

GCAG 6881
Raphae
E 6413686

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: **RE00113036** Serial: G6296881 Model: M24 SWS Center Fire
 Verify Repair: ☐ Caliber: 7.62 NATO Repairman:
 Status: Closed 5/31/2006 10:20:16 AM

Address Information

Customer: ☐ Received From: ☐ Return To: ☐ Received From: ☐

Name: C CO SPT BN SWTG (A) POC JERRY SCREEN C CO SPT BN SWTG (A) POC JERRY SCREEN
 Address 1: ARMAMENT FACILITY BLDG D-1307 ARMAMENT FACILITY BLDG D-1307
 Address 2: GRUBER ROAD PO Box: GRUBER ROAD PO Box:
 City: FORT BRAGG FORT BRAGG
 State: NC Zip Code: 28310 Country: US State: NC Zip Code: 28310 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
A057	Fit and Rear Sgt Base	1

Repair Search Refresh Close

naqlh 5/31/2006 10:47 AM CAPS NUM INS SERL

start 2 Micros... 2 Micros... 3 Intern... Arms Servi... Part Searc... 10:47 AM

Serial Number: **G6296881**
 Model: **M24 SWS**

RE00113036

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6296881.__0
FILE DATE AND TIME: 10/27/2003 11:35

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.006
The Average Y Centroid of the Five Target Set:	0.087
The Average Point of Impact of the Five Target Set:	0.087
The Average Mean Radius of the Five Target Set:	0.656
The Distance from POA to Centroid Target #1:	0.069
The Distance from Centroid Target #2 to Centroid Target #1:	0.163
The Distance from Centroid Target #3 to Centroid Target #1:	0.284
The Distance from Centroid Target #4 to Centroid Target #1:	0.134
The Distance from Centroid Target #5 to Centroid Target #1:	0.561

SERIAL NUMBER: G6296881.___0

TARGET NUMBER: 1

FILE DATE: 10/27/2003

FILE TIME: 11:35

X CENTROID: 0.033

Y CENTROID: -0.061

POA TO CENTROID: 0.069

HORZ SPREAD: 1.327

VERT SPREAD: 2.207

GROUP SPREAD: 2.278

MIN RADIUS: 0.221

MAX RADIUS: 1.213

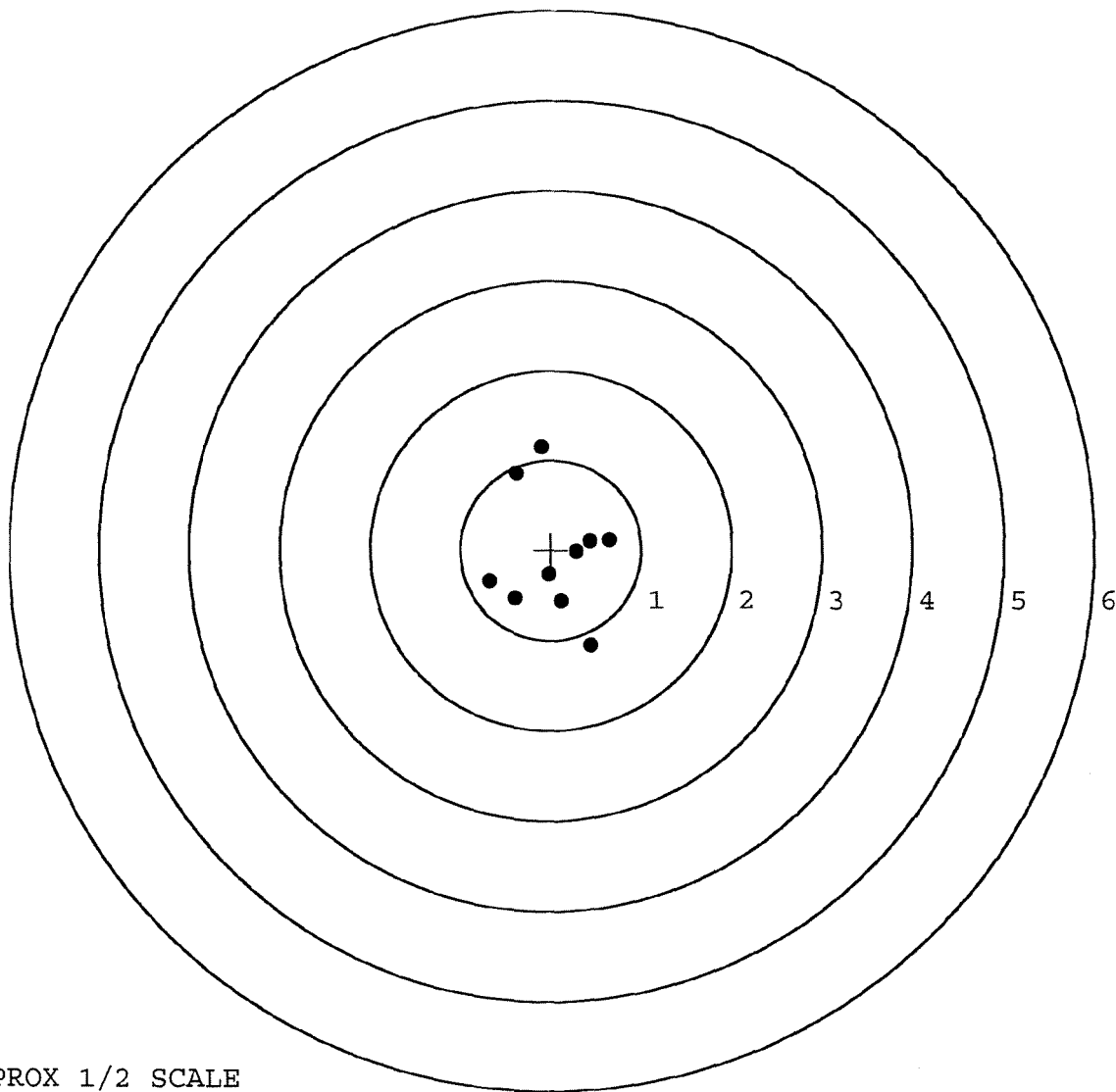
MEAN RADIUS: 0.677

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.452	-1.064
2:	0.114	-0.569
3:	-0.399	-0.534
4:	-0.679	-0.348
5:	0.285	-0.020
6:	0.434	0.098
7:	0.648	0.113
8:	-0.390	0.850
9:	-0.114	1.143
10:	-0.022	-0.275



