

06225315

MODEL 700™ M24

Model 700 M24™

Action _____

Barrel Length _____

Capacity _____

Order No. 5715

*Includes 1 in chamber.

Remington

88299

5091

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6225315

OPERATION		DATE	INT
#	NAME		
575-580	ASSEMBLY	2/1	FB
600	PROOF	2/2/88	RCW
615	MAGNAFLUX BARREL	2/18/88	P/E.
	MAGNAFLUX BOLT	5/13/88	P/E.
620	COATING	8/11/88	TJA
625-630	FINAL ASSEMBLY		
635	TEST		
640	TARGET		
	FIRING PIN INDENT		
660	PACK		

SCOPE #
1165

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6225315

OP.#	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and stock			
600	Proof			
607	Check Headspace			
610	Dis-assemble gun			
612	Magnaflux Barrel Action			
	Magnaflux Bolt			
615	Rollmark Caliber			
617	Drill & Tap Sight Holes			
618	Polish Barrel			
620	Apply Coatings (Barrel Action)			
	Apply Coatings (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/30/88	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/30/88	RW
	C) Inspect Ejector Hole for Chamfer		8/30/88	RW

OVER

OP.#		READINGS	DATE	INITIAL
625 cont.	D) Oil Firing Pin Ass'y		8/30/88	RW
	E) Adjust Trigger Pull to Min. Setting and Stake		30 Aug 88	J. U. + 88
	F) Safety on Force	6.5 6.5 6.75	30 Aug 88	J. U. + 88
	G) Safety off Force	4 4.5 4	30 Aug 88	J. U. + 88
	H) Trigger Pull Test & Retainability		30 Aug 88	J. U. + 88
	I) Firing Pin Indent	.023 .023 .023	30 Aug 88	J. U. + 88
	J) Assemble Stock		9/23/88	RW
	K) Assemble Swivel Studs		10-6-88	JS
	L) Attach Front & Rear Sight Assemblies		9/23/88	RW
	M) Iron Sight Alignment		9/23/88	RW
	N) Detach Front & Rear Sights & place in numbered container		9/23/88	RW
	O) Attach Scope to Rifle		10/3/88	RW
	P) Detach & Attach Scope 20 times		10/3/88	JY
640	Gallery Target & Test	65 R 90L	10/5/88	D.H.
	A) Optical Clarity of Scope		10/5/88	JY
645	Inspect for Live Ammo		10/5/88	JY
655	Final Inspection			
	A) Headspace		10-6-88	JS
	B) Trigger Pull		10-6-88	JS
	C) Function		10-6-88	JS
660	Pack		10-20-88	JS

SWS TRIGGER PULL TEST

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

SERIAL NO. C6225315
DATE 30 Aug. 88
TESTER J. A. + W. S.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.58	2.48	2.49	2.49	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.56	2.58	2.58	2.52	
PULL #3	2.51	2.68	2.56	2.43	
PULL #4	2.54	2.71	2.57	2.22	
PULL #5	2.57	2.55	2.50	2.13	
TOTAL	12.76	12.90	12.70	11.79	
AVG.	2.552	2.58	2.54	2.358	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.13	3.12		
PULL #2	3.11	3.15		
PULL #3	3.15	3.20		
PULL #4	3.13	3.05		
PULL #5	3.11	3.14		
TOTAL	15.68	15.66		
AVG.	3.136	3.132		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.15	4.01	4.30	4.25
PULL #2	4.06	3.99	4.30	4.22
PULL #3	4.13	4.05	4.33	4.23
PULL #4	4.07	3.99	4.35	4.22
PULL #5	4.08	4.05	4.33	4.23
TOTAL	20.49	20.09	21.61	21.15
AVG.	4.098	4.018	4.322	4.23

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6225315

CENTROIDAL DISTANCES

0 TO	1	2.1553
1 TO	2	.527277
1 TO	3	.690665
1 TO	4	1.26661
1 TO	5	.714463

+ (----) POA

5 4
1 2

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .532
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -1.8876
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: 1.96114
THE AMP FOR THIS RIFLE IS: .9654

6 Oct 1988

FILE: PATTERNING/CENTERFIRE_PATT/08225315

CENTERFIRE PATTERNS # 1

POA

+

2in circle

1in circle

OF SHOTS = 10

IN CIR

1in = 1

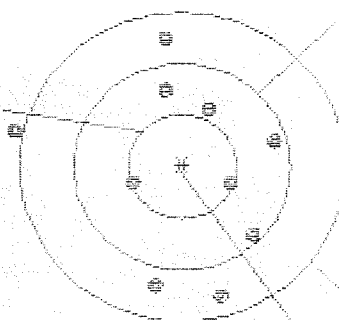
2in = 6

3in = 9

HQ = 0.473

VS = 0.473

GS = 0.542



PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.897	.721	.749
MINIMUM X	:	-1.576	-.675	-.647
MAXIMUM Y	:	1.242	1.284	1.135
MINIMUM Y	:	-1.231	-1.189	-1.248
CENTROID X	:	.151	.327	.299
CENTROID Y	:	-2.150	-2.192	-2.043
POA TO CENTROID in.	:	2.155	2.216	2.065
MIN RADIUS	:	.492	.312	.397
MEAN RADIUS	:	.960	.861	.806
MAX RADIUS	:	1.621	1.327	1.312
HORIZONTAL SPREAD	:	2.473	1.396	1.396
VERTICAL SPREAD	:	2.473	2.473	2.375
EXTREME SPREAD	:	2.542	2.534	2.378
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

5 Oct 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C8225015

CENTERFIRE PATTERNS # 2

POA

+

2 in circle

1 in circle

OF SHOTS- 10

IN CIR

1 in = 2

2 in = 7

3 in = 10

HS= 2.553

VS= 1.783

CS= 2.588

3 in circle

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	6
MAXIMUM X	:	1.275	1.133	.779
MINIMUM X	:	-1.278	-1.046	-.964
MAXIMUM Y	:	.809	.730	.683
MINIMUM Y	:	-.974	-1.053	-1.106
CENTROID X	:	.662	.804	.662
CENTROID Y	:	-2.280	-2.201	-2.154
POA TO CENTROID IN	:	2.374	2.343	2.254
MIN RADIUS	:	.124	.258	.138
MEAN RADIUS	:	.812	.730	.649
MAX RADIUS	:	1.464	1.193	1.163
HORIZONTAL SPREAD	:	2.553	2.179	1.683
VERTICAL SPREAD	:	1.783	1.783	1.783
EXTREME SPREAD	:	2.588	2.181	1.802
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	7		
NUMBER IN THREE INCH CIRCLE	=	10		

6 Oct 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C6225915

CENTERFIRE PATTERNS # 3

POA

+

2in circle

1in circle

OF SHOTS - 10

IN CIR

1in = 1

2in = 5

3in = 10

HS = 1.850

VS = 2.726

GS = 2.786

3in circle

PATTERN #	3	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.910	.954	.842
MINIMUM X	-.940	-.896	-.953
MAXIMUM Y	1.411	1.236	1.163
MINIMUM Y	-1.315	-1.159	-1.004
CENTROID X	.808	.764	.876
CENTROID Y	-2.363	-2.519	-2.674
POA TO CENTROID IN.	2.497	2.633	2.814
MIN RADIUS	.153	.186	.377
MEAN RADIUS	.989	.925	.828
MAX RADIUS	1.464	1.527	1.504
HORIZONTAL SPREAD	1.850	1.950	1.795
VERTICAL SPREAD	2.726	2.395	2.167
EXTREME SPREAD	2.786	2.511	2.278
NUMBER IN ONE INCH CIRCLE =	1	1	1
NUMBER IN TWO INCH CIRCLE =	5	5	5
NUMBER IN THREE INCH CIRCLE =	10	10	10

