

06348936

MODEL 760™ N24

Model **SWS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



Repair Number: **RE00018374** Serial: C6348936 Model: 700 Center Fire Caliber: 7.62 NATO M 24 (SWS) Repairman: Status: Closed 12/5/00 7:47:54 AM

Address Information

Customer: ☒ Received From: Return To: ☒ Received From:

Name: **COMMANDER** **COMMANDER**

Address 1: **HSC 3/10 SFG (A)** **HSC 3/10 SFG (A)**

Address 2: PO Box: PO Box:

City: **FORT CARSON** **FORT CARSON**

State: **CO** Zip Code: **80913** Country: **US** State: **CO** Zip Code: **80913** Country: **US**

FFL: ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐

Contact / Condition **Problems** **Estimate** **History / Status** **Shipping / Billing**

Contact Information:

Phone:

Fax:

Email:

Comments:

Received Condition:

Condition: **Poor**

Condition Notes:

CSR Notes:

Accessories Received:

Code	Desc	Qty
A007	With Stud	1
A009	With Swivel	1
A016	Scope Mounts	1
A017	Scope Base	1
A026	Scope	1

Repair Search **Refresh** **Close**

Start 12/5/00 9:35 AM NUM

Number: **C6348936**

Model: **700**



RE00018374

Final Inspection

SN: C6348936

DATE REC'D: 11-30-00

DATE RET'D:

AUDITOR: CLK

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: _____

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

R & E NUMBER 18374			
SERIAL NUMBER C6348936			
LOG-IN DATE 11-30-00			
INSPECT AND VERIFY:			
OPERATION #	OPERATION NAME	DATE	INITIAL
550	DIS-ASSEMBLE GUN	12-4-00	C/K
560 A	RE-BARREL AT CUSTOM SHOP		
B	DRILL AND TAP		
C	POLISH		
575	ASSEMBLE		
600	PROOF	12-6-00	C/K
605	CHECK HEADSPACE	12-6-00	
610	DIS-ASSEMBLE GUN		
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	12-17-00	C/K
655	FINAL INSPECT	12-28-00	C/K
660	PACK		
		SHIP DATE	
QAR INSPECTION DATE			

Remington Test Lab, Ilion, N.Y.

Centroidal distance calculations for Rifle # c6348936
15 Jan 2001

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1288
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0742
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .148644

