

C6594564

MODEL 700TM M24

Model **SWS**TM

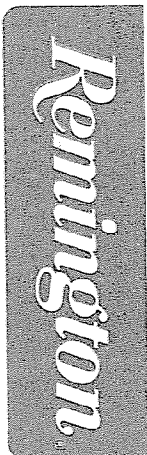
Action

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: **RE00129141** Serial: C6594564 Model M24 SWS Center Fire
 Verify Repair Caliber: 7.62 NATO Produced: 03/19/1991 Repairman: Status: New 5/9/2007 11:16:59 AM

Address Information

Customer: ☒ Received From Return To: ☐ Received From

Name: **TRANSPORTATION OFFICER** **TRANSPORTATION OFFICER**

Address 1: **USPFO FOR ARKANSAS BLDG 318** **USPFO FOR ARKANSAS BLDG 318**

Address 2: **CAMP JOSEPH T ROBINSON** PO Box: **CAMP JOSEPH T ROBINSON** PO Box:

City: **NORTH LITTLE ROCK** **NORTH LITTLE ROCK**

State: **AR** Zip Code: **72199** Country: **US** State: **AR** Zip Code: **72199** 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 <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>A017</td> <td>Scope Base</td> <td>1</td> </tr> <tr> <td>A026</td> <td>Scope</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	A017	Scope Base	1	A026	Scope	1	A057	Frt and Rear Sgt Base	1
Code	Desc	Qty																	
A007	With Stud	3																	
A017	Scope Base	1																	
A026	Scope	1																	
A057	Frt and Rear Sgt Base	1																	

Repair Search Refresh Close

nagletj 5/10/2007 11:27 AM CAPS NUM INS SCRL

start 2 Mi... 5 In... 2 Mi... SAP L... Part ... Arms ... 11:27 AM

Serial Number: **C6594564**

Model: **M24 SWS**



RE00129141

For use of this form, see DA PAM 738-750 and 738-751; the proponent agency is DCSLOG

USAPPC V1.10

M2400019374

DATE: 20070424

MAINTENANCE REQUEST

DA FORM 5990-E

----- CUSTOMER DATA -----

UIC: WPQMT0
UTIL CODE: 7

HHC 1/153

PHONE: (501)332-6081

----- ACTIVITY DATA -----

SUP WON:
SUP UIC: W8TMAA

CSMS

PHONE: 212-5802
SHOP SEC:

----- EQUIPMENT DATA -----

TYPE MNT REQ: 1 ID: A NSN: 1005012402136 MODEL: M24
NOUN: RIFLE: 7.62 SNIPER SER NUM: C6594564 QTY: 00001
ORG WON: PQMT01700023 PRIORITY: 03 FAILURE DETECTED: D
MI/KM: ----- HOURS: ----- ROUNDS:
IN WARRANTY: LEVEL OF WORK: F ADMIN NUM:

DEFICIENCY: RE-BARRELLED

PD AUTHENTICATING SIGNATURE: _____

----- SIGNATURE DATA -----

SUBMITTED BY: _____ ORD DATE: _____ MIL TIME: _____

ACCEPTED BY: _____ STATUS: _____ ORD DATE: _____ MIL TIME: _____

----- ACTION DATA -----

WORK STARTED BY: _____ STATUS: _____ ORD DATE: _____ MIL TIME: _____

INSPECTED BY: _____ STATUS: _____ ORD DATE: _____ MIL TIME: _____

PICKED UP BY: _____ STATUS: _____ ORD DATE: _____ MIL TIME: _____

----- COMPLETION DATA -----

QTY RPR: _____ QTY CONDEMNED: _____ NRTS: _____

EVAC WON: _____ EVAC UNIT NAME: _____

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

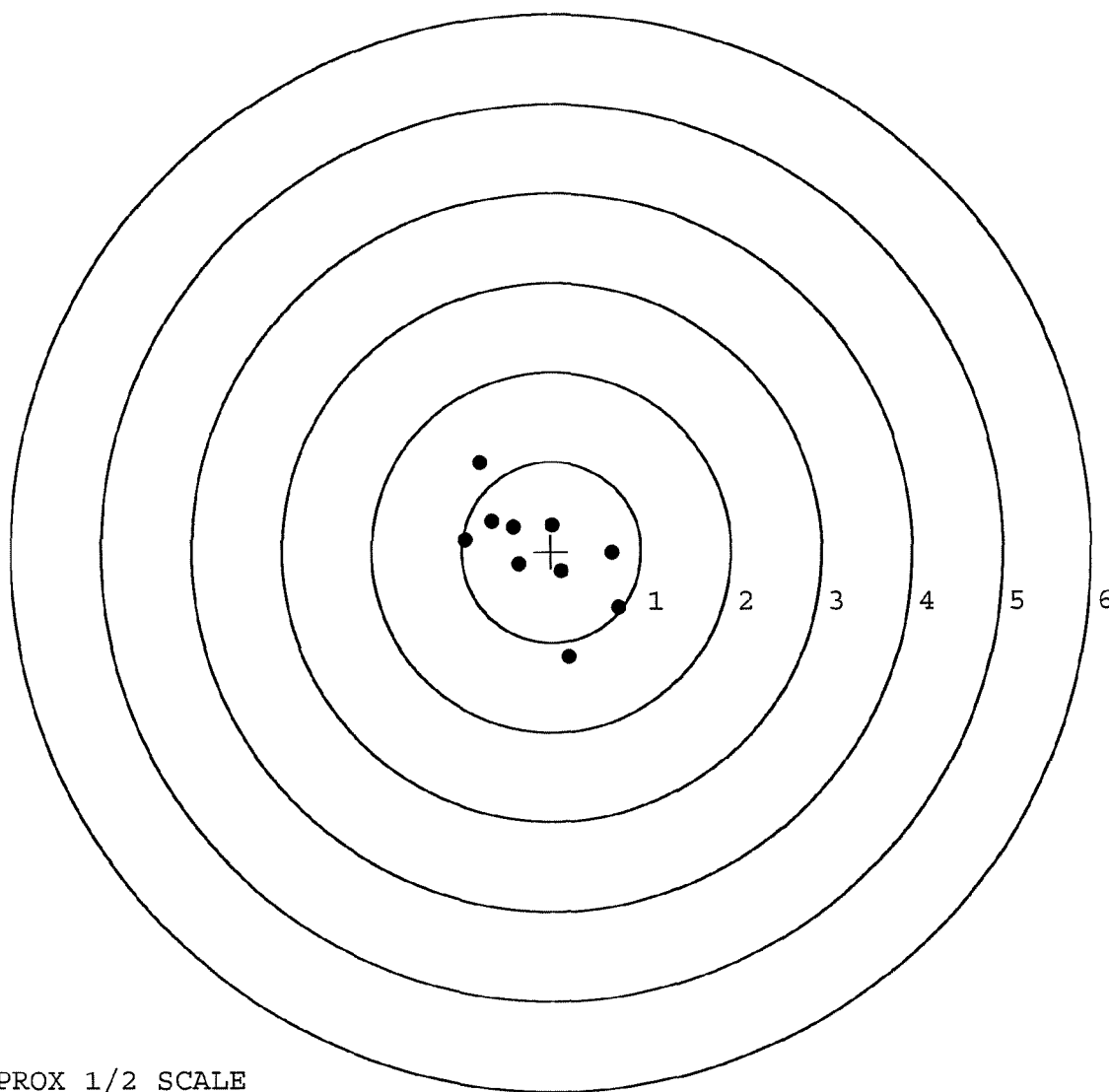
FIREARM SERIAL NUMBER / DATASET NAME: C6594564.__0
FILE DATE AND TIME: 07/09/2007 23:05

