

C6522291

MODEL 700TH M24

Model **SMS**TH

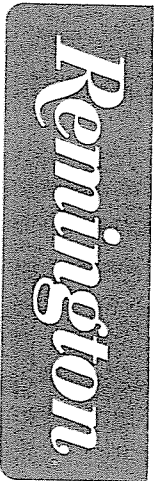
Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.



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: **RE00023073** Serial: **C6522291** Model: **700** Center Fire Caliber: **7.62 NATO M-24 (SWS)** Repairman: Status: **Closed 2/16/01 10:07:23 AM**

Verify Repair

Address Information

Customer: **C CO SPT BN** Received From: **C CO SPT BN** Return To: **C CO SPT BN**

Address 1: **USA JFK SWCS** Address 2: PO Box: City: **FT BRAGG** State: **NC** Zip Code: **28310** Country: **US**

FFL:

Contact / Condition Problems Estimate History / Status Shipping / Billing

Contact Information

Phone: Fax: Email: Comments:

Received Condition

Condition: **Poor** Condition Notes: CSR Notes:

Accessories Received

Code	Desc	Qty
A007	With Stud	1
A008	With Swivel	1
A016	Scope Mounts	1
A017	Scope Base	1
A026	Scope	1

Repair Search **Refresh** **Close**

nagle 2/17/01 7:43 AM CAPS NUM INS SCRL

Start NISTL Inbox Explor Part S SAPL Arm... Nagle New 7:43 AM

Serial Number:

C6522291

Model: **700**



RE00023073

Remington Test Lab, Ilion, N.Y.

