

C6594493

MODEL 700™ M24

Model SWS™

Action

Barrel Length

Capacity

Order No. 5716

*Includes 1 in chamber.



Repair Number: RE00080429	Serial: C6594493 Model M24 SWS Center Fire Caliber: 7.62 NATO	Repairman:	Status: Closed 4/29/2004 10:41:24 AM
Verify Repair: High Priority			

Address Information

Customer:	Received From:	Return To:	Received From:
Name: TMO 436 APS TRTD FB 4497		TMO 436 APS TRTD FB 4497	
Address 1: 505 ATLANTIC ST		505 ATLANTIC ST	
Address 2: PO Box:		PO Box:	
City: DOVER AFB		DOVER AFB	
State: DE Zip Code: 19902 Country: US		State: DE Zip Code: 19902 Country: US	

FFL: ☐ ☐ ☐ ☐ ☐ ☐ ☐

Contact / Condition	Problems	Estimate	History / Status	Shipping / Billing
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Contact Information Phone: Fax: Email: Comments:	Received Condition Fair Condition Notes: CSR Notes:	Accessories Received <table border="1"> <thead> <tr> <th>Code</th> <th>Desc</th> <th>Qty</th> </tr> </thead> <tbody> <tr> <td>A010</td> <td>Hard Case</td> <td>1</td> </tr> <tr> <td>A026</td> <td>Scope w/case</td> <td>1</td> </tr> <tr> <td>A055</td> <td>Deployment Kit</td> <td>1</td> </tr> </tbody> </table>	Code	Desc	Qty	A010	Hard Case	1	A026	Scope w/case	1	A055	Deployment Kit	1
Code	Desc	Qty												
A010	Hard Case	1												
A026	Scope w/case	1												
A055	Deployment Kit	1												

nagletj 4/29/2004 11:23 AM CAPS NUM INS SCPL

start 2 5 2

Serial Number: **C6594493**

Model: **M24 SWS**



RE00080429

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6594493.___0

FILE DATE AND TIME: 05/24/2004 06:27

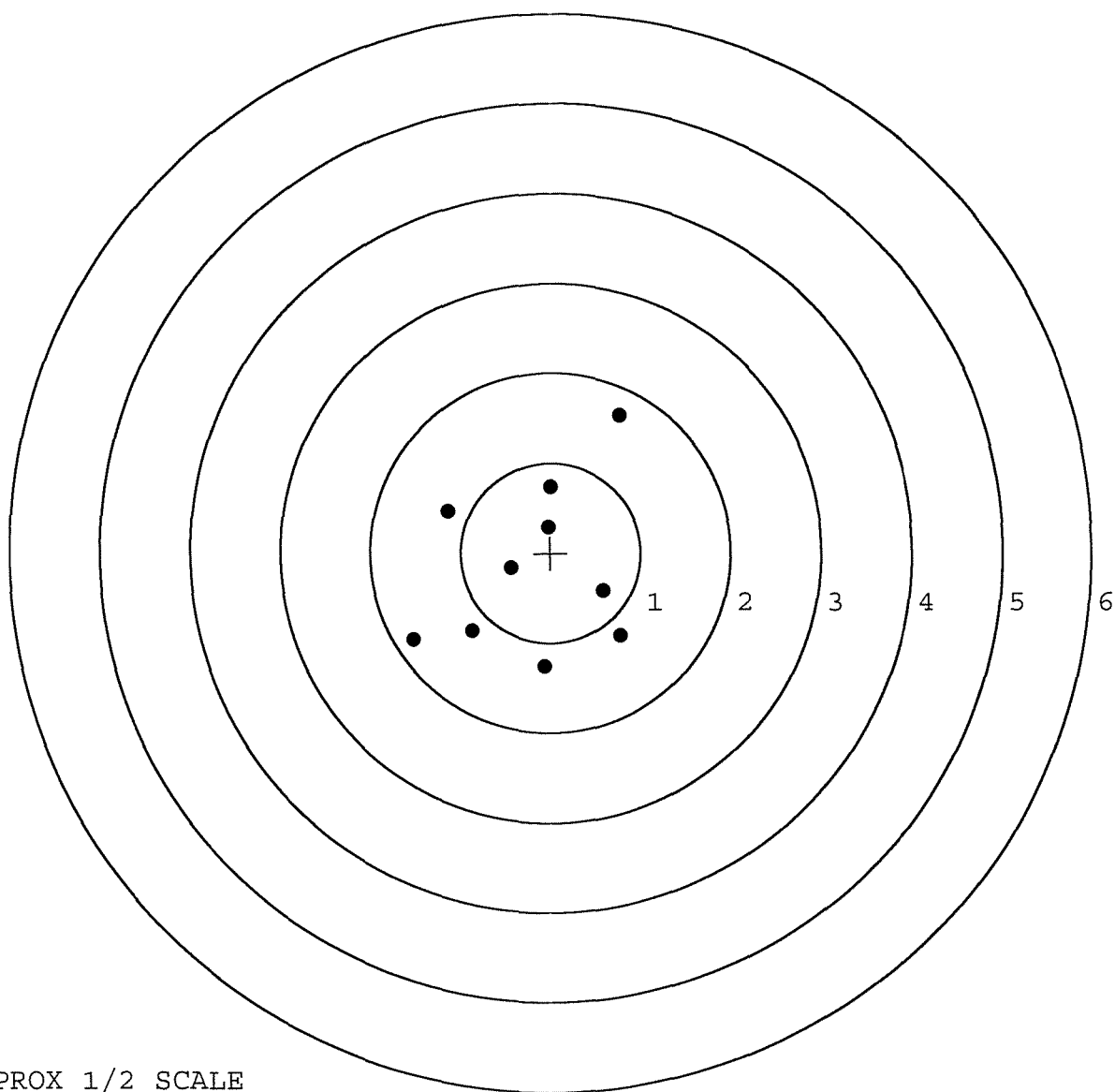
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.016
The Average Y Centroid of the Five Target Set:	-0.114
The Average Point of Impact of the Five Target Set:	0.115
The Average Mean Radius of the Five Target Set:	0.945
The Distance from POA to Centroid Target #1:	0.253
The Distance from Centroid Target #2 to Centroid Target #1:	0.335
The Distance from Centroid Target #3 to Centroid Target #1:	0.229
The Distance from Centroid Target #4 to Centroid Target #1:	0.328
The Distance from Centroid Target #5 to Centroid Target #1:	0.535