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.024
The Average Y Centroid of the Five Target Set:	-0.016
The Average Point of Impact of the Five Target Set:	0.029
The Average Mean Radius of the Five Target Set:	0.663
The Distance from POA to Centroid Target #1:	0.150
The Distance from Centroid Target #2 to Centroid Target #1:	0.266
The Distance from Centroid Target #3 to Centroid Target #1:	0.290
The Distance from Centroid Target #4 to Centroid Target #1:	0.243
The Distance from Centroid Target #5 to Centroid Target #1:	0.185

SERIAL NUMBER: C6594564. 0
TARGET NUMBER: 1
FILE DATE: 07/09/2007
FILE TIME: 23:05

	POINT#	X	Y
X CENTROID:	1:	-0.795	0.990
Y CENTROID:	2:	-0.668	0.337
POA TO CENTROID:	3:	-0.431	0.268
HORZ SPREAD:	4:	-0.965	0.133
VERT SPREAD:	5:	-0.366	-0.145
GROUP SPREAD:	6:	0.112	-0.223
MIN RADIUS:	7:	0.676	-0.019
MAX RADIUS:	8:	0.741	-0.622
MEAN RADIUS:	9:	0.199	-1.170
# IN 1 IN DIAMETER:	10:	0.010	0.292
# IN 2 IN DIAMETER:			
# in 3 IN DIAMETER:			

