

C6594493

MODEL 760™ M24

Model **S&S**™

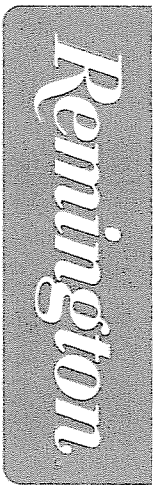
Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



File Add Repair Estimate Repair Expedite Repair Inquiry Repair Tools CSR Tools Reports Table Maintenance System Maintenance Help

Repair Number: **RE00080429** Serial: C6594493 Model M24 SWS Center Fire Caliber: 7.62 NATO Repairman: Status: Closed 4/29/2004 10:41:24 AM

Verify Repair: **High Priority**

Address Information

Customer: Received From: Return To: Received From:

Name: TMO 436 APS TRTD FB 4497 TMO 436 APS TRTD FB 4497

Address 1: 505 ATLANTIC ST 505 ATLANTIC ST

Address 2: PO Box: PO Box:

City: DOVER AFB DOVER AFB

State: DE Zip Code: 19902 Country: US State: DE Zip Code: 19902 Country: US

FFL:

Contact / Condition Problems Estimate History / Status Shipping / Billing

Contact Information

Phone: Fax: Email: Comments:

Received Condition

Fair

Condition Notes: CSR Notes:

Accessories Received

Code	Desc	Qty
A010	Hard Case	1
A026	Scope w/case	1
A055	Deployment Kit	1

Repair Search Refresh Close

hagletj 4/29/2004 11:23 AM CAPS NUM INS SCPL

start 2 5 2

Serial Number: **C6594493**

Model: **M24 SWS**



RE00080429

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6594493.___0

FILE DATE AND TIME: 05/24/2004 06:27

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.016
The Average Y Centroid of the Five Target Set:	-0.114
The Average Point of Impact of the Five Target Set:	0.115
The Average Mean Radius of the Five Target Set:	0.945
The Distance from POA to Centroid Target #1:	0.253
The Distance from Centroid Target #2 to Centroid Target #1:	0.335
The Distance from Centroid Target #3 to Centroid Target #1:	0.229
The Distance from Centroid Target #4 to Centroid Target #1:	0.328
The Distance from Centroid Target #5 to Centroid Target #1:	0.535

