

C6611397

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5716**

*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: **RE00092542** Serial: 06611397 Model: M24 SWS Center Fire Caliber: 7.62 NATO Repairman: Status: Closed 2/7/2005 9:18:45 AM

Verify Repair

Address Information

Customer: ☒ Received From Return To: ☐ Received From

Name: **DEF DIST DEPOT ANNISTON** **DEF DIST DEPOT ANNISTON**

Address 1: Address 2: PO Box: PO Box:

City: **ANNISTON** **ANNISTON**

State: **AL** Zip Code: **362014199** Country: **US** State: **AL** Zip Code: **362014199** Country: **US**

FFL: ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐

Contact / Condition Problems Estimate History / Status Shipping / Billing

Contact Information

Phone: Fax: Email: Comments:

Received Condition

Good

Condition Notes: CSR Notes:

Accessories Received

Code	Desc	Qty
A007	With Stud	3
A010	Hard Case	1
A017	Scope Base	1
A026	Scope	1
A057	Front and Rear Sgt Base	1

Repair Search **Refresh** **Close**

noilej 2/7/2005 10:18 AM CAPS NUM INS SCPL

start 8 2

Serial Number: **C6611397**

Model: **M24 SWS**



RE00092542

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)

SERIAL NO.

DATE

TESTER

3-11-05

TRW

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.34	2.19		2.06	
PULL #2	2.23	2.23		2.53	
PULL #3	2.21	2.15		2.25	
PULL #4	2.17	2.05		2.26	
PULL #5	2.18	2.17		2.21	
TOTAL	11.13	10.79		11.31	
AVERAGE	2.22	2.15		2.26	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.17	3.09		
PULL #2	3.24	3.05		
PULL #3	3.13	3.07		
PULL #4	3.09	3.07		
PULL #5	3.09	3.08		
TOTAL	15.72	15.36		
AVERAGE	3.14	3.07		

	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	4.68	3.99		4.13
PULL #2	4.31	4.20		4.21
PULL #3	4.40	4.18		4.29
PULL #4	4.40	4.00		4.18
PULL #5	4.27	3.97		4.20
TOTAL	22.06	20.34		21.01
AVERAGE	4.41	4.06		4.20

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6611397.___0

FILE DATE AND TIME: 04/12/2005 09:44

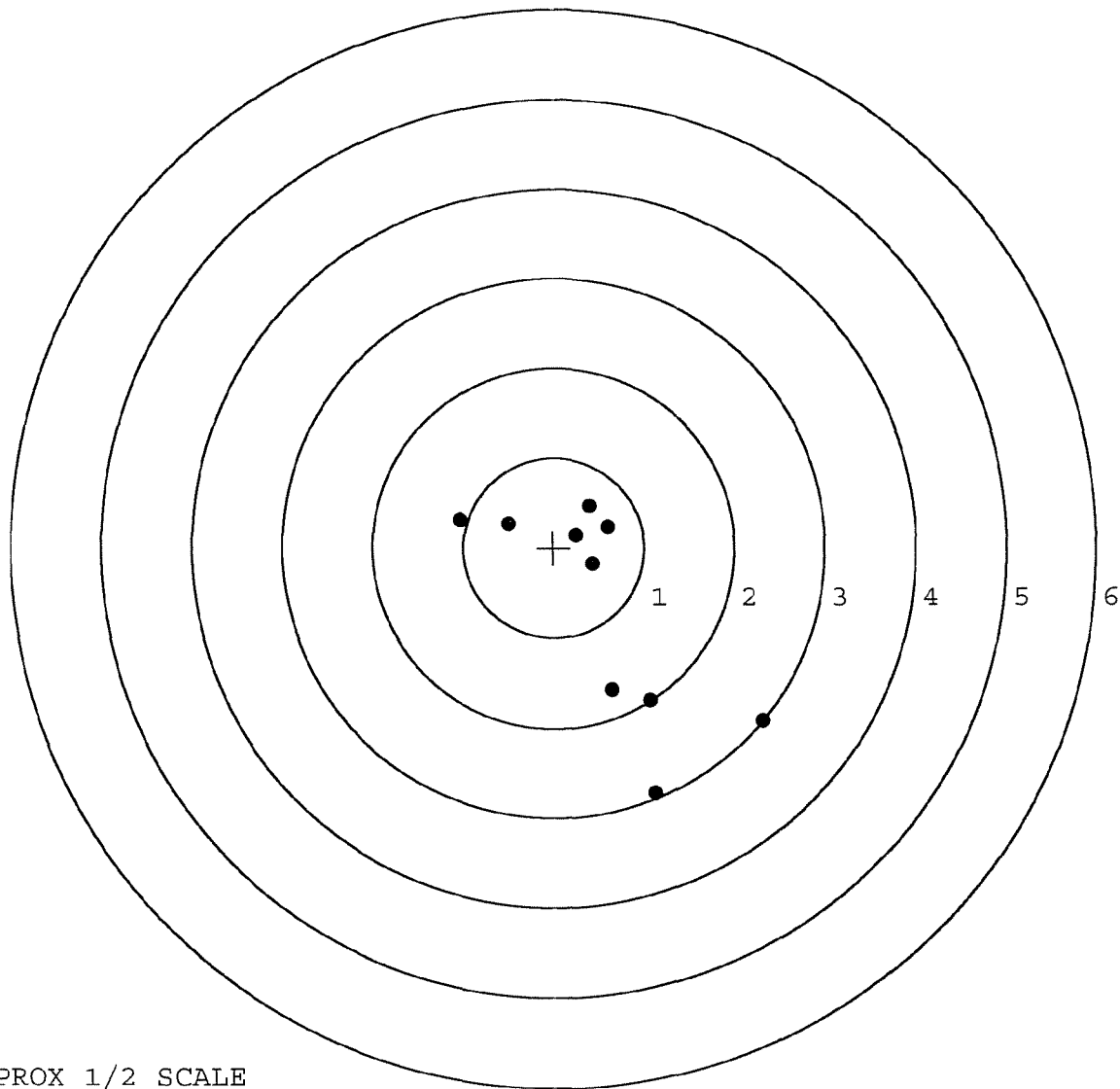
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.157
The Average Y Centroid of the Five Target Set:	-0.120
The Average Point of Impact of the Five Target Set:	0.198
The Average Mean Radius of the Five Target Set:	0.966
The Distance from POA to Centroid Target #1:	0.850
The Distance from Centroid Target #2 to Centroid Target #1:	1.059
The Distance from Centroid Target #3 to Centroid Target #1:	0.805
The Distance from Centroid Target #4 to Centroid Target #1:	0.724
The Distance from Centroid Target #5 to Centroid Target #1:	0.767

