

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: **RE00030142** Serial: **C6348850** Model: **700** Center Fire Caliber: **7.62 NATO M 24 (SWS)** Repairman:
 Verify Repair Status: **Closed 7/30/01 1:47:51 PM**

Address Information

Customer: **COMMANDER** Received From: **COMMANDER**
 Address 1: **1ST BN 1ST SFG (A)** Address 2: PO Box:
 City: **APD** State: **OK** Zip Code: **96376** Country: **US**

FFL:

Contact / Condition Problems Estimate History / Status Shipping / Billing

Contact Information: Phone: Fax: Email: Comments:

Received Condition: Poor: Condition Notes: CSR Notes:

Accessories Received:

Code	Desc	Qty
A007	With Stud	1
A017	Scope Base	1

Repair Search Refresh Close

maglet 7/31/01 7:12 AM CAPS NUM INS SCBL

Start Arms Services Repair 7:12 AM

Number: **C6348850**

Model: **700**



RE00030142

Remington Test Lab, Ilion, N.Y.

Centroidal distance calculations for Rifle # c6348850
14 Aug 2001

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0134
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.07
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .071271

THE AMR FOR THIS RIFLE IS: .9994

CENTROIDAL DISTANCES

0 TO	1	.40706
1 TO	2	.435253
1 TO	3	.431419
1 TO	4	.483177
1 TO	5	.640314

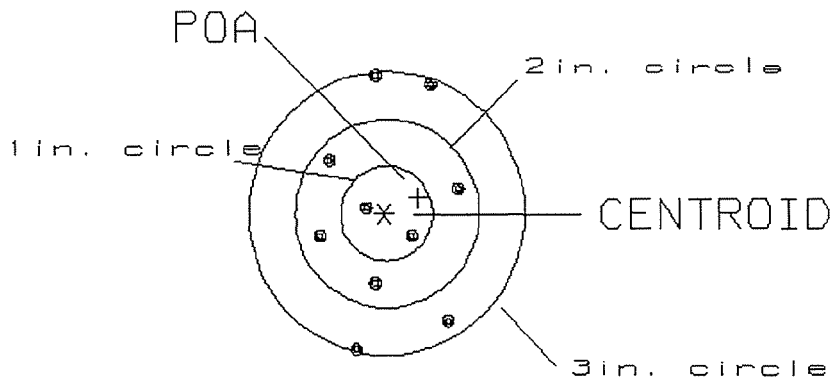
3
+
1 2 5 <----POA

PATTERN #: ☐ 1 ☐
 POA TO CENTROID: .407
 MIN RADIUS : .228
 MEAN RADIUS : .952
 MAX RADIUS : 1.499
 CENTROID X : -.373
 CENTROID Y : -.163

14 Aug 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/e6348850.1

CENTERFIRE PATTERN # 1



OF SHOTS= 10

IN CIRCLE

HS= 1.50

2

VS= 2.90

6

GS= 2.92

10

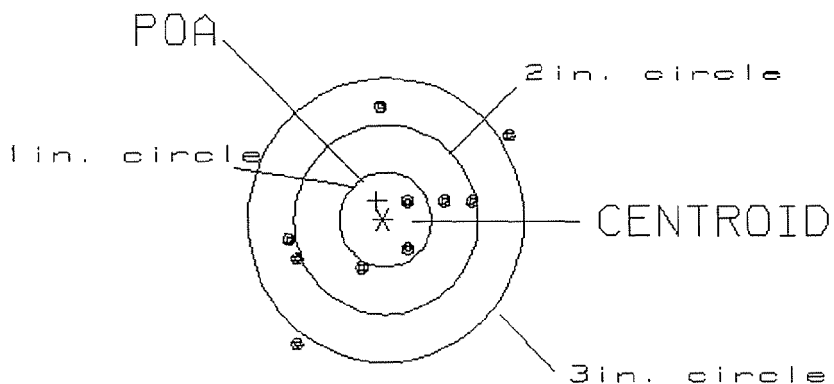
PATTERN #: 2

POA TO CENTROID: .205
 MIN RADIUS : .304
 MEAN RADIUS : .936
 MAX RADIUS : 1.640
 CENTROID X : .061
 CENTROID Y : -.196

14 Aug 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/e6340050.1

CENTERFIRE PATTERN # 2



OF SHOTS= 10

IN CIRCLE

HS= 2.37

2

VS= 2.50

5

GS= 3.18

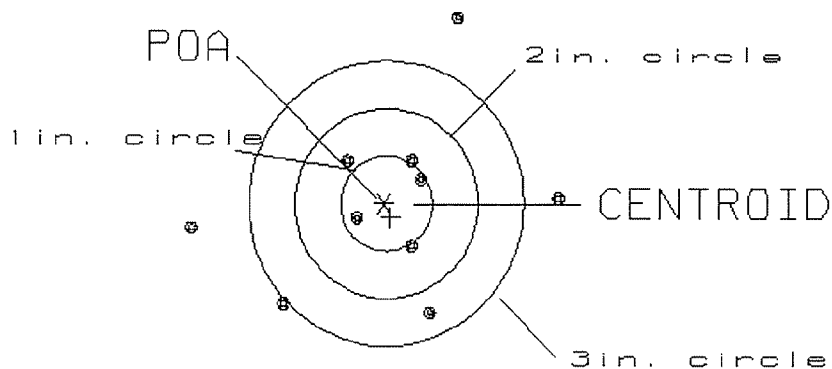
8

PATTERN #: ☐ 3 ☐
 POA TO CENTROID: .166
 MIN RADIUS : .372
 MEAN RADIUS : 1.148
 MAX RADIUS : 2.159
 CENTROID X : -.074
 CENTROID Y : .148

14 Aug 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/e6348850.1

CENTERFIRE PATTERN # 3



OF SHOTS= 10

IN CIRCLE

HS= 4.06
 VS= 3.09
 GS= 4.07

2
 5
 6

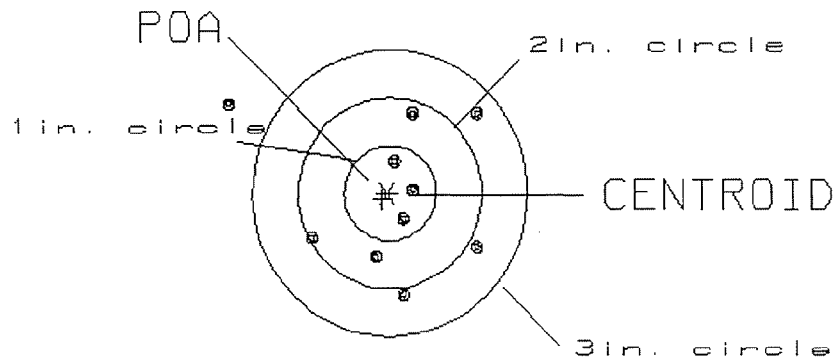
PATTERN #: ☐ 4 ☐

POA TO CENTROID: .084
 MIN RADIUS : .287
 MEAN RADIUS : .888
 MAX RADIUS : 1.971
 CENTROID X : .053
 CENTROID Y : .065

14 Aug 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/e6348850.1

CENTERFIRE PATTERN # 4



OF SHOTS= 10

IN CIRCLE

HS= 2.65

3

VS= 2.07

6

GS= 3.08

9

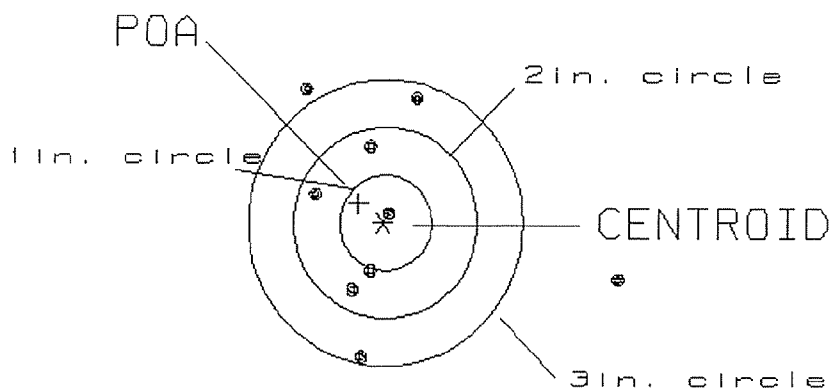
PATTERN #: 5

POA TO CENTROID: .335
 MIN RADIUS : .076
 MEAN RADIUS : 1.073
 MAX RADIUS : 2.598
 CENTROID X : .266
 CENTROID Y : -.204

14 Aug 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/e6340050.1

CENTERFIRE PATTERN # 5



OF SHOTS= 10

IN CIRCLE

HS= 3.37

1

VS= 2.80

6

GS= 3.92

8

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

R & E NUMBER			
SERIAL NUMBER C 4348850			
LOG-IN DATE 7/31/01			
INSPECT AND VERIFY:			
OPERATION #	OPERATION NAME	DATE	INITIAL
550	DIS-ASSEMBLE GUN	7/31/01	RH
560 A	RE-BARREL AT CUSTOM SHOP	8/1/01	BWT
B	DRILL AND TAP	8/1/01	BWT
C	POLISH		
575	ASSEMBLE	8/1/01	RH
600	PROOF	8/1/01	STH RH
605	CHECK HEADSPACE	8/1/01	RH
610	DIS-ASSEMBLE GUN	8/1/01	RH
612	MAGNAFLUX	8/3/01	AC
615	ROLLMARK CALIBER		
618	ROTO-BLAST	8/6/01	RH
620	APPLY COATINGS	8-8-01	TA
625 A	FINAL ASSEMBLY	8/13/01	RH
B	TRIGGER PULL TEST		
C	SAFETY "ON" FORCE		
D	SAFETY "OFF" FORCE		
E	FIRING PIN INDENT		
640	TARGET	8/15/01	AC
655	FINAL INSPECT	8/15/01	RH
660	PACK	8/16/01	DA
		SHIP DATE	
		QAR INSPECTION DATE	

Final Inspection

INC. 6348850

DATE REC'D: 7/31/01

DATE RET'D: 8/6/01

EDITOR: RLL

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.

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

MODEL 700™ H24

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

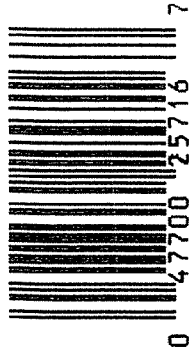
SERIAL NO.
C6348850

ORDER NO.
5716



5716 C6348850

UPC



CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6348850

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	8 11	89	RW
600	Proof	8 11	89	RW
607	Check Headspace			RW
610	Dis-assemble Gun			RW
612	Magnaflux Barrel Action		8/15/89	KCR
	Magnaflux Bolt		8/15/89	KCR
615	Rollmark Caliber		8/15/89	RW
7	Drill and Tap Sight Holes	8 16	89	
618	Polish Barrel RB	8 16	89	
620	Apply Coatings (Barrel Action)		8/19/89	TJA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/21/89	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/21/89	RW
	C) Inspect Ejector Hole for Chamfer		8/21/89	RW
	D) Oil Firing Pin Ass'y		8/21/89	RW
	E) Adjust Trigger Pull to Min Setting and Stake		8/22/89	RW

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			8/22/89	RW
	G) Safety Off Force	3	3	3			8/22/89	RW
	H) Trigger Pull Test & Retainability							
	I) Firing Pin Indent	.022	.022	.022			8/22/89	RW
	J) Assemble Stock						8/22/89	RW
	K) Assemble Swivel Studs						23 Aug 89	JD
	L) Attach Front and Rear Sight Assemblies						8/22/89	RW
	M) Iron Sight Alignment						8/22/89	RW
	N) Detach Front & Rear Sights & place in numbered container						8/22/89	RW
	O) Attach Scope to Rifle						8/22/89	WB
	P) Detach & Attach Scope 20 Times						8/22/89	WB
640	Gallery Target & Test	98	R	546			8-22-89	DH
	A) Time						8-22-89	DH
	B) Malfunctions						8-22-89	DH
	C) Pierced Primers						8-22-89	DH
	D) Optical Clarity of Scope						8-22-89	DH
645	Inspect for Live Ammo						8-22-89	DH
655	Final Inspection							
	A) Headspace						23 Aug 89	JD
	B) Trigger Pull	2.68	2.65	2.54	2.53	2.51	23 Aug 89	JD
	C) Function						23 Aug 89	JD
660	Pack						20 Sep 89	JD

Repaired Stock At front Swivel
9/13/89

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6348850
23 Aug 1989

CENTROIDAL DISTANCES

0 TO	1	.550892
1 TO	2	.593896
1 TO	3	.193197
1 TO	4	.370567
1 TO	5	.737562

5
134
2 (----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.2362

THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .141

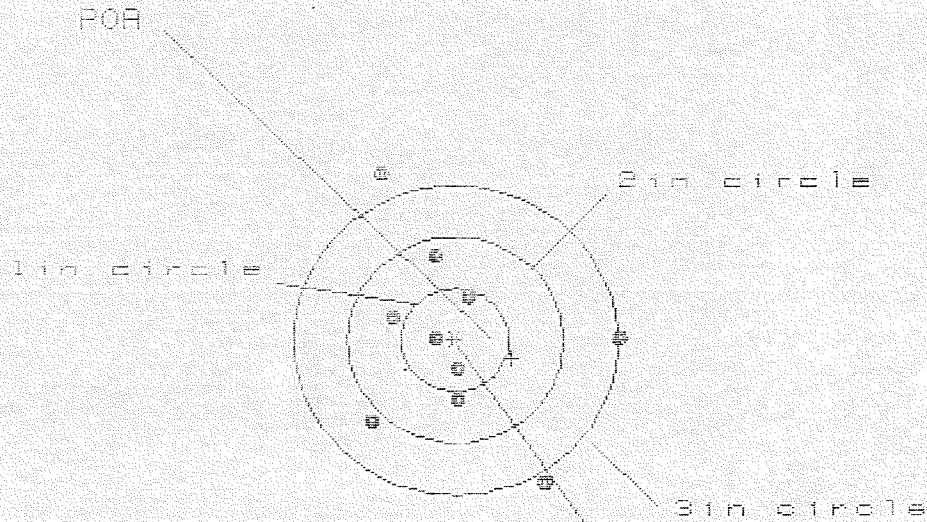
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .275384

THE AMR FOR THIS RIFLE IS: 1.045

22 Aug 1988

FILE:/PATTERNING/CENTERFIRE_PATT/06348850

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1 in = 3

2 in = 6

3 in = 8

HS= 2.296

VS= 3.003

GS= 3.351

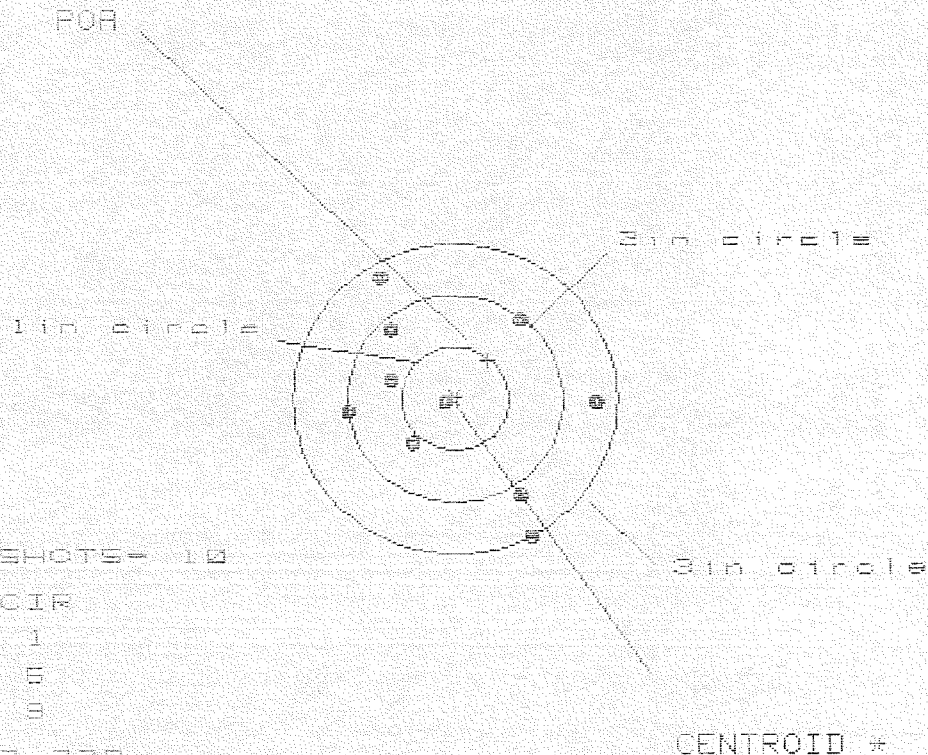
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.475	1.397	1.486
MINIMUM X	-.821	-.899	-.810
MAXIMUM Y	1.585	1.003	.848
MINIMUM Y	-1.418	-1.242	-.793
CENTROID X	-.521	-.443	-.532
CENTROID Y	.179	.003	.158
POA TO CENTROID in.	.551	.443	.555
MIN RADIUS	.146	.176	.143
MEAN RADIUS	.893	.803	.695
MAX RADIUS	1.732	1.431	1.488
HORIZONTAL SPREAD	2.296	2.296	2.296
VERTICAL SPREAD	3.003	2.245	1.631
EXTREME SPREAD	3.351	2.454	2.454
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		8	

22 Aug 1985

FILE: PATTERNING/CENTERFIRE_PATT/06346850

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 6

3 in = 9

HS= 2.332

VS= 2.553

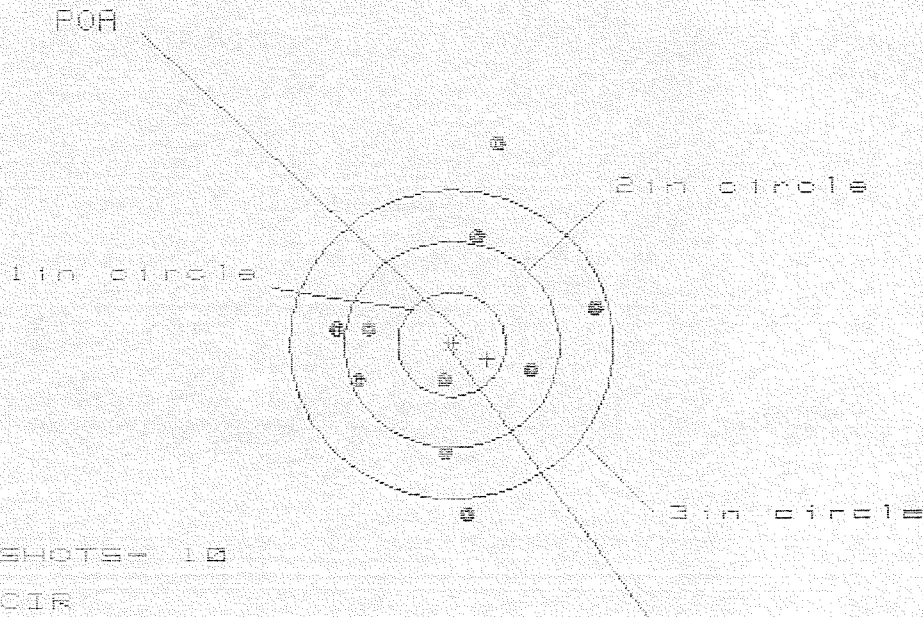
GS= 2.886

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.348	1.424	1.352
MINIMUM X	-1.981	-1.905	-1.977
MAXIMUM Y	1.214	1.065	.789
MINIMUM Y	-1.339	-1.063	-1.930
CENTROID X	-1.307	-1.383	-1.311
CENTROID Y	-1.375	-1.226	-1.359
POA TO CENTROID in.	.484	.445	.475
MIN RADIUS	.098	.183	.101
MEAN RADIUS	.945	.870	.820
MAX RADIUS	1.505	1.435	1.352
HORIZONTAL SPREAD	2.329	2.329	2.329
VERTICAL SPREAD	2.553	2.128	1.719
EXTREME SPREAD	2.886	2.488	2.332
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	9		

22 Aug 1995

FILE:/PATTERNING/CENTERFIRE_PATT/C6346850

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 4

3 in = 5

HS= 2.337

VS= 3.587

GS= 3.602

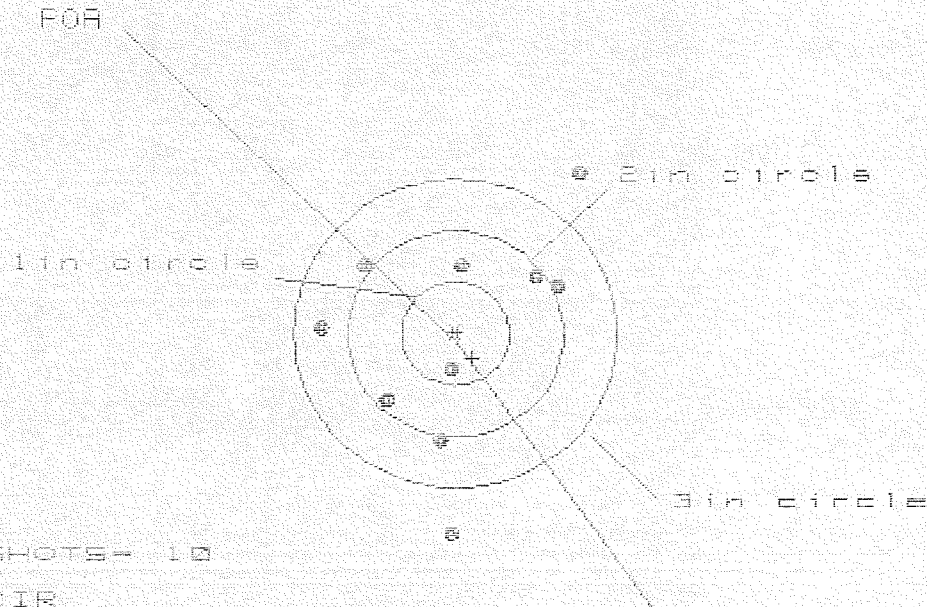
CENTROID *

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.315	1.361	1.378
MINIMUM X	:	-1.022	-0.976	-0.959
MAXIMUM Y	:	1.947	1.294	1.116
MINIMUM Y	:	-1.640	-1.423	-1.044
CENTROID X	:	-0.331	-0.377	-0.394
CENTROID Y	:	.144	-0.073	.105
POB TO CENTROID in.	:	.361	.384	.408
MIN RADIUS	:	.336	.117	.285
MEAN RADIUS	:	1.103	.962	.912
MAX RADIUS	:	1.991	1.459	1.421
HORIZONTAL SPREAD	:	2.337	2.337	2.337
VERTICAL SPREAD	:	3.587	2.717	2.160
EXTREME SPREAD	:	3.602	2.720	2.341
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	

22 Aug 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C834B050

CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1in = 1

2in = 4

3in = 8

HS= 2.393

VS= 3.540

GS= 3.725

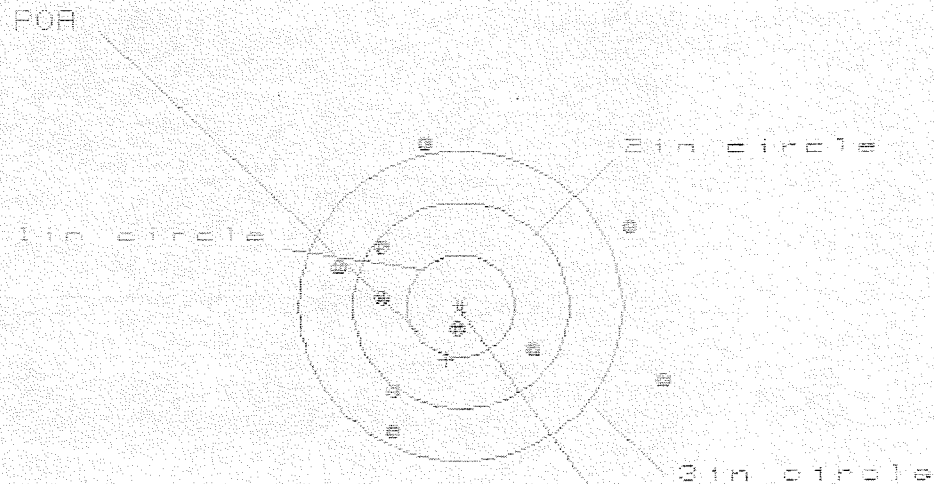
CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.157	1.156	1.071
MINIMUM X	:	-1.236	-1.237	-1.092
MAXIMUM Y	:	1.573	1.354	.614
MINIMUM Y	:	-1.967	-1.247	-1.078
CENTROID X	:	-.155	-.154	-.299
CENTROID Y	:	.237	.456	.287
POA TO CENTROID in.	:	.283	.481	.414
MIN RADIUS	:	.346	.446	.403
MEAN RADIUS	:	1.115	1.011	.895
MAX RADIUS	:	1.967	1.781	1.143
HORIZONTAL SPREAD	:	2.393	2.393	2.163
VERTICAL SPREAD	:	3.540	2.601	1.692
EXTREME SPREAD	:	3.725	2.900	2.200
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	

22 Aug 1989

FILE: \PATTERNING\CENTERFIRE_PATT\06340850

CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 4

3 in = 7

HS= 3.022

VS= 2.796

GS= 3.231

CENTROID *

PATTERN #	5	5	5
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.893	1.801	1.116
MINIMUM X	-1.129	-0.919	-0.893
MAXIMUM Y	1.610	1.526	1.616
MINIMUM Y	-1.186	-1.270	-1.180
CENTROID X	.183	-0.077	-0.303
CENTROID Y	.520	.604	.514
POA TO CENTROID in.	.537	.609	.597
MIN RADIUS	.222	.359	.298
MEAN RADIUS	1.167	1.039	.878
MAX RADIUS	2.037	1.939	1.620
HORIZONTAL SPREAD	3.022	2.720	1.809
VERTICAL SPREAD	2.796	2.796	2.796
EXTREME SPREAD	3.231	2.976	2.814
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	7		

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. 6348850

DATE 4-10-90

TESTER JPL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.53	2.52	2.64	2.44	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.45	2.57	2.64	2.44	
PULL #3	2.46	2.54	2.54	2.43	
PULL #4	2.48	2.57	2.54	2.27	
PULL #5	2.53	2.47	2.56	2.40	
TOTAL	12.45	12.67	12.92	11.98	
AVG.	2.49	2.534	2.584	2.396	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.33	3.50		
PULL #2	3.45	3.53		
PULL #3	3.54	3.48		
PULL #4	3.52	3.48		
PULL #5	3.53	3.53		
TOTAL	17.37	17.52		
AVG.	3.474	3.504		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.20	4.46		
PULL #2	4.02	4.47		
PULL #3	4.40	4.40		
PULL #4	4.31	4.40		
PULL #5	4.45	4.43		
TOTAL	21.38	22.16		
AVG.	4.276	4.432		

RECEIVING AND ESTIMATING REPORT

COMMENTS

M-24 SNIPER

INITIAL JJM	CUSTOMER ORDER NO.		DATE RECEIVED 05/29/90		DATE OPENED 05/31/90	DATE CODE	SERIAL NUMBER C6348850	MODEL AND GRADE 9999 7.62 NATO		ORDER R 90-15645
ACCESSORIES		W/STUDS	W/SWIVELS	SOFT CASE	SCOPE BASE					

FROM:

TRAFFIC MANAGEMENT OFFICE
BLDG 1702 - BAY 3
MCGUIRE AFB NJ 08641

SHIP TO:

TRAFFIC MANAGEMENT OFFICE
BLDG 1702 - BAY 3
MCGUIRE AFB NJ 08641

ACCOUNT NUMBER	ACCOUNT NUMBER N/C	WRITE ☐	PROM. DATE	ESTIMATED	VIA UPS
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REPAIR CHARGE	TAX	INSURANCE	UPS	PARCEL POST	TOTAL
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GUN CONDITION: ☒ NEW ☐ SLIGHTLY WORN ☐ VERY WORN ☐ MISUSED ☐ MARRED

CUSTOMER'S REQUEST

REPLACE TRIGGER Assy

MAIN FAULT

PARTS						
	REPAIRMAN <i>[Signature]</i>	PROOF	CLEAN	TEST	TARGET	PATTERN
	GALLERY TESTER	DATE	DATE	DATE	DATE	DATE

RD6925 REV. 6/88

OFFICE COPY

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

M2400039829