

G653 5236
R4460
F 641 3617

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: RE00132645

Serial: G6535236 Model M24 SWS Center Fire
Caliber: 7.62 NATO

Repairman:

Verify Repair

Status:

Closed 8/14/2007 8:30:38 AM

Address Information

Customer:

Received From

Return To:

Received From

Name: TRANSPORTATION DIVISION DFEL

TRANSPORTATION DIVISION DFEL

Address 1: 6759 MITCHELL AVENUE

6759 MITCHELL AVENUE

Address 2: BLDG 1836

PO Box:

BLDG 1836

PO Box:

City: FORT BENNING

FORT BENNING

State: GA

Zip Code: 31905

Country: US

State: GA

Zip Code: 31905

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
A010	Hard Case	1
A017	Scope Base	1
A026	Scope	1
A057	Fit and Rear Sgt Base	1

Repair Search

Refresh

Close

naglel

8/14/2007

3:23 PM

CAPS

NUM

INS

SCRL



3:23 PM

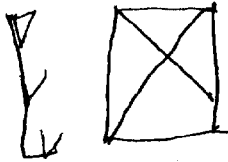
Serial Number: G6535236

Model: M24 SWS



RE00132645

New Bi Pod



85

14
35
21

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6535236.__0

FILE DATE AND TIME: 09/27/2007 05:22

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.021
The Average Y Centroid of the Five Target Set:	-0.051
The Average Point of Impact of the Five Target Set:	0.055
The Average Mean Radius of the Five Target Set:	0.685
The Distance from POA to Centroid Target #1:	0.142
The Distance from Centroid Target #2 to Centroid Target #1:	0.194
The Distance from Centroid Target #3 to Centroid Target #1:	0.088
The Distance from Centroid Target #4 to Centroid Target #1:	0.211
The Distance from Centroid Target #5 to Centroid Target #1:	0.134

SERIAL NUMBER: G6535236. __0

TARGET NUMBER: 1

FILE DATE: 09/27/2007

FILE TIME: 05:22

X CENTROID: 0.088

Y CENTROID: -0.111

POA TO CENTROID: 0.142

HORZ SPREAD: 2.061

VERT SPREAD: 1.953

GROUP SPREAD: 2.257

MIN RADIUS: 0.037

MAX RADIUS: 1.364

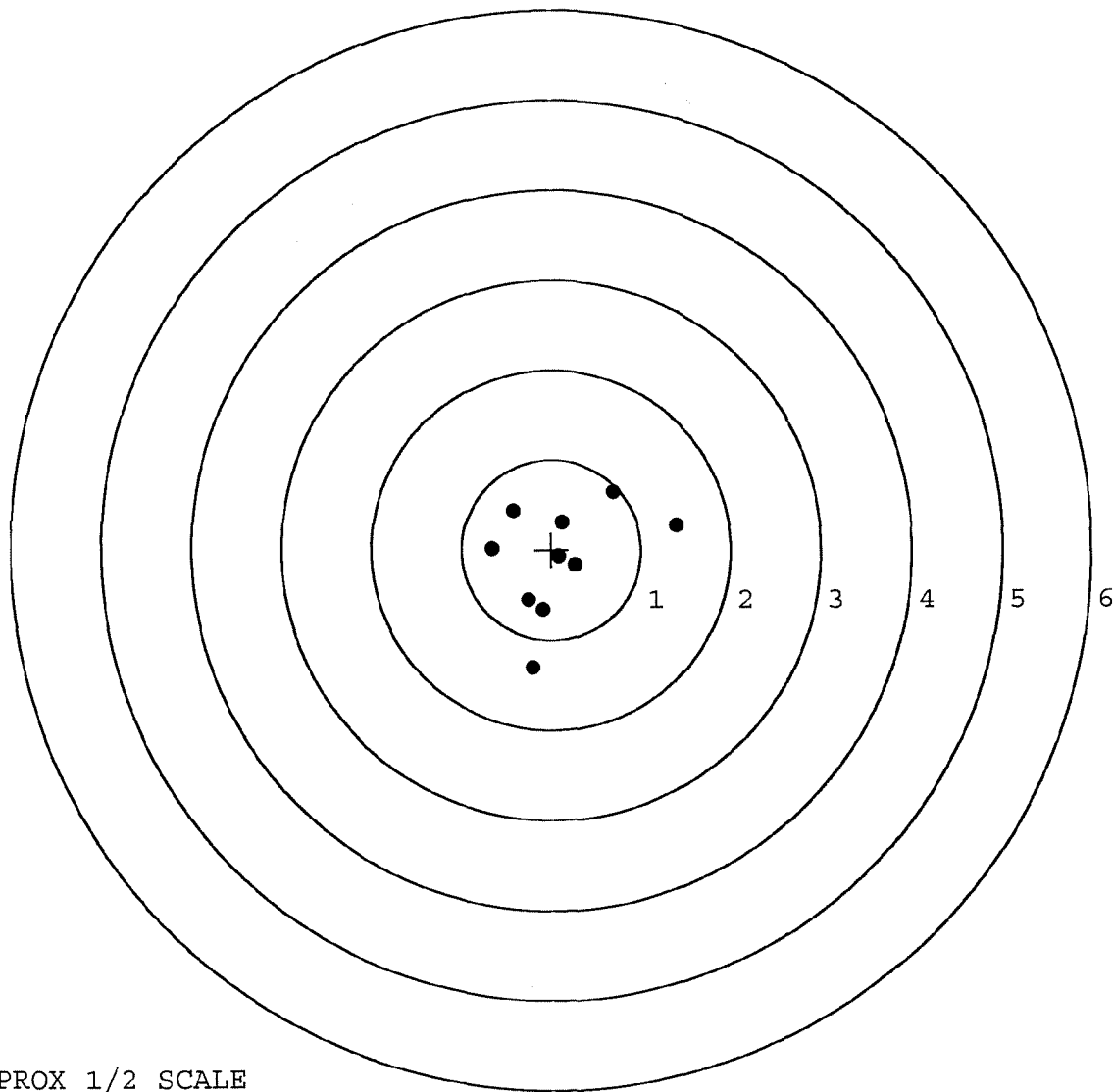
MEAN RADIUS: 0.687

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	1.399	0.265
2:	0.690	0.644
3:	-0.218	-1.309
4:	-0.105	-0.667
5:	-0.261	-0.555
6:	0.266	-0.169
7:	0.086	-0.074
8:	0.116	0.306
9:	-0.431	0.430
10:	-0.662	0.017



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6535236. 0

TARGET NUMBER: 2

FILE DATE: 09/27/2007

FILE TIME: 05:22

POINT#	X	Y
1:	0.678	-0.802
2:	0.084	-0.696
3:	0.156	-0.372
4:	0.167	0.077
5:	0.506	0.289
6:	0.039	0.534
7:	-0.485	0.568
8:	-0.837	0.254
9:	-0.491	-0.189
10:	-0.867	-0.594

