

G653 5194
Replaced
E 641 3466

Repair Inquiry

Repair Number: RE00111262

Serial: E6413466 Model: M24 SWS Center Fire
Caliber: 7.62 NATO

Repairman:

Status:

Closed 4/19/2006 12:24:16 PM

Address Information

Customer:

Received From:

Return To:

Received From:

Name: TRANSPORTATION DIVISION DFEL

TRANSPORTATION DIVISION DFEL

Address 1: 6759 MITCHELL AVENUE

6759 MITCHELL AVENUE

Address 2: BLDG 1836

PO Box:

BLDG 1836

PO Box:

City: FORT BENNING

FORT BENNING

State: GA

Zip Code: 31905

Country: US

State: GA

Zip Code: 31905

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
A045	Bi Pod	1
B000	FRONT AND REAR E	2

Repair Search

Refresh

Close

naglet

4/20/2006

7:31 AM

CAPS

NUM

INS

SCL



Arms Services Repair ...

7:31 AM

G653 5194 (New)

E6413466

Model: M24 SWS



RE00111262

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6535194.___0
FILE DATE AND TIME: 05/16/2006 16:43

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.020
The Average Y Centroid of the Five Target Set:	-0.003
The Average Point of Impact of the Five Target Set:	0.020
The Average Mean Radius of the Five Target Set:	0.643
The Distance from POA to Centroid Target #1:	0.262
The Distance from Centroid Target #2 to Centroid Target #1:	0.377
The Distance from Centroid Target #3 to Centroid Target #1:	0.409
The Distance from Centroid Target #4 to Centroid Target #1:	0.269
The Distance from Centroid Target #5 to Centroid Target #1:	0.289

SERIAL NUMBER: G6535194. __0

TARGET NUMBER: 1

FILE DATE: 05/16/2006

FILE TIME: 16:43

X CENTROID: 0.232

Y CENTROID: 0.121

POA TO CENTROID: 0.262

HORZ SPREAD: 1.400

VERT SPREAD: 2.588

GROUP SPREAD: 2.615

MIN RADIUS: 0.158

MAX RADIUS: 1.592

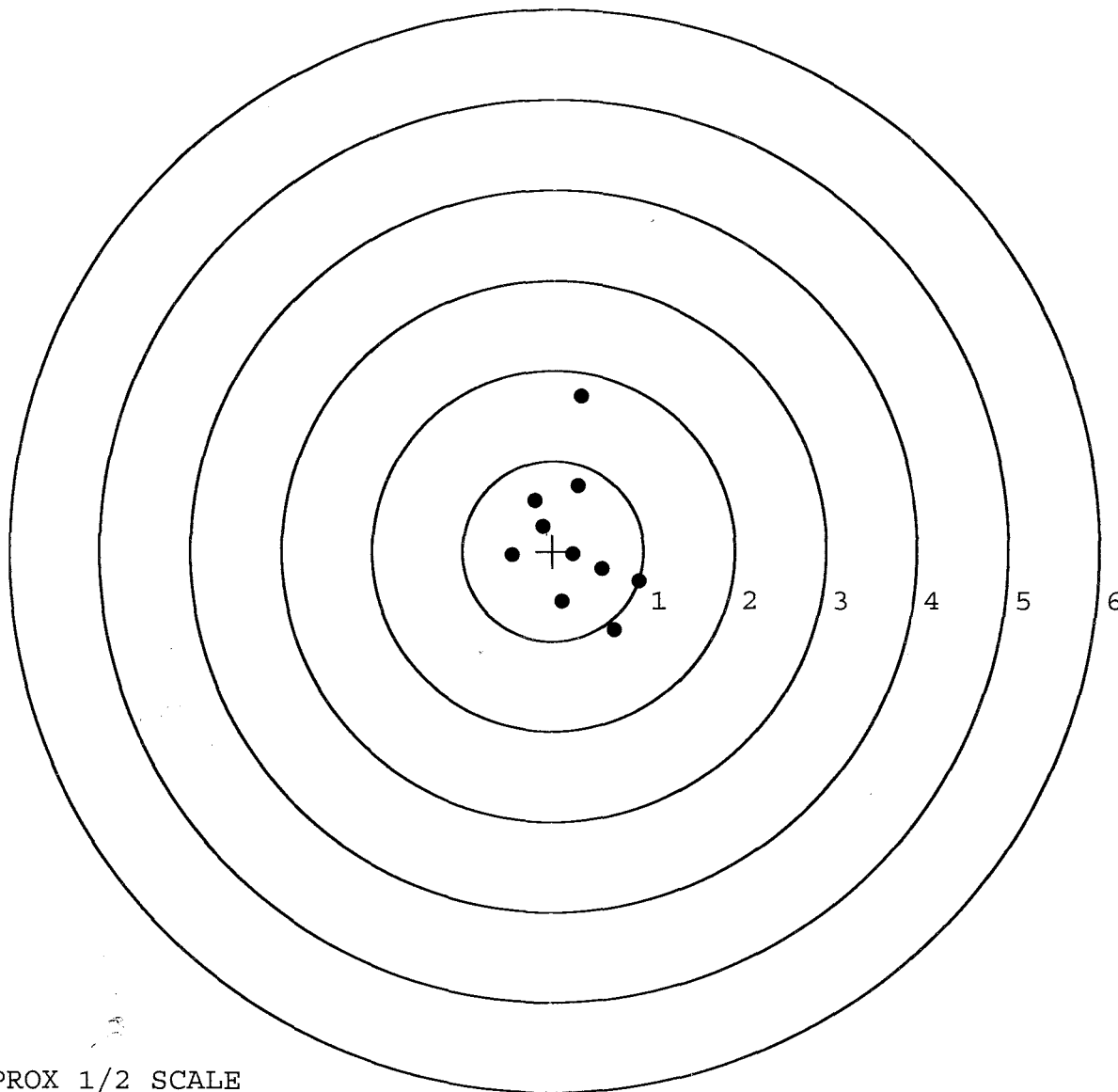
MEAN RADIUS: 0.716

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 9

POINT#	X	Y
1:	-0.206	0.566
2:	-0.118	0.280
3:	-0.451	-0.049
4:	0.277	0.722
5:	0.223	-0.037
6:	0.541	-0.203
7:	0.105	-0.563
8:	0.686	-0.877
9:	0.949	-0.338
10:	0.312	1.711

