

CB225157

MODEL 700™ M24

Model 700 M24™

Action

Barrel Length

Capacity

Order No. 5715

* Includes 1 in chamber.



BARBER - M24 0009578

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: RE00135888

Serial: C6225157 Model M24 SWS Center Fire
Caliber: 7.62 NATO Produced: 10/26/1988

Repairman:

Status:

Closed 10/26/2007 8:26:29 AM

Address Information

Customer:

Received From

Return To:

Received From

Name: US ARDEC RDECOM

US ARDEC RDECOM

Address 1: ROUTE 15 (973-724-4031)

ROUTE 15 (973-724-4031)

Address 2: BLDG. 34 NORTH

PO Box:

BLDG. 34 NORTH

PO Box:

City: PICATINNY ARSENAL

PICATINNY ARSENAL

State: NJ

Zip Code: 07806

Country: US

State: NJ

Zip Code: 07806

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	Fit and Rear Sgt Base	1

Repair Search

Refresh

Close

naglej

10/29/2007

10:57 AM

CAPS

NUM

INS

SCRL



Serial Number: C6225157
Model: M24 SWS
RE00135888

R & E NUMBER		135888	
SERIAL NUMBER		C6225157	
LOG-IN DATE		10-26-07	
OPERATION #	OPERATION NAME	DATE	INITIAL
500	DIS-ASSEMBLE GUN	11-13-07	SPD
505	RE-BARREL	11-27-07	SPD
560	ASSEMBLE	11-27-07	SPD
600	PROOF	11-27-07	TRW
605	CHECK HEADSPACE	11-27-07	TRW
610	DIS-ASSEMBLE GUN		
612	MAGNAFLUX	12-04-07	SB
510	DRILL AND TAP	12-3-07	TRW
615	ROLLMARK CALIBER	12-3-07	CW
618	ROTO-BLAST	12-5-07	SA
620	APPLY COATINGS	12-8-07	LV7
625	FINAL ASSEMBLY	12-11-07	RTZ
640	FUNCTION TEST AND	PASS FAIL	12-12-07 TRW
650	TARGET	PASS FAIL	12-12-07 TRW
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
670	FINAL INSPECTION		12-13-07 OA
	A) HEADSPACE	PASS FAIL	12-13-07 OA
	B) TRIGGER PULL	2.73 2.64 2.76 2.69 2.75	12-13-07 OA
		2 LBS MIN 10 LBS MAX	
680	F) SAFETY ON FORCE	5.6 4.5 4.5	12-13-07 OA
		2 LBS MIN	
	G) SAFETY OFF FORCE	2.0 2.0 2.0	12-13-07 OA
	I) FIRING PIN INDENT	.022 .022 .021	12-13-07 OA
690	PACK		4/7/09 FM

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6225157.___0
FILE DATE AND TIME: 12/12/2007 13:00

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

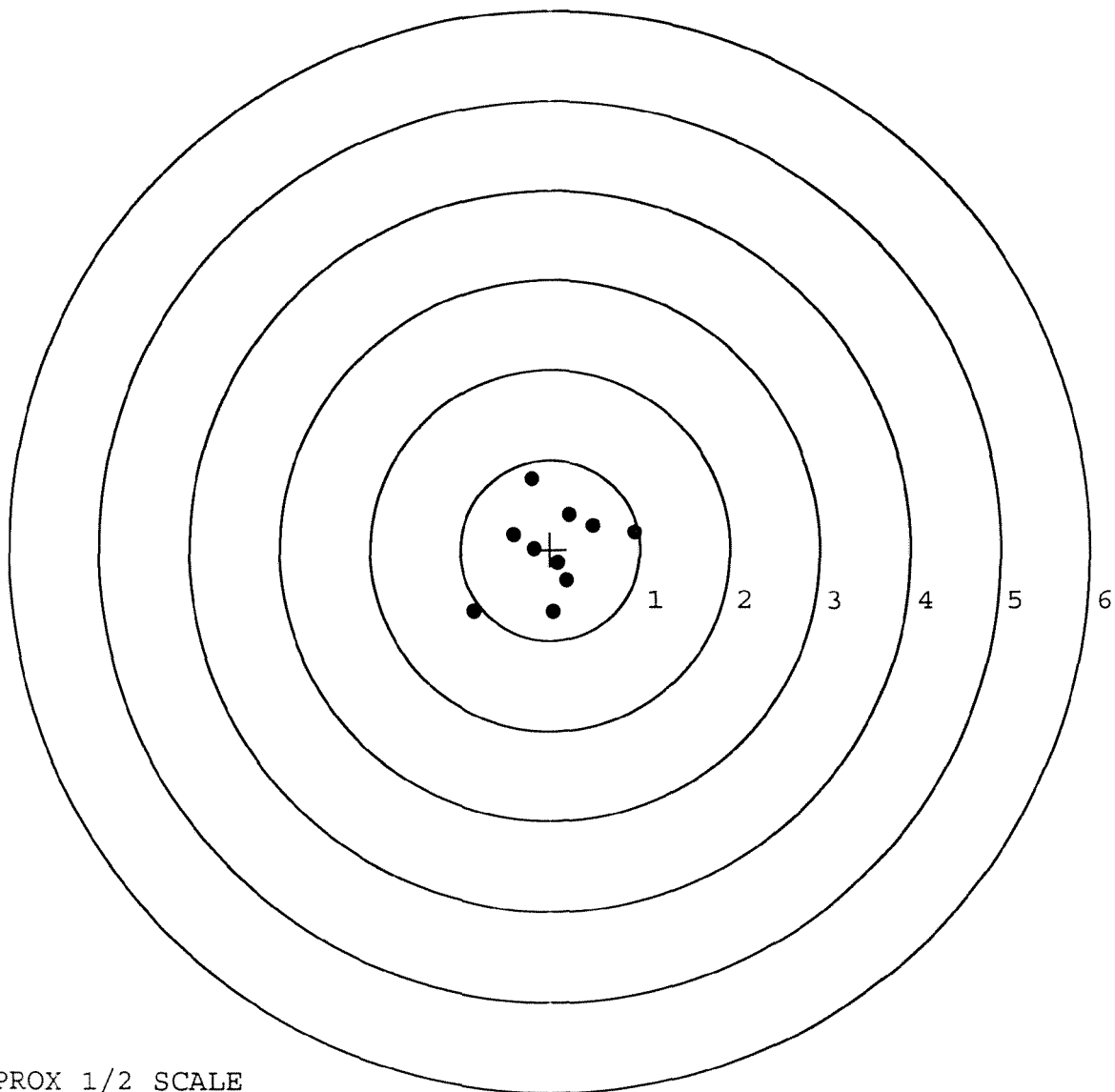
The Average X Centroid of the Five Target Set:	0.028
The Average Y Centroid of the Five Target Set:	0.007
The Average Point of Impact of the Five Target Set:	0.029
The Average Mean Radius of the Five Target Set:	0.560
The Distance from POA to Centroid Target #1:	0.029
The Distance from Centroid Target #2 to Centroid Target #1:	0.003
The Distance from Centroid Target #3 to Centroid Target #1:	0.039
The Distance from Centroid Target #4 to Centroid Target #1:	0.063
The Distance from Centroid Target #5 to Centroid Target #1:	0.037

