

C6587732

MODEL 700™ M24

Model **SWS**™

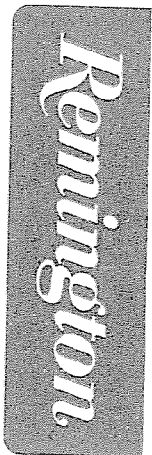
Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



RECEIVING AND ESTIMATING REPORT

COMMENTS

ORDER
R 94-18113INITIAL
FDC
CUSTOMER ORDER NO.
DAAA09-92-C-0834W/10X SCOPE M-24 SNIPER, W/DEPLOYMENT KIT
ATTN: FRED MARTIN

Scope S/N 90-0865

DATE RECEIVED	DATE OPENED	DATE CODE	SERIAL NUMBER	NEW SERIAL NUMBER	MODEL AND GRADE	
06/09/94	06/09/94		C6587732		700 7-62	NATO
ACCESSORIES SLING STRAP HARD CASE SCOPE MNTS SCOPE BASE						

FROM:

SHIP TO:

COMMANDER (W52H094138H226)
DEFENSE DIST DEPOT ANNISTON
ATTN DDAA-UR BLDG 112
ANNISTON

AL 36201-5025

COMMANDER (W52H094138H226)
DEFENSE DIST DEPOT ANNISTON
ATTN DDAA-UR BLDG 112
ANNISTON

AL

36201-5025

CUST NO: 098397 CJO.D

ACCOUNT NUMBER	ACCOUNT NUMBER N/C	WRITE	PROM. DATE	ESTIMATED	VIA
		☐			FRT
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

PARTS

COMMENTS

✓ Barrel
✓ Stock
✓ Trigger Assy
✓ Firing pin Assy
✓ Front & Rear Sight Assy

REPAIRMAN PROOF CLEAN TEST TARGET PATTERN

GALLERY TESTER DATE DATE DATE DATE DATE DATE

OFFICE COPY

RD6925 REV. 1/94

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

M2400026067

SWS TRIGGER PULL TEST

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

SERIAL NO. _____

DATE 2-28-96

TESTER DA

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.46	2.70	2.53		MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.63	2.77	2.55		
PULL #3	2.76	2.67	2.54		
PULL #4	2.87	2.77	2.44		
PULL #5	2.86	2.64	2.28		
TOTAL	1358	1355	1234		
AVG.	2.71	2.71	2.46		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.33	3.31		
PULL #2	3.16	3.32		
PULL #3	3.16	3.30		
PULL #4	3.00	3.28		
PULL #5	3.22	3.28		
TOTAL	1587	1649		
AVG.	3.17	3.29		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.19	4.03		4.44
PULL #2	4.22	4.02		4.38
PULL #3	4.06	3.83		4.47
PULL #4	4.00	4.00		4.43
PULL #5	4.10	3.94		4.30
TOTAL	2057	1982		2210
AVG.	4.11	3.96		4.42

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6587732
15 Jan 1900

CENTROIDAL DISTANCES

0 TO	1	1.09066
1 TO	2	.29533
1 TO	3	.0908735
1 TO	4	.226932
1 TO	5	.465543

3
52

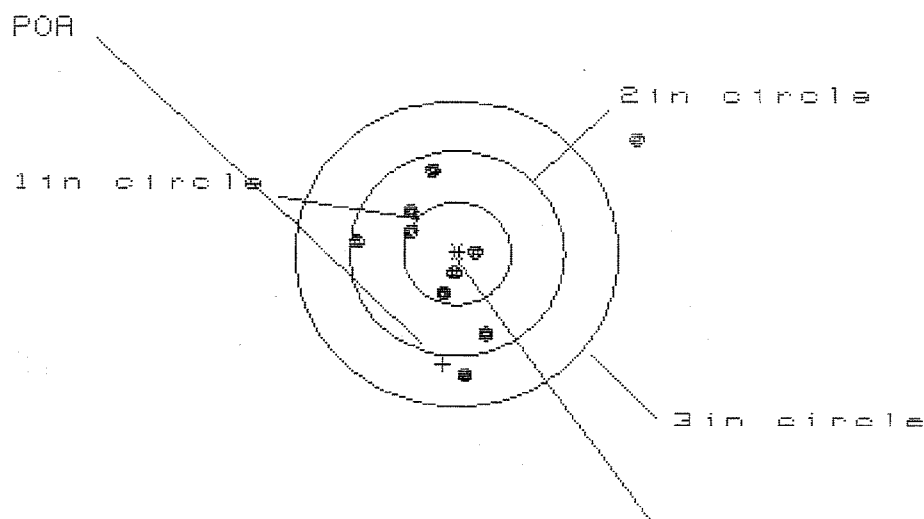
+ <----POB

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0904
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .9948
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .998899
THE AMR FOR THIS RIFLE IS: .835

15 Jan 1988

FILE:/PATTERNING/CENTERFIRE_PATT/06587732

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1in = 3

2in = 8

3in = 9

HS= 2.623

VS= 2.284

GS= 2.823

CENTROID #

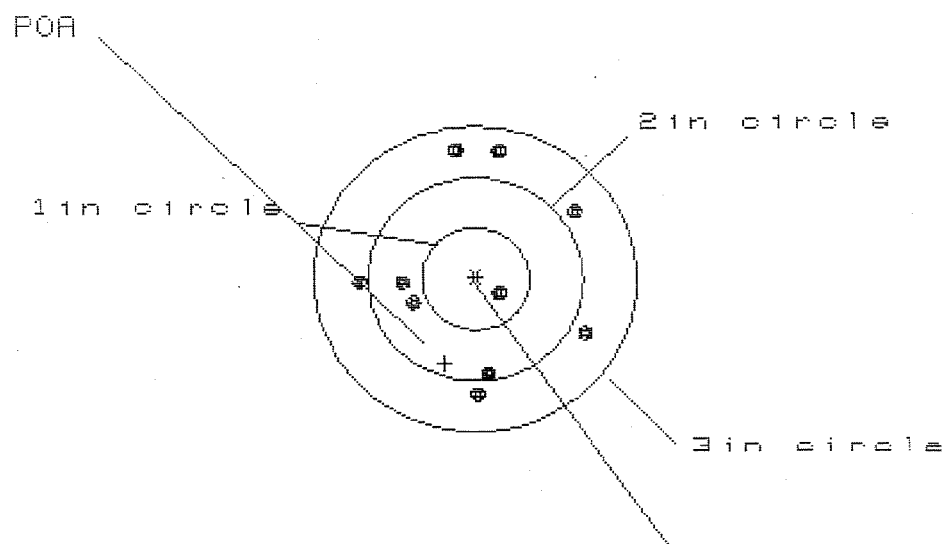
PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.719	.414	.447
MINIMUM X	:	-.904	-.713	-.680
MAXIMUM Y	:	1.112	.892	.761
MINIMUM Y	:	-1.172	-1.048	-.828
CENTROID X	:	.129	-.062	-.095

CENTROID Y	:	1.083	.959	1.090
POA TO CENTROID in.	:	1.090	.961	1.094
MIN RADIUS	:	.165	.193	.300
MEAN RADIUS	:	.767	.598	.531
MAX RADIUS	:	2.048	1.080	.941
HORIZONTAL SPREAD	:	2.623	1.127	1.127
VERTICAL SPREAD	:	2.284	1.940	1.589
EXTREME SPREAD	:	2.823	1.968	1.662
NUMBER IN ONE INCH CIRCLE =	:	3	3	3
NUMBER IN TWO INCH CIRCLE =	:	8	8	8
NUMBER IN THREE INCH CIRCLE =	:	9	9	9

