

C6349074

MODEL 700™ N24

Model **SWS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

Arms Services Repair & Estimate System

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

Repair Inquiry

Repair Number: RE00146475

Serial: C6349074 Model M24 SWS Center Fire
Caliber: 7.62 NATO Produced: 06/19/1990

Repairman:

Verify Repair

Status:

Closed 6/17/2008 9:52:11 AM

Address Information

Customer:

☒ Received From

Return To:

☐ Received From

Name: DEF DIST DEPOT

DEF DIST DEPOT

Address 1: 7 FRANKFORD AVE BLDG 362

7 FRANKFORD AVE BLDG 362

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: NN

Fax:

Email:

Comments:

Received Condition

Fair

Condition

Notes:

CSR

Notes:

Accessories Received

Code	Desc	Qty
A017	Scope Base	1
A026	Scope	1
A045	Bi Pod	1
D000	FRT SGT BASE	1

Repair Search

Refresh

Close

nagletj

6/17/2008

10:49 AM

C4PS

NUM

INS

SCPL



10:49 AM

Number: C6349074

Model: M24 SWS



RE00146475

INSPECTION CHECKLIST - REPAIRS

CONTRACT #: W52H09-07-C-0207

ISSUED 10/1/2007

R & E NUMBER

146475

SERIAL NUMBER

C6349074

LOG-IN DATE

6-17-08

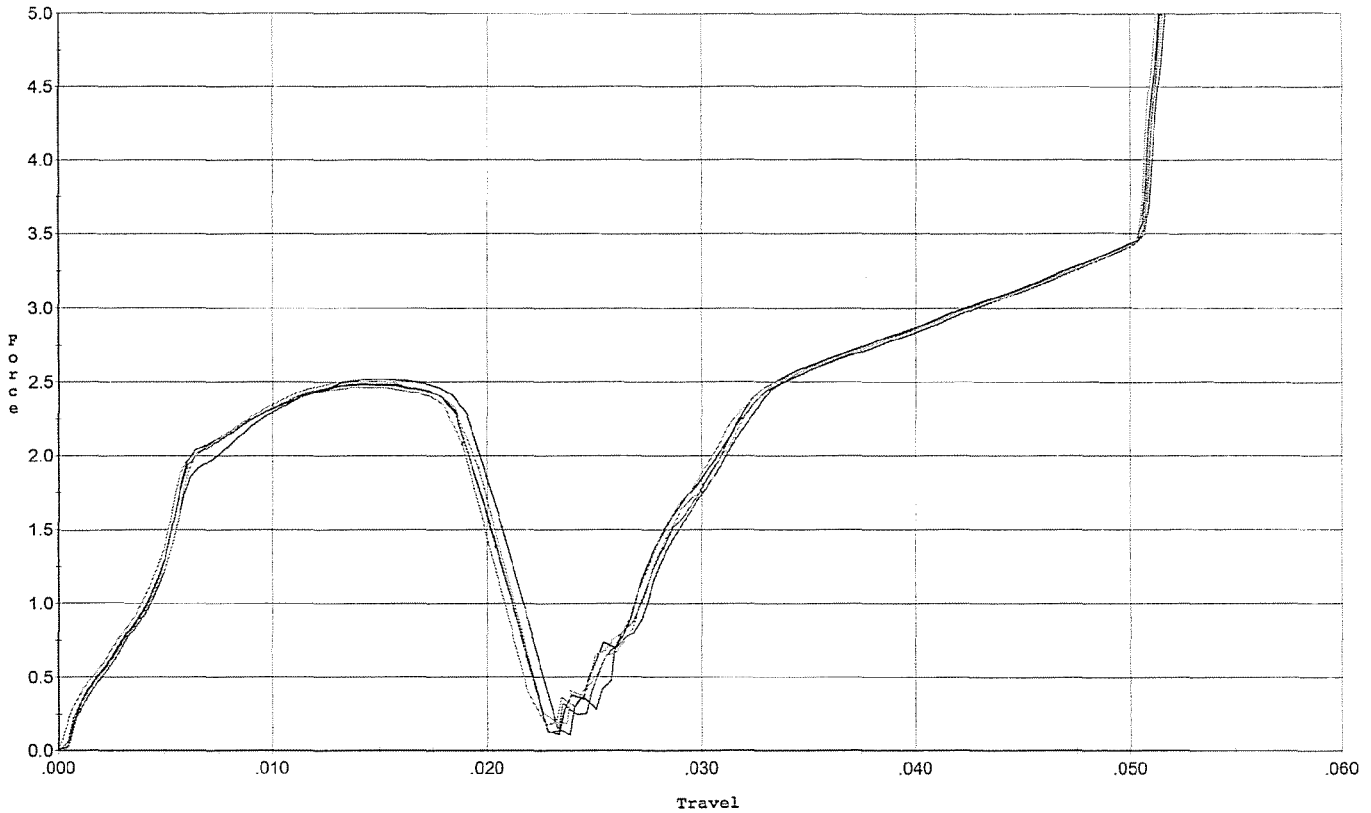
OPERATION #	OPERATION NAME	DATE	INITIAL
500	DIS-ASSEMBLE GUN	9-9-09	RTZ
505	RE BARREL	9-11-09	RTZ
420	ASSEMBLE	9-11-09	RTZ
440	PROOF	9-11-09	SPD
460	CHECK HEADSPACE	9-11-09	SPD
470	DIS-ASSEMBLE GUN	9-11-09	SPD
480	MAGNAFLUX	9-11-09	SPD
510	DRILL AND TAP	9-14-09	SP
500	ROLLMARK CALIBER	9-17-09	SP
520	GOFF BLAST BBL / REC	9-17-09	SP
530 & 540	APPLY COATINGS	9-18	
560	FINAL ASSEMBLY	9-23-09	RTZ
640	FUNCTION TEST AND	9-28-09	SPD
650	TARGET	9-28-09	SPD
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
670	FINAL INSPECTION	9-28-09	RP
	A) HEADSPACE	9-29-09	RB
	B) TRIGGER PULL	270 277 263 262 270	9/29/09 RB
680	F) SAFETY ON FORCE	3" 3" 3"	9/29/09 RB
	G) SAFETY OFF FORCE	7" 7" 7"	
	H) FIRING PIN INDENT	.021 .021 .021	
690	PACK	10/12/09	Fm

F006 REV 1/2009

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R.P. 9/8/09

Model: M/24
Serial No: Form #F005
Trigger: 2.5 lbs. ini. +/- .50 lbs.



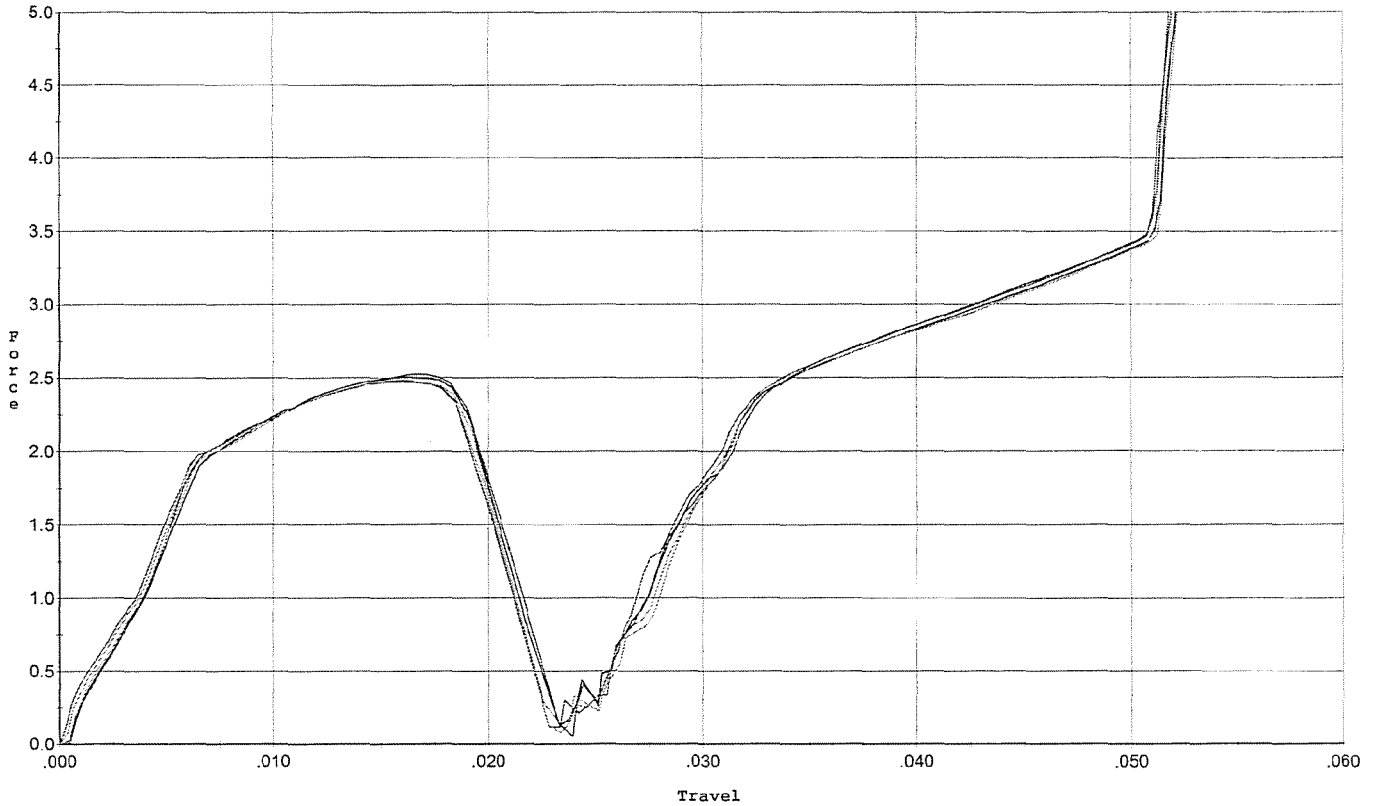
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.519	0.021	0.00	0.034	0.036		Set Trigger
2	2.482	0.020	0.00	0.035	0.036		Set Trigger
3	2.491	0.020	0.00	0.035	0.036		Set Trigger
4	2.514	0.020	0.00	0.035	0.035		Set Trigger
5	2.465	0.019	0.00	0.035	0.033		Set Trigger

Avg 2.49

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R.P. 9/8/09

Model: M/24
Serial No: Form #F005
Trigger: 2.5 lbs. after 50 cycles +/- .50 lbs.



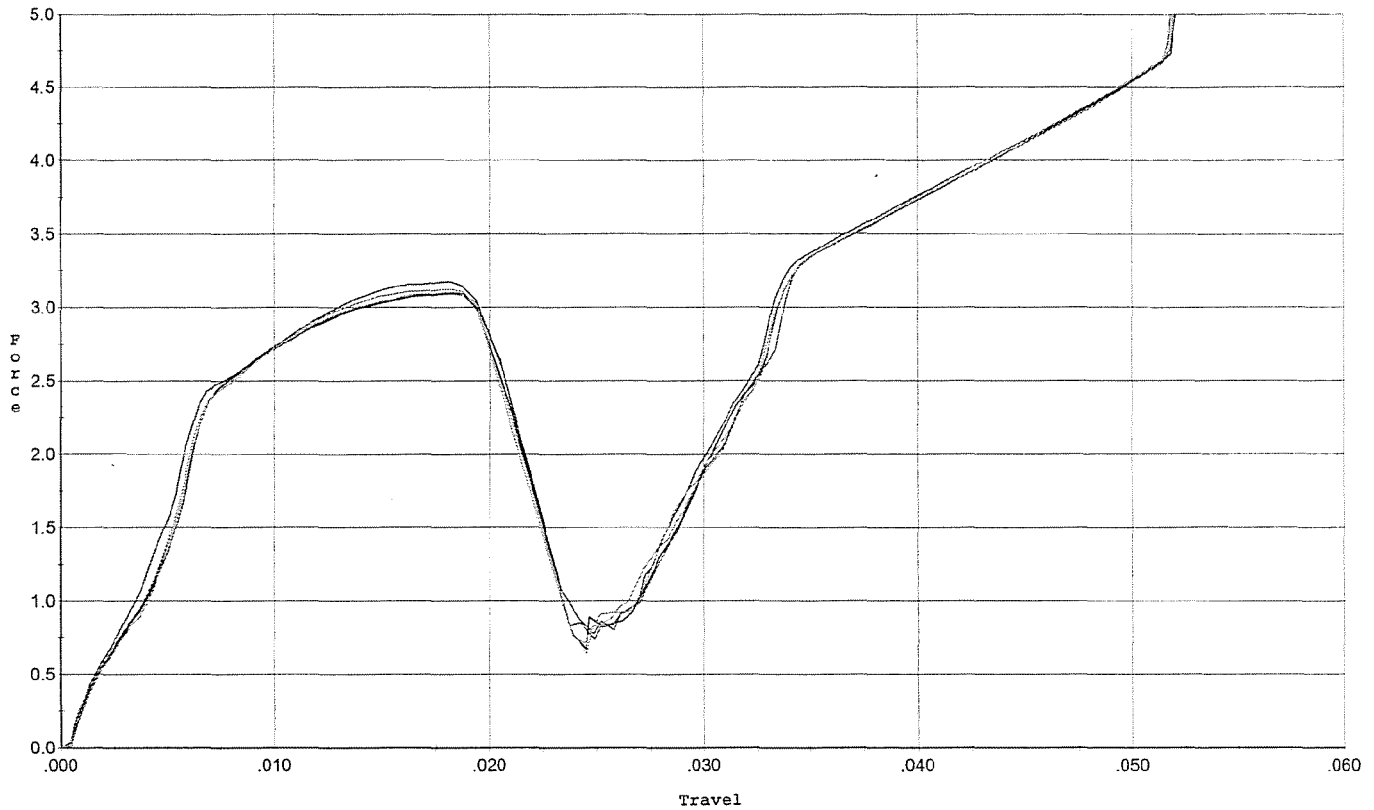
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.524	0.021	0.00	0.035	0.037		Set Trigger
2	2.506	0.019	0.00	0.035	0.033		Set Trigger
3	2.482	0.020	0.00	0.035	0.036		Set Trigger
4	2.485	0.020	0.00	0.035	0.035		Set Trigger
5	2.474	0.019	0.00	0.036	0.034		Set Trigger

Avg 2.49

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: R.P. 9/8/09

Model: M/24
Serial No: Form #F005
Trigger: 3.0 lbs. ini. +/- .75 lbs.



