

G 646 153C
Rephew

G 628 5942

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: **RE00101655** Serial: G6285942 Model: M24 SWS Center Fire Caliber: 7.32 NATO Repairman: Status: Closed 9/28/2005 2:46:08 PM

Verify Repair

Address Information

Customer: ☒ Received From Return To: ☐ Received From

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

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

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

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

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

FFL: ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐

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

Contact Information

Phone: **N/A**

Fax:

Email:

Comments:

Received Condition

Fail:

Condition Notes:

CSR Notes:

Accessories Received

Code	Desc	Qty
A007	Wth Stud	3
A010	Hard Case	1
A016	Scope Rings	2
A017	Scope Base	1
A026	Scope	1
A045	Bi Pod	1
A057	Frt and Rear Sgt Base	1

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

start 3 4 2

G6285942 (New)

Serial Number: **G6285942**

Model: **M24 SWS**



RE00101655

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6461536.__0
FILE DATE AND TIME: 10/24/2005 18:00

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.019
The Average Y Centroid of the Five Target Set:	0.032
The Average Point of Impact of the Five Target Set:	0.037
The Average Mean Radius of the Five Target Set:	0.682
The Distance from POA to Centroid Target #1:	0.198
The Distance from Centroid Target #2 to Centroid Target #1:	0.446
The Distance from Centroid Target #3 to Centroid Target #1:	0.062
The Distance from Centroid Target #4 to Centroid Target #1:	0.308
The Distance from Centroid Target #5 to Centroid Target #1:	0.267

SERIAL NUMBER: G6461536. __0

TARGET NUMBER: 1

FILE DATE: 10/24/2005

FILE TIME: 18:00

X CENTROID: -0.052

Y CENTROID: 0.191

POA TO CENTROID: 0.198

HORZ SPREAD: 1.999

VERT SPREAD: 2.687

GROUP SPREAD: 2.472

MIN RADIUS: 0.471

MAX RADIUS: 1.465

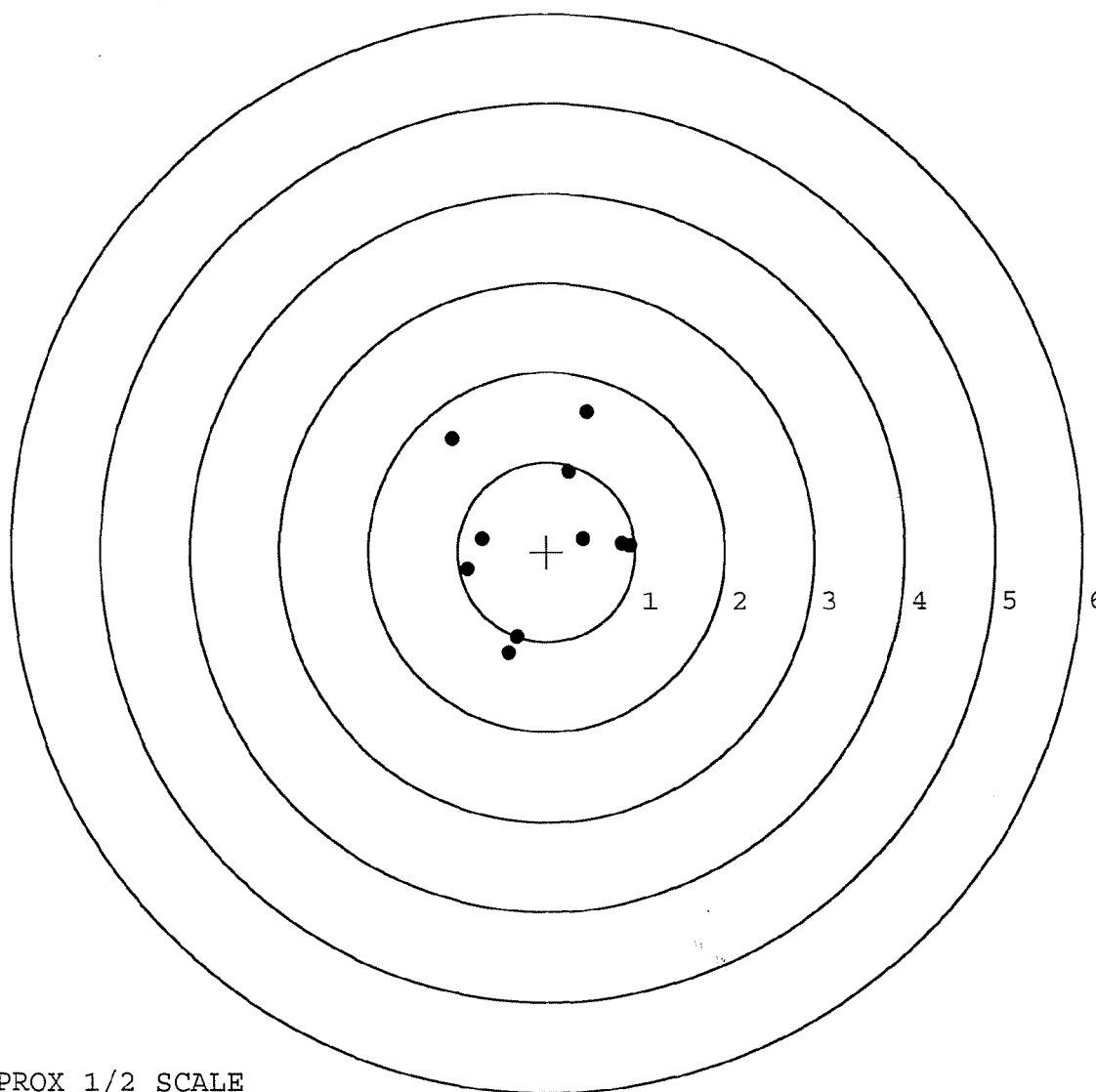
MEAN RADIUS: 1.021

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 5

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.418	0.153
2:	0.944	0.073
3:	0.850	0.098
4:	0.247	0.897
5:	0.454	1.554
6:	-1.055	1.259
7:	-0.721	0.149
8:	-0.890	-0.188
9:	-0.334	-0.952
10:	-0.431	-1.133



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461536. 0

TARGET NUMBER: 2

FILE DATE: 10/24/2005

FILE TIME: 18:00

X CENTROID: 0.326

Y CENTROID: -0.046

POA TO CENTROID: 0.329

HORZ SPREAD: 1.142

VERT SPREAD: 1.711

GROUP SPREAD: 1.714

MIN RADIUS: 0.173

MAX RADIUS: 1.045

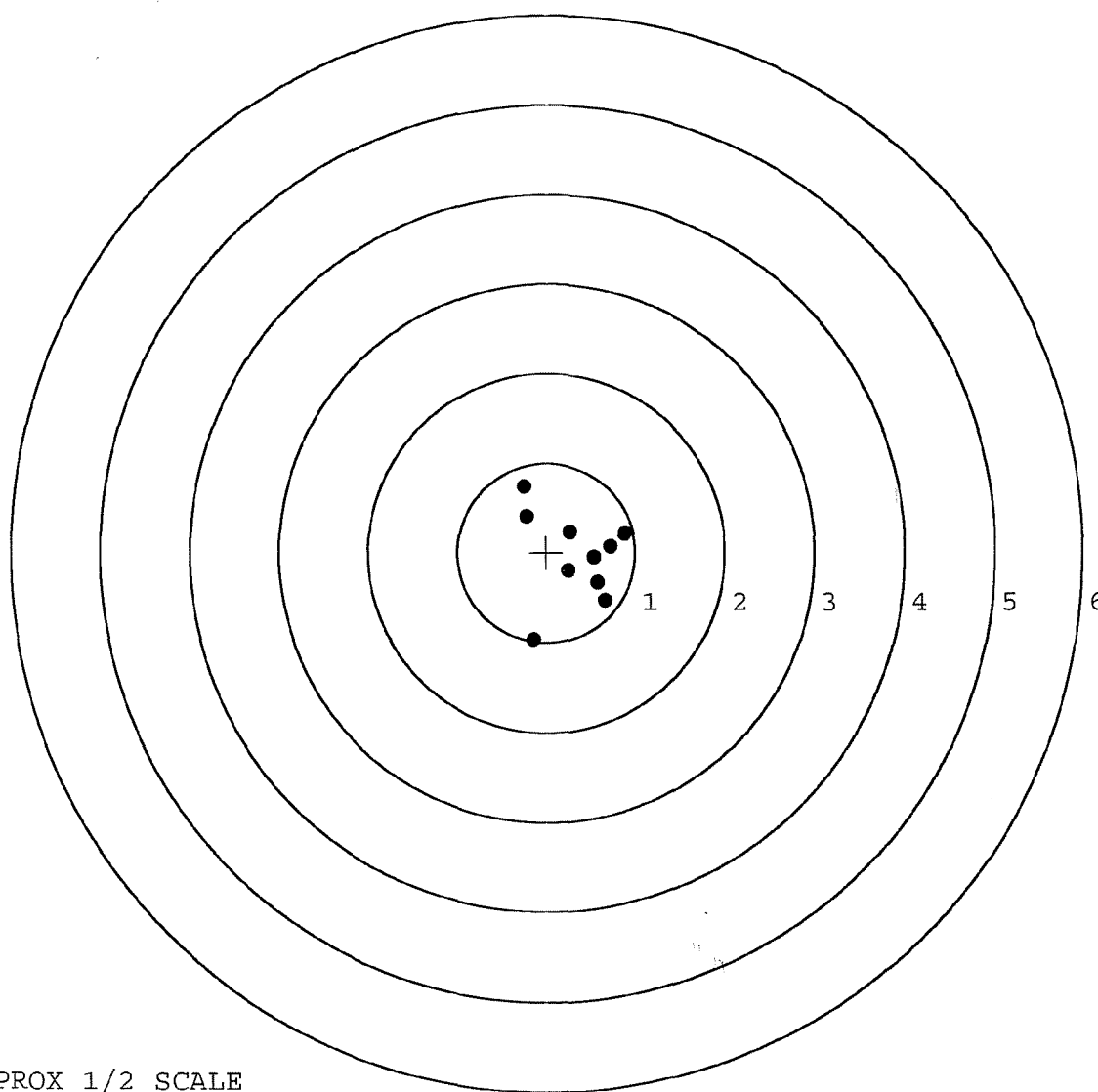
MEAN RADIUS: 0.540

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.265	0.227
2:	0.251	-0.202
3:	0.655	-0.535
4:	0.577	-0.335
5:	0.535	-0.055
6:	0.725	0.068
7:	0.886	0.209
8:	-0.256	0.735
9:	-0.232	0.402
10:	-0.151	-0.976



