

06522197

MODEL 700™ M24

Model SWS™

Action _____

Barrel Length _____

Capacity _____

Order No. 5716

*Includes 1 in chamber.



Repair Inquiry

Repair Number: **RE00102769**Serial: C6522197 Model: M24 SWS Center Fire
Caliber: 7.62 NATO

Repairman:

Status:

Closed: 10/26/2005 7:48:39 AM

Address Information

Customer:

☒ Received From

Return To:

☐ Received FromName: **PR W7LZ CAMP SHELBY DET 57**Name: **PR W7LZ CAMP SHELBY DET 57**Address 1: **OEF TRAINING BDE ROTATION**Address 1: **OEF TRAINING BDE ROTATION**Address 2: **BLDG 6520 WAREHOUSE AVE**Address 2: **BLDG 6520 WAREHOUSE AVE**

PO Box:

PO Box:

City: **CAMP SHELBY**City: **CAMP SHELBY**State: **MS**Zip Code: **39407**Country: **US**State: **MS**Zip Code: **39407**Country: **US**

FFL:

Contact / Condition

Problems

Estimate

History / Status

Shipping / Billing

Contact Information

Phone: **601 558 4593**

Fax:

Email:

Comments:

Received Condition

Fair

Condition
Notes:CSR
Notes:

Accessories Received

Code	Desc	Qty
A006	Sling Strap	1
A010	Hard Case	1
A016	Scope Rings	2
A017	Scope Base	1
A026	Scope	1
A045	Bi Pod	1
C000	TORQUE WRENCH	1
C001	SPOTTING SCOPE	1

Repair Search

Refresh

Close

nagletj

10/26/2005

9:33 AM

CAPS

NUM

INS

SCPL

start

2

2

5

Arms

2

2

2

2

Serial
Number:**C6522197**Model: **M24 SWS****RE00102769**

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6522197.___0
FILE DATE AND TIME: 11/28/2005 23:17

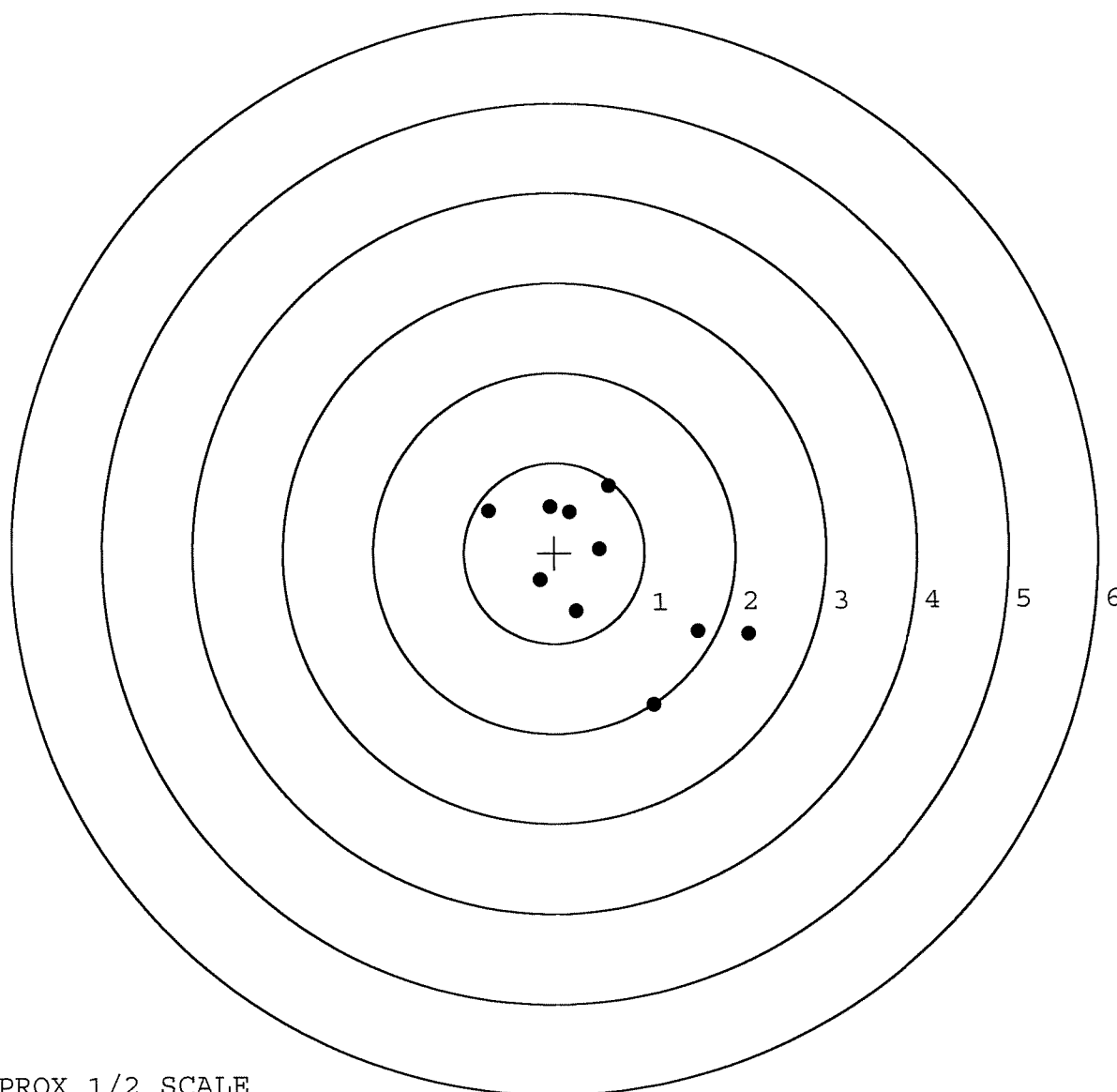
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.233
The Average Y Centroid of the Five Target Set:	-0.035
The Average Point of Impact of the Five Target Set:	0.235
The Average Mean Radius of the Five Target Set:	0.701
The Distance from POA to Centroid Target #1:	0.582
The Distance from Centroid Target #2 to Centroid Target #1:	0.528
The Distance from Centroid Target #3 to Centroid Target #1:	0.423
The Distance from Centroid Target #4 to Centroid Target #1:	0.507
The Distance from Centroid Target #5 to Centroid Target #1:	0.361