SERIAL NUMBER: C6594493. __0

TARGET NUMBER: 1

FILE DATE: 05/24/2004

FILE TIME: 06:27

X CENTROID: -0.195

Y CENTROID: -0.161

POA TO CENTROID: 0.253

HORZ SPREAD: 2.298

VERT SPREAD: 2.797

GROUP SPREAD: 3.383

MIN RADIUS: 0.245

MAX RADIUS: 1.939

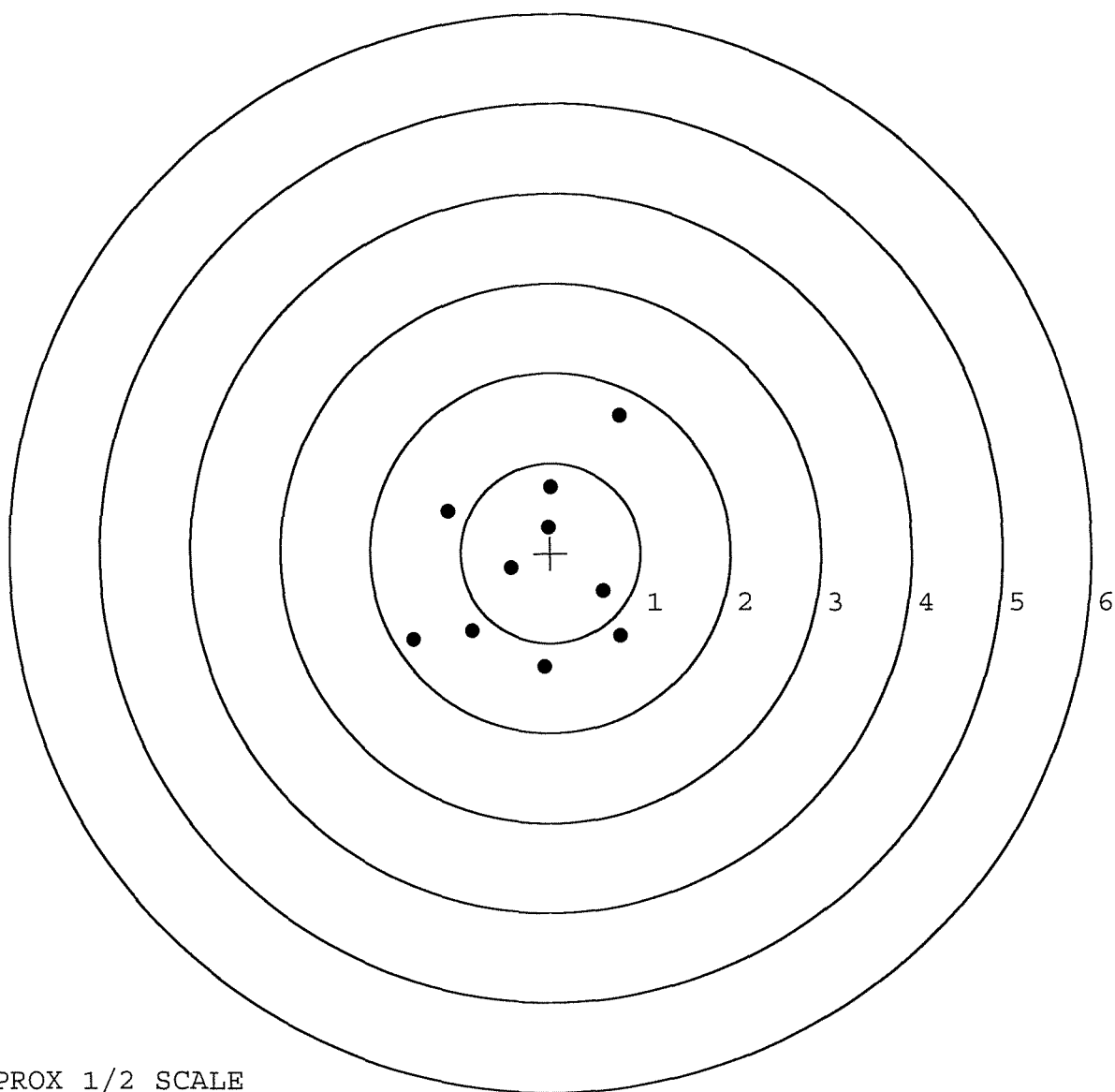
MEAN RADIUS: 1.043

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 5

in 3 IN DIAMETER: 8

POINT#	X	Y
1:	-0.070	-1.272
2:	-0.869	-0.868
3:	-1.520	-0.973
4:	-0.440	-0.168
5:	-1.144	0.468
6:	0.778	-0.922
7:	0.585	-0.423
8:	-0.025	0.288
9:	-0.006	0.735
10:	0.762	1.525



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6594493. __0

TARGET NUMBER: 2

FILE DATE: 05/24/2004

FILE TIME: 06:27

X CENTROID: -0.084

Y CENTROID: 0.156

POA TO CENTROID: 0.177

HORZ SPREAD: 2.017

VERT SPREAD: 3.017

GROUP SPREAD: 3.034

MIN RADIUS: 0.320

MAX RADIUS: 1.650

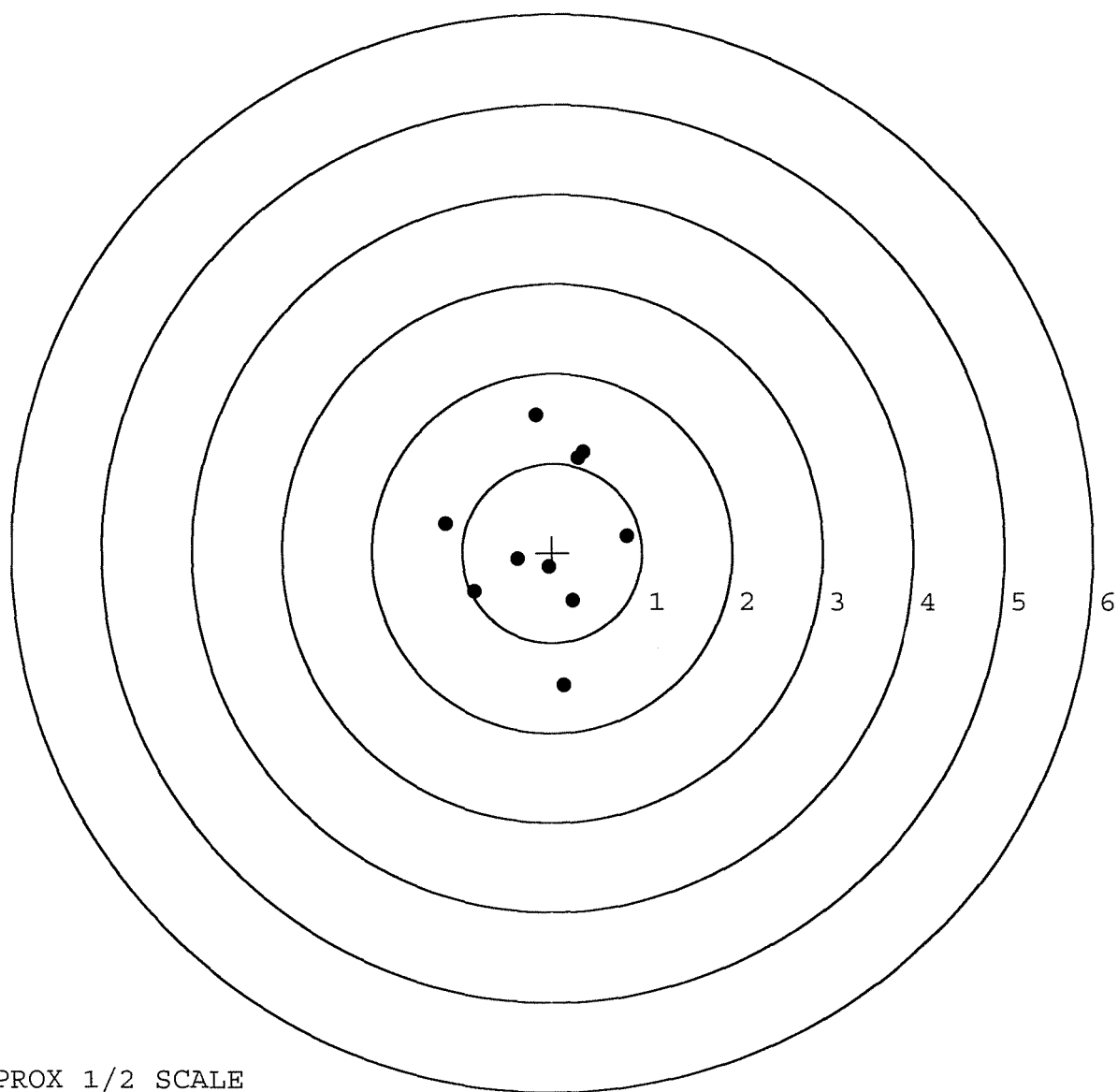
MEAN RADIUS: 0.955

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 9

POINT#	X	Y
1:	0.832	0.187
2:	0.286	1.065
3:	0.345	1.131
4:	-0.189	1.537
5:	-1.185	0.324
6:	-0.392	-0.073
7:	-0.044	-0.162
8:	0.230	-0.534
9:	-0.860	-0.440
10:	0.134	-1.480