SERIAL NUMBER: C6594493. __0
 TARGET NUMBER: 1
 FILE DATE: 05/24/2004
 FILE TIME: 06:27

X CENTROID: -0.195
 Y CENTROID: -0.161
 POA TO CENTROID: 0.253
 HORZ SPREAD: 2.298
 VERT SPREAD: 2.797
 GROUP SPREAD: 3.383
 MIN RADIUS: 0.245
 MAX RADIUS: 1.939
 MEAN RADIUS: 1.043
 # IN 1 IN DIAMETER: 2
 # IN 2 IN DIAMETER: 5
 # in 3 IN DIAMETER: 8

POINT#	X	Y
1:	-0.070	-1.272
2:	-0.869	-0.868
3:	-1.520	-0.973
4:	-0.440	-0.168
5:	-1.144	0.468
6:	0.778	-0.922
7:	0.585	-0.423
8:	-0.025	0.288
9:	-0.006	0.735
10:	0.762	1.525



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6594493. __0

TARGET NUMBER: 2

FILE DATE: 05/24/2004

FILE TIME: 06:27

X CENTROID: -0.084

Y CENTROID: 0.156

POA TO CENTROID: 0.177

HORZ SPREAD: 2.017

VERT SPREAD: 3.017

GROUP SPREAD: 3.034

MIN RADIUS: 0.320

MAX RADIUS: 1.650

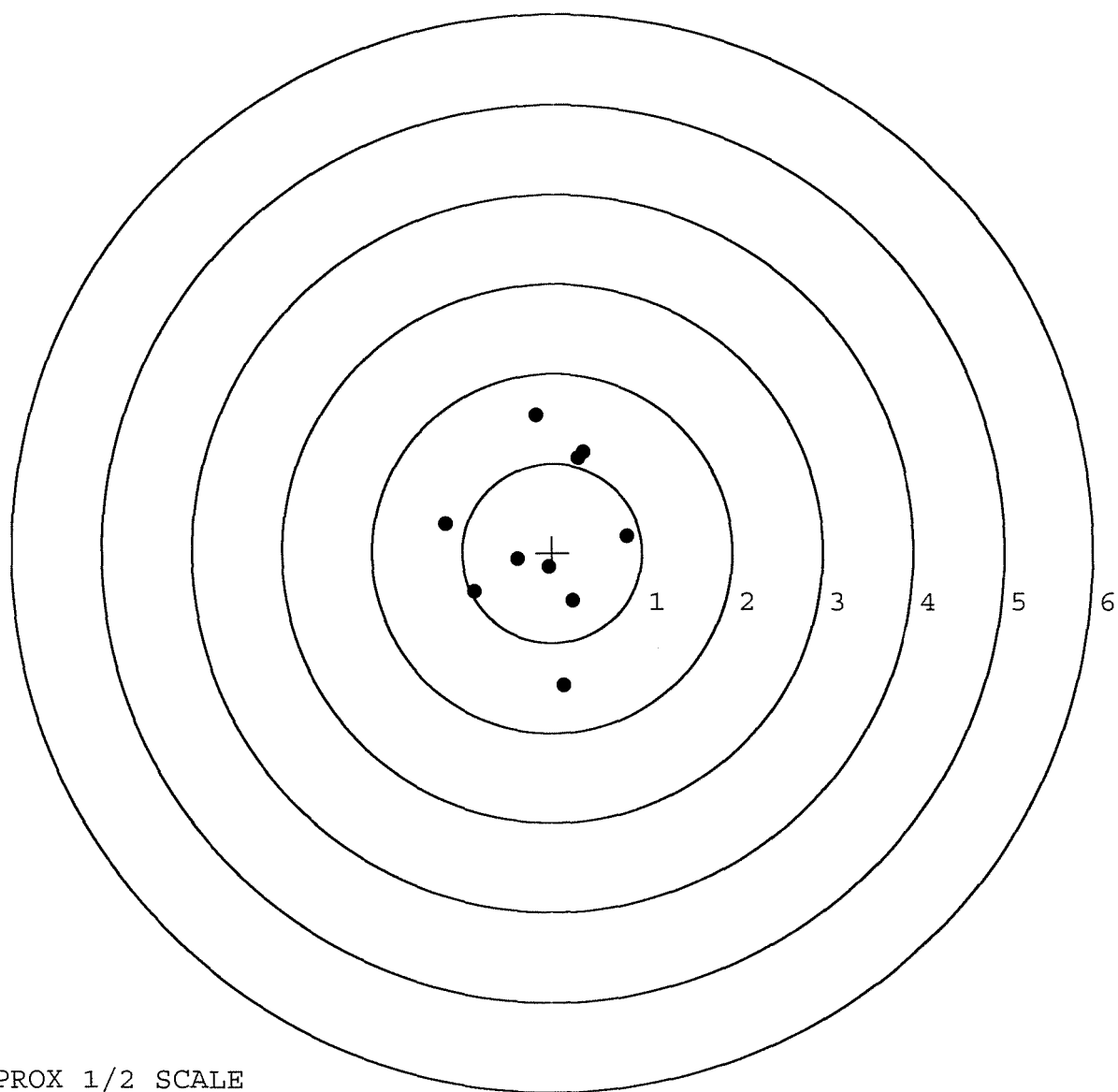