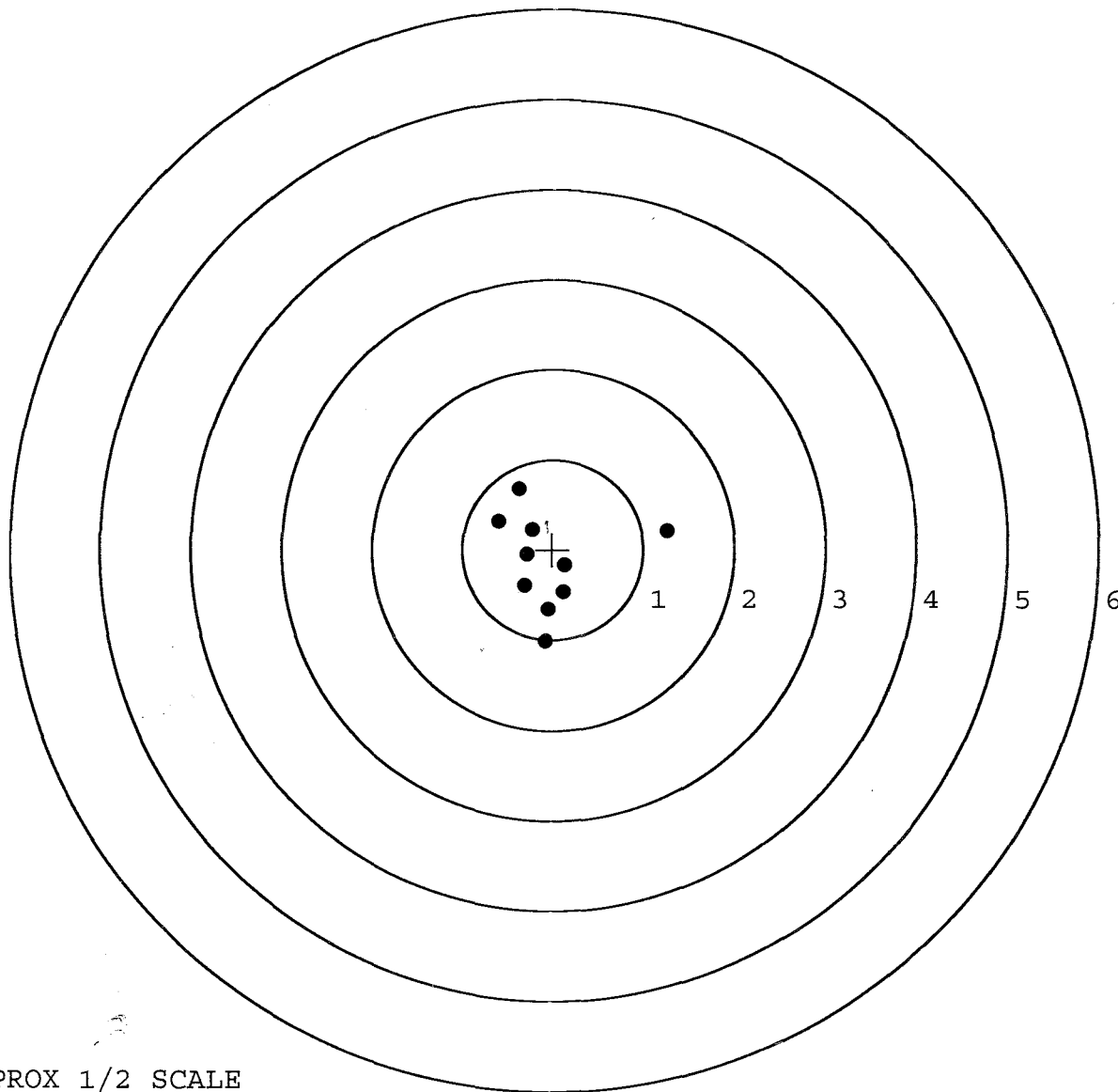


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6535194. __0
TARGET NUMBER: 2
FILE DATE: 05/16/2006
FILE TIME: 16:43

X CENTROID: -0.041
Y CENTROID: -0.139
POA TO CENTROID: 0.145
HORZ SPREAD: 1.860
VERT SPREAD: 1.697
GROUP SPREAD: 1.863
MIN RADIUS: 0.183
MAX RADIUS: 1.344
MEAN RADIUS: 0.596
IN 1 IN DIAMETER: 5
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	1.257	0.212
2:	-0.376	0.675
3:	-0.603	0.316
4:	-0.233	0.221
5:	-0.281	-0.060
6:	-0.307	-0.402
7:	0.138	-0.180
8:	0.125	-0.480
9:	-0.051	-0.670
10:	-0.075	-1.022

