

C6611428

MODEL 700TM M24

Model **SMS**TM

Action

Barrel Length

Capacity

Order No. **5715**

*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: **RE00103097** Serial: C6611528 Model: M24 SWS Center Fire Caliber: 7.62 NATO Produced: 06/18/1991 Repairman: Status: Closed 11/1/2005 3:10:15 PM

Verify Repair: [REDACTED]

Address Information

Customer: ☒ Received From Return To: ☐ Received From

Name: **JERRY NELSON STTD** **JERRY NELSON STTD**

Address 1: **1401 ARTILLERY CIRCLE** **1401 ARTILLERY CIRCLE**

Address 2: **ATTN SUPPLY BLDG 978** **ATTN SUPPLY BLDG 978** PO Box: **PO Box**

City: **FORT LEONARD WOOD** **FORT LEONARD WOOD**

State: **MO** Zip Code: **65473** Country: **US** State: **MO** Zip Code: **65473** Country: **US**

FFL: ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐

Contact / Condition Problems Estimate History / Status Shipping / Billing

Contact Information: Phone: **800 243 9700** Fax: Email: Comments:

Received Condition: Fair Condition Notes: CSR Notes:

Accessories Received:

Code	Desc	Qty
A007	With Stud	3
A009	Soft Case	1
A017	Scope Base	1
A045	Bi Pod	1
A057	Fit and Rear Sgt Base	1

Repair Search Refresh Close

negletj 11/2/2005 7:22 AM CAPS NUM JINS SCPL

start 2 Arms Service 5 3

Serial Number: **C6611528**

Model: **M24 SWS**

RE00103097

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6611528.__0
FILE DATE AND TIME: 11/18/2005 14:55

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.082
The Average Y Centroid of the Five Target Set:	0.036
The Average Point of Impact of the Five Target Set:	0.089
The Average Mean Radius of the Five Target Set:	0.585
The Distance from POA to Centroid Target #1:	0.197
The Distance from Centroid Target #2 to Centroid Target #1:	0.238
The Distance from Centroid Target #3 to Centroid Target #1:	0.270
The Distance from Centroid Target #4 to Centroid Target #1:	0.334
The Distance from Centroid Target #5 to Centroid Target #1:	0.181

SERIAL NUMBER: C6611528. __0

TARGET NUMBER: 1

FILE DATE: 11/18/2005

FILE TIME: 14:55

X CENTROID: -0.129

Y CENTROID: -0.149

POA TO CENTROID: 0.197

HORZ SPREAD: 1.515

VERT SPREAD: 1.273

GROUP SPREAD: 1.546

MIN RADIUS: 0.211

MAX RADIUS: 0.871

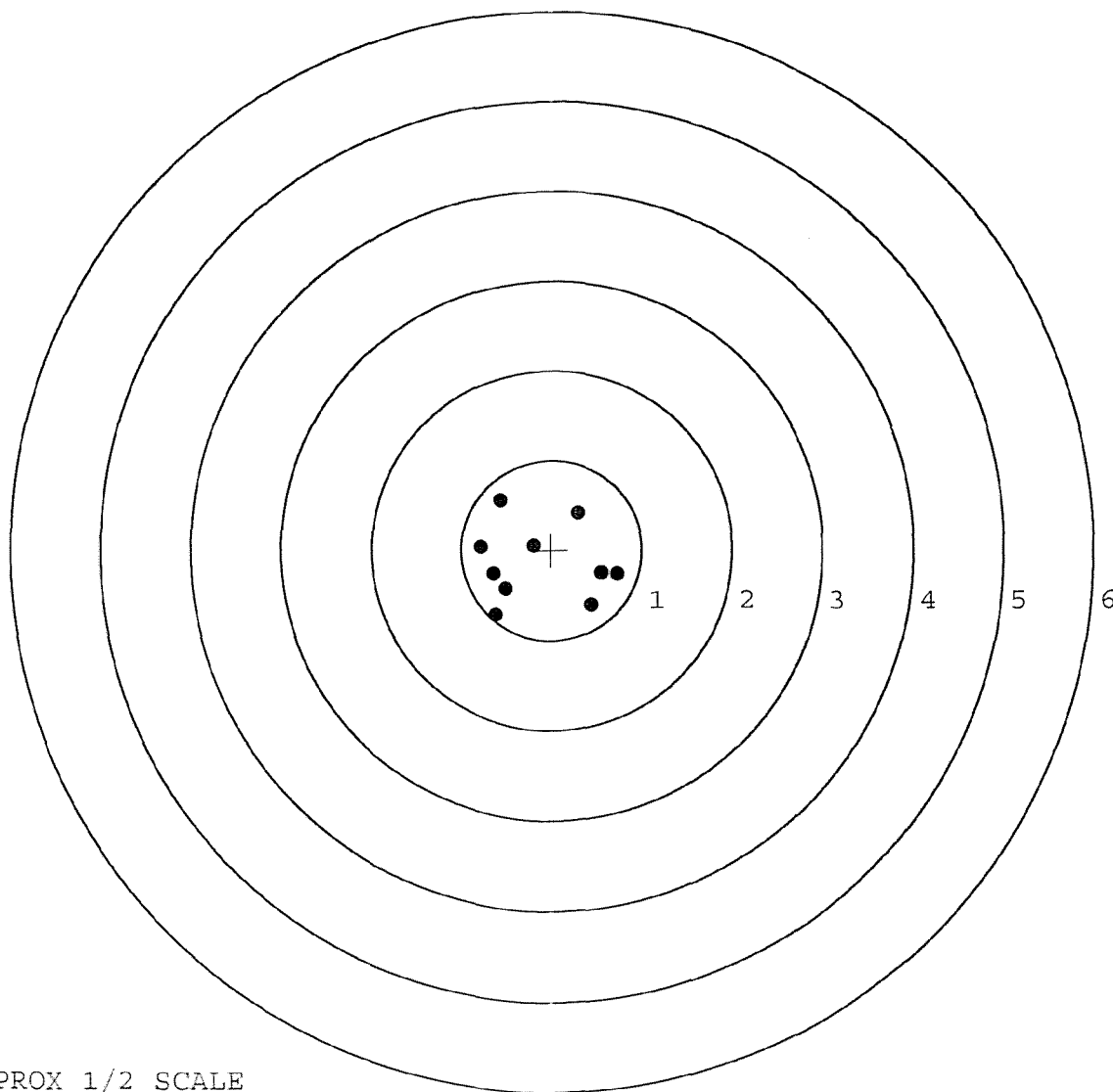
MEAN RADIUS: 0.648

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.446	-0.607
2:	0.733	-0.273
3:	0.557	-0.256
4:	0.297	0.413
5:	-0.569	0.559
6:	-0.196	0.051
7:	-0.782	0.034
8:	-0.643	-0.263
9:	-0.507	-0.433
10:	-0.625	-0.714



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6611528. __0

TARGET NUMBER: 2

FILE DATE: 11/18/2005

FILE TIME: 14:55

POINT#	X	Y
1:	0.252	-0.534
2:	-0.361	-0.567
3:	-0.561	-0.111
4:	0.536	0.043
5:	0.304	0.141
6:	0.142	0.253
7:	-0.050	0.297
8:	-0.216	0.080
9:	-0.142	0.440
10:	-0.202	0.631

X CENTROID: -0.030

Y CENTROID: 0.067

POA TO CENTROID: 0.074

HORZ SPREAD: 1.097

VERT SPREAD: 1.198

GROUP SPREAD: 1.209

MIN RADIUS: 0.187

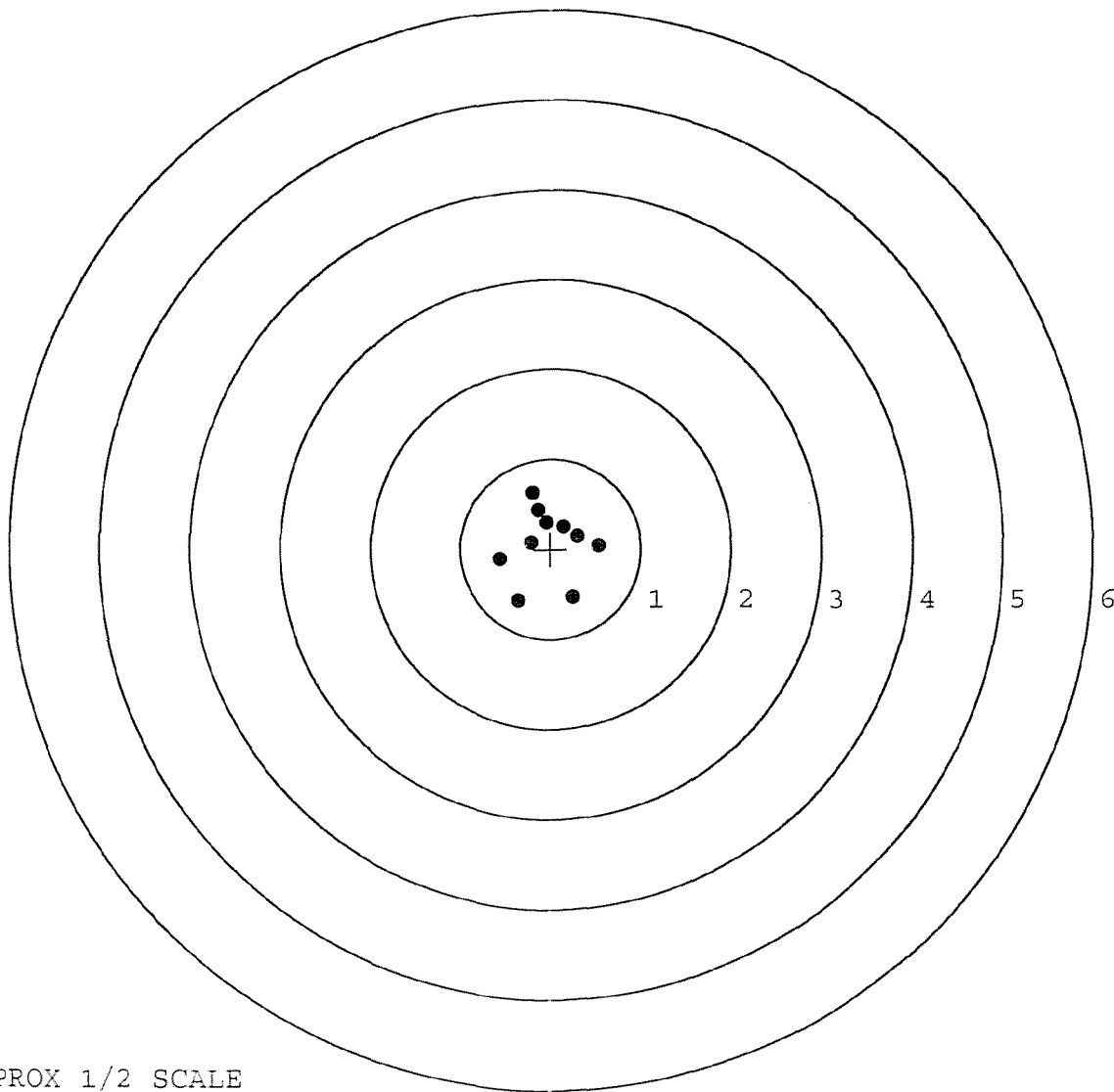
MAX RADIUS: 0.716

MEAN RADIUS: 0.450

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6611528. __0

TARGET NUMBER: 3

FILE DATE: 11/18/2005

FILE TIME: 14:55

POINT#	X	Y
1:	0.278	-0.708
2:	1.550	0.777
3:	0.200	0.545
4:	-0.619	0.579
5:	-0.419	0.445
6:	-1.092	-0.572
7:	0.371	-0.075
8:	0.099	0.071
9:	0.071	-0.129
10:	-0.032	-0.315

