

G 6590230  
Refuse  
C-6611496

## Arms Services Repair &amp; Estimate System

File Add Repair Estimate Repair Expedite Repair Inquiry Repair Tools CSR Tools Reports Table Maintenance System Maintenance Help

## Repair Inquiry

Repair Number: RE00131867

Serial: C6611496 Model M24 SWS Center Fire  
Caliber: 7.62 NATO Produced: 06/19/1991

Repairman:

Verify Repair

Status:

Closed 7/30/2007 9:46:53 AM

## Address Information

Customer: ☒ Received From  
 Name: 0002 AR RGT 03 B CO INF BN BCT (WDA6B0)  
 Address 1: ROSE BARRACKS  
 Address 2: SOUTH CAMP BLDG 728 PO Box:  
 City: MILSECK  
 State: DE Zip Code: 92249 Country: US

Return To: ☒ Received From  
 Name: 0002 AR RGT 03 B CO INF BN BCT (WDA6B0)  
 Address 1: ROSE BARRACKS  
 Address 2: SOUTH CAMP BLDG 728 PO Box:  
 City: MILSECK  
 State: DE Zip Code: 92249 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   |
| A026 | Scope                 | 1   |
| A055 | Deployment Kit        | 1   |
| A057 | Fit and Rear Sgt Base | 1   |

## Repair Search

## Refresh

## Close

naglelj

7/31/2007

9:06 AM

CAPS

NUM

INS

SCRL

start

2 M.

6 I.

3 M.

Par...

SA...

Ar...

Re...

9:06 AM

G659 0230 (New)

Serial Number: ~~C6611496~~

Model: M24 SWS



RE00131867

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6590230.\_\_\_0  
FILE DATE AND TIME: 08/21/2007 00:55

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

|                                                             |        |
|-------------------------------------------------------------|--------|
| The Average X Centroid of the Five Target Set:              | 0.126  |
| The Average Y Centroid of the Five Target Set:              | -0.004 |
| The Average Point of Impact of the Five Target Set:         | 0.126  |
| The Average Mean Radius of the Five Target Set:             | 0.620  |
| The Distance from POA to Centroid Target #1:                | 0.140  |
| The Distance from Centroid Target #2 to Centroid Target #1: | 0.346  |
| The Distance from Centroid Target #3 to Centroid Target #1: | 0.258  |
| The Distance from Centroid Target #4 to Centroid Target #1: | 0.165  |
| The Distance from Centroid Target #5 to Centroid Target #1: | 0.432  |

SERIAL NUMBER: G6590230. \_\_0

TARGET NUMBER: 1

FILE DATE: 08/21/2007

FILE TIME: 00:55

X CENTROID: -0.071

Y CENTROID: -0.121

POA TO CENTROID: 0.140

HORZ SPREAD: 2.497

VERT SPREAD: 1.984

GROUP SPREAD: 2.851

MIN RADIUS: 0.270

MAX RADIUS: 1.849

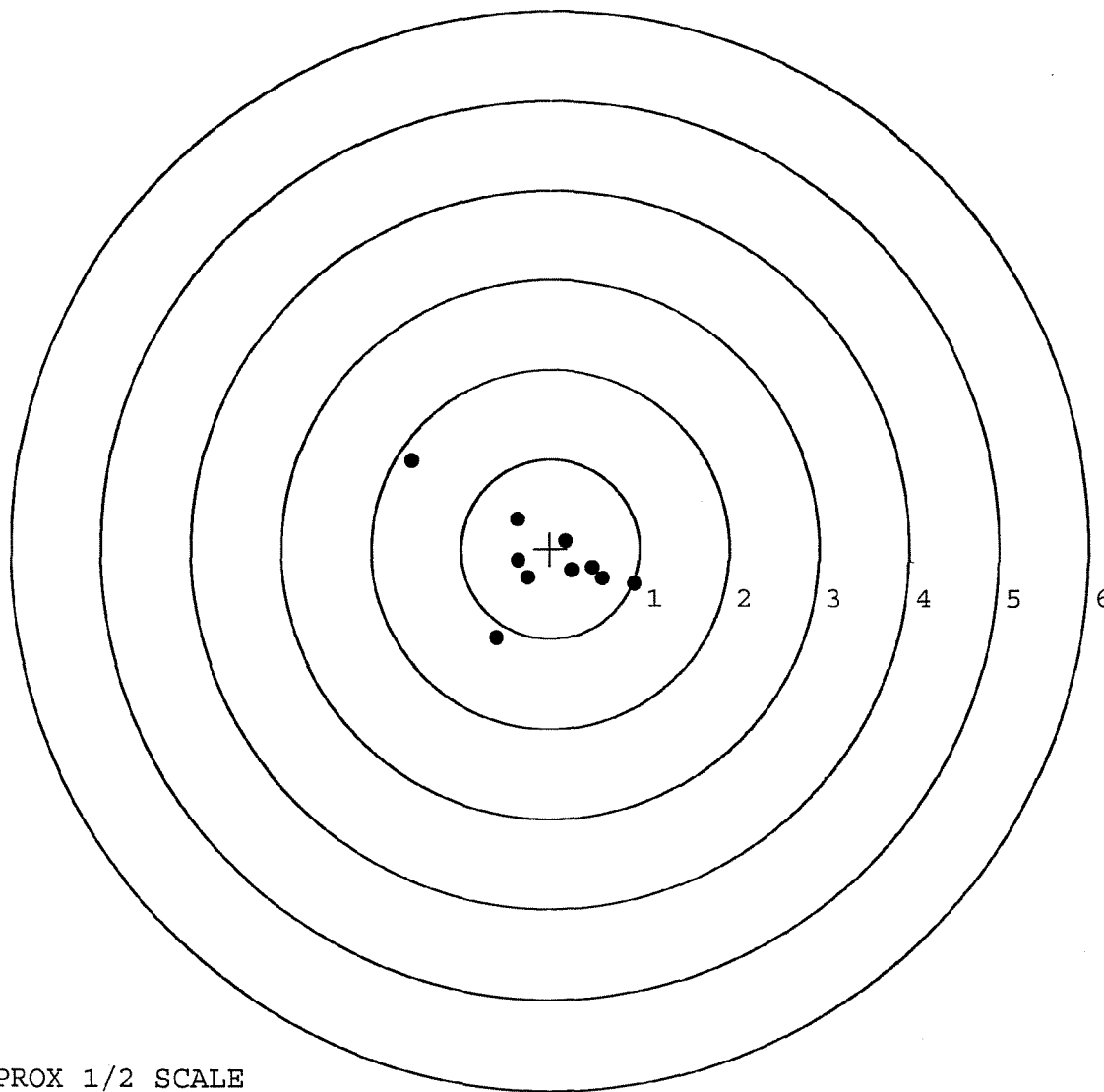
MEAN RADIUS: 0.694

# IN 1 IN DIAMETER: 4

# IN 2 IN DIAMETER: 7

# in 3 IN DIAMETER: 9

| POINT# | X      | Y      |
|--------|--------|--------|
| 1:     | -0.370 | 0.340  |
| 2:     | -0.359 | -0.131 |
| 3:     | -0.253 | -0.320 |
| 4:     | -0.603 | -0.998 |
| 5:     | 0.172  | 0.093  |
| 6:     | 0.244  | -0.241 |
| 7:     | 0.588  | -0.333 |
| 8:     | 0.945  | -0.390 |
| 9:     | 0.479  | -0.213 |
| 10:    | -1.552 | 0.986  |



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590230. \_\_0

TARGET NUMBER: 2

FILE DATE: 08/21/2007

FILE TIME: 00:55

X CENTROID: 0.267

Y CENTROID: -0.045

POA TO CENTROID: 0.270

HORZ SPREAD: 1.721

VERT SPREAD: 2.101

GROUP SPREAD: 2.113

MIN RADIUS: 0.083

MAX RADIUS: 1.203

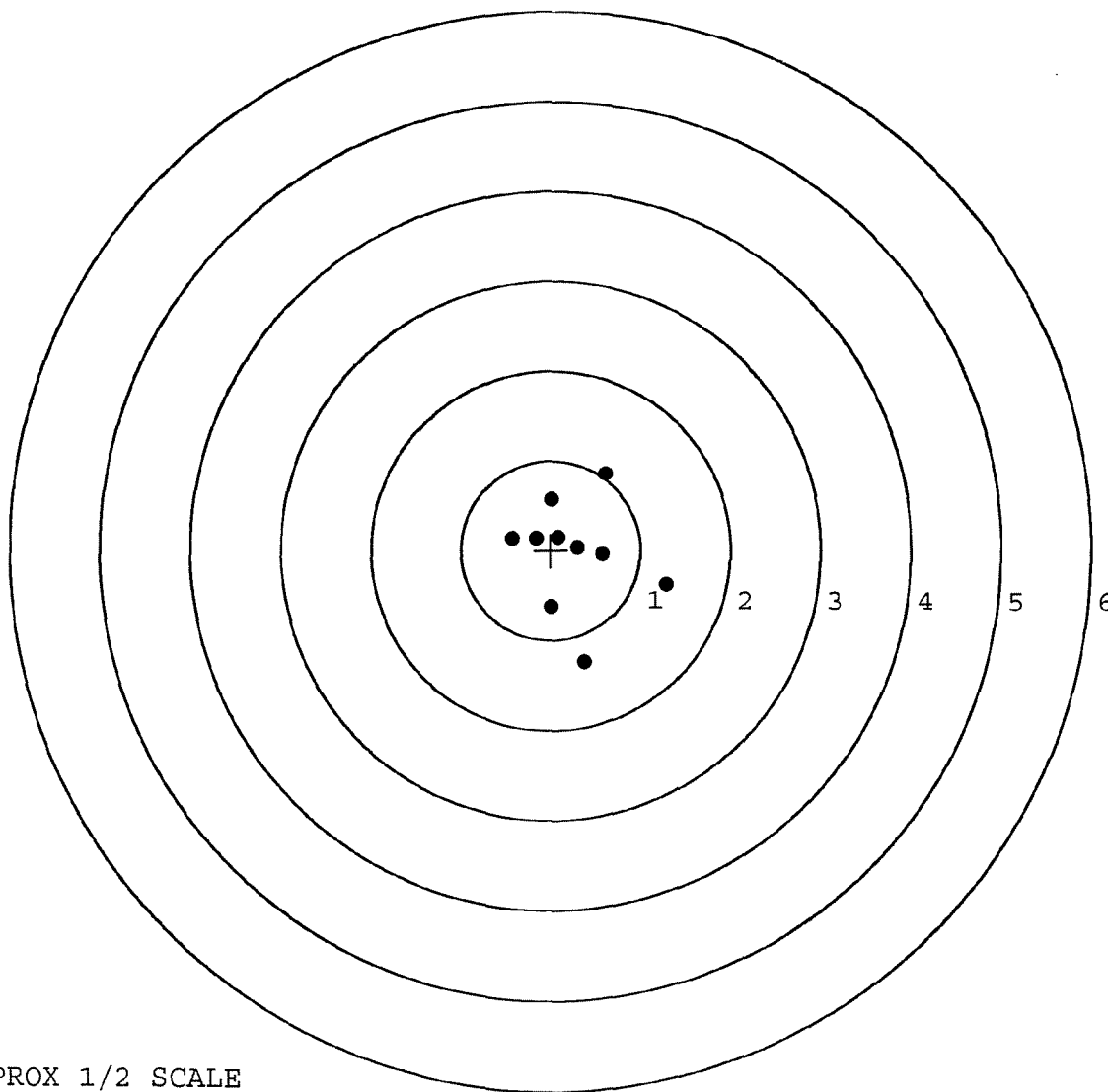
MEAN RADIUS: 0.640

# IN 1 IN DIAMETER: 4

# IN 2 IN DIAMETER: 8

# in 3 IN DIAMETER: 10

| POINT# | X      | Y      |
|--------|--------|--------|
| 1:     | 0.611  | 0.859  |
| 2:     | 1.290  | -0.381 |
| 3:     | 0.382  | -1.242 |
| 4:     | 0.010  | -0.633 |
| 5:     | -0.431 | 0.127  |
| 6:     | -0.166 | 0.128  |
| 7:     | 0.082  | 0.142  |
| 8:     | 0.011  | 0.572  |
| 9:     | 0.299  | 0.032  |
| 10:    | 0.578  | -0.049 |