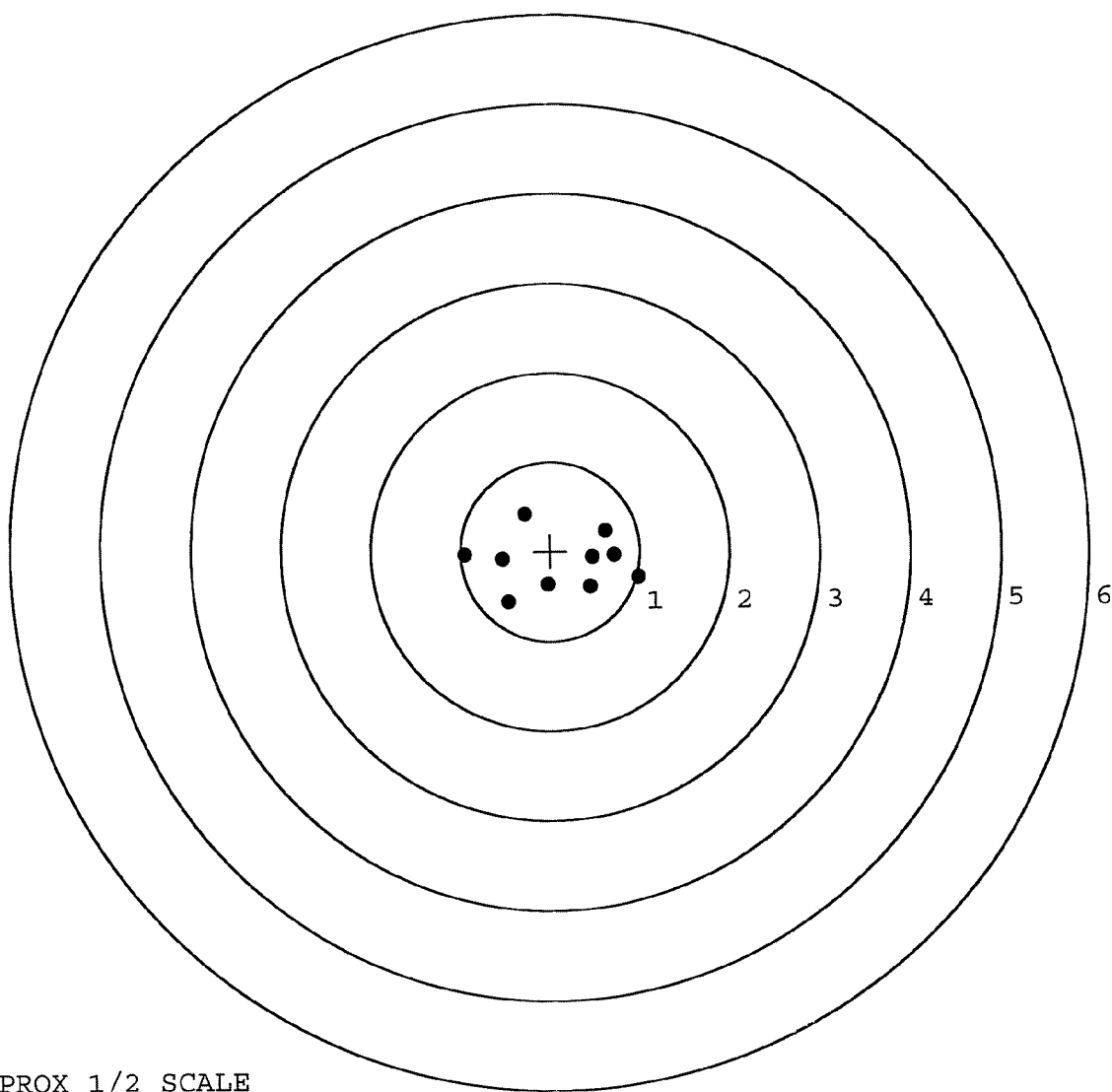


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6594564. __0
TARGET NUMBER: 2
FILE DATE: 07/09/2007
FILE TIME: 23:05

X CENTROID: 0.094
Y CENTROID: -0.125
POA TO CENTROID: 0.156
HORZ SPREAD: 1.940
VERT SPREAD: 0.980
GROUP SPREAD: 1.957
MIN RADIUS: 0.275
MAX RADIUS: 1.055
MEAN RADIUS: 0.632
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.284	0.414
2:	-0.957	-0.042
3:	-0.539	-0.090
4:	-0.476	-0.566
5:	-0.027	-0.372
6:	0.619	0.223
7:	0.471	-0.073
8:	0.711	-0.048
9:	0.983	-0.300
10:	0.443	-0.394

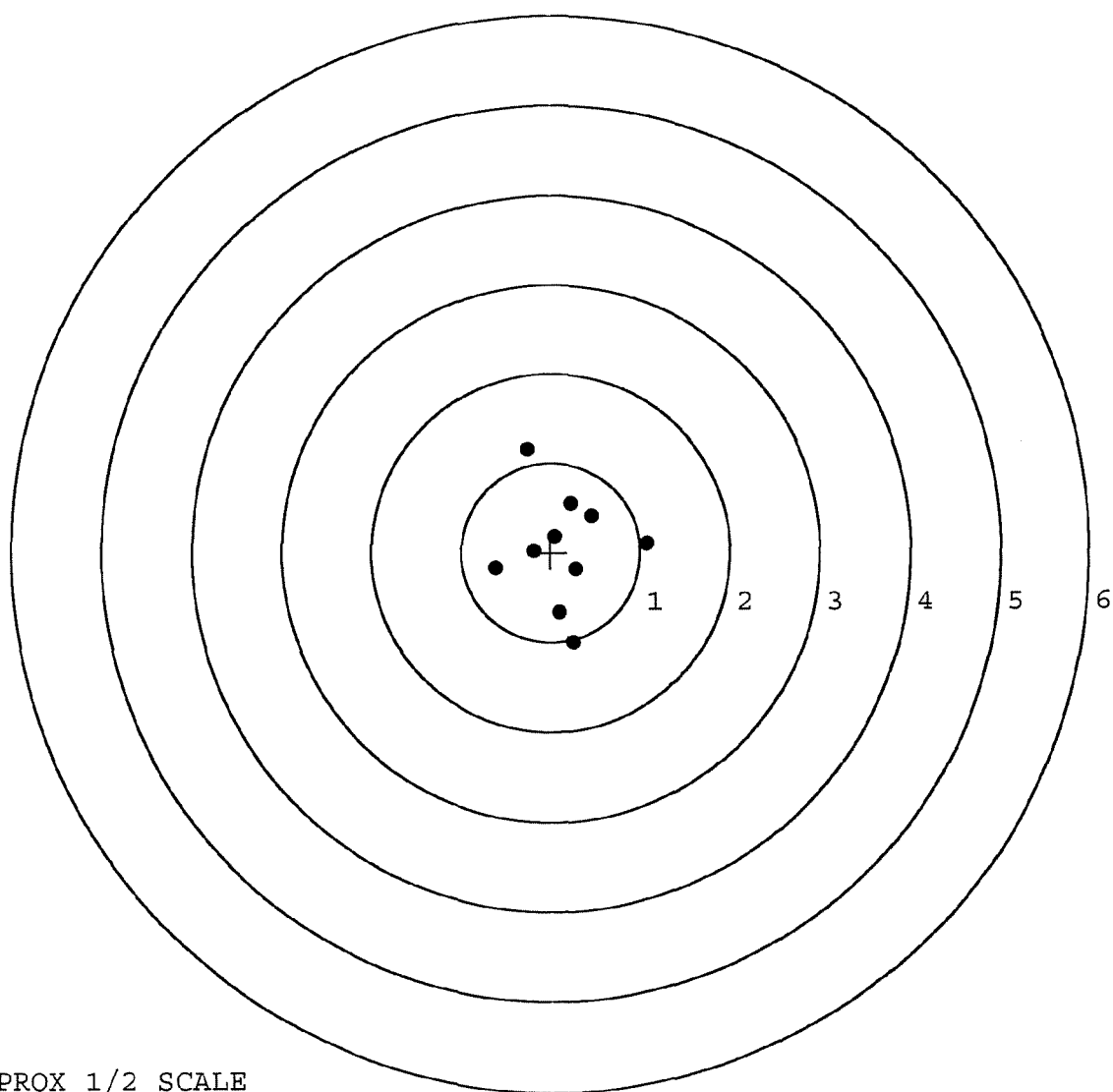


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6594564. __0
TARGET NUMBER: 3
FILE DATE: 07/09/2007
FILE TIME: 23:05

