

06594490

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

Remington

Remington

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: **RE00036710** Serial: C6594490 Model 700 Center Fire Caliber: 7.62 NATO SWS M24 WOG 7 of 7 Repairman: Status: Closed 12/1/01 6:32:56 AM

Verify Repair **High Priority**

Address Information

Customer: Received From Return To: Received From

Name: Address 1: Address 2: PO Box: City: FORT BRAGG State: NC Zip Code: Country: US

FFL:

History / Status

Date	Code	User ID	Desc1
12/1/01 6:25:22	New	urtzdj	Repair Added
12/1/01 6:32:56	Closed	urtzdj	

Shipping / Billing

Current Status

Shipping Hold ☐ InterFace Hold ☐ Estimate Sent ☐ Parts Received ☐ Passed Inspection ☐ Return As Received ☐ Has been Approved ☐ Internal Repair ☐

Closed
12/1/01 6:32:56 AM
urtzdj
Check In

Repair Location
ILN
Current Location
ILN

Repair Search Refresh Close

Start Inb... CN... S... Isra... S... Ar... Ser... Cal... 11:20 AM

Serial Number: **C6594490**

Model: **700**



RE00036710

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

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

SERIAL NO. _____

DATE 10/31/01

TESTER DM

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#	COMMENTS
PULL #1	2.40	1.79	2.11	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.53	1.81	2.19	
PULL #3	2.35	1.74	2.22	
PULL #4	2.56	1.69	2.16	
PULL #5	2.40	1.91	2.21	
TOTAL	12.24	8.94	10.89	
AVG.	2.45	1.79	2.18	

	3.00# INITIAL	3.00# AFTER 20 CYCLES	COMMENTS
PULL #1	3.01	3.07	
PULL #2	3.16	3.15	
PULL #3	3.18	2.98	
PULL #4	3.05	2.89	
PULL #5	3.15	3.11	
TOTAL	15.55	15.20	
AVG.	3.11	3.04	

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.07	3.75		4.63
PULL #2	3.81	4.08		4.66
PULL #3	4.03	3.96		4.69
PULL #4	4.02	3.97		4.64
PULL #5	3.99	3.90		4.63
TOTAL	19.92	19.66		23.25
AVG.	3.98	3.93		4.65

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

R & E NUMBER	36710		
SERIAL NUMBER	C6594490		
LOG-IN DATE	12-1-01		
INSPECT AND VERIFY:			
OPERATION #	OPERATION NAME	DATE	INITIAL
550	DIS-ASSEMBLE GUN	12-4-01	RH
560 A	RE-BARREL	12/5/01	BWT
B	DRILL AND TAP	12/5/01	BWT
575	ASSEMBLE	12-6-01	RH
600	PROOF	12-6-01	RH
605	CHECK HEADSPACE	12-6-01	RH
610	DIS-ASSEMBLE GUN	12-6-01	RH
612	MAGNAFLUX		AL
615	ROLLMARK CALIBER	12-6-01	RH
618	ROTO-BLAST	12/7	KO
620	APPLY COATINGS	12-10	HA
625 A	FINAL ASSEMBLY	12-17-01	RH
B	TRIGGER PULL TEST		
C	SAFETY "ON" FORCE		
D	SAFETY "OFF" FORCE		
E	FIRING PIN INDENT		
640	TARGET	12-17-01	AC
655	FINAL INSPECT	12-18-01	RH
660	PACK	12/19/01	DA
		SHIP DATE	
	QAR INSPECTION DATE		

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6594490.__0
FILE DATE AND TIME: 12/17/2001 07:10

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.035
The Average Y Centroid of the Five Target Set:	-0.092
The Average Point of Impact of the Five Target Set:	0.099
The Average Mean Radius of the Five Target Set:	0.575
The Distance from POA to Centroid Target #1:	0.069
The Distance from Centroid Target #2 to Centroid Target #1:	0.138
The Distance from Centroid Target #3 to Centroid Target #1:	0.139
The Distance from Centroid Target #4 to Centroid Target #1:	0.187
The Distance from Centroid Target #5 to Centroid Target #1:	0.141

SERIAL NUMBER: C6594490. __0

TARGET NUMBER: 1

FILE DATE: 12/17/2001

FILE TIME: 07:10

X CENTROID: -0.018

Y CENTROID: -0.066

POA TO CENTROID: 0.069

HORZ SPREAD: 0.836

VERT SPREAD: 1.293

GROUP SPREAD: 1.534

MIN RADIUS: 0.120

MAX RADIUS: 0.825

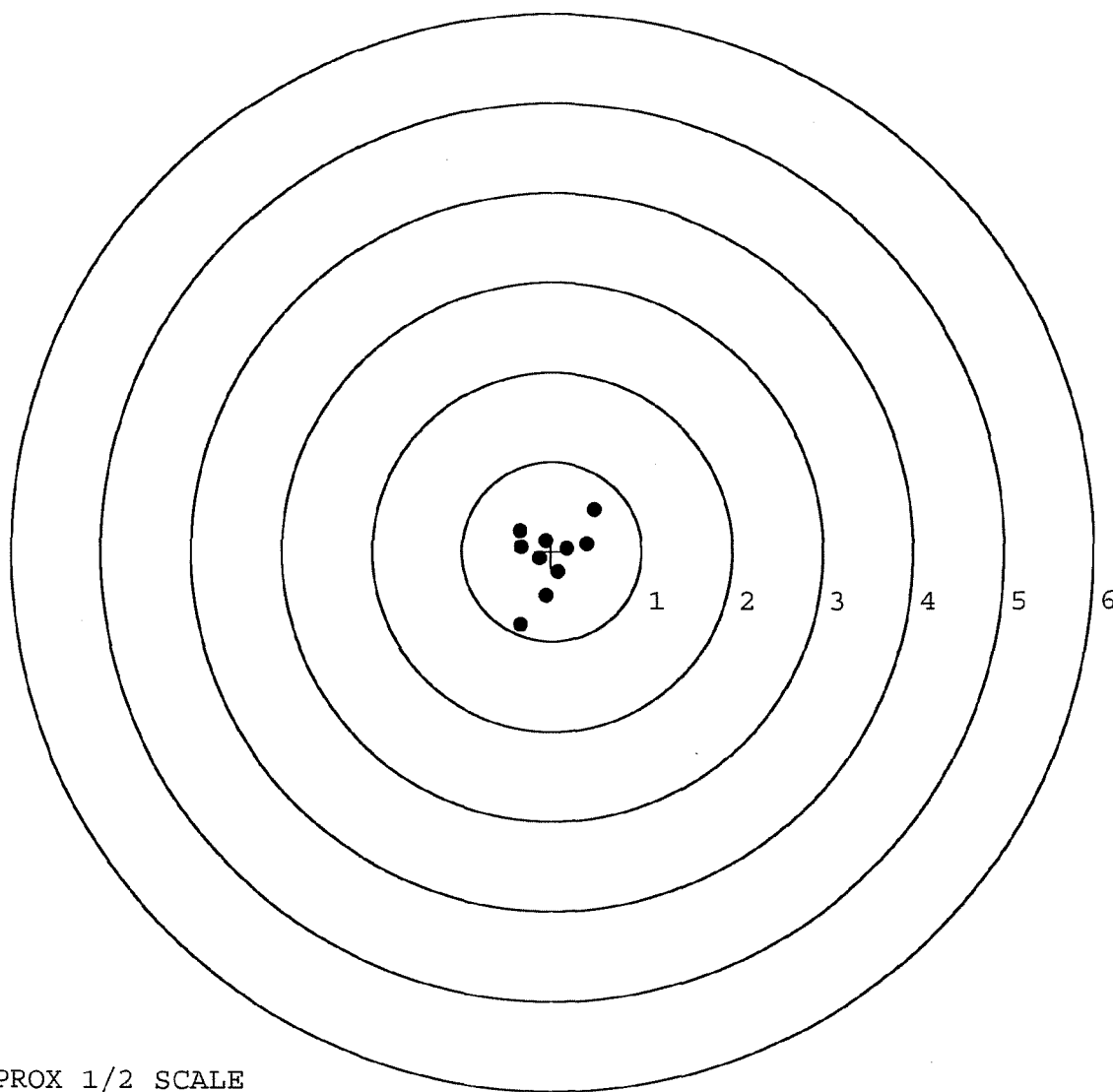
MEAN RADIUS: 0.396

IN 1 IN DIAMETER: 8

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.349	-0.822
2:	-0.064	-0.505
3:	0.079	-0.239
4:	0.396	0.091
5:	0.477	0.471
6:	0.176	0.030
7:	-0.137	-0.083
8:	-0.064	0.118
9:	-0.340	0.047
10:	-0.359	0.230



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6594490. __0

TARGET NUMBER: 2

FILE DATE: 12/17/2001

FILE TIME: 07:10

POINT#	X	Y
1:	-0.294	-1.131
2:	0.189	-1.005
3:	-0.210	-0.592
4:	0.626	-0.634
5:	0.355	0.178
6:	-0.217	0.411
7:	0.039	0.408
8:	0.135	0.616
9:	0.154	0.768
10:	-0.105	1.398