Centroidal distance calculations for Rifle # c6522291

2 Apr 2001

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0138

THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0236

THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0273386

THE AMR FOR THIS RIFLE IS: 1.078

CENTROIDAL DISTANCES

0	TO	1	.34389
1	TO	2	.499376
1	TO	3	.552161
1	TO	4	.402892
1	TO	5	.314384

2
1 54³ <----POA

PATTERN #: ☐ 1 ☐

POA TO CENTROID: .344

MIN RADIUS : .523

MEAN RADIUS : 1.379

MAX RADIUS : 2.240

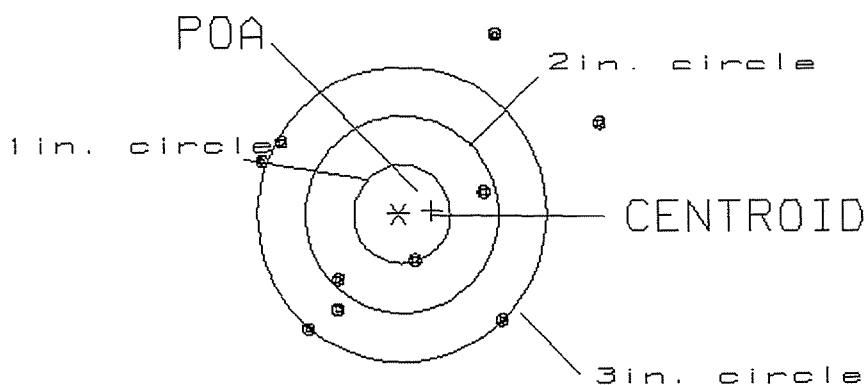
CENTROID X : -.342

CENTROID Y : -.036

2 Apr 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6522291

CENTERFIRE PATTERN # 1



OF SHOTS= 10

IN CIRCLE

HS= 3.51

0

VS= 3.02

3

GS= 3.62

7

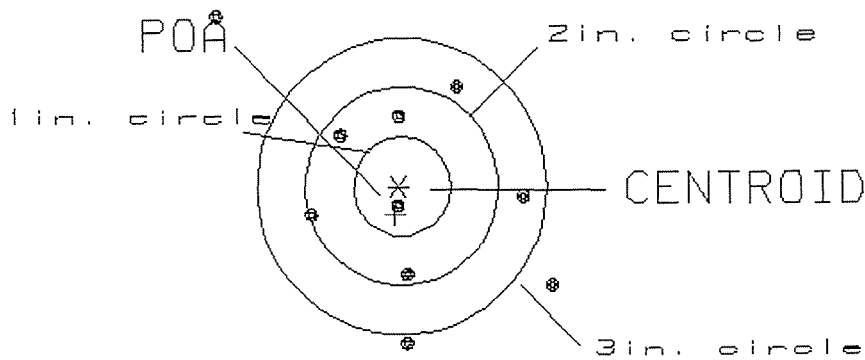
PATTERN #: ☐ 2 ☐

POA TO CENTROID: .291
 MIN RADIUS : .151
 MEAN RADIUS : 1.193
 MAX RADIUS : 2.550
 CENTROID X : .038
 CENTROID Y : .288

2 Apr 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6522291

CENTERFIRE PATTERN # 2



OF SHOTS= 10

IN CIRCLE

HS= 3.44

1

VS= 3.28

4

GS= 4.35

7

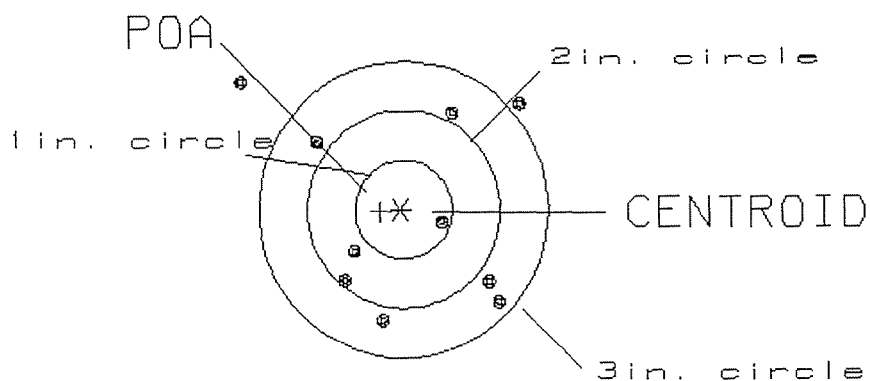
PATTERN #: ☐ 3 ☐

POA TO CENTROID: .208
 MIN RADIUS : .408
 MEAN RADIUS : 1.171
 MAX RADIUS : 2.127
 CENTROID X : .207
 CENTROID Y : .023

2 Apr 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6522291

CENTERFIRE PATTERN # 3



OF SHOTS= 10

IN CIRCLE

HS= 2.89

1

VS= 2.40

3

GS= 3.53

8

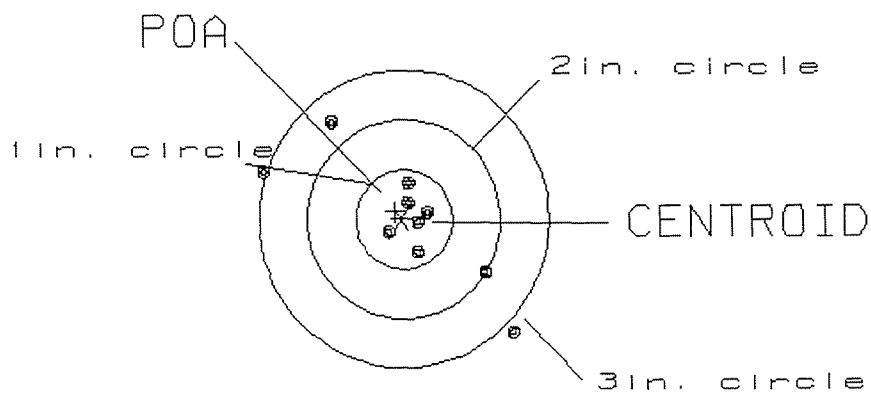
PATTERN #: ☐ 4 ☐

POA TO CENTROID: .095
 MIN RADIUS : .111
 MEAN RADIUS : .684
 MAX RADIUS : 1.590
 CENTROID X : .059
 CENTROID Y : -.075

2 Apr 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6522291

CENTERFIRE PATTERN # 4



OF SHOTS= 10

IN CIRCLE

HS= 2.61
 VS= 2.11
 GS= 3.08

6
 7
 8

