

06594648

MODEL 700™ M24

Model **SWS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



Repair Inquiry

Repair Number: RE00127460

Serial: C6594648 Model M24 SWS Center Fire
Caliber: 308 WIN

Repairman:

Verify Repair

Status:

Closed 3/30/2007 10:17:17 AM

Address Information

Customer:

Received From

Return To:

Received From

Name: CO C 1ST / 20TH S.F.G.

CO C 1ST / 20TH S.F.G.

Address 1: MASSACHUSETTS ARMY NATIONAL GUARD

MASSACHUSETTS ARMY NATIONAL GUARD

Address 2: 1505 ROOSEVELT AVENUE

PO Box:

1505 ROOSEVELT AVENUE

PO Box:

City: SPRINGFIELD

SPRINGFIELD

State: MA

Zip Code: 01109-2438

Country: US

State: MA

Zip Code: 01109-2438

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
A006	Sling Strap	1
A007	With Stud	3
A010	Hard Case	1
A017	Scope Base	1
A026	Scope	1
B000	FRONT/REAR BASE	1
B001	SCOPE CASE	1

Repair Search

Refresh

Close

naglej

3/30/2007

11:13 AM

CAPS

NUM

INS

SCFL

Serial
Number:

C6594648

Model: M24 SWS



RE00127460

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6594648.___0
FILE DATE AND TIME: 05/08/2007 13:05

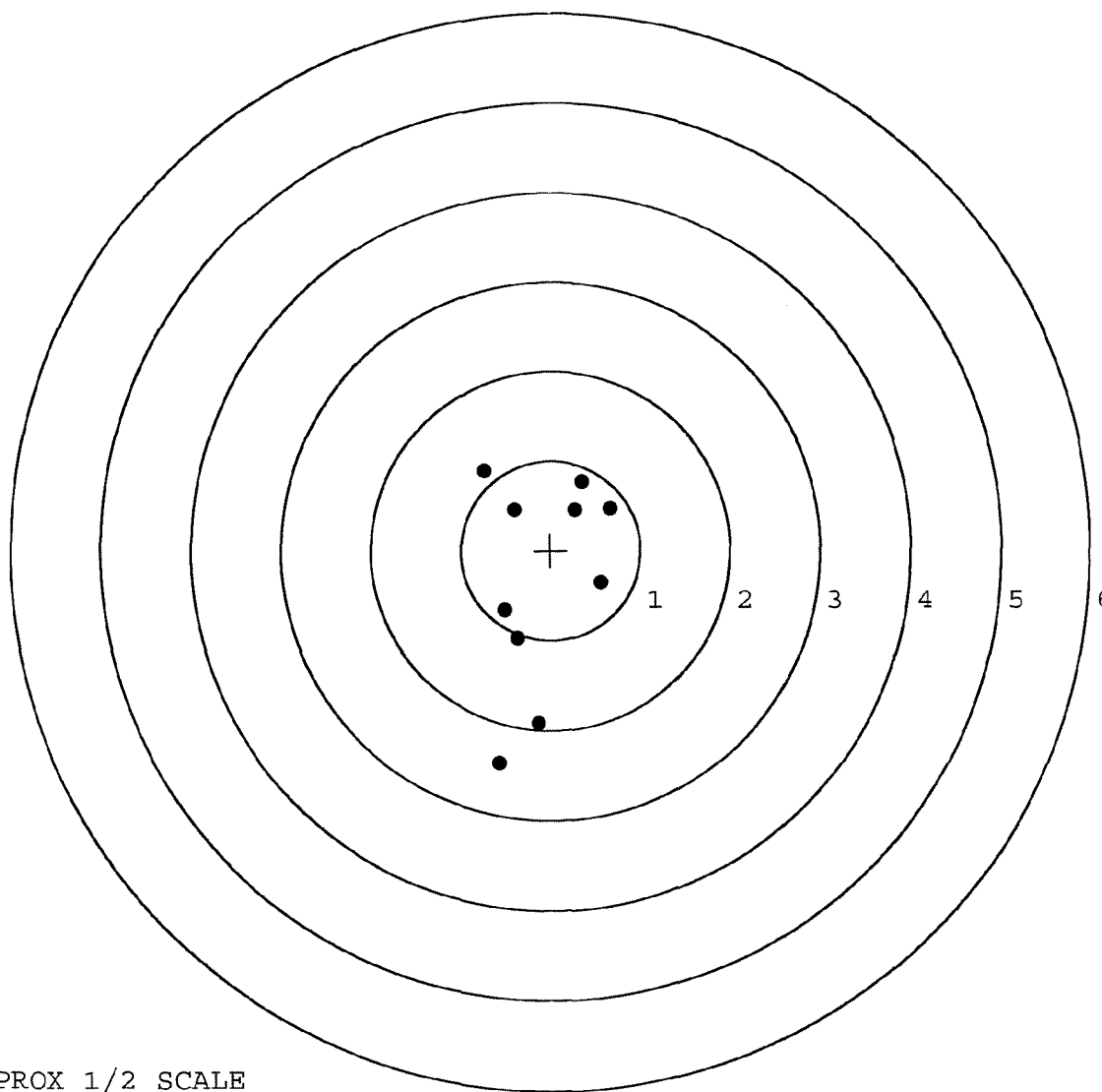
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.025
The Average Y Centroid of the Five Target Set:	-0.111
The Average Point of Impact of the Five Target Set:	0.114
The Average Mean Radius of the Five Target Set:	0.943
The Distance from POA to Centroid Target #1:	0.338
The Distance from Centroid Target #2 to Centroid Target #1:	0.379
The Distance from Centroid Target #3 to Centroid Target #1:	0.396
The Distance from Centroid Target #4 to Centroid Target #1:	0.112
The Distance from Centroid Target #5 to Centroid Target #1:	0.292

SERIAL NUMBER: C6594648. 0
TARGET NUMBER: 1
FILE DATE: 05/08/2007
FILE TIME: 13:05

X CENTROID: -0.091
Y CENTROID: -0.325
POA TO CENTROID: 0.338
HORZ SPREAD: 1.397
VERT SPREAD: 3.254
GROUP SPREAD: 3.263
MIN RADIUS: 0.547
MAX RADIUS: 2.093
MEAN RADIUS: 1.099
IN 1 IN DIAMETER: 0
IN 2 IN DIAMETER: 5
in 3 IN DIAMETER: 8

POINT#	X	Y
1:	-0.374	-0.986
2:	-0.516	-0.670
3:	0.566	-0.357
4:	0.663	0.472
5:	0.269	0.459
6:	0.347	0.769
7:	-0.407	0.459
8:	-0.734	0.893
9:	-0.145	-1.931
10:	-0.576	-2.361

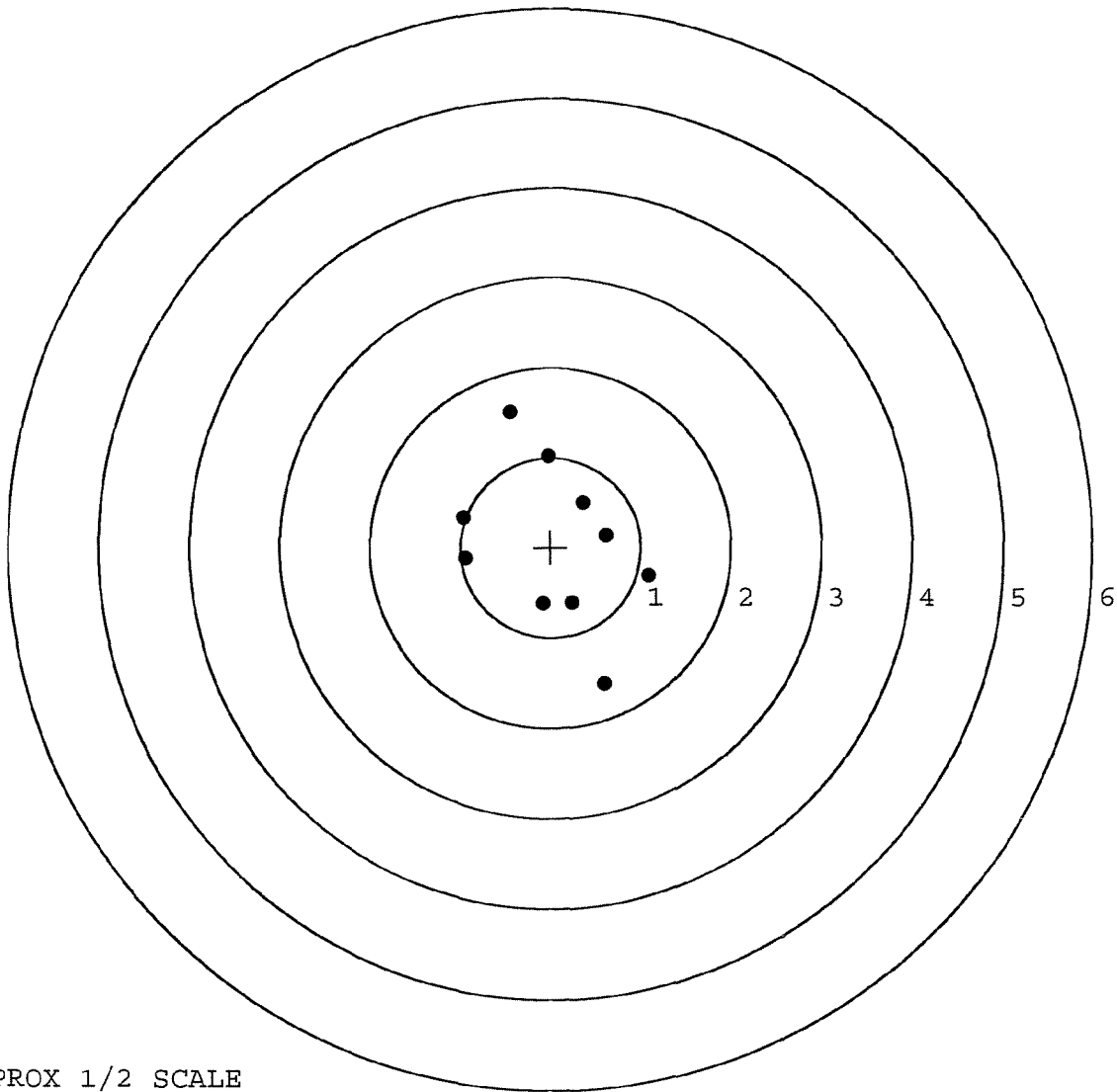


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6594648. __0
TARGET NUMBER: 2
FILE DATE: 05/08/2007
FILE TIME: 13:05

