

C6348934

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.



SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6348934.___0

FILE DATE AND TIME: 08/24/2002 13:51

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.026
The Average Y Centroid of the Five Target Set:	-0.067
The Average Point of Impact of the Five Target Set:	0.072
The Average Mean Radius of the Five Target Set:	0.577
The Distance from POA to Centroid Target #1:	0.093
The Distance from Centroid Target #2 to Centroid Target #1:	0.198
The Distance from Centroid Target #3 to Centroid Target #1:	0.215
The Distance from Centroid Target #4 to Centroid Target #1:	0.142
The Distance from Centroid Target #5 to Centroid Target #1:	0.263

SERIAL NUMBER: C6348934. __0

TARGET NUMBER: 1

FILE DATE: 08/24/2002

FILE TIME: 13:51

POINT#	X	Y
1:	0.791	-0.501
2:	0.458	-0.481
3:	0.191	-0.476
4:	-0.115	-0.336
5:	-0.730	-0.495
6:	-0.600	0.366
7:	0.094	0.202
8:	-0.075	0.456
9:	-0.092	0.095
10:	0.779	1.776

X CENTROID: 0.070

Y CENTROID: 0.061

POA TO CENTROID: 0.093

HORZ SPREAD: 1.521

VERT SPREAD: 2.277

GROUP SPREAD: 2.727

MIN RADIUS: 0.143

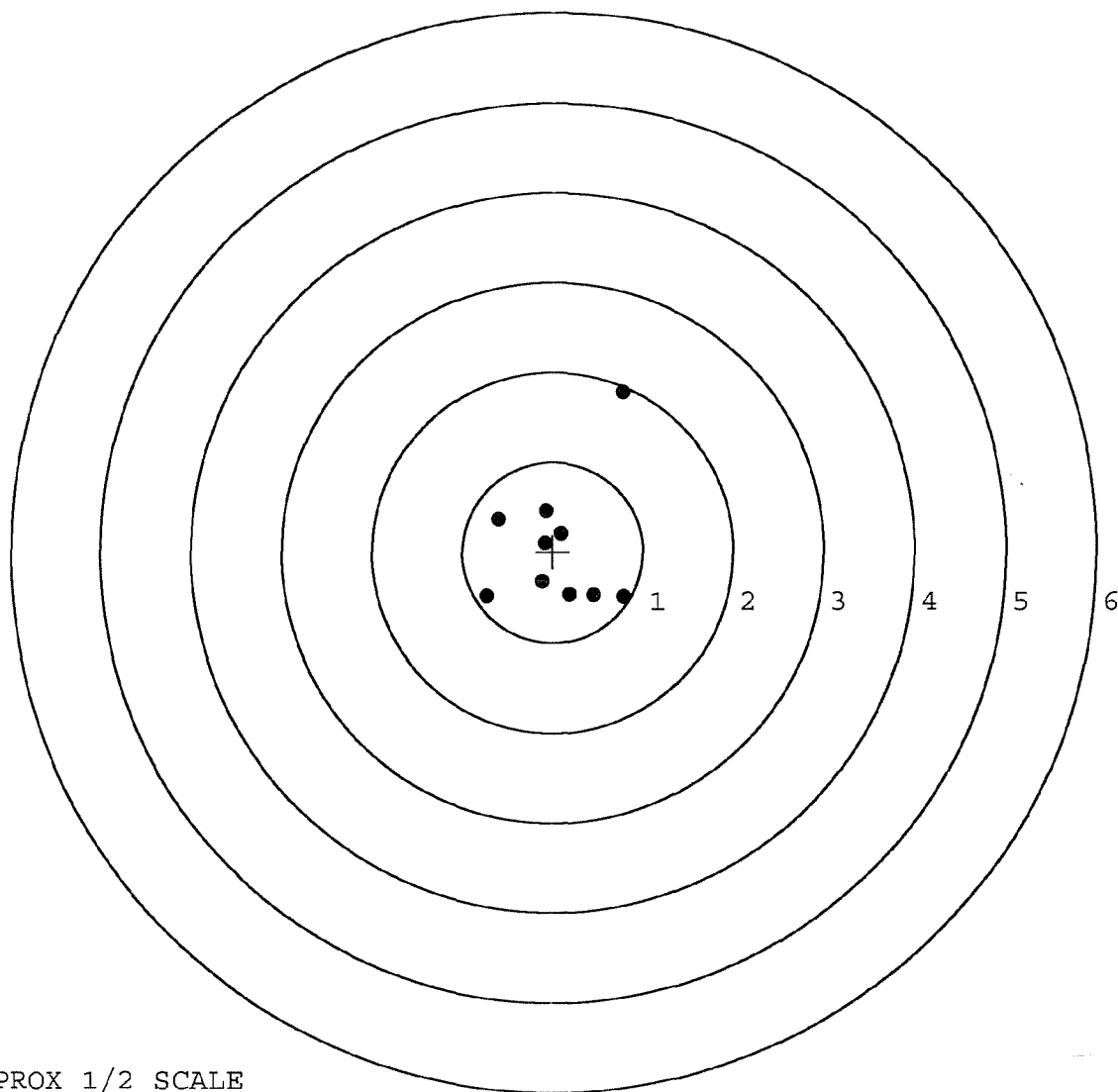
MAX RADIUS: 1.856

MEAN RADIUS: 0.686

IN 1 IN DIAMETER: 4

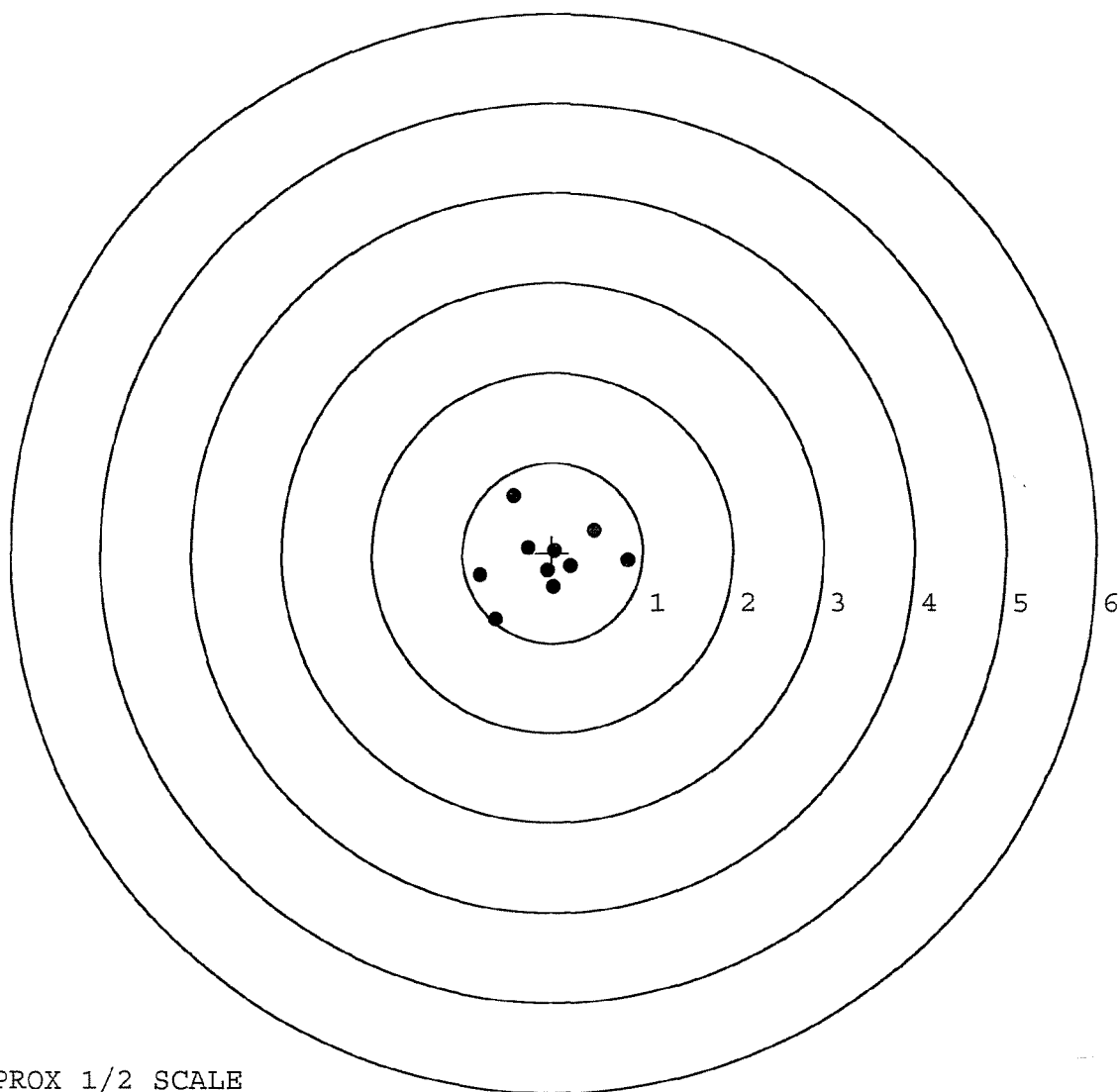
IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6348934. __0	POINT#	X	Y
TARGET NUMBER: 2	1:	0.836	-0.086
FILE DATE: 08/24/2002	2:	0.455	0.251
FILE TIME: 13:51	3:	-0.438	0.631
	4:	-0.801	-0.253
X CENTROID: -0.066	5:	-0.630	-0.740
Y CENTROID: -0.083	6:	0.015	-0.382
POA TO CENTROID: 0.106	7:	0.206	-0.144
HORZ SPREAD: 1.637	8:	-0.058	-0.196
VERT SPREAD: 1.371	9:	0.032	0.026
GROUP SPREAD: 1.645	10:	-0.279	0.059
MIN RADIUS: 0.113			
MAX RADIUS: 0.902			
MEAN RADIUS: 0.505			
# IN 1 IN DIAMETER: 5			
# IN 2 IN DIAMETER: 10			
# in 3 IN DIAMETER: 10			



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6348934. __0

TARGET NUMBER: 3

FILE DATE: 08/24/2002

FILE TIME: 13:51

POINT#	X	Y
1:	0.068	-0.954
2:	0.020	-0.709
3:	-0.036	-0.393
4:	0.192	-0.226
5:	0.456	-0.017
6:	0.872	0.073
7:	-0.454	-0.098
8:	-0.558	0.110
9:	-0.692	0.939
10:	-0.015	-0.090