SERIAL NUMBER: C6522197. __0
 TARGET NUMBER: 1
 FILE DATE: 11/28/2005
 FILE TIME: 23:17

POINT#	X	Y
1:	-0.161	-0.305
2:	0.234	-0.652
3:	0.494	0.037
4:	0.170	0.453
5:	-0.053	0.508
6:	0.601	0.739
7:	-0.723	0.467
8:	1.580	-0.883
9:	2.139	-0.914
10:	1.091	-1.696

X CENTROID: 0.537
 Y CENTROID: -0.225
 POA TO CENTROID: 0.582
 HORZ SPREAD: 2.862
 VERT SPREAD: 2.435
 GROUP SPREAD: 3.178
 MIN RADIUS: 0.265
 MAX RADIUS: 1.744
 MEAN RADIUS: 1.016
 # IN 1 IN DIAMETER: 1
 # IN 2 IN DIAMETER: 6
 # in 3 IN DIAMETER: 8

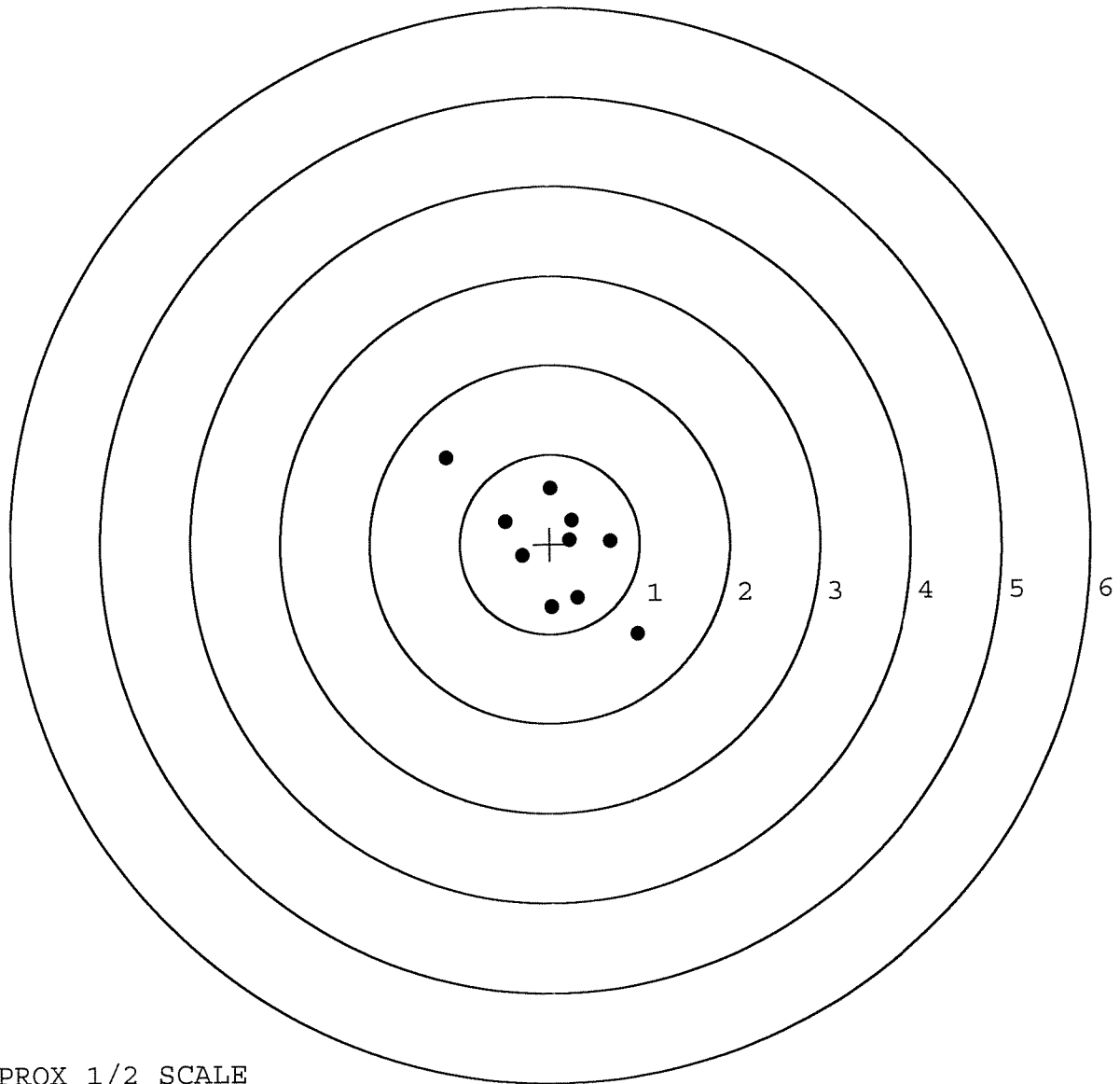


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6522197. __0
 TARGET NUMBER: 2
 FILE DATE: 11/28/2005
 FILE TIME: 23:17

X CENTROID: 0.049
 Y CENTROID: -0.025
 POA TO CENTROID: 0.055
 HORZ SPREAD: 2.117
 VERT SPREAD: 1.976
 GROUP SPREAD: 2.896
 MIN RADIUS: 0.183
 MAX RADIUS: 1.552
 MEAN RADIUS: 0.701
 # IN 1 IN DIAMETER: 3
 # IN 2 IN DIAMETER: 8
 # in 3 IN DIAMETER: 9

