

C6522354

MODEL 700™ M24

Model **SWS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



Repair Inquiry

Repair Number: RE00115235

Serial: C6522354 Model M24 SWS Center Fire
Caliber: 308

Repairman:

Verify Repair

Status:

Closed 8/2/2006 10:44:43 AM

Address Information

Customer:

☒ Received From

Return To:

☐ Received From

Name: MAT MOV BRANCH

MAT MOV BRANCH

Address 1: RAINIER AVE

RAINIER AVE

Address 2: BUDG 9611

PO Box:

BUDG 9611

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: NA

Fax:

Email:

Comments:

Received Condition

Fair

Condition
Notes:CSR
Notes:

Accessories Received

Code	Desc	Qty
A007	With Stud	3
A017	Scope Base	1
B000	FRONT AND REAR E	1

nagletj

8/2/2006

10:56 AM

CAPS

NUM

INS

SCRL

start

2 M...

Part...

5 I...

2 M...

Arm...

My...

ENL...

10:56 AM

Serial
Number:

C6522354

Model: M24 SWS



RE00115235

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6522354.___0
FILE DATE AND TIME: 08/16/2006 05:28

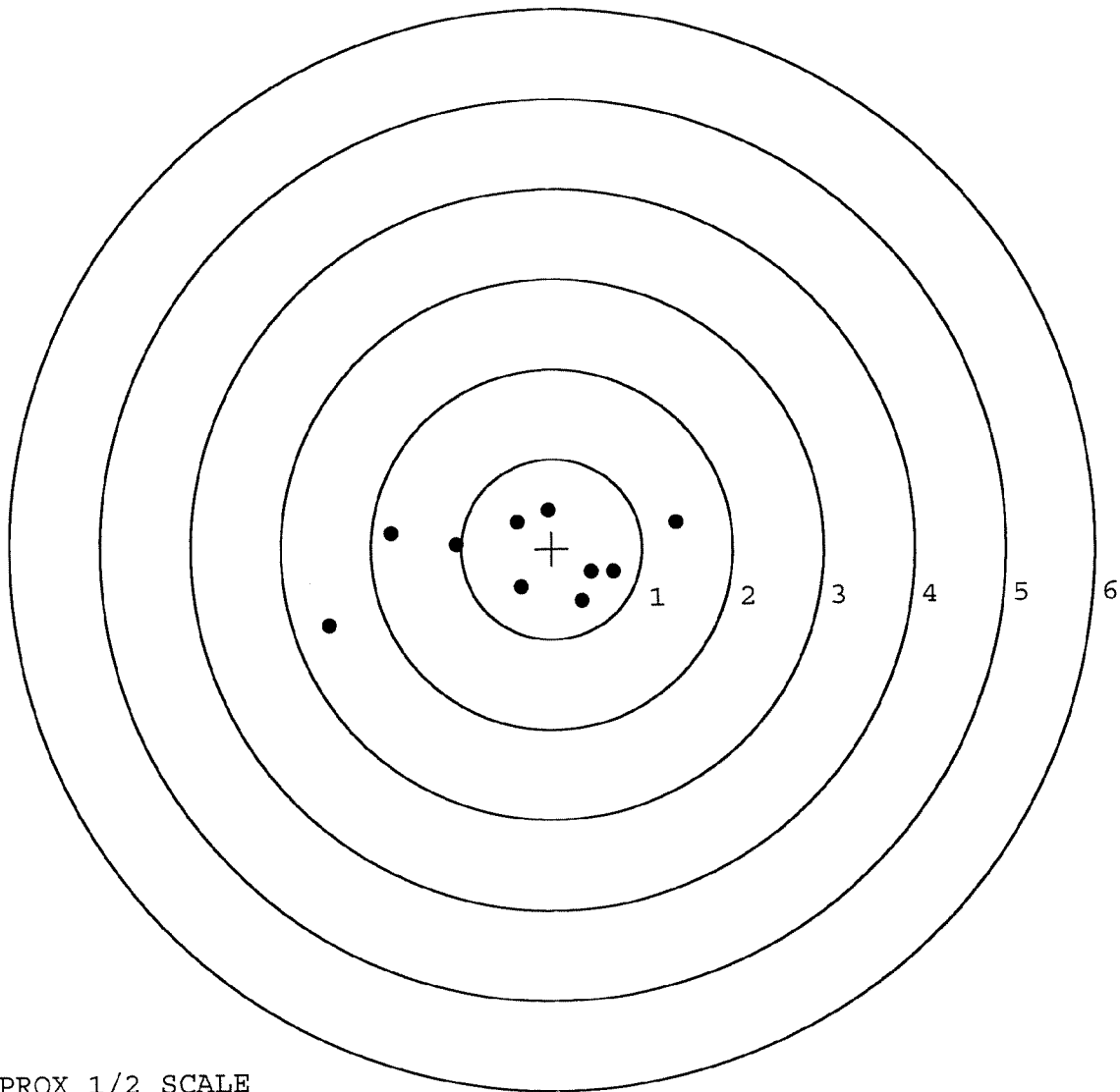
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.014
The Average Y Centroid of the Five Target Set:	-0.051
The Average Point of Impact of the Five Target Set:	0.053
The Average Mean Radius of the Five Target Set:	0.742
The Distance from POA to Centroid Target #1:	0.343
The Distance from Centroid Target #2 to Centroid Target #1:	0.367
The Distance from Centroid Target #3 to Centroid Target #1:	0.279
The Distance from Centroid Target #4 to Centroid Target #1:	0.675
The Distance from Centroid Target #5 to Centroid Target #1:	0.427

SERIAL NUMBER: C6522354. __0
 TARGET NUMBER: 1
 FILE DATE: 08/16/2006
 FILE TIME: 05:28

POINT#	X	Y
1:	1.375	0.279
2:	-0.036	0.422
3:	-0.382	0.294
4:	-0.340	-0.422
5:	-1.058	0.057
6:	-1.777	0.193
7:	-2.472	-0.829
8:	0.328	-0.585
9:	0.434	-0.261
10:	0.679	-0.261