SERIAL NUMBER: C6611397. __0
TARGET NUMBER: 1
FILE DATE: 04/12/2005
FILE TIME: 09:44

POINT#	X	Y
1:	0.428	-0.183
2:	0.594	0.238
3:	0.248	0.143
4:	0.395	0.471
5:	-0.506	0.270
6:	-1.037	0.308
7:	0.640	-1.576
8:	1.066	-1.696
9:	2.311	-1.922
10:	1.121	-2.732

X CENTROID: 0.526
Y CENTROID: -0.668
POA TO CENTROID: 0.850
HORZ SPREAD: 3.348
VERT SPREAD: 3.203
GROUP SPREAD: 4.023
MIN RADIUS: 0.495
MAX RADIUS: 2.182
MEAN RADIUS: 1.305
IN 1 IN DIAMETER: 1
IN 2 IN DIAMETER: 4
in 3 IN DIAMETER: 7



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6611397.___0

TARGET NUMBER: 2

FILE DATE: 04/12/2005

FILE TIME: 09:44

POINT#	X	Y
1:	1.073	0.163
2:	0.505	0.021
3:	0.476	-0.495
4:	-0.076	-0.636
5:	-0.506	-0.116
6:	-0.746	0.031
7:	-1.344	0.965
8:	0.504	1.199
9:	0.746	0.934
10:	0.575	1.041

