

G657 7877

Replaced

E670 3518

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: **RE00113229**

Serial: E6703518 Model M24 SWS Center Fire
Caliber: 7.62 NATO Produced: 08/21/2001

Repairman:

Status: Closed 6/5/2006 1:20:13 PM

Verify Repair

Address Information

Customer: ☒ Received From Return To: ☐ Received From
Name: NATIONAL GUARD MARKSMANSHIP TNG UNIT
Address 1: BLDG 4900 CAMP J T ROBINSON
Address 2: ATTN TSGT SEAN WALLACE PO Box:
City: 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

DAPS

NUM

INS

SCRL



Arms Services Repair ...

Part Search by Materi...

2 Microsoft Office O...

7:54 AM

G654 7277

E6703518

Model: M24 SWS



RE00113229

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6577277.___0
FILE DATE AND TIME: 07/14/2006 17:21

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

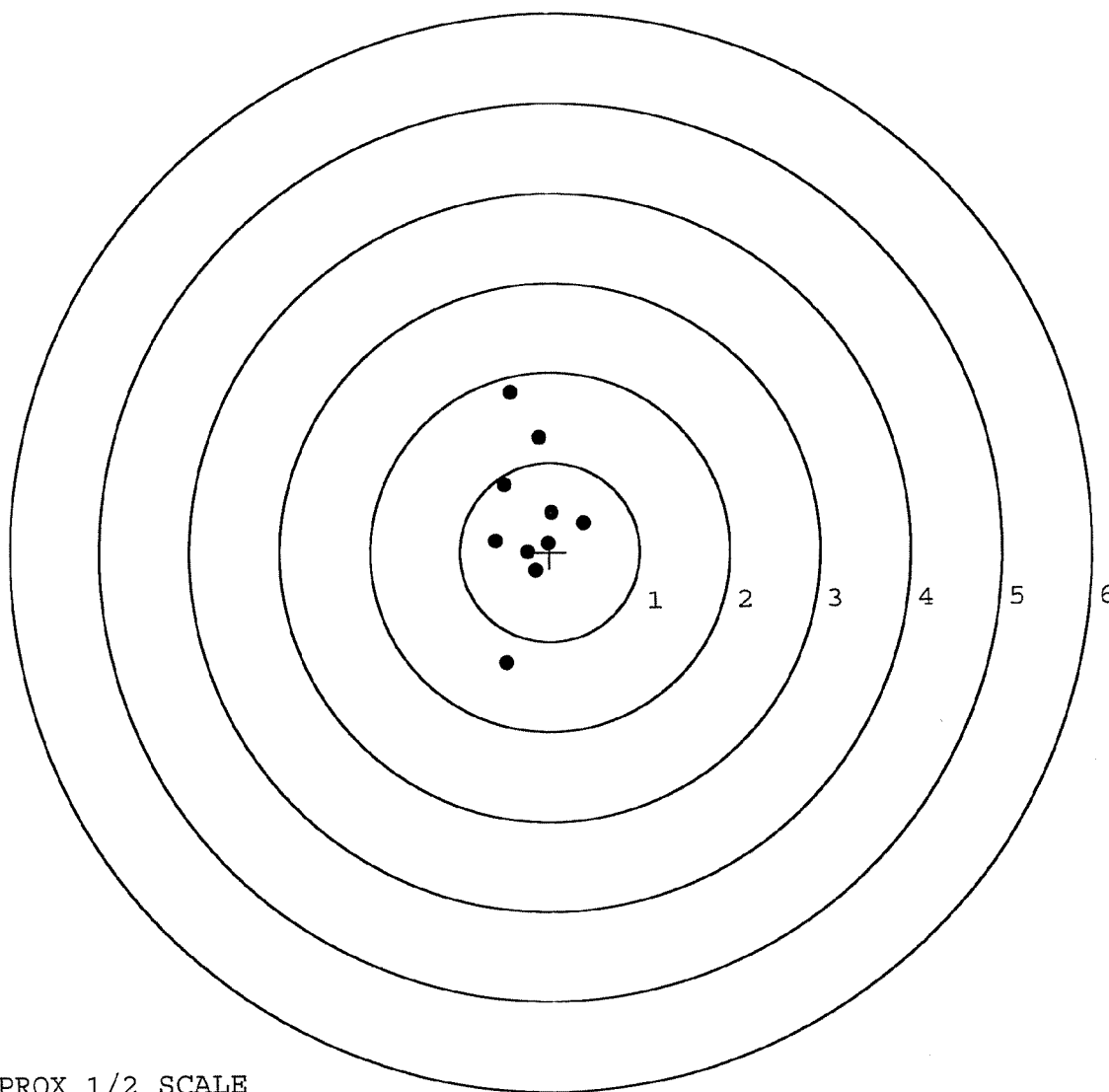
The Average X Centroid of the Five Target Set:	-0.230
The Average Y Centroid of the Five Target Set:	0.096
The Average Point of Impact of the Five Target Set:	0.249
The Average Mean Radius of the Five Target Set:	0.758
The Distance from POA to Centroid Target #1:	0.400
The Distance from Centroid Target #2 to Centroid Target #1:	0.040
The Distance from Centroid Target #3 to Centroid Target #1:	0.280
The Distance from Centroid Target #4 to Centroid Target #1:	0.401
The Distance from Centroid Target #5 to Centroid Target #1:	0.507