BARBER - M24 0009582

SERIAL NUMBER: C6225157. __0
TARGET NUMBER: 1
FILE DATE: 12/12/2007
FILE TIME: 13:00

POINT#	X	Y
1:	-0.850	-0.682
2:	0.036	-0.688
3:	0.938	0.191
4:	0.476	0.265
5:	0.218	0.393
6:	-0.205	0.789
7:	-0.413	0.164
8:	-0.181	0.012
9:	0.187	-0.344
10:	0.085	-0.148

X CENTROID: 0.029
Y CENTROID: -0.005
POA TO CENTROID: 0.029
HORZ SPREAD: 1.788
VERT SPREAD: 1.477
GROUP SPREAD: 1.990
MIN RADIUS: 0.154
MAX RADIUS: 1.110
MEAN RADIUS: 0.572
IN 1 IN DIAMETER: 5
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

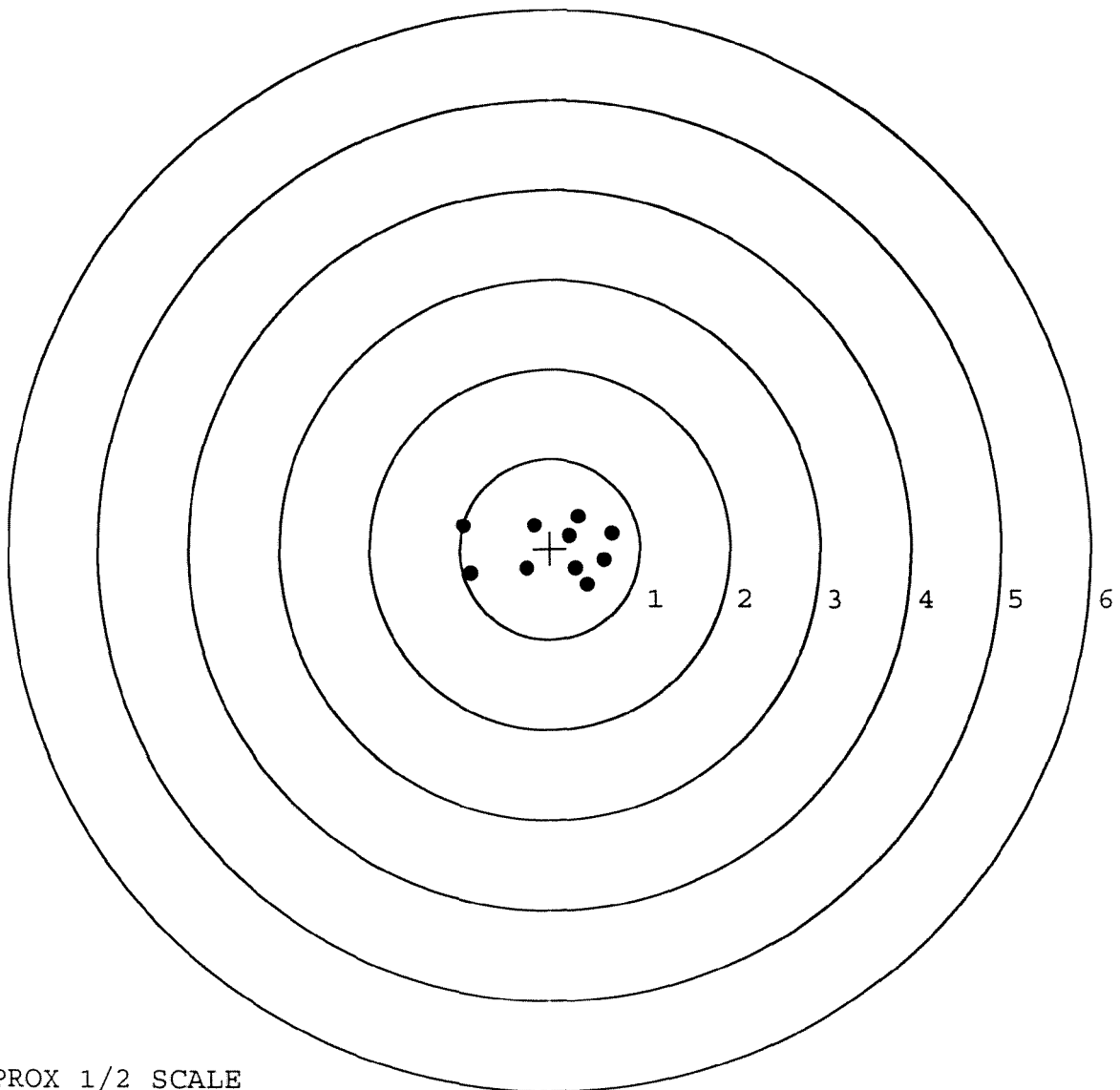
BARBER - M24 0009583

SERIAL NUMBER: C6225157. __0
TARGET NUMBER: 2
FILE DATE: 12/12/2007
FILE TIME: 13:00

X CENTROID: 0.027
Y CENTROID: -0.008