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6296881. __ 0

TARGET NUMBER: 2

FILE DATE: 10/27/2003

FILE TIME: 11:35

X CENTROID: 0.140

Y CENTROID: 0.061

POA TO CENTROID: 0.153

HORZ SPREAD: 1.192

VERT SPREAD: 1.624

GROUP SPREAD: 1.625

MIN RADIUS: 0.117

MAX RADIUS: 0.846

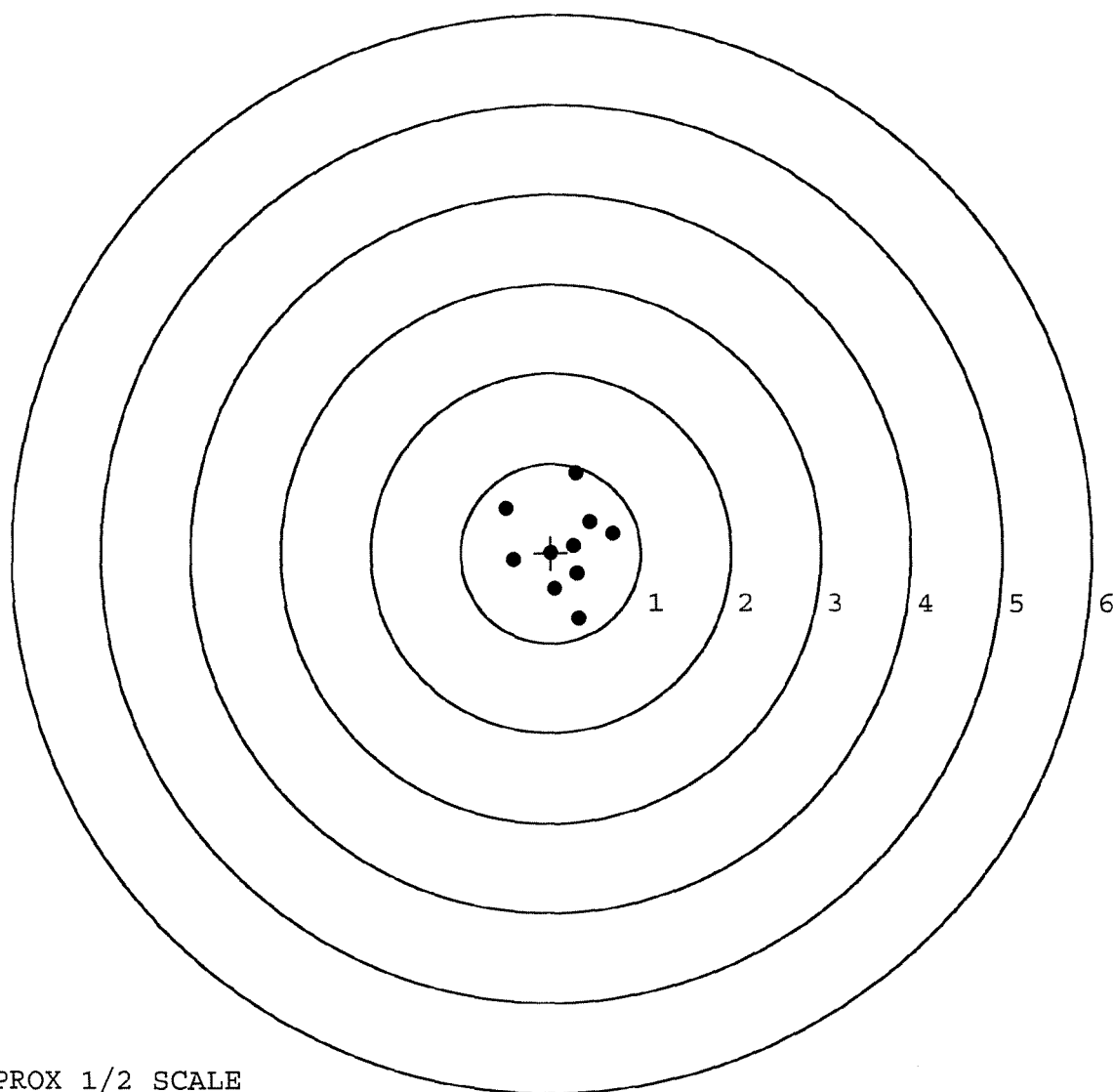
MEAN RADIUS: 0.506

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.325	-0.728
2:	0.689	0.223
3:	0.427	0.352
4:	0.279	0.896
5:	-0.503	0.496
6:	-0.417	-0.082
7:	0.304	-0.233
8:	0.048	-0.395
9:	-0.005	0.004
10:	0.256	0.081

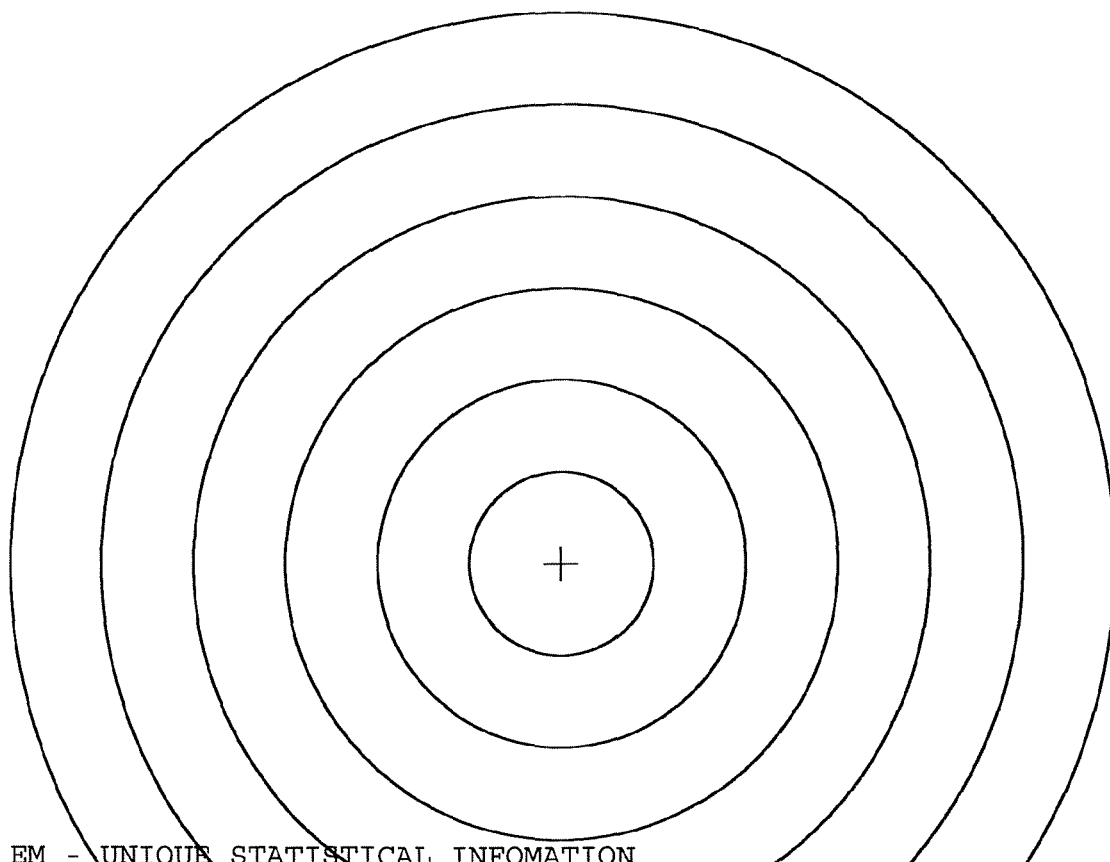


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6296881.___0
TARGET NUMBER: 3
FILE DATE: 10/27/2003
FILE TIME: 11:35

X CENTROID: 0.087
Y CENTROID: 0.218
POA TO CENTROID: 0.235
HORZ SPREAD: 2.122
VERT SPREAD: 2.947
GROUP SPREAD: 2.951
MIN RADIUS: 0.074
MAX RADIUS: 1.584
MEAN RADIUS: 0.893
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 6
in 3 IN DIAMETER: 8

POINT#	X	Y
1:	0.522	-1.257
2:	0.915	0.393
3:	0.854	1.114
4:	0.672	1.690
5:	-1.207	0.705
6:	-0.476	0.204
7:	-0.216	-0.130
8:	0.120	-0.111
9:	0.137	0.164
10:	-0.456	-0.590



EM - UNIQUE STATISTICAL INFORMATION

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The Average Y Centroid of the Five Target Set:
The Average Point of Impact of the Five Target Set:
The Average Mean Radius of the Five Target Set:

The Distance from POA to Centroid Target #1:
The Distance from Centroid Target #2 to Centroi
The Distance from Centroid Target #3 to Centroi
The Distance from Centroid Target #4 to Centroi
The Distance from Centroid Target #5 to Centroi

