

G669 5359

Replaces

C6587631

## Arms Services Repair &amp; Estimate System

File Add Repair Estimate Repair Expedite Repair Inquiry Repair Tools CSR Tools Reports Table Maintenance System Maintenance Help

## Repair Inquiry

Repair Number: RE00156475

Serial: C6587631 Model M24 SWS Center Fire  
Caliber: 7.62 NATO Produced: 12/18/1990

Repairman:

Verify Repair

Status:

Closed 12/6/2008 7:41:08 AM

## 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 MAIL STOP 181

PO Box:

BOX 339500 MAIL STOP 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   |
| A008 | With Swivel           | 2   |
| A010 | Hard Case A 2         | 1   |
| A017 | Scope Base            | 1   |
| A045 | BiPod                 | 1   |
| A057 | Fit and Rear Sgt Base | 1   |

Repair Search

Refresh

Close

nagletj

12/8/2008

12:26 PM

CAPS

NUM

INS

SCRL



12:26 PM

66695359

**C6587631**

Model: M24 SWS



RE00156475

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

R & E NUMBER 156475  
SERIAL NUMBER ~~06587631~~  
LOG-IN DATE 12-6-08

06695359

| OPERATION # | OPERATION NAME       | DATE                     | INITIAL     |
|-------------|----------------------|--------------------------|-------------|
| 500         | DIS-ASSEMBLE GUN     | 12-8-08                  | RTZ         |
| 505         | RE-BARREL            | 12-10-08                 | RTZ         |
| 560         | ASSEMBLE             | 12-11-08                 | RTZ         |
| 600         | PROOF                | 12-15-08                 | RTZ         |
| 605         | CHECK HEADSPACE      | 12-15-08                 | RTZ         |
| 610         | DIS-ASSEMBLE GUN     | 12-15-08                 | RTZ         |
| 612         | MAGNAFLUX            | 12-15-08                 | RTZ         |
| 510         | DRILL AND TAP        | 12-15-08                 | RTZ         |
| 615         | ROLLMARK CALIBER     | 12-15-08                 | RTZ         |
| 618         | ROTO-BLAST           | 1-1-09                   | RTZ         |
| 620         | APPLY COATINGS       | 1-1-09                   | RTZ         |
| 625         | FINAL ASSEMBLY       | 1-8-09                   | RTZ         |
| 640         | FUNCTION TEST AND    | 1-8-09                   | RTZ         |
| 650         | TARGET               | 1-8-09                   | RTZ         |
|             | MALFUNCTION          | CORRECTION               |             |
|             | MALFUNCTION          | CORRECTION               |             |
|             | MALFUNCTION          | CORRECTION               |             |
|             | MALFUNCTION          | CORRECTION               |             |
| 670         | FINAL INSPECTION     | 1-12-09                  | RTZ         |
|             | A) HEADSPACE         | 1-12-09                  | RTZ         |
|             | B) TRIGGER PULL      | 2.24 2.22 2.20 2.24 2.22 | 1-12-09 RTZ |
| 680         | F) SAFETY ON FORCE   | 4.0 4.0 3.0              | 1-12-09 RTZ |
|             | G) SAFETY OFF FORCE  | 5.0 6.0 6.0              | 1-12-09 RTZ |
|             | I) FIRING PIN INDENT | -0.022 -0.022 -0.022     | 1-12-09 RTZ |
| 690         | PACK                 | 1-12-09                  | RTZ         |

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6695359. \_\_0

FILE DATE AND TIME: 01/09/2009 07:13

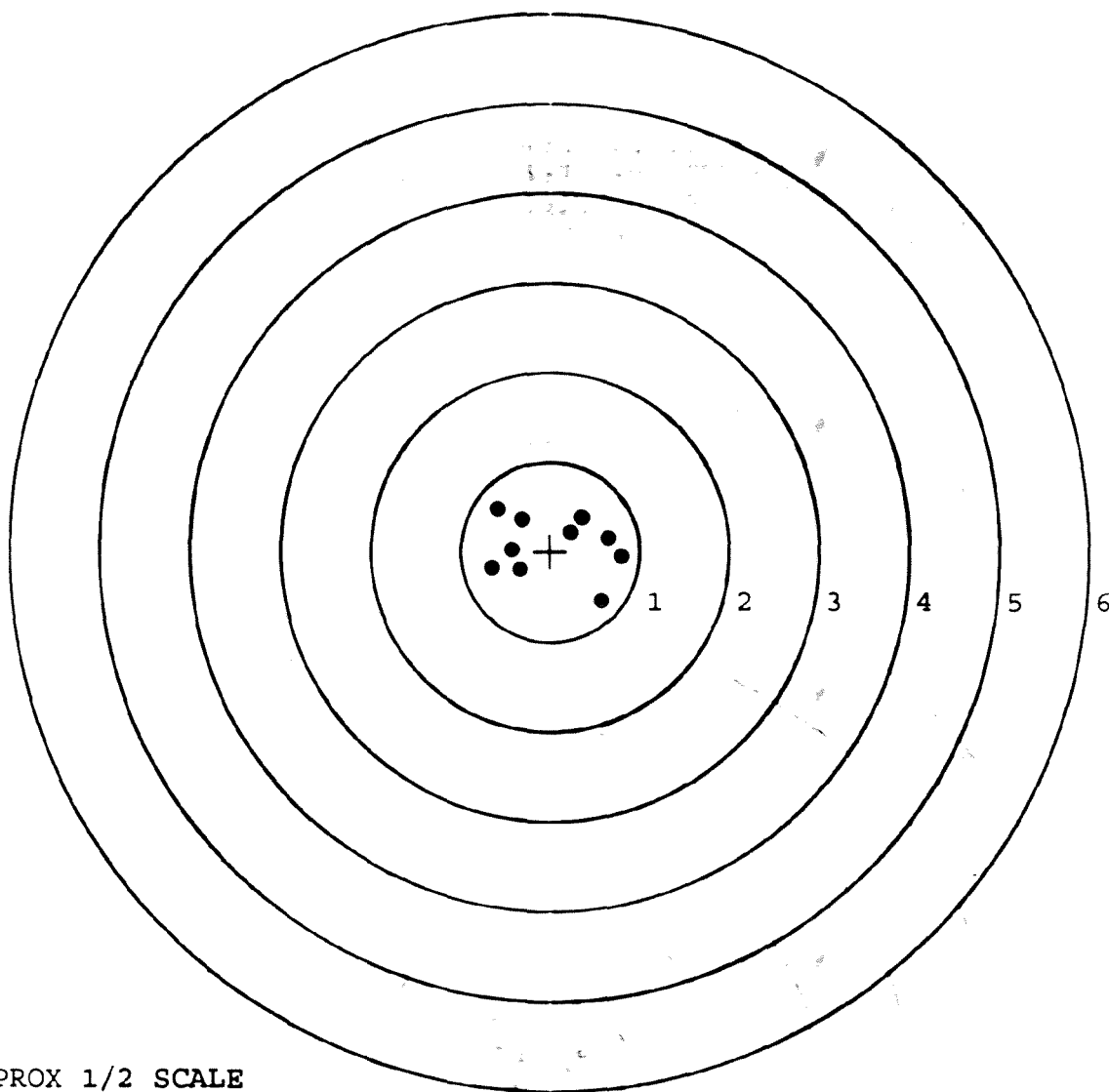
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

|                                                             |        |
|-------------------------------------------------------------|--------|
| The Average X Centroid of the Five Target Set:              | 0.119  |
| The Average Y Centroid of the Five Target Set:              | -0.025 |
| The Average Point of Impact of the Five Target Set:         | 0.122  |
| The Average Mean Radius of the Five Target Set:             | 0.663  |
| The Distance from POA to Centroid Target #1:                | 0.063  |
| The Distance from Centroid Target #2 to Centroid Target #1: | 0.120  |
| The Distance from Centroid Target #3 to Centroid Target #1: | 0.248  |
| The Distance from Centroid Target #4 to Centroid Target #1: | 0.180  |
| The Distance from Centroid Target #5 to Centroid Target #1: | 0.080  |

SERIAL NUMBER: G6695359. \_\_0  
TARGET NUMBER: 1  
FILE DATE: 01/09/2009  
FILE TIME: 07:13

| POINT# | X      | Y      |
|--------|--------|--------|
| 1:     | 0.568  | -0.547 |
| 2:     | 0.797  | -0.059 |
| 3:     | 0.646  | 0.155  |
| 4:     | 0.353  | 0.376  |
| 5:     | 0.230  | 0.207  |
| 6:     | -0.320 | 0.350  |
| 7:     | -0.588 | 0.469  |
| 8:     | -0.432 | 0.019  |
| 9:     | -0.337 | -0.212 |
| 10:    | -0.651 | -0.190 |

X CENTROID: 0.027  
Y CENTROID: 0.057  
POA TO CENTROID: 0.063  
HORZ SPREAD: 1.448  
VERT SPREAD: 1.016  
GROUP SPREAD: 1.539  
MIN RADIUS: 0.253  
MAX RADIUS: 0.811  
MEAN RADIUS: 0.575  
# IN 1 IN DIAMETER: 5  
# IN 2 IN DIAMETER: 10  
# in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6695359. \_\_0

TARGET NUMBER: 2

FILE DATE: 01/09/2009

FILE TIME: 07:13

| POINT# | X      | Y      |
|--------|--------|--------|
| 1:     | -0.389 | -1.041 |
| 2:     | -0.021 | -0.767 |
| 3:     | -0.419 | -0.089 |
| 4:     | 0.805  | -0.492 |
| 5:     | 0.334  | -0.143 |
| 6:     | 0.472  | -0.054 |
| 7:     | 0.298  | 0.298  |
| 8:     | 0.336  | 0.552  |
| 9:     | 0.135  | 0.701  |
| 10:    | -0.282 | 0.952  |