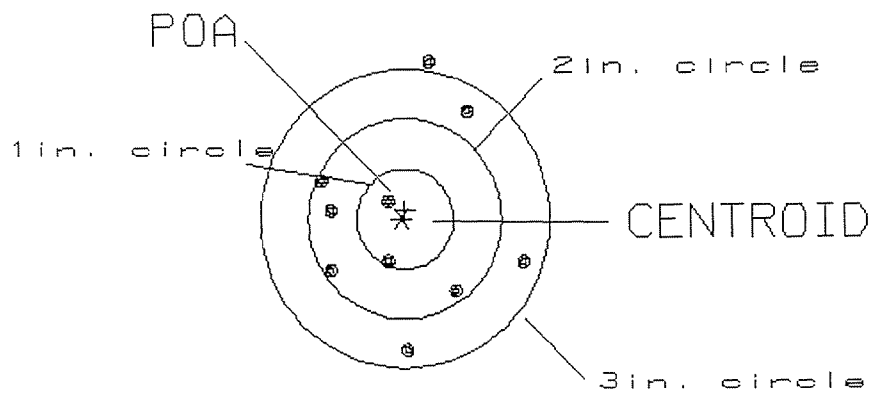
PATTERN #: 5

POA TO CENTROID: .087
 MIN RADIUS : .280
 MEAN RADIUS : .963
 MAX RADIUS : 1.604
 CENTROID X : -.031
 CENTROID Y : -.082

2 Apr 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6522291

CENTERFIRE PATTERN # 5



OF SHOTS= 10

IN CIRCLE

HS= 2.12
 VS= 2.86
 GS= 2.87

2
 6
 9

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

R & E NUMBER			
SERIAL NUMBER C6522 991			
LOG-IN DATE 2-17-01			
INSPECT AND VERIFY:			
OPERATION #	OPERATION NAME	DATE	INITIAL
550	DIS-ASSEMBLE GUN	2-21-01	CF
560 A	RE-BARREL AT CUSTOM SHOP		
B	DRILL AND TAP		
C	POLISH		
575	ASSEMBLE		
600	PROOF	3-23-01	RW
605	CHECK HEADSPACE	3-23-01	RW
610	DIS-ASSEMBLE GUN		
612	MAGNAFLUX		
615	ROLLMARK CALIBER		
618	ROTO-BLAST		
620	APPLY COATINGS		
625 A	FINAL ASSEMBLY		
B	TRIGGER PULL TEST		
C	SAFETY "ON" FORCE		
D	SAFETY "OFF" FORCE		
E	FIRING PIN INDENT		
640	TARGET	4-2-01	RW
655	FINAL INSPECT	4-3-01	RW
660	PACK		
		SHIP DATE	
QAR INSPECTION DATE			

Final Inspection

Sni: C6522291 DATE REC'D: 2-17-01 DATE RET'D:

AUDITOR: C#

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: _____

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



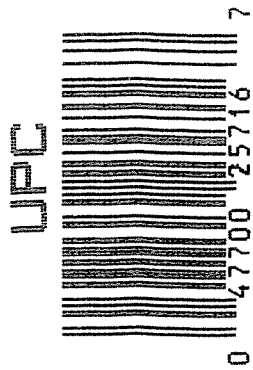

REG. U.S. PAT. & TM. OFF.

MODEL 700™ H24

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

SERIAL NO.
C6522291

ORDER NO.
5716



CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6522291
30 Aug 1990

CENTROIDAL DISTANCES

0 TO	1	.56978
1 TO	2	.377976
1 TO	3	1.17138
1 TO	4	1.07221
1 TO	5	.357543

t_2^{1s} ϕ ---- POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: 1.0202
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0396
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: 1.02097
THE AMR FOR THIS RIFLE IS: .9822