MEAN RADIUS: 0.955

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 9

POINT#	X	Y
1:	0.832	0.187
2:	0.286	1.065
3:	0.345	1.131
4:	-0.189	1.537
5:	-1.185	0.324
6:	-0.392	-0.073
7:	-0.044	-0.162
8:	0.230	-0.534
9:	-0.860	-0.440
10:	0.134	-1.480



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6594493. __0

TARGET NUMBER: 3

FILE DATE: 05/24/2004

FILE TIME: 06:27

X CENTROID: -0.120

Y CENTROID: -0.377

POA TO CENTROID: 0.395

HORZ SPREAD: 2.077

VERT SPREAD: 2.084

GROUP SPREAD: 2.078

MIN RADIUS: 0.327

MAX RADIUS: 1.198

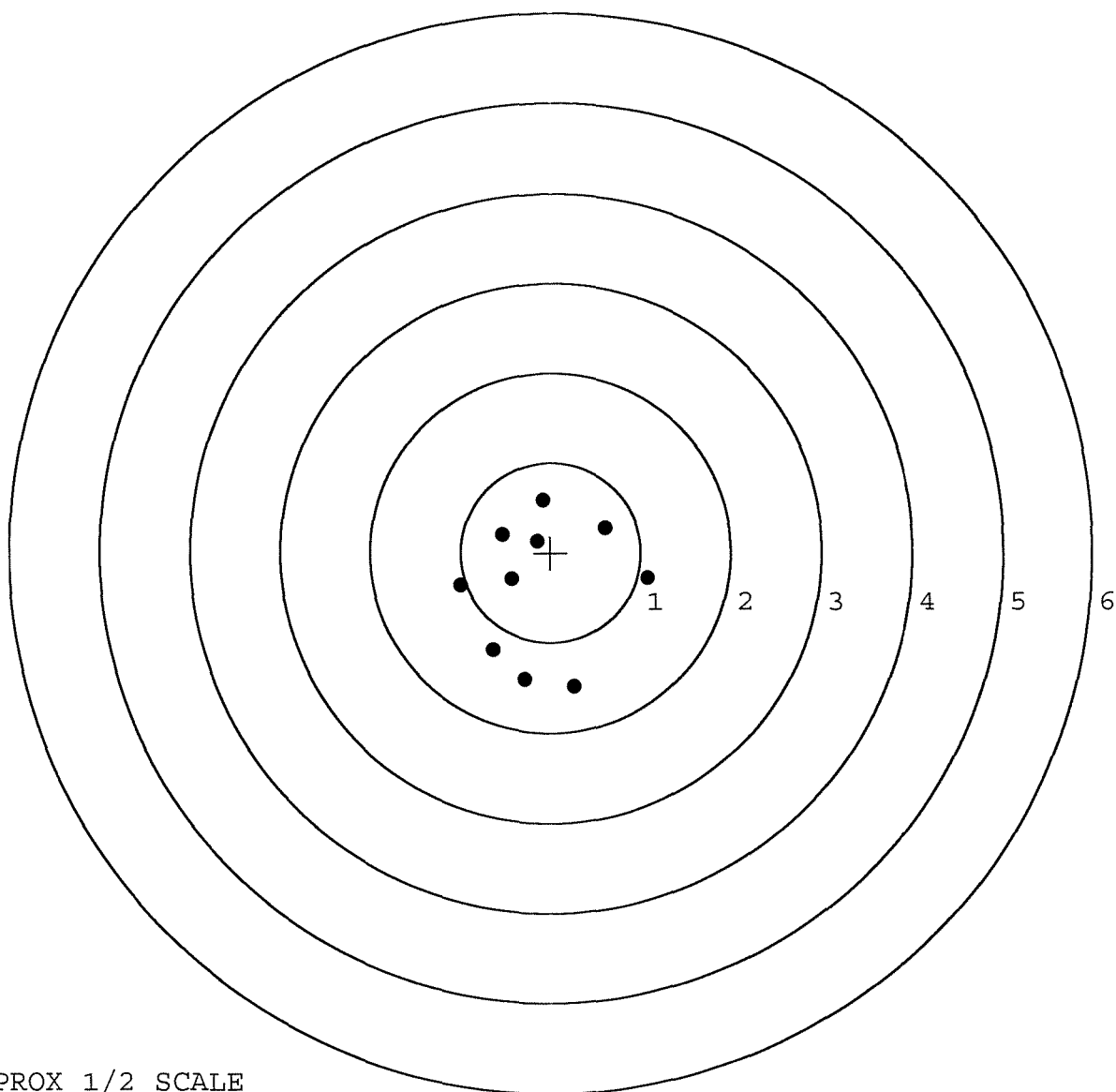
MEAN RADIUS: 0.869

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	1.076	-0.293
2:	0.612	0.277
3:	0.263	-1.498
4:	-0.291	-1.417
5:	-0.642	-1.088
6:	-1.001	-0.363
7:	-0.437	-0.300
8:	-0.534	0.201
9:	-0.151	0.127
10:	-0.090	0.586



