

C6611422

MODEL 700™ M24

Model SMS™

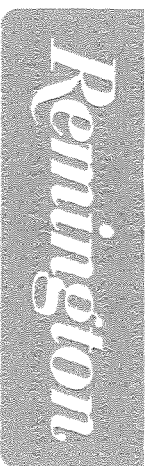
Action _____

Barrel Length _____

Capacity _____

Order No. 5716

* Includes 1 in chamber.



09/29/08 2:37 PM

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: RE00151958

Serial: C6611422 Model M24 SWS Center Fire
Caliber: 7.62 NATO Produced: 03/18/1991

Repairman:

Verify Repair

Status:

Closed 9/26/2008 8:28:49 AM

Address Information

Customer:

Received From

Return To:

Received From

Name: FB 4418 437 APS/TRTC

FB 4418 437 APS/TRTC

Address 1: 113 S BATES ST BLDG 178

113 S BATES ST BLDG 178

Address 2:

PO Box:

PO Box:

City: CHARLESTON AFB

CHARLESTON AFB

State: SC

Zip Code: 29404

Country: US

State: SC

Zip Code: 29404

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
A045	Bi Pod	1
A057	Fit and Rear Sgt Base	1

Repair Search

Refresh

Close

nagletj

9/29/2008

2:37 PM

C&PS

NUM

INS

SCRL

start

13 M...

4 M...

HR Ba...

2 Int...

Arms...

Part 5...

2:37 PM

Serial Number:

C6611422

Model M24 SWS



RE00151958

M-24
INSPECTION CHECKLIST - REPAIRS
CONTRACT #: W52H09-07-C-0207
ISSUED 10/1/2007

R & E NUMBER <u>151958</u>				
SERIAL NUMBER <u>C6611422</u>				
LOG-IN DATE <u>9-26-08</u>				

OPERATION #	OPERATION NAME		DATE	INITIAL
500	DIS-ASSEMBLE GUN		5-21-09	RTZ
505	RE-BARREL		5-26-09	RTZ
420	ASSEMBLE		5-26-09	RTZ
440	PROOF	MAGNA - FLUX	5-26-09	RTZ
460	CHECK HEADSPACE		5-26-09	RTZ
470	DIS-ASSEMBLE GUN		5-26-09	RTZ
480	MAGNAFLUX	OPERATOR <u>(D)</u>	5-30-09	(D)
510	DRILL AND TAP		5-27-09	SP
500	ROLLMARK CALIBER		6-1-09	RT
520	GOFF BLAST BBL / REC		6-1-09	DWD
530 & 540	APPLY COATINGS		6-1-09	
560	FINAL ASSEMBLY		6-5-09	LJN
640	FUNCTION TEST AND	PASS FAIL	6/5/09	RB
650	TARGET	PASS FAIL	6/5/09	RB
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
670	FINAL INSPECTION		6/5/09	TOR
	A) HEADSPACE	PASS FAIL	6/5/09	LJN
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	264 262 267 271 256 6-5-09 RTZ	
680	F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX	40 40 40 6-5-09	LJN
	G) SAFETY OFF FORCE	2 LBS MIN	50 40 50 6-5-09	LJN
	I) FIRING PIN INDENT	.020	.022 .022 .022 6-5-09	LJN
690	PACK		6/8/09	FM

F006 REV 1/2009

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6611422.__0

FILE DATE AND TIME: 06/05/2009 12:02

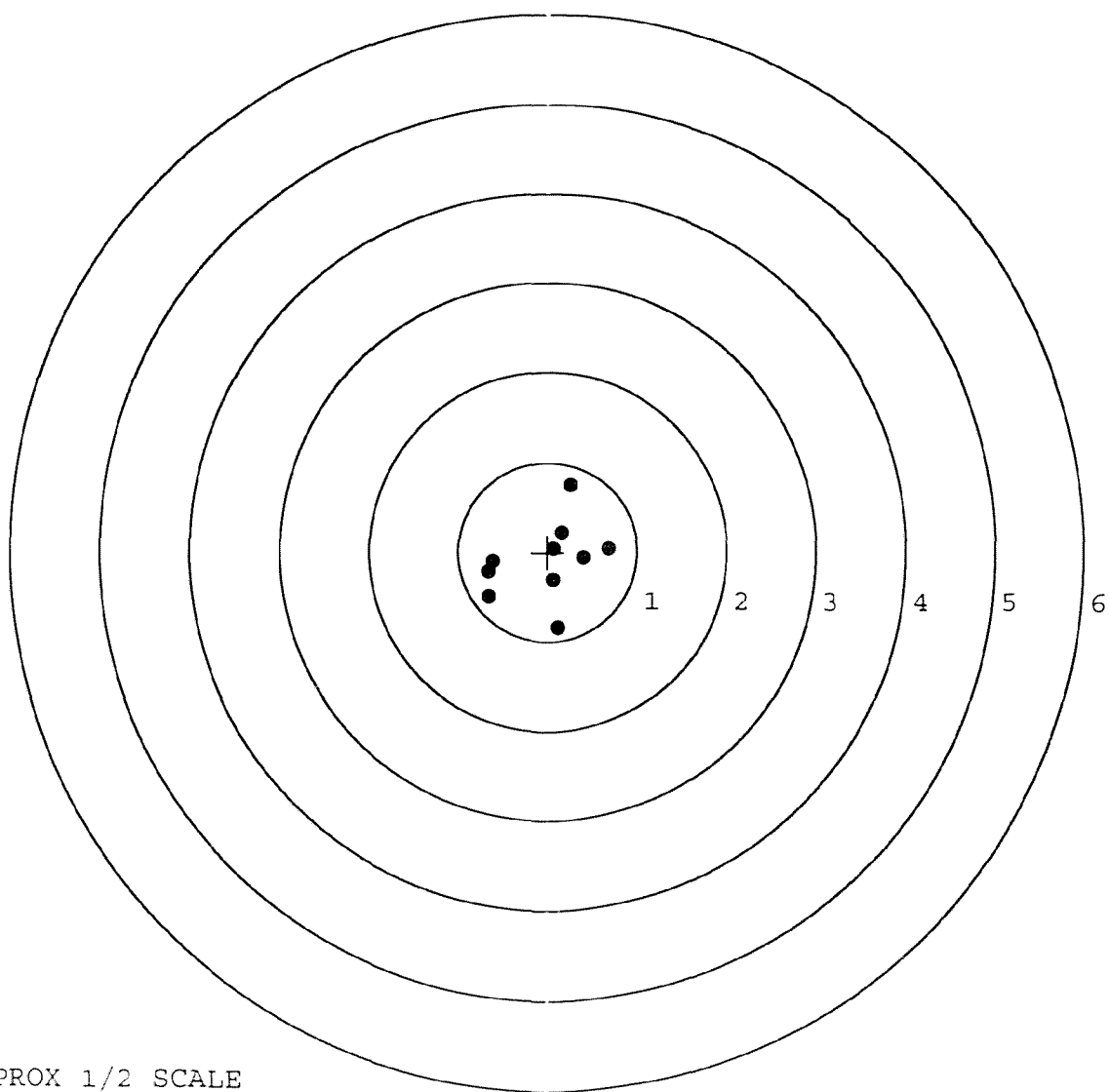
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.091
The Average Y Centroid of the Five Target Set:	0.015
The Average Point of Impact of the Five Target Set:	0.092
The Average Mean Radius of the Five Target Set:	0.590
The Distance from POA to Centroid Target #1:	0.105
The Distance from Centroid Target #2 to Centroid Target #1:	0.213
The Distance from Centroid Target #3 to Centroid Target #1:	0.308
The Distance from Centroid Target #4 to Centroid Target #1:	0.086
The Distance from Centroid Target #5 to Centroid Target #1:	0.245