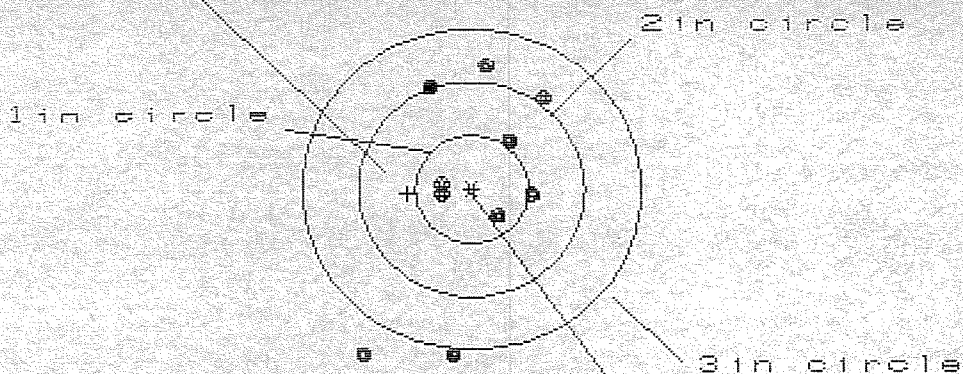
30 Aug 1990

FILE:/PATTERNING/CENTERFIRE_PATT/C6522291

CENTERFIRE PATTERNS

1

POA



OF SHOTS= 10

IN CIR

1in = 3

2in = 5

3in = 8

HS= 1.596

VS= 2.764

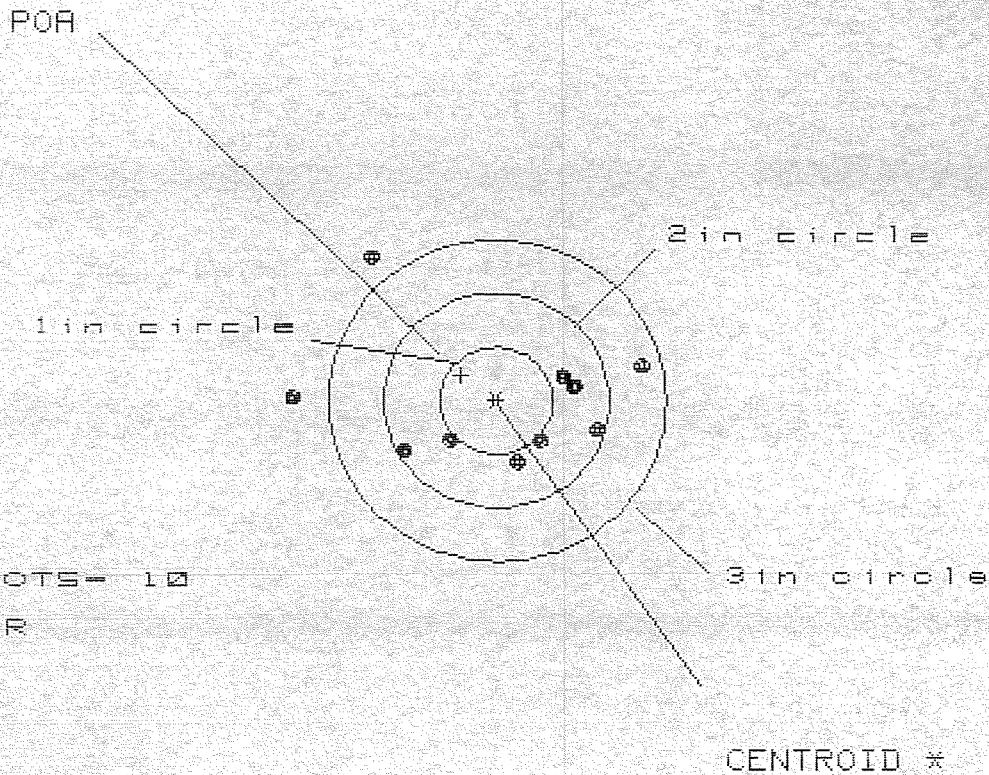
GS= 2.972

PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.658	.554	.525
MINIMUM X	:	-.938	-.462	-.491
MAXIMUM Y	:	1.178	1.001	.788
MINIMUM Y	:	-1.586	-1.707	-.605
CENTROID X	:	.568	.672	.701
CENTROID Y	:	.045	.222	.435
POA TO CENTROID in.	:	.570	.708	.825
MIN RADIUS	:	.228	.369	.257
MEAN RADIUS	:	.863	.737	.607
MAX RADIUS	:	1.843	1.722	.788
HORIZONTAL SPREAD	:	1.596	1.016	1.016
VERTICAL SPREAD	:	2.764	2.708	1.393
EXTREME SPREAD	:	2.972	2.722	1.396
NUMBER IN ONE INCH CIRCLE	=	3		
NUMBER IN TWO INCH CIRCLE	=	5		
NUMBER IN THREE INCH CIRCLE	=	8		

30 Aug 1998

FILE:/PATTERNING/CENTERFIRE_PATT/06522291

CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1in = 0

2in = 7

3in = 8

HS = 3.093

VS = 1.890

GS = 3.115

CENTROID *

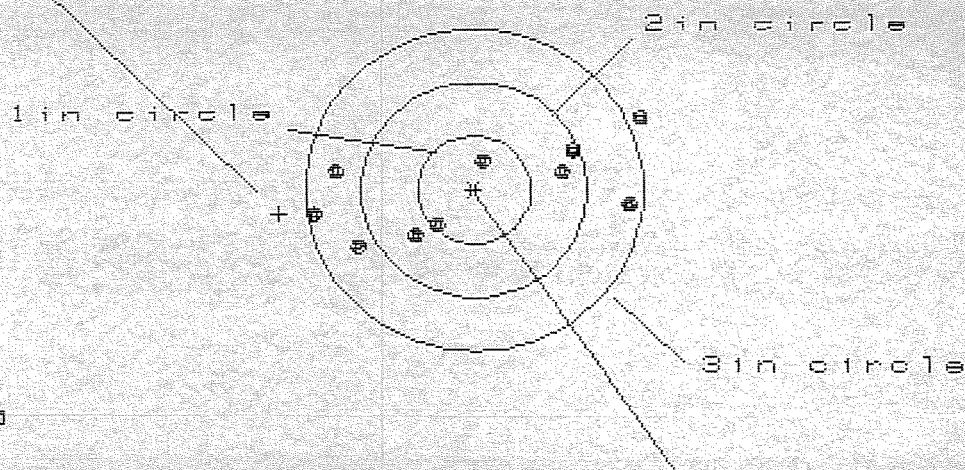
PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.308	1.110	.949
MINIMUM X	:	-1.785	-1.287	-1.134
MAXIMUM Y	:	1.288	1.288	.529
MINIMUM Y	:	-.602	-.602	-.441
CENTROID X	:	.313	.511	.672
CENTROID Y	:	-.234	-.234	-.395
POR TO CENTROID in.	:	.391	.562	.779
MIN RADIUS	:	.543	.419	.210
MEAN RADIUS	:	.970	.831	.644
MAX RADIUS	:	1.785	1.821	1.172
HORIZONTAL SPREAD	:	3.093	2.397	2.083
VERTICAL SPREAD	:	1.890	1.890	.970
EXTREME SPREAD	:	3.115	2.567	2.240
NUMBER IN ONE INCH CIRCLE =			0	
NUMBER IN TWO INCH CIRCLE =			7	
NUMBER IN THREE INCH CIRCLE =			8	

30 Aug 1990

FILE:/PATTERNING/CENTERFIRE_PATT/C6522291

CENTERFIRE PATTERNS # 3

POA



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 5

3 in = 9

HS = 2.968

VS = 1.196

GS = 3.111

CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.518	1.509	1.349
MINIMUM X	:	-1.450	-1.281	-1.175
MAXIMUM Y	:	.706	.450	.431
MINIMUM Y	:	-.490	-.411	-.430
CENTROID X	:	1.725	1.556	1.716
CENTROID Y	:	.228	.149	.168
POA TO CENTROID in.	:	1.740	1.563	1.724
MIN RADIUS	:	.302	.341	.361
MEAN RADIUS	:	1.002	.907	.859
MAX RADIUS	:	1.675	1.510	1.352
HORIZONTAL SPREAD	:	2.968	2.790	2.524
VERTICAL SPREAD	:	1.196	.861	.861
EXTREME SPREAD	:	3.111	2.791	2.546
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