X CENTROID: 0.041

Y CENTROID: 0.062

POA TO CENTROID: 0.074

HORZ SPREAD: 2.642

VERT SPREAD: 1.485

GROUP SPREAD: 2.966

MIN RADIUS: 0.059

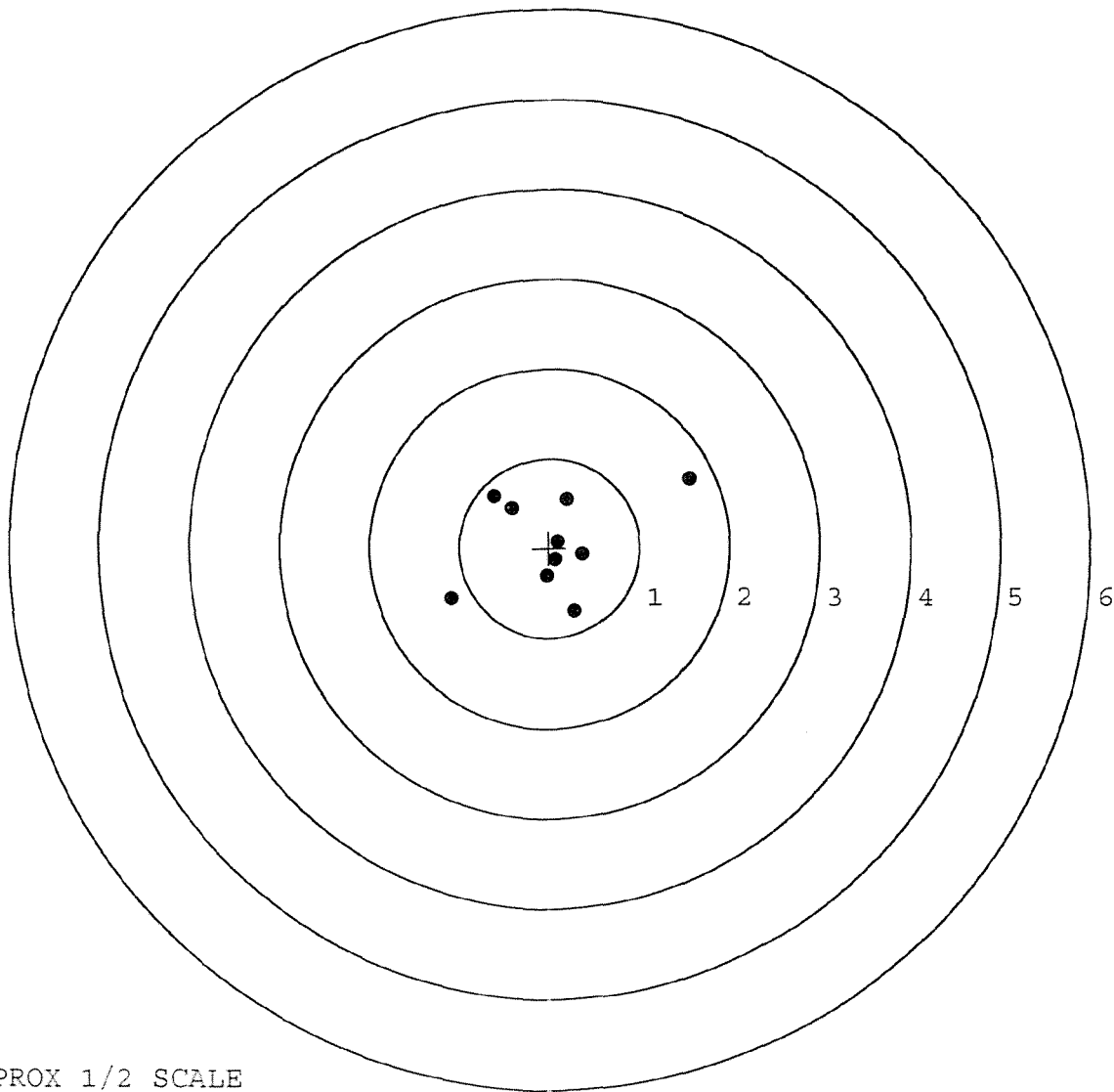
MAX RADIUS: 1.670

MEAN RADIUS: 0.671

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6611528. __0

TARGET NUMBER: 4

FILE DATE: 11/18/2005

FILE TIME: 14:55

POINT#	X	Y
1:	0.553	-0.163
2:	-1.123	0.896
3:	-0.967	0.576
4:	-0.407	0.464
5:	-0.333	0.280
6:	-0.168	0.130
7:	-0.195	-0.106
8:	0.150	0.064
9:	0.232	-0.118
10:	0.118	-0.286