X CENTROID: 0.041
Y CENTROID: 0.030
POA TO CENTROID: 0.050
HORZ SPREAD: 2.064
VERT SPREAD: 3.026
GROUP SPREAD: 3.203
MIN RADIUS: 0.569
MAX RADIUS: 1.640
MEAN RADIUS: 0.985
IN 1 IN DIAMETER: 0
IN 2 IN DIAMETER: 6
in 3 IN DIAMETER: 8

POINT#	X	Y
1:	1.092	-0.317
2:	0.235	-0.617
3:	-0.087	-0.632
4:	0.613	0.134
5:	0.357	0.503
6:	-0.033	1.016
7:	-0.455	1.513
8:	-0.972	0.336
9:	-0.940	-0.123
10:	0.596	-1.513



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6594648. 0

TARGET NUMBER: 3

FILE DATE: 05/08/2007

FILE TIME: 13:05

X CENTROID: -0.120

Y CENTROID: 0.070

POA TO CENTROID: 0.138

HORZ SPREAD: 1.560

VERT SPREAD: 2.772

GROUP SPREAD: 3.147

MIN RADIUS: 0.230

MAX RADIUS: 1.782

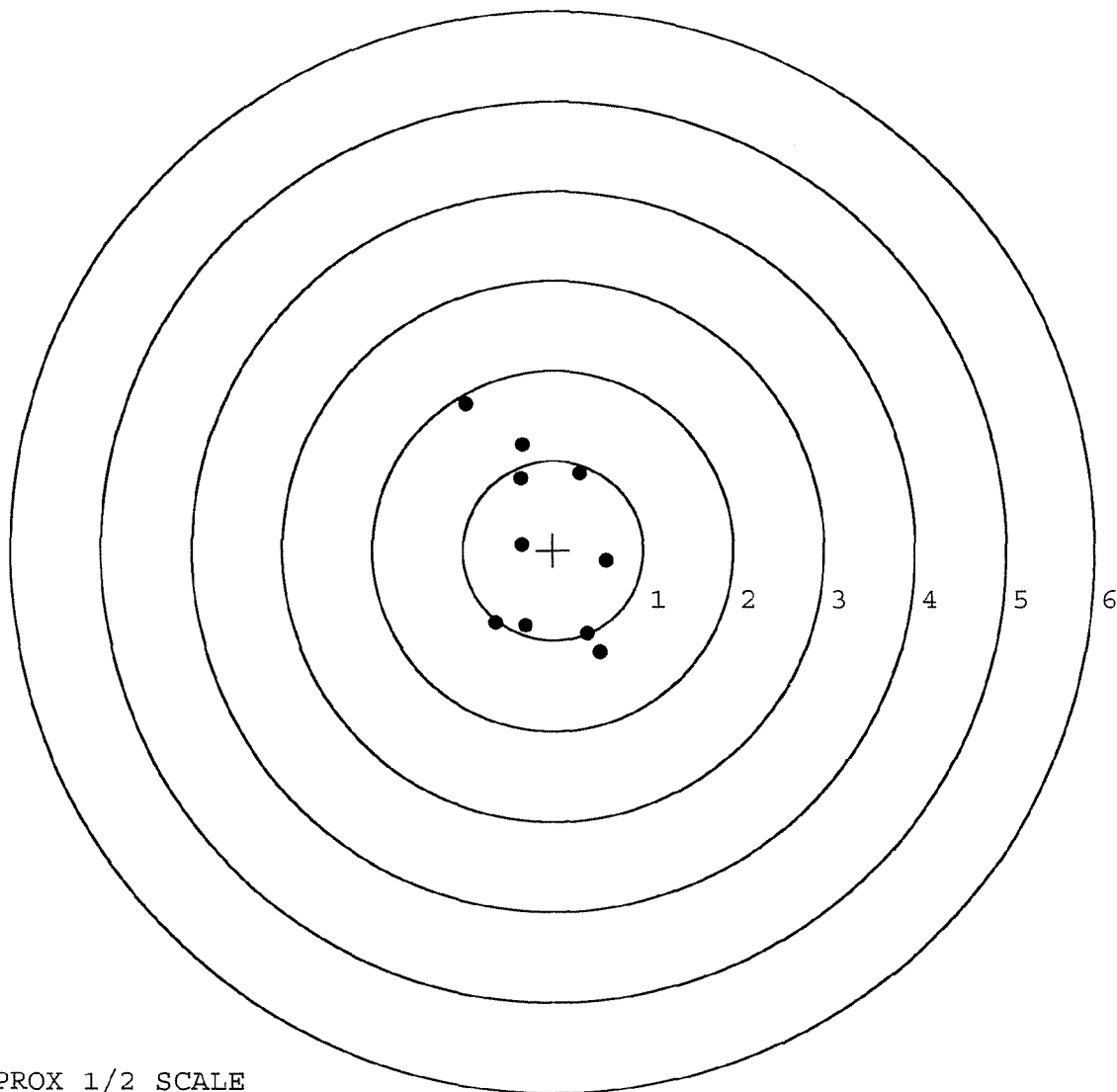
MEAN RADIUS: 0.998

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 5

in 3 IN DIAMETER: 9

POINT#	X	Y
1:	0.521	-1.135
2:	0.377	-0.928
3:	0.592	-0.124
4:	-0.350	0.063
5:	-0.315	-0.841
6:	-0.643	-0.812
7:	0.294	0.861
8:	-0.363	0.801
9:	-0.341	1.175
10:	-0.968	1.637