POA TO CENTROID: 0.028
HORZ SPREAD: 1.658
VERT SPREAD: 0.761
GROUP SPREAD: 1.660
MIN RADIUS: 0.241
MAX RADIUS: 1.026
MEAN RADIUS: 0.555

IN 1 IN DIAMETER: 5
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.966	0.248
2:	-0.874	-0.276
3:	-0.256	-0.225
4:	-0.178	0.256
5:	0.320	0.357
6:	0.692	0.173
7:	0.612	-0.130
8:	0.419	-0.404
9:	0.290	-0.220
10:	0.215	0.143



TARGET APPROX 1/2 SCALE

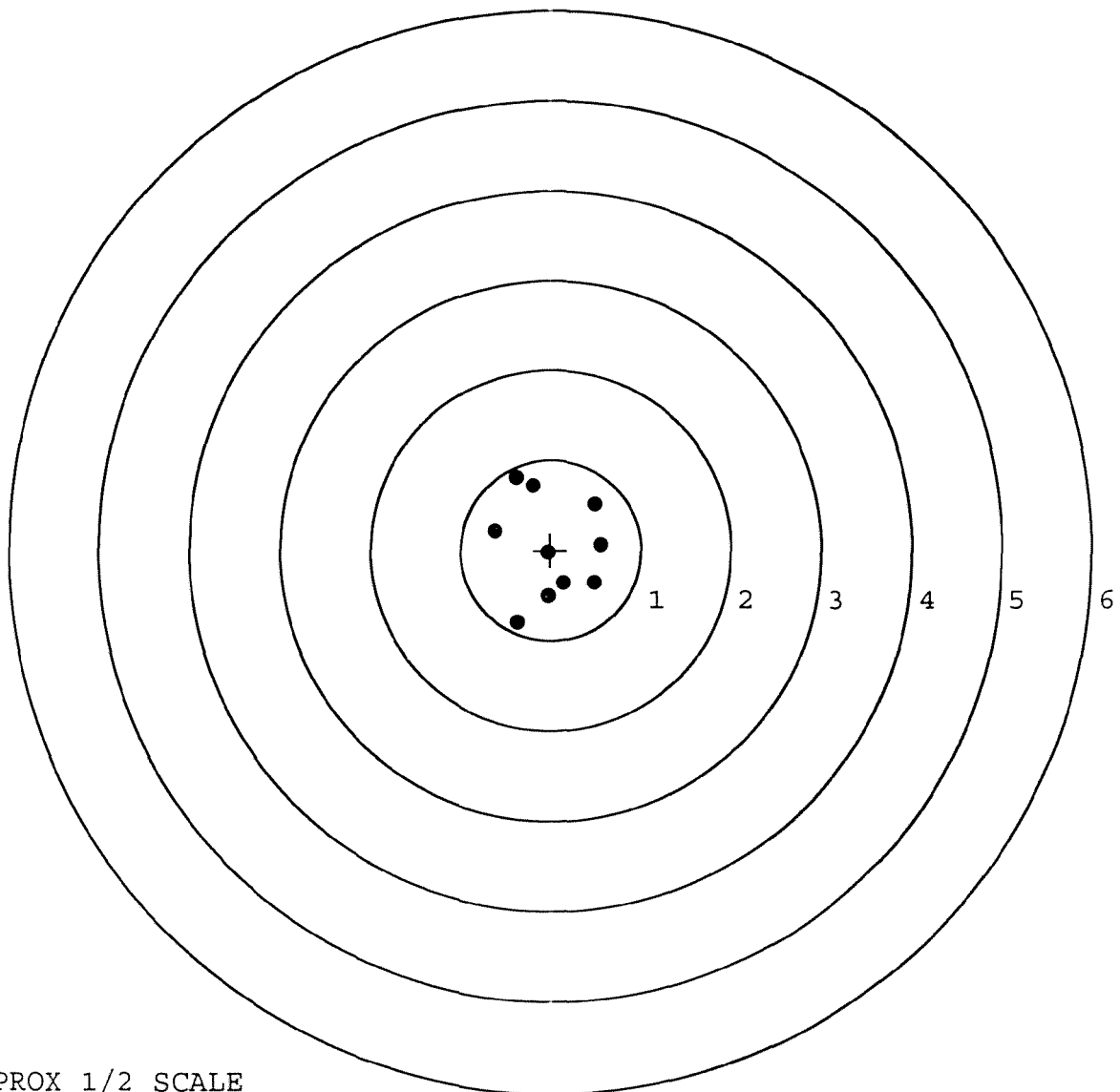
BARBER - M24 0009584

SERIAL NUMBER: C6225157. __0
TARGET NUMBER: 3
FILE DATE: 12/12/2007
FILE TIME: 13:00

X CENTROID: 0.003
Y CENTROID: 0.024
POA TO CENTROID: 0.024
HORZ SPREAD: 1.173
VERT SPREAD: 1.612
GROUP SPREAD: 1.612
MIN RADIUS: 0.063
MAX RADIUS: 0.910
MEAN RADIUS: 0.605

