

06587594

MODEL 700™ M24

Model **SMS**

™

Action

Barrel Length

Capacity

Order No.

5715

*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 Number: **RE00032497** Serial: C6587594 Model 700 Center Fire Caliber: 7 62 NATO M24 SWS WOG 15 of 25 Repairman: Status: New 9/14/01 3:10:11 PM

Verify Repair

Address Information

Customer: Received From Return To: Received From

Name: DEFENCE DIST DEPOT ANNISTON DEFENCE DIST DEPOT ANNISTON

Address 1: 7 FRANKFORD AVE 7 FRANKFORD AVE

Address 2: PO Box: PO Box:

City: ANNISTON ANNISTON

State: AL Zip Code: 36201 Country: US State: AL Zip Code: 36201 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
A006	Sling Strap	1
A007	With Stud	3
A008	With Swivel	2
A010	Hard Case	1
A026	Scope	1
X001	Scope Case	1
X002	Deployment Case	1

Repair Search Refresh Close

naglej 9/17/01 7:49 AM NUM

Start Arms Services Repair & Es... 7:49 AM

Serial Number: **C6587594**

Model: **700**



RE00032497

BARBER - M24 0023360

Remington Test Lab, Ilion, N.Y.

Centroidal distance calculations for Rifle # c6587594
5 Oct 2001

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0708
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0682
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .098305

THE AMR FOR THIS RIFLE IS: 1.12

CENTROIDAL DISTANCES

0	TO	1	.264622
1	TO	2	.126194
1	TO	3	.362244
1	TO	4	.268002
1	TO	5	.702923

5
4 <----POA
1 2 3

REMINGTON CENTERFIRE ACCURACY TEST

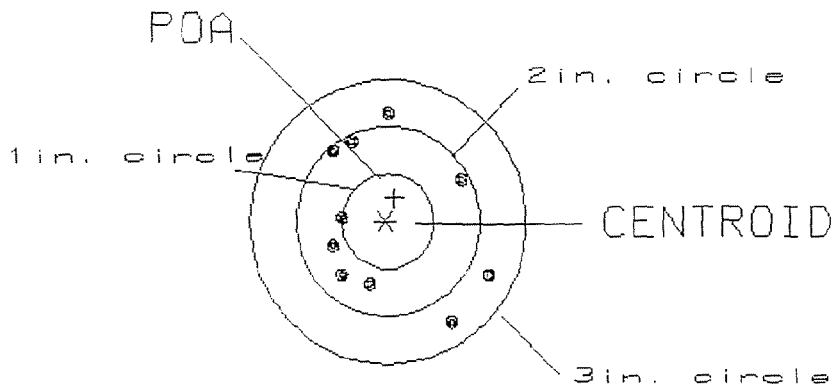
REMINGTON TEST LAB, ILION, N.Y.

PATTERN #: 1
 POA TO CENTROID: .265
 MIN RADIUS : .451
 MEAN RADIUS : .884
 MAX RADIUS : 1.290
 CENTROID X : -.100
 CENTROID Y : -.245

5 Oct 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c5587594

CENTERFIRE PATTERN # 1



OF SHOTS= 10

IN CIRCLE

HS= 1.68

1

VS= 2.17

7

GS= 2.28

10

REMINGTON CENTERFIRE ACCURACY TEST

REMINGTON TEST LAB, ILION, N.Y.

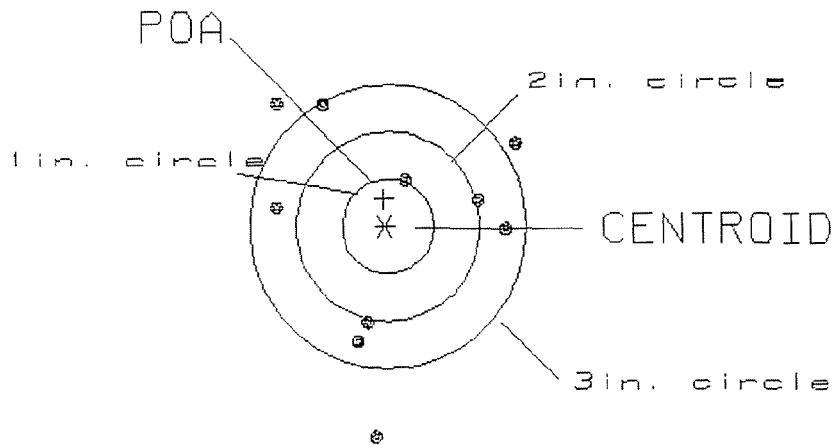
PATTERN #: 2

POA TO CENTROID: .287
 MIN RADIUS : .496
 MEAN RADIUS : 1.336
 MAX RADIUS : 2.228
 CENTROID X : .019
 CENTROID Y : -.287

5 Oct 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6587594

CENTERFIRE PATTERN # 2



OF SHOTS= 10

IN CIRCLE

HS= 2.63
 VS= 3.52
 GS= 3.66

1
 1
 7

REMINGTON CENTERFIRE ACCURACY TEST

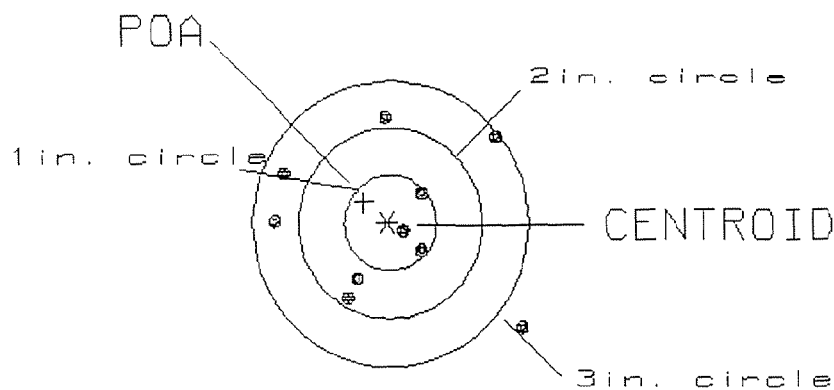
REMINGTON TEST LAB, ILION, N.Y.

PATTERN #: ☐ 3 ☐
 POA TO CENTROID: .339
 MIN RADIUS : .151
 MEAN RADIUS : .958
 MAX RADIUS : 1.783
 CENTROID X : .261
 CENTROID Y : -.215

5 Oct 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6587594

CENTERFIRE PATTERN # 3



OF SHOTS= 10

IN CIRCLE

HS= 2.70

3

VS= 2.16

5

GS= 3.05

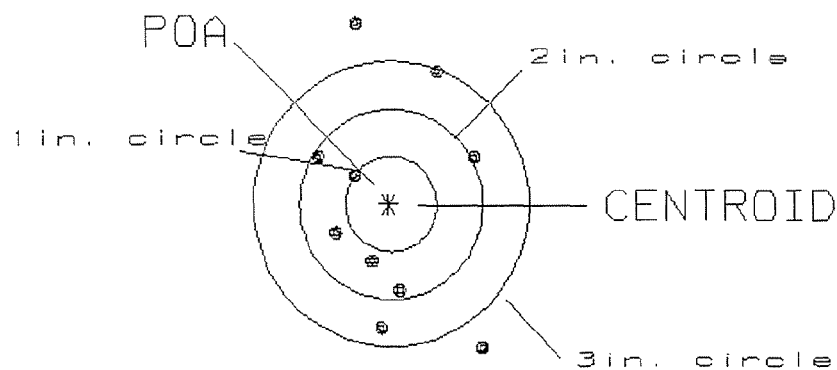
9

PATTERN #: ☐ 4 ☐
 POA TO CENTROID: .004
 MIN RADIUS : .462
 MEAN RADIUS : 1.107
 MAX RADIUS : 1.950
 CENTROID X : .004
 CENTROID Y : .002

