

C6498866

MODEL 700™ M24

Model **SWS**™

Action

Barrel Length

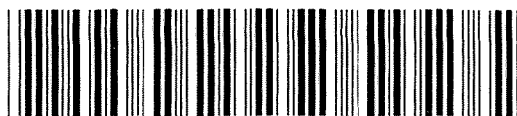
Capacity

Order No. **5716**

*Includes 1 in chamber.



Repair Number: RE00113013	Serial: C6498866 Model M24 SWS Center Fire Caliber: 7.62 NATO	Repairman:	Status: Closed 5/31/2006 10:21:23 AM															
Verify Repair																		
Address Information																		
Customer: ☒ Received From		Return To: ☐ Received From																
Name: C CO SPT BN SWTG (A) POC JERRY SCREEN		C CO SPT BN SWTG (A) POC JERRY SCREEN																
Address 1: ARMAMENT FACILITY BLDG D-1307		ARMAMENT FACILITY BLDG D-1307																
Address 2: GRUBER ROAD PO Box:		GRUBER ROAD PO Box:																
City: FORT BRAGG		FORT BRAGG																
State: NC Zip Code: 28310 Country: US		State: NC Zip Code: 28310 Country: US																
FFL: ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐																		
Contact / Condition Problems Estimate History / Status Shipping / Billing																		
Contact Information		Received Condition																
Phone: NA		Fair																
Fax:		Condition Notes:																
Email:		CSR Notes:																
Comments:																		
Accessories Received																		
<table border="1"><thead><tr><th>Code</th><th>Desc</th><th>Qty</th></tr></thead><tbody><tr><td>A007</td><td>With Stud</td><td>3</td></tr><tr><td>A010</td><td>Hard Case</td><td>1</td></tr><tr><td>A017</td><td>Scope Base</td><td>1</td></tr><tr><td>A057</td><td>Frt and Rear Sgt Base</td><td>1</td></tr></tbody></table>				Code	Desc	Qty	A007	With Stud	3	A010	Hard Case	1	A017	Scope Base	1	A057	Frt and Rear Sgt Base	1
Code	Desc	Qty																
A007	With Stud	3																
A010	Hard Case	1																
A017	Scope Base	1																
A057	Frt and Rear Sgt Base	1																
Repair Search		Refresh Close																
maglet		5/31/2006 10:29 AM C4FS NUM INS SCRL																

Serial Number: **C6498866**Model: **M24 SWS****RE00113013**

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6498866.___0
FILE DATE AND TIME: 07/05/2006 08:36

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.075
The Average Y Centroid of the Five Target Set:	0.058
The Average Point of Impact of the Five Target Set:	0.095
The Average Mean Radius of the Five Target Set:	0.712
The Distance from POA to Centroid Target #1:	0.200
The Distance from Centroid Target #2 to Centroid Target #1:	0.068
The Distance from Centroid Target #3 to Centroid Target #1:	0.145
The Distance from Centroid Target #4 to Centroid Target #1:	0.231
The Distance from Centroid Target #5 to Centroid Target #1:	0.293

SERIAL NUMBER: C6498866. __0

TARGET NUMBER: 1

FILE DATE: 07/05/2006

FILE TIME: 08:36

POINT#	X	Y
1:	1.333	0.297
2:	1.097	0.463
3:	0.891	-0.216
4:	-0.346	-1.035
5:	-0.792	-0.367
6:	-0.814	0.608
7:	-0.107	1.737
8:	0.036	0.169
9:	0.139	-0.190
10:	0.270	-0.423

X CENTROID: 0.171

Y CENTROID: 0.104

POA TO CENTROID: 0.200

HORZ SPREAD: 2.147

VERT SPREAD: 2.772

GROUP SPREAD: 2.782

MIN RADIUS: 0.149

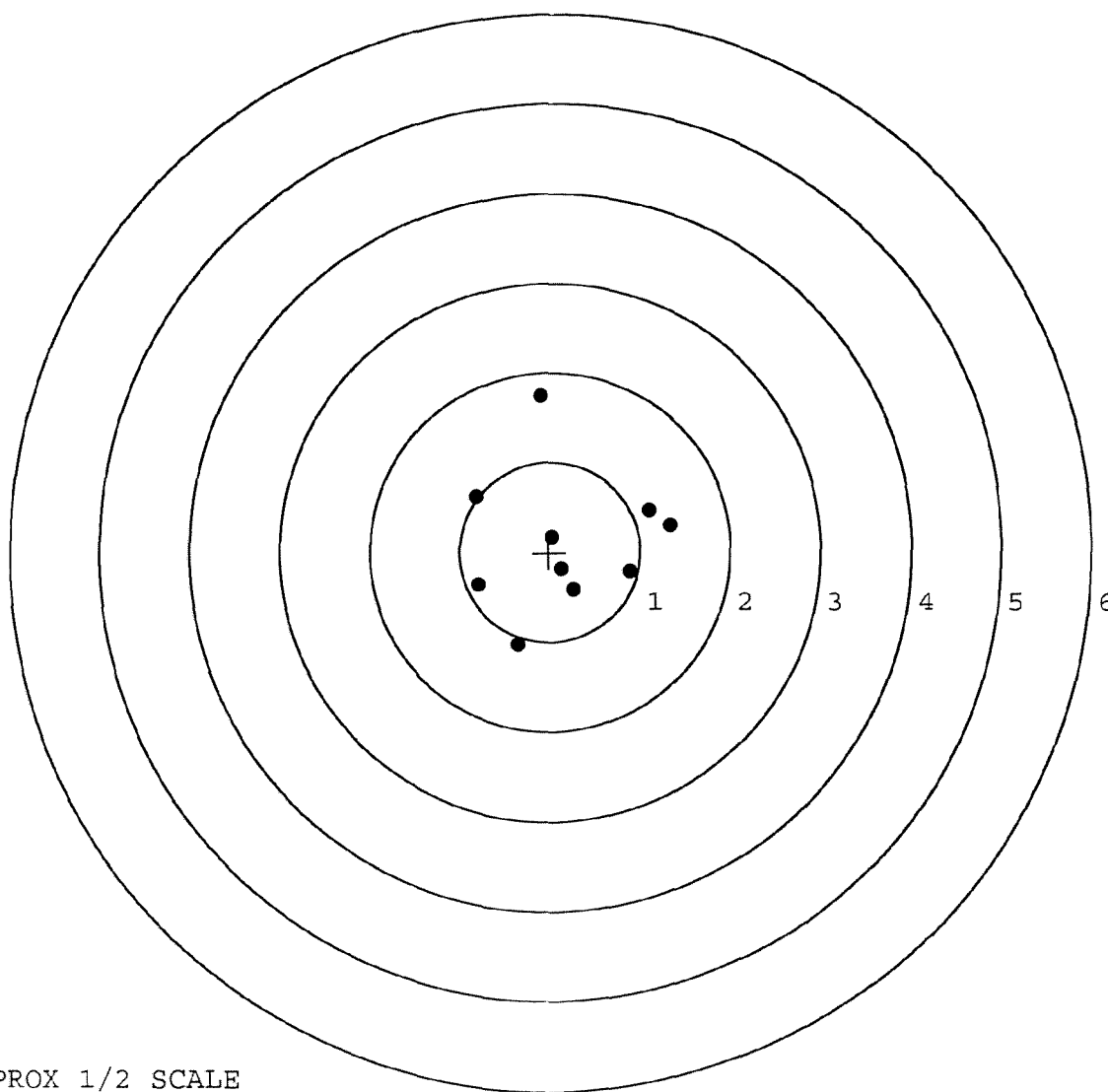
MAX RADIUS: 1.656

MEAN RADIUS: 0.903

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 5

in 3 IN DIAMETER: 9

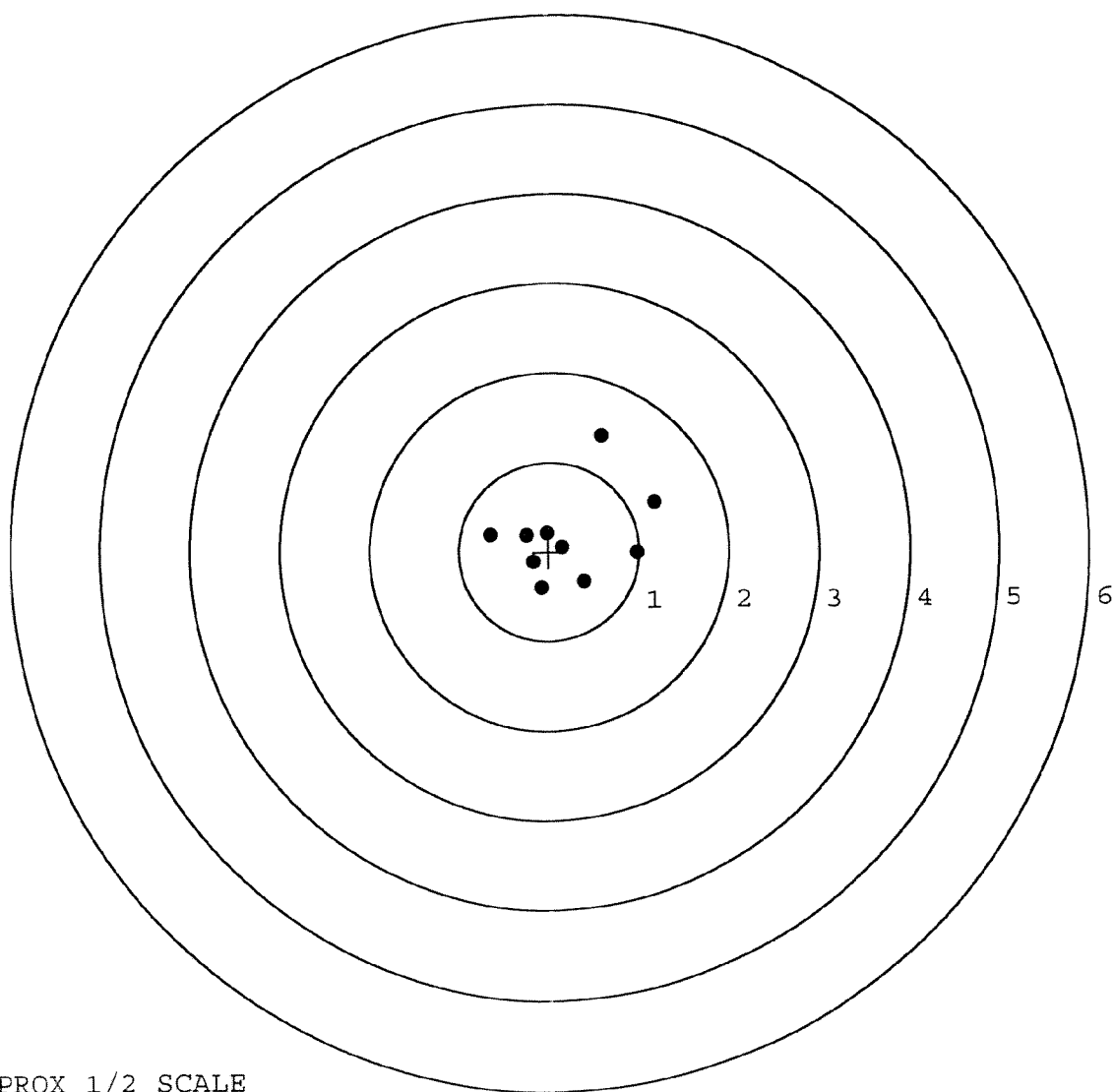


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6498866. 0
TARGET NUMBER: 2
FILE DATE: 07/05/2006
FILE TIME: 08:36

X CENTROID: 0.210
Y CENTROID: 0.159
POA TO CENTROID: 0.264
HORZ SPREAD: 1.814
VERT SPREAD: 1.698
GROUP SPREAD: 1.826
MIN RADIUS: 0.122
MAX RADIUS: 1.191
MEAN RADIUS: 0.634
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.975	-0.023
2:	1.167	0.542
3:	0.590	1.288
4:	-0.647	0.198
5:	0.393	-0.345
6:	-0.082	-0.410
7:	0.151	0.052
8:	-0.020	0.213
9:	-0.247	0.193
10:	-0.178	-0.116

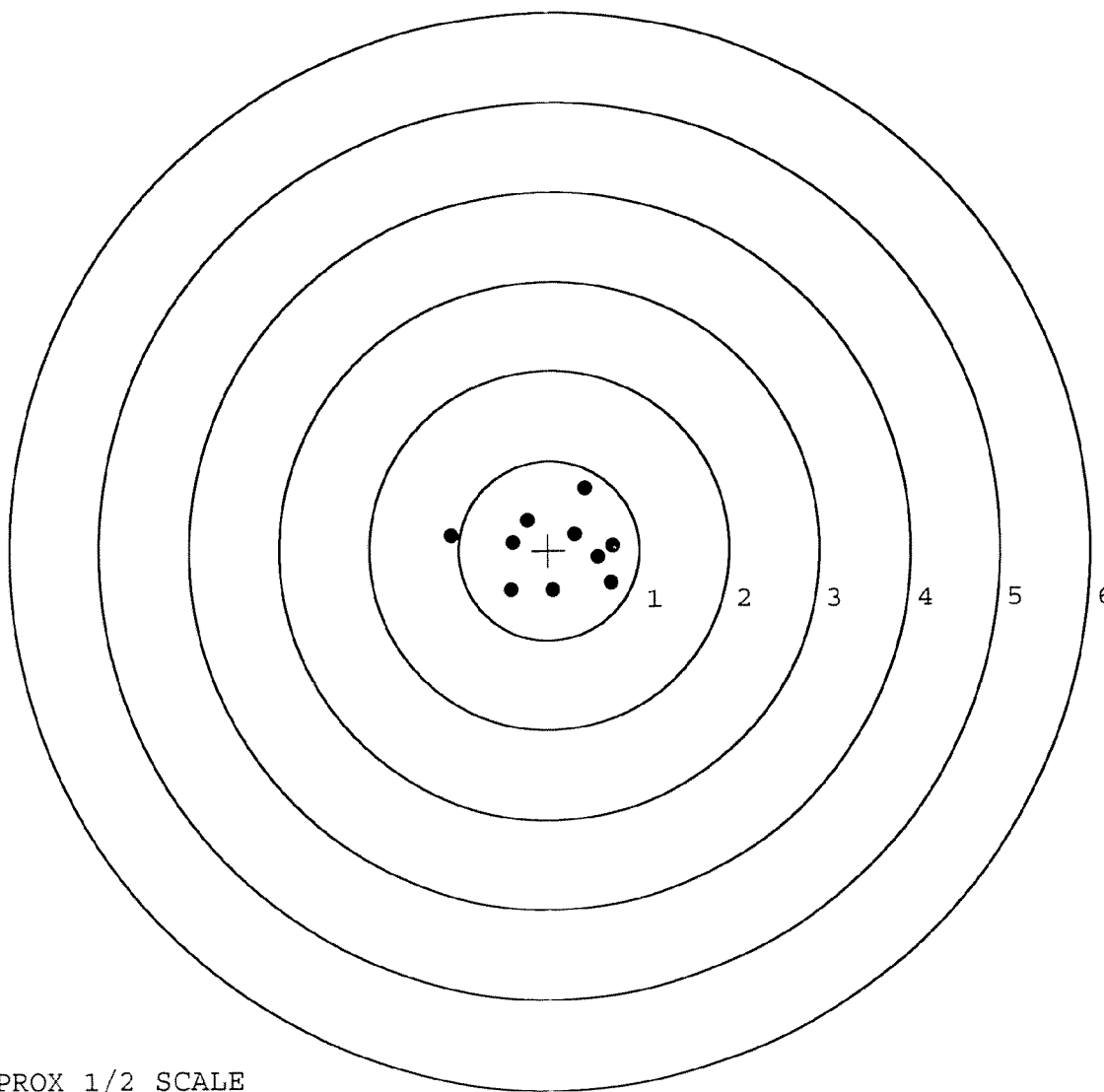


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6498866. __0
TARGET NUMBER: 3
FILE DATE: 07/05/2006
FILE TIME: 08:36

X CENTROID: 0.055
Y CENTROID: 0.016
POA TO CENTROID: 0.058
HORZ SPREAD: 1.789
VERT SPREAD: 1.141
GROUP SPREAD: 1.849
MIN RADIUS: 0.286
MAX RADIUS: 1.145
MEAN RADIUS: 0.610
IN 1 IN DIAMETER: 5
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.689	-0.371
2:	0.709	0.051
3:	0.544	-0.080
4:	0.292	0.176
5:	0.401	0.688
6:	-0.237	0.334
7:	-0.398	0.088
8:	-1.080	0.167
9:	-0.416	-0.440
10:	0.049	-0.453