SERIAL NUMBER: G6577277. __0
TARGET NUMBER: 1
FILE DATE: 07/14/2006
FILE TIME: 17:21

X CENTROID: -0.217
Y CENTROID: 0.335
POA TO CENTROID: 0.400
HORZ SPREAD: 0.978
VERT SPREAD: 3.018
GROUP SPREAD: 3.019
MIN RADIUS: 0.266
MAX RADIUS: 1.597
MEAN RADIUS: 0.700

IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 9

POINT#	X	Y
1:	-0.489	-1.238
2:	-0.165	-0.212
3:	-0.250	-0.004
4:	-0.021	0.098
5:	0.025	0.445
6:	-0.116	1.274
7:	-0.427	1.780
8:	-0.503	0.758
9:	-0.601	0.131
10:	0.377	0.323



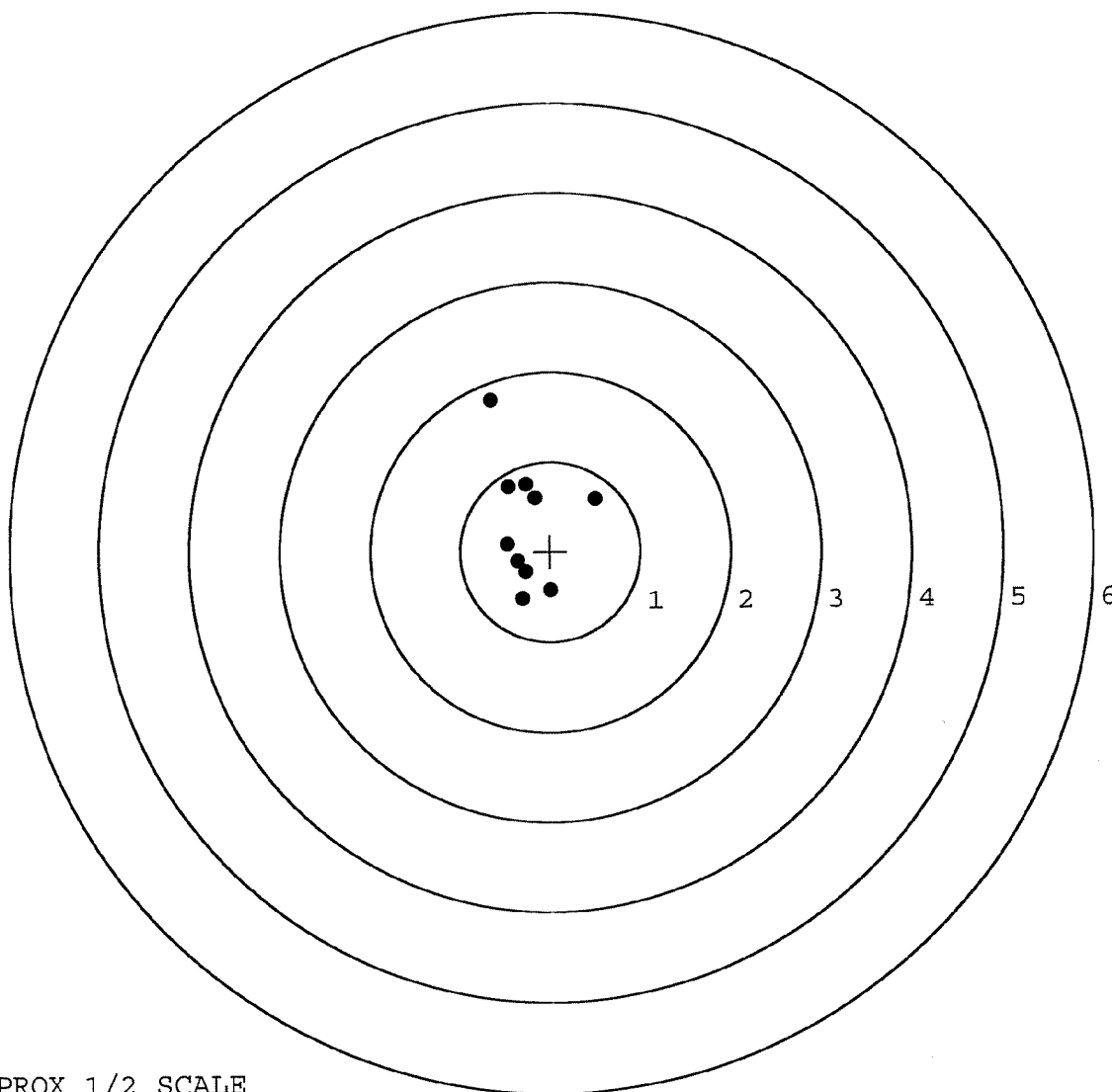
TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6577277. __0
TARGET NUMBER: 2
FILE DATE: 07/14/2006
FILE TIME: 17:21

