

66863586

Replaces

E6703416

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: **RE00173920** Serial: E6703416 Model M24 SWS Center Fire
 Verify Repair Caliber: 7.62 NATO Produced: 04/11/2001 Repairman: Status: Closed 8/27/2009 2:35:15 PM

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 550 505 ATLANTIC ST BLDG 550

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: NN

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 Refresh Close

Repair

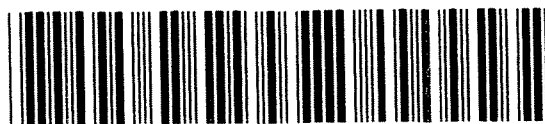
haglej 8/28/2009 8:28 AM CAPS NUM INS SCRL

start Microsoft Office ... Internet Explorer ... Microsoft Office ... Arms Services Repair ... Part Search by Mate ... 8:28 AM

G6863586

Serial Number: **E6703416**

Model: M24 SWS



RE00173920

INSPECTION CHECKLIST - REPAIRS

CONTRACT #: W52H09-07-C-0207

ISSUED 10/1/2007

R & E NUMBER

173920

SERIAL NUMBER

E6203416

66863586

LOG-IN DATE

8-27-09

OPERATION #	OPERATION NAME	DATE	INITIAL
500	DIS-ASSEMBLE GUN	9-2-09	RTZ
505	RE-BARREL	9-2-09	RTZ
420	ASSEMBLE	9-2-09	RTZ
440	PROOF	9-4-09	RTZ
460	CHECK HEADSPACE	9-4-09	RTZ
470	DIS-ASSEMBLE GUN	9-4-09	RTZ
480	MAGNAFLUX	9-10-09	RTZ
510	DRILL AND TAP	9-4-09	RTZ
500	ROLLMARK CALIBER	9-10-09	SPD
520	GOFF BLAST BBL / REC	9-10	JWS
530 & 540	APPLY COATINGS	9-16	
560	FINAL ASSEMBLY	9-22-09	RTZ
640	FUNCTION TEST AND	9-22-09	RP
650	TARGET	9-22-09	RP
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
670	FINAL INSPECTION	9-22-09	SPD
	A) HEADSPACE	9-24-09	TL
		9-24-09	TL
	B) TRIGGER PULL	2.53 2.60 2.52 2.68 2.60 9-24-09	TL
680	F) SAFETY ON FORCE	5.0 5.0 5.0 9-24-09	TL
	G) SAFETY OFF FORCE	3.0 3.0 3.0 9-24-09	TL
	I) FIRING PIN INDENT	.023 .023 .023 9-24-09	TL
690	PACK	9-24-09	FM

