G6590200
Replaced
G6236245

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: RE00140413
Verify Repair | High Priority

Serial: G6590200 Model M24 SWS Center Fire
Caliber: 7.62 NATO

Repairman:
Status: Closed 1/22/2008 3:15:38 PM

Address Information

Customer: (Received From)		Return To: (Received From)	
Name:	TRANSPORTATION DIV, DFEL		TRANSPORTATION DIV, DFEL
Address 1:	6759 MITCHELL AVENUE		6759 MITCHELL AVENUE
Address 2:	BLDG 1836 PO Box:		BLDG 1836 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: NN
Fax:
Email:
Comments:

Received Condition

Fair
Condition Notes:
CSR Notes:

Accessories Received

Code	Desc	Qty
A007	With Stud	3
A010	Hard Case	1
A017	Scope Base	1
A057	Frt and Rear Sgt Base	1
D000	BI POD ALL BROKEN	1

nagletj 1/23/2008 1:05 PM NUM

Start | 2 Mic... | 3 Mic... | My Exc... | SAP Lo... | Part 5... | Arms S...

Serial Number: G6590200
Model: M24 SWS
RE00140413

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFOMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6590200.__0
FILE DATE AND TIME: 02/11/2008 14:33

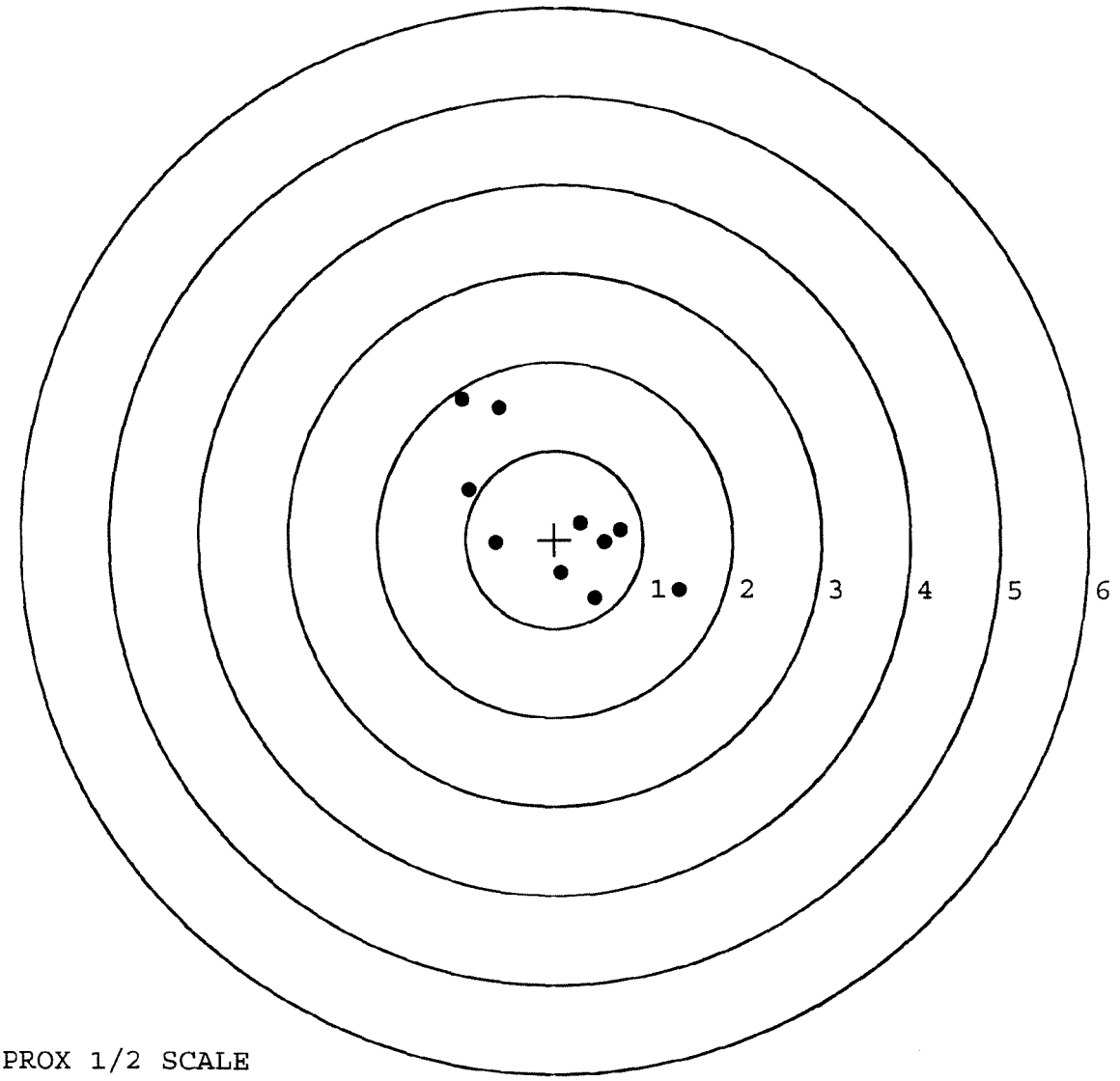
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.105
The Average Y Centroid of the Five Target Set:	0.014
The Average Point of Impact of the Five Target Set:	0.106
The Average Mean Radius of the Five Target Set:	0.794
The Distance from POA to Centroid Target #1:	0.227
The Distance from Centroid Target #2 to Centroid Target #1:	0.234
The Distance from Centroid Target #3 to Centroid Target #1:	0.062
The Distance from Centroid Target #4 to Centroid Target #1:	0.575
The Distance from Centroid Target #5 to Centroid Target #1:	0.438

SERIAL NUMBER: G6590200.__0
TARGET NUMBER: 1
FILE DATE: 02/11/2008
FILE TIME: 14:33

X CENTROID:	0.025
Y CENTROID:	0.225
POA TO CENTROID:	0.227
HORZ SPREAD:	2.449
VERT SPREAD:	2.233
GROUP SPREAD:	3.250
MIN RADIUS:	0.278
MAX RADIUS:	1.722
MEAN RADIUS:	0.971
# IN 1 IN DIAMETER:	1
# IN 2 IN DIAMETER:	6
# in 3 IN DIAMETER:	8

POINT#	X	Y
1:	1.404	-0.562
2:	0.746	0.109
3:	0.564	-0.032
4:	0.300	0.182
5:	0.460	-0.658
6:	0.074	-0.374
7:	-0.662	-0.045
8:	-0.960	0.566
9:	-0.630	1.492
10:	-1.045	1.575

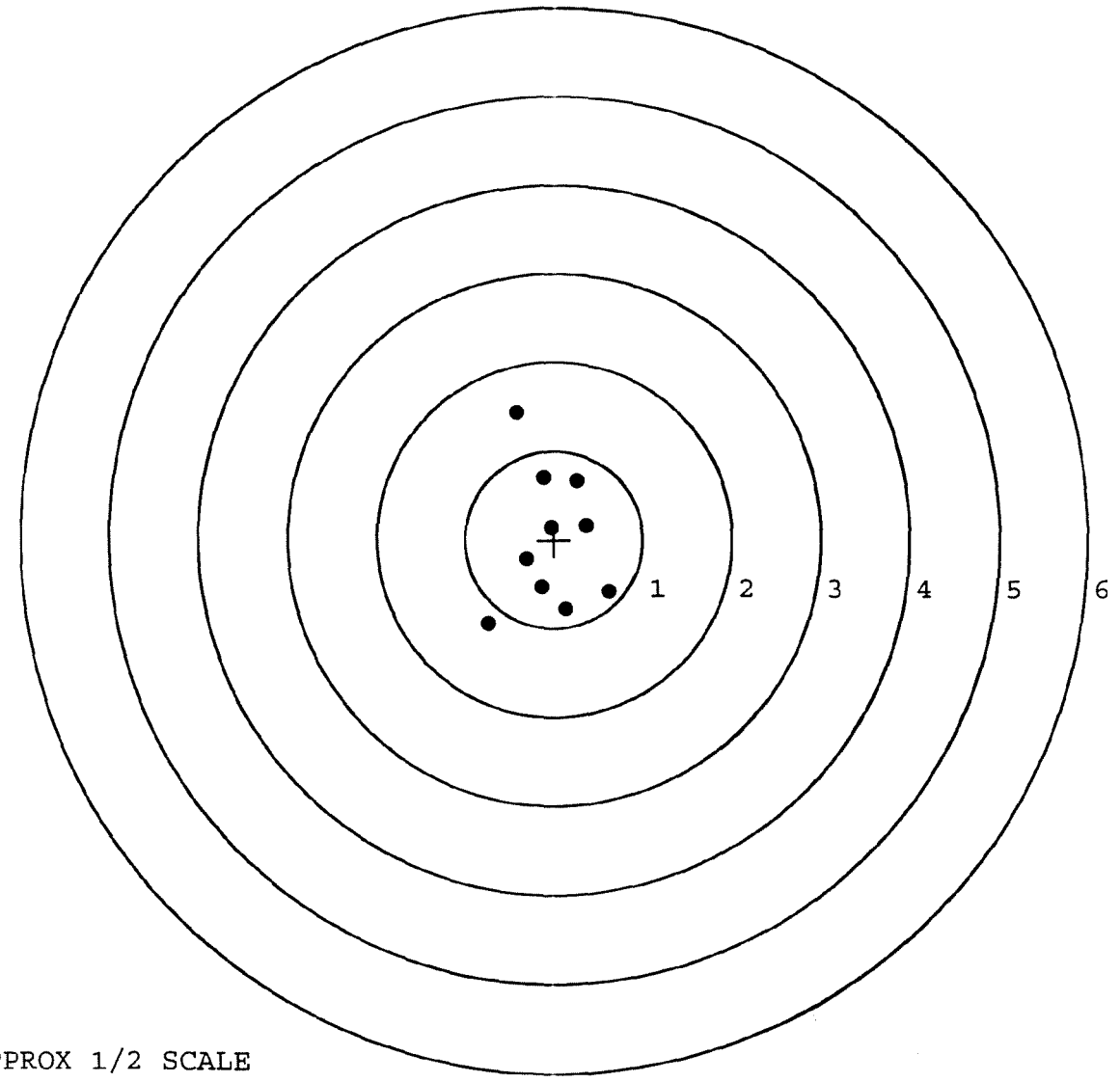


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590200.__0
TARGET NUMBER: 2
FILE DATE: 02/11/2008
FILE TIME: 14:33

X CENTROID:	-0.038
Y CENTROID:	0.000
POA TO CENTROID:	0.038
HORZ SPREAD:	1.361
VERT SPREAD:	2.384
GROUP SPREAD:	2.404
MIN RADIUS:	0.136
MAX RADIUS:	1.481
MEAN RADIUS:	0.726
# IN 1 IN DIAMETER:	3
# IN 2 IN DIAMETER:	8
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	0.623	-0.593
2:	0.134	-0.787
3:	-0.134	-0.537
4:	-0.311	-0.223
5:	-0.738	-0.955
6:	0.366	0.158
7:	-0.027	0.135
8:	0.255	0.666
9:	-0.121	0.705
10:	-0.426	1.429

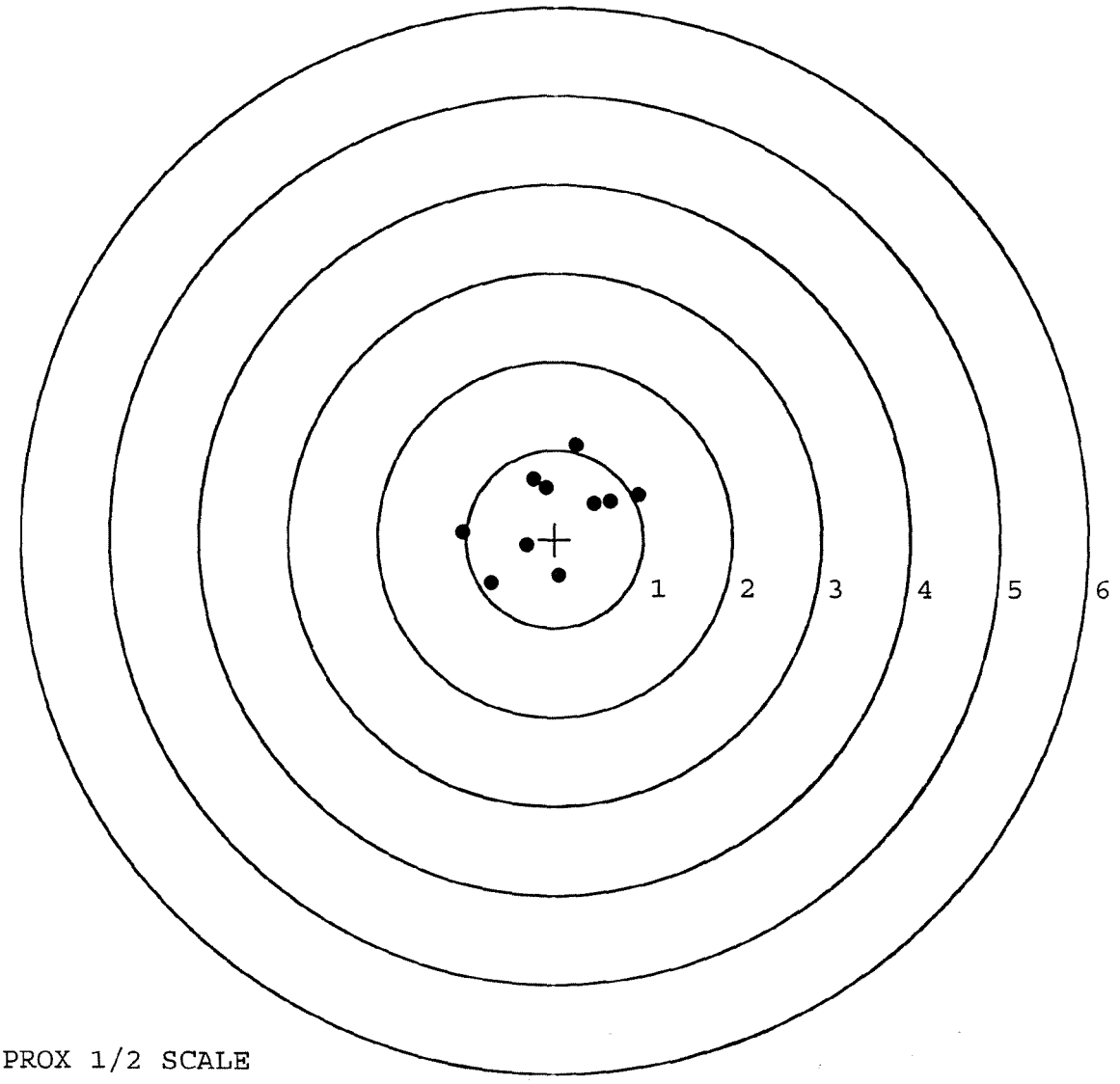


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590200.__0
TARGET NUMBER: 3
FILE DATE: 02/11/2008
FILE TIME: 14:33

X CENTROID:	-0.010
Y CENTROID:	0.276
POA TO CENTROID:	0.276
HORZ SPREAD:	1.981
VERT SPREAD:	1.556
GROUP SPREAD:	1.942
MIN RADIUS:	0.316
MAX RADIUS:	1.049
MEAN RADIUS:	0.696
# IN 1 IN DIAMETER:	4
# IN 2 IN DIAMETER:	8
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	0.945	0.504
2:	0.629	0.433
3:	0.450	0.401
4:	-0.104	0.578
5:	-0.242	0.680
6:	0.242	1.058
7:	-1.036	0.082
8:	-0.316	-0.067
9:	-0.718	-0.498
10:	0.047	-0.412

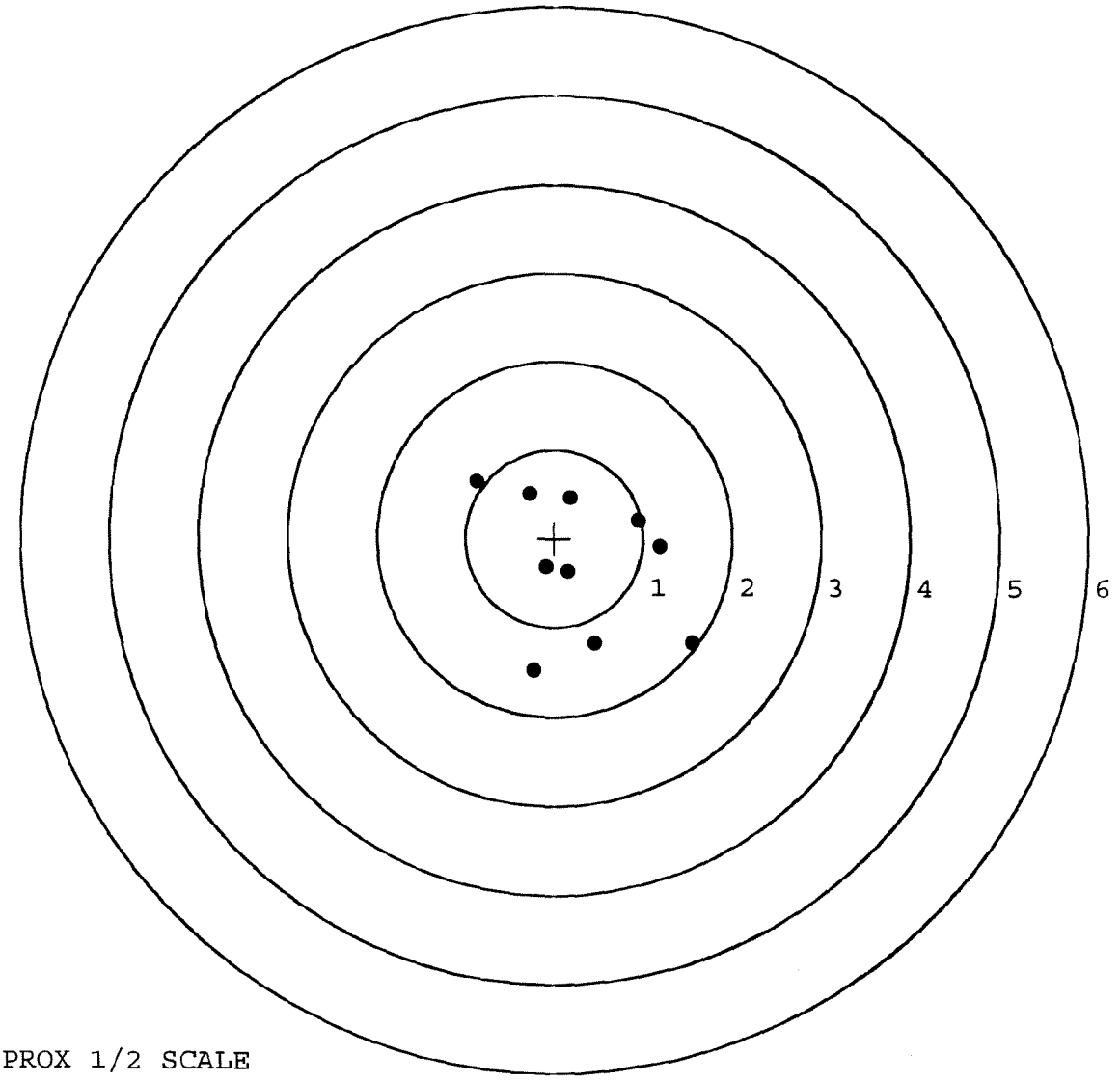


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590200.__0
TARGET NUMBER: 4
FILE DATE: 02/11/2008
FILE TIME: 14:33

X CENTROID:	0.299
Y CENTROID:	-0.281
POA TO CENTROID:	0.410
HORZ SPREAD:	2.428
VERT SPREAD:	2.133
GROUP SPREAD:	3.039
MIN RADIUS:	0.171
MAX RADIUS:	1.541
MEAN RADIUS:	0.929
# IN 1 IN DIAMETER:	2
# IN 2 IN DIAMETER:	7
# in 3 IN DIAMETER:	9

