

06523472

MODEL 700™ M24

Model **SWS**™

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

Remington

Sweat®

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: **RE00072621** Serial: C6523472 5TH Model 700 Center Fire Repairman: _____
 Verify Repair: **High Priority** Caliber: 7.62 NATO M24 SWS Produced: 12/18/1990 Status: **Closed 11/6/2003 10:30:42 AM**

Address Information

Customer: _____ Received From: _____ Return To: _____ Received From: _____
 Name: **USPFO FOR TEXAS** **USPFO FOR TEXAS**
 Address 1: **2200 W 35TH ST BLDG 72** **2200 W 35TH ST BLDG 72**
 Address 2: **CAMP MABRY** PO Box: _____ **CAMP MABRY** PO Box: _____
 City: **AUSTIN** **AUSTIN**
 State: **TX** Zip Code: **78763** Country: **US** State: **TX** Zip Code: **78763** Country: **US**

ScreenPrint32 v3.1 - Currently Unregistered
 Printing Image to '<Default Printer>'. Please Wait...

Contact / Condition **Shipping / Billing**

Contact Information: _____ Received: _____

Phone: **512 782 5831 *** Fair _____
 Fax: _____ Condition Notes: _____
 Email: _____ CSR Notes: _____
 Comments: ***SSG Timothy Osborne**

Code	Desc	Qty
A007	With Studs	3
A017	Scope Base	1

Repair Search **Refresh** **Close**

magletj 11/7/2003 7:29 AM CAPS NUM INS SCRL

start 3 Microsoft C... 4 Microsoft EX... Arms Services R... 2 Internet EX... 7:29 AM

Serial Number: **C6523472**
 Model: **700**

RE00072621

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6523472. __0
FILE DATE AND TIME: 01/20/2004 08:53

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.041
The Average Y Centroid of the Five Target Set:	0.216
The Average Point of Impact of the Five Target Set:	0.220
The Average Mean Radius of the Five Target Set:	0.636
The Distance from POA to Centroid Target #1:	0.358
The Distance from Centroid Target #2 to Centroid Target #1:	0.288
The Distance from Centroid Target #3 to Centroid Target #1:	0.104
The Distance from Centroid Target #4 to Centroid Target #1:	0.301
The Distance from Centroid Target #5 to Centroid Target #1:	0.330

SERIAL NUMBER: C6523472. __0

TARGET NUMBER: 1

FILE DATE: 01/20/2004

FILE TIME: 08:53

POINT#	X	Y
1:	0.573	1.072
2:	0.861	0.374
3:	0.319	0.497
4:	-0.213	0.728
5:	-1.190	1.474
6:	0.057	-0.772
7:	-0.096	-0.160
8:	0.311	0.054
9:	-0.316	0.178
10:	0.150	0.106

