

C6587686

MODEL 700TM M24

Model **SWS** TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington[®]

GFM

CONTRACT # DAAA21-87-C-0086

Repair

GUN SERIAL # C6587686

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock			
600	Proof			
607	Check Headspace			
610	Dis-assemble Gun			
612	Magnaflux Barrel Action			
	Magnaflux Bolt			
615	Rollmark Caliber			
617	Drill and Tap Sight Holes			
618	Polish Barrel			
620	Apply Coatings (Barrel Action)			
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		2/22/93	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		2/22/93	RW
	C) Inspect Ejector Hole for Chamfer		2/22/93	RW
	D) Oil Firing Pin Ass'y		2/22/93	RW
	E) Adjust Trigger Pull to Min Setting and Stake		2/22/93	RW

Op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			2/22/93	RW
	G) Safety Off Force	3.5	3	3			2/22/93	RW
	H) Trigger Pull Test & Retainability						2/22/93	RW
	I) Firing Pin Indent							
	J) Assemble Stock							
	K) Assemble Swivel Studs							
	L) Attach Front and Rear Sight Assemblies							
	M) Iron Sight Alignment							
	N) Detach Front & Rear Sights & place in numbered container							
	O) Attach Scope to Rifle						2/22/93	RW
	P) Detach & Attach Scope 20 Times							
640	Gallery Target & Test						2/26/93	RW
	A) Time							
	B) Malfunctions							
	C) Pierced Primers							
	D) Optical Clarity of Scope							
645	Inspect for Live Ammo						2/26/93	RW
655	Final Inspection							
	A) Headspace						3/4/93	RW
	B) Trigger Pull	2.66	2.66	2.63	2.64	2.65	3/4/93	RW
	C) Function						3/4/93	RW
660	Pack							

SWS TRIGGER PULL TEST

New Trigger Assy.

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6587686DATE 2/22/93TESTER RW

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.59	2.52	2.31		MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.65	2.65	2.47		
PULL #3	2.67	2.66	2.55		
PULL #4	2.57	2.54	2.68		
PULL #5	2.67	2.58	2.65		
TOTAL	13.15	12.95	12.46		
AVG.	2.63	2.59	2.49		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.03	3.18		
PULL #2	3.16	3.14		
PULL #3	3.04	3.10		
PULL #4	3.29	3.25		
PULL #5	3.12	3.23		
TOTAL	15.64	15.90		
AVG.	3.13	3.18		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.16	4.11		4.36
PULL #2	4.05	4.18		4.34
PULL #3	4.13	4.08		4.19
PULL #4	4.05	4.10		4.22
PULL #5	4.21	4.09		4.42
TOTAL	20.60	20.56		21.53
AVG.	4.12	4.11		4.31

Remington



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

MODEL 700™ H24

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

01

SERIAL NO.

C6587686

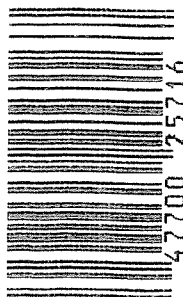
ORDER NO.

5716



5716 C6587686

LPC



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CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C 6587686

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		10/18/90	KA
600	Proof		10/18/90	KA
607	Check Headspace		10/18/90	KA
610	Dis-assemble Gun		10/18/90	KA
612	Magnaflux Barrel Action		10/22/90	KR
	Magnaflux Bolt		10/22	KR
615	Rollmark Caliber		10/22/90	JS
617	Drill and Tap Sight Holes		10/21/90	KB
618	Polish Barrel <i>KB</i>		10/24/90	KB
620	Apply Coatings (Barrel Action)		10-90	KA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		11-6-90	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		11-6-90	KS
	C) Inspect Ejector Hole for Chamfer		11-6-90	KS
	D) Oil Firing Pin Ass'y		11-6-90	KS
	E) Adjust Trigger Pull to Min Setting and Stake		11/2/90	GS

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4.3/4	4.3/4	5.0			11-7-90	KS
	G) Safety Off Force	3.0	3.25	3.0			11-7-90	KS
	H) Trigger Pull Test & Retainability							
	I) Firing Pin Indent	.020	.021	.020			11-7-90	KS
	J) Assemble Stock						11/13/90	KS
	K) Assemble Swivel Studs						11-19-90	DH
	L) Attach Front and Rear Sight Assemblies						11/13/90	KS
	M) Iron Sight Alignment						11/13/90	KS
	N) Detach Front & Rear Sights & place in numbered container						11/13/90	KS
	O) Attach Scope to Rifle						11/13/90	KS
	P) Detach & Attach Scope 20 Times						11/13/90	KS
640	Gallery Target & Test						11/14/90	AF
	A) Time						"	AF
	B) Malfunctions						"	AF
	C) Pierced Primers						"	AF
	D) Optical Clarity of Scope						"	AF
645	Inspect for Live Ammo						11/14/90	AF
655	Final Inspection							
	A) Headspace						11-19-90	DH
	B) Trigger Pull	2.48	2.51	2.47	2.42	2.47	11-19-90	DH
	C) Function						11-19-90	DH
660	Pack						12/18/90	AF

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6587686
15 Nov 1990

CENTROIDAL DISTANCES

0 TO	1	.182937
1 TO	2	.355148
1 TO	3	.252353
1 TO	4	.169499
1 TO	5	.401759

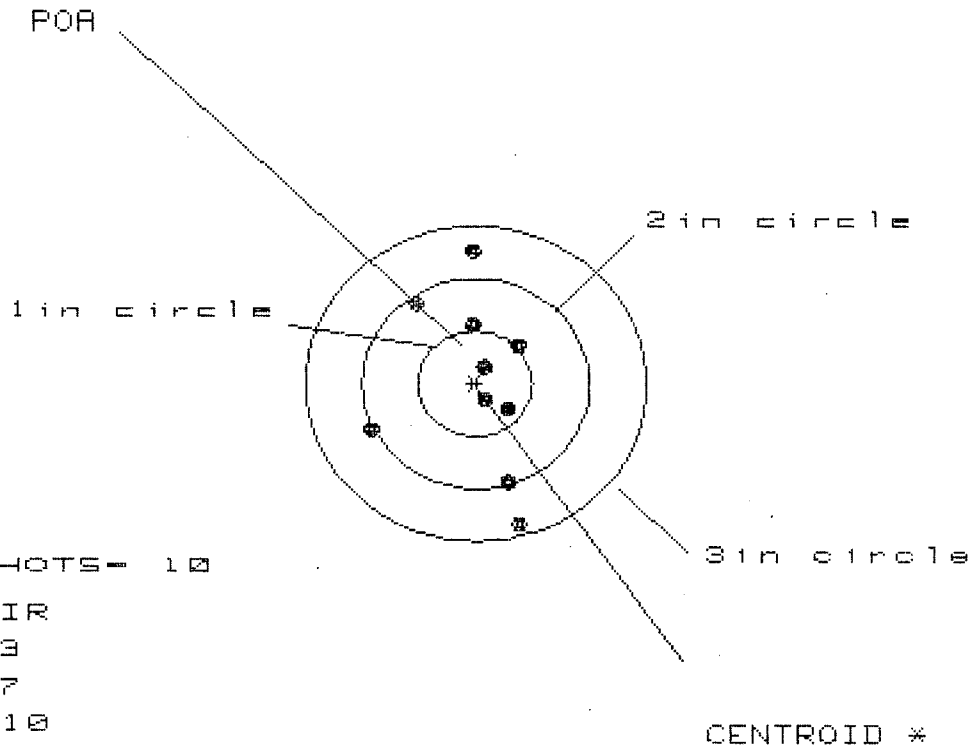
85
PB <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0606
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0018
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0606267
THE AMR FOR THIS RIFLE IS: .7192

