

C6348953

Secret Service

MODEL 700™ M24

Model **SWS**™

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

Remington

Remington[®] **DUPONT** REG. U.S. PAT. & TM. OFF.

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

MODEL 700TM M24

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

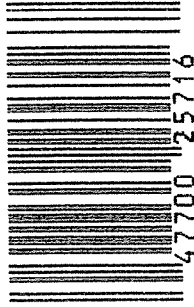
SERIAL NO. C6048953

ORDER NO. 5716



5716 C6048953

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6348953

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	8 30	89	DW
600	Proof	8 30	89	DW
607	Check Headspace	8 30	89	DW
610	Dis-assemble Gun	8 30	89	DW
612	Magnaflux Barrel Action		8/31/89	KCR
	Magnaflux Bolt		8/31/89	KCR
615	Rollmark Caliber		8/31/89	G.S.
7	Drill and Tap Sight Holes	9 1	89	FE
618	Polish Barrel RB	9 1	89	ST
620	Apply Coatings (Barrel Action)		9-7-89	ISA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		9/8/89	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		9/8/89	RW
	C) Inspect Ejector Hole for Chamfer		9/8/89	RW
	D) Oil Firing Pin Ass'y		9/8/89	RW
	E) Adjust Trigger Pull to Min Setting and Stake		9-8-89	JH

op. #	NAME BARBER - M24 0042474	READINGS			DATE	INIT
625 cont.	F) Safety On Force	5 1/2	5 3/4	5 1/2	9/8/89	WB
	G) Safety Off Force	7 1/2	7 3/4	7 3/4	9/8/89	WB
	H) Trigger Pull Test & Retainability				9-8-89	SL
	I) Firing Pin Indent	.020	.0205	.020	9/8/89	WB
	J) Assemble Stock				9/11/89	RW
	K) Assemble Swivel Studs				12 Sep 89	JS
	L) Attach Front and Rear Sight Assemblies				9/11/89	RW
	M) Iron Sight Alignment				9/11/89	RW
	N) Detach Front & Rear Sights & place in numbered container				9/11/89	RW
	O) Attach Scope to Rifle				9/11/89	WB
	P) Detach & Attach Scope 20 Times				9/11/89	WB
640	Gallery Target & Test	72R	78L		9-11-89	DH
	A) Time				9-11-89	DH
	B) Malfunctions				9-11-89	DH
	C) Pierced Primers				9-11-89	DH
	D) Optical Clarity of Scope				9-11-89	DH
645	Inspect for Live Ammo				9-11-89	DH
655	Final Inspection A) Headspace				12 Sep 89	JS
	B) Trigger Pull	2.82	2.86	2.79	12 Sep 89	JS
	C) Function				12 Sep 89	JS
660	Pack				25 Sept 89	WB

9/12/89

Marking for Secret Service Gun 1 Gun

UNIT PACK - GUN

1005-01-240-2136

1 EA

C (10) 9/89

WT 63.9 CU 6.2

DAAA21-87-G-0001-0001

RAC INC

ILION NY 13357

PAKET

1005-01-240-2136

1 EA

C (10) 9/89

WT ? CU ?

DAAA21-87-G-0001-0001

RAC INC

ILION NY 13357

UNIT PACK - SOFT CASE

1005-01-262-2818

1 EA

C (10) 9/89

WT 4 CU 2

DAAA21-87-G-0001-0001

RAC INC

ILION NY 13357

NO - ?