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6594493. __0

TARGET NUMBER: 3

FILE DATE: 05/24/2004

FILE TIME: 06:27

X CENTROID: -0.120

Y CENTROID: -0.377

POA TO CENTROID: 0.395

HORZ SPREAD: 2.077

VERT SPREAD: 2.084

GROUP SPREAD: 2.078

MIN RADIUS: 0.327

MAX RADIUS: 1.198

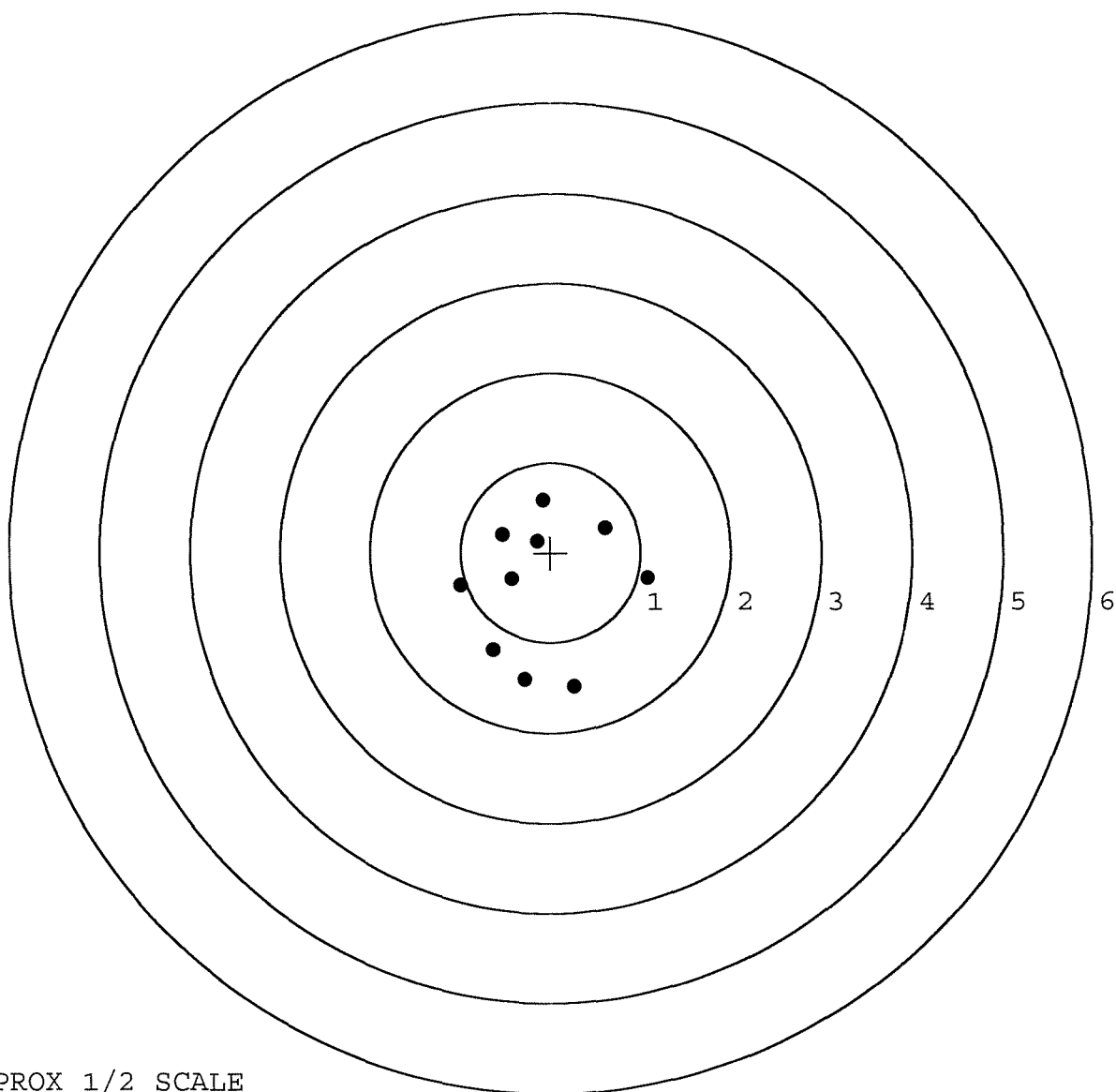
MEAN RADIUS: 0.869

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	1.076	-0.293
2:	0.612	0.277
3:	0.263	-1.498
4:	-0.291	-1.417
5:	-0.642	-1.088
6:	-1.001	-0.363
7:	-0.437	-0.300
8:	-0.534	0.201
9:	-0.151	0.127
10:	-0.090	0.586



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6594493. __0

TARGET NUMBER: 4

FILE DATE: 05/24/2004

FILE TIME: 06:27

X CENTROID: 0.079

Y CENTROID: -0.342

POA TO CENTROID: 0.351

HORZ SPREAD: 2.209

VERT SPREAD: 2.199

GROUP SPREAD: 2.276

MIN RADIUS: 0.335

MAX RADIUS: 1.318

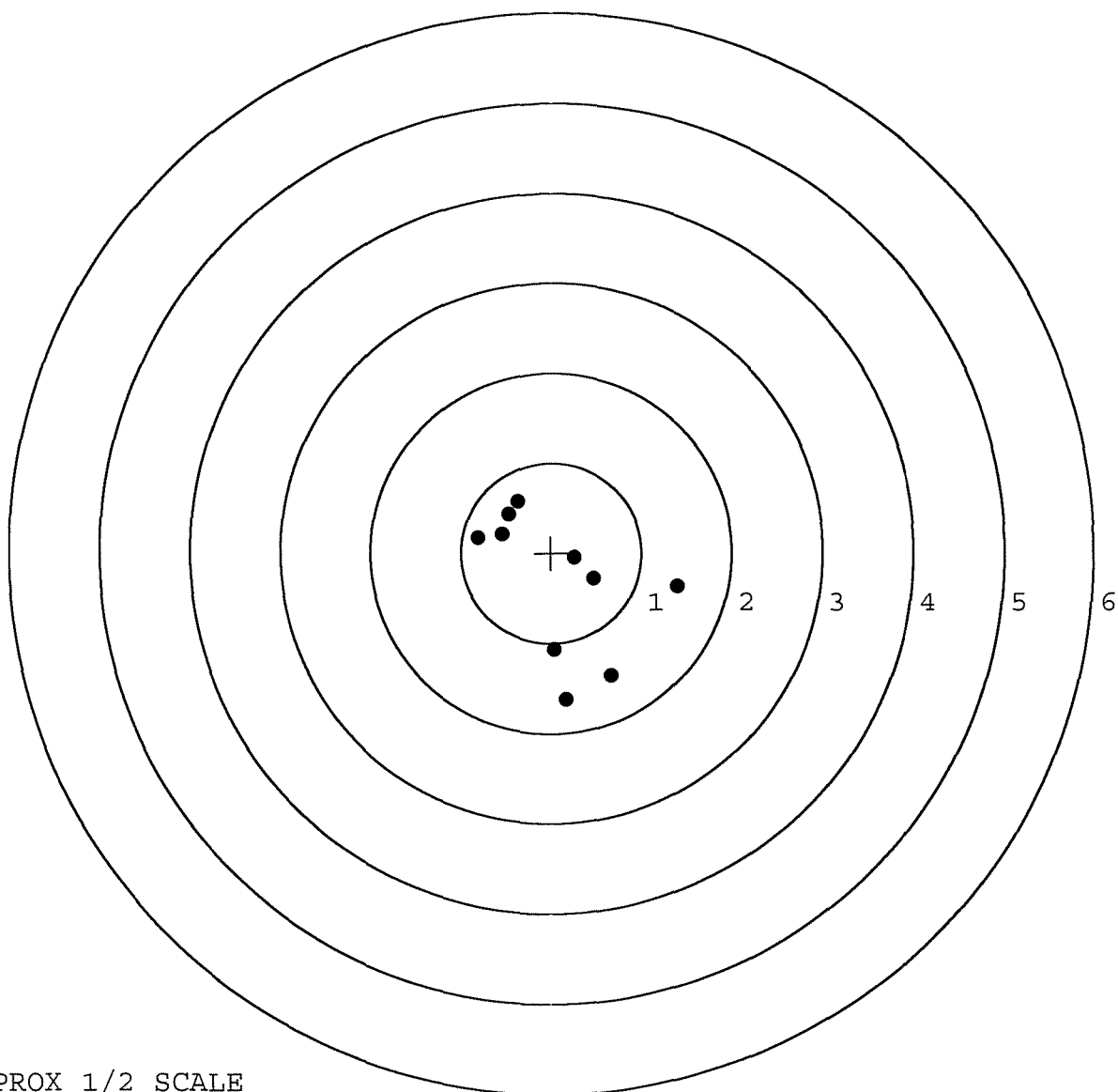
MEAN RADIUS: 0.908

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 5

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	1.397	-0.376
2:	0.672	-1.365
3:	0.172	-1.630
4:	0.037	-1.076
5:	0.468	-0.288
6:	0.257	-0.057
7:	-0.376	0.569
8:	-0.479	0.427
9:	-0.543	0.210
10:	-0.812	0.171