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590230. \_\_0

TARGET NUMBER: 3

FILE DATE: 08/21/2007

FILE TIME: 00:55

| POINT# | X      | Y      |
|--------|--------|--------|
| 1:     | 1.245  | 0.068  |
| 2:     | 0.752  | 0.097  |
| 3:     | 0.468  | 0.017  |
| 4:     | 0.012  | 0.232  |
| 5:     | 0.289  | -0.010 |
| 6:     | 0.281  | -0.257 |
| 7:     | -0.066 | -0.052 |
| 8:     | -0.266 | -0.019 |
| 9:     | -0.465 | -0.159 |
| 10:    | -0.641 | 0.001  |

X CENTROID: 0.161

Y CENTROID: -0.008

POA TO CENTROID: 0.161

HORZ SPREAD: 1.886

VERT SPREAD: 0.489

GROUP SPREAD: 1.887

MIN RADIUS: 0.128

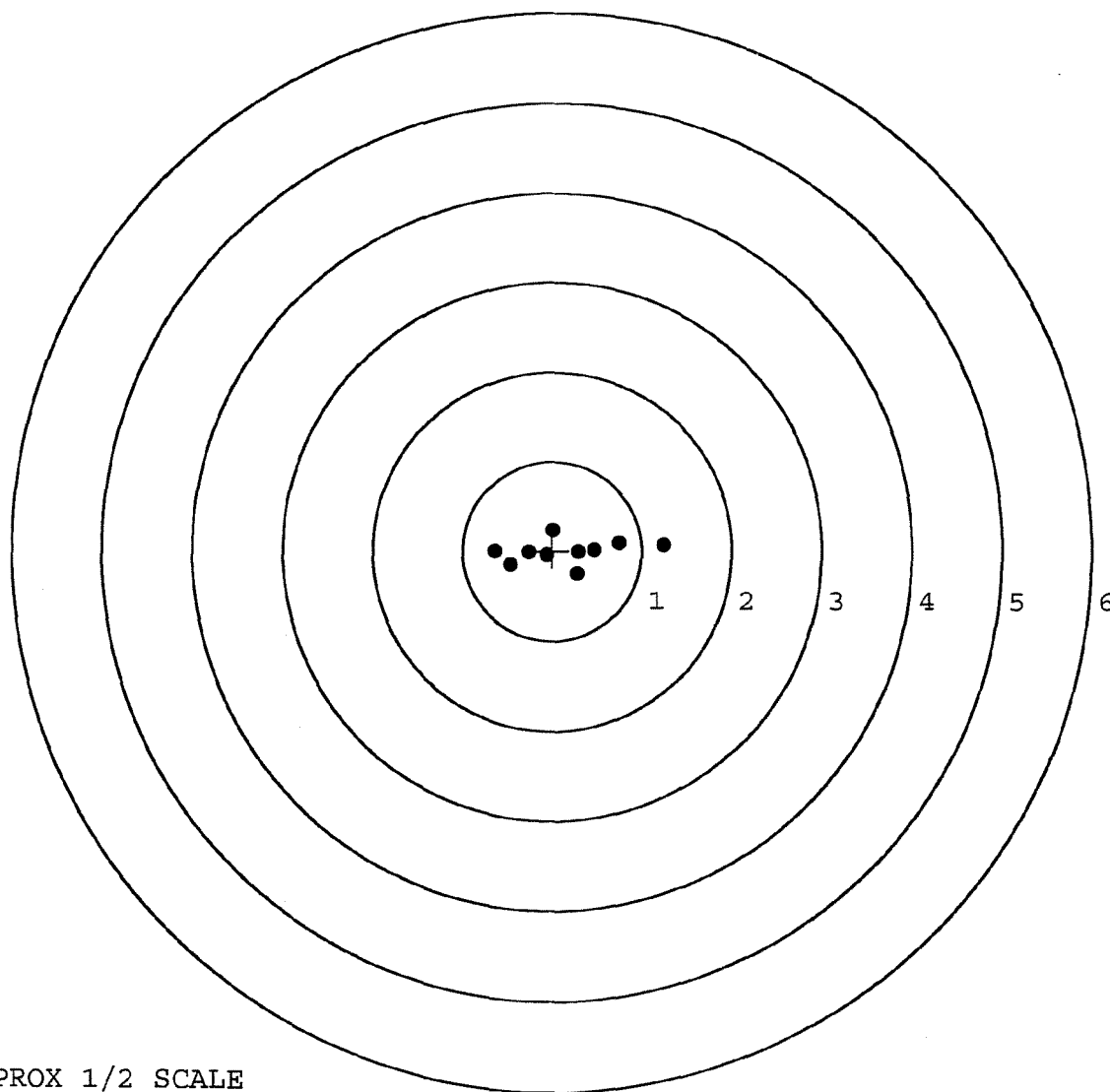
MAX RADIUS: 1.087

MEAN RADIUS: 0.479

# IN 1 IN DIAMETER: 6

# IN 2 IN DIAMETER: 9

# in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590230. \_\_0

TARGET NUMBER: 4

FILE DATE: 08/21/2007

FILE TIME: 00:55

| POINT# | X      | Y      |
|--------|--------|--------|
| 1:     | -0.307 | 0.552  |
| 2:     | 0.023  | 0.767  |
| 3:     | 0.213  | 0.271  |
| 4:     | 0.748  | 0.071  |
| 5:     | 0.617  | -0.112 |
| 6:     | 0.145  | -0.369 |
| 7:     | 0.202  | -0.743 |
| 8:     | -0.243 | -0.369 |
| 9:     | -0.597 | -0.065 |
| 10:    | 0.058  | -0.702 |

