

G686 8473
Replaces
G6535403

M-24
INSPECTION CHECKLIST - REPAIRS
CONTRACT #: W52H09-07-C-0207
ISSUED 10/1/2007

R & E NUMBER _____
SERIAL NUMBER G6535403
LOG-IN DATE 7-22-09

G6868473

OPERATION #	OPERATION NAME	DATE	INITIAL
500	DIS-ASSEMBLE GUN	7-24-09	RTZ
505	RE-BARREL	7-28-09	RTZ
420	ASSEMBLE	7-28-09	RTZ
440	PROOF	7-28-09	L.P.D.
460	CHECK HEADSPACE	7-28-09	L.P.D.
470	DIS-ASSEMBLE GUN	7-28-09	L.P.D.
480	MAGNAFLUX	7/31/09	(D)
510	DRILL AND TAP	7-29-09	SP
500	ROLLMARK CALIBER	7-31-09	D.W.D.
520	GOFF BLAST BBL / REC	7/31/09	WJ
530 & 540	APPLY COATINGS	8/1/09	✓
560	FINAL ASSEMBLY	8-7-09	RTZ
640	FUNCTION TEST AND	8-19-09	RP
650	TARGET	8-19-09	RP
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
670	FINAL INSPECTION	8-19-09	L.P.D.
	A) HEADSPACE	8-20-09	RTZ
	B) TRIGGER PULL	8-20-09	RTZ
		278 254 266 276 263	
680	F) SAFETY ON FORCE	8-20-09	RTZ
	G) SAFETY OFF FORCE	8-20-09	RTZ
	I) FIRING PIN INDENT	8-20-09	RTZ
690	PACK	8/20/09	Fry

F006 REV 1/2009

For use of this form, see DA PAM 738-750 and 738-751; the proponent agency is DCSLOG

For use of this form, see DA PAM 738-750 and 738-751; the proponent agency is DCSLOG

DA FORM 2404, APR 1979 Replaces edition of 1 Jan 64, which will be used APD PE v1.10

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6868473.___0
FILE DATE AND TIME: 08/20/2009 05:37

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:	0.067
The Average Point of Impact of the Five Target Set:	0.081
The Average Mean Radius of the Five Target Set:	0.606
The Distance from POA to Centroid Target #1:	0.089
The Distance from Centroid Target #2 to Centroid Target #1:	0.165
The Distance from Centroid Target #3 to Centroid Target #1:	0.247
The Distance from Centroid Target #4 to Centroid Target #1:	0.080
The Distance from Centroid Target #5 to Centroid Target #1:	0.160

SERIAL NUMBER: G6868473. 0

TARGET NUMBER: 1

FILE DATE: 08/20/2009

FILE TIME: 05:37

POINT#	X	Y
1:	-0.022	-1.050
2:	-0.814	-0.566
3:	0.600	-0.308
4:	0.512	-0.147
5:	0.332	-0.055
6:	-0.184	-0.228
7:	0.041	0.302
8:	-0.210	0.175
9:	-0.018	-0.005
10:	0.524	1.422

X CENTROID: 0.076

Y CENTROID: -0.046

POA TO CENTROID: 0.089

HORZ SPREAD: 1.414

VERT SPREAD: 2.472

GROUP SPREAD: 2.532

MIN RADIUS: 0.103

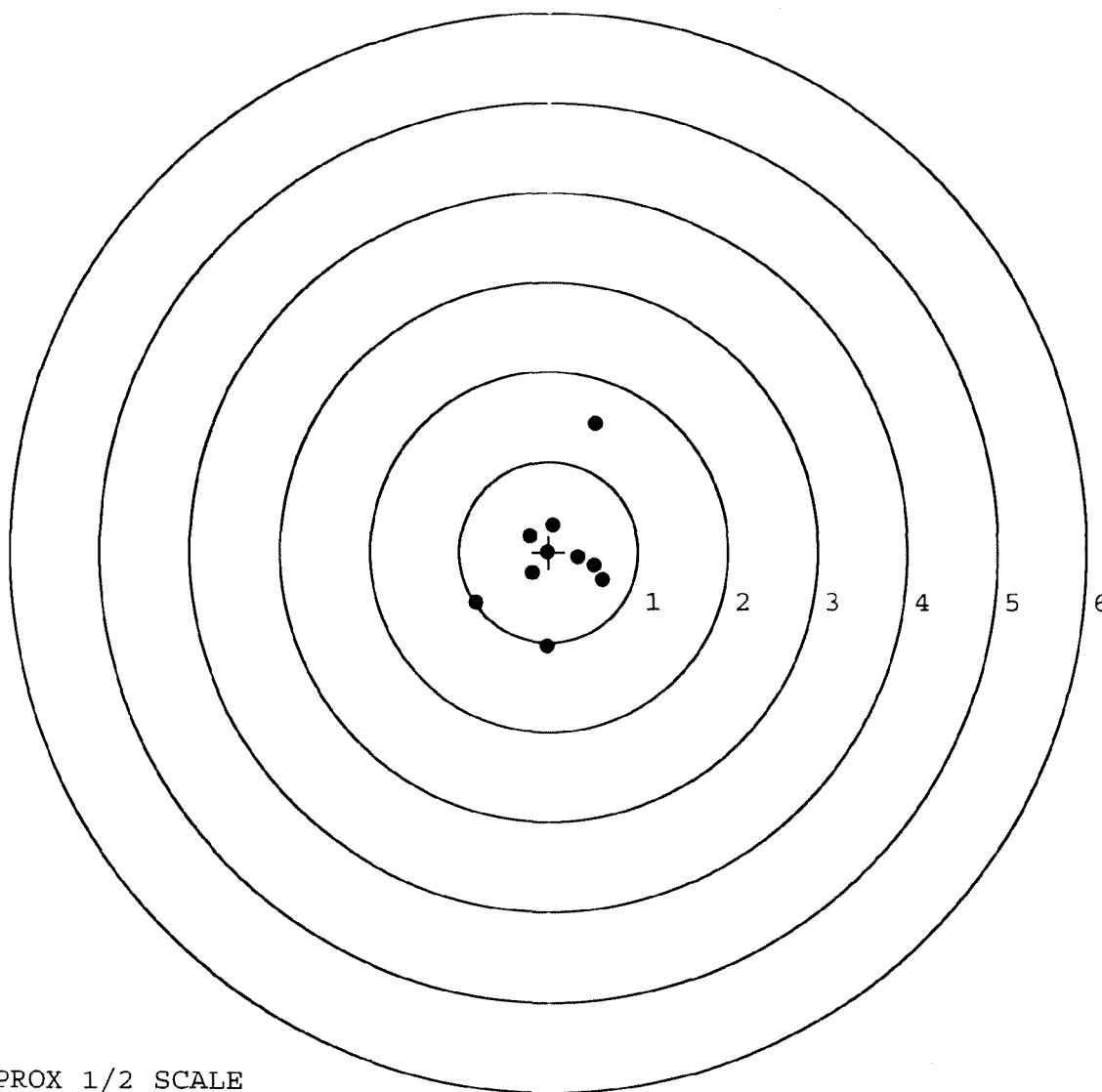
MAX RADIUS: 1.535

MEAN RADIUS: 0.600

IN 1 IN DIAMETER: 6

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6868473. 0

TARGET NUMBER: 2

FILE DATE: 08/20/2009

FILE TIME: 05:37

POINT#	X	Y
1:	-0.208	1.257
2:	0.176	0.785
3:	-1.105	-0.242
4:	-0.388	-0.367
5:	0.607	-0.074
6:	-0.003	-0.439
7:	0.179	-0.252
8:	0.088	-0.090
9:	0.302	0.064
10:	0.231	0.295

X CENTROID: -0.012

Y CENTROID: 0.094

POA TO CENTROID: 0.094

HORZ SPREAD: 1.712

VERT SPREAD: 1.696

GROUP SPREAD: 1.747

MIN RADIUS: 0.209

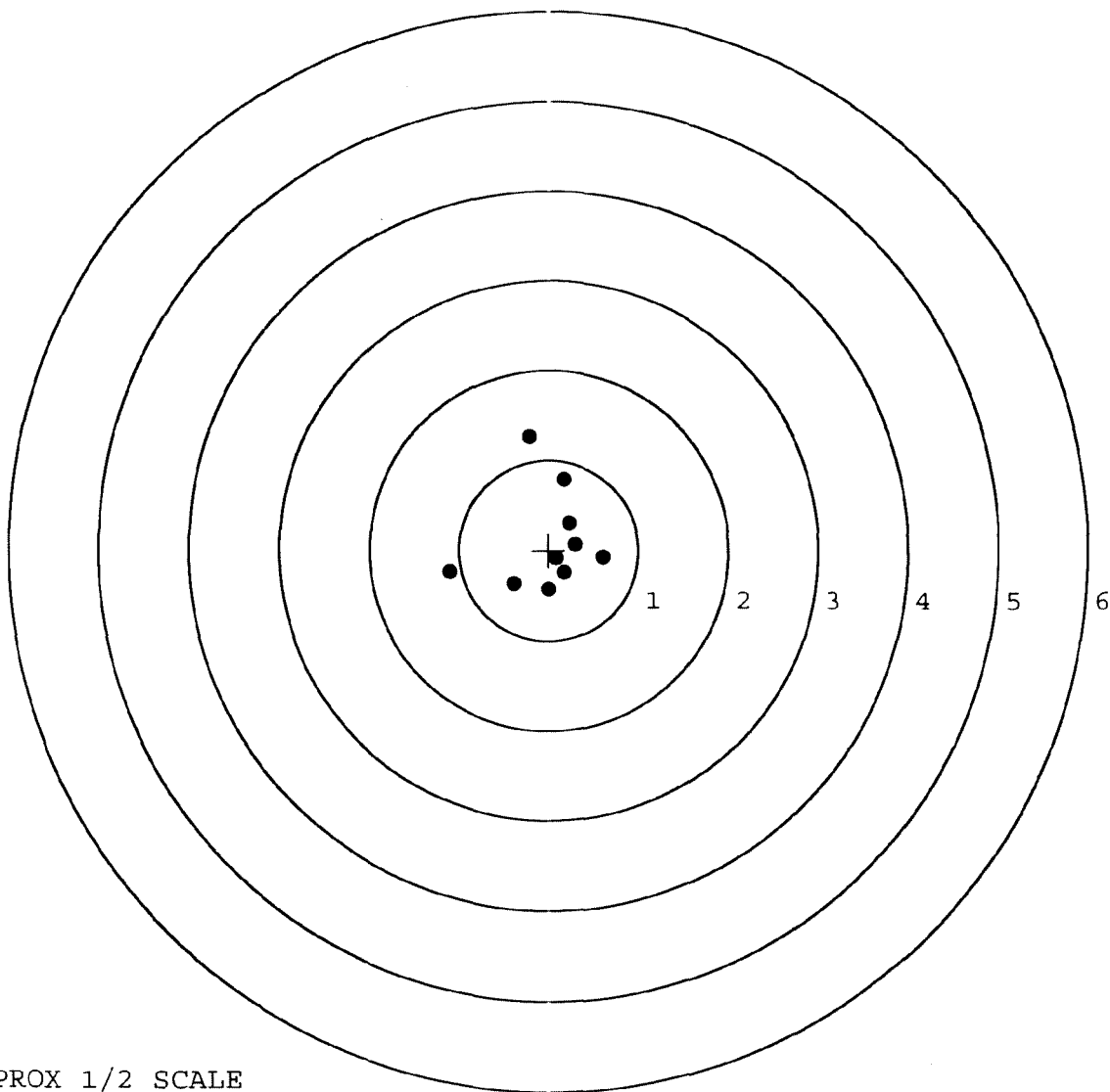
MAX RADIUS: 1.180

MEAN RADIUS: 0.604

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6868473. __0

TARGET NUMBER: 3

FILE DATE: 08/20/2009

FILE TIME: 05:37

POINT#	X	Y
1:	1.243	1.133
2:	0.774	0.589
3:	-0.101	1.148
4:	0.201	0.192
5:	-0.020	0.201
6:	-0.330	0.357
7:	0.379	-0.594
8:	0.026	-0.340
9:	-0.477	-0.545
10:	-0.467	-0.172

