

C6523445

MODEL 700TM M24

Model **SMS** TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

C-6523445

Scope S/N 87-1126

Repair Number: RE00000769		Serial: C6523445 Model 700 Center Fire Caliber: 7.62 SWS M-24 180F1B		Repairman: Tom Nagle																		
Verify Repair				Status: New 12/15/99 1:43:46 PM																		
Address Information																						
Customer: ☒ Received From		Return To: ☐ Received From																				
Name: TRANSPORTATION OFFICER		TRANSPORTATION OFFICER																				
Address 1: XVIII AIRBORNE CORPS AND FORT BRAGG		XVIII AIRBORNE CORPS AND FORT BRAGG																				
Address 2: BUILDING J-2050 PO Box:		BUILDING J-2050 PO Box:																				
City: FORT BRAGG		FORT BRAGG																				
State: NC Zip Code: 28310 Country: US		State: NC Zip Code: 28310 Country: US																				
FFL: ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐																						
Contact / Condition		Problems		Estimate																		
History / Status		Shipping / Billing																				
Contact Information		Received Condition		Accessories Received																		
Phone:		Poor		<table border="1"><thead><tr><th>Code</th><th>Desc</th><th>Qty</th></tr></thead><tbody><tr><td>A010</td><td>Hard Case</td><td>1</td></tr><tr><td>A016</td><td>Scope Mounts</td><td>2</td></tr><tr><td>A017</td><td>Scope Base</td><td>1</td></tr><tr><td>A026</td><td>Scope</td><td>1</td></tr><tr><td colspan="3">7000 BLDG</td></tr></tbody></table>	Code	Desc	Qty	A010	Hard Case	1	A016	Scope Mounts	2	A017	Scope Base	1	A026	Scope	1	7000 BLDG		
Code	Desc	Qty																				
A010	Hard Case	1																				
A016	Scope Mounts	2																				
A017	Scope Base	1																				
A026	Scope	1																				
7000 BLDG																						
Fax:		Condition Notes:																				
Email:		CSR Notes:																				
Comments:																						
Repair Search		Refresh		Close																		

BBL 96003



TRACKING DOCUMENT

Repair Order Number



Repair Order Numbe RE00000769	Description/Serial C6523445	Repairman - Tom Nagle Date Received 12/15/1999
Account # - R-	Model 700 Center Fire Caliber: 7.62 SWS M-24 18OF18	Estimate Date Current Date - 12/16/1999
<u>Customer</u> TRANSPORTATION OFFICER XVIII AIRBORNE CORPS AND FORT B BUILDING J-2050 FORT BRAGG NC 28310 US		<u>Return To</u> TRANSPORTATION OFFICER XVIII AIRBORNE CORPS AND FORT BUILDING J-2050 FORT BRAGG NC 28310 US
Phone (H) Phone (W)		Fax Email

Problems	
Reported	Found

Repair		Quantity Needed	Quantity From	Quantity From	Warranty (Y/N)
Material #	MaterialDesc				
Total:					
Serial Number: C6523445 Model ID: 700					



RE00000769

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

Remington Test Lab, Ilion, N.Y.

Centroidal distance calculations for Rifle # C6523445
7 Apr 2000

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .3214
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .2174
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .388022