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6594493. __0

TARGET NUMBER: 4

FILE DATE: 05/24/2004

FILE TIME: 06:27

X CENTROID: 0.079

Y CENTROID: -0.342

POA TO CENTROID: 0.351

HORZ SPREAD: 2.209

VERT SPREAD: 2.199

GROUP SPREAD: 2.276

MIN RADIUS: 0.335

MAX RADIUS: 1.318

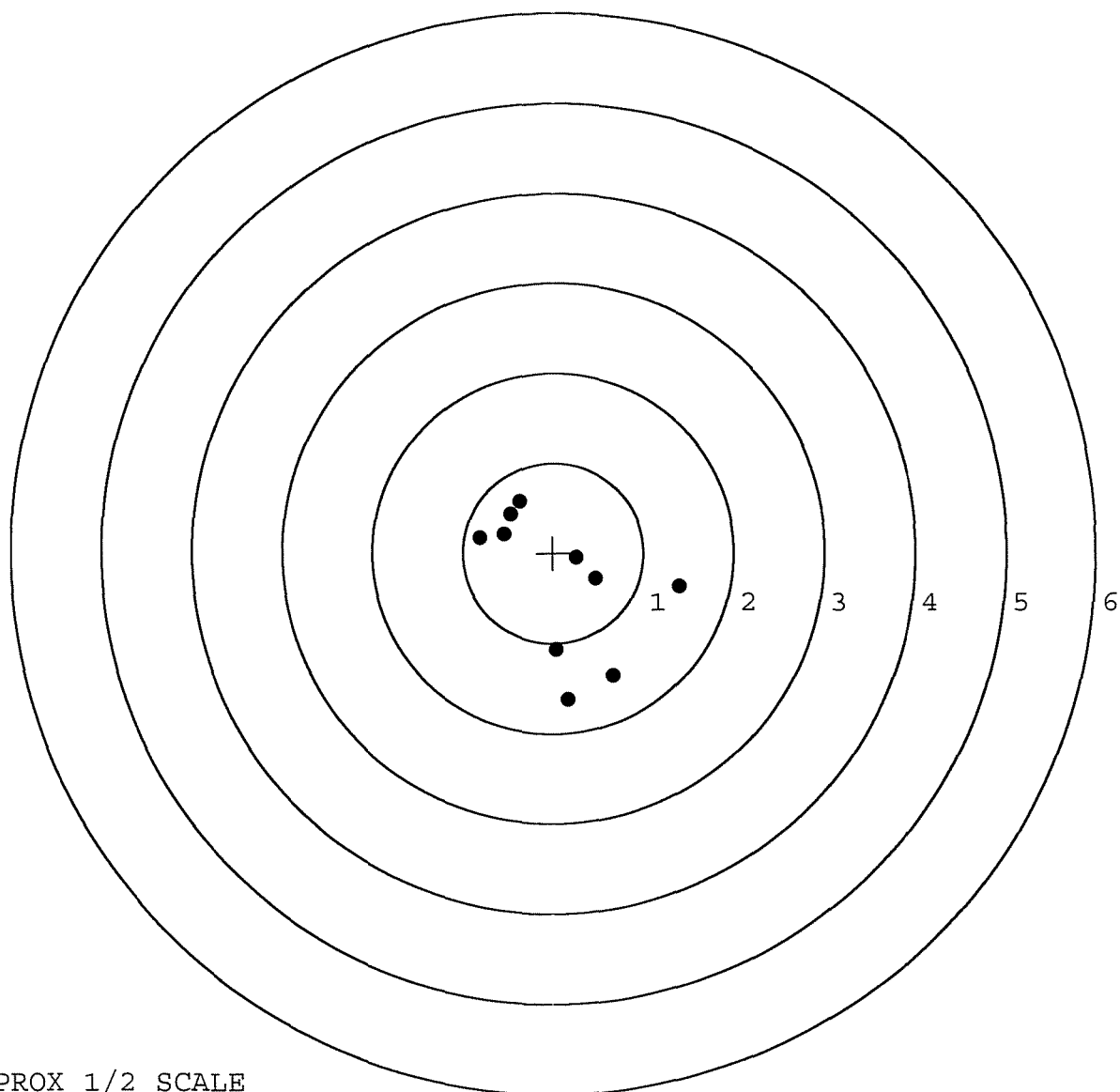
MEAN RADIUS: 0.908

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 5

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	1.397	-0.376
2:	0.672	-1.365
3:	0.172	-1.630
4:	0.037	-1.076
5:	0.468	-0.288
6:	0.257	-0.057
7:	-0.376	0.569
8:	-0.479	0.427
9:	-0.543	0.210
10:	-0.812	0.171



