

C6611414

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: **RE00087061** Serial: C6611414 Model: M24 SWS Center Fire Caliber: 7.62 NATO Repairman: Status: Closed 10/27/2004 9:29:59 AM

Verify Repair

Address Information

Customer: Received From: Return To: Received From:

Name: **ELECTRONIC MAIN SHOP GSC 10TH DIV** **ELECTRONIC MAIN SHOP GSC 10TH DIV**

Address 1: **ATTN MSG BARTRON SPC LAUBAUGH** **ATTN MSG BARTRON SPC LAUBAUGH**

Address 2: **BLDG 7426 RM 203 BAD TOELZ** **BLDG 7426 RM 203 BAD TOELZ** PO Box:

City: **FORT CARSON** **FORT CARSON**

State: **CO** Zip Code: **80913** Country: **US** State: **CO** Zip Code: **80913** 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
A017	Scope Base	1
A026	Scope	1
C000	F AND R SGT BASES	1

Repair Search Refresh Close

negletj 10/27/2004 11:58 AM CAPS NUM IINS SCPL

start 2 Arms Services 3 2

Serial Number: **C6611414**

Model: **M24 SWS**

RE00087061

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6611414.__0
FILE DATE AND TIME: 11/12/2004 21:52

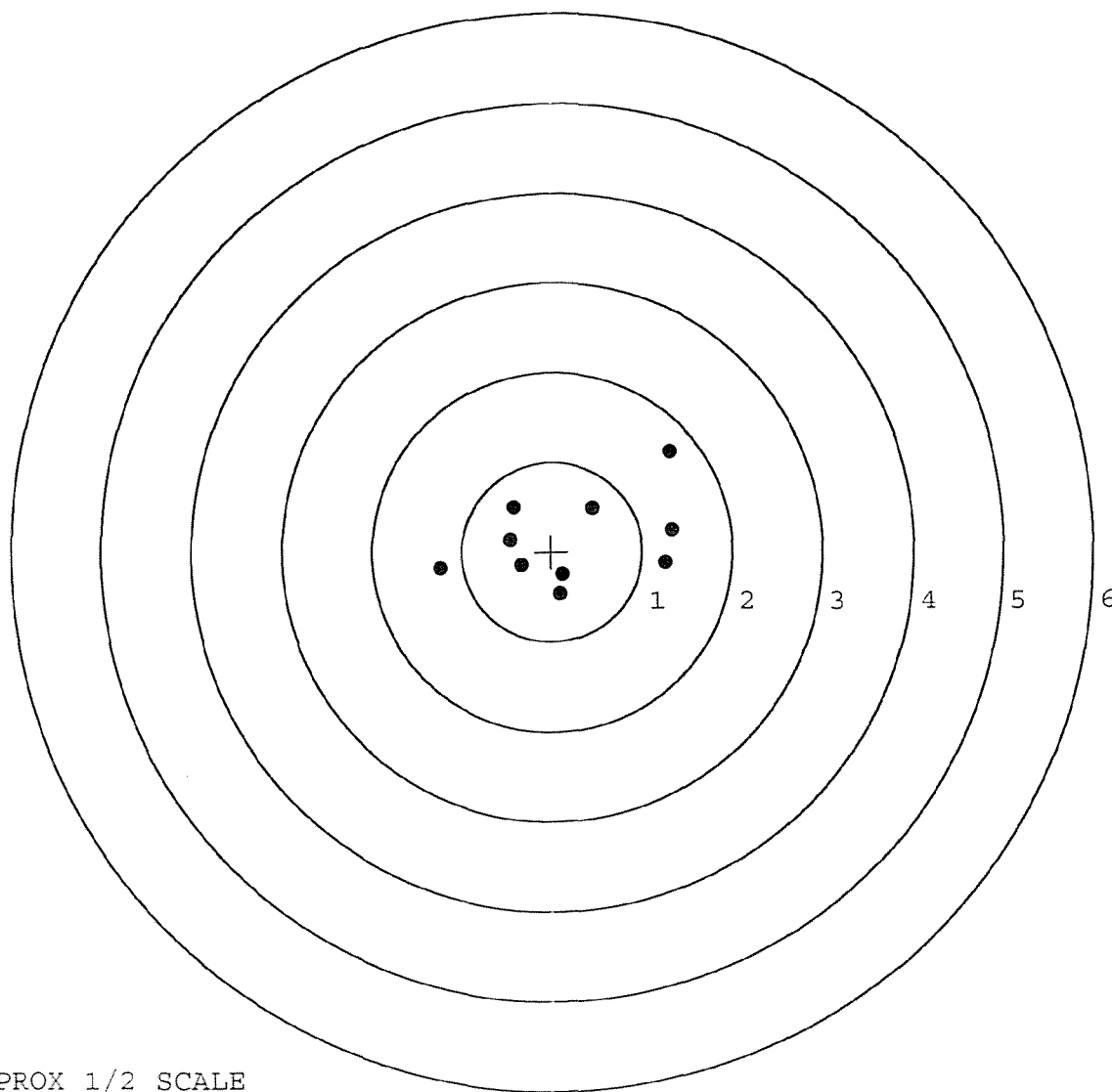
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.065
The Average Y Centroid of the Five Target Set:	0.008
The Average Point of Impact of the Five Target Set:	0.066
The Average Mean Radius of the Five Target Set:	0.678
The Distance from POA to Centroid Target #1:	0.247
The Distance from Centroid Target #2 to Centroid Target #1:	0.322
The Distance from Centroid Target #3 to Centroid Target #1:	0.270
The Distance from Centroid Target #4 to Centroid Target #1:	0.171
The Distance from Centroid Target #5 to Centroid Target #1:	0.269

