

C6349059

MODEL 700™ M24

Model **SMS**™

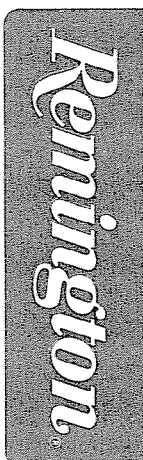
Action

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: RE00115234

Serial: C6349059 Model M24 SWS Center Fire
Caliber: 308

Repairman:

Status: Closed 8/2/2006 10:42:25 AM

Verify Repair

Address Information

Customer:

☒ Received From

Return To:

☐ Received From

Name: MAT MOV BRANCH

MAT MOV BRANCH

Address 1: RAINIER AVE

RAINIER AVE

Address 2: BUDG 9611

PO Box:

BUDG 9611

PO Box:

City: FORT LEWIS

FORT LEWIS

State: WA

Zip Code: 98433

Country: US

State: WA

Zip Code: 98433

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
A017	Scope Base	1
B000	FRONT AND REAR E	1

nagletj

8/2/2006

10:56 AM

CAPS

NUM

INS

SCRL

start

2 M...

Part...

51...

2 M...

Arms...

My D...

ENL...

10:56 AM

Serial Number: C6349059

Model: M24 SWS



RE00115234

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6349059.___0

FILE DATE AND TIME: 08/16/2006 05:32

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.061
The Average Y Centroid of the Five Target Set:	-0.131
The Average Point of Impact of the Five Target Set:	0.145
The Average Mean Radius of the Five Target Set:	0.887
The Distance from POA to Centroid Target #1:	0.100
The Distance from Centroid Target #2 to Centroid Target #1:	0.179
The Distance from Centroid Target #3 to Centroid Target #1:	0.178
The Distance from Centroid Target #4 to Centroid Target #1:	0.266
The Distance from Centroid Target #5 to Centroid Target #1:	0.678

SERIAL NUMBER: C6349059. 0

TARGET NUMBER: 1

FILE DATE: 08/16/2006

FILE TIME: 05:32

POINT#	X	Y
1:	1.018	0.391
2:	0.077	0.855
3:	-0.823	1.779
4:	-0.855	-0.141
5:	-1.075	-0.841
6:	-0.122	-1.082
7:	0.569	-0.203
8:	0.117	-0.271
9:	0.157	0.168
10:	0.205	0.022

X CENTROID: -0.073

Y CENTROID: 0.068

POA TO CENTROID: 0.100

HORZ SPREAD: 2.093

VERT SPREAD: 2.861

GROUP SPREAD: 2.946

MIN RADIUS: 0.251

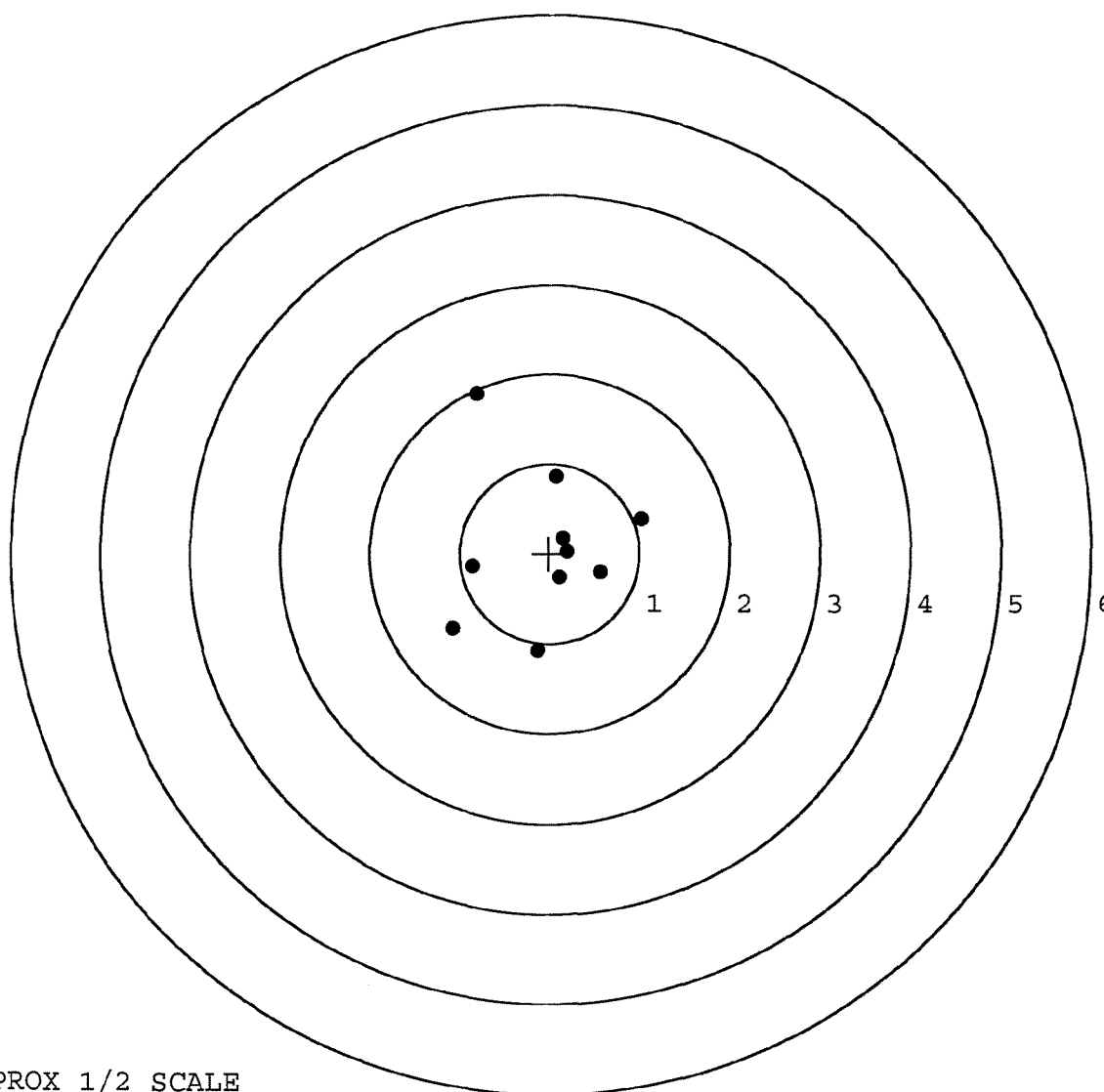
MAX RADIUS: 1.868

MEAN RADIUS: 0.874

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6349059. 0

TARGET NUMBER: 2

FILE DATE: 08/16/2006

FILE TIME: 05:32

POINT#	X	Y
1:	1.209	-0.082
2:	0.665	-0.759
3:	0.233	-0.491
4:	-0.233	-0.675
5:	-0.847	-0.498
6:	0.227	0.311
7:	-0.274	0.136
8:	-0.373	0.514
9:	0.019	0.752
10:	0.283	0.755

X CENTROID: 0.091

Y CENTROID: -0.004

POA TO CENTROID: 0.091

HORZ SPREAD: 2.056

VERT SPREAD: 1.514

GROUP SPREAD: 2.098

MIN RADIUS: 0.343

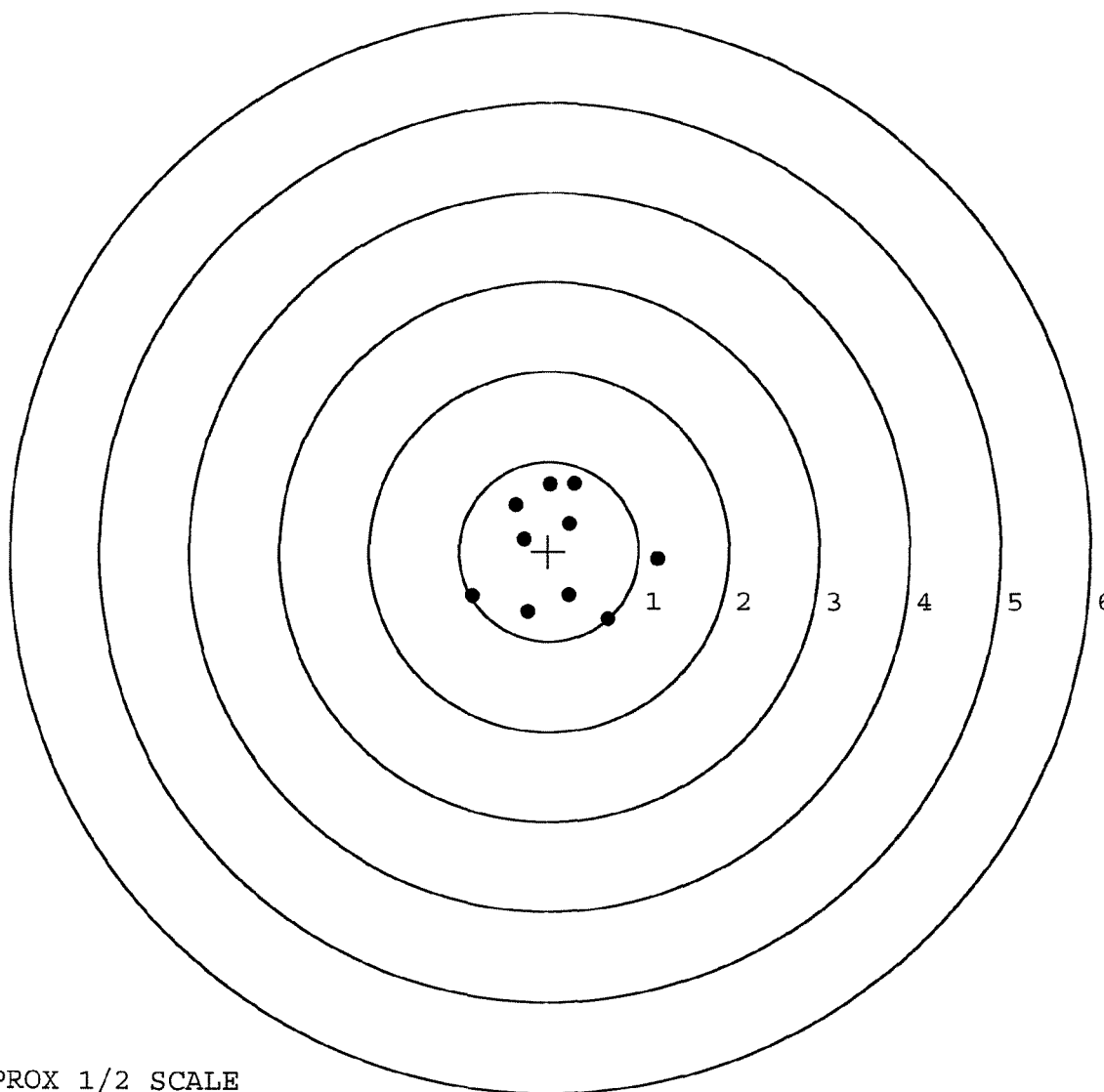
MAX RADIUS: 1.121

MEAN RADIUS: 0.735

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10

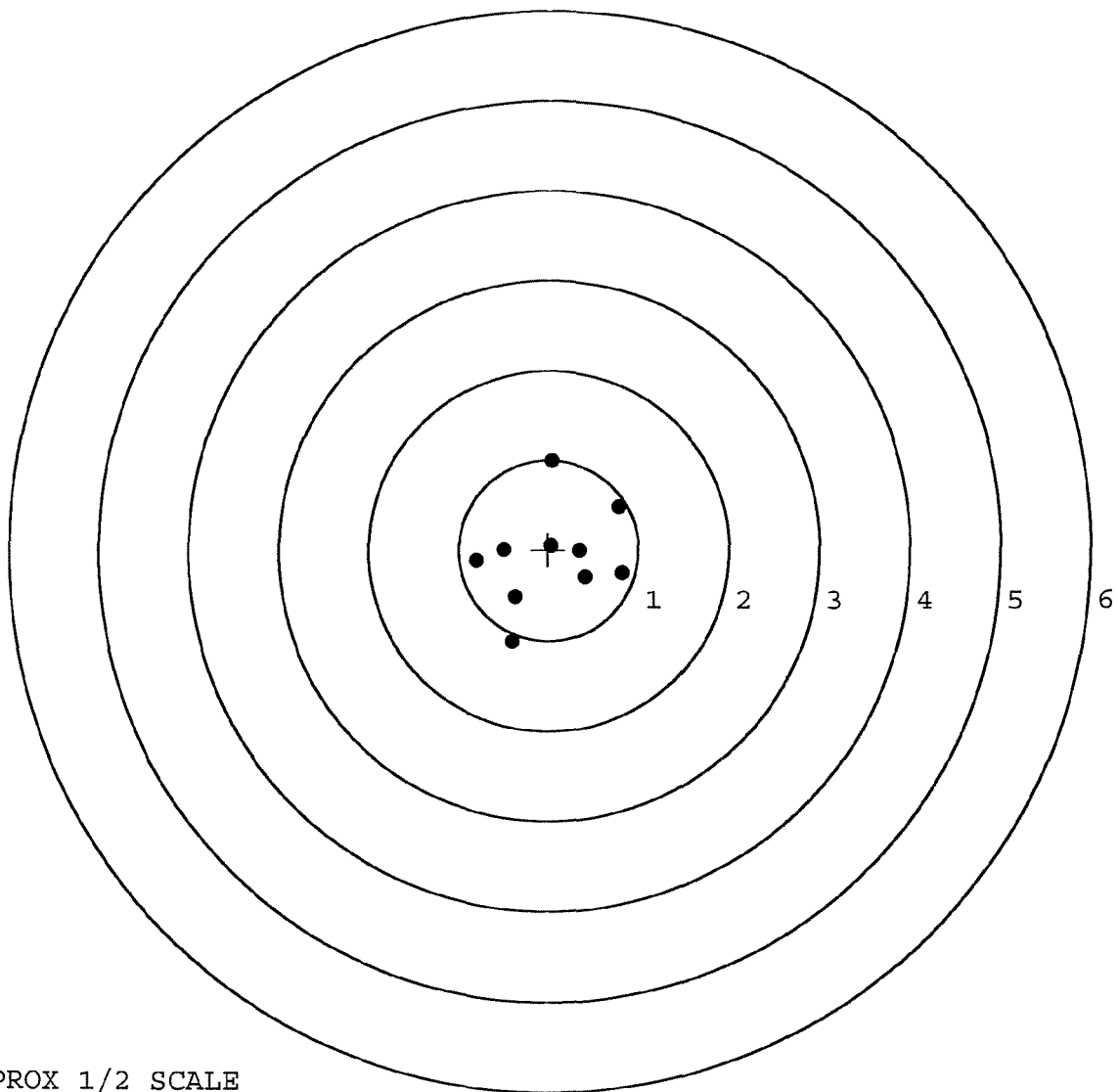


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6349059. __0
TARGET NUMBER: 3
FILE DATE: 08/16/2006
FILE TIME: 05:32

X CENTROID: 0.036
Y CENTROID: -0.073
POA TO CENTROID: 0.082
HORZ SPREAD: 1.628
VERT SPREAD: 2.012
GROUP SPREAD: 2.061
MIN RADIUS: 0.118
MAX RADIUS: 1.066
MEAN RADIUS: 0.671
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.040	0.993
2:	0.780	0.476
3:	0.825	-0.261
4:	0.407	-0.305
5:	0.349	-0.012
6:	0.037	0.045
7:	-0.498	0.003
8:	-0.803	-0.125
9:	-0.367	-0.526
10:	-0.406	-1.019



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6349059. 0

TARGET NUMBER: 4

FILE DATE: 08/16/2006

FILE TIME: 05:32

POINT#	X	Y
1:	0.912	0.063
2:	0.748	0.500
3:	-0.411	0.907
4:	-0.204	0.312
5:	-0.261	0.068
6:	-0.557	-0.342
7:	-0.402	-0.941
8:	0.060	-0.600
9:	0.398	-1.197
10:	1.336	0.665

X CENTROID: 0.162

Y CENTROID: -0.056

POA TO CENTROID: 0.171

HORZ SPREAD: 1.893

VERT SPREAD: 2.104

GROUP SPREAD: 2.366

MIN RADIUS: 0.441

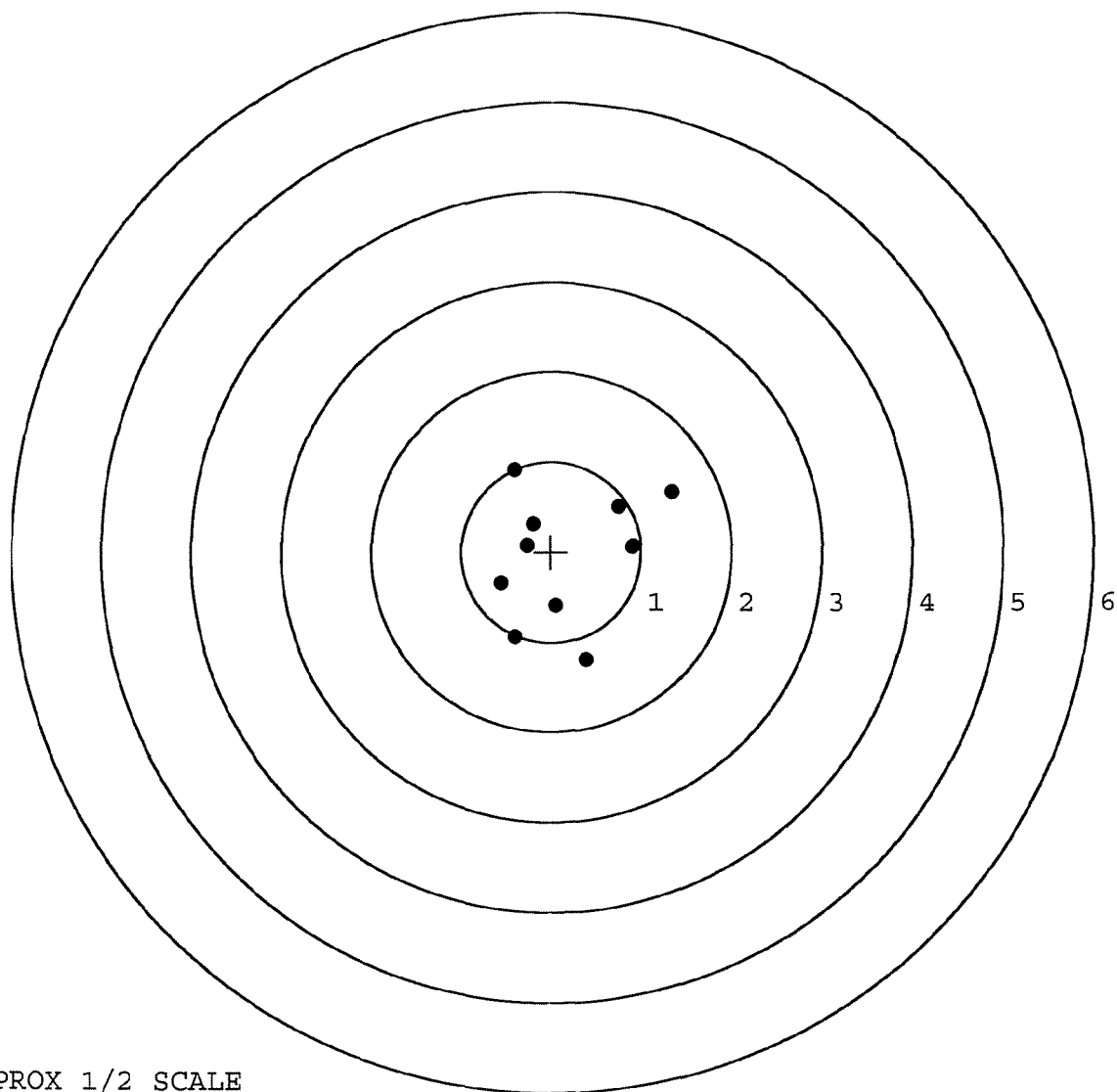
MAX RADIUS: 1.378

MEAN RADIUS: 0.857

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 10

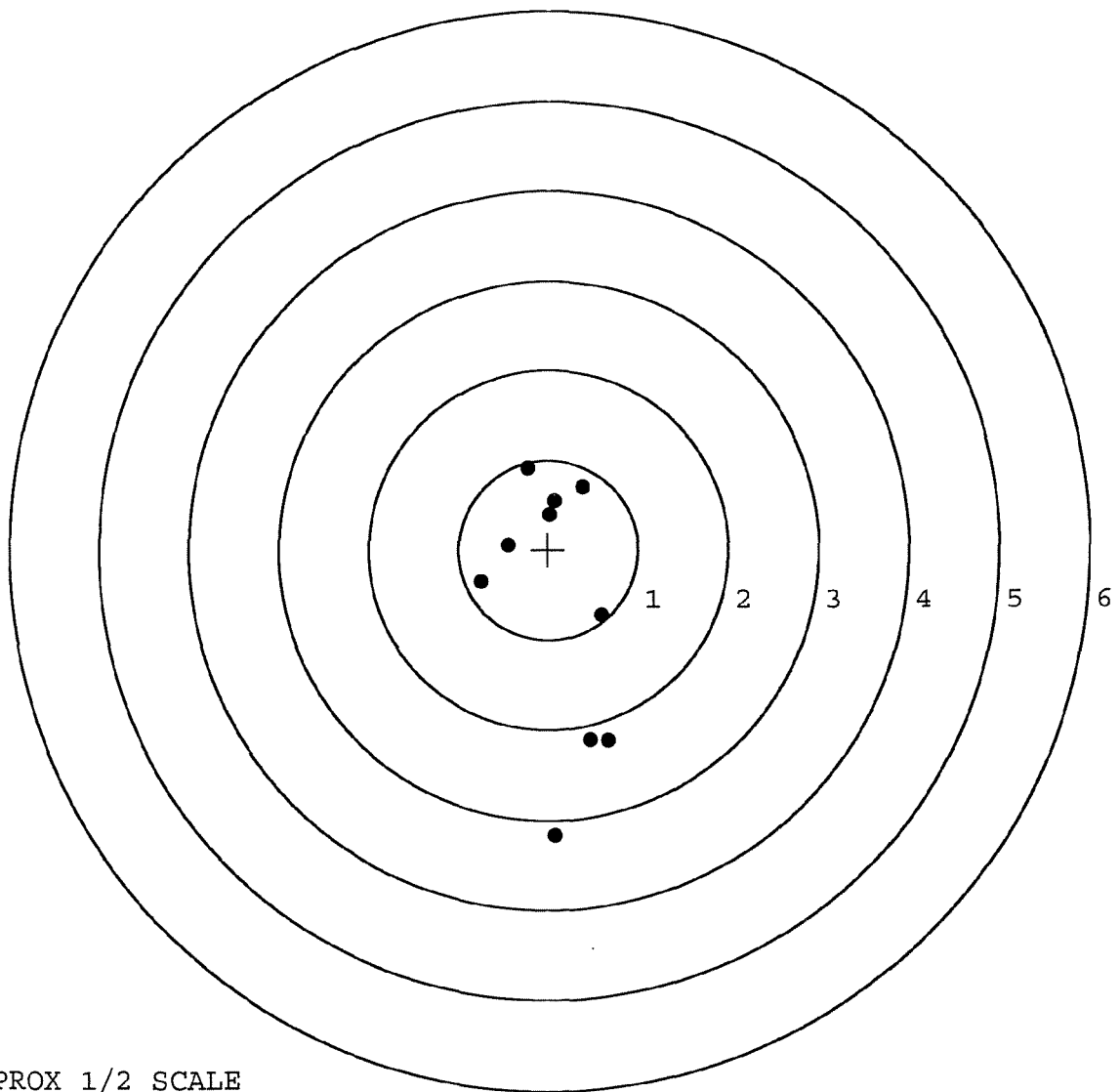


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6349059. 0
TARGET NUMBER: 5
FILE DATE: 08/16/2006
FILE TIME: 05:32

X CENTROID: 0.087
Y CENTROID: -0.591
POA TO CENTROID: 0.598
HORZ SPREAD: 1.415
VERT SPREAD: 4.091
GROUP SPREAD: 4.103
MIN RADIUS: 0.529
MAX RADIUS: 2.587
MEAN RADIUS: 1.301
IN 1 IN DIAMETER: 0
IN 2 IN DIAMETER: 4
in 3 IN DIAMETER: 6

POINT#	X	Y
1:	0.383	0.702
2:	-0.230	0.913
3:	0.018	0.390
4:	0.070	0.541
5:	-0.440	0.048
6:	-0.748	-0.354
7:	0.598	-0.729
8:	0.667	-2.125
9:	0.470	-2.120
10:	0.085	-3.178



TARGET APPROX 1/2 SCALE

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

R & E NUMBER	115234				
SERIAL NUMBER	C6349059				
LOG-IN DATE	8-2-06				
OPERATION #	OPERATION NAME		DATE	INITIAL	
500	DIS-ASSEMBLE GUN		8-8-06	RT	
505	RE-BARREL				
420	ASSEMBLE	MAGNA - FLUX			
440	PROOF	INSPECTED	8-9-06	BLG	
460	CHECK HEADSPACE	AUG 11 2006	8-9-06	BLG	
470	DIS-ASSEMBLE GUN	OPERATOR	8-9-06	BLG	
480	MAGNAFLUX		8-11-06	APD	
510	DRILL AND TAP		8-10-06	TRW	
500	ROLLMARK CALIBER		8-11-06	CW	
520	GOFF BLAST BBL / REC		8-11-06	LB	
530 & 540	APPLY COATINGS		8/13/06	EB	
560	FINAL ASSEMBLY		8-15-06	RT	
640	FUNCTION TEST AND	PASS FAIL	8-16-06	TRW	
650	TARGET	PASS FAIL	8-16-06	TRW	
	MALFUNCTION	CORRECTION			
	MALFUNCTION	CORRECTION			
	MALFUNCTION	CORRECTION			
	MALFUNCTION	CORRECTION	8/16	BD	
670	FINAL INSPECTION		8-17-06	MTM	
	A) HEADSPACE	PASS FAIL	8-17-06	MTM	
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	281 288 281 285 278		R.P.
680	F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX	4.5 4.5 5.0 8-17-06		DA
	G) SAFETY OFF FORCE	2 LBS MIN	2.5 2.5 2.5 8-17-06		DA
	I) FIRING PIN INDENT	.020	.023 .024 .024 8-17-06		DA
690	PACK		8-24-06		DA
			8		

F006 REV 5/2006

FINAL INSPECTION CHECKLIST

BARREL ASSEMBLY

BARREL

RECEIVER

FRONT SIGHT BASE

REAR SIGHT BASE

SCREWS

FINISH

SCOPE ASSEMBLY

SCOPE

SCOPE RINGS

MOUNTING SCREWS

MOUNTING BASE

SCREWS

FINISH

CLARITY

STOCK ASSEMBLY

STOCK

SLING SWIVEL STUDS

BUTT PATE

LOCK NUTS

BARREL CLEARANCE

COLOR / FINISH

SYSTEM CASE

SCOPE CASE

IRON SIGHTS

DEPLOYMENT KIT

TRIGGER ASSEMBLY

SAFETY OPERATION

RE-SET TO FACTORY
SPECS

COMMENTS: _____

F006 REV 5/2006




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

MODEL 700TM H24

SERIAL NO.
C6349059

ORDER NO.
5716

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

01

UPC



0 47700 25716 7



5716 C6349059

RC-15
Replaced

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6349059

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	1 12 90		RW
600	Proof	1 12 90		L
607	Check Headspace	1 12 90		L
610	Dis-assemble Gun	1 12 90		RW
612	Magnaflux Barrel Action	1-16-90		KCR
	Magnaflux Bolt	1-17-90		KCR
615	Rollmark Caliber	1-17-90		GS
617	Drill and Tap Sight Holes	1-19-90		FB
618	Polish Barrel RB	1-22-90		WB
620	Apply Coatings (Barrel Action)		1-28-90	JA
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		2/1/90	WB
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		2/1/90	RW
	C) Inspect Ejector Hole for Chamfer		2/1/90	RW
	D) Oil Firing Pin Ass'y		2/1/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		3/1/90	GS

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			2-1-90	gH
	G) Safety Off Force	3	3	3			2-1-90	gH
	H) Trigger Pull Test & Retainability						3/1/90	gH
	I) Firing Pin Indent	.022	.0225	.023			2-1-90	gH
	J) Assemble Stock						2/27/90	RW
	K) Assemble Swivel Studs						3/13/90	WB
	L) Attach Front and Rear Sight Assemblies						2/27/90	RW
	M) Iron Sight Alignment						2/27/90	RW
	N) Detach Front & Rear Sights & place in numbered container						2/27/90	RW
	O) Attach Scope to Rifle						2/27/90	WB
	P) Detach & Attach Scope 20 Times						2/27/90	WB
640	Gallery Target & Test						2-27-90	A
	A) Time						"	A
	B) Malfunctions						"	A
	C) Pierced Primers						"	A
	D) Optical Clarity of Scope						"	A
645	Inspect for Live Ammo						2-27-90	A
655	Final Inspection						3/13/90	WB
	A) Headspace						3/13/90	WB
	B) Trigger Pull	2.80	2.81	2.80	2.77	2.72	3/13/90	WB
	C) Function						3/13/90	WB
660	Pack						20 Mar 90	gH

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6349059

DATE 31 Jan 80

TESTER [Signature]

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.45	2.46	2.65	2.80	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.31	2.61	2.17	2.81	
PULL #3	2.34	2.57	2.31	2.80	
PULL #4	2.40	2.56	2.25	2.74	
PULL #5	2.38	2.61	2.15	2.72	
TOTAL	11.88	12.81	11.53		
AVG.	2.376	2.562	2.306		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.08	3.18		
PULL #2	3.16	3.26		
PULL #3	3.19	3.31		
PULL #4	3.24	3.22		
PULL #5	3.09	3.28		
TOTAL	15.76	16.25		
AVG.	3.152	3.25		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.17	4.22		4.02
PULL #2	4.13	4.28		3.85
PULL #3	4.17	4.44		3.96
PULL #4	4.14	4.18		3.81
PULL #5	4.16	4.21		4.03
TOTAL	20.77	21.33		19.67
AVG.	4.154	4.266		3.934

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06349059
28 Feb 1990

CENTROIDAL DISTANCES

0 TO 1	.463975
1 TO 2	.476341
1 TO 3	.186331
1 TO 4	.832309
1 TO 5	.448291

$\frac{1}{2} + \frac{1}{2} = 1$ (----POA)

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .178
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1378
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .225186
THE AMR FOR THIS RIFLE IS: .9602

30 Feb 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C6349059

CENTERFIRE PATTERNS # 1

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 10

HS= 1.808

VS= 2.447

GS= 2.523

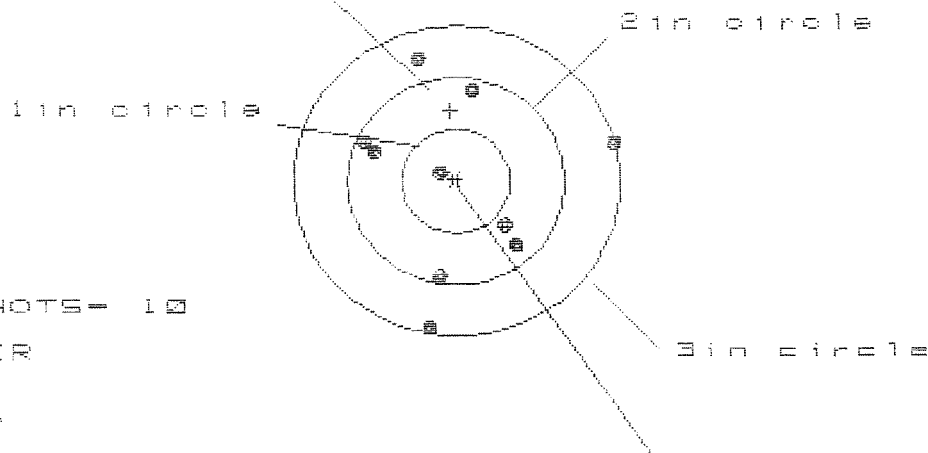
PATTERN #	1	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.020	.987	1.093
MINIMUM X	-.788	-.821	-.715
MAXIMUM Y	1.071	.918	.766
MINIMUM Y	-1.376	-1.219	-.878
CENTROID X	.347	.380	.274
CENTROID Y	-.308	-.155	-.003
Dist TO CENTROID in.	.464	.410	.274
MIN RADIUS	.453	.298	.244
MEAN RADIUS	.940	.863	.756
MAX RADIUS	1.407	1.484	1.111
HORIZONTAL SPREAD	1.808	1.808	1.808
VERTICAL SPREAD	2.447	2.137	1.644
EXTREME SPREAD	2.523	2.501	2.030
NUMBER IN ONE INCH CIRCLE	2	2	2
NUMBER IN TWO INCH CIRCLE	5	5	5
NUMBER IN THREE INCH CIRCLE	10	10	10

27 Feb 1998

FILE:/PATTERNING/CENTERFIRE_PATT/08349059

CENTERFIRE PATTERNS # 2

POA



OF SHOTS= 10

IN CIR

1in = 1

2in = 7

3in = 9

HS= 2.291

VS= 2.606

GS= 2.607

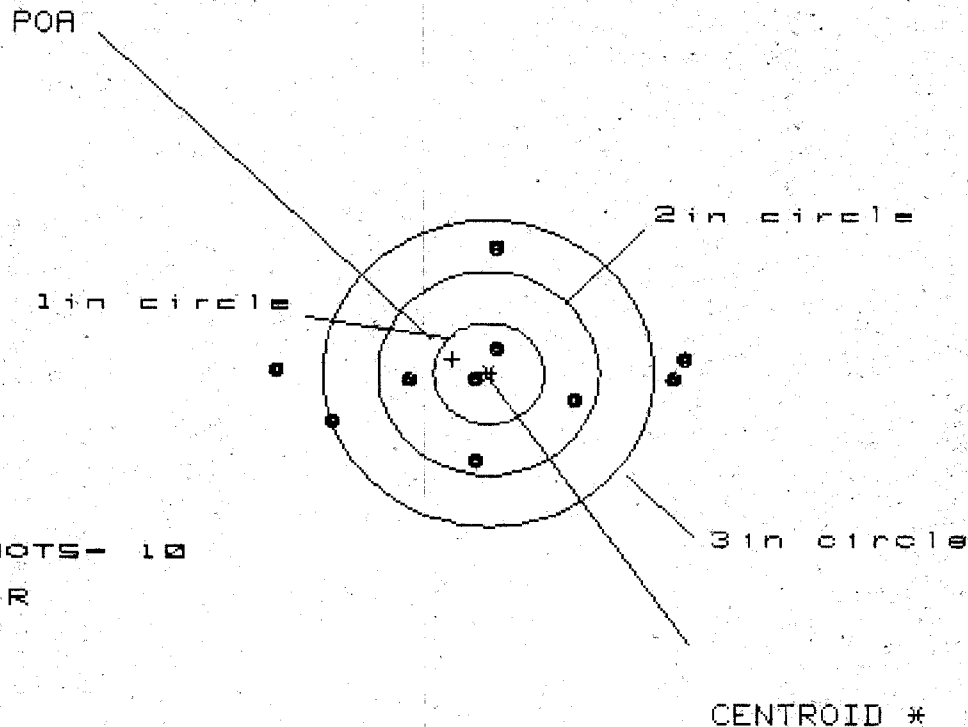
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.469	.666	.650
MINIMUM X	:	-.822	-.659	-.675
MAXIMUM Y	:	1.222	1.267	1.099
MINIMUM Y	:	-1.384	-1.339	-1.041
CENTROID X	:	.052	-.111	-.095
CENTROID Y	:	-.682	-.727	-.559
POA TO CENTROID in.	:	.684	.735	.567
MIN RADIUS	:	.179	.128	.041
MEAN RADIUS	:	.938	.856	.774
MAX RADIUS	:	1.523	1.345	1.119
HORIZONTAL SPREAD	:	2.291	1.325	1.325
VERTICAL SPREAD	:	2.606	2.606	2.140
EXTREME SPREAD	:	2.607	2.607	2.150
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

27 Feb 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6349059

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 6

HS= 3.756

VS= 2.055

GS= 3.760

PATTERN #

SHOTS (BEST OF)

10

9

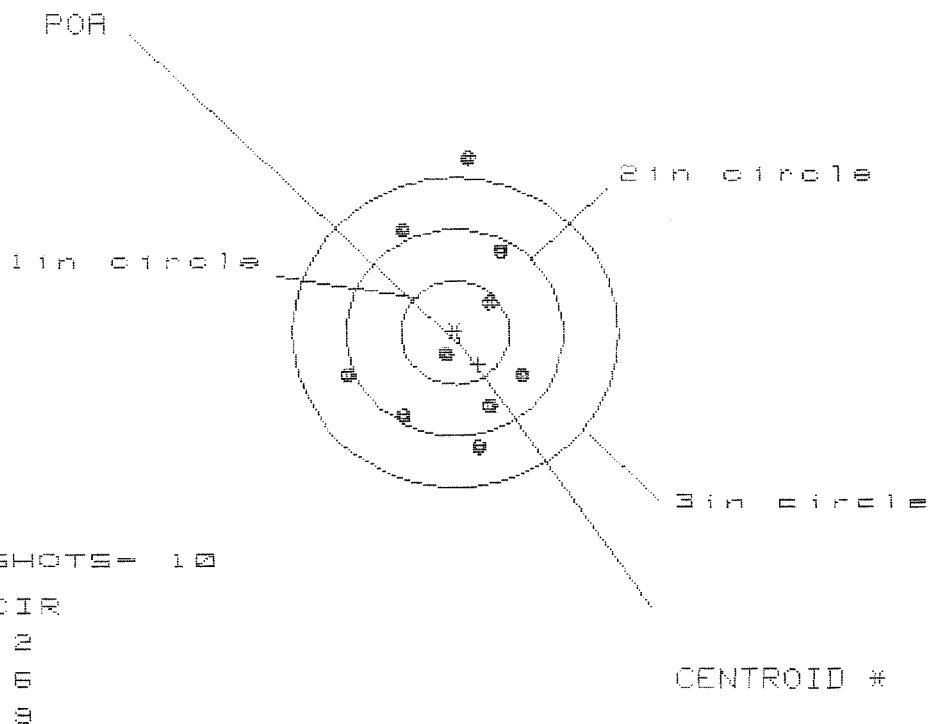
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MAXIMUM X	:	1.817	1.602	1.663
MINIMUM X	:	-1.939	-1.666	-1.466
MAXIMUM Y	:	1.219	1.219	1.241
MINIMUM Y	:	-.836	-.836	-.815
CENTROID X	:	.326	.541	.341
CENTROID Y	:	-.143	-.143	-.165
POA TO CENTROID in.	:	.356	.560	.378
MIN RADIUS	:	.129	.332	.138
MEAN RADIUS	:	1.101	1.019	.907
MAX RADIUS	:	1.939	1.717	1.664
HORIZONTAL SPREAD	:	3.756	3.268	3.129
VERTICAL SPREAD	:	2.055	2.055	2.055
EXTREME SPREAD	:	3.760	3.320	3.150
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		6	

27 Feb 1998

FILE:/PATTERNING/CENTERFIRE_PATT/06349859

CENTERFIRE PATTERNS # 4



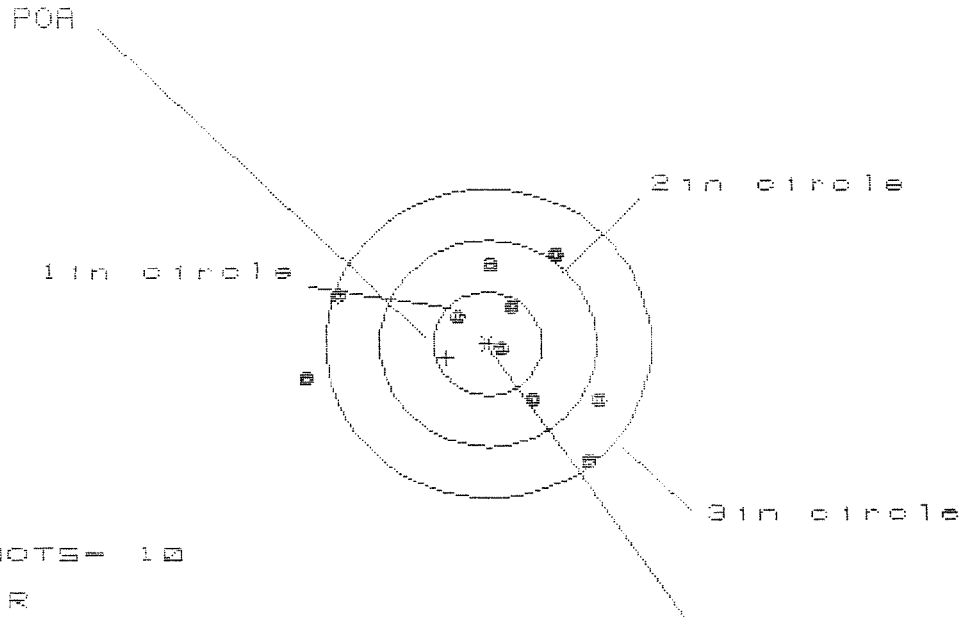
HS= 1.628
VS= 2.816
CS= 2.820

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.612	.625	.660
MINIMUM X	:	-1.016	-1.003	-.968
MAXIMUM Y	:	1.669	1.201	1.081
MINIMUM Y	:	-1.147	-.962	-.722
CENTROID X	:	-.216	-.229	-.264
CENTROID Y	:	.305	.120	.240
POA TO CENTROID in.	:	.374	.259	.357
MIN RADIUS	:	.228	.050	.158
MEAN RADIUS	:	.911	.788	.775
MAX RADIUS	:	1.673	1.307	1.192
HORIZONTAL SPREAD	:	1.628	1.628	1.628
VERTICAL SPREAD	:	2.816	2.163	1.803
EXTREME SPREAD	:	2.820	2.303	1.948
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

27 Feb 1998

FILE:/PATTERNING/CENTERFIRE_PATT/08349059

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 3

2in = 5

3in = 8

HS= 2.736

VS= 1.938

GS= 2.742

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.012	.821	.909
MINIMUM X	:	-1.724	-1.540	-1.452
MAXIMUM Y	:	.833	.798	.656
MINIMUM Y	:	-1.105	-1.140	-.751
CENTROID X	:	.381	.572	.484
CENTROID Y	:	.139	.174	.316
POA TO CENTROID in.	:	.405	.598	.578
MIN RADIUS	:	.165	.106	.195
MEAN RADIUS	:	.911	.788	.702
MAX RADIUS	:	1.752	1.588	1.472
HORIZONTAL SPREAD	:	2.736	2.361	2.361
VERTICAL SPREAD	:	1.938	1.938	1.407
EXTREME SPREAD	:	2.742	2.716	2.531
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	