

C6348953

Secret Service

MODEL 700TM M24

Model **SWS** TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington




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

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

MODEL 700TM M24

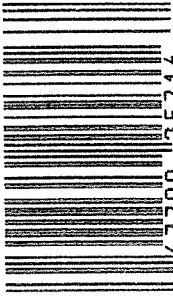
SERIAL NO.
C6348953

ORDER NO.
5716

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

20

UPC



0 47700 25716 7



5716 C6348953

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6348953

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	8 30	89	DW
600	Proof	8 30	89	DW
607	Check Headspace	8 30	89	DW
610	Dis-assemble Gun	8 30	89	DW
612	Magnaflux Barrel Action		8/31/89	KCR
	Magnaflux Bolt		8/31/89	KCR
615	Rollmark Caliber		8/31/89	G.S.
7	Drill and Tap Sight Holes	9 1	89	LE
618	Polish Barrel RB	9 1	89	BT
620	Apply Coatings (Barrel Action)		9-7-89	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		9/8/89	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		9/8/89	RW
	C) Inspect Ejector Hole for Chamfer		9/8/89	RW
	D) Oil Firing Pin Ass'y		9/8/89	RW
	E) Adjust Trigger Pull to Min Setting and Stake		9-8-89	JL

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5 1/2	5 3/4	5 1/2			9/8/89	WB
	G) Safety Off Force	2 1/2	2 3/4	2 3/4			9/8/89	WB
	H) Trigger Pull Test & Retainability						9-8-89	SL
	I) Firing Pin Indent	.020	.0205	.020			9/8/89	WB
	J) Assemble Stock						9/11/89	RW
	K) Assemble Swivel Studs						12/2/89	JS
	L) Attach Front and Rear Sight Assemblies						9/11/89	RW
	M) Iron Sight Alignment						9/11/89	RW
	N) Detach Front & Rear Sights & place in numbered container						9/11/89	RW
	O) Attach Scope to Rifle						9/11/89	WB
	P) Detach & Attach Scope 20 Times						9/11/89	WB
640	Gallery Target & Test	72R	78L				9-11-89	DH
	A) Time						9-11-89	DH
	B) Malfunctions						9-11-89	DH
	C) Pierced Primers						9-11-89	DH
	D) Optical Clarity of Scope						9-11-89	DH
645	Inspect for Live Ammo						9-11-89	DH
655	Final Inspection							
	A) Headspace						12/2/89	JS
	B) Trigger Pull	2.82	2.86	2.79	2.86	2.89	12/2/89	JS
	C) Function						12/2/89	JS
660	Pack						25 Sept 89	WB

Marking for Secret Service Gun 9/12/89
19cm

UNIT PACK - GUN

1005-01-240-2136

1 EA

C (10) 9/89

WT 63.9 CU 6.2

DAAA21-87-G-0001-0001

RAC INC

ILION NY 13357

PALLET

1005-01-240-2136

1 EA

C (10) 9/89

WT ? CU ?

DAAA21-87-G-0001-0001

RAC INC

ILION NY 13357

UNIT PACK - SOFT CASE

1005-01-262-2818

1 EA

C (10) 9/89

WT 4 CU 2

DAAA21-87-G-0001-0001

RAC INC

ILION NY 13357

NO - ?