X CENTROID: 0.046

Y CENTROID: 0.355

POA TO CENTROID: 0.358

HORZ SPREAD: 2.051

VERT SPREAD: 2.246

GROUP SPREAD: 2.569

MIN RADIUS: 0.270

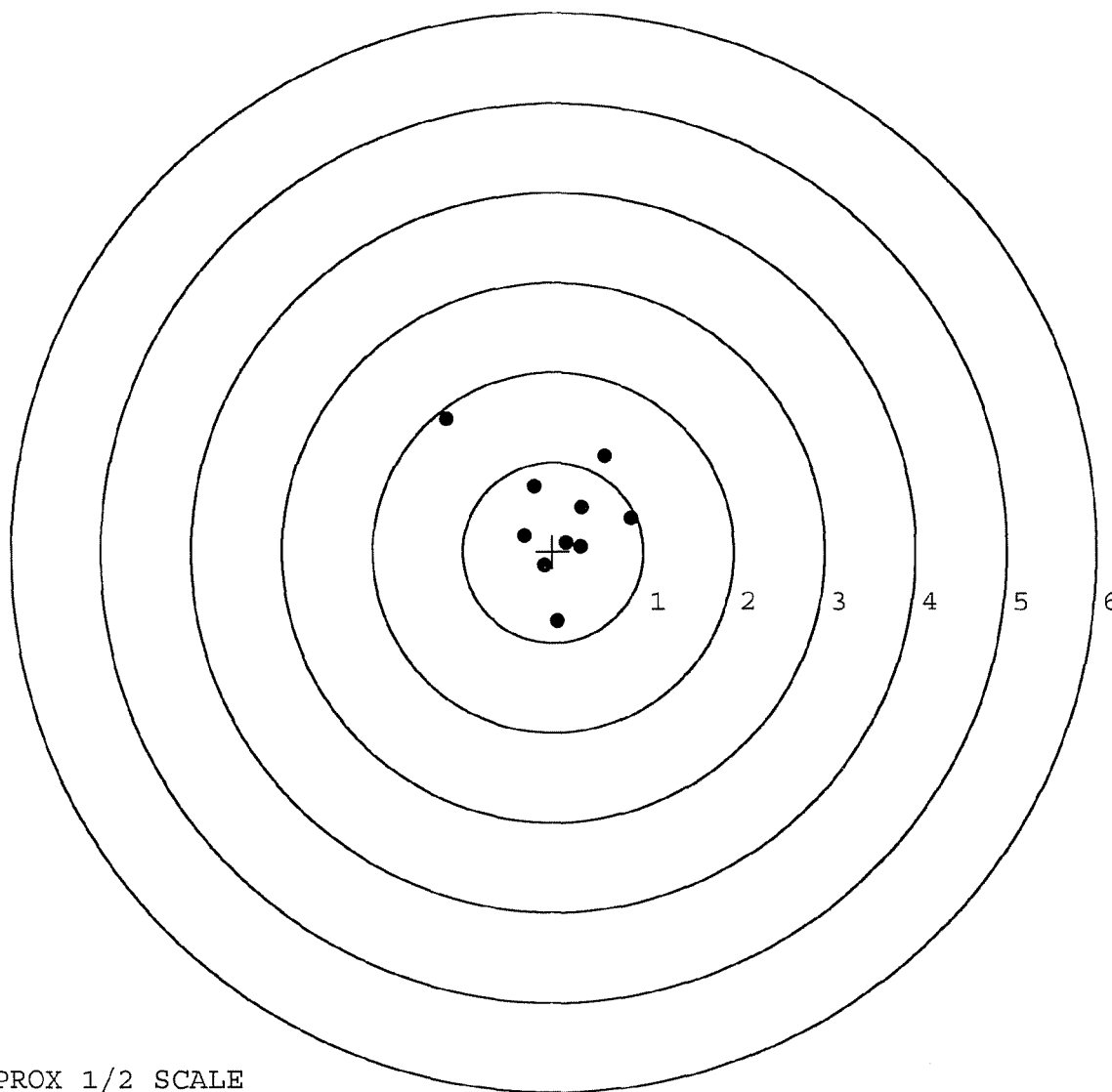
MAX RADIUS: 1.667

MEAN RADIUS: 0.687

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6523472. __0

TARGET NUMBER: 2

FILE DATE: 01/20/2004

FILE TIME: 08:53

POINT#	X	Y
1:	1.453	0.766
2:	0.613	-0.079
3:	0.368	-0.724
4:	0.204	-0.512
5:	-0.518	-0.065
6:	-0.030	-0.146
7:	0.119	0.235
8:	-0.070	0.261
9:	0.141	0.726
10:	-0.090	0.793