X CENTROID: -0.249
Y CENTROID: 0.311
POA TO CENTROID: 0.399
HORZ SPREAD: 1.161
VERT SPREAD: 2.221
GROUP SPREAD: 2.249
MIN RADIUS: 0.295
MAX RADIUS: 1.436
MEAN RADIUS: 0.637

IN 1 IN DIAMETER: 5
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.659	1.688
2:	-0.463	0.722
3:	-0.268	0.750
4:	-0.172	0.596
5:	0.502	0.586
6:	-0.477	0.085
7:	-0.360	-0.109
8:	-0.279	-0.231
9:	-0.004	-0.440
10:	-0.308	-0.533

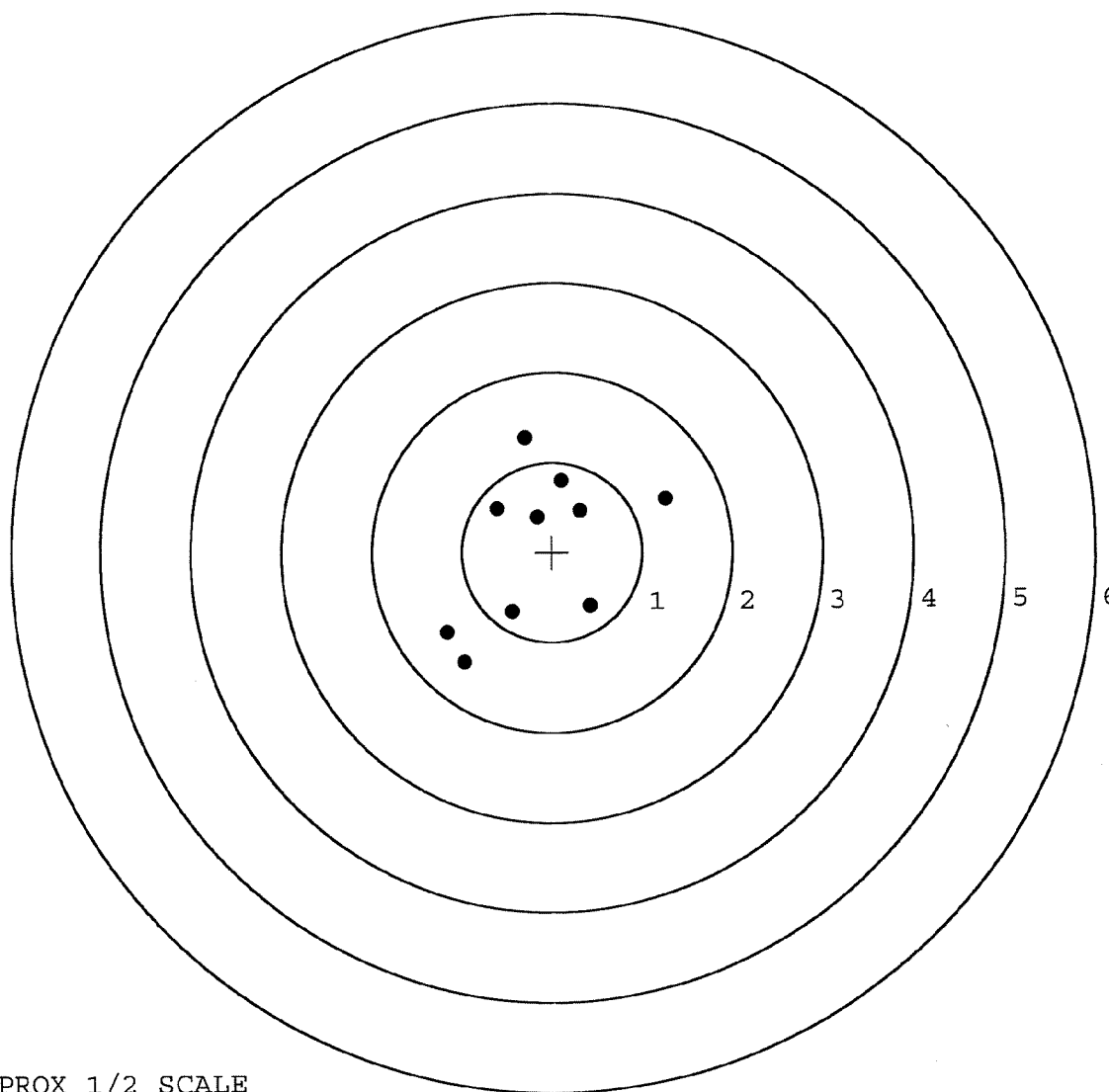


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6577277. __0
TARGET NUMBER: 3
FILE DATE: 07/14/2006
FILE TIME: 17:21