X CENTROID: -0.105

Y CENTROID: -0.093

POA TO CENTROID: 0.140

HORZ SPREAD: 1.545

VERT SPREAD: 1.370

GROUP SPREAD: 1.847

MIN RADIUS: 0.321

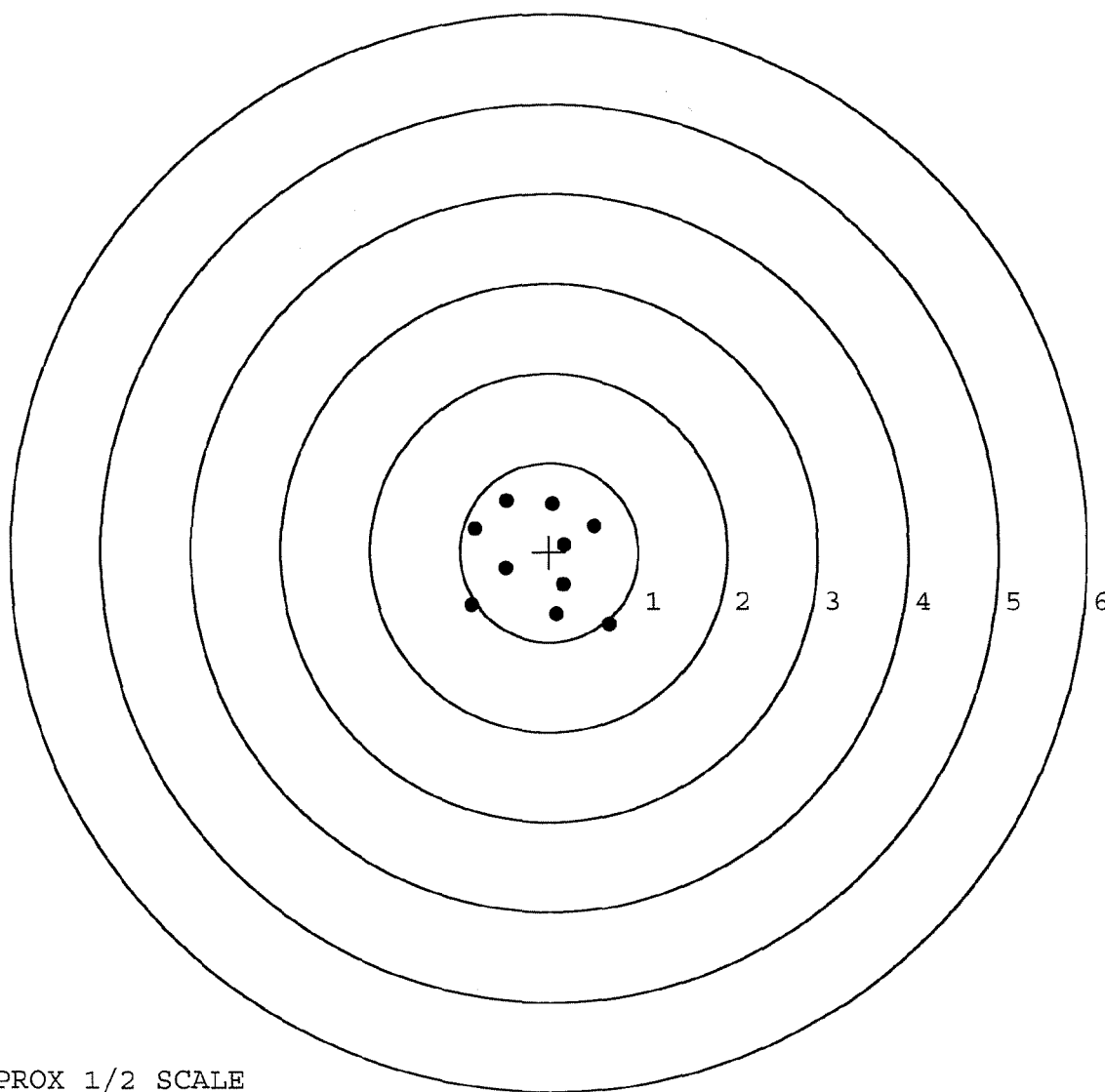
MAX RADIUS: 1.056

MEAN RADIUS: 0.664

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6535236. __0

TARGET NUMBER: 3

FILE DATE: 09/27/2007

FILE TIME: 05:22

POINT#	X	Y
1:	0.583	0.500
2:	0.220	0.680
3:	-0.372	0.622
4:	-0.792	0.587
5:	0.880	-1.265
6:	0.679	-0.950
7:	0.635	-0.460
8:	0.274	-0.423
9:	-0.045	0.003
10:	-0.368	-0.077