X CENTROID: -0.015

Y CENTROID: -0.137

POA TO CENTROID: 0.137

HORZ SPREAD: 1.564

VERT SPREAD: 1.893

GROUP SPREAD: 2.040

MIN RADIUS: 0.047

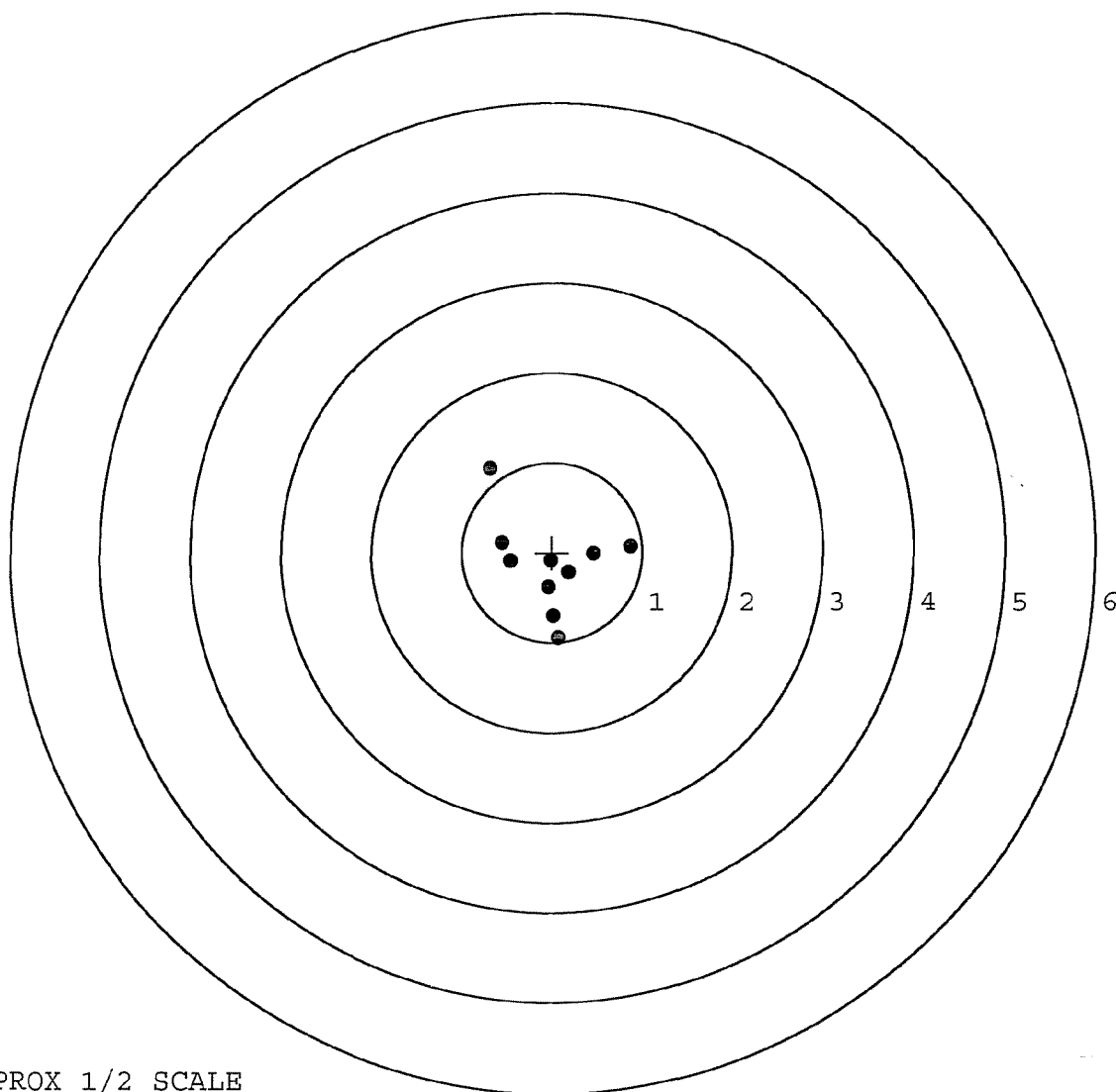
MAX RADIUS: 1.271

MEAN RADIUS: 0.563

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6348934. 0

TARGET NUMBER: 4

FILE DATE: 08/24/2002

FILE TIME: 13:51

POINT#	X	Y
1:	0.522	-0.568
2:	0.437	-0.328
3:	0.206	-0.080
4:	0.448	0.267
5:	0.352	0.685
6:	-0.692	0.229
7:	-0.458	0.256
8:	-0.326	-0.241
9:	-0.340	-0.733
10:	-0.003	-0.190

