

G6738611
Replaces
E6630945

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: RE00146677

Verify Repair

Serial: E6630945 Model M24 SWS Center Fire
Caliber: 7.62 NATO

Repairman:

Status:

Closed 6/20/2008 8:51:24 AM

Address Information

Customer:

Received From

Return To:

Received From

Name: DEPT OF THE ARMY

DEPT OF THE ARMY

Address 1: HEADQUARTERS AND HEADQUARTERS CO

HEADQUARTERS AND HEADQUARTERS CO

Address 2: 1ST BN 5TH INFANTRY

PO Box:

1ST BN 5TH INFANTRY

PO Box:

City: FORT WRAINWRIGHT

FORT WRAINWRIGHT

State: AK

Zip Code: 99703

Country: US

State: AK

Zip Code: 99703

Country: US

FFL:

Contact / Condition

Problems

Estimate

History / Status

Shipping / Billing

Contact Information

Phone: NN

Fax:

Email:

Comments:

Received Condition

Fair

Condition
Notes:CSR
Notes:

Accessories Received

Code	Desc	Qty
A010	Hard Case	1
A045	Bi Pod	1
A057	Frt and Rear Sgt Base	1
D000	SCOPE & SCOPE BAS	1

Repair Search

Refresh

Close

nagletj

6/20/2008

9:09 AM

CAPS

NUM

INS

SCRL



2 Internet Ex...

3 Microsoft O...

8 Microsoft O...

Arms Services ...

9:09 AM

66738611

Number: **E6630945**

Model: M24 SWS

RE00146677

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6738611.___0

FILE DATE AND TIME: 07/18/2008 12:11

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.073
The Average Y Centroid of the Five Target Set:	-0.134
The Average Point of Impact of the Five Target Set:	0.153
The Average Mean Radius of the Five Target Set:	0.645
The Distance from POA to Centroid Target #1:	0.362
The Distance from Centroid Target #2 to Centroid Target #1:	0.336
The Distance from Centroid Target #3 to Centroid Target #1:	0.285
The Distance from Centroid Target #4 to Centroid Target #1:	0.151
The Distance from Centroid Target #5 to Centroid Target #1:	0.340

SERIAL NUMBER: G6738611. __0

TARGET NUMBER: 1

FILE DATE: 07/18/2008

FILE TIME: 12:11

POINT#	X	Y
1:	0.681	0.087
2:	0.184	0.411
3:	-0.291	0.446
4:	-0.263	0.053
5:	-0.584	-0.040
6:	-0.859	-1.587
7:	0.761	-1.374
8:	-0.217	-0.414
9:	-0.072	-0.478
10:	-0.087	-0.650