THE AMR FOR THIS RIFLE IS: 1.194

CENTROIDAL DISTANCES

0	TO	1	.123471
1	TO	2	.0134164
1	TO	3	.223486
1	TO	4	.283706
1	TO	5	.167967

+ $\frac{2}{5}$ ₄ <----POA

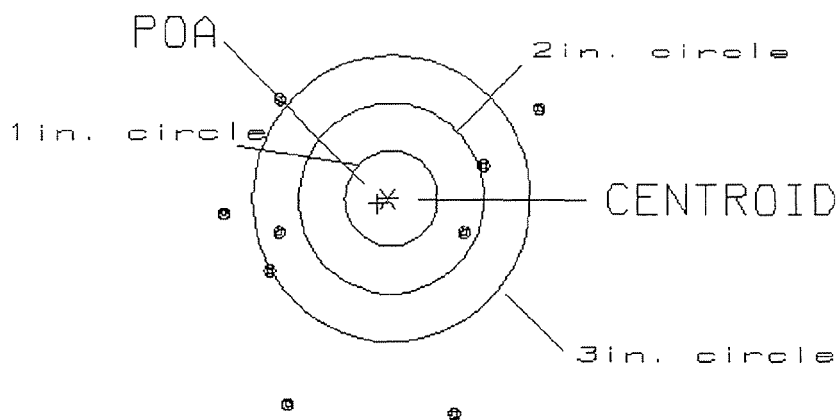
PATTERN #: 1

POA TO CENTROID: .124
 MIN RADIUS : .910
 MEAN RADIUS : 1.936
 MAX RADIUS : 4.560
 CENTROID X : .109
 CENTROID Y : .058

15 Jan 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6348936.1.1

CENTERFIRE PATTERN # 1



OF SHOTS= 10

IN CIRCLE

HS= 4.25

0

VS= 6.12

1

GS= 6.96

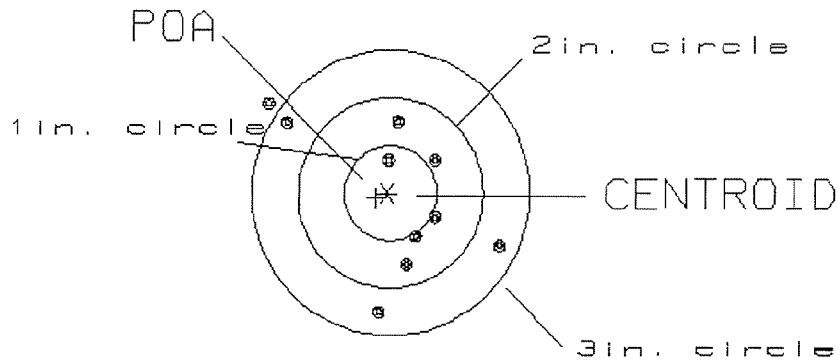
3

PATTERN #: ☐ 2 ☐
 POA TO CENTROID: .132
 MIN RADIUS : .364
 MEAN RADIUS : .907
 MAX RADIUS : 1.597
 CENTROID X : .121
 CENTROID Y : .052

15 Jan 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6348936.1.1

CENTERFIRE PATTERN # 2



OF SHOTS= 10

IN CIRCLE

HS= 2.44
 VS= 2.16
 GS= 2.86

1
 6
 9

PATTERN #: ☐ 3 ☐

POA TO CENTROID: .247

MIN RADIUS : .050

MEAN RADIUS : .806

MAX RADIUS : 1.925

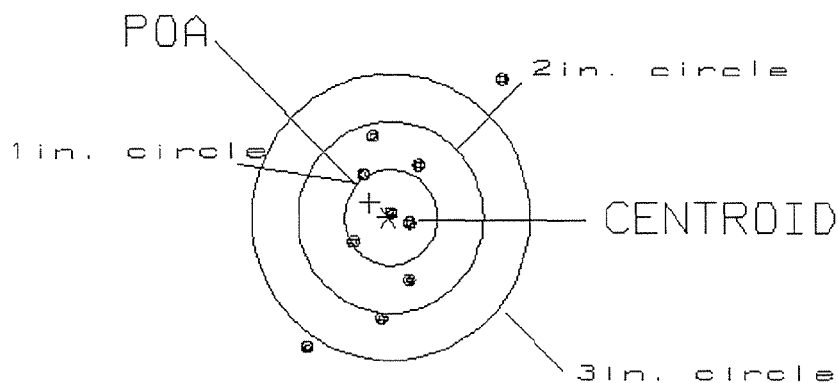
CENTROID X : .198

CENTROID Y : -.147

15 Jan 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6348936.1.1

CENTERFIRE PATTERN # 3



OF SHOTS= 10

IN CIRCLE

HS= 2.17

3

VS= 2.65

7

GS= 3.58

8

PATTERN #: ☐ 4 ☐

POA TO CENTROID: .242

MIN RADIUS : .610

MEAN RADIUS : 1.302

MAX RADIUS : 2.997

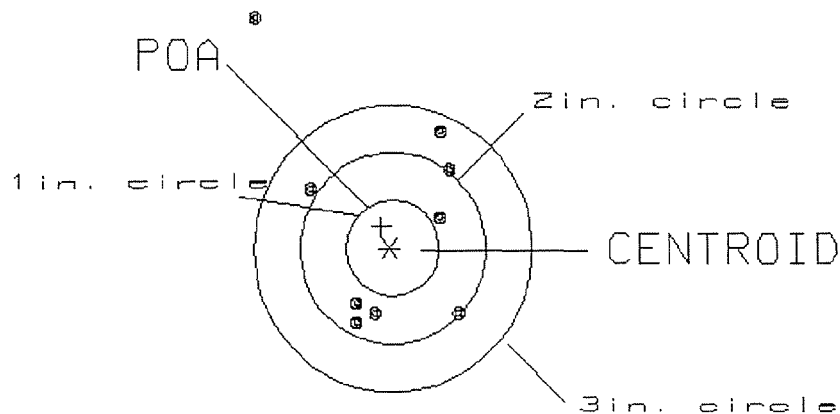
CENTROID X : .089

CENTROID Y : -.225

15 Jan 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6348936.1.1

CENTERFIRE PATTERN # 4



OF SHOTS= 10

IN CIRCLE

HS= 2.53

0

VS= 5.18

6

GS= 5.76

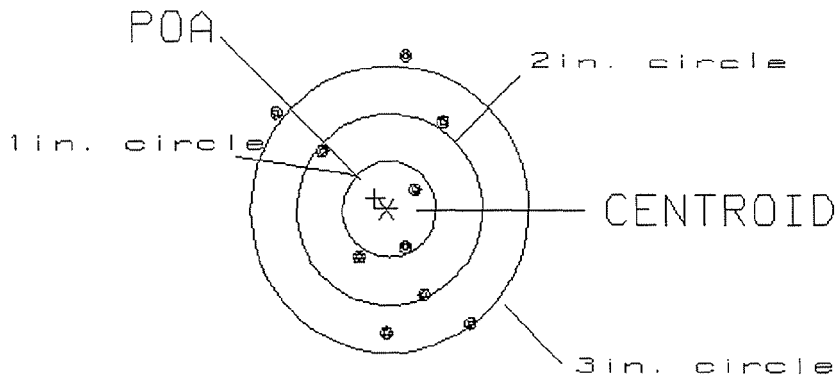
8

PATTERN #: 5
 POA TO CENTROID: .167
 MIN RADIUS : .299
 MEAN RADIUS : 1.021
 MAX RADIUS : 1.601
 CENTROID X : .127
 CENTROID Y : -.109

