

G 664 5310
Refused
G 635 1094

Repair Inquiry

Repair Number: RE00130078

Serial: G6391094 Model M24 SWS Center Fire
Caliber: 7.62 NATO

Repairman:

Status:

New 6/6/2007 7:20:36 AM

Verify Repair

Address Information

Customer:

Received From

Return To:

Received From

Name: DEPARTMENT OF THE ARMY SUPPLY OFFICER

DEPARTMENT OF THE ARMY SUPPLY OFFICER

Address 1: DOL SISA BLDG 9660 BAY A

DOL SISA BLDG 9660 BAY A

Address 2: BOX 339500 MS 181

PO Box:

BOX 339500 MS 181

PO Box:

City: FORT LEWIS

FORT LEWIS

State: WA

Zip Code: 98433

Country: US

State: WA

Zip Code: 98433

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
A017	Scope Base	1
D000	FRONT BASE	1

Repair Search

Refresh

Close

nagletj

6/6/2007

8:10 AM

CAPS

NUM

INS

SCRL

start

4 Mi...

4 In...

Arms ...

Part ...

2 Mi...

2 S...

8:10 AM

Serial Number: ~~G6391094~~

Model: M24 SWS



RE00130078

"NEW" G6645310

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6645310.___0
FILE DATE AND TIME: 07/20/2007 23:03

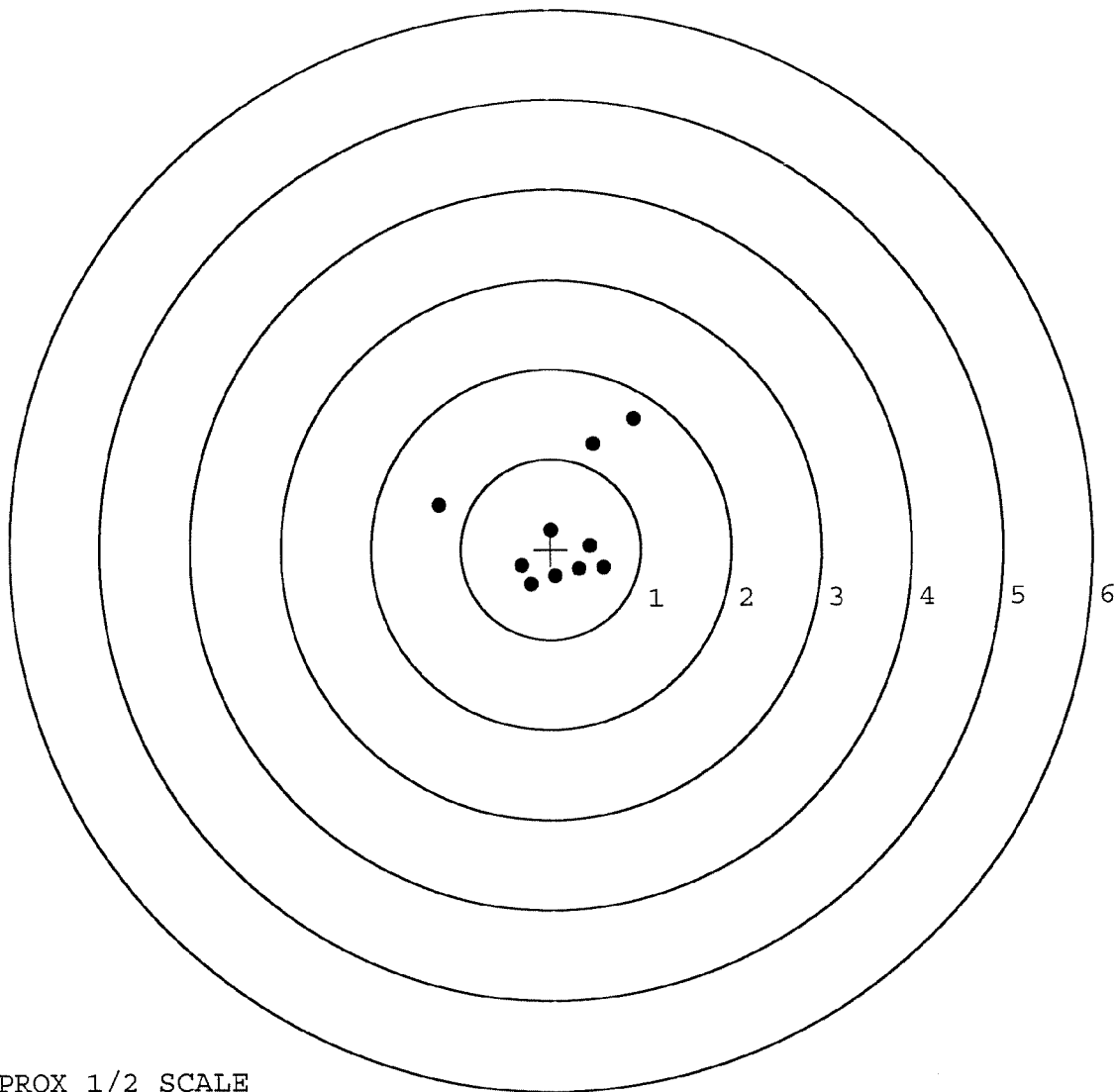
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.060
The Average Y Centroid of the Five Target Set:	0.042
The Average Point of Impact of the Five Target Set:	0.074
The Average Mean Radius of the Five Target Set:	0.713
The Distance from POA to Centroid Target #1:	0.226
The Distance from Centroid Target #2 to Centroid Target #1:	0.445
The Distance from Centroid Target #3 to Centroid Target #1:	0.237
The Distance from Centroid Target #4 to Centroid Target #1:	0.349
The Distance from Centroid Target #5 to Centroid Target #1:	0.191

SERIAL NUMBER: G6645310. __0
TARGET NUMBER: 1
FILE DATE: 07/20/2007
FILE TIME: 23:03

X CENTROID: 0.101
Y CENTROID: 0.203
POA TO CENTROID: 0.226
HORZ SPREAD: 2.175
VERT SPREAD: 1.831
GROUP SPREAD: 2.369
MIN RADIUS: 0.107
MAX RADIUS: 1.487
MEAN RADIUS: 0.726
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.486	1.163
2:	0.932	1.436
3:	-0.006	0.211
4:	0.438	0.034
5:	0.588	-0.210
6:	0.317	-0.222
7:	0.049	-0.306
8:	-0.226	-0.395
9:	-0.325	-0.180
10:	-1.243	0.496



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6645310. __0

TARGET NUMBER: 2

FILE DATE: 07/20/2007

FILE TIME: 23:03

POINT#	X	Y
1:	0.268	0.525
2:	0.109	0.421
3:	-0.250	0.257
4:	0.114	-0.206
5:	0.457	-0.119
6:	1.461	0.821
7:	-0.356	-0.788
8:	-0.346	-0.208
9:	-0.878	-0.326
10:	-2.840	-1.371

