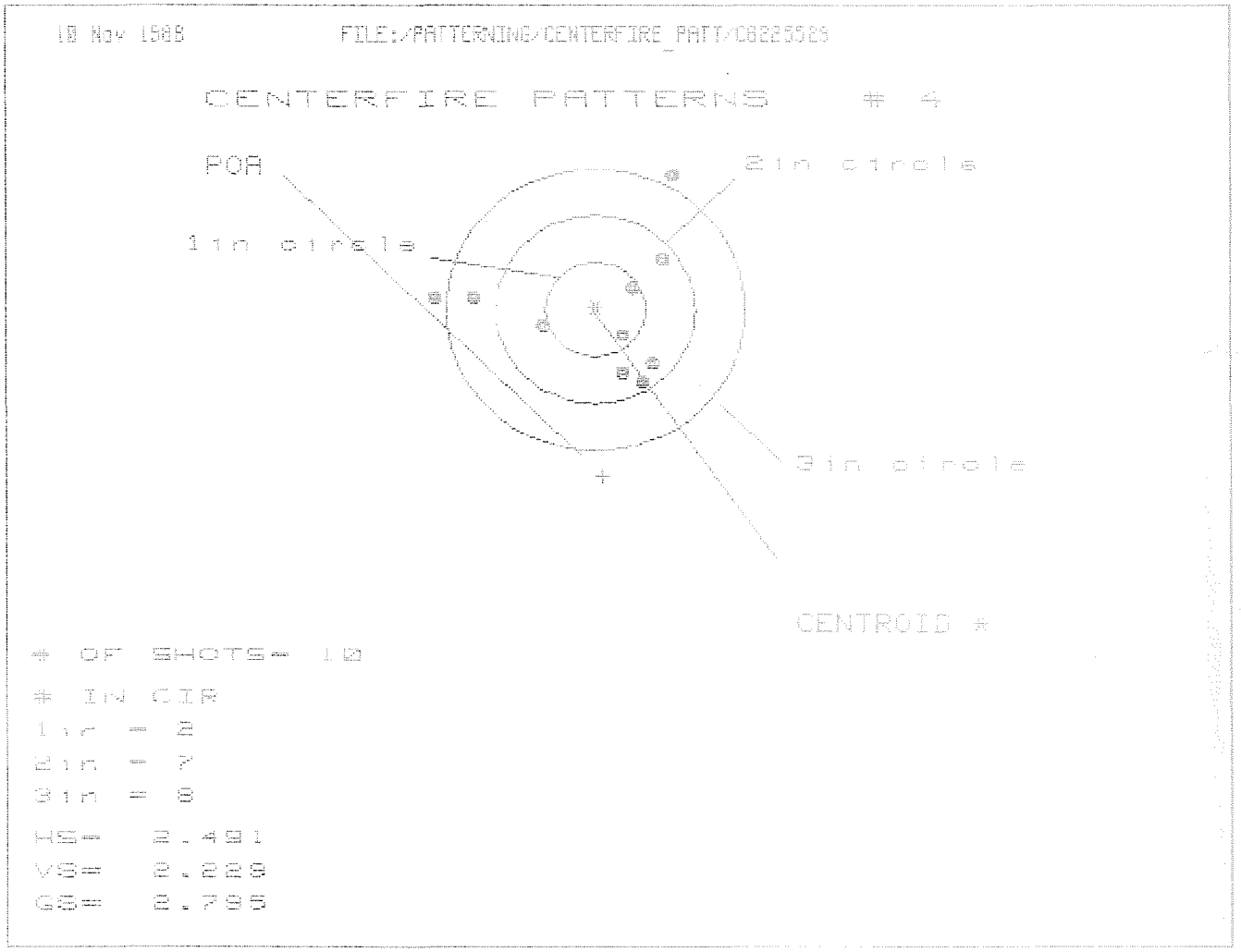
OF SHOTS= 10

# IN CIR
1in = 1
2in = 5
3in = 7

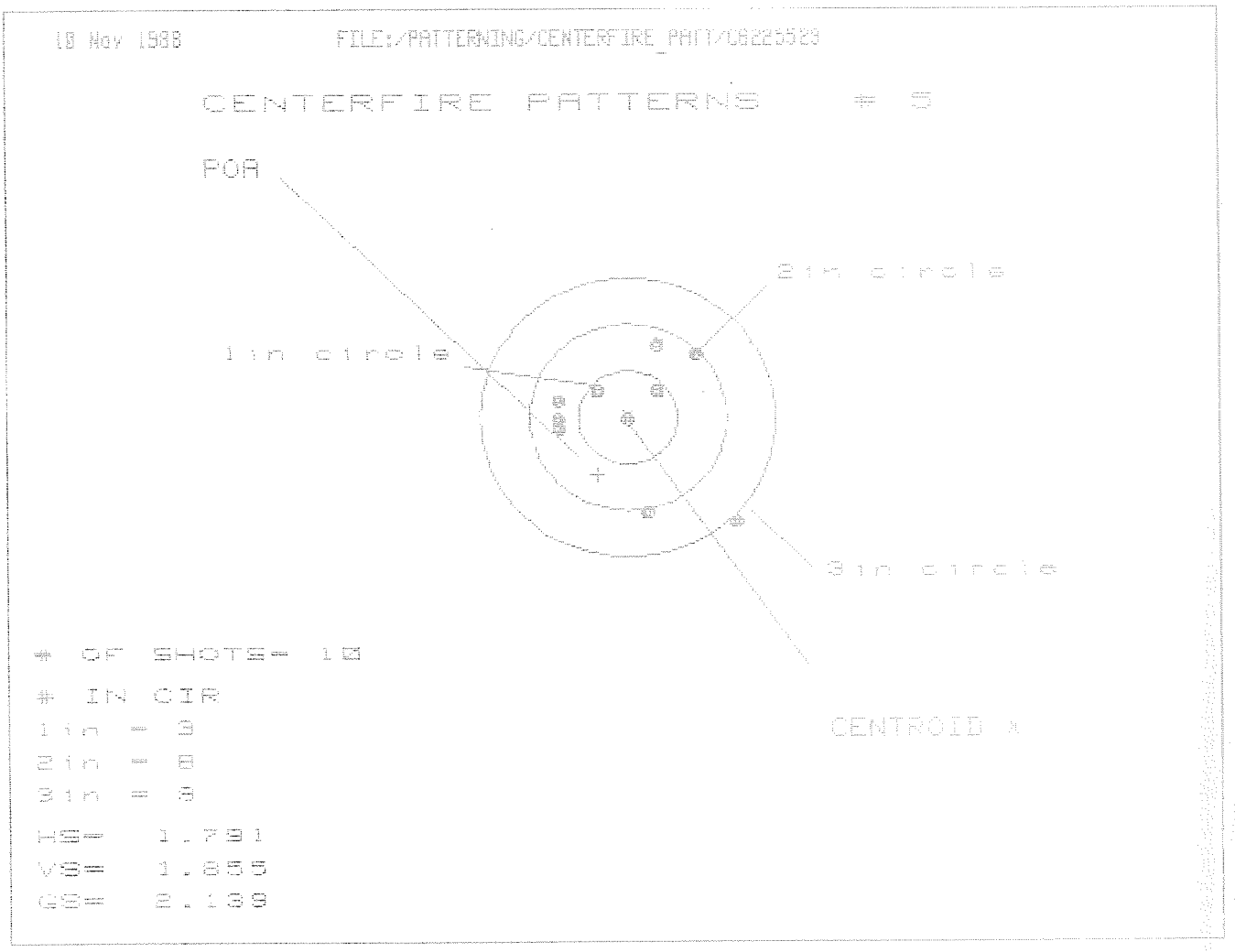
HS= 2.297
VS= 2.665
GS= 2.892

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.333	1.344	1.242
MINIMUM X	:	-.963	-.815	-.443
MAXIMUM Y	:	1.270	1.132	.940
MINIMUM Y	:	-1.395	-1.533	-1.256
CENTROID X	:	.243	.095	.197
CENTROID Y	:	.428	.566	.758
POA TO CENTROID in.	:	.492	.574	.783
MIN RADIUS	:	.366	.312	.317
MEAN RADIUS	:	1.045	.902	.778
MAX RADIUS	:	1.826	1.737	1.766
HORIZONTAL SPREAD	:	2.297	2.159	1.685
VERTICAL SPREAD	:	2.665	2.665	2.196
EXTREME SPREAD	:	2.892	2.805	2.544

NUMBER IN ONE INCH CIRCLE = 1
NUMBER IN TWO INCH CIRCLE = 5
NUMBER IN THREE INCH CIRCLE = 7



PATTERN #	:	[redacted]		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.815	.629	.569
MINIMUM X	:	-1.676	-1.386	-1.308
MAXIMUM Y	:	1.440	1.460	.708
MINIMUM Y	:	-.789	-.769	-.587