X CENTROID: 0.219

Y CENTROID: 0.125

POA TO CENTROID: 0.252

HORZ SPREAD: 1.971

VERT SPREAD: 1.517

GROUP SPREAD: 2.139

MIN RADIUS: 0.148

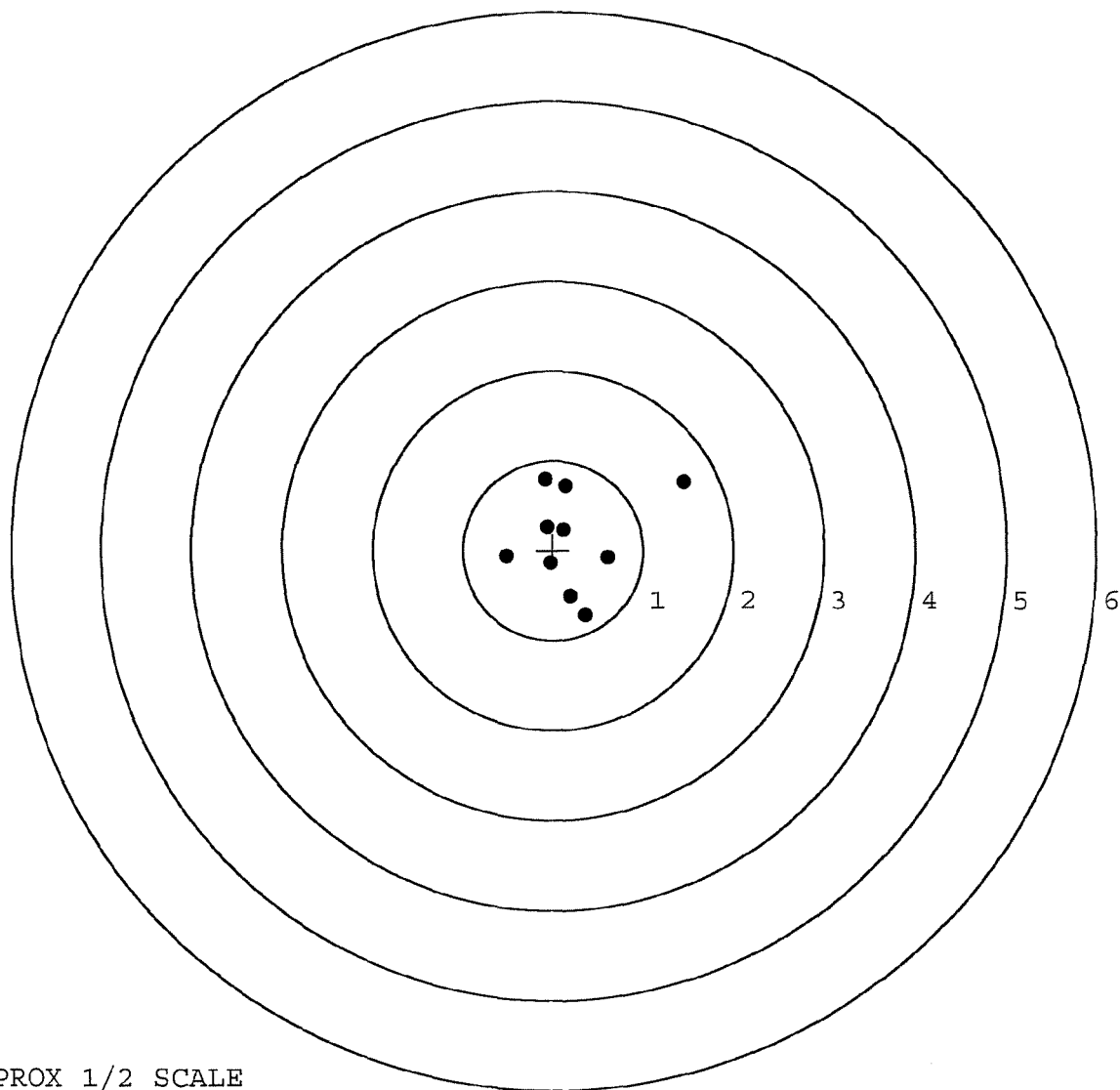
MAX RADIUS: 1.390

MEAN RADIUS: 0.627

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10

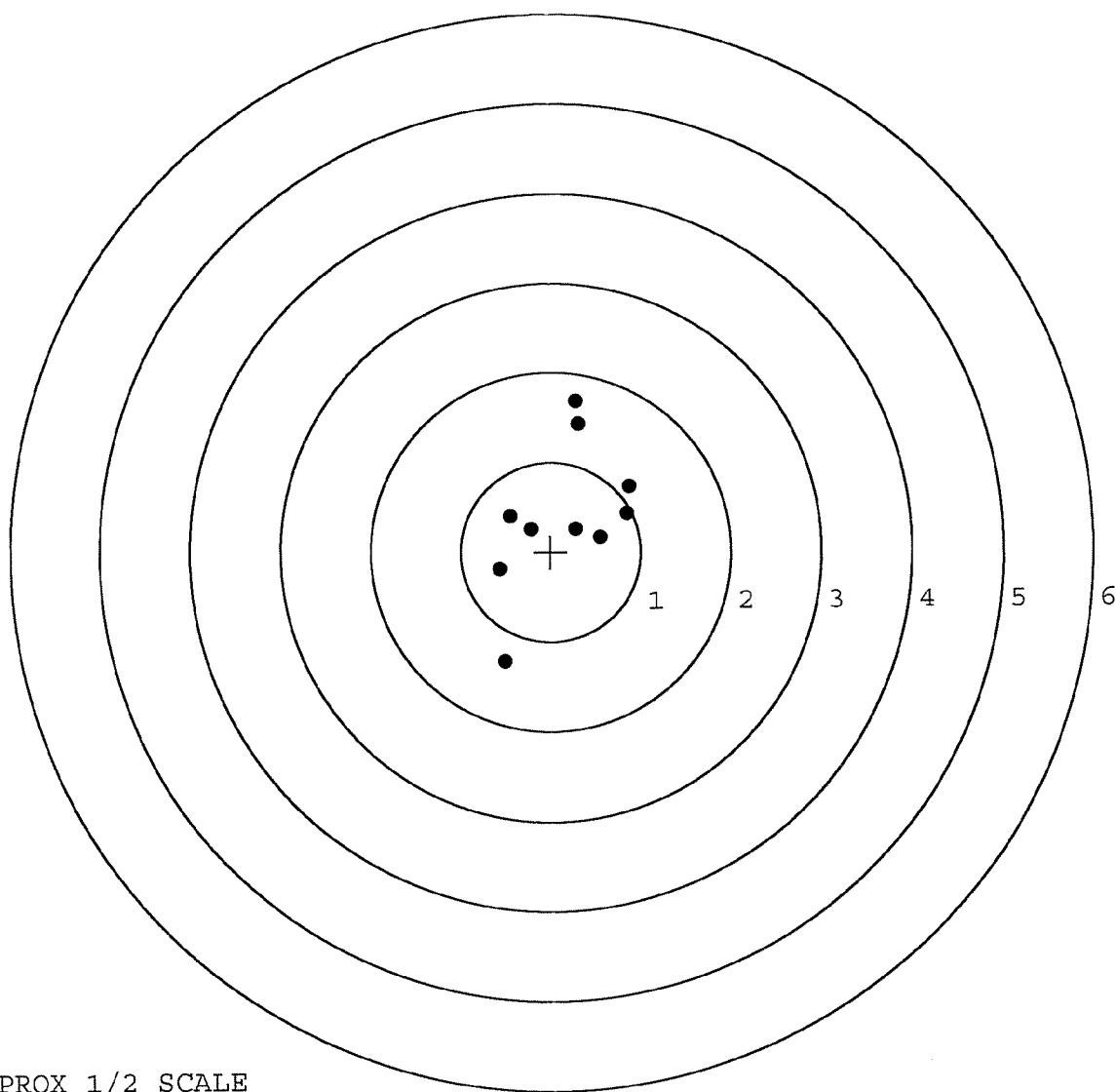


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6523472.____0
TARGET NUMBER: 3
FILE DATE: 01/20/2004
FILE TIME: 08:53

X CENTROID: 0.142
Y CENTROID: 0.393
POA TO CENTROID: 0.418
HORZ SPREAD: 1.448
VERT SPREAD: 2.901
GROUP SPREAD: 3.011
MIN RADIUS: 0.199
MAX RADIUS: 1.745
MEAN RADIUS: 0.816
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 9

POINT#	X	Y
1:	0.290	1.678
2:	0.316	1.421
3:	-0.571	-0.187
4:	-0.516	-1.223
5:	-0.450	0.405
6:	-0.214	0.259
7:	0.284	0.254
8:	0.554	0.166
9:	0.852	0.429
10:	0.877	0.729



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6523472. 0

TARGET NUMBER: 4

FILE DATE: 01/20/2004

FILE TIME: 08:53

POINT#	X	Y
1:	0.498	1.345
2:	-0.525	1.112
3:	-0.298	0.405
4:	-1.020	0.197
5:	-0.665	0.381
6:	-0.902	-0.733
7:	-0.139	-0.158
8:	0.342	-0.037
9:	0.367	-0.206
10:	0.353	-0.512