X CENTROID: 0.127

Y CENTROID: -0.008

POA TO CENTROID: 0.127

HORZ SPREAD: 1.224

VERT SPREAD: 1.993

GROUP SPREAD: 1.996

MIN RADIUS: 0.247

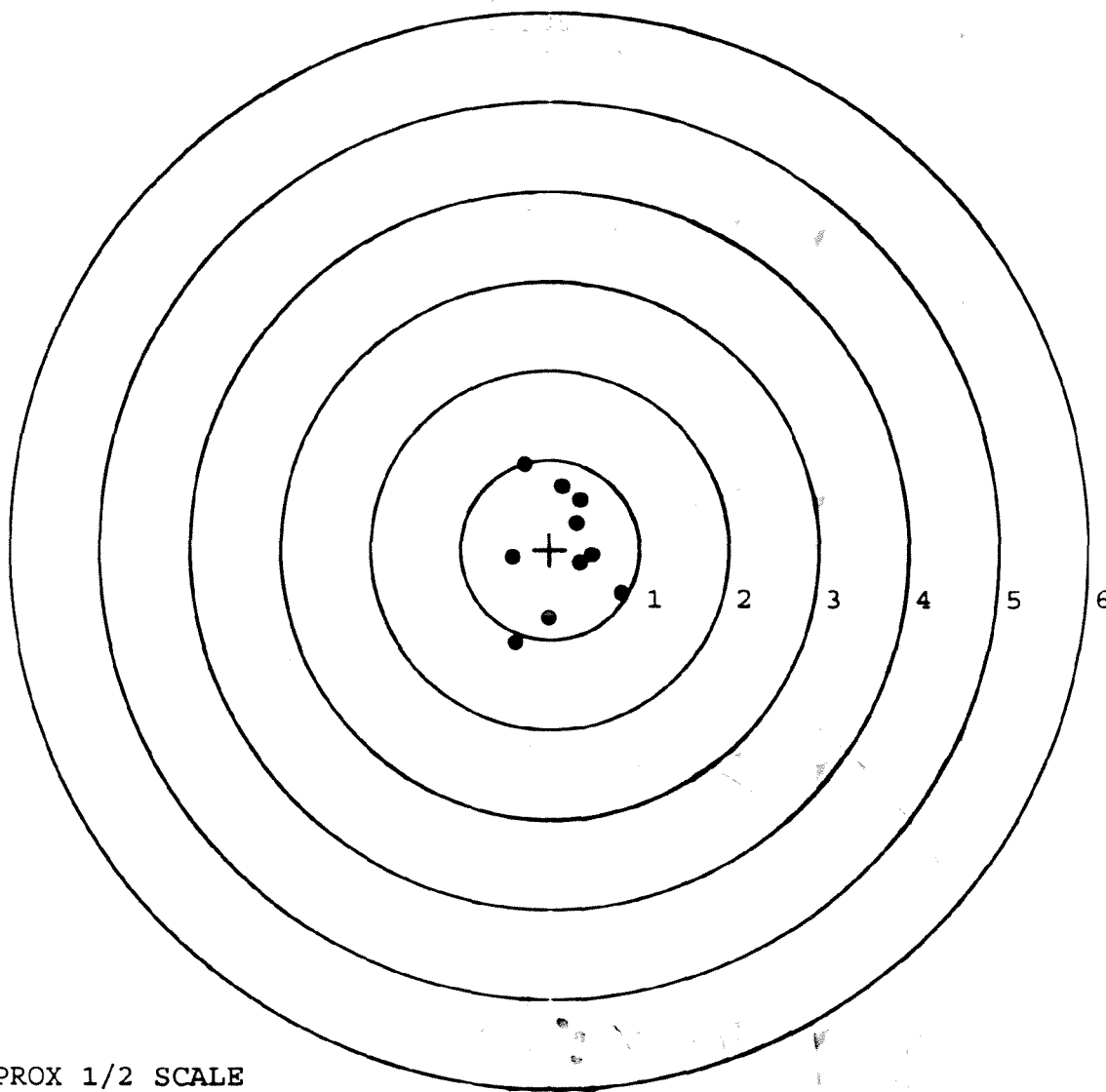
MAX RADIUS: 1.154

MEAN RADIUS: 0.661

# IN 1 IN DIAMETER: 3

# IN 2 IN DIAMETER: 8

# in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6695359. 0

TARGET NUMBER: 3

FILE DATE: 01/09/2009

FILE TIME: 07:13

| POINT# | X | Y |
|--------|---|---|
|--------|---|---|

|    |        |        |
|----|--------|--------|
| 1: | -0.284 | -1.284 |
|----|--------|--------|

|    |       |        |
|----|-------|--------|
| 2: | 0.217 | -0.710 |
|----|-------|--------|

|    |       |        |
|----|-------|--------|
| 3: | 0.474 | -0.668 |
|----|-------|--------|

|    |       |        |
|----|-------|--------|
| 4: | 0.607 | -0.619 |
|----|-------|--------|

|    |       |        |
|----|-------|--------|
| 5: | 0.821 | -0.609 |
|----|-------|--------|

|    |       |       |
|----|-------|-------|
| 6: | 0.583 | 0.420 |
|----|-------|-------|

|    |       |       |
|----|-------|-------|
| 7: | 0.251 | 0.244 |
|----|-------|-------|

|    |       |       |
|----|-------|-------|
| 8: | 0.078 | 0.672 |
|----|-------|-------|

|    |        |       |
|----|--------|-------|
| 9: | -0.191 | 0.799 |
|----|--------|-------|

|     |        |       |
|-----|--------|-------|
| 10: | -0.499 | 0.603 |
|-----|--------|-------|

X CENTROID: 0.206

Y CENTROID: -0.115

POA TO CENTROID: 0.236

HORZ SPREAD: 1.320

VERT SPREAD: 2.083

GROUP SPREAD: 2.085

MIN RADIUS: 0.362

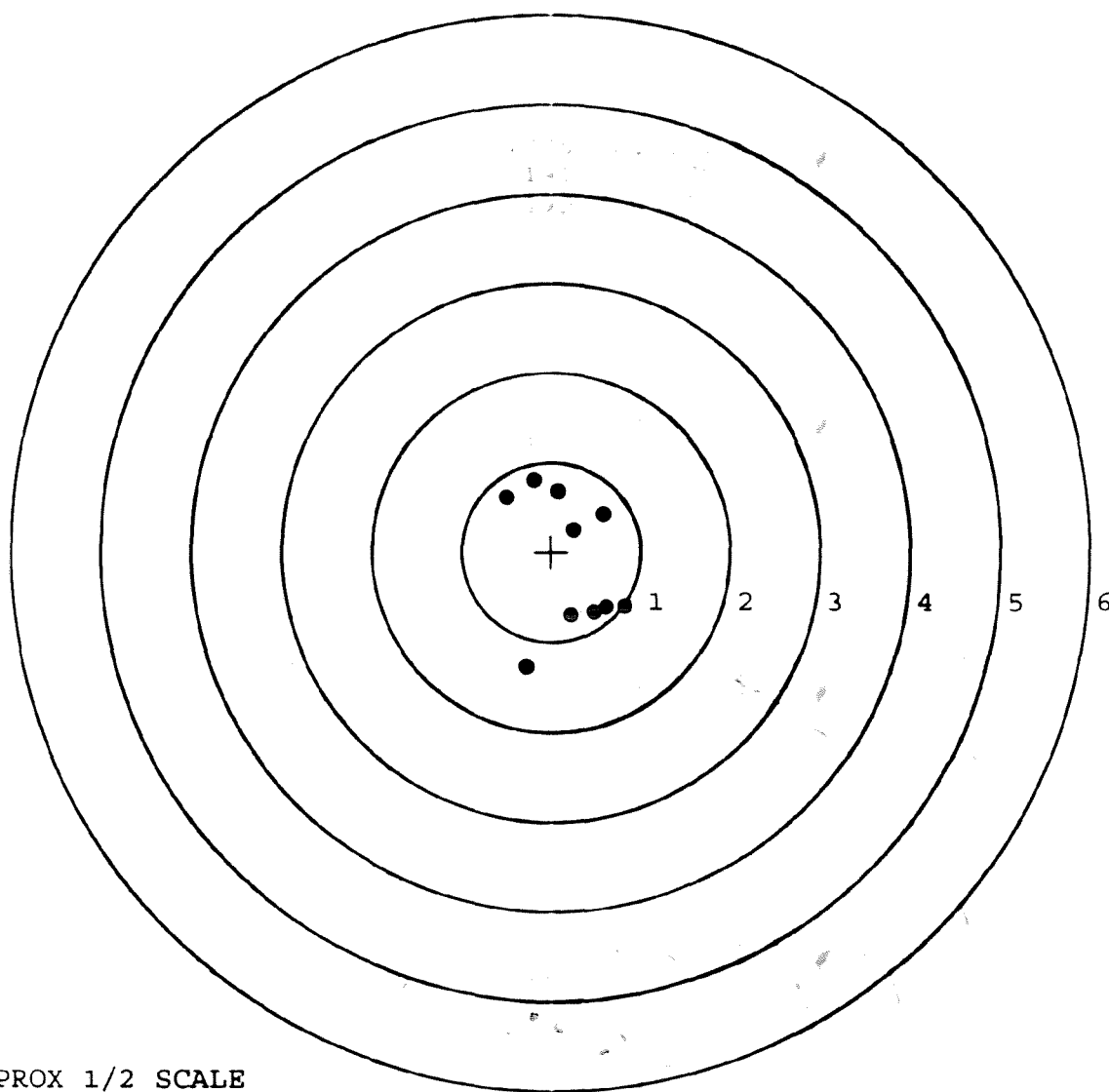
MAX RADIUS: 1.267

MEAN RADIUS: 0.773

# IN 1 IN DIAMETER: 1

# IN 2 IN DIAMETER: 8

# in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6695359. \_\_0

TARGET NUMBER: 4

FILE DATE: 01/09/2009

FILE TIME: 07:13

| POINT# | X | Y |
|--------|---|---|
|--------|---|---|

|    |        |        |
|----|--------|--------|
| 1: | -0.635 | -0.910 |
|----|--------|--------|

|    |       |        |
|----|-------|--------|
| 2: | 0.049 | -0.874 |
|----|-------|--------|

|    |        |        |
|----|--------|--------|
| 3: | -0.521 | -0.150 |
|----|--------|--------|

|    |        |       |
|----|--------|-------|
| 4: | -0.622 | 0.175 |
|----|--------|-------|

|    |       |        |
|----|-------|--------|
| 5: | 0.405 | -0.488 |
|----|-------|--------|

|    |       |        |
|----|-------|--------|
| 6: | 0.431 | -0.084 |
|----|-------|--------|

|    |       |       |
|----|-------|-------|
| 7: | 0.616 | 0.100 |
|----|-------|-------|

|    |       |       |
|----|-------|-------|
| 8: | 0.826 | 0.266 |
|----|-------|-------|

|    |       |       |
|----|-------|-------|
| 9: | 0.505 | 0.664 |
|----|-------|-------|

|     |       |       |
|-----|-------|-------|
| 10: | 0.328 | 0.453 |
|-----|-------|-------|

