

C6611381

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

M2400075913

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: **RE00093003** Serial: C6611331 Model: M24 SWS Center Fire Caliber: 7.62 NATO Produced: 03/16/1991 Repairman: Status: Closed 2/11/2005 7:32:05 AM

Verify Repair

Address Information

Customer: ☒ Received From Return To: ☐ Received From

Name: DEF DIST DEPOT ANNISTON DEF DIST DEPOT ANNISTON

Address 1: Address 2: PO Box PO Box

City: ANNISTON ANNISTON

State: AL AL Zip Code: 362014199 362014199 Country: US US

FFL: ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐

Contact / Condition Problems Estimate History / Status Shipping / Billing

Contact Information: Phone: Fax: Email: Comments:

Received Condition: Condition: Notes: CSR Notes:

Accessories Received:

Code	Desc	Qty
A007	With Stud	3
A010	Hard Case	1
A017	Scope Base	1
A026	Scope	1
A057	Frt and Rear Sgt Base	1

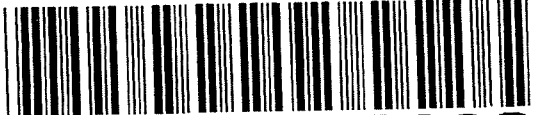
Repair Search Refresh Close

1000000 2/11/2005 10:13AM CAPS NUM INS SCPL

start 5 2 3 Arms Service

Serial Number: **C6611381**

Model: **M24 SWS**



RE00093003

M-24 INSPECTION CHECKLIST
CONTRACT #: DAAE-20-02-D-0127

R & E NUMBER	93003		
SERIAL NUMBER	C-661-1381		
LOG-IN DATE			
INSPECT AND VERIFY:			
OPERATION #	OPERATION NAME	DATE	INITIAL
550	DIS-ASSEMBLE GUN		
560 A	RE-BARREL		
B	DRILL AND TAP		
575	ASSEMBLE		
600	PROOF		
605	CHECK HEADSPACE		
610	DIS-ASSEMBLE GUN		
612	MAGNAFLUX		
615	ROLLMARK CALIBER		
618	ROTO-BLAST		
620	APPLY COATINGS		
625 A	FINAL ASSEMBLY		
B	TRIGGER PULL TEST		
C	SAFETY "ON" FORCE		
D	SAFETY "OFF" FORCE		
E	FIRING PIN INDENT		
640	TARGET	5-12-05	DPA
655	FINAL INSPECT		
660	PACK		
		SHIP DATE	
QAR INSPECTION DATE			




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

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

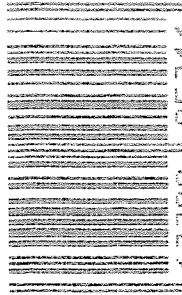
MODEL 700™ H24

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

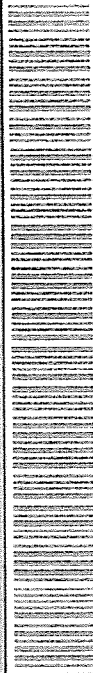
SERIAL NO.
C6611381

ORDER NO.
5716

LPC



0 47700 25716 2



5716 C6611381

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6611381

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	1 25	91	RW
600	Proof		91	RW
607	Check Headspace	1 25	91	RW
610	Dis-assemble Gun	1 25	91	RW
612	Magnaflux Barrel Action	1 25	91	KR
	Magnaflux Bolt	1 25	91	KR
615	Rollmark Caliber	1 25	91	GL
617	Drill and Tap Sight Holes	1 30	91	FB
618	Polish Barrel RBB	1 30	91	WB
620	Apply Coatings (Barrel Action)		2-10-91	TJH
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		2/11/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		2/11/91	RW
	C) Inspect Ejector Hole for Chamfer		2/11/91	RW
	D) Oil Firing Pin Ass'y		2/11/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		2/14/91	GL

