

C6523458

MODEL 700™ M24

Model 545™

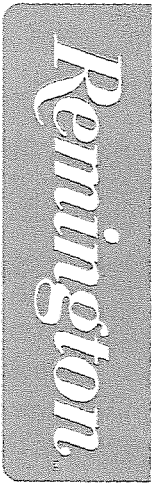
Action

Barrel Length

Capacity

Order No. 5715

*Includes 1 in chamber.



Repair Inquiry

Repair Number: RE00151966

Serial: C6523458 Model M24 SWS Center Fire
Caliber: 7.62 NATO Produced: 12/18/1990

Repairman:

Verify Repair

Status:

Closed 9/26/2008 9:50:38 AM

Address Information

Customer:

☒ Received From

Return To:

☐ Received From

Name: DEF DIST DEPOT ANNISTON AL

DEF DIST DEPOT ANNISTON AL

Address 1: 7 FRANKFORD AVE BLDG 362

7 FRANKFORD AVE BLDG 362

Address 2: PO Box:

PO Box:

City: ANNISTON

ANNISTON

State: AL

Zip Code: 36201-4199

Country: US

State: AL

Zip Code: 36201-4199

Country: US

FPL:

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	2
A010	Hard Case	1
A017	Scope Base	1
A026	Scope	1
A057	Fit and Rear Sgt Base	1

Repair Search

Refresh

Close

nagletj

9/29/2008

2:39 PM

CAPS

NUM

INS

SCRL

H start

13 M...

4 M...

HR Ba...

2 M...

Arms...

Part S...

2:59 PM

Serial Number:

C6523458

Model: M24 SWS



RE00151966

INSPECTION CHECKLIST - REPAIRS

CONTRACT #: W52H09-07-C-0207

ISSUED 10/1/2007

R & E NUMBER

151966

SERIAL NUMBER

C6523458

LOG-IN DATE

9-26-08

OPERATION #	OPERATION NAME	DATE	INITIAL		
500	DIS-ASSEMBLE GUN	3-25-09	RTZ		
505	RE-BARREL	3-27-09	RTZ		
420	ASSEMBLE	3-27-09	RTZ		
440	PROOF	MAGNA - FLUX	3-27-09	TC	
460	CHECK HEADSPACE	3-27-09	TC		
470	DIS-ASSEMBLE GUN				
480	MAGNAFLUX	OPERATOR	4/2/09	(D)	
510	DRILL AND TAP	3-28-09	SR		
500	ROLLMARK CALIBER	4/12/09	RT		
520	GOFF BLAST BBL / REC	4-2	BT		
530 & 540	APPLY COATINGS	4-3			
560	FINAL ASSEMBLY	4-13-09	RTZ		
640	FUNCTION TEST AND	PASS	FAIL	4-13-09	RPD
650	TARGET	PASS	FAIL	4-13-09	RPD
	MALFUNCTION	CORRECTION			
	MALFUNCTION	CORRECTION			
	MALFUNCTION	CORRECTION			
	MALFUNCTION	CORRECTION			
670	FINAL INSPECTION			4-13-09	RP
	A) HEADSPACE	PASS	FAIL	4-14-09	NN
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	2.75 2.78 2.78 2.82 2.75	4-14-09	NN
680	F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX	4.5 5 5		
	G) SAFETY OFF FORCE	2 LBS MIN	3.5 3.5 3.5		
	I) FIRING PIN INDENT	.020	.022 .022 .022	4-14-09	NN
690	PACK			4/13/09	Fm

F006 REV 1/2009

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6523458.___0

FILE DATE AND TIME: 04/14/2009 05:32

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.091
The Average Y Centroid of the Five Target Set:	0.016
The Average Point of Impact of the Five Target Set:	0.092
The Average Mean Radius of the Five Target Set:	0.640
The Distance from POA to Centroid Target #1:	0.111
The Distance from Centroid Target #2 to Centroid Target #1:	0.105
The Distance from Centroid Target #3 to Centroid Target #1:	0.151
The Distance from Centroid Target #4 to Centroid Target #1:	0.046
The Distance from Centroid Target #5 to Centroid Target #1:	0.098

SERIAL NUMBER: C6523458. 0

TARGET NUMBER: 1

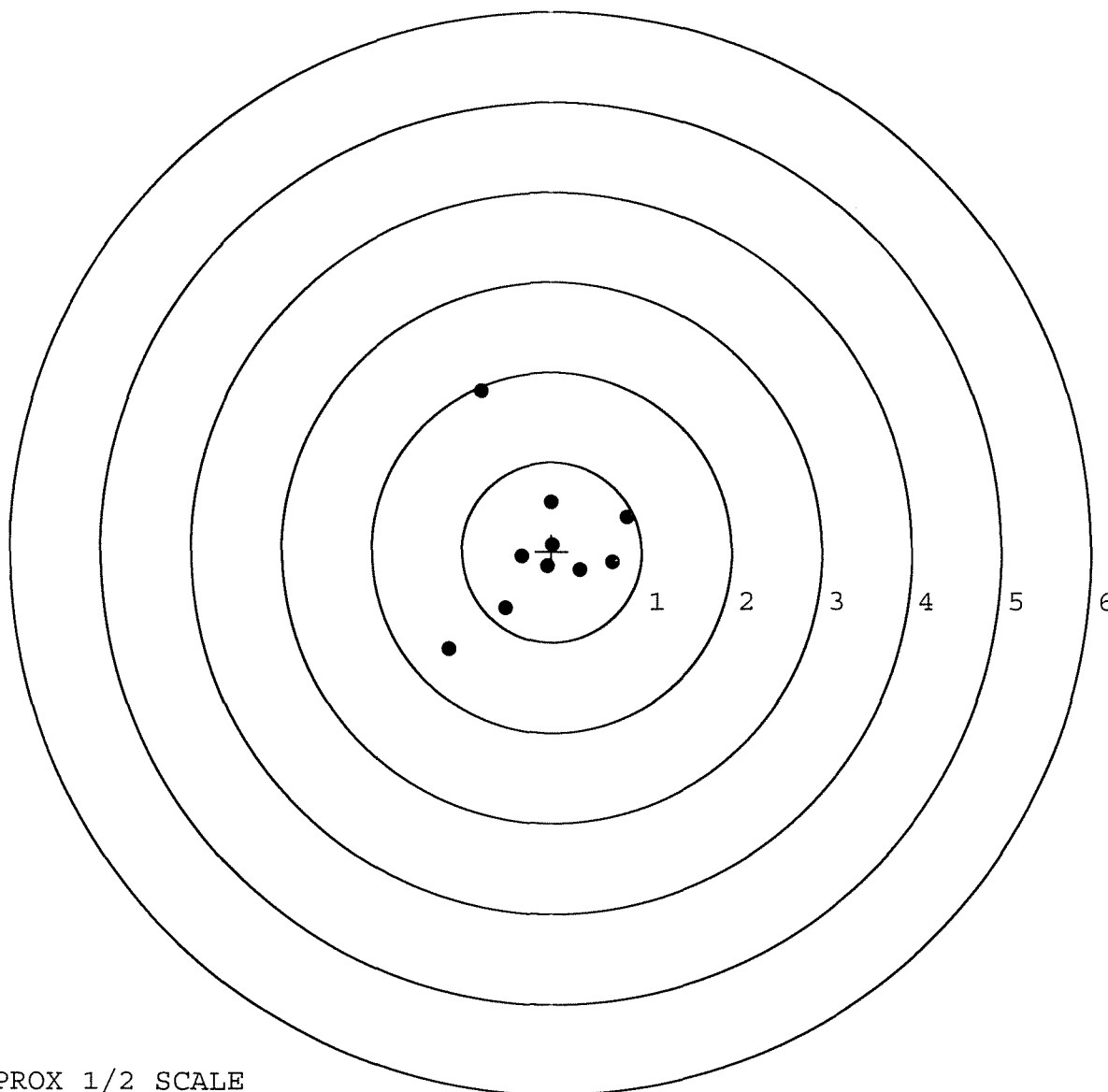
FILE DATE: 04/14/2009

FILE TIME: 05:32

X CENTROID: -0.098
Y CENTROID: 0.051
POA TO CENTROID: 0.111
HORZ SPREAD: 1.985
VERT SPREAD: 2.878
GROUP SPREAD: 2.900
MIN RADIUS: 0.110
MAX RADIUS: 1.873
MEAN RADIUS: 0.761

POINT#	X	Y
1:	-1.140	-1.085
2:	-0.516	-0.630
3:	-0.336	-0.059
4:	-0.051	-0.173
5:	0.011	0.069
6:	0.315	-0.212
7:	0.675	-0.123
8:	0.845	0.384
9:	0.003	0.549
10:	-0.786	1.793

IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 8



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6523458. 0

TARGET NUMBER: 2

FILE DATE: 04/14/2009

FILE TIME: 05:32

X CENTROID: -0.054

Y CENTROID: -0.044

POA TO CENTROID: 0.070

HORZ SPREAD: 2.076

VERT SPREAD: 2.160

GROUP SPREAD: 2.786

MIN RADIUS: 0.117

MAX RADIUS: 1.726

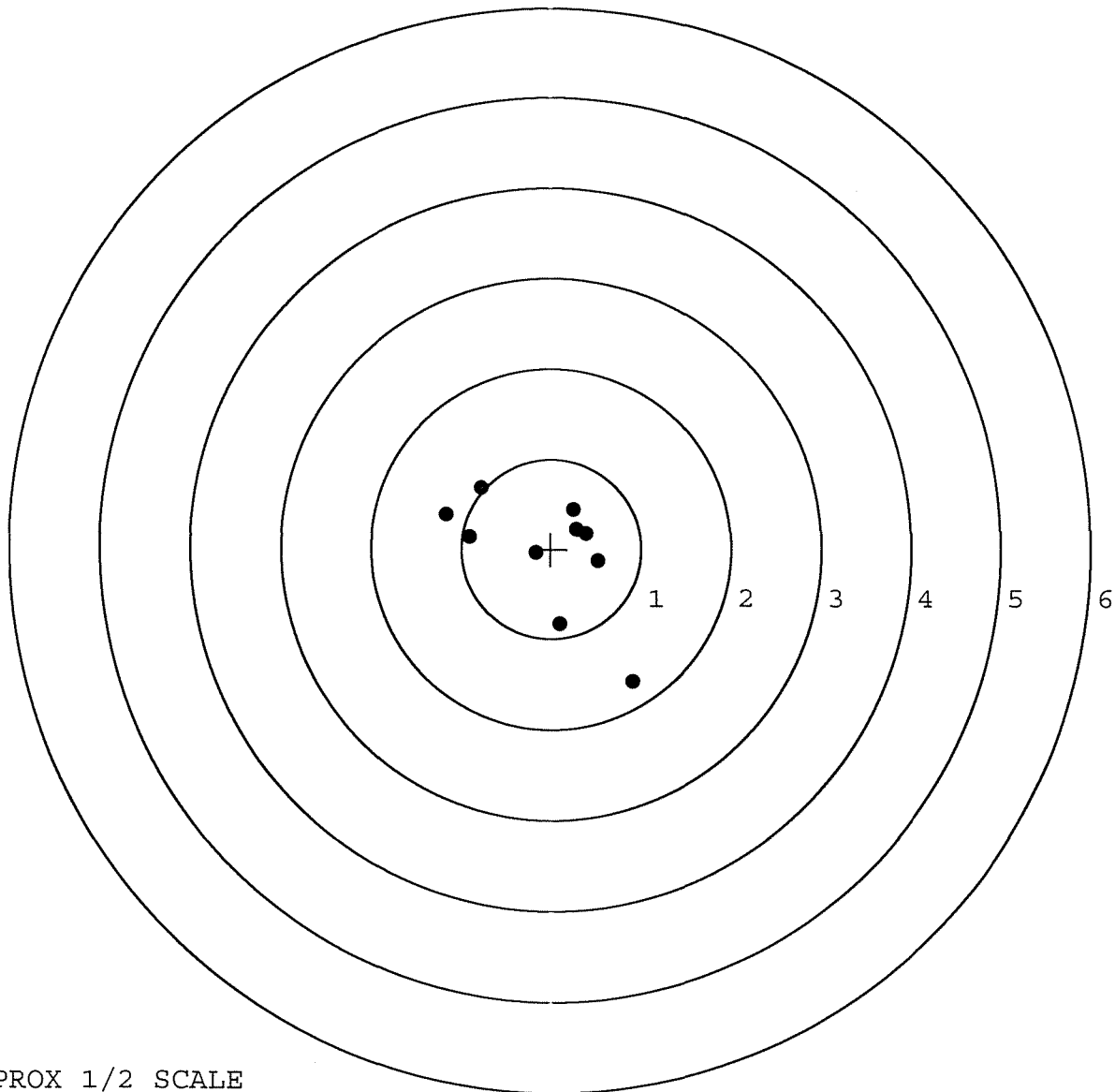
MEAN RADIUS: 0.784

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 9

POINT#	X	Y
1:	0.912	-1.474
2:	0.106	-0.840
3:	0.521	-0.129
4:	0.395	0.177
5:	0.258	0.443
6:	-0.171	-0.043
7:	0.291	0.222
8:	-0.908	0.134
9:	-1.164	0.384
10:	-0.781	0.686

