

C6611668

MODEL 700™ M24

Model **SAS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

M-24
INSPECTION CHECKLIST - REPAIRS
CONTRACT #: W52H09-07-C-0207
ISSUED 10/1/2007

R & E NUMBER	<u>152616</u>			
SERIAL NUMBER	<u>C60611668</u>			
LOG-IN DATE	<u>10-3-08</u>			

OPERATION #	OPERATION NAME	DATE	INITIAL	
500	DIS-ASSEMBLE GUN	7-13-09	RT	
505	RE-BARREL	7-16-09	RT	
420	ASSEMBLE	7-16-09	RT	
440	PROOF	7-16-09	RP	
460	CHECK HEADSPACE	7-16-09	RP	
470	DIS-ASSEMBLE GUN	7-16-09	RP	
480	MAGNAFLUX	7-18-09	RP	
510	DRILL AND TAP	7-17-09	SP	
500	ROLLMARK CALIBER	7-21-09	OWP	
520	GOFF BLAST BBL / REC	7-21-09	RP	
530 & 540	APPLY COATINGS	7-28	-	
560	FINAL ASSEMBLY	7-30-09	RT	
640	FUNCTION TEST AND	8-5-09	RP	
650	TARGET	8-5-09	RP	
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION	8/5/09	RP
670	FINAL INSPECTION	8-17-09	RP	
	A) HEADSPACE	PASS	FAIL	
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS		2.50 2.58 2.62 2.65 2.59 8-7-09 LRP
680	F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX	2.4 2.2 2.2 8-17-09	RP
	G) SAFETY OFF FORCE	2 LBS MIN	2.0 3.8 3.8 8-17-09	RP
	I) FIRING PIN INDENT	.020	.028 .028 .028 8-17-09	RP
690	PACK		10/12/09	FM

F006 REV 1/2009

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6611668.___0

FILE DATE AND TIME: 08/07/2009 07:17

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.010
The Average Y Centroid of the Five Target Set:	0.070
The Average Point of Impact of the Five Target Set:	0.071
The Average Mean Radius of the Five Target Set:	0.472
The Distance from POA to Centroid Target #1:	0.033
The Distance from Centroid Target #2 to Centroid Target #1:	0.113
The Distance from Centroid Target #3 to Centroid Target #1:	0.140
The Distance from Centroid Target #4 to Centroid Target #1:	0.105
The Distance from Centroid Target #5 to Centroid Target #1:	0.088

SERIAL NUMBER: C6611668. __0

TARGET NUMBER: 1

FILE DATE: 08/07/2009

FILE TIME: 07:17

POINT#	X	Y
1:	0.393	0.229
2:	0.344	0.029
3:	0.040	-0.333
4:	-0.191	0.215
5:	-0.326	0.152
6:	-0.200	0.019
7:	0.087	-0.033
8:	-0.001	-0.064
9:	0.112	-0.083
10:	-0.056	0.129