X CENTROID: 0.086

Y CENTROID: -0.070

POA TO CENTROID: 0.111

HORZ SPREAD: 1.345

VERT SPREAD: 1.510

GROUP SPREAD: 1.521

MIN RADIUS: 0.305

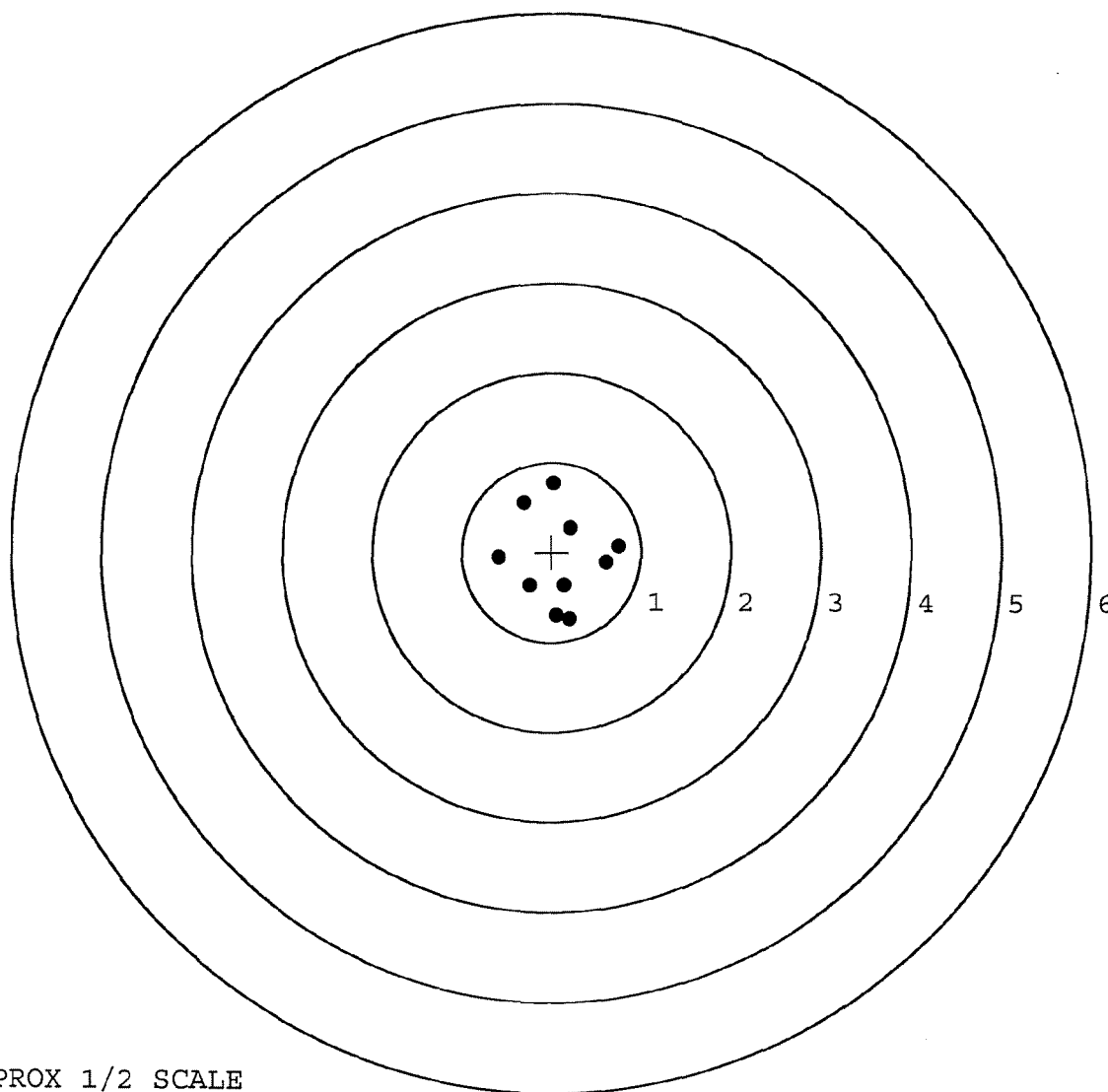
MAX RADIUS: 0.839

MEAN RADIUS: 0.590

# IN 1 IN DIAMETER: 3

# IN 2 IN DIAMETER: 10

# in 3 IN DIAMETER: 10

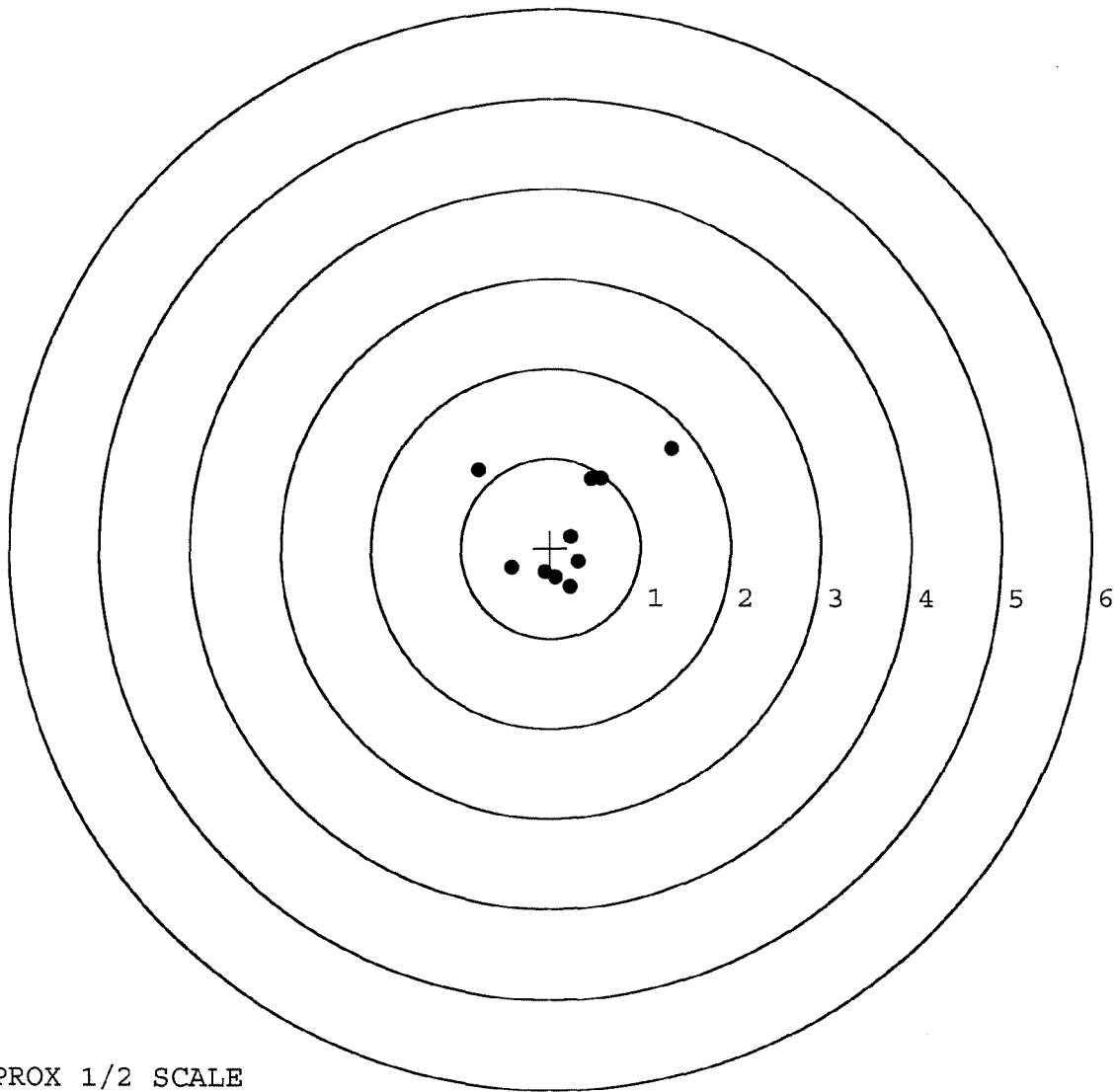


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590230. 0  
TARGET NUMBER: 5  
FILE DATE: 08/21/2007  
FILE TIME: 00:55

X CENTROID: 0.187  
Y CENTROID: 0.226  
POA TO CENTROID: 0.293  
HORZ SPREAD: 2.147  
VERT SPREAD: 1.542  
GROUP SPREAD: 2.214  
MIN RADIUS: 0.105  
MAX RADIUS: 1.452  
MEAN RADIUS: 0.698  
# IN 1 IN DIAMETER: 2  
# IN 2 IN DIAMETER: 8  
# in 3 IN DIAMETER: 10

| POINT# | X      | Y      |
|--------|--------|--------|
| 1:     | -0.806 | 0.872  |
| 2:     | 0.451  | 0.776  |
| 3:     | 0.564  | 0.784  |
| 4:     | 1.341  | 1.106  |
| 5:     | 0.224  | -0.436 |
| 6:     | 0.311  | -0.153 |
| 7:     | 0.221  | 0.126  |
| 8:     | 0.054  | -0.332 |
| 9:     | -0.061 | -0.268 |
| 10:    | -0.433 | -0.218 |



TARGET APPROX 1/2 SCALE



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

|               |                         |  |  |  |
|---------------|-------------------------|--|--|--|
| R & E NUMBER  | 131 867                 |  |  |  |
| SERIAL NUMBER | C6611496 G6590230 (New) |  |  |  |
| LOG-IN DATE   | 7-30-07                 |  |  |  |

| OPERATION # | OPERATION NAME       | DATE                     | INITIAL     |
|-------------|----------------------|--------------------------|-------------|
| 500         | DIS-ASSEMBLE GUN     | 8-8-07                   | RTZ         |
| 505         | RE-BARREL            | 8-9-07                   | RTZ         |
| 560         | ASSEMBLE             | 8-9-07                   | RTZ         |
| 600         | PROOF                | 8-9-07                   | mm          |
| 605         | CHECK HEADSPACE      | 8-9-07                   | mm          |
| 610         | DIS-ASSEMBLE GUN     | 8-9-07                   | SD          |
| 612         | MAGNAFLUX            | 8-14-07                  | LRB         |
| 510         | DRILL AND TAP        | 8-10-07                  | TRW         |
| 615         | ROLLMARK CALIBER     | 8-10-07                  | CW          |
| 618         | ROTO-BLAST           | 8-14-07                  | LY          |
| 620         | APPLY COATINGS       | 8-15-07                  | TRB         |
| 625         | FINAL ASSEMBLY       | 8-20-07                  | RTZ         |
| 640         | FUNCTION TEST AND    | 8-20-07                  | mm          |
| 650         | TARGET               | 8-20-07                  | mm          |
|             | MALFUNCTION          | CORRECTION               |             |
|             | MALFUNCTION          | CORRECTION               |             |
|             | MALFUNCTION          | CORRECTION               |             |
|             | MALFUNCTION          | CORRECTION               |             |
| 670         | FINAL INSPECTION     | 8-20-07                  | SD          |
|             | A) HEADSPACE         | PASS FAIL                |             |
|             | B) TRIGGER PULL      | 2.36 2.64 2.68 2.73 2.52 | 8-21-07 TRW |
| 680         | F) SAFETY ON FORCE   | 4.0 4.25 4.25            | 8-21-07 TRW |
|             | G) SAFETY OFF FORCE  | 2.0 2.25 2.5             | 8-21-07 TRW |
|             | I) FIRING PIN INDENT | .0225 .0225 .0225        | 8-21-07 TRW |
| 690         | PACK                 | 8-23-07                  | RTZ         |

start 3 2

Model: 700



RE00076767

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6611496.\_\_0

FILE DATE AND TIME: 02/17/2004 07:19

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

|                                                             |        |
|-------------------------------------------------------------|--------|
| The Average X Centroid of the Five Target Set:              | 0.024  |
| The Average Y Centroid of the Five Target Set:              | -0.098 |
| The Average Point of Impact of the Five Target Set:         | 0.101  |
| The Average Mean Radius of the Five Target Set:             | 1.033  |
| The Distance from POA to Centroid Target #1:                | 0.331  |
| The Distance from Centroid Target #2 to Centroid Target #1: | 0.246  |
| The Distance from Centroid Target #3 to Centroid Target #1: | 0.440  |
| The Distance from Centroid Target #4 to Centroid Target #1: | 0.332  |
| The Distance from Centroid Target #5 to Centroid Target #1: | 0.527  |

SERIAL NUMBER: C6611496. \_\_0

TARGET NUMBER: 1

FILE DATE: 02/17/2004

FILE TIME: 07:19

| POINT# | X      | Y      |
|--------|--------|--------|
| 1:     | -0.012 | -1.690 |
| 2:     | -0.543 | -1.517 |
| 3:     | -0.455 | -1.808 |
| 4:     | -0.533 | -0.662 |
| 5:     | 0.287  | -0.468 |
| 6:     | 0.081  | 0.020  |
| 7:     | -0.325 | 0.343  |
| 8:     | -0.766 | 0.370  |
| 9:     | 0.288  | 1.194  |
| 10:    | -0.272 | 1.795  |