SERIAL NUMBER: G6296881. 0

TARGET NUMBER: 1

FILE DATE: 10/27/2003

FILE TIME: 11:35

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POA TO CENTROID: 0.069

HORZ SPREAD: 1.327

VERT SPREAD: 2.207

GROUP SPREAD: 2.278

MIN RADIUS: 0.221

MAX RADIUS: 1.213

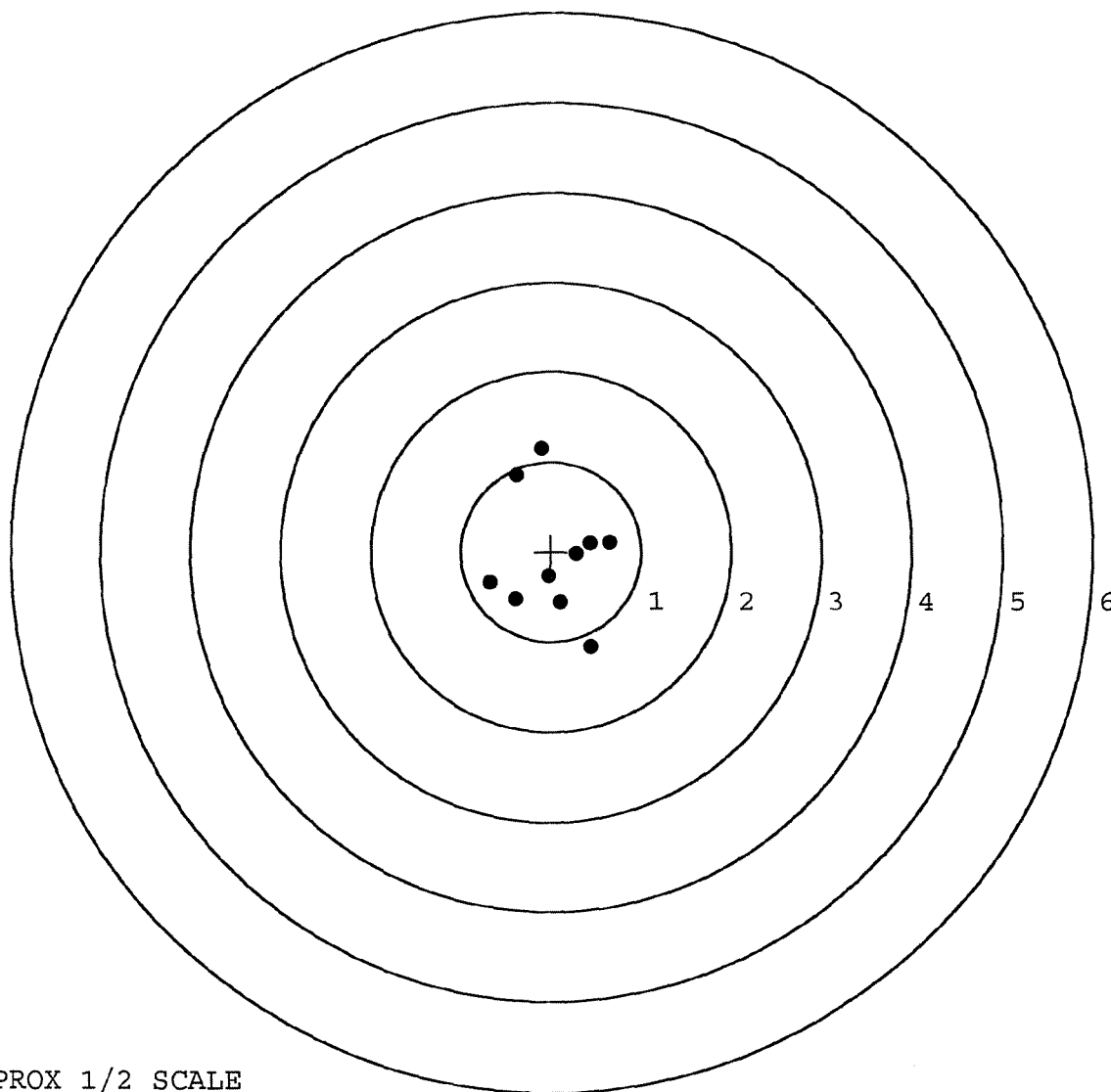
MEAN RADIUS: 0.677

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10

POINT#	X	Y
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5:	0.285	-0.020
6:	0.434	0.098
7:	0.648	0.113
8:	-0.390	0.850
9:	-0.114	1.143
10:	-0.022	-0.275



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6296881. __0

TARGET NUMBER: 2

FILE DATE: 10/27/2003

FILE TIME: 11:35

POINT#	X	Y
1:	0.325	-0.728
2:	0.689	0.223
3:	0.427	0.352
4:	0.279	0.896
5:	-0.503	0.496
6:	-0.417	-0.082
7:	0.304	-0.233
8:	0.048	-0.395
9:	-0.005	0.004
10:	0.256	0.081

X CENTROID: 0.140

Y CENTROID: 0.061

POA TO CENTROID: 0.153

HORZ SPREAD: 1.192

VERT SPREAD: 1.624

GROUP SPREAD: 1.625

MIN RADIUS: 0.117

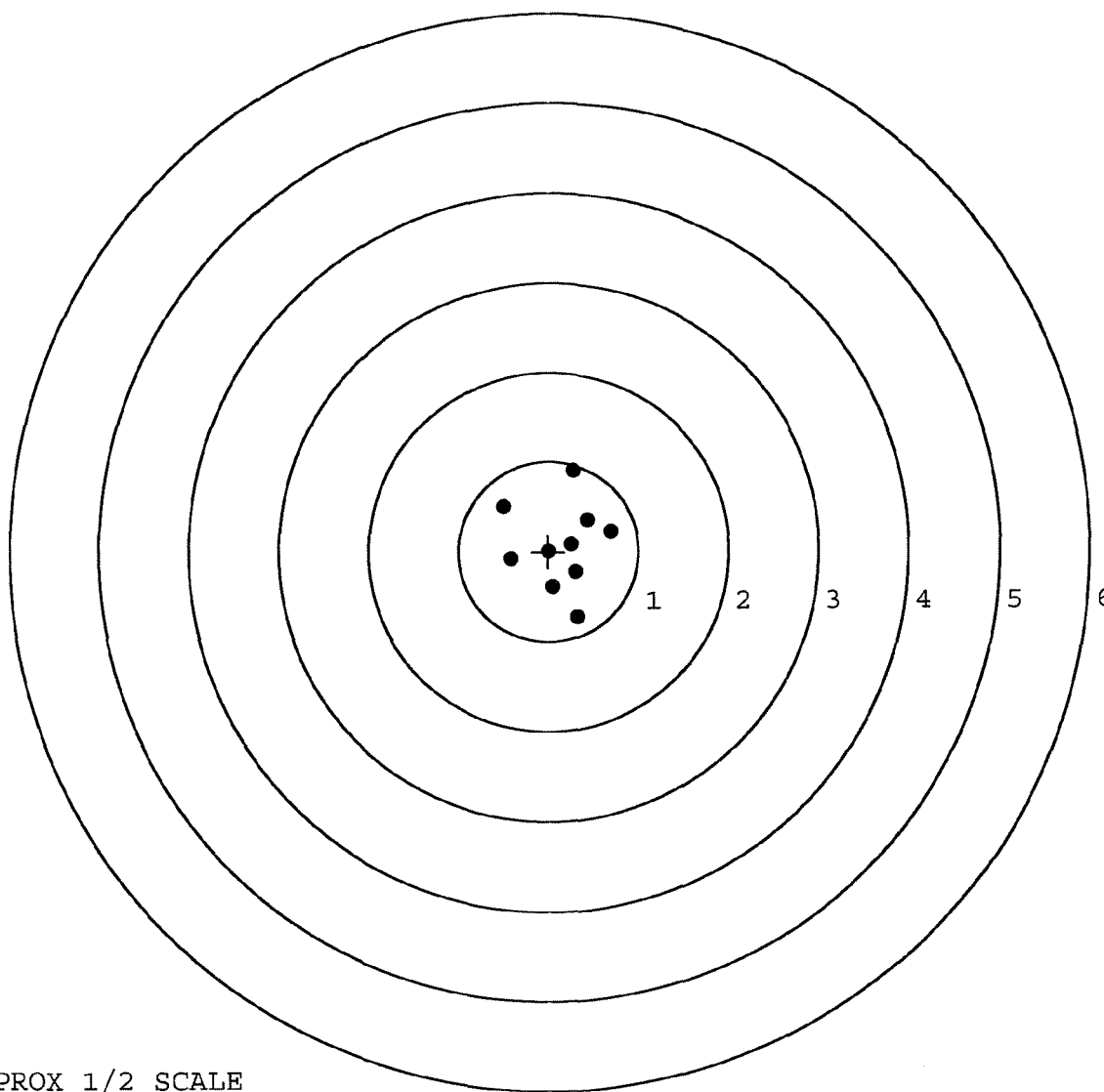
MAX RADIUS: 0.846

MEAN RADIUS: 0.506

IN 1 IN DIAMETER: 5

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in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6296881. __0

