

G 657 7118

Raphra

E 670 3439

Repair Inquiry

Repair Number: RE00113225

Serial: E6703439 Model M24 SWS Center Fire
Caliber: 7.62 NATO Produced: 08/21/2001

Repairman:

Verify Repair

Status:

Closed 6/5/2006 1:20:37 PM

Address Information

Customer:

Received From

Return To:

Received From

Name: NATIONAL GUARD MARKSMANSHIP TNG UNIT

NATIONAL GUARD MARKSMANSHIP TNG UNIT

Address 1: BLDG 4900 CAMP J T ROBINSON

BLDG 4900 CAMP J T ROBINSON

Address 2: ATTN TSGT SEAN WALLACE

PO Box:

ATTN TSGT SEAN WALLACE

PO Box:

City: NORTH LITTLE ROCK

NORTH LITTLE ROCK

State: AR

Zip Code: 72199

Country: US

State: AR

Zip Code: 72199

Country: US

FFL:

Contact / Condition

Problems

Estimate

History / Status

Shipping / Billing

Contact Information

Phone: NA

Fax:

Email:

Comments:

Received Condition

Fair

Condition
Notes:CSR
Notes:

Accessories Received

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

Repair Search

Refresh

Close

nagletj

6/6/2006

7:54 AM

CAPS

NUM

INS

SCRL



Arms Services Repair ...

Part Search by Materi...

2 Microsoft Office O...



7:54 AM

Serial
Number:

E6703439

Model: M24 SWS



RE00113225

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6577118.___0
FILE DATE AND TIME: 07/12/2006 17:20

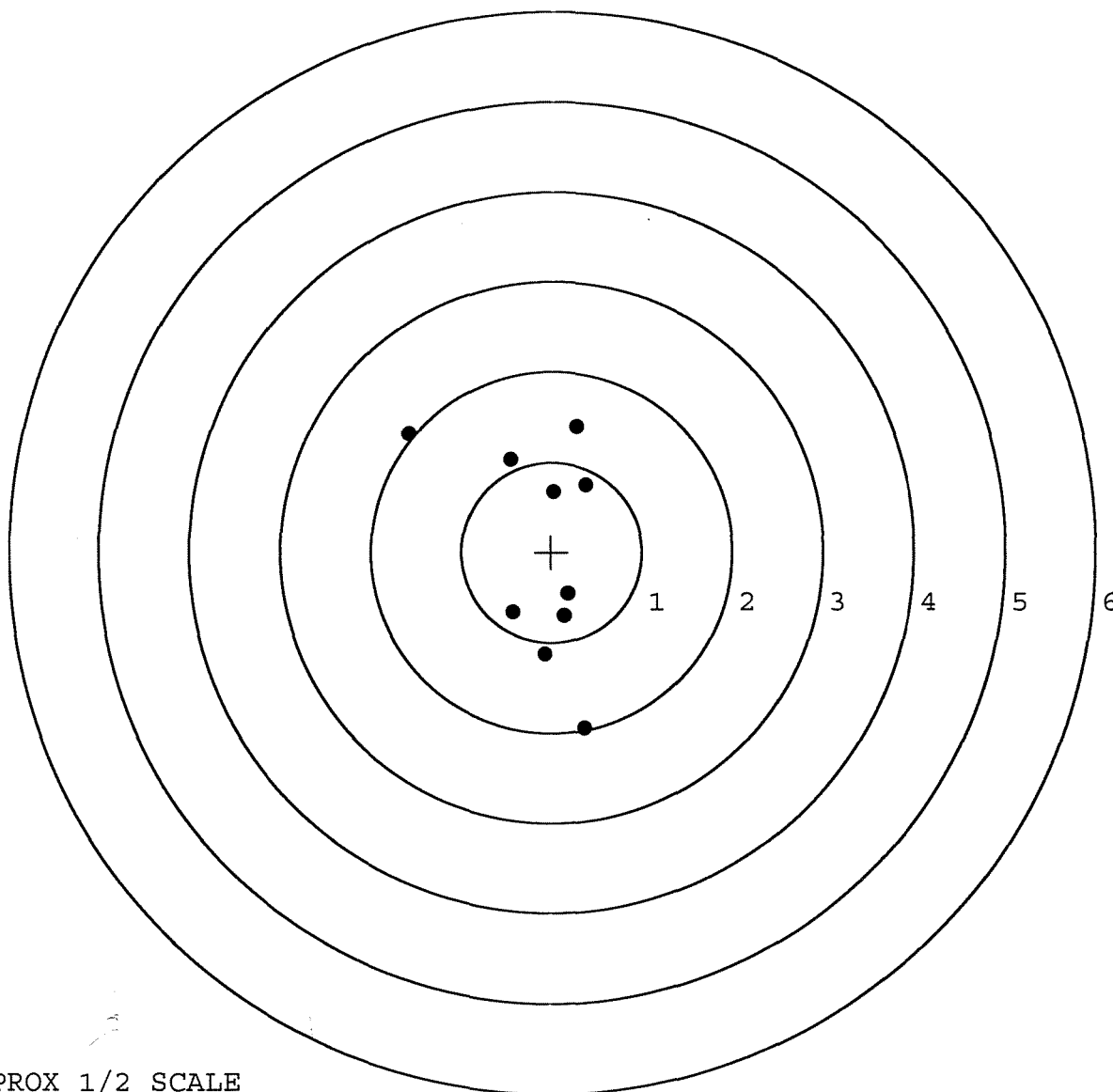
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.121
The Average Y Centroid of the Five Target Set:	0.218
The Average Point of Impact of the Five Target Set:	0.249
The Average Mean Radius of the Five Target Set:	0.946
The Distance from POA to Centroid Target #1:	0.120
The Distance from Centroid Target #2 to Centroid Target #1:	0.299
The Distance from Centroid Target #3 to Centroid Target #1:	0.274
The Distance from Centroid Target #4 to Centroid Target #1:	0.171
The Distance from Centroid Target #5 to Centroid Target #1:	0.309