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4 1/2	4 1/2	4 1/2			2/19/91	WB
	G) Safety Off Force	2 1/4	2 1/4	2 1/4			2/19/91	WB
	H) Trigger Pull Test & Retainability						2/19/91	JLL
	I) Firing Pin Indent	.0235	.023	.023			2/19/91	WB
	J) Assemble Stock						2/19/91	RW
	K) Assemble Swivel Studs						2-22-91	A
	L) Attach Front and Rear Sight Assemblies						2/19/91	RW
	M) Iron Sight Alignment						2/19/91	RW
	N) Detach Front & Rear Sights & place in numbered container						2/19/91	RW
	O) Attach Scope to Rifle						2/19/91	RW
	P) Detach & Attach Scope 20 Times						2/19/91	RW
640	Gallery Target & Test						2-20-91	DH
	A) Time						2-20-91	DH
	B) Malfunctions						2-20-91	DH
	C) Pierced Primers						2-20-91	DH
	D) Optical Clarity of Scope						2-20-91	DH
645	Inspect for Live Ammo						2-20-91	DH
655	Final Inspection						2-22-91	A
	A) Headspace							
	B) Trigger Pull	2.31	2.37	2.27	2.39	2.35	2/21/91	JLL
	C) Function						2-22-91	R
660	Pack						3-18-91	N

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN -
INITIAL & CYCLE TESTS
2.50# ± .50#
3.00# ± .75#
4.00# ± 1.00#

SERIAL NO. C6611381
DATE 2/19/91
TESTER JF

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.44	2.45	2.40	2.31	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.55	2.45	2.43	2.37	
PULL #3	2.49	2.40	2.40	2.27	
PULL #4	2.42	2.42	2.48	2.39	
PULL #5	2.41	2.49	2.41	2.35	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.25	3.40		
PULL #2	3.23	3.49		
PULL #3	3.16	3.43		
PULL #4	3.28	3.42		
PULL #5	3.26	3.42		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.19	4.16		4.29
PULL #2	4.34	4.23		4.29
PULL #3	4.31	4.27		4.30
PULL #4	4.29	4.36		4.22
PULL #5	4.29	4.25		4.24
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611381
30 Feb 1991

CENTROIDAL DISTANCES

0 TO	1	.0511957
1 TO	2	.0801561
1 TO	3	.164402
1 TO	4	.178393
1 TO	5	.035

←----POB

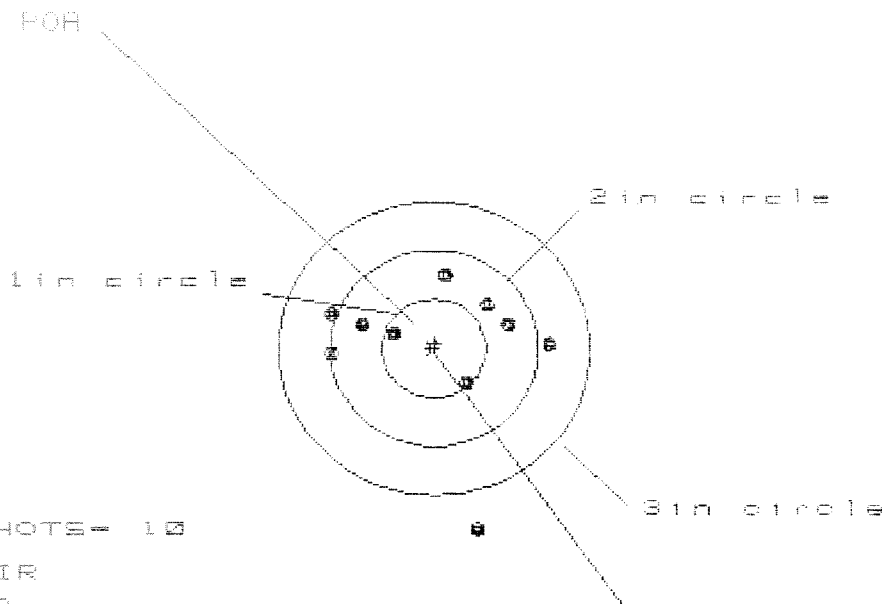
POB X-COORDINATE FOR THIS RIFLE IS: .0198
POB Y-COORDINATE FOR THIS RIFLE IS: -.0272
POB AVERAGE POI RADIUS FOR THIS RIFLE IS: .0336434
POB THIS RIFLE IS: .8346