X CENTROID: -0.226

Y CENTROID: -0.099

POA TO CENTROID: 0.247

HORZ SPREAD: 4.301

VERT SPREAD: 2.192

GROUP SPREAD: 4.827

MIN RADIUS: 0.162

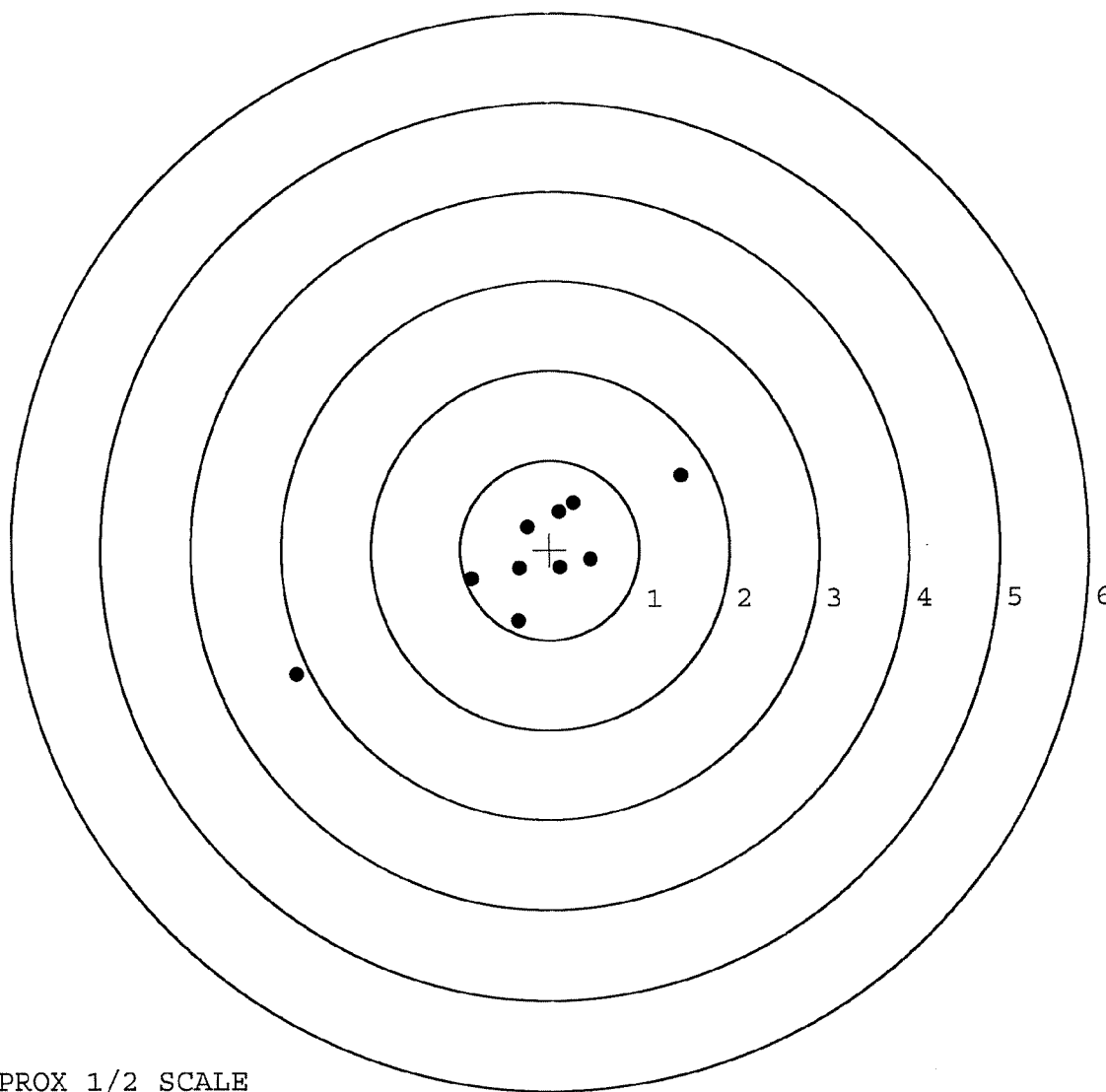
MAX RADIUS: 2.907

MEAN RADIUS: 0.919

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 8

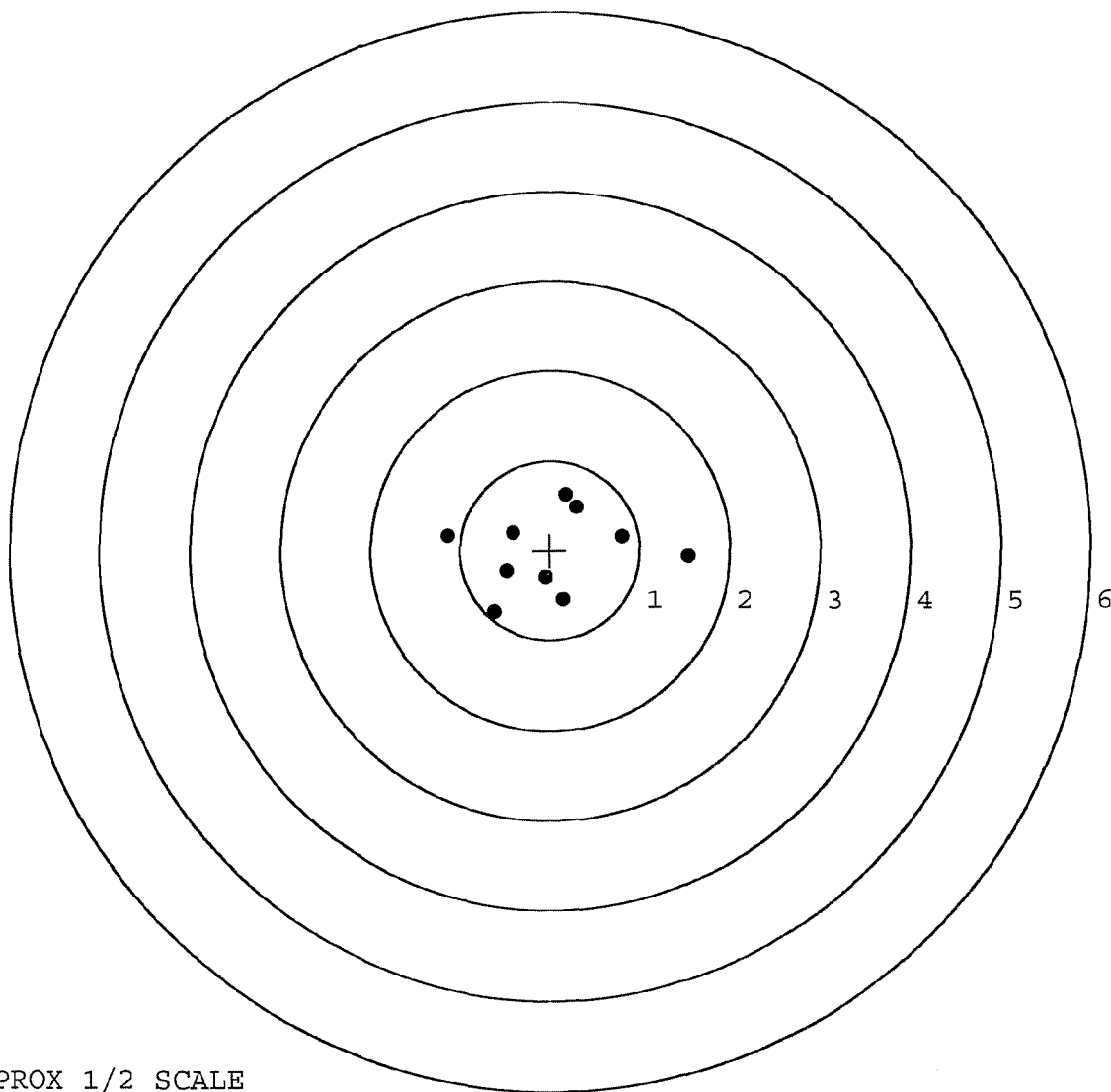


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6645310. __0
TARGET NUMBER: 3
FILE DATE: 07/20/2007
FILE TIME: 23:03

X CENTROID: 0.025
Y CENTROID: -0.022
POA TO CENTROID: 0.034
HORZ SPREAD: 2.690
VERT SPREAD: 1.310
GROUP SPREAD: 2.699
MIN RADIUS: 0.292
MAX RADIUS: 1.520
MEAN RADIUS: 0.755
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 9

POINT#	X	Y
1:	0.175	0.622
2:	0.295	0.485
3:	0.803	0.157
4:	1.545	-0.060
5:	0.148	-0.557
6:	-0.047	-0.305
7:	-0.480	-0.232
8:	-0.414	0.195
9:	-0.625	-0.688
10:	-1.145	0.164



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6645310. __0

TARGET NUMBER: 4

FILE DATE: 07/20/2007

FILE TIME: 23:03

POINT#	X	Y
1:	0.005	0.555
2:	1.360	0.184
3:	0.897	-0.728
4:	0.304	-0.481
5:	0.424	0.014
6:	-0.090	-0.317
7:	-0.439	0.148
8:	0.653	0.558
9:	0.406	0.420
10:	0.725	0.357

