

G684 8402
Replaces
E6703464

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: **RE00161967** Serial: E6703464 Model M24 SWS Center Fire Repairman: Status: Closed 2/13/2009 8:07:22 AM
 Verify Repair Caliber: 7.62 NATO

Address Information

Customer: Received From Return To: Received From
 Name: FB4830 TMO 23RD LRS LGRDDC FB4830 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

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 Sg. Base	1

Repair Search Refresh Close

Evaluat

nagleitj 2/13/2009 1:30 PM CAPS NUM INS SCRL

start 12 Microsoft... 4 Microsoft... 3 Internet E... Arms Services... Part Search b... 3 SAP Logon... 1:30 PM

G 684 840 2 (New)

Serial Number: **E6703464**

Model: **M24 SWS**



RE00161967

INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL #

G6848402 For EL703464

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 (H)	4/8/09	(H)
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		4/8/09	RT
520	GOFF BLAST BBL / REC		4-8	B+
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	L N		
CONT.									
	G) SAFETY OFF FORCE	2 LBS MIN	<u>50</u>	<u>50</u>	<u>50</u>	5-11-09	L N		
	H) TRIGGER PULL TEST AND RETAINABILITY								
	I) FIRING PIN INDENT	.020 MIN	<u>.032</u>	<u>.032</u>	<u>.032</u>	5-11-09	L N		
	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 & 650	FUNCTION TEST AND TARGET		<u>PASS</u>	FAIL					
			<u>PASS</u>	FAIL		5-6-09	WZ		
	MALFUNCTION		CORRECTION N/A						
	MALFUNCTION								
	MALFUNCTION								
	MALFUNCTION								
660	INSPECT FOR LIVE AMMO					5-6-09	TAR		
670	FINAL INSPECTION A) HEADSPACE					5-11-09	L N		
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.52</u>	<u>2.48</u>	<u>2.52</u>	<u>2.53</u>	<u>2.43</u>	5-7-09	LTZ
	C) FUNCTION							5-11-09	L N
690	PACK							5/15/09	Fry

F004 REV 5/2006

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6848402.___0

FILE DATE AND TIME: 05/06/2009 14:51

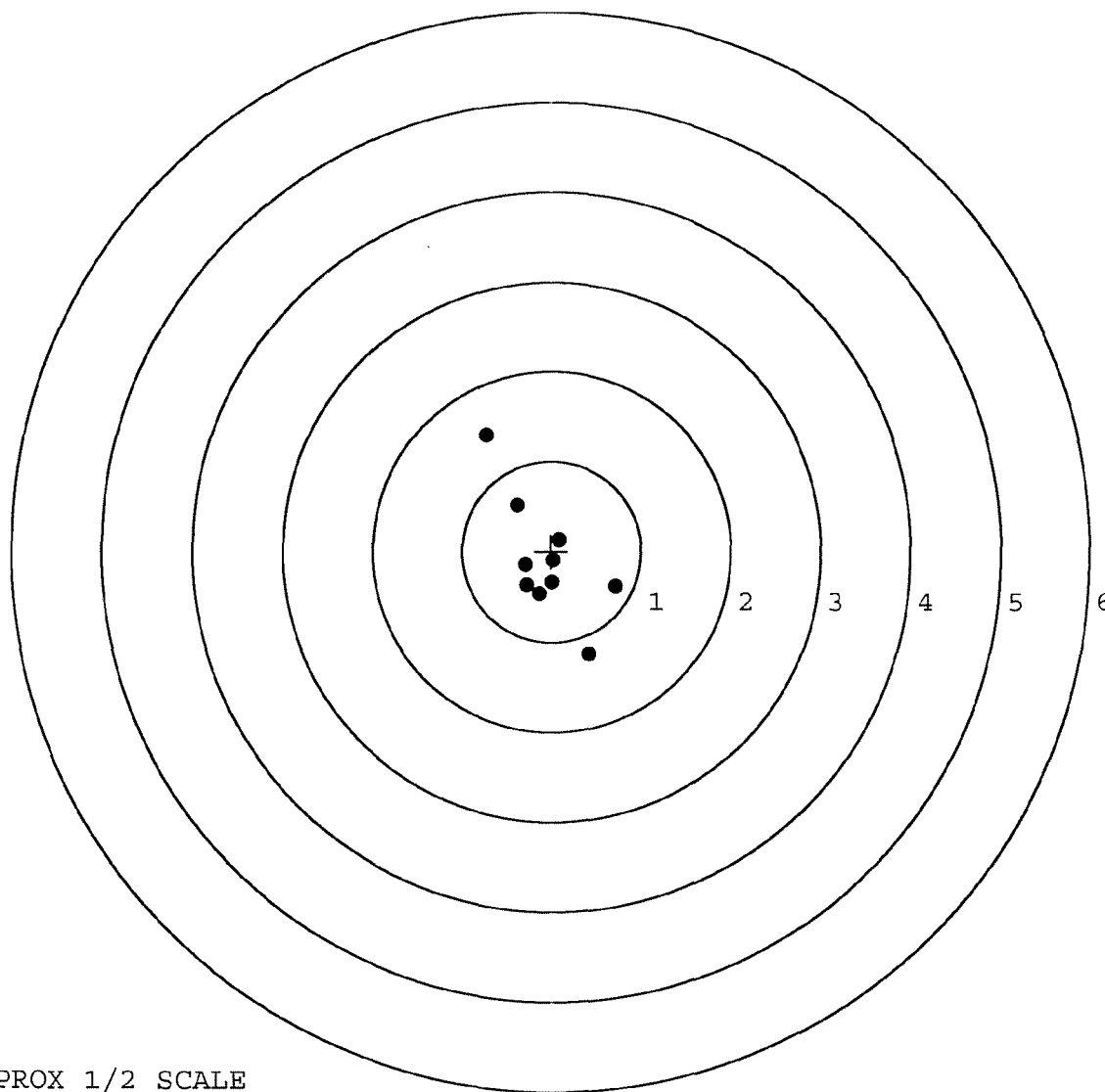
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.057
The Average Y Centroid of the Five Target Set:	-0.039
The Average Point of Impact of the Five Target Set:	0.069
The Average Mean Radius of the Five Target Set:	0.507
The Distance from POA to Centroid Target #1:	0.118
The Distance from Centroid Target #2 to Centroid Target #1:	0.153
The Distance from Centroid Target #3 to Centroid Target #1:	0.057
The Distance from Centroid Target #4 to Centroid Target #1:	0.102
The Distance from Centroid Target #5 to Centroid Target #1:	0.108

