

G6645311
Replaced
E6703584

Repair Inquiry

Repair Number: RE00129198

Serial: E6703504 Model M24 SWS Center Fire
Caliber: 7.62 NATO

Repairman:

Verify Repair

Status:

New 5/10/2007 11:17:42 AM

Address Information

Customer: ☐ Received From Return To: ☐ Received From

Name: 341 SFG/TRF 341 SFG/TRF

Address 1: 77TH STREET SOUTH BLDG 581 77TH STREET SOUTH BLDG 581

Address 2: PO Box: PO Box:

City: MALMSTROM AFB MALMSTROM AFB

State: MT Zip Code: 59402 Country: US State: MT Zip Code: 59402 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
A017	Scope Base	1
A026	Scope	1
A045	Bi Pod	1
A057	Fit and Rear Sgt Base	1

Repair Search

Refresh

Close

nagletj

5/10/2007

12:05 PM

CAPS

NUM

INS

SCRL

start

3 Mi...

5 Int...

2 Mi...

SAP L...

Part S...

Arms ...

12:05 PM

Serial
Number:

E6703504

Model: M24 SWS



RE00129198

New
Deployment
KIT



DEPARTMENT OF THE AIR FORCE
HEADQUARTERS 341ST SPACE WING (AFSPC)

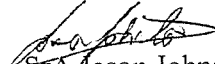
01 May 2007

MEMORANDUM FOR THOMAS J. NAGLE COMM: 315-895-3289

FROM: SrA Jason Johnston 341SFG/TRF S-4

SUBJECT: Cost for M-24 Repair

1. Sir, I would like a cost estimate if there is to be one for the repair of this M-24. I also am requesting a completely new Deployment Kit. The part number for that is 96096 with a quoted cost of \$383.25. If I can be contacted so that I can arrange payment for both I would appreciate it. I also am requesting this repair be done as fast as possible. This weapon is one of our operational weapons and we are hampered in our ability to conduct operational tactical missions with this weapon being gone. I appreciate any and all help that can be provided.
2. If there are any questions please contact me at DSN:632-2252, Comm: 406-731-2252, or my email is jason.johnston@malmstrom.af.mil. Thank-you for all the help.


SrA Jason Johnston
341 TRF/S-4

Guardians of the High Frontier

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6645311.___0
FILE DATE AND TIME: 06/01/2007 15:32

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.039
The Average Y Centroid of the Five Target Set:	-0.070
The Average Point of Impact of the Five Target Set:	0.080
The Average Mean Radius of the Five Target Set:	0.566
The Distance from POA to Centroid Target #1:	0.138
The Distance from Centroid Target #2 to Centroid Target #1:	0.036
The Distance from Centroid Target #3 to Centroid Target #1:	0.228
The Distance from Centroid Target #4 to Centroid Target #1:	0.201
The Distance from Centroid Target #5 to Centroid Target #1:	0.348

SERIAL NUMBER: G6645311. 0

TARGET NUMBER: 1

FILE DATE: 06/01/2007

FILE TIME: 15:32

X CENTROID: -0.065

Y CENTROID: -0.122

POA TO CENTROID: 0.138

HORZ SPREAD: 2.006

VERT SPREAD: 2.577

GROUP SPREAD: 2.801

MIN RADIUS: 0.278

MAX RADIUS: 1.694

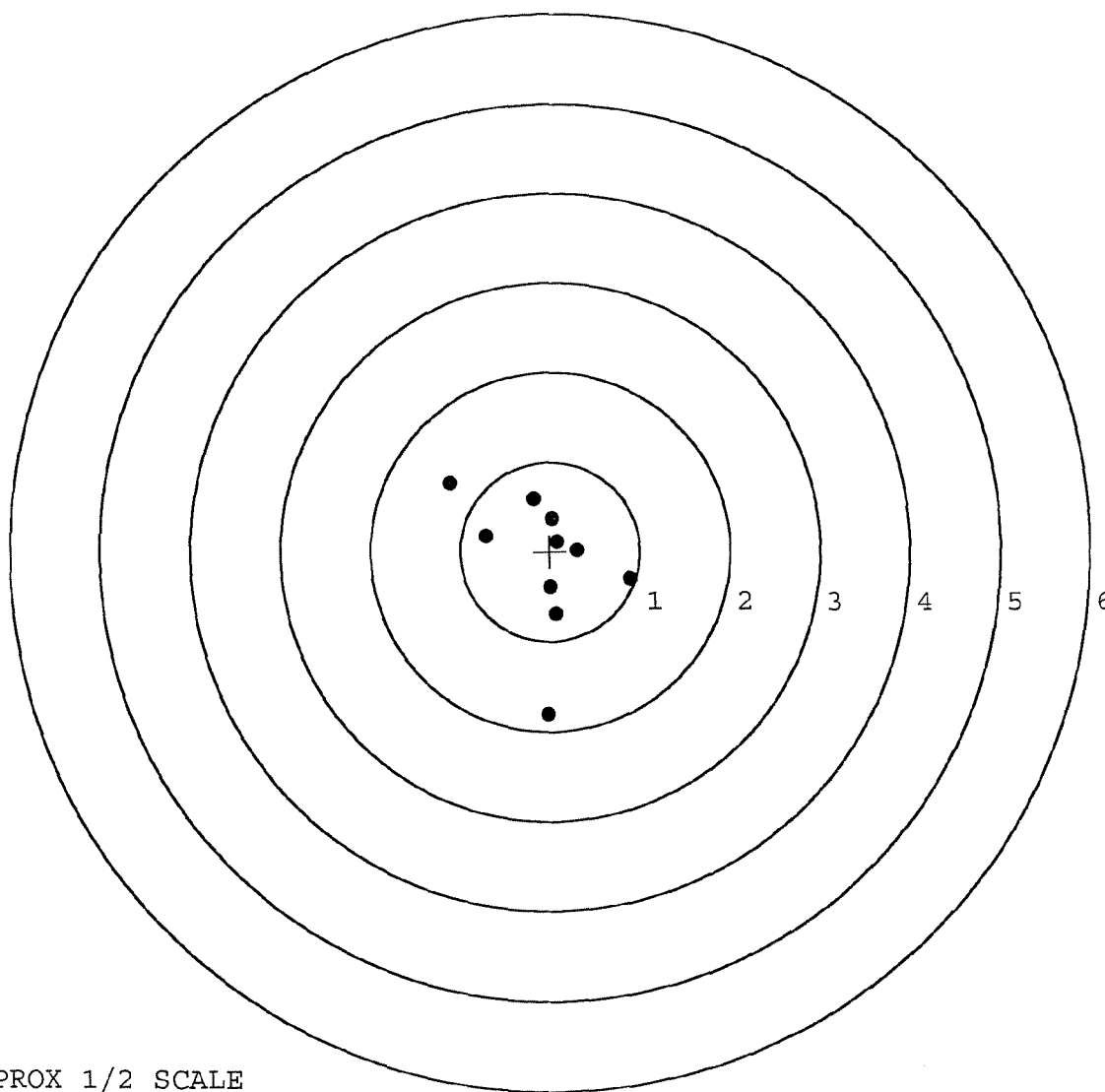
MEAN RADIUS: 0.754

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 9

POINT#	X	Y
1:	-1.115	0.762
2:	-0.714	0.170
3:	-0.188	0.588
4:	0.022	0.372
5:	0.084	0.112
6:	0.309	0.009
7:	0.008	-0.404
8:	0.070	-0.706
9:	0.891	-0.309
10:	-0.018	-1.815



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6645311. 0

TARGET NUMBER: 2

FILE DATE: 06/01/2007

FILE TIME: 15:32

X CENTROID: -0.062

Y CENTROID: -0.158

POA TO CENTROID: 0.170

HORZ SPREAD: 1.470

VERT SPREAD: 1.548

GROUP SPREAD: 1.800

MIN RADIUS: 0.187

MAX RADIUS: 1.147

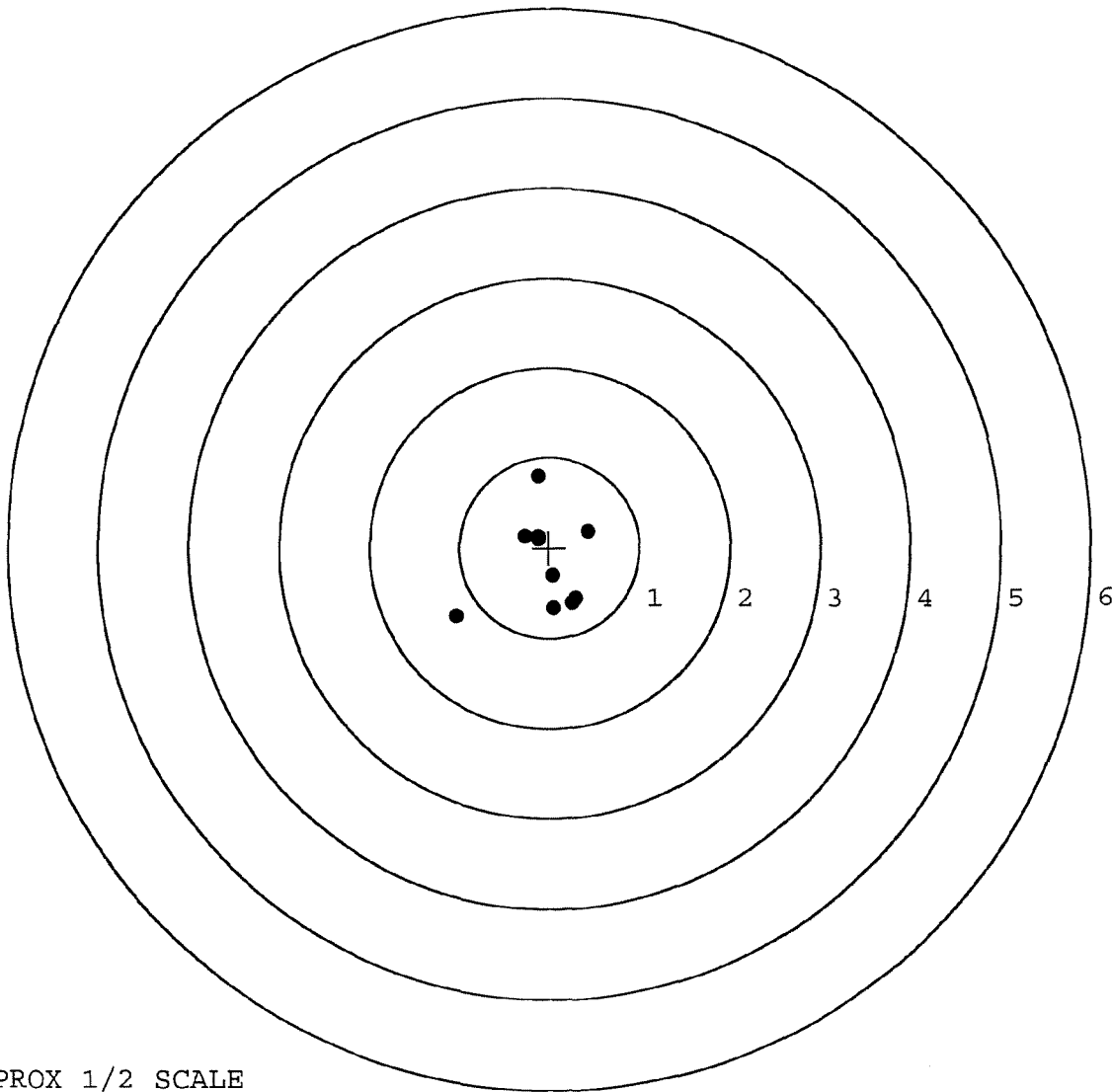
MEAN RADIUS: 0.540

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.120	0.788
2:	-0.276	0.128
3:	-0.130	0.121
4:	0.432	0.183
5:	0.045	-0.312
6:	0.049	-0.667
7:	0.255	-0.602
8:	0.298	-0.559
9:	-1.038	-0.760
10:	-0.131	0.097



TARGET APPROX 1/2 SCALE

BARBER - M24 0171282

SERIAL NUMBER: G6645311. __0

TARGET NUMBER: 3

FILE DATE: 06/01/2007

FILE TIME: 15:32

POINT#	X	Y
1:	-0.501	-1.781
2:	-0.536	-1.025
3:	0.416	0.226
4:	0.953	0.153
5:	-0.176	-0.536
6:	-0.208	-0.329
7:	-0.185	-0.012
8:	-0.337	0.154
9:	-0.519	0.009
10:	-0.806	0.007

X CENTROID: -0.190

Y CENTROID: -0.313

POA TO CENTROID: 0.366

HORZ SPREAD: 1.759

VERT SPREAD: 2.007

GROUP SPREAD: 2.420

MIN RADIUS: 0.024

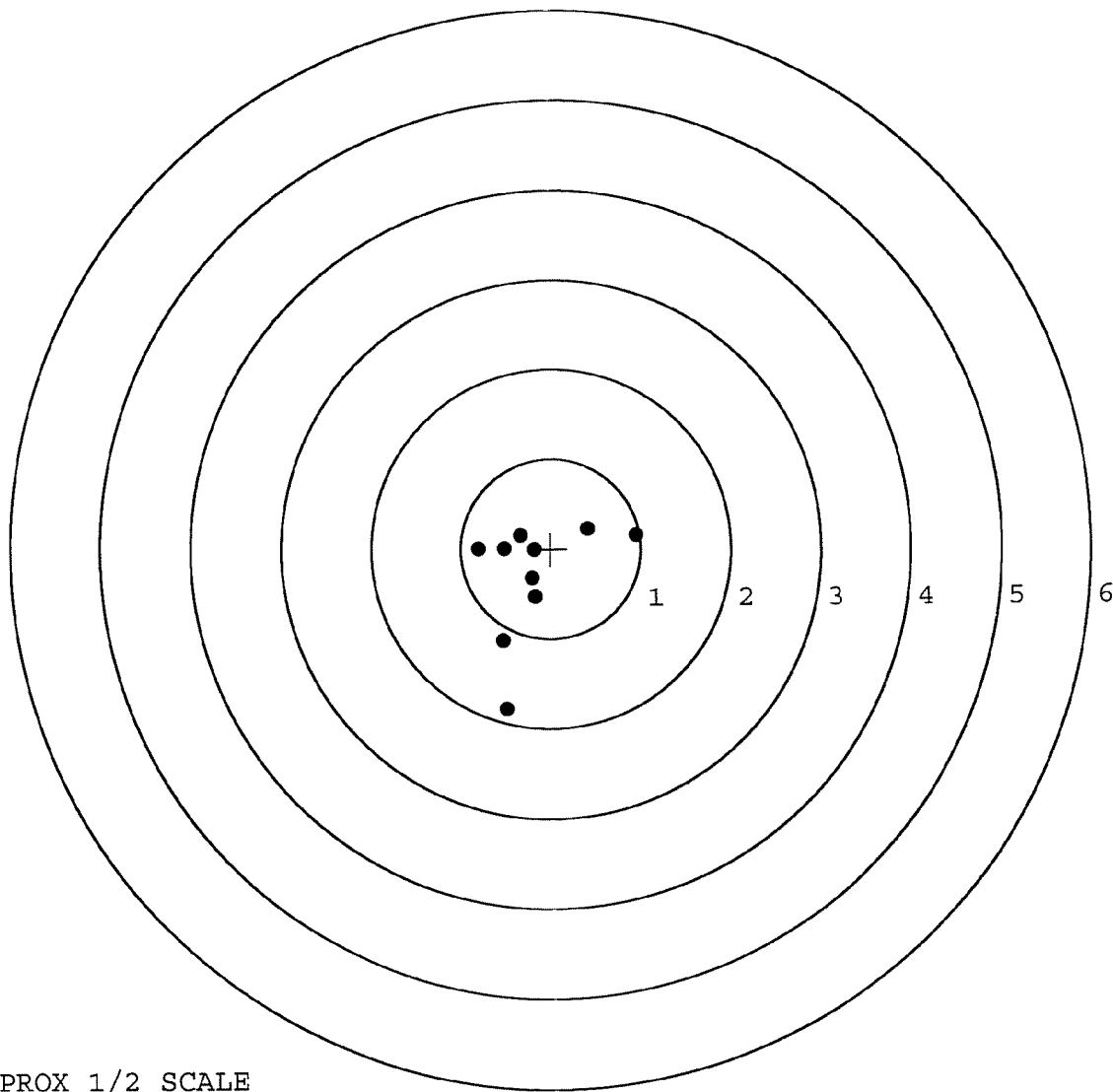
MAX RADIUS: 1.500

MEAN RADIUS: 0.653

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6645311. __0

TARGET NUMBER: 4

FILE DATE: 06/01/2007

FILE TIME: 15:32

POINT#	X	Y
1:	0.176	0.610
2:	-0.089	0.333
3:	0.381	0.188
4:	0.310	-0.013
5:	0.025	0.136
6:	-0.112	0.067
7:	-0.301	-0.059
8:	-0.112	-0.195
9:	0.084	-0.155
10:	-0.028	-0.379

X CENTROID: 0.033

Y CENTROID: 0.053

POA TO CENTROID: 0.063

HORZ SPREAD: 0.682

VERT SPREAD: 0.989

GROUP SPREAD: 1.010

MIN RADIUS: 0.083

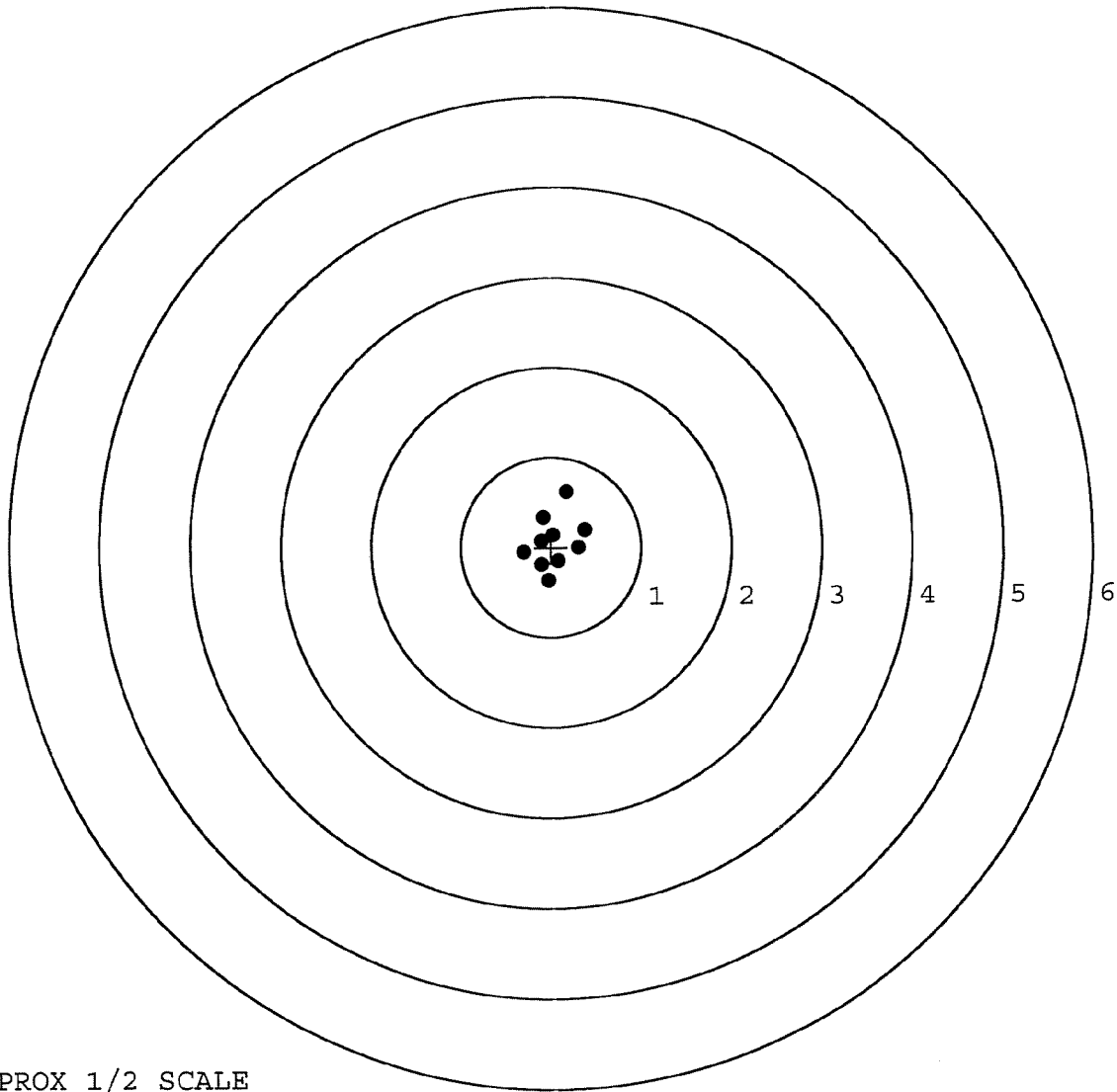
MAX RADIUS: 0.575

MEAN RADIUS: 0.306

IN 1 IN DIAMETER: 9

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10

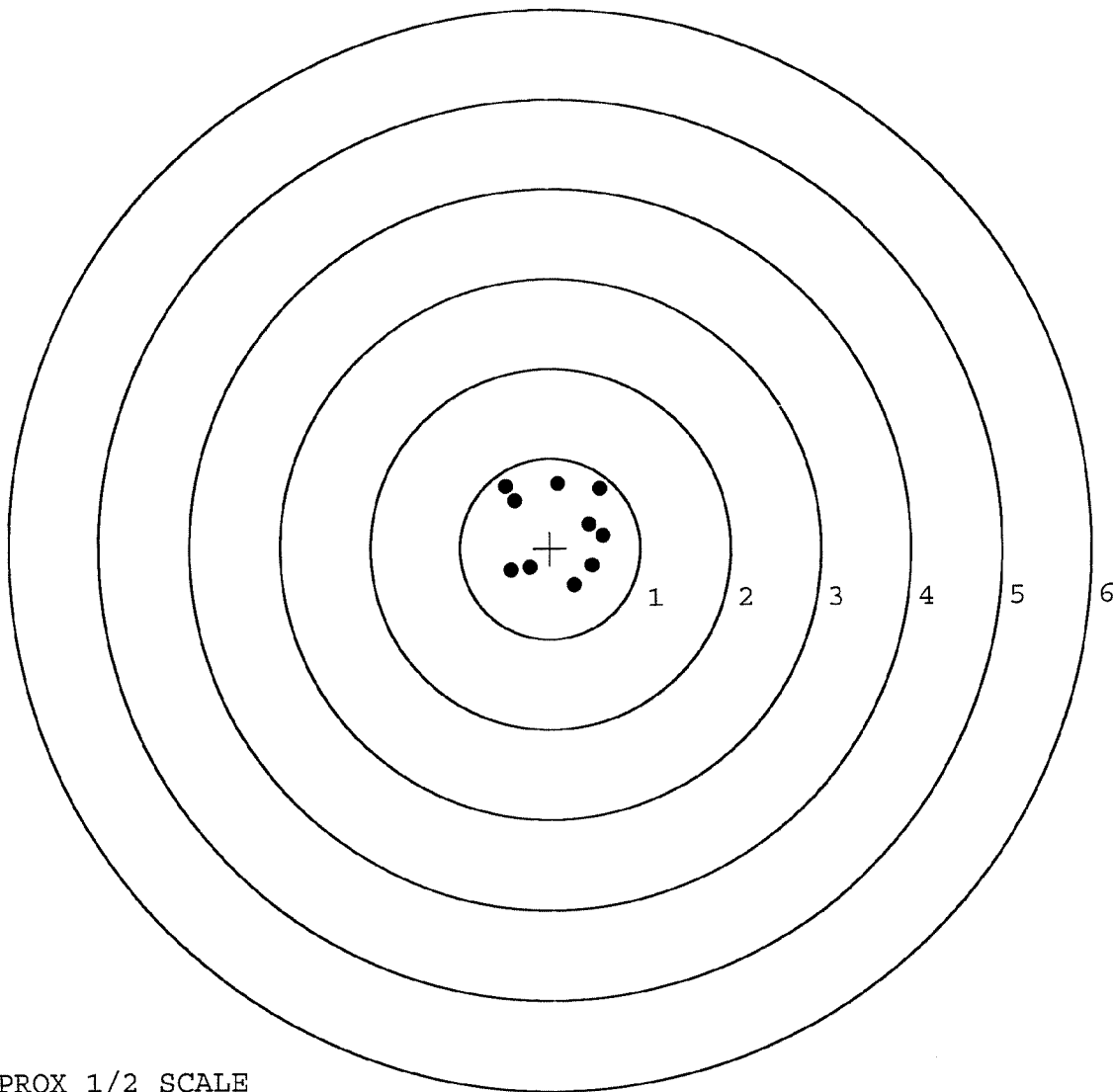


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6645311. __0
 TARGET NUMBER: 5
 FILE DATE: 06/01/2007
 FILE TIME: 15:32

POINT#	X	Y
1:	0.435	0.260
2:	0.473	-0.195
3:	0.270	-0.413
4:	-0.439	-0.246
5:	-0.392	0.528
6:	0.098	0.715
7:	0.558	0.655
8:	-0.490	0.688
9:	-0.231	-0.217
10:	0.591	0.135

X CENTROID: 0.087
 Y CENTROID: 0.191
 POA TO CENTROID: 0.210
 HORZ SPREAD: 1.081
 VERT SPREAD: 1.128
 GROUP SPREAD: 1.338
 MIN RADIUS: 0.354
 MAX RADIUS: 0.762
 MEAN RADIUS: 0.577
 # IN 1 IN DIAMETER: 1
 # IN 2 IN DIAMETER: 10
 # in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

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

R & E NUMBER	129198		
SERIAL NUMBER	E6703504 G6045311 (New)		
LOG-IN DATE	5-10-07		
OPERATION #	OPERATION NAME	DATE	INITIAL
500	DIS-ASSEMBLE GUN	5-14-07	RTZ
505	RE-BARREL	5-18-07	RTZ
560	ASSEMBLE	5-18-07	RTZ
600	PROOF	5-18-07	TRW
605	CHECK HEADSPACE	5-18-07	TRW
610	DIS-ASSEMBLE GUN	5-21-07	RTZ
612	MAGNAFLUX	5-21-07	unms
510	DRILL AND TAP	5-21-07	TRW
615	ROLLMARK CALIBER	5-21-07	CW
618	ROTO-BLAST	5-22-07	LB
620	APPLY COATINGS	5-24-07	WJ
625	FINAL ASSEMBLY	5-30-07	RTZ
640	FUNCTION TEST AND	PASS FAIL 6-1-07	TRW
650	TARGET	PASS FAIL 6-1-07	TRW
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
670	FINAL INSPECTION	6-1-07	Em
	A) HEADSPACE	PASS FAIL 6-8-07	RTZ
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS 283 284 289 289 288 6-4-07	DA
680	F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX 50 4.5 50 6-4-07	DA
	G) SAFETY OFF FORCE	2 LBS 25 25 2.5 6-4-07	DA
	I) FIRING PIN INDENT	.020 .023 .023 .023 6-4-07	DA
690	PACK	6-21-07	DA

CONTRACT # DAAE20-01-C-0007

GUN SERIAL #

E670 3504

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		3/22/01	CK
600	PROOF		1	
607	CHECK HEADSPACE			
610	DIS-ASSEMBLE GUN			
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT			
615	ROLLMARK CALIBER			
617	DRILL AND TAP SIGHT HOLES		3/22/01	DA
618	POLISH BARREL			
620	APPLY COATINGS (BARREL ACTION)			
	(BOLT)			
625	FINAL ASSEMBLY			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		3/23/01	JA
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		1	
	C) INSPECT EJECTOR HOLE FOR CHAMFER			
	D) OIL FIRING PIN ASSEMBLY		3/23/01	CK
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE		1	

OP # BARBER M24 M471287		READINGS			DATE	INITIAL
625	F) SAFETY ON FORCE	<u>6.0</u>	<u>5.0</u>	<u>5.5</u>	3/29/01	DA
CONT.						
	G) SAFETY OFF FORCE	<u>3.0</u>	<u>3.0</u>	<u>3.0</u>	3/29/01	DA
	H) TRIGGER PULL TEST AND RETAINABILITY					
	I) FIRING PIN INDENT	<u>.021</u>	<u>022</u>	<u>,022</u>	3/29/01	DA
	J) ASSEMBLE STOCK					CK
	K) ASSEMBLE SWIVEL STUDS					
	L) ATTACH FRONT AND REAR SIGHT ASSY'S					
	M) IRON SIGHT ALIGNMENT					
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER					
640	GALLERY TEST AND TARGET				3/27	K
	A) MALFUNCTIONS				3/27	A
	B) PIERCED PRIMERS				3/27	K
645	INSPECT FOR LIVE AMMO				3/27	AC
655	FINAL INSPECTION A) HEADSPACE				3/30/01	FW
	B) TRIGGER PULL	<u>2.77</u>	<u>2.75</u>	<u>2.69</u> <u>2.84</u> <u>2.87</u>	3/31/01	DA
	C) FUNCTION					
660	PACK					

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. E6703504DATE 12-19-00TESTER FW

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.59	2.76		2.87	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.75	2.76		2.89	
PULL #3	2.74	2.80		2.63	
PULL #4	2.72	2.80		2.90	
PULL #5	2.73	2.83		2.72	
TOTAL	13.53	13.95		14.01	
AVG.	2.71	2.79		2.80	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.30	3.32		
PULL #2	3.15	3.32		
PULL #3	3.25	3.25		
PULL #4	3.26	3.34		
PULL #5	3.27	3.32		
TOTAL	16.23	16.55		
AVG.	3.25	3.31		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.26	4.13		4.23
PULL #2	4.17	4.07		4.23
PULL #3	4.18	4.10		4.25
PULL #4	4.21	4.12		4.26
PULL #5	4.15	4.08		4.20
TOTAL	20.97	20.50		21.17
AVG.	4.19	4.10		4.23

BARBER - M24 0171289

Remington Test Lab, Ilion, N.Y.

Centroidal distance calculations for Rifle # e6703504
28 Mar 2001

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0908
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0668
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .112725

THE AMR FOR THIS RIFLE IS: 1.168

CENTROIDAL DISTANCES

0	TO	1	.146086
1	TO	2	.0902497
1	TO	3	.264008
1	TO	4	.125196
1	TO	5	.306444

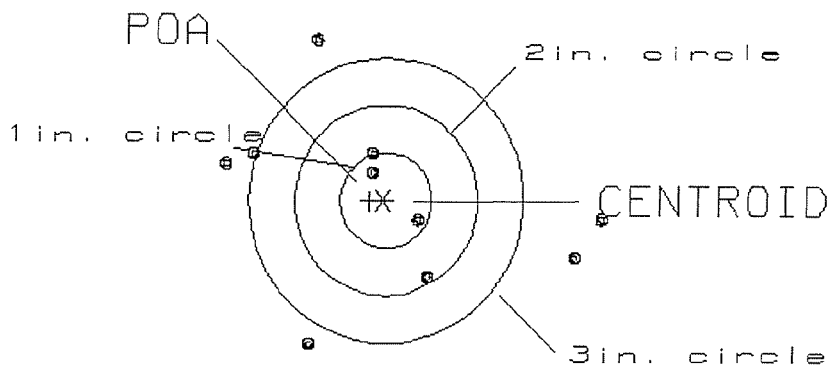
5 3
#1 <----POA

PATTERN #: 1
 POA TO CENTROID: .146
 MIN RADIUS : .319
 MEAN RADIUS : 1.365
 MAX RADIUS : 2.323
 CENTROID X : .146
 CENTROID Y : .005

28 Mar 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/e6703504

CENTERFIRE PATTERN # 1



OF SHOTS= 10

IN CIRCLE

HS= 4.05
 VS= 3.22
 GS= 4.10

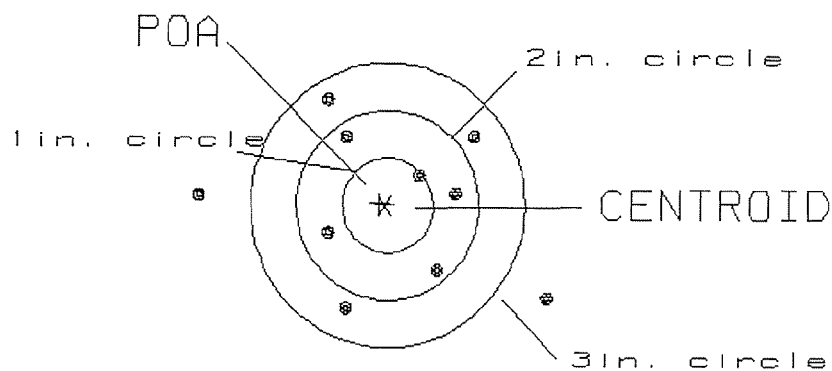
2
 4
 4

PATTERN #: ☐ 2 ☐
 POA TO CENTROID: .061
 MIN RADIUS : .471
 MEAN RADIUS : 1.148
 MAX RADIUS : 2.074
 CENTROID X : .059
 CENTROID Y : -.019

28 Mar 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/e6703504

CENTERFIRE PATTERN # 2



OF SHOTS= 10

IN CIRCLE

HS= 3.81

1

VS= 2.26

5

GS= 3.97

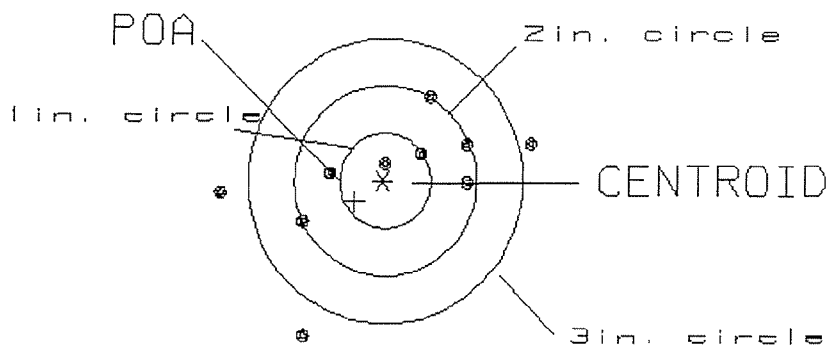
8

PATTERN #: 3
 POA TO CENTROID: .374
 MIN RADIUS : .149
 MEAN RADIUS : 1.047
 MAX RADIUS : 1.893
 CENTROID X : .306
 CENTROID Y : .215

28 Mar 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/e6703504

CENTERFIRE PATTERN # 3



OF SHOTS= 10

IN CIRCLE

HS= 3.40

2

VS= 2.59

6

GS= 3.44

7

BARBER - M24 0171293

REMINGTON CENTERFIRE ACCURACY TEST

REMINGTON TEST LAB, ILION, N.Y.

PATTERN #: ☐ 4 ☐

POA TO CENTROID: .071

MIN RADIUS : .225

MEAN RADIUS : .843

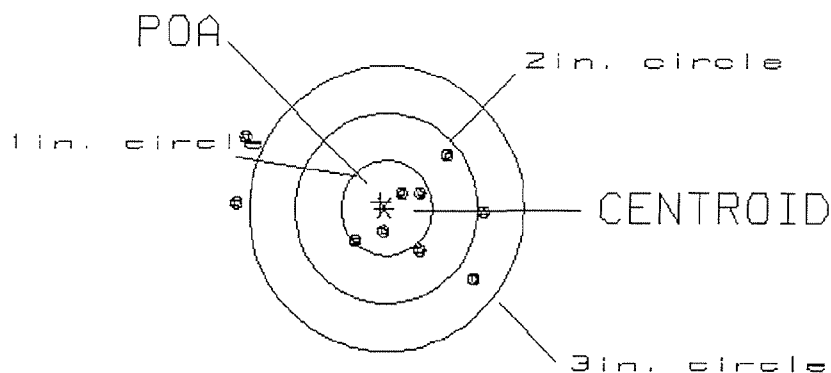
MAX RADIUS : 1.688

CENTROID X : .039

CENTROID Y : -.060

28 Mar 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/e6703504

CENTERFIRE PATTERN # 4

OF SHOTS= 10

IN CIRCLE

HS= 2.76

4

VS= 1.47

6

GS= 2.88

8

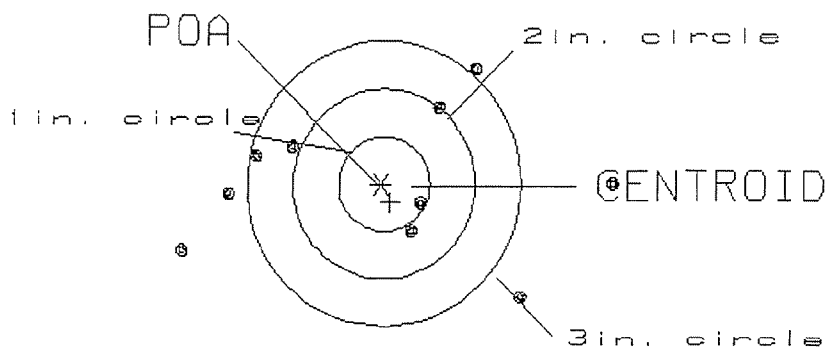
PATTERN #: 5

POA TO CENTROID: .215
 MIN RADIUS : .418
 MEAN RADIUS : 1.439
 MAX RADIUS : 2.458
 CENTROID X : -.096
 CENTROID Y : .193

28 Mar 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/e6703504

CENTERFIRE PATTERN # 5



OF SHOTS= 10

IN CIRCLE

HS= 4.65

1

VS= 2.36

3

GS= 4.70

5