5 Oct 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6587594

CENTERFIRE PATTERN # 4



OF SHOTS= 10

IN CIRCLE

HS= 1.74

1

VS= 3.39

5

GS= 3.64

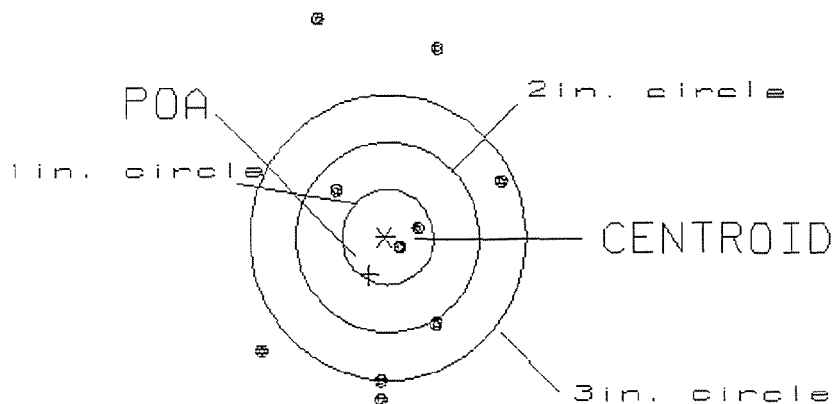
8

PATTERN #: ☐ 5 ☐
 POA TO CENTROID: .438
 MIN RADIUS : .144
 MEAN RADIUS : 1.317
 MAX RADIUS : 2.437
 CENTROID X : .170
 CENTROID Y : .404

5 Oct 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6587594

CENTERFIRE PATTERN # 5



OF SHOTS= 10

IN CIRCLE

HS= 2.60

2

VS= 4.07

3

GS= 4.13

6

M-24 INSPECTION CHECKLIST
CONTRACT #: DAAE-20-97-C-242

R & E NUMBER 32497

SERIAL NUMBER C6587594

LOG-IN DATE 9-13-01

INSPECT AND VERIFY:			
OPERATION #	OPERATION NAME	DATE	INITIAL
550	DIS-ASSEMBLE GUN	9-18-01	RH
560 A	RE-BARREL AT CUSTOM SHOP	9/20/01	BWT
B	DRILL AND TAP	9/20/01	BWT
C	POLISH	9-20-01	CD
575	ASSEMBLE	9-20-01	RH
600	PROOF	9-21-01	RH
605	CHECK HEADSPACE	9-24-01	RH
610	DIS-ASSEMBLE GUN	9-24-01	RH
612	MAGNAFLUX	9-24-01	RH
615	ROLLMARK CALIBER	9-24-01	RH
618	ROTO-BLAST	9/25	K
620	APPLY COATINGS	9/28	H.P.
625 A	FINAL ASSEMBLY	10-3-01	RH
B	TRIGGER PULL TEST		
C	SAFETY "ON" FORCE		
D	SAFETY "OFF" FORCE		
E	FIRING PIN INDENT		
640	TARGET	10-4-01	AC
655	FINAL INSPECT	10-6-01	RH
660	PACK	10-6-01	RH
		SHIP DATE	
		QAR INSPECTION DATE	

Final Inspection

In: C6587594

DATE REC'D: 9-13-01

DATE RET'D: 10-9-01

EDITOR: ~~RL~~

Item:

Barrel Assy.

☒ BARREL☒ RECEIVER☒ FRONT SIGHT BLOCK☒ REAR SIGHT BLOCK☒ SCREWS☒ FINISH

Scope Assy.

☒ SCOPE☒ SCOPE RINGS☒ MOUNTING SCREWS☒ MOUNTING BASE☒ SCREWS☒ FINISH☒ LOOSENESS☒ CLARITY

Misc.

☒ DD-250☒ BAR CODE☒ PACKAGING

Item:

Stock Assy.