X CENTROID: 0.137
Y CENTROID: 0.034
POA TO CENTROID: 0.141
HORZ SPREAD: 1.690
VERT SPREAD: 2.163
GROUP SPREAD: 2.222
MIN RADIUS: 0.166
MAX RADIUS: 1.186
MEAN RADIUS: 0.644
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.255	1.153
2:	0.220	0.547
3:	0.454	0.409
4:	0.050	0.175
5:	0.283	-0.192
6:	-0.189	0.014
7:	0.097	-0.674
8:	0.253	-1.010
9:	1.075	0.096
10:	-0.615	-0.178

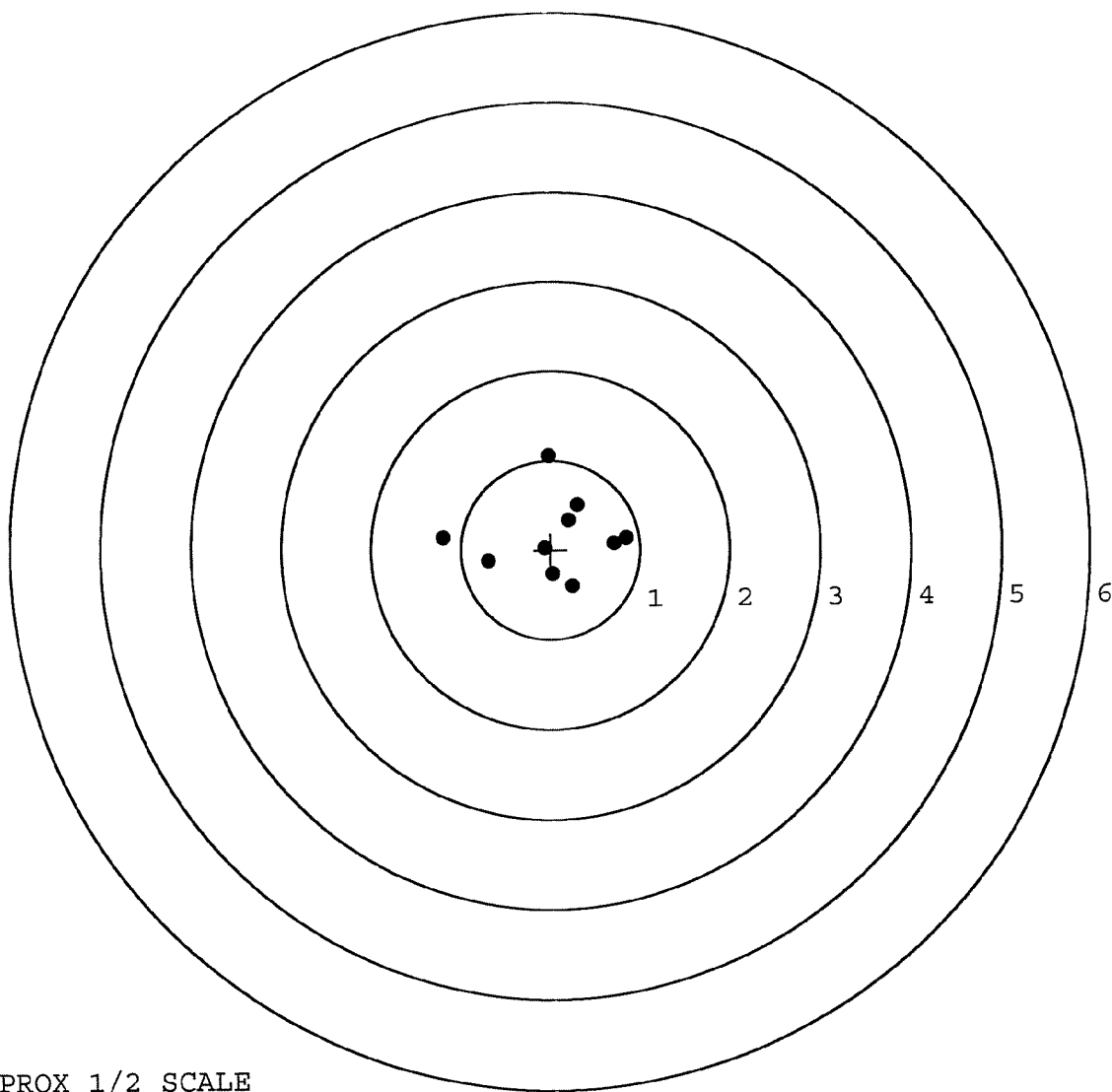


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6594564. 0
TARGET NUMBER: 4
FILE DATE: 07/09/2007
FILE TIME: 23:05

X CENTROID: 0.034
Y CENTROID: 0.145
POA TO CENTROID: 0.149
HORZ SPREAD: 2.036
VERT SPREAD: 1.458
GROUP SPREAD: 2.036
MIN RADIUS: 0.163
MAX RADIUS: 1.230
MEAN RADIUS: 0.626
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.300	0.501
2:	0.203	0.328
3:	0.710	0.070
4:	0.840	0.132
5:	-0.073	0.021
6:	0.024	-0.267
7:	0.241	-0.408
8:	-0.694	-0.123
9:	-1.196	0.145
10:	-0.020	1.050