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6594493. __0

TARGET NUMBER: 5

FILE DATE: 05/24/2004

FILE TIME: 06:27

X CENTROID: 0.238

Y CENTROID: 0.154

POA TO CENTROID: 0.283

HORZ SPREAD: 2.011

VERT SPREAD: 3.203

GROUP SPREAD: 3.665

MIN RADIUS: 0.326

MAX RADIUS: 2.033

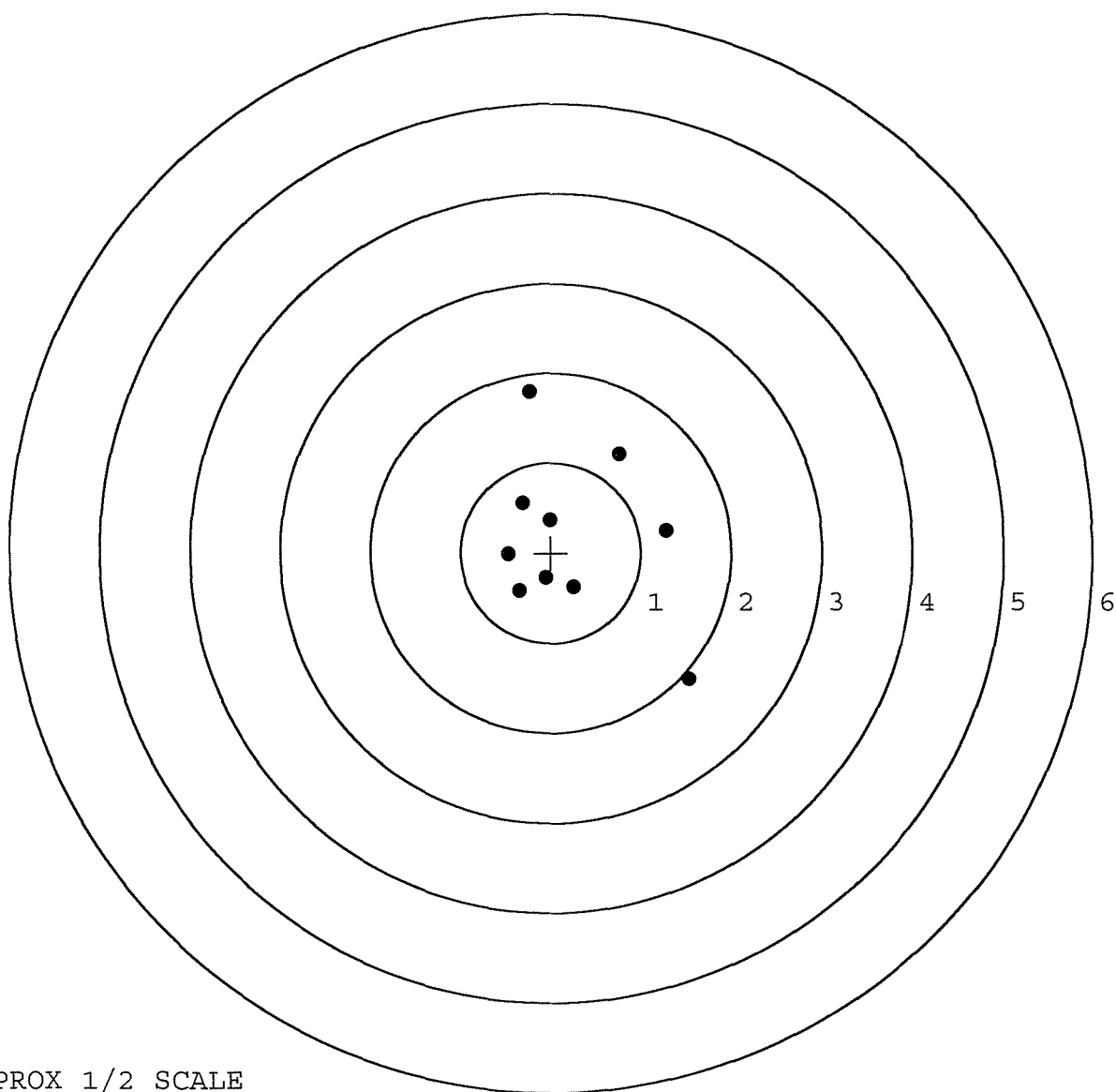
MEAN RADIUS: 0.950

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 8

POINT#	X	Y
1:	1.536	-1.410
2:	1.284	0.239
3:	0.756	1.099
4:	-0.245	1.793
5:	-0.315	0.553
6:	-0.010	0.366
7:	0.260	-0.386
8:	-0.066	-0.279
9:	-0.349	-0.423
10:	-0.475	-0.014



TARGET APPROX 1/2 SCALE

SERIAL # C6594493 INSPECTED BY: RTL
DATE REC'D: 4-29-04 DATE RET'D: 6-7-04

ITEM

BARREL ASSEMBLY

/ BARREL
/ RECEIVER
/ FRONT SIGHT BASE
/ REAR SIGHT BASE
/ SCREWS
/ FINISH

SCOPE ASSEMBLY

/ SCOPE
/ SCOPE RINGS
/ MOUNTING SCREWS
/ MOUNTING BASE
/ SCREWS
/ FINISH
/ CLARITY

ITEM

STOCK ASSEMBLY

/ STOCK
/ SLING AWIVEL STUDS
/ ADJUSTABLE
/ BUTT PLATE
/ LOCK NUTS
/ BARREL CLEARANCE
/ COLOR / FINISH

SYSTEMS CASE

/ SCOPE CASE
/ IRON SIGHTS
/ DEPLOYMENT KIT

TRIGGER ASSEMBLY

/ SAFETY OPERATION
/ RE-SET TO FACTORY SPECS

COMMENTS:

R & E NUMBER	80429		
SERIAL NUMBER	C-6594493		
LOG-IN DATE	4-29-04		
INSPECT AND VERIFY:			
OPERATION #	OPERATION NAME	DATE	INITIAL
550	DIS-ASSEMBLE GUN	5-3-04	RTL
560 A	RE-BARREL	5-4-04	RTL
B	DRILL AND TAP	5-5-04	TRW
575	ASSEMBLE	5-4-04	RTL
600	PROOF	5-4-04	RTL
605	CHECK HEADSPACE	5-4-04	RTL
610	DIS-ASSEMBLE GUN	5-4-04	RTL
612	MAGNAFLUX		
615	ROLLMARK CALIBER	5/6/04	NB
618	ROTO-BLAST	5/7/04	ND
620	APPLY COATINGS	5-10	TA
625 A	FINAL ASSEMBLY	5-11-04	RTL
B	TRIGGER PULL TEST		
C	SAFETY "ON" FORCE		
D	SAFETY "OFF" FORCE		
E	FIRING PIN INDENT		
640	TARGET	5-24-04	TRW
655	FINAL INSPECT	6-7-04	RTL
660	PACK	6-8-04	DA
		SHIP DATE	
QAR INSPECTION DATE			



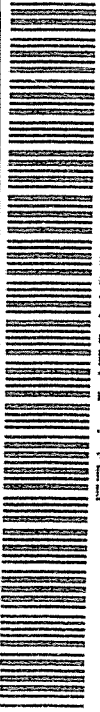

VERY IMPORTANT:
Instruction Book
enclosed to assure
safe use of this
firearm.