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6594648. 0

TARGET NUMBER: 4

FILE DATE: 05/08/2007

FILE TIME: 13:05

X CENTROID: -0.066

Y CENTROID: -0.216

POA TO CENTROID: 0.226

HORZ SPREAD: 2.191

VERT SPREAD: 1.598

GROUP SPREAD: 2.313

MIN RADIUS: 0.224

MAX RADIUS: 1.204

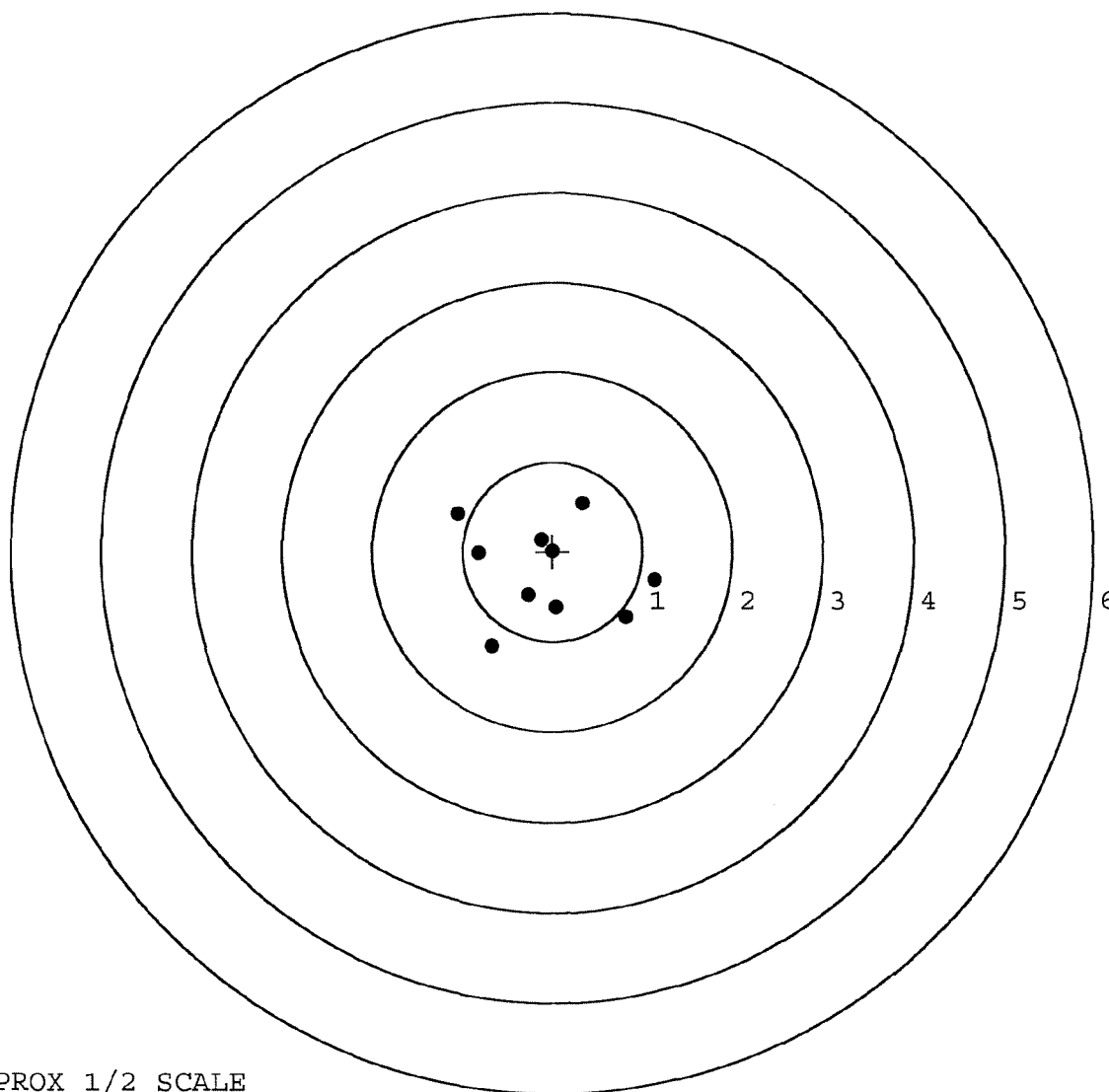
MEAN RADIUS: 0.743

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	1.134	-0.321
2:	0.813	-0.734
3:	-0.681	-1.056
4:	0.036	-0.630
5:	-0.276	-0.492
6:	0.327	0.542
7:	-0.822	-0.018
8:	-1.057	0.421
9:	-0.126	0.128
10:	-0.005	-0.001