28 Feb 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611381

CENTERFIRE PATTERNS # 1

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1in = 2

2in = 7

3in = 8

HS = 2.131

VS = 2.549

CS = 2.581

CENTROID #

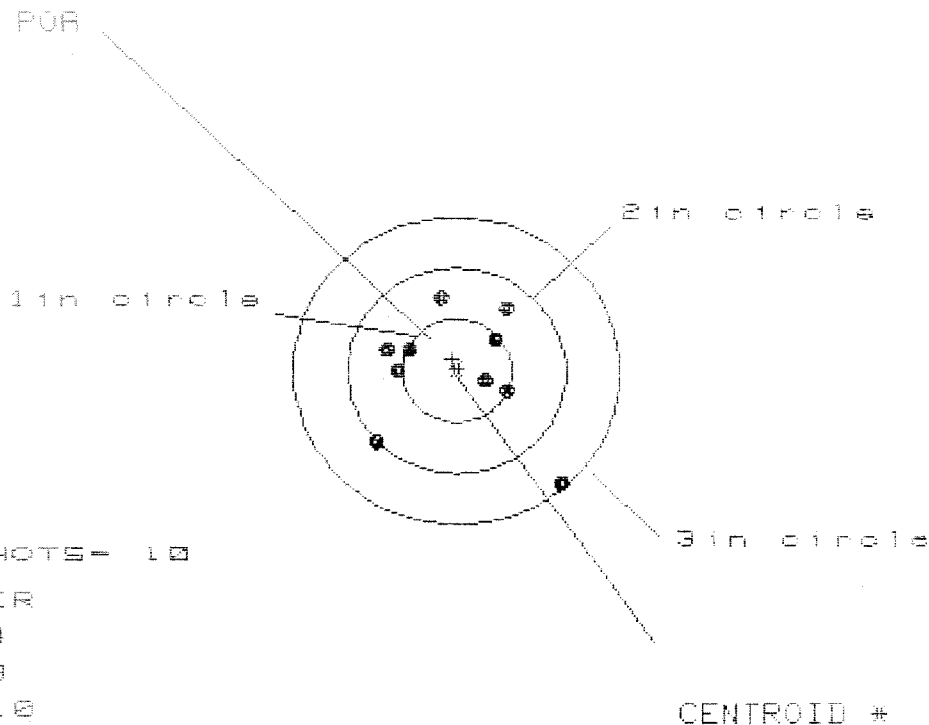
CENTER #	1	2	3
# OF SHOTS	10	9	8
EXTREMUM X	1.135	1.184	.908
MINIMUM X	-.996	-.947	-.799
MAXIMUM X	.727	.524	.500
MINIMUM Y	-1.822	-.567	-.591
CENTROID X	-.011	-.060	-.208
CENTROID Y	-.050	.153	.177
FOR TO CENTROID IN.	.051	.164	.273
MIN RADIUS	.450	.388	.244
MAX RADIUS	.889	.747	.670
AVG RADIUS	1.876	1.200	.908
HORIZONTAL SPREAD	2.131	2.131	1.787
VERTICAL SPREAD	2.549	1.091	1.091

EXTREME SPREAD	2.581	2.134	1.727
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	9		

20 Feb 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611361

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 4

2in = 9

3in = 10

HS= 1.686

VS= 1.791

GS= 2.091

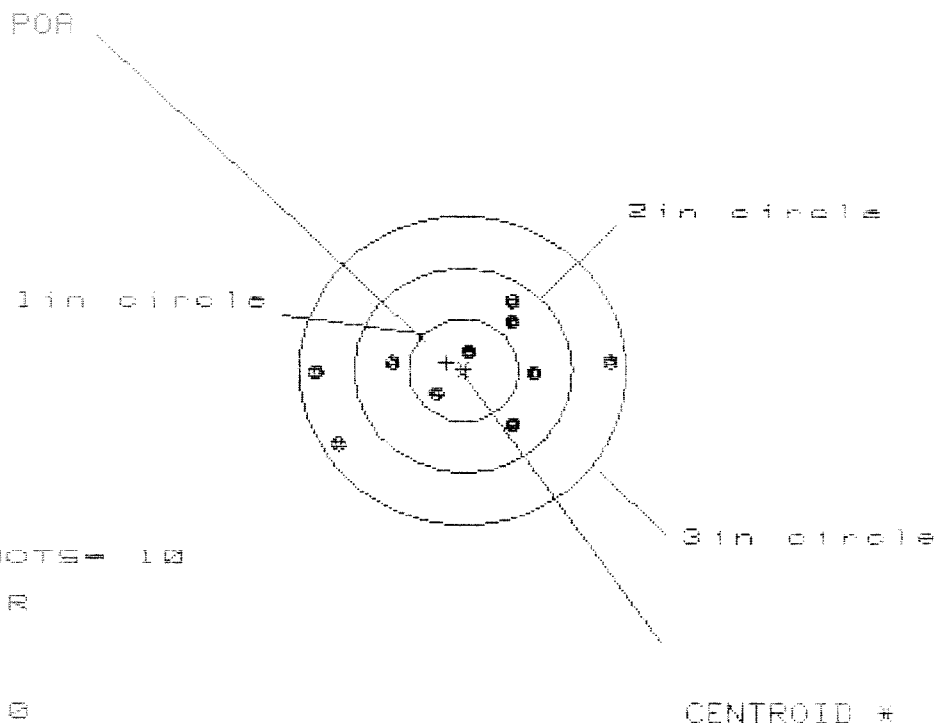
CENTROID *

PATTERN #	2		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.980	.590	.516
MINIMUM X	-.706	-.598	-.653
MAXIMUM Y	.735	.618	.516
MINIMUM Y	-1.056	-.811	-.405
CENTROID X	.041	-.067	.007
CENTROID Y	-.111	.006	.108
POR TO CENTROID in.	.119	.068	.108
MIN RADIUS	.240	.327	.376
MEAN RADIUS	.678	.575	.510
MAX RADIUS	1.440	1.007	.656
HORIZONTAL SPREAD	1.686	1.188	1.169
VERTICAL SPREAD	1.791	1.429	.922
EXTREME SPREAD	2.091	1.687	1.225
NUMBER IN ONE INCH CIRCLE =		4	
NUMBER IN TWO INCH CIRCLE =		9	
NUMBER IN THREE INCH CIRCLE =		10	

28 Feb 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8611381

CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1 in = 2

2 in = 7

3 in = 10

HS = 2.752

VS = 1.417

GS = 2.753

PATTERN #

3

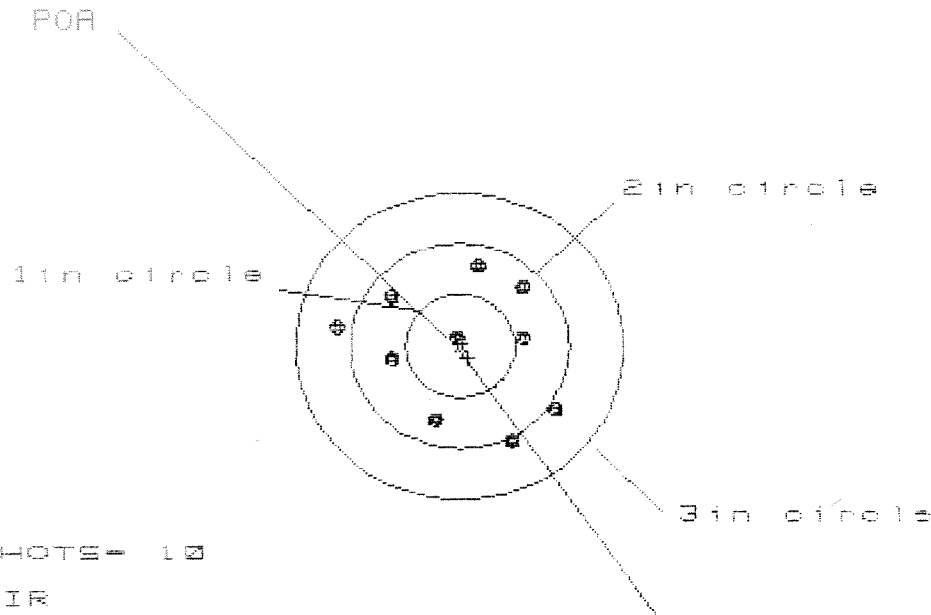
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.360	1.205	.694
MINIMUM X	-1.392	-1.298	-1.147
MAXIMUM Y	.726	.723	.727
MINIMUM Y	-.691	-.694	-.690
CENTROID X	.151	.306	.155
CENTROID Y	-.078	-.075	-.079
POA TO CENTROID in.	.170	.315	.174
MIN RADIUS	.146	.211	.147
MEAN RADIUS	.815	.742	.674
MAX RADIUS	1.392	1.472	1.339
HORIZONTAL SPREAD	2.752	2.503	1.841
VERTICAL SPREAD	1.417	1.417	1.417
EXTREME SPREAD	2.753	2.606	2.107
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	10		

20 Feb 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C85113B1

CENTERFIRE PATTERNS

4



OF SHOTS = 10

IN CIR

1in = 1

2in = 7

3in = 10

HS = 1.955

VS = 1.728

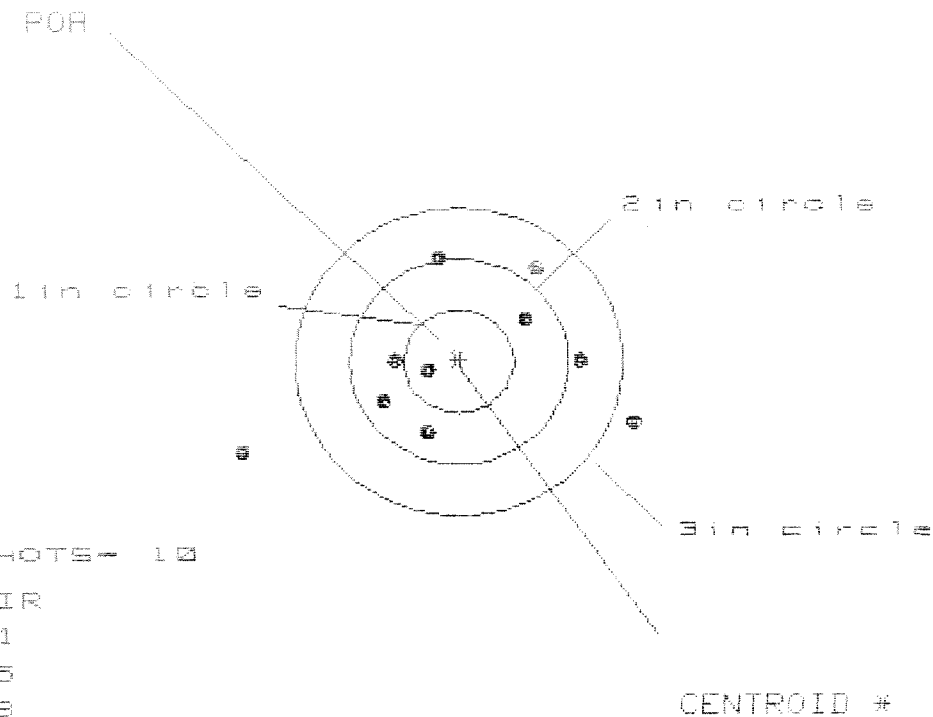
GS = 2.123

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.873	.752	.507
MINIMUM X	:	-1.083	-.738	-.644
MAXIMUM Y	:	.827	.849	.773
MINIMUM Y	:	-.961	-.879	-.955
CENTROID X	:	-.071	.049	-.045
CENTROID Y	:	.118	.096	.172
POA TO CENTROID in.	:	.138	.108	.178
MIN RADIUS	:	.098	.202	.084
MEAN RADIUS	:	.760	.724	.672
MAX RADIUS	:	1.100	.968	1.075
HORIZONTAL SPREAD	:	1.955	1.490	1.151
VERTICAL SPREAD	:	1.728	1.728	1.728
EXTREME SPREAD	:	2.123	1.865	1.797
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

28 Feb 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8811381

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 8

HS= 3.585

VS= 1.893

GS= 3.599

PATTERN #

5

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.562	1.338	1.051
MINIMUM X	-2.023	-.885	-.718
MAXIMUM Y	1.039	.944	.865
MINIMUM Y	-.854	-.737	-.816
CENTROID X	-.011	.213	.046
CENTROID Y	-.015	.080	.159
POA TO CENTROID in.	.019	.228	.165
MIN RADIUS	.239	.532	.412
MEAN RADIUS	1.031	.906	.808
MAX RADIUS	2.196	1.479	1.058
HORIZONTAL SPREAD	3.585	2.223	1.769
VERTICAL SPREAD	1.893	1.681	1.681
EXTREME SPREAD	3.599	2.347	1.929
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	8		