SERIAL NUMBER: C6611414. __0
TARGET NUMBER: 1
FILE DATE: 11/12/2004
FILE TIME: 21:52

POINT#	X	Y
1:	1.256	-0.127
2:	1.323	0.237
3:	1.306	1.110
4:	0.452	0.490
5:	0.095	-0.478
6:	0.123	-0.256
7:	-0.337	-0.151
8:	-0.454	0.140
9:	-0.420	0.501
10:	-1.234	-0.187

X CENTROID: 0.211
Y CENTROID: 0.128
POA TO CENTROID: 0.247
HORZ SPREAD: 2.557
VERT SPREAD: 1.588
GROUP SPREAD: 2.852
MIN RADIUS: 0.394
MAX RADIUS: 1.479
MEAN RADIUS: 0.860
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 6
in 3 IN DIAMETER: 10

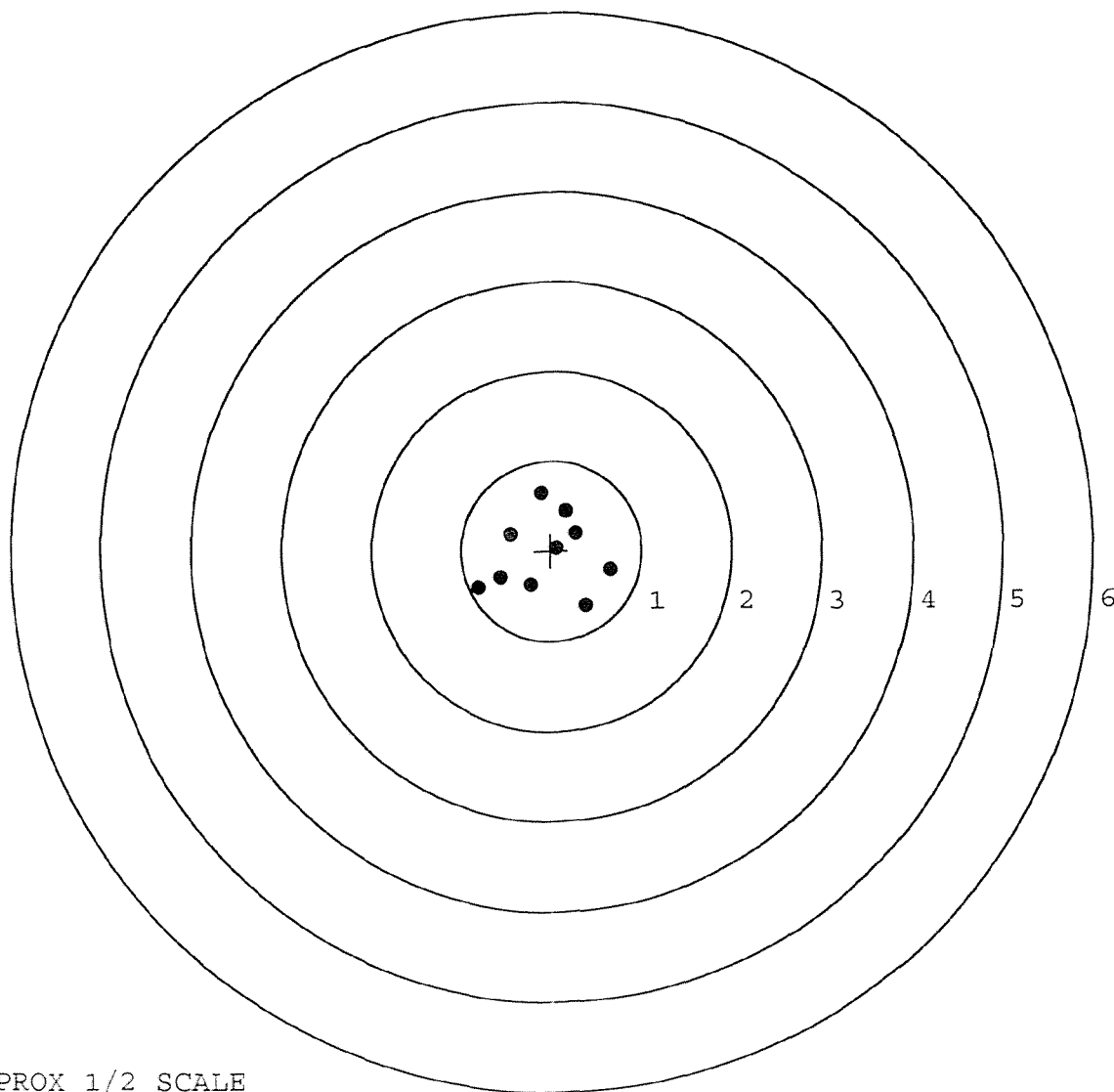


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6611414. __0
TARGET NUMBER: 2
FILE DATE: 11/12/2004
FILE TIME: 21:52