POINT#	X	Y
1:	-0.380	0.808
2:	-0.199	0.719
3:	-0.626	0.219
4:	-0.032	-0.029
5:	0.146	-0.369
6:	-0.032	-0.519
7:	-0.374	-0.804
8:	0.484	-0.364
9:	0.547	0.065
10:	0.493	0.513

IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 10
in 3 IN DIAMETER: 10



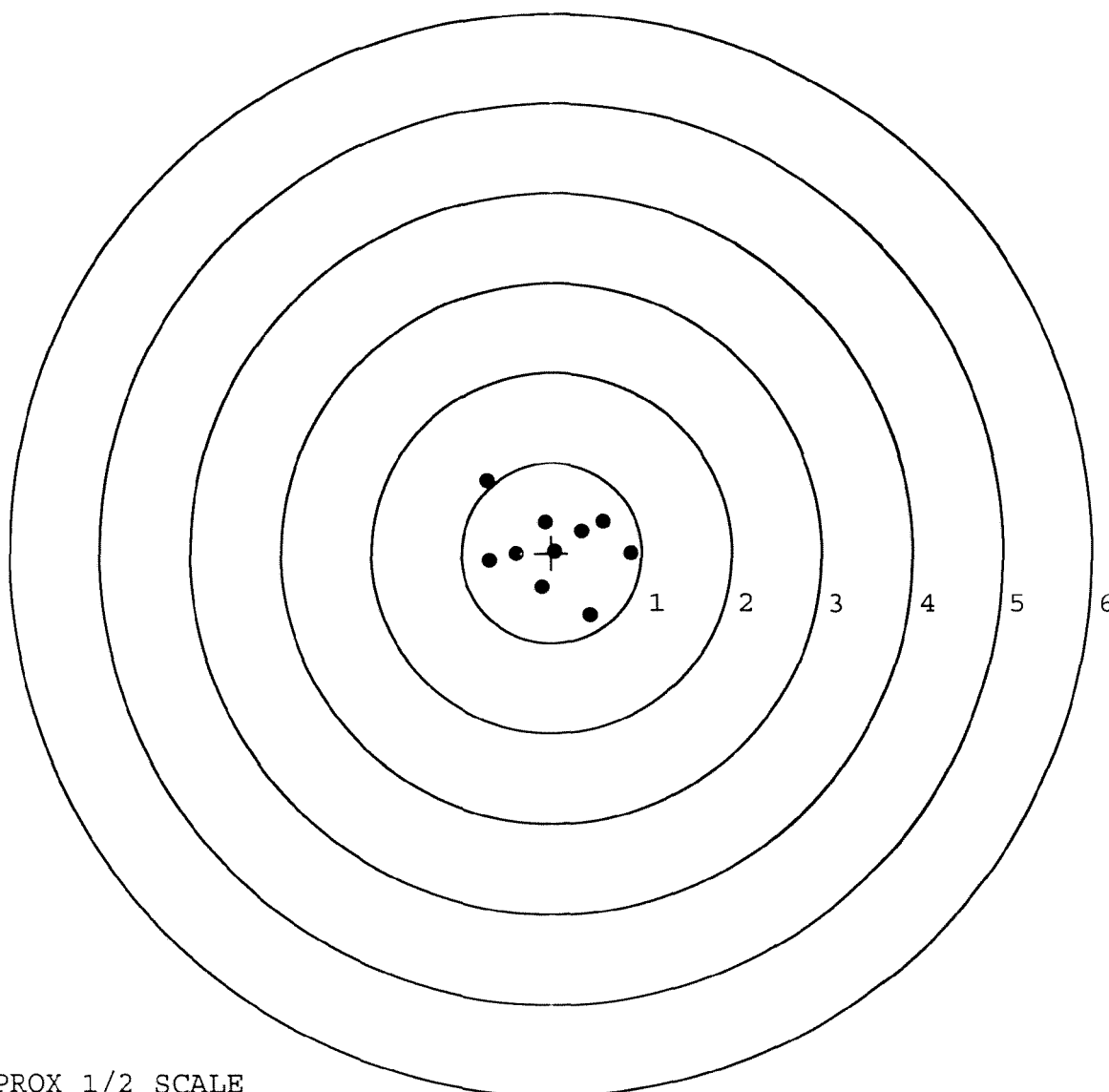
TARGET APPROX 1/2 SCALE

BARBER - M24 0009585

SERIAL NUMBER: C6225157. __0
TARGET NUMBER: 4
FILE DATE: 12/12/2007
FILE TIME: 13:00

POINT#	X	Y
1:	0.433	-0.692
2:	0.874	0.002
3:	0.573	0.353
4:	0.338	0.243
5:	0.037	0.018
6:	-0.071	0.334
7:	-0.714	0.800
8:	-0.398	-0.010
9:	-0.689	-0.085
10:	-0.105	-0.384

X CENTROID: 0.028
Y CENTROID: 0.058
POA TO CENTROID: 0.064
HORZ SPREAD: 1.588
VERT SPREAD: 1.492
GROUP SPREAD: 1.882
MIN RADIUS: 0.041
MAX RADIUS: 1.049
MEAN RADIUS: 0.569
IN 1 IN DIAMETER: 5
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10