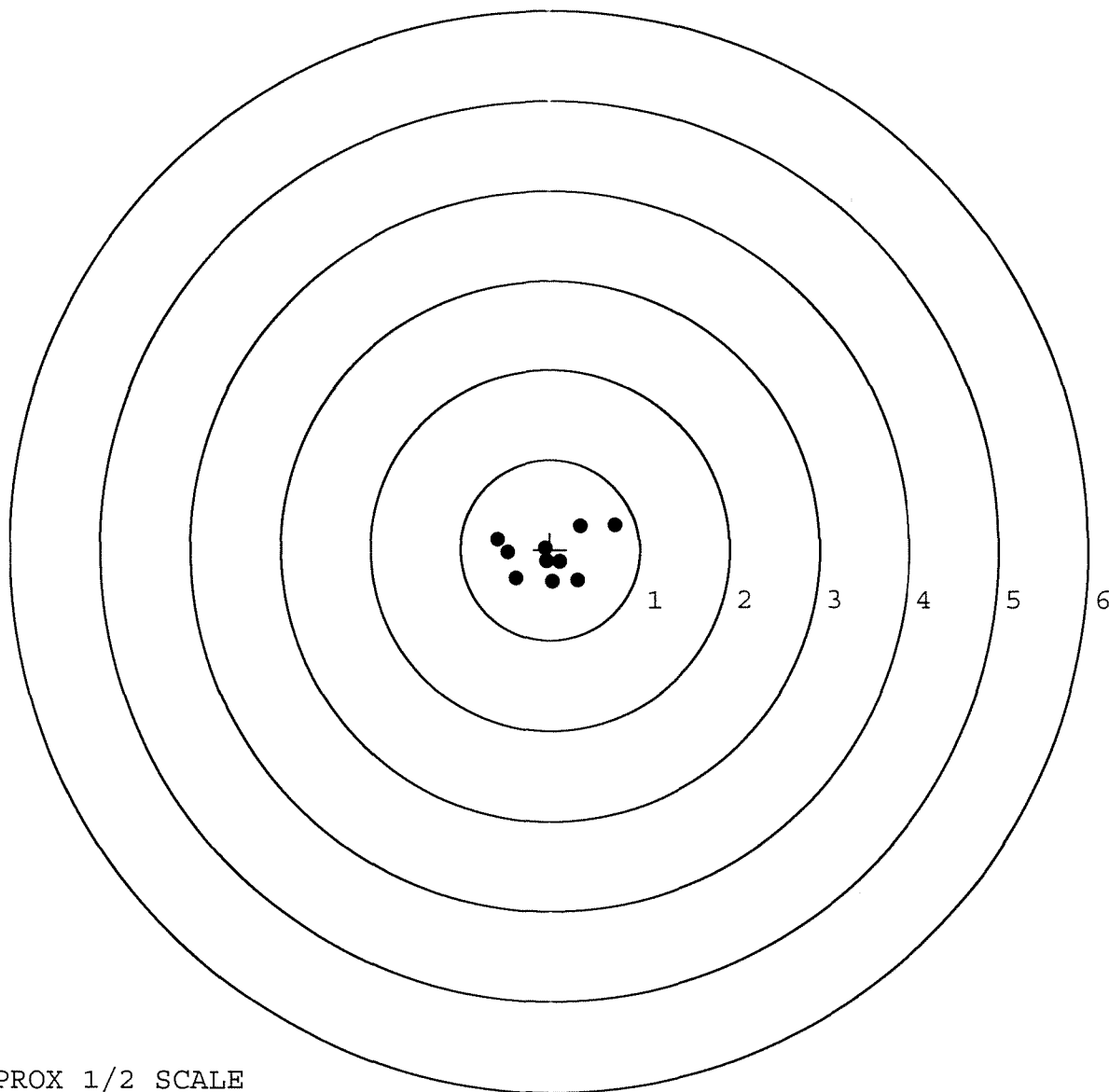


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6523458. __0
 TARGET NUMBER: 3
 FILE DATE: 04/14/2009
 FILE TIME: 05:32

POINT#	X	Y
1:	0.310	-0.340
2:	0.032	-0.359
3:	0.109	-0.134
4:	-0.040	-0.132
5:	-0.384	-0.318
6:	-0.475	-0.028
7:	-0.582	0.116
8:	0.732	0.274
9:	0.345	0.266
10:	-0.058	0.016

X CENTROID: -0.001
 Y CENTROID: -0.064
 POA TO CENTROID: 0.064
 HORZ SPREAD: 1.314
 VERT SPREAD: 0.633
 GROUP SPREAD: 1.323
 MIN RADIUS: 0.078
 MAX RADIUS: 0.807
 MEAN RADIUS: 0.385
 # IN 1 IN DIAMETER: 8
 # IN 2 IN DIAMETER: 10
 # in 3 IN DIAMETER: 10

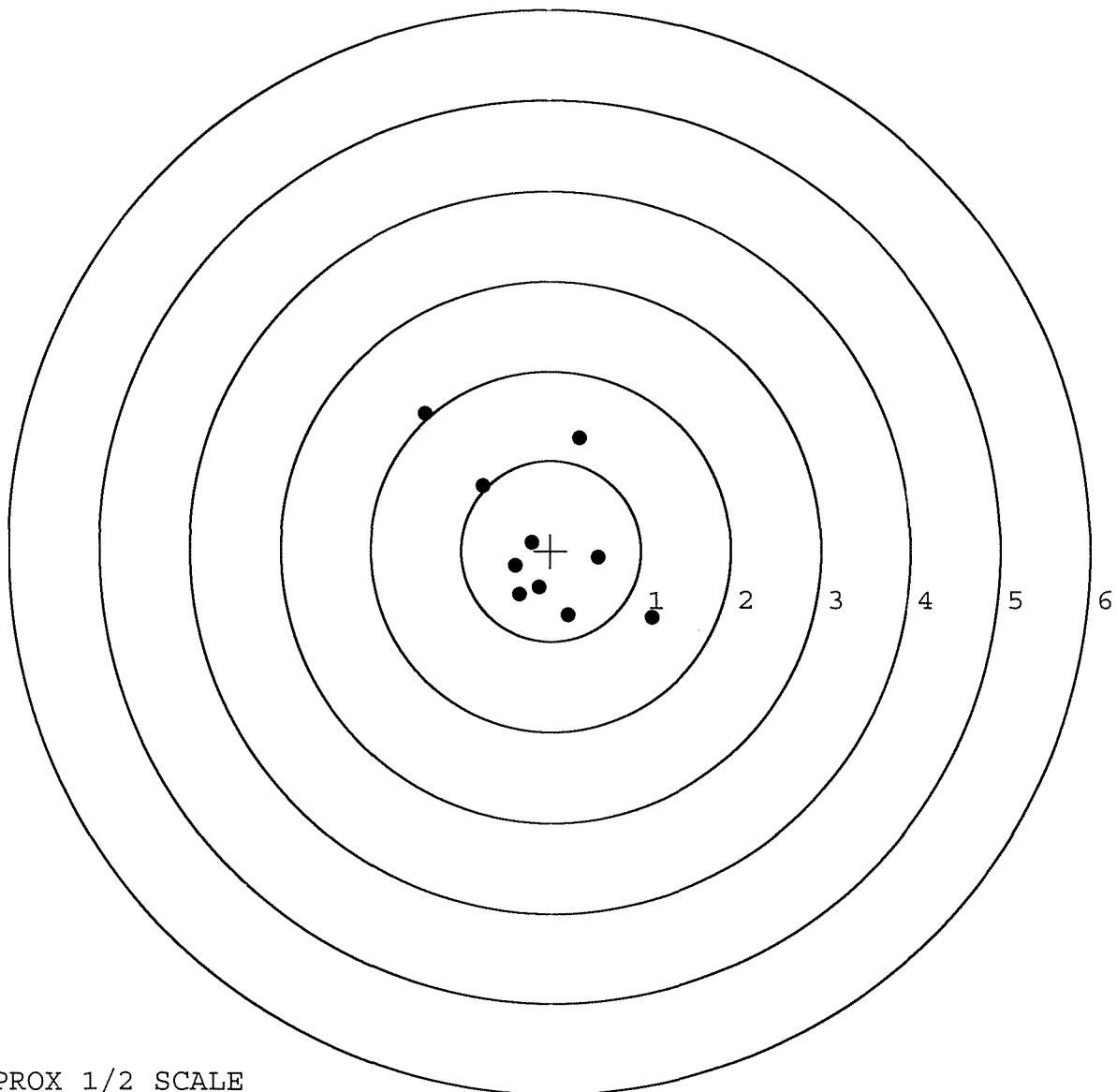


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6523458. __0
 TARGET NUMBER: 4
 FILE DATE: 04/14/2009
 FILE TIME: 05:32

X CENTROID: -0.106
 Y CENTROID: 0.097
 POA TO CENTROID: 0.143
 HORZ SPREAD: 2.512
 VERT SPREAD: 2.261
 GROUP SPREAD: 3.380
 MIN RADIUS: 0.108
 MAX RADIUS: 1.914
 MEAN RADIUS: 0.871
 # IN 1 IN DIAMETER: 2
 # IN 2 IN DIAMETER: 7
 # in 3 IN DIAMETER: 9

POINT#	X	Y
1:	1.123	-0.745
2:	0.197	-0.715
3:	-0.352	-0.491
4:	-0.129	-0.409
5:	-0.398	-0.167
6:	-0.213	0.088
7:	0.530	-0.079
8:	0.331	1.252
9:	-0.755	0.718
10:	-1.389	1.516

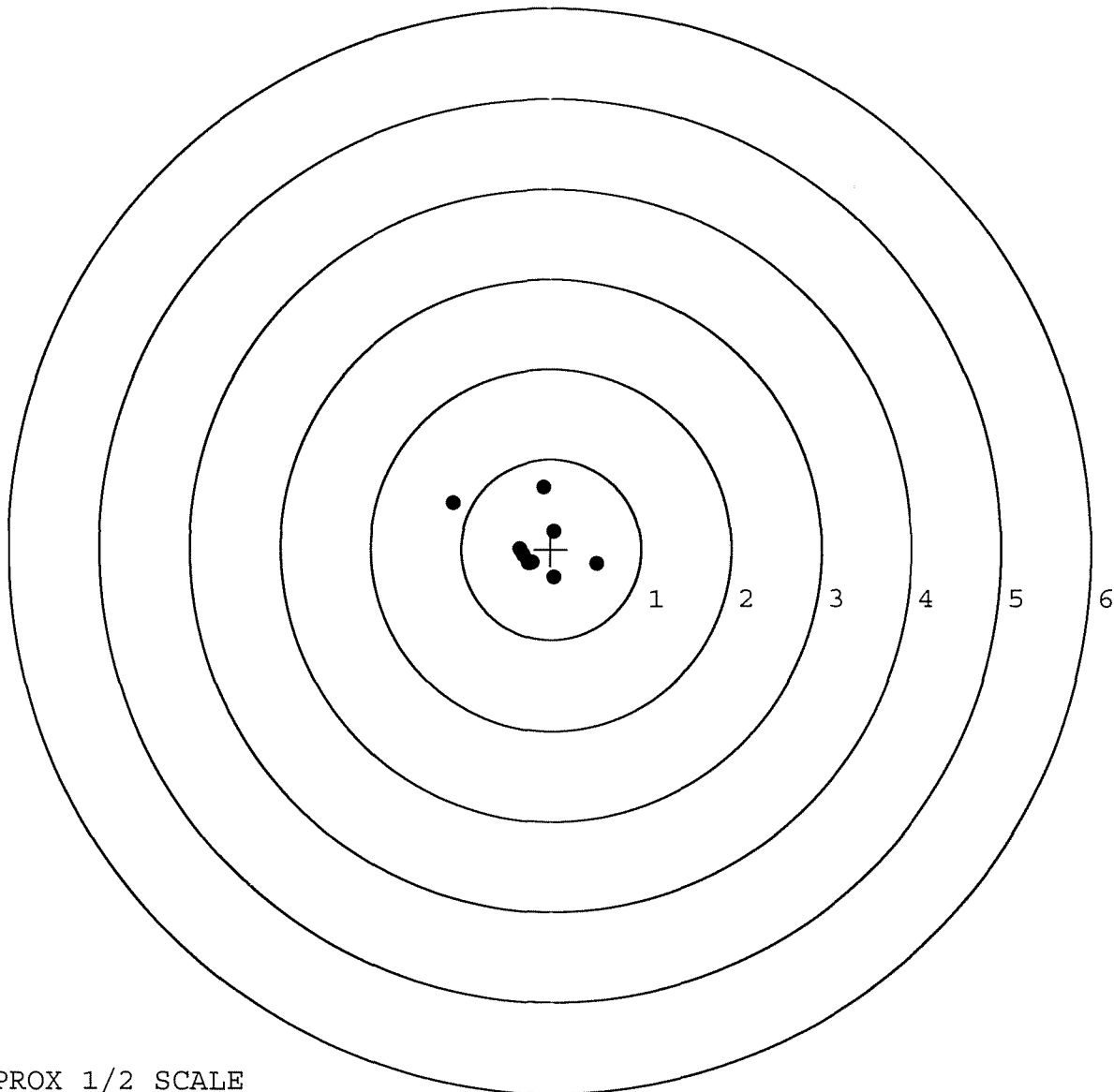


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6523458. __0
 TARGET NUMBER: 5
 FILE DATE: 04/14/2009
 FILE TIME: 05:32

X CENTROID: -0.195
 Y CENTROID: 0.041
 POA TO CENTROID: 0.200
 HORZ SPREAD: 1.594
 VERT SPREAD: 1.001
 GROUP SPREAD: 1.729
 MIN RADIUS: 0.152
 MAX RADIUS: 1.006
 MEAN RADIUS: 0.399
 # IN 1 IN DIAMETER: 7
 # IN 2 IN DIAMETER: 9
 # in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.036	-0.319
2:	0.508	-0.163
3:	-0.213	-0.142
4:	-0.353	0.007
5:	0.035	0.195
6:	-0.076	0.682
7:	-1.086	0.508
8:	-0.307	-0.063
9:	-0.239	-0.147
10:	-0.260	-0.152



TARGET APPROX 1/2 SCALE

Remington® **DUPONT**
REG. U.S. PAT. & TM. OFF.

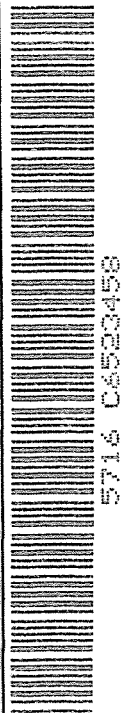
VERY IMPORTANT:
Instruction Book
enclosed to assure
safe use of this
firearm.

MODEL 700™ M24

SERIAL NO. 06523458

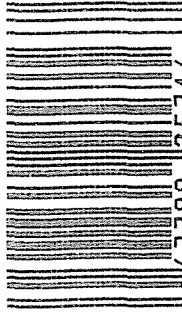
ORDER NO. 5716

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



5716 06523458

UPC



0 47700 25716 7

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6523458

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		10/2/90	KJ
600	Proof		10/2/90	KJ
607	Check Headspace		10/2/90	KJ
610	Dis-assemble Gun		10/2/90	KJ
612	Magnaflux Barrel Action		10/5/90	KR
	Magnaflux Bolt		10/5/90	KR
615	Rollmark Caliber		10/5/90	LS
617	Drill and Tap Sight Holes		10/8/90	RB
618	Polish Barrel RB		10/9/90	WB
620	Apply Coatings (Barrel Action)		10-20-90	TJ
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		11/7/90	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		11/7/90	KS
	C) Inspect Ejector Hole for Chamfer		11/7/90	KS
	D) Oil Firing Pin Ass'y		11/7/90	KS
	E) Adjust Trigger Pull to Min Setting and Stake		11/6/90	WB

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4.0	3.3/4	3.3/4			11/7/90	KS
	G) Safety Off Force	2 1/2	2 1/4	2 1/4			11/7/90	KS
	H) Trigger Pull Test & Retainability						11/6/90	WB
	I) Firing Pin Indent	.022	.023	.022			11/7/90	KS
	J) Assemble Stock						11/8/90	KS
	K) Assemble Swivel Studs						11-19-90	DH
	L) Attach Front and Rear Sight Assemblies						11/8/90	KS
	M) Iron Sight Alignment						11/8/90	KS
	N) Detach Front & Rear Sights & place in numbered container						11/8/90	KS
	O) Attach Scope to Rifle						11/8/90	KS
	P) Detach & Attach Scope 20 Times						11/8/90	KS
640	Gallery Target & Test						11-9-90	A
	A) Time						"	A
	B) Malfunctions						"	A
	C) Pierced Primers						"	A
	D) Optical Clarity of Scope						"	A
645	Inspect for Live Ammo						11-9-90	A
655	Final Inspection							
	A) Headspace						11-19-90	DH
	B) Trigger Pull	261	258	261	241	255	11-19-90	DH
	C) Function						11-19-90	DH
660	Pack						12-17-90	DH

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6523458DATE 11/6/90TESTER W/B

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.58	2.60	2.49	2.61	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.56	2.55	2.51	2.58	
PULL #3	2.49	2.60	2.57	2.61	
PULL #4	2.46	2.55	2.57	2.41	
PULL #5	2.40	2.60	2.58	2.55	
TOTAL	12.49	12.90	12.72		
AVG.	2.50	2.58	2.54		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.10	2.95		
PULL #2	3.08	2.96		
PULL #3	3.05	3.01		
PULL #4	3.04	3.00		
PULL #5	3.01	3.00		
TOTAL	15.28	14.92		
AVG.	3.06	2.98		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.17	4.16		4.00
PULL #2	4.15	4.00		3.90
PULL #3	4.11	4.05		3.95
PULL #4	4.01	4.04		4.00
PULL #5	4.14	4.19		3.90
TOTAL	20.58	20.44		19.75
AVG.	4.12	4.09		3.95

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6523458
9 Nov 1990

CENTROIDAL DISTANCES

0	TO	1	.217442
1	TO	2	.28493
1	TO	3	.369005
1	TO	4	.478759
1	TO	5	.177553

$\frac{1}{4}$ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0488
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0132
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0505537
THE AMR FOR THIS RIFLE IS: .9644

9 Nov 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6523458

CENTERFIRE PATTERNS

1

POA

1 in circle

2 in circle

3 in circle

CENTROID #

OF SHOTS - 10

IN CIR

1 in = 2

2 in = 8

3 in = 8

HS = 1.562

VS = 3.056

GS = 3.249

PATTERN #	:	1	2	3
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.766	.800	.704
MINIMUM X	:	-.796	-.762	-.697
MAXIMUM Y	:	1.385	1.200	.676
MINIMUM Y	:	-1.671	-.842	-.693
CENTROID X	:	.025	-.009	.087
CENTROID Y	:	-.216	-.031	-.181
POA TO CENTROID in.	:	.218	.032	.200
MIN RADIUS	:	.378	.205	.362
MEAN RADIUS	:	.860	.737	.655
MAX RADIUS	:	1.699	1.421	.945
HORIZONTAL SPREAD	:	1.562	1.562	1.401
VERTICAL SPREAD	:	3.056	2.042	1.369
EXTREME SPREAD	:	3.249	2.492	1.635
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	8		
NUMBER IN THREE INCH CIRCLE	=	8		

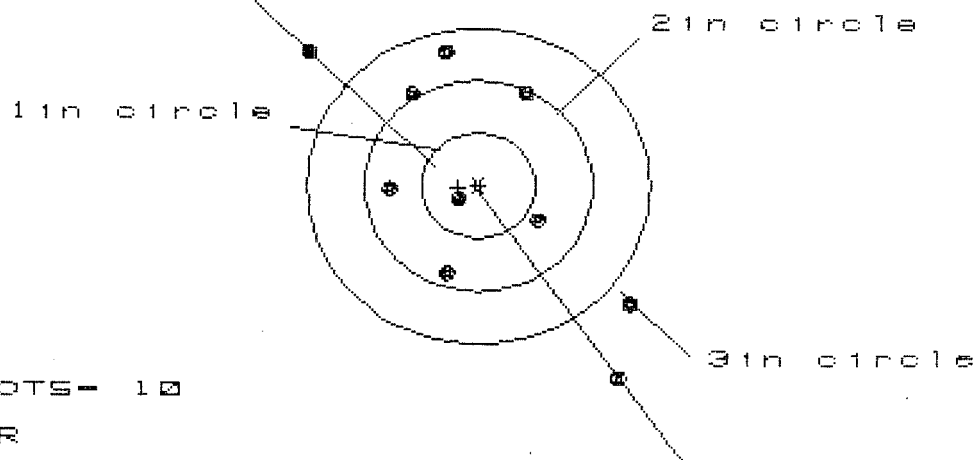
9 Nov 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C8523458

CENTERFIRE PATTERNS

2

POA



OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 7

HS= 2.791

VS= 3.166

GS= 4.140

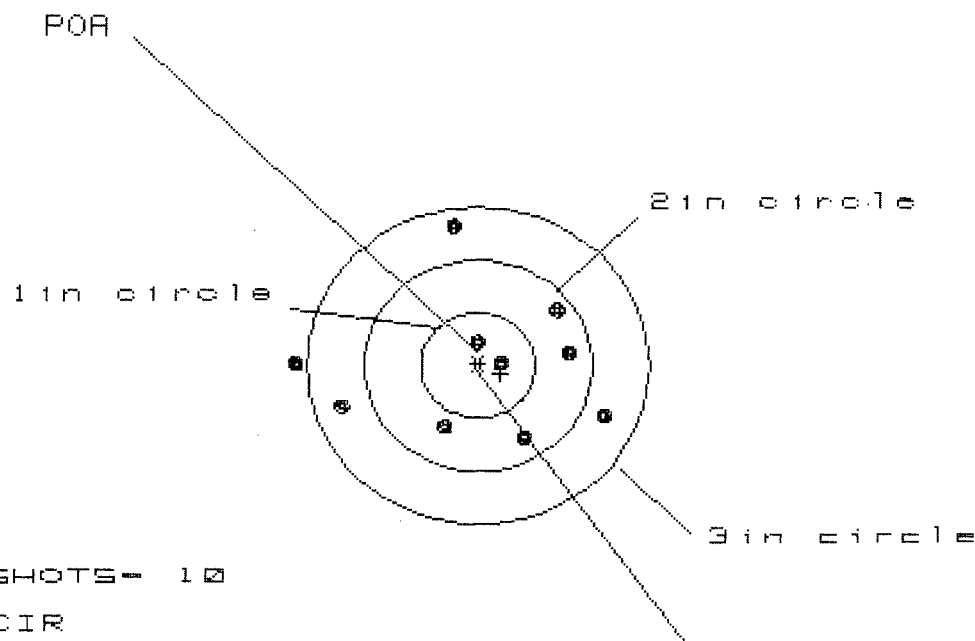
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.318	1.451	1.283
MINIMUM X	:	-1.473	-1.340	-.824
MAXIMUM Y	:	1.298	1.091	1.204
MINIMUM Y	:	-1.868	-1.348	-1.212
CENTROID X	:	.177	.044	.212
CENTROID Y	:	.025	.232	.096
POA TO CENTROID in.	:	.179	.236	.233
MIN RADIUS	:	.202	.317	.273
MEAN RADIUS	:	1.168	1.035	.942
MAX RADIUS	:	2.217	1.980	1.765
HORIZONTAL SPREAD	:	2.791	2.791	2.107
VERTICAL SPREAD	:	3.166	2.439	2.416
EXTREME SPREAD	:	4.140	3.707	2.875
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		7	