F006 REV 1/2009

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6863586.___0

FILE DATE AND TIME: 09/23/2009 08:16

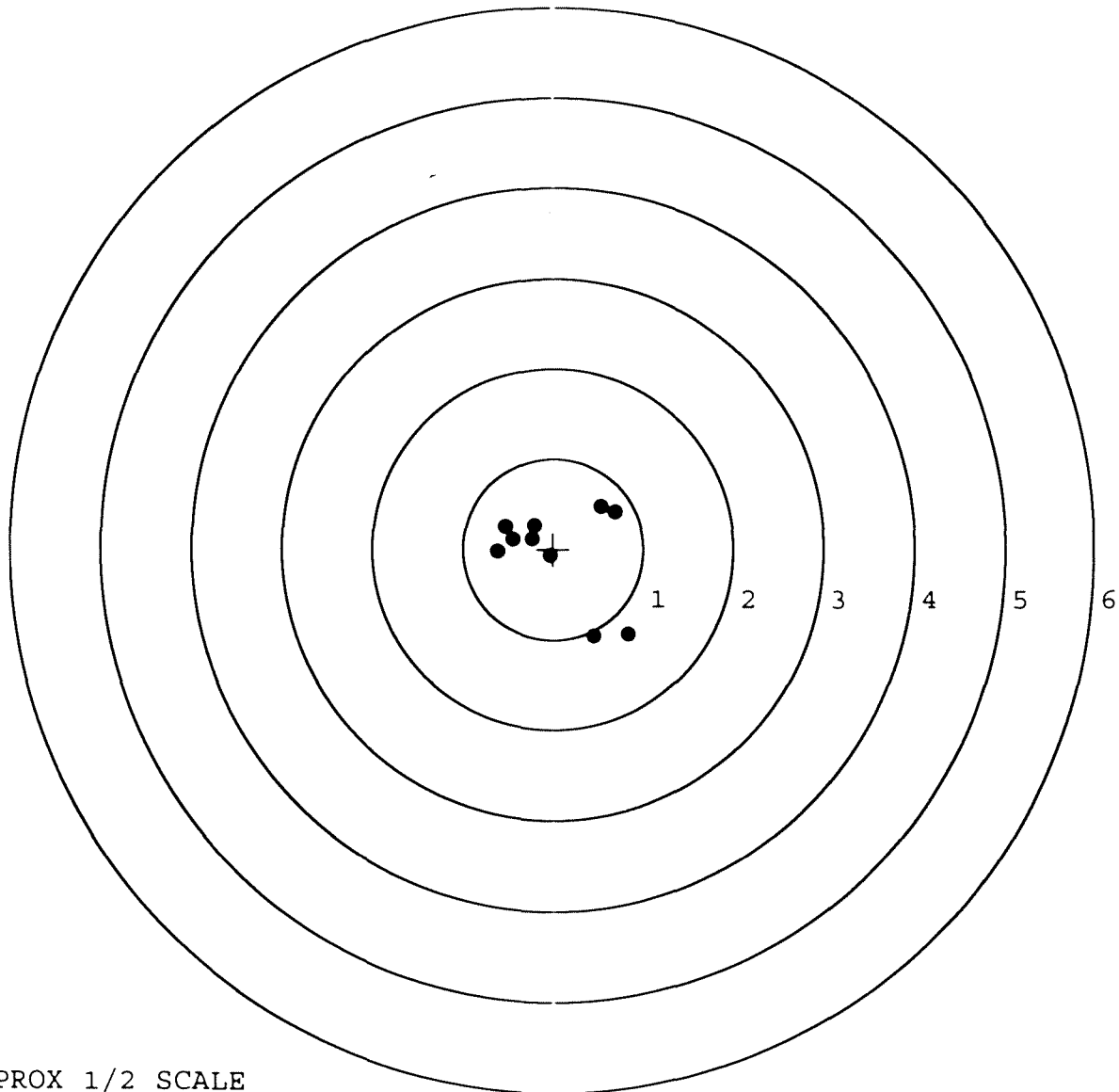
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.046
The Average Y Centroid of the Five Target Set:	0.042
The Average Point of Impact of the Five Target Set:	0.062
The Average Mean Radius of the Five Target Set:	0.679
The Distance from POA to Centroid Target #1:	0.057
The Distance from Centroid Target #2 to Centroid Target #1:	0.068
The Distance from Centroid Target #3 to Centroid Target #1:	0.182
The Distance from Centroid Target #4 to Centroid Target #1:	0.103
The Distance from Centroid Target #5 to Centroid Target #1:	0.181

SERIAL NUMBER: G6863586. 0
TARGET NUMBER: 1
FILE DATE: 09/23/2009
FILE TIME: 08:16

X CENTROID: 0.041
Y CENTROID: -0.040
POA TO CENTROID: 0.057
HORZ SPREAD: 1.443
VERT SPREAD: 1.429
GROUP SPREAD: 1.806
MIN RADIUS: 0.090
MAX RADIUS: 1.200
MEAN RADIUS: 0.630
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.529	0.468
2:	0.682	0.410
3:	0.447	-0.961
4:	0.829	-0.945
5:	-0.040	-0.079
6:	-0.212	0.263
7:	-0.527	0.248
8:	-0.614	-0.028
9:	-0.450	0.112
10:	-0.234	0.116