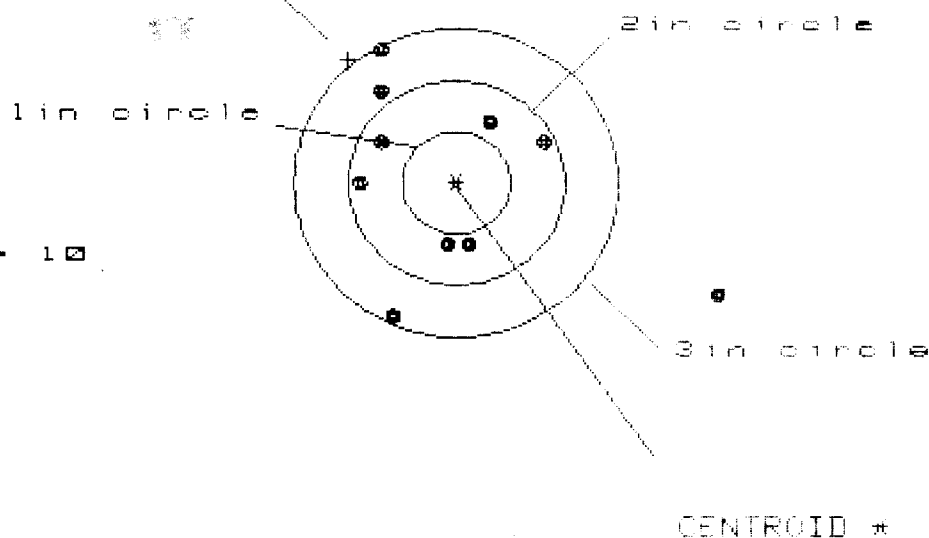
6 Oct 1988

FILE:/PATTERNING/CENTERFIRE_PATT/05225315

CENTERFIRE PATTERNS

4

POA



OF SHOTS - 10

IN CIR

1 in = 0

2 in = 6

3 in = 9

HS = 3.280

VS = 2.533

GS = 3.962

CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.434	1.102	1.045
MINIMUM X	:	-.846	-.575	-.632
MAXIMUM Y	:	1.274	1.150	.941
MINIMUM Y	:	-1.259	-1.383	-1.239
CENTROID X	:	.991	.720	.777
CENTROID Y	:	-1.202	-1.078	-1.222
POA TO CENTROID in.	:	1.558	1.297	1.449
MIN RADIUS	:	.597	.519	.573
MEAN RADIUS	:	1.112	.897	.847
MAX RADIUS	:	2.677	1.428	1.306
HORIZONTAL SPREAD	:	3.280	1.677	1.677
VERTICAL SPREAD	:	2.533	2.533	2.180
EXTREME SPREAD	:	3.962	2.535	2.235
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

6 Oct 1988

FILE:/PATTERNING/CENTERFIRE_PATT/06225315

CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 9

HS= 3.072

VS= 1.869

GS= 3.155

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.047	.699	.623
MINIMUM X	:	-1.025	-.797	-.673
MAXIMUM Y	:	1.169	1.123	1.225
MINIMUM Y	:	-.700	-.746	-.614
CENTROID X	:	.048	-.180	-.104
CENTROID Y	:	-1.443	-1.397	-1.499
POA TO CENTROID in.	:	1.444	1.409	1.503
MIN RADIUS	:	.339	.571	.489
MEAN RADIUS	:	.954	.834	.787
MAX RADIUS	:	2.089	1.217	1.286
HORIZONTAL SPREAD	:	3.072	1.496	1.496
VERTICAL SPREAD	:	1.869	1.869	1.869
EXTREME SPREAD	:	3.155	2.181	2.181
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

RECEIVING AND ESTIMATING REPORT

COMMENTS

ORDER
R 94-21803

M-24 ATTN: FRED MARTIN

INITIAL FPS	CUSTOMER ORDER NO.				
DATE RECEIVED 07/21/94	DATE OPENED 07/22/94	DATE CODE KI 5-86	SERIAL NUMBER C6225315	NEW SERIAL NUMBER	MODEL AND GRADE 700 7.62 NATO
ACCESSORIES W/STUDS		SCOPE BASE			

FROM:

COMMANDER
7TH SOS
ATTN: PBO CW2 CMR. 445
APO AE NY

09046

SHIP TO:

COMMANDER
7TH SOS
ATTN: PBO CW2 CMR. 445
APO AE NY

09046

CUST NO: 100374 C.I.D L

ACCOUNT NUMBER	ACCOUNT NUMBER N/C	PROM. DATE	ESTIMATED	VIA UPS
WRITE ☐				
GUN CONDITION				REPAIR CHARGE
☐ NEW				EXCISE
☐ LIGHTLY WORN				TAX
☐ WORN				INSURANCE
☐ VERY WORN				UPS
☐ UNREPAIRABLE				PARCEL POST
☐ MARRED				TOTAL

CUSTOMER CONCERN	AMMO	FUNCTION	FINISH	ACCURACY	FIT	INSPECT
CYCLE	A1	B1				
TRIGGER GROUP		B2			E1	F1
BOLT ASSY.		B3			E2	F2
BARREL ASSY.		B4		D1	E3	F3
REC. ASSY.		B5		D2	E4	F4
WOOD			C1	D3	E5	F5
METAL			C2			

MAIN FAULT

Marks on Receiver Walls

PARTS	Barrel - 96003	COMMENTS					
		Repowder Coat Barreled Action, Trigger Guard Assy, Front & Rear Sight Bases, Resined Scope Base & Swivel Studs					
		Could Find No Fault with Receiver Normal Machine Marks					
W52 H094221 H229		REPAIRMAN RW	PROOF ✓	CLEAN ✓	TEST ✓	TARGET ✓	PATTERN
		GALLERY TESTER RW	DATE 9/1/94	DATE 8/15/94	DATE 8/16/94	DATE 9/13/94	DATE

OFFICE COPY

FC6925 REV. 1/94

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

M2400012617

COPY 2

M2400012618

[illegible]

Replaces edition of 1 Jan 64, which will be used

Final Inspection

In: C6225315	DATE REC'D: 7/21/94	DATE RET'D:
EDITOR: AM		

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: _____

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06225315
15 Sep 1994

CENTROIDAL DISTANCES

0 TO	1	.0883629
1 TO	2	.38363
1 TO	3	.112161
1 TO	4	.0757694
1 TO	5	.520159

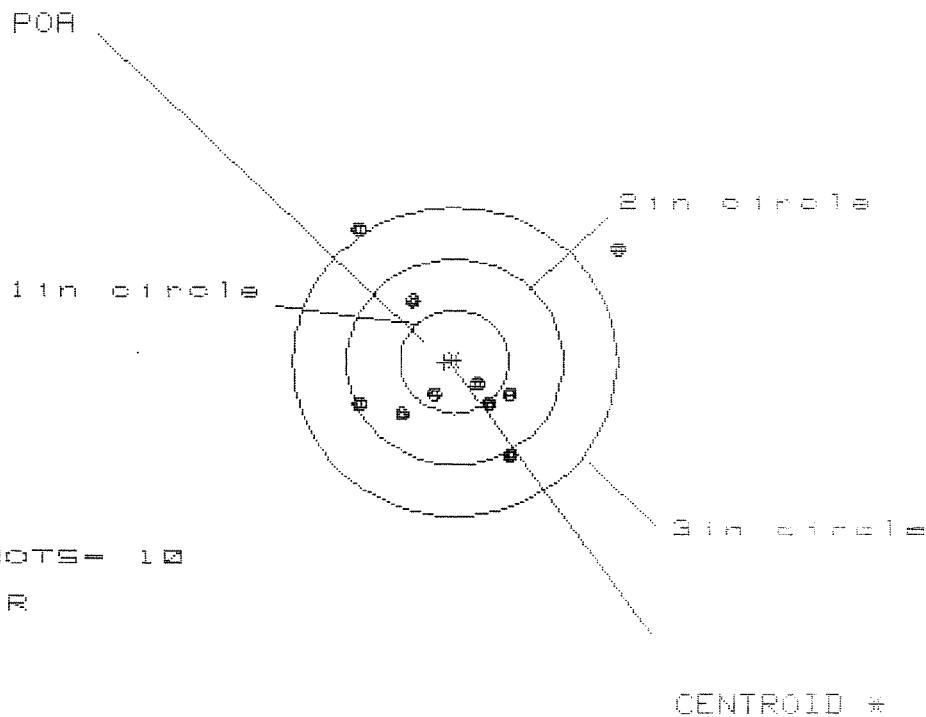
2nd <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0472
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0696
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0840952
THE AMR FOR THIS RIFLE IS: .988