SERIAL NUMBER: G6577118. __0
TARGET NUMBER: 1
FILE DATE: 07/12/2006
FILE TIME: 17:20

X CENTROID: -0.118
Y CENTROID: 0.022
POA TO CENTROID: 0.120
HORZ SPREAD: 1.966
VERT SPREAD: 3.348
GROUP SPREAD: 3.803
MIN RADIUS: 0.572
MAX RADIUS: 2.032
MEAN RADIUS: 1.129
IN 1 IN DIAMETER: 0
IN 2 IN DIAMETER: 5
in 3 IN DIAMETER: 8

POINT#	X	Y
1:	0.372	-1.950
2:	-0.072	-1.137
3:	0.146	-0.709
4:	0.186	-0.463
5:	-0.432	-0.673
6:	0.270	1.398
7:	-0.457	1.028
8:	-1.588	1.309
9:	0.022	0.668
10:	0.378	0.750



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6577118. __0

TARGET NUMBER: 2

FILE DATE: 07/12/2006

FILE TIME: 17:20

X CENTROID: -0.169

Y CENTROID: 0.317

POA TO CENTROID: 0.359

HORZ SPREAD: 1.444

VERT SPREAD: 2.589

GROUP SPREAD: 2.696

MIN RADIUS: 0.176

MAX RADIUS: 1.616

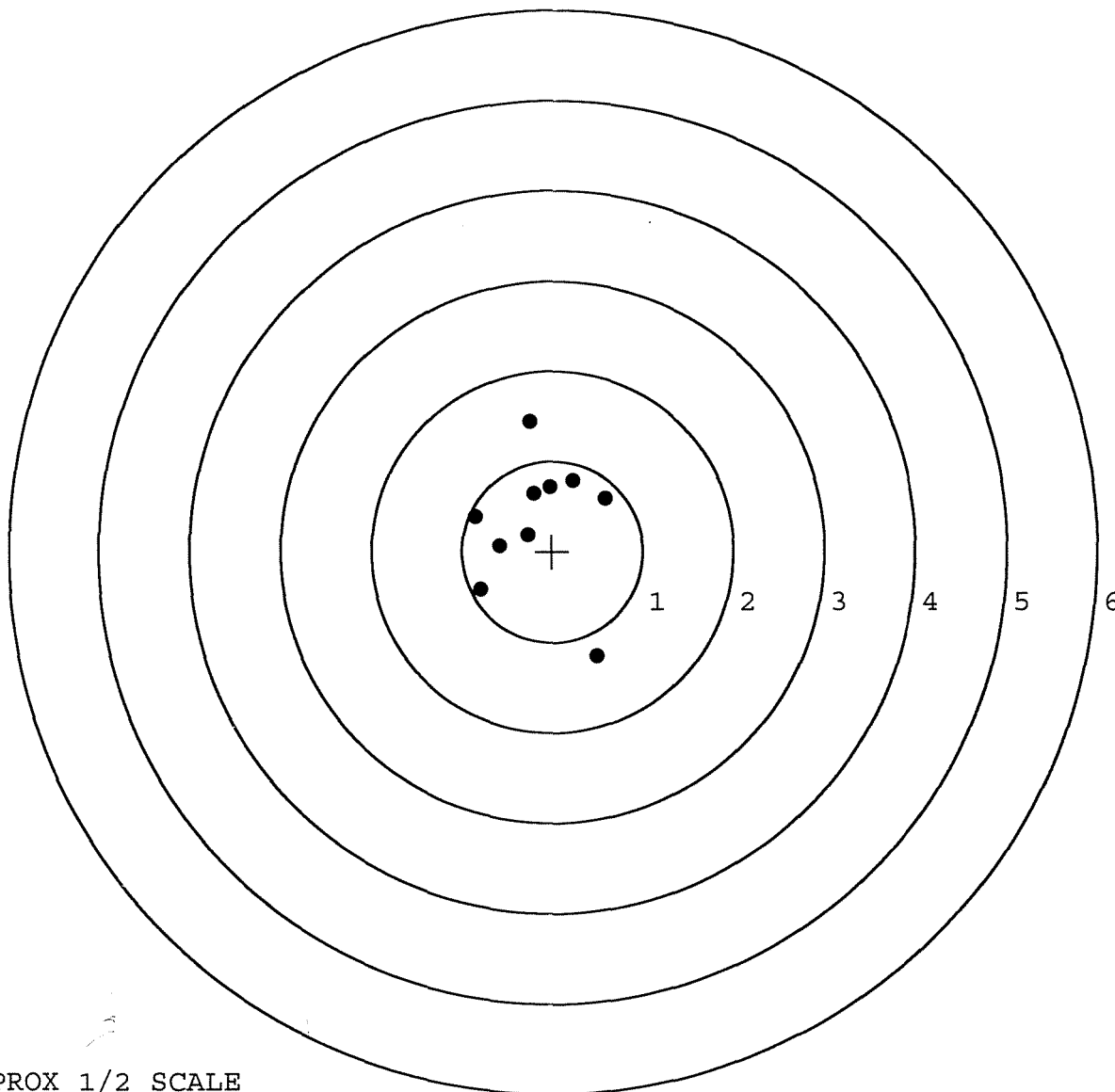
MEAN RADIUS: 0.723

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 9

POINT#	X	Y
1:	-0.254	1.434
2:	0.584	0.581
3:	0.233	0.786
4:	-0.027	0.708
5:	-0.208	0.634
6:	-0.276	0.177
7:	-0.860	0.377
8:	-0.583	0.056
9:	-0.799	-0.433
10:	0.498	-1.155



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6577118. __0

TARGET NUMBER: 3

FILE DATE: 07/12/2006

FILE TIME: 17:20

POINT#	X	Y
1:	0.724	-0.986
2:	-0.355	-0.957
3:	-0.148	-0.435
4:	-0.139	0.132
5:	0.261	0.685
6:	-0.263	0.781
7:	-0.484	0.494
8:	-0.981	0.834
9:	-0.795	1.536
10:	-0.332	0.534

