

C6611784

MODEL 700™ M24

Model S&S™

Action _____

Barrel Length _____

Capacity _____

Order No. 5716

* Includes 1 in chamber.



Repair Inquiry

Repair Number: RE00127550

Serial: C6611784 Model M24 SWS Center Fire

Repairman:

Verify Repair

Status: New 4/3/2007 7:09:13 AM

Address Information

Customer:

☒ Received From

Return To:

☐ Received From

Name: RAMON VELAZQUEZ STTD

RAMON VELAZQUEZ STTD

Address 1: 1401 ARTILLERY CIRCLE

1401 ARTILLERY CIRCLE

Address 2: ATTN: SUPPLY BLDG 978

PO Box:

ATTN: SUPPLY BLDG 978

PO Box:

City: FT LEONARD WOOD

FT LEONARD WOOD

State: MO

Zip Code: 65473

Country: US

State: MO

Zip Code: 65473

Country: US

FFL:

Contact / Condition

Problems

Estimate

History / Status

Shipping / Billing

Contact Information

Phone: 573 596 3420

Fax:

Email:

Comments:

Received Condition

Fair

Condition
Notes:CSR
Notes:

Accessories Received

Code	Desc	Qty
A007	With Stud	3
A010	Hard Case	1
A017	Scope Base	1
A045	Bi Pod	1
A057	Fit and Rear Sgt Base	2

Repair Search

Refresh

Close

nagletj

4/3/2007

7:26 AM

CAPS

NUM

INS

SCRL

Serial Number:

C6611784

Model: M24 SWS



RE00127550

Remington®

Factory Repair Instructions

(NOTE: Please print and complete this form, and then include it with your firearm.)

Model Number: <u>M24A1</u>		Serial Number: <u>C6611784</u>	
Are you the original owner?: ☒ YES ☐ NO <u>Contract # DAAE20-02-C-0149</u>			
Name: <u>US Army MPS-STTD</u>		Date of Purchase: <u>UNKNOWN</u>	
Address (no PO Boxes): <u>1401 Artillery Circle</u> <u>Bldg 978</u> <u>ATTN: Ramon Velazquez</u>			
City: <u>FT. Leonard Wood</u>		State: <u>MO</u>	Zip: <u>65473</u>
Phone (Daytime): <u>(573) 596-0131 x6-3420</u>		Fax: <u>(573) 596-0747</u>	
E-mail Address: ☐ I would like to receive future e-mail updates from Remington.			
Please describe your problem and date of occurrence:			
<u>-magazine box loose - does not allow barrel-action</u> <u>group to be mated correctly in trigger guard</u> <u>assembly</u>			
Ammunition Information:			
Manufacturer: <u>Military (Lake City)</u>		Type: <u>M118 MATCH BALL</u>	
Other (i.e. bullet weight/type, shot size, powder):			
Handload Information:			
Powder Used:		Powder Weight:	
Case/Hull Used:		Primer Used:	
Bullet Type/Shot Size:		Reloader Used:	
Firearms Care (Cleaning and Lubrication):			
Brand of cleaning solution used:			
How often do you clean the bore? (Months or Number of rounds)			
How often do you clean the action? (Months or Number of rounds)			
How often do you clean the trigger assembly? (Months or Number of rounds)			
Brand of lubricant used:			
How often do you lubricate the bore? (Months or Number of rounds)			
How often do you lubricate the action? (Months or Number of rounds)			
How often do you lubricate the trigger assembly? (Months or Number of rounds)			
Have you reviewed the cleaning and maintenance recommendations on our web site or in our owners manual? ☐ YES ☐ NO			

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6611784.___0
FILE DATE AND TIME: 05/17/2007 13:42

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.009
The Average Y Centroid of the Five Target Set:	-0.016
The Average Point of Impact of the Five Target Set:	0.018
The Average Mean Radius of the Five Target Set:	0.567
The Distance from POA to Centroid Target #1:	0.056
The Distance from Centroid Target #2 to Centroid Target #1:	0.107
The Distance from Centroid Target #3 to Centroid Target #1:	0.092
The Distance from Centroid Target #4 to Centroid Target #1:	0.130
The Distance from Centroid Target #5 to Centroid Target #1:	0.029

SERIAL NUMBER: C6611784. __0

TARGET NUMBER: 1

FILE DATE: 05/17/2007

FILE TIME: 13:42

X CENTROID: -0.046

Y CENTROID: -0.032

POA TO CENTROID: 0.056

HORZ SPREAD: 2.300

VERT SPREAD: 2.965

GROUP SPREAD: 2.971

MIN RADIUS: 0.369

MAX RADIUS: 1.622

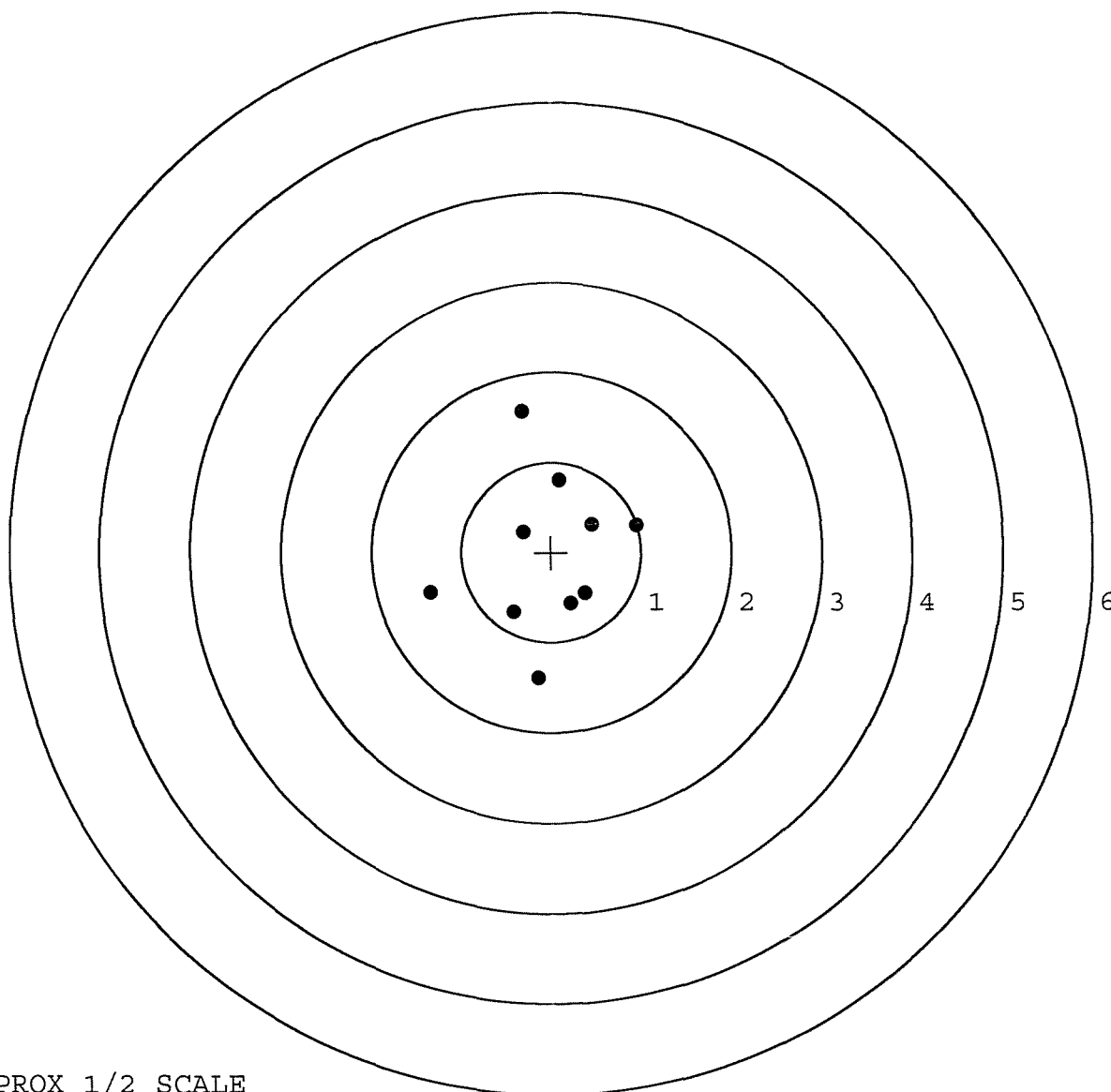
MEAN RADIUS: 0.917

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 9

POINT#	X	Y
1:	-0.333	1.565
2:	0.089	0.801
3:	0.953	0.301
4:	0.460	0.315
5:	-0.307	0.229
6:	0.377	-0.447
7:	0.217	-0.572
8:	-0.423	-0.666
9:	-1.347	-0.441
10:	-0.148	-1.400

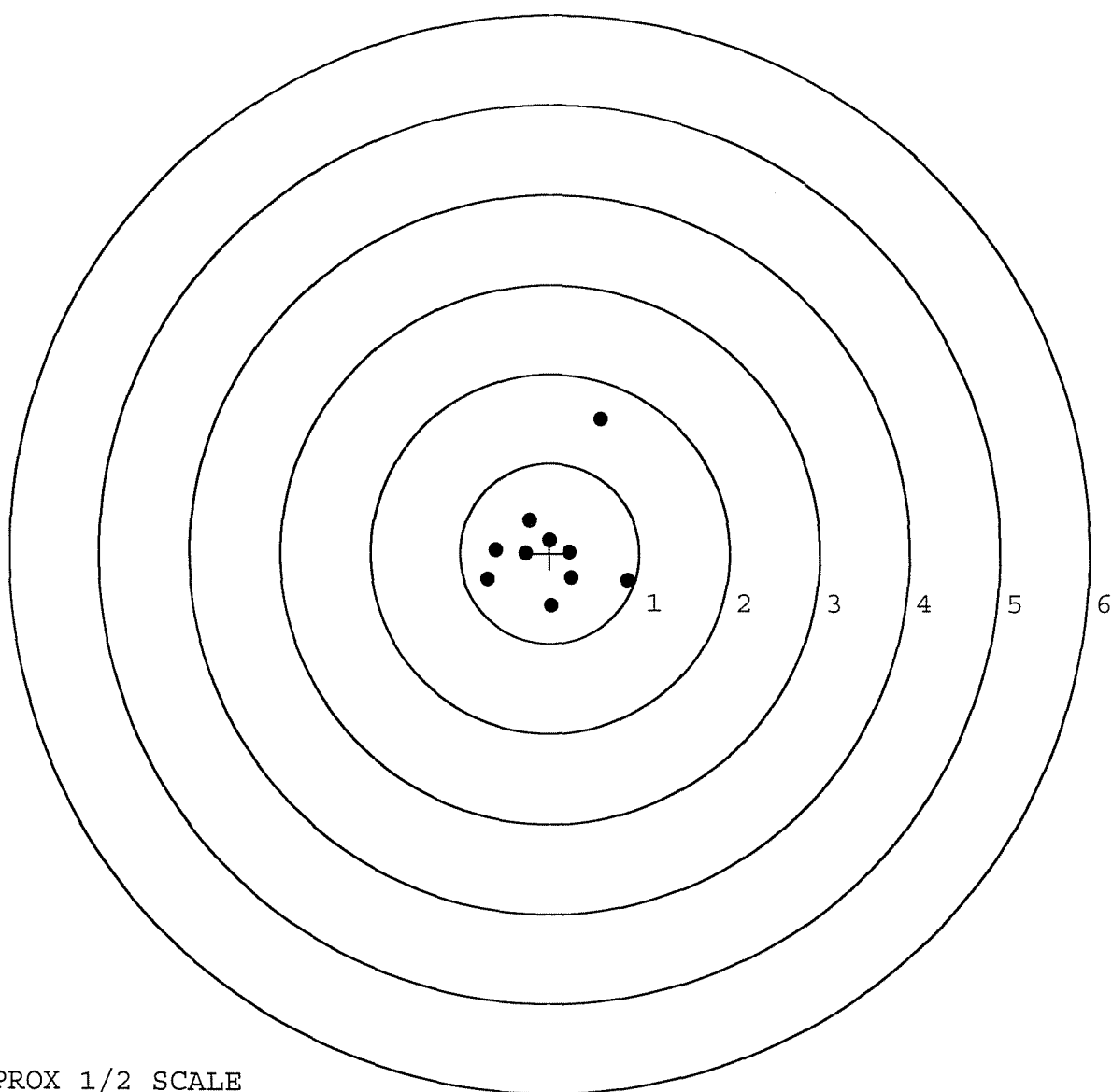


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6611784. __0
TARGET NUMBER: 2
FILE DATE: 05/17/2007
FILE TIME: 13:42