X CENTROID: 0.015

Y CENTROID: -0.070

POA TO CENTROID: 0.072

HORZ SPREAD: 1.214

VERT SPREAD: 1.418

GROUP SPREAD: 1.578

MIN RADIUS: 0.121

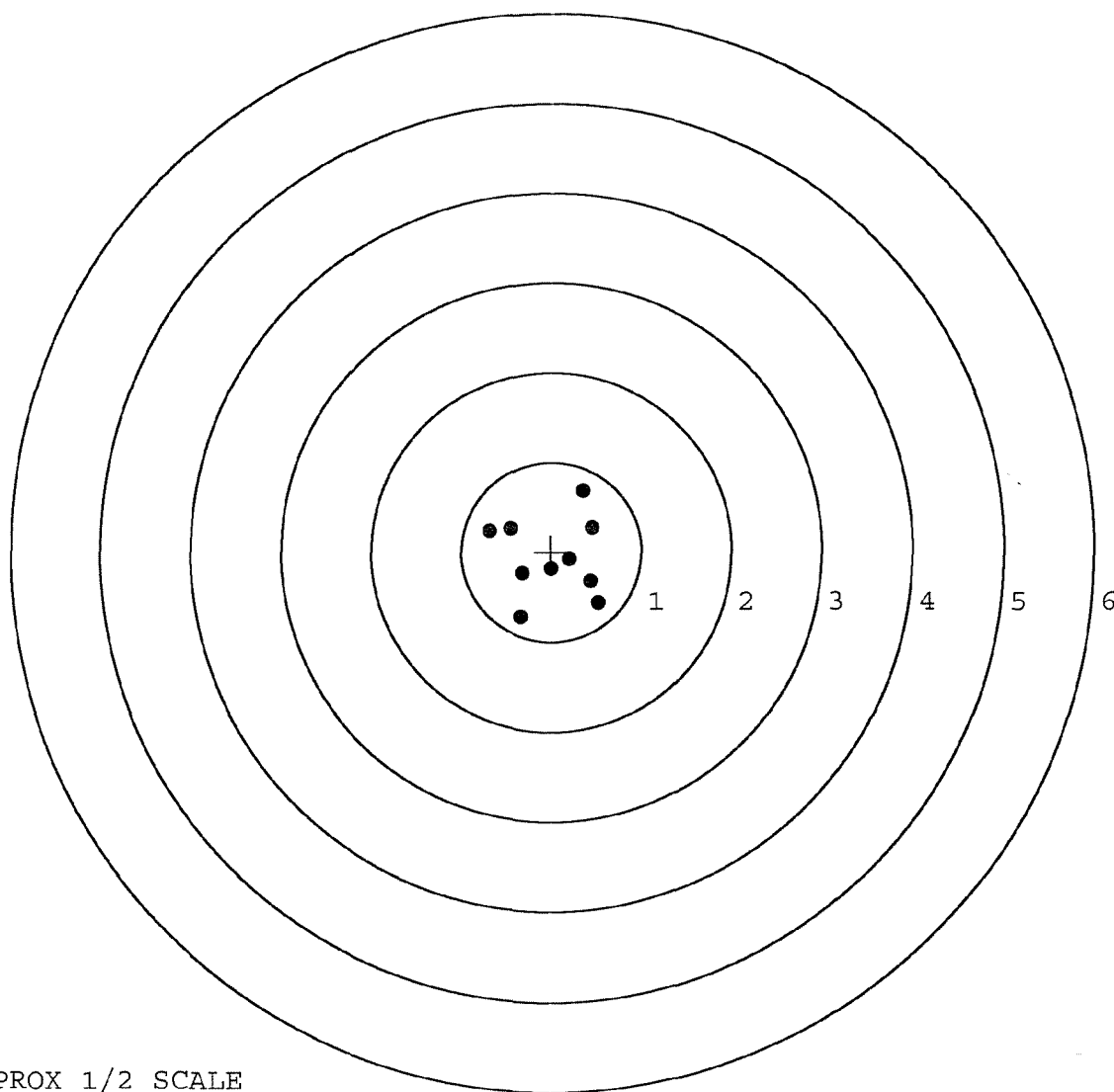
MAX RADIUS: 0.827

MEAN RADIUS: 0.537

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 10

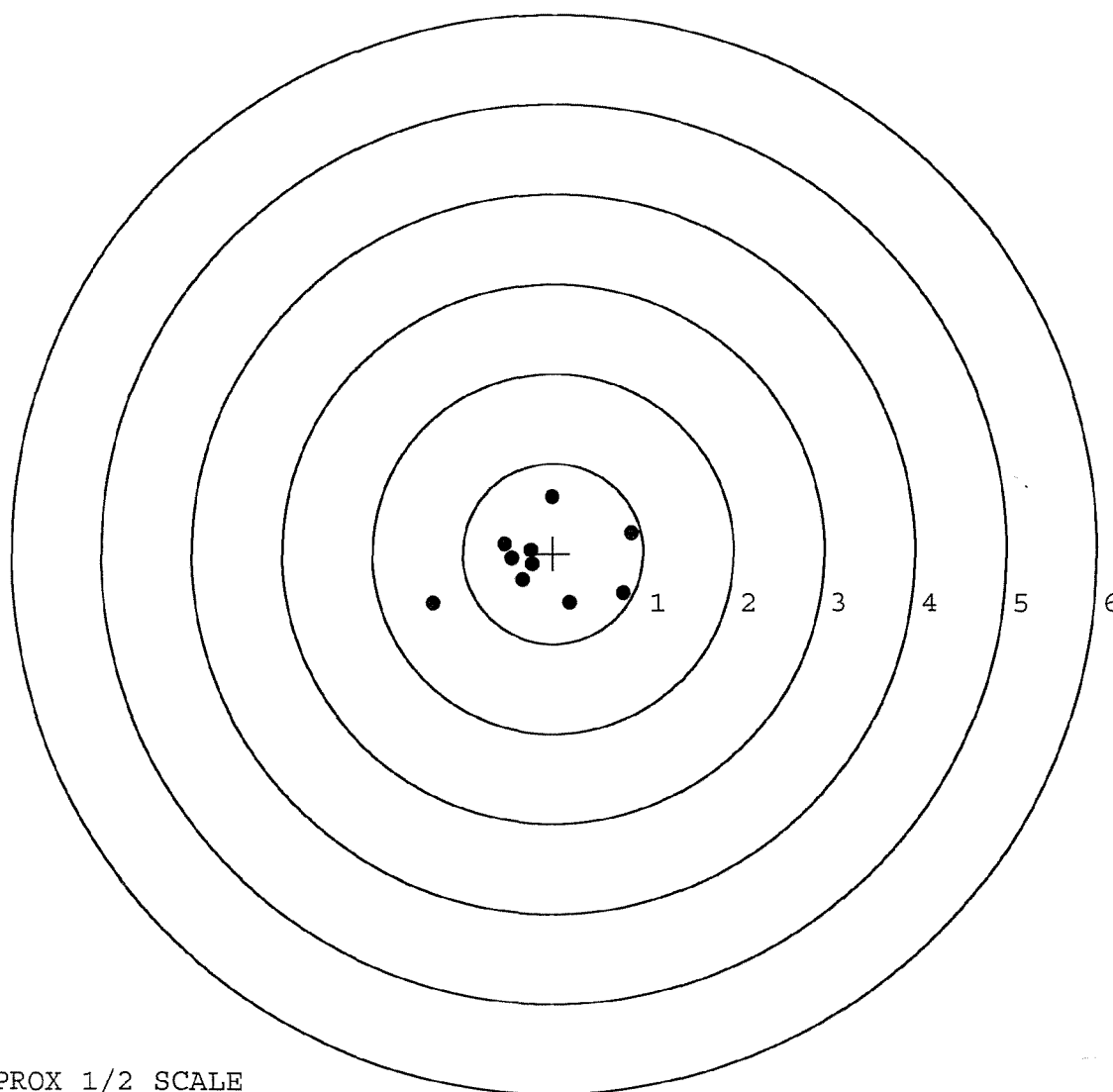
in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6348934. __0
TARGET NUMBER: 5
FILE DATE: 08/24/2002
FILE TIME: 13:51