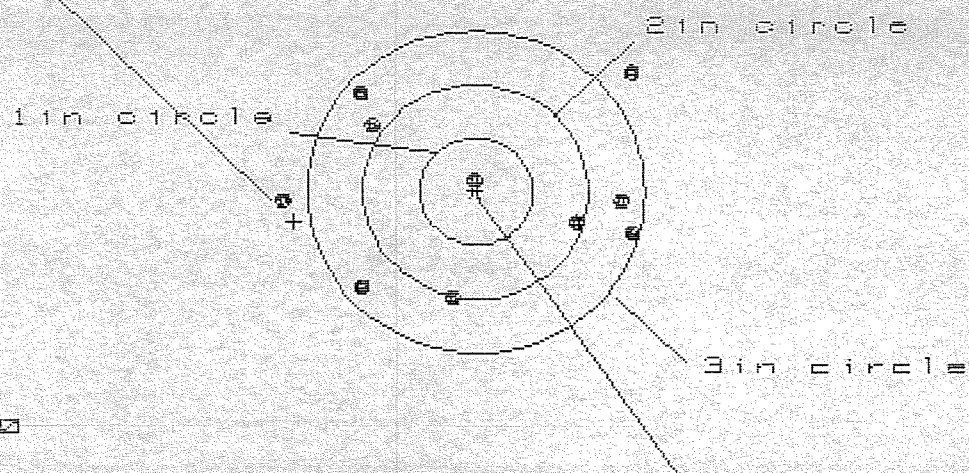
30 Aug 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C8522291

CENTERFIRE PATTERNS

4

POA



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 3

3 in = 8

HS = 3.121

VS = 2.090

CS = 3.288

CENTROID *

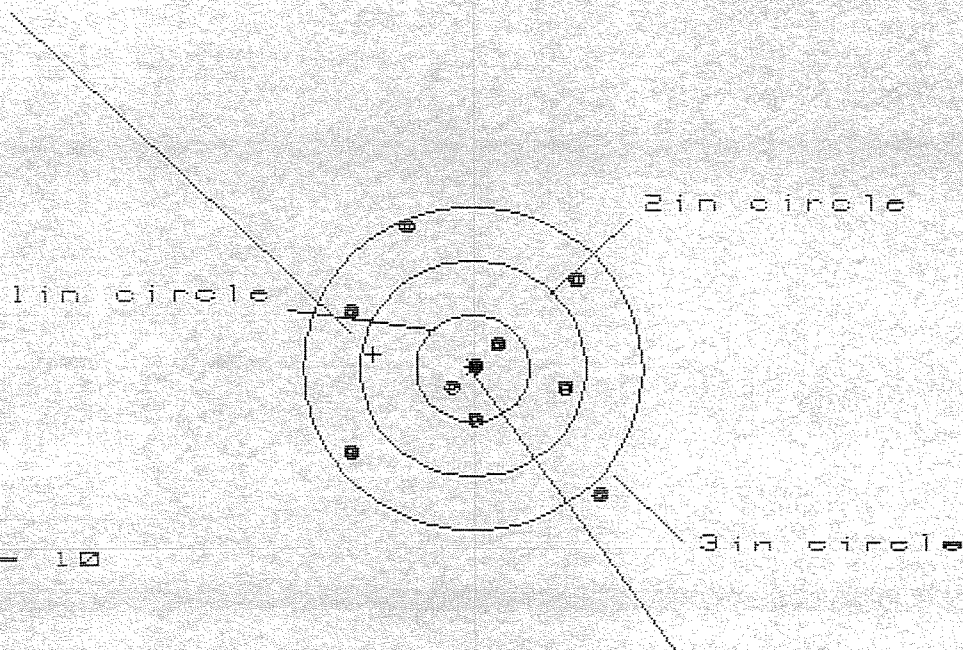
PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.399	1.548	1.352
MINIMUM X	:	-1.722	-1.573	-1.075
MAXIMUM Y	:	1.122	1.049	1.057
MINIMUM Y	:	-0.968	-0.843	-0.836
CENTROID X	:	1.613	1.464	1.660
CENTROID Y	:	.285	.160	.152
POA TO CENTROID in.	:	1.638	1.473	1.667
MIN RADIUS	:	.089	.250	.229
MEAN RADIUS	:	1.199	1.138	1.066
MAX RADIUS	:	1.751	1.574	1.507
HORIZONTAL SPREAD	:	3.121	3.121	2.426
VERTICAL SPREAD	:	2.090	1.892	1.892
EXTREME SPREAD	:	3.288	3.138	2.757
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		8	