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6594493. __0

TARGET NUMBER: 5

FILE DATE: 05/24/2004

FILE TIME: 06:27

X CENTROID: 0.238

Y CENTROID: 0.154

POA TO CENTROID: 0.283

HORZ SPREAD: 2.011

VERT SPREAD: 3.203

GROUP SPREAD: 3.665

MIN RADIUS: 0.326

MAX RADIUS: 2.033

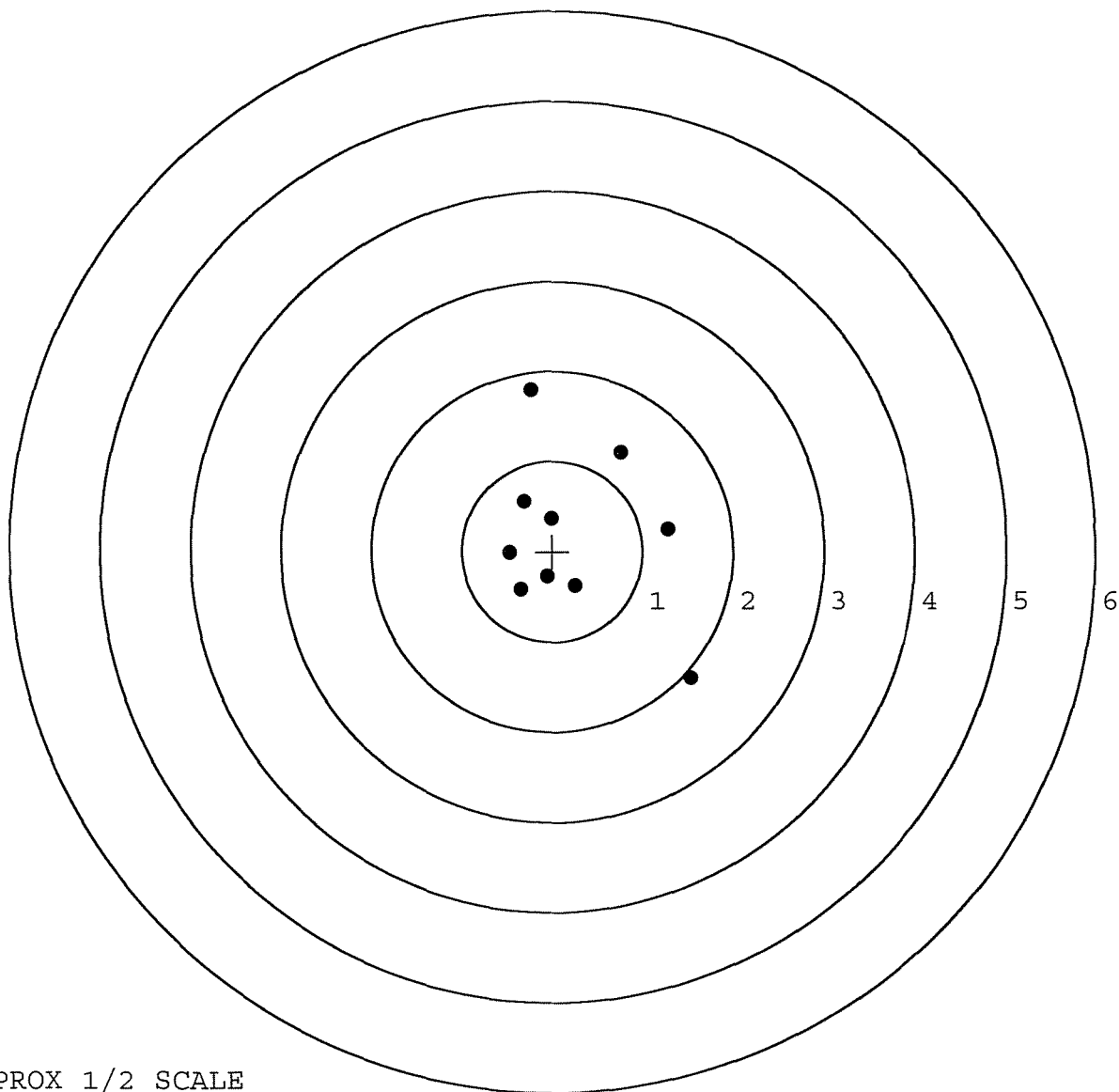
MEAN RADIUS: 0.950

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 8

POINT#	X	Y
1:	1.536	-1.410
2:	1.284	0.239
3:	0.756	1.099
4:	-0.245	1.793
5:	-0.315	0.553
6:	-0.010	0.366
7:	0.260	-0.386
8:	-0.066	-0.279
9:	-0.349	-0.423
10:	-0.475	-0.014



