

C6594565

MODEL 700™ M24

Model **SWS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

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: **RE00119826**

Serial: C6594565 Model M24 SWS Center Fire
Caliber: 7.62 NATO

Repairman:

Status:

Closed 11/6/2006 7:41:47 AM

Address Information

Customer:

☒ Received From

Return To:

☐ Received From

Name: FB4497 TMO 436 APS/TRT

FB4497 TMO 436 APS/TRT

Address 1: 505 ATLANTIC ST BLDG 505

505 ATLANTIC ST BLDG 505

Address 2: PO Box:

PO Box:

City: DOVER AFB

DOVER AFB

State: DE Zip Code: 19902

Country: US

State: DE Zip Code: 19902

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
A010	Hard Case	1
A017	Scope Base	1
A026	Scope	1
A055	Deployment Kit	1
A057	Fit and Rear Sgt Base	1
D000	NIGHT SCOPE	1

Repair Search

Refresh

Close

nagletj

11/6/2006

8:06 AM

CAPS

NUM

INS

SCRL



Serial Number: **C6594565**

Model: **M24 SWS**



RE00119826

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

R & E NUMBER	119826		
SERIAL NUMBER	C6594565		
LOG-IN DATE	11-6-06		
OPERATION #	OPERATION NAME	DATE	INITIAL
500	DIS-ASSEMBLE GUN	11-6-06	RTZ
505	RE-BARREL	11-7-06	RTZ
420	ASSEMBLE	11-7-06	RTZ
440	PROOF	11-7-06	RTZ
460	CHECK HEADSPACE	11-7-06	RTZ
470	DIS-ASSEMBLE GUN	11-7-06	RTZ
480	MAGNAFLUX		
510	DRILL AND TAP	11-9-06	RTZ
500	ROLLMARK CALIBER	11-10-06	RTZ
520	GOFF BLAST BBL / REC	11-15-06	RTZ
530 & 540	APPLY COATINGS	11-15-06	RB
560	FINAL ASSEMBLY	11-16-06	RTZ
640	FUNCTION TEST AND	(PASS) FAIL	11-16-06 TRW
650	TARGET	(PASS) FAIL	11-16-06 TRW
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	11-16-06 SDC
670	FINAL INSPECTION		
	A) HEADSPACE	PASS FAIL	
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	2.36 2.36 2.35 2.35 2.34 12-1-06 DA
680	F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX	5.5 5.0 5.0 12-1-06 DA
	G) SAFETY OFF FORCE	2 LBS MIN	2.5 2.2 2.2 12-1-06 DA
	I) FIRING PIN INDENT	.020	.021 .022 .021 12-1-06 DA
690	PACK		12-6-06 DA

F006 REV 5/2006

FINAL INSPECTION CHECKLIST

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

F006 REV 5/2006

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6594565.___0
FILE DATE AND TIME: 03/14/2005 09:27

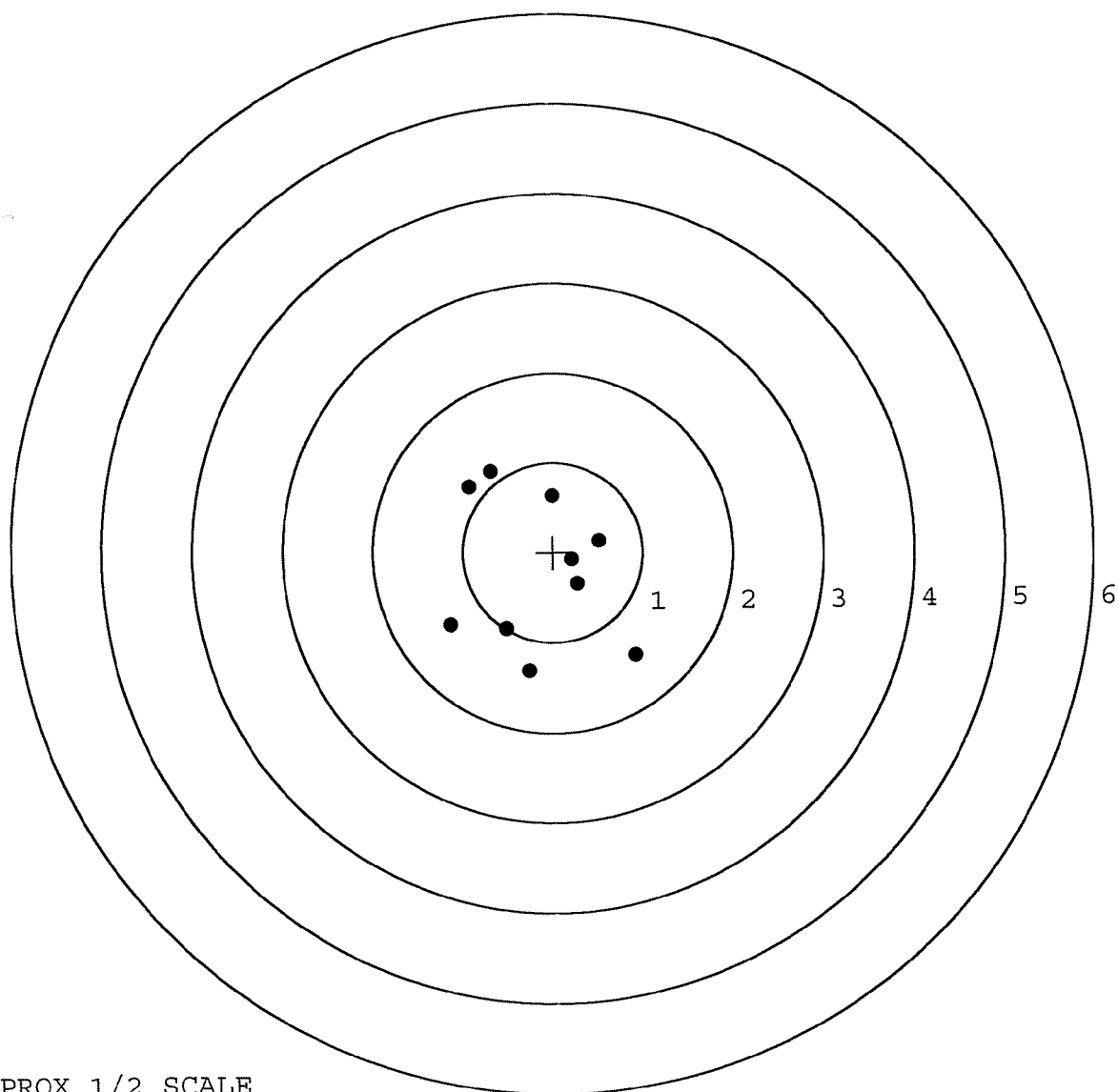
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.047
The Average Y Centroid of the Five Target Set:	-0.166
The Average Point of Impact of the Five Target Set:	0.173
The Average Mean Radius of the Five Target Set:	0.826
The Distance from POA to Centroid Target #1:	0.272
The Distance from Centroid Target #2 to Centroid Target #1:	0.242
The Distance from Centroid Target #3 to Centroid Target #1:	0.021
The Distance from Centroid Target #4 to Centroid Target #1:	0.119
The Distance from Centroid Target #5 to Centroid Target #1:	0.362