X CENTROID: -0.063
Y CENTROID: -0.040
POA TO CENTROID: 0.075
HORZ SPREAD: 1.471
VERT SPREAD: 1.251
GROUP SPREAD: 1.483
MIN RADIUS: 0.148
MAX RADIUS: 0.832
MEAN RADIUS: 0.545
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 10
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.384	-0.610
2:	0.659	-0.214
3:	0.268	0.189
4:	0.164	0.438
5:	0.066	0.031
6:	-0.110	0.641
7:	-0.459	0.189
8:	-0.231	-0.377
9:	-0.564	-0.287
10:	-0.812	-0.404

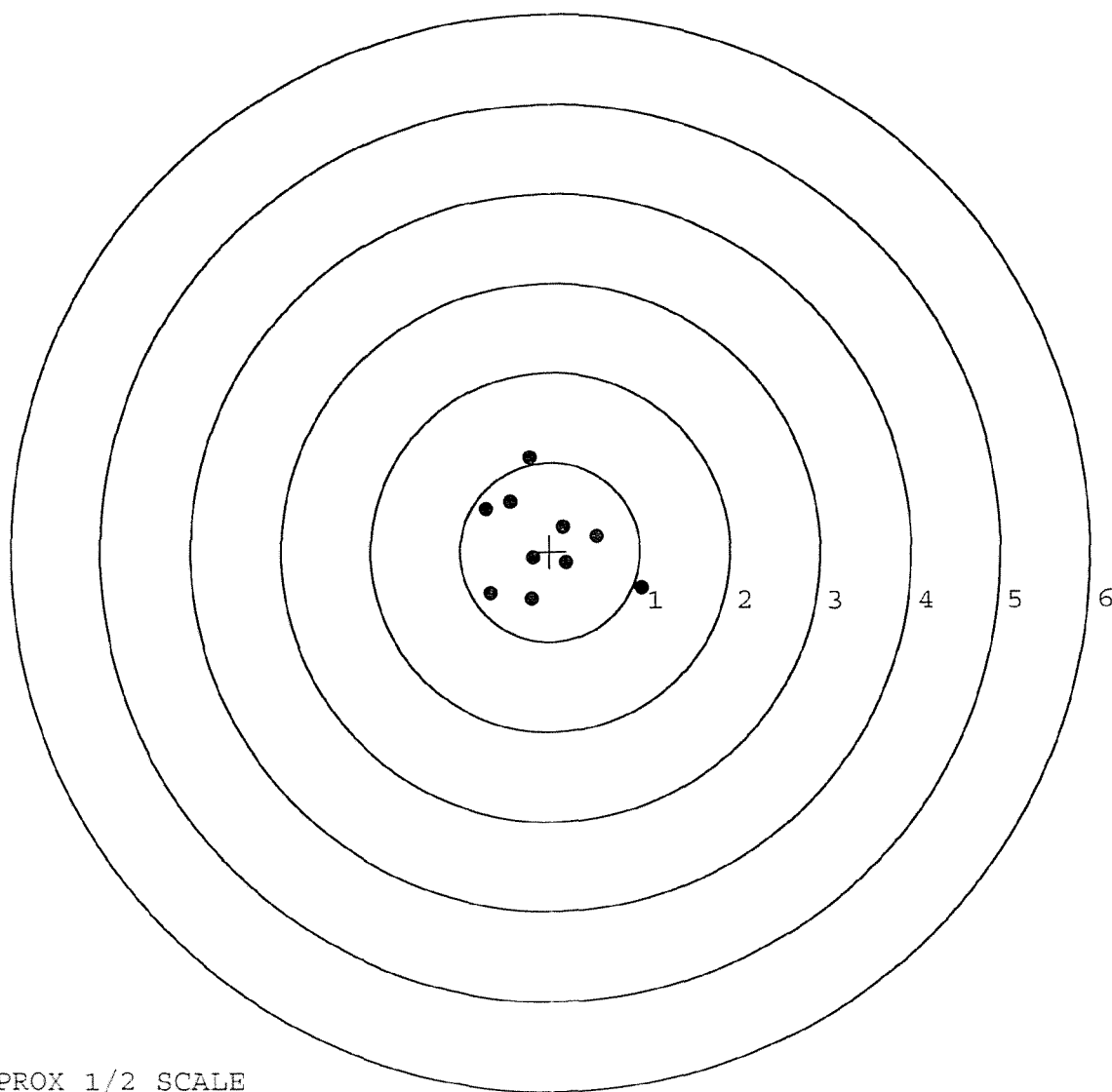


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6611414. __0
TARGET NUMBER: 3
FILE DATE: 11/12/2004
FILE TIME: 21:52

POINT#	X	Y
1:	1.017	-0.417
2:	0.515	0.168
3:	0.143	0.278
4:	-0.441	0.566
5:	-0.708	0.482
6:	-0.225	1.057
7:	-0.662	-0.466
8:	-0.207	-0.533
9:	0.186	-0.128
10:	-0.191	-0.072

X CENTROID: -0.057
Y CENTROID: 0.093
POA TO CENTROID: 0.110
HORZ SPREAD: 1.725
VERT SPREAD: 1.590
GROUP SPREAD: 1.945
MIN RADIUS: 0.213
MAX RADIUS: 1.189
MEAN RADIUS: 0.639
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6611414. __0

