C6523460

MODEL 700™ M24

Model SWS ™

Action

Barrel Length

Capacity

Order No. 5716

*Includes 1 in chamber.

Remington

04/20/09 15:34:33

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: RE00166676

Verify Repair

Serial: C6523460 Model M24 SWS Center Fire
Caliber: 7.62 NATO

Repairman:

Status: Closed 4/20/2009 2:49:12 PM

Address Information

	Customer	Received From	Return To	Received From
Name:	DIRECTOR OF EMERGENCY SERVICES		DIRECTOR OF EMERGENCY SERVICES	
Address 1:	BLDG 53		BLDG 53	
Address 2:	ANNISTON ARMY DEPOT	PO Box:	ANNISTON ARMY DEPOT	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

Date	Code	User ID	Desc1
4/20/2009 2:43:33 PM	New	valentds	Repair Added
4/20/2009 2:49:12 PM	Closed	valentds	Closed at Expedite

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

Current Status: Closed
4/20/2009 2:49:12 PM
valentds
Sniper Systems
Repair Location: ILN
Current Location: ILN
Transfer Number:

Repair Search | Refresh | Close

nagletj | 4/20/2009 | 3:34 PM | CAPS | NUM | INS | SCRL

Start | 5 Microso... | 3 Microso... | Arms Servi... | Part Searc... | Google Ne... | Mise PDF | Adobe Acr...

Serial Number: C6523460

Model: M24 SWS

RE00166676

M-24

INSPECTION CHECKLIST - REPAIRS

CONTRACT #: W52H09-07-C-0207

ISSUED 10/1/2007

Remove 3 Gre 15 Hse

R & E NUMBER 166676

SERIAL NUMBER C1052346G

LOG-IN DATE 4-20-09

OPERATION #	OPERATION NAME		DATE	INITIAL
500	DIS-ASSEMBLE GUN		4-24-09	RTC
505	RE-BARREL		4-28-09	RTC
420	ASSEMBLE		4-28-09	RTC
440	PROOF	MAGNA - FLUX	4-28-09	TQR
460	CHECK HEADSPACE		4-28-09	TQR
470	DIS-ASSEMBLE GUN		4-28-09	RTC
480	MAGNAFLUX	OPERATOR (D)	5/6/09	(D)
510	DRILL AND TAP		4-28-09	SF
500	ROLLMARK CALIBER		5/7/09	RT
520	GOFF BLAST BBL / REC		5/7/09	REM
530 & 540	APPLY COATINGS		5-/8	—
560	FINAL ASSEMBLY		5-11-09	RTC
640	FUNCTION TEST AND	(PASS) FAIL	5/12/09	RB
650	TARGET	(PASS) FAIL	5/12/09	RB
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION N/A		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION	5-12-09	VN
670	FINAL INSPECTION A) HEADSPACE	(PASS) FAIL	5-13-09	LD
	B) TRIGGER PULL (+/- .5 LBS, MIN 2.50 LBS, MAX 4.0 LBS)	267 269 268 270 267	5-13-09	RTC
680	F) SAFETY ON FORCE (2 LBS MIN, 10 LBS MAX)	4° 4° 4°	5-13-09	RD
	G) SAFETY OFF FORCE (2 LBS MIN)	4° 4° 4°	5-13-09	RD
	I) FIRING PIN INDENT (.020)	.022 .022 .022	5-13-09	RD
690	PACK		5/15/09	FM

F006 REV 1/2009

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFOMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6523460.__0
FILE DATE AND TIME: 05/12/2009 12:42

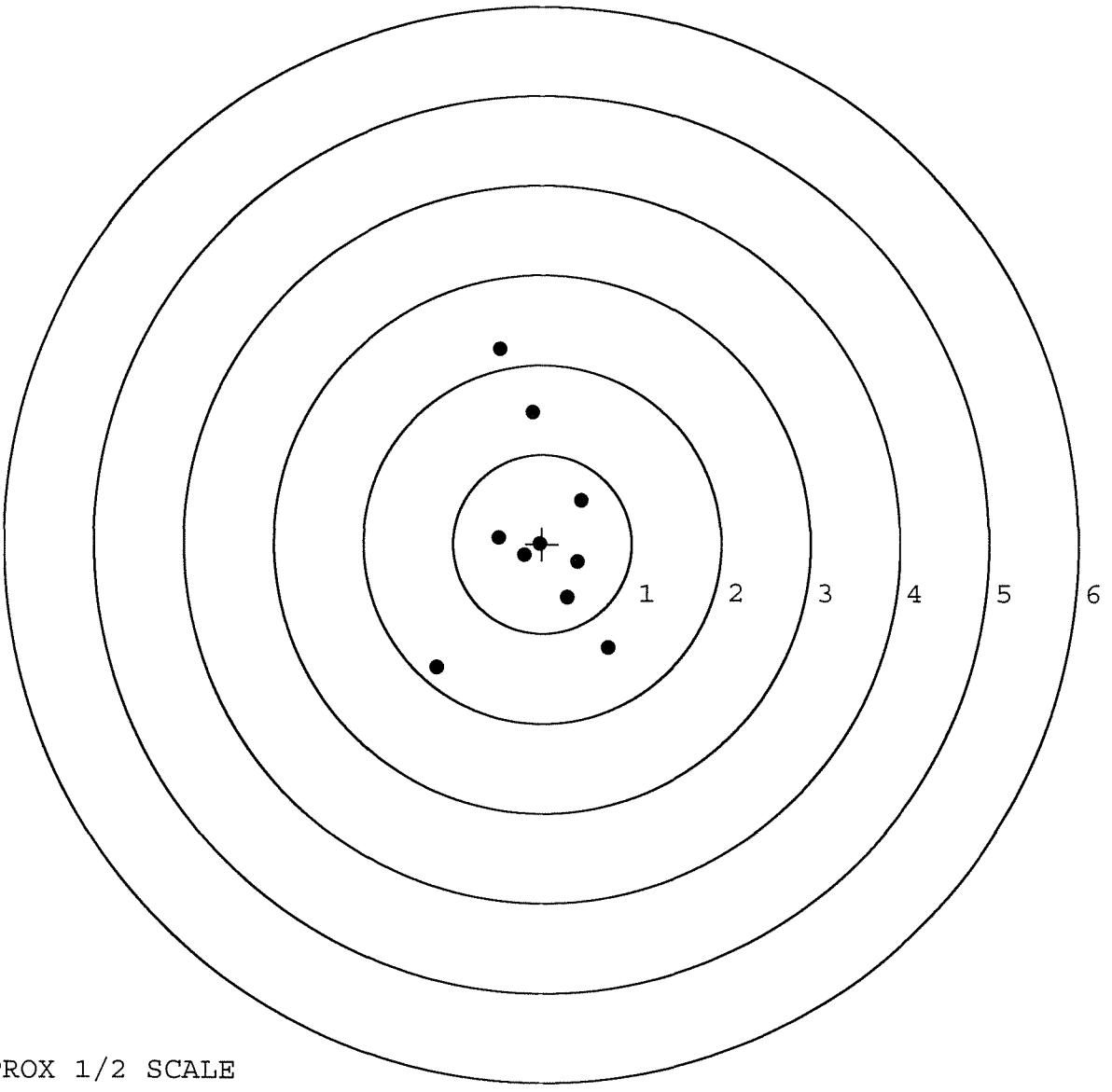
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.294
The Average Y Centroid of the Five Target Set:	-0.062
The Average Point of Impact of the Five Target Set:	0.300
The Average Mean Radius of the Five Target Set:	0.685
The Distance from POA to Centroid Target #1:	0.096
The Distance from Centroid Target #2 to Centroid Target #1:	0.485
The Distance from Centroid Target #3 to Centroid Target #1:	0.848
The Distance from Centroid Target #4 to Centroid Target #1:	0.100
The Distance from Centroid Target #5 to Centroid Target #1:	0.043

