

06348861

MODEL 700TM M24

Model **S4S** TM

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

Remington

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: RE00141256

Serial: C6348861 Model M24 SWS Center Fire
Caliber: 7.62 NATO Produced: 12/13/1989

Repairman:

Status: Closed 2/5/2008 10:17:43 AM

Verify Repair

Address Information

Customer:

☒ Received From

Return To:

☐ Received From

Name: DODAAC: W91L3M

DODAAC: W91L3M

Address 1: WOODA FSB BAGRAM AFLD

WOODA FSB BAGRAM AFLD

Address 2: SMALL ARMS SUPPORT

PO Box:

SMALL ARMS SUPPORT

PO Box:

City: BAGRAM APO

BAGRAM APO

State: AF

Zip Code: 09354

Country: AE

State: AF

Zip Code: 09354

Country: AE

FFL:

Contact / Condition

Problems

Estimate

History / Status

Shipping / Billing

Contact Information

Phone: NN

Fax:

Email:

Comments:

Received Condition

Fair

Condition

Notes:

CSR

Notes:

Accessories Received

Code	Desc	Qty
A007	With Stud	3
A010	Hard Case	1
A017	Scope Base	1
A026	Scope	1
A045	Bi Pod	1
A057	Fit and Rear Sgt Base	1
D000	SCOPE CASE	1

Repair Search

Refresh

Close

nagletj

2/7/2008

4:20 PM

NUM

Serial Number:

C6348861

Model: M24 SWS



RE00141256

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

R & E NUMBER 00141256

SERIAL NUMBER C6348861

LOG-IN DATE 2-5-08

OPERATION #	OPERATION NAME	DATE	INITIAL
500	DIS-ASSEMBLE GUN	2-15-08	RTZ
505	RE-BARREL	2-20-08	RTZ
560	ASSEMBLE	2-20-08	RTZ
600	PROOF	2-20-08	TRW
605	CHECK HEADSPACE	2-20-08	TRW
610	DIS-ASSEMBLE GUN		
612	MAGNAFLUX	2-21-08	cmw
510	DRILL AND TAP	2-21-08	Fn
615	ROLLMARK CALIBER	2-21-08	CW
618	ROTO-BLAST	2-22-08	DG
620	APPLY COATINGS	2-26-08	cm
625	FINAL ASSEMBLY	2-28-08	RTZ
640	FUNCTION TEST AND	2-28-08	TRW
650	TARGET	2-28-08	TRW
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
670	FINAL INSPECTION	2-28-08	RP
	A) HEADSPACE	3-3-08	DA
	B) TRIGGER PULL	3-3-08	DA
		2.88 2.90 2.84 2.90 2.85 3.30 8	
680	F) SAFETY ON FORCE	6.2 6.2 5.5 3-3-08	DA
	G) SAFETY OFF FORCE	4.25 4.25 4.25 3-3-08	DA
	I) FIRING PIN INDENT	.023 .023 .023 3-3-08	DA
690	PACK	17/5/08	Fn

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6348861.___0
FILE DATE AND TIME: 03/03/2008 09:38

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.061
The Average Y Centroid of the Five Target Set:	-0.057
The Average Point of Impact of the Five Target Set:	0.084
The Average Mean Radius of the Five Target Set:	0.751
The Distance from POA to Centroid Target #1:	0.391
The Distance from Centroid Target #2 to Centroid Target #1:	0.329
The Distance from Centroid Target #3 to Centroid Target #1:	0.513
The Distance from Centroid Target #4 to Centroid Target #1:	0.351
The Distance from Centroid Target #5 to Centroid Target #1:	0.390

SERIAL NUMBER: C6348861. __0

TARGET NUMBER: 1

FILE DATE: 03/03/2008

FILE TIME: 09:38

POINT#	X	Y
1:	2.418	-0.919
2:	1.155	0.544
3:	1.084	0.862
4:	0.363	0.344
5:	0.606	-0.342
6:	0.062	-0.808
7:	-0.877	-0.934
8:	-0.578	-0.706
9:	-0.719	-0.516
10:	-0.856	-0.389

X CENTROID: 0.266

Y CENTROID: -0.286

POA TO CENTROID: 0.391

HORZ SPREAD: 3.295

VERT SPREAD: 1.796

GROUP SPREAD: 3.317

MIN RADIUS: 0.345

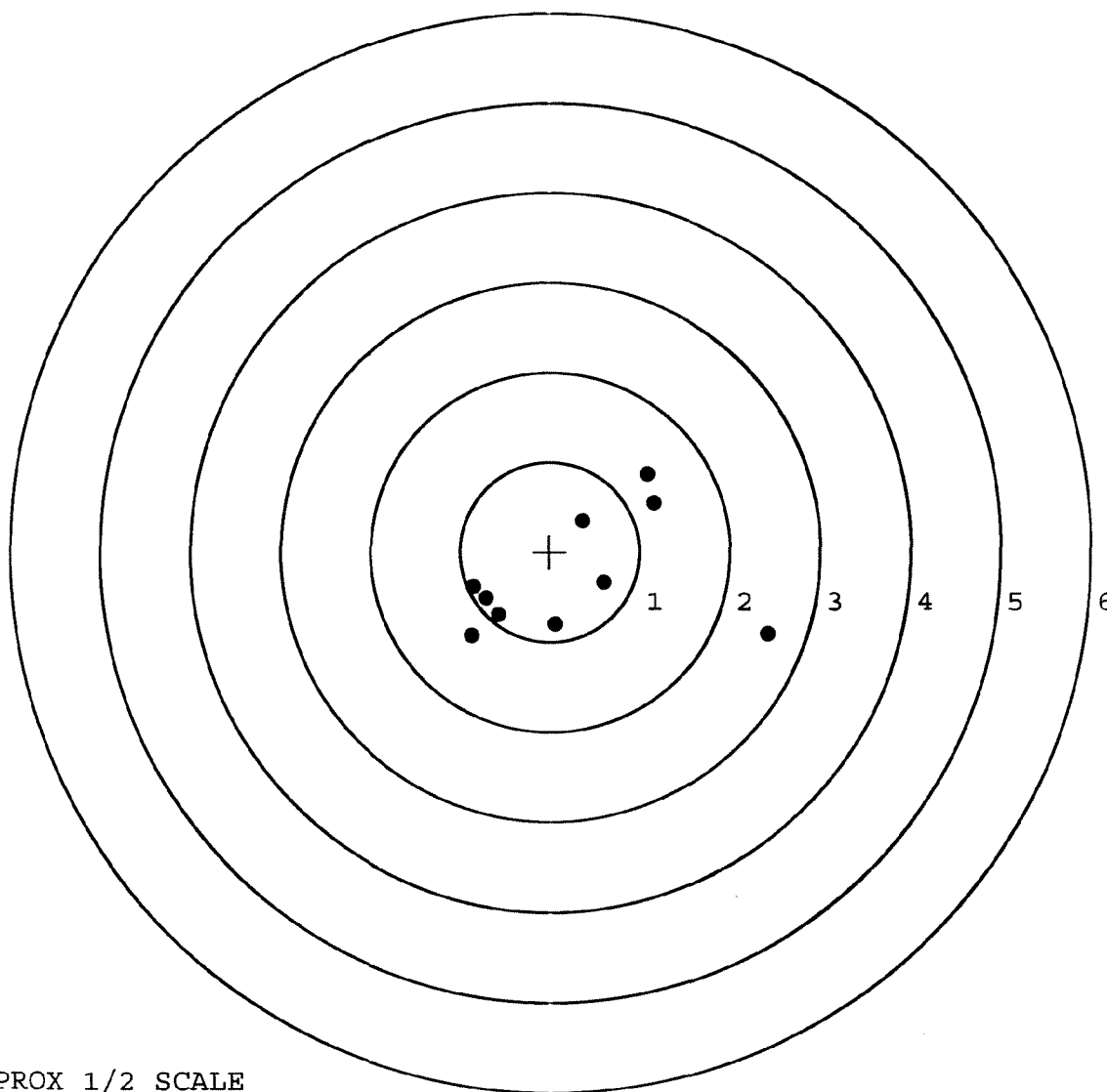
MAX RADIUS: 2.243

MEAN RADIUS: 1.081

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 4

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6348861. __0

TARGET NUMBER: 2

FILE DATE: 03/03/2008

FILE TIME: 09:38

POINT#	X	Y
1:	1.290	0.293
2:	0.717	0.267
3:	0.331	0.414
4:	0.057	0.639
5:	-0.796	0.288
6:	0.182	-0.075
7:	0.234	-0.562
8:	-0.088	-0.293
9:	-0.324	-0.728
10:	-0.713	-0.330

X CENTROID: 0.089

Y CENTROID: -0.009

POA TO CENTROID: 0.089

HORZ SPREAD: 2.086

VERT SPREAD: 1.367

GROUP SPREAD: 2.098

MIN RADIUS: 0.114

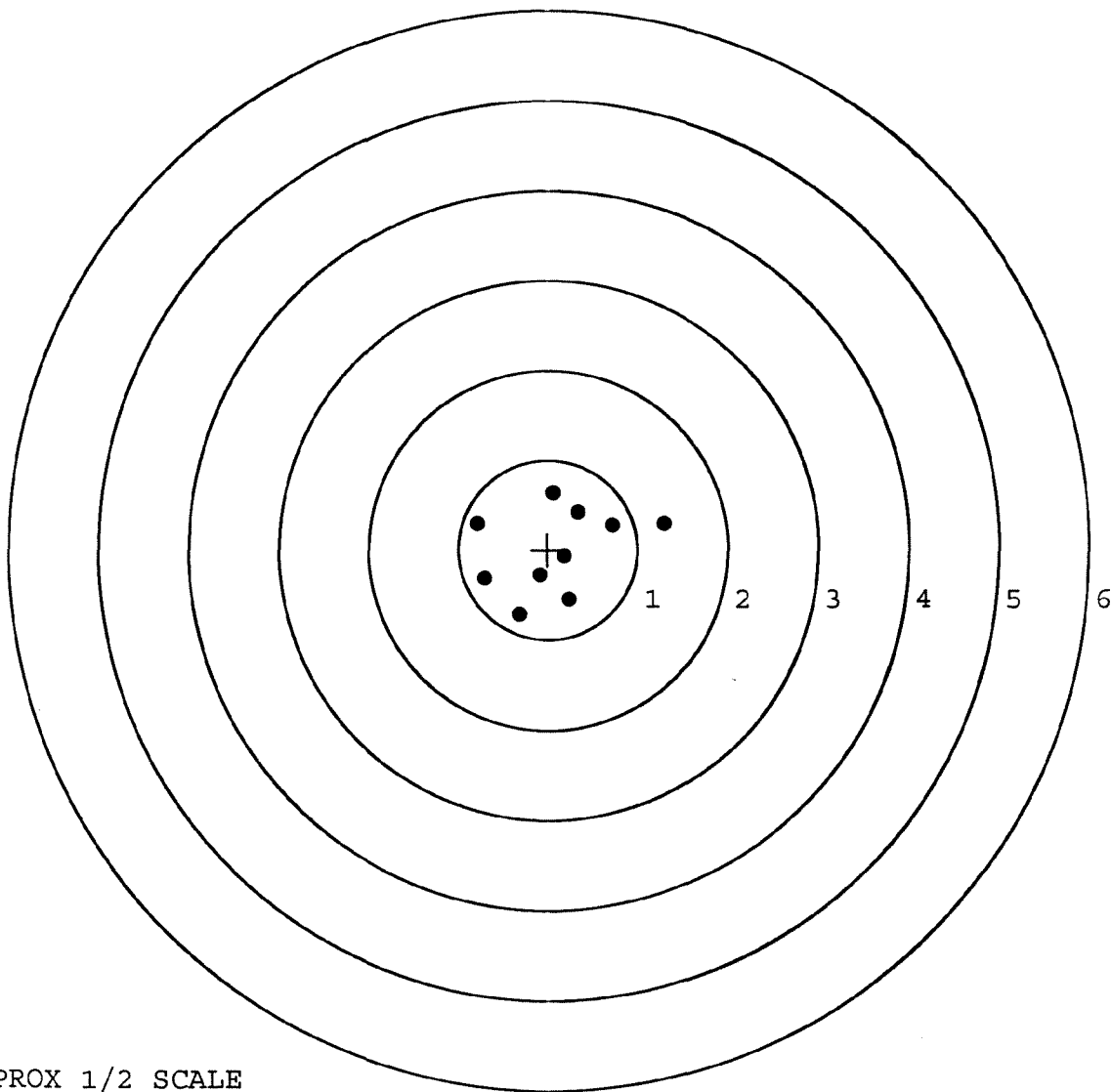
MAX RADIUS: 1.238

MEAN RADIUS: 0.671

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6348861. __0

TARGET NUMBER: 3

FILE DATE: 03/03/2008

FILE TIME: 09:38

POINT#	X	Y
1:	0.790	0.492
2:	0.491	0.182
3:	0.367	0.073
4:	0.225	-0.374
5:	-0.109	-0.745
6:	-0.008	0.028
7:	-0.194	0.181
8:	-0.478	0.361
9:	-0.594	0.070
10:	-1.114	0.813