30 Aug 1990

FILE:/PATTERNING/CENTERFIRE_PATT/06522291

CENTERFIRE PATTERNS # 5

POA



OF SHOTS= 10

IN CIR

1 in = 3

2 in = 5

3 in = 9

HS= 2.208

VS= 2.519

GS= 3.062

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.110	.996	.932
MINIMUM X	:	-1.098	-.974	-1.038
MAXIMUM Y	:	1.299	1.163	.801
MINIMUM Y	:	-1.220	-.920	-.775
CENTROID X	:	.882	.758	.822
CENTROID Y	:	-.126	.010	-.135
POA TO CENTROID in.	:	.891	.758	.833
MIN RADIUS	:	.026	.162	.039
MEAN RADIUS	:	.877	.815	.713
MAX RADIUS	:	1.650	1.340	1.295
HORIZONTAL SPREAD	:	2.208	1.970	1.970
VERTICAL SPREAD	:	2.519	2.083	1.576
EXTREME SPREAD	:	3.062	2.523	2.523
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

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

SERIAL NO. C6522291

DATE 8/29/90

TESTER JPL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.32	2.31	2.19	2.49	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.16	2.32	2.00	2.50	
PULL #3	2.21	2.29	2.29	2.51	
PULL #4	2.25	2.28	2.30	2.38	
PULL #5	2.19	2.28	2.28	2.51	
TOTAL	11.03	11.48	11.06	12.39	
AVG.	2.206	2.296	2.212	2.478	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.26	3.19		
PULL #2	3.02	3.03		
PULL #3	3.22	3.11		
PULL #4	3.23	3.08		
PULL #5	3.13	3.17		
TOTAL	15.86	15.68		
AVG.	3.172	3.116		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.17	4.20		4.12
PULL #2	4.08	4.16		4.11
PULL #3	4.18	4.19		4.11
PULL #4	4.41	4.17		4.14
PULL #5	4.16	4.14		4.17
TOTAL	21.00	20.86		20.65
AVG.	4.2	4.172		4.13

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	3 ³ / ₄	4	3 ³ / ₄			8/29/90	WLB
	G) Safety Off Force	2 ¹ / ₄	2 ¹ / ₄	2 ¹ / ₄			8/29/90	WLB
	H) Trigger Pull Test & Retainability						8/29/90	JLL
	I) Firing Pin Indent	.0225	.022	.022			8/29/90	WLB
	J) Assemble Stock						8/29/90	RW
	K) Assemble Swivel Studs						9/5/90	JDS
	L) Attach Front and Rear Sight Assemblies						8/29/90	RW
	M) Iron Sight Alignment						8/29/90	RW
	N) Detach Front & Rear Sights & place in numbered container						8/29/90	RW
	O) Attach Scope to Rifle						8/29/90	RW
	P) Detach & Attach Scope 20 Times						8/29/90	RW
640	Gallery Target & Test						8-30-90	DH
	A) Time						8-30-90	DH
	B) Malfunctions						8-30-90	DH
	C) Pierced Primers						8-30-90	DH
	D) Optical Clarity of Scope						8-30-90	DH
645	Inspect for Live Ammo						8-30-90	DH
655	Final Inspection							
	A) Headspace						9/5/90	JDS
	B) Trigger Pull	2.49	2.50	2.51	2.38	2.51	9/1/90	JLL
	C) Function						9/5/90	JDS
660	Pack						9-18-90	JLL

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6522291

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	8 2	90	RW
600	Proof	8 2	90	RW
607	Check Headspace	8 2	90	RW
610	Dis-assemble Gun	8 2	90	RW
612	Magnaflux Barrel Action		8/6/90	RW
	Magnaflux Bolt		8/6/90	RW
615	Rollmark Caliber		8/6/90	GB
617	Drill and Tap Sight Holes		8/10/90	FB
618	Polish Barrel RWB		8/14/90	WB
620	Apply Coatings (Barrel Action)		8-22-90	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/24/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/24/90	RW
	C) Inspect Ejector Hole for Chamfer		8/24/90	RW
	D) Oil Firing Pin Ass'y		8/24/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		8/29/90	JA