

/ G673 8629
Replaces

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: RE00148640

Serial: E6703406 Model M24 SWS Center Fire
Caliber: 7.62 NATO Produced: 10/29/2001

Repairman:

Verify Repair

Status:

Closed 8/5/2008 12:42:37 PM

Address Information

Customer: ☐ Received From Return To: ☐ Received From

Name: CW3 A. J. AIYETORO CW3 A. J. AIYETORO

Address 1: BLDG 502 LANGFORD LAKE ROAD BLDG 502 LANGFORD LAKE ROAD

Address 2: PO Box: PO Box:

City: FORT IRWIN FORT IRWIN

State: CA Zip Code: 92310 Country: US State: CA Zip Code: 92310 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
A010	Hard Case	1
A017	Scope Base	1
A026	Scope	1
A045	Bi Pod	1
A057	Frt Sgt Base	1

Repair Search

Refresh

Close

naglatj

8/7/2008

2:02 PM

CAPS

NUM

INS

SCRL

H start

4 Mi...

Arms...

Part 5...

4 Mi...

Staple...

3 SA...

2:02 PM

Serial
Number:

E6703406

Model: M24 SWS



RE00148640

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6738629.___0
FILE DATE AND TIME: 09/10/2008 14:19

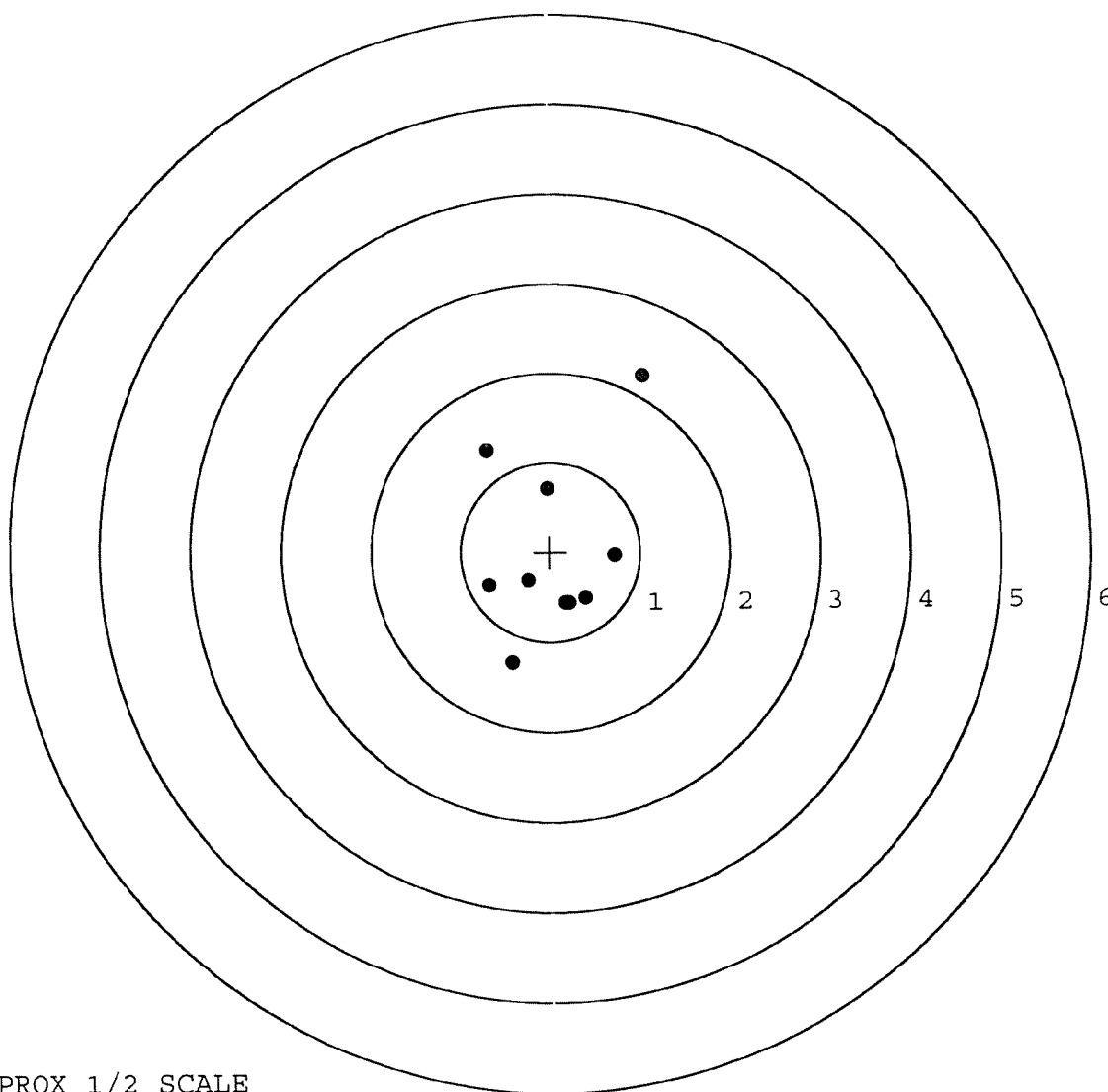
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.140
The Average Y Centroid of the Five Target Set:	0.080
The Average Point of Impact of the Five Target Set:	0.161
The Average Mean Radius of the Five Target Set:	0.851
The Distance from POA to Centroid Target #1:	0.048
The Distance from Centroid Target #2 to Centroid Target #1:	0.266
The Distance from Centroid Target #3 to Centroid Target #1:	0.293
The Distance from Centroid Target #4 to Centroid Target #1:	0.293
The Distance from Centroid Target #5 to Centroid Target #1:	0.101

SERIAL NUMBER: G6738629. __0
TARGET NUMBER: 1
FILE DATE: 09/10/2008
FILE TIME: 14:19

X CENTROID: 0.043
Y CENTROID: 0.022
POA TO CENTROID: 0.048
HORZ SPREAD: 1.740
VERT SPREAD: 3.190
GROUP SPREAD: 3.511
MIN RADIUS: 0.448
MAX RADIUS: 2.180
MEAN RADIUS: 0.934
IN 1 IN DIAMETER: 1
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 9

POINT#	X	Y
1:	-0.682	-0.370
2:	-0.251	-0.316
3:	-0.432	-1.227
4:	0.391	-0.510
5:	0.174	-0.560
6:	0.719	-0.042
7:	0.211	-0.560
8:	-0.029	0.708
9:	-0.705	1.136
10:	1.035	1.963



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6738629. __0

TARGET NUMBER: 2

FILE DATE: 09/10/2008

FILE TIME: 14:19

POINT#	X	Y
--------	---	---

1:	-0.955	-0.134
----	--------	--------

2:	-0.355	-0.515
----	--------	--------

3:	0.172	0.276
----	-------	-------

4:	0.505	0.292
----	-------	-------

5:	0.020	0.896
----	-------	-------

6:	0.604	-0.207
----	-------	--------

7:	0.567	-0.399
----	-------	--------

8:	0.461	-0.646
----	-------	--------

9:	0.761	-0.477
----	-------	--------

10:	0.879	-0.310
-----	-------	--------

X CENTROID: 0.266

Y CENTROID: -0.122

POA TO CENTROID: 0.293

HORZ SPREAD: 1.834

VERT SPREAD: 1.542

GROUP SPREAD: 1.842

MIN RADIUS: 0.349

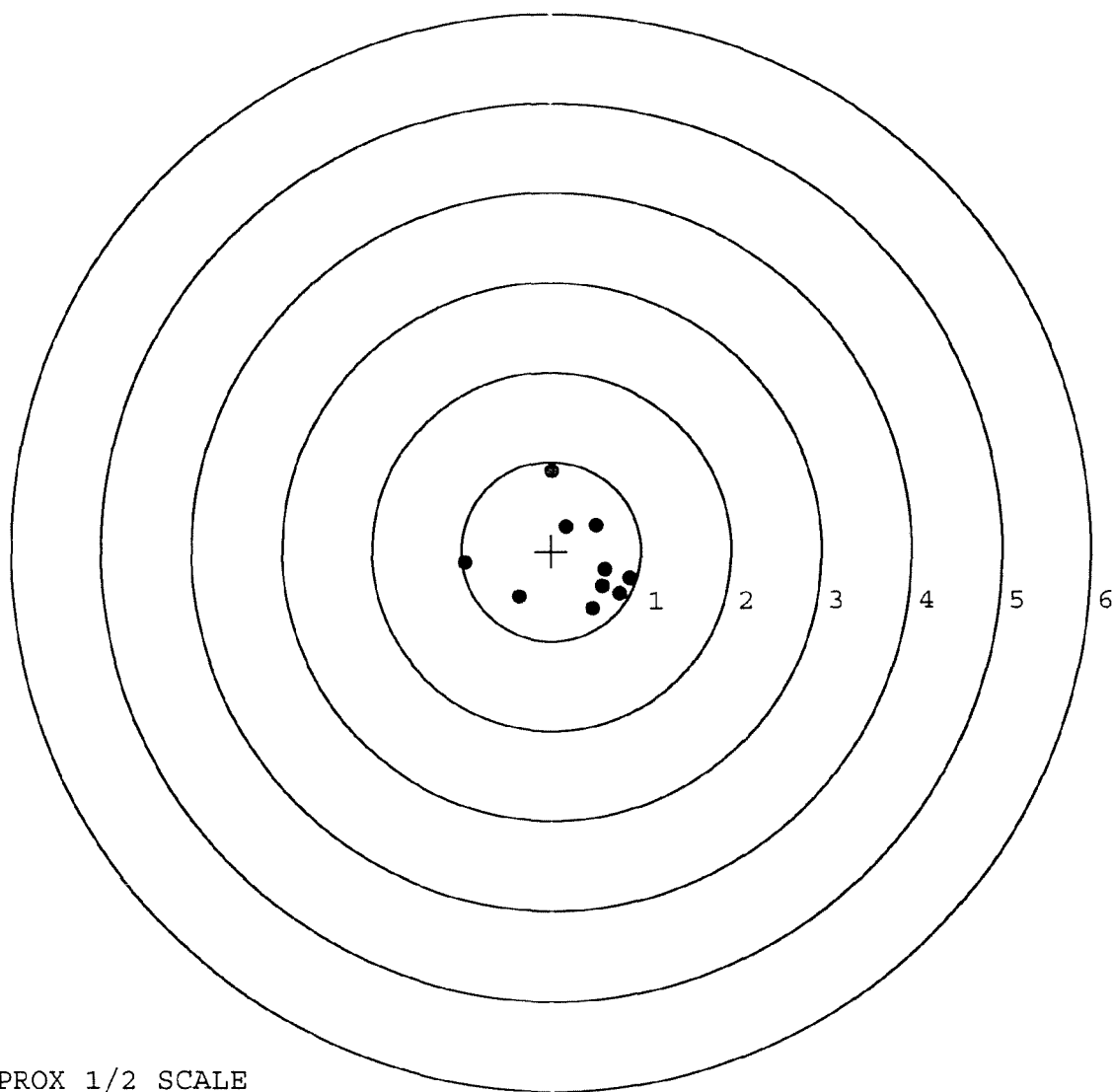
MAX RADIUS: 1.221

MEAN RADIUS: 0.646

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10

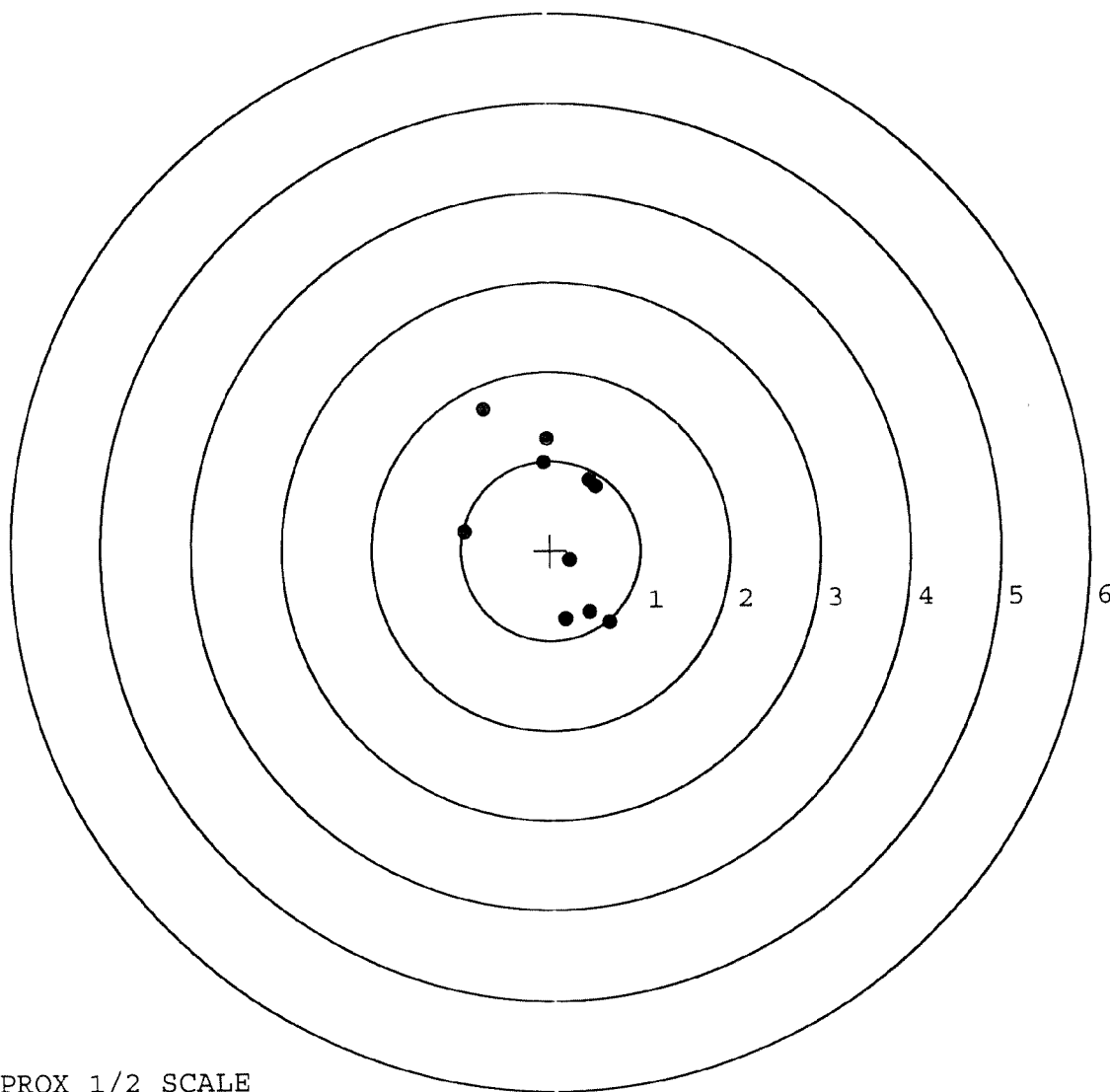


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6738629. 0
TARGET NUMBER: 3
FILE DATE: 09/10/2008
FILE TIME: 14:19

POINT#	X	Y
1:	0.164	-0.764
2:	0.652	-0.803
3:	0.427	-0.693
4:	0.217	-0.109
5:	0.511	0.708
6:	0.438	0.785
7:	-0.069	0.984
8:	-0.033	1.252
9:	-0.736	1.579
10:	-0.959	0.208

X CENTROID: 0.061
Y CENTROID: 0.315
POA TO CENTROID: 0.321
HORZ SPREAD: 1.611
VERT SPREAD: 2.382
GROUP SPREAD: 2.757
MIN RADIUS: 0.451
MAX RADIUS: 1.495
MEAN RADIUS: 0.922
IN 1 IN DIAMETER: 1
IN 2 IN DIAMETER: 5
in 3 IN DIAMETER: 10

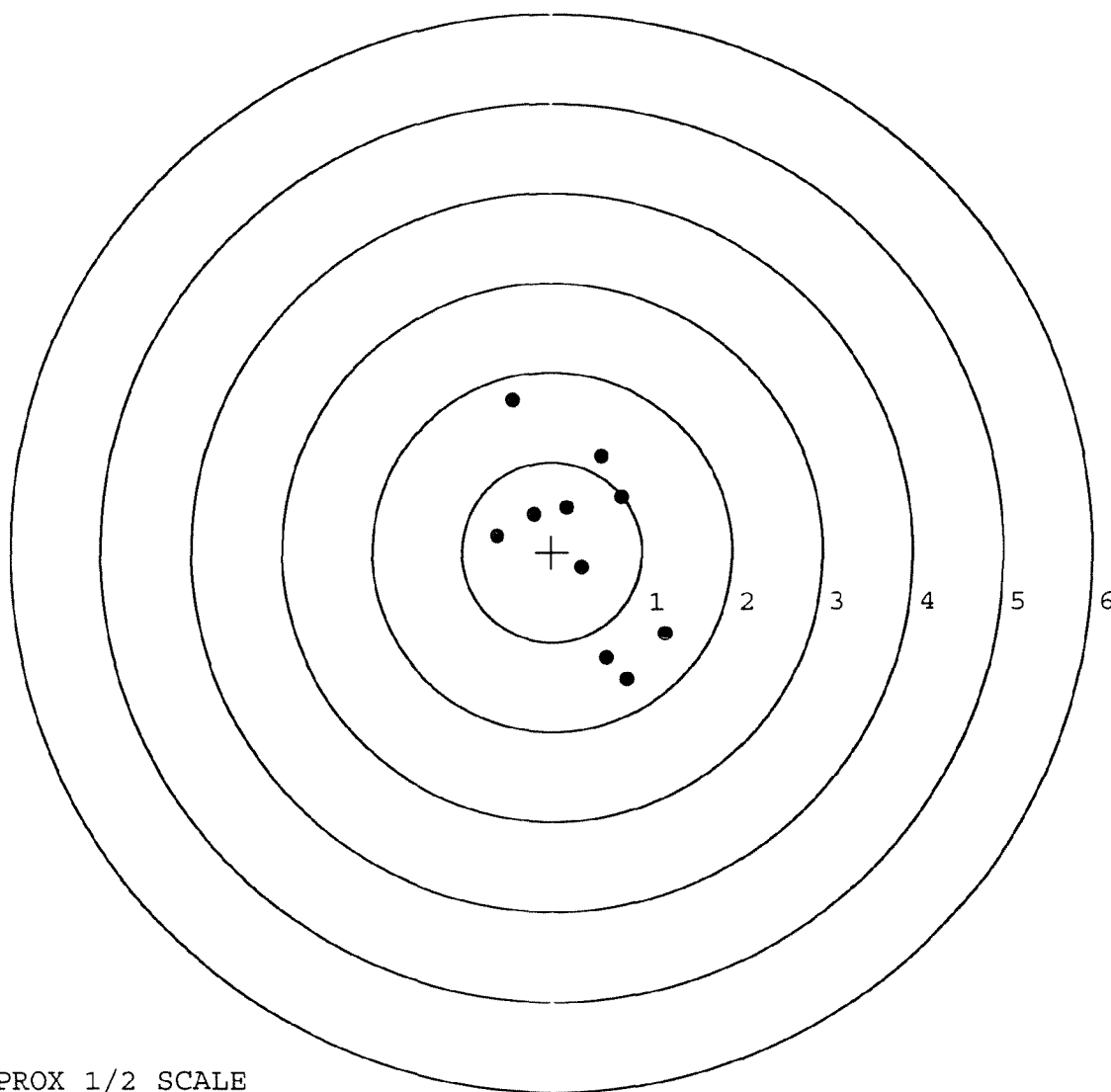


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6738629. __0
TARGET NUMBER: 4
FILE DATE: 09/10/2008
FILE TIME: 14:19

X CENTROID: 0.331
Y CENTROID: 0.075
POA TO CENTROID: 0.340
HORZ SPREAD: 1.868
VERT SPREAD: 3.109
GROUP SPREAD: 3.357
MIN RADIUS: 0.249
MAX RADIUS: 1.777
MEAN RADIUS: 0.999
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 5
in 3 IN DIAMETER: 8

POINT#	X	Y
1:	-0.608	0.178
2:	-0.427	1.683
3:	-0.195	0.426
4:	0.169	0.496
5:	0.557	1.061
6:	0.776	0.608
7:	0.338	-0.174
8:	0.604	-1.185
9:	0.838	-1.426
10:	1.260	-0.913



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6738629. 0

TARGET NUMBER: 5

FILE DATE: 09/10/2008

FILE TIME: 14:19

POINT#	X	Y
1:	0.279	-0.830
2:	0.454	-0.270
3:	0.373	-0.038
4:	0.164	0.265
5:	0.565	0.371
6:	0.957	0.156
7:	-0.576	-0.488
8:	-0.984	0.239
9:	-0.528	0.576
10:	-0.726	1.139

X CENTROID: -0.002

Y CENTROID: 0.112

POA TO CENTROID: 0.112

HORZ SPREAD: 1.941

VERT SPREAD: 1.969

GROUP SPREAD: 2.211

MIN RADIUS: 0.226

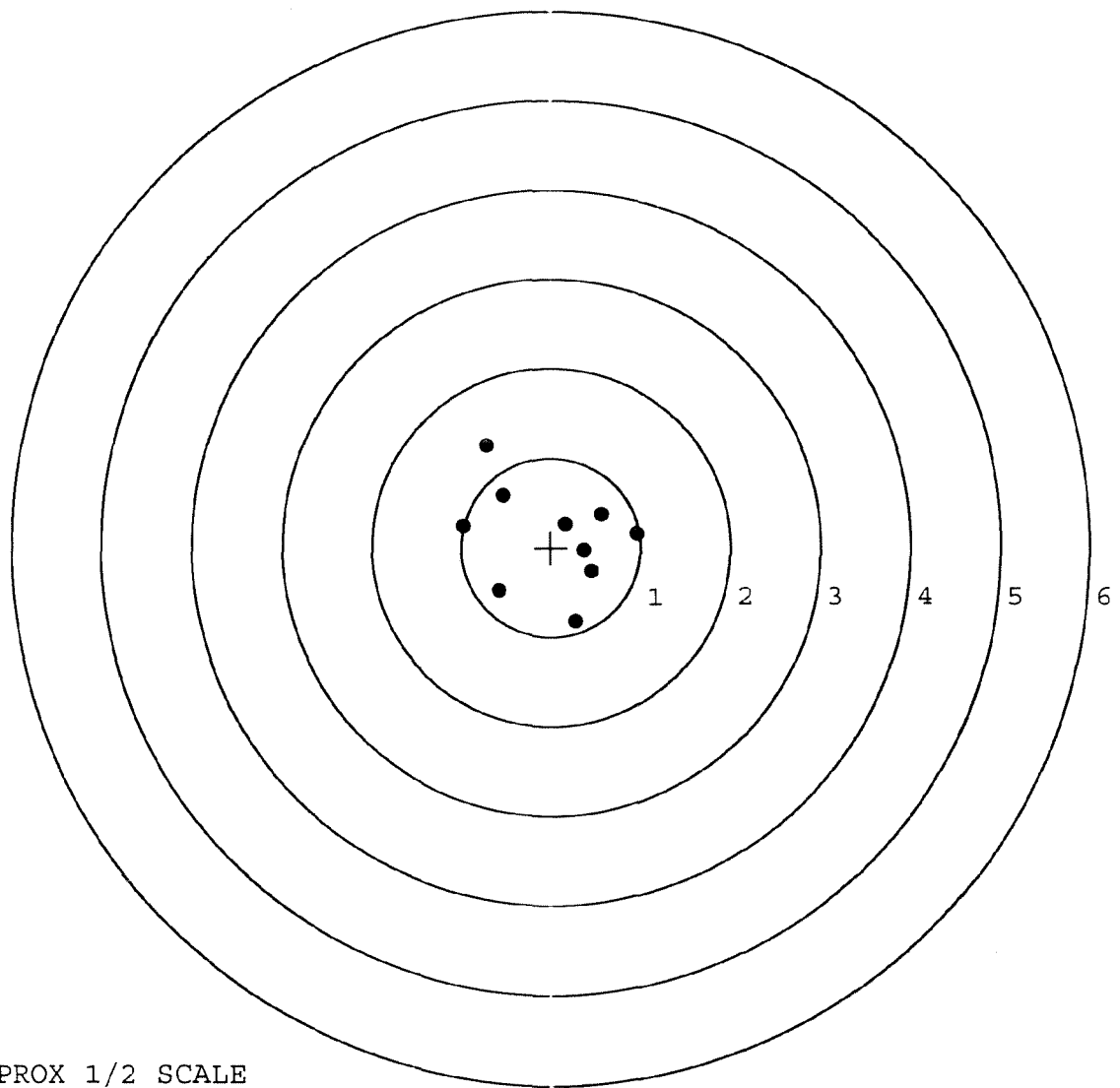
MAX RADIUS: 1.256

MEAN RADIUS: 0.757

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

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

R & E NUMBER 148640
SERIAL NUMBER E6203406 GL0738629
LOG-IN DATE 8-5-08

OPERATION #	OPERATION NAME	DATE	INITIAL
500	DIS-ASSEMBLE GUN	8/27/08	RTZ
505	RE-BARREL	8/28/08	RTZ
560	ASSEMBLE	8/28/08	RTZ
600	PROOF	8/28/08	S.P.D.
605	CHECK HEADSPACE	8/28/08	S.P.D.
610	DIS-ASSEMBLE GUN	8/28/08	S.P.D.
612	MAGNAFLUX	9-2-08	BT
510	DRILL AND TAP	8-29-08	SP
615	ROLLMARK CALIBER	8/3/08	RT
618	ROTO-BLAST	9/3/08	DG
620	APPLY COATINGS	9/8	W
625	FINAL ASSEMBLY	9-9-08	RTZ
640	FUNCTION TEST AND	9-10-08	TRW
650	TARGET	9-10-08	TRW
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
670	FINAL INSPECTION	9/10/08	RTZ
	A) HEADSPACE	9-11-08	RTZ
	B) TRIGGER PULL	226 220 205 209 2.12 9-11-08	RTZ
680	F) SAFETY ON FORCE	8-0 8-0 8-0 9-11-08	RTZ
	G) SAFETY OFF FORCE	250 250 250 9-11-08	RTZ
	I) FIRING PIN INDENT	024 024 024 9-11-08	RTZ
690	PACK	9/12/08	FM

MAGNA - FLUX

SEP 02 2008

OPERATOR BT

PASS

FAIL

PASS

FAIL

PASS

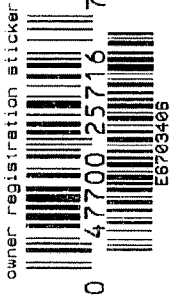
FAIL

N/A

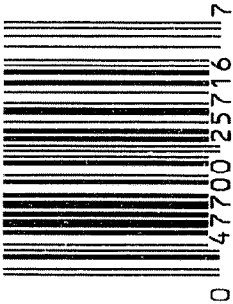
MODEL 700TH M24
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO

DOCUMENT ENVELOPE ASSEMBLY:
- INSTRUCTION BOOK
- PRODUCT OWNER'S CARD
- SAFETY BOOKLET

46 FORM 1444



UPC



ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

E6703406



MODEL 700™ M24
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO

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

SERIAL NO. **J**
E6703406

ORDER NO. **25716**

46
 Made in Illinois, NY Reg. U.S. Pat. & tm. Off. Marca Registrada Marque Deposee.



5716 E6703406

29EV

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MODEL 700TH M24

UPC



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MODEL 700TH M24

UPC



SERIAL NO.



AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#
3.00# ± .75#
4.00# ± 1.00#

SERIAL NO. E6703406

DATE 5/10/01

TESTER RL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	232	203		235	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	245	206		238	
PULL #3	234	201		240	
PULL #4	235	204		246	
PULL #5	233	207		240	
TOTAL	1179	1021		1199	
AVG.	235	204		239	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	329	302		
PULL #2	324	307		
PULL #3	324	308		
PULL #4	322	300		
PULL #5	324	311		
TOTAL	1625	1528		
AVG.	325	305		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	404	411		437
PULL #2	400	410		438
PULL #3	403	404		436
PULL #4	400	409		424
PULL #5	401	408		435
TOTAL	2008	2042		2170 2008 2042
AVG.	401	408		434

Remington Test Lab, Ilion, N.Y.

E6703406

Centroidal distance calculations for Rifle # E6709406
20 Aug 2001

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1626

THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .185

THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .2463

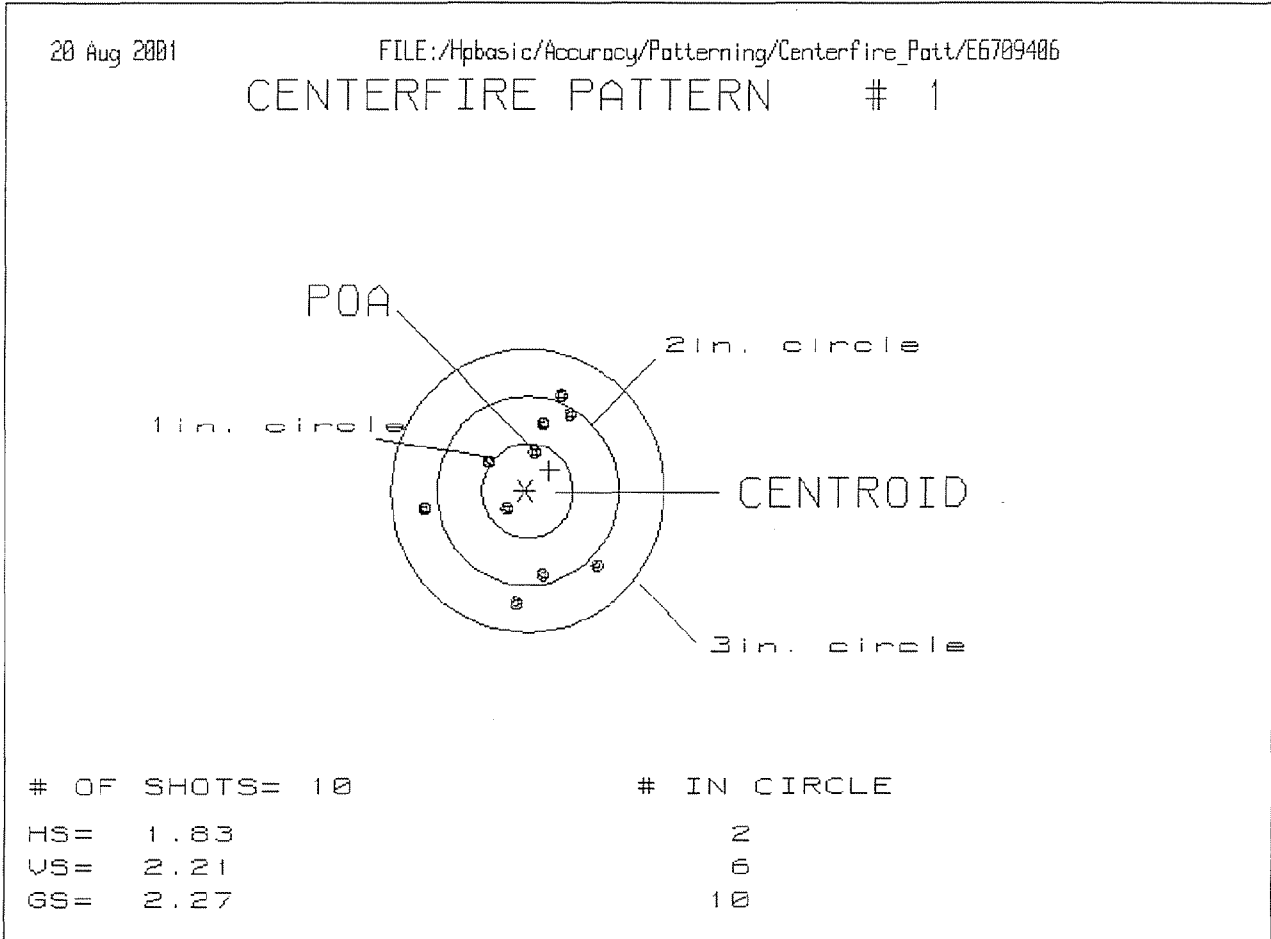
THE AMR FOR THIS RIFLE IS: 1.123

CENTROIDAL DISTANCES

0 TO	1	.342498
1 TO	2	.714083
1 TO	3	.647992
1 TO	4	.68842
1 TO	5	.511353

4 5 2
+ 3 <----POA
1

PATTERN #: ☐ 1 ☐
 POA TO CENTROID: .343
 MIN RADIUS : .339
 MEAN RADIUS : .834
 MAX RADIUS : 1.231
 CENTROID X : -.269
 CENTROID Y : -.212

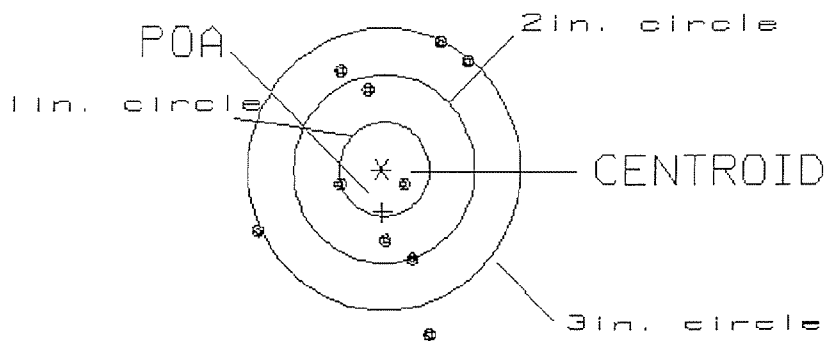


PATTERN #: 2
 POA TO CENTROID: .455
 MIN RADIUS : .245
 MEAN RADIUS : 1.072
 MAX RADIUS : 1.805
 CENTROID X : -.014
 CENTROID Y : .455

20 Aug 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/E6709406

CENTERFIRE PATTERN # 2



OF SHOTS= 10

IN CIRCLE

HS= 2.27

1

VS= 3.03

5

GS= 3.03

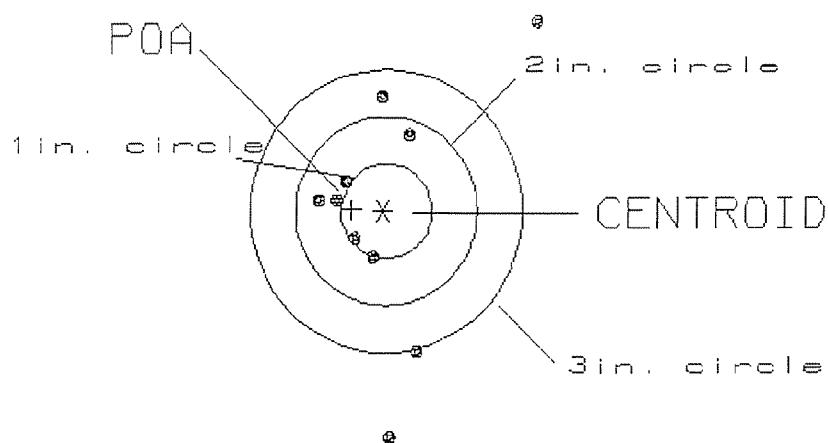
8

PATTERN #: ☐ 3 ☐
 POA TO CENTROID: .348
 MIN RADIUS : .441
 MEAN RADIUS : 1.144
 MAX RADIUS : 2.579
 CENTROID X : .348
 CENTROID Y : -.014

20 Aug 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/E6709406

CENTERFIRE PATTERN # 3



OF SHOTS= 10

IN CIRCLE

HS= 2.37

1

VS= 4.34

6

GS= 4.64

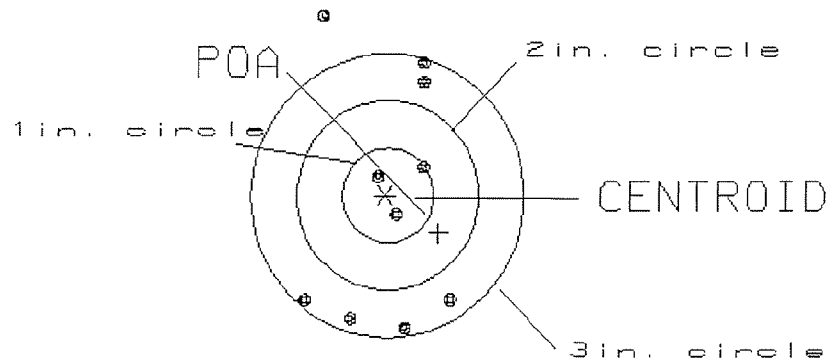
7

PATTERN #: ☐ 4 ☐
 POA TO CENTROID: .711
 MIN RADIUS : .163
 MEAN RADIUS : 1.128
 MAX RADIUS : 2.023
 CENTROID X : -.590
 CENTROID Y : .397

20 Aug 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/E6709406

CENTERFIRE PATTERN # 4



OF SHOTS= 10

IN CIRCLE

HS= 1.61
 VS= 3.34
 GS= 3.46

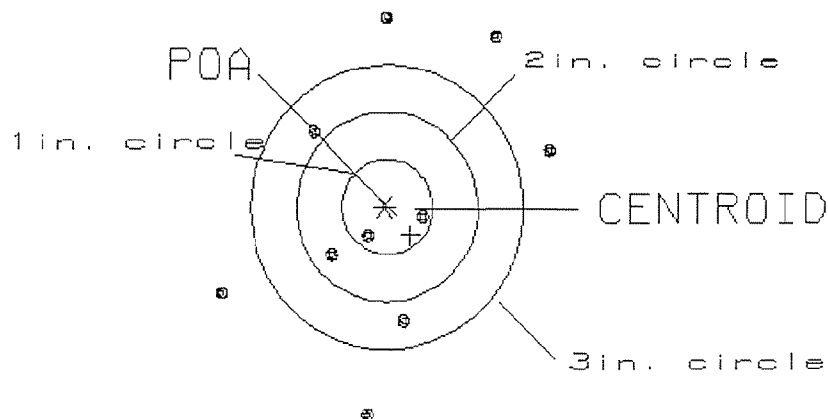
2
 3
 5

PATTERN #: ☐ 5 ☐
 POA TO CENTROID: .415
 MIN RADIUS : .391
 MEAN RADIUS : 1.438
 MAX RADIUS : 2.217
 CENTROID X : -.288
 CENTROID Y : .299

20 Aug 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/E6709406

CENTERFIRE PATTERN # 5



OF SHOTS= 10

IN CIRCLE

HS= 3.61

2

VS= 4.22

3

GS= 4.29

5

CONTRACT #

E670 3406

GUN SERIAL #

~~E670 9406~~

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		8/7/01	AK
600	PROOF		8-2-01	AK
607	CHECK HEADSPACE		8-2-01	AK
610	DIS-ASSEMBLE GUN		8-2-01	AK
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT		8-6-01	AC
615	ROLLMARK CALIBER		8-6-01	AK
617	DRILL AND TAP SIGHT HOLES		8-6-01	GUT
618	POLISH BARREL		8-7-01	GD
620	APPLY COATINGS (BARREL ACTION)		8-8-01	TA
	(BOLT)		8-8-01	TA
625	FINAL ASSEMBLY			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		8-16-01	AK
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		8-16-01	AK
	C) INSPECT EJECTOR HOLE FOR CHAMFER		8-16-01	AK
	D) OIL FIRING PIN ASSEMBLY		8-16-01	AK
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE		8-16-01	AK

OP #	OPERATION NAME	READINGS			DATE	INITIAL		
625	F) SAFETY ON FORCE	<u>8.0</u>	<u>8.0</u>	<u>7.5</u>	8-22-01	DA		
CONT.	G) SAFETY OFF FORCE	<u>3.0</u>	<u>3.0</u>	<u>2.5</u>	8-22-01	DA		
	H) TRIGGER PULL TEST AND RETAINABILITY				10-26-01	PH		
	I) FIRING PIN INDENT	<u>-0.23</u>	<u>-0.24</u>	<u>-0.23</u>	8-22-01	DA		
	J) ASSEMBLE STOCK				8/1/01	PH		
	K) ASSEMBLE SWIVEL STUDS				10-25-01	PH		
	L) ATTACH FRONT AND REAR SIGHT ASSY'S				8-22-01	PH		
	M) IRON SIGHT ALIGNMENT				8-22-01	PH		
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER				8-22-01	PH		
640	GALLERY TEST AND TARGET				8/20	A		
	A) MALFUNCTIONS	Rough chamber OK PH			8/20	A		
	B) PIERCED PRIMERS				8/20	A		
645	INSPECT FOR LIVE AMMO				8/20	A		
655	FINAL INSPECTION A) HEADSPACE				10-25-01	PH		
	B) TRIGGER PULL	<u>2.26</u>	<u>2.21</u>	<u>2.13</u>	<u>2.21</u>	<u>2.33</u>	8-22-01	DA
	C) FUNCTION				10-25-01	PH		
660	PACK				10/26/01	DA		