

G669 5395
Replaces
E 670 3498

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: RE00146676

Serial: E6703498 Model M24 SWS Center Fire
Caliber: 7.62 NATO

Repairman:

Verify Repair

Status:

Closed 6/20/2008 8:51:08 AM

Address Information

Customer:

Received From

Return To:

Received From

Name: DEPT OF THE ARMY

DEPT OF THE ARMY

Address 1: HEADQUARTERS AND HEADQUARTERS CO

HEADQUARTERS AND HEADQUARTERS CO

Address 2: 1ST BN 5TH INFANTRY

PO Box:

1ST BN 5TH INFANTRY

PO Box:

City: FORT WRAINWRIGHT

FORT WRAINWRIGHT

State: AK

Zip Code: 99703

Country: US

State: AK

Zip Code: 99703

Country: US

FFL:

Contact / Condition

Problems

Estimate

History / Status

Shipping / Billing

Contact Information

Phone: NN

Fax:

Email:

Comments:

Received Condition

Fair

Condition
Notes:CSR
Notes:

Accessories Received

Code	Desc	Qty
A010	Hard Case	1
D000	SCOPE & SCOPE BAS	1

Repair Search

Refresh

Close

nagletj

6/20/2008

9:09 AM

CAPS

NUM

INS

SCRL

start

2 Internet Ex...

3 Microsoft O...

8 Microsoft O...

Arms Services ...

9:09 AM

Number:

E6703498

Model: M24 SWS



RE00146676

INSPECTION CHECKLIST - REPAIRS
CONTRACT #: W52H09-07-C-0207

R & E NUMBER	146626		
SERIAL NUMBER	5669 5395		
LOG-IN DATE	10-20-08		

OPERATION #	OPERATION NAME	DATE	INITIAL
500	DIS-ASSEMBLE GUN	6-24-08	RTZ
505	RE-BARREL		
420	ASSEMBLE	6-25-08	RSN
440	PROOF	6-25-08	SD
460	CHECK HEADSPACE	6-25-08	SD
470	DIS-ASSEMBLE GUN	6-25-08	RP
480	MAGNAFLUX	7-10-08	BH
510	DRILL AND TAP	7-7-08	TRW
500	ROLLMARK CALIBER	7/9/08	RT
520	GOFF BLAST BBL / REC	7/11/08	DG
530 & 540	APPLY COATINGS	7-15	CM
560	FINAL ASSEMBLY	7-17-08	RTZ
640	FUNCTION TEST AND	(PASS) FAIL	7-18-08 TRW
650	TARGET	(PASS) FAIL	7-18-08 TRW
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
670	FINAL INSPECTION	7-18-08	MED
	A) HEADSPACE	(PASS) FAIL	7-21-08 RTZ
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS 2.65 2.60 2.76 2.81 2787-21-08 RTZ	
680	F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX 6 6 6 7-21-08 RTZ	
	G) SAFETY OFF FORCE	2 LBS MIN 3 3 3 7-21-08 RTZ	
	I) FIRING PIN INDENT	.020 021 022 021 7-21-08 RTZ	
690	PACK	7/23/08 FM	

F006 REV 5/2006

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6695395.__0
FILE DATE AND TIME: 07/18/2008 12:17