TARGET APPROX 1/2 SCALE

SERIAL # C6594493 INSPECTED BY: RTL

DATE REC'D: 4-29-04 DATE RET'D: 6-7-04

ITEM

BARREL ASSEMBLY

☒ BARREL

☒ RECEIVER

☒ FRONT SIGHT BASE

☒ REAR SIGHT BASE

☒ SCREWS

☒ FINISH

SCOPE ASSEMBLY

☒ SCOPE

☒ SCOPE RINGS

☒ MOUNTING SCREWS

☒ MOUNTING BASE

☒ SCREWS

☒ FINISH

☒ CLARITY

ITEM

STOCK ASSEMBLY

☒ STOCK

☒ SLING AWIVEL STUDS

☒ ADJUSTABLE

☒ BUTT PLATE

☒ LOCK NUTS

☒ BARREL CLEARANCE

☒ COLOR / FINISH

SYSTEMS CASE

☒ SCOPE CASE

☒ IRON SIGHTS

☒ DEPLOYMENT KIT

TRIGGER ASSEMBLY

☒ SAFETY OPERATION

☒ RE-SET TO FACTORY SPECS

COMMENTS:

80429

BARBER - M24 0018085			
R & E NUMBER	80429		
SERIAL NUMBER	C659449 3	C659449.3	
LOG-IN DATE	4-29-04		
INSPECT AND VERIFY:			
OPERATION #	OPERATION NAME	DATE	INITIAL
550	DIS-ASSEMBLE GUN	5-3-04	RTL
560 A	RE-BARREL	5-4-04	RTL
B	DRILL AND TAP	5-5-04	TRW
575	ASSEMBLE	5-4-04	RTL
600	PROOF	5-4-04	RTL
605	CHECK HEADSPACE	5-4-04	RTL
610	DIS-ASSEMBLE GUN	5-4-04	RTL
612	MAGNAFLUX	<i>RL</i>	
615	ROLLMARK CALIBER	5/6/04	NB
618	ROTO-BLAST	3/7/04	JJ
620	APPLY COATINGS	5-10	TA
625 A	FINAL ASSEMBLY	5-11-04	RTL
B	TRIGGER PULL TEST		
C	SAFETY "ON" FORCE		
D	SAFETY "OFF" FORCE		
E	FIRING PIN INDENT		
640	TARGET	5-24-04	TRW
655	FINAL INSPECT	6-7-04	RTL
660	PACK	6-8-04	DA
		SHIP DATE	
QAR INSPECTION DATE			

0 11 47700 25716 111 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6594493

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		10/30/90	Kd
600	Proof		10/30/90	Kd
607	Check Headspace		10/30/90	Kd
610	Dis-assemble Gun		10/30/90	Kd
612	Magnaflux Barrel Action		11/1/90	Kcd
	Magnaflux Bolt		11/1/90	Kcd
615	Rollmark Caliber		11/1/90	GS
617	Drill and Tap Sight Holes		11/6/90	K-B
618	Polish Barrel AB		11/7/90	WSB
620	Apply Coatings (Barrel Action)		11-26-90	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		11-26-90	DH
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		11-26-90	DH
	C) Inspect Ejector Hole for Chamfer		11-26-90	DH
	D) Oil Firing Pin Ass'y		12-26-90	DH
	E) Adjust Trigger Pull to Min Setting and Stake		11/8/90	FH

op. #	OP. NAME	READINGS			DATE	INIT
625 cont.	F) Safety On Force	4	3.5	3.5	12/8/90	RW
	G) Safety Off Force	2.5	2.5	2	12/8/90	RW
	H) Trigger Pull Test & Retainability				12/8/90	SL
	I) Firing Pin Indent	.0205	.020	.0205	12/8/90	RW
	J) Assemble Stock				12/8/90	KS
	K) Assemble Swivel Studs				12-12-90	JS
	L) Attach Front and Rear Sight Assemblies				12/8/90	KS
	M) Iron Sight Alignment				14/8/90	KS
	N) Detach Front & Rear Sights & place in numbered container				12/8/90	KS
	O) Attach Scope to Rifle				12/8/90	KS
	P) Detach & Attach Scope 20 Times				12/8/90	KS
640	Gallery Target & Test				12/11/90	NF
	A) Time				"	NF
	B) Malfunctions				"	NF
	C) Pierced Primers				"	NF
	D) Optical Clarity of Scope				"	NF
645	Inspect for Live Ammo				12/11/90	NF
655	Final Inspection					
	A) Headspace				12-12-90	JS
	B) Trigger Pull	2.65	2.61	2.59	12-12-90	JS
	C) Function				12-12-90	JS
660	Pack				12-17-90	DH

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. 06594493

DATE 12/8/90

TESTER JM

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.30	2.42	2.31	265	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.22	2.30	2.38	261	
PULL #3	2.38	2.40	2.40	259	
PULL #4	2.28	2.38	2.42	259	
PULL #5	2.43	2.42	2.39	256	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.44	3.40		
PULL #2	3.43	3.43		
PULL #3	3.40	3.39		
PULL #4	3.41	3.37		
PULL #5	3.38	3.20		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.39	4.42		4.42
PULL #2	4.39	4.39		4.40
PULL #3	4.46	4.39		4.37
PULL #4	4.30	4.40		4.36
PULL #5	4.48	4.43		4.46
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6594493
11 Dec 1990