POINT#	X	Y
1:	0.217	0.046
2:	0.241	0.264
3:	0.013	0.626
4:	-0.496	0.259
5:	-0.309	-0.127
6:	0.018	-0.705
7:	0.306	-0.605
8:	0.972	-1.009
9:	0.669	0.030
10:	-1.145	0.967

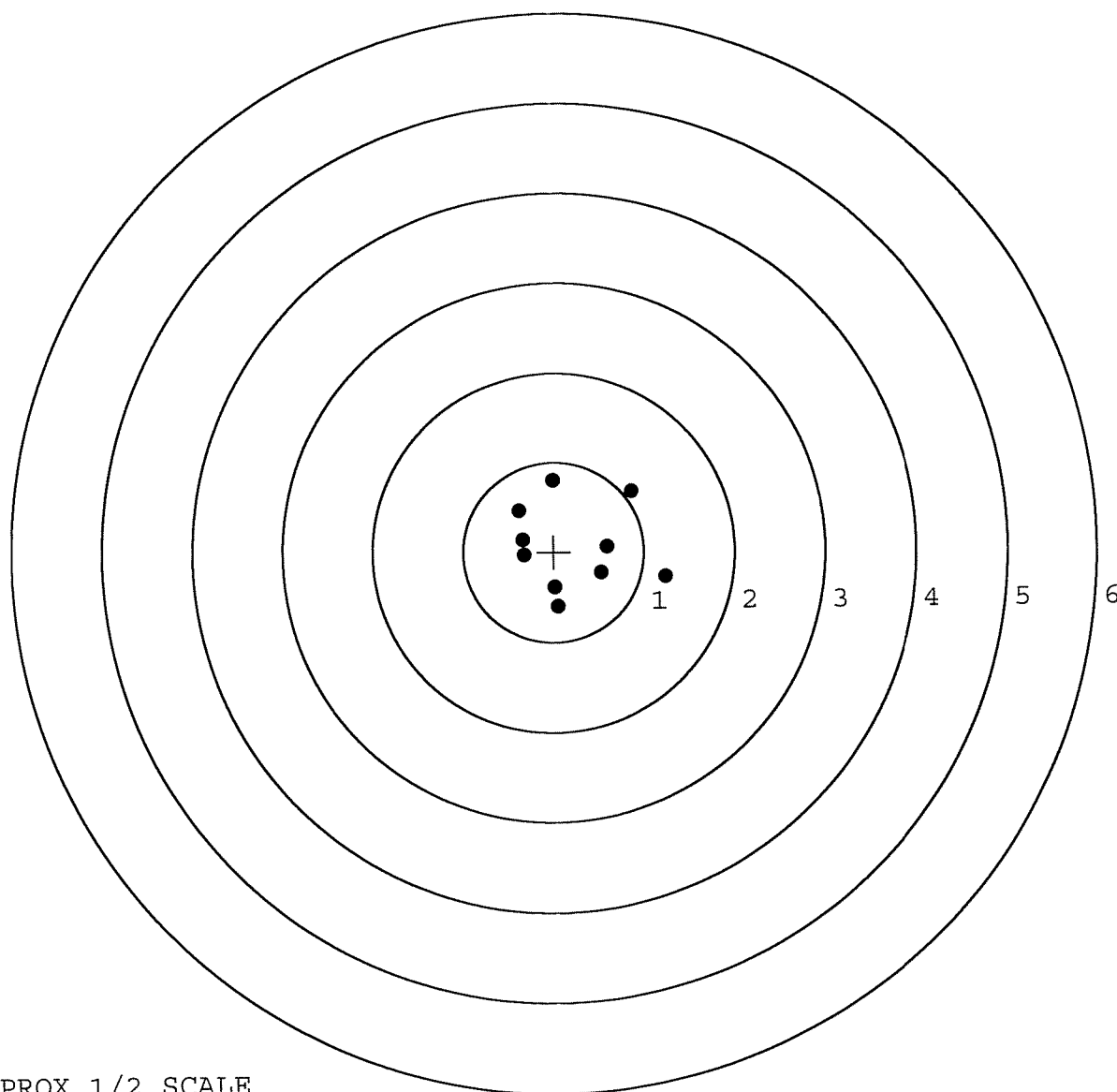


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6522197. 0
 TARGET NUMBER: 3
 FILE DATE: 11/28/2005
 FILE TIME: 23:17

X CENTROID: 0.220
 Y CENTROID: 0.056
 POA TO CENTROID: 0.227
 HORZ SPREAD: 1.621
 VERT SPREAD: 1.410
 GROUP SPREAD: 1.789
 MIN RADIUS: 0.368
 MAX RADIUS: 1.074
 MEAN RADIUS: 0.657
 # IN 1 IN DIAMETER: 3
 # IN 2 IN DIAMETER: 9
 # in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.327	-0.034
2:	-0.341	0.139
3:	-0.385	0.465
4:	-0.008	0.797
5:	0.862	0.671
6:	0.588	0.057
7:	0.526	-0.237
8:	1.236	-0.292
9:	0.044	-0.613
10:	0.008	-0.394

