G 641 4416
Replaced
C. 6225382

04/24/08 12:24:41

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: RE00144821
Verify Repair

Serial: G6414416 Model M24 SWS Center Fire
Caliber: 7.62 NATO

Repairman:
Status: Closed 4/24/2008 10:57:26 AM

Address Information

Customer: (Received From)		Return To: (Received From)	
Name:	B/210TH BSB		B/210TH BSB
Address 1:	2 BCT		2 BCT
Address 2:	10 TH MTN DIV	PO Box:	10 TH MTN DIV PO Box:
City:	FORT DRUM		FORT DRUM
State:	NY	Zip Code: 13602 Country: US	State: NY Zip Code: 13602 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
A008	With Swivel	2
A010	Hard Case	1
A026	Scope	1
A057	Fit and Rear Sgt Base	1

naglet 4/24/2008 12:24 PM NUM

Start 1 Micros... The Asso... 2 Micros... SAP Logo... Arms Ser...

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFOMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6414416.__0
FILE DATE AND TIME: 05/29/2008 08:55

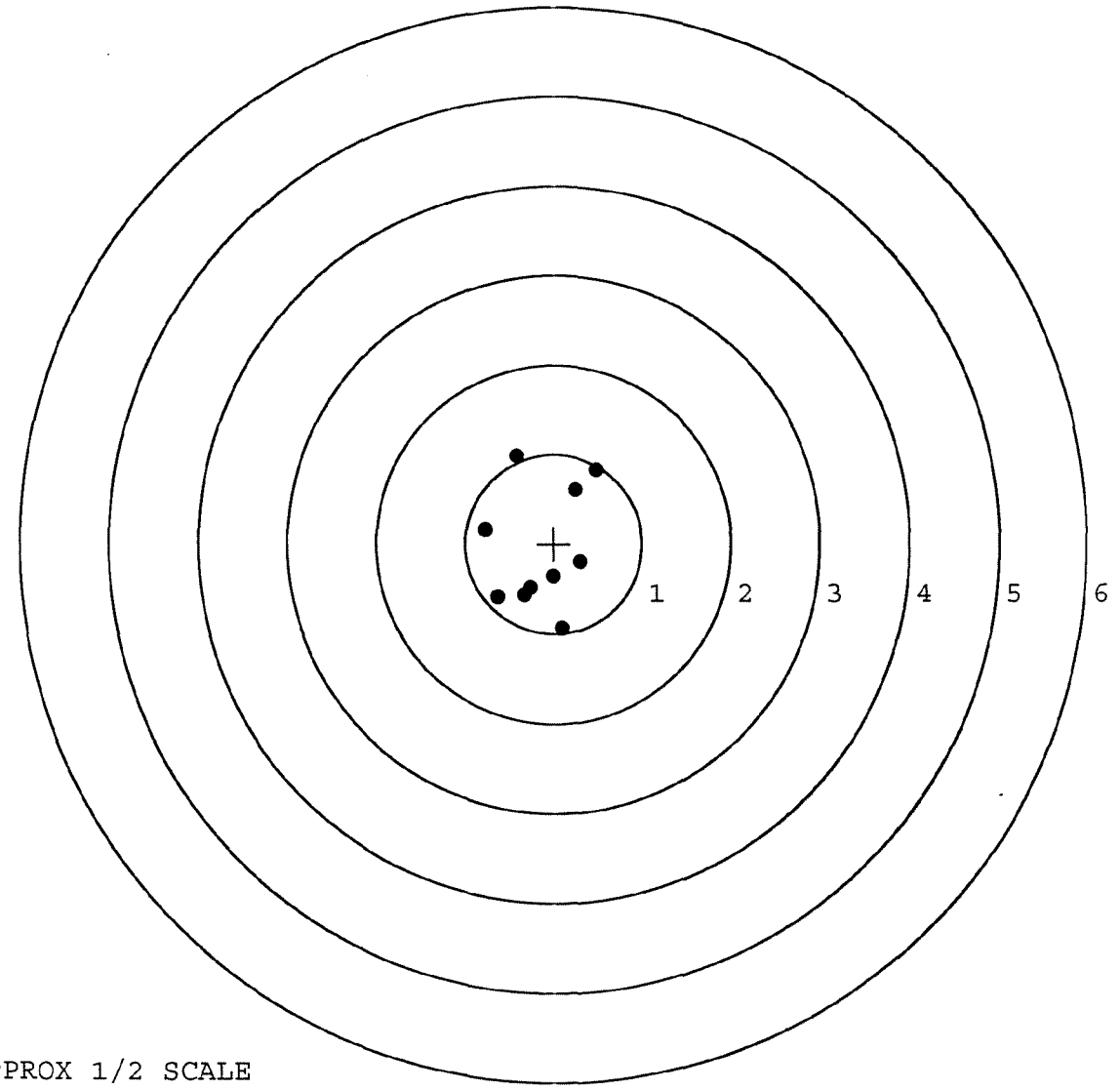
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.021
The Average Y Centroid of the Five Target Set:	-0.064
The Average Point of Impact of the Five Target Set:	0.068
The Average Mean Radius of the Five Target Set:	0.648
The Distance from POA to Centroid Target #1:	0.147
The Distance from Centroid Target #2 to Centroid Target #1:	0.185
The Distance from Centroid Target #3 to Centroid Target #1:	0.050
The Distance from Centroid Target #4 to Centroid Target #1:	0.309
The Distance from Centroid Target #5 to Centroid Target #1:	0.061

SERIAL NUMBER: G6414416.__0
TARGET NUMBER: 1
FILE DATE: 05/29/2008
FILE TIME: 08:55

X CENTROID:	-0.133
Y CENTROID:	-0.062
POA TO CENTROID:	0.147
HORZ SPREAD:	1.259
VERT SPREAD:	1.933
GROUP SPREAD:	1.823
MIN RADIUS:	0.329
MAX RADIUS:	1.083
MEAN RADIUS:	0.705
# IN 1 IN DIAMETER:	3
# IN 2 IN DIAMETER:	8
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	0.090	-0.952
2:	0.306	-0.201
3:	-0.013	-0.368
4:	-0.273	-0.498
5:	-0.339	-0.576
6:	-0.634	-0.594
7:	-0.775	0.157
8:	0.484	0.828
9:	0.243	0.600
10:	-0.424	0.981

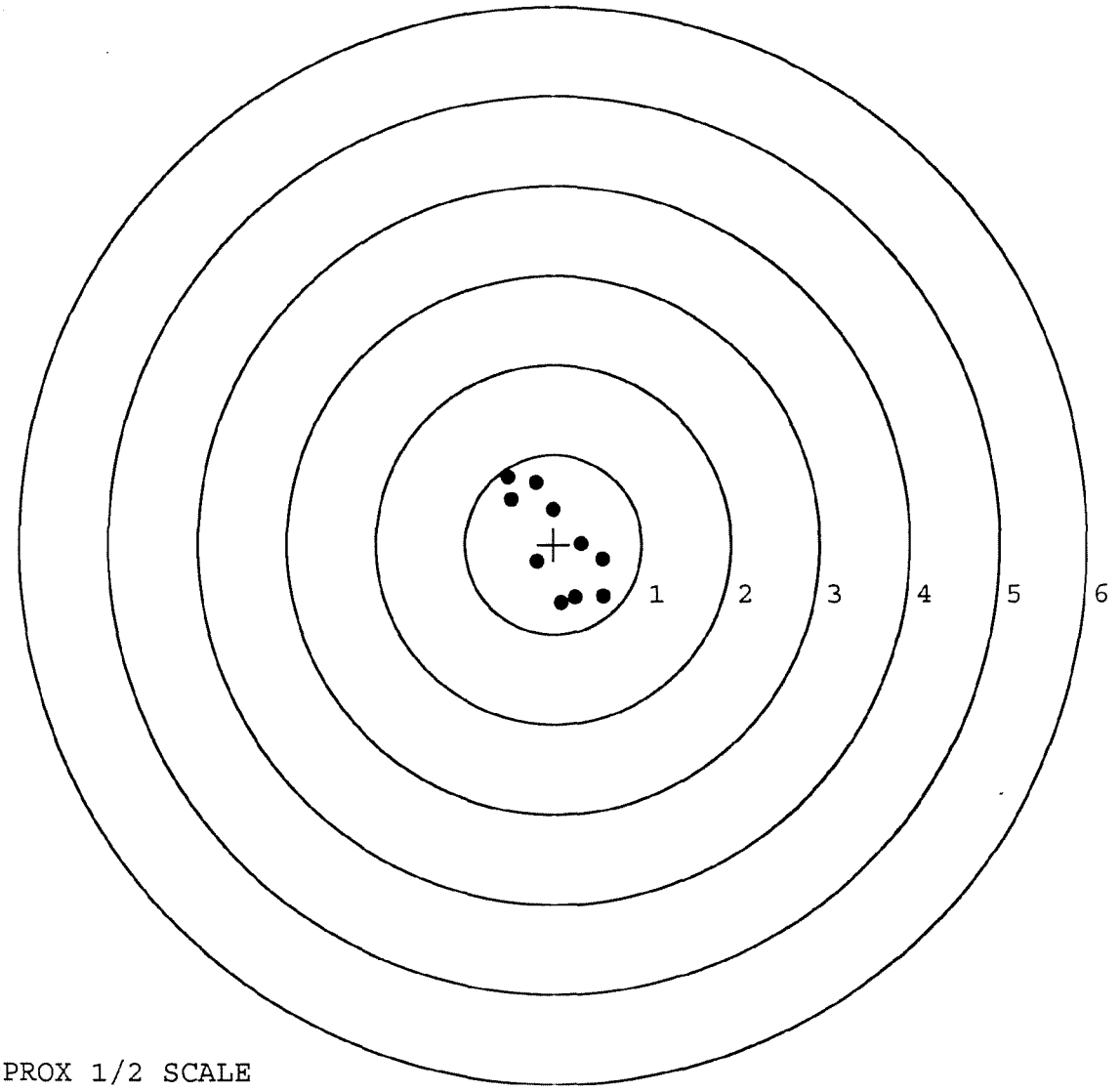


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6414416.__0
TARGET NUMBER: 2
FILE DATE: 05/29/2008
FILE TIME: 08:55

X CENTROID:	0.035
Y CENTROID:	0.014
POA TO CENTROID:	0.038
HORZ SPREAD:	1.088
VERT SPREAD:	1.406
GROUP SPREAD:	1.719
MIN RADIUS:	0.281
MAX RADIUS:	0.925
MEAN RADIUS:	0.599
# IN 1 IN DIAMETER:	3
# IN 2 IN DIAMETER:	10
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	0.564	-0.580
2:	0.243	-0.599
3:	0.083	-0.655
4:	0.557	-0.172
5:	0.316	0.009
6:	-0.187	-0.198
7:	-0.012	0.392
8:	-0.203	0.692
9:	-0.485	0.502
10:	-0.524	0.751

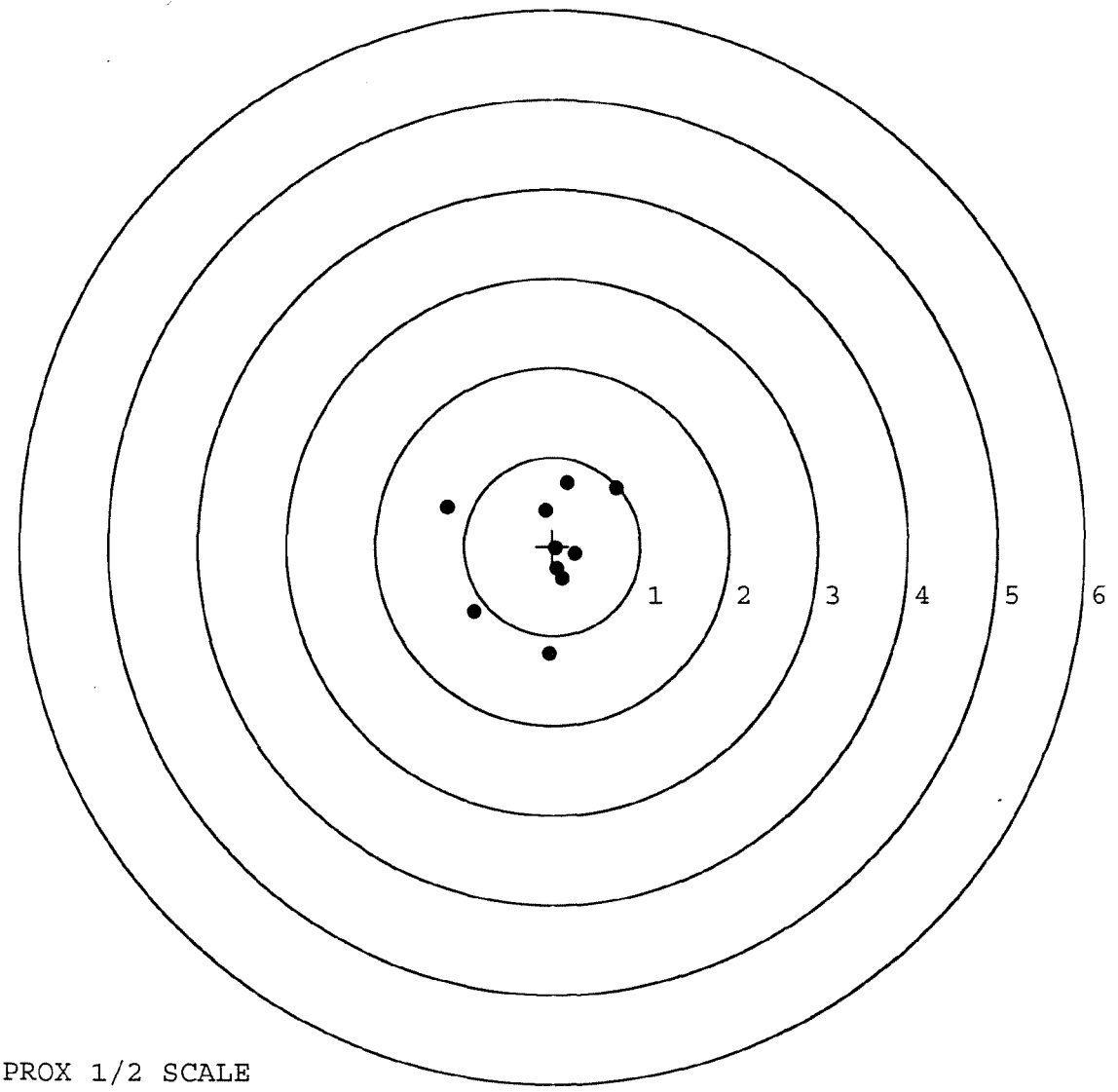


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6414416.__0
TARGET NUMBER: 3
FILE DATE: 05/29/2008
FILE TIME: 08:55

X CENTROID:	-0.085
Y CENTROID:	-0.049
POA TO CENTROID:	0.098
HORZ SPREAD:	1.913
VERT SPREAD:	1.924
GROUP SPREAD:	2.007
MIN RADIUS:	0.121
MAX RADIUS:	1.204
MEAN RADIUS:	0.685
# IN 1 IN DIAMETER:	5
# IN 2 IN DIAMETER:	6
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	0.725	0.657
2:	0.169	0.713
3:	-0.081	0.405
4:	-1.188	0.435
5:	-0.887	-0.738
6:	-0.040	-1.211
7:	0.112	-0.373
8:	0.034	-0.026
9:	0.254	-0.093
10:	0.049	-0.257

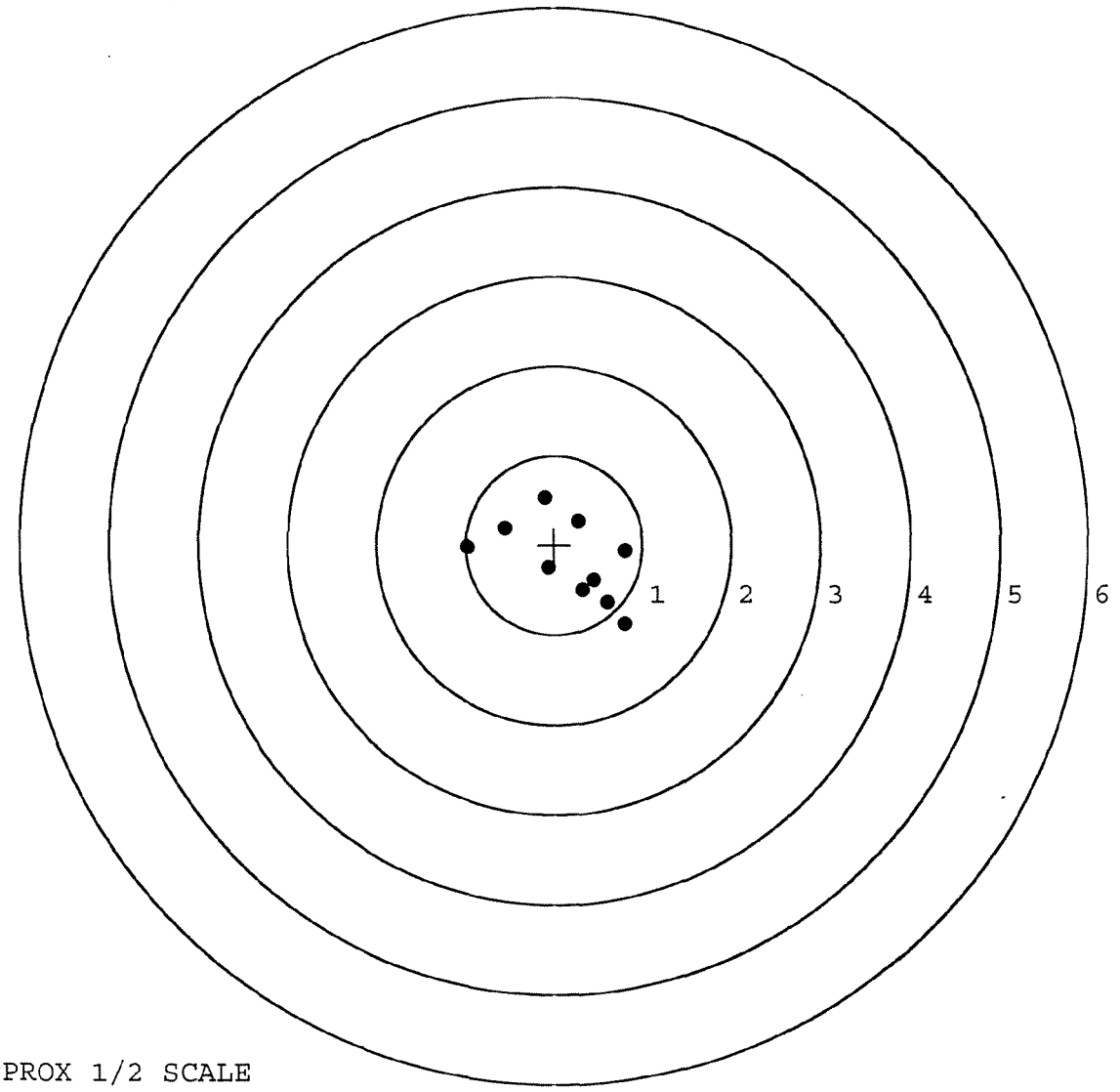


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6414416.__0
TARGET NUMBER: 4
FILE DATE: 05/29/2008
FILE TIME: 08:55