X CENTROID: -0.325
 Y CENTROID: -0.111
 POA TO CENTROID: 0.343
 HORZ SPREAD: 3.847
 VERT SPREAD: 1.251
 GROUP SPREAD: 4.003
 MIN RADIUS: 0.311
 MAX RADIUS: 2.264
 MEAN RADIUS: 1.017
 # IN 1 IN DIAMETER: 2
 # IN 2 IN DIAMETER: 6
 # in 3 IN DIAMETER: 8

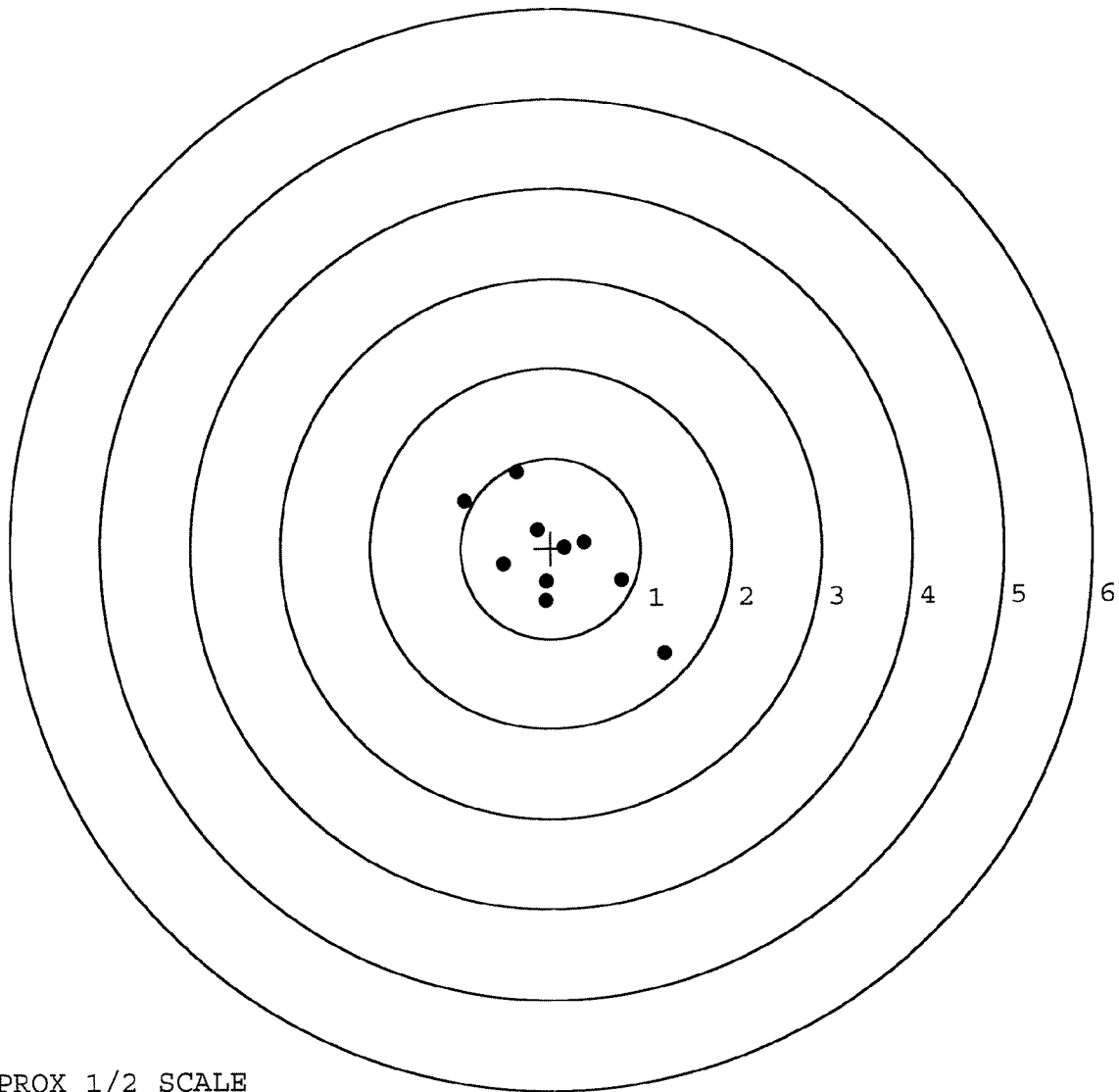


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6522354. __0
 TARGET NUMBER: 2
 FILE DATE: 08/16/2006
 FILE TIME: 05:28

POINT#	X	Y
1:	1.258	-1.180
2:	0.784	-0.357
3:	-0.377	0.848
4:	-0.956	0.530
5:	-0.530	-0.173
6:	-0.149	0.204
7:	0.148	0.013
8:	0.370	0.061
9:	-0.059	-0.370
10:	-0.065	-0.582

X CENTROID: 0.042
 Y CENTROID: -0.101
 POA TO CENTROID: 0.109
 HORZ SPREAD: 2.214
 VERT SPREAD: 2.028
 GROUP SPREAD: 2.797
 MIN RADIUS: 0.155
 MAX RADIUS: 1.626
 MEAN RADIUS: 0.687
 # IN 1 IN DIAMETER: 5
 # IN 2 IN DIAMETER: 7
 # in 3 IN DIAMETER: 9

