

C6523440

MODEL 700TM N24

Model **SWS** TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6523440
17 Jan 1991

CENTROIDAL DISTANCES

0 TO	1	.384635
1 TO	2	.323224
1 TO	3	.476807
1 TO	4	.393855
1 TO	5	.323155

 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0258
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0854
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0892121

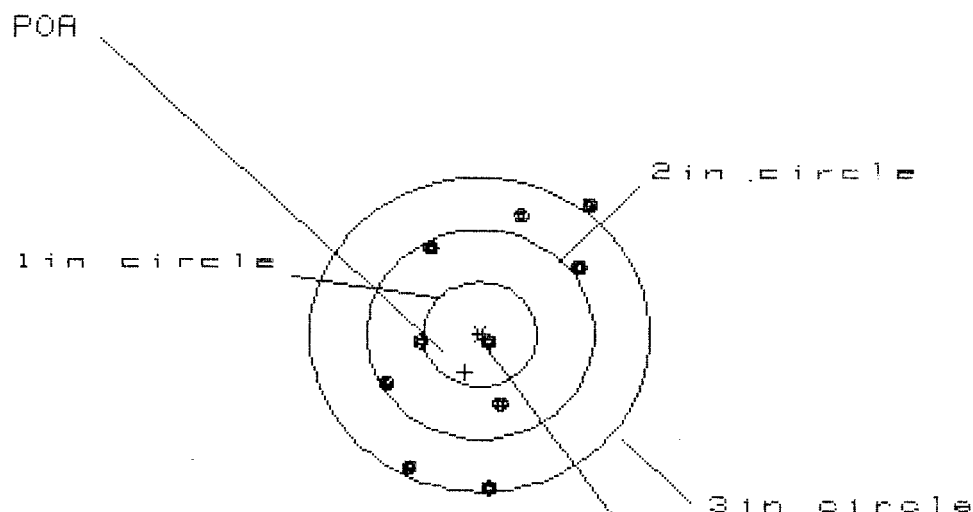
THE AMR FOR THIS RIFLE IS: 1.017

17 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6523440

CENTERFIRE PATTERNS

1



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 5

3 in = 9

HS= 1.822

VS= 2.657

GS= 2.929

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.963	.986	1.007
MINIMUM X	-.859	-.752	-.731
MAXIMUM Y	1.221	1.226	1.064
MINIMUM Y	-1.436	-1.301	-1.267
CENTROID X	.130	.023	.002
CENTROID Y	.362	.227	.389
POA TO CENTROID in.	.385	.228	.389
MIN RADIUS	.070	.147	.177
MEAN RADIUS	.984	.906	.851
MAX RADIUS	1.555	1.312	1.361
HORIZONTAL SPREAD	1.822	1.738	1.738
VERTICAL SPREAD	2.657	2.527	2.331
EXTREME SPREAD	2.929	2.543	2.526
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	9		

17 Jan 1991

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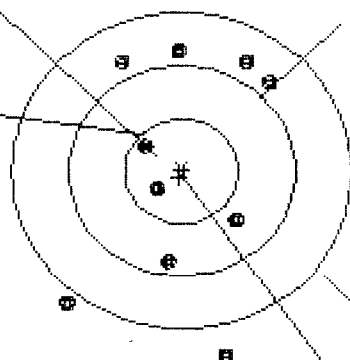
CENTERFIRE PATTERNS # 2

POA

1 in circle

2 in circle

3 in circle



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 4

3 in = 8

HS= 1.798

VS= 2.866

GS= 2.962

CENTROID #

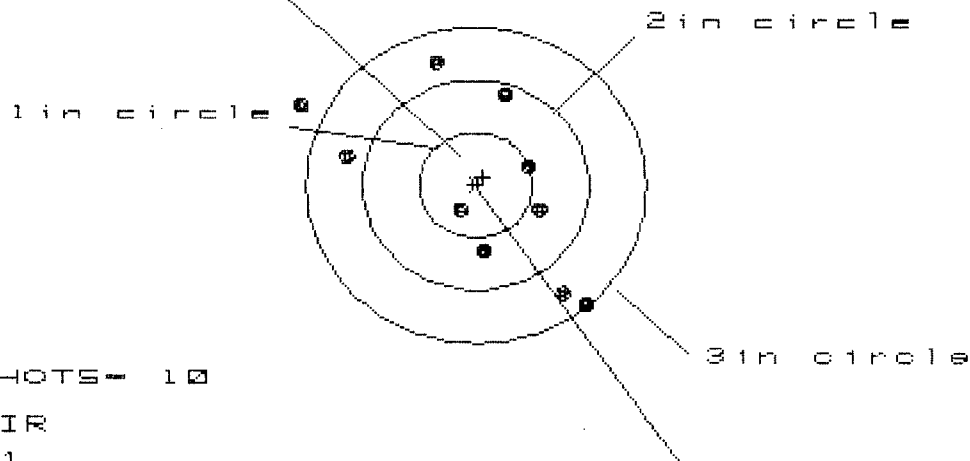
PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.758	.797	.672
MINIMUM X	:	-1.040	-1.001	-.590
MAXIMUM Y	:	1.122	.928	.751
MINIMUM Y	:	-1.744	-1.414	-1.215
CENTROID X	:	.023	-.017	.108
CENTROID Y	:	.057	.251	.428
POA TO CENTROID in.	:	.062	.252	.441
MIN RADIUS	:	.224	.263	.382
MEAN RADIUS	:	1.021	.917	.808
MAX RADIUS	:	1.780	1.733	1.235
HORIZONTAL SPREAD	:	1.798	1.798	1.262
VERTICAL SPREAD	:	2.866	2.342	1.966
EXTREME SPREAD	:	2.962	2.790	2.020
NUMBER IN ONE INCH CIRCLE =			2	
NUMBER IN TWO INCH CIRCLE =			4	
NUMBER IN THREE INCH CIRCLE =			8	