THE AMR FOR THIS RIFLE IS: 1.087

CENTROIDAL DISTANCES

0 TO	1	1.25148
1 TO	2	1.08446
1 TO	3	.790919
1 TO	4	1.47801
1 TO	5	1.13661

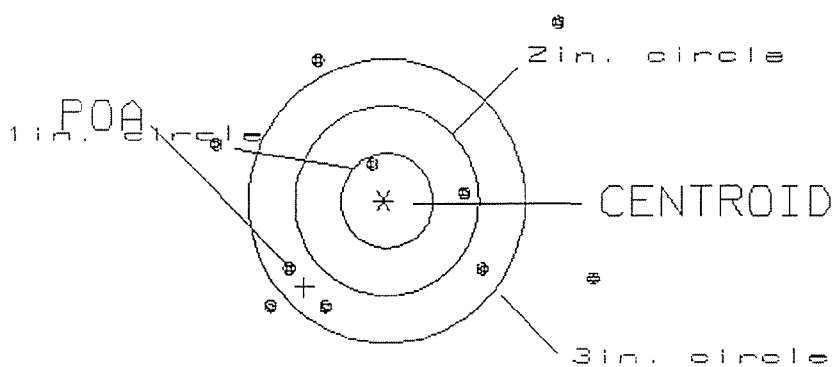
1
3
+5 2 <----POA
4

PATTERN #: ☐ 1 ☐
 POA TO CENTROID: 1.251
 MIN RADIUS : .446
 MEAN RADIUS : 1.547
 MAX RADIUS : 2.638
 CENTROID X : .857
 CENTROID Y : .912

7 Apr 2000

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/C6523445.1

CENTERFIRE PATTERN # 1



OF SHOTS= 10

IN CIRCLE

HS= 4.12

1

VS= 3.07

2

GS= 4.34

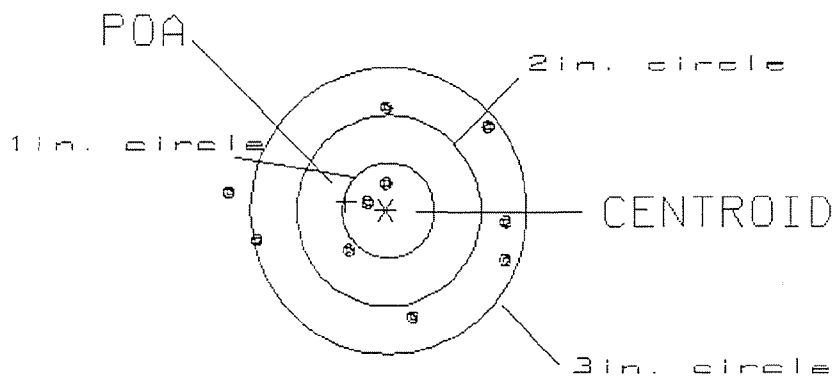
5

PATTERN #: ☐ 2 ☐
 POA TO CENTROID: .436
 MIN RADIUS : .275
 MEAN RADIUS : 1.061
 MAX RADIUS : 1.786
 CENTROID X : .428
 CENTROID Y : -.084

7 Apr 2000

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/C6523445.1

CENTERFIRE PATTERN # 2



OF SHOTS= 10

IN CIRCLE

HS= 3.07

2

VS= 2.14

3

GS= 3.11

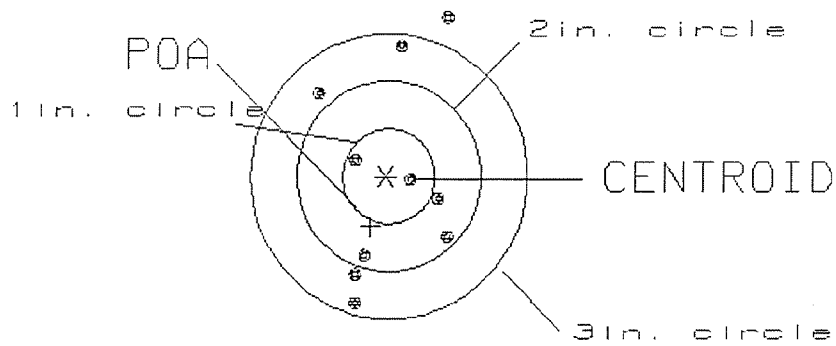
5

PATTERN #: 3
 POA TO CENTROID: .554
 MIN RADIUS : .249
 MEAN RADIUS : .981
 MAX RADIUS : 1.789
 CENTROID X : .165
 CENTROID Y : .529