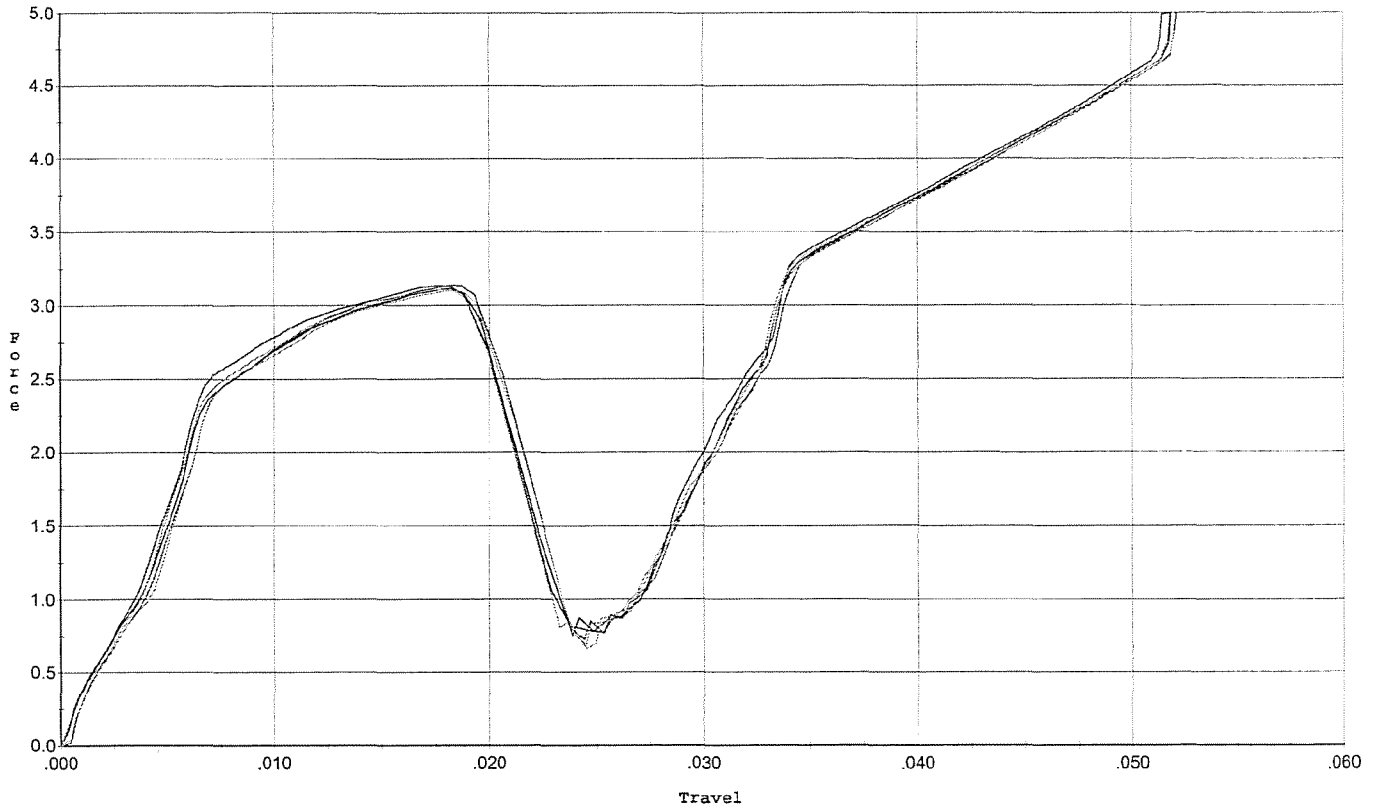
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.174	0.020	0.00	0.033	0.045		Set Trigger
2	3.096	0.021	0.00	0.033	0.044		Set Trigger
3	3.105	0.021	0.00	0.033	0.043		Set Trigger
4	3.103	0.020	0.00	0.033	0.041		Set Trigger
5	3.123	0.021	0.00	0.033	0.045		Set Trigger

Avg 3.12

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R.P. 9/8/09

Model: M/24
Serial No: Form #F005
Trigger: 3.0 lbs. after 20 cycles +/- .75 lbs.



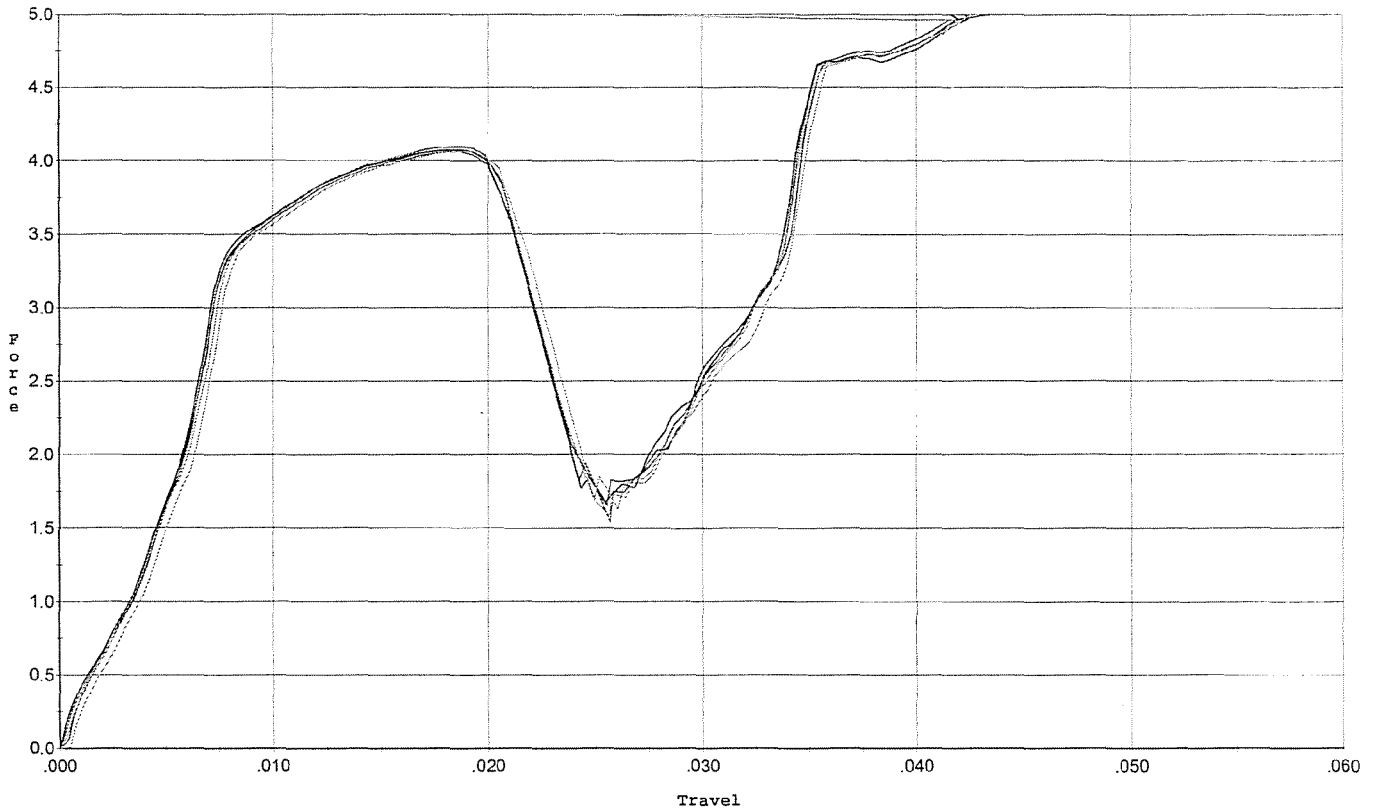
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.135	0.020	0.00	0.033	0.043		Set Trigger
2	3.114	0.020	0.00	0.033	0.041		Set Trigger
3	3.137	0.021	0.00	0.033	0.044		Set Trigger
4	3.101	0.021	0.00	0.033	0.044		Set Trigger
5	3.109	0.020	0.00	0.033	0.042		Set Trigger

Avg 3.11

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R.P. 9/8/09

Model: M/24
Serial No: Form #F005
Trigger: 4.0 lbs. ini. +/- 1.0 lbs.



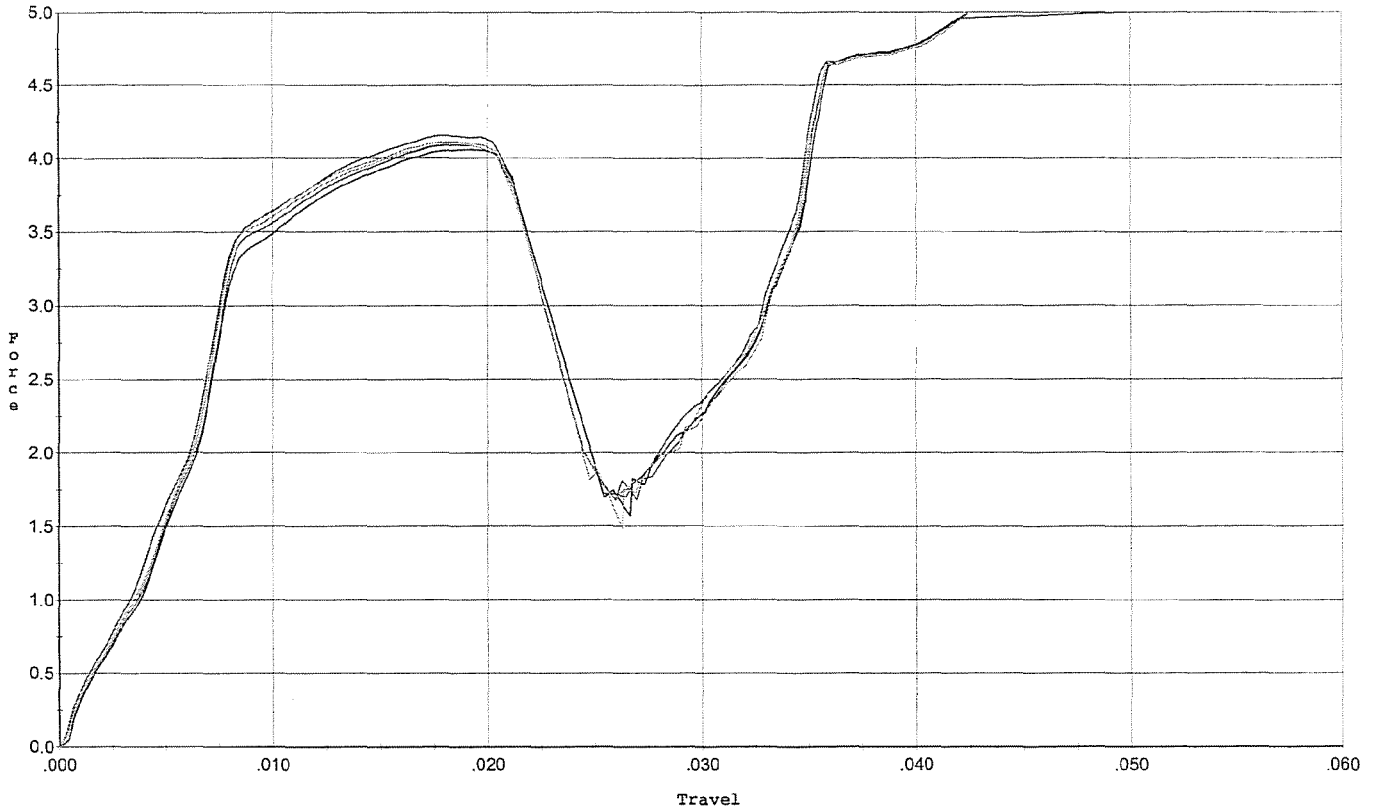
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.094	0.021	0.00	0.031	0.057		Set Trigger
2	4.072	0.021	0.00	0.031	0.058		Set Trigger
3	4.061	0.021	0.00	0.031	0.057		Set Trigger
4	4.065	0.022	0.00	0.031	0.059		Set Trigger
5	4.099	0.021	0.00	0.031	0.056		Set Trigger

Avg 4.07

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R.P. 9/8/09

Model: M/24
Serial No: Form #F005
Trigger: 4.0 lbs. after 20 cycles +/- 1.0 lbs.