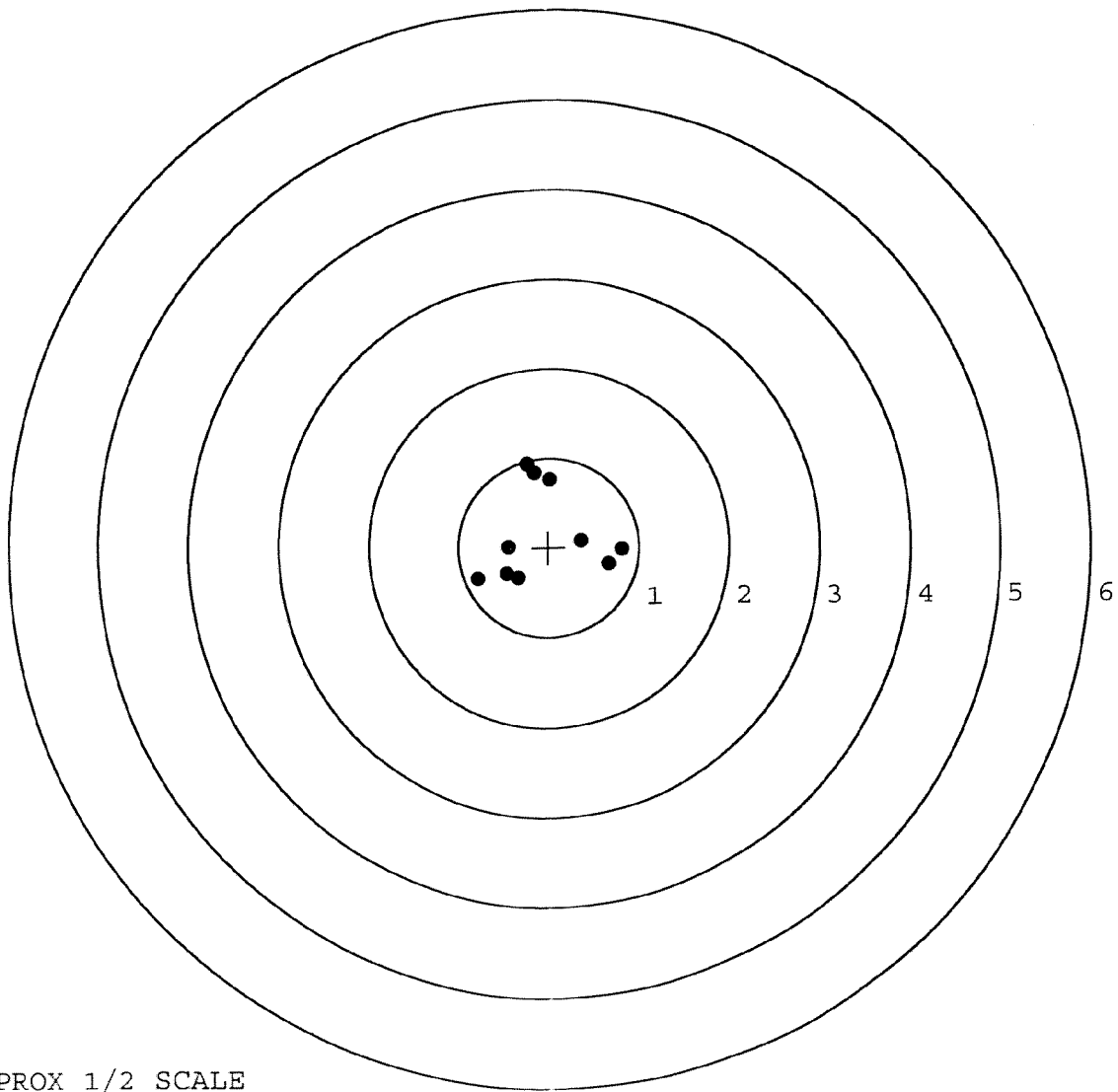


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6498866. __0
TARGET NUMBER: 4
FILE DATE: 07/05/2006
FILE TIME: 08:36

X CENTROID: -0.057
Y CENTROID: 0.140
POA TO CENTROID: 0.151
HORZ SPREAD: 1.593
VERT SPREAD: 1.284
GROUP SPREAD: 1.625
MIN RADIUS: 0.408
MAX RADIUS: 0.882
MEAN RADIUS: 0.669
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 10
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.809	-0.028
2:	0.662	-0.197
3:	0.362	0.067
4:	0.016	0.762
5:	-0.234	0.937
6:	-0.444	0.010
7:	-0.337	-0.343
8:	-0.465	-0.299
9:	-0.784	-0.347
10:	-0.156	0.835