X CENTROID:	0.153
Y CENTROID:	-0.179
POA TO CENTROID:	0.235
HORZ SPREAD:	1.786
VERT SPREAD:	1.412
GROUP SPREAD:	1.971
MIN RADIUS:	0.234
MAX RADIUS:	1.143
MEAN RADIUS:	0.640
# IN 1 IN DIAMETER:	4
# IN 2 IN DIAMETER:	9
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	0.797	-0.881
2:	0.806	-0.073
3:	0.272	0.269
4:	-0.068	-0.257
5:	-0.110	0.531
6:	-0.565	0.192
7:	-0.980	-0.028
8:	0.449	-0.392
9:	0.325	-0.504
10:	0.604	-0.645

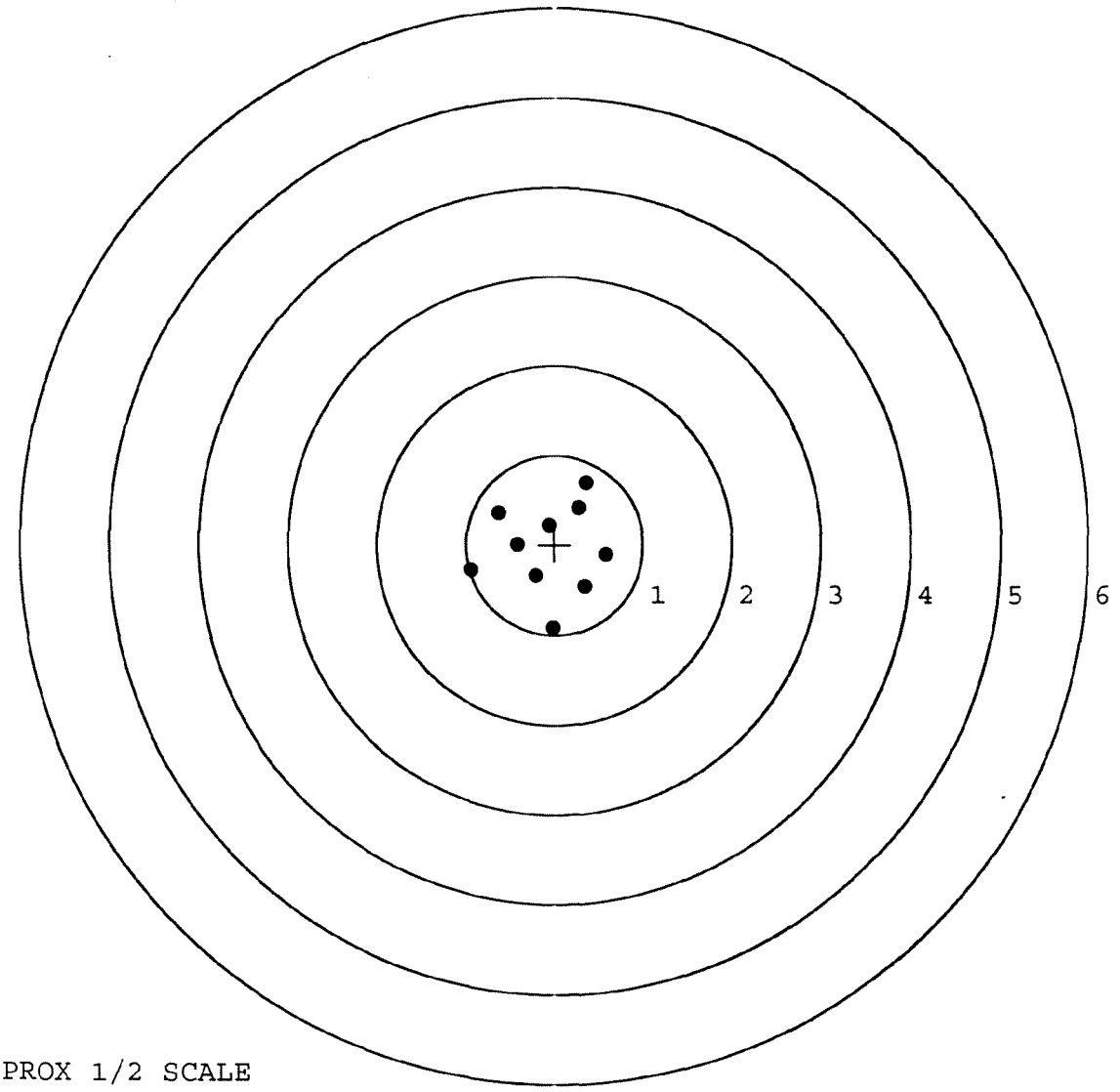


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6414416.__0
TARGET NUMBER: 5
FILE DATE: 05/29/2008
FILE TIME: 08:55

X CENTROID:	-0.075
Y CENTROID:	-0.045
POA TO CENTROID:	0.087
HORZ SPREAD:	1.531
VERT SPREAD:	1.632
GROUP SPREAD:	1.631
MIN RADIUS:	0.265
MAX RADIUS:	0.903
MEAN RADIUS:	0.612
# IN 1 IN DIAMETER:	3
# IN 2 IN DIAMETER:	10
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	-0.021	-0.933
2:	0.344	-0.460
3:	0.585	-0.109
4:	-0.217	-0.348
5:	-0.425	-0.004
6:	-0.634	0.354
7:	-0.946	-0.284
8:	-0.065	0.220
9:	0.273	0.415
10:	0.356	0.699

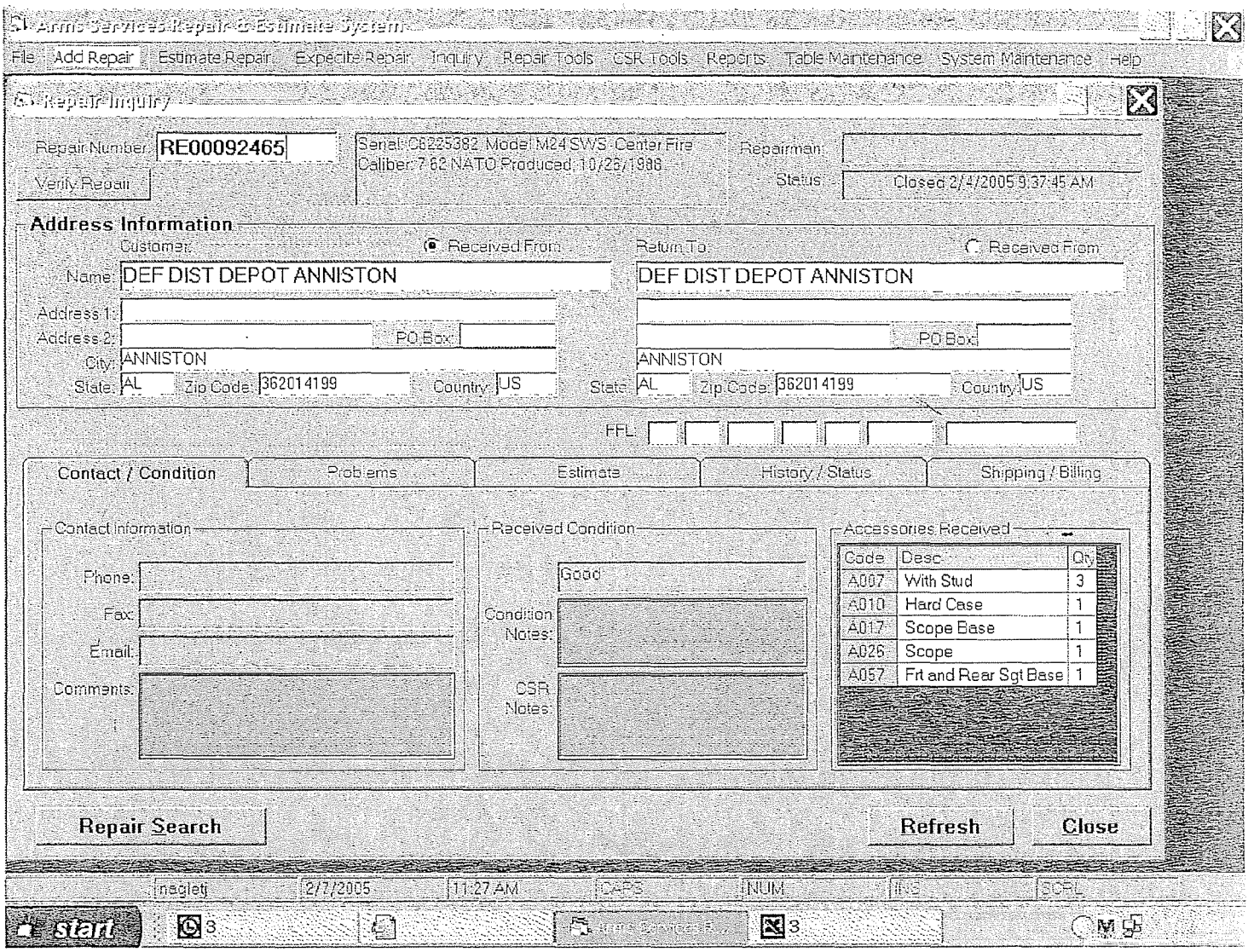


TARGET APPROX 1/2 SCALE

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

P & E NUMBER 144821
SERIAL NUMBER GG41441b
LOG-IN DATE 4-24-08

OPERATION #	OPERATION NAME		DATE	INITIAL
500	DIS-ASSEMBLE GUN		4-28-08	RTZ
505	RE-BARREL			
560	ASSEMBLE	MAGNA-FLUX	4-30-08	TRW
600	PROOF		4-30-08	TRW
605	CHECK HEADSPACE		4-30-08	TRW
610	DIS-ASSEMBLE GUN		4-30-08	[illegible]
612	MAGNAFLUX	OPERATOR [signature]	5/1/08	[signature]
510	DRILL AND TAP		5-1-08	TRW
615	ROLLMARK CALIBER		5-1-08	CW
618	ROTO-BLAST		5-1-08	DG
620	APPLY COATINGS		5-5-08	[illegible]
625	FINAL ASSEMBLY		5-27-08	RTZ
640	FUNCTION TEST AND	(PASS) FAIL	5-29-08	TRW
650	TARGET	(PASS) FAIL	5-29-08	TRW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION	5/29/08	MED
670	FINAL INSPECTION A) HEADSPACE	(PASS) FAIL	5/29/08 5/29/08	FM FM
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	2.49 2.59 2.58 2.60 2.55	5-29-08	TRW
	C) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	6.5 6.5 6	5/29/08	FM
	D) SAFETY OFF FORCE 2 LBS MIN	4 4 4	5/29/08	FM
	E) FIRING PIN INDENT .020	.022 .022 .023	5/29/08	FM
690	PACK		5/29/08	FM



C6414416

Serial Number: C6225382

Model: M24 SWS

RE00092465

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)

SERIAL NO. _____

DATE 4-28-05

TESTER TRW

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.37	2.90		2.43	
PULL #2	2.53	2.88		2.21	
PULL #3	2.32	2.73		2.57	
PULL #4	2.46	2.83		2.41	
PULL #5	2.55	2.65		2.50	
TOTAL	12.23	13.99		12.12	
AVERAGE	2.44	2.79		2.42	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.10	3.40		
PULL #2	3.48	3.13		
PULL #3	3.36	3.20		
PULL #4	3.42	3.26		
PULL #5	3.31	3.30		
TOTAL	16.67	16.29		
AVERAGE	3.33	3.25		

	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	4.19	4.05		4.03
PULL #2	4.31	4.25		4.04
PULL #3	4.15	4.18		4.08
PULL #4	4.04	4.22		4.10
PULL #5	4.04	4.21		4.25
TOTAL	20.73	20.91		20.50
AVERAGE	4.14	4.18		4.10

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFOMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6414416.__0
FILE DATE AND TIME: 05/03/2005 07:03

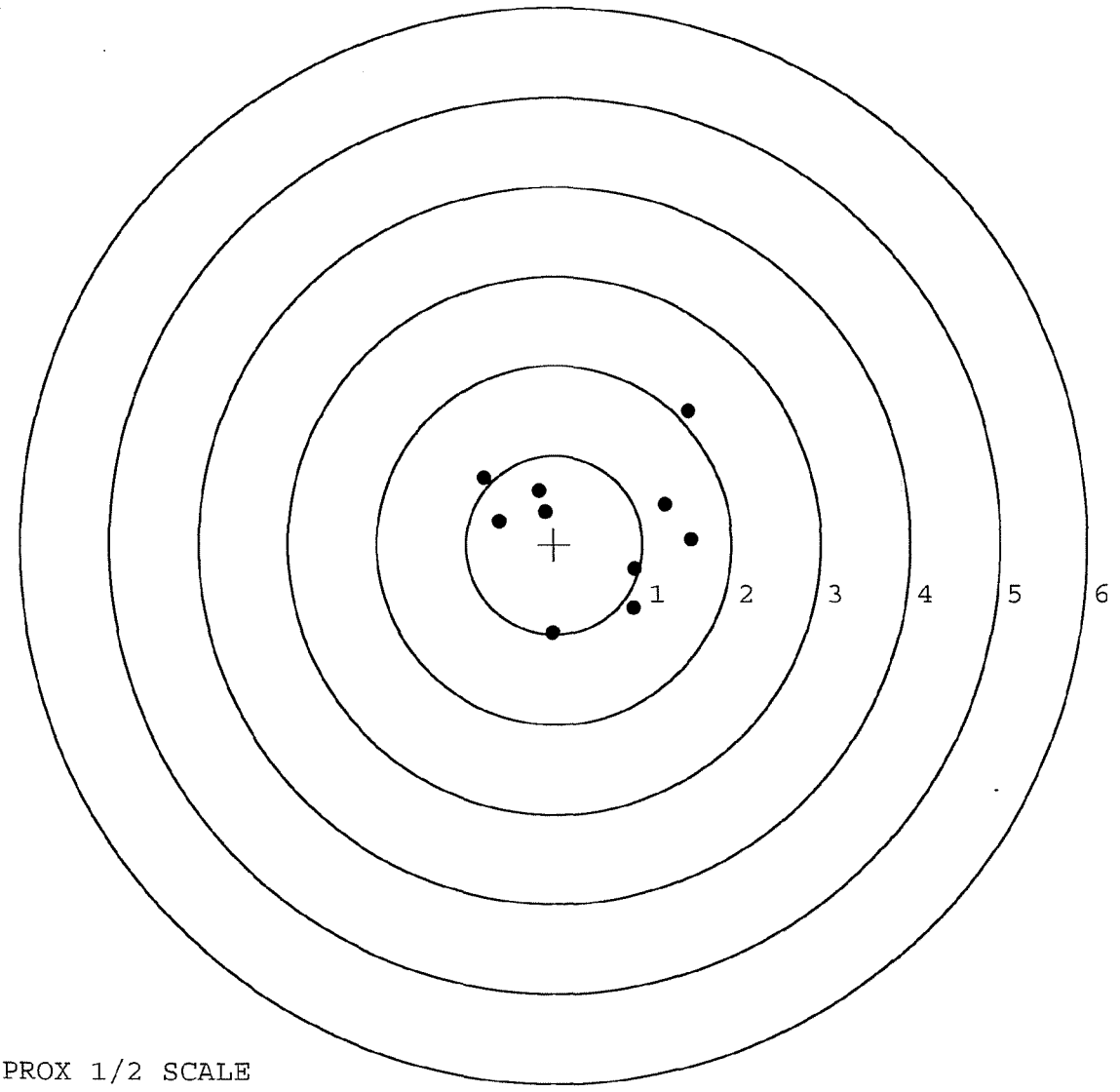
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.079
The Average Y Centroid of the Five Target Set:	-0.198
The Average Point of Impact of the Five Target Set:	0.213
The Average Mean Radius of the Five Target Set:	0.811
The Distance from POA to Centroid Target #1:	0.482
The Distance from Centroid Target #2 to Centroid Target #1:	0.626
The Distance from Centroid Target #3 to Centroid Target #1:	0.516
The Distance from Centroid Target #4 to Centroid Target #1:	0.799
The Distance from Centroid Target #5 to Centroid Target #1:	0.769

SERIAL NUMBER: G6414416.__0
TARGET NUMBER: 1
FILE DATE: 05/03/2005
FILE TIME: 07:03

X CENTROID:	0.438
Y CENTROID:	0.201
POA TO CENTROID:	0.482
HORZ SPREAD:	2.344
VERT SPREAD:	2.486
GROUP SPREAD:	2.919
MIN RADIUS:	0.574
MAX RADIUS:	1.683
MEAN RADIUS:	1.035
# IN 1 IN DIAMETER:	0
# IN 2 IN DIAMETER:	4
# in 3 IN DIAMETER:	9

POINT#	X	Y
1:	0.899	-0.711
2:	0.910	-0.280
3:	1.550	0.064
4:	1.248	0.447
5:	1.509	1.499
6:	-0.177	0.600
7:	-0.112	0.364
8:	-0.633	0.263
9:	-0.794	0.747
10:	-0.021	-0.987