9 Nov 1998

FILE:/PATTERNING/CENTERFIRE_PATT/06523458

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 2

2in = 6

3in = 9

HS= 2.715

VS= 2.012

GS= 2.751

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.140	.965	.914
MINIMUM X	:	-1.575	-1.333	-1.384
MAXIMUM Y	:	1.296	1.295	.650
MINIMUM Y	:	-.716	-.717	-.555
CENTROID X	:	-.198	-.023	.028
CENTROID Y	:	.078	.079	-.082
POA TO CENTROID in.	:	.213	.083	.087
MIN RADIUS	:	.212	.071	.154
MEAN RADIUS	:	.888	.776	.701
MAX RADIUS	:	1.575	1.376	1.395
HORIZONTAL SPREAD	:	2.715	2.298	2.298
VERTICAL SPREAD	:	2.012	2.012	1.206
EXTREME SPREAD	:	2.751	2.301	2.301
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

9 Nov 1990

FILE:/PATTERNING/CENTERFIRE_PATT/C6523458

CENTERFIRE PATTERNS

4

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 2

2in = 6

3in = 7

HS= 3.444

VS= 2.121

GS= 3.777

CENTROID *

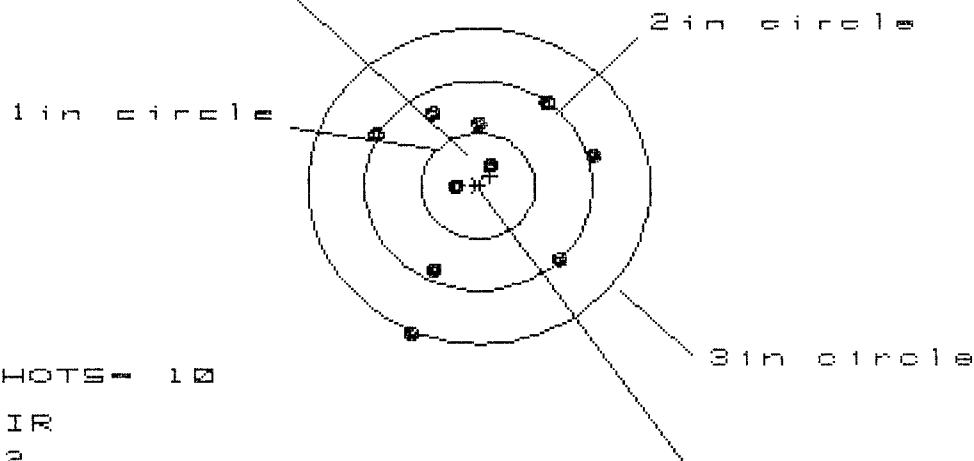
PATTERN #	:	4	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.109	.850	.593
MINIMUM X	:	-2.335	-2.053	-.900
MAXIMUM Y	:	1.229	1.158	1.168
MINIMUM Y	:	-.892	-.963	-.953
CENTROID X	:	.344	.603	.860
CENTROID Y	:	.141	.212	.202
POA TO CENTROID in.	:	.371	.639	.883
MIN RADIUS	:	.233	.320	.250
MEAN RADIUS	:	1.073	.866	.662
MAX RADIUS	:	2.420	2.054	1.245
HORIZONTAL SPREAD	:	3.444	2.903	1.493
VERTICAL SPREAD	:	2.121	2.121	2.121
EXTREME SPREAD	:	3.777	2.947	2.228
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		7	

9 Nov 1990

FILE:/PATTERNING/CENTERFIRE_PATT/06523458

CENTERFIRE PATTERNS # 5

POA



OF SHOTS - 10

IN CIR

1in = 2

2in = 8

3in = 9

HS= 1.882

VS= 2.243

GS= 2.513

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.017	.952	.735
MINIMUM X	:	-.865	-.930	-.810
MAXIMUM Y	:	.796	.636	.647
MINIMUM Y	:	-1.447	-.994	-.983
CENTROID X	:	-.104	-.039	-.159
CENTROID Y	:	-.094	.066	.055
POA TO CENTROID in.	:	.140	.077	.168
MIN RADIUS	:	.170	.116	.220
MEAN RADIUS	:	.833	.719	.685
MAX RADIUS	:	1.558	1.113	1.141
HORIZONTAL SPREAD	:	1.882	1.882	1.546
VERTICAL SPREAD	:	2.243	1.630	1.630
EXTREME SPREAD	:	2.513	1.969	1.969
NUMBER IN ONE INCH CIRCLE =			2	
NUMBER IN TWO INCH CIRCLE =			8	
NUMBER IN THREE INCH CIRCLE =			9	