15 Sep 1994

FILE:/PATTERNING/CENTERFIRE_PATT/C6225315

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1in = 3

2in = 6

3in = 8

HS= 2.410

VS= 2.119

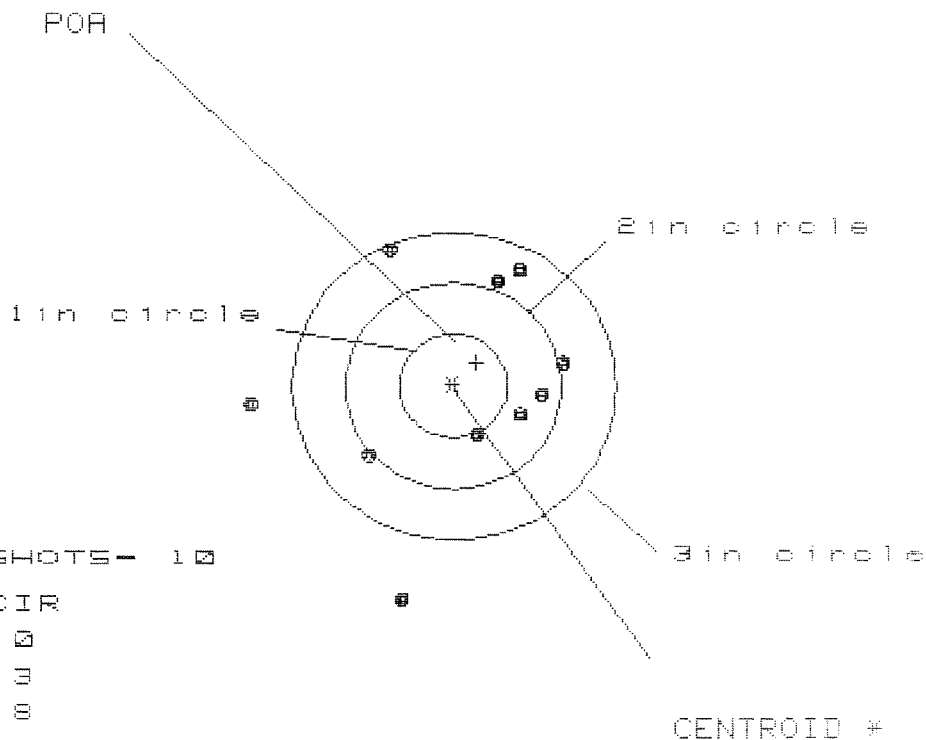
GS= 2.838

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.477	.691	.603
MINIMUM X	:	-.933	-.769	-.857
MAXIMUM Y	:	1.260	1.382	.908
MINIMUM Y	:	-.858	-.737	-.564
CENTROID X	:	.088	-.076	.012
CENTROID Y	:	.008	-.113	-.286
POA TO CENTROID in.	:	.089	.136	.286
MIN RADIUS	:	.254	.171	.155
MEAN RADIUS	:	.853	.710	.562
MAX RADIUS	:	1.838	1.551	.954
HORIZONTAL SPREAD	:	2.410	1.460	1.460
VERTICAL SPREAD	:	2.119	2.119	1.472
EXTREME SPREAD	:	2.838	2.536	1.723
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

15 Sep 1994

FILE:/PATTERNING/CENTERFIRE_PATT/C8225315

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 0

2in = 3

3in = 8

HS= 2.939

VS= 3.430

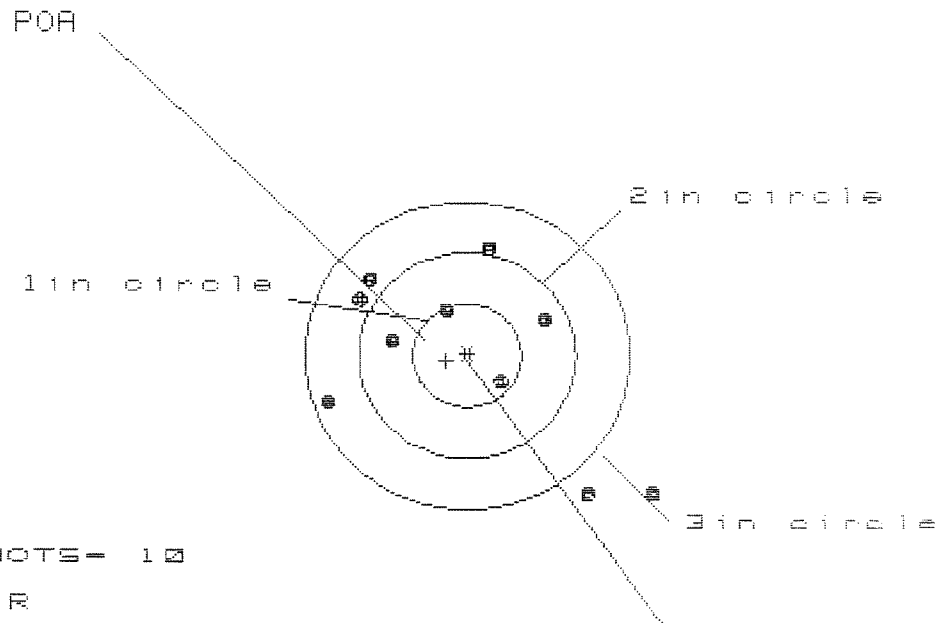
GS= 3.432

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.049	.999	.756
MINIMUM X	:	-1.890	-1.940	-1.111
MAXIMUM Y	:	1.329	1.096	1.046
MINIMUM Y	:	-2.101	-.916	-.966
CENTROID X	:	-.216	-.166	.076
CENTROID Y	:	-.226	.007	.057
POA TO CENTROID in.	:	.313	.166	.095
MIN RADIUS	:	.574	.732	.588
MEAN RADIUS	:	1.203	1.078	.902
MAX RADIUS	:	2.148	1.981	1.472
HORIZONTAL SPREAD	:	2.939	2.939	1.867
VERTICAL SPREAD	:	3.430	2.012	2.012
EXTREME SPREAD	:	3.432	2.969	2.328
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		8	

15 Sep 1994

FILE:/PATTERNING/CENTERFIRE_PATT/C8225315

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1in = 2

2in = 4

3in = 8

HS= 2.989

VS= 2.386

GS= 3.286

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.682	1.254	1.083
MINIMUM X	:	-1.307	-1.120	-.963
MAXIMUM Y	:	1.053	.907	.722
MINIMUM Y	:	-1.333	-1.479	-.753
CENTROID X	:	.192	.005	-.152
CENTROID Y	:	.050	.196	.381
POA TO CENTROID in.	:	.198	.196	.410
MIN RADIUS	:	.361	.307	.193
MEAN RADIUS	:	1.093	.927	.750
MAX RADIUS	:	2.135	1.939	1.223
HORIZONTAL SPREAD	:	2.989	2.374	2.046
VERTICAL SPREAD	:	2.386	2.386	1.475
EXTREME SPREAD	:	3.286	2.817	2.184
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	

15 Sep 1994

FILE:/PATTERNING/CENTERFIRE_PATT/CG225315

CENTERFIRE PATTERNS # 4

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 1

2in = 6

3in = 8

HS= 1.780

VS= 3.143

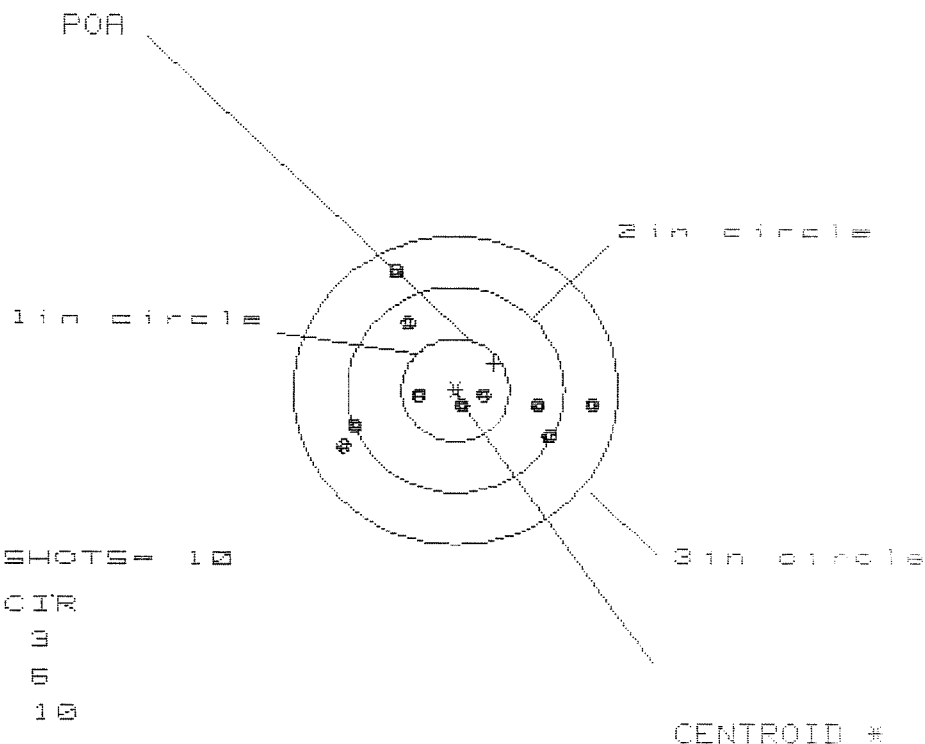
GS= 3.412

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.989	1.048	.957
MINIMUM X	:	-.791	-.732	-.689
MAXIMUM Y	:	1.381	1.185	.728
MINIMUM Y	:	-1.762	-1.357	-1.209
CENTROID X	:	.059	-.000	.091
CENTROID Y	:	.078	.274	.126
POA TO CENTROID in.	:	.098	.274	.155
MIN RADIUS	:	.365	.223	.311
MEAN RADIUS	:	.991	.841	.799
MAX RADIUS	:	1.842	1.393	1.218
HORIZONTAL SPREAD	:	1.780	1.780	1.646
VERTICAL SPREAD	:	3.143	2.542	1.937
EXTREME SPREAD	:	3.412	2.723	2.037
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