7 Apr 2000

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/C6523445.1

CENTERFIRE PATTERN # 3



OF SHOTS= 10

IN CIRCLE

HS= 1.49

2

VS= 3.00

5

GS= 3.19

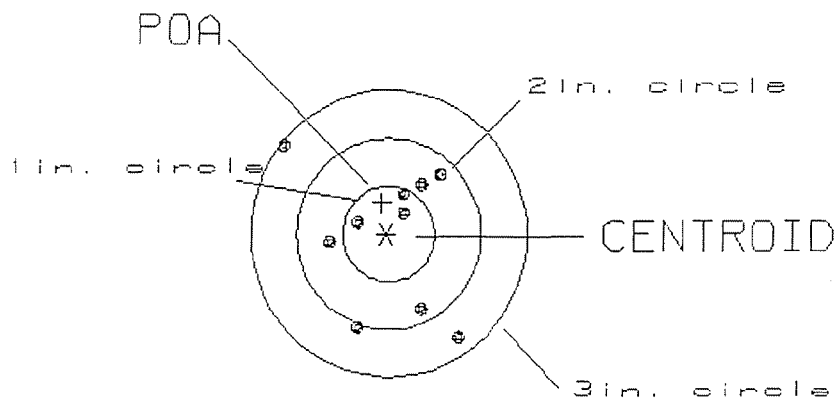
9

PATTERN #: ☐ 4 ☐
 POA TO CENTROID: .324
 MIN RADIUS : .247
 MEAN RADIUS : .794
 MAX RADIUS : 1.495
 CENTROID X : .042
 CENTROID Y : -.321

7 Apr 2000

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/C6523445.1

CENTERFIRE PATTERN # 4



OF SHOTS= 10

IN CIRCLE

HS= 1.97

2

VS= 1.96

7

GS= 2.78

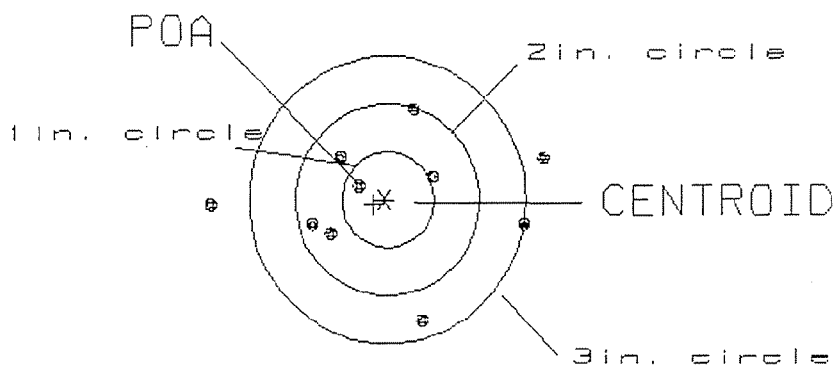
10

PATTERN #: 5
 POA TO CENTROID: .126
 MIN RADIUS : .371
 MEAN RADIUS : 1.052
 MAX RADIUS : 1.918
 CENTROID X : .115
 CENTROID Y : .051

7 Apr 2000

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/C6523445.1

CENTERFIRE PATTERN # 5



OF SHOTS= 10

IN CIRCLE

HS= 3.57

2

US= 2.14

6

GS= 3.61

8

21 DAY TURN - AROUND

M-24

CONTRACT # DAAA09-92-C-0834

R&E NO.

SERIAL NO. *C6523445*

LOG IN DATE: / /		DATE	INT.
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>4-5-00</i>	<i>RW</i>
655	FINAL INSPECT	<i>4-10-00</i>	<i>RW</i>
660	PACK		

QAR INSPECTION

SHIP DATE

Final Inspection

S/N: C6523445 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

Remington®

MODEL 700™ H24

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

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

REG. U.S. PAT. & TM. OFF.

