

C6587701

MODEL 700TM M24

Model **SWS** TM

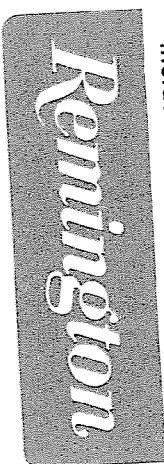
Action _____

Barrel Length _____

Capacity _____

Order No. **5716**

*Includes 1 in chamber.



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: **RE00170716** Serial: **C6587701** Model **M24 SWS** Center Fire Caliber: **7.62 NATO** Repairman: _____ Status: **Closed 7/6/2009 12:59 03 PM**

Verify Repair

Address Information

Customer: ☒ Received From Return To ☐ Received From

Name: **US ARMY GARRISON APC** **US ARMY GARRISON APC**

Address 1: **POLICE DEPT BLDG 2200** **POLICE DEPT BLDG 2200**

Address 2: **ATTN: SRT LT HOLFORD** PO Box: _____ **ATTN: SRT LT HOLFORD** PO Box: _____

City: **ABERDEEN PROVING GROUND** **ABERDEEN PROVING GROUND**

State: **MD** Zip Code: **21005** Country: **US** State: **MD** Zip Code: **21005** Country: **US**

FFL: _____

Contact / Condition Problems Estimate History / Status Shipping / Billing

Contact Information

Phone: **NN**

Fax: _____

Email: _____

Comments: _____

Received Condition

Condition: **Fair**

Notes: _____

CSR Notes: _____

Accessories Received

Code	Desc	Qty
A007	With Stud	2
A010	Hard Case	1
A017	Scope Base	1
A026	Scope	1
A045	Bi Pod	1
A057	FR SIGHT BASE	1

Repair Search **Refresh** **Close** **Refresh** **Close**

7/6/2009 12:59 PM CAPS NUM INS SERIAL

start 5 Microsoft... 5 Microsoft... Part Search by... Misc PDF... Internet Ex... Arms Services... 12:59:59

Serial Number: **C6587701**

Model: **M24 SWS**



RE00170716

INSPECTION CHECKLIST - REPAIRS

CONTRACT #: W52H09-07-C-0207

ISSUED 10/1/2007

R & E NUMBER

170216

SERIAL NUMBER

C6587701

LOG-IN DATE

7-6-09

OPERATION #	OPERATION NAME		DATE	INITIAL
500	DIS-ASSEMBLE GUN		7-10-09	RJR
505	RE-BARREL			
420	ASSEMBLE			
440	PROOF			
460	CHECK HEADSPACE			
470	DIS-ASSEMBLE GUN			
480	MAGNAFLUX			
510	DRILL AND TAP			
500	ROLLMARK CALIBER			
520	GOFF BLAST BBL / REC			
530 & 540	APPLY COATINGS			
560	FINAL ASSEMBLY			
640	FUNCTION TEST AND	PASS FAIL	7/23	RB
650	TARGET	PASS FAIL	7/23	RB
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION	7/23	TJR
670	FINAL INSPECTION			
	A) HEADSPACE	PASS FAIL	7-24-09	RJR
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	250 255 260 262 252 7-24-09	RJR
680	F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX	4.0 4.0 4.0 7-24-09	RJR
	G) SAFETY OFF FORCE	2 LBS MIN	4.0 4.0 4.0 7-24-09	RJR
	I) FIRING PIN INDENT	.020	.002 .003 .003 7-24-09	RJR
690	PACK		9/24/09	Fm

F006 REV 1/2009




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

MODEL 700TM H24

SERIAL NO.
C6587701

ORDER NO.
5716

01

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



5716 C6587701



CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6587701

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	1023	90	RW
600	Proof	1023	90	RW
607	Check Headspace	1023	90	RW
610	Dis-assemble Gun	1023	90	RW
612	Magnaflux Barrel Action		10/24/90	KR
	Magnaflux Bolt		"	KR
615	Rollmark Caliber		"	BS
617	Drill and Tap Sight Holes		10/25/90	FB
618	Polish Barrel AB		10/30/90	WB
620	Apply Coatings (Barrel Action)		11-7-90	TA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		11/12/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		11/12/90	RW
	C) Inspect Ejector Hole for Chamfer		11/12/90	RW
	D) Oil Firing Pin Ass'y		11/12/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		11/19/90	WB

