

C6594531

MODEL 700TM N24

Model **SWS** TM

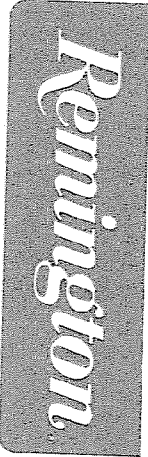
Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.



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: RE00131400

Serial: C6594531 Model M24 SWS Center Fire
Caliber: 7.62 NATO

Repairman:

Verify Repair

Status:

Closed 7/17/2007 7:48:41 AM

Address Information

Customer:

Received From

Return To:

Received From

Name: CO. B 2d Bn., 3d SFG-A

CO. B 2d Bn., 3d SFG-A

Address 1: SGT TIMOTHY KRANZ

SGT TIMOTHY KRANZ

Address 2: E-1650 KUWAIT STREET

PO Box:

E-1650 KUWAIT STREET

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

Phone: NN

Fax:

Email:

Comments:

Received Condition

Fair

Condition
Notes:CSR
Notes:

Accessories Received

Code	Desc	Qty
A007	With Stud	3
A010	Hard Case	1
A057	Frt and Rear Sgt Base	1

Repair Search

Refresh

Close

naglej

7/17/2007

8:14 AM

CAPS

NUM

INS

SCRL



3 Microsoft O...

3 Microsoft O...

Arms Services ...

4 Internet Ex...

8:14 AM

Serial Number: C6594531

Model: M24 SWS



RE00131400

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6594531.___0
FILE DATE AND TIME: 09/10/2007 05:11

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.040
The Average Y Centroid of the Five Target Set:	0.068
The Average Point of Impact of the Five Target Set:	0.079
The Average Mean Radius of the Five Target Set:	0.789
The Distance from POA to Centroid Target #1:	0.316
The Distance from Centroid Target #2 to Centroid Target #1:	0.505
The Distance from Centroid Target #3 to Centroid Target #1:	0.454
The Distance from Centroid Target #4 to Centroid Target #1:	0.146
The Distance from Centroid Target #5 to Centroid Target #1:	0.228

