

G-6590159

Replaces

C-6594600

07/13/07 08:27:24

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: RE00131329

Serial: C6594600 Model M24 SWS Center Fire
Produced: 03/18/1991

Repairman:

Status:

Closed 7/12/2007 2:59:23 PM

Verify Repair

Address Information

Customer:

☒ Received From

Return To:

☐ Received From

Name: CO B 2D BN., 3D SFG-A

CO B 2D BN., 3D SFG-A

Address 1: SGT TIMOTHY KRANZ

SGT TIMOTHY KRANZ

Address 2: E-1650 KUWAIT ST.

PO Box:

E-1650 KUWAIT ST.

PO Box:

City: FT. BRAGG

FT. BRAGG

State: NC

Zip Code: 28310

Country: US

State: NC

Zip Code: 28310

Country: US

FFL:

Contact / Condition

Problems

Estimate

History / Status

Shipping / Billing

Contact Information

Phone: NA

Fax:

Email:

Comments:

Received Condition

Fair

Condition
Notes:CSR
Notes:

Accessories Received

Code	Desc	Qty
A007	With Stud	3
A010	Hard Case	1
A057	Fit and Rear Sgt Base	1

Repair Search

Refresh

Close

nagletj

7/13/2007

8:27 AM

CAPS

NUM

INS

SCRL

start

4 Microsoft O...

5 Internet Ex...

6 Microsoft O...

Arms Services ...

8:27 AM

G6590159 (New)

~~C6594600~~

Model: M24 SWS



RE00131329

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6590159.___0
FILE DATE AND TIME: 09/10/2007 05:25

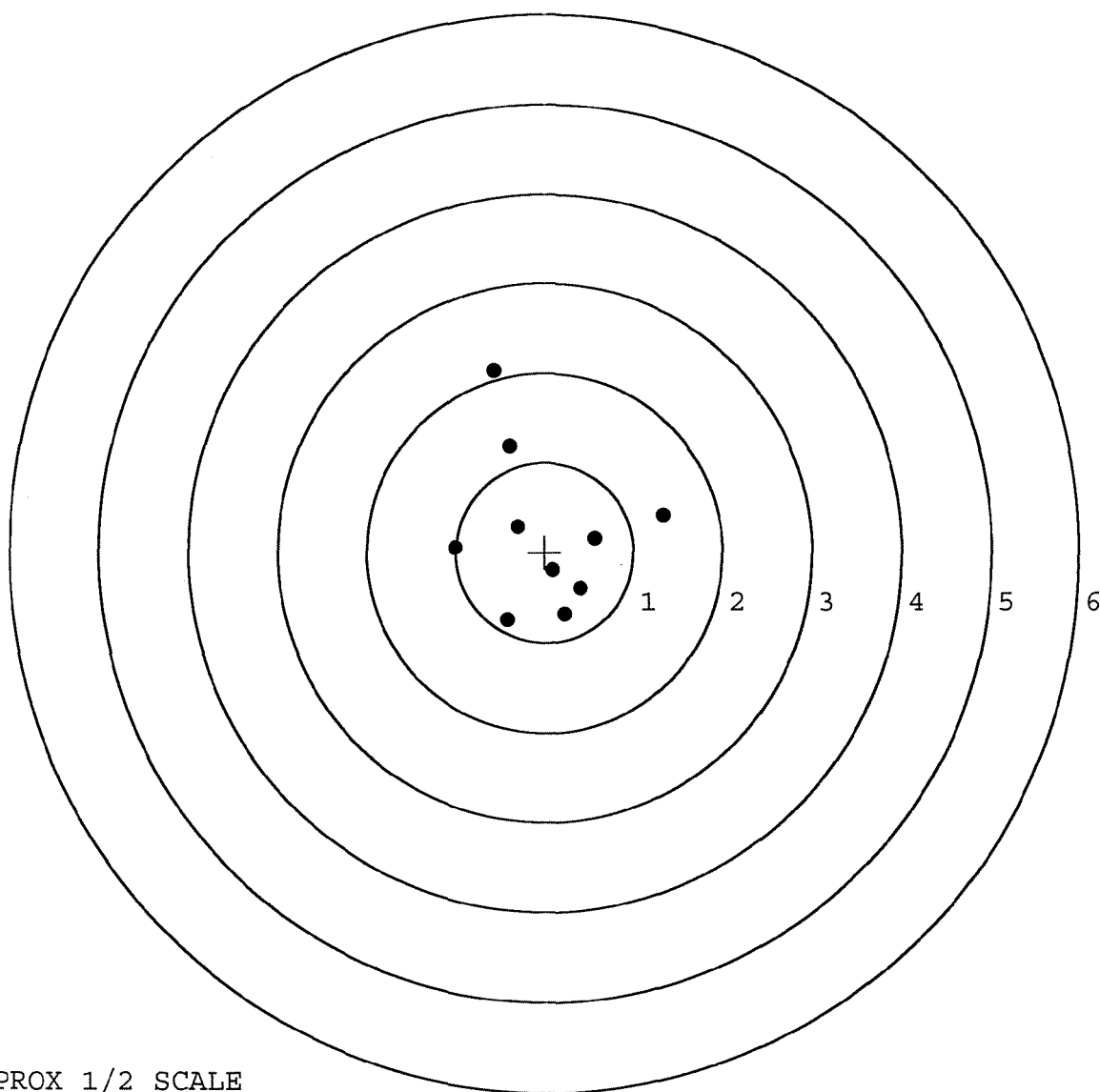
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.016
The Average Y Centroid of the Five Target Set:	0.039
The Average Point of Impact of the Five Target Set:	0.042
The Average Mean Radius of the Five Target Set:	0.639
The Distance from POA to Centroid Target #1:	0.207
The Distance from Centroid Target #2 to Centroid Target #1:	0.258
The Distance from Centroid Target #3 to Centroid Target #1:	0.368
The Distance from Centroid Target #4 to Centroid Target #1:	0.109
The Distance from Centroid Target #5 to Centroid Target #1:	0.130