X CENTROID: -0.156
Y CENTROID: 0.062
POA TO CENTROID: 0.168
HORZ SPREAD: 2.431
VERT SPREAD: 2.497
GROUP SPREAD: 2.879
MIN RADIUS: 0.329
MAX RADIUS: 1.523
MEAN RADIUS: 0.966
IN 1 IN DIAMETER: 1
IN 2 IN DIAMETER: 6
in 3 IN DIAMETER: 8

POINT#	X	Y
1:	-1.170	-0.891
2:	-0.977	-1.221
3:	-0.446	-0.664
4:	0.422	-0.601
5:	1.261	0.590
6:	-0.165	0.391
7:	0.109	0.794
8:	-0.613	0.488
9:	-0.294	1.276
10:	0.315	0.460

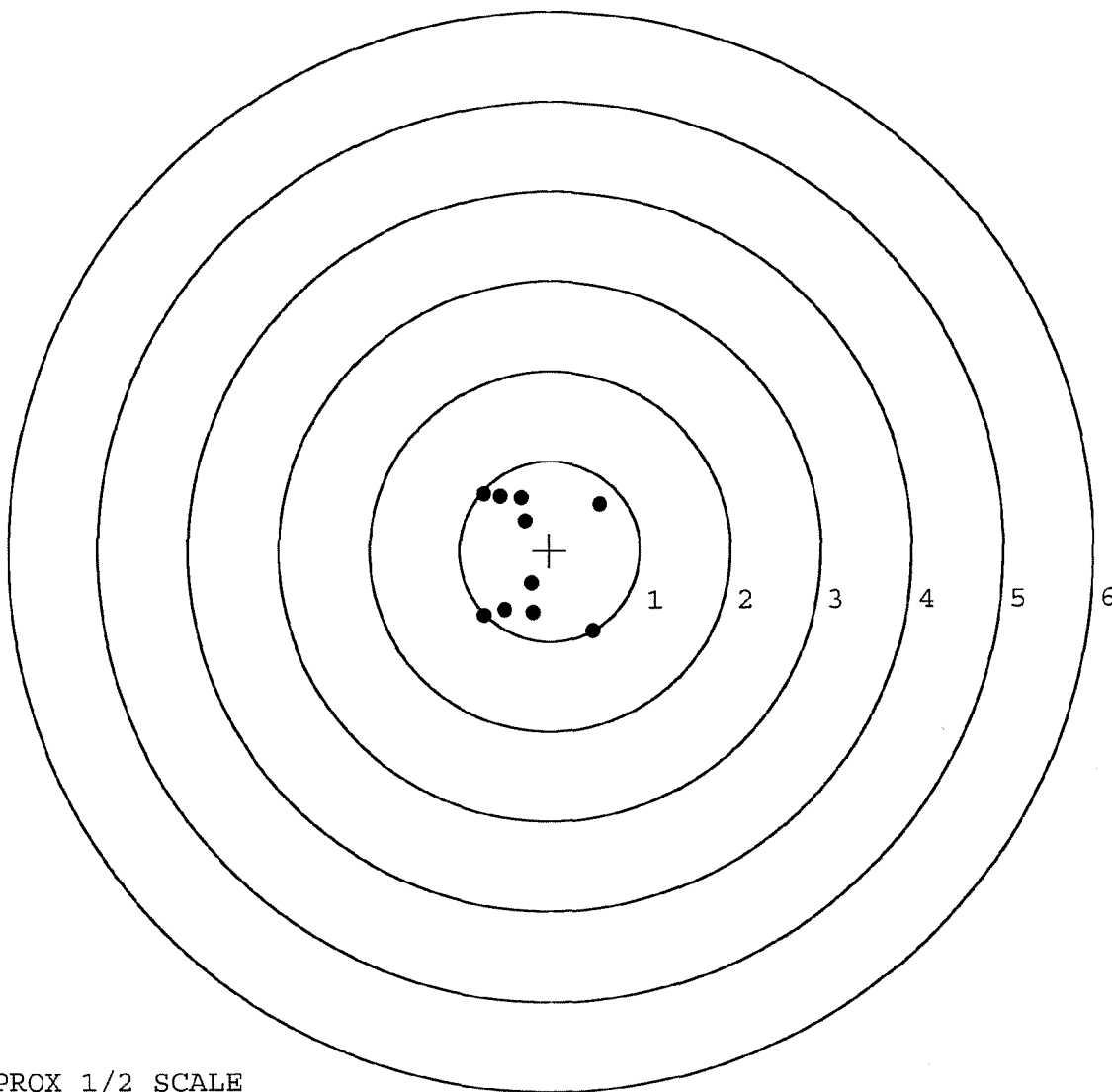


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6577277. 0
TARGET NUMBER: 4
FILE DATE: 07/14/2006
FILE TIME: 17:21

