

G6591533

Replaces

C6702858

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: RE00135884

Serial: C6702858 Model M24 SWS Center Fire
Caliber: 7.62 NATO Produced: 10/19/1992

Repairman:

Status:

Closed 10/26/2007 8:26:55 AM

Verify Repair

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

Repair Search

Refresh

Close

nagletj

10/29/2007

10:57 AM

CAPS

NUM

INS

SCRL



G6591533 (New)

Serial Number: C6702858

Model: M24 SWS



RE00135884

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6591533.__0
FILE DATE AND TIME: 12/13/2007 13:50

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.012
The Average Y Centroid of the Five Target Set:	-0.014
The Average Point of Impact of the Five Target Set:	0.019
The Average Mean Radius of the Five Target Set:	0.641
The Distance from POA to Centroid Target #1:	0.037
The Distance from Centroid Target #2 to Centroid Target #1:	0.120
The Distance from Centroid Target #3 to Centroid Target #1:	0.121
The Distance from Centroid Target #4 to Centroid Target #1:	0.107
The Distance from Centroid Target #5 to Centroid Target #1:	0.141

SERIAL NUMBER: G6591533. 0

TARGET NUMBER: 1

FILE DATE: 12/13/2007

FILE TIME: 13:50

POINT#	X	Y
1:	0.452	-0.820
2:	0.743	-0.064
3:	0.429	0.511
4:	0.272	-0.354
5:	0.343	-0.084
6:	-0.023	-0.010
7:	-0.340	0.177
8:	-0.733	-0.126
9:	-0.911	0.047
10:	-0.524	0.948

X CENTROID: -0.029

Y CENTROID: 0.022

POA TO CENTROID: 0.037

HORZ SPREAD: 1.654

VERT SPREAD: 1.768

GROUP SPREAD: 2.020

MIN RADIUS: 0.033

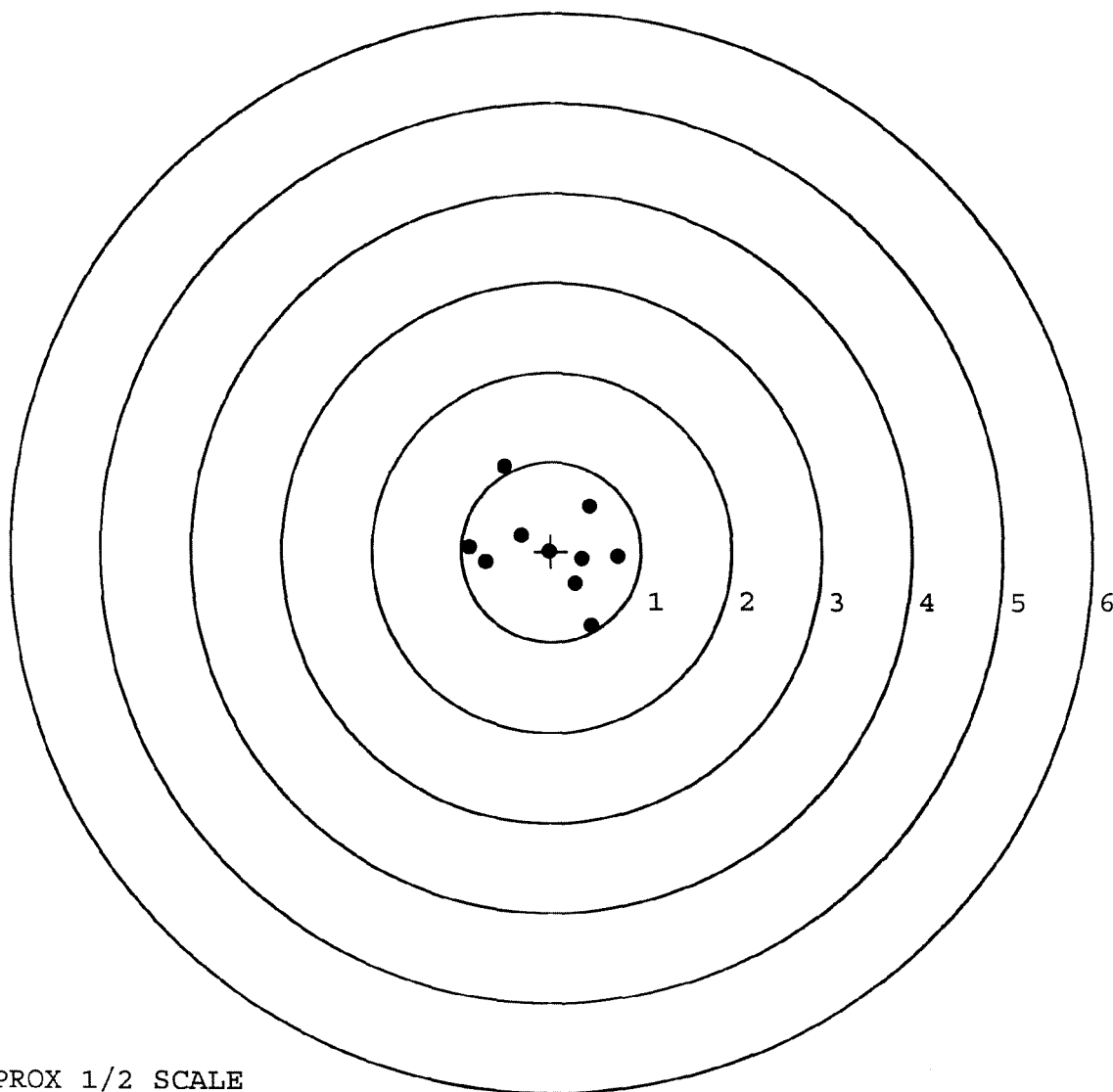
MAX RADIUS: 1.049

MEAN RADIUS: 0.632

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6591533. __0

TARGET NUMBER: 2

FILE DATE: 12/13/2007

FILE TIME: 13:50

POINT#	X	Y
1:	0.606	-0.757
2:	0.463	-0.349
3:	0.645	0.398
4:	0.127	0.260
5:	0.156	1.193
6:	-0.495	0.597
7:	-0.140	-0.057
8:	-0.467	-0.047
9:	-0.025	-0.562
10:	-0.025	-0.838