SERIAL NUMBER: G6590159. __0
TARGET NUMBER: 1
FILE DATE: 09/10/2007
FILE TIME: 05:25

POINT#	X	Y
1:	-0.432	-0.758
2:	0.225	-0.691
3:	0.404	-0.401
4:	0.088	-0.203
5:	1.337	0.418
6:	0.561	0.158
7:	-0.311	0.281
8:	-1.007	0.059
9:	-0.405	1.185
10:	-0.573	2.022

X CENTROID: -0.011
Y CENTROID: 0.207
POA TO CENTROID: 0.207
HORZ SPREAD: 2.344
VERT SPREAD: 2.780
GROUP SPREAD: 2.828
MIN RADIUS: 0.309
MAX RADIUS: 1.900
MEAN RADIUS: 0.935
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 5
in 3 IN DIAMETER: 9

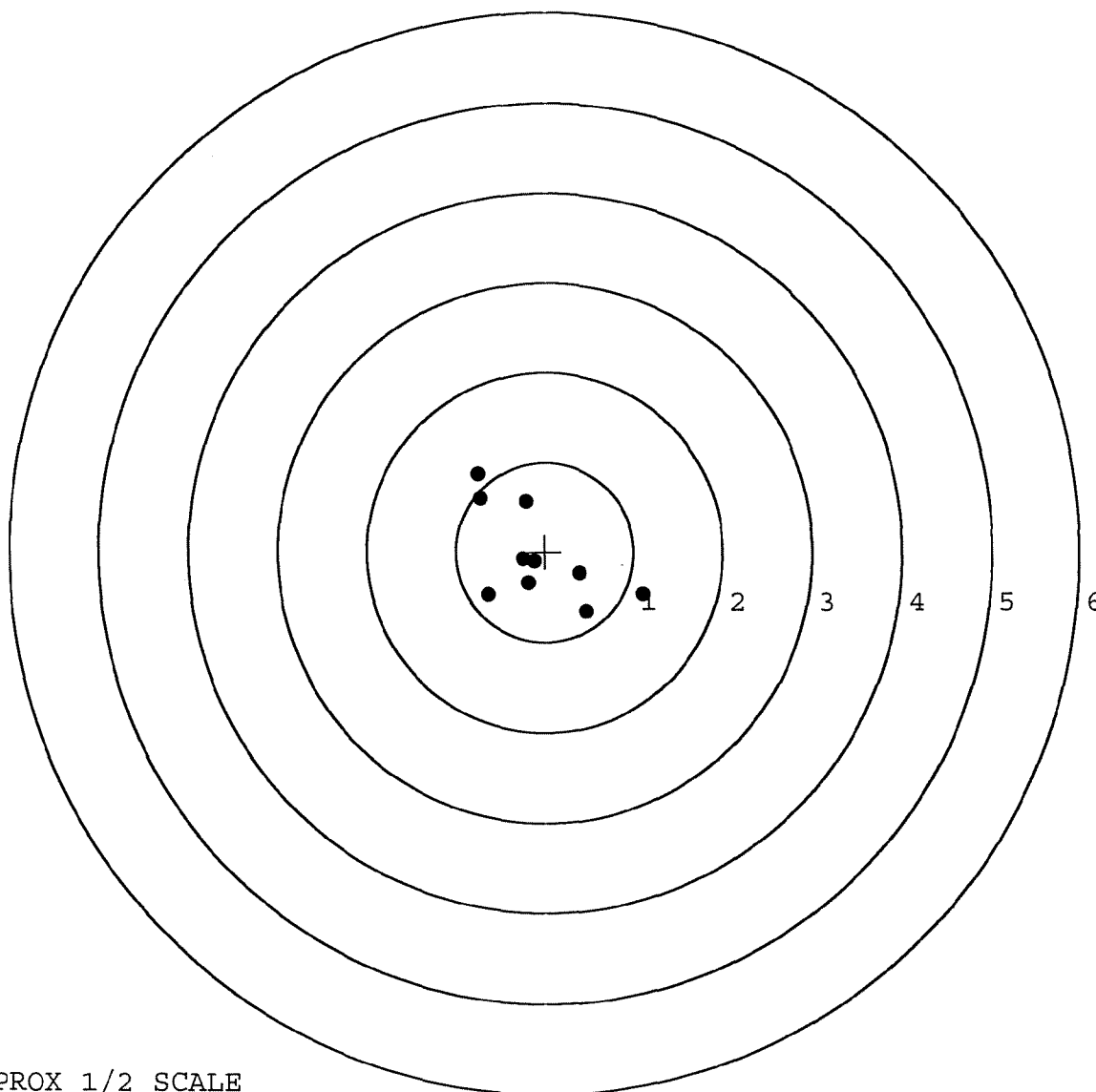


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590159. __0
TARGET NUMBER: 2
FILE DATE: 09/10/2007
FILE TIME: 05:25

X CENTROID: -0.093
Y CENTROID: -0.037
POA TO CENTROID: 0.101
HORZ SPREAD: 1.862
VERT SPREAD: 1.537
GROUP SPREAD: 2.301
MIN RADIUS: 0.080
MAX RADIUS: 1.276
MEAN RADIUS: 0.655
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	1.104	-0.479
2:	0.471	-0.664
3:	0.391	-0.234
4:	-0.640	-0.486
5:	-0.190	-0.347
6:	-0.121	-0.113
7:	-0.247	-0.081
8:	-0.758	0.873
9:	-0.730	0.594
10:	-0.214	0.563

