

G6845864
Replaces
E6703520

Repair Inquiry

Repair Number: RE00161971

Serial: E6703520 Model M24 SWS Center Fire
Caliber: 7.62 NATO

Repairman:

Status:

Closed 2/13/2009 8:06:41 AM

Address Information

Customer: ☒ Received From Return To: ☐ Received From
Name: FB4830 TMO 23RD LRS LGRDDC FE4830 TMO 23RD LRS LGRDDC
Address 1: 4380D ALABAMA ROAD 4380D ALABAMA ROAD
Address 2: PO Box: PO Box:
City: MOODY AFB MOODY AFB
State: GA Zip Code: 31699 Country: US State: GA Zip Code: 31699 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
A007	With Stud	2
A010	Hard Case	1
A017	Scope Base	1
A057	Fit and Rear Sgt Base	1

Repair Search

Refresh

Close

Evaluation

nagletj

2/13/2009

1:31 PM

CAPS

NUM

INS

SCRL

H start

12 Microsoft...

4 Microsoft...

3 Internet E...

Arms Services...

Part Search B...

3 SAP Logon...

1:31 PM

G6845864

Serial Number: E6703520

Model: M24 SWS



RE00161971

INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL #

G6845864 For E6703620

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		4-3-09	SP
430	ASSEMBLE TO STOCK		4-3-09	SP
440	PROOF		4-3-09	SP
460	CHECK HEADSPACE		4-3-09	SP
470	DIS-ASSEMBLE ACTION		4-3-09	SP
472	SERIALIZE BOLT HANDLE	MAGNA-FLUX	4-6-09	RT
475	DRILL AND TAP SIGHT HOLES		4-6-09	SP
480	MAGNAFLUX BBL ACTION	OPERATOR	4/8/09	RT
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		4/8/09	RT
520	GOFF BLAST BBL / REC		4-8	RT
542	APPLY COATINGS (BARREL ACTION)		4-13	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		4/13-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		4/13-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		4-13-09	SP
	D) OIL FIRING PIN ASSEMBLY			
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

F004 REV 5/2006

560	F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX	<u>40</u>	<u>40</u>	<u>40</u>	5-11-09	RN		
CONT.									
	G) SAFETY OFF FORCE	2 LBS MIN	<u>50</u>	<u>50</u>	<u>50</u>	5-11-09	RN		
	H) TRIGGER PULL TEST AND RETAINABILITY								
	I) FIRING PIN INDENT	.020 MIN	<u>.023</u>	<u>.023</u>	<u>.023</u>	5-11-09	RN		
	J) ASSEMBLE STOCK								
	K) ASSEMBLE SWIVEL STUDS								
	L) ATTACH FRONT AND REAR SIGHT ASSY'S								
	M) IRON SIGHT ALIGNMENT								
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER								
640 &	FUNCTION TEST AND		PASS	FAIL					
650	TARGET		PASS	FAIL		5-6-09	WN		
	MALFUNCTION		CORRECTION						
	MALFUNCTION		CORRECTION						
	MALFUNCTION		CORRECTION						
	MALFUNCTION		CORRECTION						
660	INSPECT FOR LIVE AMMO					5-6-09	TOR		
670	FINAL INSPECTION A) HEADSPACE					5-11-09	RN		
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.68</u>	<u>272</u>	<u>267</u>	<u>267</u>	<u>271</u>	5-7-09	RTL
	C) FUNCTION					5-11-09	RN		
690	PACK					5/15/09	Fm		

F004 REV 5/2006

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6845864.__0

FILE DATE AND TIME: 05/07/2009 05:33

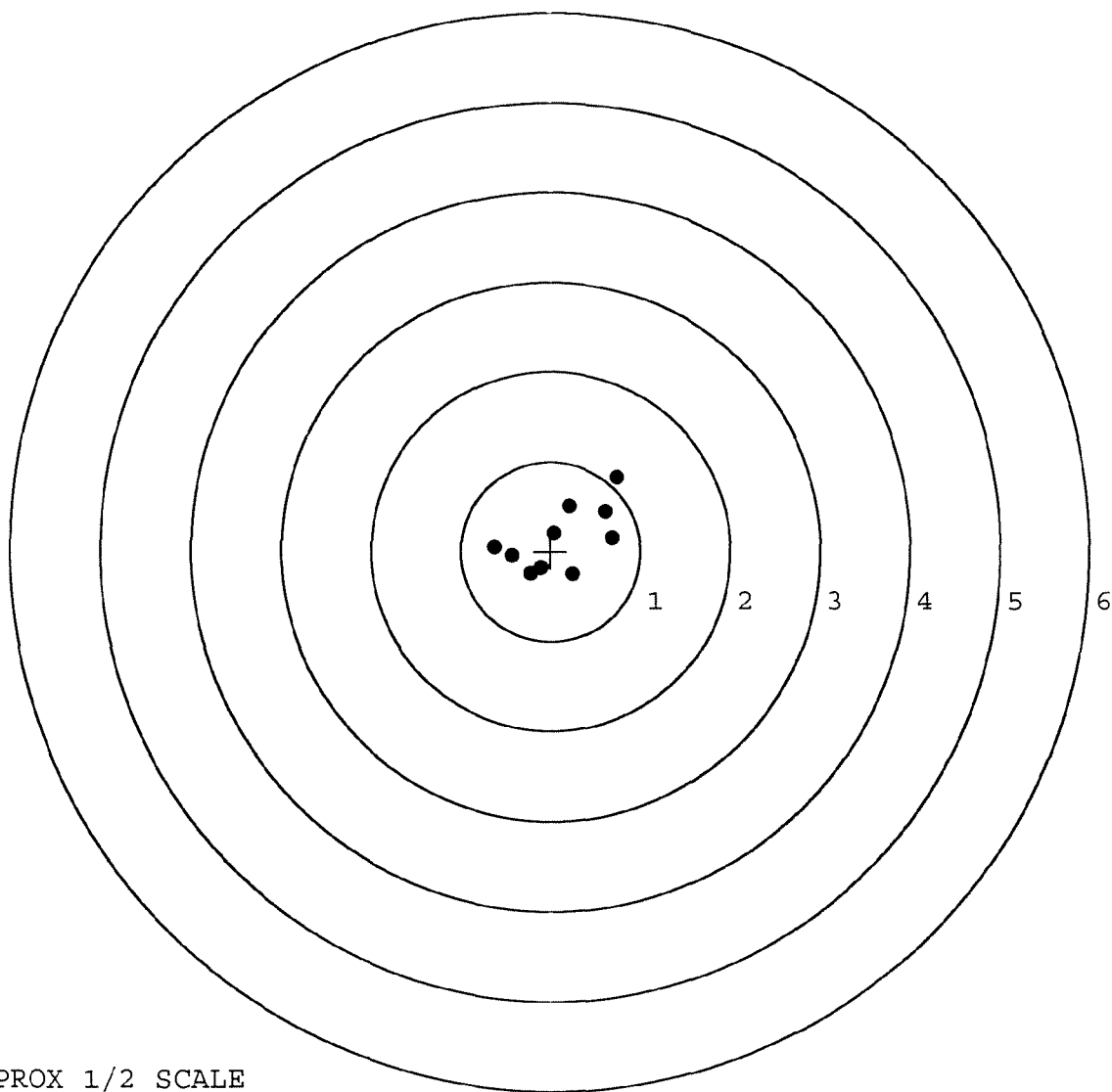
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.010
The Average Y Centroid of the Five Target Set:	0.109
The Average Point of Impact of the Five Target Set:	0.110
The Average Mean Radius of the Five Target Set:	0.546
The Distance from POA to Centroid Target #1:	0.185
The Distance from Centroid Target #2 to Centroid Target #1:	0.147
The Distance from Centroid Target #3 to Centroid Target #1:	0.118
The Distance from Centroid Target #4 to Centroid Target #1:	0.289
The Distance from Centroid Target #5 to Centroid Target #1:	0.256

SERIAL NUMBER: G6845864. __0
TARGET NUMBER: 1
FILE DATE: 05/07/2009
FILE TIME: 05:33

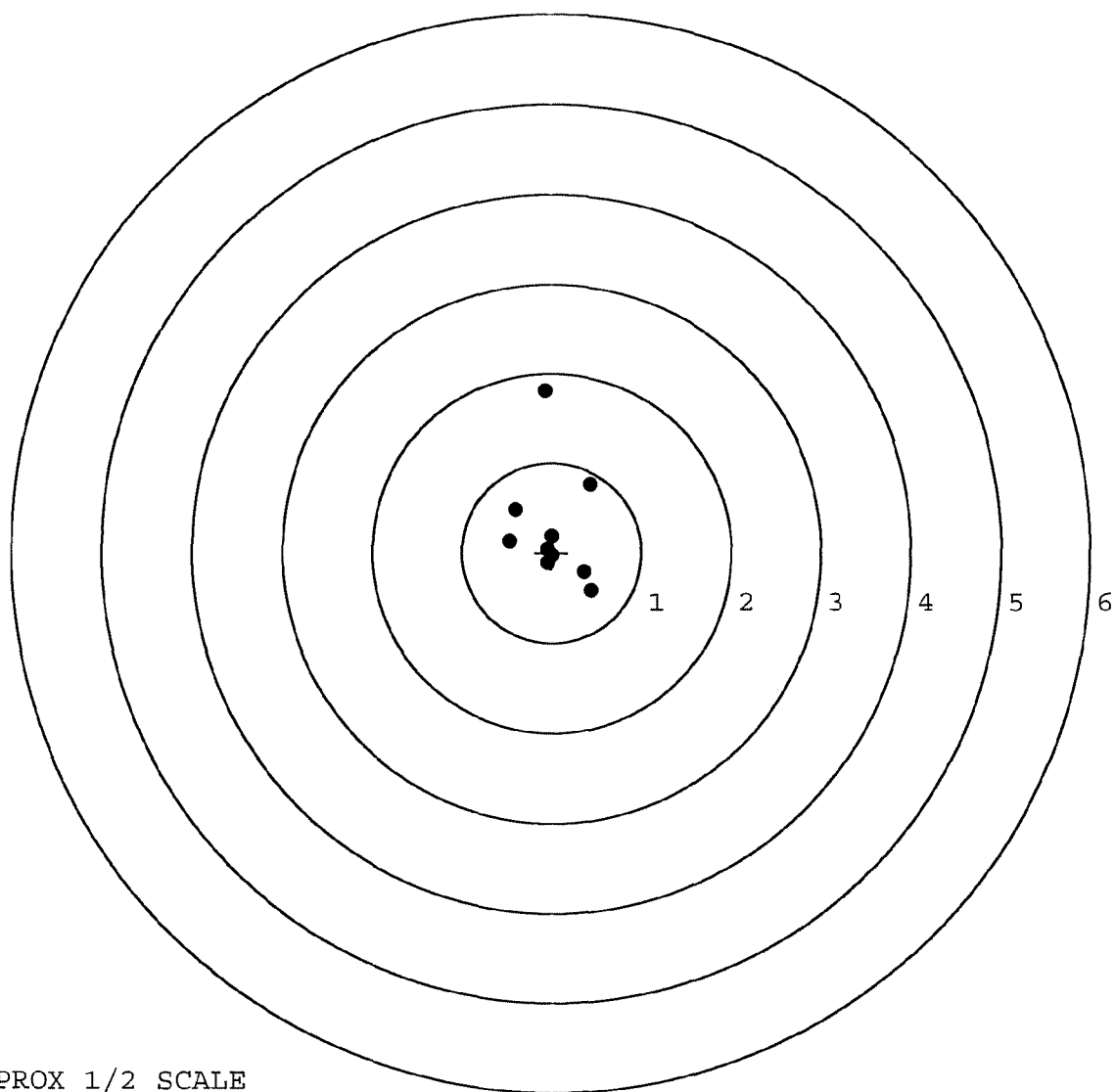
POINT#	X	Y
1:	0.686	0.157
2:	0.609	0.451
3:	0.742	0.828
4:	0.044	0.206
5:	0.208	0.501
6:	0.248	-0.257
7:	-0.113	-0.183
8:	-0.432	-0.050
9:	-0.621	0.050
10:	-0.221	-0.252

X CENTROID: 0.115
Y CENTROID: 0.145
POA TO CENTROID: 0.185
HORZ SPREAD: 1.363
VERT SPREAD: 1.085
GROUP SPREAD: 1.569
MIN RADIUS: 0.094
MAX RADIUS: 0.927
MEAN RADIUS: 0.521
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 10
in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6845864.____0	POINT#	X	Y
TARGET NUMBER: 2	1:	0.009	-0.028
FILE DATE: 05/07/2009	2:	0.442	-0.424
FILE TIME: 05:33	3:	0.363	-0.217
	4:	-0.042	-0.116
X CENTROID: 0.024	5:	0.012	0.181
Y CENTROID: 0.260	6:	-0.044	0.037
POA TO CENTROID: 0.261	7:	-0.471	0.127
HORZ SPREAD: 0.913	8:	-0.402	0.475
VERT SPREAD: 2.227	9:	0.440	0.763
GROUP SPREAD: 2.284	10:	-0.067	1.803
MIN RADIUS: 0.080			
MAX RADIUS: 1.546			
MEAN RADIUS: 0.556			
# IN 1 IN DIAMETER: 5			
# IN 2 IN DIAMETER: 9			
# in 3 IN DIAMETER: 9			



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6845864. __0

TARGET NUMBER: 3

FILE DATE: 05/07/2009

FILE TIME: 05:33

POINT#	X	Y
1:	0.469	0.069
2:	0.445	0.388
3:	0.159	-0.653
4:	0.033	-0.302
5:	0.196	0.156
6:	0.038	0.113
7:	-0.175	0.309
8:	-0.660	-0.114
9:	-0.462	0.478
10:	-0.068	1.085

X CENTROID: -0.002

Y CENTROID: 0.153

POA TO CENTROID: 0.153

HORZ SPREAD: 1.129

VERT SPREAD: 1.738

GROUP SPREAD: 1.753

MIN RADIUS: 0.057

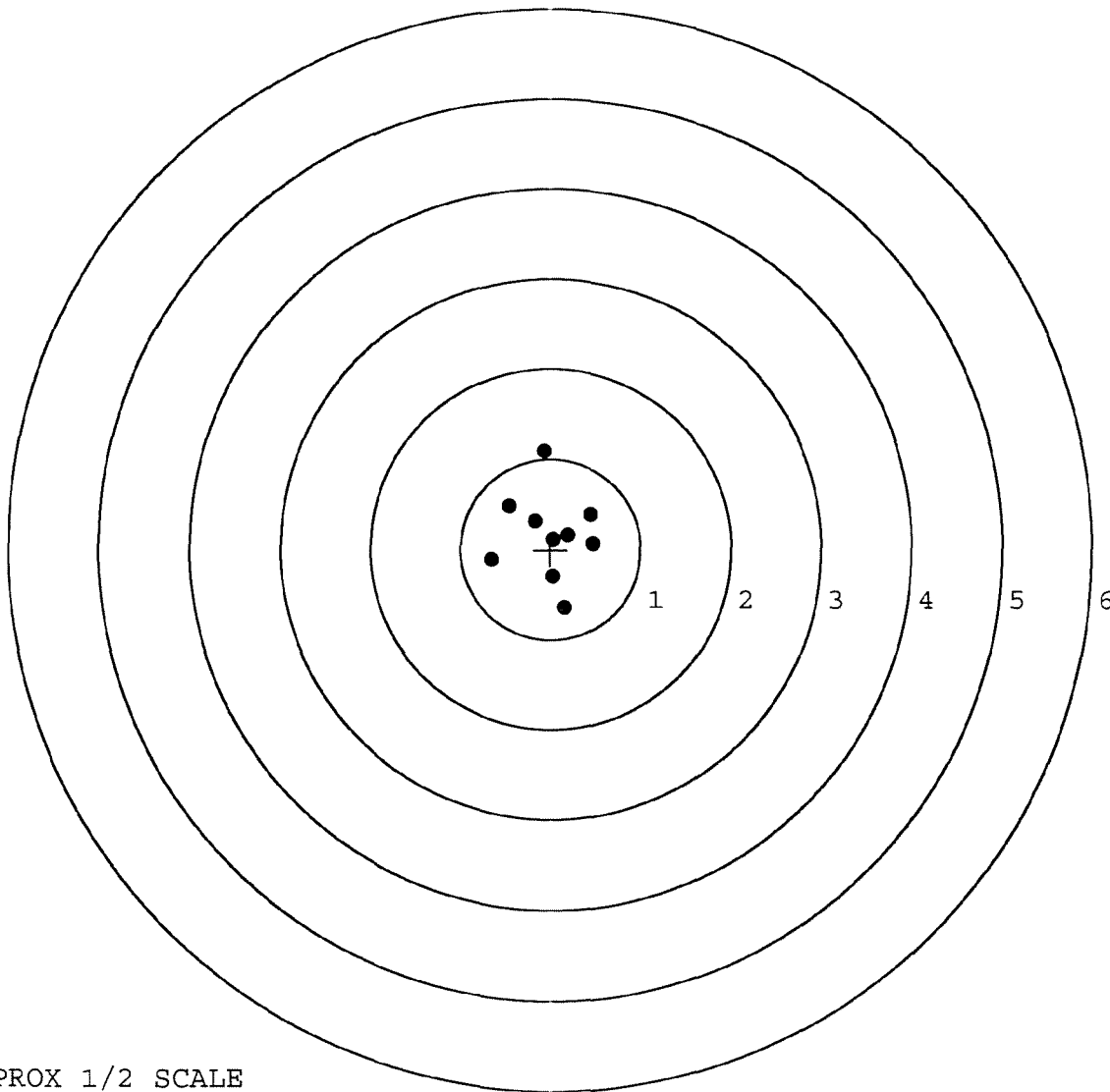
MAX RADIUS: 0.934

MEAN RADIUS: 0.496

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10

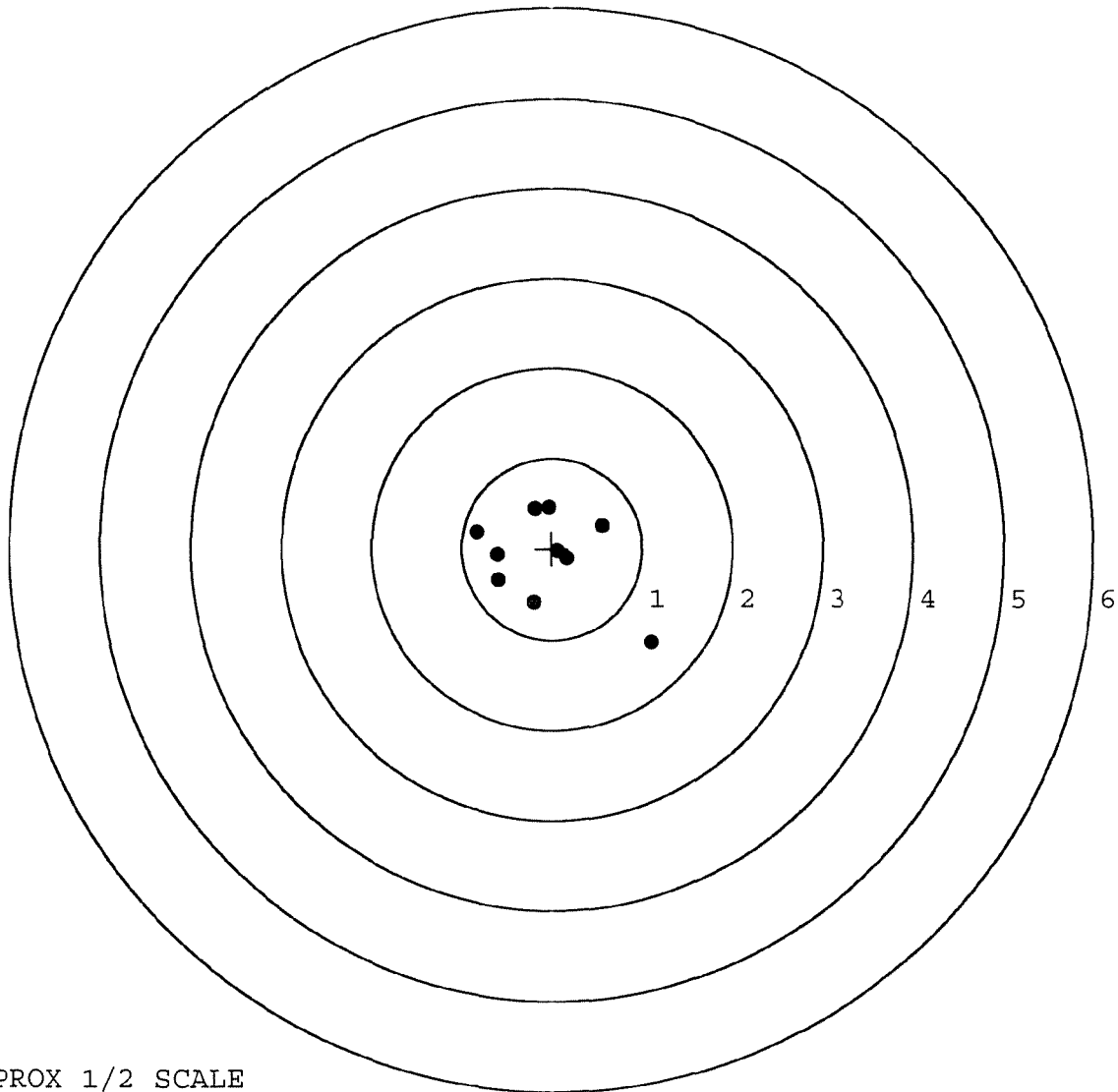


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6845864. __0
TARGET NUMBER: 4
FILE DATE: 05/07/2009
FILE TIME: 05:33

POINT#	X	Y
1:	0.556	0.254
2:	0.169	-0.109
3:	0.061	-0.026
4:	-0.188	0.441
5:	-0.036	0.454
6:	-0.201	-0.598
7:	-0.594	-0.353
8:	-0.606	-0.071
9:	-0.839	0.179
10:	1.097	-1.029

X CENTROID: -0.058
Y CENTROID: -0.086
POA TO CENTROID: 0.104
HORZ SPREAD: 1.936
VERT SPREAD: 1.483
GROUP SPREAD: 2.282
MIN RADIUS: 0.133
MAX RADIUS: 1.491
MEAN RADIUS: 0.614
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

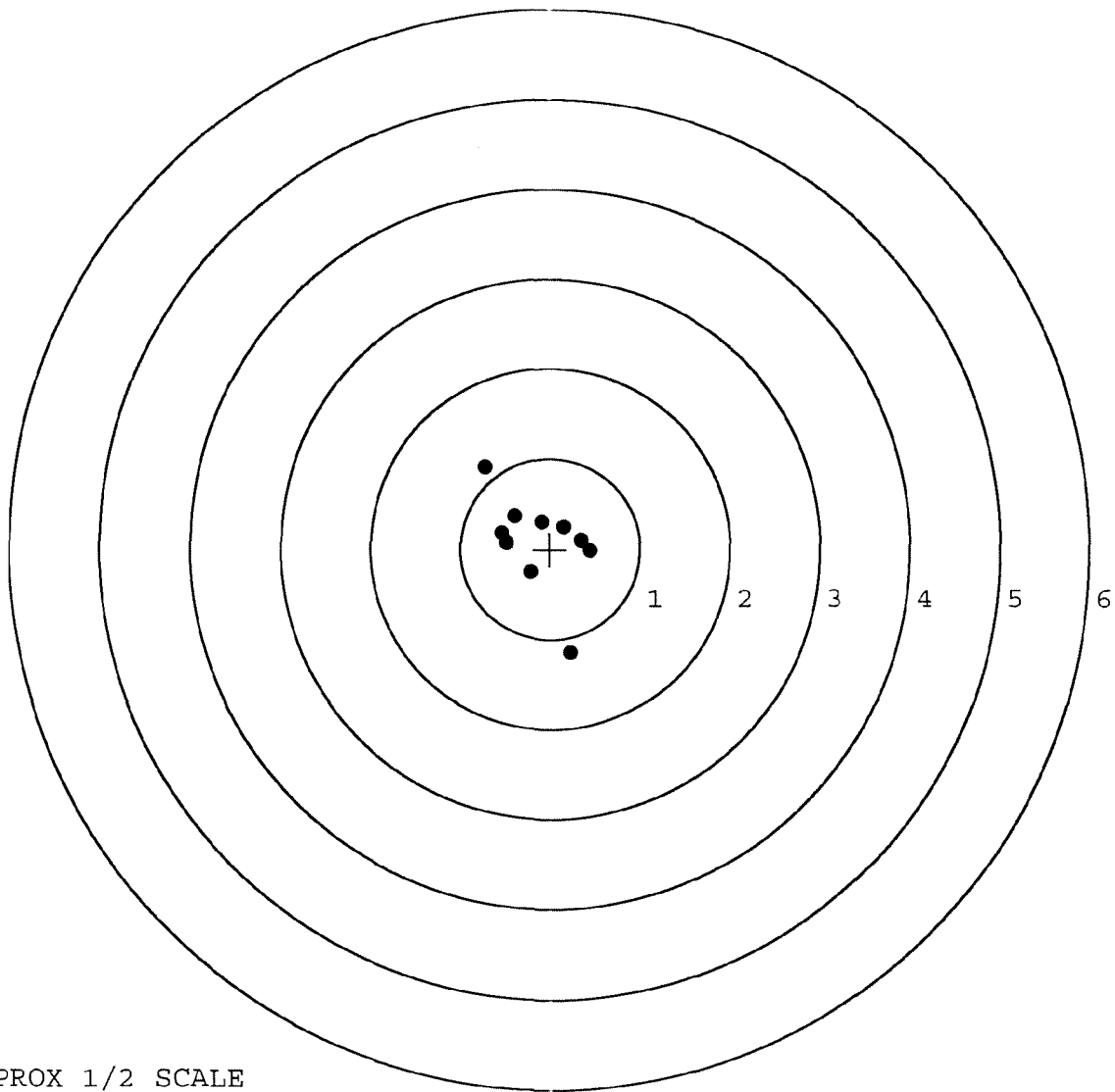


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6845864. 0
TARGET NUMBER: 5
FILE DATE: 05/07/2009
FILE TIME: 05:33

POINT#	X	Y
1:	0.448	-0.015
2:	0.350	0.104
3:	0.149	0.247
4:	-0.218	-0.259
5:	-0.098	0.306
6:	-0.399	0.361
7:	-0.545	0.175
8:	-0.490	0.068
9:	-0.726	0.905
10:	0.222	-1.147

X CENTROID: -0.131
Y CENTROID: 0.074
POA TO CENTROID: 0.150
HORZ SPREAD: 1.174
VERT SPREAD: 2.052
GROUP SPREAD: 2.260
MIN RADIUS: 0.234
MAX RADIUS: 1.271
MEAN RADIUS: 0.545
IN 1 IN DIAMETER: 7
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10



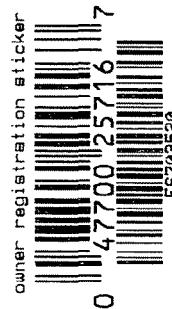
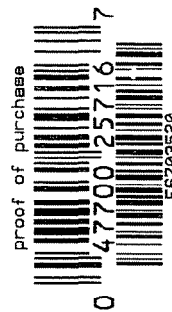
TARGET APPROX 1/2 SCALE

MODEL 700™ M24
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO

DOCUMENT ENVELOPE ASSEMBLY:

- INSTRUCTION BOOK
- PRODUCT OWNER'S CARD
- SAFETY BOOKLET

46 FORM 1444

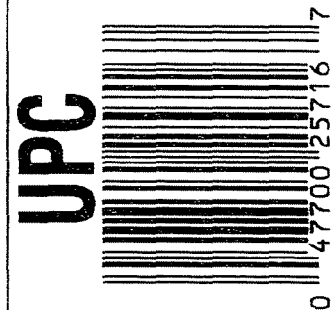


ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

E6703520



Remington®

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

MODEL 700TH M24
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO

SERIAL NO. ^J

E6703520

ORDER NO.

25716

46

Made in Ilion, NY Reg. U.S. Pat & tm. Off. Marca Registrada Marque Deposee.



5716 E6703520

11CV

ORDER 25716

MODEL 700TH M24

UPC



ORDER 25716

MODEL 700TH M24

UPC



SERIAL NO.



CONTRACT # DAAE20-01-C-0007

GUN SERIAL #

E6703520

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		3/21/01	CK
600	PROOF		"	"
607	CHECK HEADSPACE		"	"
610	DIS-ASSEMBLE GUN		"	"
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT			
615	ROLLMARK CALIBER			
617	DRILL AND TAP SIGHT HOLES		3/21/01	DA
618	POLISH BARREL			
620	APPLY COATINGS (BARREL ACTION)			
	(BOLT)			
625	FINAL ASSEMBLY			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		3/22/01	DA
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		"	"
	C) INSPECT EJECTOR HOLE FOR CHAMFER		"	"
	D) OIL FIRING PIN ASSEMBLY		3/23/01	CK
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE		3/23/01	CK

OP #	OPERATION NAME	READINGS			DATE	INITIAL
625	F) SAFETY ON FORCE	<u>7.0</u>	<u>7.0</u>	<u>6.5</u>	3/26	DBL
CONT.	G) SAFETY OFF FORCE	<u>3.5</u>	<u>3.5</u>	<u>3.5</u>	3/26	DBL
	H) TRIGGER PULL TEST AND RETAINABILITY					
	I) FIRING PIN INDENT	<u>1021</u>	<u>1022</u>	<u>1022</u>	3/26	DBL
	J) ASSEMBLE STOCK					CK
	K) ASSEMBLE SWIVEL STUDS					
	L) ATTACH FRONT AND REAR SIGHT ASSY'S					
	M) IRON SIGHT ALIGNMENT					
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER					
640	GALLERY TEST AND TARGET				3-25-01	Rw
	A) MALFUNCTIONS				3-25-01	Rw
	B) PIERCED PRIMERS				3-25-01	Rw
645	INSPECT FOR LIVE AMMO				3-25-01	Rw
655	FINAL INSPECTION A) HEADSPACE				3/30/01	Rw
	B) TRIGGER PULL	<u>284</u>	<u>286</u>	<u>287</u>	3-26	TJD
	C) FUNCTION					
660	PACK				4/2/01	DA

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

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

SERIAL NO. E6703520

DATE 12-29-00

TESTER RW

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.55	2.70		2.66	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.49	2.62		2.72	
PULL #3	2.52	2.61		2.36	
PULL #4	2.36	2.78		2.83	
PULL #5	2.68	2.72		2.73	
TOTAL	12.60	13.43		13.30	
AVG.	2.52	2.69		2.66	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.08	3.11		
PULL #2	3.09	3.15		
PULL #3	3.00	3.12		
PULL #4	3.09	3.13		
PULL #5	3.04	3.11		
TOTAL	15.30	15.62		
AVG.	3.06	3.12		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.12	4.32		4.11
PULL #2	4.17	4.40		4.47
PULL #3	4.12	4.48		4.52
PULL #4	4.13	4.55		4.53
PULL #5	4.14	4.53		4.60
TOTAL	20.68	22.28		22.23
AVG.	4.14	4.46		4.45

Remington Test Lab, Ilion, N.Y.

Centroidal distance calculations for Rifle # e6703520
27 Mar 2001

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0104
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .015
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0182527

THE AMR FOR THIS RIFLE IS: 1.276

CENTROIDAL DISTANCES

0 TO 1	.167386
1 TO 2	.36761
1 TO 3	.135831
1 TO 4	.309808
1 TO 5	.111018

3
5
4 + 1 <----POA
2

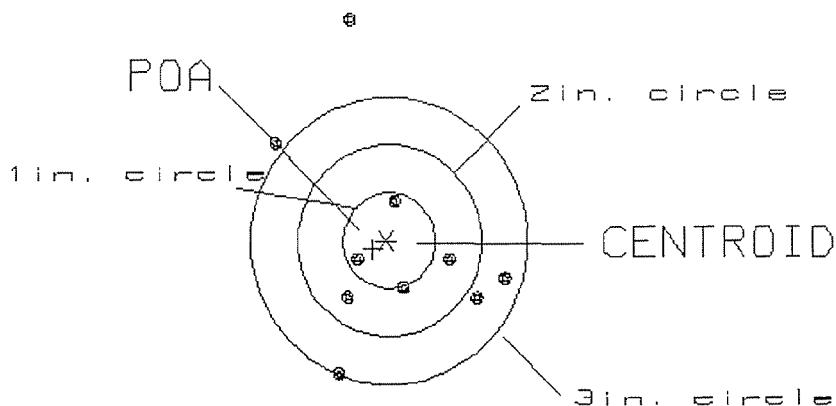
PATTERN #: 1

POA TO CENTROID: .168
 MIN RADIUS : .408
 MEAN RADIUS : 1.050
 MAX RADIUS : 2.311
 CENTROID X : .143
 CENTROID Y : .087

26 Mar 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/e6703520

CENTERFIRE PATTERN # 1



OF SHOTS= 10

IN CIRCLE

HS= 2.45

2

VS= 3.65

5

GS= 3.65

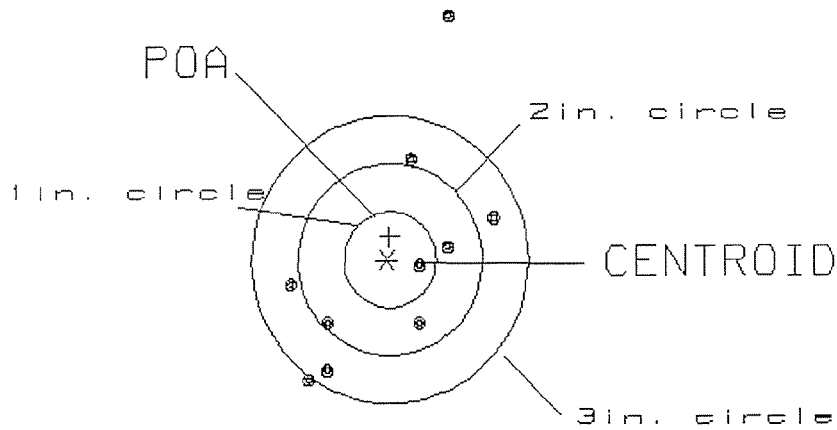
8

PATTERN #: ☐ 2 ☐
 POA TO CENTROID: .243
 MIN RADIUS : .335
 MEAN RADIUS : 1.137
 MAX RADIUS : 2.588
 CENTROID X : -.021
 CENTROID Y : -.242

26 Mar 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/e6703520

CENTERFIRE PATTERN # 2



OF SHOTS= 10

IN CIRCLE

HS= 2.15
 VS= 3.76
 GS= 4.08

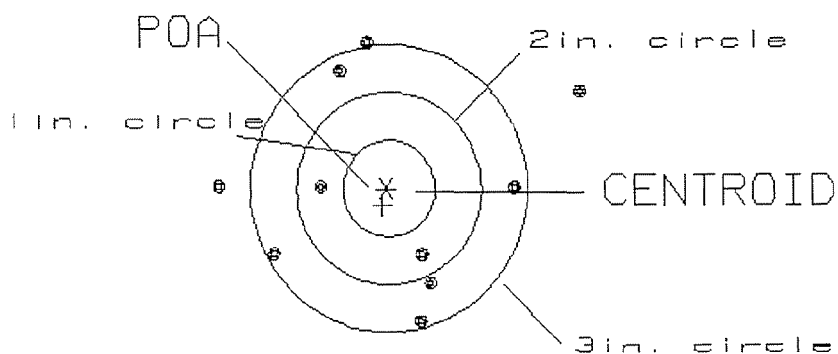
1
 4
 8

PATTERN #: 3
 POA TO CENTROID: .185
 MIN RADIUS : .704
 MEAN RADIUS : 1.369
 MAX RADIUS : 2.255
 CENTROID X : .044
 CENTROID Y : .180

26 Mar 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/e6703520

CENTERFIRE PATTERN # 3



OF SHOTS= 10

IN CIRCLE

HS= 3.82

0

VS= 2.89

2

GS= 3.95

7

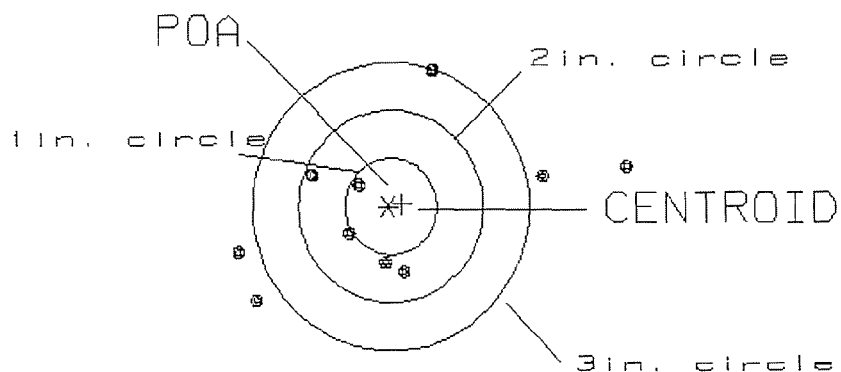
PATTERN #: ☐ 4 ☐

POA TO CENTROID: .149
 MIN RADIUS : .419
 MEAN RADIUS : 1.234
 MAX RADIUS : 2.600
 CENTROID X : -.147
 CENTROID Y : -.022

26 Mar 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/e6703520

CENTERFIRE PATTERN # 4



OF SHOTS= 10

IN CIRCLE

HS= 4.24
 VS= 2.45
 GS= 4.32

1
 5
 5

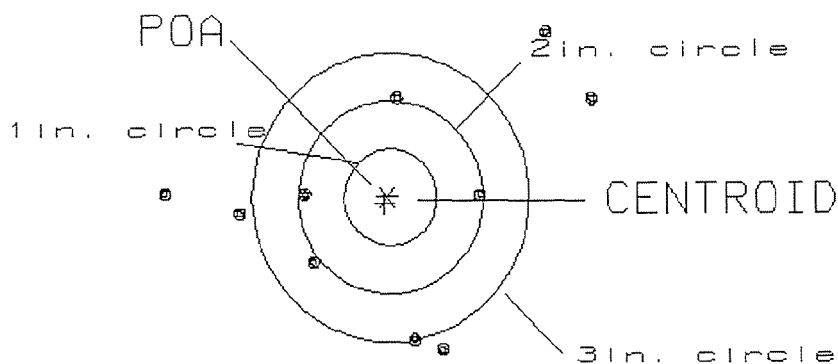
PATTERN #: 5

POA TO CENTROID: .079
 MIN RADIUS : .922
 MEAN RADIUS : 1.591
 MAX RADIUS : 2.409
 CENTROID X : .033
 CENTROID Y : .072

26 Mar 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/e6703520

CENTERFIRE PATTERN # 5



OF SHOTS= 10

IN CIRCLE

HS= 4.52

0

VS= 3.26

2

GS= 4.64

5