X CENTROID: 0.084

Y CENTROID: -0.016

POA TO CENTROID: 0.086

HORZ SPREAD: 1.140

VERT SPREAD: 2.031

GROUP SPREAD: 2.039

MIN RADIUS: 0.228

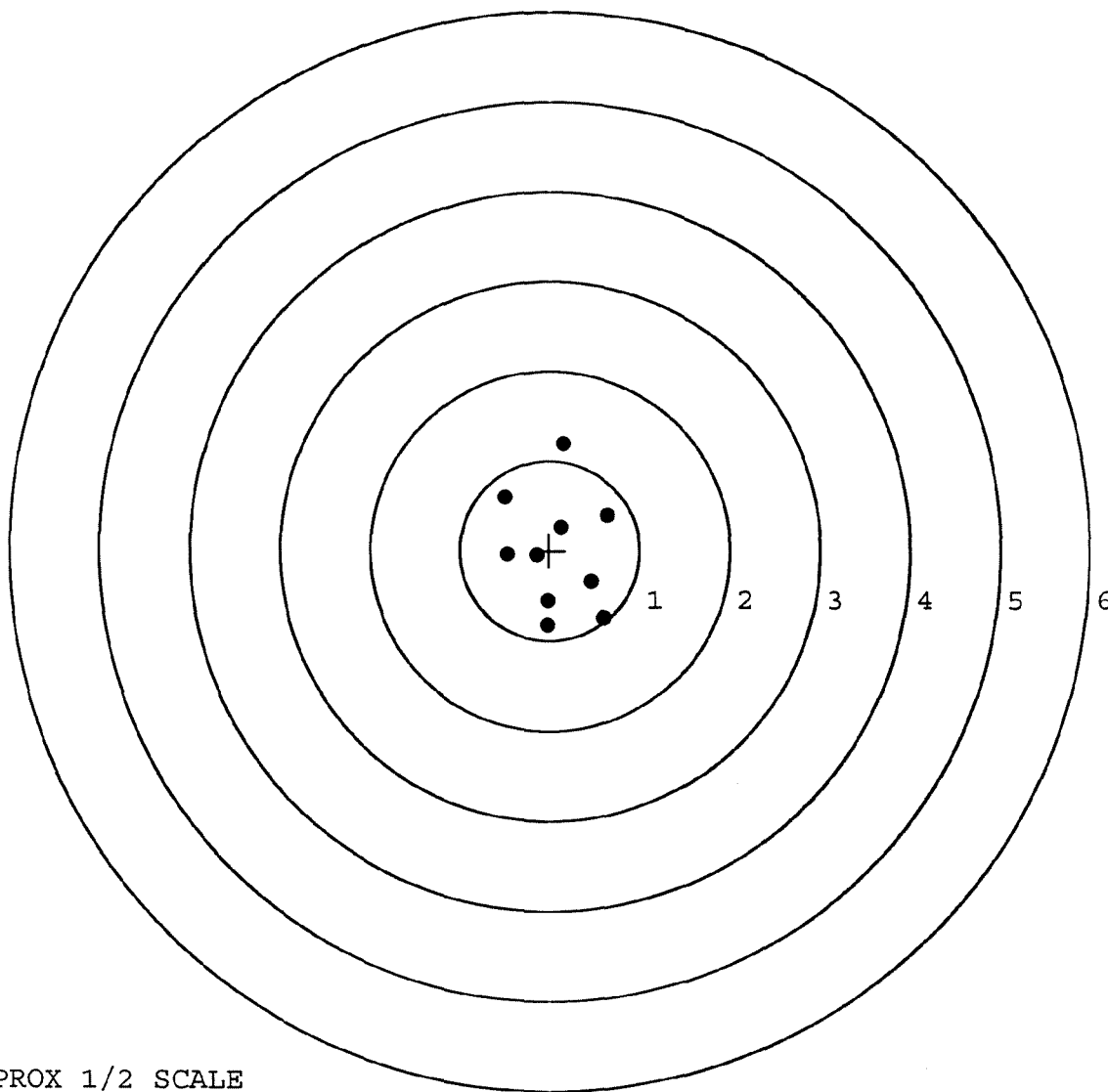
MAX RADIUS: 1.211

MEAN RADIUS: 0.661

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6591533. __0

TARGET NUMBER: 3

FILE DATE: 12/13/2007

FILE TIME: 13:50

POINT#	X	Y
1:	0.520	-0.841
2:	0.888	-0.473
3:	0.327	-0.213
4:	0.416	0.539
5:	-0.683	0.922
6:	-0.619	-0.375
7:	-0.245	-0.338
8:	-0.025	0.013
9:	-0.287	0.022
10:	-0.141	-0.153