X CENTROID: 0.067

Y CENTROID: 0.042

POA TO CENTROID: 0.079

HORZ SPREAD: 0.920

VERT SPREAD: 2.529

GROUP SPREAD: 2.536

MIN RADIUS: 0.318

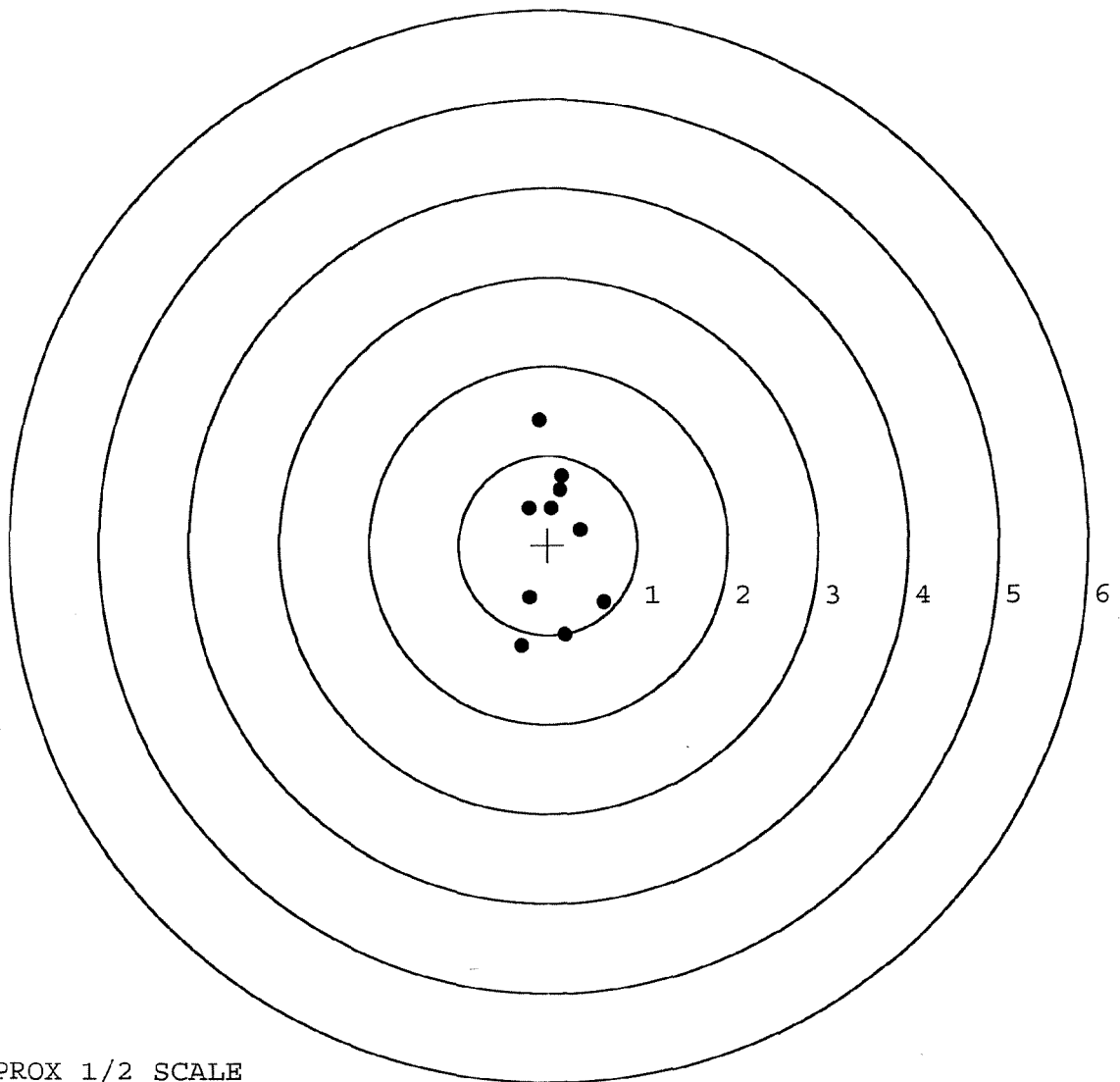
MAX RADIUS: 1.367

MEAN RADIUS: 0.768

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10

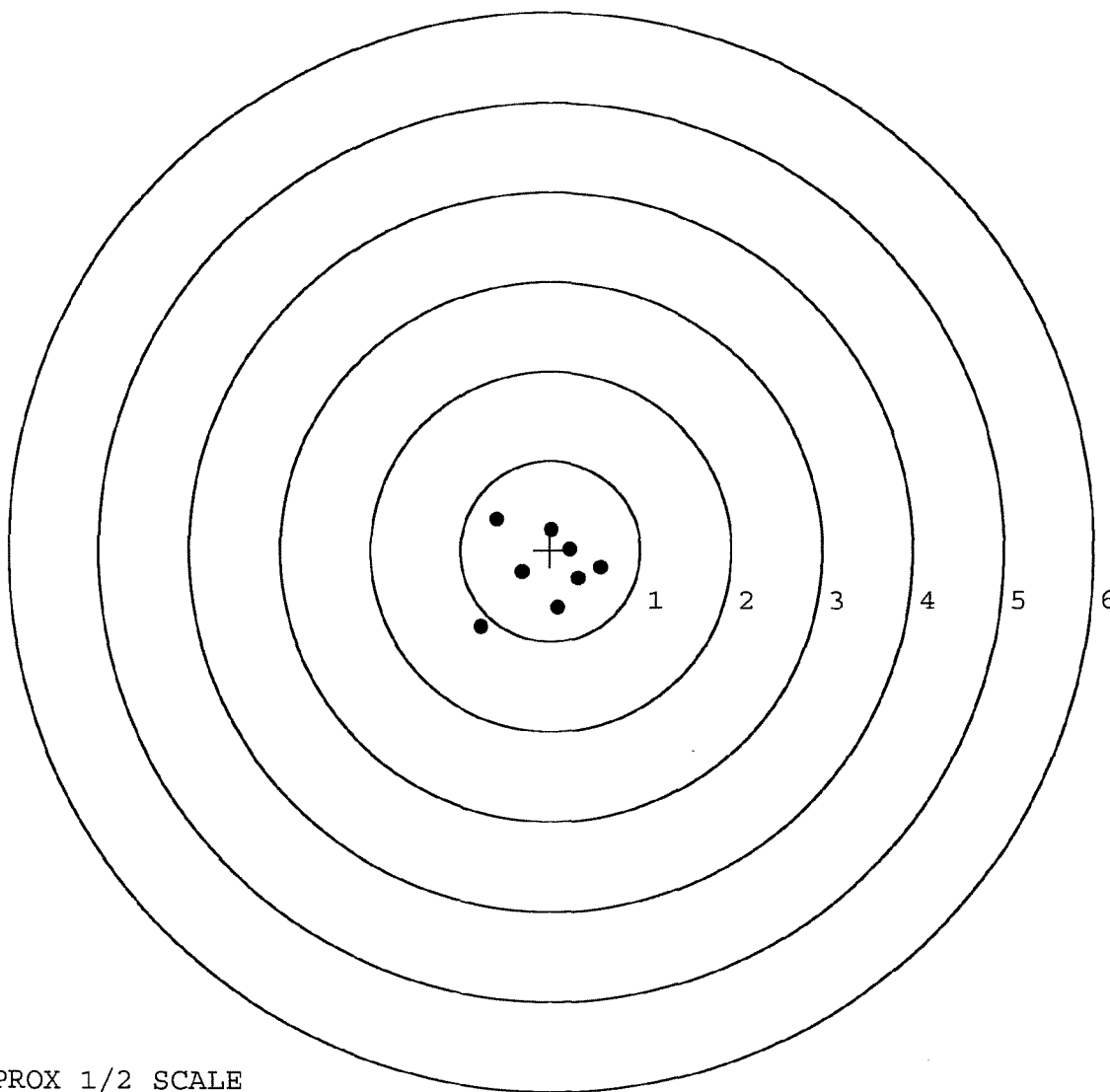


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6594490. 0
TARGET NUMBER: 3
FILE DATE: 12/17/2001
FILE TIME: 07:10

X CENTROID: -0.023
Y CENTROID: -0.205
POA TO CENTROID: 0.206
HORZ SPREAD: 1.345
VERT SPREAD: 1.198
GROUP SPREAD: 1.497
MIN RADIUS: 0.290
MAX RADIUS: 0.991
MEAN RADIUS: 0.512
IN 1 IN DIAMETER: 6
IN 2 IN DIAMETER: 10
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.779	-0.845
2:	-0.311	-0.240
3:	-0.314	-0.240
4:	0.082	-0.634
5:	0.316	-0.310
6:	0.566	-0.187
7:	0.566	-0.187
8:	0.226	0.013
9:	0.017	0.230
10:	-0.597	0.353