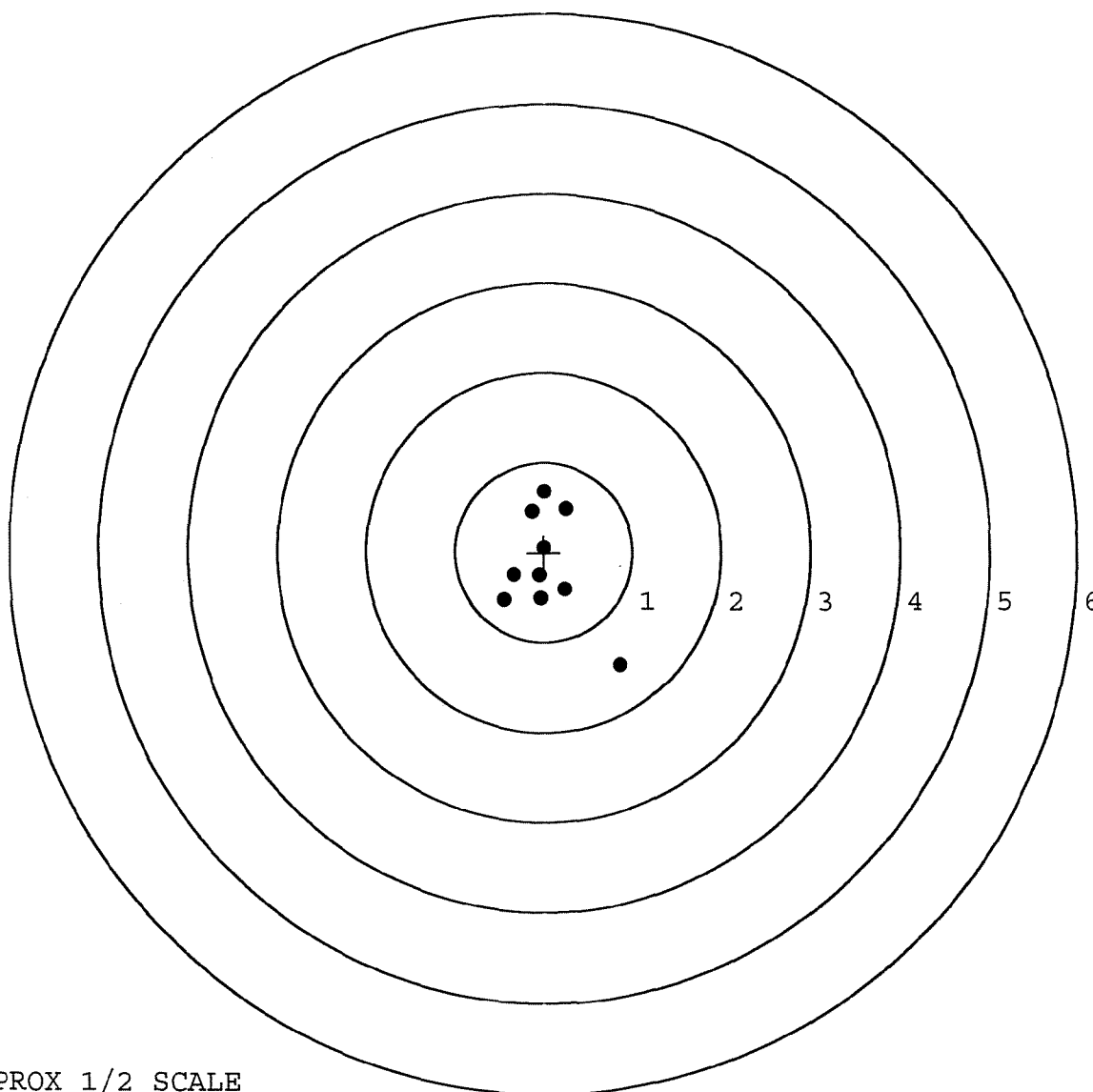


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590159. __0
TARGET NUMBER: 3
FILE DATE: 09/10/2007
FILE TIME: 05:25

POINT#	X	Y
1:	0.002	0.679
2:	0.253	0.484
3:	-0.135	0.457
4:	0.005	0.053
5:	0.239	-0.423
6:	-0.042	-0.520
7:	-0.055	-0.260
8:	-0.346	-0.255
9:	-0.458	-0.539
10:	0.858	-1.260

X CENTROID: 0.032
Y CENTROID: -0.158
POA TO CENTROID: 0.162
HORZ SPREAD: 1.316
VERT SPREAD: 1.939
GROUP SPREAD: 2.120
MIN RADIUS: 0.134
MAX RADIUS: 1.377
MEAN RADIUS: 0.559
IN 1 IN DIAMETER: 5
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

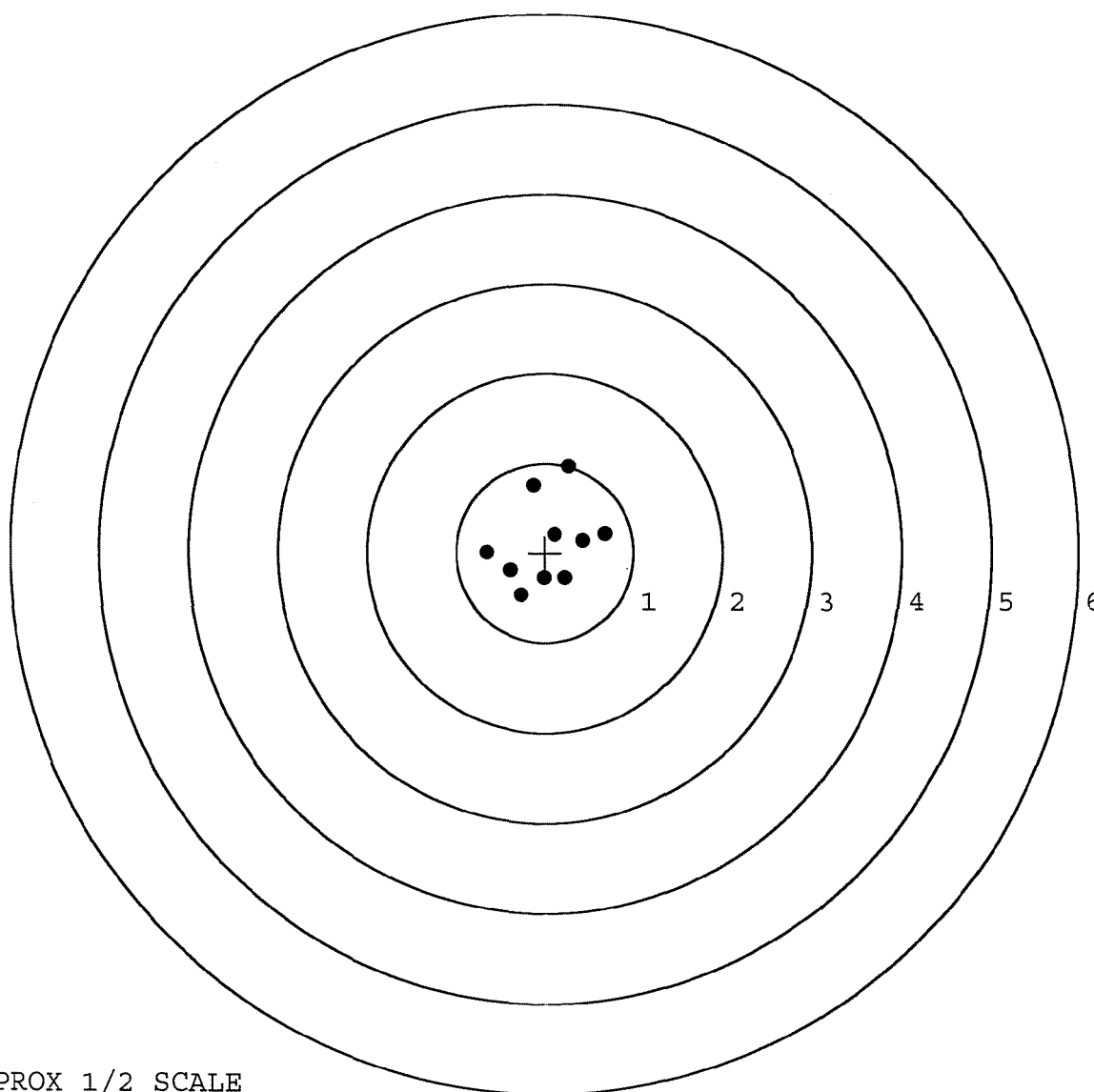


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590159. __0
TARGET NUMBER: 4
FILE DATE: 09/10/2007
FILE TIME: 05:25

POINT#	X	Y
1:	0.269	0.968
2:	-0.130	0.755
3:	0.110	0.204
4:	-0.657	-0.005
5:	-0.397	-0.194
6:	-0.277	-0.474
7:	-0.018	-0.280
8:	0.221	-0.285
9:	0.679	0.212
10:	0.420	0.135

X CENTROID: 0.022
Y CENTROID: 0.104
POA TO CENTROID: 0.106
HORZ SPREAD: 1.336
VERT SPREAD: 1.442
GROUP SPREAD: 1.542
MIN RADIUS: 0.134
MAX RADIUS: 0.899
MEAN RADIUS: 0.544
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 10
in 3 IN DIAMETER: 10

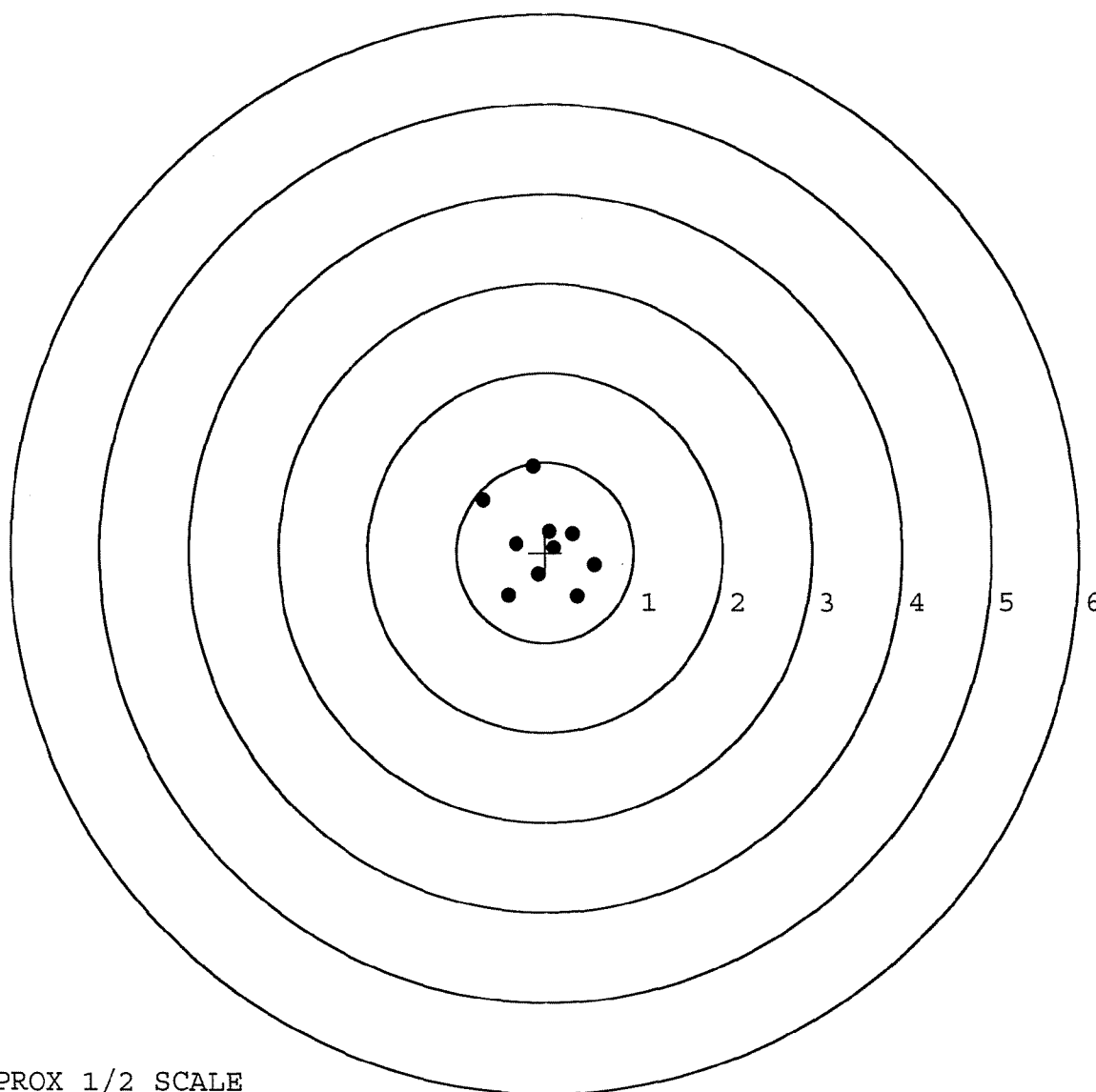


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590159. __0
TARGET NUMBER: 5
FILE DATE: 09/10/2007
FILE TIME: 05:25

X CENTROID: -0.031
Y CENTROID: 0.079
POA TO CENTROID: 0.085
HORZ SPREAD: 1.259
VERT SPREAD: 1.448
GROUP SPREAD: 1.530
MIN RADIUS: 0.131
MAX RADIUS: 0.884
MEAN RADIUS: 0.503
IN 1 IN DIAMETER: 5
IN 2 IN DIAMETER: 10
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.139	0.956
2:	-0.700	0.580
3:	-0.333	0.103
4:	-0.425	-0.476
5:	0.356	-0.492
6:	0.559	-0.138
7:	-0.086	-0.246
8:	0.051	0.238
9:	0.311	0.208
10:	0.098	0.056



TARGET APPROX 1/2 SCALE

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

R & E NUMBER 131329
 SERIAL NUMBER G6594600 G6590159 (New)
 LOG-IN DATE 7-17-07

OPERATION #	OPERATION NAME	DATE	INITIAL
500	DIS-ASSEMBLE GUN	8-14-07	RTZ
505	RE-BARREL	8-15-07	RTZ
560	ASSEMBLE	8-20-07	RTZ
600	PROOF	8/23/07	non
605	CHECK HEADSPACE	8/23/07	non
610	DIS-ASSEMBLE GUN	8-25-07	RTZ
612	MAGNAFLUX	8-30-07	JB
510	DRILL AND TAP	8-27-07	TRW
615	ROLLMARK CALIBER	8-28-07	CW
618	ROTO-BLAST	8-30-07	W
620	APPLY COATINGS	8/31/07	RB
625	FINAL ASSEMBLY	9-8-07	RTZ
640	FUNCTION TEST AND	(PASS) FAIL	9-8-07 TRW
650	TARGET	(PASS) FAIL	9-8-07 TRW
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
670	FINAL INSPECTION		
	A) HEADSPACE	PASS FAIL	9-12-07 DA
	B) TRIGGER PULL	9-10-07 DA	
		2.83 2.85 2.80 2.87 2.88	
680	F) SAFETY ON FORCE	55 50 50 9-12-07	DA
	G) SAFETY OFF FORCE	30 30 30 9-12-07	DA
	I) FIRING PIN INDENT	.023 .023 .023 9-12-07	DA
690	PACK	9-12-07	DA

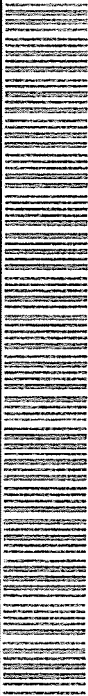
VERY IMPORTANT:
Instruction Book
enclosed to assure
safe use of this
firearm.



REG. U.S. PAT. & TM. OFF.

MODEL 700™ M24

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

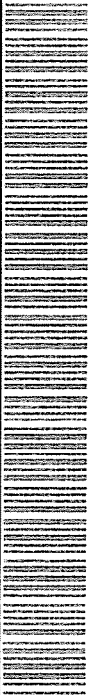


5716 C6594600

SERIAL NO.
C6594600

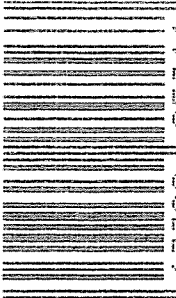
ORDER NO.
5716

20



5716 C6594600

LPC



0 47200 25716 7

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

M2400165874

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6594600

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		12/21/90	K.S.
600	Proof		12/21/90	K.S.
607	Check Headspace		12/21/90	K.S.
610	Dis-assemble Gun		12/21/90	K.S.
612	Magnaflux Barrel Action		1-9-91	KR
	Magnaflux Bolt		"	KR
615	Rollmark Caliber		"	JS
617	Drill and Tap Sight Holes	1 10 91		LB
618	Polish Barrel	1 10 91		WB
620	Apply Coatings (Barrel Action)		1-22-91	TJA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		1-29-91	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		1-29-91	KS
	C) Inspect Ejector Hole for Chamfer		1-29-91	KS
	D) Oil Firing Pin Ass'y		1-29-91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		1/30/91	JS