X CENTROID: 0.424

Y CENTROID: 0.071

POA TO CENTROID: 0.430

HORZ SPREAD: 1.799

VERT SPREAD: 1.286

GROUP SPREAD: 1.799

MIN RADIUS: 0.057

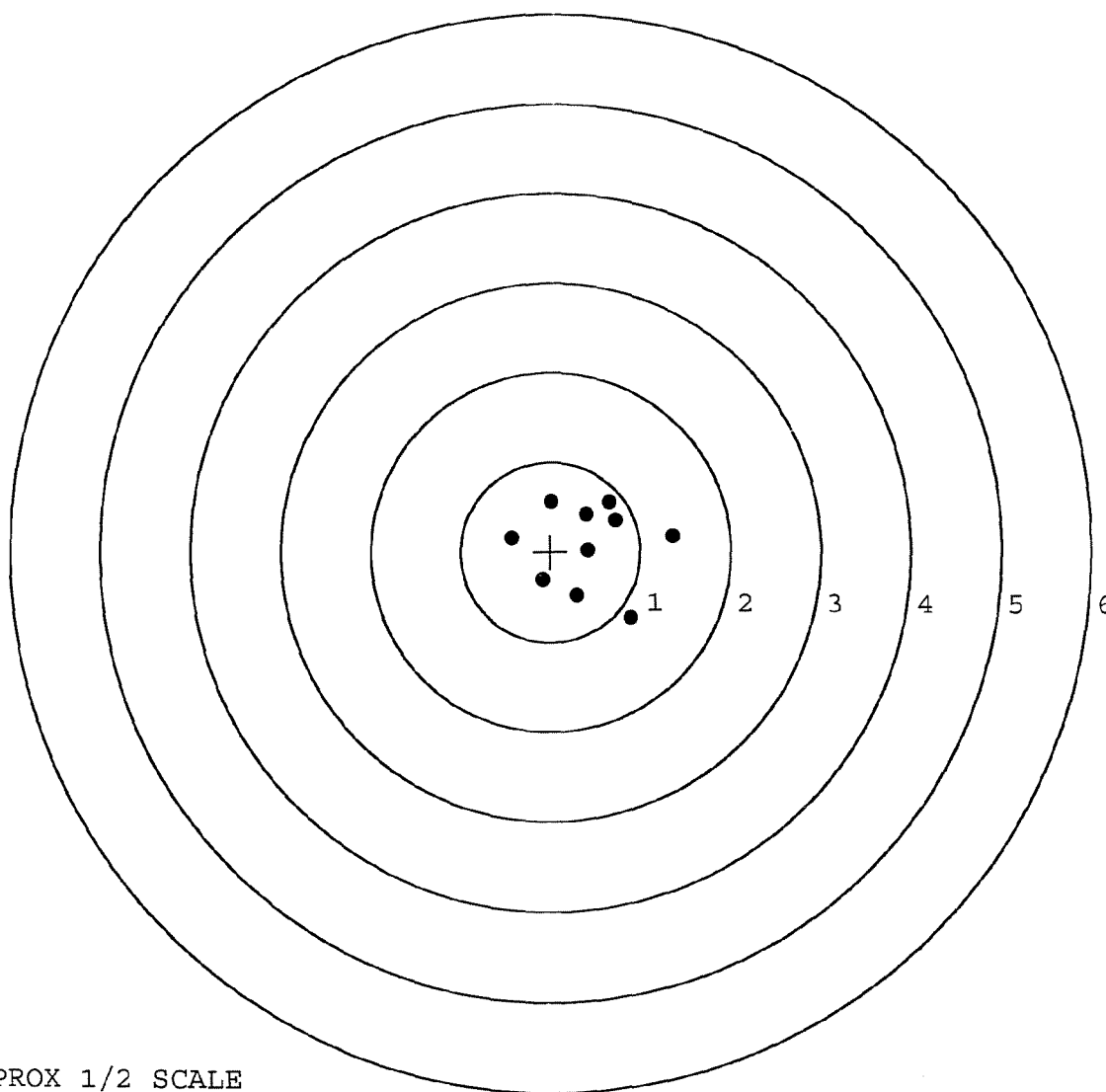
MAX RADIUS: 0.942

MEAN RADIUS: 0.595

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6645310. __0

TARGET NUMBER: 5

FILE DATE: 07/20/2007

FILE TIME: 23:03

X CENTROID: -0.023

Y CENTROID: 0.058

POA TO CENTROID: 0.062

HORZ SPREAD: 1.206

VERT SPREAD: 1.326

GROUP SPREAD: 1.323

MIN RADIUS: 0.262

MAX RADIUS: 0.835

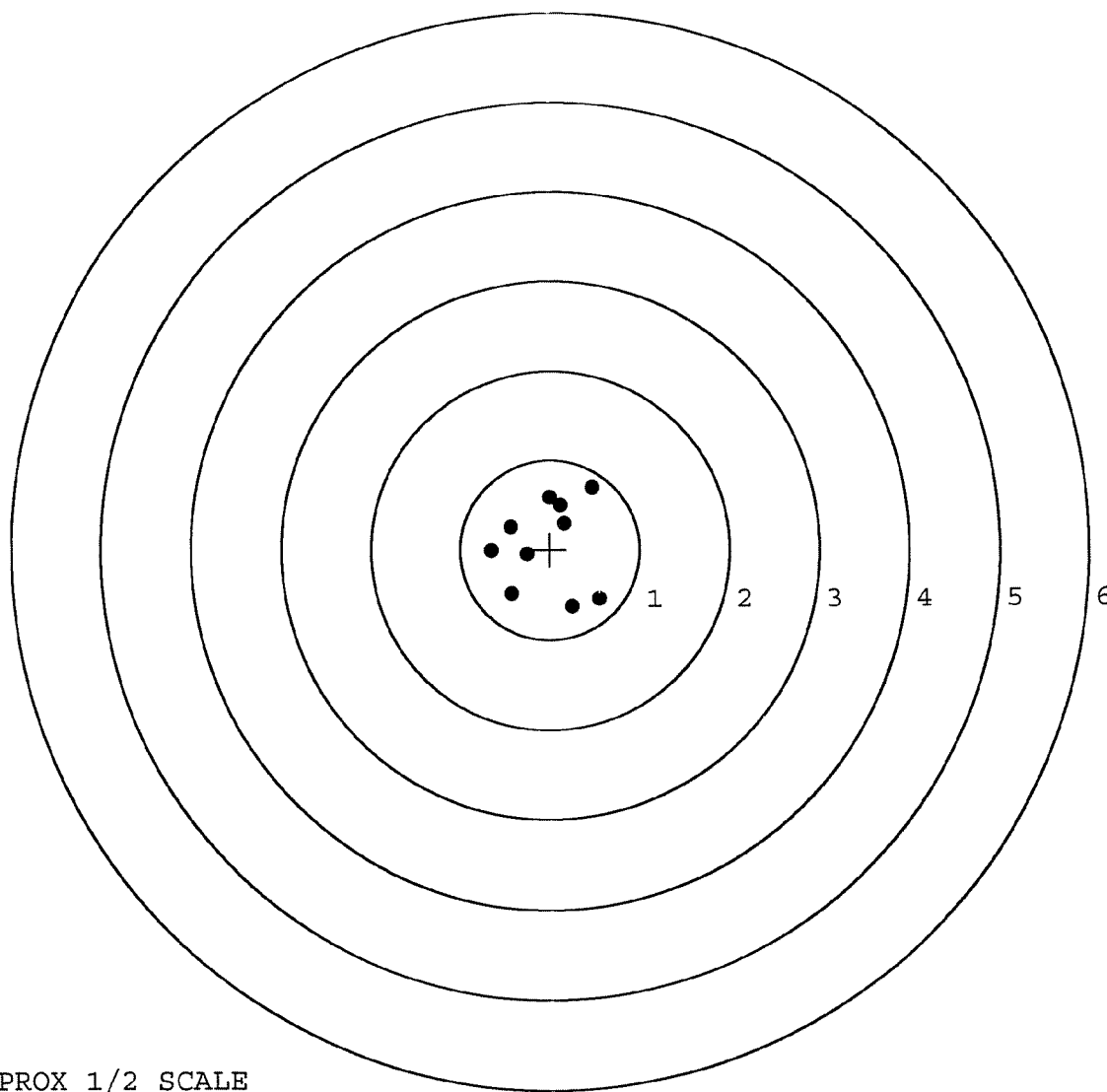
MEAN RADIUS: 0.571

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.474	0.689
2:	0.000	0.586
3:	0.160	0.289
4:	-0.435	0.256
5:	-0.659	-0.008
6:	-0.259	-0.055
7:	-0.430	-0.488
8:	0.247	-0.637
9:	0.547	-0.552
10:	0.125	0.500



TARGET APPROX 1/2 SCALE

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

R & E NUMBER 00130078

SERIAL NUMBER 66391094 "NEW" G 6645310

LOG-IN DATE 6-6-07

OPERATION #	OPERATION NAME	DATE	INITIAL
500	DIS-ASSEMBLE GUN	7-11-07	RTZ
505	RE-BARREL	7-13-07	RTZ
560	ASSEMBLE	7-16-07	TRW
600	PROOF	7-16-07	TRW
605	CHECK HEADSPACE	7-16-07	TRW
610	DIS-ASSEMBLE GUN	7-16-07	RTZ
612	MAGNAFLUX	7-17-07	unint
510	DRILL AND TAP	7-16-07	TRW
615	ROLLMARK CALIBER	7-16-07	CW
618	ROTO-BLAST	7-17-07	UB
620	APPLY COATINGS	7-18-07	CM
625	FINAL ASSEMBLY	7-20-07	RTZ
640	FUNCTION TEST AND	(PASS) FAIL	7-20-07 TRW
650	TARGET	(PASS) FAIL	7-20-07 TRW
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
670	FINAL INSPECTION		7-20-07 Fm
	A) HEADSPACE	PASS FAIL	7-24-07 RA
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	2.89 2.91 2.89 2.84 2.89 7-23-07 RA
680	F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX	5.0 4.5 4.5 7-23-07 RA
	G) SAFETY OFF FORCE	2 LBS FAIL	2.0 2.0 2.0 7-23-07 RA
	I) FIRING PIN INDENT	.020	.023 .023 .022 7-23-07 RA
690	PACK		7-25-07 RA

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

R & E NUMBER	85921		
SERIAL NUMBER	C6225529		C6639 1094 (New)
LOG-IN DATE	10-4-04		
INSPECT AND VERIFY:			
OPERATION #	OPERATION NAME	DATE	INITIAL
550	DIS-ASSEMBLE GUN	10-4-04	RTL
560 A	RE-BARREL	10-5-04	
B	DRILL AND TAP	10-19-04	TRW
575	ASSEMBLE	10-15-04	RTL
600	PROOF	10-18-04	RTL
605	CHECK HEADSPACE	10-18-04	RTL
610	DIS-ASSEMBLE GUN	10-19-04	RTL
612	MAGNAFLUX		
615	ROLLMARK CALIBER	10/20/04	LB
618	ROTO-BLAST	10-22-04	LB
620	APPLY COATINGS	10/26/04	HP
625 A	FINAL ASSEMBLY	11-3-04	RTL
B	TRIGGER PULL TEST		
C	SAFETY "ON" FORCE		
D	SAFETY "OFF" FORCE		
E	FIRING PIN INDENT		
640	TARGET	11-8-04	TRW
655	FINAL INSPECT	11-8-04	RTL
660	PACK	11-9-04	DA
		SHIP DATE	
		QAR INSPECTION DATE	

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6391094.___0
FILE DATE AND TIME: 11/08/2004 07:53

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

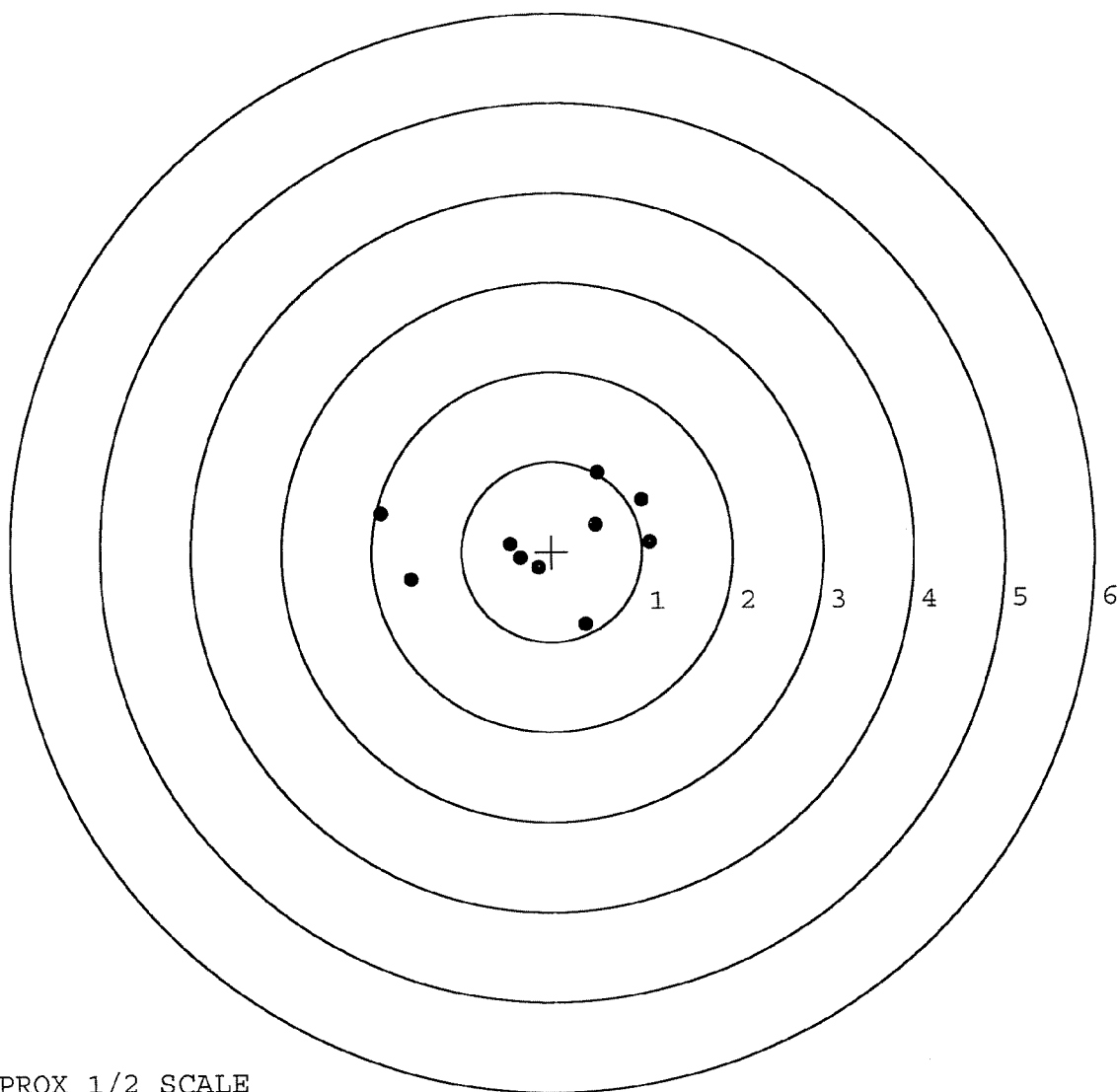
The Average X Centroid of the Five Target Set:	-0.045
The Average Y Centroid of the Five Target Set:	-0.013
The Average Point of Impact of the Five Target Set:	0.047
The Average Mean Radius of the Five Target Set:	0.789
The Distance from POA to Centroid Target #1:	0.141
The Distance from Centroid Target #2 to Centroid Target #1:	0.111
The Distance from Centroid Target #3 to Centroid Target #1:	0.304
The Distance from Centroid Target #4 to Centroid Target #1:	0.243
The Distance from Centroid Target #5 to Centroid Target #1:	0.142

SERIAL NUMBER: G6391094. 0
TARGET NUMBER: 1
FILE DATE: 11/08/2004
FILE TIME: 07:53

X CENTROID: -0.097
Y CENTROID: 0.102
POA TO CENTROID: 0.141
HORZ SPREAD: 2.978
VERT SPREAD: 1.687
GROUP SPREAD: 2.997
MIN RADIUS: 0.283
MAX RADIUS: 1.830
MEAN RADIUS: 0.931

IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 5
in 3 IN DIAMETER: 8

POINT#	X	Y
1:	0.374	-0.810
2:	1.082	0.103
3:	0.995	0.572
4:	0.488	0.295
5:	0.519	0.877
6:	-0.152	-0.175
7:	-0.353	-0.068
8:	-0.462	0.089
9:	-1.565	-0.299
10:	-1.896	0.438