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6594490. 0

TARGET NUMBER: 4

FILE DATE: 12/17/2001

FILE TIME: 07:10

X CENTROID: 0.164

Y CENTROID: -0.024

POA TO CENTROID: 0.165

HORZ SPREAD: 1.579

VERT SPREAD: 2.094

GROUP SPREAD: 2.094

MIN RADIUS: 0.118

MAX RADIUS: 1.248

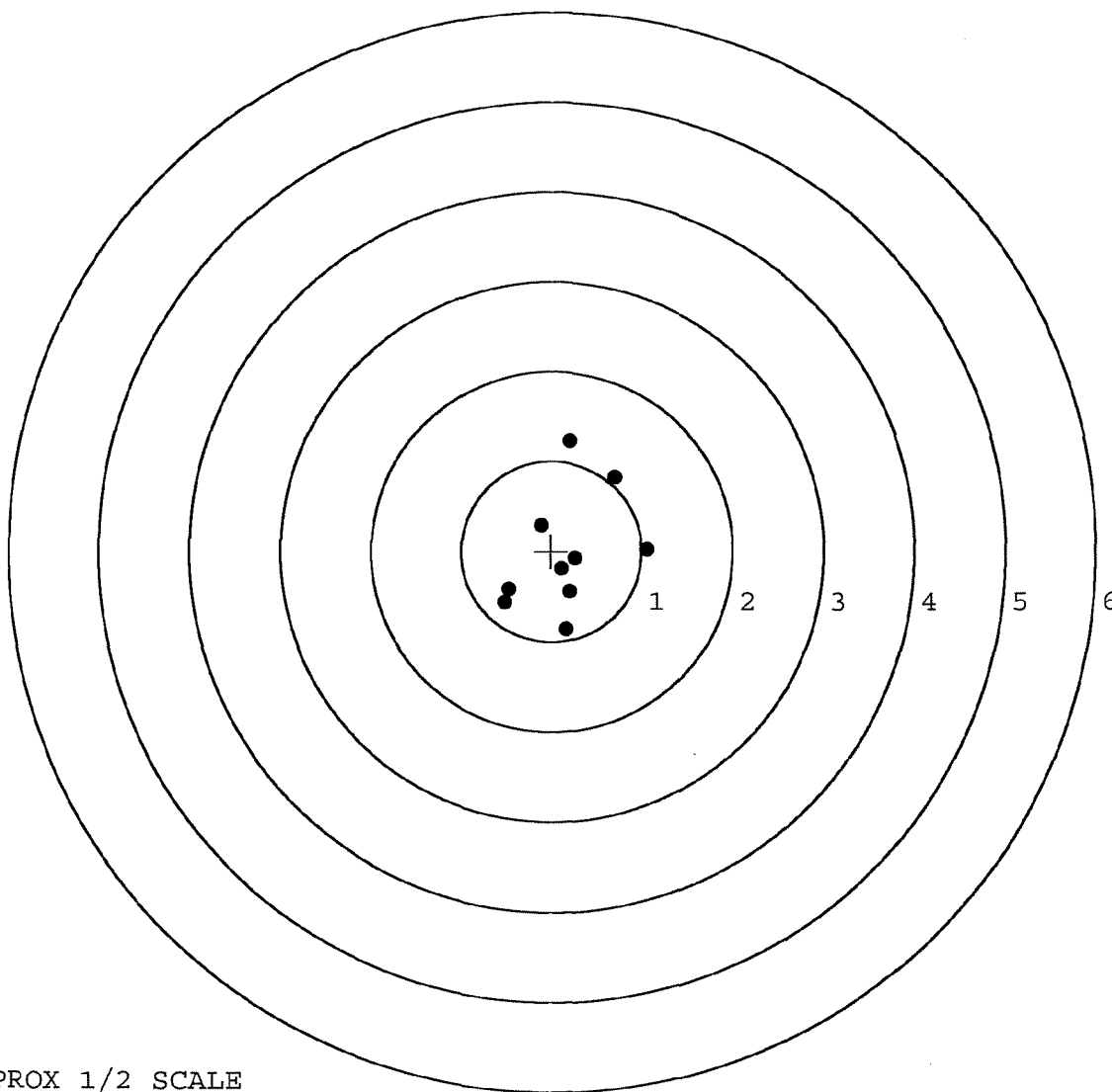
MEAN RADIUS: 0.677

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.170	-0.871
2:	-0.518	-0.567
3:	-0.472	-0.426
4:	0.213	-0.452
5:	0.119	-0.196
6:	0.268	-0.079
7:	1.061	0.025
8:	-0.120	0.281
9:	0.702	0.824
10:	0.212	1.223



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6594490.___0

TARGET NUMBER: 5

FILE DATE: 12/17/2001

FILE TIME: 07:10

X CENTROID: -0.015

Y CENTROID: -0.207

POA TO CENTROID: 0.208

HORZ SPREAD: 1.550

VERT SPREAD: 1.461

GROUP SPREAD: 1.805

MIN RADIUS: 0.124

MAX RADIUS: 1.262

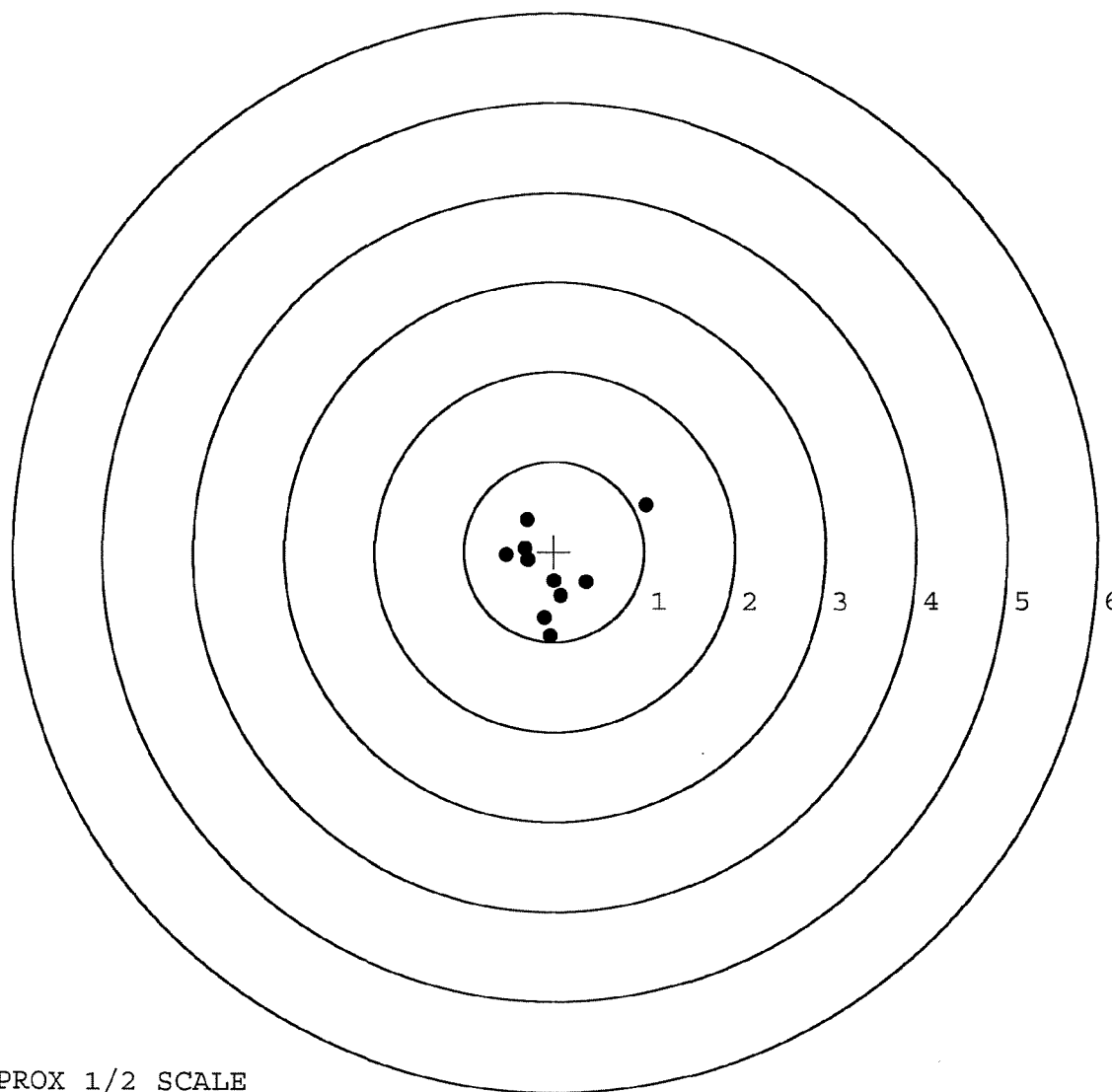
MEAN RADIUS: 0.524

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.043	-0.942
2:	-0.109	-0.741
3:	0.075	-0.494
4:	0.364	-0.343
5:	0.003	-0.330
6:	-0.292	-0.098
7:	-0.533	-0.036
8:	-0.326	0.035
9:	-0.303	0.355
10:	1.017	0.519



TARGET APPROX 1/2 SCALE

Remington
 MODEL 700™ M24

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

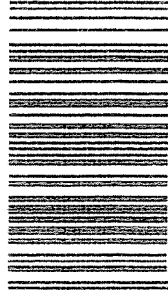
REG. U.S. PAT. & TM. OFF.

SERIAL NO.
 06594490

ORDER NO.
 5716

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

UPC



0 47700 25716 7



5716 06594490

TEST INIT. ACTION TO CORRECT		ASSEM. #
PROOF	<i>Shut 100 Rd</i> <i>test</i> <i>OK DH</i> <i>1-29-91</i>	
TEST ✓		
TGT		
PROOF		
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		

MOD.		GA. CAL.	GUN #	ASSEM. #
# TEST	DATE	MALFUNCTION/DEFECT		
	1st			
	1/16/91	shove brand ejector		PH
	2nd	POLISHED EJECTOR REP'D K.S.		1/17/91
	3rd			
	4th			
		FUNCTION		RD 6654 Rev 1

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C 6594490

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		10/31/90	KH
600	Proof		10/31/90	KH
607	Check Headspace		10/31/90	KH
610	Dis-assemble Gun		10/31/90	KH
612	Magnaflux Barrel Action		11/2/90	KCR
	Magnaflux Bolt		11/2/90	KCR
615	Rollmark Caliber		11/2/90	GS
617	Drill and Tap Sight Holes		11/5/90	FB
618	Polish Barrel RB		11/6/90	WB
620	Apply Coatings (Barrel Action)		11-26-90	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		12/28/90	K.S.
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		12/28/90	K.S.
	C) Inspect Ejector Hole for Chamfer		12/28/90	K.S.
	D) Oil Firing Pin Ass'y		12/28/90	K.S.
	E) Adjust Trigger Pull to Min Setting and Stake		1-3-91	JH

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4.50	4.25	4.50			1/2/91	KJ
	G) Safety Off Force	3.0	3.0	3.0			1/2/91	KJ
	H) Trigger Pull Test & Retainability						1-3-91	JH
	I) Firing Pin Indent	.020	.020	.020			1/2/91	KJ
	J) Assemble Stock						1-16-91	MS
	K) Assemble Swivel Studs						1-17-91	JH
	L) Attach Front and Rear Sight Assemblies						1-16-91	MS
	M) Iron Sight Alignment						1-16-91	MS
	N) Detach Front & Rear Sights & place in numbered container						1-16-91	MS
	O) Attach Scope to Rifle						1-16-91	MS
	P) Detach & Attach Scope 20 Times						1-16-91	MS
640	Gallery Target & Test						1-16-91	DH
	A) Time						1-16-91	DH
	B) Malfunctions						1-16-91	DH
	C) Pierced Primers						1-16-91	DH
	D) Optical Clarity of Scope						1-16-91	DH
645	Inspect for Live Ammo						1-16-91	DH
655	Final Inspection							
	A) Headspace						1-17-91	JH
	B) Trigger Pull	2.36	2.33	2.24	2.28	2.34	1-17-91	JH
	C) Function						1-17-91	JH
660	Pack						3-19-91	VF

SWS TRIGGER PULL TEST

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

SERIAL NO. C6594490

DATE 1-3-91

TESTER JEL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.37	2.44	2.44	2.36	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.29	2.41	2.44	2.33	
PULL #3	2.47	2.41	2.40	2.24	
PULL #4	2.42	2.41	2.38	2.28	
PULL #5	2.39	2.43	2.44	2.34	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.30	3.36		
PULL #2	3.20	3.20		
PULL #3	3.33	3.22		
PULL #4	3.34	3.32		
PULL #5	3.34	3.22		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.37	4.29		4.43
PULL #2	4.34	4.20		4.37
PULL #3	4.37	4.17		4.37
PULL #4	4.33	4.42		4.48
PULL #5	4.36	4.46		4.47
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6594490
17 Jan 1991