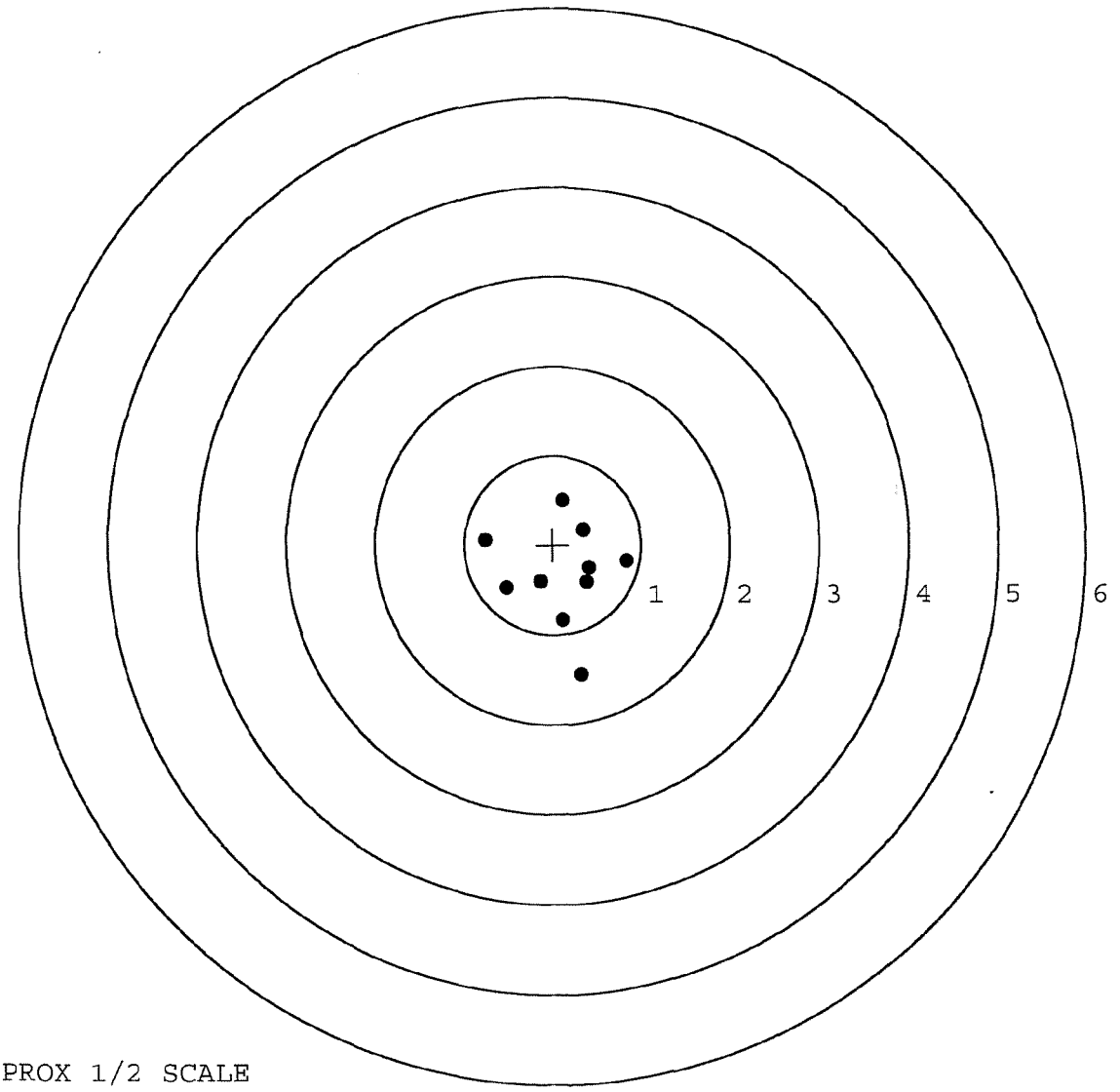


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6414416.__0
TARGET NUMBER: 2
FILE DATE: 05/03/2005
FILE TIME: 07:03

X CENTROID:	0.108
Y CENTROID:	-0.331
POA TO CENTROID:	0.349
HORZ SPREAD:	1.603
VERT SPREAD:	1.938
GROUP SPREAD:	1.949
MIN RADIUS:	0.264
MAX RADIUS:	1.132
MEAN RADIUS:	0.625
# IN 1 IN DIAMETER:	3
# IN 2 IN DIAMETER:	9
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	0.321	-1.443
2:	0.107	-0.845
3:	0.384	-0.414
4:	0.407	-0.259
5:	0.838	-0.182
6:	-0.143	-0.414
7:	-0.532	-0.481
8:	0.353	0.170
9:	0.111	0.495
10:	-0.765	0.058

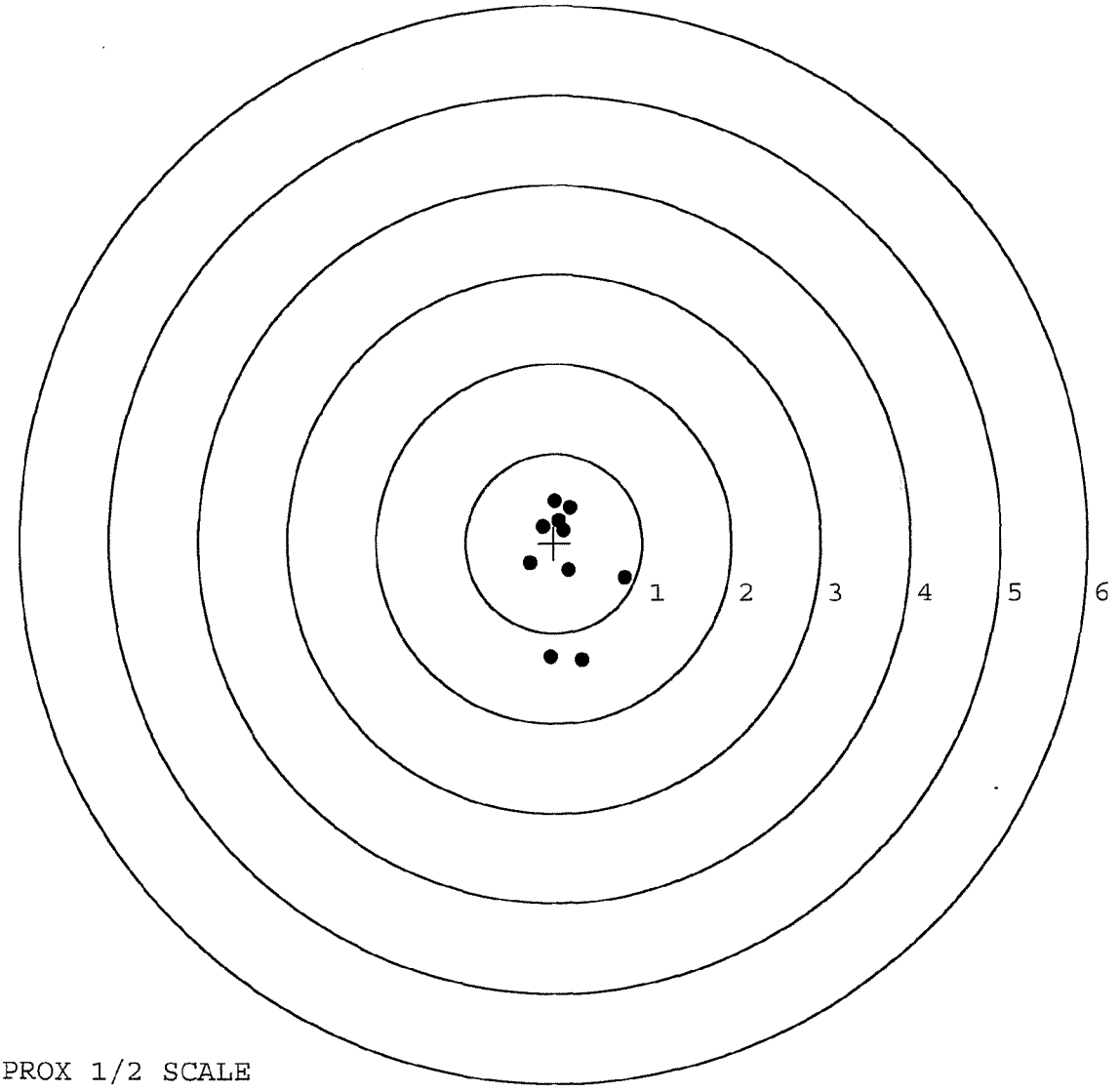


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6414416.__0
TARGET NUMBER: 3
FILE DATE: 05/03/2005
FILE TIME: 07:03

X CENTROID:	0.117
Y CENTROID:	-0.203
POA TO CENTROID:	0.234
HORZ SPREAD:	1.075
VERT SPREAD:	1.764
GROUP SPREAD:	1.792
MIN RADIUS:	0.107
MAX RADIUS:	1.112
MEAN RADIUS:	0.595
# IN 1 IN DIAMETER:	5
# IN 2 IN DIAMETER:	8
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	0.319	-1.296
2:	-0.044	-1.273
3:	0.796	-0.382
4:	0.161	-0.300
5:	-0.279	-0.222
6:	0.178	0.397
7:	0.002	0.468
8:	0.108	0.146
9:	-0.127	0.181
10:	0.056	0.252

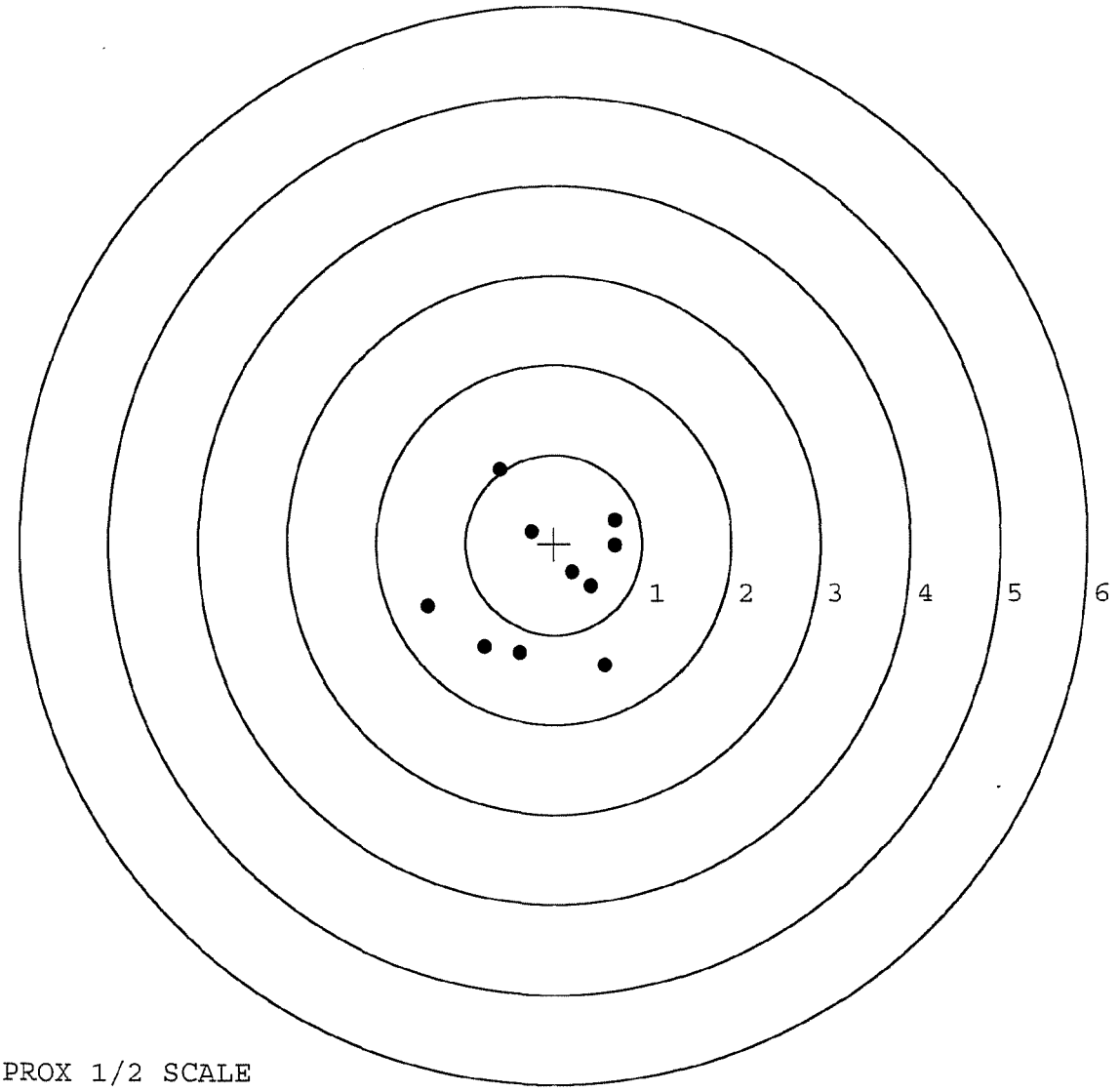


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6414416.__0
TARGET NUMBER: 4
FILE DATE: 05/03/2005
FILE TIME: 07:03

X CENTROID:	-0.093
Y CENTROID:	-0.397
POA TO CENTROID:	0.408
HORZ SPREAD:	2.113
VERT SPREAD:	2.170
GROUP SPREAD:	2.312
MIN RADIUS:	0.304
MAX RADIUS:	1.363
MEAN RADIUS:	0.900
# IN 1 IN DIAMETER:	1
# IN 2 IN DIAMETER:	5
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	0.568	-1.343
2:	-0.398	-1.210
3:	-0.792	-1.140
4:	-1.422	-0.696
5:	-0.615	0.827
6:	-0.254	0.135
7:	0.415	-0.472
8:	0.200	-0.315
9:	0.691	-0.020
10:	0.681	0.264

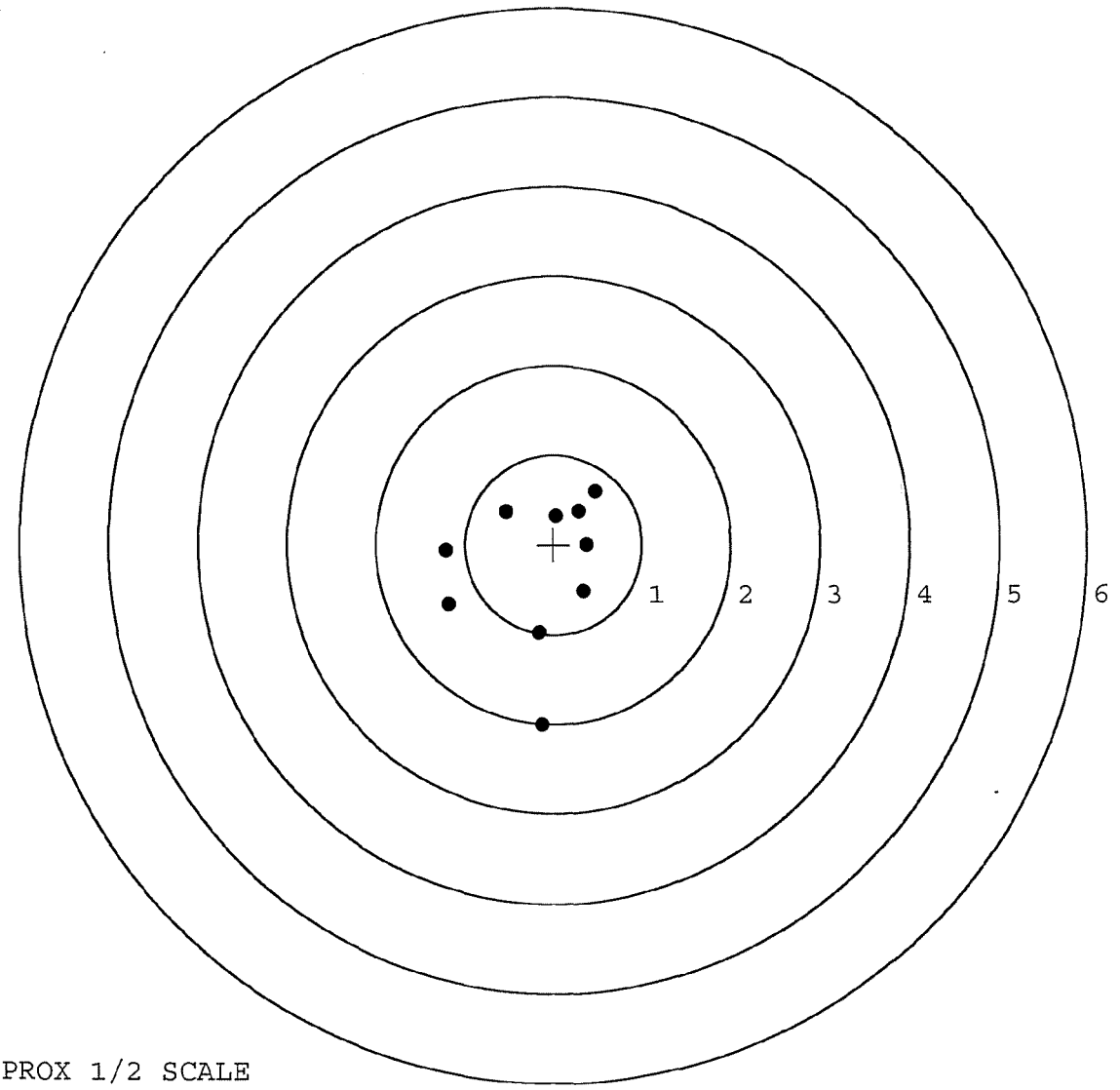


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6414416.__0
TARGET NUMBER: 5
FILE DATE: 05/03/2005
FILE TIME: 07:03

X CENTROID:	-0.177
Y CENTROID:	-0.261
POA TO CENTROID:	0.315
HORZ SPREAD:	1.687
VERT SPREAD:	2.617
GROUP SPREAD:	2.686
MIN RADIUS:	0.577
MAX RADIUS:	1.757
MEAN RADIUS:	0.903
# IN 1 IN DIAMETER:	0
# IN 2 IN DIAMETER:	6
# in 3 IN DIAMETER:	9

