

C6611521

MODEL 700™ M24

Model S&S™

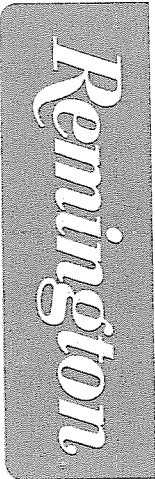
Action

Barrel Length

Capacity

Order No. 5715

*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: RE00166678

Serial: C6611521 Model M24 SWS Center Fire
Caliber: 7.62 NATO

Repairman:

Verify Repair

Status:

Closed 4/20/2009 2:49:17 PM

Address Information

Customer: ☒ Received From Return To: ☐ Received From

Name: DIRECTOR OF EMERGENCY SERVICES

Address 1: BLDG 53

Address 2: ANNISTON ARMY DEPOT PO Box:

City: ANNISTON

State: AL Zip Code: 36201 Country: US

State: AL Zip Code: 36201 Country: US

FEL:

Contact / Condition	Problems	Estimate	History / Status	Shipping / Billing
Date	Code	User ID	Desc1	Current Status
4/20/2009 2:46:28 PM	New	valentds	Repair Added	Closed
4/20/2009 2:49:17 PM	Closed	valentds	Closed at Expedite	4/20/2009 2:49:17 PM
				valentds
				Sniper Systems
				Repair Location
				ILN
				Current Location
				ILN
				Transfer Number

Repair Search

Refresh

Close

naglel

4/20/2009

3:34 PM

CAPE

NUM

ING

SCAL

Serial Number:

C6611521

Model: M24 SWS

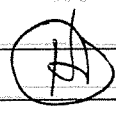


RE00166678

INSPECTION CHECKLIST - REPAIRS

CONTRACT #: W52H09-07-C-0207

ISSUED 10/1/2007

R & E NUMBER	<u>166678</u>			
SERIAL NUMBER	<u>C6611521</u>			
LOG-IN DATE	<u>4-20-09</u>			
OPERATION #	OPERATION NAME		DATE	INITIAL
500	DIS-ASSEMBLE GUN		4-24-09	RTZ
505	RE-BARREL		4-28-09	FR
420	ASSEMBLE		4-28-09	RTZ
440	PROOF	MAGNA - FLUX	4-28-09	TAR
460	CHECK HEADSPACE		4-28-09	TAR
470	DIS-ASSEMBLE GUN		4-28-09	RTZ
480	MAGNAFLUX	OPERATOR 	5/6/09	
510	DRILL AND TAP		4-28-09	SP
500	ROLLMARK CALIBER		5/7/09	RT
520	GOFF BLAST BBL / REC		5/7/09	RTM
530 & 540	APPLY COATINGS		5/8	
560	FINAL ASSEMBLY		5-11-09	RTL
640	FUNCTION TEST AND	<u>PASS</u> FAIL		
650	TARGET	<u>PASS</u> FAIL	5-12-09	WN
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION	5/12/09	RB
670	FINAL INSPECTION			
	A) HEADSPACE	<u>PASS</u> FAIL	5-13-09	RTZ
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	265 259 257 263 257	5-13-09 RTZ
680	F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX	40 40 40	5-13-09 L. 21
	G) SAFETY OFF FORCE	2 LBS MIN	50 50 50	5-13-09 L. 21
	I) FIRING PIN INDENT	.020	.023 .023 .023	5-13-09 L. 21
690	PACK		5/13/09	Em

F006 REV 1/2009

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6611521.___0
FILE DATE AND TIME: 05/12/2009 12:56