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6 1/2	6 1/2	6 1/2			1/30/91	WB
	G) Safety Off Force	3	3	3			1/30/91	WB
	H) Trigger Pull Test & Retainability						1-30-91	JH
	I) Firing Pin Indent	1.022	1.0225	1.022			1/30/91	WB
	J) Assemble Stock						1/30/91	KS
	K) Assemble Swivel Studs						2-4-91	AC
	L) Attach Front and Rear Sight Assemblies						1/30/91	KS
	M) Iron Sight Alignment						1/30/91	KS
	N) Detach Front & Rear Sights & place in numbered container						1/30/91	KS
	O) Attach Scope to Rifle						1/30/91	KS
	P) Detach & Attach Scope 20 Times						1/30/91	KS
640	Gallery Target & Test						1-31-91	DH
	A) Time						1-31-91	DH
	B) Malfunctions						1-31-91	DH
	C) Pierced Primers						1-31-91	DH
	D) Optical Clarity of Scope						1-31-91	DH
645	Inspect for Live Ammo						1-31-91	DH
655	Final Inspection							
	A) Headspace						2-4-91	AC
	B) Trigger Pull	2.58	2.49	2.54	2.27	2.28	2-4-91	JH
	C) Function						2-4-91	AC
660	Pack						3/15/91	WB

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C6594600

DATE 1/30/91

TESTER JR

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.22	2.25	2.27	2.51	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.38	2.29	2.20	2.49	
PULL #3	2.36	2.44	2.39	2.54	
PULL #4	2.36	2.33	2.38	2.27	
PULL #5	2.31	2.38	2.40	2.28	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.45	3.31		
PULL #2	3.45	3.28		
PULL #3	3.15	3.32		
PULL #4	3.47	3.35		
PULL #5	3.45	3.45		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.36	4.44		4.22
PULL #2	4.42	4.22		4.16
PULL #3	4.50	4.53		4.19
PULL #4	4.42	4.44		4.44
PULL #5	4.42	4.26		4.16
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6594600.
31 Jan 1991

CENTROIDAL DISTANCES

0 TO	1	.185586
1 TO	2	.0594138
1 TO	3	.271974
1 TO	4	.306026
1 TO	5	.274707

$\frac{35}{24}$

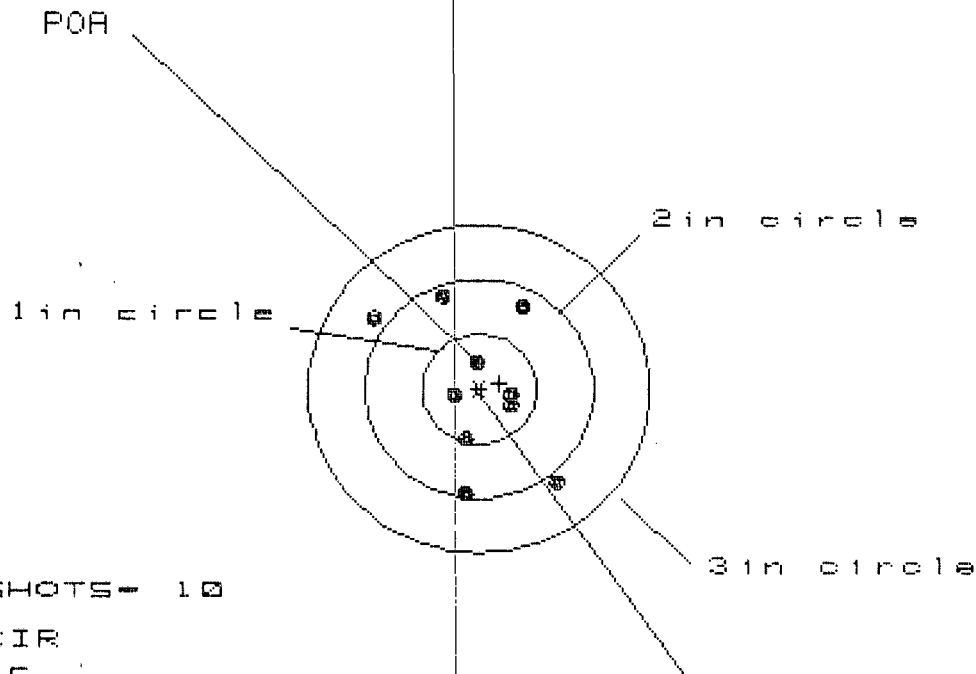
-----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0886
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0174
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0902924
THE AMR FOR THIS RIFLE IS: .784