SERIAL NUMBER: C6523460.__0
TARGET NUMBER: 1
FILE DATE: 05/12/2009
FILE TIME: 12:42

X CENTROID:	-0.063
Y CENTROID:	0.072
POA TO CENTROID:	0.096
HORZ SPREAD:	1.917
VERT SPREAD:	3.568
GROUP SPREAD:	3.636
MIN RADIUS:	0.077
MAX RADIUS:	2.147
MEAN RADIUS:	0.956
# IN 1 IN DIAMETER:	3
# IN 2 IN DIAMETER:	6
# in 3 IN DIAMETER:	8

POINT#	X	Y
1:	-0.475	2.179
2:	-0.108	1.473
3:	0.443	0.490
4:	-0.030	0.003
5:	-0.202	-0.132
6:	-0.493	0.067
7:	0.396	-0.201
8:	0.280	-0.601
9:	0.740	-1.166
10:	-1.177	-1.389

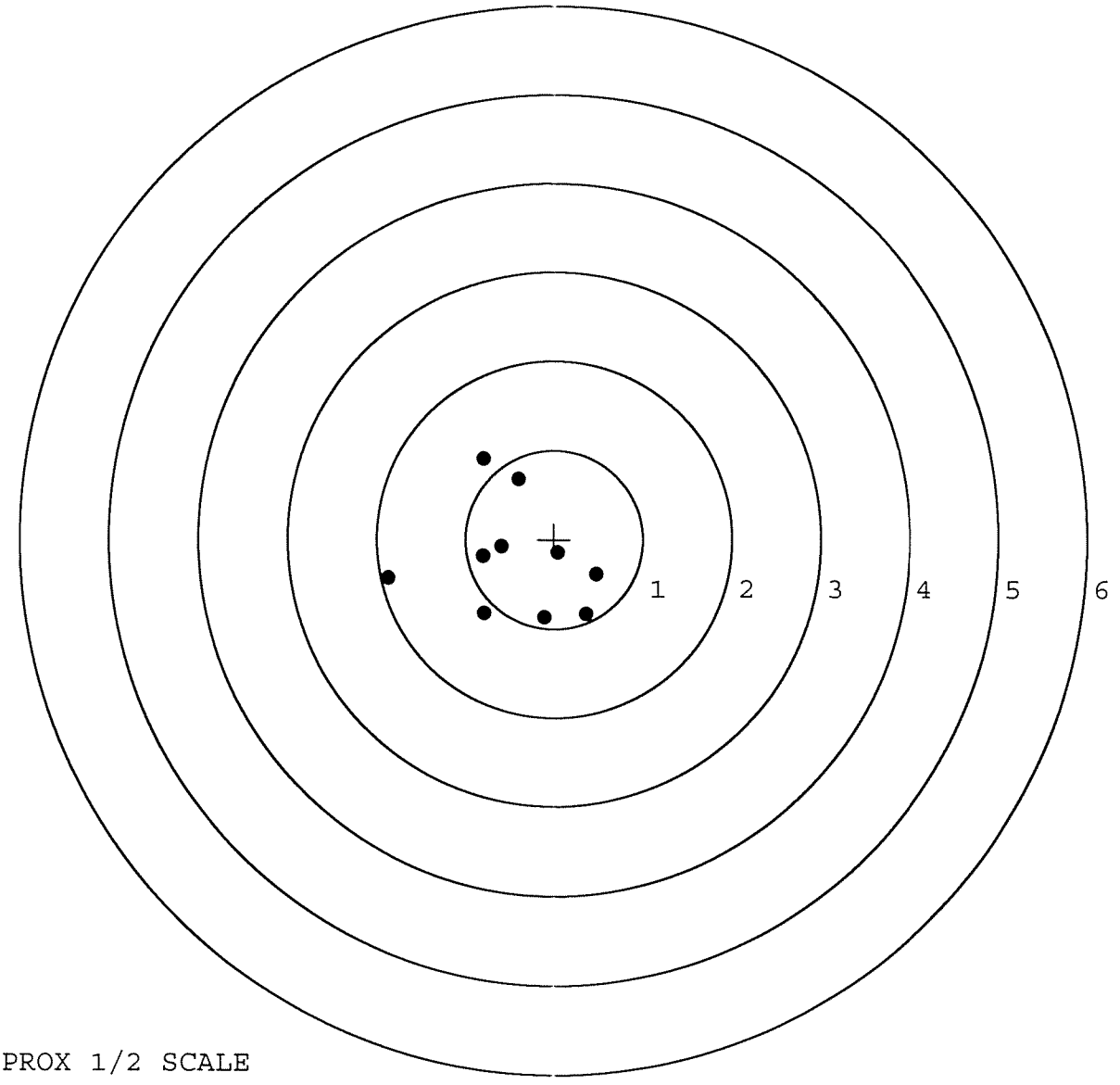


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6523460.__0
TARGET NUMBER: 2
FILE DATE: 05/12/2009
FILE TIME: 12:42

X CENTROID:	-0.449
Y CENTROID:	-0.221
POA TO CENTROID:	0.500
HORZ SPREAD:	2.345
VERT SPREAD:	1.781
GROUP SPREAD:	2.345
MIN RADIUS:	0.204
MAX RADIUS:	1.436
MEAN RADIUS:	0.796
# IN 1 IN DIAMETER:	3
# IN 2 IN DIAMETER:	7
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	-0.798	0.905
2:	-0.405	0.676
3:	-1.868	-0.437
4:	-0.802	-0.189
5:	-0.596	-0.081
6:	0.041	-0.151
7:	0.477	-0.390
8:	0.365	-0.839
9:	-0.110	-0.876
10:	-0.789	-0.831

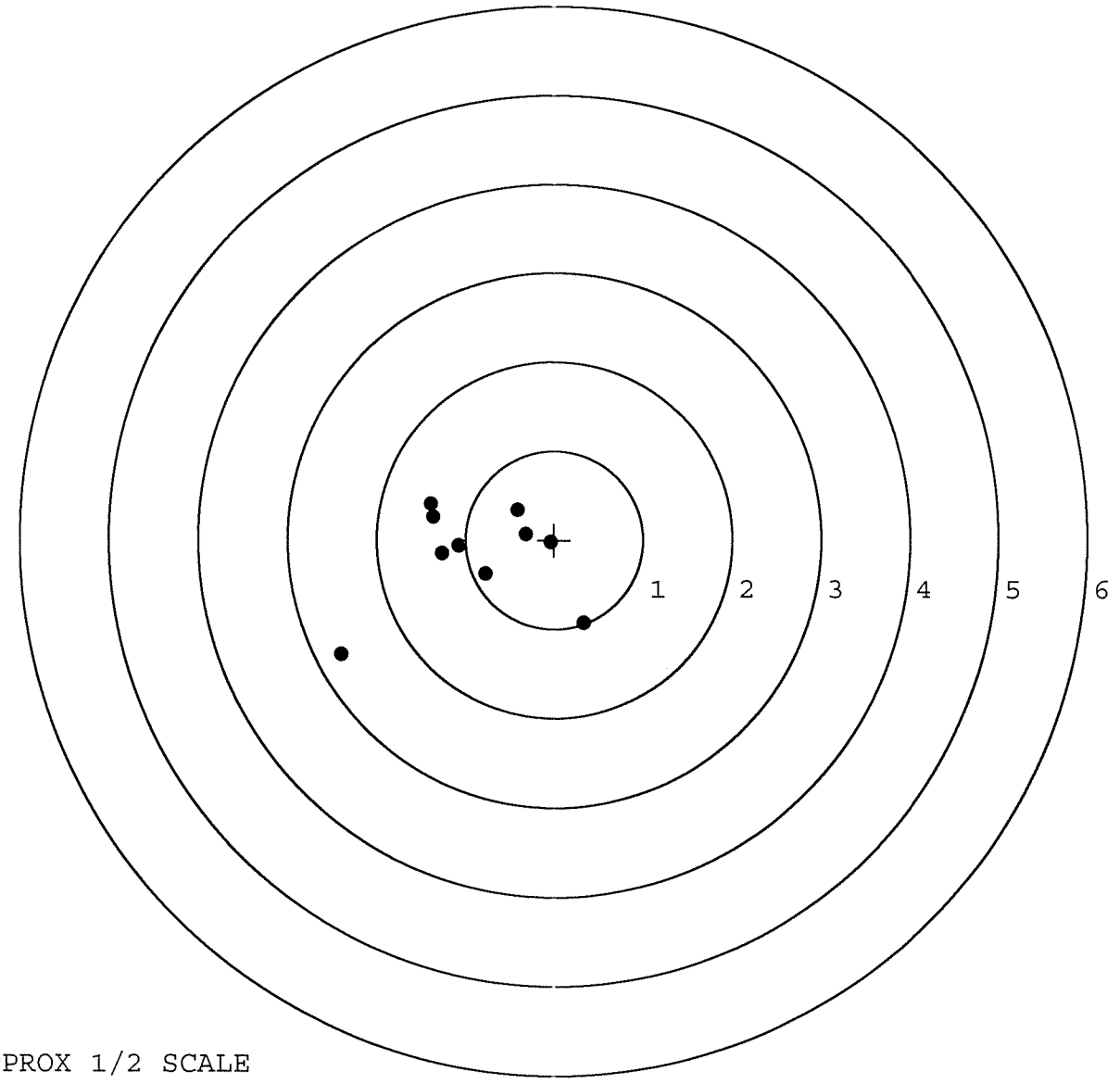


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6523460.__0
TARGET NUMBER: 3
FILE DATE: 05/12/2009
FILE TIME: 12:42

X CENTROID:	-0.872
Y CENTROID:	-0.181
POA TO CENTROID:	0.891
HORZ SPREAD:	2.731
VERT SPREAD:	1.699
GROUP SPREAD:	2.754
MIN RADIUS:	0.222
MAX RADIUS:	1.888
MEAN RADIUS:	0.774
# IN 1 IN DIAMETER:	3
# IN 2 IN DIAMETER:	8
# in 3 IN DIAMETER:	9