X CENTROID: -0.225

Y CENTROID: -0.242

POA TO CENTROID: 0.331

HORZ SPREAD: 1.054

VERT SPREAD: 3.603

GROUP SPREAD: 3.608

MIN RADIUS: 0.403

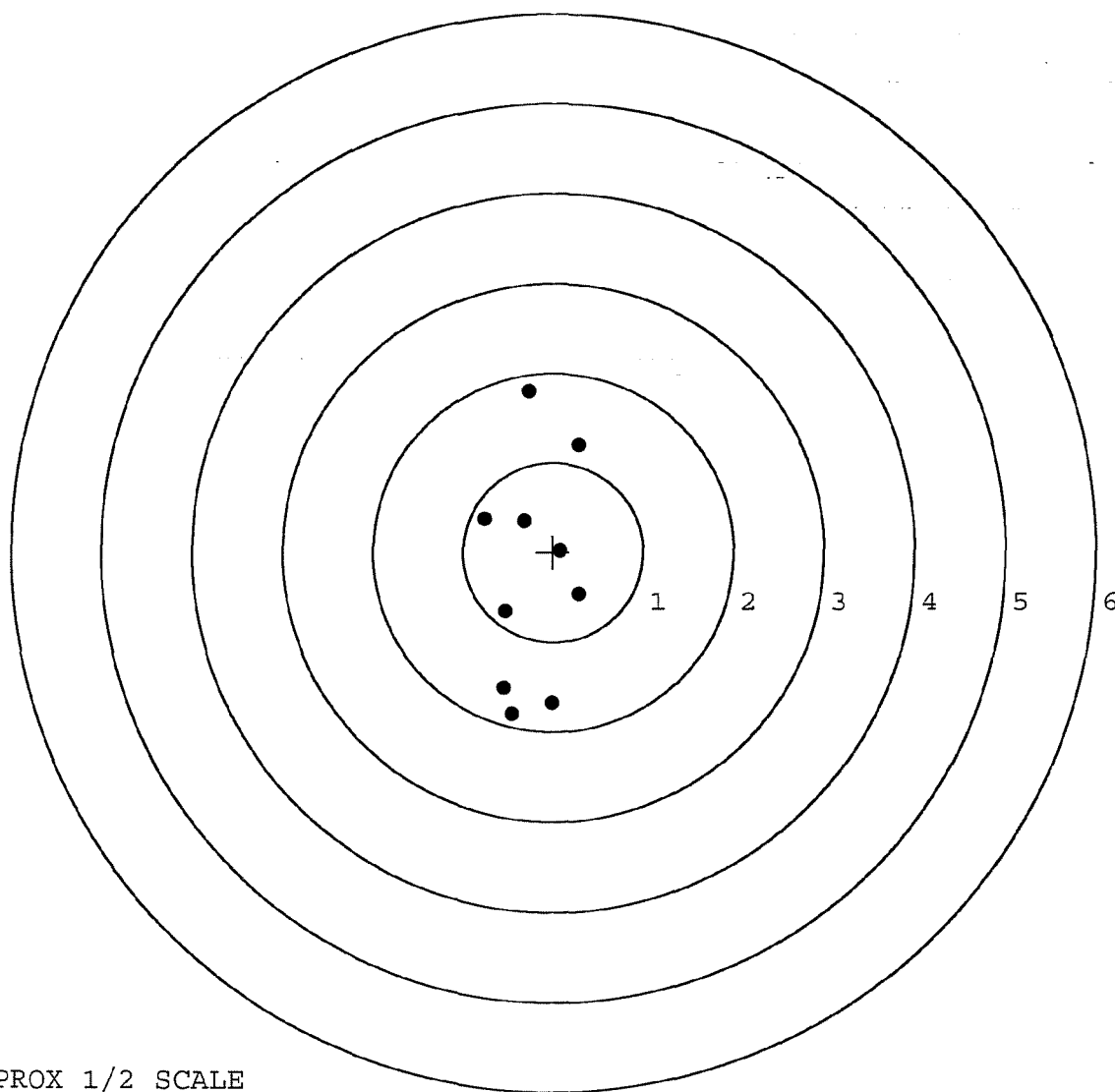
MAX RADIUS: 2.038

MEAN RADIUS: 1.082

# IN 1 IN DIAMETER: 1

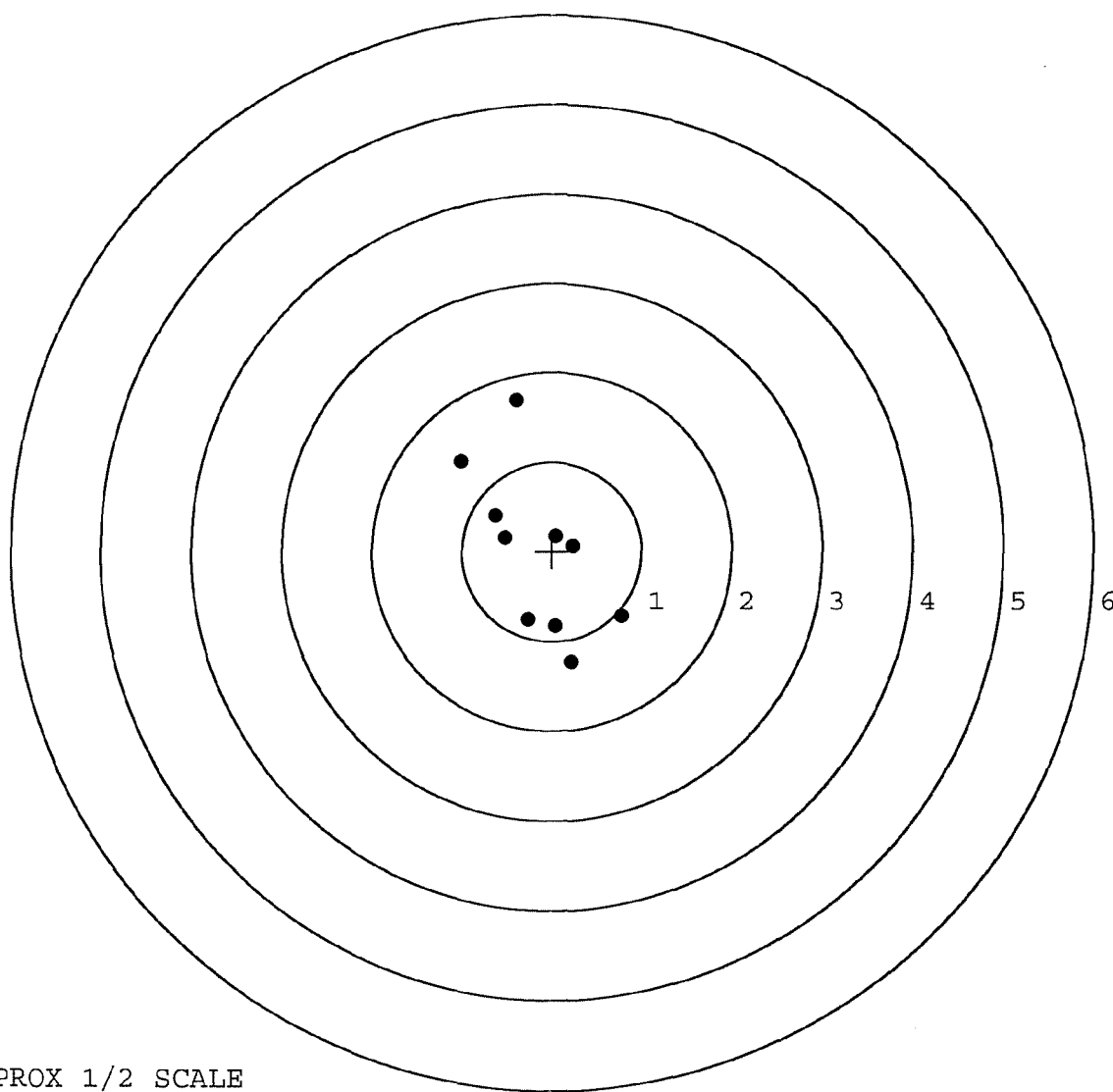
# IN 2 IN DIAMETER: 5

# in 3 IN DIAMETER: 7



TARGET APPROX 1/2 SCALE

|                              |        |        |        |
|------------------------------|--------|--------|--------|
| SERIAL NUMBER: C6611496. __0 | POINT# | X      | Y      |
| TARGET NUMBER: 2             | 1:     | 0.781  | -0.725 |
| FILE DATE: 02/17/2004        | 2:     | 0.231  | -1.238 |
| FILE TIME: 07:19             | 3:     | 0.045  | -0.837 |
|                              | 4:     | -0.266 | -0.766 |
| X CENTROID: -0.149           | 5:     | 0.239  | 0.054  |
| Y CENTROID: -0.008           | 6:     | 0.042  | 0.173  |
| POA TO CENTROID: 0.149       | 7:     | -0.524 | 0.160  |
| HORZ SPREAD: 1.792           | 8:     | -0.631 | 0.404  |
| VERT SPREAD: 2.924           | 9:     | -1.011 | 1.007  |
| GROUP SPREAD: 2.990          | 10:    | -0.394 | 1.686  |
| MIN RADIUS: 0.263            |        |        |        |
| MAX RADIUS: 1.712            |        |        |        |
| MEAN RADIUS: 0.882           |        |        |        |
| # IN 1 IN DIAMETER: 3        |        |        |        |
| # IN 2 IN DIAMETER: 6        |        |        |        |
| # in 3 IN DIAMETER: 9        |        |        |        |



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6611496. \_\_0

TARGET NUMBER: 3

FILE DATE: 02/17/2004

FILE TIME: 07:19

| POINT# | X      | Y      |
|--------|--------|--------|
| 1:     | 0.890  | -1.854 |
| 2:     | 0.315  | -1.056 |
| 3:     | 0.708  | -0.983 |
| 4:     | 0.271  | -0.303 |
| 5:     | 0.106  | -0.469 |
| 6:     | -0.095 | -0.142 |
| 7:     | 0.633  | 0.775  |
| 8:     | -0.463 | 0.753  |
| 9:     | -0.359 | 1.095  |
| 10:    | -0.334 | 1.749  |