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

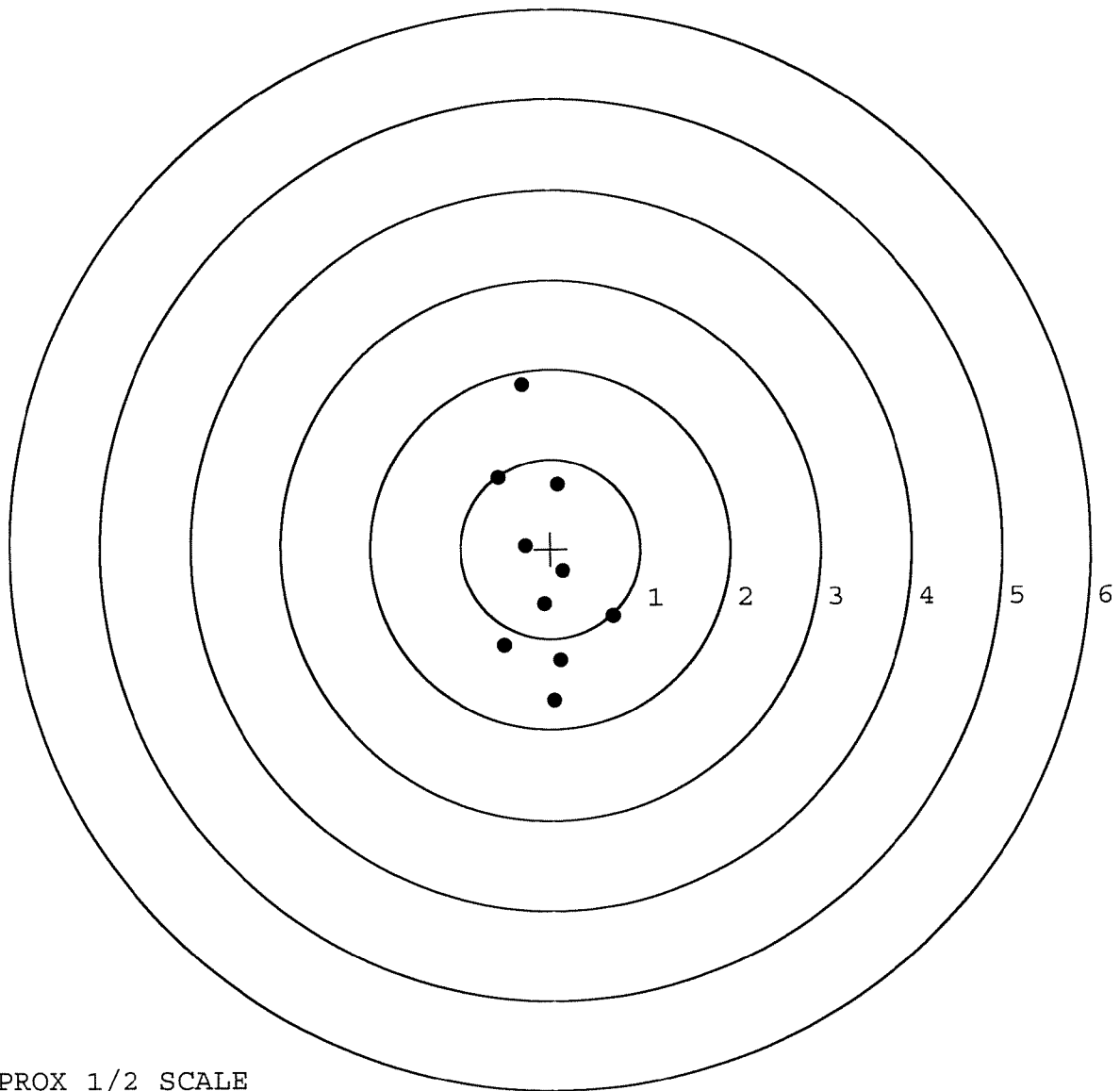
The Average X Centroid of the Five Target Set:	-0.077
The Average Y Centroid of the Five Target Set:	0.012
The Average Point of Impact of the Five Target Set:	0.078
The Average Mean Radius of the Five Target Set:	0.741
The Distance from POA to Centroid Target #1:	0.237
The Distance from Centroid Target #2 to Centroid Target #1:	0.327
The Distance from Centroid Target #3 to Centroid Target #1:	0.191
The Distance from Centroid Target #4 to Centroid Target #1:	0.211
The Distance from Centroid Target #5 to Centroid Target #1:	0.496

BARBER - M24 0078183

SERIAL NUMBER: C6611521. __0
TARGET NUMBER: 1
FILE DATE: 05/12/2009
FILE TIME: 12:56

X CENTROID: -0.072
Y CENTROID: -0.226
POA TO CENTROID: 0.237
HORZ SPREAD: 1.272
VERT SPREAD: 3.517
GROUP SPREAD: 3.533
MIN RADIUS: 0.210
MAX RADIUS: 2.067
MEAN RADIUS: 0.951
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 6
in 3 IN DIAMETER: 9

POINT#	X	Y
1:	-0.308	1.828
2:	-0.577	0.798
3:	0.083	0.717
4:	-0.282	0.036
5:	0.137	-0.248
6:	-0.076	-0.626
7:	0.695	-0.755
8:	0.104	-1.246
9:	0.029	-1.689
10:	-0.526	-1.074