SERIAL NUMBER: C6611422. __0
TARGET NUMBER: 1
FILE DATE: 06/05/2009
FILE TIME: 12:02

POINT#	X	Y
1:	0.254	0.751
2:	0.683	0.036
3:	0.402	-0.069
4:	0.157	0.215
5:	0.068	0.041
6:	0.065	-0.316
7:	0.119	-0.849
8:	-0.656	-0.508
9:	-0.660	-0.228
10:	-0.612	-0.110

X CENTROID: -0.018
Y CENTROID: -0.104
POA TO CENTROID: 0.105
HORZ SPREAD: 1.343
VERT SPREAD: 1.600
GROUP SPREAD: 1.606
MIN RADIUS: 0.168
MAX RADIUS: 0.897
MEAN RADIUS: 0.555
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 10
in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6611422.___0

TARGET NUMBER: 2

FILE DATE: 06/05/2009

FILE TIME: 12:02

POINT#	X	Y
1:	0.149	1.301
2:	0.245	0.382
3:	-0.312	0.432
4:	-0.783	0.637
5:	-0.308	0.056
6:	-0.057	-0.015
7:	0.081	-0.240
8:	0.092	-0.568
9:	0.364	-0.768
10:	-0.001	-0.154

X CENTROID: -0.053

Y CENTROID: 0.106

POA TO CENTROID: 0.119

HORZ SPREAD: 1.147

VERT SPREAD: 2.069

GROUP SPREAD: 2.080

MIN RADIUS: 0.121

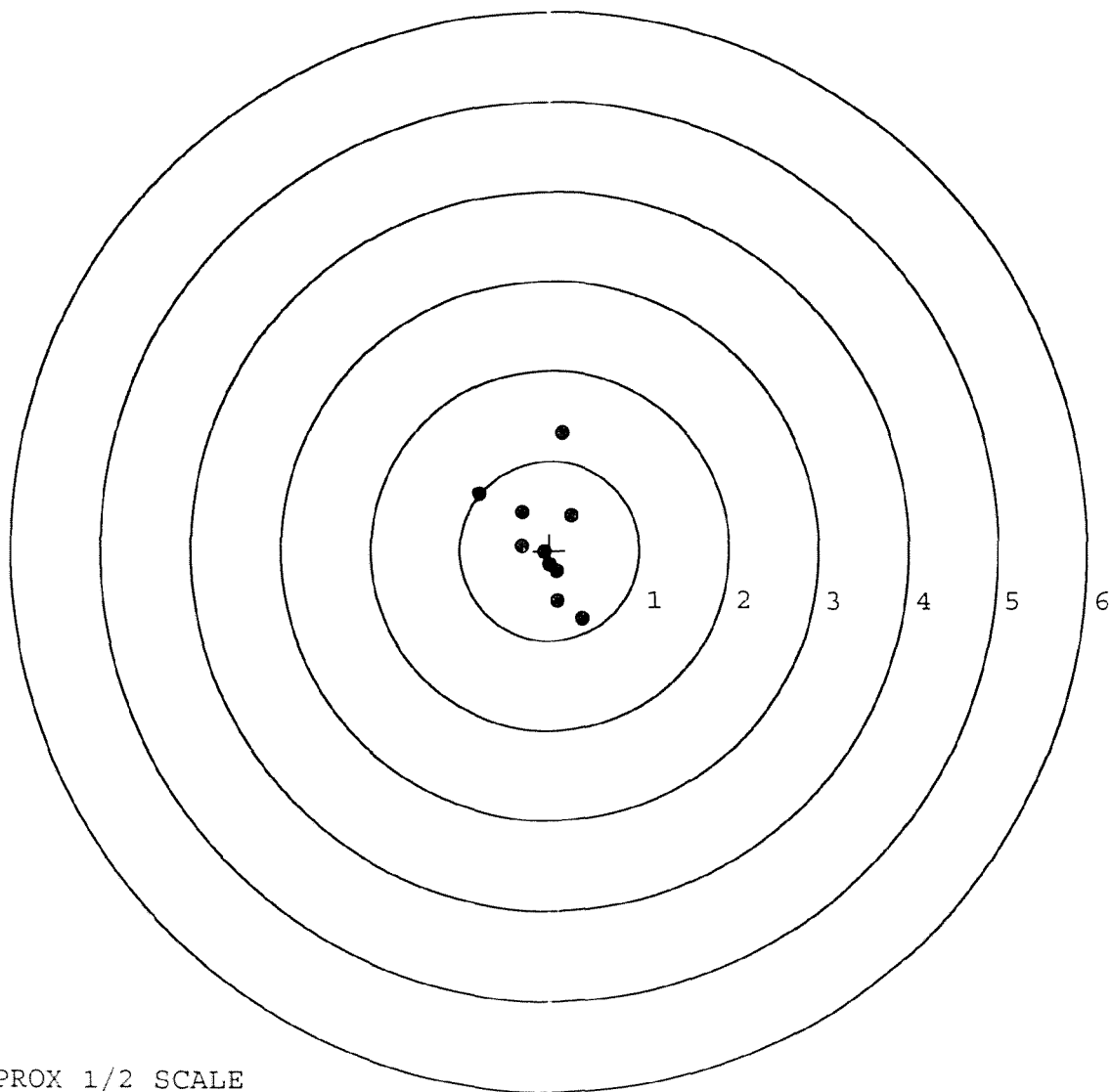
MAX RADIUS: 1.212

MEAN RADIUS: 0.561

IN 1 IN DIAMETER: 6

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10

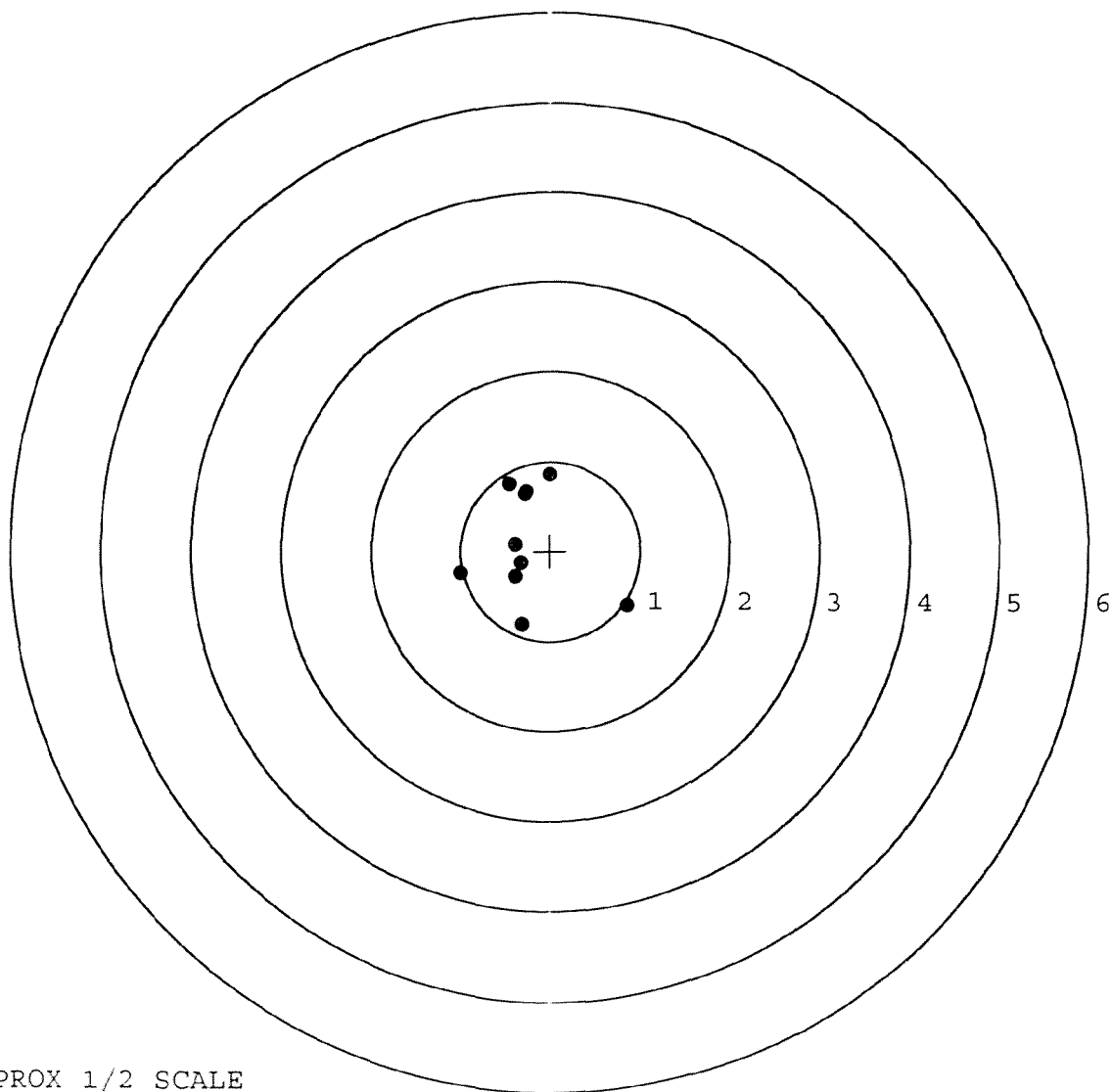


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6611422. __0
TARGET NUMBER: 3
FILE DATE: 06/05/2009
FILE TIME: 12:02