X CENTROID: 0.123

Y CENTROID: 0.197

POA TO CENTROID: 0.232

HORZ SPREAD: 1.720

VERT SPREAD: 1.742

GROUP SPREAD: 2.403

MIN RADIUS: 0.078

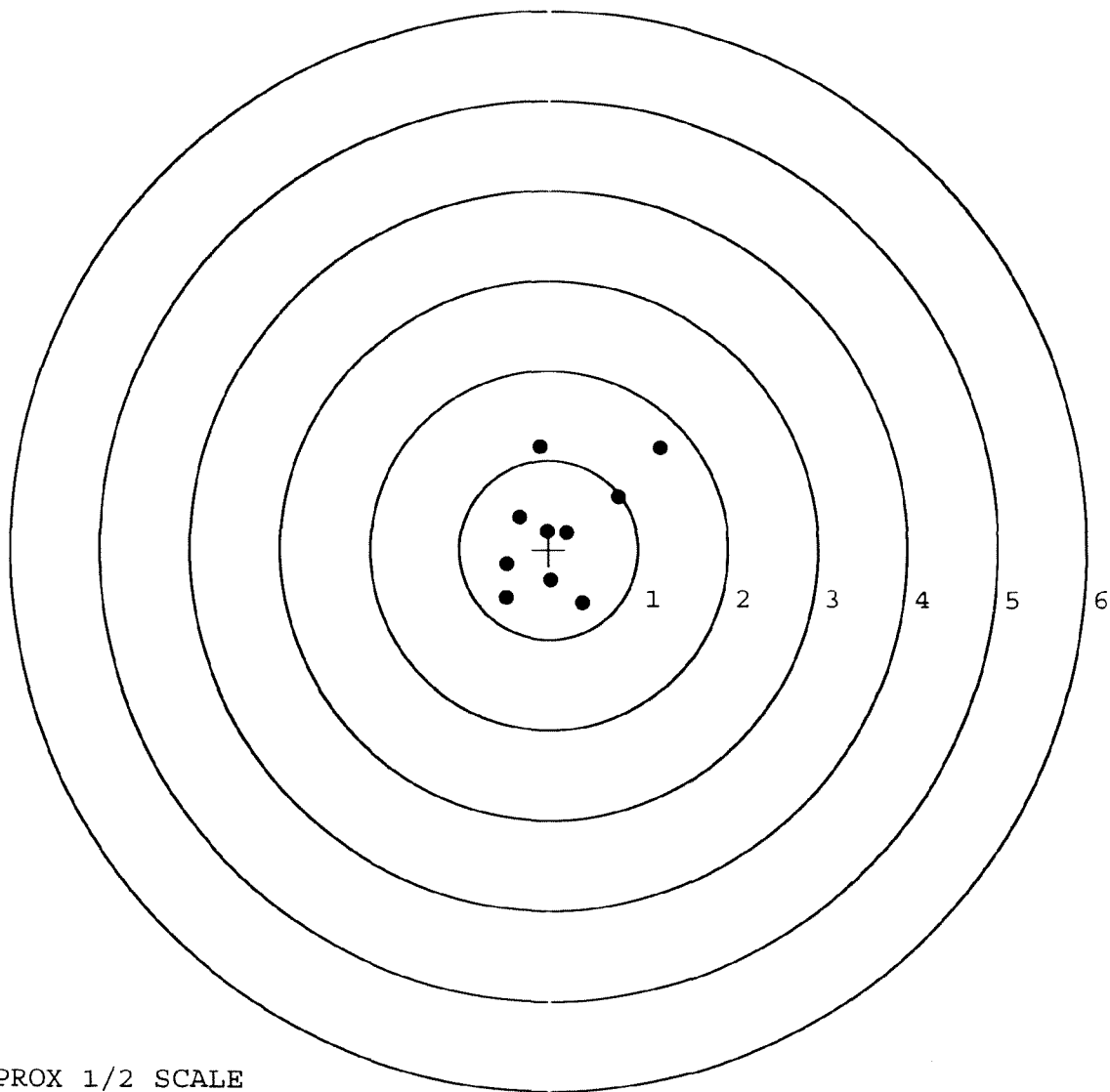
MAX RADIUS: 1.460

MEAN RADIUS: 0.693

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6868473. 0

TARGET NUMBER: 4

FILE DATE: 08/20/2009

FILE TIME: 05:37

POINT#	X	Y
1:	-0.221	0.568
2:	-0.593	-0.065
3:	-0.277	0.093
4:	0.001	-0.005
5:	-0.521	-0.578
6:	0.287	-0.710
7:	0.359	0.031
8:	0.739	0.279
9:	0.424	0.455
10:	0.643	0.271

X CENTROID: 0.084

Y CENTROID: 0.034

POA TO CENTROID: 0.091

HORZ SPREAD: 1.332

VERT SPREAD: 1.278

GROUP SPREAD: 1.524

MIN RADIUS: 0.092

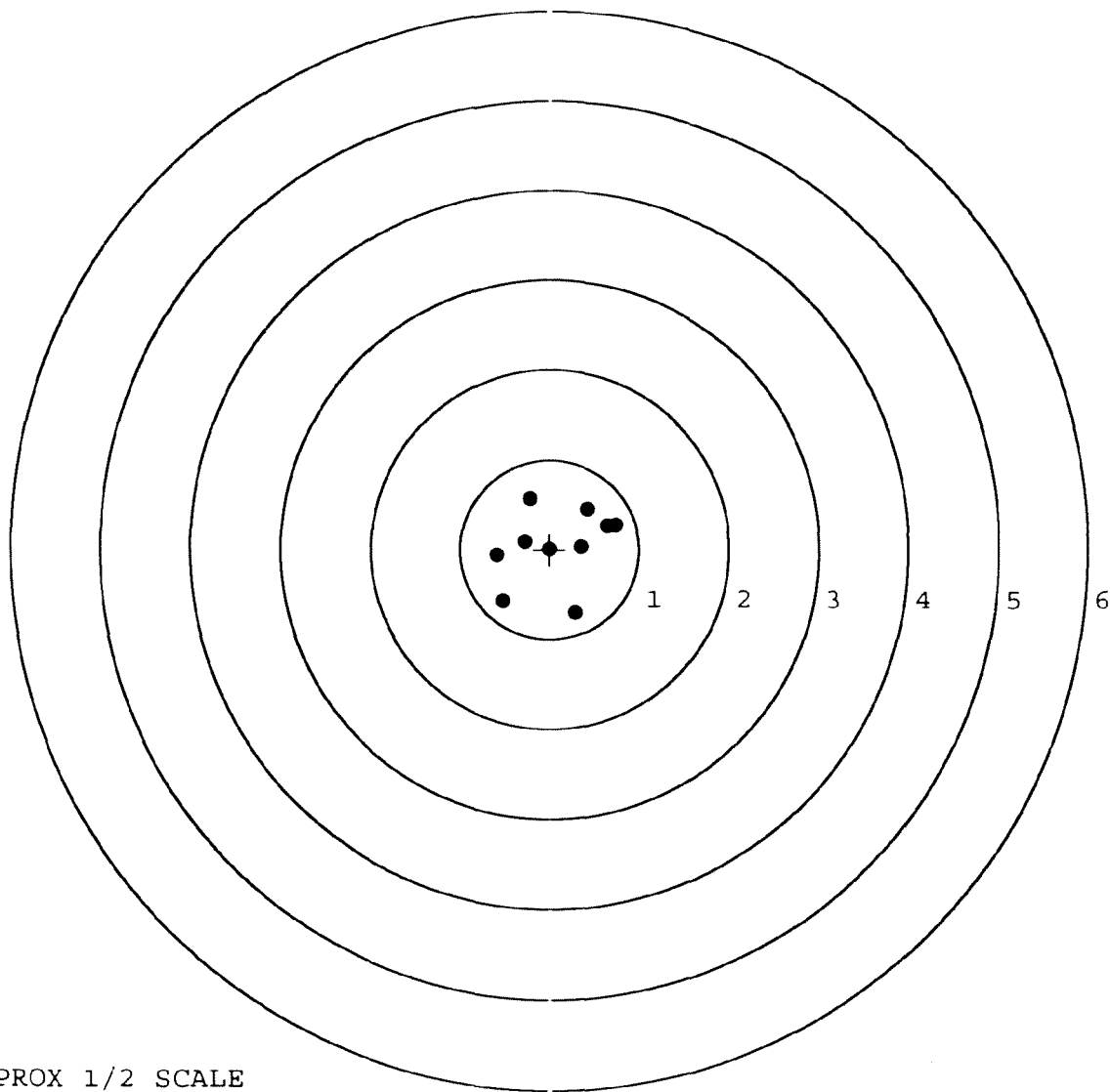
MAX RADIUS: 0.861

MEAN RADIUS: 0.551

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6868473. . 0

TARGET NUMBER: 5

FILE DATE: 08/20/2009

FILE TIME: 05:37

POINT#	X	Y
1:	0.477	0.783
2:	0.541	0.388
3:	0.302	0.360
4:	0.411	0.002
5:	0.289	-0.153
6:	-0.136	0.061
7:	-0.834	0.390
8:	-0.262	-0.373
9:	-0.502	-0.283
10:	-0.739	-0.596