X CENTROID: -0.062

Y CENTROID: 0.108

POA TO CENTROID: 0.125

HORZ SPREAD: 1.904

VERT SPREAD: 1.558

GROUP SPREAD: 1.931

MIN RADIUS: 0.097

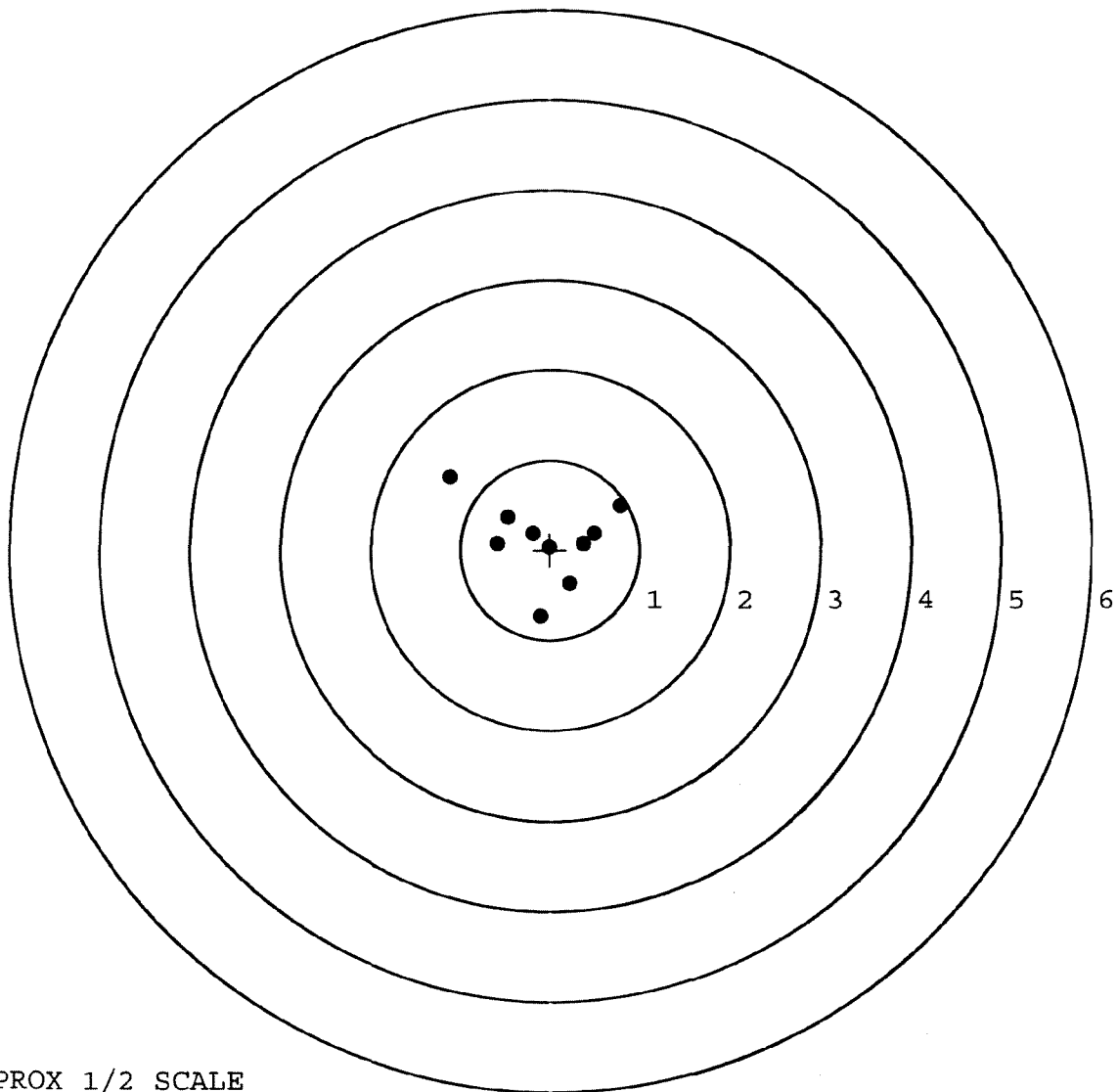
MAX RADIUS: 1.266

MEAN RADIUS: 0.587

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6348861. __0

TARGET NUMBER: 4

FILE DATE: 03/03/2008

FILE TIME: 09:38

POINT#	X	Y
1:	0.869	0.022
2:	0.183	0.721
3:	-1.395	0.869
4:	-0.555	-0.191
5:	-0.403	-0.390
6:	-0.071	-0.919
7:	0.363	-0.591
8:	0.017	-0.474
9:	0.307	-0.338
10:	0.102	-0.223

X CENTROID: -0.058

Y CENTROID: -0.151

POA TO CENTROID: 0.162

HORZ SPREAD: 2.264

VERT SPREAD: 1.788

GROUP SPREAD: 2.417

MIN RADIUS: 0.176

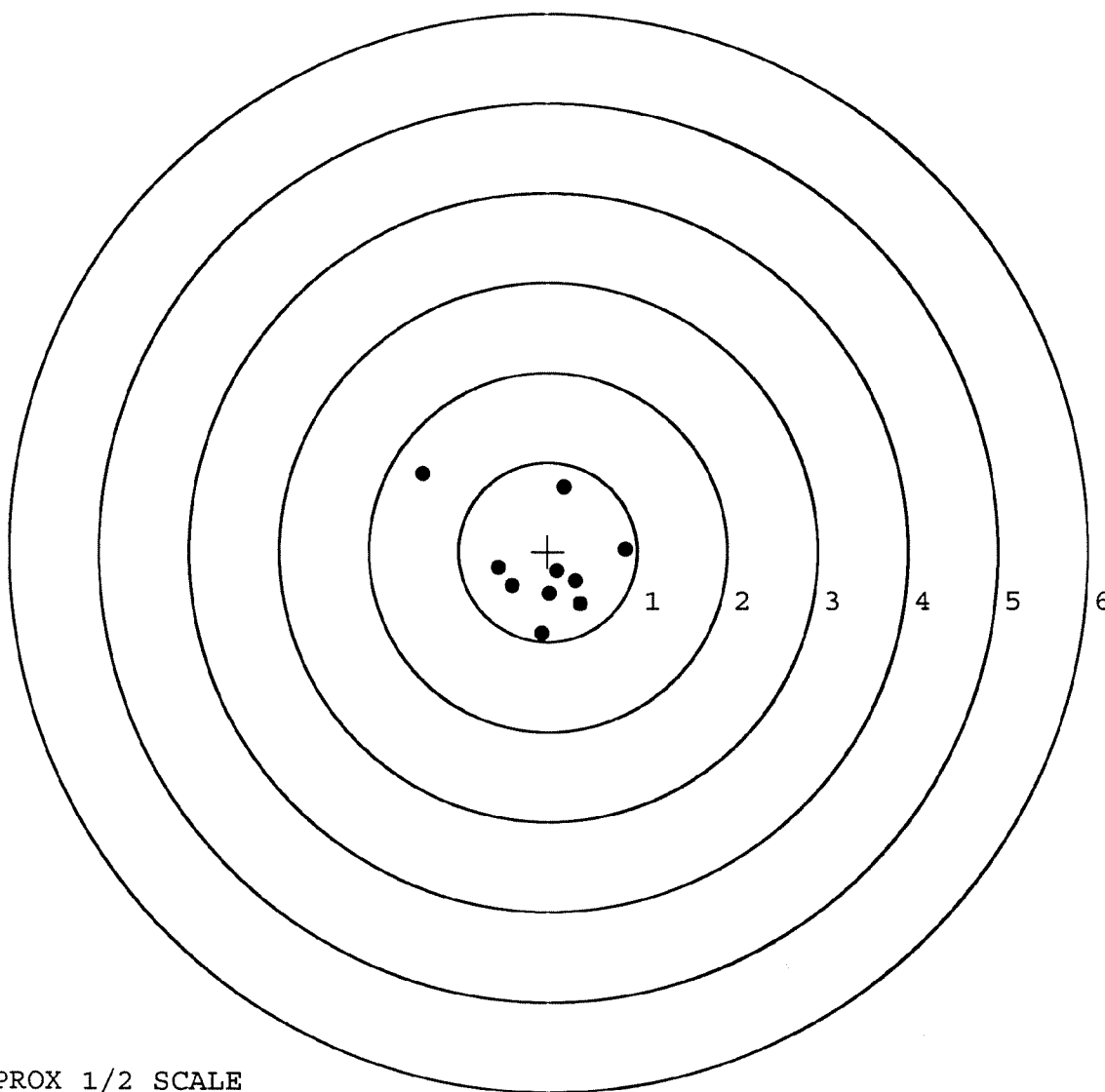
MAX RADIUS: 1.682

MEAN RADIUS: 0.674

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6348861. __0

TARGET NUMBER: 5

FILE DATE: 03/03/2008

FILE TIME: 09:38

POINT#	X	Y
1:	1.181	1.069
2:	-0.099	1.022
3:	-0.350	0.482
4:	-0.101	0.112
5:	0.398	-0.024
6:	0.700	-0.430
7:	0.529	-0.574
8:	-0.221	-0.351
9:	-0.680	-0.245
10:	-0.651	-0.551