X CENTROID: 0.138

Y CENTROID: -0.085

POA TO CENTROID: 0.162

HORZ SPREAD: 1.461

VERT SPREAD: 1.574

GROUP SPREAD: 1.943

MIN RADIUS: 0.293

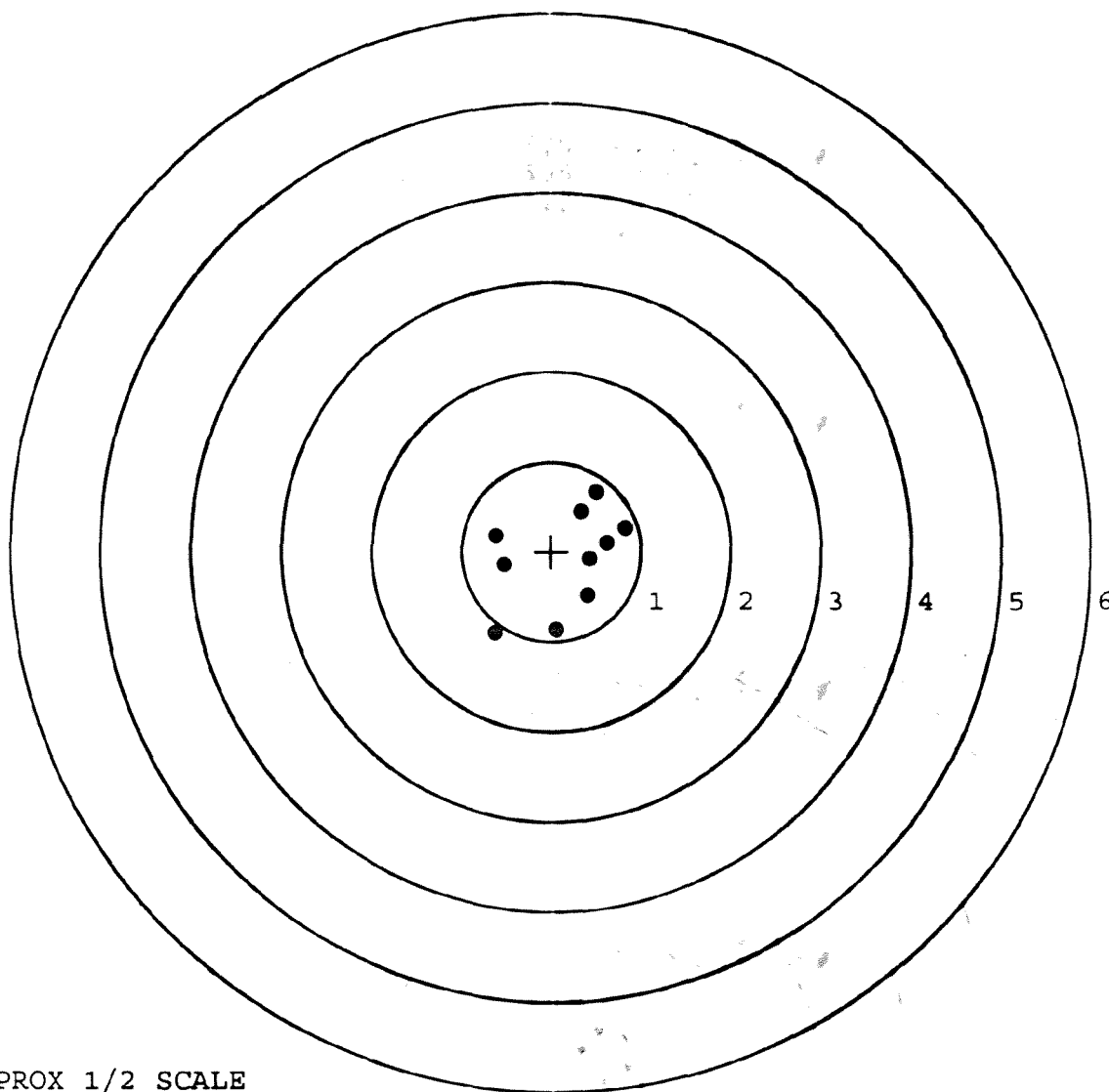
MAX RADIUS: 1.131

MEAN RADIUS: 0.686

# IN 1 IN DIAMETER: 2

# IN 2 IN DIAMETER: 9

# in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6695359. 0

TARGET NUMBER: 5

FILE DATE: 01/09/2009

FILE TIME: 07:13

POINT# X Y

1: -0.852 -0.699

2: -0.150 -0.589

3: 0.665 -0.405

4: 0.347 -0.158

5: 0.576 0.017

6: 0.731 0.267

7: 0.235 0.756

8: 0.047 0.494

9: -0.266 0.416

10: -0.333 0.143

X CENTROID: 0.100

Y CENTROID: 0.024

POA TO CENTROID: 0.103

HORZ SPREAD: 1.583

VERT SPREAD: 1.455

GROUP SPREAD: 1.854

MIN RADIUS: 0.307

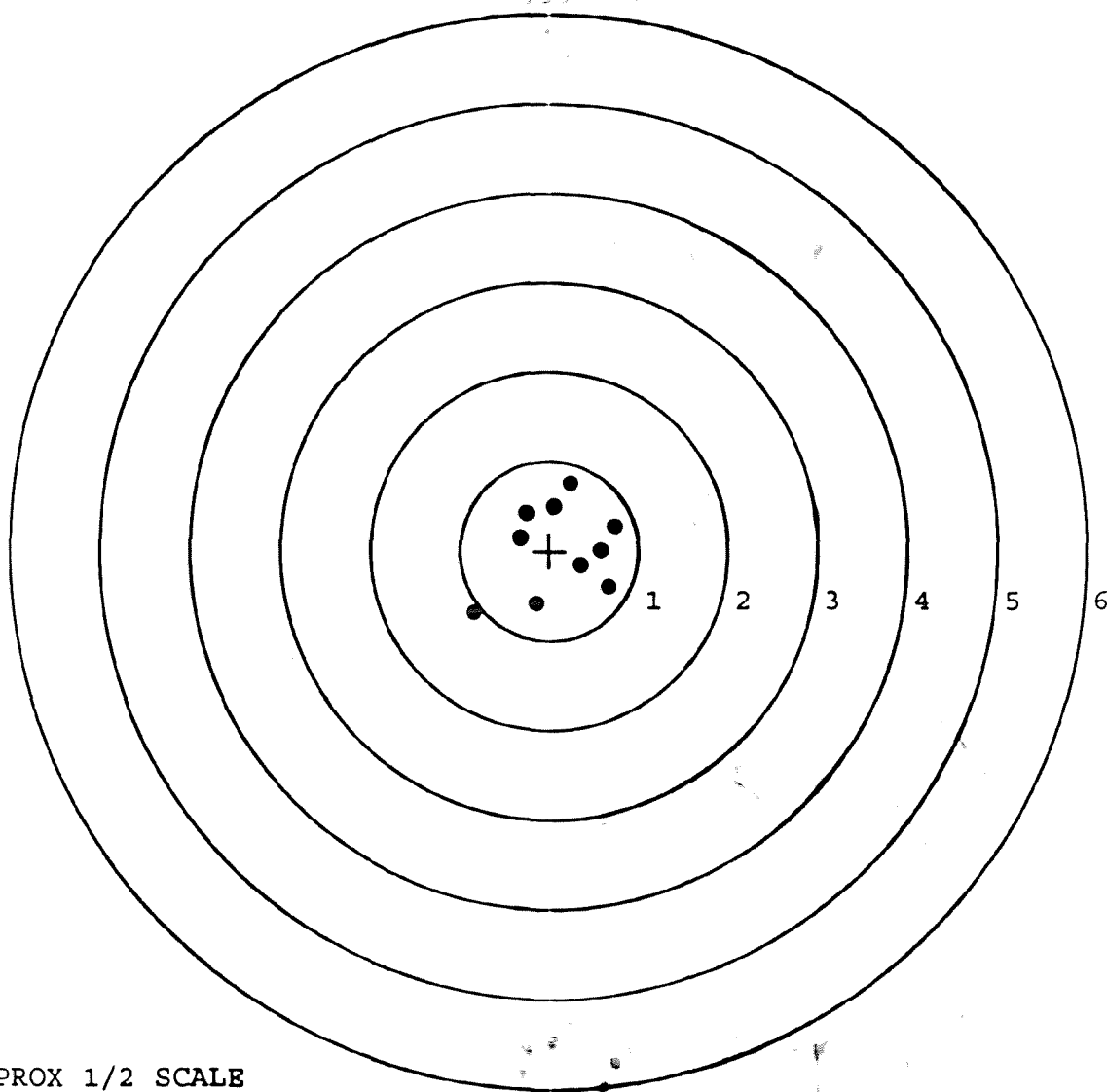
MAX RADIUS: 1.196

MEAN RADIUS: 0.623

# IN 1 IN DIAMETER: 4

# IN 2 IN DIAMETER: 9

# in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

Army 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: **RE00106762** Serial: C6587631 Model: M24 SWS Center Fire Caliber: 7.62 NATO Repairman: Status: Closed 1/16/2006 8:53:16 AM

Verify Repair

**Address Information**

Customer: ☒ Received From: Return To: ☐ Received From:

Name: **JOINT TRANSPORT DIV** **JOINT TRANSPORT DIV**

Address 1: **BLDG 9611** **BLDG 9611**

Address 2:  PO Box:   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: **253-966-5597** Fax:  Email:  Comments:

Received Condition: Fair Condition Notes:  CSR Notes:

Accessories Received:

| Code | Desc                  | Qty |
|------|-----------------------|-----|
| A007 | With Stud             | 3   |
| A017 | Scope Base            | 1   |
| A045 | Bi Pod                | 1   |
| A057 | Frt and Rear Sgt Base | 1   |
| C000 | WOOD CASE             | 1   |

Repair Search Refresh Close

magletj 1/16/2006 8:53 AM CAPS NUM IHS SCPL

start 3 Arms Service 4 2

Serial Number: **C6587631**

Model: **M24 SWS**



**RE00106762**

ATTN: Remington Arms Co. Inc.