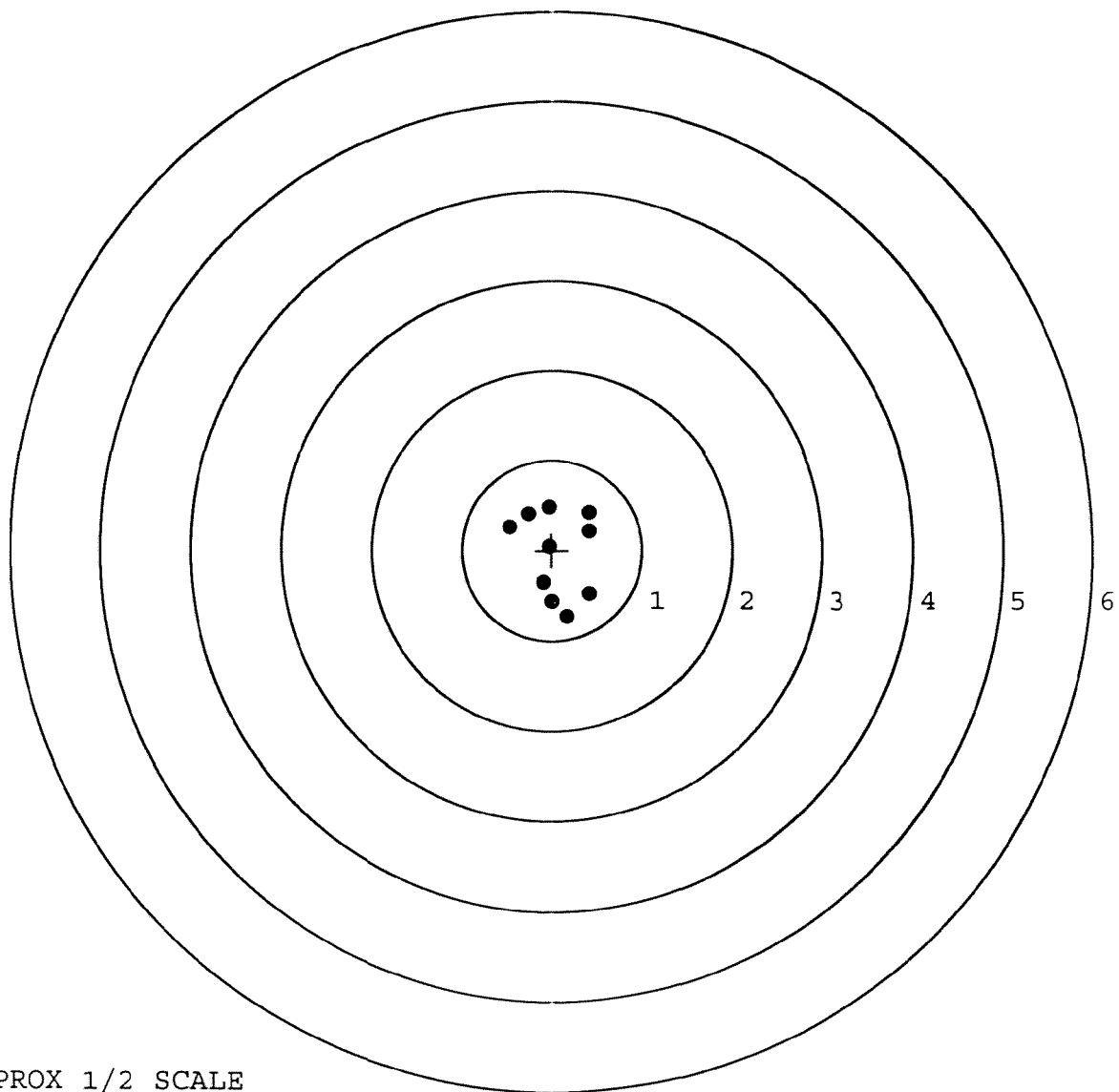
TARGET APPROX 1/2 SCALE

BARBER - M24 0009586

SERIAL NUMBER: C6225157. __0
TARGET NUMBER: 5
FILE DATE: 12/12/2007
FILE TIME: 13:00

POINT#	X	Y
1:	0.417	-0.485
2:	0.172	-0.735
3:	-0.004	-0.572
4:	-0.095	-0.359
5:	-0.031	0.045
6:	0.415	0.213
7:	0.418	0.419
8:	-0.033	0.480
9:	-0.266	0.404
10:	-0.468	0.257

X CENTROID: 0.052
Y CENTROID: -0.033
POA TO CENTROID: 0.062
HORZ SPREAD: 0.886
VERT SPREAD: 1.215
GROUP SPREAD: 1.232
MIN RADIUS: 0.114
MAX RADIUS: 0.712
MEAN RADIUS: 0.498
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 10
in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # *C6225757*

OPERATION		DATE	INT
#	NAME		
575-580	ASSEMBLY <i>2</i>	<i>26</i>	<i>FB</i>
600	PROOF <i>20</i>	<i>20</i>	<i>RW</i>
615	MAGNAFLUX BARREL	<i>5/13/88</i>	<i>pfe.</i>
	MAGNAFLUX BOLT	<i>5/13/88</i>	<i>pfe.</i>
620	COATING	<i>8/11/88</i>	<i>JA</i>
625-630	FINAL ASSEMBLY		
635	TEST		
640	TARGET		
	FIRING PIN INDENT		
660	PACK		

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6225157

OP.#	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and stock	QUALITY AUDIT		
600	Proof			
607	Check Headspace			
610	Dis-assemble gun			
612	Magnaflux Barrel Action			
	Magnaflux Bolt			
615	Rollmark Caliber			
617	Drill & Tap Sight Holes			
618	Polish Barrel			
620	Apply Coatings (Barrel Action)			
	Apply Coatings (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/23/88	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/23/88	RW
	C) Inspect Ejector Hole for Chamfer		8/23/88	RW

