

C6611534

MODEL 700™ M24

Model S&S™

Action

Barrel Length

Capacity

Order No. 5715

*Includes 1 in chamber.



Smead®

Repair Inquiry

Repair Number: RE00120081

Serial: C6611634 Model M24 SWS Center Fire
Caliber: 7.62 NATO Produced: 03/20/1991

Repairman:

Verify Repair

Status:

Closed 11/10/2006 7:41:28 AM

Address Information

Customer:

Received From

Return To:

Received From

Name: SSG MARTINEZ, PAULA

SSG MARTINEZ, PAULA

Address 1: HHC 369 AR

HHC 369 AR

Address 2:

PO Box:

PO Box:

City: FT STEWART

FT STEWART

State: GA

Zip Code: 31313

Country: US

State: GA

Zip Code: 31313

Country: US

FFL:

Contact / Condition

Problems

Estimate

History / Status

Shipping / Billing

Contact Information

Phone: NA

Fax:

Email:

Comments:

Received Condition

Fair

Condition
Notes:CSR
Notes:

Accessories Received

Code	Desc	Qty
A007	With Stud	3
A010	Hard Case	1
A017	Scope Base	1
A026	Scope	1
A055	Deployment Kit	1
A057	Fit and Rear Sgt Base	1

Repair Search

Refresh

Close

nagletj

11/13/2006

7:42 AM

CAPS

NUM

INS

SCRL

start

4 Microsoft Of...

4 Internet Exp...

VAC-DIS-2006

Arms Services R...

7:42 AM

Serial Number: C6611634

Model: M24 SWS



RE00120081

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6611634.___0

FILE DATE AND TIME: 12/06/2006 05:28

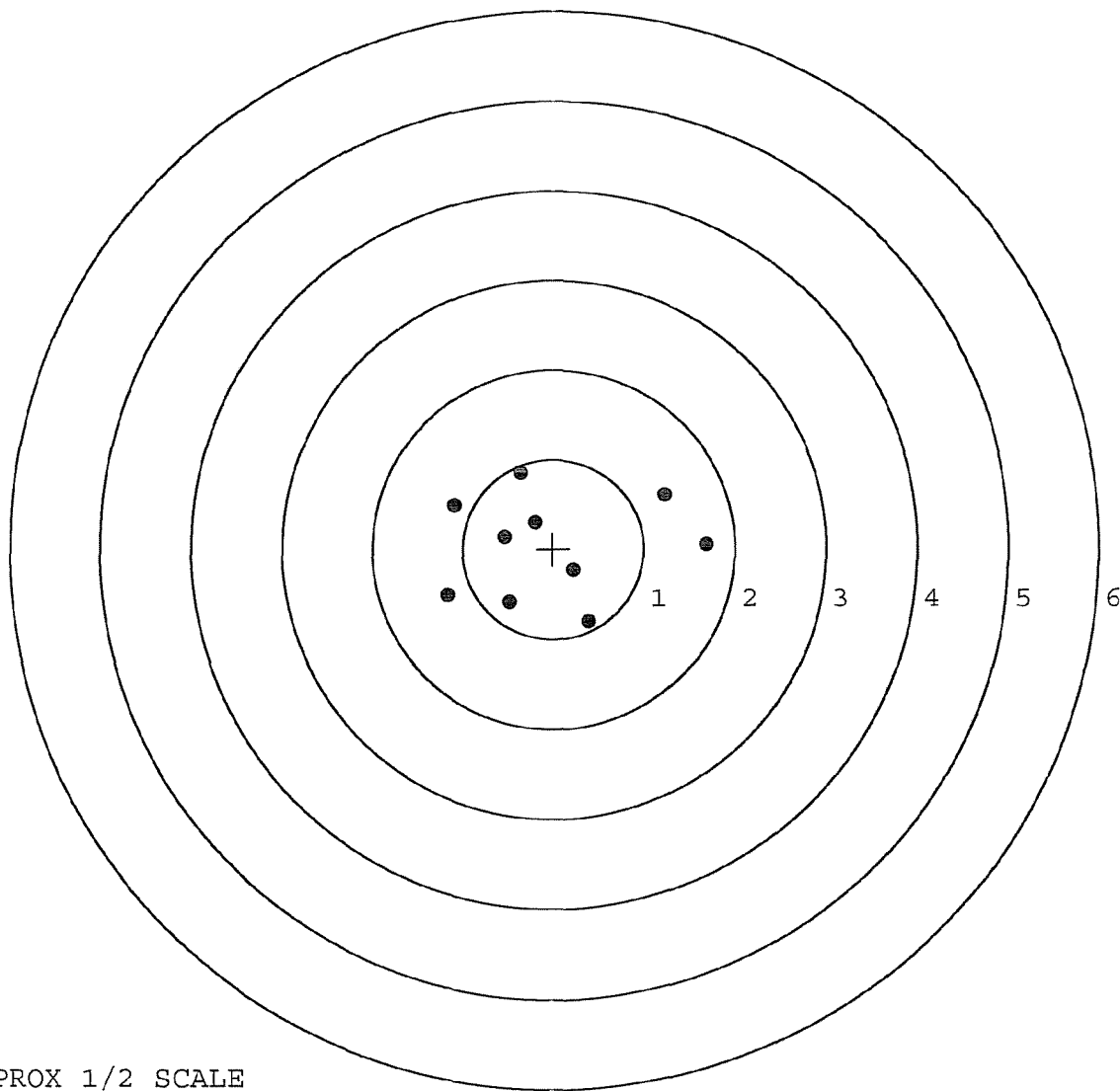
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.052
The Average Y Centroid of the Five Target Set:	0.007
The Average Point of Impact of the Five Target Set:	0.052
The Average Mean Radius of the Five Target Set:	0.735
The Distance from POA to Centroid Target #1:	0.038
The Distance from Centroid Target #2 to Centroid Target #1:	0.023
The Distance from Centroid Target #3 to Centroid Target #1:	0.091
The Distance from Centroid Target #4 to Centroid Target #1:	0.184
The Distance from Centroid Target #5 to Centroid Target #1:	0.007

SERIAL NUMBER: C6611634. __0
TARGET NUMBER: 1
FILE DATE: 12/06/2006
FILE TIME: 05:28

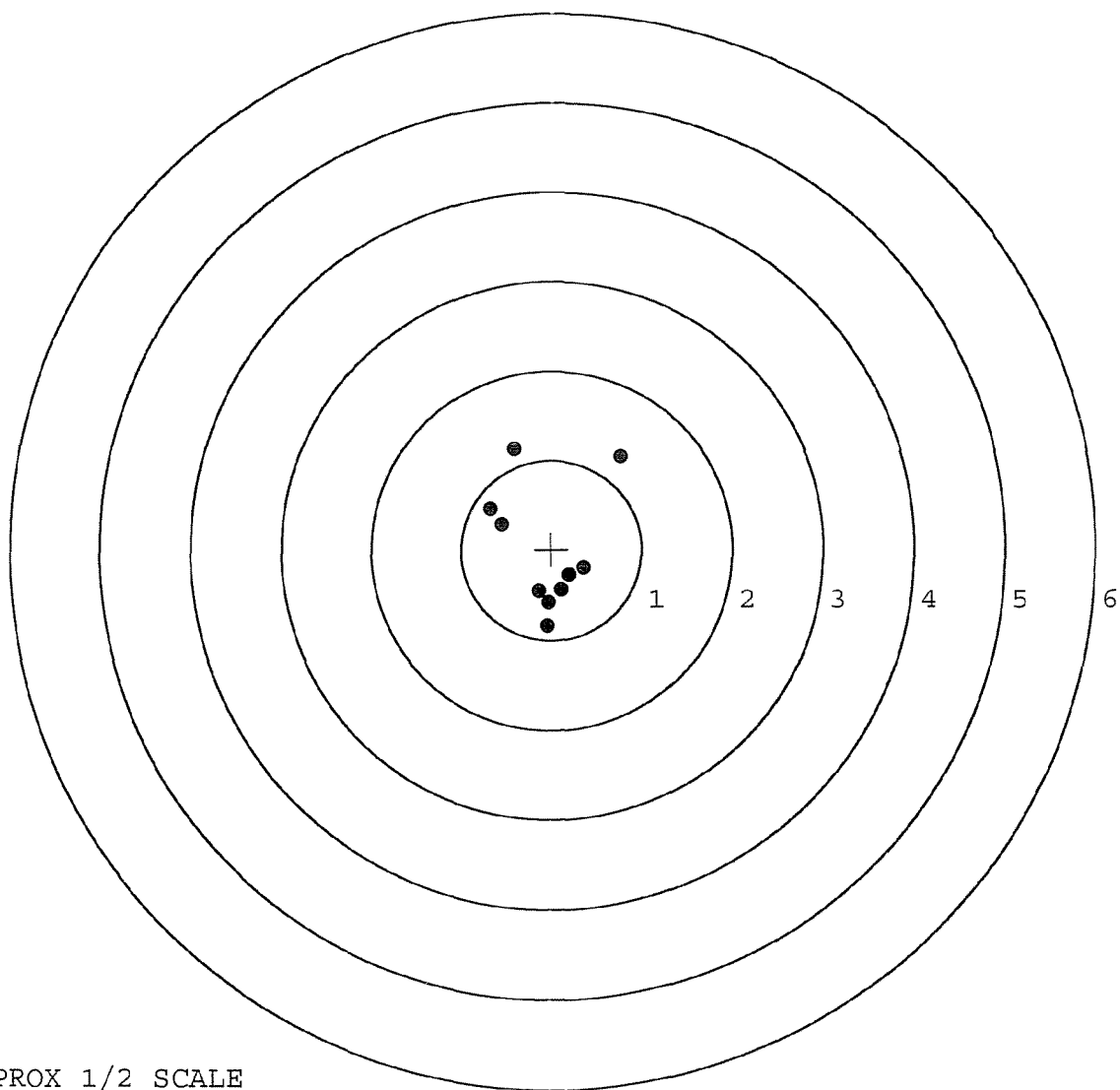
X CENTROID: -0.027
Y CENTROID: 0.027
POA TO CENTROID: 0.038
HORZ SPREAD: 2.849
VERT SPREAD: 1.663
GROUP SPREAD: 2.906
MIN RADIUS: 0.320
MAX RADIUS: 1.711
MEAN RADIUS: 0.932
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 6
in 3 IN DIAMETER: 9

POINT#	X	Y
1:	1.683	0.048
2:	1.231	0.606
3:	0.398	-0.811
4:	0.233	-0.234
5:	-0.477	-0.594
6:	-1.166	-0.526
7:	-0.537	0.137
8:	-0.197	0.298
9:	-0.354	0.852
10:	-1.088	0.489