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CENTERFIRE PATTERNS # 3

POA



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 5

3 in = 9

HS= 2.467

VS= 2.326

GS= 3.142

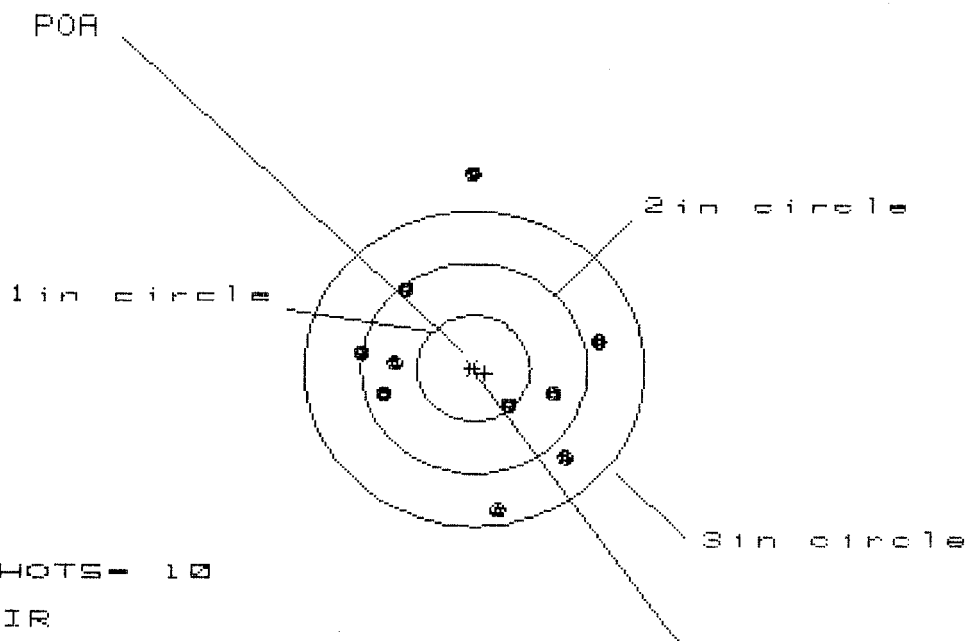
CENTROID *

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.931	.761	.734
MINIMUM X	:	-1.536	-1.304	-1.209
MAXIMUM Y	:	1.193	1.283	1.153
MINIMUM Y	:	-1.133	-1.043	-1.106
CENTROID X	:	-.063	.107	.012
CENTROID Y	:	-.074	-.164	-.034
POA TO CENTROID in.	:	.097	.196	.036
MIN RADIUS	:	.273	.329	.346
MEAN RADIUS	:	.983	.867	.823
MAX RADIUS	:	1.737	1.375	1.328
HORIZONTAL SPREAD	:	2.467	2.065	1.943
VERTICAL SPREAD	:	2.326	2.326	2.259
EXTREME SPREAD	:	3.142	2.643	2.527
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1 in - 1