X CENTROID: 0.121

Y CENTROID: 0.311

POA TO CENTROID: 0.333

HORZ SPREAD: 2.417

VERT SPREAD: 1.835

GROUP SPREAD: 2.547

MIN RADIUS: 0.481

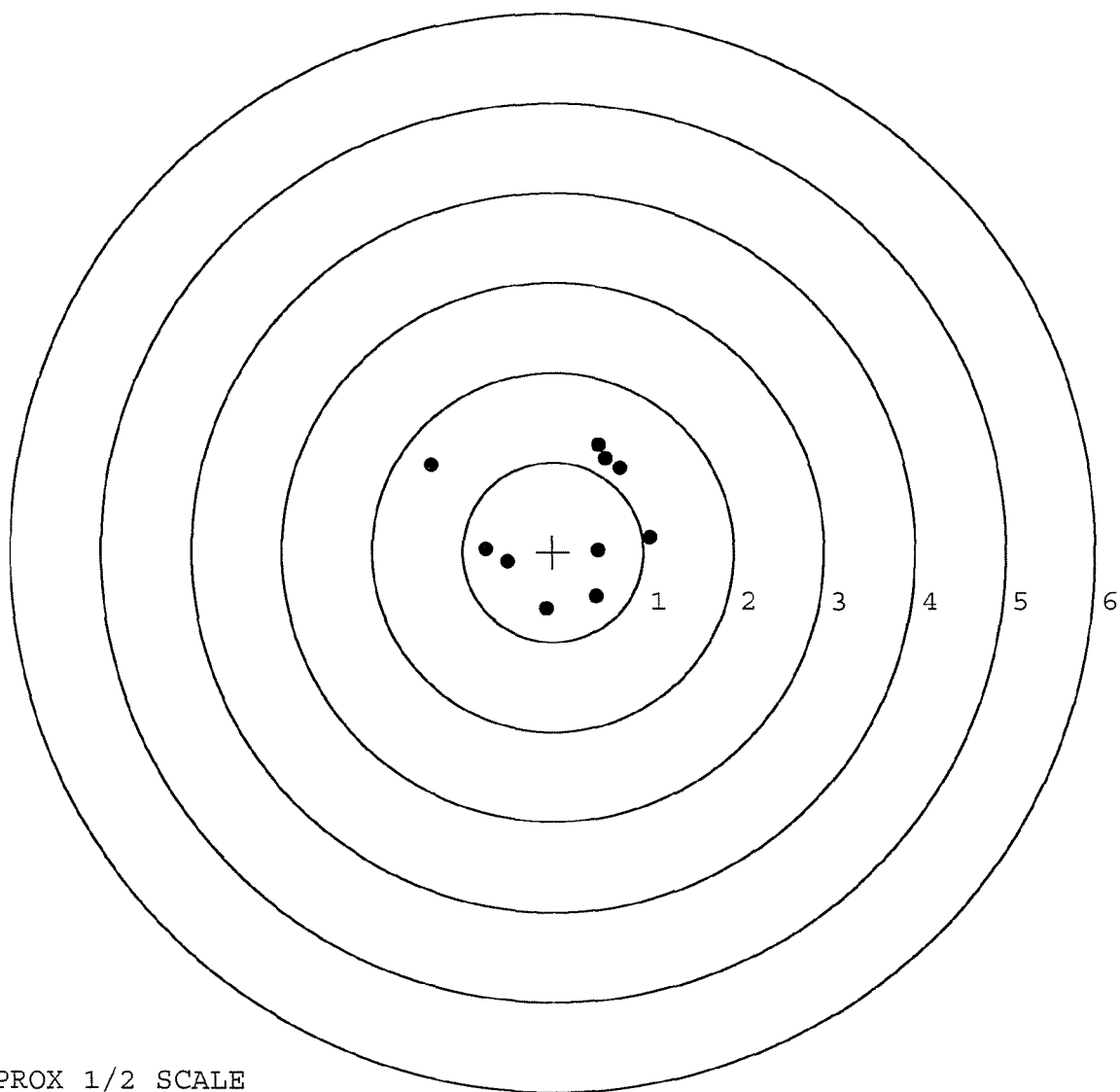
MAX RADIUS: 1.604

MEAN RADIUS: 0.928

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 9

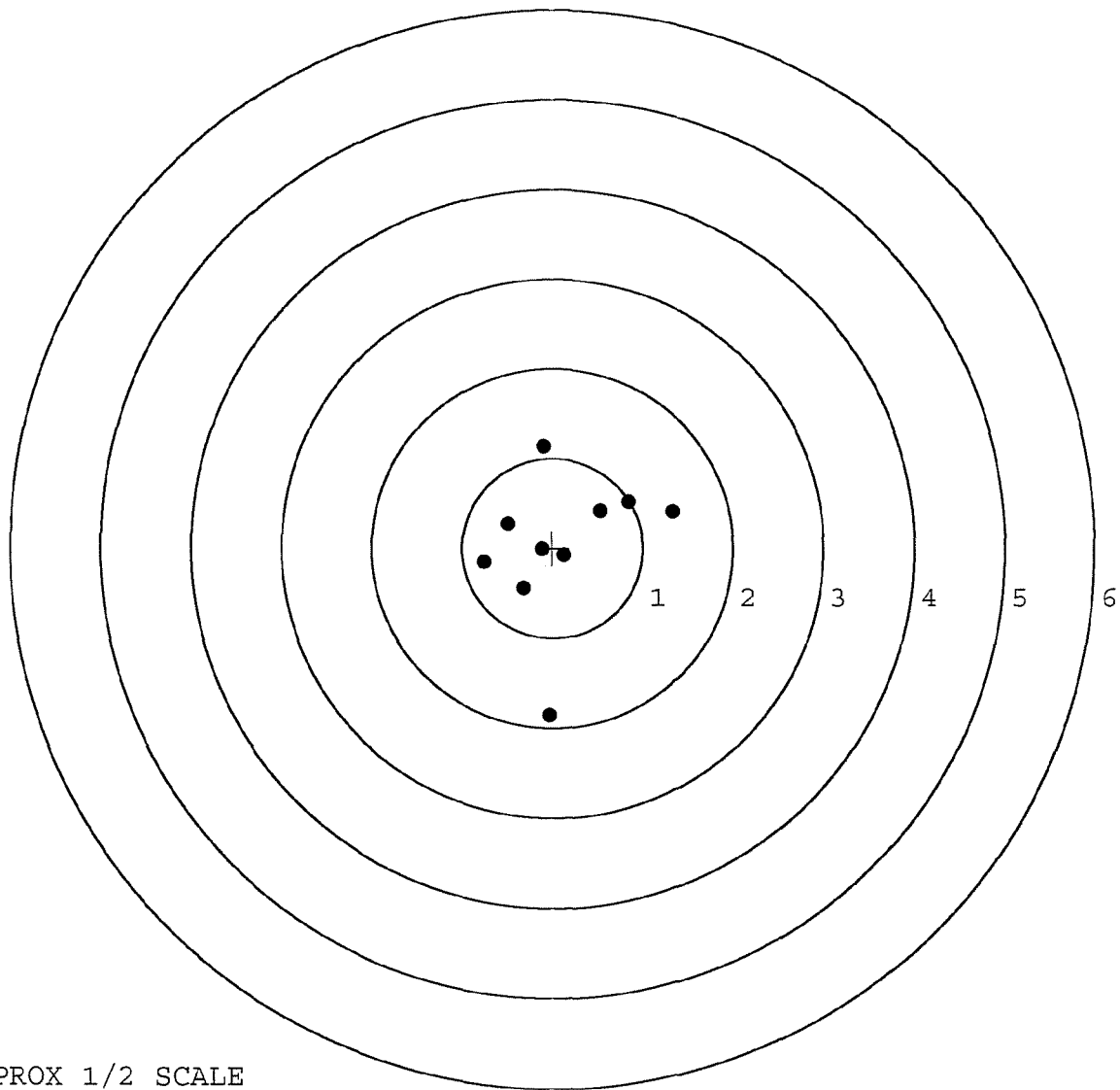


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6611397.____0
TARGET NUMBER: 3
FILE DATE: 04/12/2005
FILE TIME: 09:44

POINT#	X	Y
1:	1.327	0.402
2:	0.842	0.517
3:	0.531	0.419