X CENTROID: 0.169

Y CENTROID: -0.078

POA TO CENTROID: 0.187

HORZ SPREAD: 1.672

VERT SPREAD: 1.945

GROUP SPREAD: 2.495

MIN RADIUS: 0.229

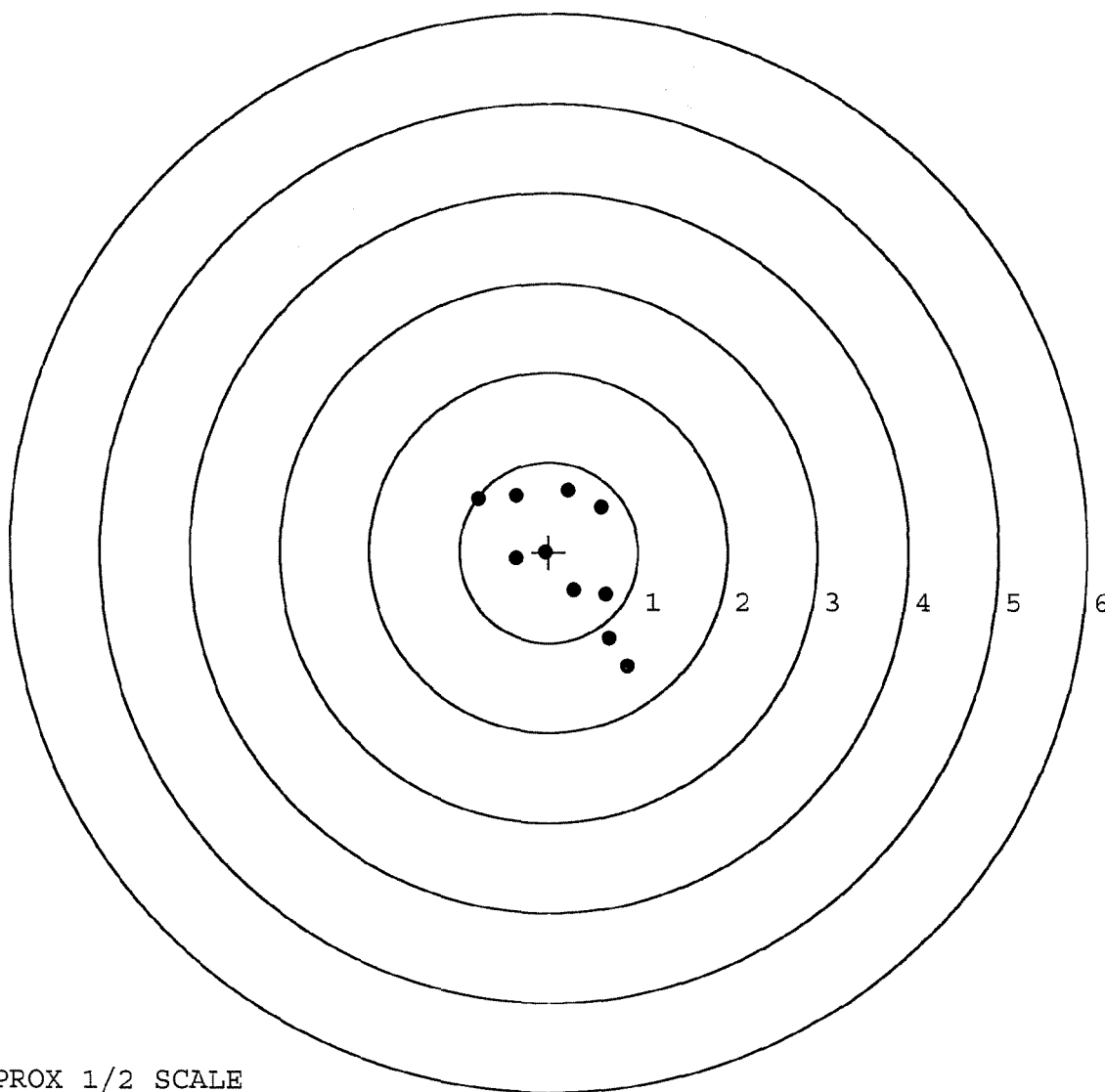
MAX RADIUS: 1.383

MEAN RADIUS: 0.765

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6535236. 0

TARGET NUMBER: 4

FILE DATE: 09/27/2007

FILE TIME: 05:22

X CENTROID: -0.020

Y CENTROID: 0.070

POA TO CENTROID: 0.073

HORZ SPREAD: 1.230

VERT SPREAD: 1.827

GROUP SPREAD: 1.888

MIN RADIUS: 0.169

MAX RADIUS: 0.960

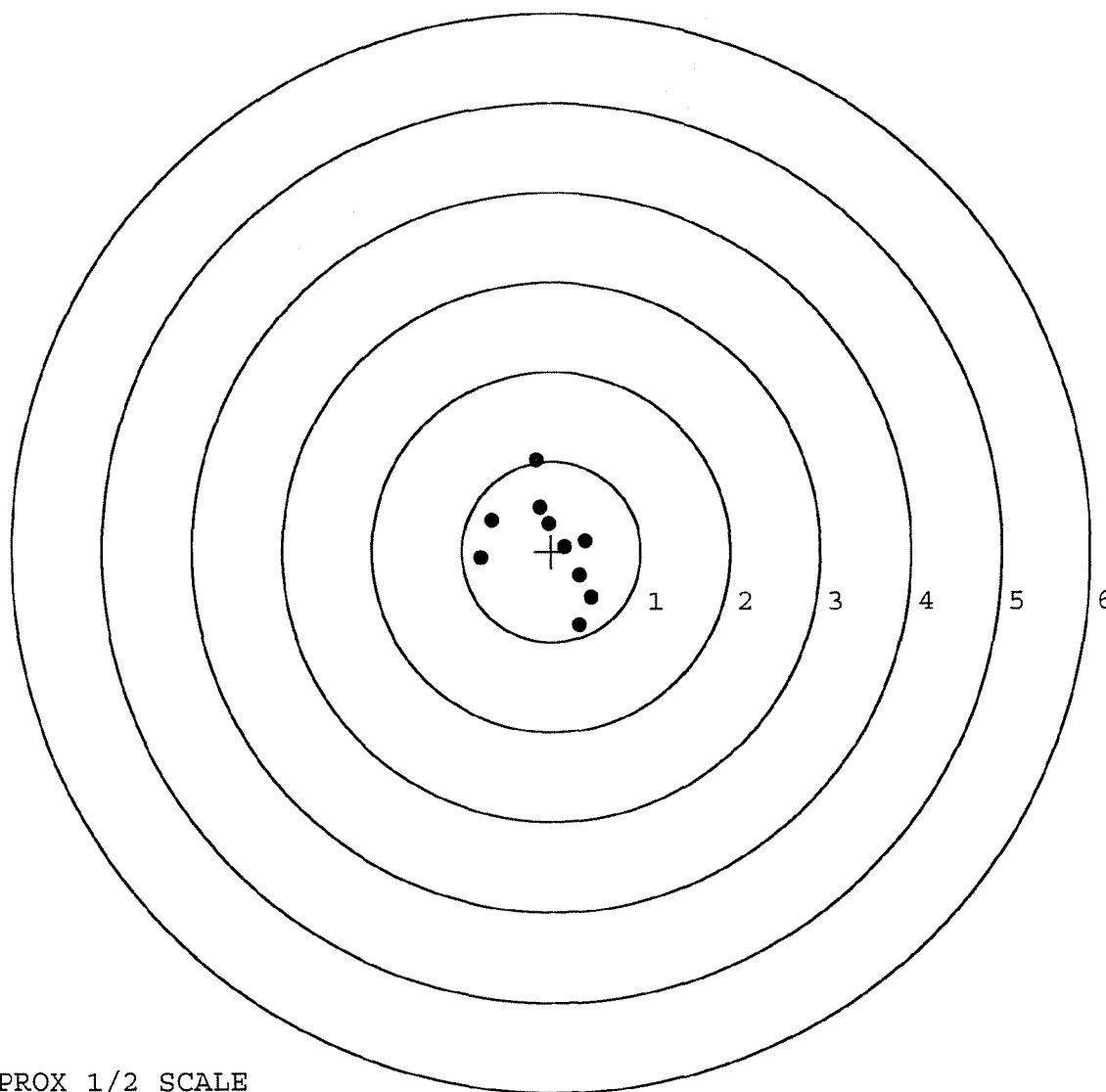
MEAN RADIUS: 0.584

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.309	-0.809
2:	0.443	-0.501
3:	0.314	-0.262
4:	0.381	0.123
5:	0.148	0.048
6:	-0.132	0.492
7:	-0.168	1.018
8:	-0.670	0.349
9:	-0.787	-0.070
10:	-0.038	0.310