op. #	NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			11/21/90	WB
	G) Safety Off Force	2 1/4	2 1/4	2 1/4			11/21/90	WB
	H) Trigger Pull Test & Retainability						11/19/90	WB
	I) Firing Pin Indent	.023	.023	.023			11/21/90	WB
	J) Assemble Stock						11/26/90	RW
	K) Assemble Swivel Studs						11-28-90	JS
	L) Attach Front and Rear Sight Assemblies						11/26/90	RW
	M) Iron Sight Alignment						11/26/90	RW
	N) Detach Front & Rear Sights & place in numbered container						11/26/90	RW
	O) Attach Scope to Rifle						11/26/90	RW
	P) Detach & Attach Scope 20 Times						11/26/90	RW
640	Gallery Target & Test						11-27-90	DH
	A) Time						11-27-90	DH
	B) Malfunctions						11-27-90	DH
	C) Pierced Primers						11-27-90	DH
	D) Optical Clarity of Scope						11-27-90	DH
645	Inspect for Live Ammo						11-27-90	DH
655	Final Inspection							
	A) Headspace						11-28-90	JS
	B) Trigger Pull	262	230	228	230	235	11-28-90	JS
	C) Function						11-28-90	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. C6587701

DATE 11/19/90

TESTER WB

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.45	2.45	2.50	2.62	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.47	2.55	2.55	2.76	
PULL #3	2.38	2.30	2.57	2.28	
PULL #4	2.43	2.52	2.58	2.30	
PULL #5	2.45	2.48	2.57	2.35	
TOTAL	12.18	12.30	12.77		
AVG.	2.43	2.46	2.55		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.20	3.32		
PULL #2	3.14	3.16		
PULL #3	3.05	3.30		
PULL #4	3.18	3.37		
PULL #5	3.25	3.37		
TOTAL	15.82	16.52		
AVG.	3.16	3.30		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.35	4.32		4.19
PULL #2	4.39	4.31		4.20
PULL #3	4.40	4.33		4.20
PULL #4	4.39	4.32		4.24
PULL #5	4.35	4.23		4.25
TOTAL	21.88	21.51		21.08
AVG.	4.38	4.30		4.21

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6587701
27 Nov 1990

CENTROIDAL DISTANCES

0	TO	1	.330492
1	TO	2	.282809
1	TO	3	.697001
1	TO	4	.203062
1	TO	5	.463781

1
4
3

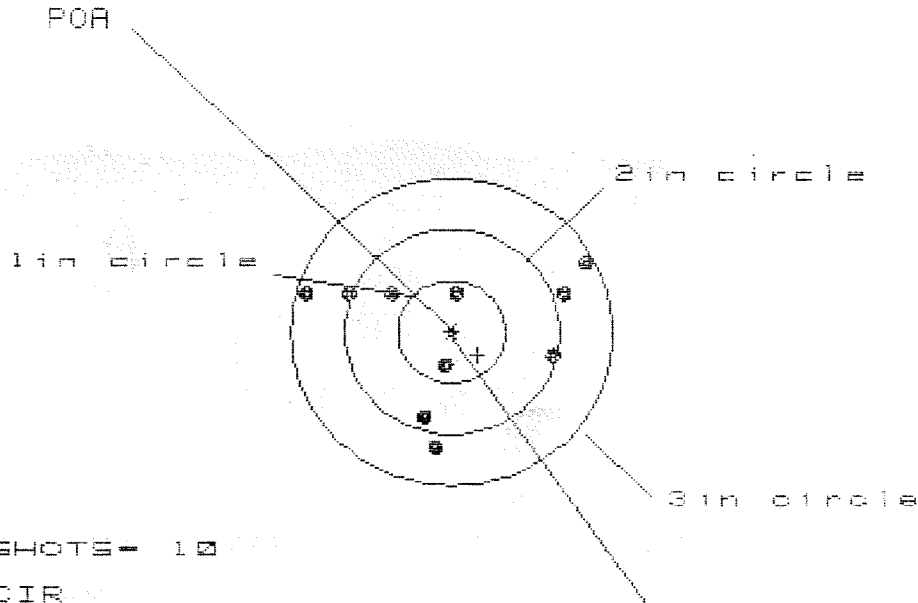
<----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.011
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .024
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0264000
THE AMR FOR THIS RIFLE IS: .9696