The deficiencies on the M24 SWS contained herein are as follows:

C6587631:

- No scope
- Barrel not free-floating

C6587630:

- Buttstock can't adjust (held on with 100mph tape)
- Bipod can't adjust (held together with 100mph tape)
- No scope

Both rifles were missing all BII. Please contact our unit with information regarding the replacement of the following items:

- Soft carrying case
- Sling
- Deployment case
- Day optic sight case
- System case
- Scope

Please direct any questions or information to the following personnel:

CPT Joshua Dailey  
HHT 1/2 CR XO  
Comm: (253) 966-5587  
DSN: 347-5587

1SG John Horney  
HHT 1/2 CR 1SG  
Comm: (253) 966-5524  
DSN: 347-5524

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6587631.\_\_\_0  
FILE DATE AND TIME: 01/26/2006 12:49

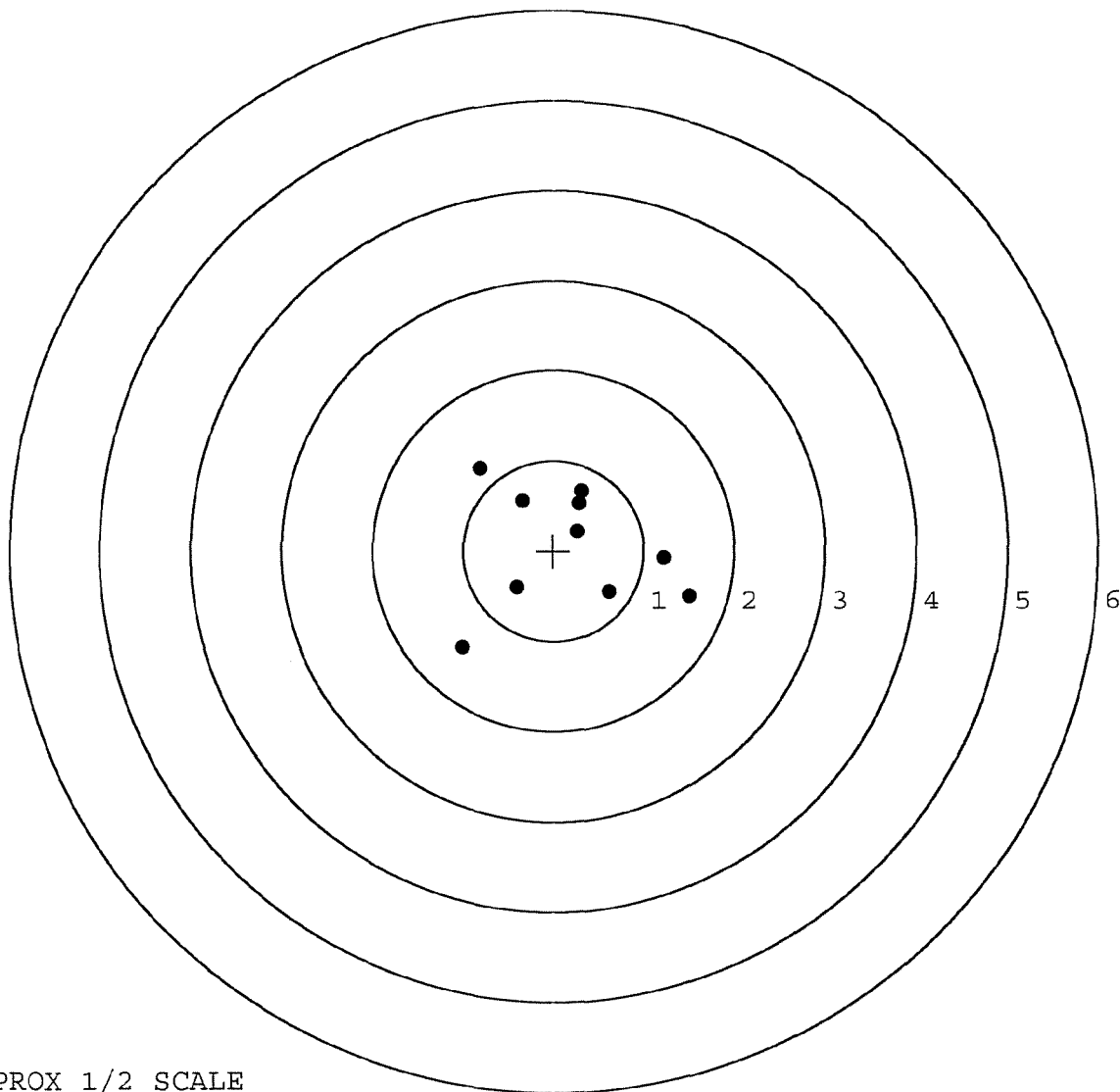
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

|                                                             |       |
|-------------------------------------------------------------|-------|
| The Average X Centroid of the Five Target Set:              | 0.066 |
| The Average Y Centroid of the Five Target Set:              | 0.018 |
| The Average Point of Impact of the Five Target Set:         | 0.069 |
| The Average Mean Radius of the Five Target Set:             | 0.803 |
| The Distance from POA to Centroid Target #1:                | 0.167 |
| The Distance from Centroid Target #2 to Centroid Target #1: | 0.162 |
| The Distance from Centroid Target #3 to Centroid Target #1: | 0.138 |
| The Distance from Centroid Target #4 to Centroid Target #1: | 0.114 |
| The Distance from Centroid Target #5 to Centroid Target #1: | 0.209 |

SERIAL NUMBER: C6587631. \_\_0  
TARGET NUMBER: 1  
FILE DATE: 01/26/2006  
FILE TIME: 12:49

| POINT# | X      | Y      |
|--------|--------|--------|
| 1:     | 1.505  | -0.508 |
| 2:     | 1.223  | -0.083 |
| 3:     | 0.617  | -0.457 |
| 4:     | -0.403 | -0.408 |
| 5:     | 0.266  | 0.220  |
| 6:     | 0.280  | 0.533  |
| 7:     | 0.313  | 0.661  |
| 8:     | -0.346 | 0.560  |
| 9:     | -0.813 | 0.914  |
| 10:    | -1.010 | -1.074 |

X CENTROID: 0.163  
Y CENTROID: 0.036  
POA TO CENTROID: 0.167  
HORZ SPREAD: 2.515  
VERT SPREAD: 1.988  
GROUP SPREAD: 2.578  
MIN RADIUS: 0.211  
MAX RADIUS: 1.615  
MEAN RADIUS: 0.893  
# IN 1 IN DIAMETER: 1  
# IN 2 IN DIAMETER: 6  
# in 3 IN DIAMETER: 9

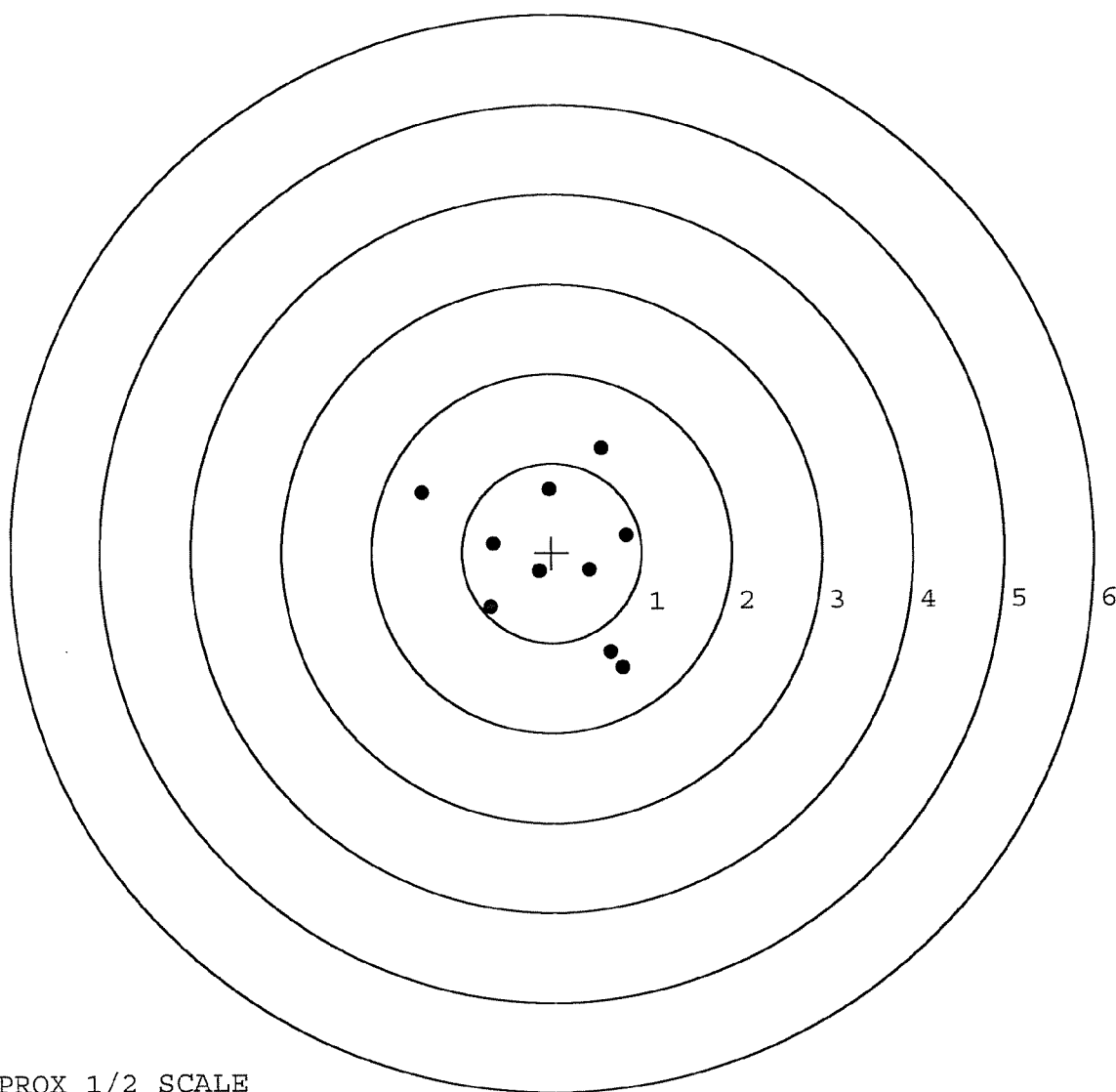


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6587631. \_\_0  
TARGET NUMBER: 2  
FILE DATE: 01/26/2006  
FILE TIME: 12:49

| POINT# | X      | Y      |
|--------|--------|--------|
| 1:     | 0.782  | -1.282 |
| 2:     | 0.651  | -1.113 |
| 3:     | 0.827  | 0.188  |
| 4:     | 0.416  | -0.195 |
| 5:     | -0.142 | -0.208 |
| 6:     | -0.680 | -0.611 |
| 7:     | -0.652 | 0.102  |
| 8:     | -1.434 | 0.677  |
| 9:     | -0.032 | 0.710  |
| 10:    | 0.560  | 1.165  |