X CENTROID: -0.045

Y CENTROID: 0.058

POA TO CENTROID: 0.074

HORZ SPREAD: 1.375

VERT SPREAD: 1.379

GROUP SPREAD: 1.839

MIN RADIUS: 0.091

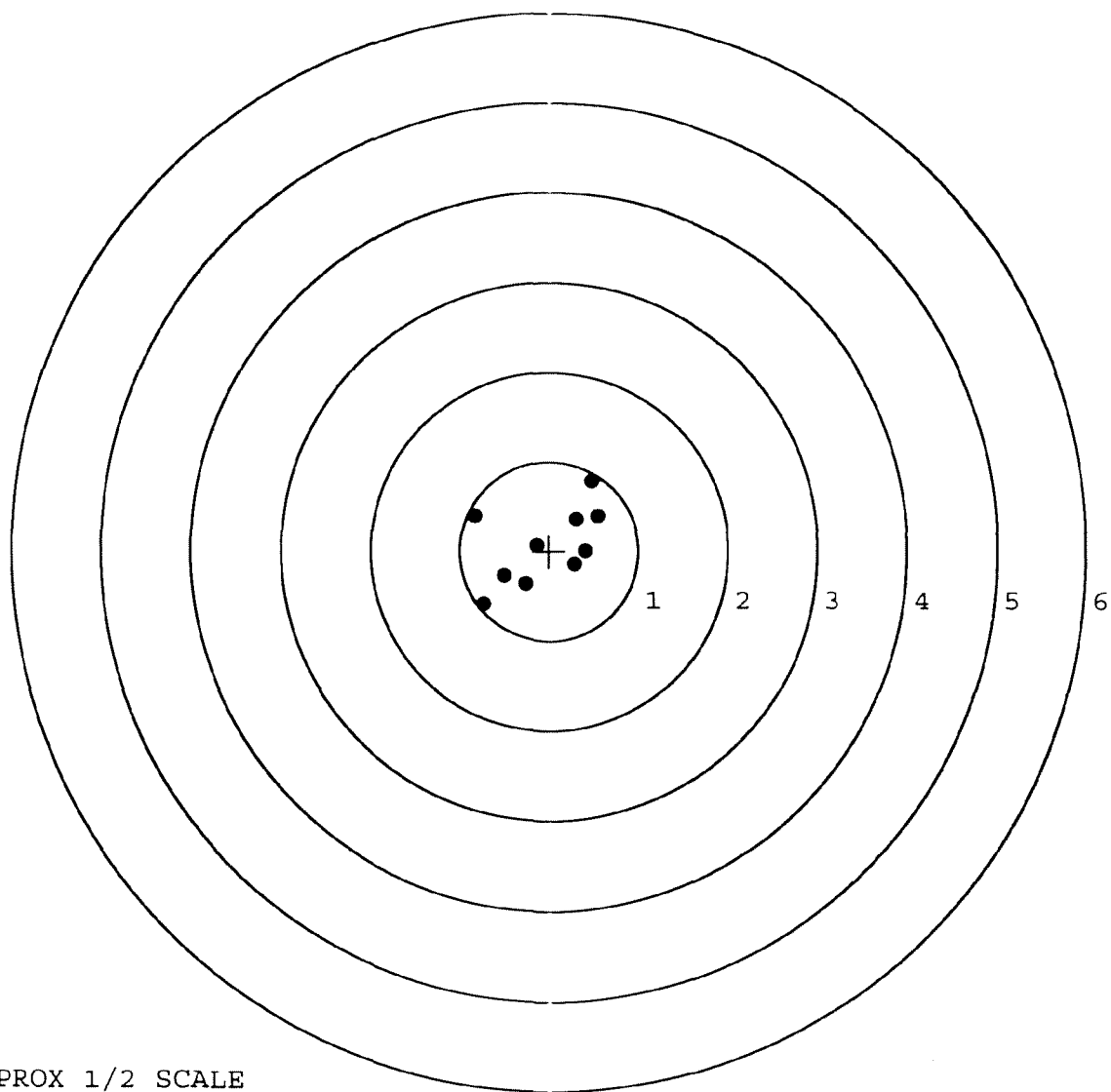
MAX RADIUS: 0.953

MEAN RADIUS: 0.583

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

Repair Number: RE00109527	Serial: C6587688 Model: M24 SWS Center Fire Caliber: 7.62 NATO	Repairman:	Status: Closed 3/7/2006 9:49:39 AM												
Verify Repair															
Address Information															
Customer: ☒ Received From		Return To: ☐ Received From													
Name: TRANSPORTATION OFFICER	TRANSPORTATION OFFICER														
Address 1: USPFO FOR ARKANSAS BLDG 318	USPFO FOR ARKANSAS BLDG 318														
Address 2: CAMP JOSEPH T ROBINSON	PO Box:	CAMP JOSEPH T ROBINSON	PO Box:												
City: NORTH LITTLE ROCK	NORTH LITTLE ROCK														
State: AR Zip Code: 72199 Country: US	State: AR Zip Code: 72199 Country: US														
FFL: ☐ ☐ ☐ ☐ ☐ ☐															
Contact / Condition	Problems	Estimate	History / Status												
Shipping / Billing															
Contact Information		Received Condition													
Phone: NA		Fair													
Fax:		Condition Notes:													
Email:		CSR Notes:													
Comments:															
		Accessories Received													
		<table border="1"><thead><tr><th>Code</th><th>Desc</th><th>Qty</th></tr></thead><tbody><tr><td>A007</td><td>With Stud</td><td>3</td></tr><tr><td>A017</td><td>Scope Base</td><td>1</td></tr><tr><td>A057</td><td>Fit and Rear Sgt Base</td><td>1</td></tr></tbody></table>		Code	Desc	Qty	A007	With Stud	3	A017	Scope Base	1	A057	Fit and Rear Sgt Base	1
Code	Desc	Qty													
A007	With Stud	3													
A017	Scope Base	1													
A057	Fit and Rear Sgt Base	1													
Repair Search		Refresh	Close												
naglet	3/7/2006	10:00 AM	C&PS												
NUM	INS	SCRL													

start | 3 Micr... | Part Se... | Arms S... | 3 Micr... | 4 Int... | Adobe ... | 10:00 AM

G653 5403 (New)

Serial Number: **C6587688**

Model: **M24 SWS**



RE00109527

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6535403.__0
FILE DATE AND TIME: 03/24/2006 15:15

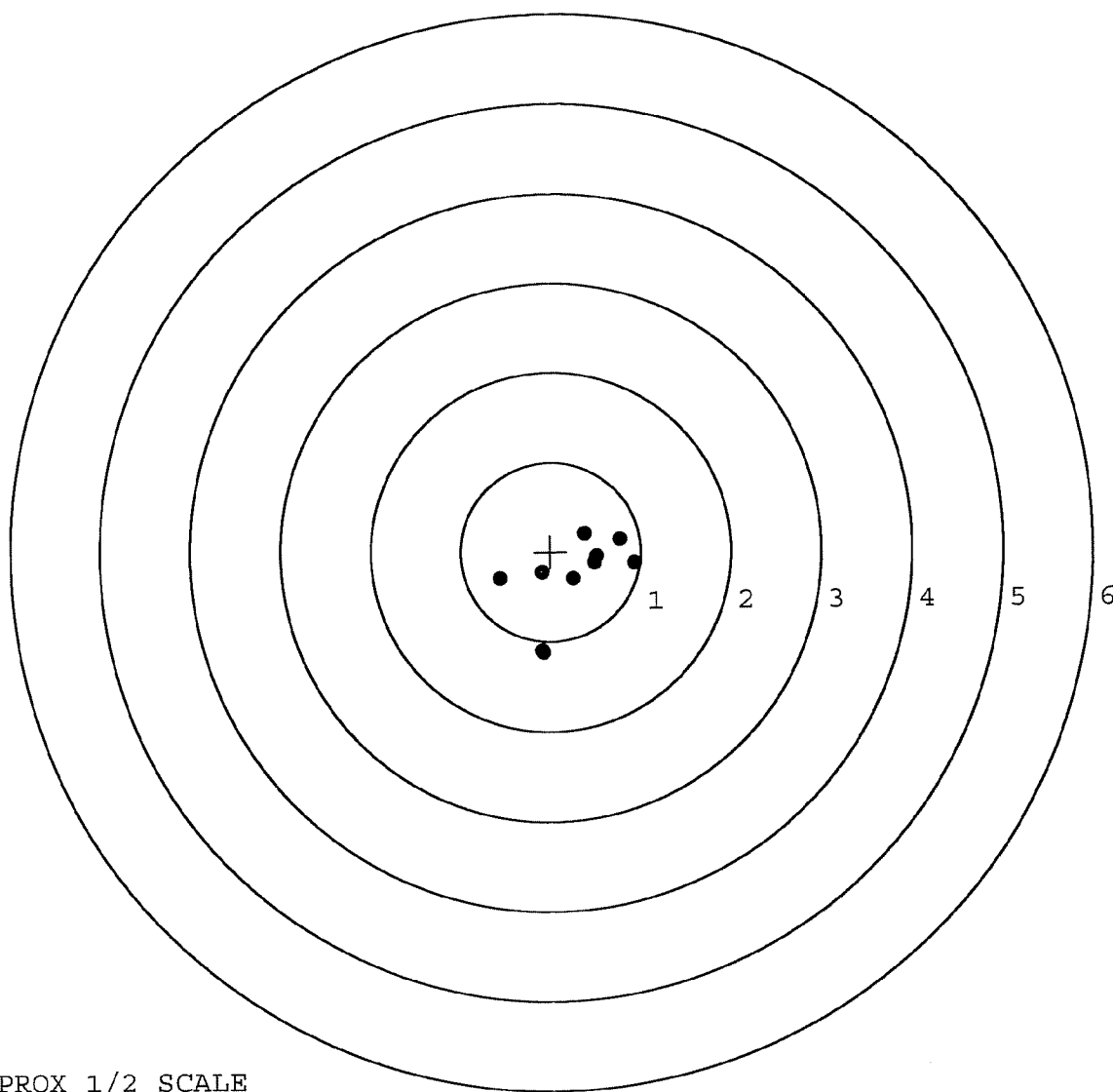
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.029
The Average Y Centroid of the Five Target Set:	0.057
The Average Point of Impact of the Five Target Set:	0.064
The Average Mean Radius of the Five Target Set:	0.703
The Distance from POA to Centroid Target #1:	0.395
The Distance from Centroid Target #2 to Centroid Target #1:	0.609
The Distance from Centroid Target #3 to Centroid Target #1:	0.748
The Distance from Centroid Target #4 to Centroid Target #1:	0.538
The Distance from Centroid Target #5 to Centroid Target #1:	0.329

SERIAL NUMBER: G6535403. __0
TARGET NUMBER: 1
FILE DATE: 03/24/2006
FILE TIME: 15:15

POINT#	X	Y
1:	-0.083	-1.129
2:	-0.098	-0.234
3:	0.255	-0.307
4:	0.493	-0.130
5:	0.384	0.204
6:	0.768	0.139
7:	0.929	-0.135
8:	0.518	-0.054
9:	-0.095	-1.108
10:	-0.566	-0.301

X CENTROID: 0.250
Y CENTROID: -0.305
POA TO CENTROID: 0.395
HORZ SPREAD: 1.495
VERT SPREAD: 1.333
GROUP SPREAD: 1.527
MIN RADIUS: 0.005
MAX RADIUS: 0.888
MEAN RADIUS: 0.551
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 10
in 3 IN DIAMETER: 10

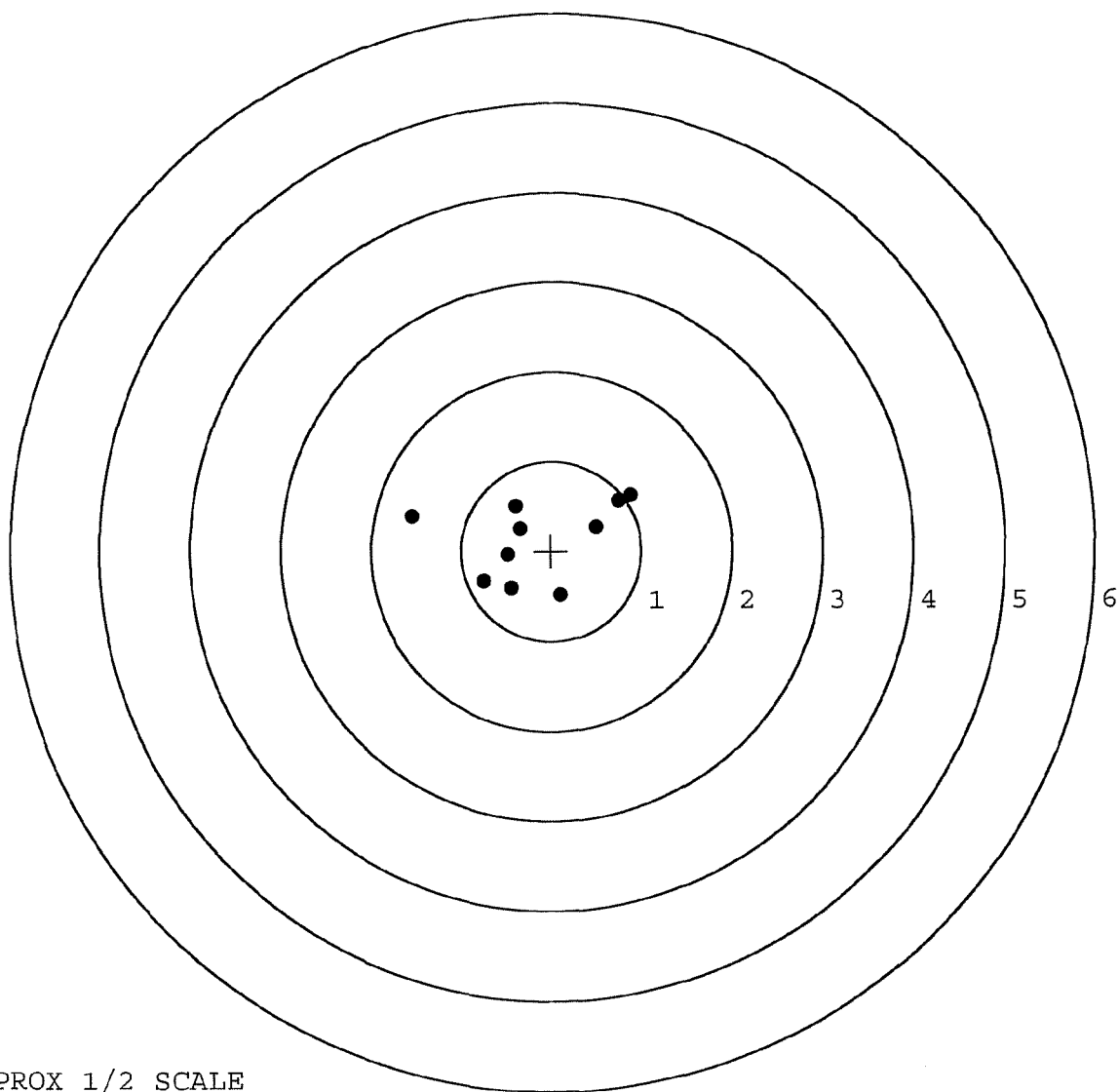


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6535403. __0
TARGET NUMBER: 2
FILE DATE: 03/24/2006
FILE TIME: 15:15