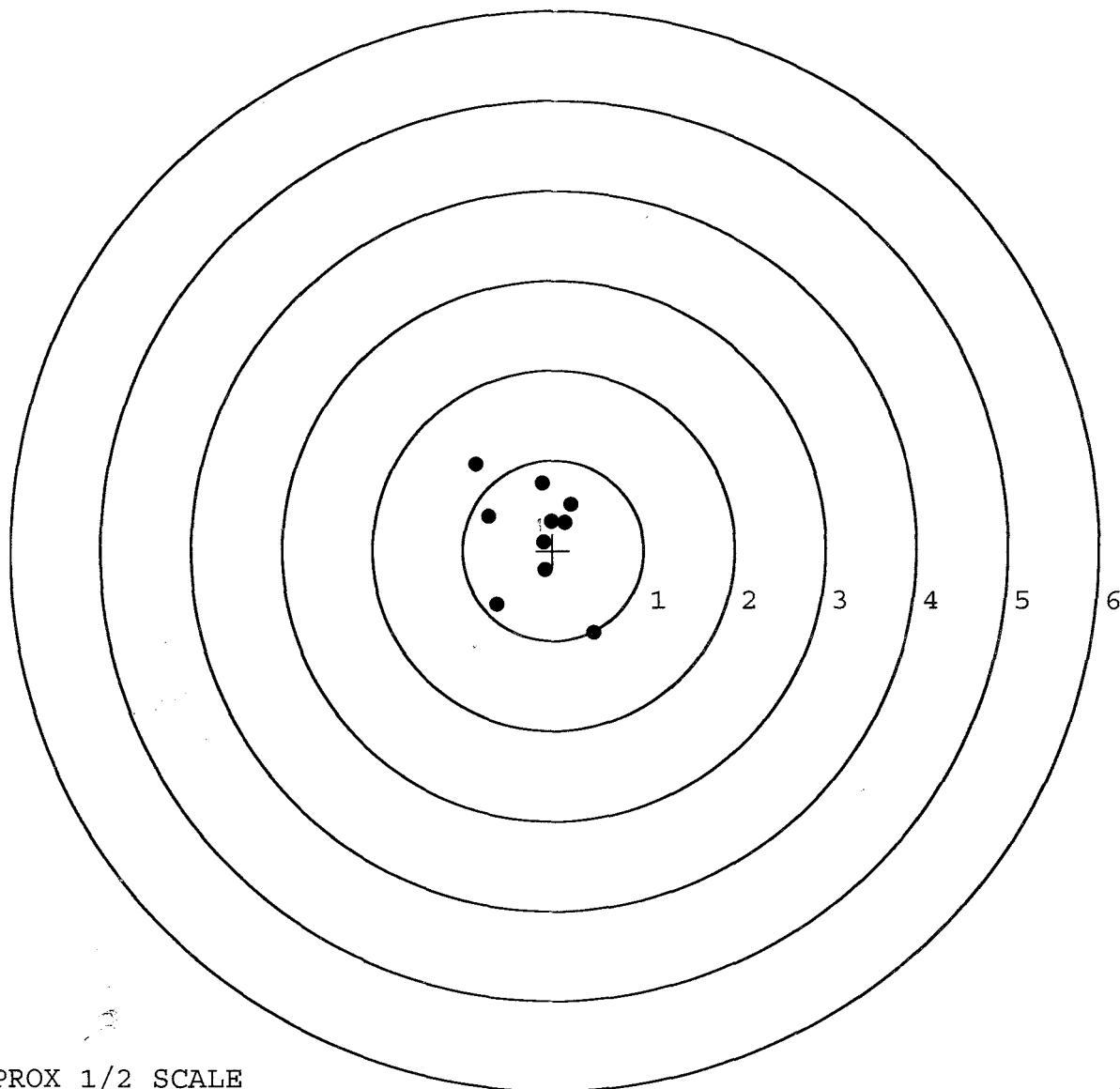


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6535194. __0
TARGET NUMBER: 3
FILE DATE: 05/16/2006
FILE TIME: 16:43

X CENTROID: -0.175
Y CENTROID: 0.158
POA TO CENTROID: 0.236
HORZ SPREAD: 1.321
VERT SPREAD: 1.863
GROUP SPREAD: 2.284
MIN RADIUS: 0.097
MAX RADIUS: 1.243
MEAN RADIUS: 0.589
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.866	0.949
2:	-0.716	0.379
3:	-0.617	-0.600
4:	0.455	-0.914
5:	-0.087	-0.215
6:	-0.100	0.096
7:	-0.023	0.321
8:	0.128	0.309
9:	0.195	0.510
10:	-0.123	0.741

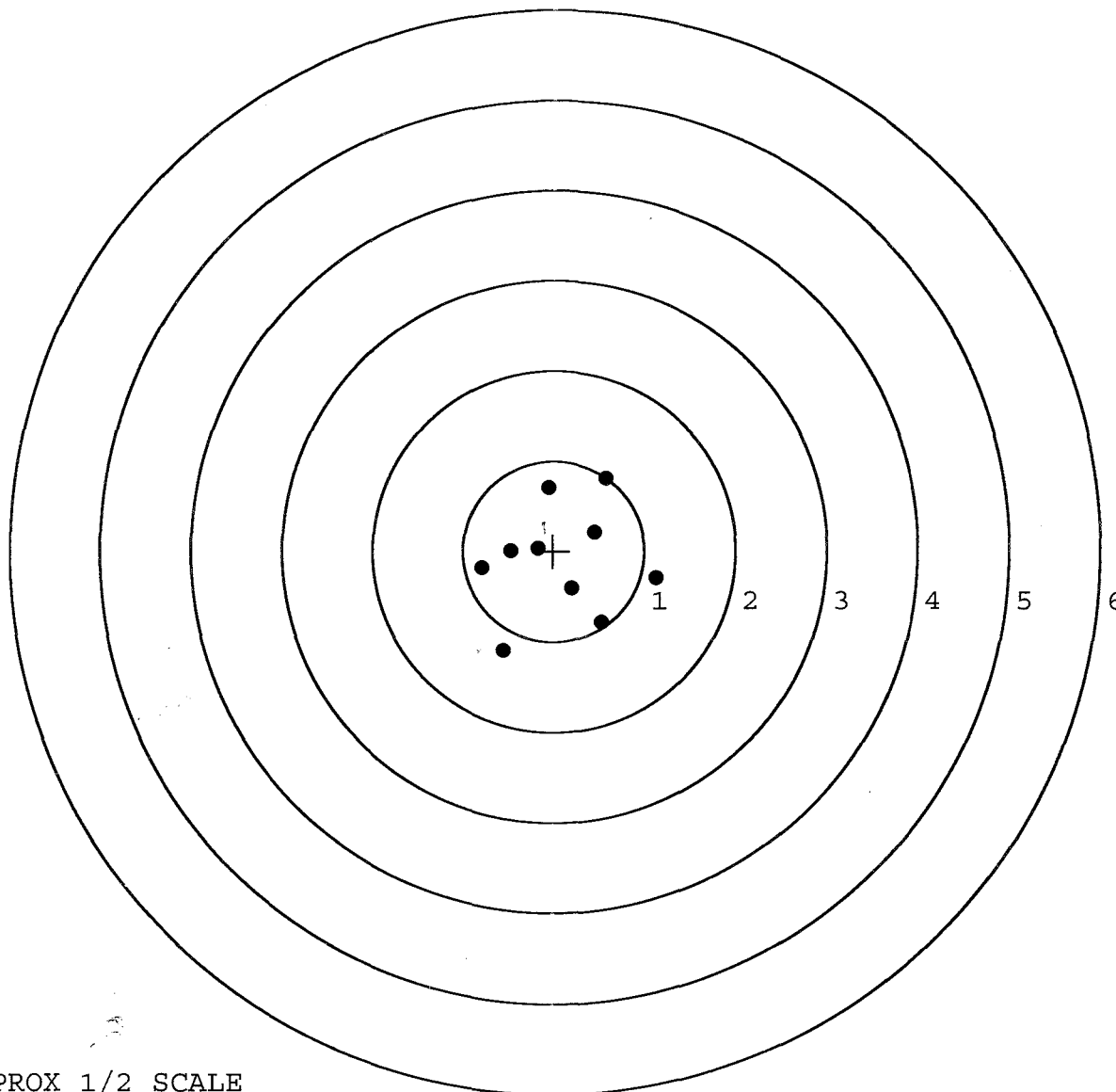


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6535194. __0
TARGET NUMBER: 4
FILE DATE: 05/16/2006
FILE TIME: 16:43

X CENTROID: 0.085
Y CENTROID: -0.104
POA TO CENTROID: 0.134
HORZ SPREAD: 1.919
VERT SPREAD: 1.918
GROUP SPREAD: 2.223
MIN RADIUS: 0.291
MAX RADIUS: 1.185
MEAN RADIUS: 0.748
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.173	0.031
2:	-0.472	0.004
3:	-0.788	-0.188
4:	-0.550	-1.105
5:	0.204	-0.418
6:	0.527	-0.788
7:	1.131	-0.306
8:	0.450	0.211
9:	0.574	0.813
10:	-0.057	0.703