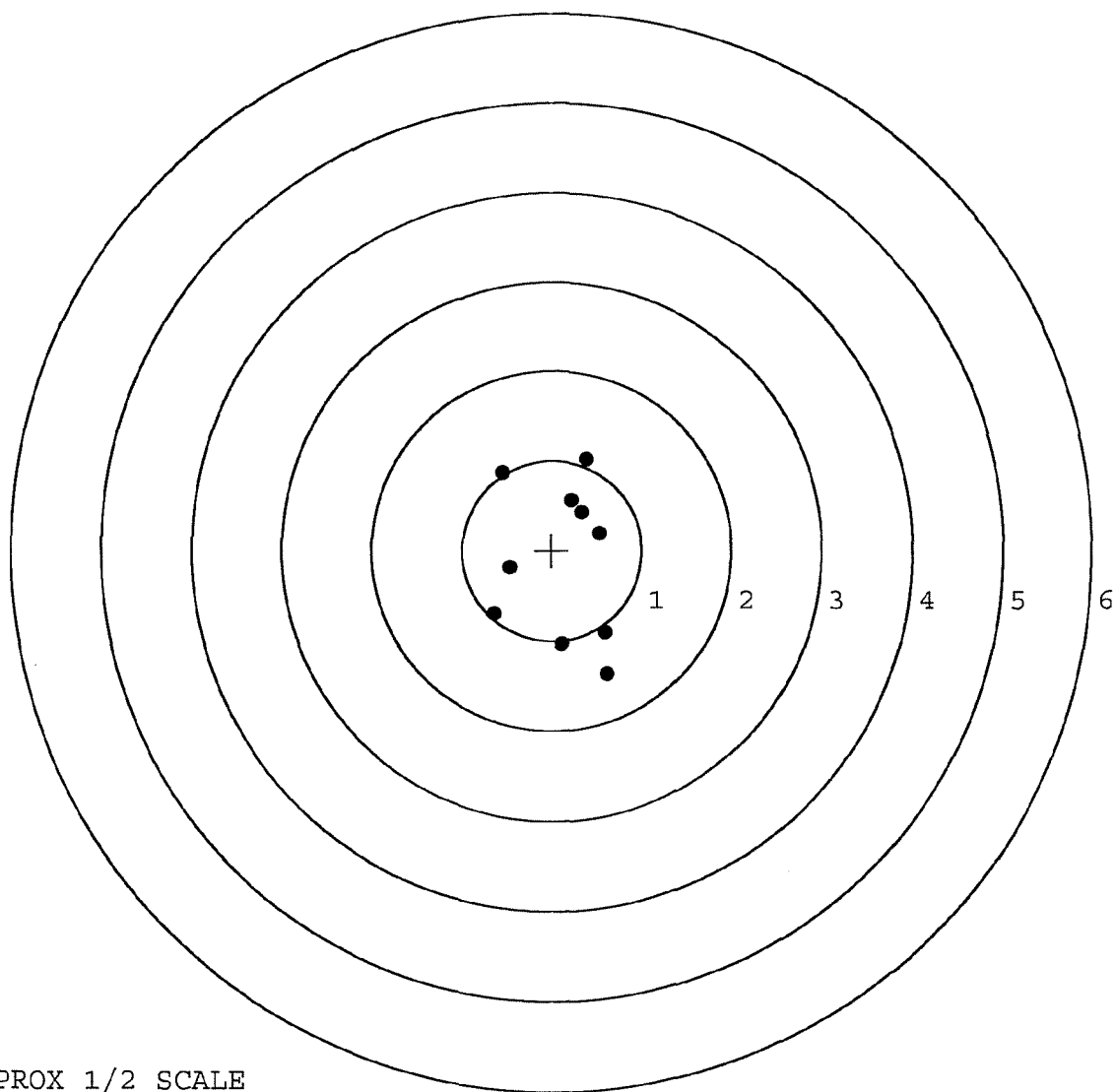


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6594648. 0
TARGET NUMBER: 5
FILE DATE: 05/08/2007
FILE TIME: 13:05

X CENTROID: 0.112
Y CENTROID: -0.115
POA TO CENTROID: 0.161
HORZ SPREAD: 1.265
VERT SPREAD: 2.396
GROUP SPREAD: 2.536
MIN RADIUS: 0.522
MAX RADIUS: 1.361
MEAN RADIUS: 0.892
IN 1 IN DIAMETER: 0
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 10

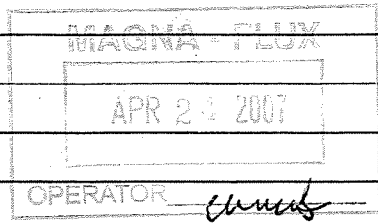
POINT#	X	Y
1:	0.620	-1.378
2:	0.111	-1.046
3:	0.592	-0.910
4:	-0.645	-0.703
5:	-0.472	-0.192
6:	0.532	0.196
7:	0.327	0.429
8:	0.214	0.564
9:	0.392	1.018
10:	-0.549	0.873