X CENTROID: 0.013
Y CENTROID: 0.057
POA TO CENTROID: 0.059
HORZ SPREAD: 1.567
VERT SPREAD: 2.082
GROUP SPREAD: 2.188
MIN RADIUS: 0.088
MAX RADIUS: 1.538
MEAN RADIUS: 0.591
IN 1 IN DIAMETER: 5
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 9

POINT#	X	Y
1:	0.569	1.491
2:	0.870	-0.303
3:	0.026	-0.591
4:	0.245	-0.276
5:	0.221	0.008
6:	-0.004	0.144
7:	-0.230	0.364
8:	-0.272	-0.006
9:	-0.600	0.038
10:	-0.697	-0.294



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6611784. __0

TARGET NUMBER: 3

FILE DATE: 05/17/2007

FILE TIME: 13:42

X CENTROID: 0.046

Y CENTROID: -0.040

POA TO CENTROID: 0.061

HORZ SPREAD: 0.878

VERT SPREAD: 1.688

GROUP SPREAD: 1.881

MIN RADIUS: 0.262

MAX RADIUS: 1.098

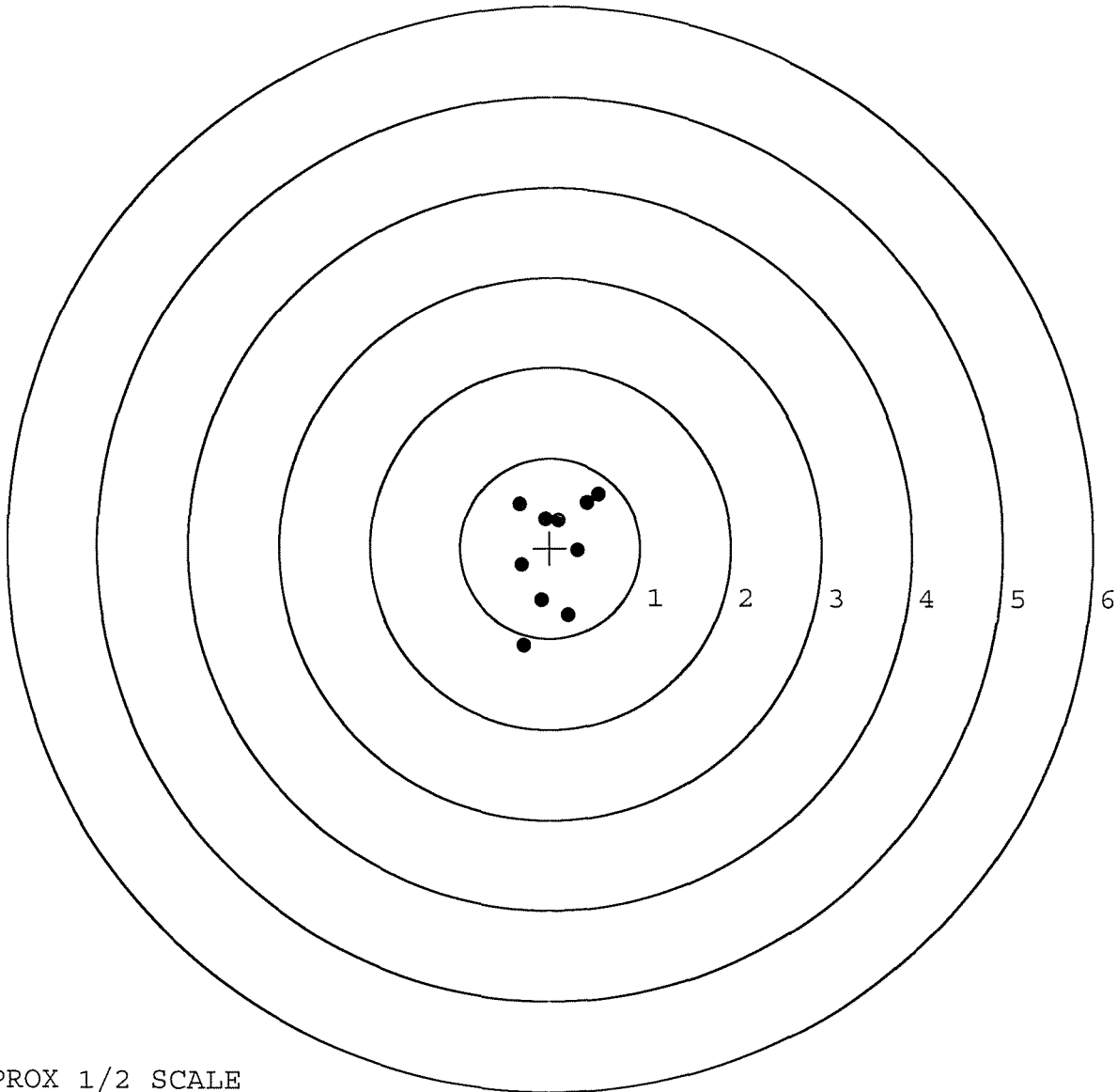
MEAN RADIUS: 0.590

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.293	-1.085
2:	0.201	-0.749
3:	-0.097	-0.585
4:	-0.316	-0.191
5:	0.307	-0.030
6:	0.537	0.603
7:	0.412	0.510
8:	0.097	0.313
9:	-0.052	0.321
10:	-0.341	0.490

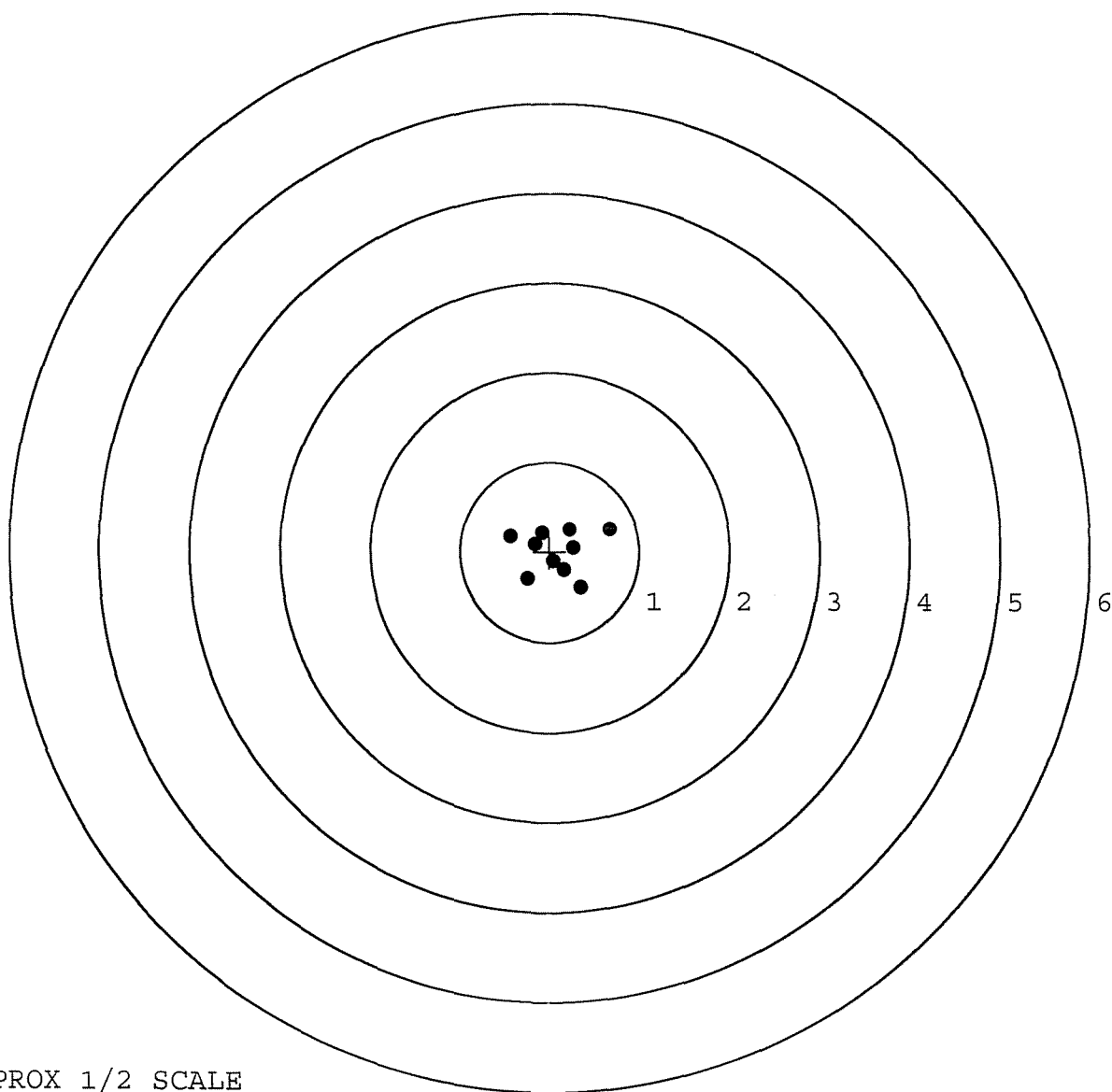


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6611784. 0
TARGET NUMBER: 4
FILE DATE: 05/17/2007
FILE TIME: 13:42

X CENTROID: 0.080
Y CENTROID: -0.004
POA TO CENTROID: 0.081
HORZ SPREAD: 1.113
VERT SPREAD: 0.653
GROUP SPREAD: 1.116
MIN RADIUS: 0.111
MAX RADIUS: 0.648
MEAN RADIUS: 0.347
IN 1 IN DIAMETER: 8
IN 2 IN DIAMETER: 10
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.678	0.247
2:	0.350	-0.406
3:	0.228	0.244
4:	0.271	0.044
5:	-0.081	0.211
6:	-0.251	-0.308
7:	0.161	-0.212
8:	-0.435	0.167
9:	-0.160	0.084
10:	0.044	-0.108

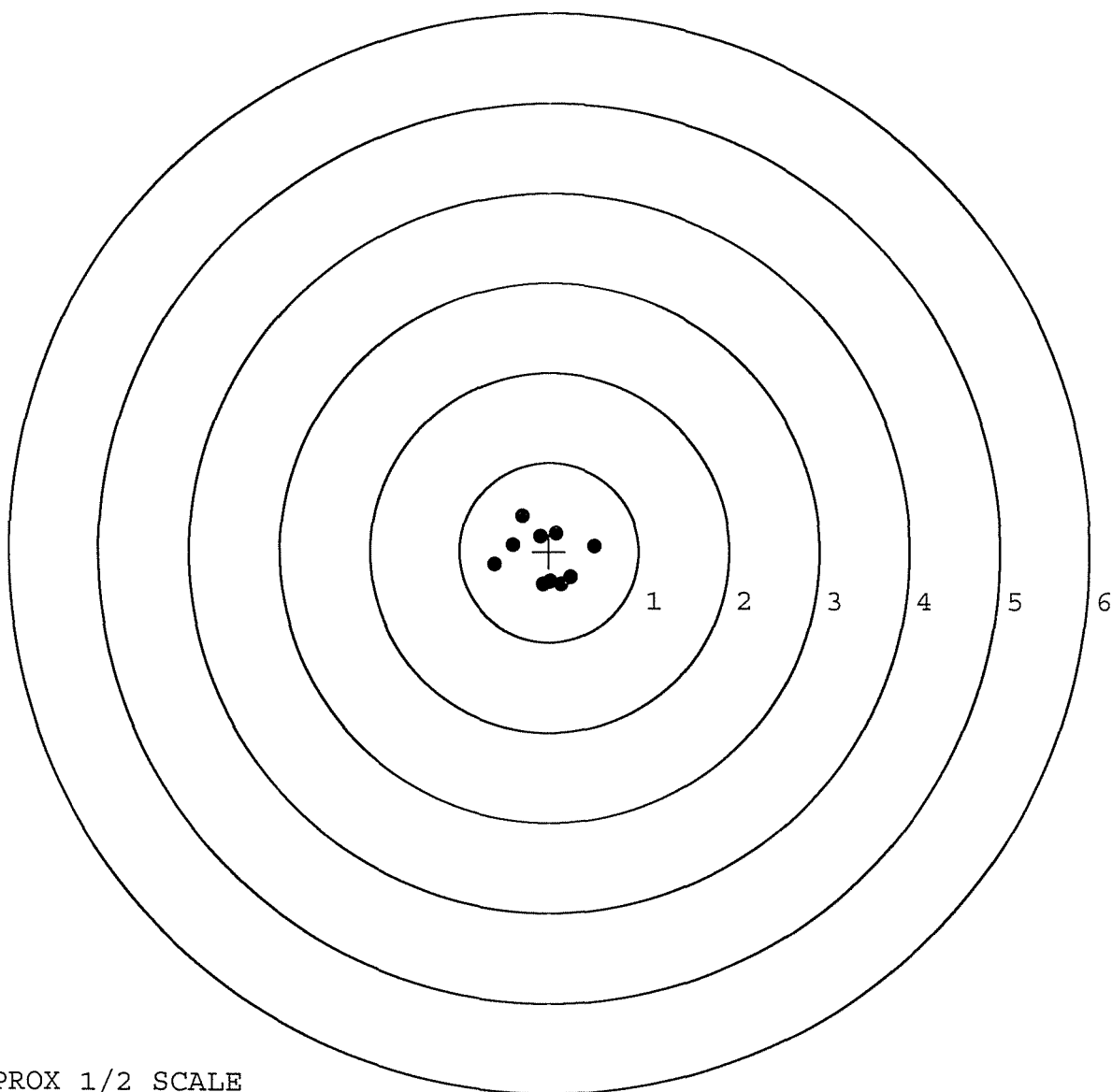


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6611784. 0
TARGET NUMBER: 5
FILE DATE: 05/17/2007
FILE TIME: 13:42

X CENTROID: -0.050
Y CENTROID: -0.060
POA TO CENTROID: 0.078
HORZ SPREAD: 1.123
VERT SPREAD: 0.770
GROUP SPREAD: 1.142
MIN RADIUS: 0.233
MAX RADIUS: 0.574
MEAN RADIUS: 0.391
IN 1 IN DIAMETER: 7
IN 2 IN DIAMETER: 10
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.510	0.065
2:	0.244	-0.293
3:	0.138	-0.371
4:	-0.070	-0.371
5:	-0.613	-0.141
6:	-0.406	0.075
7:	-0.302	0.399
8:	0.082	0.205
9:	-0.099	0.167
10:	0.016	-0.339



TARGET APPROX 1/2 SCALE

M-24 INSPECTION CHECKLIST
CONTRACT #: DAAE-20-02-C-0149

R & E NUMBER		127550	
SERIAL NUMBER		C6611784	
LOG-IN DATE		4-3-07	

OPERATION #	OPERATION NAME	DATE	INITIAL
500	DIS-ASSEMBLE GUN	4-26-07	RTZ
505	RE-BARREL	4-30-07	RTZ
560	ASSEMBLE	4-30-07	RTZ
600	PROOF	5-1-07	TRW
605	CHECK HEADSPACE	5-1-07	TRW
610	DIS-ASSEMBLE GUN	5-1-07	RTZ
612	MAGNAFLUX	5-2-07	TRW
510	DRILL AND TAP	5-1-07	FM
615	ROLLMARK CALIBER	5-1-07	CW
618	ROTO-BLAST	5-2-07	CB
620	APPLY COATINGS	5-5-07	WJ
625	FINAL ASSEMBLY	5-14-07	RTZ
640	FUNCTION TEST AND	PASS FAIL 5-17-07	TRW
650	TARGET	PASS FAIL 5-17-07	TRW
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
670	FINAL INSPECTION	5-17-07	FM
	A) HEADSPACE	PASS FAIL 5-17-07	
	B) TRIGGER PULL	2.73 2.79 2.74 2.77 2.72 5-11-07	TRW
680	F) SAFETY ON FORCE	5.25 5.25 5.0 5-17-07	TRW
	G) SAFETY OFF FORCE	2.0 2.25 2.5 5-17-07	TRW
	I) FIRING PIN INDENT	.023 .023 .0225 5-17-07	TRW
690	PACK	5-18-07	DA




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

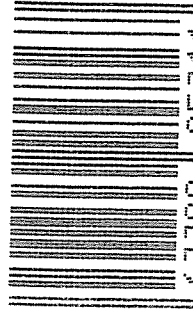
MODEL 700™ M24

SERIAL NO.
C6611784

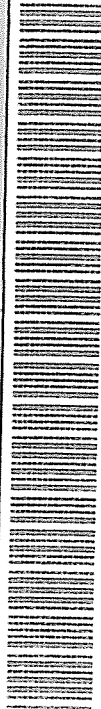
ORDER NO.
5716

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

UPC



0 47700 25716 2



5716 C6611784

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6611784

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		1/22/91	KS
600	Proof		1/22/91	KS
607	Check Headspace		1/22/91	KS
610	Dis-assemble Gun		1/22/91	KS
612	Magnaflux Barrel Action		1/29/91	KR
	Magnaflux Bolt		1/29/91	KR
615	Rollmark Caliber		1/29/91	GL
617	Drill and Tap Sight Holes	2 2	91	FB
618	Polish Barrel RBB	2 2	91	WB
620	Apply Coatings (Barrel Action)		2-11-91	ISA
	Apply Coating (Bolt)			
625	Final Assembly		3/4/91	KA
	A) Clean inside of Bolt Assembly		3/4/91	KA
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		3/4/91	KA
	C) Inspect Ejector Hole for Chamfer		3/4/91	KA
	D) Oil Firing Pin Ass'y		3/4/91	KA
	E) Adjust Trigger Pull to Min Setting and Stake		3-5-91	SM