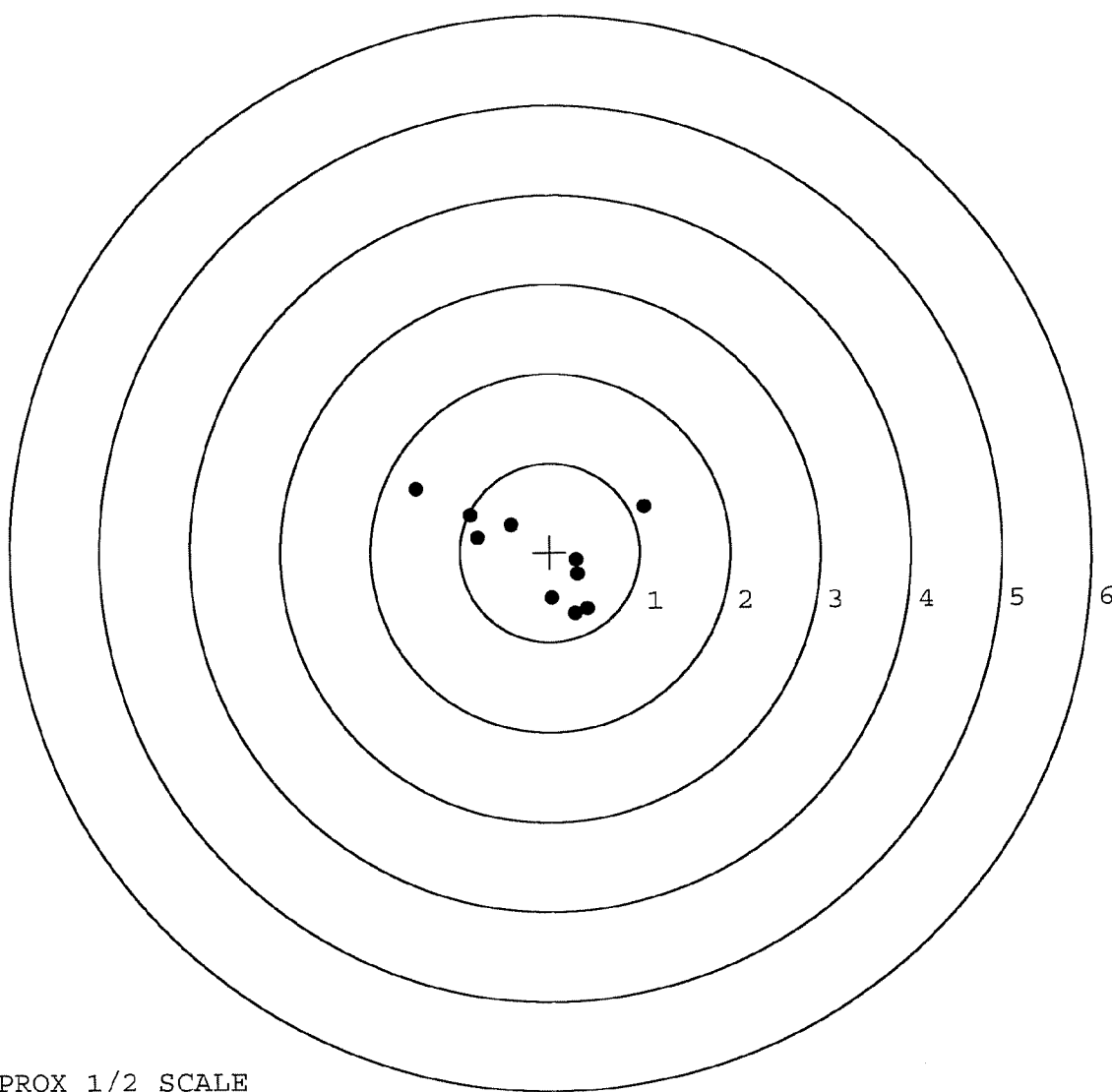


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6391094.____0
TARGET NUMBER: 2
FILE DATE: 11/08/2004
FILE TIME: 07:53

X CENTROID: -0.122
Y CENTROID: -0.006
POA TO CENTROID: 0.123
HORZ SPREAD: 2.534
VERT SPREAD: 1.416
GROUP SPREAD: 2.543
MIN RADIUS: 0.430
MAX RADIUS: 1.548
MEAN RADIUS: 0.793
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 9

POINT#	X	Y
1:	1.047	0.506
2:	-1.487	0.724
3:	-0.881	0.425
4:	-0.802	0.167
5:	-0.433	0.310
6:	0.299	-0.092
7:	0.313	-0.253
8:	0.417	-0.639
9:	0.021	-0.515
10:	0.282	-0.692

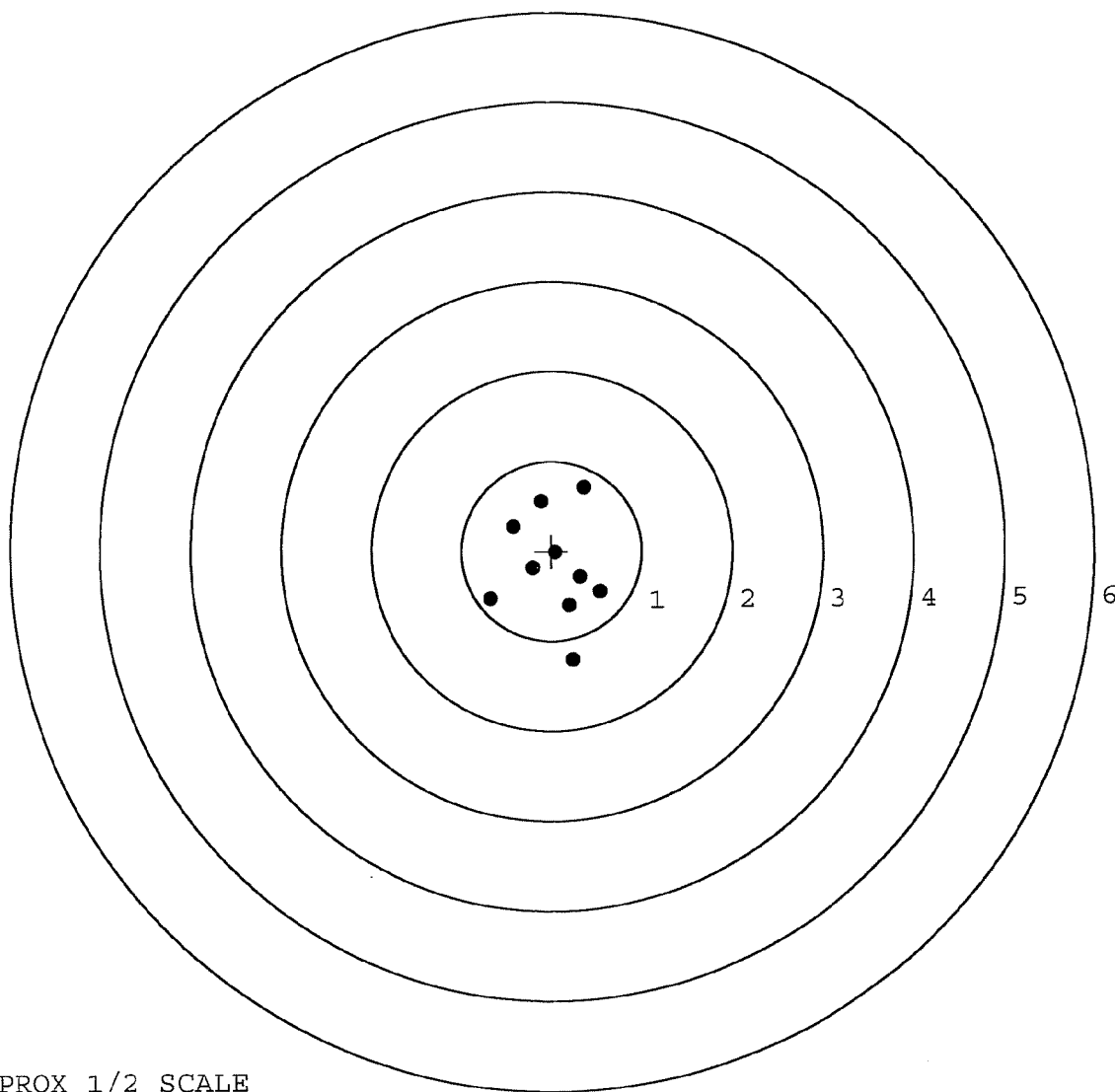


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6391094.___0
TARGET NUMBER: 3
FILE DATE: 11/08/2004
FILE TIME: 07:53

X CENTROID: 0.026
Y CENTROID: -0.176
POA TO CENTROID: 0.178
HORZ SPREAD: 1.223
VERT SPREAD: 1.926
GROUP SPREAD: 1.931
MIN RADIUS: 0.162
MAX RADIUS: 1.060
MEAN RADIUS: 0.596
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.238	-1.215
2:	-0.685	-0.531
3:	-0.426	0.278
4:	-0.115	0.557
5:	0.370	0.711
6:	0.044	-0.015
7:	-0.220	-0.190
8:	0.316	-0.293
9:	0.538	-0.455
10:	0.197	-0.607

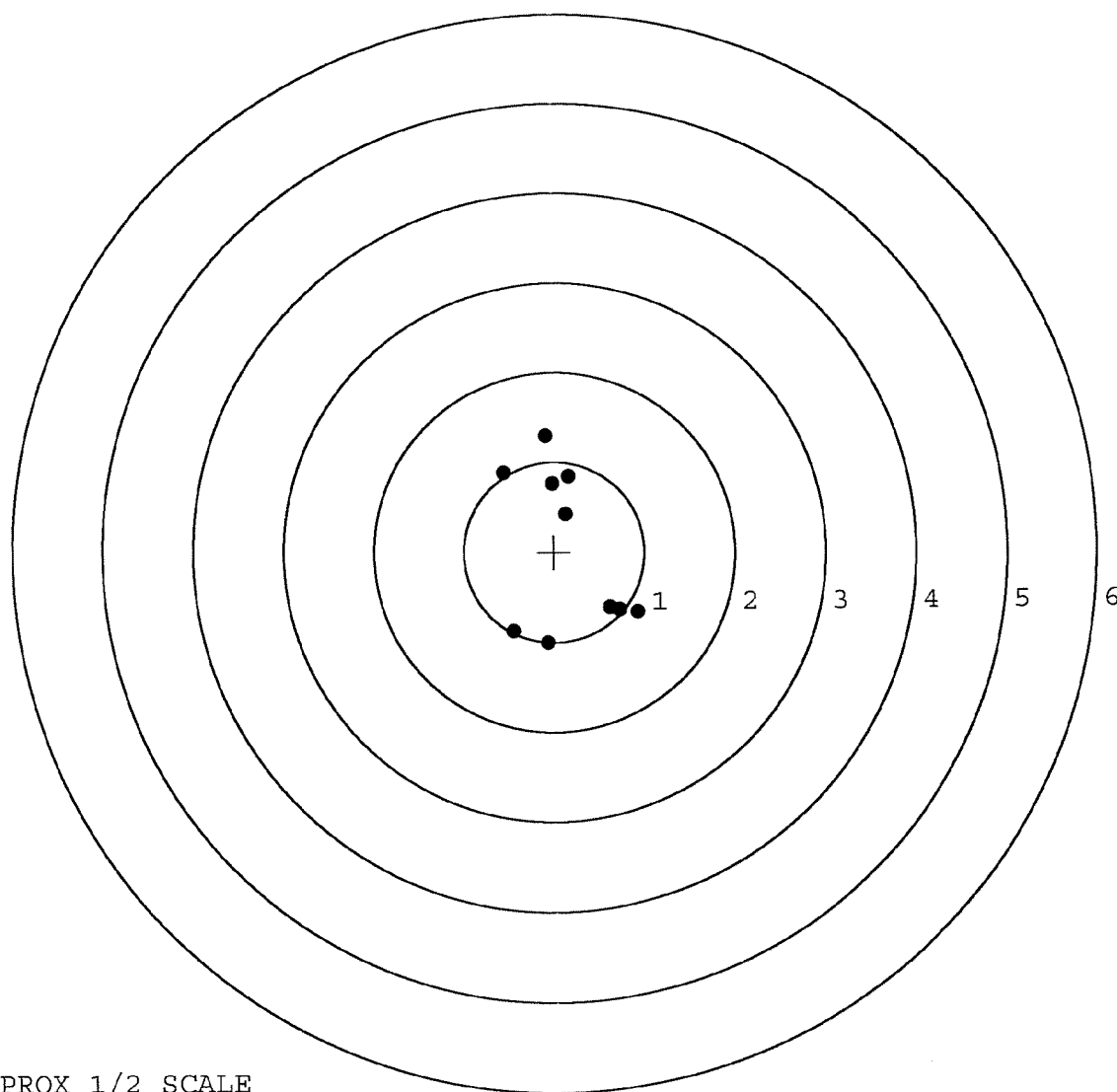


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6391094. 0
TARGET NUMBER: 4
FILE DATE: 11/08/2004
FILE TIME: 07:53

