

Arms Services Repair Estimate File on

File Add Repair Estimate Repair Expedite Repair Inquiry Repair Tools CSR Tools Reports Table Maintenance System Maintenance Help

Repair Number: **RE00032485** Serial: C6348893 Model 700 Center Fire Caliber: 7.62 NATO M24 SWS WOG 9 of 25 Repairman: Status: New 9/14/01 3:09:21 PM

Verify Repair

Address Information

Customer: ☒ Received From Return To: ☒ Received From

Name: DEFENCE DIST DEPOT ANNISTON DEFENCE DIST DEPOT ANNISTON

Address 1: 7 FRANKFORD AVE 7 FRANKFORD AVE

Address 2: PO Box: 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

Contact Information

Phone: Fax: Email: Comments:

Received Condition

Fair

Condition Notes: CSR Notes:

Accessories Received

Code	Desc	Qty
A006	Sling Strap	1
A007	With Stud	3
A008	With Swivel	2
A010	Hard Case	1
A026	Scope	1
X001	Scope Case	1
X002	Deployment Kit	1

Repair Search Refresh Close

nagletj 9/17/01 7:29 AM C4PS NUM INS SCFL

Start Arms Services Repair... 7:29 AM

Serial Number: **C6348893**

Model: **700**



RE00032485

Remington Test Lab, Ilion, N.Y.

Centroidal distance calculations for Rifle # c6348893
3 Oct 2001

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: $-.086$
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: $-.2844$
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: $.297118$

THE AMR FOR THIS RIFLE IS: 1.137

CENTROIDAL DISTANCES

0 TO 1	.593709
1 TO 2	.43126
1 TO 3	.386246
1 TO 4	.41689
1 TO 5	.318226

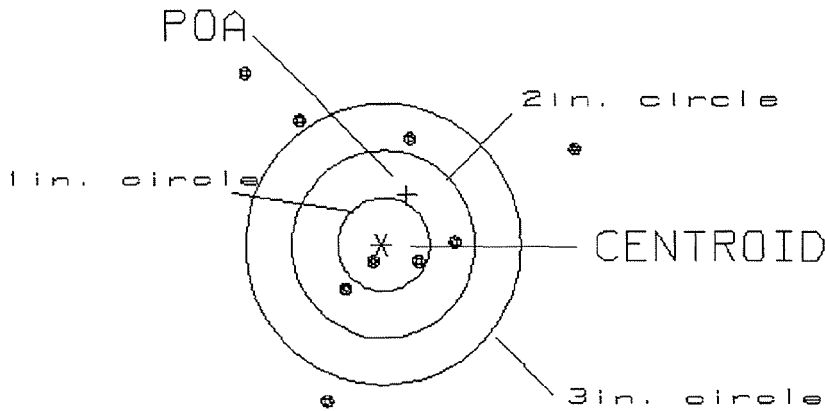
4+
3+
1 <----POA

PATTERN #: ☐ 1 ☐
 POA TO CENTROID: .594
 MIN RADIUS : .216
 MEAN RADIUS : 1.421
 MAX RADIUS : 2.804
 CENTROID X : -.281
 CENTROID Y : -.523

2 Oct 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6348893

CENTERFIRE PATTERN # 1



# OF SHOTS= 10	# IN CIRCLE
HS= 3.66	2
VS= 4.62	4
GS= 4.85	5

REMINGTON CENTERFIRE ACCURACY TEST

REMINGTON TEST LAB, ILION, N.Y.

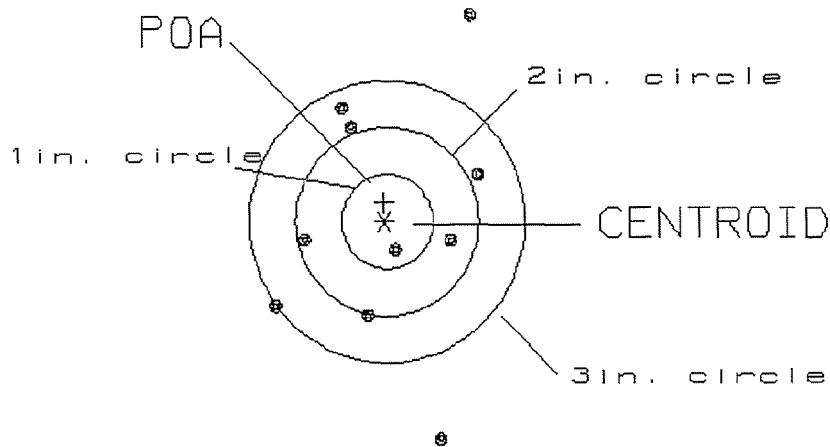
PATTERN #: ☐ 2 ☐

POA TO CENTROID: .202
 MIN RADIUS : .322
 MEAN RADIUS : 1.274
 MAX RADIUS : 2.389
 CENTROID X : .007
 CENTROID Y : -.202

2 Oct 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6348893

CENTERFIRE PATTERN # 2



OF SHOTS= 10

IN CIRCLE

HS= 2.19
 VS= 4.50
 GS= 4.50

1
 3
 6

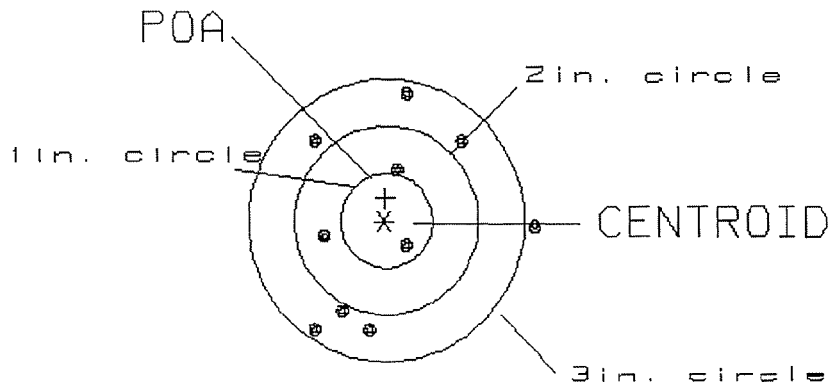
PATTERN #: ☐ 3 ☐

POA TO CENTROID: .243
 MIN RADIUS : .289
 MEAN RADIUS : 1.056
 MAX RADIUS : 1.632
 CENTROID X : -.016
 CENTROID Y : -.242

2 Oct 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6348893

CENTERFIRE PATTERN # 3



OF SHOTS= 10

IN CIRCLE

HS= 2.45
 VS= 2.56
 GS= 2.72

1
 3
 9

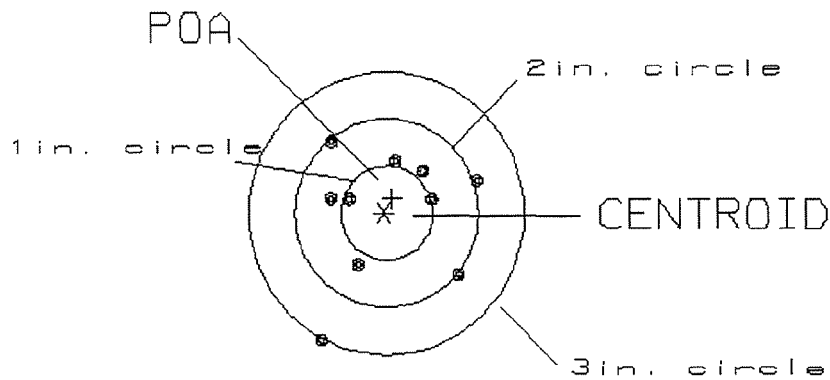
PATTERN #: ☐ 4 ☐

POA TO CENTROID: .177
 MIN RADIUS : .427
 MEAN RADIUS : .779
 MAX RADIUS : 1.538
 CENTROID X : -.087
 CENTROID Y : -.154

2 Oct 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6348893

CENTERFIRE PATTERN # 4



OF SHOTS= 10

IN CIRCLE

HS= 1.72
 VS= 2.06
 GS= 2.40

1
 6
 9

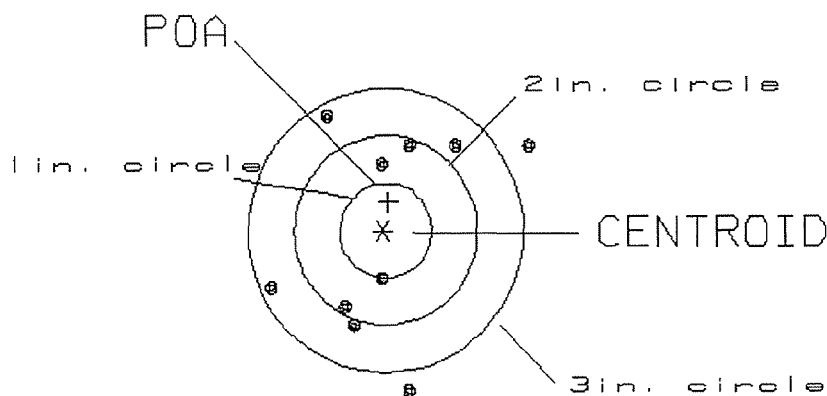
PATTERN #: ☐ 5 ☐

POA TO CENTROID: .306
 MIN RADIUS : .477
 MEAN RADIUS : 1.156
 MAX RADIUS : 1.779
 CENTROID X : -.053
 CENTROID Y : -.301

2 Oct 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6348893

CENTERFIRE PATTERN # 5



OF SHOTS= 10

IN CIRCLE

HS= 2.83

1

VS= 2.66

4

GS= 3.19

8

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

R & E NUMBER 32485			
SERIAL NUMBER C634 8893			
LOG-IN DATE 9-13-01			
INSPECT AND VERIFY:			
OPERATION #	OPERATION NAME	DATE	INITIAL
550	DIS-ASSEMBLE GUN	9-18-01	RJL
560 A	RE-BARREL AT CUSTOM SHOP	9/20/01	BWT
B	DRILL AND TAP	9/20/01	BWT
C	POLISH	9-20-01	GD
575	ASSEMBLE	9-20-01	RJL
600	PROOF	9-21-01	RJL
605	CHECK HEADSPACE	9-24-01	RJL
610	DIS-ASSEMBLE GUN	9-24-01	RJL
612	MAGNAFLUX	9-24-01	RJL
615	ROLLMARK CALIBER	9-24-01	RJL
618	ROTO-BLAST	9/25	K
620	APPLY COATINGS	9/28	HP
625 A	FINAL ASSEMBLY	10-01-01	RJL
B	TRIGGER PULL TEST		
C	SAFETY "ON" FORCE		
D	SAFETY "OFF" FORCE		
E	FIRING PIN INDENT		
640	TARGET	10/2/01	RJL
655	FINAL INSPECT	10-4-01	RJL
660	PACK	10-5-01	RJL
		SHIP DATE	
		QAR INSPECTION DATE	

Final Inspection

ID: C1234 8893

DATE REC'D: 9-7-01

DATE RET'D: 10-9-01

EDITOR: [Signature]

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
- ☒ Spring Swivel Studs
- ☒ ADJUSTABLE BUTT PLATE
- ☒ LOCK NUTS
- ☒ BARREL CLEARANCE
- ☒ COLOR/FINISH

Systems Case

- ☒ SCOPE CASE
- ☒ IRON SIGHTS
- ☒ DEPLOYMENT KIT

Trigger

- ☐ SAFETY OPERATION
- ☐ SET

Comments: _____

op. #	OP. NAME	READINGS			DATE	INIT
625 cont.	F) Safety On Force	6	6	6	27 July 89	JS
	G) Safety Off Force	4	4	4	29 July 89	JS
	H) Trigger Pull Test & Retainability				27 July 89	JS
	I) Firing Pin Indent	.02	.02	.02	29 July 89	JS
	J) Assemble Stock				7/26/89	RW
	K) Assemble Swivel Studs				23 Aug 89	JS
	L) Attach Front and Rear Sight Assemblies				7/27/89	RW
	M) Iron Sight Alignment				7/27/89	RW
	N) Detach Front & Rear Sights & place in numbered container				7/27/89	RW
	O) Attach Scope to Rifle				8/7/89	WB
	P) Detach & Attach Scope 20 Times				8/7/89	WB
640	Gallery Target & Test	94 R	58 L		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	JS
	B) Trigger Pull	2.24	2.31	2.38	23 Aug 89	JS
	C) Function				23 Aug 89	JS
660	Pack				20 Sept 89	JS

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6348893

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	7 11	89	RW
600	Proof	7 11	89	RW
607	Check Headspace	3 11	89	RW
610	Dis-assemble Gun	1	89	RW
612	Magnaflux Barrel Action		7/13	KCR
	Magnaflux Bolt		7/13	KCR
615	Rollmark Caliber		7/13	S.S.
617	Drill and Tap Sight Holes	7 13	89	FB
618	Polish Barrel RB	7 13	89	BT
620	Apply Coatings (Barrel Action)		7-21-89	TJA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		7/25/89	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		7/25/89	RW
	C) Inspect Ejector Hole for Chamfer		7/25/89	RW
	D) Oil Firing Pin Ass'y		7/20/89	RW
	E) Adjust Trigger Pull to Min Setting and Stake		8/1/89	SS



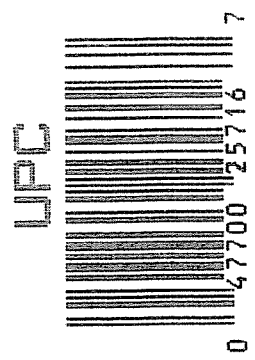
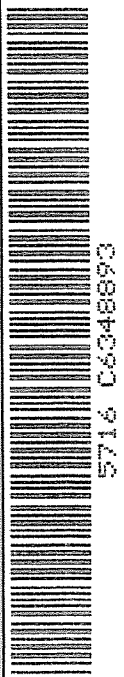

VERY IMPORTANT!
Instruction Book
enclosed to assure
safe use of this
firearm.

MODEL 700™ H24

SERIAL NO.
C6348893

ORDER NO.
5716

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



SWS TRIGGER PULL TEST

8893

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50#+.50#
3.00#+.75#
4.00#+1.00#

SERIAL NO. C6225520

DATE 20 April 89

TESTER gls

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.54	2.40	2.38	2.58	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.52	2.41	2.07	2.57	
PULL #3	2.16	2.37	2.16	2.05	
PULL #4	2.46	2.44	2.24	2.45	
PULL #5	2.50	2.28	2.22	2.62	
TOTAL	12.18	11.90	11.07	12.27	
AVG.	2.436	2.38	2.214	2.454	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.38	3.18		
PULL #2	3.32	2.94		
PULL #3	3.40	3.18		
PULL #4	3.18	3.24		
PULL #5	3.26	3.22		
TOTAL	16.54	15.76		
AVG.	3.308	3.152		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.18	4.13		4.05
PULL #2	4.14	4.06		3.91
PULL #3	4.00	4.01		3.83
PULL #4	4.02	4.20		4.11
PULL #5	4.06	4.02		3.98
TOTAL	20.40	20.42		19.88
AVG.	4.08	4.084		3.976

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6348893
23 Aug 1989

CENTROIDAL DISTANCES

0 TO	1	1.01045
1 TO	2	1.68848
1 TO	3	.225539
1 TO	4	.434495
1 TO	5	.637389

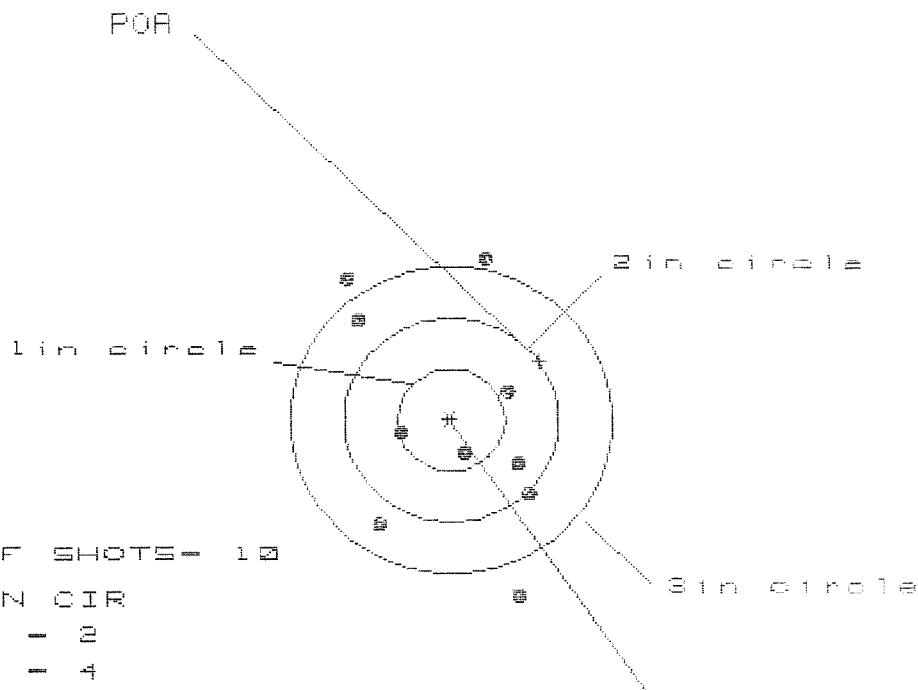
2
5+ (----POA
13+

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.4512
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1846
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .487502
THE AMR FOR THIS RIFLE IS: 1.083

22 Aug 1989

FILE: \PATTERNING\CENTERFIRE_PATT\0834B883

CENTERFIRE PATTERNS # 1



OF SHOTS - 10

IN CIR

1 in = 2

2 in = 4

3 in = 7

HS = 1.728

VS = 3.317

GS = 3.548

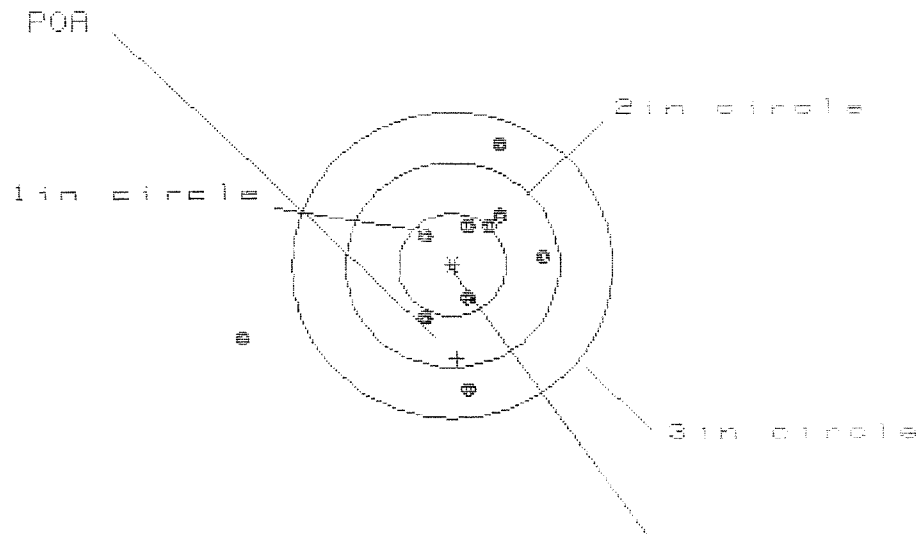
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.734	.887	.691
MINIMUM X	-.994	-.921	-.961
MAXIMUM Y	1.584	1.392	1.544
MINIMUM Y	-1.733	-1.214	-1.062
CENTROID X	-.826	-.899	-.783
CENTROID Y	-.582	-.390	-.542
POR TO CENTROID in.	1.011	.979	.953
MIN RADIUS	.387	.512	.329
MEAN RADIUS	1.089	1.025	.916
MAX RADIUS	1.852	1.527	1.577
HORIZONTAL SPREAD	1.728	1.728	1.632
VERTICAL SPREAD	3.317	2.606	2.606
EXTREME SPREAD	3.548	2.795	2.795
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		4	
NUMBER IN THREE INCH CIRCLE =		7	

22 Aug 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C6348893

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in - 3

2 in - 7

3 in - 9

HS- 2.829

VS- 2.443

GS- 3.088

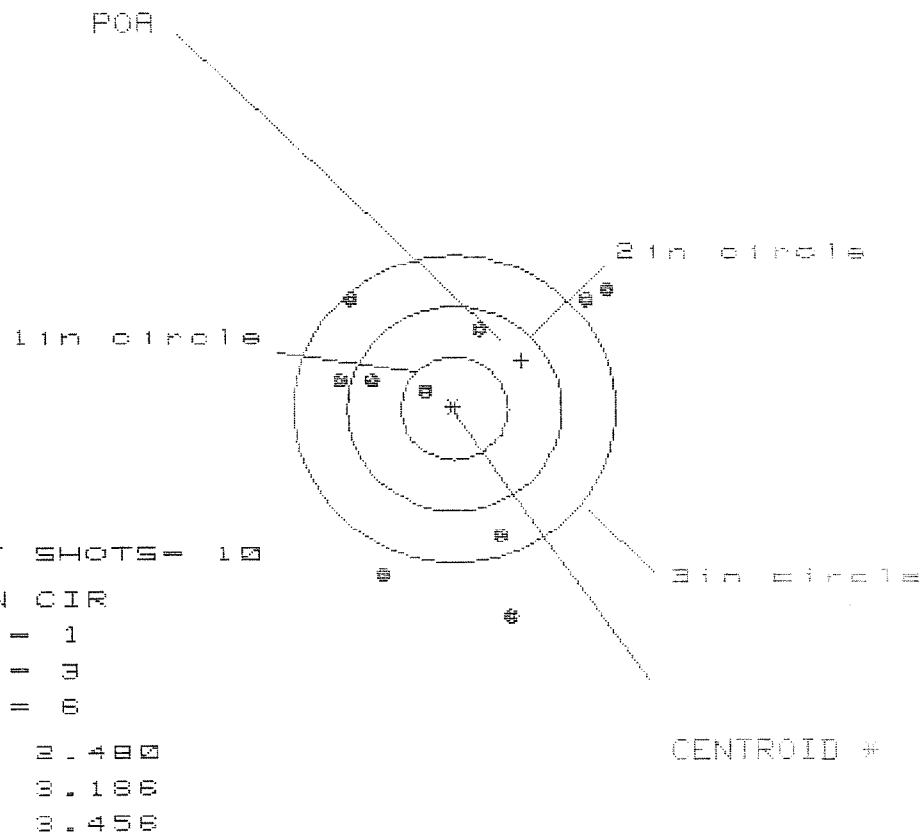
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.830	.608	.635
MINIMUM X	:	-1.999	-.485	-.459
MAXIMUM Y	:	1.191	1.112	.559
MINIMUM Y	:	-1.252	-1.331	-1.192
CENTROID X	:	-.045	.177	.151
CENTROID Y	:	.915	.994	.855
POA TO CENTROID in.	:	.916	1.010	.868
MIN RADIUS	:	.332	.311	.280
MEAN RADIUS	:	.844	.661	.613
MAX RADIUS	:	2.122	1.337	1.196
HORIZONTAL SPREAD	:	2.829	1.093	1.093
VERTICAL SPREAD	:	2.443	2.443	1.751
EXTREME SPREAD	:	3.088	2.466	1.791
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

22 Aug 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C634B8893

CENTERFIRE PATTERNS # 3

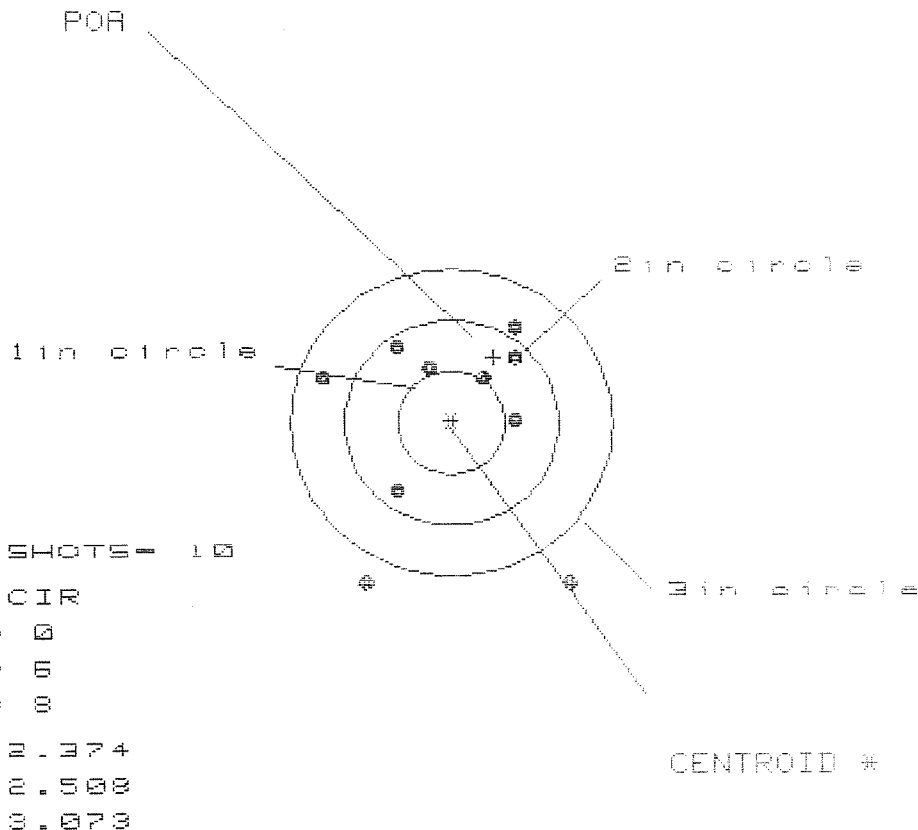


PATTERN #	3	3	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.393	1.457	1.440
MINIMUM X	-1.087	-1.023	-0.840
MAXIMUM Y	1.207	.987	.989
MINIMUM Y	-1.979	-1.803	-1.679
CENTROID X	-.628	-.692	-.875
CENTROID Y	-.474	-.254	-.377
POA TO CENTROID in.	.787	.738	.953
MIN RADIUS	.320	.246	.057
MEAN RADIUS	1.300	1.169	1.054
MAX RADIUS	2.062	1.894	1.747
HORIZONTAL SPREAD	2.480	2.480	2.280
VERTICAL SPREAD	3.186	2.790	2.669
EXTREME SPREAD	3.456	3.456	3.241
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	3		
NUMBER IN THREE INCH CIRCLE =	6		

22 Aug 1989

FILE:/PATTERNING/CENTERFIRE_PATT/08346883

CENTERFIRE PATTERNS # 4

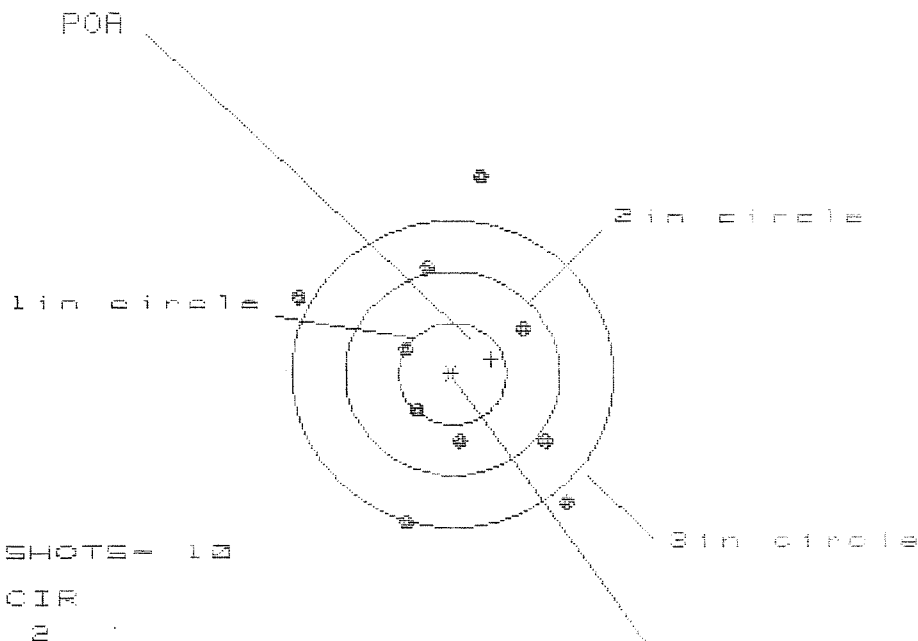


PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.122	.766	.682
MINIMUM X	:	-1.252	-1.127	-1.211
MAXIMUM Y	:	.942	.772	.555
MINIMUM Y	:	-1.566	-1.736	-1.087
CENTROID X	:	-.395	-.520	-.436
CENTROID Y	:	-.637	-.467	-.250
POA TO CENTROID in.	:	.750	.699	.503
MIN RADIUS	:	.534	.407	.245
MEAN RADIUS	:	1.063	.933	.753
MAX RADIUS	:	1.897	1.860	1.211
HORIZONTAL SPREAD	:	2.374	1.893	1.893
VERTICAL SPREAD	:	2.508	2.508	1.642
EXTREME SPREAD	:	3.073	2.881	2.015
NUMBER IN ONE INCH CIRCLE	=		6	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

22 Aug 1989

FILE:/PATTERNING/CENTERFIRE_PATT/0634B893

CENTERFIRE PATTERNS # 5



OF SHOTS - 10

IN CIR

1in - 2

2in - 4

3in - 6

HS - 2.458

VS - 3.381

GS - 3.436

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.026	1.050	1.028
MINIMUM X	:	-1.432	-1.408	-1.276
MAXIMUM Y	:	1.908	1.293	1.161
MINIMUM Y	:	-1.473	-1.261	-1.393
CENTROID X	:	-.362	-.386	-.517
CENTROID Y	:	-.145	-.357	-.225
POR TO CENTROID in.	:	.390	.526	.564
MIN RADIUS	:	.439	.342	.315
MEAN RADIUS	:	1.119	1.005	.934
MAX RADIUS	:	1.920	1.704	1.521
HORIZONTAL SPREAD	:	2.458	2.458	2.305
VERTICAL SPREAD	:	3.381	2.554	2.554
EXTREME SPREAD	:	3.436	3.180	2.675
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		6	