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6535236. __0

TARGET NUMBER: 5

FILE DATE: 09/27/2007

FILE TIME: 05:22

POINT#	X	Y
1:	0.105	-0.665
2:	0.435	-0.443
3:	-0.088	-0.305
4:	-0.741	-0.153
5:	-0.613	0.103
6:	-0.934	0.508
7:	-0.390	0.568
8:	0.130	0.376
9:	0.498	0.345
10:	1.327	-0.767

X CENTROID: -0.027

Y CENTROID: -0.043

POA TO CENTROID: 0.051

HORZ SPREAD: 2.261

VERT SPREAD: 1.335

GROUP SPREAD: 2.596

MIN RADIUS: 0.269

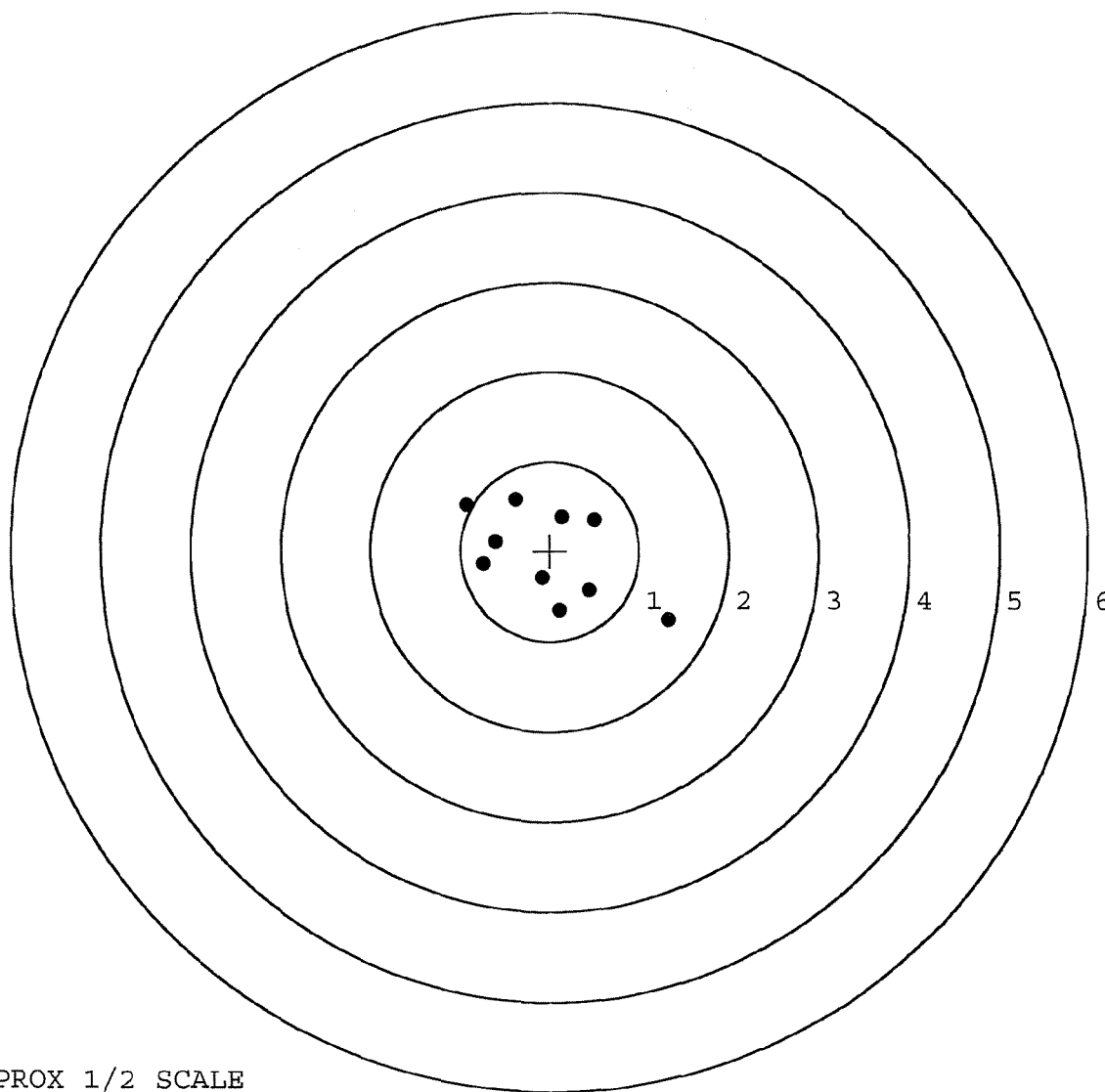
MAX RADIUS: 1.535

MEAN RADIUS: 0.725

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

R & E NUMBER

132645

SERIAL NUMBER

G6535236

LOG-IN DATE

8-14-07

OPERATION #	OPERATION NAME	DATE	INITIAL
500	DIS-ASSEMBLE GUN	9-11-07	RTZ
505	RE-BARREL	9-11-07	RTZ
560	ASSEMBLE	9-11-07	RTZ
600	PROOF	9-12-07	TKW
605	CHECK HEADSPACE	9-12-07	TKW
610	DIS-ASSEMBLE GUN	9-12-07	RTZ
612	MAGNAFLUX	9-13-07	JS
510	DRILL AND TAP	9-12-07	FM
615	ROLLMARK CALIBER	9-12-07	CW
618	ROTO-BLAST	9-12-07	PC
620	APPLY COATINGS	9-14-07	RB
625	FINAL ASSEMBLY	9-19-07	RTZ
640	FUNCTION TEST AND	9-26-07	TKW
650	TARGET	9-26-07	TKW
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
670	FINAL INSPECTION	9-26-07	BWD
	A) HEADSPACE	9-27-07	RTZ
	B) TRIGGER PULL	9-27-07	DA
	F) SAFETY ON FORCE	9-26-07	DA
	G) SAFETY OFF FORCE	9-26-07	DA
	I) FIRING PIN INDENT	9-26-07	DA
690	PACK	9-27-07	DA

MAGNA-FLUX

2007

OPERATOR

JG

PASS

FAIL

PASS

FAIL

CORRECTION

CORRECTION

CORRECTION

CORRECTION

PASS

FAIL

+/- .5 LBS
MIN 2.50 LBS
MAX 4.0 LBS

2.85 2.75 2.86 2.92 2.71 9-26-07

2 LBS MIN
10 LBS MAX

55 62 62 9-26-07

2 LBS
MAX

2.5 2.5 2.5 9-26-07

.023 .024 .024 9-26-07

.023 .024 .024 9-26-07

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6535236.___0
FILE DATE AND TIME: 05/17/2006 16:25