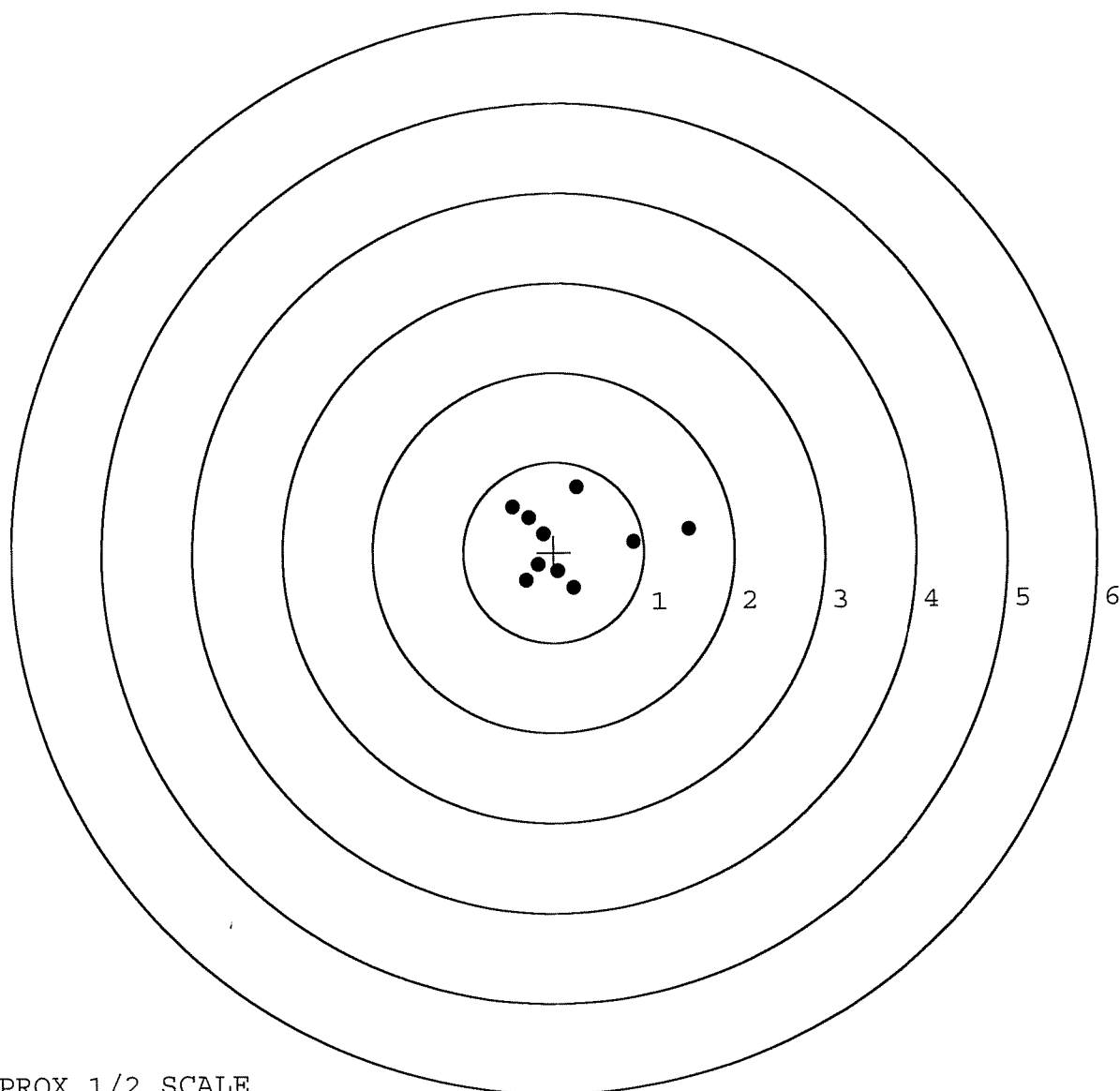


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6522197. __0
 TARGET NUMBER: 4
 FILE DATE: 11/28/2005
 FILE TIME: 23:17

X CENTROID: 0.156
 Y CENTROID: 0.110
 POA TO CENTROID: 0.191
 HORZ SPREAD: 1.953
 VERT SPREAD: 1.114
 GROUP SPREAD: 1.970
 MIN RADIUS: 0.292
 MAX RADIUS: 1.348
 MEAN RADIUS: 0.612
 # IN 1 IN DIAMETER: 3
 # IN 2 IN DIAMETER: 9
 # in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.176	-0.138
2:	-0.312	-0.310
3:	0.043	-0.213
4:	0.217	-0.399
5:	0.885	0.107
6:	1.497	0.246
7:	0.259	0.715
8:	-0.119	0.206
9:	-0.274	0.382
10:	-0.456	0.501

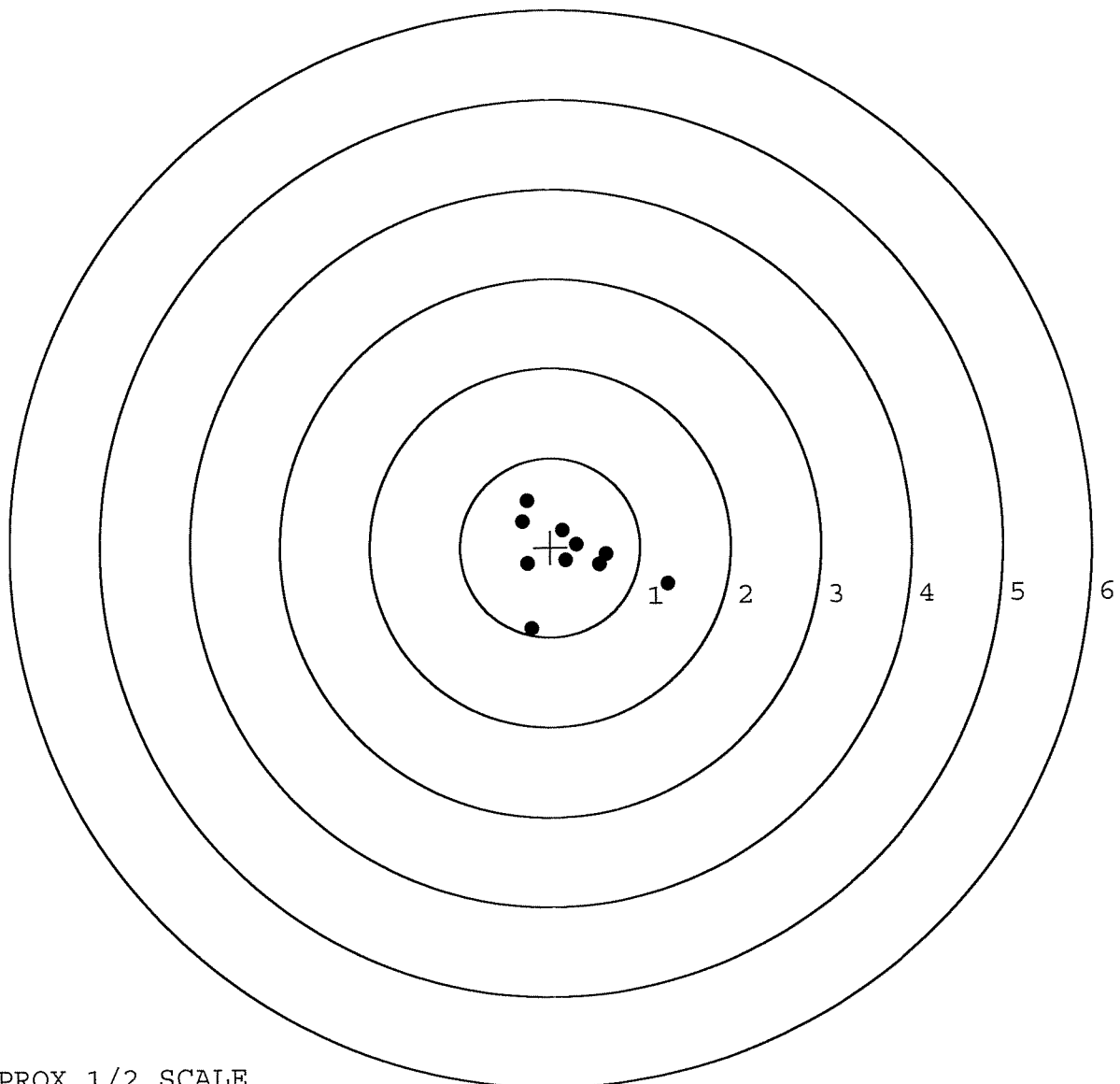


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6522197. 0
 TARGET NUMBER: 5
 FILE DATE: 11/28/2005
 FILE TIME: 23:17

X CENTROID: 0.201
 Y CENTROID: -0.091
 POA TO CENTROID: 0.221
 HORZ SPREAD: 1.613
 VERT SPREAD: 1.430
 GROUP SPREAD: 1.823
 MIN RADIUS: 0.066
 MAX RADIUS: 1.148
 MEAN RADIUS: 0.522
 # IN 1 IN DIAMETER: 6
 # IN 2 IN DIAMETER: 9
 # in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.259	-0.181
2:	-0.313	0.289
3:	-0.259	0.521
4:	-0.216	-0.909
5:	0.137	0.192
6:	0.173	-0.151
7:	0.541	-0.197
8:	0.617	-0.086
9:	1.300	-0.423
10:	0.291	0.030



TARGET APPROX 1/2 SCALE

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

R & E NUMBER	102769		CAMP Shelby	
SERIAL NUMBER	C6522197			
LOG-IN DATE	10-26-05			
OPERATION #	OPERATION NAME		DATE	INITIAL
500	DIS-ASSEMBLE GUN		11-3-05	Ac
505	RE-BARREL		11-8-05	Ac
560	ASSEMBLE		11-15-05	CD
600	PROOF	MAGNA-FLUX INSPECTED	11-15-05	CD
605	CHECK HEADSPACE		11-15-05	CD
610	DIS-ASSEMBLE GUN	NOV 18 2005	11-15-05	CD
612	MAGNAFLUX	OPERATOR <i>unib</i>	11-18-05	<i>unib</i>
510	DRILL AND TAP		11-17-05	BR
615	ROLLMARK CALIBER		11-18-05	CW
618	ROTO-BLAST		11-21-05	LB
620	APPLY COATINGS		11/22/05	FB
625	FINAL ASSEMBLY		11-23-05	Ac
640	FUNCTION TEST AND	PASS FAIL	11-28-05	<i>mtm</i>
650	TARGET	PASS FAIL	11-28-05	<i>mtm</i>
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
670	FINAL INSPECTION		11-29-05	Ac
	A) HEADSPACE	PASS FAIL	11-29-05	Ac
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS		
680	F) SAFETY ON FORCE	2 LBS MIN 10 LBS	5 lbs 5 lbs 5 lbs	Ac
	G) SAFETY OFF FORCE	2 LBS	3 lbs 3 lbs 3 lbs	Ac
	I) FIRING PIN INDENT	.020	.021 .021 .021	Ac
690	PACK		12-2-05	RA

0 47700 25716 7

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6522197
11 Sep 1990

CENTROIDAL DISTANCES

0 TO	1	.0936803
1 TO	2	.579843
1 TO	3	.680404
1 TO	4	.277305
1 TO	5	.236044

$\begin{matrix} 2 \\ 3 \end{matrix} \begin{matrix} 4 \\ 1 \end{matrix}$ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.2836
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .13
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .311976