X CENTROID: -0.199

Y CENTROID: 0.179

POA TO CENTROID: 0.268

HORZ SPREAD: 1.518

VERT SPREAD: 2.078

GROUP SPREAD: 2.506

MIN RADIUS: 0.246

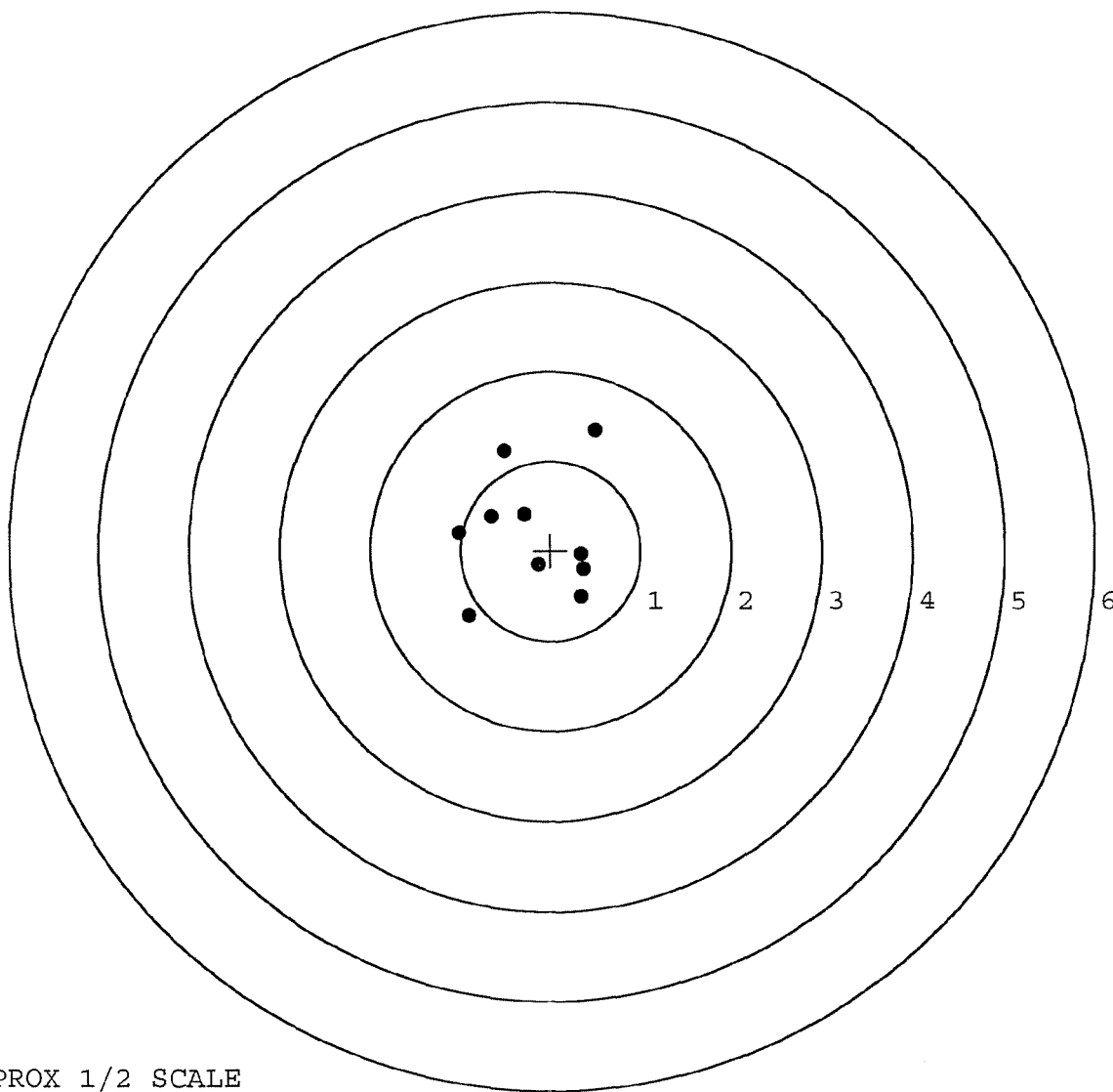
MAX RADIUS: 1.358

MEAN RADIUS: 0.757

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6523472.___0

TARGET NUMBER: 5

FILE DATE: 01/20/2004

FILE TIME: 08:53

X CENTROID: -0.005

Y CENTROID: 0.029

POA TO CENTROID: 0.029

HORZ SPREAD: 0.621

VERT SPREAD: 0.831

GROUP SPREAD: 0.856

MIN RADIUS: 0.085

MAX RADIUS: 0.495

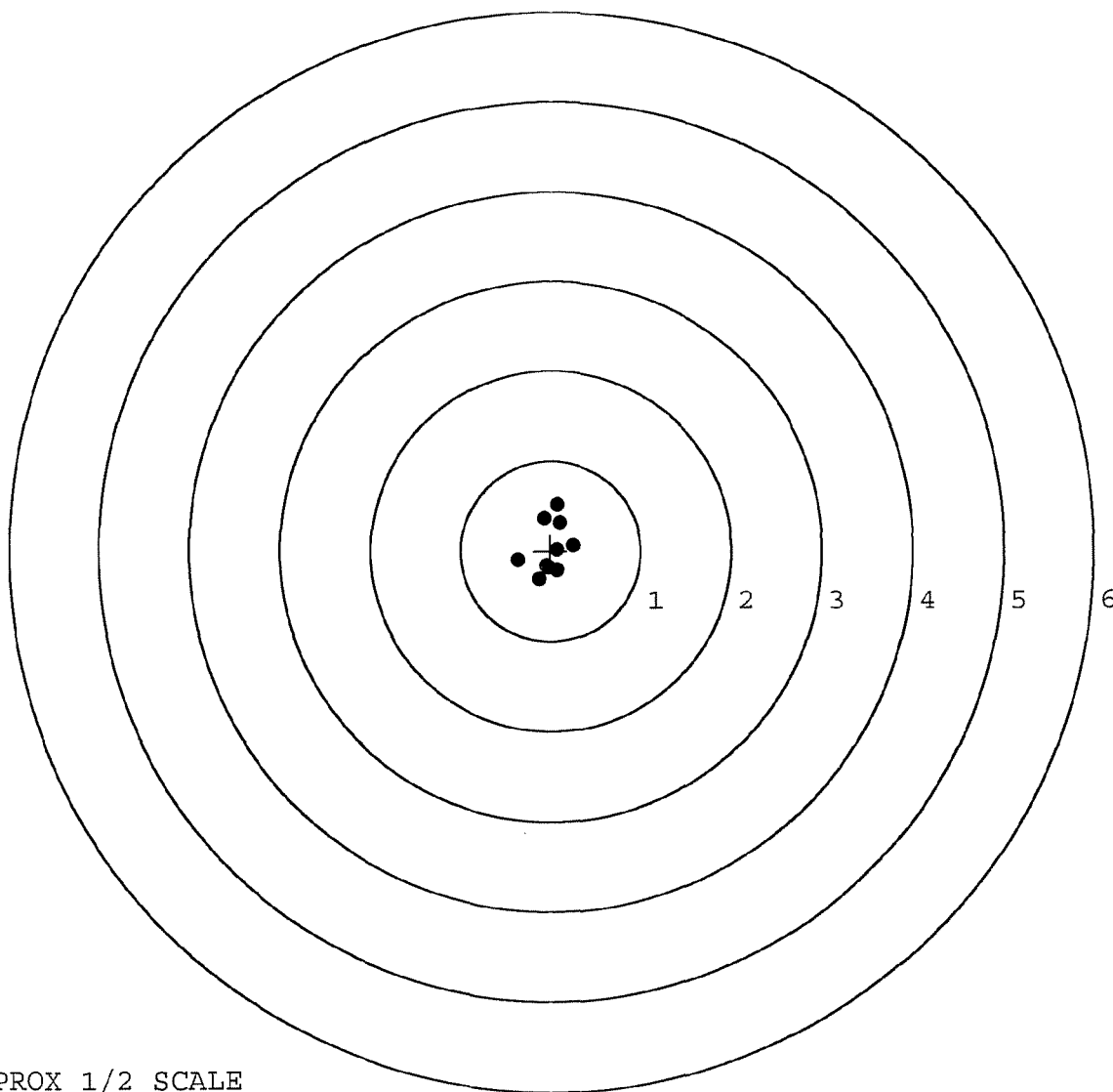
MEAN RADIUS: 0.291

IN 1 IN DIAMETER: 10

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.362	-0.105
2:	-0.128	-0.314
3:	0.075	-0.218
4:	0.259	0.065
5:	0.106	0.314
6:	0.076	0.517
7:	-0.049	-0.171
8:	-0.074	0.361
9:	0.079	0.017
10:	-0.030	-0.180



TARGET APPROX 1/2 SCALE

M-24 INSPECTION CHECKLIST
CONTRACT #: DAAE-20-02-D-0127

R & E NUMBER	7262		
SERIAL NUMBER	C6523472		
LOG-IN DATE	11-6-03		
INSPECT AND VERIFY:			
OPERATION #	OPERATION NAME	DATE	INITIAL
550	DIS-ASSEMBLE GUN	12-23-03	RTL
560 A	RE-BARREL	1-7-04	RTL
B	DRILL AND TAP	1-9-04	TRW
575	ASSEMBLE	1-8-04	RTL
600	PROOF	1-8-04	RW
605	CHECK HEADSPACE	1-8-04	RW
610	DIS-ASSEMBLE GUN	1-8-04	RW
612	MAGNAFLUX		
615	ROLLMARK CALIBER	1-13-04	AB
618	ROTO-BLAST	1/13/2004	Dons
620	APPLY COATINGS	1-15	TA