FSCM 3A703 ALPHA
SOFT CASE 96076

NOTE

No tag on Case
itself only on Box

ORDER FOR SUPPLIES OR SERVICES				Form Approved OMB No. 0704-0187 Expires Jul 31, 1989		PAGE 1 OF 2	
1. CONTRACT/PURCH ORDER NO. DAAA2187G0001		2. DELIVERY ORDER NO. 0001-		3. DATE OF ORDER. 06/15/89		4. REQUISITION/PURCH REQUEST NO. 1A92VP611ANG01	
6. ISSUED BY US Army AMCCOM AMSMC-PCW-B(D), Bldg. 10 Picatinny Arsenal, NJ 07806-5000 J. McDonough (JACK) (201)-724-2024				7. ADMINISTERED BY DCASMA Syracuse U.S. Courthouse and Fed. Bldg. 100 South Clinton Street Syracuse, NY 13260-0115		5. CERTIFIED FOR NA- TIONAL DEFENSE UN- DER DMS REG 1 DO	
9. CONTRACTOR NAME AND ADDRESS REMINGTON ARMS CO., INC. 14 HOEFLER AVE. ILION, NY 13357-				10. DELIVER TO FOB POINT BY 06/30/89		8. DELIVERY FOB [] DEST [X] OTHER (see schedule if other)	
14. SHIP TO SEE SCHEDULE DAAA2187G0001/0001				15. PAYMENT WILL BE MADE BY DCASR Boston 495 Summer Street Boston, MA 02210-2104		11. MARK IF BUS. IS [X] SMALL [] SMALL DISAD- VANTAGED [] WOMEN-OWNED	
16. DELIVERY ☒ This delivery order is issued on another Government agency or in accordance with and subject to terms and conditions of above numbered contract.				12. DISCOUNT TERMS 0 % 0 Net 0			
PURCHASE Reference your				13. MAIL INVOICES TO			
ACCEPTANCE. THE CONTRACTOR HEREBY ACCEPTS THE OFFER REPRESENTED BY THE NUMBERED PURCHASE ORDER AS IT MAY PREVIOUSLY HAVE BEEN OR IS NOW MODIFIED, SUBJECT TO ALL OF THE TERMS AND CONDITIONS SET FORTH, AND AGREES TO PERFORM THE SAME.							
NAME OF CONTRACTOR SIGNATURE TYPED NAME AND TITLE DATE SIGNED ☐ If this box is marked, supplier must sign Acceptance and return the following number of copies:							
17. ACCOUNTING AND APPROPRIATION DATA/LOCAL USE 2191408900P9999993123S999999 Doc # 203A5J 91249037 to [unclear]							
18. ITEM NO.	19. SCHEDULE OF SUPPLIES/SERVICE	20. QUANTITY ORDERED/ACCEPTED*	21. UNIT	22. UNIT PRICE	23. AMOUNT		
0143AA	stock no 1-240-2136 doc 203a5j 9037 niin 01-240-2136 ser 0005 REQ 9-180-13-006 CL 3123 PLEASE PHONE 24 HRS PRIOR TO DELIVERY: US SECRET SERVICE JJ ROWLEY TRAINING CENTER 9200 POWDER MILL ROAD, IR-2 LAUREL, MD 20707 ATTN: GUS AUGUSTYN 301 344 8530 Sniper Weapon System, P/N 96209	1	EA	4003.000000	4003.00		
*If quantity accepted by the Government is same as quantity ordered, indicate by x. If different, enter actual quantity accepted below quantity ordered and encircle.		24. UNITED STATES OF AMERICA BY: HARRY SANTA		25. TOTAL 4003.00		29. DIFFERENCES	
26. QUANTITY IN COLUMN 20 HAS BEEN [] INSPECTED [] RECEIVED [] ACCEPTED AND CONFORMS TO THE CONTRACT EXCEPT AS NOTED		27. SHIP. NO.		28. D.O. VOUCHER NO.		30. INITIALS	
DATE SIGNATURE OF AUTHORIZED GOVERNMENT REP.		31. PAYMENT [] COMPLETE [] PARTIAL [] FINAL		32. PAID BY		33. AMT VERIFIED CORRECT FOR	
36. I certify this account is correct and proper for payment		DATE SIGNATURE AND TITLE OF CERTIFYING OFFICER		34. CHECK NUMBER		35. BILL OF LADING NO.	
37. REC'D AT	38. RECEIVED BY	39. DATE REC'D	40. TOTAL CONT.	41. S/R ACCOUNT NUMBER	42. S/R VOUCHER NO.		