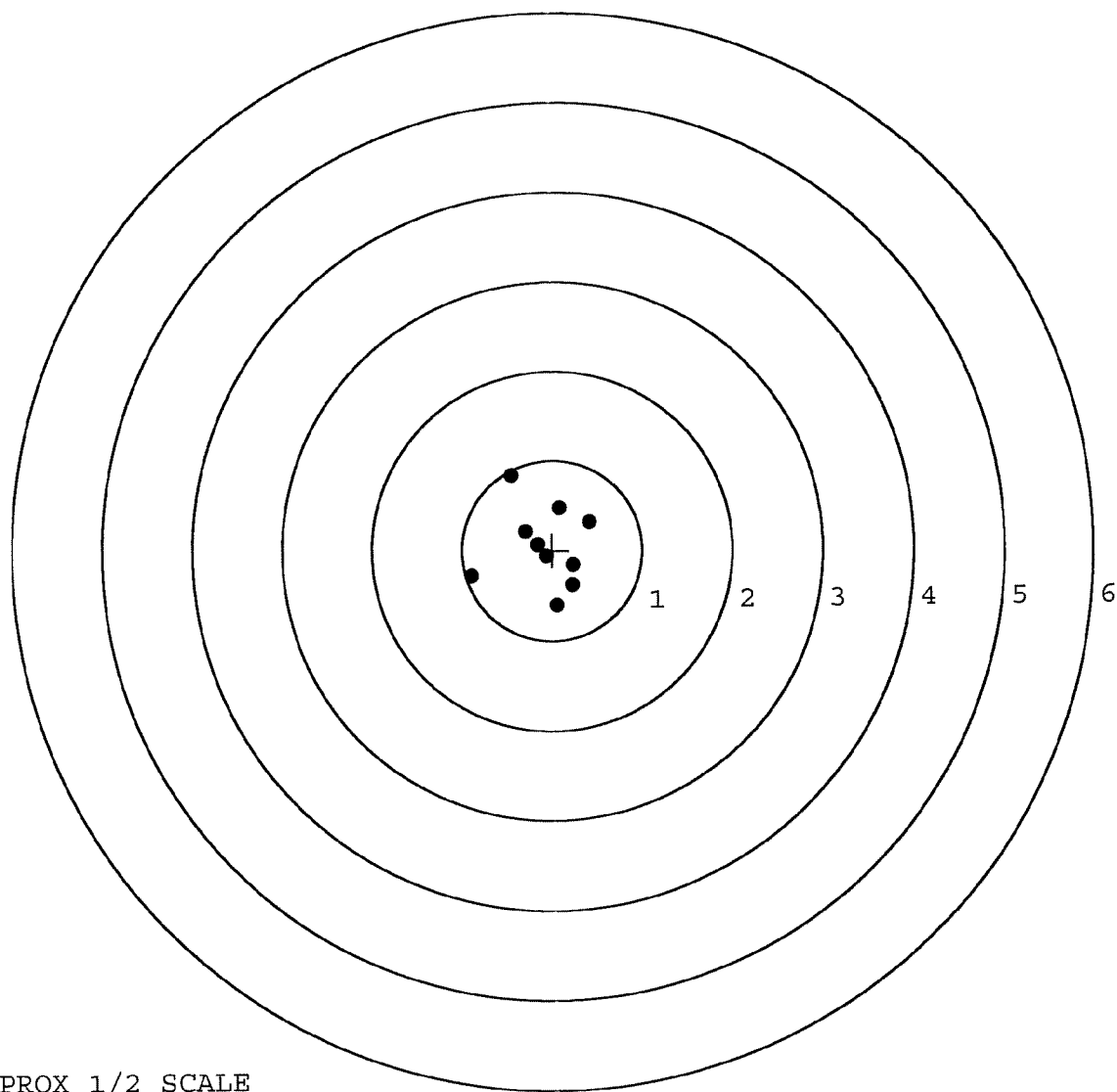


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6522354. __0
 TARGET NUMBER: 3
 FILE DATE: 08/16/2006
 FILE TIME: 05:28

POINT#	X	Y
1:	-0.895	-0.285
2:	-0.449	0.834
3:	0.086	0.469
4:	0.420	0.308
5:	0.047	-0.615
6:	-0.299	0.212
7:	-0.166	0.060
8:	-0.071	-0.069
9:	0.233	-0.171
10:	0.223	-0.392

X CENTROID: -0.087
 Y CENTROID: 0.035
 POA TO CENTROID: 0.094
 HORZ SPREAD: 1.315
 VERT SPREAD: 1.449
 GROUP SPREAD: 1.532
 MIN RADIUS: 0.083
 MAX RADIUS: 0.877
 MEAN RADIUS: 0.483
 # IN 1 IN DIAMETER: 5
 # IN 2 IN DIAMETER: 10
 # in 3 IN DIAMETER: 10

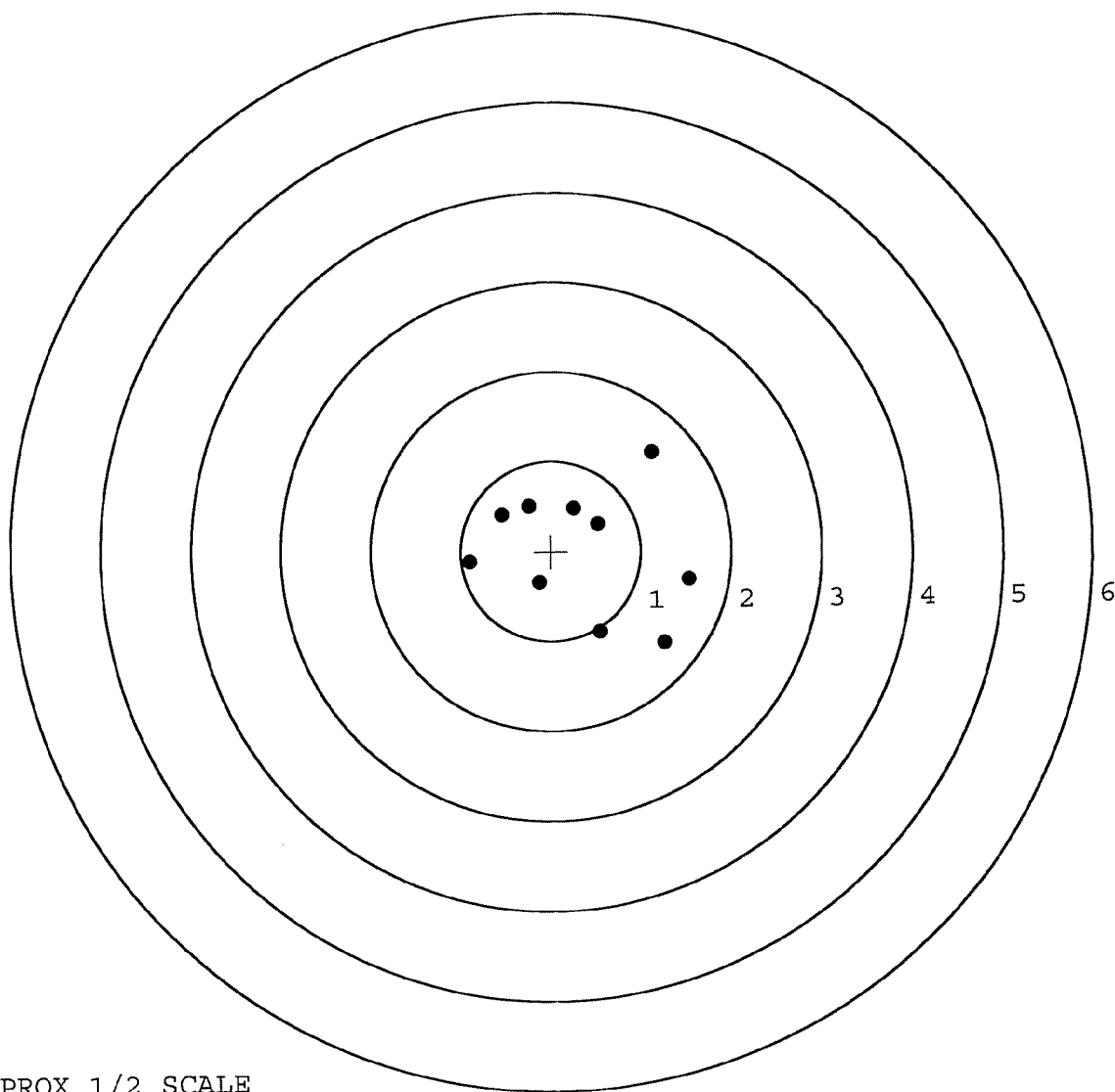


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6522354. 0
 TARGET NUMBER: 4
 FILE DATE: 08/16/2006
 FILE TIME: 05:28

POINT#	X	Y
1:	1.253	-1.036
2:	1.529	-0.333
3:	1.130	1.083
4:	0.537	-0.900
5:	0.526	0.303
6:	0.254	0.479
7:	-0.138	-0.350
8:	-0.244	0.504
9:	-0.541	0.414
10:	-0.903	-0.107

X CENTROID: 0.340
 Y CENTROID: 0.006
 POA TO CENTROID: 0.340
 HORZ SPREAD: 2.432
 VERT SPREAD: 2.119
 GROUP SPREAD: 2.348
 MIN RADIUS: 0.351
 MAX RADIUS: 1.385
 MEAN RADIUS: 0.930
 # IN 1 IN DIAMETER: 2
 # IN 2 IN DIAMETER: 6
 # in 3 IN DIAMETER: 10