27 Nov 1998

FILE:/PATTERNING/CENTERFIRE_PATT/06587701

CENTERFIRE PATTERNS # 1



OF SHOTS - 10

IN CIRCLE

1in = 2

2in = 5

3in = 10

HS = 2.598

VS = 1.836

GS = 2.613

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.198	1.043	1.060
MINIMUM X	-1.400	-1.082	-.952
MAXIMUM Y	.665	.708	.556
MINIMUM Y	-1.171	-1.128	-1.040
CENTROID X	-.243	-.088	-.218
CENTROID Y	.224	.181	.093
POA TO CENTROID in.	.331	.201	.237
MIN RADIUS	.312	.360	.207
MEAN RADIUS	.935	.878	.808
MAX RADIUS	1.453	1.260	1.161
HORIZONTAL SPREAD	2.598	2.125	2.012
VERTICAL SPREAD	1.836	1.836	1.596
EXTREME SPREAD	2.613	2.265	2.014
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	10		

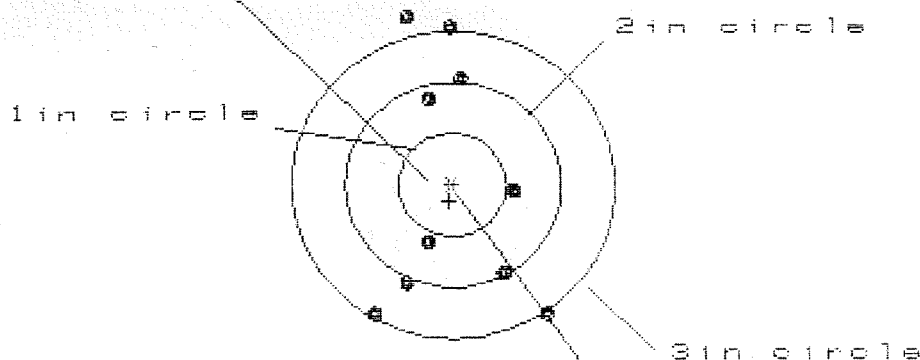
27 Nov 1990

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CENTERFIRE PATTERNS

2

POA



OF SHOTS = 10

IN CIRC

1 in = 0

2 in = 3

3 in = 7

HS = 1.538

VS = 2.896

GS = 3.161

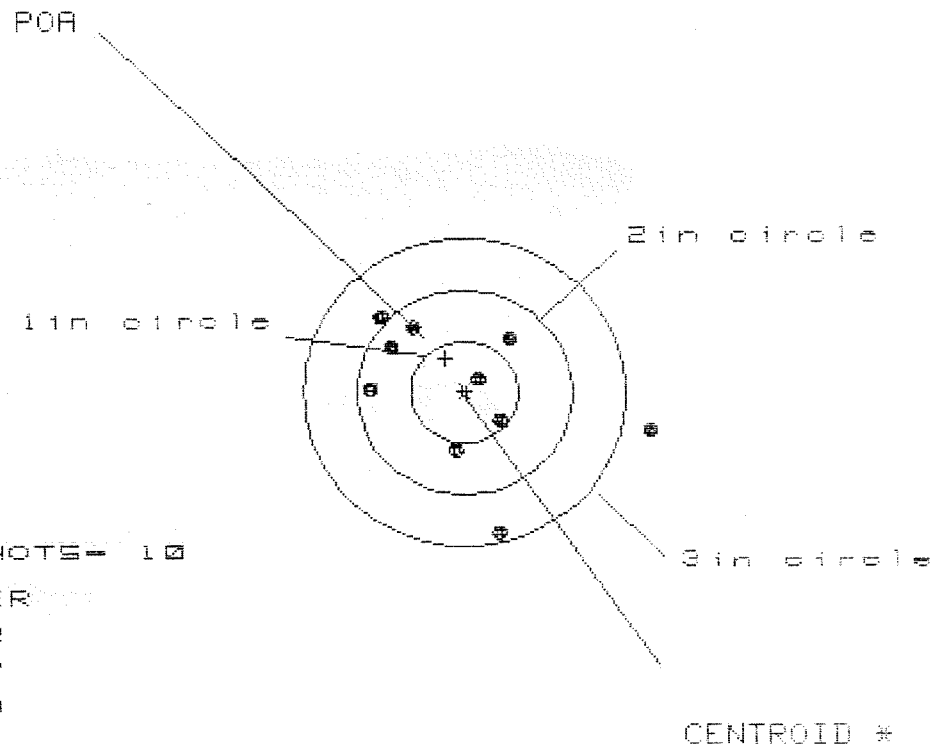
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.822	.773	.766
MINIMUM X	:	-.716	-.765	-.772
MAXIMUM Y	:	1.593	1.740	1.471
MINIMUM Y	:	-1.303	-1.126	-.909