X CENTROID: 0.030  
Y CENTROID: -0.057  
POA TO CENTROID: 0.064  
HORZ SPREAD: 2.261  
VERT SPREAD: 2.447  
GROUP SPREAD: 2.958  
MIN RADIUS: 0.229  
MAX RADIUS: 1.637  
MEAN RADIUS: 0.948  
# IN 1 IN DIAMETER: 2  
# IN 2 IN DIAMETER: 6  
# in 3 IN DIAMETER: 9

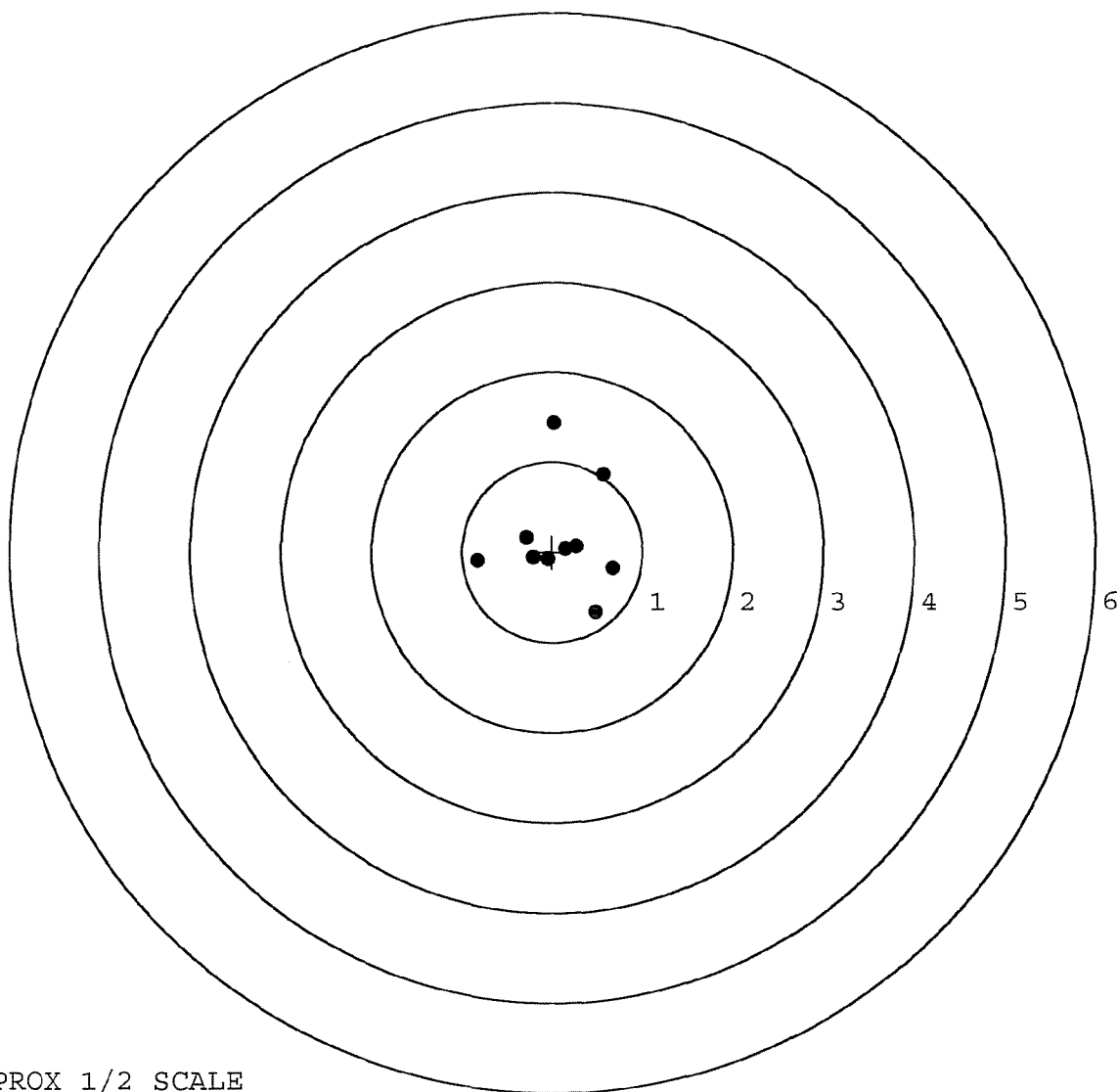


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6587631. \_\_0  
TARGET NUMBER: 3  
FILE DATE: 01/26/2006  
FILE TIME: 12:49

| POINT# | X      | Y      |
|--------|--------|--------|
| 1:     | 0.483  | -0.662 |
| 2:     | 0.675  | -0.177 |
| 3:     | 0.569  | 0.862  |
| 4:     | 0.019  | 1.427  |
| 5:     | -0.820 | -0.100 |
| 6:     | -0.290 | 0.161  |
| 7:     | -0.209 | -0.064 |
| 8:     | -0.050 | -0.084 |
| 9:     | 0.153  | 0.038  |
| 10:    | 0.271  | 0.061  |

X CENTROID: 0.080  
Y CENTROID: 0.146  
POA TO CENTROID: 0.167  
HORZ SPREAD: 1.495  
VERT SPREAD: 2.089  
GROUP SPREAD: 2.140  
MIN RADIUS: 0.130  
MAX RADIUS: 1.282  
MEAN RADIUS: 0.599  
# IN 1 IN DIAMETER: 5  
# IN 2 IN DIAMETER: 9  
# in 3 IN DIAMETER: 10

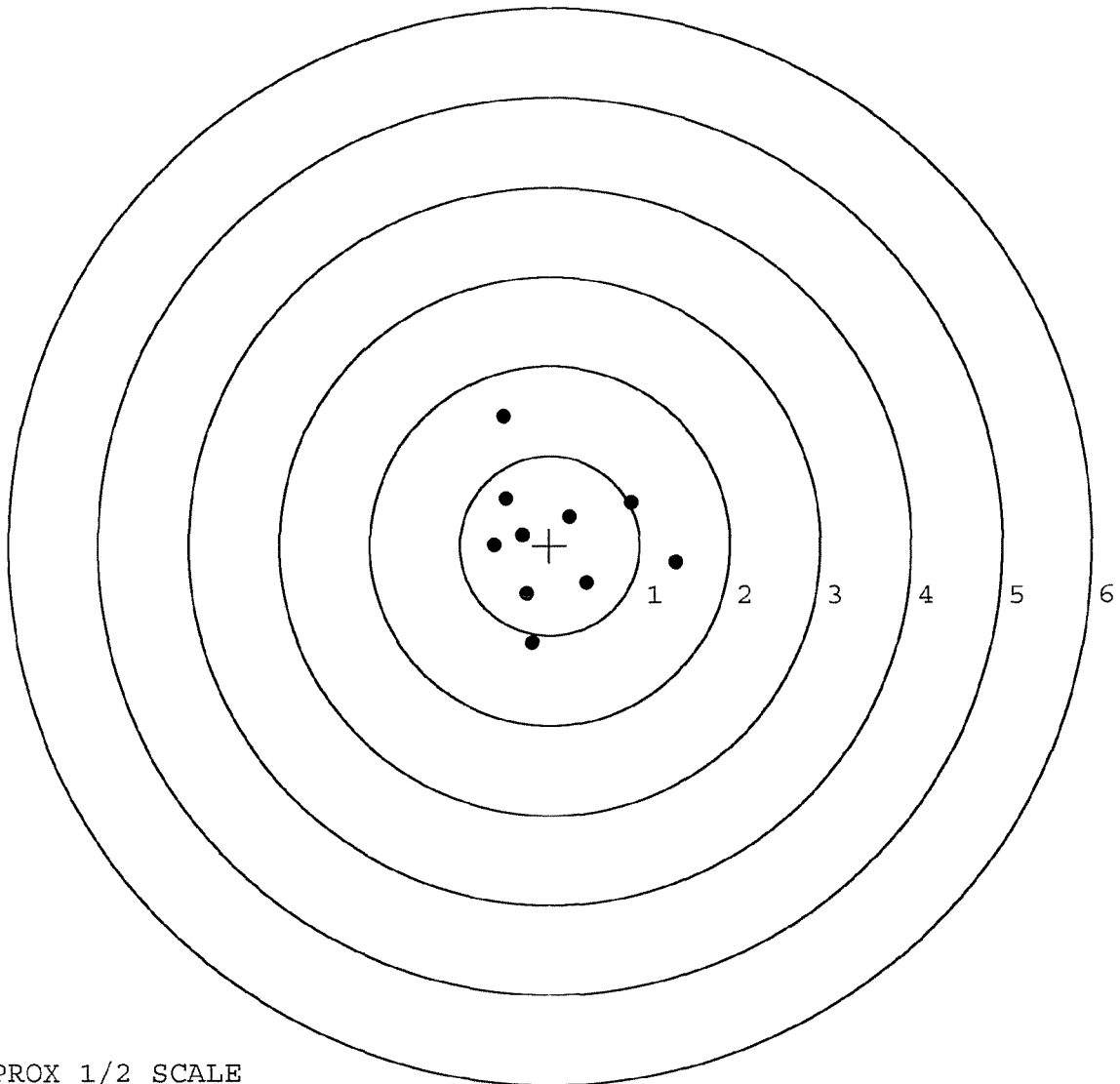


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6587631. \_\_0  
TARGET NUMBER: 4  
FILE DATE: 01/26/2006  
FILE TIME: 12:49

| POINT# | X      | Y      |
|--------|--------|--------|
| 1:     | 1.400  | -0.188 |
| 2:     | 0.905  | 0.484  |
| 3:     | 0.409  | -0.418 |
| 4:     | 0.216  | 0.322  |
| 5:     | -0.197 | -1.087 |
| 6:     | -0.256 | -0.544 |
| 7:     | -0.618 | 0.009  |
| 8:     | -0.310 | 0.114  |
| 9:     | -0.493 | 0.524  |
| 10:    | -0.520 | 1.438  |

X CENTROID: 0.054  
Y CENTROID: 0.065  
POA TO CENTROID: 0.085  
HORZ SPREAD: 2.018  
VERT SPREAD: 2.525  
GROUP SPREAD: 2.546  
MIN RADIUS: 0.304  
MAX RADIUS: 1.488  
MEAN RADIUS: 0.833  
# IN 1 IN DIAMETER: 2  
# IN 2 IN DIAMETER: 7  
# in 3 IN DIAMETER: 10