	POINT#	X	Y
	1:	0.193	-0.549
	2:	0.785	-0.441
	3:	0.866	0.223
	4:	-0.015	0.622
	5:	-1.329	-0.563
	6:	-0.337	-0.296
	7:	-0.240	-0.125
	8:	-0.250	0.035
	9:	-0.544	0.094
	10:	-0.460	-0.066
X CENTROID:		-0.133	
Y CENTROID:		-0.107	
POA TO CENTROID:		0.171	
HORZ SPREAD:		2.195	
VERT SPREAD:		1.185	
GROUP SPREAD:		2.331	
MIN RADIUS:		0.108	
MAX RADIUS:		1.280	
MEAN RADIUS:		0.595	
# IN 1 IN DIAMETER:		5	
# IN 2 IN DIAMETER:		8	
# in 3 IN DIAMETER:		10	



TARGET APPROX 1/2 SCALE

M-24 INSPECTION CHECKLIST
CONTRACT #: DAAE-20-97-C-242

R & E NUMBER	50332		
SERIAL NUMBER	06348934		
LOG-IN DATE	8/6/02		
INSPECT AND VERIFY:			
OPERATION #	OPERATION NAME	DATE	INITIAL
550	DIS-ASSEMBLE GUN	8/8/02	RL
560 A	RE-BARREL	8-8-02	DA
B	DRILL AND TAP	8-13-02	AC
575	ASSEMBLE	8/13/02	RL
600	PROOF	8-13-02	MAGNA-FLUX INSPECTED AUG 14 2002
605	CHECK HEADSPACE	8/13/02	RL
610	DIS-ASSEMBLE GUN	8/13/02	RL
612	MAGNAFLUX		OPERATOR RL
615	ROLLMARK CALIBER	8/14	AB
618	ROTO-BLAST	8/15	RO
620	APPLY COATINGS	8-16	TA
625 A	FINAL ASSEMBLY	8/22/02	RL
B	TRIGGER PULL TEST		
C	SAFETY "ON" FORCE		
D	SAFETY "OFF" FORCE		
E	FIRING PIN INDENT		
640	TARGET	8-23-02	TRW
655	FINAL INSPECT	8-23-02	RW
660	PACK	8-23-02	DA
		SHIP DATE	
QAR INSPECTION DATE			

110.83
28 00
150 00
28283

378
2.




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

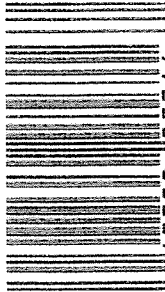
MODEL 700™ M24

SERIAL NO.
06348934

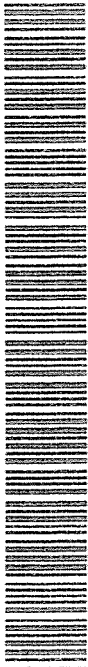
ORDER NO.
5716

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

UPC



0 47700 25716 7



5716 06348934

TEST INIT. ACTION TO CORRECT		ASSEM. #
PROOF	114-89 shot OK DH	
TEST		
TGT		
PROOF		
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		

MOD.		GA. CAL.	GUN #	ASSEM. #
# TEST	DATE	MALFUNCTION/DEFECT		
	1st			
	10-31-89	shove brass don't eject		
	2nd			
	11/6/89	Polish Ejector Ream Ejector Hole		
	3rd			
	11-11			
	4th			
		FUNCTION		

RD 6654

Rev 1

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6348934

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	9 26	89	RW
600	Proof	9 26	89	RW
607	Check Headspace	9 26	89	RW
610	Dis-assemble Gun	9 26	89	RW
612	Magnaflux Barrel Action	9/29/89		KCR
	Magnaflux Bolt	9/29/89		KCR
615	Rollmark Caliber	9/29/89		SL
7	Drill and Tap Sight Holes	9 29	89	LB
618	Polish Barrel AB	9 29	89	BT
620	Apply Coatings (Barrel Action)		10/11/89	TJA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		10/12/89	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/12/89	RW
	C) Inspect Ejector Hole for Chamfer		10/12/89	RW
	D) Oil Firing Pin Ass'y		10/12/89	RW
	E) Adjust Trigger Pull to Min Setting and Stake		10/12/89	RW