POINT#	X	Y
1:	0.006	0.854
2:	-0.281	0.642
3:	-0.458	0.755
4:	-1.004	-0.252
5:	-0.318	-0.818
6:	0.857	-0.603
7:	-0.388	-0.284
8:	-0.322	-0.132
9:	-0.390	0.080
10:	-0.273	0.670

X CENTROID: -0.257
Y CENTROID: 0.091
POA TO CENTROID: 0.273
HORZ SPREAD: 1.861
VERT SPREAD: 1.672
GROUP SPREAD: 1.894
MIN RADIUS: 0.133
MAX RADIUS: 1.313
MEAN RADIUS: 0.644
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

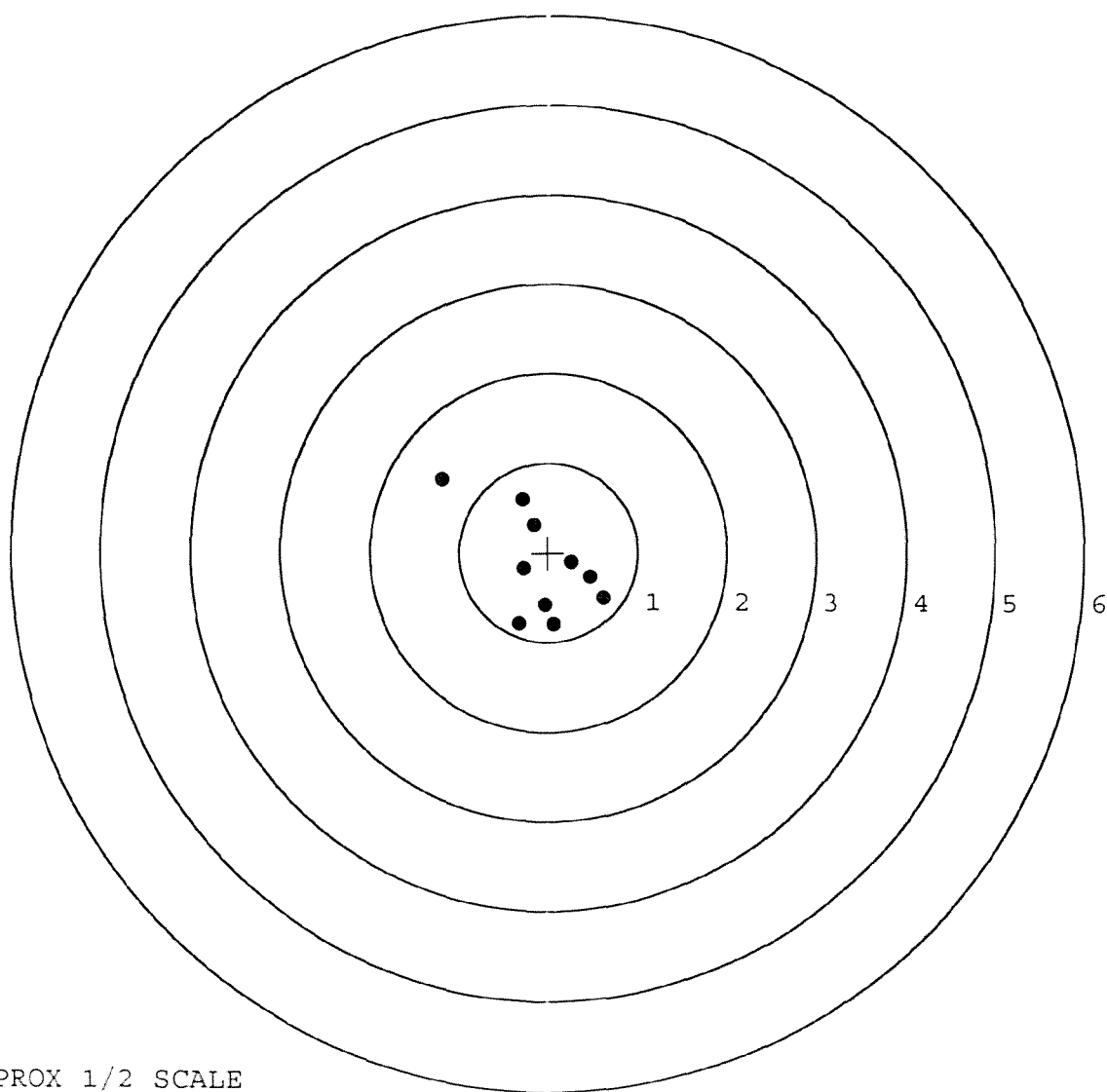


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6611422.___0
TARGET NUMBER: 4
FILE DATE: 06/05/2009
FILE TIME: 12:02

POINT#	X	Y
1:	-1.188	0.815
2:	-0.290	0.592
3:	-0.166	0.309
4:	-0.274	-0.181
5:	-0.325	-0.804
6:	0.071	-0.809
7:	-0.039	-0.592
8:	0.265	-0.110
9:	0.472	-0.278
10:	0.616	-0.516

X CENTROID: -0.086
Y CENTROID: -0.157
POA TO CENTROID: 0.179
HORZ SPREAD: 1.804
VERT SPREAD: 1.624
GROUP SPREAD: 2.242
MIN RADIUS: 0.190
MAX RADIUS: 1.470
MEAN RADIUS: 0.642
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