X CENTROID: -0.251

Y CENTROID: 0.262

POA TO CENTROID: 0.363

HORZ SPREAD: 1.705

VERT SPREAD: 2.522

GROUP SPREAD: 2.944

MIN RADIUS: 0.172

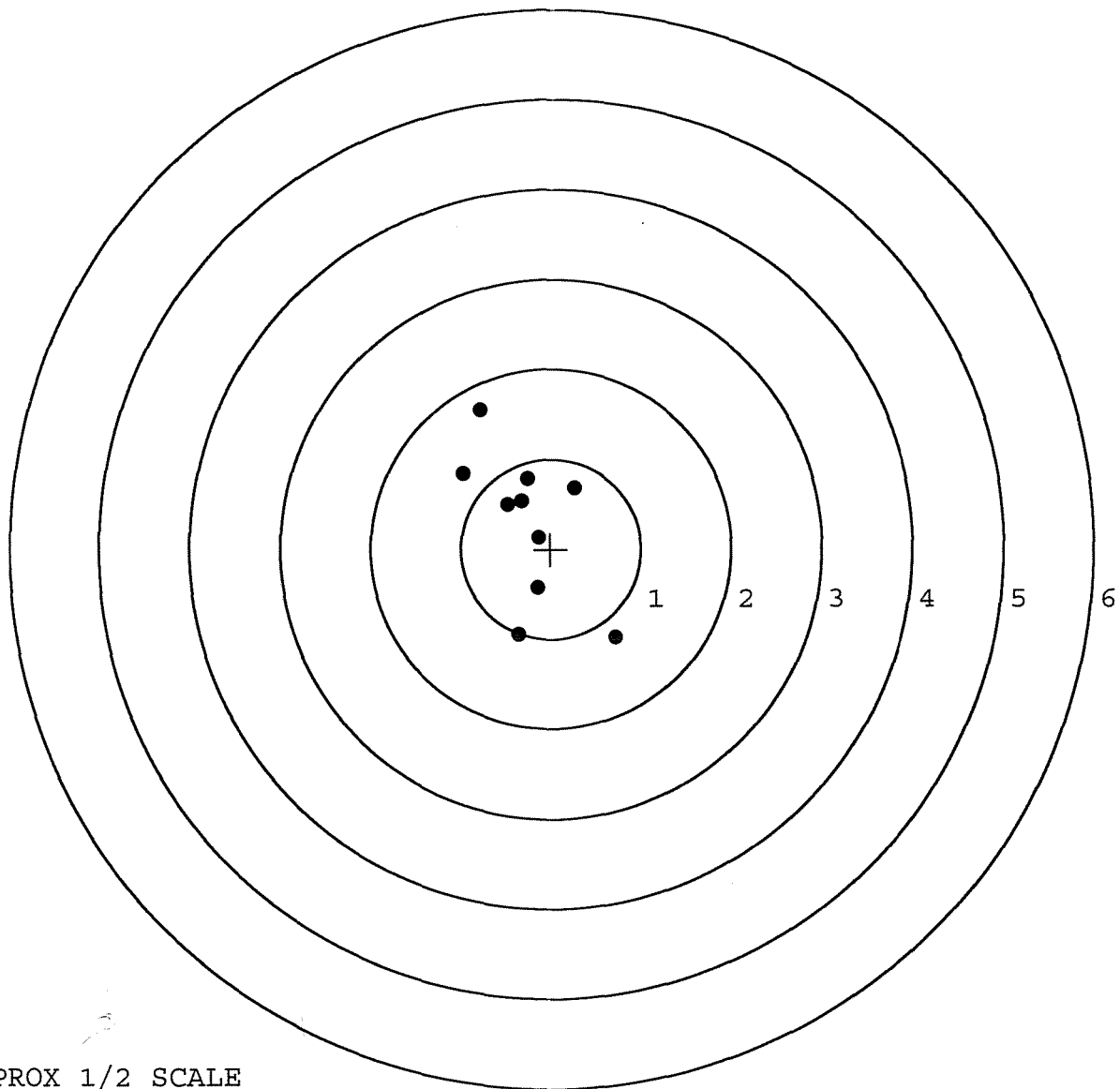
MAX RADIUS: 1.584

MEAN RADIUS: 0.779

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6577118.___0

TARGET NUMBER: 4

FILE DATE: 07/12/2006

FILE TIME: 17:20

X CENTROID: -0.032

Y CENTROID: 0.170