TARGET APPROX 1/2 SCALE

BARBER - M24 0078184

SERIAL NUMBER: C6611521. __0

TARGET NUMBER: 2

FILE DATE: 05/12/2009

FILE TIME: 12:56

X CENTROID: -0.040

Y CENTROID: 0.099

POA TO CENTROID: 0.107

HORZ SPREAD: 0.938

VERT SPREAD: 2.045

GROUP SPREAD: 2.109

MIN RADIUS: 0.135

MAX RADIUS: 1.195

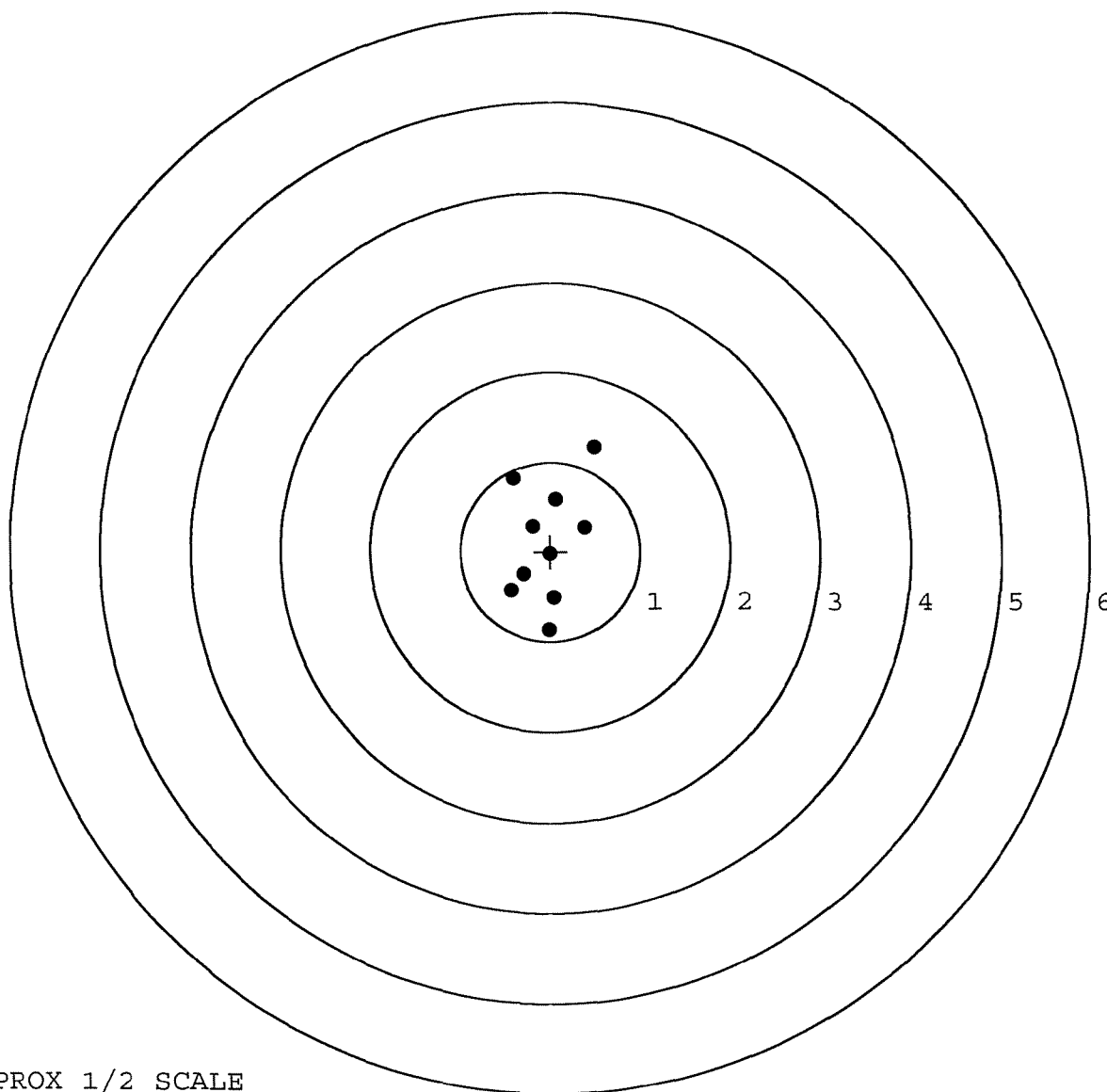
MEAN RADIUS: 0.604

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.498	1.167
2:	-0.418	0.814
3:	0.059	0.582
4:	-0.200	0.281
5:	0.388	0.268
6:	-0.009	-0.032
7:	0.045	-0.518
8:	-0.016	-0.878
9:	-0.440	-0.439
10:	-0.305	-0.251