POINT#	X	Y
1:	1.553	-1.175
2:	0.457	-1.186
3:	-0.230	-1.481
4:	0.155	-0.374
5:	-0.098	-0.322
6:	1.187	-0.095
7:	0.942	0.203
8:	0.182	0.463
9:	-0.286	0.510
10:	-0.875	0.652

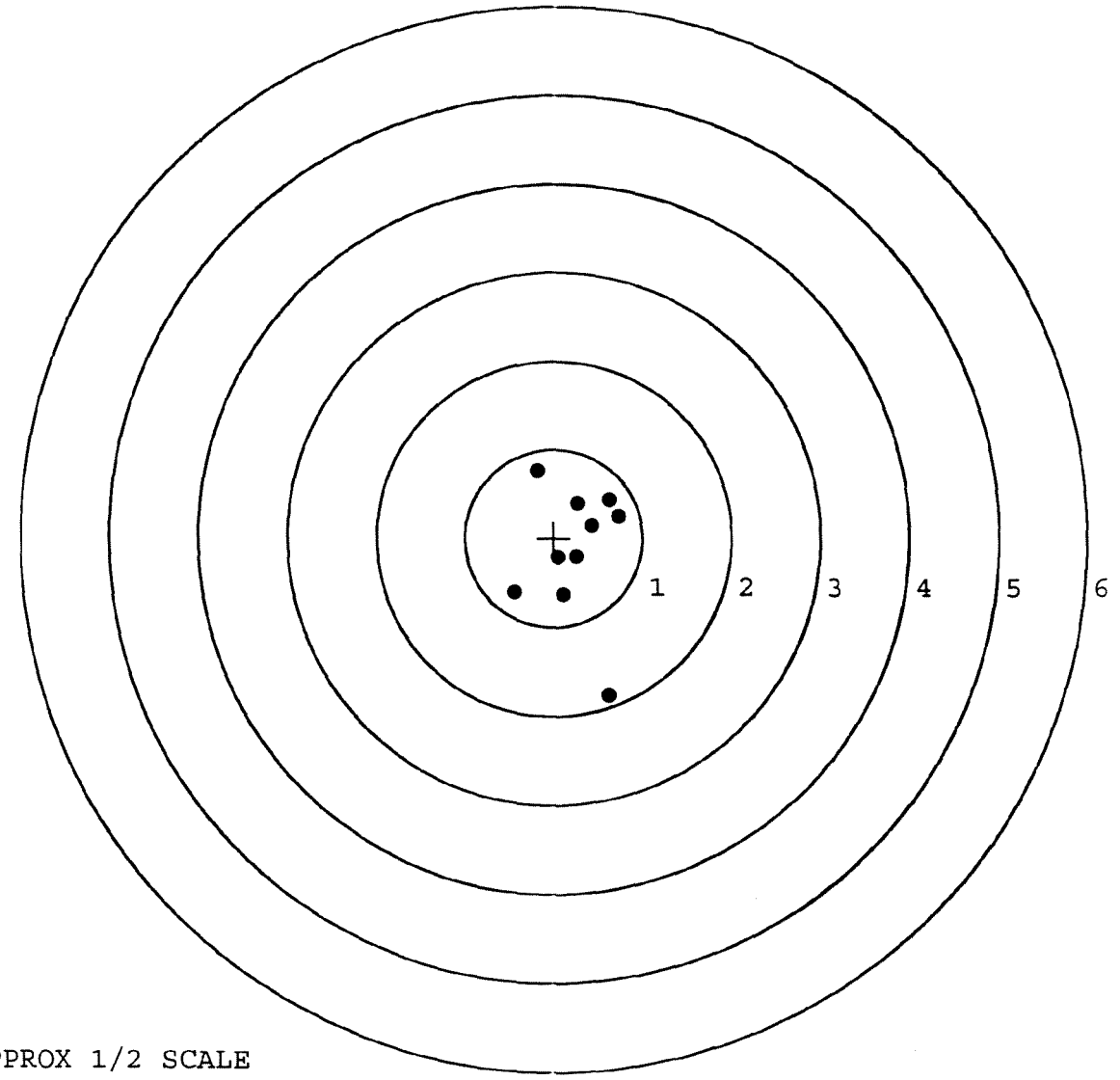


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590200.__0
TARGET NUMBER: 5
FILE DATE: 02/11/2008
FILE TIME: 14:33

X CENTROID:	0.249
Y CENTROID:	-0.151
POA TO CENTROID:	0.291
HORZ SPREAD:	1.172
VERT SPREAD:	2.522
GROUP SPREAD:	2.653
MIN RADIUS:	0.065
MAX RADIUS:	1.660
MEAN RADIUS:	0.650
# IN 1 IN DIAMETER:	3
# IN 2 IN DIAMETER:	8
# in 3 IN DIAMETER:	9

POINT#	X	Y
1:	0.632	-1.767
2:	-0.445	-0.620
3:	0.111	-0.645
4:	0.258	-0.216
5:	0.052	-0.221
6:	-0.192	0.755
7:	0.633	0.433
8:	0.727	0.240
9:	0.438	0.134
10:	0.272	0.392



TARGET APPROX 1/2 SCALE

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

R & E NUMBER 00140413

SERIAL NUMBER G6590200

LOG-IN DATE 1-22-08

OPERATION #	OPERATION NAME				DATE	INITIAL
500	DIS-ASSEMBLE GUN				1-24-08	L.P.D.
505	RE-BARREL				1-25-08	L.P.D.
560	ASSEMBLE				1-30-08	TRW
600	PROOF				1-30-08	TRW
605	CHECK HEADSPACE				1-30-08	TRW
610	DIS-ASSEMBLE GUN				1-30-08	L.P.D.
612	MAGNAFLUX	MAGNA-FLUX FEB 01 2008 OPERATOR JB			2-1-08	JB
510	DRILL AND TAP				1-30-08	TRW
615	ROLLMARK CALIBER				1-30-08	CW
618	ROTO-BLAST				2-4-08	KY
620	APPLY COATINGS				2-6-08	CW
625	FINAL ASSEMBLY				2-7-08	RTR
640	FUNCTION TEST AND	(PASS)	FAIL		2-8-08	TRW
650	TARGET	(PASS)	FAIL		2-8-08	TRW
	MALFUNCTION	CORRECTION		N/A		
	MALFUNCTION	CORRECTION				
	MALFUNCTION	CORRECTION				
	MALFUNCTION	CORRECTION			2-8-08	R.P.
670	FINAL INSPECTION				2-12-08	DA
	A) HEADSPACE	PASS	FAIL		2-12-08	DA
	B) TRIGGER PULL (+/- .5 LBS, MIN 2.50 LBS, MAX 4.0 LBS)	2.83	2.86	2.79 2.94 2.87	2-12-08	DA
680	F) SAFETY ON FORCE (2 LBS MIN, 10 LBS MAX)	4.5	4.5	4.5	2-12-08	DA
	G) SAFETY OFF FORCE (2 LBS MIN)	3	2.5	2.5	2-12-08	DA
	I) FIRING PIN INDENT (.020)	.021	.021	.0205	2-12-08	DA
690	PACK				2-19-08	FM

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: RE00118095

Verify Repair

Serial: G6236245 Model M24 SWS Center Fire
Caliber: 7.62 NATO

Repairman:

Status: Closed 9/28/2006 8:41:42 AM

Address Information

	Customer: (Received From)	Return To: (Received From)
Name:	TRANSPORATION DIVISION, DFEL.	TRANSPORATION DIVISION, DFEL.
Address 1:	6759 MITCHELL AVENUE	6759 MITCHELL AVENUE
Address 2:	BLDG 1836 PO Box:	BLDG 1836 PO Box:
City:	FORT BENNING	FORT BENNING
State:	GA Zip Code: 31905 Country: US	GA Zip Code: 31905 Country: US

FFL:

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

Contact Information

Phone: NA
Fax:
Email:
Comments:

Received Condition

Poor
Condition Notes:
CSR Notes:

Accessories Received

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

Repair Search | Refresh | Close

nagletj | 9/28/2006 | 8:48 AM | CAPS | NUM | INS | SCRL

start | 3 M. | 3 M. | 5 I.. | Par... | Sto... | Mo... | Ar... | 8:48 AM

G6590200 (New)

Serial Number: ~~G6236245~~ G6236245

Model: M24 SWS

RE00118095

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFOMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6590200.__0
FILE DATE AND TIME: 10/11/2006 01:14

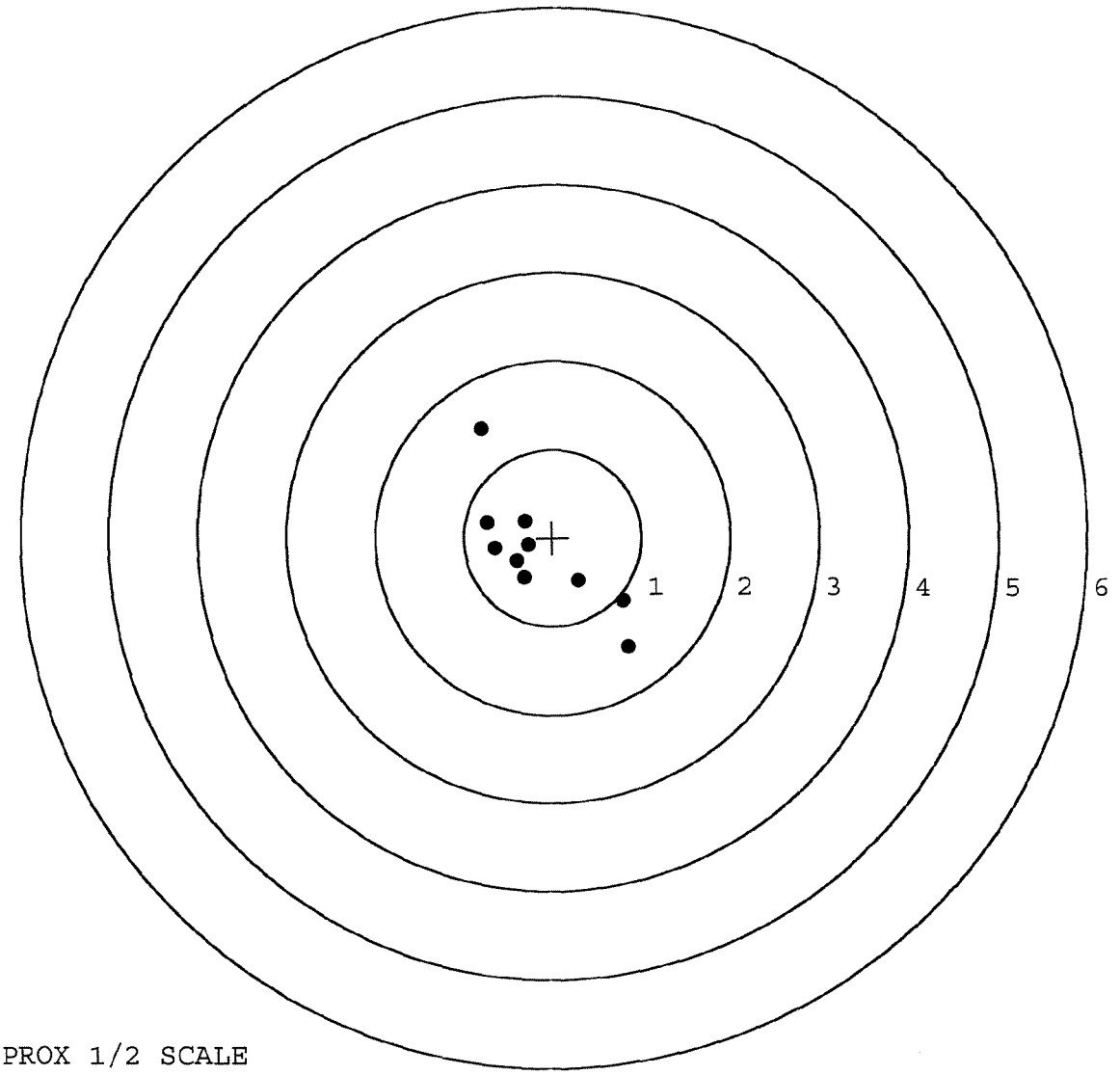
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.064
The Average Y Centroid of the Five Target Set:	-0.017
The Average Point of Impact of the Five Target Set:	0.066
The Average Mean Radius of the Five Target Set:	0.683
The Distance from POA to Centroid Target #1:	0.237
The Distance from Centroid Target #2 to Centroid Target #1:	0.273
The Distance from Centroid Target #3 to Centroid Target #1:	0.242
The Distance from Centroid Target #4 to Centroid Target #1:	0.414
The Distance from Centroid Target #5 to Centroid Target #1:	0.270

SERIAL NUMBER: G6590200.__0
TARGET NUMBER: 1
FILE DATE: 10/11/2006
FILE TIME: 01:14

X CENTROID:	-0.156
Y CENTROID:	-0.179
POA TO CENTROID:	0.237
HORZ SPREAD:	1.674
VERT SPREAD:	2.462
GROUP SPREAD:	2.977
MIN RADIUS:	0.154
MAX RADIUS:	1.549
MEAN RADIUS:	0.699
# IN 1 IN DIAMETER:	5
# IN 2 IN DIAMETER:	7
# in 3 IN DIAMETER:	9

POINT#	X	Y
1:	0.863	-1.237
2:	0.802	-0.716
3:	0.299	-0.488
4:	-0.811	1.225
5:	-0.317	0.188
6:	-0.746	0.173
7:	-0.650	-0.121
8:	-0.406	-0.272
9:	-0.315	-0.454
10:	-0.278	-0.085

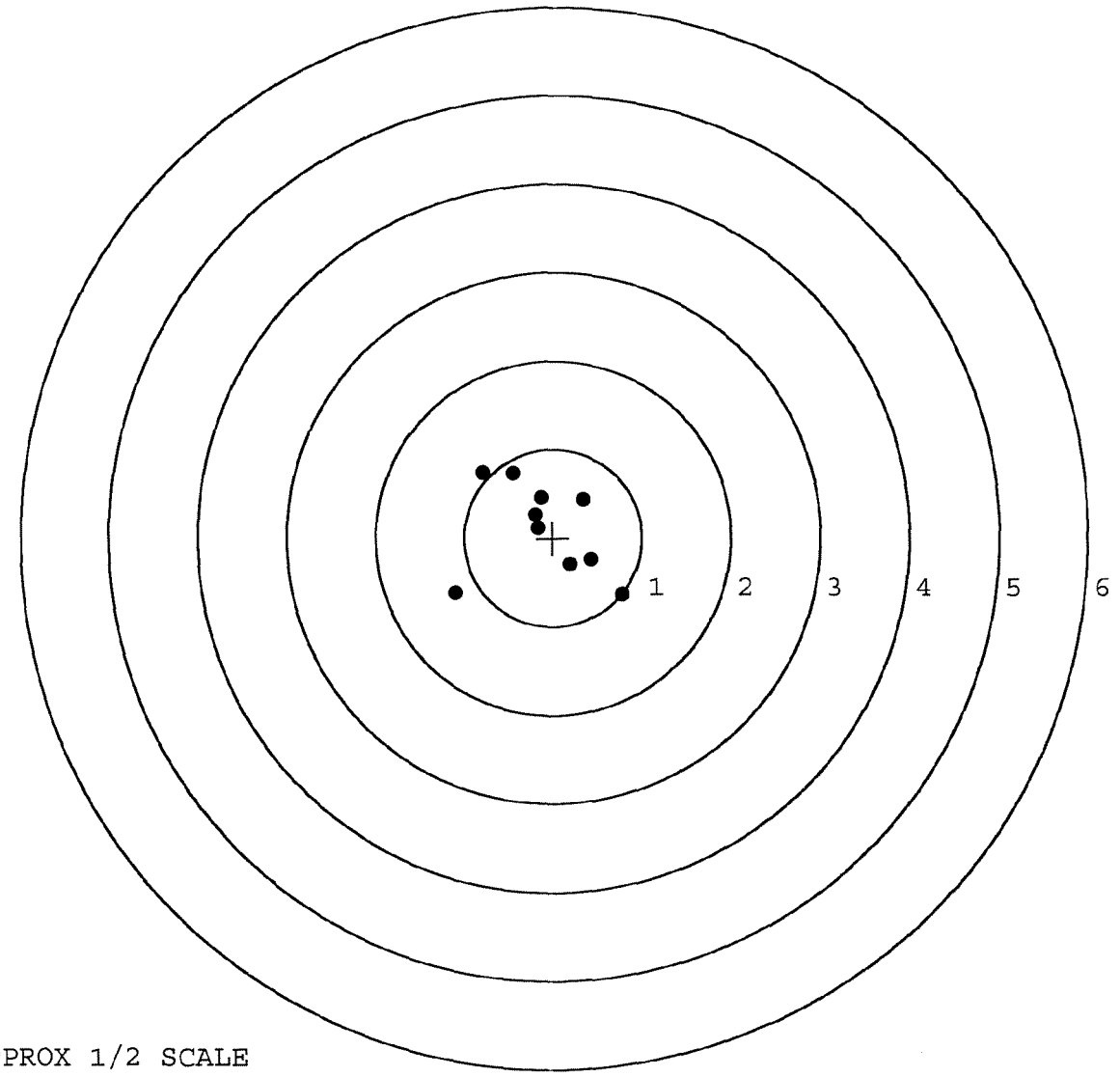


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590200.__0
TARGET NUMBER: 2
FILE DATE: 10/11/2006
FILE TIME: 01:14

X CENTROID:	-0.112
Y CENTROID:	0.090
POA TO CENTROID:	0.144
HORZ SPREAD:	1.880
VERT SPREAD:	1.378
GROUP SPREAD:	1.880
MIN RADIUS:	0.065
MAX RADIUS:	1.219
MEAN RADIUS:	0.636
# IN 1 IN DIAMETER:	3
# IN 2 IN DIAMETER:	8
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	-1.099	-0.625
2:	0.781	-0.642
3:	0.427	-0.243
4:	0.198	-0.303
5:	0.346	0.433
6:	-0.174	0.109
7:	-0.202	0.257
8:	-0.139	0.451
9:	-0.458	0.729
10:	-0.797	0.736