CENTROID X	:	.032	.081	.088
CENTROID Y	:	.158	-.019	-.236
POA TO CENTROID in.	:	.161	.083	.252
MIN RADIUS	:	.604	.497	.340
MEAN RADIUS	:	1.145	1.061	.932
MAX RADIUS	:	1.653	1.741	1.471
HORIZONTAL SPREAD	:	1.538	1.538	1.538
VERTICAL SPREAD	:	2.896	2.866	2.380
EXTREME SPREAD	:	3.161	2.983	2.499
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		7	

27 Nov 1998

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CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1in = 2

2in = 7

3in = 9

HS = 2.618

VS = 2.132

GS = 2.701

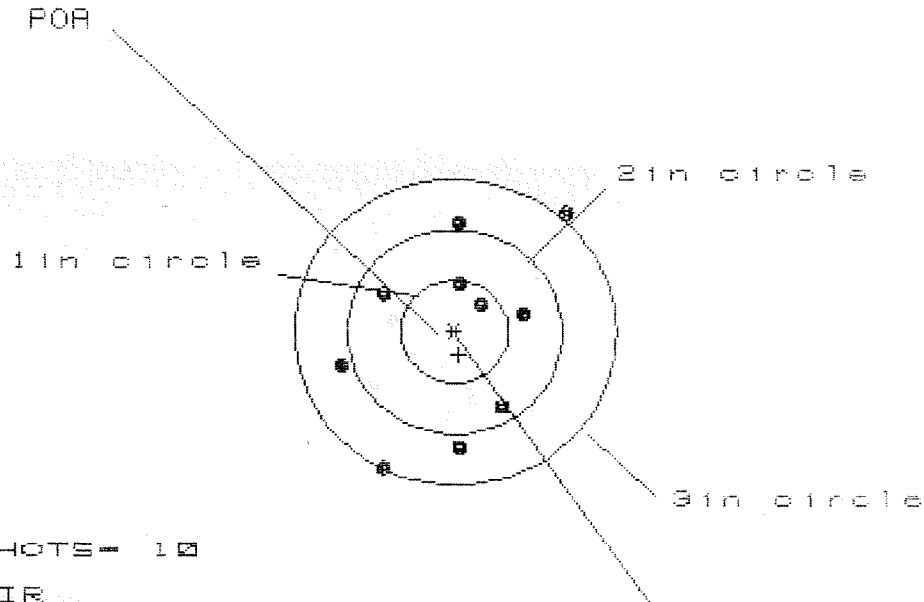
PATTERN #	3		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.715	.602	.670
MINIMUM X	-.903	-.712	-.644
MAXIMUM Y	.764	.727	.551
MINIMUM Y	-1.368	-1.405	-.786
CENTROID X	.176	-.015	-.083
CENTROID Y	-.333	-.296	-.120
POA TO CENTROID in.	.376	.296	.146
MIN RADIUS	.156	.301	.368
MEAN RADIUS	.858	.747	.627
MAX RADIUS	1.747	1.507	.797
HORIZONTAL SPREAD	2.618	1.314	1.314
VERTICAL SPREAD	2.132	2.132	1.337
EXTREME SPREAD	2.701	2.401	1.497
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		9	

27 Nov 1938

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CENTERFIRE PATTERNS

4



OF SHOTS = 10

IN CIR

1in = 2

2in = 5

3in = 8

HS = 2.063

VS = 2.512

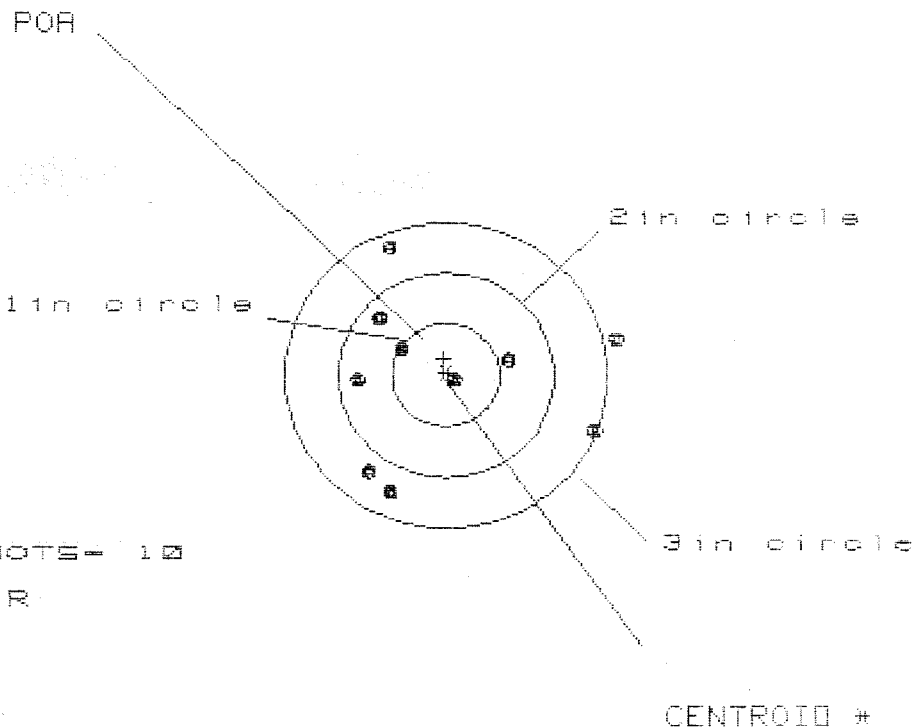
GS = 3.021

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.030	.737	.670
MINIMUM X	:	-1.033	-.919	-.986
MAXIMUM Y	:	1.156	1.217	1.064
MINIMUM Y	:	-1.356	-1.228	-1.143
CENTROID X	:	-.040	-.154	-.087
CENTROID Y	:	.229	.101	.255
POA TO CENTROID in.	:	.233	.184	.269
MIN RADIUS	:	.344	.515	.356
MEAN RADIUS	:	.939	.885	.791
MAX RADIUS	:	1.548	1.339	1.146
HORIZONTAL SPREAD	:	2.063	1.656	1.656
VERTICAL SPREAD	:	2.512	2.445	2.207
EXTREME SPREAD	:	3.021	2.538	2.207
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

27 Nov 1998

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CENTERFIRE PATTERNS # 5



OF SHOTS - 10

IN CIR

1in = 1

2in = 5

3in = 9

HS = 2.418

VS = 2.417

GS = 2.688

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	1.563
MINIMUM X	-.855
MAXIMUM Y	1.278
MINIMUM Y	-1.139
CENTROID X	.020
CENTROID Y	-.158
POR TO CENTROID in.	.159
MIN RADIUS	.139
MEAN RADIUS	.971
MAX RADIUS	1.595
HORIZONTAL SPREAD	2.418
VERTICAL SPREAD	2.417
EXTREME SPREAD	2.688
NUMBER IN ONE INCH CIRCLE =	1
NUMBER IN TWO INCH CIRCLE =	5
NUMBER IN THREE INCH CIRCLE =	9