

G6845883
Replaces
E6703515

Repair Inquiry

Repair Number: RE00161969

Serial: E6703515 Model M24 SWS Center Fire
Caliber: 7.62 NATO

Repairman:

Status:

Closed 2/13/2009 9:06:51 AM

Address Information

Customer:

Received From

Return To:

Received From

Name: FB4830 TMO 23RD LRS LGRDDC

FB4830 TMO 23RD LRS LGRDDC

Address 1: 4380D ALABAMA ROAD

4380D ALABAMA ROAD

Address 2: PO Box:

PO Box:

City: MOODY AFB

MOODY AFB

State: GA

Zip Code: 31699

Country: US

State: GA

Zip Code: 31699

Country: US

FFL:

Contact / Condition

Problems

Estimate

History / Status

Shipping / Billing

Contact Information

Phone:

Fax:

Email:

Comments:

Received Condition

Fair

Condition

Notes:

CSR

Notes:

Accessories Received

Code	Desc	Qty
A007	With Stud	2
A010	Hard Case	1
A017	Scope Base	1
A057	Fit and Rear Sgt Base	1

Repair Search

Refresh

Close

Evaluate

nagletj

2/13/2009

1:31 PM

CAPS

NUM

INS

SCRL

start

12 Microsoft...

4 Microsoft...

3 Internet E...

Arms Services...

Part Search B...

3 SAP Logon...

1:31 PM

G6845883

Serial Number: E6703515

Model: M24 SWS



RE00161969

INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL #

G6845883 for E6703515

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		4-3-09	SP
430	ASSEMBLE TO STOCK		4-3-09	SP
440	PROOF		4-3-09	SP
460	CHECK HEADSPACE		4-3-09	SP
470	DIS-ASSEMBLE ACTION		4-3-09	SP
472	SERIALIZE BOLT HANDLE		4-6-09	RT
475	DRILL AND TAP SIGHT HOLES	MAGNA - FLUX APR 09 2009 OPERATOR (S)	4-6-09	
480	MAGNAFLUX BBL ACTION		4-8-09	(H)
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		4-8-09	RT
520	GOFF BLAST BBL / REC		4-8	BT
542	APPLY COATINGS (BARREL ACTION)		4-13	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		4-13-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		4-13-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		4-13-09	SP
	D) OIL FIRING PIN ASSEMBLY			
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

F004 REV 5/2006

560	F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX	<u>30</u>	<u>30</u>	<u>30</u>	5-11-09	LN		
CONT.									
	G) SAFETY OFF FORCE	2 LBS MIN	<u>40</u>	<u>40</u>	<u>40</u>	5-11-09	LN		
	H) TRIGGER PULL TEST AND RETAINABILITY								
	I) FIRING PIN INDENT	.020 MIN	<u>.024</u>	<u>.024</u>	<u>.024</u>	5-11-09	LN		
	J) ASSEMBLE STOCK								
	K) ASSEMBLE SWIVEL STUDS								
	L) ATTACH FRONT AND REAR SIGHT ASSY'S								
	M) IRON SIGHT ALIGNMENT								
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER								
640 &	FUNCTION TEST AND		PASS	FAIL					
650	TARGET		PASS	FAIL		5-6-09	LN		
	MALFUNCTION		CORRECTION						
	MALFUNCTION		CORRECTION	N/A					
	MALFUNCTION		CORRECTION						
	MALFUNCTION		CORRECTION						
660	INSPECT FOR LIVE AMMO					5-6-09	TCR		
670	FINAL INSPECTION A) HEADSPACE					5-11-09	LN		
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>226</u>	<u>231</u>	<u>236</u>	<u>242</u>	<u>242</u>	5-7-09	LN
	C) FUNCTION							5-11-09	LN
690	PACK							5/15/09	Fm