SERIAL NUMBER: C6594531. __0

TARGET NUMBER: 1

FILE DATE: 09/10/2007

FILE TIME: 05:11

X CENTROID: -0.053

Y CENTROID: 0.311

POA TO CENTROID: 0.316

HORZ SPREAD: 2.769

VERT SPREAD: 2.498

GROUP SPREAD: 3.134

MIN RADIUS: 0.137

MAX RADIUS: 1.588

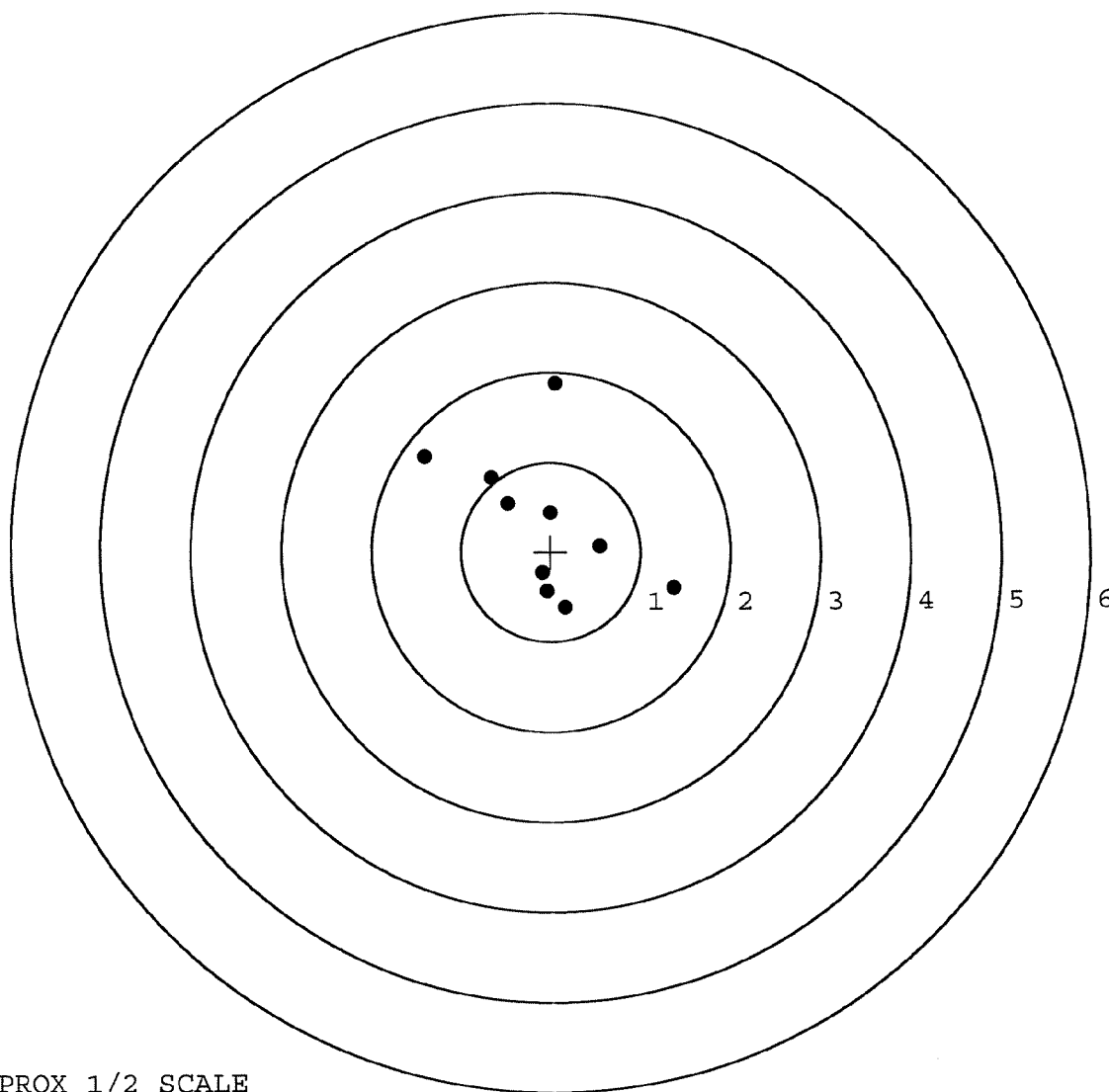
MEAN RADIUS: 0.903

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 7

POINT#	X	Y
1:	-1.402	1.067
2:	-0.654	0.830
3:	-0.475	0.542
4:	-0.005	0.439
5:	0.551	0.062
6:	1.367	-0.400
7:	0.162	-0.621
8:	-0.045	-0.446
9:	-0.096	-0.238
10:	0.064	1.877

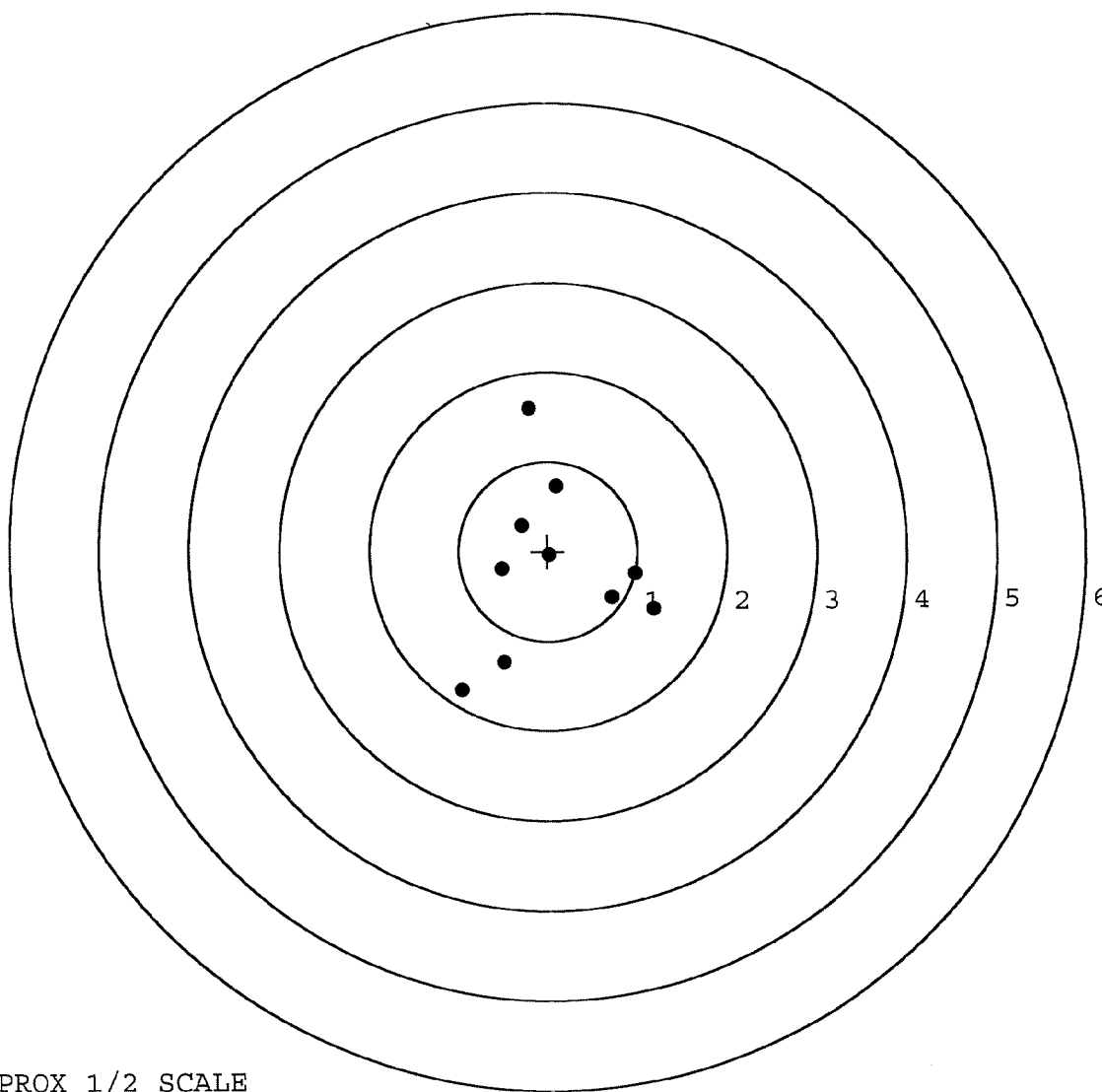


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6594531.___0
TARGET NUMBER: 2
FILE DATE: 09/10/2007
FILE TIME: 05:11

