

C6348951

MODEL 700TM N24

Model **SWS** TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6348951

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	9 26	89	RW
600	Proof	9 26	89	RW
607	Check Headspace	9 26 9 26	89	RW
610	Dis-assemble Gun			RW
612	Magnaflux Barrel Action		9/29/89	KCR
	Magnaflux Bolt		9/29/89	KCR
615	Rollmark Caliber		9/29/89	BT
7	Drill and Tap Sight Holes	9 29	89	LB
618	Polish Barrel RB	9 29	89	BT
620	Apply Coatings (Barrel Action)		10/1/89	TJA
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		10/16/89	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/16/89	RW
	C) Inspect Ejector Hole for Chamfer		10/16/89	RW
	D) Oil Firing Pin Ass'y		10/16/89	RW
	E) Adjust Trigger Pull to Min Setting and Stake		19 Oct 89	JS

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			19 Oct 89	JS
	G) Safety Off Force	4	3	3			19 Oct 89	JS
	H) Trigger Pull Test & Retainability						19 Oct 89	JS
	I) Firing Pin Indent	10205	10205	10205			19 Oct 89	JS
	J) Assemble Stock						10/19/89	RW
	K) Assemble Swivel Studs						10/23/89	JS
	L) Attach Front and Rear Sight Assemblies						12/11/89	RW
	M) Iron Sight Alignment						12/11/89	RW
	N) Detach Front & Rear Sights & place in numbered container						12/11/89	RW
	O) Attach Scope to Rifle						20 Oct 89	JS
	P) Detach & Attach Scope 20 Times						20 Oct 89	JS
640	Gallery Target & Test						10-20-89	AC
	A) Time						10-20-89	AC
	B) Malfunctions						10-20-89	AC
	C) Pierced Primers						10-20-89	AC
	D) Optical Clarity of Scope						10-20-89	AC
645	Inspect for Live Ammo						10-20-89	AC
655	Final Inspection						23 Oct 89	JS
	A) Headspace						23 Oct 89	JS
	B) Trigger Pull	2.81	283	261	283	279	23 Oct 89	JS
	C) Function						23 Oct 89	JS
660	Pack						15/10/89	JS

Remington
 MODEL 700™ M24

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

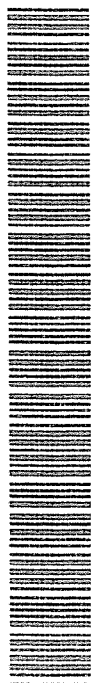
REC'D US PATENT OFF

SERIAL NO.
 C6348951

ORDER NO.
 5716

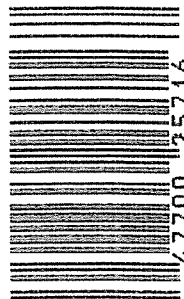
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.

01



5716 C6348951

LPC



0 47700 25716 7

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6348951
20 Oct 1989

CENTROIDAL DISTANCES

0 TO 1	.73139
1 TO 2	.457849
1 TO 3	.62184
1 TO 4	.866092
1 TO 5	.248455

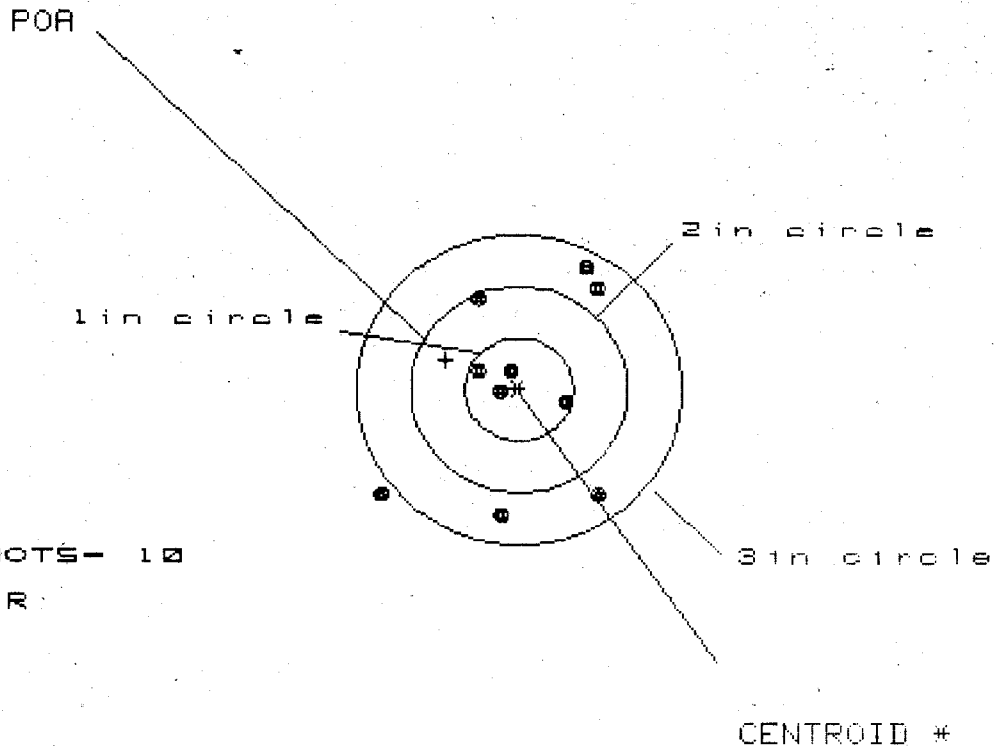
b2 51 <----POA
4

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .296
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.2922
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .415929
THE AMR FOR THIS RIFLE IS: 1.011

20 Oct 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C6340951

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in - 4

2in - 5

3in = 9

HS= 2.006

VS= 2.407

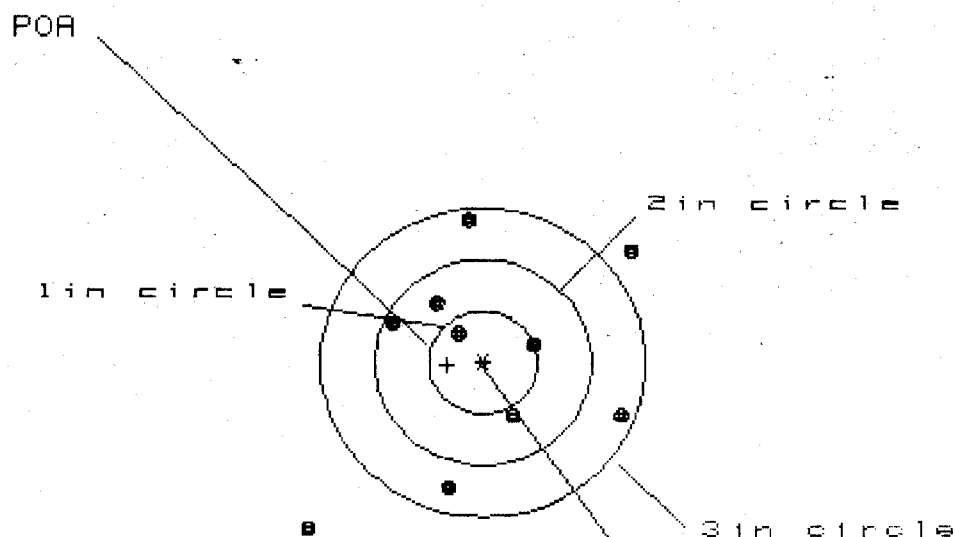
GS= 2.895

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.745	.605	.661
MINIMUM X	:	-1.261	-.564	-.508
MAXIMUM Y	:	1.163	1.044	.951
MINIMUM Y	:	-1.244	-1.363	-1.232
CENTROID X	:	.674	.814	.758
CENTROID Y	:	-.284	-.165	-.296
POA TO CENTROID in.	:	.731	.830	.813
MIN RADIUS	:	.175	.260	.259
MEAN RADIUS	:	.894	.809	.760
MAX RADIUS	:	1.650	1.391	1.252
HORIZONTAL SPREAD	:	2.006	1.169	1.169
VERTICAL SPREAD	:	2.407	2.407	2.183
EXTREME SPREAD	:	2.895	2.515	2.344
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