TARGET NUMBER: 4

FILE DATE: 11/12/2004

FILE TIME: 21:52

POINT#	X	Y
1:	1.125	-0.544
2:	0.630	-0.066
3:	0.983	0.397
4:	0.267	-0.106
5:	-0.062	-0.863
6:	-0.153	-0.236
7:	-0.761	-0.036
8:	-0.162	0.466
9:	-0.884	0.744
10:	0.464	-0.051

X CENTROID: 0.145

Y CENTROID: -0.030

POA TO CENTROID: 0.148

HORZ SPREAD: 2.009

VERT SPREAD: 1.607

GROUP SPREAD: 2.386

MIN RADIUS: 0.144

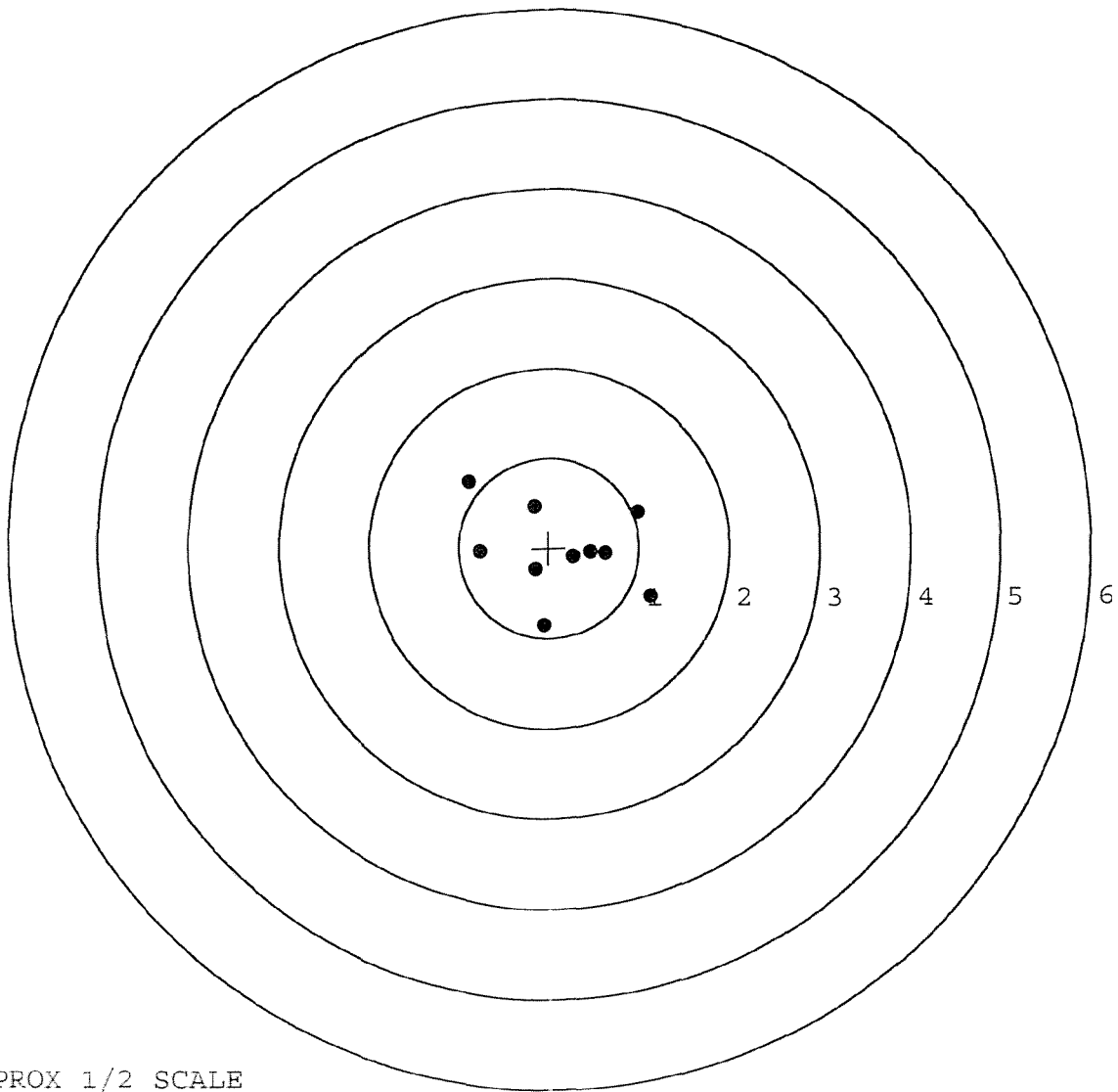
MAX RADIUS: 1.287

MEAN RADIUS: 0.700

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10

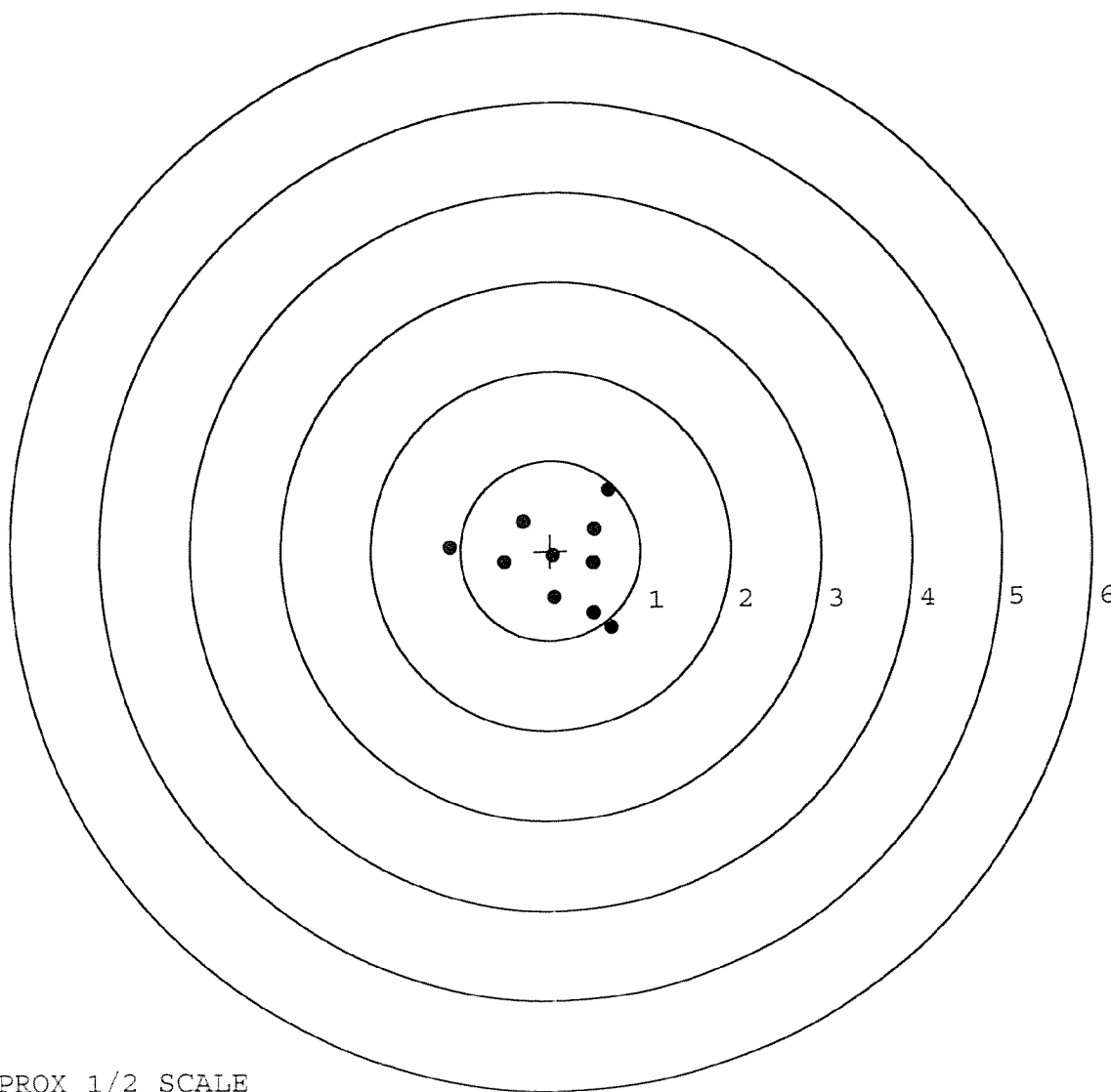


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6611414.___0
TARGET NUMBER: 5
FILE DATE: 11/12/2004
FILE TIME: 21:52

X CENTROID: 0.091
Y CENTROID: -0.112
POA TO CENTROID: 0.145
HORZ SPREAD: 1.790
VERT SPREAD: 1.534
GROUP SPREAD: 2.009
MIN RADIUS: 0.080
MAX RADIUS: 1.219
MEAN RADIUS: 0.645
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.673	-0.863
2:	0.479	-0.701
3:	0.475	-0.141
4:	0.491	0.235
5:	0.653	0.671
6:	0.033	-0.057
7:	0.044	-0.523
8:	-0.519	-0.123
9:	-0.302	0.328
10:	-1.117	0.050



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)

SERIAL NO.

DATE

6-22-04

TESTER

RW

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.63	2.46		2.19	
PULL #2	2.71	2.58		2.17	
PULL #3	2.76	2.57		2.23	
PULL #4	2.56	2.47		2.19	
PULL #5	2.53	2.60		2.16	
TOTAL	13.19	12.68		10.94	
AVERAGE	2.64	2.54		2.19	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.10	3.21		
PULL #2	3.05	3.02		
PULL #3	3.09	3.06		
PULL #4	3.18	3.12		
PULL #5	3.16	3.09		
TOTAL	15.58	15.50		
AVERAGE	3.12	3.10		

	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	4.24	4.27		4.21
PULL #2	4.24	4.28		4.04
PULL #3	4.21	4.21		4.25
PULL #4	4.24	4.22		4.24
PULL #5	4.19	4.23		4.12
TOTAL	21.12	21.21		20.86
AVERAGE	4.22	4.24		4.17