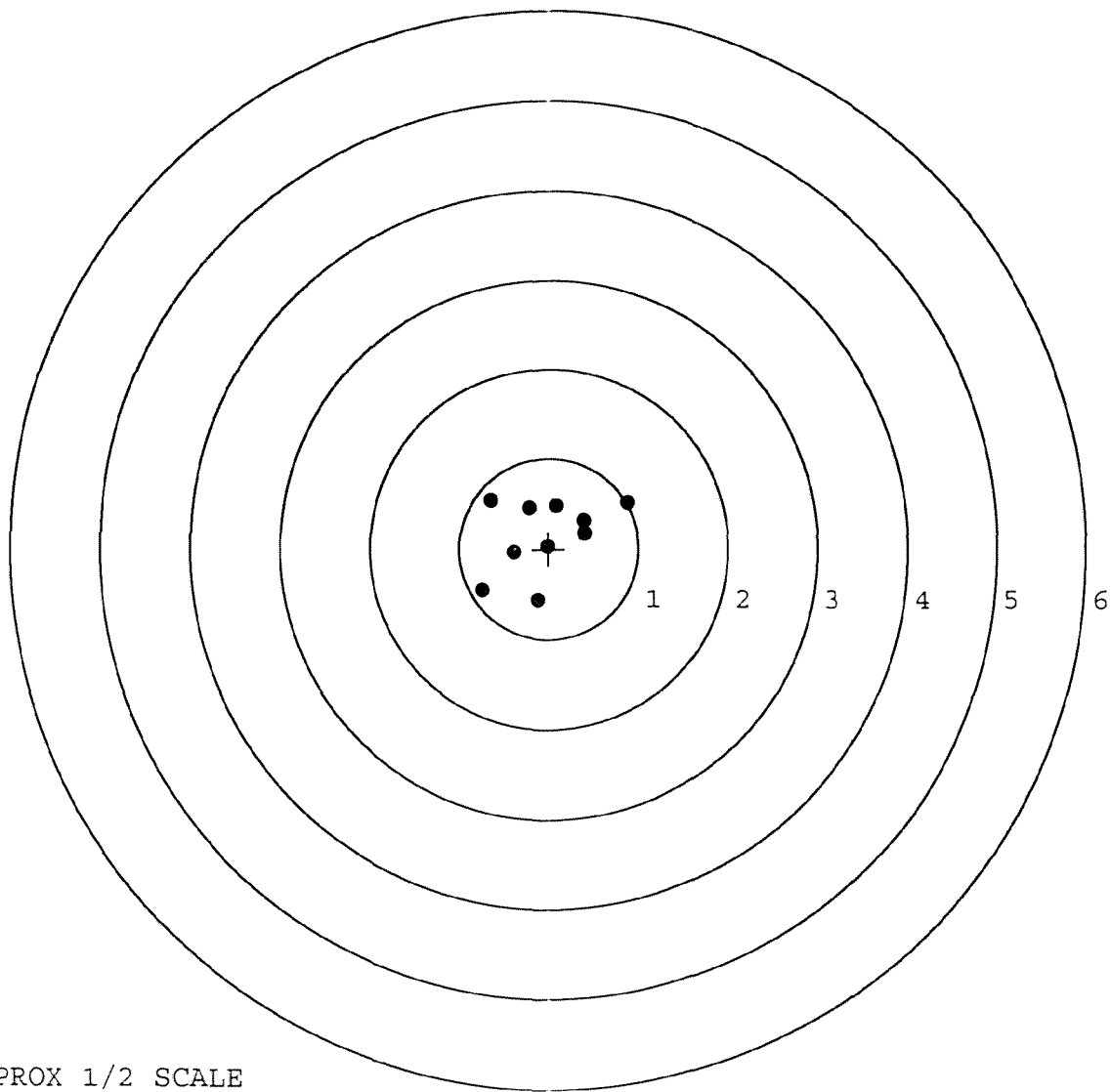


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6611422. __0
TARGET NUMBER: 5
FILE DATE: 06/05/2009
FILE TIME: 12:02

X CENTROID: -0.040
Y CENTROID: 0.140
POA TO CENTROID: 0.146
HORZ SPREAD: 1.614
VERT SPREAD: 1.107
GROUP SPREAD: 1.882
MIN RADIUS: 0.114
MAX RADIUS: 0.985
MEAN RADIUS: 0.548
IN 1 IN DIAMETER: 6
IN 2 IN DIAMETER: 10
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.874	0.507
2:	0.396	0.170
3:	0.391	0.309
4:	0.081	0.476
5:	-0.224	0.448
6:	-0.651	0.535
7:	-0.393	-0.041
8:	-0.008	0.031
9:	-0.740	-0.461
10:	-0.124	-0.572



TARGET APPROX 1/2 SCALE



MODEL 700TM N24

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

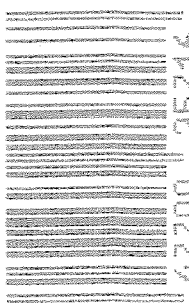


VERY IMPORTANT
Instruction Book
enclosed to assure
safe use of this
firearm.