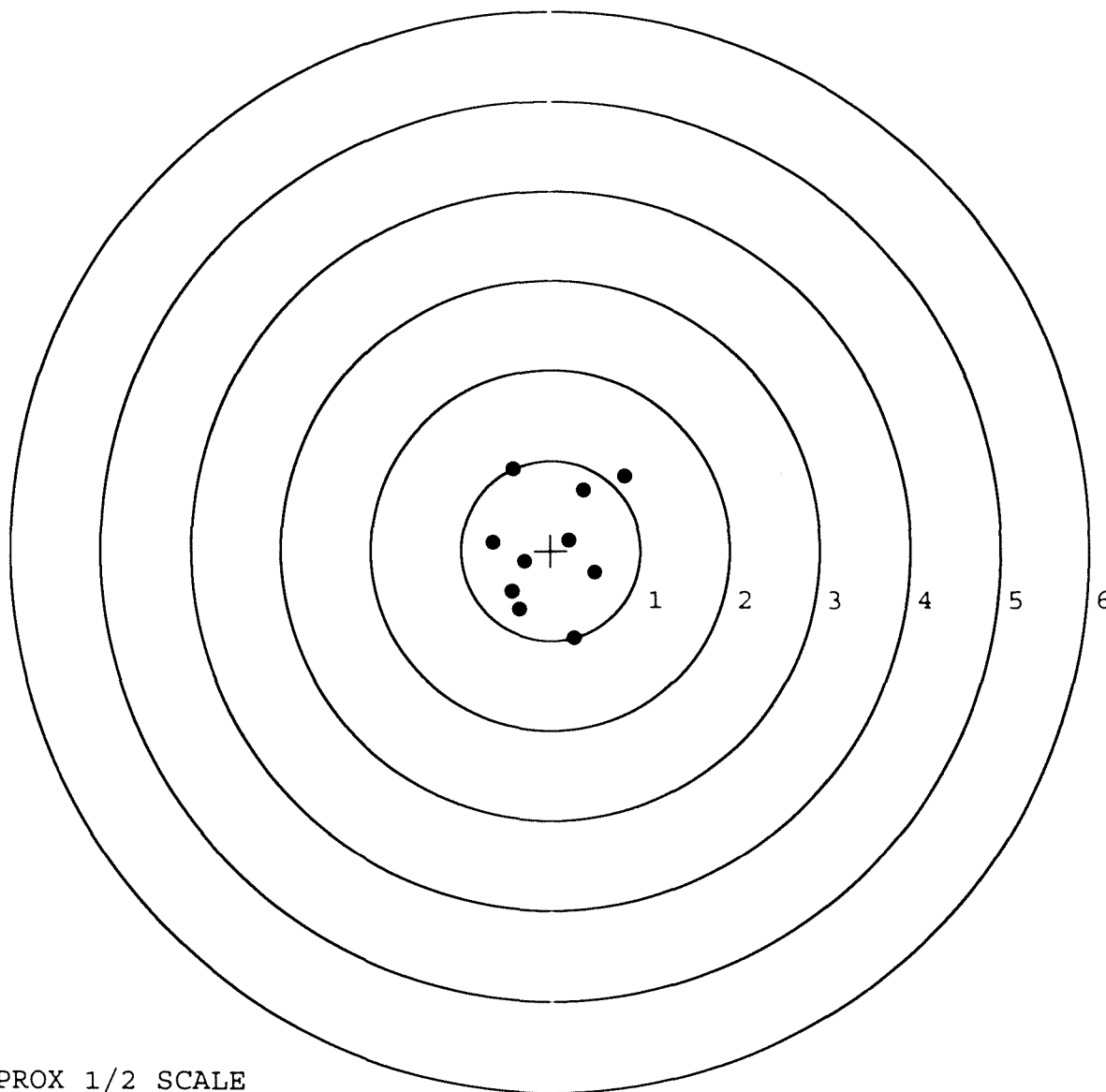


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6863586. __0
TARGET NUMBER: 2
FILE DATE: 09/23/2009
FILE TIME: 08:16

X CENTROID: -0.002
Y CENTROID: 0.013
POA TO CENTROID: 0.013
HORZ SPREAD: 1.464
VERT SPREAD: 1.881
GROUP SPREAD: 1.897
MIN RADIUS: 0.228
MAX RADIUS: 1.158
MEAN RADIUS: 0.707
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.823	0.825
2:	-0.422	0.902
3:	0.366	0.667
4:	0.201	0.117
5:	0.490	-0.249
6:	0.254	-0.979
7:	-0.358	-0.659
8:	-0.436	-0.460
9:	-0.297	-0.124
10:	-0.641	0.087