F004 REV 5/2006

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6845883.__0

FILE DATE AND TIME: 05/06/2009 14:59

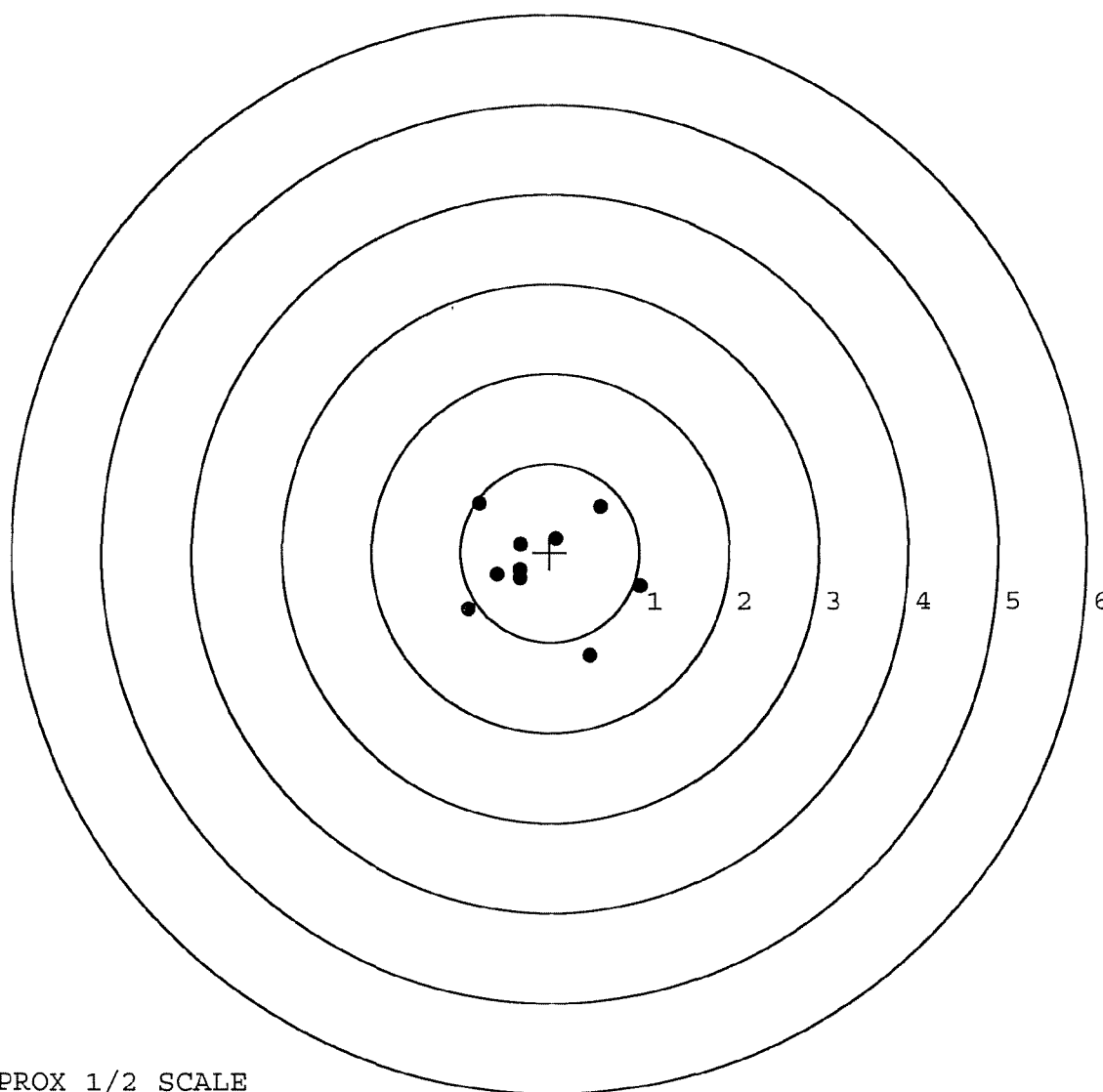
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.078
The Average Y Centroid of the Five Target Set:	-0.029
The Average Point of Impact of the Five Target Set:	0.084
The Average Mean Radius of the Five Target Set:	0.623
The Distance from POA to Centroid Target #1:	0.202
The Distance from Centroid Target #2 to Centroid Target #1:	0.166
The Distance from Centroid Target #3 to Centroid Target #1:	0.138
The Distance from Centroid Target #4 to Centroid Target #1:	0.153
The Distance from Centroid Target #5 to Centroid Target #1:	0.343

SERIAL NUMBER: G6845883. __0
TARGET NUMBER: 1
FILE DATE: 05/06/2009
FILE TIME: 14:59

POINT#	X	Y
1:	0.560	0.509
2:	0.071	0.155
3:	1.000	-0.385
4:	0.444	-1.158
5:	-0.332	-0.289
6:	-0.332	0.090
7:	-0.592	-0.253
8:	-0.919	-0.635
9:	-0.782	0.548
10:	-0.331	-0.200

X CENTROID: -0.121
Y CENTROID: -0.162
POA TO CENTROID: 0.202
HORZ SPREAD: 1.919
VERT SPREAD: 1.706
GROUP SPREAD: 2.101
MIN RADIUS: 0.213
MAX RADIUS: 1.145
MEAN RADIUS: 0.678
IN 1 IN DIAMETER: 5
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10