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:	-0.119
The Average Point of Impact of the Five Target Set:	0.142
The Average Mean Radius of the Five Target Set:	0.621
The Distance from POA to Centroid Target #1:	0.166
The Distance from Centroid Target #2 to Centroid Target #1:	0.047
The Distance from Centroid Target #3 to Centroid Target #1:	0.218
The Distance from Centroid Target #4 to Centroid Target #1:	0.342
The Distance from Centroid Target #5 to Centroid Target #1:	0.164

SERIAL NUMBER: G6535236. 0

TARGET NUMBER: 1

FILE DATE: 05/17/2006

FILE TIME: 16:25

X CENTROID: -0.166

Y CENTROID: -0.004

POA TO CENTROID: 0.166

HORZ SPREAD: 1.859

VERT SPREAD: 1.567

GROUP SPREAD: 1.934

MIN RADIUS: 0.290

MAX RADIUS: 1.092

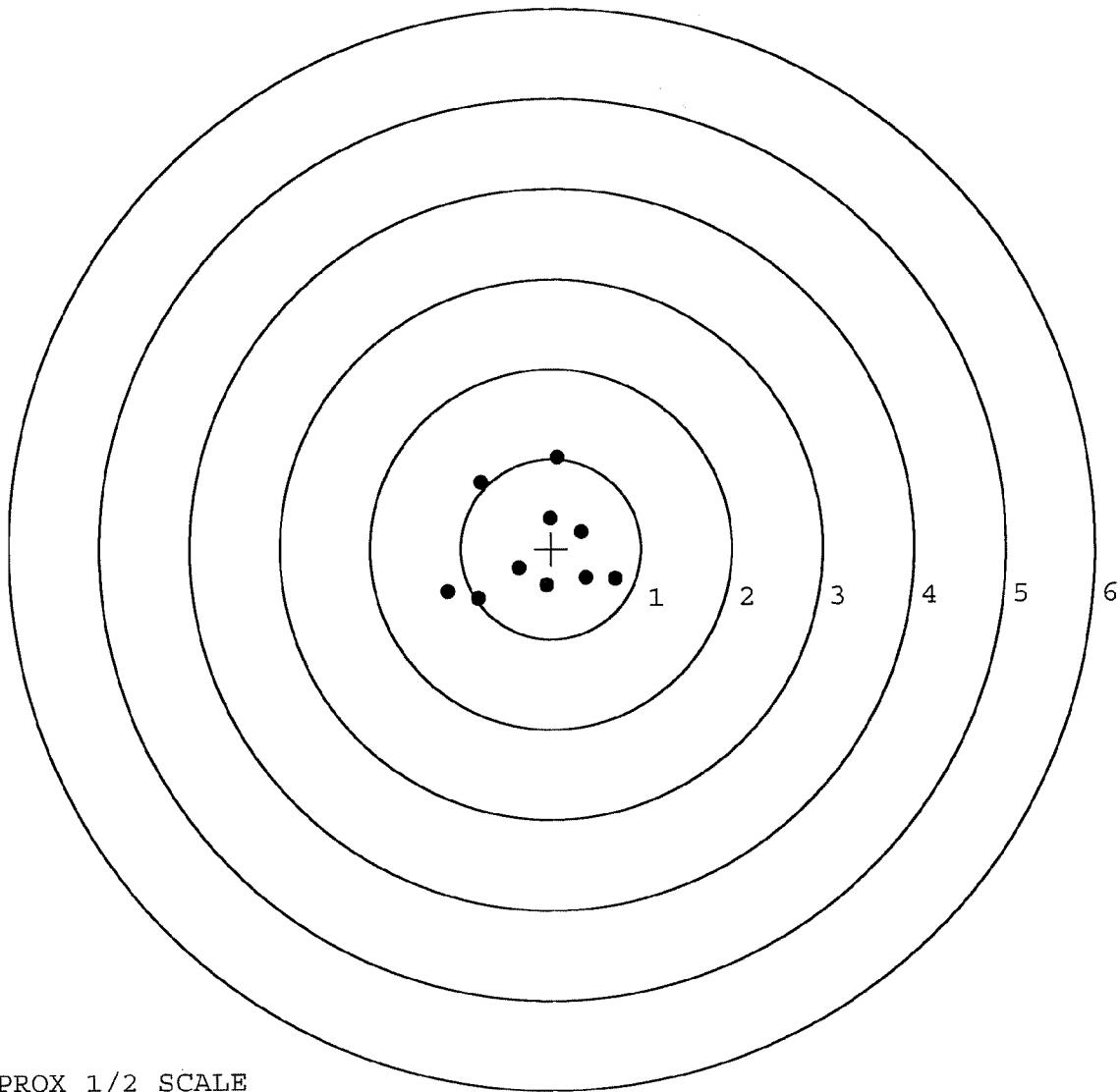
MEAN RADIUS: 0.714

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.768	0.742
2:	0.074	1.019
3:	-0.008	0.335
4:	0.337	0.183
5:	0.709	-0.344
6:	0.382	-0.327
7:	-0.058	-0.412
8:	-0.366	-0.214
9:	-0.813	-0.548
10:	-1.150	-0.478