CENTROIDAL DISTANCES

Ø TO	1	.393548
1 TO	2	.572291
1 TO	3	.472547
1 TO	4	.413105
1 TO	5	.127988

PA <----POA

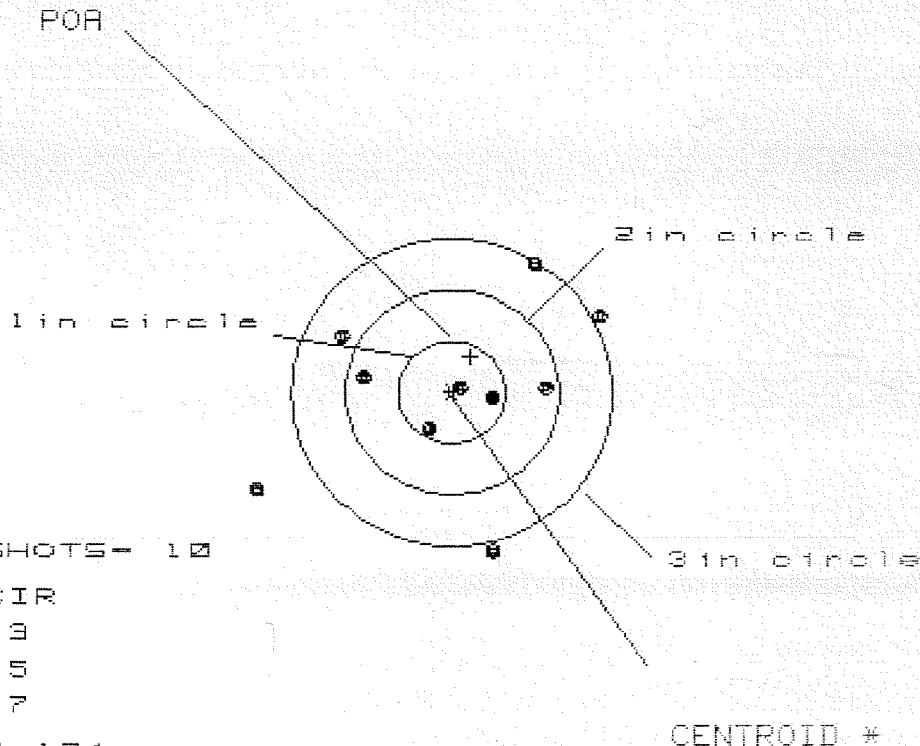
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0156
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1018
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .102988

THE AMR FOR THIS RIFLE IS: .9974

17 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8594490

CENTERFIRE PATTERNS # 1

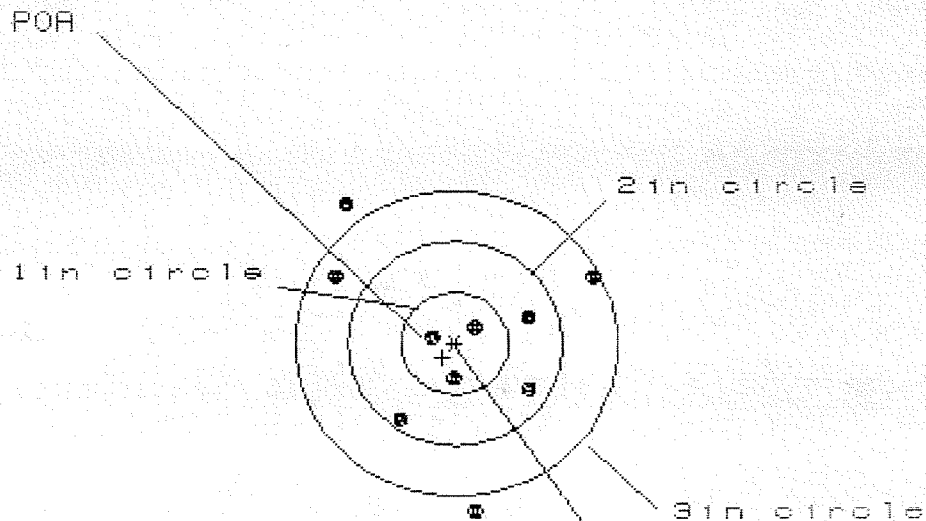


PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.349	1.152	.829
MINIMUM X	:	-1.775	-1.237	-1.093
MAXIMUM Y	:	1.221	1.116	1.201
MINIMUM Y	:	-1.511	-1.616	-1.531
CENTROID X	:	-.176	.021	-.123
CENTROID Y	:	-.352	-.247	-.332
POA TO CENTROID in.	:	.394	.248	.354
MIN RADIUS	:	.081	.172	.061
MEAN RADIUS	:	1.035	.921	.845
MAX RADIUS	:	2.010	1.626	1.565
HORIZONTAL SPREAD	:	3.124	2.389	1.922
VERTICAL SPREAD	:	2.732	2.732	2.732
EXTREME SPREAD	:	3.569	2.768	2.758
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		7	