X CENTROID: 0.015

Y CENTROID: -0.090

POA TO CENTROID: 0.091

HORZ SPREAD: 1.571

VERT SPREAD: 1.763

GROUP SPREAD: 2.134

MIN RADIUS: 0.110

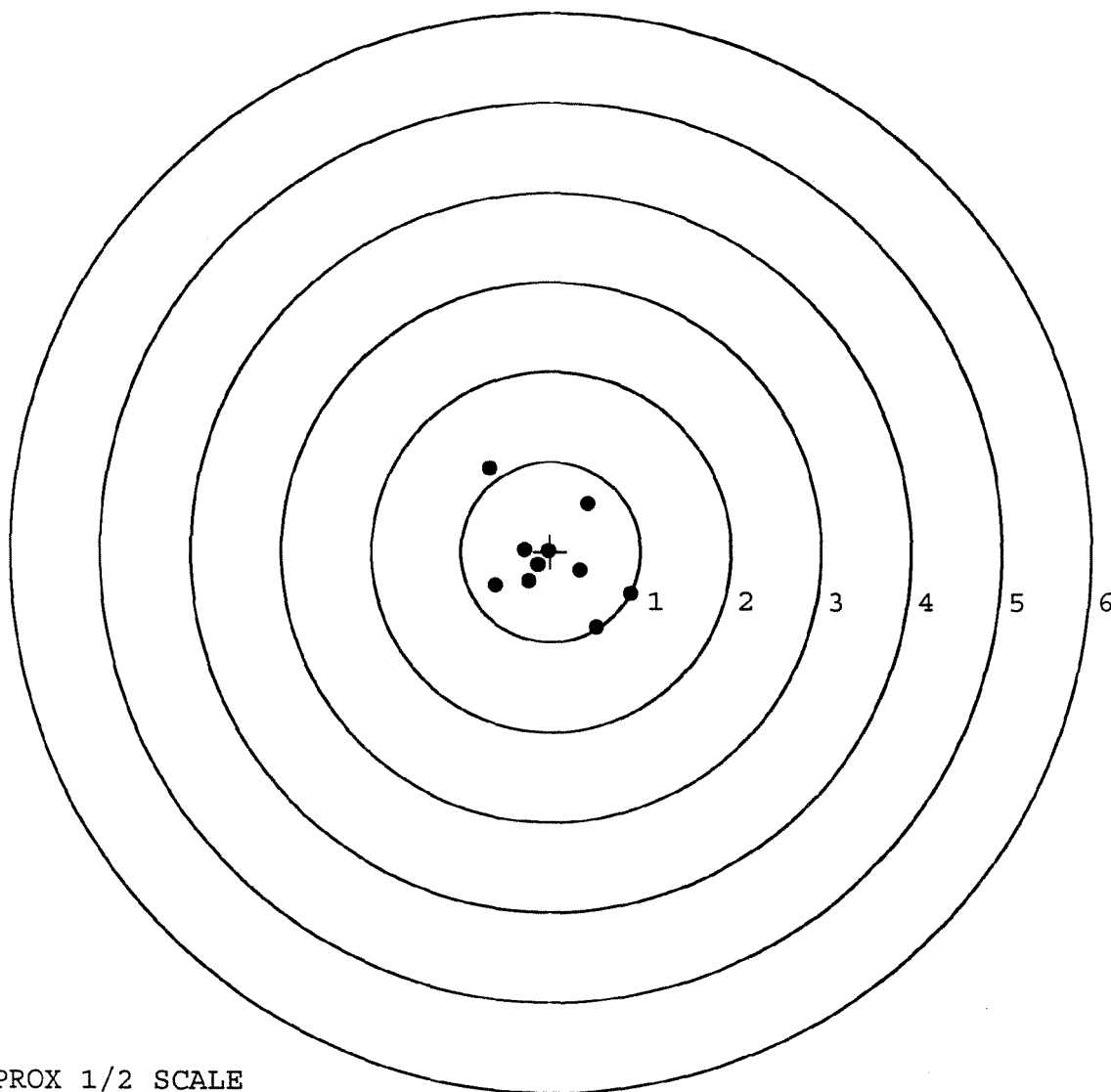
MAX RADIUS: 1.229

MEAN RADIUS: 0.582

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10

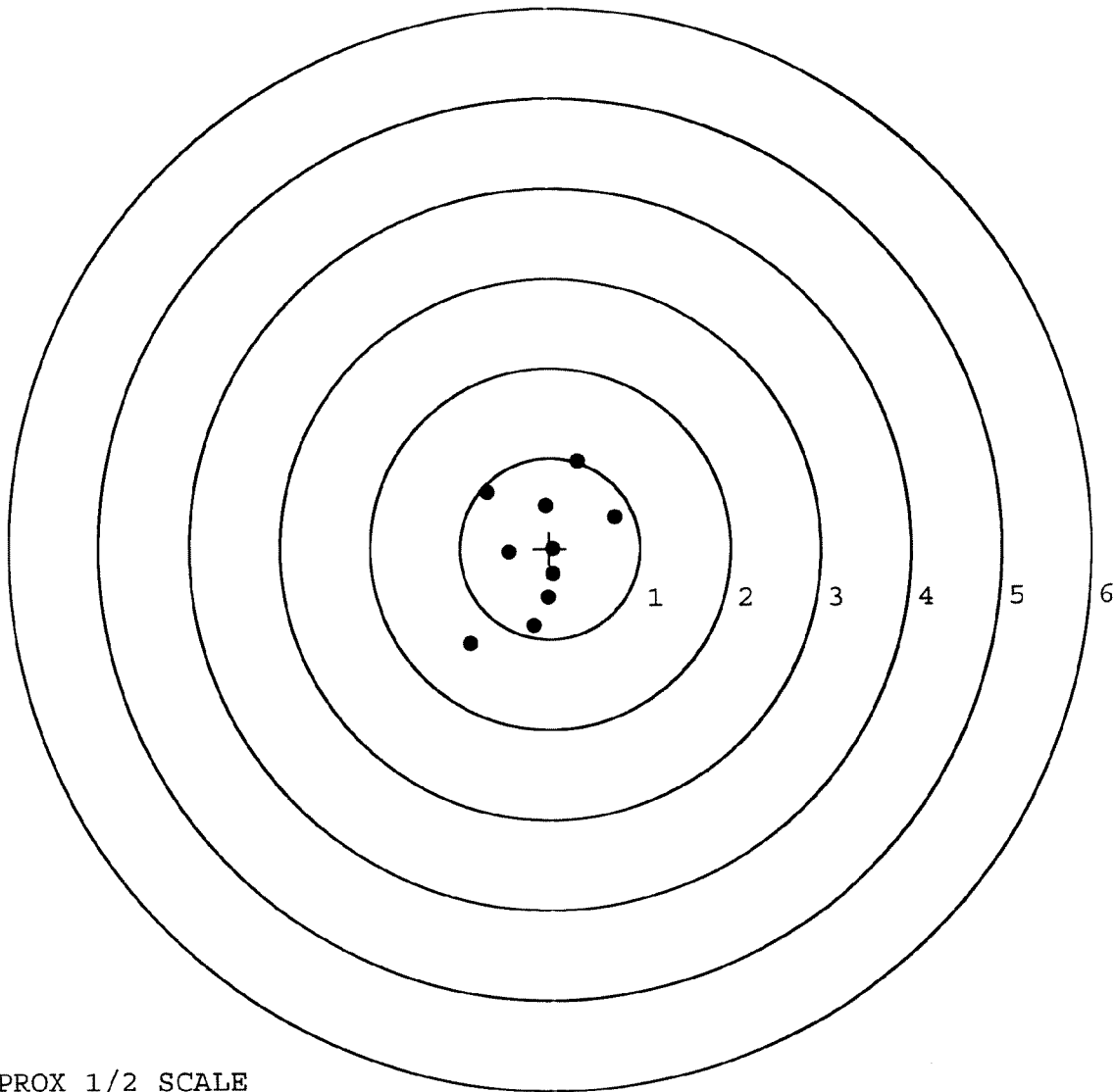


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6591533. __0
 TARGET NUMBER: 4
 FILE DATE: 12/13/2007
 FILE TIME: 13:50

X CENTROID: -0.118
 Y CENTROID: -0.038
 POA TO CENTROID: 0.124
 HORZ SPREAD: 1.616
 VERT SPREAD: 2.010
 GROUP SPREAD: 2.344
 MIN RADIUS: 0.155
 MAX RADIUS: 1.271
 MEAN RADIUS: 0.680
 # IN 1 IN DIAMETER: 3
 # IN 2 IN DIAMETER: 8
 # in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.316	0.963
2:	0.726	0.346
3:	-0.045	0.469
4:	-0.691	0.624
5:	-0.458	-0.041
6:	-0.890	-1.047
7:	0.034	-0.007
8:	0.034	-0.289
9:	-0.023	-0.544
10:	-0.182	-0.854



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6591533. __0

TARGET NUMBER: 5

FILE DATE: 12/13/2007

FILE TIME: 13:50

POINT#	X	Y
1:	0.688	-0.658
2:	0.450	-0.484
3:	-0.242	-0.957
4:	0.026	-0.203
5:	-0.452	-0.237
6:	0.304	0.888
7:	0.382	0.639
8:	-0.056	0.613
9:	-0.180	0.334
10:	0.176	0.556