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

R & E NUMBER	87061		
SERIAL NUMBER	C661 1414		
LOG-IN DATE	10-27-04		
INSPECT AND VERIFY:			
OPERATION #	OPERATION NAME	DATE	INITIAL
550	DIS-ASSEMBLE GUN	10-29-04	RTZ
560 A	RE-BARREL	11-2-04	RTZ
B	DRILL AND TAP	11-4-04	TRW
575	ASSEMBLE	11-2-04	RTZ
600	PROOF	11-3-04	RTZ
605	CHECK HEADSPACE	11-3-04	RTZ
610	DIS-ASSEMBLE GUN	11-4-04	RTZ
612	MAGNAFLUX		
615	ROLLMARK CALIBER	11/5/04	LB
618	ROTO-BLAST	11-6-04	LB
620	APPLY COATINGS	11/9	HP
625 A	FINAL ASSEMBLY	11-11-04	RTZ
B	TRIGGER PULL TEST	11-16-04	DA
C	SAFETY "ON" FORCE	11-16-04	DA
D	SAFETY "OFF" FORCE	11-16-04	DA
E	FIRING PIN INDENT	11-16-04	DA
640	TARGET	11-12-04	TRW
655	FINAL INSPECT	11-17-04	AC
660	PACK	11-17-04	DA
		SHIP DATE	
		QAR INSPECTION DATE	




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

REG. U.S. PAT. & TM. OFF.

MODEL 700™ H24

4.5

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

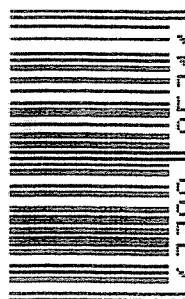
SERIAL NO.

C6611414

ORDER NO.

5715

UPC



0 47700 25716 7



5715 C6611414

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C 6611414

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		3/26/91	K.S.
600	Proof		3/26/91	K.S.
607	Check Headspace		3/26/91	K.S.
610	Dis-assemble Gun		3/26/91	K.S.
612	Magnaflux Barrel Action		APR 2 1991	KR
	Magnaflux Bolt		APR 2 1991	"
615	Rollmark Caliber		APR 2 1991	JS
617	Drill and Tap Sight Holes		APR 5 1991	LB
618	Polish Barrel		APR 5 1991	WB
620	Apply Coatings (Barrel Action)		4-16-91	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		4/10/91	K.S.
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		4/10/91	K.S.
	C) Inspect Ejector Hole for Chamfer		4/10/91	K.S.
	D) Oil Firing Pin Ass'y		4/10/91	K.S.
	E) Adjust Trigger Pull to Min Setting and Stake		4/15/91	JS

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			4-16-91	DH
	G) Safety Off Force	2	2	2			4-16-91	DH
	H) Trigger Pull Test & Retainability						4/15/91	SH
	I) Firing Pin Indent	1020	1021	1020			4-16-91	DH
	J) Assemble Stock						4/22/91	KS
	K) Assemble Swivel Studs						4-30-91	DH
	L) Attach Front and Rear Sight Assemblies						4/22/91	KS
	M) Iron Sight Alignment						4/22/91	KS
	N) Detach Front & Rear Sights & place in numbered container						4/22/91	KS
	O) Attach Scope to Rifle						4/22/91	KS
	P) Detach & Attach Scope 20 Times						4/22/91	KS
640	Gallery Target & Test						4/23/91	KT
	A) Time							KT
	B) Malfunctions							KT
	C) Pierced Primers							KT
	D) Optical Clarity of Scope							KT
645	Inspect for Live Ammo						4/23/91	KT
655	Final Inspection							
	A) Headspace						4-30-91	DH
	B) Trigger Pull	2.22	2.20	2.23	2.20	2.23	4/26/91	SH
	C) Function						4-30-91	DH
660	Pack						6-18-91	VF

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C6611414

DATE 4/15/91

TESTER JR

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.50	2.34	2.30	2.22	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.38	2.27	2.33	2.20	
PULL #3	2.37	2.22	2.28	2.23	
PULL #4	2.42	2.18	2.26	2.20	
PULL #5	2.30	2.29	2.33	2.23	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.47	3.51		
PULL #2	3.49	3.50		
PULL #3	3.50	3.30		
PULL #4	3.30	3.38		
PULL #5	3.43	3.52		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.30	4.32		4.38
PULL #2	4.43	4.47		4.29
PULL #3	4.29	4.47		4.13
PULL #4	4.30	4.25		4.32
PULL #5	4.38	4.48		4.50
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611414
23 Apr 1991