☒ STOCK☒ SLING SWIVEL STUDS☒ ADJUSTABLE BUTT PLATE☒ LOCK NUTS☒ BARREL CLEARANCE☒ COLOR/FINISH

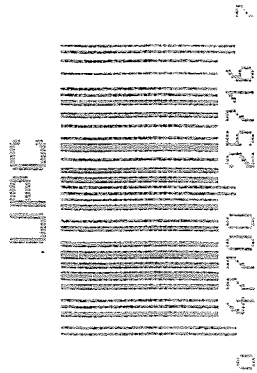
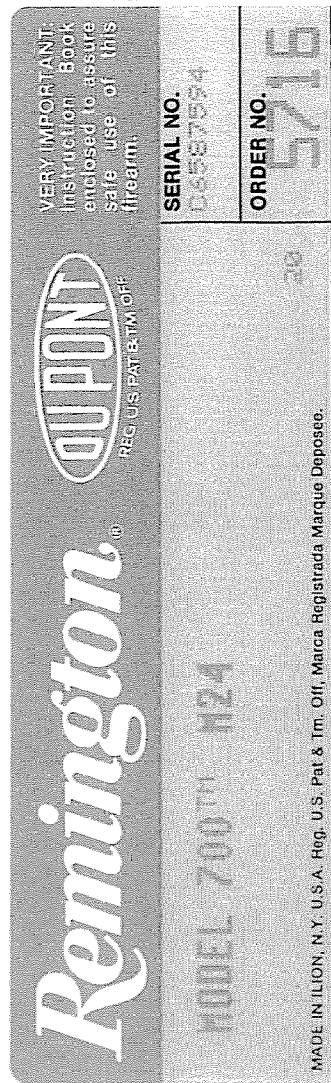
Systems Case

☒ SCOPE CASE☒ IRON SIGHTS☒ DEPLOYMENT KIT

Trigger

☒ SAFETY OPERATION☒ SET

Comments:



MOD. <u>M24</u>		GA. CAL. <u>308</u>	GUN # <u>7594</u>
# TEST	DATE	MALFUNCTION/DEFECT	ASSEM. #
	1st		
NF	1/10	Does not feed properly	KS
	2nd		
		ADJUSTED MAGAZINE BOX 1-10-91	K. S.
	3rd		
	4th		

FUNCTION _____ RD 6654 Rev 1

TEST INIT. ACTION TO CORRECT		ASSEM. #
PROOF		
TEST		
TGT		
PROOF		
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		

CONTRACT # DAAA21-87-C-0086

NEW BBL

GUN SERIAL #

C 6587594

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		10/24/90	Kd
600	Proof		10/24/90	Kd
607	Check Headspace		10/24/90	Kd
610	Dis-assemble Gun		10/24/90	Kd
612	Magnaflux Barrel Action		10/30/90	KR
	Magnaflux Bolt		10/30/90	KR
615	Rollmark Caliber		10/30/90	GL
617	Drill and Tap Sight Holes		11/6/90	KB
618	Polish Barrel AB		11/7/90	KB
620	Apply Coatings (Barrel Action)		11-24-90	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		12/14/90	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		12/14/90	KS
	C) Inspect Ejector Hole for Chamfer		12/14/90	KS
	D) Oil Firing Pin Ass'y		12/14/90	KS
	E) Adjust Trigger Pull to Min Setting and Stake		1-2-91	JA

BARBER - M24 0023372								
op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			1/2/91	WB
	G) Safety Off Force	2 ³ / ₄	2 ³ / ₄	2 ³ / ₄			1/2/91	WB
	H) Trigger Pull Test & Retainability						1-2-91	JL
	I) Firing Pin Indent	.020	.020	.020			1/2/91	WB
	J) Assemble Stock						1/3/90	K.S.
	K) Assemble Swivel Studs						1-11-91	JL
	L) Attach Front and Rear Sight Assemblies						1/3/90	K.S.
	M) Iron Sight Alignment						1/3/90	K.S.
	N) Detach Front & Rear Sights & place in numbered container						1/3/90	K.S.
	O) Attach Scope to Rifle						1/3/90	K.S.
	P) Detach & Attach Scope 20 Times						1/3/90	K.S.
640	Gallery Target & Test						1-10-91	NF
	A) Time						"	NF
	B) Malfunctions						"	NF
	C) Pierced Primers						"	NF
	D) Optical Clarity of Scope						"	NF
645	Inspect for Live Ammo						1-10-91	NF
655	Final Inspection							
	A) Headspace						1-11-91	JL
	B) Trigger Pull	2.10	2.00	2.15	2.00	2.15	1-11-91	JL
	C) Function						1-11-91	JL
660	Pack						3/15/91	WB