CENTROID X	:	-.071	.115	.037
CENTROID Y	:	1.770	1.750	1.568
POA TO CENTROID in.	:	1.771	1.754	1.568
MIN RADIUS	:	.408	.292	.198
MEAN RADIUS	:	.913	.788	.658
MAX RADIUS	:	1.685	1.589	1.344
HORIZONTAL SPREAD	:	2.491	2.015	1.877
VERTICAL SPREAD	:	2.229	2.229	1.295
EXTREME SPREAD	:	2.795	2.417	1.915
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		8	



PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	6
MAXIMUM X	:	1.055	.774	.909
MINIMUM X	:	-.736	-.619	-.584
MAXIMUM Y	:	.781	.662	.520
MINIMUM Y	:	-1.074	-1.132	-.345
CENTROID X	:	.308	.191	.156
CENTROID Y	:	.620	.739	.881
POA TO CENTROID in.	:	.692	.763	.894
MIN RADIUS	:	.060	.197	.114
MEAN RADIUS	:	.732	.619	.539
MAX RADIUS	:	1.505	1.166	.933
HORIZONTAL SPREAD	:	1.791	1.393	1.393
VERTICAL SPREAD	:	1.855	1.794	.865
EXTREME SPREAD	:	2.139	1.809	1.611
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	