X CENTROID: 0.052
Y CENTROID: -0.183
POA TO CENTROID: 0.190
HORZ SPREAD: 2.153
VERT SPREAD: 3.141
GROUP SPREAD: 3.234
MIN RADIUS: 0.145
MAX RADIUS: 1.793
MEAN RADIUS: 0.979
IN 1 IN DIAMETER: 1
IN 2 IN DIAMETER: 6
in 3 IN DIAMETER: 8

POINT#	X	Y
1:	-0.973	-1.549
2:	-0.498	-1.238
3:	1.180	-0.643
4:	0.715	-0.519
5:	0.978	-0.247
6:	0.020	-0.041
7:	-0.518	-0.199
8:	-0.287	0.293
9:	0.102	0.725
10:	-0.201	1.592



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6594531. __0

TARGET NUMBER: 3

FILE DATE: 09/10/2007

FILE TIME: 05:11

X CENTROID: 0.220

Y CENTROID: -0.051

POA TO CENTROID: 0.226

HORZ SPREAD: 1.757

VERT SPREAD: 2.118

GROUP SPREAD: 2.615

MIN RADIUS: 0.250

MAX RADIUS: 1.395

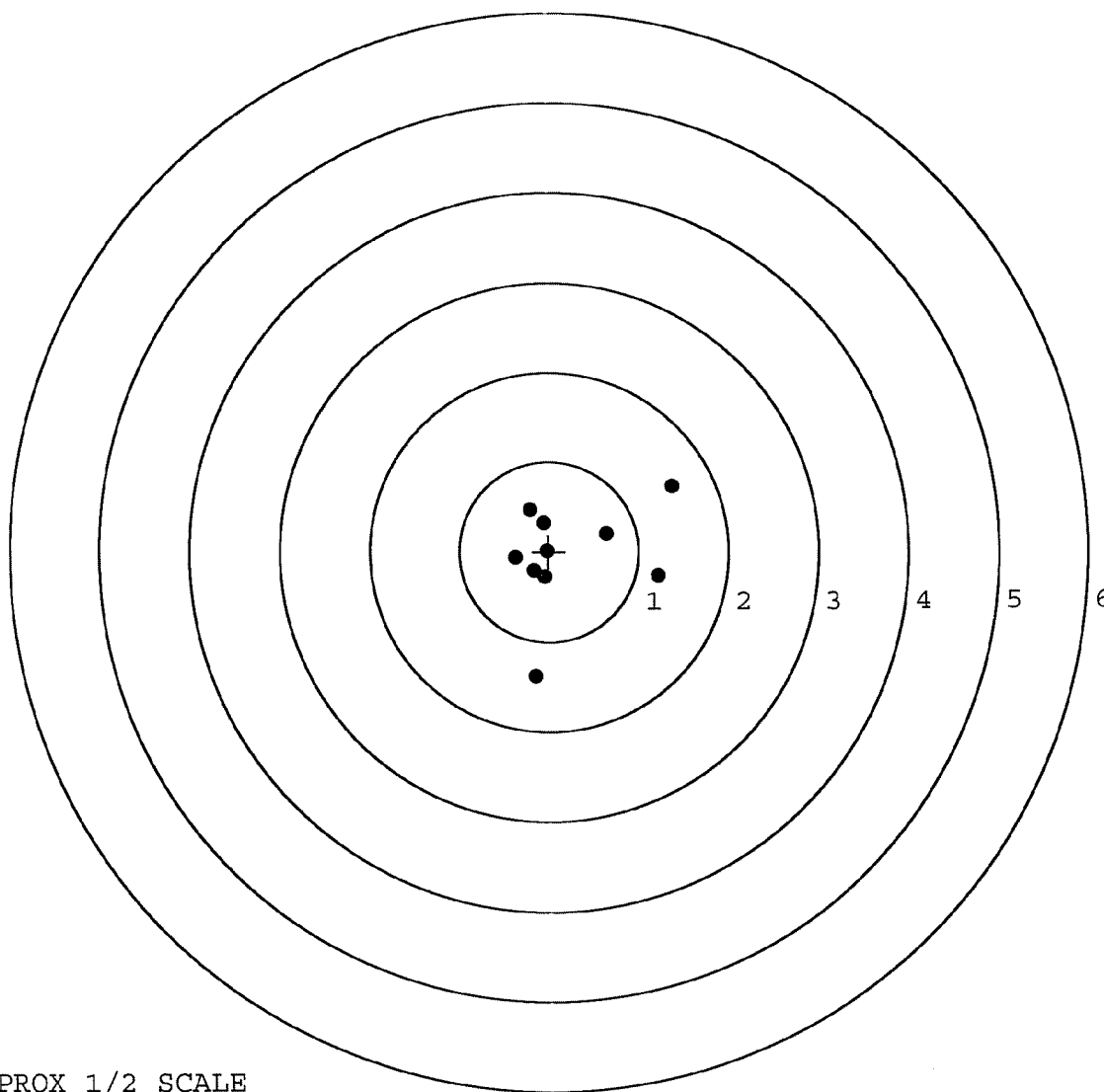
MEAN RADIUS: 0.706

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.155	-1.392
2:	1.219	-0.272
3:	1.379	0.726
4:	0.642	0.200
5:	-0.048	-0.280
6:	-0.173	-0.215
7:	-0.023	0.007
8:	-0.378	-0.071
9:	-0.055	0.318
10:	-0.207	0.466