X CENTROID: 0.137
Y CENTROID: 0.036
POA TO CENTROID: 0.142
HORZ SPREAD: 1.479
VERT SPREAD: 2.304
GROUP SPREAD: 2.304
MIN RADIUS: 0.381
MAX RADIUS: 1.275
MEAN RADIUS: 0.920
IN 1 IN DIAMETER: 1
IN 2 IN DIAMETER: 5
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.922	-0.672
2:	0.614	-0.614
3:	-0.075	-1.013
4:	-0.458	-0.874
5:	-0.087	1.291
6:	-0.557	0.882
7:	0.167	0.835
8:	0.140	0.417
9:	-0.019	0.756
10:	0.722	-0.645

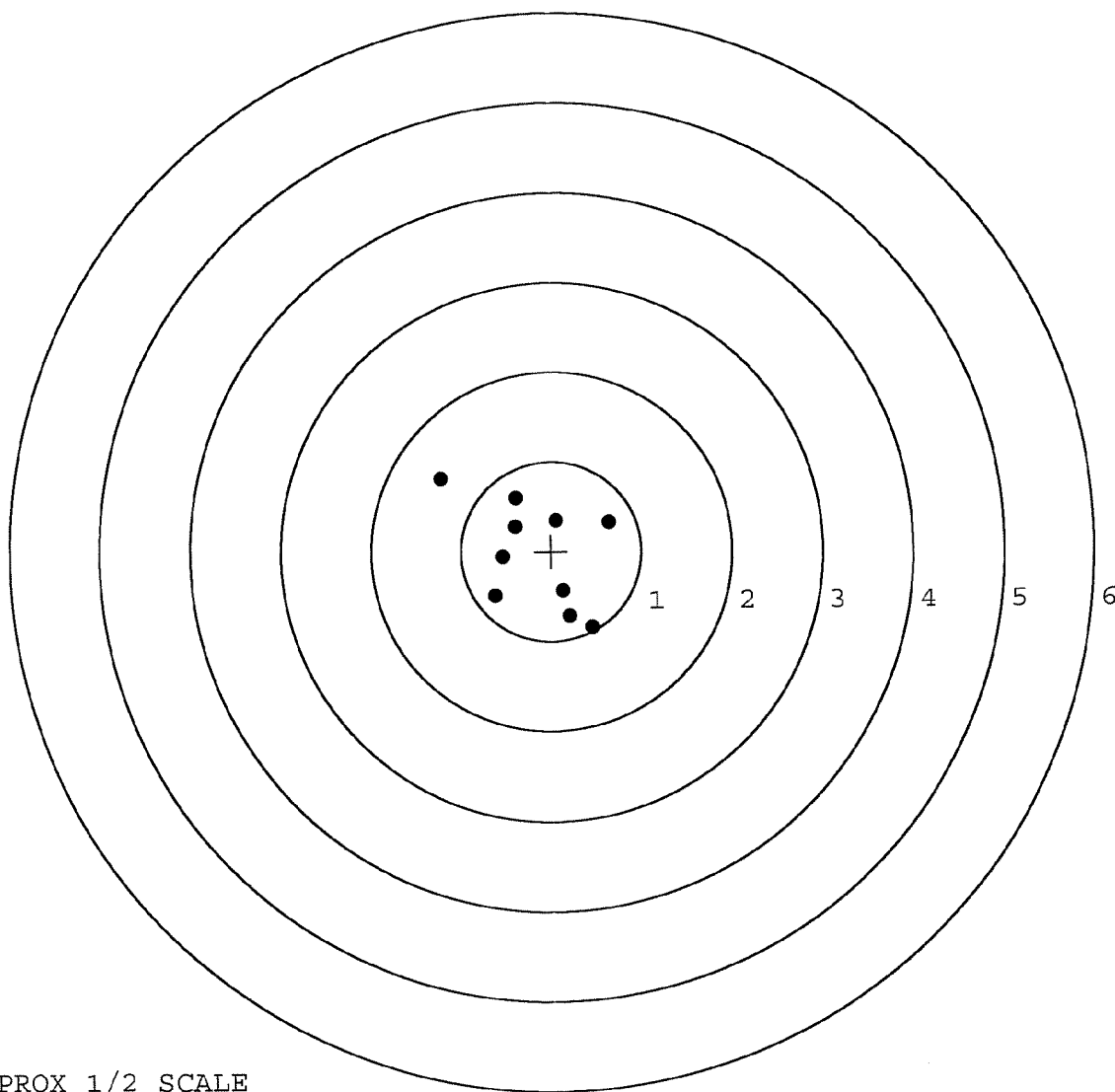


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6391094.___0
TARGET NUMBER: 5
FILE DATE: 11/08/2004
FILE TIME: 07:53

X CENTROID: -0.167
Y CENTROID: -0.022
POA TO CENTROID: 0.168
HORZ SPREAD: 1.864
VERT SPREAD: 1.672
GROUP SPREAD: 2.369
MIN RADIUS: 0.372
MAX RADIUS: 1.351
MEAN RADIUS: 0.707
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.454	-0.852
2:	0.210	-0.721
3:	0.139	-0.444
4:	0.640	0.325
5:	0.057	0.341
6:	-0.390	0.598
7:	-0.394	0.275
8:	-0.536	-0.065
9:	-0.623	-0.494
10:	-1.224	0.820



TARGET APPROX 1/2 SCALE

RECEIVING AND ESTIMATING REPORT

COMMENTS

ORDER

R 94-24908

M-24 SNIPER

INITIAL FPS	CUSTOMER ORDER NO.				
DATE RECEIVED 08/29/94	DATE OPENED 08/30/94	DATE CODE DI 9-88	SERIAL NUMBER C6225529	NEW SERIAL NUMBER	MODEL AND GRADE 700 7.62 NATO
ACCESSORIES W/STUDS	SCOPE MNTS		SCOPE BASE		

FROM:

SHIP TO:

DEPT OF THE ARMY
B CO ARMS
2/75 RANGER BATTALION
FT LEWIS

WA 98433

DEPT OF THE ARMY
B CO ARMS
2/75 RANGER BATTALION
FT LEWIS

WA

98433

CUST NO:062072 C.O.D.L

ACCOUNT NUMBER	ACCOUNT NUMBER N/C	WRITE ☐	PROM. DATE	ESTIMATED	VIA
					R768625192

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

New Barrel

PARTS

COMMENTS

Barrel 96003
Mag Spring 15677

Repowder Coat Trigger Guard
Assy Front & Rear Sight Bases
Rezined Scope Base, Rings &
Swivel Studs

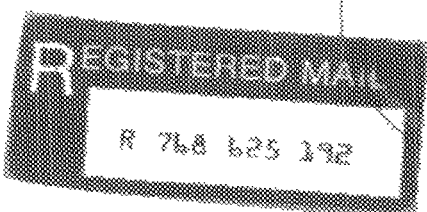
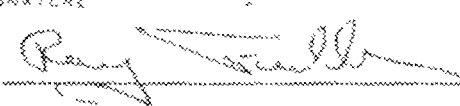
REPAIRMAN RW	PROOF ✓	CLEAN ✓	TEST ✓	TARGET C	PATTERN
GALLERY TESTER RW	DATE 9/1/94	DATE 9/13/94	DATE 9/13/94	DATE 9/13/94	DATE

OFFICE COPY

R06925 REV. 1/94

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

M2400171294

PACKING LIST		PACKED BY Mr. Ray Fuller WG-10 Bn. Armor	1. NO. BOXES 1	2a. REQUISITION NO. 77245	2b. ORDER NO.
3. ITEM 7.62mm M24 Sniper Weapons System (SW5)				4. DATE 26 July 1994	
				5. PAGE 1 OF 1 PAGES	
BOX NO.	CONTENTS - STOCK NUMBER AND ALPHANUMERIC	UNIT OF ISSUE	QUANTITIES REQUIRED		
1a.	1b.	1c.	1d. UNIT OF ISSUE	1e. QUANTITY	1f. TOTAL
	7.62mm M24 Sniper Weapon System (SW5) Serial No 6225529 NSN: 1005-01-240-2136	EA			1
					
<u>Note:</u> All Optic Scope Ring Mounts Packed					
6. I HEREBY CERTIFY THAT THE ITEMS LISTED HEREON ARE WITHIN THE SPECIFIED BOXES					
7. TYPED NAME AND TITLE Ray Fuller WG-10 Bn. Armor			8. SIGNATURE 		

DD FORM 1750

MAINTENANCE REQUEST				PAGE 807	NO OF PAGES	REQUIREMENTS CONTROL SYMBOL CSGLD - 1047191			
For use of this form, see DA FORM 2407-700, the predecessor agency is DCSLOO									
SECTION I - EQUIPMENT DATA									
CONTROL NUMBER		WORK ORDER NO 94245		WESEC		ORG NO 02		PD AUTHENTICATION <i>[Signature]</i>	
☒ Work Request ☐ MWO ☐ Warranty Claim		1A. ORGANIZATION Bn Armo HHC 275 RGR RGT		B. LOCATION Fort Lewis Wn			C. UNIT IDENT CODE 443M/A		
2. SERIAL NO C6825529		3. NOUN NOMENCLATURE M245 SWR		4. LINE NO		5. MODEL M24		6. NATIONAL STOCK NUMBER 1005-01-240-2136	
7A. MAINTENANCE ACTIVITY Remedy Point Co		8. LEVEL		9. UTILIZATION LOW		10. MOSR STEM		11. ESD NO	
12. FAILURE DETECTED DURING (Select one - use ☒ or ☐)		13. FIRST INDICATION OF TROUBLE (Select one - use ☒ or ☐)		14. INSPECTION		15. OVERHEATING		16. OUT OF ADJUSTMENT	
☐ A Sub. Man. ☒ C Test ☐ E Storage ☐ D Flight ☐ GBS Inoperative ☐ FSS Overheating ☐ TSD Out of Adjustment		☐ B Handling ☐ O Normal Op ☐ F Inspection ☐ H Other ☐ GBS Noisy ☐ SST Low Performance ☒ Other							
17A. DESCRIBE DEFICIENCIES OR SYMPTOMS ON THE BASIS OF COMPLETE CHECKOUT AND DIAGNOSTIC PROCEDURE IN EQUIPMENT TM (Do not prescribe repair).									
<i>Handgun has jammed 13000 lbs. During Barrel Test Fire at 200/300 yds. gauge was shot exceeding the center of 2.6" to 4.0" 3.8" at 100 yds (5-10 ft. Group). This center was provided as by Mr. Jim Glen ARCE DEN 884-7071</i>									
17. REMARKS Request Re Banding and Complete Weapon Reconditioning.									
SECTION II - WORK ACCOMPLISHED									
17A. REPAIR ORGANIZATION ACTIVITY				C. UNIT IDENT CODE		17B. TYPE ORGANIZATION ACTIVITY ACCORDING TO WORK (Select one - use ☒ or ☐)		17C. AMS ACCT CODE	
B. LOCATION						☐ 1 TDR ☐ 2 TO ☐ 3 Contractor			
25A. ACT CODE	B. PARTS CODE	C. COMPONENT PART NAME, SPC. OR MARKING			D. MANPOWER (Hrs. & Fraction)	E. NATIONAL STOCK NUMBER	F. PARTS SERVICE CODE	G. QTY	H. PARTS COST
		(1) CR CODE	(2) REP DESIGN	(3) MFR CODE					
									\$
									\$
									\$
									\$
									\$
									\$
									\$
									\$
									\$
									\$
									\$
									\$
									\$
I. TOTAL MANPOWER					J. TOTAL MANPOWER COST		K. TOTAL PARTS COST		
					\$		\$		
21. DELAY (Select One)		22. Parts		23. Manpower		24. Facilities		25. Tools	
☐ 1		☐ 2		☐ 3		☐ 4		☐ 5	
26. SUBMITTED BY <i>Ray Fuller</i>		27. RECEIVED BY		28. WORK STARTED BY		29. INSPECTED BY		30. ACCEPTED BY	
JULIAN DATE 4235		JULIAN DATE		JULIAN DATE		JULIAN DATE		JULIAN DATE	
31. DISPOSITION (Select One)		32. To Use		33. To Stock		34. Salvaged		35. Enclosed	
☐ A		☐ B		☐ C		☐ D		☐ E	