TARGET APPROX 1/2 SCALE

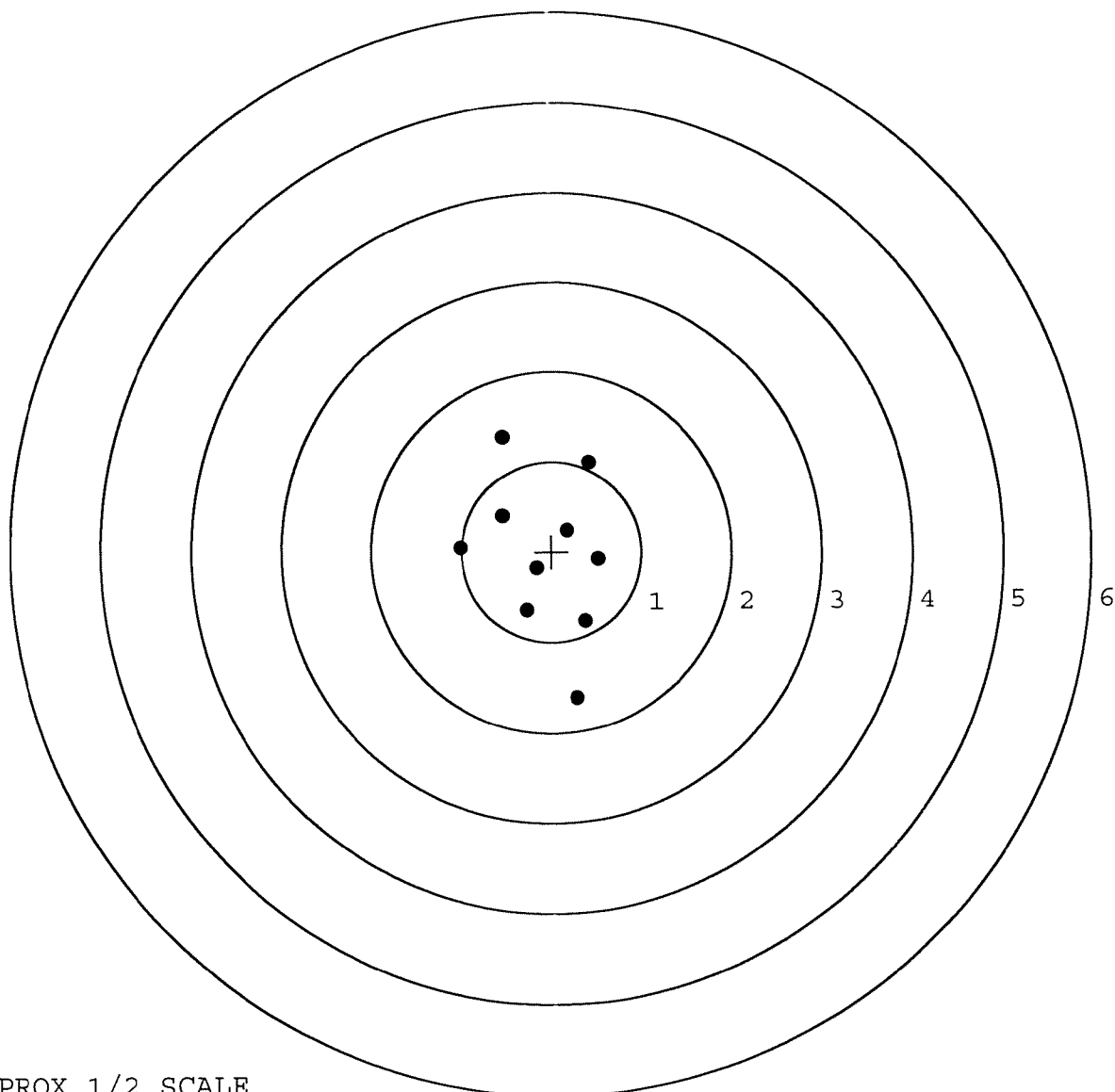
BARBER - M24 0078185

SERIAL NUMBER: C6611521. __0
TARGET NUMBER: 3
FILE DATE: 05/12/2009
FILE TIME: 12:56

X CENTROID: -0.075
Y CENTROID: -0.035
POA TO CENTROID: 0.083
HORZ SPREAD: 1.533
VERT SPREAD: 2.891
GROUP SPREAD: 3.002
MIN RADIUS: 0.178
MAX RADIUS: 1.620
MEAN RADIUS: 0.839

IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 9

POINT#	X	Y
1:	-0.534	1.274
2:	0.427	0.989
3:	-0.540	0.405
4:	0.180	0.238
5:	0.526	-0.085
6:	-0.173	-0.184
7:	-1.007	0.053
8:	-0.282	-0.651
9:	0.375	-0.773
10:	0.275	-1.617