X CENTROID: -0.246
Y CENTROID: -0.064
POA TO CENTROID: 0.255
HORZ SPREAD: 1.291
VERT SPREAD: 1.521
GROUP SPREAD: 1.941
MIN RADIUS: 0.309
MAX RADIUS: 1.095
MEAN RADIUS: 0.712
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.732	-0.718
2:	-0.503	-0.659
3:	-0.204	-0.370
4:	-0.190	-0.687
5:	0.476	-0.887
6:	0.559	0.514
7:	-0.277	0.331
8:	-0.315	0.589
9:	-0.548	0.611
10:	-0.730	0.634

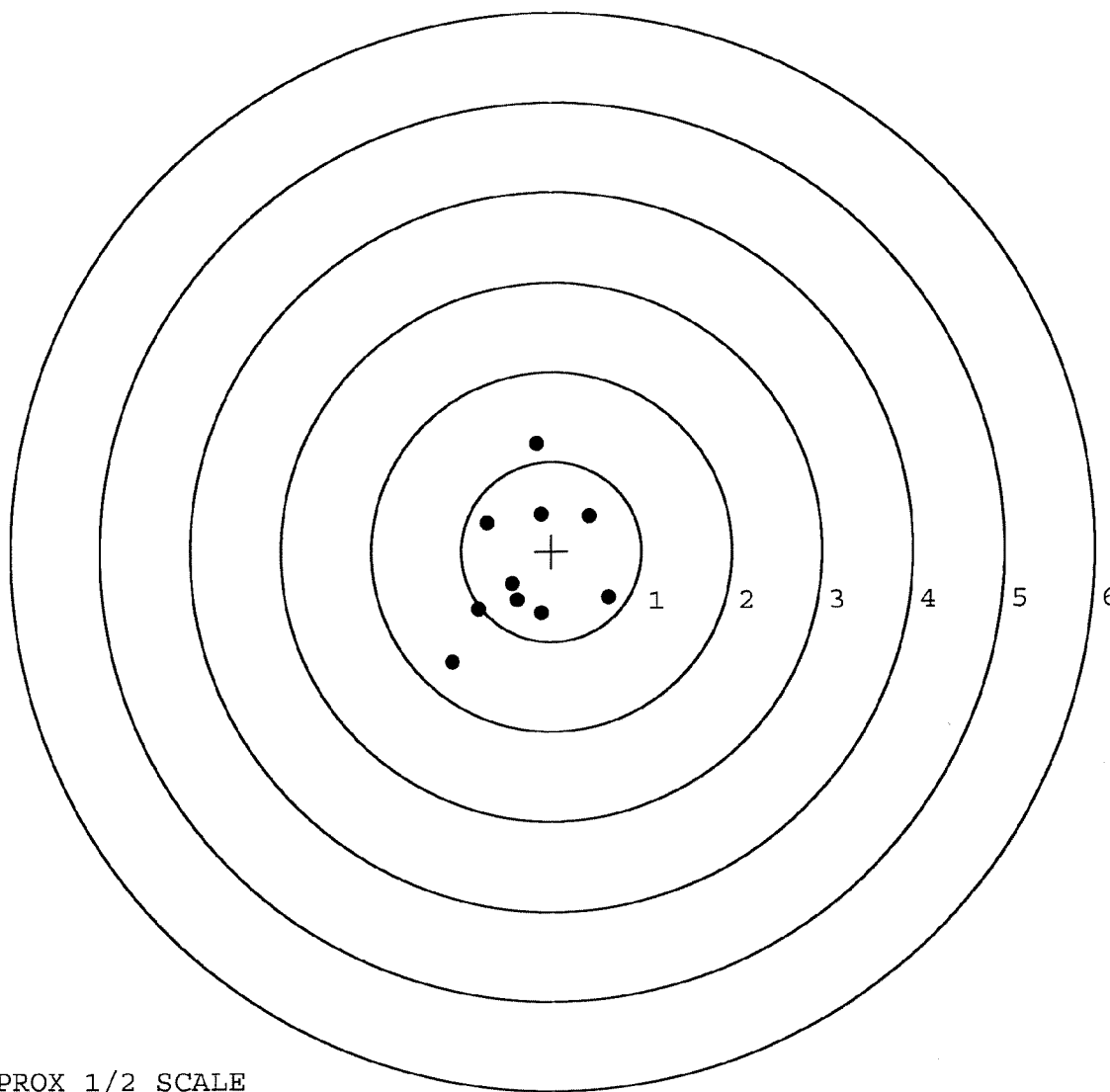


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6577277. __0
TARGET NUMBER: 5
FILE DATE: 07/14/2006
FILE TIME: 17:21

X CENTROID: -0.280
Y CENTROID: -0.167
POA TO CENTROID: 0.326
HORZ SPREAD: 1.740
VERT SPREAD: 2.426
GROUP SPREAD: 2.602
MIN RADIUS: 0.251
MAX RADIUS: 1.368
MEAN RADIUS: 0.775
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-1.106	-1.230
2:	-0.811	-0.646
3:	-0.385	-0.541
4:	-0.438	-0.362
5:	0.634	-0.519
6:	0.423	0.389
7:	-0.717	0.316
8:	-0.166	1.196
9:	-0.117	0.413
10:	-0.114	-0.689



TARGET APPROX 1/2 SCALE

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

R & E NUMBER	113229			
SERIAL NUMBER	E6703518		606577277	
LOG-IN DATE	6-5-06			
OPERATION #	OPERATION NAME		DATE	INITIAL
500	DIS-ASSEMBLE GUN		7-5-06	RTL
505	RE-BARREL		7-5-06	RLC
560	ASSEMBLE		7-5-06	RLC
600	PROOF	MAGNA-FLUX INSPECTED	7-5-06	MTL
605	CHECK HEADSPACE		7-5-06	MTL
610	DIS-ASSEMBLE GUN	JUL 06 2006	7-6-06	RLC
612	MAGNAFLUX	OPERATOR <i>Wmms</i>	7-6-06	<i>Wmms</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	HP
625	FINAL ASSEMBLY		7-11-06	RL
640	FUNCTION TEST AND	PASS FAIL	7-14-06	<i>X.P.D.</i>
650	TARGET	PASS FAIL	7-14-06	<i>X.P.D.</i>
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
670	FINAL INSPECTION		7-27-06	AC
	A) HEADSPACE	PASS FAIL	7-27-06	AC
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	2.77 2.63 2.56 2.42 2.49	7-17-06 NA
680	F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX	6.2 6.5 6.5	7-17-06 NA
	G) SAFETY OFF FORCE	2 LBS MIN	3.2 3.2 3.2	7-17-06 NA
	I) FIRING PIN INDENT	.020	.022 .023 .023	7-17-06 NA
690	PACK		7-1-06	NA

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

Remington®

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

46

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

SERIAL NO. J
E6703518

ORDER NO.
25716

21WV

5716 E6703518

ORDER 25716

MODEL 700™ M24

UPC



ORDER 25716

MODEL 700™ M24

UPC



SERIAL NO.



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

DOCUMENT ENVELOPE ASSEMBLY:

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

46 FORM 1444

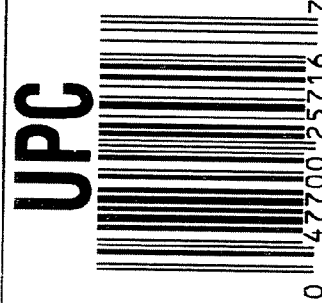


ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

E6703518



CONTRACT #

GUN SERIAL # E670 3518

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		5-3-01	CK
600	PROOF		5-3-01	CK
607	CHECK HEADSPACE		5-3-01	CK
610	DIS-ASSEMBLE GUN		5-3-01	CK
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT		5-1-01	CK
615	ROLLMARK CALIBER		5-1-01	CK
617	DRILL AND TAP SIGHT HOLES		5/1/01	CK
618	POLISH BARREL		5/1/01	CK
620	APPLY COATINGS (BARREL ACTION)		5/1/01	CK
	(BOLT)		5/1/01	TA
625	FINAL ASSEMBLY A) CLEAN INSIDE OF BOLT ASSEMBLY		5/2/01	CK
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		5/2/01	CK
	C) INSPECT EJECTOR HOLE FOR CHAMFER		5/1/01	CK
	D) OIL FIRING PIN ASSEMBLY		5/2/01	CK
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE		5/2/01	CK