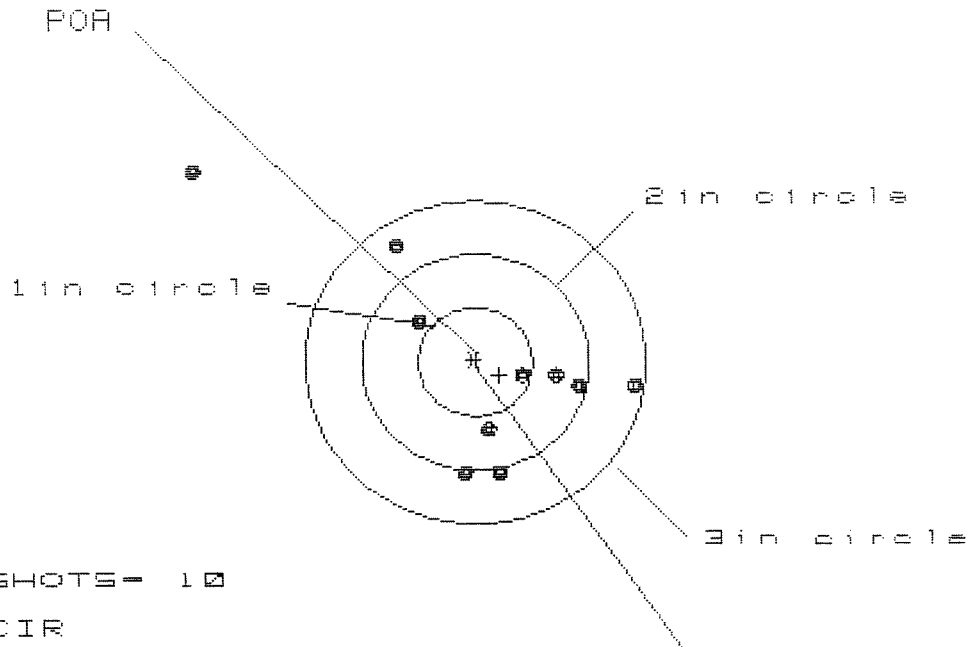
THE AMR FOR THIS RIFLE IS: 1.31

OK after TO 1.3 - ROUNDS OUT

18 Sep 1998

FILE:/PATTERNING/CENTERFIRE_PATT/08522197

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 9

HS= 3.937

VS= 2.822

GS= 4.426

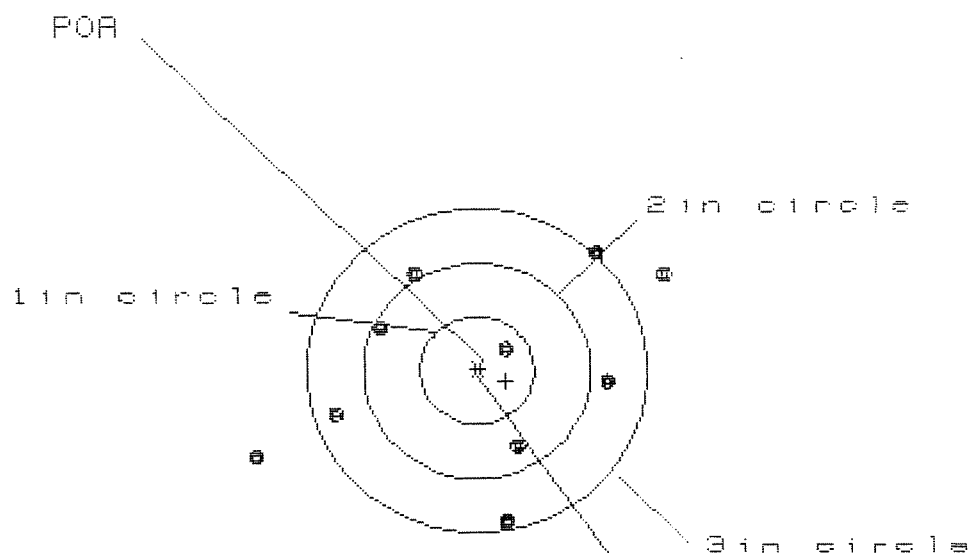
CENTROID #

PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.426	1.147	.793
MINIMUM X	:	-2.511	-.959	-.815
MAXIMUM Y	:	1.805	1.284	1.282
MINIMUM Y	:	-1.017	-.816	-.818
CENTROID X	:	-.208	.071	-.073
CENTROID Y	:	.121	-.080	-.078
POA TO CENTROID in.	:	.241	.107	.107
MIN RADIUS	:	.390	.153	.269
MEAN RADIUS	:	1.105	.777	.747
MAX RADIUS	:	3.092	1.602	1.519
HORIZONTAL SPREAD	:	3.937	2.106	1.608
VERTICAL SPREAD	:	2.822	2.100	2.100
EXTREME SPREAD	:	4.426	2.475	2.299
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	5		
NUMBER IN THREE INCH CIRCLE	=	9		