CENTROIDAL DISTANCES

0 TO 1	.170699
1 TO 2	.246976
1 TO 3	.272839
1 TO 4	.348511
1 TO 5	.268881

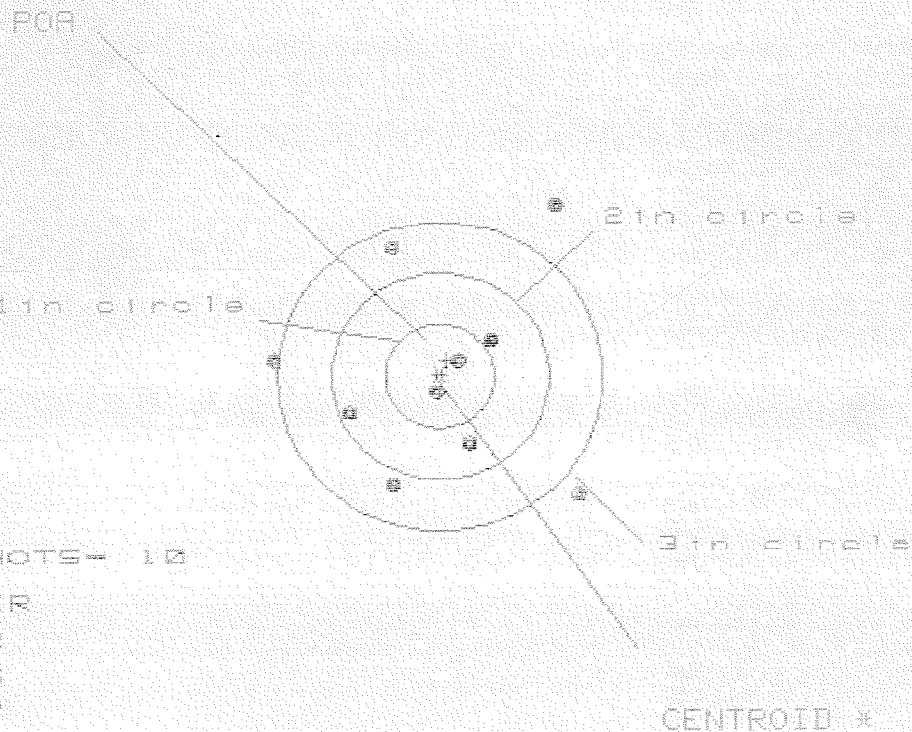
<----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0976
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0262
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .101055
THE AMR FOR THIS RIFLE IS: .0822

23 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8B11414

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 7

HS= 2.797

VS= 2.800

GS= 3.092

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.223	1.346	.714
MINIMUM X	:	-1.574	-1.451	-1.283
MAXIMUM Y	:	1.619	1.402	1.276
MINIMUM Y	:	-1.181	-1.001	-1.019
CENTROID X	:	-.067	-.190	-.358
CENTROID Y	:	-.157	-.337	-.211
POA TO CENTROID in.	:	.176	.387	.416
MIN RADIUS	:	.184	.048	.242
MEAN RADIUS	:	1.024	.902	.829
MAX RADIUS	:	1.962	1.678	1.297
HORIZONTAL SPREAD	:	2.797	2.797	1.997
VERTICAL SPREAD	:	2.800	2.403	2.295
EXTREME SPREAD	:	3.092	3.092	2.295
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		7	

23 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611414

CENTERFIRE PATTERNS # 2

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 3

2in = 6

3in = 10

HS= 2.169

VS= 1.485

GS= 2.452

CENTROID *

PATTERN #

:

2

SHOTS (BEST OF)

:

10

9

8

MAXIMUM X

:

1.113

1.212

1.093

MINIMUM X

:

-1.056

-.957

-.841

MAXIMUM Y

:

.635

.540

.532

MINIMUM Y

:

-.858

-.430

-.362

CENTROID X

:

-.013

-.112

.007

CENTROID Y

:

.084

.179

.111

POA TO CENTROID in.

:

.085

.211

.111

MIN RADIUS

:

.137

.140

.134

MEAN RADIUS

:

.767

.712

.655

MAX RADIUS

:

1.234

1.286

1.151

HORIZONTAL SPREAD

:

2.169

2.169

1.934

VERTICAL SPREAD

:

1.485

.970

.894

EXTREME SPREAD

:

2.452

2.376

2.093

NUMBER IN ONE INCH CIRCLE =

:

3

NUMBER IN TWO INCH CIRCLE =

:

6

NUMBER IN THREE INCH CIRCLE =

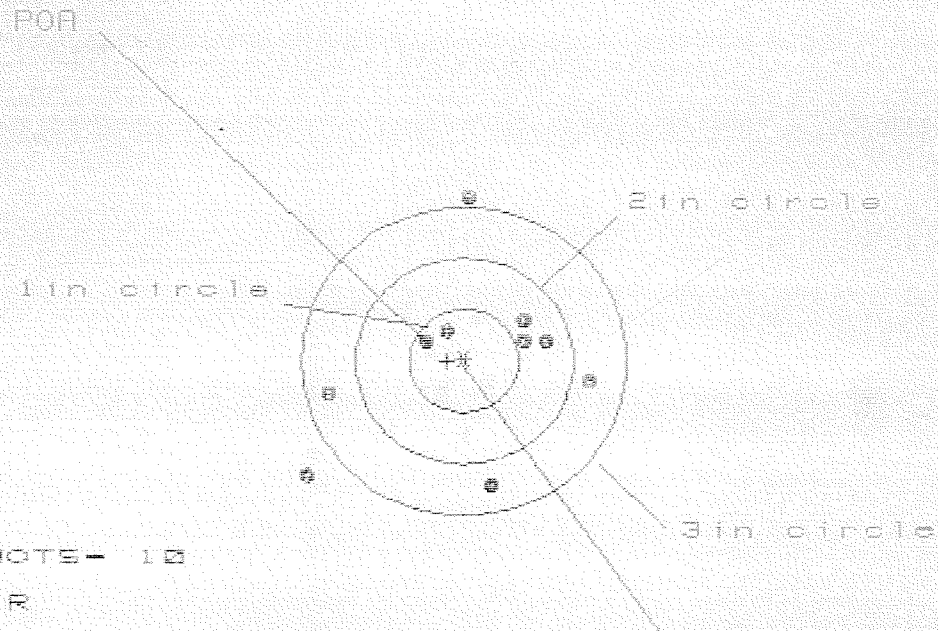
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10