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461536. 0

TARGET NUMBER: 3

FILE DATE: 10/24/2005

FILE TIME: 18:00

X CENTROID: -0.114

Y CENTROID: 0.188

POA TO CENTROID: 0.220

HORZ SPREAD: 2.668

VERT SPREAD: 1.140

GROUP SPREAD: 2.705

MIN RADIUS: 0.169

MAX RADIUS: 1.632

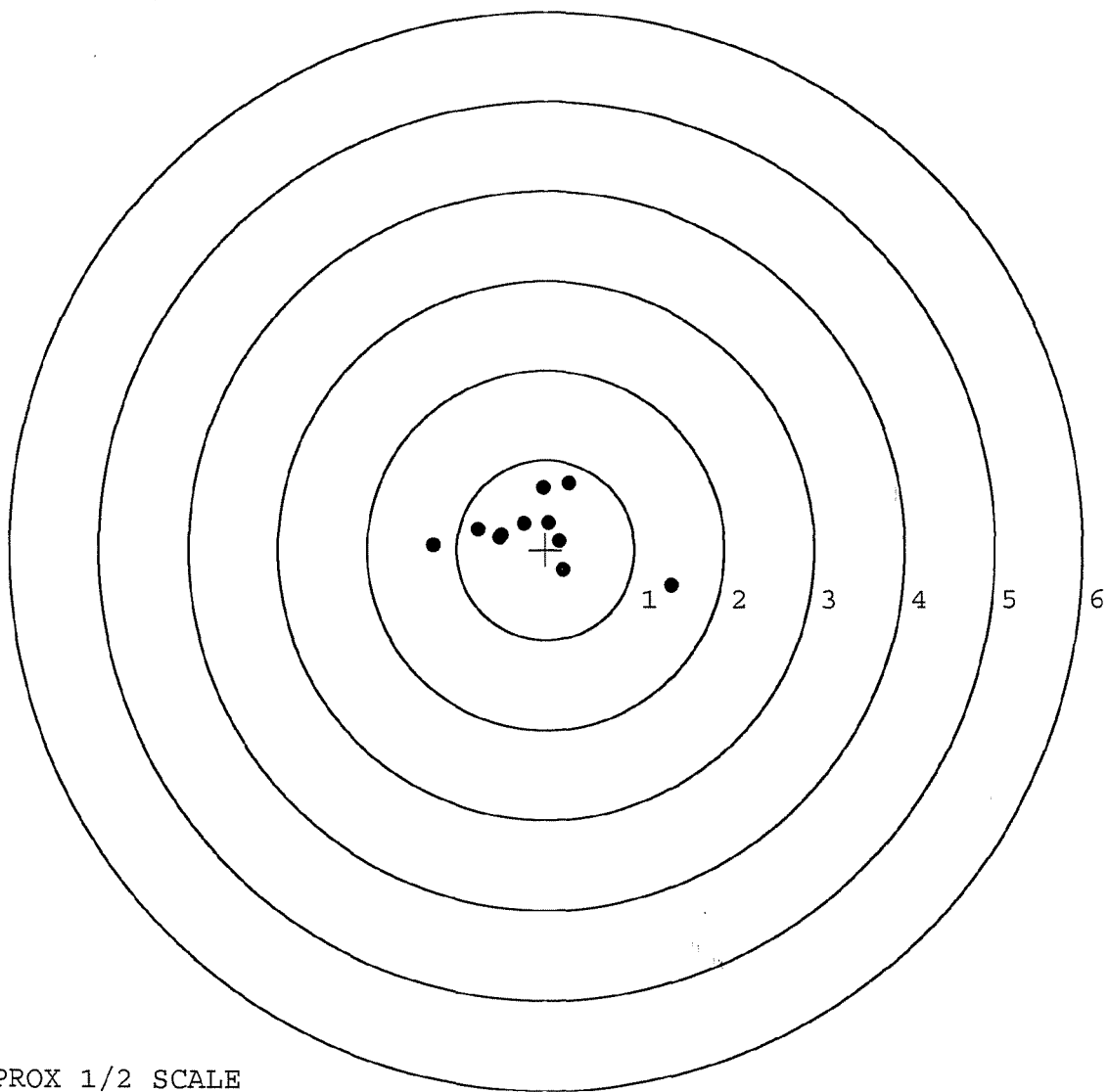
MEAN RADIUS: 0.597

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	1.410	-0.397
2:	0.199	-0.232
3:	0.158	0.098
4:	0.262	0.743
5:	-0.028	0.691
6:	-0.251	0.287
7:	-0.498	0.163
8:	-0.761	0.233
9:	-1.258	0.048
10:	-0.514	0.137
11:	0.031	0.295



TARGET APPROX 1/2 SCALE

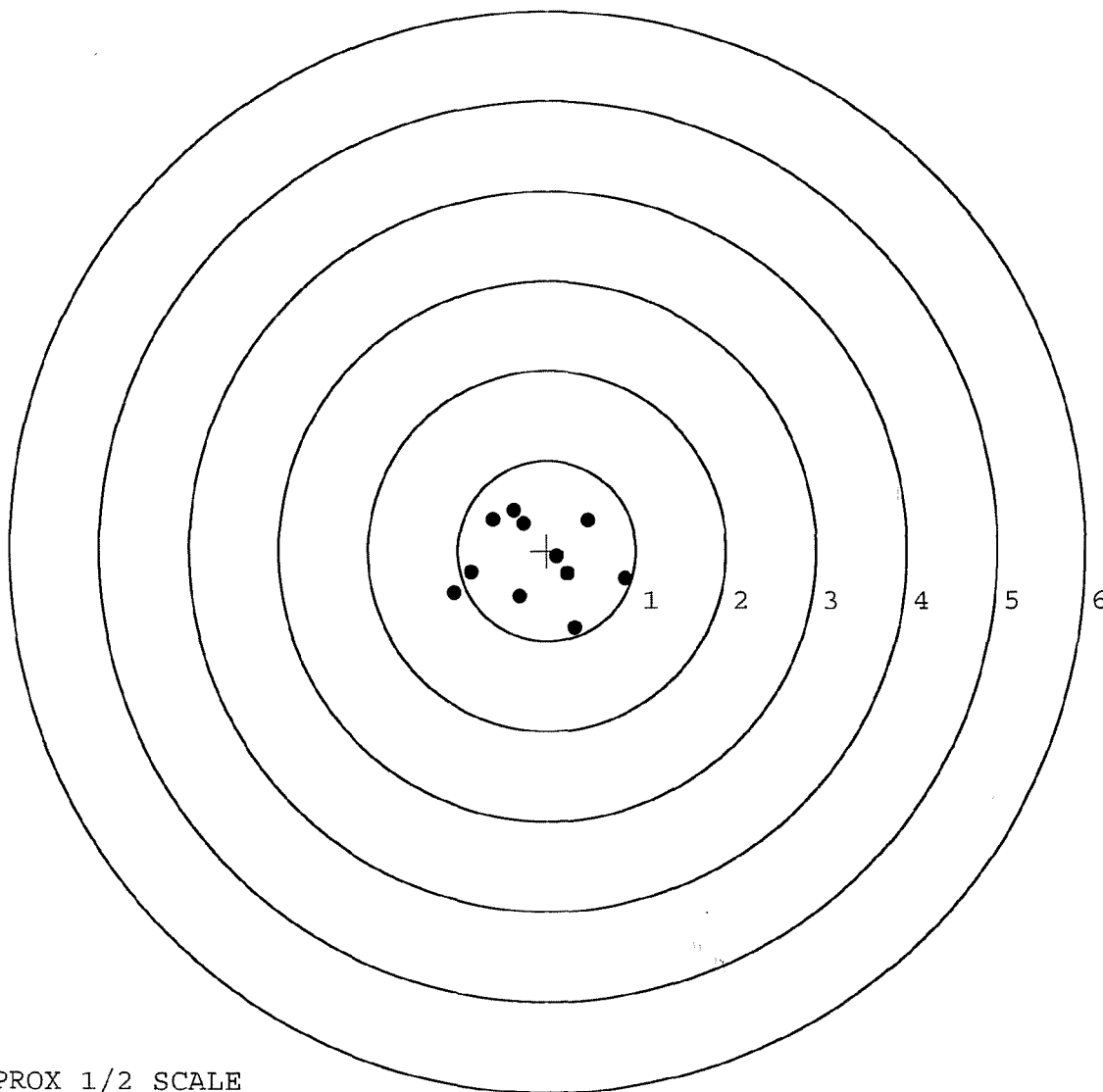
SERIAL NUMBER: G6461536. 0

TARGET NUMBER: 4

FILE DATE: 10/24/2005

FILE TIME: 18:00

	POINT#	X	Y
X CENTROID:	1:	0.110	-0.064
Y CENTROID:	2:	0.110	-0.064
POA TO CENTROID:	3:	0.460	0.342
HORZ SPREAD:	4:	0.878	-0.310
VERT SPREAD:	5:	-0.271	0.301
GROUP SPREAD:	6:	-0.375	0.448
MIN RADIUS:	7:	-0.607	0.349
MAX RADIUS:	8:	-0.851	-0.238
MEAN RADIUS:	9:	-1.046	-0.474
# IN 1 IN DIAMETER:	10:	-0.309	-0.511
# IN 2 IN DIAMETER:	11:	0.310	-0.858
# in 3 IN DIAMETER:	12:	0.232	-0.249



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461536. 0

TARGET NUMBER: 5

FILE DATE: 10/24/2005

FILE TIME: 18:00

X CENTROID: -0.141

Y CENTROID: -0.060

POA TO CENTROID: 0.153

HORZ SPREAD: 1.548

VERT SPREAD: 1.847

GROUP SPREAD: 2.232

MIN RADIUS: 0.111

MAX RADIUS: 1.235

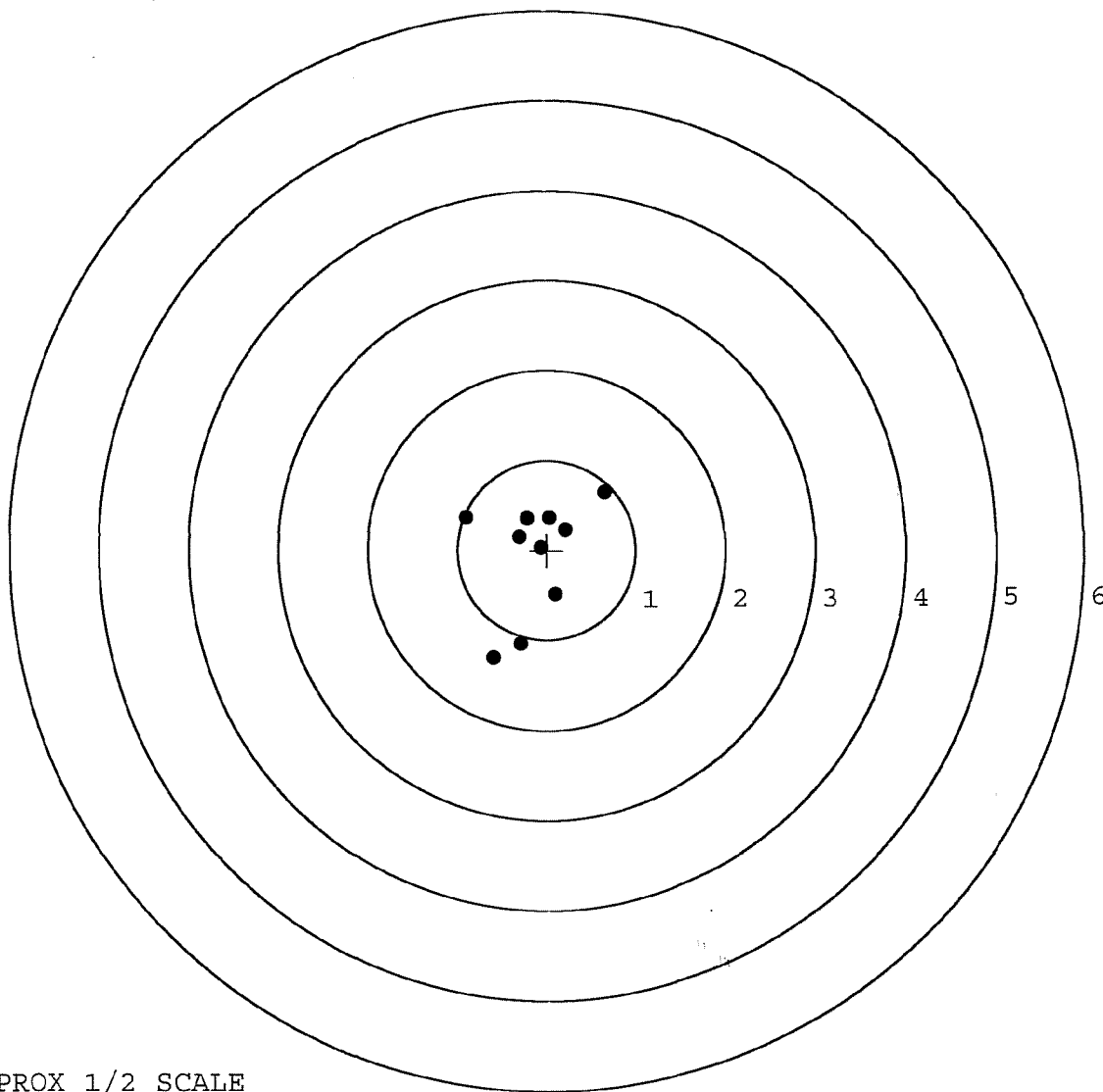
MEAN RADIUS: 0.639

IN 1 IN DIAMETER: 6

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.215	0.230
2:	0.037	0.364
3:	-0.218	0.360
4:	-0.309	0.152
5:	-0.901	0.369
6:	0.647	0.643
7:	0.098	-0.497
8:	-0.299	-1.047
9:	-0.606	-1.204
10:	-0.073	0.028



