

C6587594

MODEL 700TM M24

Model **SMS** TM

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

Remington

M2400023397

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER

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: **RE00032497** Serial: C6587594 Model 700 Center Fire Caliber: 7 62 NATO M24 SWS WOG 15 of 25 Repairman: Status: New 9/14/01 3:10:11 PM

Verify Repair

Address Information

Customer: Received From Return To: Received From

Name: DEFENCE DIST DEPOT ANNISTON DEFENCE DIST DEPOT ANNISTON

Address 1: 7 FRANKFORD AVE 7 FRANKFORD AVE

Address 2: PO Box: PO Box:

City: ANNISTON ANNISTON

State: AL Zip Code: 36201 Country: US State: AL Zip Code: 36201 Country: US

FFL:

Contact / Condition Problems Estimate History / Status Shipping / Billing

Contact Information

Phone: Fax: Email: Comments:

Received Condition

Fair

Condition: Notes: CSR Notes:

Accessories Received

Code	Desc	Qty
A006	Sling Strap	1
A007	With Stud	3
A008	With Swivel	2
A010	Hard Case	1
A026	Scope	1
X001	Scope Case	1
X002	Deployment Case	1

Repair Search Refresh Close

nagletj 9/17/01 7:49 AM CAPS NUM INS SCPL

Start Arms Services Repair & Es... 7:49 AM

Serial Number: **C6587594**

Model: **700**



RE00032497

Remington Test Lab, Ilion, N.Y.

Centroidal distance calculations for Rifle # c6587594
5 Oct 2001

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0708
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0682
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .098305