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			3/5/91	JK
	G) Safety Off Force	3	3	3			3/5/91	JK
	H) Trigger Pull Test & Retainability						3-5-91	JK
	I) Firing Pin Indent	.022	.0215	.0215			3/5/91	JK
	J) Assemble Stock						3/5/91	JK
	K) Assemble Swivel Studs						3-11-91	D/H
	L) Attach Front and Rear Sight Assemblies						3/5/91	JK
	M) Iron Sight Alignment						3/5/91	JK
	N) Detach Front & Rear Sights & place in numbered container						3/5/91	JK
	O) Attach Scope to Rifle						3/5/91	JK
	P) Detach & Attach Scope 20 Times						3/5/91	JK
640	Gallery Target & Test						3-6-91	AC
	A) Time						3-6-91	AC
	B) Malfunctions						3-6-91	AC
	C) Pierced Primers						3-6-91	AC
	D) Optical Clarity of Scope						3-6-91	AC
645	Inspect for Live Ammo						3-6-91	AC
655	Final Inspection						3-11-91	D/H
	A) Headspace						3-11-91	D/H
	B) Trigger Pull	2.53	2.52	2.51	2.53	2.53	3/11/91	JK
	C) Function						3-11-91	D/H
660	Pack						6-19-91	AF

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C6611784

DATE 3-5-91

TESTER JL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.47	2.48	2.30	2.53	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.47	2.43	2.46	2.52	
PULL #3	2.50	2.43	2.44	2.51	
PULL #4	2.54	2.47	2.48	2.53	
PULL #5	2.47	2.37	2.36	2.53	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.28	3.43		
PULL #2	3.19	3.43		
PULL #3	3.19	3.40		
PULL #4	3.47	3.41		
PULL #5	3.38	3.40		
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	4.27		4.29
PULL #2	4.27	4.29		4.26
PULL #3	4.24	4.29		4.26
PULL #4	4.26	4.25		4.24
PULL #5	4.28	4.28		4.32
TOTAL				
AVG.				

MOD. _____ GA. _____ GUN # 1784
 CAL. _____ #

# TEST	DATE	MALFUNCTION/DEFECT	ASSEM. #
	1st	check cross hairs alignment And bolt hits stock	K
	2nd	filed stock alignment appears OK. DID NOT CHANGE IT	K.S. 3/6/91
	3rd	STOCK REP'D ALIGNMENT CORRECTED	3/20/91 K.S.
	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		

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611784
6 Mar 1991

CENTROIDAL DISTANCES

0 TO	1	.315525
1 TO	2	.528289
1 TO	3	.405961
1 TO	4	.512575
1 TO	5	.397555

$\frac{24}{16}$ (----POR
1
2

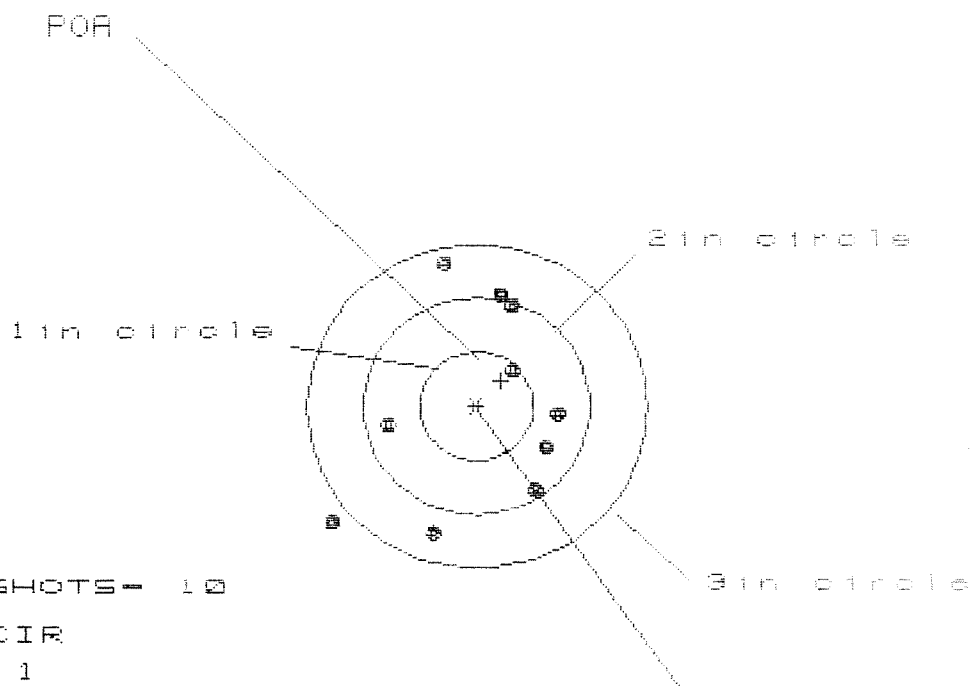
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0092
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.104
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .104407

THE AMR FOR THIS RIFLE IS: .9544

8 Mar 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6B117B4

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 5

3 in = 9

HS = 2.040

VS = 2.446

GS = 2.643

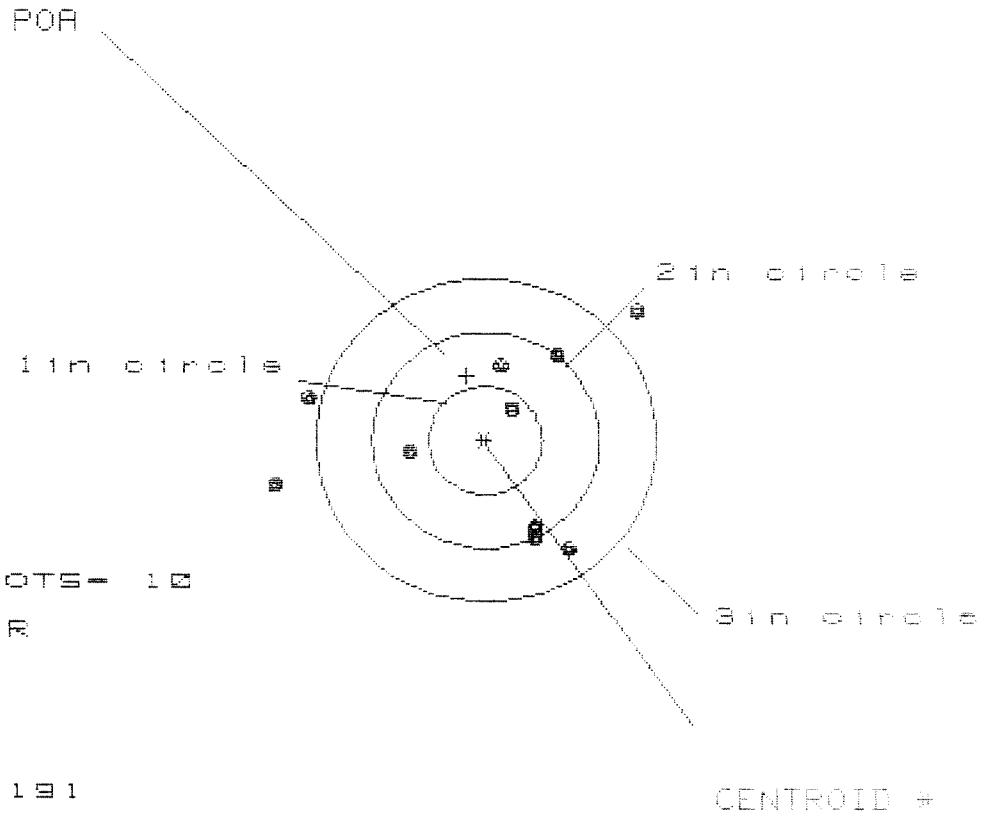
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.762	.620	.563
MINIMUM X	-1.278	-.943	-1.000
MAXIMUM Y	1.296	1.173	1.101
MINIMUM Y	-1.149	-1.273	-1.127
CENTROID X	-.215	-.074	-.017
CENTROID Y	-.230	-.106	-.253
POA TO CENTROID in.	.315	.129	.253
MIN RADIUS	.495	.310	.418
MEAN RADIUS	1.007	.895	.838
MAX RADIUS	1.694	1.370	1.259
HORIZONTAL SPREAD	2.040	1.563	1.563
VERTICAL SPREAD	2.446	2.446	2.227
EXTREME SPREAD	2.643	2.446	2.298
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	9		

6 Mar 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8B117B4

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 1

2in = 4

3in = 7

HS= 3.191

VS= 2.146

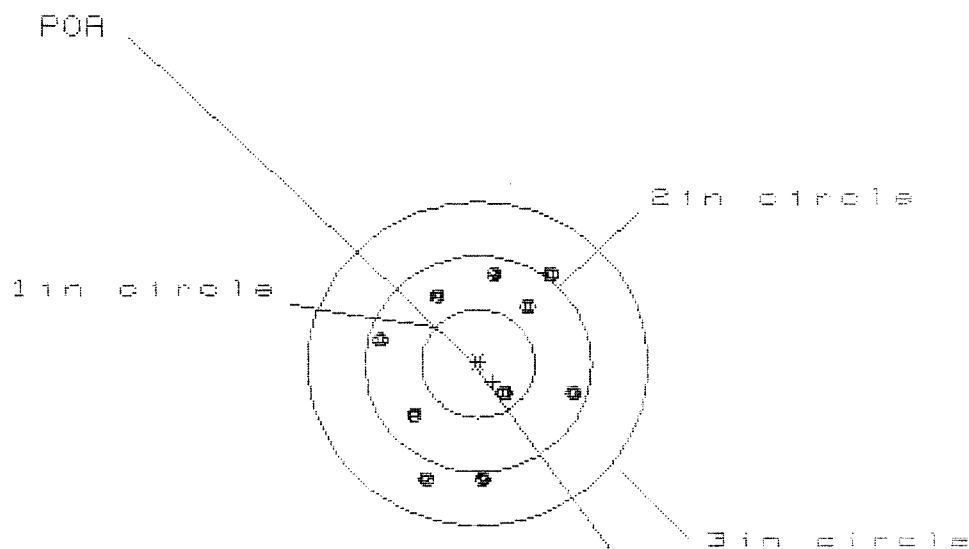
GS= 3.574

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.370	1.167	.682
MINIMUM X	:	-1.821	-1.795	-1.649
MAXIMUM Y	:	1.161	1.111	.886
MINIMUM Y	:	-.985	-1.035	-.896
CENTROID X	:	.164	.367	.221
CENTROID Y	:	-.597	-.547	-.686
POA TO CENTROID in.	:	.619	.659	.721
MIN RADIUS	:	.380	.223	.413
MEAN RADIUS	:	1.126	1.011	.943
MAX RADIUS	:	1.876	1.834	1.728
HORIZONTAL SPREAD	:	3.191	2.962	2.331
VERTICAL SPREAD	:	2.146	2.146	1.782
EXTREME SPREAD	:	3.574	3.052	2.725
NUMBER IN ONE INCH CIRCLE =			1	
NUMBER IN TWO INCH CIRCLE =			4	
NUMBER IN THREE INCH CIRCLE =			7	