SERIAL NO.
C6611422

ORDER NO.
5716

UPC



0 4700 25716 2



5716 C6611422

GEM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # 06611422

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	1 25	91	RW
600	Proof	1 25	91	RW
607	Check Headspace	1 25	91	RW
610	Dis-assemble Gun	1 25	91	RW
612	Magnaflux Barrel Action	1 25	91	KR
	Magnaflux Bolt	1 25	91	KR
615	Rollmark Caliber	1 25	91	GS
617	Drill and Tap Sight Holes	1 30	91	FB
618	Polish Barrel <i>RBB</i>	1 30	91	WB
620	Apply Coatings (Barrel Action)		2-10-91	TJH
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		2/11/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		2/11/91	RW
	C) Inspect Ejector Hole for Chamfer		2/11/91	RW
	D) Oil Firing Pin Ass'y		2/11/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		2/11/91	JL

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	4 ³ / ₄	4 ³ / ₄			2/11/91	WB
	G) Safety Off Force	3	2 ³ / ₄	2 ³ / ₄			2/11/91	WB
	H) Trigger Pull Test & Retainability						2/11/91	WB
	I) Firing Pin Indent	.0225	.023	.023			2/11/91	WB
	J) Assemble Stock						2/15/91	RW
	K) Assemble Swivel Studs						2-22-91	A
	L) Attach Front and Rear Sight Assemblies						2/15/91	RW
	M) Iron Sight Alignment						2/13/91	RW
	N) Detach Front & Rear Sights & place in numbered container						2/13/91	RW
	O) Attach Scope to Rifle						2/13/91	RW
	P) Detach & Attach Scope 20 Times						2/13/91	RW
640	Gallery Target & Test						2-13-91	DH
	A) Time						2-13-91	DH
	B) Malfunctions						2-13-91	DH
	C) Pierced Primers						2-13-91	DH
	D) Optical Clarity of Scope						2-13-91	DH
645	Inspect for Live Ammo						2-13-91	DH
655	Final Inspection							
	A) Headspace						2-22-91	A
	B) Trigger Pull	2.17	2.28	2.15	2.14	2.25	2/20/91	WB
	C) Function						2-22-91	A
660	Pack						3-14-91	V

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C661422

DATE 2/11/91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.27	2.23	2.34	2.17	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.39	2.24	2.28	2.28	
PULL #3	2.50	2.22	2.33	2.15	
PULL #4	2.26	2.27	2.20	2.14	
PULL #5	2.34	2.22	2.21	2.25	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.30	3.53		
PULL #2	3.26	3.35		
PULL #3	3.30	3.14		
PULL #4	3.54	3.31		
PULL #5	3.53	3.23		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.29	4.26		4.37
PULL #2	4.21	4.11		4.38
PULL #3	4.24	4.21		4.48
PULL #4	4.32	4.11		4.36
PULL #5	4.29	4.33		4.43
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06611422
14 Feb 1991

CENTROIDAL DISTANCES

0 TO 1	.178104
1 TO 2	.286723
1 TO 3	.0997647
1 TO 4	.196774
1 TO 5	.0506952

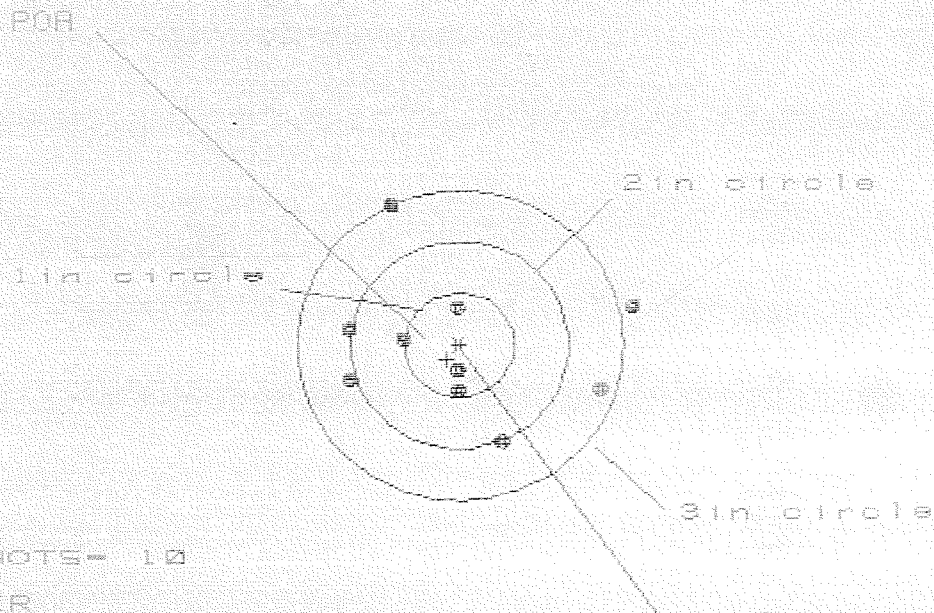
←----FOR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0638
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0582
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0811818
THE A.P.R. FOR THIS RIFLE IS: .9088