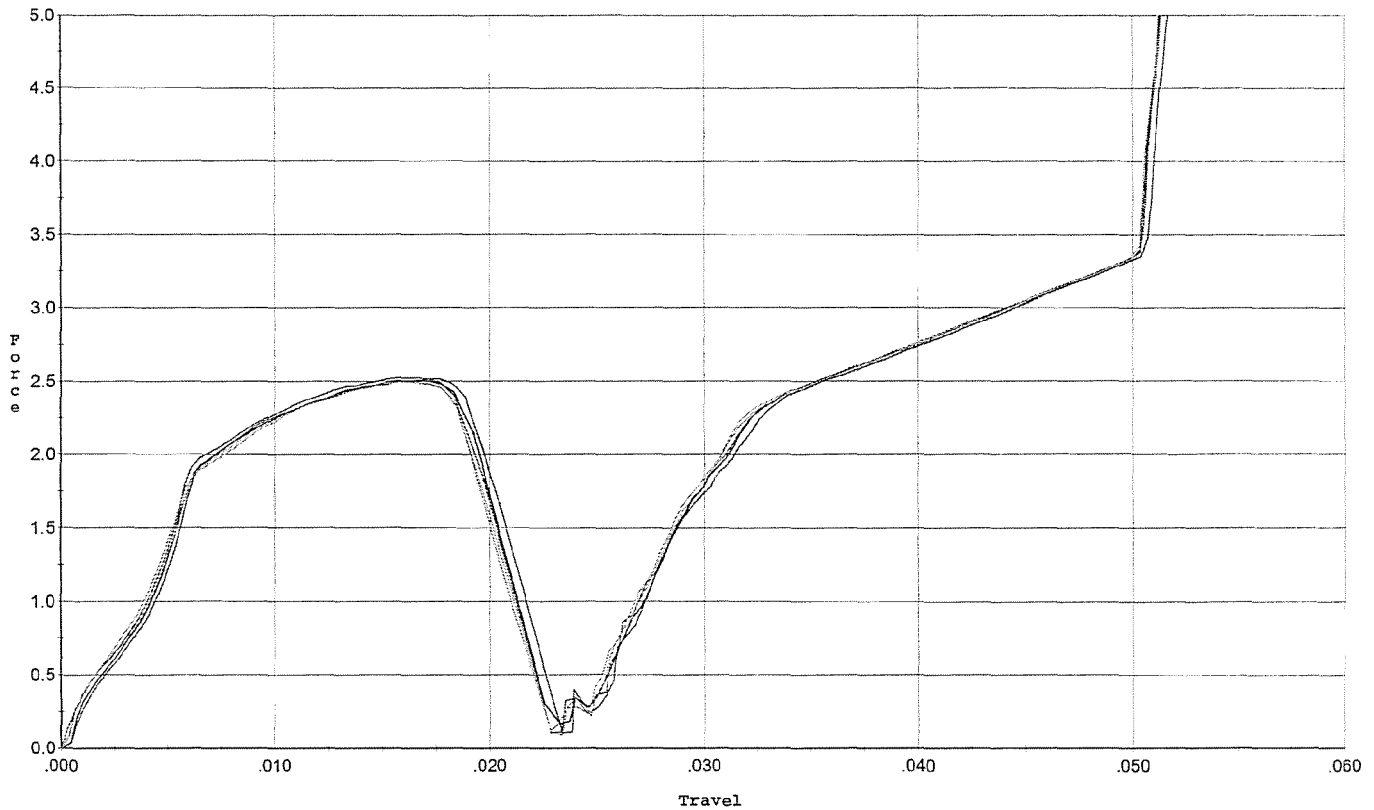
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.155	0.021	0.00	0.031	0.059		Set Trigger
2	4.057	0.021	0.00	0.031	0.057		Set Trigger
3	4.088	0.021	0.00	0.031	0.058		Set Trigger
4	4.094	0.021	0.00	0.031	0.058		Set Trigger
5	4.111	0.021	0.00	0.031	0.058		Set Trigger

Avg 4.10

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: R.P. 9/8/09

Model: M/24
Serial No: Form #F005
Trigger: reset to 2.5 lbs. +/- .50 lbs. for final test



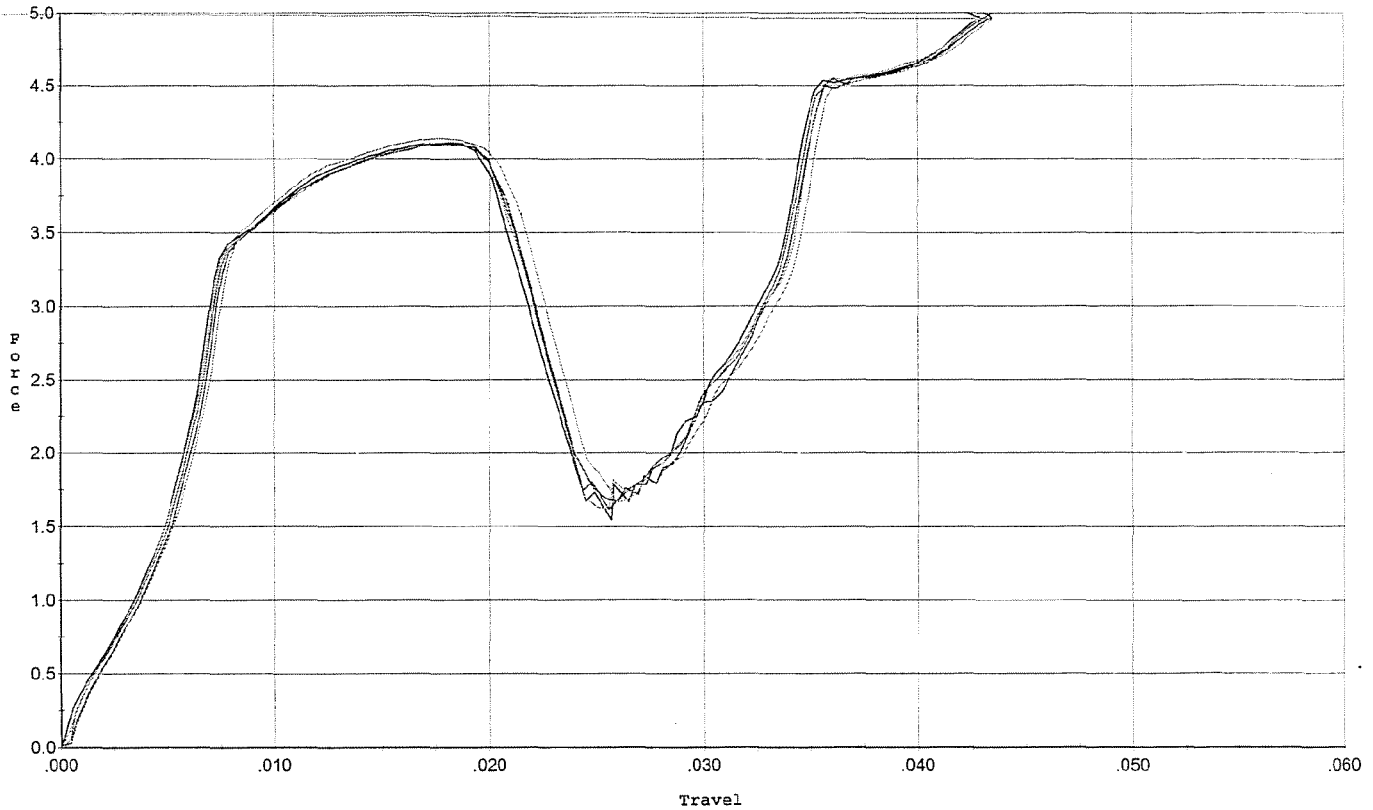
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.517	0.020	0.00	0.034	0.036		Set Trigger
2	2.507	0.019	0.00	0.035	0.034		Set Trigger
3	2.524	0.020	0.00	0.035	0.035		Set Trigger
4	2.502	0.020	0.00	0.035	0.035		Set Trigger
5	2.498	0.018	0.00	0.035	0.032		Set Trigger

Aug 2.51

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R.P. 9/8/09

Model: M/24
Serial No: Form #F005
Trigger: set to 4.0 lbs. +/- 1.0 lbs. for target & accuracy



#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.098	0.021	0.00	0.031	0.057		Set Trigger
2	4.109	0.020	0.00	0.031	0.055		Set Trigger
3	4.096	0.021	0.00	0.031	0.057		Set Trigger
4	4.115	0.021	0.00	0.031	0.058		Set Trigger
5	4.139	0.021	0.00	0.031	0.059		Set Trigger

Avg 4.11

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6349074.___0

FILE DATE AND TIME: 09/29/2009 10:13

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.003
The Average Y Centroid of the Five Target Set:	0.031
The Average Point of Impact of the Five Target Set:	0.031
The Average Mean Radius of the Five Target Set:	0.987
The Distance from POA to Centroid Target #1:	0.188
The Distance from Centroid Target #2 to Centroid Target #1:	0.125
The Distance from Centroid Target #3 to Centroid Target #1:	0.180
The Distance from Centroid Target #4 to Centroid Target #1:	0.179
The Distance from Centroid Target #5 to Centroid Target #1:	0.519

SERIAL NUMBER: C6349074. __ 0

TARGET NUMBER: 1

FILE DATE: 09/29/2009

FILE TIME: 10:13

X CENTROID: -0.107

Y CENTROID: 0.155

POA TO CENTROID: 0.188

HORZ SPREAD: 1.719

VERT SPREAD: 2.891

GROUP SPREAD: 2.921

MIN RADIUS: 0.510

MAX RADIUS: 1.646

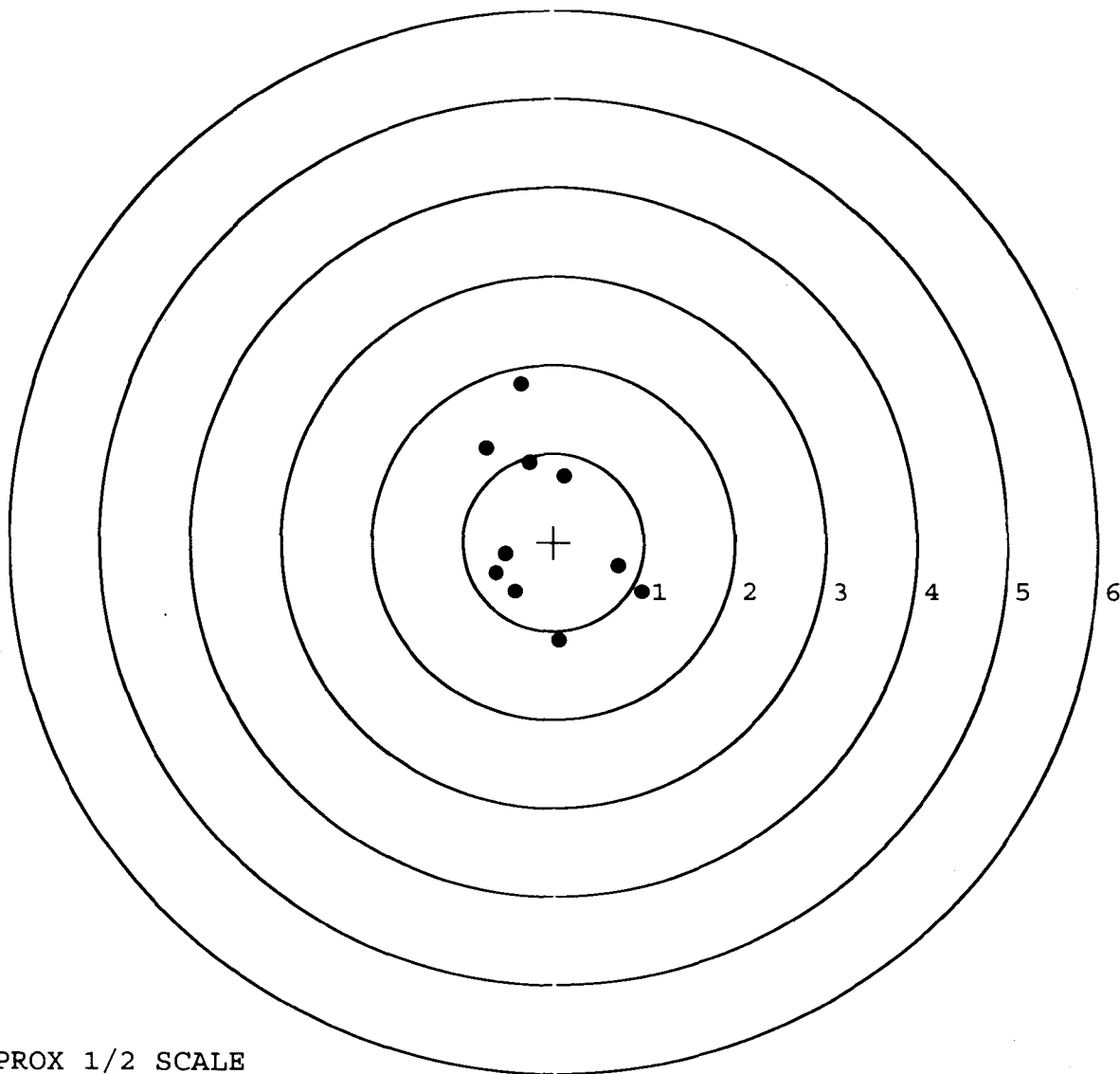
MEAN RADIUS: 0.966

IN 1 IN DIAMETER: 0

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 9

POINT#	X	Y
1:	-0.359	1.781
2:	-0.740	1.060
3:	-0.265	0.904
4:	0.125	0.752
5:	0.061	-1.110
6:	0.979	-0.557
7:	0.718	-0.261
8:	-0.426	-0.548
9:	-0.636	-0.344
10:	-0.531	-0.129