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6611634. __ 0	POINT#	X	Y
TARGET NUMBER: 2	1:	0.768	1.046
FILE DATE: 12/06/2006	2:	-0.412	1.126
FILE TIME: 05:28	3:	-0.678	0.458
	4:	-0.550	0.281
X CENTROID: -0.040	5:	0.363	-0.206
Y CENTROID: 0.007	6:	0.205	-0.282
POA TO CENTROID: 0.041	7:	0.119	-0.450
HORZ SPREAD: 1.446	8:	-0.137	-0.461
VERT SPREAD: 1.978	9:	-0.046	-0.852
GROUP SPREAD: 2.065	10:	-0.031	-0.587
MIN RADIUS: 0.379			
MAX RADIUS: 1.316			
MEAN RADIUS: 0.711			
# IN 1 IN DIAMETER: 4			
# IN 2 IN DIAMETER: 8			
# in 3 IN DIAMETER: 10			



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6611634. 0

TARGET NUMBER: 3

FILE DATE: 12/06/2006

FILE TIME: 05:28

POINT#	X	Y
1:	0.045	1.151
2:	-0.311	1.143
3:	-0.419	0.861
4:	-0.682	-0.426
5:	-0.420	-0.318
6:	0.043	-0.407
7:	0.492	-0.505
8:	0.541	-0.263
9:	0.065	-0.259
10:	-0.009	0.119