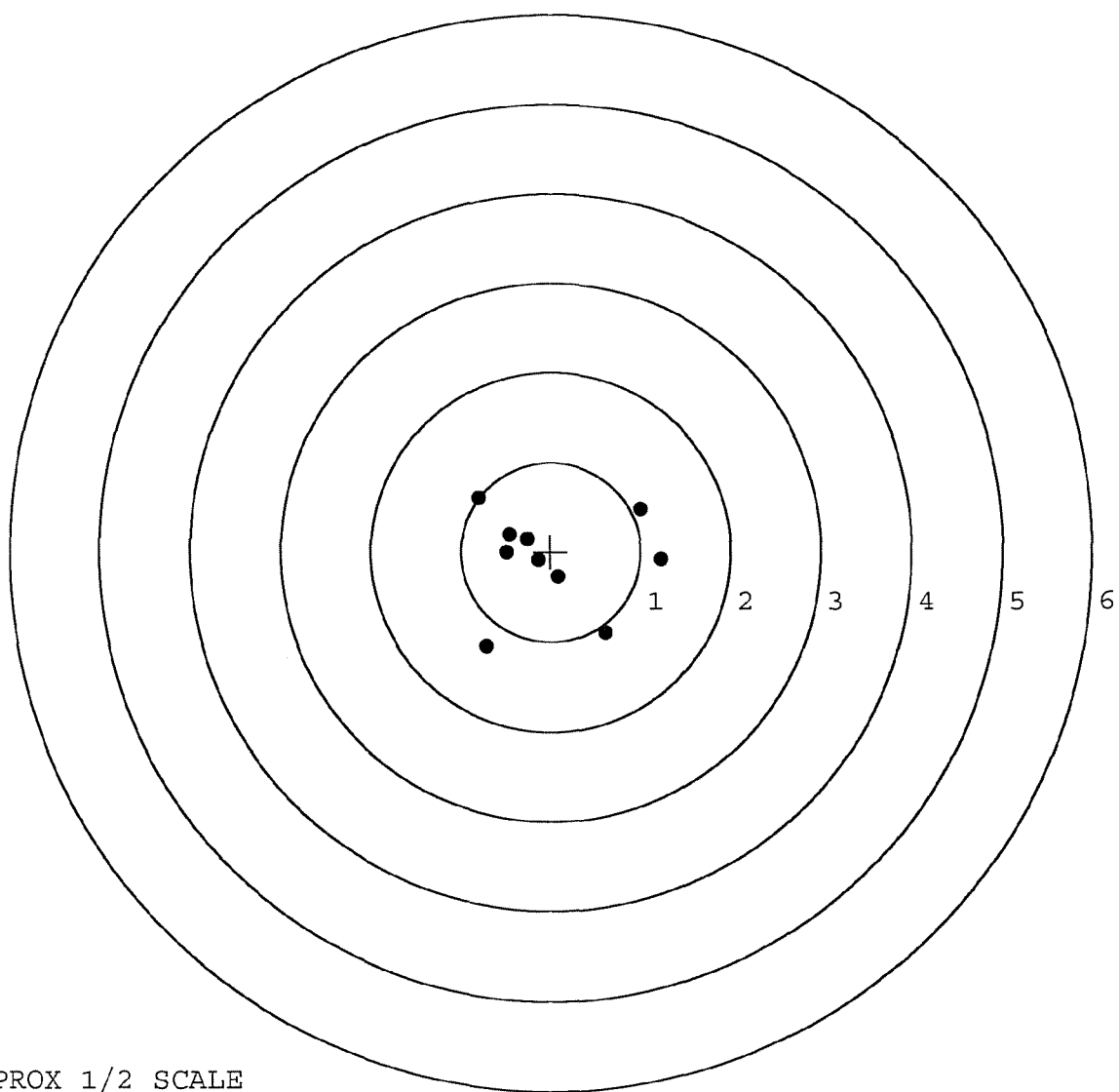


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6587631. \_\_0  
TARGET NUMBER: 5  
FILE DATE: 01/26/2006  
FILE TIME: 12:49

| POINT# | X      | Y      |
|--------|--------|--------|
| 1:     | 1.232  | -0.088 |
| 2:     | 1.000  | 0.476  |
| 3:     | 0.611  | -0.901 |
| 4:     | -0.714 | -1.057 |
| 5:     | 0.085  | -0.281 |
| 6:     | -0.136 | -0.097 |
| 7:     | -0.264 | 0.144  |
| 8:     | -0.493 | -0.011 |
| 9:     | -0.465 | 0.195  |
| 10:    | -0.803 | 0.605  |

X CENTROID: 0.005  
Y CENTROID: -0.102  
POA TO CENTROID: 0.102  
HORZ SPREAD: 2.035  
VERT SPREAD: 1.662  
GROUP SPREAD: 2.174  
MIN RADIUS: 0.141  
MAX RADIUS: 1.227  
MEAN RADIUS: 0.741  
# IN 1 IN DIAMETER: 3  
# IN 2 IN DIAMETER: 5  
# in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

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

|               |                      |                                    |             |
|---------------|----------------------|------------------------------------|-------------|
| R & E NUMBER  | 106762               | New scope 185433 N                 |             |
| SERIAL NUMBER | 06587631             |                                    |             |
| LOG-IN DATE   | 1-16-06              |                                    |             |
| OPERATION #   | OPERATION NAME       | DATE                               | INITIAL     |
| 500           | DIS-ASSEMBLE GUN     | 1-17-06                            | RTZ         |
| 505           | RE-BARREL            | 1-18-06                            | RTZ         |
| 560           | ASSEMBLE             | 1-18-06                            | RTZ         |
| 600           | PROOF                | MAGNA-FLUX<br>INSPECTED<br>1-18-06 | RTZ         |
| 605           | CHECK HEADSPACE      | 1-18-06                            | RTZ         |
| 610           | DIS-ASSEMBLE GUN     | JAN 20 2006                        |             |
| 612           | MAGNAFLUX            | OPERATOR <u>CPD</u>                | 1-20-06 APD |
| 510           | DRILL AND TAP        | 1-19-06                            | TRW         |
| 615           | ROLLMARK CALIBER     | 1-19-06                            | CW          |
| 618           | ROTO-BLAST           | 1-20-06                            | LB          |
| 620           | APPLY COATINGS       | 1-23                               | HP          |
| 625           | FINAL ASSEMBLY       | 1-25-06                            | AC          |
| 640           | FUNCTION TEST AND    | <u>PASS</u> FAIL                   | 1-26-06 TRW |
| 650           | TARGET               | <u>PASS</u> FAIL                   |             |
|               | MALFUNCTION          | CORRECTION                         |             |
|               | MALFUNCTION          | CORRECTION                         |             |
|               | MALFUNCTION          | CORRECTION                         |             |
|               | MALFUNCTION          | CORRECTION                         |             |
| 670           | FINAL INSPECTION     |                                    | 1-26-06 TRW |
|               | A) HEADSPACE         | <u>PASS</u> FAIL                   | 2-7-06 AC   |
|               | B) TRIGGER PULL      | 2.84 2.79 2.85 2.89 2.85           | 2/7/06 DA   |
| 680           | F) SAFETY ON FORCE   | 4.5 4.2 3.5                        | 2/7/06 DA   |
|               | G) SAFETY OFF FORCE  | 2.2 2.0 2.2                        | 2/7/06 DA   |
|               | I) FIRING PIN INDENT | .020                               |             |
| 690           | PACK                 | 1020 1021 1021                     | 2-24-06 DA  |

**Remington**<sup>®</sup> **DUPONT**  
REG. U.S. PAT. & TM. OFF.

**MODEL 700<sup>™</sup> H24**

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

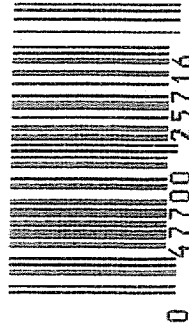
**SERIAL NO.** 06587631

**ORDER NO.** 5716

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

0 47700 25716 7

LPC



Safety Hrs Stock

INSIDE

Repaired

12-12-90 KS

OK

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6587631

| OP. #     | OP. NAME                                                 | READINGS         | DATE     | INIT |
|-----------|----------------------------------------------------------|------------------|----------|------|
| 575 & 580 | Assemble Action and Stock                                | QUALITY<br>AUDIT | 10/22/90 | KS   |
| 600       | Proof                                                    |                  | 10/22/90 | KS   |
| 607       | Check Headspace                                          |                  | 10/22/90 | KS   |
| 610       | Dis-assemble Gun                                         |                  | 10/22/90 | KS   |
| 612       | Magnaflux Barrel Action                                  |                  | 10/24/90 | KR   |
|           | Magnaflux Bolt                                           |                  | 11       | KR   |
| 615       | Rollmark Caliber                                         |                  | 11       | KS   |
| 617       | Drill and Tap Sight Holes                                |                  | 10/25/90 | KS   |
| 618       | Polish Barrel <i>KS</i>                                  |                  | 10/26/90 | KS   |
| 620       | Apply Coatings (Barrel Action)                           |                  | 11-7-90  | KS   |
|           | Apply Coating (Bolt)                                     |                  | 11-7-90  | KS   |
| 625       | Final Assembly                                           |                  | 11/7/90  | KS   |
|           | A) Clean inside of Bolt Assembly                         |                  | 11/7/90  | KS   |
|           | B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head |                  | 11/7/90  | KS   |
|           | C) Inspect Ejector Hole for Chamfer                      |                  | 11/7/90  | KS   |
|           | D) Oil Firing Pin Ass'y                                  |                  | 11/7/90  | KS   |
|           | E) Adjust Trigger Pull to Min Setting and Stake          |                  | 11/28/90 | KS   |

| op. #        | OP. NAME                                                    | READINGS |       |       | DATE     | INIT |
|--------------|-------------------------------------------------------------|----------|-------|-------|----------|------|
| 625<br>cont. | F) Safety On Force                                          | 5        | 5     | 5     | 11/28/90 | WB   |
|              | G) Safety Off Force                                         | 2 1/4    | 2 1/4 | 2 1/4 | 11/28/90 | WB   |
|              | H) Trigger Pull Test & Retainability                        |          |       |       | 11/29/90 | KL   |
|              | I) Firing Pin Indent                                        | .021     | .0212 | .0215 | 11/28/90 | WB   |
|              | J) Assemble Stock                                           |          |       |       | 11/29/90 | KS   |
|              | K) Assemble Swivel Studs                                    |          |       |       | 12-1-90  | JS   |
|              | L) Attach Front and Rear Sight Assemblies                   |          |       |       | 11/29/90 | KS   |
|              | M) Iron Sight Alignment                                     |          |       |       | 11/29/90 | KS   |
|              | N) Detach Front & Rear Sights & place in numbered container |          |       |       | 11/29/90 | KS   |
|              | O) Attach Scope to Rifle                                    |          |       |       | 11/29/90 | KS   |
|              | P) Detach & Attach Scope 20 Times                           |          |       |       | 11/29/90 | KS   |
| 640          | Gallery Target & Test                                       |          |       |       | 11/30/90 | KL   |
|              | A) Time                                                     |          |       |       |          | KL   |
|              | B) Malfunctions                                             |          |       |       |          | KL   |
|              | C) Pierced Primers                                          |          |       |       |          | KL   |
|              | D) Optical Clarity of Scope                                 |          |       |       |          | KL   |
| 645          | Inspect for Live Ammo                                       |          |       |       | 11/30/90 | KL   |
| 655          | Final Inspection                                            |          |       |       |          |      |
|              | A) Headspace                                                |          |       |       | 12-1-90  | JS   |
|              | B) Trigger Pull                                             | 2.39     | 2.38  | 2.37  | 12-1-90  | JS   |
|              | C) Function                                                 |          |       |       | 12-1-90  | JS   |
| 660          | Pack                                                        |          |       |       | 12/14/90 | JS   |