15 Sep 1994

FILE:/PATTERNING/CENTERFIRE_PATT/C8225315

CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1in = 3

2in = 6

3in = 10

HS= 2.337

VS= 1.664

GS= 2.367

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.282	1.031	.987
MINIMUM X	-1.055	-.913	-.957
MAXIMUM Y	1.151	1.136	.816
MINIMUM Y	-.513	-.528	-.386
CENTROID X	-.359	-.501	-.457
CENTROID Y	-.258	-.243	-.385
POA TO CENTROID in.	.442	.557	.598
MIN RADIUS	.142	.232	.146
MEAN RADIUS	.800	.746	.672
MAX RADIUS	1.289	1.190	1.048
HORIZONTAL SPREAD	2.337	1.944	1.944
VERTICAL SPREAD	1.664	1.664	1.202
EXTREME SPREAD	2.367	2.141	1.944
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	10		

CONTRACT # DAAA21-87-C-0086

New Barrel

GUN SERIAL # C6225315

OP. #	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and Stock		9/1/94	RW
600	Proof		9/1/94	RW
607	Check Headspace		9/1/94	RW
610	Dis-assemble Gun		9/1/94	RW
612	Magnaflux Barrel Action			
	Magnaflux Bolt			
615	Rollmark Caliber			
617	Drill and Tap Sight Holes			
618	Polish Barrel			
620	Apply Coatings (Barrel Action)			
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		9/13/94	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		9/13/94	RW
	C) Inspect Ejector Hole for Chamfer		9/13/94	RW
	D) Oil Firing Pin Ass'y		9/13/94	RW
	E) Adjust Trigger Pull to Min Setting and Stake		9/13/94	RW

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force							
	G) Safety Off Force							
	H) Trigger Pull Test & Retainability							
	I) Firing Pin Indent							
	J) Assemble Stock							
	K) Assemble Swivel Studs							
	L) Attach Front and Rear Sight Assemblies							
	M) Iron Sight Alignment							
	N) Detach Front & Rear Sights & place in numbered container							
	O) Attach Scope to Rifle							
	P) Detach & Attach Scope 20 Times							
640	Gallery Target & Test						9/13 OK	WB
	A) Time						9/13	WB
	B) Malfunctions						9/13 OK	WB
	C) Pierced Primers						9/13 OK	WB
	D) Optical Clarity of Scope						9/13 OK	WB
645	Inspect for Live Ammo						9/13/94	RW
655	Final Inspection						9/14/94	RW
	A) Headspace						9/14/94	RW
	B) Trigger Pull	2.49	2.63	2.77	2.59	2.66	9/14/94	RW
	C) Function						9/14/94	RW
660	Pack							

BBL - 96003
Bolt - 96005
New Trig Assy - 96024

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: **RE00009402** Serial: C6225315 Model 700 Center Fire Caliber: 7.62 NATO M-24 [SWS] Repairman: Status: New 5/18/00 8:38:46 AM

Address Information

Customer: ☒ Received From Return To: ☒ Received From

Name: DEF DIST DEPOT ANNISTON DEF DIST DEPOT ANNISTON

Address 1: Address 2: PO Box: PO Box:

City: ANNISTON ANNISTON

State: AL Zip Code: 362014199 Country: US State: AL Zip Code: 362014199 Country: US

FFL: ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐

Contact / Condition Problems Estimate History / Status Shipping / Billing

Contact Information

Phone: Fax: Email: Comments:

Received Condition

Poor

Condition Notes: CSR Notes:

Accessories Received

Code	Desc	Qty
A007	With Stud	2
A008	With Swivel	2
A010	Hard Case	1
A017	Scope Base	1

Repair Search Refresh Close

naglej 5/18/00 12:14 PM CAPS NUM INS SCRL

Start Inb... Micr... SA... Nag... Audit R&... Ar... Prin... Re... 12:14 PM

Serial Number: **C6225315**

Model: **700**



RE00009402

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

SERIAL NO. C6225315
DATE 7/14-00
TESTER FW

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#	COMMENTS
PULL #1	2.67	2.30	2.23	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.76	2.31	2.26	
PULL #3	2.78	2.32	2.03	
PULL #4	2.60	2.40	2.15	
PULL #5	2.93	2.37	2.00	
TOTAL	13.74	11.70	10.67	
AVG.	2.75	2.34	2.13	

	3.00# INITIAL	3.00# AFTER 20 CYCLES	COMMENTS
PULL #1	3.40	3.34	
PULL #2	3.38	3.35	
PULL #3	3.44	3.41	
PULL #4	3.38	3.36	
PULL #5	3.49	3.06	
TOTAL	17.09	16.52	
AVG.	3.42	3.30	

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.02	4.34		3.99
PULL #2	4.03	4.18		4.01
PULL #3	4.00	4.13		4.06
PULL #4	4.05	4.05		3.87
PULL #5	3.95	4.03		4.02
TOTAL	20.05	20.70		19.95
AVG.	4.01	4.15		3.99

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

R & E NUMBER			
SERIAL NUMBER <i>C6225315</i>			
LOG-IN DATE <i>5-11-00</i>			
INSPECT AND VERIFY:			
OPERATION #	OPERATION NAME	DATE	INITIAL
550	DIS-ASSEMBLE GUN	<i>5-15-00</i>	<i>RW</i>
560 A	RE-BARREL AT CUSTOM SHOP		
B	DRILL AND TAP		
C	POLISH		
575	ASSEMBLE		
600	PROOF	<i>5-22-00</i>	<i>RW</i>
605	CHECK HEADSPACE	<i>5-22-00</i>	<i>RW</i>
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	<i>5-20-00</i>	<i>RW</i>
655	FINAL INSPECT	<i>5-25-00</i>	<i>RW</i>
660	PACK		
		SHIP DATE	
		QAR INSPECTION DATE	

Final Inspection

S.N.

DATE REC'D:

DATE RET'D:

AUDITOR: *RLW*

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:

Remington Test Lab, Ilion, N.Y.

Centroidal distance calculations for Rifle # c6225315
17 Jul 2000

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1068
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1662
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .197557