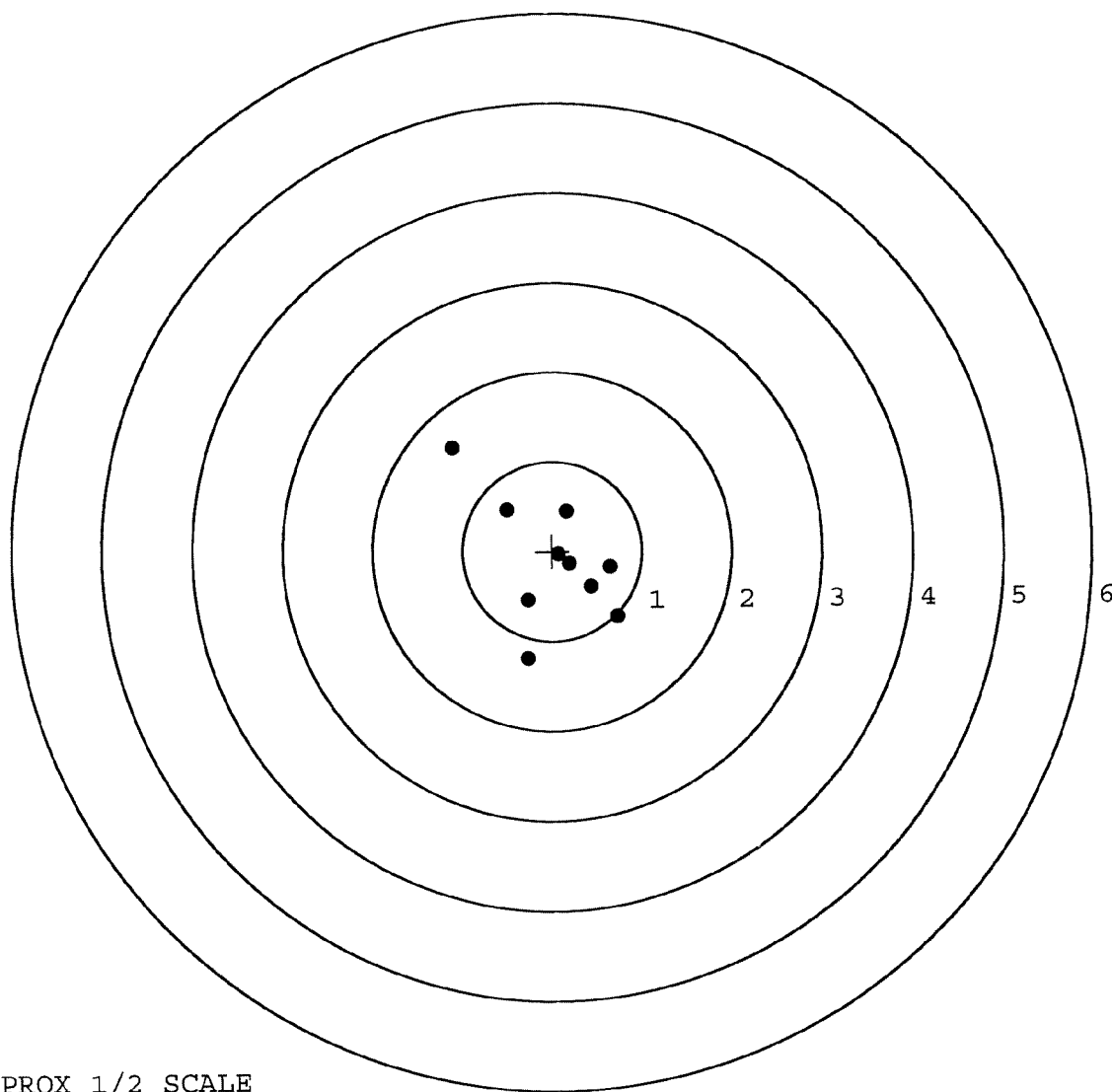


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6594564. 0
TARGET NUMBER: 5
FILE DATE: 07/09/2007
FILE TIME: 23:05

X CENTROID: 0.005
Y CENTROID: -0.118
POA TO CENTROID: 0.118
HORZ SPREAD: 1.827
VERT SPREAD: 2.353
GROUP SPREAD: 2.632
MIN RADIUS: 0.105
MAX RADIUS: 1.692
MEAN RADIUS: 0.706
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 9

POINT#	X	Y
1:	-1.105	1.159
2:	0.162	0.444
3:	0.187	-0.143
4:	0.429	-0.406
5:	0.642	-0.184
6:	0.722	-0.736
7:	-0.275	-0.548
8:	-0.281	-1.194
9:	0.070	-0.036
10:	-0.500	0.462



TARGET APPROX 1/2 SCALE

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50 LBS (plus or minus 0.50 LBS)
3.00 LBS (plus or minus 0.75 LBS)
4.00 LBS (plus or minus 1.00 LBS)

DATE 6-6-07

TESTER TRW

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.39	2.76		2.75	
PULL #2	2.28	2.71		2.74	
PULL #3	2.44	2.73		2.76	
PULL #4	2.47	2.71		2.90	
PULL #5	2.58	2.66		2.75	
TOTAL	12.16	13.57		13.90	
AVERAGE	2.43	2.71		2.78	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.19	3.21		
PULL #2	3.25	3.13		
PULL #3	3.20	3.20		
PULL #4	3.22	3.24		
PULL #5	3.35	3.18		
TOTAL	16.21	15.96		
AVERAGE	3.24	3.19		

	4.00 LBS INITIAL	4.00 LBS AFTER 20 CYCLES	MAX SETTING GREATER THAN 4 LBS	RESET TO 4 LBS FOR TARGET & ACCURACY
PULL #1	4.54	4.47		4.54
PULL #2	4.46	4.55		4.52
PULL #3	4.61	4.59		4.58
PULL #4	4.50	4.65		4.46
PULL #5	4.57	4.68		4.53
TOTAL	22.68	22.94		22.63
AVERAGE	4.53	4.58		4.52