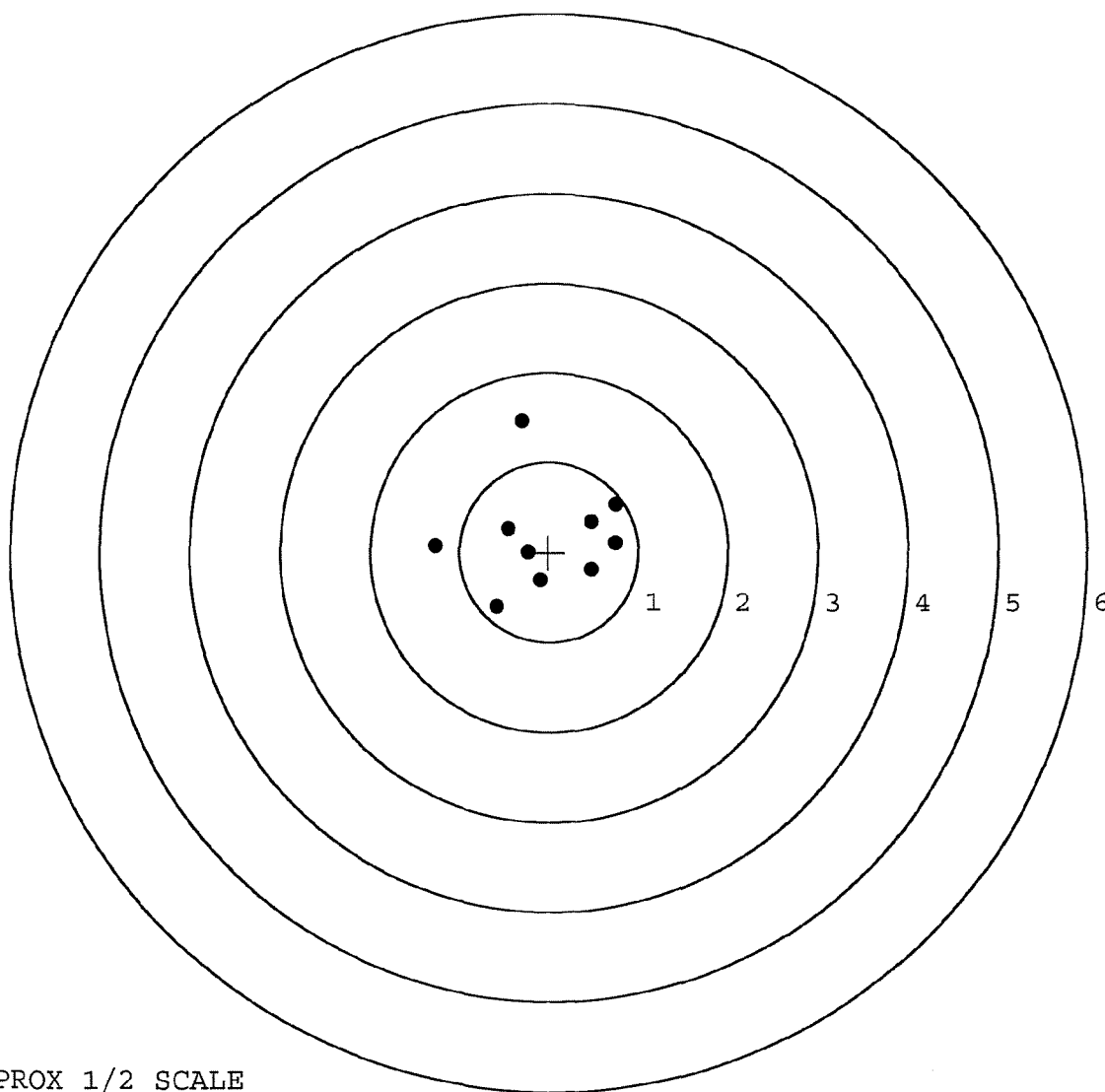


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6594531. __0
TARGET NUMBER: 4
FILE DATE: 09/10/2007
FILE TIME: 05:11

X CENTROID: -0.050
Y CENTROID: 0.166
POA TO CENTROID: 0.173
HORZ SPREAD: 2.030
VERT SPREAD: 2.062
GROUP SPREAD: 2.081
MIN RADIUS: 0.245
MAX RADIUS: 1.310
MEAN RADIUS: 0.750
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.584	-0.612
2:	-1.280	0.071
3:	-0.099	-0.314
4:	-0.227	-0.004
5:	-0.456	0.261
6:	0.484	-0.188
7:	0.741	0.112
8:	0.477	0.345
9:	0.750	0.535
10:	-0.306	1.450