X CENTROID: 0.110

Y CENTROID: 0.049

POA TO CENTROID: 0.120

HORZ SPREAD: 1.140

VERT SPREAD: 1.845

GROUP SPREAD: 1.924

MIN RADIUS: 0.266

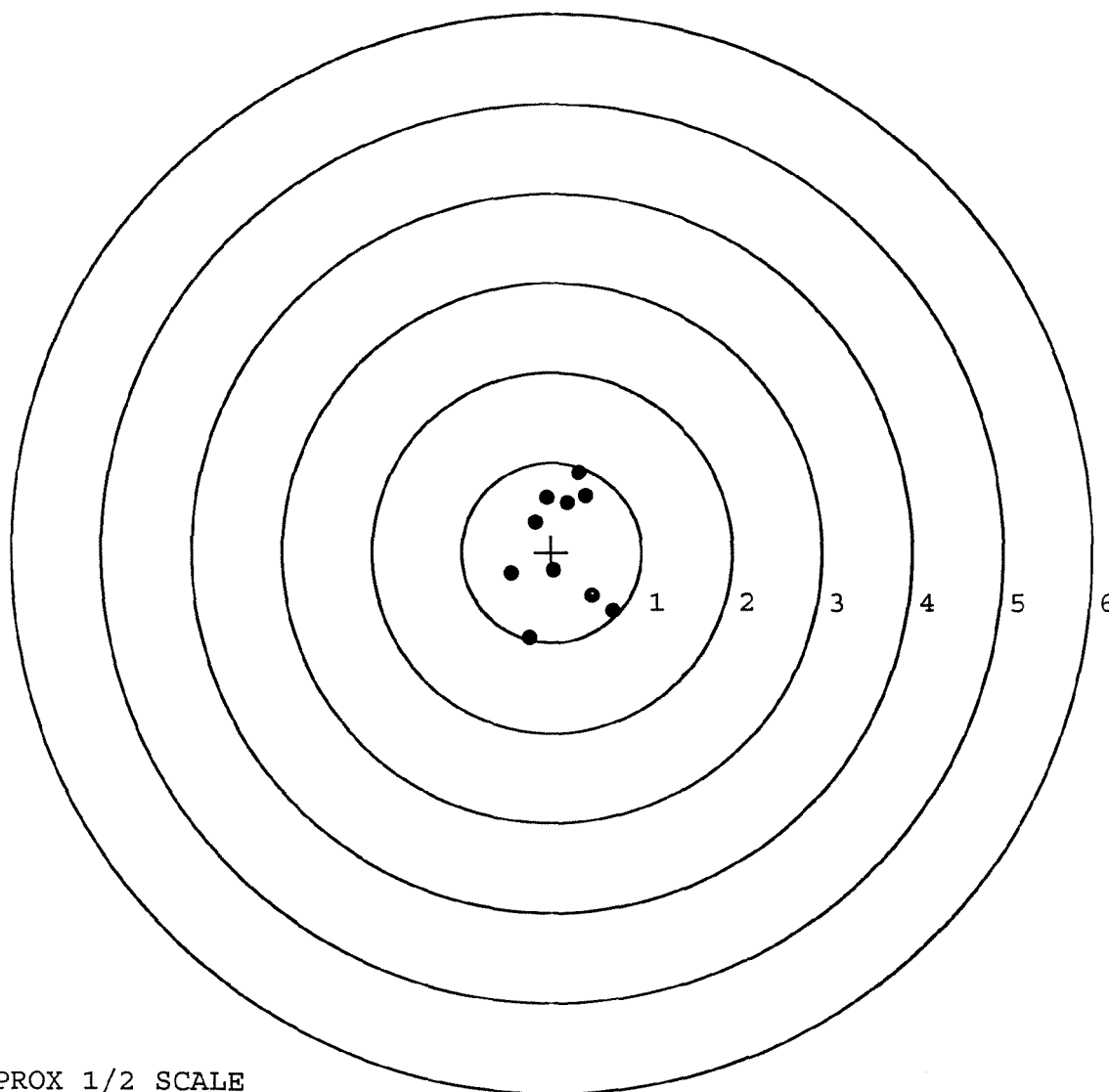
MAX RADIUS: 1.066

MEAN RADIUS: 0.652

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

no

R & E NUMBER	135884			
SERIAL NUMBER	C6202858 C66591533 (new)			
LOG-IN DATE	10-26-07			
OPERATION #	OPERATION NAME		DATE	INITIAL
500	DIS-ASSEMBLE GUN		11-20-07	RTZ
505	RE-BARREL		11-27-07	RPD
560	ASSEMBLE		11-27-07	RPD
600	PROOF	MAGNA - FLUX	11-27-07	RPD
605	CHECK HEADSPACE	DEC 04 2007	11-27-07	TRW
610	DIS-ASSEMBLE GUN			
612	MAGNAFLUX	OPERATOR JB	12-04-07	JB
510	DRILL AND TAP		12-3-07	TRW
615	ROLLMARK CALIBER		12-3-07	CW
618	ROTO-BLAST		12-5-07	YU
620	APPLY COATINGS	12/8/07	12-8-07	ACM
625	FINAL ASSEMBLY		12-12-07	RTZ
640	FUNCTION TEST AND	PASS FAIL	12-13-07	TRW
650	TARGET	PASS FAIL	12-13-07	TRW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION	12-13-07	FM
670	FINAL INSPECTION		12-14-07	RA
	A) HEADSPACE	PASS FAIL	12-14-07	RA
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	2.95 2.94 2.63 2.80 2.58 12-14-07	RA
680	F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX	4.5 4.5 5.0 12-14-07	RA
	G) SAFETY OFF FORCE	2 LBS MIN	3.0 3.0 2.5 12-14-07	RA
	I) FIRING PIN INDENT	.020	1024 .0235 .024 12-14-07	RA
690	PACK		12-13-08	FM

GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C 6702858

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		5/1/92	Rw
600	Proof		5/1/92	Rw
607	Check Headspace		5/1/92	Rw
610	Dis-assemble Gun		5/1/92	Rw
612	Magnaflux Barrel Action	MAY	5 1992	Kck
	Magnaflux Bolt	MAY	5 1992	Kck
615	Rollmark Caliber	MAY	5 1992	CS
617	Drill and Tap Sight Holes	MAY	5 1992	LB
618	Polish Barrel	MAY	5 1992	WB
620	Apply Coatings (Barrel Action)		6-10-92	AA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		6/13/92	Rw
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		6/13/92	Rw
	C) Inspect Ejector Hole for Chamfer		6/13/92	Rw
	D) Oil Firing Pin Ass'y		6/13/92	Rw
	E) Adjust Trigger Pull to Min Setting and Stake		6/15/92	Rw

op. #	BARBER - M24 0167525	READINGS					DATE	INIT
	OP. NAME							
625 cont.	F) Safety On Force	4	4	4			6/15/92	RW
	G) Safety Off Force	3	3	3			6/15/92	RW
	H) Trigger Pull Test & Retainability						6/15/92	RW
	I) Firing Pin Indent	.0215	.023	.021			6/15/92	RW
	J) Assemble Stock						6/16/92	RW
	K) Assemble Swivel Studs							
	L) Attach Front and Rear Sight Assemblies							
	M) Iron Sight Alignment							
	N) Detach Front & Rear Sights & place in numbered container							
	O) Attach Scope to Rifle						6/16/92	RW
	P) Detach & Attach Scope 20 Times						6/16/92	RW
640	Gallery Target & Test						6-25-92	DH
	A) Time						6-25-92	DH
	B) Malfunctions						6-25-92	DH
	C) Pierced Primers						6-25-92	DH
	D) Optical Clarity of Scope						6-25-92	DH
645	Inspect for Live Ammo						6-25-92	DH
655	Final Inspection							
	A) Headspace						6/25/92	RW
	B) Trigger Pull	224	231	214	229	235	6-25-92	DH
	C) Function						6/25/92	RW
660	Pack							