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			10/27/89	gdl
	G) Safety Off Force	4	4	4			10/27/89	gdl
	H) Trigger Pull Test & Retainability						27/10/89	gdl
	I) Firing Pin Indent	.0215	.022	.0215			10/27/89	gdl
	J) Assemble Stock						10/27/89	RW
	K) Assemble Swivel Studs						15/10/89	gdl
	L) Attach Front and Rear Sight Assemblies						10/27/89	RW
	M) Iron Sight Alignment						10/27/89	RW
	N) Detach Front & Rear Sights & place in numbered container						10/27/89	RW
	O) Attach Scope to Rifle						10/27/89	gdl
	P) Detach & Attach Scope 20 Times						10/27/89	gdl
640	Gallery Target & Test						10-31-89	AC
	A) Time						10-31-89	AC
	B) Malfunctions						10-31-89	AC
	C) Pierced Primers						10-31-89	AC
	D) Optical Clarity of Scope						10-31-89	AC
645	Inspect for Live Ammo						10-31-89	AC
655	Final Inspection							
	A) Headspace						15/10/89	gdl
	B) Trigger Pull	277	275	281	275	272	15/10/89	gdl
	C) Function						15/10/89	gdl
660	Pack						14/10/89	gdl

SWS TRIGGER PULL TEST

TAVE RTAG

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. 8939

DATE 3-26-90

TESTER JY

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#	COMMENTS
PULL #1	2.29	2.30	2.43	MIN. SETTING,
PULL #2	2.30	2.19	2.45	NO AVG. OF 5
PULL #3	2.36	2.50	2.41	READINGS ACCEPT-
PULL #4	2.33	2.27	2.43	ABLE LESS THAN 2#
PULL #5	2.27	2.40	2.40	
TOTAL	11.55	11.66	22.12	
AVG.	2.31	2.332	4.424	

	3.00# INITIAL	3.00# AFTER 20 CYCLES	COMMENTS
PULL #1	3.36	3.36	
PULL #2	3.37	3.54	
PULL #3	3.37	3.59	
PULL #4	3.38	3.57	
PULL #5	3.27	3.55	
TOTAL	16.75	17.81	
AVG.	3.35	3.562	

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.49	4.44		
PULL #2	4.44	4.42		
PULL #3	4.46	4.44		
PULL #4	4.45	4.44		
PULL #5	4.45	4.44		
TOTAL	22.29	22.18		
AVG.	4.458	4.436		

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6348934
1 Nov 1989

CENTROIDAL DISTANCES

0	TO	1	.283424
1	TO	2	.772622
1	TO	3	.283132
1	TO	4	.258048
1	TO	5	.32538

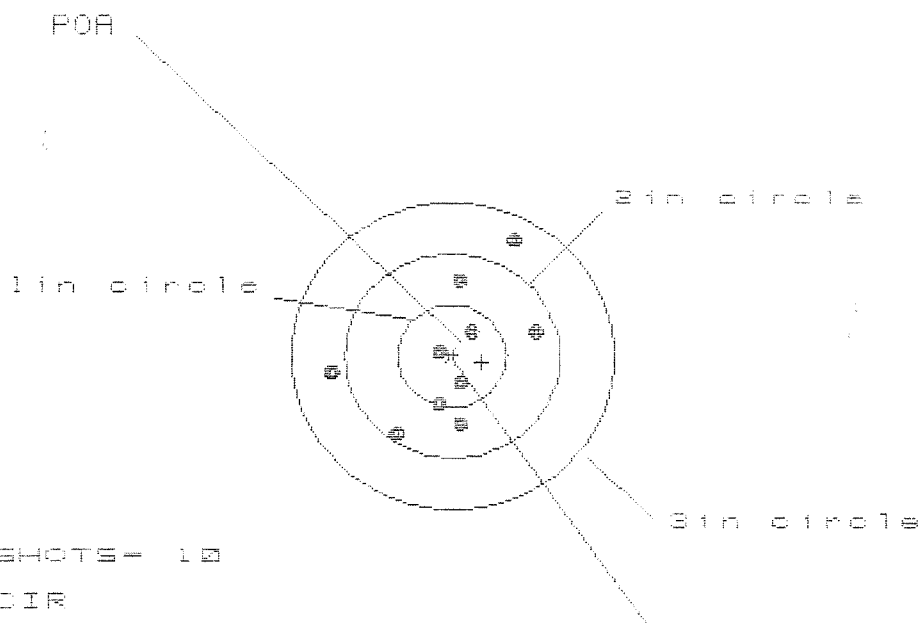
2
41+ <----POA
53

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.3162
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1226
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .339136
THE AMR FOR THIS RIFLE IS: .9178