2 in - 5

3 in - 4

HS- 2.117

VS= 3.155

GS= 3.160

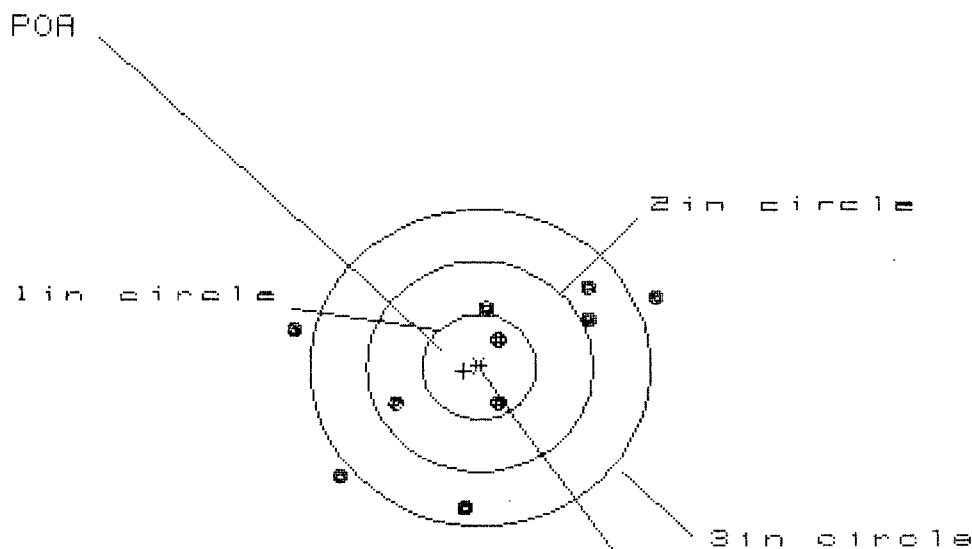
CENTROID #

PATTERN #	4		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.081	1.083	1.109
MINIMUM X	-1.036	-1.034	-1.008
MAXIMUM Y	1.814	.991	.849
MINIMUM Y	-1.341	-1.140	-.824
CENTROID X	-.101	-.103	-.129
CENTROID Y	.043	-.158	-.016
POA TO CENTROID in.	.110	.189	.130
MIN RADIUS	.498	.376	.477
MEAN RADIUS	1.032	.920	.888
MAX RADIUS	1.814	1.187	1.204
HORIZONTAL SPREAD	2.117	2.117	2.117
VERTICAL SPREAD	3.155	2.131	1.673
EXTREME SPREAD	3.160	2.280	2.221
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	9		

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CENTERFIRE PATTERNS # 5



OF SHOTS - 10

IN CIR

1 in = 2

2 in = 4

3 in = 7

HS = 3.146

VS = 2.150

GS = 3.189

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.511	1.329	.973
MINIMUM X	:	-1.635	-1.428	-1.262
MAXIMUM Y	:	.786	.824	.905
MINIMUM Y	:	-1.364	-1.326	-1.244
CENTROID X	:	.140	.322	.156
CENTROID Y	:	.039	.001	-.080
POA TO CENTROID in.	:	.146	.322	.175
MIN RADIUS	:	.331	.317	.252
MEAN RADIUS	:	1.067	.987	.922
MAX RADIUS	:	1.671	1.716	1.532
HORIZONTAL SPREAD	:	3.146	2.757	2.235
VERTICAL SPREAD	:	2.150	2.150	2.150
EXTREME SPREAD	:	3.189	3.189	2.828
NUMBER IN ONE INCH CIRCLE =			2	
NUMBER IN TWO INCH CIRCLE =			4	
NUMBER IN THREE INCH CIRCLE =			7	



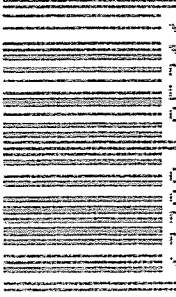

VERY IMPORTANT:
Instruction Book
enclosed to assure
safe use of this
firearm.

MODEL 700™ N24

SERIAL NO.
06523440

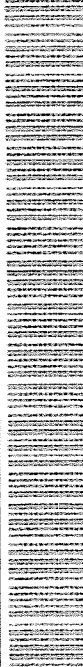
ORDER NO.
5716

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



UPC

0 4700 25716 7



5716 06523440

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6523440

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	10 9	90	RW
600	Proof	10 9	90	RW
607	Check Headspace	10 9	90	RW
610	Dis-assemble Gun	10 9	90	RW
612	Magnaflux Barrel Action		10/17/90	KR
	Magnaflux Bolt		10/17/90	KR
615	Rollmark Caliber		10/17/90	LL
617	Drill and Tap Sight Holes		10/18/90	KOB
618	Polish Barrel RWB		10/19/90	WLB
620	Apply Coatings (Barrel Action)		11-5-90	THA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		12/12/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		12/12/90	RW
	C) Inspect Ejector Hole for Chamfer		12/12/90	RW
	D) Oil Firing Pin Ass'y		12/12/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		1-14-91	M

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4.			1/13/91	JL
	G) Safety Off Force	3	3.	3			1/15/91	JL
	H) Trigger Pull Test & Retainability						1-14-91	JL
	I) Firing Pin Indent	.021	.020	.0205			1-15-91	JL
	J) Assemble Stock						1/16/91	RW
	K) Assemble Swivel Studs						1-17-91	JL
	L) Attach Front and Rear Sight Assemblies						1/16/91	RW
	M) Iron Sight Alignment						1/16/91	RW
	N) Detach Front & Rear Sights & place in numbered container						1/16/91	RW
	O) Attach Scope to Rifle						1/16/91	RW
	P) Detach & Attach Scope 20 Times						1/16/91	RW
640	Gallery Target & Test						1-16-91	AC
	A) Time						1-16-91	AC
	B) Malfunctions						1-16-91	AC
	C) Pierced Primers						1-16-91	AC
	D) Optical Clarity of Scope						1-16-91	AC
645	Inspect for Live Ammo						1-16-91	AC
655	Final Inspection						1-17-91	JL
	A) Headspace						1-17-91	JL
	B) Trigger Pull	2.37	2.35	2.27	2.29	2.30	1-17-91	JL
	C) Function						1-17-91	JL
660	Pack						3-19-91	RW

SWS TRIGGER PULL TEST

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

SERIAL NO. 06523440

DATE 1-14-91

TESTER JP

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.30	2.35	2.34	2.39	MIN. SETTING,
PULL #2	2.33	2.32	2.33	2.35	NO AVG. OF 5
PULL #3	2.37	2.33	2.29	2.27	READINGS ACCEPT-
PULL #4	2.35	2.31	2.24	2.29	ABLE LESS THAN 2#
PULL #5	2.37	2.34	2.20	2.30	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.49	3.25		
PULL #2	3.46	3.32		
PULL #3	3.30	3.22		
PULL #4	3.33	3.29		
PULL #5	3.32	3.22		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.29	4.26		4.30
PULL #2	4.16	4.32		4.26
PULL #3	4.28	4.26		4.30
PULL #4	4.27	4.28		4.24
PULL #5	4.21	4.29		4.39
TOTAL				
AVG.				

Arms Services Repair Estimate System

File Add Repair Estimate Repair Expedite Repair Inquiry Repair Tools CSR Tools Report Table Maintenance System Maintenance Help

Repair Number: **RE00032479** Serial: C6523440 Model 700 Center Fire Caliber: 7 62 NATO M24 SWS WOG 7 of 25 Repairman: Status: New 9/14/01 3:07:39 PM

Verify Repair

Address Information

Customer: ☒ Received From Return To: ☐ Received From

Name: DEFENCE DIST DEPOT ANNISTON DEFENCE DIST DEPOT ANNISTON

Address 1: 7 FRANKFORD AVE 7 FRANKFORD AVE

Address 2: PO Box: PO Box:

City: ANNISTON ANNISTON

State: AL Zip Code: 36201 Country: US State: AL Zip Code: 36201 Country: US

FFL:

Contact / Condition Problems Estimate History / Status Shipping / Billing

Contact Information

Phone: Fax: Email: Comments:

Received Condition

Fair

Condition Notes: CSR Notes:

Accessories Received

Code	Desc	Qty
A006	Sling Strap	1
A007	With Stud	3
A008	With Swivel	2
A010	Hard Case	1
A026	Scope	1
X001	Scope Case	1
X002	Deployment Kit	1

Repair Search Refresh Close

naglej 9/17/01 7:29 AM CAPS NUM JMS SCRL

Start Arms Services Repair... 7:29 AM

Serial Number: **C6523440**

Model: **700**



RE00032479

M-24 INSPECTION CHECKLIST
CONTRACT #: DAAE-20-97-C-242

R & E NUMBER 32429			
SERIAL NUMBER C 6523446			
LOG-IN DATE 9-13-01			
INSPECT AND VERIFY:			
OPERATION #	OPERATION NAME	DATE	INITIAL
550	DIS-ASSEMBLE GUN	N/A	
560 A	RE-BARREL AT CUSTOM SHOP	N/A	
B	DRILL AND TAP	N/A	
C	POLISH	N/A	
575	ASSEMBLE	N/A	
600	PROOF	N/A	
605	CHECK HEADSPACE	N/A	
610	DIS-ASSEMBLE GUN	N/A	
612	MAGNAFLUX	N/A	
615	ROLLMARK CALIBER	N/A	
618	ROTO-BLAST	N/A	
620	APPLY COATINGS	N/A	
625 A	FINAL ASSEMBLY	N/A	
B	TRIGGER PULL TEST	N/A	
C	SAFETY "ON" FORCE	N/A	
D	SAFETY "OFF" FORCE	N/A	
E	FIRING PIN INDENT	N/A	
640	TARGET TEST	9/21	AC
655	FINAL INSPECT	9-21-01	BA
660	PACK	9/25/01	DA
		SHIP DATE	
		QAR INSPECTION DATE	

MOD. _____ GA. CAL. _____ GUN # C6523440

# TEST	DATE	MALFUNCTION/DEFECT	ASSEM. #
	1st	power coat on barrel tackie <i>AC</i>	
	2nd		
	3rd		
	4th		
		FUNCTION	RD 5654 Rev 1

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