4:	-0.099	1.133
5:	-0.497	0.268
6:	0.132	-0.082
7:	-0.758	-0.158
8:	-0.322	-0.453
9:	-0.119	-0.019
10:	-0.036	-1.870

X CENTROID: 0.100
Y CENTROID: 0.016
POA TO CENTROID: 0.101
HORZ SPREAD: 2.085
VERT SPREAD: 3.003
GROUP SPREAD: 3.004
MIN RADIUS: 0.103
MAX RADIUS: 1.891
MEAN RADIUS: 0.828
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 9



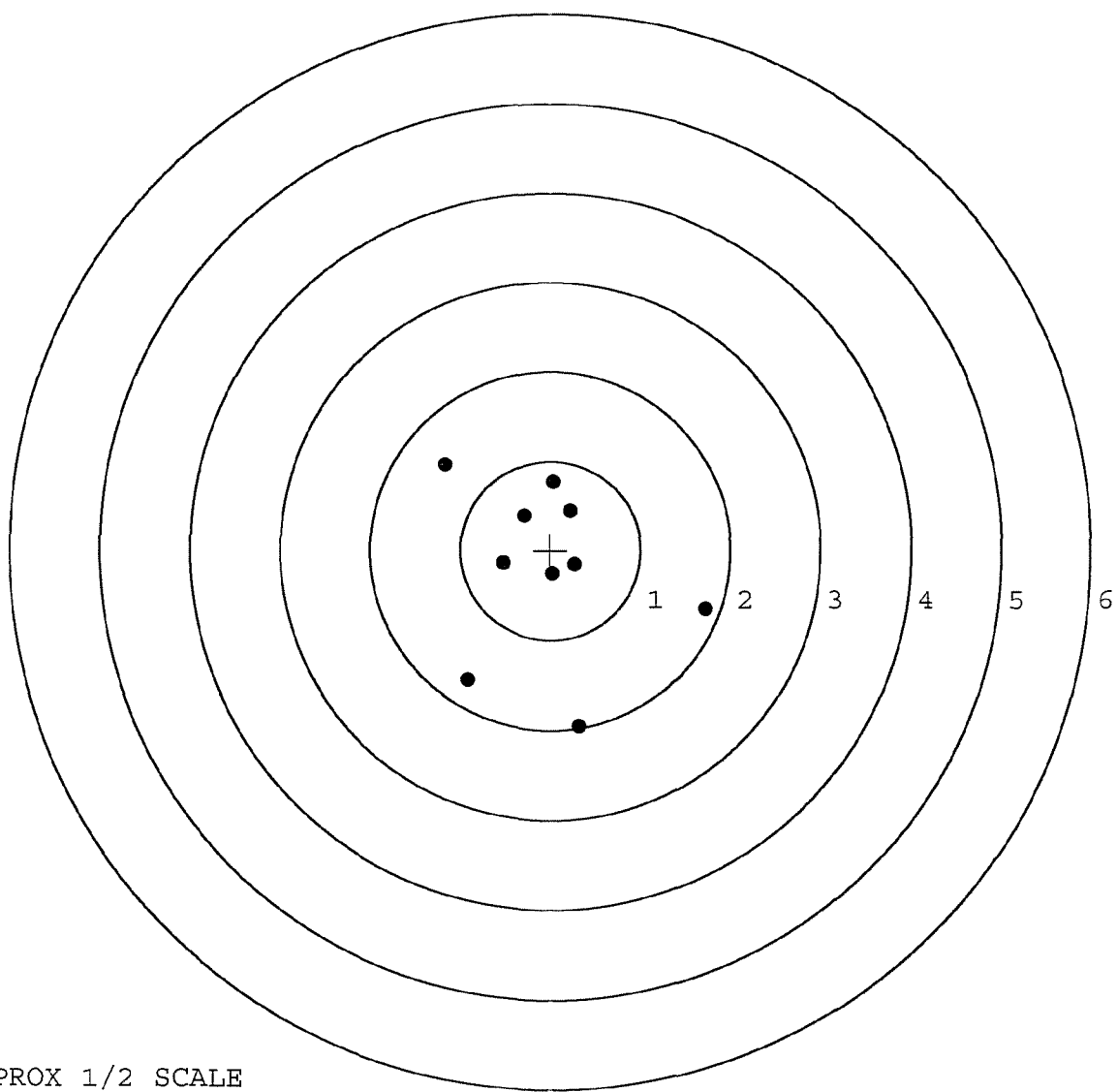
TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6611397.____0
TARGET NUMBER: 4
FILE DATE: 04/12/2005
FILE TIME: 09:44