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6535236. __0

TARGET NUMBER: 2

FILE DATE: 05/17/2006

FILE TIME: 16:25

X CENTROID: -0.143

Y CENTROID: -0.045

POA TO CENTROID: 0.150

HORZ SPREAD: 1.701

VERT SPREAD: 1.943

GROUP SPREAD: 2.253

MIN RADIUS: 0.107

MAX RADIUS: 1.552

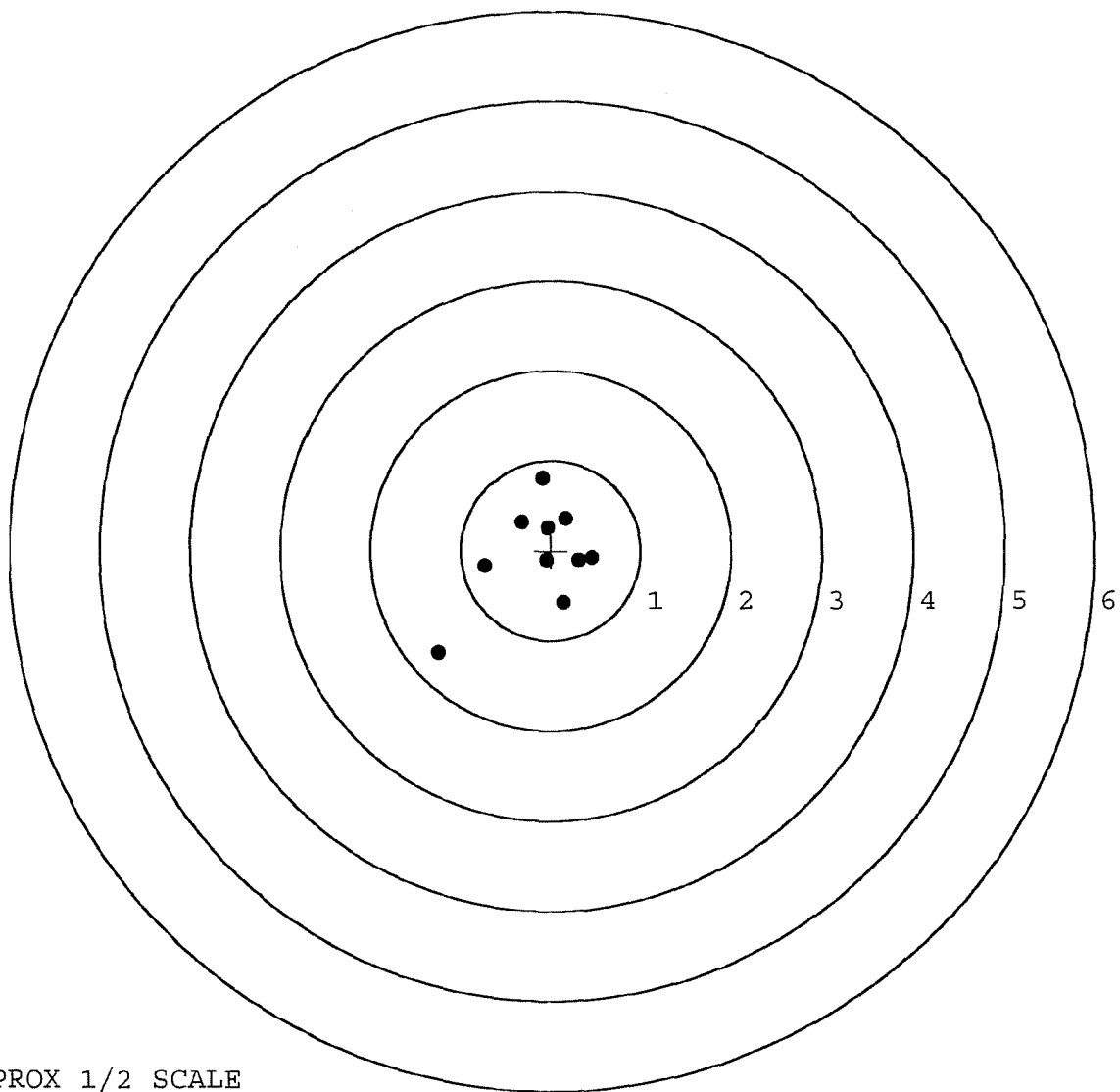
MEAN RADIUS: 0.602

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 9

POINT#	X	Y
1:	-0.101	0.802
2:	-0.332	0.319
3:	-0.043	0.256
4:	0.166	0.358
5:	0.459	-0.078
6:	0.145	-0.584
7:	-0.738	-0.174
8:	-1.242	-1.141
9:	0.309	-0.101
10:	-0.056	-0.107

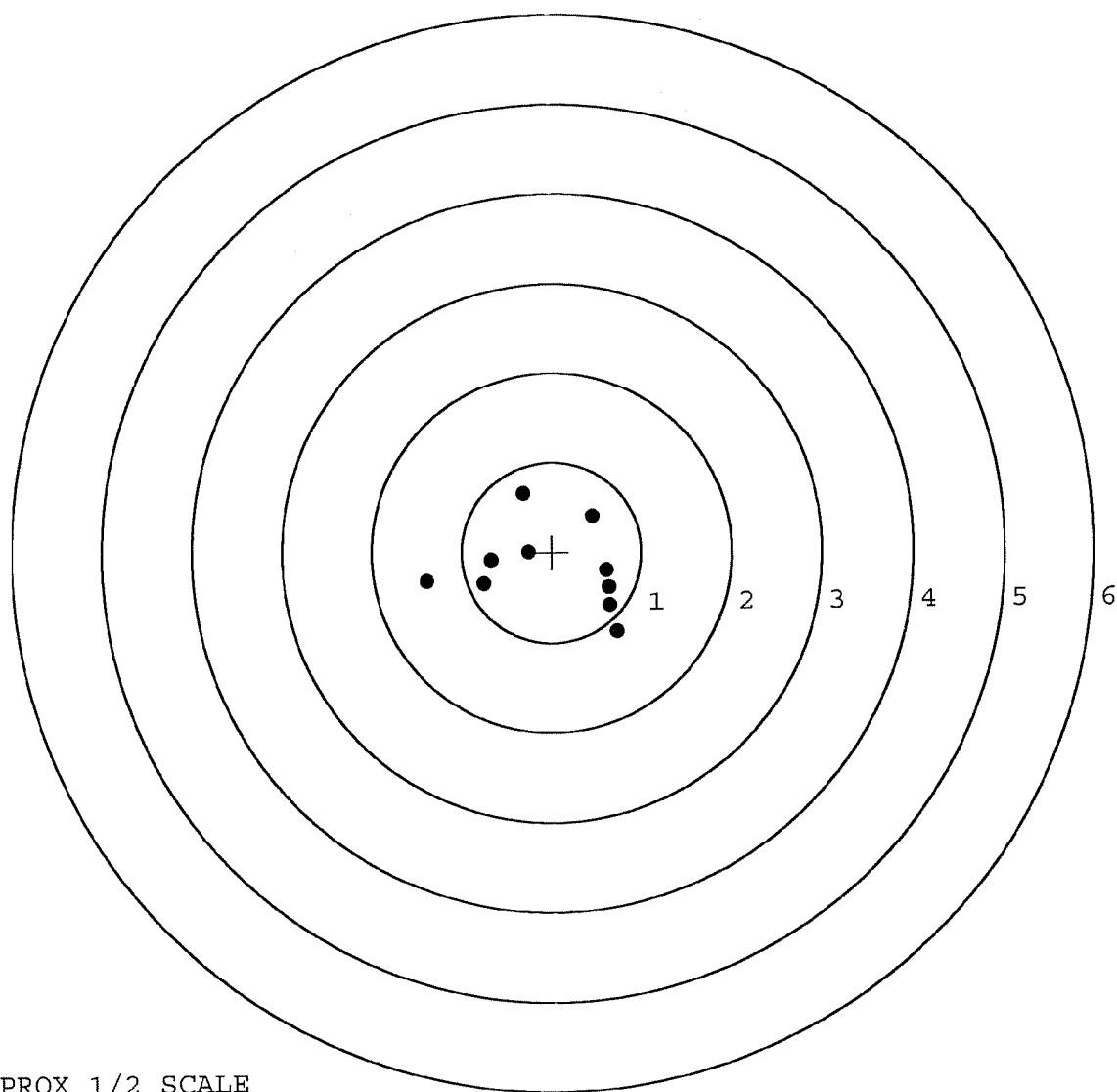


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6535236. __0
 TARGET NUMBER: 3
 FILE DATE: 05/17/2006
 FILE TIME: 16:25