X CENTROID: 0.167

Y CENTROID: -0.043

POA TO CENTROID: 0.173

HORZ SPREAD: 1.353

VERT SPREAD: 3.603

GROUP SPREAD: 3.805

MIN RADIUS: 0.279

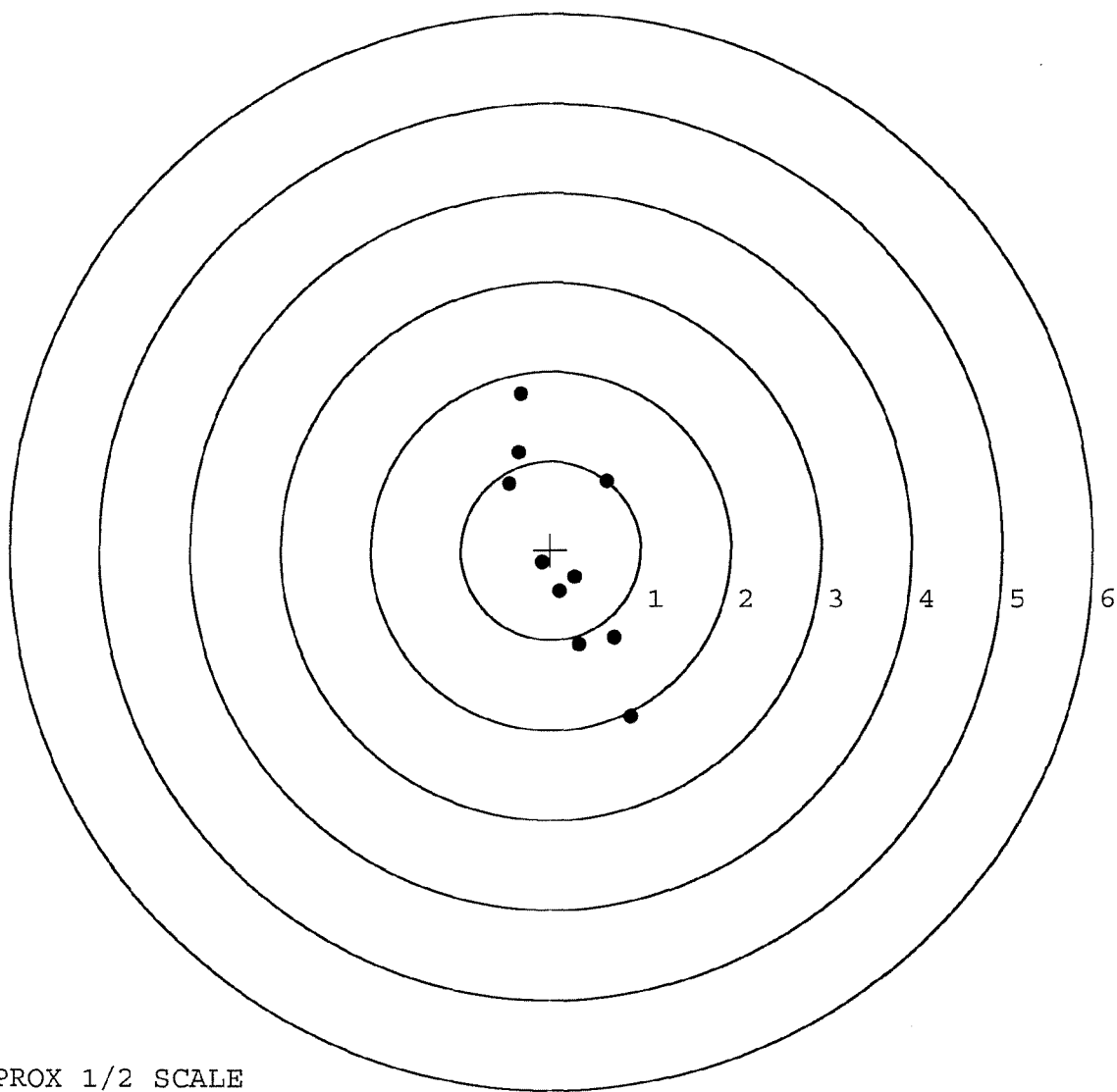
MAX RADIUS: 1.949

MEAN RADIUS: 1.012

# IN 1 IN DIAMETER: 3

# IN 2 IN DIAMETER: 4

# in 3 IN DIAMETER: 8



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6611496. \_\_0

TARGET NUMBER: 4

FILE DATE: 02/17/2004

FILE TIME: 07:19

| POINT# | X      | Y      |
|--------|--------|--------|
| 1:     | -0.019 | -2.054 |
| 2:     | -0.211 | 1.665  |
| 3:     | -0.150 | 1.411  |
| 4:     | -0.094 | 0.903  |
| 5:     | 0.027  | 0.619  |
| 6:     | -0.173 | -0.113 |
| 7:     | 0.516  | -0.578 |
| 8:     | 0.202  | -0.505 |
| 9:     | 0.188  | -0.741 |
| 10:    | 0.013  | -0.906 |

X CENTROID: 0.030

Y CENTROID: -0.030

POA TO CENTROID: 0.042

HORZ SPREAD: 0.727

VERT SPREAD: 3.719

GROUP SPREAD: 3.724

MIN RADIUS: 0.219

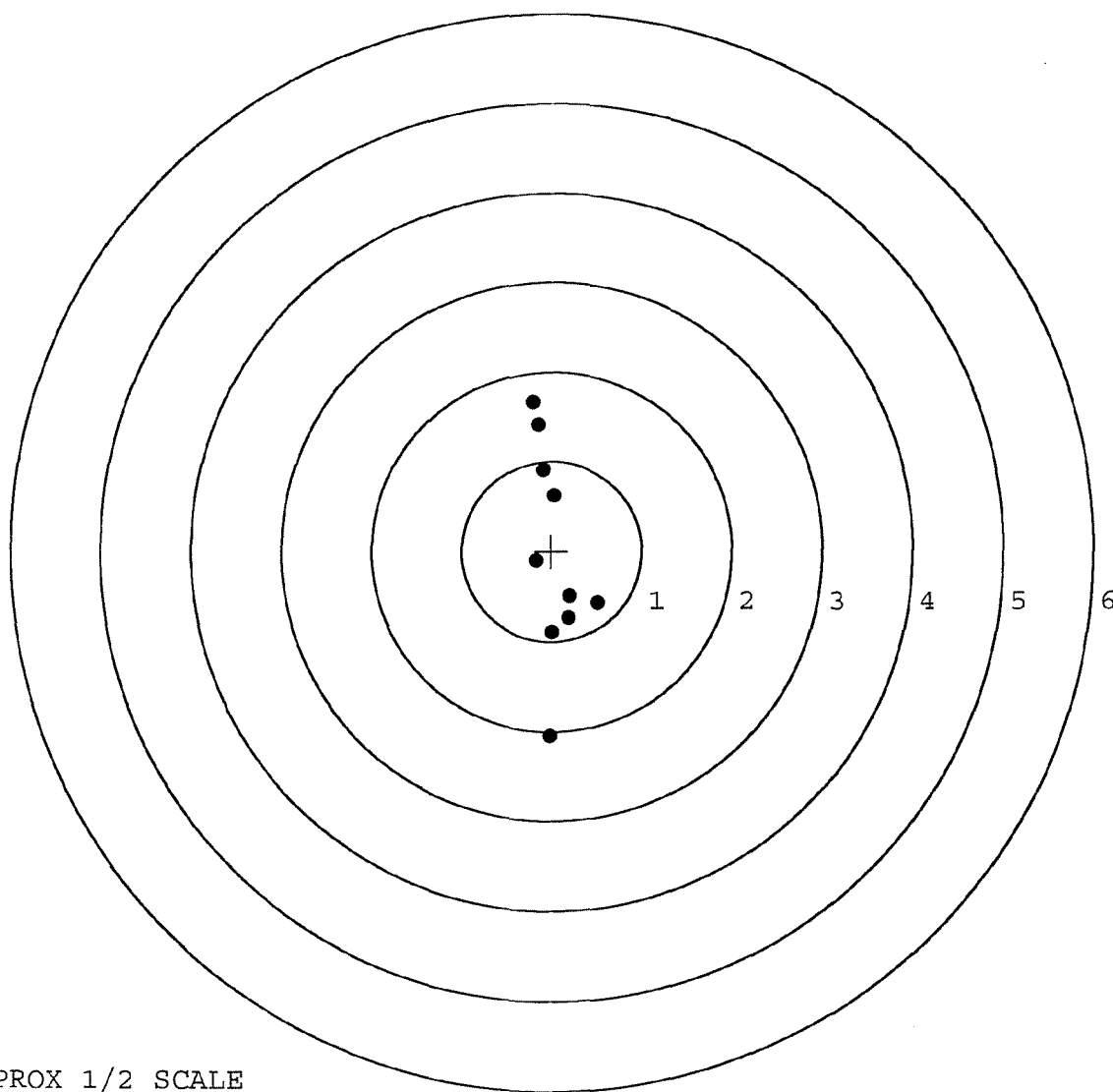
MAX RADIUS: 2.025

MEAN RADIUS: 0.984

# IN 1 IN DIAMETER: 1

# IN 2 IN DIAMETER: 7

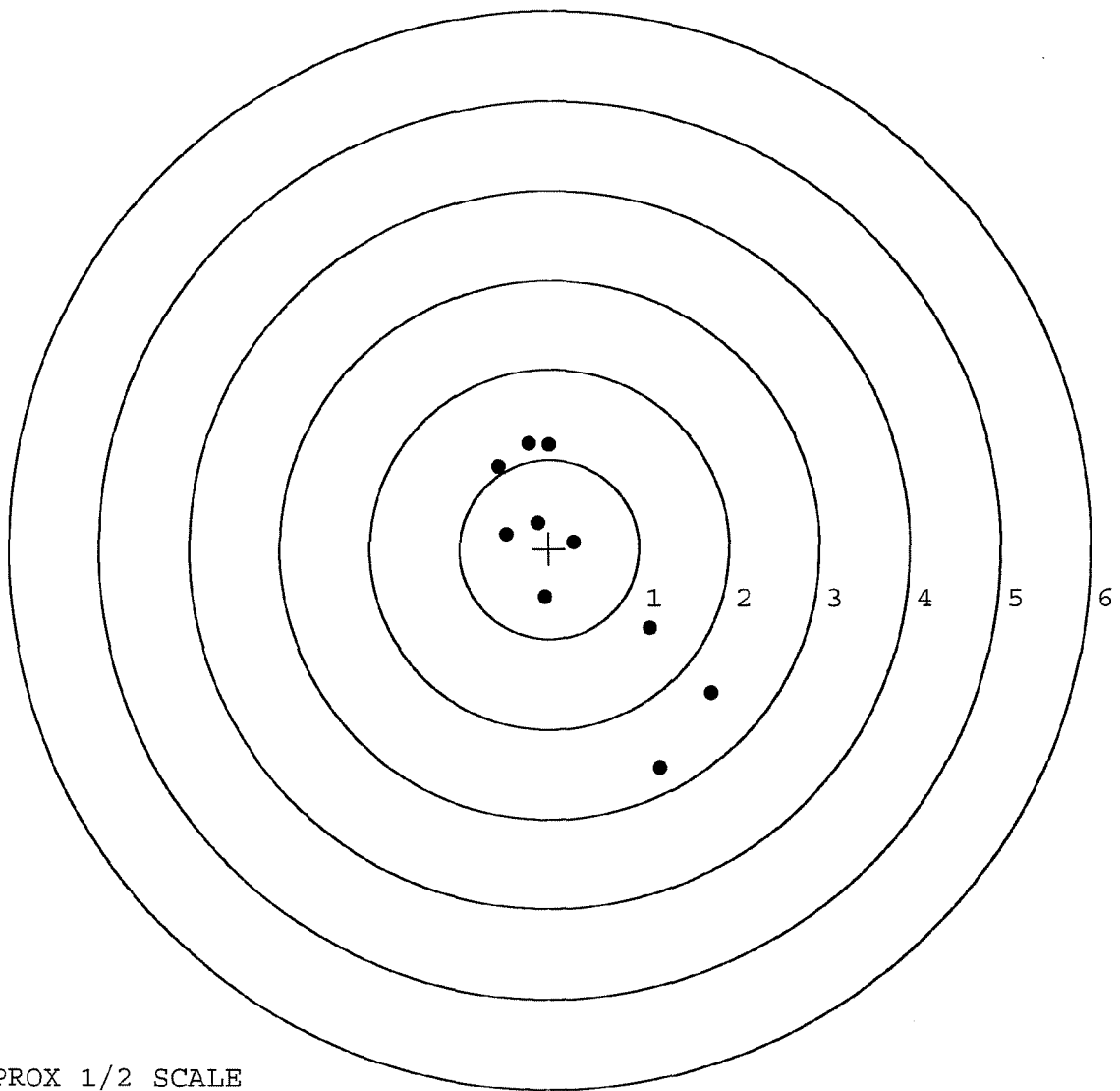
# in 3 IN DIAMETER: 8



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6611496. \_\_0  
TARGET NUMBER: 5  
FILE DATE: 02/17/2004  
FILE TIME: 07:19

|                     | POINT# | X      | Y      |
|---------------------|--------|--------|--------|
|                     | 1:     | 1.805  | -1.603 |
|                     | 2:     | 1.240  | -2.436 |
|                     | 3:     | 1.116  | -0.893 |
|                     | 4:     | 0.269  | 0.074  |
| X CENTROID:         | 5:     | -0.050 | -0.546 |
| Y CENTROID:         | 6:     | -0.482 | 0.165  |
| POA TO CENTROID:    | 7:     | -0.133 | 0.290  |
| HORZ SPREAD:        | 8:     | -0.572 | 0.925  |
| VERT SPREAD:        | 9:     | -0.229 | 1.175  |
| GROUP SPREAD:       | 10:    | 0.002  | 1.166  |
| MIN RADIUS:         |        | 0.244  |        |
| MAX RADIUS:         |        | 2.456  |        |
| MEAN RADIUS:        |        | 1.207  |        |
| # IN 1 IN DIAMETER: |        | 1      |        |
| # IN 2 IN DIAMETER: |        | 4      |        |
| # in 3 IN DIAMETER: |        | 8      |        |



TARGET APPROX 1/2 SCALE





# RECEIVING AND TESTING REPORT

COMMENTS

ORDER

R 94-18715

INITIAL CUSTOMER ORDER NO.