DUPONT

SERIAL NO. 06523445

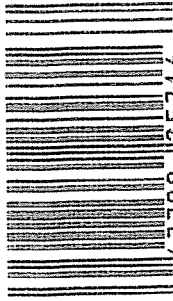
ORDER NO. 5716

01



5716 06523445

LPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # *C6523 445*

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	9 24	90	<i>Rw</i>
600	Proof	9 24	90	<i>Rw</i>
607	Check Headspace	9 24	90	<i>Rw</i>
610	Dis-assemble Gun	9 24	90	<i>Rw</i>
612	Magnaflux Barrel Action		9-25-90	<i>RR</i>
	Magnaflux Bolt		9-25-90	<i>RR</i>
615	Rollmark Caliber		9-25-90	<i>RR</i>
617	Drill and Tap Sight Holes		9-25-90	<i>FB</i>
618	Polish Barrel <i>RB</i>		9/28/90	<i>WB</i>
620	Apply Coatings (Barrel Action)		10-2-90	<i>TA</i>
	Apply Coating (Bolt)		10-2-90	<i>TA</i>
625	Final Assembly A) Clean inside of Bolt Assembly		10/9/90	<i>Rw</i>
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/9/90	<i>Rw</i>
	C) Inspect Ejector Hole for Chamfer		10/9/90	<i>Rw</i>
	D) Oil Firing Pin Ass'y		10/9/90	<i>Rw</i>
	E) Adjust Trigger Pull to Min Setting and Stake		10/31/90	<i>HL</i>

op. #	OP. NAME	READINGS					DATE	INIT
625 nt.	F) Safety On Force	5	5	5			10/31/90	WLB
	G) Safety Off Force	2 3/4	2 3/4	2 3/4			10/31/90	WLB
	H) Trigger Pull Test & Retainability						10/30/90	JS
	I) Firing Pin Indent	.0225	.0225	.0225			10/31/90	WLB
	J) Assemble Stock						11/1/90	RW
	K) Assemble Swivel Studs						11/1/90	JS
	L) Attach Front and Rear Sight Assemblies						11/1/90	RW
	M) Iron Sight Alignment						11/1/90	RW
	N) Detach Front & Rear Sights & place in numbered container						11/1/90	RW
	O) Attach Scope to Rifle						11/1/90	RW
	P) Detach & Attach Scope 20 Times						11/1/90	RW
640	Gallery Target & Test						11-2-90	DH
	A) Time						11-2-90	DH
	B) Malfunctions						11-2-90	DH
	C) Pierced Primers						11-2-90	DH
	D) Optical Clarity of Scope						11-2-90	DH
645	Inspect for Live Ammo						11-2-90	DH
655	Final Inspection							
	A) Headspace						11/19/90	JS
	B) Trigger Pull	282	277	273	268	271	11/19/90	JS
	C) Function						11/19/90	JS
660	Pack						12/18/90	NF

SWS TRIGGER PULL TEST

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

SERIAL NO. C6523445
DATE 10/30/98
TESTER JEP

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.24	2.44	2.41	2.82	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.28	2.28	2.25	2.71	
PULL #3	2.28	2.30	2.27	2.73	
PULL #4	2.22	2.37	2.29	2.68	
PULL #5	2.25	2.35	2.30	2.71	
TOTAL	11.27	11.74	11.42		
AVG.	2.254	2.348	2.284		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.28	3.46		
PULL #2	3.28	3.43		
PULL #3	3.29	3.46		
PULL #4	3.21	3.40		
PULL #5	3.33	3.45		
TOTAL	16.39	17.2		
AVG.	3.278	3.44		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.30	4.10		4.23
PULL #2	4.28	4.37		4.45
PULL #3	4.12	4.11		4.38
PULL #4	4.27	4.24		4.44
PULL #5	4.24	4.24		4.36
TOTAL	21.21	21.06		21.86
AVG.	4.242	4.212		4.372

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6523445
2 Nov 1990

CENTROIDAL DISTANCES

0 TO	1	.340847
1 TO	2	.240635
1 TO	3	.437887
1 TO	4	.112805
1 TO	5	.3722

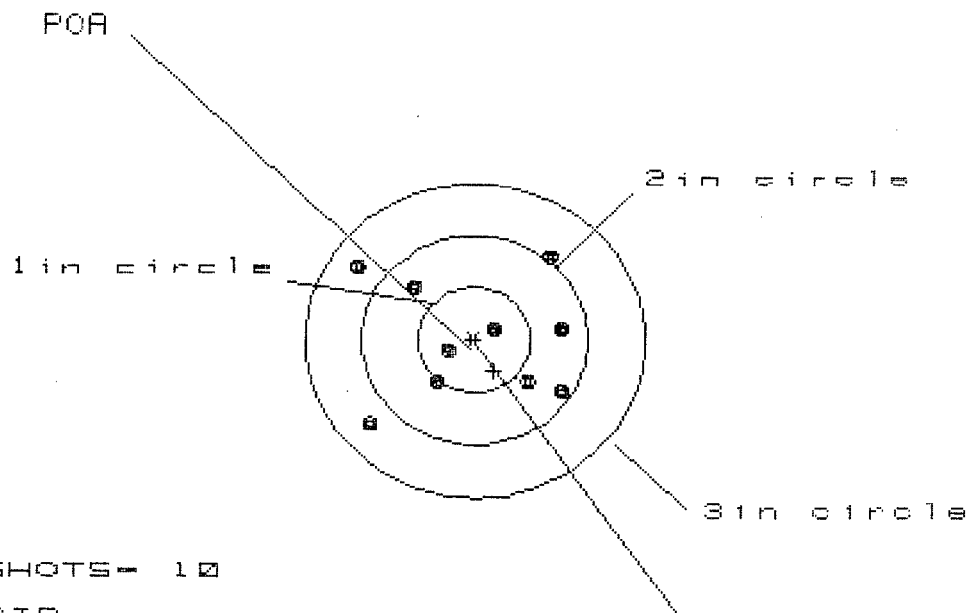
3 1/2 <----FOR

AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1144
AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1206
AVERAGE POI RADIUS FOR THIS RIFLE IS: .166228
AVERAGE POI THIS RIFLE IS: .7968