23 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611414

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 8

HS= 2.569

VS= 2.806

GS= 3.024

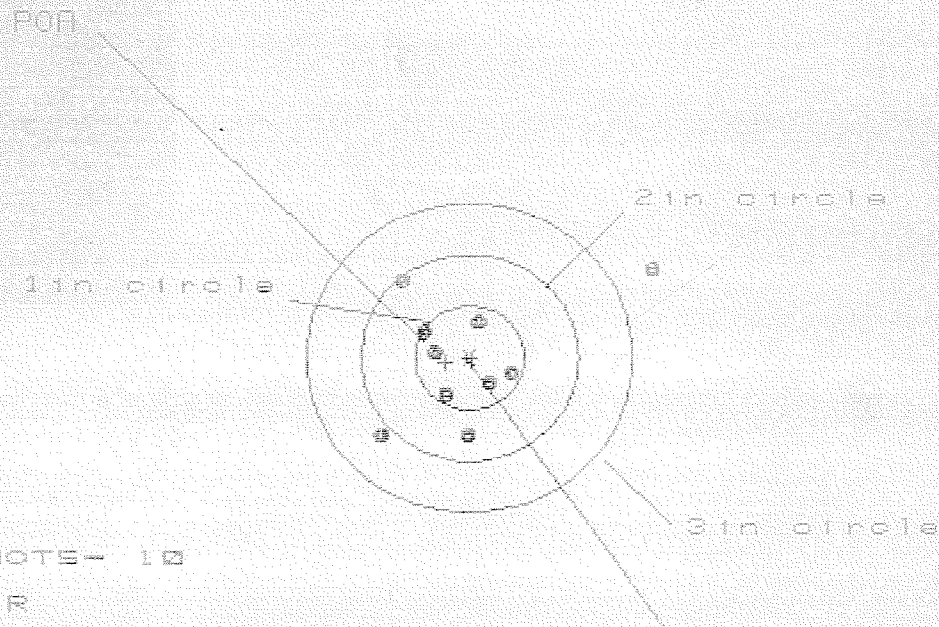
CENTROID *

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.119	.958	.939
MINIMUM X	-1.450	-1.405	-1.424
MAXIMUM Y	1.568	1.448	.478
MINIMUM Y	-1.238	-1.358	-1.177
CENTROID X	.154	.315	.334
CENTROID Y	.003	.123	-.059
POA TO CENTROID in.	.154	.338	.339
MIN RADIUS	.318	.367	.447
MEAN RADIUS	.991	.861	.801
MAX RADIUS	1.807	1.465	1.442
HORIZONTAL SPREAD	2.569	2.363	2.363
VERTICAL SPREAD	2.806	2.806	1.655
EXTREME SPREAD	3.024	2.818	2.364
NUMBER IN ONE INCH CIRCLE =	2	2	2
NUMBER IN TWO INCH CIRCLE =	5	5	5
NUMBER IN THREE INCH CIRCLE =	8	8	8

23 Apr 1993

FILE: /PATTERNING/CENTERFIRE_PATT/C6611414

CENTERFIRE PATTERNS # 4



* OF SHOTS- 10

IN CIR

1in = 5

2in = 8

3in = 9

HS= 2.490

VS= 1.617

GS= 2.969

CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.654	.583	.582
MINIMUM X	:	-.836	-.653	-.494
MAXIMUM Y	:	.838	.797	.718
MINIMUM Y	:	-.787	-.695	-.718
CENTROID X	:	.217	.834	.115
CENTROID Y	:	.045	-.047	.040
POA TO CENTROID in.	:	.222	.058	.122
MIN RADIUS	:	.307	.217	.239
MEAN RADIUS	:	.699	.553	.492
MAX RADIUS	:	1.850	.954	.865
HORIZONTAL SPREAD	:	2.490	1.236	.996
VERTICAL SPREAD	:	1.617	1.492	1.428
EXTREME SPREAD	:	2.969	1.558	1.558
NUMBER IN ONE INCH CIRCLE	=		5	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	

23 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C0611414

CENTERFIRE PATTERNS

5

POB

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 1

2in = 6

3in = 9

HS= 2.534

VS= 2.589

GS= 2.654

CENTROID *

PATTERN #

SHOTS (BEST OF)

MAXIMUM X

MINIMUM X

MAXIMUM Y

MINIMUM Y

CENTROID X

CENTROID Y

POB TO CENTROID in.

MIN RADIUS

MEAN RADIUS

MAX RADIUS

HORIZONTAL SPREAD

VERTICAL SPREAD

EXTREME SPREAD

NUMBER IN ONE INCH CIRCLE =

NUMBER IN TWO INCH CIRCLE =

NUMBER IN THREE INCH CIRCLE =

10

9

8

1.265

1.124

1.093

-1.269

-.838

-.869

1.234

1.323

1.164

-1.355

-1.266

-.845

.197

.338

.369

-.106

-.195

-.036

.224

.390

.371

.482

.374

.304

.930

.852

.777

1.501

1.325

1.169

2.534

1.962

1.962

2.589

2.589

2.009

2.654

2.595

2.051

1

6

9