12 Feb 1984

FILE:/PATTERNING/CENTERFIRE_PATT/06611422

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1in = 3

2in = 5

3in = 9

ME = 2.600

VS = 2.267

GS = 2.653

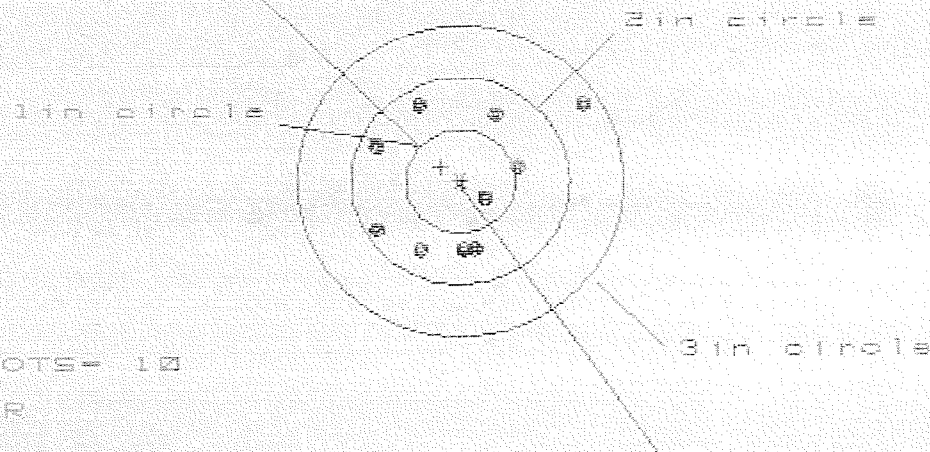
PATTERN #				
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.588	1.504	1.449
MINIMUM X	:	-1.012	-.835	-.890
MAXIMUM Y	:	1.357	1.393	.564
MINIMUM Y	:	-.910	-.874	-.700
CENTROID X	:	.115	-.062	-.007
CENTROID Y	:	.136	.100	-.075
POA TO CENTROID IN.	:	.178	.117	.075
MIN RADIUS	:	.241	.238	.088
MEAN RADIUS	:	.917	.807	.702
MAX RADIUS	:	1.622	1.550	1.463
HORIZONTAL SPREAD	:	2.600	2.339	2.339
VERTICAL SPREAD	:	2.267	2.267	1.263
EXTREME SPREAD	:	2.653	2.625	2.421
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

13 FEB 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6511422

CENTERFIRE PATTERNS # 2

POB



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 9

3 in = 10

HS= 1.882

VS= 1.482

GS= 2.234

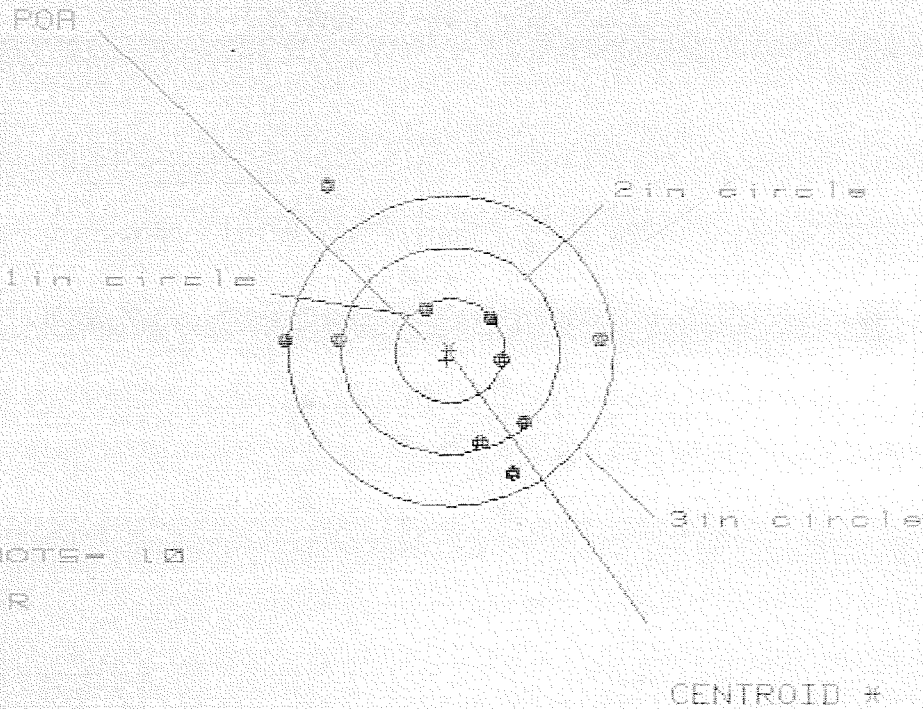
CENTROID *

PATTERN #		10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.089	.680	.597
MINIMUM X	:	-.794	-.673	-.756
MAXIMUM Y	:	.708	.872	.826
MINIMUM Y	:	-.694	-.610	-.656
CENTROID X	:	.172	.051	.134
CENTROID Y	:	-.145	-.229	-.182
POB TO CENTROID in.	:	.225	.235	.226
MIN RADIUS	:	.246	.340	.266
MEAN RADIUS	:	.762	.693	.674
MAX RADIUS	:	1.325	.907	.890
HORIZONTAL SPREAD	:	1.882	1.353	1.353
VERTICAL SPREAD	:	1.482	1.482	1.482
EXTREME SPREAD	:	2.234	1.556	1.556
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		9	
NUMBER IN THREE INCH CIRCLE	=		10	