POINT#	X	Y
1:	-0.136	-2.018
2:	-0.172	-0.985
3:	0.339	-0.520
4:	-1.193	-0.671
5:	-1.218	-0.073
6:	-0.541	0.370
7:	0.378	-0.005
8:	0.026	0.319
9:	0.282	0.374
10:	0.469	0.599



TARGET APPROX 1/2 SCALE

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

R & E NUMBER	92463		
SERIAL NUMBER	C0225382	C6641446	NEW
LOG-IN DATE	3-4-05		
INSPECT AND VERIFY:			
OPERATION #	OPERATION NAME	DATE	INITIAL
550	DIS-ASSEMBLE GUN	4-4-05	RTL
560 A	RE-BARREL	4-7-05	RTL
B	DRILL AND TAP	4-11-05	TRW
575	ASSEMBLE	4-7-05	RTL
600	PROOF	4-8-05	AC
605	CHECK HEADSPACE	4-8-05	AC
610	DIS-ASSEMBLE GUN	4-11-05	RTL
612	MAGNAFLUX		
615	ROLLMARK CALIBER	4-12-05	CW
618	ROTO-BLAST	4-18-05	LB
620	APPLY COATINGS	4-25-05	
625 A	FINAL ASSEMBLY	4-29-05	RTL
B	TRIGGER PULL TEST	5-9-05	TRW
C	SAFETY "ON" FORCE	5-9-05	AC
D	SAFETY "OFF" FORCE	5-9-05	AC
E	FIRING PIN INDENT	5-9-05	AC
640	TARGET	5-2-05	TRW
655	FINAL INSPECT	5-9-05	AC
660	PACK	5-10-05	DA
		SHIP DATE	
	QAR INSPECTION DATE		

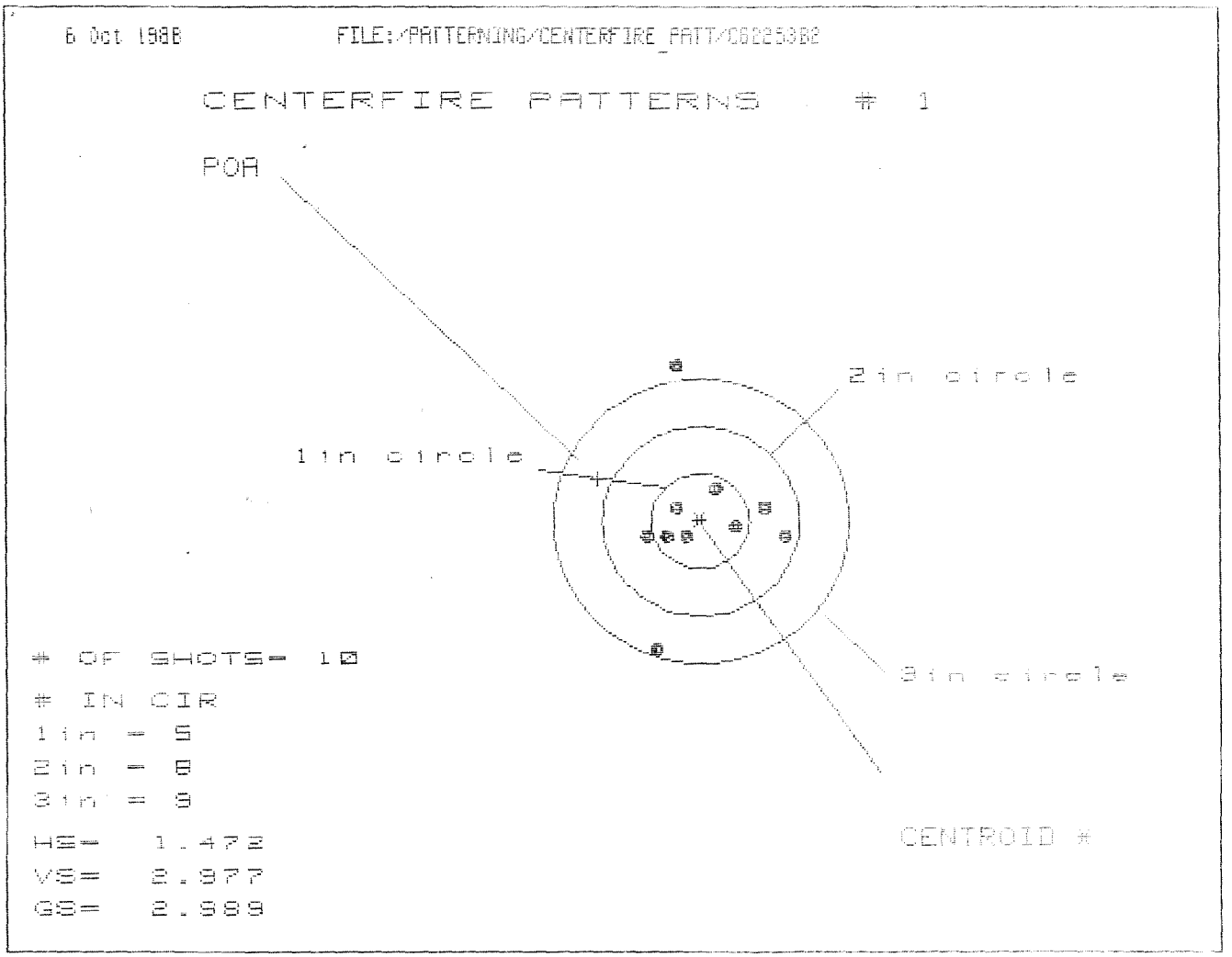
CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6225382

CENTROIDAL DISTANCES

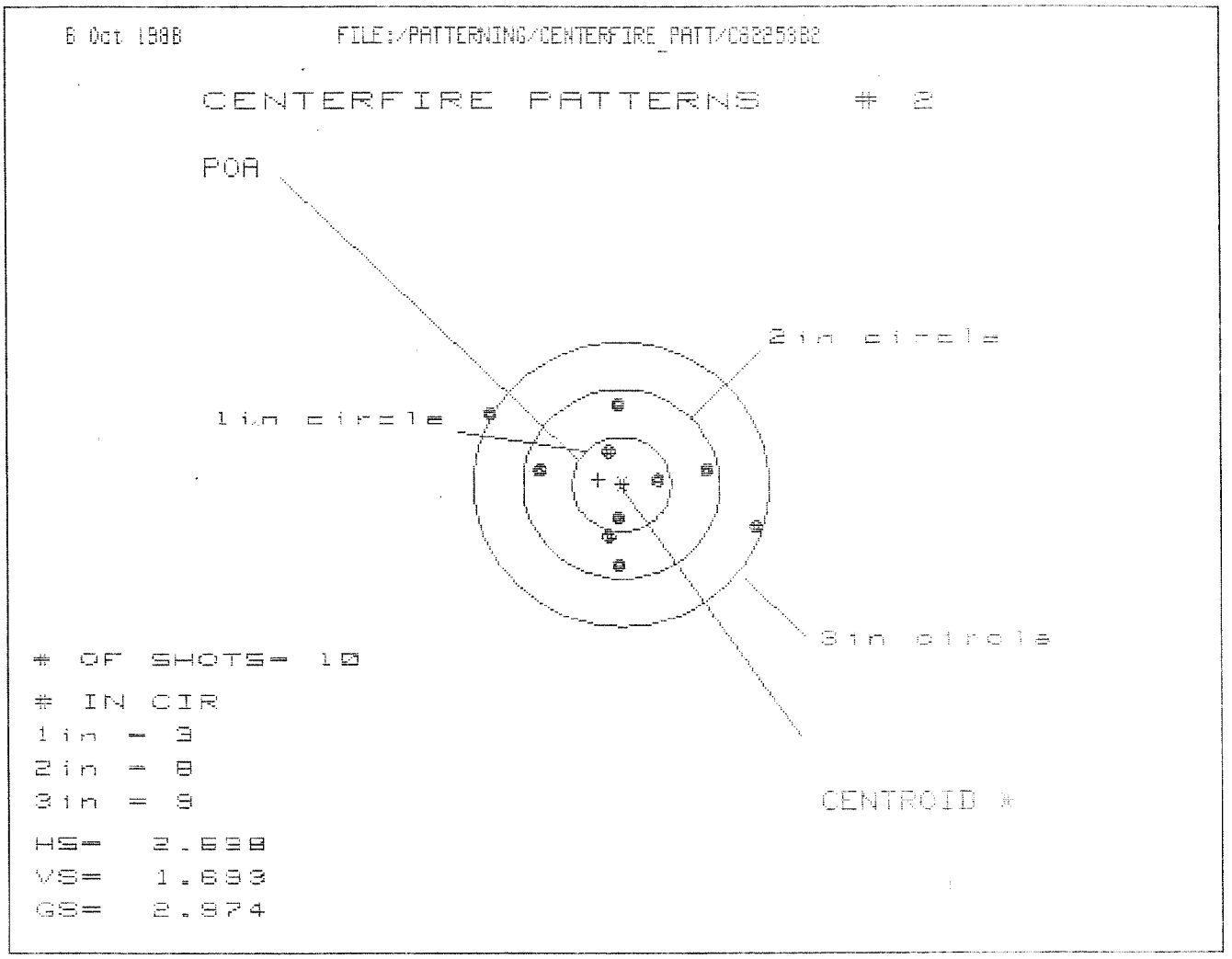
0	TO	1	1.13567
1	TO	2	.901619
1	TO	3	.366956
1	TO	4	.657682
1	TO	5	1.13008

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .6084
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1434
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .625071

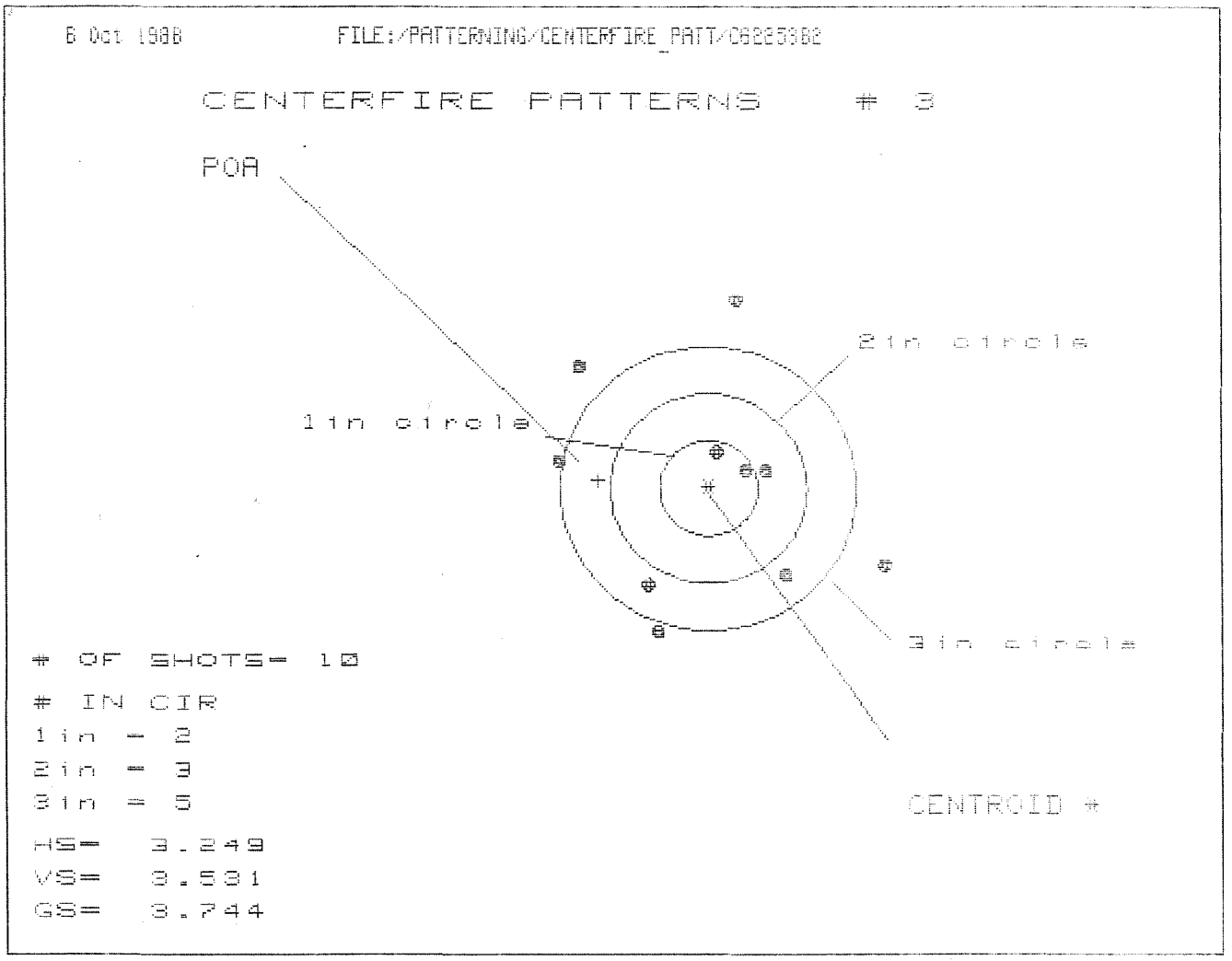
THE AMR FOR THIS RIFLE IS: .9264



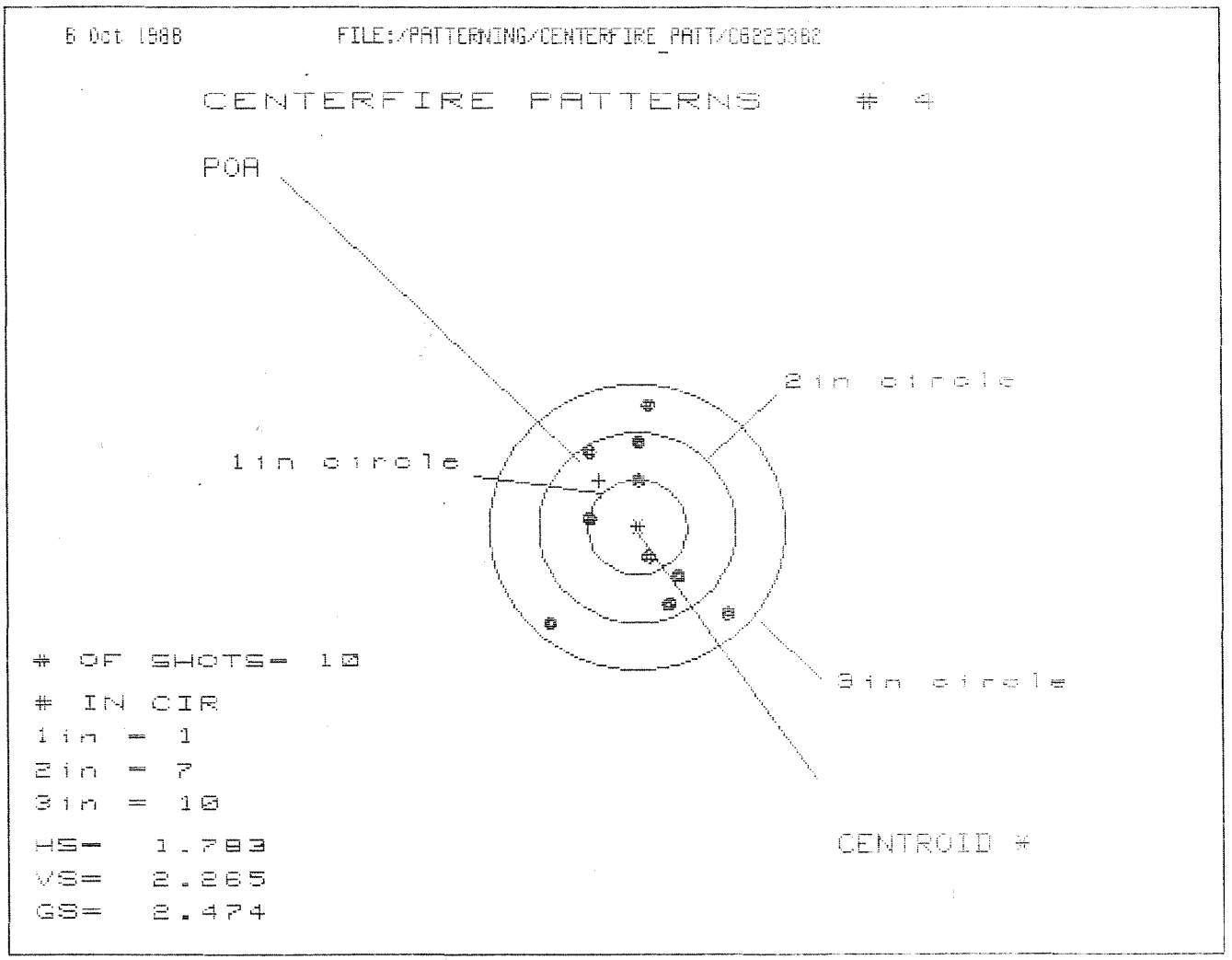
PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.896	.873	.812
MINIMUM X	:	-.576	-.599	-.660
MAXIMUM Y	:	1.622	.506	.359
MINIMUM Y	:	-1.355	-1.175	-.165
CENTROID X	:	1.044	1.067	1.128
CENTROID Y	:	-.447	-.627	-.480
POA TO CENTROID in.	:	1.136	1.237	1.226
MIN RADIUS	:	.272	.210	.296
MEAN RADIUS	:	.694	.593	.488
MAX RADIUS	:	1.634	1.274	.828
HORIZONTAL SPREAD	:	1.472	1.472	1.472
VERTICAL SPREAD	:	2.977	1.681	.524
EXTREME SPREAD	:	2.989	1.846	1.472
NUMBER IN ONE INCH CIRCLE	=		5	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	



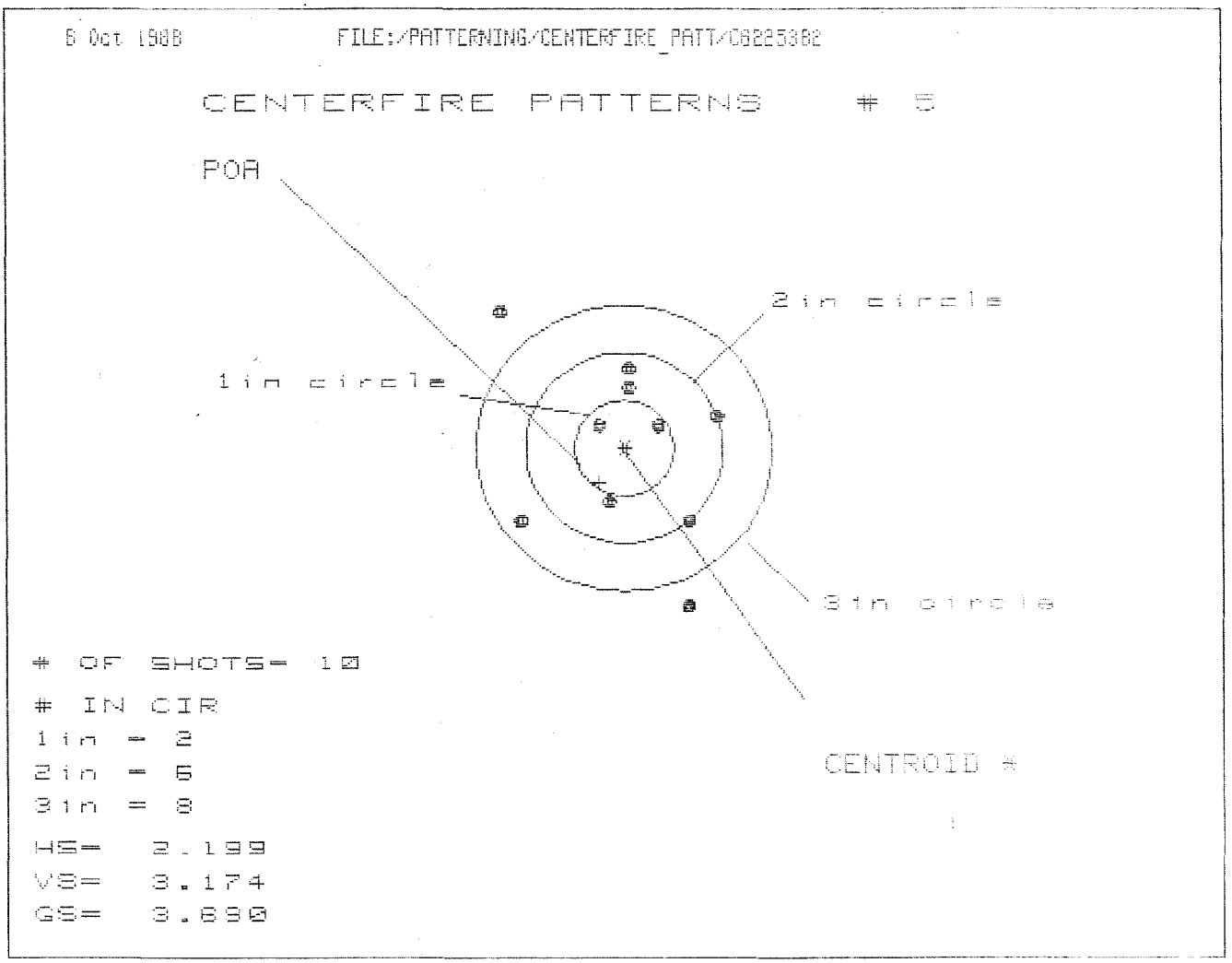
PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.366	1.218	.861
MINIMUM X	:	-1.332	-1.006	-.854
MAXIMUM Y	:	.829	.915	.865
MINIMUM Y	:	-.864	-.778	-.828
CENTROID X	:	.234	.382	.230
CENTROID Y	:	-.051	-.137	-.087
POA TO CENTROID in.	:	.240	.406	.246
MIN RADIUS	:	.333	.237	.296
MEAN RADIUS	:	.808	.713	.634
MAX RADIUS	:	1.539	1.280	.877
HORIZONTAL SPREAD	:	2.698	2.224	1.715
VERTICAL SPREAD	:	1.693	1.693	1.693
EXTREME SPREAD	:	2.974	2.312	1.715
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	



PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.775	1.808	1.079
MINIMUM X	:	-1.474	-1.441	-1.215
MAXIMUM Y	:	2.031	1.515	1.442
MINIMUM Y	:	-1.500	-1.275	-1.348
CENTROID X	:	1.120	1.087	.861
CENTROID Y	:	-.088	-.313	-.240
POA TO CENTROID in.	:	1.123	1.131	.894
MIN RADIUS	:	.355	.569	.610
MEAN RADIUS	:	1.273	1.194	1.117
MAX RADIUS	:	2.053	1.991	1.793
HORIZONTAL SPREAD	:	3.249	3.249	2.294
VERTICAL SPREAD	:	3.531	2.790	2.790
EXTREME SPREAD	:	3.744	3.744	3.091
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		5	



PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.889	.790	.790
MINIMUM X	:	-.894	-.618	-.618
MAXIMUM Y	:	1.285	1.176	.919
MINIMUM Y	:	-.980	-1.037	-.890
CENTROID X	:	.388	.487	.487
CENTROID Y	:	-.494	-.385	-.532
POA TO CENTROID in.	:	.628	.621	.722
MIN RADIUS	:	.370	.416	.310
MEAN RADIUS	:	.873	.817	.760
MAX RADIUS	:	1.327	1.303	1.190
HORIZONTAL SPREAD	:	1.783	1.408	1.408
VERTICAL SPREAD	:	2.265	2.213	1.809
EXTREME SPREAD	:	2.474	2.349	2.203
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	



PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.963	.825	.889
MINIMUM X	:	-1.236	-1.184	-1.120
MAXIMUM Y	:	1.480	.962	.771
MINIMUM Y	:	-1.694	-1.530	-.808
CENTROID X	:	.256	.394	.330
CENTROID Y	:	.363	.199	.390
POA TO CENTROID in.	:	.444	.441	.511
MIN RADIUS	:	.371	.472	.361
MEAN RADIUS	:	.984	.884	.753
MAX RADIUS	:	1.928	1.612	1.381
HORIZONTAL SPREAD	:	2.199	2.009	2.009
VERTICAL SPREAD	:	3.174	2.492	1.579
EXTREME SPREAD	:	3.690	2.574	2.289
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6725382

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		JUL 29 1991	
600	Proof		JUL 29 1991	
607	Check Headspace		JUL 29 1991	
610	Dis-assemble Gun		JUL 29 1991	
612	Magnaflux Barrel Action		JUL 30 1991	
	Magnaflux Bolt		JUL 30 1991	
615	Rollmark Caliber		JUL 30 1991	
617	Drill and Tap Sight Holes		JUL 30 1991	
618	Polish Barrel		JUL 31 1991	
620	Apply Coatings (Barrel Action)		AUG 1 1991	
	Apply Coating (Bolt)		AUG 1 1991	
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						9-25-91	DH
	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						9-24-91	DH
	A) Time						9-24-91	DH
	B) Malfunctions						9-24-91	DH
	C) Pierced Primers						9-24-91	DH
	D) Optical Clearity of Scope						9-24-91	DH
645	Inspect for Live Ammo						9-24-91	DH
655	Final Inspection A) Headspace						9-25-91	DH
	B) Trigger Pull	2.65	2.54	2.53	2.58	2.52	9/24/91	RW
	C) Function						9-25-91	DH
660	Pack						9/25/91	WB

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06225382
24 Sep 1991

CENTROIDAL DISTANCES

0 TO 1 .3002703
1 TO 2 .38266
1 TO 3 .455089
1 TO 4 .326221
1 TO 5 .0936002

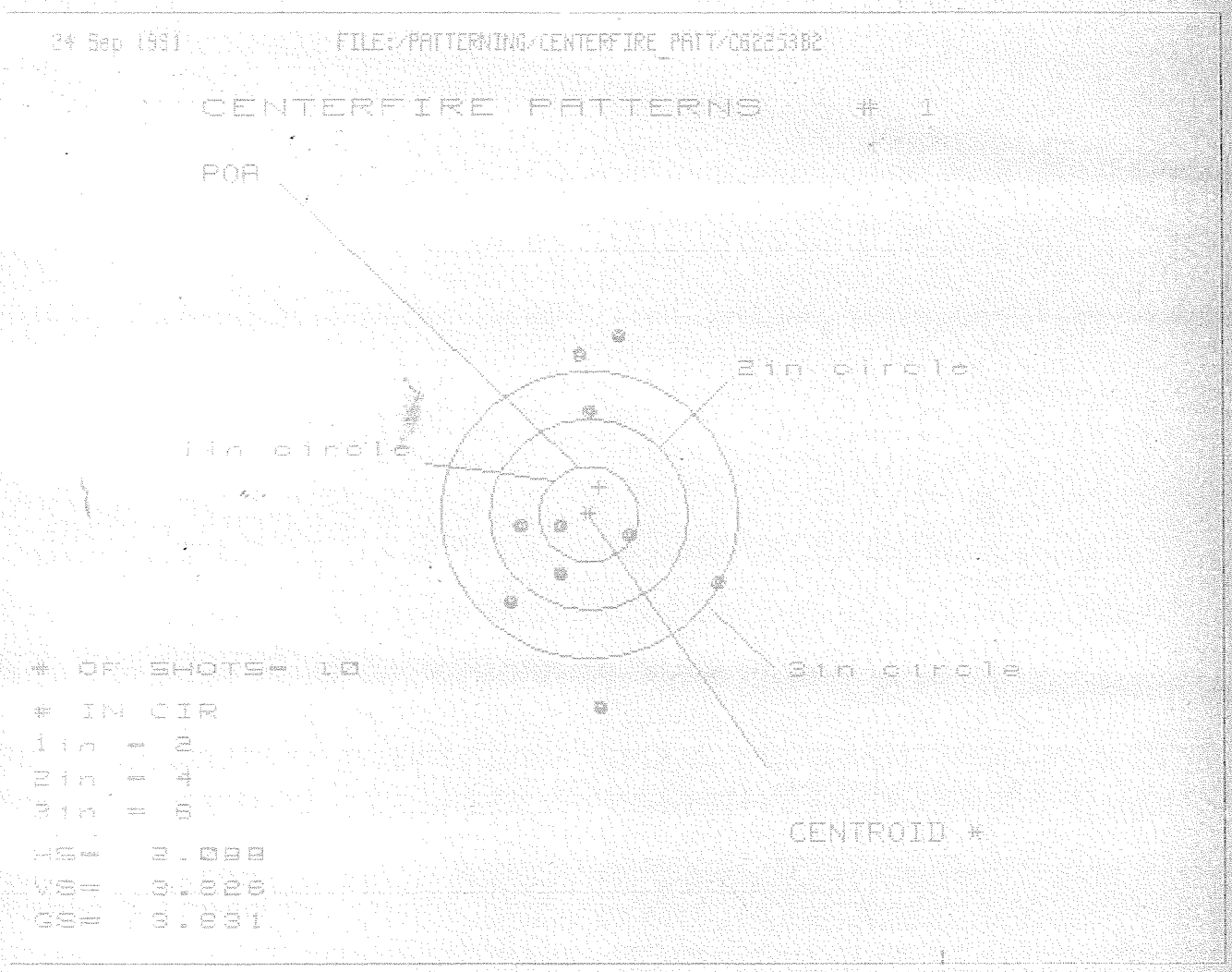
<-----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.192
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1742
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .259248

THE AMR FOR THIS RIFLE IS: 1.03

24 Sep (99) FILE:/PATTERNING/CENTERFIRE_PATT/CR26302

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

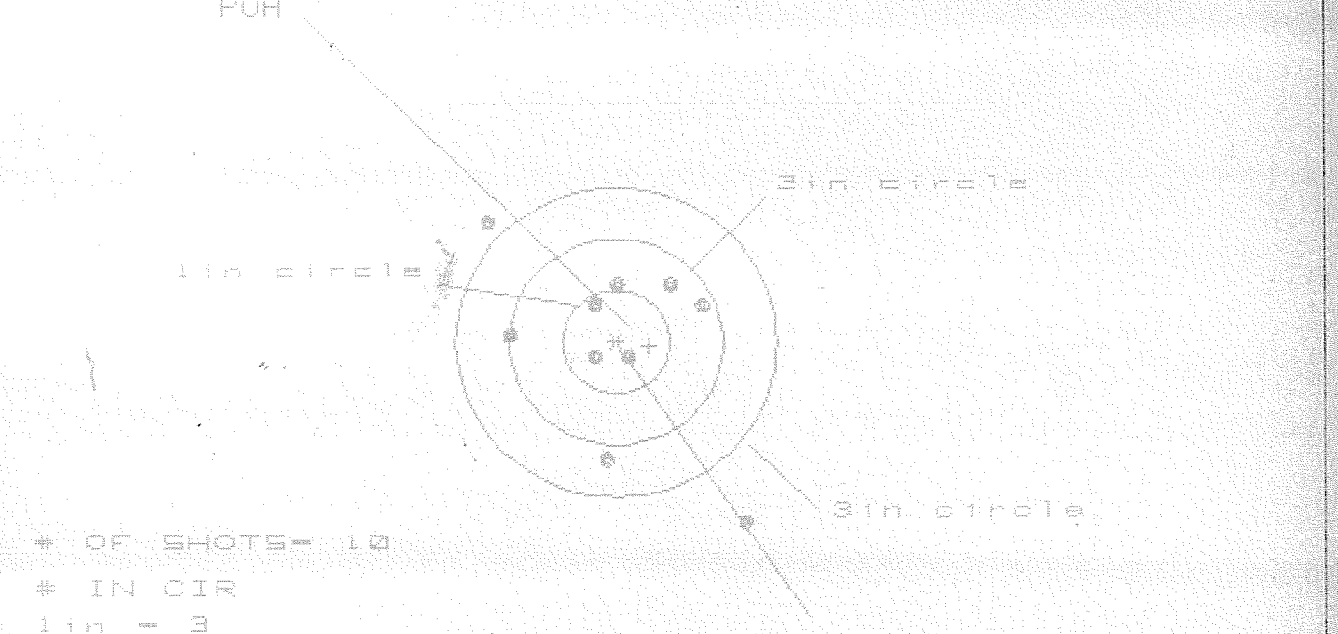
#	IN CIR
1in	= 2
2in	= 4
3in	= 6

HS= 2.088
VS= 3.826
GS= 3.831

PATTERN #	:	[redacted]		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.325	1.341	1.385
MINIMUM X	:	-.763	-.747	-.703
MAXIMUM Y	:	1.846	1.626	1.667
MINIMUM Y	:	-1.980	-1.131	-.927
CENTROID X	:	-.102	-.118	-.162
CENTROID Y	:	-.285	-.065	-.269
POA TO CENTROID in.	:	.303	.135	.314
MIN RADIUS	:	.349	.443	.296
MEAN RADIUS	:	1.151	1.074	.949
MAX RADIUS	:	1.984	1.665	1.667
HORIZONTAL SPREAD	:	2.088	2.088	2.088
VERTICAL SPREAD	:	3.826	2.757	2.594
EXTREME SPREAD	:	3.831	2.970	2.769
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		6	

24 Sep 1991 FILE:/PATTERNING/CENTERFIRE_PATT/C8225382

CENTERFIRE PATTERNS # 2



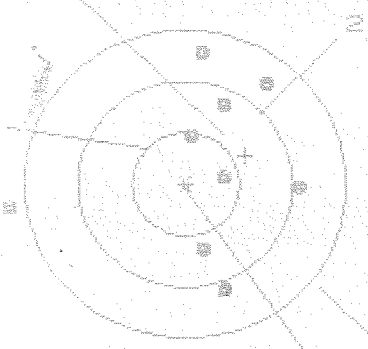
OF SHOTS= 10
IN CIR
1 in = 3
2 in = 7
3 in = 8

HS= 2.382
VS= 2.891
CS= 3.746

PATTERN #			
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.207	.963	.832
MINIMUM X	-1.175	-1.041	-.982
MAXIMUM Y	1.135	.940	.519
MINIMUM Y	-1.756	-1.344	-1.226
CENTROID X	-.304	-.439	-.308
CENTROID Y	.040	.235	.117
POA TO CENTROID in.	.307	.497	.330
MIN RADIUS	.163	.213	.218
MEAN RADIUS	.907	.747	.656
MAX RADIUS	2.130	1.403	1.228
HORIZONTAL SPREAD	2.382	2.004	1.814
VERTICAL SPREAD	2.891	2.284	1.745
EXTREME SPREAD	3.746	2.537	1.848
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		8	

24 Sep 1991 FILE:/PATTERNING/CENTERFIRE_PATT/CG225382

CENTERFIRE PATTERNS # 3



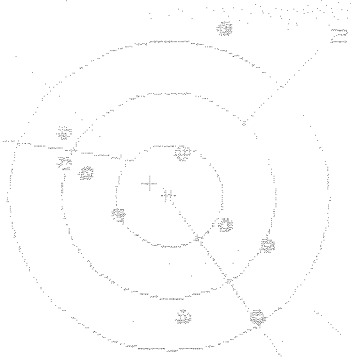
# OF SHOTS= 10 *
# IN CIR
1in = 2
2in = 4
3in = 8
HS= 2.673
VS= 2.962
GS= 3.540

PATTERN #	:	[redacted]		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.013	.840	.611
MINIMUM X	:	-1.660	-1.833	-.350
MAXIMUM Y	:	1.269	1.081	1.026
MINIMUM Y	:	-1.693	-1.188	-1.243
CENTROID X	:	-.557	-.384	-.155
CENTROID Y	:	-1.276	-.088	-.033
POA TO CENTROID in.	:	.621	.394	.158
MIN RADIUS	:	.358	.208	.172
MEAN RADIUS	:	1.095	.891	.733
MAX RADIUS	:	2.299	1.885	1.244
HORIZONTAL SPREAD	:	2.673	2.673	.961
VERTICAL SPREAD	:	2.962	2.269	2.269
EXTREME SPREAD	:	3.540	2.705	2.275
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	

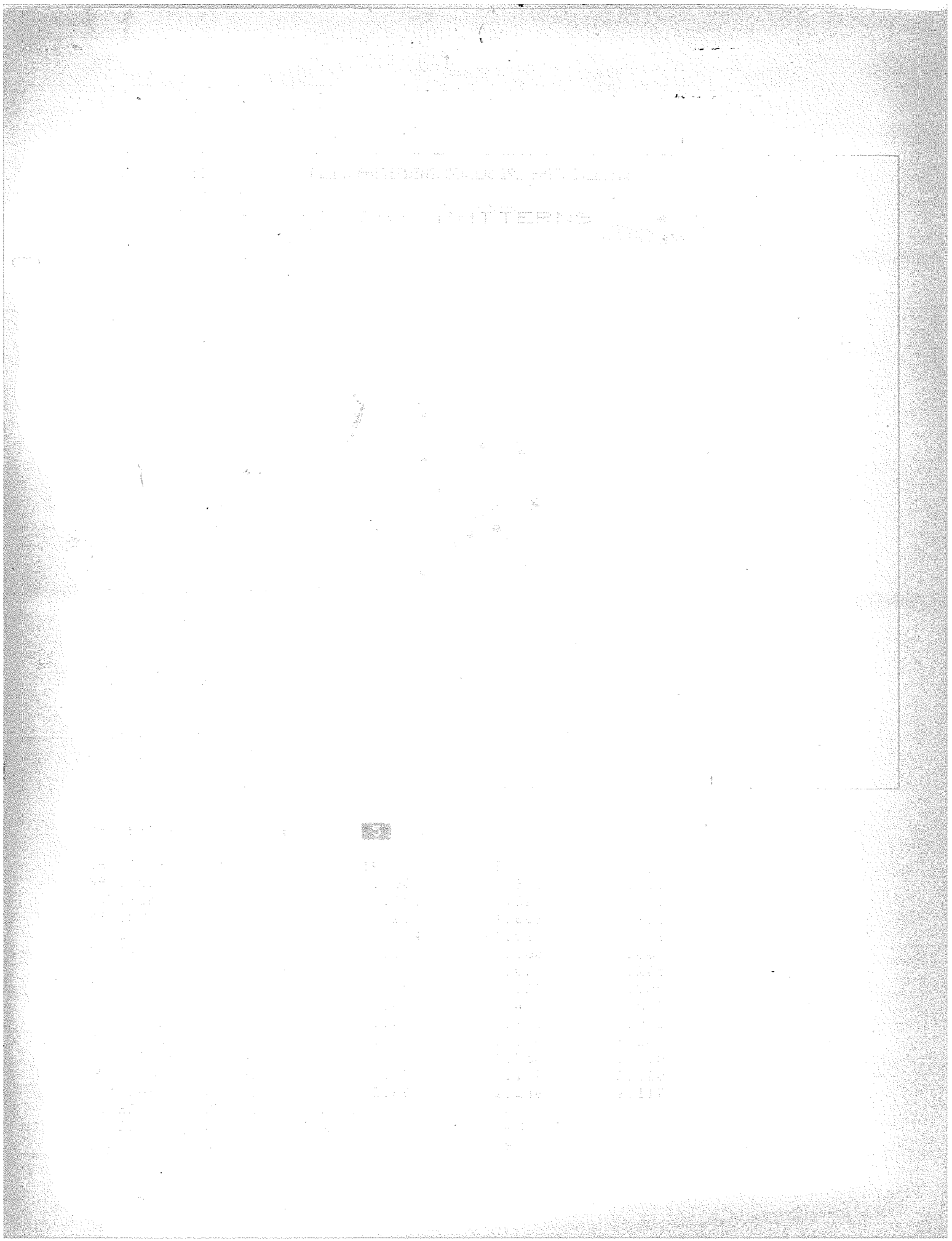
24 Sep 1991 FILE: PATTERNING/CENTERFIRE_PATT/C0625SBE

CENTERFIRE PATTERNS # 4

POA



PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.964	1.019	1.128
MINIMUM X	:	-.957	-.912	-.803
MAXIMUM Y	:	1.617	.832	.719
MINIMUM Y	:	-1.220	-1.041	-1.160
CENTROID X	:	.180	.125	.016
CENTROID Y	:	-.121	-.300	-.181
POA TO CENTROID	:	.217	.325	.181
MIN RADIUS	:	.468	.433	.341
MEAN RADIUS	:	.992	.906	.832
MAX RADIUS	:	1.692	1.293	1.204
HORIZONTAL SPREAD	:	1.931	1.931	1.931
VERTICAL SPREAD	:	2.837	1.873	1.873
EXTREME SPREAD	:	2.858	2.525	2.221
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	



RECEIVING AND ESTIMATING REPORT

COMMENTS: WOG 1 OF 7 M-24 ATTN: FRED MARTIN -- W/ADJUSTABLE RECOIL PAD

ORDER: R 93-26579

INITIAL	CUSTOMER ORDER NO.
EPS	8326

DATE RECEIVED	DATE OPENED	DATE CODE	SERIAL NUMBER	NEW SERIAL NUMBER	MODEL AND GRADE
12/09/93	12/09/93	OL 7-91	C6225382		700 7.62 NATO

ACCESSORIES: W/STUDS SCOPE BASE

FROM:

U. S. ARMY
THOMPSON, ALLAN R
CO. D 2ND BN. 1ST SWTG
FT BRAGG NC 28307

SHIP TO:

U. S. ARMY
THOMPSON, ALLAN R
CO. D 2ND BN. 1ST SWTG
FT BRAGG NC 28307

CUST NO: 086383 C.O.D

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

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: Replace Barrel ASSY

PARTS:
Barrel ASSY — 96003
Front Sight Mounting Base - 9601

COMMENTS:
Re zinc - Scope Base & Swivel Studs
Repowder Coat - Floor plate latch, Trigger Guard & Rear Sight Base

W52 H09401 H229

REPAIRMAN	PROOF	CLEAN	TEST	TARGET	PATTERN
RW	✓	✓	✓	✓	
GALLERY TESTER	**DATE**	**DATE**	**DATE**	**DATE**	**DATE**
RW	12/16/93	12/28/93	12/29/93	12/29/93	

OFFICE COPY

RD6925 REV. 1/92

RD-6947-Rev 3

PAYMENT:
Mastercard / Visa *(circle one)*
Card #:_____
Exp. Date:_____
Signature_____

RETURN:
☐ Clark Street Entrance
☐ Via US Mail or UPS

(PLEASE PRINT CLEARLY)

FIREARMS DELIVERED TO PLANT

FILE No 008326

DATE 12/9/93

CUSTOMER NAME: U.S. ARMY THOMPSON ALLAN R

ADDRESS: D CO 2BN 1ST SIGTG
FT BRAGG N.C.

ZIP: 28307

PHONE: 432-9037

REMINGTON EMPLOYEE:
YES ☐ NO ☑
EMPLOYEE # _____
DEPT. # _____

FIREARM MODEL: 84

CHECK FOR AMMUNITION ✓

GAUGE: 762

SERIAL # C6225233, C6225379, C6225229, C6225414, C6225382, C6225341, C6225390

CONDITION:

WOOD	GOOD	FAIR	POOR	FANCY	PLAIN
METAL	GOOD	FAIR	POOR	FANCY	PLAIN
BARREL	VT. RIB	PLAIN	DEER RSS		

ACCESSORIES:

SCOPE: YES (NO) (BRAND NAME/POWER)_____

SLING: YES (NO) GUN CASE: YES (NO) (HARD - SOFT)

EXTRA BBL FOR GUN MENTIONED ABOVE:

OTHER (Note in this area items missing or added from orig. equipment)

CUSTOMER REQUEST: REBARREL — ALLAN FRED MARTIN

SIGNATURE: Allan Thompson DATE: 12/9/93
(Person delivering firearm to Plant)

SIGNATURE: Ronald J Bailey DATE: 12/9/93
(Security Officer)

SIGNATURE: Richard Wright DATE: 12/9/93
(Firearm picked up by)

Arm Service Copy

CONTRACT # DAAA21-87-C-0086 New Barrel

GUN SERIAL # C6225382

OP. #	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and Stock		12/16/93	RW
600	Proof		12/16/93	RW
607	Check Headspace		12/16/93	RW
610	Dis-assemble Gun		12/16/93	RW
612	Magnaflux Barrel Action			
	Magnaflux Bolt			
615	Rollmark Caliber			
617	Drill and Tap Sight Holes			
618	Polish Barrel			
620	Apply Coatings (Barrel Action)			
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		12/28/93	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		12/28/93	RW
	C) Inspect Ejector Hole for Chamfer		12/28/93	RW
	D) Oil Firing Pin Ass'y		12/28/93	RW
	E) Adjust Trigger Pull to Min Setting and Stake			

op. #	OP. NAME	READINGS	DATE	INIT
635 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		12/29/93	RW
	A) Time			
	B) Malfunctions			
	C) Pierced Primers			
	D) Optical Clearity of Scope			
645	Inspect for Live Ammo		12/29/93	RW
655	Final Inspection A) Headspace		1/3/94	RW
	B) Trigger Pull	2.49 | 2.41 | 2.48 | 2.59 | 2.68	1/3/94	RW
	C) Function		1/3/94	RW
660	Pack			

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6225382
11 Jan 1994

CENTROIDAL DISTANCES

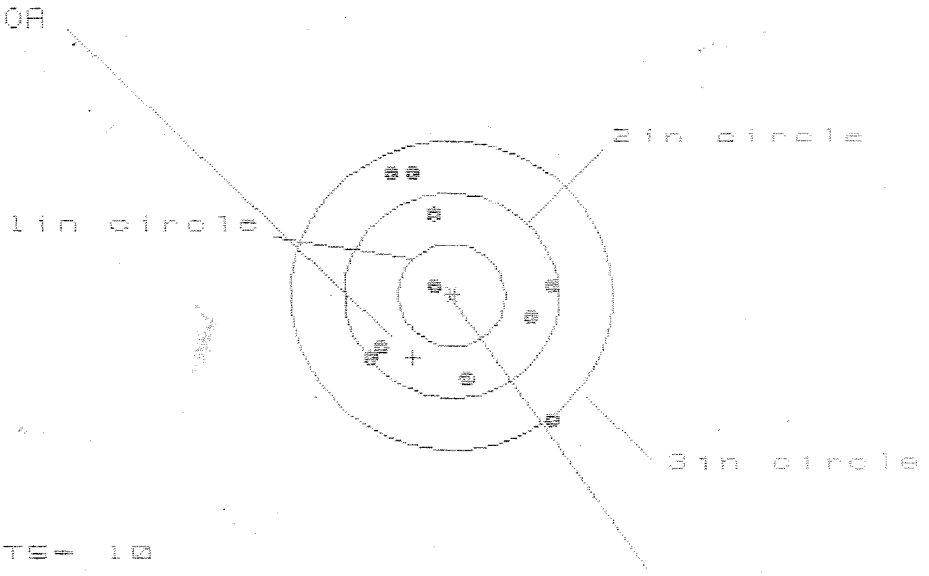
0	TO	1	.711891
1	TO	2	.847257
1	TO	3	.600787
1	TO	4	.444605
1	TO	5	.609147

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .277
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1524
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .316156

THE AMR FOR THIS RIFLE IS: 1.017

11 Jan 1994 FILE:/PATTERNING/CENTERFIRE_PATT/C022538B2

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

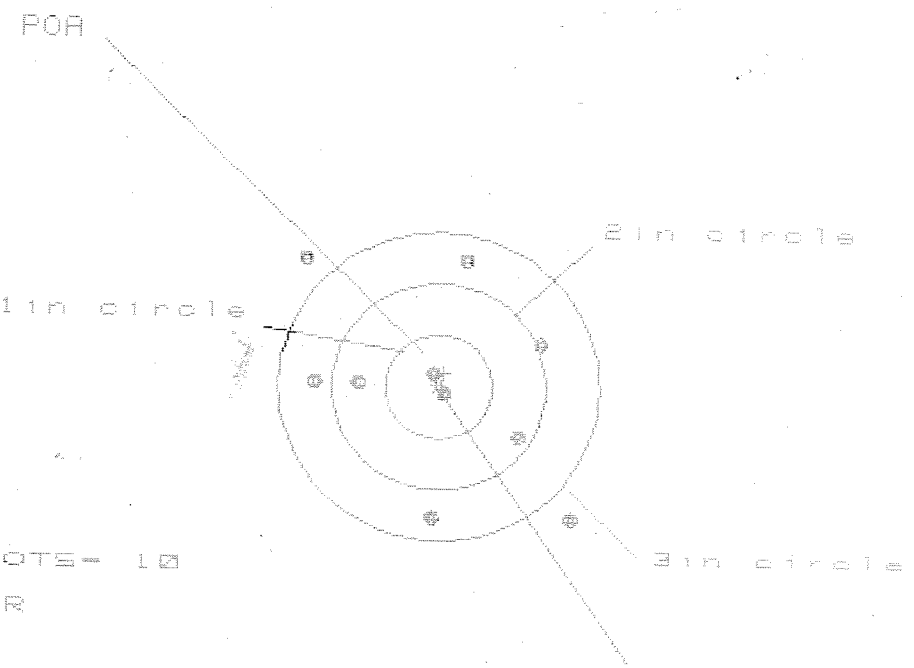
# IN CIR
1in = 1
2in = 7
3in = 9

HS= 1.726
VS= 2.436
GS= 2.864

PATTERN #	:	[redacted]		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.948	1.006	.950
MINIMUM X	:	-.778	-.673	-.730
MAXIMUM Y	:	1.212	1.077	1.140
MINIMUM Y	:	-1.224	-.928	-.794
CENTROID X	:	.367	.262	.319
CENTROID Y	:	.610	.746	.612
POA TO CENTROID in.	:	.712	.791	.690
MIN RADIUS	:	.153	.073	.111
MEAN RADIUS	:	.934	.850	.802
MAX RADIUS	:	1.548	1.168	1.188
HORIZONTAL SPREAD	:	1.726	1.679	1.679
VERTICAL SPREAD	:	2.436	2.005	1.934
EXTREME SPREAD	:	2.864	2.112	1.994
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

11 Jan 1994 FILE:/PATTERNING/CENTERFIRE_PATT/C0E2538E

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

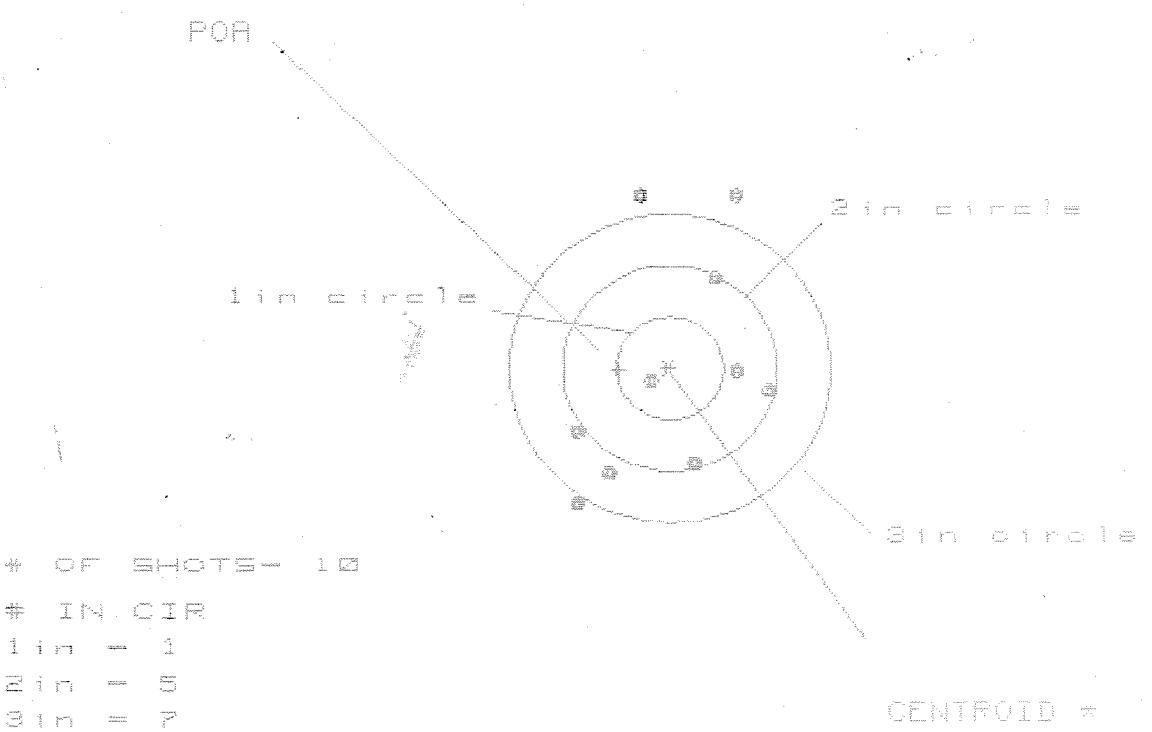
# IN CIR
1in = 2
2in = 4
3in = 8

HS= 2.514
VS= 2.547
GS= 3.579

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.241	1.124	.982
MINIMUM X	:	-1.273	-1.135	-1.128
MAXIMUM Y	:	1.248	1.104	1.212
MINIMUM Y	:	-1.299	-1.389	-1.251
CENTROID X	:	-.042	-.180	-.038
CENTROID Y	:	-.132	.012	-.126
POA TO CENTROID in.	:	.139	.180	.131
MIN RADIUS	:	.111	.086	.117
MEAN RADIUS	:	1.017	.930	.824
MAX RADIUS	:	1.796	1.584	1.254
HORIZONTAL SPREAD	:	2.514	2.250	2.110
VERTICAL SPREAD	:	2.547	2.490	2.463
EXTREME SPREAD	:	3.579	2.766	2.486
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	

11 Jan 1994 FILE:/PATTERNING/CENTERFIRE_PATT/CB225382

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

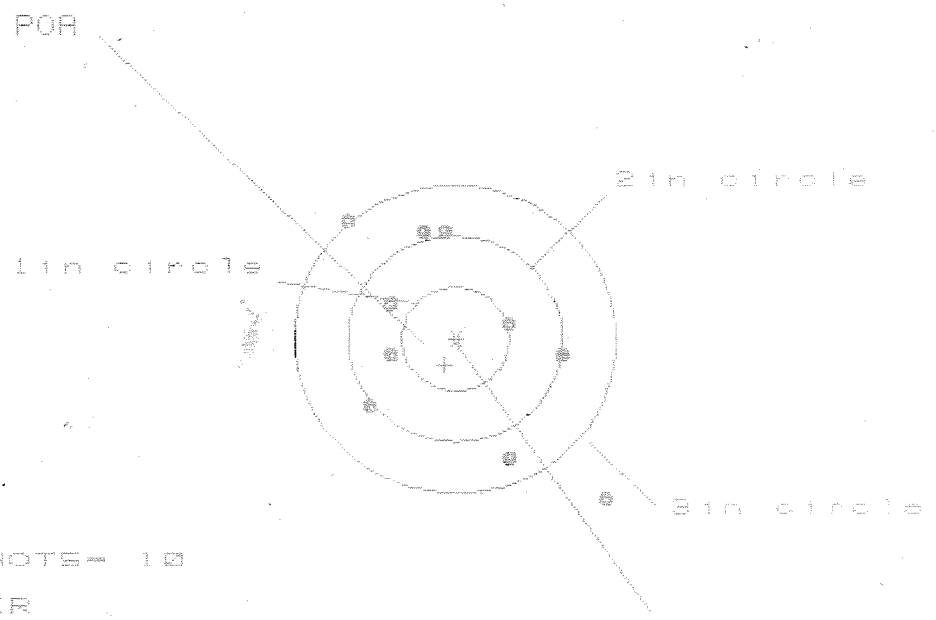
# IN CIR
1in = 1
2in = 5
3in = 7

HS= 1.815
VS= 3.021
GS= 3.331

PATTERN #	:	3	
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.950	1.014	.983
MINIMUM X	:	-.866	-.802	-.833
MAXIMUM Y	:	1.692	1.878	1.340
MINIMUM Y	:	-1.329	-1.143	-.908
CENTROID X	:	.475	.411	.442
CENTROID Y	:	.019	-.167	-.402
POA TO CENTROID in.	:	.475	.444	.597
MIN RADIUS	:	.200	.159	.372
MEAN RADIUS	:	1.104	1.002	.871
MAX RADIUS	:	1.771	1.895	1.404
HORIZONTAL SPREAD	:	1.816	1.816	1.816
VERTICAL SPREAD	:	3.021	3.021	2.248
EXTREME SPREAD	:	3.331	3.072	2.574
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		7	

01 Jan 1994 FILE:/PATTERNING/CENTERFIRE_PATT/C6225382

CENTERFIRE PATTERNS # 4



\# OF SHOTS= 10

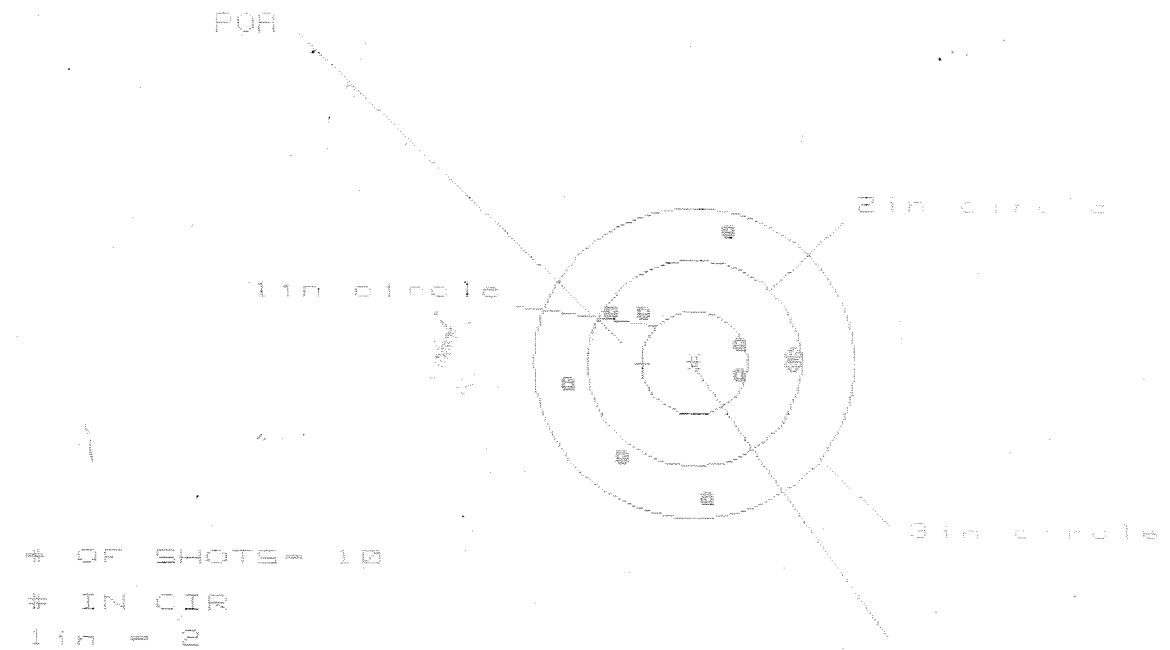
\# IN CIR
1in = 0
2in = 3
3in = 9

HS= 2.378
VS= 2.626
CS= 3.543

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.406	1.185	1.083
MINIMUM X	:	-.971	-.815	-.711
MAXIMUM Y	:	1.110	.942	1.014
MINIMUM Y	:	-1.516	-1.350	-1.233
CENTROID X	:	.102	-.054	.048
CENTROID Y	:	.253	.421	.304
POA TO CENTROID in.	:	.273	.425	.307
MIN RADIUS	:	.544	.497	.587
MEAN RADIUS	:	1.093	.948	.916
MAX RADIUS	:	2.068	1.493	1.344
HORIZONTAL SPREAD	:	2.378	2.000	1.794
VERTICAL SPREAD	:	2.626	2.292	2.247
EXTREME SPREAD	:	3.543	2.714	2.359
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		9	

11 Jan 1994 FILE:/PATTERNING/CENTERFIRE_PATT/C62253B2

CENTERFIRE PATTERNS # 5



OF SHOTS= 10

# IN CIR
1in = 2
2in = 5
3in = 10

HS= 2.113
VS= 2.573
GS= 2.581

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.926	.958	.974
MINIMUM X	:	-1.187	-1.155	-1.139
MAXIMUM Y	:	1.286	.672	.530
MINIMUM Y	:	-1.277	-1.133	-.871
CENTROID X	:	.483	.451	.435
CENTROID Y	:	.012	-.132	.010
POA TO CENTROID in.	:	.483	.470	.435
MIN RADIUS	:	.485	.491	.530
MEAN RADIUS	:	.936	.895	.848
MAX RADIUS	:	1.329	1.160	1.167
HORIZONTAL SPREAD	:	2.113	2.113	2.113
VERTICAL SPREAD	:	2.573	1.805	1.401
EXTREME SPREAD	:	2.581	2.147	2.147
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	

RECEIVING AND ESTIMATING REPORT

CUST NO: 046771 C.O.D

COMMENTS: M-24 SNIPER

INITIAL	CUSTOMER ORDER NO.
JJM	006252

DATE RECEIVED	DATE OPENED	DATE CODE	SERIAL NUMBER	MODEL AND GRADE	ORDER
07/29/91	07/29/91	KI 5-88	C6225382	700 7.62 NATO	R 91-14521

ACCESSORIES: W/STUDS SCOPE BASE

FROM:

CO D 2ND BN 1ST SPWAR TNG GP
C/O CPT M K STEPHENSON
FT BRAGG NC 28307
USA

SHIP TO:

CO D 2ND BN 1ST SPWAR TNG GP
C/O CPT M K STEPHENSON
FT BRAGG NC
USA 28307

ACCOUNT NUMBER	ACCOUNT NUMBER N/C		PROM. DATE	ESTIMATED	VIA
		WRITE ☐ CLEAN/TEST			DOOR

REPAIR CHARGE	TAX	INSURANCE	UPS	PARCEL POST	TOTAL

GUN CONDITION: ☐ NEW ☐ SLIGHTLY WORN ☑ VERY WORN ☐ MISUSED ☐ MARRED

CUSTOMER'S REQUEST

1) NEW BARREL
2) RE-BLUE - COAT TRIGGER GUARD ASSY
3) CLEAN FIRE CONTROL

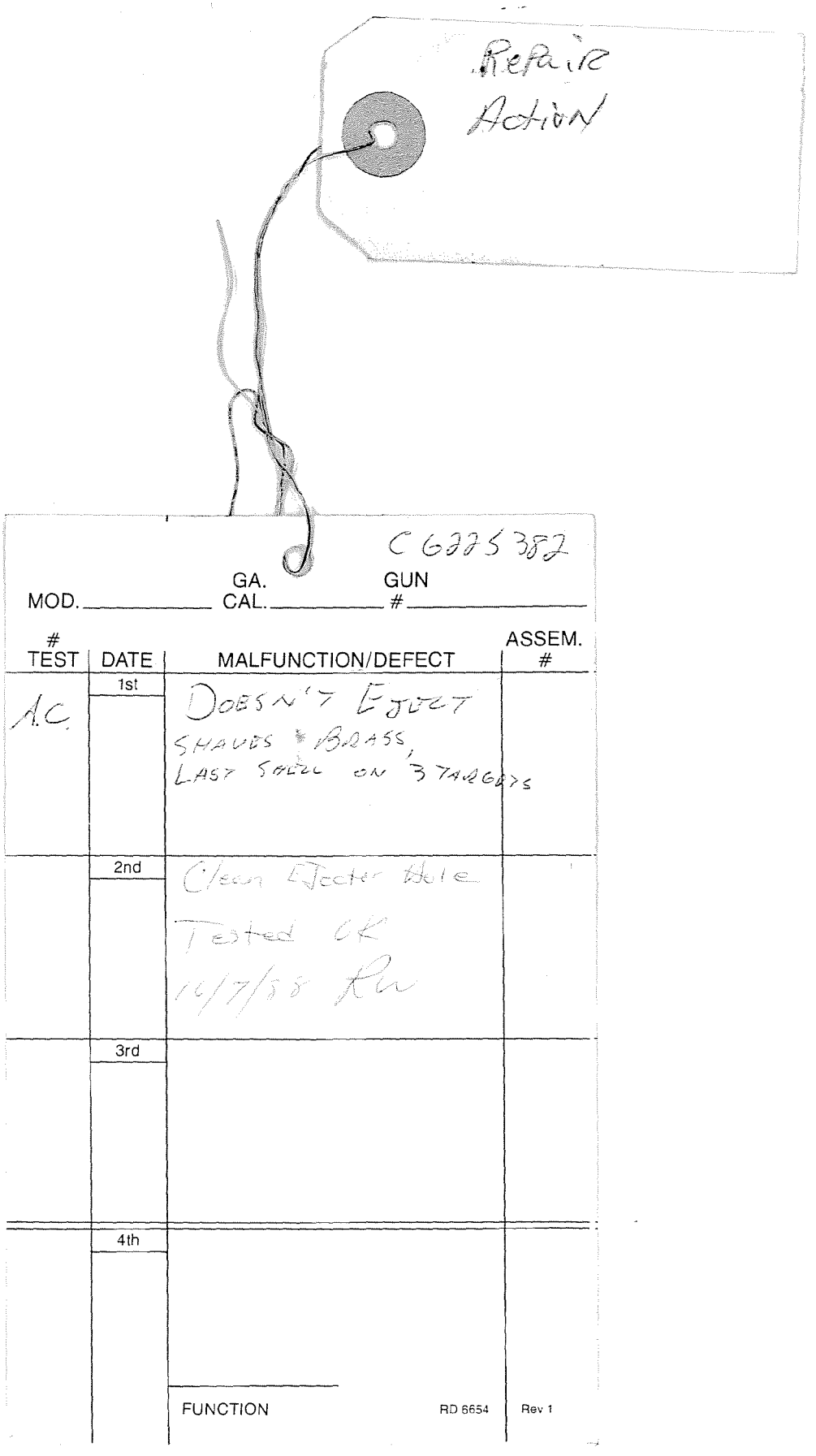
MAIN FAULT

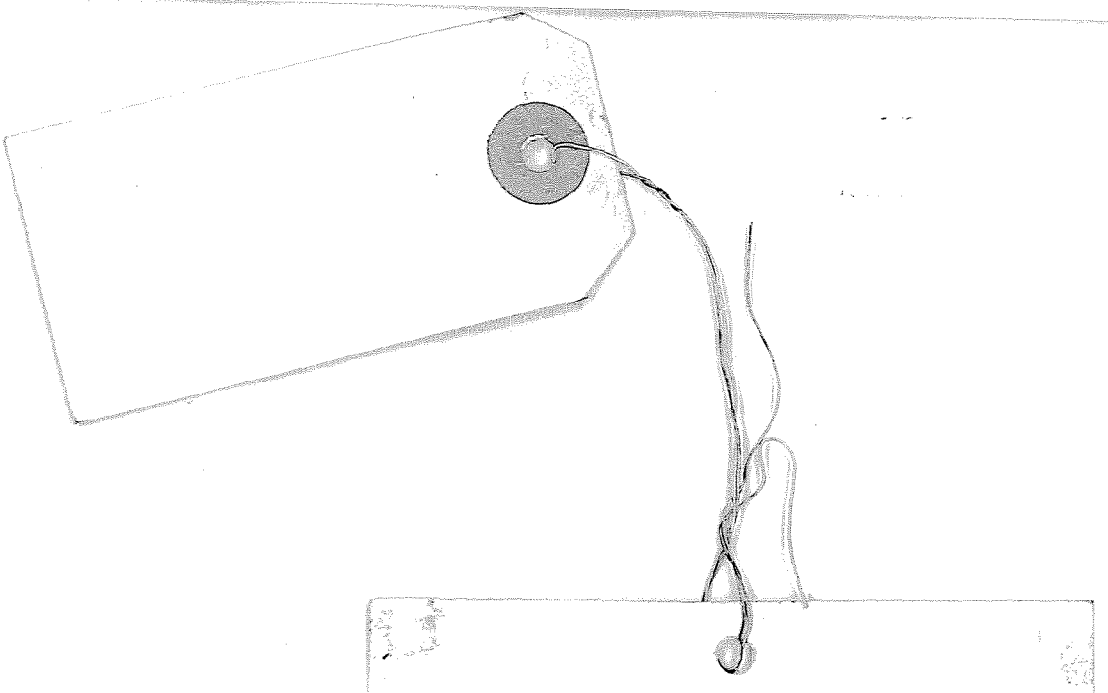
PARTS

REPAIRMAN	PROOF	CLEAN	TEST	TARGET	PATTERN
RW	✓	D.H	D.H.	D.H.	
GALLERY TESTER	**DATE**	**DATE**	**DATE**	**DATE**	**DATE**
D.H	9/29/91	Sept 24	Sept 24	Sept 24	

OFFICE COPY

RD6925 REV. 7/90


Repair
Action
C6225382
MOD.
GA.
CAL.
GUN
#
TEST
DATE
MALFUNCTION/DEFECT
ASSEM. #
1st
A.C.
DOESN'T EJECT
SHAVES * BOASS,
LAST SHELL ON 3 TARGETS
2nd
Clean Ejector hole
Tested OK
11/7/08 Rw
3rd
4th
FUNCTION
RD 6654
Rev 1



TEST	INIT.	ACTION TO CORRECT	ASSEM. #
PROOF			
TEST			
TGT			
PROOF			
TEST			
TGT			
		ENGINEER	
PROOF			
TEST			
TGT			
		ENGINEER	
PROOF			
TEST			
TGT			

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6225382

OPERATION #	OPERATION NAME	DATE	INT
575-580	ASSEMBLY	2 26	FB
600	PROOF	29	RW
615	MAGNAFLUX BARREL	5/13/88	pfe.
	MAGNAFLUX BOLT	5/13/88	pfe.
620	COATING	8/11/88	TJA
625-630	FINAL ASSEMBLY		
635	TEST		
640	TARGET		
	FIRING PIN INDENT		
660	PACK		

Scope #
1126

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6225382

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

OVER

OP.#		READINGS	DATE	INITIAL
625 cont.	D) Oil Firing Pin Ass'y		9/9/88	RW
	E) Adjust Trigger Pull to Min. Setting and Stake		9Sept.88	JW+DS
	F) Safety on Force	6 | 6 | 5.5	9Sept88	JW+DS
	G) Safety off Force	3 | 3 | 3	9Sept.88	JW+DS
	H) Trigger Pull Test & Retainabilty		9Sept.88	JW+DS
	I) Firing Pin Indent	.023 | .0225 | .0225	9Sept88	JW+DS
	J) Assemble Stock		9/20/88	RW
	K) Assemble Swivel Studs		10-7-88	DS
	L) Attach Front & Rear Sight Assemblies		9/20/88	RW
	M) Iron Sight Alignment		9/20/88	RW
	N) Detach Front & Rear Sights & place in numbered container		9/20/88	RW
	0) Attach Scope to Rifle		10/3/88	RW
	P) Detach & Attach Scope 20 times		10/4/88	DS
640	Gallery Target & Test	56 R 99L	10-6-88	AC
	A) Optical Clearity of Scope	OK	10-6-88	AC
645	Inspect for Live Ammo	none	10-6-88	AC
655	Final Inspection A) Headspace		10-7-88	DS
	B) Trigger Pull		10-7-88	DS
	C) Function		10-7-88	DS
660	Pack	OK	10/20/88	W.B.

SWS TRIGGER PULL TEST

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

SERIAL NO. C625382

DATE 9 Sept. 88

TESTER JW-RS

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.66	2.16	2.44	2.91	MIN. SETTING,
PULL #2	2.72	2.25	2.46	2.90	NO AVG. OF 5
PULL #3	2.67	2.31	2.54	2.90	READINGS ACCEPT-
PULL #4	2.56	2.31	2.36	2.83	ABLE LESS THAN 2#
PULL #5	2.53	2.23	2.56	2.85	
TOTAL	13.13	11.26	12.36	14.39	
AVG.	2.626	2.252	2.472	2.878	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.04	2.86		
PULL #2	2.99	3.24		
PULL #3	2.99	3.15		
PULL #4	2.99	3.06		
PULL #5	3.05	3.16		
TOTAL	15.06	15.46		
AVG.	3.012	3.092		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.16	4.02		4.28
PULL #2	4.17	4.10		4.30
PULL #3	4.20	4.14		4.33
PULL #4	4.19	4.15		4.35
PULL #5	4.19	4.18		4.36
TOTAL	20.91	20.59		21.62
AVG.	4.182	4.118		4.324

RECEIVING AND ESTIMATING REPORT

COMMENTS: SNIPER M-24

ORDER: R 96-02141

INITIAL	CUSTOMER ORDER NO.
FPS	10799

DATE RECEIVED	DATE OPENED	DATE CODE	SERIAL NUMBER	NEW SERIAL NUMBER	MODEL AND GRADE
01/11/96	01/17/96		C6225382		700 7.62 NATO

ACCESSORIES: W/STUDS SCOPE BASE SOFT CASE

FROM:

DEMAREST, WARREN C.
D CO. 2ND BN. 1ST SWTG
FT BRAGG NC 28307

SHIP TO:

COMMANDER
~~DEMAREST, WARREN C.~~
D CO. 2ND BN. 1ST SWTG
FT BRAGG NC 28307

CUST NO: 135950 C.O.D

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

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

PARTS

W52H096017#345

Barrel - 96003
Stock - 96018
Firing pin Assy - 96007
Front Sight Base - 18544

COMMENTS

Re powder Coat Trigger Guard Assy & Rear Sight Base. Re-Lic Scope Base & Swivel Studs.

REPAIRMAN	PROOF	CLEAN	TEST	TARGET	PATTERN
RW	✓	✓	WB	WB	

GALLERY TESTER	DATE	DATE	DATE	DATE	DATE
RW	1/29/96	1/31/96	1/31/96	1/31/96	

OFFICE COPY

RD6925 REV. 1/94

RD-6947-Rev 3
PAYMENT:
Mastercard / Visa *(circle one)*
Card #:_____
Exp. Date:_____
Signature_____
RETURN:
☐ Clark Street Entrance
☑ Via US Mail or UPS

(PLEASE PRINT CLEARLY)

FIREARMS DELIVERED TO PLANT

FILE No. 010799

DATE 1/17/96

CUSTOMER NAME: WARREN C DEMAREST

REMINGTON EMPLOYEE:
YES ☐ NO ☑

ADDRESS: D CO 2ND BN 15 WTG

EMPLOYEE # _____

FT. [redacted] 28307

DEPT. # _____

ZIP: [redacted] 28307

PHONE: (910) 432-9037

FIREARM MODEL: M24

CHECK FOR AMMUNITION

GAUGE: 7.62

SERIAL # C629782

CONDITION:

WOOD	GOOD	FAIR	POOR	FANCY	PLAIN
METAL	GOOD	FAIR	POOR	FANCY	PLAIN
BARREL	VT. RIB	PLAIN	DEER RSS		

ACCESSORIES:

SCOPE: YES NO (BRAND NAME/POWER)_____

SLING: YES NO GUN CASE: YES NO (HARD - SOFT)

EXTRA BBL FOR GUN MENTIONED ABOVE:

OTHER (Note in this area items missing or added from orig. equipment)

_____

CUSTOMER REQUEST: REPAIR PER CONTRACT

_____

SIGNATURE: Warren C Demarest DATE: 17 JAN 96
(Person delivering firearm to Plant)

SIGNATURE: [illegible] DATE: 1/17/96
(Security Officer)

SIGNATURE: Richard Wright DATE: _____
(Firearm picked up by)

Arm Service Copy

CONTRACT # DAAA21-87-C-0086 New Barrel & Stock

GUN SERIAL # C6225382

OP. #	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and Stock		1/23/96	RW
600	Proof		1/23/96	RW
607	Check Headspace		1/23/96	RW
610	Dis-assemble Gun		1/23/96	RW
612	Magnaflux Barrel Action			
	Magnaflux Bolt			
615	Rollmark Caliber			
617	Drill and Tap Sight Holes			
618	Polish Barrel			
620	Apply Coatings (Barrel Action)			
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		1/27/96	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		1/27/96	RW
	C) Inspect Ejector Hole for Chamfer		1/27/96	RW
	D) Oil Firing Pin Ass'y		1/27/96	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		1/27/96	RW
	K) Assemble Swivel Studs			
	L) Attach Front and Rear Sight Assemblies			
	M) Iron Sight Alignment			
	N) Detach Front & Rear Sights & place in numbered container			
	O) Attach Scope to Rifle			
	P) Detach & Attach Scope 20 Times			
640	Gallery Target & Test		1/31/96	WB
	A) Time			
	B) Malfunctions			
	C) Pierced Primers			
	D) Optical Clearity of Scope			
645	Inspect for Live Ammo		1/31/96	WB
655	Final Inspection A) Headspace		2/1/96	RW
	B) Trigger Pull			
	C) Function		2/1/96	RW
660	Pack			

SWS/Repair

Final Inspection

S/N: C6225382	DATE REC'D: 1/17/96	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: _____

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6225382
3 Jan 1900

CENTROIDAL DISTANCES

0	TO	1	1.65309
1	TO	2	.27236
1	TO	3	.126127
1	TO	4	.28008
1	TO	5	.414276

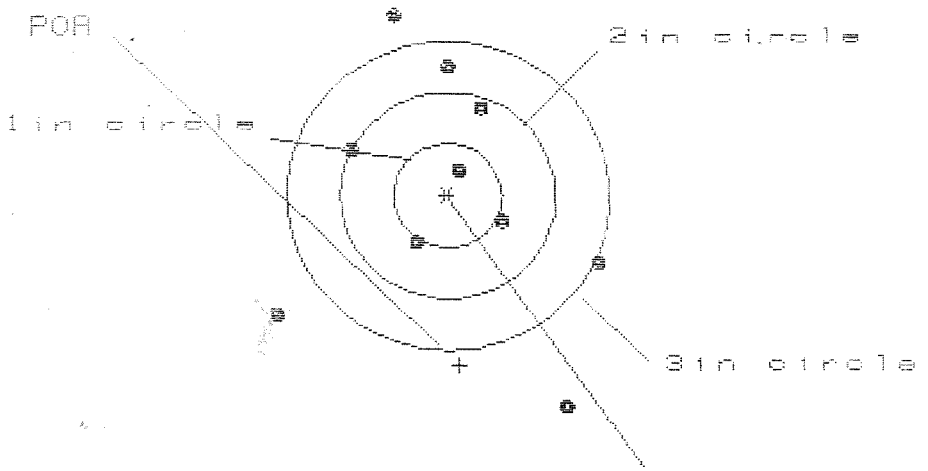
+ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1528
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: 1.7216
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: 1.72840

THE AMR FOR THIS RIFLE IS: .9948

2 Jan 1900 FILE:/PATTERNING/CENTERFIRE_PATT/C6225382

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

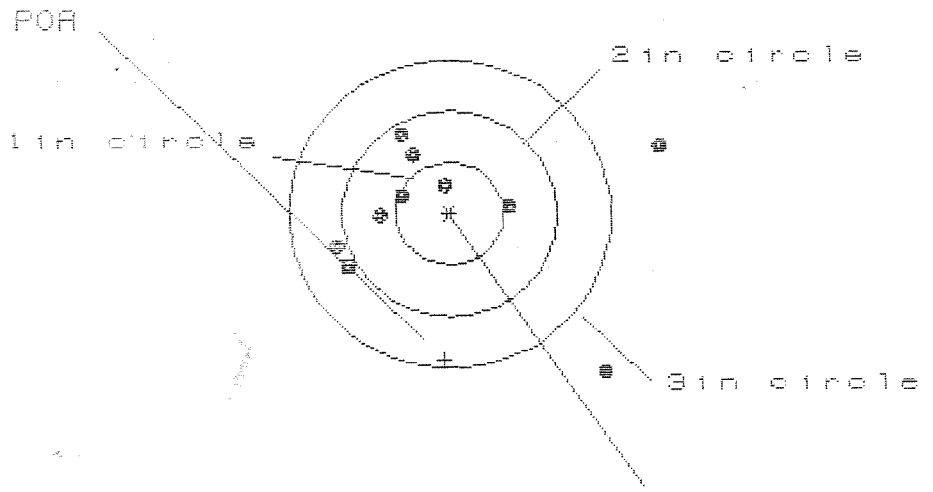
# IN CIR
1in = 1
2in = 5
3in = 6

HS= 2.933
VS= 3.804
GS= 4.133

PATTERN #	:	[redacted]		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.374	1.492	1.312
MINIMUM X	:	-1.559	-1.441	-.940
MAXIMUM Y	:	1.764	1.537	1.362
MINIMUM Y	:	-2.040	-1.400	-1.067
CENTROID X	:	-.101	-.219	-.039
CENTROID Y	:	1.650	1.877	2.052
POA TO CENTROID in.	:	1.653	1.890	2.052
MIN RADIUS	:	.275	.215	.146
MEAN RADIUS	:	1.215	1.068	.918
MAX RADIUS	:	2.303	2.009	1.691
HORIZONTAL SPREAD	:	2.933	2.933	2.252
VERTICAL SPREAD	:	3.804	2.937	2.429
EXTREME SPREAD	:	4.133	3.106	3.097
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		6	

2 Jan 1900 FILE:/PATTERNING/CENTERFIRE_PATT/C0225382

CENTERFIRE PATTERNS # 2



* OF SHOTS= 10 CENTROID *

# IN CIR	
1in	2
2in	6
3in	8

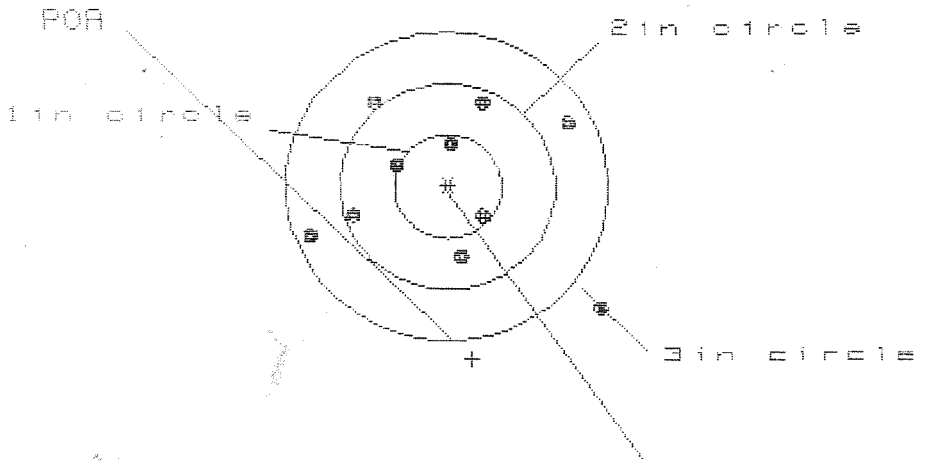
HS= 3.039
VS= 2.257
GS= 3.221

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.958	2.123	.988
MINIMUM X	:	-1.081	-.916	-.650
MAXIMUM Y	:	.735	.566	.634
MINIMUM Y	:	-1.522	-.731	-.663
CENTROID X	:	.051	-.114	-.380
CENTROID Y	:	1.424	1.593	1.525
POA TO CENTROID in.	:	1.425	1.597	1.572
MIN RADIUS	:	.260	.100	.106
MEAN RADIUS	:	.989	.776	.553
MAX RADIUS	:	2.127	2.192	.990
HORIZONTAL SPREAD	:	3.039	3.039	1.638
VERTICAL SPREAD	:	2.257	1.297	1.297
EXTREME SPREAD	:	3.221	3.221	1.682

NUMBER IN ONE INCH CIRCLE	=	2
NUMBER IN TWO INCH CIRCLE	=	6
NUMBER IN THREE INCH CIRCLE	=	8

2 Jan 1900 FILE:/PATTERNING/CENTERFIRE_PATT/C022538Z

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

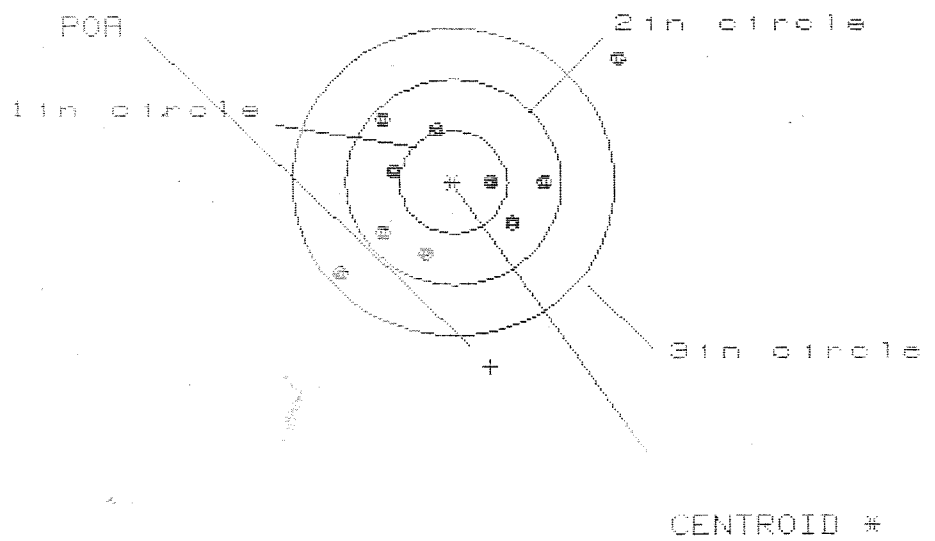
# IN CIR
1in = 2
2in = 7
3in = 8

HS= 2.757
VS= 2.053
GS= 2.869

PATTERN #	:	3	
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.443	1.260	1.116
MINIMUM X	:	-1.314	-1.154	-.908
MAXIMUM Y	:	.838	.703	.625
MINIMUM Y	:	-1.215	-.821	-.899
CENTROID X	:	-.223	-.383	-.239
CENTROID Y	:	1.682	1.817	1.895
POA TO CENTROID in.	:	1.697	1.857	1.910
MIN RADIUS	:	.393	.328	.188
MEAN RADIUS	:	.946	.816	.739
MAX RADIUS	:	1.887	1.358	1.195
HORIZONTAL SPREAD	:	2.757	2.414	2.024
VERTICAL SPREAD	:	2.053	1.524	1.524
EXTREME SPREAD	:	2.869	2.663	2.205
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

2 Jan 1900 FILE:/PATTERNING/CENTERFIRE_PATT/C02253B2

CENTERFIRE PATTERNS # 4



OF SHOTS= 10

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

HS= 2.537
VS= 2.109
GS= 3.299

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.496	1.019	.910
MINIMUM X	:	-1.041	-.875	-.627
MAXIMUM Y	:	1.182	.714	.615
MINIMUM Y	:	-.927	-.796	-.673
CENTROID X	:	-.343	-.509	-.400
CENTROID Y	:	1.791	1.660	1.759
POA TO CENTROID in.	:	1.823	1.736	1.804
MIN RADIUS	:	.382	.450	.443
MEAN RADIUS	:	.886	.758	.694
MAX RADIUS	:	1.907	1.183	.913
HORIZONTAL SPREAD	:	2.537	1.894	1.537
VERTICAL SPREAD	:	2.109	1.510	1.288
EXTREME SPREAD	:	3.299	2.132	1.637
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	

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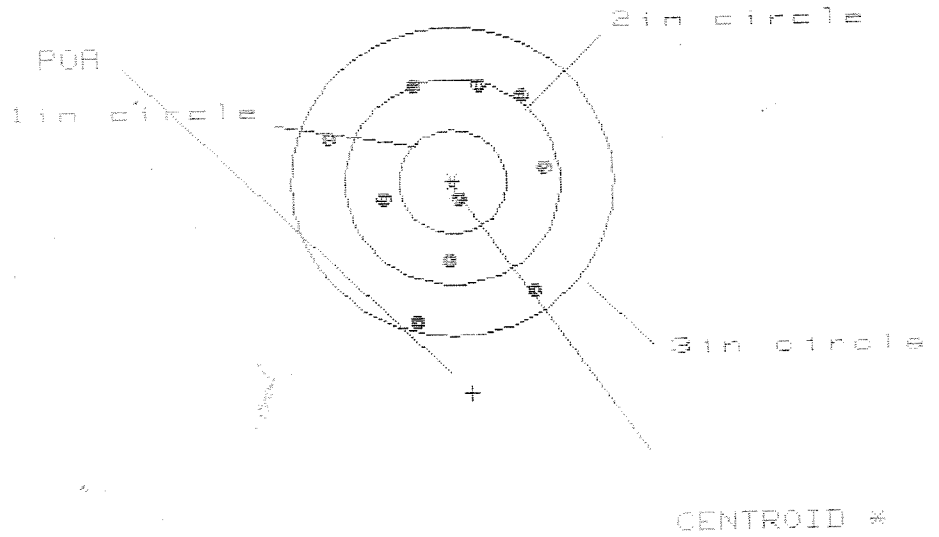
CENTERFIRE PATTERNS # 5



OF SHOTS= 10

# IN CIR	
1in	= 1
2in	= 5
3in	= 10

HS=	1.977
VS=	2.299
GS=	2.410

PATTERN #	:	[redacted]		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.849	.814	.909
MINIMUM X	:	-1.128	-1.163	-1.068
MAXIMUM Y	:	.963	.815	.666
MINIMUM Y	:	-1.336	-1.192	-1.032
CENTROID X	:	-.153	-.118	-.213
CENTROID Y	:	2.061	2.209	2.358
POA TO CENTROID in.	:	2.066	2.212	2.368
MIN RADIUS	:	.127	.271	.430
MEAN RADIUS	:	.930	.890	.818
MAX RADIUS	:	1.371	1.413	1.074
HORIZONTAL SPREAD	:	1.977	1.977	1.977
VERTICAL SPREAD	:	2.299	2.007	1.698
EXTREME SPREAD	:	2.410	2.410	1.993
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		10	