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6594531. 0

TARGET NUMBER: 5

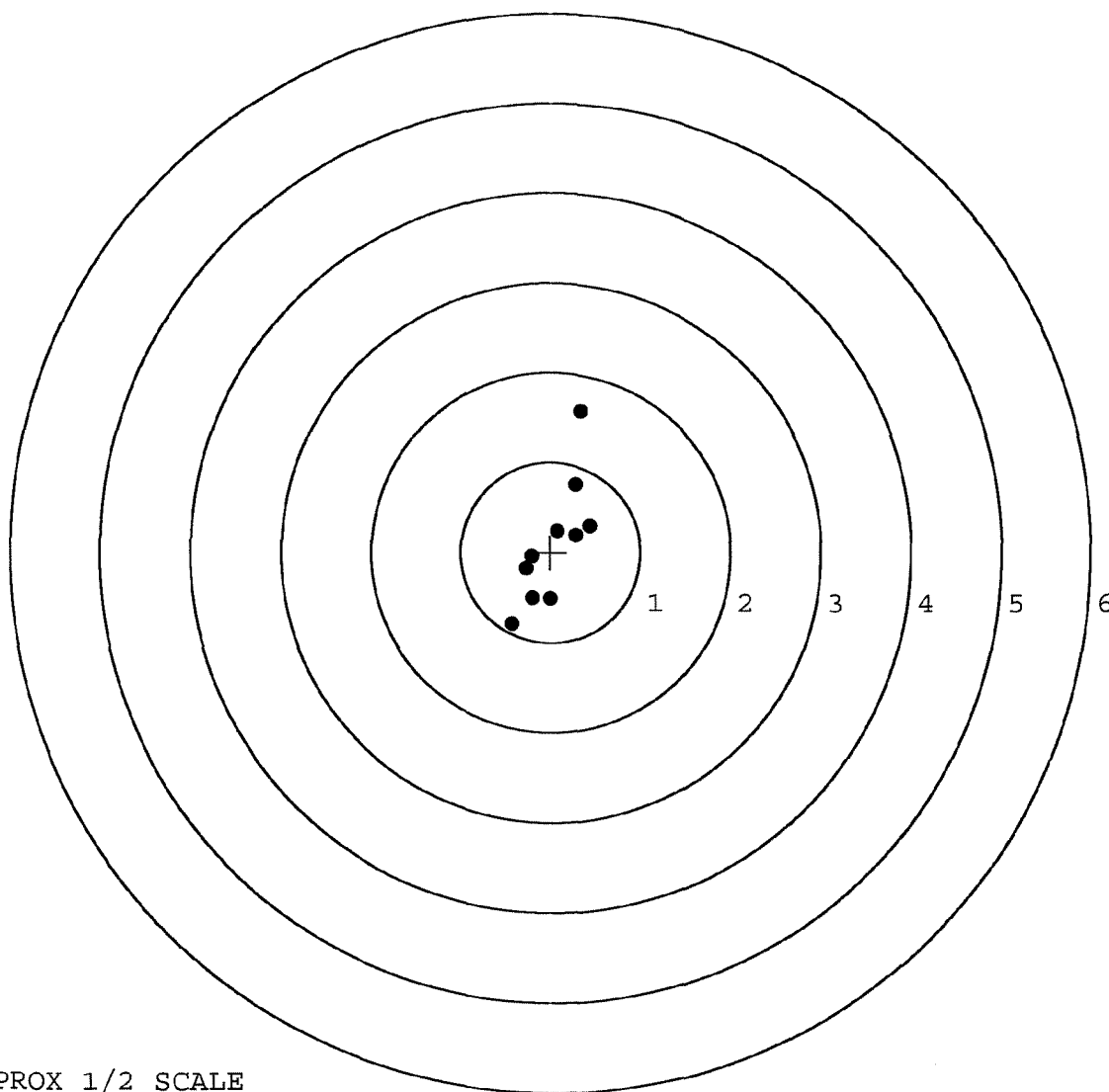
FILE DATE: 09/10/2007

FILE TIME: 05:11

X CENTROID: 0.032
Y CENTROID: 0.099
POA TO CENTROID: 0.104
HORZ SPREAD: 0.867
VERT SPREAD: 2.368
GROUP SPREAD: 2.488
MIN RADIUS: 0.146
MAX RADIUS: 1.503
MEAN RADIUS: 0.605

IN 1 IN DIAMETER: 5
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 9

POINT#	X	Y
1:	0.334	1.572
2:	0.282	0.753
3:	0.439	0.300
4:	0.086	0.235
5:	-0.428	-0.796
6:	0.004	-0.515
7:	-0.204	-0.512
8:	-0.209	-0.048
9:	-0.270	-0.185
10:	0.285	0.189



TARGET APPROX 1/2 SCALE

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

R & E NUMBER <u>131400</u>			
SERIAL NUMBER <u>C6594531</u>			
LOG-IN DATE <u>7-17-07</u>			

OPERATION #	OPERATION NAME	DATE	INITIAL
500	DIS-ASSEMBLE GUN	8-14-07	RTZ
505	RE-BARREL	8-15-07	RTZ
560	ASSEMBLE	8-20-07	RTZ
600	PROOF	8-23-07	RTZ
605	CHECK HEADSPACE	8-25-07	RTZ
610	DIS-ASSEMBLE GUN		
612	MAGNAFLUX	8-30-07	JS
510	DRILL AND TAP	8-27-07	TRW
615	ROLLMARK CALIBER	8-28-07	CW
618	ROTO-BLAST	8-30-07	LY
620	APPLY COATINGS	8/31/07	RB
625	FINAL ASSEMBLY	9-7-07	RTZ
640	FUNCTION TEST AND	9-8-07	TRW
650	TARGET	9-8-07	TRW
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
670	FINAL INSPECTION	9-8-07	DK
	A) HEADSPACE	9/10/07	non
	B) TRIGGER PULL	9/10/07	non
		282 2.89 2.89 2.92 2.94 9-10-07	DA
680	F) SAFETY ON FORCE	4.0 4.50 4.25 9/10/07	non
	G) SAFETY OFF FORCE	3.0 2.75 2.5 9/10/07	non
	I) FIRING PIN INDENT	.020 .020 .021 .021 9/10/07	non
690	PACK	9-12-07	DA