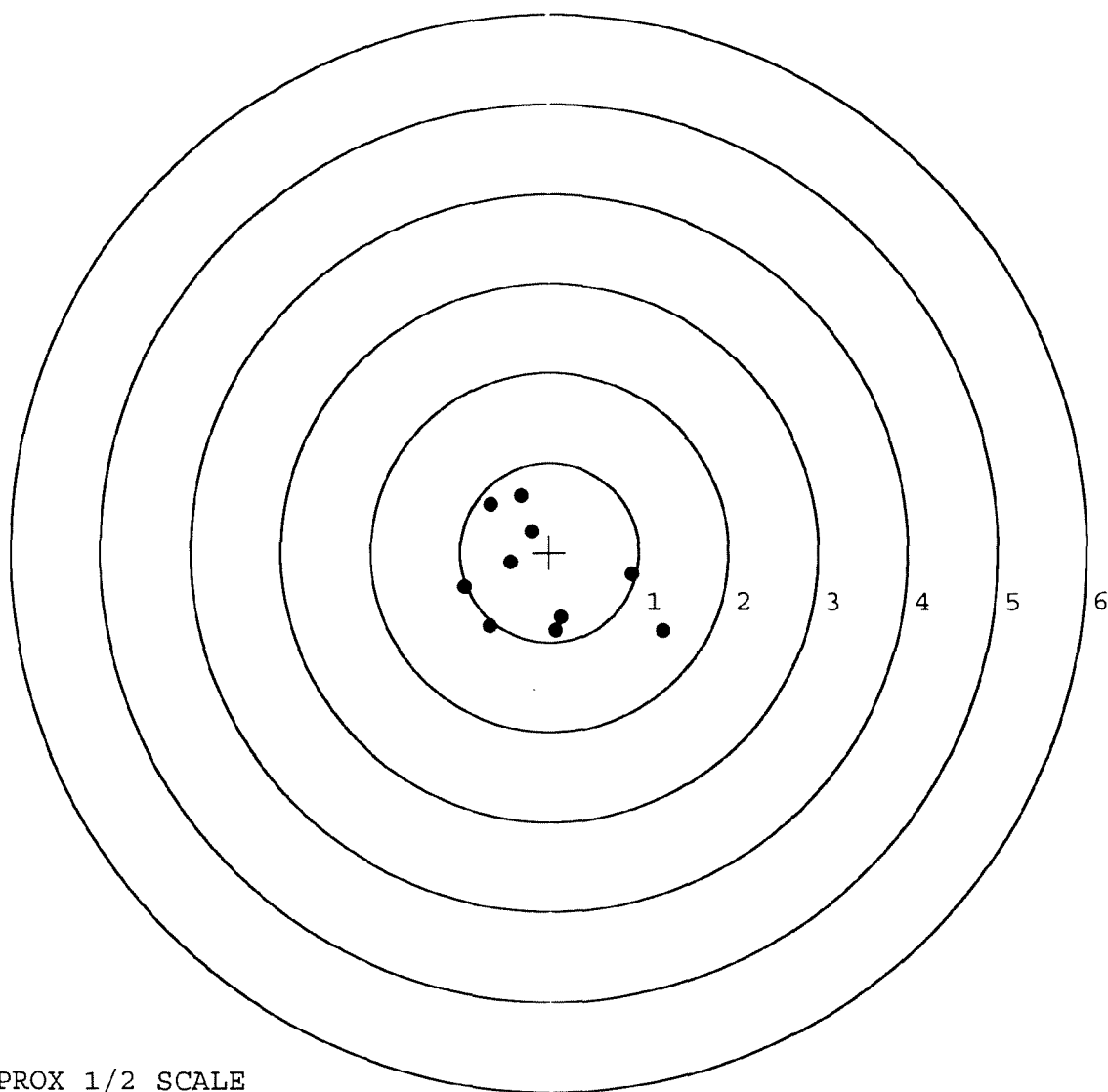
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.014
The Average Y Centroid of the Five Target Set:	-0.061
The Average Point of Impact of the Five Target Set:	0.063
The Average Mean Radius of the Five Target Set:	0.740
The Distance from POA to Centroid Target #1:	0.279
The Distance from Centroid Target #2 to Centroid Target #1:	0.328
The Distance from Centroid Target #3 to Centroid Target #1:	0.142
The Distance from Centroid Target #4 to Centroid Target #1:	0.346
The Distance from Centroid Target #5 to Centroid Target #1:	0.290

SERIAL NUMBER: G6695395. __0
TARGET NUMBER: 1
FILE DATE: 07/18/2008
FILE TIME: 12:17

POINT#	X	Y
1:	1.262	-0.882
2:	0.920	-0.248
3:	0.133	-0.730
4:	0.069	-0.874
5:	-0.670	-0.826
6:	-0.948	-0.388
7:	-0.440	-0.112
8:	-0.194	0.231
9:	-0.655	0.539
10:	-0.318	0.627

X CENTROID: -0.084
Y CENTROID: -0.266
POA TO CENTROID: 0.279
HORZ SPREAD: 2.210
VERT SPREAD: 1.509
GROUP SPREAD: 2.386
MIN RADIUS: 0.388
MAX RADIUS: 1.480
MEAN RADIUS: 0.811
IN 1 IN DIAMETER: 1
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10