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

R & E NUMBER <u>129141</u>			
SERIAL NUMBER <u>060594564</u>			
LOG-IN DATE <u>5-9-07</u>			
OPERATION #	OPERATION NAME	DATE	INITIAL
500	DIS-ASSEMBLE GUN	6-8-07	RJL
505	RE-BARREL	6-15-07	RJL
560	ASSEMBLE	6-18-07	RJL
600	PROOF	6-18-07	TRW
605	CHECK HEADSPACE	6-18-07	TRW
610	DIS-ASSEMBLE GUN	6-18-07	RJL
612	MAGNAFLUX	6-19-07	WMB
510	DRILL AND TAP	6-18-07	S.D
615	ROLLMARK CALIBER	6-19-07	CW
618	ROTO-BLAST	6-19-07	DK
620	APPLY COATINGS	6-12-07	EB
625	FINAL ASSEMBLY	6-28-07	RJL
640	FUNCTION TEST AND	PASS FAIL 7/9/07	WMB
650	TARGET	PASS FAIL 7/9/07	WMB
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
670	FINAL INSPECTION	7-11-07	DA
	A) HEADSPACE	PASS FAIL 7-11-07	DA
	B) TRIGGER PULL	222 2.18 2.13 2.18 2.18 7-11-07	DA
		2 LBS MIN 10 LBS MAX	
680	F) SAFETY ON FORCE	50 50 45 7-11-07	DA
		2 LBS MIN	
	G) SAFETY OFF FORCE	2.5 30 30 7-11-07	DA
		2 LBS MIN	
	I) FIRING PIN INDENT	.023 .023 .023 7-11-07	DA
690	PACK	7-11-07	DA




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

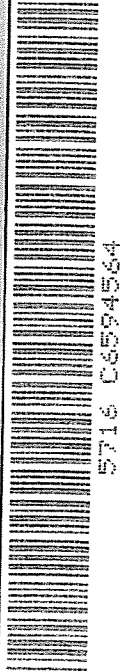
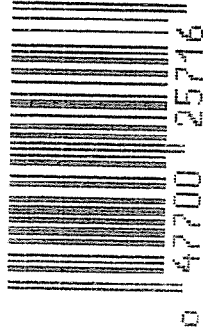
MODEL 700TM M24

SERIAL NO.
06594564

ORDER NO.
5716

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

UPC



MOD.		GA. CAL.	GUN #	ASSEM. #
#	DATE	MALFUNCTION/DEFECT		
TEST	1st	CG594564 shoe burst off don't eject		
	2nd	POLISHED EJECTOR K.S. Rep'd 1/21/91		
	3rd	100 Rd. test OK AC. 1-29-91		
	4th			
FUNCTION		RD 6654	Rev 1	

TEST INIT. ACTION TO CORRECT		ASSEM. #
PROOF		
TEST		
TGT		
PROOF		
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		

CONTRACT # DAAA21-87-C-0086

C6594564

GUN SERIAL #

~~C6954564~~

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		10/3/90	Kd
600	Proof		10/3/90	Kd
607	Check Headspace		10/3/90	Kd
610	Dis-assemble Gun		10/3/90	Kd
612	Magnaflux Barrel Action		11/1/90	KCR
	Magnaflux Bolt		11/1/90	KCR
615	Rollmark Caliber		11/1/90	GB
617	Drill and Tap Sight Holes		11/6/90	LB
618	Polish Barrel <i>P.B.</i>		11/7/90	LB
620	Apply Coatings (Barrel Action)		11-7-90	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		1/17/91	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		1/17/91	KS
	C) Inspect Ejector Hole for Chamfer		1/17/91	KS
	D) Oil Firing Pin Ass'y		1/17/91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		1-18-91	JS

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			1/18/91	WB
	G) Safety Off Force	2 1/2	2 1/2	2 1/2			1/18/91	WB
	H) Trigger Pull Test & Retainability						1-18-91	JH
	I) Firing Pin Indent	.020	.020	.020			1/18/91	WB
	J) Assemble Stock						1/18/91	KS
	K) Assemble Swivel Studs						2-4-91	AC
	L) Attach Front and Rear Sight Assemblies						1/18/91	KS
	M) Iron Sight Alignment						1/18/91	KS
	N) Detach Front & Rear Sights & place in numbered container						1/18/91	KS
	O) Attach Scope to Rifle						1/18/91	KS
	P) Detach & Attach Scope 20 Times						1/18/91	KS
640	Gallery Target & Test						1-20-91	DH
	A) Time						1-20-91	DH
	B) Malfunctions						1-20-91	DH
	C) Pierced Primers						1-20-91	DH
	D) Optical Clarity of Scope						1-20-91	DH
645	Inspect for Live Ammo						1-20-91	DH
655	Final Inspection							
	A) Headspace						2-4-91	AC
	B) Trigger Pull	2.13	2.16	2.18	2.15	2.17	2-1-91	JH
	C) Function						2-4-91	AC
660	Pack						3-19-91	DH

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

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

SERIAL NO

C6594564

~~C6594564~~

DATE

1-18-91

TESTER

[Signature]

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.47	2.25	2.46	2.13	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.47	2.34	2.29	2.16	
PULL #3	2.50	2.40	2.15	2.18	
PULL #4	2.37	2.32	2.30	2.15	
PULL #5	2.28	2.38	2.28	2.17	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.36	3.38		
PULL #2	3.37	3.32		
PULL #3	3.38	3.38		
PULL #4	3.32	3.36		
PULL #5	3.38	3.43		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.48	4.42		4.41
PULL #2	4.43	4.46		4.22
PULL #3	4.26	4.43		4.42
PULL #4	4.49	4.49		4.42
PULL #5	4.50	4.43		4.41
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6594564
21 Jan 1991

CENTROIDAL DISTANCES

0 TO	1	.0707248
1 TO	2	.231573
1 TO	3	.228239
1 TO	4	.0931719
1 TO	5	.217021

$\frac{2}{45}$ <----POA

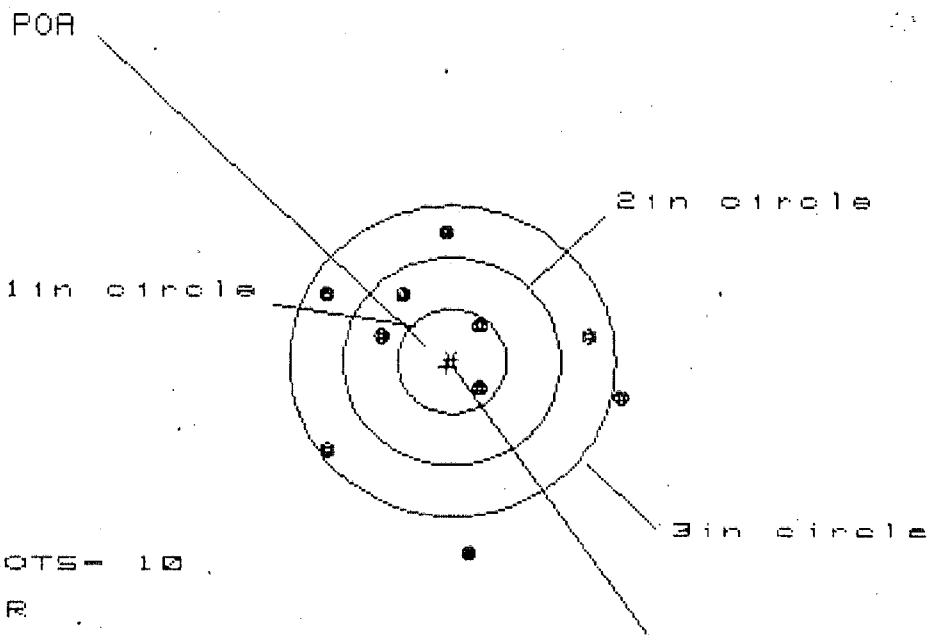
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0228
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0888
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0916803

THE AMR FOR THIS RIFLE IS: .8206

21 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C65945B4

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 2

2in = 4

3in = 8

HS= 2.660

VS= 3.136

GS= 3.142

CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.510	1.524	1.449
MINIMUM X	-1.150	-1.136	-.945
MAXIMUM Y	1.255	1.046	.980
MINIMUM Y	-1.881	-1.024	-1.090
CENTROID X	.049	.035	-.156
CENTROID Y	.051	.260	.326
POA TO CENTROID in.	.071	.263	.361
MIN RADIUS	.373	.350	.424
MEAN RADIUS	1.091	.971	.866
MAX RADIUS	1.885	1.613	1.449
HORIZONTAL SPREAD	2.660	2.660	2.394
VERTICAL SPREAD	3.136	2.070	2.070
EXTREME SPREAD	3.142	2.779	2.611
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	8		

21 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C65945B4

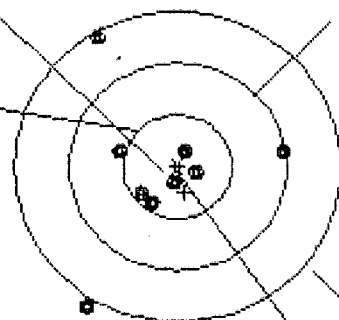
CENTERFIRE PATTERNS # 2

POA

1in circle

2in circle

3in circle



CENTROID *

OF SHOTS- 10

IN CIR

1in = 5

2in = 7

3in = 8

HS= 2.367

VS= 2.537

GS= 2.892

PATTERN #

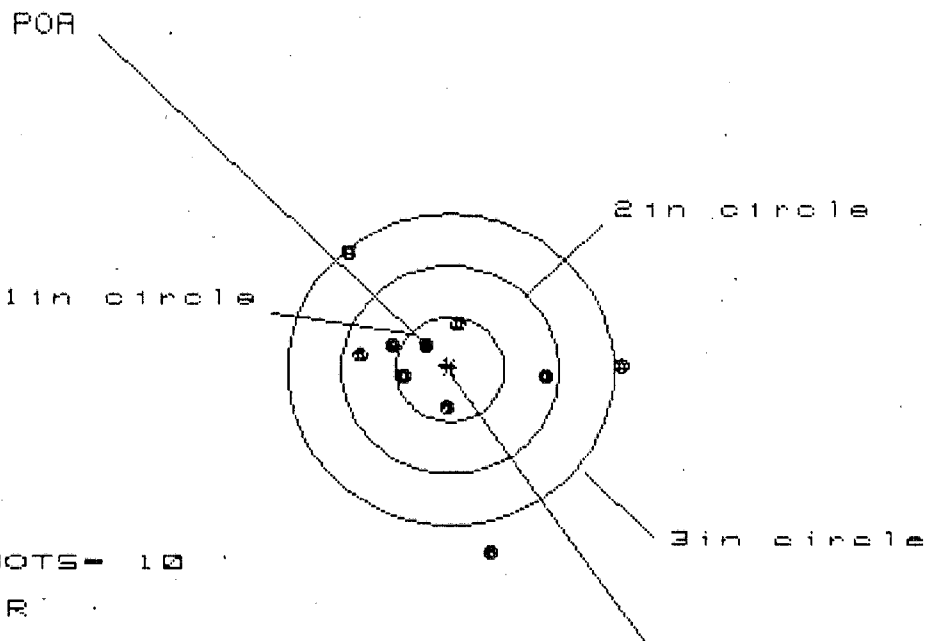
2

SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	-1.562	1.133	1.054
MINIMUM X	:	-.805	-.632	-.674
MAXIMUM Y	:	1.198	1.233	1.070
MINIMUM Y	:	-1.339	-1.304	-.513
CENTROID X	:	-.066	-.240	-.161
CENTROID Y	:	.252	.217	.380
POA TO CENTROID in.	:	.261	.323	.412
MIN RADIUS	:	.134	.158	.146
MEAN RADIUS	:	.741	.640	.547
MAX RADIUS	:	1.594	1.449	1.265
HORIZONTAL SPREAD	:	2.367	1.765	1.728
VERTICAL SPREAD	:	2.537	2.537	1.583
EXTREME SPREAD	:	2.892	2.537	1.998
NUMBER IN ONE INCH CIRCLE =	:	5		
NUMBER IN TWO INCH CIRCLE =	:	7		
NUMBER IN THREE INCH CIRCLE =	:	8		

21 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6594564

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 4

2in = 7

3in = 8

HS= 2.413

VS= 2.860

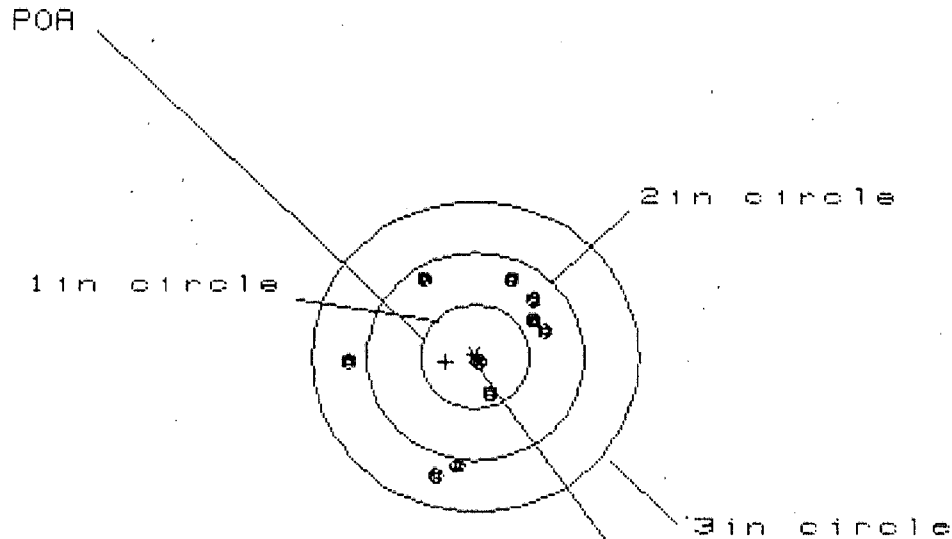
GS= 3.125

PATTERN #	:	4	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.532	1.575	1.137
MINIMUM X	:	-.881	-.838	-.642
MAXIMUM Y	:	1.115	.921	.900
MINIMUM Y	:	-1.745	-.531	-.552
CENTROID X	:	.029	-.014	-.210
CENTROID Y	:	-.040	.154	.175
POA TO CENTROID in.	:	.049	.154	.273
MIN RADIUS	:	.330	.186	.036
MEAN RADIUS	:	.864	.730	.572
MAX RADIUS	:	1.785	1.583	1.169
HORIZONTAL SPREAD	:	2.413	2.413	1.779
VERTICAL SPREAD	:	2.860	1.452	1.452
EXTREME SPREAD	:	3.125	2.647	2.130
NUMBER IN ONE INCH CIRCLE =	:	4		
NUMBER IN TWO INCH CIRCLE =	:	7		
NUMBER IN THREE INCH CIRCLE =	:	8		

21 Jan 1991

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 2

2in = 7

3in = 10

HS= 1.729

VS= 1.966

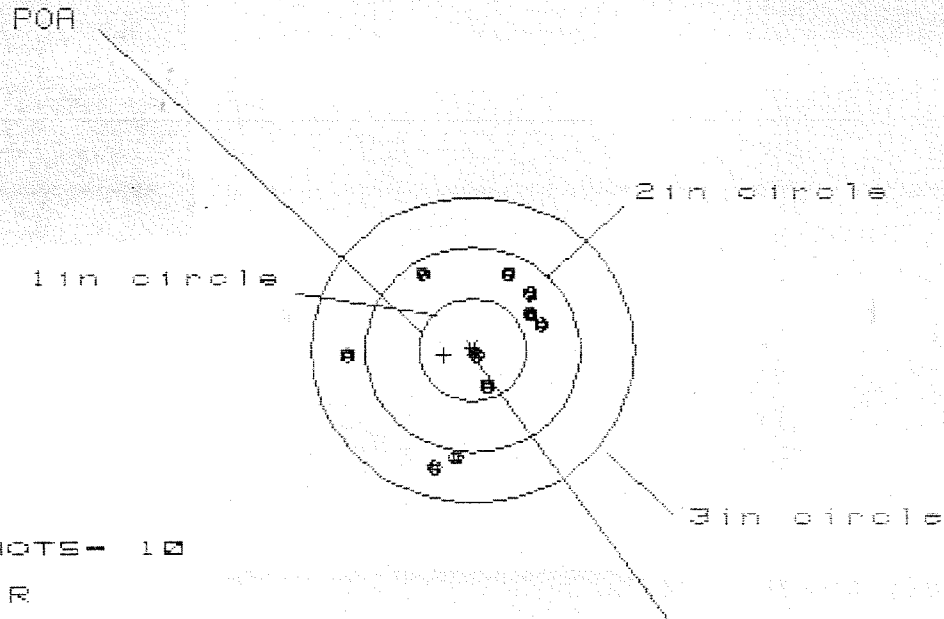
GS= 2.038

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.603	.558	.412
MINIMUM X	:	-1.126	-1.171	-.656
MAXIMUM Y	:	.795	.664	.640
MINIMUM Y	:	-1.171	-1.227	-1.251
CENTROID X	:	.266	.311	.457
CENTROID Y	:	.048	.179	.203
POA TO CENTROID in.	:	.270	.359	.500
MIN RADIUS	:	.072	.167	.229
MEAN RADIUS	:	.765	.697	.603
MAX RADIUS	:	1.240	1.239	1.292
HORIZONTAL SPREAD	:	1.729	1.729	1.068
VERTICAL SPREAD	:	1.966	1.891	1.891
EXTREME SPREAD	:	2.038	1.920	1.920
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

21 Jan 1991

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

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CENTROID #

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EXTREME SPREAD	:	2.038	1.920	1.920
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	