1 May 1989

FILE:/PATTERNING/CENTERFIRE_PATT/0834B934

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1 in = 3

2 in = 8

3 in = 10

HS= 1.943

VS= 1.895

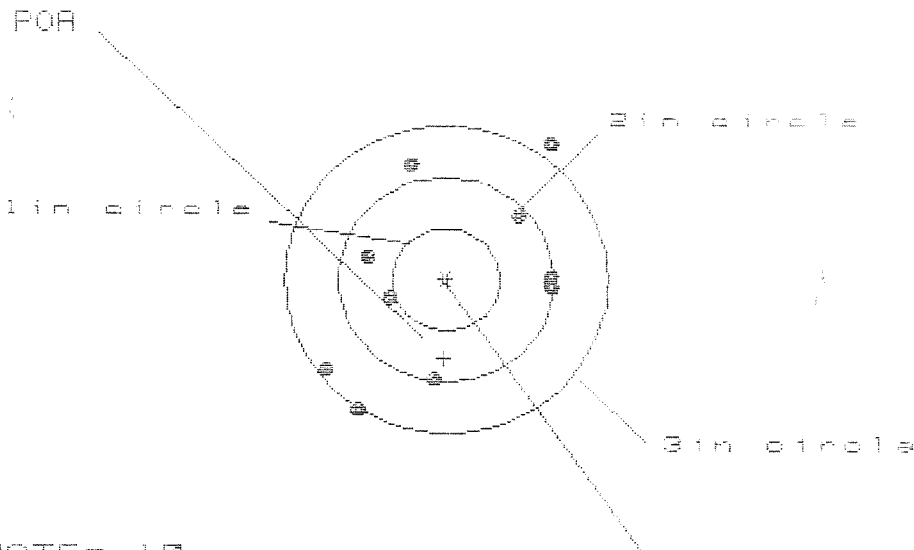
GS= 2.169

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.802	.867	.733
MINIMUM X	-1.141	-1.076	-.542
MAXIMUM Y	1.101	.858	.858
MINIMUM Y	-.794	-.672	-.672
CENTROID X	-.277	-.342	-.208
CENTROID Y	.068	-.062	-.061
POA TO CENTROID in.	.284	.348	.217
MIN RADIUS	.093	.127	.129
MEAN RADIUS	.667	.592	.519
MAX RADIUS	1.246	1.076	.864
HORIZONTAL SPREAD	1.943	1.943	1.275
VERTICAL SPREAD	1.895	1.530	1.530
EXTREME SPREAD	2.169	1.980	1.649
NUMBER IN ONE INCH CIRCLE	= 3		
NUMBER IN TWO INCH CIRCLE	= 8		
NUMBER IN THREE INCH CIRCLE	= 10		

1 Nov 1989

FILE:/PATTERNING/CENTERFIRE_PATT/CS34B934

CENTERFIRE PATTERNS # 2



OF SHOTS - 10

IN CIR

1 in = 0

2 in = 5

3 in = 0

HS = 2.134

VS = 2.600

GS = 3.165

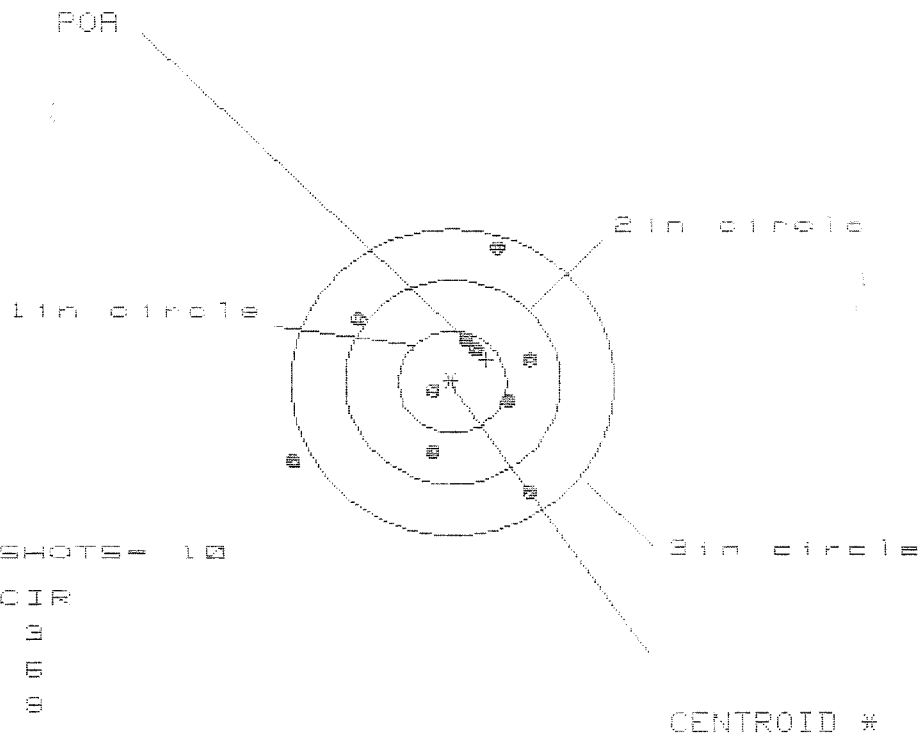
CENTROID #

PATTERN #	2	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.999	1.109	1.021
MINIMUM X	-1.135	-1.025	-1.113
MAXIMUM Y	1.337	1.284	1.145
MINIMUM Y	-1.263	-1.114	-1.985
CENTROID X	.023	-.087	.001
CENTROID Y	.772	.623	.762
POA TO CENTROID in.	.772	.629	.763
MIN RADIUS	.512	.380	.488
MEAN RADIUS	1.100	1.020	.979
MAX RADIUS	1.665	1.317	1.390
HORIZONTAL SPREAD	2.134	2.134	2.134
VERTICAL SPREAD	2.600	2.398	2.130
EXTREME SPREAD	3.165	2.443	2.346
NUMBER IN ONE INCH CIRCLE	=	0	
NUMBER IN TWO INCH CIRCLE	=	5	
NUMBER IN THREE INCH CIRCLE	=	8	