SWS TRIGGER PULL TESTAVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6702858DATE 6/15/92TESTER RW

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.49	2.27	2.29	2.24	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.25	2.31	2.28	2.31	
PULL #3	2.40	2.25	2.31	2.14	
PULL #4	2.39	2.26	2.33	2.29	
PULL #5	2.46	2.23	2.17	2.35	
TOTAL	11.99	11.32	11.38		
AVG.	2.40	2.26	2.28		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.14	3.05		
PULL #2	3.10	3.01		
PULL #3	3.04	3.00		
PULL #4	3.08	3.17		
PULL #5	3.07	3.21		
TOTAL	15.43	15.44		
AVG.	3.09	3.09		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.08	4.04		4.09
PULL #2	4.16	4.04		4.20
PULL #3	4.13	4.35		4.13
PULL #4	4.04	4.17		4.08
PULL #5	4.11	4.10		4.15
TOTAL	20.52	20.70		20.65
AVG.	4.10	4.14		4.13

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6702858
25 Jun 1992

CENTROIDAL DISTANCES

0 TO	1	.0992975
1 TO	2	.304869
1 TO	3	.130698
1 TO	4	.211073
1 TO	5	.124531

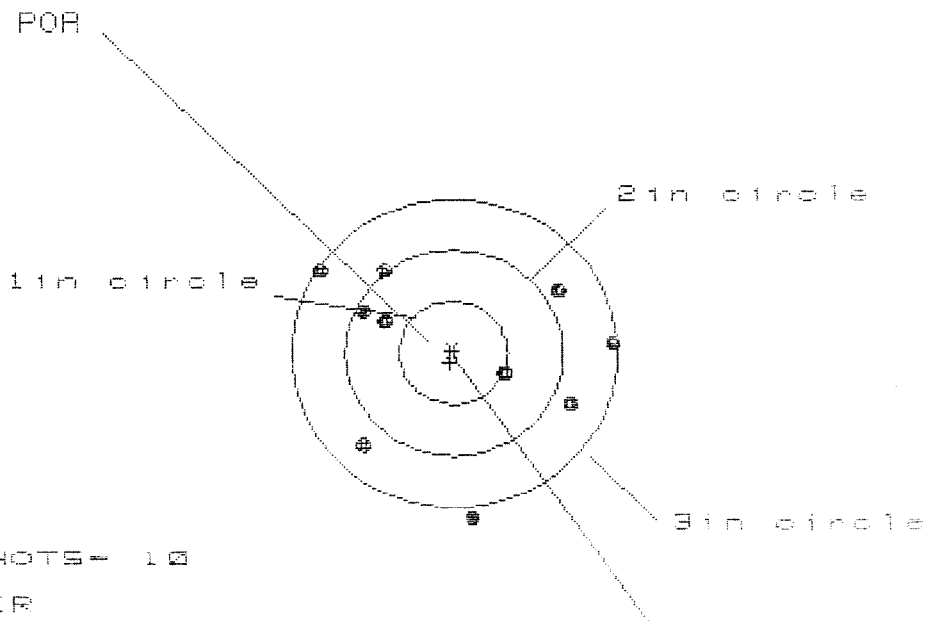
$\frac{3}{4}$ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0732
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0738
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .103948
THE AMP FOR THIS RIFLE IS: 1.046

25 Jun 1992

FILE:/PATTERNING/CENTERFIRE_PATT/C6702858

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 1

2in = 4

3in = 5

HS= 2.744

VS= 2.392

GS= 2.827

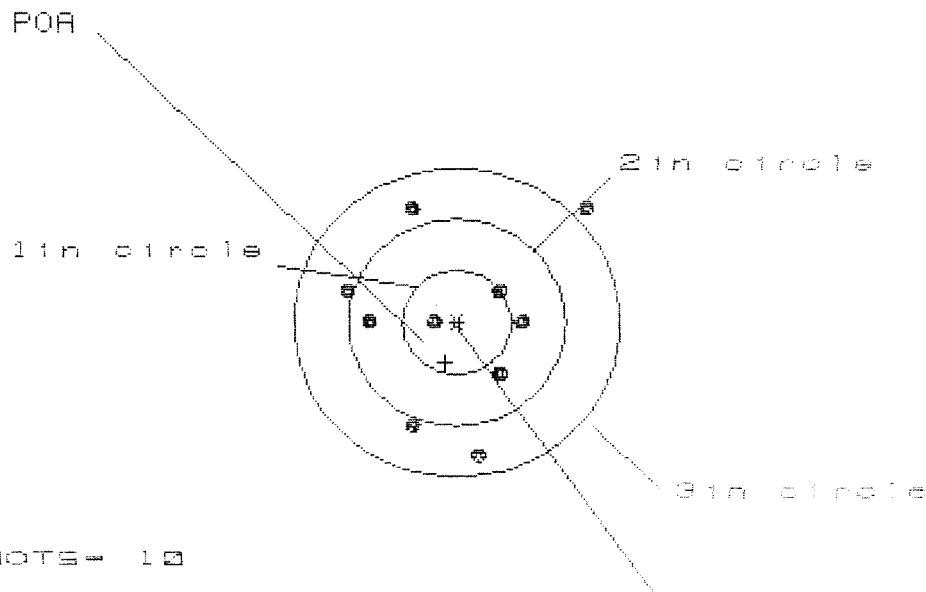
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.505	1.525	1.297
MINIMUM X	-1.239	-1.219	-1.029
MAXIMUM Y	.814	.638	.633
MINIMUM Y	-1.579	-1.076	-1.081
CENTROID X	.032	.012	-.178
CENTROID Y	.094	.270	.275
POR TO CENTROID IN.	.100	.270	.328
MIN RADIUS	.455	.554	.423
MEAN RADIUS	1.117	1.046	.956
MAX RADIUS	1.589	1.525	1.448
HORIZONTAL SPREAD	2.744	2.744	2.326
VERTICAL SPREAD	2.392	1.714	1.714
EXTREME SPREAD	2.827	2.827	2.653
NUMBER IN ONE INCH CIRCLE	= 1		
NUMBER IN TWO INCH CIRCLE	= 4		
NUMBER IN THREE INCH CIRCLE	= 5		

25 Jun 1992

FILE:/PATTERNING/CENTERFIRE_PATT/C6702050

CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1in = 1

2in = 5

3in = 9

HSE = 2.200

VSE = 2.398

OSE = 2.582

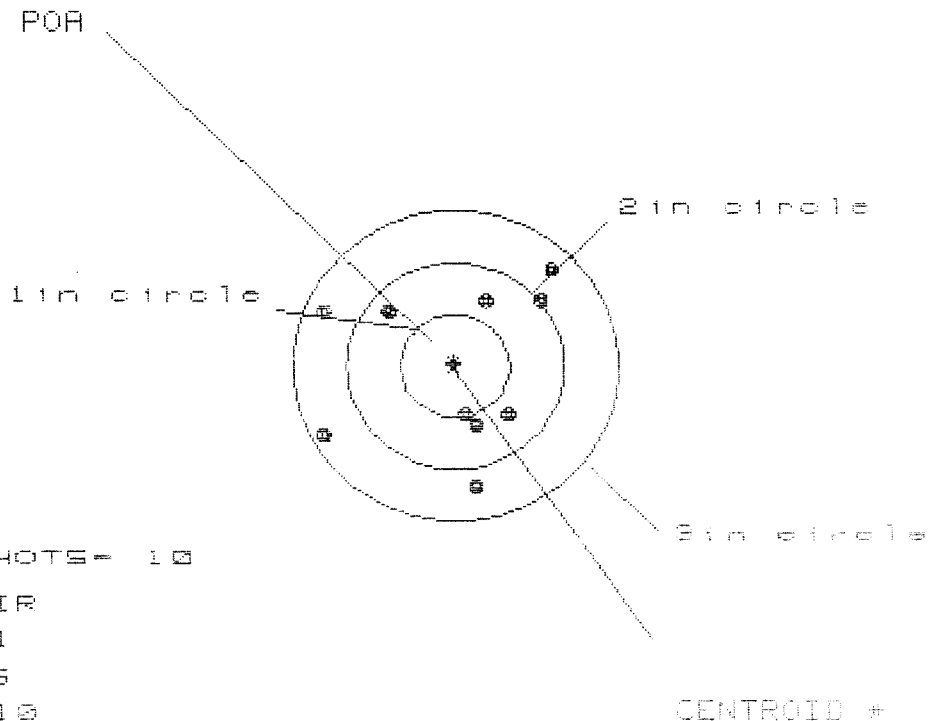
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.177	.741	.787
MINIMUM X	-1.023	-.992	-.846
MAXIMUM Y	1.155	1.273	1.132
MINIMUM Y	-1.243	-1.125	-1.038
CENTROID X	.105	-.026	-.072
CENTROID Y	.390	.272	.413
POA TO CENTROID in.	.484	.274	.419
MIN RADIUS	.193	.163	.017
MEAN RADIUS	.899	.813	.746
MAX RADIUS	1.584	1.307	1.159
HORIZONTAL SPREAD	2.200	1.633	1.633
VERTICAL SPREAD	2.398	2.398	2.170
EXTREME SPREAD	2.582	2.488	2.171
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	9		

25 Jun 1992

FILE:/PATTERNING/CENTERFIRE_PATT/C6702858

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1in = 1

2in = 6

3in = 10

HS= 2.085

VS= 2.031

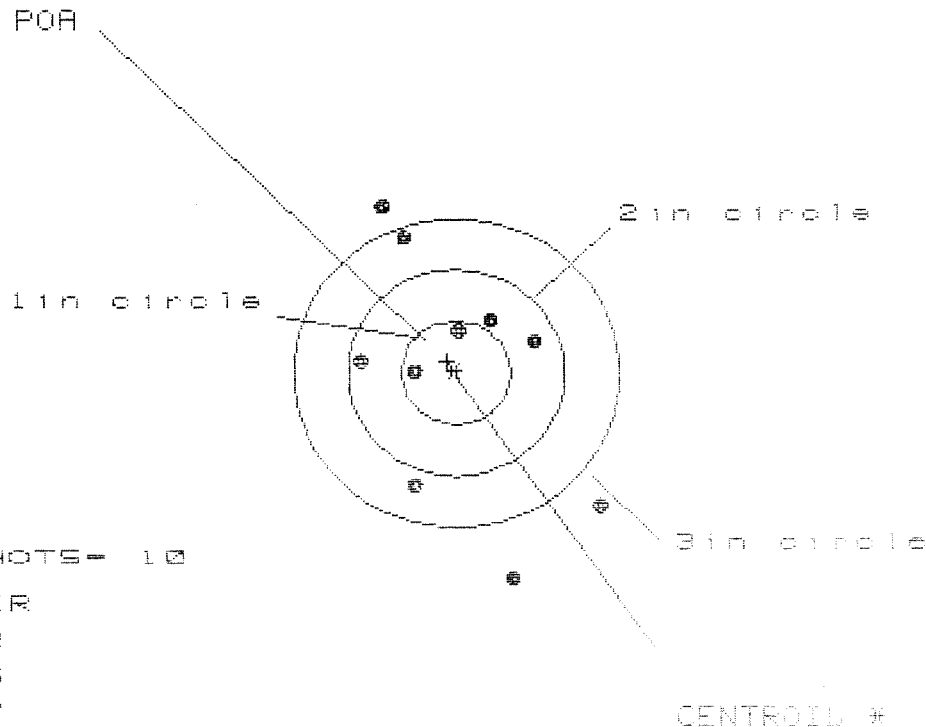
GS= 2.556

PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	.884
MINIMUM X	-1.201
MAXIMUM Y	.892
MINIMUM Y	-1.139
CENTROID X	.011
CENTROID Y	-.035
POR TO CENTROID in.	.037
MIN RADIUS	.451
MEAN RADIUS	.930
MAX RADIUS	1.339
HORIZONTAL SPREAD	2.085
VERTICAL SPREAD	2.031
EXTREME SPREAD	2.556
NUMBER IN ONE INCH CIRCLE	1
NUMBER IN TWO INCH CIRCLE	6
NUMBER IN THREE INCH CIRCLE	10

25 Jun 1932

FILE:/PATTERNING/CENTERFIRE_PATT/C6702858

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 5

3 in = 7

HS= 2.205

VS= 3.579

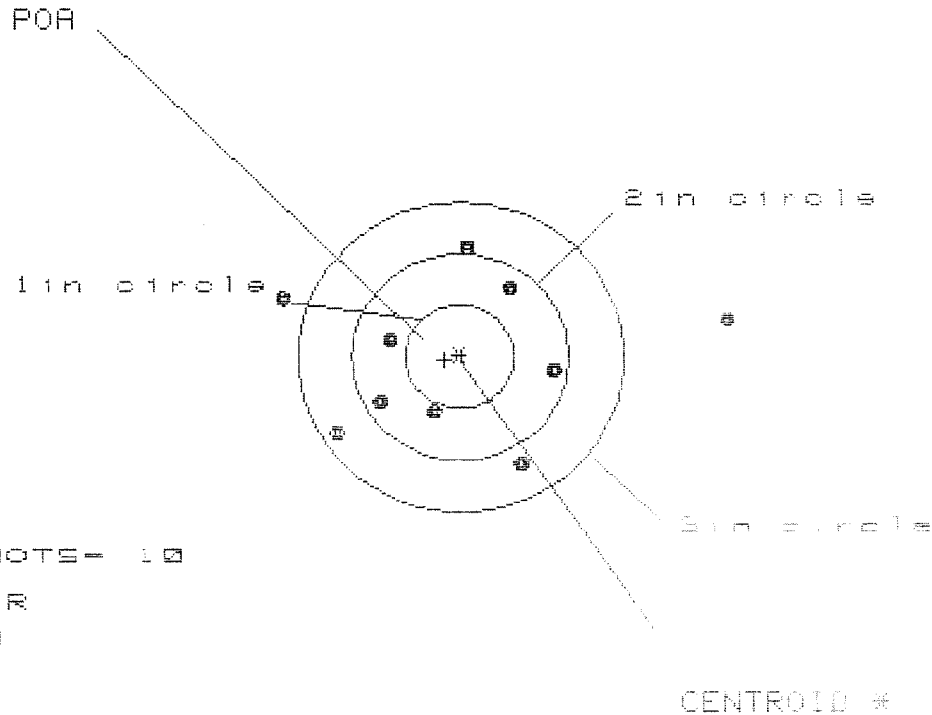
GS= 3.773

PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.296	1.350	.896
MINIMUM X	-.909	-.655	-.687
MAXIMUM Y	1.635	1.419	1.235
MINIMUM Y	-1.944	-1.475	-1.495
CENTROID X	.078	.024	-.144
CENTROID Y	-.112	.104	.298
POA TO CENTROID IN.	.137	.106	.322
MIN RADIUS	.379	.179	.244
MEAN RADIUS	1.122	.976	.837
MAX RADIUS	2.003	1.999	1.500
HORIZONTAL SPREAD	2.205	2.205	1.583
VERTICAL SPREAD	3.579	2.894	2.730
EXTREME SPREAD	3.773	3.522	2.755
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		7	

25 Jun 1992

FILE:/PATTERNING/CENTERFIRE_PATT/CB702858

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 0

2in = 5

3in = 0

HS= 4.185

VS= 2.159

GS= 4.187

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	2.563	1.138	.962
MINIMUM X	-1.682	-1.403	-1.004
MAXIMUM Y	1.164	1.146	1.217
MINIMUM Y	-1.055	-1.013	-.942
CENTROID X	.140	-.139	.037
CENTROID Y	.032	-.010	-.081
POA TO CENTROID in.	.140	.139	.089
MIN RADIUS	.541	.456	.400
MEAN RADIUS	1.164	.968	.897
MAX RADIUS	2.532	1.512	1.232
HORIZONTAL SPREAD	4.185	2.541	1.966
VERTICAL SPREAD	2.159	2.159	2.159
EXTREME SPREAD	4.187	2.720	2.204
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	8		