THE AMR FOR THIS RIFLE IS: 1.21

CENTROIDAL DISTANCES

0 TO	1	.316183
1 TO	2	.301955
1 TO	3	.0800562
1 TO	4	.608905
1 TO	5	.807965

4
+ <----POA
3 2 5

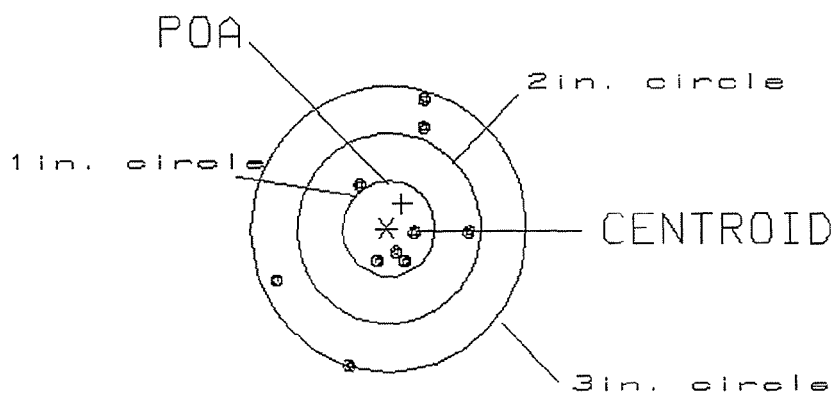
PATTERN #: ☐ 1 ☐

POA TO CENTROID: .316
 MIN RADIUS : .224
 MEAN RADIUS : .804
 MAX RADIUS : 1.480
 CENTROID X : -.174
 CENTROID Y : -.264

17 Jul 2000

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6225315.1

CENTERFIRE PATTERN # 1



OF SHOTS= 10

IN CIRCLE

HS= 2.18

4

VS= 2.77

6

GS= 2.87

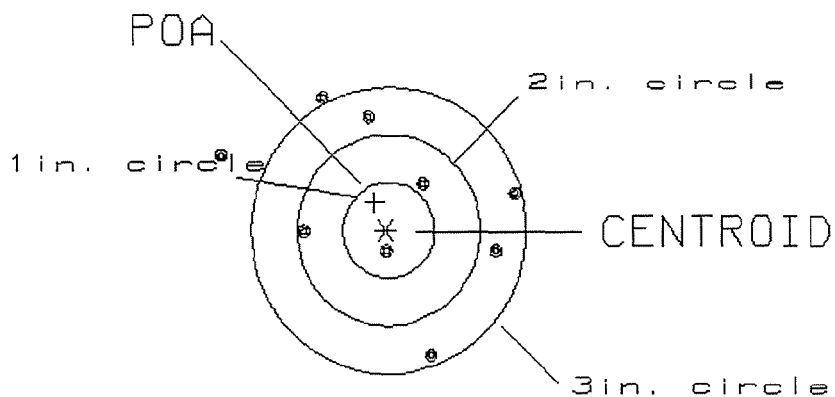
10

PATTERN #: ☐ 2 ☐
 POA TO CENTROID: .315
 MIN RADIUS : .195
 MEAN RADIUS : 1.313
 MAX RADIUS : 2.560
 CENTROID X : .127
 CENTROID Y : -.288

17 Jul 2000

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6225315.1

CENTERFIRE PATTERN # 2



OF SHOTS= 10

IN CIRCLE

HS= 3.26

1

VS= 3.96

3

GS= 4.08

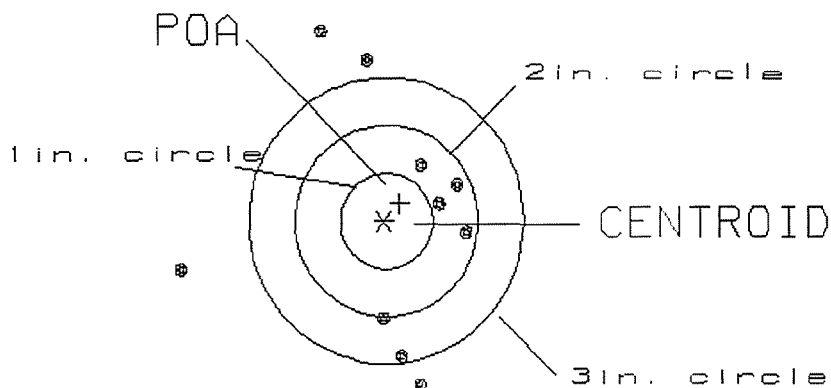
7

PATTERN #: ☐ 3 ☐
 POA TO CENTROID: .251
 MIN RADIUS : .633
 MEAN RADIUS : 1.342
 MAX RADIUS : 2.262
 CENTROID X : -.171
 CENTROID Y : -.184

17 Jul 2000

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6225315.1

CENTERFIRE PATTERN # 3



OF SHOTS= 10

IN CIRCLE

HS= 3.12

0

VS= 3.67

4

GS= 3.81

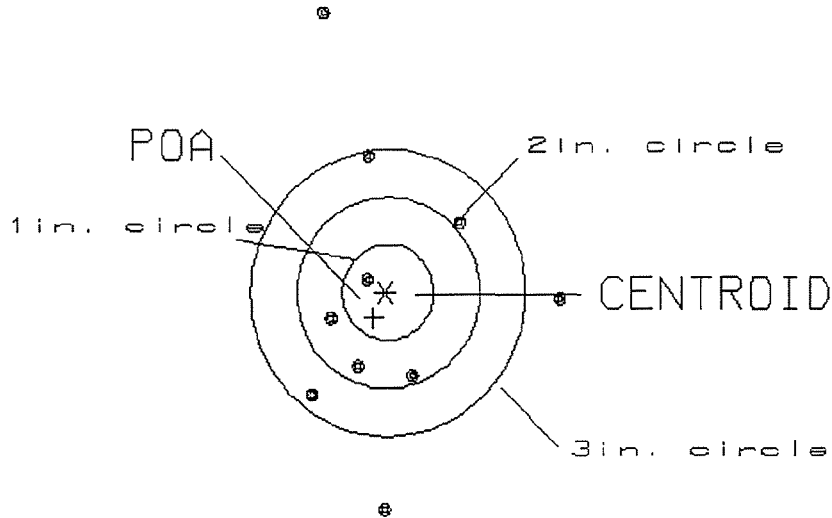
6

PATTERN #: ☐ 4 ☐
 POA TO CENTROID: .294
 MIN RADIUS : .271
 MEAN RADIUS : 1.367
 MAX RADIUS : 3.001
 CENTROID X : .124
 CENTROID Y : .267

17 Jul 2000

FILE:/Hqbasic/Accuracy/Patterning/Centerfire_Patt/c6225315.1

CENTERFIRE PATTERN # 4



OF SHOTS= 10

IN CIRCLE

HS= 2.70

1

VS= 5.16

4

GS= 5.21

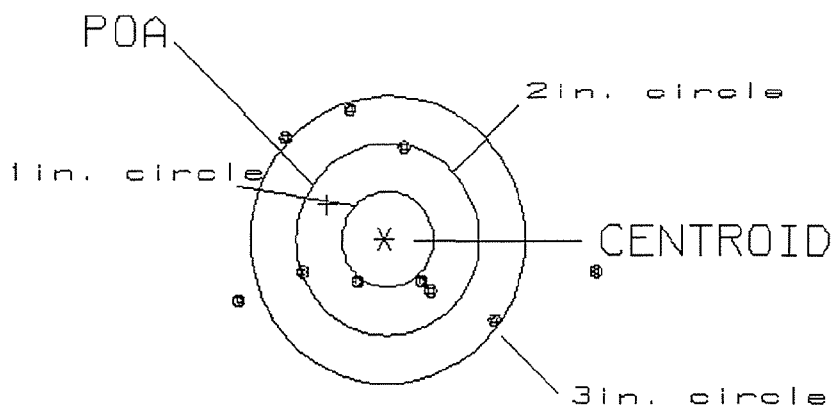
7

PATTERN #: ☐ 5 ☐
 POA TO CENTROID: .725
 MIN RADIUS : .517
 MEAN RADIUS : 1.222
 MAX RADIUS : 2.268
 CENTROID X : .628
 CENTROID Y : -.362

17 Jul 2000

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6225315.1

CENTERFIRE PATTERN # 5



OF SHOTS= 10

IN CIRCLE

HS= 3.90

0

VS= 2.16

5

GS= 3.92

7

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: RE00131878

Serial: C6225315 Model M24 SWS Center Fire
Caliber: 7.62 NATO

Repairman:

Verify Repair

Status:

Closed 7/30/2007 10:55:35 AM

Address Information

Customer:

Received From

Return To:

Received From

Name: A CO 1/10SF BN

A CO 1/10SF BN

Address 1: PANZER KASERNE

PANZER KASERNE

Address 2: APO

PO Box:

APO

PO Box:

City: WH0940

WH0940

State: AE

Zip Code: 09107

Country: IT

State: AE

Zip Code: 09107

Country: IT

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
A007	With Stud	3
A057	Fit and Rear Sgt Base	1

Repair Search

Refresh

Close

naglet

7/30/2007

12:50 PM

CAPS

NUM

INS

SCRL

start

4 Micro...

6 Inter...

RAC0179...

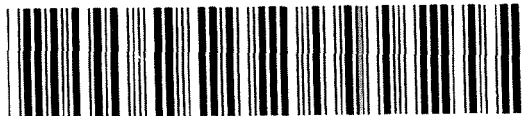
Part Sear...

Arms Ser...

12:50 PM

Serial Number: C6225315

Model: M24 SWS



RE00131878

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6225315.___0
FILE DATE AND TIME: 09/26/2007 07:40

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.020
The Average Y Centroid of the Five Target Set:	-0.092
The Average Point of Impact of the Five Target Set:	0.094
The Average Mean Radius of the Five Target Set:	0.759
The Distance from POA to Centroid Target #1:	0.206
The Distance from Centroid Target #2 to Centroid Target #1:	0.232
The Distance from Centroid Target #3 to Centroid Target #1:	0.358
The Distance from Centroid Target #4 to Centroid Target #1:	0.331
The Distance from Centroid Target #5 to Centroid Target #1:	0.359

SERIAL NUMBER: C6225315. __0

TARGET NUMBER: 1

FILE DATE: 09/26/2007

FILE TIME: 07:40

POINT#	X	Y
1:	2.270	0.076
2:	0.551	-0.460
3:	0.372	-0.584
4:	-0.248	-0.693
5:	0.266	1.033
6:	-1.174	1.228
7:	-0.393	0.413
8:	-0.315	0.013
9:	0.437	-0.031
10:	0.160	-0.259

X CENTROID: 0.193

Y CENTROID: 0.074

POA TO CENTROID: 0.206

HORZ SPREAD: 3.444

VERT SPREAD: 1.921

GROUP SPREAD: 3.632

MIN RADIUS: 0.266

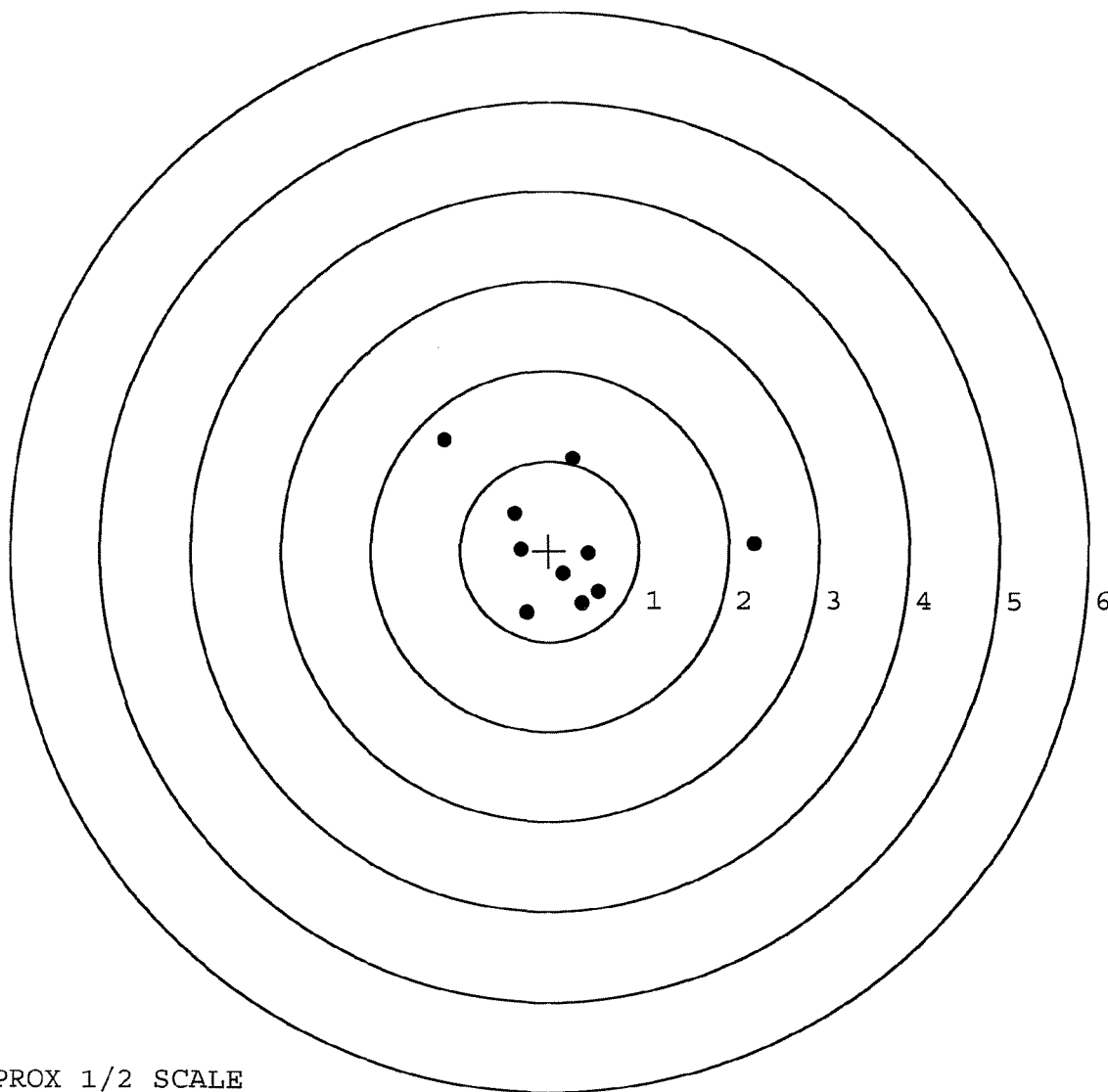
MAX RADIUS: 2.077

MEAN RADIUS: 0.883

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 8



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6225315. 0

TARGET NUMBER: 2

FILE DATE: 09/26/2007

FILE TIME: 07:40

POINT#	X	Y
1:	0.748	-0.802
2:	0.194	-0.989
3:	-0.117	-0.838
4:	0.185	-0.313
5:	0.518	0.237
6:	0.017	1.085
7:	-0.859	0.100
8:	0.134	0.212
9:	-0.143	0.113
10:	-0.038	0.006

X CENTROID: 0.064

Y CENTROID: -0.119

POA TO CENTROID: 0.135

HORZ SPREAD: 1.607

VERT SPREAD: 2.074

GROUP SPREAD: 2.082

MIN RADIUS: 0.161

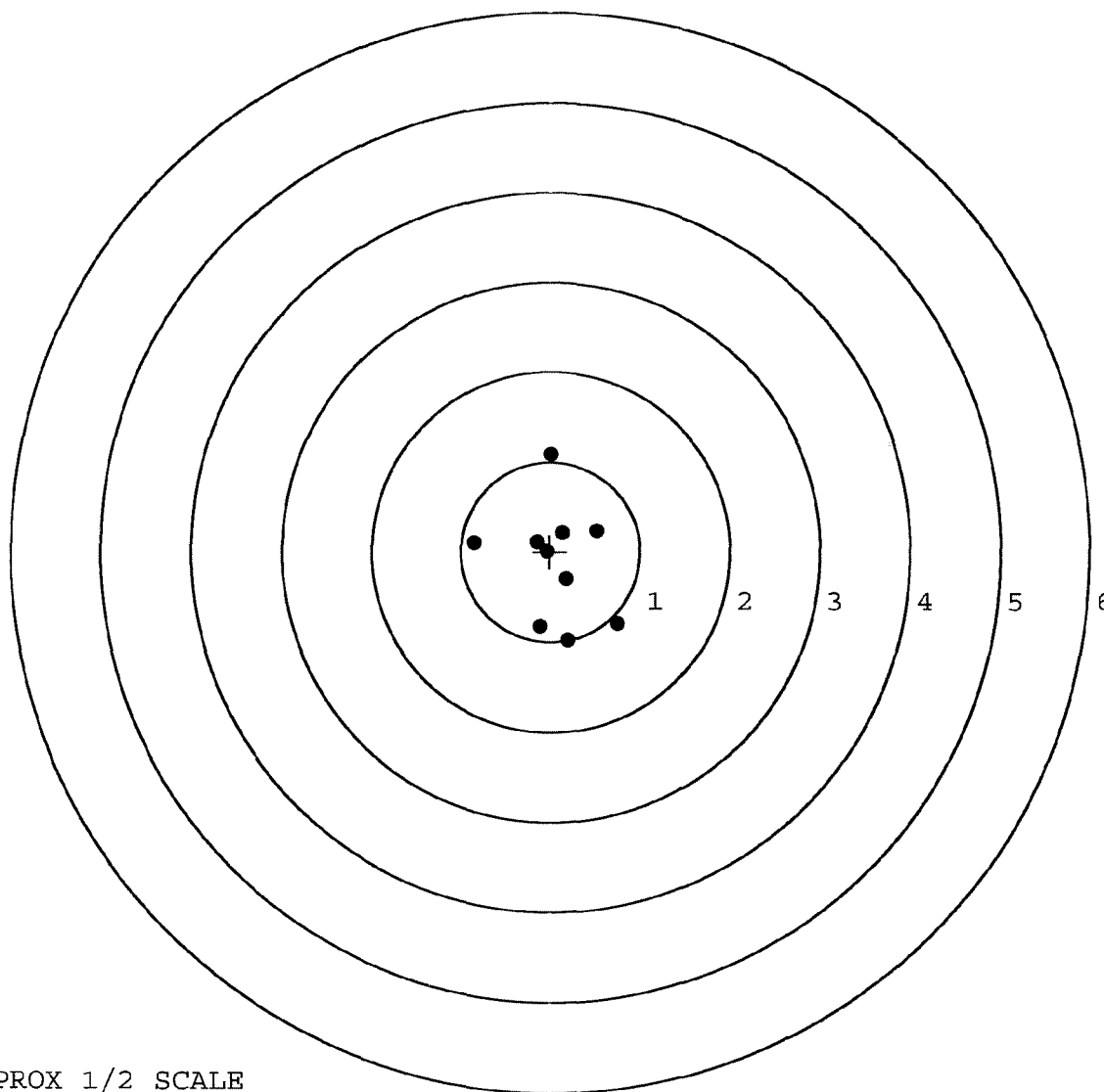
MAX RADIUS: 1.205

MEAN RADIUS: 0.636

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6225315. 0

TARGET NUMBER: 3

FILE DATE: 09/26/2007

FILE TIME: 07:40

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

1:	-1.026	0.328
----	--------	-------

2:	-0.735	0.290
----	--------	-------

3:	-0.753	-0.495
----	--------	--------

4:	-0.156	-0.210
----	--------	--------

5:	-0.263	0.340
----	--------	-------

6:	0.530	0.058
----	-------	-------

7:	0.355	-0.321
----	-------	--------

8:	1.175	-0.244
----	-------	--------

9:	0.873	-0.650
----	-------	--------

10:	-0.187	-1.244
-----	--------	--------

X CENTROID: -0.019

Y CENTROID: -0.215

POA TO CENTROID: 0.216

HORZ SPREAD: 2.201

VERT SPREAD: 1.584

GROUP SPREAD: 2.274

MIN RADIUS: 0.137

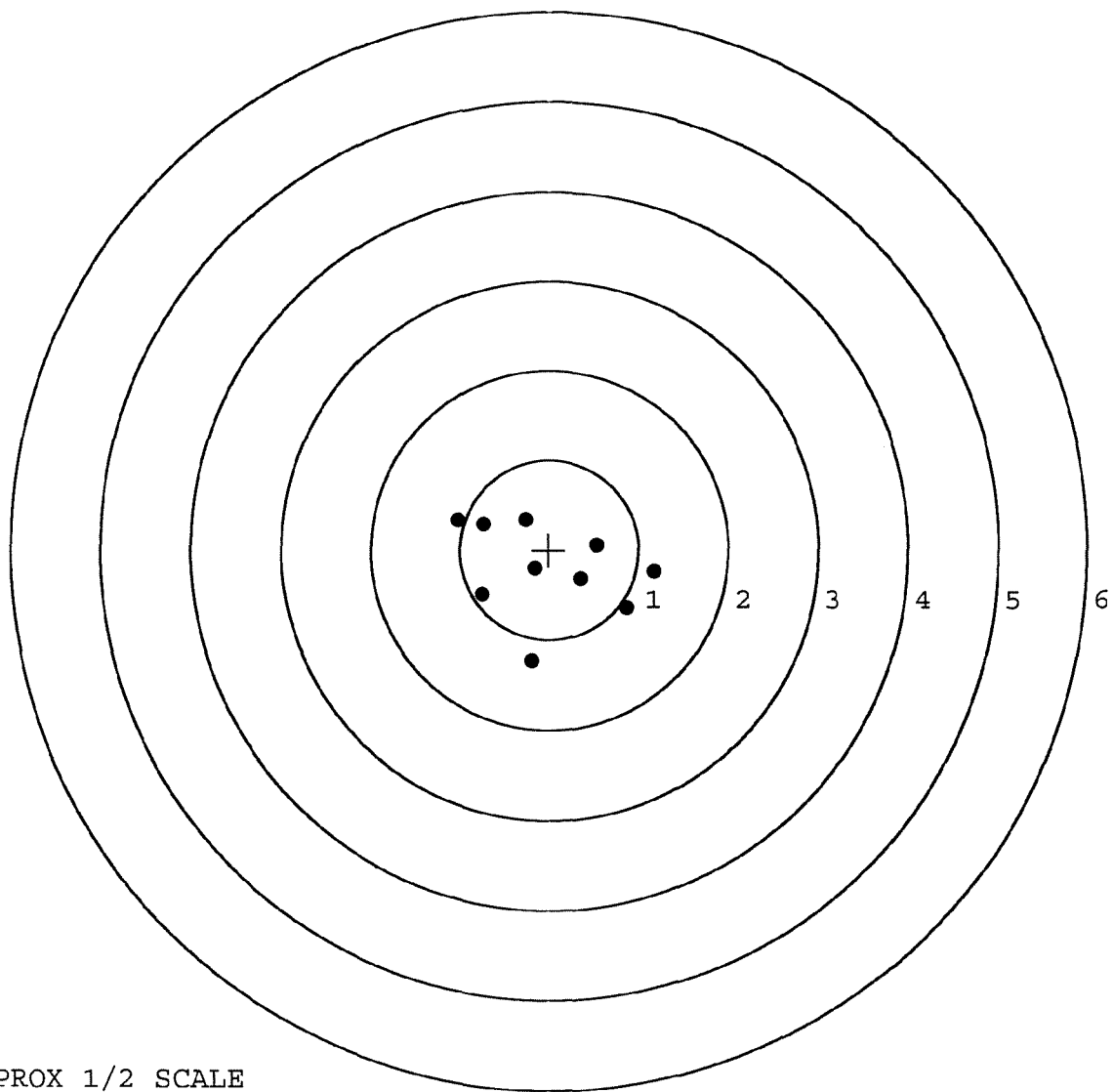
MAX RADIUS: 1.194

MEAN RADIUS: 0.778

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6225315. 0

TARGET NUMBER: 4

FILE DATE: 09/26/2007

FILE TIME: 07:40

POINT#	X	Y
1:	0.387	-1.556
2:	0.000	-1.393
3:	-0.407	-1.194
4:	-0.120	-0.237
5:	0.098	-0.210
6:	0.527	1.269
7:	0.156	0.697
8:	-0.031	0.318
9:	-0.672	0.126
10:	0.271	0.088

X CENTROID: 0.021

Y CENTROID: -0.209

POA TO CENTROID: 0.210

HORZ SPREAD: 1.199

VERT SPREAD: 2.825

GROUP SPREAD: 2.828

MIN RADIUS: 0.077

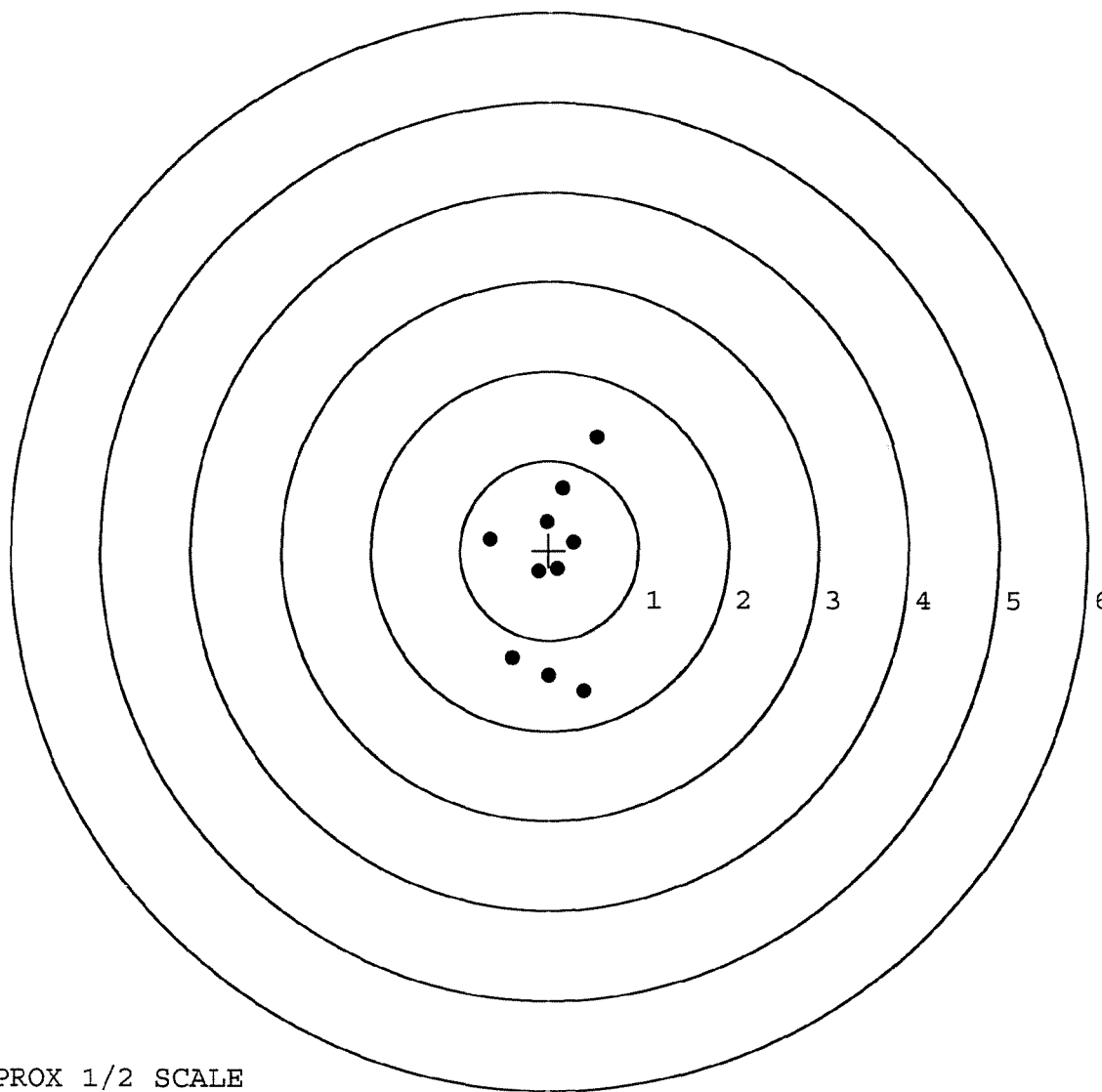
MAX RADIUS: 1.562

MEAN RADIUS: 0.804

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6225315. 0

TARGET NUMBER: 5

FILE DATE: 09/26/2007

FILE TIME: 07:40

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

1:	0.682	-0.798
----	-------	--------

2:	0.481	-0.394
----	-------	--------

3:	-1.217	-0.665
----	--------	--------

4:	-0.415	-0.181
----	--------	--------

5:	0.051	-0.092
----	-------	--------

6:	-1.116	1.010
----	--------	-------

7:	-0.371	0.409
----	--------	-------

8:	0.334	0.474
----	-------	-------

9:	0.064	0.462
----	-------	-------

10:	-0.095	-0.153
-----	--------	--------

X CENTROID: -0.160

Y CENTROID: 0.007

POA TO CENTROID: 0.160

HORZ SPREAD: 1.899

VERT SPREAD: 1.808

GROUP SPREAD: 2.550

MIN RADIUS: 0.173

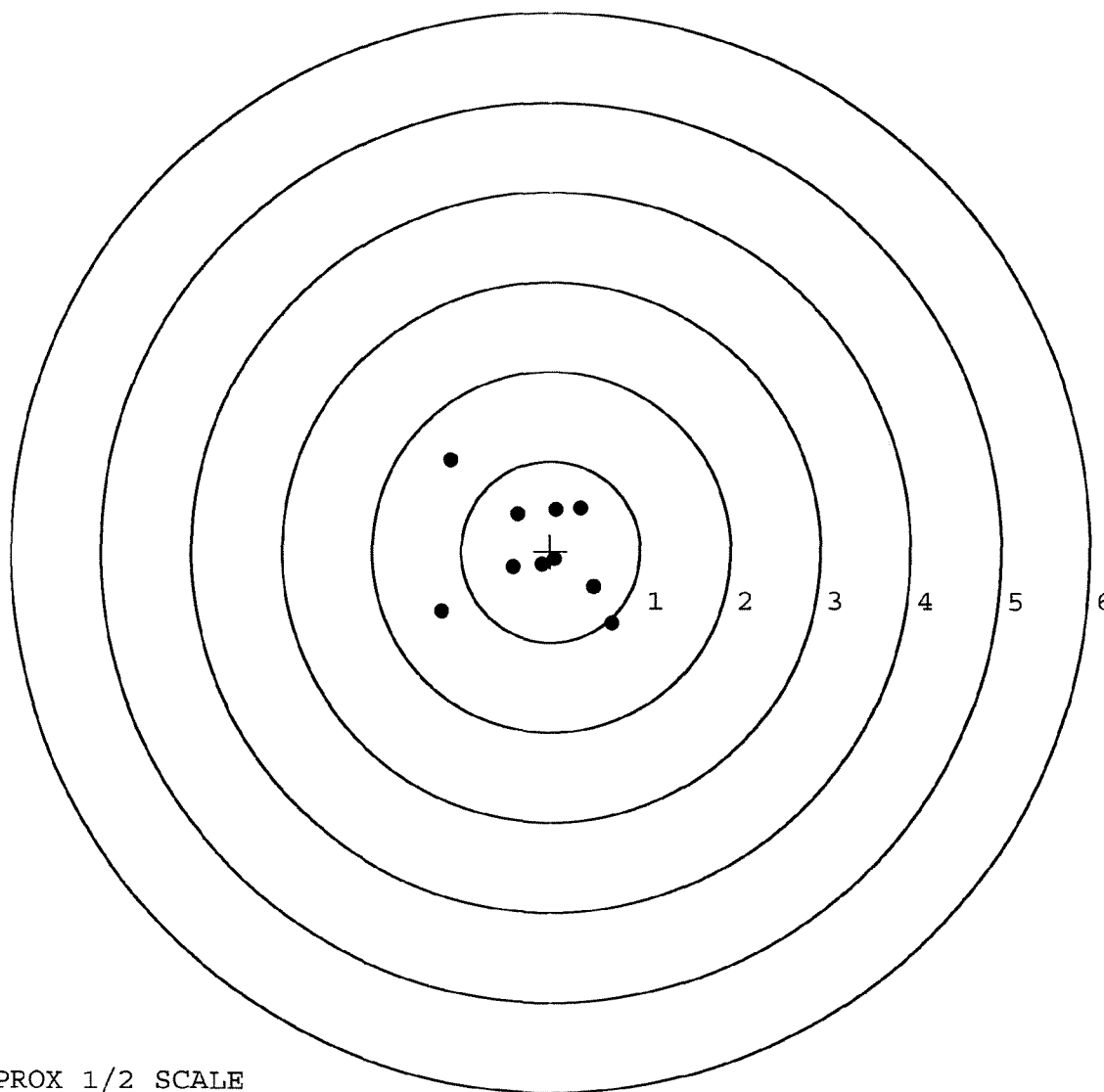
MAX RADIUS: 1.385

MEAN RADIUS: 0.692

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

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

R & E NUMBER 131878

SERIAL NUMBER C6225315

LOG-IN DATE 7-30-07

OPERATION #	OPERATION NAME		DATE	INITIAL
500	DIS-ASSEMBLE GUN		8-27-07	RTZ
505	RE-BARREL		9-14-07	RTZ
560	ASSEMBLE		9-14-07	RTZ
600	PROOF	MAGNA - FLUX	9-14-07	mm
605	CHECK HEADSPACE	SEP 18 2007	9-14-07	mm
610	DIS-ASSEMBLE GUN		9-17-07	TRW
612	MAGNAFLUX	OPERATOR NR8	9-18-07	NR8
510	DRILL AND TAP		9-17-07	TRW
615	ROLLMARK CALIBER		9-17-07	CW
618	ROTO-BLAST		9-18-07	PC
620	APPLY COATINGS		9-21-07	TRZ
625	FINAL ASSEMBLY		9-25-07	RTZ
640	FUNCTION TEST AND	PASS FAIL	9-25-07	mm
650	TARGET	PASS FAIL	9-25-07	mm
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
670	FINAL INSPECTION		9-25-07	SD
	A) HEADSPACE	PASS FAIL	9-27-07	mm
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	2.60 2.58 2.69 2.60 2.62 9-26-07	DA
680	F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX	50 50 50 9-26-07	DA
	G) SAFETY OFF FORCE	2 LBS MIN	25 25 25 9-26-07	DA
	I) FIRING PIN INDENT	.020	023 1022 1.0225 9-26-07	DA
690	PACK		10-4-07	DA