13 Feb 1981

FILE:/PATTERNING/CENTERFIRE_PATT/C8B11422

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1 in = 2

2 in = 5

3 in = 8

HS= 3.912

VS= 2.711

GS= 3.202

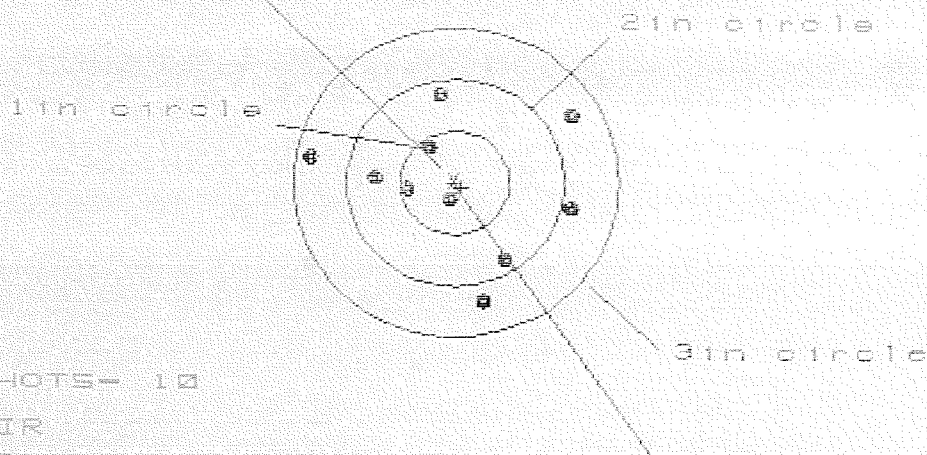
PATTERN #		10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.404	1.283	1.080
MINIMUM X	:	-1.508	-1.629	-1.325
MAXIMUM Y	:	1.562	.628	.664
MINIMUM Y	:	-1.149	-.975	-.939
CENTROID X	:	.027	.148	.351
CENTROID Y	:	.089	-.085	-.121
POB TO CENTROID in.	:	.093	.170	.372
MIN RADIUS	:	.427	.330	.194
MEAN RADIUS	:	1.041	.918	.783
MAX RADIUS	:	1.905	1.655	1.365
HORIZONTAL SPREAD	:	2.912	2.912	2.405
VERTICAL SPREAD	:	2.711	1.603	1.603
EXTREME SPREAD	:	3.202	2.912	2.405
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	5		
NUMBER IN THREE INCH CIRCLE	=	8		

13 Feb 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8611422

CENTERFIRE PATTERNS # 4

POB



* OF SHOTS- 10

IN CIR

1 in = 3

2 in = 5

3 in = 10

HS= 2.483

VS= 2.014

CS= 2.538

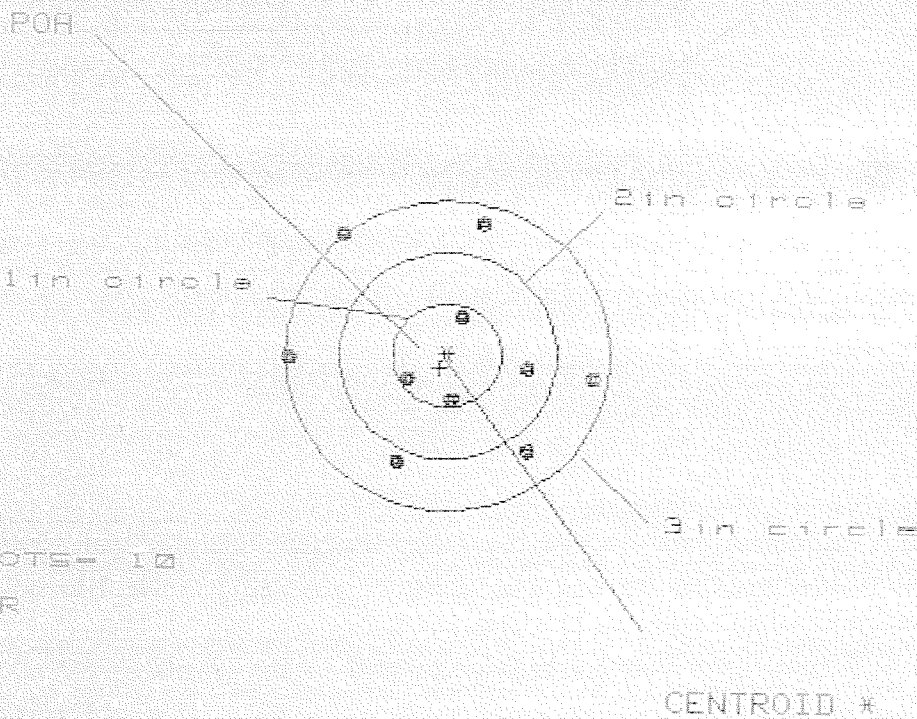
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.186	.953	1.067
MINIMUM X	-1.377	-.846	-.732
MAXIMUM Y	.848	.881	.970
MINIMUM Y	-1.166	-1.133	-1.044
CENTROID X	-.061	.092	-.022
CENTROID Y	.048	.015	-.074
POB TO CENTROID in.	.077	.094	.077
MIN RADIUS	.143	.197	.054
MEAN RADIUS	.848	.800	.721
MAX RADIUS	1.488	1.158	1.073
HORIZONTAL SPREAD	2.483	1.799	1.799
VERTICAL SPREAD	2.014	2.014	2.014
EXTREME SPREAD	2.538	2.056	2.056
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	10		

13 Feb 1991

FILE: /PATTERNING/CENTERFIRE_PATT/C6B11422

CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1in = 3

2in = 4

3in = 3

HS= 2.749

VS= 2.213

GS= 2.751

PATTERN #		10	9	8
SHOTS (BEST DF)	:	10	9	8
MAXIMUM X	:	1.314	1.282	1.008
MINIMUM X	:	-1.435	-1.547	-.747
MAXIMUM Y	:	1.248	1.375	1.384
MINIMUM Y	:	-.973	-.838	-.829
CENTROID X	:	.066	.178	.372
CENTROID Y	:	.123	-.012	-.021
POH TO CENTROID in.	:	.148	.179	.372
MIN RADIUS	:	.357	.266	.369
MEAN RADIUS	:	.976	.887	.798
MAX RADIUS	:	1.585	1.549	1.384
HORIZONTAL SPREAD	:	2.749	2.749	1.755
VERTICAL SPREAD	:	2.213	2.213	2.213
EXTREME SPREAD	:	2.751	2.751	2.333
NUMBER IN ONE INCH CIRCLE	:	3	3	3

NUMBER IN TWO INCH CIRCLE = 4
NUMBER IN THREE INCH CIRCLE = 9