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6349074. __0

TARGET NUMBER: 2

FILE DATE: 09/29/2009

FILE TIME: 10:13

X CENTROID: -0.064

Y CENTROID: 0.038

POA TO CENTROID: 0.074

HORZ SPREAD: 1.445

VERT SPREAD: 1.509

GROUP SPREAD: 1.605

MIN RADIUS: 0.176

MAX RADIUS: 1.000

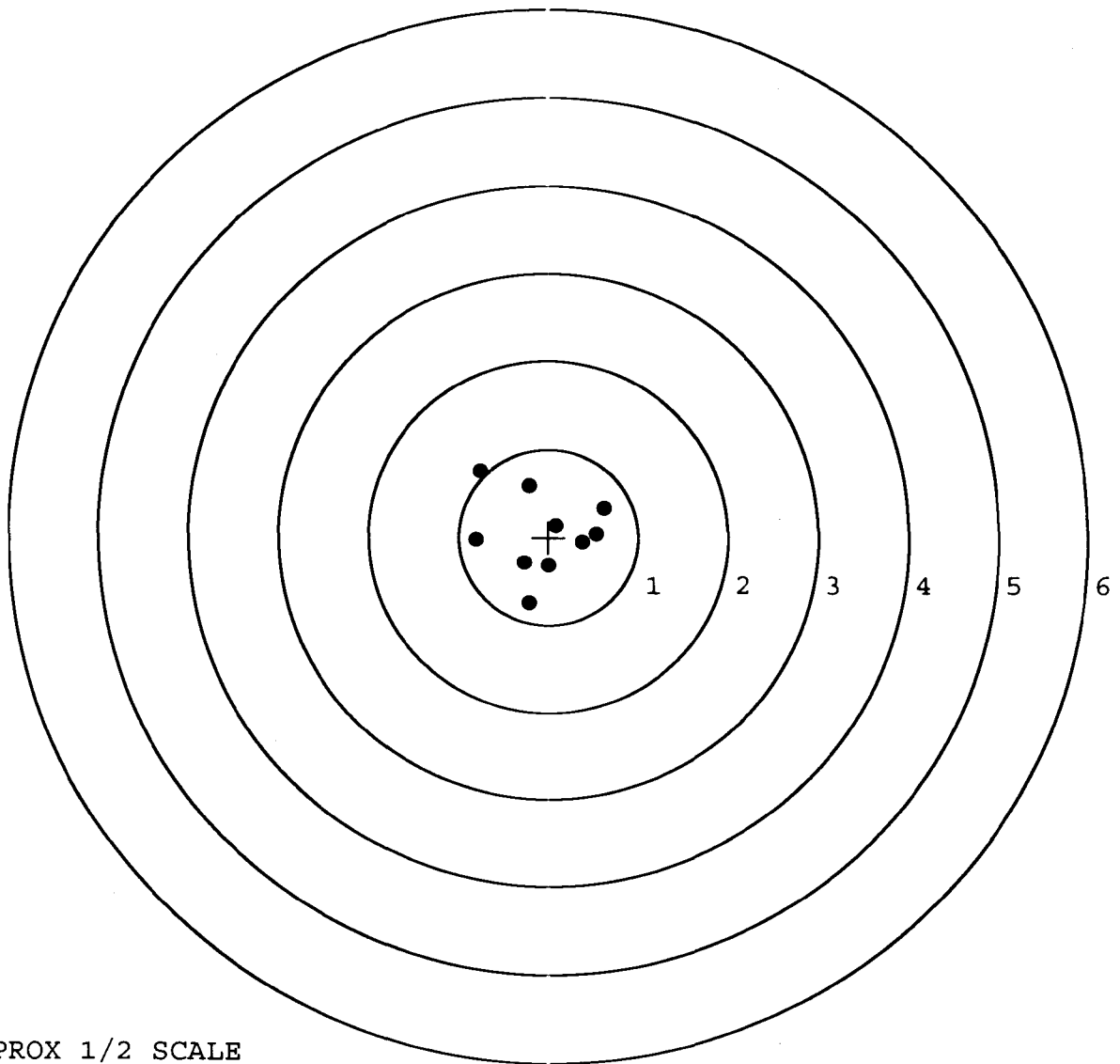
MEAN RADIUS: 0.588

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.765	0.750
2:	-0.210	0.583
3:	-0.812	-0.030
4:	-0.218	-0.759
5:	-0.271	-0.298
6:	0.004	-0.327
7:	0.084	0.134
8:	0.385	-0.058
9:	0.534	0.045
10:	0.633	0.335



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6349074. __0

TARGET NUMBER: 3

FILE DATE: 09/29/2009

FILE TIME: 10:13

POINT#	X	Y
1:	-0.199	1.805
2:	-0.946	1.004
3:	0.245	0.866
4:	1.136	0.550
5:	0.641	0.421
6:	0.035	0.005
7:	0.219	-0.600
8:	0.027	-0.694
9:	-0.188	-0.714
10:	-0.544	-2.091

X CENTROID: 0.043

Y CENTROID: 0.055

POA TO CENTROID: 0.070

HORZ SPREAD: 2.082

VERT SPREAD: 3.896

GROUP SPREAD: 3.911

MIN RADIUS: 0.051

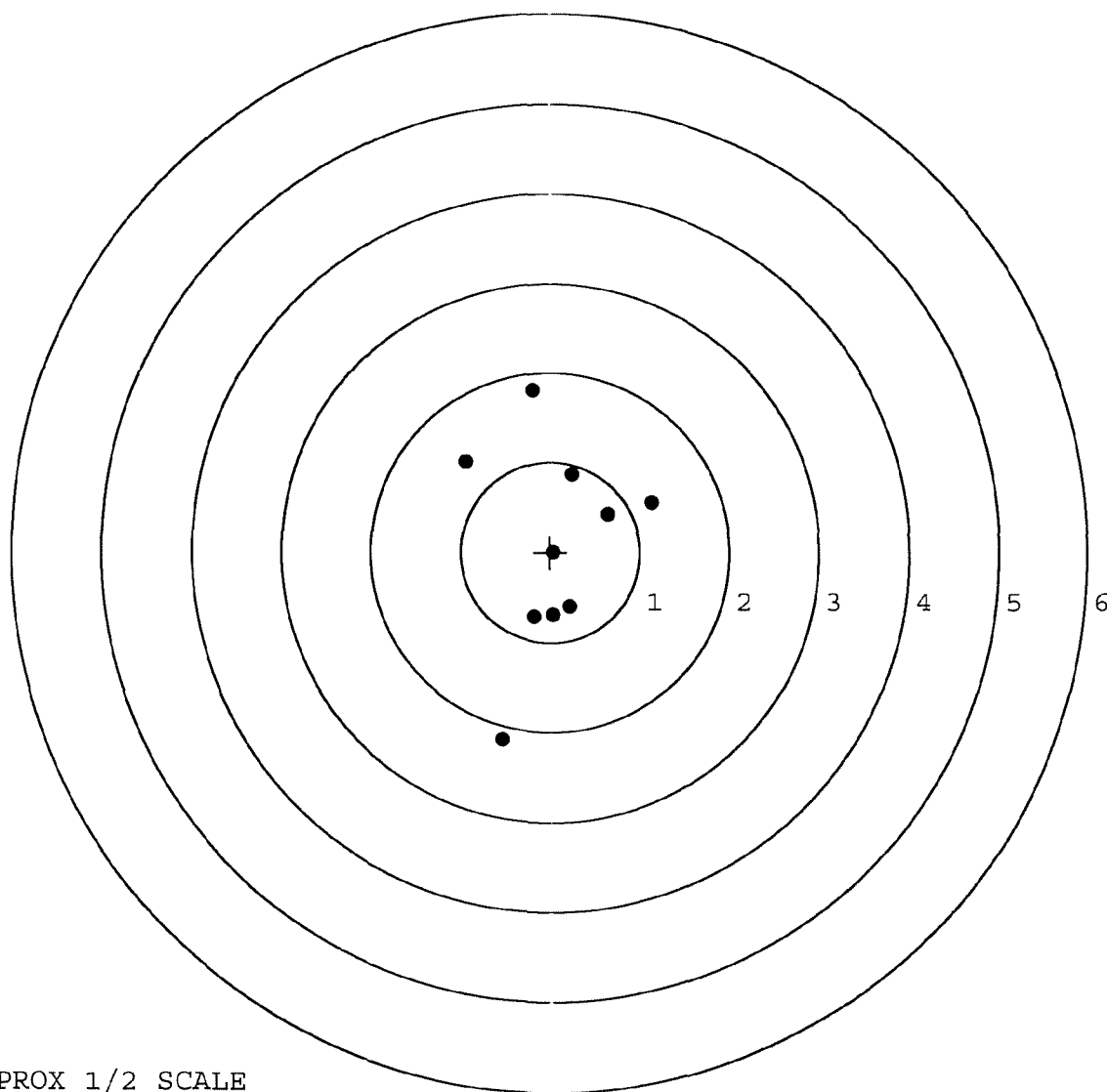
MAX RADIUS: 2.225

MEAN RADIUS: 1.038

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 8



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6349074. __0

TARGET NUMBER: 4

FILE DATE: 09/29/2009

FILE TIME: 10:13

POINT#	X	Y
1:	0.710	2.762
2:	0.167	2.171
3:	-0.901	1.226
4:	0.607	0.455
5:	-0.155	-1.587
6:	0.083	-1.291
7:	0.115	-0.607
8:	-0.145	-0.587
9:	0.097	-0.230
10:	-0.032	0.005

