C6594561

MODEL 700™ M24

Model SWS ™

Action

Barrel Length

Capacity

Order No. 5716

*Includes 1 in chamber.

Remington

GFM

CONTRACT # DAAA21-87-C-0086 Repair

GUN SERIAL # C6594561

OP. #	OP. NAME	READINGS	DATE	INIT
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 and Tap Sight Holes			
618	Polish Barrel			
620	Apply Coatings (Barrel Action)			
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		2/16/93	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		2/16/93	RW
	C) Inspect Ejector Hole for Chamfer		2/16/93	RW
	D) Oil Firing Pin Ass'y		2/16/93	RW
	E) Adjust Trigger Pull to Min Setting and Stake		2/16/93	RW

Op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			2/16/93	RW
	G) Safety Off Force	3	2.5	3			2/16/93	RW
	H) Trigger Pull Test & Retainability						2/16/93	RW
	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						2/16/93	RW
	P) Detach & Attach Scope 20 Times							
640	Gallery Target & Test						2/26/93	RW
	A) Time							
	B) Malfunctions							
	C) Pierced Primers							
	D) Optical Clearity of Scope							
645	Inspect for Live Ammo						2/26/93	RW
655	Final Inspection A) Headspace						3/4/93	RW
	B) Trigger Pull	2.54	2.52	2.55	2.55	2.55	3/4/93	RW
	C) Function						3/4/93	RW
660	Pack							

SWS TRIGGER PULL TEST

New Trigger Assy.

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

SERIAL NO. C6594561

DATE 2/15/93

TESTER RW

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.55	2.61	2.42		MIN. SETTING,
PULL #2	2.41	2.69	2.40		NO AVG. OF 5
PULL #3	2.47	2.40	2.45		READINGS ACCEPT-
PULL #4	2.48	2.38	2.30		ABLE LESS THAN 2#
PULL #5	2.48	2.35	2.39		
TOTAL	12.39	12.43	11.96		
AVG.	2.48	2.49	2.39		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.06	3.20		
PULL #2	3.10	3.10		
PULL #3	3.03	3.09		
PULL #4	3.05	3.11		
PULL #5	3.05	3.07		
TOTAL	15.29	15.57		
AVG.	3.06	3.11		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.09	4.04		4.06
PULL #2	4.03	4.02		4.12
PULL #3	4.04	4.05		4.26
PULL #4	4.06	4.00		4.29
PULL #5	4.16	4.01		4.28
TOTAL	20.38	20.12		21.01
AVG.	4.08	4.02		4.20

RECEIVING AND ESTIMATING REPORT

COMMENTS: WOG 16 OF 30 W/10X SCOPE & DEPLOYMENT KIT M-24

ORDER: R 93-02467

INITIAL	CUSTOMER ORDER NO.
FPS	

DATE RECEIVED	DATE OPENED	DATE CODE	SERIAL NUMBER	NEW SERIAL NUMBER	MODEL AND GRADE
01/25/93	01/25/93	BK 11-90	C6594561		700 7-62 NATO

ACCESSORIES: W/STUDS W/SWIVELS SOFT CASE SCOPE BASE

FROM:

MCHALE, EDWARD J CPT;SF
HSC 3RD BN 3RD SFG (A)
FT BRAGG NC 28307

SHIP TO:

MCHALE, EDWARD J CPT;SF
HSC 3RD BN 3RD SFG (A)
FT BRAGG NC 28307

CUST NO:073985 C.O.D

ACCOUNT NUMBER	ACCOUNT NUMBER N/C		PROM. DATE	ESTIMATED	VIA
		WRITE ☐ CLEAN/TEST			UPS

GUN CONDITION

- ☐ NEW
- ☐ LIGHTLY WORN
- ☐ WORN
- ☐ VERY WORN
- ☐ UNREPAIRABLE
- ☐ MARRED

REPAIR CHARGE	
EXCISE	
TAX	
INSURANCE	
UPS	
PARCEL POST	
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

PARTS

COMMENTS

REPAIRMAN	PROOF	CLEAN	TEST	TARGET	PATTERN
GALLERY TESTER	DATE	DATE	DATE	DATE	DATE

RD6925 REV. 1/92

OK Sqts
OK pin

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6594561

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		10/31/90	KA
600	Proof		10/31/90	KA
607	Check Headspace		10/31/90	KA
610	Dis-assemble Gun		10/31/90	KA
612	Magnaflux Barrel Action		11/1/90	KCR
	Magnaflux Bolt		11/1/90	KCR
615	Rollmark Caliber		11/1/90	GB
617	Drill and Tap Sight Holes		11/6/90	WB
618	Polish Barrel RB		11/7/90	WB
620	Apply Coatings (Barrel Action)		11-26-90	
	Apply Coating (Bolt)		11-26-90	
625	Final Assembly A) Clean inside of Bolt Assembly		12/5/90	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		12/5/90	KS
	C) Inspect Ejector Hole for Chamfer		12/5/90	KS
	D) Oil Firing Pin Ass'y		12/5/90	KS
	E) Adjust Trigger Pull to Min Setting and Stake		12/6/90	RH

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4 4	4 4	4 4			12/6/90	WB
	G) Safety Off Force	2 1/2	2 1/2	2 1/2			12/6/90	WB
	H) Trigger Pull Test & Retainability						12/6/90	
	I) Firing Pin Indent	.020	.020	.020			12/6/90	WB
	J) Assemble Stock						12/6/90	KS
	K) Assemble Swivel Studs						12-7-90	
	L) Attach Front and Rear Sight Assemblies						12/6/90	KS
	M) Iron Sight Alignment						12/6/90	KS
	N) Detach Front & Rear Sights & place in numbered container						12/6/90	KS
	O) Attach Scope to Rifle						12/6/90	KS
	P) Detach & Attach Scope 20 Times						12/6/90	KS
640	Gallery Target & Test						12/6/90	KJ
	A) Time						—	KJ
	B) Malfunctions						—	KJ
	C) Pierced Primers						0	KJ
	D) Optical Clearity of Scope						✓	KJ
645	Inspect for Live Ammo						12/6/90	KJ
655	Final Inspection A) Headspace						12-7-90	
	B) Trigger Pull	271	268	269	270	269	12-7-90	
	C) Function						12-7-90	
660	Pack						12/19/90	

SWS TRIGGER PULL TEST

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

SERIAL NO. 0159456
DATE 12/6/90
TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.29	2.39	2.40	271	MIN. SETTING,
PULL #2	2.24	2.38	2.38	268	NO AVG. OF 5
PULL #3	2.40	2.40	2.41	269	READINGS ACCEPT-
PULL #4	2.38	2.37	2.42	270	ABLE LESS THAN 2#
PULL #5	2.39	2.37	2.33	269	
TOTAL					
AVG.					

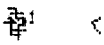
	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.24	3.25		
PULL #2	3.27	3.25		
PULL #3	3.27	3.28		
PULL #4	3.17	3.26		
PULL #5	3.25	3.26		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.42	4.40		4.36
PULL #2	4.38	4.45		4.49
PULL #3	4.40	4.46		4.48
PULL #4	4.41	4.49		4.43
PULL #5	4.49	4.48		4.33
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6594561
7 Dec 1990

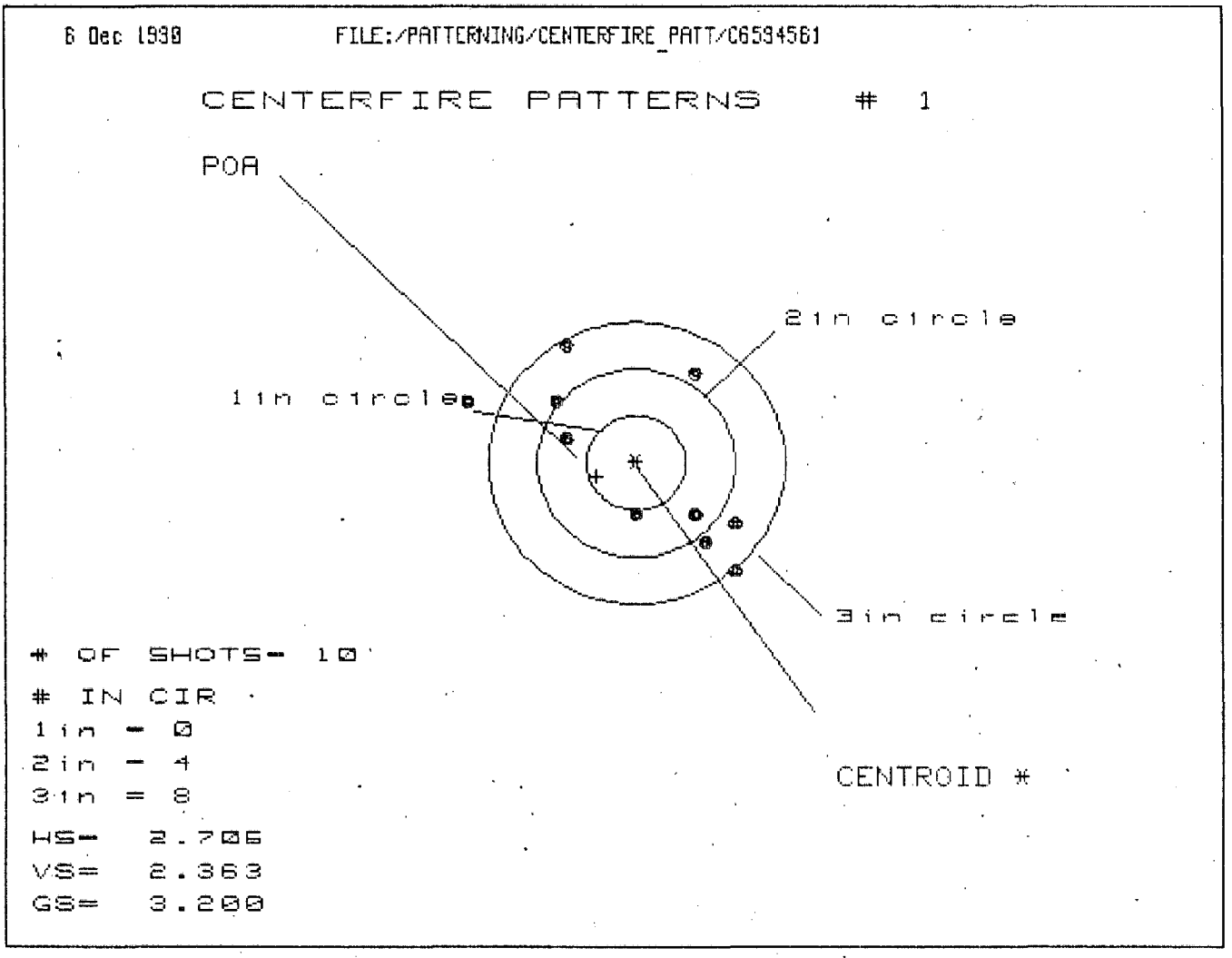
CENTROIDAL DISTANCES

0	TO	1	.427013
1	TO	2	.210535
1	TO	3	.35399
1	TO	4	.416621
1	TO	5	.221822



THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1992
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0584
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .207584

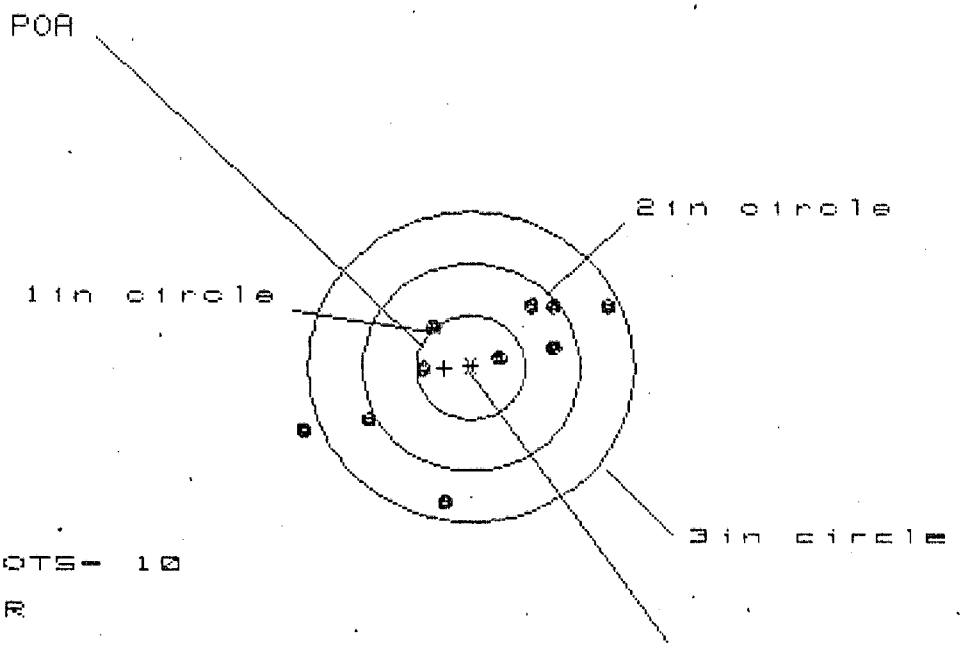
THE AMR FOR THIS RIFLE IS: .874



PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.006	.817	.914
MINIMUM X	:	-1.700	-.948	-.851
MAXIMUM Y	:	1.207	1.275	1.139
MINIMUM Y	:	-1.156	-1.088	-.867
CENTROID X	:	.402	.591	.494
CENTROID Y	:	.144	.076	.212
POA TO CENTROID in.	:	.427	.596	.537
MIN RADIUS	:	.546	.511	.619
MEAN RADIUS	:	1.112	1.011	.977
MAX RADIUS	:	1.808	1.546	1.379
HORIZONTAL SPREAD	:	2.706	1.765	1.765
VERTICAL SPREAD	:	2.363	2.363	2.006
EXTREME SPREAD	:	3.200	2.883	2.520
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	

6 Dec 1998 FILE:/PATTERNING/CENTERFIRE_PATT/C6594561

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

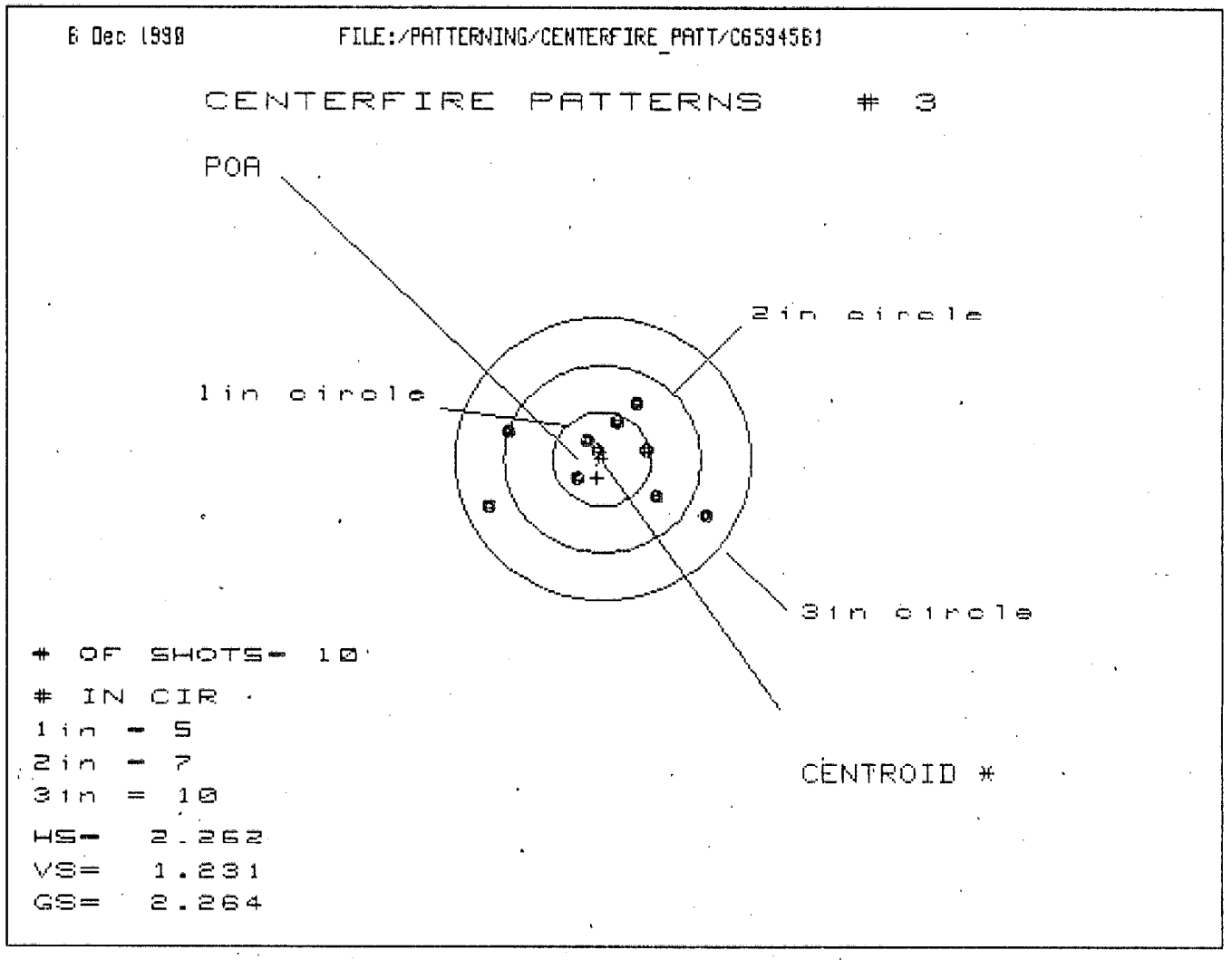
# IN CIR
1in = 2
2in = 6
3in = 9

HS= 2.804
VS= 1.864
GS= 3.031

PATTERN # : 2

SHOTS (BEST OF) :	10	9	8
MAXIMUM X :	1.245	1.072	.748
MINIMUM X :	-1.559	-1.147	-1.013
MAXIMUM Y :	.594	.530	.593
MINIMUM Y :	-1.270	-1.334	-1.271
CENTROID X :	.243	.416	.282
CENTROID Y :	.006	.070	.007
POA TO CENTROID in.:	.243	.422	.282
MIN RADIUS :	.267	.083	.231
MEAN RADIUS :	.920	.801	.768
MAX RADIUS :	1.662	1.394	1.299
HORIZONTAL SPREAD :	2.804	2.219	1.761
VERTICAL SPREAD :	1.864	1.864	1.864
EXTREME SPREAD :	3.031	2.483	2.106

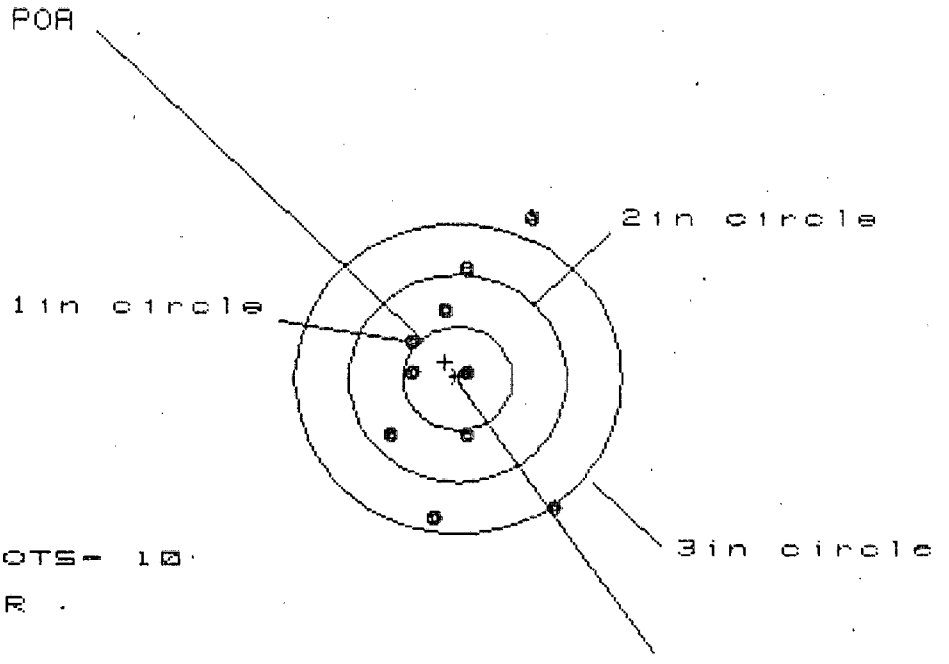
NUMBER IN ONE INCH CIRCLE = 2
NUMBER IN TWO INCH CIRCLE = 6
NUMBER IN THREE INCH CIRCLE = 9



PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.074	.942	.550
MINIMUM X	:	-1.188	-1.120	-1.002
MAXIMUM Y	:	.640	.584	.503
MINIMUM Y	:	-.591	-.647	-.581
CENTROID X	:	.052	.184	.066
CENTROID Y	:	.197	.253	.334
POA TO CENTROID in.	:	.204	.313	.340
MIN RADIUS	:	.137	.168	.030
MEAN RADIUS	:	.658	.574	.473
MAX RADIUS	:	1.290	1.156	1.023
HORIZONTAL SPREAD	:	2.262	2.062	1.552
VERTICAL SPREAD	:	1.231	1.231	1.084
EXTREME SPREAD	:	2.264	2.264	1.740
NUMBER IN ONE INCH CIRCLE	=		5	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

6 Dec 1990 FILE:/PATTERNING/CENTERFIRE_PATT/C6594561

CENTERFIRE PATTERNS # 4



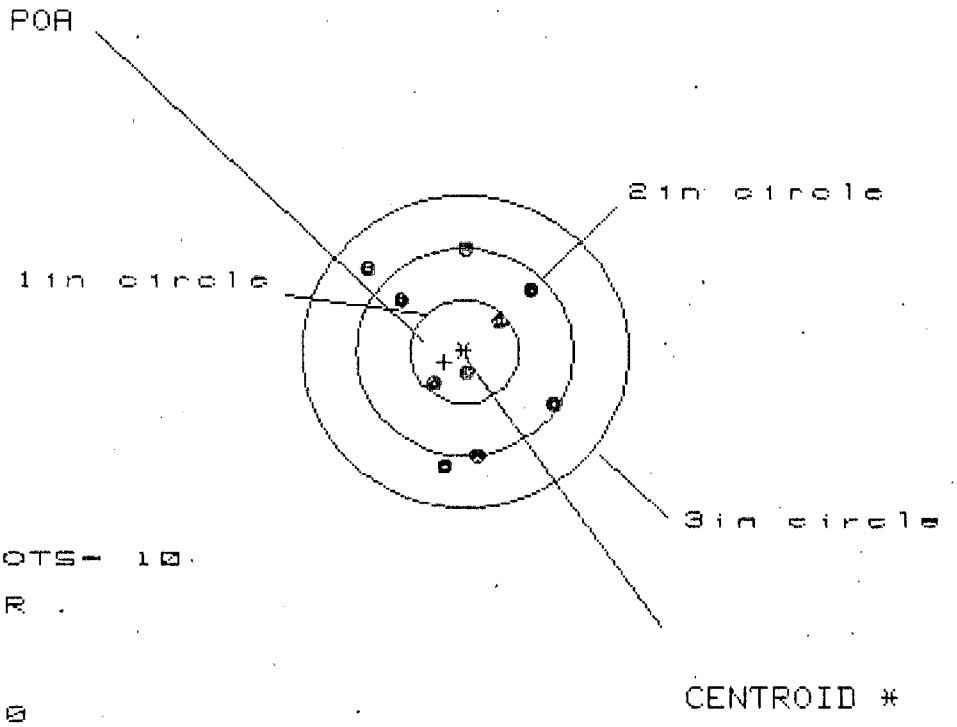
# OF SHOTS= 10
# IN CIR
1in = 2
2in = 6
3in = 8
HS= 1.547
VS= 2.961
GS= 3.097

PATTERN # : 4

SHOTS (BEST OF) :	10	9	8
MAXIMUM X :	.895	.971	.276
MINIMUM X :	-.652	-.576	-.455
MAXIMUM Y :	1.606	1.277	1.140
MINIMUM Y :	-1.355	-1.176	-1.313
CENTROID X :	.115	.039	-.082
CENTROID Y :	-.158	-.337	-.200
POA TO CENTROID in.:	.195	.339	.216
MIN RADIUS :	.102	.295	.215
MEAN RADIUS :	.889	.795	.674
MAX RADIUS :	1.743	1.465	1.314
HORIZONTAL SPREAD :	1.547	1.547	.731
VERTICAL SPREAD :	2.961	2.453	2.453
EXTREME SPREAD :	3.097	2.522	2.468
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		8	

6 Dec 1990 FILE:/PATTERNING/CENTERFIRE_PATT/C6594561

CENTERFIRE PATTERNS # 5



# OF SHOTS= 10
# IN CIR .
1in = 3
2in = 7
3in = 10
HS= 1.637
VS= 2.104
GS= 2.112

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.793	.777	.669
MINIMUM X	:	-.844	-.860	-.736
MAXIMUM Y	:	.965	.839	.920
MINIMUM Y	:	-1.139	-1.140	-1.059
CENTROID X	:	.184	.200	.307
CENTROID Y	:	.103	.229	.148
POA TO CENTROID in.	:	.211	.304	.341
MIN RADIUS	:	.211	.336	.274
MEAN RADIUS	:	.791	.748	.697
MAX RADIUS	:	1.148	1.143	1.059
HORIZONTAL SPREAD	:	1.637	1.637	1.405
VERTICAL SPREAD	:	2.104	1.979	1.979
EXTREME SPREAD	:	2.112	2.071	1.980
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

RECEIVING AND ESTIMATING REPORT

COMMENTS: WOG 16 OF 30 W/10X SCOPE & DEPLOYMENT KIT M-24

ORDER: R93-02467

INITIAL	CUSTOMER ORDER NO.
EPS	

DATE RECEIVED	DATE OPENED	DATE CODE	SERIAL NUMBER	NEW SERIAL NUMBER	MODEL AND GRADE
01/25/93	01/25/93	RK 11-90	C6594561		700 7-62 NATO

ACCESSORIES: W/STUDS W/SWIVELS SOFT CASE SCOPE BASE

FROM:

MCHALE; EDWARD J CPT;SF
HSC 3RD BN 3RD SFG (A)
FT BRAGG NC 28307

SHIP TO:

MCHALE; EDWARD J CPT;SF
HSC 3RD BN 3RD SFG (A)
FT BRAGG NC 28307

CUST NO:073985 C.@.D

ACCOUNT NUMBER	ACCOUNT NUMBER N/C	WRITE	PROM. DATE	ESTIMATED	VIA
		☐ CLEAN/TEST			UPS

GUN CONDITION
- ☐ NEW
- ☐ LIGHTLY WORN
- ☐ WORN
- ☐ VERY WORN
- ☐ UNREPAIRABLE
- ☐ MARRED

REPAIR CHARGE	
EXCISE	
TAX	
INSURANCE	
UPS	
PARCEL POST	
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: Rust on Gun

PARTS: Magazine Spring - 15677
Trigger Assy - 96024

COMMENTS: Zinc Phosphate Scope Base, Scope Rings, Swivels & Swivel Studs Re-powder Coat Floor plate, latch, Trigger Guard, Front Sight Base & Barrel Assy - 96001

REPAIRMAN	PROOF	CLEAN	TEST	TARGET	PATTERN
RW		✓	✓		
GALLERY TESTER	**DATE**	**DATE**	**DATE**	**DATE**	**DATE**
RW		2/16/93	2/26/93		

OFFICE COPY

RD6925 REV. 1/92