X CENTROID: 0.071

Y CENTROID: 0.051

POA TO CENTROID: 0.087

HORZ SPREAD: 1.861

VERT SPREAD: 1.643

GROUP SPREAD: 2.446

MIN RADIUS: 0.182

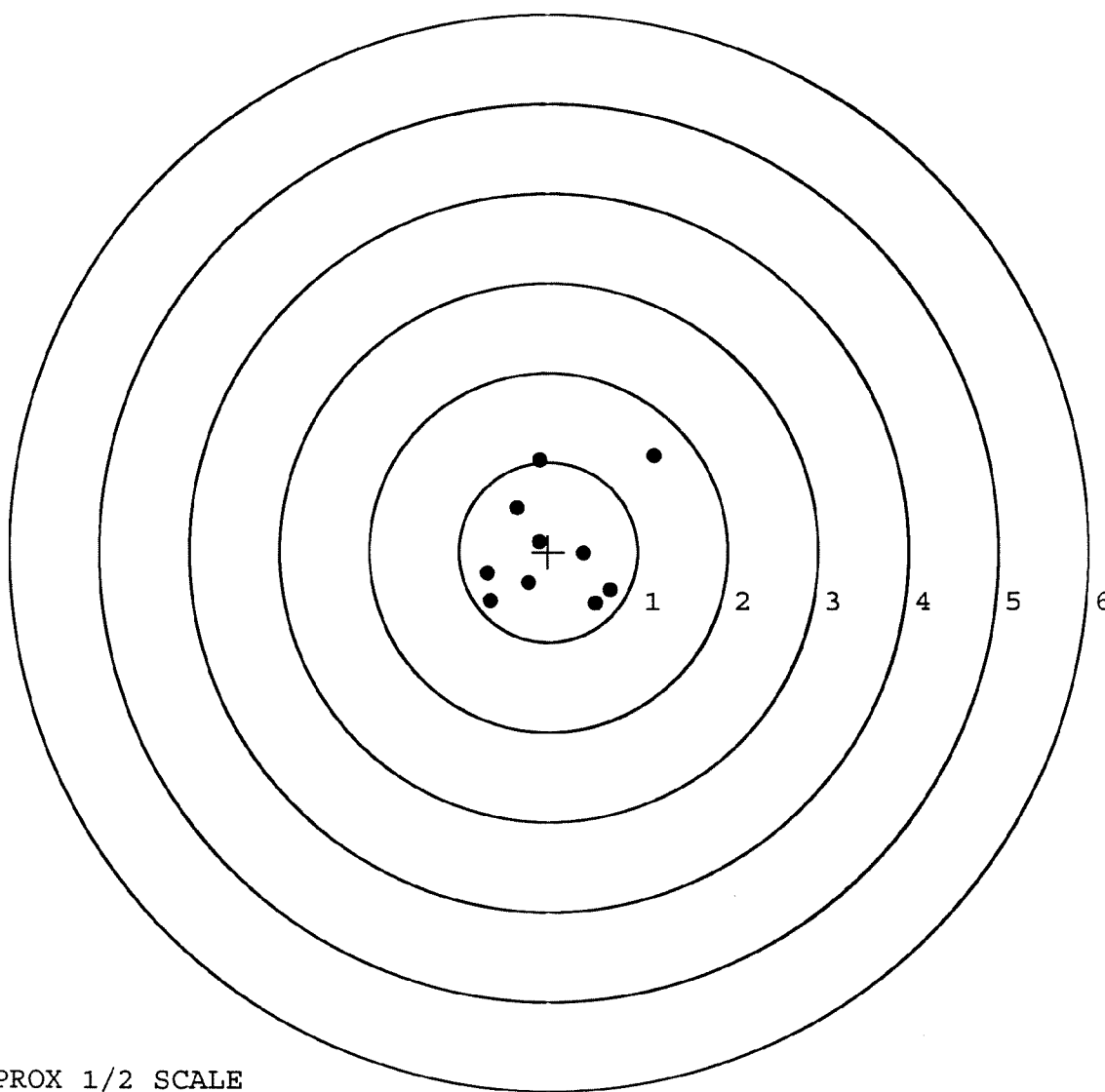
MAX RADIUS: 1.506

MEAN RADIUS: 0.742

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

**AVERAGE 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 6-21-06

TESTER R.P.

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	254	249		255	
PULL #2	260	251		250	
PULL #3	234	246		252	
PULL #4	267	253		250	
PULL #5	277	256		252	
TOTAL	1292	1255		1259	
AVERAGE	258	251		251	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	310	302		
PULL #2	310	304		
PULL #3	312	314		
PULL #4	301	310		
PULL #5	293	297		
TOTAL	1526	1527		
AVERAGE	305	305		

	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	418	392		410
PULL #2	392	391		408
PULL #3	410	415		396
PULL #4	403	411		417
PULL #5	401	409		421
TOTAL	2024	2018		2052
AVERAGE	404	403		410

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6348861.___0
FILE DATE AND TIME: 08/02/2002 11:06

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.066
The Average Y Centroid of the Five Target Set:	-0.002
The Average Point of Impact of the Five Target Set:	0.066
The Average Mean Radius of the Five Target Set:	0.938
The Distance from POA to Centroid Target #1:	0.302
The Distance from Centroid Target #2 to Centroid Target #1:	0.236
The Distance from Centroid Target #3 to Centroid Target #1:	0.467
The Distance from Centroid Target #4 to Centroid Target #1:	0.463
The Distance from Centroid Target #5 to Centroid Target #1:	0.539

SERIAL NUMBER: C6348861. 0

TARGET NUMBER: 1

FILE DATE: 08/02/2002

FILE TIME: 11:06

POINT#	X	Y
1:	0.276	-1.217
2:	-0.060	-0.749
3:	0.756	0.301
4:	0.415	1.016
5:	0.037	0.721
6:	-0.060	0.324
7:	-0.973	0.733
8:	0.428	0.459
9:	0.108	0.529
10:	0.269	0.651