SWS TRIGGER PULL TEST

BARBER - M24 0023373

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6587594DATE 1-2-91TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.25	2.33	2.35	2.10	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.22	2.32	2.40	2.00	
PULL #3	2.47	2.34	2.33	2.15	
PULL #4	2.40	2.28	2.39	2.00	
PULL #5	2.39	2.37	2.39	2.15	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.36	3.22		
PULL #2	3.41	3.50		
PULL #3	3.33	3.30		
PULL #4	3.44	3.13		
PULL #5	3.31	3.27		
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	4.44		4.45
PULL #2	4.45	4.39		4.45
PULL #3	4.11	4.25		4.31
PULL #4	4.44	4.46		4.47
PULL #5	4.40	4.44		4.38
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6587594
11 Jan 1991

CENTROIDAL DISTANCES

0 TO	1	.289249
1 TO	2	.5886
1 TO	3	.411428
1 TO	4	.467787
1 TO	5	.728616

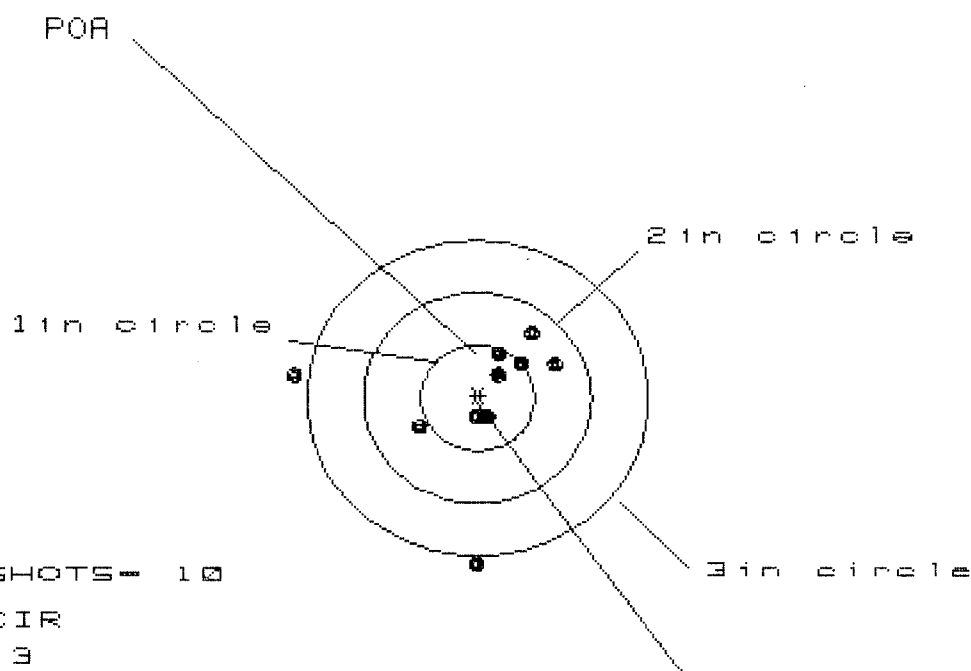
$\bar{x} = .172$ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .172
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0016
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .172007
THE AMR FOR THIS RIFLE IS: .8598

11 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6587594.1

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1in = 3

2in = 8

3in = 8

HS= 2.298

VS= 2.172

GS= 2.402

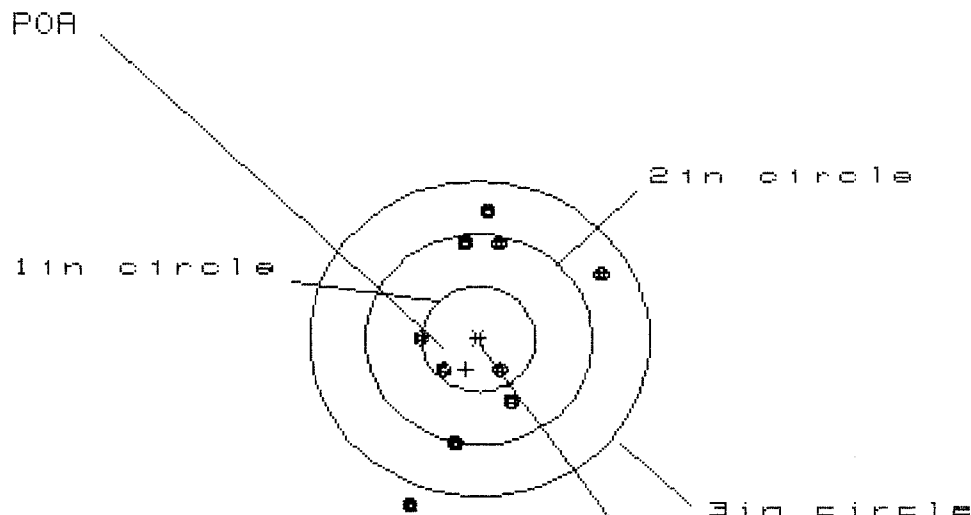
CENTROID #

PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.663	.482	.458
MINIMUM X	:	-1.634	-.675	-.699
MAXIMUM Y	:	.632	.658	.469
MINIMUM Y	:	-1.540	-1.514	-.415
CENTROID X	:	-.183	-.001	.023
CENTROID Y	:	-.224	-.250	-.061
POA TO CENTROID in.	:	.289	.250	.065
MIN RADIUS	:	.182	.191	.062
MEAN RADIUS	:	.704	.570	.405
MAX RADIUS	:	1.651	1.526	.813
HORIZONTAL SPREAD	:	2.298	1.157	1.157
VERTICAL SPREAD	:	2.172	2.172	.884
EXTREME SPREAD	:	2.402	2.231	1.329
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		8	

11 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6587594.1

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 3

2in = 6

3in = 9

HS= 1.647

VS= 2.760

GS= 2.846

CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.048	.981	.330
MINIMUM X	:	-.599	-.558	-.435
MAXIMUM Y	:	1.218	1.046	1.108
MINIMUM Y	:	-1.542	-1.199	-1.137
CENTROID X	:	.116	.183	.060
CENTROID Y	:	.283	.455	.393
POA TO CENTROID in.	:	.306	.490	.398
MIN RADIUS	:	.352	.492	.443
MEAN RADIUS	:	.889	.811	.753
MAX RADIUS	:	1.654	1.223	1.144
HORIZONTAL SPREAD	:	1.647	1.539	.765
VERTICAL SPREAD	:	2.760	2.245	2.245
EXTREME SPREAD	:	2.846	2.262	2.262
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