X CENTROID: -0.214

Y CENTROID: 0.174

POA TO CENTROID: 0.276

HORZ SPREAD: 1.676

VERT SPREAD: 1.182

GROUP SPREAD: 1.983

MIN RADIUS: 0.063

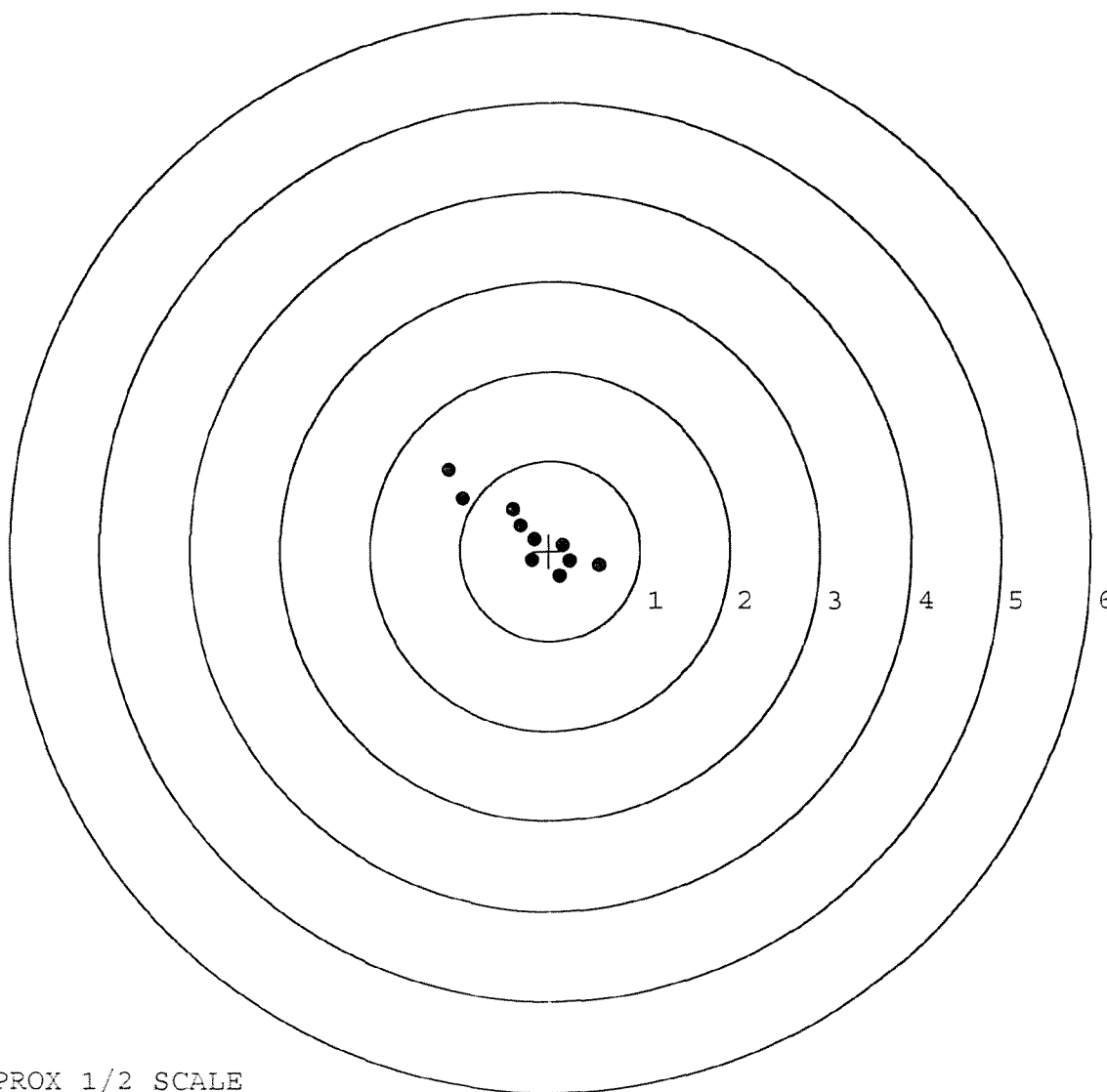
MAX RADIUS: 1.161

MEAN RADIUS: 0.518

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6611528. 0

TARGET NUMBER: 5

FILE DATE: 11/18/2005

FILE TIME: 14:55

POINT#	X	Y
1:	1.017	0.499
2:	0.209	-0.944
3:	0.275	-0.602
4:	-0.441	-0.525
5:	-1.006	0.189
6:	-0.482	0.097
7:	-0.078	0.089
8:	-0.037	0.286
9:	-0.049	0.425
10:	-0.185	0.735