X CENTROID: 0.120

Y CENTROID: 0.277

POA TO CENTROID: 0.302

HORZ SPREAD: 1.729

VERT SPREAD: 2.233

GROUP SPREAD: 2.316

MIN RADIUS: 0.186

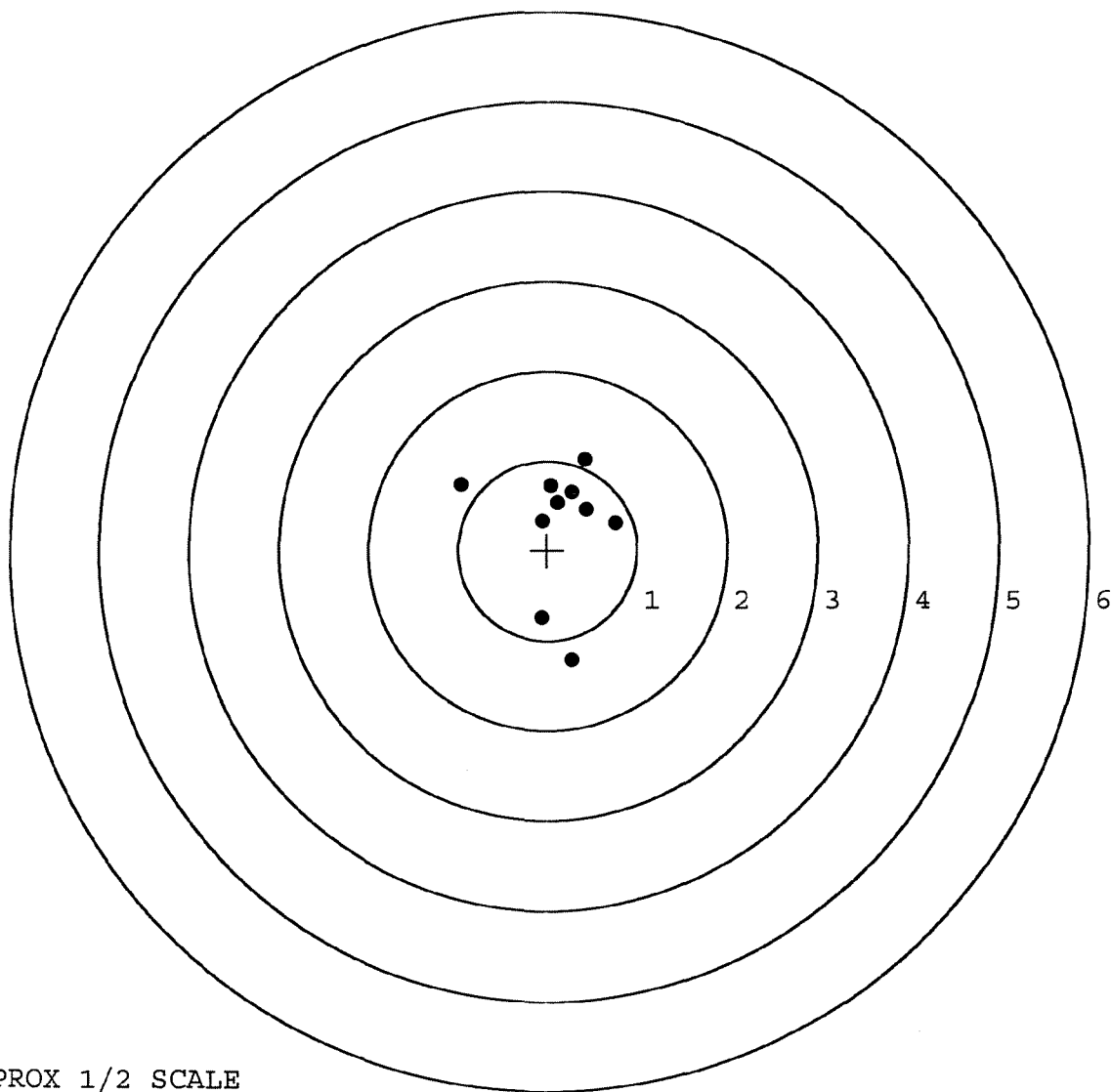
MAX RADIUS: 1.502

MEAN RADIUS: 0.681

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

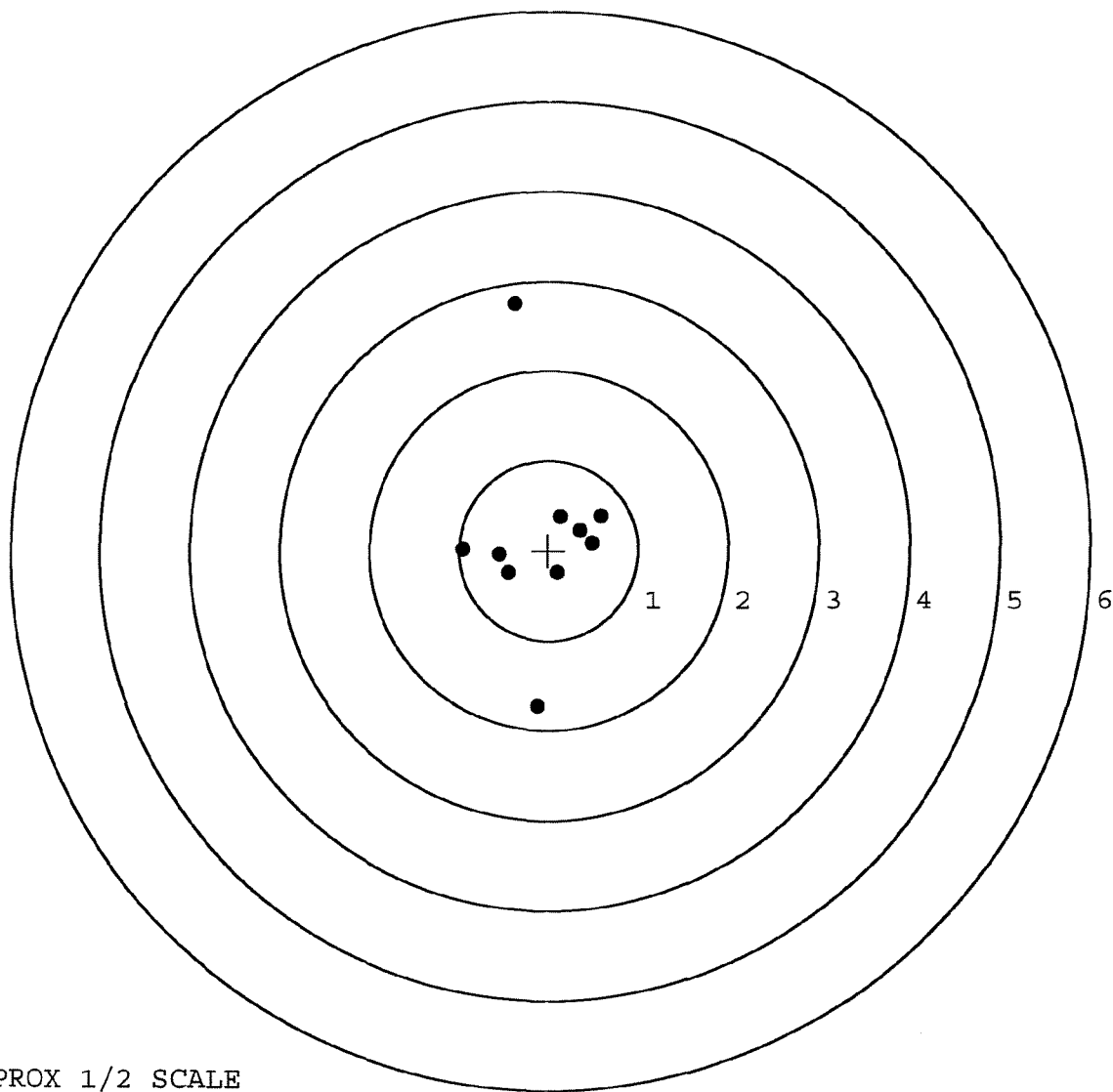
SERIAL NUMBER: C6348861.____0

TARGET NUMBER: 2

FILE DATE: 08/02/2002

FILE TIME: 11:06

	POINT#	X	Y
	1:	-0.116	-1.740
	2:	-0.453	-0.258
	3:	-0.548	-0.048
	4:	-0.959	0.009
	5:	-0.390	2.742
	6:	0.586	0.380
	7:	0.353	0.226
	8:	0.131	0.375
	9:	0.103	-0.252
	10:	0.486	0.085
X CENTROID:		-0.081	
Y CENTROID:		0.152	
POA TO CENTROID:		0.172	
HORZ SPREAD:		1.545	
VERT SPREAD:		4.482	
GROUP SPREAD:		4.490	
MIN RADIUS:		0.308	
MAX RADIUS:		2.609	
MEAN RADIUS:		0.892	
# IN 1 IN DIAMETER:		3	
# IN 2 IN DIAMETER:		8	
# in 3 IN DIAMETER:		8	

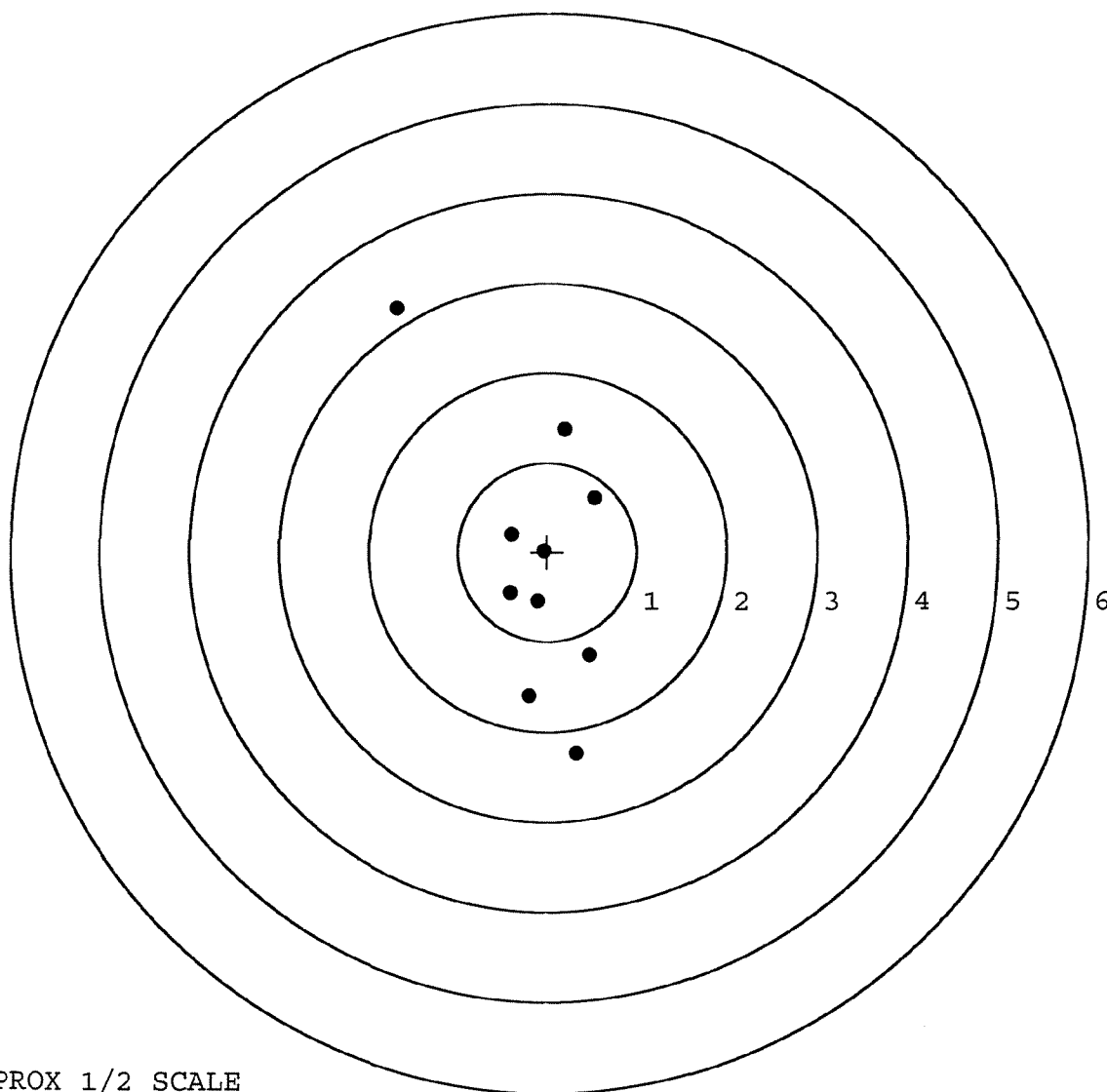


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6348861. __0
TARGET NUMBER: 3
FILE DATE: 08/02/2002
FILE TIME: 11:06

POINT#	X	Y
1:	0.331	-2.245
2:	-0.204	-1.612
3:	0.474	-1.159
4:	-0.113	-0.560
5:	-0.416	-0.464
6:	-0.036	0.011
7:	-0.413	0.198
8:	0.526	0.600
9:	0.189	1.368
10:	-1.687	2.716

X CENTROID: -0.135
Y CENTROID: -0.115
POA TO CENTROID: 0.177
HORZ SPREAD: 2.213
VERT SPREAD: 4.961
GROUP SPREAD: 5.356
MIN RADIUS: 0.160
MAX RADIUS: 3.228
MEAN RADIUS: 1.208
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 5
in 3 IN DIAMETER: 7

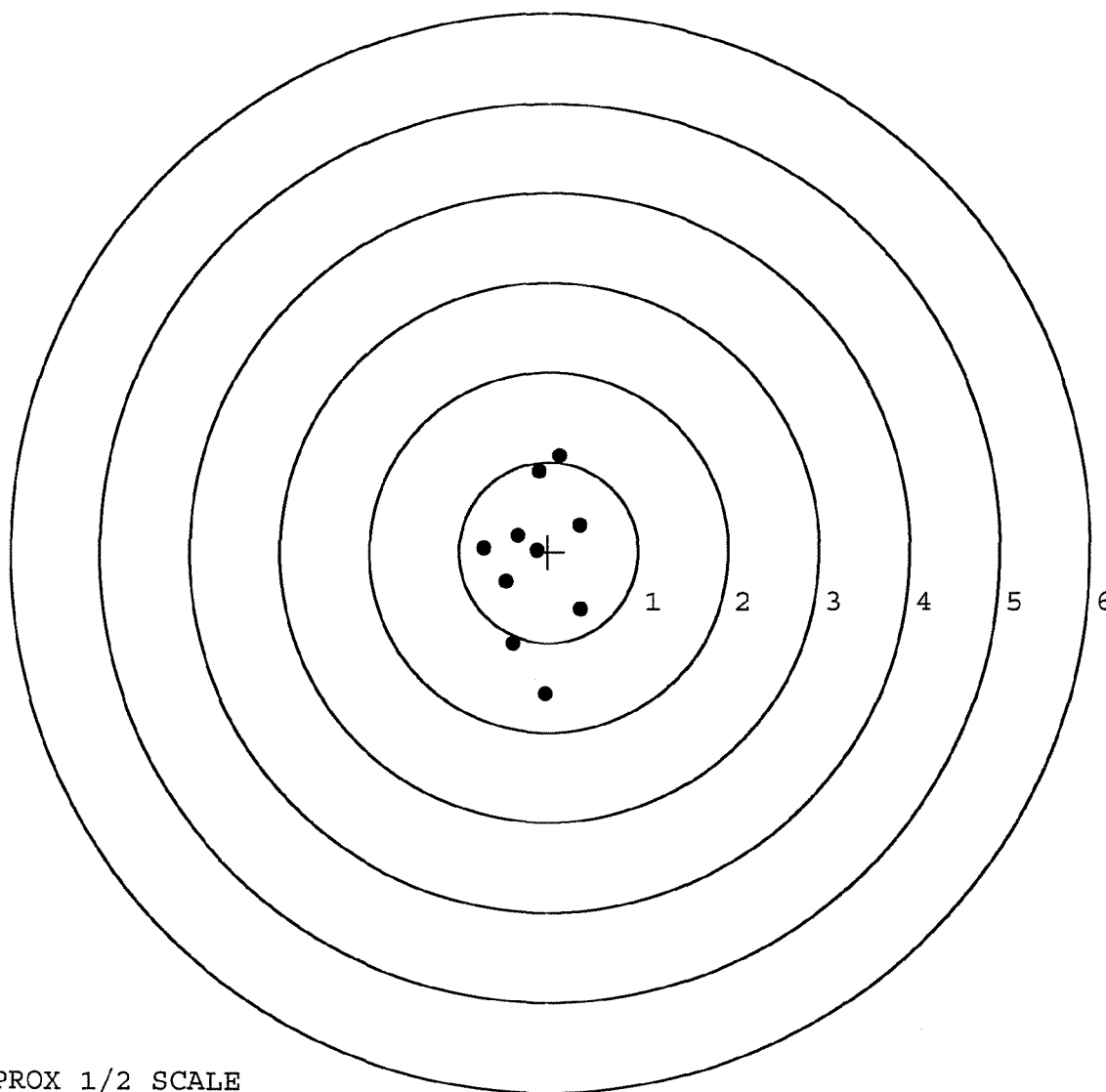


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6348861. __0
TARGET NUMBER: 4
FILE DATE: 08/02/2002
FILE TIME: 11:06

POINT#	X	Y
1:	-0.036	-1.580
2:	-0.395	-1.017
3:	0.362	-0.640
4:	0.348	0.295
5:	0.125	1.069
6:	-0.109	0.896
7:	-0.352	0.178
8:	-0.722	0.037
9:	-0.479	-0.334
10:	-0.130	0.018

X CENTROID: -0.139
Y CENTROID: -0.108
POA TO CENTROID: 0.176
HORZ SPREAD: 1.084
VERT SPREAD: 2.649
GROUP SPREAD: 2.654
MIN RADIUS: 0.126
MAX RADIUS: 1.476
MEAN RADIUS: 0.749
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 10