SERIAL NUMBER: C6594565. __0
TARGET NUMBER: 1
FILE DATE: 03/14/2005
FILE TIME: 09:27

X CENTROID: -0.165
Y CENTROID: -0.216
POA TO CENTROID: 0.272
HORZ SPREAD: 2.053
VERT SPREAD: 2.231
GROUP SPREAD: 2.628
MIN RADIUS: 0.398
MAX RADIUS: 1.423
MEAN RADIUS: 0.935
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 5
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.908	-1.150
2:	-0.277	-1.319
3:	-0.529	-0.853
4:	-1.145	-0.803
5:	-0.924	0.734
6:	-0.680	0.912
7:	-0.002	0.633
8:	0.518	0.129
9:	0.268	-0.357
10:	0.210	-0.083

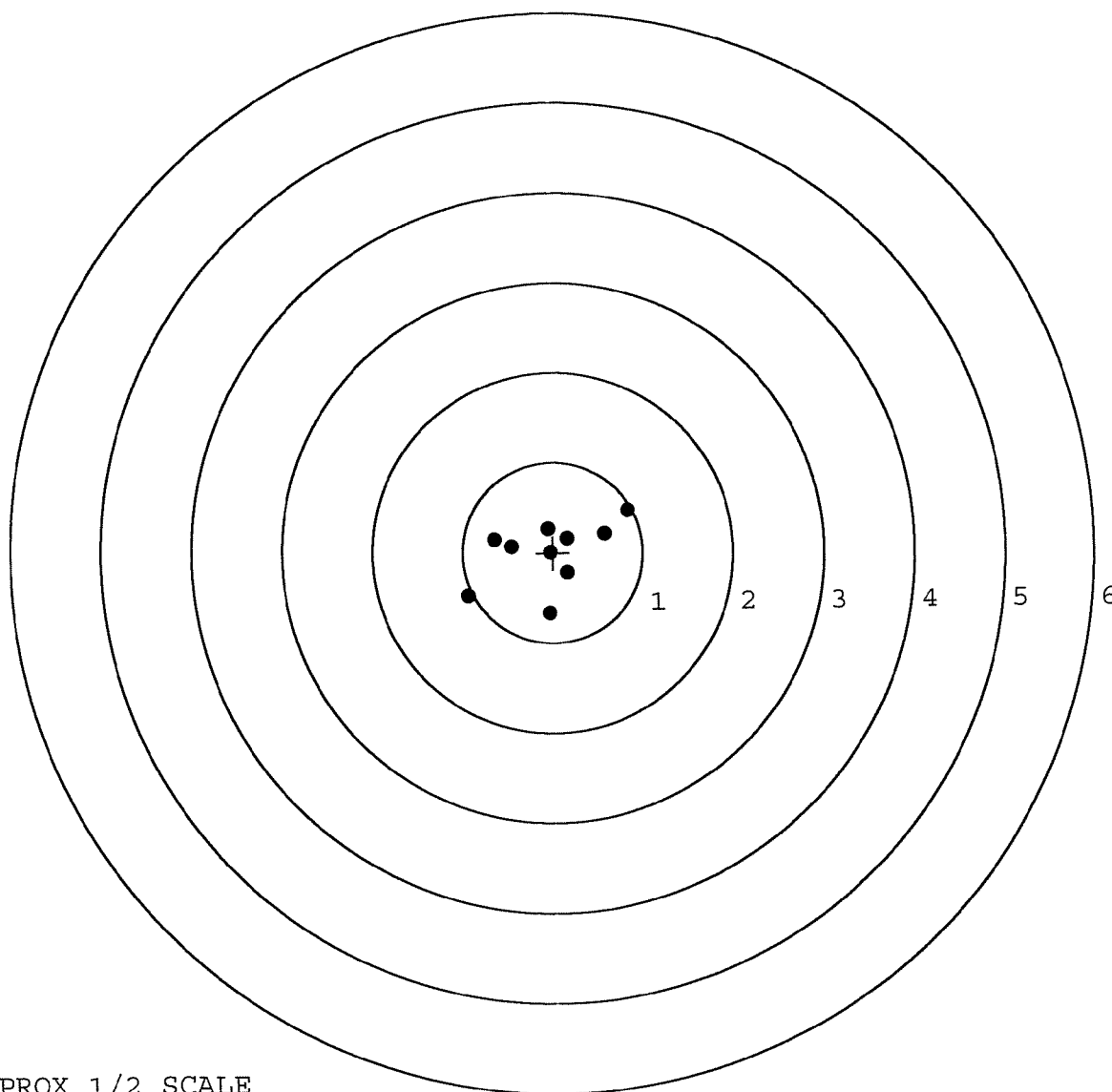


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6594565. __0
TARGET NUMBER: 2
FILE DATE: 03/14/2005
FILE TIME: 09:27