TARGET APPROX 1/2 SCALE

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

R & E NUMBER	101655		
SERIAL NUMBER	66285942 66461536 (New)		
LOG-IN DATE	9-28-05		
INSPECT AND VERIFY:			
OPERATION #	OPERATION NAME	DATE	INITIALS
550	DIS-ASSEMBLE GUN	9-29-05	RTL
560 A	RE-BARREL	9-29-05	RTL
B	DRILL AND TAP	10-4-05	BR
575	ASSEMBLE	9-29-05	RTL
600	PROOF MAGNA-FLUX INSPECTED	10-3-05	RTL
605	CHECK HEADSPACE	10-3-05	RTL
610	DIS-ASSEMBLE GUN	10-3-05	RTL
612	MAGNAFLUX OPERATOR <i>unus</i>	10/4/05	<i>unus</i>
615	ROLLMARK CALIBER	10-4-05	CW
618	ROTO-BLAST	10-10-05	LB
620	APPLY COATINGS	10/21/05. Repaired	WJ
625 A	FINAL ASSEMBLY	10-24-05	RTL
B	TRIGGER PULL TEST		
C	SAFETY "ON" FORCE		
D	SAFETY "OFF" FORCE		
E	FIRING PIN INDENT		
640	TARGET	10/24/05	MJD
655	FINAL INSPECT	10-28-05	RTL
660	PACK	10-28-05	JA
		SHIP DATE	
		QAR INSPECTION DATE	

NMP COPY 2

~~C6636188~~

Serial Number: C6636188

Model: 700



RE00073079

G6285942

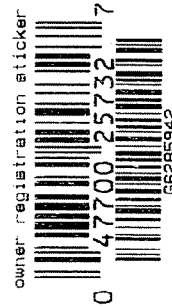
M-24 INSPECTION CHECKLIST
CONTRACT #: DAAE-20-02-D-0127

R & E NUMBER	073079		
SERIAL NUMBER	06636188 06636188 G6285942		
LOG-IN DATE	11-17-03		
INSPECT AND VERIFY:			
OPERATION #	OPERATION NAME	DATE	INITIAL
550	DIS-ASSEMBLE GUN	12-16-03	PW
560 A	RE-BARREL		
B	DRILL AND TAP		
575	ASSEMBLE		
600	PROOF		
605	CHECK HEADSPACE		
610	DIS-ASSEMBLE GUN		
612	MAGNAFLUX		
615	ROLLMARK CALIBER		
618	ROTO-BLAST		
620	APPLY COATINGS		
625 A	FINAL ASSEMBLY		
B	TRIGGER PULL TEST		
C	SAFETY "ON" FORCE		
D	SAFETY "OFF" FORCE		
E	FIRING PIN INDENT		
640	TARGET	12-19-03	AC
655	FINAL INSPECT	12-22-03	RTL
660	PACK	12-23-03	DA
		SHIP DATE	
	QAR INSPECTION DATE		

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

- INSTRUCTION BOOK 3518

46 FORM 200348



ORDER NO. **25732**

BARREL LENGTH **24"**

CAPACITY **5**

G6285942



Remington®

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

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

SERIAL NO. J
G6285942

ORDER NO.
25732

46

Made in Ilion, NY Reg. U.S. Pat & tm. Off. Marca Registrada Marque Deposee.



5732 G6285942

11WX

M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 628 5942

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		11-18-02	RL
600	PROOF		11-19-02	AC
607	CHECK HEADSPACE		11-19-02	AC
610	DIS-ASSEMBLE GUN		12-2-02	RL
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	RD		
615	ROLLMARK CALIBER		12-6-	LB
617	DRILL AND TAP SIGHT HOLES		12-3-02	TRW
620	APPLY COATINGS (BARREL ACTION)		12-17	TA
	(BOLT)		12-17	TA
625	FINAL ASSEMBLY			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		1-10-03	DA
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		1-10-03	DA
	C) INSPECT EJECTOR HOLE FOR CHAMFER		1-10-03	DA
	D) OIL FIRING PIN ASSEMBLY		1-10-03	DA
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS		7-25-03	RL

OP #	OPERATION NAME	READINGS	DATE	INITIAL
625	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>20</u> <u>20</u> <u>2.0</u>	7/25/03	OA
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>6.0</u> <u>6.0</u> <u>5.5</u>	7/25/03	OA
	H) TRIGGER PULL TEST AND RETAINABILITY		7/25/03	PL
	I) FIRING PIN INDENT .020 MIN	<u>022</u> <u>024</u> <u>022</u>	7/25/03	OA
	J) ASSEMBLE STOCK		5/14/03	RL
	K) ASSEMBLE SWIVEL STUDS		8-5-03	RL
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		8-5-03	RL
	M) IRON SIGHT ALIGNMENT		8-5-03	RL
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		8-5-03	RL
640	GALLERY TEST AND TARGET	PASS FAIL	5-14-03	A
	MALFUNCTION <i>Ric</i>	<u>CORRECTION</u> <i>OK</i>	5-14-03	A
	MALFUNCTION	CORRECTION	5-14-03	A
	MALFUNCTION	CORRECTION	5-14-03	A
	MALFUNCTION	CORRECTION	5-14-03	A
645	INSPECT FOR LIVE AMMO		5-14-03	A
655	FINAL INSPECTION A) HEADSPACE		8/5/03	FW
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.74</u> <u>2.75</u> <u>2.77</u> <u>2.72</u> <u>2.71</u>	7/25/03	OA
	C) FUNCTION		8/5/03	FW
660	PACK		8/7/03	OA

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

SERIAL NO. _____

DATE 5-12-03

TESTER TRW

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.36	2.20		2.63	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2
PULL #2	2.26	2.10		2.61	
PULL #3	2.40	2.24		2.55	
PULL #4	2.36	2.05		2.61	
PULL #5	2.17	2.34		2.26	
TOTAL	11.55	10.93		12.66	
AVG.	2.31	2.18		2.53	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.20	3.03		
PULL #2	3.17	3.04		
PULL #3	3.33	3.17		
PULL #4	3.15	3.15		
PULL #5	3.40	3.12		
TOTAL	16.25	15.51		
AVG.	3.25	3.10		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCUR
PULL #1	4.28	4.46		4.24
PULL #2	4.05	4.38		4.25
PULL #3	4.25	4.39		4.17
PULL #4	4.16	4.25		4.20
PULL #5	4.20	4.15		4.25
TOTAL	20.94	21.63		21.11
AVG.	4.18	4.32		4.22

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6285942.___0
FILE DATE AND TIME: 05/14/2003 06:09

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.311
The Average Y Centroid of the Five Target Set:	0.107
The Average Point of Impact of the Five Target Set:	0.329
The Average Mean Radius of the Five Target Set:	0.913
The Distance from POA to Centroid Target #1:	0.636
The Distance from Centroid Target #2 to Centroid Target #1:	0.797
The Distance from Centroid Target #3 to Centroid Target #1:	0.217
The Distance from Centroid Target #4 to Centroid Target #1:	1.136
The Distance from Centroid Target #5 to Centroid Target #1:	0.975

SERIAL NUMBER: G6285942. 0

TARGET NUMBER: 1

FILE DATE: 05/14/2003

FILE TIME: 06:09

X CENTROID: 0.542

Y CENTROID: 0.333

POA TO CENTROID: 0.636

HORZ SPREAD: 2.536

VERT SPREAD: 2.728

GROUP SPREAD: 2.830

MIN RADIUS: 0.385

MAX RADIUS: 1.577

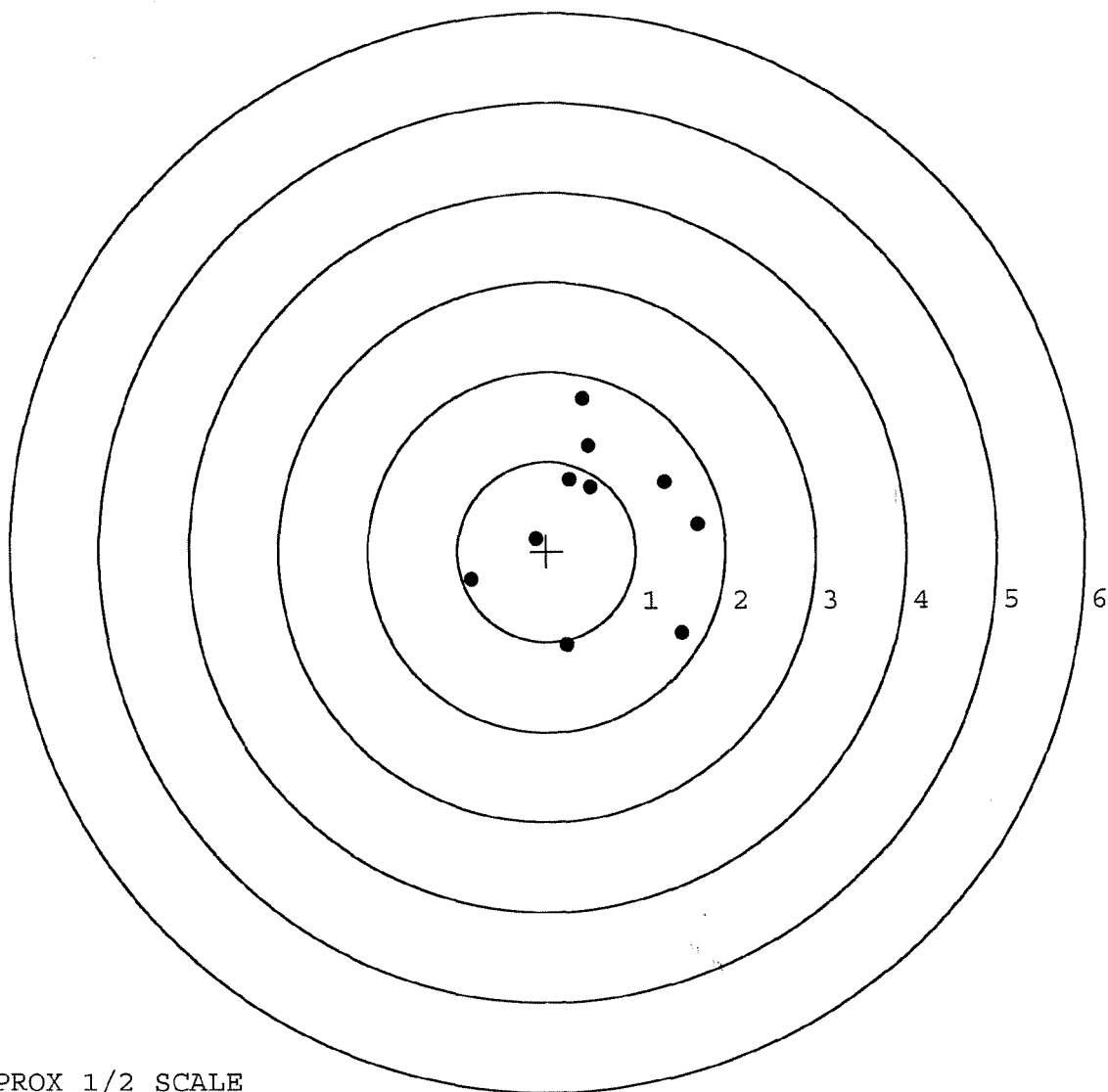
MEAN RADIUS: 1.039

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 5

in 3 IN DIAMETER: 8

POINT#	X	Y
1:	0.260	0.801
2:	-0.123	0.140
3:	-0.843	-0.314
4:	0.232	-1.034
5:	1.511	-0.911
6:	1.693	0.295
7:	1.325	0.761
8:	0.493	0.715
9:	0.406	1.694
10:	0.468	1.180