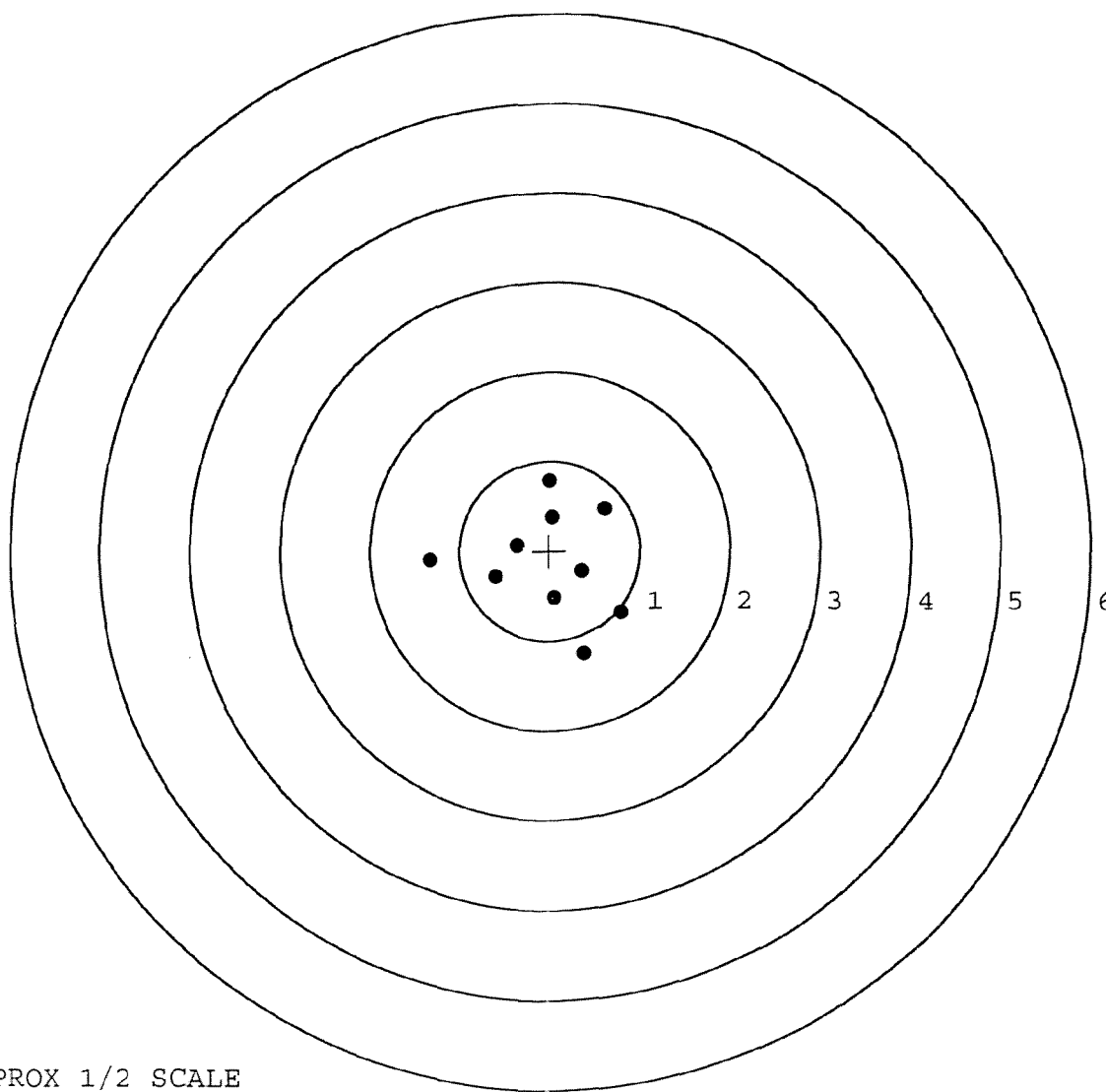


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6498866. __0
TARGET NUMBER: 5
FILE DATE: 07/05/2006
FILE TIME: 08:36

POINT#	X	Y
1:	0.791	-0.686
2:	0.390	-1.142
3:	0.364	-0.229
4:	0.056	-0.521
5:	0.607	0.468
6:	0.031	0.378
7:	-0.003	0.786
8:	-0.365	0.057
9:	-0.598	-0.290
10:	-1.324	-0.117

X CENTROID: -0.005
Y CENTROID: -0.130
POA TO CENTROID: 0.130
HORZ SPREAD: 2.115
VERT SPREAD: 1.928
GROUP SPREAD: 2.190
MIN RADIUS: 0.382
MAX RADIUS: 1.319
MEAN RADIUS: 0.745
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

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

R & E NUMBER	113013		
SERIAL NUMBER	C6498866		
LOG-IN DATE	5-30-06		
OPERATION #	OPERATION NAME	DATE	INITIAL
500	DIS-ASSEMBLE GUN	6-16-06	RTZ
505	RE-BARREL	6-20-06	RTZ
420	ASSEMBLE	6-20-06	RTZ
440	PROOF	MAGNA-FLUX INSPECTED JUN 3 2006 6-20-06	TRW
460	CHECK HEADSPACE	6-20-06	TRW
470	DIS-ASSEMBLE GUN	6-21-06	RTZ
480	MAGNAFLUX	OPERATOR <u>unab</u> 6/23/06	<u>unab</u>
510	DRILL AND TAP	6-22-06	TRW
500	ROLLMARK CALIBER	6-22-06	CW
520	GOFF BLAST BBL / REC	6-23-06	LB
530 & 540	APPLY COATINGS	6/28/06	TRW
560	FINAL ASSEMBLY	7/5/06	BLG
640	FUNCTION TEST AND	PASS FAIL 7-5-06	TRW
650	TARGET	PASS FAIL 7-5-06	TRW
	MALFUNCTION ^{25 clicks} left windage	CORRECTION adj barrel OK 7-6-06	AC
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION N/A	
	MALFUNCTION	CORRECTION	7-5-06 R.P.
670	FINAL INSPECTION	7-7-06	AC
	A) HEADSPACE	PASS FAIL 7-7-06	AC
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS N/A	
680	F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX 5 lbs 5 lbs 5 lbs AC	
	G) SAFETY OFF FORCE	2 LBS 4 lbs 4 lbs 4 lbs AC	
	I) FIRING PIN INDENT	.020 .023 .023 .023 AC	
690	PACK	7-10-06	

F006 REV 5/2006

FINAL INSPECTION CHECKLIST

BARREL ASSEMBLY _____ BARREL _____ RECEIVER _____ FRONT SIGHT BASE _____ REAR SIGHT BASE _____ SCREWS _____ FINISH	STOCK ASSEMBLY _____ STOCK _____ SLING SWIVEL STUDS _____ BUTT PATE _____ LOCK NUTS _____ BARREL CLEARANCE _____ COLOR / FINISH
SCOPE ASSEMBLY _____ SCOPE _____ SCOPE RINGS _____ MOUNTING SCREWS _____ MOUNTING BASE _____ SCREWS _____ FINISH _____ CLARITY	SYSTEM CASE _____ SCOPE CASE _____ IRON SIGHTS _____ DEPLOYMENT KIT TRIGGER ASSEMBLY _____ SAFETY OPERATION _____ RE-SET TO FACTORY SPECS
COMMENTS: _____	

F006 REV 5/2006




VERY IMPORTANT:
Instruction Book
enclosed to assure
safe use of this
firearm.