6 Mar 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C68117B4

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 1

2in = 7

3in = 10

HS= 1.743

VS= 1.921

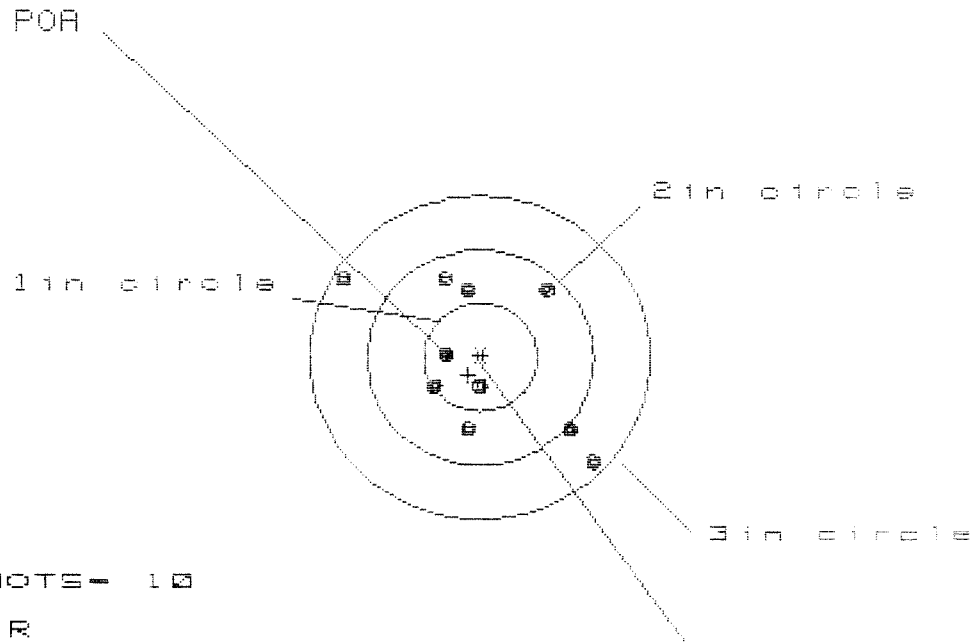
GS= 2.186

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.873	.816	.819
MINIMUM X	:	-.870	-.927	-.924
MAXIMUM Y	:	.869	.752	.608
MINIMUM Y	:	-1.052	-1.157	-.727
CENTROID X	:	-.136	-.079	-.082
CENTROID Y	:	.168	.285	.429
POA TO CENTROID in.	:	.216	.296	.437
MIN RADIUS	:	.310	.373	.469
MEAN RADIUS	:	.841	.792	.729
MAX RADIUS	:	1.169	1.157	.985
HORIZONTAL SPREAD	:	1.743	1.743	1.743
VERTICAL SPREAD	:	1.921	1.909	1.335
EXTREME SPREAD	:	2.186	1.936	1.810
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	7		
NUMBER IN THREE INCH CIRCLE	=	10		

8 Mar 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8611784

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 3

2in = 7

3in = 10

HS= 2.232

VS= 1.726

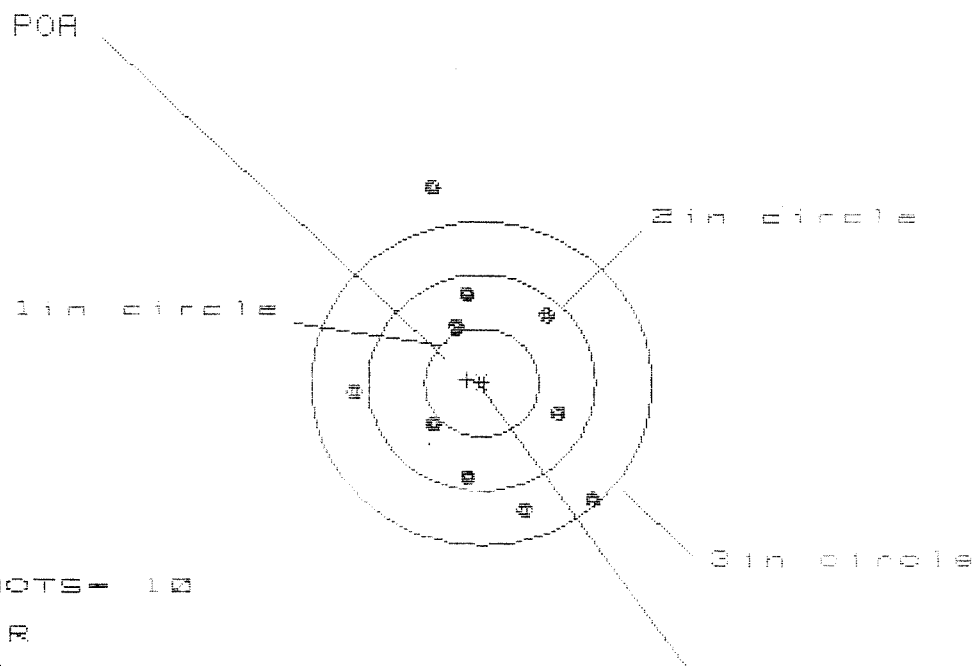
GS= 2.822

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.038	.905	.772
MINIMUM X	:	-1.194	-.537	-.424
MAXIMUM Y	:	.768	.809	.700
MINIMUM Y	:	-.958	-.873	-.701
CENTROID X	:	.107	.240	.127
CENTROID Y	:	.168	.083	.192
POA TO CENTROID in.	:	.199	.254	.230
MIN RADIUS	:	.255	.200	.278
MEAN RADIUS	:	.783	.720	.628
MAX RADIUS	:	1.420	1.257	1.036
HORIZONTAL SPREAD	:	2.232	1.442	1.196
VERTICAL SPREAD	:	1.726	1.682	1.401
EXTREME SPREAD	:	2.822	2.164	1.783
NUMBER IN ONE INCH CIRCLE =			3	
NUMBER IN TWO INCH CIRCLE =			7	
NUMBER IN THREE INCH CIRCLE =			10	

6 Mar 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C86117B4

CENTERFIRE PATTERNS # 5



OF SHOTS - 10

IN CIR

1 in = 0

2 in = 6

3 in = 9

HS = 2.104

VS = 2.989

GS = 3.188

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.977	.926	.736
MINIMUM X	:	-1.127	-1.178	-1.062
MAXIMUM Y	:	1.820	1.063	.960
MINIMUM Y	:	-1.159	-.967	-1.070
CENTROID X	:	.127	.178	.062
CENTROID Y	:	-.029	-.231	-.128
POA TO CENTROID in.	:	.131	.292	.142
MIN RADIUS	:	.550	.558	.508
MEAN RADIUS	:	1.015	.904	.851
MAX RADIUS	:	1.876	1.242	1.141
HORIZONTAL SPREAD	:	2.104	2.104	1.798
VERTICAL SPREAD	:	2.989	2.030	2.030
EXTREME SPREAD	:	3.188	2.030	2.092
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	