15 Nov 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6587686

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in - 3

2 in - 7

3 in - 10

HS- 1.296

VS- 2.588

GS- 2.613

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.386	.399	.407
MINIMUM X	-.910	-.867	-.859
MAXIMUM Y	1.298	1.155	.755
MINIMUM Y	-1.290	-1.121	-.977
CENTROID X	-.079	-.122	-.130
CENTROID Y	-.165	-.022	-.166
POA TO CENTROID in.	.183	.124	.211
MIN RADIUS	.137	.108	.168
MEAN RADIUS	.727	.653	.586
MAX RADIUS	1.346	1.167	1.032
HORIZONTAL SPREAD	1.296	1.266	1.266
VERTICAL SPREAD	2.588	2.276	1.732
EXTREME SPREAD	2.613	2.290	1.907
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	10		

15 Nov 1990

FILE:/PATTERNING/CENTERFIRE_PATT/C8587886

CENTERFIRE PATTERNS # 2

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in - 3

2in - 8

3in = 10

HS= 1.690

VS= 1.820

GS= 2.120

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.934	.886	.692
MINIMUM X	:	-.756	-.804	-.694
MAXIMUM Y	:	1.039	.682	.624
MINIMUM Y	:	-.781	-.666	-.724
CENTROID X	:	-.040	.008	-.103
CENTROID Y	:	.188	.073	.131
POA TO CENTROID in.	:	.192	.073	.166
MIN RADIUS	:	.169	.279	.165
MEAN RADIUS	:	.666	.625	.560
MAX RADIUS	:	1.126	1.000	.839
HORIZONTAL SPREAD	:	1.690	1.690	1.385
VERTICAL SPREAD	:	1.820	1.348	1.348
EXTREME SPREAD	:	2.120	1.691	1.477
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	

15 Nov 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C8587686

CENTERFIRE PATTERNS

3

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS- 10

IN CIR

1 in = 1

2 in = 8

3 in = 9

HS= 1.967

VS= 2.520

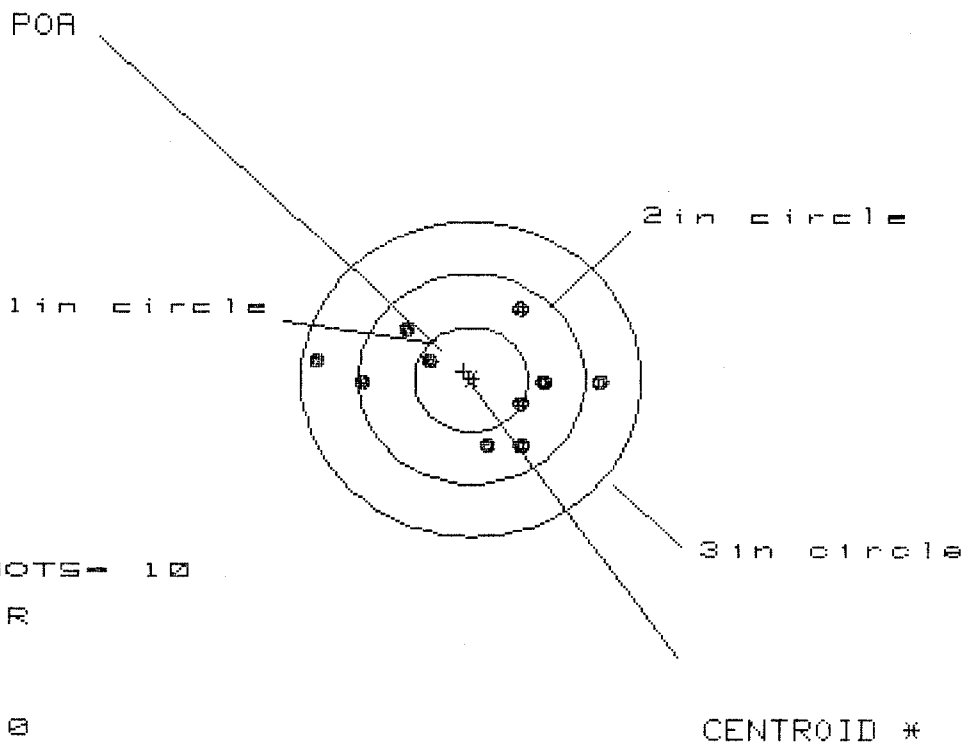
GS= 3.108

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.670	.526	.505
MINIMUM X	:	-1.296	-.707	-.641
MAXIMUM Y	:	1.585	.981	.900
MINIMUM Y	:	-.934	-.758	-.839
CENTROID X	:	.160	.304	.238
CENTROID Y	:	-.084	-.260	-.179
POA TO CENTROID in.	:	.180	.399	.298
MIN RADIUS	:	.271	.289	.267
MEAN RADIUS	:	.850	.681	.661
MAX RADIUS	:	2.048	1.003	.941
HORIZONTAL SPREAD	:	1.967	1.233	1.146
VERTICAL SPREAD	:	2.520	1.739	1.739
EXTREME SPREAD	:	3.108	1.844	1.844
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	

15 Nov 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6587686

CENTERFIRE PATTERNS # 4

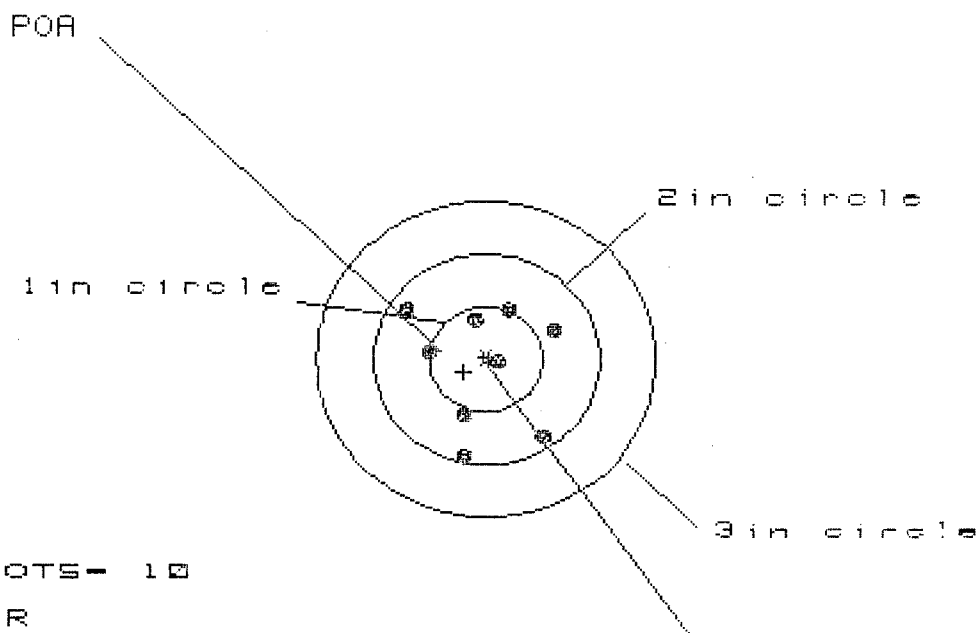


PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.136	.986	.608
MINIMUM X	:	-1.351	-1.066	-.943
MAXIMUM Y	:	.684	.700	.693
MINIMUM Y	:	-.579	-.563	-.570
CENTROID X	:	.064	.214	.091
CENTROID Y	:	-.074	-.090	-.083
POA TO CENTROID in.	:	.098	.232	.123
MIN RADIUS	:	.400	.326	.428
MEAN RADIUS	:	.779	.693	.659
MAX RADIUS	:	1.359	1.066	.943
HORIZONTAL SPREAD	:	2.487	2.052	1.551
VERTICAL SPREAD	:	1.263	1.263	1.263
EXTREME SPREAD	:	2.496	2.052	1.551
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	

15 Nov 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6587686

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 5

2in = 10

3in = 10

HS= 1.217

VS= 1.357

GS= 1.614

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.563	.540	.597
MINIMUM X	:	-.655	.677	-.020
MAXIMUM Y	:	.469	.370	.273
MINIMUM Y	:	-.888	-.778	-.696
CENTROID X	:	.198	.220	.163
CENTROID Y	:	.126	.225	.322
POA TO CENTROID in.	:	.234	.315	.361
MIN RADIUS	:	.149	.195	.212
MEAN RADIUS	:	.574	.520	.458
MAX RADIUS	:	.911	.902	.715
HORIZONTAL SPREAD	:	1.217	1.217	1.217
VERTICAL SPREAD	:	1.357	1.148	.969
EXTREME SPREAD	:	1.614	1.614	1.227
NUMBER IN ONE INCH CIRCLE	=		5	
NUMBER IN TWO INCH CIRCLE	=		10	
NUMBER IN THREE INCH CIRCLE	=		10	

SWS TRIGGER PULL TEST

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

SERIAL NO. C10587686
DATE 13 Nov 98
TESTER JS

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	238	212	239	248	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	227	208	237	251	
PULL #3	232	208	238	247	
PULL #4	228	206	235	242	
PULL #5	229	206	242	247	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	321	315		
PULL #2	316	313		
PULL #3	324	313		
PULL #4	315	312		
PULL #5	316	312		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	424	426		419
PULL #2	430	428		418
PULL #3	427	425		416
PULL #4	424	424		419
PULL #5	426	424		419
TOTAL				
AVG.				

RECEIVING AND ESTIMATING REPORT

COMMENTS

ORDER

R 93-02464

INITIAL FPS	CUSTOMER ORDER NO.	WDG 14 OF 30 W/10X SCOPE & DEPLOYMENT KIT M24			
DATE RECEIVED 01/25/93	DATE OPENED 01/25/93	DATE CODE EK 10-90	SERIAL NUMBER C6587686	NEW SERIAL NUMBER	MODEL AND GRADE 700 7-62 NATO
ACCESSORIES W/STUDS	W/SWIVELS		SOFT CASE	SCOPE BASE	

FROM:

SHIP TO:

MCHALE, EDWARD J CPT, SF
HSC 3RD BN 3RD SFG (A)
FT BRAGG NC 28307

MCHALE, EDWARD J CPT, SF
HSC 3RD BN 3RD SFG (A)
FT BRAGG NC 28307

CUST NO: 073985 C.O.D

ACCOUNT NUMBER	ACCOUNT NUMBER N/C	WRITE ☐ CLEAN/TEST	PROM. DATE	ESTIMATED	VIA UPS
GUN CONDITION					REPAIR CHARGE
☐ NEW					EXCISE
☐ LIGHTLY WORN					TAX
☐ WORN					INSURANCE
☐ VERY WORN					UPS
☐ UNREPAIRABLE					PARCEL POST
☐ MARRED					TOTAL

CUSTOMER CONCERN	AMMO	FUNCTION	FINISH	ACCURACY	FIT	INSPECT
CYCLE	A1	B1				
TRIGGER GROUP		B2			E1	F1
BOLT ASSY.		B3			E2	F2
BARREL ASSY.		B4		D1	E3	F3
REC. ASSY.		B5		D2	E4	F4
WOOD			C1	D3	E5	F5
METAL			C2			

MAIN FAULT

Rust on Gun

PARTS	COMMENTS
Magazine Spring - 15677 Trigger Assy - 96024	Zinc Phosphate Scope Base, Scope Rings, Swivels & Swivel Studs Re-powder Coat Floor plate & latch, Trigger Guard & Barrel Assy - 96001
REPAIRMAN RW	PROOF
GALLERY TESTER RW	DATE
CLEAN	TEST ✓
TARGET	PATTERN
DATE	DATE
2/26/93	

OFFICE COPY

RD6925 REV. 1/92

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

M2400025286