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5:	-1.207	0.705
6:	-0.476	0.204
7:	-0.216	-0.130
8:	0.120	-0.111
9:	0.137	0.164
10:	-0.456	-0.590

X CENTROID: 0.087

Y CENTROID: 0.218

POA TO CENTROID: 0.235

HORZ SPREAD: 2.122

VERT SPREAD: 2.947

GROUP SPREAD: 2.951

MIN RADIUS: 0.074

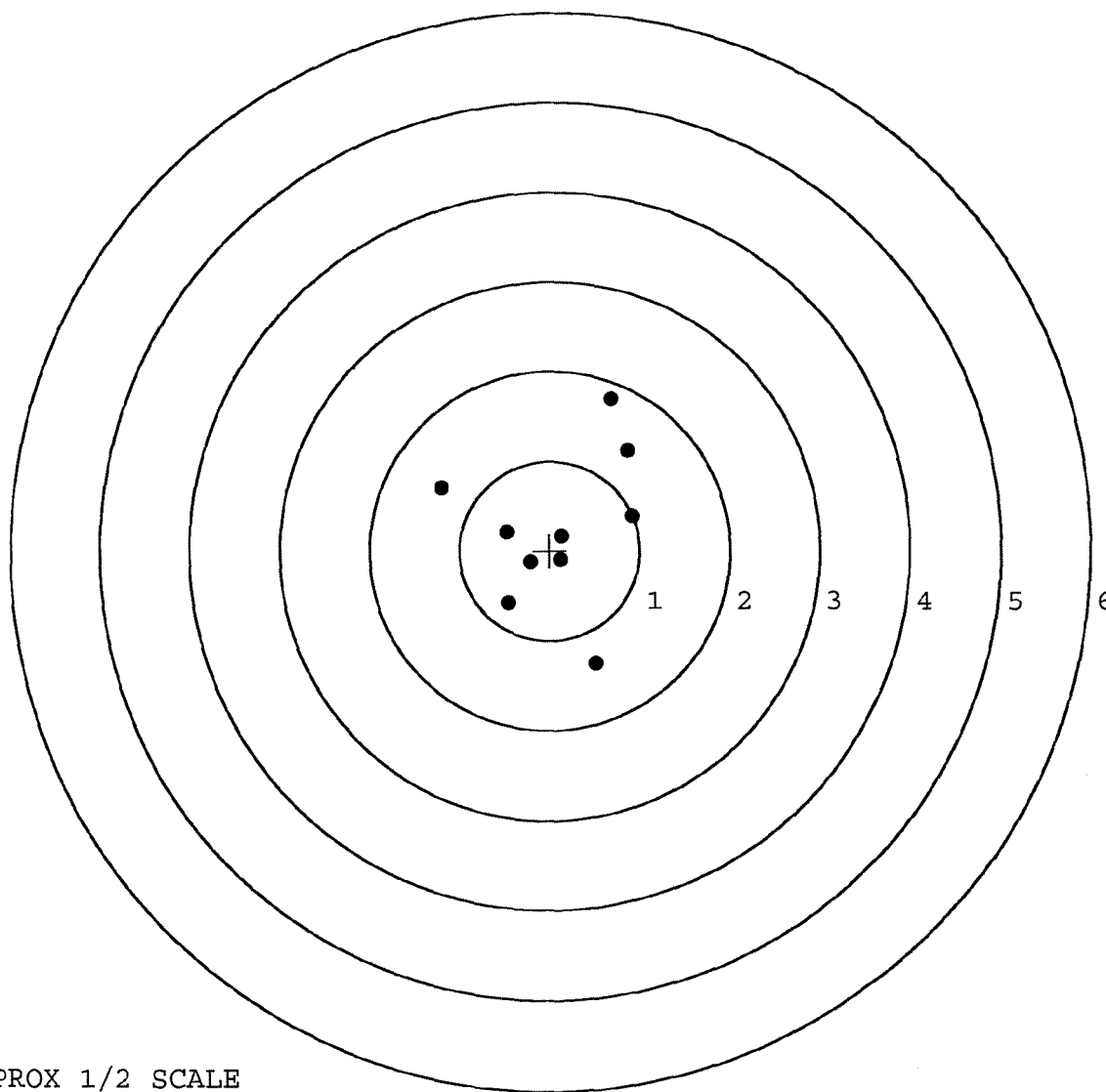
MAX RADIUS: 1.584

MEAN RADIUS: 0.893

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 8



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6296881. __0

TARGET NUMBER: 4

FILE DATE: 10/27/2003

FILE TIME: 11:35

POINT#	X	Y
1:	0.753	-0.304
2:	0.525	-0.411
3:	0.190	-0.720
4:	0.131	-0.285
5:	-0.232	-0.272
6:	-0.314	0.135
7:	-0.042	0.429
8:	0.361	0.303
9:	0.234	0.382
10:	0.039	-0.117

X CENTROID: 0.164

Y CENTROID: -0.086

POA TO CENTROID: 0.186

HORZ SPREAD: 1.067

VERT SPREAD: 1.149

GROUP SPREAD: 1.172

MIN RADIUS: 0.129

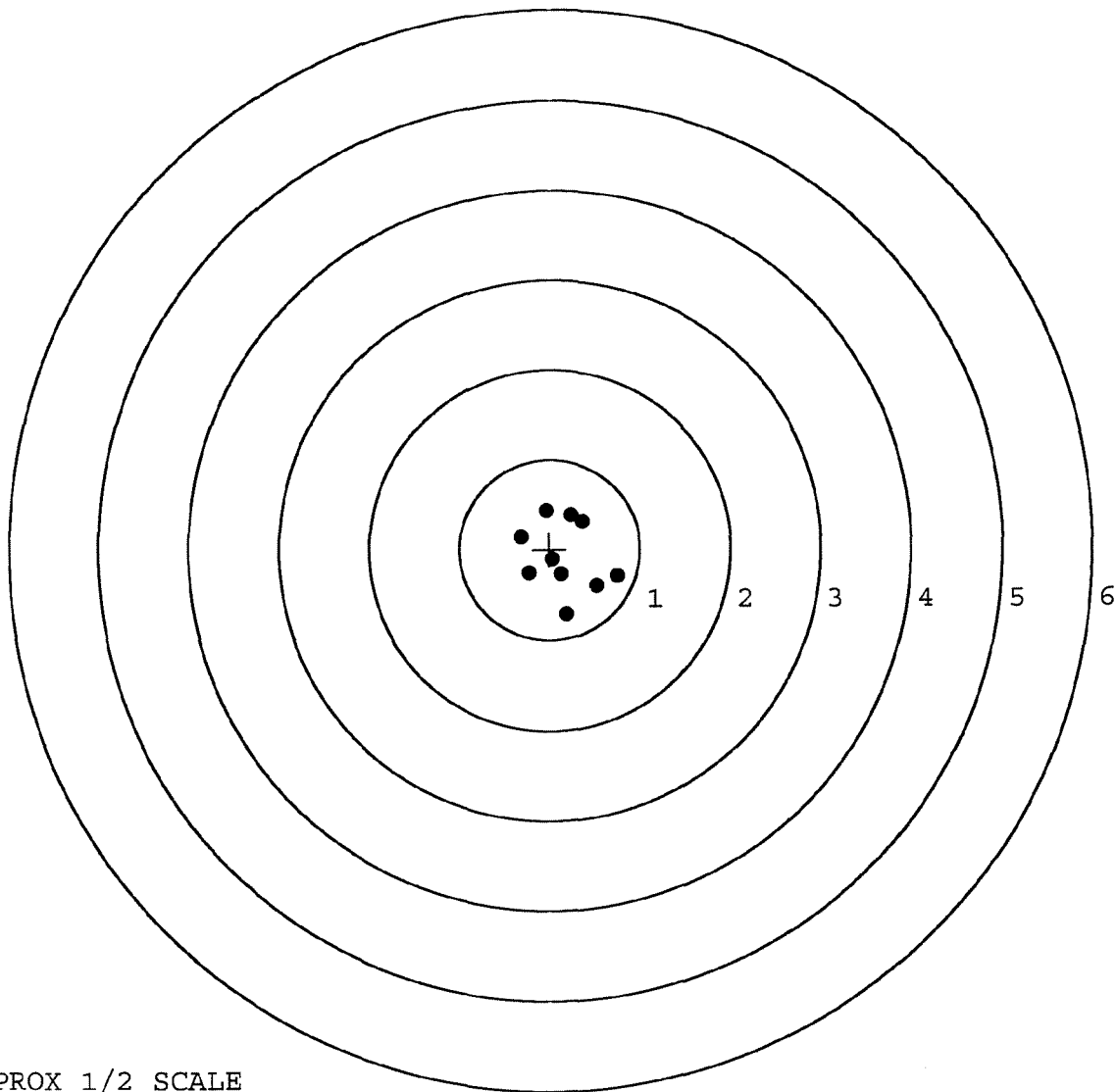
MAX RADIUS: 0.635

MEAN RADIUS: 0.451

IN 1 IN DIAMETER: 6

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6296881. __ 0

TARGET NUMBER: 5

FILE DATE: 10/27/2003

FILE TIME: 11:35

POINT#	X	Y
1:	0.371	-0.091
2:	-0.010	-0.173
3:	-0.082	-0.571
4:	-0.309	0.031
5:	-0.083	0.285
6:	0.239	0.722
7:	-0.473	0.701
8:	-0.768	1.533
9:	-0.914	0.277
10:	-1.934	0.295

X CENTROID: -0.396

Y CENTROID: 0.301

POA TO CENTROID: 0.498

HORZ SPREAD: 2.305

VERT SPREAD: 2.104

GROUP SPREAD: 2.337

MIN RADIUS: 0.284

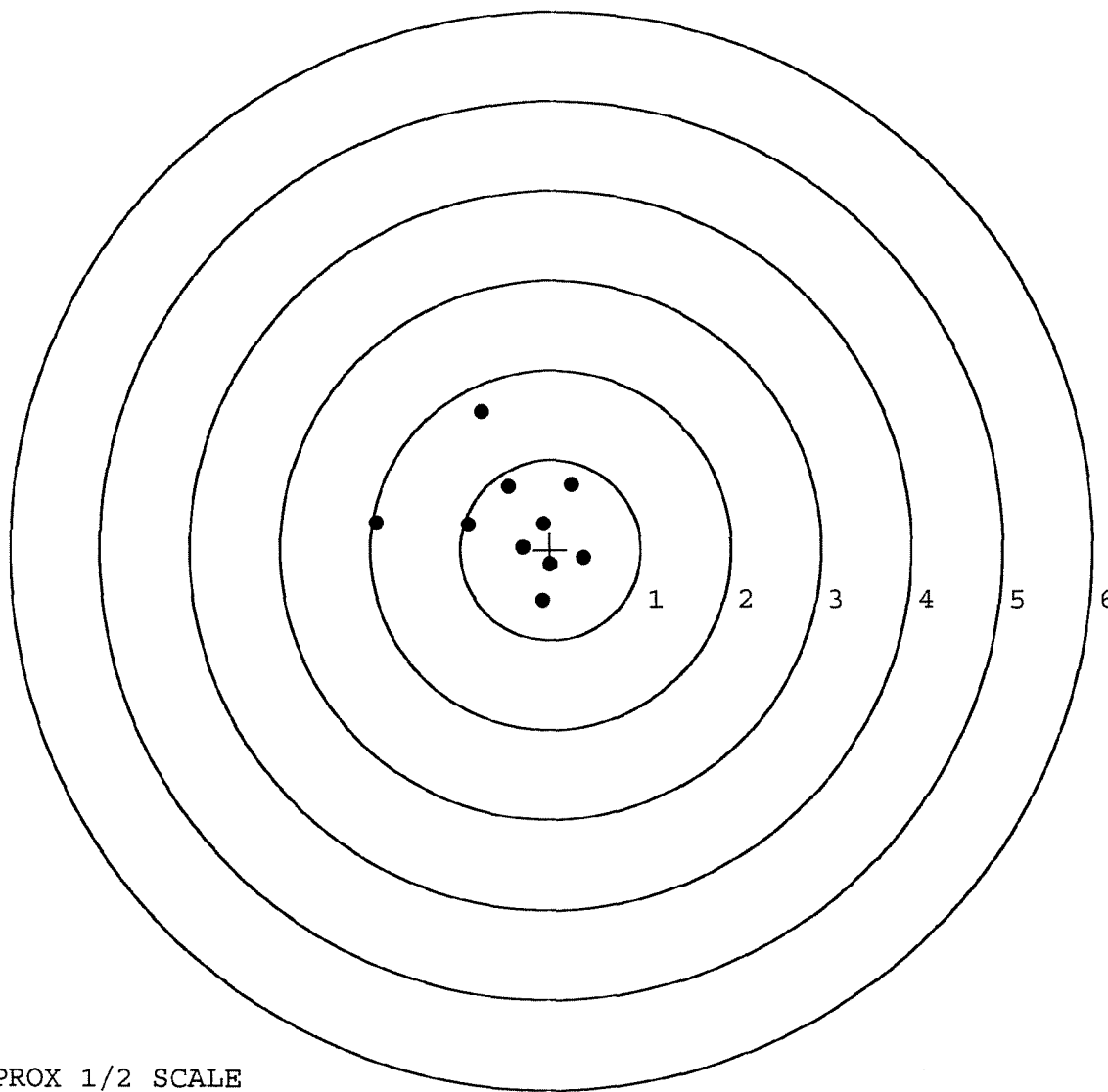
MAX RADIUS: 1.538

MEAN RADIUS: 0.751

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 9



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 6-7-06

TESTER R.P.

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	256	256		253	
PULL #2	250	259		258	
PULL #3	250	262		260	
PULL #4	255	245		258	
PULL #5	256	255		251	
TOTAL	1267	1277		1280	
AVERAGE	253	255		256	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	300	298		
PULL #2	298	298		
PULL #3	299	302		
PULL #4	313	295		
PULL #5	302	292		
TOTAL	1512	1485		
AVERAGE	302	297		

	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	409	412		412
PULL #2	405	414		421
PULL #3	398	398		413
PULL #4	416	410		419
PULL #5	410	413		410
TOTAL	2038	2047		2075
AVERAGE	407	409		415

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

R & E NUMBER	11 3036		Fort Bragg	
SERIAL NUMBER	G6296881 TH			
LOG-IN DATE	5-31-06			
OPERATION #	OPERATION NAME		DATE	INITIAL
500	DIS-ASSEMBLE GUN		6-20-06	AC
505	RE-BARREL		6-21-06	AC
560	ASSEMBLE		6-22-06	AC
600	PROOF	MAGNA-FLUX INSPECTED JUN 27 2006	6-22-06	AC
605	CHECK HEADSPACE		6-22-06	AC
610	DIS-ASSEMBLE GUN		6-22-06	AC
612	MAGNAFLUX	OPERATOR <u>luned</u>	6/27/06	luned
510	DRILL AND TAP		6-26-06	TRC
615	ROLLMARK CALIBER		6-27-06	CW
618	ROTO-BLAST		6-29-06	LB
620	APPLY COATINGS		7/6	HP
625	FINAL ASSEMBLY		7-10-06	AC
640	FUNCTION TEST AND	PASS FAIL	7-11-06	L.P.D.
650	TARGET	PASS FAIL	7-11-06	L.P.D.
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
670	FINAL INSPECTION		7-13-06	AC
	A) HEADSPACE	PASS FAIL	7-13-06	AC
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	7-12-06	DA
		2.23 2.24 2.24 2.36 2.36		
680	F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX	7-12-06	DA
		5.5 5.5 5.5		
	G) SAFETY OFF FORCE	2 LBS MIN	7-12-06	DA
		3.0 3.0 3.0		
	I) FIRING PIN INDENT	.020	7-12-06	DA
		.023 .022 .022		
690	PACK		8-4-06	DA

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6296881.___0
FILE DATE AND TIME: 10/27/2003 11:35

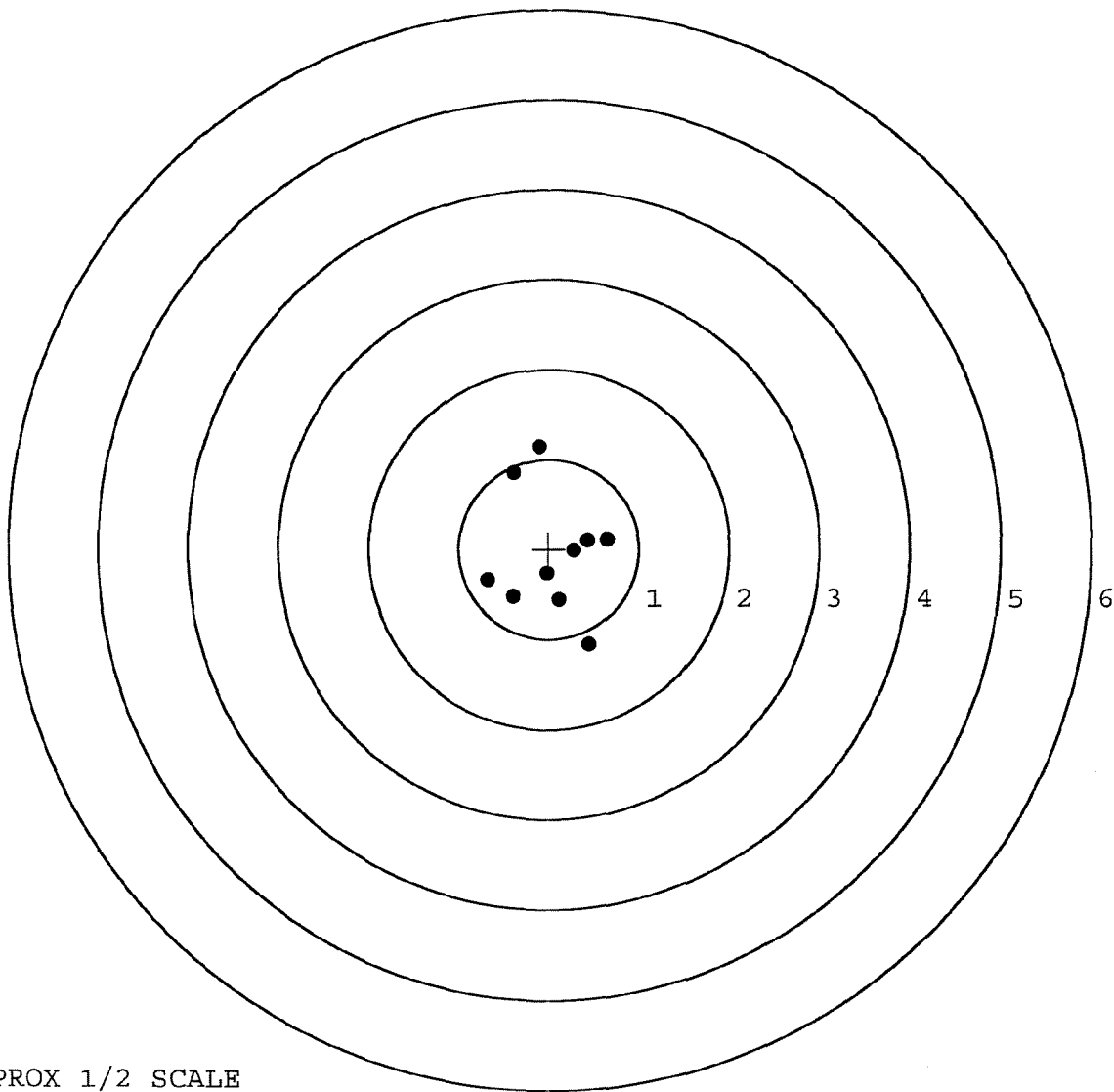
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The Average Y Centroid of the Five Target Set:	0.087
The Average Point of Impact of the Five Target Set:	0.087
The Average Mean Radius of the Five Target Set:	0.656
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The Distance from Centroid Target #3 to Centroid Target #1:	0.284
The Distance from Centroid Target #4 to Centroid Target #1:	0.134
The Distance from Centroid Target #5 to Centroid Target #1:	0.561

SERIAL NUMBER: G6296881. __0
TARGET NUMBER: 1
FILE DATE: 10/27/2003
FILE TIME: 11:35

POINT#	X	Y
1:	0.452	-1.064
2:	0.114	-0.569
3:	-0.399	-0.534
4:	-0.679	-0.348
5:	0.285	-0.020
6:	0.434	0.098
7:	0.648	0.113
8:	-0.390	0.850
9:	-0.114	1.143
10:	-0.022	-0.275

X CENTROID: 0.033
Y CENTROID: -0.061
POA TO CENTROID: 0.069
HORZ SPREAD: 1.327
VERT SPREAD: 2.207
GROUP SPREAD: 2.278
MIN RADIUS: 0.221
MAX RADIUS: 1.213
MEAN RADIUS: 0.677
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6296881.___0

TARGET NUMBER: 2

FILE DATE: 10/27/2003

FILE TIME: 11:35

POINT#	X	Y
1:	0.325	-0.728
2:	0.689	0.223
3:	0.427	0.352
4:	0.279	0.896
5:	-0.503	0.496
6:	-0.417	-0.082
7:	0.304	-0.233
8:	0.048	-0.395
9:	-0.005	0.004
10:	0.256	0.081

X CENTROID: 0.140

Y CENTROID: 0.061

POA TO CENTROID: 0.153

HORZ SPREAD: 1.192

VERT SPREAD: 1.624

GROUP SPREAD: 1.625

MIN RADIUS: 0.117

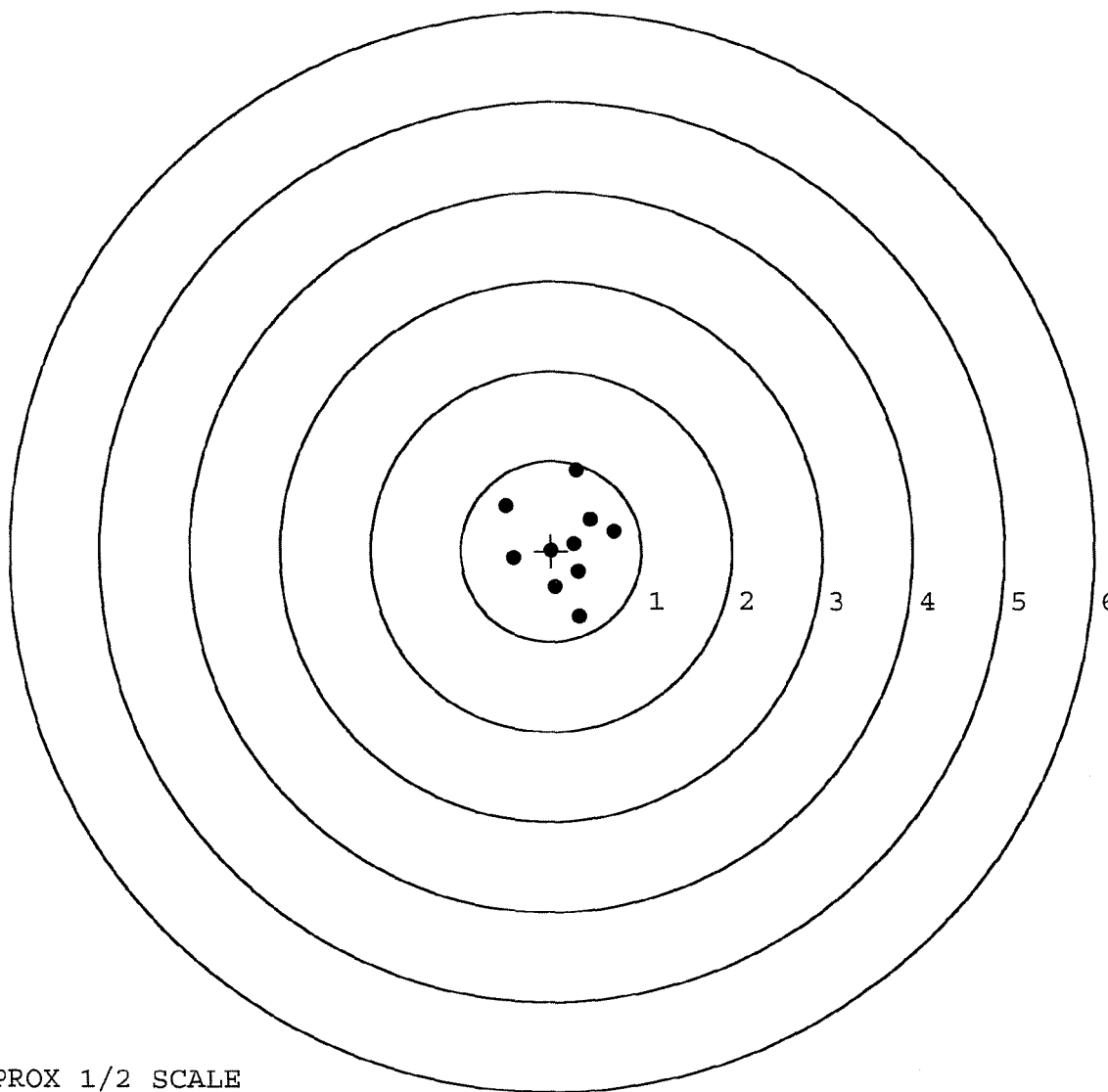
MAX RADIUS: 0.846

MEAN RADIUS: 0.506

IN 1 IN DIAMETER: 5

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TARGET NUMBER: 3

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2:	0.915	0.393
3:	0.854	1.114
4:	0.672	1.690
5:	-1.207	0.705
6:	-0.476	0.204
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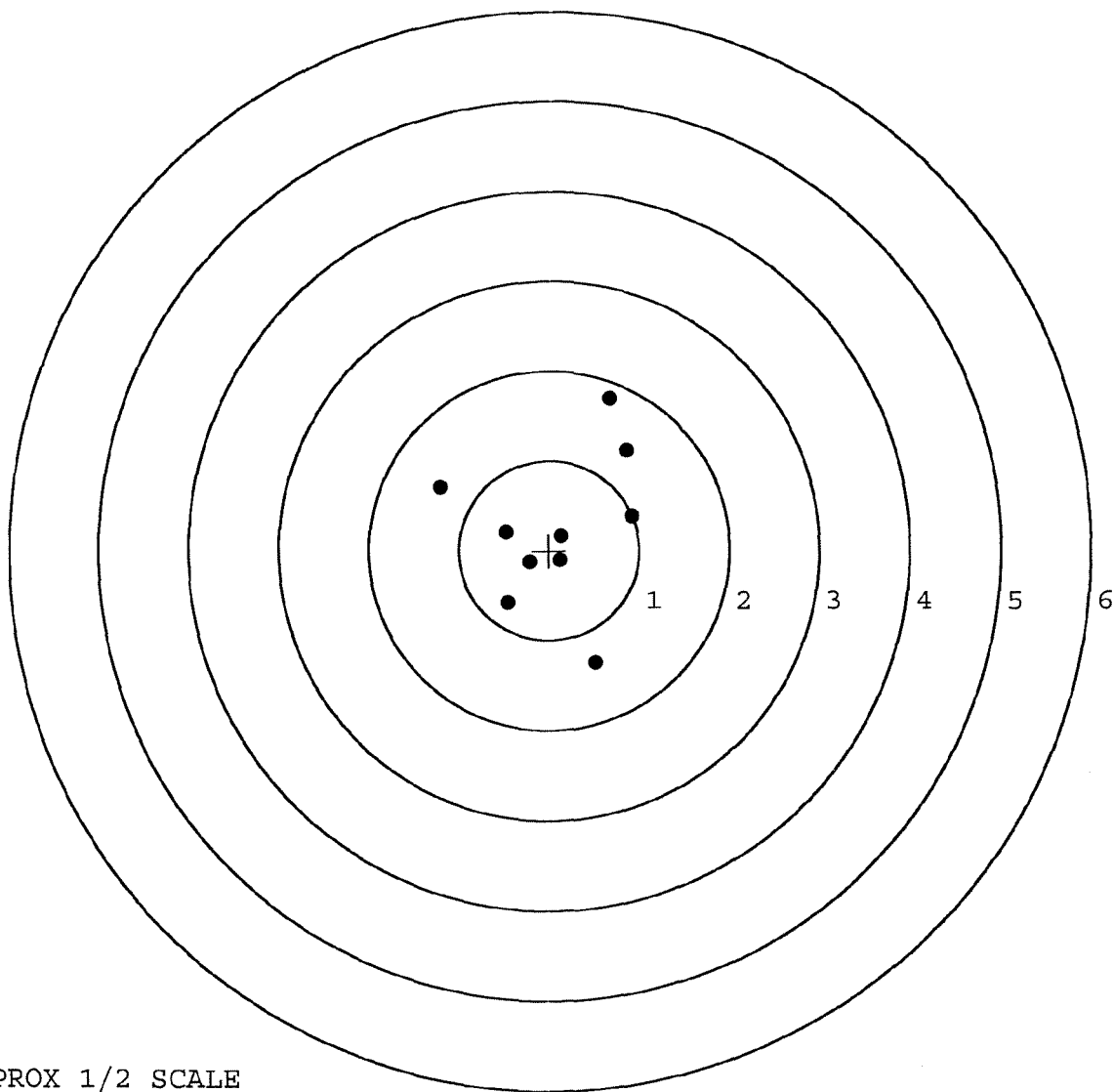
MAX RADIUS: 1.584

MEAN RADIUS: 0.893

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 8



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6296881. __0

TARGET NUMBER: 4

FILE DATE: 10/27/2003

FILE TIME: 11:35

POINT#	X	Y
1:	0.753	-0.304
2:	0.525	-0.411
3:	0.190	-0.720
4:	0.131	-0.285
5:	-0.232	-0.272
6:	-0.314	0.135
7:	-0.042	0.429
8:	0.361	0.303
9:	0.234	0.382
10:	0.039	-0.117

X CENTROID: 0.164

Y CENTROID: -0.086

POA TO CENTROID: 0.186

HORZ SPREAD: 1.067

VERT SPREAD: 1.149

GROUP SPREAD: 1.172

MIN RADIUS: 0.129

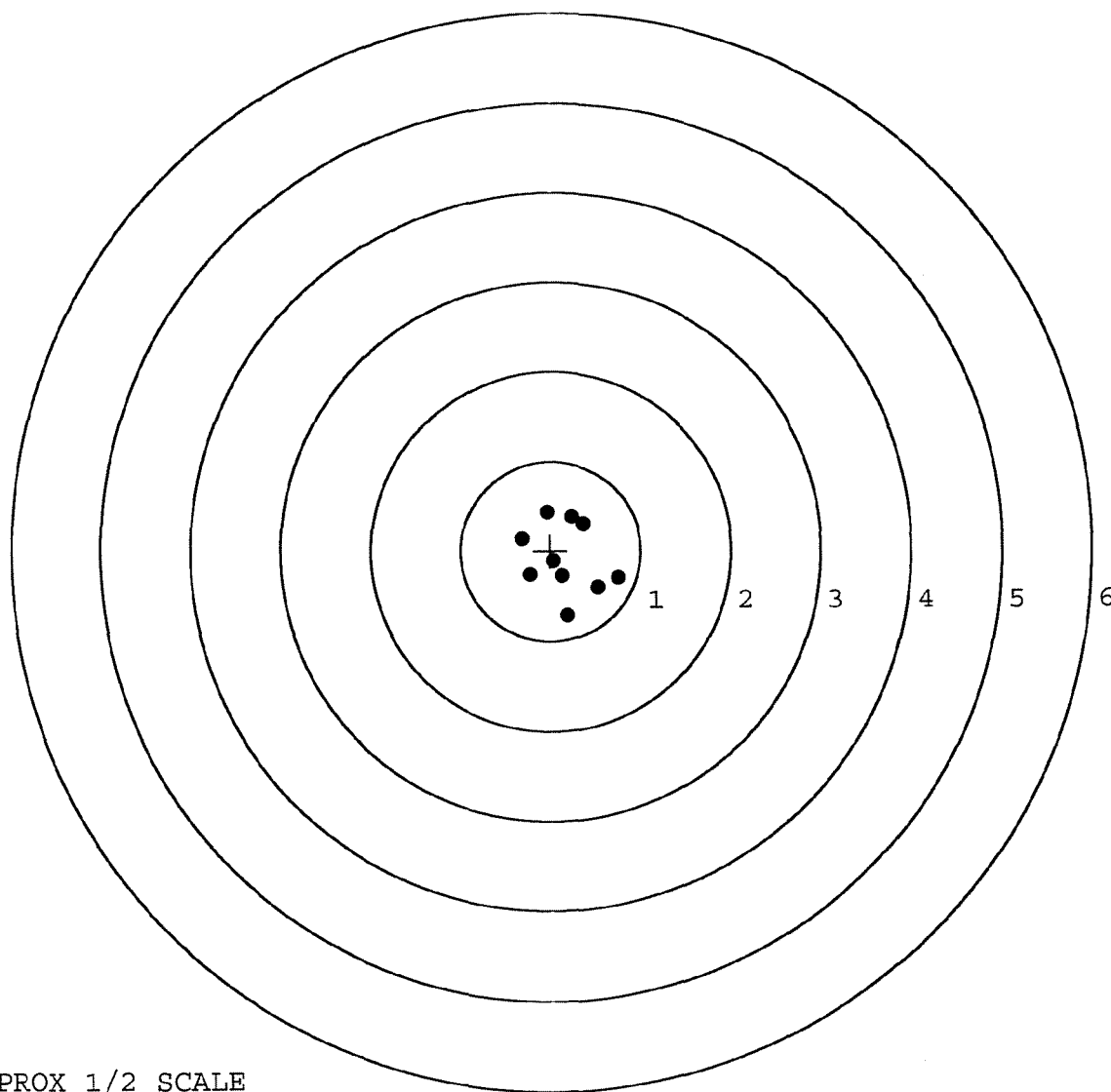
MAX RADIUS: 0.635

MEAN RADIUS: 0.451

IN 1 IN DIAMETER: 6

IN 2 IN DIAMETER: 10

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TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6296881.___0

TARGET NUMBER: 5

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X CENTROID: -0.396

Y CENTROID: 0.301

POA TO CENTROID: 0.498

HORZ SPREAD: 2.305

VERT SPREAD: 2.104

GROUP SPREAD: 2.337

MIN RADIUS: 0.284

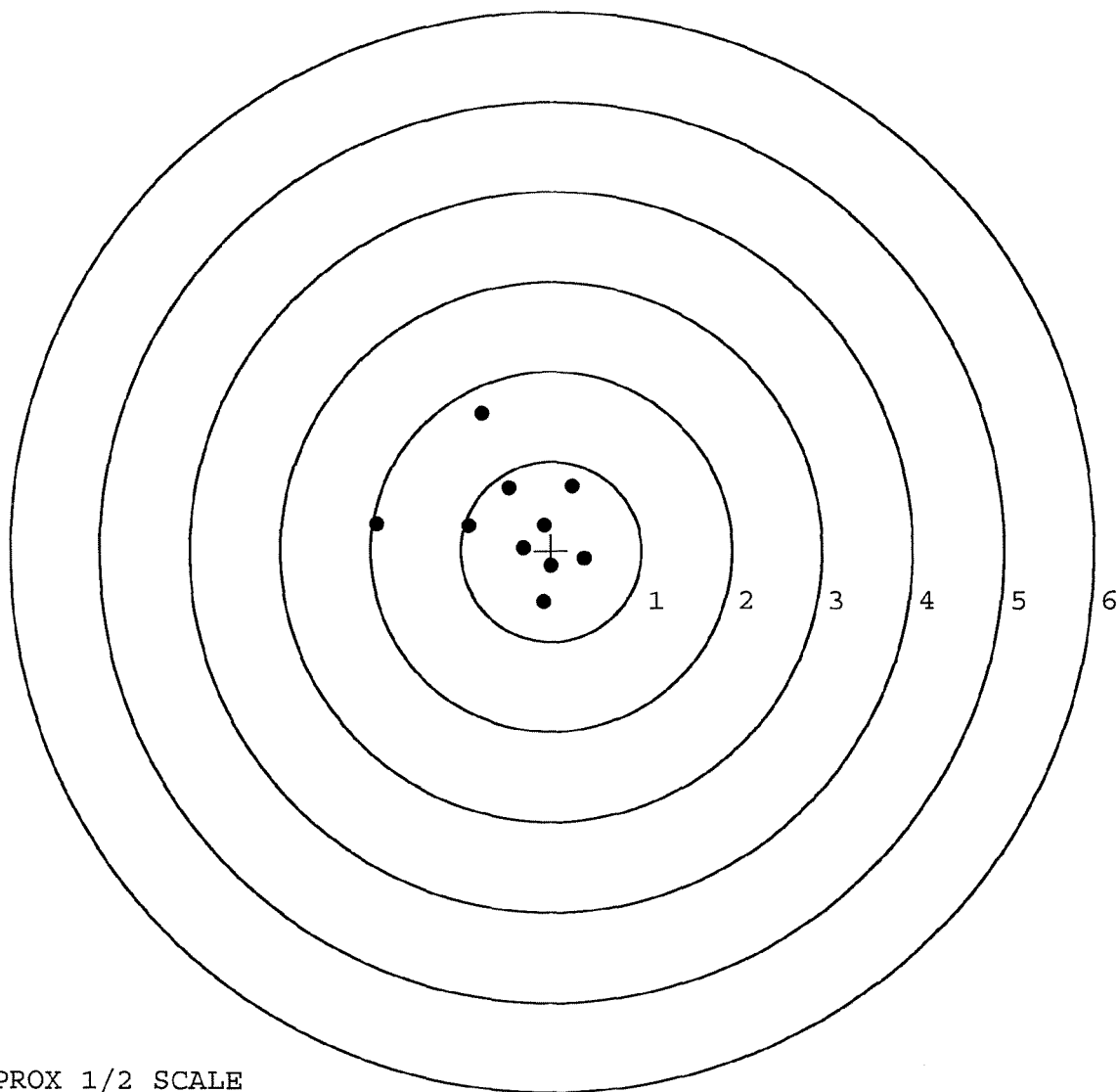
MAX RADIUS: 1.538

MEAN RADIUS: 0.751

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

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

R & E NUMBER	70766		
SERIAL NUMBER	E641-3586 C62910881 (New)		
LOG-IN DATE	9-30-03		
INSPECT AND VERIFY:			
OPERATION #	OPERATION NAME	DATE	INITIAL
550	DIS-ASSEMBLE GUN	10-6-03	RTL
560 A	RE-BARREL	10-8-03	RTL
B	DRILL AND TAP	10-10-03	TRW
575	ASSEMBLE	10-9-03	RTL
600	PROOF	10-9-03	AC
605	CHECK HEADSPACE	10-9-03	AC
610	DIS-ASSEMBLE GUN	10-10-03	RTL
612	MAGNAFLUX		
615	ROLLMARK CALIBER	10-11-03	RTL
618	ROTO-BLAST	10/13/2003	DonS.
620	APPLY COATINGS	10-15	RTL
625 A	FINAL ASSEMBLY	10-24-03	RTL
B	TRIGGER PULL TEST		
C	SAFETY "ON" FORCE		
D	SAFETY "OFF" FORCE		
E	FIRING PIN INDENT		
640	TARGET	10-27-03	AC
655	FINAL INSPECT	10-27-03	RTL
660	PACK	11-28-03	DA
		SHIP DATE	
QAR INSPECTION DATE			