X CENTROID: 0.020

Y CENTROID: 0.026

POA TO CENTROID: 0.033

HORZ SPREAD: 0.719

VERT SPREAD: 0.562

GROUP SPREAD: 0.723

MIN RADIUS: 0.089

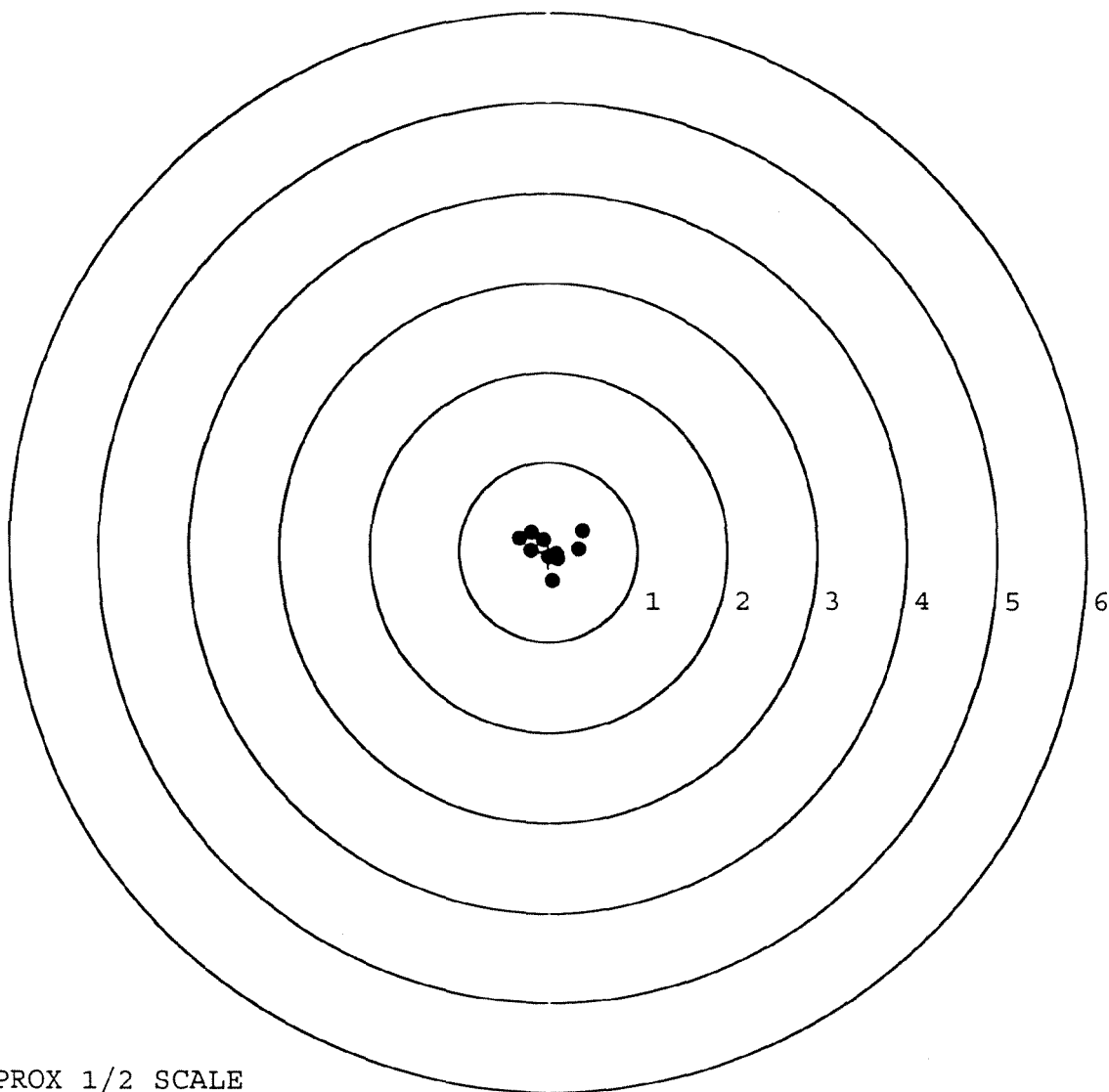
MAX RADIUS: 0.424

MEAN RADIUS: 0.243

IN 1 IN DIAMETER: 10

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10

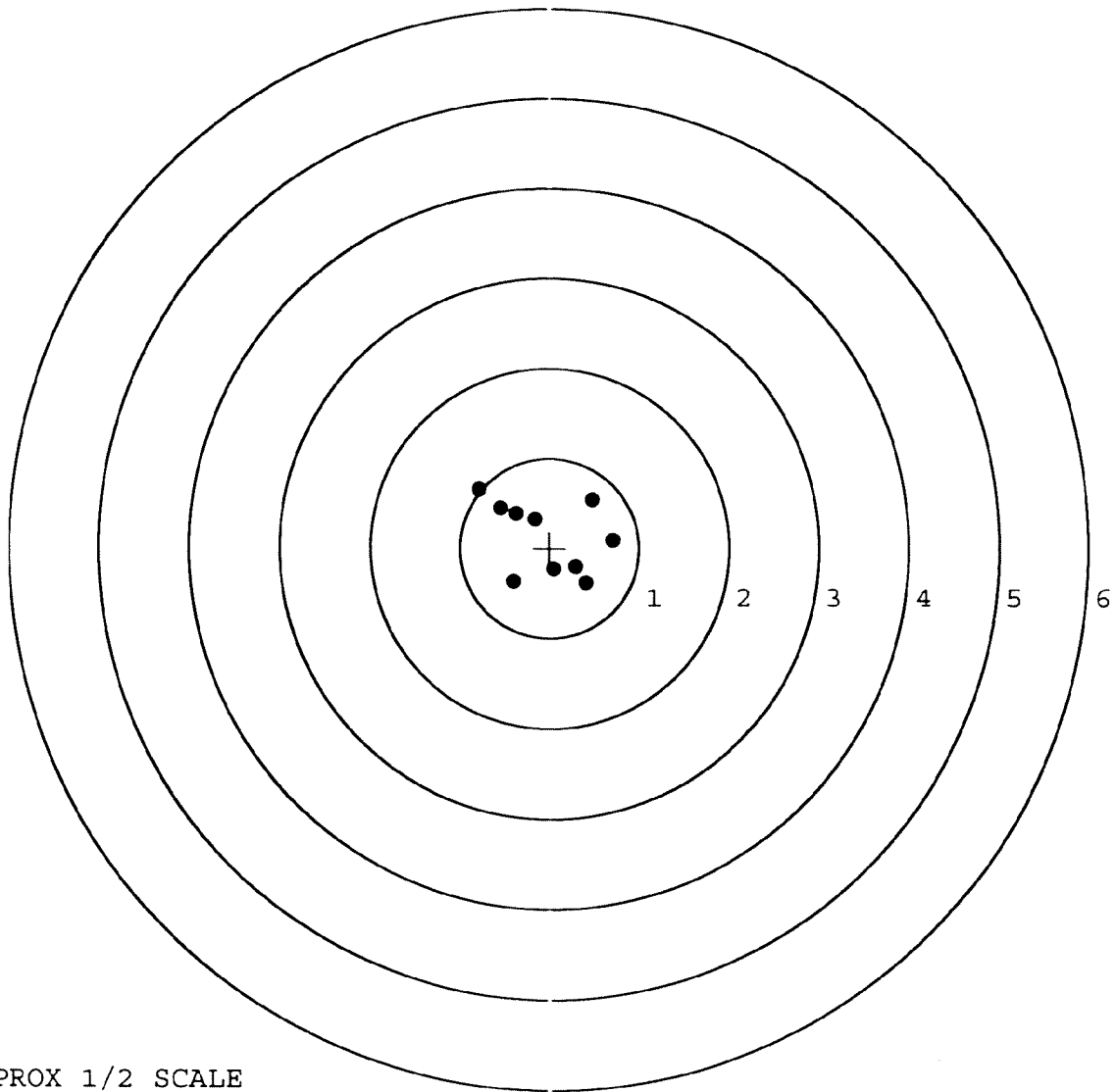


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6611668. 0
TARGET NUMBER: 2
FILE DATE: 08/07/2009
FILE TIME: 07:17

X CENTROID: -0.034
Y CENTROID: 0.125
POA TO CENTROID: 0.129
HORZ SPREAD: 1.501
VERT SPREAD: 1.041
GROUP SPREAD: 1.602
MIN RADIUS: 0.237
MAX RADIUS: 0.925
MEAN RADIUS: 0.575
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 10
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.481	0.542
2:	0.708	0.093
3:	0.408	-0.387
4:	0.296	-0.211
5:	0.050	-0.234
6:	-0.402	-0.377
7:	-0.793	0.654
8:	-0.548	0.450
9:	-0.378	0.393
10:	-0.161	0.325



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6611668. 0

TARGET NUMBER: 3

FILE DATE: 08/07/2009

FILE TIME: 07:17

X CENTROID: -0.069

Y CENTROID: 0.134

POA TO CENTROID: 0.151

HORZ SPREAD: 1.352

VERT SPREAD: 0.994

GROUP SPREAD: 1.478

MIN RADIUS: 0.257

MAX RADIUS: 0.767

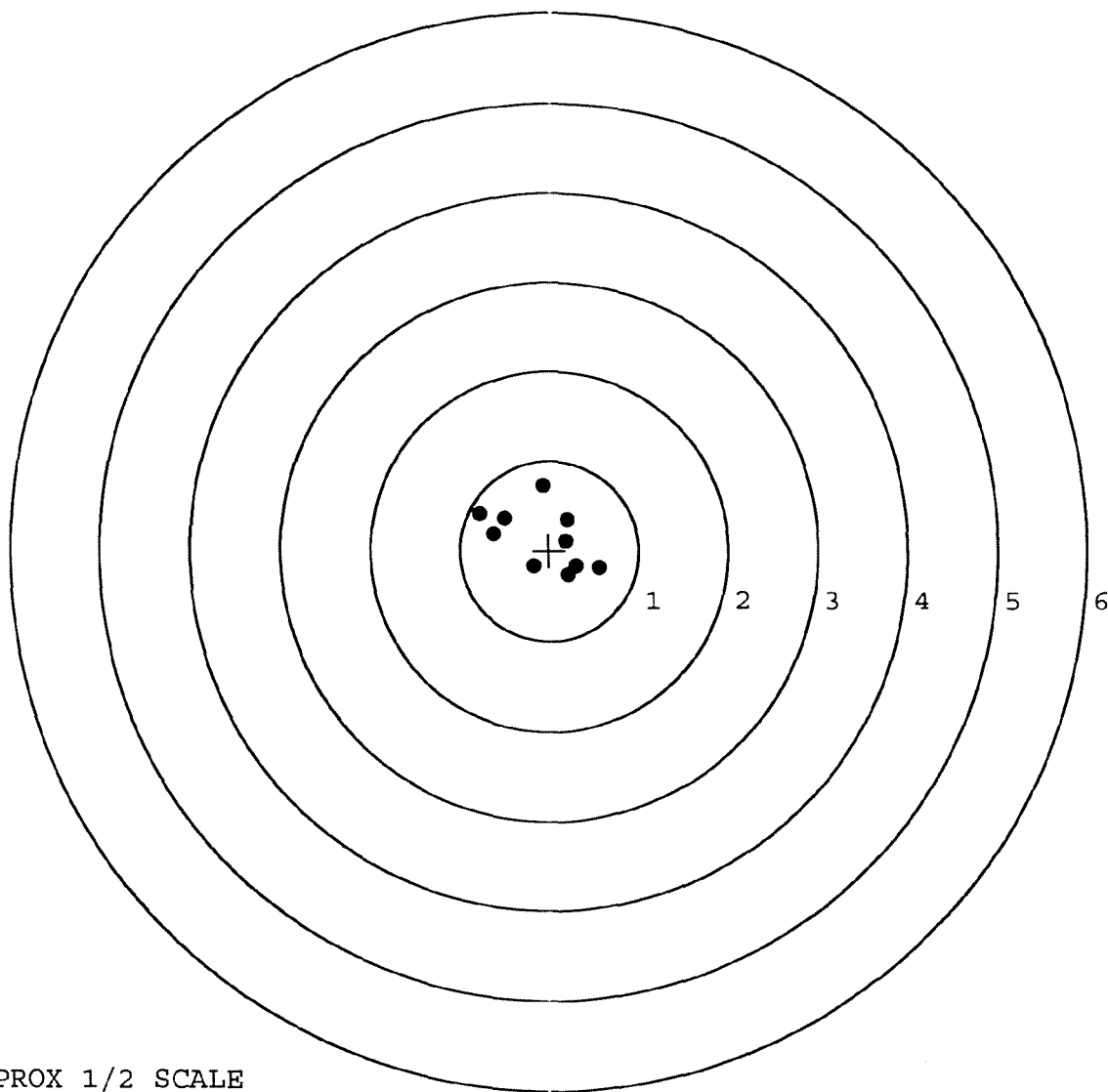
MEAN RADIUS: 0.502

IN 1 IN DIAMETER: 6

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.072	0.724
2:	0.200	0.347
3:	0.187	0.111
4:	0.566	-0.190
5:	0.215	-0.270
6:	-0.176	-0.176
7:	-0.786	0.407
8:	-0.623	0.190
9:	-0.503	0.366
10:	0.301	-0.170