39

4

67.9

82

SWS TRIGGER PULL TEST

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

SERIAL NO. C6348953

DATE 9-8-89

TESTER JM

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.53	2.55	2.42	2.82	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.50	2.55	2.33	2.86	
PULL #3	2.53	2.50	2.45	2.79	
PULL #4	2.51	2.56	2.50	2.86	
PULL #5	2.45	2.48	2.40	2.88	
TOTAL	12.52	12.64	12.10	14.21	
AVG.	2.504	2.528	2.42	2.842	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.43	3.45		
PULL #2	3.42	3.40		
PULL #3	3.43	3.50		
PULL #4	3.52	3.43		
PULL #5	3.46	3.42		
TOTAL	17.26	17.20		
AVG.	3.452	3.44		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.14	4.54		4.17
PULL #2	4.24	4.58		4.16
PULL #3	3.93	4.39		4.57
PULL #4	4.10	4.24		4.20
PULL #5	4.17	4.23		4.41
TOTAL	20.58	21.98		21.51
AVG.	4.116	4.396		4.302

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6348953
12 Sep 1989

CENTROIDAL DISTANCES

0 TO	1	.306067
1 TO	2	.558069
1 TO	3	.329876
1 TO	4	.362684
1 TO	5	1.24425

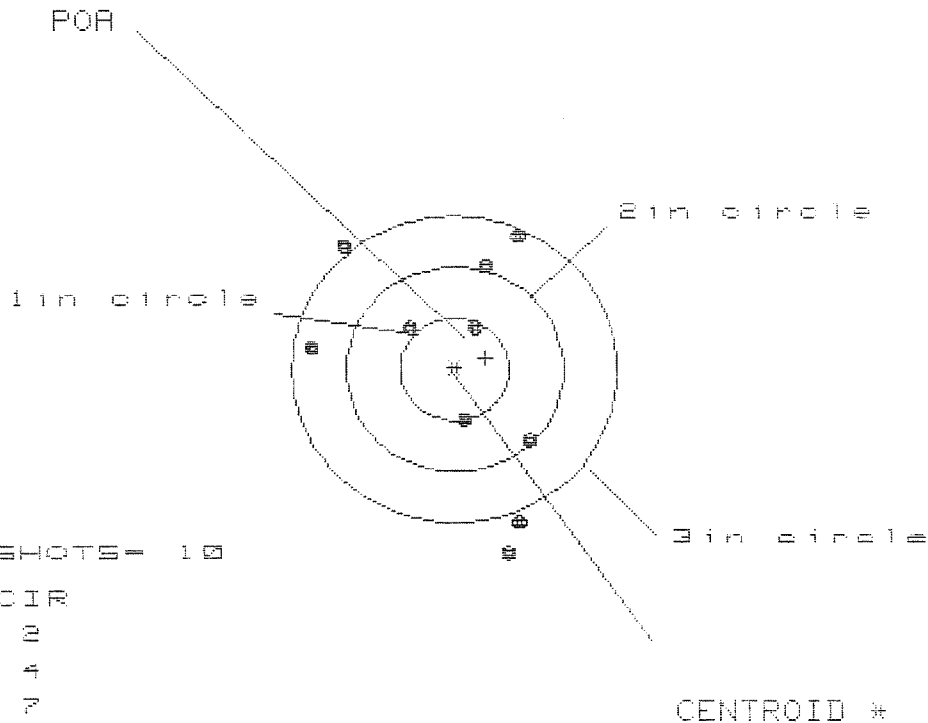
$\frac{1}{5}$ ⁵ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1732
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0552
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .181784
THE AMP FOR THIS RIFLE IS: 1.047

11 Sep 1989

FILE:/PATTERNING/CENTERFIRE_PATT/06348953

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1in = 2

2in = 4

3in = 7

HS= 2.007

VS= 3.033

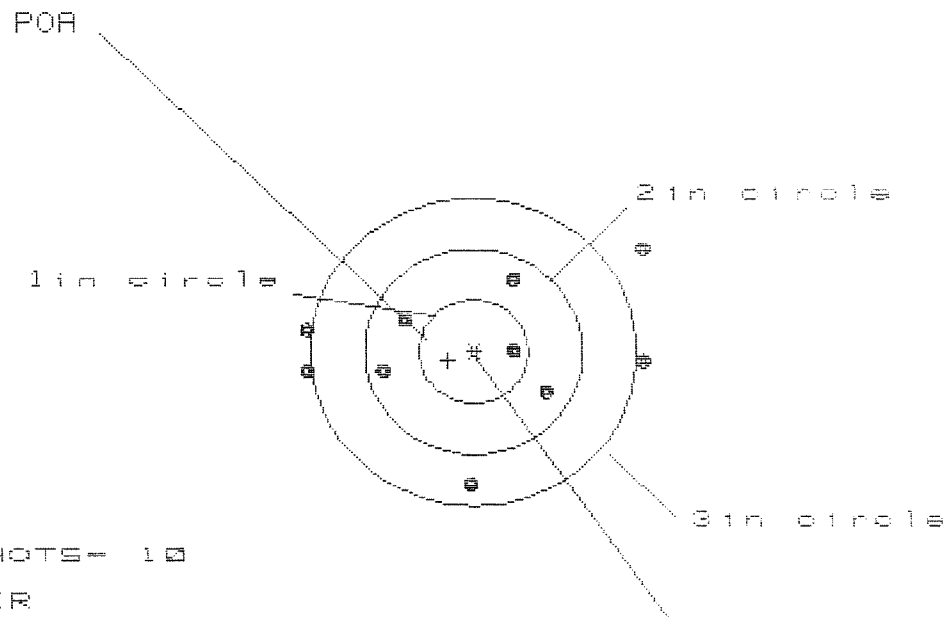
GS= 3.271

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.661	.713	.791
MINIMUM X	-1.346	-1.294	-1.216
MAXIMUM Y	1.285	1.091	.882
MINIMUM Y	-1.748	-1.675	-1.137
CENTROID X	-.286	-.338	-.416
CENTROID Y	-.109	.085	.294
POR TO CENTROID in.	.307	.348	.509
MIN RADIUS	.476	.347	.315
MEAN RADIUS	1.127	1.022	.896
MAX RADIUS	1.808	1.787	1.385
HORIZONTAL SPREAD	2.007	2.007	2.007
VERTICAL SPREAD	3.033	2.766	2.019
EXTREME SPREAD	3.271	3.090	2.541
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	7		

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FILE:/PATTERNING/CENTERFIRE_PATT/0634B953

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1in = 1

2in = 5

3in = 6

HS= 3.051

VS= 2.341

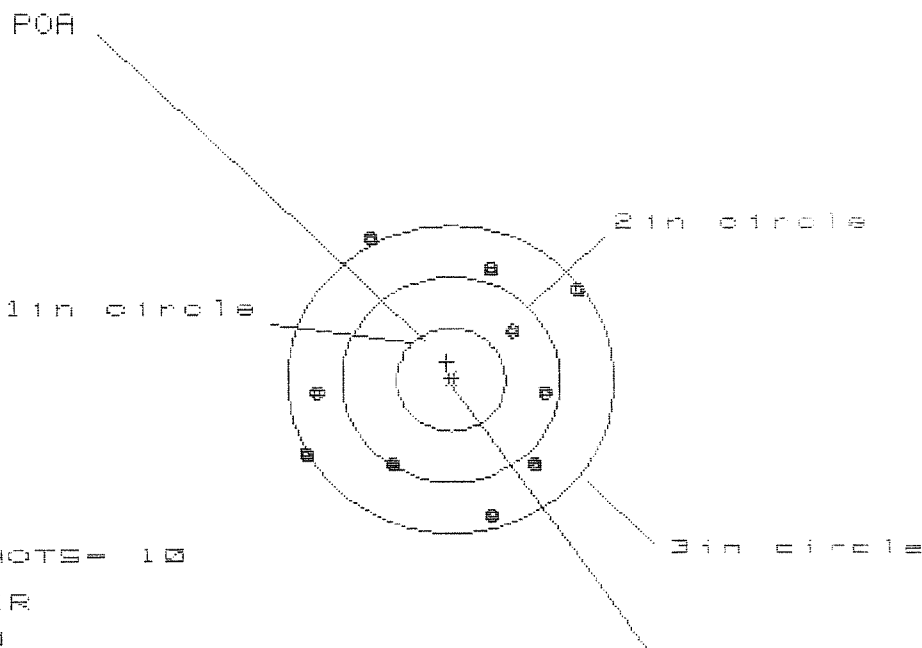
GS= 3.267

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.533	1.702	1.081
MINIMUM X	:	-1.518	-1.348	-1.135
MAXIMUM Y	:	1.004	.803	.808
MINIMUM Y	:	-1.337	-1.225	-1.220
CENTROID X	:	.235	.065	-.148
CENTROID Y	:	.091	-.021	-.026
POA TO CENTROID in.	:	.252	.068	.150
MIN RADIUS	:	.409	.596	.439
MEAN RADIUS	:	1.129	1.044	.938
MAX RADIUS	:	1.832	1.703	1.258
HORIZONTAL SPREAD	:	3.051	3.050	2.216
VERTICAL SPREAD	:	2.341	2.028	2.028
EXTREME SPREAD	:	3.267	3.059	2.280
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		6	

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FILE:/PATTERNING/CENTERFIRE_PATT/06348953

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1in = 0

2in = 3

3in = 8

HS= 2.515

VS= 2.698

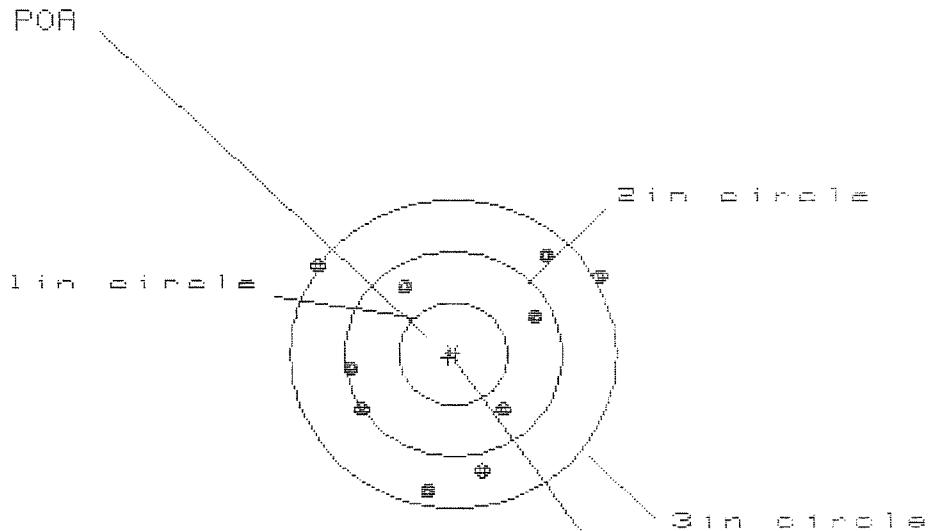
GS= 2.973

PATTERN #	3	3	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.138	1.057	.875
MINIMUM X	-1.377	-1.458	-1.506
MAXIMUM Y	1.408	1.266	1.199
MINIMUM Y	-1.298	-1.134	-1.201
CENTROID X	.037	.118	.301
CENTROID Y	-.176	-.332	-.265
POA TO CENTROID in.	.180	.353	.401
MIN RADIUS	.716	.737	.553
MEAN RADIUS	1.195	1.132	1.048
MAX RADIUS	1.587	1.554	1.507
HORIZONTAL SPREAD	2.515	2.515	2.381
VERTICAL SPREAD	2.698	2.400	2.400
EXTREME SPREAD	2.973	2.973	2.584
NUMBER IN ONE INCH CIRCLE	=	0	
NUMBER IN TWO INCH CIRCLE	=	3	
NUMBER IN THREE INCH CIRCLE	=	8	

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CENTERFIRE PATTERNS # 4



OF SHOTS = 10

IN CIR

1 in = 0

2 in = 4

3 in = 8

HS = 2.587

VS = 2.317

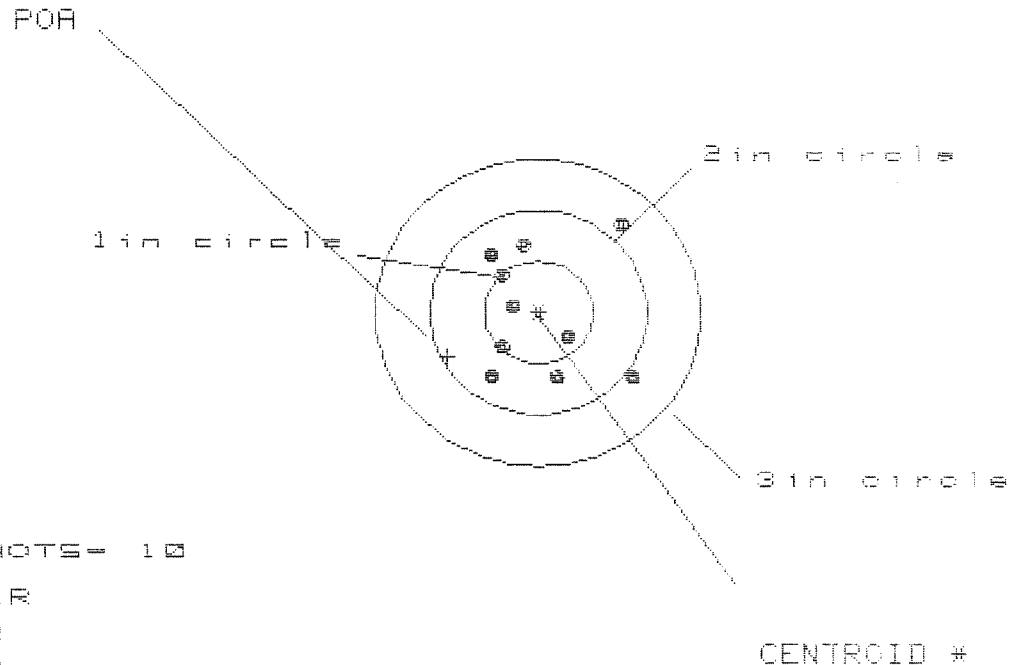
GS = 2.596

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.350	1.029	.893
MINIMUM X	:	-1.237	-1.087	-.932
MAXIMUM Y	:	1.012	1.094	1.213
MINIMUM Y	:	-1.305	-1.223	-1.104
CENTROID X	:	.046	-.104	.032
CENTROID Y	:	.037	-.045	-.164
POA TO CENTROID in.	:	.059	.113	.167
MIN RADIUS	:	.679	.741	.563
MEAN RADIUS	:	1.113	1.051	.988
MAX RADIUS	:	1.540	1.502	1.506
HORIZONTAL SPREAD	:	2.587	2.116	1.825
VERTICAL SPREAD	:	2.317	2.317	2.317
EXTREME SPREAD	:	2.596	2.577	2.577
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1 in = 2

2 in = 8

3 in = 10

HS= 1.338

VS= 1.437

GS= 1.923

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.861	.950	.473
MINIMUM X	:	-.477	-.388	-.270
MAXIMUM Y	:	.819	.780	.716
MINIMUM Y	:	-.618	-.527	-.591
CENTROID X	:	.834	.745	.627
CENTROID Y	:	.433	.342	.406
POR TO CENTROID in.	:	.940	.820	.747
MIN RADIUS	:	.287	.251	.124
MEAN RADIUS	:	.671	.598	.515
MAX RADIUS	:	1.146	1.080	.719
HORIZONTAL SPREAD	:	1.338	1.338	.743
VERTICAL SPREAD	:	1.437	1.307	1.307
EXTREME SPREAD	:	1.923	1.728	1.348
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	