15 Jan 1900

FILE:/PATTERNING/CENTERFIRE_PATT/C8587732

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 1

2in = 4

3in = 10

HS= 2.035

VS= 2.397

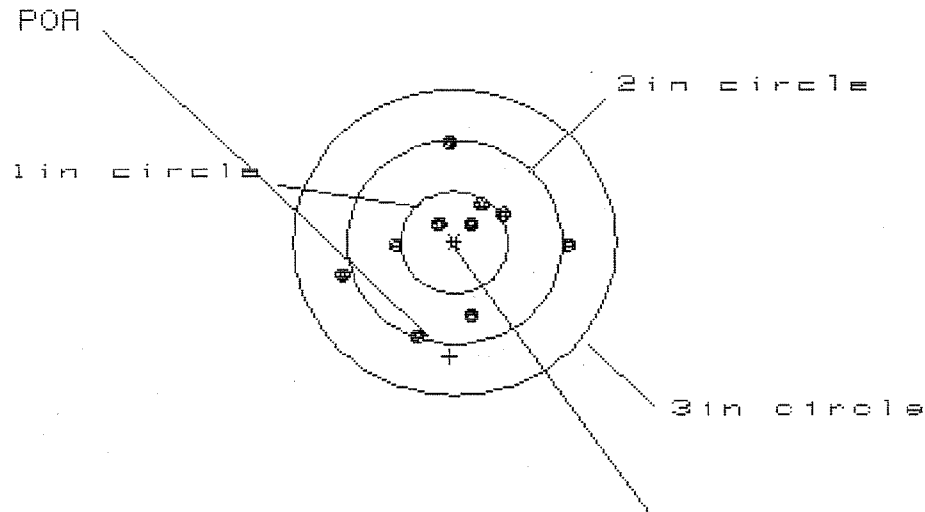
GS= 2.401

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.989	.974	1.004
MINIMUM X	:	-1.046	-1.061	-1.031
MAXIMUM Y	:	1.256	1.262	.977
MINIMUM Y	:	-1.141	-1.082	-.832
CENTROID X	:	.283	.298	.268
CENTROID Y	:	.031	.692	.522
POA TO CENTROID in.	:	.878	.753	.587
MIN RADIUS	:	.288	.248	.336
MEAN RADIUS	:	.953	.899	.817
MAX RADIUS	:	1.263	1.383	1.324
HORIZONTAL SPREAD	:	2.035	2.035	2.035
VERTICAL SPREAD	:	2.397	2.364	1.809
EXTREME SPREAD	:	2.401	2.378	2.094
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		10	