POA TO CENTROID: 0.173

HORZ SPREAD: 1.612

VERT SPREAD: 1.864

GROUP SPREAD: 2.065

MIN RADIUS: 0.067

MAX RADIUS: 1.302

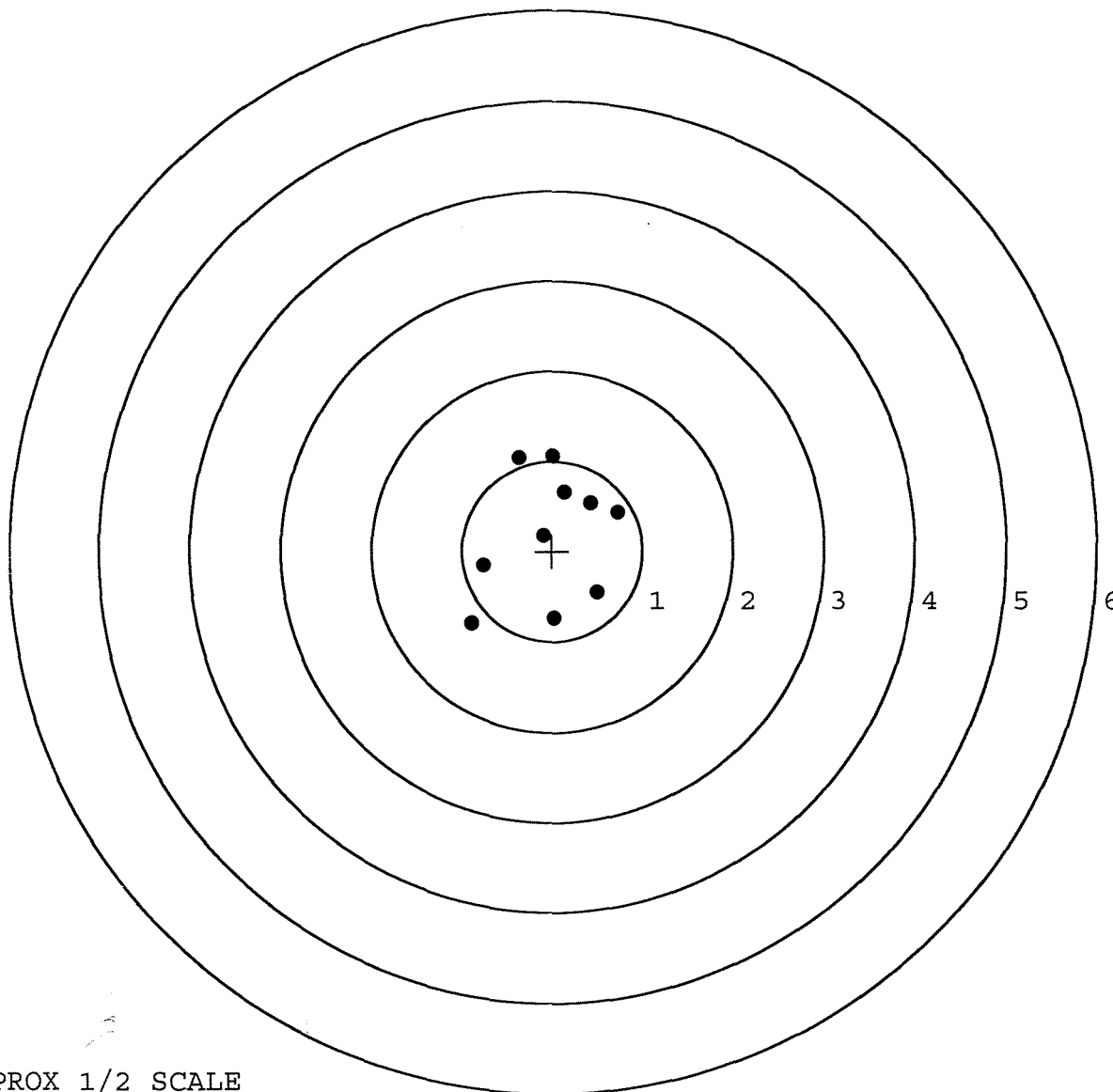
MEAN RADIUS: 0.765

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.496	-0.465
2:	0.027	-0.752
3:	-0.889	-0.809
4:	-0.763	-0.172
5:	-0.099	0.175
6:	-0.374	1.039
7:	0.000	1.055
8:	0.134	0.660
9:	0.426	0.539
10:	0.723	0.435