OVER

OP. #		READINGS	DATE	INITIAL
625 cont.	D) Oil Firing Pin Ass'y		8/23/88	RW
	E) Adjust Trigger Pull to Min. Setting and Stake		24 Aug 88	J.V. WB
	F) Safety on Force	5 $\frac{3}{4}$ # 6 $\frac{1}{4}$ # 6 #	24 Aug	J.V. WB.
	G) Safety off Force	2 $\frac{1}{2}$ # 2 $\frac{1}{2}$ # 2 $\frac{1}{2}$ #	24 Aug	J.V. WB.
	H) Trigger Pull Test & Retainabilty		24 Aug	WB.
	I) Firing Pin Indent	.022 .023 .022	24 Aug	J.V. WB.
	J) Assemble Stock		8/25/88	RW
	K) Assemble Swivel Studs		10-14-88	JV
	L) Attach Front & Rear Sight Assemblies		8/25/88	RW
	M) Iron Sight Alignment		9/2/88	RW
	N) Detach Front & Rear Sights & place in numbered container		9/2/88	RW
	O) Attach Scope to Rifle		9/12/88	RW.
	P) Detach & Attach Scope 20 times		9/12/88	W.B.
640	Gallery Target & Test	47 R 93L	9/16/88	D. H.
	A) Optical Clarity of Scope		9/16/88	W. B.
645	Inspect for Live Ammo		9/16/88	W. B.
655	Final Inspection			
	A) Headspace	OK	9/30/88	J.S.
	B) Trigger Pull	OK	9/30/88	J.S.
	C) Function	OK	9/30/88	J.S.
660	Pack			

MOD. _____		GA. CAL. _____	GUN # _____	5157
# TEST	DATE	MALFUNCTION/DEFECT	ASSEM. #	
	1st 9/16	WON'T EXTRACT 3 TIMES ON TEST.		
	2nd	EXTRACTOR LOOSE New EXTRACTOR		
	3rd 9/20/88	SHOT OK 100 RDS	94	
	4th			
		FUNCTION	RD 6654	Rev 1

TEST INIT. ACTION TO CORRECT		ASSEM. #
PROOF		
TEST		
TGT		
PROOF		
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6225157DATE 24 Aug 88TESTER W.B.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#	COMMENTS
PULL #1	2.62	2.05	2.14 2.23	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2# AFTER TEST COMPLETED, RE-ADJUST INTERNAL SETTING UP TOWARD MEAN TOLERANCE.
PULL #2	2.55	2.02	2.05 2.22	
PULL #3	2.58	2.06	2.08 2.25	
PULL #4	2.67	2.02	2.04 2.16	
PULL #5	2.61	2.03	2.08 2.28	
TOTAL	13.03	10.18	10.39 11.14	
AVG.	2.61	2.04	2.08 2.23	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.16	3.10		
PULL #2	3.18	3.11		
PULL #3	3.18	3.13		
PULL #4	3.18	3.12		
PULL #5	3.18	3.18		
TOTAL	15.88	15.64		
AVG.	3.18	3.13		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.35	4.16		4.31
PULL #2	4.42	4.22		4.34
PULL #3	4.45	4.24		4.35
PULL #4	4.39	4.26		4.38
PULL #5	4.36	4.27		4.37
TOTAL	21.97	21.15		21.75
AVG.	4.40	4.23		4.35

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6225157

CENTROIDAL DISTANCES

0 TO	1	.760019
1 TO	2	1.25993
1 TO	3	.168003
1 TO	4	1.07348
1 TO	5	1.53764

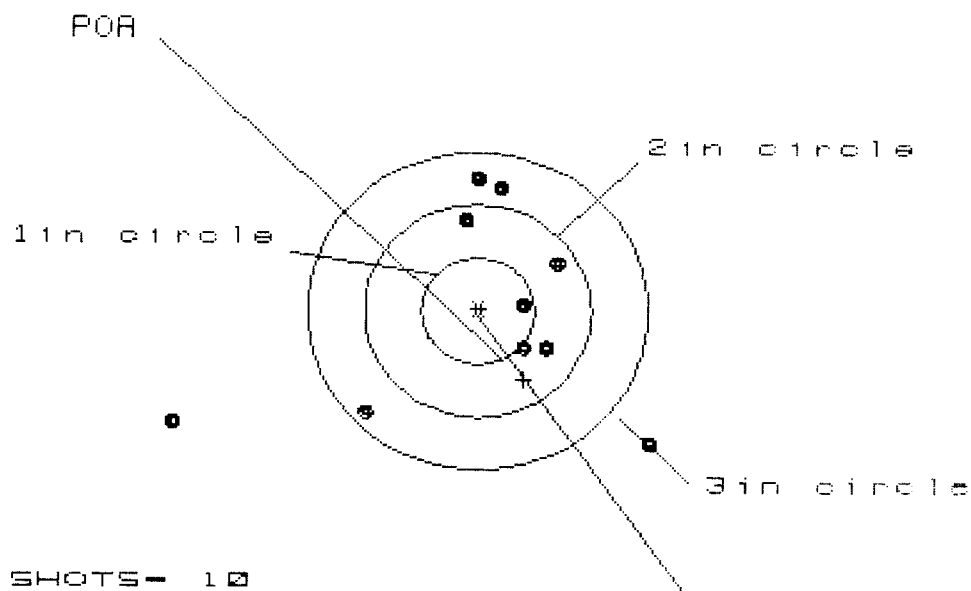
2⁴
3
5 + <----POB

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -1.0564
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .6908
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: 1.26221
THE AMR FOR THIS RIFLE IS: 1.193