MODEL 700™

M24

SERIAL NO.

C6498866

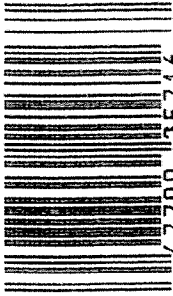
ORDER NO.

5716

MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.

Q1

UPC



0 47700 25716 7



5716 C6498866

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#
3.00# + .75#
4.00# + 1.00#

SERIAL NO. C6498866

DATE 6-5-90

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.39	2.17	2.28	2.38	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.32	2.35	2.18	2.33	
PULL #3	2.22	2.15	2.16	2.37	
PULL #4	2.20	2.21	2.21	2.27	
PULL #5	2.32	2.22	2.26	2.36	
TOTAL	11.45	11.10	11.09	11.71	
AVG.	2.25	2.22	2.218	2.342	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.36	3.15		
PULL #2	3.31	3.29		
PULL #3	3.28	3.26		
PULL #4	3.34	3.32		
PULL #5	3.27	3.30		
TOTAL	16.56	16.32		
AVG.	3.312	3.264		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.36	4.42		4.46
PULL #2	4.32	4.39		4.47
PULL #3	4.38	4.34		4.53
PULL #4	4.39	4.40		4.23
PULL #5	4.37	4.36		4.41
TOTAL	21.82	21.91		22.10
AVG.	4.364	4.382		4.42

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6498866
31 Jul 1990

CENTROIDAL DISTANCES

0 TO	1	.757388
1 TO	2	.2022
1 TO	3	1.23873
1 TO	4	.497041
1 TO	5	1.56281

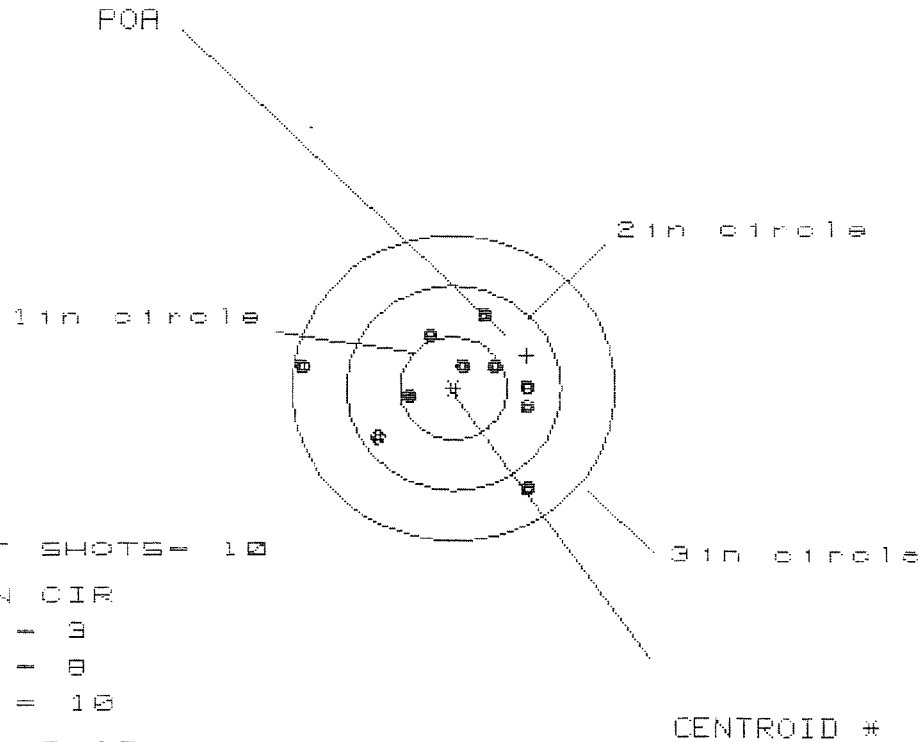
$\bar{x} = \frac{1}{n} \sum_{i=1}^n x_i$ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.071
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0698
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0995643
THE AMR FOR THIS RIFLE IS: .7786