20 Oct 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C634B951

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 8

HS= 3.004

VS= 3.006

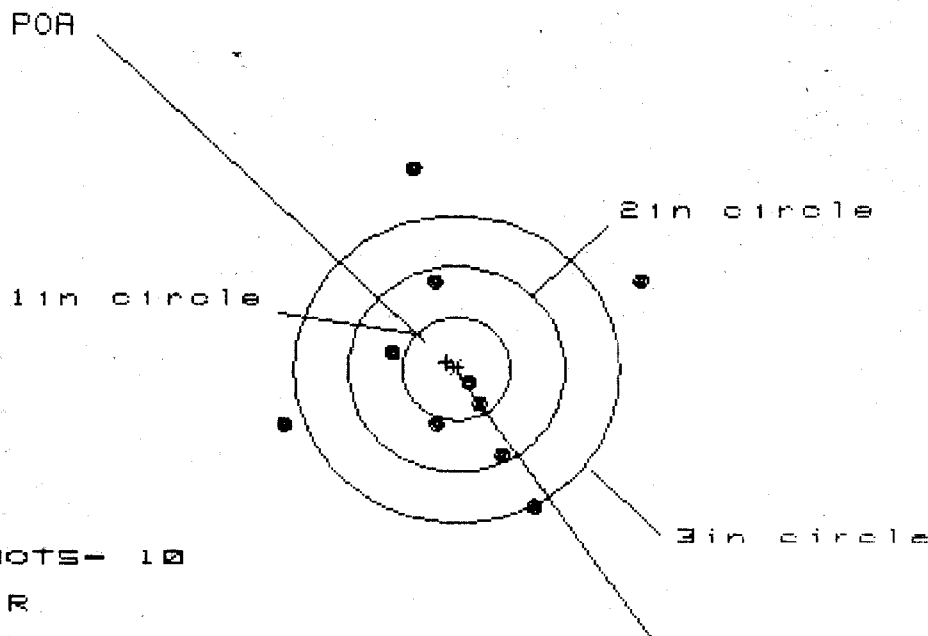
GS= 4.044

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.414	1.238	1.285
MINIMUM X	-1.590	-.969	-.815
MAXIMUM Y	1.346	1.161	1.269
MINIMUM Y	-1.660	-1.351	-1.243
CENTROID X	.329	.505	.350
CENTROID Y	.017	.201	.093
POA TO CENTROID in.	.329	.544	.363
MIN RADIUS	.414	.313	.373
MEAN RADIUS	1.112	.960	.875
MAX RADIUS	2.299	1.508	1.421
HORIZONTAL SPREAD	3.004	2.207	2.100
VERTICAL SPREAD	3.006	2.512	2.512
EXTREME SPREAD	4.044	2.806	2.521
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	8		

20 Oct 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C6348951

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 2

2in = 6

3in = 6

HS= 3.334

VS= 3.285

GS= 3.583

CENTROID *

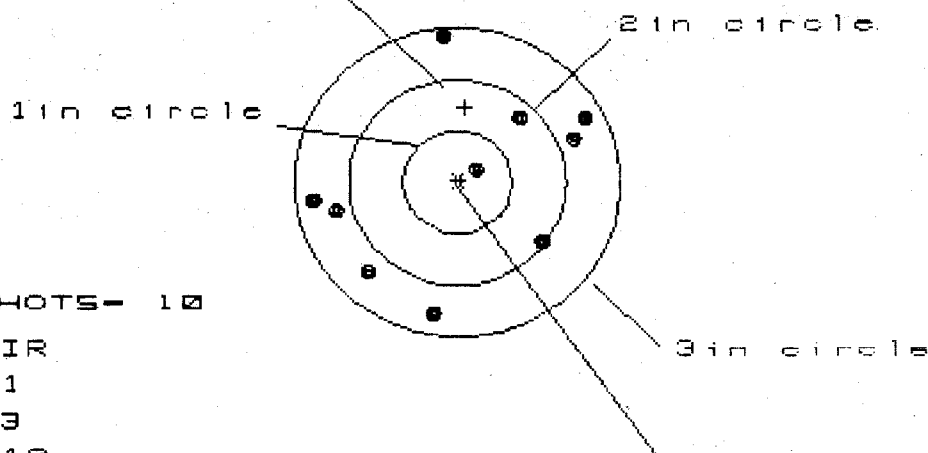
PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.721	1.676	.862
MINIMUM X	-1.612	-1.658	-1.449
MAXIMUM Y	1.946	1.070	1.200
MINIMUM Y	-1.339	-1.123	-.994
CENTROID X	.092	.137	-.072
CENTROID Y	-.065	-.281	-.410
POA TO CENTROID in.	.112	.313	.417
MIN RADIUS	.180	.073	.229
MEAN RADIUS	1.073	.914	.783
MAX RADIUS	1.989	1.970	1.456
HORIZONTAL SPREAD	3.334	3.334	2.311
VERTICAL SPREAD	3.285	2.193	2.193
EXTREME SPREAD	3.583	3.583	2.461
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		6	