POINT#	X	Y
1:	-0.756	-0.342
2:	-0.676	-0.092
3:	-1.389	-0.319
4:	-0.262	0.002
5:	-0.320	0.650
6:	0.457	0.396
7:	0.610	-0.206
8:	0.639	-0.391
9:	0.644	-0.589
10:	0.720	-0.884

X CENTROID: -0.033
 Y CENTROID: -0.177
 POA TO CENTROID: 0.181
 HORZ SPREAD: 2.109
 VERT SPREAD: 1.534
 GROUP SPREAD: 2.183
 MIN RADIUS: 0.291
 MAX RADIUS: 1.363
 MEAN RADIUS: 0.785
 # IN 1 IN DIAMETER: 1
 # IN 2 IN DIAMETER: 8
 # in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6535236. 0

TARGET NUMBER: 4

FILE DATE: 05/17/2006

FILE TIME: 16:25

X CENTROID: -0.036

Y CENTROID: -0.320

POA TO CENTROID: 0.322

HORZ SPREAD: 1.546

VERT SPREAD: 1.915

GROUP SPREAD: 2.089

MIN RADIUS: 0.211

MAX RADIUS: 1.526

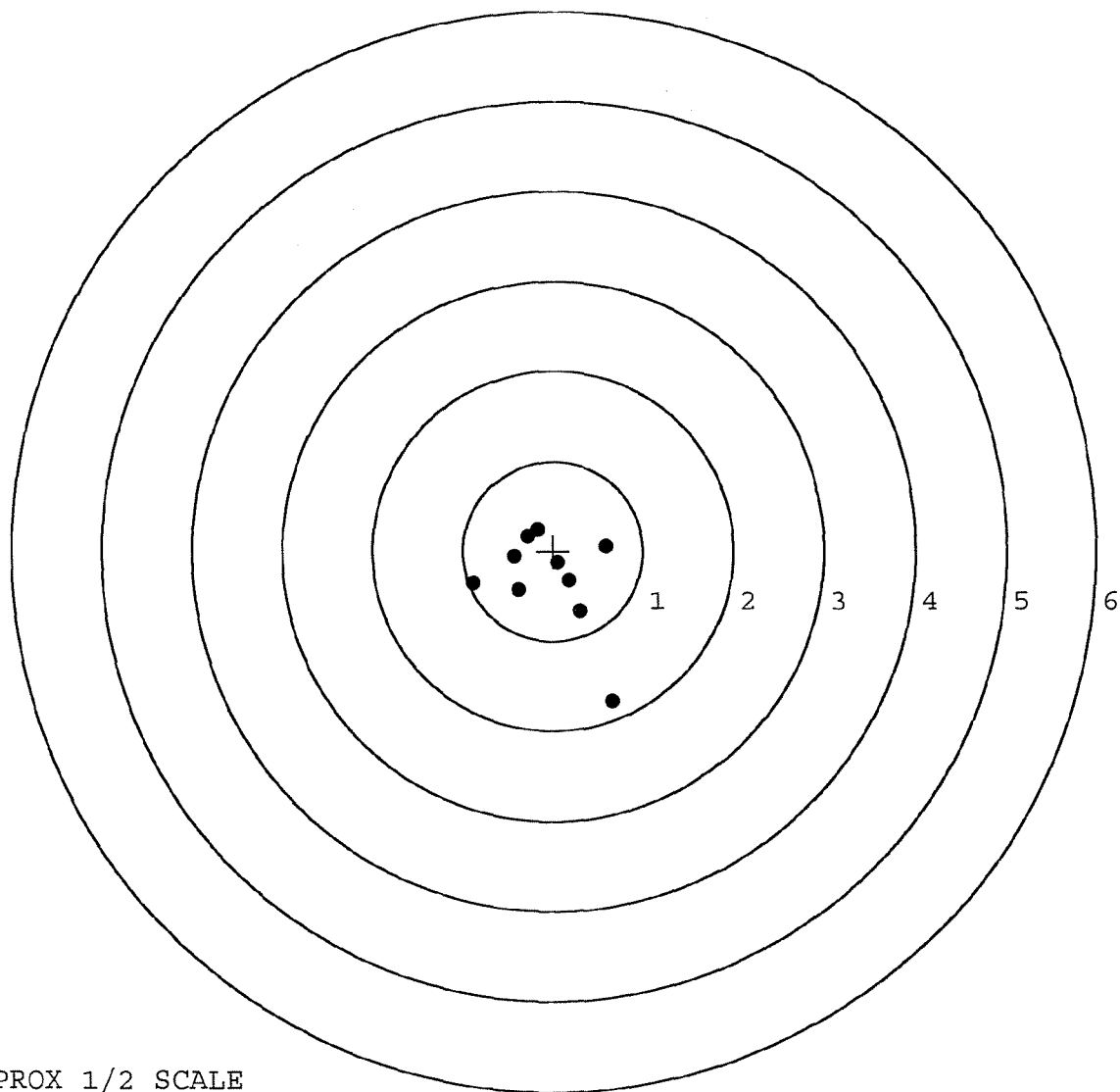
MEAN RADIUS: 0.598

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 9

POINT#	X	Y
1:	-0.170	0.239
2:	-0.281	0.164
3:	-0.436	-0.063
4:	-0.881	-0.360
5:	0.301	-0.673
6:	0.665	-1.676
7:	0.589	0.057
8:	0.053	-0.129
9:	-0.383	-0.436
10:	0.184	-0.327