TARGET APPROX 1/2 SCALE

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

R & E NUMBER	127460		
SERIAL NUMBER	C6594648		
LOG-IN DATE	3-3-07 3-30-07		
OPERATION #	OPERATION NAME	DATE	INITIAL
500	DIS-ASSEMBLE GUN	4-17-07	RTZ
505	RE-BARREL	4-20-07	RTZ
560	ASSEMBLE	4-19-07	TRW
600	PROOF	4-19-07	TRW
605	CHECK HEADSPACE	4-19-07	TRW
610	DIS-ASSEMBLE GUN	4-20-07	RTZ
612	MAGNAFLUX	4/24/07	unmarked
510	DRILL AND TAP	4-24-07	TRW
615	ROLLMARK CALIBER	4-24-07	TRW
618	ROTO-BLAST	4-24-07	LB
620	APPLY COATINGS	4-27-07	W
625	FINAL ASSEMBLY	5-7-07	RTZ
640	FUNCTION TEST AND	PASS FAIL 5-8-07	TRW
650	TARGET	PASS FAIL 5-8-07	TRW
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
670	FINAL INSPECTION	5-8-07	CHS
	A) HEADSPACE	PASS FAIL 5-11-07	RTZ RR
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	2.39 2.41 2.41 2.40 2.34 5-9-07 TRW
680	F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX	6.5 6.5 6.5 5-9-07 TRW
	G) SAFETY OFF FORCE	2 LBS MIN	2.5 2.75 2.5 5-9-07 TRW
	I) FIRING PIN INDENT	.020	.021 .022 .0215 5-9-07 TRW
690	PACK		5-14-07 RTZ



N/A




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

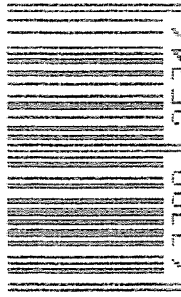
MODEL 700™ H24

SERIAL NO.
06594648

ORDER NO.
5716

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

UPC



0 47700 25716



5716 06594648

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6594648

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		12/21/90	K.S.
600	Proof		12/21/90	K.S.
607	Check Headspace		12/21/90	K.S.
610	Dis-assemble Gun		12/21/90	K.S.
612	Magnaflux Barrel Action		1/9/91	KR
	Magnaflux Bolt		"	KR
615	Rollmark Caliber		"	GB
617	Drill and Tap Sight Holes	1 10 91		LB
618	Polish Barrel	1 10 91		WB
620	Apply Coatings (Barrel Action)		1-22-91	TH
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		1/28/91	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		1/28/91	KS
	C) Inspect Ejector Hole for Chamfer		1/28/91	KS
	D) Oil Firing Pin Ass'y		1/28/91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		1/29/91	JP

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			1/29/91	WB
	G) Safety Off Force	2 3/4	2 3/4	2 3/4			1/29/91	WB
	H) Trigger Pull Test & Retainability						1/29/91	YU
	I) Firing Pin Indent	.0705	.020	.020			1/29/91	WB
	J) Assemble Stock						1/29/91	KS
	K) Assemble Swivel Studs						2-4-91	AC
	L) Attach Front and Rear Sight Assemblies						1/29/91	KS
	M) Iron Sight Alignment						1/29/91	KS
	N) Detach Front & Rear Sights & place in numbered container						1/29/91	KS
	O) Attach Scope to Rifle						1/29/91	KS
	P) Detach & Attach Scope 20 Times						1/29/91	KS
640	Gallery Target & Test						1-30-91	DH
	A) Time						1-30-91	DH
	B) Malfunctions						1-30-91	DH
	C) Pierced Primers						1-30-91	DH
	D) Optical Clarity of Scope						1-30-91	DH
645	Inspect for Live Ammo						1-30-91	DH
655	Final Inspection							
	A) Headspace						2-4-91	AC
	B) Trigger Pull	2.35	2.29	2.27	2.29	2.26	2-1-91	YU
	C) Function						2-4-91	AC
660	Pack						3-19-91	VF

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

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

SERIAL NO. C6594648

DATE 1-29-81

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.41	2.40	2.29	2.35	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.34	2.39	2.39	2.29	
PULL #3	2.39	2.24	2.20	2.27	
PULL #4	2.42	2.37	2.31	2.29	
PULL #5	2.40	2.37	2.39	2.26	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.10	3.37		
PULL #2	3.51	3.37		
PULL #3	3.22	3.47		
PULL #4	3.38	3.43		
PULL #5	3.29	3.33		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.32	4.29		4.22
PULL #2	4.34	4.40		4.11
PULL #3	4.47	4.33		4.16
PULL #4	4.46	4.31		4.19
PULL #5	4.46	4.23		4.29
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6594648
30 Jan 1991

CENTROIDAL DISTANCES

0 TO 1	.07245
1 TO 2	.152109
1 TO 3	.162635
1 TO 4	.276442
1 TO 5	.0443847

44 (----POB

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0242
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0386
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0455588
THE AMR FOR THIS RIFLE IS: .8592

30 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06594648

CENTERFIRE PATTERNS # 1

POR

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 1

2in = 8

3in = 10

HE= 1.694

VS= 1.906

GS= 2.051

CENTROID *

PATTERN #	1	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.751	.726	.605
MINIMUM X	-.943	-.968	-.960
MAXIMUM Y	.559	.409	.413
MINIMUM Y	-1.347	-.495	-.491
CENTROID X	.068	.093	.214
CENTROID Y	.025	.175	.171
POR TO CENTROID in.	.072	.198	.274
MIN RADIUS	.206	.135	.156
MEAN RADIUS	.751	.652	.603
MAX RADIUS	1.367	.969	.962
HORIZONTAL SPREAD	1.694	1.694	1.565
VERTICAL SPREAD	1.906	.904	.904
EXTREME SPREAD	2.051	1.773	1.658
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	9		
NUMBER IN THREE INCH CIRCLE =	10		