1 NOV 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C6523445

CENTERFIRE PATTERNS # 1



OF SHOTS - 10

IN CIR

1in = 2

2in = 7

3in = 10

HS = 1.879

VS = 1.539

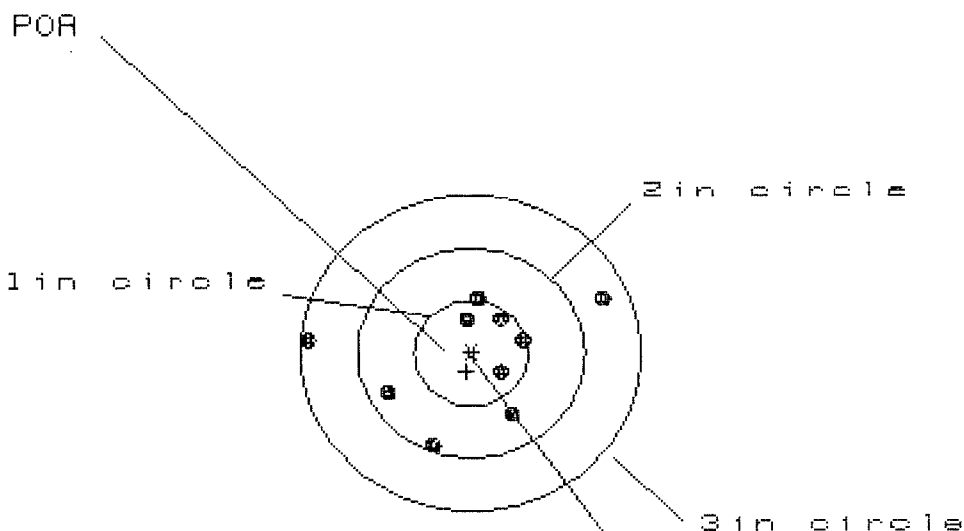
GS = 2.234

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.816	.698	.571
MINIMUM X	:	-1.063	-1.019	-.795
MAXIMUM Y	:	.789	.864	.780
MINIMUM Y	:	-.750	-.675	-.545
CENTROID X	:	-.169	-.051	.076
CENTROID Y	:	.296	.221	.305
POA TO CENTROID in.	:	.341	.227	.314
MIN RADIUS	:	.248	.234	.133
MEAN RADIUS	:	.771	.705	.628
MAX RADIUS	:	1.258	1.222	.948
HORIZONTAL SPREAD	:	1.879	1.717	1.366
VERTICAL SPREAD	:	1.539	1.539	1.325
EXTREME SPREAD	:	2.234	2.227	1.730
NUMBER IN ONE INCH CIRCLE =			2	
NUMBER IN TWO INCH CIRCLE =			7	
NUMBER IN THREE INCH CIRCLE =			10	

2 Nov 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C8523445

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 4

2in = 8

3in = 10

HS= 2.577

VS= 1.413

GS= 2.603

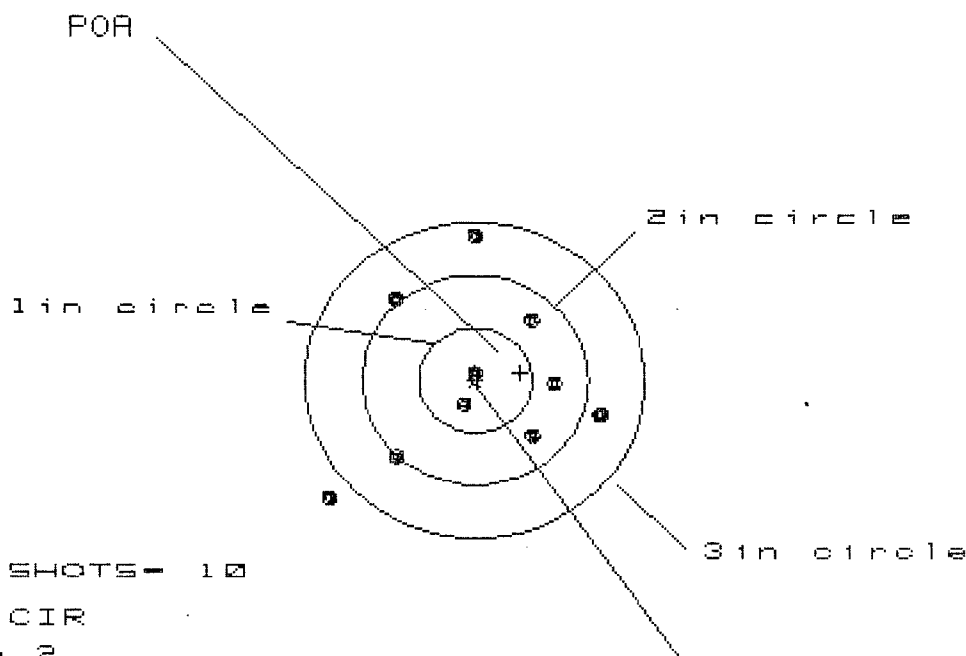
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.132	.972	.400
MINIMUM X	:	-1.445	-.868	-.747
MAXIMUM Y	:	.549	.565	.631
MINIMUM Y	:	-.864	-.848	-.782
CENTROID X	:	.039	.200	.078
CENTROID Y	:	.175	.159	.093
POA TO CENTROID in.	:	.179	.255	.122
MIN RADIUS	:	.283	.186	.219
MEAN RADIUS	:	.711	.599	.549
MAX RADIUS	:	1.451	1.105	.856
HORIZONTAL SPREAD	:	2.577	1.840	1.147
VERTICAL SPREAD	:	1.413	1.413	1.413
EXTREME SPREAD	:	2.603	2.049	1.453
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	