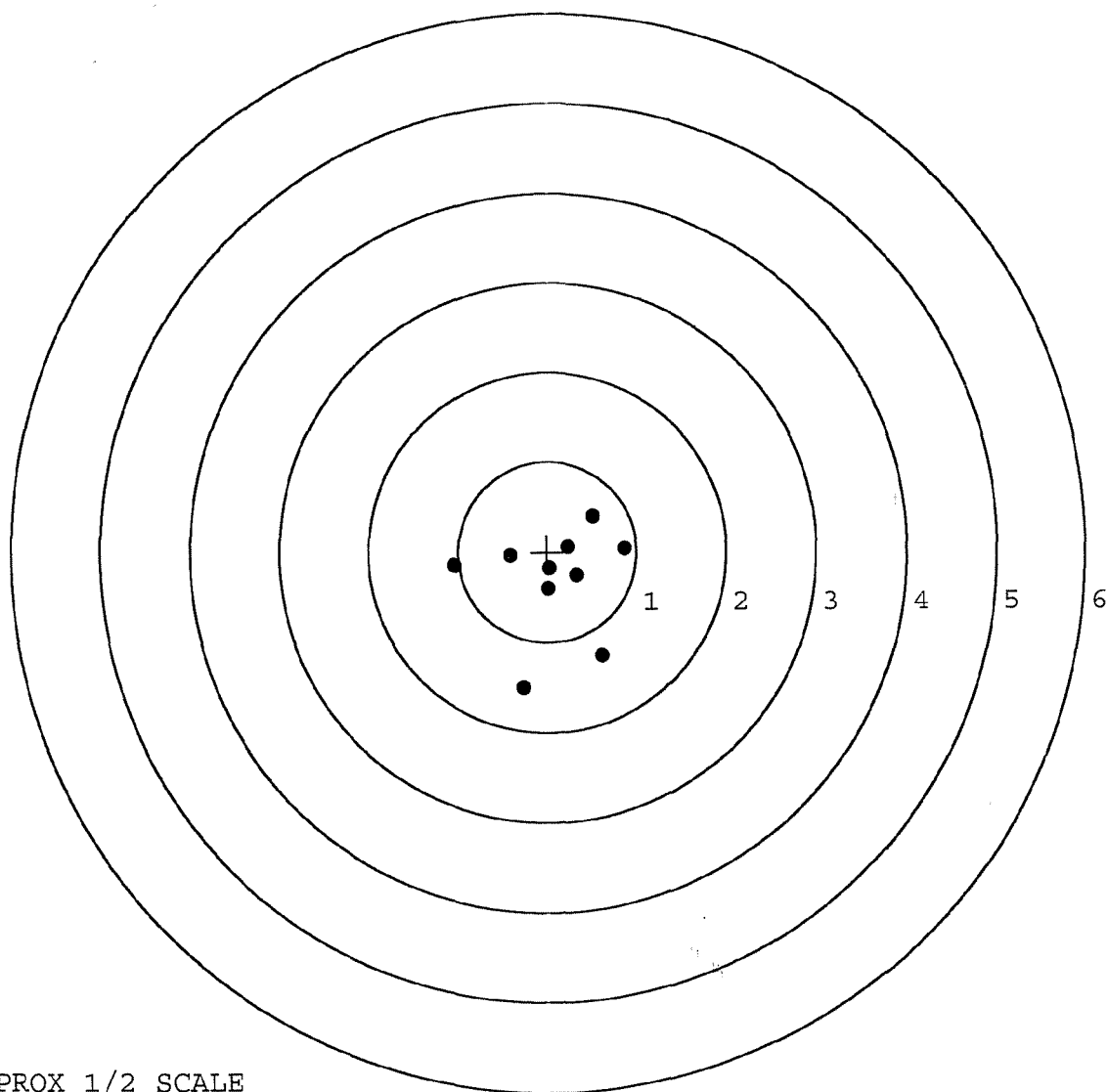


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6285942.___0
TARGET NUMBER: 2
FILE DATE: 05/14/2003
FILE TIME: 06:09

X CENTROID: 0.086
Y CENTROID: -0.321
POA TO CENTROID: 0.332
HORZ SPREAD: 1.912
VERT SPREAD: 1.904
GROUP SPREAD: 2.056
MIN RADIUS: 0.119
MAX RADIUS: 1.240
MEAN RADIUS: 0.656
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.618	-1.147
2:	-0.267	-1.510
3:	-1.044	-0.148
4:	-0.420	-0.042
5:	0.008	-0.411
6:	0.868	0.040
7:	0.510	0.394
8:	0.235	0.056
9:	0.327	-0.255
10:	0.020	-0.185



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6285942. 0

TARGET NUMBER: 3

FILE DATE: 05/14/2003

FILE TIME: 06:09

X CENTROID: 0.456

Y CENTROID: 0.133

POA TO CENTROID: 0.475

HORZ SPREAD: 2.410

VERT SPREAD: 2.857

GROUP SPREAD: 2.920

MIN RADIUS: 0.276

MAX RADIUS: 1.633

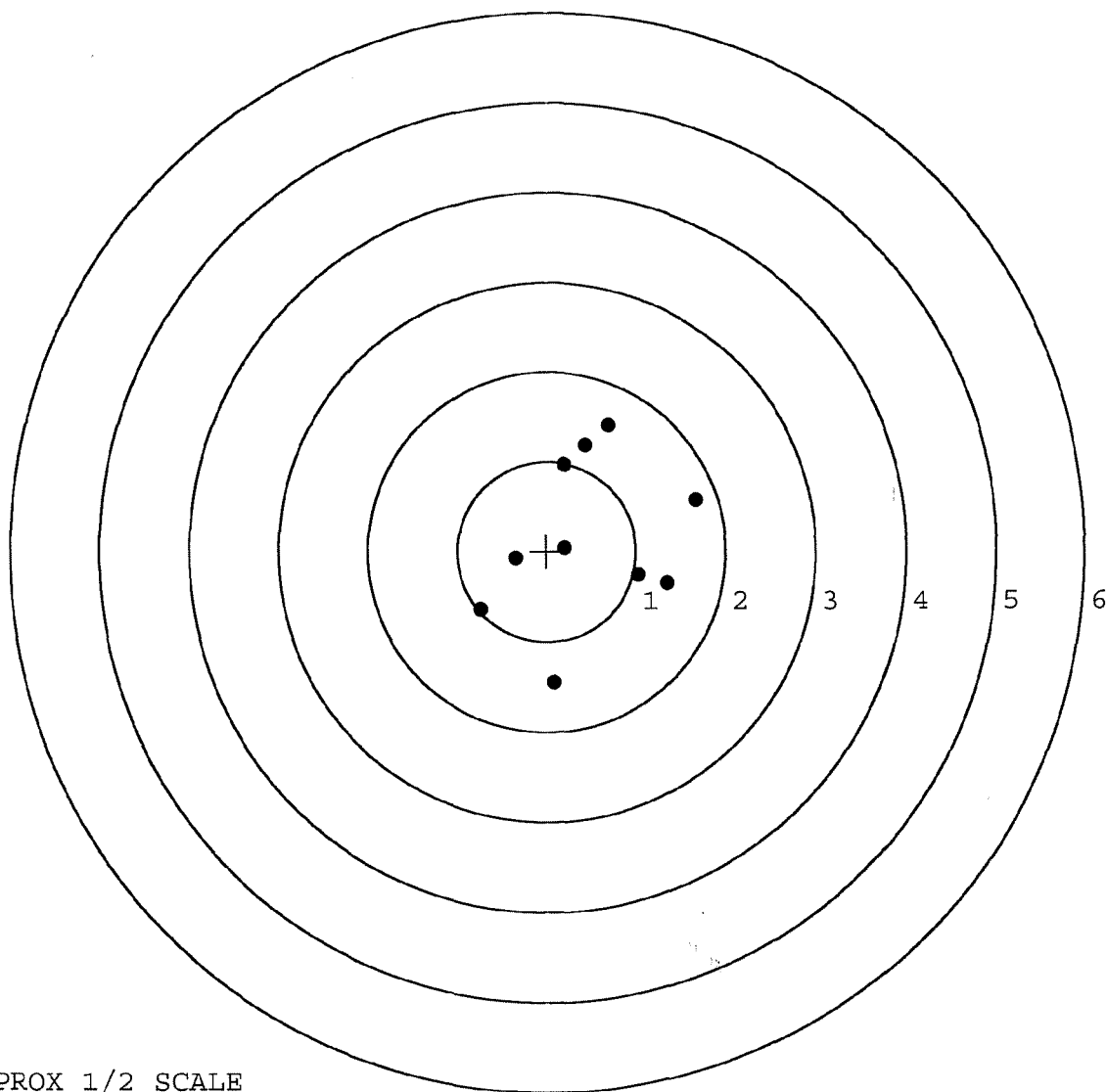
MEAN RADIUS: 1.039

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 4

in 3 IN DIAMETER: 9

POINT#	X	Y
1:	0.200	0.030
2:	-0.349	-0.083
3:	-0.743	-0.644
4:	0.083	-1.457
5:	1.349	-0.361
6:	1.030	-0.272
7:	1.667	0.572
8:	0.688	1.400
9:	0.440	1.184
10:	0.199	0.961