625 A	FINAL ASSEMBLY	1-16-04	RW
B	TRIGGER PULL TEST		
C	SAFETY "ON" FORCE		
D	SAFETY "OFF" FORCE		
E	FIRING PIN INDENT		
640	TARGET	1-20-04	AC
655	FINAL INSPECT	1-21-04	RW
660	PACK	1-22-04	RA
		SHIP DATE	
QAR INSPECTION DATE			




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

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

MODEL 700™ M24

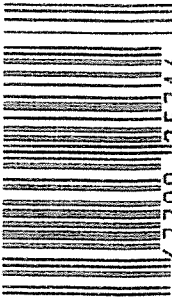
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SERIAL NO. C6523472

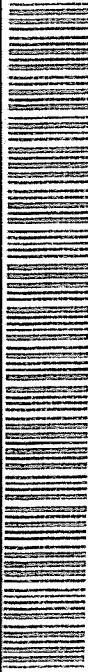
ORDER NO. 5716

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

UPC



0 47700 25716 7



5716 C6523472

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C 6523472

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		10/2/90	Kel
600	Proof		10/2/90	Kel
607	Check Headspace		10/2/90	Kel
610	Dis-assemble Gun		10/2/90	Kel
612	Magnaflux Barrel Action		10/5/90	KR
	Magnaflux Bolt		10/5/90	KR
615	Rollmark Caliber		10/5/90	YX
617	Drill and Tap Sight Holes		10/8/90	LB
618	Polish Barrel RB		10/9/90	WB
620	Apply Coatings (Barrel Action)		10-20-90	TH
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		11/7/90	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		11/7/90	KS
	C) Inspect Ejector Hole for Chamfer		11/7/90	KS
	D) Oil Firing Pin Ass'y		11/7/90	KS
	E) Adjust Trigger Pull to Min Setting and Stake		11-7-90	KS