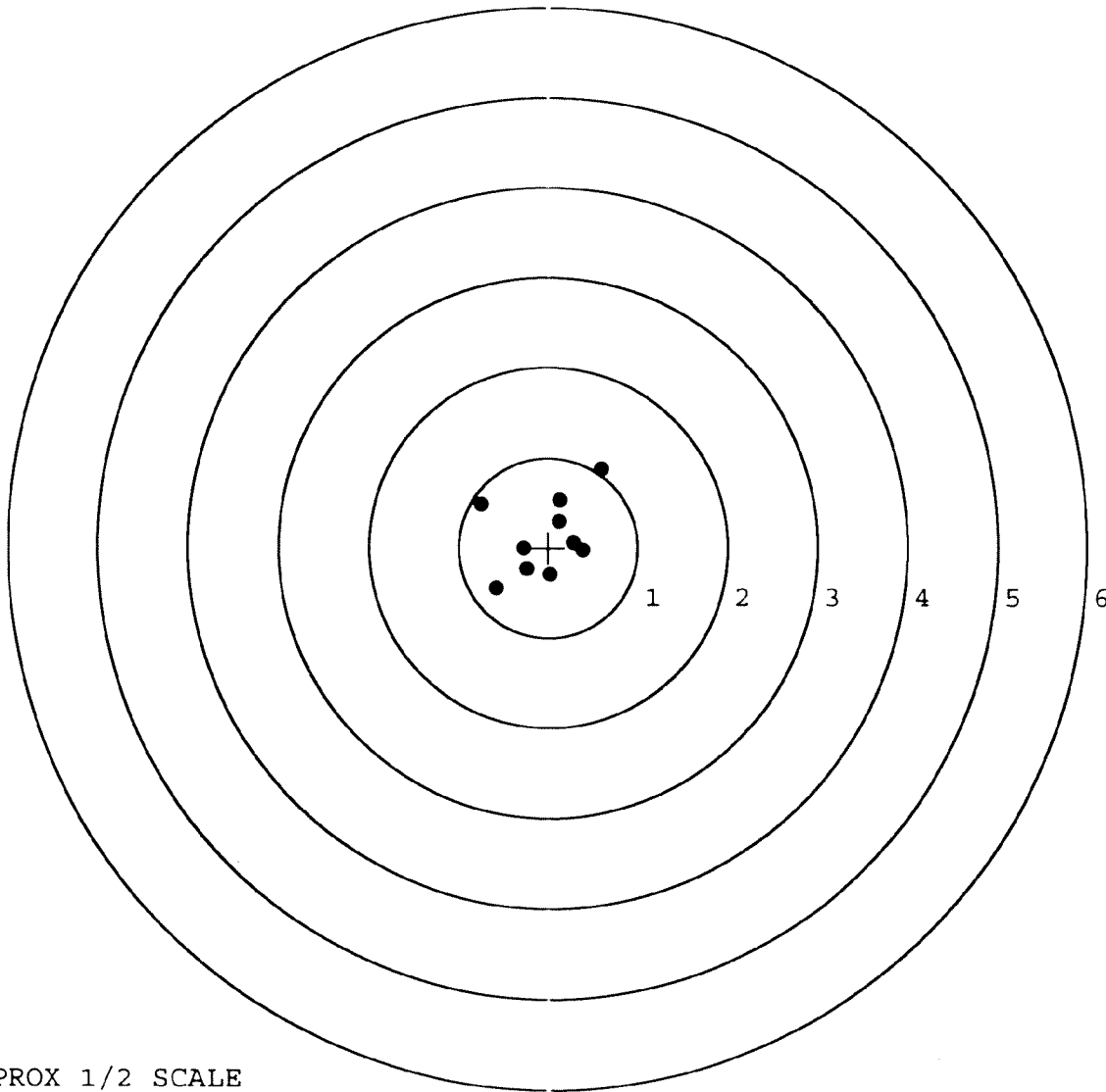


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6611668.___0
TARGET NUMBER: 4
FILE DATE: 08/07/2009
FILE TIME: 07:17

X CENTROID: -0.030
Y CENTROID: 0.119
POA TO CENTROID: 0.122
HORZ SPREAD: 1.348
VERT SPREAD: 1.332
GROUP SPREAD: 1.781
MIN RADIUS: 0.237
MAX RADIUS: 0.983
MEAN RADIUS: 0.516
IN 1 IN DIAMETER: 7
IN 2 IN DIAMETER: 10
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.599	0.874
2:	-0.749	0.480
3:	-0.583	-0.458
4:	0.024	-0.304
5:	0.392	-0.031
6:	-0.277	-0.013
7:	0.130	0.530
8:	0.124	0.299
9:	0.282	0.054
10:	-0.241	-0.245