FSCM 3A703 M4P/W

SOFT CASE 96076

NOTE

No tag on Case

itself only on Box

ORDER FOR SUPPLIES OR SERVICES				Form Approved OMB No. 0704-0187 Expires Jul 31, 1989		PAGE 1 OF 2	
1. CONTRACT/PURCH ORDER NO. DAAA218760001		2. DELIVERY ORDER NO. 0001-		3. DATE OF ORDER. 06/15/89		4. REQUISITION/PURCH REQUEST NO. 1A92VP611ANG01	
6. ISSUED BY US Army AMCCOM AMSMC-PCW-B(1D), Bldg. 10 Picatinny Arsenal, NJ 07806-5000 J. McDonough (JACK)		CODE W15GKN04		7. ADMINISTERED BY DCASMA Syracuse U.S. Courthouse and Fed. Bldg. 100 South Clinton Street Syracuse, NY 13260-0115		CODE s3306a	
9. CONTRACTOR NAME AND ADDRESS REMINGTON ARMS CO., INC. 14 HOEFLER AVE. ILION, NY 13357-		CODE 00004279		FACILITY CODE		10. DELIVER TO FOB POINT BY 06/30/89	
		C 6348953 8 Digs-?		12. DISCOUNT TERMS 0 % 0 Net 0		11. MARK IF BUS. IS [X] SMALL [] SMALL DISADVANTAGED [] WOMEN-OWNED	
				13. MAIL INVOICES TO			
14. SHIP TO SEE SCHEDULE DAAA218760001/0001		CODE W15BW901		15. PAYMENT WILL BE MADE BY DCASR Boston 495 Summer Street Boston, MA 02210-2184		CODE s2202a	
						MARK ALL PACKAGES AND PAPERS WITH CONTRACT OR ORDER NUMBER	
16. DELIVERY ☒ This delivery order is issued on another Government agency or in accordance with and subject to terms and conditions of above numbered contract.							
PURCHASE ☐ Reference your _____ furnish the following on terms specified herein.							
ACCEPTANCE. THE CONTRACTOR HEREBY ACCEPTS THE OFFER REPRESENTED BY THE NUMBERED PURCHASE ORDER AS IT MAY PREVIOUSLY HAVE BEEN OR IS NOW MODIFIED, SUBJECT TO ALL OF THE TERMS AND CONDITIONS SET FORTH, AND AGREES TO PERFORM THE SAME.							
NAME OF CONTRACTOR _____ SIGNATURE _____ TYPED NAME AND TITLE _____ DATE SIGNED _____ ☐ If this box is marked, supplier must sign Acceptance and return the following number of copies:							
17. ACCOUNTING AND APPROPRIATION DATA/LOCAL USE 2191408900P9999993123S99999 Doc # 203A53 91249037 to Accountant							
18. ITEM NO.	19. SCHEDULE OF SUPPLIES/SERVICE	20. QUANTITY ORDERED/ACCEPTED*	21. UNIT	22. UNIT PRICE	23. AMOUNT		
0143AA	stock no 1-240-2136 doc 203a5j 9037 niin 01-240-2136 ser 0005 REQ 9-180-13-006 CL 3123 PLEASE PHONE 24 HRS PRIOR TO DELIVERY: US SECRET SERVICE JJ ROWLEY TRAINING CENTER 9200 POWDER MILL ROAD, R-2 LAUREL, MD 20707 ATTN: GUS AUGUSTYN 301 344 8530 Sniper Weapon System, P/N 96209	1	EA	4003.000000	4003.00		
*If quantity accepted by the Government is same as quantity ordered, indicate by x. If different, enter actual quantity accepted below quantity ordered and encircle.		24. UNITED STATES OF AMERICA BY: HARRY SANTA HARRY SANTA CONTRACTING/ORDERING OFFICER			25. TOTAL 4003.00		
26. QUANTITY IN COLUMN 20 HAS BEEN [] INSPECTED [] RECEIVED [] ACCEPTED AND CONFORMS TO THE CONTRACT EXCEPT AS NOTED DATE _____ SIGNATURE OF AUTHORIZED GOVERNMENT REP. _____		27. SHIP. NO.		28. D.O. VOUCHER NO.		29. DIFFERENCES	
36. I certify this account is correct and proper for payment DATE _____ SIGNATURE AND TITLE OF CERTIFYING OFFICER _____		31. PAYMENT [] COMPLETE [] PARTIAL [] FINAL		32. PAID BY over		33. AMT VERIFIED CORRECT FOR	
						34. CHECK NUMBER	
						35. BILL OF LADING NO.	
37. REC'D AT	38. RECEIVED BY	39. DATE REC'D	40. TOTAL CONT.	41. S/R ACCOUNT NUMBER		42. S/R VOUCHER NO.	

39

4

67.9

82

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

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

SERIAL NO. C6348953DATE 9-8-89TESTER JM

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.53	2.55	2.42	2.82	MIN. SETTING,
PULL #2	2.50	2.55	2.33	2.86	NO AVG. OF 5
PULL #3	2.53	2.50	2.45	2.79	READINGS ACCEPT-
PULL #4	2.51	2.56	2.50	2.86	ABLE LESS THAN 2#
PULL #5	2.45	2.48	2.40	2.88	
TOTAL	12.52	12.64	12.10	14.21	
AVG.	2.504	2.528	2.42	2.842	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.43	3.45		
PULL #2	3.42	3.40		
PULL #3	3.43	3.50		
PULL #4	3.52	3.43		
PULL #5	3.46	3.42		
TOTAL	17.26	17.20		
AVG.	3.452	3.44		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.14	4.54		4.17
PULL #2	4.24	4.58		4.16
PULL #3	3.93	4.39		4.57
PULL #4	4.10	4.24		4.20
PULL #5	4.17	4.23		4.41
TOTAL	20.58	21.98		21.51
AVG.	4.116	4.396		4.302

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06348953
12 Sep 1989

CENTROIDAL DISTANCES

0 TO	1	.308087
1 TO	2	.558089
1 TO	3	.329876
1 TO	4	.362684
1 TO	5	1.24425

$\frac{1}{5}$ ⁵ <----POA

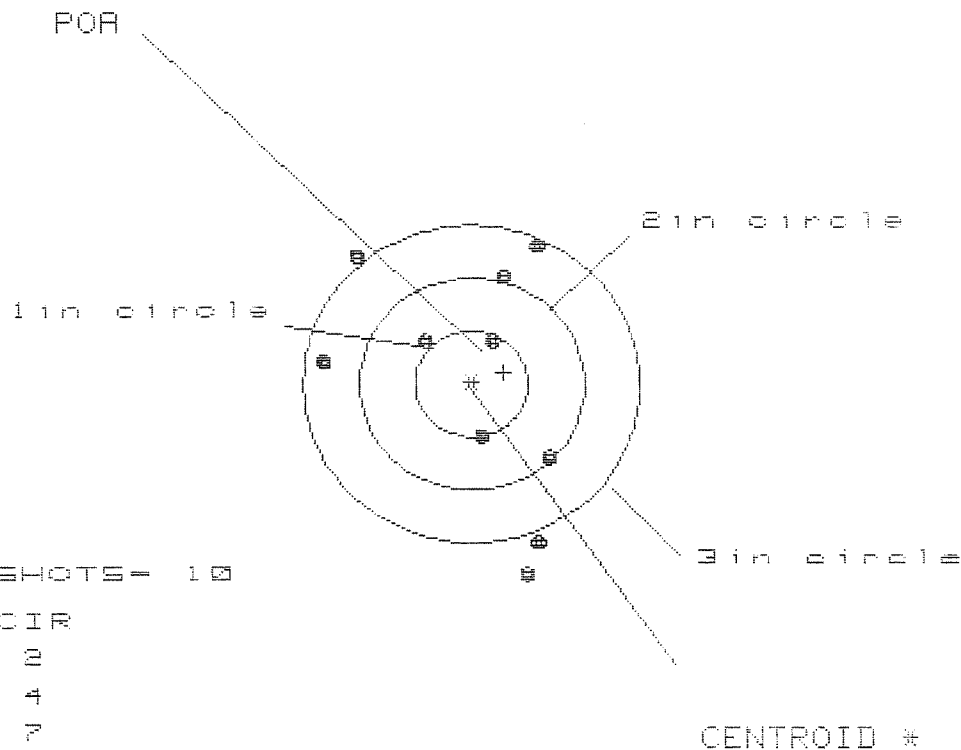
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1732
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0552
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .181784
THE AMR FOR THIS RIFLE IS: 1.047

11 Sep 1989

FILE:/PATTERNING/CENTERFIRE_PATT/06346853

CENTERFIRE PATTERNS

1



OF SHOTS= 10

IN CIR

1 in = 2

2 in = 4

3 in = 7

HS= 2.007

VS= 3.033

GS= 3.271

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.661	.713	.791
MINIMUM X	-1.346	-1.294	-1.216
MAXIMUM Y	1.285	1.091	.882
MINIMUM Y	-1.748	-1.675	-1.137
CENTROID X	-.286	-.338	-.416
CENTROID Y	-.109	.085	.294
POA TO CENTROID in.	.307	.348	.509
MIN RADIUS	.476	.347	.315
MEAN RADIUS	1.127	1.022	.896
MAX RADIUS	1.808	1.787	1.385
HORIZONTAL SPREAD	2.007	2.007	2.007
VERTICAL SPREAD	3.033	2.766	2.019
EXTREME SPREAD	3.271	3.090	2.541
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	7		

11 Sep 1989

FILE:/PATTERNING/CENTERFIRE_PATT/06340353

CENTERFIRE PATTERNS

2

POA

1 in circle

2 in circle

3 in circle

OF SHOTS= 10

IN CIR

1 in = 1

2 in = 5

3 in = 6

HS= 3.051

VS= 2.341

GS= 3.267

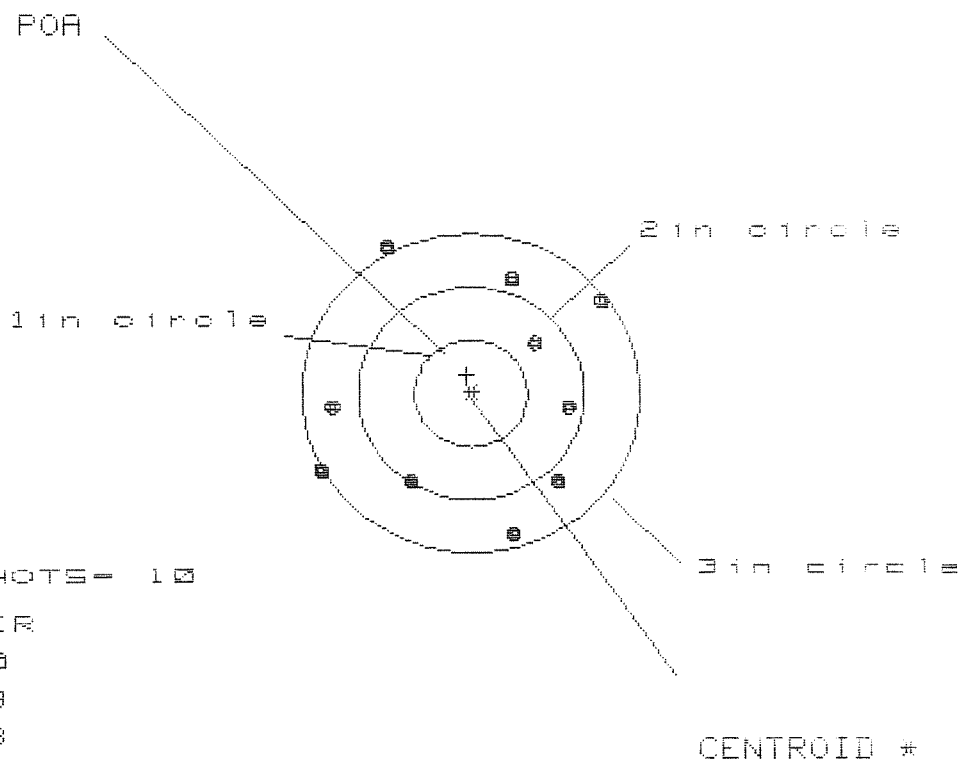
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.533	1.702	1.081
MINIMUM X	:	-1.518	-1.348	-1.135
MAXIMUM Y	:	1.004	.803	.808
MINIMUM Y	:	-1.337	-1.225	-1.220
CENTROID X	:	.235	.065	-.148
CENTROID Y	:	.091	-.021	-.026
POA TO CENTROID in.	:	.252	.068	.150
MIN RADIUS	:	.409	.596	.439
MEAN RADIUS	:	1.129	1.044	.938
MAX RADIUS	:	1.832	1.703	1.258
HORIZONTAL SPREAD	:	3.051	3.050	2.216
VERTICAL SPREAD	:	2.341	2.028	2.028
EXTREME SPREAD	:	3.267	3.059	2.280
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		6	

11 Sep 1989

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CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1 in = 0

2 in = 3

3 in = 8

HS= 2.515

VS= 2.698

GS= 2.973

PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	1.138
MINIMUM X	-1.377
MAXIMUM Y	1.408
MINIMUM Y	-1.290
CENTROID X	.037
CENTROID Y	-.176
POA TO CENTROID in.	.180
MIN RADIUS	.716
MEAN RADIUS	1.195
MAX RADIUS	1.587
HORIZONTAL SPREAD	2.515
VERTICAL SPREAD	2.698
EXTREME SPREAD	2.973
NUMBER IN ONE INCH CIRCLE =	0
NUMBER IN TWO INCH CIRCLE =	3
NUMBER IN THREE INCH CIRCLE =	8

11 Sep 1989

FILE:/PATTERNING/CENTERFIRE_PATT/06346353

CENTERFIRE PATTERNS

4

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS= 10

IN CIR

1 in = 0

2 in = 4

3 in = 8

HS= 2.587

VS= 2.317

GS= 2.586

PATTERN #	:	4
SHOTS (BEST OF)	:	10
MAXIMUM X	:	1.350
MINIMUM X	:	-1.237
MAXIMUM Y	:	1.012
MINIMUM Y	:	-1.305
CENTROID X	:	.046
CENTROID Y	:	.037
POA TO CENTROID in.	:	.059
MIN RADIUS	:	.679
MEAN RADIUS	:	1.113
MAX RADIUS	:	1.540
HORIZONTAL SPREAD	:	2.587
VERTICAL SPREAD	:	2.317
EXTREME SPREAD	:	2.596
NUMBER IN ONE INCH CIRCLE	=	0
NUMBER IN TWO INCH CIRCLE	=	4
NUMBER IN THREE INCH CIRCLE	=	8

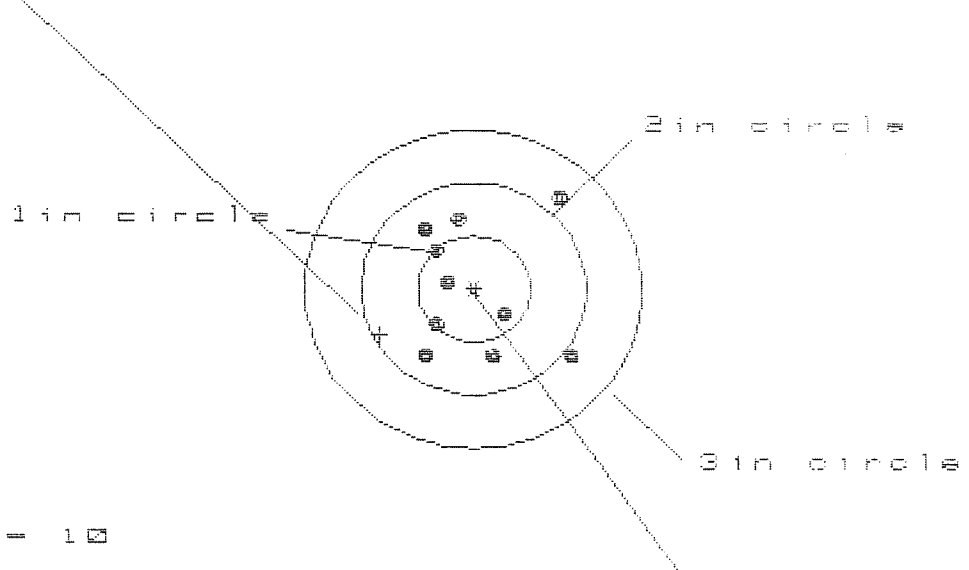
01 Sep 1989

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CENTERFIRE PATTERNS

5

POA



OF SHOTS= 10

IN CIR

1 in = 2

2 in = 8

3 in = 10

HS= 1.338

VS= 1.437

GS= 1.923

CENTROID *

PATTERN #	:	5	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.861	.950	.473
MINIMUM X	:	-.477	-.388	-.270
MAXIMUM Y	:	.819	.780	.716
MINIMUM Y	:	-.618	-.527	-.591
CENTROID X	:	.834	.745	.627
CENTROID Y	:	.433	.342	.406
POA TO CENTROID in.	:	.940	.820	.747
MIN RADIUS	:	.287	.251	.124
MEAN RADIUS	:	.671	.598	.515
MAX RADIUS	:	1.146	1.080	.719
HORIZONTAL SPREAD	:	1.338	1.338	.743
VERTICAL SPREAD	:	1.437	1.387	1.367
EXTREME SPREAD	:	1.923	1.728	1.348
NUMBER IN ONE INCH CIRCLE =	:	2		
NUMBER IN TWO INCH CIRCLE =	:	8		
NUMBER IN THREE INCH CIRCLE =	:	10		