30 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06534648

CENTERFIRE PATTERNS # 2

POA

1in circle

2in circle

3in circle

CENTROID #

OF SHOTS- 10

IN CIR

1in = 3

2in = 7

3in = 9

HS= 2.459

VS= 1.800

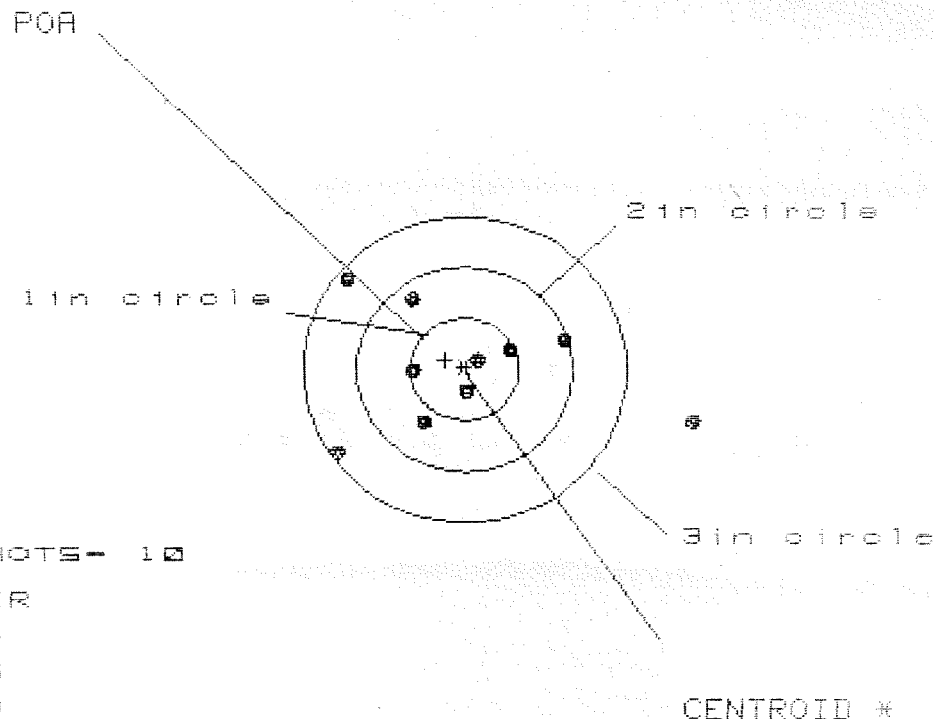
QS= 2.859

PATTERN #	:	2	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.036	.877	.981
MINIMUM X	:	-1.433	-.988	-.884
MAXIMUM Y	:	1.007	.929	.681
MINIMUM Y	:	-.793	-.871	-.754
CENTROID X	:	-.043	.117	.013
CENTROID Y	:	-.079	-.001	-.118
POA TO CENTROID in.	:	.089	.117	.118
MIN RADIUS	:	.224	.253	.288
MEAN RADIUS	:	.801	.710	.631
MAX RADIUS	:	1.593	1.245	.990
HORIZONTAL SPREAD	:	2.469	1.865	1.865
VERTICAL SPREAD	:	1.800	1.800	1.436
EXTREME SPREAD	:	2.959	2.207	1.896
NUMBER IN ONE INCH CIRCLE	=	3		
NUMBER IN TWO INCH CIRCLE	=	7		
NUMBER IN THREE INCH CIRCLE	=	9		