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6611668. __0

TARGET NUMBER: 5

FILE DATE: 08/07/2009

FILE TIME: 07:17

X CENTROID: 0.061

Y CENTROID: -0.052

POA TO CENTROID: 0.081

HORZ SPREAD: 1.141

VERT SPREAD: 1.408

GROUP SPREAD: 1.455

MIN RADIUS: 0.139

MAX RADIUS: 0.806

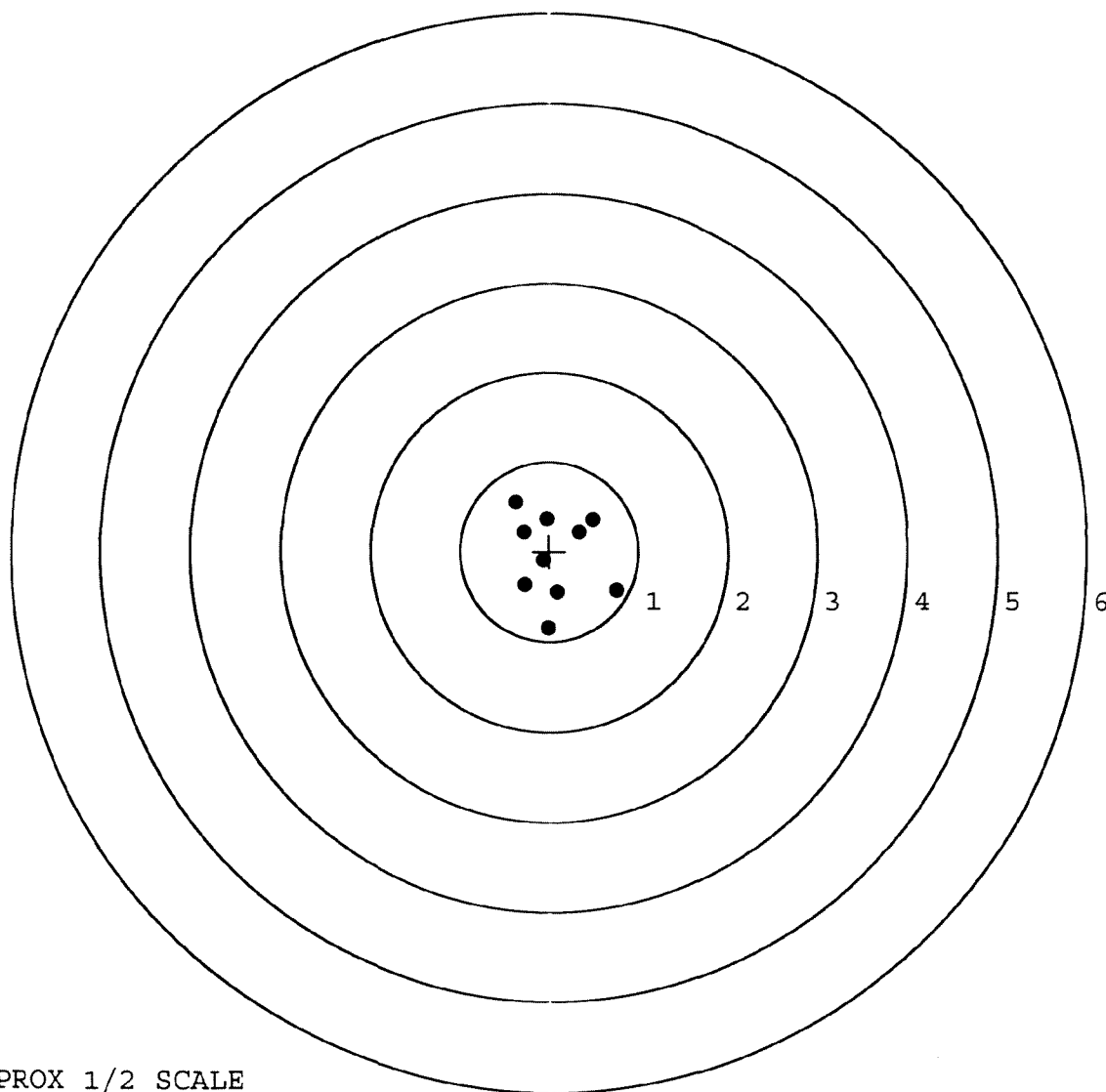
MEAN RADIUS: 0.522

IN 1 IN DIAMETER: 6

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.757	-0.440
2:	-0.017	-0.855
3:	0.090	-0.459
4:	-0.279	-0.377
5:	0.492	0.358
6:	0.345	0.219
7:	-0.384	0.553
8:	-0.038	0.361
9:	-0.286	0.219
10:	-0.068	-0.103



TARGET APPROX 1/2 SCALE




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

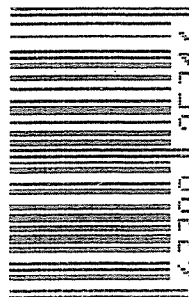
MODEL 700™ H24

SERIAL NO.
C6611668

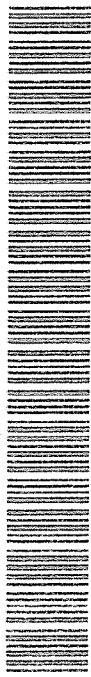
ORDER NO.
5716

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

UPC



0 4700 25716 7



5716 C6611668

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C 6611668

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		1/15/91	KS
600	Proof		1/15/91	KS
607	Check Headspace		1/15/91	KS
610	Dis-assemble Gun		1/15/91	KS
612	Magnaflux Barrel Action	1 18 91		KR
	Magnaflux Bolt	1 18 91		KR
615	Rollmark Caliber	1 18 91		GS
617	Drill and Tap Sight Holes	1 24 91		FB
618	Polish Barrel	1 24 91		WB
620	Apply Coatings (Barrel Action)		2-15-91	TH
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		3/5/91	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		3/5/91	KS
	C) Inspect Ejector Hole for Chamfer		3/5/91	KS
	D) Oil Firing Pin Ass'y		3/5/91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		3/6/91	KS