20 Oct 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C634B951

CENTERFIRE PATTERNS # 4

POA



OF SHOTS- 10

IN CIR

1in = 1

2in = 3

3in = 10

HS= 2.534

VS= 2.704

GS= 2.706

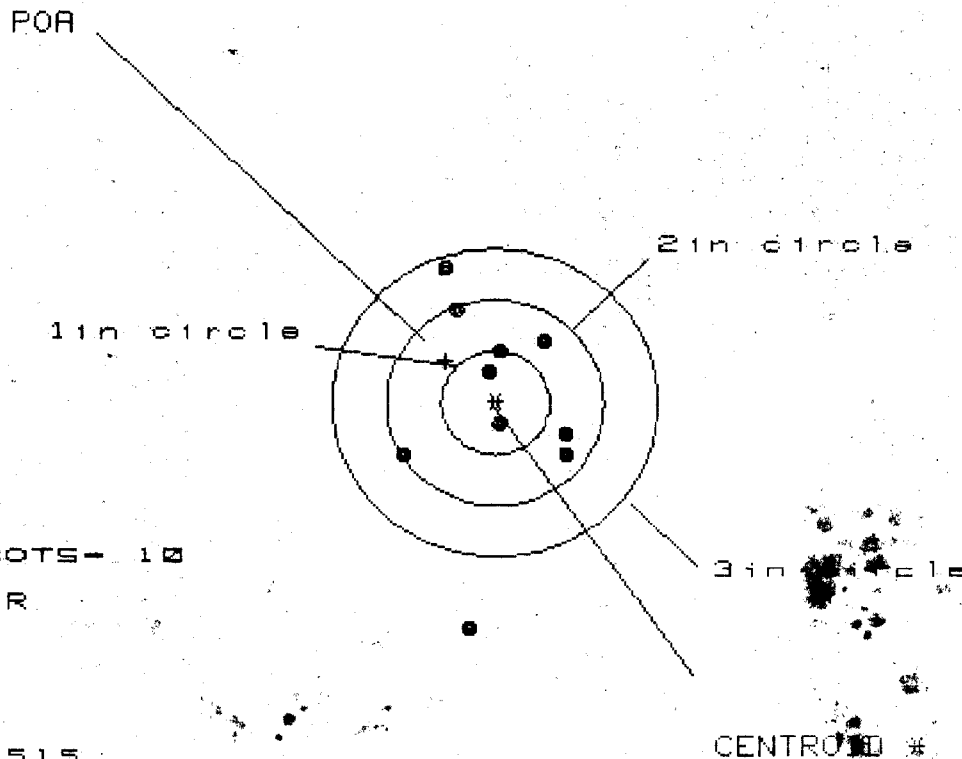
CENTROID #

PATTERN #	1	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.191	1.177	1.164
MINIMUM X	-1.343	-1.357	-1.210
MAXIMUM Y	1.430	.808	.874
MINIMUM Y	-1.274	-1.115	-1.014
CENTROID X	-.072	-.058	-.205
CENTROID Y	-.724	-.883	-.983
POA TO CENTROID in.	.727	.884	1.005
MIN RADIUS	.187	.305	.469
MEAN RADIUS	1.087	1.048	1.001
MAX RADIUS	1.435	1.428	1.346
HORIZONTAL SPREAD	2.534	2.534	2.374
VERTICAL SPREAD	2.704	1.923	1.889
EXTREME SPREAD	2.706	2.654	2.438
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	3		
NUMBER IN THREE INCH CIRCLE =	10		

28 Oct 1989

FILE:/PATTERNING/CENTERFIRE_PATT/0634B951

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 2

2in = 8

3in = 9

HS= 1.515

VS= 3.450

GS= 3.454

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.681	.651	.593
MINIMUM X	-.834	-.864	-.922
MAXIMUM Y	1.288	1.047	.807
MINIMUM Y	-2.162	-.781	-.650
CENTROID X	.457	.487	.545
CENTROID Y	-.405	-.164	-.295
POA TO CENTROID in.	.610	.514	.620
MIN RADIUS	.179	.104	.243
MEAN RADIUS	.888	.697	.648
MAX RADIUS	2.179	1.145	1.099
HORIZONTAL SPREAD	1.515	1.515	1.515
VERTICAL SPREAD	3.450	1.828	1.457
EXTREME SPREAD	3.454	2.140	1.769
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	8		
NUMBER IN THREE INCH CIRCLE =	9		

SWS TRIGGER PULL TEST

TIME

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. 8951DATE 23 MAR 90TESTER JS

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	225	223		234	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	226	222		227	
PULL #3	225	224		227	
PULL #4	223	225		222	
PULL #5	224	224		225	
TOTAL	1128	1118			
AVG.	225.6	223.6			

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.00	2.90		
PULL #2	2.87	2.87		
PULL #3	2.95	2.88		
PULL #4	2.96	2.81		
PULL #5	2.81	2.93		
TOTAL	14.59	14.39		
AVG.	2.918	2.878		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.02	4.01		
PULL #2	3.97	3.97		
PULL #3	4.01	3.95		
PULL #4	4.00	3.99		
PULL #5	4.02	3.99		
TOTAL	20.02	19.91		
AVG.	4.004	3.982		

Repair Number: **RE00018384** Serial: C6348951 Model: 700 Center Fire Caliber 7.62 NATO M-24 (SWS) Repairman: Status: Closed 12/5/00 8:13:51 AM

Verify Repair

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**

PFL:

Contact / Condition Problems Estimate History / Status Shipping / Billing

Contact Information: Received Condition: Accessories Received:

Phone: Poor

Fax:

Email:

Comments:

Condition Notes:

CSH Notes:

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

12/5/00 9:28 AM

Start In N A M S S E P Y Im

9:28 AM

Number: **C6348951**

Model: **700**



RE00018384

BBL - 96003

Final Inspection

Sn: C6348951

DATE REC'D: 11-30-00

DATE RET'D:

Auditor: CK

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	18384		
SERIAL NUMBER	C634895-1		
LOG-IN DATE	11-30-00		
INSPECT AND VERIFY:			
OPERATION #	OPERATION NAME	DATE	INITIAL
550	DIS-ASSEMBLE GUN	12-5-00	CK
560 A	RE-BARREL AT CUSTOM SHOP		
B	DRILL AND TAP		
C	POLISH		
575	ASSEMBLE		
600	PROOF	12-9-00	CK
605	CHECK HEADSPACE	12-9-00	CK
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	1-15-01	RW
655	FINAL INSPECT	1-30-01	CK
660	PACK		
		SHIP DATE	
QAR INSPECTION DATE			

Remington Test Lab, Ilion, N.Y.