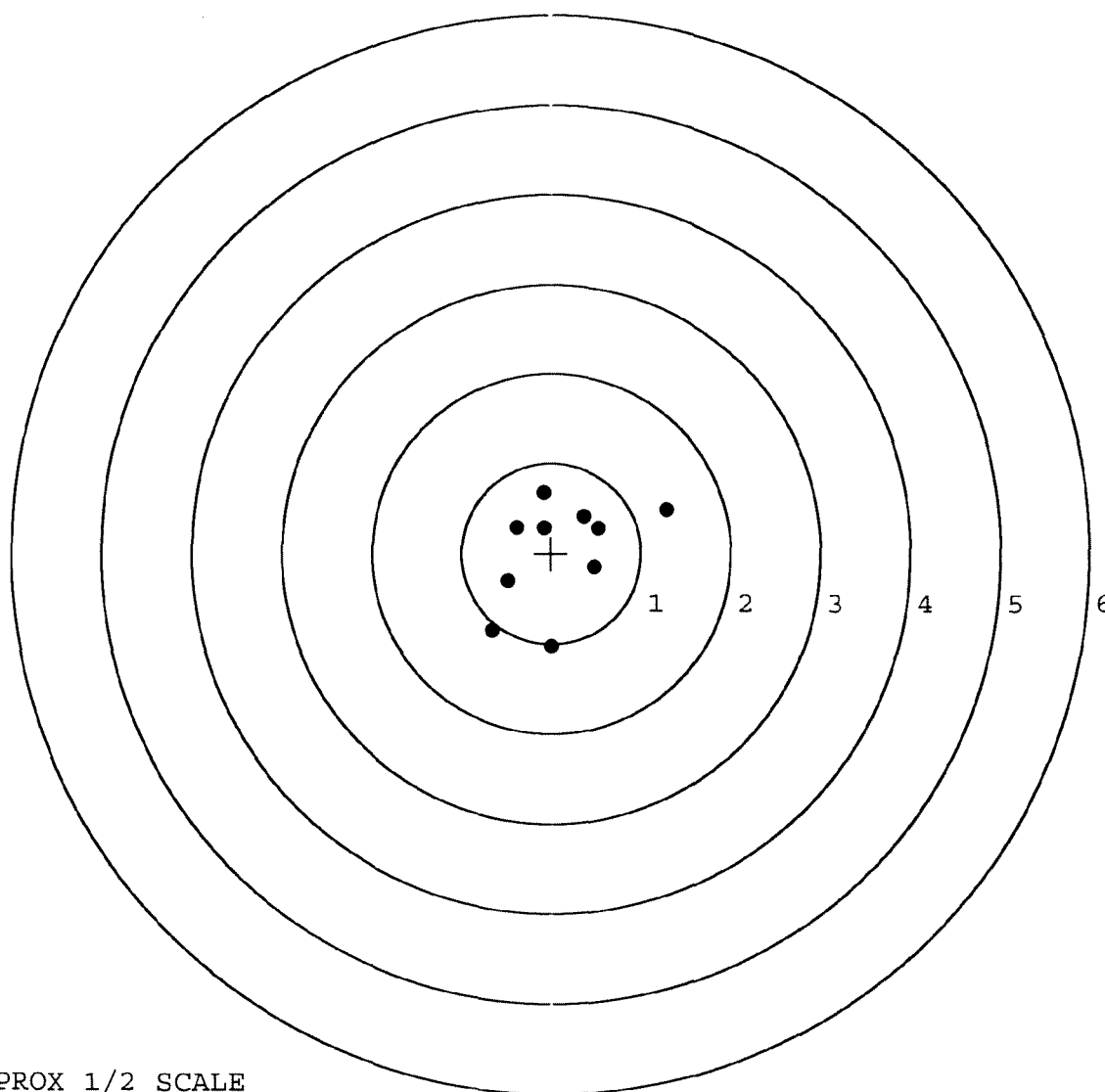


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6695395. __0
TARGET NUMBER: 2
FILE DATE: 07/18/2008
FILE TIME: 12:17

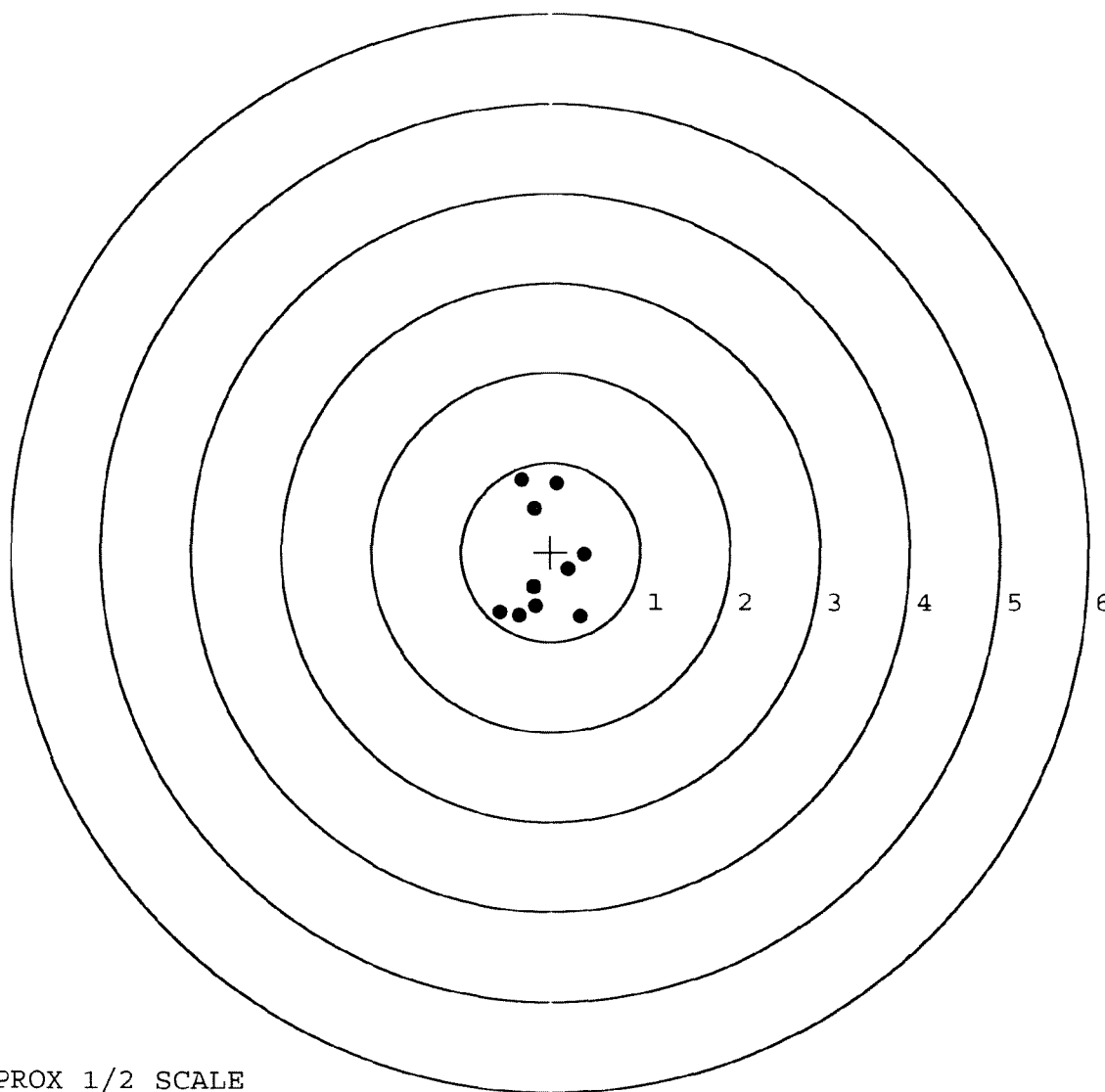
POINT#	X	Y
1:	1.284	0.485
2:	0.526	0.281
3:	0.363	0.408
4:	0.485	-0.148
5:	-0.082	0.673
6:	-0.081	0.283
7:	-0.390	0.287
8:	-0.484	-0.301
9:	-0.664	-0.855
10:	-0.002	-1.034

X CENTROID: 0.096
Y CENTROID: 0.008
POA TO CENTROID: 0.096
HORZ SPREAD: 1.948
VERT SPREAD: 1.707
GROUP SPREAD: 2.364
MIN RADIUS: 0.327
MAX RADIUS: 1.281
MEAN RADIUS: 0.712
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6695395. __ 0	POINT#	X	Y
TARGET NUMBER: 3	1:	0.328	-0.722
FILE DATE: 07/18/2008	2:	0.197	-0.187
FILE TIME: 12:17	3:	0.375	-0.028
	4:	0.073	0.767
X CENTROID: -0.082	5:	-0.184	0.489
Y CENTROID: -0.125	6:	-0.323	0.810
POA TO CENTROID: 0.149	7:	-0.188	-0.389
HORZ SPREAD: 0.943	8:	-0.169	-0.605
VERT SPREAD: 1.532	9:	-0.360	-0.709
GROUP SPREAD: 1.665	10:	-0.568	-0.671
MIN RADIUS: 0.285			
MAX RADIUS: 0.965			
MEAN RADIUS: 0.612			
# IN 1 IN DIAMETER: 4			
# IN 2 IN DIAMETER: 10			
# in 3 IN DIAMETER: 10			



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6695395. __0

TARGET NUMBER: 4

FILE DATE: 07/18/2008

FILE TIME: 12:17

POINT#	X	Y
1:	0.693	0.821
2:	0.222	0.752
3:	0.637	0.003
4:	0.338	-0.186
5:	-0.219	0.107
6:	-0.364	0.496
7:	-0.841	0.380
8:	-0.859	-0.049
9:	0.010	-0.599
10:	0.155	-0.987

X CENTROID: -0.023

Y CENTROID: 0.074

POA TO CENTROID: 0.077

HORZ SPREAD: 1.552

VERT SPREAD: 1.808

GROUP SPREAD: 1.886

MIN RADIUS: 0.199

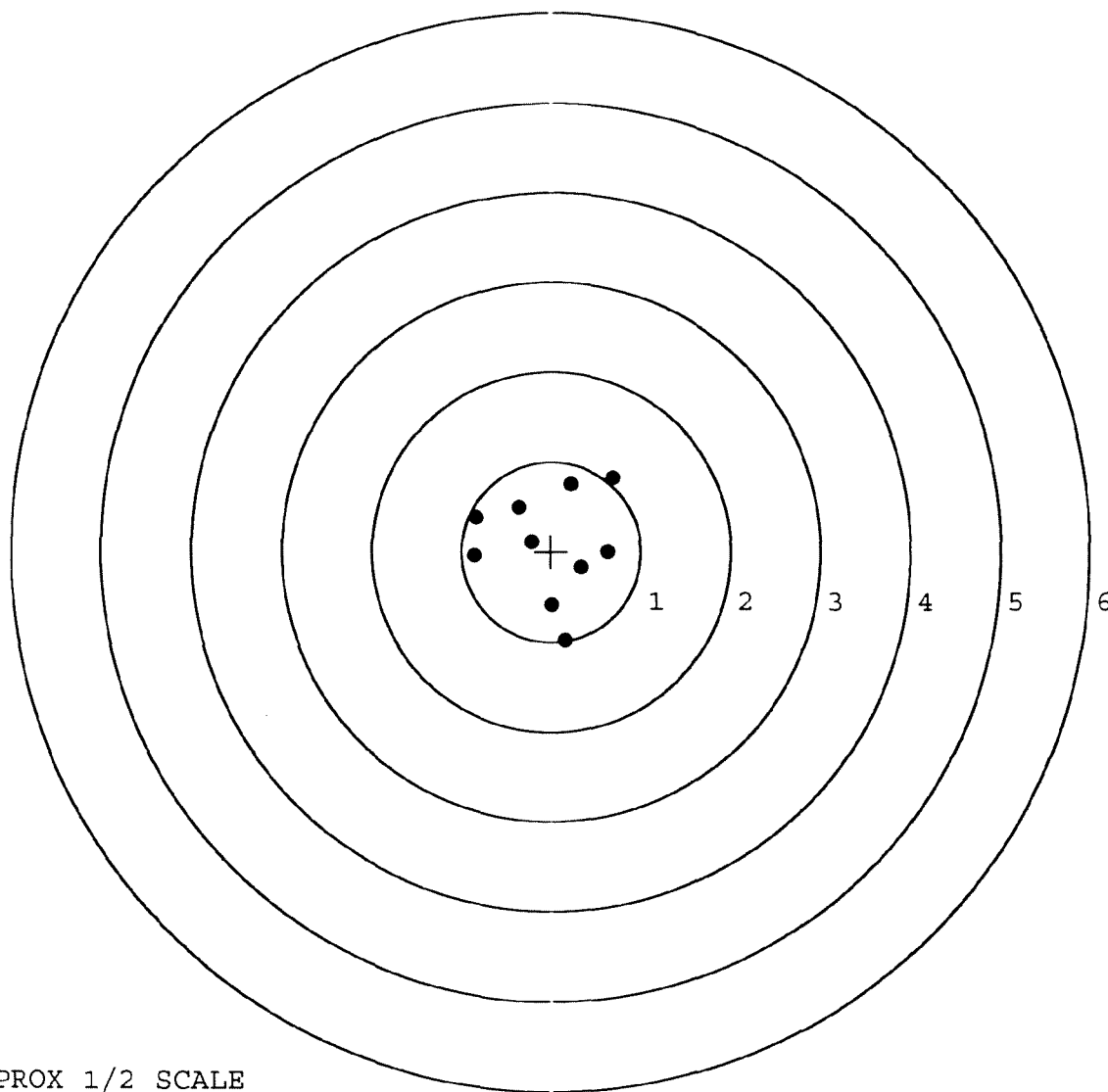
MAX RADIUS: 1.076

MEAN RADIUS: 0.707

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10

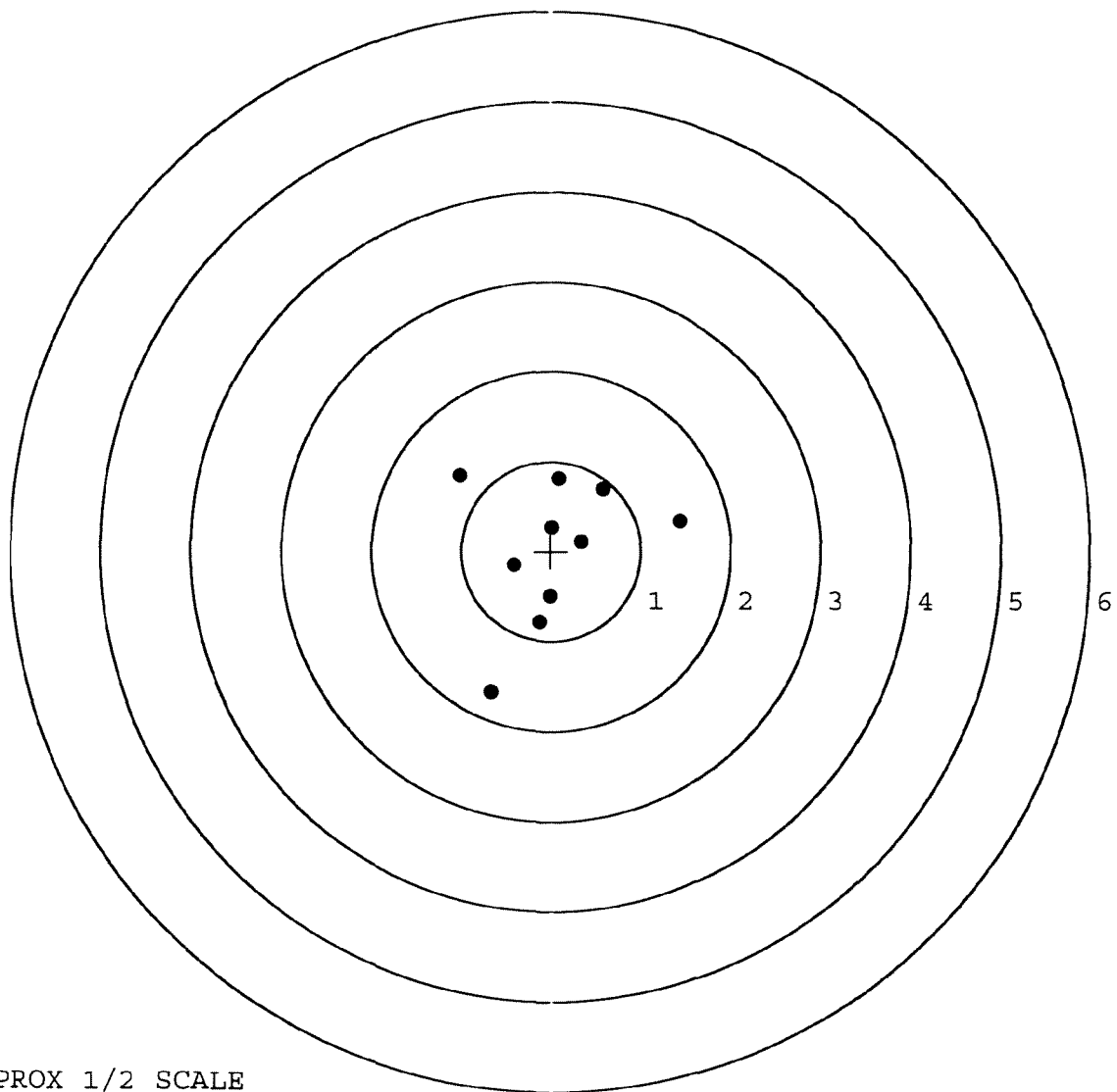


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6695395. __0
TARGET NUMBER: 5
FILE DATE: 07/18/2008
FILE TIME: 12:17

POINT#	X	Y
1:	1.430	0.339
2:	0.585	0.692
3:	0.089	0.808
4:	0.339	0.112
5:	0.017	0.267
6:	-1.016	0.840
7:	-0.408	-0.157
8:	-0.009	-0.502
9:	-0.131	-0.790
10:	-0.675	-1.572

X CENTROID: 0.022
Y CENTROID: 0.004
POA TO CENTROID: 0.022
HORZ SPREAD: 2.446
VERT SPREAD: 2.412
GROUP SPREAD: 2.843
MIN RADIUS: 0.263
MAX RADIUS: 1.723
MEAN RADIUS: 0.857
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

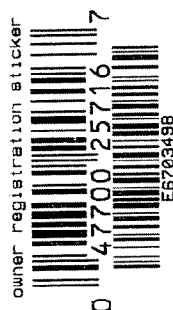
MODEL 700TH M24
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO

DOCUMENT ENVELOPE ASSEMBLY:

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

470 500 550 600 650 700 750 800 850 900 950 1000

46 FORM 1444

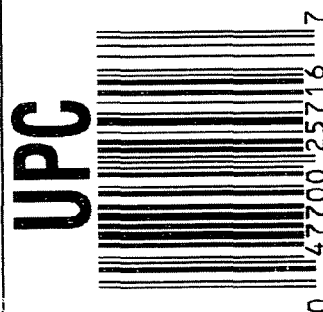


ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

E6703498



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**
E6703498

46
ORDER NO. **25716**

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



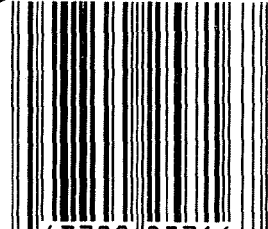
29EV

ORDER

25716

MODEL 700TH M24

UPC



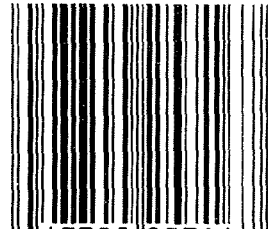
0 47700 25716 7

ORDER

25716

MODEL 700TH M24

UPC



0 47700 25716 7

SERIAL NO.



E6703498

Remington Test Lab, Ilion, N.Y.

Centroidal distance calculations for Rifle # E6703498
22 Aug 2001

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: $-.3662$
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: $.0128$
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: $.366424$

THE AMR FOR THIS RIFLE IS: 1.013

CENTROIDAL DISTANCES

Ø TO	1	.405561
1 TO	2	1.0586
1 TO	3	.776043
1 TO	4	.880548
1 TO	5	.560022

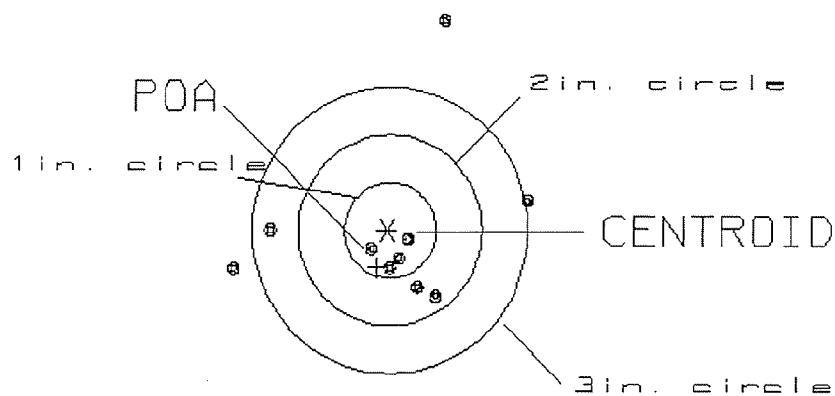
5	1	
4	+	<----POA
3		
2		

PATTERN #: ☐ 1 ☐
 POA TO CENTROID: .406
 MIN RADIUS : .187
 MEAN RADIUS : .954
 MAX RADIUS : 2.317
 CENTROID X : .104
 CENTROID Y : .392

22 Aug 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/E6703490

CENTERFIRE PATTERN # 1



OF SHOTS= 10

IN CIRCLE

HS= 3.20

4

VS= 2.94

6

GS= 3.43

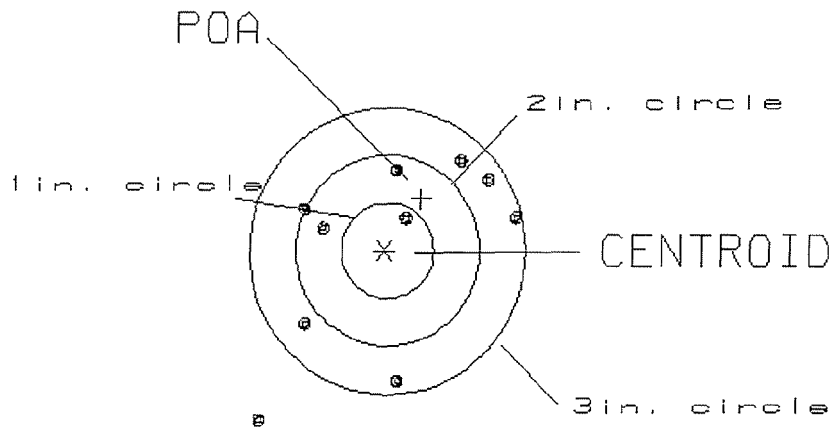
7

PATTERN #: □ 2 □
 POA TO CENTROID: .671
 MIN RADIUS : .403
 MEAN RADIUS : 1.153
 MAX RADIUS : 2.192
 CENTROID X : -.398
 CENTROID Y : -.540

22 Aug 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/E6703498

CENTERFIRE PATTERN # 2



OF SHOTS= 10

IN CIRCLE

HS= 2.77
 VS= 2.65
 GS= 3.51

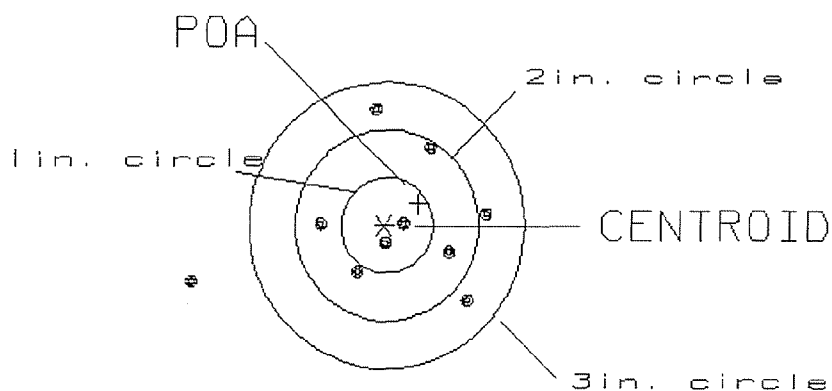
1
 4
 5

PATTERN #: ☐ 3 ☐
 POA TO CENTROID: .435
 MIN RADIUS : .198
 MEAN RADIUS : .897
 MAX RADIUS : 2.145
 CENTROID X : -.377
 CENTROID Y : -.217

22 Aug 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/E6703498

CENTERFIRE PATTERN # 3



OF SHOTS= 10

IN CIRCLE

HS= 3.14

2

VS= 1.99

6

GS= 3.21

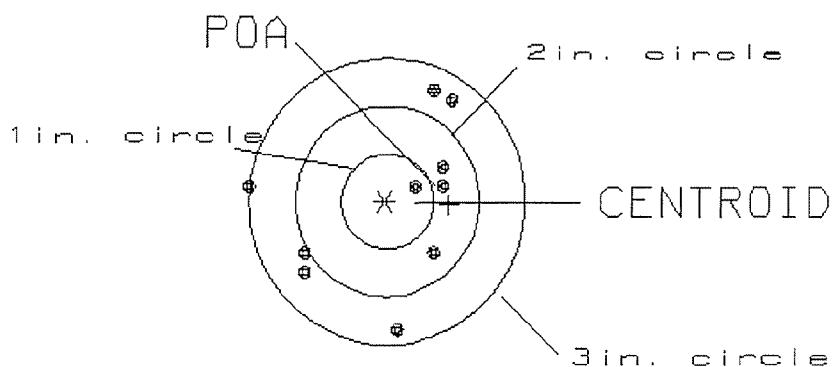
9

PATTERN #: ☐ 4 ☐
 POA TO CENTROID: .705
 MIN RADIUS : .348
 MEAN RADIUS : 1.005
 MAX RADIUS : 1.508
 CENTROID X : -.704
 CENTROID Y : .042