31 Jul 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C6498866

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 3

2in = 8

3in = 10

HS= 2.184

VS= 1.707

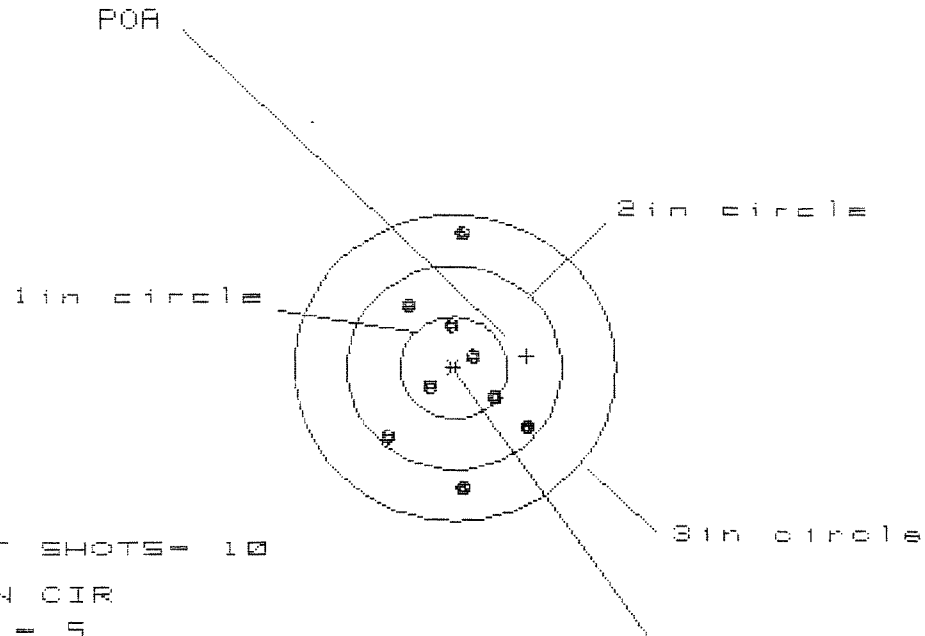
GS= 2.456

PATTERN #	:	1	2	3
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.727	.565	.626
MINIMUM X	:	-1.457	-.906	-.845
MAXIMUM Y	:	.690	.717	.593
MINIMUM Y	:	-1.017	-.990	-.623
CENTROID X	:	-.686	-.524	-.585
CENTROID Y	:	-.321	-.348	-.224
POA TO CENTROID in.	:	.757	.629	.627
MIN RADIUS	:	.220	.242	.107
MEAN RADIUS	:	.739	.639	.550
MAX RADIUS	:	1.477	1.104	1.050
HORIZONTAL SPREAD	:	2.184	1.471	1.471
VERTICAL SPREAD	:	1.707	1.707	1.216
EXTREME SPREAD	:	2.456	1.742	1.605
NUMBER IN ONE INCH CIRCLE	=	3		
NUMBER IN TWO INCH CIRCLE	=	8		
NUMBER IN THREE INCH CIRCLE	=	10		

31 Jul 1998

FILE:/PATTERNING/CENTERFIRE_PATT/0649B886

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 5

2 in = 8

3 in = 10

HS= 1.308

VS= 2.493

GS= 2.493

CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.655	.663	.678
MINIMUM X	:	-.653	-.645	-.630
MAXIMUM Y	:	1.308	.762	.632
MINIMUM Y	:	-1.187	-1.042	-.656
CENTROID X	:	-.677	-.685	-.700
CENTROID Y	:	-.119	-.264	-.134
POA TO CENTROID in.	:	.688	.735	.713
MIN RADIUS	:	.242	.261	.268
MEAN RADIUS	:	.689	.626	.552
MAX RADIUS	:	1.308	1.048	.910
HORIZONTAL SPREAD	:	1.308	1.308	1.308
VERTICAL SPREAD	:	2.493	1.804	1.288
EXTREME SPREAD	:	2.493	1.886	1.627
NUMBER IN ONE INCH CIRCLE	=		5	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	

31 Jul 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6498866

CENTERFIRE PATTERNS

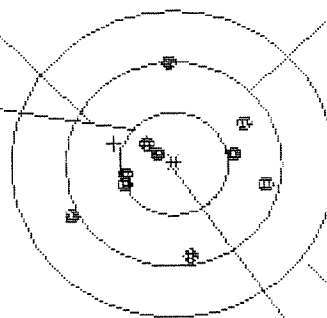
3

POA

1in circle

2in circle

3in circle



OF SHOTS- 10

IN CIR

1in = 3

2in = 8

3in = 10

HS= 1.751

VS= 1.960

GS= 1.977

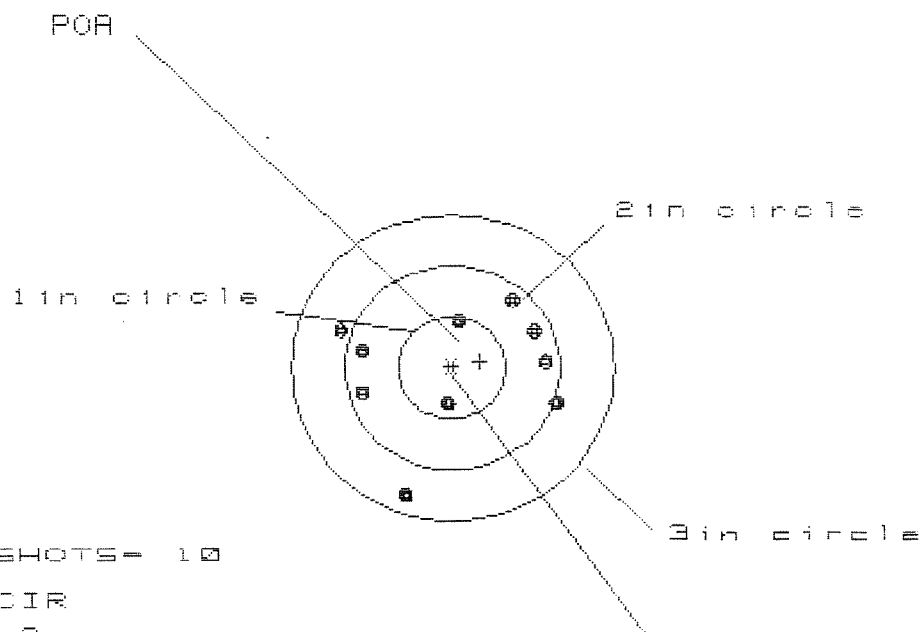
CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.833	.731	.788
MINIMUM X	:	-.918	-.554	-.577
MAXIMUM Y	:	1.050	.989	.460
MINIMUM Y	:	-.911	-.971	-.848
CENTROID X	:	.547	.649	.672
CENTROID Y	:	-.202	-.141	-.264
POA TO CENTROID in.:	:	.583	.664	.722
MIN RADIUS	:	.194	.256	.331
MEAN RADIUS	:	.663	.620	.577
MAX RADIUS	:	1.069	1.005	.849
HORIZONTAL SPREAD	:	1.751	1.285	1.285
VERTICAL SPREAD	:	1.960	1.960	1.308
EXTREME SPREAD	:	1.977	1.977	1.380
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	

31 Jul 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6498866

CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1in = 2

2in = 7

3in = 10

HS= 2.014

VS= 1.806

GS= 2.177

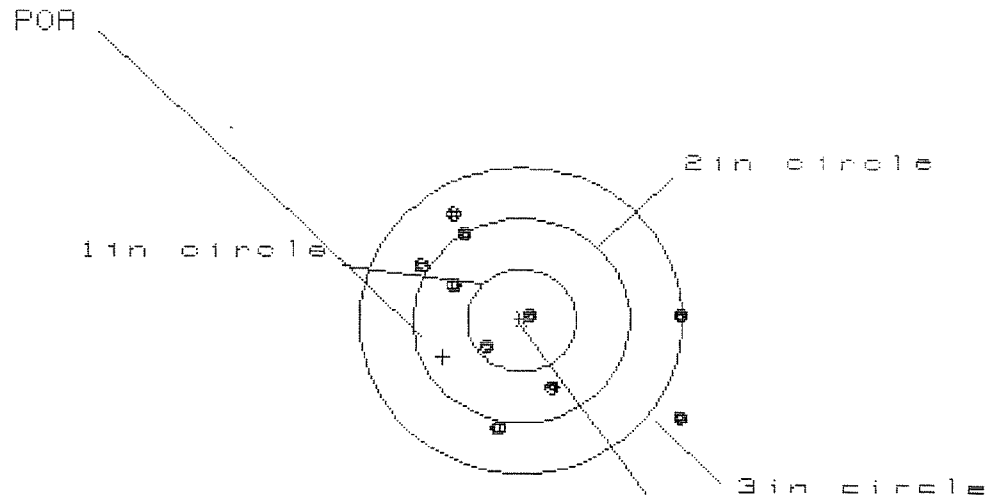
CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.961	.910	.772
MINIMUM X	:	-1.053	-1.104	-1.031
MAXIMUM Y	:	.670	.532	.564
MINIMUM Y	:	-1.236	-.517	-.485
CENTROID X	:	-.263	-.212	-.074
CENTROID Y	:	-.060	.078	.046
POA TO CENTROID in.	:	.270	.226	.087
MIN RADIUS	:	.326	.342	.406
MEAN RADIUS	:	.860	.794	.735
MAX RADIUS	:	1.319	1.132	1.079
HORIZONTAL SPREAD	:	2.014	2.014	1.803
VERTICAL SPREAD	:	1.906	1.049	1.049
EXTREME SPREAD	:	2.177	2.155	1.894
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

31 Jul 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C649B866

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 2

2in = 4

3in = 9

HM = 0.359

VS = 2.060

GS = 2.827

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.446	1.606	.643
MINIMUM X	:	-.913	-.753	-.553
MAXIMUM Y	:	1.055	.953	.947
MINIMUM Y	:	-1.005	-1.107	-1.113
CENTROID X	:	.724	.564	.364
CENTROID Y	:	.353	.455	.461
POA TO CENTROID in.	:	.806	.725	.587
MIN RADIUS	:	.071	.230	.325
MEAN RADIUS	:	.942	.838	.716
MAX RADIUS	:	1.706	1.606	1.124
HORIZONTAL SPREAD	:	2.359	2.359	1.196
VERTICAL SPREAD	:	2.060	2.060	2.060
EXTREME SPREAD	:	2.827	2.413	2.095
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		9	

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6498866

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	5 9	90	RW
600	Proof	5 9	90	RW
607	Check Headspace	5 9	90	RW
610	Dis-assemble Gun	5 9	90	RW
612	Magnaflux Barrel Action	5-15-90		KER
	Magnaflux Bolt	5-15-90		KER
615	Rollmark Caliber	5-15-90		ES
617	Drill and Tap Sight Holes		5/17/90	FB
618	Polish Barrel RB		5/17/90	WB
620	Apply Coatings (Barrel Action)		5-25-90	TJA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		5/30/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/30/90	RW
	C) Inspect Ejector Hole for Chamfer		5/30/90	RW
	D) Oil Firing Pin Ass'y		5/30/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		6-5-90	ML

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	3 1/2	3 1/2	3 1/2			6/7/90	WB
	G) Safety Off Force	2	2	2			6/7/90	WB
	H) Trigger Pull Test & Retainability						6-5-90	RL
	I) Firing Pin Indent	.024	.0235	.0235			6/7/90	WB
	J) Assemble Stock						7/16/90	RW
	K) Assemble Swivel Studs						8/29/90	QAS
	L) Attach Front and Rear Sight Assemblies						7/16/90	RW
	M) Iron Sight Alignment						7/16/90	RW
	N) Detach Front & Rear Sights & place in numbered container						7/16/90	RW
	O) Attach Scope to Rifle						7/27/90	RL
	P) Detach & Attach Scope 20 Times						7/27/90	RL
640	Gallery Target & Test						7-31-90	DH
	A) Time						7-31-90	DH
	B) Malfunctions						7-31-90	DH
	C) Pierced Primers						7-31-90	DH
	D) Optical Clarity of Scope						7-31-90	DH
645	Inspect for Live Ammo						7-31-90	DH
655	Final Inspection							
	A) Headspace						8/29/90	QAS
	B) Trigger Pull	2.38	2.33	2.37	2.27	2.36	8/22/90	RL
	C) Function						8/29/90	QAS
660	Pack						9/19/90	RF