19 Sep 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C6225157

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in - 1

2in - 5

3in - 8

HS- 4.285

VS= 2.493

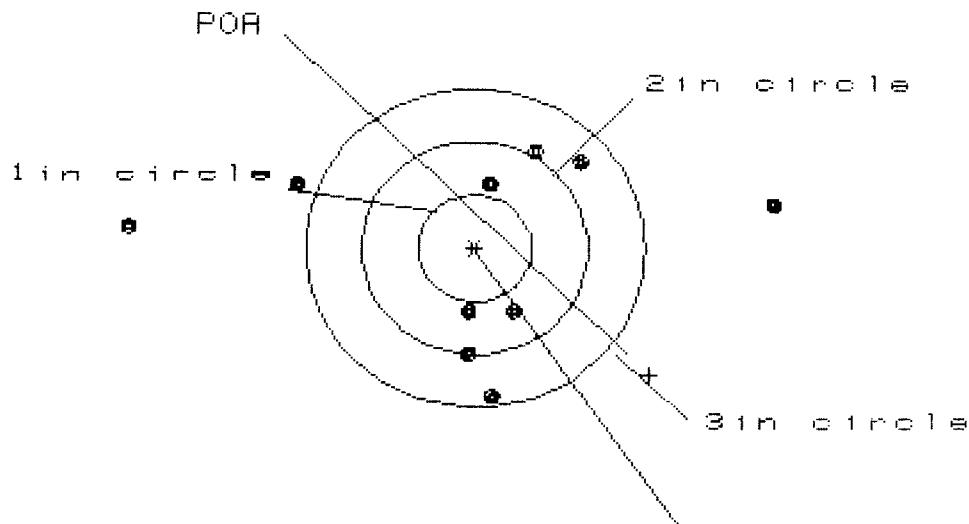
GS= 4.287

PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.545	1.241	.541
MINIMUM X	:	-2.740	-1.345	-1.190
MAXIMUM Y	:	1.292	1.174	1.009
MINIMUM Y	:	-1.201	-1.319	-1.207
CENTROID X	:	-.402	-.098	-.253
CENTROID Y	:	.645	.763	.928
POA TO CENTROID in.	:	.760	.770	.962
MIN RADIUS	:	.446	.138	.351
MEAN RADIUS	:	1.208	.915	.818
MAX RADIUS	:	2.941	1.811	1.695
HORIZONTAL SPREAD	:	4.285	2.586	1.731
VERTICAL SPREAD	:	2.493	2.493	2.216
EXTREME SPREAD	:	4.287	2.956	2.457
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	5		
NUMBER IN THREE INCH CIRCLE	=	8		

19 Sep 1988

FILE:/PATTERNING/CENTERFIRE_PATT/06225157

CENTERFIRE PATTERNS # 2



OF SHOTS - 10

IN CIR

1 in - 0

2 in - 4

3 in - 7

HS - 5.704

VS - 2.291

GS - 5.705

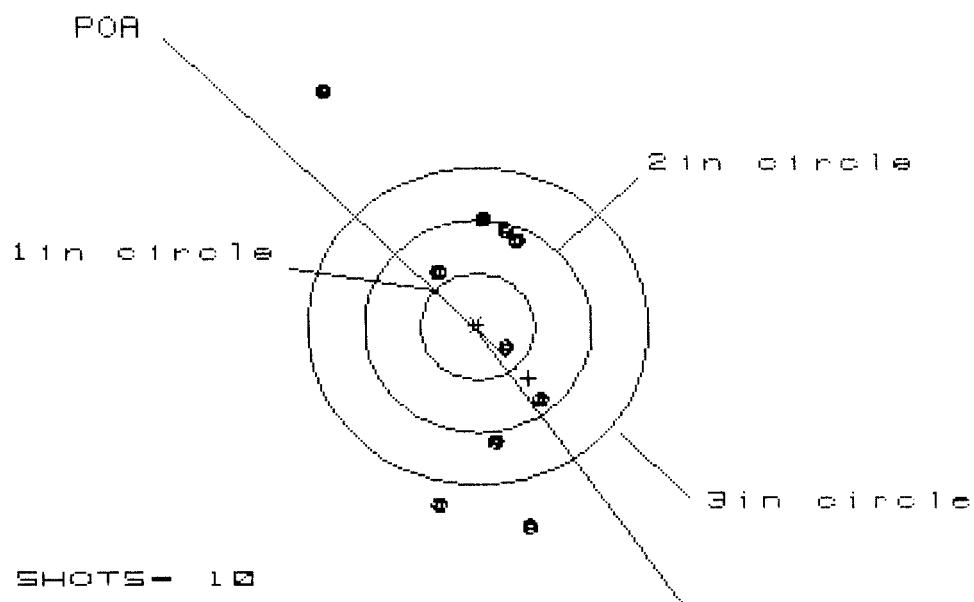
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.671	2.334	.942
MINIMUM X	:	-3.033	-1.872	-1.580
MAXIMUM Y	:	.872	.899	.949
MINIMUM Y	:	-1.419	-1.392	-1.342
CENTROID X	:	-1.537	-1.200	-1.492
CENTROID Y	:	1.192	1.165	1.115
POA TO CENTROID in.	:	1.945	1.672	1.863
MIN RADIUS	:	.577	.529	.509
MEAN RADIUS	:	1.387	1.178	1.004
MAX RADIUS	:	3.043	2.368	1.738
HORIZONTAL SPREAD	:	5.704	4.206	2.522
VERTICAL SPREAD	:	2.291	2.291	2.291
EXTREME SPREAD	:	5.705	4.215	2.654
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		7	