MODEL 700™ H24

SERIAL NO.
C6594493

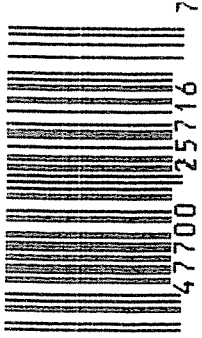
ORDER NO.
5716

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



5716 C6594493

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6594493

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		10/30/90	Kd
600	Proof		10/30/90	Kd
607	Check Headspace		10/30/90	Kd
610	Dis-assemble Gun		10/30/90	Kd
612	Magnaflux Barrel Action		11/1/90	Kcd
	Magnaflux Bolt		11/1/90	Kcd
615	Rollmark Caliber		11/1/90	GS
617	Drill and Tap Sight Holes		11/6/90	K-B
618	Polish Barrel <i>PB</i>		11/7/90	WS
620	Apply Coatings (Barrel Action)		11-26-90	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		11-26-90	DH
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		11-26-90	DH
	C) Inspect Ejector Hole for Chamfer		11-26-90	DH
	D) Oil Firing Pin Ass'y		12-26-90	DH
	E) Adjust Trigger Pull to Min Setting and Stake		11/8/90	FH

op. #	OP. NAME	READINGS			DATE	INIT
625 cont.	F) Safety On Force	4	3.5	3.5	12/8/90	RW
	G) Safety Off Force	2.5	2.5	2	12/8/90	RW
	H) Trigger Pull Test & Retainability				12/8/90	SL
	I) Firing Pin Indent	.0205	.020	.0205	12/8/90	RW
	J) Assemble Stock				12/8/90	KS
	K) Assemble Swivel Studs				12-12-90	JS
	L) Attach Front and Rear Sight Assemblies				12/8/90	KS
	M) Iron Sight Alignment				14/8/90	KS
	N) Detach Front & Rear Sights & place in numbered container				12/8/90	KS
	O) Attach Scope to Rifle				12/8/90	KS
	P) Detach & Attach Scope 20 Times				12/8/90	KS
640	Gallery Target & Test				12/11/90	NF
	A) Time				"	NF
	B) Malfunctions				"	NF
	C) Pierced Primers				"	NF
	D) Optical Clarity of Scope				"	NF
645	Inspect for Live Ammo				12/11/90	NF
655	Final Inspection					
	A) Headspace				12-12-90	JS
	B) Trigger Pull	2.65	2.61	2.59	12-12-90	JS
	C) Function				12-12-90	JS
660	Pack				12-17-90	DH

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6594493

DATE 12/8/90

TESTER JM

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.30	2.42	2.31	265	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.22	2.30	2.38	261	
PULL #3	2.38	2.40	2.40	259	
PULL #4	2.28	2.38	2.42	259	
PULL #5	2.43	2.42	2.39	256	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.44	3.40		
PULL #2	3.43	3.43		
PULL #3	3.40	3.39		
PULL #4	3.41	3.37		
PULL #5	3.38	3.20		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.39	4.42		4.42
PULL #2	4.39	4.39		4.40
PULL #3	4.46	4.39		4.37
PULL #4	4.30	4.40		4.36
PULL #5	4.48	4.43		4.46
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6594493
11 Dec 1990

CENTROIDAL DISTANCES

0 TO	1	.252
1 TO	2	.491171
1 TO	3	.231795
1 TO	4	.200564
1 TO	5	.329874

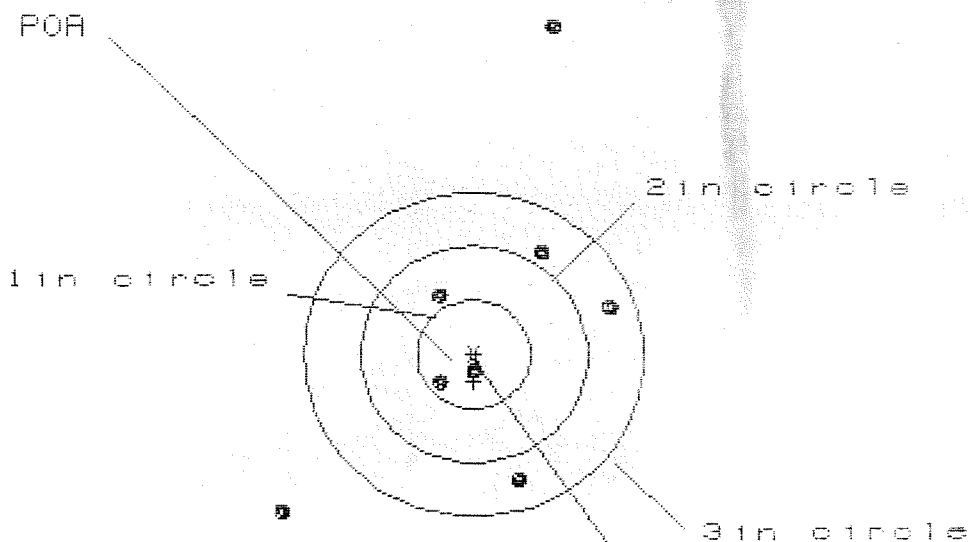
$\bar{x}_2$ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0208
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0266
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0337668
THE AMR FOR THIS RIFLE IS: 1.036