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6535194. __0

TARGET NUMBER: 5

FILE DATE: 05/16/2006

FILE TIME: 16:43

X CENTROID: 0.000

Y CENTROID: -0.050

POA TO CENTROID: 0.051

HORZ SPREAD: 1.547

VERT SPREAD: 1.281

GROUP SPREAD: 1.623

MIN RADIUS: 0.265

MAX RADIUS: 0.936

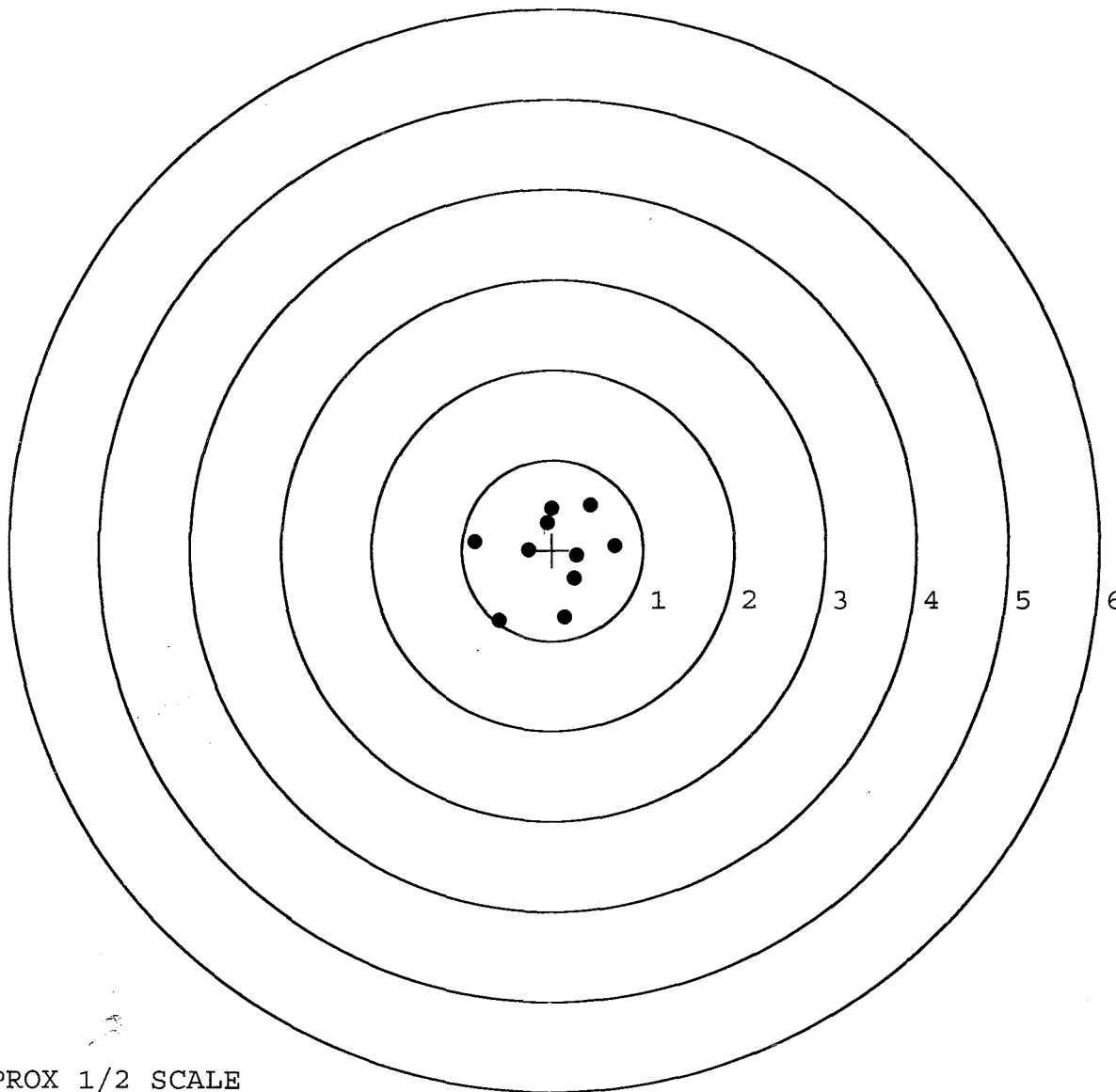
MEAN RADIUS: 0.567

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.014	0.462
2:	0.414	0.498
3:	0.693	0.048
4:	0.273	-0.061
5:	0.246	-0.316
6:	0.146	-0.744
7:	-0.583	-0.783
8:	-0.261	-0.001
9:	-0.854	0.092
10:	-0.063	0.300



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)

DATE 4-21-06

TESTER R.P.

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	246	248		257	
PULL #2	240	244		246	
PULL #3	262	245		243	
PULL #4	248	244		243	
PULL #5	240	255		251	
TOTAL	1236	1236		1240	
AVERAGE	247	247		248	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	308	320		
PULL #2	300	319		
PULL #3	303	307		
PULL #4	307	314		
PULL #5	309	317		
TOTAL	1527	1577		
AVERAGE	305	315		

	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	402	402		420
PULL #2	402	403		423
PULL #3	410	411		410
PULL #4	412	402		402
PULL #5	411	405		414
TOTAL	2037	2023		2069
AVERAGE	407	404		413

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

R & E NUMBER	111262			
SERIAL NUMBER	E6413466		G6535194 (New)	
LOG-IN DATE	4-19-06			
OPERATION #	OPERATION NAME		DATE	INITIAL
500	DIS-ASSEMBLE GUN		5-2-06	RTZ
505	RE-BARREL		5-3-06	RTZ
560	ASSEMBLE		5-3-06	RTZ
600	PROOF	MAGNA-FLUX	5-3-06	MTM
605	CHECK HEADSPACE	INSPECTED	5-3-06	MTM
610	DIS-ASSEMBLE GUN	MAGNA-FLUX		
612	MAGNAFLUX	OPERATOR <u>APD</u>	5-8-06	APD
510	DRILL AND TAP		5-5-06	TRW
615	ROLLMARK CALIBER		5-8-06	CW
618	ROTO-BLAST		5-8-06	LB
620	APPLY COATINGS		5-11-06	RTZ
625	FINAL ASSEMBLY		5-15-06	RTZ
640	FUNCTION TEST AND	<u>PASS</u> FAIL	5-16-06	APD
650	TARGET	<u>PASS</u> FAIL	5-16-06	APD
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
670	FINAL INSPECTION		5-23-06	MTM
	A) HEADSPACE	<u>PASS</u> FAIL	5-23-06	MTM
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	2.88 2.86 2.91 2.91 2.98	APD
680	F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX	8 lbs. 8 lbs. 8 lbs.	MTM
	G) SAFETY OFF FORCE	2 LBS MIN	4 lbs. 4 lbs. 4 lbs.	MTM
	I) FIRING PIN INDENT	.020	.024 .024 .024	MTM
690	PACK		5-24-06	APD