17 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08534490

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 3

2in = 5

3in = 8

HS= 2.440

VS= 3.021

GS= 3.249

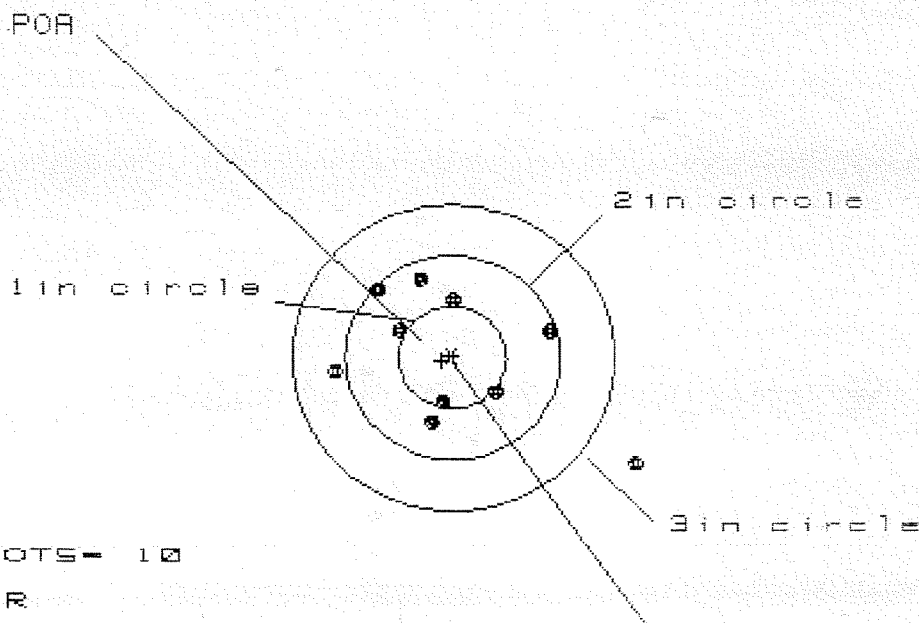
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.324	1.208	1.213
MINIMUM X	:	-1.117	-1.232	-1.227
MAXIMUM Y	:	1.346	.821	.631
MINIMUM Y	:	-1.675	-1.526	-1.772
CENTROID X	:	.118	.233	.228
CENTROID Y	:	.139	-.010	.180
POA TO CENTROID in.	:	.182	.233	.291
MIN RADIUS	:	.272	.289	.170
MEAN RADIUS	:	.945	.850	.751
MAX RADIUS	:	1.701	1.526	1.367
HORIZONTAL SPREAD	:	2.440	2.440	2.440
VERTICAL SPREAD	:	3.021	2.347	1.403
EXTREME SPREAD	:	3.249	2.643	2.440
NUMBER IN ONE INCH CIRCLE =			3	
NUMBER IN TWO INCH CIRCLE =			6	
NUMBER IN THREE INCH CIRCLE =			8	

17 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8594450

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in - 1

2 in - 7

3 in - 9

HS- 2.843

VS= 1.771

GS= 3.002

CENTROID *

PATTERN #	3	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.716	1.091	.974
MINIMUM X	-1.127	-.936	-.659
MAXIMUM Y	.732	.617	.585
MINIMUM Y	-1.039	-.773	-.805
CENTROID X	.098	-.093	.024
CENTROID Y	.033	.148	.180
POA TO CENTROID in.	.103	.175	.182
MIN RADIUS	.414	.331	.382
MEAN RADIUS	.861	.702	.666
MAX RADIUS	2.006	1.107	.987
HORIZONTAL SPREAD	2.843	2.027	1.633
VERTICAL SPREAD	1.771	1.390	1.390
EXTREME SPREAD	3.002	2.076	1.679
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	9		

17 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6594490

CENTERFIRE PATTERNS

4

POA

1in circle

2in circle

3in circle

CENTROID #

OF SHOTS- 10

IN CIR

1in - 1

2in - 6

3in - 9

HS- 1.973

VS- 2.815

GS- 2.853

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.126	1.041	.993
MINIMUM X	:	-.848	-.932	-.980
MAXIMUM Y	:	1.430	1.276	.780
MINIMUM Y	:	-1.385	-1.244	-1.085
CENTROID X	:	.124	.208	.256
CENTROID Y	:	-.068	.086	-.073
POA TO CENTROID in.	:	.141	.225	.266
MIN RADIUS	:	.387	.286	.267
MEAN RADIUS	:	.983	.898	.828
MAX RADIUS	:	1.580	1.395	1.279
HORIZONTAL SPREAD	:	1.973	1.973	1.973
VERTICAL SPREAD	:	2.815	2.520	1.865
EXTREME SPREAD	:	2.853	2.532	2.402
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

17 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06594490

CENTERFIRE PATTERNS # 5

POA

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 1

2 in = 3

3 in = 8

HS= 2.273

VS= 3.593

GS= 3.738

CENTROID *

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	1.181
MINIMUM X	-1.092
MAXIMUM Y	1.975
MINIMUM Y	-1.618
CENTROID X	-.086
CENTROID Y	-.261
POA TO CENTROID in.	.274
MIN RADIUS	.125
MEAN RADIUS	1.163
MAX RADIUS	1.976
HORIZONTAL SPREAD	2.273
VERTICAL SPREAD	3.593
EXTREME SPREAD	3.738
NUMBER IN ONE INCH CIRCLE =	1
NUMBER IN TWO INCH CIRCLE =	3
NUMBER IN THREE INCH CIRCLE =	8