15 Jan 1988

FILE:/PATTERNING/CENTERFIRE_PATT/08587732

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 6

3 in = 10

HS= 2.123

VS= 1.943

GS= 2.136

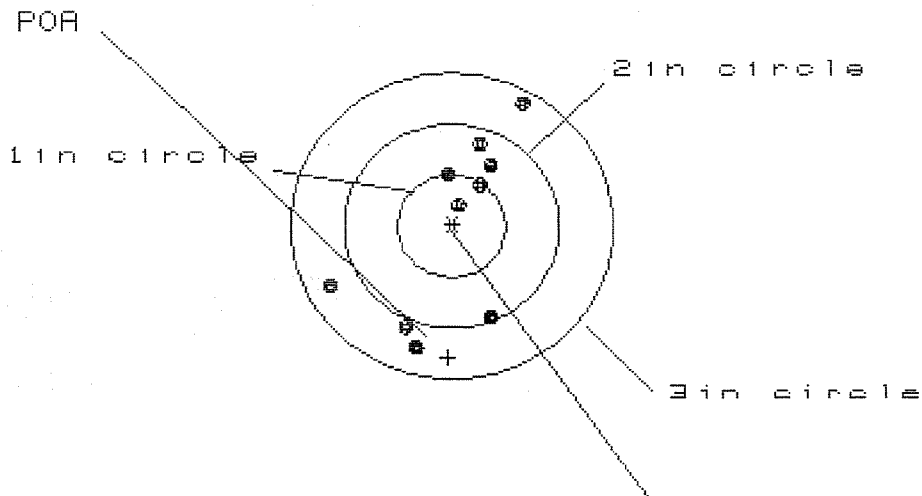
CENTROID *

PATTERN #	3	3	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.099	1.520	.508
MINIMUM X	-1.022	-.582	-.582
MAXIMUM Y	1.022	.957	.957
MINIMUM Y	-.957	-.986	-.986
CENTROID X	.048	.076	.037
CENTROID Y	1.120	1.126	1.164
POA TO CENTROID in.	1.121	1.129	1.165
MIN RADIUS	.199	.212	.180
MEAN RADIUS	.701	.656	.598
MAX RADIUS	1.101	.999	1.047
HORIZONTAL SPREAD	2.123	1.522	1.089
VERTICAL SPREAD	1.943	1.943	1.943
EXTREME SPREAD	2.136	1.972	1.972
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		10	

15 Jan 1900

FILE:/PATTERNING/CENTERFIRE_PATT/C6587732

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 2

2in = 6

3in = 10

HS- 1.760

VS- 2.395

GS- 2.585

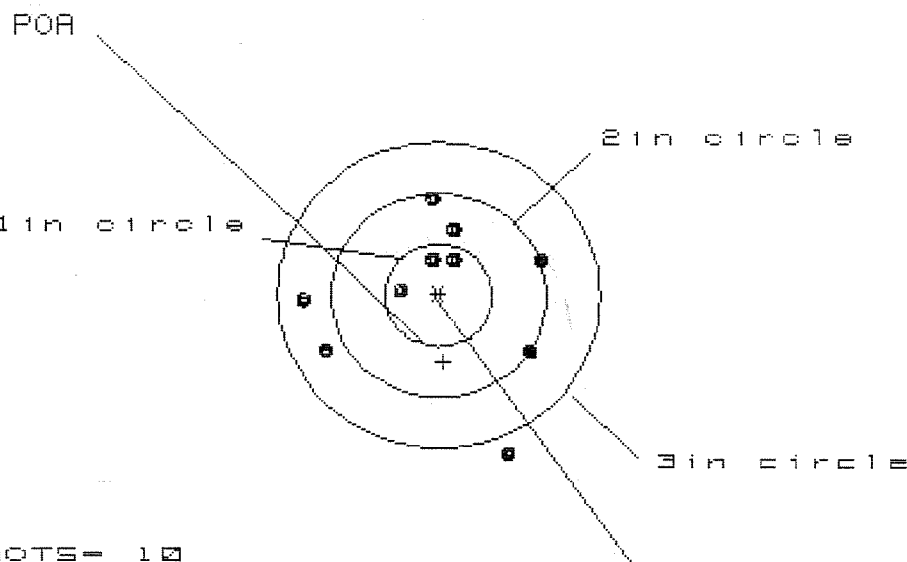
CENTROID #

PATTERN #	4	8
SHOTS (BEST OF)	10	8
MAXIMUM X	.410	.410
MINIMUM X	-1.047	-1.047
MAXIMUM Y	.786	.786
MINIMUM Y	-1.008	-1.008
CENTROID X	.036	-.038
CENTROID Y	1.290	1.157
POA TO CENTROID in.	1.290	1.158
MIN RADIUS	.166	.314
MEAN RADIUS	.864	.832
MAX RADIUS	1.368	1.097
HORIZONTAL SPREAD	1.760	1.457
VERTICAL SPREAD	2.395	1.988
EXTREME SPREAD	2.585	2.068
NUMBER IN ONE INCH CIRCLE	= 2	
NUMBER IN TWO INCH CIRCLE	= 6	
NUMBER IN THREE INCH CIRCLE	= 10	

15 Jan 1968

FILE:/PATTERNING/CENTERFIRE_PATT/08587732

CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1in = 3

2in = 5

3in = 8

HS= 2.174

VS= 2.518

GS= 2.611

CENTROID #

PATTERN #	:	10	:	8
SHOTS (BEST OF)	:	10	:	8
MAXIMUM X	:	.933	:	.887
MINIMUM X	:	-1.219	:	-1.152
MAXIMUM Y	:	.943	:	.737
MINIMUM Y	:	-1.575	:	-1.784
CENTROID X	:	-.042	:	.026
CENTROID Y	:	.650	:	.856
POA TO CENTROID in.	:	.651	:	.856
MIN RADIUS	:	.325	:	.110
MEAN RADIUS	:	.890	:	.670
MAX RADIUS	:	1.713	:	1.367
HORIZONTAL SPREAD	:	2.174	:	2.039
VERTICAL SPREAD	:	2.518	:	1.521
EXTREME SPREAD	:	2.611	:	2.217
NUMBER IN ONE INCH CIRCLE	=	3		
NUMBER IN TWO INCH CIRCLE	=	5		
NUMBER IN THREE INCH CIRCLE	=	9		

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C 6587732

OP. #	OP. NAME	READINGS	DATE	INITIAL
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			
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head			
	C) Inspect Ejector Hole for Chamfer			
	D) Oil Firing Pin Ass'y			
	E) Adjust Trigger Pull to Min Setting and Stake			

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5 1/2	5 1/2	5 1/2			5/3/96	WB
	G) Safety Off Force	3	3	3			5/3/96	WB
	H) Trigger Pull Test & Retainability							
	I) Firing Pin Indent	.020	.0205	.020			5/3/96	WB
	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							
	P) Detach & Attach Scope 20 Times							
640	Gallery Target & Test							
	A) Time							
	B) Malfunctions							
	C) Pierced Primers							
	D) Optical Clarity of Scope							
645	Inspect for Live Ammo							
655	Final Inspection							
	A) Headspace							
	B) Trigger Pull	2.38	2.29	2.28	2.32	2.33	4/15/96	WB
	C) Function							
660	Pack							




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

MODEL 700™ H24

SERIAL NO. C6587732

ORDER NO. 5716

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

Ø1

UPC



0 47700 25716 7



5716 C6587732

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6587732

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	1019	90	RW
600	Proof	1019	90	RW
607	Check Headspace	1019	90	RW
610	Dis-assemble Gun	1010	90	RW
612	Magnaflux Barrel Action		10/23/90	KR
	Magnaflux Bolt		10/23/90	KR
615	Rollmark Caliber		10/23/90	K.R
617	Drill and Tap Sight Holes		10/26/90	LB
618	Polish Barrel AB		10/29/90	LB
620	Apply Coatings (Barrel Action)		11-7-90	TH
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		11/12/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		11/12/90	RW
	C) Inspect Ejector Hole for Chamfer		11/12/90	RW
	D) Oil Firing Pin Ass'y		11/12/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		11-16-90	TH

op. #	OP. NAME	READINGS			DATE	INIT		
625 cont.	F) Safety On Force	4 1/4	4 1/4	4 1/4	11/14/90	WB		
	G) Safety Off Force	2 3/4	2 3/4	2 3/4	11/16/90	WB		
	H) Trigger Pull Test & Retainability				11-16-90	JF		
	I) Firing Pin Indent	.0225	.0215	.022	11/16/90	WB		
	J) Assemble Stock				11/28/90	RW		
	K) Assemble Swivel Studs				11-29-90	J28		
	L) Attach Front and Rear Sight Assemblies				11/28/90	RW		
	M) Iron Sight Alignment				11/28/90	RW		
	N) Detach Front & Rear Sights & place in numbered container				11/28/90	RW		
	O) Attach Scope to Rifle				11/28/90	RW		
	P) Detach & Attach Scope 20 Times				11/28/90	RW		
640	Gallery Target & Test				11/28/90	DH		
	A) Time				11-28-90	DH		
	B) Malfunctions				11-28-90	DH		
	C) Pierced Primers				11-28-90	DH		
	D) Optical Clarity of Scope				11-28-90	DH		
645	Inspect for Live Ammo				11-28-90	DH		
655	Final Inspection							
	A) Headspace				11-29-90	J28		
	B) Trigger Pull	246	245	247	244	241	11-29-90	J28
	C) Function						11-29-90	J28
660	Pack						12/19/90	VF

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO C6587732

DATE 11-16-90

TESTER JLL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.45	2.48	2.32	2.46	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.28	2.21	2.39	2.45	
PULL #3	2.44	2.38	2.31	2.47	
PULL #4	2.46	2.44	2.48	2.44	
PULL #5	2.30	2.24	2.47	2.41	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.33	3.27		
PULL #2	3.18	3.29		
PULL #3	3.25	3.10		
PULL #4	3.30	3.21		
PULL #5	3.31	3.20		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.20	4.29		4.21
PULL #2	4.14	4.25		4.31
PULL #3	4.17	4.29		4.31
PULL #4	4.19	4.29		4.26
PULL #5	4.19	4.17		4.32
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6587732
28 Nov 1990

CENTROIDAL DISTANCES

0 TO 1	.151743
1 TO 2	.198565
1 TO 3	.659242
1 TO 4	.338565
1 TO 5	.387568

$\#_5^3$ <----POB

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1162
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .016
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .117296
THE AMR FOR THIS RIFLE IS: .9266

28 Nov 1998

FILE:/PATTERNING/CENTERFIRE_PATT/08587732

CENTERFIRE PATTERNS # 1

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 2

2in = 4

3in = 9

HS= 2.595

VS= 2.343

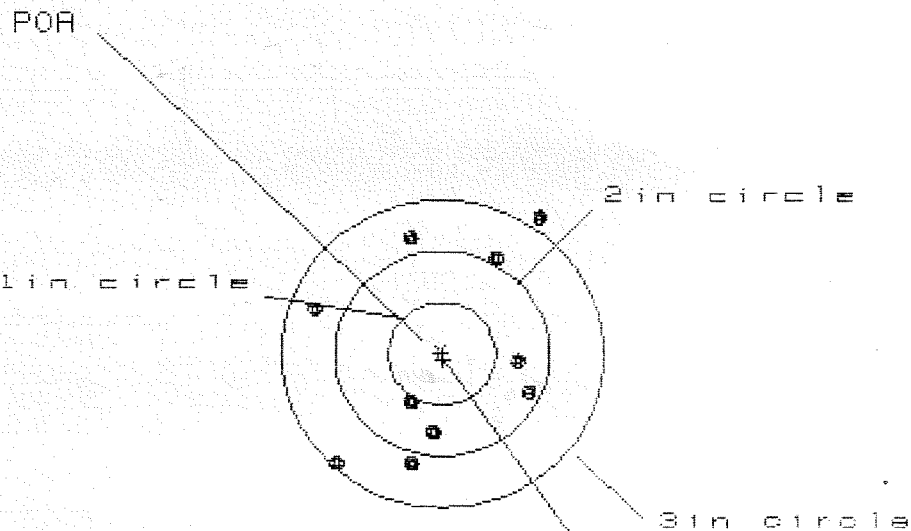
GS= 2.845

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.054	.883	.827
MINIMUM X	-1.541	-.738	-.794
MAXIMUM Y	1.206	1.131	.978
MINIMUM Y	-1.137	-1.212	-1.071
CENTROID X	-.099	.072	.128
CENTROID Y	-.115	-.040	-.181
POA TO CENTROID in.	.152	.083	.222
MIN RADIUS	.352	.332	.253
MEAN RADIUS	.931	.825	.773
MAX RADIUS	1.684	1.215	1.142
HORIZONTAL SPREAD	2.595	1.621	1.621
VERTICAL SPREAD	2.343	2.343	2.049
EXTREME SPREAD	2.845	2.371	2.179
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	9		

28 Nov 1998

FILE:/PATTERNING/CENTERFIRE_PATT/06587732

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 0

2 in = 4

3 in = 9

HS= 2.106

VS= 2.356

GS= 3.025

CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.944	.898	.792
MINIMUM X	:	-1.162	-1.057	-1.163
MAXIMUM Y	:	1.287	1.309	1.193
MINIMUM Y	:	-1.069	-.926	-1.005
CENTROID X	:	-.011	-.116	-.010
CENTROID Y	:	.063	-.080	.036
POA TO CENTROID in.	:	.064	.140	.038
MIN RADIUS	:	.530	.353	.507
MEAN RADIUS	:	1.057	.970	.940
MAX RADIUS	:	1.596	1.316	1.254
HORIZONTAL SPREAD	:	2.106	1.955	1.955
VERTICAL SPREAD	:	2.356	2.235	2.198
EXTREME SPREAD	:	3.025	2.479	2.199
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		9	

28 Nov 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6587732

CENTERFIRE PATTERNS

3

POB

1 in circle

2 in circle

3 in circle

OF SHOTS - 10

IN CIR

1 in = 2

2 in = 8

3 in = 8

HS = 2.385

VS = 2.184

GS = 2.889

CENTROID *

PATTERN #	3	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.710	.597	.537
MINIMUM X	-.675	-.485	-.537
MAXIMUM Y	.649	.658	.466
MINIMUM Y	-1.545	-1.536	-.991
CENTROID X	.487	.297	.357
CENTROID Y	.187	.178	.370
POB TO CENTROID in.	.522	.346	.514
MIN RADIUS	.116	.264	.273
MEAN RADIUS	.800	.704	.546
MAX RADIUS	1.712	1.610	.998
HORIZONTAL SPREAD	2.385	1.082	1.074
VERTICAL SPREAD	2.194	2.194	1.457
EXTREME SPREAD	2.889	2.357	1.517
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	8		
NUMBER IN THREE INCH CIRCLE =	8		

28 Nov 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C8587732

CENTERFIRE PATTERNS # 4

POA

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 3

2 in = 6

3 in = 10

HS= 2.369

VS= 2.063

GS= 2.386

CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.233	.625	.500
MINIMUM X	:	-1.136	-.999	-.816
MAXIMUM Y	:	1.115	1.117	1.083
MINIMUM Y	:	-.948	-.946	-.980
CENTROID X	:	-.050	-.187	-.062
CENTROID Y	:	.220	.218	.252
POA TO CENTROID in.	:	.226	.287	.260
MIN RADIUS	:	.140	.083	.114
MEAN RADIUS	:	.772	.705	.664
MAX RADIUS	:	1.233	1.131	1.097
HORIZONTAL SPREAD	:	2.369	1.624	1.316
VERTICAL SPREAD	:	2.063	2.063	2.063
EXTREME SPREAD	:	2.386	2.144	2.144
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	

28 Nov 1998

FILE:/PATTERNING/CENTERFIRE_PATT/06587732

CENTERFIRE PATTERNS

5

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS = 10

IN CIR

1in = 0

2in = 4

3in = 9

HS = 1.308

VS = 2.970

GS = 3.013

PATTERN #

5

SHOTS (BEST OF)	10	9	8
MAXIMUM X	.700	.751	.817
MINIMUM X	-.608	-.557	-.490
MAXIMUM Y	1.645	1.381	1.241
MINIMUM Y	-1.325	-1.142	-1.282
CENTROID X	.254	.203	.137
CENTROID Y	-.275	-.458	-.318
POA TO CENTROID in.	.374	.501	.346
MIN RADIUS	.608	.563	.494
MEAN RADIUS	1.073	.982	.945
MAX RADIUS	1.707	1.433	1.284
HORIZONTAL SPREAD	1.308	1.308	1.308
VERTICAL SPREAD	2.970	2.523	2.523
EXTREME SPREAD	3.013	2.659	2.552
NUMBER IN ONE INCH CIRCLE =		0	
NUMBER IN TWO INCH CIRCLE =		4	
NUMBER IN THREE INCH CIRCLE =		9	