OP #	OPERATION NAME	READINGS	DATE	INITIAL
625	F) SAFETY ON FORCE	<u>2.5</u> <u>6.9</u> <u>6.9</u>	6/4/01	DA
CONT.			"	"
	G) SAFETY OFF FORCE	<u>2.5</u> <u>2.5</u> <u>2.5</u>		
	H) TRIGGER PULL TEST AND RETAINABILITY		6-4-01	KH
	I) FIRING PIN INDENT	<u>.022</u> <u>.021</u> <u>.022</u>	6/4/01	DA
	J) ASSEMBLE STOCK		5-3-01	C/K
	K) ASSEMBLE SWIVEL STUDS		8-16-01	RH
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		11	RH
	M) IRON SIGHT ALIGNMENT		11	RH
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		11	RH
640	GALLERY TEST AND TARGET		5/9/01	RW
	A) MALFUNCTIONS		5/9/01	RW
	B) PIERCED PRIMERS		5/09/01	RW
645	INSPECT FOR LIVE AMMO		5/9/01	RW
655	FINAL INSPECTION A) HEADSPACE		6/4/01	RH
	B) TRIGGER PULL	<u>225</u> <u>227</u> <u>224</u> <u>231</u> <u>235</u>	6-4-01	RH
	C) FUNCTION		6/4/01	RH
660	PACK		8/16/01	RH

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

SERIAL NO. E6703518
DATE 5/3/01
TESTER DA

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.26	2.66		2.69	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.35	2.61		2.52	
PULL #3	2.50	2.63		2.57	
PULL #4	2.34	2.74		2.45	
PULL #5	2.56	2.63		2.57	
TOTAL	1201	1327		1280	
AVG.	2.40	2.65		2.56	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.08	3.00		
PULL #2	3.11	2.96		
PULL #3	3.16	3.16		
PULL #4	3.00	2.97		
PULL #5	2.98	2.90		
TOTAL	1533	1499		
AVG.	3.06	2.99		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.06	4.09		4.24
PULL #2	4.01	4.08		4.49
PULL #3	4.00	4.11		4.49
PULL #4	4.00	4.00		4.50
PULL #5	3.92	4.15		4.50
TOTAL	1999	2043		2222
AVG.	3.99	4.08		4.44

Remington Test Lab, Ilion, N.Y.

Centroidal distance calculations for Rifle # e6703518
11 May 2001

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: $-.053$
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: $-.2354$
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: $.241293$

THE AMR FOR THIS RIFLE IS: $.9018$

CENTROIDAL DISTANCES

Ø TO	1	.581489
1 TO	2	.508087
1 TO	3	.405153
1 TO	4	.584778
1 TO	5	.283129

2⁴ <----POA
3
5
1

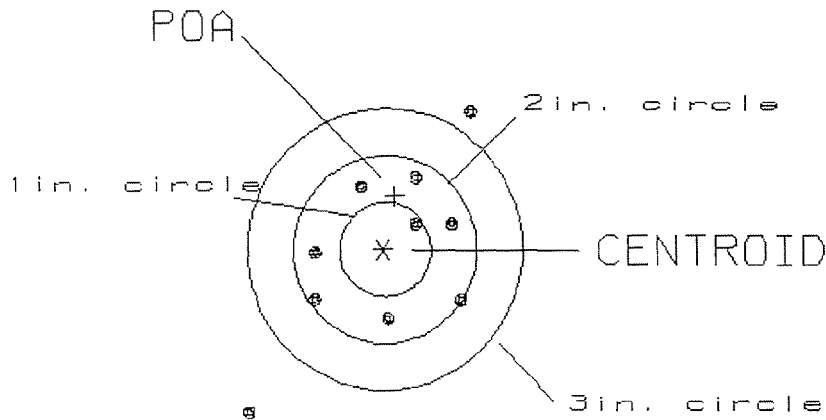
PATTERN #: 1

POA TO CENTROID: .581
 MIN RADIUS : .434
 MEAN RADIUS : 1.022
 MAX RADIUS : 2.256
 CENTROID X : -.129
 CENTROID Y : -.567