CENTROIDAL DISTANCES

0 TO	1	.252
1 TO	2	.491171
1 TO	3	.231795
1 TO	4	.200564
1 TO	5	.329874

$\bar{x}_2$ <----POA

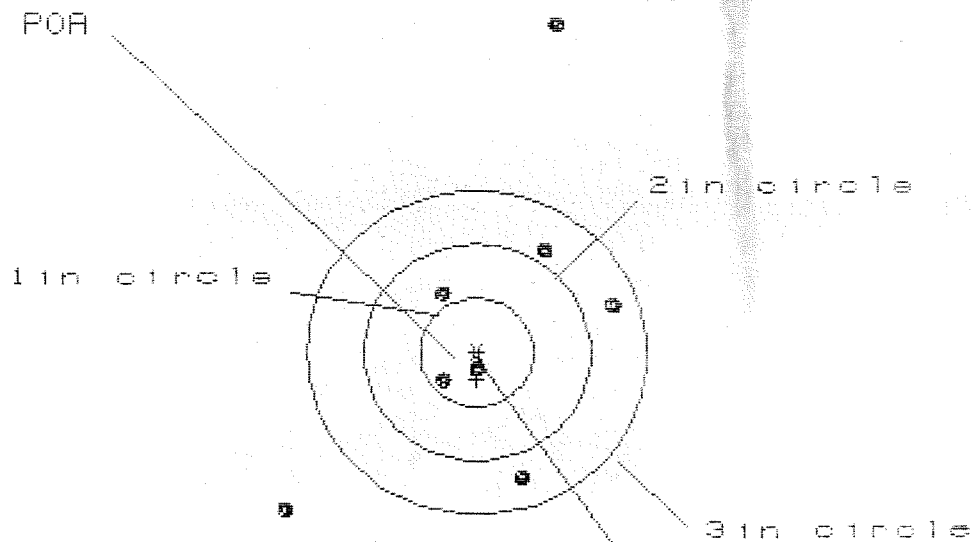
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0208
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0266
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0337668

THE AMR FOR THIS RIFLE IS: 1.036

11 Dec 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6594493

CENTERFIRE PATTERNS # 1



OF SHOTS - 10

IN CIR

1 in = 3

2 in = 4

3 in = 7

HS= 2.849

VS= 4.928

GS= 5.104

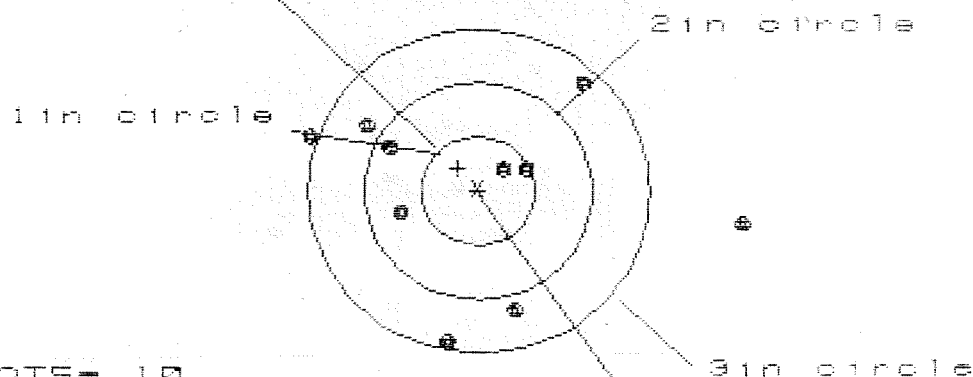
PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.152	1.231	1.028
MINIMUM X	-1.697	-1.618	-.745
MAXIMUM Y	3.034	1.325	1.192
MINIMUM Y	-1.894	-1.557	-1.690
CENTROID X	.000	-.079	.124
CENTROID Y	.252	-.085	.049
POA TO CENTROID in.	.252	.115	.133
MIN RADIUS	.125	.169	.103
MEAN RADIUS	1.213	.997	.842
MAX RADIUS	3.115	1.938	1.847
HORIZONTAL SPREAD	2.849	2.849	1.773
VERTICAL SPREAD	4.928	2.882	2.882
EXTREME SPREAD	5.104	3.380	3.119
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	7		

11 Dec 1998

FILE:/PATTERNING/CENTERFIRE_PATT/06594493

CENTERFIRE PATTERNS # 2

POA



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 4

3 in = 8

HS= 3.816

VS= 2.406

GS= 3.899

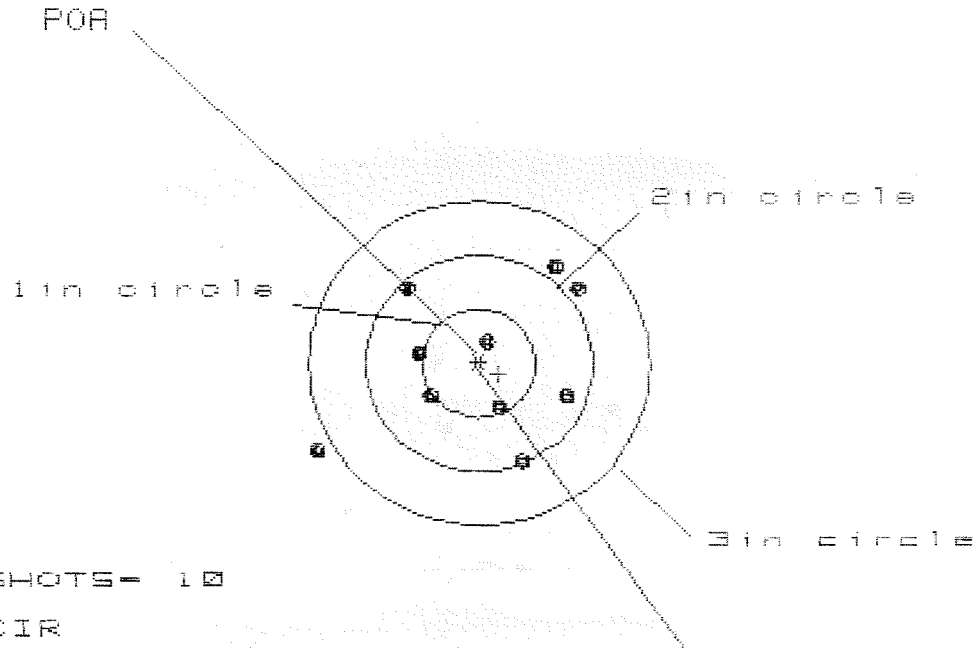
CENTROID *

PATTERN #	2	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	2.337	1.150	.998
MINIMUM X	-1.479	-1.219	-.867
MAXIMUM Y	.989	.957	1.018
MINIMUM Y	-1.417	-1.449	-1.389
CENTROID X	.180	-.080	.072
CENTROID Y	-.205	-.173	-.233
POA TO CENTROID in.	.272	.191	.244
MIN RADIUS	.304	.437	.403
MEAN RADIUS	1.137	.975	.931
MAX RADIUS	2.355	1.496	1.425
HORIZONTAL SPREAD	3.816	2.369	1.865
VERTICAL SPREAD	2.406	2.406	2.406
EXTREME SPREAD	3.899	2.684	2.684
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	8		

11 Dec 1998

FILE:/PATTERNING/CENTERFIRE_PATT/08594493

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1in = 3

2in = 7

3in = 9

CENTROID #

HS= 2.286

VS= 1.742

GS= 2.686

PATTERN #	3	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.882	.726	.737
MINIMUM X	-1.404	-.775	-.684
MAXIMUM Y	.864	.780	.851
MINIMUM Y	-.878	-.962	-.891
CENTROID X	-.175	-.019	-.110
CENTROID Y	.100	.184	.113
POA TO CENTROID in.	.202	.185	.158
MIN RADIUS	.233	.167	.211
MEAN RADIUS	.817	.725	.686
MAX RADIUS	1.596	.984	1.041
HORIZONTAL SPREAD	2.286	1.501	1.421
VERTICAL SPREAD	1.742	1.742	1.742
EXTREME SPREAD	2.686	1.846	1.846
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	7		
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. C6594493DATE 4-14-97TESTER EK

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#	COMMENTS
PULL #1	2.56	2.57	2.66	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.55	2.30	2.57	
PULL #3	2.56	2.52	2.54	
PULL #4	2.50	2.61	2.16	
PULL #5	2.56	2.54	2.58	
TOTAL	12.73	12.54	12.51	
AVG.	2.55	2.51	2.50	

	3.00# INITIAL	3.00# AFTER 20 CYCLES	COMMENTS
PULL #1	3.34	3.46	
PULL #2	3.37	3.37	
PULL #3	3.36	2.94	
PULL #4	3.40	2.61	
PULL #5	3.41	3.25	
TOTAL	16.88	15.63	
AVG.	3.38	3.13	

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.03	3.97		4.18
PULL #2	4.07	3.97		4.24
PULL #3	4.07	4.14		4.22
PULL #4	3.79	3.69		4.23
PULL #5	4.06	4.08		4.24
TOTAL	20.02	19.85		21.11
AVG.	4.00	3.97		4.22

21 DAY TURN - AROUND

M-24

CONTRACT # DAAA09-92-C-0834

R&E NO.

SERIAL NO.

C6594493

LOG IN DATE: / /

DATE

INIT.

INSPECT & VERIFY:

OP. #

OP. NAME

550

DIS-ASSEMBLE GUN

560 A

RE-BARREL AT CUSTOM SHOP

B

DRILL & TAP

C

POLISH

575

ASSEMBLE

600

PROOF

605

CHECK HEADSPACE

610

DIS-ASSEMBLE

612

MAGNAFLUX

615

ROLLMARK CALIBER

618

ROTO-BLAST

620

APPLY COATINGS

625 A

FINAL ASSEMBLY

B

TRIGGER PULL TEST

2.852.682.612.622.63

C

SAFETY ON FORCE

444

D

SAFETY OFF FORCE

2.522

E

FIRING PIN INDENT

640

TARGET

655

FINAL INSPECT

660

PACK

QAR INSPECTION

SHIP DATE

6/18/97

Per

Final Inspection

Sn: C6594423

DATE REC'D: 11/3/96

DATE RET'D:

Auditor: RW

Item:

Barrel Assy.

☒ BARREL☒ RECEIVER☒ FRONT SIGHT BLOCK☒ REAR SIGHT BLOCK☒ SCREWS☒ FINISH

Scope Assy.

☒ Scope☒ Scope Rings☒ Mounting Screws☒ Mounting Base☒ SCREWS☒ FINISH☒ Looseness☒ CLARITY

Misc.

☐ DD-250☐ BAR CODE☐ PACKAGING

Item:

Stock Assy.

☒ Stock☒ Sling Swivel Studs☒ ADJUSTABLE BUTT PLATE☒ LOCK NUTS☒ BARREL CLEARANCE☒ COLOR/FINISH

Systems Case

☒ Scope Case☒ IRON SIGHTS☒ Deployment Kit

Trigger

☒ SAFETY OPERATION☒ SET

Comments: