C634907A

MODEL 700™ M24

Model SPS™

Action

Barrel Length

Capacity

Order No. 57176

*Includes 1 in chamber.

Remington

06/17/08 10:49:34

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: RE00146475
Verify Repair

Serial: C6349074 Model M24 SWS Center Fire
Caliber: 7.62 NATO Produced: 06/19/1990

Repairman:
Status: Closed 6/17/2008 9:52:11 AM

Address Information

Customer: (Received From)	Return To: (Received From)
Name: DEF DIST DEPOT	DEF DIST DEPOT
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 Country: US	State: AL Zip Code: 36201 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
A017	Scope Base	1
A026	Scope	1
A045	Bi Pod	1
D000	FRT SGT BASE	1

Repair Search | Refresh | Close

nagletj | 6/17/2008 | 10:49 AM | CAPS | NUM | INS | SCRL

start | 10 M | My... | 4 M... | Par... | Ar... | Cre... | My... | 10:49 AM

Number: C6349074

Model: M24 SWS

RE00146475

M-24
INSPECTION CHECKLIST - REPAIRS
CONTRACT #: W52H09-07-C-0207
ISSUED 10/1/2007

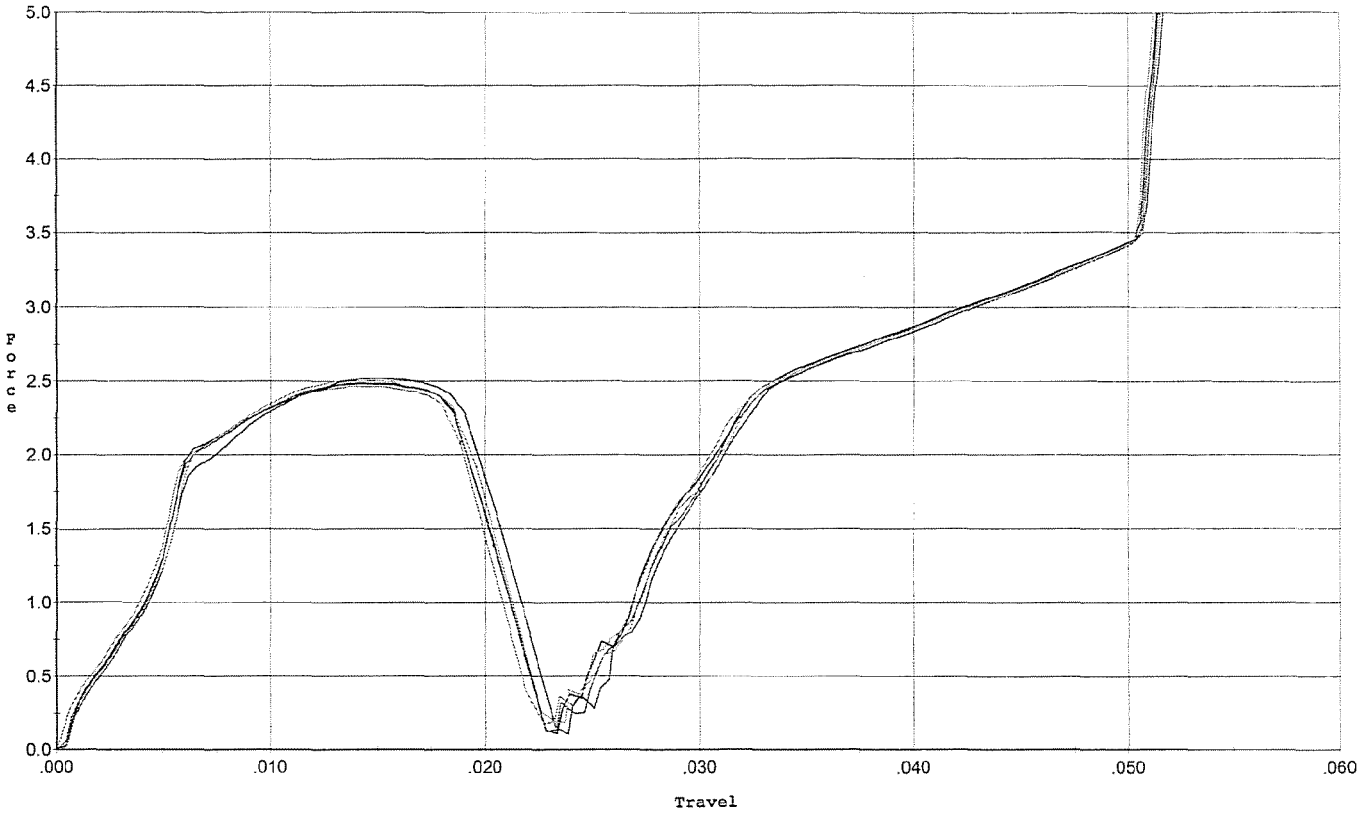
R & E NUMBER 146475
SERIAL NUMBER CB349074
LOG-IN DATE 6-17-08

OPERATION #	OPERATION NAME			DATE	INITIAL
500	DIS-ASSEMBLE GUN			9-9-09	RTC
505	RE BARREL			9-11-09	RTC
420	ASSEMBLE			9-11-09	RTC
440	PROOF			9-11-09	LPL
460	CHECK HEADSPACE			9-11-09	LPL
470	DIS-ASSEMBLE GUN			9-11-09	LPL
480	MAGNAFLUX	(P)		9-14-09	LPL
510	DRILL AND TAP			9-14-09	LPL
500	ROLLMARK CALIBER			9/17/09	SP
520	GOFF BLAST BBL / REC			9/17/09	SP
530 & 540	APPLY COATINGS			9/18	
560	FINAL ASSEMBLY			9-23-09	RTC
640	FUNCTION TEST AND	(PASS)	FAIL	9-28-09	LPL
650	TARGET	(PASS)	FAIL	9-28-09	LPL
	MALFUNCTION	CORRECTION	N/A		
	MALFUNCTION	CORRECTION			
	MALFUNCTION	CORRECTION			
	MALFUNCTION	CORRECTION		9-28-09	RP
670	FINAL INSPECTION A) HEADSPACE	(PASS)	FAIL	9/29/09	RB
	B) TRIGGER PULL (+/- 5 LBS, MIN 2.50 LBS, MAX 4.0 LBS)	2.90	2.77 2.63 2.62 2.70	9/29/09	RB
680	F) SAFETY ON FORCE (2 LBS MIN, 10 LBS MAX)	3#	3# 3#	9/29/09	RB
	G) SAFETY OFF FORCE (2 LBS MIN)	7#	7# 7#		
	I) FIRING PIN INDENT .020	.021	.021 .021		
690	PACK			10/12/09	FM

F006 REV 1/2009

Trigger Profile [lbs,inch]

Profile	SWS	**Model:**	M/24
GunType:	Rifle	**Serial No:**	Form #F005
Make:	Remington	**Trigger:**	2.5 lbs. ini. +/- .50 lbs.
Note:	R.P. 9/8/09		

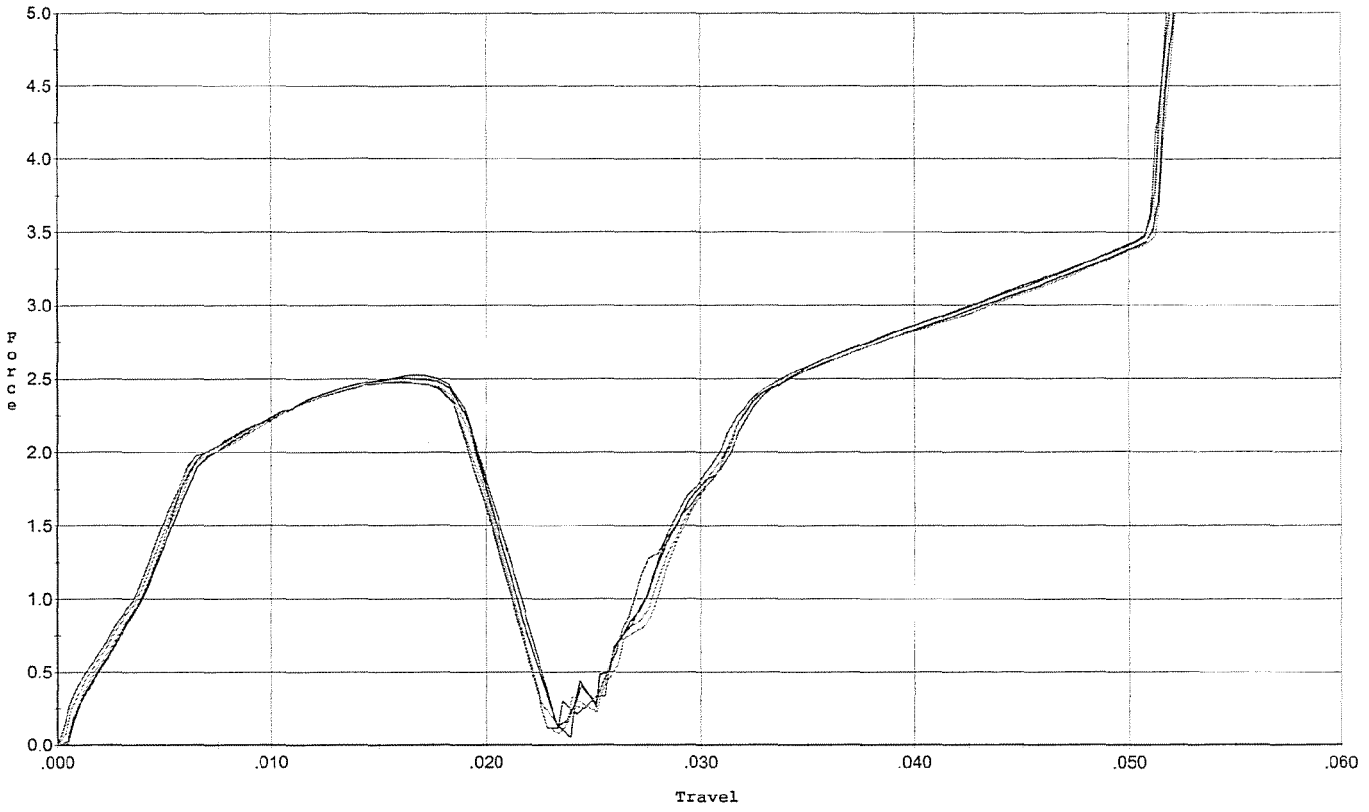


#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.519	0.021	0.00	0.034	0.036		Set Trigger
2	2.482	0.020	0.00	0.035	0.036		Set Trigger
3	2.491	0.020	0.00	0.035	0.036		Set Trigger
4	2.514	0.020	0.00	0.035	0.035		Set Trigger
5	2.465	0.019	0.00	0.035	0.033		Set Trigger

Avg 2.49

Trigger Profile [lbs,inch]

Profile	SWS	**Model:**	M/24
GunType:	Rifle	**Serial No:**	Form #F005
Make:	Remington	**Trigger:**	2.5 lbs. after 50 cycles +/- .50 lbs.
Note:	R.P. 9/8/09		



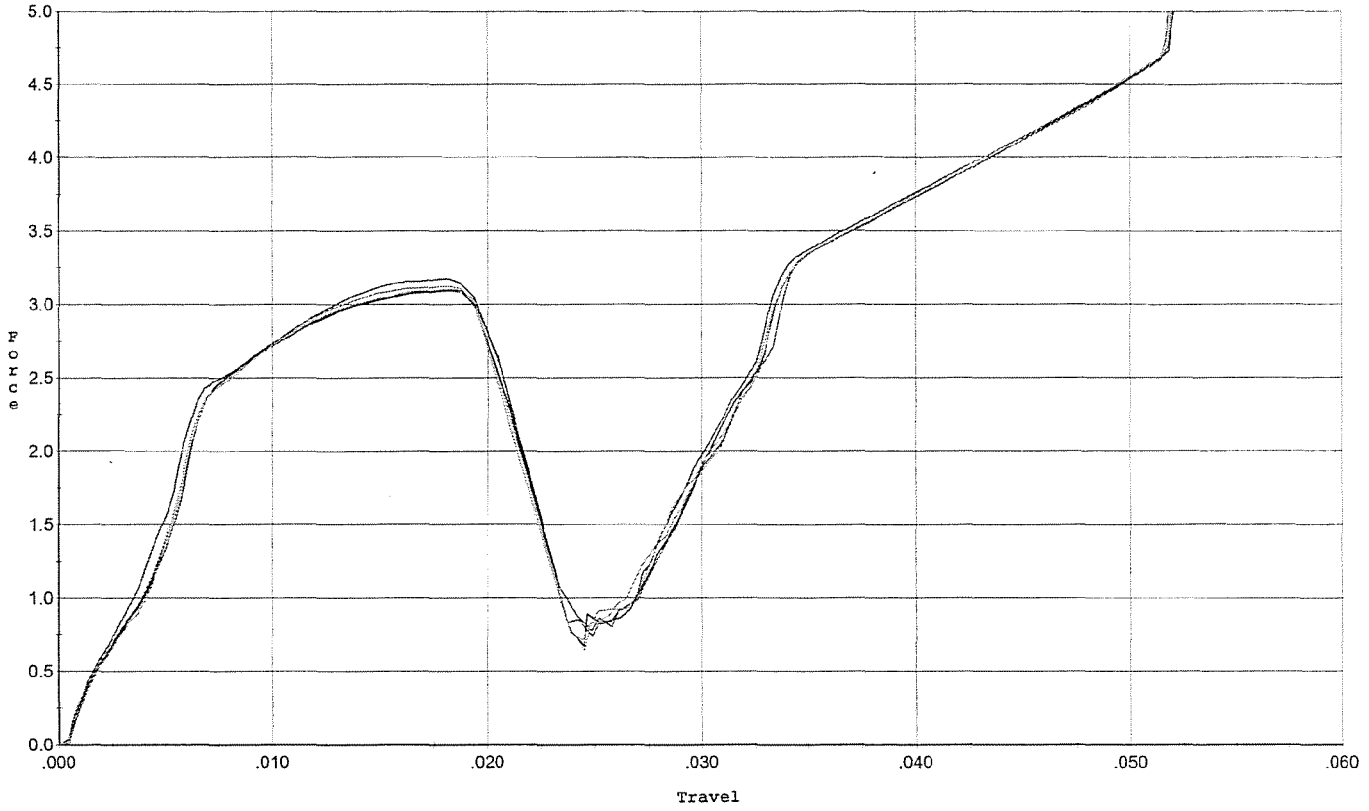
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.524	0.021	0.00	0.035	0.037		Set Trigger
2	2.506	0.019	0.00	0.035	0.033		Set Trigger
3	2.482	0.020	0.00	0.035	0.036		Set Trigger
4	2.485	0.020	0.00	0.035	0.035		Set Trigger
5	2.474	0.019	0.00	0.036	0.034		Set Trigger

Avg 2.49

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc.. 9/8/2009 5:14:37 PM

Trigger Profile [lbs,inch]

Profile	SWS	**Model:**	M/24
GunType:	Rifle	**Serial No:**	Form #F005
Make:	Remington	**Trigger:**	3.0 lbs. ini. +/- .75 lbs.
Note:	R.P. 9/8/09		



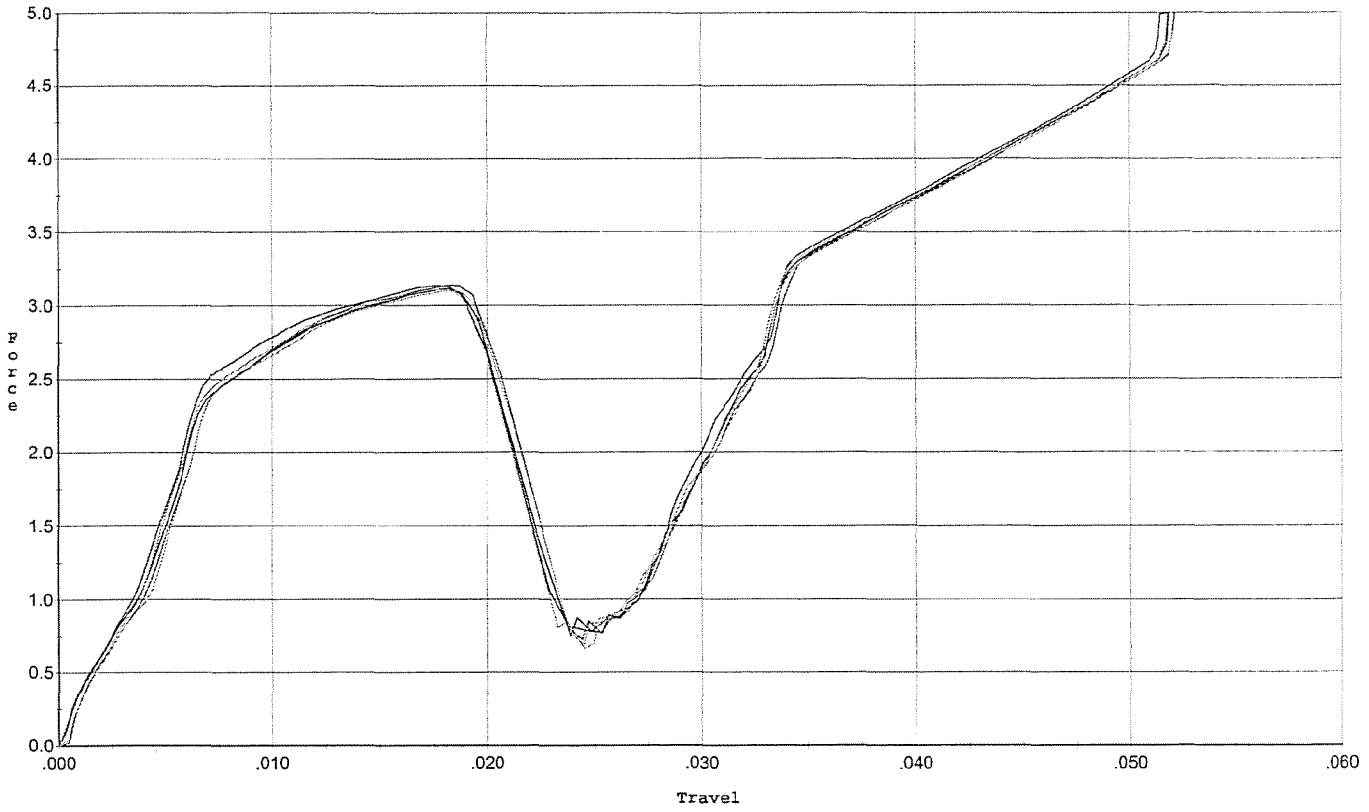
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.174	0.020	0.00	0.033	0.045		Set Trigger
2	3.096	0.021	0.00	0.033	0.044		Set Trigger
3	3.105	0.021	0.00	0.033	0.043		Set Trigger
4	3.103	0.020	0.00	0.033	0.041		Set Trigger
5	3.123	0.021	0.00	0.033	0.045		Set Trigger

Avg 3.12

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc.. 9/8/2009 5:16:07 PM

Trigger Profile [lbs,inch]

Profile	SWS	**Model:**	M/24
GunType:	Rifle	**Serial No:**	Form #F005
Make:	Remington	**Trigger:**	3.0 lbs. after 20 cycles +/- .75 lbs.
Note:	R.P. 9/8/09		



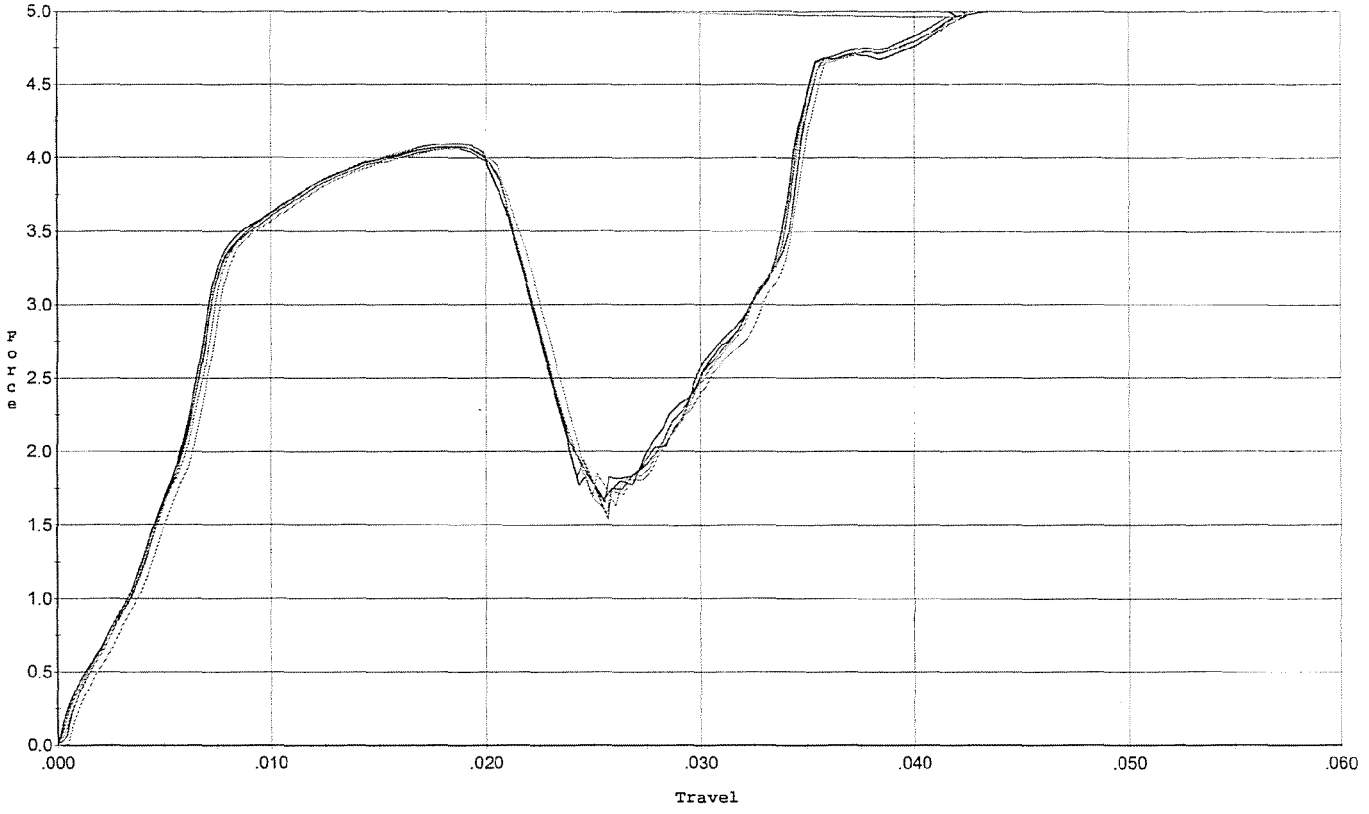
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.135	0.020	0.00	0.033	0.043		Set Trigger
2	3.114	0.020	0.00	0.033	0.041		Set Trigger
3	3.137	0.021	0.00	0.033	0.044		Set Trigger
4	3.101	0.021	0.00	0.033	0.044		Set Trigger
5	3.109	0.020	0.00	0.033	0.042		Set Trigger

Avg 3.11

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc.. 9/8/2009 5:17:27 PM

Trigger Profile [lbs,inch]

Profile	SWS	**Model:**	M/24
GunType:	Rifle	**Serial No:**	Form #F005
Make:	Remington	**Trigger:**	4.0 lbs. ini. +/- 1.0 lbs.
Note:	R.P. 9/8/09		



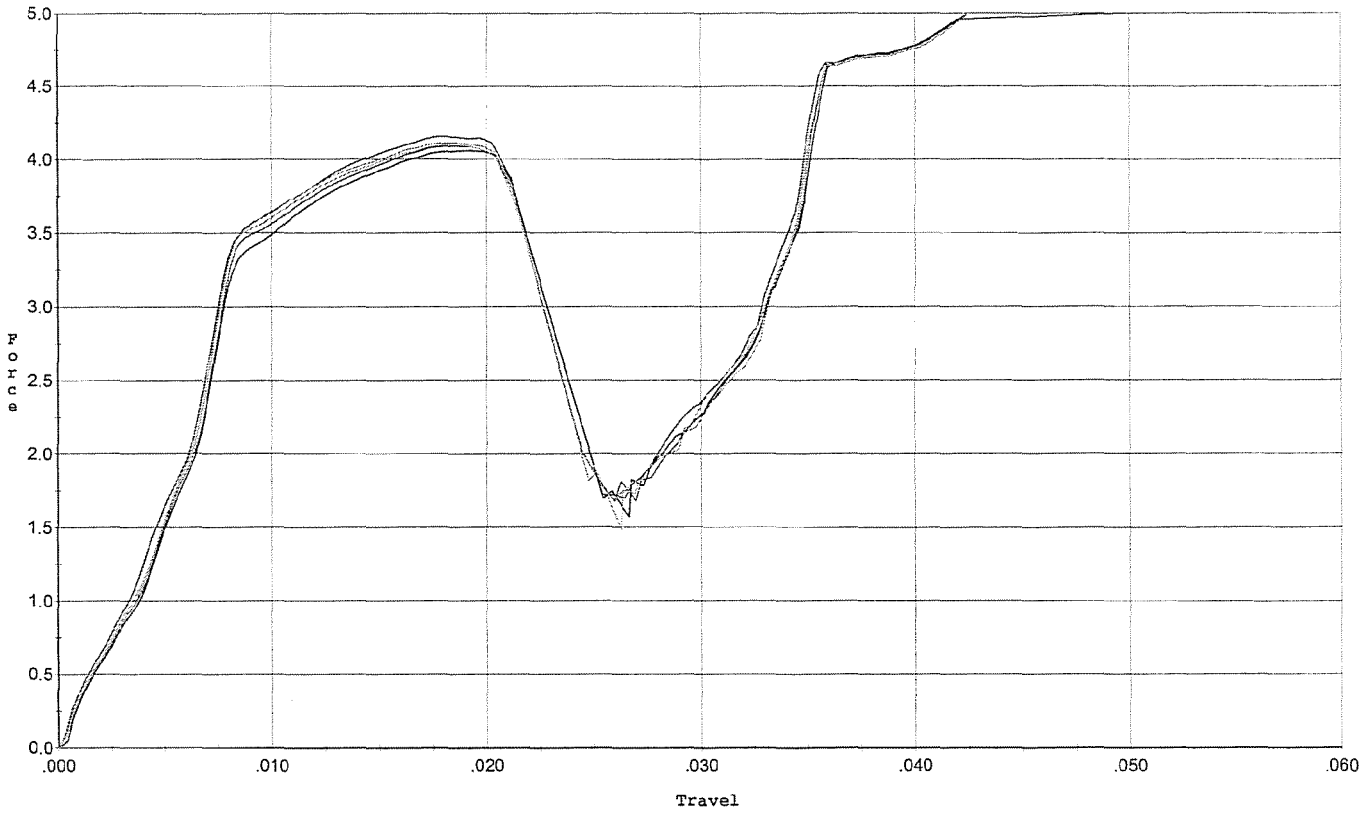
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.094	0.021	0.00	0.031	0.057		Set Trigger
2	4.072	0.021	0.00	0.031	0.058		Set Trigger
3	4.061	0.021	0.00	0.031	0.057		Set Trigger
4	4.065	0.022	0.00	0.031	0.059		Set Trigger
5	4.099	0.021	0.00	0.031	0.056		Set Trigger

Avg 4.07

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc.. 9/8/2009 5:19:09 PM

Trigger Profile [lbs,inch]

Profile	SWS	**Model:**	M/24
GunType:	Rifle	**Serial No:**	Form #F005
Make:	Remington	**Trigger:**	4.0 lbs. after 20 cycles +/- 1.0 lbs.
Note:	R.P. 9/8/09		



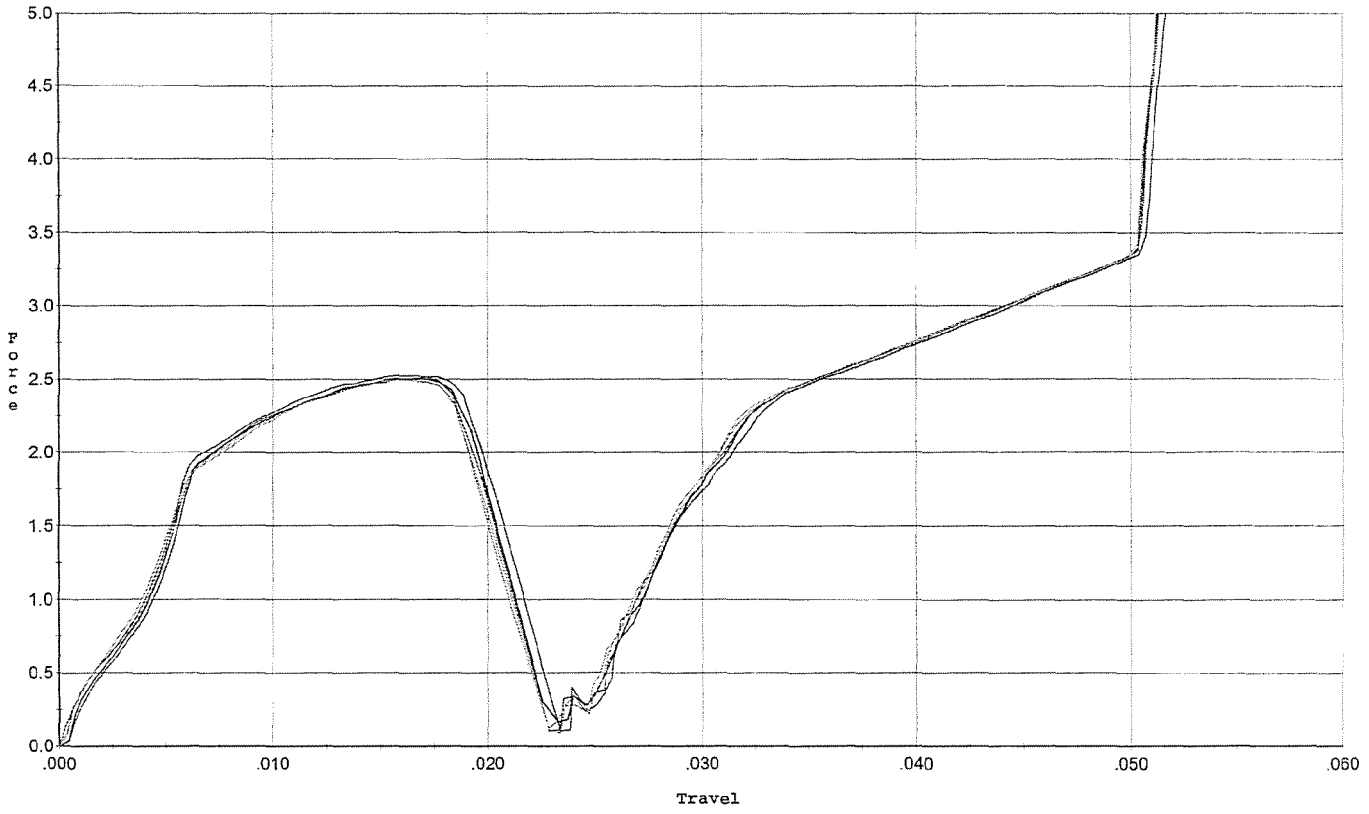
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.155	0.021	0.00	0.031	0.059		Set Trigger
2	4.057	0.021	0.00	0.031	0.057		Set Trigger
3	4.088	0.021	0.00	0.031	0.058		Set Trigger
4	4.094	0.021	0.00	0.031	0.058		Set Trigger
5	4.111	0.021	0.00	0.031	0.058		Set Trigger

Avg 4.10

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc.. 9/8/2009 5:20:26 PM

Trigger Profile [lbs,inch]

Profile	SWS	**Model:**	M/24
GunType:	Rifle	**Serial No:**	Form #F005
Make:	Remington	**Trigger:**	reset to 2.5 lbs. +/- .50 lbs. for final test
Note:	R.P. 9/8/09		



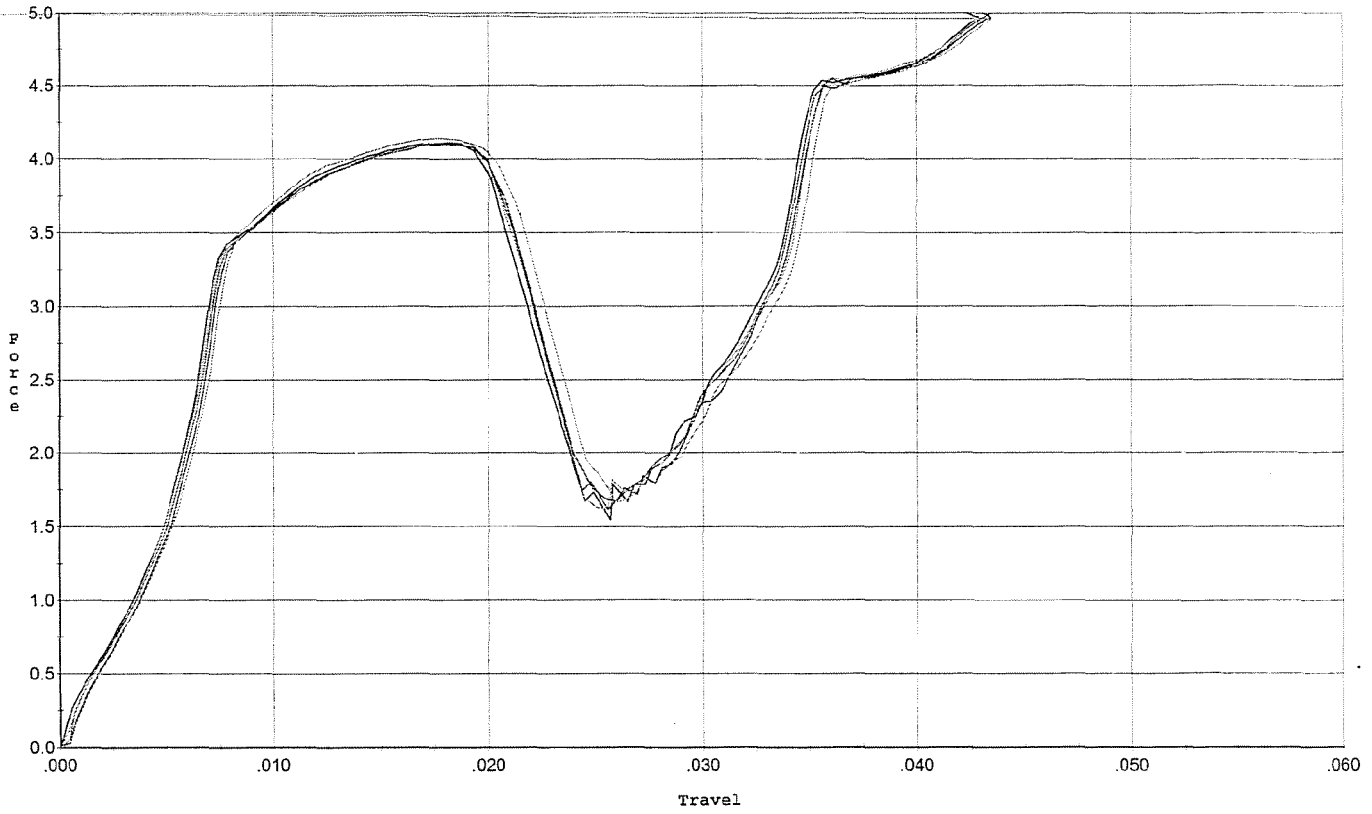
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.517	0.020	0.00	0.034	0.036		Set Trigger
2	2.507	0.019	0.00	0.035	0.034		Set Trigger
3	2.524	0.020	0.00	0.035	0.035		Set Trigger
4	2.502	0.020	0.00	0.035	0.035		Set Trigger
5	2.498	0.018	0.00	0.035	0.032		Set Trigger

Avg 2.51

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc.. 9/8/2009 5:22:35 PM

Trigger Profile [lbs,inch]

Profile	SWS	**Model:**	M/24
GunType:	Rifle	**Serial No:**	Form #F005
Make:	Remington	**Trigger:**	set to 4.0 lbs. +/- 1.0 lbs. for target & accuracy
Note:	R.P. 9/8/09		



#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.098	0.021	0.00	0.031	0.057		Set Trigger
2	4.109	0.020	0.00	0.031	0.055		Set Trigger
3	4.096	0.021	0.00	0.031	0.057		Set Trigger
4	4.115	0.021	0.00	0.031	0.058		Set Trigger
5	4.139	0.021	0.00	0.031	0.059		Set Trigger

Avg 4.11

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc.. 9/8/2009 5:24:41 PM

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFOMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6349074.__0
FILE DATE AND TIME: 09/29/2009 10:13

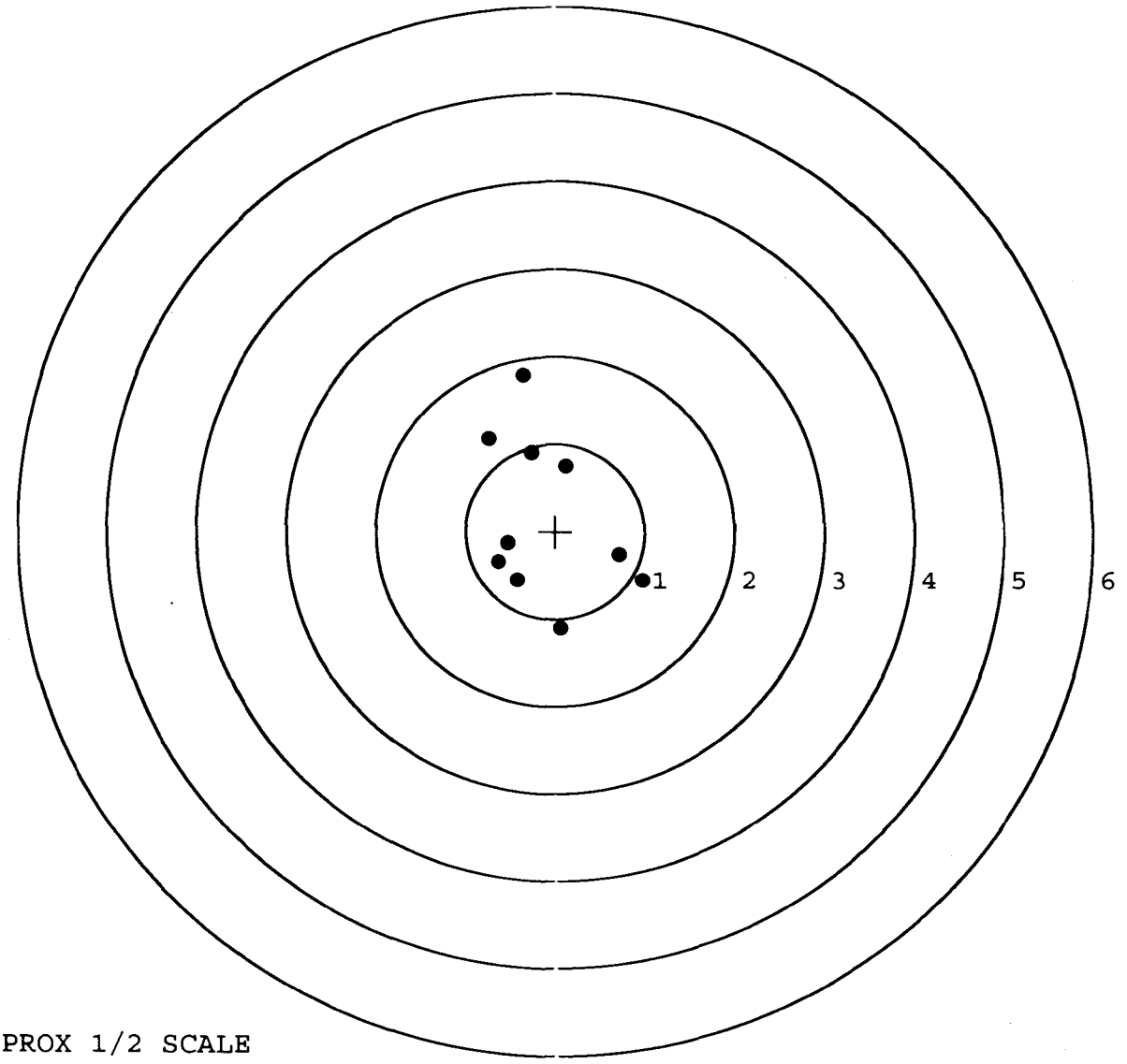
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.003
The Average Y Centroid of the Five Target Set:	0.031
The Average Point of Impact of the Five Target Set:	0.031
The Average Mean Radius of the Five Target Set:	0.987
The Distance from POA to Centroid Target #1:	0.188
The Distance from Centroid Target #2 to Centroid Target #1:	0.125
The Distance from Centroid Target #3 to Centroid Target #1:	0.180
The Distance from Centroid Target #4 to Centroid Target #1:	0.179
The Distance from Centroid Target #5 to Centroid Target #1:	0.519

SERIAL NUMBER: C6349074.__0
TARGET NUMBER: 1
FILE DATE: 09/29/2009
FILE TIME: 10:13

X CENTROID:	-0.107
Y CENTROID:	0.155
POA TO CENTROID:	0.188
HORZ SPREAD:	1.719
VERT SPREAD:	2.891
GROUP SPREAD:	2.921
MIN RADIUS:	0.510
MAX RADIUS:	1.646
MEAN RADIUS:	0.966
# IN 1 IN DIAMETER:	0
# IN 2 IN DIAMETER:	6
# in 3 IN DIAMETER:	9

POINT#	X	Y
1:	-0.359	1.781
2:	-0.740	1.060
3:	-0.265	0.904
4:	0.125	0.752
5:	0.061	-1.110
6:	0.979	-0.557
7:	0.718	-0.261
8:	-0.426	-0.548
9:	-0.636	-0.344
10:	-0.531	-0.129

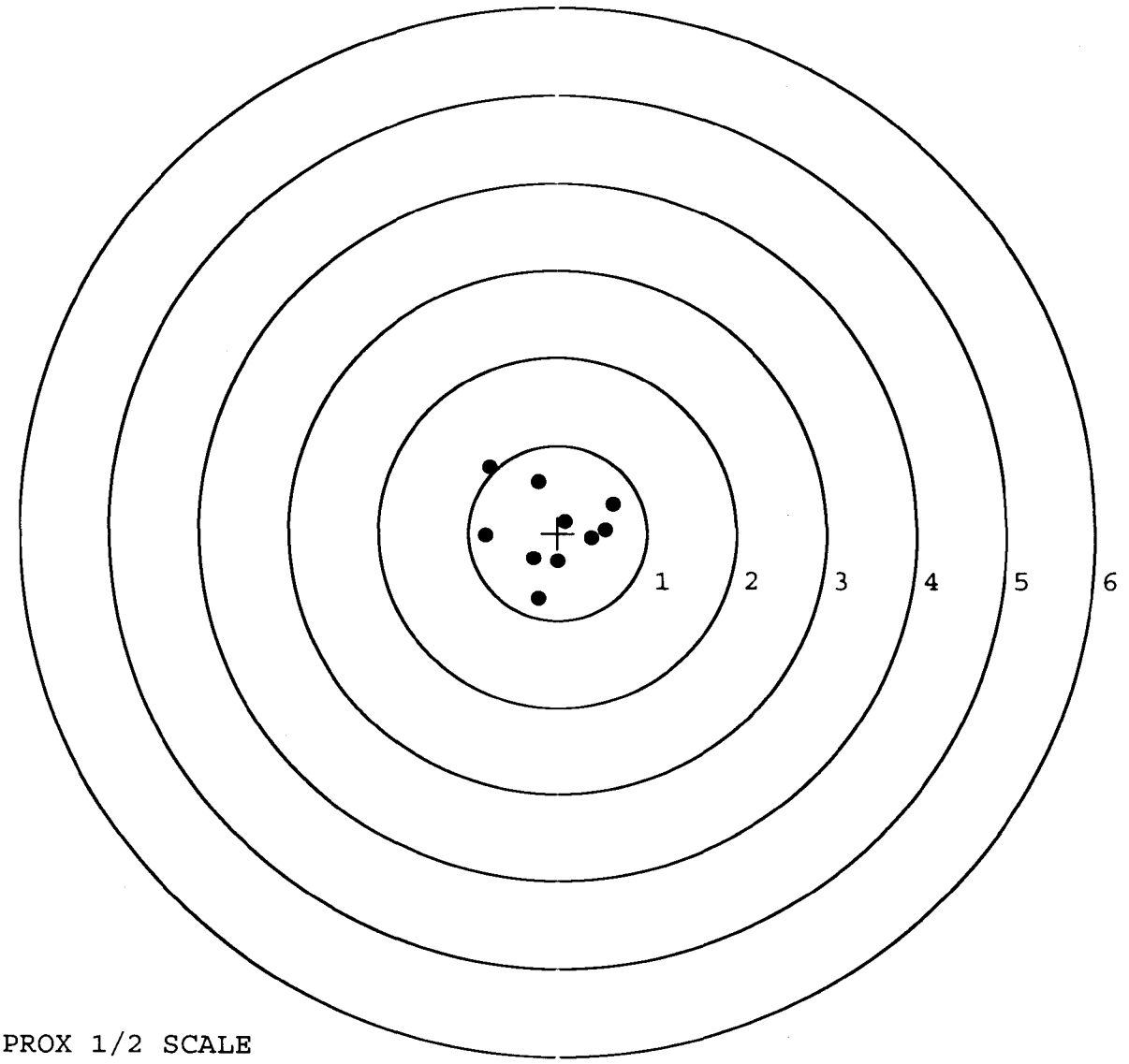


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6349074.__0
TARGET NUMBER: 2
FILE DATE: 09/29/2009
FILE TIME: 10:13

X CENTROID:	-0.064
Y CENTROID:	0.038
POA TO CENTROID:	0.074
HORZ SPREAD:	1.445
VERT SPREAD:	1.509
GROUP SPREAD:	1.605
MIN RADIUS:	0.176
MAX RADIUS:	1.000
MEAN RADIUS:	0.588
# IN 1 IN DIAMETER:	4
# IN 2 IN DIAMETER:	10
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	-0.765	0.750
2:	-0.210	0.583
3:	-0.812	-0.030
4:	-0.218	-0.759
5:	-0.271	-0.298
6:	0.004	-0.327
7:	0.084	0.134
8:	0.385	-0.058
9:	0.534	0.045
10:	0.633	0.335

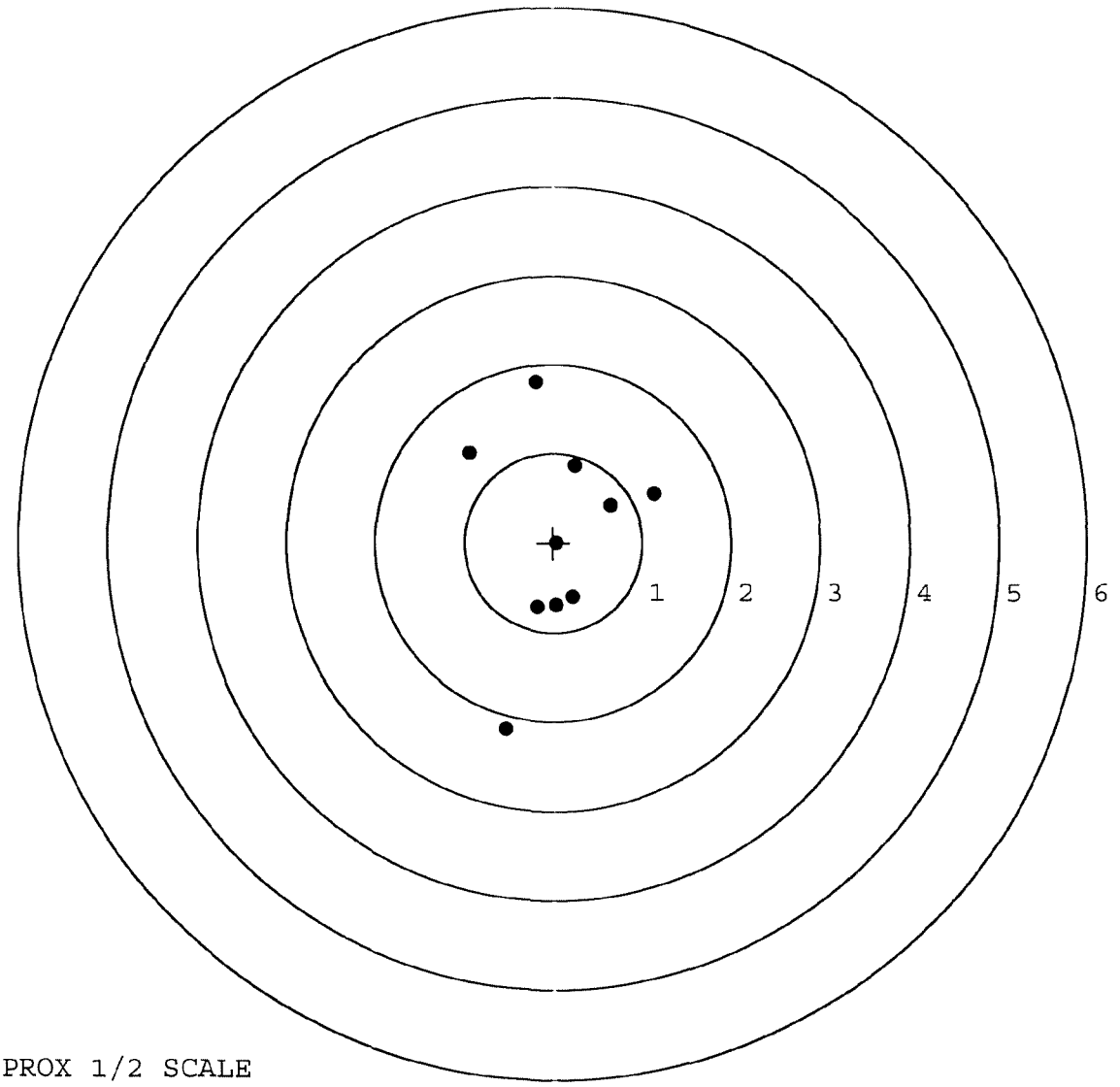


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6349074.__0
TARGET NUMBER: 3
FILE DATE: 09/29/2009
FILE TIME: 10:13

X CENTROID:	0.043
Y CENTROID:	0.055
POA TO CENTROID:	0.070
HORZ SPREAD:	2.082
VERT SPREAD:	3.896
GROUP SPREAD:	3.911
MIN RADIUS:	0.051
MAX RADIUS:	2.225
MEAN RADIUS:	1.038
# IN 1 IN DIAMETER:	1
# IN 2 IN DIAMETER:	6
# in 3 IN DIAMETER:	8

POINT#	X	Y
1:	-0.199	1.805
2:	-0.946	1.004
3:	0.245	0.866
4:	1.136	0.550
5:	0.641	0.421
6:	0.035	0.005
7:	0.219	-0.600
8:	0.027	-0.694
9:	-0.188	-0.714
10:	-0.544	-2.091



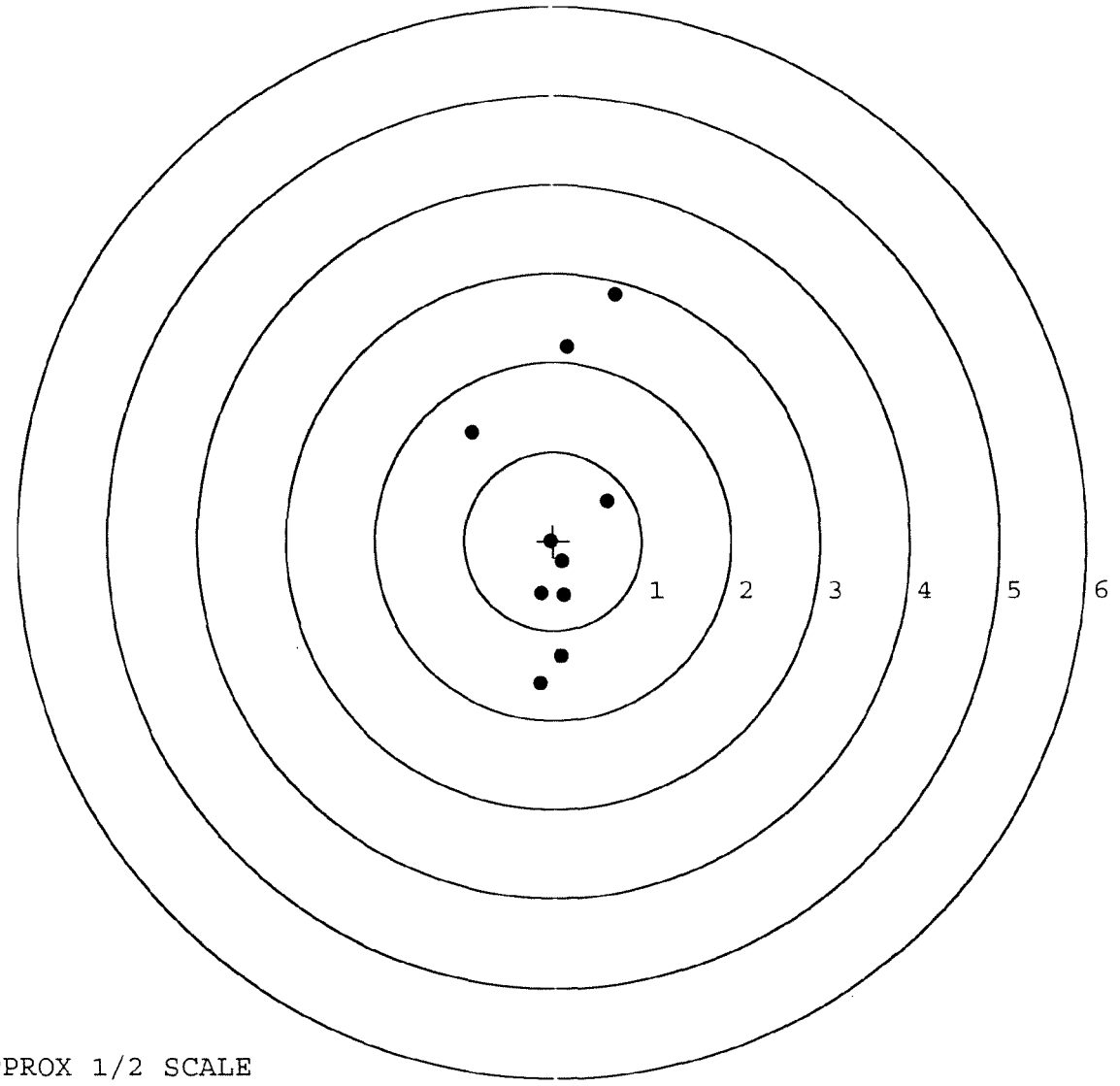
TARGET APPROX 1/2 SCALE

BARBER - M24 0107242

SERIAL NUMBER: C6349074.__0
TARGET NUMBER: 4
FILE DATE: 09/29/2009
FILE TIME: 10:13

X CENTROID:	0.055
Y CENTROID:	0.232
POA TO CENTROID:	0.238
HORZ SPREAD:	1.611
VERT SPREAD:	4.349
GROUP SPREAD:	4.434
MIN RADIUS:	0.243
MAX RADIUS:	2.614
MEAN RADIUS:	1.227
# IN 1 IN DIAMETER:	2
# IN 2 IN DIAMETER:	5
# in 3 IN DIAMETER:	6

POINT#	X	Y
1:	0.710	2.762
2:	0.167	2.171
3:	-0.901	1.226
4:	0.607	0.455
5:	-0.155	-1.587
6:	0.083	-1.291
7:	0.115	-0.607
8:	-0.145	-0.587
9:	0.097	-0.230
10:	-0.032	0.005

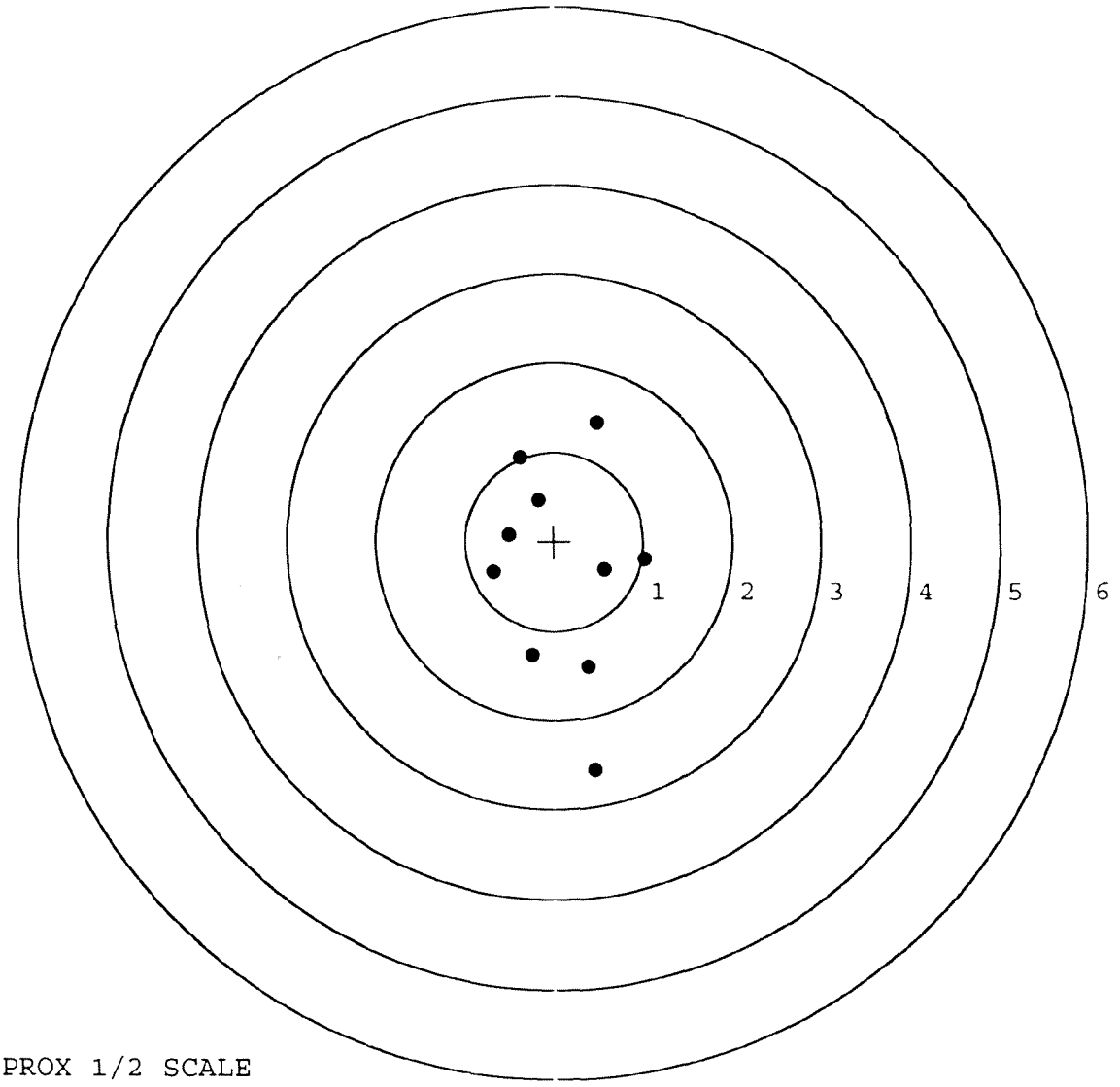


TARGET APPROX 1/2 SCALE

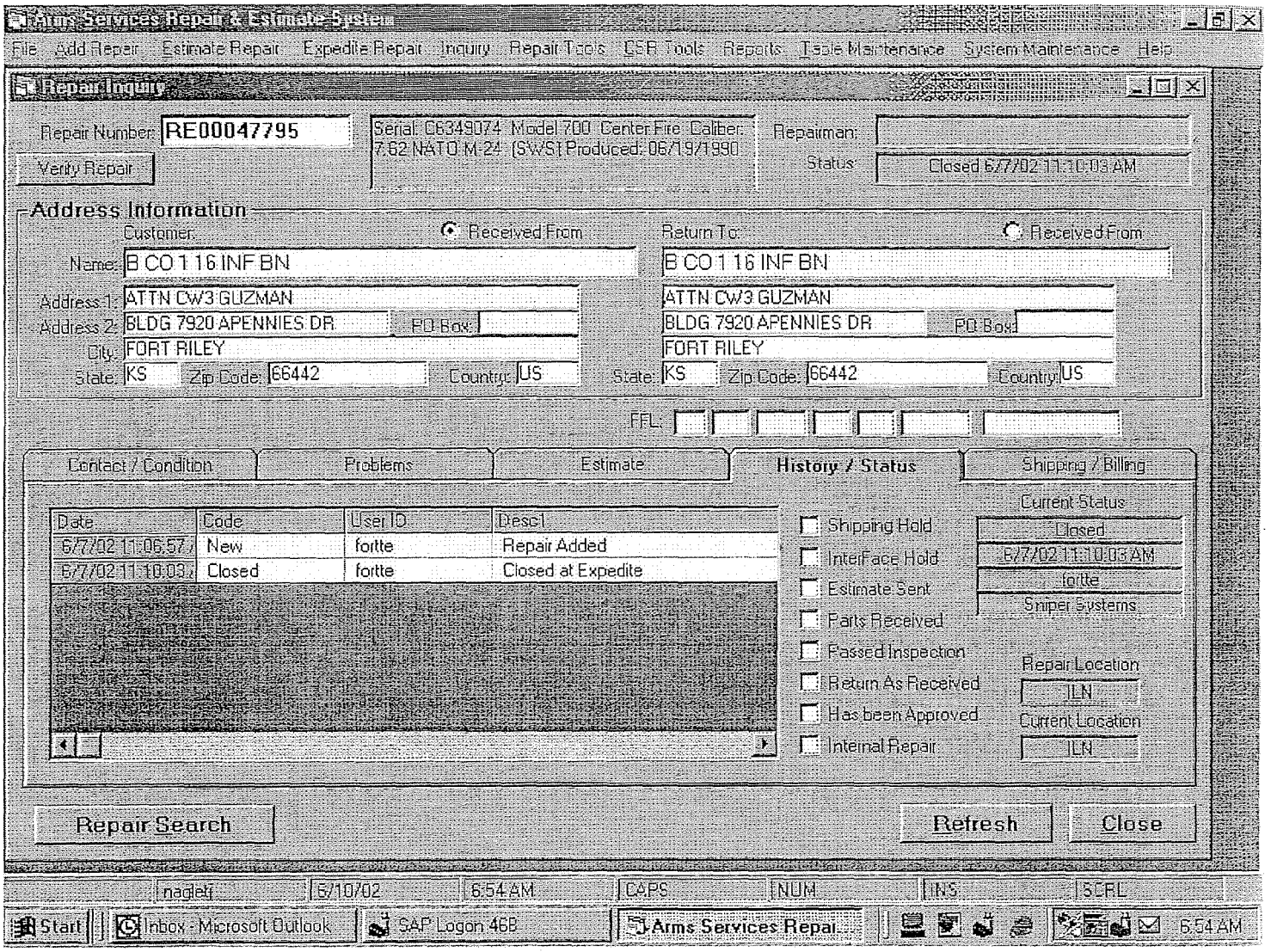
SERIAL NUMBER: C6349074.__0
TARGET NUMBER: 5
FILE DATE: 09/29/2009
FILE TIME: 10:13

X CENTROID:	0.091
Y CENTROID:	-0.325
POA TO CENTROID:	0.337
HORZ SPREAD:	1.698
VERT SPREAD:	3.896
GROUP SPREAD:	3.896
MIN RADIUS:	0.473
MAX RADIUS:	2.268
MEAN RADIUS:	1.117
# IN 1 IN DIAMETER:	1
# IN 2 IN DIAMETER:	5
# in 3 IN DIAMETER:	8

POINT#	X	Y
1:	0.487	1.334
2:	-0.384	0.943
3:	-0.180	0.461
4:	-0.509	0.079
5:	-0.683	-0.335
6:	0.564	-0.310
7:	1.015	-0.198
8:	0.383	-1.394
9:	-0.248	-1.267
10:	0.466	-2.562



TARGET APPROX 1/2 SCALE



Serial Number: C6349074

Model: 700

RE00047795

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

SERIAL NO. _____

DATE 5-22-02

TESTER TRW

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.39	2.53		2.61	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPTABLE LESS THAN 2#
PULL #2	2.43	2.46		2.53	
PULL #3	2.56	2.46		2.62	
PULL #4	2.59	2.53		2.63	
PULL #5	2.21	2.45		2.59	
TOTAL	12.18	12.43		12.98	
AVG.	2.43	2.48		2.59	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.26	3.21		
PULL #2	3.21	3.00		
PULL #3	3.04	3.09		
PULL #4	3.12	3.12		
PULL #5	3.13	3.09		
TOTAL	15.76	15.51		
AVG.	3.15	3.10		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURAC
PULL #1	4.13	4.11		4.13
PULL #2	4.18	4.14		4.26
PULL #3	4.35	4.13		4.30
PULL #4	4.15	4.10		4.27
PULL #5	4.15	4.15		4.39
TOTAL	20.96	20.63		21.35
AVG.	4.19	4.12		4.27

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFOMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6349074.__0
FILE DATE AND TIME: 06/29/2002 11:36

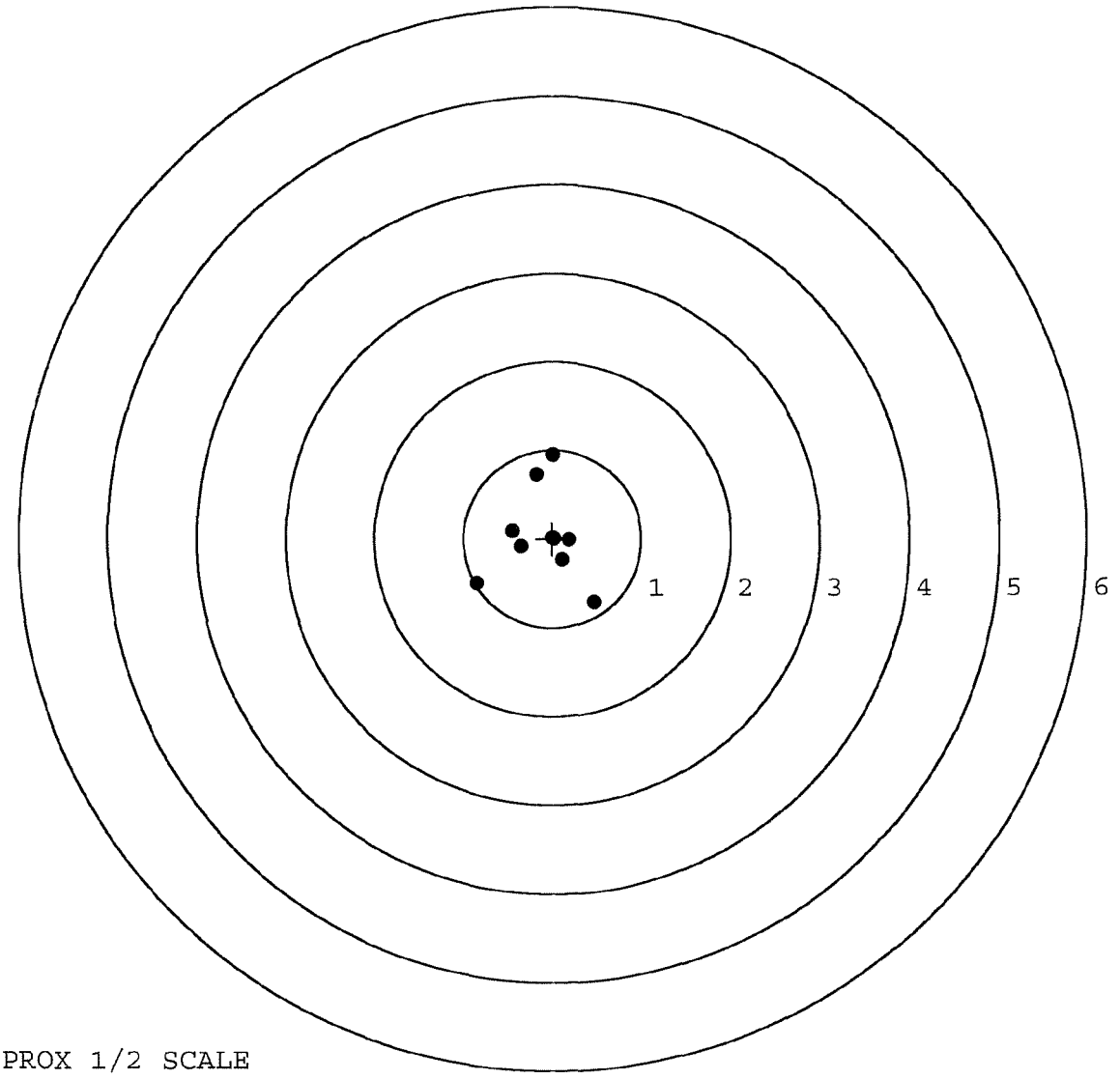
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.041
The Average Y Centroid of the Five Target Set:	0.089
The Average Point of Impact of the Five Target Set:	0.098
The Average Mean Radius of the Five Target Set:	0.502
The Distance from POA to Centroid Target #1:	0.105
The Distance from Centroid Target #2 to Centroid Target #1:	0.162
The Distance from Centroid Target #3 to Centroid Target #1:	0.180
The Distance from Centroid Target #4 to Centroid Target #1:	0.370
The Distance from Centroid Target #5 to Centroid Target #1:	0.041

SERIAL NUMBER: C6349074.__0
TARGET NUMBER: 1
FILE DATE: 06/29/2002
FILE TIME: 11:36

X CENTROID:	-0.103
Y CENTROID:	0.021
POA TO CENTROID:	0.105
HORZ SPREAD:	1.322
VERT SPREAD:	1.662
GROUP SPREAD:	1.726
MIN RADIUS:	0.101
MAX RADIUS:	0.937
MEAN RADIUS:	0.498
# IN 1 IN DIAMETER:	6
# IN 2 IN DIAMETER:	10
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	-0.002	0.011
2:	0.025	-0.001
3:	0.192	-0.016
4:	0.113	-0.243
5:	0.473	-0.718
6:	-0.849	-0.496
7:	-0.448	0.093
8:	-0.355	-0.089
9:	-0.184	0.725
10:	0.007	0.944

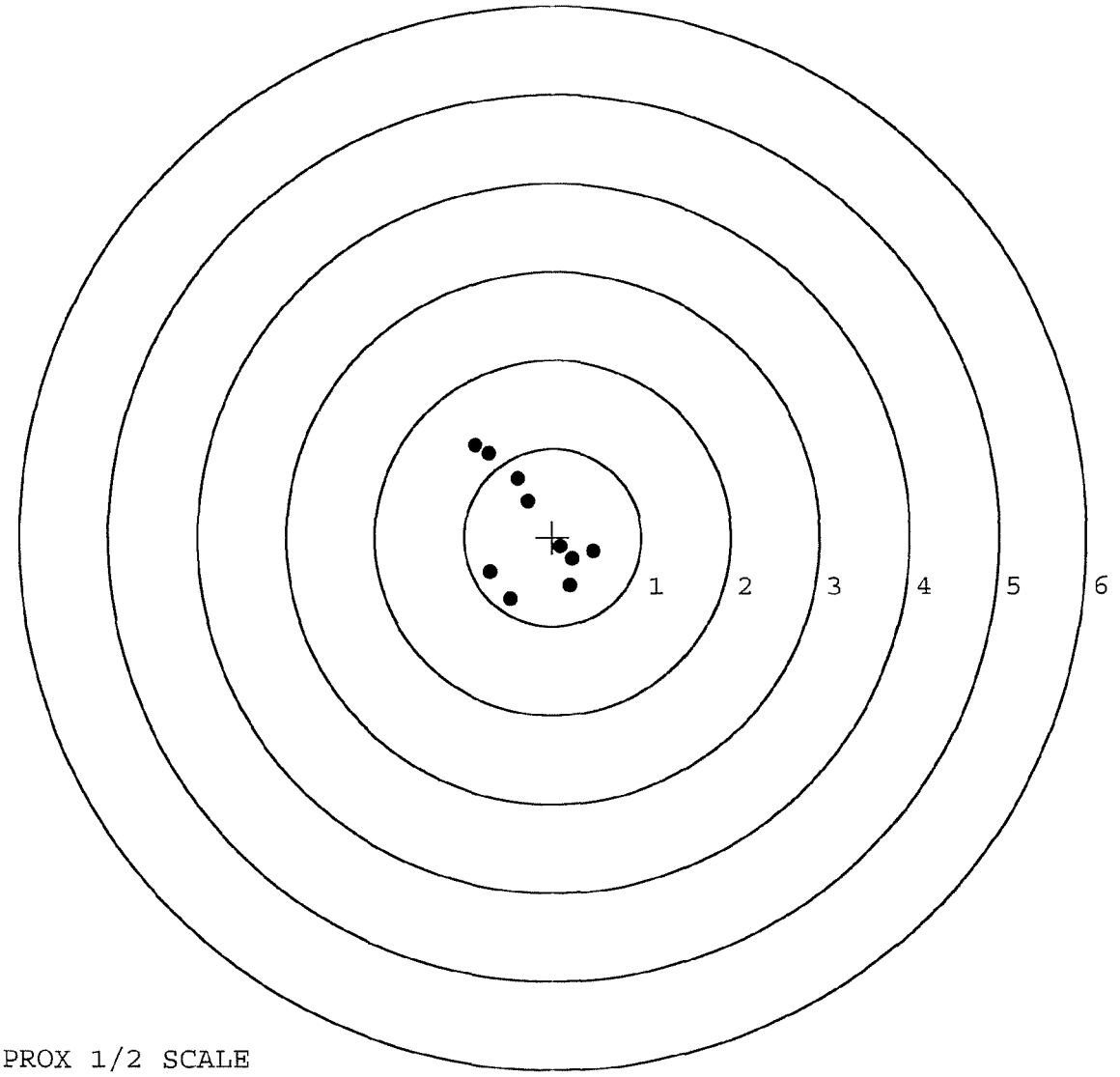


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6349074.__0
TARGET NUMBER: 2
FILE DATE: 06/29/2002
FILE TIME: 11:36

X CENTROID:	-0.248
Y CENTROID:	0.091
POA TO CENTROID:	0.265
HORZ SPREAD:	1.329
VERT SPREAD:	1.740
GROUP SPREAD:	1.917
MIN RADIUS:	0.323
MAX RADIUS:	1.136
MEAN RADIUS:	0.702
# IN 1 IN DIAMETER:	2
# IN 2 IN DIAMETER:	9
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	-0.867	1.044
2:	-0.718	0.947
3:	-0.395	0.661
4:	-0.285	0.412
5:	-0.705	-0.390
6:	-0.485	-0.696
7:	0.088	-0.108
8:	0.462	-0.159
9:	0.197	-0.551
10:	0.224	-0.251

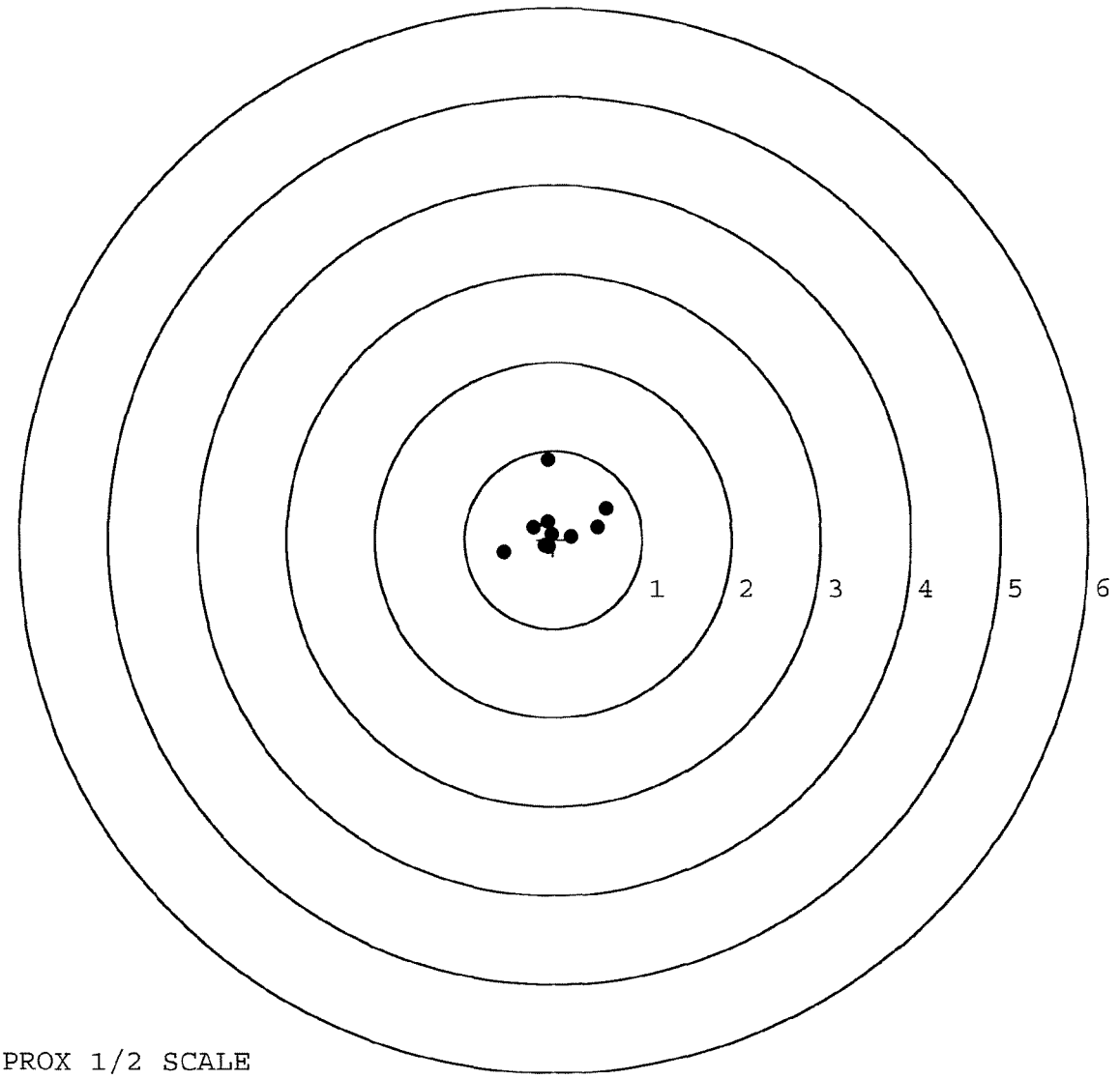


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6349074.__0
TARGET NUMBER: 3
FILE DATE: 06/29/2002
FILE TIME: 11:36

X CENTROID:	0.021
Y CENTROID:	0.151
POA TO CENTROID:	0.152
HORZ SPREAD:	1.148
VERT SPREAD:	1.040
GROUP SPREAD:	1.151
MIN RADIUS:	0.098
MAX RADIUS:	0.748
MEAN RADIUS:	0.365
# IN 1 IN DIAMETER:	7
# IN 2 IN DIAMETER:	10
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	-0.064	0.894
2:	-0.556	-0.146
3:	0.592	0.350
4:	0.502	0.142
5:	-0.222	0.140
6:	-0.064	0.200
7:	-0.100	-0.070
8:	0.201	0.029
9:	-0.023	0.057
10:	-0.055	-0.086



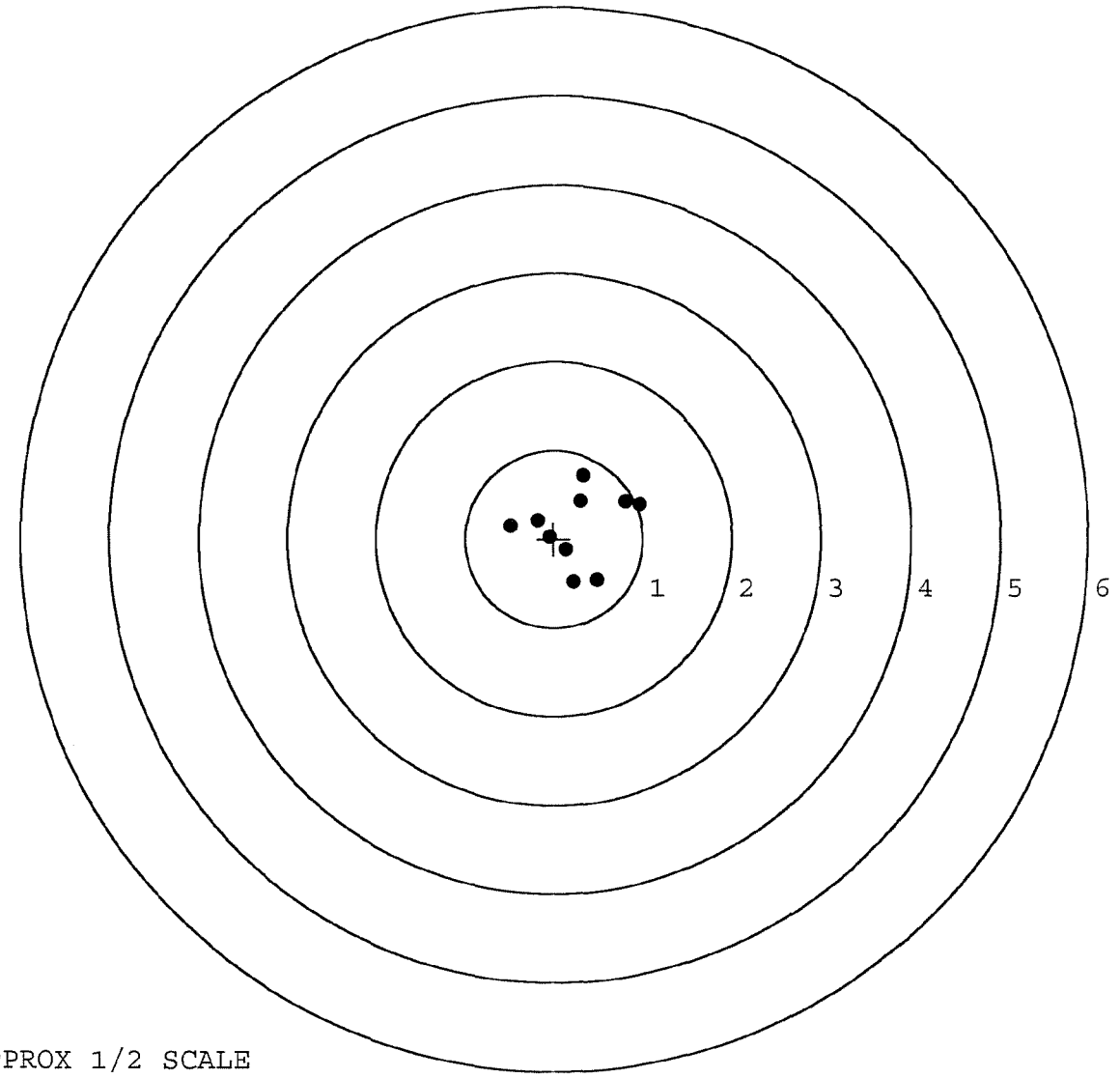
TARGET APPROX 1/2 SCALE

BARBER - M24 0107250

SERIAL NUMBER: C6349074.__0
TARGET NUMBER: 4
FILE DATE: 06/29/2002
FILE TIME: 11:36

X CENTROID:	0.251
Y CENTROID:	0.128
POA TO CENTROID:	0.282
HORZ SPREAD:	1.454
VERT SPREAD:	1.215
GROUP SPREAD:	1.474
MIN RADIUS:	0.272
MAX RADIUS:	0.761
MEAN RADIUS:	0.533
# IN 1 IN DIAMETER:	4
# IN 2 IN DIAMETER:	10
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	0.331	0.725
2:	0.295	0.427
3:	0.803	0.427
4:	0.487	-0.462
5:	0.222	-0.490
6:	0.139	-0.120
7:	-0.051	0.021
8:	-0.189	0.209
9:	-0.490	0.151
10:	0.964	0.395

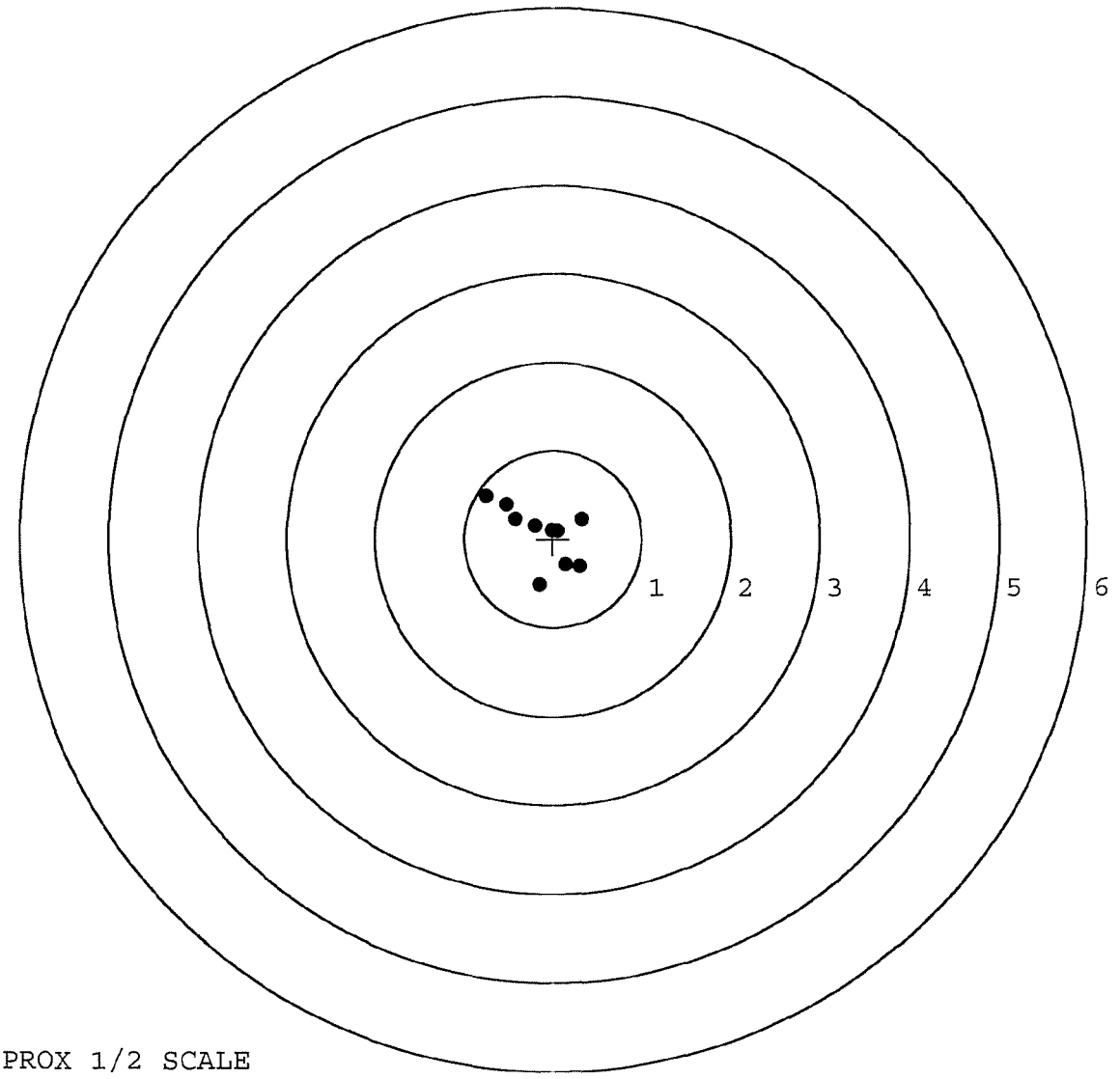


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6349074.__0
TARGET NUMBER: 5
FILE DATE: 06/29/2002
FILE TIME: 11:36

X CENTROID:	-0.127
Y CENTROID:	0.054
POA TO CENTROID:	0.138
HORZ SPREAD:	1.079
VERT SPREAD:	1.008
GROUP SPREAD:	1.328
MIN RADIUS:	0.121
MAX RADIUS:	0.765
MEAN RADIUS:	0.414
# IN 1 IN DIAMETER:	6
# IN 2 IN DIAMETER:	10
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	0.321	0.228
2:	-0.014	0.098
3:	-0.429	0.229
4:	-0.758	0.487
5:	-0.532	0.395
6:	-0.156	-0.521
7:	0.143	-0.298
8:	0.300	-0.316
9:	0.057	0.091
10:	-0.204	0.150



TARGET APPROX 1/2 SCALE

620P

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

R & E NUMBER 47795

SERIAL NUMBER C6349074

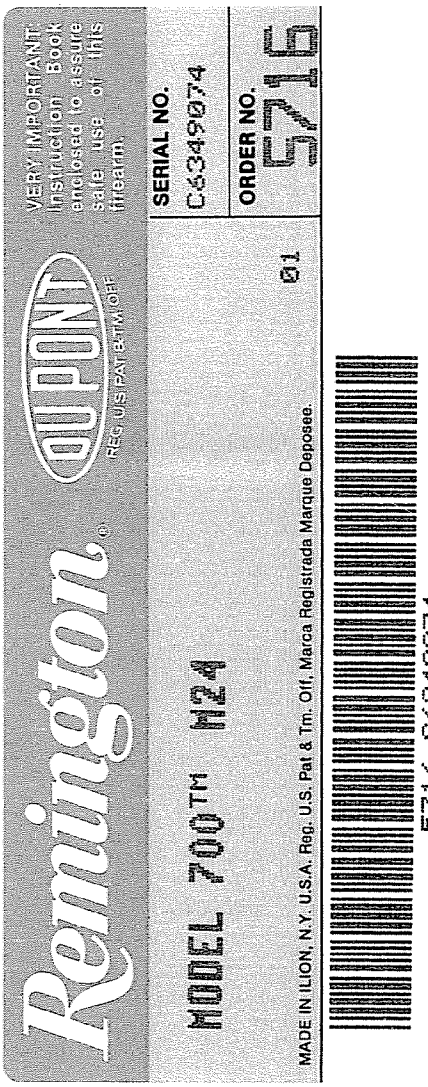
LOG-IN DATE 6/7/02

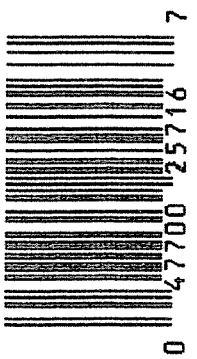
INSPECT AND VERIFY:			
OPERATION #	OPERATION NAME	DATE	INITIAL
550	DIS-ASSEMBLE GUN	6/14/02	RL
560 A	RE-BARREL AT CUSTOM SHOP	6/17/02	BWT
B	DRILL AND TAP	6/17/02	BWT
C	POLISH		
575	ASSEMBLE	6/17/02	RL
600	PROOF	6/17/02	RW
605	CHECK HEADSPACE	6/17/02	RW
610	DIS-ASSEMBLE GUN	6/17/02	RW
612	MAGNAFLUX DRD		
615	ROLLMARK CALIBER	6/17/02	RW
618	ROTO-BLAST	6/19/02	KO
620	APPLY COATINGS	6-24	JA
625 A	FINAL ASSEMBLY	6/27/02	RL
B	TRIGGER PULL TEST		
C	SAFETY "ON" FORCE		
D	SAFETY "OFF" FORCE		
E	FIRING PIN INDENT		
640	TARGET	6-28-02	TRW
655	FINAL INSPECT		
660	PACK	6-28-02	DA

MAGNA FLUX INSPECTED JUN 18 2002 OPERATOR

QAR INSPECTION DATE

SHIP DATE


Remington
DUPONT
REG. U.S. PAT. OFF.
VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.
SERIAL NO.
C6349074
ORDER NO.
5716
MODEL 700TM M24
01
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.
5716 C6349074


UPC
0 47700 25716 7

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6349074

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	1 30	90	RW
600	Proof	1 30	90	
607	Check Headspace	1 30	90	
610	Dis-assemble Gun	1 30	90	RW
612	Magnaflux Barrel Action	2-5-90		KeR
	Magnaflux Bolt	2-5-90		
615	Rollmark Caliber	2-5-90		GB
617	Drill and Tap Sight Holes	2-5-90		WB
618	Polish Barrel RB	2-5-90		WB
620	Apply Coatings (Barrel Action)		2-17-90	TJH
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		3/19/90	WB
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		3/19/90	WB
	C) Inspect Ejector Hole for Chamfer		4/18/90	RW
	D) Oil Firing Pin Ass'y		4/18/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		4/19/90	DH

BARBER - M24 0107255

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4.5	4.5	4.5			4/20/90	JCl
	G) Safety Off Force	3	3	3			4/20/90	JCl
	H) Trigger Pull Test & Retainability						4/19/90	JCl
	I) Firing Pin Indent	.021	.022	.022			4/20/90	JCl
	J) Assemble Stock						4/20/90	Rw
	K) Assemble Swivel Studs						5/8/90	WB
	L) Attach Front and Rear Sight Assemblies						4/20/90	Rw
	M) Iron Sight Alignment						4/20/90	Rw
	N) Detach Front & Rear Sights & place in numbered container						4/20/90	Rw
	O) Attach Scope to Rifle						4/20/90	WB
	P) Detach & Attach Scope 20 Times						4/20/90	WB
640	Gallery Target & Test						4-23-90	AC
	A) Time						4-23-90	AC
	B) Malfunctions						4-23-90	AC
	C) Pierced Primers						4-23-90	AC
	D) Optical Clearity of Scope						4-23-90	AC
645	Inspect for Live Ammo						4-23-90	AC
655	Final Inspection A) Headspace						5/8/90	WB
	B) Trigger Pull	2.52	2.47	2.52	2.41	2.37	5/7/90	WB
	C) Function						5/8/90	WB
660	Pack						6-19-90	DH

SWS TRIGGER PULL TEST

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

SERIAL NO C6349074

DATE 4/19/90

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.54	2.43	2.50	2.52	MIN. SETTING,
PULL #2	2.55	2.41	2.39	2.47	NO AVG. OF 5
PULL #3	2.44	2.30	2.32	2.52	READINGS ACCEPT-
PULL #4	2.35	2.45	2.32	2.41	ABLE LESS THAN 2#
PULL #5	2.33	2.51	2.28	2.37	
TOTAL	12.21	12.10	11.81		
AVG.	2.442	2.42	2.362		

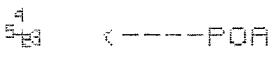
	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.36	3.25		
PULL #2	3.27	3.20		
PULL #3	3.22	3.07		
PULL #4	3.20	3.23		
PULL #5	3.22	3.25		
TOTAL	16.27	15.90		
AVG.	3.254	3.18		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.41	4.18		4.13
PULL #2	4.25	4.19		4.50
PULL #3	4.25	4.11		4.49
PULL #4	4.18	4.13		4.50
PULL #5	4.24	4.20		4.48
TOTAL	21.33	20.81		22.10
AVG.	4.266	4.162		4.42

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6349074
23 Apr 1990

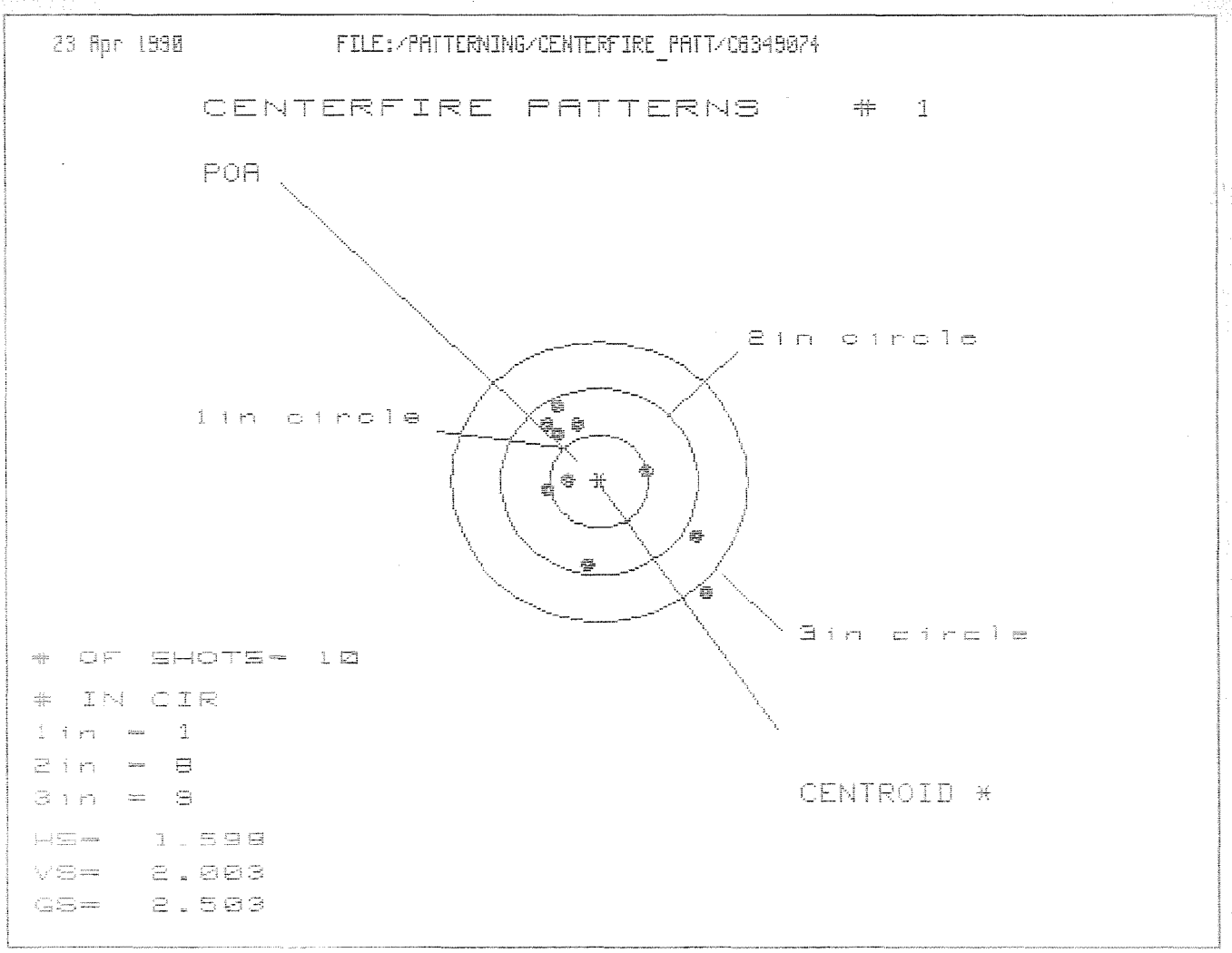
CENTROIDAL DISTANCES

0	TO	1	.0272947
1	TO	2	.0799812
1	TO	3	.258008
1	TO	4	.426433
1	TO	5	.254348



THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .029
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0798
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0849061