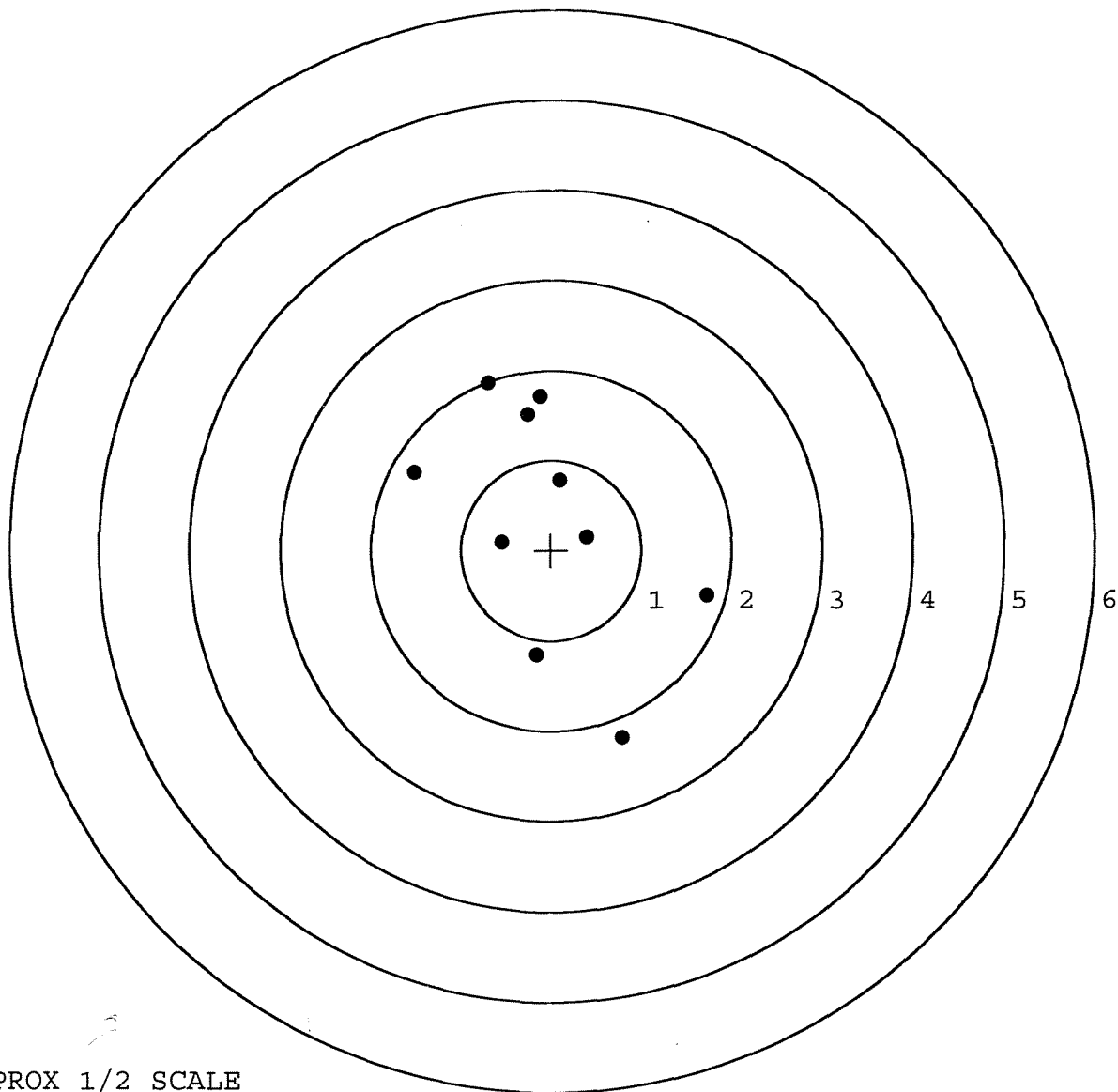


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6577118. __0
TARGET NUMBER: 5
FILE DATE: 07/12/2006
FILE TIME: 17:20

X CENTROID: -0.033
Y CENTROID: 0.320
POA TO CENTROID: 0.321
HORZ SPREAD: 3.249
VERT SPREAD: 3.931
GROUP SPREAD: 4.210
MIN RADIUS: 0.465
MAX RADIUS: 2.534
MEAN RADIUS: 1.334
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 3
in 3 IN DIAMETER: 6