X CENTROID: -0.078

Y CENTROID: 0.025

POA TO CENTROID: 0.082

HORZ SPREAD: 2.023

VERT SPREAD: 1.679

GROUP SPREAD: 2.047

MIN RADIUS: 0.064

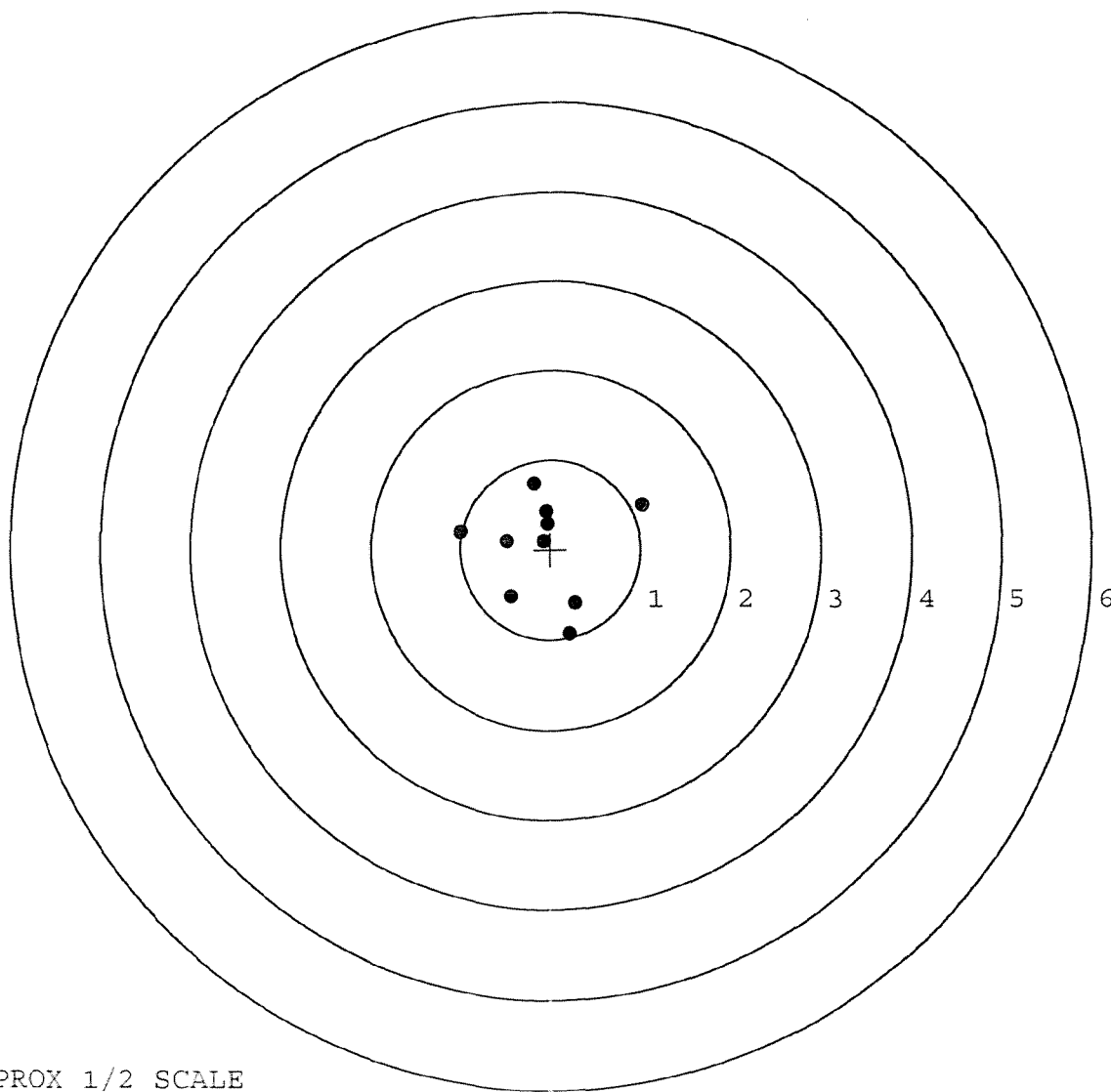
MAX RADIUS: 1.193

MEAN RADIUS: 0.638

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10



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 11-7-05

TESTER R.P.

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.48	2.42		2.65	
PULL #2	2.58	2.51		2.64	
PULL #3	2.57	2.39		2.65	
PULL #4	2.48	2.48		2.59	
PULL #5	2.49	2.52		2.42	
TOTAL	12.60	12.32		12.95	
AVERAGE	2.52	2.46		2.59	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.10	2.89		
PULL #2	3.10	2.93		
PULL #3	3.01	3.12		
PULL #4	3.11	3.13		
PULL #5	3.07	3.17		
TOTAL	15.39	15.24		
AVERAGE	3.07	3.04		

	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	4.12	4.01		4.08
PULL #2	4.08	3.80		4.11
PULL #3	4.09	3.79		4.10
PULL #4	4.10	4.09		4.12
PULL #5	4.11	4.07		4.09
TOTAL	20.50	19.76		20.50
AVERAGE	4.10	3.95		4.10

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

R & E NUMBER	103097			
SERIAL NUMBER	C6011528			
LOG-IN DATE	11-18-05			
OPERATION #	OPERATION NAME		DATE	INITIAL
500	DIS-ASSEMBLE GUN		11-7-05	RTL
505	RE-BARREL		11-9-05	RTL
560	ASSEMBLE		11-9-05	CD
600	PROOF	MAGNA-FLUX INSPECTED	11-9-05	CD
605	CHECK HEADSPACE		11-9-05	CD
610	DIS-ASSEMBLE GUN		11-9-05	CD
612	MAGNAFLUX	OPERATOR <u>mm</u>	11-10-05	mm
510	DRILL AND TAP		11-10-05	BR
615	ROLLMARK CALIBER		11-10-05	CW
618	ROTO-BLAST		11-14-05	LB
620	APPLY COATINGS		11-15-05	HP
625	FINAL ASSEMBLY		11-16-05	RTL
640	FUNCTION TEST AND	PASS FAIL	11-18-05	TRW
650	TARGET	PASS FAIL	11-18-05	TRW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION	11-18-05	TRW
670	FINAL INSPECTION			
	A) HEADSPACE	PASS FAIL	11-18-05	AK
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	2.36 2.40 2.17 2.19 2.43	AK
680	F) SAFETY ON FORCE	2 LBS MIN 10 LBS	6 lbs 6 lbs 6 lbs	AK 11-18-05
	G) SAFETY OFF FORCE	2 LBS MAX	2 lbs 2 lbs 2 lbs	AK 11-18-05
	I) FIRING PIN INDENT	.020	.022 .022 .022	AK
690	PACK		11-30-05	DA




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

MODEL 700TH H24

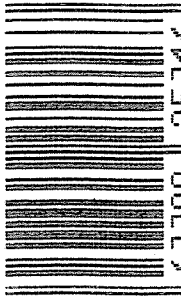
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.

SERIAL NO.
C6611428

ORDER NO.
5716

46

LPC



0 47700 25716 7



5716 C6611428

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C 6611428

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		CC
615	Rollmark Caliber	APR 2 1991		GL
617	Drill and Tap Sight Holes	APR 5 1991		FB
618	Polish Barrel	APR 5 1991		WB
620	Apply Coatings (Barrel Action)		3/10/91	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		4/10/91	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		4/10/91	KS
	C) Inspect Ejector Hole for Chamfer		4/10/91	KS
	D) Oil Firing Pin Ass'y		4/10/91	KS
	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	6	7	7			4-24-91	DH
	G) Safety Off Force	3	3	3			4-24-91	DH
	H) Trigger Pull Test & Retainability						4/15/91	SH
	I) Firing Pin Indent	.021	.020	.022			4/16-91	DH
	J) Assemble Stock						4/24/91	KS
	K) Assemble Swivel Studs						5-1-91	DH
	L) Attach Front and Rear Sight Assemblies						4/24/91	KS
	M) Iron Sight Alignment						4/24/91	KS
	N) Detach Front & Rear Sights & place in numbered container						4/24/91	KS
	O) Attach Scope to Rifle						4/24/91	KS
	P) Detach & Attach Scope 20 Times						4/24/91	KS
640	Gallery Target & Test						4-25-91	AC
	A) Time						4-25-91	AC
	B) Malfunctions						4-25-91	AC
	C) Pierced Primers						4-25-91	AC
	D) Optical Clarity of Scope						4-25-91	AC
645	Inspect for Live Ammo						4-25-91	AC
655	Final Inspection							
	A) Headspace						5-1-91	DH
	B) Trigger Pull	2.60	2.55	2.58	2.58	2.60	4/24/91	SH
	C) Function						5-1-91	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. C6611428

DATE 4/15/91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.21	2.41	2.40	2.50	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.44	2.41	2.43	2.55	
PULL #3	2.44	2.27	2.28	2.58	
PULL #4	2.43	2.41	2.49	2.58	
PULL #5	2.42	2.43	2.44	2.60	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.32	3.29		
PULL #2	3.21	3.27		
PULL #3	3.17	3.31		
PULL #4	3.35	3.31		
PULL #5	3.28	3.30		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.39	4.51		4.15
PULL #2	4.35	4.40		4.39
PULL #3	4.41	4.39		4.36
PULL #4	4.26	4.38		4.36
PULL #5	4.42	4.44		4.36
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611428
25 Apr 1991

CENTROIDAL DISTANCES

0 TO	1	.491506
1 TO	2	.507521
1 TO	3	.484586
1 TO	4	.436479
1 TO	5	.501105

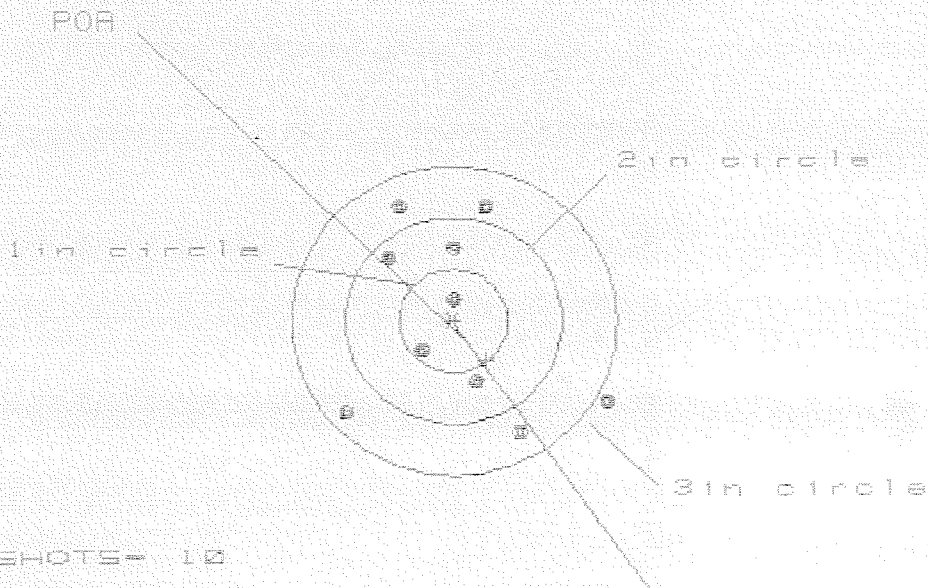
1
948 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1828
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0568
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .191421
THE AMP FOR THIS RIFLE IS: 1.01

25 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/CGB11428

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1 in = 2

2 in = 5

3 in = 8

HS= 2.350

VS= 2.179

GS= 2.686

PATTERN #

1

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.373

.752

.647

MINIMUM X

-.987

-.834

-.598

MAXIMUM Y

1.093

1.001

.884

MINIMUM Y

-1.086

-1.178

-1.295

CENTROID X

-.303

-.456

-.351

CENTROID Y

.387

.479

.596

POA TO CENTROID in.

.491

.661

.692

MIN RADIUS

.180

.217

.103

MEAN RADIUS

.935

.843

.770

MAX RADIUS

1.603

1.397

1.447

HORIZONTAL SPREAD

2.360

1.586

1.245

VERTICAL SPREAD

2.179

2.179

2.179

EXTREME SPREAD

2.686

2.436

2.436

NUMBER IN ONE INCH CIRCLE =

2

NUMBER IN TWO INCH CIRCLE =

5

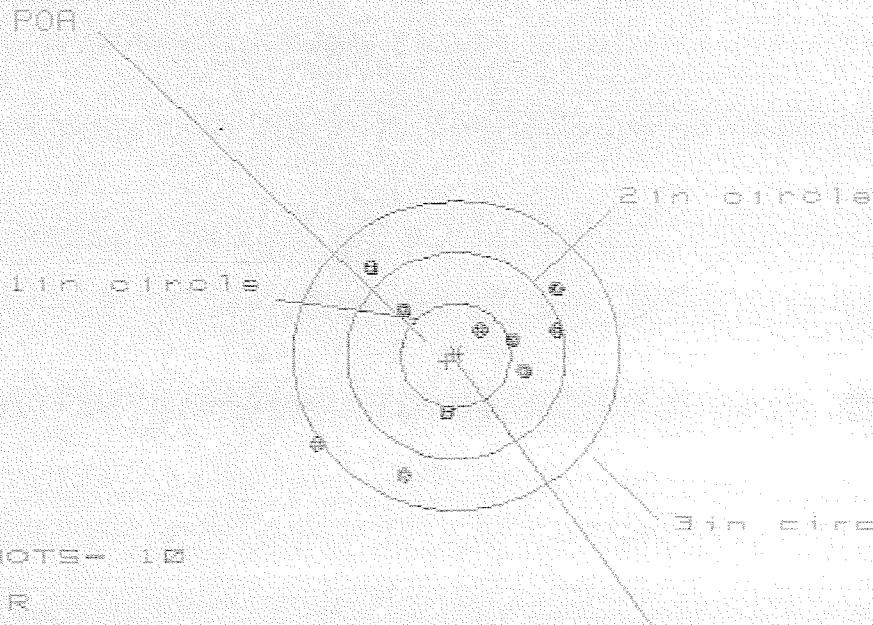
NUMBER IN THREE INCH CIRCLE =

9

25 Apr 1991

FILE: /PATTERNING/CENTERFIRE_PATT/08511428

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in - 1

2 in - 6

3 in - 9

HS- 2.230

VS- 1.990

GS- 2.680

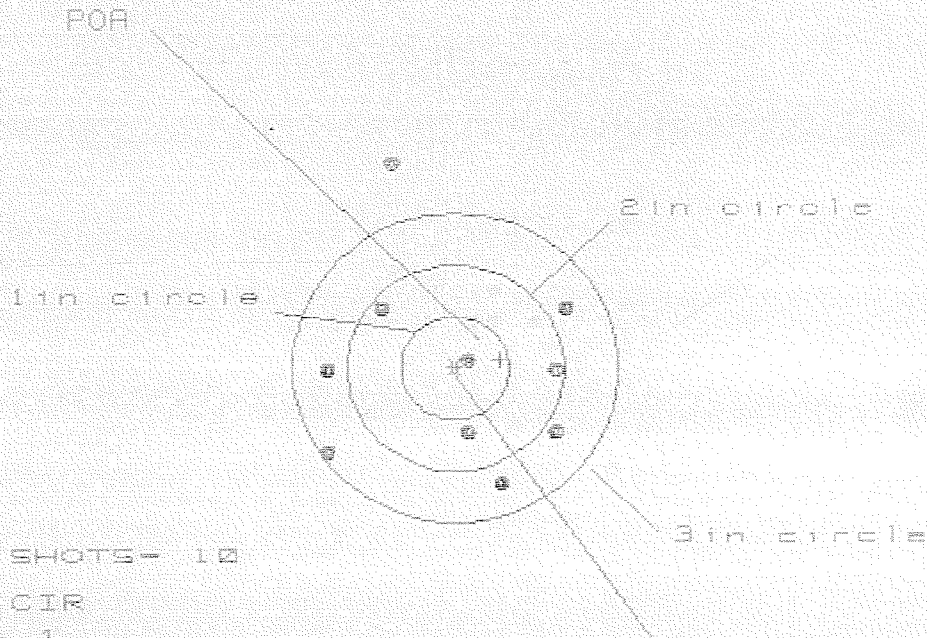
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.926	.781	.699
MINIMUM X	:	-1.304	-.886	-.968
MAXIMUM Y	:	.872	.783	.632
MINIMUM Y	:	-1.118	-1.207	-.750
CENTROID X	:	.080	.225	.307
CENTROID Y	:	.054	.143	.294
POA TO CENTROID in.	:	.096	.266	.425
MIN RADIUS	:	.328	.176	.023
MEAN RADIUS	:	.872	.759	.647
MAX RADIUS	:	1.532	1.373	1.156
HORIZONTAL SPREAD	:	2.230	1.667	1.667
VERTICAL SPREAD	:	1.990	1.990	1.382
EXTREME SPREAD	:	2.680	2.307	1.797
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

25 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611428

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1in = 1

2in = 4

3in = 9

HS= 2.269

VS= 3.118

GS= 3.280

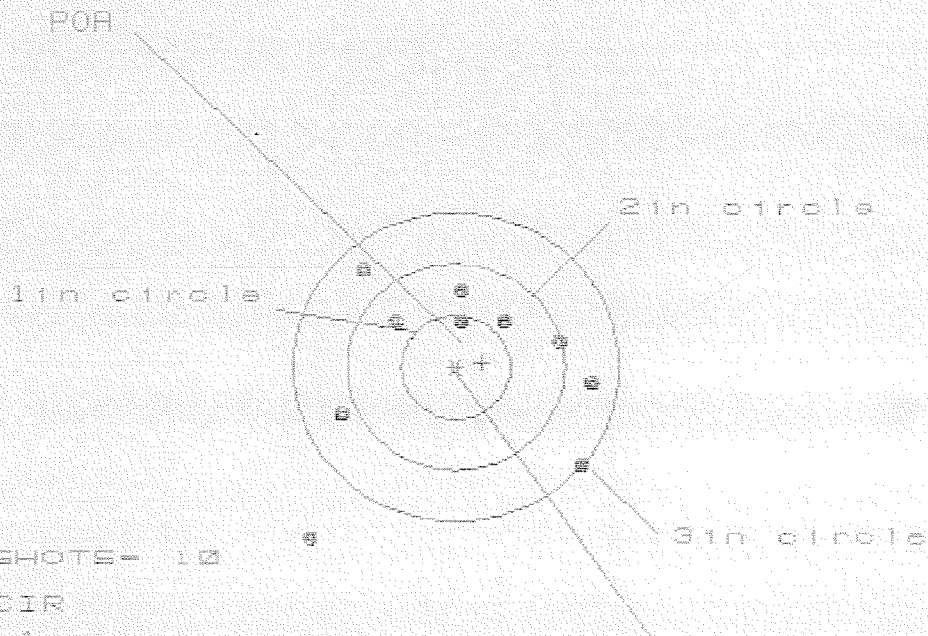
CENTROID *

PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	1.046
MINIMUM X	-1.222
MAXIMUM Y	1.981
MINIMUM Y	-1.137
CENTROID X	-.421
CENTROID Y	-.083
POA TO CENTROID in.	.429
MIN RADIUS	.161
MEAN RADIUS	1.082
MAX RADIUS	2.059
HORIZONTAL SPREAD	2.269
VERTICAL SPREAD	3.118
EXTREME SPREAD	3.280
NUMBER IN ONE INCH CIRCLE =	1
NUMBER IN TWO INCH CIRCLE =	4
NUMBER IN THREE INCH CIRCLE =	9

25 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06611428

CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1in = 1

2in = 4

3in = 9

HS= 2.573

VS= 2.587

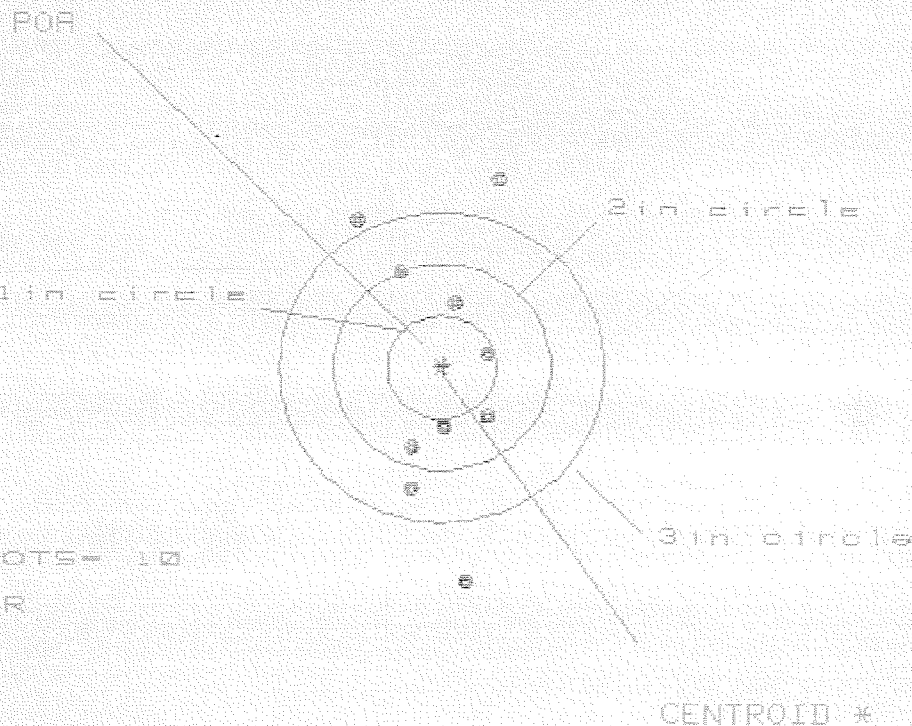
GS= 3.046

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.220	1.069	1.195
MINIMUM X	:	-1.353	-1.214	-1.088
MAXIMUM Y	:	.905	.718	.576
MINIMUM Y	:	-1.682	-1.135	-1.785
CENTROID X	:	-.248	-.097	-.223
CENTROID Y	:	-.046	.141	.283
POA TO CENTROID in.	:	.252	.172	.360
MIN RADIUS	:	.408	.267	.189
MEAN RADIUS	:	1.085	.899	.777
MAX RADIUS	:	2.159	1.515	1.342
HORIZONTAL SPREAD	:	2.573	2.283	2.283
VERTICAL SPREAD	:	2.587	1.853	1.361
EXTREME SPREAD	:	3.046	2.766	2.384
NUMBER IN ONE INCH CIRCLE =			1	
NUMBER IN TWO INCH CIRCLE =			4	
NUMBER IN THREE INCH CIRCLE =			9	

25 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611428

CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 6

3 in = 7

HS= 1.318

VS= 3.846

GS= 3.865

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.562	.582	.531
MINIMUM X	:	-.756	-.736	-.663
MAXIMUM Y	:	1.817	1.591	1.398
MINIMUM Y	:	-2.029	-1.362	-1.163
CENTROID X	:	-.022	-.042	-.115
CENTROID Y	:	-.028	.198	-.001
POB TO CENTROID in.	:	.036	.202	.115
MIN RADIUS	:	.455	.439	.540
MEAN RADIUS	:	1.075	.968	.982
MAX RADIUS	:	2.037	1.694	1.548
HORIZONTAL SPREAD	:	1.318	1.318	1.194
VERTICAL SPREAD	:	3.846	2.953	2.561
EXTREME SPREAD	:	3.865	3.080	2.599
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	6		
NUMBER IN THREE INCH CIRCLE	=	7		