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN  
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. 06587631

DATE 11-28-90

TESTER JL

|         | 2.50#<br>INITIAL | 2.50# AFTER<br>50 CYCLES | FINAL TEST &<br>TO RESET 2.50# |     | COMMENTS                                                               |
|---------|------------------|--------------------------|--------------------------------|-----|------------------------------------------------------------------------|
| PULL #1 | 2.44             | 2.39                     | 2.44                           | 239 | MIN. SETTING,<br>NO AVG. OF 5<br>READINGS ACCEPT-<br>ABLE LESS THAN 2# |
| PULL #2 | 2.37             | 2.44                     | 2.45                           | 238 |                                                                        |
| PULL #3 | 2.50             | 2.38                     | 2.38                           | 237 |                                                                        |
| PULL #4 | 2.47             | 2.40                     | 2.44                           | 240 |                                                                        |
| PULL #5 | 2.42             | 2.43                     | 2.49                           | 243 |                                                                        |
| TOTAL   |                  |                          |                                |     |                                                                        |
| AVG.    |                  |                          |                                |     |                                                                        |

|         | 3.00#<br>INITIAL | 3.00# AFTER<br>20 CYCLES |  | COMMENTS |
|---------|------------------|--------------------------|--|----------|
| PULL #1 | 3.34             | 3.40                     |  |          |
| PULL #2 | 3.30             | 3.39                     |  |          |
| PULL #3 | 3.31             | 3.38                     |  |          |
| PULL #4 | 3.29             | 3.37                     |  |          |
| PULL #5 | 3.29             | 3.37                     |  |          |
| TOTAL   |                  |                          |  |          |
| AVG.    |                  |                          |  |          |

|         | 4.00#<br>INITIAL | 4.00# AFTER<br>20 CYCLES | MAX SETTING<br>GREATER THAN 4# | RESET TO 4# FOR<br>TARGET & ACCURACY |
|---------|------------------|--------------------------|--------------------------------|--------------------------------------|
| PULL #1 | 4.36             | 4.33                     |                                | 4.34                                 |
| PULL #2 | 4.32             | 4.31                     |                                | 4.33                                 |
| PULL #3 | 4.22             | 4.35                     |                                | 4.35                                 |
| PULL #4 | 4.29             | 4.36                     |                                | 4.35                                 |
| PULL #5 | 4.29             | 4.35                     |                                | 4.31                                 |
| TOTAL   |                  |                          |                                |                                      |
| AVG.    |                  |                          |                                |                                      |

CENTROIDAL DISTANCE CALCULATIONS  
FOR RIFLE # 06587631  
30 Nov 1990

CENTROIDAL DISTANCES

|      |   |          |
|------|---|----------|
| 0 TO | 1 | .0534883 |
| 1 TO | 2 | .21422   |
| 1 TO | 3 | .072111  |
| 1 TO | 4 | .390267  |
| 1 TO | 5 | .0807527 |

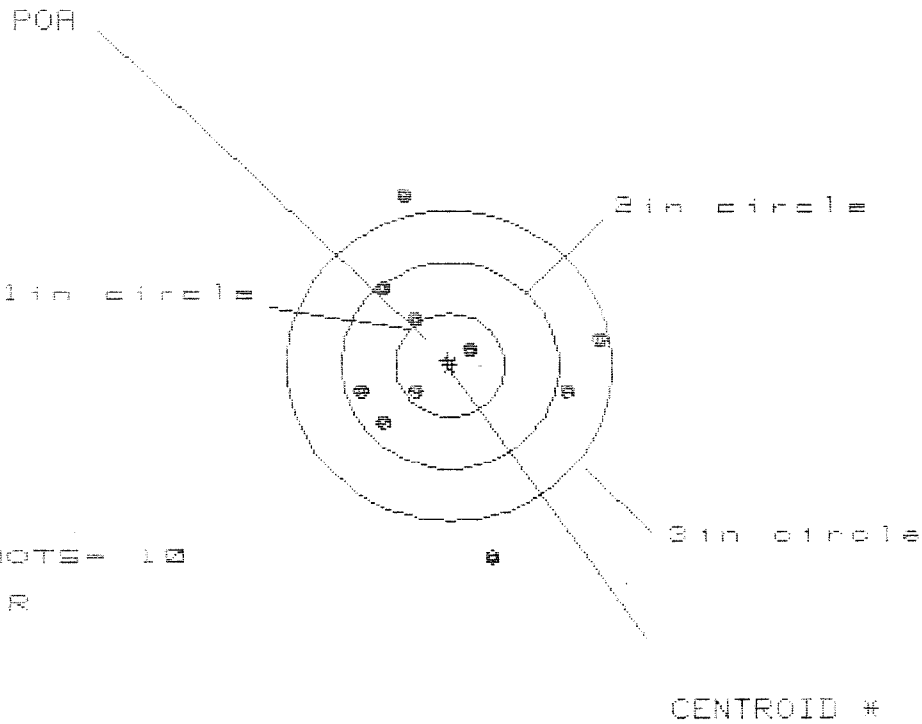
$\frac{a}{2}$  <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0618  
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0066  
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0621514  
THE AMR FOR THIS RIFLE IS: 1.091

30 Nov 1998

FILE:/PATTERNING/CENTERFIRE\_PATT/08587831

# CENTERFIRE PATTERNS # 1



# OF SHOTS- 10

# IN CIR

1 in = 2

2 in = 5

3 in = 8

HS= 2.171

VS= 3.516

GS= 3.611

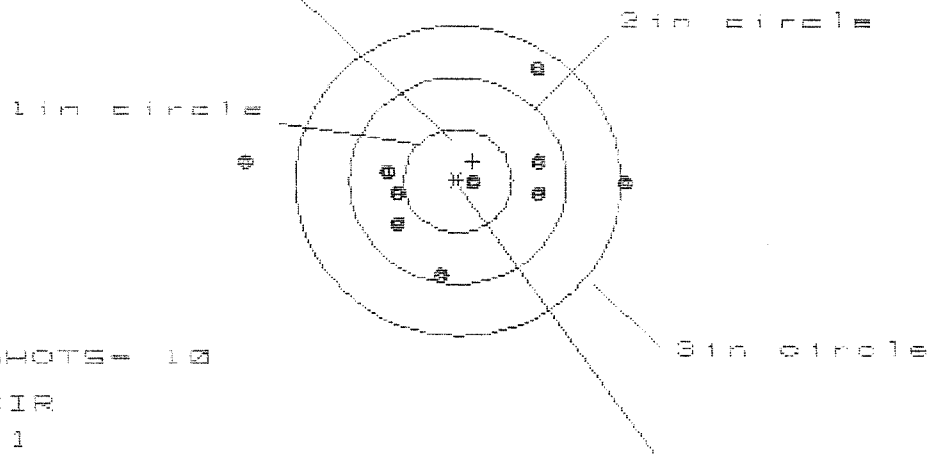
|                             |   |        |       |       |
|-----------------------------|---|--------|-------|-------|
| PATTERN #                   | : | 1      |       |       |
| SHOTS (BEST OF)             | : | 10     | 9     | 8     |
| MAXIMUM X                   | : | 1.363  | 1.487 | 1.339 |
| MINIMUM X                   | : | -.888  | -.764 | -.812 |
| MAXIMUM Y                   | : | 1.631  | 1.421 | .762  |
| MINIMUM Y                   | : | -1.885 | -.880 | -.622 |
| CENTROID X                  | : | .019   | -.025 | .023  |
| CENTROID Y                  | : | -.050  | .160  | -.018 |
| POA TO CENTROID in.         | : | .053   | .162  | .029  |
| MIN RADIUS                  | : | .261   | .282  | .244  |
| MEAN RADIUS                 | : | 1.011  | .895  | .811  |
| MAX RADIUS                  | : | 1.926  | 1.472 | 1.371 |
| HORIZONTAL SPREAD           | : | 2.171  | 2.171 | 2.171 |
| VERTICAL SPREAD             | : | 3.516  | 2.221 | 1.384 |
| EXTREME SPREAD              | : | 3.611  | 2.410 | 2.228 |
| NUMBER IN ONE INCH CIRCLE   | = |        | 2     |       |
| NUMBER IN TWO INCH CIRCLE   | = |        | 5     |       |
| NUMBER IN THREE INCH CIRCLE | = |        | 8     |       |