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6285942. 0

TARGET NUMBER: 4

FILE DATE: 05/14/2003

FILE TIME: 06:09

X CENTROID: -0.393

Y CENTROID: 0.978

POA TO CENTROID: 1.054

HORZ SPREAD: 1.820

VERT SPREAD: 2.099

GROUP SPREAD: 2.206

MIN RADIUS: 0.437

MAX RADIUS: 1.291

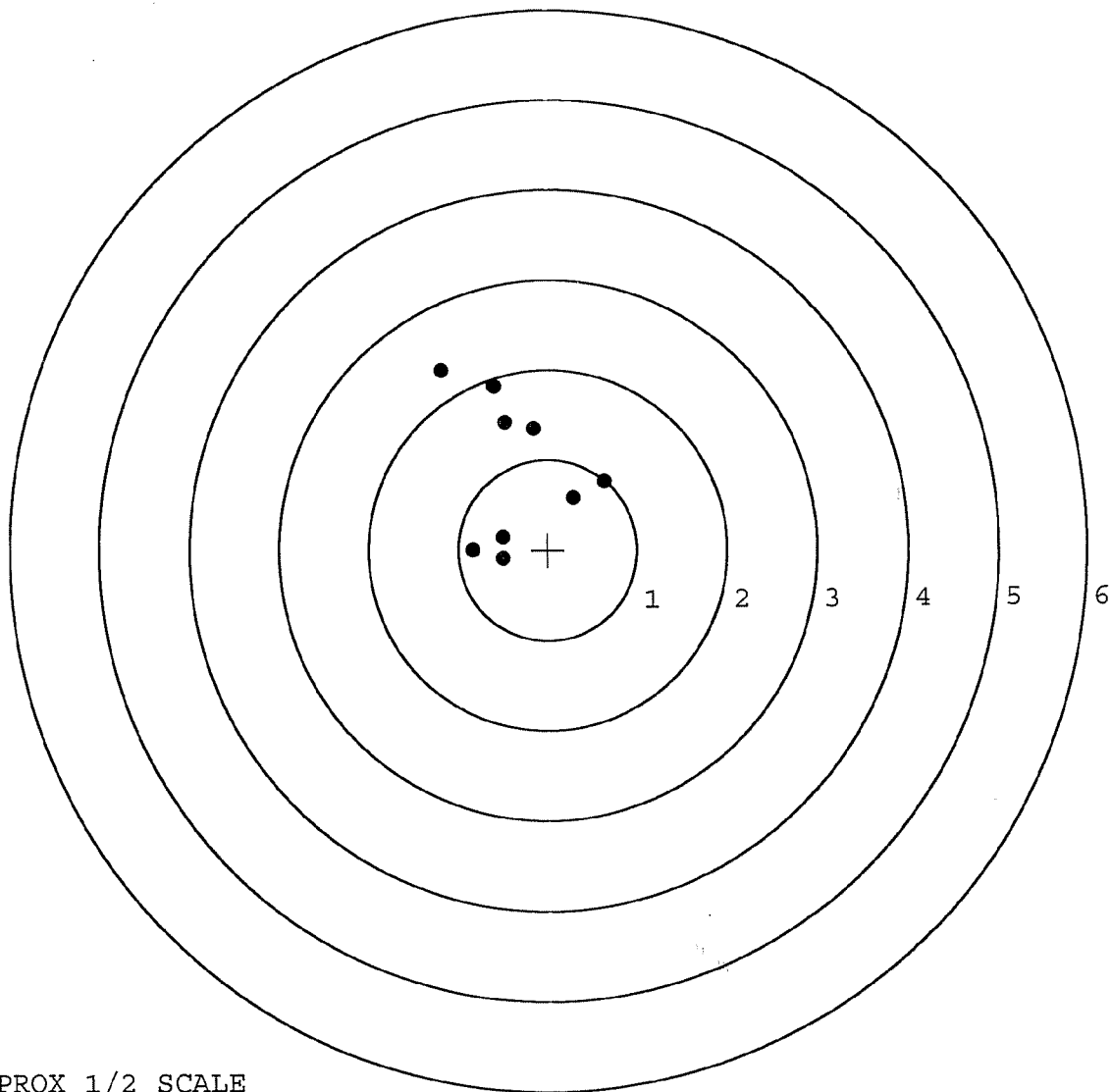
MEAN RADIUS: 0.875

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.291	0.578
2:	0.638	0.760
3:	-0.598	1.817
4:	-0.604	1.821
5:	-1.182	2.000
6:	-0.154	1.344
7:	-0.475	1.417
8:	-0.835	0.000
9:	-0.503	0.142
10:	-0.503	-0.099

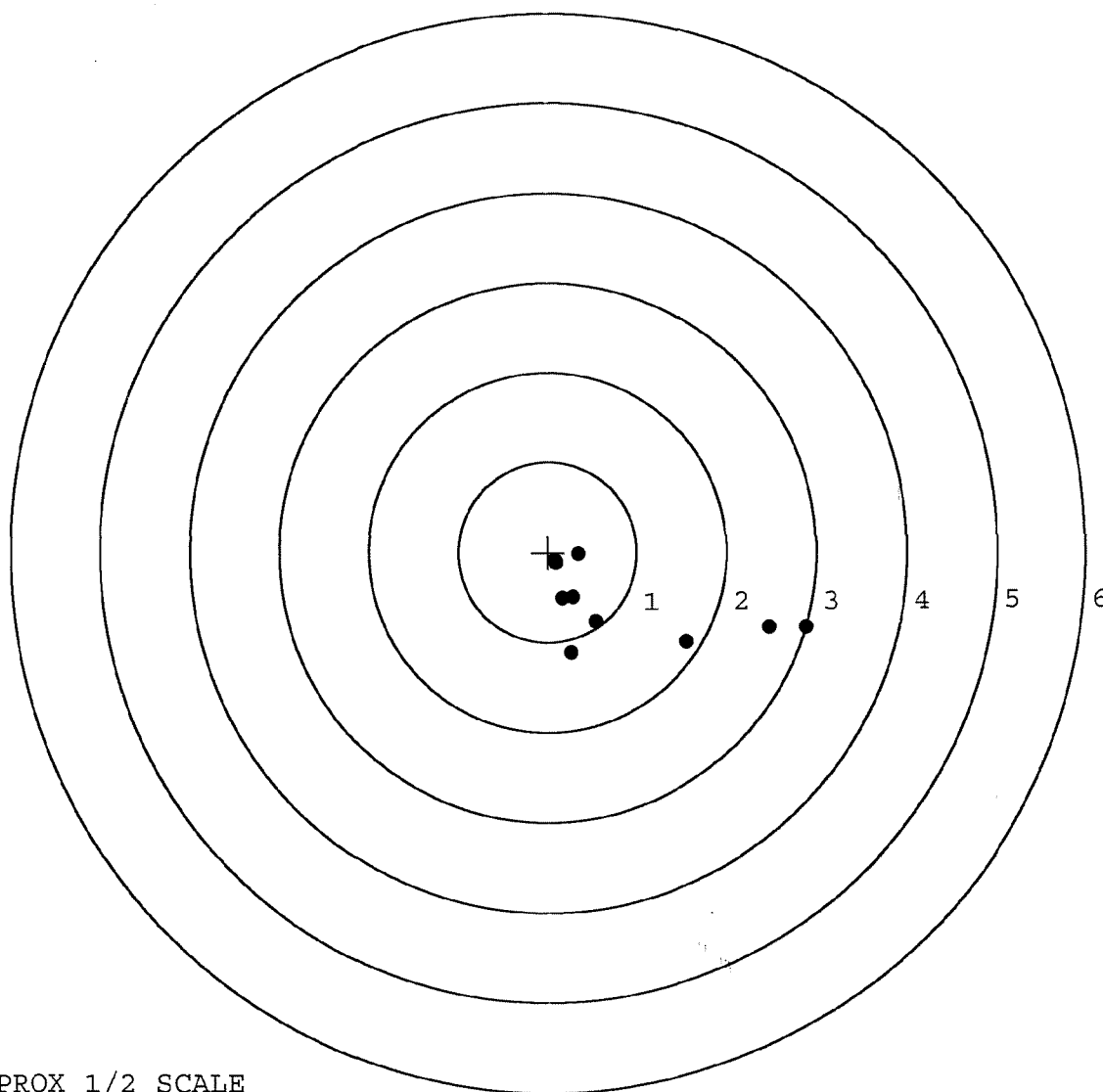


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6285942.___0
TARGET NUMBER: 5
FILE DATE: 05/14/2003
FILE TIME: 06:09

X CENTROID: 0.866
Y CENTROID: -0.587
POA TO CENTROID: 1.046
HORZ SPREAD: 2.806
VERT SPREAD: 1.121
GROUP SPREAD: 2.905
MIN RADIUS: 0.383
MAX RADIUS: 2.033
MEAN RADIUS: 0.954
IN 1 IN DIAMETER: 1
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 8

POINT#	X	Y
1:	0.284	-0.505
2:	0.076	-0.097
3:	2.882	-0.849
4:	2.468	-0.851
5:	1.549	-1.007
6:	0.093	-0.126
7:	0.165	-0.517
8:	0.534	-0.778
9:	0.265	-1.121
10:	0.343	-0.022



TARGET APPROX 1/2 SCALE

Ams 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: **RE00050328** Serial: C6636188 Model: 700 Center Fire Caliber: 7.62 NATO M-24 (SWS) Repairman: Status: Closed 8/6/02 3:33:24 PM

Verify Repair

Address Information

Customer: Received From: Return To: Received From:

Name: USAIC USAIC

Address 1: DFEL SUPPLY DIV BLDG 490 DFEL SUPPLY DIV BLDG 490

Address 2: PD Box: PD Box:

City: FORT BENNING FORT BENNING

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

FFL:

Contact / Condition Problems Estimate History / Status Shipping / Billing

Contact Information

Phone: Fax: Email: Comments:

Received Condition

Condition: Poor

Notes: PACKED IN SAME HARD CASE AS SER# E6413580

CSR Notes:

Accessories Received

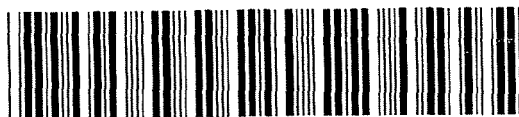
Code	Desc	Qty
A007	With Stud	1
A010	Hard Case	1
A017	Scope Base	1
A026	Scope	1
X	FRT & REAR SGT BA	2

Repair Search Refresh Close

Start | naget | 8/7/02 | 7:48 AM | CAPS | NUM | INS | SCFL | 7:48 AM

Serial Number: **C6636188**

Model: **700**



RE00050328

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6636188.___0
FILE DATE AND TIME: 08/24/2002 13:56

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.050
The Average Y Centroid of the Five Target Set:	0.063
The Average Point of Impact of the Five Target Set:	0.080
The Average Mean Radius of the Five Target Set:	0.657
The Distance from POA to Centroid Target #1:	0.102
The Distance from Centroid Target #2 to Centroid Target #1:	0.122
The Distance from Centroid Target #3 to Centroid Target #1:	0.365
The Distance from Centroid Target #4 to Centroid Target #1:	0.247
The Distance from Centroid Target #5 to Centroid Target #1:	0.082

SERIAL NUMBER: C6636188. __0

TARGET NUMBER: 1

FILE DATE: 08/24/2002

FILE TIME: 13:56

POINT#	X	Y
1:	0.873	-1.054
2:	-1.395	-0.148
3:	0.221	1.363
4:	-0.224	0.749
5:	0.092	0.043
6:	-0.205	0.095
7:	-0.153	-0.024
8:	0.541	-0.554
9:	0.422	-0.801
10:	0.246	-0.601

X CENTROID: 0.042

Y CENTROID: -0.093

POA TO CENTROID: 0.102

HORZ SPREAD: 2.268

VERT SPREAD: 2.417

GROUP SPREAD: 2.503

MIN RADIUS: 0.145

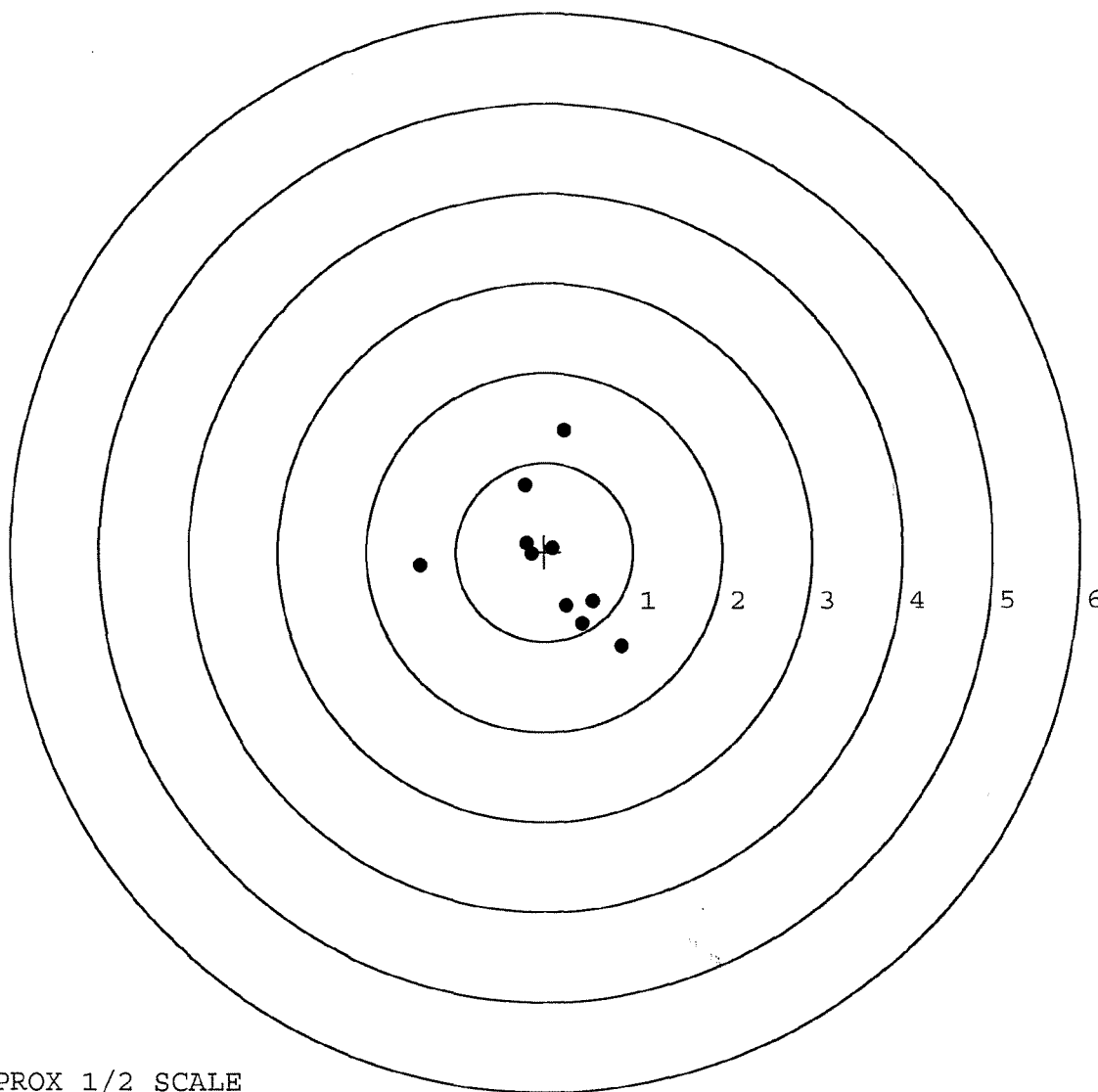
MAX RADIUS: 1.467

MEAN RADIUS: 0.775

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6636188. 0

TARGET NUMBER: 2

FILE DATE: 08/24/2002

FILE TIME: 13:56

X CENTROID: 0.026

Y CENTROID: 0.028

POA TO CENTROID: 0.038

HORZ SPREAD: 1.596

VERT SPREAD: 1.490

GROUP SPREAD: 1.694

MIN RADIUS: 0.118

MAX RADIUS: 0.945

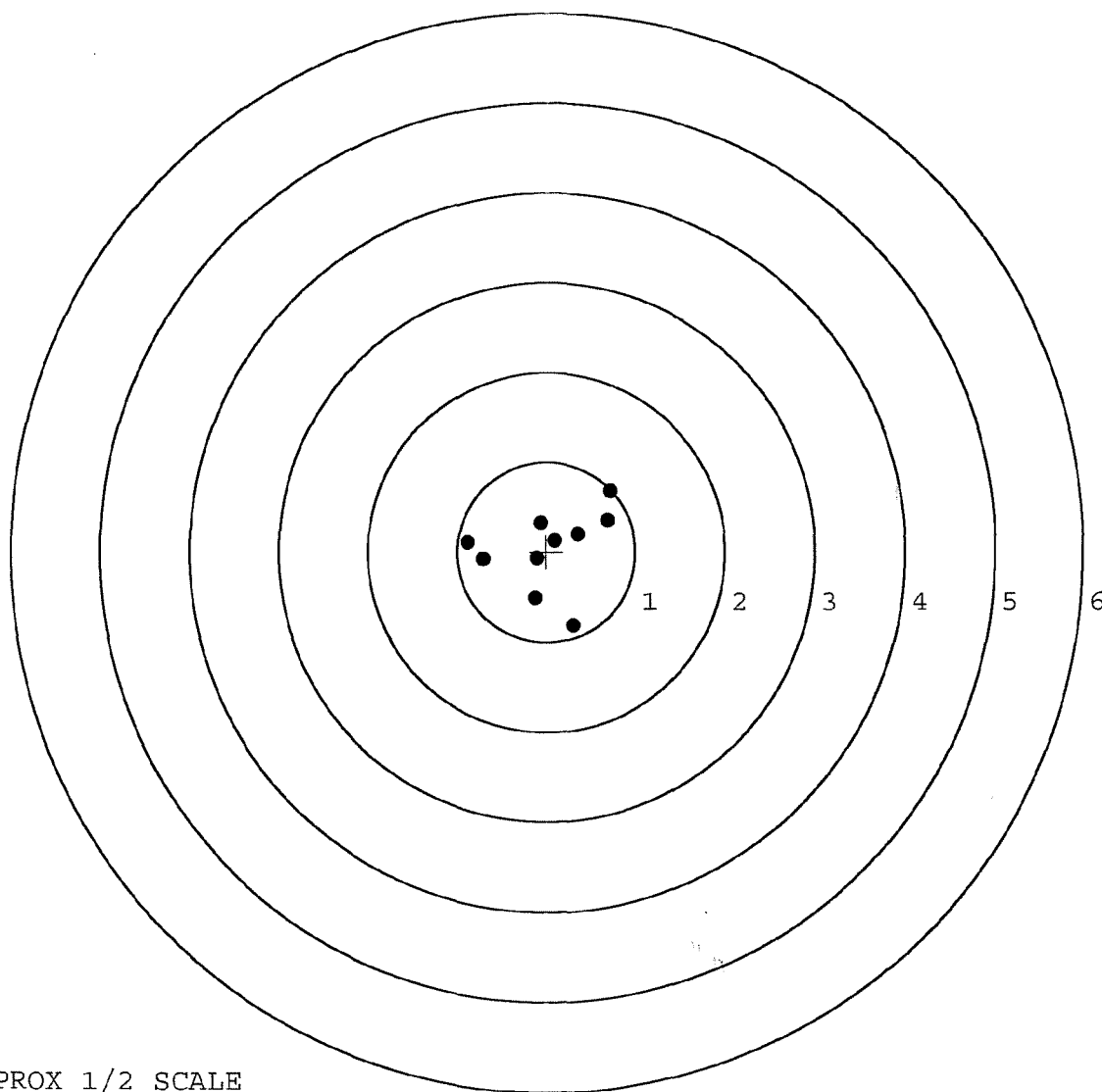
MEAN RADIUS: 0.576

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.304	-0.816
2:	-0.129	-0.514
3:	-0.712	-0.081
4:	-0.881	0.107
5:	0.715	0.674
6:	0.685	0.351
7:	0.357	0.196
8:	0.096	0.123
9:	-0.068	0.319
10:	-0.112	-0.079



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6636188. __0

TARGET NUMBER: 3

FILE DATE: 08/24/2002

FILE TIME: 13:56

X CENTROID: 0.165

Y CENTROID: 0.251

POA TO CENTROID: 0.300

HORZ SPREAD: 2.281

VERT SPREAD: 1.201

GROUP SPREAD: 2.288

MIN RADIUS: 0.152

MAX RADIUS: 1.248

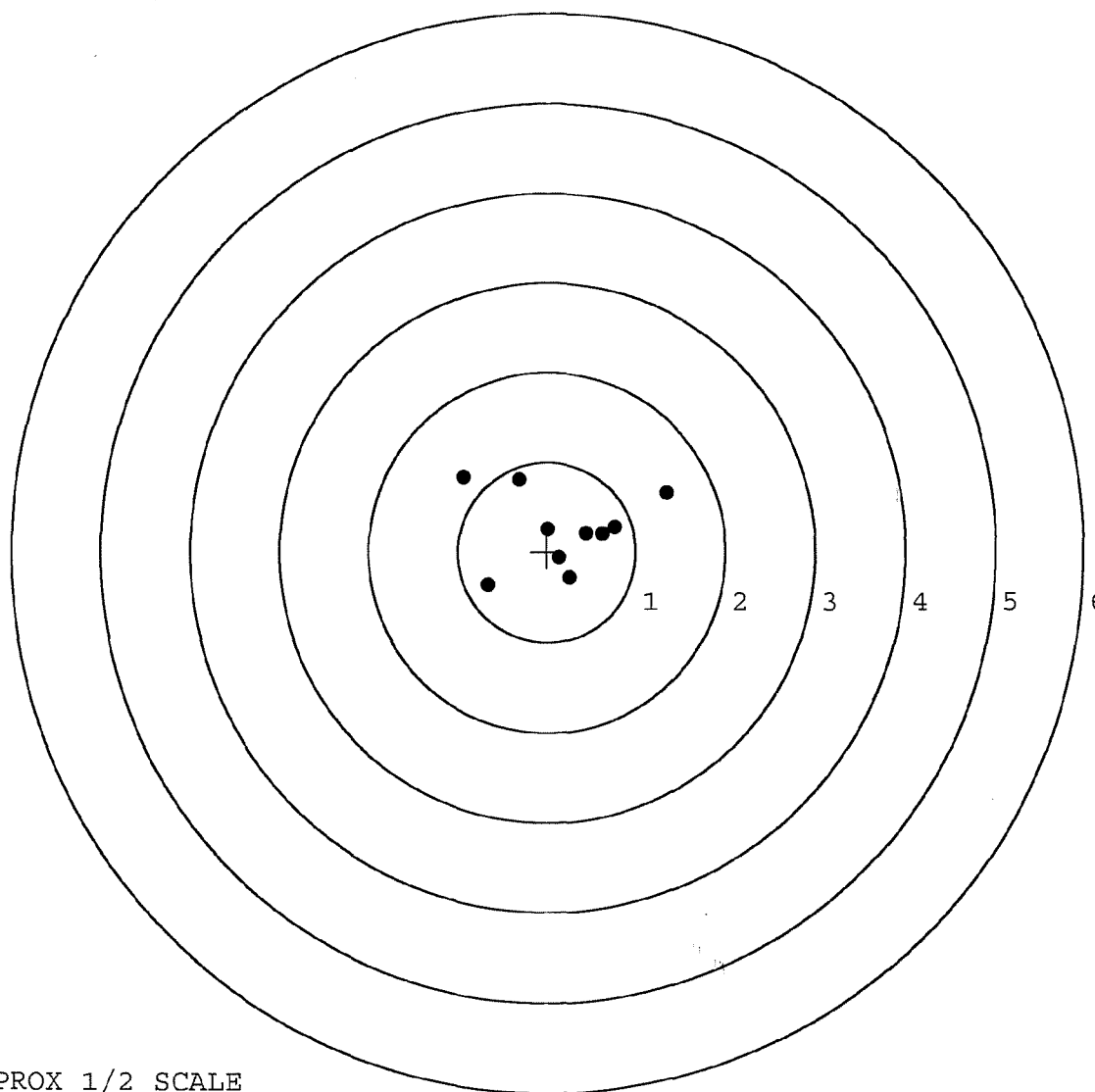
MEAN RADIUS: 0.660

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.661	-0.367
2:	-0.939	0.834
3:	-0.316	0.806
4:	1.342	0.658
5:	0.758	0.277
6:	0.619	0.202
7:	0.434	0.207
8:	0.259	-0.287
9:	0.013	0.250
10:	0.138	-0.072