15 Jan 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6348936.1.1

CENTERFIRE PATTERN # 5



OF SHOTS= 10

IN CIRCLE

HS= 2.08

2

VS= 2.82

5

GS= 3.02

8

Remington Test Lab, Ilion, N.Y.

Centroidal distance calculations for Rifle # c6348936
10 Jan 2001

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0858
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0456
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0971648

THE AMR FOR THIS RIFLE IS: 1.591

CENTROIDAL DISTANCES

0	TO	1	.453927
1	TO	2	.870067
1	TO	3	1.118
1	TO	4	.651153
1	TO	5	.594577

2

1 + <3---POA

4

5

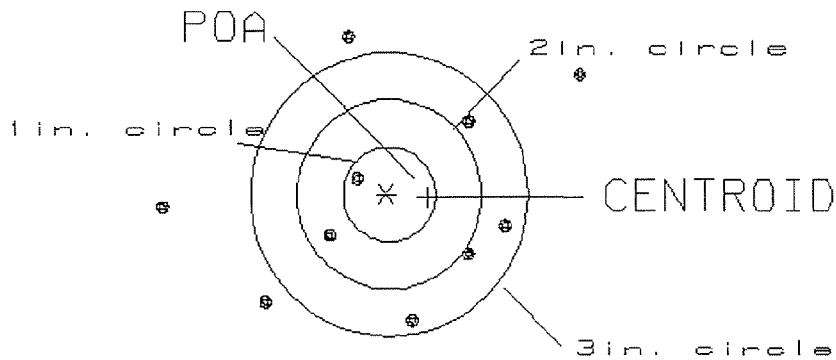
PATTERN #: ☐ 1 ☐

POA TO CENTROID: .454
 MIN RADIUS : .385
 MEAN RADIUS : 1.442
 MAX RADIUS : 2.443
 CENTROID X : -.453
 CENTROID Y : .029

10 Jan 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6348936

CENTERFIRE PATTERN # 1



OF SHOTS= 10

IN CIRCLE

HS= 4.46
 VS= 2.98
 GS= 4.67

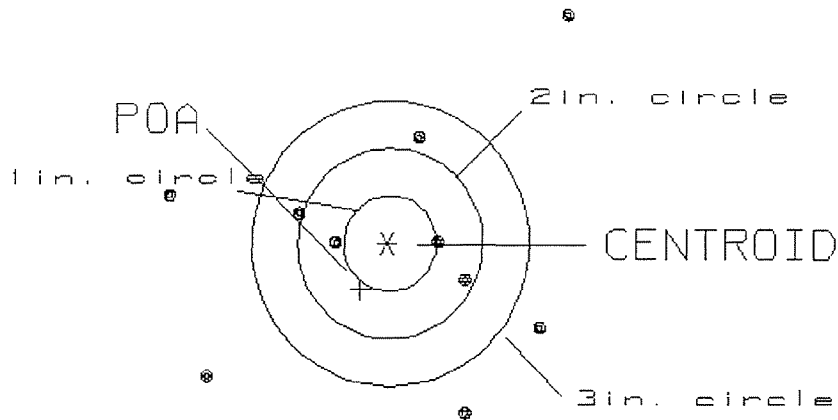
1
 2
 6

PATTERN #: 2
 POA TO CENTROID: .564
 MIN RADIUS : .491
 MEAN RADIUS : 1.600
 MAX RADIUS : 3.059
 CENTROID X : .288
 CENTROID Y : .485