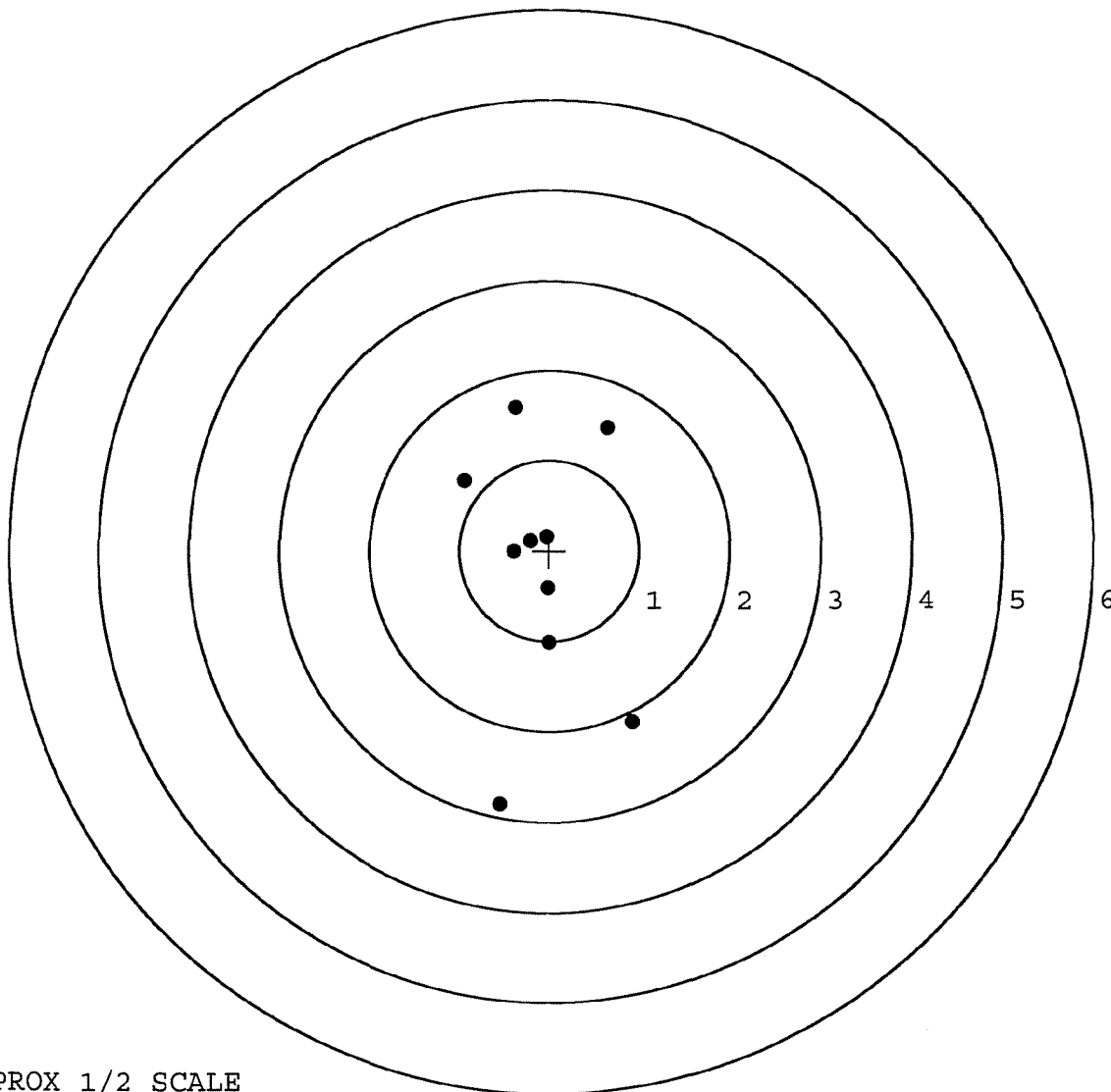


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6348861. __0
TARGET NUMBER: 5
FILE DATE: 08/02/2002
FILE TIME: 11:06

X CENTROID: -0.097
Y CENTROID: -0.218
POA TO CENTROID: 0.238
HORZ SPREAD: 1.877
VERT SPREAD: 4.393
GROUP SPREAD: 4.396
MIN RADIUS: 0.216
MAX RADIUS: 2.631
MEAN RADIUS: 1.160
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 5
in 3 IN DIAMETER: 6

POINT#	X	Y
1:	0.642	1.358
2:	-0.386	1.584
3:	-0.948	0.776
4:	-0.027	0.159
5:	-0.212	0.110
6:	-0.399	-0.008
7:	-0.015	-0.417
8:	0.003	-1.022
9:	-0.552	-2.809
10:	0.929	-1.906



TARGET APPROX 1/2 SCALE

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

R & E NUMBER	112227		
SERIAL NUMBER	C6348861		
LOG-IN DATE	5-11-06		
OPERATION #	OPERATION NAME	DATE	INITIAL
500	DIS-ASSEMBLE GUN	6-21-06	RTC
505	RE-BARREL	6-22-06	RTC
420	ASSEMBLE	6-22-06	RTC
440	PROOF	6-23-06	TRW
460	CHECK HEADSPACE	6-23-06	TRW
470	DIS-ASSEMBLE GUN	6-23-06	RTC
480	MAGNAFLUX	6-23-06	unc
510	DRILL AND TAP	6-23-06	TRW
500	ROLLMARK CALIBER	6-23-06	CW
520	GOFF BLAST BBL / REC	6-23-06	LB
530 & 540	APPLY COATINGS	6-24-06	TR
560	FINAL ASSEMBLY	6-27-06	RTC
640	FUNCTION TEST AND	PASS FAIL 6-27-06	MTH
650	TARGET	PASS FAIL 6-27-06	MTH
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
670	FINAL INSPECTION	6-28-06	AC
	A) HEADSPACE	PASS FAIL 6-28-06	AC
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS N/A AC	
680	F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX 7/bs 7/bs 7/bs AC	
	G) SAFETY OFF FORCE	2 LBS MIN 4/bs 4/bs 4/bs AC	
	I) FIRING PIN INDENT	.020 .022 .022 .022 AC	
690	PACK	7-11-06	DA

F006 REV 5/2006

FINAL INSPECTION CHECKLIST

BARREL ASSEMBLY		STOCK ASSEMBLY	
_____	BARREL	_____	STOCK
_____	RECEIVER	_____	SLING SWIVEL STUDS
_____	FRONT SIGHT BASE	_____	
_____	REAR SIGHT BASE	_____	BUTT PATE
_____	SCREWS	_____	LOCK NUTS
_____	FINISH	_____	BARREL CLEARANCE
		_____	COLOR / FINISH
SCOPE ASSEMBLY		SYSTEM CASE	
_____	SCOPE	_____	SCOPE CASE
_____	SCOPE RINGS	_____	IRON SIGHTS
_____	MOUNTING SCREWS	_____	DEPLOYMENT KIT
_____	MOUNTING BASE		
_____	SCREWS	TRIGGER ASSEMBLY	
_____	FINISH	_____	SAFETY OPERATION
_____	CLARITY	_____	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 C&B Tools Reports Table Maintenance System Maintenance Help

Repair Inquiry

Repair Number: **RE00049376** Serial: **C6348861** Model: **700** Center Fire Caliber: **7.62 NATO** M24 SWS Produced: **12/13/1989** Repairman: Status: **Closed 7/16/02 2:55:53 PM**

Verify Repair

Address Information

Customer: **COMMANDER INFANTRY** Received From: **COMMANDER INFANTRY** Return To: **COMMANDER INFANTRY**

Address 1: **2ND BATTALION AIR 503D** Address 2: **UNIT 31401 BOX 104** PO Box: D/O: **APD** State: **NJ** Zip Code: **09630** Country: **US**

State: **NJ** Zip Code: **09630** Country: **US**

FFI:

Contact / Condition Problems Estimate History / Status Shipping / Billing

Contact Information

Phone: Fax: Email: Comments:

Received Condition

Fair

Correction Notes:

CSR Notes:

Accessories Received

Code	Desc	Qty
A007	With Studs	3
A009	Soft Case	1
A010	Hard Case	1
A017	Scope Base	1
A026	Scope	1
A042	Adjustable Butt Pad	1
X001	Extra firing pins	2

Repair Search Refresh Close

7/17/02 9:49 AM CAPS NUM INS SCFL

Start n. Ca. SA Pa. MR. U. W. P. S 9:49 AM

Serial Number: **C6348861**

Model: **700**



RE00049376

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6348861.___0

FILE DATE AND TIME: 08/02/2002 11:06

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.066
The Average Y Centroid of the Five Target Set:	-0.002
The Average Point of Impact of the Five Target Set:	0.066
The Average Mean Radius of the Five Target Set:	0.938
The Distance from POA to Centroid Target #1:	0.302
The Distance from Centroid Target #2 to Centroid Target #1:	0.236
The Distance from Centroid Target #3 to Centroid Target #1:	0.467
The Distance from Centroid Target #4 to Centroid Target #1:	0.463
The Distance from Centroid Target #5 to Centroid Target #1:	0.539

SERIAL NUMBER: C6348861. __0

TARGET NUMBER: 1

FILE DATE: 08/02/2002

FILE TIME: 11:06

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

1:	0.276	-1.217
----	-------	--------

2:	-0.060	-0.749
----	--------	--------

3:	0.756	0.301
----	-------	-------

4:	0.415	1.016
----	-------	-------

5:	0.037	0.721
----	-------	-------

6:	-0.060	0.324
----	--------	-------

7:	-0.973	0.733
----	--------	-------

8:	0.428	0.459
----	-------	-------

9:	0.108	0.529
----	-------	-------

10:	0.269	0.651
-----	-------	-------

X CENTROID: 0.120

Y CENTROID: 0.277

POA TO CENTROID: 0.302

HORZ SPREAD: 1.729

VERT SPREAD: 2.233

GROUP SPREAD: 2.316

MIN RADIUS: 0.186

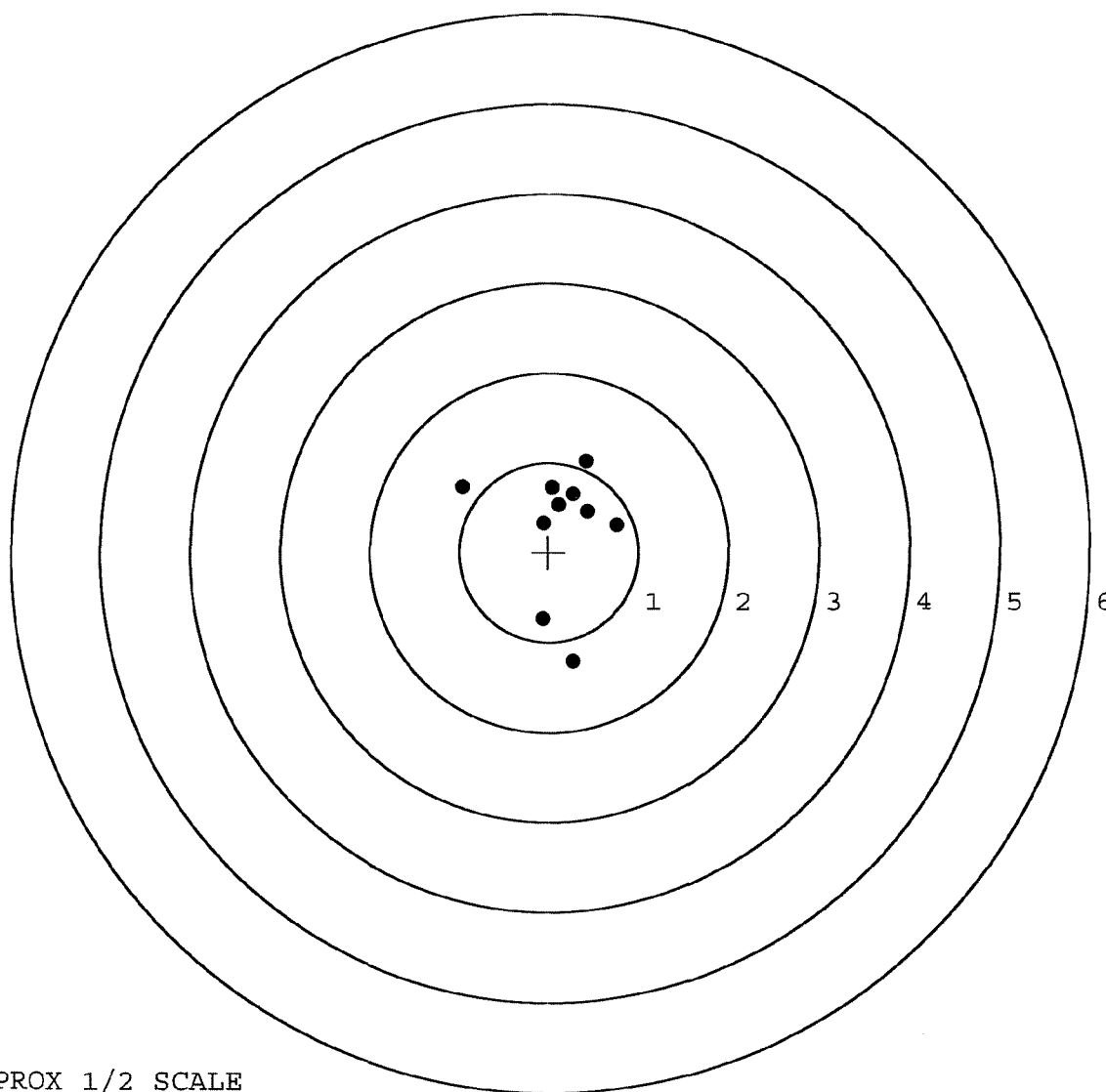
MAX RADIUS: 1.502

MEAN RADIUS: 0.681

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6348861.____0

TARGET NUMBER: 2

FILE DATE: 08/02/2002

FILE TIME: 11:06

POINT#	X	Y
1:	-0.116	-1.740
2:	-0.453	-0.258
3:	-0.548	-0.048
4:	-0.959	0.009
5:	-0.390	2.742
6:	0.586	0.380
7:	0.353	0.226
8:	0.131	0.375
9:	0.103	-0.252
10:	0.486	0.085

X CENTROID: -0.081

Y CENTROID: 0.152

POA TO CENTROID: 0.172

HORZ SPREAD: 1.545

VERT SPREAD: 4.482

GROUP SPREAD: 4.490

MIN RADIUS: 0.308

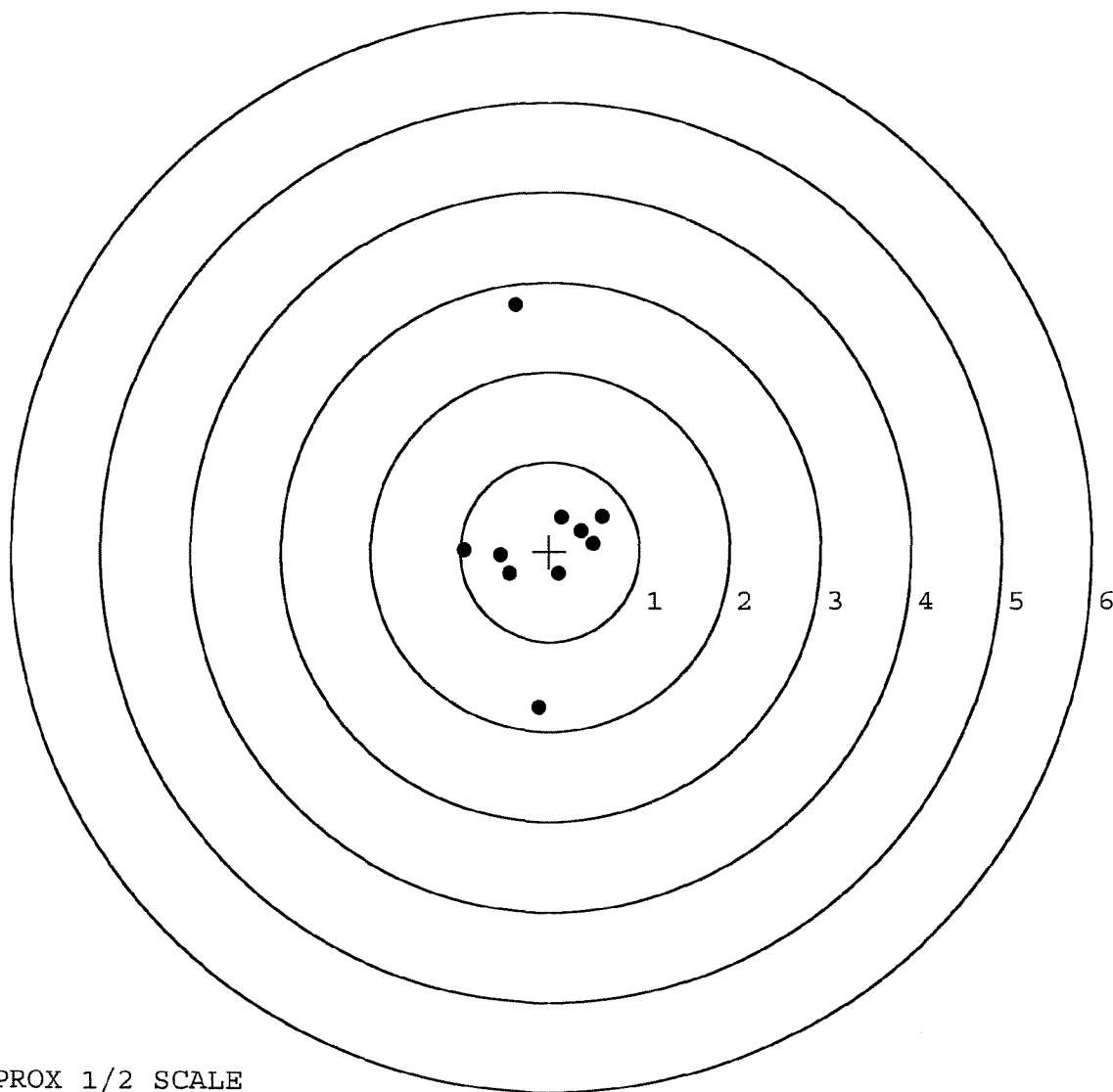
MAX RADIUS: 2.609

MEAN RADIUS: 0.892

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 8

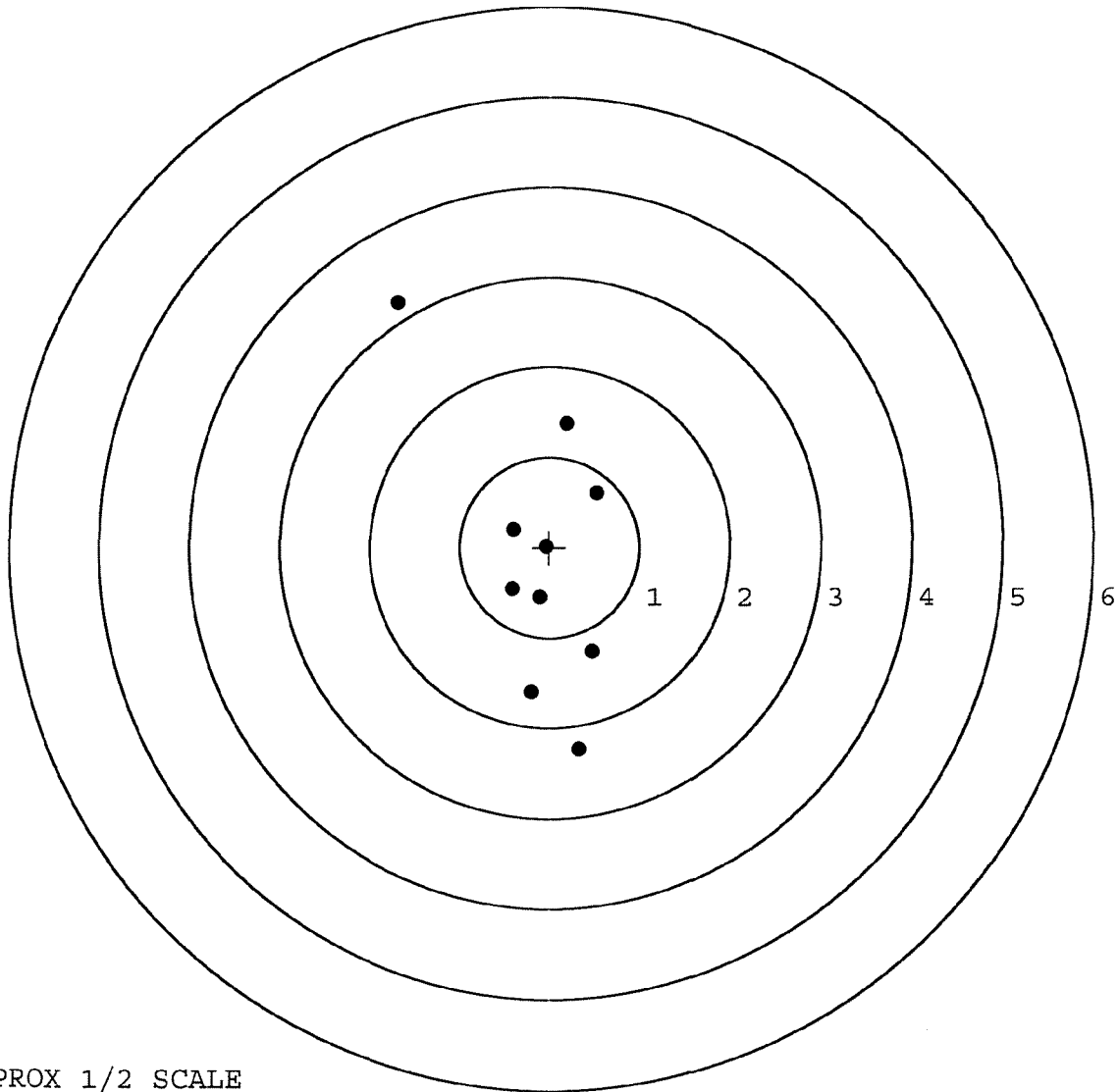


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6348861.____0
TARGET NUMBER: 3
FILE DATE: 08/02/2002
FILE TIME: 11:06

POINT#	X	Y
1:	0.331	-2.245
2:	-0.204	-1.612
3:	0.474	-1.159
4:	-0.113	-0.560
5:	-0.416	-0.464
6:	-0.036	0.011
7:	-0.413	0.198
8:	0.526	0.600
9:	0.189	1.368
10:	-1.687	2.716

X CENTROID: -0.135
Y CENTROID: -0.115
POA TO CENTROID: 0.177
HORZ SPREAD: 2.213
VERT SPREAD: 4.961
GROUP SPREAD: 5.356
MIN RADIUS: 0.160
MAX RADIUS: 3.228
MEAN RADIUS: 1.208
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 5
in 3 IN DIAMETER: 7

