

G6738625

Replaces

C6225223

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: RE00147685

Serial: C6225223 Model M24 SWS Center Fire
Caliber: 7.62 NATO

Repairman:

Verify Repair

Status: Closed 7/17/2008 6:22:12 AM

Address Information

Customer:

Received From

Return To:

Received From

Name: PBO 1/75 RANGER REGIMENT

PBO 1/75 RANGER REGIMENT

Address 1: ATTN: WO1 CURTIS B MATHIS

ATTN: WO1 CURTIS B MATHIS

Address 2: 1036 LIBERATOR RD

PO Box:

1036 LIBERATOR RD

PO Box:

City: HUNTER AAF

HUNTER AAF

State: GA

Zip Code: 31409

Country: US

State: GA

Zip Code: 31409

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
A057	Fit and Rear Sgt Base	1
D000	MARS RAIL	1

Repair Search

Refresh

Close

nagletj

7/17/2008

8:10 AM

CAPS

NUM

INS

SCRL

H start

10 Micr...

Excite Mail...

8 Micros...

Arms Ser...

Part Sear...

8:10 AM

G6738625 (New)

Number: ~~C6225223~~

Model: M24 SWS

Reset



RE00147685

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

R & E NUMBER 147685
SERIAL NUMBER C6225223 C6738625 (New)
LOG-IN DATE 7-17-08

OPERATION #	OPERATION NAME	DATE	INITIAL
500	DIS-ASSEMBLE GUN	9-29-08	RTZ
505	RE-BARREL	9-30-08	RTZ
560	ASSEMBLE	9-30-08	RTZ
600	PROOF	10-2-08	SPD
605	CHECK HEADSPACE	10-2-08	SPD
610	DIS-ASSEMBLE GUN	10-2-08	SPD
612	MAGNAFLUX	10/8/08	(K)
510	DRILL AND TAP	10-6-08	SP
615	ROLLMARK CALIBER	10/8/08	RT
618	ROTO-BLAST		
620	APPLY COATINGS	10-11	C
625	FINAL ASSEMBLY	10-13-08	RTZ
640	FUNCTION TEST AND	10-14-08	SPD
650	TARGET	10-14-08	SPD
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
670	FINAL INSPECTION	10-14-08	RT
	A) HEADSPACE	10-12-08	SPD
	B) TRIGGER PULL	2.74 2.71 2.82 2.80 2.83	10-12-08
680	F) SAFETY ON FORCE	4.0 4.0 3.0	10-22-08
	G) SAFETY OFF FORCE	4.0 4.0 4.0	10-22-08
	I) FIRING PIN INDENT	.030 .031 .032	10-22-08
690	PACK	10/23/08	FM

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6738625.___0
FILE DATE AND TIME: 10/15/2008 07:18

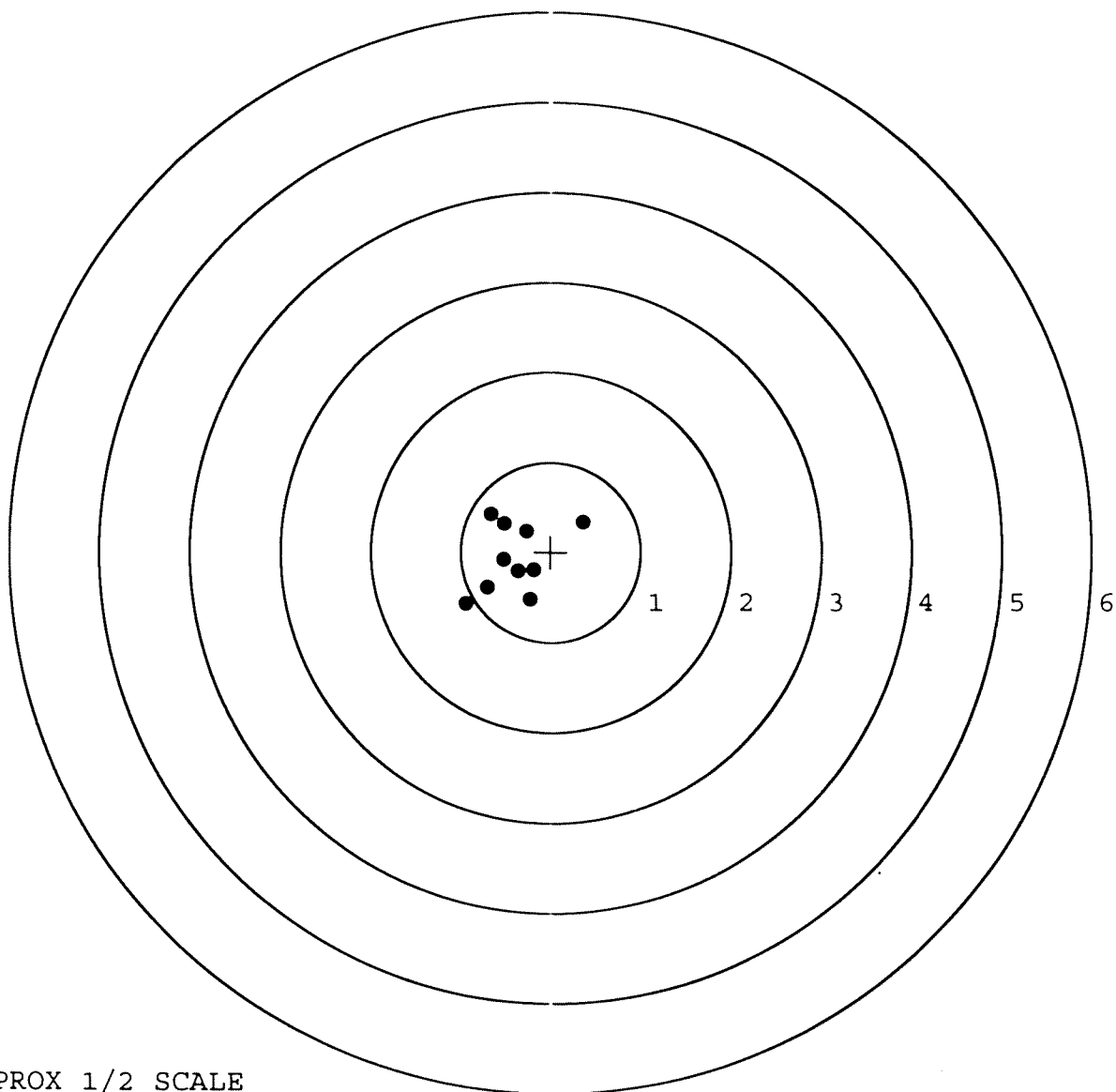
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.090
The Average Y Centroid of the Five Target Set:	-0.234
The Average Point of Impact of the Five Target Set:	0.251
The Average Mean Radius of the Five Target Set:	0.627
The Distance from POA to Centroid Target #1:	0.410
The Distance from Centroid Target #2 to Centroid Target #1:	0.497
The Distance from Centroid Target #3 to Centroid Target #1:	0.631
The Distance from Centroid Target #4 to Centroid Target #1:	0.564
The Distance from Centroid Target #5 to Centroid Target #1:	0.187