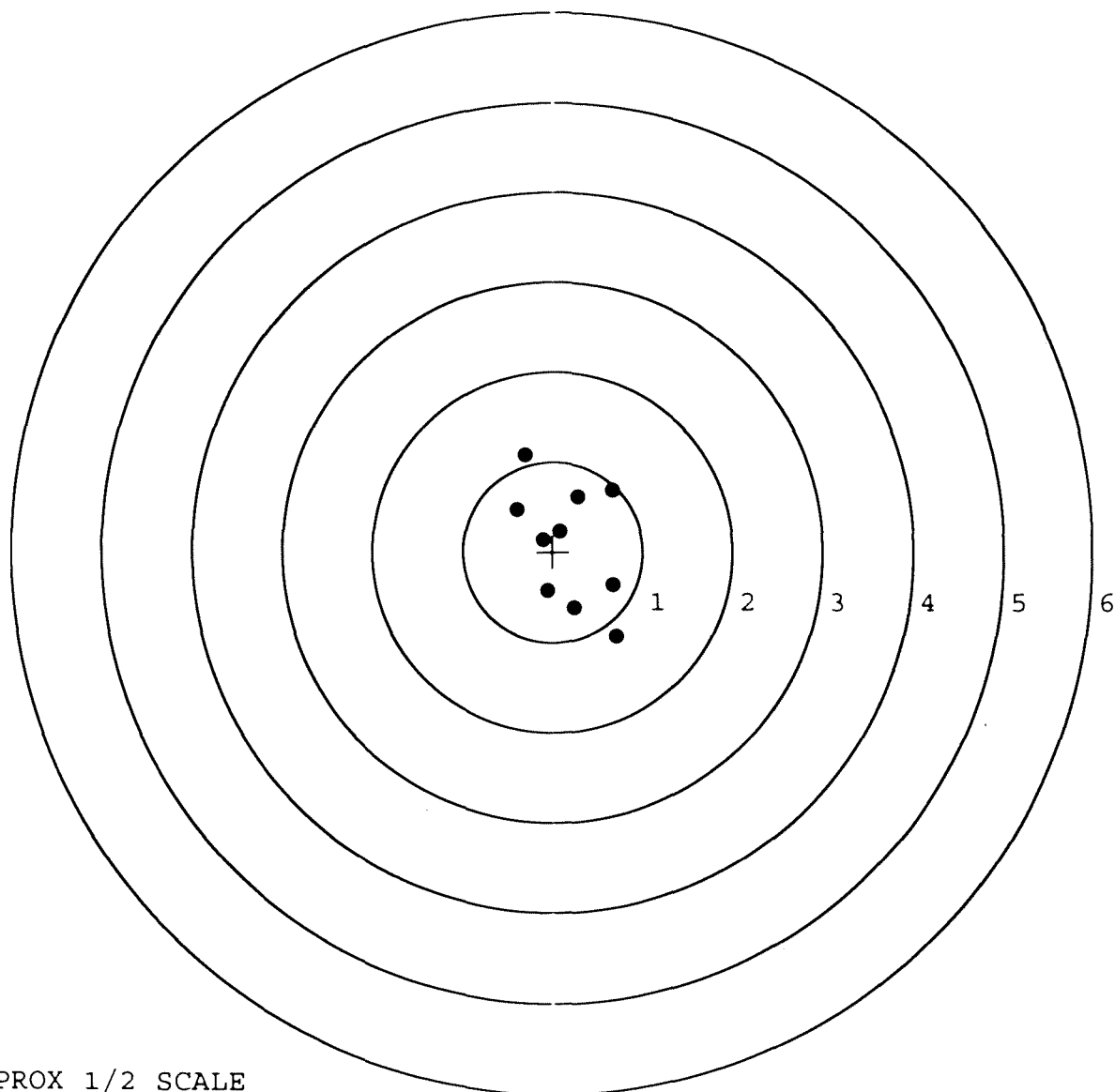


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6863586. 0
TARGET NUMBER: 3
FILE DATE: 09/23/2009
FILE TIME: 08:16

X CENTROID: 0.174
Y CENTROID: 0.084
POA TO CENTROID: 0.194
HORZ SPREAD: 1.113
VERT SPREAD: 2.015
GROUP SPREAD: 2.258
MIN RADIUS: 0.173
MAX RADIUS: 1.151
MEAN RADIUS: 0.668
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.708	-0.935
2:	0.235	-0.625
3:	0.668	-0.370
4:	-0.060	-0.439
5:	-0.310	1.080
6:	-0.405	0.473
7:	0.663	0.682
8:	0.275	0.608
9:	0.083	0.231
10:	-0.113	0.139

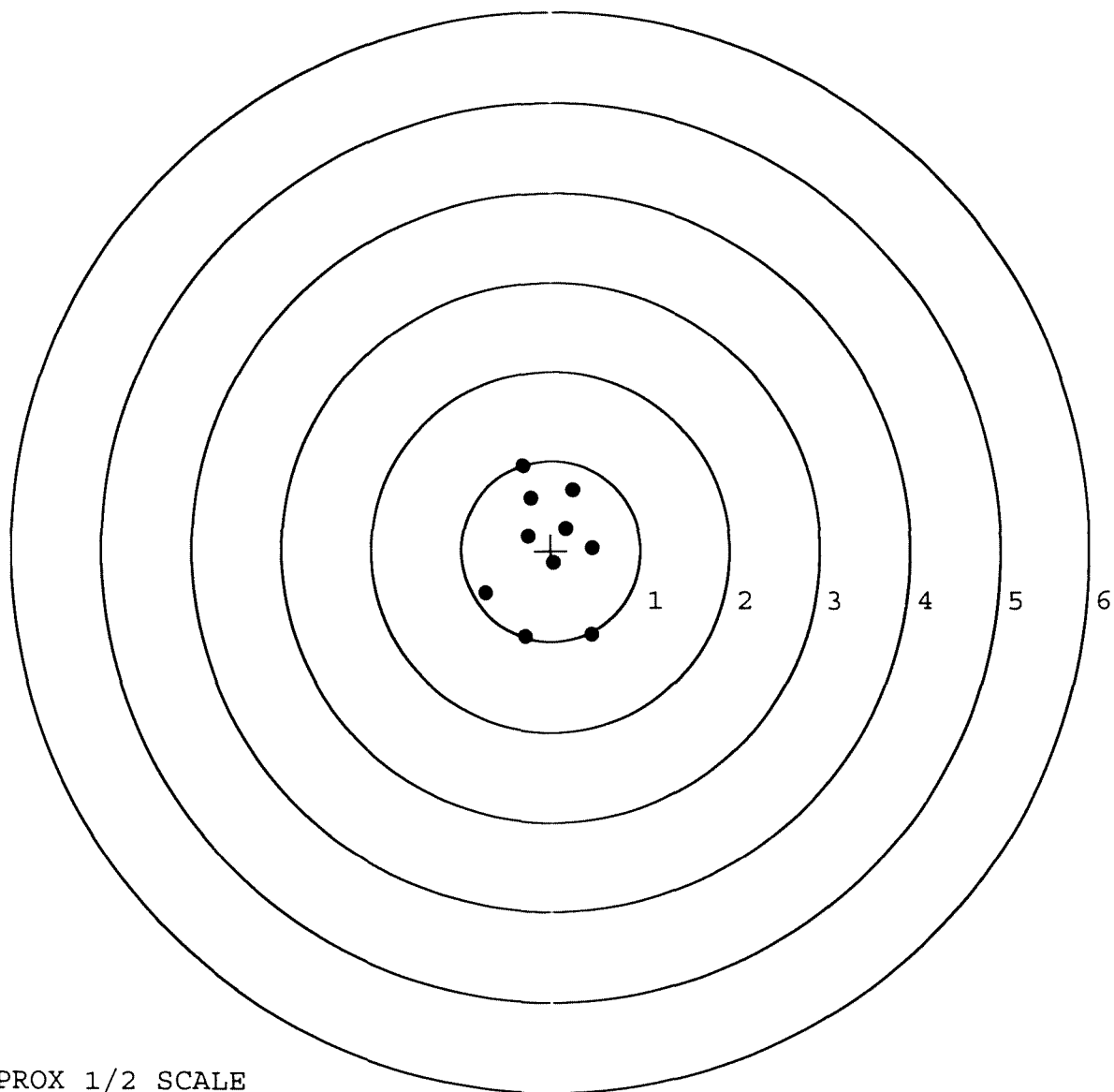


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6863586. __0
TARGET NUMBER: 4
FILE DATE: 09/23/2009
FILE TIME: 08:16

X CENTROID: -0.047
Y CENTROID: 0.013
POA TO CENTROID: 0.049
HORZ SPREAD: 1.188
VERT SPREAD: 1.889
GROUP SPREAD: 2.023
MIN RADIUS: 0.170
MAX RADIUS: 1.066
MEAN RADIUS: 0.642
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.727	-0.476
2:	-0.295	-0.947
3:	0.450	-0.930
4:	0.031	-0.138
5:	-0.257	0.162
6:	0.461	0.030
7:	0.166	0.240
8:	0.245	0.668
9:	-0.230	0.582
10:	-0.318	0.942