X CENTROID: -0.065

Y CENTROID: 0.110

POA TO CENTROID: 0.128

HORZ SPREAD: 1.223

VERT SPREAD: 1.656

GROUP SPREAD: 1.833

MIN RADIUS: 0.057

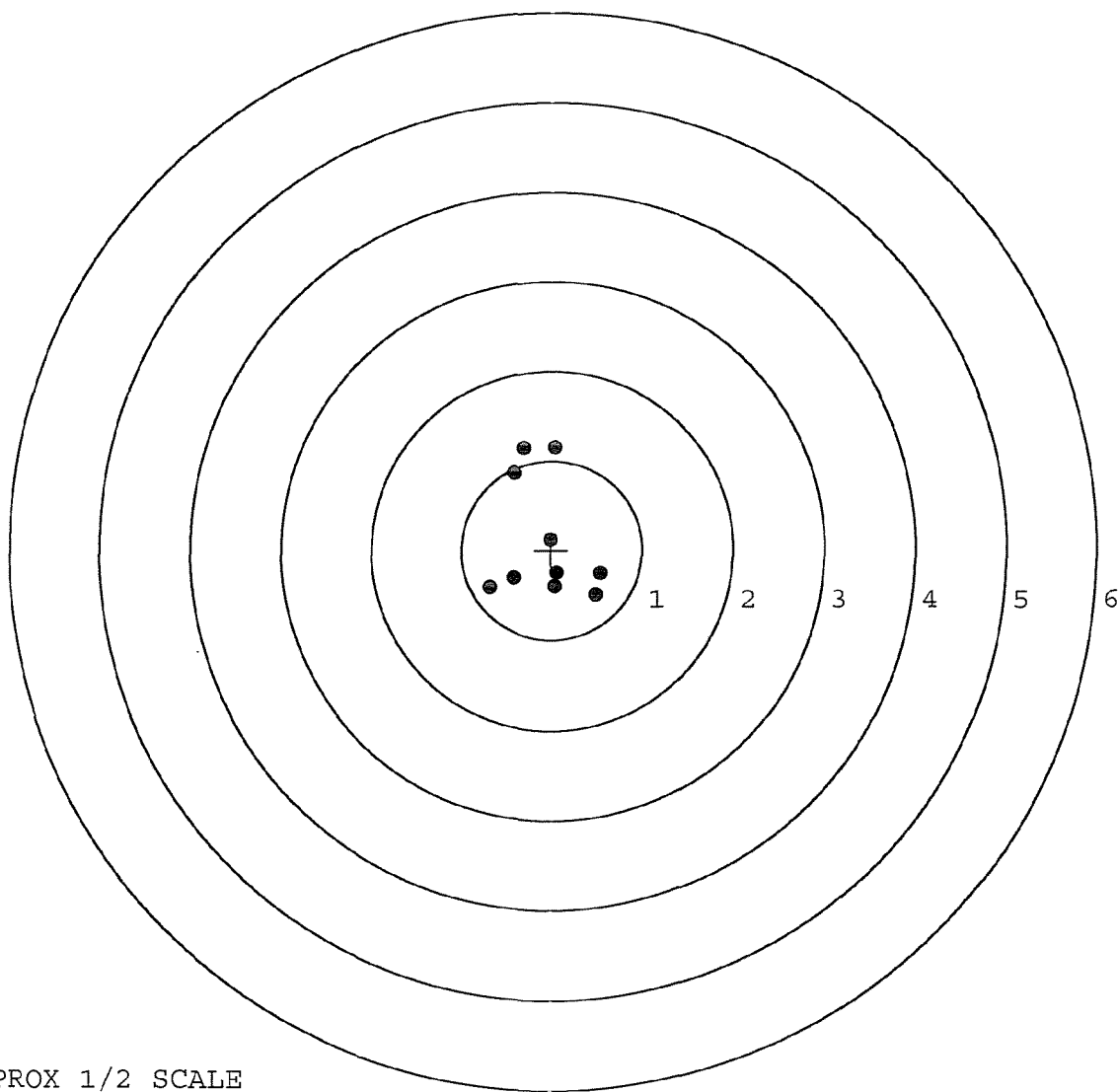
MAX RADIUS: 1.062

MEAN RADIUS: 0.683

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

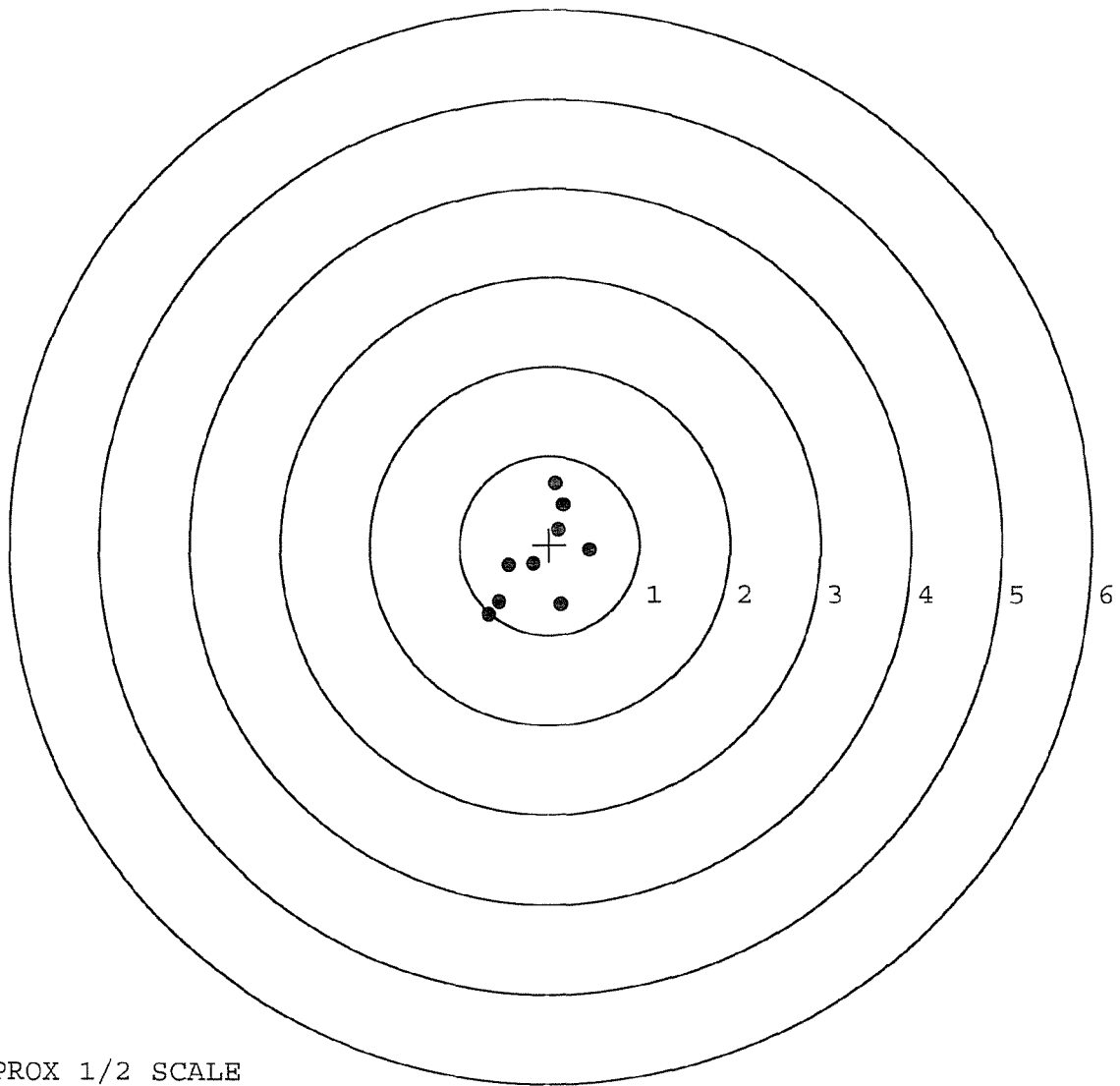
SERIAL NUMBER: C6611634. __0

TARGET NUMBER: 4

FILE DATE: 12/06/2006

FILE TIME: 05:28

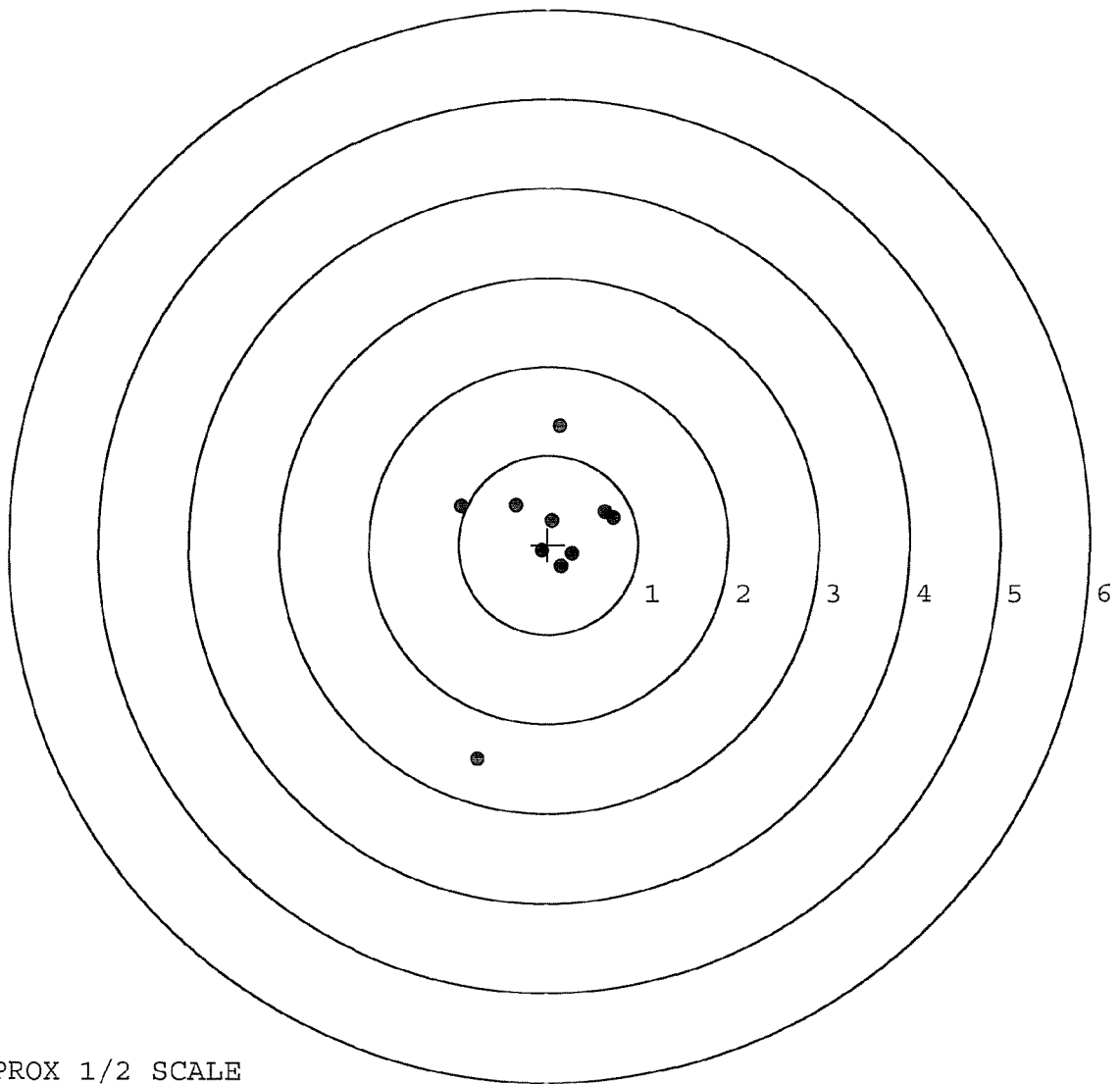
	POINT#	X	Y
	1:	-0.673	-0.779
	2:	-0.554	-0.636
	3:	0.138	-0.661
	4:	0.445	-0.055
	5:	-0.178	-0.218
	6:	-0.450	-0.231
	7:	0.068	0.692
	8:	0.154	0.450
	9:	0.103	0.171
X CENTROID:		-0.105	
Y CENTROID:		-0.141	
POA TO CENTROID:		0.176	
HORZ SPREAD:		1.118	
VERT SPREAD:		1.471	
GROUP SPREAD:		1.647	
MIN RADIUS:		0.106	
MAX RADIUS:		0.854	
MEAN RADIUS:		0.554	
# IN 1 IN DIAMETER:		3	
# IN 2 IN DIAMETER:		9	
# in 3 IN DIAMETER:		9	



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6611634. __0
TARGET NUMBER: 5
FILE DATE: 12/06/2006
FILE TIME: 05:28

	POINT#	X	Y
	1:	0.135	1.328
	2:	-0.972	0.432
	3:	-0.359	0.438
	4:	0.725	0.298
	5:	0.628	0.363
	6:	0.049	0.269
	7:	0.275	-0.105
	8:	0.154	-0.243
	9:	-0.071	-0.072
	10:	-0.784	-2.397
X CENTROID:		-0.022	
Y CENTROID:		0.031	
POA TO CENTROID:		0.038	