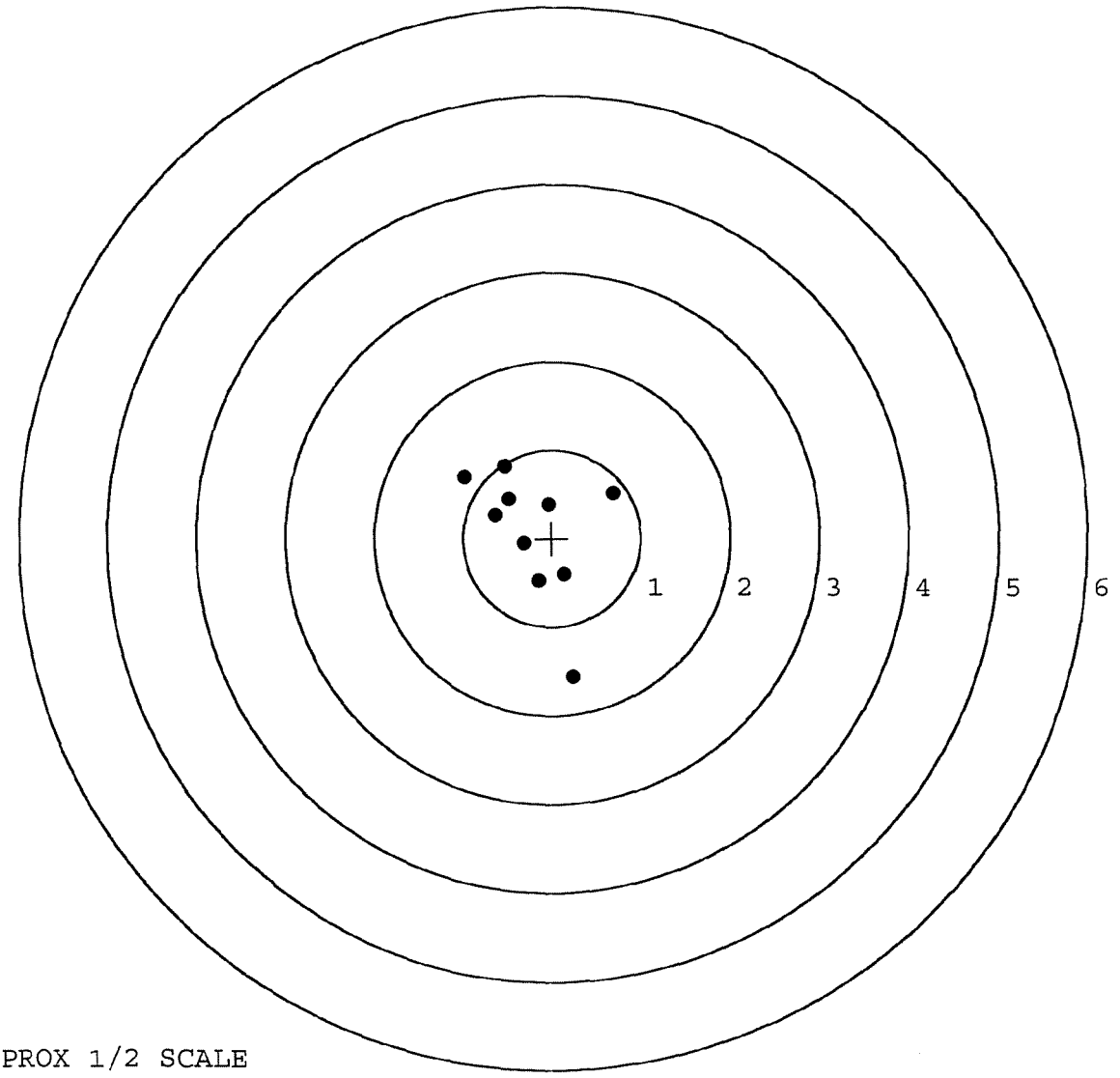


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590200.__0
TARGET NUMBER: 3
FILE DATE: 10/11/2006
FILE TIME: 01:14

X CENTROID:	-0.209
Y CENTROID:	0.057
POA TO CENTROID:	0.216
HORZ SPREAD:	1.686
VERT SPREAD:	2.384
GROUP SPREAD:	2.582
MIN RADIUS:	0.158
MAX RADIUS:	1.689
MEAN RADIUS:	0.715
# IN 1 IN DIAMETER:	4
# IN 2 IN DIAMETER:	7
# in 3 IN DIAMETER:	9

POINT#	X	Y
1:	0.249	-1.569
2:	0.693	0.507
3:	0.144	-0.412
4:	-0.152	-0.487
5:	-0.314	-0.061
6:	-0.646	0.255
7:	-0.046	0.385
8:	-0.488	0.443
9:	-0.535	0.815
10:	-0.993	0.695

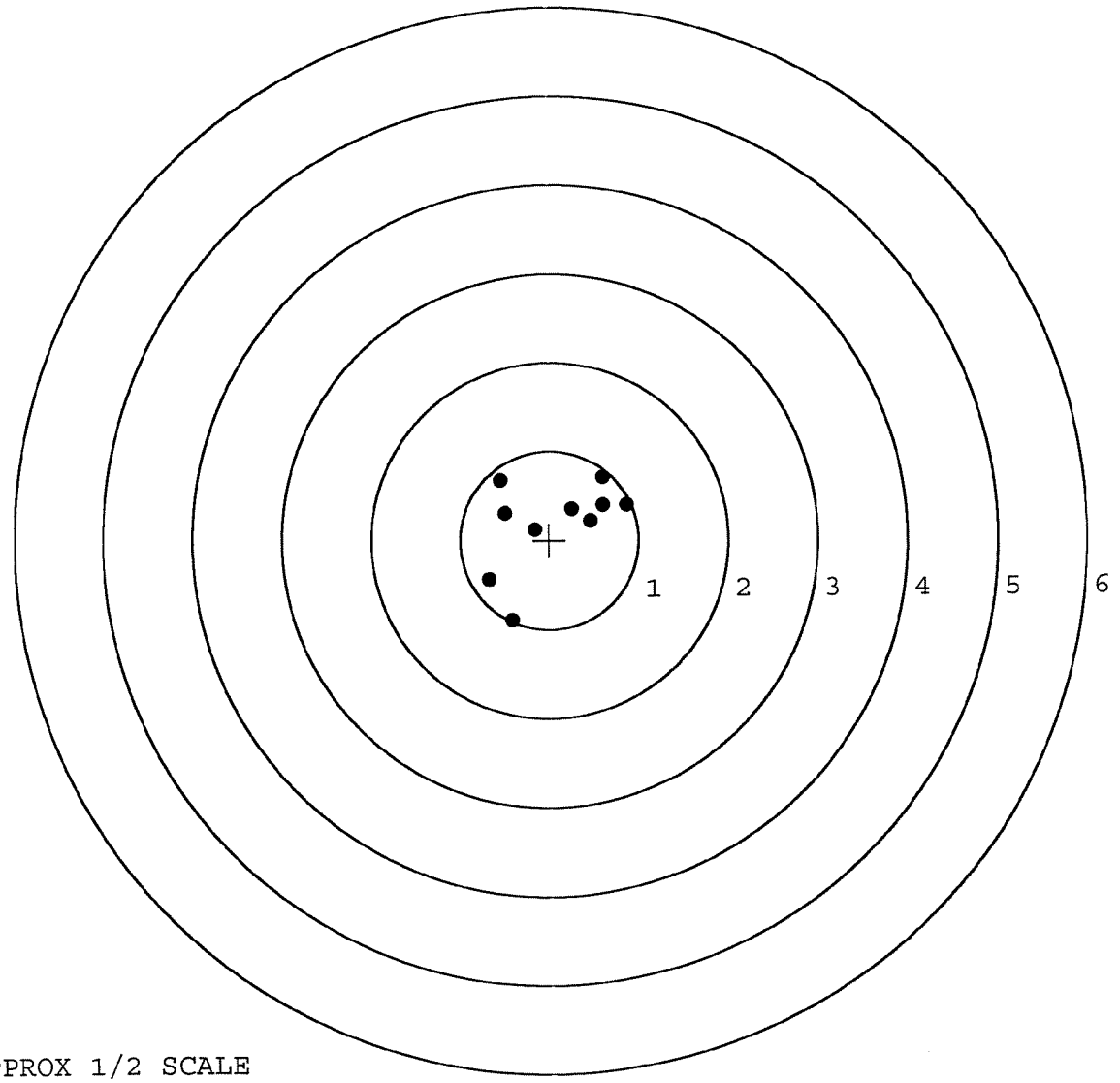


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590200.__0
TARGET NUMBER: 4
FILE DATE: 10/11/2006
FILE TIME: 01:14

X CENTROID:	0.049
Y CENTROID:	0.181
POA TO CENTROID:	0.187
HORZ SPREAD:	1.549
VERT SPREAD:	1.598
GROUP SPREAD:	1.899
MIN RADIUS:	0.220
MAX RADIUS:	1.176
MEAN RADIUS:	0.657
# IN 1 IN DIAMETER:	3
# IN 2 IN DIAMETER:	9
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	-0.425	-0.895
2:	-0.676	-0.439
3:	-0.553	0.675
4:	-0.494	0.304
5:	-0.161	0.115
6:	0.601	0.703
7:	0.873	0.391
8:	0.259	0.349
9:	0.462	0.219
10:	0.602	0.387

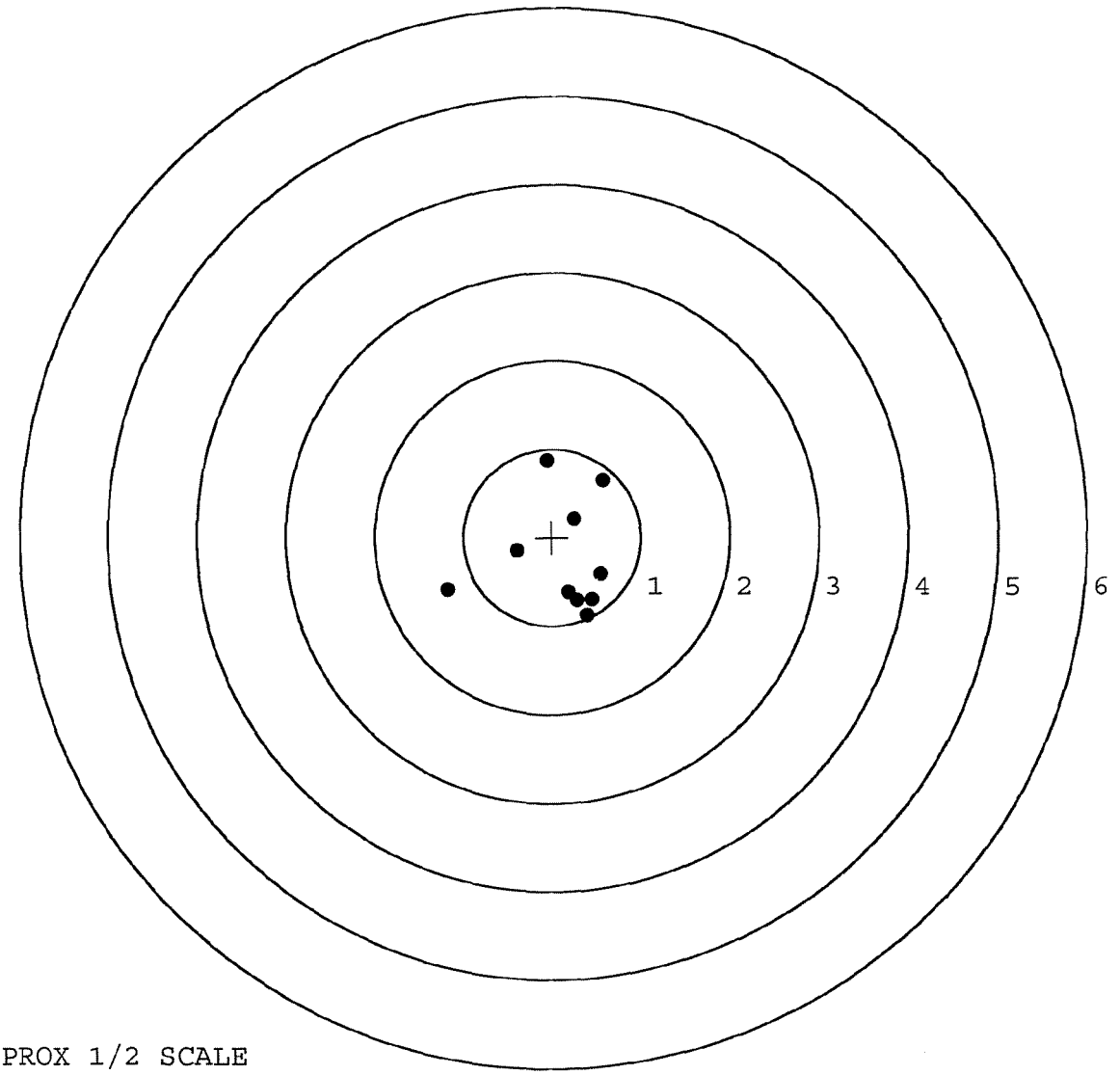


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590200.__0
TARGET NUMBER: 5
FILE DATE: 10/11/2006
FILE TIME: 01:14

X CENTROID:	0.108
Y CENTROID:	-0.236
POA TO CENTROID:	0.260
HORZ SPREAD:	1.755
VERT SPREAD:	1.751
GROUP SPREAD:	2.153
MIN RADIUS:	0.390
MAX RADIUS:	1.335
MEAN RADIUS:	0.710
# IN 1 IN DIAMETER:	3
# IN 2 IN DIAMETER:	7
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	0.578	0.649
2:	-0.060	0.867
3:	0.250	0.209
4:	-0.398	-0.156
5:	-1.177	-0.598
6:	0.193	-0.617
7:	0.549	-0.419
8:	0.456	-0.703
9:	0.403	-0.884
10:	0.288	-0.713



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 9-30-06

TESTER RP

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	259	247		2.53	
PULL #2	250	255		250	
PULL #3	247	240		247	
PULL #4	256	250		244	
PULL #5	257	254		250	
TOTAL	1269	1246		12.44	
AVERAGE	253	249		248	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	302	321		
PULL #2	298	324		
PULL #3	296	316		
PULL #4	304	325		
PULL #5	306	326		
TOTAL	15.06	16.12		
AVERAGE	301	322		

	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	4.15	4.21		4.03
PULL #2	4.16	4.05		4.02
PULL #3	4.09	4.05		4.02
PULL #4	4.14	4.07		3.99
PULL #5	4.10	4.11		4.12
TOTAL	20.64	20.49		20.18
AVERAGE	4.12	4.09		4.03

DATE: 20060911 MAINTENANCE REQUEST DA FORM 5990-E

---------- CUSTOMER DATA ----------

UIC: W2L58L HHC 2/29 INF. REGT. PHONE: (706)544-1450
UTIL CODE: 0

---------- ACTIVITY DATA ----------

SUP WON: ITT PHONE: 544-8635
SUP UIC: W6CR07 SHOP SEC:

---------- EQUIPMENT DATA ----------

TYPE MNT REQ: 1 ID: A NSN: 1005012402136 MODEL: M24RIFLE

NOUN: RIFLE 7.62MM SNIP SER NUM: G6236245 / 881195 QTY: 00001

ORG WON: 2L58L1601268 PRIORITY: 03 FAILURE DETECTED: F

MI/KM: 000000 HOURS: ------ ROUNDS:

IN WARRANTY: N LEVEL OF WORK: F ADMIN NUM: S-29

DEFICIENCY: FIRING PIN NOTCH WORN

PD AUTHENTICATING SIGNATURE: _____

---------- SIGNATURE DATA ----------

SUBMITTED BY: SSG Phillips ORD DATE: 06256 MIL TIME: 1110

ACCEPTED BY: E Bullard STATUS: A ORD DATE: 06256 MIL TIME: 1110

---------- ACTION DATA ----------

WORK STARTED BY: _____ STATUS: ___ ORD DATE: _____ MIL TIME: _____

INSPECTED BY: _____ STATUS: ___ ORD DATE: _____ MIL TIME: _____

PICKED UP BY: _____ STATUS: ___ ORD DATE: _____ MIL TIME: _____

---------- COMPLETION DATA ----------

QTY RPR: _____ QTY CONDEMNED: _____ NRTS: _____

EVAC WON: _____ EVAC UNIT NAME: _____

575-8183
SSG Phillips

WC W6GIA64
APC mgwm
WAR
K4AB

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

R & E NUMBER	118097			
SERIAL NUMBER	~~G6236245~~	G6590200 (New)		
LOG-IN DATE	9-28-06			

OPERATION #	OPERATION NAME		DATE	INITIAL
500	DIS-ASSEMBLE GUN		9-30-06	RTL
505	RE-BARREL		10-4-06	RTL
420	ASSEMBLE		10-4-06	RTL
440	PROOF	MAGNA-FLUX INSPECTED OCT 06 2006	10-4-06	TRW
460	CHECK HEADSPACE		10-4-06	TRW
470	DIS-ASSEMBLE GUN		10-4-06	RTL
480	MAGNAFLUX	OPERATOR (illegible)	10-6-06	DPD
510	DRILL AND TAP		10-5-06	SD
500	ROLLMARK CALIBER		10-6-06	RP
520	GOFF BLAST BBL / REC		10-6-06	LB
530 & 540	APPLY COATINGS		10/9/06	
560	FINAL ASSEMBLY		10-10-06	RTL
640	FUNCTION TEST AND	(PASS) FAIL	10-10-06	L.P.D.
650	TARGET	(PASS) FAIL	10-10-06	L.P.D.
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION	N/A	
	MALFUNCTION	CORRECTION		
670	FINAL INSPECTION		10-18-06	RTL
	A) HEADSPACE	PASS FAIL	10-18-06	RTL
	B) TRIGGER PULL (+/- .5 LBS, MIN 2.50 LBS, MAX 4.0 LBS)	2.26 2.30 2.20 2.28 2.28	10-12-06	DA
680	F) SAFETY ON FORCE (2 LBS MIN, 10 LBS MAX)	6# 6# 6#	10-12-06	DA
	G) SAFETY OFF FORCE (2 LBS MIN)	2.5 2.5 2.5	10-12-06	DA
	I) FIRING PIN INDENT (.020)	.021 .020 .021	10-12-06	DA
690	PACK		10-19-06	DA

F006 REV 5/2006

FINAL INSPECTION CHECKLIST

BARREL ASSEMBLY

_____ BARREL

_____ RECEIVER

_____ FRONT SIGHT BASE

_____ REAR SIGHT BASE

_____ SCREWS

_____ FINISH

SCOPE ASSEMBLY

_____ SCOPE

_____ SCOPE RINGS

_____ MOUNTING SCREWS

_____ MOUNTING BASE

_____ SCREWS

_____ FINISH

_____ CLARITY

STOCK ASSEMBLY

_____ STOCK

_____ SLING SWIVEL STUDS

_____

_____ BUTT PATE

_____ LOCK NUTS

_____ BARREL CLEARANCE

_____ COLOR / FINISH

SYSTEM CASE

_____ SCOPE CASE

_____ IRON SIGHTS

_____ DEPLOYMENT KIT

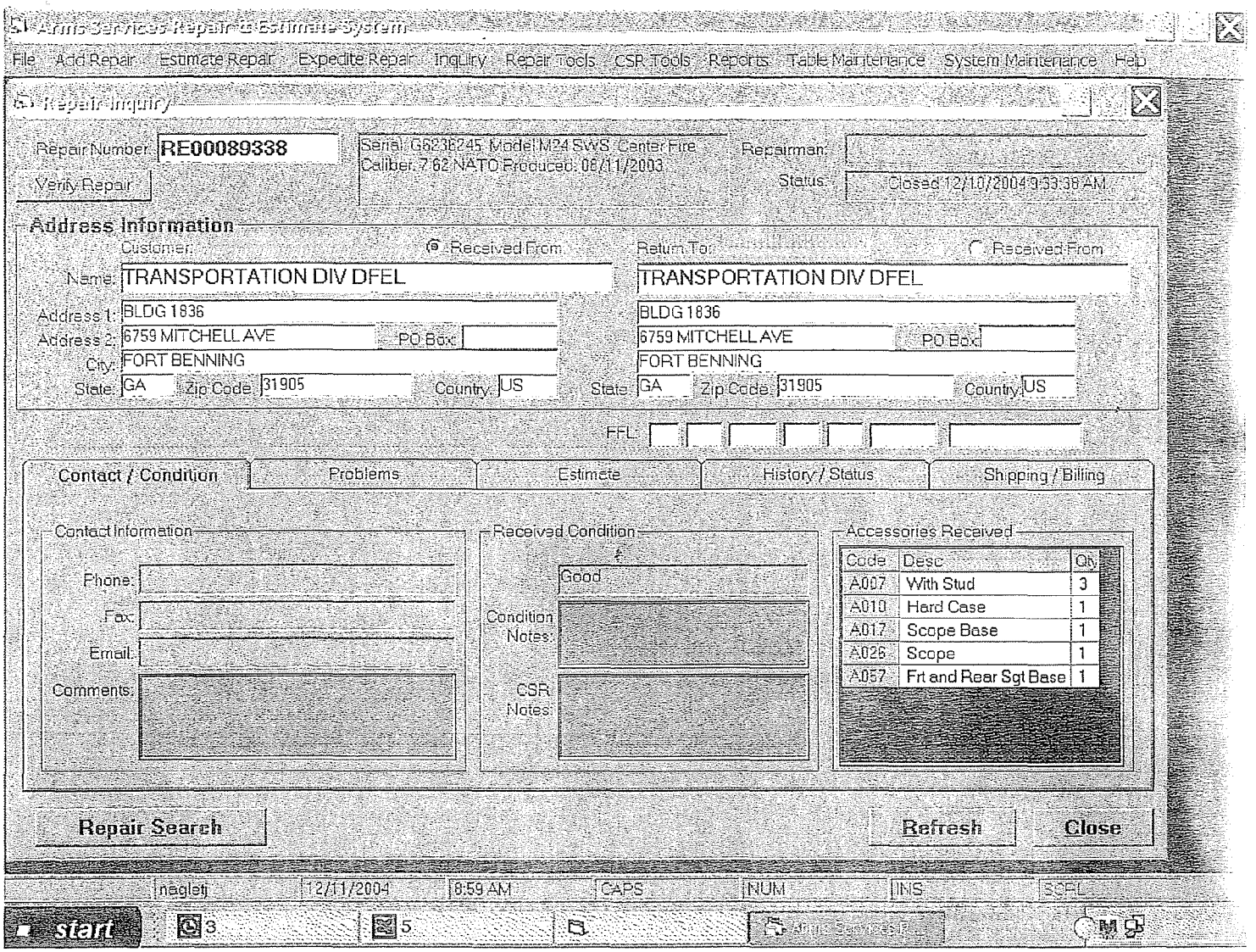
TRIGGER ASSEMBLY

_____ SAFETY OPERATION

_____ RE-SET TO FACTORY SPECS

COMMENTS: _____

F006 REV 5/2006


Arms Services Repair & Estimate System
File Add Repair Estimate Repair Expedite Repair Inquiry Repair Tools CSR Tools Reports Table Maintenance System Maintenance Help
Repair Inquiry
Repair Number: RE00089338
Verify Repair
Serial: G6236245 Model: M24 SWS Center Fire
Caliber: 7.62 NATO Produced: 08/11/2003
Repairman:
Status: Closed 12/10/2004 9:33:38 AM
Address Information
Customer: Received From
Name: TRANSPORTATION DIV DFEL
Address 1: BLDG 1836
Address 2: 6759 MITCHELL AVE PO Box:
City: FORT BENNING
State: GA Zip Code: 31905 Country: US
Return To: Received From
TRANSPORTATION DIV DFEL
BLDG 1836
6759 MITCHELL AVE PO Box:
FORT BENNING
State: GA Zip Code: 31905 Country: US
FFL:
Contact / Condition
Problems
Estimate
History / Status
Shipping / Billing
Contact Information
Phone:
Fax:
Email:
Comments:
Received Condition
Good
Condition Notes:
CSR Notes:
Accessories Received
Code Desc Qty
A007 With Stud 3
A010 Hard Case 1
A017 Scope Base 1
A026 Scope 1
A057 Frt and Rear Sgt Base 1
Repair Search
Refresh
Close
naglelj 12/11/2004 8:59 AM CAPS NUM INS SCRL
start


Serial Number: G6236245
Model: M24 SWS
RE00089338

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFOMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6236245.__1
FILE DATE AND TIME: 01/05/2005 11:09

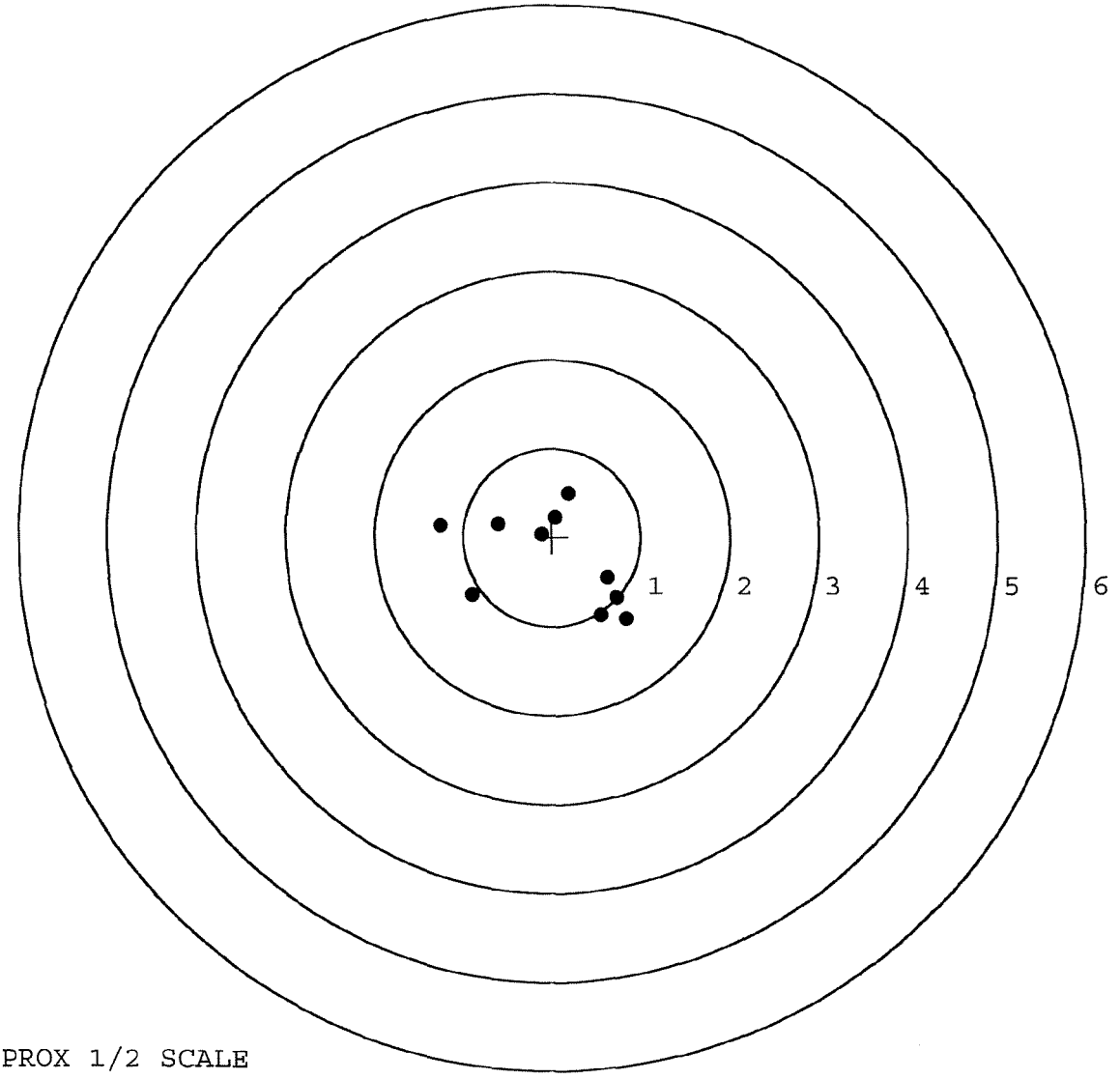
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.049
The Average Y Centroid of the Five Target Set:	-0.080
The Average Point of Impact of the Five Target Set:	0.094
The Average Mean Radius of the Five Target Set:	0.751
The Distance from POA to Centroid Target #1:	0.258
The Distance from Centroid Target #2 to Centroid Target #1:	0.445
The Distance from Centroid Target #3 to Centroid Target #1:	0.066
The Distance from Centroid Target #4 to Centroid Target #1:	0.180
The Distance from Centroid Target #5 to Centroid Target #1:	0.304

SERIAL NUMBER: G6236245.__1
TARGET NUMBER: 1
FILE DATE: 01/05/2005
FILE TIME: 11:09

X CENTROID:	0.011
Y CENTROID:	-0.258
POA TO CENTROID:	0.258
HORZ SPREAD:	2.093
VERT SPREAD:	1.414
GROUP SPREAD:	2.347
MIN RADIUS:	0.316
MAX RADIUS:	1.326
MEAN RADIUS:	0.799
# IN 1 IN DIAMETER:	2
# IN 2 IN DIAMETER:	8
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	0.839	-0.923
2:	0.731	-0.685
3:	0.553	-0.883
4:	0.624	-0.465
5:	-0.605	0.148
6:	-1.254	0.140
7:	-0.116	0.031
8:	0.046	0.215
9:	0.188	0.491
10:	-0.897	-0.651

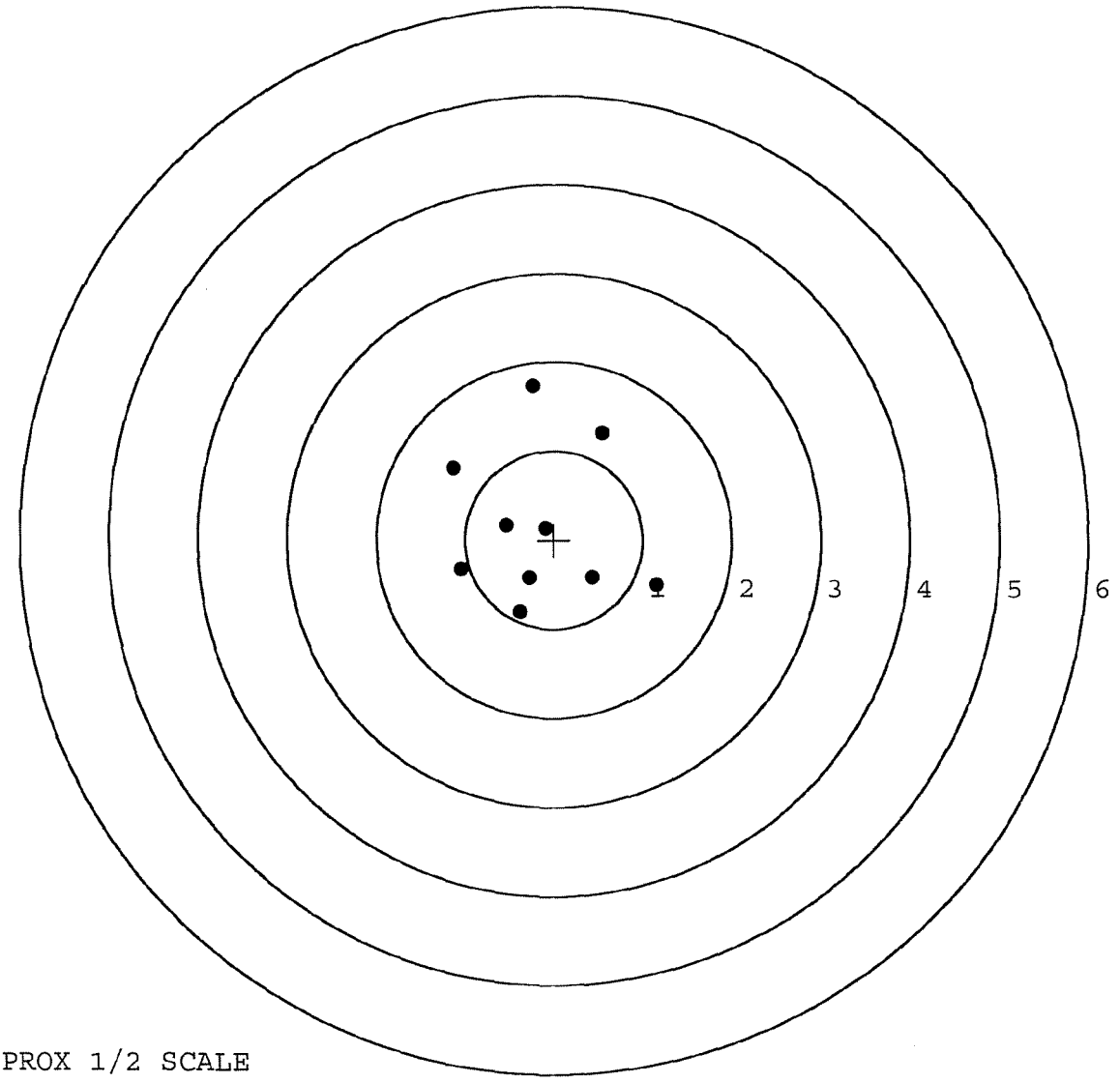


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6236245.__1
TARGET NUMBER: 2
FILE DATE: 01/05/2005
FILE TIME: 11:09

X CENTROID:	-0.156
Y CENTROID:	0.154
POA TO CENTROID:	0.219
HORZ SPREAD:	2.292
VERT SPREAD:	2.542
GROUP SPREAD:	2.633
MIN RADIUS:	0.063
MAX RADIUS:	1.572
MEAN RADIUS:	0.935
# IN 1 IN DIAMETER:	2
# IN 2 IN DIAMETER:	5
# in 3 IN DIAMETER:	9

POINT#	X	Y
1:	1.156	-0.509
2:	0.437	-0.421
3:	-0.374	-0.818
4:	-0.279	-0.430
5:	-0.095	0.138
6:	-0.534	0.169
7:	-1.045	-0.327
8:	-1.136	0.813
9:	0.547	1.199
10:	-0.239	1.724

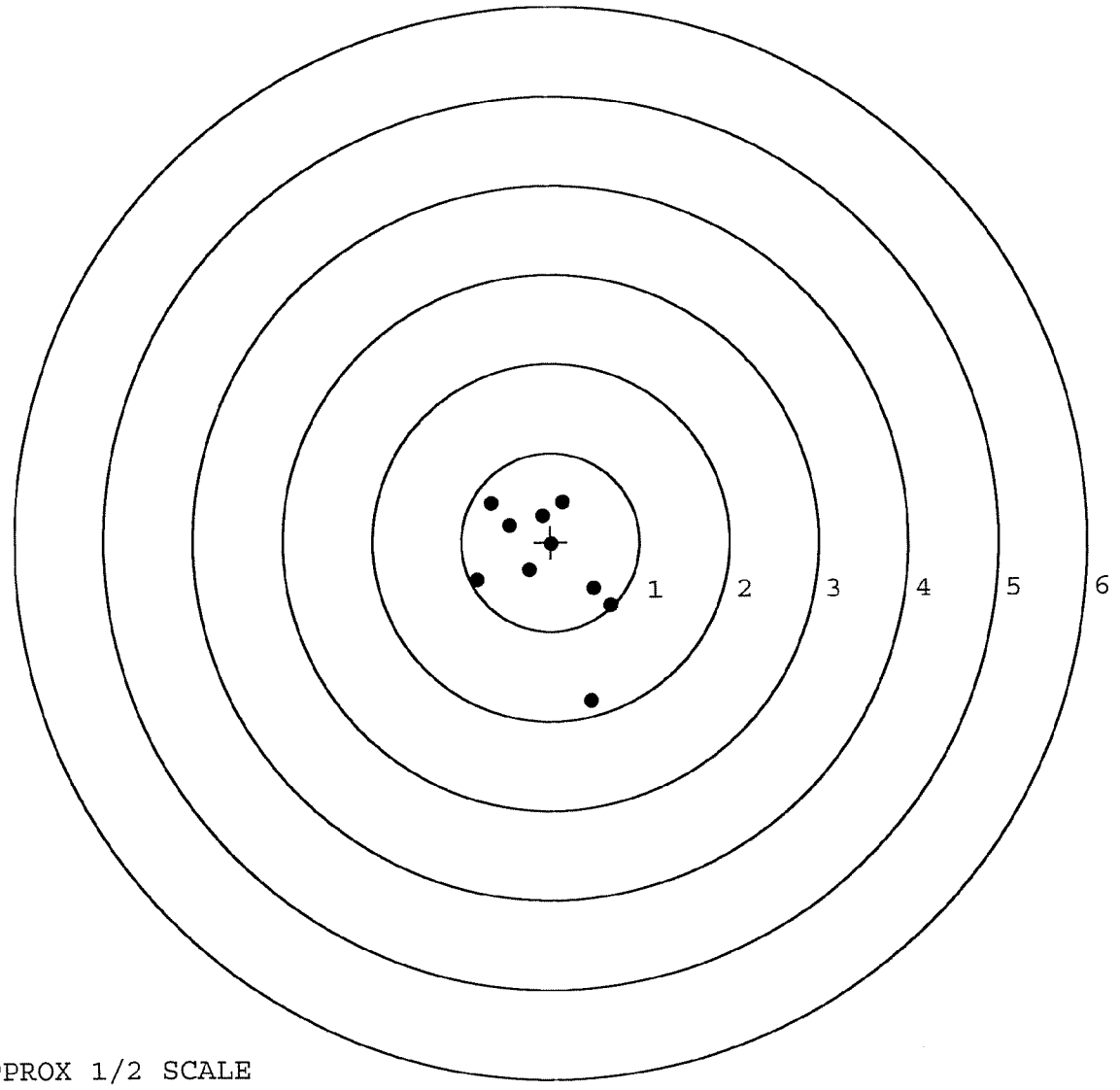


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6236245.__1
TARGET NUMBER: 3
FILE DATE: 01/05/2005
FILE TIME: 11:09

X CENTROID:	-0.053
Y CENTROID:	-0.242
POA TO CENTROID:	0.247
HORZ SPREAD:	1.499
VERT SPREAD:	2.227
GROUP SPREAD:	2.485
MIN RADIUS:	0.205
MAX RADIUS:	1.617
MEAN RADIUS:	0.708
# IN 1 IN DIAMETER:	2
# IN 2 IN DIAMETER:	9
# in 3 IN DIAMETER:	9

POINT#	X	Y
1:	0.446	-1.780
2:	0.670	-0.720
3:	0.481	-0.528
4:	-0.829	-0.424
5:	-0.660	0.445
6:	-0.454	0.187
7:	0.145	0.447
8:	-0.093	0.294
9:	0.012	-0.021
10:	-0.243	-0.316

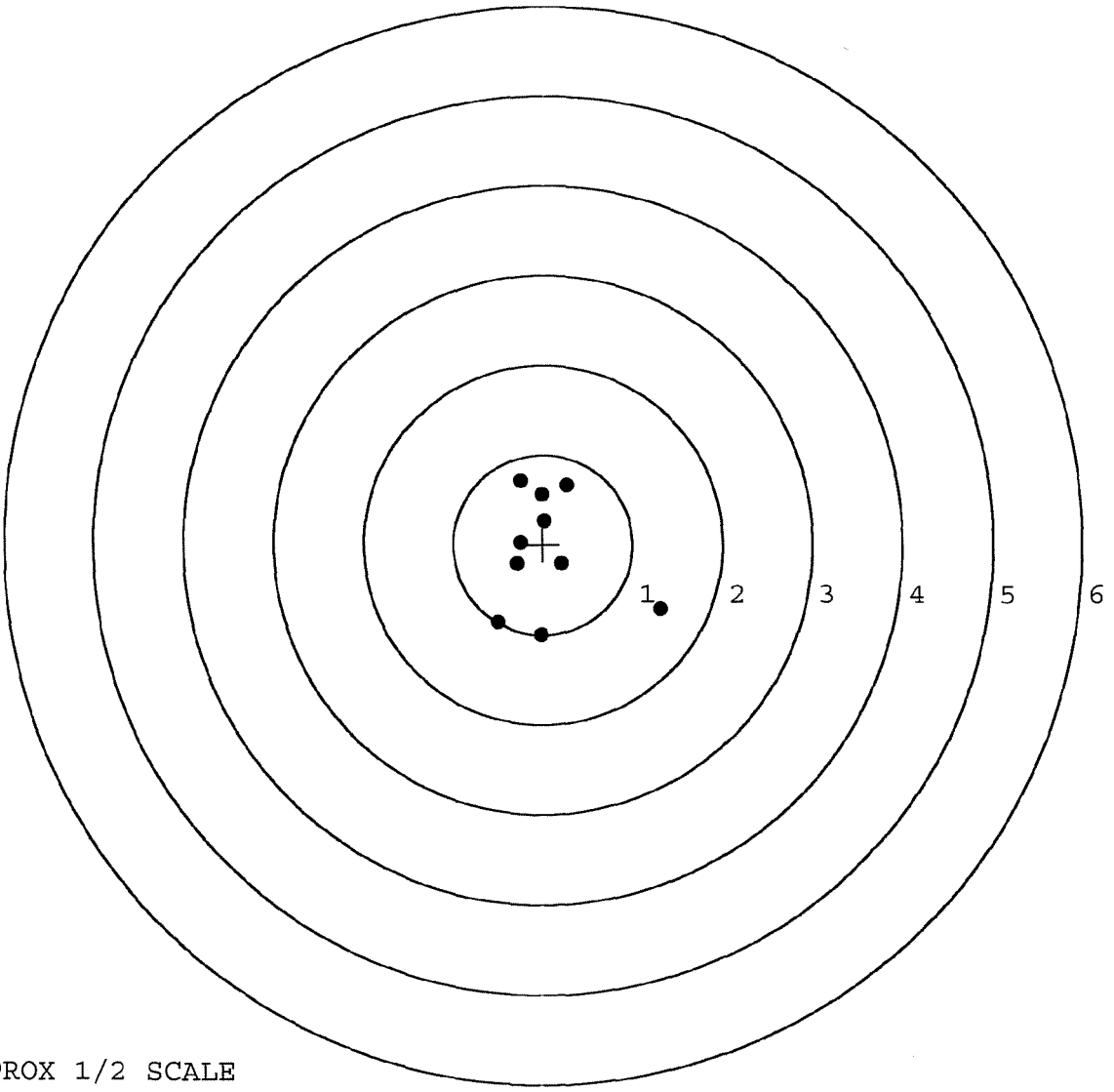


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6236245.__1
TARGET NUMBER: 4
FILE DATE: 01/05/2005
FILE TIME: 11:09

X CENTROID:	0.048
Y CENTROID:	-0.083
POA TO CENTROID:	0.096
HORZ SPREAD:	1.813
VERT SPREAD:	1.720
GROUP SPREAD:	2.120
MIN RADIUS:	0.213
MAX RADIUS:	1.416
MEAN RADIUS:	0.683
# IN 1 IN DIAMETER:	4
# IN 2 IN DIAMETER:	9
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	1.310	-0.725
2:	0.213	-0.217
3:	-0.019	-1.011
4:	-0.503	-0.873
5:	-0.293	-0.219
6:	-0.252	0.026
7:	0.025	0.266
8:	0.271	0.664
9:	-0.252	0.709
10:	-0.018	0.555

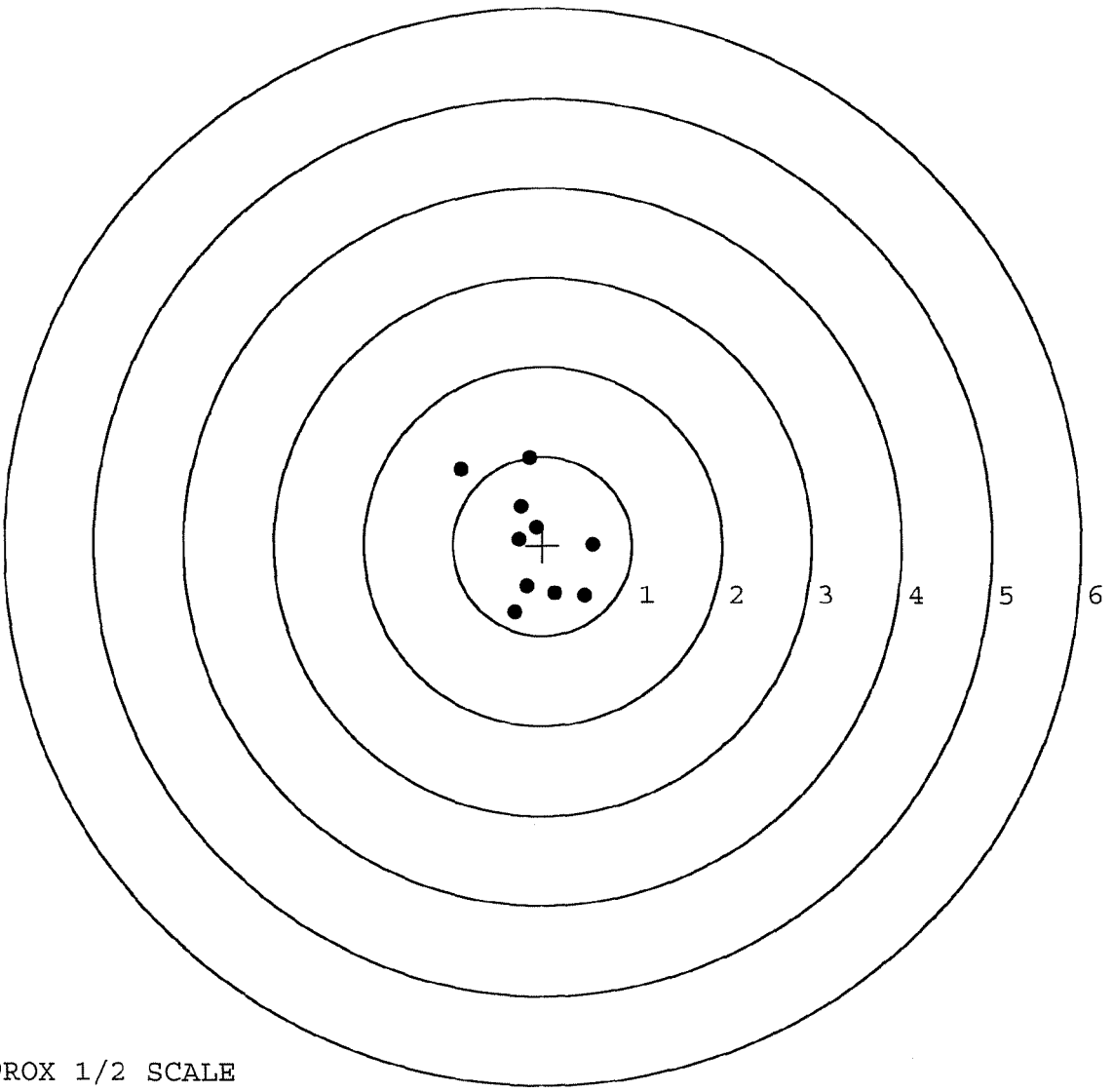


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6236245.__1
TARGET NUMBER: 5
FILE DATE: 01/05/2005
FILE TIME: 11:09

X CENTROID:	-0.095
Y CENTROID:	0.026
POA TO CENTROID:	0.099
HORZ SPREAD:	1.480
VERT SPREAD:	1.726
GROUP SPREAD:	1.990
MIN RADIUS:	0.171
MAX RADIUS:	1.167
MEAN RADIUS:	0.630
# IN 1 IN DIAMETER:	4
# IN 2 IN DIAMETER:	9
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	0.563	0.010
2:	0.478	-0.564
3:	0.141	-0.540
4:	-0.177	-0.456
5:	-0.310	-0.741
6:	-0.917	0.855
7:	-0.153	0.985
8:	-0.245	0.441
9:	-0.071	0.202
10:	-0.260	0.071



TARGET APPROX 1/2 SCALE

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

R & E NUMBER	89338		
SERIAL NUMBER	G62236245		
LOG-IN DATE	12-10-04		
INSPECT AND VERIFY:			
OPERATION #	OPERATION NAME	DATE	INITIAL
550	DIS-ASSEMBLE GUN	12-13-04	RTL
560 A	RE-BARREL	12-14-04	RTL
B	DRILL AND TAP	12-16-04	TRW
575	ASSEMBLE	12-15-04	RTL
600	PROOF	12-15-04	RTL
605	CHECK HEADSPACE	12-15-04	RTL
610	DIS-ASSEMBLE GUN	12-16-04	RTL
612	MAGNAFLUX		BS
615	ROLLMARK CALIBER	12-17-04	CW
618	ROTO-BLAST	12-27-04	LB
620	APPLY COATINGS	12/28/04	HP
625 A	FINAL ASSEMBLY	12-29-04	RTL
B	TRIGGER PULL TEST	N/A	
C	SAFETY "ON" FORCE		
D	SAFETY "OFF" FORCE		
E	FIRING PIN INDENT		
640	TARGET	1-5-05	TRW
655	FINAL INSPECT	1-5-05	AC
660	PACK	1-5-05	QA
		SHIP DATE	
	QAR INSPECTION DATE		

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: RE00073080

Verify Repair

Serial: C6349154 Model 700 Center Fire Caliber: 7 62 NATO M24 SWS

Repairman:

Status: Closed 11/17/2003 8:51:22 AM

Address Information

Customer:	Received From	Return To:	Received From
Name:	TRANSPORTATION DIV DFEL	TRANSPORTATION DIV DFEL	
Address 1:	WAREHOUSE BLDG 280	WAREHOUSE BLDG 280	
Address 2:	6701 TRANSPORTATION AVE PO Box:	6701 TRANSPORTATION AVE 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:

Fax:

Email:

Comments:

Received Condition

Fair

Condition Notes:

CSR Notes:

Accessories Received

Code	Desc	Qty
A007	With Studs	3
A017	F/R Scope Bases	2
A026	Scope / w/base	1

Repair Search | Refresh | Close

nagletj | 11/17/2003 | 9:01 AM | CAPS | NUM | INS | SCRL

Start | 2 Micros... | MyExercise | Arms Serv... | 6 Micros... | 4 Ms Progr... | Cal Tool | 9:01 AM

G6236245

Serial Number: ~~C6349154~~

Model: 700

RE00073080

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

R & E NUMBER	073080		
SERIAL NUMBER	C6349154 G6236245		
LOG-IN DATE	11-17-03		
INSPECT AND VERIFY:			
OPERATION #	OPERATION NAME	DATE	INITIAL
550	DIS-ASSEMBLE GUN	12-16-03	RW
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	12-18-03	AC
655	FINAL INSPECT	12-22-03	RTC
660	PACK	12/22/03	DA
		SHIP DATE	
	QAR INSPECTION DATE		

INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6236245

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		10/7/02	RL
600	PROOF		10/7/02	RL
607	CHECK HEADSPACE	MAGNA - FLUX	10/7/02	RL
610	DIS-ASSEMBLE GUN	INSPECTED	10/7/02	RL
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	OCT 8 2002 OPERATOR		
615	ROLLMARK CALIBER		10/9/02	RL
617	DRILL AND TAP SIGHT HOLES		10/9/02	TRW
620	APPLY COATINGS (BARREL ACTION)		10-17	TA
	(BOLT)		10-17	TA
625	FINAL ASSEMBLY A) CLEAN INSIDE OF BOLT ASSEMBLY		5-13-03	
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		5-13-03	
	C) INSPECT EJECTOR HOLE FOR CHAMFER		5-13-03	
	D) OIL FIRING PIN ASSEMBLY		5-13-03	
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS		5-13-03	

OP #	OPERATION NAME	READINGS	DATE	INITIAL
625	F) SAFETY ON FORCE [2 LBS MIN 10 LBS MAX]	5 5.0 5.0 5.0	7/8/03	DA
CONT.	G) SAFETY OFF FORCE [2 LBS MIN]	2.0 2.0 2.0	7/8/03	DA
	H) TRIGGER PULL TEST AND RETAINABILITY		7/8/03	[illegible]
	I) FIRING PIN INDENT [.020 MIN]	.021 .023 .0250	7/8/03	DA
	J) ASSEMBLE STOCK		5-14-03	RW
	K) ASSEMBLE SWIVEL STUDS		7-24-03	RTL
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		7-24-03	RTL
	M) IRON SIGHT ALIGNMENT		7-24-03	RTL
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		7-24-03	RTL
640	GALLERY TEST AND TARGET	PASS FAIL	5-29-03	[illegible]
	MALFUNCTION	CORRECTION	5-29-03	[illegible]
	MALFUNCTION	CORRECTION	5-29-03	[illegible]
	MALFUNCTION	CORRECTION	5-29-03	[illegible]
	MALFUNCTION	CORRECTION	5-29-03	[illegible]
645	INSPECT FOR LIVE AMMO		5-29-03	[illegible]
655	FINAL INSPECTION A) HEADSPACE		7/24/03	RW
	B) TRIGGER PULL [+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS]	2.64 2.72 2.89 2.90 2.89	7/8/03	DA
	C) FUNCTION		7/24/03	RW
660	PACK		8/7/03	DA

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

SERIAL NO.

DATE 5-5-03

TESTER TRW

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.68	2.48		2.28	MIN. SETTING,
PULL #2	2.60	2.38		2.32	NO AVG. OF 5
PULL #3	2.33	2.42		2.40	READINGS ACCEPT-
PULL #4	2.56	2.39		2.41	ABLE LESS THAN 2
PULL #5	2.50	2.35		2.12	
TOTAL	12.67	12.02		11.53	
AVG.	2.53	2.40		2.30	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.19	3.05		
PULL #2	3.26	3.45		
PULL #3	3.20	3.41		
PULL #4	3.18	3.33		
PULL #5	3.22	3.40		
TOTAL	16.05	16.60		
AVG.	3.21	3.32		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FO TARGET & ACCUR
PULL #1	4.32	4.06		4.22
PULL #2	4.25	4.37		4.08
PULL #3	4.26	4.41		4.07
PULL #4	4.18	4.40		4.10
PULL #5	4.26	4.20		3.94
TOTAL	21.27	21.44		20.41
AVG.	4.25	4.28		4.08

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFOMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6236245.__0
FILE DATE AND TIME: 05/29/2003 07:48

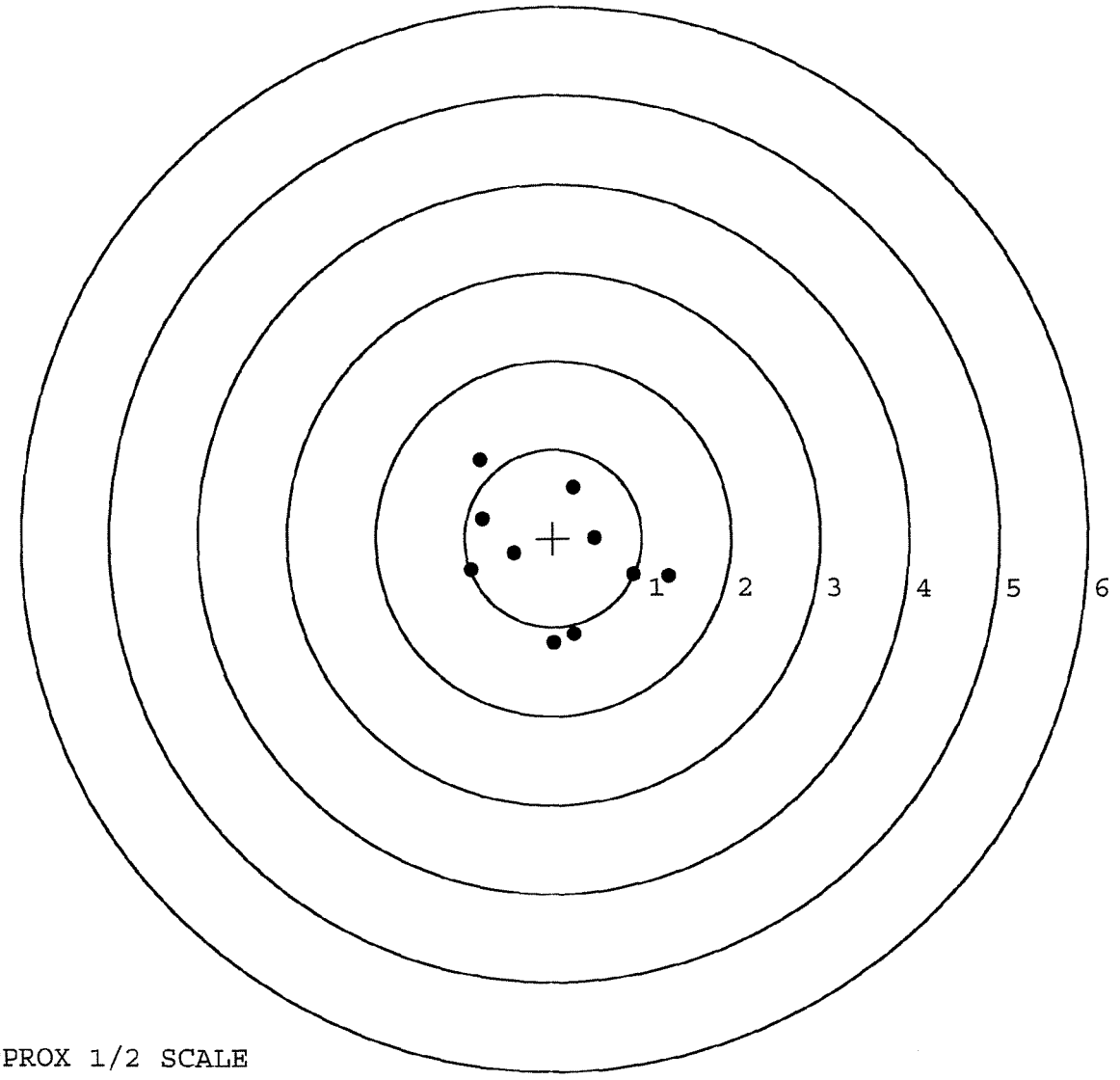
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.040
The Average Y Centroid of the Five Target Set:	-0.111
The Average Point of Impact of the Five Target Set:	0.118
The Average Mean Radius of the Five Target Set:	0.678
The Distance from POA to Centroid Target #1:	0.197
The Distance from Centroid Target #2 to Centroid Target #1:	0.160
The Distance from Centroid Target #3 to Centroid Target #1:	0.141
The Distance from Centroid Target #4 to Centroid Target #1:	0.117
The Distance from Centroid Target #5 to Centroid Target #1:	0.220

SERIAL NUMBER: G6236245.__0
TARGET NUMBER: 1
FILE DATE: 05/29/2003
FILE TIME: 07:48

X CENTROID:	0.018
Y CENTROID:	-0.196
POA TO CENTROID:	0.197
HORZ SPREAD:	2.226
VERT SPREAD:	2.058
GROUP SPREAD:	2.501
MIN RADIUS:	0.459
MAX RADIUS:	1.367
MEAN RADIUS:	0.912
# IN 1 IN DIAMETER:	2
# IN 2 IN DIAMETER:	8
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	1.305	-0.427
2:	0.910	-0.410
3:	0.467	0.003
4:	0.230	0.579
5:	0.242	-1.081
6:	0.021	-1.182
7:	-0.440	-0.175
8:	-0.802	0.223
9:	-0.921	-0.366
10:	-0.830	0.876

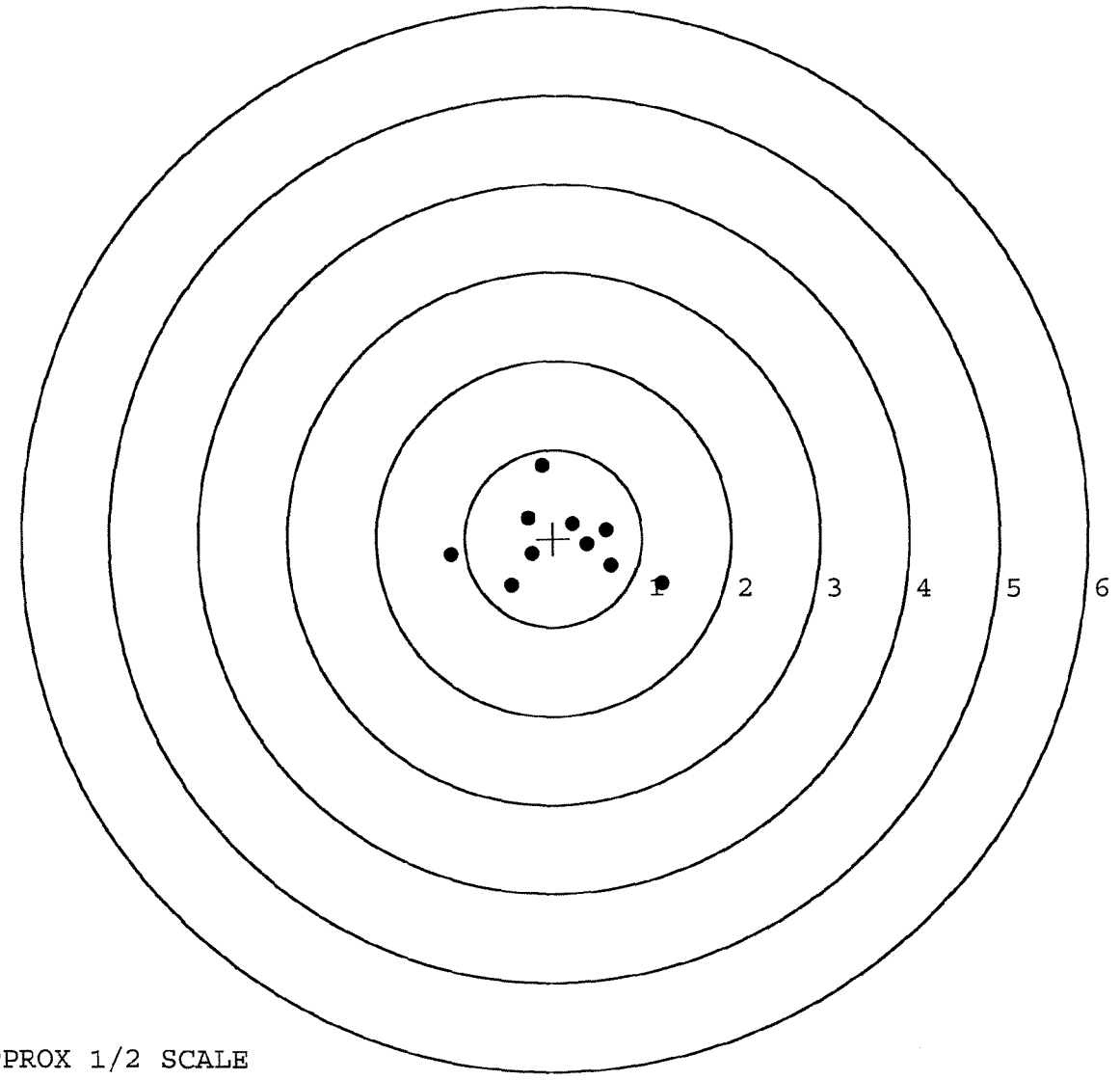


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6236245.__0
TARGET NUMBER: 2
FILE DATE: 05/29/2003
FILE TIME: 07:48

X CENTROID:	0.079
Y CENTROID:	-0.048
POA TO CENTROID:	0.093
HORZ SPREAD:	2.385
VERT SPREAD:	1.351
GROUP SPREAD:	2.406
MIN RADIUS:	0.255
MAX RADIUS:	1.241
MEAN RADIUS:	0.665
# IN 1 IN DIAMETER:	4
# IN 2 IN DIAMETER:	8
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	1.231	-0.508
2:	0.652	-0.309
3:	0.598	0.096
4:	0.385	-0.073
5:	0.223	0.162
6:	-0.243	-0.180
7:	-0.470	-0.532
8:	-1.154	-0.188
9:	-0.292	0.231
10:	-0.138	0.819

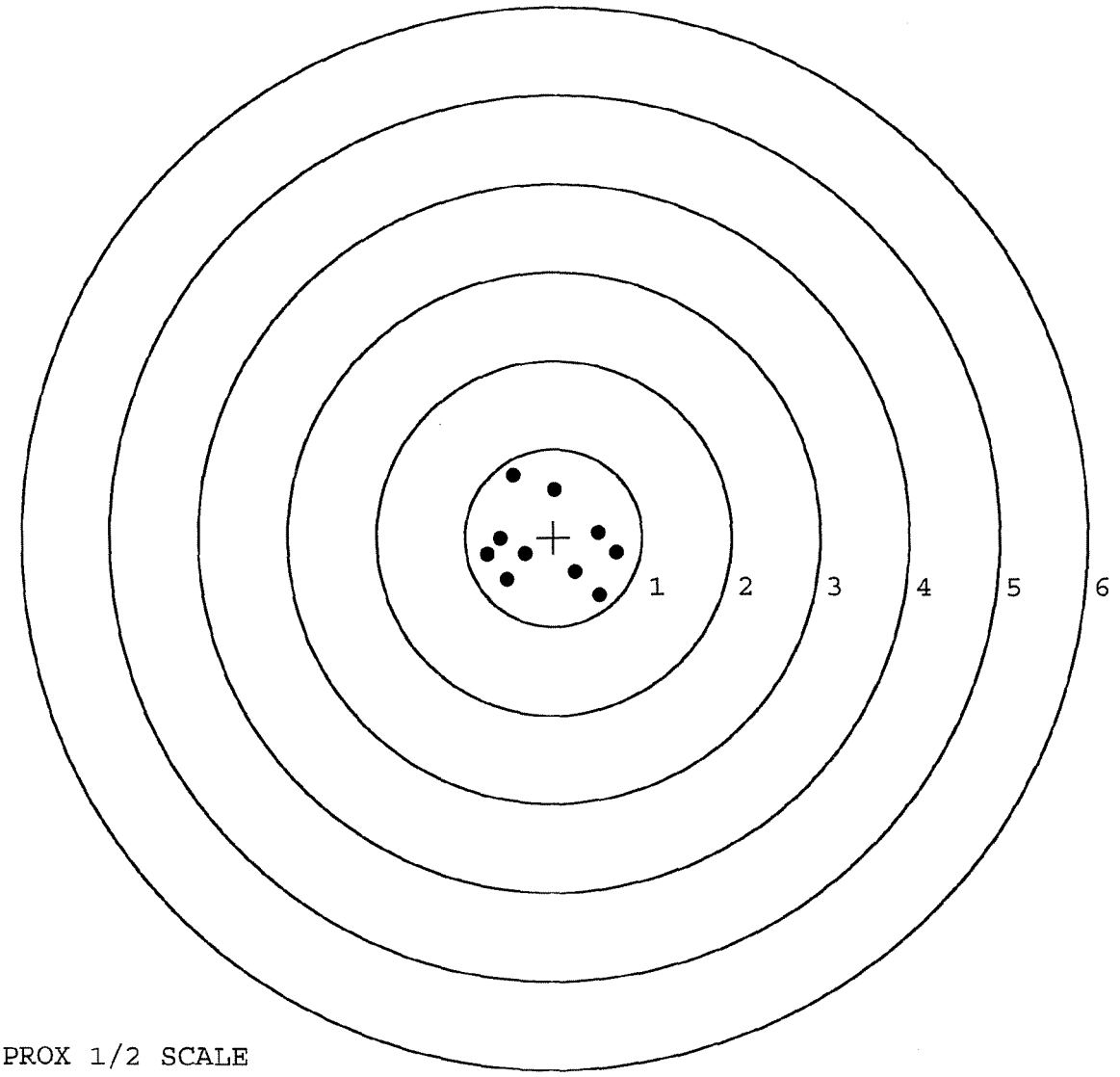


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6236245.__0
TARGET NUMBER: 3
FILE DATE: 05/29/2003
FILE TIME: 07:48

X CENTROID:	-0.065
Y CENTROID:	-0.082
POA TO CENTROID:	0.105
HORZ SPREAD:	1.466
VERT SPREAD:	1.345
GROUP SPREAD:	1.665
MIN RADIUS:	0.282
MAX RADIUS:	0.874
MEAN RADIUS:	0.626
# IN 1 IN DIAMETER:	2
# IN 2 IN DIAMETER:	10
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	0.521	-0.647
2:	0.253	-0.389
3:	0.713	-0.175
4:	0.510	0.047
5:	0.012	0.540
6:	-0.460	0.698
7:	-0.325	-0.193
8:	-0.605	-0.025
9:	-0.753	-0.196
10:	-0.520	-0.482

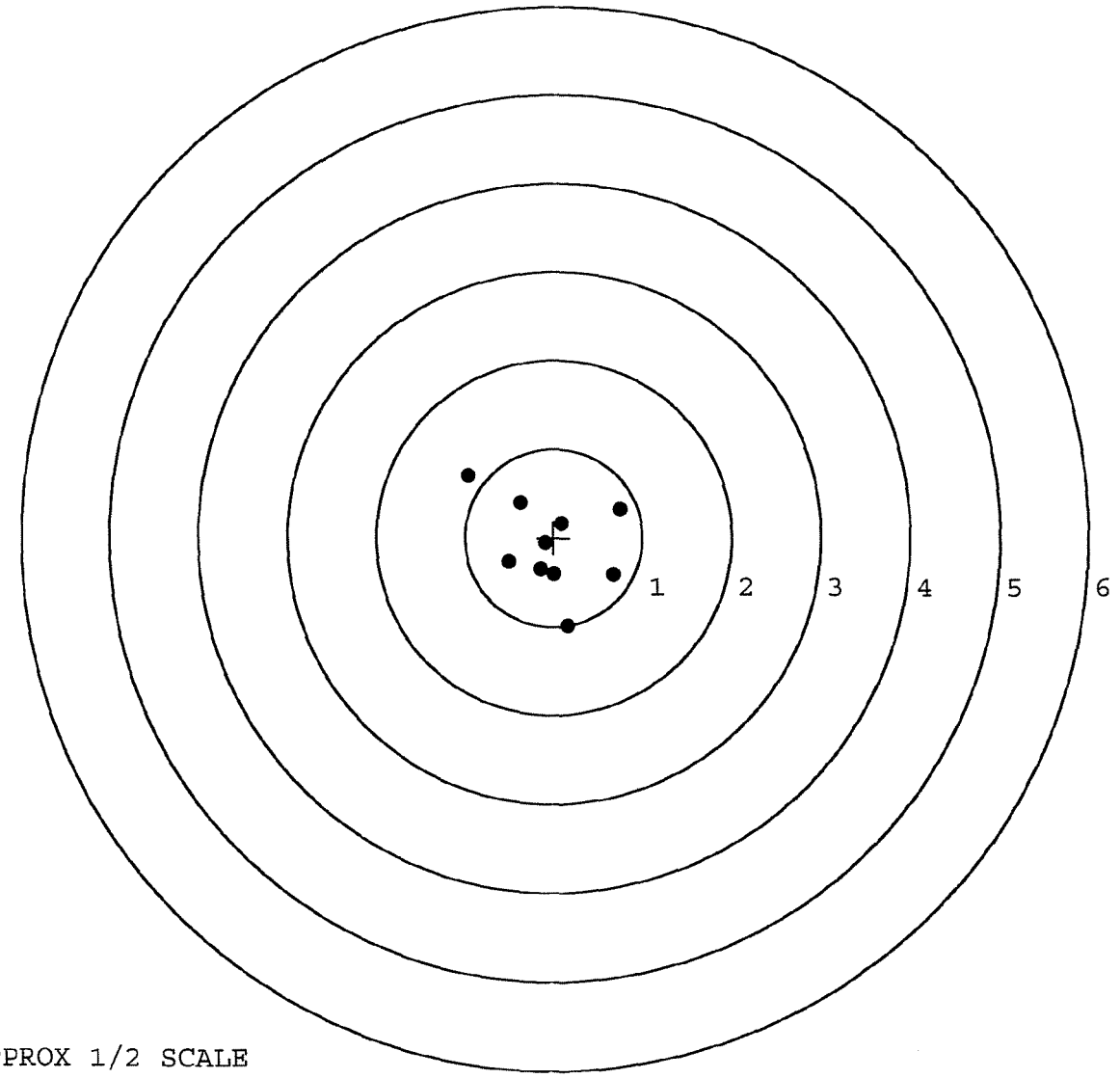


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6236245.__0
TARGET NUMBER: 4
FILE DATE: 05/29/2003
FILE TIME: 07:48

X CENTROID:	-0.040
Y CENTROID:	-0.095
POA TO CENTROID:	0.104
HORZ SPREAD:	1.716
VERT SPREAD:	1.694
GROUP SPREAD:	2.042
MIN RADIUS:	0.067
MAX RADIUS:	1.225
MEAN RADIUS:	0.586
# IN 1 IN DIAMETER:	5
# IN 2 IN DIAMETER:	9
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	0.675	-0.416
2:	0.168	-0.995
3:	0.743	0.320
4:	0.090	0.154
5:	-0.375	0.395
6:	-0.973	0.699
7:	-0.503	-0.279
8:	0.010	-0.410
9:	-0.099	-0.063
10:	-0.141	-0.358

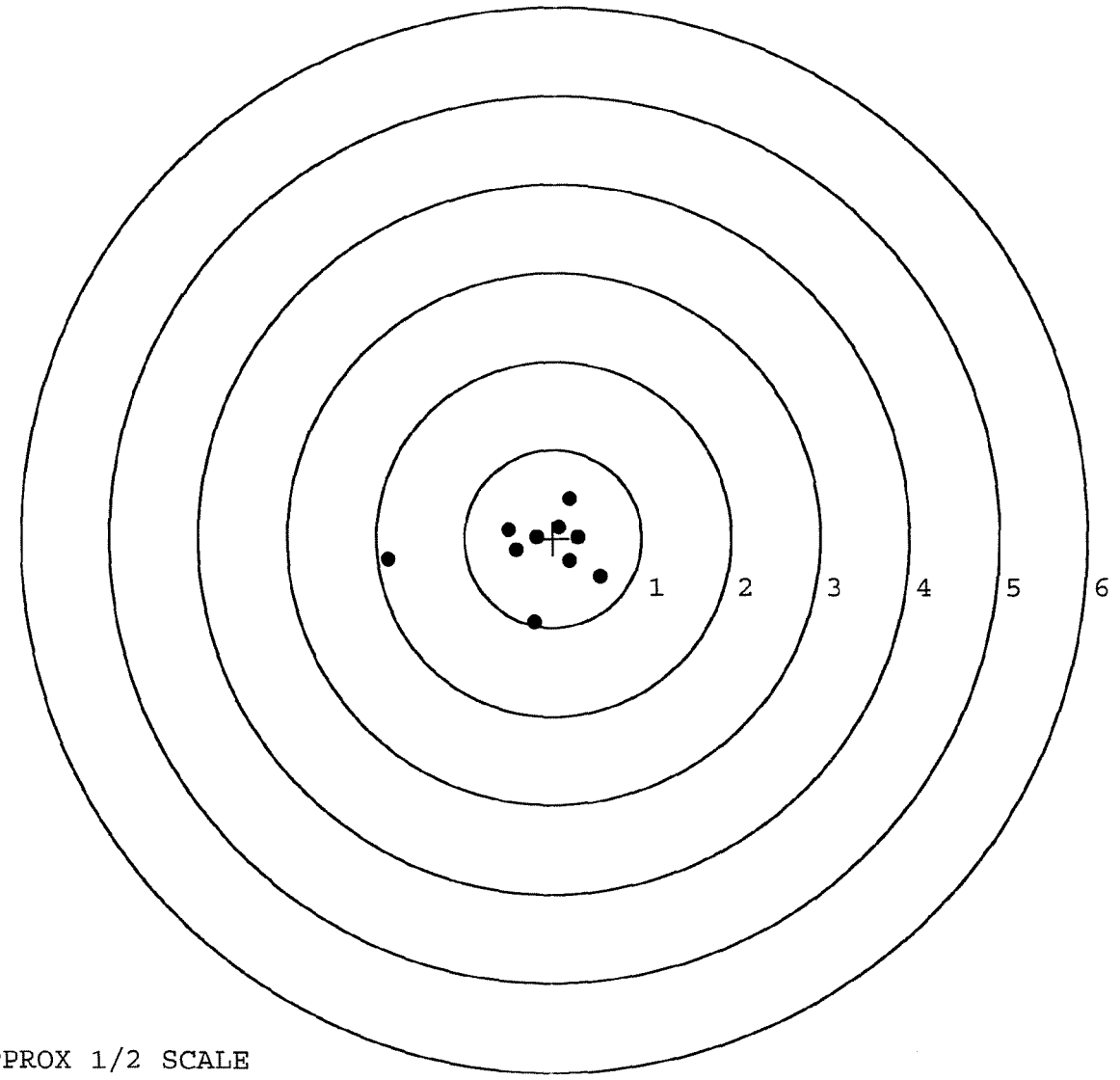


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6236245.__0
TARGET NUMBER: 5
FILE DATE: 05/29/2003
FILE TIME: 07:48

X CENTROID:	-0.193
Y CENTROID:	-0.132
POA TO CENTROID:	0.234
HORZ SPREAD:	2.403
VERT SPREAD:	1.393
GROUP SPREAD:	2.410
MIN RADIUS:	0.149
MAX RADIUS:	1.680
MEAN RADIUS:	0.600
# IN 1 IN DIAMETER:	6
# IN 2 IN DIAMETER:	9
# in 3 IN DIAMETER:	9

POINT#	X	Y
1:	-0.213	-0.950
2:	0.534	-0.430
3:	0.281	0.013
4:	0.189	0.443
5:	-1.869	-0.245
6:	-0.504	0.098
7:	-0.417	-0.135
8:	-0.187	0.016
9:	0.071	0.121
10:	0.189	-0.255



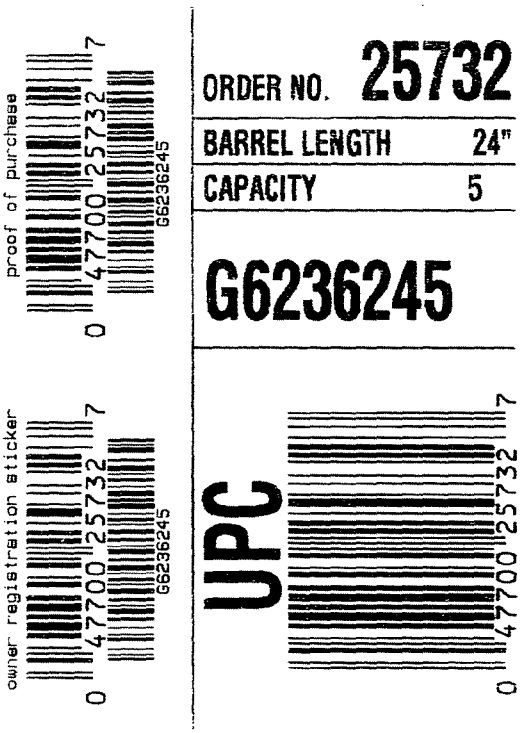
TARGET APPROX 1/2 SCALE

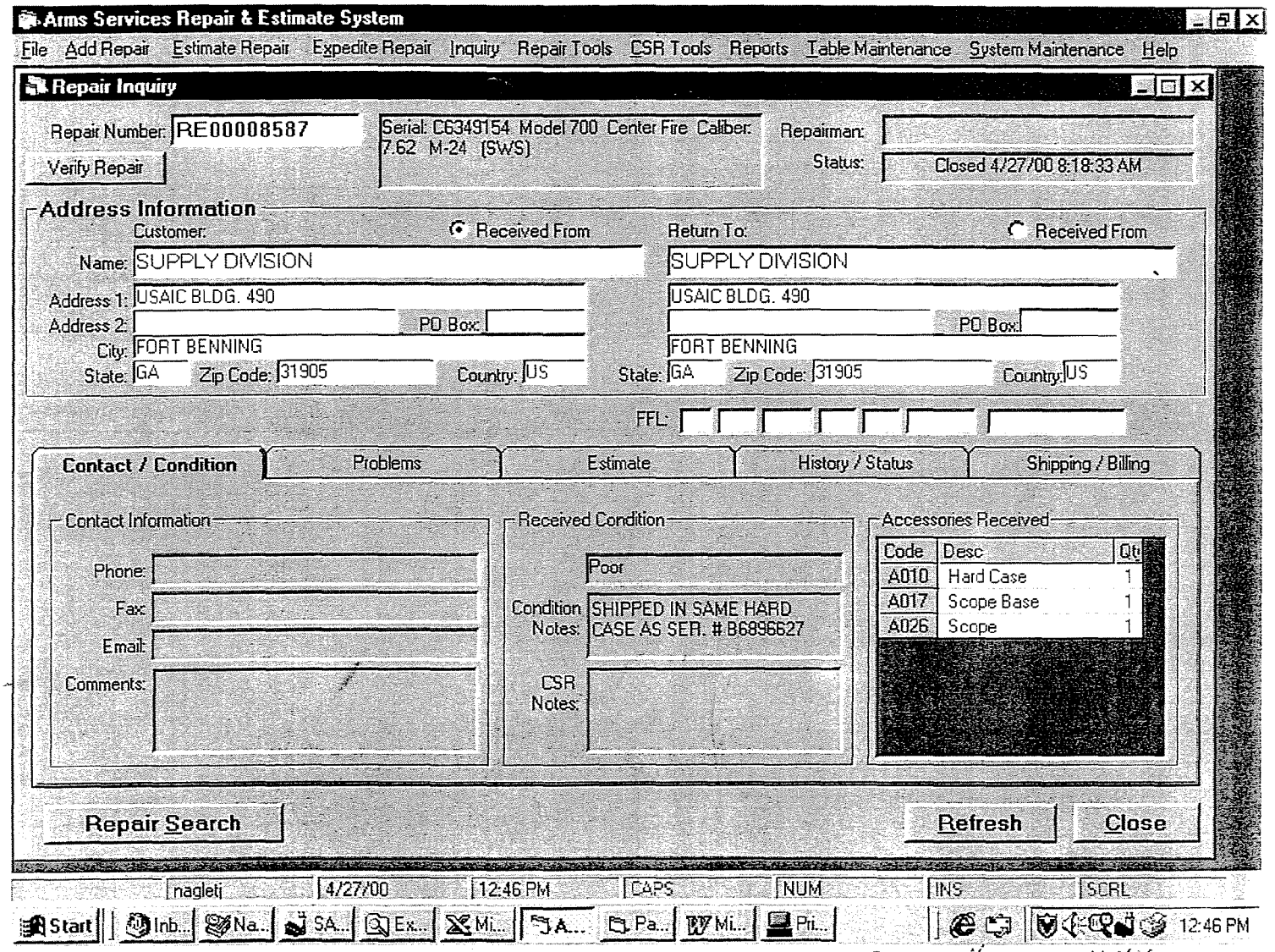

Remington®
VERY IMPORTANT. Instruction Book enclosed to assure safe use of this firearm.
M/24 7.62 NATO (RIFLE ONLY)
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO
46
SERIAL NO. J
G6236245
ORDER NO.
25732
Made in Ilion, NY Reg. U.S. Pat & tm. Off. Marca Registrada Marque Deposee.
5732 G6236245
11WX

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

– INSTUCTION BOOK 3518

46 FORM 200348





Scope # 87-1144

Serial Number: C6349154

Model: 700

RE00008587

96003 - BBL

96089 - Scope Ring Assy (2)

Remington Test Lab, Ilion, N.Y.

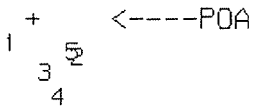
Centroidal distance calculations for Rifle # c6349154
22 Aug 2000

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1234
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.3076
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .331429

THE AMR FOR THIS RIFLE IS: 1.111

CENTROIDAL DISTANCES

0 TO 1 .235476
1 TO 2 .470287
1 TO 3 .307293
1 TO 4 .493223
1 TO 5 .430205

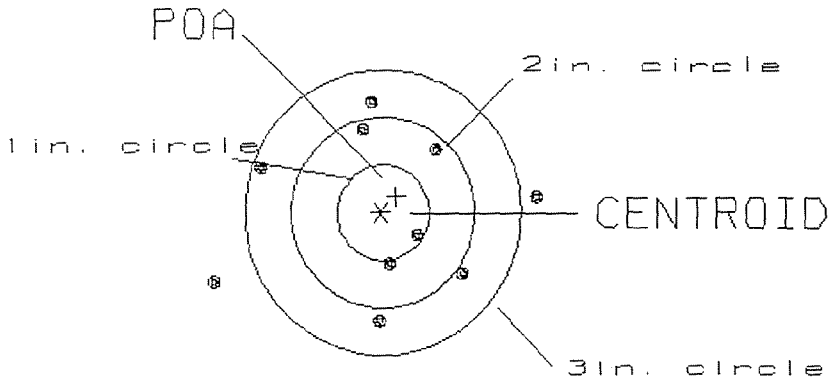


REMINGTON CENTERFIRE ACCURACY TEST REMINGTON TEST LAB, ILION, N.Y.

PATTERN #:	1
POA TO CENTROID:	.235
MIN RADIUS :	.412
MEAN RADIUS :	1.124
MAX RADIUS :	1.970
CENTROID X :	-.168
CENTROID Y :	-.165

22 Aug 2000 FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6349154.1

CENTERFIRE PATTERN # 1



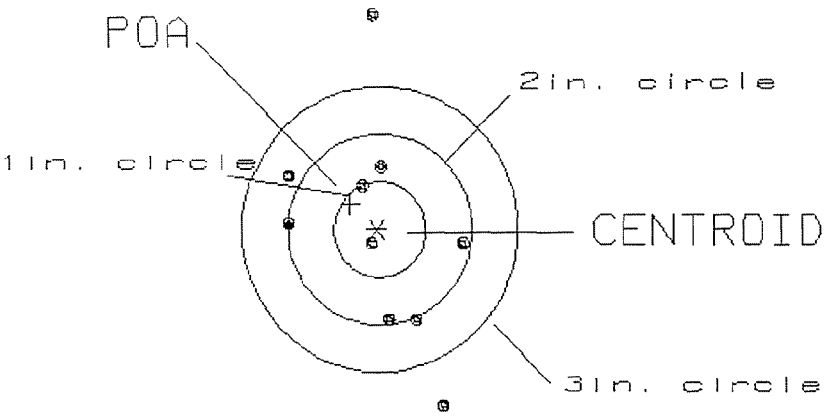
# OF SHOTS= 10	# IN CIRCLE
HS= 3.52	1
VS= 2.35	4
GS= 3.62	8

REMINGTON CENTERFIRE ACCURACY TEST REMINGTON TEST LAB, ILION, N.Y.

PATTERN #:		2
POA TO CENTROID:		.391
MIN RADIUS	:	.143
MEAN RADIUS	:	1.063
MAX RADIUS	:	2.251
CENTROID X	:	.293
CENTROID Y	:	-.258

22 Aug 2000 FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6349154.1

CENTERFIRE PATTERN # 2



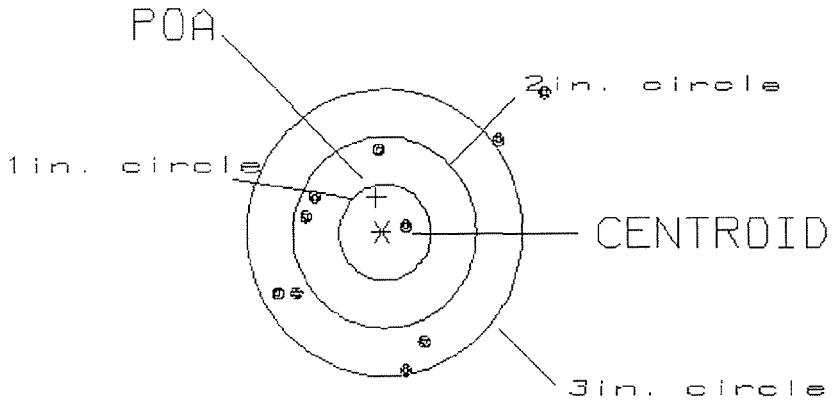
# OF SHOTS= 10	# IN CIRCLE
HS= 1.87	1
VS= 4.11	6
GS= 4.19	8

REMINGTON CENTERFIRE ACCURACY TEST REMINGTON TEST LAB, ILION, N.Y.

PATTERN #:		3
POA TO CENTROID:		.369
MIN RADIUS	:	.228
MEAN RADIUS	:	1.182
MAX RADIUS	:	2.250
CENTROID X	:	.067
CENTROID Y	:	-.363

22 Aug 2000 FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6349154.1

CENTERFIRE PATTERN # 3



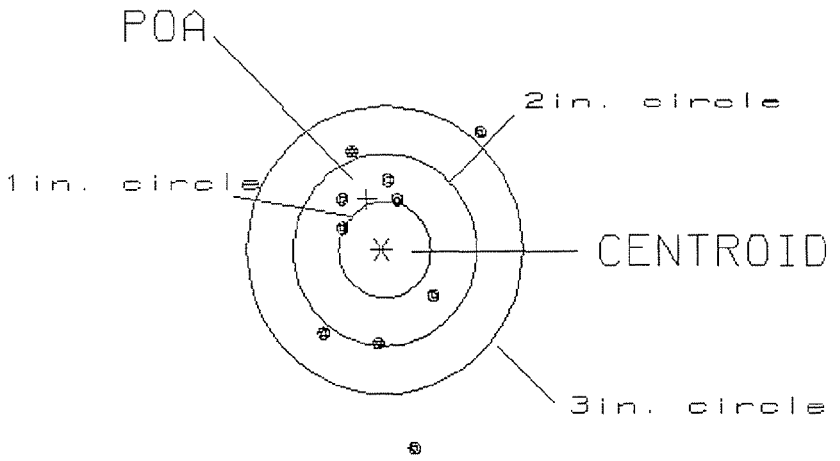
# OF SHOTS= 10	# IN CIRCLE
HS= 2.92	1
VS= 2.90	4
GS= 3.58	8

REMINGTON CENTERFIRE ACCURACY TEST REMINGTON TEST LAB, ILION, N.Y.

PATTERN #:		4
POA TO CENTROID:		.553
MIN RADIUS	:	.533
MEAN RADIUS	:	1.012
MAX RADIUS	:	2.092
CENTROID X	:	.167
CENTROID Y	:	-.527

22 Aug 2000 FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6349154.1

CENTERFIRE PATTERN # 4



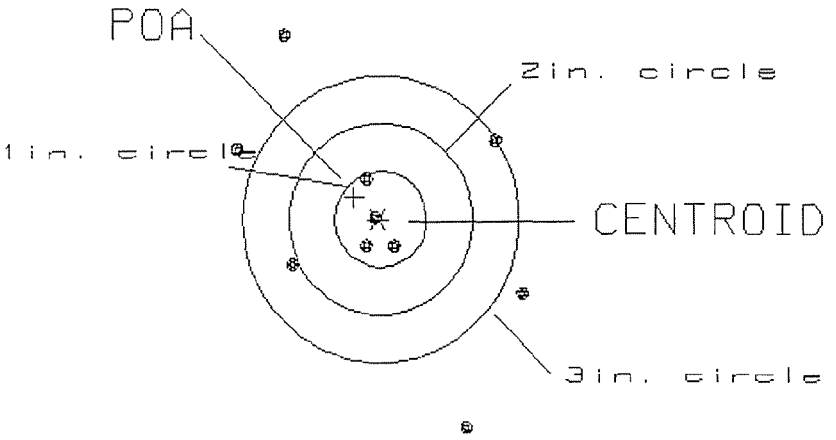
# OF SHOTS= 10	# IN CIRCLE
HS= 1.70	0
VS= 3.29	6
GS= 3.37	8

REMINGTON CENTERFIRE ACCURACY TEST REMINGTON TEST LAB, ILION, N.Y.

PATTERN #:		5
POA TO CENTROID:		.343
MIN RADIUS	:	.094
MEAN RADIUS	:	1.174
MAX RADIUS	:	2.315
CENTROID X	:	.258
CENTROID Y	:	-.225

22 Aug 2000 FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6349154.1

CENTERFIRE PATTERN # 5



# OF SHOTS= 10	# IN CIRCLE
HS= 3.13	4
VS= 4.07	4
GS= 4.50	5

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

R & E NUMBER	8587
SERIAL NUMBER	C6349154
LOG-IN DATE	4-24-00

INSPECT AND VERIFY:			
OPERATION #	OPERATION NAME	DATE	INITIAL
550	DIS-ASSEMBLE GUN	4-24-00	RW
560 A	RE-BARREL AT CUSTOM SHOP		
B	DRILL AND TAP		
C	POLISH		
575	ASSEMBLE		
600	PROOF	5-2-00	RW
605	CHECK HEADSPACE	5-2-00	RW
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	8-21-00	RW
655	FINAL INSPECT	8-22-00	RW
660	PACK		
		SHIP DATE	
	QAR INSPECTION DATE		

Final Inspection

S/N: C6349154 | DATE REC'D: 4-24-00 | 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-1350
- ___ 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: _____

SWS TRIGGER PULL TEST

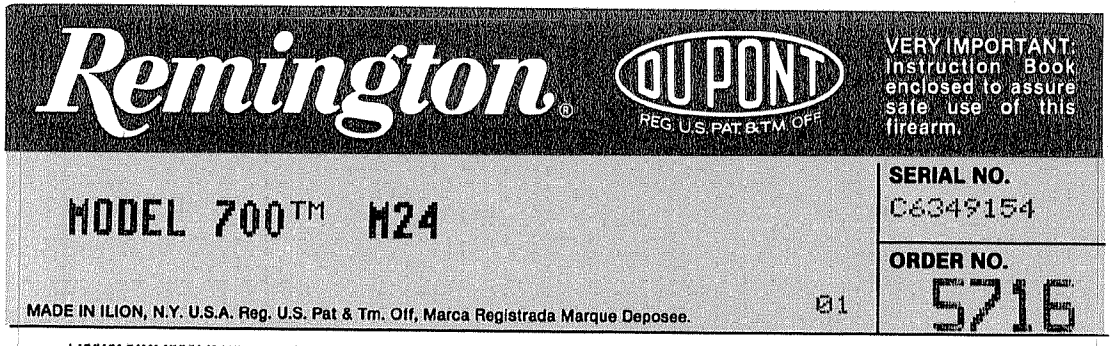
AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS
2.50# ± .50#
3.00# ± .75#
4.00# ± 1.00#

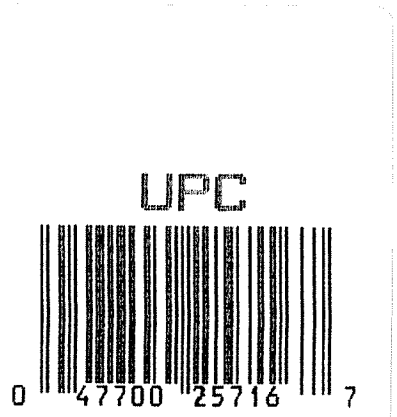
SERIAL NO. C634 9154
DATE 12 Mar 90
TESTER [illegible]

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	217	231		229	MIN. SETTING,
PULL #2	221	221		231	NO AVG. OF 5
PULL #3	218	227		233	READINGS ACCEPT-
PULL #4	221	232		233	ABLE LESS THAN 2#
PULL #5	214	226		220	
TOTAL	1091	1149			
AVG.	2.182	2.298			

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.13	3.17		
PULL #2	3.09	3.15		
PULL #3	311	3.11		
PULL #4	306	3.12		
PULL #5	313	3.11		
TOTAL	1552	1559		
AVG.	3.104	3.118		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	437	419		
PULL #2	425	419		
PULL #3	426	414		
PULL #4	405	409		
PULL #5	419	395		
TOTAL	2112	2056		
AVG.	4.224	4112		





Scope 0552

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6349154

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	9 26	89	RW
600	Proof	9 26	89	RW
607	Check Headspace	9 26	89	RW
610	Dis-assemble Gun	9 [illegible]	[illegible]	RW
612	Magnaflux Barrel Action	REJECTED	9/29/89	KCR
	Magnaflux Bolt		9/29/89	KCR
615	Rollmark Caliber			
7	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			
	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			
	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			
	A) Time			
	B) Malfunctions			
	C) Pierced Primers			
	D) Optical Clearity of Scope			
645	Inspect for Live Ammo			
655	Final Inspection A) Headspace			
	B) Trigger Pull			
	C) Function			
660	Pack			

Scope 0512

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6349154

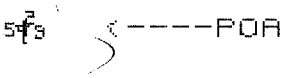
OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		10-9 89	RW
600	Proof		10-9 89	[illegible]
607	Check Headspace		10-9 89	RW
610	Dis-assemble Gun		10-[illegible] 89	RW
612	Magnaflux Barrel Action		11/7/89	KCR
	Magnaflux Bolt		11/7/89	KCR
615	Rollmark Caliber		11/7/89	G.S.
7	Drill and Tap Sight Holes			
618	Polish Barrel			
620	Apply Coatings (Barrel Action)		11-3-89	TJA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		11-7-89	[illegible]
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		11-7-89	[illegible]
	C) Inspect Ejector Hole for Chamfer		11-7-89	[illegible]
	D) Oil Firing Pin Ass'y		11-7-89	[illegible]
	E) Adjust Trigger Pull to Min Setting and Stake		10/26/89	[illegible]

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			10/26/89	JSS
	G) Safety Off Force	3	3	3			10/26/89	JSS
	H) Trigger Pull Test & Retainability						10/26/89	JSS
	I) Firing Pin Indent	.021	.021	.022			10/26/89	JSS
	J) Assemble Stock						11-16-89	AC
	K) Assemble Swivel Studs						28/10/89	JSS
	L) Attach Front and Rear Sight Assemblies						11-16-89	AC
	M) Iron Sight Alignment						11-16-89	AC
	N) Detach Front & Rear Sights & place in numbered container						11-16-89	AC
	O) Attach Scope to Rifle						16/11/89	JSS
	P) Detach & Attach Scope 20 Times						16/11/89	JSS
640	Gallery Target & Test						11-27-89	DH
	A) Time						11-27-89	DH
	B) Malfunctions						11-27-89	DH
	C) Pierced Primers						11-27-89	DH
	D) Optical Clearity of Scope						11-27-89	DH
645	Inspect for Live Ammo						11-27-89	DH
655	Final Inspection A) Headspace						28/11/89	JSS
	B) Trigger Pull	235	231	239	234	237	28/11/89	JSS
	C) Function						28/11/89	JSS
660	Pack						15/12/89	JSS

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6349154
27 Nov 1989

CENTROIDAL DISTANCES

Ø	TO	1	.149482
1	TO	2	.363Ø34
1	TO	3	.29274
1	TO	4	.122332
1	TO	5	.261276

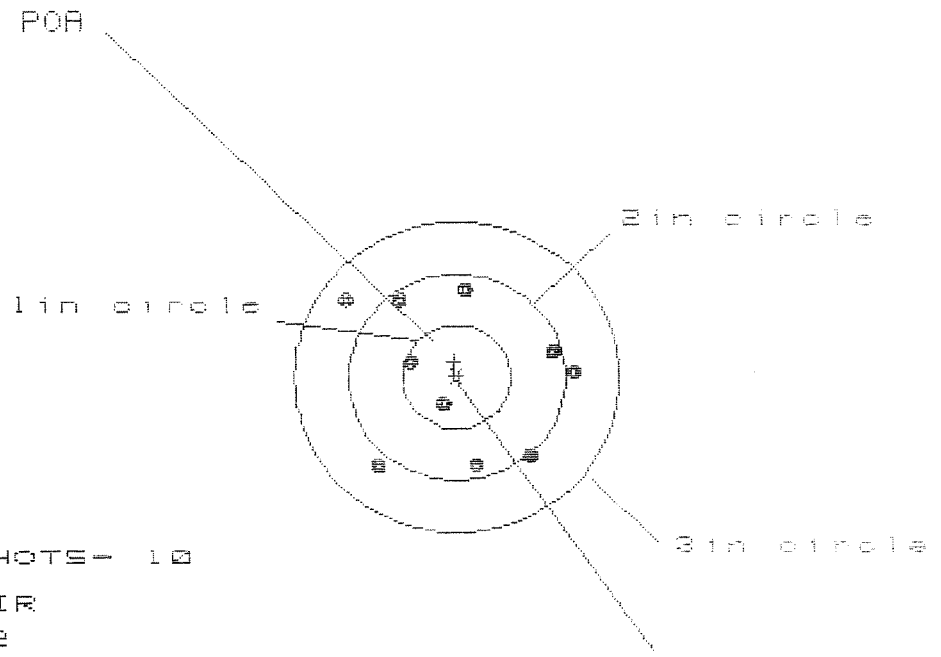


THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .05
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0212
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0543087

THE AMR FOR THIS RIFLE IS: .9894

27 Nov 1989 FILE:/PATTERNING/CENTERFIRE_PATT/C6348134

CENTERFIRE PATTERNS # 1

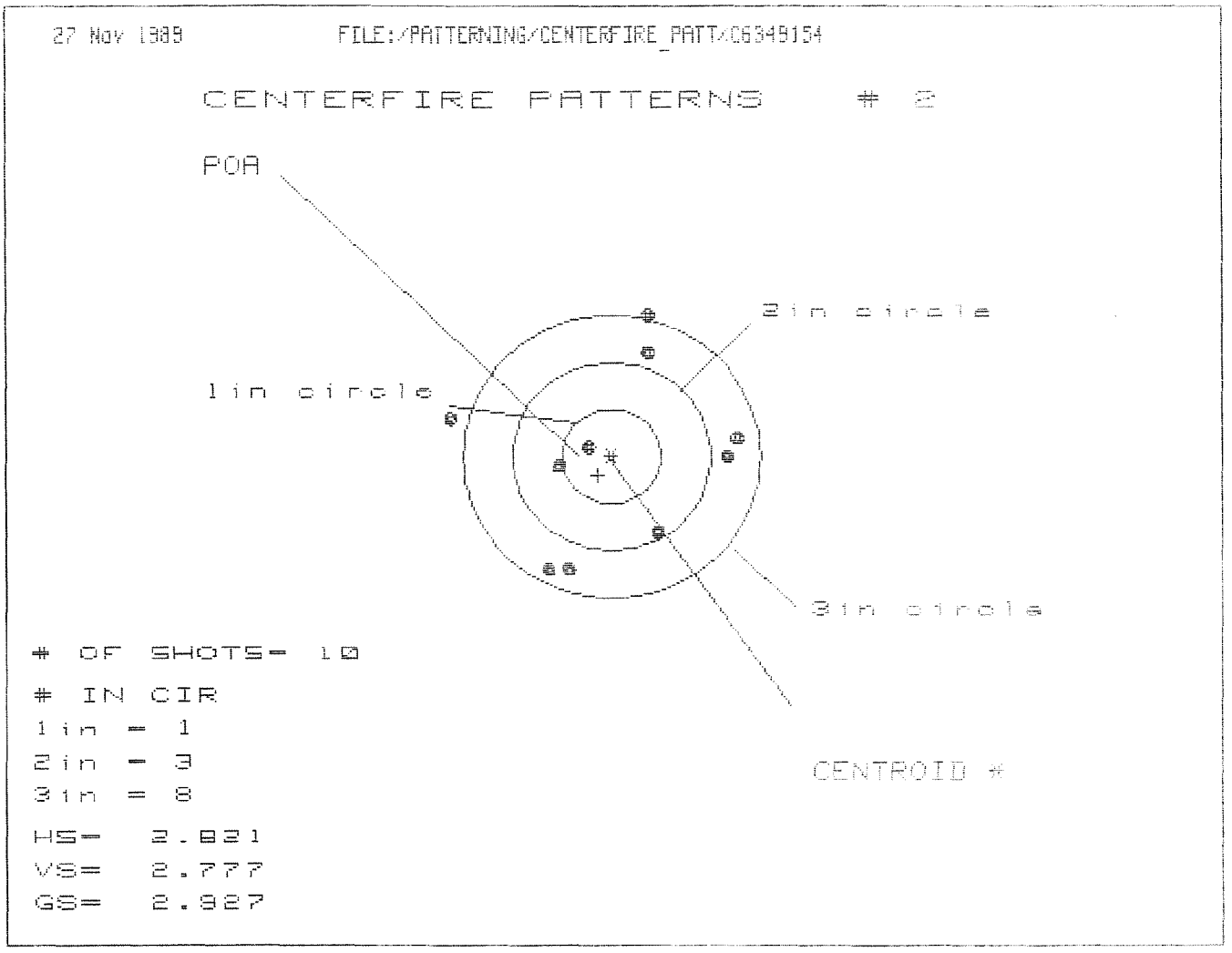


OF SHOTS= 10

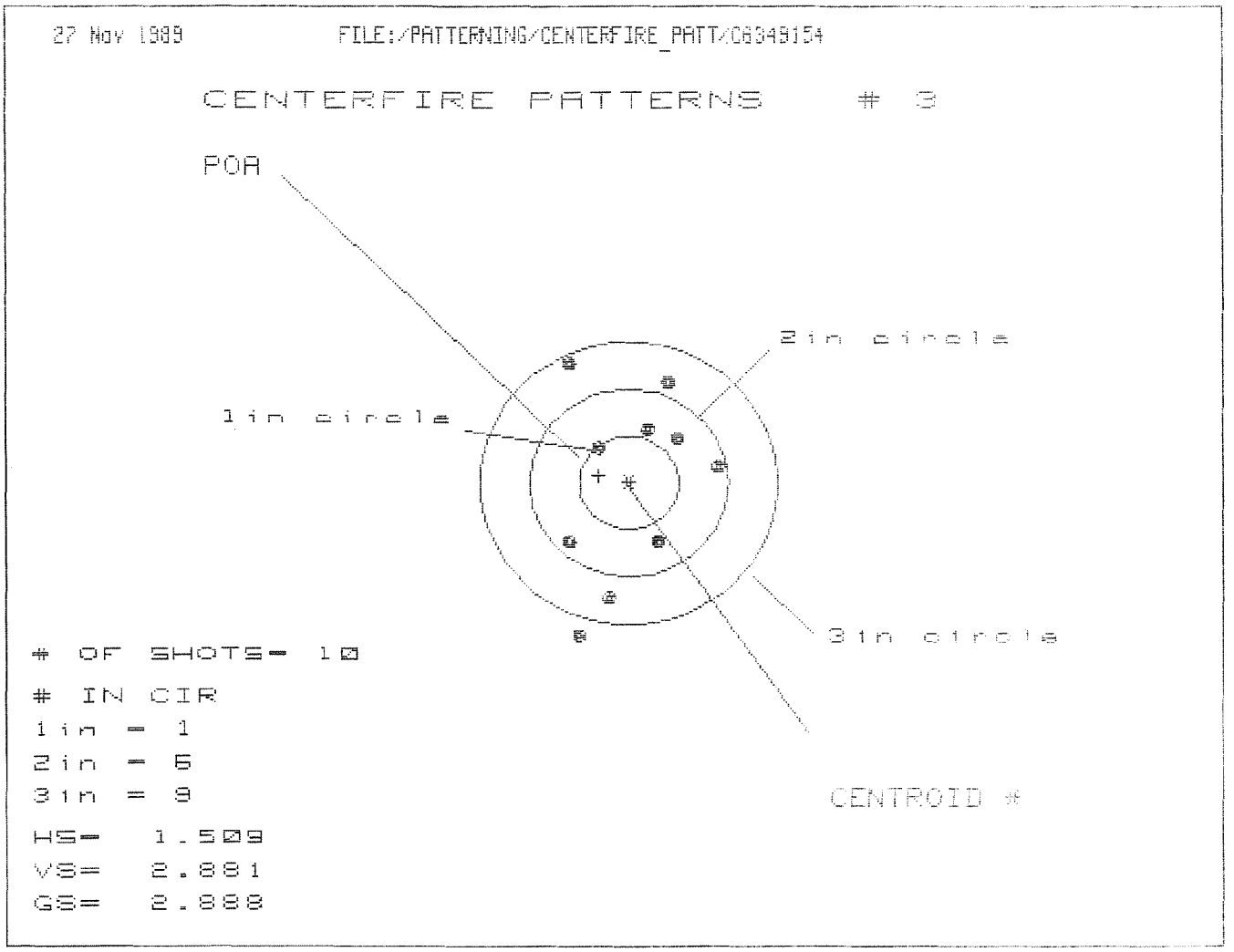
# IN CIR
1in = 2
2in = 6
3in = 10

HS= 2.088
VS= 1.675
GS= 2.314

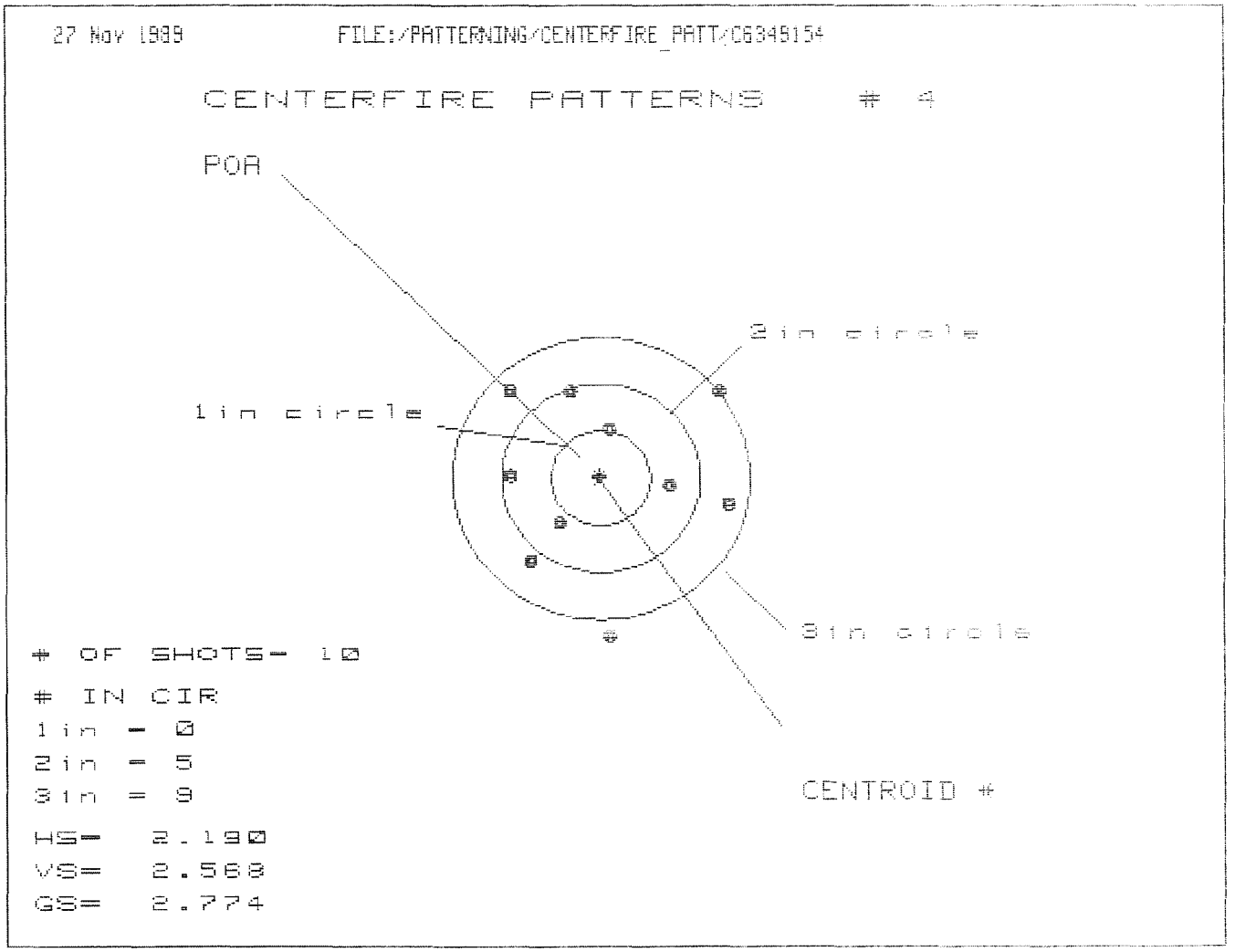
PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.054	.939	.832
MINIMUM X	:	-1.034	-.855	-.731
MAXIMUM Y	:	.851	.930	.840
MINIMUM Y	:	-.824	-.745	-.835
CENTROID X	:	.021	.136	.243
CENTROID Y	:	-.148	-.227	-.137
POA TO CENTROID in.	:	.150	.265	.279
MIN RADIUS	:	.287	.290	.430
MEAN RADIUS	:	.865	.818	.781
MAX RADIUS	:	1.254	1.120	1.030
HORIZONTAL SPREAD	:	2.088	1.794	1.563
VERTICAL SPREAD	:	1.675	1.675	1.675
EXTREME SPREAD	:	2.314	1.967	1.967
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	



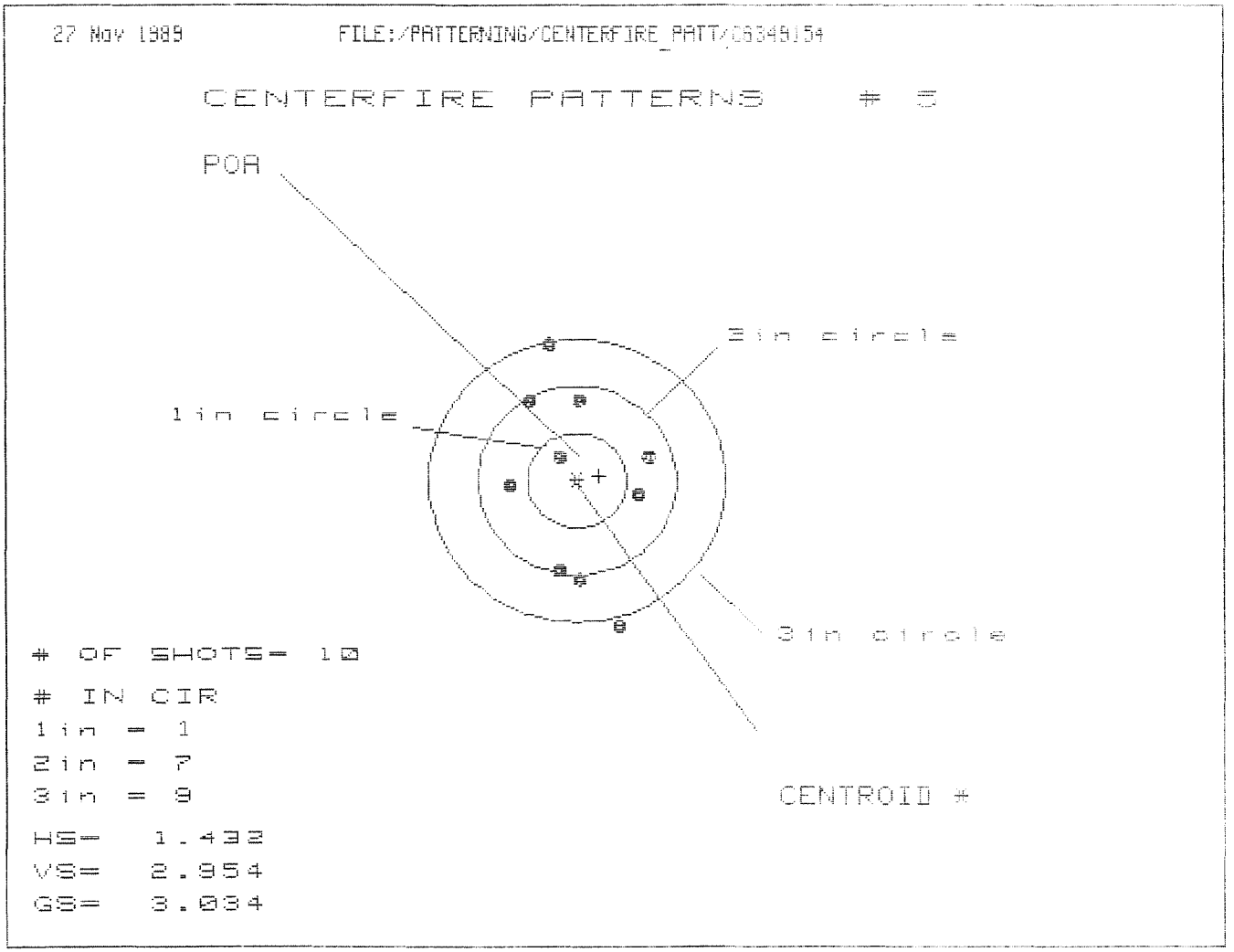
PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.233	1.057	1.077
MINIMUM X	:	-1.588	-.801	-.781
MAXIMUM Y	:	1.531	1.577	1.360
MINIMUM Y	:	-1.246	-1.200	-1.003
CENTROID X	:	.134	.310	.290
CENTROID Y	:	.197	.151	-.046
POA TO CENTROID in.	:	.238	.345	.294
MIN RADIUS	:	.292	.471	.561
MEAN RADIUS	:	1.128	1.071	.991
MAX RADIUS	:	1.640	1.585	1.370
HORIZONTAL SPREAD	:	2.821	1.858	1.858
VERTICAL SPREAD	:	2.777	2.777	2.368
EXTREME SPREAD	:	2.927	2.927	2.536
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		8	



PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.856	.805	.717
MINIMUM X	:	-.653	-.704	-.768
MAXIMUM Y	:	1.301	1.125	1.084
MINIMUM Y	:	-1.580	-1.378	-1.237
CENTROID X	:	.305	.356	.444
CENTROID Y	:	-.077	.099	-.042
POA TO CENTROID in.	:	.315	.370	.446
MIN RADIUS	:	.474	.383	.539
MEAN RADIUS	:	.980	.872	.819
MAX RADIUS	:	1.645	1.397	1.278
HORIZONTAL SPREAD	:	1.509	1.509	1.485
VERTICAL SPREAD	:	2.881	2.503	2.321
EXTREME SPREAD	:	2.888	2.547	2.393
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	



PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.244	1.251	1.401
MINIMUM X	:	-.946	-.939	-.789
MAXIMUM Y	:	.917	.733	.821
MINIMUM Y	:	-1.651	-1.046	-.958
CENTROID X	:	.012	.005	-.145
CENTROID Y	:	-.026	.158	.070
POA TO CENTROID in.	:	.028	.158	.161
MIN RADIUS	:	.563	.382	.509
MEAN RADIUS	:	1.052	.966	.901
MAX RADIUS	:	1.652	1.386	1.447
HORIZONTAL SPREAD	:	2.190	2.190	2.190
VERTICAL SPREAD	:	2.568	1.779	1.779
EXTREME SPREAD	:	2.774	2.558	2.444
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	



PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.714	.764	.740
MINIMUM X	:	-.718	-.668	-.692
MAXIMUM Y	:	1.436	1.267	.855
MINIMUM Y	:	-1.518	-1.227	-1.669
CENTROID X	:	-.222	-.272	-.248
CENTROID Y	:	-.052	.117	-.042
POA TO CENTROID in.	:	.228	.296	.252
MIN RADIUS	:	.301	.140	.278
MEAN RADIUS	:	.922	.821	.771
MAX RADIUS	:	1.584	1.281	1.069
HORIZONTAL SPREAD	:	1.432	1.432	1.432
VERTICAL SPREAD	:	2.954	2.494	1.924
EXTREME SPREAD	:	3.034	2.504	1.960
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	