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	4 1/2	4 3/4			11/7/90	KS
	G) Safety Off Force	2	2 1/4	2 1/4			11/7/90	KS
	H) Trigger Pull Test & Retainability						11-7-90	DL
	I) Firing Pin Indent	.021	.022	.023			11/7/90	KS
	J) Assemble Stock						11/8/90	KS
	K) Assemble Swivel Studs						11-9-90	DH
	L) Attach Front and Rear Sight Assemblies						11/8/90	KS
	M) Iron Sight Alignment						11/8/90	KS
	N) Detach Front & Rear Sights & place in numbered container						11/8/90	KS
	O) Attach Scope to Rifle						11/8/90	KS
	P) Detach & Attach Scope 20 Times						11/8/90	KS
640	Gallery Target & Test						11-7-90	AC
	A) Time						11-9-90	AC
	B) Malfunctions						11-9-90	AC
	C) Pierced Primers						11-9-90	AC
	D) Optical Clarity of Scope						11-9-90	AC
645	Inspect for Live Ammo						11-9-90	AC
655	Final Inspection							
	A) Headspace						11-19-90	DH
	B) Trigger Pull	2.25	2.11	2.12	2.02	2.02	11-19-90	DH
	C) Function						11-19-90	DH
660	Pack						12-17-90	DH

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6523472

DATE 11-7-90

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.43	2.38	2.47	2.25	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.38	2.47	2.27	2.11	
PULL #3	2.16	2.40	2.20	2.12	
PULL #4	2.26	2.17	2.30	2.02	
PULL #5	2.34	2.40	2.29	2.02	
TOTAL	11.57	11.82	11.53		
AVG.	2.314	2.364	2.306		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.39	3.43		
PULL #2	3.45	3.46		
PULL #3	3.44	3.43		
PULL #4	3.42	3.40		
PULL #5	3.44	3.41		
TOTAL	17.16	17.13		
AVG.	3.432	3.426		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.40	4.18		4.39
PULL #2	4.47	4.32		4.39
PULL #3	4.42	4.19		4.11
PULL #4	4.30	4.39		4.35
PULL #5	4.32	4.37		4.39
TOTAL	21.91	21.45		21.63
AVG.	4.382	4.29		4.326

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6523472
9 Nov 1990

CENTROIDAL DISTANCES

0 TO	1	.459831
1 TO	2	.474982
1 TO	3	.384749
1 TO	4	.265036
1 TO	5	.28493

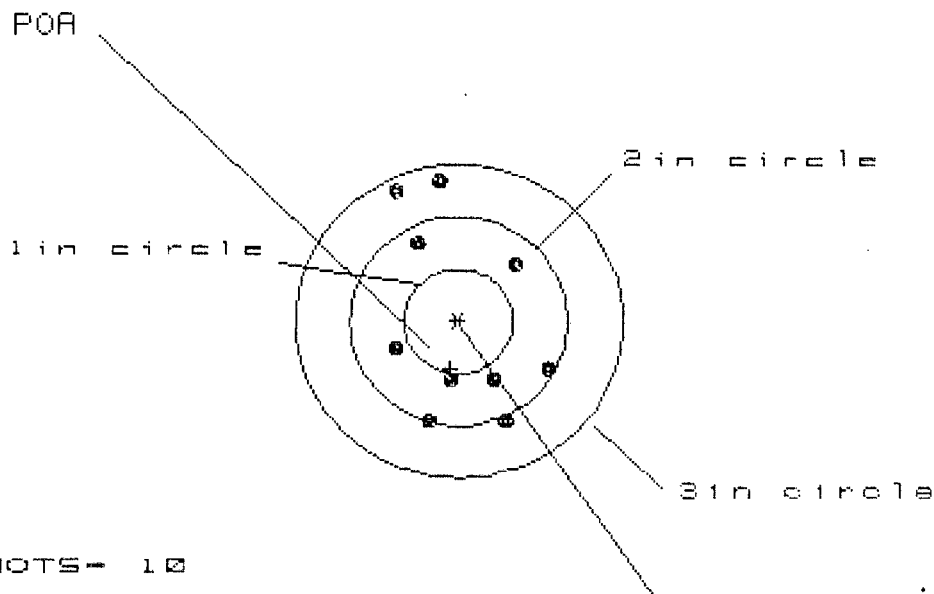
2  <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .006
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .2268
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .226879
THE AMR FOR THIS RIFLE IS: .924

9 Nov 1990

FILE:/PATTERNING/CENTERFIRE_PATT/C6523472

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 0

2 in = 6

3 in = 10

HS= 1.483

VS= 2.336

GS= 2.427

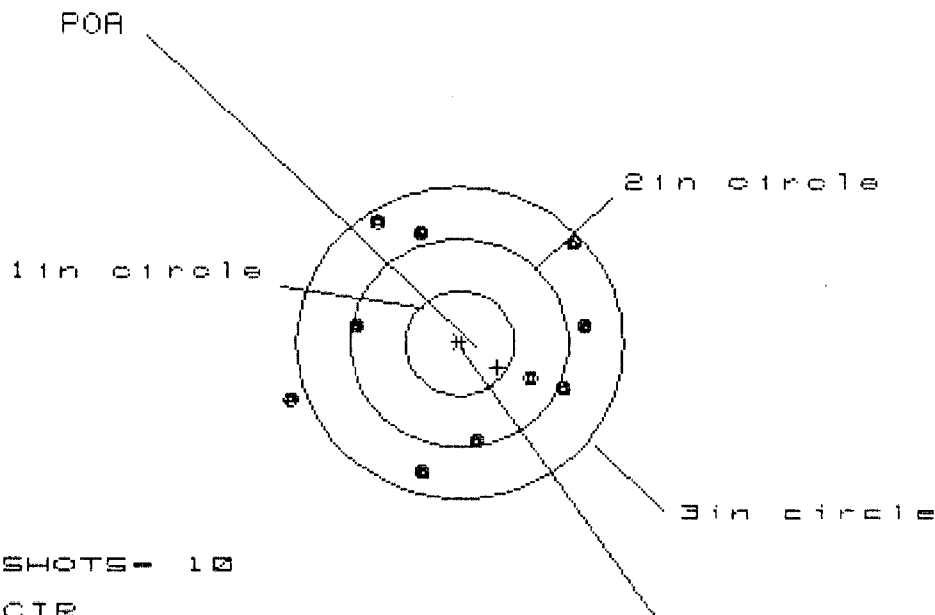
CENTROID *

PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.861	.791	.757
MINIMUM X	:	-.623	-.674	-.708
MAXIMUM Y	:	1.345	1.484	1.058
MINIMUM Y	:	-.992	-.852	-.667
CENTROID X	:	.073	.143	.177
CENTROID Y	:	.454	.314	.129
POA TO CENTROID in.	:	.459	.345	.219
MIN RADIUS	:	.567	.450	.305
MEAN RADIUS	:	.931	.848	.716
MAX RADIUS	:	1.400	1.509	1.176
HORIZONTAL SPREAD	:	1.483	1.465	1.465
VERTICAL SPREAD	:	2.336	2.336	1.725
EXTREME SPREAD	:	2.427	2.366	1.865
NUMBER IN ONE INCH CIRCLE	=	0		
NUMBER IN TWO INCH CIRCLE	=	6		
NUMBER IN THREE INCH CIRCLE	=	10		

9 Nov 1990

FILE:/PATTERNING/CENTERFIRE_PATT/C6523472

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 0

2in = 3

3in = 9

HQ= 2.721

VS= 2.398

GS= 2.994

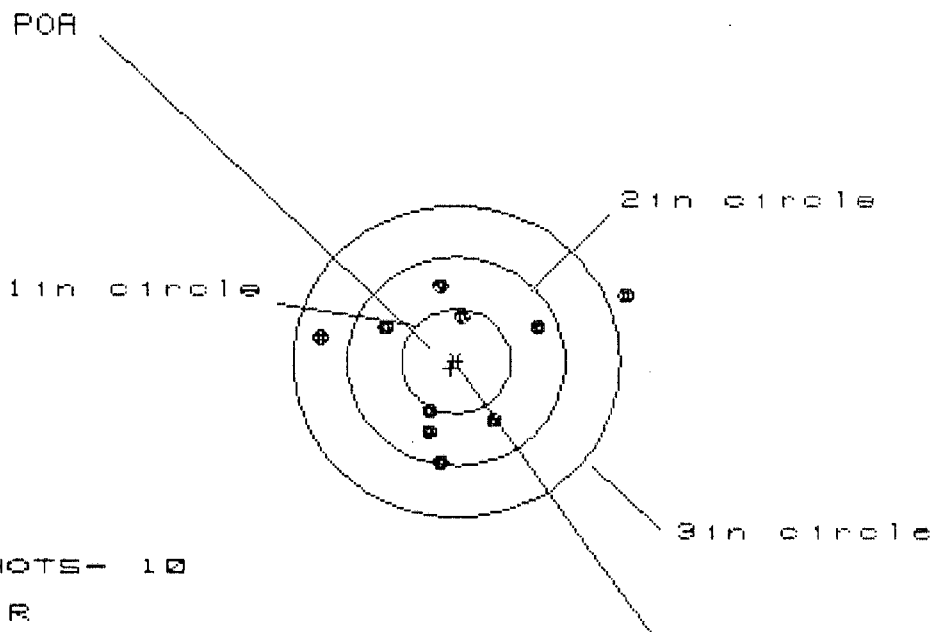
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.143	.967	1.077
MINIMUM X	:	-1.578	-1.111	-1.001
MAXIMUM Y	:	1.169	1.115	1.226
MINIMUM Y	:	-1.229	-1.283	-1.173
CENTROID X	:	-.349	-.173	-.283
CENTROID Y	:	.236	.290	.180
POA TO CENTROID in.	:	.421	.338	.335
MIN RADIUS	:	.748	.638	.663
MEAN RADIUS	:	1.167	1.091	1.064
MAX RADIUS	:	1.652	1.455	1.477
HORIZONTAL SPREAD	:	2.721	2.078	2.078
VERTICAL SPREAD	:	2.398	2.398	2.398
EXTREME SPREAD	:	2.994	2.576	2.435
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		9	

9 Nov 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6523472

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 1

2in = 7

3in = 9

HS= 2.773

VS= 1.721

GS= 2.806

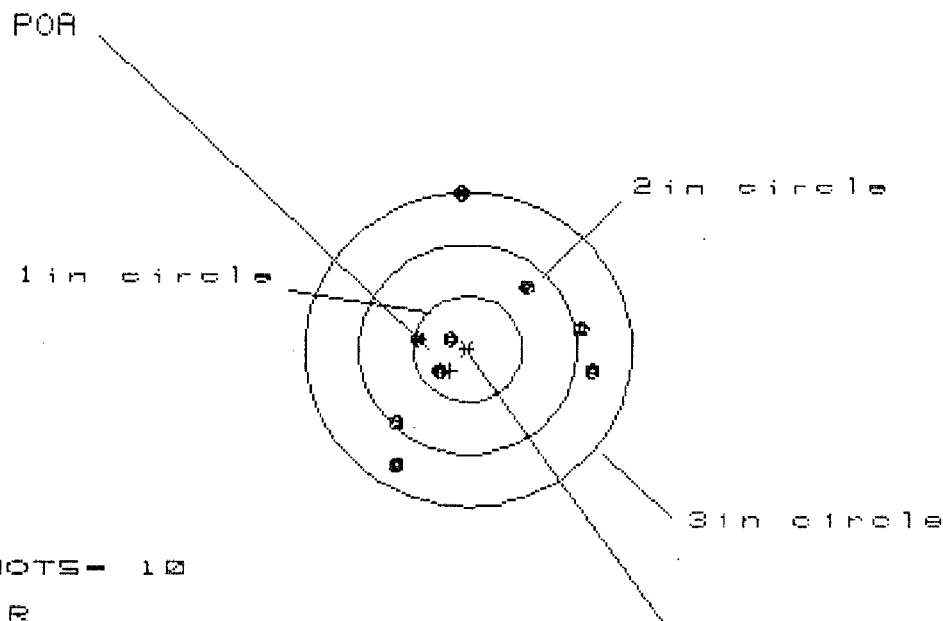
CENTROID #

PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	1.560
MINIMUM X	-1.213
MAXIMUM Y	.720
MINIMUM Y	-1.001
CENTROID X	.049
CENTROID Y	.070
POA TO CENTROID in.	.085
MIN RADIUS	.471
MEAN RADIUS	.857
MAX RADIUS	1.683
HORIZONTAL SPREAD	2.773
VERTICAL SPREAD	1.721
EXTREME SPREAD	2.806
NUMBER IN ONE INCH CIRCLE =	1
NUMBER IN TWO INCH CIRCLE =	7
NUMBER IN THREE INCH CIRCLE =	9

9 Nov 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6523472

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1 in = 4

2 in = 6

3 in = 9

HS= 1.786

VS= 2.640

GS= 2.705

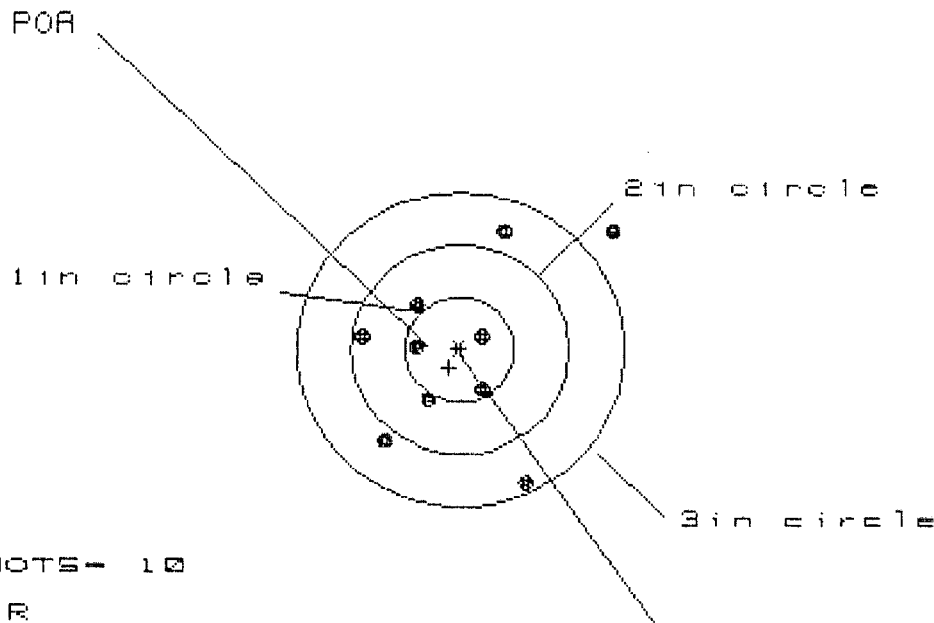
CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.095	1.084	.996
MINIMUM X	:	-.691	-.702	-.767
MAXIMUM Y	:	1.507	.751	.631
MINIMUM Y	:	-1.133	-.966	-.611
CENTROID X	:	.161	.172	.260
CENTROID Y	:	.204	.037	.157
POA TO CENTROID in.	:	.260	.176	.304
MIN RADIUS	:	.195	.295	.304
MEAN RADIUS	:	.807	.723	.674
MAX RADIUS	:	1.510	1.194	1.006
HORIZONTAL SPREAD	:	1.786	1.786	1.763
VERTICAL SPREAD	:	2.640	1.717	1.242
EXTREME SPREAD	:	2.705	2.174	1.903
NUMBER IN ONE INCH CIRCLE	=	4		
NUMBER IN TWO INCH CIRCLE	=	6		
NUMBER IN THREE INCH CIRCLE	=	9		

9 Nov 1990

FILE:/PATTERNING/CENTERFIRE_PATT/C6523472

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 3

2in = 6

3in = 9

HS= 2.218

VS= 2.456

GS= 2.886

CENTROID *

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.361	.731	.604
MINIMUM X	-.857	-.706	-.615
MAXIMUM Y	1.168	1.297	1.152
MINIMUM Y	-1.288	-1.159	-.845
CENTROID X	.096	-.055	-.146
CENTROID Y	.170	.041	.186
POA TO CENTROID in.	.195	.069	.237
MIN RADIUS	.209	.286	.150
MEAN RADIUS	.858	.726	.628
MAX RADIUS	1.787	1.395	1.301
HORIZONTAL SPREAD	2.218	1.437	1.219
VERTICAL SPREAD	2.456	2.456	1.997
EXTREME SPREAD	2.886	2.466	2.277
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		9	