X CENTROID: -0.044
Y CENTROID: -0.006
POA TO CENTROID: 0.045
HORZ SPREAD: 1.780
VERT SPREAD: 1.138
GROUP SPREAD: 2.013
MIN RADIUS: 0.016
MAX RADIUS: 1.016
MEAN RADIUS: 0.525
IN 1 IN DIAMETER: 5
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.835	0.463
2:	0.579	0.212
3:	-0.466	0.068
4:	-0.648	0.150
5:	-0.945	-0.477
6:	-0.040	-0.675
7:	0.163	-0.225
8:	-0.028	-0.004
9:	0.163	0.159
10:	-0.055	0.265

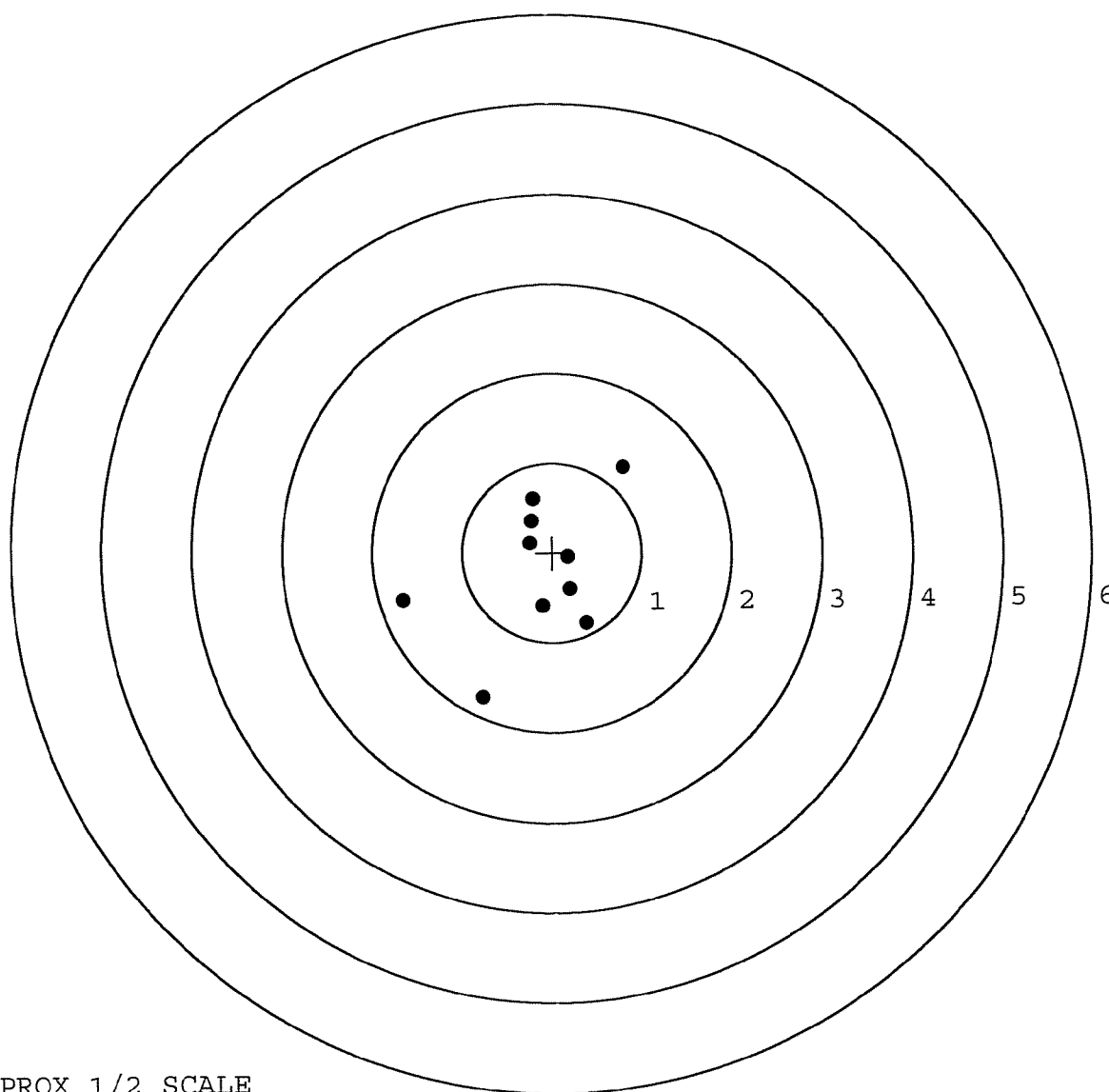


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6594565. __0
TARGET NUMBER: 3
FILE DATE: 03/14/2005
FILE TIME: 09:27

X CENTROID: -0.170
Y CENTROID: -0.195
POA TO CENTROID: 0.259
HORZ SPREAD: 2.468
VERT SPREAD: 2.561
GROUP SPREAD: 3.014
MIN RADIUS: 0.315
MAX RADIUS: 1.544
MEAN RADIUS: 0.827
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 7

POINT#	X	Y
1:	0.803	0.950
2:	0.380	-0.788
3:	-0.116	-0.596
4:	0.197	-0.412
5:	0.176	-0.047
6:	-0.249	0.110
7:	-0.229	0.359
8:	-0.213	0.605
9:	-1.665	-0.524
10:	-0.787	-1.611

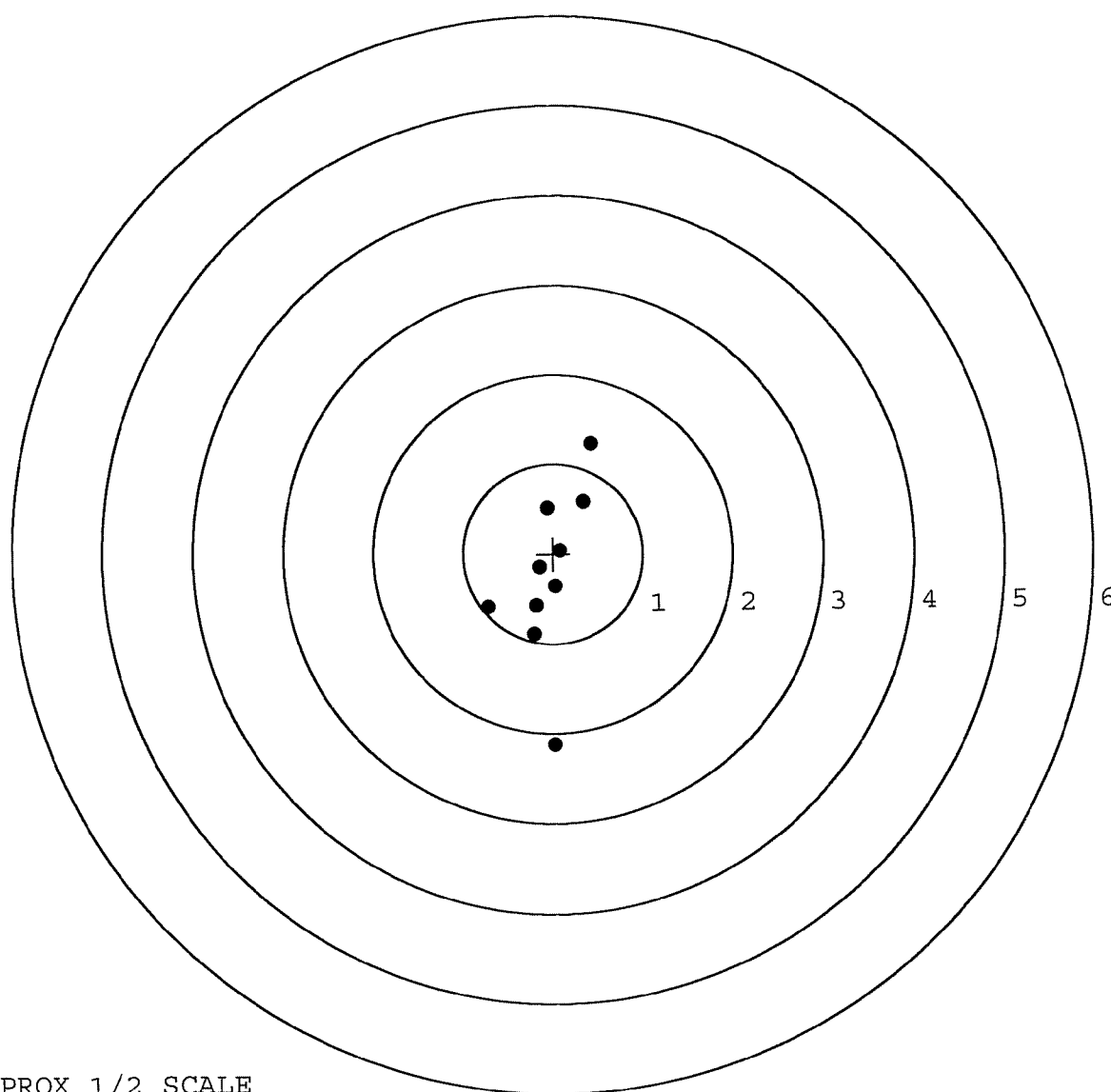


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6594565. __0
TARGET NUMBER: 4
FILE DATE: 03/14/2005
FILE TIME: 09:27

POINT#	X	Y
1:	0.003	-2.136
2:	-0.728	-0.592
3:	0.438	1.224
4:	0.342	0.579
5:	-0.063	0.512
6:	0.079	0.039
7:	-0.155	-0.147
8:	0.026	-0.365
9:	-0.194	-0.575
10:	-0.224	-0.897

X CENTROID: -0.048
Y CENTROID: -0.236
POA TO CENTROID: 0.241
HORZ SPREAD: 1.166
VERT SPREAD: 3.360
GROUP SPREAD: 3.388
MIN RADIUS: 0.139
MAX RADIUS: 1.901
MEAN RADIUS: 0.750
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 8

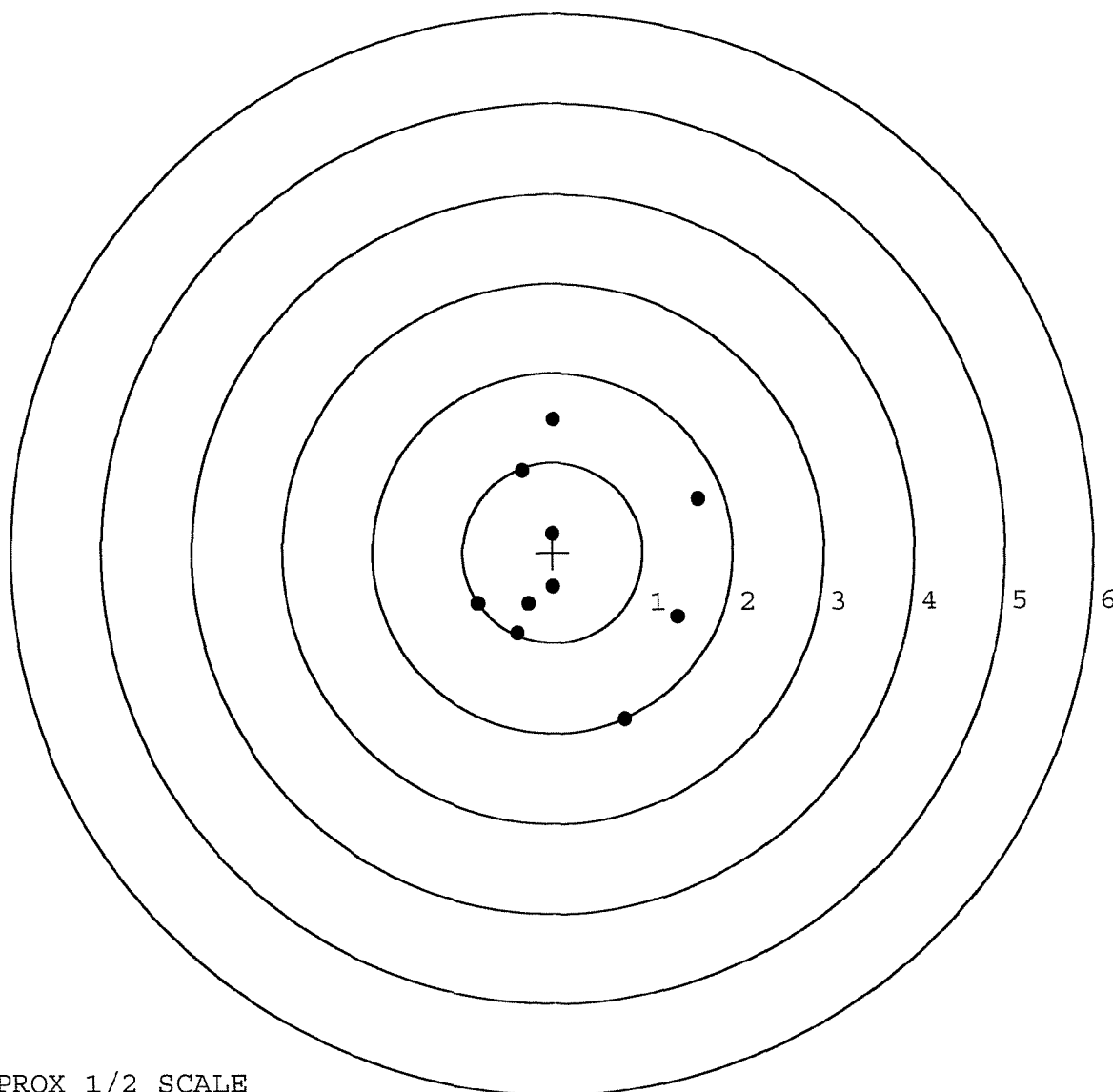


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6594565. __0
TARGET NUMBER: 5
FILE DATE: 03/14/2005
FILE TIME: 09:27

X CENTROID: 0.194
Y CENTROID: -0.178
POA TO CENTROID: 0.264
HORZ SPREAD: 2.454
VERT SPREAD: 3.332
GROUP SPREAD: 3.423
MIN RADIUS: 0.284
MAX RADIUS: 1.780
MEAN RADIUS: 1.095
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 4
in 3 IN DIAMETER: 7

POINT#	X	Y
1:	1.617	0.593
2:	1.383	-0.715
3:	0.793	-1.854
4:	0.007	1.478
5:	-0.335	0.912
6:	0.002	0.212
7:	-0.005	-0.380
8:	-0.276	-0.570
9:	-0.405	-0.896
10:	-0.837	-0.562



TARGET APPROX 1/2 SCALE

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

R & E NUMBER	92674		
SERIAL NUMBER	06594565		
LOG-IN DATE	2-8-05		
INSPECT AND VERIFY:			
OPERATION #	OPERATION NAME	DATE	INITIAL
550	DIS-ASSEMBLE GUN	2-14-05	RTL
560 A	RE-BARREL	2-16-05	RTL
B	DRILL AND TAP	2-17-05	TRW
575	ASSEMBLE	2-16-05	RTL
600	PROOF	2-17-05	MAGNA-FLUX AC
605	CHECK HEADSPACE	2-17-05	INSPECTED AC
610	DIS-ASSEMBLE GUN	2-17-05	RTL
612	MAGNAFLUX	OPERATOR	
615	ROLLMARK CALIBER	2-18-05	CW
618	ROTO-BLAST	2-18-05	LB
620	APPLY COATINGS	3-1-05	HP
625 A	FINAL ASSEMBLY	3-8-05	RTL
B	TRIGGER PULL TEST		
C	SAFETY "ON" FORCE	3-17-05	AC
D	SAFETY "OFF" FORCE	3-17-05	AC
E	FIRING PIN INDENT	3-17-05	AC
640	TARGET	3-14-05	TRW
655	FINAL INSPECT	3-17-05	AC
660	PACK	3-17-05	DA
		SHIP DATE	
		QAR INSPECTION DATE	




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

MODEL 700™

M24

SERIAL NO.

C6594565

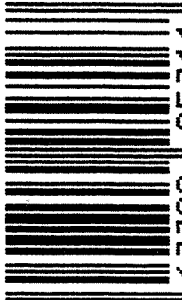
ORDER NO.

5716

20

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

UPC



0 47700 25716 7



5716 C6594565

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6594565

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		12/26/90	K.S.
600	Proof		12/26/90	K.S.
607	Check Headspace		12/26/90	K.S.
610	Dis-assemble Gun		12/26/90	K.S.
612	Magnaflux Barrel Action		1-7-91	KR
	Magnaflux Bolt		1-7-91	KR
615	Rollmark Caliber		1-7-91	LS
617	Drill and Tap Sight Holes	1	10 91	FB
618	Polish Barrel	1	10 91	WB
620	Apply Coatings (Barrel Action)		1-26-91	TH
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		2/11/91	KL
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		2/11/91	KL
	C) Inspect Ejector Hole for Chamfer		2/11/91	KL
	D) Oil Firing Pin Ass'y		2/11/91	KL
	E) Adjust Trigger Pull to Min Setting and Stake		2/12/91	KL

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			2/12/91	WB
	G) Safety Off Force	2 1/4	2 1/4	2 1/4			2/12/91	WB
	H) Trigger Pull Test & Retainability						2/12/91	JH
	I) Firing Pin Indent	.020	.0205	.020			2/12/91	WB
	J) Assemble Stock						2/12/91	Kd
	K) Assemble Swivel Studs						2-25-91	AC
	L) Attach Front and Rear Sight Assemblies						2/12/91	Kd
	M) Iron Sight Alignment						2/12/91	Kd
	N) Detach Front & Rear Sights & place in numbered container						2/12/91	Kd
	O) Attach Scope to Rifle						2/12/91	XX
	P) Detach & Attach Scope 20 Times						2/12/91	XX
640	Gallery Target & Test						2-12-91	NF
	A) Time						"	NF
	B) Malfunctions						"	NF
	C) Pierced Primers						"	NF
	D) Optical Clarity of Scope						"	NF
645	Inspect for Live Ammo						2-12-91	NF
655	Final Inspection						2-25-91	AC
	A) Headspace						2/20/91	WB
	B) Trigger Pull	2.40	2.45	2.44	2.45	2.46	2/20/91	WB
	C) Function						2-25-91	AC
660	Pack						3/14/91	WB

SWS TRIGGER PULL TEST

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

SERIAL NO. 06594865

DATE 2/12/91

TESTER JEL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.48	2.16	2.43	2.40	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.49	2.18	2.35	2.45	
PULL #3	2.24	2.35	2.40	2.44	
PULL #4	2.37	2.36	2.40	2.45	
PULL #5	2.34	2.40	2.41	2.46	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.37	3.39		
PULL #2	3.38	3.36		
PULL #3	3.37	3.40		
PULL #4	3.38	3.40		
PULL #5	3.38	3.42		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.29	4.25		4.35
PULL #2	4.25	4.27		4.34
PULL #3	4.26	4.30		4.35
PULL #4	4.13	4.33		4.36
PULL #5	4.27	4.34		4.39
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6594565
13 Feb 1991

CENTROIDAL DISTANCES

0 TO	1	.152761
1 TO	2	.46179
1 TO	3	.888272
1 TO	4	.160112
1 TO	5	.0928493

3

2.4 <----POA

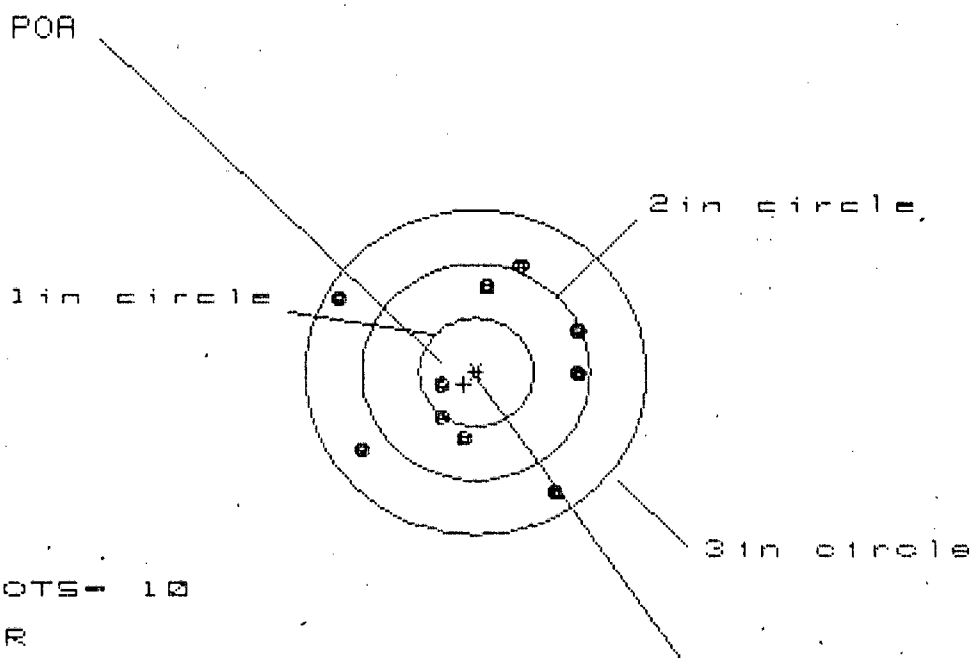
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0418
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .352
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .354473

THE AMR FOR THIS RIFLE IS: 1.094

13 Feb 1991

FILE:/PATTERNING/CENTERFIRE_PATT/ C6594565

CENTERFIRE PATTERNS # 1



OF SHOTS - 10

IN CIR

1 in = 2

2 in = 6

3 in = 10

HS = 2.161

VS = 2.058

GS = 2.660

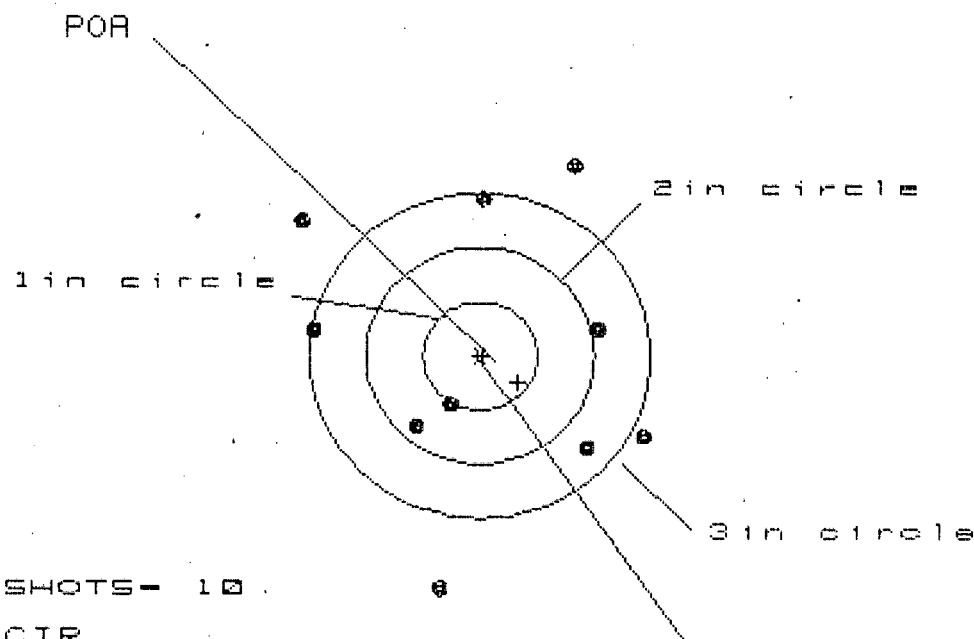
CENTROID #

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.910	.771	.843
MINIMUM X	:	-1.251	-1.138	-1.066
MAXIMUM Y	:	.987	1.068	.944
MINIMUM Y	:	-1.071	-.990	-.752
CENTROID X	:	.106	.245	.173
CENTROID Y	:	.110	.029	.153
POA TO CENTROID in.	:	.153	.246	.231
MIN RADIUS	:	.352	.477	.429
MEAN RADIUS	:	.910	.845	.800
MAX RADIUS	:	1.448	1.299	1.305
HORIZONTAL SPREAD	:	2.161	1.909	1.909
VERTICAL SPREAD	:	2.058	2.058	1.696
EXTREME SPREAD	:	2.660	2.208	2.208
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	

13 Feb 1991

FILE://PATTERNING/CENTERFIRE_PATT/ C6594565

CENTERFIRE PATTERNS # 2



OF SHOTS - 10

IN CIR

1in - 0

2in - 2

3in - 6

HS - 2.995

VS - 3.903

GS - 4.087

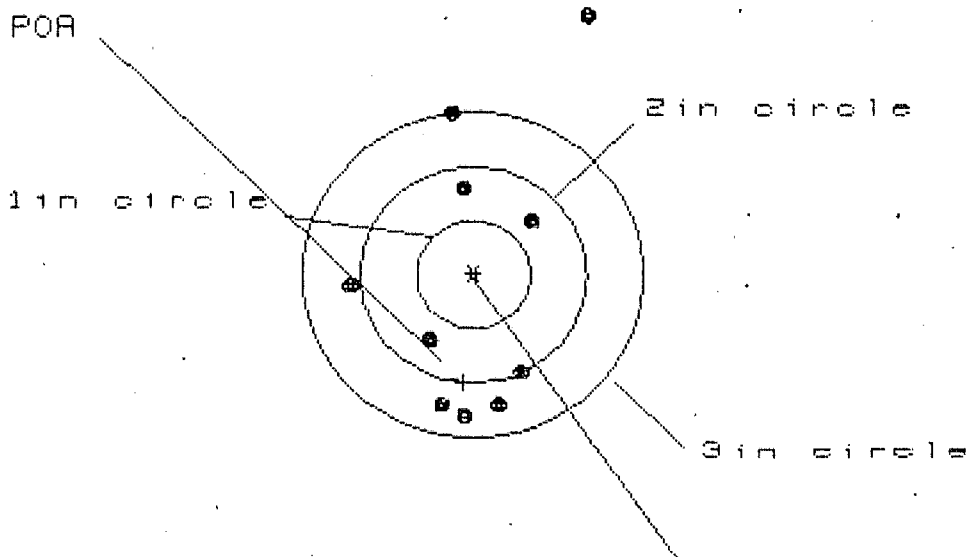
CENTROID #

PATTERN #	2	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.437	1.393	1.193
MINIMUM X	-1.558	-1.602	-1.685
MAXIMUM Y	1.757	1.519	1.644
MINIMUM Y	-2.146	-1.119	-.994
CENTROID X	-.335	-.291	-.091
CENTROID Y	.247	.485	.360
POA TO CENTROID in.	.416	.566	.371
MIN RADIUS	.503	.730	.749
MEAN RADIUS	1.438	1.363	1.271
MAX RADIUS	2.182	1.890	1.741
HORIZONTAL SPREAD	2.995	2.995	2.878
VERTICAL SPREAD	3.903	2.638	2.638
EXTREME SPREAD	4.087	3.608	3.044
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	2		
NUMBER IN THREE INCH CIRCLE =	6		

13 Feb 1991

FILE:/PATTERNING/CENTERFIRE_PATT/ C6594565

CENTERFIRE PATTERNS # 3



OF SHOTS - 10

IN CIR

1in = 0

2in = 3

3in = 0

HS = 2.041

VS = 3.742

GS = 3.897

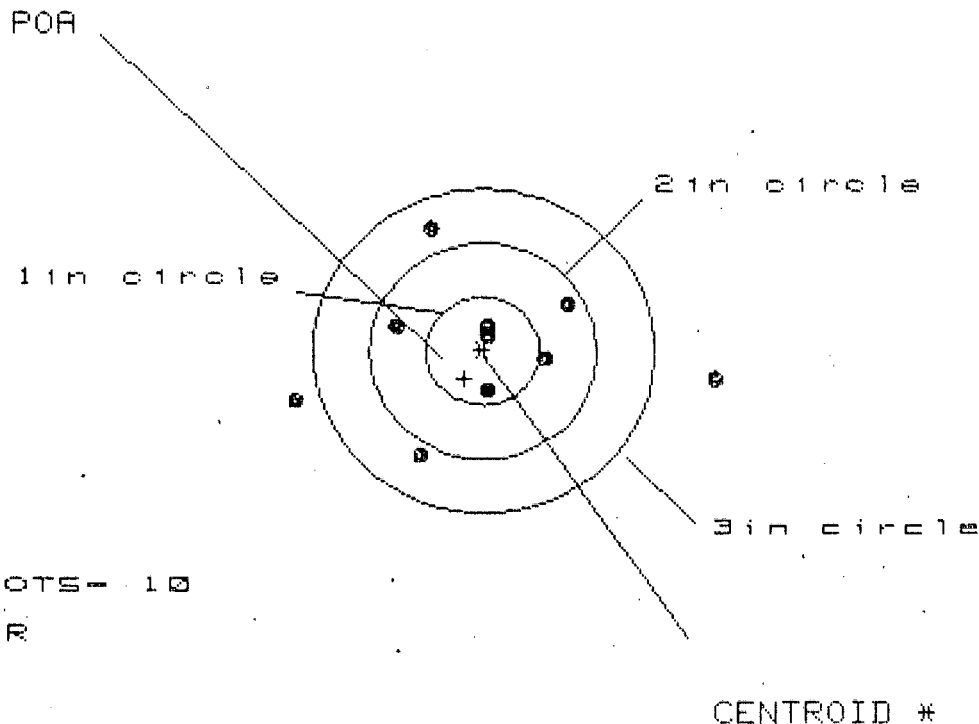
CENTROID *

PATTERN #	3	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.973	.638	.627
MINIMUM X	-1.068	-.960	-.971
MAXIMUM Y	2.413	1.784	1.288
MINIMUM Y	-1.329	-1.061	-.838
CENTROID X	.084	-.024	-.013
CENTROID Y	.998	.730	.507
POA TO CENTROID in.	1.002	.731	.507
MIN RADIUS	.710	.431	.312
MEAN RADIUS	1.219	1.006	.852
MAX RADIUS	2.602	1.786	1.288
HORIZONTAL SPREAD	2.041	1.598	1.598
VERTICAL SPREAD	3.742	2.845	2.126
EXTREME SPREAD	3.897	2.846	2.126
NUMBER IN ONE INCH CIRCLE =		0	
NUMBER IN TWO INCH CIRCLE =		3	
NUMBER IN THREE INCH CIRCLE =		8	

13 Feb 1991

FILE:/PATTERNING/CENTERFIRE_PATT/ C6594565

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 4

2in = 6

3in = 8

HS= 3.630

VS= 2.157

GS= 3.638

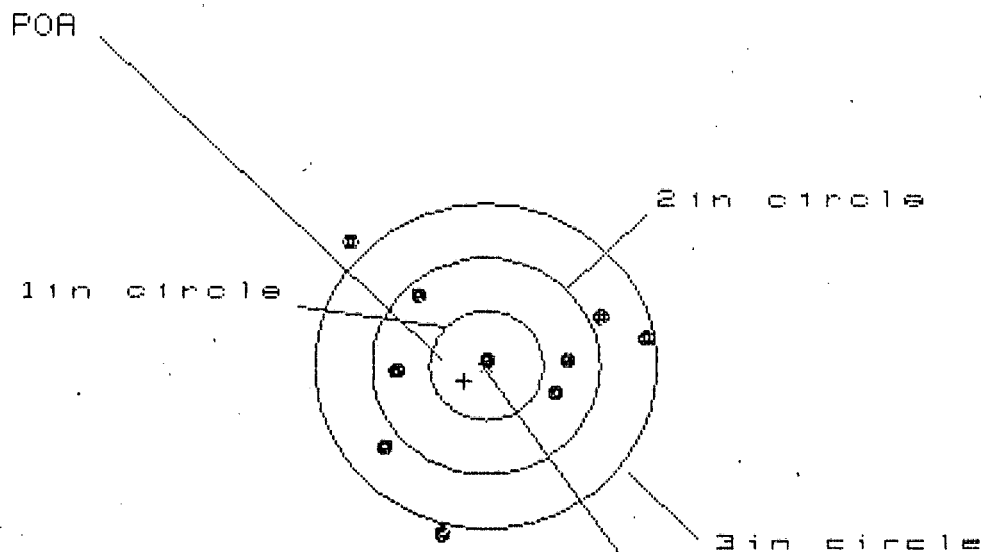
CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.994	.991	.814
MINIMUM X	:	-1.635	-1.414	-.709
MAXIMUM Y	:	1.155	1.129	1.067
MINIMUM Y	:	-1.002	-1.028	-1.090
CENTROID X	:	.162	-.059	.118
CENTROID Y	:	.260	.286	.348
POA TO CENTROID in.	:	.307	.292	.367
MIN RADIUS	:	.173	.307	.123
MEAN RADIUS	:	.907	.803	.661
MAX RADIUS	:	2.008	1.499	1.220
HORIZONTAL SPREAD	:	3.630	2.405	1.523
VERTICAL SPREAD	:	2.157	2.157	2.157
EXTREME SPREAD	:	3.638	2.572	2.164
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

13 Feb 1991

FILE:/PATTERNING/CENTERFIRE_PATT/ C6594565

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 8

HS= 2.583

VS= 2.645

GS= 2.772

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.406	1.275	1.215
MINIMUM X	:	-1.177	-1.000	-1.060
MAXIMUM Y	:	1.121	.773	.599
MINIMUM Y	:	-1.524	-1.400	-.791
CENTROID X	:	.192	.323	.383
CENTROID Y	:	.145	.021	.196
POA TO CENTROID in.	:	.241	.323	.430
MIN RADIUS	:	.059	.207	.166
MEAN RADIUS	:	.997	.925	.829
MAX RADIUS	:	1.625	1.480	1.323
HORIZONTAL SPREAD	:	2.583	2.275	2.275
VERTICAL SPREAD	:	2.645	2.173	1.390

EXTREME SPREAD : 2.772 2.466 2.465
NUMBER IN ONE INCH CIRCLE = 1
NUMBER IN TWO INCH CIRCLE = 5
NUMBER IN THREE INCH CIRCLE = 8