10 Jan 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6348936

CENTERFIRE PATTERN # 2



OF SHOTS= 10

IN CIRCLE

HS= 4.37
 VS= 4.17
 GS= 5.42

1
 3
 5

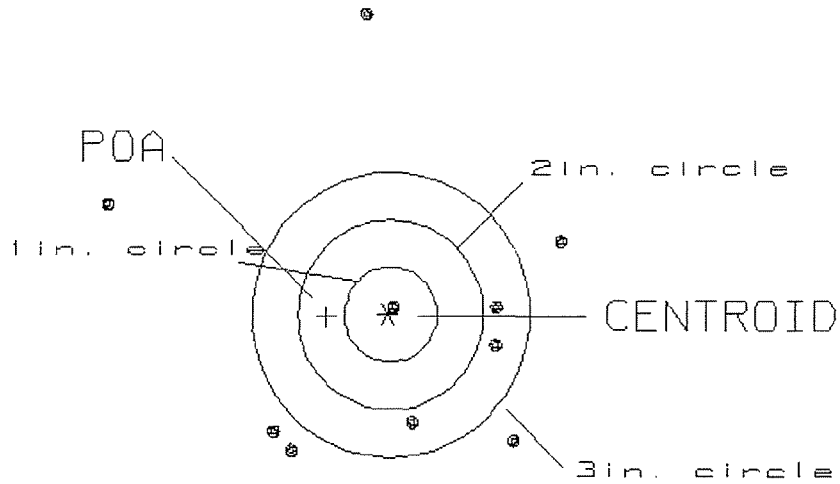
PATTERN #: 3

POA TO CENTROID: .666
 MIN RADIUS : .121
 MEAN RADIUS : 1.742
 MAX RADIUS : 3.333
 CENTROID X : .665
 CENTROID Y : .027

10 Jan 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6348936

CENTERFIRE PATTERN # 3



OF SHOTS= 10

IN CIRCLE

HS= 4.92
 VS= 4.56
 GS= 5.14

1
 1
 4

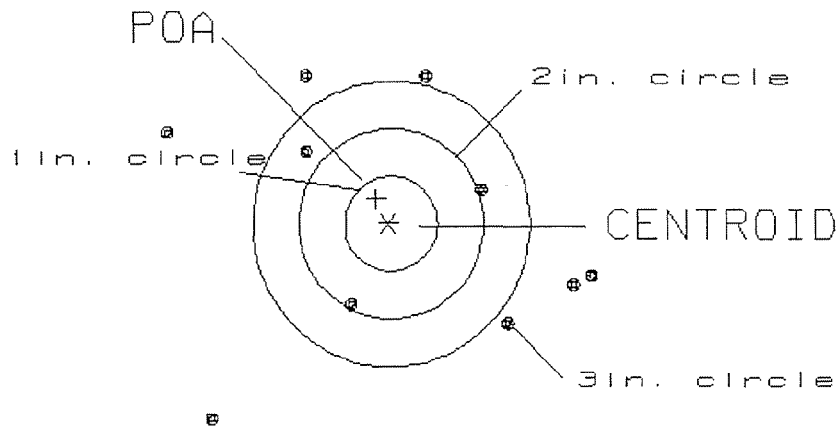
PATTERN #: 4

POA TO CENTROID: .291
 MIN RADIUS : .940
 MEAN RADIUS : 1.782
 MAX RADIUS : 2.813
 CENTROID X : .131
 CENTROID Y : -.259

10 Jan 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6348936

CENTERFIRE PATTERN # 4



OF SHOTS= 10

IN CIRCLE

HS= 4.56
 VS= 3.58
 GS= 4.79

0
 1
 3

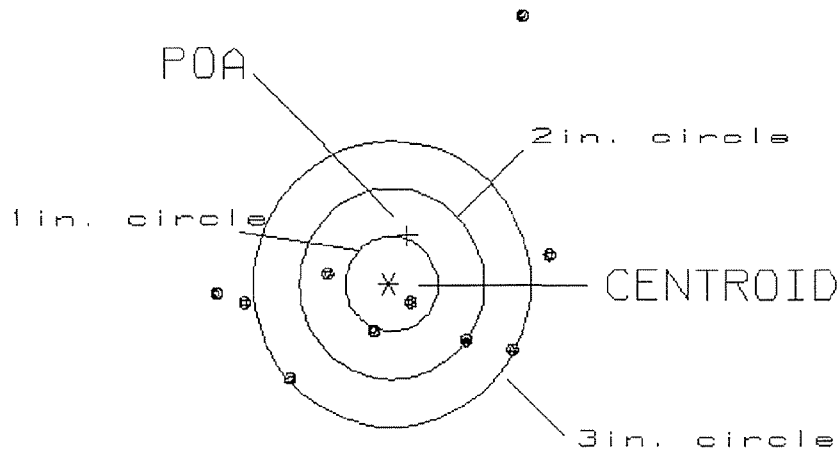
PATTERN #: 5

POA TO CENTROID: .548
 MIN RADIUS : .310
 MEAN RADIUS : 1.388
 MAX RADIUS : 3.156
 CENTROID X : -.202
 CENTROID Y : -.510