2 Nov 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6523445

CENTERFIRE PATTERNS # 3



OF SHOTS - 10

IN CIR

1 in = 2

2 in = 5

3 in = 9

HS = 2.356

VS = 2.486

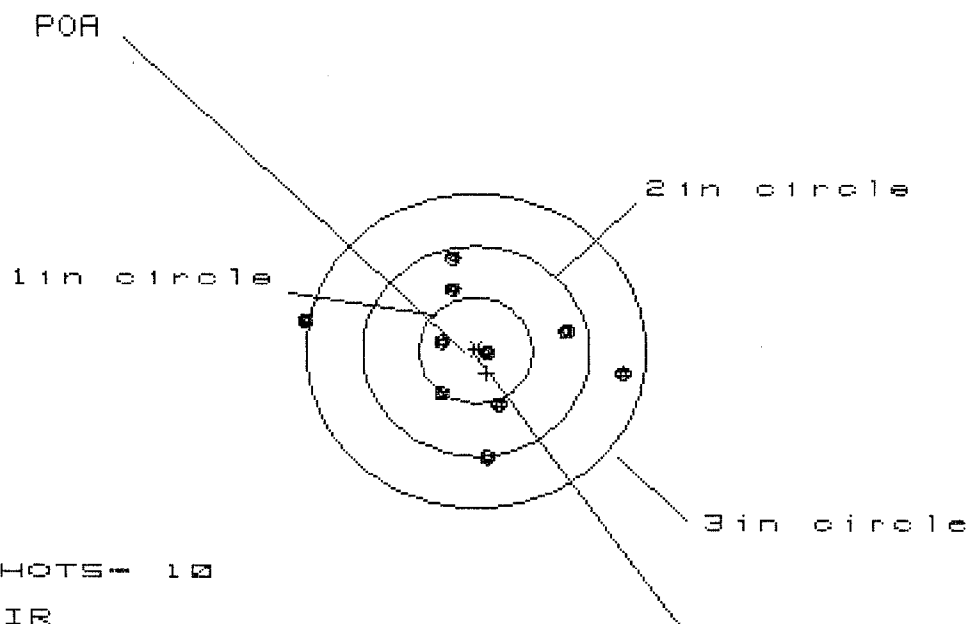
GS = 2.768

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.098	.958	.935
MINIMUM X	:	-1.258	-.889	-.911
MAXIMUM Y	:	1.352	1.226	.805
MINIMUM Y	:	-1.134	-.805	-.652
CENTROID X	:	-.400	-.260	-.237
CENTROID Y	:	-.076	.050	-.103
POA TO CENTROID in.	:	.407	.265	.259
MIN RADIUS	:	.096	.106	.165
MEAN RADIUS	:	.871	.768	.693
MAX RADIUS	:	1.694	1.239	1.194
HORIZONTAL SPREAD	:	2.356	1.847	1.847
VERTICAL SPREAD	:	2.486	2.031	1.457
EXTREME SPREAD	:	2.768	2.151	2.119
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