22 Aug 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/E6703498

CENTERFIRE PATTERN # 4



OF SHOTS= 10

IN CIRCLE

HS= 2.17

1

VS= 2.56

4

GS= 2.58

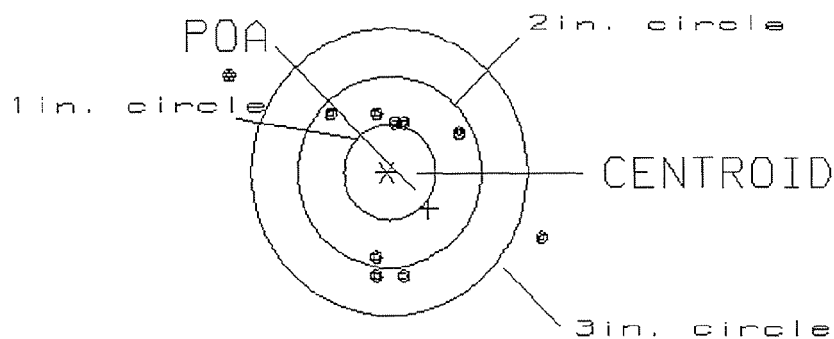
9

PATTERN #: ☐ 5 ☐
 POA TO CENTROID: .598
 MIN RADIUS : .542
 MEAN RADIUS : 1.054
 MAX RADIUS : 1.983
 CENTROID X : -.456
 CENTROID Y : .387

22 Aug 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/E6703498

CENTERFIRE PATTERN # 5



OF SHOTS= 10

IN CIRCLE

HS= 3.39

0

VS= 2.12

6

GS= 3.77

8

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

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

SERIAL NO. E6703498

DATE 5/14/01

TESTER RH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	234	233		232	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	240	234		241	
PULL #3	242	232		229	
PULL #4	241	228		250	
PULL #5	236	232		253	
TOTAL	1193	1159		1205	
AVG.	238	231		241	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	311	308		
PULL #2	307	302		
PULL #3	300	307		
PULL #4	312	314		
PULL #5	304	318		
TOTAL	1534	1549		
AVG.	306	309		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	410	428	2	431
PULL #2	417	407		406
PULL #3	417	408		434
PULL #4	402	418		427
PULL #5	414	413		447
TOTAL	2060	2074		2145
AVG.	412	414		429

GUN SERIAL # E 6703498

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		8/2/01	RHL
600	PROOF		8-2-01	RHL
607	CHECK HEADSPACE		8-2-01	RHL
610	DIS-ASSEMBLE GUN		8-2-01	RHL
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT		8-6-01	AR
615	ROLLMARK CALIBER		8-6-01	RHL
617	DRILL AND TAP SIGHT HOLES		8-6-01	BWT
618	POLISH BARREL		8-7-01	GD
620	APPLY COATINGS (BARREL ACTION)		8-8-01	TA
	(BOLT)		8-8-01	TA
625	FINAL ASSEMBLY			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		8-15-01	RHL
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		8-15-01	RHL
	C) INSPECT EJECTOR HOLE FOR CHAMFER		8-15-01	RHL
	D) OIL FIRING PIN ASSEMBLY		8-15-01	RHL
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE		8-15-01	RHL

OP #	OPERATION NAME	READINGS			DATE	INITIAL
625	F) SAFETY ON FORCE	<u>8.5</u>	<u>8.0</u>	<u>8.5</u>	8-22-01	DA
CONT.	G) SAFETY OFF FORCE	<u>3.0</u>	<u>2.5</u>	<u>3.0</u> OR DA	8-22-01	DA
	H) TRIGGER PULL TEST AND RETAINABILITY					
	I) FIRING PIN INDENT	<u>.023</u>	<u>.022</u>	<u>.022</u>	8-22-01	DA
	J) ASSEMBLE STOCK				8/2/01	RH
	K) ASSEMBLE SWIVEL STUDS				10-25-01	RH
	L) ATTACH FRONT AND REAR SIGHT ASSY'S				8-22-01	RH
	M) IRON SIGHT ALIGNMENT				8-22-01	RH
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER				8-22-01	RH
640	GALLERY TEST AND TARGET				8/21	RW
	A) MALFUNCTIONS				8/21	RW
	B) PIERCED PRIMERS				8/21	RW
645	INSPECT FOR LIVE AMMO				8/21-	RW
655	FINAL INSPECTION A) HEADSPACE				10-25-01	RH
	B) TRIGGER PULL	<u>2.32</u>	<u>2.29</u>	<u>2.18</u> <u>2.26</u> <u>2.20</u>	8-22-01	DA
	C) FUNCTION				10-25-01	RH
660	PACK				10-26-01	DA