HORZ SPREAD:		1.697	
VERT SPREAD:		3.725	
GROUP SPREAD:		3.837	
MIN RADIUS:		0.114	
MAX RADIUS:		2.545	
MEAN RADIUS:		0.795	
# IN 1 IN DIAMETER:		4	
# IN 2 IN DIAMETER:		7	
# in 3 IN DIAMETER:		9	



TARGET APPROX 1/2 SCALE

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

5042

R & E NUMBER	120081			
SERIAL NUMBER	C6611634			
LOG-IN DATE	11-10-06			
OPERATION #	OPERATION NAME		DATE	INITIAL
500	DIS-ASSEMBLE GUN		11-27-06	RTZ
505	RE-BARREL		11-28-06	RTZ
420	ASSEMBLE		11-28-06	RTZ
440	PROOF		11-28-06	TRW
460	CHECK HEADSPACE		11-28-06	TRW
470	DIS-ASSEMBLE GUN		11-28-06	RTZ
480	MAGNAFLUX		11-28-06	TRW
510	DRILL AND TAP			
500	ROLLMARK CALIBER		11-29-06	CW
520	GOFF BLAST BBL / REC			
530 & 540	APPLY COATINGS		12/4/06	TRW
560	FINAL ASSEMBLY		12-4-06	RTZ
640	FUNCTION TEST AND	PASS FAIL	12-5-06	TRW
650	TARGET	PASS FAIL	12-5-06	TRW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
670	FINAL INSPECTION		12-5-06	TRW
	A) HEADSPACE	PASS FAIL	12-6-06	RTZ
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	2.45 2.45 2.45 2.38 2.40	12-6-06 DA
680	F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX	5.0 5.0 4.5	12-6-06 DA
	G) SAFETY OFF FORCE	2 LBS MIN	2.0 2.0 2.0	12-6-06 DA
	I) FIRING PIN INDENT	.020	.023 .023 .023	12-6-06 DA
690	PACK		12-7-06	DA

