

C6522238

MODEL 700™ N24

Model SWS™

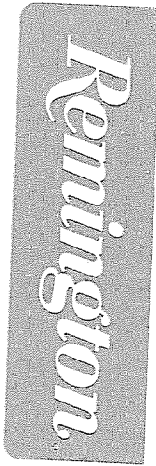
Action

Barrel Length

Capacity

Order No. 5716

* Includes 1 in chamber.



CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C 6522238

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		7/9/90	KQ
600	Proof		7/9/90	KQ
607	Check Headspace		7/9/90	KQ
610	Dis-assemble Gun		7/9/90	KQ
612	Magnaflux Barrel Action		7/17/90	KR
	Magnaflux Bolt		7/17/90	KR
615	Rollmark Caliber		7/17/90	RLS
617	Drill and Tap Sight Holes		7/23/90	FB
618	Polish Barrel RB		7/24/90	WB
620	Apply Coatings (Barrel Action)		7-6-90	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/16/90	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/16/90	KS
	C) Inspect Ejector Hole for Chamfer		8/16/90	KS
	D) Oil Firing Pin Ass'y		8/16/90	KS
	E) Adjust Trigger Pull to Min Setting and Stake		9-13-90	RL

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			8/14/90	JK
	G) Safety Off Force	3	3	3			8/14/90	JK
	H) Trigger Pull Test & Retainability						9-13-90	JK
	I) Firing Pin Indent	.022	.0225	.0225			8/14/90	JK
	J) Assemble Stock						8/17/90	KS
	K) Assemble Swivel Studs						9/14/90	JK
	L) Attach Front and Rear Sight Assemblies						8/17/90	KS
	M) Iron Sight Alignment						8/17/90	KS
	N) Detach Front & Rear Sights & place in numbered container						8/17/90	KS
	O) Attach Scope to Rifle						8/17/90	KS
	P) Detach & Attach Scope 20 Times						8/17/90	KS
640	Gallery Target & Test						8-20-90	JK
	A) Time						"	JK
	B) Malfunctions						"	JK
	C) Pierced Primers						"	JK
	D) Optical Clarity of Scope						"	JK
645	Inspect for Live Ammo						8-20-90	JK
655	Final Inspection							
	A) Headspace						9/14/90	JK
	B) Trigger Pull	2.50	2.42	2.45	2.45	2.45	9-13-90	JK
	C) Function						9/14/90	JK
560	Pack						9-18-90	JK

MOD. _____ GA. _____ GUN# C6524738
CAL. _____ #

# TEST	DATE	MALFUNCTION/DEFECT	ASSEM. #
	1st	Bolt Rel.	KS
	2nd	Changed Bolt Rel. (WAS BEST)	KS KS
	3rd		
	4th		
		FUNCTION	RD 6654 Rev 1

TEST INIT. ACTION TO CORRECT		ASSEM. #
PROOF		
TEST		
TGT		
PROOF		
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		

SWS TRIGGER PULL TEST

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

SERIAL NO. C6522238

DATE 9-13-90

TESTER JP

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.30	2.50	2.35	2.50	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.15	2.50	2.30	2.42	
PULL #3	2.18	2.37	2.21	2.45	
PULL #4	2.16	2.35	2.37	2.45	
PULL #5	2.46	2.40	2.43	2.45	
TOTAL	11.25	12.12	11.66	12.27	
AVG.	2.25	2.424	2.332	2.454	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.39	3.44		
PULL #2	3.40	3.47		
PULL #3	3.43	3.33		
PULL #4	3.33	3.33		
PULL #5	3.48	3.48		
TOTAL	17.03	17.05		
AVG.	3.406	3.41		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.38	4.21		4.35
PULL #2	4.50	4.29		4.34
PULL #3	4.50	4.35		4.42
PULL #4	4.49	4.46		4.37
PULL #5	4.35	4.30		4.42
TOTAL	22.22	21.61		21.90
AVG.	4.444	4.322		4.38

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6522238
21 Aug 1990

CENTROIDAL DISTANCES

0 TO	1	.168027
1 TO	2	.224956
1 TO	3	1.10376
1 TO	4	.496049
1 TO	5	.0817435

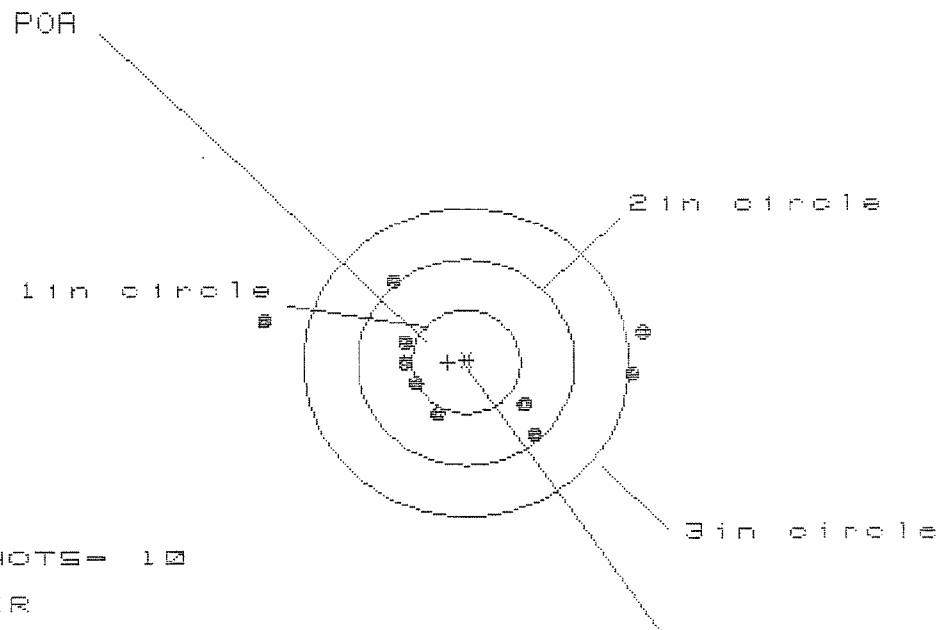
$\bar{x}$ $\bar{y}$ <----POB

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1102
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0468
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .119726
THE AMR FOR THIS RIFLE IS: .7464

28 Aug 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6522238

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 5

3 in = 7

HS= 3.554

VS= 1.520

GS= 3.555

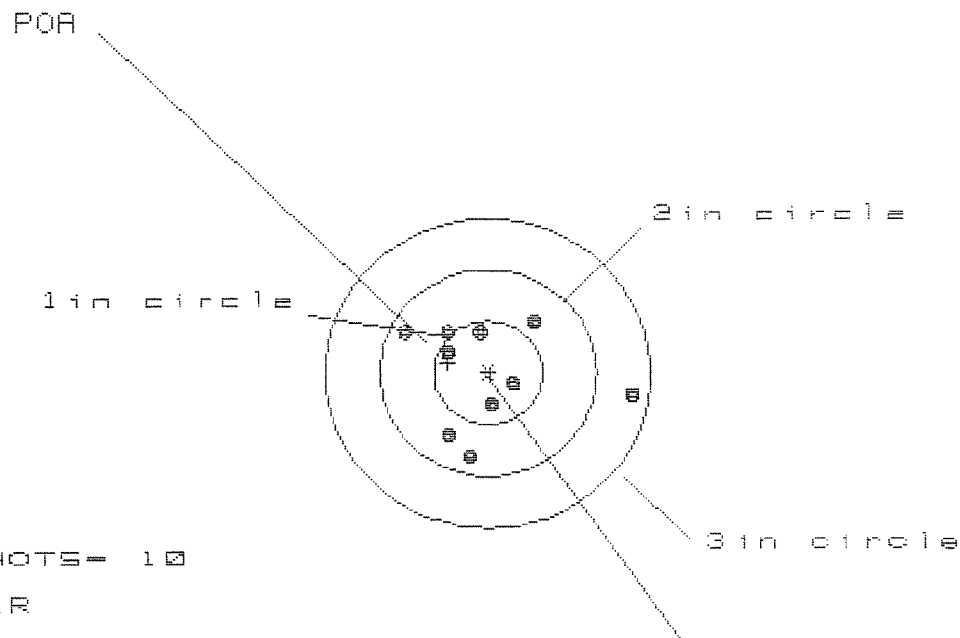
CENTROID #

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.639	1.426	1.496
MINIMUM X	:	-1.915	-.903	-.724
MAXIMUM Y	:	.822	.871	.920
MINIMUM Y	:	-.698	-.649	-.600
CENTROID X	:	.168	.381	.202
CENTROID Y	:	.003	-.046	-.095
POR TO CENTROID in.	:	.168	.383	.224
MIN RADIUS	:	.498	.493	.482
MEAN RADIUS	:	1.000	.906	.788
MAX RADIUS	:	1.966	1.479	1.496
HORIZONTAL SPREAD	:	3.554	2.329	2.220
VERTICAL SPREAD	:	1.520	1.520	1.520
EXTREME SPREAD	:	3.555	2.391	2.391
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		7	

28 Aug 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6522238

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 4

2in = 9

3in = 10

HS= 2.067

VS= 1.209

GS= 2.159

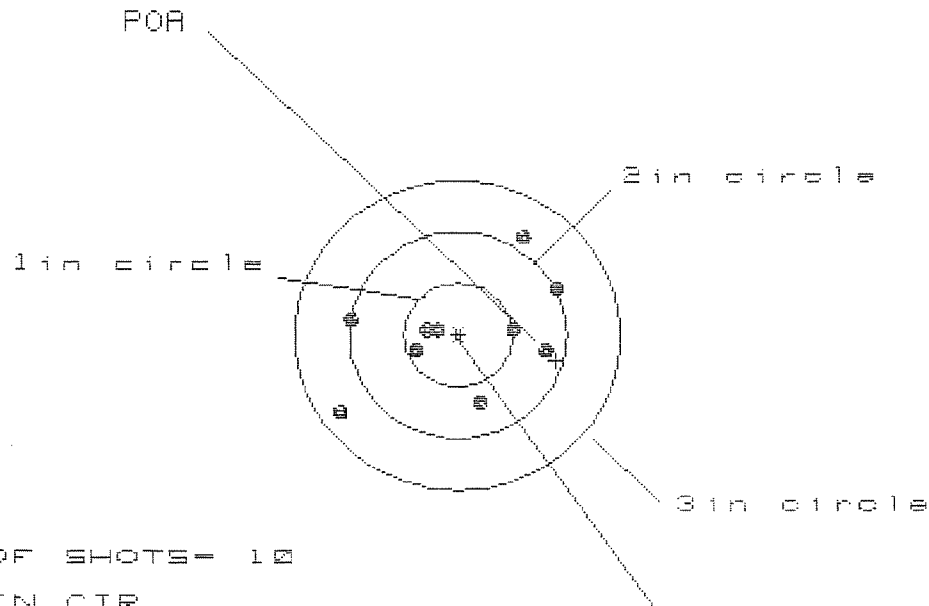
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.327	.577	.503
MINIMUM X	:	-.740	-.593	-.302
MAXIMUM Y	:	.455	.435	.488
MINIMUM Y	:	-.754	-.774	-.721
CENTROID X	:	.370	.223	.297
CENTROID Y	:	-.096	-.076	-.129
POA TO CENTROID in.	:	.383	.236	.324
MIN RADIUS	:	.244	.281	.259
MEAN RADIUS	:	.610	.517	.486
MAX RADIUS	:	1.339	.774	.724
HORIZONTAL SPREAD	:	2.067	1.170	.805
VERTICAL SPREAD	:	1.209	1.209	1.209
EXTREME SPREAD	:	2.159	1.343	1.333
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		9	
NUMBER IN THREE INCH CIRCLE	=		10	

28 Aug 1998

FILE:/PATTERNING/CENTERFIRE_PATT/06522238

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1in = 4

2in = 8

3in = 10

HS= 1.951

VS= 1.755

GS= 2.406

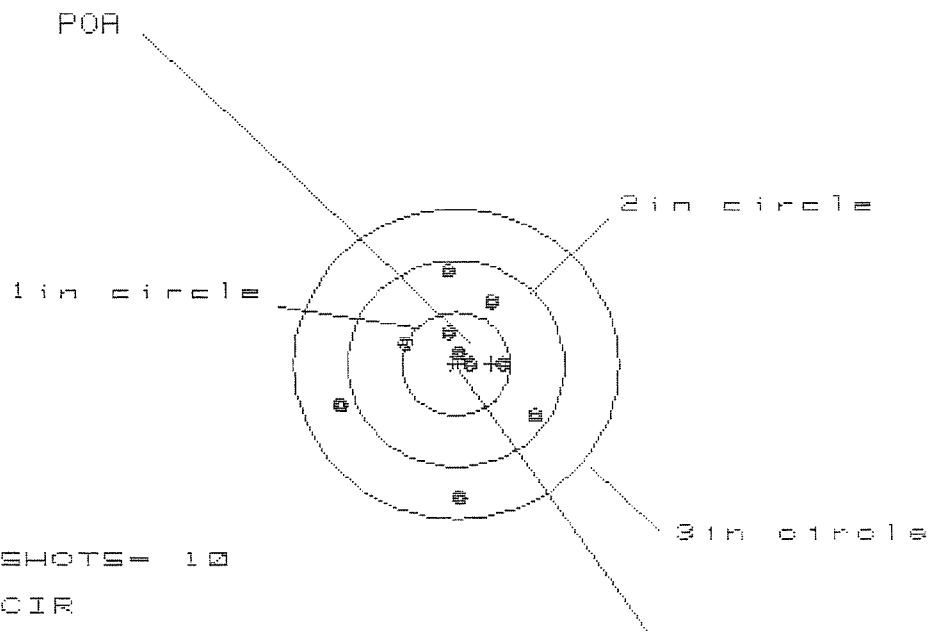
CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.872	.752	.808
MINIMUM X	:	-1.079	-1.067	-1.011
MAXIMUM Y	:	.989	.904	.463
MINIMUM Y	:	-.766	-.738	-.625
CENTROID X	:	-.908	-.788	-.844
CENTROID Y	:	.249	.334	.221
POA TO CENTROID in.	:	.941	.856	.872
MIN RADIUS	:	.161	.272	.231
MEAN RADIUS	:	.725	.664	.604
MAX RADIUS	:	1.323	1.068	1.025
HORIZONTAL SPREAD	:	1.951	1.819	1.819
VERTICAL SPREAD	:	1.755	1.642	1.088
EXTREME SPREAD	:	2.406	1.843	1.843
NUMBER IN ONE INCH CIRCLE =			4	
NUMBER IN TWO INCH CIRCLE =			8	
NUMBER IN THREE INCH CIRCLE =			10	

28 Aug 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C8522238

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1 in = 4

2 in = 8

3 in = 10

HS= 1.810

VS= 2.226

GS= 2.227

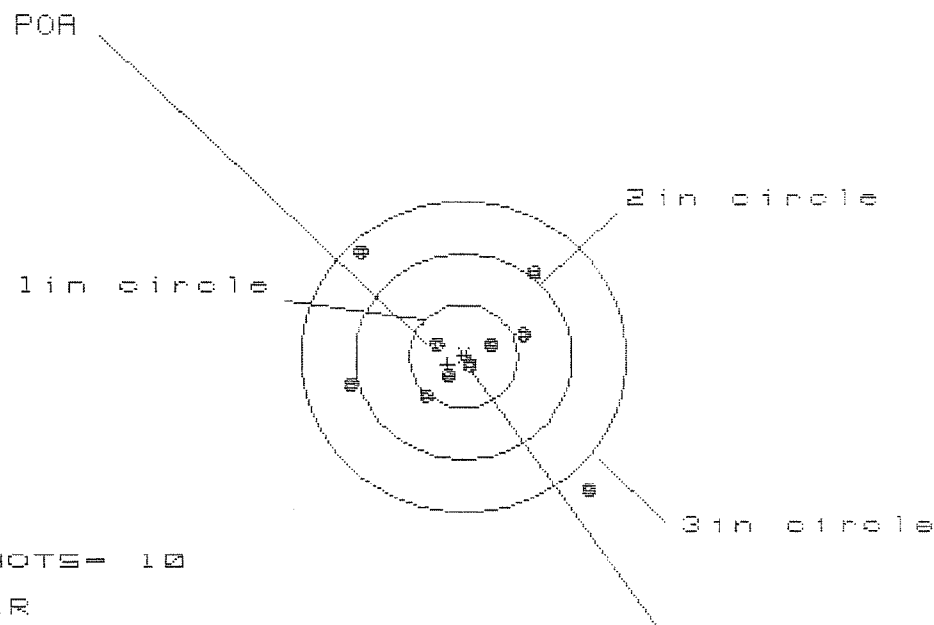
CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.758	.760	.628
MINIMUM X	:	-1.052	-1.050	-.641
MAXIMUM Y	:	.950	.809	.744
MINIMUM Y	:	-1.276	-.683	-.748
CENTROID X	:	-.328	-.330	-.198
CENTROID Y	:	-.004	.137	.202
POA TO CENTROID in.	:	.328	.357	.283
MIN RADIUS	:	.122	.012	.135
MEAN RADIUS	:	.652	.543	.468
MAX RADIUS	:	1.276	1.171	.977
HORIZONTAL SPREAD	:	1.810	1.810	1.270
VERTICAL SPREAD	:	2.226	1.492	1.492
EXTREME SPREAD	:	2.227	1.818	1.690
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	

20 Aug 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C8522238

CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1in = 4

2in = 6

3in = 9

HS= 2.147

VS= 2.236

GS= 3.048

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.121	.786	.682
MINIMUM X	:	-1.026	-.901	-1.005
MAXIMUM Y	:	.970	.830	.745
MINIMUM Y	:	-1.266	-.537	-.433
CENTROID X	:	.147	.022	.126
CENTROID Y	:	.082	.222	.119
POA TO CENTROID in.	:	.168	.223	.173
MIN RADIUS	:	.121	.160	.163
MEAN RADIUS	:	.715	.622	.518
MAX RADIUS	:	1.691	1.170	1.062
HORIZONTAL SPREAD	:	2.147	1.687	1.687
VERTICAL SPREAD	:	2.236	1.367	1.179
EXTREME SPREAD	:	3.048	2.008	2.008
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	




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

MODEL 700TM H24

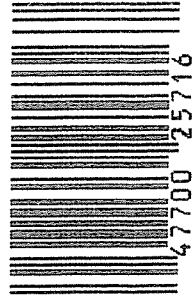
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.

SERIAL NO.
C6522238

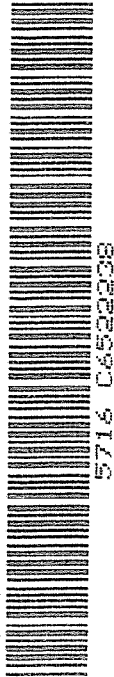
ORDER NO.
5716

01

UPC



0 47700 25716 7



5716 C6522238

Scope S/N 86-0894

BBL 96003



TRACKING DOCUMENT

Repair Order Number



Repair Order Numbe

RE00000740

Description/Serial

C6522238

Repairman -

Date Received 12/15/1999

Account # - R-

Model 700 Center Fire Caliber: 7.62

Estimate Date

SWS M-24 4OF18

Current Date - 12/16/1999

Customer

TRANSPORTATION OFFICER
XVIII AIBORNE CORPS AND FORT BR
BUILDING J-2050
FORT BRAGG NC 28310 US

Return To

TRANSPORTATION OFFICER
XVIII AIBORNE CORPS AND FORT B
BUILDING J-2050
FORT BRAGG NC 28310 US

Phone (H)

Fax

Phone (W)

Email

Problems

Reported

Found

Repair

Material # MaterialDesc

Quantity
Needed

Quantity
From

Quantity
From

Warranty
(Y/N)

Total:

Serial Number: C6522238

Model ID: 700



RE00000740

Repairman	Proof	Clean	Test	Target	Pattern
Gallery Tester	Date	Date	Date	Date	Date

LEUPOLD & STEVENS, INC.

MAILING: PO BOX 688
BEAVERTON OR 97075-0688
(503) 646-9171

SHIPPING: 14400 NW GREENBRIER PARKWAY
BEAVERTON OR 97006-5934
FAX (503) 526-1455

TELEX 15-1227

MAIL REMITTANCE IN U.S.
FUNDS TO:

LEUPOLD & STEVENS, INC.
PO BOX 4985
BEAVERTON OR 97076-4985 USA

B
I
L
L
T
O
REMINGTON ARMS CO., INC.
Attn:
14 HOEFLE AVE.
ILION NY 13357

S
H
I
P
T
O
REMINGTON ARMS CO., INC.
Attn:
14 HOEFLE AVE.
ILION NY 13357

Invoice No.	Date	Type of Service	Via
0198918	01/18/00	WARRANTY	UPS 2DAY
1 ea ULTRA M3A-10X S/N# 860894			Charge
Complaints/Requests WARRANTY- INSPECTION			
Service Activity: CLEANED RETICLE REBUILT/REWORKED ADJUSTMENTS			
CONTROL #M-30082			
CLEANED, SEALED, RECOLLIMATED, VISUAL & MECHANICAL INSPECTION 100%			
SHIPPING & HANDLING			
			AMOUNT DUE
			NO CHG

For Customer Use Only:

Charge/Debit Card Payment: ☐ Visa ☐ Master Card Card # _____

Expiration Date: _____ Signature: _____

VALUE FOR CUSTOMS PURPOSES ONLY \$ _____ THESE COMMODITIES ARE EXITING THE U.S.A. UNDER GENERAL LICENSE _____
"THESE COMMODITIES LICENSED BY THE UNITED STATES FOR ULTIMATE DESTINATION USA DIVERSION CONTRARY TO
UNITED STATES LAW PROHIBITED."

EXPORTER/MANUFACTURER: LEUPOLD & STEVENS INC.
PLACE: BEAVERTON, OREGON USA

ECCN: 0A987

SIGNATURE: _____
NAME: _____ EXPORT/INVOICING SPECIALIST

I.D. 93-0372974

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

M2400002480

Remington Test Lab, Ilion, N.Y.

Centroidal distance calculations for Rifle # C6522238
5 Apr 2000

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .172
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0136
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .172537

THE AMR FOR THIS RIFLE IS: 1.096

CENTROIDAL DISTANCES

0 TO	1	.294002
1 TO	2	.428439
1 TO	3	.504004
1 TO	4	.502252
1 TO	5	.532241

4
+
5 1 ←----POA

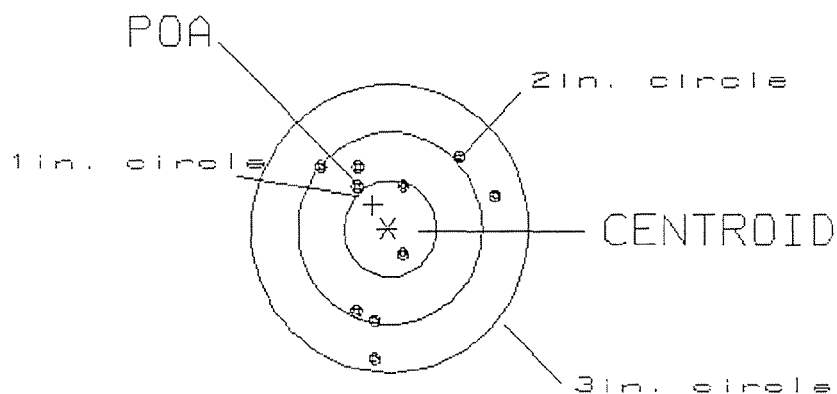
PATTERN #: ☐ 1 ☐

POA TO CENTROID: .294
 MIN RADIUS : .282
 MEAN RADIUS : .850
 MAX RADIUS : 1.343
 CENTROID X : .161
 CENTROID Y : -.246

5 Apr 2000

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/C6522238

CENTERFIRE PATTERN # 1



OF SHOTS= 10

IN CIRCLE

HS= 1.87

2

VS= 2.06

7

GS= 2.25

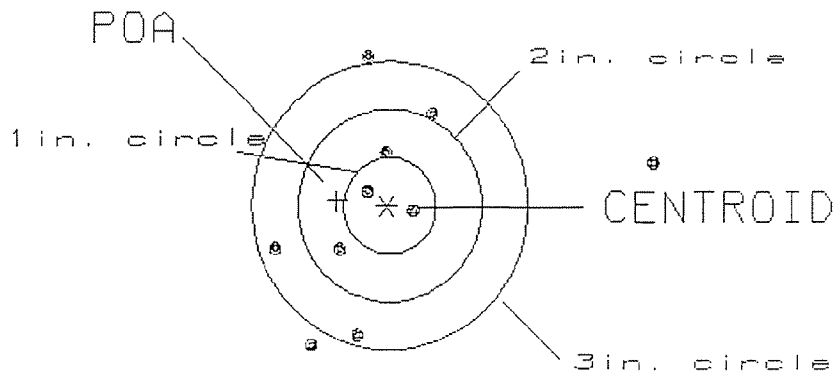
10

PATTERN #: 020
 POA TO CENTROID: .545
 MIN RADIUS : .215
 MEAN RADIUS : 1.178
 MAX RADIUS : 2.909
 CENTROID X : .543
 CENTROID Y : -.052

5 Apr 2000

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/C6522238

CENTERFIRE PATTERN # 2



OF SHOTS= 10

IN CIRCLE

HS= 4.15
 VS= 3.03
 GS= 4.26

2
 4
 7

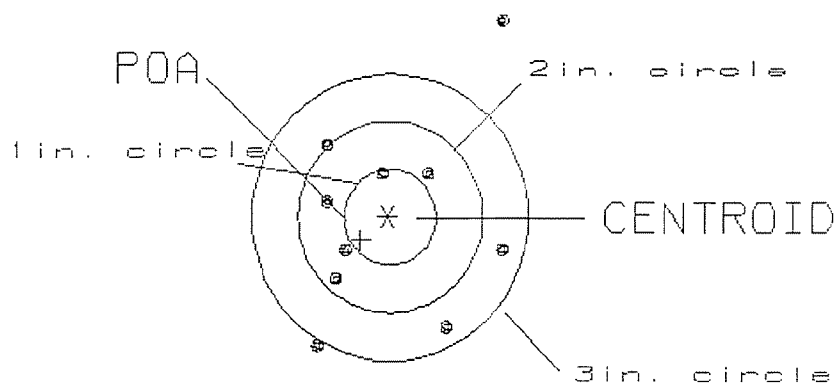
PATTERN #: ☐ 3 ☐

POA TO CENTROID: .375
 MIN RADIUS : .516
 MEAN RADIUS : 1.084
 MAX RADIUS : 2.379
 CENTROID X : .287
 CENTROID Y : .242

5 Apr 2000

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/C6522238

CENTERFIRE PATTERN # 3



OF SHOTS= 10

IN CIRCLE

HS= 2.00

0

VS= 3.44

6

GS= 3.98

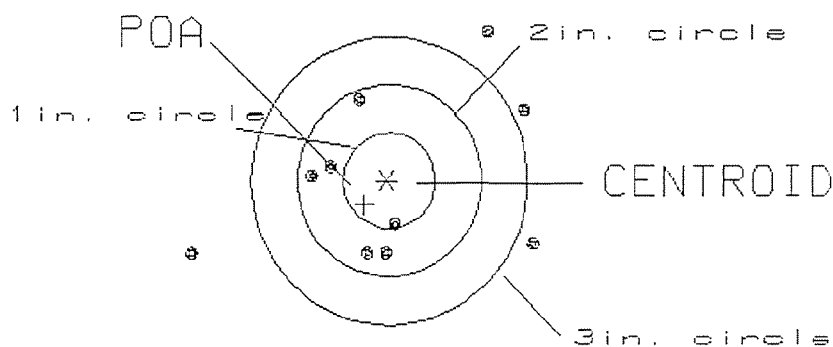
4

PATTERN #: ☐ 4 ☐
 POA TO CENTROID: .347
 MIN RADIUS : .481
 MEAN RADIUS : 1.190
 MAX RADIUS : 2.235
 CENTROID X : .240
 CENTROID Y : .250

5 Apr 2000

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/C6522238

CENTERFIRE PATTERN # 4



OF SHOTS= 10

IN CIRCLE

HS= 3.70

1

VS= 2.35

6

GS= 3.92

6

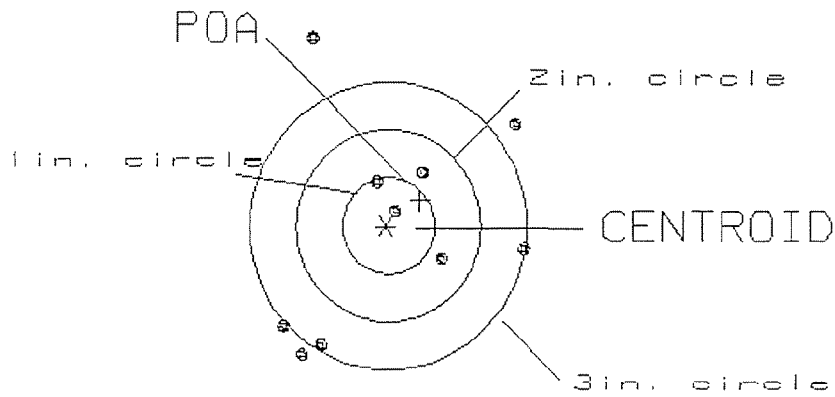
PATTERN #: 050

POA TO CENTROID: .454
 MIN RADIUS : .127
 MEAN RADIUS : 1.178
 MAX RADIUS : 2.126
 CENTROID X : -.371
 CENTROID Y : -.262

5 Apr 2000

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/C6522238

CENTERFIRE PATTERN # 5



OF SHOTS= 10

IN CIRCLE

HS= 2.59
 VS= 3.24
 GS= 3.26

2
 4
 6

21 DAY TURN - AROUND

M-24

CONTRACT # DAAA09-92-C-0834

R&E NO.

SERIAL NO.

C6522738

LOG IN DATE: / /		DATE	INIT.
INSPECT & VERIFY:			
OP. #	OP. NAME		
550	DIS-ASSEMBLE GUN	<i>12-24-99</i>	<i>RW</i>
560 A	RE-BARREL AT CUSTOM SHOP		
B	DRILL & TAP		
C	POLISH		
575	ASSEMBLE		
600	PROOF	<i>1-12-00</i>	<i>RW</i>
605	CHECK HEADSPACE	<i>1-12-00</i>	<i>RW</i>
610	DIS-ASSEMBLE		
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	<i>4-3-00</i>	<i>RW</i>
655	FINAL INSPECT	<i>4-10-00</i>	<i>RW</i>
660	PACK		

QAR INSPECTION

SHIP DATE

Final Inspection

Sn: C652238

DATE REC'D: 12-12-99

DATE RET'D:

AUDITOR: RW

Item:

Barrel Assy.

☒ BARREL

☒ RECEIVER

☒ FRONT SIGHT BLOCK

☒ REAR SIGHT BLOCK

☒ SCREWS

☒ FINISH

Scope Assy.

☒ Scope

☒ Scope Rings

☒ Mounting Screws

☒ Mounting Base

☒ SCREWS

☒ FINISH

☒ LOOSENESS

☒ CLARITY

Misc.

☐ DD-250

☐ BAR CODE

☐ PACKAGING

Item:

Stock Assy.

☒ STOCK

☒ SLING SWIVEL STUDS

☒ ADJUSTABLE BUTT PLATE

☒ LOCK NUTS

☒ BARREL CLEARANCE

☒ COLOR/FINISH

Systems Case

☒ Scope Case

☐ IRON SIGHTS

☐ Deployment Kit

Trigger

☒ SAFETY OPERATION

☒ SET

Comments: