G 659 1542
Replaces
C-6225473

08/22/07 07:53:19

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: RE00133015
Verify Repair | High Priority

Serial: C6225473 Model M24 SWS Center Fire
Caliber: 7.62 NATO Produced: 12/20/1988

Repairman:
Status: Closed 8/22/2007 7:14:10 AM

Address Information

Customer: (Received From)	Return To: (Received From)
Name: TRANSPORTATION OFFICER	TRANSPORTATION OFFICER
Address 1: XR WOK8 USA ROCK ISL ARSENAL	XR WOK8 USA ROCK ISL ARSENAL
Address 2: BLDG 299 GILLESPIE AVE _BECK PO Box:	BLDG 299 GILLESPIE AVE _BECK PO Box:
City: ROCK ISLAND	ROCK ISLAND
State: IL Zip Code: 61299 Country: US	State: IL Zip Code: 61299 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
A057	Frt and Rear Sgt Base	1

Repair Search | Refresh | Close

naglet | 8/22/2007 | 7:53 AM | CAPS | NUM | INS | SCRL

start | Inbox - Micr... | Calendar - M... | FW: Restrict... | Arms Service... | 7:53 AM

G6591542 (Rem)

Serial Number: C6225473

Model: M24 SWS

RE00133015

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFOMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6591542.__0
FILE DATE AND TIME: 09/19/2007 21:10

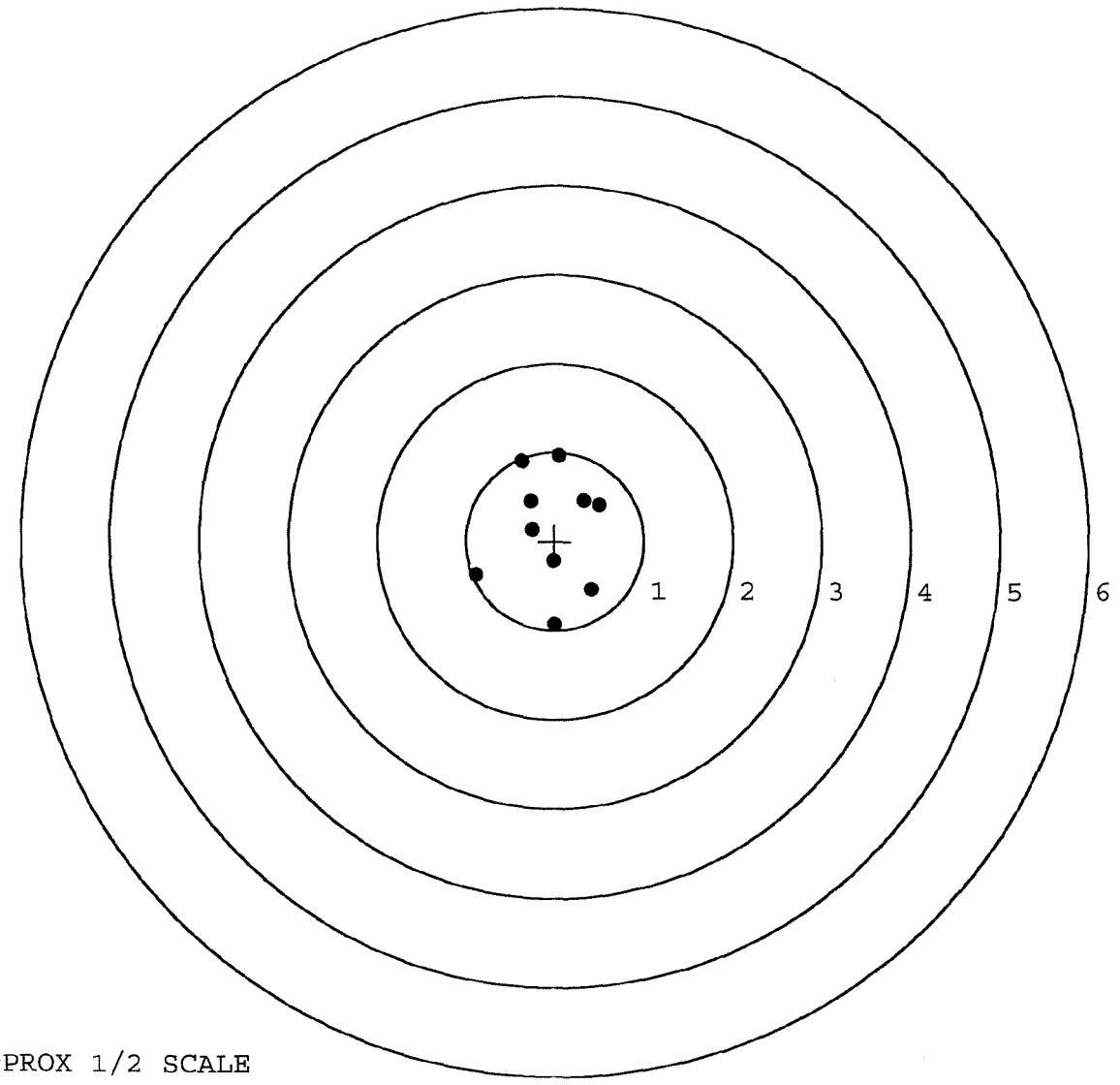
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.061
The Average Y Centroid of the Five Target Set:	0.124
The Average Point of Impact of the Five Target Set:	0.138
The Average Mean Radius of the Five Target Set:	0.697
The Distance from POA to Centroid Target #1:	0.131
The Distance from Centroid Target #2 to Centroid Target #1:	0.171
The Distance from Centroid Target #3 to Centroid Target #1:	0.448
The Distance from Centroid Target #4 to Centroid Target #1:	0.375
The Distance from Centroid Target #5 to Centroid Target #1:	0.109

SERIAL NUMBER: G6591542.__0
TARGET NUMBER: 1
FILE DATE: 09/19/2007
FILE TIME: 21:10

X CENTROID:	-0.048
Y CENTROID:	0.122
POA TO CENTROID:	0.131
HORZ SPREAD:	1.385
VERT SPREAD:	1.905
GROUP SPREAD:	1.906
MIN RADIUS:	0.203
MAX RADIUS:	1.064
MEAN RADIUS:	0.661
# IN 1 IN DIAMETER:	3
# IN 2 IN DIAMETER:	9
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	-0.368	0.895
2:	-0.270	0.452
3:	-0.251	0.133
4:	-0.016	-0.222
5:	0.419	-0.544
6:	0.006	-0.941
7:	-0.884	-0.385
8:	0.501	0.409
9:	0.330	0.454
10:	0.050	0.964

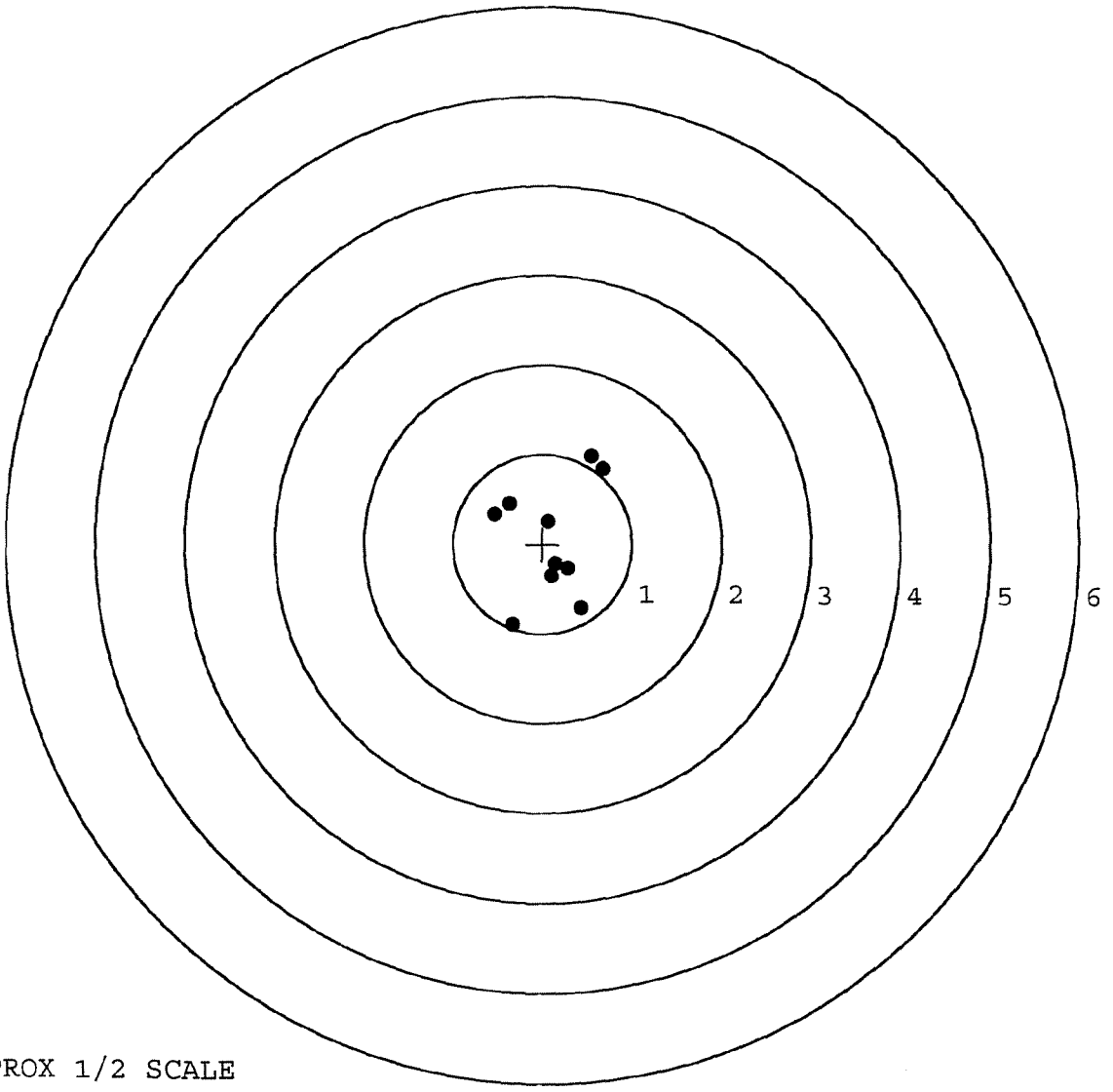


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6591542.__0
TARGET NUMBER: 2
FILE DATE: 09/19/2007
FILE TIME: 21:10

X CENTROID:	0.101
Y CENTROID:	0.038
POA TO CENTROID:	0.108
HORZ SPREAD:	1.201
VERT SPREAD:	1.889
GROUP SPREAD:	2.082
MIN RADIUS:	0.214
MAX RADIUS:	1.046
MEAN RADIUS:	0.646
# IN 1 IN DIAMETER:	4
# IN 2 IN DIAMETER:	8
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	-0.534	0.329
2:	-0.377	0.449
3:	0.062	0.248
4:	0.101	-0.362
5:	0.289	-0.273
6:	0.436	-0.711
7:	-0.330	-0.904
8:	0.667	0.845
9:	0.545	0.985
10:	0.151	-0.226

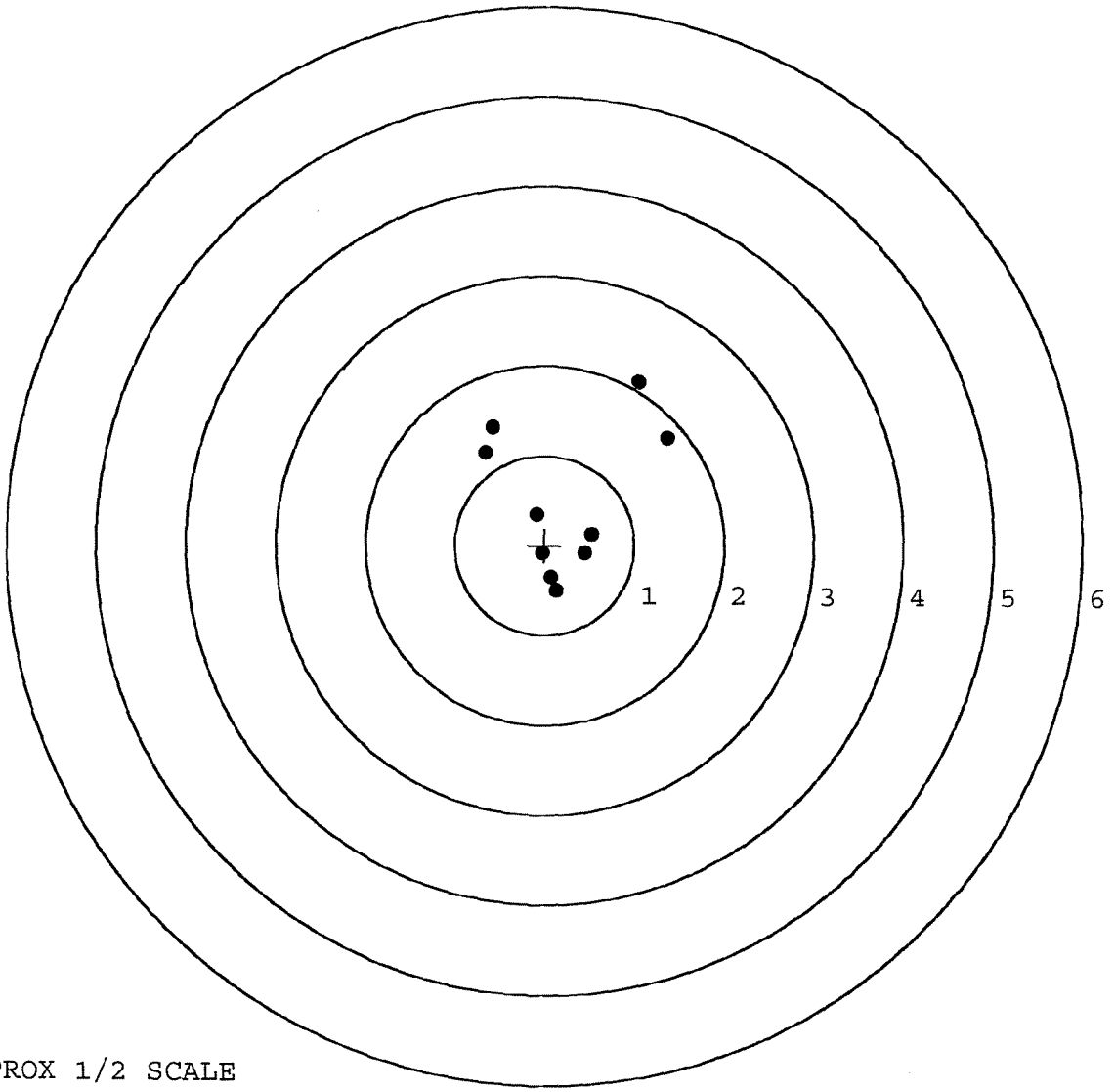


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6591542.__0
TARGET NUMBER: 3
FILE DATE: 09/19/2007
FILE TIME: 21:10

X CENTROID:	0.221
Y CENTROID:	0.479
POA TO CENTROID:	0.528
HORZ SPREAD:	2.027
VERT SPREAD:	2.333
GROUP SPREAD:	2.501
MIN RADIUS:	0.338
MAX RADIUS:	1.571
MEAN RADIUS:	0.901
# IN 1 IN DIAMETER:	2
# IN 2 IN DIAMETER:	6
# in 3 IN DIAMETER:	9

POINT#	X	Y
1:	-0.583	1.308
2:	-0.670	1.031
3:	-0.087	0.341
4:	-0.030	-0.090
5:	0.136	-0.511
6:	0.453	-0.083
7:	0.525	0.132
8:	1.357	1.211
9:	1.037	1.822
10:	0.075	-0.366

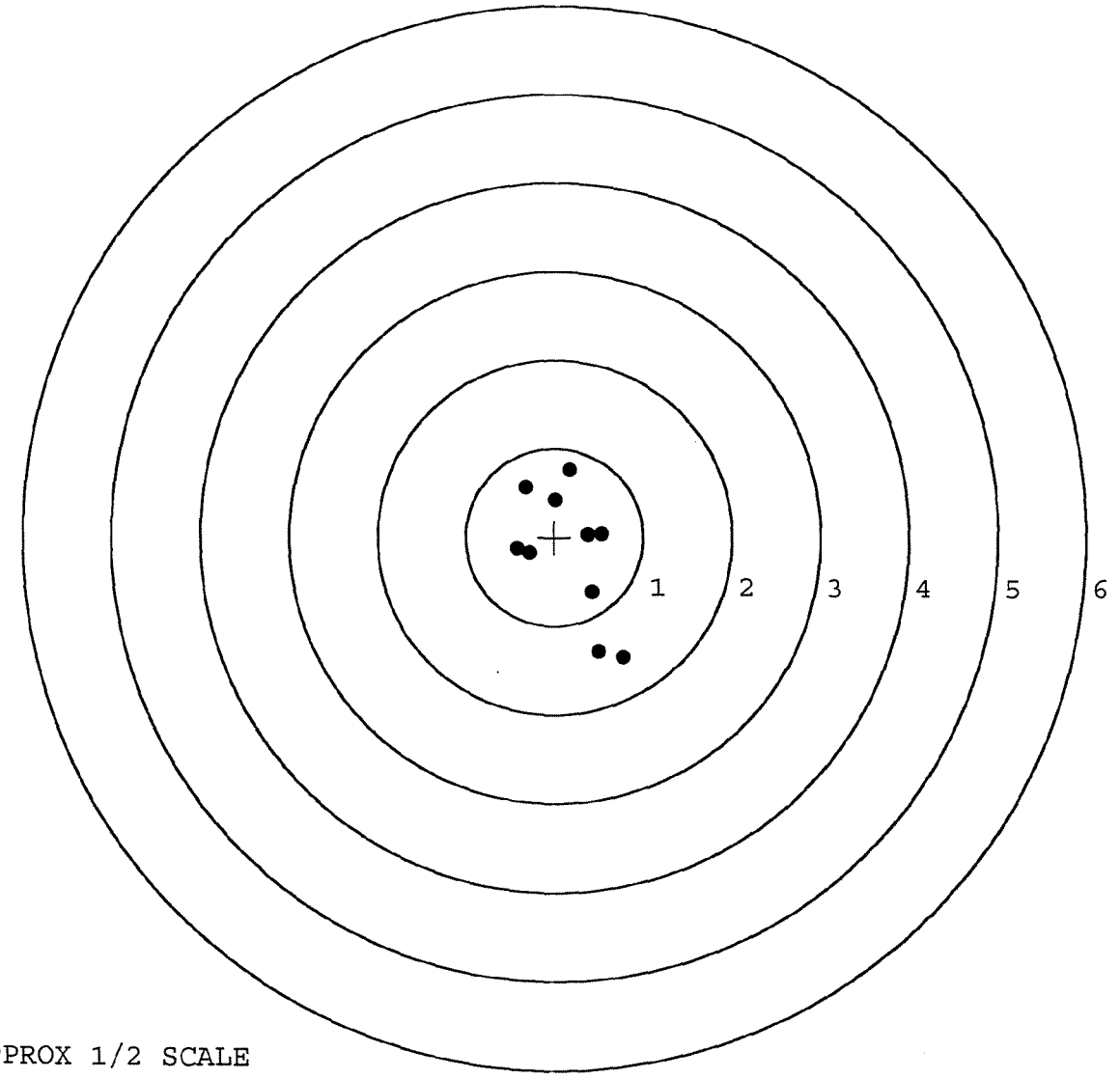


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6591542.__0
TARGET NUMBER: 4
FILE DATE: 09/19/2007
FILE TIME: 21:10

X CENTROID:	0.179
Y CENTROID:	-0.176
POA TO CENTROID:	0.251
HORZ SPREAD:	1.208
VERT SPREAD:	2.104
GROUP SPREAD:	2.207
MIN RADIUS:	0.298
MAX RADIUS:	1.321
MEAN RADIUS:	0.721
# IN 1 IN DIAMETER:	3
# IN 2 IN DIAMETER:	8
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	-0.330	0.554
2:	0.012	0.415
3:	0.169	0.754
4:	0.535	0.046
5:	0.386	0.037
6:	0.430	-0.616
7:	0.507	-1.291
8:	0.786	-1.350
9:	-0.286	-0.184
10:	-0.422	-0.129

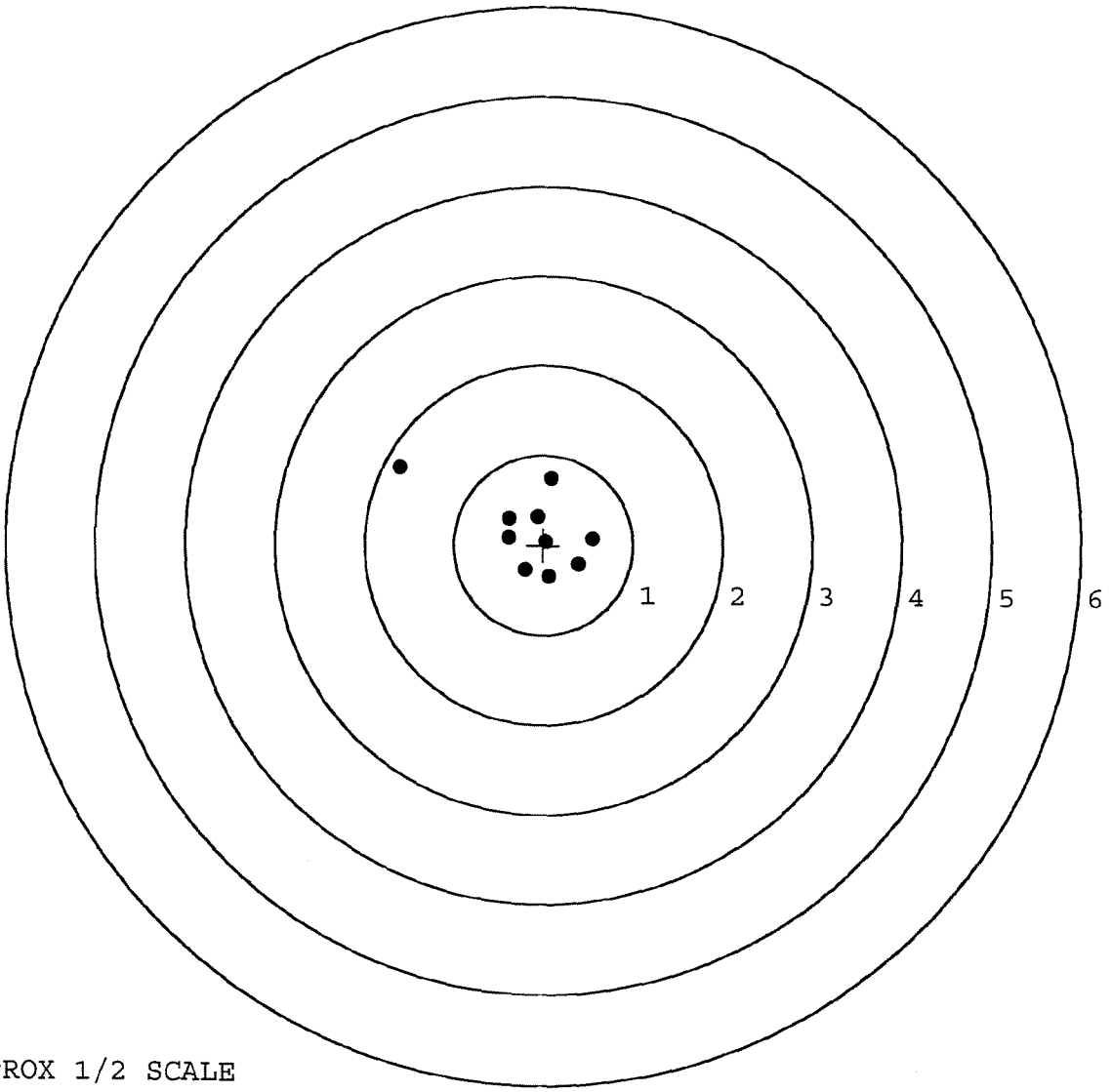


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6591542.__0
TARGET NUMBER: 5
FILE DATE: 09/19/2007
FILE TIME: 21:10

X CENTROID:	-0.150
Y CENTROID:	0.159
POA TO CENTROID:	0.219
HORZ SPREAD:	2.176
VERT SPREAD:	1.205
GROUP SPREAD:	2.312
MIN RADIUS:	0.184
MAX RADIUS:	1.626
MEAN RADIUS:	0.554
# IN 1 IN DIAMETER:	5
# IN 2 IN DIAMETER:	9
# in 3 IN DIAMETER:	9

POINT#	X	Y
1:	0.088	0.745
2:	-1.619	0.857
3:	-0.384	0.298
4:	-0.061	0.320
5:	-0.385	0.083
6:	-0.194	-0.277
7:	0.068	-0.348
8:	0.396	-0.209
9:	0.032	0.045
10:	0.557	0.077



TARGET APPROX 1/2 SCALE

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

R & E NUMBER 133015

SERIAL NUMBER C022543 GG591542 (RW)

LOG-IN DATE 8-22-07

OPERATION #	OPERATION NAME						DATE	INITIAL
500	DIS-ASSEMBLE GUN						9-10-07	RTC
505	RE-BARREL						9-11-07	RTC
560	ASSEMBLE						9-11-07	RTC
600	PROOF						9-12-07	TRW
605	CHECK HEADSPACE						9-12-07	TRW
610	DIS-ASSEMBLE GUN						9-12-07	RTC
612	MAGNAFLUX	MAGNA-FLUX					9-13-07	JG
510	DRILL AND TAP						9-12-07	FM
615	ROLLMARK CALIBER	OPERATOR JG					9-12-07	CW
618	ROTO-BLAST						9-12-07	RC
620	APPLY COATINGS						9/14/07	RB
625	FINAL ASSEMBLY						9-19-07	RTC
640	FUNCTION TEST AND	(PASS)	FAIL				9/19/07	MM
650	TARGET	(PASS)	FAIL				9/19/07	MM
	MALFUNCTION	CORRECTION						
	MALFUNCTION	CORRECTION	N/A					
	MALFUNCTION	CORRECTION						
	MALFUNCTION	CORRECTION					9-19-07	SD
670	FINAL INSPECTION						9-21-07	DA
	A) HEADSPACE	PASS	FAIL				9-21-07	DA
	B) TRIGGER PULL (+/- .5 LBS, MIN 2.50 LBS, MAX 4.0 LBS)	2.85	2.88	2.87	2.93	2.92	9/21/07	DA
680	F) SAFETY ON FORCE (2 LBS MIN, 10 LBS MAX)	4.0	4.5	4.0			9/21/07	DA
	G) SAFETY OFF FORCE (2 LBS MIN)	2.0	2.0	2.0			9/21/07	DA
	I) FIRING PIN INDENT .020	.023	.023	.024			9/21/07	DA
690	PACK						9-24-07	DA

Scope # 1764

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6225473

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	pjc.
	Magnaflux Bolt		9-14-88	pjc.
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				2NOV88		JLS
	F) Safety on Force	4	4	4	2NOV88		JLS
	G) Safety off Force	3	3	3	2NOV88		JLS
	H) Trigger Pull Test & Retainabilty				2NOV88		JLS
	I) Firing Pin Indent	.021	.021	.021	2NOV88		JLS
	J) Assemble Stock				11/2/88		RW
	K) Attach Front & Rear Sight Assemblies						
	L) Iron Sight Alignment				11/2/88		RW
	M) Detach Front & Rear Sights & place in numbered container				11/2/88		RW
	N) Attach Scope to Rifle				11/2/88		RW
	O) Detach & Attach Scope 20 times				8NOV88		JLS
640	Gallery Target & Test	50 R	101 L		11-9-88		AC
	A) Optical Clearity of Scope	OK			11-9-88		AC
645	Inspect for Live Ammo	NONE			11-9-88		AC
655	Final Inspection A) Headspace				29NOV88		JLS
	B) Trigger Pull	2.45	2.47	2.44	2.46	2.46	JLS
	C) Function				29NOV88		JLS
	D) Assemble Swivel Studs				29NOV88		JLS
660	Pack				15Dec88		JLS

SWS TRIGGER PULL TEST

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

SERIAL NO. C6225423
DATE 2/20/88
TESTER JS

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.33	2.37	2.42	2.45	MIN. SETTING,
PULL #2	2.29	2.27	2.41	2.47	NO AVG. OF 5
PULL #3	2.24	2.31	2.46	2.44	READINGS ACCEPT-
PULL #4	2.29	2.28	2.45	2.46	ABLE LESS THAN 2#
PULL #5	2.37	2.31	2.39	2.46	
TOTAL	11.52	11.54	12.13	12.28	
AVG.	2.304	2.308	2.426	2.456	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.28	3.21		
PULL #2	3.33	3.35		
PULL #3	3.28	3.31		
PULL #4	3.32	3.34		
PULL #5	3.19	3.38		
TOTAL	16.40	16.59		
AVG.	3.28	3.318		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.21	4.05		4.01
PULL #2	4.25	4.10		4.05
PULL #3	4.16	4.19		3.86
PULL #4	4.23	4.17		3.97
PULL #5	4.19	4.22		3.91
TOTAL	21.04	20.73		19.80
AVG.	4.208	4.146		3.96

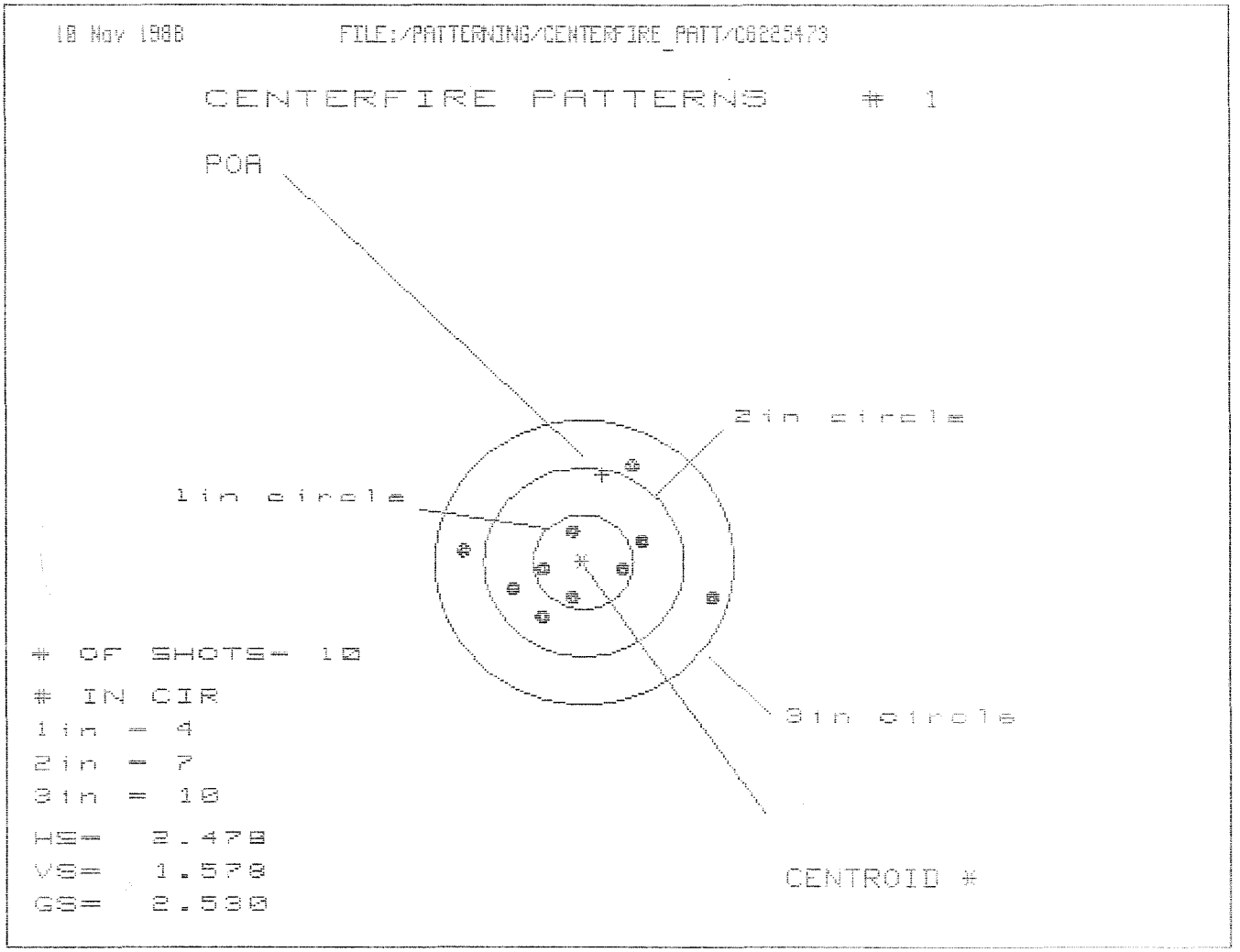
CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6225473

CENTROIDAL DISTANCES

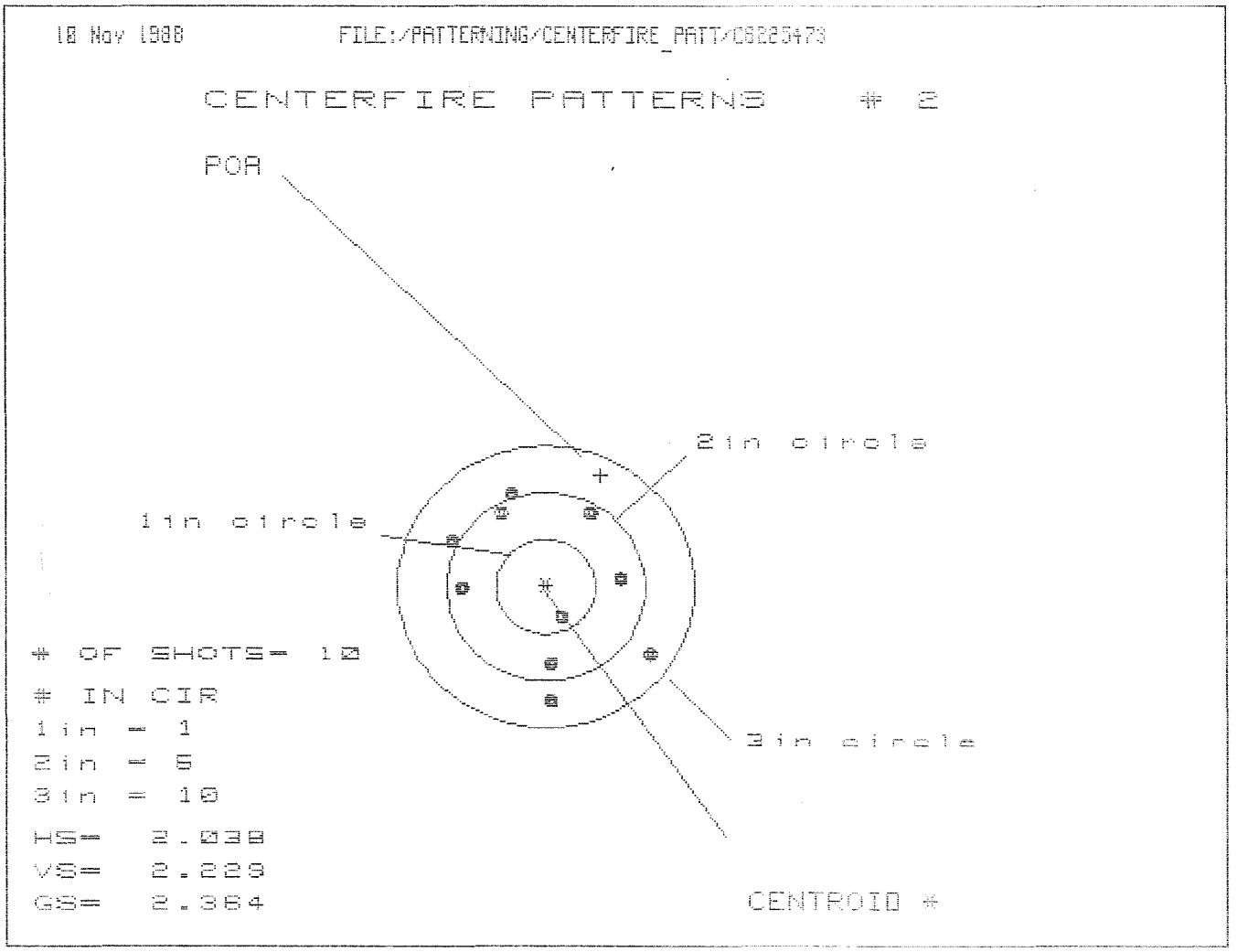
0	TO	1	.944892
1	TO	2	.448486
1	TO	3	.143265
1	TO	4	.699952
1	TO	5	1.11034

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.4054
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.624
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .744127

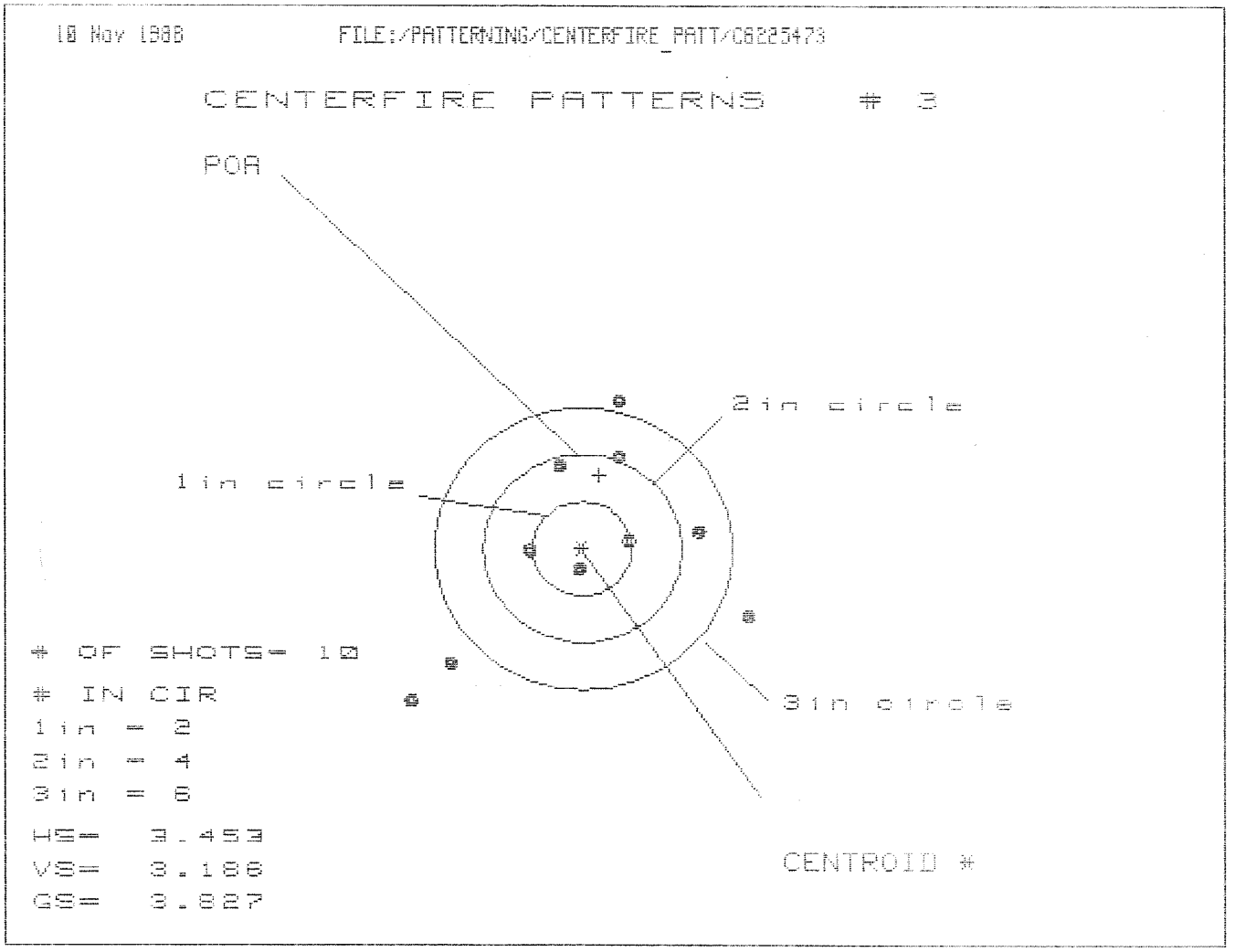
THE AMR FOR THIS RIFLE IS: 1.019



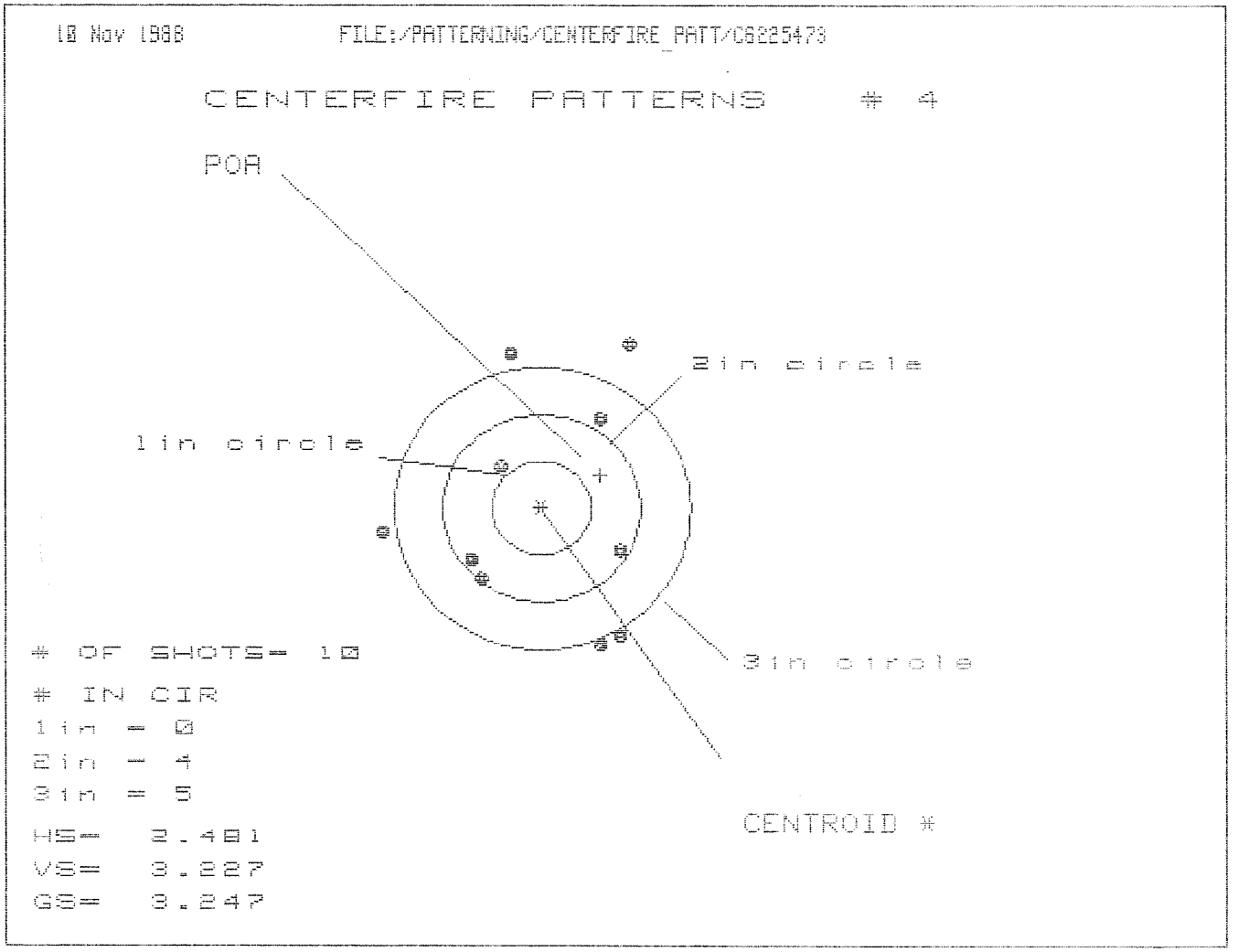
PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.303	.725	.596
MINIMUM X	:	-1.175	-1.030	-.678
MAXIMUM Y	:	1.031	.994	1.011
MINIMUM Y	:	-.547	-.584	-.567
CENTROID X	:	-.188	-.333	-.204
CENTROID Y	:	-.926	-.889	-.906
POA TO CENTROID in.	:	.945	.949	.928
MIN RADIUS	:	.293	.248	.269
MEAN RADIUS	:	.722	.639	.586
MAX RADIUS	:	1.345	1.192	1.141
HORIZONTAL SPREAD	:	2.478	1.755	1.274
VERTICAL SPREAD	:	1.578	1.578	1.578
EXTREME SPREAD	:	2.530	1.893	1.809
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	