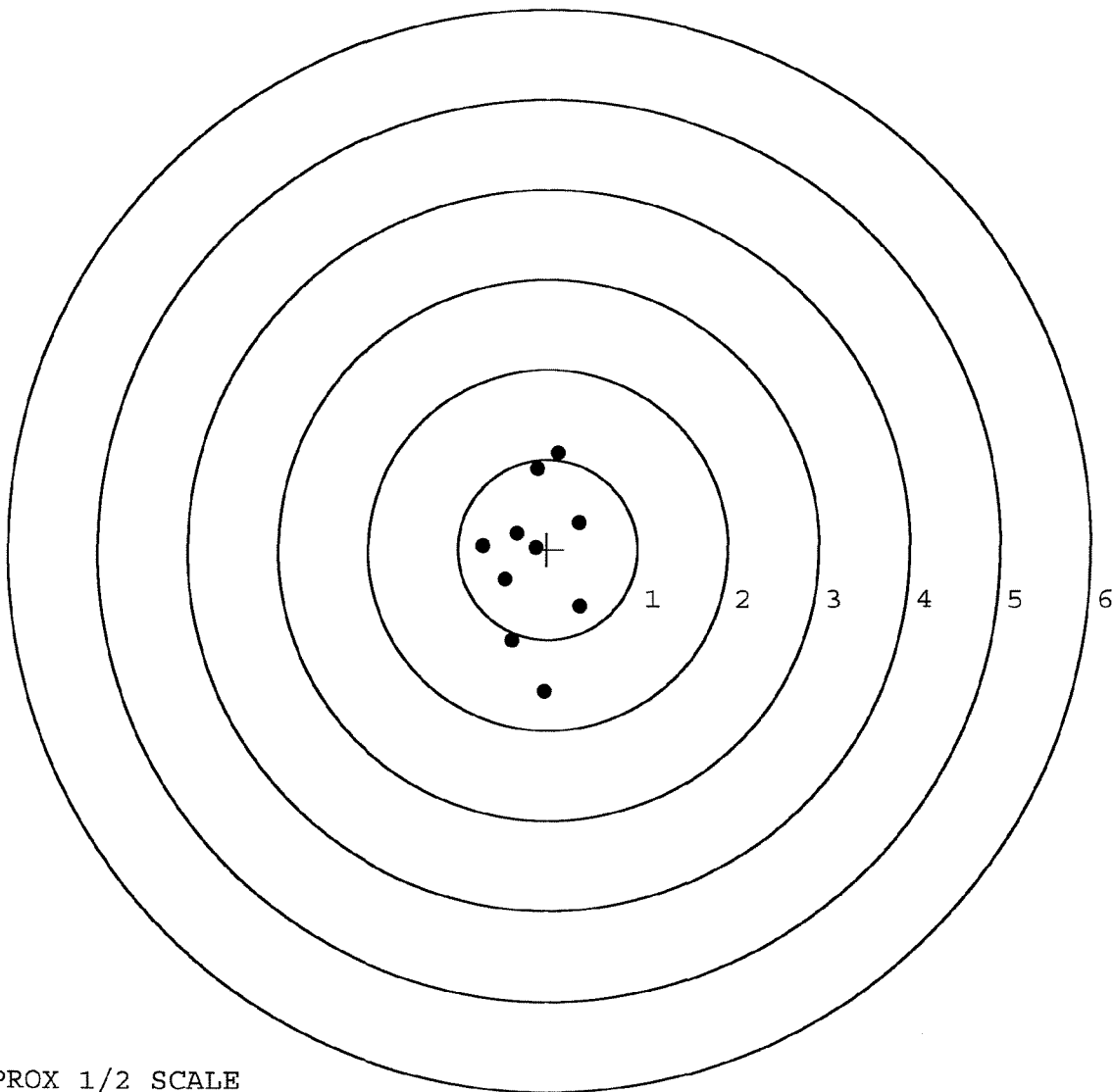


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6348861. __0
TARGET NUMBER: 4
FILE DATE: 08/02/2002
FILE TIME: 11:06

X CENTROID: -0.139
Y CENTROID: -0.108
POA TO CENTROID: 0.176
HORZ SPREAD: 1.084
VERT SPREAD: 2.649
GROUP SPREAD: 2.654
MIN RADIUS: 0.126
MAX RADIUS: 1.476
MEAN RADIUS: 0.749
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.036	-1.580
2:	-0.395	-1.017
3:	0.362	-0.640
4:	0.348	0.295
5:	0.125	1.069
6:	-0.109	0.896
7:	-0.352	0.178
8:	-0.722	0.037
9:	-0.479	-0.334
10:	-0.130	0.018

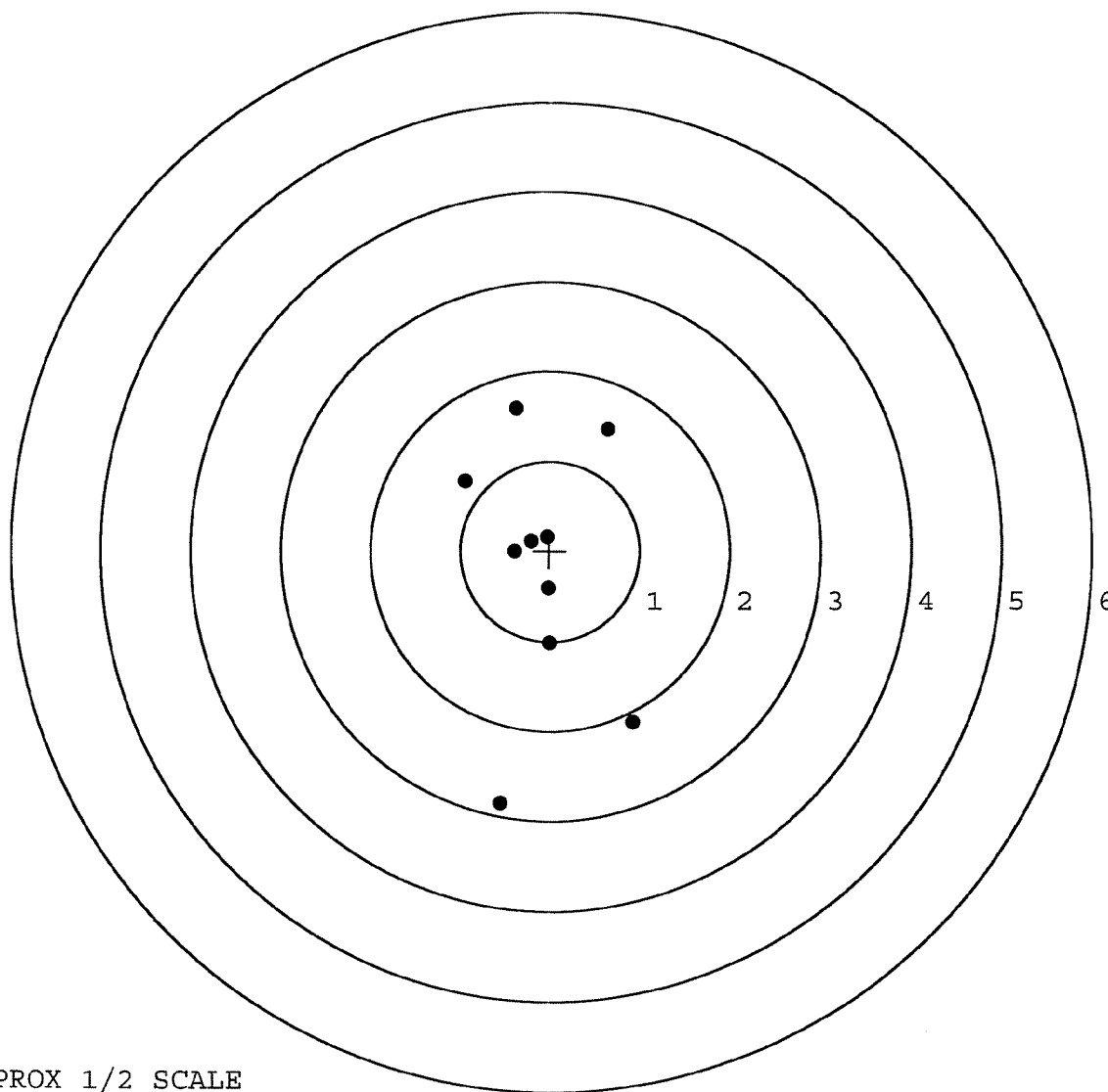


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6348861.____0
TARGET NUMBER: 5
FILE DATE: 08/02/2002
FILE TIME: 11:06

POINT#	X	Y
1:	0.642	1.358
2:	-0.386	1.584
3:	-0.948	0.776
4:	-0.027	0.159
5:	-0.212	0.110
6:	-0.399	-0.008
7:	-0.015	-0.417
8:	0.003	-1.022
9:	-0.552	-2.809
10:	0.929	-1.906

X CENTROID: -0.097
Y CENTROID: -0.218
POA TO CENTROID: 0.238
HORZ SPREAD: 1.877
VERT SPREAD: 4.393
GROUP SPREAD: 4.396
MIN RADIUS: 0.216
MAX RADIUS: 2.631
MEAN RADIUS: 1.160
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 5
in 3 IN DIAMETER: 6



TARGET APPROX 1/2 SCALE

Final Inspection

In: C6348861

DATE REC'D: 7/16/02

DATE RET'D: 8/7/02

WRITER:

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: _____

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

R & E NUMBER	49316		
SERIAL NUMBER	C10348861		
LOG-IN DATE	7/16/02		
INSPECT AND VERIFY:			
OPERATION #	OPERATION NAME	DATE	INITIAL
550	DIS-ASSEMBLE GUN	7/18/02	PL
560 A	RE-BARREL	7/18/02	DA
B	DRILL AND TAP	7-19-02	AC
575	ASSEMBLE	7/19/02	PL
600	PROOF	7-20-02	AC
605	CHECK HEADSPACE	7/22/02	PL
610	DIS-ASSEMBLE GUN	7/22/02	PL
612	MAGNAFLUX	MAGNA - FLUX	
615	ROLLMARK CALIBER	INSPECTED	
618	ROTO-BLAST	JUL 23 2002	
620	APPLY COATINGS	7/25/02	
625 A	FINAL ASSEMBLY	7-26	TA
B	TRIGGER PULL TEST	7-30-02	RW
C	SAFETY "ON" FORCE		
D	SAFETY "OFF" FORCE		
E	FIRING PIN INDENT		
640	TARGET	8-1-02	TRW
655	FINAL INSPECT	8-6-02	RW
660	PACK	8-7-02	DA
		SHIP DATE	
	QAR INSPECTION DATE		




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.

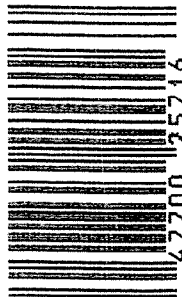
SERIAL NO.
C6348861

ORDER NO.
5716



5716 C6348861

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6348861

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	8 24	89	RW
600	Proof	8 24	89	RW
607	Check Headspace			RW
610	Dis-assemble Gun			RW
612	Magnaflux Barrel Action		8/15/89	KCR
	Magnaflux Bolt		8/15/89	KCR
615	Rollmark Caliber			
7	Drill and Tap Sight Holes	8 28	89	
618	Polish Barrel <i>RS</i>	28	89	BT
620	Apply Coatings (Barrel Action)		9-7-89	TSA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		9/7/89	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		9/7/89	RW
	C) Inspect Ejector Hole for Chamfer		9/7/89	RW
	D) Oil Firing Pin Ass'y		9/7/89	RW
	E) Adjust Trigger Pull to Min Setting and Stake		9-8-89	SL

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5 1/4	5 1/4	5 1/4			9/8/89	WB
	G) Safety Off Force	3 1/4	3 1/4	3 1/4			9/8/89	WB
	H) Trigger Pull Test & Retainability						9-8-89	SP
	I) Firing Pin Indent	.0215	.021	.0225			9/8/89	WB
	J) Assemble Stock						9/8/89	RW
	K) Assemble Swivel Studs						6-5-89	JS
	L) Attach Front and Rear Sight Assemblies						9/8/89	RW
	M) Iron Sight Alignment						9/8/89	RW
	N) Detach Front & Rear Sights & place in numbered container						9/8/89	RW
	O) Attach Scope to Rifle						10/4/89	SP
	P) Detach & Attach Scope 20 Times						10/4/89	SP
640	Gallery Target & Test						10-5-89	AC
	A) Time						10-5-89	AC
	B) Malfunctions						10-5-89	AC
	C) Pierced Primers						10-5-89	AC
	D) Optical Clarity of Scope						10-5-89	AC
645	Inspect for Live Ammo						10-5-89	AC
655	Final Inspection						6-5-89	JS
	A) Headspace						6-5-89	JS
	B) Trigger Pull	274	273	283	268	276	6-5-89	JS
	C) Function						6-5-89	JS
660	Pack						14 Dec 89	JS