31 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6594600

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 5

2in = 8

3in = 10

HS= 1.612

VS= 1.834

GS= 2.156

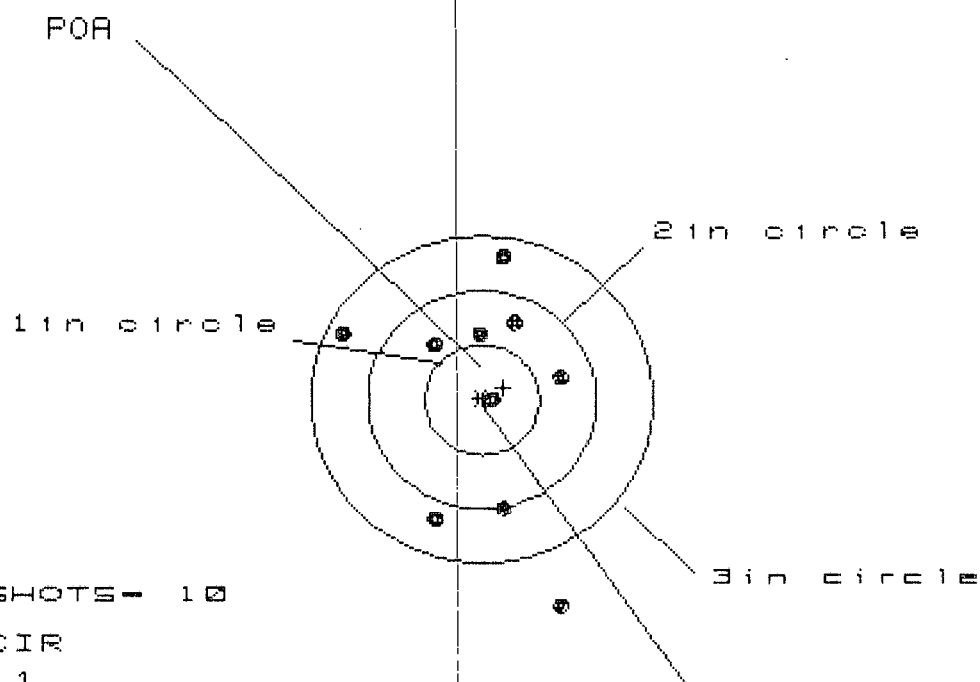
CENTROID #

PATTERN #	:	11	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.709	.608	.374
MINIMUM X	:	-.903	-.465	-.389
MAXIMUM Y	:	.884	.953	.860
MINIMUM Y	:	-.950	-.881	-.974
CENTROID X	:	-.179	-.078	-.154
CENTROID Y	:	-.049	-.117	-.024
POA TO CENTROID in.	:	.185	.141	.156
MIN RADIUS	:	.204	.193	.238
MEAN RADIUS	:	.656	.593	.549
MAX RADIUS	:	1.094	1.060	.981
HORIZONTAL SPREAD	:	1.612	1.073	.763
VERTICAL SPREAD	:	1.834	1.834	1.834
EXTREME SPREAD	:	2.156	2.009	1.854
NUMBER IN ONE INCH CIRCLE =	:	5		
NUMBER IN TWO INCH CIRCLE =	:	8		
NUMBER IN THREE INCH CIRCLE =	:	10		

31 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6594600

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 9

HS= 1.852

VS= 3.160

GS= 3.195

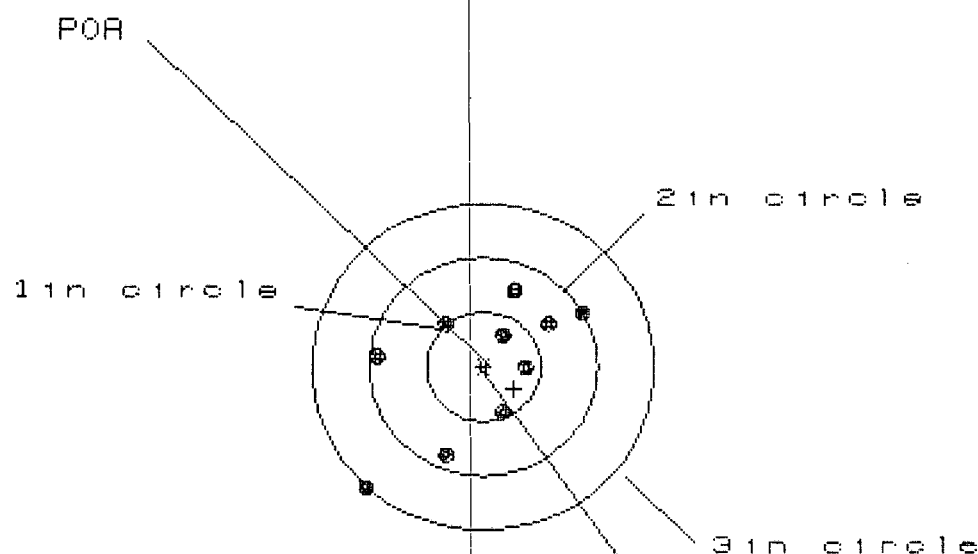
CENTROID #

PATTERN #	:	2	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.659	.732	.592
MINIMUM X	:	-1.193	-1.120	-.508
MAXIMUM Y	:	1.314	1.108	1.156
MINIMUM Y	:	-1.846	-1.264	-1.216
CENTROID X	:	-.186	-.259	-.119
CENTROID Y	:	-.108	.098	.050
POA TO CENTROID in.	:	.215	.276	.129
MIN RADIUS	:	.074	.273	.186
MEAN RADIUS	:	.951	.810	.751
MAX RADIUS	:	1.959	1.316	1.318
HORIZONTAL SPREAD	:	1.852	1.852	1.100
VERTICAL SPREAD	:	3.160	2.372	2.372
EXTREME SPREAD	:	3.195	2.453	2.453
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	5		
NUMBER IN THREE INCH CIRCLE	=	9		