2.50# + .50#
3.00# + .75#
4.00# + 1.00#

DATE 6-4-03

TESTER TRW

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.48	2.70		2.40	MIN. SETTING,
PULL #2	2.60	2.46		2.35	NO AVG. OF 5
PULL #3	2.61	2.56		2.40	READINGS ACCEPT-
PULL #4	2.70	2.62		2.41	ABLE LESS THAN 2
PULL #5	2.59	2.57		2.40	
TOTAL	12.98	12.91		11.96	
AVG.	2.59	2.58		2.39	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.37	3.34		
PULL #2	3.28	3.33		
PULL #3	3.25	3.30		
PULL #4	3.29	3.03		
PULL #5	3.26	3.19		
TOTAL	16.45	16.19		
AVG.	3.29	3.23		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCUR
PULL #1	4.09	4.37		4.46
PULL #2	4.28	4.35		4.45
PULL #3	4.43	4.36		4.49
PULL #4	4.44	4.40		4.02
PULL #5	4.43	4.39		4.40
TOTAL	21.67	21.87		21.82
AVG.	4.33	4.37		4.36

SERIAL # E6413466 INSPECTED BY: RTL

DATE REC'D: 6-2-03 DATE RET'D: 6-26-03

ITEM

BARREL ASSEMBLY

 / BARREL

 / RECEIVER

 / FRONT SIGHT BASE

 / REAR SIGHT BASE

 / SCREWS

 / FINISH

SCOPE ASSEMBLY

 / SCOPE

 / SCOPE RINGS

 / MOUNTING SCREWS

 / MOUNTING BASE

 / SCREWS

 / FINISH

 / CLARITY

ITEM

STOCK ASSEMBLY

 / STOCK

 / SLING AWIVEL STUDS

 / ADJUSTABLE

 / BUTT PLATE

 / LOCK NUTS

 / BARREL CLEARANCE

 / COLOR / FINISH

SYSTEMS CASE

 / SCOPE CASE

 / IRON SIGHTS

 / DEPLOYMENT KIT

TRIGGER ASSEMBLY

 / SAFETY OPERATION

 / RE-SET TO FACTORY SPECS

COMMENTS:

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: E6413466.___0
FILE DATE AND TIME: 06/24/2003 06:55

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.143
The Average Y Centroid of the Five Target Set:	-0.077
The Average Point of Impact of the Five Target Set:	0.162
The Average Mean Radius of the Five Target Set:	0.647
The Distance from POA to Centroid Target #1:	0.087
The Distance from Centroid Target #2 to Centroid Target #1:	0.160
The Distance from Centroid Target #3 to Centroid Target #1:	0.286
The Distance from Centroid Target #4 to Centroid Target #1:	0.368
The Distance from Centroid Target #5 to Centroid Target #1:	0.754

SERIAL NUMBER: E6413466. __0

TARGET NUMBER: 1

FILE DATE: 06/24/2003

FILE TIME: 06:55

X CENTROID: -0.079

Y CENTROID: 0.038

POA TO CENTROID: 0.087

HORZ SPREAD: 1.570

VERT SPREAD: 1.035

GROUP SPREAD: 1.843

MIN RADIUS: 0.354

MAX RADIUS: 0.977

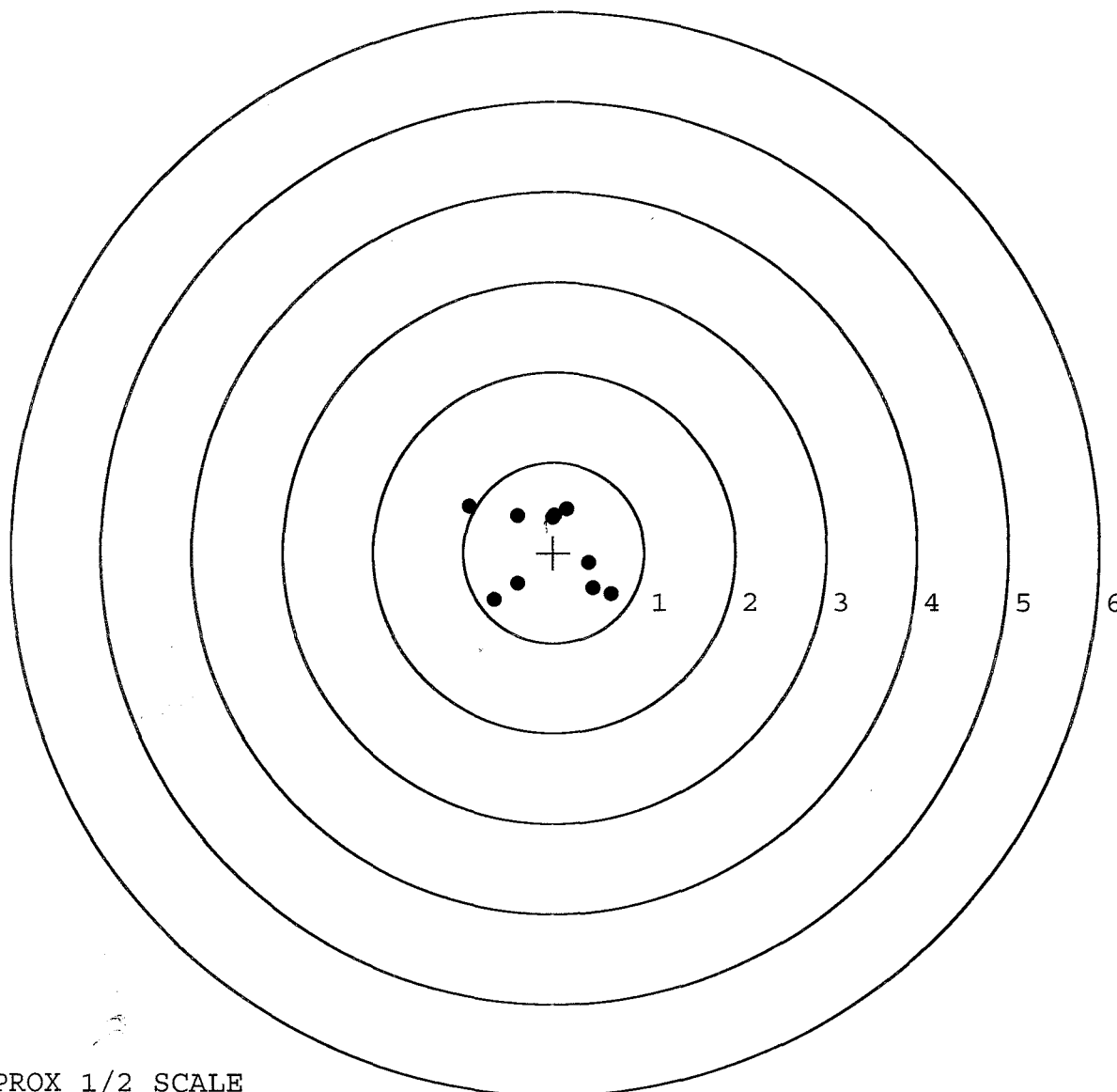
MEAN RADIUS: 0.604

IN 1 IN DIAMETER: 6

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.146	0.483
2:	-0.018	0.387
3:	-0.404	0.409
4:	-0.935	0.509
5:	-0.658	-0.526
6:	-0.394	-0.341
7:	0.393	-0.107
8:	0.437	-0.388
9:	0.635	-0.457
10:	0.012	0.414

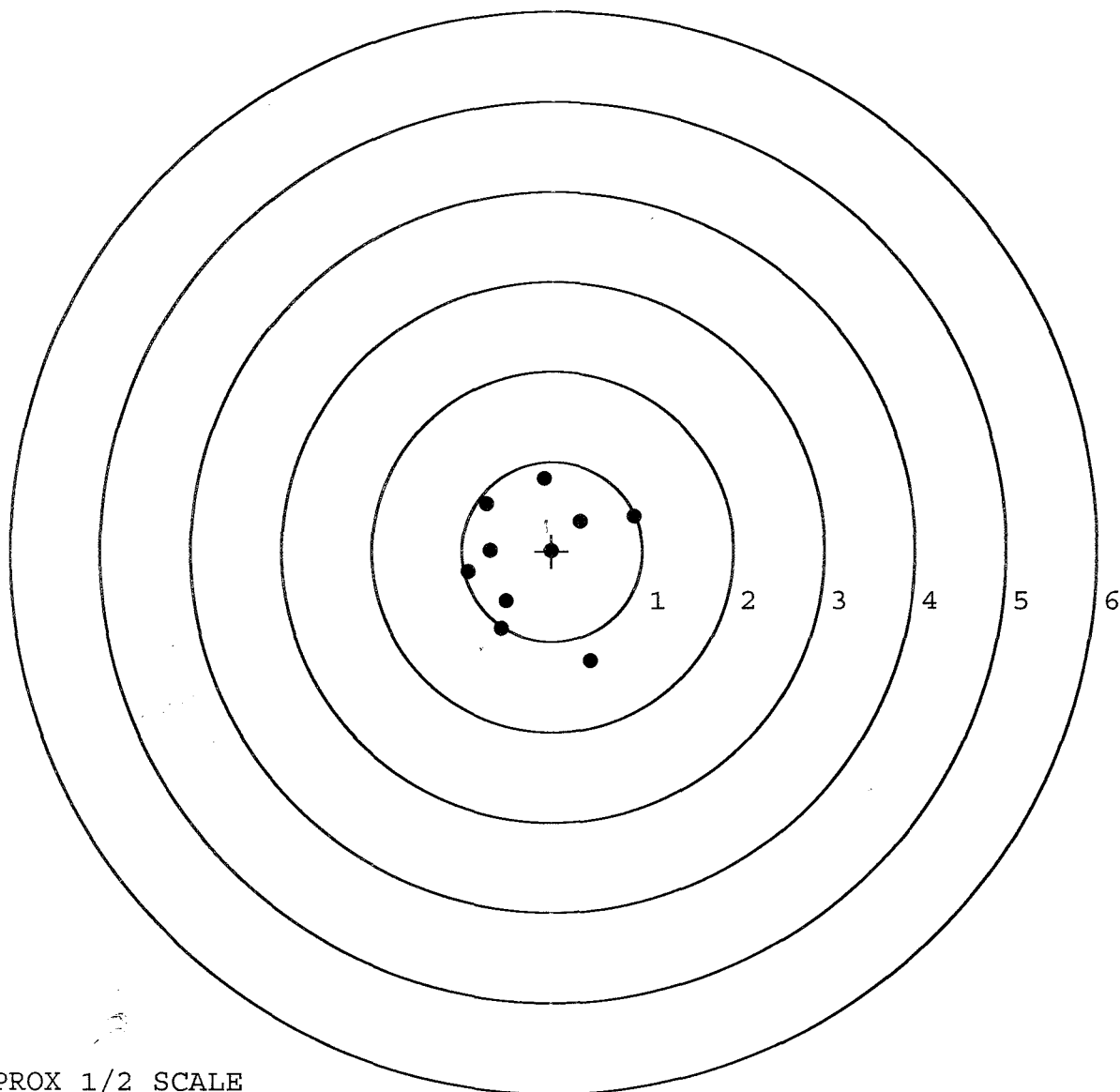


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: E6413466. __0
 TARGET NUMBER: 2
 FILE DATE: 06/24/2003
 FILE TIME: 06:55

X CENTROID: -0.188
 Y CENTROID: -0.080
 POA TO CENTROID: 0.204
 HORZ SPREAD: 1.835
 VERT SPREAD: 2.024
 GROUP SPREAD: 2.095
 MIN RADIUS: 0.193
 MAX RADIUS: 1.293
 MEAN RADIUS: 0.775
 # IN 1 IN DIAMETER: 1
 # IN 2 IN DIAMETER: 8
 # in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.013	0.003
2:	0.904	0.387
3:	0.313	0.339
4:	-0.093	0.810
5:	-0.731	0.528
6:	-0.683	0.010
7:	-0.931	-0.238
8:	-0.562	-0.865
9:	-0.512	-0.556
10:	0.433	-1.214



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: E6413466. 0

TARGET NUMBER: 3

FILE DATE: 06/24/2003

FILE TIME: 06:55

X CENTROID: 0.190

Y CENTROID: -0.062

POA TO CENTROID: 0.200

HORZ SPREAD: 1.729

VERT SPREAD: 0.753

GROUP SPREAD: 1.729

MIN RADIUS: 0.079

MAX RADIUS: 1.025

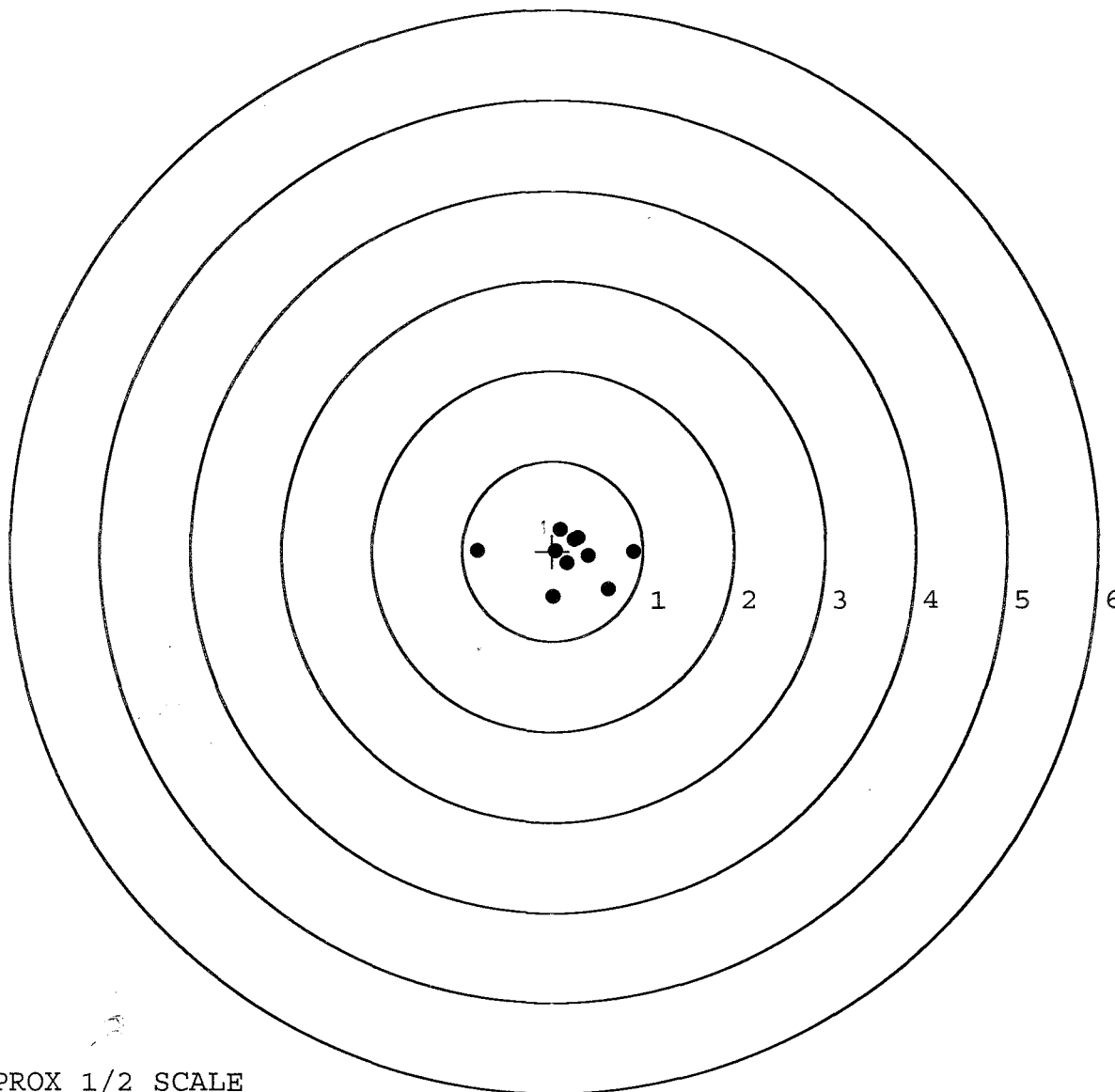
MEAN RADIUS: 0.399

IN 1 IN DIAMETER: 7

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.896	-0.017
2:	0.619	-0.432
3:	0.008	-0.510
4:	-0.833	0.002
5:	0.086	0.243
6:	0.034	0.003
7:	0.166	-0.137
8:	0.394	-0.056
9:	0.246	0.133
10:	0.281	0.151

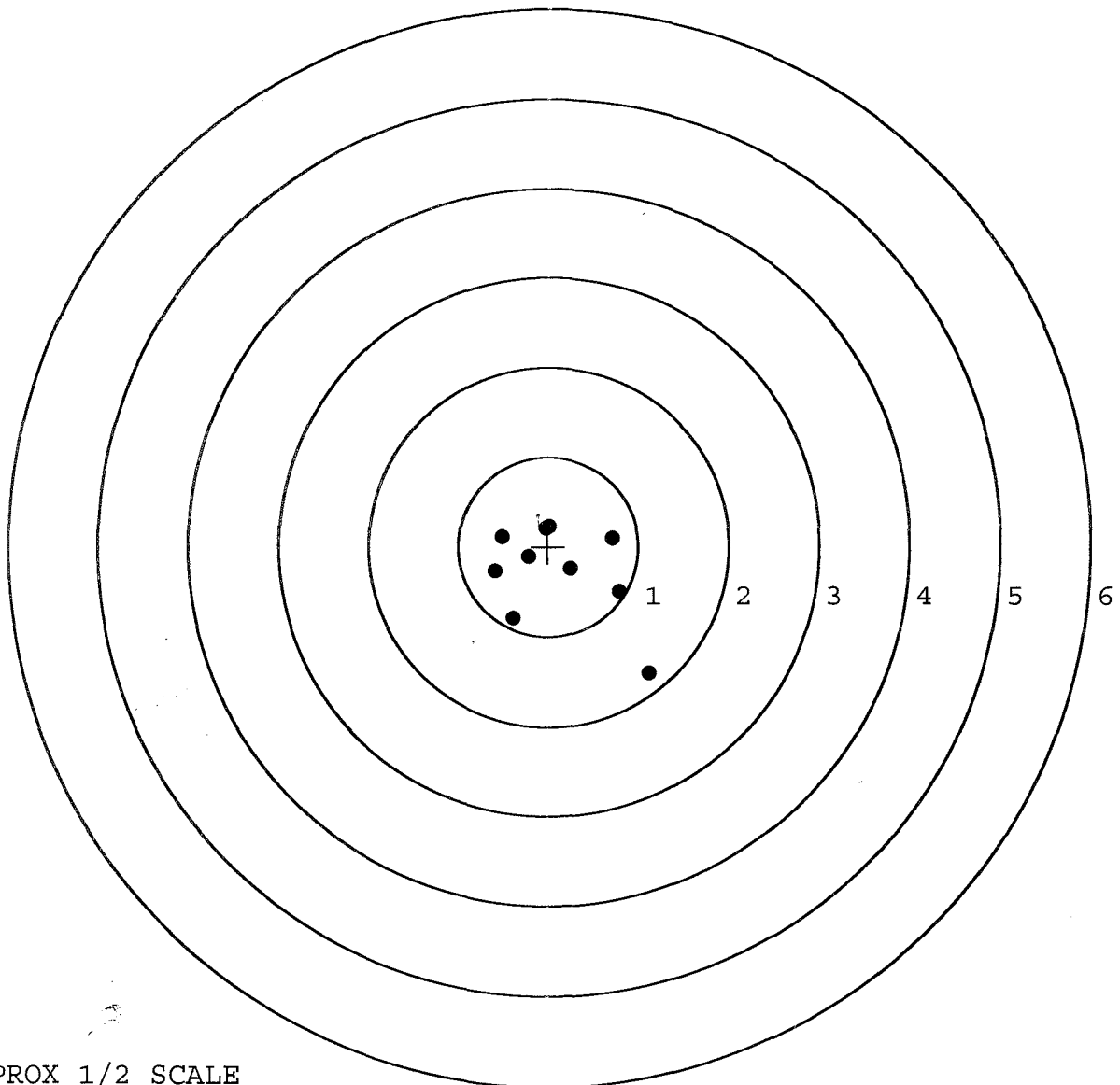


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: E6413466. 0
TARGET NUMBER: 4
FILE DATE: 06/24/2003
FILE TIME: 06:55

X CENTROID: 0.116
Y CENTROID: -0.273
POA TO CENTROID: 0.297
HORZ SPREAD: 1.712
VERT SPREAD: 1.631
GROUP SPREAD: 2.232
MIN RADIUS: 0.135
MAX RADIUS: 1.518
MEAN RADIUS: 0.661
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 9

POINT#	X	Y
1:	-0.217	-0.119
2:	0.018	0.221
3:	-0.513	0.109
4:	-0.589	-0.278
5:	-0.393	-0.802
6:	1.123	-1.410
7:	0.791	-0.502
8:	0.716	0.098
9:	0.250	-0.252
10:	-0.021	0.201

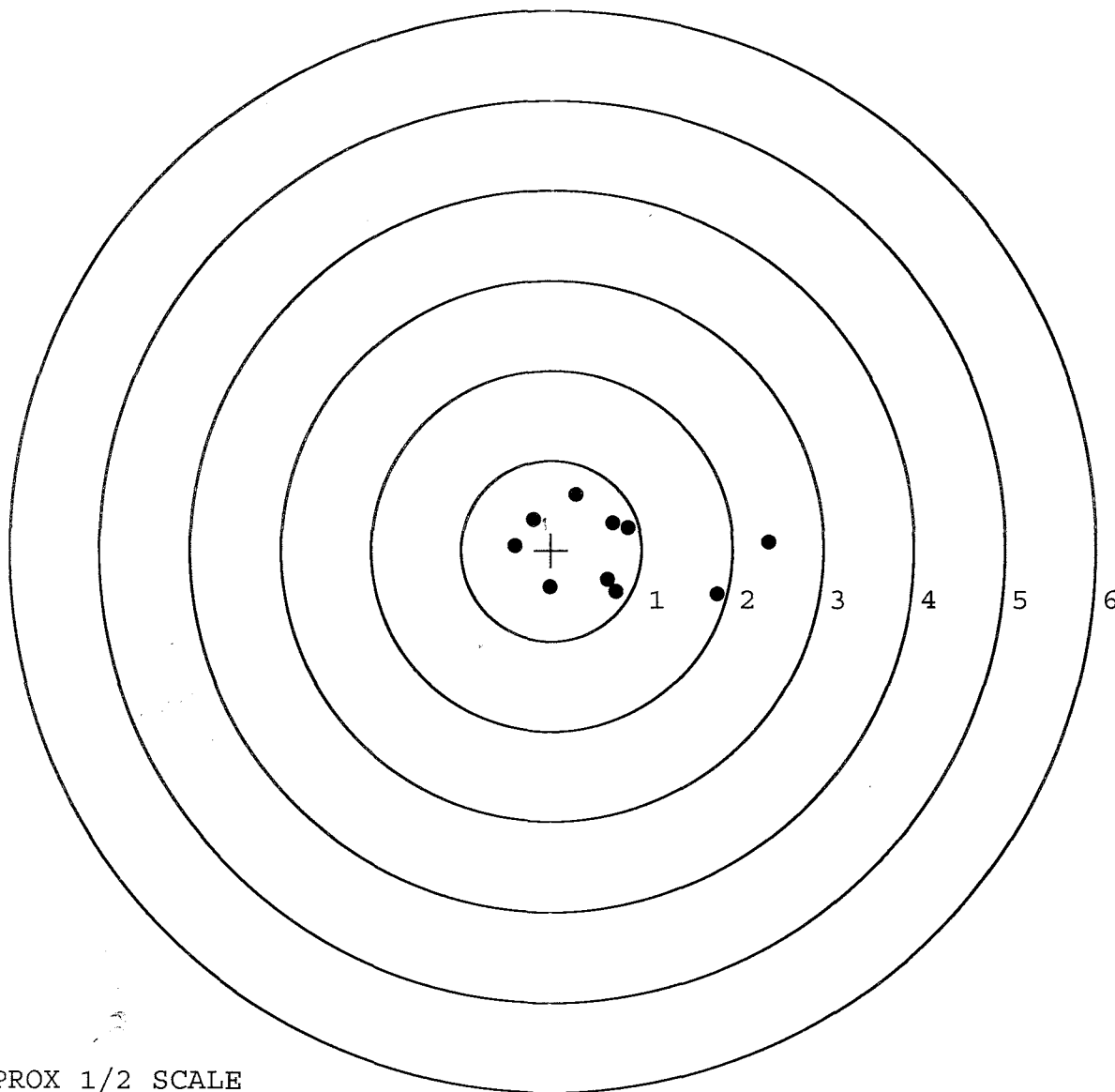


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: E6413466. __0
TARGET NUMBER: 5
FILE DATE: 06/24/2003
FILE TIME: 06:55

X CENTROID: 0.674
Y CENTROID: -0.007
POA TO CENTROID: 0.674
HORZ SPREAD: 2.803
VERT SPREAD: 1.108
GROUP SPREAD: 2.803
MIN RADIUS: 0.302
MAX RADIUS: 1.728
MEAN RADIUS: 0.795
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 9

POINT#	X	Y
1:	-0.403	0.043
2:	-0.201	0.339
3:	0.268	0.620
4:	0.678	0.300
5:	0.717	-0.464
6:	1.833	-0.488
7:	2.400	0.083
8:	-0.018	-0.412
9:	0.843	0.244
10:	0.625	-0.333



TARGET APPROX 1/2 SCALE

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

R & E NUMBER	C66086		
SERIAL NUMBER	C6349002 E643466 (NEW)		
LOG-IN DATE	6/2/03		
INSPECT AND VERIFY:			
OPERATION #	OPERATION NAME	DATE	INITIAL
550	DIS-ASSEMBLE GUN	6/4/03	RTL
560 A	RE-BARREL	6/5/03	RTL
B	DRILL AND TAP	6-5-03	TRW
575	ASSEMBLE	6-5/03	RTL
600	PROOF	6-5-03	AC
605	CHECK HEADSPACE	6-5-03	AC
610	DIS-ASSEMBLE GUN	6-5-03	RTL
612	MAGNAFLUX		
615	ROLLMARK CALIBER	6-17-03	JB
618	ROTO-BLAST	6-17-03	JB
620	APPLY COATINGS	6-19-03	TA
625 A	FINAL ASSEMBLY	6-23-03	RTL
B	TRIGGER PULL TEST	6-26-03	TRW
C	SAFETY "ON" FORCE	6-26-03	DA
D	SAFETY "OFF" FORCE	6-26-03	DA
E	FIRING PIN INDENT	6-26-03	DA
640	TARGET	6-26-03	AC
655	FINAL INSPECT	6-26-03	RTL
660	PACK	6-26-03	DA
		SHIP DATE	
		QAR INSPECTION DATE	