W/10X SCOPE M-24 SNIPER W/DEPLOYMENT KIT

JJM DAAA09-92-C-0834

ATTN FRED MARTIN

DATE RECEIVED

DATE OPENED

DATE CODE

SERIAL NUMBER

NEW SERIAL NUMBER

MODEL AND GRADE

06/14/94

06/15/94

C6611496

700 7.62

NATO

ACCESSORIES

HARD CASE

SCOPE MNTS

SCOPE BASE

SLING STRAP

96-0499

FROM:

SHIP TO:

COMMANDER (W52H094138H226)  
DEFENSE DIST DEPOT ANNISTON  
ATTN DDAA-UR BLDG 112  
ANNISTON

AL 36201-5025

COMMANDER (W52H094138H226)  
DEFENSE DIST DEPOT ANNISTON  
ATTN DDAA-UR BLDG 112  
ANNISTON

AL

36201-5025

CUST NO: 098397 C.O.D.

ACCOUNT NUMBER

ACCOUNT NUMBER N/C

WRITE ☐

PROM. DATE

ESTIMATED

VIA

UPS

GUN CONDITION

- ☐ NEW
- ☐ LIGHTLY WORN
- ☐ WORN
- ☐ VERY WORN
- ☐ UNREPAIRABLE
- ☐ MARRED

REPAIR CHARGE

EXCISE

TAX

INSURANCE

UPS

PARCEL POST

TOTAL

CUSTOMER CONCERN

AMMO

FUNCTION

FINISH

ACCURACY

FIT

INSPECT

CYCLE

A1

B1

TRIGGER GROUP

B2

E1

F1

BOLT ASSY.

B3

E2

F2

BARREL ASSY.

B4

D1

E3

F3

REC. ASSY.

B5

D2

E4

F4

WOOD

C1

D3

E5

F5

METAL

C2

MAIN FAULT

PARTS

COMMENTS

Trigger Assy \$173.71

Scope Rep 119.43

Clean/Insp/Rep 50.00

343.14

REPAIRMAN

PROOF

CLEAN

TEST

TARGET

PATTERN

GALLERY TESTER

DATE

DATE

DATE

DATE

DATE

OFFICE COPY

RD6925 REV. 1/94

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER  
KINZER V. REMINGTON

M2400167168

SWS TRIGGER PULL TEST

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

SERIAL NO. C6611496  
DATE 10-27-95  
TESTER DA

|         | 2.50#<br>INITIAL | 2.50# AFTER<br>50 CYCLES | FINAL TEST &<br>TO RESET 2.50# | COMMENTS                                                               |
|---------|------------------|--------------------------|--------------------------------|------------------------------------------------------------------------|
| PULL #1 | 2.41             | 2.57                     | 2.41                           | MIN. SETTING,<br>NO AVG. OF 5<br>READINGS ACCEPT-<br>ABLE LESS THAN 2# |
| PULL #2 | 2.30             | 2.46                     | 2.57                           |                                                                        |
| PULL #3 | 2.30             | 2.44                     | 2.64                           |                                                                        |
| PULL #4 | 2.37             | 2.49                     | 2.20                           |                                                                        |
| PULL #5 | 2.30             | 2.39                     | 2.65                           |                                                                        |
| TOTAL   | 11.68            | 12.35                    | 12.97                          |                                                                        |
| AVG.    | 2.33             | 2.47                     | 2.59                           |                                                                        |

|         | 3.00#<br>INITIAL | 3.00# AFTER<br>20 CYCLES | COMMENTS |
|---------|------------------|--------------------------|----------|
| PULL #1 | 3.07             | 3.04                     |          |
| PULL #2 | 3.00             | 2.92                     |          |
| PULL #3 | 3.01             | 3.15                     |          |
| PULL #4 | 3.00             | 2.93                     |          |
| PULL #5 | 3.00             | 2.98                     |          |
| TOTAL   | 15.08            | 15.02                    |          |
| AVG.    | 3.01             | 3.00                     |          |

|         | 4.00#<br>INITIAL | 4.00# AFTER<br>20 CYCLES | MAX SETTING<br>GREATER THAN 4# | RESET TO 4# FOR<br>TARGET & ACCURACY |
|---------|------------------|--------------------------|--------------------------------|--------------------------------------|
| PULL #1 | 4.09             | 4.05                     | 4.07                           |                                      |
| PULL #2 | 4.00             | 4.11                     | 4.15                           |                                      |
| PULL #3 | 4.00             | 4.12                     | 4.14                           |                                      |
| PULL #4 | 4.04             | 4.06                     | 4.02                           |                                      |
| PULL #5 | 4.00             | 4.11                     | 4.09                           |                                      |
| TOTAL   | 20.13            | 20.45                    | 20.47                          |                                      |
| AVG.    | 4.02             | 4.09                     | 4.09                           |                                      |

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6611496

| OP. #        | OP. NAME                                                       | READINGS | DATE | INITIAL |
|--------------|----------------------------------------------------------------|----------|------|---------|
| 575 &<br>580 | Assemble Action<br>and Stock                                   |          |      |         |
| 600          | Proof                                                          |          |      |         |
| 607          | Check Headspace                                                |          |      |         |
| 610          | Dis-assemble Gun                                               |          |      |         |
| 612          | Magnaflux Barrel<br>Action                                     |          |      |         |
|              | Magnaflux Bolt                                                 |          |      |         |
| 615          | Rollmark Caliber                                               |          |      |         |
| 617          | Drill and Tap Sight Holes                                      |          |      |         |
| 618          | Polish Barrel                                                  |          |      |         |
| 620          | Apply Coatings<br>(Barrel Action)                              |          |      |         |
|              | Apply Coating (Bolt)                                           |          |      |         |
| 625          | Final Assembly<br>A) Clean inside of<br>Bolt Assembly          |          |      |         |
|              | B) Inspect Rear Firing<br>Pin Hole for Chamfer<br>in Bolt Head |          |      |         |
|              | C) Inspect Ejector Hole<br>for Chamfer                         |          |      |         |
|              | D) Oil Firing Pin Ass'y                                        |          |      |         |
|              | E) Adjust Trigger Pull to<br>Min Setting and Stake             |          |      |         |

| op. #        | OP. NAME                                                    | READINGS |       |       |      |      | DATE  | INIT |
|--------------|-------------------------------------------------------------|----------|-------|-------|------|------|-------|------|
| 625<br>cont. | F) Safety On Force                                          | 6 1/2    | 6 1/2 | 6 1/2 |      |      | 11/28 | WB   |
|              | G) Safety Off Force                                         | 4        | 3 1/2 | 3 3/4 |      |      | 11/28 | WB   |
|              | H) Trigger Pull Test & Retainability                        |          |       |       |      |      |       |      |
|              | I) Firing Pin Indent                                        |          |       |       |      |      |       |      |
|              | J) Assemble Stock                                           |          |       |       |      |      |       |      |
|              | K) Assemble Swivel Studs                                    |          |       |       |      |      |       |      |
|              | L) Attach Front and Rear Sight Assemblies                   |          |       |       |      |      |       |      |
|              | M) Iron Sight Alignment                                     |          |       |       |      |      |       |      |
|              | N) Detach Front & Rear Sights & place in numbered container |          |       |       |      |      |       |      |
|              | O) Attach Scope to Rifle                                    |          |       |       |      |      |       |      |
|              | P) Detach & Attach Scope 20 Times                           |          |       |       |      |      |       |      |
| 640          | Gallery Target & Test                                       |          |       |       |      |      |       |      |
|              | A) Time                                                     |          |       |       |      |      |       |      |
|              | B) Malfunctions                                             |          |       |       |      |      |       |      |
|              | C) Pierced Primers                                          |          |       |       |      |      |       |      |
|              | D) Optical Clarity of Scope                                 |          |       |       |      |      |       |      |
| 645          | Inspect for Live Ammo                                       |          |       |       |      |      |       |      |
| 655          | Final Inspection<br>A) Headspace                            |          |       |       |      |      |       |      |
|              | B) Trigger Pull                                             | 2.74     | 2.62  | 2.60  | 2.51 | 2.53 | 11/28 | WB   |
|              | C) Function                                                 |          |       |       |      |      |       |      |
| 660          | Pack                                                        |          |       |       |      |      |       |      |