POINT#	X	Y
1:	1.722	-0.654
2:	0.317	-1.966
3:	-0.925	-1.452
4:	0.021	-0.262
5:	0.272	-0.163
6:	0.219	0.441
7:	-0.296	0.391
8:	-0.525	-0.149
9:	0.033	0.768
10:	-1.169	0.961

X CENTROID: -0.033
Y CENTROID: -0.209
POA TO CENTROID: 0.211
HORZ SPREAD: 2.891
VERT SPREAD: 2.927
GROUP SPREAD: 3.312
MIN RADIUS: 0.076
MAX RADIUS: 1.811
MEAN RADIUS: 0.997

IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 6
in 3 IN DIAMETER: 6

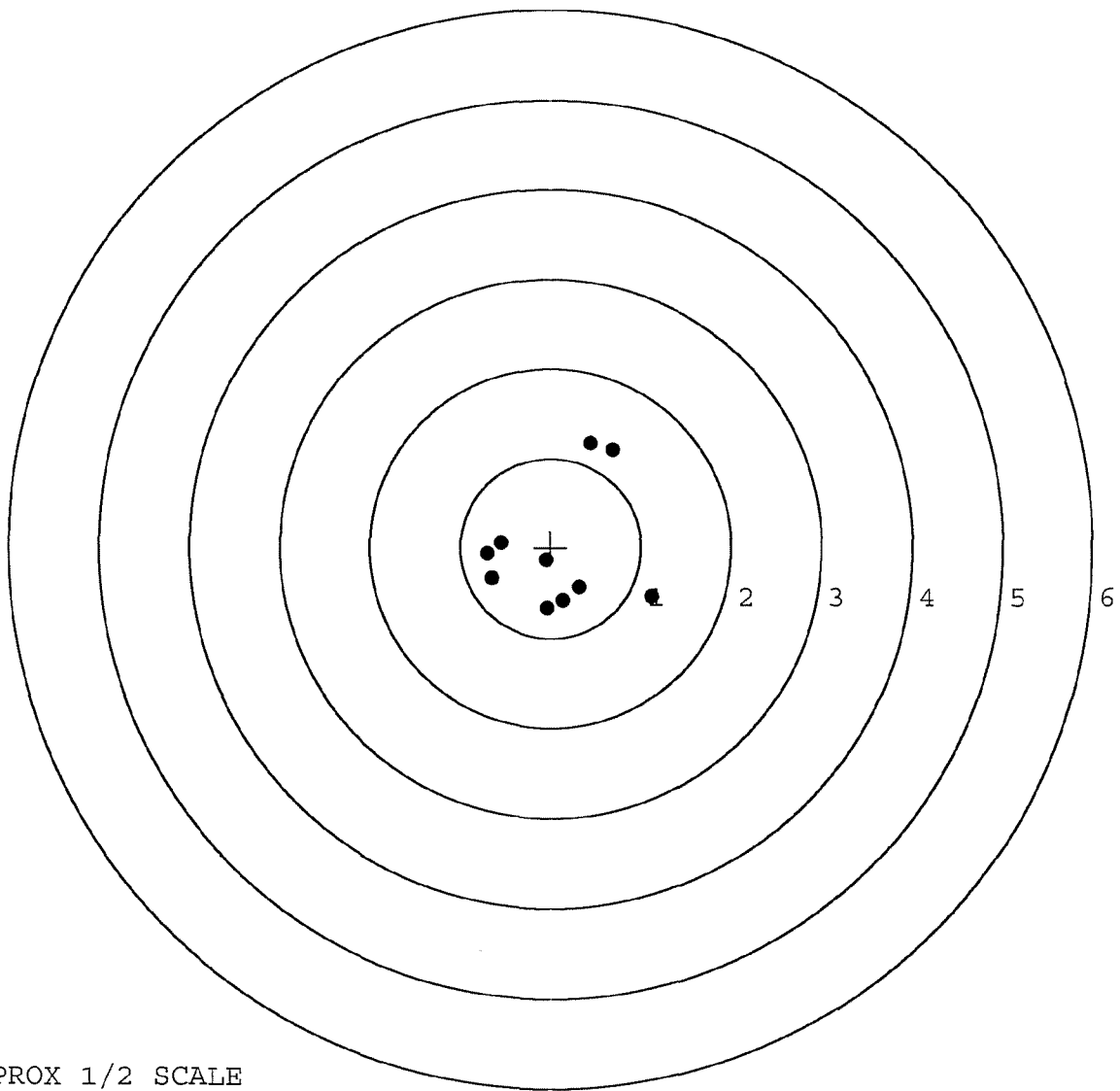


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6611397.___0
TARGET NUMBER: 5
FILE DATE: 04/12/2005
FILE TIME: 09:44