X CENTROID: -0.176
Y CENTROID: 0.130
POA TO CENTROID: 0.218
HORZ SPREAD: 2.430
VERT SPREAD: 1.117
GROUP SPREAD: 2.441
MIN RADIUS: 0.213
MAX RADIUS: 1.401
MEAN RADIUS: 0.730
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.497	0.267
2:	0.743	0.561
3:	0.878	0.623
4:	-0.394	0.501
5:	-0.352	0.248
6:	-0.485	-0.044
7:	-1.552	0.390
8:	-0.750	-0.339
9:	-0.442	-0.418
10:	0.101	-0.494

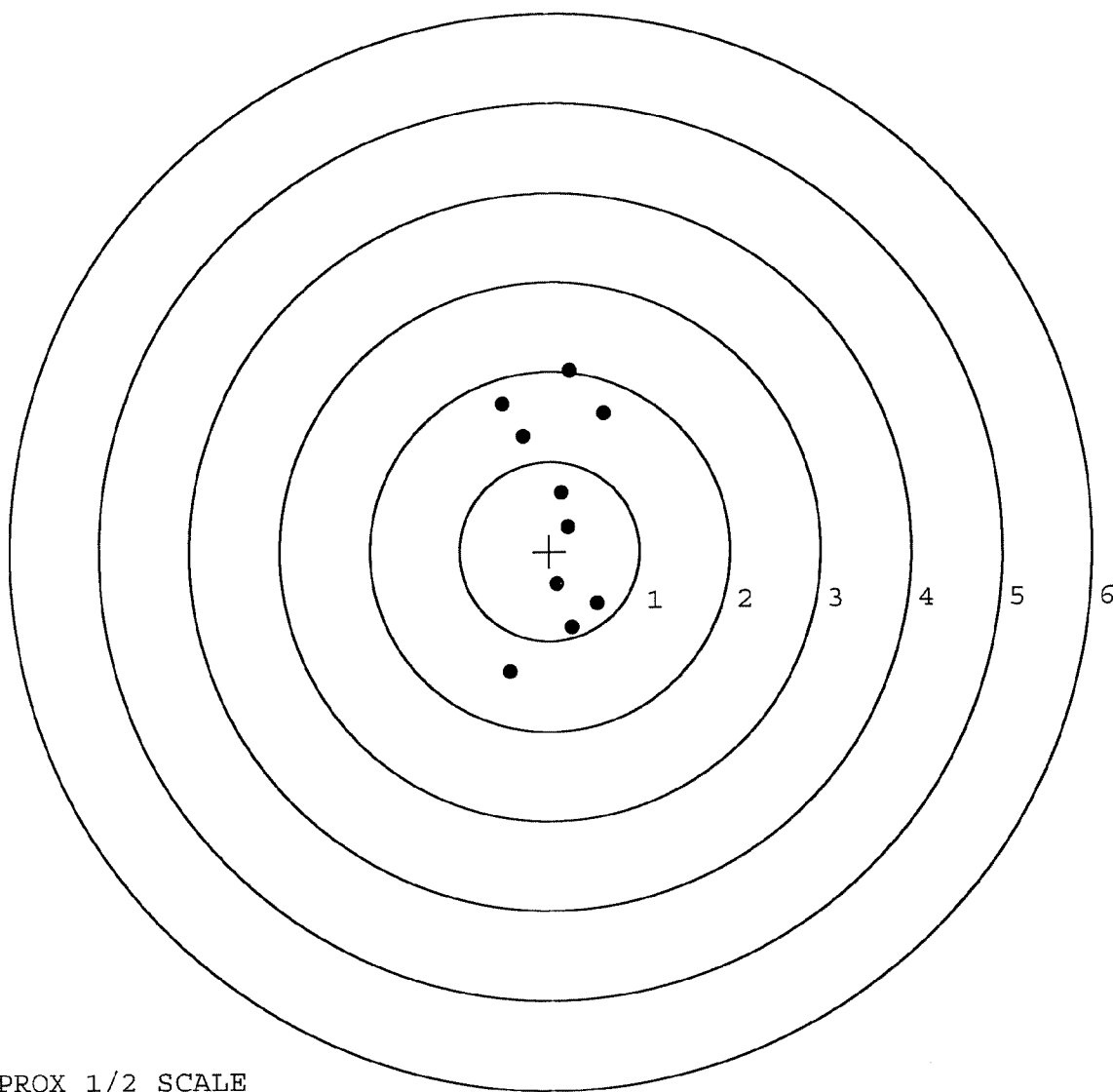


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6535403. __0
TARGET NUMBER: 3
FILE DATE: 03/24/2006
FILE TIME: 15:15

X CENTROID: 0.079
Y CENTROID: 0.422
POA TO CENTROID: 0.430
HORZ SPREAD: 1.126
VERT SPREAD: 3.345
GROUP SPREAD: 3.414
MIN RADIUS: 0.196
MAX RADIUS: 1.845
MEAN RADIUS: 1.058
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 4
in 3 IN DIAMETER: 8

POINT#	X	Y
1:	0.207	0.273
2:	0.135	0.653
3:	-0.289	1.284
4:	-0.517	1.641
5:	0.235	2.000
6:	0.609	1.532
7:	0.530	-0.589
8:	0.082	-0.367
9:	0.252	-0.859
10:	-0.450	-1.345

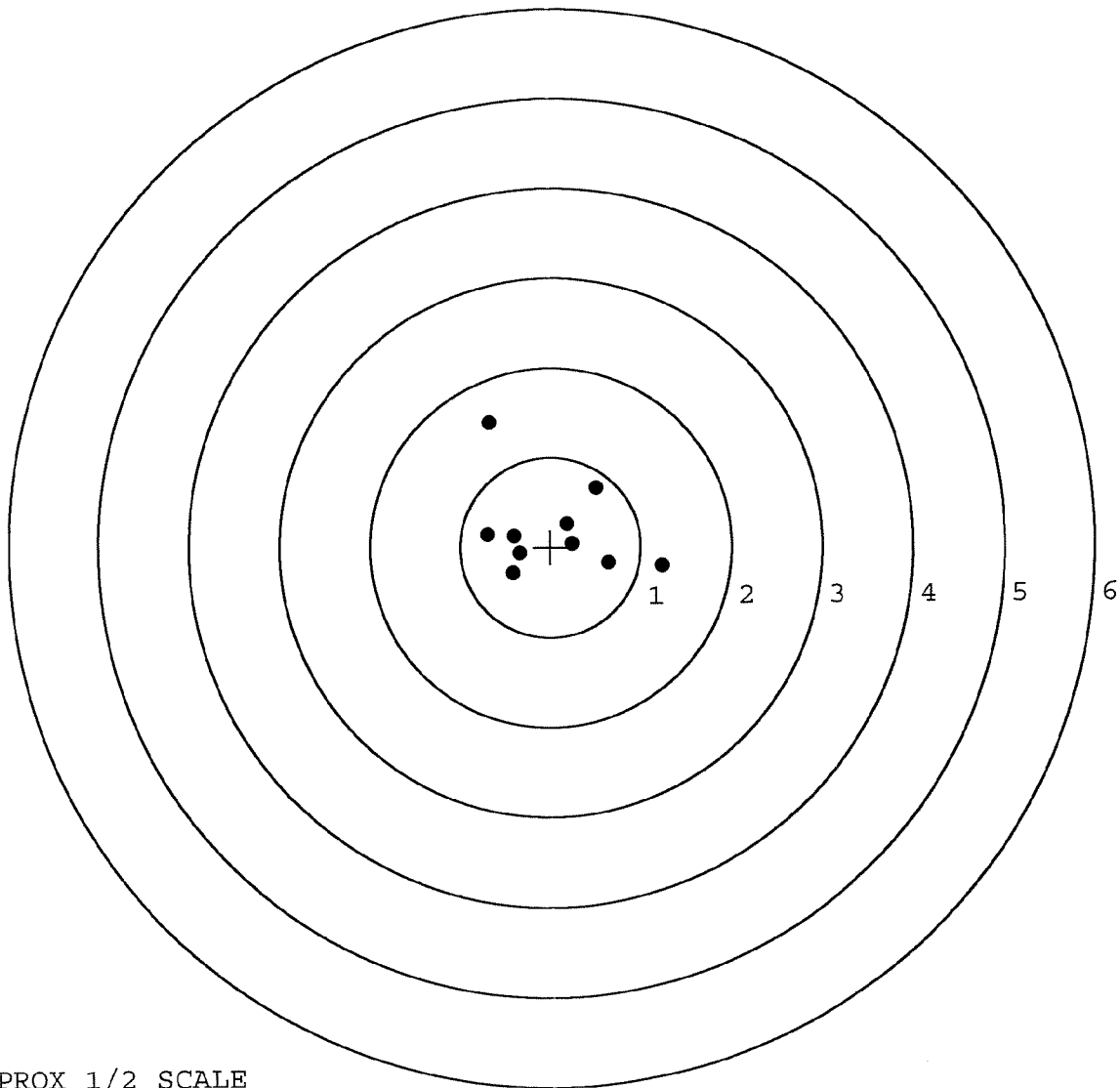


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6535403. __0
TARGET NUMBER: 4
FILE DATE: 03/24/2006
FILE TIME: 15:15

X CENTROID: 0.029
Y CENTROID: 0.184
POA TO CENTROID: 0.187
HORZ SPREAD: 1.932
VERT SPREAD: 1.686
GROUP SPREAD: 2.500
MIN RADIUS: 0.177
MAX RADIUS: 1.398
MEAN RADIUS: 0.677
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	1.234	-0.226
2:	0.645	-0.186
3:	0.244	0.037
4:	0.191	0.257
5:	0.509	0.660
6:	-0.668	1.396
7:	-0.698	0.144
8:	-0.401	0.123
9:	-0.343	-0.070
10:	-0.418	-0.290



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6535403. 0

TARGET NUMBER: 5

FILE DATE: 03/24/2006

FILE TIME: 15:15

POINT#	X	Y
1:	0.906	-0.396
2:	0.445	-0.395
3:	0.197	-0.130
4:	0.363	0.601
5:	-0.173	0.064
6:	-0.426	0.012
7:	-0.838	-0.466
8:	-0.384	-0.438
9:	-0.198	-0.240
10:	-0.270	-0.072

X CENTROID: -0.038

Y CENTROID: -0.146

POA TO CENTROID: 0.151

HORZ SPREAD: 1.744

VERT SPREAD: 1.067

GROUP SPREAD: 1.745

MIN RADIUS: 0.186

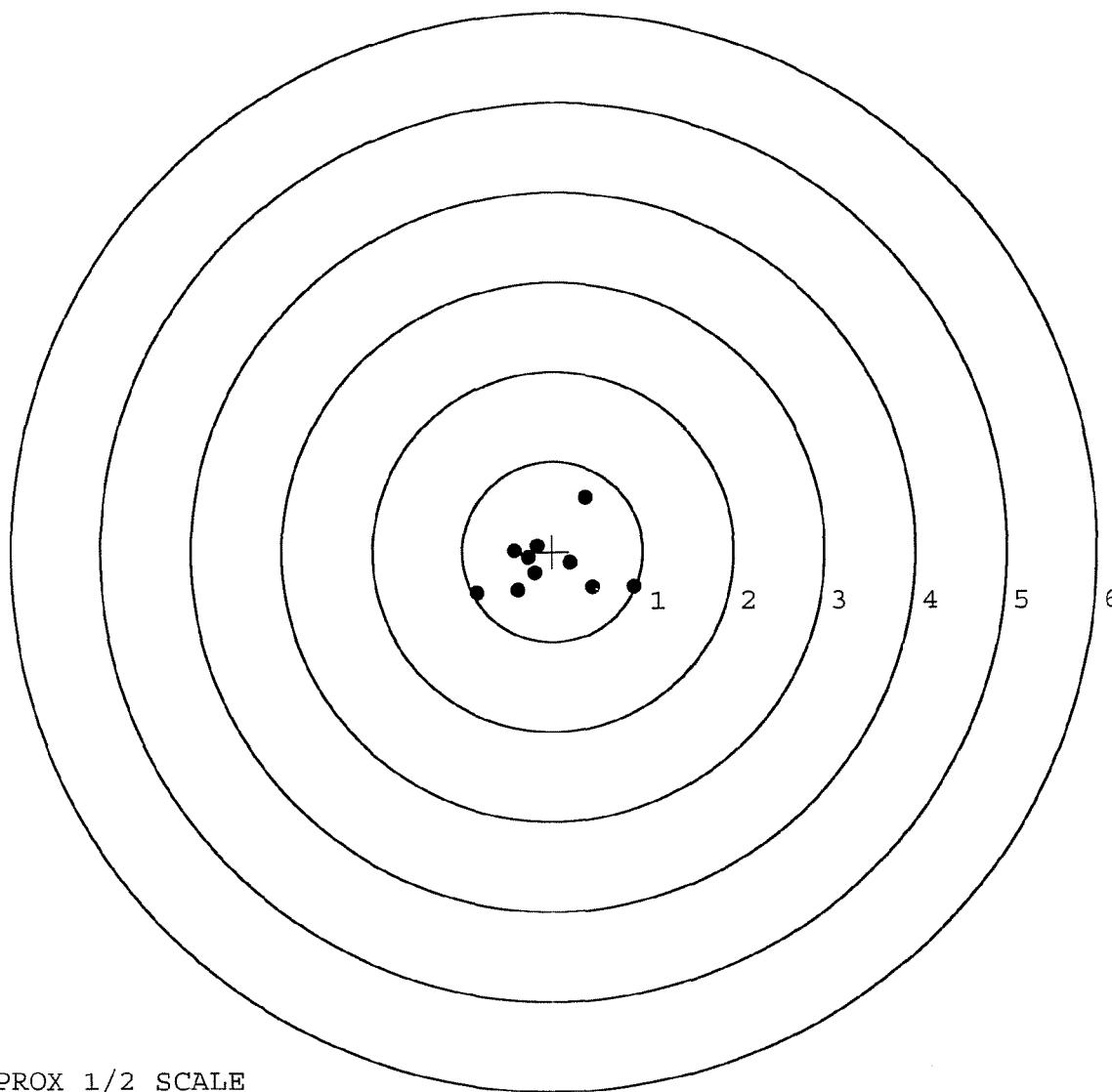
MAX RADIUS: 0.976

MEAN RADIUS: 0.502

IN 1 IN DIAMETER: 6

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10



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 3-24-06

TESTER TRW

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.70	2.65		2.77	
PULL #2	2.39	2.65		2.80	
PULL #3	2.72	2.57		2.79	
PULL #4	2.74	2.64		2.57	
PULL #5	2.47	2.73		2.17	
TOTAL	13.02	13.24		13.10	
AVERAGE	2.60	2.64		2.62	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.43	3.05		
PULL #2	3.08	3.03		
PULL #3	3.02	2.96		
PULL #4	3.53	3.03		
PULL #5	3.21	3.12		
TOTAL	16.27	15.19		
AVERAGE	3.25	3.03		

	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	4.42	4.18		4.52
PULL #2	4.27	4.29		4.36
PULL #3	4.29	4.16		4.26
PULL #4	4.30	3.94		4.31
PULL #5	4.27	4.22		4.33
TOTAL	21.55	20.79		21.78
AVERAGE	4.31	4.15		4.35

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

R & E NUMBER	109527		
SERIAL NUMBER	G0587688 G0535403 (NEW)		
LOG-IN DATE	3-7-06		
INSPECT AND VERIFY:			
OPERATION #	OPERATION NAME	DATE	INITIAL
550	DIS-ASSEMBLE GUN	3-9-06	RTZ
560 A	RE-BARREL	3-9-06	RTZ
B	DRILL AND TAP	3-17-06	TRW
575	ASSEMBLE	3-15-06	mm
600	PROOF	3-15-06	mm
605	CHECK HEADSPACE	3-15-06	RTZ
610	DIS-ASSEMBLE GUN	3-17-06	RTZ
612	MAGNAFLUX	3-20-06	APD
615	ROLLMARK CALIBER	3-20-06	CW
618	ROTO-BLAST	3-20-06	LB
620	APPLY COATINGS	3/21/06	BB
625 A	FINAL ASSEMBLY	3-23-06	RTZ
B	TRIGGER PULL TEST	3-20-06	AC
C	SAFETY "ON" FORCE	3-27-06	AC
D	SAFETY "OFF" FORCE	3-27-06	AC
E	FIRING PIN INDENT	3-27-06	AC
640	TARGET	3-24-06	AC
655	FINAL INSPECT	3-24-06	AC
660	PACK	4-6-06	DA
		SHIP DATE	
		QAR INSPECTION DATE	

Repair Inquiry

Repair Number: RE00068112

Serial: C6587688 Model 700 Center Fire Caliber: 7
62 NATO M/24 SWS

Repairman:

Verify Repair

Status:

Closed 7/28/2003 11:17:33 AM

Address Information

Customer:

☒ Received From

Return To:

☐ Received From

Name: USPFO FOR ARK

USPFO FOR ARK

Address 1: CAMP J T ROBINSON

CAMP J T ROBINSON

Address 2: PO Box

PO Box

City: NORTH LITTLE ROCK

NORTH LITTLE ROCK

State: AR Zip Code: 72119

Country: US

State: AR Zip Code: 72119

Country: US

FFL:

Contact / Condition

Problems

Estimate

History / Status

Shipping / Billing

Contact Information

Phone:

Fax:

Email:

Comments:

Received Condition

Fair

Condition
Notes:CSR
Notes:

Accessories Received

Code	Desc	Qty
A007	With Stud	3
A017	Scope Base	1
C000	FRONT AND REAR B.	1

Repair Search

Refresh

Close

naglej

7/28/2003

12:46 PM

CAPS

NUM

INS

SCRL

start

6 Mon

4 Mon

Arms Se..

My Exec

Info Hub

S Mgr

Part 532

12:46 PM

Serial Number: C6587688

Model: 700



RE00068112

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6587688.__0
FILE DATE AND TIME: 08/25/2003 03:47

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.094
The Average Y Centroid of the Five Target Set:	-0.062
The Average Point of Impact of the Five Target Set:	0.113
The Average Mean Radius of the Five Target Set:	0.748
The Distance from POA to Centroid Target #1:	0.052
The Distance from Centroid Target #2 to Centroid Target #1:	0.248
The Distance from Centroid Target #3 to Centroid Target #1:	0.160
The Distance from Centroid Target #4 to Centroid Target #1:	0.256
The Distance from Centroid Target #5 to Centroid Target #1:	0.258

SERIAL NUMBER: C6587688. __0

TARGET NUMBER: 1

FILE DATE: 08/25/2003

FILE TIME: 03:47

POINT#	X	Y
1:	1.505	0.779
2:	-0.224	1.453
3:	0.804	-0.233
4:	0.444	-0.186
5:	-0.422	0.333
6:	-0.645	-0.357
7:	-0.521	-1.049
8:	-0.302	-0.601
9:	-0.144	-0.327
10:	-0.016	-0.011

X CENTROID: 0.048

Y CENTROID: -0.020

POA TO CENTROID: 0.052

HORZ SPREAD: 2.150

VERT SPREAD: 2.502

GROUP SPREAD: 2.729

MIN RADIUS: 0.065

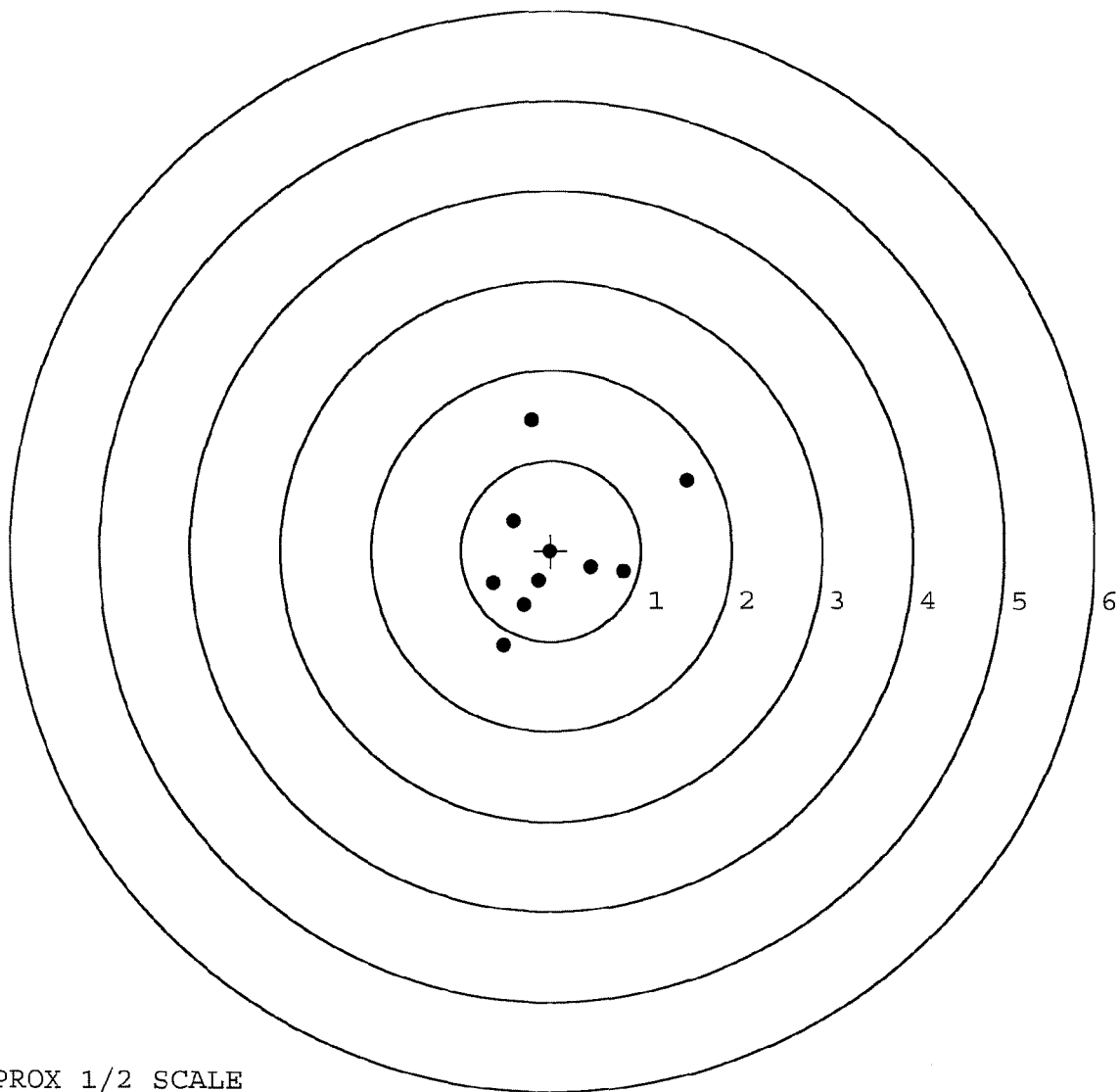
MAX RADIUS: 1.662

MEAN RADIUS: 0.801

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6587688. __0

TARGET NUMBER: 2

FILE DATE: 08/25/2003

FILE TIME: 03:47

POINT#	X	Y
1:	1.195	-0.423
2:	-0.154	-0.931
3:	-0.663	-0.945
4:	0.625	0.287
5:	0.258	0.028
6:	0.035	0.507
7:	-0.710	1.187
8:	-0.960	1.011
9:	-0.929	0.649
10:	0.009	0.170