X CENTROID: 0.055

Y CENTROID: 0.232

POA TO CENTROID: 0.238

HORZ SPREAD: 1.611

VERT SPREAD: 4.349

GROUP SPREAD: 4.434

MIN RADIUS: 0.243

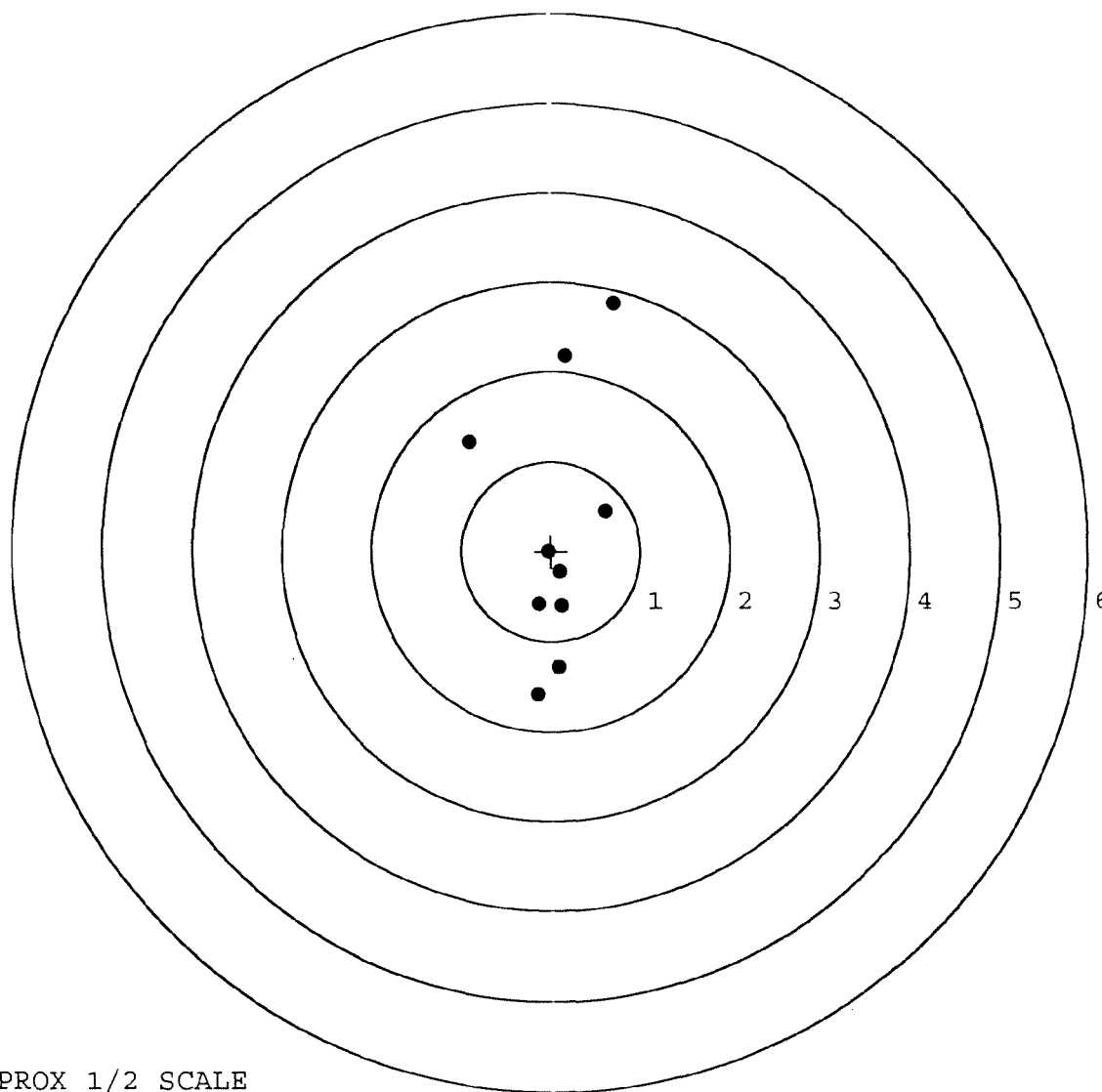
MAX RADIUS: 2.614

MEAN RADIUS: 1.227

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 5

in 3 IN DIAMETER: 6



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6349074. __0

TARGET NUMBER: 5

FILE DATE: 09/29/2009

FILE TIME: 10:13

X CENTROID: 0.091

Y CENTROID: -0.325

POA TO CENTROID: 0.337

HORZ SPREAD: 1.698

VERT SPREAD: 3.896

GROUP SPREAD: 3.896

MIN RADIUS: 0.473

MAX RADIUS: 2.268

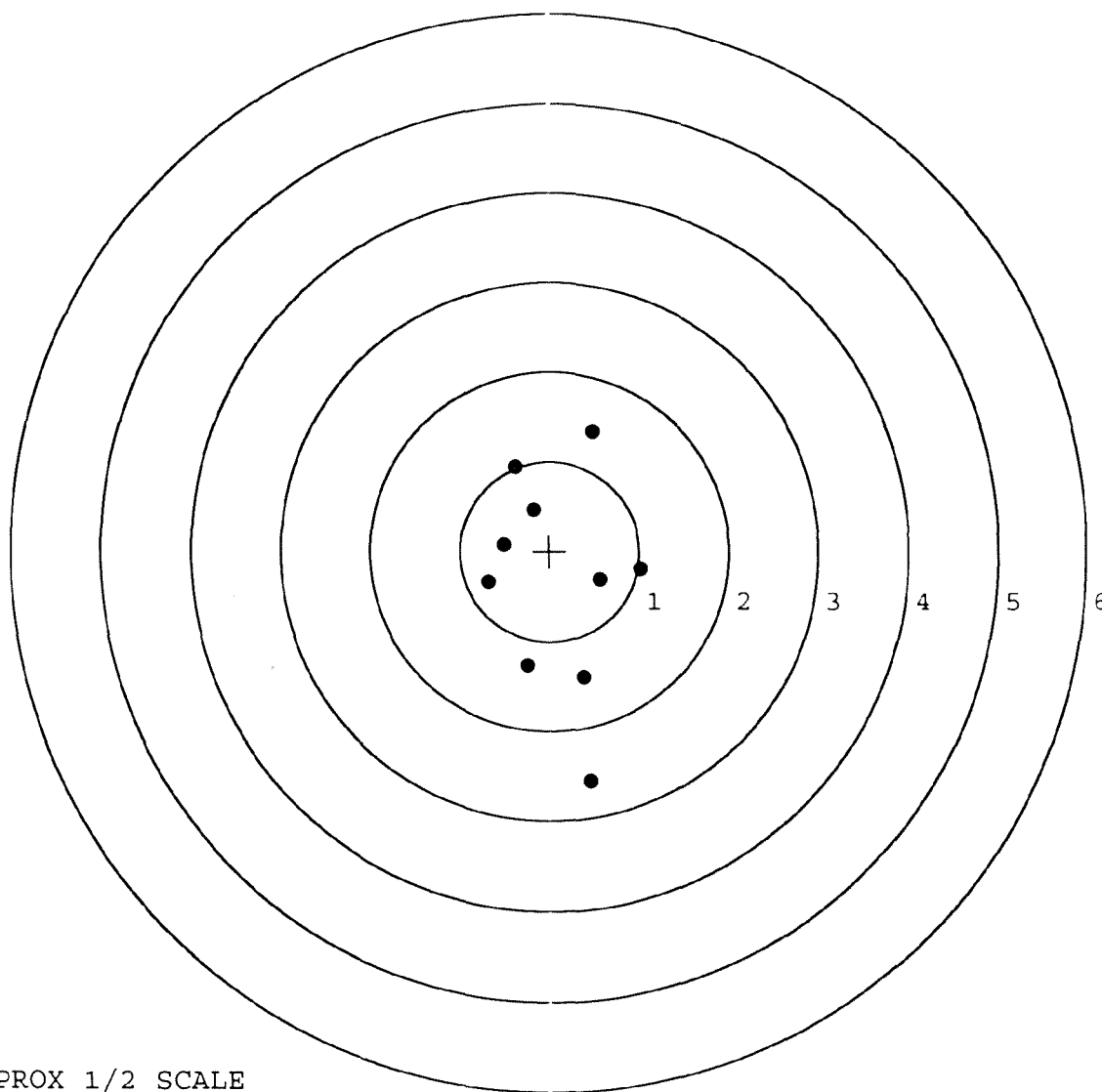
MEAN RADIUS: 1.117

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 5

in 3 IN DIAMETER: 8

POINT#	X	Y
1:	0.487	1.334
2:	-0.384	0.943
3:	-0.180	0.461
4:	-0.509	0.079
5:	-0.683	-0.335
6:	0.564	-0.310
7:	1.015	-0.198
8:	0.383	-1.394
9:	-0.248	-1.267
10:	0.466	-2.562



TARGET APPROX 1/2 SCALE

Arms Services Repair & Estimate System

File Add Repair Estimate Repair Expedite Repair Inquiry Repair Tools CSR Tools Reports Issue Maintenance System Maintenance Help

Repair Inquiry

Repair Number: **RE00047795** Serial: C6349074 Model: 700 Center Fire Caliber: 7.62 NATO M-24 (SWS) Produced: 06/19/1990 Repairman: Status: Closed 6/7/02 11:10:03 AM

Verify Repair

Address Information

Customer: Received From: Return To: Received From:

Name: B CO 116 INF BN B CO 116 INF BN

Address 1: ATTN CW3 GUZMAN ATTN CW3 GUZMAN

Address 2: BLDG 7920 APENNIES DR PO Box: BLDG 7920 APENNIES DR PO Box:

City: FORT RILEY FORT RILEY

State: KS Zip Code: 66442 Country: US State: KS Zip Code: 66442 Country: US

FFL: [] [] [] [] [] [] [] []

Contact / Condition	Problems	Estimate	History / Status	Shipping / Billing
Date	Code	User ID	Desc	Current Status
6/7/02 11:06:57	New	fortie	Repair Added	Closed
6/7/02 11:10:03	Closed	fortie	Closed at Expedite	6/7/02 11:10:03 AM
				fortie
				Sniper Systems
				Repair Location
				ILN
				Current Location
				ILN

Repair Search Refresh Close

inagle 5/10/02 6:54 AM CAPS NUM INS SCRL

Start Inbox - Microsoft Outlook SAP Logon 46B Arms Services Repair 6:54 AM

Serial Number: **C6349074**

Model: **700**



RE00047795

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# $\pm$.50#
3.00# $\pm$.75#
4.00# $\pm$ 1.00#

SERIAL NO. _____

DATE 5-22-02

TESTER TRW

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.39	2.53		2.61	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.43	2.46		2.53	
PULL #3	2.56	2.46		2.62	
PULL #4	2.59	2.53		2.63	
PULL #5	2.21	2.45		2.59	
TOTAL	12.18	12.43		12.98	
AVG.	2.43	2.48		2.59	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.26	3.21		
PULL #2	3.21	3.00		
PULL #3	3.04	3.09		
PULL #4	3.12	3.12		
PULL #5	3.13	3.09		
TOTAL	15.76	15.51		
AVG.	3.15	3.10		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURAC
PULL #1	4.13	4.11		4.13
PULL #2	4.18	4.14		4.26
PULL #3	4.35	4.13		4.30
PULL #4	4.15	4.10		4.27
PULL #5	4.15	4.15		4.39
TOTAL	20.96	20.63		21.35
AVG.	4.19	4.12		4.27

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6349074.__0
FILE DATE AND TIME: 06/29/2002 11:36

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.041
The Average Y Centroid of the Five Target Set:	0.089
The Average Point of Impact of the Five Target Set:	0.098
The Average Mean Radius of the Five Target Set:	0.502
The Distance from POA to Centroid Target #1:	0.105
The Distance from Centroid Target #2 to Centroid Target #1:	0.162
The Distance from Centroid Target #3 to Centroid Target #1:	0.180
The Distance from Centroid Target #4 to Centroid Target #1:	0.370
The Distance from Centroid Target #5 to Centroid Target #1:	0.041

SERIAL NUMBER: C6349074. __0

TARGET NUMBER: 1

FILE DATE: 06/29/2002

FILE TIME: 11:36

X CENTROID: -0.103

Y CENTROID: 0.021

POA TO CENTROID: 0.105

HORZ SPREAD: 1.322

VERT SPREAD: 1.662

GROUP SPREAD: 1.726

MIN RADIUS: 0.101

MAX RADIUS: 0.937

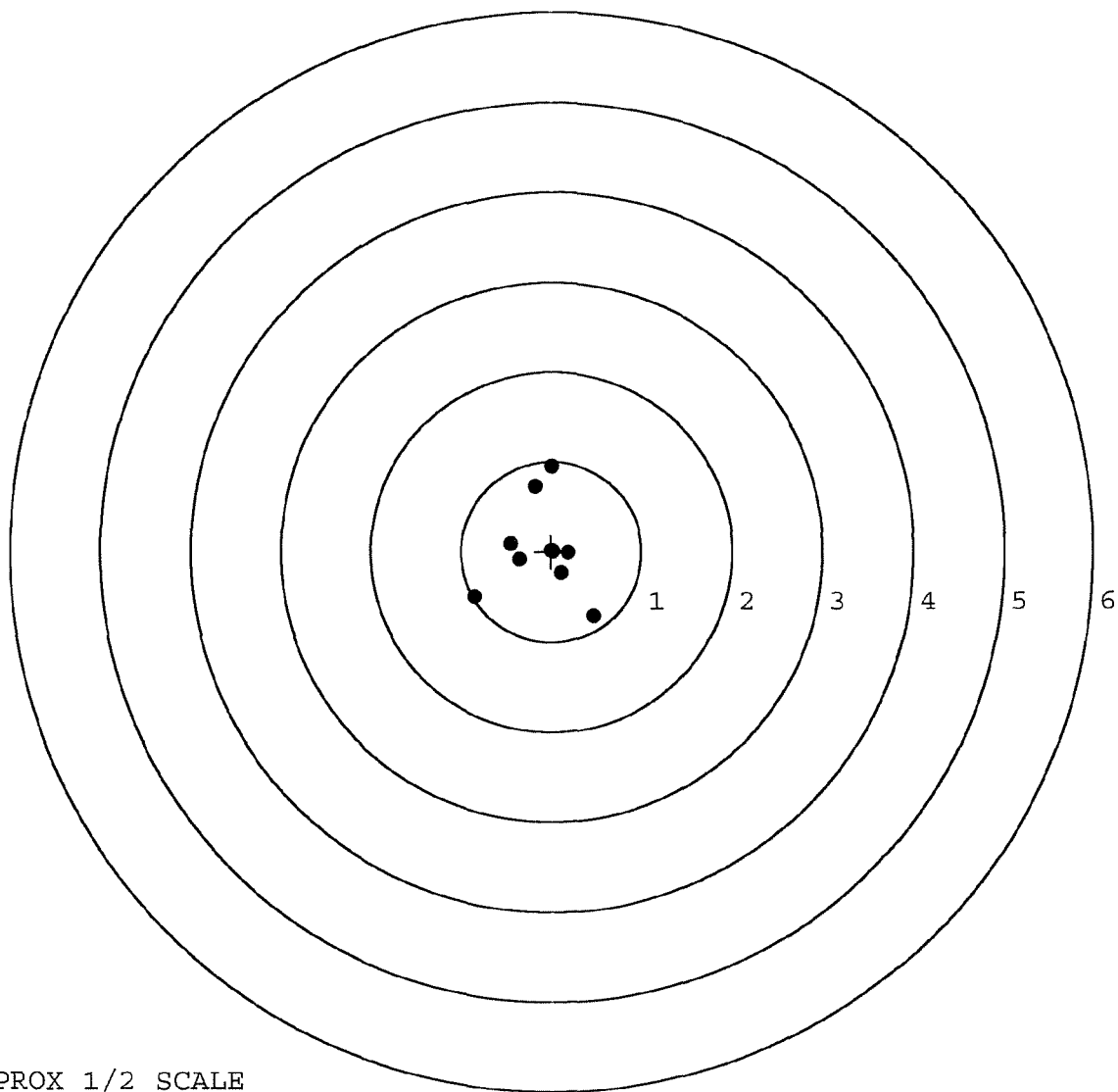
MEAN RADIUS: 0.498

IN 1 IN DIAMETER: 6

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.002	0.011
2:	0.025	-0.001
3:	0.192	-0.016
4:	0.113	-0.243
5:	0.473	-0.718
6:	-0.849	-0.496
7:	-0.448	0.093
8:	-0.355	-0.089
9:	-0.184	0.725
10:	0.007	0.944



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6349074. __0

TARGET NUMBER: 2

FILE DATE: 06/29/2002

FILE TIME: 11:36

X CENTROID: -0.248

Y CENTROID: 0.091

POA TO CENTROID: 0.265

HORZ SPREAD: 1.329

VERT SPREAD: 1.740

GROUP SPREAD: 1.917

MIN RADIUS: 0.323

MAX RADIUS: 1.136

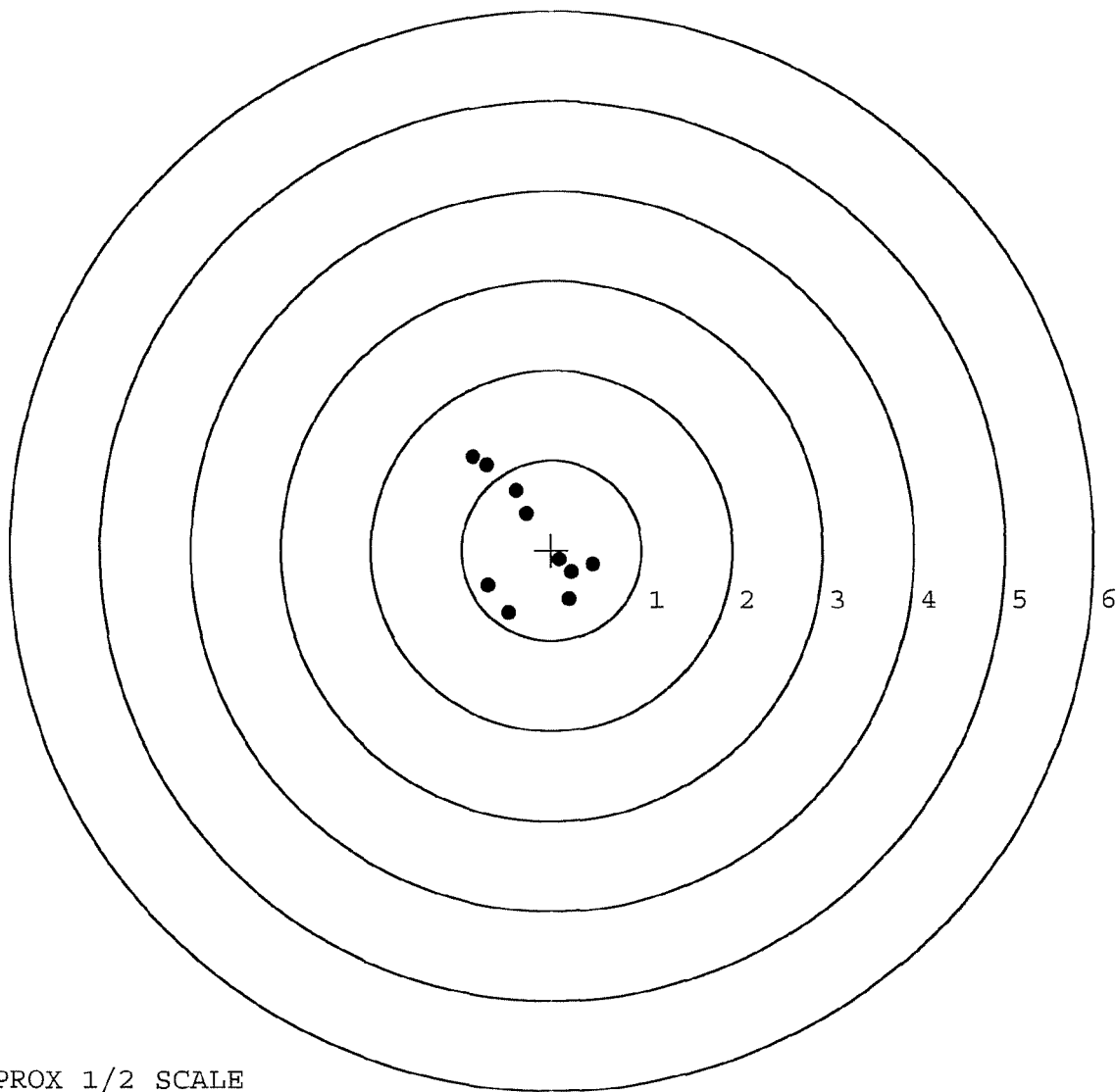
MEAN RADIUS: 0.702

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.867	1.044
2:	-0.718	0.947
3:	-0.395	0.661
4:	-0.285	0.412
5:	-0.705	-0.390
6:	-0.485	-0.696
7:	0.088	-0.108
8:	0.462	-0.159
9:	0.197	-0.551
10:	0.224	-0.251



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6349074.___0

TARGET NUMBER: 3

FILE DATE: 06/29/2002

FILE TIME: 11:36

POINT#	X	Y
1:	-0.064	0.894
2:	-0.556	-0.146
3:	0.592	0.350
4:	0.502	0.142
5:	-0.222	0.140
6:	-0.064	0.200
7:	-0.100	-0.070
8:	0.201	0.029
9:	-0.023	0.057
10:	-0.055	-0.086