POINT#	X	Y
1:	1.116	-0.553
2:	0.317	-0.442
3:	0.135	-0.588
4:	-0.044	-0.679
5:	-0.049	-0.141
6:	-0.553	0.047
7:	-0.706	-0.076
8:	-0.651	-0.353
9:	0.688	1.095
10:	0.443	1.172

X CENTROID: 0.070
Y CENTROID: -0.052
POA TO CENTROID: 0.087
HORZ SPREAD: 1.822
VERT SPREAD: 1.851
GROUP SPREAD: 1.972
MIN RADIUS: 0.148
MAX RADIUS: 1.303
MEAN RADIUS: 0.772
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

M-24 INSPECTION CHECKLIST
CONTRACT #: DAAE-20-02-D-0127

R & E NUMBER	92542		
SERIAL NUMBER	C6611397		
LOG-IN DATE	2-7-05		
INSPECT AND VERIFY:			
OPERATION #	OPERATION NAME	DATE	INITIAL
550	DIS-ASSEMBLE GUN	3-14-05	RTZ
560 A	RE-BARREL	3-17-05	RTZ
B	DRILL AND TAP	3-21-05	TRW
575	ASSEMBLE	3-18-05	RTZ
600	PROOF	3-21-05	AE
605	CHECK HEADSPACE	3-21-05	AE
610	DIS-ASSEMBLE GUN	3-21-05	RTZ
612	MAGNAFLUX		
615	ROLLMARK CALIBER	3-23-05	CW
618	ROTO-BLAST	3/29	SW
620	APPLY COATINGS	4/5	HP
625 A	FINAL ASSEMBLY	4-11-05	RTZ
B	TRIGGER PULL TEST	4-12-05	TRW
C	SAFETY "ON" FORCE	4-14-05	AE
D	SAFETY "OFF" FORCE	4-14-05	AC
E	FIRING PIN INDENT	4-14-05	AC
640	TARGET	4-12-05	TRW
655	FINAL INSPECT	4-14-05	AC
660	PACK	4-21-05	RTZ
		SHIP DATE	
		QAR INSPECTION DATE	




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

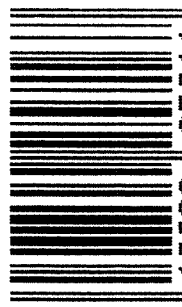
MODEL 700™ H24

SERIAL NO.
C6611397

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 C6611397

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C 6611397

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		3/19/91	K.S.
600	Proof		3/19/91	K.S.
607	Check Headspace		3/19/91	K.S.
610	Dis-assemble Gun		3/19/91	K.S.
612	Magnaflux Barrel Action		3/28/91	K.R.
	Magnaflux Bolt		"	K.R.
615	Rollmark Caliber		"	G.S.
617	Drill and Tap Sight Holes	APR	3 1991	FB
618	Polish Barrel	APR	3 1991	WB
620	Apply Coatings (Barrel Action)		4-19-91	JA
	Apply Coating (Bolt)			D
625	Final Assembly A) Clean inside of Bolt Assembly		5/1/91	K.S.
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/1/91	K.S.
	C) Inspect Ejector Hole for Chamfer		5/1/91	K.S.
	D) Oil Firing Pin Ass'y		5/1/91	K.S.
	E) Adjust Trigger Pull to Min Setting and Stake		5-10-91	D/H

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	8	7	7			5-10-91	DH
	G) Safety Off Force	3	3 1/2	3			5-10-91	DH
	H) Trigger Pull Test & Retainability						5-10-91	DH
	I) Firing Pin Indent	.020	.020	.021			5-10-91	DH
	J) Assemble Stock						5/10/91	KS
	K) Assemble Swivel Studs						5-21-91	DH
	L) Attach Front and Rear Sight Assemblies						5/10/91	KS
	M) Iron Sight Alignment						5/10/91	KS
	N) Detach Front & Rear Sights & place in numbered container						5/10/91	KS
	O) Attach Scope to Rifle						5/10/91	KS
	P) Detach & Attach Scope 20 Times						5/10/91	KS
640	Gallery Target & Test						5-14-91	NF
	A) Time						"	NF
	B) Malfunctions						"	NF
	C) Pierced Primers						"	NF
	D) Optical Clarity of Scope						"	NF
645	Inspect for Live Ammo						5-14-91	NF
655	Final Inspection							
	A) Headspace						5-21-91	DH
	B) Trigger Pull	2.46	2.49	2.48	2.55	2.57	5-21-91	JCF
	C) Function						5-21-91	DH
660	Pack						6-11-91	NF