THE AMR FOR THIS RIFLE IS: 1.12

CENTROIDAL DISTANCES

0	TO	1	.264622
1	TO	2	.126194
1	TO	3	.362244
1	TO	4	.268002
1	TO	5	.702923

5
4 <----POA
1 2 3

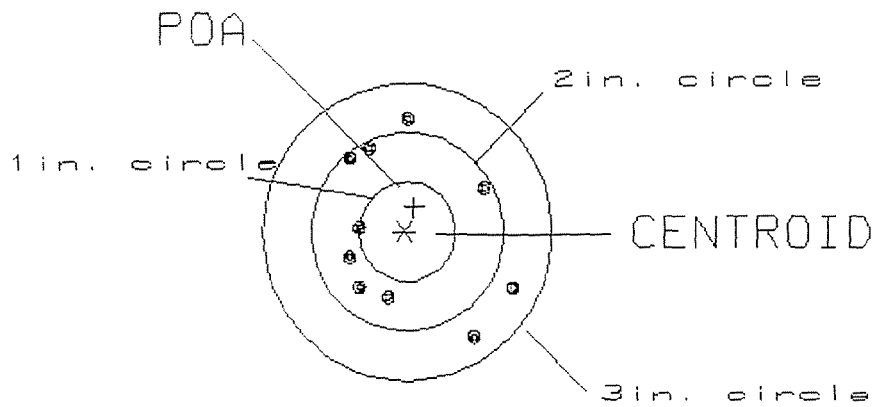
PATTERN #: ☐ 1 ☐

POA TO CENTROID: .265
 MIN RADIUS : .451
 MEAN RADIUS : .884
 MAX RADIUS : 1.290
 CENTROID X : -.100
 CENTROID Y : -.245

5 Oct 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6587594

CENTERFIRE PATTERN # 1



OF SHOTS= 10

IN CIRCLE

HS= 1.68

1

VS= 2.17

7

GS= 2.28

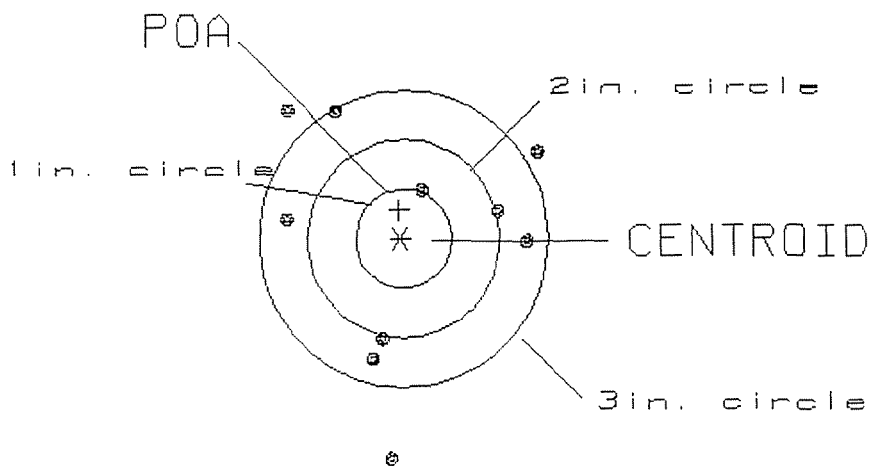
10

PATTERN #: ☐ 2 ☐
 POA TO CENTROID: .287
 MIN RADIUS : .496
 MEAN RADIUS : 1.336
 MAX RADIUS : 2.228
 CENTROID X : .019
 CENTROID Y : -.287

5 Oct 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6587594

CENTERFIRE PATTERN # 2



OF SHOTS= 10

IN CIRCLE

HS= 2.63
 VS= 3.52
 GS= 3.66

1
 1
 7

PATTERN #: ☐ 3 ☐

POA TO CENTROID: .339

MIN RADIUS : .151

MEAN RADIUS : .958

MAX RADIUS : 1.783

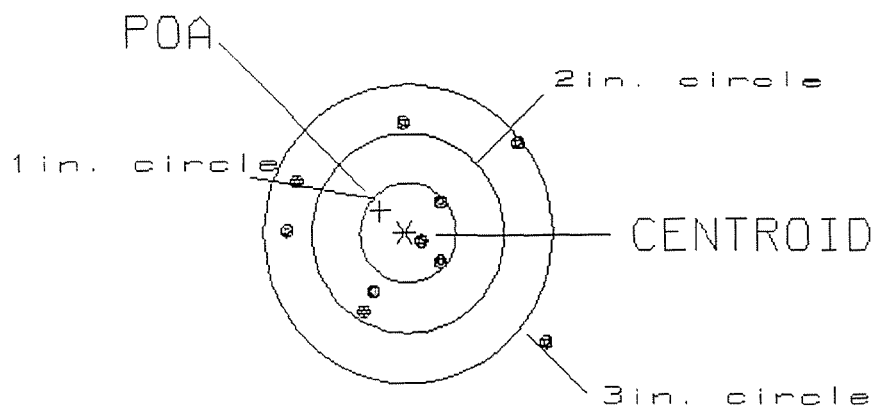
CENTROID X : .261

CENTROID Y : -.215

5 Oct 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6587594

CENTERFIRE PATTERN # 3



OF SHOTS= 10

IN CIRCLE

HS= 2.70

3

VS= 2.16

5

GS= 3.05

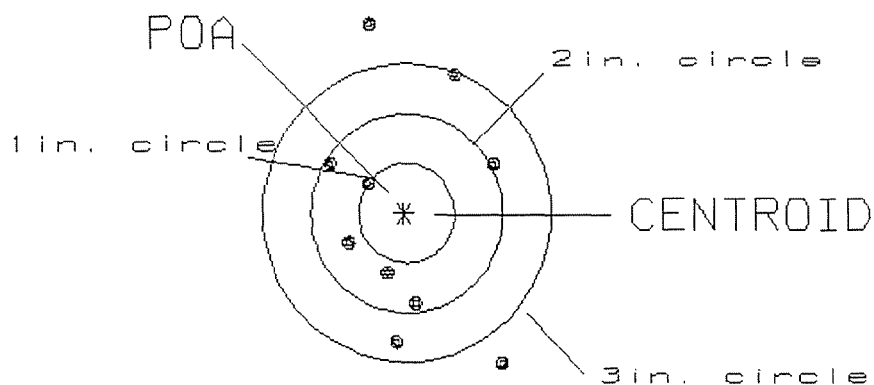
9

PATTERN #: ☐ 4 ☐
 POA TO CENTROID: .004
 MIN RADIUS : .462
 MEAN RADIUS : 1.107
 MAX RADIUS : 1.950
 CENTROID X : .004
 CENTROID Y : .002

5 Oct 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6587594

CENTERFIRE PATTERN # 4



OF SHOTS= 10

IN CIRCLE

HS= 1.74
 VS= 3.39
 GS= 3.64

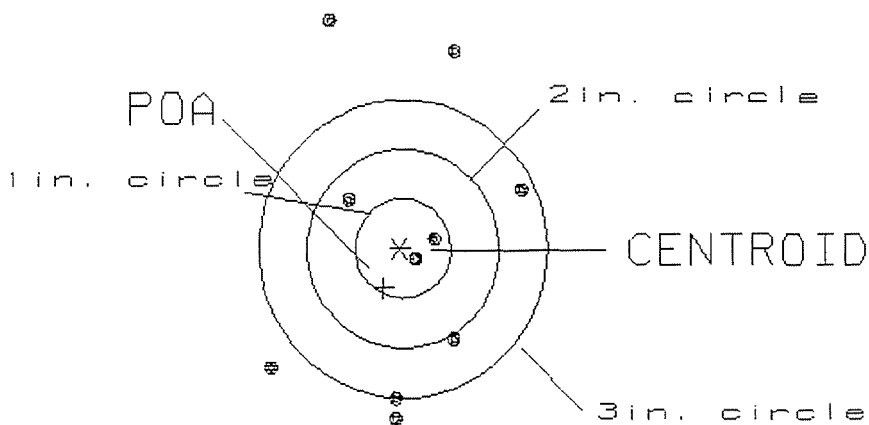
1
 5
 8

PATTERN #: ☐ 5 ☐
 POA TO CENTROID: .438
 MIN RADIUS : .144
 MEAN RADIUS : 1.317
 MAX RADIUS : 2.437
 CENTROID X : .170
 CENTROID Y : .404

5 Oct 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6587594

CENTERFIRE PATTERN # 5



OF SHOTS= 10

IN CIRCLE

HS= 2.60
 VS= 4.07
 GS= 4.13

2
 3
 6

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

R & E NUMBER 32497

SERIAL NUMBER C6587594

LOG-IN DATE 9-13-01

INSPECT AND VERIFY:			
OPERATION #	OPERATION NAME	DATE	INITIAL
550	DIS-ASSEMBLE GUN	9-18-01	RH
560 A	RE-BARREL AT CUSTOM SHOP	9/20/01	BWT
B	DRILL AND TAP	9/20/01	BWT
C	POLISH	9-20-01	CD
575	ASSEMBLE	9-20-01	RH
600	PROOF	9-21-01	RH
605	CHECK HEADSPACE	9-24-01	RH
610	DIS-ASSEMBLE GUN	9-24-01	RH
612	MAGNAFLUX	9-24-01	AL
615	ROLLMARK CALIBER	9-24-01	RH
618	ROTO-BLAST	9/25	K
620	APPLY COATINGS	9/28	H.P.
625 A	FINAL ASSEMBLY	10-3-01	RH
B	TRIGGER PULL TEST		
C	SAFETY "ON" FORCE		
D	SAFETY "OFF" FORCE		
E	FIRING PIN INDENT		
640	TARGET	10-4-01	AC
655	FINAL INSPECT	10-6-01	RH
660	PACK	10-6-01	RH
		SHIP DATE	
		QAR INSPECTION DATE	

Final Inspection

In: C6587594

DATE REC'D: 9-13-01

DATE RET'D: 10-9-01

AUDITOR: ~~RL~~

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.

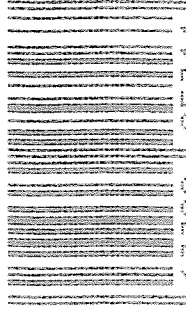
MODEL 700TM H24

SERIAL NO.
C6587594

ORDER NO.
5716

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

UPC



0 4700 25716 7



5716 C6587594

MOD. M24 GA. CAL. 308 GUN # 7594

# TEST	DATE	MALFUNCTION/DEFECT	ASSEM. #
	1st		
NF	4/10	Does not feed properly	KS
	2nd	ADJUSTED MAGAZINE BOX 1-10-91	K. S.
	3rd		
	4th		
		FUNCTION	RD 6654 Rev 1

TEST INIT. ACTION TO CORRECT		ASSEM. #
PROOF		
TEST		
TGT		
PROOF		
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		

CONTRACT # DAAA21-87-C-0086

NEW BBLGUN SERIAL # **C 6587594**

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		10/24/90	Kd
600	Proof		10/24/90	Kd
607	Check Headspace		10/24/90	Kd
610	Dis-assemble Gun		10/24/90	Kd
612	Magnaflux Barrel Action		10/30/90	KR
	Magnaflux Bolt		10/30/90	KR
615	Rollmark Caliber		10/30/90	GL
617	Drill and Tap Sight Holes		11/6/90	LB
618	Polish Barrel AB		11/7/90	LB
620	Apply Coatings (Barrel Action)		11-26-90	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		12/14/90	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		12/14/90	KS
	C) Inspect Ejector Hole for Chamfer		12/14/90	KS
	D) Oil Firing Pin Ass'y		12/14/90	KS
	E) Adjust Trigger Pull to Min Setting and Stake		1-2-91	JA

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			1/2/91	WB
	G) Safety Off Force	2 ³ / ₄	2 ³ / ₄	2 ³ / ₄			1/2/91	WB
	H) Trigger Pull Test & Retainability						1-2-91	JL
	I) Firing Pin Indent	.020	.020	.020			1/2/91	WB
	J) Assemble Stock						1/3/91	K.S.
	K) Assemble Swivel Studs						1-11-91	JL
	L) Attach Front and Rear Sight Assemblies						1/3/91	K.S.
	M) Iron Sight Alignment						1/3/91	K.S.
	N) Detach Front & Rear Sights & place in numbered container						1/3/91	K.S.
	O) Attach Scope to Rifle						1/3/91	K.S.
	P) Detach & Attach Scope 20 Times						1/3/91	K.S.
640	Gallery Target & Test						1-10-91	NF
	A) Time						"	NF
	B) Malfunctions						"	NF
	C) Pierced Primers						"	NF
	D) Optical Clarity of Scope						"	NF
645	Inspect for Live Ammo						1-10-91	NF
655	Final Inspection							
	A) Headspace						1-11-91	JL
	B) Trigger Pull	2.10	2.00	2.15	2.00	2.15	1-11-91	JL
	C) Function						1-11-91	JL
660	Pack						3/15/91	WB

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

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

SERIAL NO. C6587594

DATE 1-2-91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.25	2.33	2.35	2.10	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.22	2.32	2.40	2.00	
PULL #3	2.47	2.34	2.33	2.15	
PULL #4	2.40	2.28	2.39	2.00	
PULL #5	2.39	2.37	2.39	2.15	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.36	3.22		
PULL #2	3.41	3.50		
PULL #3	3.33	3.30		
PULL #4	3.44	3.13		
PULL #5	3.31	3.27		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.29	4.44		4.45
PULL #2	4.45	4.37		4.45
PULL #3	4.11	4.25		4.31
PULL #4	4.44	4.46		4.47
PULL #5	4.40	4.44		4.38
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6587594
11 Jan 1991

CENTROIDAL DISTANCES

0 TO	1	.289249
1 TO	2	.5886
1 TO	3	.411428
1 TO	4	.467787
1 TO	5	.728616

$\bar{x}$ $\bar{y}$ <----POA

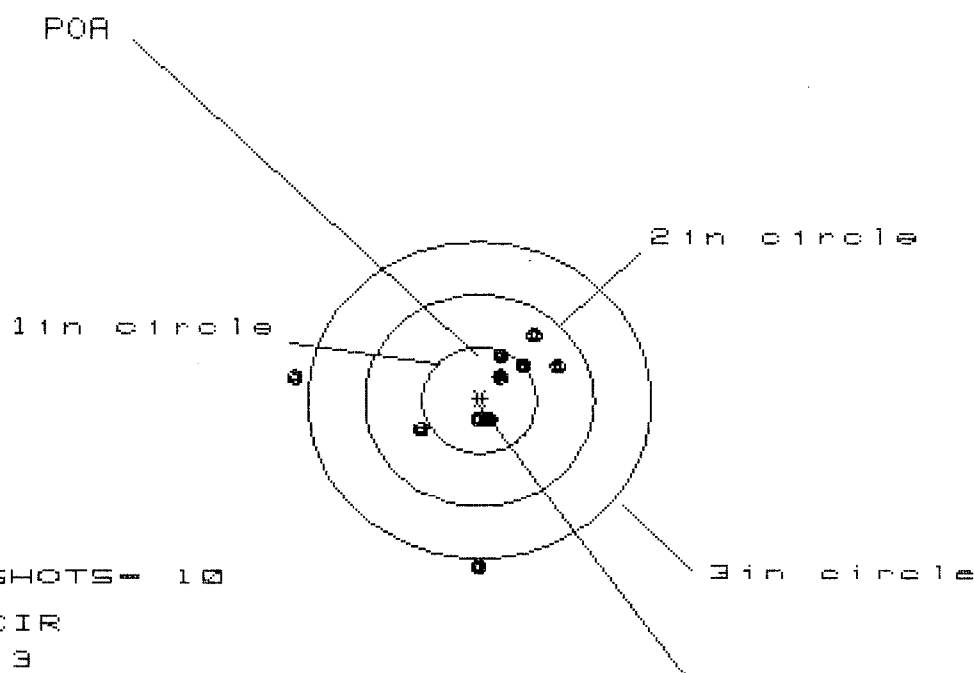
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .172
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0016
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .172007
THE AMR FOR THIS RIFLE IS: .8598

11 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6587594.1

CENTERFIRE PATTERNS

1



OF SHOTS- 10

IN CIR

1in - 3

2in - 8

3in - 8

HS- 2.298

VS= 2.172

GS= 2.402

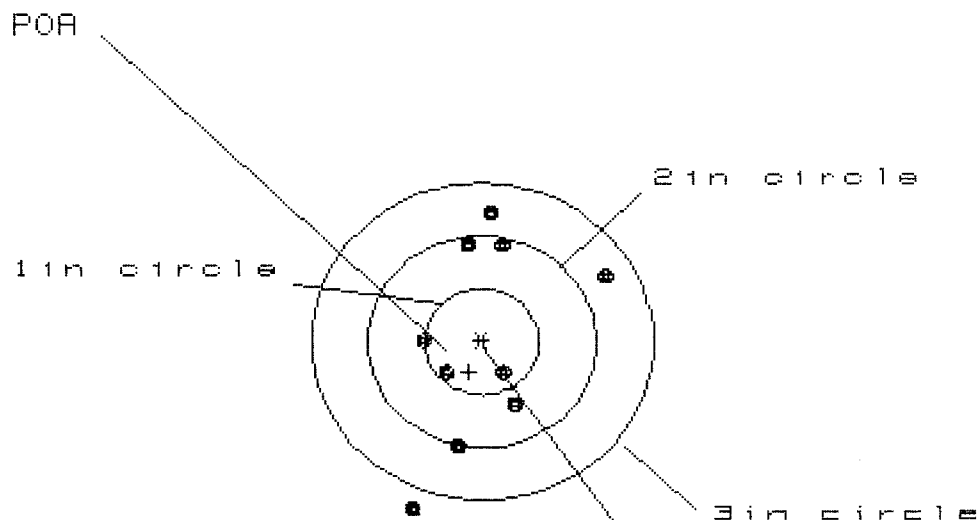
CENTROID #

PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.663	.482	.458
MINIMUM X	:	-1.634	-.675	-.699
MAXIMUM Y	:	.632	.658	.469
MINIMUM Y	:	-1.540	-1.514	-.415
CENTROID X	:	-.183	-.001	.023
CENTROID Y	:	-.224	-.250	-.061
POA TO CENTROID in.	:	.289	.250	.065
MIN RADIUS	:	.182	.191	.062
MEAN RADIUS	:	.704	.570	.405
MAX RADIUS	:	1.651	1.526	.813
HORIZONTAL SPREAD	:	2.298	1.157	1.157
VERTICAL SPREAD	:	2.172	2.172	.884
EXTREME SPREAD	:	2.402	2.231	1.329
NUMBER IN ONE INCH CIRCLE	=	3		
NUMBER IN TWO INCH CIRCLE	=	8		
NUMBER IN THREE INCH CIRCLE	=	8		

11 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8587594.1

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 3

2in = 5

3in = 9

HS- 1.647

VS- 2.760

GS- 2.846

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.048	.981	.330
MINIMUM X	:	-.599	-.558	-.435
MAXIMUM Y	:	1.218	1.046	1.108
MINIMUM Y	:	-1.542	-1.199	-1.137
CENTROID X	:	.116	.183	.060
CENTROID Y	:	.283	.455	.393
POA TO CENTROID in.	:	.306	.490	.398
MIN RADIUS	:	.352	.492	.443
MEAN RADIUS	:	.889	.811	.753
MAX RADIUS	:	1.654	1.223	1.144
HORIZONTAL SPREAD	:	1.647	1.539	.765
VERTICAL SPREAD	:	2.760	2.245	2.245
EXTREME SPREAD	:	2.846	2.262	2.262
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

11 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8587594.1

CENTERFIRE PATTERNS

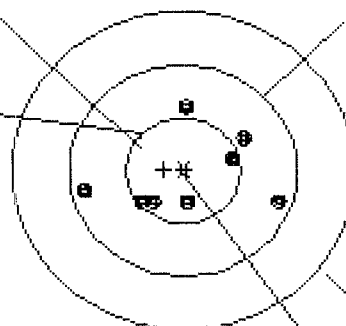
3

POA

1 in circle

2 in circle

3 in circle



OF SHOTS- 10

IN CIR

1 in = 4

2 in = 8

3 in = 8

HS= 1.636

VS= 3.924

GS= 3.952

CENTROID #

PATTERN #	:	3	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.813	.819	.767
MINIMUM X	:	-.823	-.817	-.869
MAXIMUM Y	:	2.209	.808	.625
MINIMUM Y	:	-1.715	-1.470	-.276
CENTROID X	:	.169	.163	.215
CENTROID Y	:	-.011	-.256	-.072
POA TO CENTROID in.	:	.169	.304	.226
MIN RADIUS	:	.308	.067	.247
MEAN RADIUS	:	.853	.666	.560
MAX RADIUS	:	2.209	1.526	.876
HORIZONTAL SPREAD	:	1.636	1.636	1.636
VERTICAL SPREAD	:	3.924	2.278	.901
EXTREME SPREAD	:	3.952	2.318	1.641
NUMBER IN ONE INCH CIRCLE	=	4		
NUMBER IN TWO INCH CIRCLE	=	8		
NUMBER IN THREE INCH CIRCLE	=	8		

01 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6507594.1

CENTERFIRE PATTERNS

4

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 1

2in = 6

3in = 9

HS= 2.502

VS= 2.583

GS= 3.411

PATTERN #

4

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.548

.777

.679

MINIMUM X

-.954

-.782

-.451

MAXIMUM Y

1.488

1.142

1.058

MINIMUM Y

-1.095

-.929

-1.012

CENTROID X

.236

.064

.162

CENTROID Y

-.016

-.182

-.099

POA TO CENTROID in.

.236

.193

.189

MIN RADIUS

.194

.421

.299

MEAN RADIUS

.893

.744

.691

MAX RADIUS

2.147

1.156

1.095

HORIZONTAL SPREAD

2.502

1.559

1.130

VERTICAL SPREAD

2.583

2.071

2.071

EXTREME SPREAD

3.411

2.074

2.074

NUMBER IN ONE INCH CIRCLE =

1

NUMBER IN TWO INCH CIRCLE =

6

NUMBER IN THREE INCH CIRCLE =

9

11 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6587594.1

CENTERFIRE PATTERNS

5

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 3

2in = 6

3in = 8

HS= 2.793

VS= 2.797

GS= 3.122

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.715	.587	.658
MINIMUM X	:	-1.078	-.887	-.816
MAXIMUM Y	:	1.511	1.583	1.050
MINIMUM Y	:	-1.286	-1.214	-1.017
CENTROID X	:	.522	.331	.260
CENTROID Y	:	-.040	-.112	-.309
POA TO CENTROID in.	:	.523	.350	.404
MIN RADIUS	:	.359	.156	.114
MEAN RADIUS	:	.960	.809	.666
MAX RADIUS	:	1.831	1.681	1.193
HORIZONTAL SPREAD	:	2.793	1.474	1.474
VERTICAL SPREAD	:	2.797	2.797	2.067
EXTREME SPREAD	:	3.122	3.012	2.316
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	