X CENTROID: 0.021

Y CENTROID: 0.151

POA TO CENTROID: 0.152

HORZ SPREAD: 1.148

VERT SPREAD: 1.040

GROUP SPREAD: 1.151

MIN RADIUS: 0.098

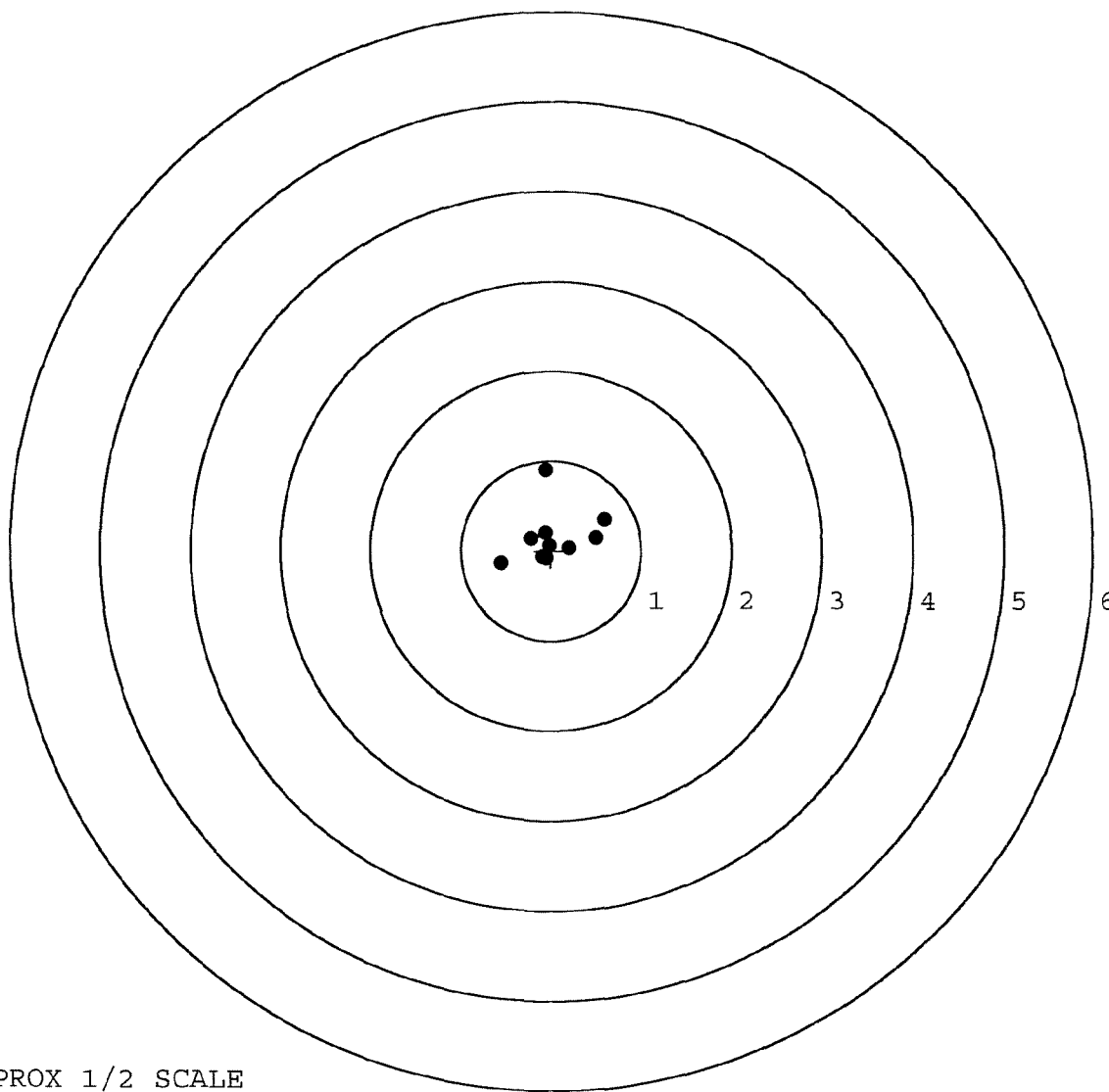
MAX RADIUS: 0.748

MEAN RADIUS: 0.365

IN 1 IN DIAMETER: 7

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10

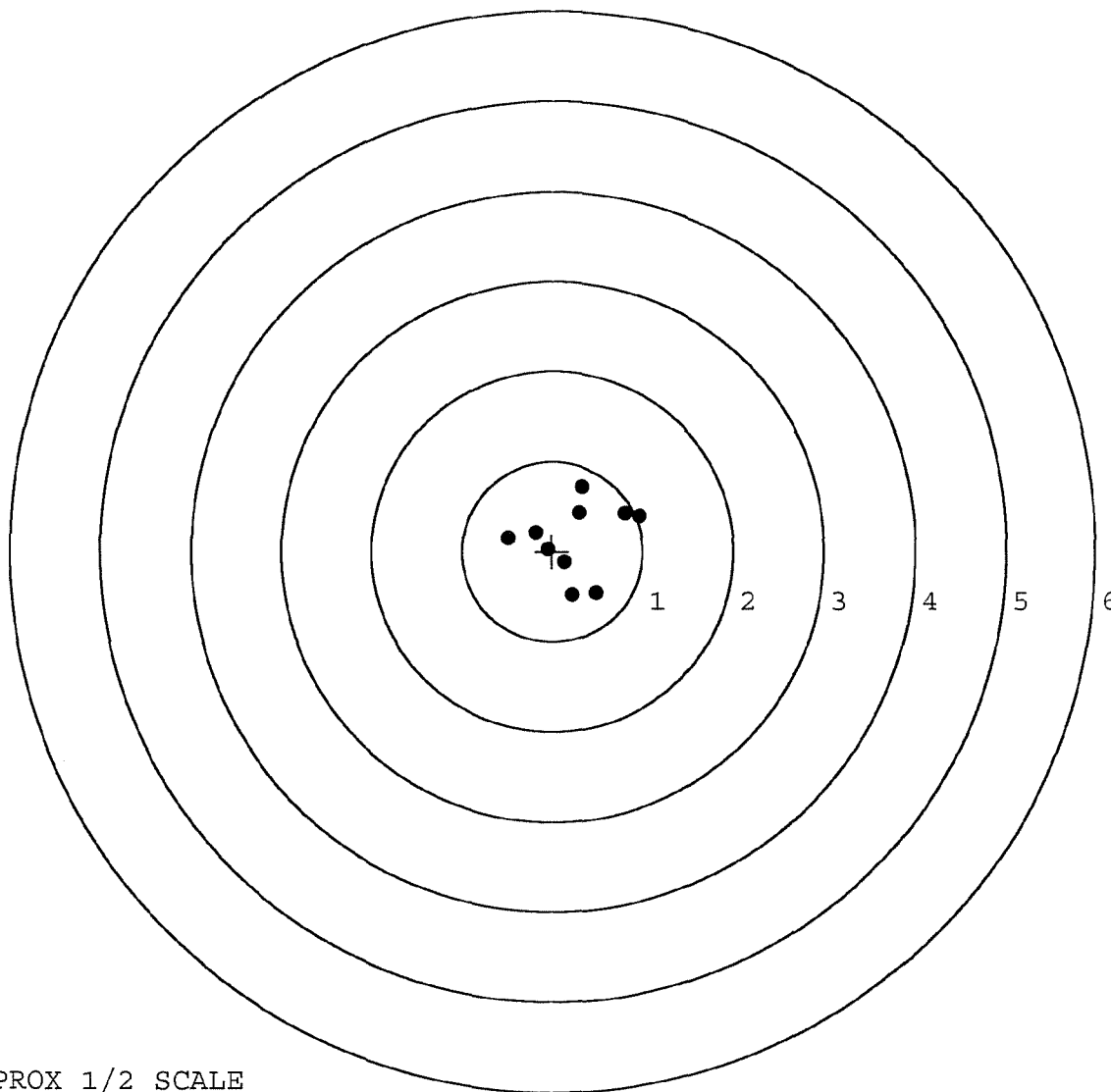


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6349074. __0
TARGET NUMBER: 4
FILE DATE: 06/29/2002
FILE TIME: 11:36

X CENTROID: 0.251
Y CENTROID: 0.128
POA TO CENTROID: 0.282
HORZ SPREAD: 1.454
VERT SPREAD: 1.215
GROUP SPREAD: 1.474
MIN RADIUS: 0.272
MAX RADIUS: 0.761
MEAN RADIUS: 0.533
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 10
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.331	0.725
2:	0.295	0.427
3:	0.803	0.427
4:	0.487	-0.462
5:	0.222	-0.490
6:	0.139	-0.120
7:	-0.051	0.021
8:	-0.189	0.209
9:	-0.490	0.151
10:	0.964	0.395

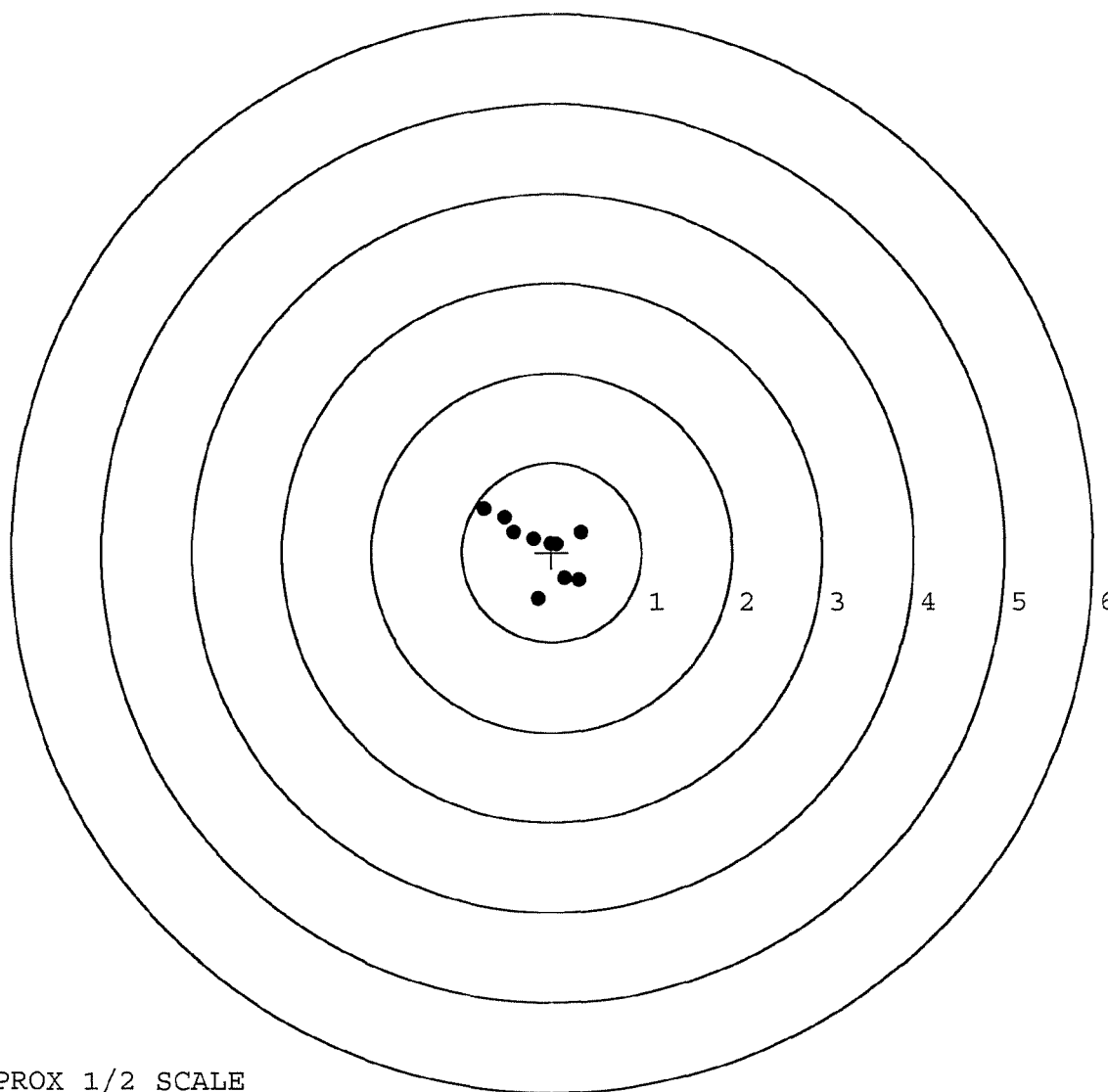


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6349074. __ 0
TARGET NUMBER: 5
FILE DATE: 06/29/2002
FILE TIME: 11:36

X CENTROID: -0.127
Y CENTROID: 0.054
POA TO CENTROID: 0.138
HORZ SPREAD: 1.079
VERT SPREAD: 1.008
GROUP SPREAD: 1.328
MIN RADIUS: 0.121
MAX RADIUS: 0.765
MEAN RADIUS: 0.414
IN 1 IN DIAMETER: 6
IN 2 IN DIAMETER: 10
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.321	0.228
2:	-0.014	0.098
3:	-0.429	0.229
4:	-0.758	0.487
5:	-0.532	0.395
6:	-0.156	-0.521
7:	0.143	-0.298
8:	0.300	-0.316
9:	0.057	0.091
10:	-0.204	0.150



TARGET APPROX 1/2 SCALE

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

R & E NUMBER 47795

SERIAL NUMBER C6349074

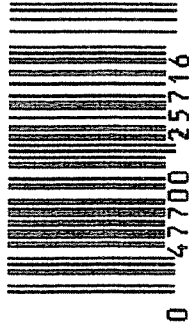
LOG-IN DATE 6/7/02

INSPECT AND VERIFY:			
OPERATION #	OPERATION NAME	DATE	INITIAL
550	DIS-ASSEMBLE GUN	6/14/02	RL
560 A	RE-BARREL AT CUSTOM SHOP	6/17/02	BWT
B	DRILL AND TAP	6/17/02	BWT
C	POLISH		
575	ASSEMBLE	6/17/02	RL
600	PROOF	6/17/02	RW
605	CHECK HEADSPACE	6/17/02	RW
610	DIS-ASSEMBLE GUN	6/17/02	RW
612	MAGNAFLUX	6/17/02	
615	ROLLMARK CALIBER	6/17/02	RW
618	ROTO-BLAST	6/19/02	RO
620	APPLY COATINGS	6-24	JA
625 A	FINAL ASSEMBLY	6/27/02	RL
B	TRIGGER PULL TEST		
C	SAFETY "ON" FORCE		
D	SAFETY "OFF" FORCE		
E	FIRING PIN INDENT		
640	TARGET	6-28-02	TRW
655	FINAL INSPECT		
660	PACK	6-28-02	RA
		SHIP DATE	
		QAR INSPECTION DATE	

Remington[®] MODEL 700TM H24 MADE IN ILION, 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.
DU PONT REG. U.S. PAT. & T.M. OFF.		SERIAL NO. C6349074
01		ORDER NO. 5716



LPC



CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6349074

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	1 30	90	RW
600	Proof	1 30	90	A
607	Check Headspace	1 30	90	A
610	Dis-assemble Gun	1 30	90	RW
612	Magnaflux Barrel Action	2-5-90		KCR
	Magnaflux Bolt	2-5-90		
615	Rollmark Caliber	2-5-90		CS
617	Drill and Tap Sight Holes	2-5-90		LB
618	Polish Barrel RB	2-5-90		WB
620	Apply Coatings (Barrel Action)		2-17-90	TJA
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		2/19/90	WB
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		2/19/90	WB
	C) Inspect Ejector Hole for Chamfer		4/18/90	RW
	D) Oil Firing Pin Ass'y		4/18/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		4/19/90	WB

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4.5	4.5	4.5			4/20/90	JL
	G) Safety Off Force	3	3	3			4/20/90	JL
	H) Trigger Pull Test & Retainability						4/19/90	JL
	I) Firing Pin Indent	.021	.022	.022			4/20/90	JL
	J) Assemble Stock						4/20/90	RW
	K) Assemble Swivel Studs						5/8/90	WB
	L) Attach Front and Rear Sight Assemblies						4/20/90	RW
	M) Iron Sight Alignment						4/20/90	RW
	N) Detach Front & Rear Sights & place in numbered container						4/20/90	RW
	O) Attach Scope to Rifle						4/20/90	WB
	P) Detach & Attach Scope 20 Times						4/20/90	WB
640	Gallery Target & Test						4-23-90	AC
	A) Time						4-23-90	AC
	B) Malfunctions						4-23-90	AC
	C) Pierced Primers						4-23-90	AC
	D) Optical Clarity of Scope						4-23-90	AC
645	Inspect for Live Ammo						4-23-90	AC
655	Final Inspection						5/8/90	WB
	A) Headspace							
	B) Trigger Pull	2.52	2.47	2.52	2.41	2.37	5/7/90	WB
	C) Function						5/8/90	WB
660	Pack						6-19-90	D/H

SWS TRIGGER PULL TEST

T11

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

SERIAL NO C6349074

DATE 4/19/90

TESTER J21

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.54	2.43	2.50	2.52	MIN. SETTING,
PULL #2	2.55	2.41	2.39	2.47	NO AVG. OF 5
PULL #3	2.44	2.30	2.32	2.52	READINGS ACCEPT-
PULL #4	2.35	2.45	2.32	2.41	ABLE LESS THAN 2#
PULL #5	2.33	2.51	2.28	2.37	
TOTAL	12.21	12.10	11.81		
AVG.	2.442	2.42	2.362		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.36	3.15		
PULL #2	3.27	3.20		
PULL #3	3.22	3.07		
PULL #4	3.20	3.23		
PULL #5	3.22	3.25		
TOTAL	16.27	15.90		
AVG.	3.254	3.18		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.41	4.18		4.13
PULL #2	4.25	4.19		4.50
PULL #3	4.25	4.11		4.49
PULL #4	4.18	4.13		4.50
PULL #5	4.24	4.20		4.48
TOTAL	21.33	20.81		22.10
AVG.	4.266	4.162		4.42

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6349074
23 Apr 1990

CENTROIDAL DISTANCES

0 TO 1	.0272947
1 TO 2	.0799812
1 TO 3	.258008
1 TO 4	.426433
1 TO 5	.254348

⁴
5-83 <----POA

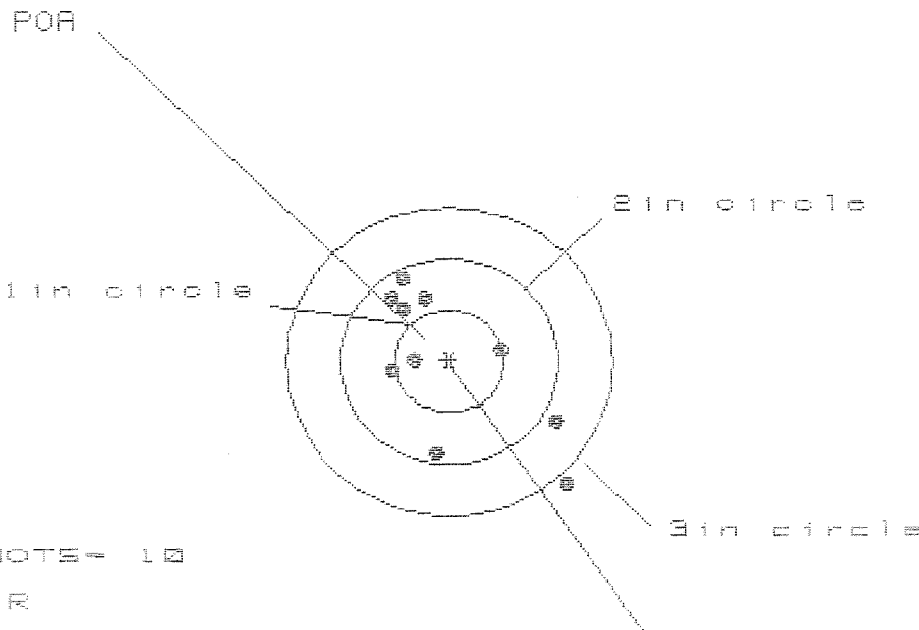
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .029
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0798
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0849061

THE AMR FOR THIS RIFLE IS: .8282

23 Apr 1990

FILE:/PATTERNING/CENTERFIRE_PATT/C8345074

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 0

3 in = 9

HS = 1.598

VS = 2.003

GS = 2.503

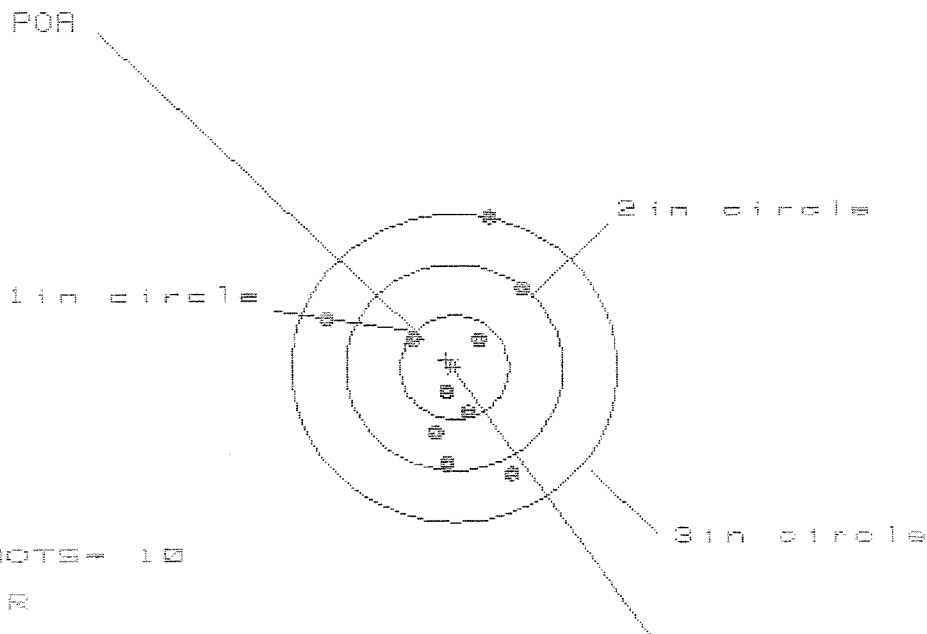
CENTROID *

PATTERN #				
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.049	1.114	.755
MINIMUM X	:	-.549	-.433	-.293
MAXIMUM Y	:	.044	.716	.623
MINIMUM Y	:	-1.159	-.995	-1.089
CENTROID X	:	.024	-.092	-.232
CENTROID Y	:	-.013	.115	.208
POA TO CENTROID in.	:	.020	.148	.312
MIN RADIUS	:	.369	.257	.195
MEAN RADIUS	:	.812	.680	.550
MAX RADIUS	:	1.563	1.340	1.101
HORIZONTAL SPREAD	:	1.598	1.547	1.048
VERTICAL SPREAD	:	2.003	1.711	1.711
EXTREME SPREAD	:	2.503	2.058	1.749
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	

23 Apr 1990

FILE:/PATTERNING/CENTERFIRE_PATT/C8349074

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1 in = 4

2 in = 7

3 in = 10

HS= 1.775

VS= 2.468

GS= 2.481

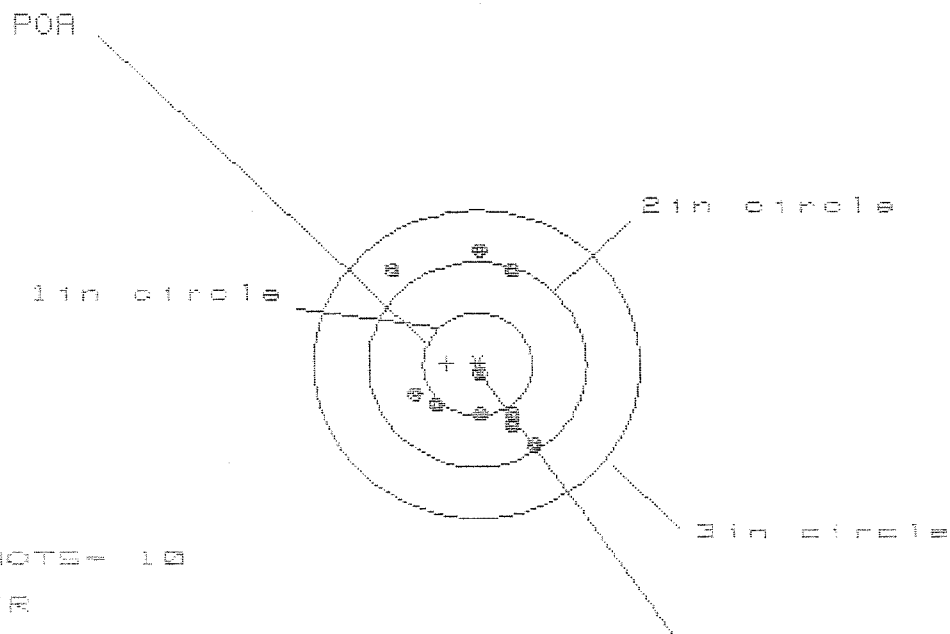
CENTROID #

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.617	.651	.510
MINIMUM X	-1.158	-1.124	-.443
MAXIMUM Y	1.453	.920	1.001
MINIMUM Y	-1.015	-.854	-.773
CENTROID X	.078	.044	.185
CENTROID Y	-.072	-.233	-.314
POA TO CENTROID in.	.106	.237	.364
MIN RADIUS	.208	.049	.181
MEAN RADIUS	.790	.677	.598
MAX RADIUS	1.484	1.297	1.123
HORIZONTAL SPREAD	1.775	1.775	.953
VERTICAL SPREAD	2.468	1.774	1.774
EXTREME SPREAD	2.481	2.277	1.829
NUMBER IN ONE INCH CIRCLE =	4		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	10		

23 Apr 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C8349074

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 2

2in = 8

3in = 10

HS= 1.320

VS= 1.925

GS= 2.167

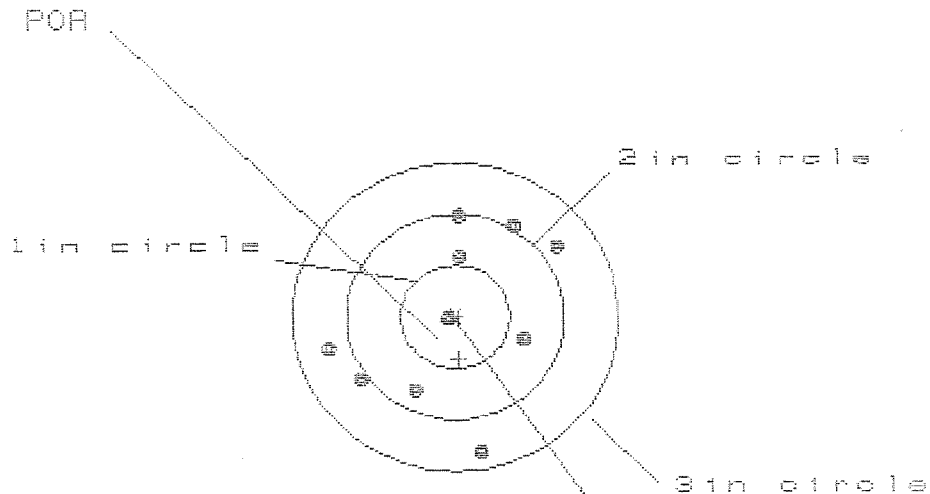
CENTROID #

PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	.564
MINIMUM X	-.756
MAXIMUM Y	1.154
MINIMUM Y	-.771
CENTROID X	.282
CENTROID Y	-.015
POA TO CENTROID in.	.282
MIN RADIUS	.042
MEAN RADIUS	.717
MAX RADIUS	1.212
HORIZONTAL SPREAD	1.320
VERTICAL SPREAD	1.925
EXTREME SPREAD	2.167
NUMBER IN ONE INCH CIRCLE =	2
NUMBER IN TWO INCH CIRCLE =	8
NUMBER IN THREE INCH CIRCLE =	10

23 Apr 1990

FILE:/PATTERNING/CENTERFIRE_PATT/08349074

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 4

3 in = 10

HSI= 2.103

VS= 2.320

GS= 2.329

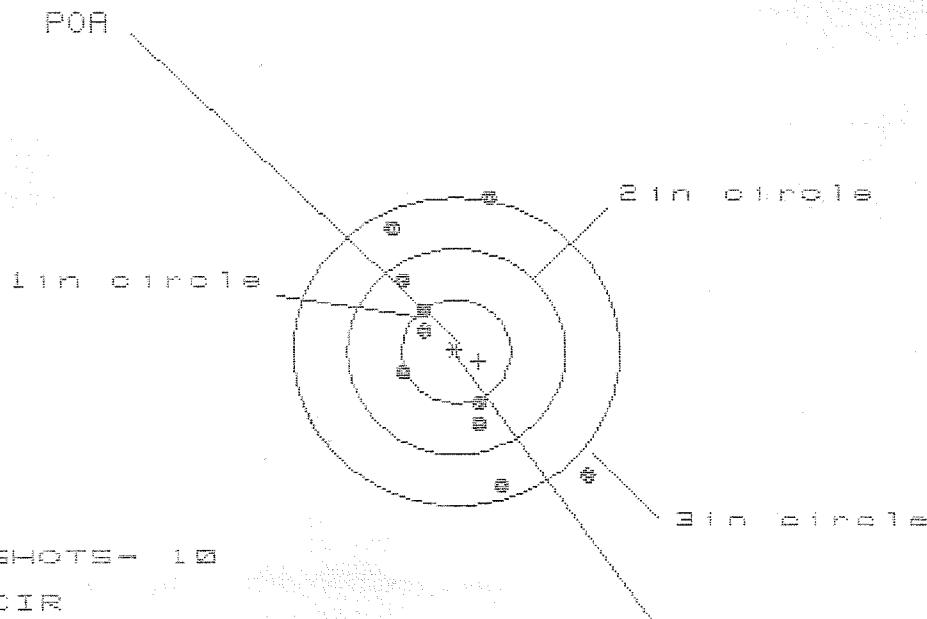
CENTROID *

PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.946	.972	.831
MINIMUM X	-1.157	-1.131	-.984
MAXIMUM Y	1.020	.876	.822
MINIMUM Y	-1.300	-.833	-.887
CENTROID X	-.030	-.056	.085
CENTROID Y	.410	.554	.608
POA TO CENTROID in.	.411	.557	.614
MIN RADIUS	.051	.188	.286
MEAN RADIUS	.886	.836	.773
MAX RADIUS	1.320	1.210	1.296
HORIZONTAL SPREAD	2.103	2.103	1.815
VERTICAL SPREAD	2.320	1.709	1.709
EXTREME SPREAD	2.329	2.301	2.229
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	10		

23 Apr 1990

FILE:/PATTERNING/CENTERFIRE_PATT/06349074

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 2

2in = 6

3in = 8

HS= 1.837

VS= 2.791

GS= 2.871

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.213	.503	.552
MINIMUM X	:	-.624	-.489	-.440
MAXIMUM Y	:	1.522	1.392	1.202
MINIMUM Y	:	-1.269	-1.399	-1.225
CENTROID X	:	-.209	-.344	-.393
CENTROID Y	:	.098	.228	.054
POA TO CENTROID in.	:	.231	.413	.397
MIN RADIUS	:	.361	.179	.272
MEAN RADIUS	:	.936	.811	.725
MAX RADIUS	:	1.690	1.487	1.344
HORIZONTAL SPREAD	:	1.837	.992	.992
VERTICAL SPREAD	:	2.791	2.791	2.427
EXTREME SPREAD	:	2.971	2.790	2.622
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	6		
NUMBER IN THREE INCH CIRCLE	=	8		