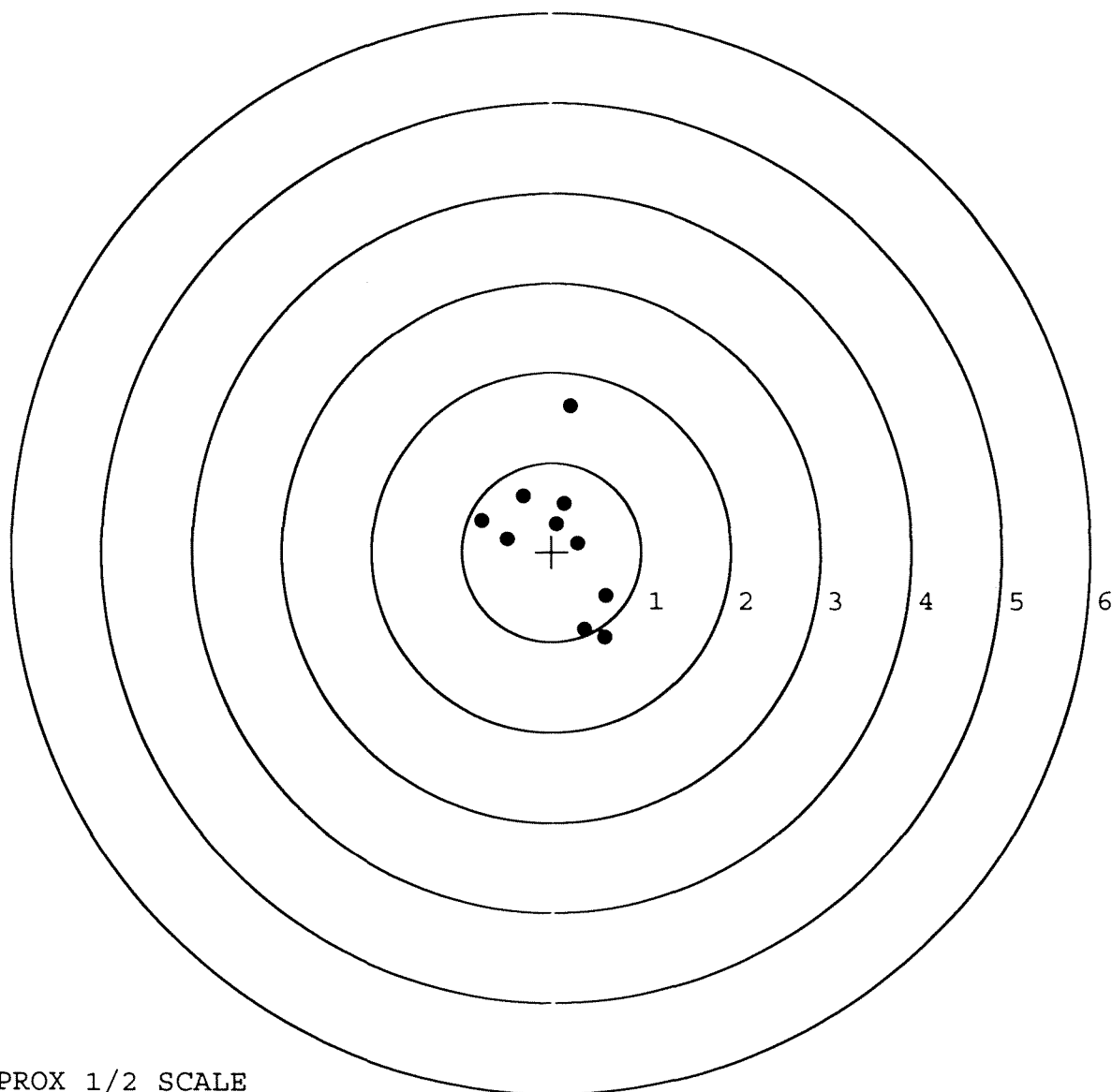


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6863586. 0
TARGET NUMBER: 5
FILE DATE: 09/23/2009
FILE TIME: 08:16

X CENTROID: 0.063
Y CENTROID: 0.140
POA TO CENTROID: 0.154
HORZ SPREAD: 1.385
VERT SPREAD: 2.580
GROUP SPREAD: 2.608
MIN RADIUS: 0.176
MAX RADIUS: 1.490
MEAN RADIUS: 0.747
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.362	-0.870
2:	0.590	-0.957
3:	0.602	-0.495
4:	-0.783	0.360
5:	-0.497	0.151
6:	0.291	0.099
7:	0.050	0.315
8:	0.136	0.542
9:	-0.325	0.631
10:	0.209	1.623



TARGET APPROX 1/2 SCALE

M(BOL 24" DDC

ORDER 25716

MODEL 700TH M24

UPC



ORDER 25716

MODEL 700TH M24

UPC



SERIAL NO.



E6703416

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
E6703416

ORDER NO.
25716

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



5716 E6703416

11CV

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

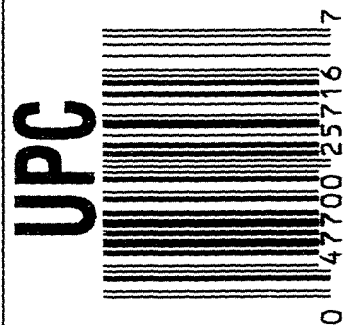


ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

E6703416



GUN SERIAL # E6703416

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		4/3/01	CK
600	PROOF		↓	↓
607	CHECK HEADSPACE		↓	↓
610	DIS-ASSEMBLE GUN			
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT			
615	ROLLMARK CALIBER			
617	DRILL AND TAP SIGHT HOLES		3/24/01	DA
618	POLISH BARREL			
620	APPLY COATINGS (BARREL ACTION)			
	(BOLT)			
625	FINAL ASSEMBLY		3/25/01	DA
	A) CLEAN INSIDE OF BOLT ASSEMBLY			
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		"	"
	C) INSPECT EJECTOR HOLE FOR CHAMFER		"	"
	D) OIL FIRING PIN ASSEMBLY		4/4/01	CK
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE		"	"

OP #	OPERATION NAME	READINGS			DATE	INITIAL		
625	F) SAFETY ON FORCE	<u>8.0</u>	<u>7.0</u>	<u>7.0</u>	4/5/01	DA		
CONT.					"	"		
	G) SAFETY OFF FORCE	<u>3.0</u>	<u>3.5</u>	<u>3.0</u>				
	H) TRIGGER PULL TEST AND RETAINABILITY							
	I) FIRING PIN INDENT	<u>.022</u>	<u>.023</u>	<u>.023</u>	4/5/01	DA		
	J) ASSEMBLE STOCK				4-3-01	C/C		
	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				4-4-01	PLH		
	A) MALFUNCTIONS	opens head. Rough Chamber			4-4-01	PLH		
	B) PIERCED PRIMERS				4-4-01	PLH		
645	INSPECT FOR LIVE AMMO				4-4-01	PLH		
655	FINAL INSPECTION A) HEADSPACE				4-4-01	RW		
	B) TRIGGER PULL	<u>2.78</u>	<u>2.75</u>	<u>2.76</u>	<u>2.66</u>	<u>2.75</u>	4/5/01	DA
	C) FUNCTION							
660	PACK				4/6/01	DA		

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. E6703416

DATE 3/01

TESTER RW

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.24	2.61		2.45	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.27	2.27		2.46	
PULL #3	2.37	2.19		2.46	
PULL #4	2.49	2.24		2.50	
PULL #5	2.47	2.09		2.51	
TOTAL	11.84	11.40		12.38	
AVG.	2.37	2.28		2.48	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.41	3.43		
PULL #2	3.35	3.53		
PULL #3	3.43	3.52		
PULL #4	3.47	3.41		
PULL #5	3.39	3.41		
TOTAL	17.05	17.30		
AVG.	3.41	3.46		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.01	4.35		4.59
PULL #2	4.16	4.42		4.58
PULL #3	4.25	4.34		4.55
PULL #4	4.41	4.31		4.41
PULL #5	4.42	4.33		4.55
TOTAL	21.25	21.75		22.68
AVG.	4.25	4.35		4.54

Remington Test Lab, Ilion, N.Y.

Centroidal distance calculations for Rifle # E6703416
5 Apr 2001

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0484
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .058
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0755418

THE AMR FOR THIS RIFLE IS: .9156

CENTROIDAL DISTANCES

0	TO	1	.0300666
1	TO	2	.300222
1	TO	3	.070859
1	TO	4	.146813
1	TO	5	.185801

$25 \frac{4}{13}$ <----POA

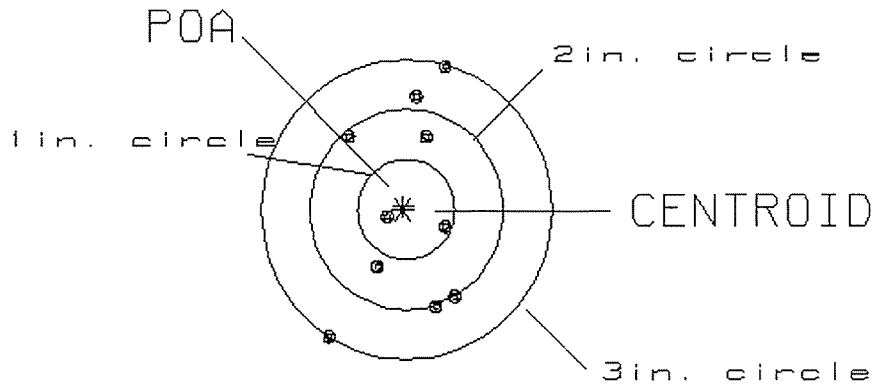
PATTERN #: ☐ 1 ☐

POA TO CENTROID: .030
 MIN RADIUS : .169
 MEAN RADIUS : .904
 MAX RADIUS : 1.474
 CENTROID X : -.002
 CENTROID Y : -.030

5 Apr 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/E6703416

CENTERFIRE PATTERN # 1



OF SHOTS= 10

IN CIRCLE

HS= 1.21
 VS= 2.69
 GS= 2.91

2
 6
 10

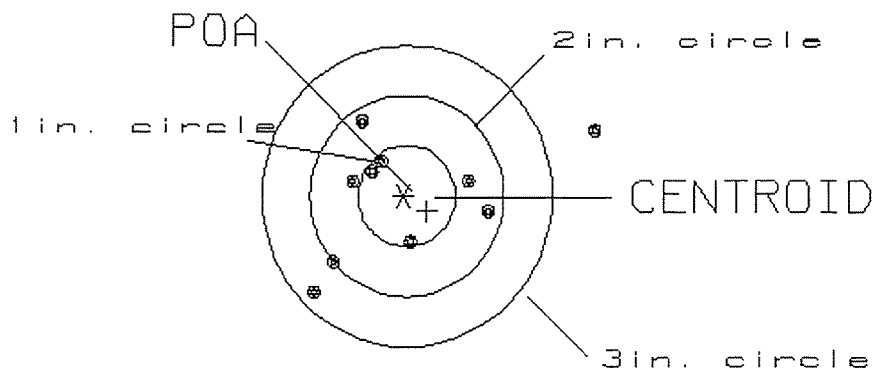
PATTERN #: ☐ 2 ☐

POA TO CENTROID: .284
MIN RADIUS : .427
MEAN RADIUS : .852
MAX RADIUS : 2.008
CENTROID X : -.240
CENTROID Y : .153

5 Apr 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/E6703416

CENTERFIRE PATTERN # 2



OF SHOTS= 10

IN CIRCLE

HS= 2.90

3

VS= 1.64

7

GS= 3.29

9

PATTERN #: ☐ 3 ☐

POA TO CENTROID: .071

MIN RADIUS : .090

MEAN RADIUS : .772

MAX RADIUS : 1.437

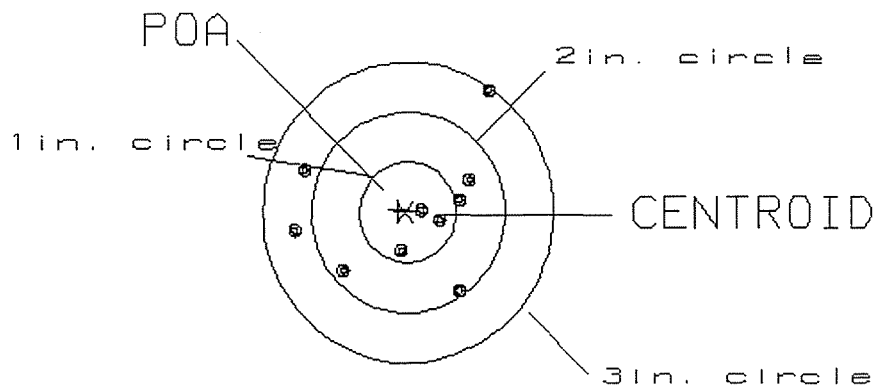
CENTROID X : .068

CENTROID Y : -.019

5 Apr 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/E6703416

CENTERFIRE PATTERN # 3



OF SHOTS= 10

IN CIRCLE

HS= 2.00

3

VS= 1.97

7

GS= 2.45

10

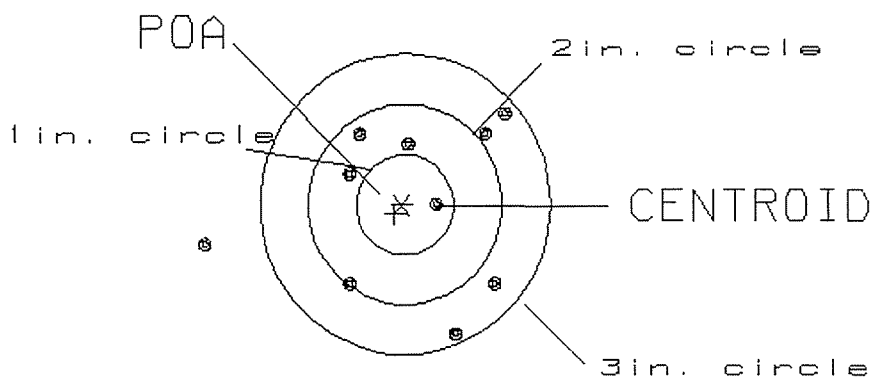
PATTERN #: ☐ 4 ☐

POA TO CENTROID: .121
MIN RADIUS : .328
MEAN RADIUS : 1.056
MAX RADIUS : 2.096
CENTROID X : .075
CENTROID Y : .095

5 Apr 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/E6703416

CENTERFIRE PATTERN # 4



OF SHOTS= 10

IN CIRCLE

HS= 3.13

1

VS= 2.14

5

GS= 3.37

9

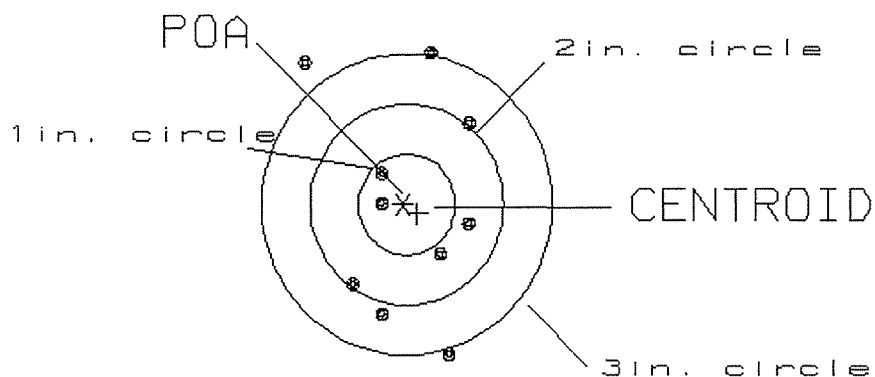
PATTERN #: ☐ 5 ☐

POA TO CENTROID: .170
 MIN RADIUS : .271
 MEAN RADIUS : .994
 MAX RADIUS : 1.716
 CENTROID X : -.143
 CENTROID Y : .091

5 Apr 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/E6703416

CENTERFIRE PATTERN # 5



OF SHOTS= 10

IN CIRCLE

HS= 1.69
 VS= 3.01
 GS= 3.24

2
 5
 7