11 Dec 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6594493

CENTERFIRE PATTERNS # 1



OF SHOTS - 10

IN CIR

1in = 3

2in = 4

3in = 7

HS= 2.849

VS= 4.928

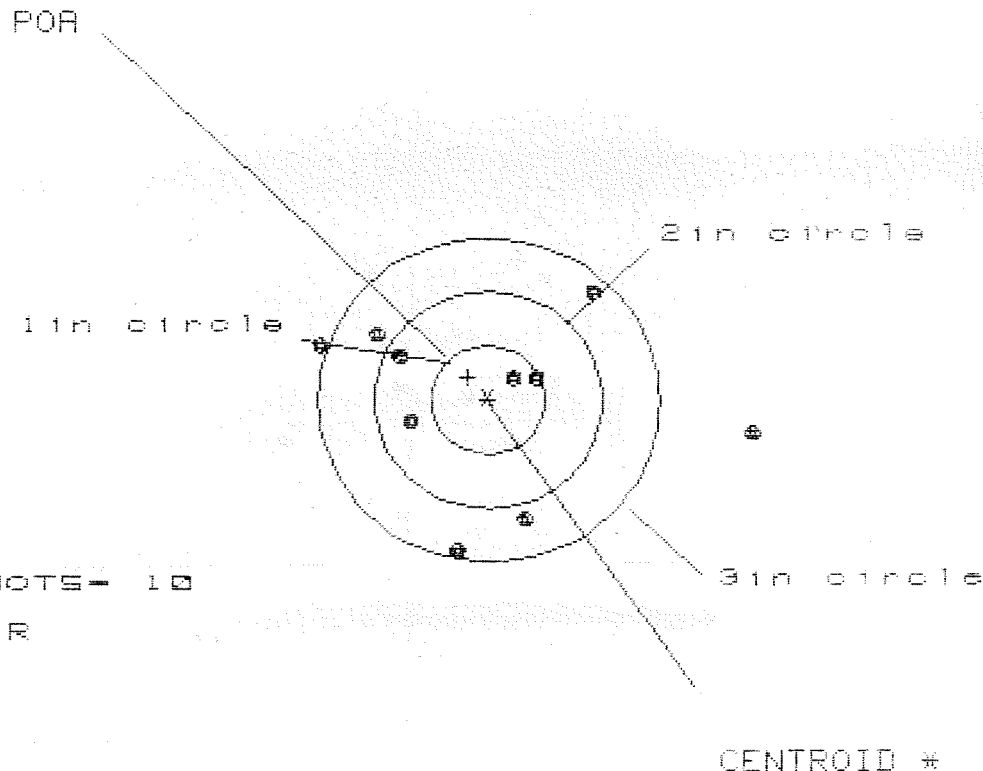
GS= 5.104

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.152	1.231	1.028
MINIMUM X	:	-1.697	-1.618	-.745
MAXIMUM Y	:	3.034	1.325	1.192
MINIMUM Y	:	-1.894	-1.557	-1.690
CENTROID X	:	.000	-.079	.124
CENTROID Y	:	.252	-.085	.049
POA TO CENTROID in.	:	.252	.115	.133
MIN RADIUS	:	.125	.169	.103
MEAN RADIUS	:	1.213	.997	.842
MAX RADIUS	:	3.115	1.938	1.847
HORIZONTAL SPREAD	:	2.849	2.849	1.773
VERTICAL SPREAD	:	4.928	2.882	2.882
EXTREME SPREAD	:	5.104	3.380	3.119
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		7	

11 Dec 1998

FILE:/PATTERNING/CENTERFIRE_PATT/08594493

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 2

2in = 4

3in = 8

HS= 3.816

VS= 2.406

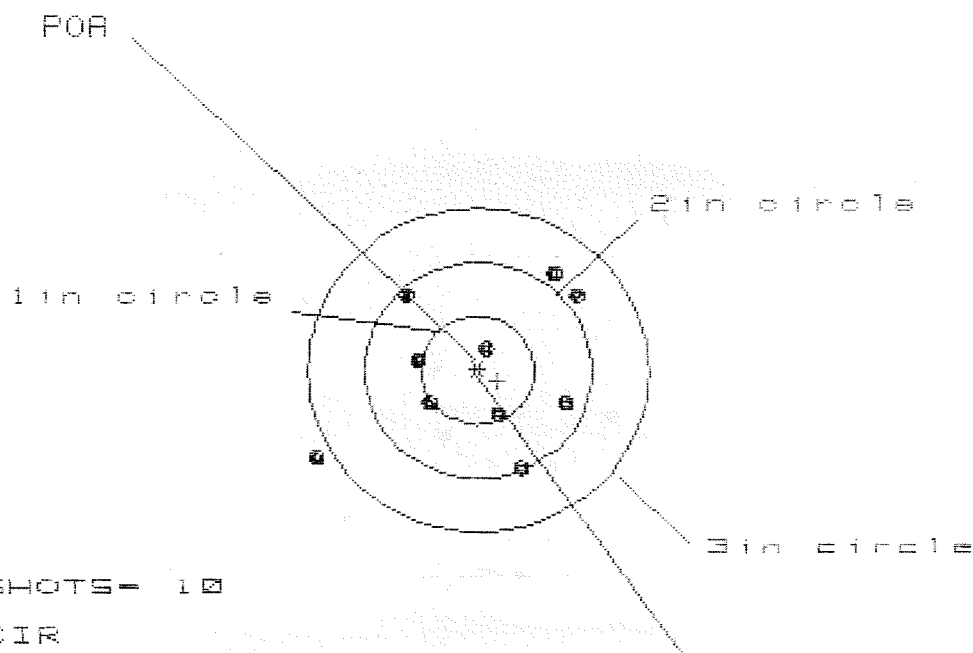
GS= 3.899

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.337	1.150	.998
MINIMUM X	:	-1.479	-1.219	-.867
MAXIMUM Y	:	.989	.957	1.018
MINIMUM Y	:	-1.417	-1.449	-1.389
CENTROID X	:	.180	-.080	.072
CENTROID Y	:	-.205	-.173	-.233
POA TO CENTROID in.	:	.272	.191	.244
MIN RADIUS	:	.304	.437	.403
MEAN RADIUS	:	1.137	.975	.931
MAX RADIUS	:	2.355	1.496	1.425
HORIZONTAL SPREAD	:	3.816	2.369	1.865
VERTICAL SPREAD	:	2.406	2.406	2.406
EXTREME SPREAD	:	3.899	2.684	2.684
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	

11 Dec 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C8594493

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1in = 3

2in = 7

3in = 9

HS= 2.286

VS= 1.742

GS= 2.686

CENTROID #

PATTERN #	3	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.882	.726	.737
MINIMUM X	-1.404	-.775	-.684
MAXIMUM Y	.864	.780	.851
MINIMUM Y	-.878	-.962	-.891
CENTROID X	-.175	-.019	-.110
CENTROID Y	.100	.184	.113
POA TO CENTROID in.	.202	.185	.158
MIN RADIUS	.233	.167	.211
MEAN RADIUS	.817	.725	.686
MAX RADIUS	1.596	.984	1.041
HORIZONTAL SPREAD	2.286	1.501	1.421
VERTICAL SPREAD	1.742	1.742	1.742
EXTREME SPREAD	2.686	1.846	1.846
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	9		

RECEIVING AND ESTIMATING REPORT

R 96-21855

W/LEUPOLD 10X SCOPE

INITIAL
JJM

CUSTOMER ORDER NO.