10 Jan 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6348936

CENTERFIRE PATTERN # 5



OF SHOTS= 10

IN CIRCLE

HS= 3.59
 VS= 3.87
 GS= 4.58

1
 4
 6




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

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

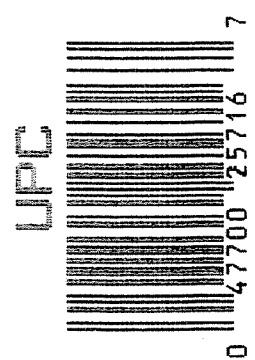
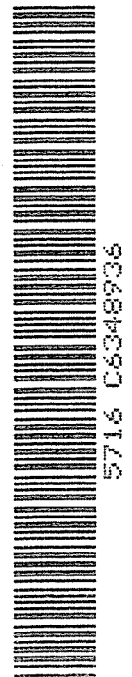
MODEL 700™ H24

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

SERIAL NO.
C6348936

ORDER NO.
5716

Q1



CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6348936

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	9 14	89	RW
600	Proof	9 14	89	RW
607	Check Headspace	9 14	89	RW
610	Dis-assemble Gun	9 14	89	RW
612	Magnaflux Barrel Action	9-14-89		KCR
	Magnaflux Bolt	9-14-89		KCR
615	Rollmark Caliber		9-15-89	GS
7	Drill and Tap Sight Holes	9 15	89	fg
618	Polish Barrel	9 15	89	BT
620	Apply Coatings (Barrel Action)		9-15-89	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		9/26/89	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		9/26/89	RW
	C) Inspect Ejector Hole for Chamfer		9/26/89	RW
	D) Oil Firing Pin Ass'y		9/26/89	RW
	E) Adjust Trigger Pull to Min Setting and Stake		10/2/89	JS

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			10/11/89	gH
	G) Safety Off Force	4	4	4			10/11/89	gH
	H) Trigger Pull Test & Retainability						10 Oct 89	gH
	I) Firing Pin Indent	.021	.021	.022			10/11/89	gH
	J) Assemble Stock						10/11/89	RW
	K) Assemble Swivel Studs						13 Oct 89	gH
	L) Attach Front and Rear Sight Assemblies						10/11/89	RW
	M) Iron Sight Alignment						10/11/89	RW
	N) Detach Front & Rear Sights & place in numbered container						10/11/89	RW
	O) Attach Scope to Rifle						10/11/89	gH
	P) Detach & Attach Scope 20 Times						10/11/89	gH
640	Gallery Target & Test						10-12-89	DH
	A) Time						10-12-89	DH
	B) Malfunctions						10-12-89	DH
	C) Pierced Primers						10-12-89	DH
	D) Optical Clarity of Scope						10-12-89	DH
645	Inspect for Live Ammo						10-12-89	DH
655	Final Inspection							
	A) Headspace						13 Oct 89	gH
	B) Trigger Pull	243	242	235	242	244	13 Oct 89	gH
	C) Function						13 Oct 89	gH
660	Pack						15 Dec 89	gH

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. 8936

DATE 23 MAR 90

TESTER JAS

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#	COMMENTS
PULL #1	238	233	220	MIN. SETTING,
PULL #2	238	230	209	NO AVG. OF 5
PULL #3	238	227	211	READINGS ACCEPT-
PULL #4	239	225	209	ABLE LESS THAN 2#
PULL #5	233	232	209	
TOTAL	1186	1157		
AVG.	237.2	231.4		

	3.00# INITIAL	3.00# AFTER 20 CYCLES	COMMENTS
PULL #1	3.05	291	
PULL #2	298	290	
PULL #3	296	288	
PULL #4	292	292	
PULL #5	299	297	
TOTAL	1490	1464	
AVG.	298	292.8	

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.02	403		
PULL #2	4.02	400		
PULL #3	404	396		
PULL #4	403	402		
PULL #5	402	400		
TOTAL	2013	2001		
AVG.	402.6	400.2		

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6348936
12 Oct 1989

CENTROIDAL DISTANCES

0 TO	1	.295743
1 TO	2	.051
1 TO	3	.432695
1 TO	4	.225801
1 TO	5	.994399

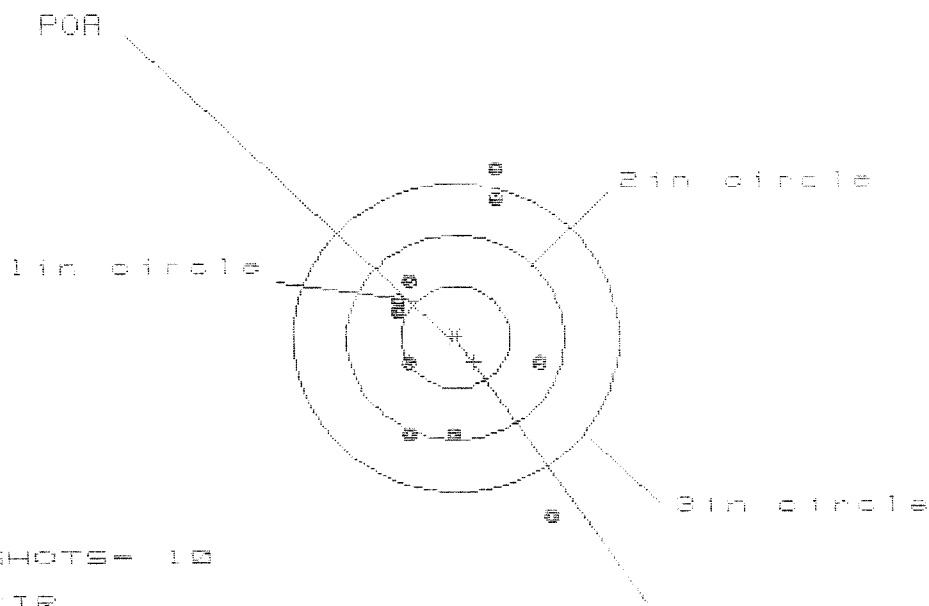
5 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0472
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1382
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .146038
THE AMR FOR THIS RIFLE IS: .9272

12 Oct 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C8348936

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1 in = 0

2 in = 6

3 in = 8

HS = 1.490

VS = 3.315

QS = 3.353

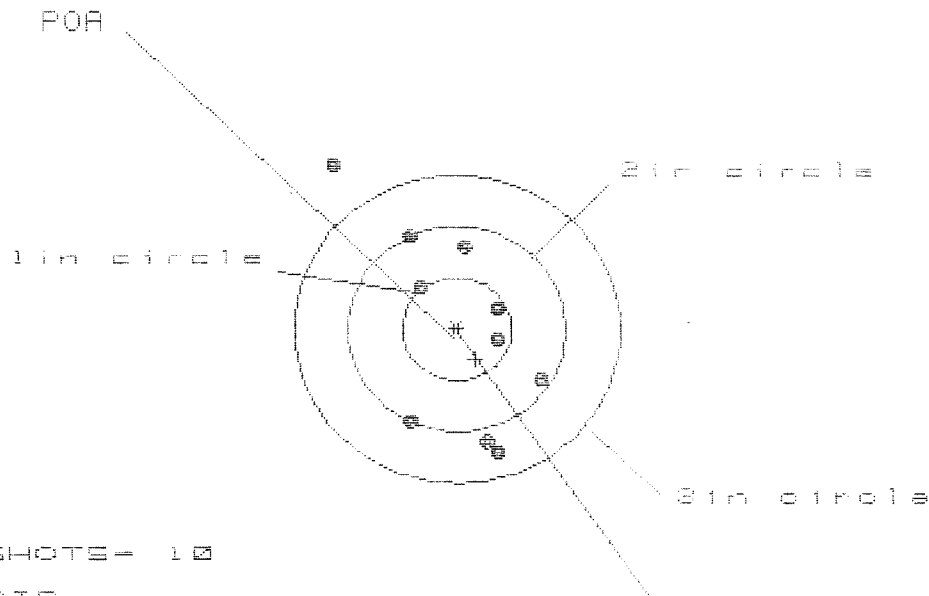
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.916	.850	.914
MINIMUM X	-.574	-.472	-.408
MAXIMUM Y	1.611	1.421	1.380
MINIMUM Y	-1.704	-1.160	-.982
CENTROID X	-.170	-.272	-.336
CENTROID Y	.242	.432	.254
POA TO CENTROID in.	.296	.510	.421
MIN RADIUS	.543	.394	.392
MEAN RADIUS	1.023	.890	.787
MAX RADIUS	1.935	1.511	1.480
HORIZONTAL SPREAD	1.490	1.322	1.322
VERTICAL SPREAD	3.315	2.581	2.362
EXTREME SPREAD	3.353	2.725	2.504
NUMBER IN ONE INCH CIRCLE	=	0	
NUMBER IN TWO INCH CIRCLE	=	6	
NUMBER IN THREE INCH CIRCLE	=	8	

12 Oct 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C8348336

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 6

3 in = 9

HS= 1.922

VS= 2.792

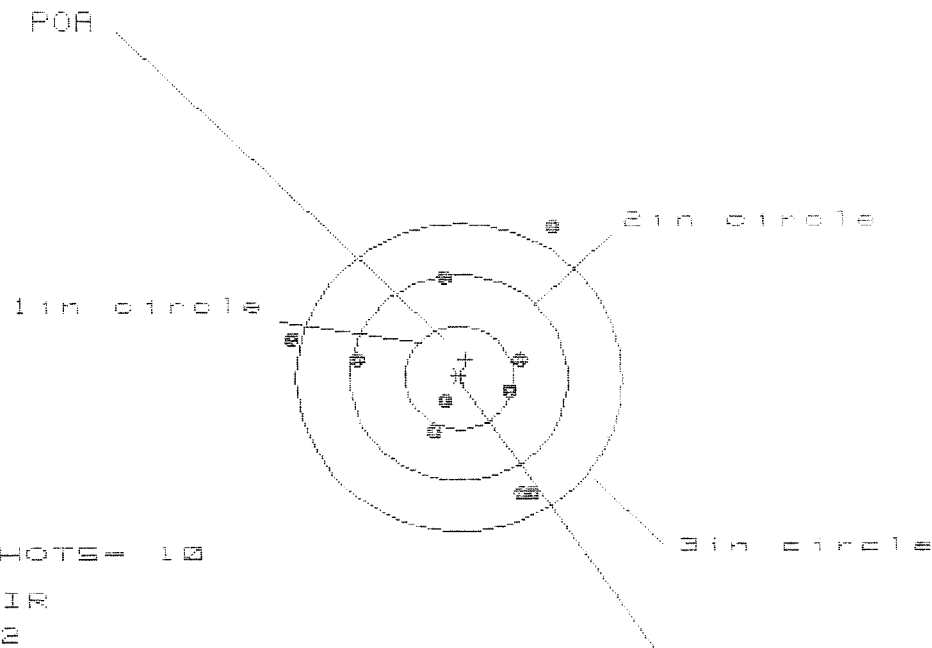
GS= 3.145

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.813	.690	.717
MINIMUM X	:	-1.109	-.580	-.553
MAXIMUM Y	:	1.578	1.064	.935
MINIMUM Y	:	-1.214	-1.039	-1.052
CENTROID X	:	-.170	-.047	-.074
CENTROID Y	:	.293	.118	.247
POA TO CENTROID in.	:	.339	.127	.258
MIN RADIUS	:	.391	.268	.301
MEAN RADIUS	:	.939	.809	.763
MAX RADIUS	:	1.929	1.212	1.086
HORIZONTAL SPREAD	:	1.922	1.270	1.270
VERTICAL SPREAD	:	2.792	2.103	1.987
EXTREME SPREAD	:	3.145	2.249	2.133
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

12 Oct 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C834B936

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 2

2in = 6

3in = 8

HS= 2.400

VS= 2.647

GS= 2.673

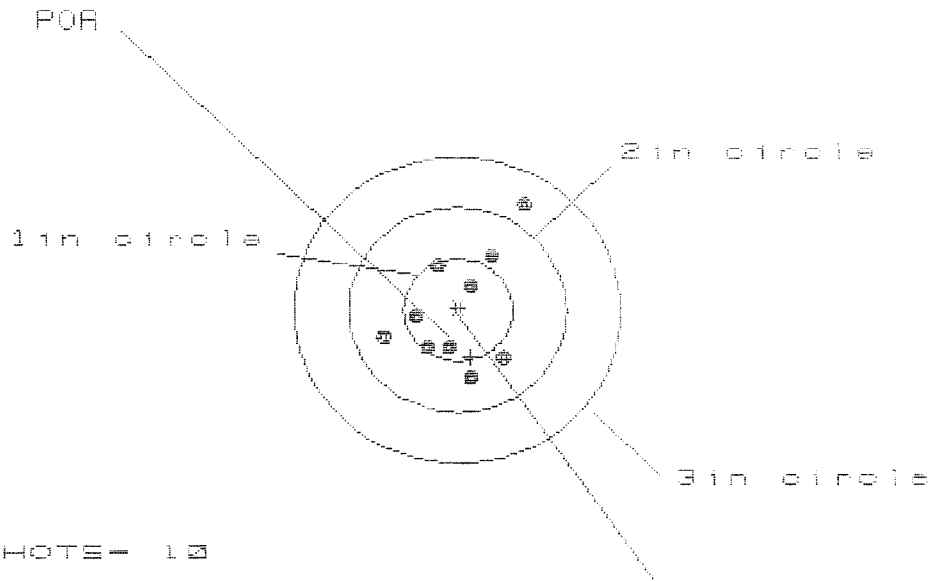
CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.860	.710	.526
MINIMUM X	:	-1.568	-1.472	-1.030
MAXIMUM Y	:	1.503	1.127	1.196
MINIMUM Y	:	-1.144	-.977	-.908
CENTROID X	:	-.062	-.158	.026
CENTROID Y	:	-.177	-.344	-.413
POA TO CENTROID in.	:	.188	.379	.414
MIN RADIUS	:	.288	.099	.205
MEAN RADIUS	:	.970	.855	.749
MAX RADIUS	:	1.732	1.572	1.218
HORIZONTAL SPREAD	:	2.428	2.182	1.556
VERTICAL SPREAD	:	2.647	2.104	2.104
EXTREME SPREAD	:	2.673	2.664	2.231
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

12 Oct 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C8348936

CENTERFIRE PATTERNS # 4



OF SHOTS = 10

IN CIR

1in = 5

2in = 9

3in = 10

HS = 1.298

VS = 1.713

GS = 1.859

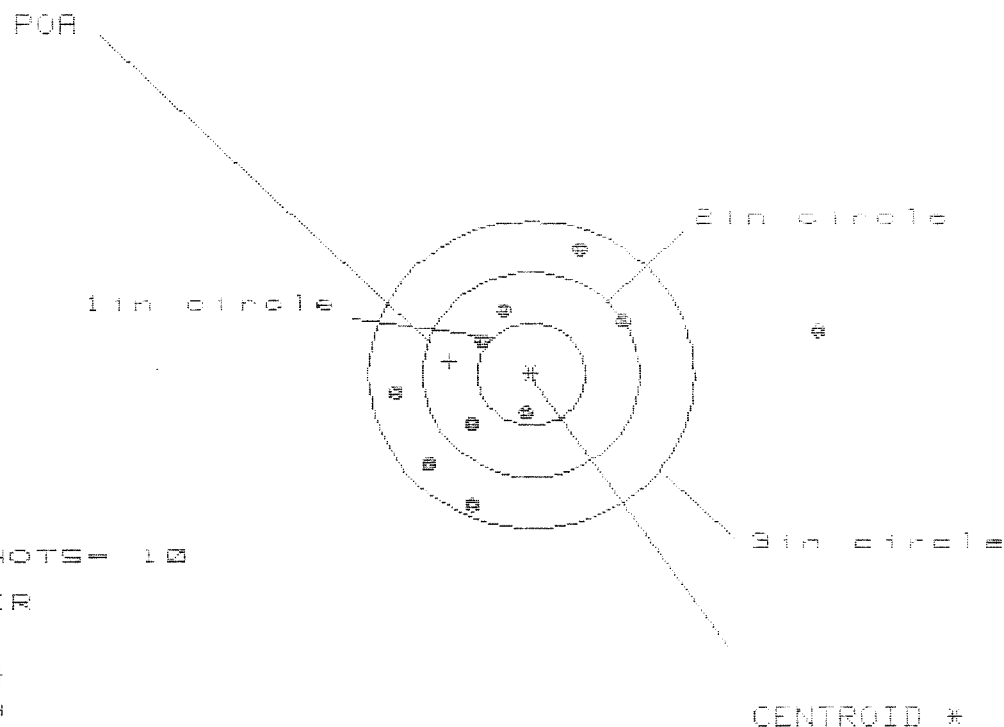
CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.586	.524	.443
MINIMUM X	:	-.712	-.647	-.409
MAXIMUM Y	:	1.039	.606	.584
MINIMUM Y	:	-.674	-.559	-.581
CENTROID X	:	-.115	-.180	-.099
CENTROID Y	:	.461	.346	.368
POB TO CENTROID in.	:	.475	.390	.381
MIN RADIUS	:	.315	.266	.310
MEAN RADIUS	:	.585	.496	.477
MAX RADIUS	:	1.193	.694	.638
HORIZONTAL SPREAD	:	1.298	1.171	.852
VERTICAL SPREAD	:	1.713	1.165	1.165
EXTREME SPREAD	:	1.859	1.258	1.179
NUMBER IN ONE INCH CIRCLE	=		5	
NUMBER IN TWO INCH CIRCLE	=		9	
NUMBER IN THREE INCH CIRCLE	=		10	

12 Oct 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C8348936

CENTERFIRE PATTERNS # 5



OF SHOTS = 10

IN CIR

1in = 1

2in = 4

3in = 9

HS = 3.862

VS = 2.483

GS = 3.924

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.628	1.146	1.112
MINIMUM X	:	-1.234	-.942	-.976
MAXIMUM Y	:	1.189	1.241	1.086
MINIMUM Y	:	-1.294	-1.242	-.946
CENTROID X	:	.753	.461	.495
CENTROID Y	:	-.128	-.180	-.025
POA TO CENTROID in.	:	.753	.495	.495
MIN RADIUS	:	.342	.398	.273
MEAN RADIUS	:	1.119	.892	.837
MAX RADIUS	:	2.670	1.462	1.313
HORIZONTAL SPREAD	:	3.862	2.088	2.088
VERTICAL SPREAD	:	2.483	2.483	2.032
EXTREME SPREAD	:	3.924	2.694	2.494
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		9	