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6535236. __0

TARGET NUMBER: 5

FILE DATE: 05/17/2006

FILE TIME: 16:25

X CENTROID: -0.008

Y CENTROID: -0.048

POA TO CENTROID: 0.049

HORZ SPREAD: 1.360

VERT SPREAD: 0.950

GROUP SPREAD: 1.364

MIN RADIUS: 0.071

MAX RADIUS: 0.833

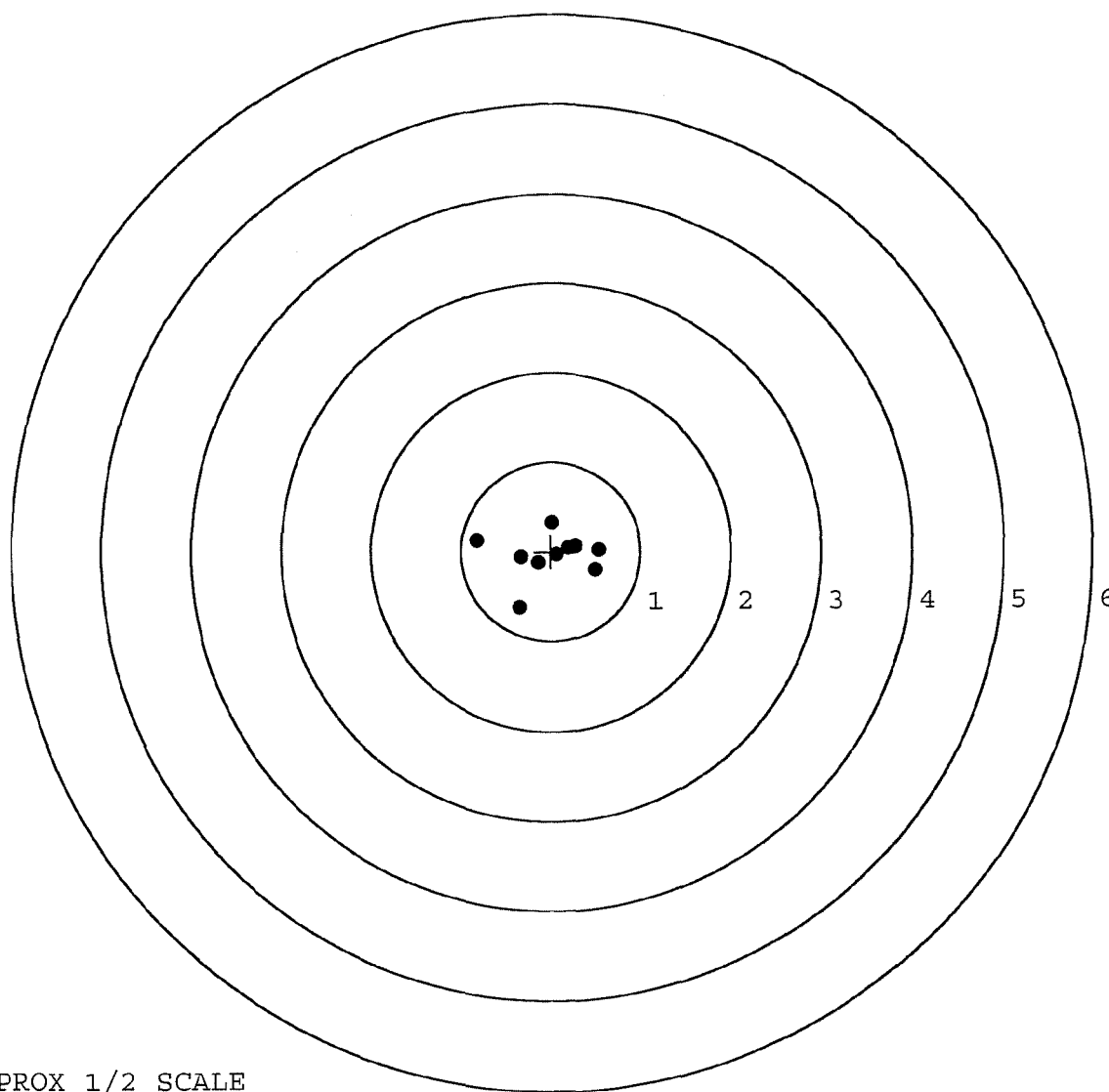
MEAN RADIUS: 0.405

IN 1 IN DIAMETER: 6

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10

POINT#.	X	Y
1:	0.009	0.322
2:	0.195	0.045
3:	0.538	0.020
4:	0.497	-0.201
5:	-0.146	-0.130
6:	-0.339	-0.063
7:	-0.822	0.129
8:	-0.356	-0.628
9:	0.062	-0.039
10:	0.279	0.061



TARGET APPROX 1/2 SCALE

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50 LBS (plus or minus 0.50 LBS)

3.00 LBS (plus or minus 0.75 LBS)

4.00 LBS (plus or minus 1.00 LBS)

DATE 4-24-06

TESTER R.P.

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	254	254		255	
PULL #2	250	254		257	
PULL #3	255	265		260	
PULL #4	257	244		247	
PULL #5	263	247		247	
TOTAL	1279	1264		1266	
AVERAGE	255	252		253	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	313	325		
PULL #2	320	321		
PULL #3	328	318		
PULL #4	319	328		
PULL #5	308	315		
TOTAL	1588	1607		
AVERAGE	317	321		

	4.00 LBS INITIAL	4.00 LBS AFTER 20 CYCLES	MAX SETTING GREATER THAN 4 LBS	RESET TO 4 LBS FOR TARGET & ACCURACY
PULL #1	409	407		406
PULL #2	390	386		399
PULL #3	395	418		411
PULL #4	402	409		414
PULL #5	409	408		400
TOTAL	2005	2028		2030
AVERAGE	401	405		406

M-24 INSPECTION CHECKLIST
CONTRACT #: DAAE-20-02-C-0149

R & E NUMBER	111259			
SERIAL NUMBER	E6413617		G6535236 (NEW)	
LOG-IN DATE	4-19-06			
OPERATION #	OPERATION NAME		DATE	INITIAL
500	DIS-ASSEMBLE GUN		5-2-06	RTZ
505	RE-BARREL		5-3-06	RTZ
560	ASSEMBLE		5-3-06	RTZ
600	PROOF	MAGNA-FLUX	5-3-06	MTM
605	CHECK HEADSPACE	INSPECTED	5-3-06	MTM
610	DIS-ASSEMBLE GUN	MAY 08 2006		
612	MAGNAFLUX	OPERATOR <u>GPD</u>	3-8-06	APM
510	DRILL AND TAP		5-5-06	TRW
615	ROLLMARK CALIBER		5-8-06	CW
618	ROTO-BLAST		5-9-06	LB
620	APPLY COATINGS		5/11/06	TS
625	FINAL ASSEMBLY		5-17-06	RTZ
640	FUNCTION TEST AND	PASS FAIL	5-17-06	MTM
650	TARGET	PASS FAIL	5-17-06	MTM
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
670	FINAL INSPECTION		5-23-06	MTM
	A) HEADSPACE	PASS FAIL	5-23-06	MTM
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	2.82 2.90 2.89 2.71 2.93	K.P.D.
680	F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX	8 lbs. 8 lbs. 8 lbs.	MTM
	G) SAFETY OFF FORCE	2 LBS MIN	4 lbs. 4 lbs. 4 lbs.	MTM
	I) FIRING PIN INDENT	.020	.021 .022 .022	MTM
690	PACK		5-24-06	RTZ