TARGET APPROX 1/2 SCALE

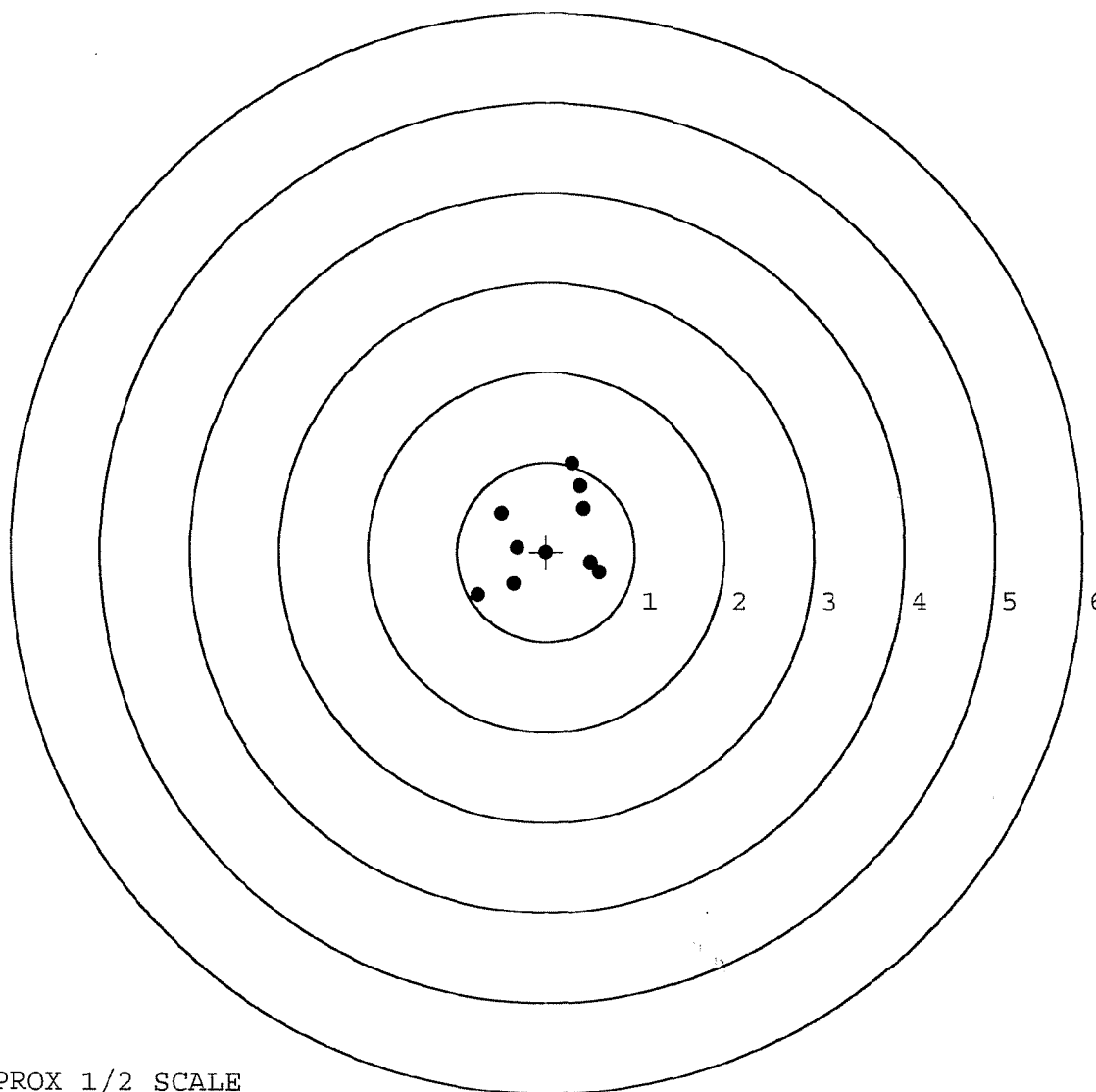
SERIAL NUMBER: C6636188. 0

TARGET NUMBER: 4

FILE DATE: 08/24/2002

FILE TIME: 13:56

		POINT#	X	Y
		1:	0.290	0.988
		2:	0.379	0.746
		3:	0.415	0.492
		4:	-0.510	0.440
X CENTROID:	0.019	5:	-0.770	-0.476
Y CENTROID:	0.153	6:	-0.373	-0.358
POA TO CENTROID:	0.154	7:	-0.331	0.053
HORZ SPREAD:	1.370	8:	-0.010	-0.012
VERT SPREAD:	1.464	9:	0.499	-0.117
GROUP SPREAD:	1.807	10:	0.600	-0.224
MIN RADIUS:	0.168			
MAX RADIUS:	1.009			
MEAN RADIUS:	0.612			
# IN 1 IN DIAMETER:	2			
# IN 2 IN DIAMETER:	9			
# in 3 IN DIAMETER:	10			

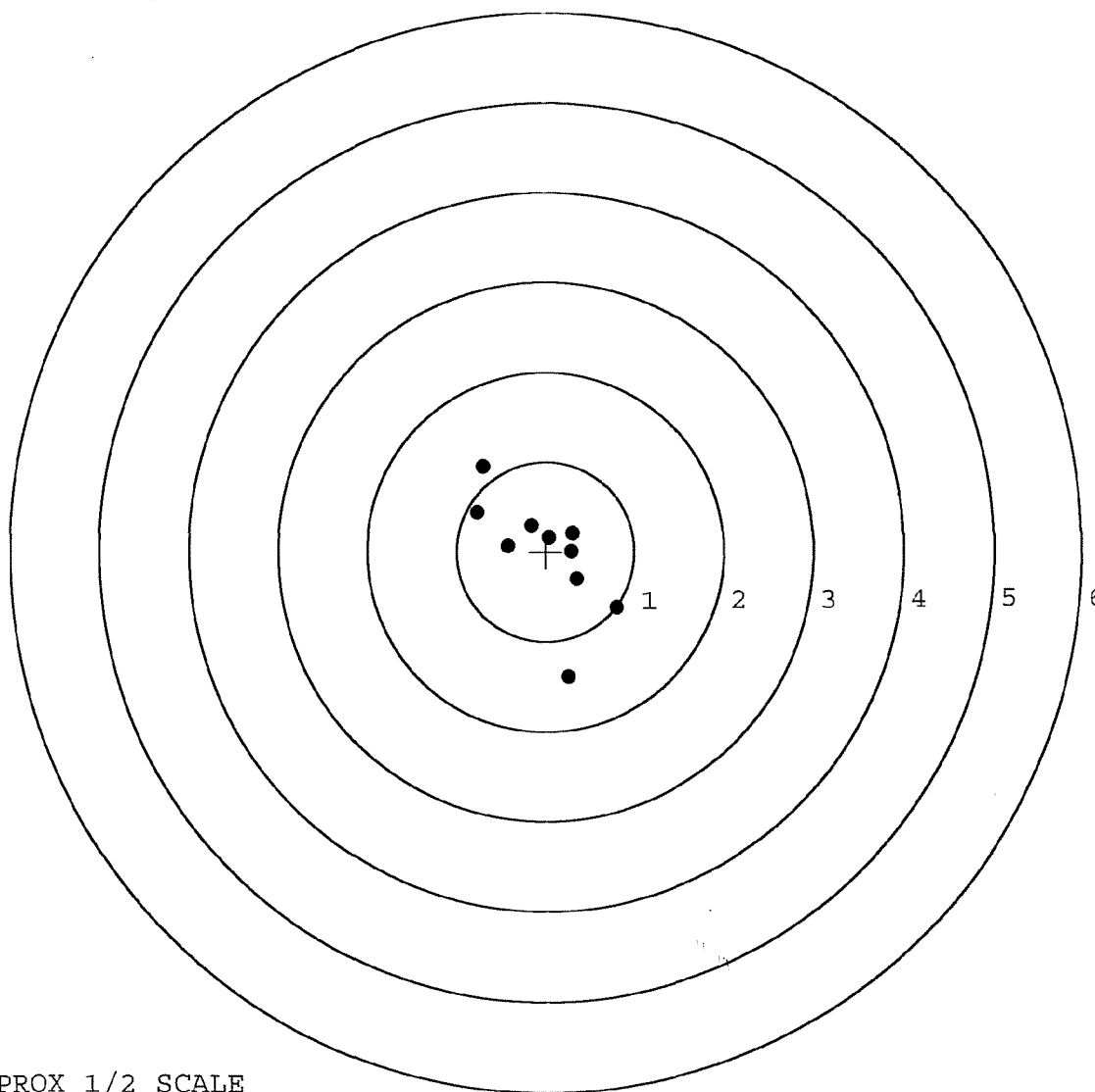


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6636188. 0
TARGET NUMBER: 5
FILE DATE: 08/24/2002
FILE TIME: 13:56

X CENTROID: -0.002
Y CENTROID: -0.023
POA TO CENTROID: 0.023
HORZ SPREAD: 1.560
VERT SPREAD: 2.348
GROUP SPREAD: 2.534
MIN RADIUS: 0.185
MAX RADIUS: 1.398
MEAN RADIUS: 0.659
IN 1 IN DIAMETER: 6
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.259	-1.397
2:	0.796	-0.633
3:	-0.695	0.951
4:	-0.764	0.441
5:	-0.433	0.065
6:	-0.158	0.290
7:	0.035	0.158
8:	0.304	0.202
9:	0.287	0.004
10:	0.353	-0.313



TARGET APPROX 1/2 SCALE

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

R & E NUMBER	50328		
SERIAL NUMBER	C6636188		
LOG-IN DATE	8/6/02		
INSPECT AND VERIFY:			
OPERATION #	OPERATION NAME	DATE	INITIAL
550	DIS-ASSEMBLE GUN	8/12/02	RL
560 A	RE-BARREL	8-12-02	DA
B	DRILL AND TAP	8-13-02	AC
575	ASSEMBLE	8/13/02	RL
600	PROOF	8-13-02	MAGNAFLUX INSPECTED AUG 14 2002
605	CHECK HEADSPACE	8/13/02	RL
610	DIS-ASSEMBLE GUN	8/13/02	RL
612	MAGNAFLUX		OPERATOR BR
615	ROLLMARK CALIBER	8/14	KB
618	ROTO-BLAST	8/15	K6
620	APPLY COATINGS	8-16	TA
625 A	FINAL ASSEMBLY	8/22/02	RL
B	TRIGGER PULL TEST		
C	SAFETY "ON" FORCE		
D	SAFETY "OFF" FORCE		
E	FIRING PIN INDENT		
640	TARGET	8-23-02	AC
655	FINAL INSPECT	8-23-02	RW
660	PACK	8-26-02	DA
		SHIP DATE	
	QAR INSPECTION DATE		