30 Nov 1998

FILE:/PATTERNING/CENTERFIRE\_PATT/05587631

# CENTERFIRE PATTERNS # 2

POB



# OF SHOTS = 10

# IN CIR

1 in = 1

2 in = 7

3 in = 8

HS = 3.464

VS = 2.025

GS = 3.473

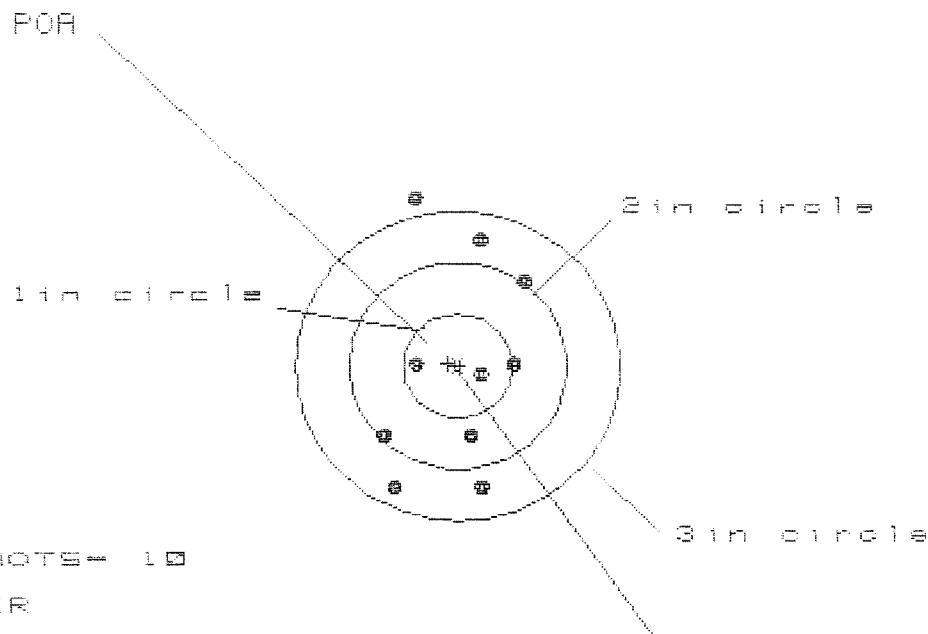
CENTROID #

|                             |   |        |       |       |
|-----------------------------|---|--------|-------|-------|
| PATTERN #                   | : | 2      |       |       |
| SHOTS (BEST OF)             | : | 10     | 9     | 8     |
| MAXIMUM X                   | : | 1.548  | 1.335 | .672  |
| MINIMUM X                   | : | -1.916 | -.866 | -.699 |
| MAXIMUM Y                   | : | 1.098  | 1.120 | 1.117 |
| MINIMUM Y                   | : | -.927  | -.905 | -.908 |
| CENTROID X                  | : | -.144  | .069  | -.098 |
| CENTROID Y                  | : | -.189  | -.211 | -.208 |
| POB TO CENTROID in.         | : | .238   | .222  | .230  |
| MIN RADIUS                  | : | .124   | .092  | .075  |
| MEAN RADIUS                 | : | .916   | .793  | .707  |
| MAX RADIUS                  | : | 1.926  | 1.335 | 1.299 |
| HORIZONTAL SPREAD           | : | 3.464  | 2.201 | 1.371 |
| VERTICAL SPREAD             | : | 2.025  | 2.025 | 2.025 |
| EXTREME SPREAD              | : | 3.473  | 2.216 | 2.216 |
| NUMBER IN ONE INCH CIRCLE   | = |        | 1     |       |
| NUMBER IN TWO INCH CIRCLE   | = |        | 7     |       |
| NUMBER IN THREE INCH CIRCLE | = |        | 8     |       |

30 May 1990

FILE:/PATTERNING/CENTERFIRE\_PATT/06587631

# CENTERFIRE PATTERNS # 3



# OF SHOTS = 10

# IN CIR

1in = 2

2in = 5

3in = 8

HS = 1.255

VS = 2.859

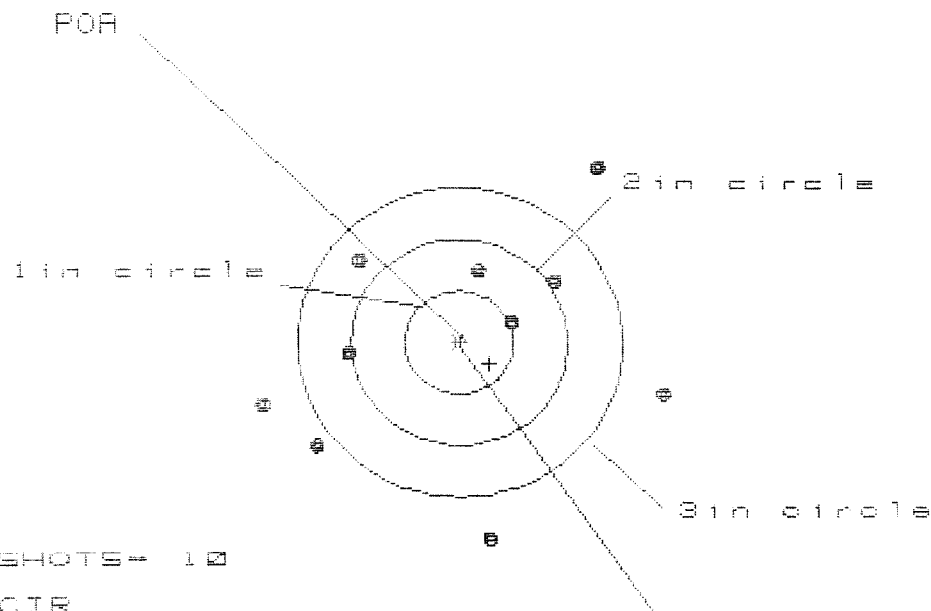
GS = 2.870

| PATTERN #                   | 3      |
|-----------------------------|--------|
| SHOTS (BEST OF)             | 10     |
| MAXIMUM X                   | .588   |
| MINIMUM X                   | -.667  |
| MAXIMUM Y                   | 1.665  |
| MINIMUM Y                   | -1.194 |
| CENTROID X                  | .087   |
| CENTROID Y                  | -.026  |
| POA TO CENTROID in.         | .091   |
| MIN RADIUS                  | .242   |
| MEAN RADIUS                 | .930   |
| MAX RADIUS                  | 1.703  |
| HORIZONTAL SPREAD           | 1.255  |
| VERTICAL SPREAD             | 2.859  |
| EXTREME SPREAD              | 2.870  |
| NUMBER IN ONE INCH CIRCLE   | = 2    |
| NUMBER IN TWO INCH CIRCLE   | = 5    |
| NUMBER IN THREE INCH CIRCLE | = 9    |

30 Nov 1990

FILE:/PATTERNING/CENTERFIRE\_PATT/06587631

# CENTERFIRE PATTERNS # 4



# OF SHOTS= 10

# IN CIR

1 in = 0

2 in = 3

3 in = 5

HS= 3.660

VS= 3.532

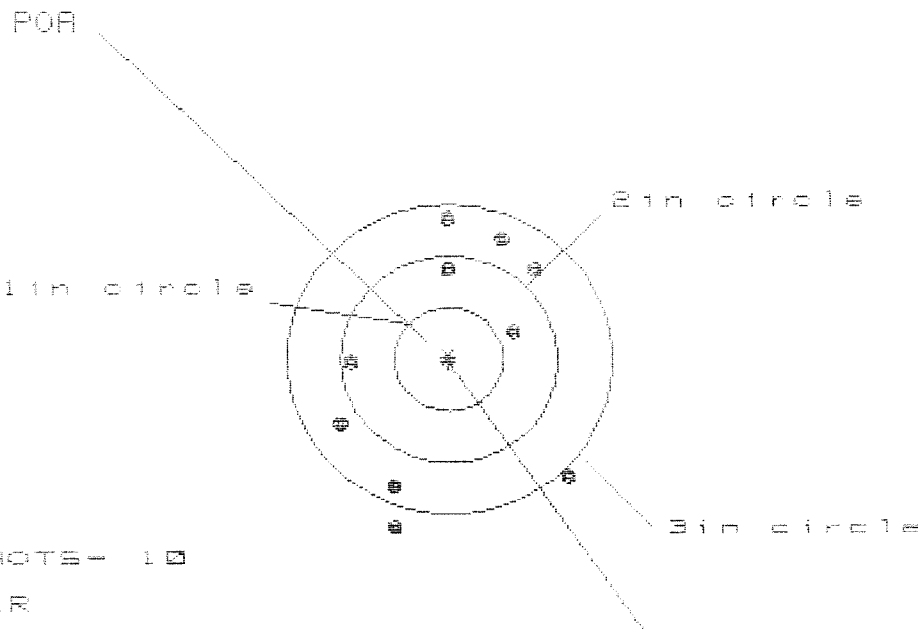
GS= 3.819

| PATTERN #                     | 4      | 9      | 8      |
|-------------------------------|--------|--------|--------|
| SHOTS (BEST OF)               | 10     | 9      | 8      |
| MAXIMUM X                     | 1.873  | 2.018  | 1.309  |
| MINIMUM X                     | -1.787 | -1.642 | -1.389 |
| MAXIMUM Y                     | 1.678  | .942   | .901   |
| MINIMUM Y                     | -1.854 | -1.668 | -1.709 |
| CENTROID X                    | -.279  | -.424  | -.676  |
| CENTROID Y                    | .202   | .016   | .057   |
| POA TO CENTROID in.           | .345   | .425   | .679   |
| MIN RADIUS                    | .513   | .731   | .591   |
| MEAN RADIUS                   | 1.400  | 1.330  | 1.208  |
| MAX RADIUS                    | 2.127  | 2.044  | 1.856  |
| HORIZONTAL SPREAD             | 3.660  | 3.660  | 2.699  |
| VERTICAL SPREAD               | 3.532  | 2.610  | 2.610  |
| EXTREME SPREAD                | 3.819  | 3.660  | 2.941  |
| NUMBER IN ONE INCH CIRCLE =   | 0      |        |        |
| NUMBER IN TWO INCH CIRCLE =   | 3      |        |        |
| NUMBER IN THREE INCH CIRCLE = | 5      |        |        |

30 Nov 1990

FILE:/PATTERNING/CENTERFIRE\_PATT/08587631

# CENTERFIRE PATTERNS # 5



# OF SHOTS- 10

# IN CIR

1 in = 0

2 in = 0

3 in = 0

HSI = 2.000

VS# = 3.001

GS# = 3.000

CENTROID \*

| PATTERN #                     | 5      |
|-------------------------------|--------|
| SHOTS (BEST OF)               | 10     |
| MAXIMUM X                     | 1.065  |
| MINIMUM X                     | -1.971 |
| MAXIMUM Y                     | 1.384  |
| MINIMUM Y                     | -1.647 |
| CENTROID X                    | .008   |
| CENTROID Y                    | .030   |
| POR TO CENTROID in.           | .031   |
| MIN RADIUS                    | .672   |
| MEAN RADIUS                   | 1.198  |
| MAX RADIUS                    | 1.711  |
| HORIZONTAL SPREAD             | 2.036  |
| VERTICAL SPREAD               | 3.031  |
| EXTREME SPREAD                | 3.060  |
| NUMBER IN ONE INCH CIRCLE =   | 0      |
| NUMBER IN TWO INCH CIRCLE =   | 3      |
| NUMBER IN THREE INCH CIRCLE = | 8      |