18 Sep 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C8522197

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 3

3 in = 7

HS= 3.668

VS= 2.530

GS= 4.019

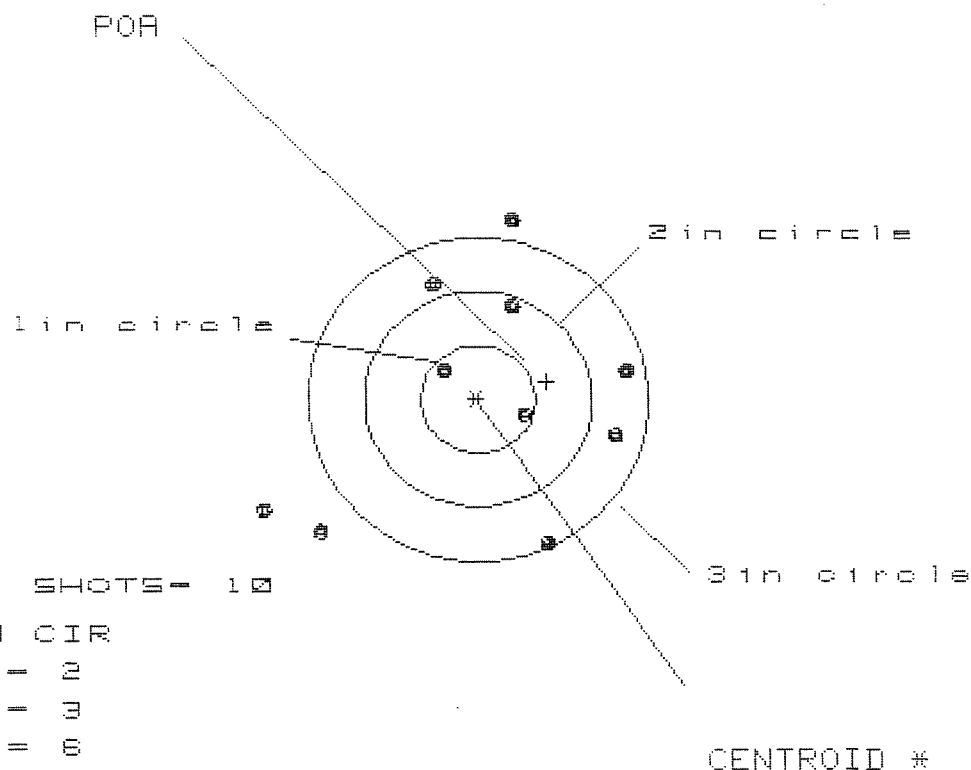
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.671	1.449	1.071
MINIMUM X	:	-1.997	-1.450	-1.269
MAXIMUM Y	:	1.101	1.013	1.109
MINIMUM Y	:	-1.429	-1.517	-1.421
CENTROID X	:	-.251	-.029	-.210
CENTROID Y	:	.103	.191	.095
POA TO CENTROID in.	:	.271	.193	.231
MIN RADIUS	:	.293	.070	.263
MEAN RADIUS	:	1.251	1.117	1.057
MAX RADIUS	:	2.148	1.638	1.519
HORIZONTAL SPREAD	:	3.668	2.899	2.340
VERTICAL SPREAD	:	2.530	2.530	2.530
EXTREME SPREAD	:	4.019	3.141	2.730
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		7	

10 Sep 1990

FILE:/PATTERNING/CENTERFIRE_PATT/C6522197

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 3

3 in = 6

HS= 3.147

VS= 3.066

GS= 3.511

CENTROID *

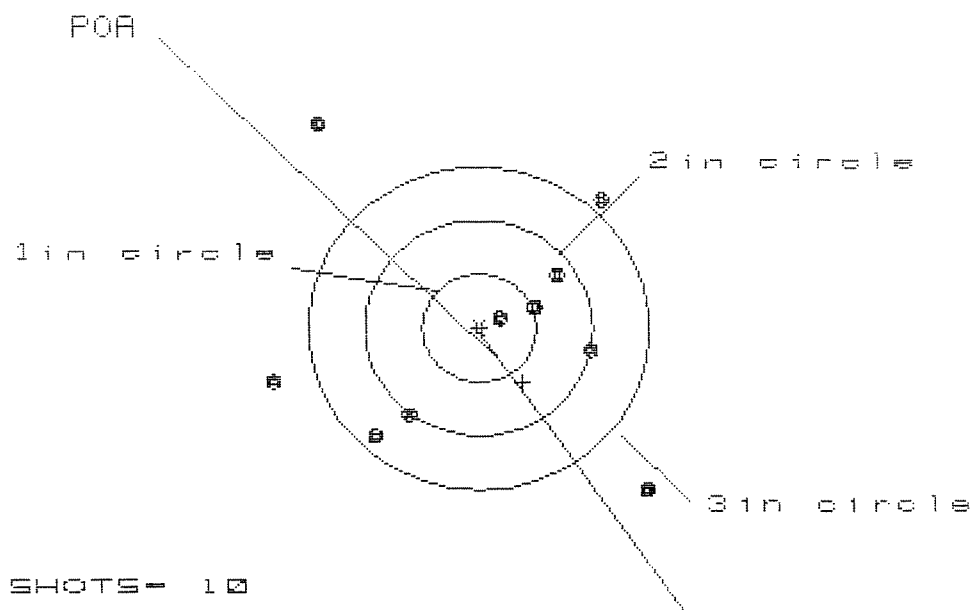
PATTERN #	:	3	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.287	1.081	.875
MINIMUM X	:	-1.868	-1.643	-.843
MAXIMUM Y	:	1.688	1.568	1.398
MINIMUM Y	:	-1.377	-1.498	-1.668
CENTROID X	:	-.604	-.398	-.192
CENTROID Y	:	-.167	-.047	.123
POA TO CENTROID in.	:	.627	.400	.228
MIN RADIUS	:	.373	.267	.394
MEAN RADIUS	:	1.265	1.123	.972
MAX RADIUS	:	2.151	2.136	1.681
HORIZONTAL SPREAD	:	3.147	2.724	1.718
VERTICAL SPREAD	:	3.066	3.066	3.066
EXTREME SPREAD	:	3.511	3.408	3.082
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		6	

10 Sep 1990

FILE:/PATTERNING/CENTERFIRE_PATT/C6522197

CENTERFIRE PATTERNS

4



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 5

3 in = 6

HS= 3.257

VS= 3.389

GS= 4.479

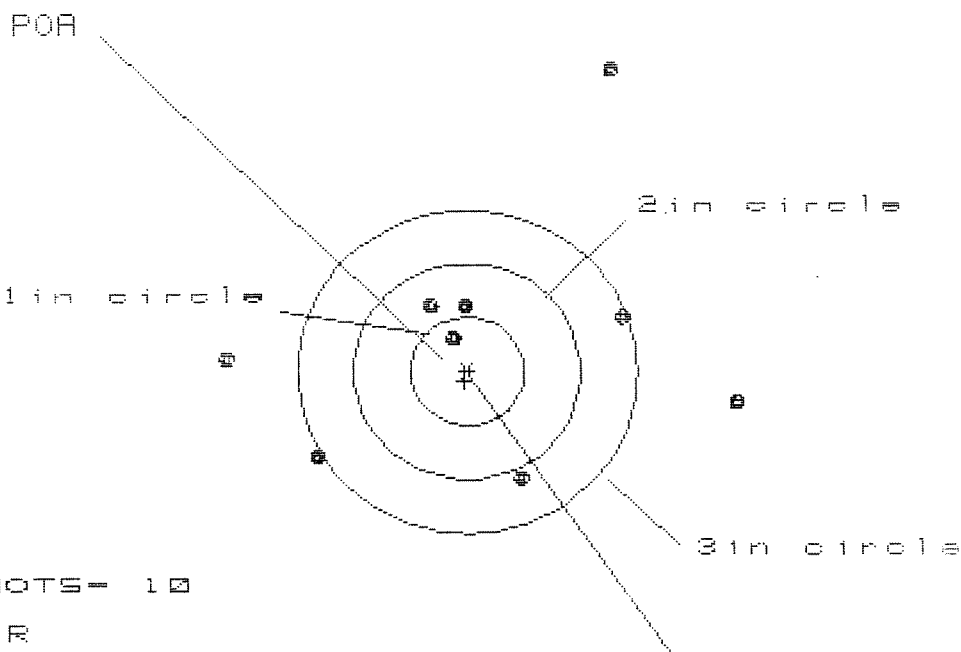
CENTROID #

PATTERN #	:	4	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.463	1.300	1.086
MINIMUM X	:	-1.794	-1.957	-1.795
MAXIMUM Y	:	1.879	1.410	1.247
MINIMUM Y	:	-1.510	-1.301	-0.952
CENTROID X	:	-0.381	-0.218	-0.380
CENTROID Y	:	.503	.294	.457
POA TO CENTROID in.	:	.631	.366	.594
MIN RADIUS	:	.213	.346	.245
MEAN RADIUS	:	1.289	1.152	1.054
MAX RADIUS	:	2.384	1.973	1.841
HORIZONTAL SPREAD	:	3.257	3.257	2.881
VERTICAL SPREAD	:	3.389	2.711	2.199
EXTREME SPREAD	:	4.479	3.423	3.324
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	5		
NUMBER IN THREE INCH CIRCLE	=	6		

18 Sep 1998

FILE:/PATTERNING/CENTERFIRE_PATT/06522197

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 3

3 in = 5

HS= 4.489

VS= 5.574

GS= 6.230

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	2.369	2.201	2.338
MINIMUM X	-2.119	-2.288	-2.151
MAXIMUM Y	2.770	2.458	.578
MINIMUM Y	-2.804	-1.337	-1.030
CENTROID X	.026	.195	.057
CENTROID Y	.090	.402	.095
POA TO CENTROID in.	.094	.447	.111
MIN RADIUS	.300	.306	.311
MEAN RADIUS	1.642	1.434	1.275
MAX RADIUS	3.188	2.693	2.356
HORIZONTAL SPREAD	4.489	4.489	4.489
VERTICAL SPREAD	5.574	3.795	1.607
EXTREME SPREAD	6.230	4.508	4.508
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	3		
NUMBER IN THREE INCH CIRCLE =	5		

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C 6522197

DATE 9/7/90

TESTER WLB

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.46	2.43	2.48	2.39	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.43	2.43	2.41	2.35	
PULL #3	2.43	2.46	2.52	2.30	
PULL #4	2.39	2.44	2.52	2.36	
PULL #5	2.43	2.48	2.49	2.40	
TOTAL	12.14	12.24	12.42	11.80	
AVG.	2.43	2.45	2.48	2.36	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.22	3.20		
PULL #2	3.19	3.13		
PULL #3	3.17	3.16		
PULL #4	3.15	3.15		
PULL #5	3.07	3.15		
TOTAL	15.80	15.79		
AVG.	3.	3.16		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.10	4.09		4.14
PULL #2	4.00	4.04		4.17
PULL #3	4.08	4.06		4.12
PULL #4	4.04	4.04		4.16
PULL #5	4.05	4.11		4.17
TOTAL	20.27	20.34		20.76
AVG.	4.05	4.07		4.15

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6522197

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		8/1/90	KS
600	Proof		8/1/90	KS
607	Check Headspace		8/1/90	KS
610	Dis-assemble Gun		8/1/90	KS
612	Magnaflux Barrel Action		8/6/90	KR
	Magnaflux Bolt		8/6/90	KR
615	Rollmark Caliber		8/6/90	LS
617	Drill and Tap Sight Holes		8/10/90	KB
618	Polish Barrel <i>RB</i>		8/14/90	WB
620	Apply Coatings (Barrel Action)		8-22-90	TJA
	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		9/2/90	WB

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5 1/2	6	5 1/2			9/7/90	WB
	G) Safety Off Force	7 1/2	7 1/2	7 1/2			9/7/90	WB
	H) Trigger Pull Test & Retainability						9/7/90	WB
	I) Firing Pin Indent	.0225	.0225	.0225			9/7/90	WB
	J) Assemble Stock						9/8/90	KS
	K) Assemble Swivel Studs						9/15/90	928
	L) Attach Front and Rear Sight Assemblies						9/8/90	KS
	M) Iron Sight Alignment						9/8/90	KS
	N) Detach Front & Rear Sights & place in numbered container						9/8/90	KS
	O) Attach Scope to Rifle						9/8/90	KS
	P) Detach & Attach Scope 20 Times						9/8/90	KS
640	Gallery Target & Test						9/10/90	AF
	A) Time						9/10/90	AF
	B) Malfunctions						9/10/90	AF
	C) Pierced Primers						9/10/90	AF
	D) Optical Clarity of Scope						9/10/90	AF
645	Inspect for Live Ammo						9/10/90	AF
655	Final Inspection						9/15/90	928
	A) Headspace						9-14-90	928
	B) Trigger Pull	2.34	2.35	2.30	2.36	2.40	9/15/90	928
	C) Function						9/15/90	928
660	Pack						9/19/90	AF