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

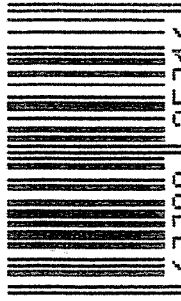
MODEL 700™ H24

SERIAL NO. C6636188

ORDER NO. 5716

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

UPC



0 47700 25716 7



5716 C6636188

repaired stock

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C 6636188

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		4/3/91	K.S.
600	Proof		4/3/91	K.S.
607	Check Headspace		4/3/91	K.S.
610	Dis-assemble Gun		4/3/91	K.S.
612	Magnaflux Barrel Action		4/10/91	KR
	Magnaflux Bolt		4/10/91	"
615	Rollmark Caliber		4/10/91	LS
617	Drill and Tap Sight Holes		APR 19 1991	LB
618	Polish Barrel		APR 19 1991	WB
620	Apply Coatings (Barrel Action)		4-10-91	LS
	Apply Coating (Bolt)		4-10-91	LS
625	Final Assembly A) Clean inside of Bolt Assembly		5/17/91	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/17/91	KS
	C) Inspect Ejector Hole for Chamfer		5/17/91	KS
	D) Oil Firing Pin Ass'y		5/17/91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		5-18-91	PH

M2400152691

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. CLG30188

DATE 5-18-91

TESTER DH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.62	2.70	2.63	2.70	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.70	2.71	2.54	2.40	
PULL #3	2.68	2.66	2.55	2.45	
PULL #4	2.66	2.54	2.60	2.44	
PULL #5	2.69	2.71	2.61	2.45	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.07	3.06		
PULL #2	3.06	3.09		
PULL #3	3.06	3.05		
PULL #4	3.09	3.11		
PULL #5	3.06	3.12		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.24	4.19		4.18
PULL #2	4.75	4.20		4.30
PULL #3	4.21	4.22		4.26
PULL #4	4.25	4.14		4.23
PULL #5	4.25	4.27		4.29
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636188
20 May 1991

CENTROIDAL DISTANCES

0 TO	1	.287057
1 TO	2	.439619
1 TO	3	.386005
1 TO	4	.34704
1 TO	5	.600033

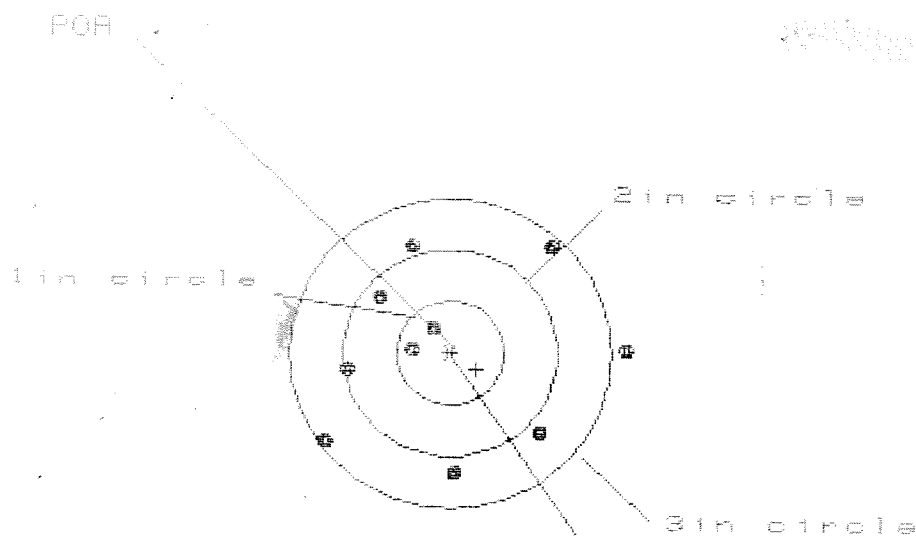
1.5 ←---POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0444
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0184
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0480816
THE AMR FOR THIS RIFLE IS: 1.006

28 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C66361B8

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1in = 2

2in = 4

3in = 4

HS= 2.797

VS= 2.247

GS= 2.928

CENTROID

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.661	1.125	1.086
MINIMUM X	-1.136	-0.952	-0.862
MAXIMUM Y	1.066	1.066	.957
MINIMUM Y	-1.181	-1.181	-1.290
CENTROID X	-.239	-.423	-.304
CENTROID Y	.159	.159	.258
POA TO CENTROID in.	.287	.452	.485
MIN RADIUS	.258	.217	.130
MEAN RADIUS	1.034	.921	.872
MAX RADIUS	1.661	1.502	1.341
HORIZONTAL SPREAD	2.797	2.077	1.868
VERTICAL SPREAD	2.247	2.247	2.247
EXTREME SPREAD	2.928	2.791	2.344
NUMBER IN ONE INCH CIRCLE	= 2		
NUMBER IN TWO INCH CIRCLE	= 4		
NUMBER IN THREE INCH CIRCLE	= 8		

28 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C883B1B8

CENTERFIRE PATTERNS # 2

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS- 10

IN CIR

1 in - 2

2 in - 6

3 in - 9

HS= 2.468

VS= 3.589

GS= 3.658

PATTERN #

2

SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.128	1.150	.985
MINIMUM X	:	-1.340	-1.318	-.675
MAXIMUM Y	:	1.186	.919	.981
MINIMUM Y	:	-2.403	-.646	-.664
CENTROID X	:	-.040	-.062	.103
CENTROID Y	:	-.233	.034	.052
POA TO CENTROID in.	:	.236	.070	.115
MIN RADIUS	:	.256	.326	.353
MEAN RADIUS	:	.957	.769	.694
MAX RADIUS	:	2.411	1.326	1.115
HORIZONTAL SPREAD	:	2.468	2.468	1.668
VERTICAL SPREAD	:	3.589	1.565	1.565
EXTREME SPREAD	:	3.658	2.484	1.908
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

28 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8636188

CENTERFIRE PATTERNS

3

POA

1in circle

2in circle

3in circle

OF SHOTS - 12

IN CIR

1in - 2

2in - 5

3in - 7

HS= 2.508

VS= 3.767

GS= 3.850

CENTROID *

PATTERN #

3

SHOTS (BEST OF)

10

9

8

MAXIMUM X

.974

.803

.704

MINIMUM X

-1.534

-1.129

-1.228

MAXIMUM Y

1.953

1.798

.979

MINIMUM Y

-1.814

-1.969

-1.744

CENTROID X

.071

.242

.341

CENTROID Y

-.071

.084

-.141

POA TO CENTROID in.

.101

.256

.369

MIN RADIUS

.220

.391

.304

MEAN RADIUS

1.126

.995

.850

MAX RADIUS

2.073

1.969

1.747

HORIZONTAL SPREAD

2.508

1.932

1.932

VERTICAL SPREAD

3.767

3.767

2.723

EXTREME SPREAD

3.850

3.850

2.763

NUMBER IN ONE INCH CIRCLE =

2

NUMBER IN TWO INCH CIRCLE =

5

NUMBER IN THREE INCH CIRCLE =

7

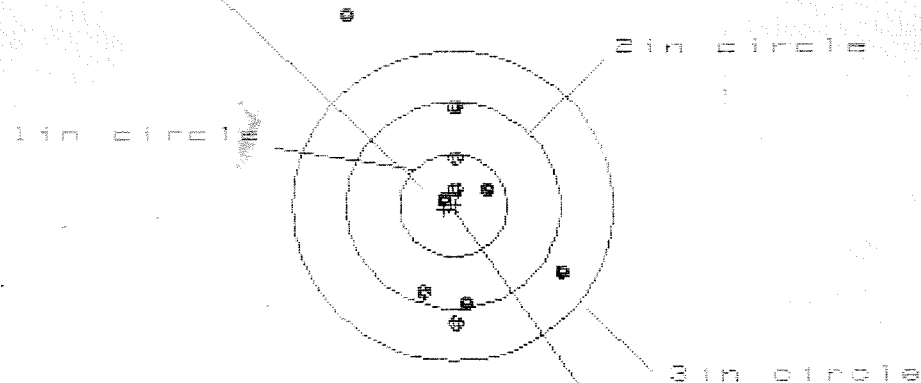
28 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C66361B8

CENTERFIRE PATTERNS

4

POB



OF SHOTS- 10

IN CIR

1in = 4

2in = 7

3in = 9

HS= 2.031

VS= 3.016

GS= 3.238

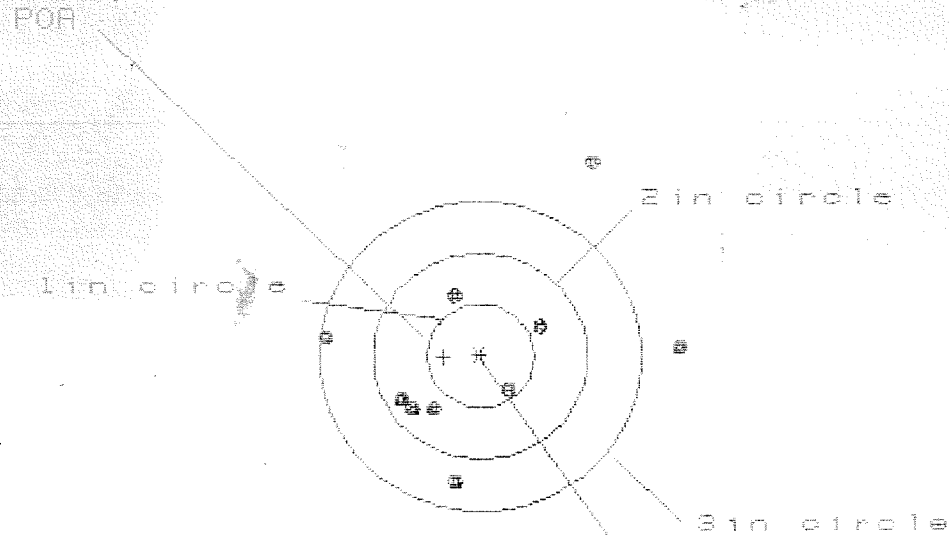
CENTROID #

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.044	.935	.291
MINIMUM X	:	-.987	-.444	-.328
MAXIMUM Y	:	1.864	1.119	1.062
MINIMUM Y	:	-1.152	-.944	-1.001
CENTROID X	:	.087	.196	.080
CENTROID Y	:	.040	-.168	-.111
POB TO CENTROID in.	:	.095	.258	.137
MIN RADIUS	:	.157	.381	.270
MEAN RADIUS	:	.833	.713	.651
MAX RADIUS	:	2.110	1.121	1.063
HORIZONTAL SPREAD	:	2.031	1.379	.619
VERTICAL SPREAD	:	3.016	2.063	2.063
EXTREME SPREAD	:	3.238	2.063	2.063
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

28 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8636188

CENTERFIRE PATTERNS # 5



* OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 8

HS= 3.311*

VS= 3.132

GS= 3.425

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.966	2.027	.954
MINIMUM X	:	-1.405	-1.284	-1.030
MAXIMUM Y	:	1.890	.791	.834
MINIMUM Y	:	-1.242	-1.032	-.989
CENTROID X	:	.343	.222	-.032
CENTROID Y	:	.013	-.197	-.240
POA TO CENTROID in.	:	.344	.297	.242
MIN RADIUS	:	.387	.359	.273
MEAN RADIUS	:	1.081	.905	.710
MAX RADIUS	:	2.184	2.056	1.109
HORIZONTAL SPREAD	:	3.311	3.311	1.984
VERTICAL SPREAD	:	3.132	1.823	1.823
EXTREME SPREAD	:	3.425	3.311	1.986
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	