Centroidal distance calculations for Rifle # c6348951
30 Jan 2001

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0738
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0982
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .12284

THE AMR FOR THIS RIFLE IS: 1.09

CENTROIDAL DISTANCES

0	TO	1	.0941541
1	TO	2	.596525
1	TO	3	.256096
1	TO	4	.272046
1	TO	5	.26992

2 5 4 3 4 <----POA

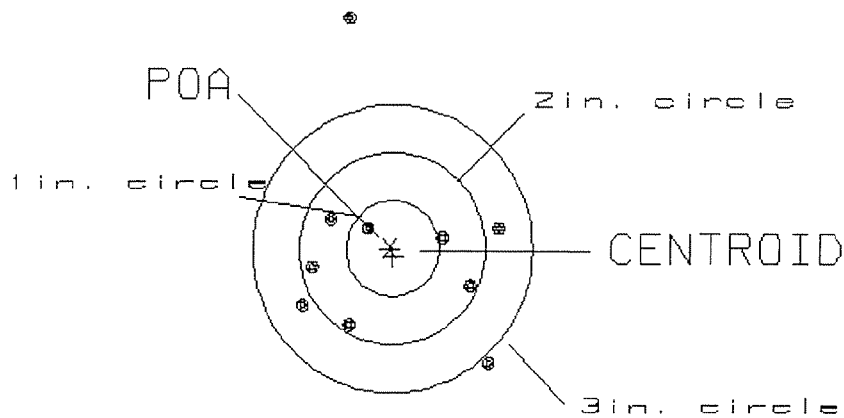
PATTERN #: 1

POA TO CENTROID: .094
 MIN RADIUS : .311
 MEAN RADIUS : 1.055
 MAX RADIUS : 2.421
 CENTROID X : -.036
 CENTROID Y : .087

29 Jan 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6348951.1.1

CENTERFIRE PATTERN # 1



OF SHOTS= 10

IN CIRCLE

HS= 2.08

1

VS= 3.53

6

GS= 3.85

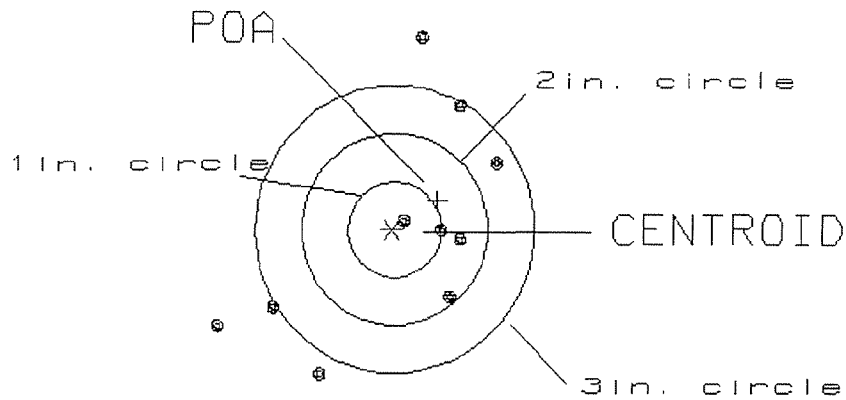
8

PATTERN #: C 2 C
 POA TO CENTROID: .576
 MIN RADIUS : .174
 MEAN RADIUS : 1.235
 MAX RADIUS : 2.173
 CENTROID X : -.495
 CENTROID Y : -.294

29 Jan 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6348951.1.1

CENTERFIRE PATTERN # 2



OF SHOTS= 10

IN CIRCLE

HS= 2.99
 VS= 3.46
 GS= 3.76

2
 4
 6

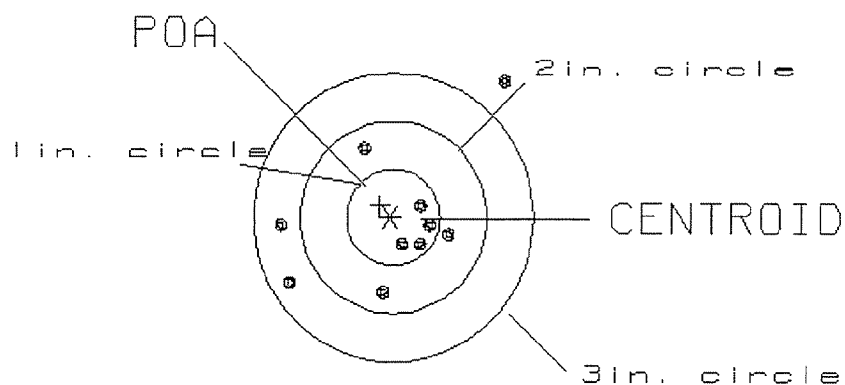
PATTERN #: 3

POA TO CENTROID: .166
 MIN RADIUS : .264
 MEAN RADIUS : .790
 MAX RADIUS : 1.886
 CENTROID X : .112
 CENTROID Y : -.122

29 Jan 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6340951.1.1

CENTERFIRE PATTERN # 3



OF SHOTS= 10

IN CIRCLE

HS= 2.42

4

VS= 2.20

7

GS= 3.14

9

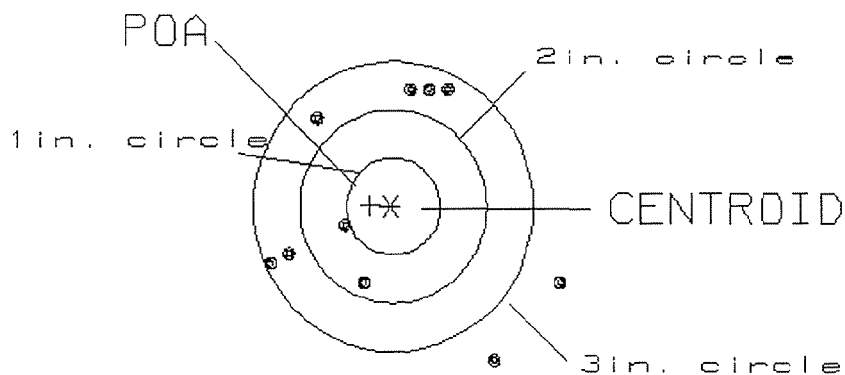
PATTERN #: 4

POA TO CENTROID: .218
 MIN RADIUS : .552
 MEAN RADIUS : 1.276
 MAX RADIUS : 1.942
 CENTROID X : .217
 CENTROID Y : -.013

29 Jan 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6348951.1.1

CENTERFIRE PATTERN # 4



OF SHOTS= 10

IN CIRCLE

HS= 3.05

0

VS= 2.77

2

GS= 3.07

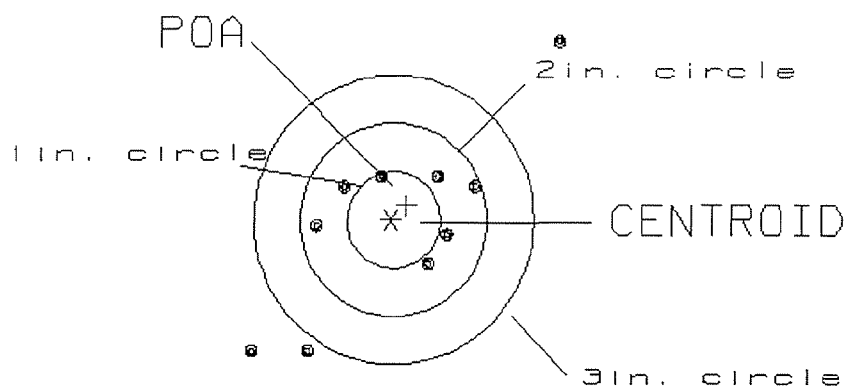
8

PATTERN #: 5
 POA TO CENTROID: .224
 MIN RADIUS : .418
 MEAN RADIUS : 1.096
 MAX RADIUS : 2.558
 CENTROID X : -.167
 CENTROID Y : -.149

29 Jan 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6348951.1.1

CENTERFIRE PATTERN # 5



OF SHOTS= 10

IN CIRCLE

HS= 3.26

1

VS= 3.26

7

GS= 4.58

7

Remington Test Lab, Ilion, N.Y.

Centroidal distance calculations for Rifle # c6348951
16 Jan 2001

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0088
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.2192
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .219377

THE AMR FOR THIS RIFLE IS: 1.407

CENTROIDAL DISTANCES

0	TO	1	.27883
1	TO	2	.700009
1	TO	3	.892307
1	TO	4	.566675
1	TO	5	.252357

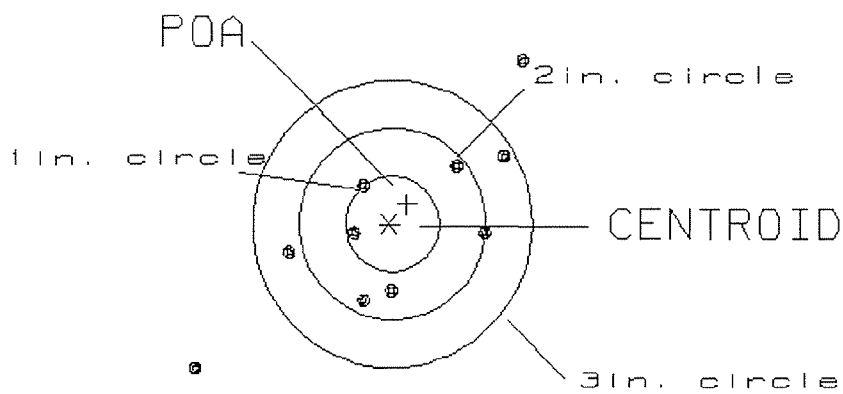
4 5+ <----POA
1 2
3

PATTERN #: 1
 POA TO CENTROID: .278
 MIN RADIUS : .416
 MEAN RADIUS : 1.154
 MAX RADIUS : 2.550
 CENTROID X : -.189
 CENTROID Y : -.205

15 Jan 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6348951.1

CENTERFIRE PATTERN # 1



OF SHOTS= 10

IN CIRCLE

HS= 3.43

1

VS= 3.15

6

GS= 4.66

8

PATTERN #: 2

POA TO CENTROID: .531

MIN RADIUS : .619

MEAN RADIUS : 1.436

MAX RADIUS : 2.435

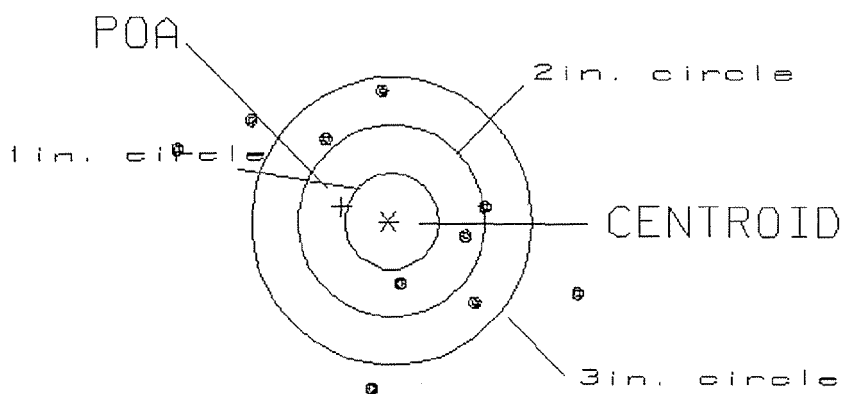
CENTROID X : .509

CENTROID Y : -.152

15 Jan 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6348951.1

CENTERFIRE PATTERN # 2



OF SHOTS= 10

IN CIRCLE

HS= 4.33

0

VS= 3.14

2

GS= 4.59

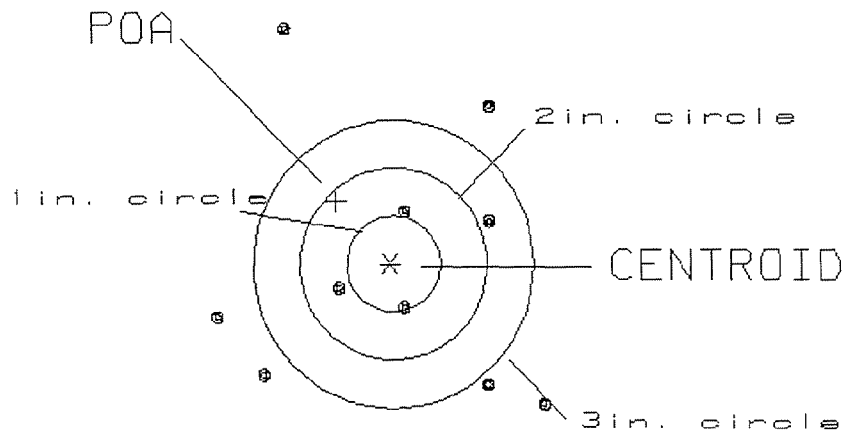
6

PATTERN #: ☐ 3 ☐
 POA TO CENTROID: .374
 MIN RADIUS : .442
 MEAN RADIUS : 1.494
 MAX RADIUS : 2.686
 CENTROID X : .585
 CENTROID Y : -.649

15 Jan 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6348951.1

CENTERFIRE PATTERN # 3



OF SHOTS= 10

IN CIRCLE

H3= 3.55

1

US= 3.83

3

GS= 4.77

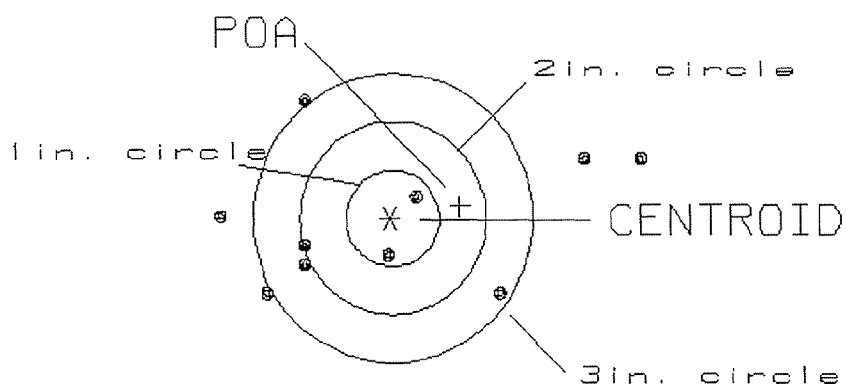
4

PATTERN #: 4
 POA TO CENTROID: .760
 MIN RADIUS : .356
 MEAN RADIUS : 1.406
 MAX RADIUS : 2.753
 CENTROID X : -.750
 CENTROID Y : -.125

15 Jan 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6348951.1

CENTERFIRE PATTERN # 4



OF SHOTS= 10

IN CIRCLE

HS= 4.51

2

VS= 2.03

2

GS= 4.54

5

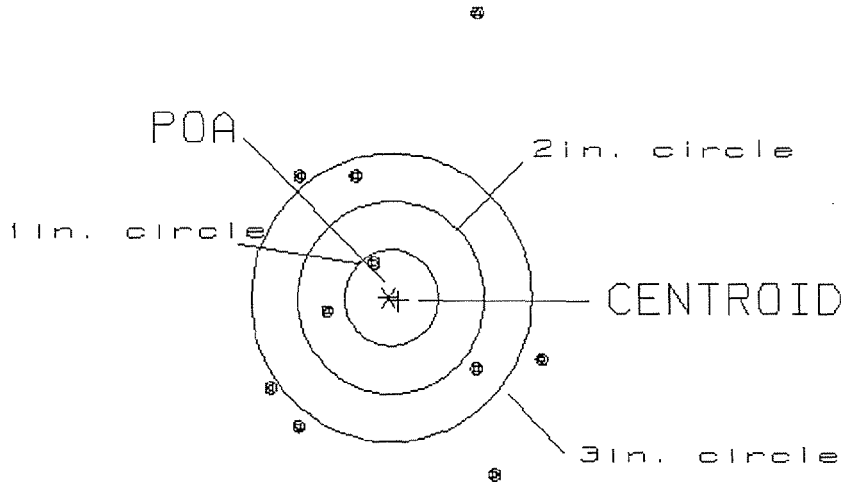
PATTERN #: 5

POA TO CENTROID: .117
 MIN RADIUS : .389
 MEAN RADIUS : 1.546
 MAX RADIUS : 3.117
 CENTROID X : -.111
 CENTROID Y : .035

15 Jan 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6348951.1

CENTERFIRE PATTERN # 5



OF SHOTS= 10

IN CIRCLE

HS= 2.90

1

VS= 4.85

2

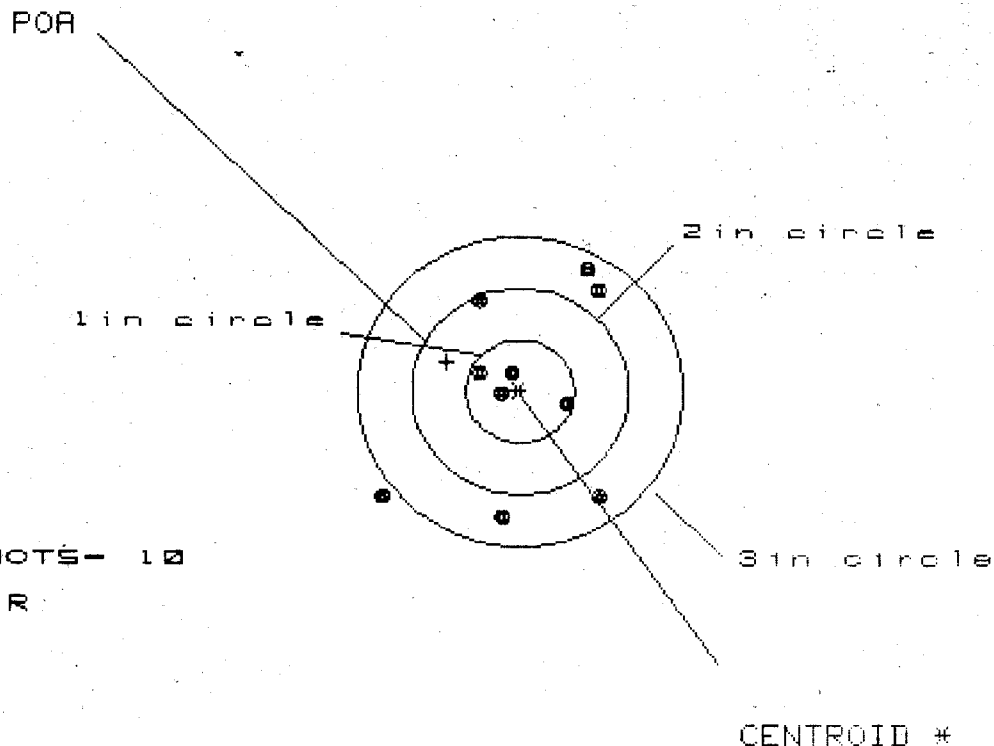
GS= 4.85

4

20 Oct 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C6340951

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 4

2in = 5

3in = 9

HS= 2.006

VS= 2.407

GS= 2.895

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.745	.605	.661
MINIMUM X	:	-1.261	-.564	-.508
MAXIMUM Y	:	1.163	1.044	.951
MINIMUM Y	:	-1.244	-1.363	-1.232
CENTROID X	:	.674	.814	.758
CENTROID Y	:	-.284	-.165	-.296
POA TO CENTROID in.	:	.731	.830	.813
MIN RADIUS	:	.175	.260	.259
MEAN RADIUS	:	.894	.809	.760
MAX RADIUS	:	1.650	1.391	1.252
HORIZONTAL SPREAD	:	2.006	1.169	1.169
VERTICAL SPREAD	:	2.407	2.407	2.183
EXTREME SPREAD	:	2.895	2.515	2.344
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	