X CENTROID: -0.129

Y CENTROID: 0.154

POA TO CENTROID: 0.201

HORZ SPREAD: 2.155

VERT SPREAD: 2.132

GROUP SPREAD: 2.589

MIN RADIUS: 0.139

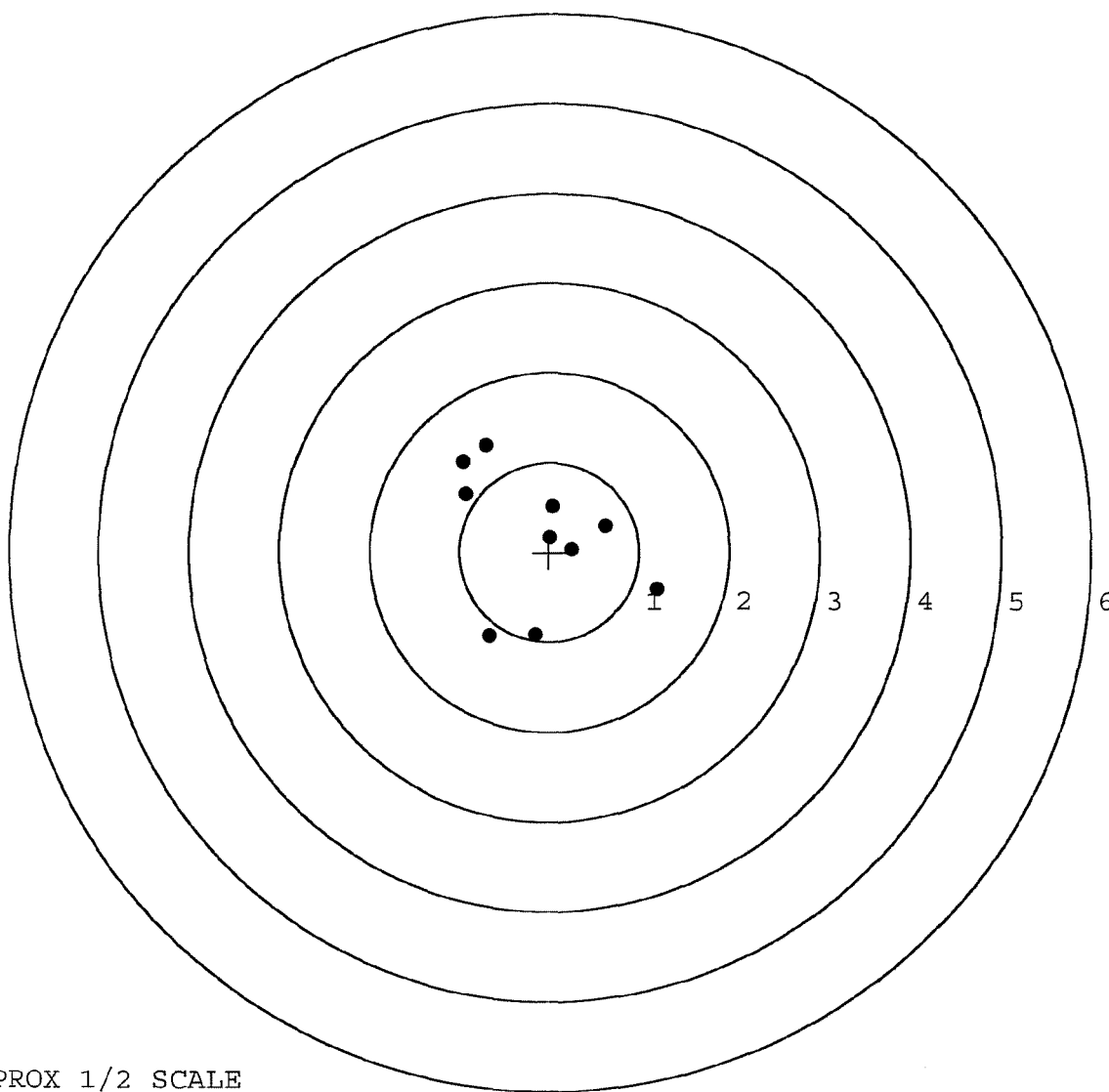
MAX RADIUS: 1.445

MEAN RADIUS: 0.877

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 5

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6587688. __0

TARGET NUMBER: 3

FILE DATE: 08/25/2003

FILE TIME: 03:47

POINT#	X	Y
1:	0.433	-0.702
2:	0.138	-0.714
3:	-0.234	-0.417
4:	0.099	-0.214
5:	0.604	-0.038
6:	0.556	0.114
7:	-0.398	0.024
8:	-0.339	0.312
9:	-0.761	0.434
10:	-0.865	0.006

X CENTROID: -0.077

Y CENTROID: -0.120

POA TO CENTROID: 0.142

HORZ SPREAD: 1.469

VERT SPREAD: 1.148

GROUP SPREAD: 1.648

MIN RADIUS: 0.200

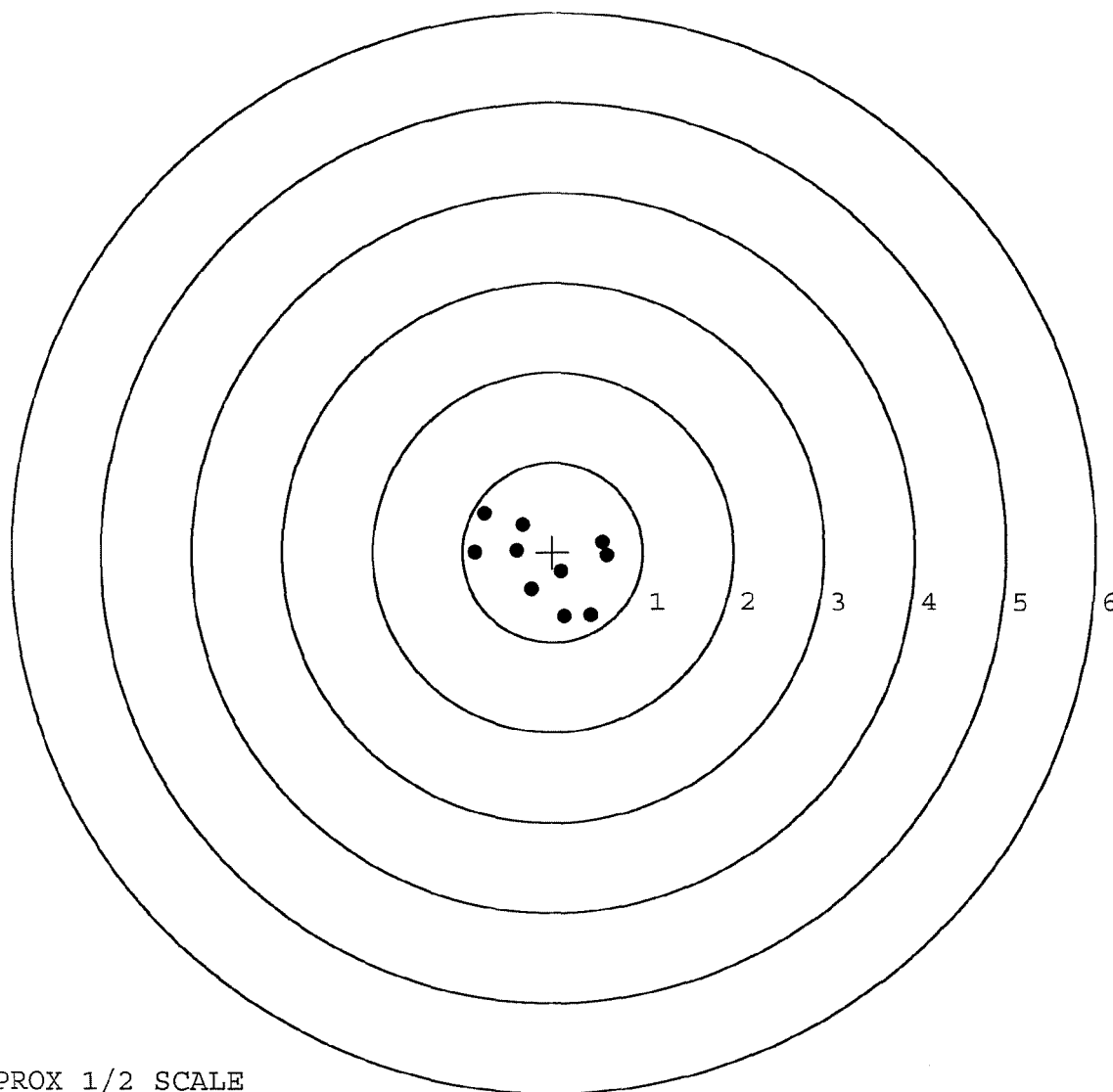
MAX RADIUS: 0.880

MEAN RADIUS: 0.584

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6587688. __0

TARGET NUMBER: 4

FILE DATE: 08/25/2003

FILE TIME: 03:47

X CENTROID: -0.117

Y CENTROID: -0.215

POA TO CENTROID: 0.245

HORZ SPREAD: 1.334

VERT SPREAD: 1.742

GROUP SPREAD: 1.794

MIN RADIUS: 0.308

MAX RADIUS: 0.978

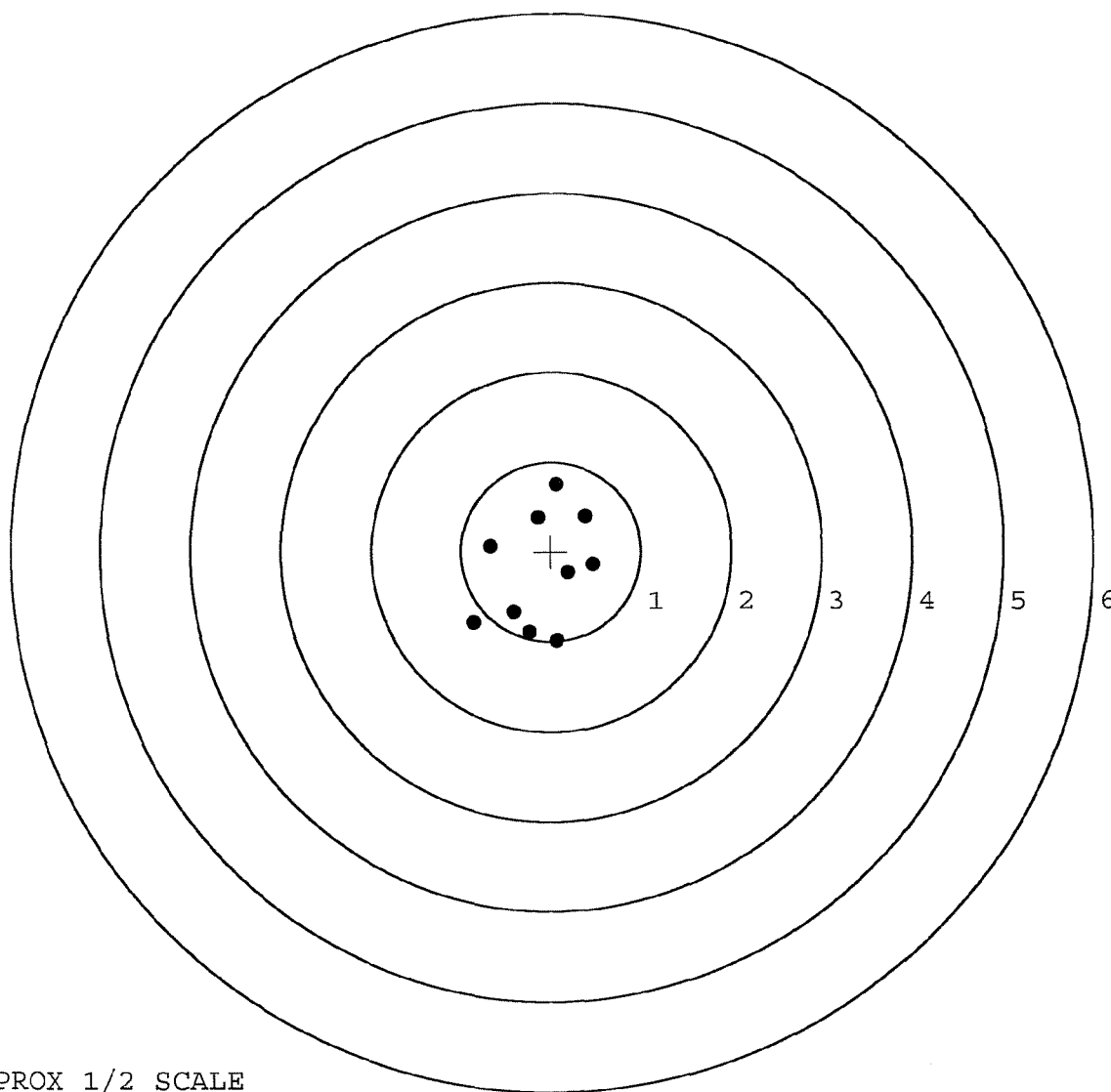
MEAN RADIUS: 0.689

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.071	-0.995
2:	-0.241	-0.902
3:	-0.416	-0.677
4:	-0.862	-0.794
5:	-0.673	0.062
6:	0.190	-0.235
7:	0.472	-0.142
8:	0.385	0.402
9:	-0.153	0.383
10:	0.056	0.747



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6587688. 0

TARGET NUMBER: 5

FILE DATE: 08/25/2003

FILE TIME: 03:47

POINT#	X	Y
1:	-0.030	-1.082
2:	-0.016	-0.794
3:	-0.442	-0.927
4:	-0.232	-0.264
5:	0.480	-0.374
6:	0.582	-0.045
7:	-0.458	1.009
8:	-0.740	0.589
9:	-1.135	0.889
10:	0.058	-0.117