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5 1/4	5 1/4	5 1/4			3/6/91	WB
	G) Safety Off Force	8 1/2	8 1/2	8 1/2			3/6/91	WB
	H) Trigger Pull Test & Retainability						3/6/91	KL
	I) Firing Pin Indent	.0215	.021	.021			3/6/91	WB
	J) Assemble Stock						3/6/91	KL
	K) Assemble Swivel Studs						3-11-91	D/H
	L) Attach Front and Rear Sight Assemblies						3/6/91	KL
	M) Iron Sight Alignment						3/6/91	KL
	N) Detach Front & Rear Sights & place in numbered container						3/6/91	KL
	O) Attach Scope to Rifle						3/6/91	KL
	P) Detach & Attach Scope 20 Times						3/6/91	KL
640	Gallery Target & Test						3-7-91	KL
	A) Time						"	KL
	B) Malfunctions						"	KL
	C) Pierced Primers						"	KL
	D) Optical Clarity of Scope						"	KL
645	Inspect for Live Ammo						3-7-91	KL
655	Final Inspection							
	A) Headspace						3-11-91	D/H
	B) Trigger Pull	2.60	2.62	2.58	2.55	2.56	3/11/91	KL
	C) Function						3-11-91	D/H
660	Pack						3-10-91	DA

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6611668

DATE 3-6-91

TESTER JLP.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.42	2.34	2.43	2.60	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.43	2.37	2.45	2.62	
PULL #3	2.49	2.41	2.38	2.58	
PULL #4	2.51	2.39	2.49	2.55	
PULL #5	2.37	2.46	2.43	2.56	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.58	3.19		
PULL #2	3.27	3.21		
PULL #3	3.21	3.18		
PULL #4	3.28	3.22		
PULL #5	3.20	3.24		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.39	4.16		4.24
PULL #2	4.31	4.27		4.25
PULL #3	4.34	4.17		4.26
PULL #4	4.29	4.25		4.32
PULL #5	4.31	4.24		4.29
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611668
8 Mar 1991

CENTROIDAL DISTANCES

0 TO	1	.242495
1 TO	2	.608685
1 TO	3	.294007
1 TO	4	.393249
1 TO	5	.50657

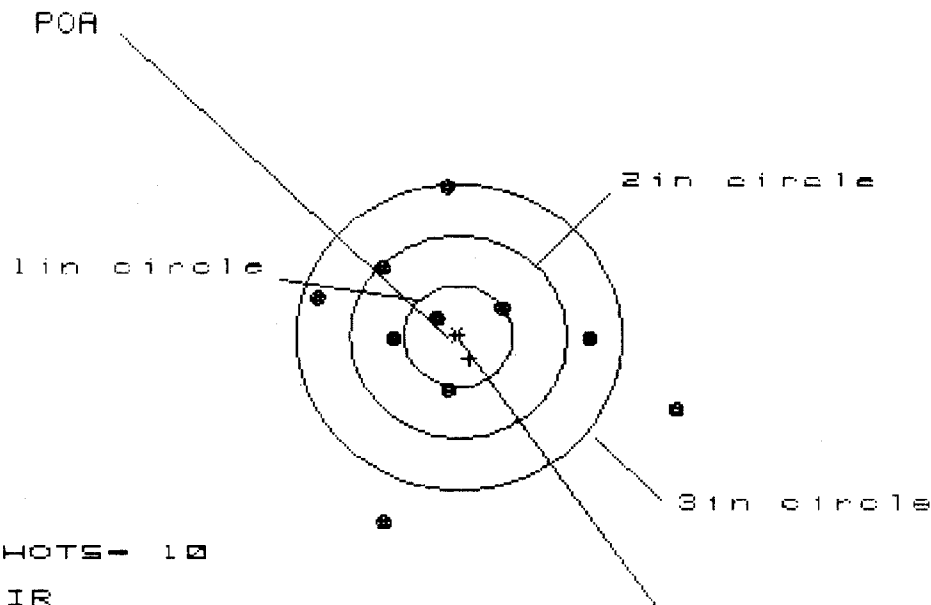
Page 5 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0192
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0052
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0198917
THE AMP FOR THIS RIFLE IS: .9886

7 Mar 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611658

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in - 1

2 in - 5

3 in - 7

HS- 3.248

VS- 3.331

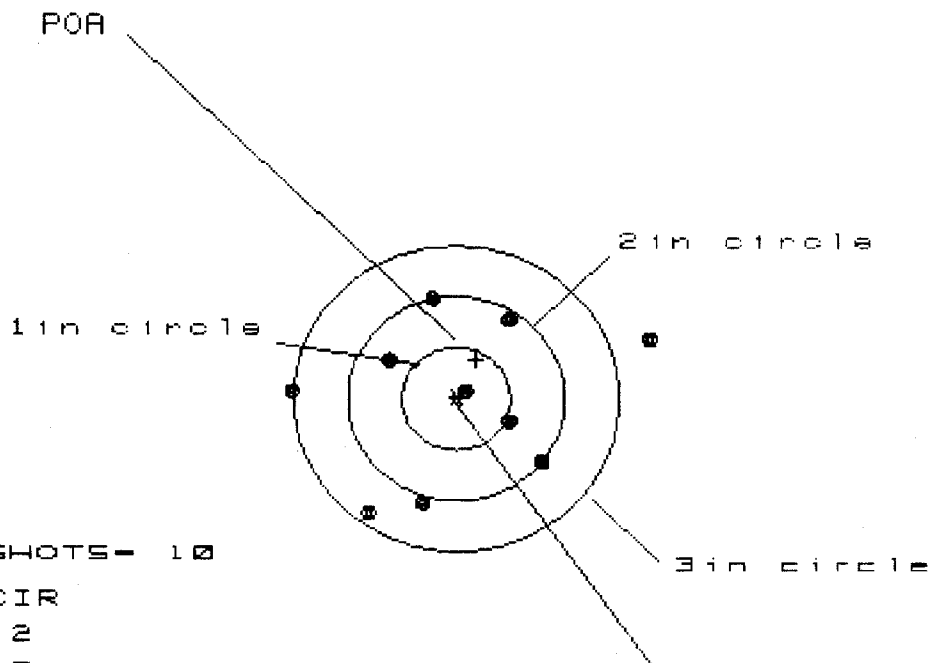
GS- 3.431

PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.995	1.454	1.389
MINIMUM X	:	-1.253	-1.032	-1.097
MAXIMUM Y	:	1.500	1.424	1.186
MINIMUM Y	:	-1.831	-1.907	-0.866
CENTROID X	:	-0.102	-0.323	-0.258
CENTROID Y	:	.220	.296	.534
POA TO CENTROID in.	:	.243	.438	.593
MIN RADIUS	:	.270	.124	.123
MEAN RADIUS	:	1.107	.954	.815
MAX RADIUS	:	2.108	1.977	1.420
HORIZONTAL SPREAD	:	3.248	2.486	2.486
VERTICAL SPREAD	:	3.331	3.331	2.052
EXTREME SPREAD	:	3.431	3.402	2.519
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	5		
NUMBER IN THREE INCH CIRCLE	=	7		

7 Mar 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611668

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 6

3 in = 9

HS= 3.243

VS= 2.096

GS= 3.281

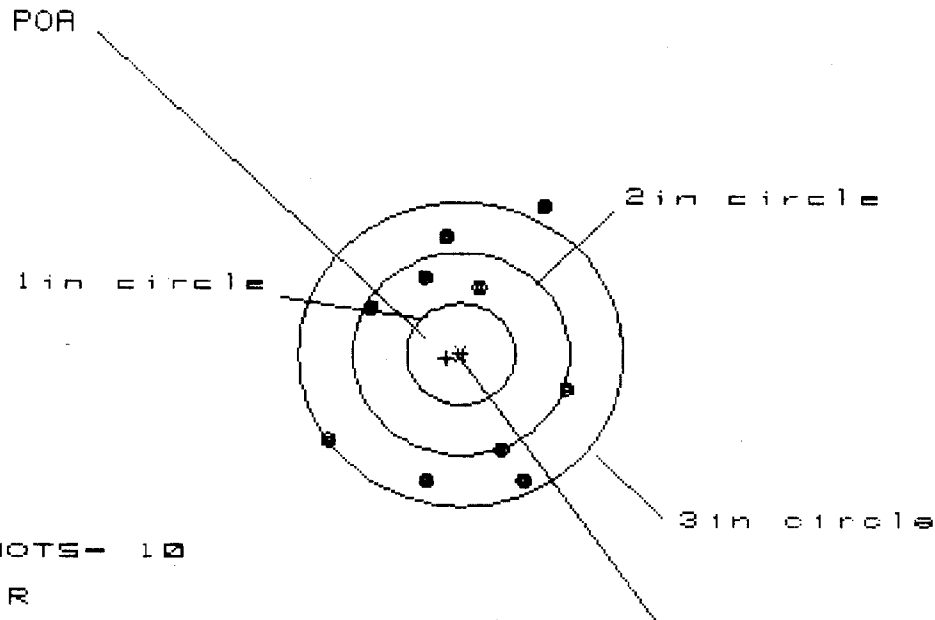
CENTROID #

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.757	.961	.799
MINIMUM X	:	-1.486	-1.291	-.814
MAXIMUM Y	:	.945	1.014	1.037
MINIMUM Y	:	-1.151	-1.082	-1.059
CENTROID X	:	-.185	-.380	-.218
CENTROID Y	:	-.383	-.452	-.475
POA TO CENTROID in.	:	.425	.590	.523
MIN RADIUS	:	.112	.296	.211
MEAN RADIUS	:	1.011	.930	.856
MAX RADIUS	:	1.863	1.305	1.335
HORIZONTAL SPREAD	:	3.243	2.252	1.613
VERTICAL SPREAD	:	2.096	2.096	2.096
EXTREME SPREAD	:	3.281	2.368	2.336
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	6		
NUMBER IN THREE INCH CIRCLE	=	9		

7 Mar 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611668

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 0

2 in = 4

3 in = 9

HS= 2.253

VS= 2.648

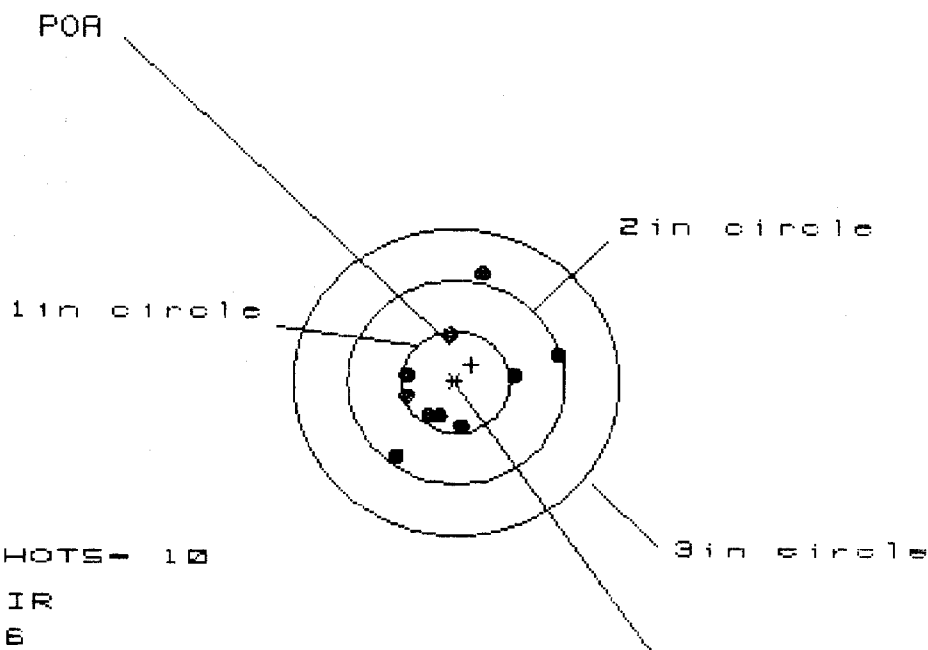
GS= 3.014

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.010	1.094	.949
MINIMUM X	:	-1.244	-1.159	-.891
MAXIMUM Y	:	1.418	1.337	1.252
MINIMUM Y	:	-1.230	-1.072	-1.157
CENTROID X	:	.132	.047	.192
CENTROID Y	:	.042	-.116	-.031
POA TO CENTROID in.	:	.138	.125	.194
MIN RADIUS	:	.680	.853	.737
MEAN RADIUS	:	1.137	1.082	1.034
MAX RADIUS	:	1.610	1.340	1.270
HORIZONTAL SPREAD	:	2.253	2.253	1.840
VERTICAL SPREAD	:	2.648	2.409	2.409
EXTREME SPREAD	:	3.014	2.479	2.479
NUMBER IN ONE INCH CIRCLE	=	0		
NUMBER IN TWO INCH CIRCLE	=	4		
NUMBER IN THREE INCH CIRCLE	=	9		

7 Mar 1991

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 6

2in = 8

3in = 10

HS= 1.561

VS= 1.788

GS= 1.980

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.983	1.013	.739
MINIMUM X	:	-.578	-.548	-.421
MAXIMUM Y	:	1.049	.541	.588
MINIMUM Y	:	-.739	-.622	-.575
CENTROID X	:	-.144	-.174	-.301
CENTROID Y	:	-.171	-.288	-.335
POA TO CENTROID in.	:	.224	.337	.450
MIN RADIUS	:	.371	.256	.155
MEAN RADIUS	:	.610	.531	.425
MAX RADIUS	:	1.084	1.081	.764
HORIZONTAL SPREAD	:	1.561	1.561	1.160
VERTICAL SPREAD	:	1.788	1.163	1.163
EXTREME SPREAD	:	1.980	1.852	1.391
NUMBER IN ONE INCH CIRCLE	=	6		
NUMBER IN TWO INCH CIRCLE	=	8		
NUMBER IN THREE INCH CIRCLE	=	10		

7 Mar 1991

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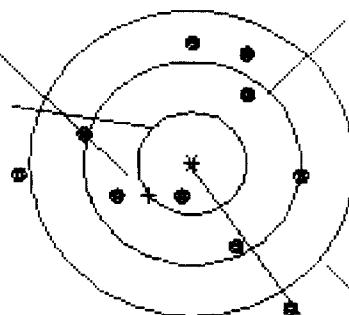
CENTERFIRE PATTERNS # 5

POA

1 in circle

2 in circle

3 in circle



OF SHOTS- 10

IN CIR

1 in - 1

2 in - 4

3 in - 8

HS- 2.680

VS- 2.671

GS- 2.849

CENTROID *

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.045	1.142	.950
MINIMUM X	:	-1.635	-1.538	-1.085
MAXIMUM Y	:	1.217	1.055	1.021
MINIMUM Y	:	-1.454	-1.009	-1.043
CENTROID X	:	.395	.298	.490
CENTROID Y	:	.318	.480	.514
POA TO CENTROID in.	:	.508	.565	.710
MIN RADIUS	:	.349	.507	.561
MEAN RADIUS	:	1.078	1.006	.922
MAX RADIUS	:	1.698	1.562	1.092
HORIZONTAL SPREAD	:	2.680	2.680	2.035
VERTICAL SPREAD	:	2.671	2.064	2.064
EXTREME SPREAD	:	2.849	2.680	2.101
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	4		
NUMBER IN THREE INCH CIRCLE	=	8		