F006 REV 5/2006

FINAL INSPECTION CHECKLIST

BARREL ASSEMBLY	STOCK ASSEMBLY
_____ BARREL	_____ STOCK
_____ RECEIVER	_____ SLING SWIVEL STUDS
_____ FRONT SIGHT BASE	_____ BUTT PATE
_____ REAR SIGHT BASE	_____ LOCK NUTS
_____ SCREWS	_____ BARREL CLEARANCE
_____ FINISH	_____ COLOR / FINISH
SCOPE ASSEMBLY	SYSTEM CASE
_____ SCOPE	_____ SCOPE CASE
_____ SCOPE RINGS	_____ IRON SIGHTS
_____ MOUNTING SCREWS	_____ DEPLOYMENT KIT
_____ MOUNTING BASE	TRIGGER ASSEMBLY
_____ SCREWS	_____ SAFETY OPERATION
_____ FINISH	_____ RE-SET TO FACTORY SPECS
_____ CLARITY	
COMMENTS: _____	

F006 REV 5/2006



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



REQUEST PATENT OFF

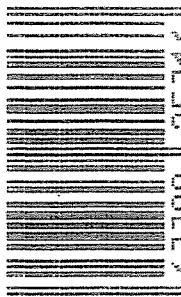
MODEL 700™ H24

SERIAL NO.
C6611634

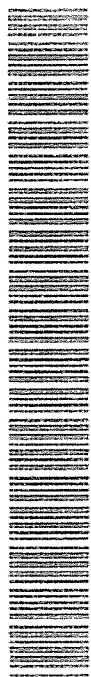
ORDER NO.
5716

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

UPC



0 47700 25746 7



5716 C6611634

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6611634

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		1/15/91	KS
600	Proof		1/15/91	KS
607	Check Headspace		1/15/91	KS
610	Dis-assemble Gun		1/15/91	KS
612	Magnaflux Barrel Action	1 18	91	KR
	Magnaflux Bolt	1 18	91	KR
615	Rollmark Caliber			LS
617	Drill and Tap Sight Holes	1 24	91	CB
618	Polish Barrel	1 24	91	CB
620	Apply Coatings (Barrel Action)		2-15-91	TH
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		3/8/91	KA
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		3/8/91	KA
	C) Inspect Ejector Hole for Chamfer		3/8/91	KA
	D) Oil Firing Pin Ass'y		3/8/91	KA
	E) Adjust Trigger Pull to Min Setting and Stake		3/9/91	KA

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			3/9/91	JK
	G) Safety Off Force	3	3	3			3/9/91	JK
	H) Trigger Pull Test & Retainability						3/9/91	JK
	I) Firing Pin Indent	10225	1022	1022			3/9/91	JK
	J) Assemble Stock						3/9/91	JK
	K) Assemble Swivel Studs						3/12/91	JK
	L) Attach Front and Rear Sight Assemblies						3/9/91	JK
	M) Iron Sight Alignment						3/9/91	JK
	N) Detach Front & Rear Sights & place in numbered container						3/9/91	JK
	O) Attach Scope to Rifle						3/9/91	JK
	P) Detach & Attach Scope 20 Times						3/9/91	JK
640	Gallery Target & Test						3/11/91	JK
	A) Time							JK
	B) Malfunctions							JK
	C) Pierced Primers							JK
	D) Optical Clarity of Scope							JK
645	Inspect for Live Ammo						3/11/91	JK
655	Final Inspection							
	A) Headspace						3/12/91	JK
	B) Trigger Pull	2.53	2.48	2.45	2.47	2.47	3/12/91	JK
	C) Function						3/12/91	JK
660	Pack						3-19-91	JK

SWS TRIGGER PULL TEST

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

SERIAL NO. C16611634

DATE 3-4-91

TESTER JU.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.53	2.41	2.42	2.53	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.52	2.25	2.33	2.48	
PULL #3	2.55	2.32	2.38	2.45	
PULL #4	2.53	2.34	2.36	2.47	
PULL #5	2.51	2.33	2.26	2.47	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.31	3.32		
PULL #2	3.35	3.34		
PULL #3	3.31	3.34		
PULL #4	3.32	3.30		
PULL #5	3.33	3.36		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.36	4.30		4.37
PULL #2	4.32	4.33		4.36
PULL #3	4.30	4.29		4.37
PULL #4	4.28	4.30		4.37
PULL #5	4.	4.35		4.37
TOTAL				
AVG.				

ENVELOIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611634
11 Mar 1991

CENTROIDAL DISTANCES

0 TO	1	.14151
1 TO	2	.244951
1 TO	3	.308058
1 TO	4	.197091
1 TO	5	.161447

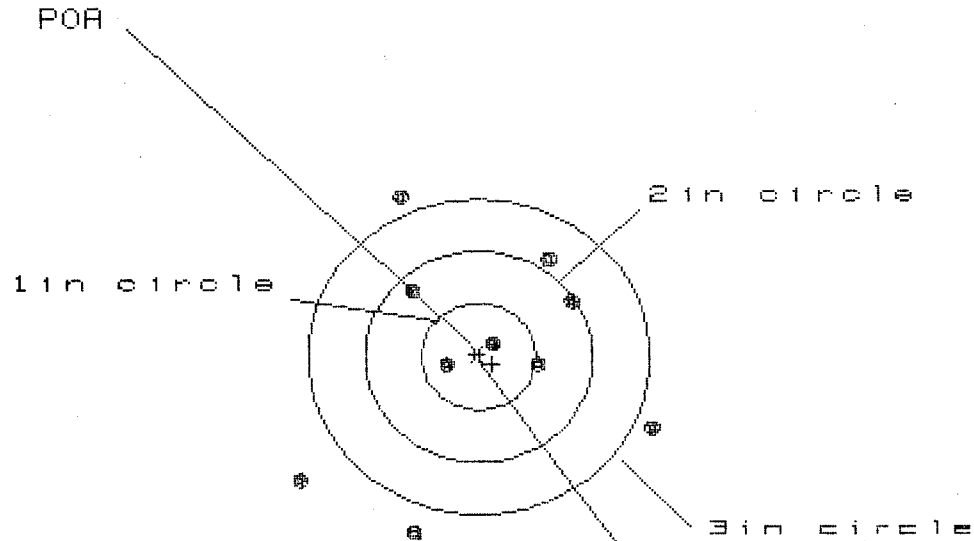
10 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0534
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0518
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0743962
THE AMP FOR THIS RIFLE IS: .9674

11 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611634

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 5

3 in = 6

HS= 3.082

VS= 3.197

GS= 3.197

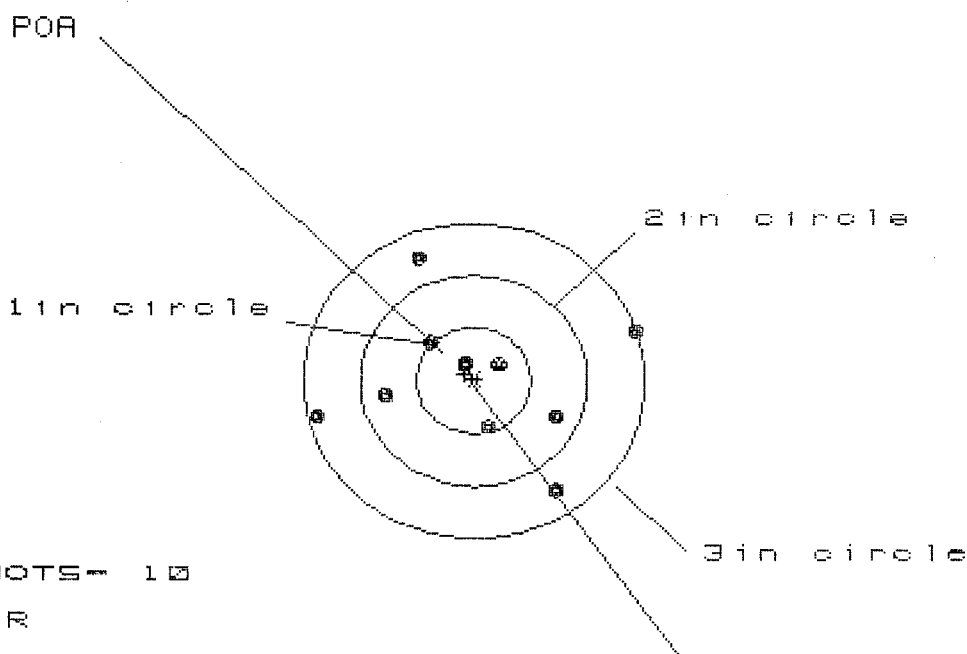
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.532	1.360	1.265
MINIMUM X	-1.550	-.809	-.904
MAXIMUM Y	1.537	1.407	1.183
MINIMUM Y	-1.660	-1.790	-.990
CENTROID X	-.120	.052	.147
CENTROID Y	.075	.205	.429
POA TO CENTROID in.	.141	.211	.453
MIN RADIUS	.140	.088	.303
MEAN RADIUS	1.086	.958	.835
MAX RADIUS	1.942	1.945	1.606
HORIZONTAL SPREAD	3.082	2.169	2.169
VERTICAL SPREAD	3.197	3.197	2.173
EXTREME SPREAD	3.197	3.197	3.070
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	6		

11 Mar 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611634

CENTERFIRE PATTERNS # 2



OF SHOTS - 10

IN CIR

1in = 4

2in = 6

3in = 10

HS = 2.765

VS = 2.252

GS = 2.867

CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.371	.895	.739
MINIMUM X	:	-1.394	-1.241	-.833
MAXIMUM Y	:	1.200	1.251	1.220
MINIMUM Y	:	-1.052	-1.001	-1.032
CENTROID X	:	.081	-.072	.084
CENTROID Y	:	-.065	-.116	-.085
POA TO CENTROID in.	:	.104	.136	.119
MIN RADIUS	:	.179	.206	.198
MEAN RADIUS	:	.847	.780	.702
MAX RADIUS	:	1.446	1.342	1.299
HORIZONTAL SPREAD	:	2.765	2.136	1.572
VERTICAL SPREAD	:	2.252	2.252	2.252
EXTREME SPREAD	:	2.867	2.545	2.545
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	

11 Mar 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6811634

CENTERFIRE PATTERNS

3

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in - 0

2in - 6

3in - 9

HS= 2.573

VS= 2.394

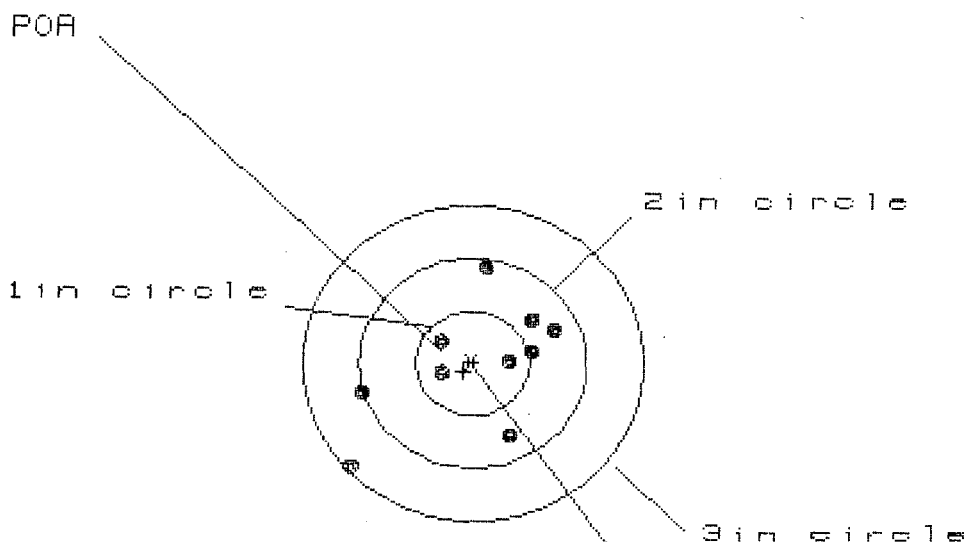
GS= 2.770

PATTERN #	3		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.339	1.202	1.090
MINIMUM X	-1.234	-.991	-1.103
MAXIMUM Y	1.240	1.374	.481
MINIMUM Y	-1.154	-1.020	-.849
CENTROID X	.188	.325	.437
CENTROID Y	.081	-.053	-.224
POA TO CENTROID in.	.205	.330	.492
MIN RADIUS	.530	.377	.250
MEAN RADIUS	1.036	.906	.767
MAX RADIUS	1.722	1.640	1.273
HORIZONTAL SPREAD	2.573	2.193	2.193
VERTICAL SPREAD	2.394	2.394	1.330
EXTREME SPREAD	2.770	2.434	2.434
NUMBER IN ONE INCH CIRCLE =		0	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		9	

11 Mar 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6B11634

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 3

2in = 9

3in = 10

HS= 1.871

VS= 1.870

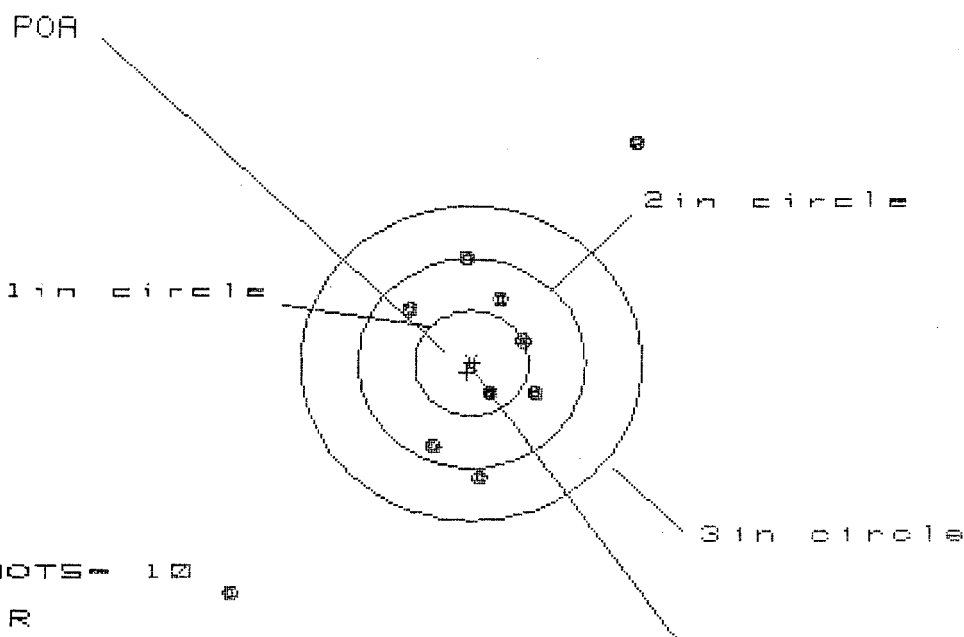
GS= 2.293

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.769	.647	.512
MINIMUM X	:	-1.102	-1.078	-.577
MAXIMUM Y	:	.910	.804	.760
MINIMUM Y	:	-.960	-.827	-.871
CENTROID X	:	.077	.199	.334
CENTROID Y	:	.081	.187	.230
POA TO CENTROID in.	:	.111	.273	.406
MIN RADIUS	:	.307	.258	.196
MEAN RADIUS	:	.721	.614	.524
MAX RADIUS	:	1.461	1.133	.873
HORIZONTAL SPREAD	:	1.871	1.725	1.089
VERTICAL SPREAD	:	1.870	1.631	1.631
EXTREME SPREAD	:	2.293	1.828	1.642
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		9	
NUMBER IN THREE INCH CIRCLE	=		10	

1 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8611634

CENTERFIRE PATTERNS # 5



OF SHOTS - 10

IN CIR

1in - 1

2in - 6

3in - 8

HS - 3.614

VS - 4.291

GS - 5.610

CENTROID #

PATTERN #	5	5	5
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.433	1.191	.448
MINIMUM X	-2.181	-.743	-.594
MAXIMUM Y	2.123	1.882	1.026
MINIMUM Y	-2.168	-1.328	-1.093
CENTROID X	.041	.283	.134
CENTROID Y	.087	.328	.093
POA TO CENTROID in.	.096	.433	.163
MIN RADIUS	.308	.272	.279
MEAN RADIUS	1.147	.902	.713
MAX RADIUS	3.075	2.227	1.093
HORIZONTAL SPREAD	3.614	1.934	1.042
VERTICAL SPREAD	4.291	3.210	2.119
EXTREME SPREAD	5.610	3.478	2.121
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	8		