31 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6594600

CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1in = 4

2in = 8

3in = 9

HS = 1.905

VS = 1.751

GS = 2.510

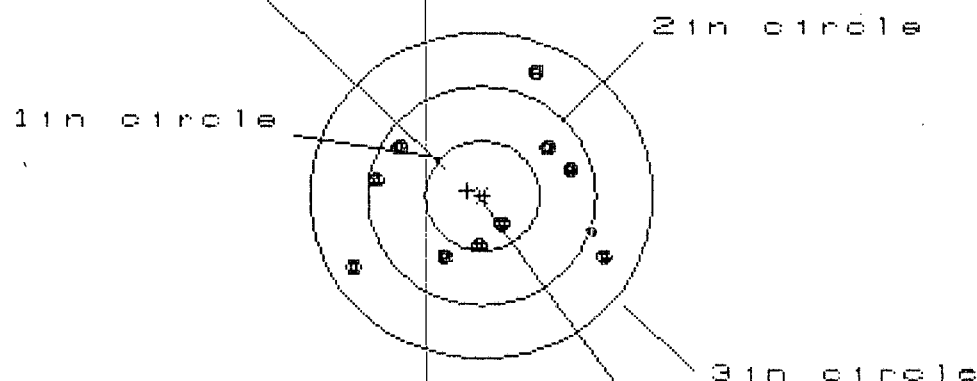
PATTERN #	:	M3	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.877	.763	.591
MINIMUM X	:	-1.028	-1.001	-.906
MAXIMUM Y	:	.649	.527	.578
MINIMUM Y	:	-1.102	-.941	-.890
CENTROID X	:	-.268	-.154	-.249
CENTROID Y	:	.208	.330	.279
POA TO CENTROID in.	:	.339	.364	.374
MIN RADIUS	:	.365	.215	.310
MEAN RADIUS	:	.746	.621	.604
MAX RADIUS	:	1.507	1.039	.954
HORIZONTAL SPREAD	:	1.905	1.764	1.497
VERTICAL SPREAD	:	1.751	1.468	1.468
EXTREME SPREAD	:	2.510	1.831	1.589
NUMBER IN ONE INCH CIRCLE =	:	4		
NUMBER IN TWO INCH CIRCLE =	:	8		
NUMBER IN THREE INCH CIRCLE =	:	9		

31 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6534680

CENTERFIRE PATTERNS # 4

POA



OF SHOTS- 10

IN CIR

1in = 2

2in = 7

3in = 10

HS= 2.196

VS= 1.802

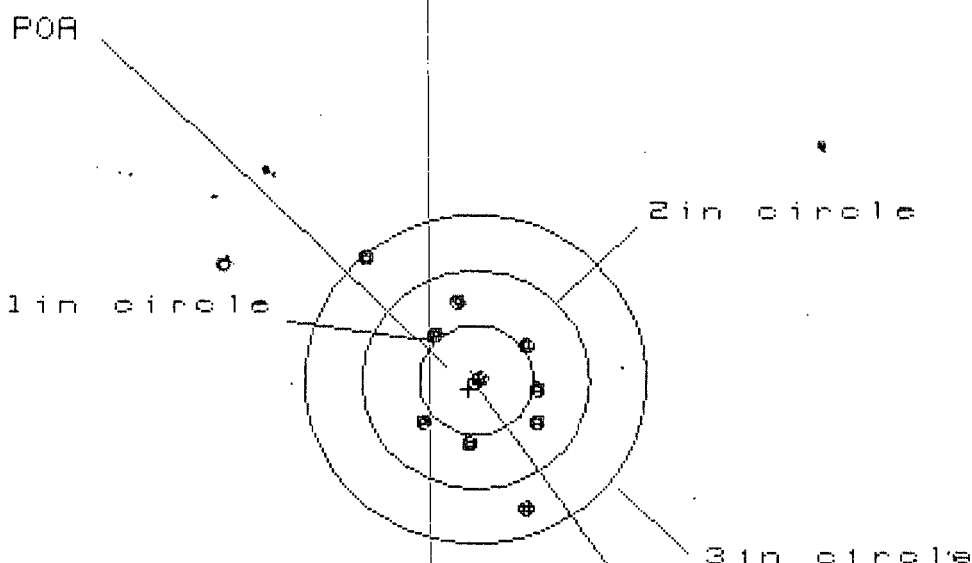
GS= 2.372

PATTERN #	:	4	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.090	.967	.818
MINIMUM X	:	-1.106	-1.099	-.978
MAXIMUM Y	:	1.099	1.021	.944
MINIMUM Y	:	-.703	-.614	-.689
CENTROID X	:	.127	.250	.129
CENTROID Y	:	-.045	.033	.110
POA TO CENTROID in.	:	.135	.252	.170
MIN RADIUS	:	.332	.362	.469
MEAN RADIUS	:	.859	.806	.768
MAX RADIUS	:	1.311	1.145	1.040
HORIZONTAL SPREAD	:	2.196	2.066	1.796
VERTICAL SPREAD	:	1.802	1.635	1.633
EXTREME SPREAD	:	2.372	2.188	1.805
NUMBER IN ONE INCH CIRCLE =	:	2		
NUMBER IN TWO INCH CIRCLE =	:	7		
NUMBER IN THREE INCH CIRCLE =	:	10		

31 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8594680

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 1

2in = 8

3in = 10

HS= 1.526

VS= 2.288

GS= 2.700

CENTROID #

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.540	.430	.474
MINIMUM X	-.986	-.595	-.550
MAXIMUM Y	1.097	.856	.722
MINIMUM Y	-1.191	-1.069	-.637
CENTROID X	.063	.173	.129
CENTROID Y	.081	-.041	.093
POA TO CENTROID in.	.103	.177	.159
MIN RADIUS	.035	.171	.045
MEAN RADIUS	.708	.619	.537
MAX RADIUS	1.475	1.126	.752
HORIZONTAL SPREAD	1.526	1.025	1.025
VERTICAL SPREAD	2.288	1.925	1.359
EXTREME SPREAD	2.700	2.018	1.365
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	8		
NUMBER IN THREE INCH CIRCLE =	10		