1 Nov 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C8348934

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1in = 3

2in = 6

3in = 9

HS= 2.224

VS= 2.438

GS= 2.768

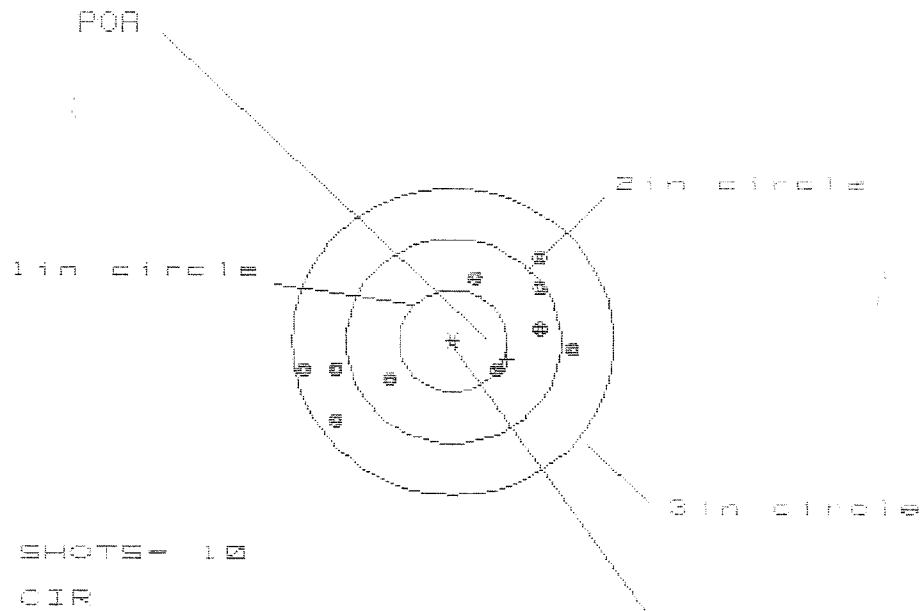
CENTROID #

PATTERN #	3	3	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.759	.596	.623
MINIMUM X	-1.465	-1.093	-1.066
MAXIMUM Y	1.329	1.247	.657
MINIMUM Y	-1.109	-1.191	-1.036
CENTROID X	-.319	-.156	-.183
CENTROID Y	-.220	-.138	-.293
POR TO CENTROID in.	.388	.208	.346
MIN RADIUS	.149	.202	.270
MEAN RADIUS	.842	.728	.566
MAX RADIUS	1.641	1.332	1.252
HORIZONTAL SPREAD	2.224	1.689	1.689
VERTICAL SPREAD	2.438	2.438	1.693
EXTREME SPREAD	2.768	2.468	2.391
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	9		

1 Nov 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C834B334

CENTERFIRE PATTERNS # 4



OF SHOTS - 10

IN CIR

1 in = 0

2 in = 5

3 in = 10

MOI = 0.5000

VS = 1.607

GS = 2.545

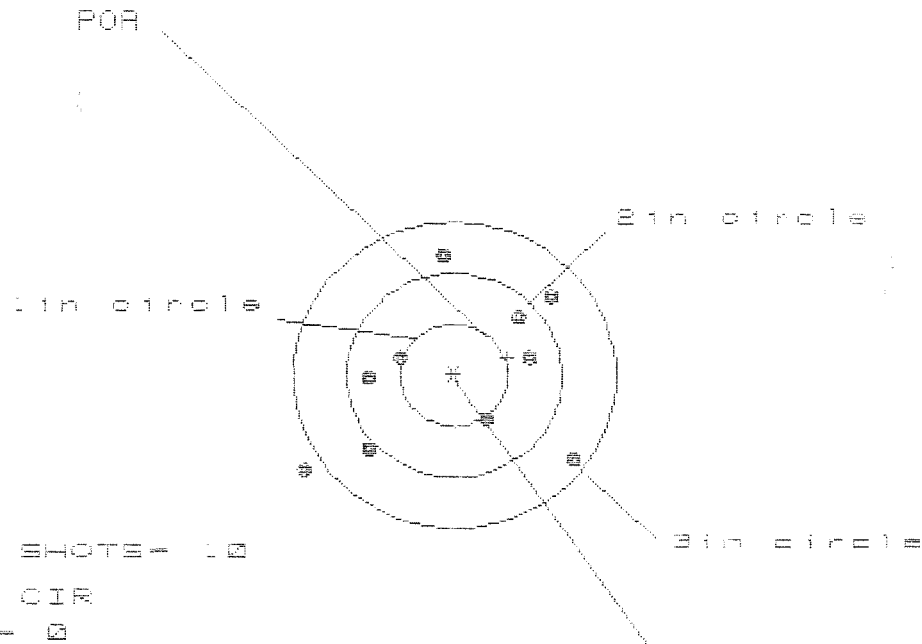
CENTROID #

PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.107	.948	.798
MINIMUM X	-1.431	-1.252	-1.462
MAXIMUM Y	.811	.780	.677
MINIMUM Y	-.796	-.827	-.466
CENTROID X	-.507	-.348	-.198
CENTROID Y	.177	.208	.311
POB TO CENTROID in.	.537	.406	.389
MIN RADIUS	.501	.415	.454
MEAN RADIUS	.985	.902	.789
MAX RADIUS	1.457	1.460	1.467
HORIZONTAL SPREAD	2.538	2.200	2.200
VERTICAL SPREAD	1.607	1.607	1.143
EXTREME SPREAD	2.545	2.473	2.223
NUMBER IN ONE INCH CIRCLE =		0	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		10	

1 Nov 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C834B934

CENTERFIRE PATTERNS # 5



OF SHOTS = 10

IN CIR

1 in = 0

2 in = 5

3 in = 9

HS = 2.514

VS = 2.059

ES = 2.841

CENTROID *

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.141	.988	.889
MINIMUM X	-1.373	-.990	-.866
MAXIMUM Y	1.185	1.087	.977
MINIMUM Y	-.874	-.885	-.963
CENTROID X	-.501	-.348	-.472
CENTROID Y	-.176	-.078	.032
POA TO CENTROID in.	.531	.357	.473
MIN RADIUS	.507	.539	.512
MEAN RADIUS	.995	.906	.848
MAX RADIUS	1.628	1.326	1.295
HORIZONTAL SPREAD	2.514	1.978	1.755
VERTICAL SPREAD	2.059	1.972	1.940
EXTREME SPREAD	2.841	2.350	2.349
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	9		