11 May 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/e6703518

CENTERFIRE PATTERN # 1



OF SHOTS= 10

IN CIRCLE

HS= 2.35

1

US= 3.25

8

GS= 4.01

8

PATTERN #: 2

POA TO CENTROID: .185

MIN RADIUS : .113

MEAN RADIUS : .731

MAX RADIUS : 1.812

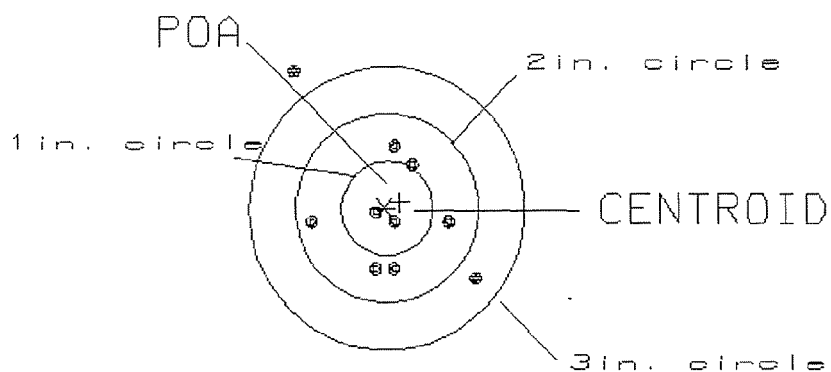
CENTROID X : -.175

CENTROID Y : -.061

11 May 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/e6703518

CENTERFIRE PATTERN # 2



OF SHOTS= 10

IN CIRCLE

HS= 1.94

3

VS= 2.27

6

GS= 2.99

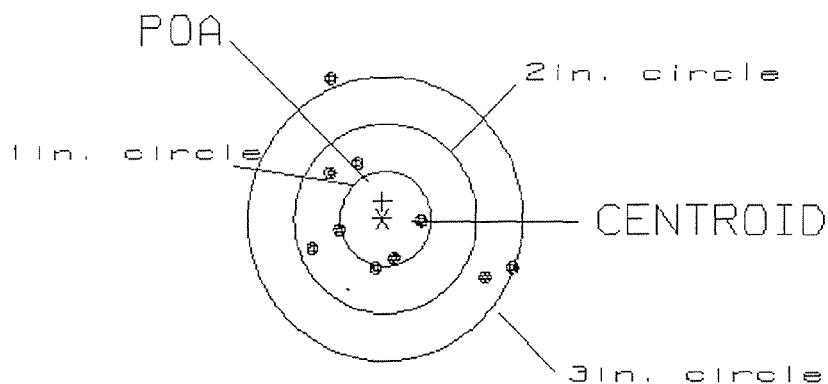
9

PATTERN #: 3
 POA TO CENTROID: .186
 MIN RADIUS : .374
 MEAN RADIUS : .848
 MAX RADIUS : 1.593
 CENTROID X : .006
 CENTROID Y : -.185

11 May 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/e6703518

CENTERFIRE PATTERN # 3



OF SHOTS= 10

IN CIRCLE

HS= 2.19

3

VS= 2.06

7

GS= 2.86

8

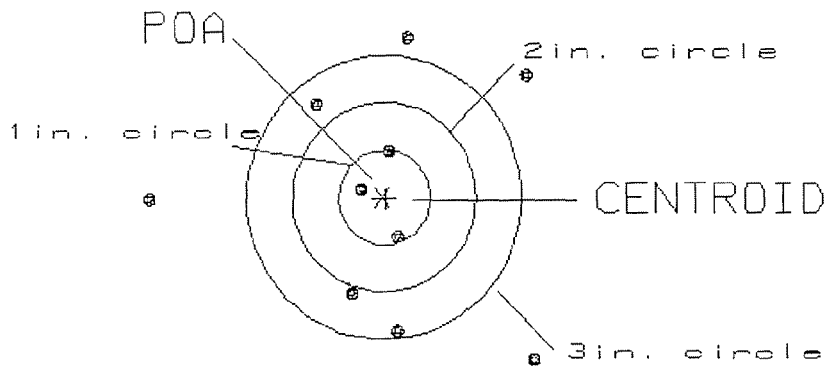
PATTERN #: 4

POA TO CENTROID: .048
 MIN RADIUS : .261
 MEAN RADIUS : 1.356
 MAX RADIUS : 2.503
 CENTROID X : -.047
 CENTROID Y : .012

11 May 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/e6703518

CENTERFIRE PATTERN # 4



OF SHOTS= 10

IN CIRCLE

HS= 4.15
 VS= 3.43
 GS= 4.50

3
 3
 6

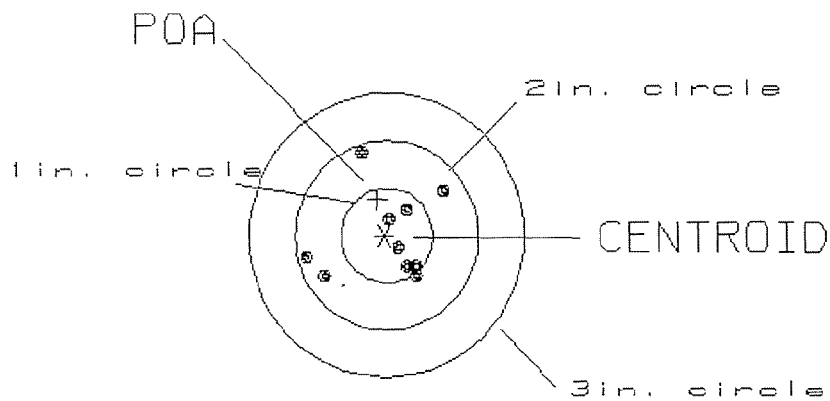
PATTERN #: ☐ 5 ☐

POA TO CENTROID: .385
 MIN RADIUS : .197
 MEAN RADIUS : .552
 MAX RADIUS : .941
 CENTROID X : .080
 CENTROID Y : -.376

11 May 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/e6703518

CENTERFIRE PATTERN # 5



OF SHOTS= 10

IN CIRCLE

HS= 1.44
 VS= 1.31
 GS= 1.60

5
 10
 10