SERIAL NUMBER: G6848402. 0
TARGET NUMBER: 1
FILE DATE: 05/06/2009
FILE TIME: 14:51

POINT#	X	Y
1:	-0.732	1.293
2:	-0.382	0.510
3:	0.092	0.127
4:	0.717	-0.391
5:	0.422	-1.137
6:	0.021	-0.101
7:	-0.287	-0.152
8:	0.011	-0.341
9:	-0.138	-0.471
10:	-0.274	-0.378

X CENTROID: -0.055
Y CENTROID: -0.104
POA TO CENTROID: 0.118
HORZ SPREAD: 1.449
VERT SPREAD: 2.430
GROUP SPREAD: 2.690
MIN RADIUS: 0.076
MAX RADIUS: 1.552
MEAN RADIUS: 0.577
IN 1 IN DIAMETER: 6
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 9

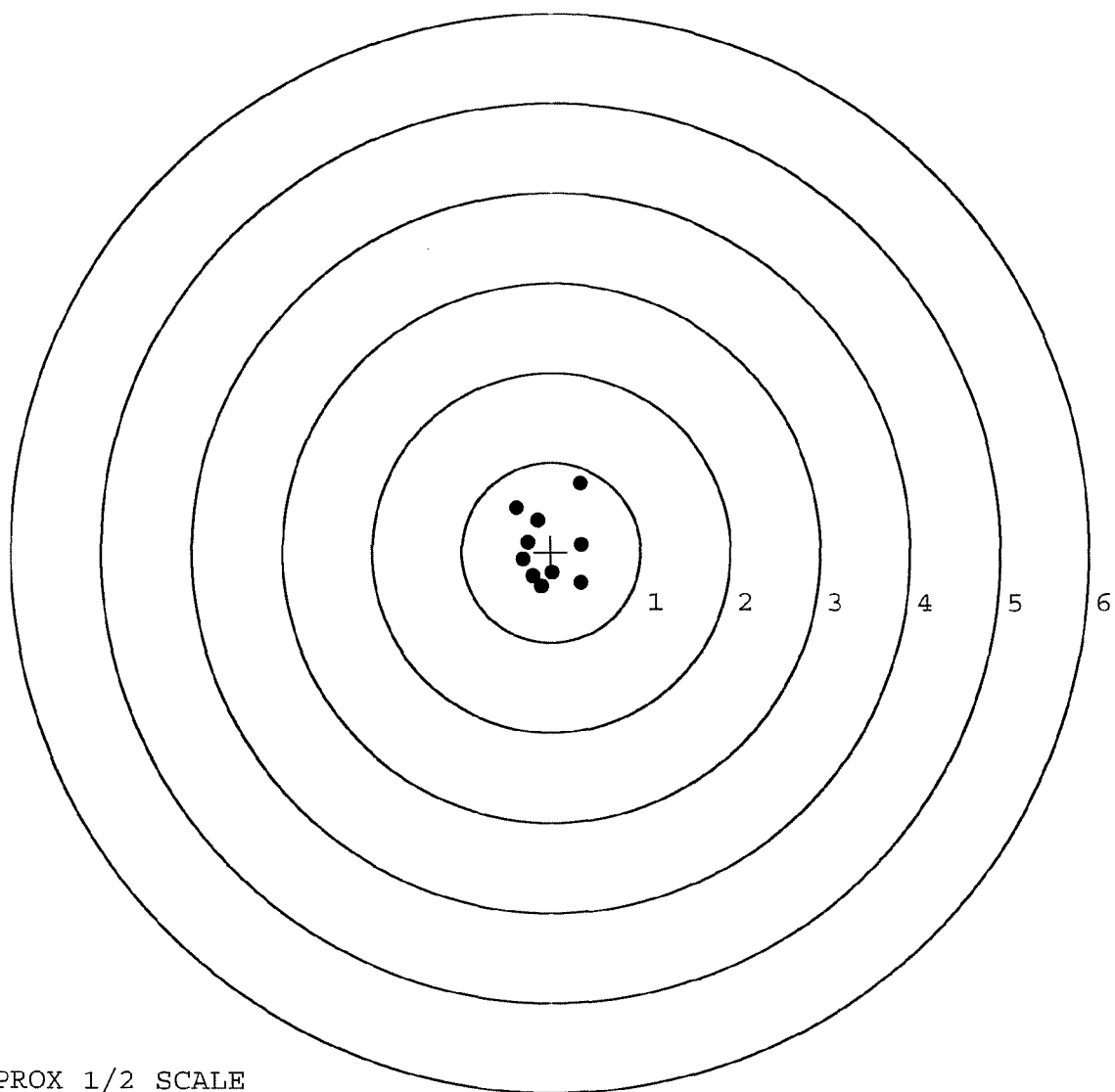


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6848402. __0
TARGET NUMBER: 2
FILE DATE: 05/06/2009
FILE TIME: 14:51

POINT#	X	Y
1:	0.328	0.764
2:	-0.147	0.349
3:	-0.387	0.488
4:	-0.265	0.113
5:	-0.313	-0.084
6:	-0.206	-0.271
7:	-0.107	-0.385
8:	0.338	-0.345
9:	0.020	-0.228
10:	0.340	0.082

X CENTROID: -0.040
Y CENTROID: 0.048
POA TO CENTROID: 0.063
HORZ SPREAD: 0.727
VERT SPREAD: 1.149
GROUP SPREAD: 1.229
MIN RADIUS: 0.234
MAX RADIUS: 0.805
MEAN RADIUS: 0.423
IN 1 IN DIAMETER: 7
IN 2 IN DIAMETER: 10
in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6848402. __0

TARGET NUMBER: 3

FILE DATE: 05/06/2009

FILE TIME: 14:51

POINT#	X	Y
1:	0.508	0.192
2:	0.338	0.150
3:	0.203	0.081
4:	0.072	0.135
5:	-0.302	0.008
6:	-0.475	-0.166
7:	-0.522	0.145
8:	0.216	-0.406
9:	0.361	-1.204
10:	-0.376	0.026

X CENTROID: 0.002

Y CENTROID: -0.104

POA TO CENTROID: 0.104

HORZ SPREAD: 1.030

VERT SPREAD: 1.396

GROUP SPREAD: 1.612

MIN RADIUS: 0.249

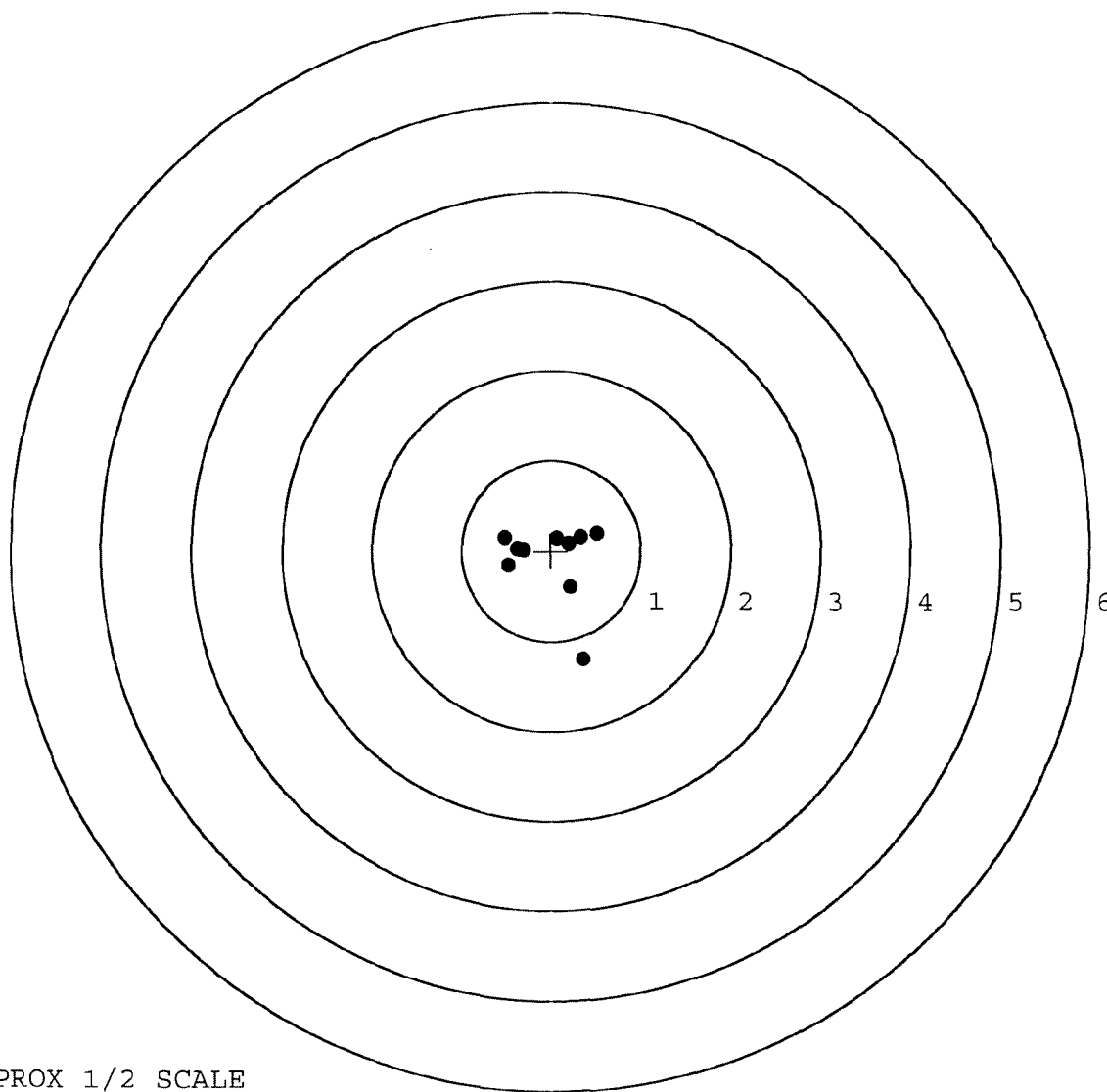
MAX RADIUS: 1.157

MEAN RADIUS: 0.484

IN 1 IN DIAMETER: 7

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6848402.___0

TARGET NUMBER: 4

FILE DATE: 05/06/2009

FILE TIME: 14:51

X CENTROID: -0.133

Y CENTROID: -0.039

POA TO CENTROID: 0.139

HORZ SPREAD: 1.296

VERT SPREAD: 0.995

GROUP SPREAD: 1.372

MIN RADIUS: 0.108

MAX RADIUS: 0.794

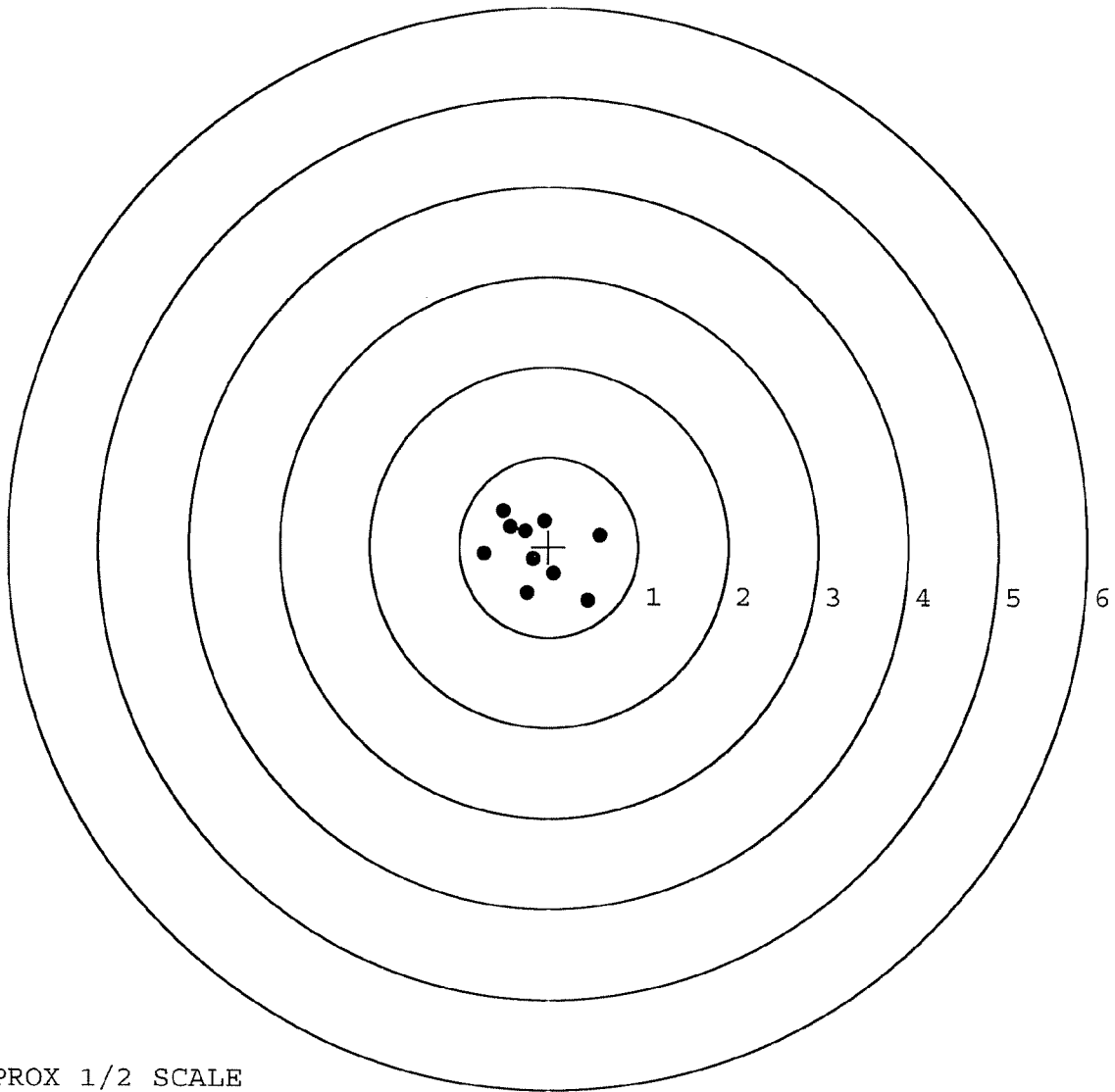
MEAN RADIUS: 0.458

IN 1 IN DIAMETER: 6

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.573	0.130
2:	0.435	-0.594
3:	-0.241	-0.507
4:	0.054	-0.296
5:	-0.179	-0.136
6:	-0.723	-0.074
7:	-0.047	0.288
8:	-0.263	0.179
9:	-0.432	0.222
10:	-0.509	0.401



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6848402.___0

TARGET NUMBER: 5

FILE DATE: 05/06/2009

FILE TIME: 14:51

POINT#	X	Y
1:	0.579	-0.347
2:	0.246	-0.647
3:	0.081	-0.822
4:	-0.323	-0.605
5:	-0.008	-0.039
6:	-0.217	0.104
7:	-0.298	0.295
8:	0.063	0.376
9:	-0.620	0.603
10:	-0.116	1.121