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. 0634 8861

DATE 14 MAR 90

TESTER JD

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.18	2.39		2.58	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.03	2.42		2.61	
PULL #3	2.32	2.51		2.68	
PULL #4	2.40	2.51		2.45	
PULL #5	2.43	2.49		2.78	
TOTAL	11.41	12.52			
AVG.	2.282	2.504			

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.51	3.56		
PULL #2	3.52	3.65		
PULL #3	3.54	3.61		
PULL #4	3.55	3.66		
PULL #5	3.57	3.64		
TOTAL	17.69	18.12		
AVG.	3.538	3.624		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	3.90	3.92		
PULL #2	3.90	3.93		
PULL #3	3.80	3.93		
PULL #4	3.64	3.92		
PULL #5	3.89	3.90		
TOTAL	19.13	19.60		
AVG.	3.826	3.92		

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06348861
5 Oct 1989

CENTROIDAL DISTANCES

0 TO 1	.749024
1 TO 2	.609082
1 TO 3	.709662
1 TO 4	.7179
1 TO 5	.585137

2 (----POA
1

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .245
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.2418
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .344227

THE AMR FOR THIS RIFLE IS: .9662

5 Oct 1989

FILE:/PATTERN/ING/CENTERFIRE_PATT/C89040081

CENTERFIRE PATTERNS

1

FOR

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS= 10

IN CIR

1 in = 2

2 in = 4

3 in = 8

HS= 2.526

VS= 3.184

OS= 3.229

PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.290	1.290	1.335
MINIMUM X	:	-1.326	-1.236	-1.191
MAXIMUM Y	:	1.639	.890	.720
MINIMUM Y	:	-1.545	-1.363	-1.157
CENTROID X	:	.429	.339	.294
CENTROID Y	:	-.614	-.796	-.626
FOR TO CENTROID in.	:	.749	.866	.691
MIN RADIUS	:	.126	.328	.214
MEAN RADIUS	:	1.081	1.012	.935
MAX RADIUS	:	1.828	1.444	1.567
HORIZONTAL SPREAD	:	2.526	2.253	1.877
VERTICAL SPREAD	:	3.184	2.719	2.719
EXTREME SPREAD	:	3.229	2.719	2.719
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	4		
NUMBER IN THREE INCH CIRCLE	=	8		

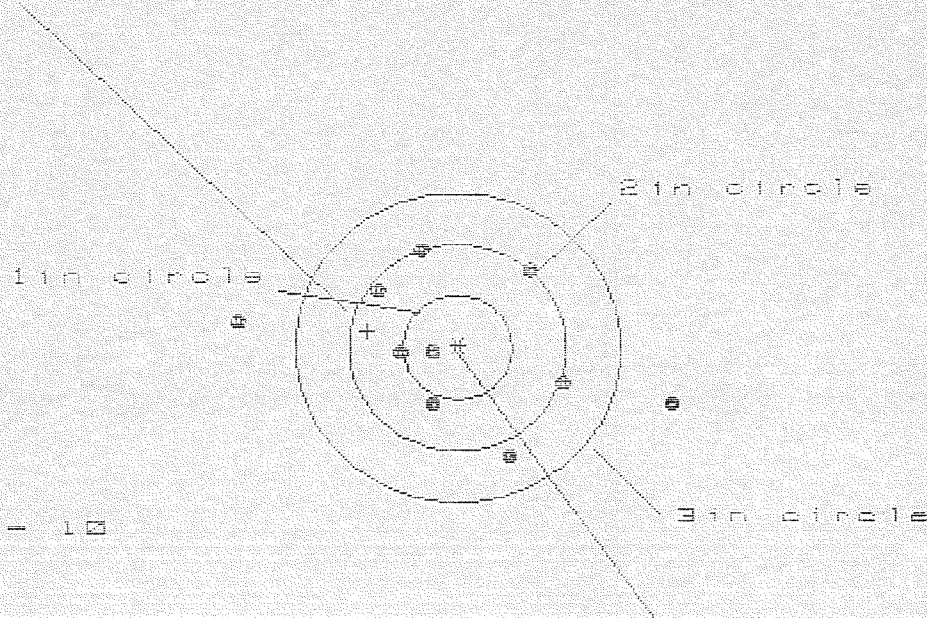
5 Oct 1989

FILE:/PATTERNING/CENTERFIRE_PATT/08348851

CENTERFIRE PATTERNS

2

POA



OF SHOTS- 10

IN CIR

1in = 2

2in = 4

3in = 8

HS= 4.037

VS= 1.939

GS= 4.103

CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.962	1.732	.964
MINIMUM X	:	-2.075	-.948	-.732
MAXIMUM Y	:	.937	.961	.900
MINIMUM Y	:	-1.002	-.978	-1.039
CENTROID X	:	.829	1.059	.843
CENTROID Y	:	-.156	-.180	-.119
POA TO CENTROID in.	:	.843	1.075	.851
MIN RADIUS	:	.247	.473	.270
MEAN RADIUS	:	1.048	.956	.799
MAX RADIUS	:	2.086	1.799	1.125
HORIZONTAL SPREAD	:	4.037	2.680	1.696
VERTICAL SPREAD	:	1.939	1.939	1.939
EXTREME SPREAD	:	4.103	2.884	2.100
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	

5 Oct 1989

FILE:/PATTERNING/CENTERFIRE_PATT/08348861

CENTERFIRE PATTERNS # 3

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS= 10

IN CIR

1in = 2

2in = 6

3in = 8

HS= 2.282

VS= 2.279

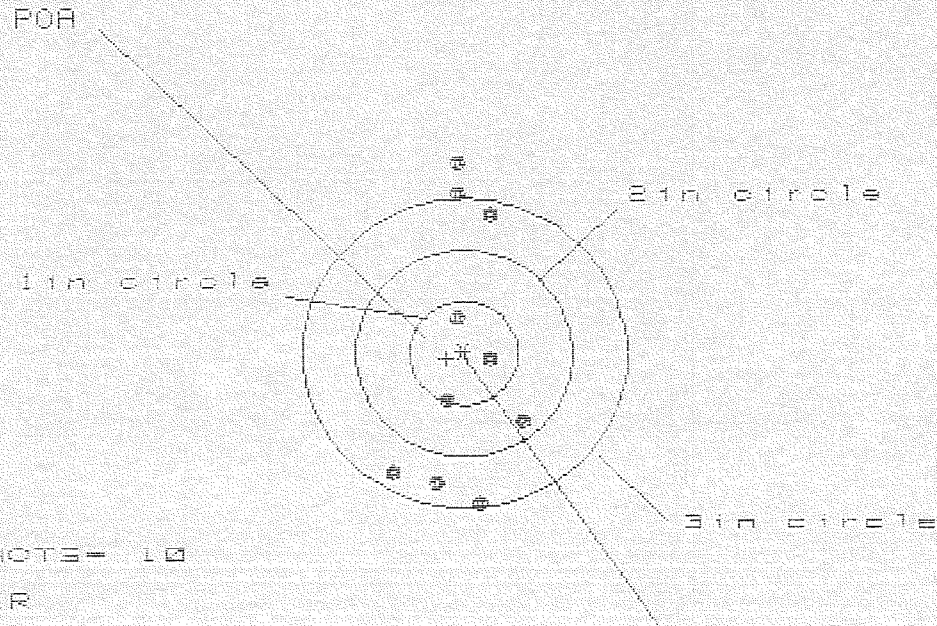
GS= 2.615

PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	.873
MINIMUM X	-1.409
MAXIMUM Y	1.108
MINIMUM Y	-1.171
CENTROID X	-.195
CENTROID Y	-.276
POA TO CENTROID in.	.339
MIN RADIUS	.100
MEAN RADIUS	.862
MAX RADIUS	1.592
HORIZONTAL SPREAD	2.282
VERTICAL SPREAD	2.279
EXTREME SPREAD	2.615
NUMBER IN ONE INCH CIRCLE =	2
NUMBER IN TWO INCH CIRCLE =	6
NUMBER IN THREE INCH CIRCLE =	8

5 Oct 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C8345861

CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1in = 2

2in = 4

3in = 8

HS= 1.307

VS= 3.342

CS= 3.350

CENTROID *

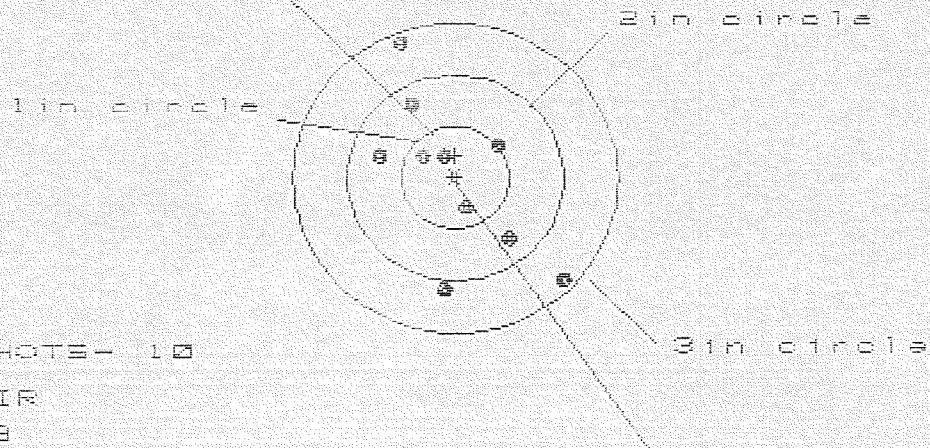
PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.550	.543	.540
MINIMUM X	:	-.657	-.664	-.667
MAXIMUM Y	:	1.861	1.735	1.729
MINIMUM Y	:	-1.481	-1.275	-1.058
CENTROID X	:	.161	.168	.171
CENTROID Y	:	.052	-.154	-.371
POA TO CENTROID in.	:	.169	.228	.409
MIN RADIUS	:	.196	.268	.148
MEAN RADIUS	:	1.070	.957	.827
MAX RADIUS	:	1.862	1.736	1.747
HORIZONTAL SPREAD	:	1.207	1.207	1.207
VERTICAL SPREAD	:	3.342	3.010	2.787
EXTREME SPREAD	:	3.350	3.016	2.788
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	

5 Oct 1989

FILE:/PATTERNING/CENTERFIRE_PATT/0834B8861

CENTERFIRE PATTERNS # 5

POB



OF SHOTS- 10

IN CIR

1in = 3

2in = 7

3in = 10

HS= 1.767

VS= 2.330

GS= 2.739

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.039	.652	.605
MINIMUM X	:	-.728	-.612	-.659
MAXIMUM Y	:	1.291	1.181	.762
MINIMUM Y	:	-1.039	-1.149	-1.001
CENTROID X	:	.001	-.115	-.068
CENTROID Y	:	-.215	-.105	-.253
POB TO CENTROID in.	:	.215	.156	.262
MIN RADIUS	:	.209	.137	.271
MEAN RADIUS	:	.770	.670	.610
MAX RADIUS	:	1.431	1.238	1.002
HORIZONTAL SPREAD	:	1.767	1.264	1.264
VERTICAL SPREAD	:	2.330	2.330	1.763
EXTREME SPREAD	:	2.739	2.360	1.788
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	