19 Sep 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C6225157

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in - 1

2in - 5

3in - 7

HS- 1.885

VS= 4.139

GS= 4.589

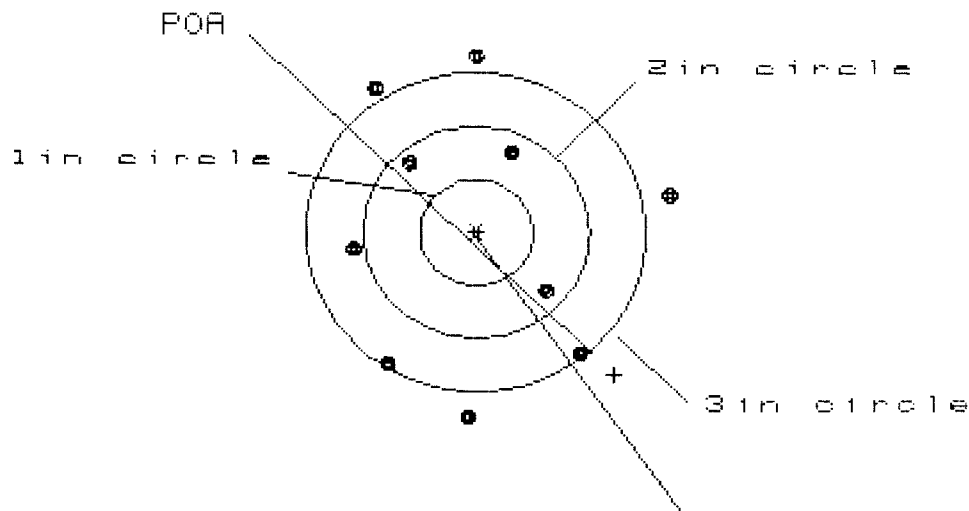
CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.539	.390	.426
MINIMUM X	:	-1.346	-.474	-.438
MAXIMUM Y	:	2.260	1.251	1.047
MINIMUM Y	:	-1.879	-1.628	-1.633
CENTROID X	:	-.450	-.301	-.337
CENTROID Y	:	.484	.233	.437
POA TO CENTROID in.	:	.661	.380	.552
MIN RADIUS	:	.256	.114	.140
MEAN RADIUS	:	1.194	1.012	.908
MAX RADIUS	:	2.630	1.655	1.687
HORIZONTAL SPREAD	:	1.885	.864	.864
VERTICAL SPREAD	:	4.139	2.879	2.680
EXTREME SPREAD	:	4.589	2.907	2.703
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		7	

19 Sep 1988

FILE:/PATTERNING/CENTERFIRE_PATT/06225157

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

CENTROID +

IN CIR

1 in = 0

2 in = 3

3 in = 6

HS= 2.723

VS= 3.425

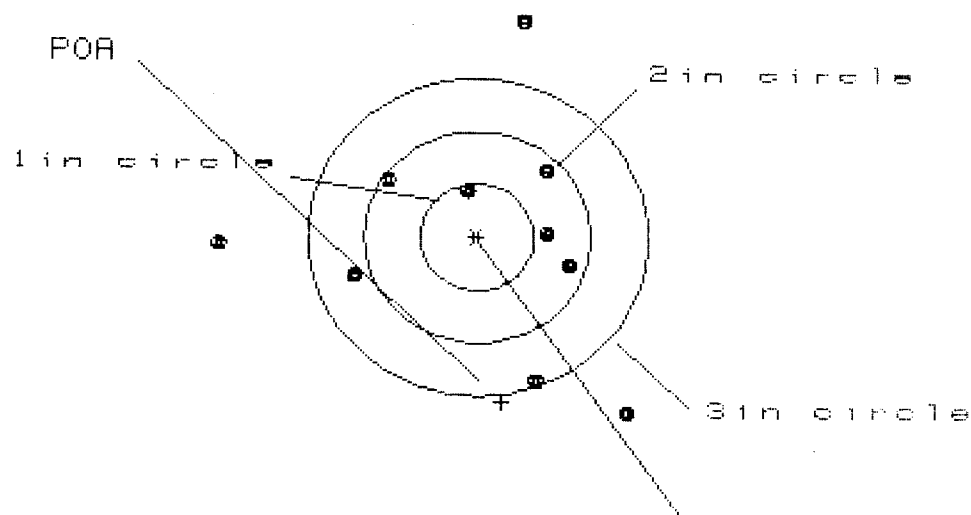
GS= 3.426

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.676	1.664	1.075
MINIMUM X	:	-1.047	-1.059	-.851
MAXIMUM Y	:	1.659	1.463	1.488
MINIMUM Y	:	-1.766	-1.399	-1.374
CENTROID X	:	-1.215	-1.203	-1.411
CENTROID Y	:	1.346	1.542	1.517
POA TO CENTROID in.	:	1.813	1.956	2.071
MIN RADIUS	:	.763	.579	.652
MEAN RADIUS	:	1.322	1.252	1.180
MAX RADIUS	:	1.769	1.676	1.722
HORIZONTAL SPREAD	:	2.723	2.723	1.926
VERTICAL SPREAD	:	3.425	2.862	2.862
EXTREME SPREAD	:	3.426	3.097	3.097
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		6	

19 Sep 1988

FILE:/PATTERNING/CENTERFIRE_PATT/06225157

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in - 1

2 in - 5

3 in - 7

HS- 3.669

VS- 3.725

GS- 4.023

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.361	1.104	.672
MINIMUM X	-2.308	-1.386	-1.248
MAXIMUM Y	2.047	2.044	1.834
MINIMUM Y	-1.678	-1.681	-1.610
CENTROID X	-.213	.044	-.095
CENTROID Y	1.558	1.561	1.771
POA TO CENTROID in.	1.572	1.562	1.774
MIN RADIUS	.473	.343	.343
MEAN RADIUS	1.301	1.154	1.027
MAX RADIUS	2.308	2.049	1.856
HORIZONTAL SPREAD	3.669	2.490	1.920
VERTICAL SPREAD	3.725	3.725	3.444
EXTREME SPREAD	4.023	3.845	3.447
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	7		