POINT#	X	Y
1:	-1.389	0.405
2:	-1.366	0.255
3:	-1.262	-0.157
4:	-1.080	-0.068
5:	-0.780	-0.383
6:	-0.415	0.337
7:	-0.046	-0.030
8:	-0.321	0.066
9:	0.334	-0.938
10:	-2.397	-1.294

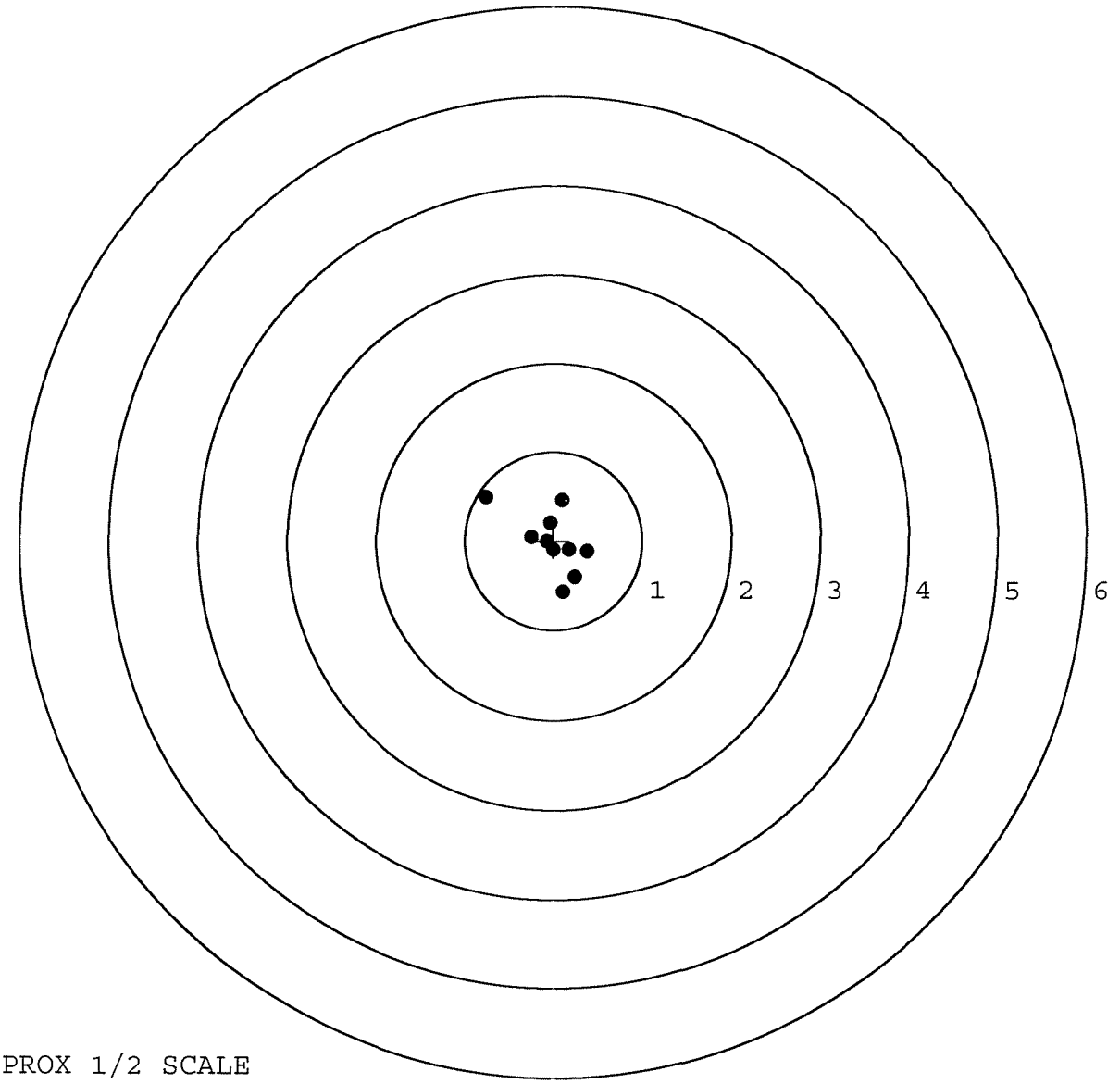


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6523460.__0
TARGET NUMBER: 4
FILE DATE: 05/12/2009
FILE TIME: 12:42

X CENTROID:	-0.010
Y CENTROID:	-0.013
POA TO CENTROID:	0.016
HORZ SPREAD:	1.148
VERT SPREAD:	1.066
GROUP SPREAD:	1.378
MIN RADIUS:	0.064
MAX RADIUS:	0.903
MEAN RADIUS:	0.367
# IN 1 IN DIAMETER:	8
# IN 2 IN DIAMETER:	10
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	-0.762	0.487
2:	0.095	0.460
3:	0.386	-0.120
4:	0.241	-0.410
5:	0.111	-0.579
6:	0.179	-0.106
7:	-0.037	0.204
8:	-0.248	0.045
9:	-0.074	-0.009
10:	0.005	-0.100

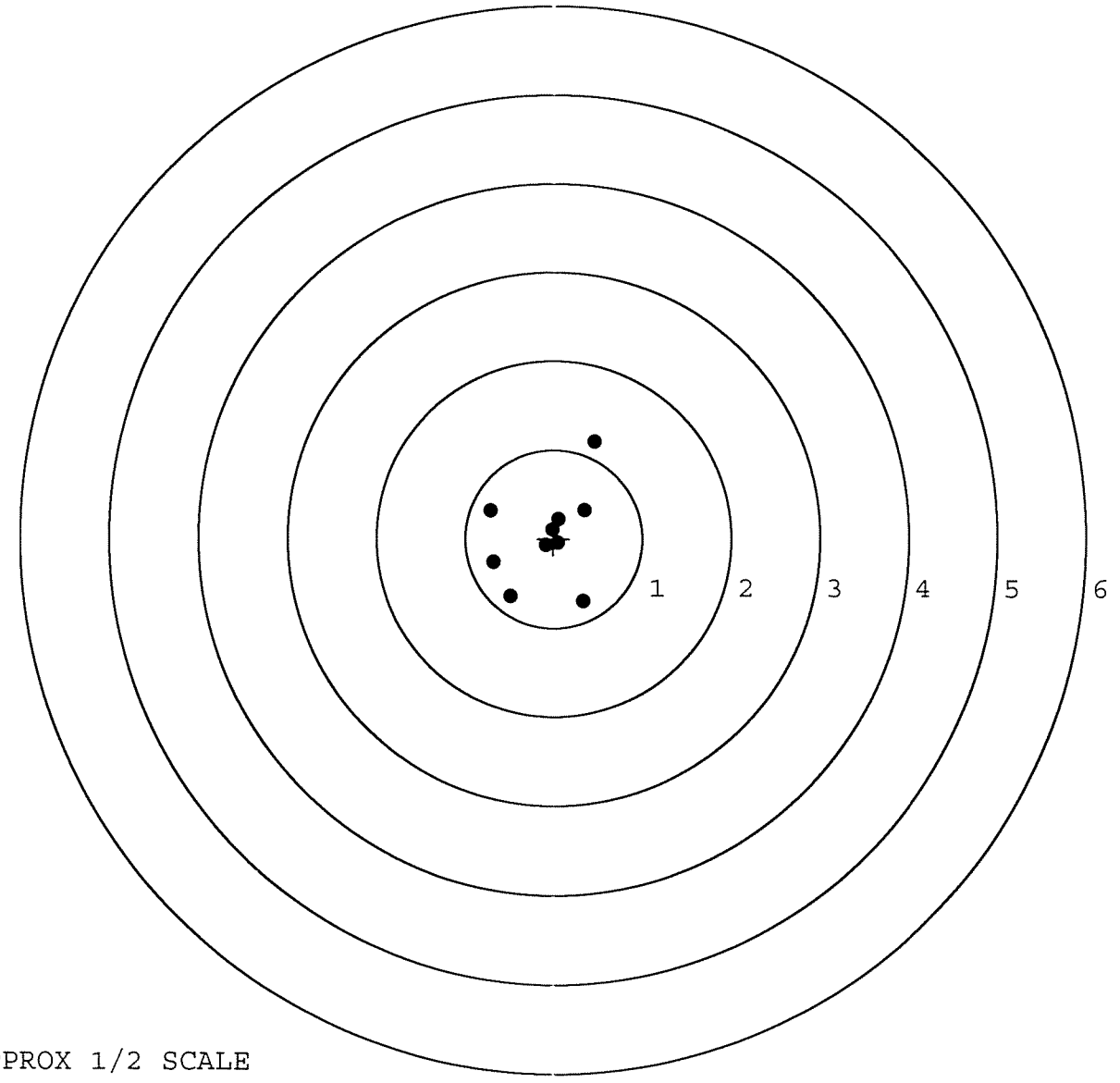


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6523460.__0
TARGET NUMBER: 5
FILE DATE: 05/12/2009
FILE TIME: 12:42

X CENTROID:	-0.075
Y CENTROID:	0.031
POA TO CENTROID:	0.081
HORZ SPREAD:	1.176
VERT SPREAD:	1.793
GROUP SPREAD:	1.983
MIN RADIUS:	0.092
MAX RADIUS:	1.187
MEAN RADIUS:	0.531
# IN 1 IN DIAMETER:	4
# IN 2 IN DIAMETER:	9
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	0.462	1.090
2:	-0.714	0.317
3:	-0.686	-0.269
4:	-0.492	-0.648
5:	0.334	-0.703
6:	0.352	0.326
7:	0.057	0.224
8:	-0.017	0.102
9:	-0.091	-0.079
10:	0.049	-0.053



TARGET APPROX 1/2 SCALE

Remington®

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

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

MODEL 700™ M24

SERIAL NO.
C6523460

ORDER NO.
5716

01

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

5716 C6523460

UPC

0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6523460

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		10/2/90	[illegible]
600	Proof		10/2/90	[illegible]
607	Check Headspace		10/2/90	[illegible]
610	Dis-assemble Gun		10/2/90	[illegible]
612	Magnaflux Barrel Action		10/5/90	KR
	Magnaflux Bolt		10/5/90	KR
615	Rollmark Caliber		10/5/90	[illegible]
617	Drill and Tap Sight Holes		10/8/90	[illegible]
618	Polish Barrel RB		10/9/90	[illegible]
620	Apply Coatings (Barrel Action)		10-20-90	[illegible]
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		10/21/90	WB
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/21/90	WB
	C) Inspect Ejector Hole for Chamfer		10/21/90	WB
	D) Oil Firing Pin Ass'y		10/21/90	WB
	E) Adjust Trigger Pull to Min Setting and Stake		10-25-90	PH

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4 1/2	4 1/2	4 1/2			10/26/90	CWB
	G) Safety Off Force	2 1/4	2 1/4	2 1/4			10/26/90	CWB
	H) Trigger Pull Test & Retainability						10-25-90	DH
	I) Firing Pin Indent	.0215	.022	.022			10/26/90	CWB
	J) Assemble Stock						10/26/90	KA
	K) Assemble Swivel Studs						3/NOV90	gss
	L) Attach Front and Rear Sight Assemblies						10/26/90	KA
	M) Iron Sight Alignment						10/26/90	KA
	N) Detach Front & Rear Sights & place in numbered container						10/26/90	KA
	O) Attach Scope to Rifle						10/26/90	KA
	P) Detach & Attach Scope 20 Times						10/26/90	KA
640	Gallery Target & Test						10-27-90	KT
	A) Time						10-27-90	KT
	B) Malfunctions						10-27-90	KT
	C) Pierced Primers						10-27-90	KT
	D) Optical Clearity of Scope						10-27-90	KT
645	Inspect for Live Ammo						10-27-90	KT
655	Final Inspection A) Headspace						3/NOV90	gss
	B) Trigger Pull	238	239	247	235	244	3/NOV90	gss
	C) Function						3/NOV90	gss
660	Pack						12/14/90	NF