X CENTROID: -0.193

Y CENTROID: -0.112

POA TO CENTROID: 0.223

HORZ SPREAD: 1.717

VERT SPREAD: 2.091

GROUP SPREAD: 2.260

MIN RADIUS: 0.157

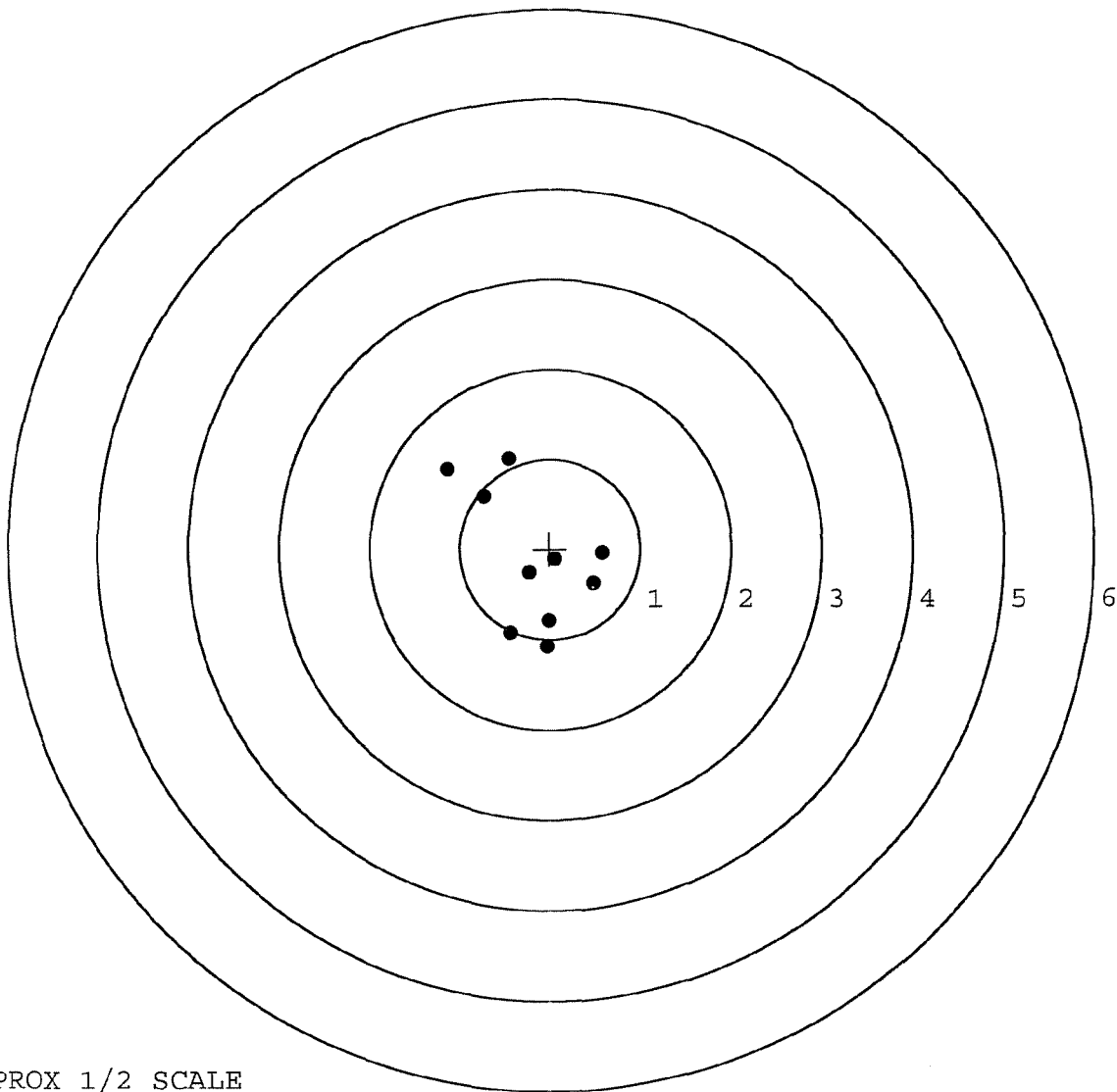
MAX RADIUS: 1.374

MEAN RADIUS: 0.787

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

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

SERIAL # C6587688 INSPECTED BY: RTL

DATE REC'D: 7-28-03 DATE RET'D: 8-23-03

ITEM

BARREL ASSEMBLY

☒ BARREL
☒ RECEIVER
☒ FRONT SIGHT BASE
☒ REAR SIGHT BASE
☒ SCREWS
☒ FINISH

SCOPE ASSEMBLY

☐ SCOPE
☐ SCOPE RINGS
☐ MOUNTING SCREWS
☐ MOUNTING BASE
☐ SCREWS
☐ FINISH
☐ CLARITY

ITEM

STOCK ASSEMBLY

☒ STOCK
☒ SLING AWIVEL STUDS
☒ ADJUSTABLE
☒ BUTT PLATE
☒ LOCK NUTS
☒ BARREL CLEARANCE
☒ COLOR / FINISH

SYSTEMS CASE

☐ SCOPE CASE
☐ IRON SIGHTS
☐ DEPLOYMENT KIT

TRIGGER ASSEMBLY

☒ SAFETY OPERATION
☒ RE-SET TO FACTORY SPECS

COMMENTS:

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

R & E NUMBER	68112		
SERIAL NUMBER	C6587688		
LOG-IN DATE	7-28-03		
INSPECT AND VERIFY:			
OPERATION #	OPERATION NAME	DATE	INITIAL
550	DIS-ASSEMBLE GUN	RTL	7-30-03
560 A	RE-BARREL	8-7-03	RTL
B	DRILL AND TAP	8-11-03	TRW
575	ASSEMBLE	8-11-03	RTL
600	PROOF	8-11-03	AC
605	CHECK HEADSPACE	8-11-03	AC
610	DIS-ASSEMBLE GUN	8-11-03	RTL
612	MAGNAFLUX		
615	ROLLMARK CALIBER	8-12-03	SB
618	ROTO-BLAST	8-13-03	JB
620	APPLY COATINGS	8-14	TA
625 A	FINAL ASSEMBLY	8-19-03	Rur
B	TRIGGER PULL TEST		
C	SAFETY "ON" FORCE		
D	SAFETY "OFF" FORCE		
E	FIRING PIN INDENT		
640	TARGET	8-25-03	AC
655	FINAL INSPECT	8-25-03	RTL
660	PACK	8-25-03	AA
		SHIP DATE	
	QAR INSPECTION DATE		

Remington
 MODEL 700™ M24

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

REG. U.S. PAT. & TM. OFF.

SERIAL NO.
 C6587688

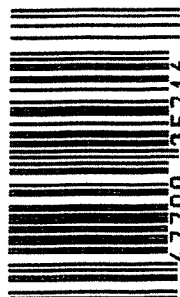
ORDER NO.
 5716

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



5716 C6587688

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6587688

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	10 9 90	10/9/90	RW
600	Proof	10 9 90	10/9/90	RW
607	Check Headspace	10 9 90	10/9/90	RW
610	Dis-assemble Gun	10 9 90	10/9/90	RW
612	Magnaflux Barrel Action		10/11/90	KR
	Magnaflux Bolt		10/11/90	KR
615	Rollmark Caliber		10/11/90	GS
617	Drill and Tap Sight Holes		10/11/90	LB
618	Polish Barrel		10/12/90	WB
620	Apply Coatings (Barrel Action)		10/18/90	TH
	Apply Coating (Bolt)		10/18/90	TH
625	Final Assembly			
	A) Clean inside of Bolt Assembly		10/22/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/22/90	RW
	C) Inspect Ejector Hole for Chamfer		10/22/90	RW
	D) Oil Firing Pin Ass'y		10/22/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		11/5/90	TH

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4 1/2	4 1/2	4 1/2			11/5/90	WB
	G) Safety Off Force	2 3/4	2 3/4	2 3/4			11/5/90	WB
	H) Trigger Pull Test & Retainability						11/5/90	JH
	I) Firing Pin Indent	.0235	.023	.023			11/5/90	WB
	J) Assemble Stock						11/5/90	RW
	K) Assemble Swivel Studs						11-20-90	DH
	L) Attach Front and Rear Sight Assemblies						11/5/90	RW
	M) Iron Sight Alignment						11/5/90	RW
	N) Detach Front & Rear Sights & place in numbered container						11/5/90	RW
	O) Attach Scope to Rifle						11/5/90	RW
	P) Detach & Attach Scope 20 Times						11/5/90	RW
640	Gallery Target & Test						11-7-90	AC
	A) Time						11-7-90	AC
	B) Malfunctions						11-7-90	AC
	C) Pierced Primers						11-7-90	AC
	D) Optical Clarity of Scope						11-7-90	AC
645	Inspect for Live Ammo						11-7-90	AC
655	Final Inspection							
	A) Headspace						11-20-90	DH
	B) Trigger Pull	229	230	233	230	231	11-20-90	DH
	C) Function						11-20-90	DH
660	Pack						12/14/90	NF

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C6587688

DATE 11-5-90

TESTER JLL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.23	2.45	2.46	2.29	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.49	2.36	2.40	2.30	
PULL #3	2.48	2.33	2.36	2.33	
PULL #4	2.42	2.32	2.38	2.30	
PULL #5	2.51	2.42	2.40	2.31	
TOTAL	12.13	11.88	12.00		
AVG.	2.426	2.376	2.40		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.48	3.43		
PULL #2	3.49	3.45		
PULL #3	3.36	3.44		
PULL #4	3.45	3.45		
PULL #5	3.29	3.47		
TOTAL	17.07	17.24		
AVG.	3.414	3.448		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.39	4.40		4.44
PULL #2	4.35	4.38		4.47
PULL #3	4.43	4.45		4.20
PULL #4	4.45	4.46		4.40
PULL #5	4.45	4.43		4.37
TOTAL	22.07	22.12		21.88
AVG.	4.414	4.424		4.376

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6587688
7 Nov 1990

CENTROIDAL DISTANCES

0 TO	1	.03245
1 TO	2	.0854751
1 TO	3	.320351
1 TO	4	.185691
1 TO	5	.149803

$\frac{4}{3}$ <----FOR

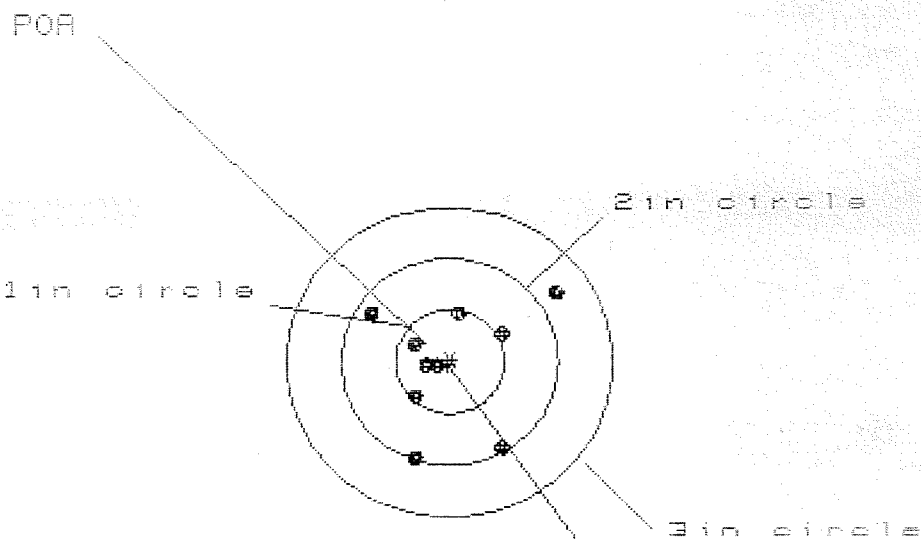
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0334
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0062
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0339706
THE AMR FOR THIS RIFLE IS: .7902

7 Nov 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C65876B8

CENTERFIRE PATTERNS

1



OF SHOTS- 10

IN CIR

1in = 4

2in = 8

3in = 10

HS= 1.721

VS= 1.604

GS= 2.045

CENTROID *

PATTERN #

1

SHOTS (BEST OF)

10

9

8

MAXIMUM X

.996

.566

.546

MINIMUM X

-.725

-.615

-.635

MAXIMUM Y

.679

.571

.465

MINIMUM Y

-.925

-.850

-.816

CENTROID X

.010

-.092

-.072

CENTROID Y

.027

-.048

.058

POA TO CENTROID in.