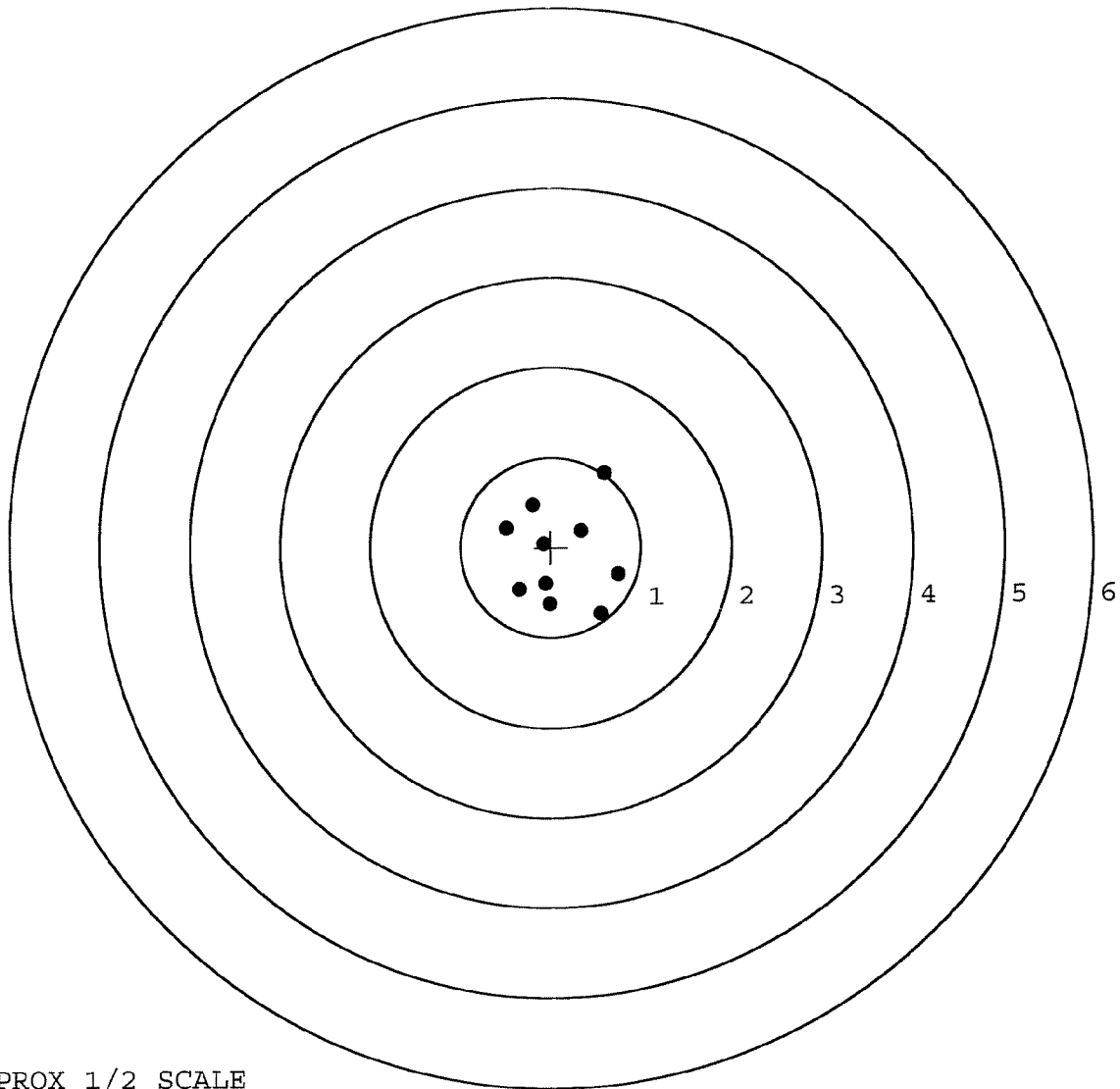


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6522354. __0
 TARGET NUMBER: 5
 FILE DATE: 08/16/2006
 FILE TIME: 05:28

X CENTROID: 0.101
 Y CENTROID: -0.083
 POA TO CENTROID: 0.131
 HORZ SPREAD: 1.239
 VERT SPREAD: 1.569
 GROUP SPREAD: 1.606
 MIN RADIUS: 0.223
 MAX RADIUS: 1.035
 MEAN RADIUS: 0.592
 # IN 1 IN DIAMETER: 3
 # IN 2 IN DIAMETER: 9
 # in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.550	-0.743
2:	0.743	-0.301
3:	0.596	0.826
4:	0.340	0.186
5:	-0.201	0.470
6:	-0.496	0.214
7:	-0.086	0.039
8:	-0.355	-0.468
9:	-0.063	-0.410
10:	-0.017	-0.639



TARGET APPROX 1/2 SCALE

INSPECTION CHECKLIST - REPAIRS

CONTRACT #: DAAE-20-02-C-0149

R & E NUMBER	115235		
SERIAL NUMBER	C6522354		
LOG-IN DATE	8-2-06		
OPERATION #	OPERATION NAME	DATE	INITIAL
500	DIS-ASSEMBLE GUN	8-7-06	RTZ
505	RE-BARREL	8-8-06	RTZ
420	ASSEMBLE	8-8-06	RTZ
440	PROOF	8-9-06	TLG
460	CHECK HEADSPACE	8-9-06	TLG
470	DIS-ASSEMBLE GUN	8-9-06	TLG
480	MAGNAFLUX	8-11-06	APD
510	DRILL AND TAP	8-10-06	TRW
500	ROLLMARK CALIBER	8-11-06	CW
520	GOFF BLAST BBL / REC	8-11-06	LB
530 & 540	APPLY COATINGS	8/13/06	RTZ
560	FINAL ASSEMBLY	8-15-06	RTZ
640	FUNCTION TEST AND	(PASS) FAIL	8-16-06 TRW
650	TARGET	(PASS) FAIL	8-16-06 TRW
	MALFUNCTION 26 clicks left window	CORRECTION OK	8-23-06 AC
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	8/16 BD
670	FINAL INSPECTION		8-17-06 MTH
	A) HEADSPACE	(PASS) FAIL	8-17-06 MTH
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	255 254 259 258 261 R.P.
680	F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX	4.0 3.5 3.5 8-17-06 DA
	G) SAFETY OFF FORCE	2 LBS MIN	2.5 2.2 2.5 8-17-06 DA
	I) FIRING PIN INDENT	.020	.023 .024 .024 8-17-06 DA
690	PACK		8-24-06 DA

F006 REV 5/2006

BARREL ASSEMBLY	STOCK ASSEMBLY
_____ BARREL	_____ STOCK
_____ RECEIVER	_____ SLING SWIVEL STUDS
_____ FRONT SIGHT BASE	_____ BUTT PATE
_____ REAR SIGHT BASE	_____ LOCK NUTS
_____ SCREWS	_____ BARREL CLEARANCE
_____ FINISH	_____ COLOR / FINISH
SCOPE ASSEMBLY	SYSTEM CASE
_____ SCOPE	_____ SCOPE CASE
_____ SCOPE RINGS	_____ IRON SIGHTS
_____ MOUNTING SCREWS	_____ DEPLOYMENT KIT
_____ MOUNTING BASE	TRIGGER ASSEMBLY
_____ SCREWS	_____ SAFETY OPERATION
_____ FINISH	_____ RE-SET TO FACTORY
_____ CLARITY	SPECS
COMMENTS: _____	

F006 REV 5/2006



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

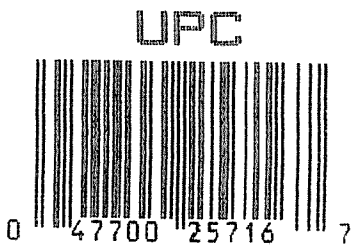
MODEL 700™ H24	SERIAL NO. C6522354
	ORDER NO. 5716

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

01



5716 C6522354



CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06522354
7 Aug 1990

CENTROIDAL DISTANCES

0 TO	1	.317844
1 TO	2	.346521
1 TO	3	.616351
1 TO	4	.652798
1 TO	5	.294124

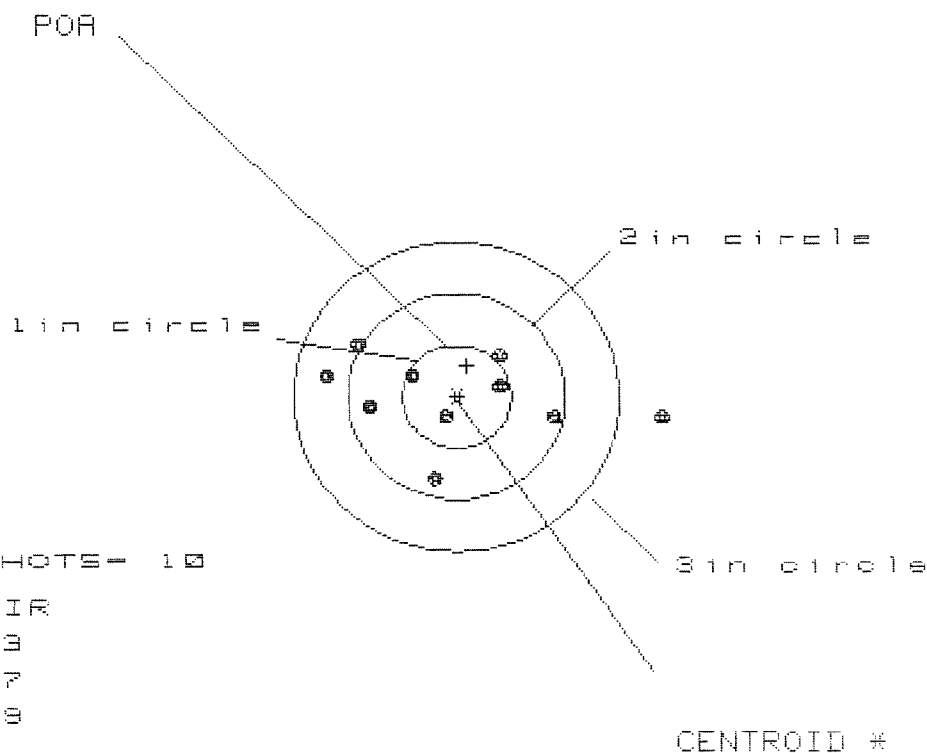
$\bar{x}_1$ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.462
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.221
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .512138
THE AMR FOR THIS RIFLE IS: .779

7 Aug 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6522354

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1 in = 3

2 in = 7

3 in = 9

HS = 3.071

VS = 1.283

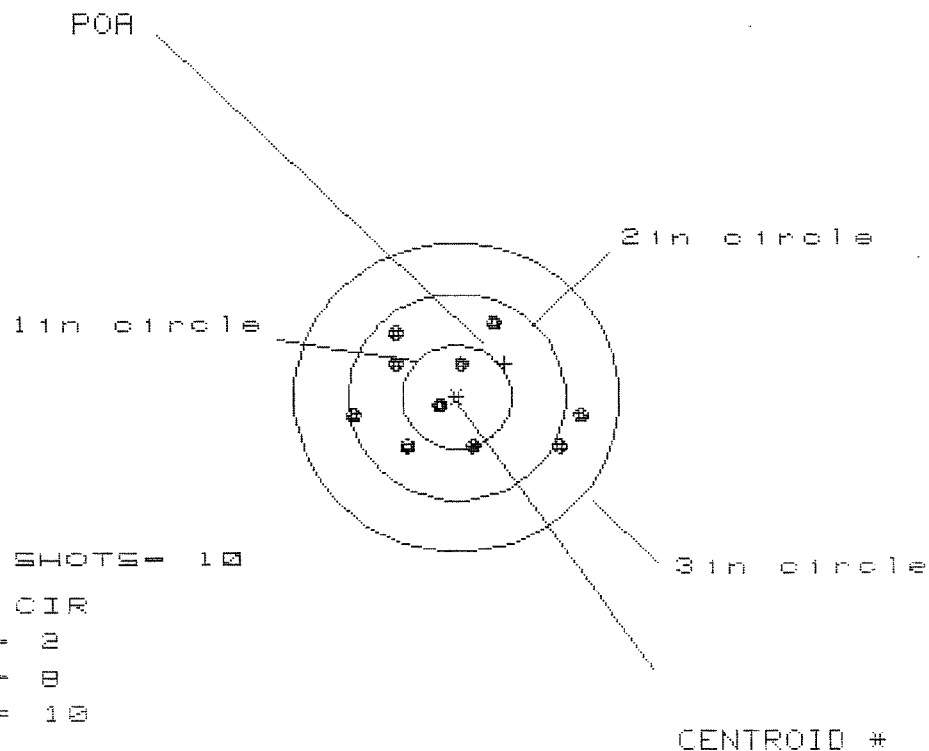
GS = 3.097

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.895	1.134	1.013
MINIMUM X	-1.176	-.965	-.784
MAXIMUM Y	.500	.483	.511
MINIMUM Y	-.783	-.800	-.772
CENTROID X	-.096	-.307	-.186
CENTROID Y	-.303	-.286	-.314
POA TO CENTROID in.	.318	.419	.365
MIN RADIUS	.190	.212	.153
MEAN RADIUS	.828	.685	.641
MAX RADIUS	1.902	1.161	1.038
HORIZONTAL SPREAD	3.071	2.099	1.797
VERTICAL SPREAD	1.283	1.283	1.283
EXTREME SPREAD	3.097	2.152	1.942
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	9		

7 Aug 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6522354

CENTERFIRE PATTERNS # 2



OF SHOTS - 10

IN CIR

1in = 2

2in = 8

3in = 10

HS = 2.038

VS = 1.266

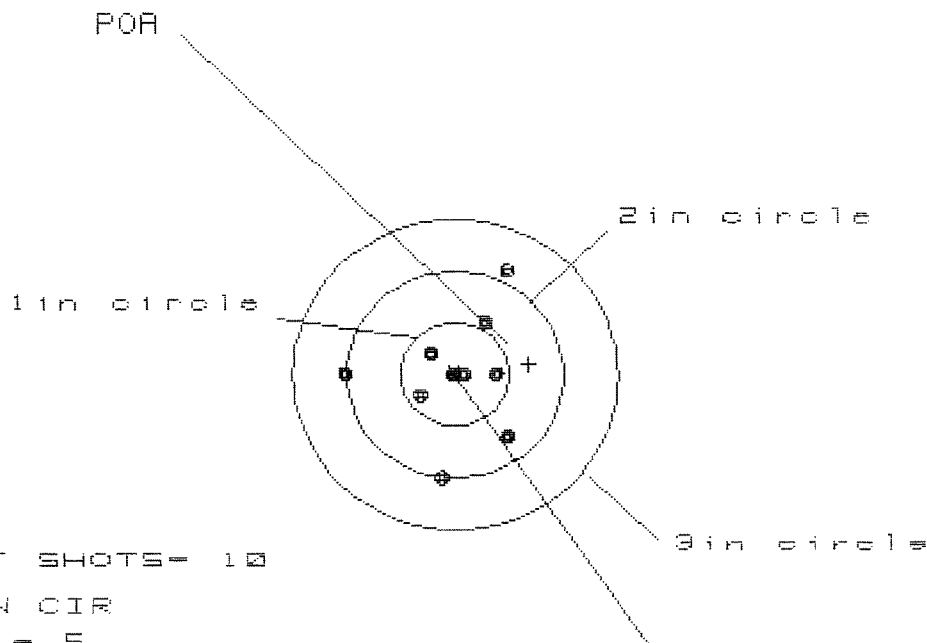
GS = 2.038

PATTERN #	:	2
SHOTS (BEST OF)	:	10
MAXIMUM X	:	1.093
MINIMUM X	:	-.945
MAXIMUM Y	:	.740
MINIMUM Y	:	-.526
CENTROID X	:	-.442
CENTROID Y	:	-.322
POA TO CENTROID in.	:	.547
MIN RADIUS	:	.175
MEAN RADIUS	:	.696
MAX RADIUS	:	1.113
HORIZONTAL SPREAD	:	2.038
VERTICAL SPREAD	:	1.266
EXTREME SPREAD	:	2.039
NUMBER IN ONE INCH CIRCLE	=	2
NUMBER IN TWO INCH CIRCLE	=	8
NUMBER IN THREE INCH CIRCLE	=	10

7 Aug 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6522354

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1 in = 5

2 in = 8

3 in = 10

HS= 1.545

VS= 1.924

GS= 2.022

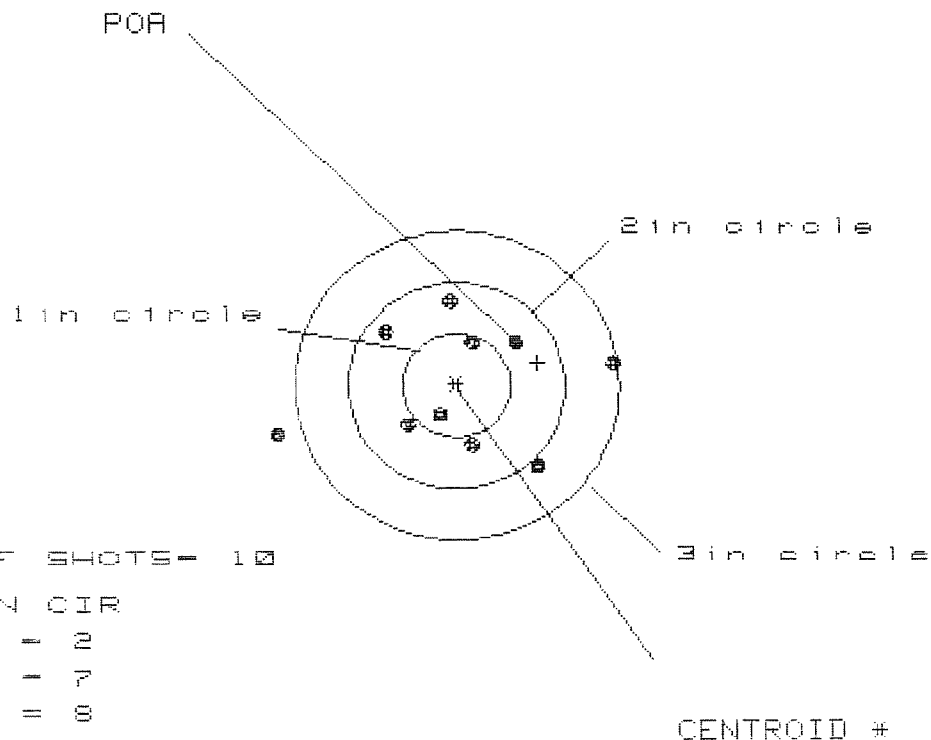
CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.507	.524	.401
MINIMUM X	:	-1.038	-.981	-.337
MAXIMUM Y	:	.953	.592	.602
MINIMUM Y	:	-.971	-.865	-.855
CENTROID X	:	-.679	-.736	-.613
CENTROID Y	:	-.103	-.209	-.219
POA TO CENTROID in.	:	.687	.765	.651
MIN RADIUS	:	.055	.120	.134
MEAN RADIUS	:	.548	.503	.438
MAX RADIUS	:	1.080	.985	.874
HORIZONTAL SPREAD	:	1.545	1.505	.738
VERTICAL SPREAD	:	1.924	1.457	1.457
EXTREME SPREAD	:	2.022	1.598	1.502
NUMBER IN ONE INCH CIRCLE	=		5	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	

7 Aug 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C8522354

CENTERFIRE PATTERNS # 4



MS = 3.184

VS = 1.592

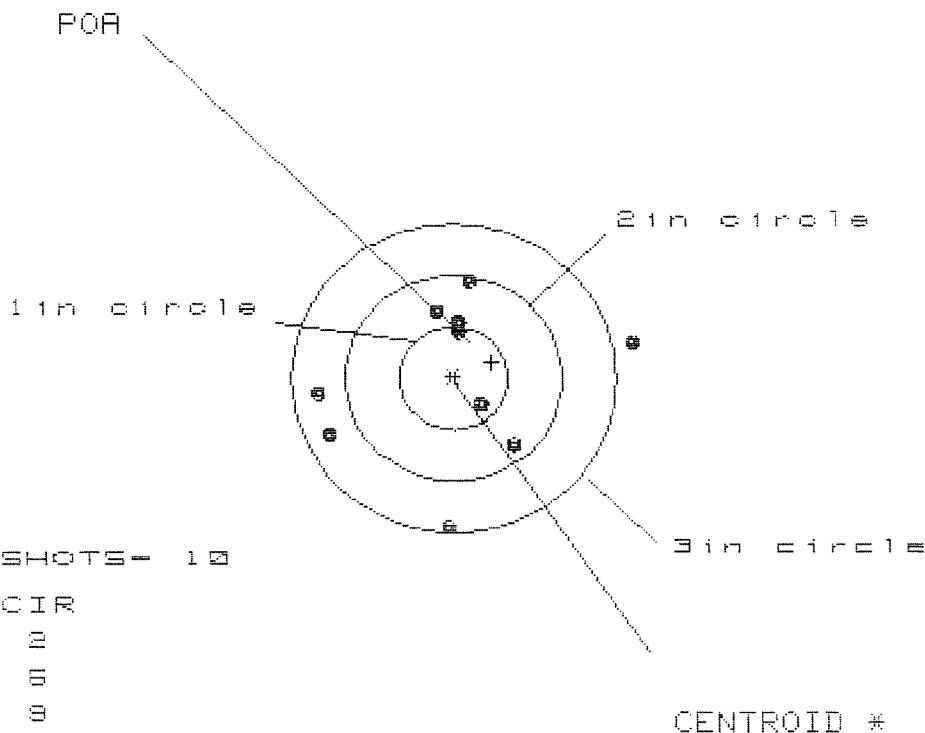
GS = 3.273

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.488	1.300	.717
MINIMUM X	:	-1.696	-.862	-.700
MAXIMUM Y	:	.837	.783	.811
MINIMUM Y	:	-.755	-.809	-.781
CENTROID X	:	-.744	-.556	-.718
CENTROID Y	:	-.224	-.170	-.198
POA TO CENTROID in.	:	.777	.581	.745
MIN RADIUS	:	.317	.400	.352
MEAN RADIUS	:	.871	.769	.681
MAX RADIUS	:	1.763	1.318	1.061
HORIZONTAL SPREAD	:	3.184	2.162	1.417
VERTICAL SPREAD	:	1.592	1.592	1.592
EXTREME SPREAD	:	3.273	2.172	1.880
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		8	

7 Aug 1998

FILE:/PATTERNING/CENTERFIRE_PATT/06522354

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 2

2in = 6

3in = 9

HS= 2.879

VS= 2.359

GS= 2.839

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.625	.752	.766
MINIMUM X	-1.254	-1.074	-1.060
MAXIMUM Y	.943	.979	.806
MINIMUM Y	-1.416	-1.380	-.793
CENTROID X	-.349	-.529	-.543
CENTROID Y	-.153	-.189	-.016
POA TO CENTROID in.	.381	.562	.543
MIN RADIUS	.295	.422	.437
MEAN RADIUS	.952	.885	.786
MAX RADIUS	1.656	1.384	1.218
HORIZONTAL SPREAD	2.879	1.826	1.826
VERTICAL SPREAD	2.359	2.359	1.599
EXTREME SPREAD	2.939	2.370	2.625
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		9	

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. 06522354

DATE 8/24/80

TESTER JK

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.50	2.49	2.41	2.45	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.37	2.47	2.50	2.36	
PULL #3	2.51	2.48	2.35	2.48	
PULL #4	2.47	2.37	2.41	2.49	
PULL #5	2.43	2.48	2.40	2.50	
TOTAL	12.28	12.29	12.07	12.28	
AVG.	2.456	2.458	2.414	2.456	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.30	3.16		
PULL #2	3.37	3.20		
PULL #3	3.05	3.26		
PULL #4	3.23	3.16		
PULL #5	3.20	3.18		
TOTAL	16.15	15.96		
AVG.	3.23	3.192		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.23	4.26		4.42
PULL #2	4.30	4.17		4.33
PULL #3	4.21	4.29		4.30
PULL #4	4.44	4.29		4.35
PULL #5	4.26	4.26		4.35
TOTAL	21.44	21.27		21.75
AVG.	4.288	4.254		4.35

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6522354

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	6 29	90	RW
600	Proof	6 29	90	RW
607	Check Headspace	6 29	90	RW
610	Dis-assemble Gun	6 29	90	RW
612	Magnaflux Barrel Action		7-12-90	KR
	Magnaflux Bolt		7-12-90	KR
615	Rollmark Caliber		7-12-90	L.S.
617	Drill and Tap Sight Holes		7/13/90	FB
618	Polish Barrel AB		7/16/90	WB
620	Apply Coatings (Barrel Action)		7-23-90	TA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		7/25/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		7/25/90	RW
	C) Inspect Ejector Hole for Chamfer		7/25/90	RW
	D) Oil Firing Pin Ass'y		7/25/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		8/24/90	98

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			8/2/90	RL
	G) Safety Off Force	3	2	3			8/2/90	RL
	H) Trigger Pull Test & Retainability						8/24/90	RL
	I) Firing Pin Indent	.0225	.0225	.0225			8/2/90	RL
	J) Assemble Stock						8/6/90	RW
	K) Assemble Swivel Studs						8/29/90	RL
	L) Attach Front and Rear Sight Assemblies						8/6/90	RW
	M) Iron Sight Alignment						8/6/90	RW
	N) Detach Front & Rear Sights & place in numbered container						8/6/90	RW
	O) Attach Scope to Rifle						8/6/90	RW
	P) Detach & Attach Scope 20 Times						8/6/90	RW
640	Gallery Target & Test						8-7-90	KI
	A) Time							KI
	B) Malfunctions							KI
	C) Pierced Primers							KI
	D) Optical Clarity of Scope							KI
645	Inspect for Live Ammo						8-7-90	KI
655	Final Inspection							
	A) Headspace						8/29/90	RL
	B) Trigger Pull	2.46	2.36	2.48	2.49	2.50	8/24/90	RL
	C) Function						8/29/90	RL
660	Pack						9/20/90	RF