X CENTROID: -0.075

Y CENTROID: -0.355

POA TO CENTROID: 0.362

HORZ SPREAD: 1.620

VERT SPREAD: 2.033

GROUP SPREAD: 2.275

MIN RADIUS: 0.123

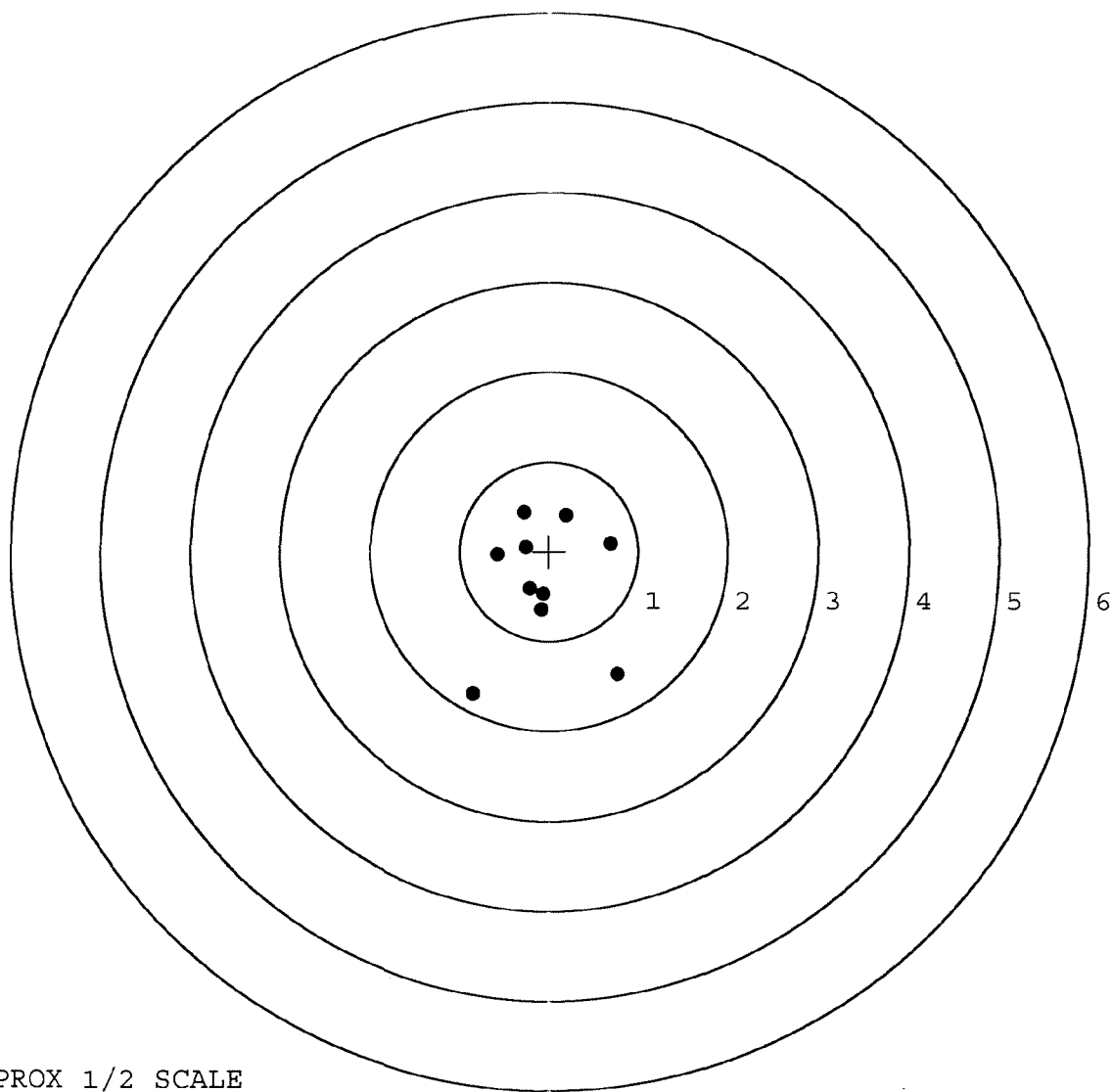
MAX RADIUS: 1.461

MEAN RADIUS: 0.691

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6738611. __0

TARGET NUMBER: 2

FILE DATE: 07/18/2008

FILE TIME: 12:11

POINT#	X	Y
--------	---	---

1:	0.562	1.038
----	-------	-------

2:	0.243	0.724
----	-------	-------

3:	0.301	0.379
----	-------	-------

4:	-0.612	0.666
----	--------	-------

5:	0.248	-0.765
----	-------	--------

6:	0.059	-0.692
----	-------	--------

7:	-0.056	-0.495
----	--------	--------