.033

.104

.093

MIN RADIUS

.114

.032

.076

MEAN RADIUS

.618

.525

.477

MAX RADIUS

1.205

.908

.982

HORIZONTAL SPREAD

1.721

1.181

1.181

VERTICAL SPREAD

1.604

1.421

1.281

EXTREME SPREAD

2.045

1.739

1.739

NUMBER IN ONE INCH CIRCLE =

4

NUMBER IN TWO INCH CIRCLE =

9

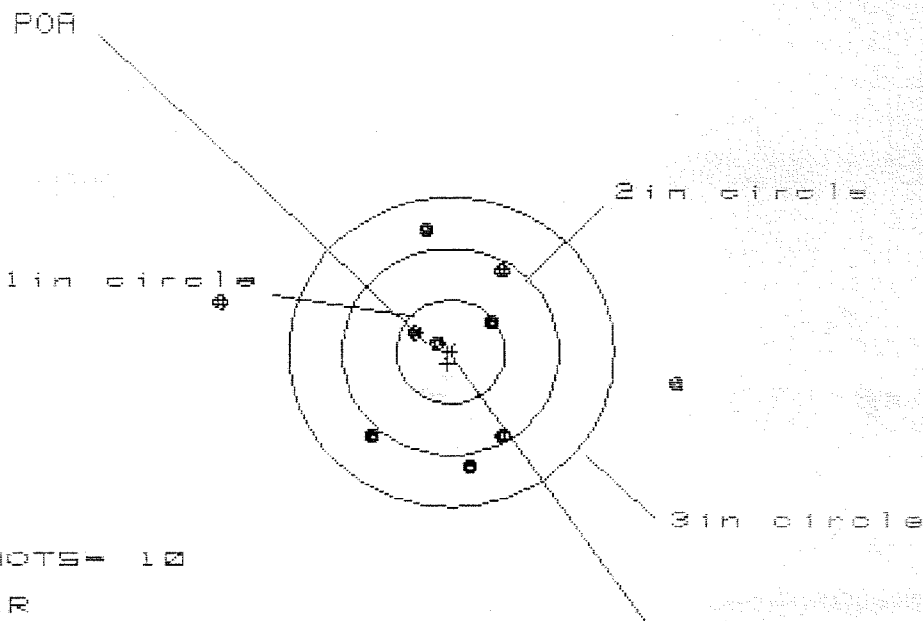
NUMBER IN THREE INCH CIRCLE =

10

7 May 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C65876B8

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1 in = 3

2 in = 5

3 in = 8

HS= 4.247

VS= 2.295

ES= 4.328

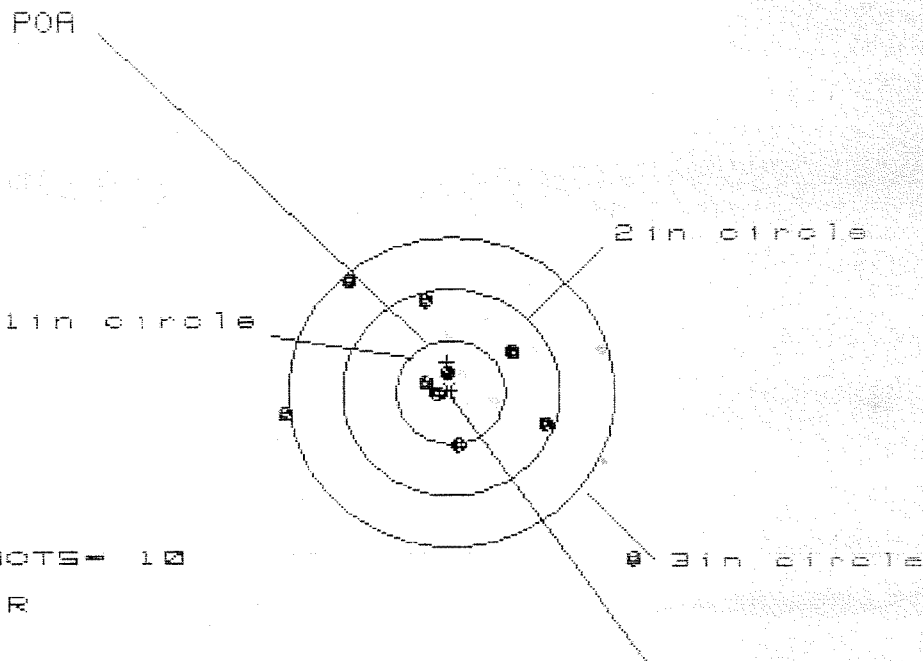
CENTROID *

PATTERN #	:	2	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.075	1.834	.486
MINIMUM X	:	-2.172	-.962	-.733
MAXIMUM Y	:	1.205	1.258	1.220
MINIMUM Y	:	-1.090	-1.037	-1.075
CENTROID X	:	.027	.268	.039
CENTROID Y	:	.112	.059	.097
POA TO CENTROID in.	:	.115	.275	.105
MIN RADIUS	:	.091	.335	.109
MEAN RADIUS	:	1.056	.943	.782
MAX RADIUS	:	2.224	1.859	1.247
HORIZONTAL SPREAD	:	4.247	2.796	1.219
VERTICAL SPREAD	:	2.295	2.295	2.295
EXTREME SPREAD	:	4.328	2.832	2.341
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

7 Nov 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6587688

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1 in = 3

2 in = 7

3 in = 8

HS= 3.172

VS= 2.604

GS= 3.674

CENTROID #

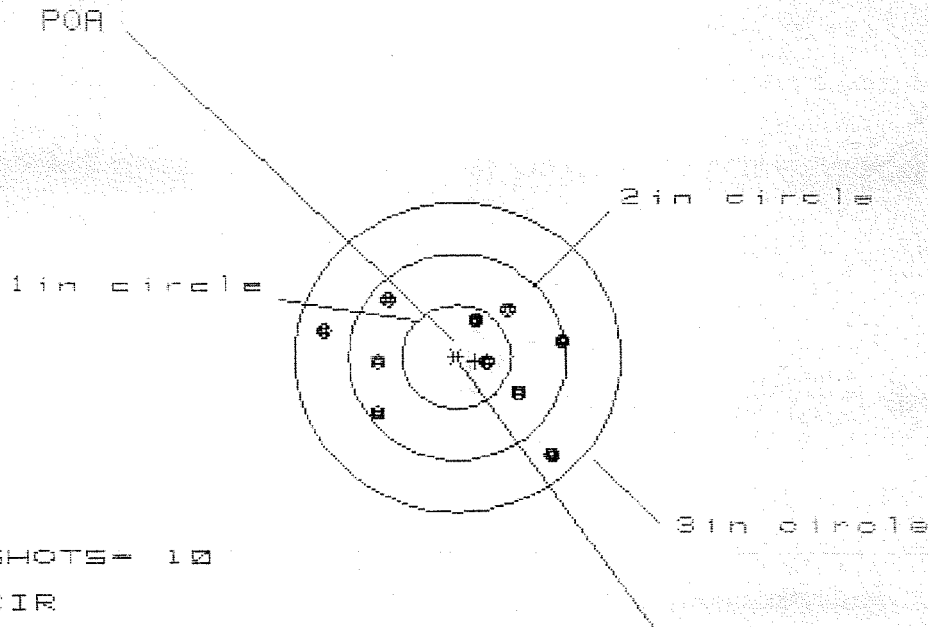
PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.622	1.074	.903
MINIMUM X	:	-1.550	-1.370	-.961
MAXIMUM Y	:	1.045	.872	.823
MINIMUM Y	:	-1.559	-.716	-.765
CENTROID X	:	.033	-.147	.024
CENTROID Y	:	-.293	-.120	-.071
POA TO CENTROID in.	:	.295	.190	.075
MIN RADIUS	:	.138	.121	.053
MEAN RADIUS	:	.897	.719	.620
MAX RADIUS	:	2.249	1.426	1.265
HORIZONTAL SPREAD	:	3.172	2.444	1.864
VERTICAL SPREAD	:	2.604	1.588	1.588
EXTREME SPREAD	:	3.674	2.447	2.319
NUMBER IN ONE INCH CIRCLE =			3	
NUMBER IN TWO INCH CIRCLE =			7	
NUMBER IN THREE INCH CIRCLE =			8	

7 Nov 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C8587668

CENTERFIRE PATTERNS

4



OF SHOTS= 10

IN CIR

1 in = 2

2 in = 8

3 in = 10

HS= 2.240

VS= 1.583

CS= 2.447

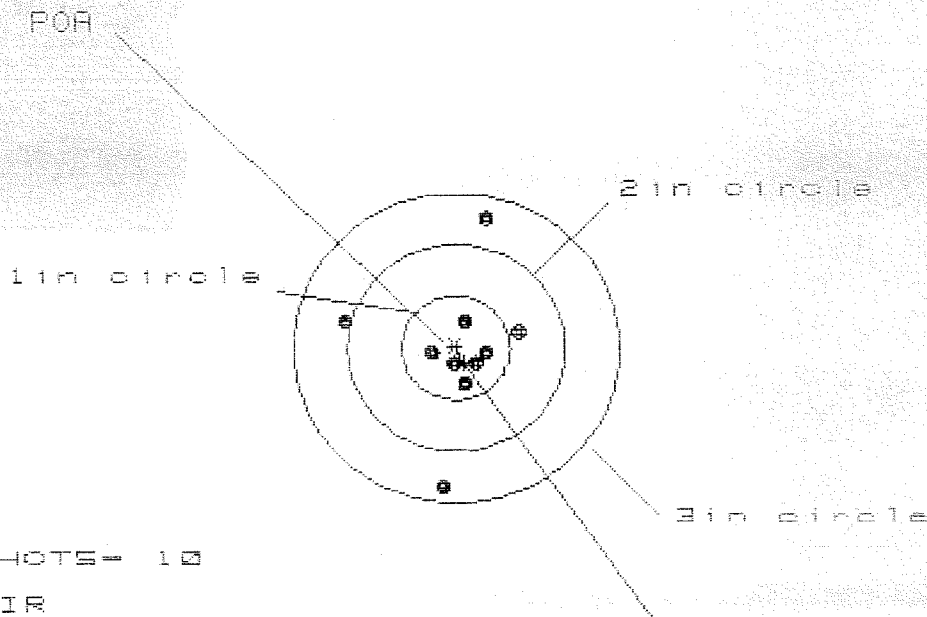
CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.988	1.082	.938
MINIMUM X	:	-1.252	-1.158	-.797
MAXIMUM Y	:	.605	.497	.517
MINIMUM Y	:	-.978	-.643	-.623
CENTROID X	:	-.167	-.261	-.117
CENTROID Y	:	.043	.151	.131
POA TO CENTROID in.	:	.172	.302	.175
MIN RADIUS	:	.291	.383	.255
MEAN RADIUS	:	.814	.756	.676
MAX RADIUS	:	1.297	1.169	1.012
HORIZONTAL SPREAD	:	2.240	2.240	1.735
VERTICAL SPREAD	:	1.583	1.140	1.140
EXTREME SPREAD	:	2.447	2.243	1.864
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	

7 Nov 1990

FILE:/PATTERNING/CENTERFIRE_PATT/C65876B8

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 6

2in = 7

3in = 10

HS= 1.508

VS= 2.557

GS= 2.591

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.533	.518	.553
MINIMUM X	:	-.975	-.990	-.955
MAXIMUM Y	:	1.243	1.097	.293
MINIMUM Y	:	-1.314	-.471	-.334
CENTROID X	:	-.078	-.063	-.098
CENTROID Y	:	.142	.288	.151
POA TO CENTROID in.	:	.162	.295	.180
MIN RADIUS	:	.143	.188	.147
MEAN RADIUS	:	.566	.503	.387
MAX RADIUS	:	1.321	1.130	.999
HORIZONTAL SPREAD	:	1.508	1.508	1.508
VERTICAL SPREAD	:	2.557	1.588	.627
EXTREME SPREAD	:	2.591	1.589	1.514
NUMBER IN ONE INCH CIRCLE =			6	
NUMBER IN TWO INCH CIRCLE =			7	
NUMBER IN THREE INCH CIRCLE =			10	