11 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6587594.1

CENTERFIRE PATTERNS

3

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS- 10

IN CIR

1 in = 4

2 in = 8

3 in = 8

HS= 1.636

VS= 3.924

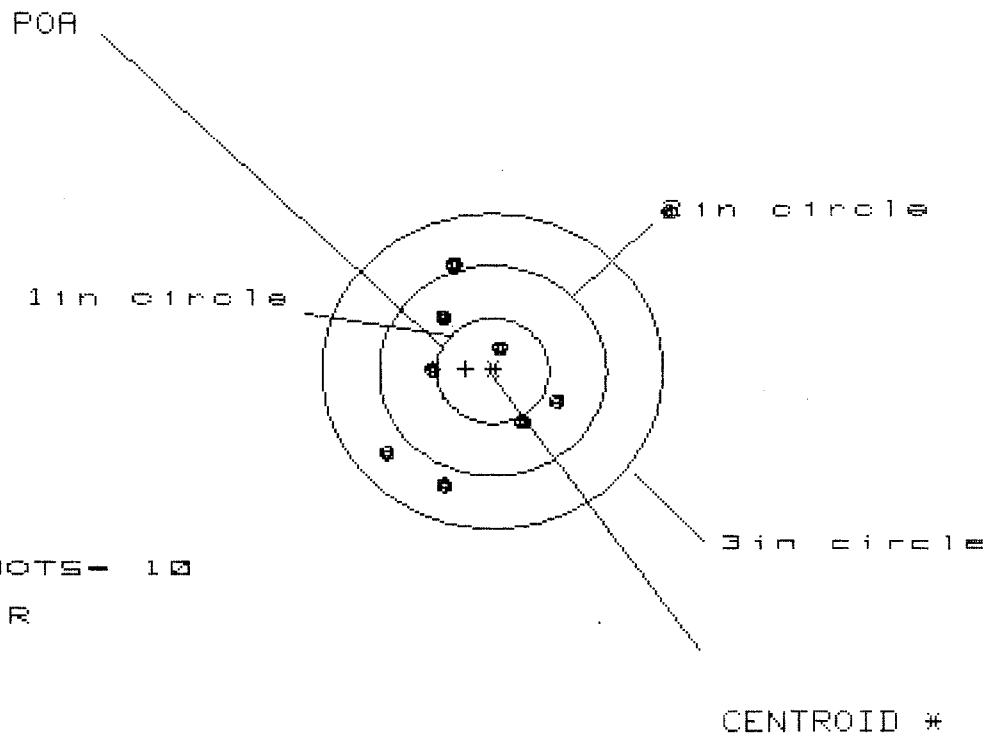
GS= 3.952

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.813	.819	.767
MINIMUM X	:	-.823	-.817	-.869
MAXIMUM Y	:	2.209	.808	.625
MINIMUM Y	:	-1.715	-1.470	-.276
CENTROID X	:	.169	.163	.215
CENTROID Y	:	-.011	-.256	-.072
POA TO CENTROID in.	:	.169	.304	.226
MIN RADIUS	:	.308	.067	.247
MEAN RADIUS	:	.853	.666	.560
MAX RADIUS	:	2.209	1.526	.876
HORIZONTAL SPREAD	:	1.636	1.636	1.636
VERTICAL SPREAD	:	3.924	2.278	.901
EXTREME SPREAD	:	3.952	2.318	1.641
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		8	

01 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6587594.1

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 1

2in = 6

3in = 9

HS= 2.502

VS= 2.583

GS= 3.411

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.548	.777	.679
MINIMUM X	:	-.954	-.782	-.451
MAXIMUM Y	:	1.488	1.142	1.058
MINIMUM Y	:	-1.095	-.929	-1.012
CENTROID X	:	.236	.064	.162
CENTROID Y	:	-.016	-.182	-.099
POA TO CENTROID in.	:	.236	.193	.189
MIN RADIUS	:	.194	.421	.299
MEAN RADIUS	:	.893	.744	.691
MAX RADIUS	:	2.147	1.156	1.095
HORIZONTAL SPREAD	:	2.502	1.559	1.130
VERTICAL SPREAD	:	2.583	2.071	2.071
EXTREME SPREAD	:	3.411	2.074	2.074
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

11 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6587594.1

CENTERFIRE PATTERNS

5

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 3

2in = 6

3in = 8

HS= 2.793

VS= 2.797

GS= 3.122

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.715	.587	.658
MINIMUM X	:	-1.078	-.887	-.816
MAXIMUM Y	:	1.511	1.583	1.050
MINIMUM Y	:	-1.286	-1.214	-1.017
CENTROID X	:	.522	.331	.260
CENTROID Y	:	-.040	-.112	-.309
POA TO CENTROID in.	:	.523	.350	.404
MIN RADIUS	:	.359	.156	.114
MEAN RADIUS	:	.960	.809	.666
MAX RADIUS	:	1.831	1.681	1.193
HORIZONTAL SPREAD	:	2.793	1.474	1.474
VERTICAL SPREAD	:	2.797	2.797	2.067
EXTREME SPREAD	:	3.122	3.012	2.316
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	