SERIAL NUMBER: G6738625. 0
TARGET NUMBER: 1
FILE DATE: 10/15/2008
FILE TIME: 07:18

X CENTROID: -0.403
Y CENTROID: -0.071
POA TO CENTROID: 0.410
HORZ SPREAD: 1.307
VERT SPREAD: 1.004
GROUP SPREAD: 1.595
MIN RADIUS: 0.123
MAX RADIUS: 0.869
MEAN RADIUS: 0.436
IN 1 IN DIAMETER: 7
IN 2 IN DIAMETER: 10
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.364	0.336
2:	-0.271	0.230
3:	-0.519	0.318
4:	-0.661	0.425
5:	-0.524	-0.093
6:	-0.361	-0.216
7:	-0.189	-0.203
8:	-0.228	-0.532
9:	-0.702	-0.397
10:	-0.943	-0.579

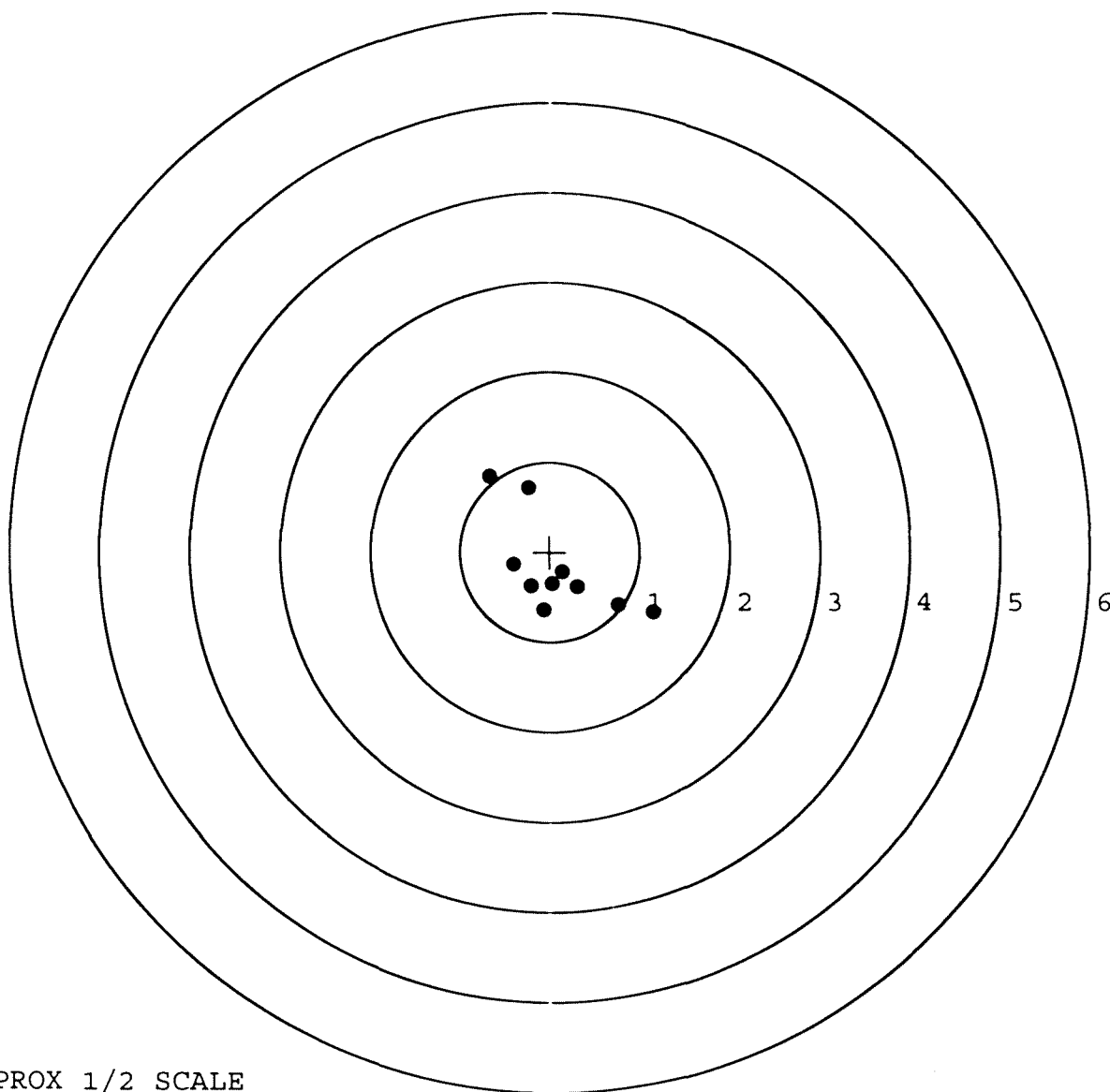


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6738625. __0
TARGET NUMBER: 2
FILE DATE: 10/15/2008
FILE TIME: 07:18

X CENTROID: 0.080
Y CENTROID: -0.185
POA TO CENTROID: 0.202
HORZ SPREAD: 1.820
VERT SPREAD: 1.509
GROUP SPREAD: 2.364
MIN RADIUS: 0.075
MAX RADIUS: 1.272
MEAN RADIUS: 0.608
IN 1 IN DIAMETER: 6
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.670	0.842
2:	-0.244	0.715
3:	-0.402	-0.146
4:	-0.211	-0.386
5:	-0.071	-0.649
6:	0.027	-0.356
7:	0.143	-0.226
8:	0.312	-0.390
9:	0.764	-0.590
10:	1.150	-0.667

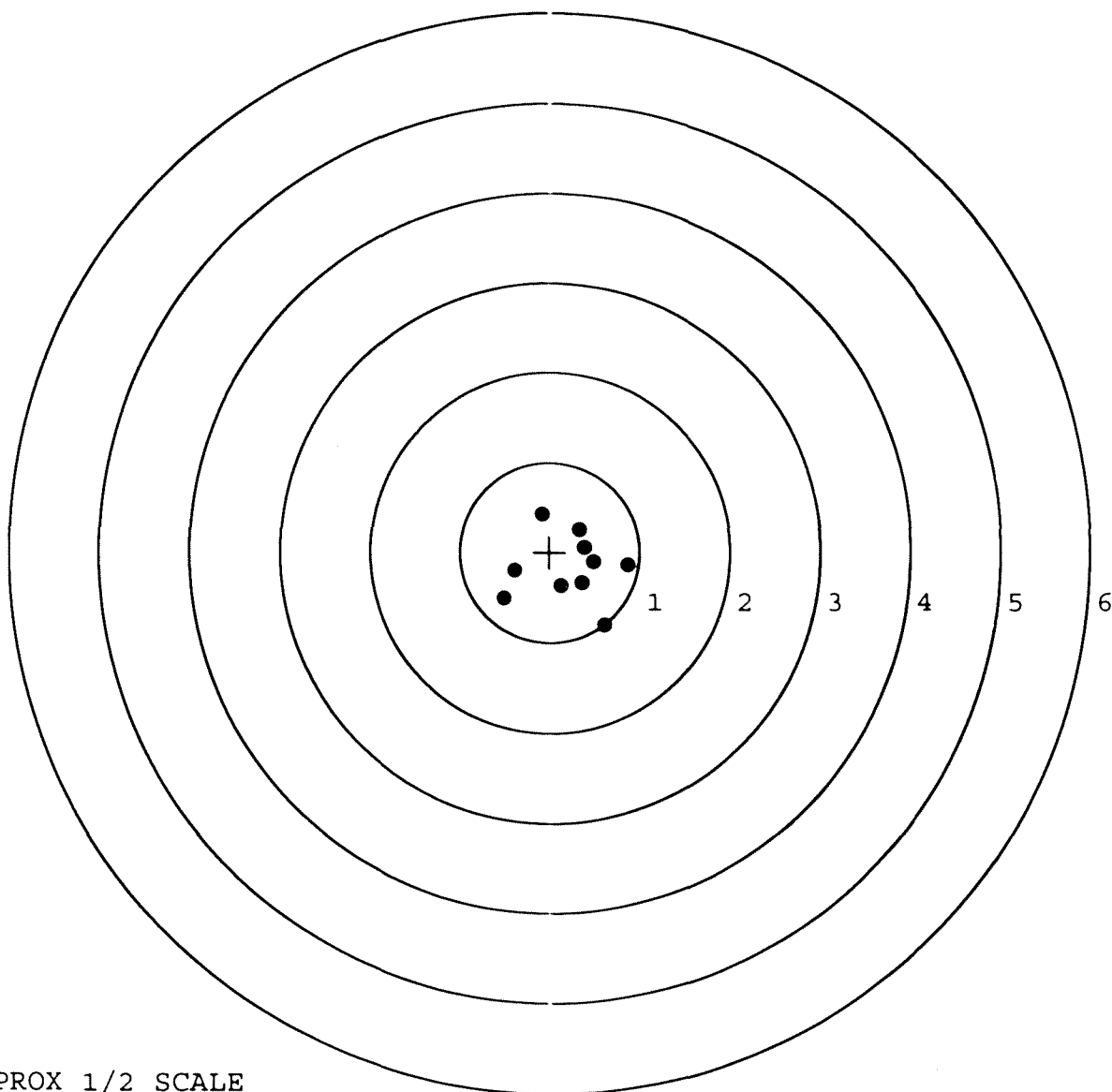


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6738625. __0
TARGET NUMBER: 3
FILE DATE: 10/15/2008
FILE TIME: 07:18

X CENTROID: 0.219
Y CENTROID: -0.177
POA TO CENTROID: 0.282
HORZ SPREAD: 1.379
VERT SPREAD: 1.235
GROUP SPREAD: 1.428
MIN RADIUS: 0.218
MAX RADIUS: 0.806
MEAN RADIUS: 0.494
IN 1 IN DIAMETER: 5
IN 2 IN DIAMETER: 10
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.512	-0.517
2:	-0.389	-0.207
3:	-0.090	0.423
4:	0.336	0.256
5:	0.388	0.059
6:	0.492	-0.107
7:	0.360	-0.344
8:	0.129	-0.377
9:	0.867	-0.147
10:	0.607	-0.812

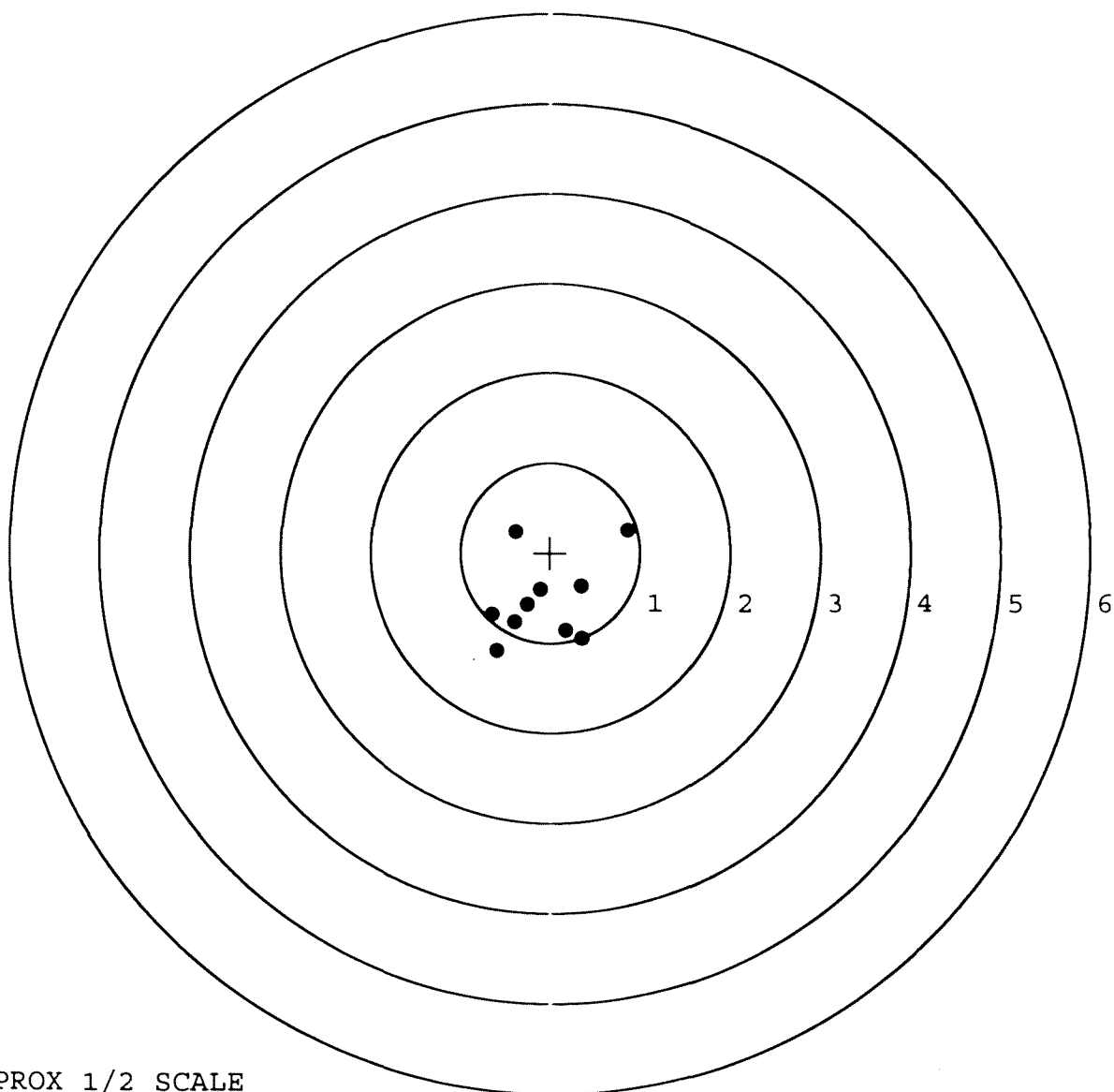


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6738625. __0
TARGET NUMBER: 4
FILE DATE: 10/15/2008
FILE TIME: 07:18

X CENTROID: -0.065
Y CENTROID: -0.523
POA TO CENTROID: 0.527
HORZ SPREAD: 1.514
VERT SPREAD: 1.349
GROUP SPREAD: 1.990
MIN RADIUS: 0.123
MAX RADIUS: 1.211
MEAN RADIUS: 0.562
IN 1 IN DIAMETER: 5
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.863	0.256
2:	0.353	-0.370
3:	-0.383	0.235
4:	-0.651	-0.681
5:	-0.600	-1.093
6:	-0.394	-0.768
7:	-0.260	-0.579
8:	-0.111	-0.408
9:	0.175	-0.864
10:	0.356	-0.953

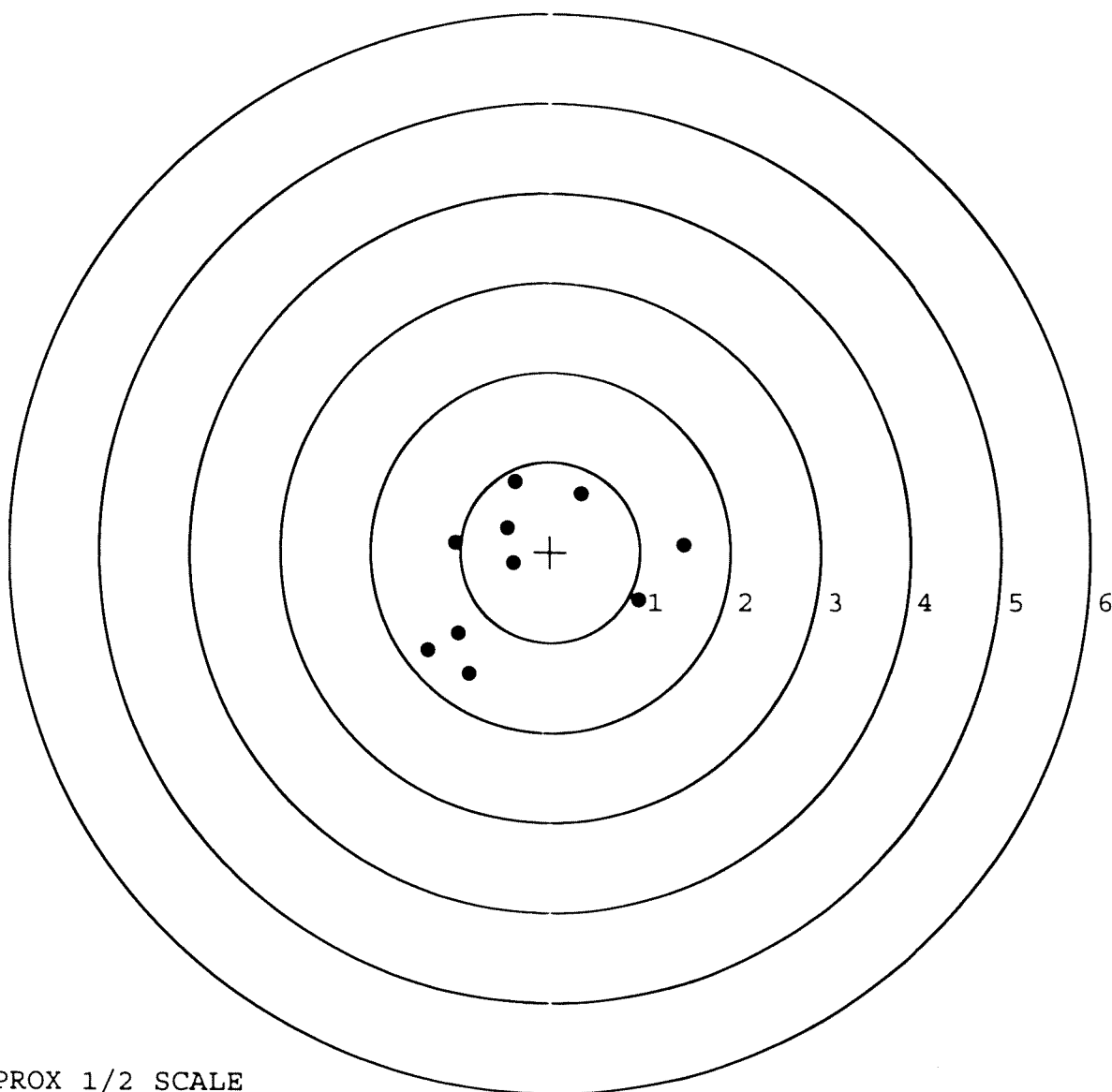


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6738625. __0
TARGET NUMBER: 5
FILE DATE: 10/15/2008
FILE TIME: 07:18

X CENTROID: -0.281
Y CENTROID: -0.213
POA TO CENTROID: 0.352
HORZ SPREAD: 2.849
VERT SPREAD: 2.124
GROUP SPREAD: 3.080
MIN RADIUS: 0.156
MAX RADIUS: 1.789
MEAN RADIUS: 1.036
IN 1 IN DIAMETER: 1
IN 2 IN DIAMETER: 4
in 3 IN DIAMETER: 9

POINT#	X	Y
1:	0.983	-0.528
2:	1.484	0.083
3:	0.349	0.648
4:	-0.387	0.774
5:	-0.475	0.260
6:	-0.412	-0.129
7:	-1.058	0.102
8:	-1.025	-0.901
9:	-1.365	-1.087
10:	-0.902	-1.350



TARGET APPROX 1/2 SCALE

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6225223

OPERATION		DATE	INT
#	NAME		
575-580	ASSEMBLY	2/1	FB
600	PROOF	2/4/88	Ku
615	MAGNAFLUX BARREL	2/18/88	P/E.
	MAGNAFLUX BOLT	2/25/88	P/E.
620	COATING	3/21/88	TJA
625-630	FINAL ASSEMBLY		
635	TEST		
640	TARGET		
	FIRING PIN INDENT		
660	PACK		

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6225223

OP.#	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and stock			
600	Proof			
607	Check Headspace			
610	Dis-assemble gun			
612	Magnaflux Barrel Action			
	Magnaflux Bolt			
615	Rollmark Caliber			
617	Drill & Tap Sight Holes			
618	Polish Barrel			
620	Apply Coatings (Barrel Action)			
	Apply Coatings (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		9/7/88	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		9/7/88	RW
	C) Inspect Ejector Hole for Chamfer		9/7/88	RW

OVER

OP.#		READINGS	DATE	INITIAL
625 cont.	D) Oil Firing Pin Ass'y		9/7/88	RW
	E) Adjust Trigger Pull to Min. Setting and Stake		7 Sept 88	JS
	F) Safety on Force	4 4 4	7 Sept 88	JS
	G) Safety off Force	3 3 3	7 Sept 88	JS
	H) Trigger Pull Test & Retainabilty		7 Sept 88	JS
	I) Firing Pin Indent	.022 .022 .022	7 Sept 88	JS
	J) Assemble Stock		9/21/88	RW
	K) Assemble Swivel Studs		10-7-88	JS
	L) Attach Front & Rear Sight Assemblies		9/21/88	RW
	M) Iron Sight Alignment		9/21/88	RW
	N) Detach Front & Rear Sights & place in numbered container		9/21/88	RW
	O) Attach Scope to Rifle		10/3/88	RW
	P) Detach & Attach Scope 20 times		10/3/88	JS
640	Gallery Target & Test	53 R 107 L	10-6-88	AC
	A) Optical Clarity of Scope	OK	10-6-88	AC
645	Inspect for Live Ammo	none	10-6-88	AC
655	Final Inspection			
	A) Headspace		10-7-88	JS
	B) Trigger Pull		10-7-88	JS
	C) Function		10-7-88	JS
660	Pack		15 Dec 88	JS

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6225223

DATE 7 Sept 88

TESTER JSJ

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.65	2.67	2.81	2.94	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.57	2.68	2.89	2.95	
PULL #3	2.47	2.69	2.74	2.85	
PULL #4	2.69	2.69	2.68	2.79	
PULL #5	2.74	2.68	2.95	2.89	
TOTAL	13.12	13.41	14.07	14.42	
AVG.	2.624	2.682	2.814	2.884	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.14	3.20		
PULL #2	3.19	3.20		
PULL #3	3.08	3.08		
PULL #4	3.00	3.19		
PULL #5	3.13	3.17		
TOTAL	15.54	15.90		
AVG.	3.108	3.18		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.19	4.07		4.07
PULL #2	4.04	4.16		4.08
PULL #3	4.09	4.26		4.01
PULL #4	4.14	4.12		3.98
PULL #5	4.15	4.28		3.99
TOTAL	20.61	20.89		20.13
AVG.	4.122	4.178		4.026

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6225223

CENTROIDAL DISTANCES

0 TO 1 .36658
1 TO 2 1.77135
1 TO 3 1.22115
1 TO 4 1.10917
1 TO 5 1.50408

3 4 5
+
1 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .2906
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .606
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .672075
THE AMR FOR THIS RIFLE IS: .9582

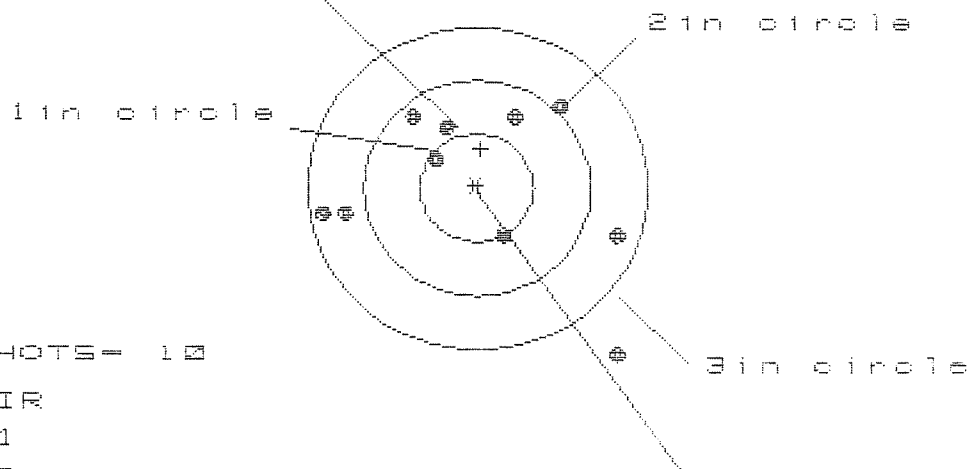
6 Oct 1988

FILE:/PATTERNING/CENTERFIRE_PATT/06225223

CENTERFIRE PATTERNS

1

POA



OF SHOTS= 10

IN CIR

1in = 1

2in = 5

3in = 9

HS= 2.675

VS= 2.273

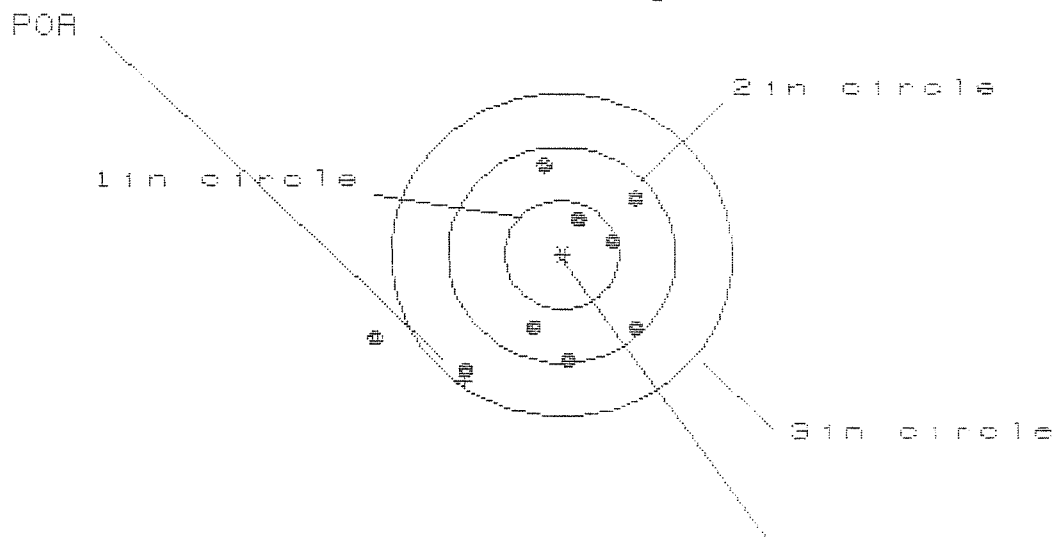
GS= 2.972

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.272	1.410	1.252
MINIMUM X	-1.403	-1.265	-1.190
MAXIMUM Y	.716	.542	.497
MINIMUM Y	-1.557	-.652	-.697
CENTROID X	-.034	-.172	-.014
CENTROID Y	-.365	-.191	-.146
POA TO CENTROID in.	.366	.257	.146
MIN RADIUS	.479	.276	.420
MEAN RADIUS	1.013	.851	.792
MAX RADIUS	1.989	1.534	1.411
HORIZONTAL SPREAD	2.675	2.675	2.442
VERTICAL SPREAD	2.273	1.194	1.194
EXTREME SPREAD	2.972	2.686	2.454
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	9		

8 Oct 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C8225223

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 1

2in = 7

3in = 8

HS= 2.448

VS= 3.429

GS= 4.050

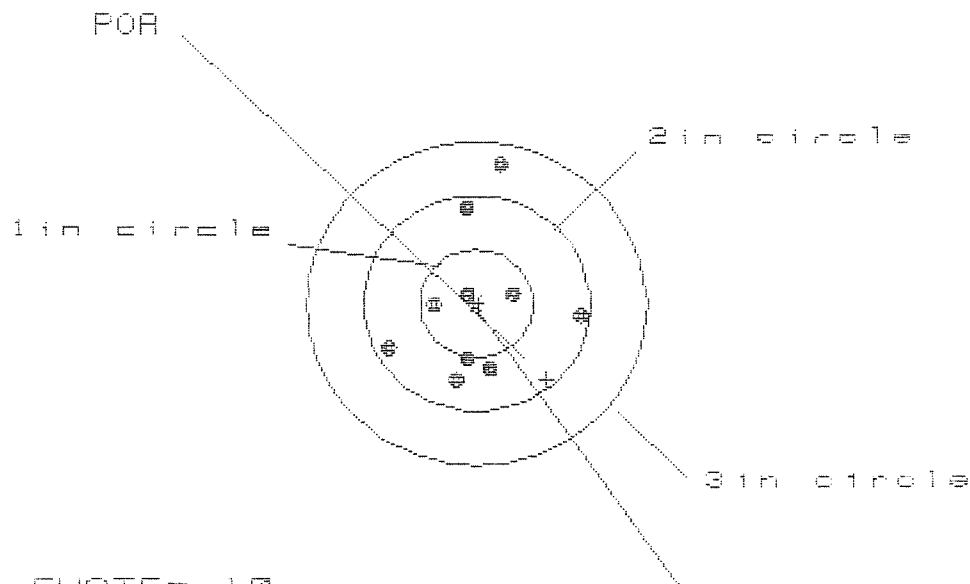
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.836	.768	.579
MINIMUM X	:	-1.612	-1.520	-.940
MAXIMUM Y	:	2.408	1.052	.984
MINIMUM Y	:	-1.021	-.754	-.822
CENTROID X	:	.850	.758	.948
CENTROID Y	:	1.170	.903	.971
POA TO CENTROID in.	:	1.446	1.178	1.357
MIN RADIUS	:	.315	.470	.488
MEAN RADIUS	:	1.080	.908	.786
MAX RADIUS	:	2.549	1.616	1.249
HORIZONTAL SPREAD	:	2.448	2.288	1.518
VERTICAL SPREAD	:	3.429	1.806	1.806
EXTREME SPREAD	:	4.050	2.656	2.171
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		8	

6 Oct 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C8225223

CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1 in = 3

2 in = 9

3 in = 10

IS = 1.706

VS = 2.054

ES = 2.085

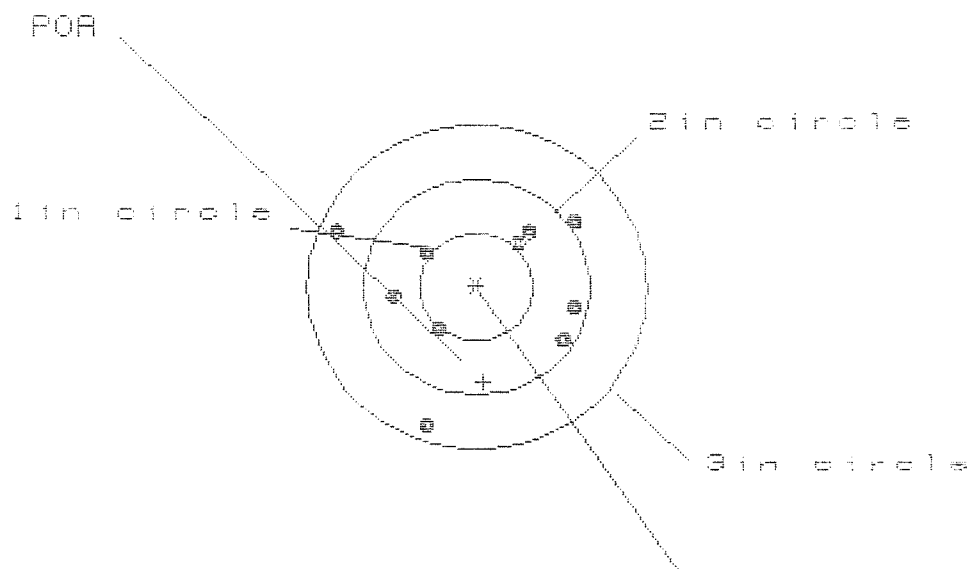
CENTROID *

PATTERN #	3		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.942	.964	.469
MINIMUM X	-.764	-.742	-.622
MAXIMUM Y	1.304	1.055	1.063
MINIMUM Y	-.750	-.605	-.597
CENTROID X	-.617	-.639	-.759
CENTROID Y	.708	.563	.555
POA TO CENTROID in.	.939	.851	.940
MIN RADIUS	.133	.259	.270
MEAN RADIUS	.689	.605	.550
MAX RADIUS	1.319	1.057	1.064
HORIZONTAL SPREAD	1.706	1.706	1.091
VERTICAL SPREAD	2.054	1.660	1.660
EXTREME SPREAD	2.085	1.747	1.662
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		9	
NUMBER IN THREE INCH CIRCLE =		10	

6 Oct 1988

FILE:/PATTERNING/CENTERFIRE_PATT/08225223

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 0

2in = 7

3in = 10

HS= 2.185

VS= 1.874

GS= 2.327

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.908	.767	.690
MINIMUM X	:	-1.276	-.878	-.955
MAXIMUM Y	:	.583	.644	.491
MINIMUM Y	:	-1.291	-1.230	-.540
CENTROID X	:	.804	.870	.105
CENTROID Y	:	.884	.823	.976
POA TO CENTROID in.	:	.886	.826	.989
MIN RADIUS	:	.550	.527	.356
MEAN RADIUS	:	.871	.805	.704
MAX RADIUS	:	1.390	1.374	.970
HORIZONTAL SPREAD	:	2.185	1.645	1.645
VERTICAL SPREAD	:	1.874	1.874	1.031
EXTREME SPREAD	:	2.327	2.327	1.774
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	