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6523460
27 Oct 1990

CENTROIDAL DISTANCES

0	TO	1	.14893
1	TO	2	.444185
1	TO	3	.0784347
1	TO	4	.234546
1	TO	5	.244387

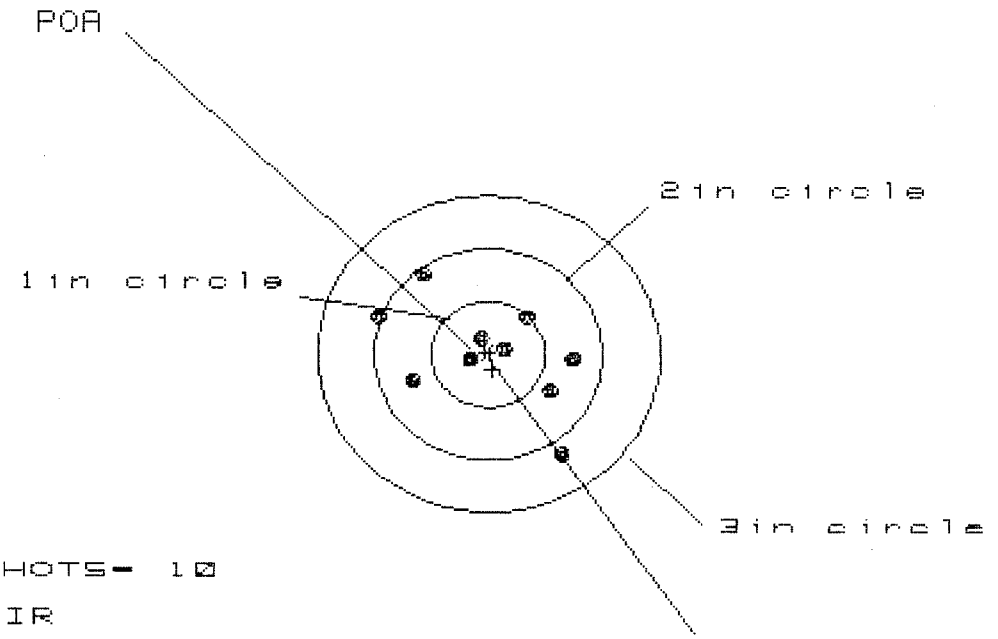
<----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1276
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0122
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .128182

THE AMR FOR THIS RIFLE IS: .837

27 Oct 1990 FILE:/PATTERNING/CENTERFIRE_PATT/C6523460

CENTERFIRE PATTERNS # 1



\# OF SHOTS= 10

\# IN CIR

1in = 4

2in = 8

3in = 10

HS= 1.681

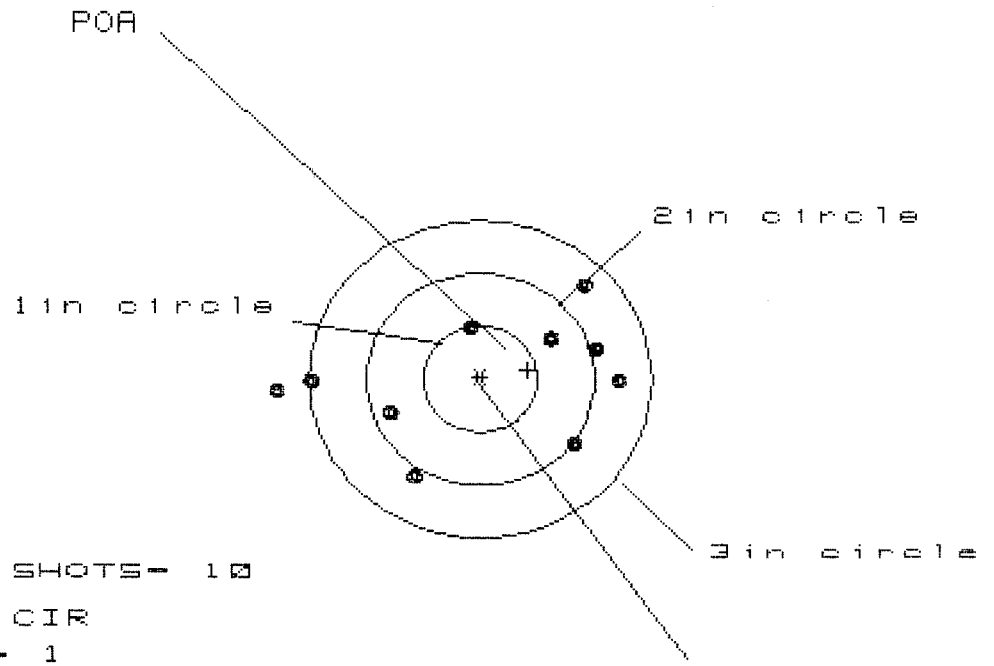
VS= 1.700

GS= 2.069

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.755	.822	.714
MINIMUM X	:	-.926	-.859	-.704
MAXIMUM Y	:	.748	.643	.679
MINIMUM Y	:	-.952	-.487	-.451
CENTROID X	:	-.038	-.105	.003
CENTROID Y	:	.144	.249	.213
POA TO CENTROID in.	:	.148	.270	.213
MIN RADIUS	:	.172	.101	.132
MEAN RADIUS	:	.626	.560	.505
MAX RADIUS	:	1.127	.906	.917
HORIZONTAL SPREAD	:	1.681	1.681	1.418
VERTICAL SPREAD	:	1.700	1.130	1.130
EXTREME SPREAD	:	2.069	1.746	1.597
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	

27 Oct 1998 FILE:/PATTERNING/CENTERFIRE_PATT/C6523480

CENTERFIRE PATTERNS # 2

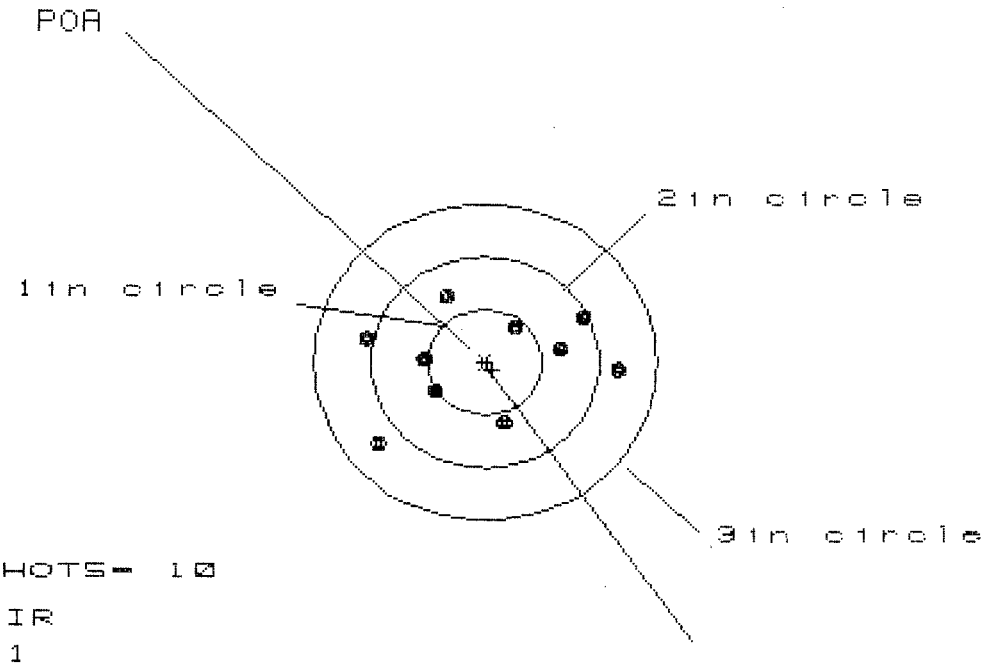


# OF SHOTS= 10
# IN CIR
1in = 1
2in = 3
3in = 9
HS= 2.989
VS= 1.730
GS= 2.992

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.243	1.049	.844
MINIMUM X	:	-1.746	-1.642	-1.212
MAXIMUM Y	:	.838	.822	.816
MINIMUM Y	:	-.892	-.908	-.914
CENTROID X	:	-.418	-.224	-.019
CENTROID Y	:	-.086	-.071	-.064
POA TO CENTROID in.	:	.427	.235	.067
MIN RADIUS	:	.476	.518	.393
MEAN RADIUS	:	1.093	.989	.867
MAX RADIUS	:	1.751	1.643	1.338
HORIZONTAL SPREAD	:	2.989	2.691	2.056
VERTICAL SPREAD	:	1.730	1.730	1.730
EXTREME SPREAD	:	2.992	2.691	2.300
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		9	

27 Oct 1998 FILE:/PATTERNING/CENTERFIRE_PATT/C6523460

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

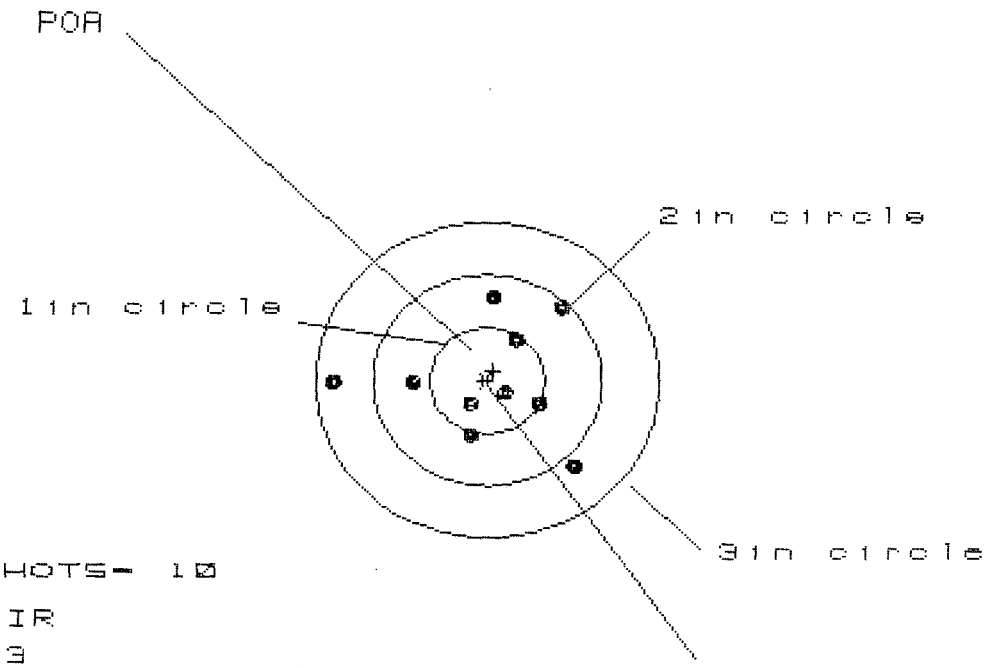
# IN CIR	
1in	= 1
2in	= 7
3in	= 10

HS= 2.203
VS= 1.420
GS= 2.242

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.196	1.094	.865
MINIMUM X	:	-1.006	-1.109	-.973
MAXIMUM Y	:	.637	.550	.532
MINIMUM Y	:	-.783	-.695	-.713
CENTROID X	:	-.064	.039	-.098
CENTROID Y	:	.070	.157	.175
POA TO CENTROID in.	:	.095	.162	.200
MIN RADIUS	:	.387	.256	.340
MEAN RADIUS	:	.785	.726	.672
MAX RADIUS	:	1.212	1.121	.983
HORIZONTAL SPREAD	:	2.203	2.203	1.837
VERTICAL SPREAD	:	1.420	1.245	1.245
EXTREME SPREAD	:	2.242	2.224	1.844
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

27 Oct 1998 FILE:/PATTERNING/CENTERFIRE_PATT/C6523460

CENTERFIRE PATTERNS # 4



OF SHOTS= 10

# IN CIR
1in = 3
2in = 8
3in = 10

HS= 2.033
VS= 1.630
GS= 2.195

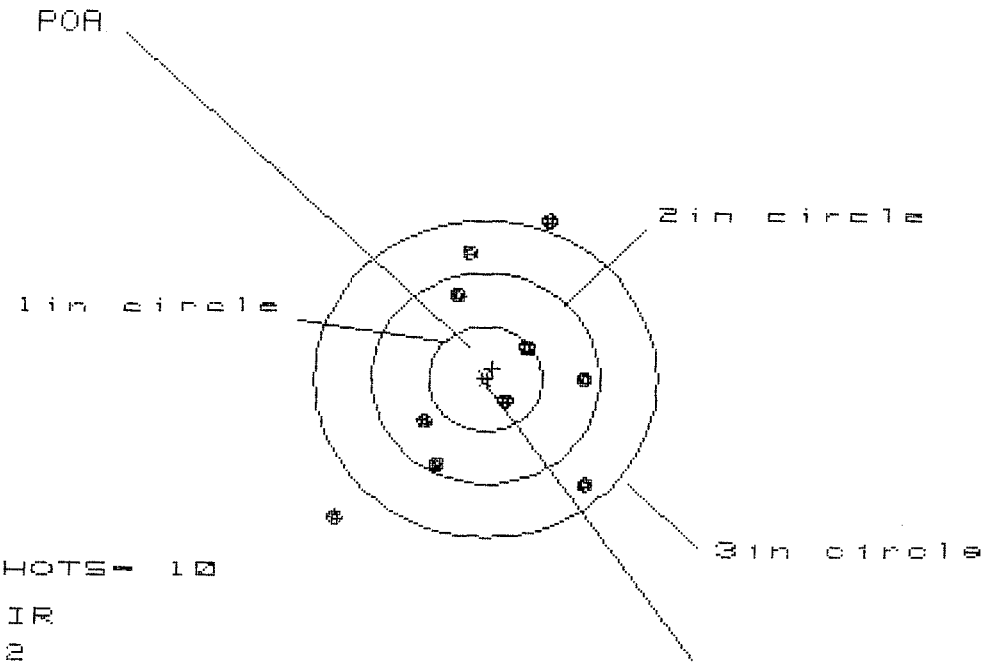
PATTERN # : 4

SHOTS (BEST OF) :	10	9	8
MAXIMUM X :	.720	.574	.558
MINIMUM X :	-1.313	-.816	-.744
MAXIMUM Y :	.838	.841	.743
MINIMUM Y :	-.792	-.789	-.605
CENTROID X :	-.054	.092	.020
CENTROID Y :	-.090	-.094	.004
POA TO CENTROID in.:	.105	.132	.020
MIN RADIUS :	.181	.147	.243
MEAN RADIUS :	.682	.599	.558
MAX RADIUS :	1.313	.976	.837
HORIZONTAL SPREAD :	2.033	1.390	1.302
VERTICAL SPREAD :	1.630	1.630	1.348
EXTREME SPREAD :	2.195	1.747	1.507

NUMBER IN ONE INCH CIRCLE = 3
NUMBER IN TWO INCH CIRCLE = 8
NUMBER IN THREE INCH CIRCLE = 10

27 Oct 1998 FILE:/PATTERNING/CENTERFIRE_PATT/C6523460

CENTERFIRE PATTERNS # 5



OF SHOTS= 10

# IN CIR	
1in	= 2
2in	= 6
3in	= 8

HS= 2.260
VS= 2.727
GS= 3.352

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.884	.731	.784
MINIMUM X	:	-1.376	-.678	-.625
MAXIMUM Y	:	1.456	1.314	1.192
MINIMUM Y	:	-1.272	-1.151	-.987
CENTROID X	:	-.064	.089	.036
CENTROID Y	:	-.099	.043	-.122
POA TO CENTROID in.	:	.118	.098	.127
MIN RADIUS	:	.278	.264	.197
MEAN RADIUS	:	.999	.879	.805
MAX RADIUS	:	1.873	1.380	1.260
HORIZONTAL SPREAD	:	2.260	1.409	1.409
VERTICAL SPREAD	:	2.727	2.465	2.178
EXTREME SPREAD	:	3.352	2.500	2.424
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

SWS TRIGGER PULL TEST

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

SERIAL NO. C6523460

DATE 10-24-90

TESTER D.H

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.57	2.51	2.52	2.38	MIN. SETTING,
PULL #2	2.53	2.60	2.62	2.39	NO AVG. OF 5
PULL #3	2.61	2.58	2.56	2.47	READINGS ACCEPT-
PULL #4	2.48	2.51	2.55	2.35	ABLE LESS THAN 2#
PULL #5	2.49	2.39	2.63	2.44	
TOTAL	12.68	12.59	12.88		
AVG.	2.53	2.51	2.57		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.27	3.09		
PULL #2	3.16	3.19		
PULL #3	3.19	3.37		
PULL #4	3.19	3.39		
PULL #5	3.15	3.14		
TOTAL	15.96	16.18		
AVG.	3.19	3.23		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.30	4.30		4.09
PULL #2	4.32	4.18		4.14
PULL #3	4.40	4.43		4.11
PULL #4	4.23	4.14		4.01
PULL #5	4.20	4.21		4.00
TOTAL	21.45	21.26		20.35
AVG.	4.29	4.25		4.07