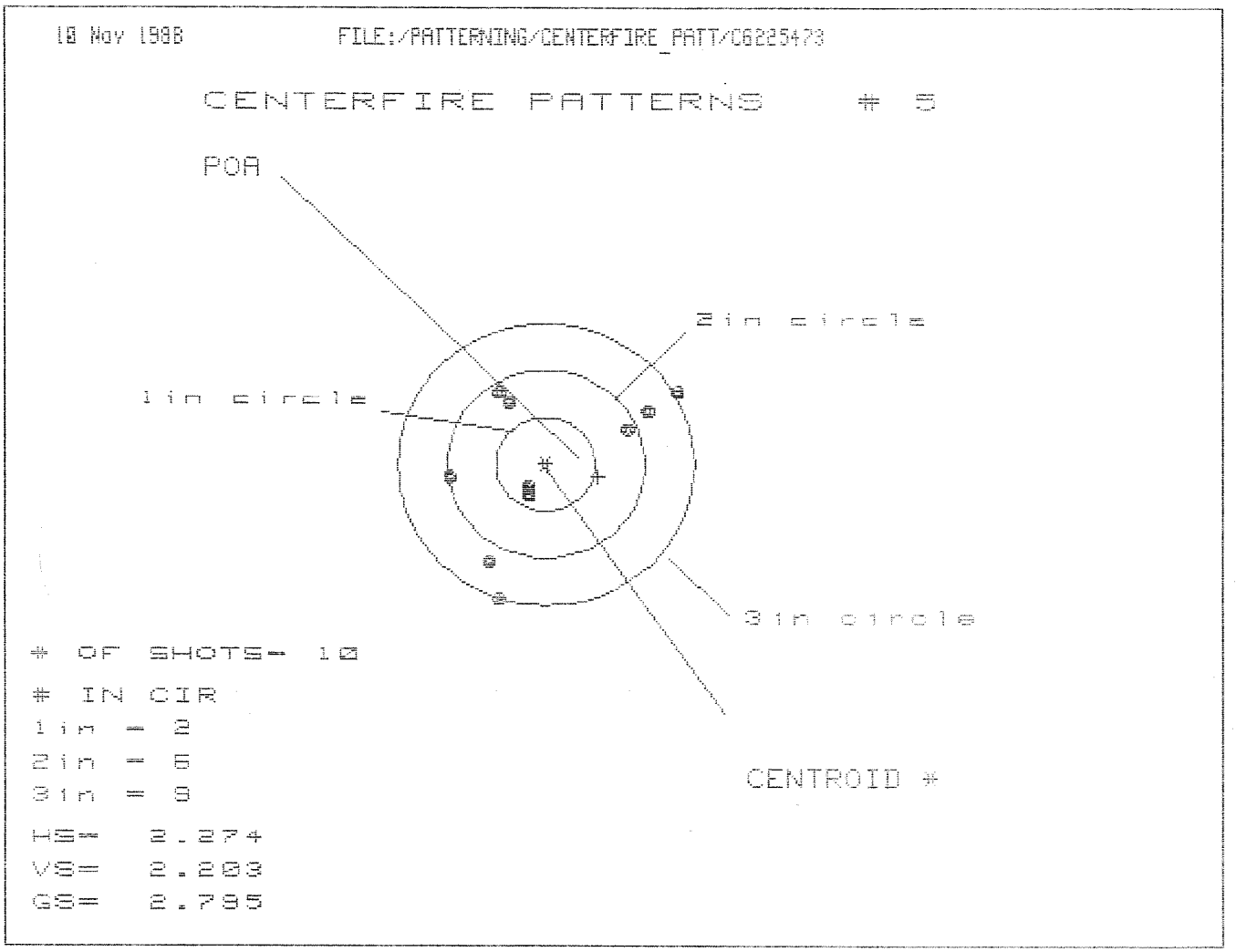
PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.086	.858	.885
MINIMUM X	:	-.952	-.831	-.804
MAXIMUM Y	:	1.000	.919	.755
MINIMUM Y	:	-1.229	-1.310	-1.016
CENTROID X	:	-.552	-.673	-.700
CENTROID Y	:	-1.188	-1.107	-.943
POA TO CENTROID in.	:	1.310	1.295	1.174
MIN RADIUS	:	.362	.491	.615
MEAN RADIUS	:	.916	.866	.793
MAX RADIUS	:	1.309	1.329	1.029
HORIZONTAL SPREAD	:	2.038	1.689	1.689
VERTICAL SPREAD	:	2.229	2.229	1.771
EXTREME SPREAD	:	2.364	2.274	1.808
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	



PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.673	1.475	1.278
MINIMUM X	:	-1.780	-1.573	-.950
MAXIMUM Y	:	1.565	1.385	1.208
MINIMUM Y	:	-1.621	-1.413	-1.092
CENTROID X	:	-.169	.029	.226
CENTROID Y	:	-.784	-.604	-.427
POA TO CENTROID in.	:	.802	.604	.483
MIN RADIUS	:	.222	.286	.279
MEAN RADIUS	:	1.211	1.045	.894
MAX RADIUS	:	2.408	2.115	1.681
HORIZONTAL SPREAD	:	3.453	3.048	2.228
VERTICAL SPREAD	:	3.186	2.798	2.300
EXTREME SPREAD	:	3.827	3.282	2.658
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		6	



PATTERN #	:	[redacted]		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.910	.928	.901
MINIMUM X	:	-1.571	-1.470	-1.497
MAXIMUM Y	:	1.793	1.803	1.352
MINIMUM Y	:	-1.434	-1.234	-1.009
CENTROID X	:	-.590	-.691	-.664
CENTROID Y	:	-.353	-.553	-.778
POA TO CENTROID in.	:	.688	.885	1.023
MIN RADIUS	:	.594	.712	.629
MEAN RADIUS	:	1.284	1.177	1.076
MAX RADIUS	:	2.011	1.816	1.505
HORIZONTAL SPREAD	:	2.481	2.398	2.398
VERTICAL SPREAD	:	3.227	3.037	2.361
EXTREME SPREAD	:	3.247	3.205	2.544
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		5	



PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.307	1.185	1.148
MINIMUM X	:	-.967	-.821	-.858
MAXIMUM Y	:	.789	.874	.708
MINIMUM Y	:	-1.414	-1.329	-1.116
CENTROID X	:	-.528	-.674	-.637
CENTROID Y	:	.131	.046	.212
POA TO CENTROID in.	:	.544	.675	.671
MIN RADIUS	:	.328	.197	.366
MEAN RADIUS	:	.961	.867	.814
MAX RADIUS	:	1.516	1.373	1.264
HORIZONTAL SPREAD	:	2.274	2.006	2.006
VERTICAL SPREAD	:	2.203	2.203	1.824
EXTREME SPREAD	:	2.795	2.507	2.312
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	