8:	-0.167	-0.221
----	--------	--------

9:	-0.380	-0.210
----	--------	--------

10:	-0.497	-0.639
-----	--------	--------

X CENTROID: -0.030

Y CENTROID: -0.022

POA TO CENTROID: 0.037

HORZ SPREAD: 1.174

VERT SPREAD: 1.803

GROUP SPREAD: 1.983

MIN RADIUS: 0.242

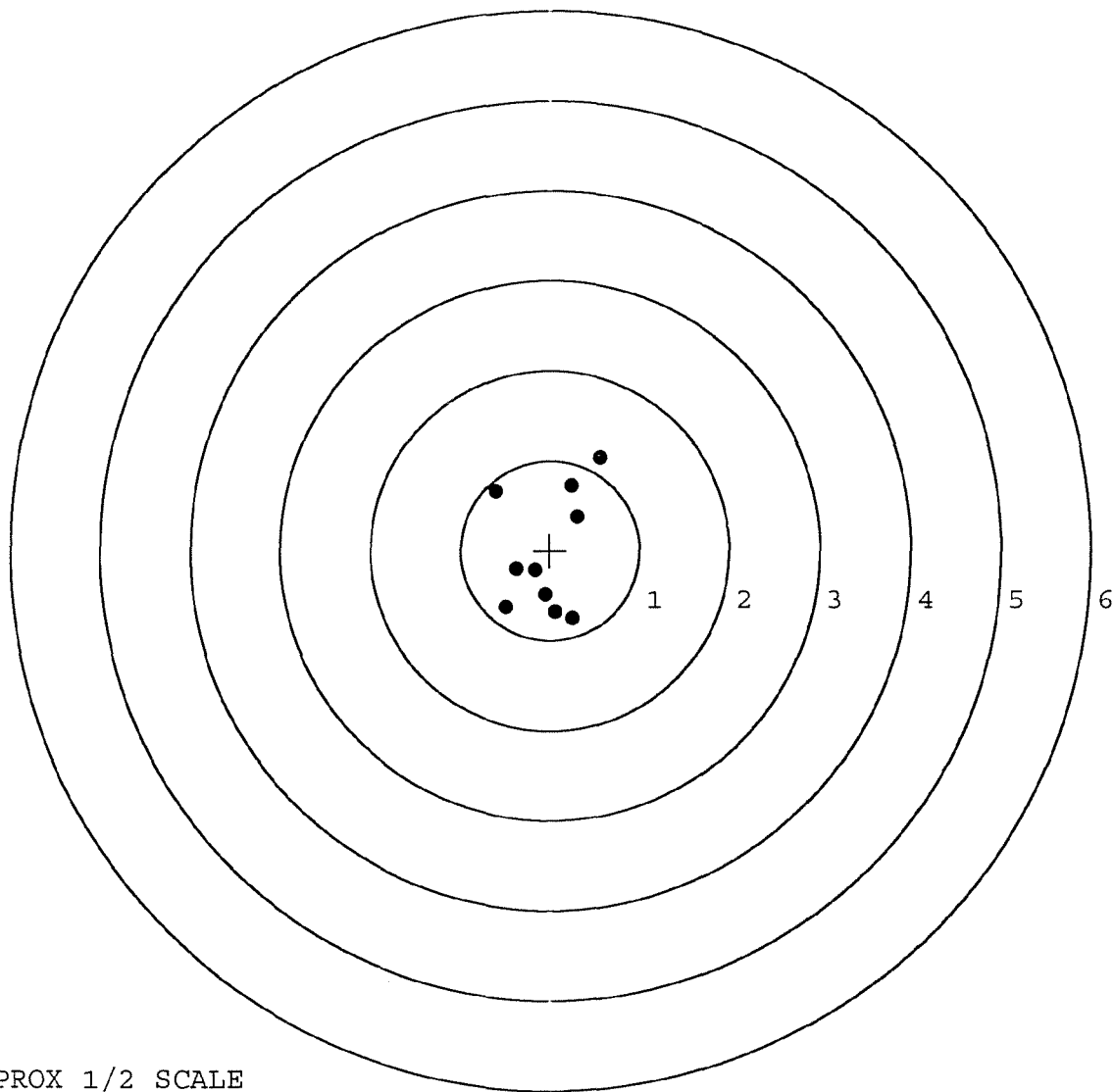
MAX RADIUS: 1.214

MEAN RADIUS: 0.679

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6738611. __0

TARGET NUMBER: 3

FILE DATE: 07/18/2008

FILE TIME: 12:11

POINT#	X	Y
1:	0.217	-0.717
2:	-0.333	-1.055
3:	-0.330	-0.267
4:	-0.809	-0.106
5:	-0.254	0.813
6:	0.213	0.475
7:	0.435	0.243
8:	0.277	-0.094
9:	-0.031	-0.101
10:	-0.050	0.111

X CENTROID: -0.067

Y CENTROID: -0.070

POA TO CENTROID: 0.096

HORZ SPREAD: 1.244

VERT SPREAD: 1.868

GROUP SPREAD: 1.870

MIN RADIUS: 0.047

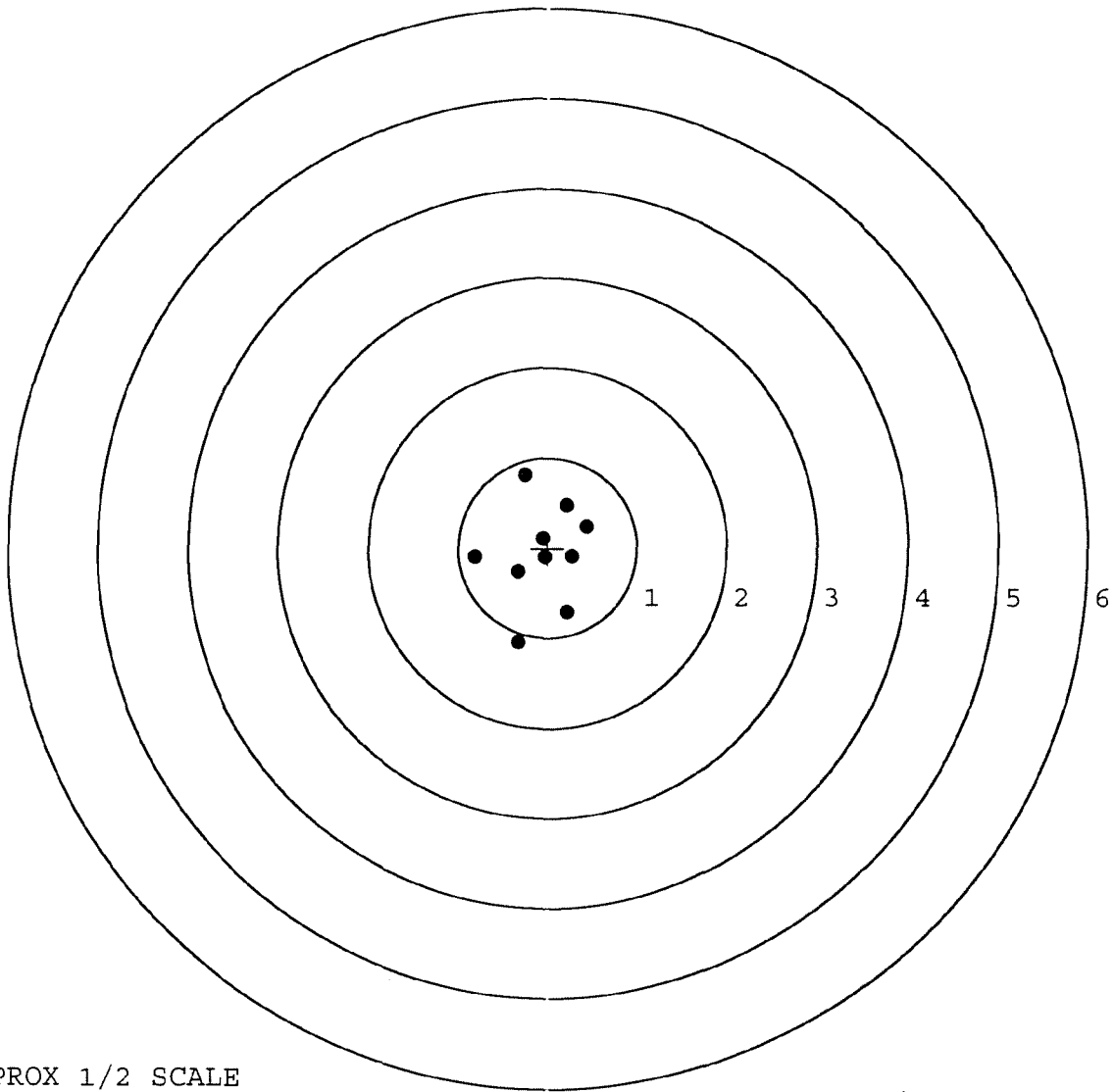
MAX RADIUS: 1.021

MEAN RADIUS: 0.548

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10

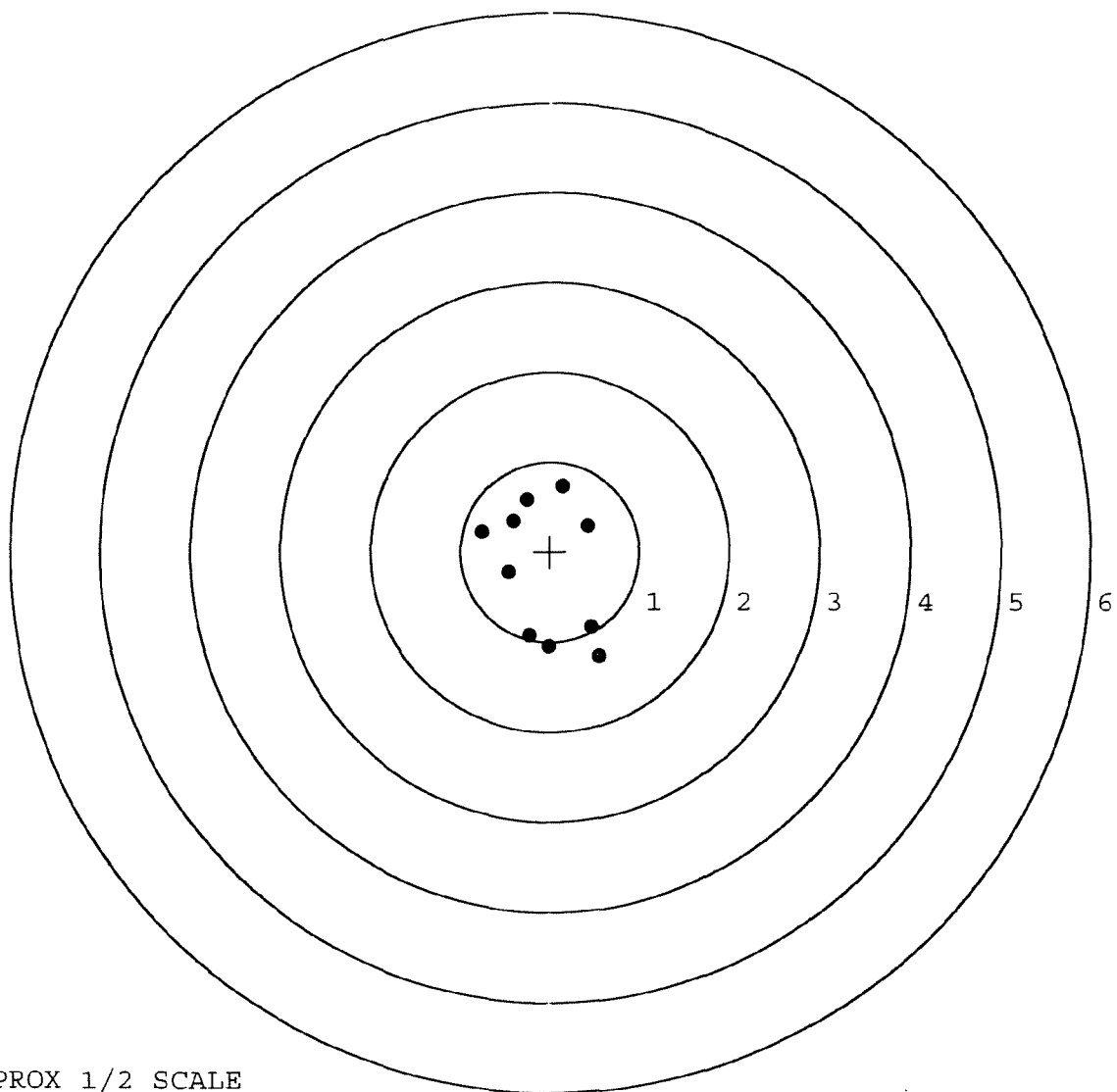


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6738611. __0
TARGET NUMBER: 4
FILE DATE: 07/18/2008
FILE TIME: 12:11

POINT#	X	Y
1:	0.557	-1.157
2:	0.465	-0.836
3:	-0.016	-1.056
4:	-0.238	-0.933
5:	-0.461	-0.229
6:	0.424	0.292
7:	0.142	0.728
8:	-0.263	0.586
9:	-0.417	0.345
10:	-0.765	0.216

X CENTROID: -0.057
Y CENTROID: -0.204
POA TO CENTROID: 0.212
HORZ SPREAD: 1.322
VERT SPREAD: 1.885
GROUP SPREAD: 1.930
MIN RADIUS: 0.405
MAX RADIUS: 1.133
MEAN RADIUS: 0.790
IN 1 IN DIAMETER: 1
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

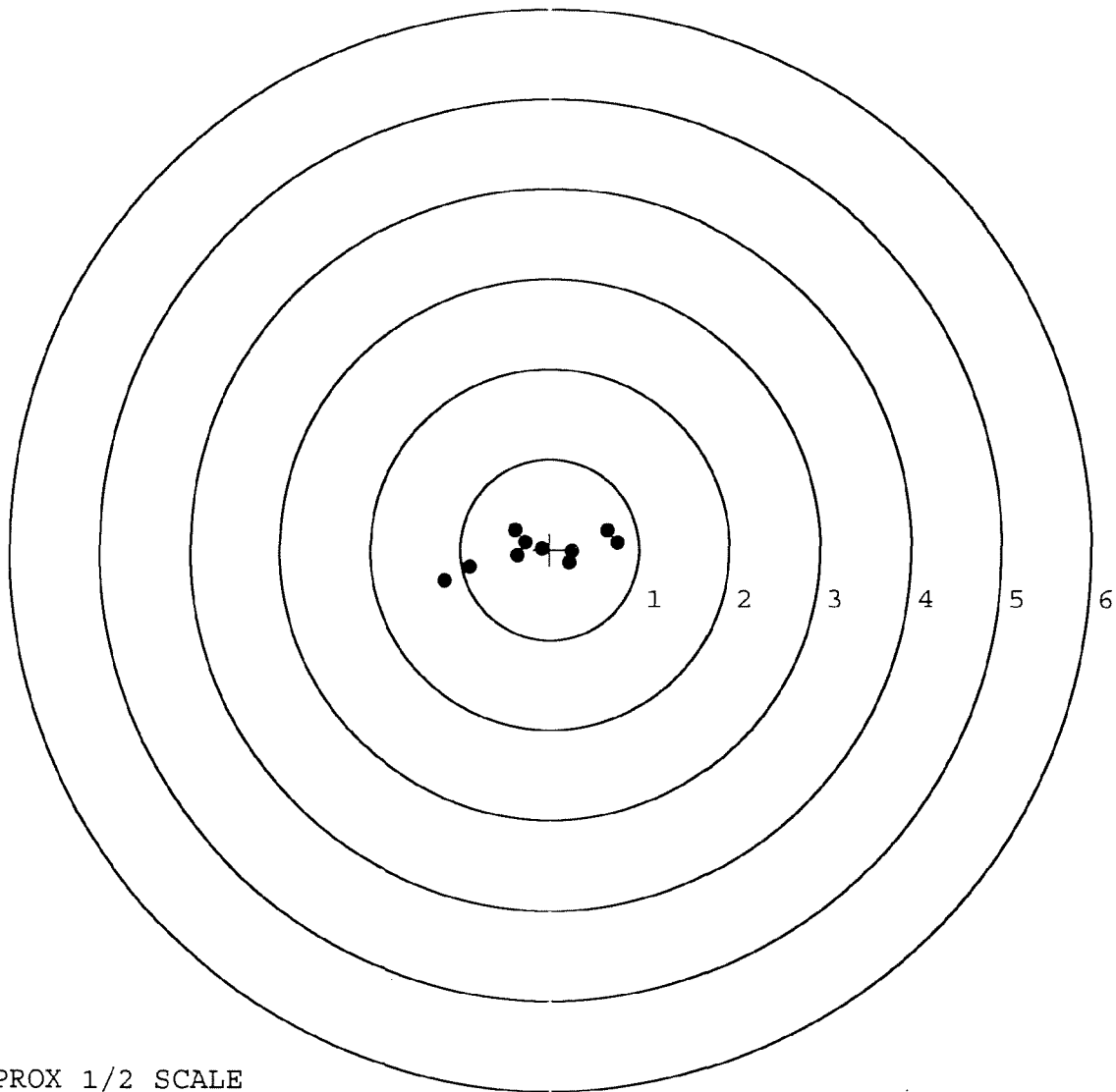


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6738611. __0
TARGET NUMBER: 5
FILE DATE: 07/18/2008
FILE TIME: 12:11

POINT#	X	Y
1:	0.749	0.076
2:	0.634	0.208
3:	0.218	-0.150
4:	0.247	-0.023
5:	-0.089	0.010
6:	-0.394	0.220
7:	-0.369	-0.069
8:	-0.899	-0.199
9:	-1.174	-0.353
10:	-0.280	0.082

X CENTROID: -0.136
Y CENTROID: -0.020
POA TO CENTROID: 0.137
HORZ SPREAD: 1.923
VERT SPREAD: 0.573
GROUP SPREAD: 1.970
MIN RADIUS: 0.055
MAX RADIUS: 1.090
MEAN RADIUS: 0.515
IN 1 IN DIAMETER: 6
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

INSPECTION CHECKLIST - REPAIRS
CONTRACT #: W52H09-07-C-0207

R & E NUMBER	146677		
SERIAL NUMBER	E6630945	G6738611	
LOG-IN DATE	6-25-08 6-20-08		

OPERATION #	OPERATION NAME	DATE	INITIAL
500	DIS-ASSEMBLE GUN	6-25-08	RSW
505	RE-BARREL		
420	ASSEMBLE	6-25-08	RSW
440	PROOF	6-25-08	SD
460	CHECK HEADSPACE	6-25-08	SD
470	DIS-ASSEMBLE GUN	6-25-08	RP
480	MAGNAFLUX	7-10-08	BTJ
510	DRILL AND TAP	7-7-08	TRW
500	ROLLMARK CALIBER	7/9/08	
520	GOFF BLAST BBL / REC	7-11-08	DG
530 & 540	APPLY COATINGS	7-15	CM
560	FINAL ASSEMBLY	7-17-08	RTZ
640	FUNCTION TEST AND	(PASS) FAIL	7-18-08 TRW
650	TARGET	(PASS) FAIL	7-18-08 TRW
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
670	FINAL INSPECTION	7-18-08	MEB
	A) HEADSPACE	(PASS) FAIL	7-21-08 RTZ
	B) TRIGGER PULL	285 282 282 284 287 7-21-08	RTZ
680	F) SAFETY ON FORCE	6 6 6 7-21-08	RTZ
	G) SAFETY OFF FORCE	3 3 3 7-21-08	RTZ
	I) FIRING PIN INDENT	021 0215 021 7-21-08	RTZ
690	PACK	7/23/08	Fm

F006 REV 5/2006

Remington®

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

MODEL 700TM M24
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO

SERIAL NO. **E6630945**

ORDER NO. **25716**

Made in Ilion, NY Reg. U.S. Pat. & tm. Off. Marca Registrada Marque Deposee.



5716 E6630945

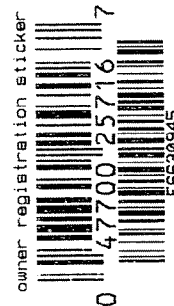
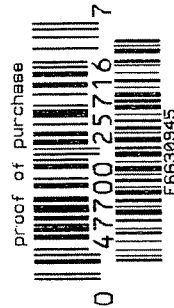
29EV

MODEL 700TH M24
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO

DOCUMENT ENVELOPE ASSEMBLY:

- INSTRUCTION BOOK
- PRODUCT OWNER'S CARD
- SAFETY BOOKLET

46 FORM 1444

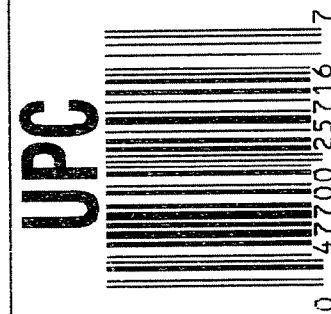


ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

E6630945



47700 25716

ORDER 25716

MODEL 700™ M24

UPC



0 47700 25716 7

ORDER 25716

MODEL 700™ M24

UPC



0 47700 25716 7

UPC

UPC

UPC

SERIAL NO.



E6630945

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

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

SERIAL NO. E6630945

DATE 9-14-01

TESTER DA

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	251	257		257	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	247	247		255	
PULL #3	248	246		249	
PULL #4	253	251		247	
PULL #5	255	254		249	
TOTAL	1254	1255		1257	
AVG.	250	251		251	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	313	302		
PULL #2	307	311		
PULL #3	314	310		
PULL #4	316	306		
PULL #5	316	309		
TOTAL	1566	1538		
AVG.	3.13	3.07		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	406	4.17		4.09
PULL #2	411	4.07		4.17
PULL #3	407	4.14		4.15
PULL #4	414	4.09		4.19
PULL #5	414	4.06		4.11
TOTAL	2052	2053		2071
AVG.	4.10	4.10		4.14

Remington Test Lab, Ilion, N.Y.

Centroidal distance calculations for Rifle # E6630945
11 Sep 2001

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1952
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.2052
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .283214

THE AMR FOR THIS RIFLE IS: 1.307

CENTROIDAL DISTANCES

0 TO	1	.298304
1 TO	2	.255225
1 TO	3	.131712
1 TO	4	.497845
1 TO	5	.55211

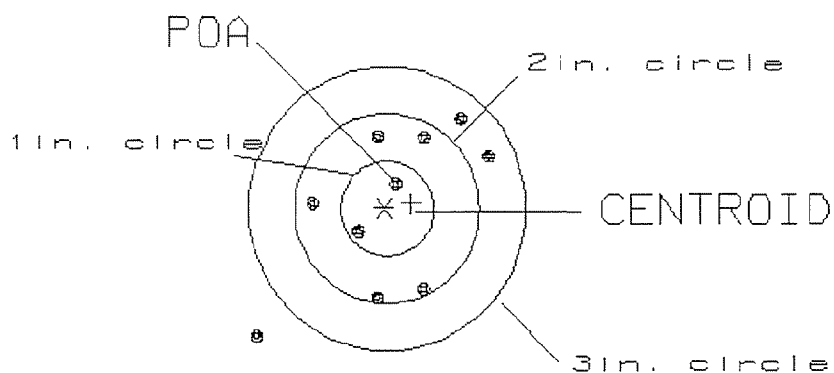
2 1³ + <----POA
4
5

PATTERN #: ☐ 1 ☐
 POA TO CENTROID: .298
 MIN RADIUS : .282
 MEAN RADIUS : .928
 MAX RADIUS : 1.924
 CENTROID X : -.293
 CENTROID Y : -.056

11 Sep 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/E6630945

CENTERFIRE PATTERN # 1



OF SHOTS= 10

IN CIRCLE

HS= 2.51

2

VS= 2.26

7

GS= 3.14

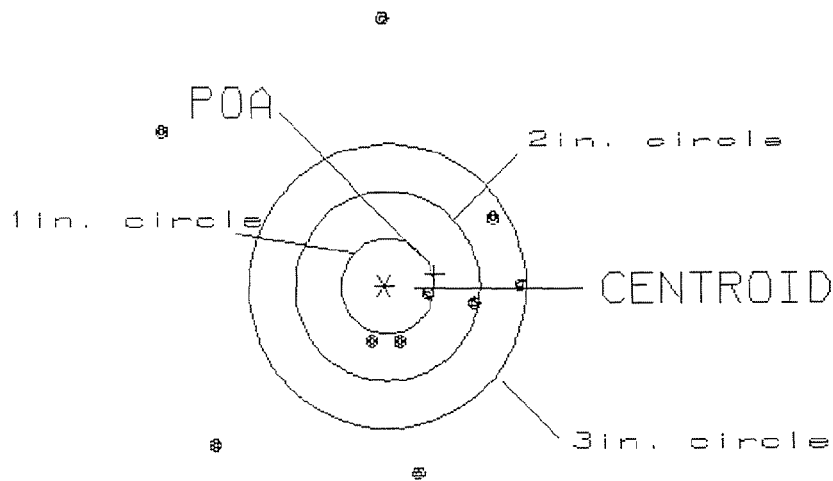
9

PATTERN #: 2
 POA TO CENTROID: .553
 MIN RADIUS : .412
 MEAN RADIUS : 1.557
 MAX RADIUS : 2.904
 CENTROID X : -.539
 CENTROID Y : -.124

11 Sep 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/E6630945

CENTERFIRE PATTERN # 2



OF SHOTS= 10

IN CIRCLE

HS= 3.87

1

VS= 4.79

4

GS= 4.81

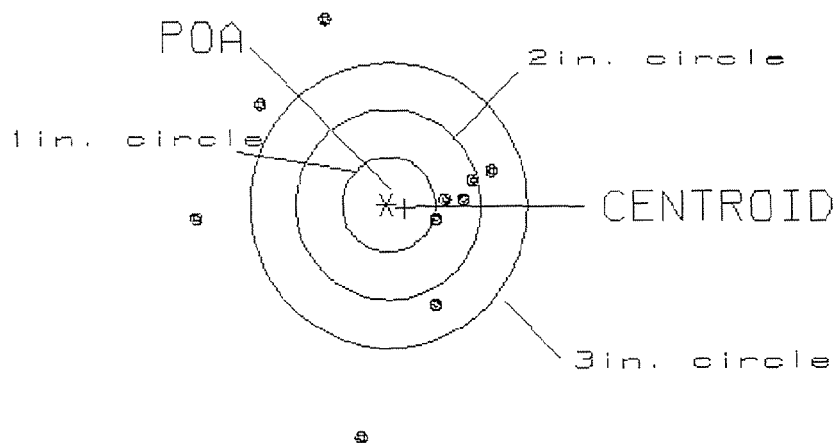
6

PATTERN #: ☐ 3 ☐
 POA TO CENTROID: .209
 MIN RADIUS : .470
 MEAN RADIUS : 1.357
 MAX RADIUS : 2.501
 CENTROID X : -.205
 CENTROID Y : .042

11 Sep 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/E6630945

CENTERFIRE PATTERN # 3



OF SHOTS= 10

IN CIRCLE

HS= 3.21
 VS= 4.47
 GS= 4.49

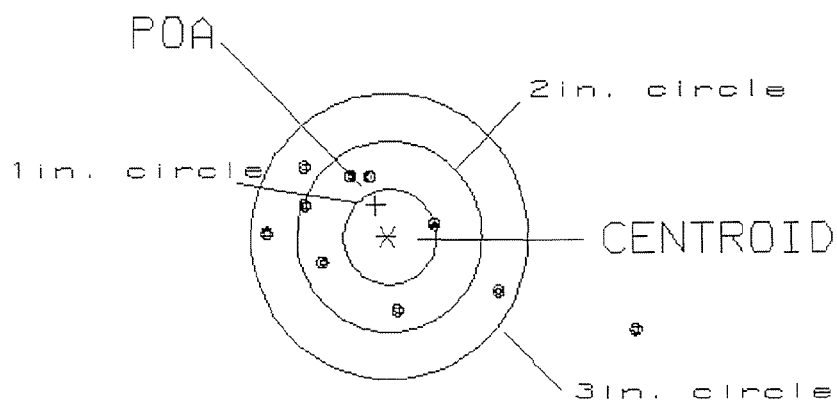
1
 4
 5

PATTERN #: ☐ 4 ☐
 POA TO CENTROID: .353
 MIN RADIUS : .508
 MEAN RADIUS : 1.110
 MAX RADIUS : 2.877
 CENTROID X : .122
 CENTROID Y : -.331

11 Sep 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/E6630945

CENTERFIRE PATTERN # 4



OF SHOTS= 10

IN CIRCLE

HS= 4.08

0

VS= 1.70

6

GS= 4.20

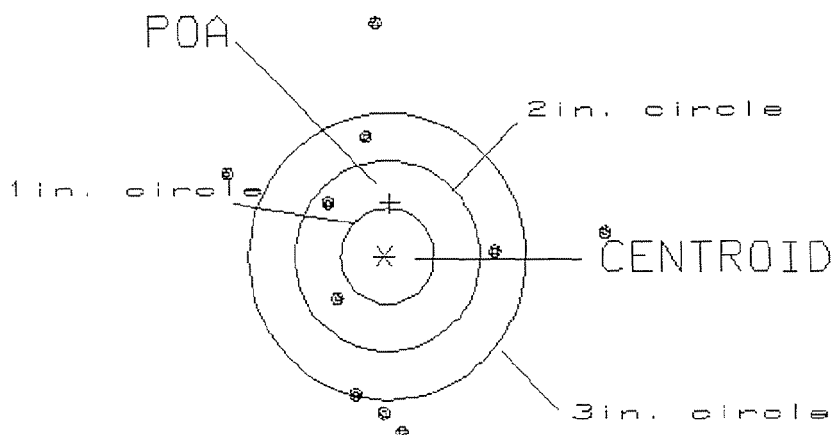
9

PATTERN #: ☐ 5 ☐
 POA TO CENTROID: .560
 MIN RADIUS : .712
 MEAN RADIUS : 1.581
 MAX RADIUS : 2.463
 CENTROID X : -.061
 CENTROID Y : -.557

11 Sep 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/E6630945

CENTERFIRE PATTERN # 5



OF SHOTS= 10

IN CIRCLE

HS= 4.10

0

VS= 4.29

2

GS= 4.30

4

CONTRACT #

GUN SERIAL # E6630 945

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		9-10-01	eth
600	PROOF		9-10-01	eth
607	CHECK HEADSPACE		9-10-01	eth
610	DIS-ASSEMBLE GUN		9-10-01	eth
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT		9-10-01	AE
615	ROLLMARK CALIBER		9-10-01	eth
617	DRILL AND TAP SIGHT HOLES		9-10-01	BWF
618	POLISH BARREL		9-10-01	GD
620	APPLY COATINGS (BARREL ACTION)		9-10-01	HT
	(BOLT)		9-10-01	HT
625	FINAL ASSEMBLY			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		9-11-01	eth
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		9-11-01	eth
	C) INSPECT EJECTOR HOLE FOR CHAMFER		9-11-01	eth
	D) OIL FIRING PIN ASSEMBLY		9-11-01	eth
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE		9-11-01	eth

OP #	OPERATION NAME	READINGS	DATE	INITIAL
625	F) SAFETY ON FORCE	<u>6.2</u> <u>55</u> <u>6.2</u>	10/26/01	DA
CONT.	G) SAFETY OFF FORCE	<u>2.5</u> <u>3.2</u> <u>3.2</u>	10/26/01	DA
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT	<u>0.22</u> <u>0.23</u> <u>0.22</u>	10/26/01	DA
	J) ASSEMBLE STOCK		9-10-01	DA
	K) ASSEMBLE SWIVEL STUDS		10-26-01	DA
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		10-26-01	DA
	M) IRON SIGHT ALIGNMENT		10-26-01	DA
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		10-26-01	DA
640	GALLERY TEST AND TARGET		9/11	DA
	A) MALFUNCTIONS		9/11	DA
	B) PIERCED PRIMERS		9/11	DA
645	INSPECT FOR LIVE AMMO		9/11	DA
655	FINAL INSPECTION A) HEADSPACE		10-26-01	DA
	B) TRIGGER PULL	<u>2.39</u> <u>2.37</u> <u>2.33</u> <u>2.38</u> <u>2.37</u>	10/26/01	DA
	C) FUNCTION		10-26-01	DA
660	PACK		10-26-01	DA