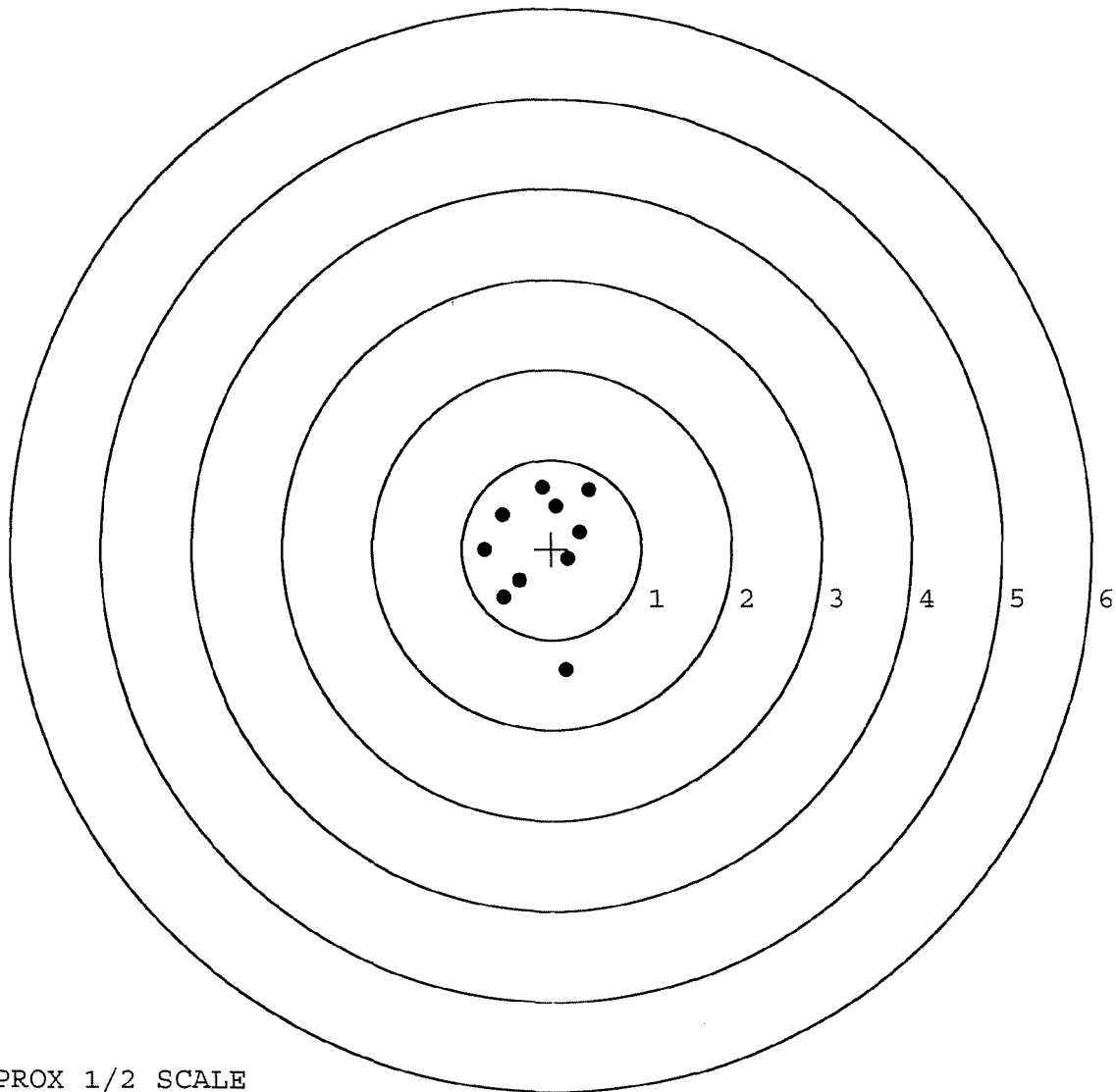


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6845883. __0
TARGET NUMBER: 2
FILE DATE: 05/06/2009
FILE TIME: 14:59

POINT#	X	Y
1:	0.184	-0.109
2:	0.307	0.190
3:	0.049	0.485
4:	0.417	0.666
5:	-0.105	0.687
6:	-0.549	0.376
7:	-0.742	-0.019
8:	-0.360	-0.357
9:	-0.534	-0.544
10:	0.154	-1.335

X CENTROID: -0.118
Y CENTROID: 0.004
POA TO CENTROID: 0.118
HORZ SPREAD: 1.159
VERT SPREAD: 2.022
GROUP SPREAD: 2.039
MIN RADIUS: 0.322
MAX RADIUS: 1.366
MEAN RADIUS: 0.651
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6845883. __0

TARGET NUMBER: 3

FILE DATE: 05/06/2009

FILE TIME: 14:59

POINT#	X	Y
1:	0.185	0.176
2:	-0.011	-0.023
3:	-0.156	-0.128
4:	-0.397	-0.091
5:	-0.713	-0.038
6:	0.067	0.655
7:	-0.334	1.178
8:	1.046	-0.496
9:	-0.171	-0.811
10:	0.376	-1.219

X CENTROID: -0.011

Y CENTROID: -0.080

POA TO CENTROID: 0.080

HORZ SPREAD: 1.759

VERT SPREAD: 2.397

GROUP SPREAD: 2.500

MIN RADIUS: 0.057

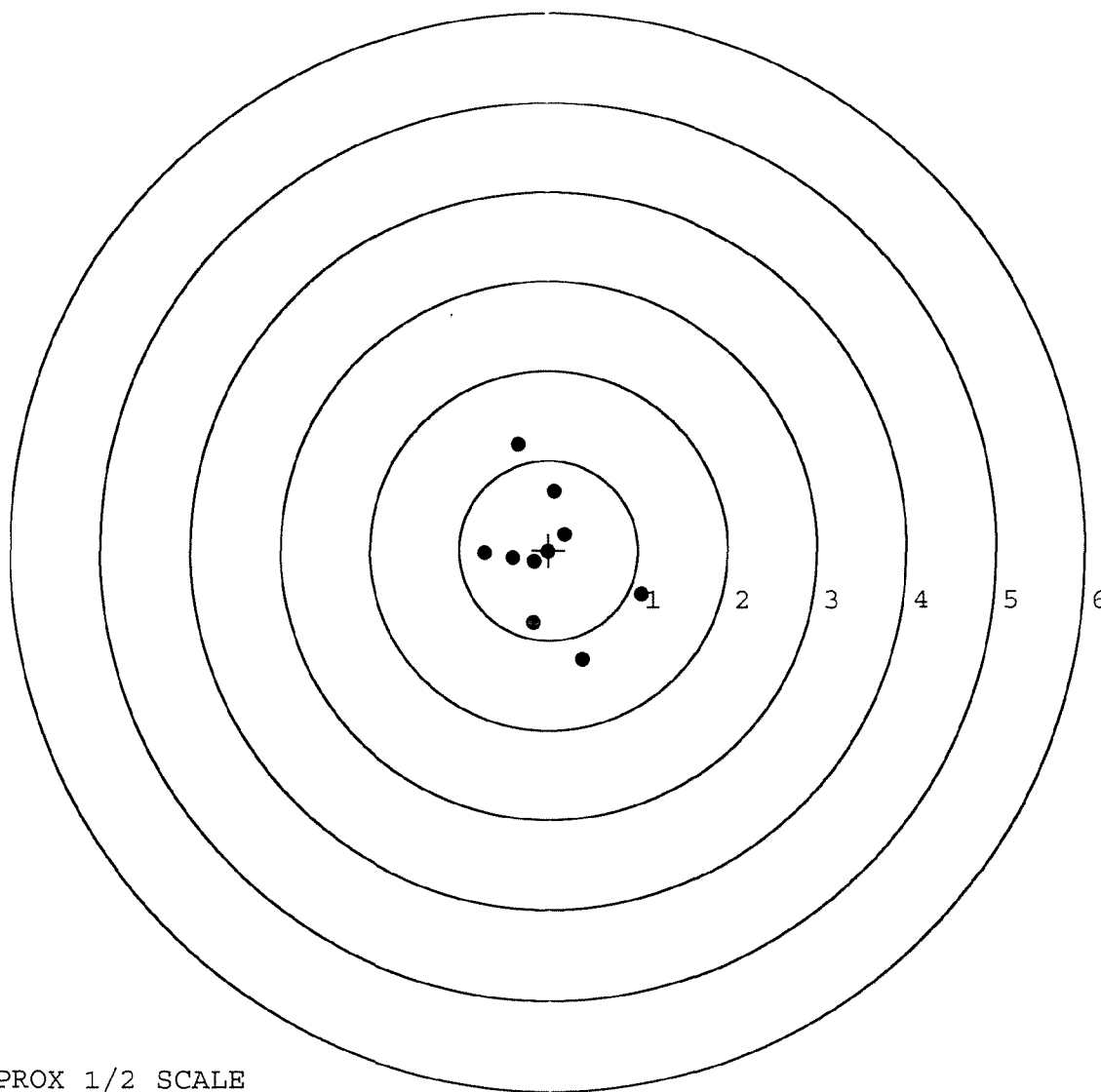
MAX RADIUS: 1.299

MEAN RADIUS: 0.675

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6845883. 0

TARGET NUMBER: 4

FILE DATE: 05/06/2009

FILE TIME: 14:59

POINT#	X	Y
1:	0.715	0.149
2:	0.151	0.047
3:	0.156	0.310
4:	0.033	0.023
5:	-0.072	-0.223
6:	-0.216	-0.382
7:	-0.077	-0.500
8:	0.061	-0.671
9:	0.212	0.040
10:	-0.829	0.323

X CENTROID: 0.013

Y CENTROID: -0.088

POA TO CENTROID: 0.089

HORZ SPREAD: 1.544

VERT SPREAD: 0.994

GROUP SPREAD: 1.554

MIN RADIUS: 0.113

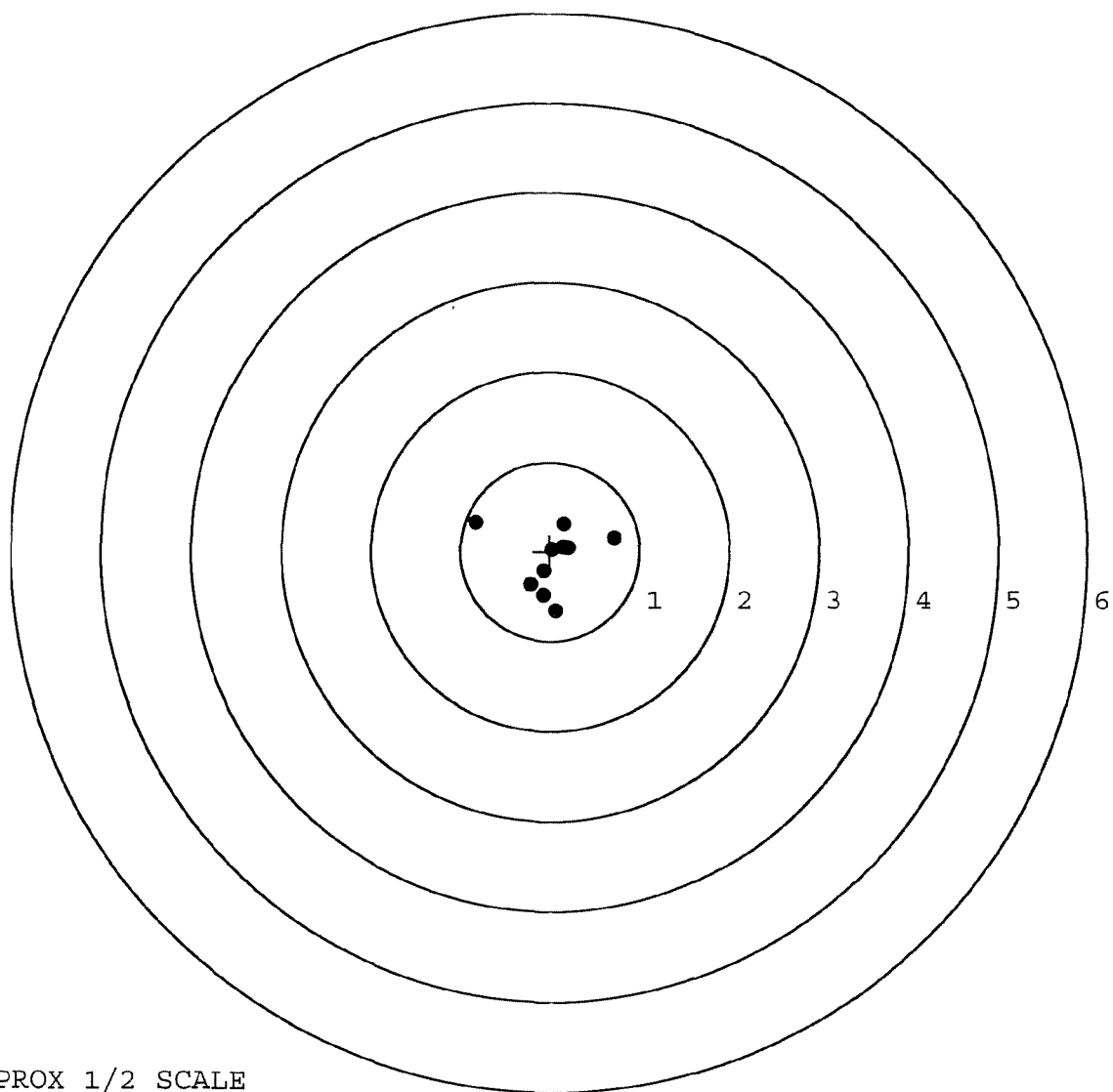
MAX RADIUS: 0.937

MEAN RADIUS: 0.418

IN 1 IN DIAMETER: 7

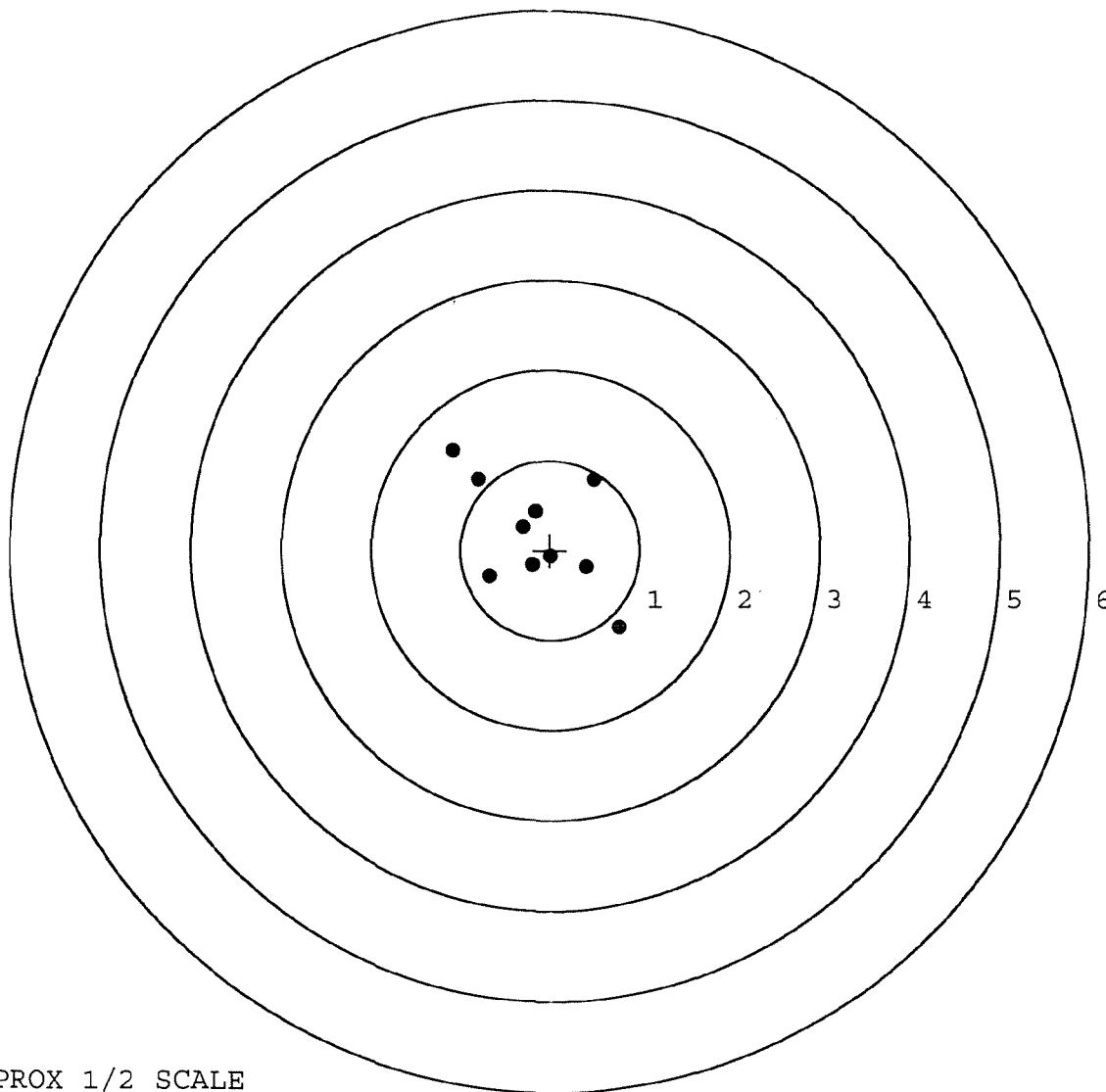
IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6845883. __ 0	POINT#	X	Y
TARGET NUMBER: 5	1:	0.493	0.788
FILE DATE: 05/06/2009	2:	-0.802	0.788
FILE TIME: 14:59	3:	-1.086	1.109
	4:	-0.166	0.439
X CENTROID: -0.156	5:	-0.306	0.257
Y CENTROID: 0.179	6:	-0.674	-0.294
POA TO CENTROID: 0.238	7:	-0.199	-0.170
HORZ SPREAD: 1.857	8:	0.011	-0.070
VERT SPREAD: 1.971	9:	0.401	-0.191
GROUP SPREAD: 2.708	10:	0.771	-0.862
MIN RADIUS: 0.169			
MAX RADIUS: 1.394			
MEAN RADIUS: 0.694			
# IN 1 IN DIAMETER: 4			
# IN 2 IN DIAMETER: 8			
# in 3 IN DIAMETER: 10			



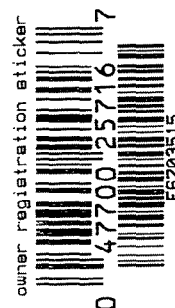
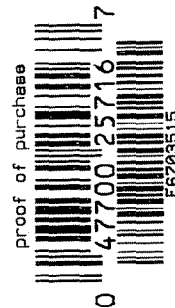
TARGET APPROX 1/2 SCALE

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

DOCUMENT ENVELOPE ASSEMBLY:

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

46 FORM 1444

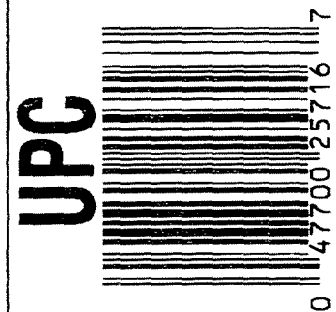


ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

E6703515



Remington®

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

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

SERIAL NO. J
E6703515

46

ORDER NO.
25716

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



5716 E6703515

11CV

ORDER 25716

MODEL 700TH M24

UPC



ORDER 25716

MODEL 700TH M24

UPC



SERIAL NO.



CONTRACT # DAAE20-01-C-0007

GUN SERIAL # E670 3515

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		4/2/01	C/C
600	PROOF		"	"
607	CHECK HEADSPACE		"	"
610	DIS-ASSEMBLE GUN		"	"
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT			
615	ROLLMARK CALIBER			
617	DRILL AND TAP SIGHT HOLES		3/21/01	DA
618	POLISH BARREL			
620	APPLY COATINGS (BARREL ACTION)			
	(BOLT)			
625	FINAL ASSEMBLY A) CLEAN INSIDE OF BOLT ASSEMBLY		3/22/01	DA
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		"	"
	C) INSPECT EJECTOR HOLE FOR CHAMFER		"	"
	D) OIL FIRING PIN ASSEMBLY		4/3/01	CK
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE		"	"

OP #	OPERATION NAME	READINGS	DATE	INITIAL
625	F) SAFETY ON FORCE	<u>6.5</u> <u>6.9</u> <u>6.5</u>	4/4/01	DA
CONT.	G) SAFETY OFF FORCE	<u>3.9</u> <u>3.9</u> <u>3.5</u>	"	"
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT	<u>.022</u> <u>.023</u> <u>.023</u>	4/4/01	DA
	J) ASSEMBLE STOCK			CK
	K) ASSEMBLE SWIVEL STUDS			
	L) ATTACH FRONT AND REAR SIGHT ASSY'S			
	M) IRON SIGHT ALIGNMENT			
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER			
640	GALLERY TEST AND TARGET		3/29	AC
	A) MALFUNCTIONS		3/29	AC
	B) PIERCED PRIMERS		3/29	AC
645	INSPECT FOR LIVE AMMO		3/29	AC
655	FINAL INSPECTION A) HEADSPACE		4-5-01	Rw
	B) TRIGGER PULL	<u>259</u> <u>263</u> <u>225</u> <u>230</u> <u>250</u>	4/4/01	DA
	C) FUNCTION			
660	PACK		4/4/01	DA

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. E6703515

DATE 3/01

TESTER Lu

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.63	2.21		2.40	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.66	2.18		2.27	
PULL #3	2.66	2.12		2.13	
PULL #4	2.71	2.11		2.25	
PULL #5	2.62	2.14		2.30	
TOTAL	13.28	10.76		11.35	
AVG.	2.66	2.15		2.27	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.38	3.17		
PULL #2	3.37	3.27		
PULL #3	3.33	3.17		
PULL #4	3.23	3.26		
PULL #5	3.37	3.30		
TOTAL	16.68	16.17		
AVG.	3.34	3.23		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.18	4.10		4.12
PULL #2	4.21	4.06		4.02
PULL #3	4.02	4.17		4.10
PULL #4	4.29	4.01		4.06
PULL #5	4.28	3.92		4.01
TOTAL	20.98	20.26		20.31
AVG.	4.20	4.05		4.06

Remington Test Lab, Ilion, N.Y.

Centroidal distance calculations for Rifle # e6703515
30 Mar 2001

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0588
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0238
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0634341

THE AMR FOR THIS RIFLE IS: 1.062

CENTROIDAL DISTANCES

Ø TO	1	.113745
1 TO	2	.0860523
1 TO	3	.197588
1 TO	4	.21174
1 TO	5	.111072

 4 <----POA

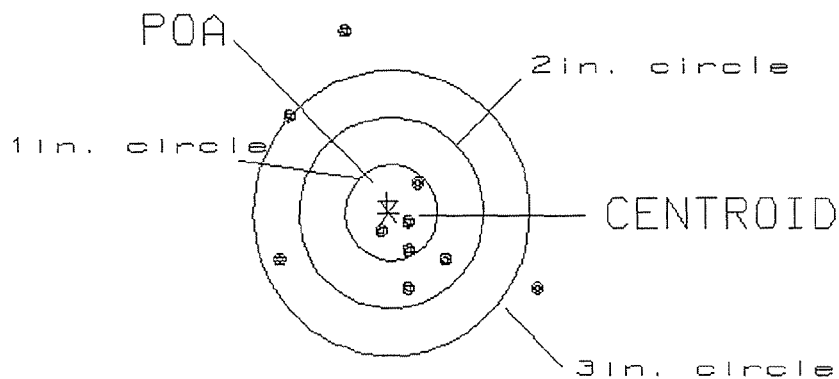
PATTERN #: ☐ 1 ☐

POA TO CENTROID: .114
 MIN RADIUS : .191
 MEAN RADIUS : .933
 MAX RADIUS : 1.921
 CENTROID X : .013
 CENTROID Y : -.113

30 Mar 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/e6703515

CENTERFIRE PATTERN # 1



OF SHOTS= 10

IN CIRCLE

HS= 2.86

4

VS= 2.67

6

GS= 3.35

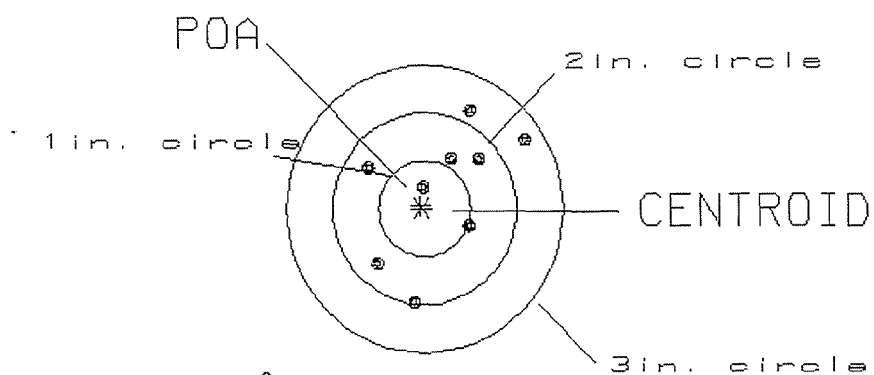
8

PATTERN #: ☐ 2 ☐
 POA TO CENTROID: .031
 MIN RADIUS : .265
 MEAN RADIUS : .956
 MAX RADIUS : 2.500
 CENTROID X : .016
 CENTROID Y : -.027

30 Mar 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/e6703515

CENTERFIRE PATTERN # 2



OF SHOTS= 10

IN CIRCLE

HS= 2.89

1

VS= 2.62

7

GS= 3.83

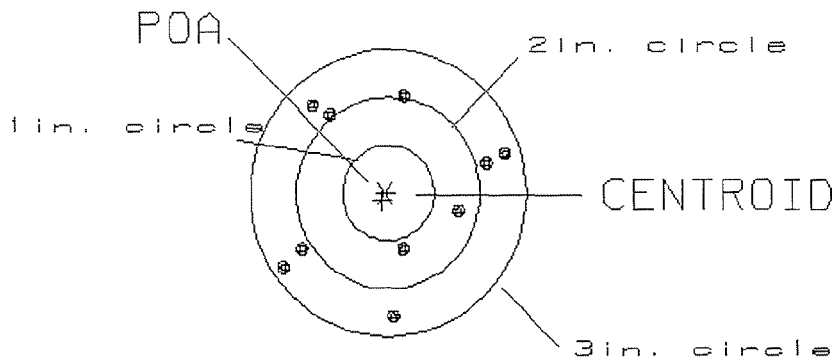
9

PATTERN #: 3
 POA TO CENTROID: .091
 MIN RADIUS : .631
 MEAN RADIUS : 1.099
 MAX RADIUS : 1.354
 CENTROID X : .038
 CENTROID Y : .083

30 Mar 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/e6703515

CENTERFIRE PATTERN # 3



OF SHOTS= 10

IN CIRCLE

HS= 2.39

0

VS= 2.38

2

GS= 2.67

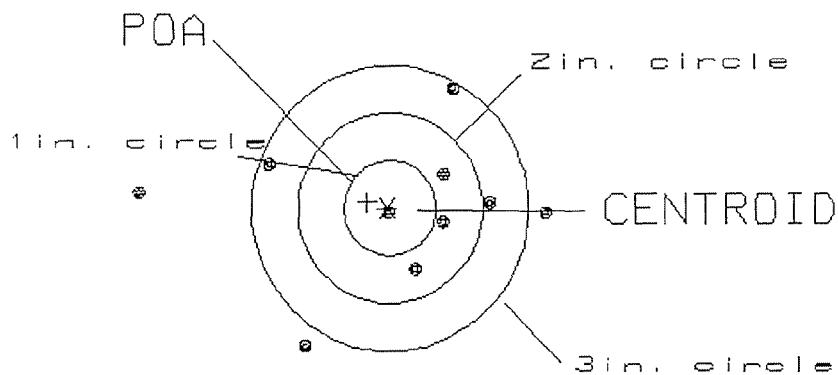
10

PATTERN #: ☐ 4 ☐
 POA TO CENTROID: .226
 MIN RADIUS : .036
 MEAN RADIUS : 1.182
 MAX RADIUS : 2.672
 CENTROID X : .218
 CENTROID Y : -.060

30 Mar 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/e6703515

CENTERFIRE PATTERN # 4



OF SHOTS= 10

IN CIRCLE

H3= 4.32
 US= 2.63
 GS= 4.32

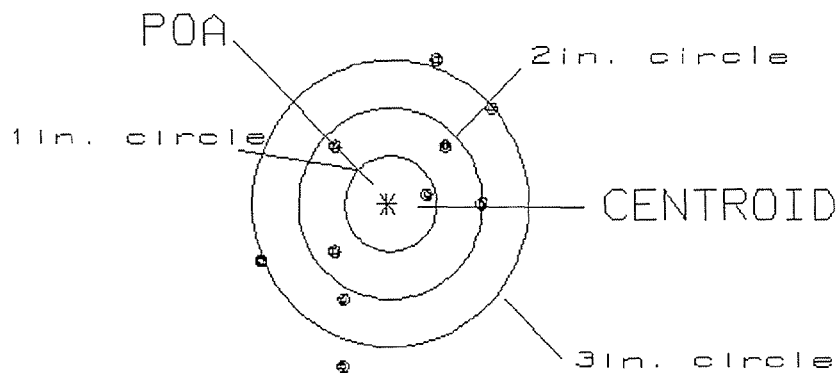
1
 4
 7

PATTERN #: ☐ 5 ☐
 POA TO CENTROID: .009
 MIN RADIUS : .439
 MEAN RADIUS : 1.141
 MAX RADIUS : 1.770
 CENTROID X : .009
 CENTROID Y : -.002

30 Mar 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/e6703515

CENTERFIRE PATTERN # 5



OF SHOTS= 10

IN CIRCLE

HS= 2.56

1

VS= 3.15

4

GS= 3.31

7