DA FORM 2407, AUG 88

EXPIRES 31 MAY 89 MAY BE USED

NMP COPY 2

Final Inspection

Sn: C6225529

DATE REC'D: 8/29/94

DATE RET'D:

Auditor: AW

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 # 06225529
15 Sep 1994

CENTROIDAL DISTANCES

0 TO	1	.288979
1 TO	2	.304532
1 TO	3	.630849
1 TO	4	.293956
1 TO	5	.214853

POI <----POI

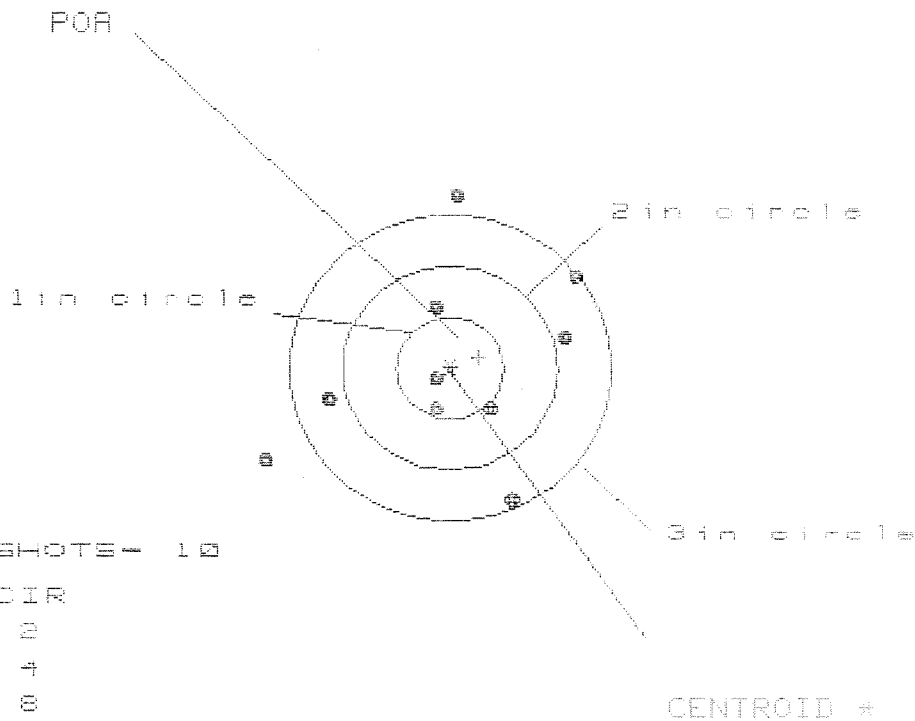
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0408
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0456
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0602202
THE AMR FOR THIS RIFLE IS: 1.005

15 Sep 1994

FILE:/PATTERNING/CENTERFIRE_PATT/06225523

CENTERFIRE PATTERNS

1



OF SHOTS- 10

IN CIR

1in = 2

2in = 4

3in = 8

HS= 2.853

VS= 3.022

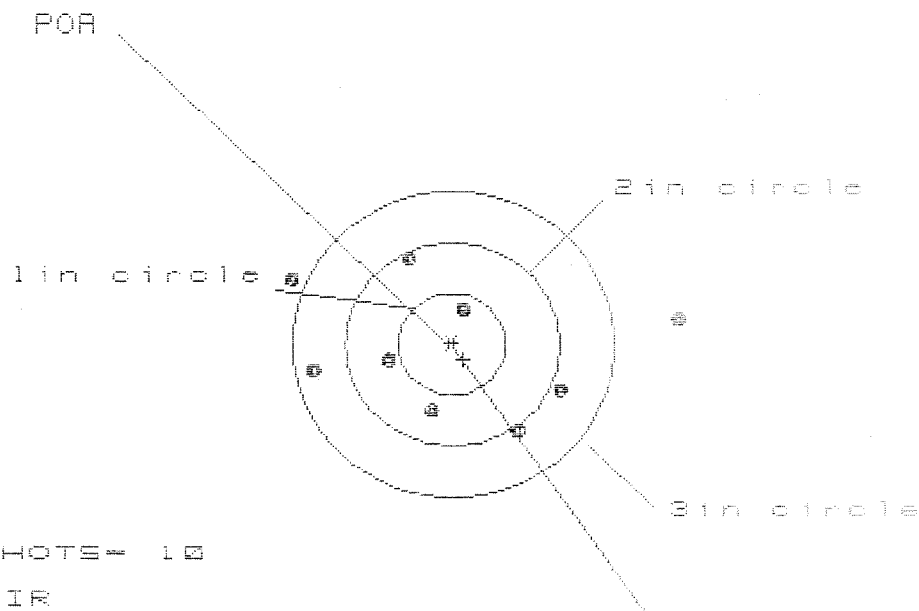
GS= 3.454

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.215	1.022	1.013
MINIMUM X	-1.738	-1.336	-1.345
MAXIMUM Y	1.691	1.587	.955
MINIMUM Y	-1.331	-1.435	-1.236
CENTROID X	-.270	-.077	-.068
CENTROID Y	-.103	.001	-.198
POB TO CENTROID in.	.289	.077	.209
MIN RADIUS	.178	.397	.349
MEAN RADIUS	1.075	.986	.879
MAX RADIUS	1.972	1.589	1.392
HORIZONTAL SPREAD	2.953	2.358	2.358
VERTICAL SPREAD	3.022	3.022	2.191
EXTREME SPREAD	3.454	3.051	2.622
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	8		

15 Sep 1994

FILE:/PATTERNING/CENTERFIRE_PATT/08225529

CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1in = 2

2in = 5

3in = 3

HS = 3.668

VS = 1.668

GS = 3.689

PATTERN #

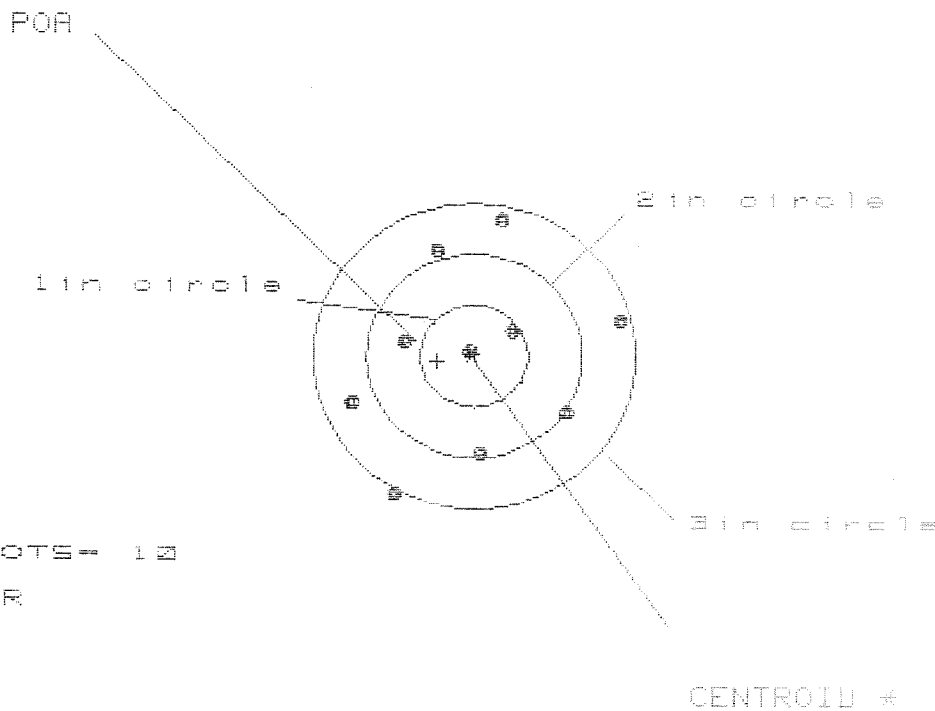
2

SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.141	1.273	1.112
MINIMUM X	:	-1.527	-1.289	-1.263
MAXIMUM Y	:	.832	.858	.940
MINIMUM Y	:	-.836	-.810	-.728
CENTROID X	:	-.102	-.340	-.179
CENTROID Y	:	.151	.125	.043
POA TO CENTROID in.	:	.182	.362	.184
MIN RADIUS	:	.351	.355	.476
MEAN RADIUS	:	1.026	.885	.809
MAX RADIUS	:	2.154	1.444	1.271
HORIZONTAL SPREAD	:	3.668	2.562	2.375
VERTICAL SPREAD	:	1.668	1.668	1.668
EXTREME SPREAD	:	3.689	2.797	2.388
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	5		
NUMBER IN THREE INCH CIRCLE	=	8		