# Remington.



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

**MODEL 700<sup>TM</sup> M24**

SERIAL NO.  
**C6611496**

ORDER NO.  
**5716**

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

20



5716 C6611496

**UPC**



0 47700 25716 7

repaired 8 weeks

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C 6611496

| OP. #        | OP. NAME                                                       | READINGS | DATE    | INIT |
|--------------|----------------------------------------------------------------|----------|---------|------|
| 575 &<br>580 | Assemble Action<br>and Stock                                   |          | 2/1/91  | KJ   |
| 600          | Proof                                                          |          | 2/1/91  | KJ   |
| 607          | Check Headspace                                                |          | 2/1/91  | KJ   |
| 610          | Dis-assemble Gun                                               |          | 2/1/91  | KJ   |
| 612          | Magnaflux Barrel<br>Action                                     | 2 11     | 2/1/91  | Kcd  |
|              | Magnaflux Bolt                                                 | 2 11     | 2/1/91  | Kcd  |
| 615          | Rollmark Caliber                                               | 2 11     | 2/1/91  | GS   |
| 617          | Drill and Tap Sight Holes                                      | 2 13     | 91      | LB   |
| 618          | Polish Barrel RBB                                              | 2 13     | 2 1     | WB   |
| 620          | Apply Coatings<br>(Barrel Action)                              |          | 3/2/91  | JA   |
|              | Apply Coating (Bolt)                                           |          |         |      |
| 625          | Final Assembly                                                 |          | 3/20/91 | KS   |
|              | A) Clean inside of<br>Bolt Assembly                            |          |         |      |
|              | B) Inspect Rear Firing<br>Pin Hole for Chamfer<br>in Bolt Head |          | 3/20/91 | KS   |
|              | C) Inspect Ejector Hole<br>for Chamfer                         |          | 3/20/91 | KS   |
|              | D) Oil Firing Pin Ass'y                                        |          | 3/20/91 | KS   |
|              | E) Adjust Trigger Pull to<br>Min Setting and Stake             |          | 3/21/91 | KJ   |

| op. #        | OP. NAME                                                    | READINGS |       |       |      |      | DATE    | INIT |
|--------------|-------------------------------------------------------------|----------|-------|-------|------|------|---------|------|
| 625<br>cont. | F) Safety On Force                                          | 7 1/2    | 6     | 6     |      |      | 3/22/91 | WB   |
|              | G) Safety Off Force                                         | 2 1/2    | 2 1/2 | 2 1/2 |      |      | 3/22/91 | WB   |
|              | H) Trigger Pull Test & Retainability                        |          |       |       |      |      | 3/21/91 | DL   |
|              | I) Firing Pin Indent                                        | .0225    | .023  | .023  |      |      | 3/22/91 | WB   |
|              | J) Assemble Stock                                           |          |       |       |      |      | 3/22/91 | KS   |
|              | K) Assemble Swivel Studs                                    |          |       |       |      |      | 4-8-91  | DH   |
|              | L) Attach Front and Rear Sight Assemblies                   |          |       |       |      |      | 3/22/91 | KS   |
|              | M) Iron Sight Alignment                                     |          |       |       |      |      | 3/22/91 | KS   |
|              | N) Detach Front & Rear Sights & place in numbered container |          |       |       |      |      | 3/22/91 | KS   |
|              | O) Attach Scope to Rifle                                    |          |       |       |      |      | 3/22/91 | KS   |
|              | P) Detach & Attach Scope 20 Times                           |          |       |       |      |      | 3/22/91 | KS   |
| 640          | Gallery Target & Test                                       |          |       |       |      |      | 4-3-91  | AC   |
|              | A) Time                                                     |          |       |       |      |      | 4-3-91  | AC   |
|              | B) Malfunctions                                             |          |       |       |      |      | 4-3-91  | AC   |
|              | C) Pierced Primers                                          |          |       |       |      |      | 4-3-91  | AC   |
|              | D) Optical Clarity of Scope                                 |          |       |       |      |      | 4-3-91  | AC   |
| 645          | Inspect for Live Ammo                                       |          |       |       |      |      | 4-3-91  | AC   |
| 655          | Final Inspection                                            |          |       |       |      |      |         |      |
|              | A) Headspace                                                |          |       |       |      |      | 4-8-91  | DH   |
|              | B) Trigger Pull                                             | 2.27     | 2.57  | 2.51  | 2.47 | 2.48 | 4/5/91  | DL   |
|              | C) Function                                                 |          |       |       |      |      | 4-8-91  | DH   |
| 660          | Pack                                                        |          |       |       |      |      | 6-19-91 | VF   |



## SWS TRIGGER PULL TEST

PIMI

AVERAGE PULL FORCE BETWEEN  
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C6611498DATE 3-21-91TESTER JH

|         | 2.50#<br>INITIAL | 2.50# AFTER<br>50 CYCLES | FINAL TEST &<br>TO RESET 2.50# |      | COMMENTS                                                               |
|---------|------------------|--------------------------|--------------------------------|------|------------------------------------------------------------------------|
| PULL #1 | 2.25             | 2.52                     | 2.40                           | 2.27 | MIN. SETTING,<br>NO AVG. OF 5<br>READINGS ACCEPT-<br>ABLE LESS THAN 2# |
| PULL #2 | 2.29             | 2.43                     | 2.31                           | 2.57 |                                                                        |
| PULL #3 | 2.32             | 2.31                     | 2.29                           | 2.51 |                                                                        |
| PULL #4 | 2.32             | 2.33                     | 2.48                           | 2.47 |                                                                        |
| PULL #5 | 2.25             | 2.44                     | 2.33                           | 2.48 |                                                                        |
| TOTAL   |                  |                          |                                |      |                                                                        |
| AVG.    |                  |                          |                                |      |                                                                        |

|         | 3.00#<br>INITIAL | 3.00# AFTER<br>20 CYCLES |  | COMMENTS |
|---------|------------------|--------------------------|--|----------|
| PULL #1 | 3.35             | 3.27                     |  |          |
| PULL #2 | 3.29             | 3.25                     |  |          |
| PULL #3 | 3.28             | 3.28                     |  |          |
| PULL #4 | 3.27             | 3.29                     |  |          |
| PULL #5 | 3.27             | 3.31                     |  |          |
| TOTAL   |                  |                          |  |          |
| AVG.    |                  |                          |  |          |

|         | 4.00#<br>INITIAL | 4.00# AFTER<br>20 CYCLES | MAX SETTING<br>GREATER THAN 4# | RESET TO 4# FOR<br>TARGET & ACCURACY |
|---------|------------------|--------------------------|--------------------------------|--------------------------------------|
| PULL #1 | 4.21             | 4.40                     | 4.                             | 4.44                                 |
| PULL #2 | 4.14             | 4.45                     |                                | 4.49                                 |
| PULL #3 | 4.41             | 4.43                     |                                | 4.48                                 |
| PULL #4 | 4.41             | 4.43                     |                                | 4.41                                 |
| PULL #5 | 4.38             | 4.43                     |                                | 4.45                                 |
| TOTAL   |                  |                          |                                |                                      |
| AVG.    |                  |                          |                                |                                      |

CENTROIDAL DISTANCE CALCULATIONS  
FOR RIFLE # C6611496  
3 Apr 1991

CENTROIDAL DISTANCES

|      |   |         |
|------|---|---------|
| Ø TO | 1 | .151433 |
| 1 TO | 2 | .480276 |
| 1 TO | 3 | .116662 |
| 1 TO | 4 | .18186  |
| 1 TO | 5 | .248214 |

2 ~~3~~ <----POA

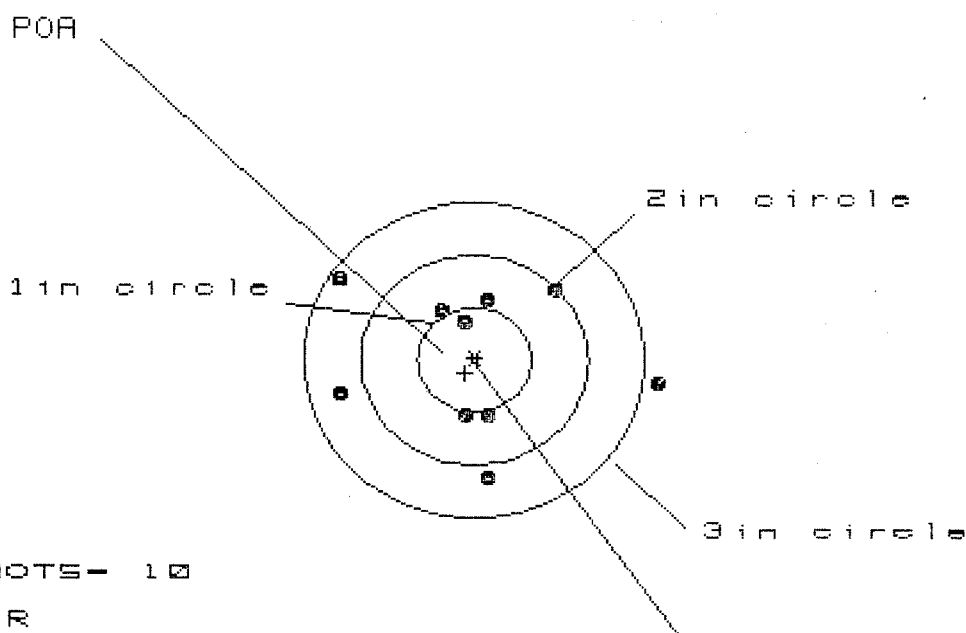
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0256  
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0704  
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0749101  
THE AMP FOR THIS RIFLE IS: .815

3 Apr 1991

FILE:/PATTERNING/CENTERFIRE\_PATT/C6611496

# CENTERFIRE PATTERNS

# 1



# OF SHOTS- 10

# IN CIR

1in - 1

2in - 5

3in - 9

HS- 2.822

VS- 1.903

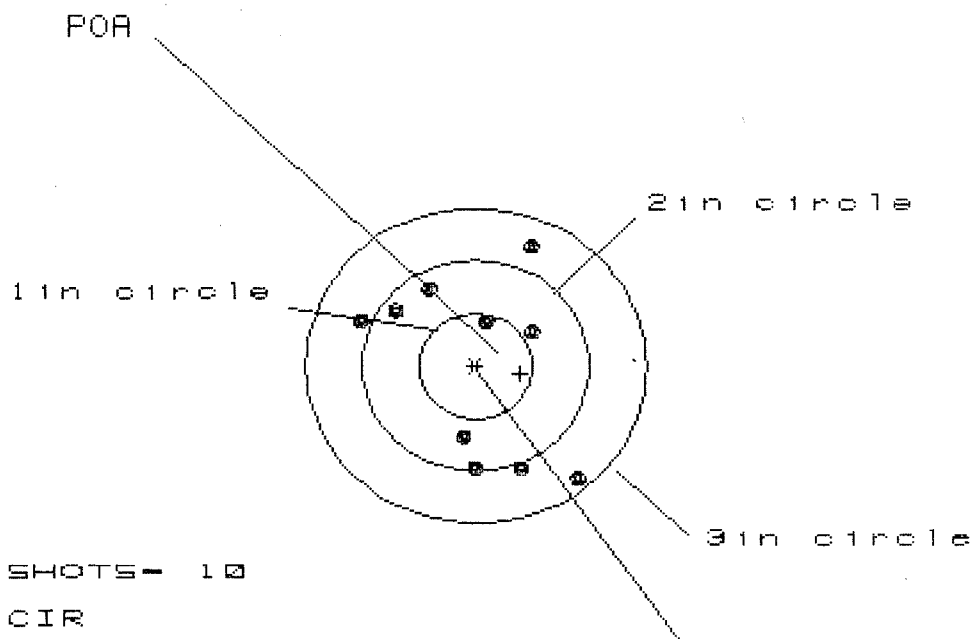
GS- 2.981

|                             |   |        |        |        |
|-----------------------------|---|--------|--------|--------|
| PATTERN #                   | : | 10     | 9      | 8      |
| SHOTS (BEST OF)             | : | 10     | 9      | 8      |
| MAXIMUM X                   | : | 1.660  | .925   | .803   |
| MINIMUM X                   | : | -1.162 | -.977  | -1.073 |
| MAXIMUM Y                   | : | .735   | .710   | .698   |
| MINIMUM Y                   | : | -1.168 | -1.193 | -1.105 |
| CENTROID X                  | : | .084   | -.101  | .021   |
| CENTROID Y                  | : | .126   | .151   | .063   |
| POA TO CENTROID in.         | : | .152   | .182   | .066   |
| MIN RADIUS                  | : | .374   | .356   | .430   |
| MEAN RADIUS                 | : | .894   | .797   | .738   |
| MAX RADIUS                  | : | 1.676  | 1.222  | 1.113  |
| HORIZONTAL SPREAD           | : | 2.822  | 1.902  | 1.876  |
| VERTICAL SPREAD             | : | 1.903  | 1.903  | 1.803  |
| EXTREME SPREAD              | : | 2.981  | 2.270  | 2.088  |
| NUMBER IN ONE INCH CIRCLE   | = | 1      |        |        |
| NUMBER IN TWO INCH CIRCLE   | = | 6      |        |        |
| NUMBER IN THREE INCH CIRCLE | = | 9      |        |        |