2 Nov 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6523445

CENTERFIRE PATTERNS # 4



OF SHOTS - 10

IN CIR

1in = 3

2in = 7

3in = 10

HS = 2.746

VS = 1.925

GS = 2.791

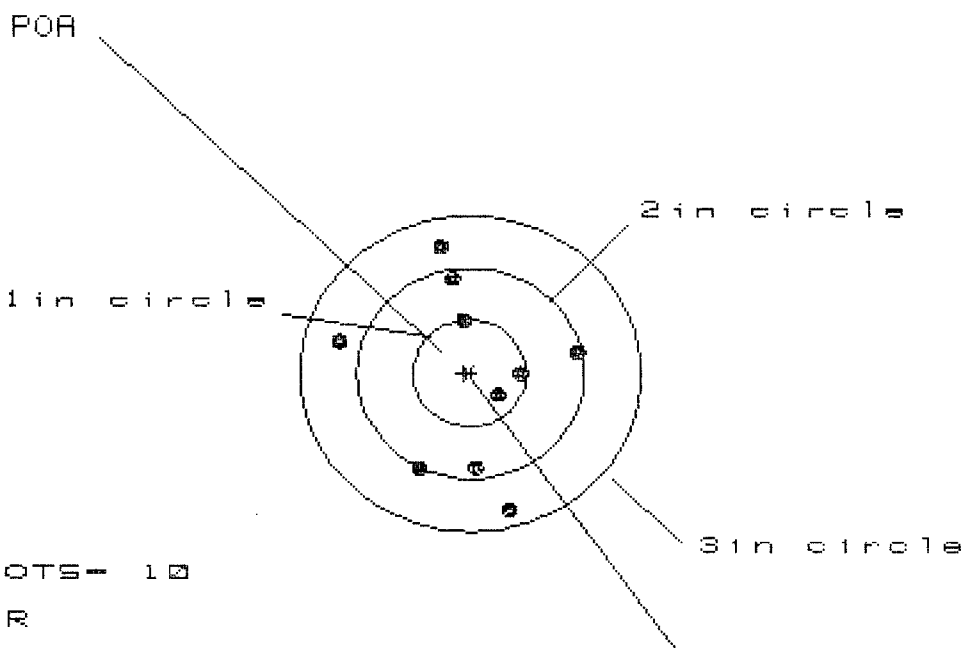
CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.290	1.128	.780
MINIMUM X	:	-1.456	-.506	-.365
MAXIMUM Y	:	.922	.955	.934
MINIMUM Y	:	-1.003	-.970	-.991
CENTROID X	:	-.096	.066	-.075
CENTROID Y	:	.210	.177	.198
POA TO CENTROID in.	:	.231	.189	.212
MIN RADIUS	:	.112	.055	.091
MEAN RADIUS	:	.763	.678	.603
MAX RADIUS	:	1.486	1.141	.992
HORIZONTAL SPREAD	:	2.746	1.634	1.145
VERTICAL SPREAD	:	1.925	1.925	1.925
EXTREME SPREAD	:	2.791	1.945	1.945
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

2 Nov 1990

FILE:/PATTERNING/CENTERFIRE_PATT/06523445

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 2

2in = 6

3in = 10

HS= 2.023

VS= 2.488

GS= 2.557

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.900	.943	.923
MINIMUM X	:	-1.123	-1.080	-1.100
MAXIMUM Y	:	1.220	1.079	.858
MINIMUM Y	:	-1.268	-1.042	-.907
CENTROID X	:	.054	.011	.031
CENTROID Y	:	-.002	.139	.004
POA TO CENTROID in.	:	.054	.139	.032
MIN RADIUS	:	.327	.408	.349
MEAN RADIUS	:	.868	.811	.768
MAX RADIUS	:	1.325	1.120	1.149
HORIZONTAL SPREAD	:	2.023	2.023	2.023
VERTICAL SPREAD	:	2.488	2.121	1.765
EXTREME SPREAD	:	2.557	2.135	2.027
NUMBER IN ONE INCH CIRCLE =			2	
NUMBER IN TWO INCH CIRCLE =			6	
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. C6523445

DATE _____

TESTER RW

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.63	2.58	2.59		MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.58	2.67	2.62		
PULL #3	2.66	2.86	2.32		
PULL #4	2.52	2.76	2.50		
PULL #5	2.84	2.70	2.35		
TOTAL	13.23	13.57	12.38		
AVG.	2.65	2.71	2.48		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.18	3.02		
PULL #2	3.26	3.23		
PULL #3	3.34	3.10		
PULL #4	3.15	3.35		
PULL #5	3.28	3.12		
TOTAL	16.21	15.82		
AVG.	3.24	3.16		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.00	4.16		4.22
PULL #2	4.00	4.13		4.18
PULL #3	4.14	4.10		4.16
PULL #4	4.25	4.05		4.10
PULL #5	4.00	4.08		4.15
TOTAL	20.39	20.52		20.81
AVG.	4.08	4.10		4.16

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6523445

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	6	5 1/2			12/4	WB
	G) Safety Off Force	3 1/2	3 1/2	3 1/2			12/4	WB
	H) Trigger Pull Test & Retainability							
	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							
	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	2.81	2.86	2.88	2.76	2.87	12/4	WB
	C) Function							
660	Pack							