TARGET APPROX 1/2 SCALE

BARBER - M24 0078186

SERIAL NUMBER: C6611521. __0

TARGET NUMBER: 4

FILE DATE: 05/12/2009

FILE TIME: 12:56

X CENTROID: -0.181

Y CENTROID: -0.046

POA TO CENTROID: 0.187

HORZ SPREAD: 0.847

VERT SPREAD: 2.257

GROUP SPREAD: 2.257

MIN RADIUS: 0.121

MAX RADIUS: 1.179

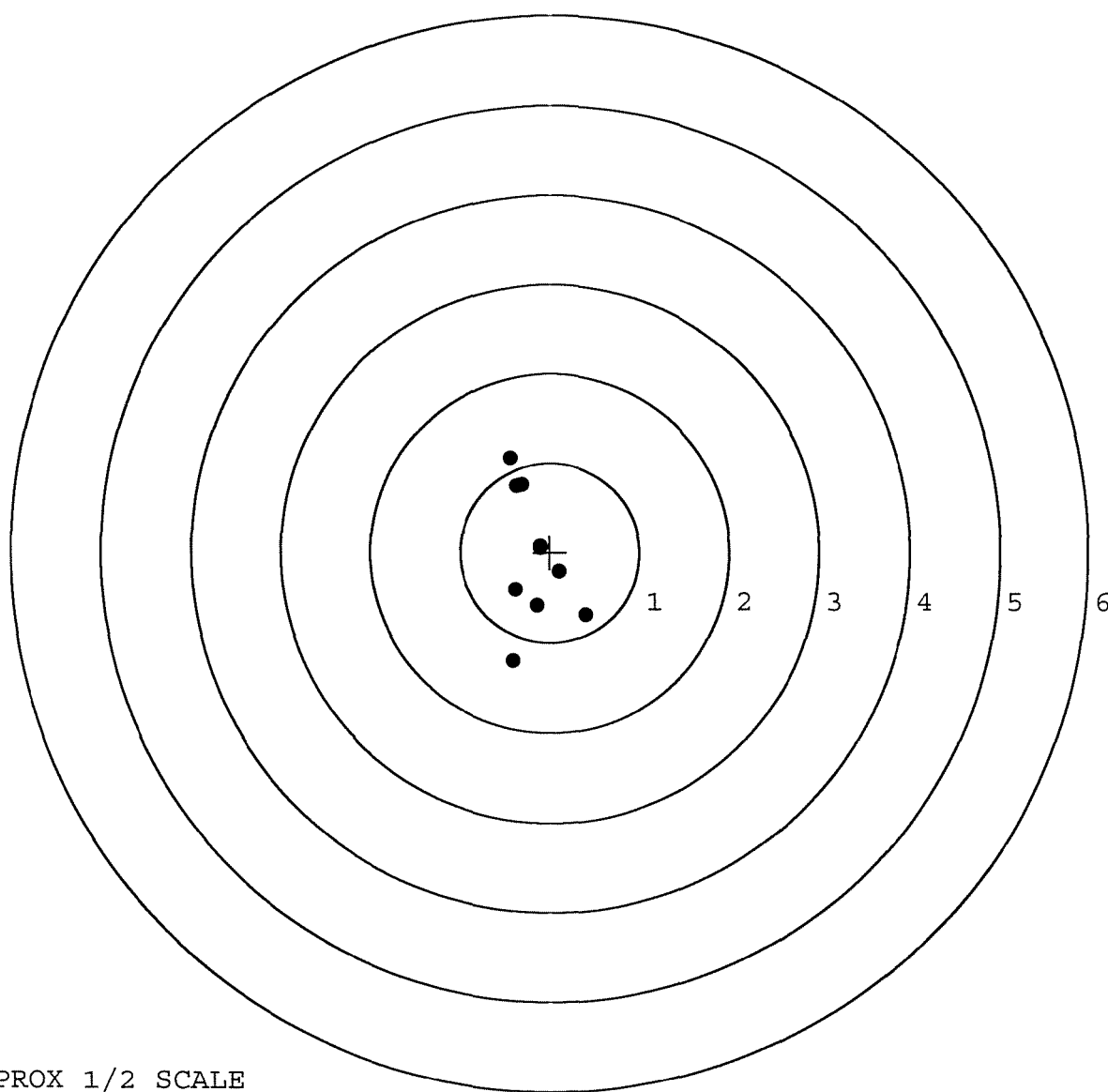
MEAN RADIUS: 0.638

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.444	1.057
2:	-0.376	0.742
3:	-0.112	0.068
4:	0.104	-0.216
5:	-0.387	-0.418
6:	-0.150	-0.599
7:	0.403	-0.699
8:	-0.419	-1.200
9:	-0.110	0.052
10:	-0.320	0.756



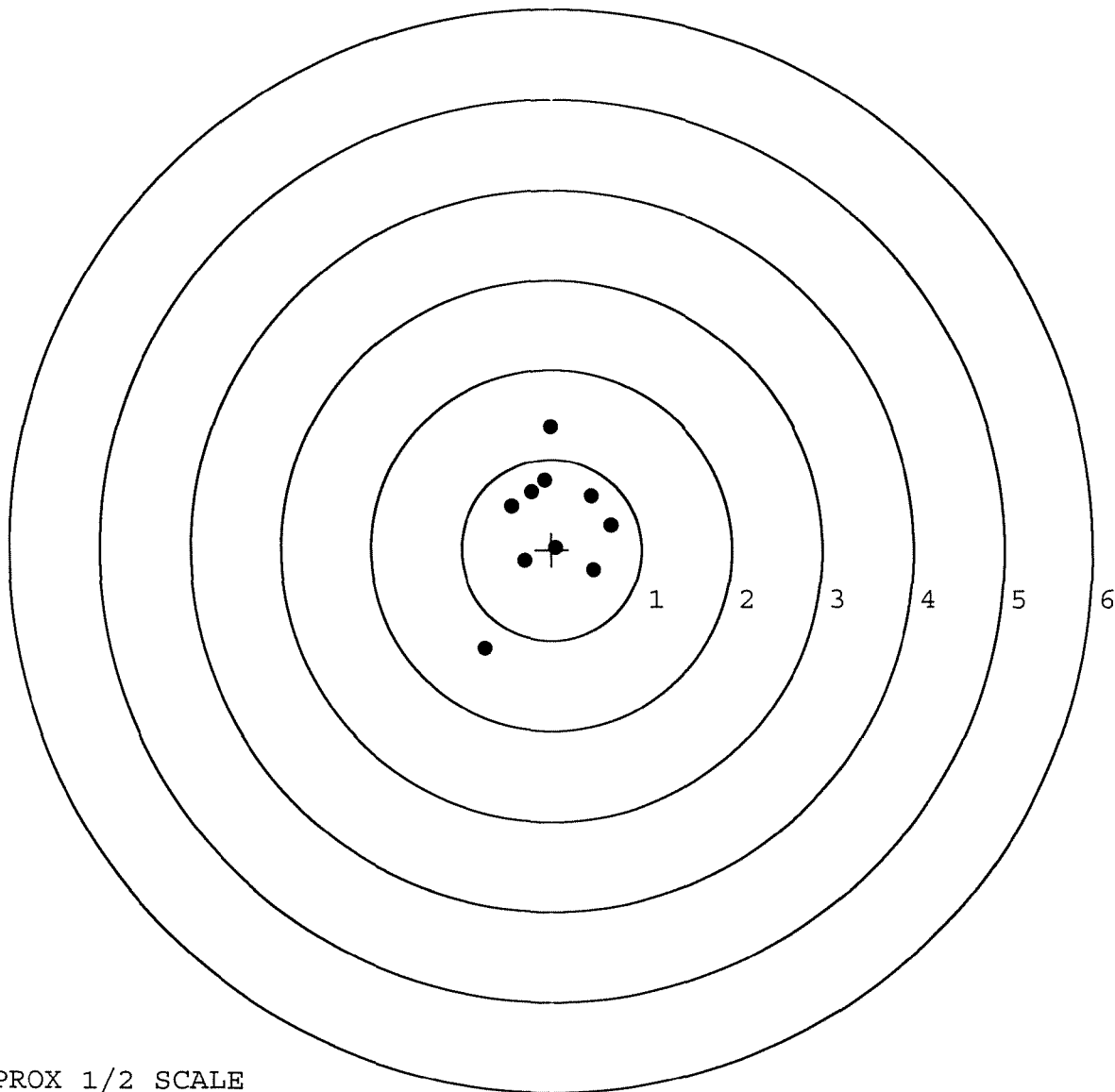
TARGET APPROX 1/2 SCALE

BARBER - M24 0078187

SERIAL NUMBER: C6611521. __0
TARGET NUMBER: 5
FILE DATE: 05/12/2009
FILE TIME: 12:56

POINT#	X	Y
1:	-0.018	1.363
2:	0.448	0.591
3:	0.661	0.270
4:	0.469	-0.233
5:	0.044	0.025
6:	-0.302	-0.130
7:	-0.734	-1.094
8:	-0.444	0.477
9:	-0.223	0.639
10:	-0.078	0.762

X CENTROID: -0.018
Y CENTROID: 0.267
POA TO CENTROID: 0.268
HORZ SPREAD: 1.395
VERT SPREAD: 2.457
GROUP SPREAD: 2.559
MIN RADIUS: 0.250
MAX RADIUS: 1.538
MEAN RADIUS: 0.671
IN 1 IN DIAMETER: 5
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

 		VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.
MODEL 700™ M24		SERIAL NO. C6611521
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat & Tm. Off, Marca Registrada Marque Deposee.		ORDER NO. 5716



5716 C6611521

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6611521

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	QUALITY AUDIT	3/12/91	K.S.
600	Proof		3/12/91	K.S.
607	Check Headspace		3/12/91	K.S.
610	Dis-assemble Gun		3/12/91	K.S.
612	Magnaflux Barrel Action		3/27/91	KR
	Magnaflux Bolt		11	KR
615	Rollmark Caliber		3/27/91	L.S.
617	Drill and Tap Sight Holes		APR 3 1991	LB
618	Polish Barrel		APR 3 1991	WB
620	Apply Coatings (Barrel Action)		4-18-91	JH
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		4/30/91	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		4/30/91	KS
	C) Inspect Ejector Hole for Chamfer		4/30/91	KS
	D) Oil Firing Pin Ass'y		4/30/91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		5/3/91	JH

op. #	BARBER NAME M24 0078190	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			5/4/91	QJ
	G) Safety Off Force	3	3	3			5/4/91	QJ
	H) Trigger Pull Test & Retainability						5/3/91	QJ
	I) Firing Pin Indent	.0215	.0215	.0215			5/4/91	QJ
	J) Assemble Stock						5/7/91	KS
	K) Assemble Swivel Studs						5-9-91	AC
	L) Attach Front and Rear Sight Assemblies						5/7/91	KS
	M) Iron Sight Alignment						5/7/91	KS
	N) Detach Front & Rear Sights & place in numbered container						5/7/91	KS
	O) Attach Scope to Rifle						5/7/91	KS
	P) Detach & Attach Scope 20 Times						5/7/91	KS
640	Gallery Target & Test						5-8-91	DH
	A) Time						5-8-91	DH
	B) Malfunctions						5-8-91	DH
	C) Pierced Primers						5-8-91	DH
	D) Optical Clarity of Scope						5-8-91	DH
645	Inspect for Live Ammo						5-8-91	DH
655	Final Inspection						5-9-91	AC
	A) Headspace						5-9-91	AC
	B) Trigger Pull	2.15	2.13	2.15	2.17	2.18	5/9/91	QJ
	C) Function						5-9-91	AC
660	Pack						6-17-91	N

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C661152

DATE 5-3-91

TESTER JEP

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.44	2.16	2.25	2.15	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.22	2.15	2.18	2.13	
PULL #3	2.32	2.16	2.20	2.15	
PULL #4	2.23	2.18	2.22	2.17	
PULL #5	2.31	2.23	2.26	2.18	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES			COMMENTS
PULL #1	3.52	3.47			
PULL #2	3.43	3.56			
PULL #3	3.46	3.52			
PULL #4	3.45	3.47			
PULL #5	3.48	3.53			
TOTAL					
AVG.					

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.22	4.31		4.79
PULL #2	4.29	4.53		4.47
PULL #3	4.53	4.27		4.45
PULL #4	4.22	4.38		4.46
PULL #5	4.33	4.44		4.26
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611521
8 May 1991

CENTROIDAL DISTANCES

0 TO	1	.265415
1 TO	2	.150013
1 TO	3	.56927
1 TO	4	.499544
1 TO	5	.327905

42 <----POA

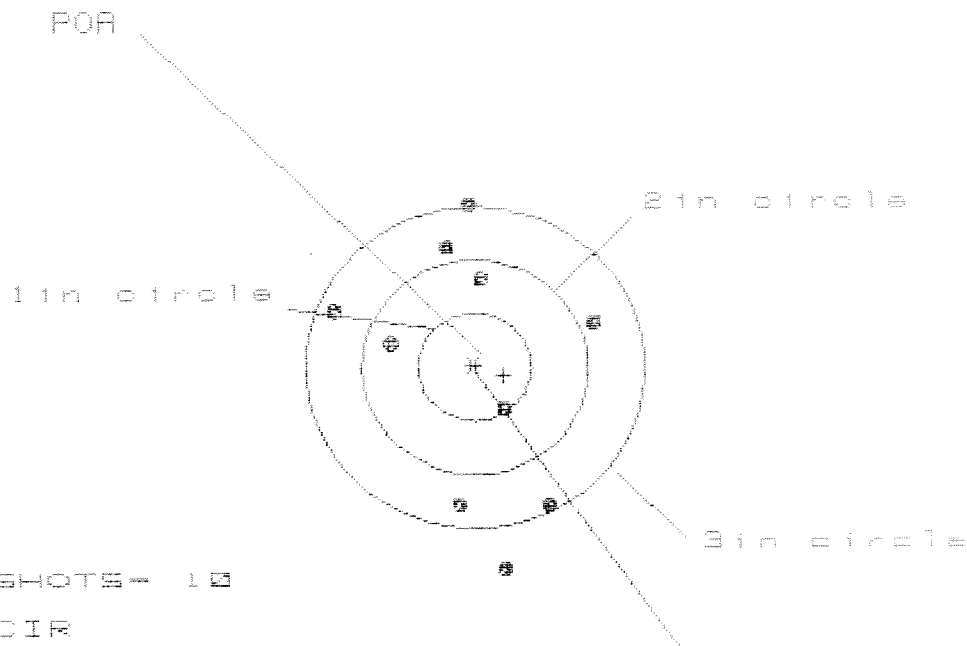
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: 1.043
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: 1.043
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: 1.043

THE AMR FOR THIS RIFLE IS: 1.043

6 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611521

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 1

2in = 3

3in = 8

HS= 2.293

VS= 3.397

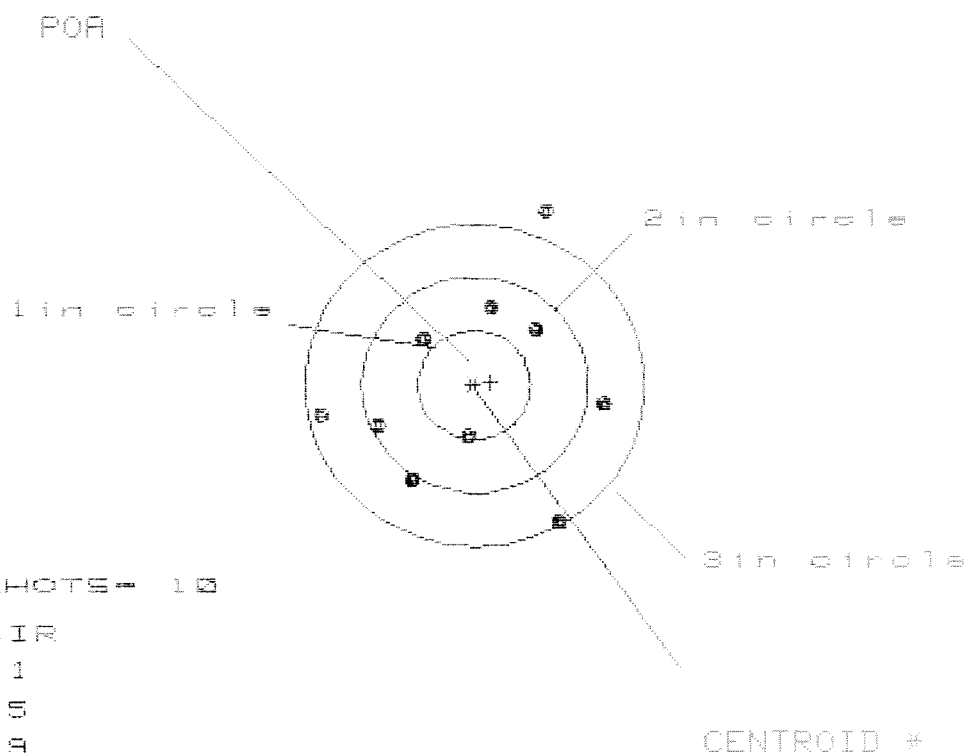
GS= 3.414

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.039	1.072	1.071
MINIMUM X	-1.254	-1.221	-1.232
MAXIMUM Y	1.555	1.350	1.074
MINIMUM Y	-1.842	-1.434	-1.145
CENTROID X	-.254	-.287	-.310
CENTROID Y	.077	.282	.101
FOR TO CENTROID in.	.266	.493	.301
MIN RADIUS	.454	.647	.501
MEAN RADIUS	1.176	1.076	.901
MAX RADIUS	1.866	1.591	1.301
HORIZONTAL SPREAD	2.293	2.293	1.701
VERTICAL SPREAD	3.397	2.784	2.101
EXTREME SPREAD	3.414	2.870	2.101
NUMBER IN ONE INCH CIRCLE =	1	1	1
NUMBER IN TWO INCH CIRCLE =	3	3	3
NUMBER IN THREE INCH CIRCLE =	8	8	8

6 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08611521

CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1in = 1

2in = 5

3in = 9

HS = 2.500

VS = 2.900

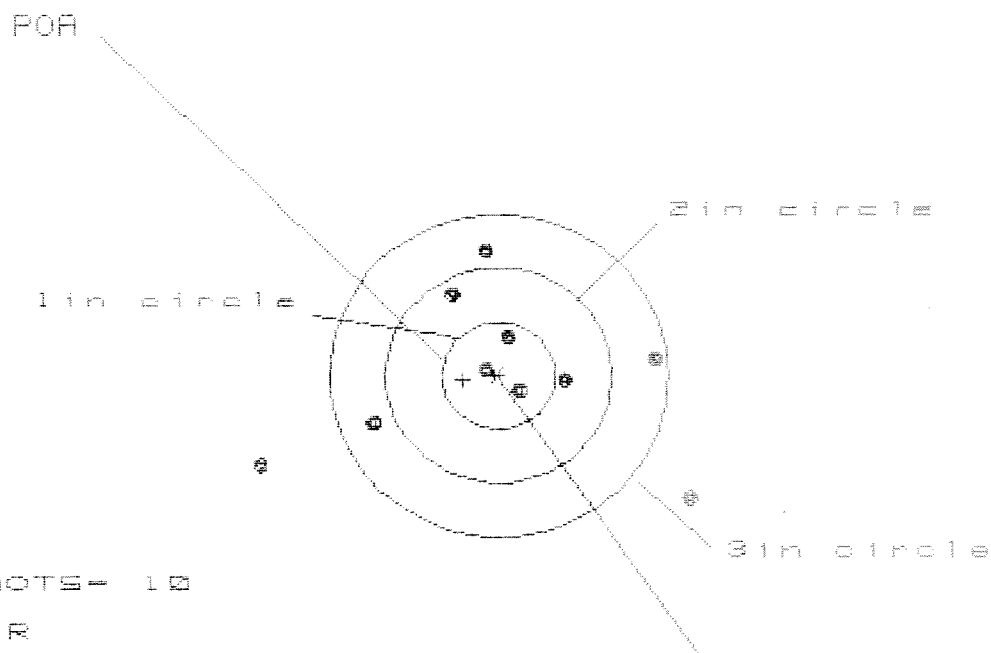
GS = 2.900

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.171	1.238	1.338
MINIMUM X	:	-1.337	-1.270	-1.170
MAXIMUM Y	:	1.671	.900	.769
MINIMUM Y	:	-1.235	-1.050	-.838
CENTROID X	:	-.144	-.210	-.210
CENTROID Y	:	-.025	-.210	-.079
POA TO CENTROID in.	:	.146	.297	.320
MIN RADIUS	:	.450	.255	.289
MEAN RADIUS	:	1.025	.922	.860
MAX RADIUS	:	1.776	1.316	1.342
HORIZONTAL SPREAD	:	2.508	2.508	2.508
VERTICAL SPREAD	:	2.906	1.950	1.607
EXTREME SPREAD	:	2.909	2.510	2.510
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

8 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8611521

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 3

2in = 5

3in = 8

HS= 3.736

VS= 2.323

GS= 3.750

CENTROID +

PATTERN #	:	3	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.645	1.413	1.377
MINIMUM X	:	-2.091	-1.345	-1.168
MAXIMUM Y	:	1.208	1.120	.969
MINIMUM Y	:	-1.115	-1.203	-.725
CENTROID X	:	.314	.546	.369
CENTROID Y	:	.039	.126	.277
POA TO CENTROID in.	:	.316	.560	.461
MIN RADIUS	:	.110	.193	.172
MEAN RADIUS	:	1.021	.873	.721
MAX RADIUS	:	2.235	1.856	1.378
HORIZONTAL SPREAD	:	3.736	2.758	2.545
VERTICAL SPREAD	:	2.323	2.323	1.694
EXTREME SPREAD	:	3.750	2.926	2.630
NUMBER IN ONE INCH CIRCLE	=	3		
NUMBER IN TWO INCH CIRCLE	=	5		
NUMBER IN THREE INCH CIRCLE	=	8		

8 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08611521

CENTERFIRE PATTERNS # 4

POA

1in circle

2in circle

3in circle

OF SHOTS= 10

IN CIR

1in = 1

2in = 4

3in = 9

HS= 1.844

VS= 3.377

GS= 3.470

CENTROID #

PATTERN #	:	4	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.116	1.169	1.084
MINIMUM X	:	-.728	-.675	-.566
MAXIMUM Y	:	1.198	.956	1.060
MINIMUM Y	:	-2.179	-1.143	-1.039
CENTROID X	:	.208	.155	.240
CENTROID Y	:	-.113	.129	.025
POA TO CENTROID in.	:	.237	.202	.241
MIN RADIUS	:	.121	.140	.102
MEAN RADIUS	:	1.018	.835	.814
MAX RADIUS	:	2.230	1.478	1.348
HORIZONTAL SPREAD	:	1.844	1.844	1.644
VERTICAL SPREAD	:	3.377	2.099	2.099
EXTREME SPREAD	:	3.470	2.535	2.255
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		9	

8 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8611521

CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 1

2in = 7

3in = 8

HS= 3.170

VS= 2.333

GS= 3.793

CENTROID #

PATTERN #	:	5	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.529	1.329	1.145
MINIMUM X	:	-1.641	-1.471	-0.880
MAXIMUM Y	:	.911	.753	.816
MINIMUM Y	:	-1.422	-0.782	-0.719
CENTROID X	:	-0.003	-0.173	0.011
CENTROID Y	:	-0.134	0.024	-0.039
POA TO CENTROID in.	:	0.134	0.175	0.041
MIN RADIUS	:	0.035	0.261	0.130
MEAN RADIUS	:	0.973	0.851	0.747
MAX RADIUS	:	2.088	1.555	1.156
HORIZONTAL SPREAD	:	3.170	2.800	2.035
VERTICAL SPREAD	:	2.333	1.535	1.935
EXTREME SPREAD	:	3.793	2.830	2.029
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	7		
NUMBER IN THREE INCH CIRCLE	=	8		