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# CENTERFIRE PATTERNS # 2



# OF SHOTS- 10

# IN CIR

1in = 1

2in = 6

3in = 10

HS= 1.931

VS= 2.141

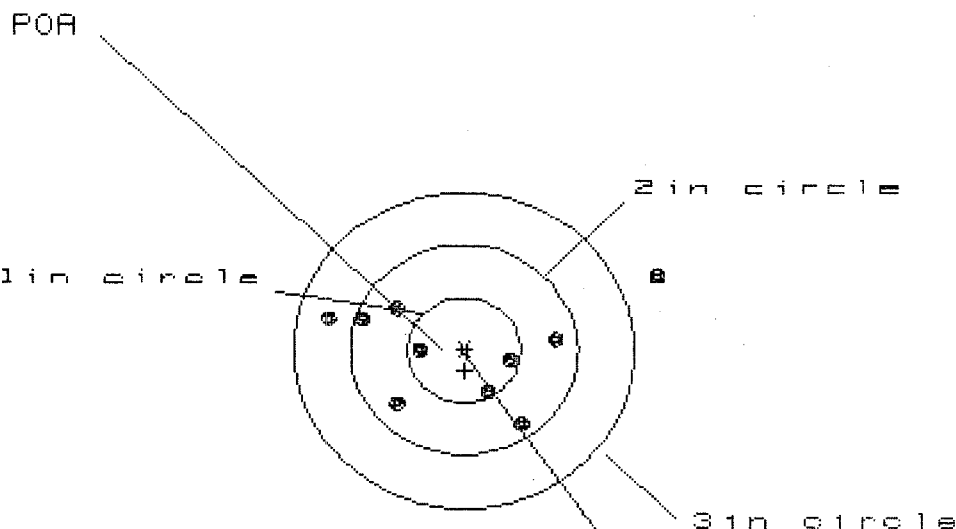
GS= 2.438

| PATTERN #                     | : | 2      |        |       |
|-------------------------------|---|--------|--------|-------|
| SHOTS (BEST OF)               | : | 10     | 9      | 8     |
| MAXIMUM X                     | : | .942   | .584   | .653  |
| MINIMUM X                     | : | -.989  | -.884  | -.815 |
| MAXIMUM Y                     | : | 1.107  | .993   | .782  |
| MINIMUM Y                     | : | -1.034 | -1.085 | -.961 |
| CENTROID X                    | : | -.393  | -.498  | -.567 |
| CENTROID Y                    | : | .070   | .184   | .060  |
| POA TO CENTROID in.           | : | .400   | .531   | .570  |
| MIN RADIUS                    | : | .427   | .365   | .506  |
| MEAN RADIUS                   | : | .914   | .844   | .812  |
| MAX RADIUS                    | : | 1.399  | 1.172  | 1.092 |
| HORIZONTAL SPREAD             | : | 1.931  | 1.468  | 1.468 |
| VERTICAL SPREAD               | : | 2.141  | 2.078  | 1.743 |
| EXTREME SPREAD                | : | 2.438  | 2.135  | 1.959 |
| NUMBER IN ONE INCH CIRCLE =   |   |        | 1      |       |
| NUMBER IN TWO INCH CIRCLE =   |   |        | 6      |       |
| NUMBER IN THREE INCH CIRCLE = |   |        | 10     |       |

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# CENTERFIRE PATTERNS # 3



# OF SHOTS- 10

# IN CIR

1 in - 3

2 in - 8

3 in - 9

HS- 2.937

VS= 1.315

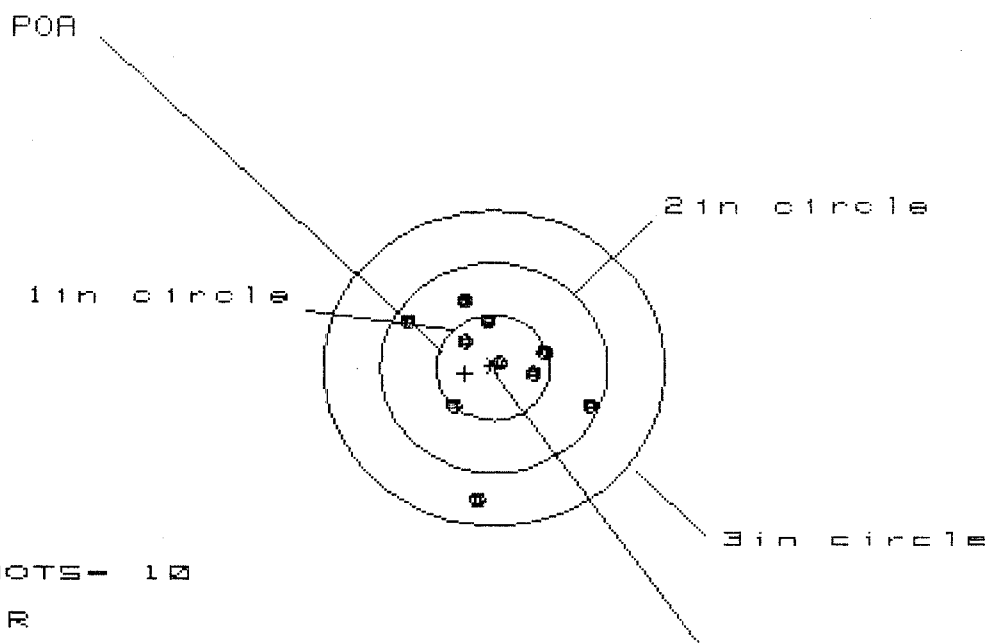
GS= 2.957

|                             |   |        |       |       |
|-----------------------------|---|--------|-------|-------|
| PATTERN #                   | : | 3      |       |       |
| SHOTS (BEST OF)             | : | 10     | 9     | 8     |
| MAXIMUM X                   | : | 1.748  | 1.050 | .925  |
| MINIMUM X                   | : | -1.189 | -.995 | -.868 |
| MAXIMUM Y                   | : | .654   | .423  | .471  |
| MINIMUM Y                   | : | -.660  | -.588 | -.540 |
| CENTROID X                  | : | -.007  | -.201 | -.076 |
| CENTROID Y                  | : | .199   | .127  | .079  |
| POA TO CENTROID in.         | : | .200   | .237  | .110  |
| MIN RADIUS                  | : | .353   | .185  | .317  |
| MEAN RADIUS                 | : | .854   | .714  | .665  |
| MAX RADIUS                  | : | 1.866  | 1.066 | .971  |
| HORIZONTAL SPREAD           | : | 2.937  | 2.045 | 1.793 |
| VERTICAL SPREAD             | : | 1.315  | 1.011 | 1.011 |
| EXTREME SPREAD              | : | 2.957  | 2.060 | 1.811 |
| NUMBER IN ONE INCH CIRCLE   | = |        | 3     |       |
| NUMBER IN TWO INCH CIRCLE   | = |        | 8     |       |
| NUMBER IN THREE INCH CIRCLE | = |        | 9     |       |

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# CENTERFIRE PATTERNS # 4



# OF SHOTS- 10

# IN CIR

1in = 6

2in = 9

3in = 10

HS= 1.523

VS= 1.934

GS= 1.934

|                             |   |        |       |       |
|-----------------------------|---|--------|-------|-------|
| PATTERN #                   | : | 4      |       |       |
| SHOTS (BEST OF)             | : | 10     | 9     | 8     |
| MAXIMUM X                   | : | .812   | .791  | .517  |
| MINIMUM X                   | : | -.711  | -.732 | -.633 |
| MAXIMUM Y                   | : | .688   | .549  | .487  |
| MINIMUM Y                   | : | -1.247 | -.495 | -.547 |
| CENTROID X                  | : | .251   | .272  | .173  |
| CENTROID Y                  | : | .054   | .192  | .254  |
| POA TO CENTROID in.         | : | .257   | .333  | .307  |
| MIN RADIUS                  | : | .053   | .130  | .180  |
| MEAN RADIUS                 | : | .584   | .491  | .428  |
| MAX RADIUS                  | : | 1.260  | .933  | .673  |
| HORIZONTAL SPREAD           | : | 1.523  | 1.523 | 1.150 |
| VERTICAL SPREAD             | : | 1.934  | 1.044 | 1.034 |
| EXTREME SPREAD              | : | 1.934  | 1.714 | 1.187 |
| NUMBER IN ONE INCH CIRCLE   | = |        | 6     |       |
| NUMBER IN TWO INCH CIRCLE   | = |        | 9     |       |
| NUMBER IN THREE INCH CIRCLE | = |        | 10    |       |

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# CENTERFIRE PATTERNS

# 5

POA

1 in circle

2 in circle

3 in circle

CENTROID \*

# OF SHOTS- 10

# IN CIR

1 in - 3

2 in - 8

3 in - 9

HS- 2.755

VS- 2.034

GS- 3.126

|                             |   |       |       |       |
|-----------------------------|---|-------|-------|-------|
| PATTERN #                   | : | 5     |       |       |
| SHOTS (BEST OF)             | : | 10    | 9     | 8     |
| MAXIMUM X                   | : | 1.898 | .724  | .643  |
| MINIMUM X                   | : | -.857 | -.646 | -.727 |
| MAXIMUM Y                   | : | 1.182 | .805  | .559  |
| MINIMUM Y                   | : | -.852 | -.721 | -.620 |
| CENTROID X                  | : | .193  | -.018 | .063  |
| CENTROID Y                  | : | -.097 | -.228 | -.329 |
| POA TO CENTROID in.         | : | .216  | .229  | .335  |
| MIN RADIUS                  | : | .330  | .279  | .311  |
| MEAN RADIUS                 | : | .829  | .653  | .597  |
| MAX RADIUS                  | : | 2.236 | 1.033 | .730  |
| HORIZONTAL SPREAD           | : | 2.755 | 1.370 | 1.370 |
| VERTICAL SPREAD             | : | 2.034 | 1.526 | 1.179 |
| EXTREME SPREAD              | : | 3.126 | 1.749 | 1.375 |
| NUMBER IN ONE INCH CIRCLE   | = |       | 3     |       |
| NUMBER IN TWO INCH CIRCLE   | = |       | 8     |       |
| NUMBER IN THREE INCH CIRCLE | = |       | 9     |       |