DATE RECEIVED

DATE OPENED

DATE CODE

SERIAL NUMBER

NEW SERIAL NUMBER

MODEL AND GRADE

10/03/96

10/03/96

RK 11-90

C6594493

700

7.62

NATO

ACCESSORIES

W/STUDS

W/SWIVELS

SCOPE BASE

Scope # 90-0669

FROM:

TRANSPORTATION OFFICER
ANNISTON ARMY DEPOT
ANNISTON

AL 36201

SHIP TO:

TRANSPORTATION OFFICER
ANNISTON ARMY DEPOT
ANNISTONAL
36201

CUST NO: 150939 C.O.D.L

ACCOUNT NUMBER

ACCOUNT NUMBER N/C

WRITE ☐

PROM. DATE

ESTIMATED

VIA

UPS

GUN CONDITION

- ☐ NEW
☐ LIGHTLY WORN
☐ WORN
☐ VERY WORN
☐ UNREPAIRABLE
☐ MARRED

REPAIR CHARGE

EXCISE

TAX

INSURANCE

UPS

PARCEL POST

TOTAL

CUSTOMER CONCERN

AMMO

FUNCTION

FINISH

ACCURACY

FIT

INSPECT

CYCLE

A1

B1

TRIGGER GROUP

B2

E1

F1

BOLT ASSY.

B3

E2

F2

BARREL ASSY.

B4

D1

E3

F3

REC. ASSY.

B5

D2

E4

F4

WOOD

C1

D3

E5

F5

METAL

C2

MAIN FAULT

PARTS

COMMENTS

✓ Trigger Assy - 96024
✓ Front Sight Assy - 96118
✓ Rear ll ll - 96119

Scope sent back to Factory
for inspec.

REPAIRMAN

PROOF

CLEAN

TEST

TARGET

PATTERN

GALLERY TESTER

DATE

DATE

DATE

DATE

DATE

OFFICE COPY

RD6925 REV. 6/96

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER

M2400018133

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50#+ .50#

3.00#+ .75#

4.00#+1.00#

SERIAL NO. C6594493

DATE 4-14-97

TESTER EK

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#	COMMENTS
PULL #1	2.56	2.57	2.66	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.55	2.30	2.57	
PULL #3	2.56	2.52	2.54	
PULL #4	2.50	2.61	2.16	
PULL #5	2.56	2.54	2.58	
TOTAL	12.73	12.54	12.51	
AVG.	2.55	2.51	2.50	

	3.00# INITIAL	3.00# AFTER 20 CYCLES	COMMENTS
PULL #1	3.34	3.46	
PULL #2	3.37	3.37	
PULL #3	3.36	2.94	
PULL #4	3.40	2.61	
PULL #5	3.41	3.25	
TOTAL	16.88	15.63	
AVG.	3.38	3.13	

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.03	3.97		4.18
PULL #2	4.07	3.97		4.24
PULL #3	4.07	4.14		4.22
PULL #4	3.79	3.69		4.23
PULL #5	4.06	4.08		4.24
TOTAL	20.02	19.85		21.11
AVG.	4.00	3.97		4.22

21 DAY TURN - AROUND

M-24

CONTRACT # DAAA09-92-C-0834

R&E NO.

SERIAL NO.

C6594493

LOG IN DATE: / /

DATE

INIT.

INSPECT & VERIFY:

OP. #

OP. NAME

550

DIS-ASSEMBLE GUN

560 A

RE-BARREL AT CUSTOM SHOP

B

DRILL & TAP

C

POLISH

575

ASSEMBLE

600

PROOF

605

CHECK HEADSPACE

610

DIS-ASSEMBLE

612

MAGNAFLUX

615

ROLLMARK CALIBER

618

ROTO-BLAST

620

APPLY COATINGS

625 A

FINAL ASSEMBLY

B

TRIGGER PULL TEST

2.85

2.68

2.61

2.62

2.63

C

SAFETY ON FORCE

4

4

4

D

SAFETY OFF FORCE

2.5

2

2

E

FIRING PIN INDENT

640

TARGET

655

FINAL INSPECT

6/18/97

Per

660

PACK

QAR INSPECTION

SHIP DATE

Final Inspection

Sn: C6594423

DATE REC'D: 11/3/96

DATE RET'D:

Auditor: RW

Item:

Barrel Assy.

☒ BARREL☒ RECEIVER☒ FRONT SIGHT BLOCK☒ REAR SIGHT BLOCK☒ SCREWS☒ FINISH

Scope Assy.

☒ Scope☒ Scope Rings☒ Mounting Screws☒ Mounting Base☒ SCREWS☒ FINISH☒ LOOSENESS☒ CLARITY

Misc.

☐ DD-250☐ BAR CODE☐ PACKAGING

Item:

Stock Assy.

☒ STOCK☒ SLING SWIVEL STUDS☒ ADJUSTABLE BUTT PLATE☒ LOCK NUTS☒ BARREL CLEARANCE☒ COLOR/FINISH

Systems Case

☒ Scope Case☒ IRON SIGHTS☒ Deployment Kit

Trigger

☒ SAFETY OPERATION☒ SET

Comments: