

G684 8432
Replaces
E6703535

Repair Inquiry

Repair Number: RE00161973

Serial: E6703535 Model M24 SWS Center Fire
Caliber: 7.62 NATO

Repairman:

Verify Repair

Status:

Closed 2/13/2009 8:06:30 AM

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

Fair

Condition

Notes:

CSR

Notes:

Accessories Received

Code	Desc	Qty
A007	With Stud	2
A010	Hard Case	1
A017	Scope Base	1
A057	Fit SGT BASE	1

Repair Search

Refresh

Close

6 Evaluated

nagletj

2/13/2009

1:31 PM

CAPS

NUM

INS

SCPL

start

12 Microsoft...

4 Microsoft...

3 Internet E...

Arms Services...

Part Search b...

3 SAP Logon...

1:31 PM

Serial
Number:~~E6703535~~

Model: M24 SWS



RE00161973

INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL #

G 6848432 FOR E 6703535

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	(D)
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		4-8-09	RT
520	GOFF BLAST BBL / REC		4-8	BT
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>4°</u>	<u>4°</u>	<u>4°</u>	5-11-09	LJN		
CONT.									
	G) SAFETY OFF FORCE	2 LBS MIN	<u>5°</u>	<u>5°</u>	<u>5°</u>	5-11-09	LJN		
	H) TRIGGER PULL TEST AND RETAINABILITY								
	I) FIRING PIN INDENT	.020 MIN	<u>.023</u>	<u>.023</u>	<u>.023</u>	5-11-09	LJN		
	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		PASS	FAIL					
			PASS	FAIL		5-6-09	WZ		
	MALFUNCTION		CORRECTION						
	MALFUNCTION		CORRECTION	1/1					
	MALFUNCTION		CORRECTION						
	MALFUNCTION		CORRECTION						
660	INSPECT FOR LIVE AMMO					5-6-09	TJR		
670	FINAL INSPECTION A) HEADSPACE					5-11-09	LJN		
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.81</u>	<u>2.91</u>	<u>2.84</u>	<u>2.81</u>	<u>2.90</u>	5-7-09	RTZ
	C) FUNCTION					5-11-09	LJN		
690	PACK					5/15/09	Fm		

F004 REV 5/2006

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6848432.___0

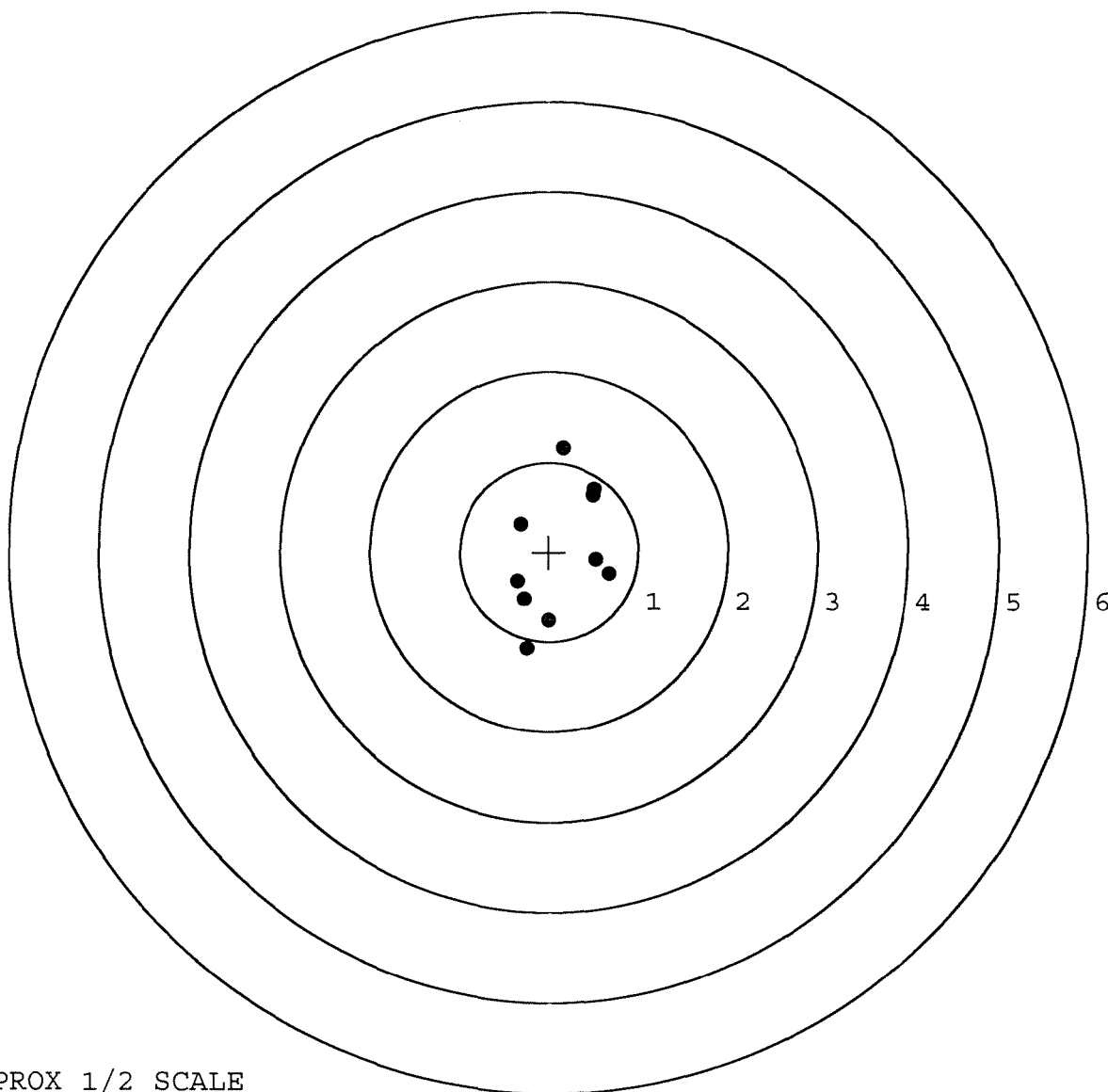
FILE DATE AND TIME: 05/07/2009 05:54

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.094
The Average Y Centroid of the Five Target Set:	-0.073
The Average Point of Impact of the Five Target Set:	0.119
The Average Mean Radius of the Five Target Set:	0.662
The Distance from POA to Centroid Target #1:	0.120
The Distance from Centroid Target #2 to Centroid Target #1:	0.279
The Distance from Centroid Target #3 to Centroid Target #1:	0.323
The Distance from Centroid Target #4 to Centroid Target #1:	0.214
The Distance from Centroid Target #5 to Centroid Target #1:	0.286

SERIAL NUMBER: G6848432. __0	POINT#	X	Y
TARGET NUMBER: 1	1:	-0.316	0.307
FILE DATE: 05/07/2009	2:	0.166	1.155
FILE TIME: 05:54	3:	0.508	0.702
	4:	0.675	-0.244
	5:	0.527	-0.084
	6:	-0.353	-0.328
	7:	-0.276	-0.527
	8:	-0.007	-0.771
	9:	-0.247	-1.085
	10:	0.496	0.629

X CENTROID:	0.117
Y CENTROID:	-0.025
POA TO CENTROID:	0.120
HORZ SPREAD:	1.028
VERT SPREAD:	2.240
GROUP SPREAD:	2.278
MIN RADIUS:	0.414
MAX RADIUS:	1.181
MEAN RADIUS:	0.740
# IN 1 IN DIAMETER:	1
# IN 2 IN DIAMETER:	8
# in 3 IN DIAMETER:	10

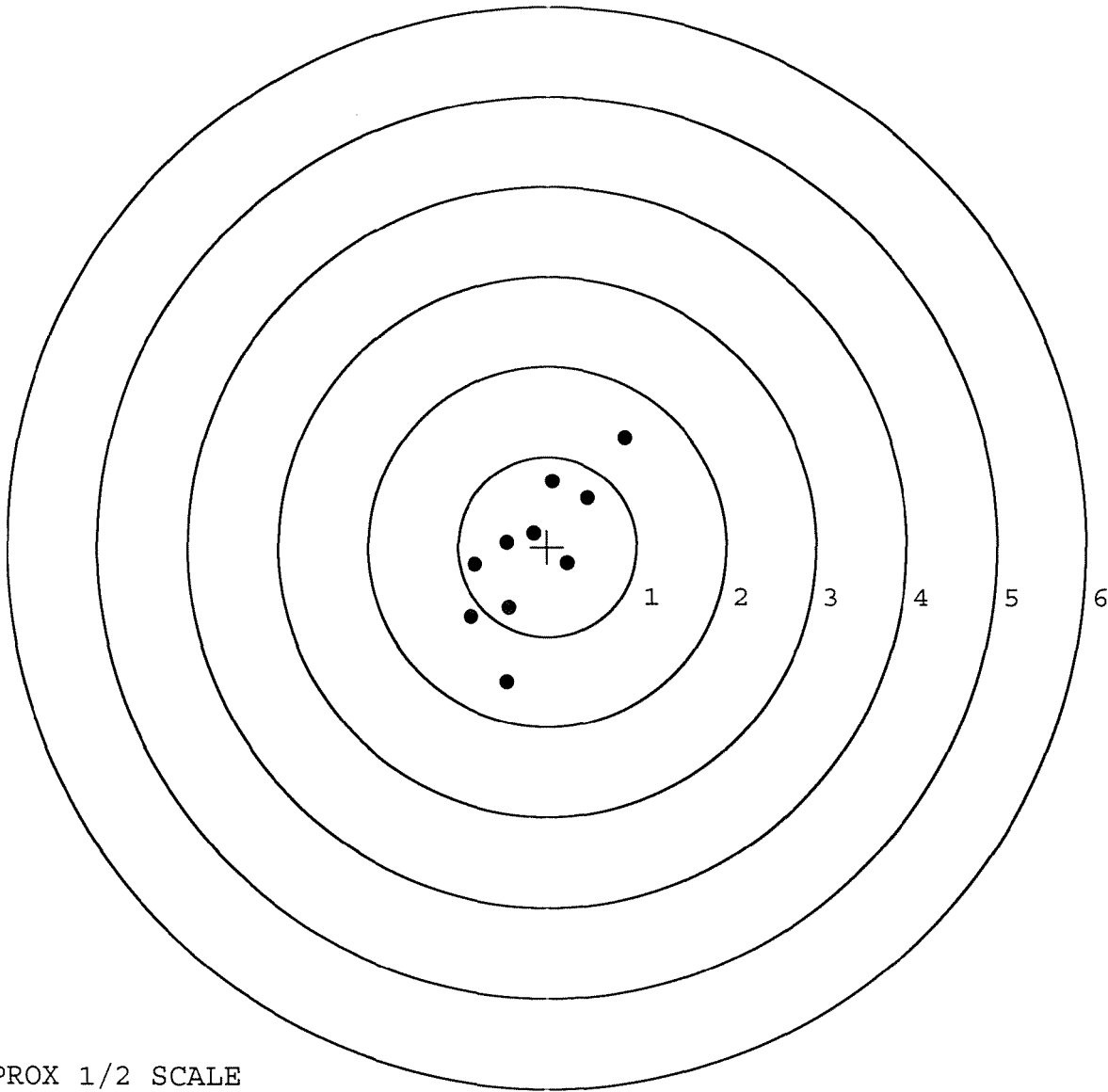


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6848432. __0
TARGET NUMBER: 2
FILE DATE: 05/07/2009
FILE TIME: 05:54

X CENTROID: -0.158
Y CENTROID: -0.070
POA TO CENTROID: 0.172
HORZ SPREAD: 1.720
VERT SPREAD: 2.719
GROUP SPREAD: 3.019
MIN RADIUS: 0.222
MAX RADIUS: 1.634
MEAN RADIUS: 0.808
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 9

POINT#	X	Y
1:	0.861	1.208
2:	0.451	0.542
3:	0.054	0.723
4:	-0.158	0.152
5:	-0.458	0.053
6:	0.225	-0.186
7:	-0.428	-0.686
8:	-0.813	-0.204
9:	-0.859	-0.792
10:	-0.451	-1.511

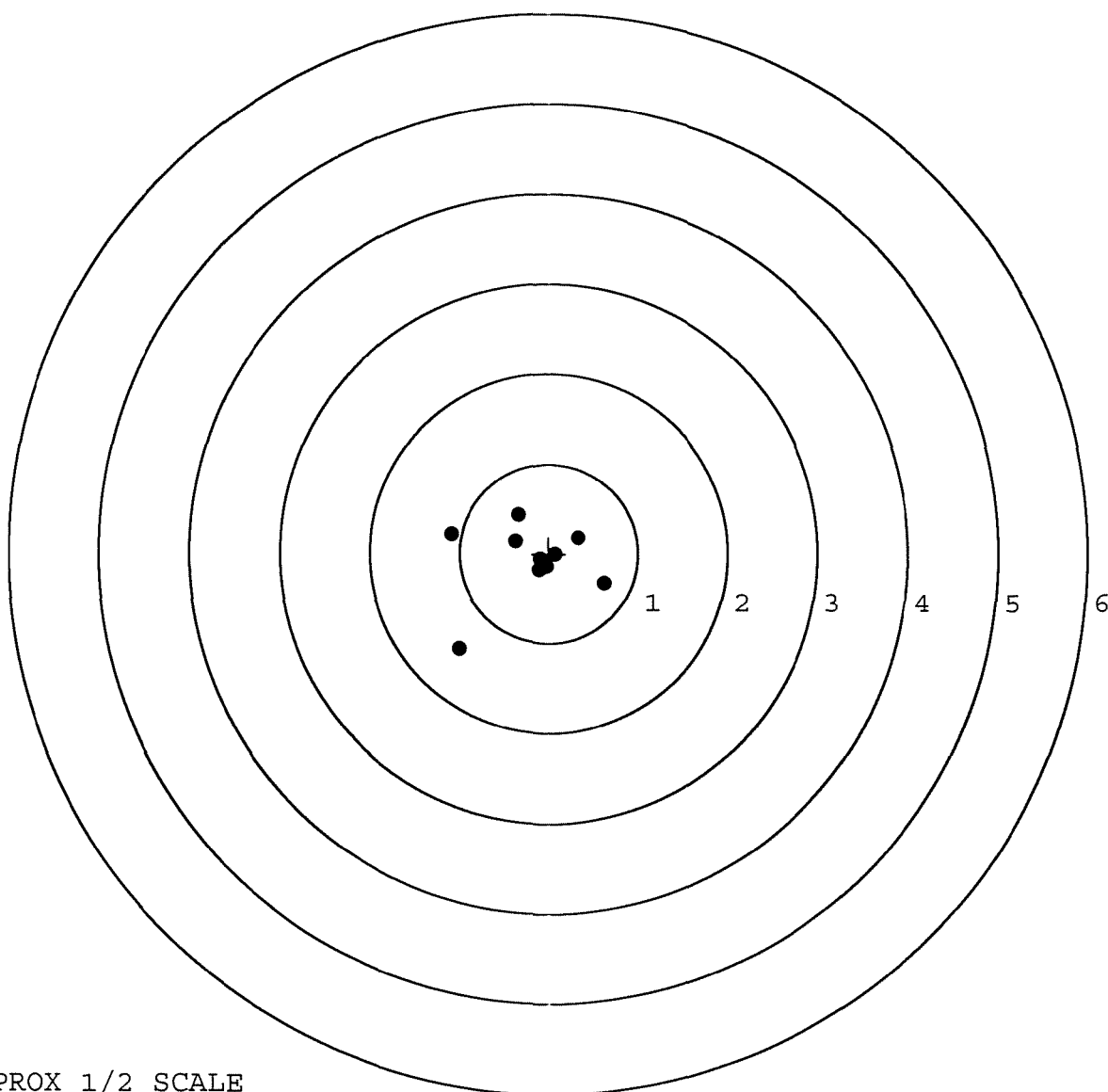


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6848432. 0
TARGET NUMBER: 3
FILE DATE: 05/07/2009
FILE TIME: 05:54

X CENTROID: -0.201
Y CENTROID: -0.084
POA TO CENTROID: 0.218
HORZ SPREAD: 1.711
VERT SPREAD: 1.496
GROUP SPREAD: 1.821
MIN RADIUS: 0.107
MAX RADIUS: 1.268
MEAN RADIUS: 0.517
IN 1 IN DIAMETER: 5
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.624	-0.337
2:	0.329	0.176
3:	-0.370	0.138
4:	-0.334	0.429
5:	-1.087	0.220
6:	-1.002	-1.067
7:	-0.113	-0.183
8:	0.069	-0.013
9:	-0.095	-0.065
10:	-0.027	-0.142

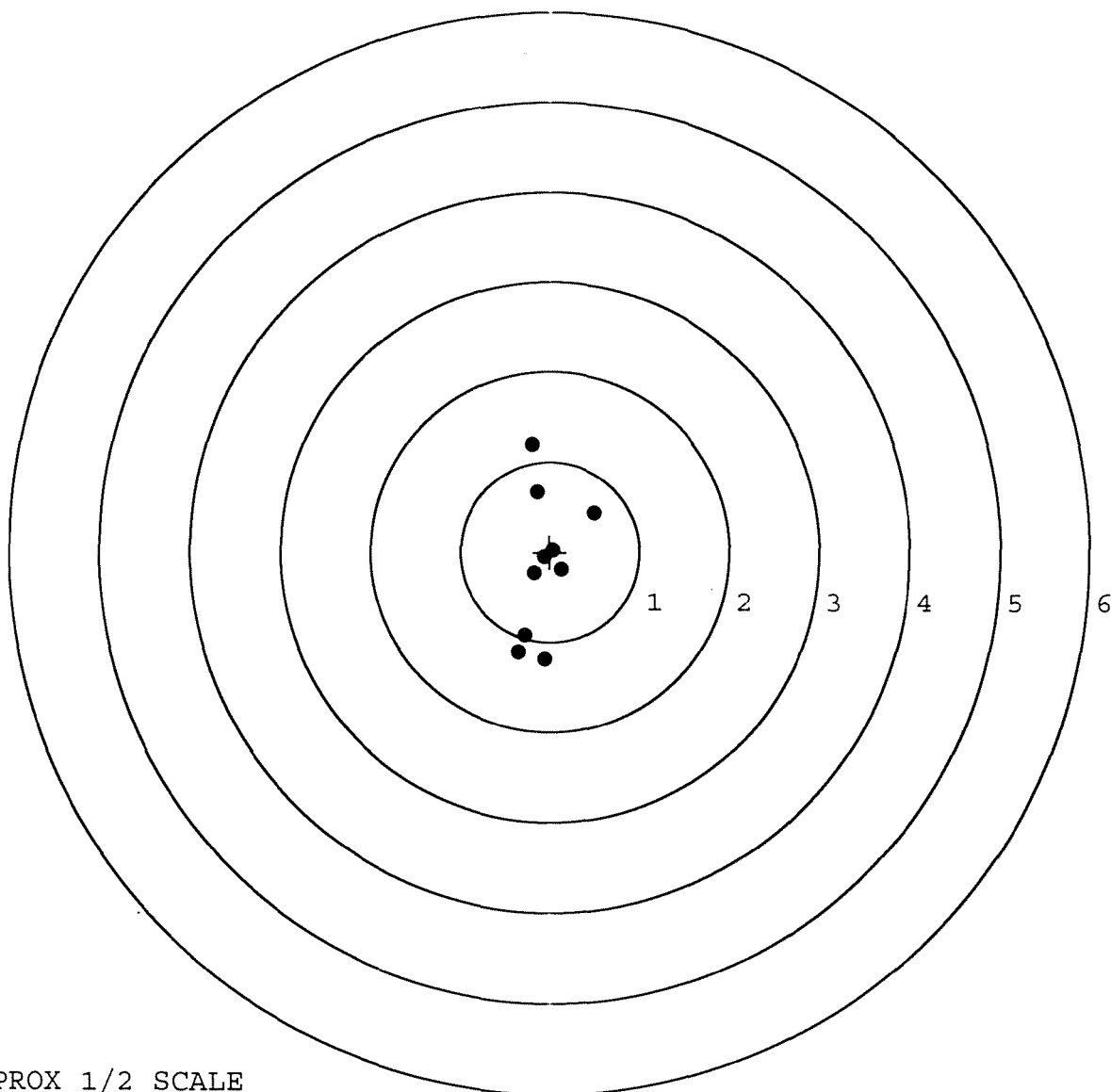


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6848432. 0
TARGET NUMBER: 4
FILE DATE: 05/07/2009
FILE TIME: 05:54

X CENTROID: -0.061
Y CENTROID: -0.142
POA TO CENTROID: 0.155
HORZ SPREAD: 0.847
VERT SPREAD: 2.387
GROUP SPREAD: 2.391
MIN RADIUS: 0.089
MAX RADIUS: 1.338
MEAN RADIUS: 0.647
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 10

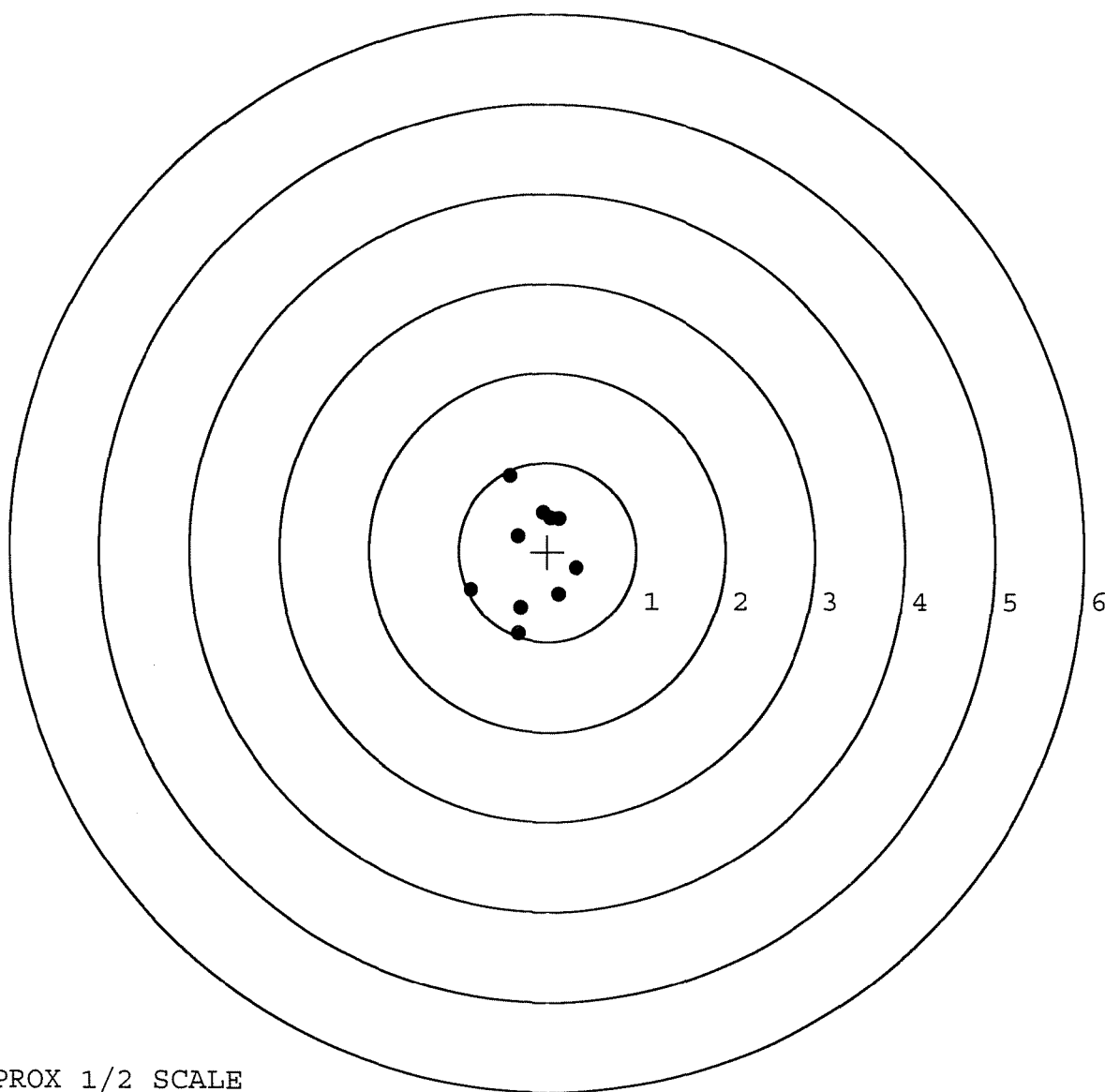
POINT#	X	Y
1:	-0.200	1.188
2:	-0.142	0.661
3:	0.497	0.434
4:	-0.059	-1.199
5:	-0.350	-1.116
6:	-0.283	-0.929
7:	-0.180	-0.235
8:	0.039	0.024
9:	0.131	-0.199
10:	-0.064	-0.054



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6848432. __0
TARGET NUMBER: 5
FILE DATE: 05/07/2009
FILE TIME: 05:54

	POINT#	X	Y
	1:	-0.414	0.850
	2:	0.128	0.370
	3:	-0.053	0.434
	4:	-0.332	0.171
X CENTROID:	5:	-0.861	-0.429
Y CENTROID:	6:	-0.322	-0.919
POA TO CENTROID:	7:	-0.303	-0.628
HORZ SPREAD:	8:	0.121	-0.474
VERT SPREAD:	9:	0.326	-0.185
GROUP SPREAD:	10:	0.034	0.377
MIN RADIUS:		0.270	
MAX RADIUS:		0.927	
MEAN RADIUS:		0.598	
# IN 1 IN DIAMETER:		3	
# IN 2 IN DIAMETER:		10	
# in 3 IN DIAMETER:		10	

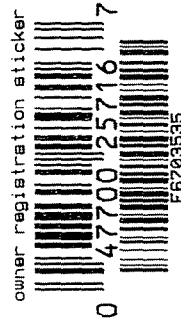


TARGET APPROX 1/2 SCALE

MODEL 700™ M24
501 ACTION CENTERFIRE RIFLE
7.62 NATO

CONTENT ENVELOPE ASSEMBLY:
INSTRUCTION BOOK
PRODUCT OWNER'S CARD
SAFETY BOOKLET

46 FORM 1444

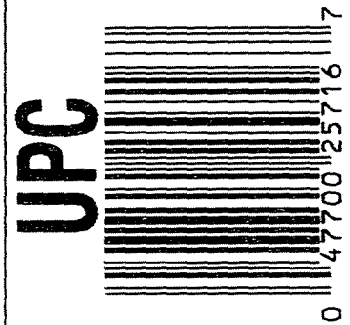


ORDER NO. **25716**

BARREL LENGTH 24"

CAPACITY 6

E6703535



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
E6703535

46

ORDER NO.
25716

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



5716 E6703535

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ORDER 25716

MODEL 700TH M24

UPC



ORDER 25716

MODEL 700TH M24

UPC



SERIAL NO.



CONTRACT # DAAE20-01-C-0007

GUN SERIAL # E670 3535

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		3/27/09	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		3/28/09	DA
618	POLISH BARREL			
620	APPLY COATINGS (BARREL ACTION)			
	(BOLT)			
625	FINAL ASSEMBLY		3/28/09	DA
	A) CLEAN INSIDE OF BOLT ASSEMBLY			
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD			
	C) INSPECT EJECTOR HOLE FOR CHAMFER			
	D) OIL FIRING PIN ASSEMBLY		4/4/09	CK
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE		x	11

OP #	OPERATION NAME	READINGS			DATE	INITIAL		
625	F) SAFETY ON FORCE	<u>4.0</u>	<u>4.5</u>	<u>4.5</u>	3/29/01	DA		
CONT.								
	G) SAFETY OFF FORCE	<u>2.5</u>	<u>3.0</u>	<u>3.0</u>	3/29/01	DA		
	H) TRIGGER PULL TEST AND RETAINABILITY							
	I) FIRING PIN INDENT	<u>.023</u>	<u>.022</u>	<u>.022</u>	3/29/01	DA		
	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				3/27	K		
	A) MALFUNCTIONS	OK + C Rough chamber			3/27	A		
	B) PIERCED PRIMERS				3/27	K		
645	INSPECT FOR LIVE AMMO				3/27	K		
655	FINAL INSPECTION A) HEADSPACE				3/30/01 3	PW [Signature]		
	B) TRIGGER PULL	<u>2.34</u>	<u>2.45</u>	<u>2.45</u>	<u>2.34</u>	<u>2.26</u>	3/30/01	DA
	C) FUNCTION							
660	PACK							

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

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

SERIAL NO. E6703535

DATE 3/26/01

TESTER DA

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.50	2.42		2.31	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.56	2.46		2.26	
PULL #3	2.54	2.24		2.13	
PULL #4	2.50	2.26		2.25	
PULL #5	2.51	2.32		2.23	
TOTAL	12.61	11.70		11.18	
AVG.	2.52	2.34		2.23	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.09	3.11		
PULL #2	3.15	3.03		
PULL #3	3.01	2.90		
PULL #4	3.11	3.01		
PULL #5	3.00	3.01		
TOTAL	15.36	15.06		
AVG.	3.07	3.01		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.14	4.09		4.27
PULL #2	4.06	4.04		4.23
PULL #3	4.00	4.02		4.29
PULL #4	4.00	4.11		4.20
PULL #5	4.01	4.00		4.28
TOTAL	20.18	20.26		21.27
AVG.	4.03	4.05		4.25

Remington Test Lab, Ilion, N.Y.

Centroidal distance calculations for Rifle # e6703535
28 Mar 2001

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0508
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.002
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0508394

THE AMR FOR THIS RIFLE IS: 1.067

CENTROIDAL DISTANCES

0	TO	1	.169027
1	TO	2	.0752861
1	TO	3	.373803
1	TO	4	.152003
1	TO	5	.229059

$\frac{21}{4} + 5_3$ <----POA

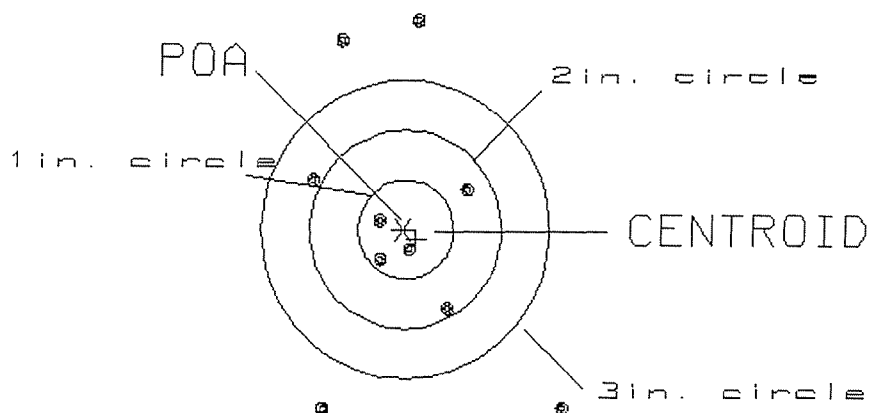
PATTERN #: ☐ 1 ☐

POA TO CENTROID: .169
 MIN RADIUS : .230
 MEAN RADIUS : 1.209
 MAX RADIUS : 2.493
 CENTROID X : -.137
 CENTROID Y : .099

28 Mar 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/e6703535

CENTERFIRE PATTERN # 1



OF SHOTS= 10

IN CIRCLE

HS= 2.64
 VS= 3.90
 GS= 4.36

3
 5
 6

PATTERN #: ☐ 2 ☐

POA TO CENTROID: .223

MIN RADIUS : .808

MEAN RADIUS : 1.183

MAX RADIUS : 1.794

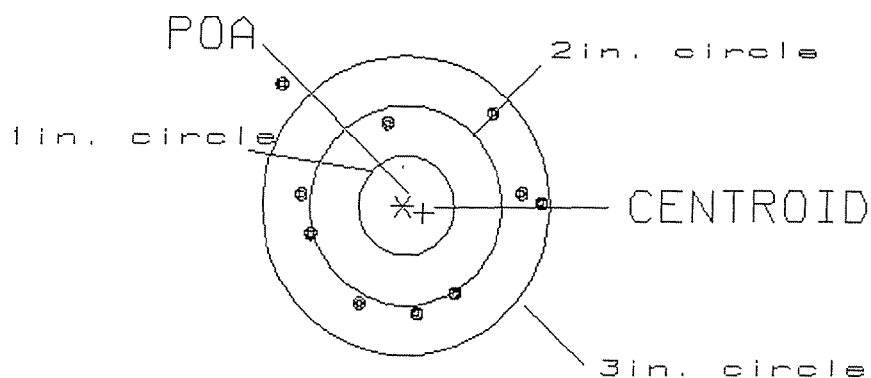
CENTROID X : -.209

CENTROID Y : .077

28 Mar 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/e6703535

CENTERFIRE PATTERN # 2



OF SHOTS= 10

IN CIRCLE

HS= 2.76

0

VS= 2.33

2

GS= 3.02

9

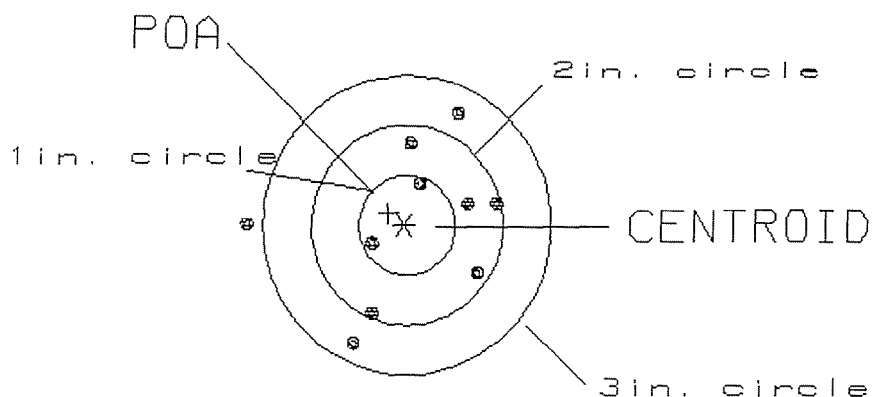
PATTERN #: ☐ 3 ☐

POA TO CENTROID: .204
 MIN RADIUS : .432
 MEAN RADIUS : .930
 MAX RADIUS : 1.625
 CENTROID X : .163
 CENTROID Y : -.124

28 Mar 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/e6703535

CENTERFIRE PATTERN # 3



OF SHOTS= 10

IN CIRCLE

HS= 2.52

2

VS= 2.24

7

GS= 2.53

9

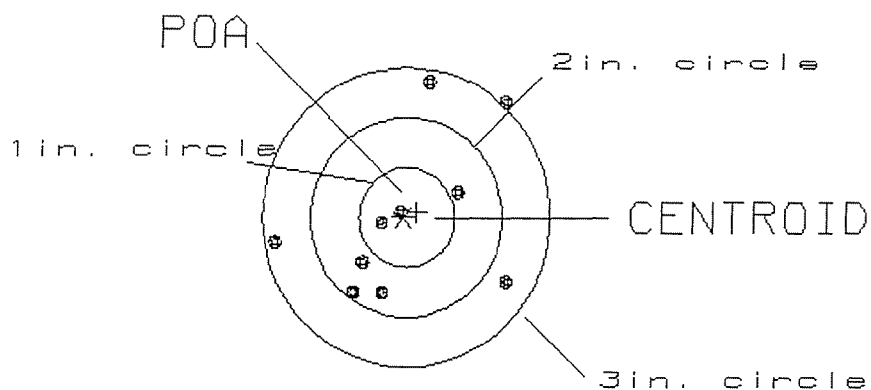
PATTERN #: 4

POA TO CENTROID: .146
 MIN RADIUS : .046
 MEAN RADIUS : .875
 MAX RADIUS : 1.572
 CENTROID X : -.136
 CENTROID Y : -.053

28 Mar 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/e6703535

CENTERFIRE PATTERN # 4



OF SHOTS= 10

IN CIRCLE

HS= 2.47

2

VS= 2.12

6

GS= 2.81

9

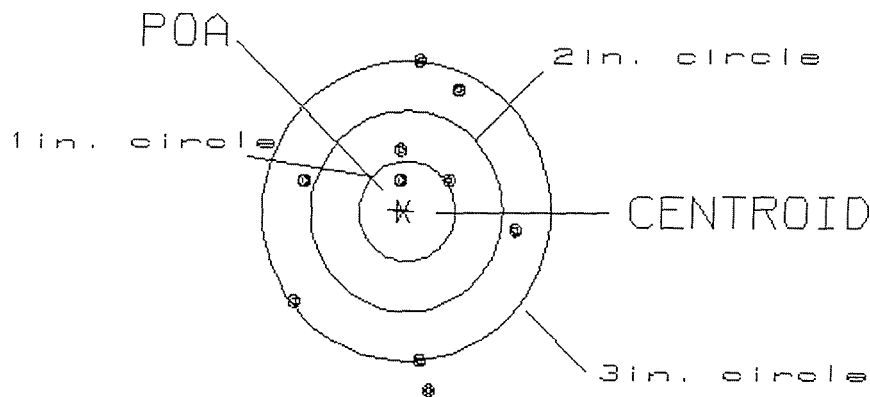
PATTERN #: 5

POA TO CENTROID: .066
 MIN RADIUS : .362
 MEAN RADIUS : 1.137
 MAX RADIUS : 1.756
 CENTROID X : .065
 CENTROID Y : -.009

28 Mar 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/e6703535

CENTERFIRE PATTERN # 5



OF SHOTS= 10

IN CIRCLE

HS= 2.25
 VS= 3.30
 GS= 3.30

1
 3
 7