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS
2.50# + .50#
3.00# + .75#
4.00# + 1.00#

SERIAL NO. C6611397
DATE 5-10-91
TESTER D/H

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.70	2.77	2.72	2.46	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.61	2.53	2.83	2.49	
PULL #3	2.63	2.65	2.70	2.48	
PULL #4	2.70	2.67	2.86	2.55	
PULL #5	2.47	2.63	2.40	2.57	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.18	2.99		
PULL #2	3.24	3.32		
PULL #3	3.00	3.22		
PULL #4	3.12	3.19		
PULL #5	3.10	3.17		
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	4.11		4.06
PULL #2	3.98	4.26		4.28
PULL #3	4.29	4.27		4.07
PULL #4	4.24	3.95		4.21
PULL #5	4.22	4.13		4.25
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611397
14 May 1991

CENTROIDAL DISTANCES

0 TO	1	.0657343
1 TO	2	.156554
1 TO	3	.0837257
1 TO	4	.0779359
1 TO	5	.0873613

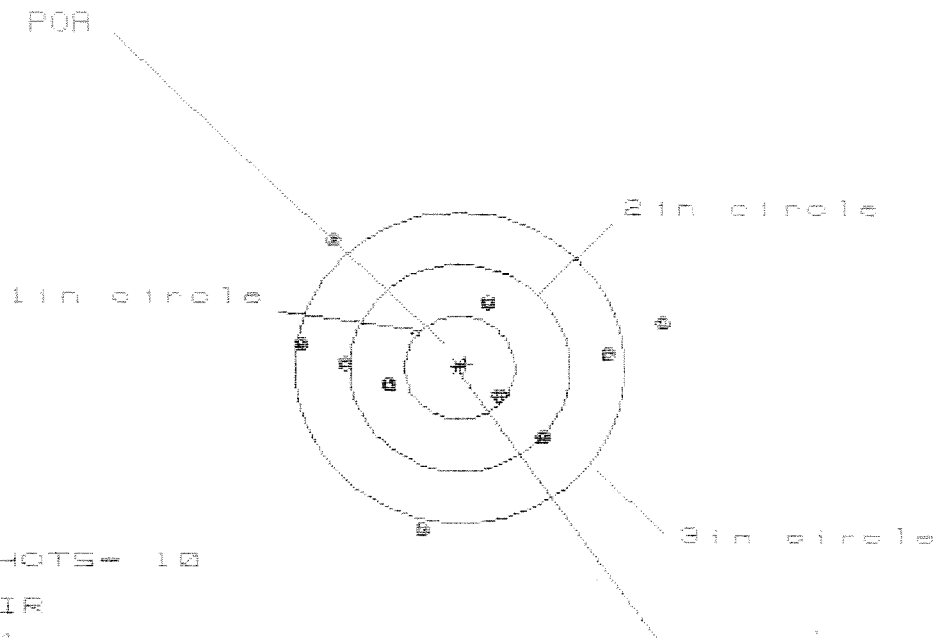
✱ <----POB

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0220
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.042
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0477695
THE AMR FOR THIS RIFLE IS: .9448