30 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6534648

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 4

2 in = 6

3 in = 9

HS= 3.305

VS= 1.694

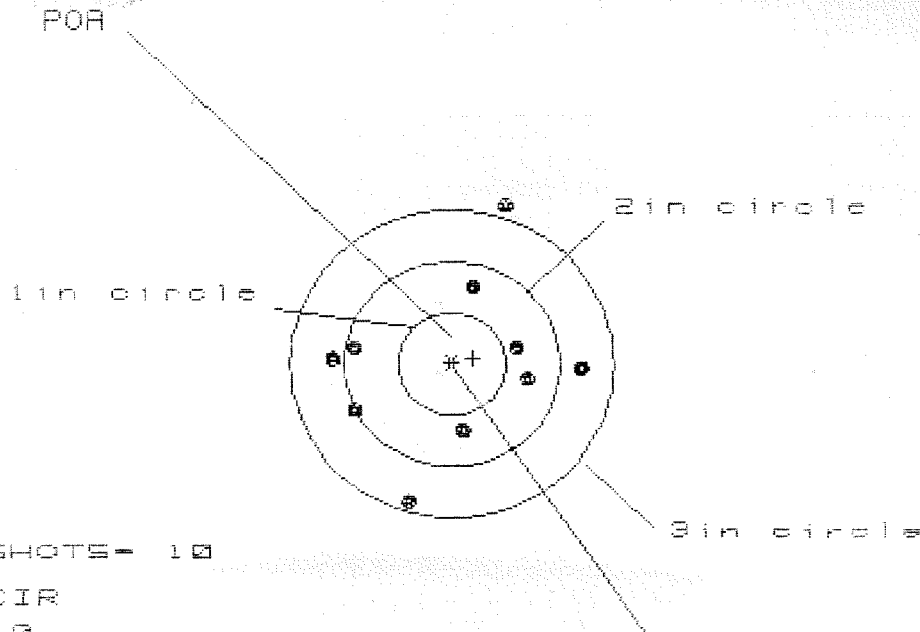
QS= 3.475

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.109	1.201	1.081
MINIMUM X	:	-1.196	-.961	-.936
MAXIMUM Y	:	.892	.830	.722
MINIMUM Y	:	-.802	-.864	-.724
CENTROID X	:	.183	-.052	.068
CENTROID Y	:	-.090	-.028	.090
POA TO CENTROID in.	:	.203	.059	.105
MIN RADIUS	:	.143	.251	.226
MEAN RADIUS	:	.878	.728	.648
MAX RADIUS	:	2.181	1.292	1.183
HORIZONTAL SPREAD	:	3.305	2.162	2.017
VERTICAL SPREAD	:	1.694	1.694	1.446
EXTREME SPREAD	:	3.475	2.435	2.097
NUMBER IN ONE INCH CIRCLE =			4	
NUMBER IN TWO INCH CIRCLE =			6	
NUMBER IN THREE INCH CIRCLE =			9	

30 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06534648

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 0

2in = 5

3in = 9

HS= 2.291

VS= 2.836

GS= 2.961

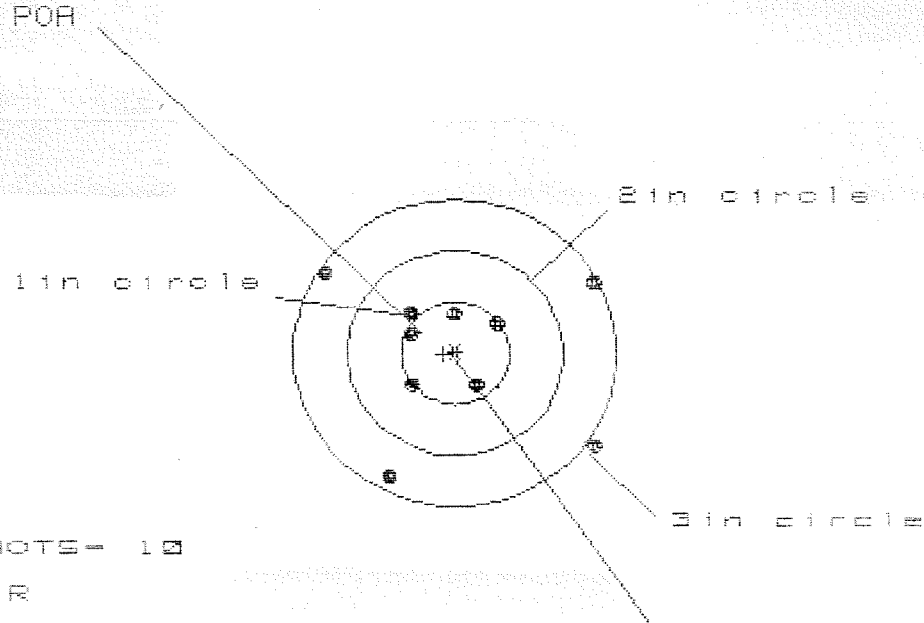
CENTROID #

PATTERN #	:	4	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.208	1.262	1.222
MINIMUM X	:	-1.083	-1.029	-1.069
MAXIMUM Y	:	1.517	.921	.777
MINIMUM Y	:	-1.319	-1.150	-.600
CENTROID X	:	-.196	-.250	-.210
CENTROID Y	:	-.057	-.226	-.082
POA TO CENTROID in.	:	.204	.337	.226
MIN RADIUS	:	.627	.470	.604
MEAN RADIUS	:	.993	.914	.871
MAX RADIUS	:	1.593	1.272	1.223
HORIZONTAL SPREAD	:	2.291	2.291	2.291
VERTICAL SPREAD	:	2.836	2.071	1.377
EXTREME SPREAD	:	2.961	2.291	2.291
NUMBER IN ONE INCH CIRCLE =	:	0		
NUMBER IN TWO INCH CIRCLE =	:	5		
NUMBER IN THREE INCH CIRCLE =	:	9		

30 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/05594648

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 4

2in = 6

3in = 9

HS= 2.582

VS= 2.000

GS= 3.065

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.325	1.408	1.270
MINIMUM X	:	-1.257	-1.110	-.646
MAXIMUM Y	:	.782	.686	.646
MINIMUM Y	:	-1.224	-1.320	-1.235
CENTROID X	:	.109	-.038	.100
CENTROID Y	:	.008	.104	.019
POA TO CENTROID in.	:	.109	.111	.102
MIN RADIUS	:	.417	.248	.408
MEAN RADIUS	:	.873	.762	.706
MAX RADIUS	:	1.585	1.516	1.425
HORIZONTAL SPREAD	:	2.582	2.518	1.916
VERTICAL SPREAD	:	2.006	2.006	1.881
EXTREME SPREAD	:	3.065	2.685	2.685
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	