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

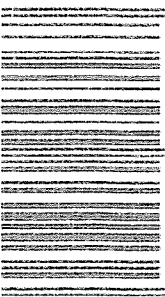
MODEL 700TM H24

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

SERIAL NO.
C6594531

ORDER NO.
5716

UPC



0 47700 25716 7



5716 C6594531

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6594531

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	1228	90	RW
600	Proof	1228	90	RW
607	Check Headspace	1228	90	RW
610	Dis-assemble Gun	1228	90	RW
612	Magnaflux Barrel Action		1-7-91	KR
	Magnaflux Bolt		"	KR
615	Rollmark Caliber		"	GL
617	Drill and Tap Sight Holes	1 10	91	FB
618	Polish Barrel	1 10	91	WB
620	Apply Coatings (Barrel Action)		1-12-91	TJA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		1/19/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		1/19/91	RW
	C) Inspect Ejector Hole for Chamfer		1/19/91	RW
	D) Oil Firing Pin Ass'y		1/19/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		1-29-91	GM

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.-	F) Safety On Force	3 1/2	3 1/2	3 1/2			1/30/91	WLB
	G) Safety Off Force	2	2	2			1/30/91	WLB
	H) Trigger Pull Test & Retainability						1-29-91	WLB
	I) Firing Pin Indent	.020	.0205	.0205			1/30/91	WLB
	J) Assemble Stock						1/30/91	RW
	K) Assemble Swivel Studs						2-4-91	AC
	L) Attach Front and Rear Sight Assemblies						1/30/91	RW
	M) Iron Sight Alignment						1/30/91	RW
	N) Detach Front & Rear Sights & place in numbered container						1/30/91	RW
	O) Attach Scope to Rifle						1/30/91	RW
	P) Detach & Attach Scope 20 Times						1/30/91	RW
640	Gallery Target & Test						1-30-91	NF
	A) Time						"	NF
	B) Malfunctions						"	NF
	C) Pierced Primers						"	NF
	D) Optical Clarity of Scope						"	NF
645	Inspect for Live Ammo						1-30-91	NF
655	Final Inspection							
	A) Headspace						2-4-91	AC
	B) Trigger Pull	2.41	2.32	2.47	2.29	2.46	2-4-91	WLB
	C) Function						2-4-91	AC
660	Pack						3/15/91	WLB

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6594531

DATE 1-29-91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.44	2.47	2.32	2.41	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.49	2.51	2.42	2.32	
PULL #3	2.42	2.11	2.30	2.42	
PULL #4	2.47	2.43	2.22	2.29	
PULL #5	2.39	2.45	2.40	2.46	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.35	3.28		
PULL #2	3.24	3.23		
PULL #3	3.22	3.16		
PULL #4	3.21	3.18		
PULL #5	3.23	3.23		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.36	4.41		4.27
PULL #2	4.21	4.48		4.50
PULL #3	4.25	4.38		4.28
PULL #4	4.32	4.50		4.52
PULL #5	4.30	4.49		4.44
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6594531
31 Jan 1991

CENTROIDAL DISTANCES

0 TO 1	.0658027
1 TO 2	.076243
1 TO 3	.300268
1 TO 4	.0331059
1 TO 5	.0633246

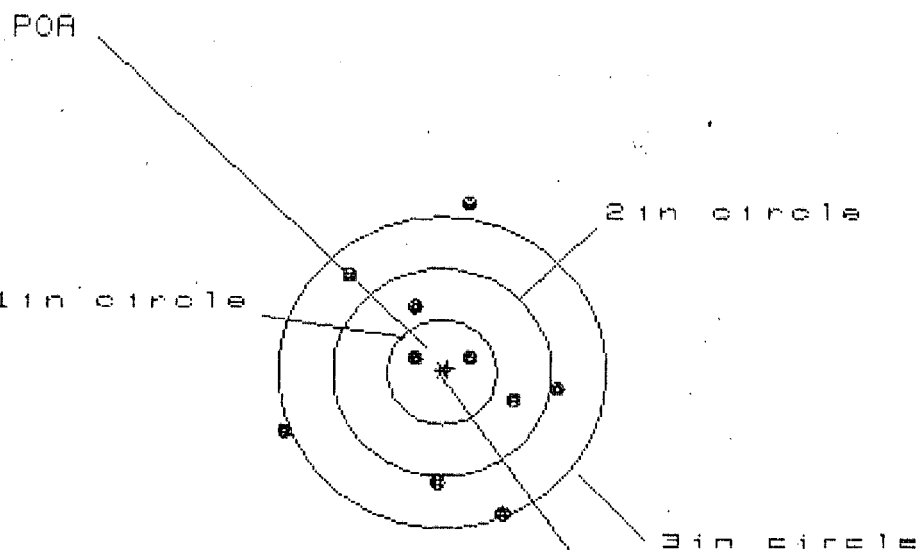
3. <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0932
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0928
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .131522
THE AMR FOR THIS RIFLE IS: .9248

31 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06594531

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 2

2in = 4

3in = 7

HS= 2.529

VS= 3.093

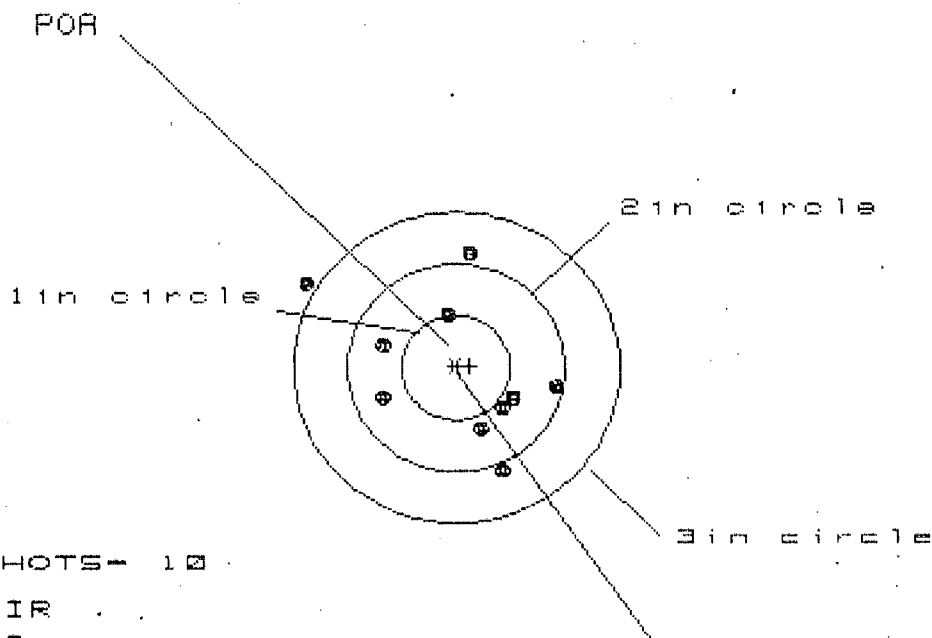
GS= 3.110

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.091	1.120	.944
MINIMUM X	:	-1.438	-1.409	-1.000
MAXIMUM Y	:	1.683	1.105	1.056
MINIMUM Y	:	-1.410	-1.223	-1.272
CENTROID X	:	-.053	-.081	.095
CENTROID Y	:	-.039	-.226	-.177
POA TO CENTROID in.	:	.065	.240	.201
MIN RADIUS	:	.301	.402	.294
MEAN RADIUS	:	1.019	.952	.857
MAX RADIUS	:	1.703	1.462	1.454
HORIZONTAL SPREAD	:	2.529	2.529	1.944
VERTICAL SPREAD	:	3.093	2.328	2.328
EXTREME SPREAD	:	3.110	2.735	2.735
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		7	

31 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6594531

CENTERFIRE PATTERNS # 2



OF SHOTS - 10

IN CIR

1in = 0

2in = 7

3in = 9

HS = 2.328

VS = 2.040

GS = 2.515

CENTROID #

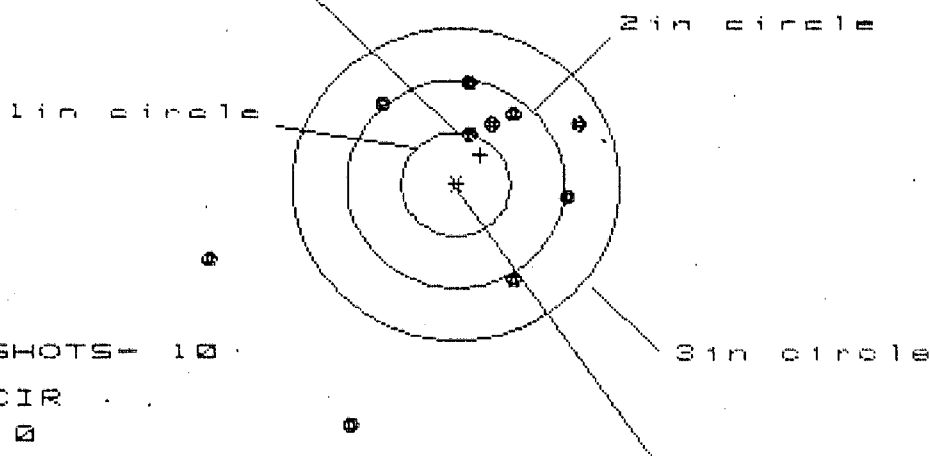
PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.970	.820	.816
MINIMUM X	:	-1.358	-.843	-.847
MAXIMUM Y	:	1.106	1.193	.736
MINIMUM Y	:	-.934	-.847	-.698
CENTROID X	:	-.126	.025	.029
CENTROID Y	:	-.017	-.104	-.253
POA TO CENTROID in.	:	.127	.107	.255
MIN RADIUS	:	.505	.381	.284
MEAN RADIUS	:	.849	.737	.648
MAX RADIUS	:	1.569	1.194	.959
HORIZONTAL SPREAD	:	2.328	1.663	1.663
VERTICAL SPREAD	:	2.040	2.040	1.434
EXTREME SPREAD	:	2.515	2.070	1.691
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

31 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6594531

CENTERFIRE PATTERNS # 3

POA



OF SHOTS- 10

IN CIR

1in = 0

2in = 3

3in = 8

HS= 3.434

VS= 3.341

GS= 3.670

CENTROID *

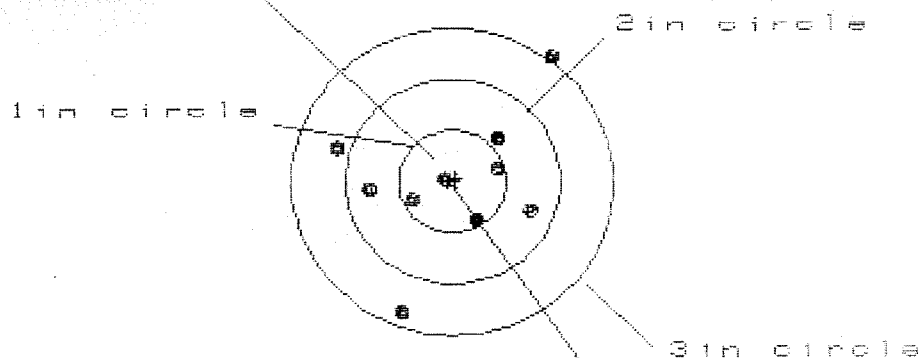
PATTERN #	3	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.162	1.052	.754
MINIMUM X	-2.272	-2.382	-1.108
MAXIMUM Y	.997	.736	.615
MINIMUM Y	-2.344	-1.128	-1.249
CENTROID X	-.228	-.118	.180
CENTROID Y	-.283	-.022	.099
POA TO CENTROID in.	.363	.120	.206
MIN RADIUS	.514	.235	.205
MEAN RADIUS	1.239	.979	.687
MAX RADIUS	2.547	2.572	1.257
HORIZONTAL SPREAD	3.434	3.434	1.862
VERTICAL SPREAD	3.341	1.864	1.864
EXTREME SPREAD	3.670	3.670	2.049
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	3		
NUMBER IN THREE INCH CIRCLE =	8		

31 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06594531

CENTERFIRE PATTERNS # 4

POA



OF SHOTS- 10

IN CIR

1in = 4

2in = 7

3in = 9

HS= 1.979

VS= 2.438

GS= 2.842

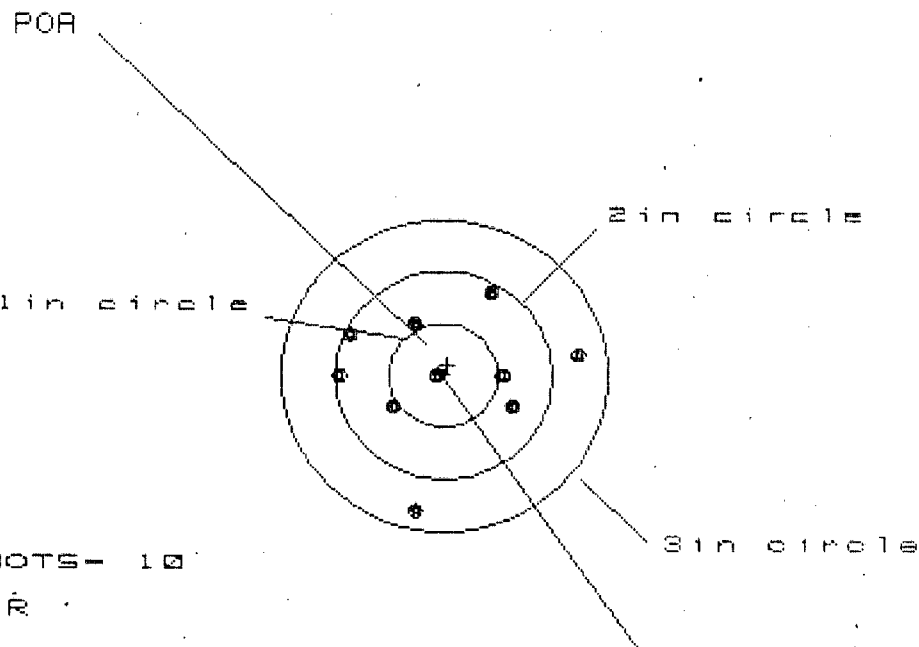
CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.935	.839	.787
MINIMUM X	:	-1.044	-.940	-.992
MAXIMUM Y	:	1.207	.582	.445
MINIMUM Y	:	-1.231	-1.097	-.383
CENTROID X	:	-.023	-.127	-.075
CENTROID Y	:	-.025	-.159	-.022
POA TO CENTROID in.	:	.034	.204	.078
MIN RADIUS	:	.052	.128	.022
MEAN RADIUS	:	.746	.654	.573
MAX RADIUS	:	1.527	1.175	1.046
HORIZONTAL SPREAD	:	1.979	1.779	1.779
VERTICAL SPREAD	:	2.438	1.679	.828
EXTREME SPREAD	:	2.842	1.915	1.874
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

31 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06594531

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 8

3 in = 10

HS= 2.222

VS= 2.060

GS= 2.227

PATTERN #	5	5	5
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.252	1.219	.798
MINIMUM X	-.970	-1.003	-.850
MAXIMUM Y	.794	.654	.656
MINIMUM Y	-1.266	-.449	-.447
CENTROID X	-.036	-.003	-.156
CENTROID Y	-.100	.041	.039
POA TO CENTROID in.	.106	.041	.160
MIN RADIUS	.064	.165	.143
MEAN RADIUS	.771	.711	.630
MAX RADIUS	1.299	1.219	.914
HORIZONTAL SPREAD	2.222	2.222	1.648
VERTICAL SPREAD	2.060	1.103	1.103
EXTREME SPREAD	2.227	2.227	1.680
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	8		
NUMBER IN THREE INCH CIRCLE =	10		