14 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8811397

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 1

2in = 4

3in = 7

HS= 3.288

VS= 2.794

GS= 3.288

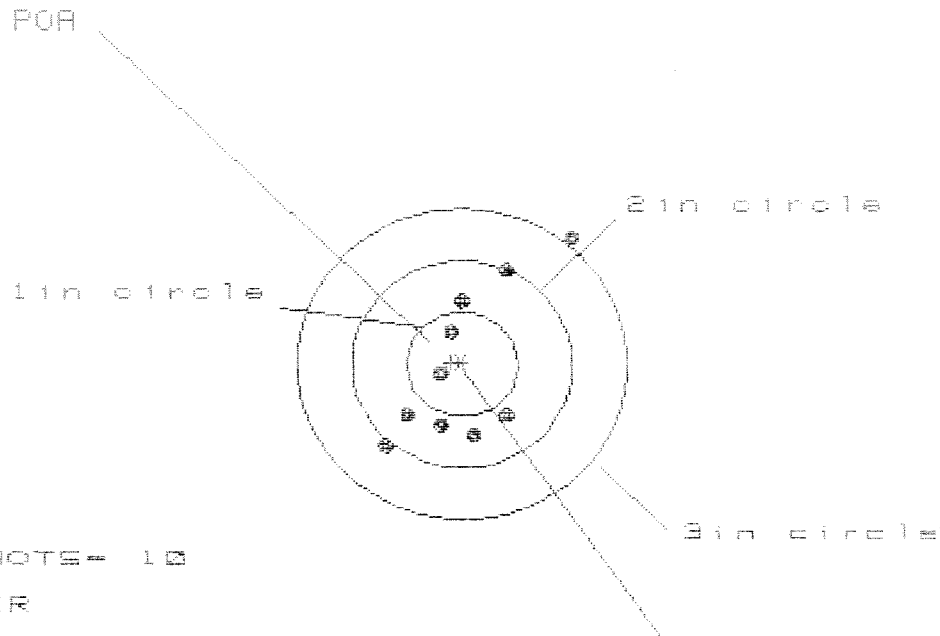
CENTROID *

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.881	1.570	1.453
MINIMUM X	:	-1.401	-1.192	-1.309
MAXIMUM Y	:	1.217	1.263	.823
MINIMUM Y	:	-1.577	-1.531	-1.373
CENTROID X	:	-.055	-.264	-.147
CENTROID Y	:	-.036	-.082	-.240
POA TO CENTROID in.	:	.065	.276	.282
MIN RADIUS	:	.429	.508	.447
MEAN RADIUS	:	1.184	1.088	1.017
MAX RADIUS	:	1.927	1.583	1.498
HORIZONTAL SPREAD	:	3.282	2.762	2.762
VERTICAL SPREAD	:	2.794	2.794	2.196
EXTREME SPREAD	:	3.288	2.909	2.763
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		7	

14 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611397

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 2

2in = 8

3in = 9

HS= 1.722

VS= 1.991

GS= 2.632

CENTROID *

PATTERN #	2	2	2
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.989	.491	.413
MINIMUM X	-.733	-.623	-.586
MAXIMUM Y	1.250	1.050	.975
MINIMUM Y	-.741	-.602	-.664
CENTROID X	.100	-.010	.068
CENTROID Y	-.014	-.153	-.078
POA TO CENTROID in.	.101	.153	.103
MIN RADIUS	.246	.107	.191
MEAN RADIUS	.736	.603	.580
MAX RADIUS	1.594	1.159	1.059
HORIZONTAL SPREAD	1.722	1.114	.919
VERTICAL SPREAD	1.991	1.652	1.639
EXTREME SPREAD	2.632	1.993	1.670
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		8	
NUMBER IN THREE INCH CIRCLE =		9	

14 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8611397

CENTERFIRE PATTERNS # 3

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 2

2in = 7

3in = 10

HS= 1.567

VS= 2.402

GS= 2.495

CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.689	.740	.720
MINIMUM X	-.878	-.827	-.847
MAXIMUM Y	1.252	1.079	.953
MINIMUM Y	-1.150	-1.011	-.807
CENTROID X	-.138	-.189	-.169
CENTROID Y	-.047	-.186	-.060
POA TO CENTROID in.	.146	.266	.179
MIN RADIUS	.449	.418	.467
MEAN RADIUS	.860	.790	.760
MAX RADIUS	1.334	1.296	1.181
HORIZONTAL SPREAD	1.567	1.567	1.567
VERTICAL SPREAD	2.402	2.090	1.760
EXTREME SPREAD	2.495	2.268	2.027
NUMBER IN ONE INCH CIRCLE	=	2	
NUMBER IN TWO INCH CIRCLE	=	7	
NUMBER IN THREE INCH CIRCLE	=	10	

14 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8611397

CENTERFIRE PATTERNS

4

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 1

2in = 4

3in = 8

HS= 3.002

VS= 2.476

GS= 3.189

CENTROID *

PATTERN #

4

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.418

1.242

1.065

MINIMUM X

-1.584

-1.416

-1.241

MAXIMUM Y

1.217

1.129

1.252

MINIMUM Y

-1.259

-1.347

-1.224

CENTROID X

.010

.186

.363

CENTROID Y

.007

.095

-.028

POA TO CENTROID in.

.013

.209

.364

MIN RADIUS

.378

.320

.165

MEAN RADIUS

1.193

1.105

.980

MAX RADIUS

1.769

1.723

1.558

HORIZONTAL SPREAD

3.002

2.658

2.306

VERTICAL SPREAD

2.476

2.476

2.476

EXTREME SPREAD

3.189

2.822

2.611

NUMBER IN ONE INCH CIRCLE =

1

NUMBER IN TWO INCH CIRCLE =

4

NUMBER IN THREE INCH CIRCLE =

8

14 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8611397

CENTERFIRE PATTERNS

5

POA

1 in circle

2 in circle

3 in circle

OF SHOTS = 10

IN CIR

1 in = 1

2 in = 8

3 in = 10

HS = 1.660

VS = 1.904

GS = 2.101

CENTROID #

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.638	.668	.544
MINIMUM X	-1.022	-.992	-.891
MAXIMUM Y	1.224	.812	.775
MINIMUM Y	-.680	-.544	-.581
CENTROID X	-.031	-.061	.063
CENTROID Y	-.120	-.256	-.219
POA TO CENTROID in.	.124	.263	.228
MIN RADIUS	.240	.230	.111
MEAN RADIUS	.751	.677	.608
MAX RADIUS	1.254	1.051	.947
HORIZONTAL SPREAD	1.660	1.660	1.435
VERTICAL SPREAD	1.904	1.356	1.356
EXTREME SPREAD	2.101	1.995	1.560
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	8		
NUMBER IN THREE INCH CIRCLE =	10		