15 Sep 1994

FILE:/PATTERNING/CENTERFIRE_PATT/08225529

CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1in = 2

2in = 5

3in = 9

HS = 2.571

VS = 2.704

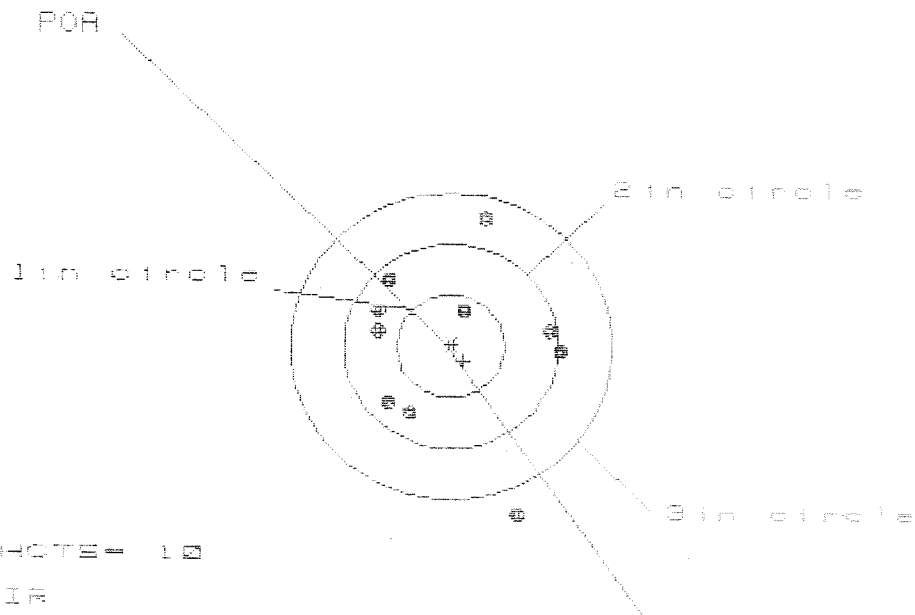
GS = 2.895

PATTERN #	3		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.385	1.382	.934
MINIMUM X	-1.186	-1.269	-1.106
MAXIMUM Y	1.394	1.249	1.272
MINIMUM Y	-1.310	-1.071	-1.048
CENTROID X	.341	.424	.201
CENTROID Y	.054	.199	.176
POA TO CENTROID in.	.345	.469	.315
MIN RADIUS	.100	.145	.047
MEAN RADIUS	.986	.918	.852
MAX RADIUS	1.507	1.424	1.324
HORIZONTAL SPREAD	2.571	2.571	2.040
VERTICAL SPREAD	2.704	2.320	2.320
EXTREME SPREAD	2.895	2.702	2.401
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		9	

15 Sep 1994

FILE:/PATTERNING/CENTERFIRE_PATT/08225523

CENTERFIRE PATTERNS # 4



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 8

3 in = 9

HDI = 1.696

VSD = 2.936

GSD = 2.953

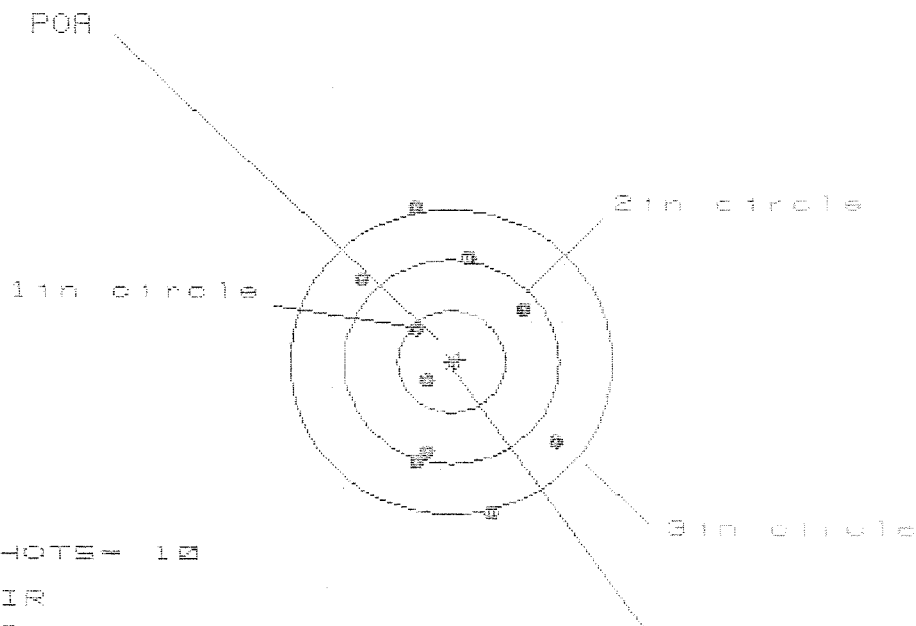
CENTROID *

PATTERN #				
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.975	1.046	1.095
MINIMUM X	:	-.721	-.650	-.661
MAXIMUM Y	:	1.259	1.073	.581
MINIMUM Y	:	-1.677	-.843	-.739
CENTROID X	:	.117	-.188	-.237
CENTROID Y	:	.148	.334	.290
FOR TO CENTROID in.	:	.189	.383	.310
MIN RADIUS	:	.414	.296	.428
MEAN RADIUS	:	.934	.805	.759
MAX RADIUS	:	1.793	1.142	1.104
HORIZONTAL SPREAD	:	1.696	1.696	1.696
VERTICAL SPREAD	:	2.936	1.916	1.290
EXTREME SPREAD	:	2.953	2.855	1.716
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	

15 Sep 1994

FILE:/PATTERNING/CENTERFIRE_PATT/06225529

CENTERFIRE PATTERNS # 5



OF SHOTS = 10

IN CIR

1in = 2

2in = 4

3in = 4

ME = 1.7502

VE = 2.9668

GE = 3.0552

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.981	.942	.983
MINIMUM X	:	-.811	-.850	-.809
MAXIMUM Y	:	1.491	1.178	1.014
MINIMUM Y	:	-1.478	-1.313	-.957
CENTROID X	:	-.071	-.032	-.073
CENTROID Y	:	-.022	-.187	-.023
POR TO CENTROID in.	:	.074	.190	.076
MIN RADIUS	:	.303	.258	.301
MEAN RADIUS	:	1.005	.937	.874
MAX RADIUS	:	1.530	1.352	1.236
HORIZONTAL SPREAD	:	1.792	1.792	1.792
VERTICAL SPREAD	:	2.969	2.491	1.971
EXTREME SPREAD	:	3.052	2.619	2.411
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	

CONTRACT # DAAA21-87-C-0086

New Barrel

GUN SERIAL # C6225529

OP. #	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and Stock		9/1/94	RW
600	Proof		9/1/94	RW
607.	Check Headspace		9/1/94	RW
610	Dis-assemble Gun		9/1/94	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		9/2/94	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		9/2/94	RW
	C) Inspect Ejector Hole for Chamfer		9/2/94	RW
	D) Oil Firing Pin Ass'y		9/2/94	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							
	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						9/13	WB
	A) Time						9/13	WB
	B) Malfunctions						9/13	WB
	C) Pierced Primers						9/13	WB
	D) Optical Clarity of Scope						9/13	WB
645	Inspect for Live Ammo						9/13/94	RW
655	Final Inspection							
	A) Headspace						9/14/94	RW
	B) Trigger Pull	2.43	2.45	2.49	2.51	2.51	9/14/94	RW
	C) Function						9/14/94	RW
660	Pack							

Scope #

1769

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6225529

OP. #	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and stock	8	9/88	FB
600	Proof	9	7/88	RW
607	Check Headspace	9	7/88	RW
610	Dis-assemble gun	9	7/88	RW
612	Magnaflux Barrel Action		9-14-88	Rfe
	Magnaflux Bolt		9-14-88	Rfe
615	Rollmark Caliber			
617	Drill & Tap Sight Holes			
618	Polish Barrel			
620	Apply Coatings (Barrel Action)		10-31-88	TJA
	Apply Coatings (Bolt)		10-31-88	TJA
625	Final Assembly A) Clean inside of Bolt Assembly		11/2/88	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		11/2/88	RW
	C) Inspect Ejector Hole for Chamfer		11/2/88	RW

OVER

OP.#		READINGS	DATE	INITIAL
625 cont.	D) Oil Firing Pin Ass'y		11/2/88	RW
	E) Adjust Trigger Pull to Min. Setting and Stake		2 NOV 88	JS
	F) Safety on Force	5.5 5 5	2 NOV 88	JS
	G) Safety off Force	4 4 3	2 NOV 88	JS
	H) Trigger Pull Test & Retainabilty		2 NOV 88	JS
	I) Firing Pin Indent	.0205 .0215 .021	2 NOV 88	JS
	J) Assemble Stock		11/7/88	RW
	K) Assemble Swivel Studs		29 NOV 88	JS
	L) Attach Front & Rear Sight Assemblies		11/7/88	RW
	M) Iron Sight Alignment		11/7/88	RW
	N) Detach Front & Rear Sights & place in numbered container		11/7/88	RW
	O) Attach Scope to Rifle		11/8/88	RW
	P) Detach & Attach Scope 20 times		8 NOV 88	JS
640	Gallery Target & Test	59 R 92L	11-10-88	A.C.
	A) Optical Clarity of Scope	OK	11-10-88	A.C.
645	Inspect for Live Ammo	NO WE	11-10-88	A.C.
655	Final Inspection A) Headspace		29 NOV 88	JS
	B) Trigger Pull		29 NOV 88	JS
	C) Function		29 NOV 88	JS
660	Pack		15 Dec 88	JS

SWS TRIGGER PULL TEST

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

SERIAL NO. C6225529

DATE 1/10/88

TESTER J. U. + 90.8

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.42	2.27	2.33	2.48	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.35	2.31	2.31	2.42	
PULL #3	2.31	2.32	2.32	2.41	
PULL #4	2.30	2.27	2.31	2.40	
PULL #5	2.33	2.30	2.31	2.36	
TOTAL	11.71	11.47	11.58	12.07	
AVG.	2.342	2.294	2.316	2.414	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.21	3.07		
PULL #2	3.17	3.18		
PULL #3	3.01	3.19		
PULL #4	3.17	3.19		
PULL #5	3.18	3.22		
TOTAL	15.74	15.85		
AVG.	3.148	3.17		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.23	4.19		4.26
PULL #2	4.23	4.20		4.35
PULL #3	4.23	4.22		4.37
PULL #4	4.22	4.21		4.34
PULL #5	4.22	4.22		4.35
TOTAL	21.13	21.04		21.67
AVG.	4.226	4.208		4.334

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6225529

CENTROIDAL DISTANCES

0 TO	1	.477326
1 TO	2	.520739
1 TO	3	.550281
1 TO	4	1.42123
1 TO	5	.661852

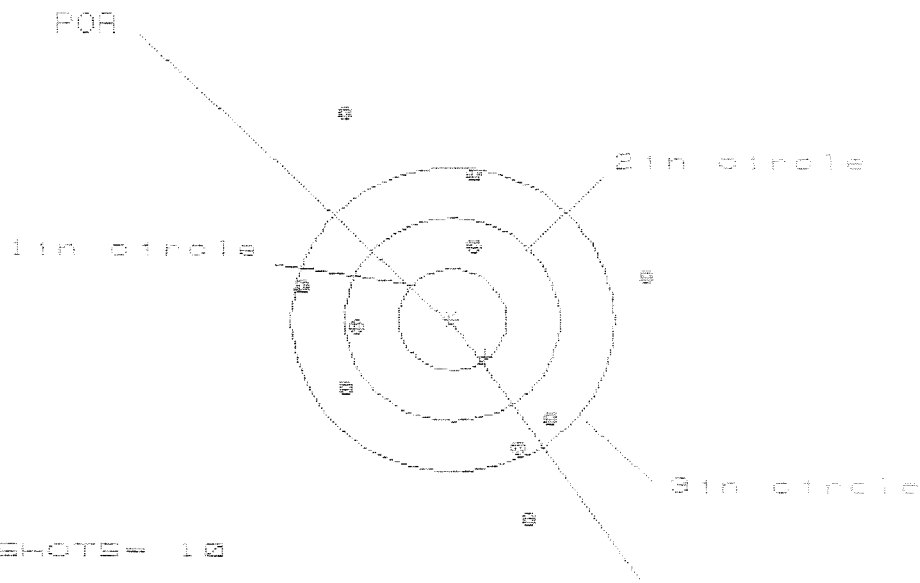
4
2
1 3 5
+ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0056
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .8132
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .813227
THE AMR FOR THIS RIFLE IS: 1.078

10 Nov 1988

FILE:/PATTERNING/CENTERFIRE_PATT/06225523

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1in = 6

2in = 2

3in = 7

HS = 3.215

VS = 4.068

GS = 4.400

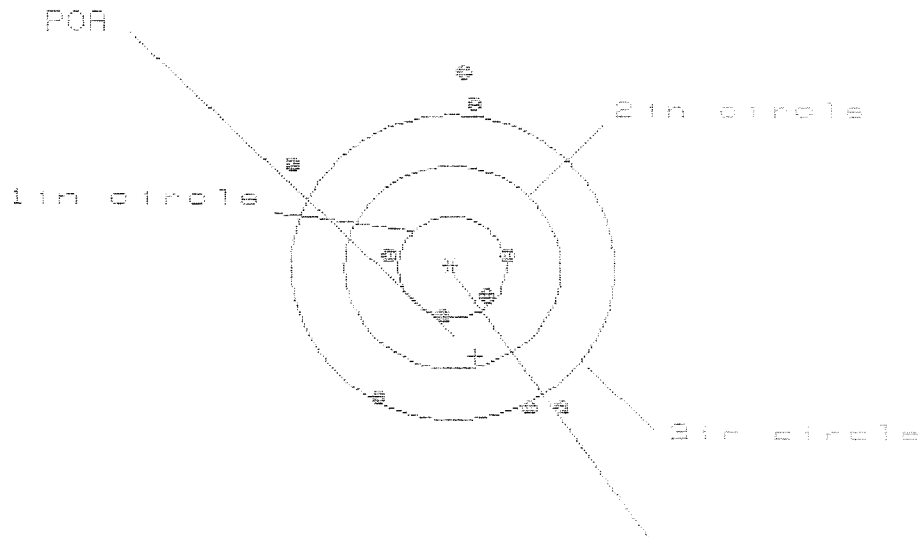
CENTROID #

PATTERN #				
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.853	1.743	1.816
MINIMUM X	:	-1.362	-1.472	-1.399
MAXIMUM Y	:	2.079	1.670	1.450
MINIMUM Y	:	-1.989	-1.758	-1.264
CENTROID X	:	-1.304	-1.194	-1.267
CENTROID Y	:	.368	.137	.357
FOR TO CENTROID in.	:	.478	.238	.446
MIN RADIUS	:	.796	1.012	.900
MEAN RADIUS	:	1.488	1.388	1.311
MAX RADIUS	:	2.302	1.871	1.873
HORIZONTAL SPREAD	:	3.215	3.215	3.215
VERTICAL SPREAD	:	4.068	3.428	2.714
EXTREME SPREAD	:	4.400	3.468	3.217
NUMBER IN ONE INCH CIRCLE	=		6	
NUMBER IN TWO INCH CIRCLE	=		2	
NUMBER IN THREE INCH CIRCLE	=		7	

18 Nov 1988

FILE:/PATTERNING/CENTERFIRE_PATT/06225529

CENTERFIRE PATTERNS # 2



OF SHOTS - 10

IN CIR

1 in = 3

2 in = 4

3 in = 5

HS = 0.5330

VS = 0.2800

GS = 0.4000

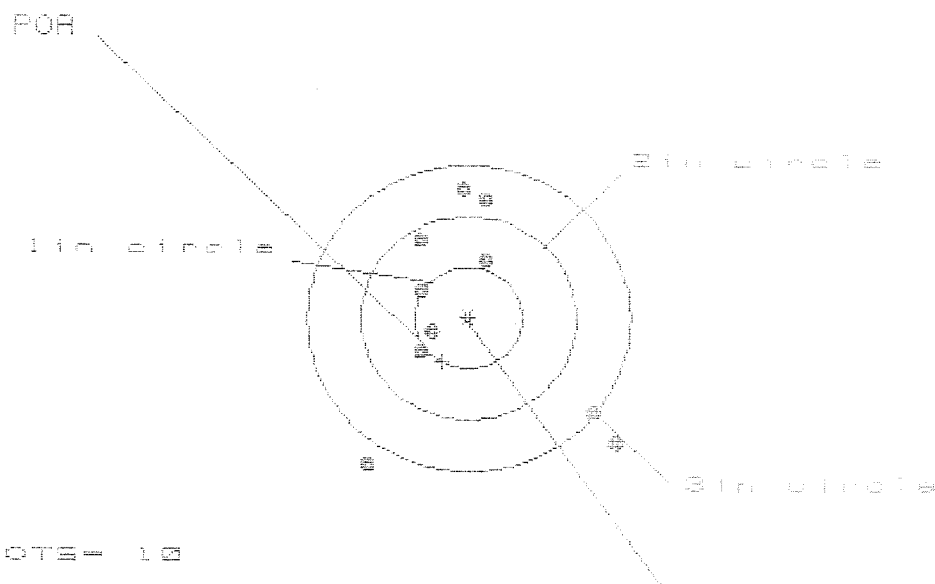
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.049	1.060	.877
MINIMUM X	-1.481	-1.470	-.820
MAXIMUM Y	1.915	1.831	1.990
MINIMUM Y	-1.375	-1.163	-1.004
CENTROID X	-.209	-.220	-.037
CENTROID Y	.080	.668	.509
POA TO CENTROID in.	.905	.703	.511
MIN RADIUS	.408	.282	.180
MEAN RADIUS	1.211	1.096	.955
MAX RADIUS	1.917	1.941	1.990
HORIZONTAL SPREAD	2.530	2.530	1.697
VERTICAL SPREAD	3.290	2.994	2.994
EXTREME SPREAD	3.496	3.496	3.097
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		4	
NUMBER IN THREE INCH CIRCLE =		5	

18 Nov 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C8225523

CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 5

3 in = 4

HS = 0.887

VS = 0.665

GS = 0.882

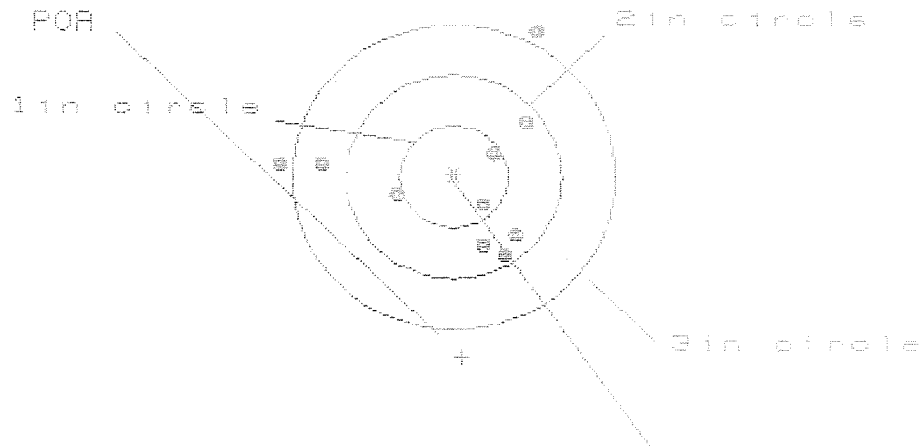
CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.333	1.344	1.242
MINIMUM X	:	-0.963	-0.815	-0.442
MAXIMUM Y	:	1.270	1.132	0.948
MINIMUM Y	:	-1.395	-1.533	-1.256
CENTROID X	:	.243	.095	.197
CENTROID Y	:	.428	.566	.758
FOR TO CENTROID in.	:	.492	.574	.723
MIN RADIUS	:	.366	.312	.317
MEAN RADIUS	:	1.045	.982	.778
MAX RADIUS	:	1.826	1.737	1.766
HORIZONTAL SPREAD	:	2.297	2.159	1.685
VERTICAL SPREAD	:	2.665	2.665	2.195
EXTREME SPREAD	:	2.892	2.885	2.544
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		7	

10 Nov 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C8225529

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 2

2in = 7

3in = 8

HS= 2.491

VS= 2.229

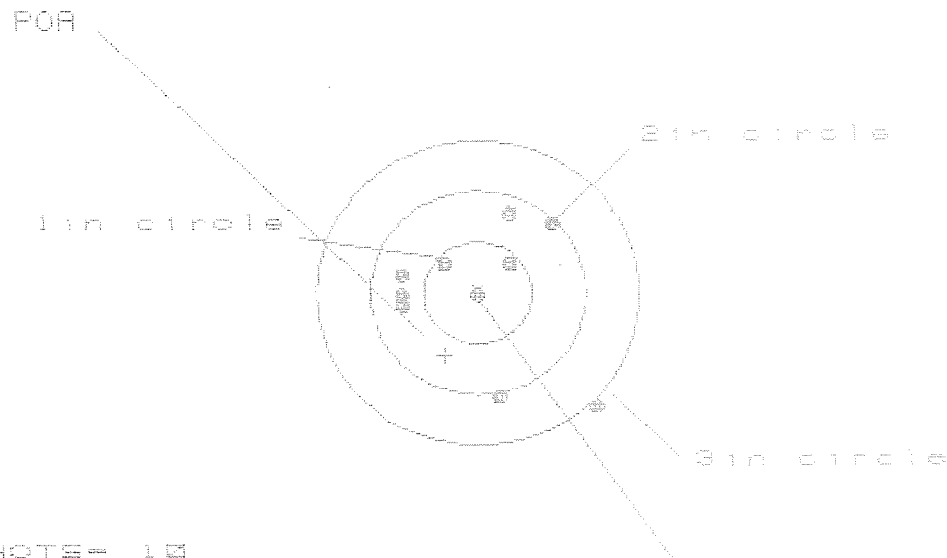
GS= 2.795

PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.815	.629	.569
MINIMUM X	-1.676	-1.386	-1.388
MAXIMUM Y	1.440	1.460	.706
MINIMUM Y	-.789	-.769	-.587
CENTROID X	-.071	.113	.037
CENTROID Y	1.770	1.750	1.568
FOR TO CENTROID in.	1.771	1.754	1.568
MIN RADIUS	.408	.292	.198
MEAN RADIUS	.913	.788	.652
MAX RADIUS	1.685	1.589	1.344
HORIZONTAL SPREAD	2.491	2.015	1.877
VERTICAL SPREAD	2.229	2.229	1.293
EXTREME SPREAD	2.795	2.417	1.915
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	8		

10 May 1988

FILE:/PATTERNING/CENTERFIRE_PATT/08225529

CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1 in = 3

2 in = 8

3 in = 9

HS= 1.791

VS= 1.855

GS= 2.139

CENTROID X

PATTERN #	5	5	6
SHOTS (BEST OF)	10	5	6
MAXIMUM X	1.055	.774	.909
MINIMUM X	-.736	-.619	-.584
MAXIMUM Y	.781	.662	.520
MINIMUM Y	-1.074	-1.132	-.345
CENTROID X	.308	.191	.156
CENTROID Y	.620	.739	.881
POA TO CENTROID in.	.692	.763	.894
MIN RADIUS	.860	.197	.114
MEAN RADIUS	.732	.619	.539
MAX RADIUS	1.505	1.166	.933
HORIZONTAL SPREAD	1.791	1.393	1.393
VERTICAL SPREAD	1.855	1.794	.865
EXTREME SPREAD	2.139	1.809	1.611
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		8	
NUMBER IN THREE INCH CIRCLE =		9	