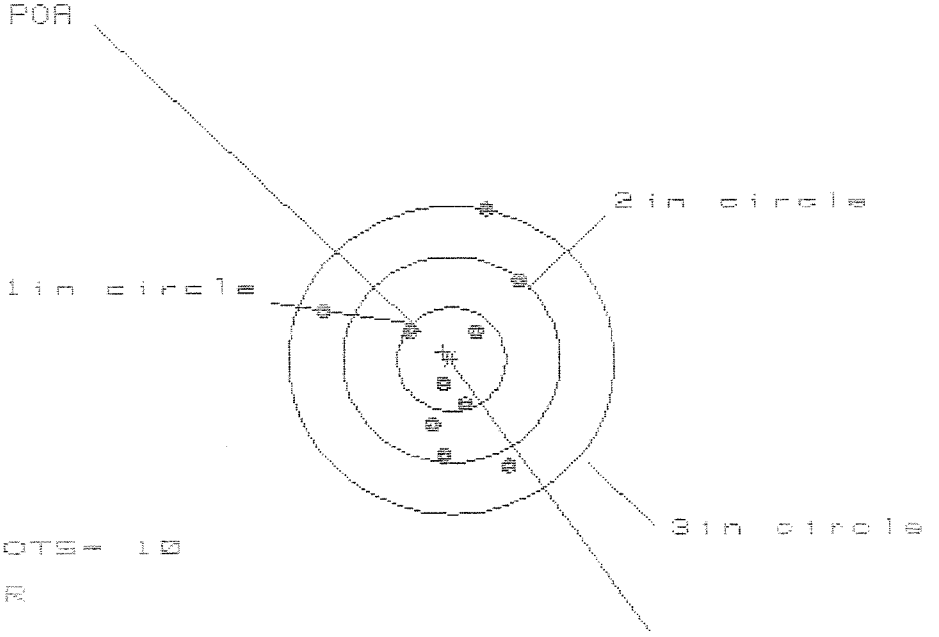
THE AMR FOR THIS RIFLE IS: .8282



PATTERN #	:	[redacted]		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.049	1.114	.755
MINIMUM X	:	-.549	-.433	-.293
MAXIMUM Y	:	.844	.716	.623
MINIMUM Y	:	-1.159	-.995	-1.089
CENTROID X	:	.024	-.092	-.232
CENTROID Y	:	-.013	.115	.208
POA TO CENTROID in.	:	.028	.148	.312
MIN RADIUS	:	.369	.257	.195
MEAN RADIUS	:	.812	.680	.550
MAX RADIUS	:	1.563	1.340	1.101
HORIZONTAL SPREAD	:	1.598	1.547	1.048
VERTICAL SPREAD	:	2.003	1.711	1.711
EXTREME SPREAD	:	2.503	2.058	1.749
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	

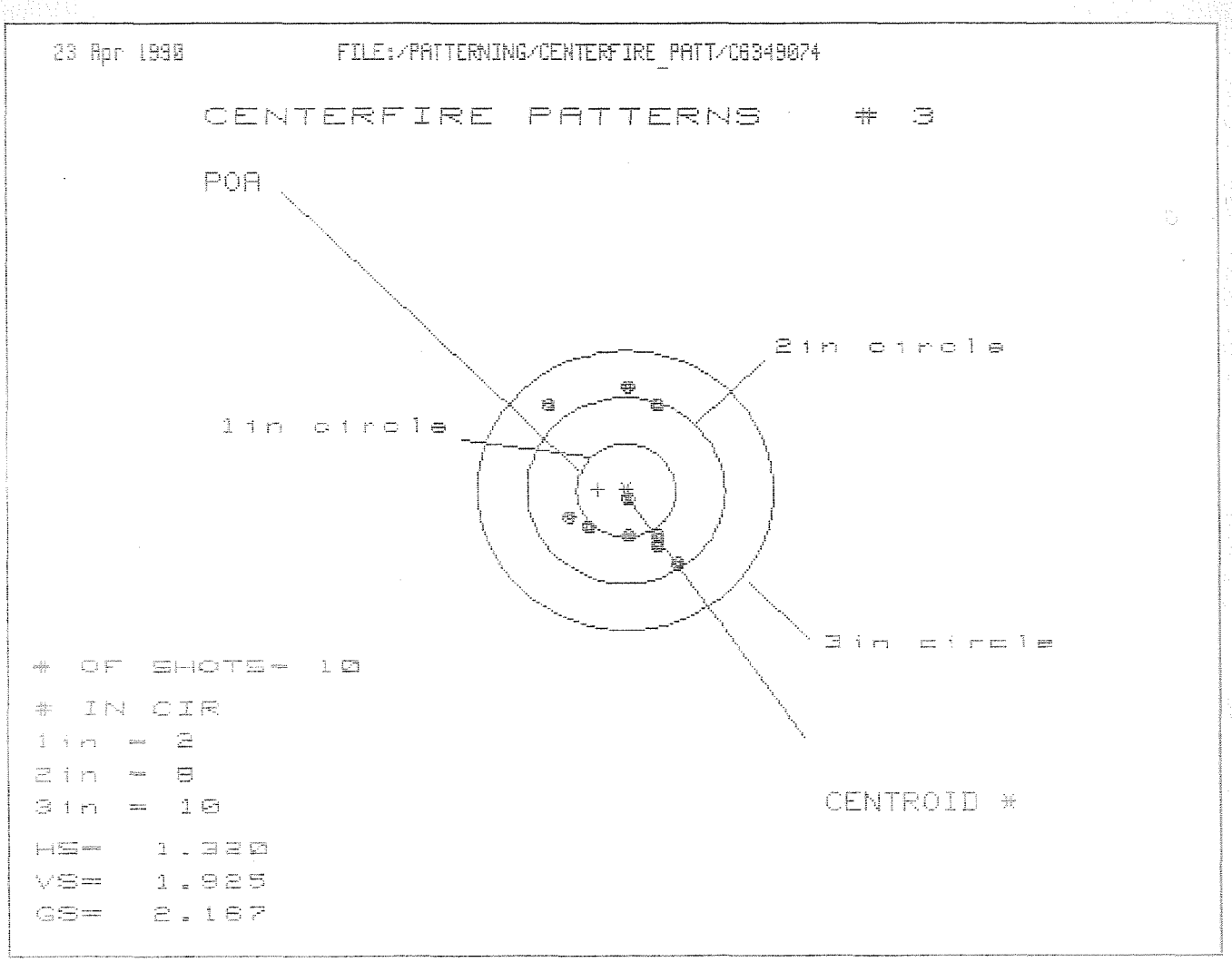
23 Apr 1998 FILE:/PATTERNING/CENTERFIRE_PATT/C0349074

CENTERFIRE PATTERNS # 2



OF SHOTS= 10
IN CIR
1 in = 4
2 in = 7
3 in = 10
HS= 1.775
VS= 2.468
GS= 2.481

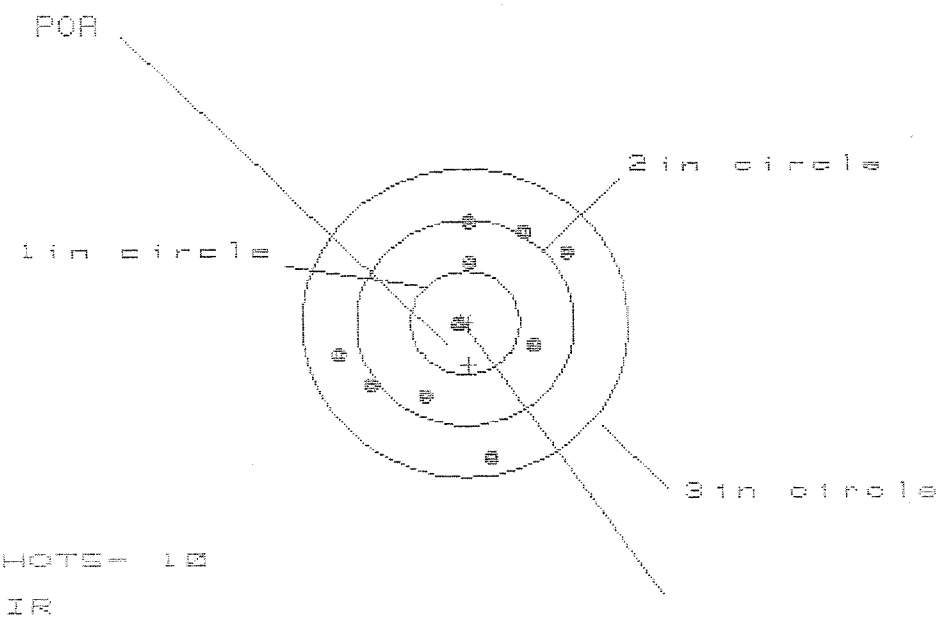
PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.617	.651	.510
MINIMUM X	:	-1.158	-1.124	-.443
MAXIMUM Y	:	1.453	.920	1.001
MINIMUM Y	:	-1.015	-.854	-.773
CENTROID X	:	.078	.044	.185
CENTROID Y	:	-.072	-.233	-.314
POA TO CENTROID in.	:	.106	.237	.364
MIN RADIUS	:	.208	.049	.181
MEAN RADIUS	:	.790	.677	.598
MAX RADIUS	:	1.484	1.297	1.123
HORIZONTAL SPREAD	:	1.775	1.775	.953
VERTICAL SPREAD	:	2.468	1.774	1.774
EXTREME SPREAD	:	2.481	2.277	1.829
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	



PATTERN #	:	[redacted]		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.564	.480	.477
MINIMUM X	:	-.756	-.665	-.668
MAXIMUM Y	:	1.154	1.259	1.147
MINIMUM Y	:	-.771	-.666	-.509
CENTROID X	:	.282	.366	.369
CENTROID Y	:	-.015	-.120	-.277
POA TO CENTROID in.	:	.282	.385	.462
MIN RADIUS	:	.042	.100	.236
MEAN RADIUS	:	.717	.637	.520
MAX RADIUS	:	1.212	1.259	1.166
HORIZONTAL SPREAD	:	1.320	1.145	1.145
VERTICAL SPREAD	:	1.925	1.925	1.655
EXTREME SPREAD	:	2.167	1.991	1.676
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	

23 Apr 1998 FILE:/PATTERNING/CENTERFIRE_PATT/C0345074

CENTERFIRE PATTERNS # 4



OF SHOTS= 10

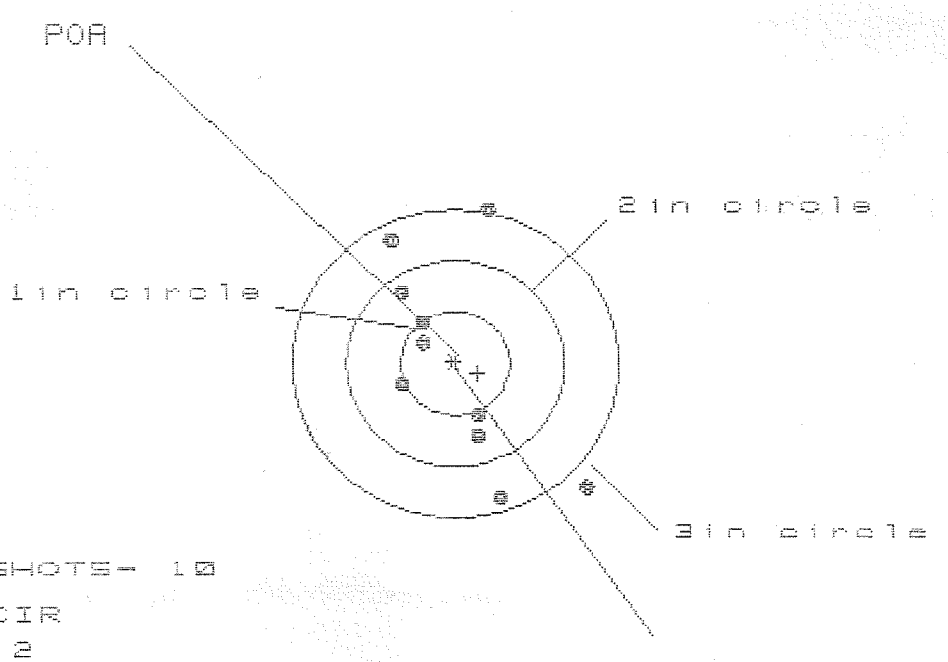
# IN CIR	
1in	= 1
2in	= 4
3in	= 10

HS= 2.103
VS= 2.320
GS= 2.329

PATTERN #	:	[redacted]		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.946	.972	.831
MINIMUM X	:	-1.157	-1.131	-.984
MAXIMUM Y	:	1.020	.876	.822
MINIMUM Y	:	-1.300	-.833	-.887
CENTROID X	:	-.030	-.056	.085
CENTROID Y	:	.410	.554	.608
POA TO CENTROID in.	:	.411	.557	.614
MIN RADIUS	:	.051	.188	.280
MEAN RADIUS	:	.886	.836	.773
MAX RADIUS	:	1.320	1.210	1.296
HORIZONTAL SPREAD	:	2.103	2.103	1.815
VERTICAL SPREAD	:	2.320	1.709	1.709
EXTREME SPREAD	:	2.329	2.301	2.229
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		10	

23 Apr 1998 FILE:/PATTERNING/CENTERFIRE_PATT/C6345074

CENTERFIRE PATTERNS # 5



\# OF SHOTS= 10

\# IN CIR
1in = 2
2in = 6
3in = 8

HS= 1.837
VS= 2.791
GS= 2.971

PATTERN #	:	[redacted]		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.213	.503	.552
MINIMUM X	:	-.624	-.489	-.440
MAXIMUM Y	:	1.522	1.392	1.202
MINIMUM Y	:	-1.269	-1.399	-1.225
CENTROID X	:	-.209	-.344	-.393
CENTROID Y	:	.098	.228	.054
POA TO CENTROID in.	:	.231	.413	.397
MIN RADIUS	:	.361	.179	.272
MEAN RADIUS	:	.936	.811	.725
MAX RADIUS	:	1.690	1.487	1.344
HORIZONTAL SPREAD	:	1.837	.992	.992
VERTICAL SPREAD	:	2.791	2.791	2.427
EXTREME SPREAD	:	2.971	2.799	2.622

NUMBER IN ONE INCH CIRCLE = 2
NUMBER IN TWO INCH CIRCLE = 6
NUMBER IN THREE INCH CIRCLE = 8