X CENTROID: -0.061

Y CENTROID: -0.004

POA TO CENTROID: 0.061

HORZ SPREAD: 1.199

VERT SPREAD: 1.943

GROUP SPREAD: 1.953

MIN RADIUS: 0.068

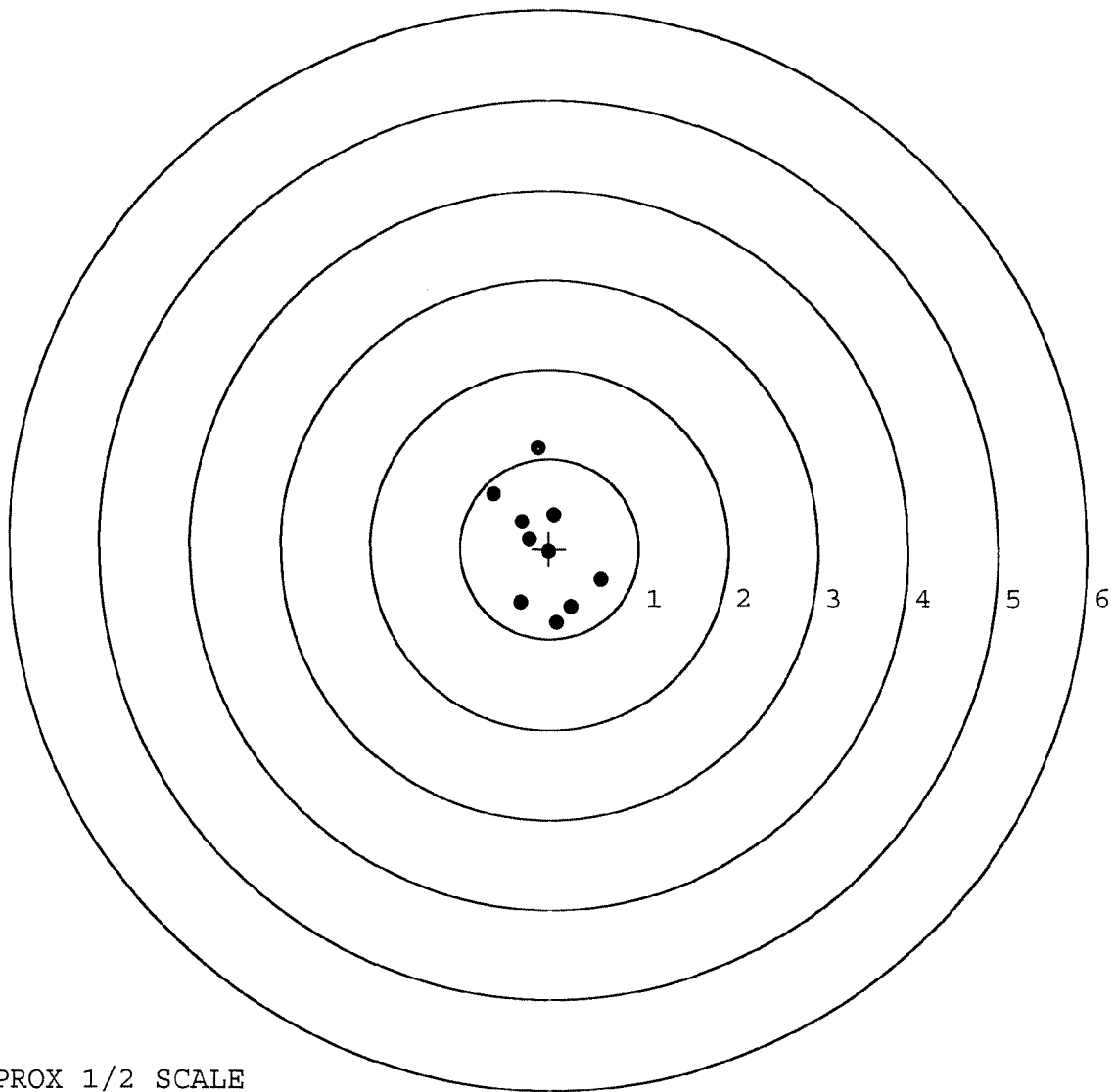
MAX RADIUS: 1.118

MEAN RADIUS: 0.591

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10



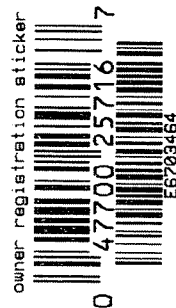
TARGET APPROX 1/2 SCALE

MODEL 700TH 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

E6703464



Remington®

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

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

SERIAL NO. J
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ORDER NO.
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Made in Ilion, NY Reg. U.S. Pat & tm. Off. Marca Registrada Marque Deposee.



5716 E6703464

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MODEL 700[™] M24

UPC



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MODEL 700[™] M24

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SERIAL NO.



GUN SERIAL # E 670 3464

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		8/2/01	CK
600	PROOF		11	11
607	CHECK HEADSPACE		11	11
610	DIS-ASSEMBLE GUN		11	11
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT			
615	ROLLMARK CALIBER			
617	DRILL AND TAP SIGHT HOLES		3/22/01	DA
618	POLISH BARREL			
620	APPLY COATINGS (BARREL ACTION)			
	(BOLT)			
625	FINAL ASSEMBLY		3/22/01	DA
	A) CLEAN INSIDE OF BOLT ASSEMBLY			
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		11	11
	C) INSPECT EJECTOR HOLE FOR CHAMFER		11	11
	D) OIL FIRING PIN ASSEMBLY		3/28/01	CK
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE		11	11

OP #	OPERATION NAME	READINGS	DATE	INITIAL
625	F) SAFETY ON FORCE	<u>7.0</u> <u>6.5</u> <u>7.0</u>	3/26	DBL
CONT.	G) SAFETY OFF FORCE	<u>4.0</u> <u>4.0</u> <u>4.0</u>	3/26	DBL
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT	<u>.022</u> <u>.021</u> <u>.021</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		3/26	AC
	A) MALFUNCTIONS		3/26	AC
	B) PIERCED PRIMERS		3/26	AC
645	INSPECT FOR LIVE AMMO		3/26	AC
655	FINAL INSPECTION A) HEADSPACE		3/30/01	RW
	B) TRIGGER PULL	<u>254</u> <u>266</u> <u>283</u> <u>283</u> <u>289</u>	3/26	DBL
	C) FUNCTION			
660	PACK		4/2/01	DBL

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. EG703464

DATE 2-2-01

TESTER RA

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.52	2.55	2	2.48	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.56	2.52		2.57	
PULL #3	2.47	2.51		2.51	
PULL #4	2.42	2.51		2.54	
PULL #5	2.53	2.51		2.54	
TOTAL	12.50	12.60		12.64	
AVG.	2.50	2.52		2.52	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.04	3.00		
PULL #2	2.94	2.98		
PULL #3	2.94	2.97		
PULL #4	2.95	2.93		
PULL #5	2.95	2.97		
TOTAL	14.82	14.85		
AVG.	2.96	2.97		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.17	4.11		4.07
PULL #2	4.12	4.18		4.08
PULL #3	4.19	4.10		4.06
PULL #4	4.14	4.11		4.01
PULL #5	4.24	4.17		4.12
TOTAL	20.86	20.67		20.34
AVG.	4.17	4.13		4.06

Remington Test Lab, Ilion, N.Y.

Centroidal distance calculations for Rifle # e6703464
27 Mar 2001

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0922
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .2248
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .242973

THE AMR FOR THIS RIFLE IS: 1.039

CENTROIDAL DISTANCES

0 TO	1	.387881
1 TO	2	.176822
1 TO	3	.322967
1 TO	4	.256844
1 TO	5	.275289

1
4 2 5
+ <----POA

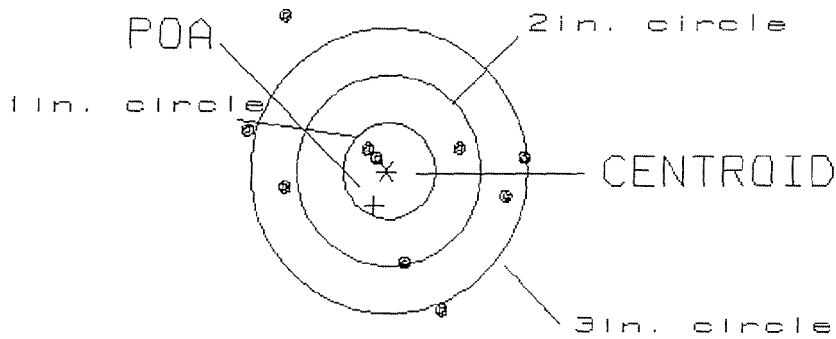
PATTERN #: ☐ 1 ☐

POA TO CENTROID: .388
 MIN RADIUS : .135
 MEAN RADIUS : 1.140
 MAX RADIUS : 2.016
 CENTROID X : .134
 CENTROID Y : .364

27 Mar 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/e6703464.1

CENTERFIRE PATTERN # 1



OF SHOTS= 10

IN CIRCLE

HS= 3.04
 VS= 3.14
 GS= 3.55

2
 4
 7

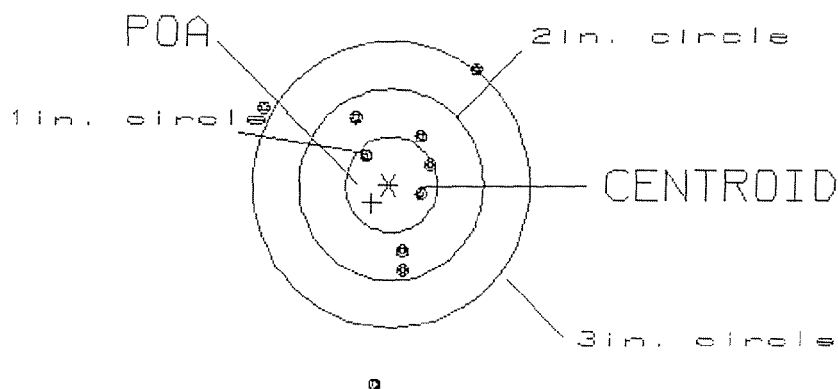
PATTERN #: 2

POA TO CENTROID: .263
 MIN RADIUS : .300
 MEAN RADIUS : .941
 MAX RADIUS : 2.080
 CENTROID X : .179
 CENTROID Y : .193

27 Mar 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/e6703464.1

CENTERFIRE PATTERN # 2



OF SHOTS= 10

IN CIRCLE

HS= 2.30

3

VS= 3.27

7

GS= 3.45

8

PATTERN #: 030

POA TO CENTROID: .200

MIN RADIUS : .269

MEAN RADIUS : 1.265

MAX RADIUS : 2.824

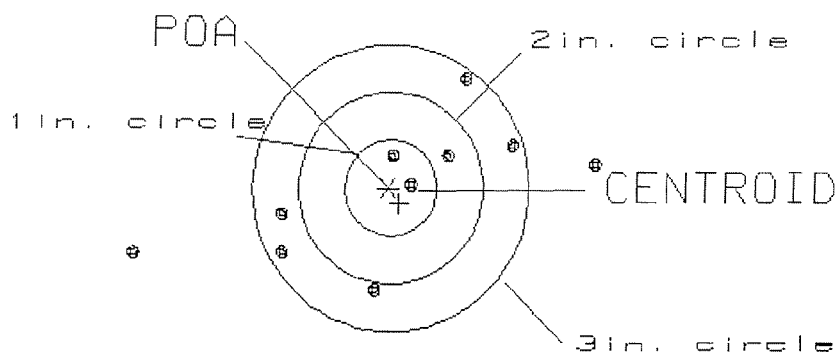
CENTROID X : -.118

CENTROID Y : .162

27 Mar 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/e6703464.1

CENTERFIRE PATTERN # 3



OF SHOTS= 10

IN CIRCLE

HS= 4.98

2

VS= 2.21

3

GS= 5.06

8

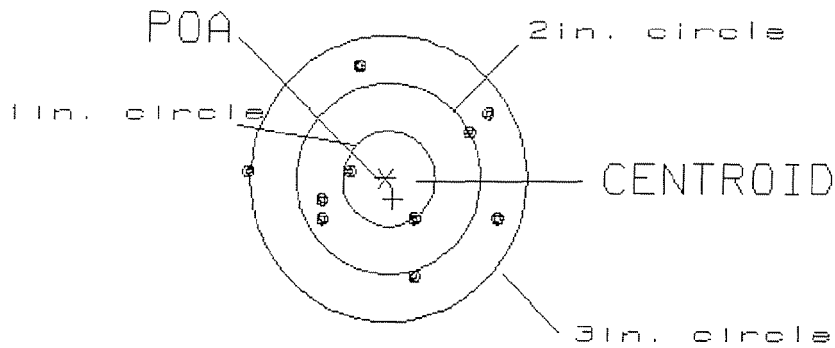
PATTERN #: ☐ 4 ☐

POA TO CENTROID: .232
 MIN RADIUS : .392
 MEAN RADIUS : .968
 MAX RADIUS : 1.488
 CENTROID X : -.078
 CENTROID Y : .219

27 Mar 2001

FILE:/Hqbasic/Accuracy/Patterning/Centerfire_Patt/e6703464.1

CENTERFIRE PATTERN # 4



OF SHOTS= 10

IN CIRCLE

HS= 2.64
 VS= 2.14
 GS= 2.68

1
 5
 10

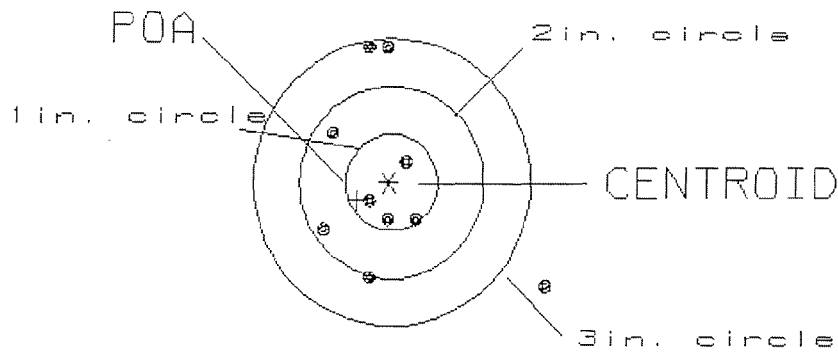
PATTERN #: 5

POA TO CENTROID: .391
 MIN RADIUS : .259
 MEAN RADIUS : .881
 MAX RADIUS : 1.931
 CENTROID X : .344
 CENTROID Y : .186

27 Mar 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/e6703464.1

CENTERFIRE PATTERN # 5



OF SHOTS= 10

IN CIRCLE

HS= 2.33
 VS= 2.50
 GS= 3.12

4
 7
 9