POINT#	X	Y
1:	0.797	-2.075
2:	-0.160	-1.161
3:	1.724	-0.504
4:	0.397	0.143
5:	-0.549	0.085
6:	0.099	0.779
7:	-1.525	0.854
8:	-0.711	1.856
9:	-0.133	1.707
10:	-0.273	1.512



TARGET APPROX 1/2 SCALE

M-24 INSPECTION CHECKLIST
CONTRACT #: DAAE-20-02-C-0149

R & E NUMBER	113225			
SERIAL NUMBER	E6703439		G6577118	
LOG-IN DATE	6-5-06			
OPERATION #	OPERATION NAME		DATE	INITIAL
500	DIS-ASSEMBLE GUN		7-5-06	BLG
505	RE-BARREL		7-5-06	BLG
560	ASSEMBLE		7-5-06	BLG
600	PROOF	MAGNA-FLUX INSPECTED	7-5-06	MTM
605	CHECK HEADSPACE		7-5-06	MTM
610	DIS-ASSEMBLE GUN	JUL 06 2006	7-6-06	BLG
612	MAGNAFLUX	OPERATOR <i>unm</i>	7/6/06	<i>unm</i>
510	DRILL AND TAP		7-6-06	TRW
615	ROLLMARK CALIBER		7-7-06	CW
618	ROTO-BLAST		7-7-06	LB
620	APPLY COATINGS		7/7	HA
625	FINAL ASSEMBLY		7-11-06	BLG
640	FUNCTION TEST AND	PASS FAIL	7-12-06	MTM
650	TARGET	PASS FAIL	7-12-06	MTM
	MALFUNCTION Bolt off	CORRECTION OK	7-14-06	TRW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION N/A		
	MALFUNCTION	CORRECTION		
670	FINAL INSPECTION		7-14-06	BD
	A) HEADSPACE	PASS FAIL	7-27-06	<i>A</i>
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	2.38 2.56 2. 2.64 2.35 2.29 7-13-06	RA
680	F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX	6.0 6.0 6.0 7-13-06	RA
	G) SAFETY OFF FORCE	2 LBS MIN	2.0 2.0 2.0 7-13-06	RA
	I) FIRING PIN INDENT	.020	.021 .021 .021 7-13-06	RA
690	PACK		8-1-06	RA

Remington®

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

Made in Illinois, NY

Reg. U.S. Pat. & Tm. Off. - Marca Registrada - Marque Deposee



5716 E6703439

ORDER

25716

MODEL 700™ M24

UPC



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MODEL 700™ M24

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0 47700 25716 7

SERIAL NO.



E6703439

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

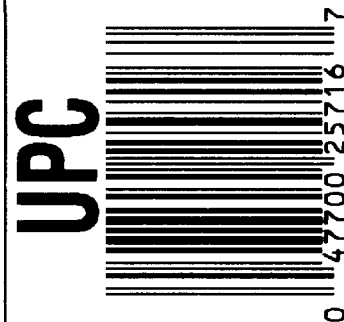


ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

E6703439



GUN SERIAL # E 6703439

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		4/2/01	RH
600	PROOF		4/2/01	RH
607	CHECK HEADSPACE		4/2/01	RH
610	DIS-ASSEMBLE GUN		4/2/01	RH
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT		4/2/01	RH
615	ROLLMARK CALIBER		4/2/01	RH
617	DRILL AND TAP SIGHT HOLES		4/10/01	OR
618	POLISH BARREL		4/10/01	RH
620	APPLY COATINGS (BARREL ACTION)		4/10/01	RH
	(BOLT)		4/10/01	RH
625	FINAL ASSEMBLY		4/10/01	OR
	A) CLEAN INSIDE OF BOLT ASSEMBLY		4/10/01	RH
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		4/10/01	RH
	C) INSPECT EJECTOR HOLE FOR CHAMFER		4/10/01	RH
	D) OIL FIRING PIN ASSEMBLY		4/10/01	RH
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE		4/10/01	RH

OP #	OPERATION NAME	READINGS	DATE	INITIAL
625	F) SAFETY ON FORCE	<u>5²⁵</u> <u>5⁰</u> <u>5⁰</u>	4/23/01	KH
CONT.	G) SAFETY OFF FORCE	<u>3²⁵</u> <u>3⁷⁵</u> <u>3²⁵</u>	4/23/01	KH
	H) TRIGGER PULL TEST AND RETAINABILITY		4/23/01	KH
	I) FIRING PIN INDENT	<u>020</u> <u>021</u> <u>023</u>	4/23/01	KH
	J) ASSEMBLE STOCK		4/26/01	KH
	K) ASSEMBLE SWIVEL STUDS		4/26/01	KH
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		4/26/01	KH
	M) IRON SIGHT ALIGNMENT		4/26/01	KH
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		4/26/01	KH
640	GALLERY TEST AND TARGET		4/20/01	RW
	A) MALFUNCTIONS		4/20/01	RW
	B) PIERCED PRIMERS		4/20/01	RW
645	INSPECT FOR LIVE AMMO		4/20/01	RW
655	FINAL INSPECTION A) HEADSPACE		4/23/01	KH
	B) TRIGGER PULL	<u>263</u> <u>253</u> <u>251</u> <u>267</u> <u>261</u>	4/23/01	KH
	C) FUNCTION		4/23/01	KH
660	PACK		8/16/01	DA

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

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

SERIAL NO. E 6703439

DATE 3/31/01

TESTER SF

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.78	2.72		2.51	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.90	2.15		2.46	
PULL #3	2.89	2.69		2.38	
PULL #4	2.83	2.65		2.46	
PULL #5	2.52	2.66		2.47	
TOTAL	13.92	12.87		12.28	
AVG.	2.78	2.57		2.46	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.27	3.00		
PULL #2	3.30	3.04		
PULL #3	3.24	3.29		
PULL #4	3.22	3.26		
PULL #5	3.27	3.33		
TOTAL	16.3	15.92		
AVG.	3.26	3.18		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.27	4.00		4.14
PULL #2	4.20	4.13		4.07
PULL #3	4.28	4.06		4.14
PULL #4	4.16	4.17		4.11
PULL #5	4.14	4.15		4.15
TOTAL	21.05	20.51		20.61
AVG.	4.21	4.10		4.12

Remington Test Lab, Ilion, N.Y.

Centroidal distance calculations for Rifle # e6703439
20 Apr 2001

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0576
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.204
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .211976

THE AMR FOR THIS RIFLE IS: 1.16

CENTROIDAL DISTANCES

0	TO	1	.503083
1	TO	2	.676737
1	TO	3	.65105
1	TO	4	.499509
1	TO	5	.703981

+ 1<----POA
5₃4

PATTERN #: ☐ 1 ☐

POA TO CENTROID: .503

MIN RADIUS : .656

MEAN RADIUS : 1.203

MAX RADIUS : 2.354

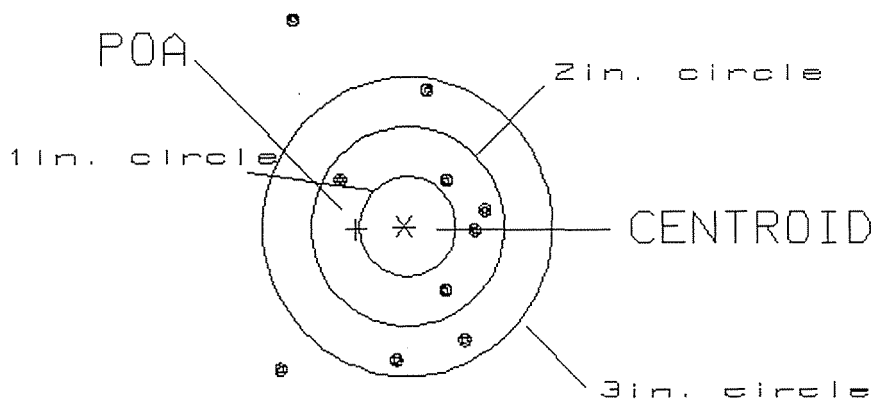
CENTROID X : .502

CENTROID Y : .033

20 Apr 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/e6703439

CENTERFIRE PATTERN # 1



OF SHOTS= 10

IN CIRCLE

HS= 2.07

0

VS= 3.50

5

GS= 3.59

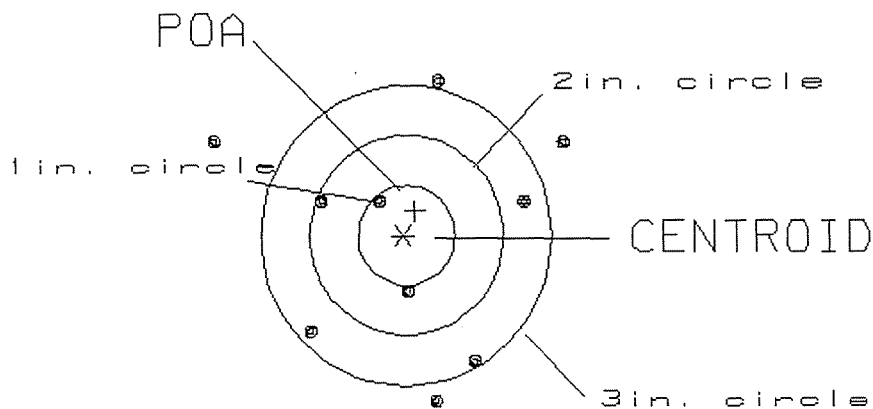
8

PATTERN #: ☐ 2 ☐
 POA TO CENTROID: .270
 MIN RADIUS : .393
 MEAN RADIUS : 1.335
 MAX RADIUS : 2.217
 CENTROID X : -.115
 CENTROID Y : -.245

20 Apr 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/e6703439

CENTERFIRE PATTERN # 2



OF SHOTS= 10

IN CIRCLE

HS= 3.65
 VS= 3.29
 GS= 3.65

1
 3
 6

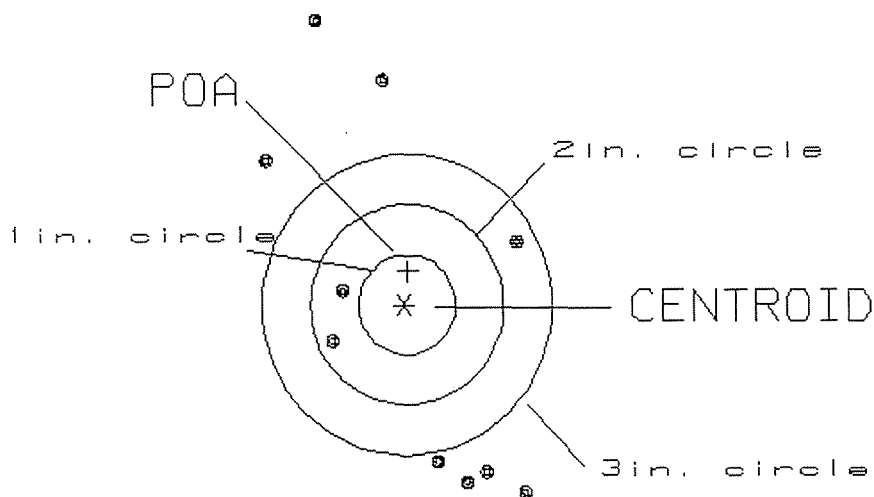
PATTERN #: ☐ 3 ☐

POA TO CENTROID: .339
 MIN RADIUS : .688
 MEAN RADIUS : 1.767
 MAX RADIUS : 2.994
 CENTROID X : -.033
 CENTROID Y : -.338

20 Apr 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/e6703439

CENTERFIRE PATTERN # 3



OF SHOTS= 10

IN CIRCLE

HS= 2.64

0

VS= 4.67

2

GS= 5.15

3

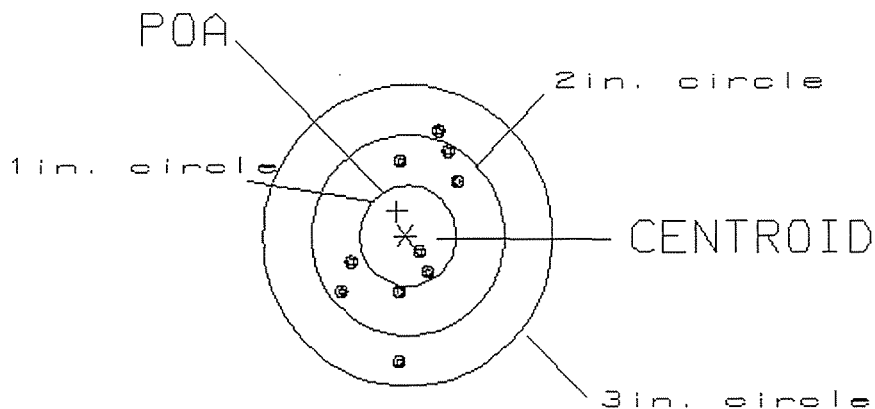
PATTERN #: ☐ 4 ☐

POA TO CENTROID: .260
 MIN RADIUS : .225
 MEAN RADIUS : .762
 MAX RADIUS : 1.272
 CENTROID X : .087
 CENTROID Y : -.245

20 Apr 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/e6703439

CENTERFIRE PATTERN # 4



OF SHOTS= 10

IN CIRCLE

HS= 1.20

2

VS= 2.34

6

GS= 2.36

10

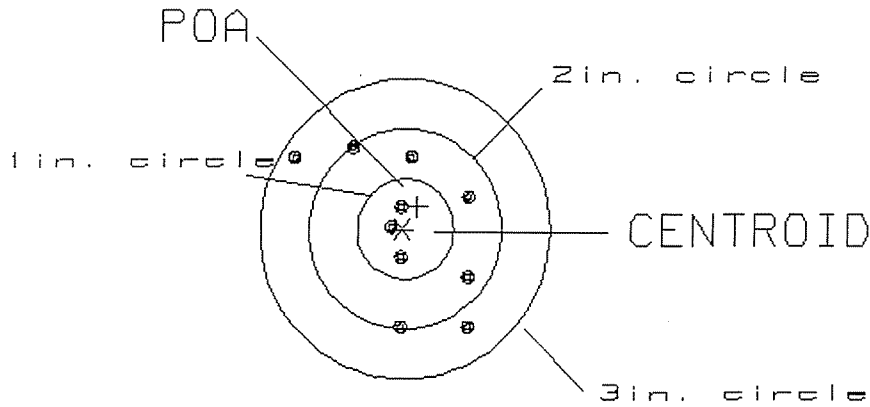
PATTERN #: ☐ 5 ☐

POA TO CENTROID: .272
 MIN RADIUS : .129
 MEAN RADIUS : .731
 MAX RADIUS : 1.305
 CENTROID X : -.153
 CENTROID Y : -.225

20 Apr 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/e6703439

CENTERFIRE PATTERN # 5



OF SHOTS= 10

IN CIRCLE

HS= 1.78

3

VS= 1.81

6

GS= 2.42

10