

06349130

MODEL 700TM M24

Model **SWS** TM

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

Remington

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6349130

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	10-9	89	RW
600	Proof	10-9	89	A
607	Check Headspace	10-9	89	RW
610	Dis-assemble Gun	10-9	89	RW
612	Magnaflux Barrel Action	10/31/89		KCR
	Magnaflux Bolt	10/31/89		KCR
615	Rollmark Caliber			
7	Drill and Tap Sight Holes			
618	Polish Barrel			
620	Apply Coatings (Barrel Action)		11/3/89	TH
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		11/6/89	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		11/6/89	RW
	C) Inspect Ejector Hole for Chamfer		11/6/89	RW
	D) Oil Firing Pin Ass'y		12/6/89	RW
	E) Adjust Trigger Pull to Min Setting and Stake		7/10/89	QJ

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	4	4			10/20/89	JS
	G) Safety Off Force	3	2	3			10/20/89	JS
	H) Trigger Pull Test & Retainability						7/20/89	JS
	I) Firing Pin Indent	.020	.020	.0205			10/20/89	JS
	J) Assemble Stock						11/13/89	RW
	K) Assemble Swivel Studs						15/00/89	JS
	L) Attach Front and Rear Sight Assemblies						11/13/89	RW
	M) Iron Sight Alignment						11/13/89	RW
	N) Detach Front & Rear Sights & place in numbered container						11/13/89	RW
	O) Attach Scope to Rifle						13/00/89	JS
	P) Detach & Attach Scope 20 Times						13/00/89	JS
640	Gallery Target & Test						11-14-89	DH
	A) Time						11-14-89	DH
	B) Malfunctions						11-14-89	DH
	C) Pierced Primers						11-14-89	DH
	D) Optical Clarity of Scope						11-14-89	DH
645	Inspect for Live Ammo						11-14-89	DH
655	Final Inspection							
	A) Headspace						15/00/89	JS
	B) Trigger Pull	2.67	2.74	2.76	2.75	2.72	15/00/89	JS
	C) Function						15/00/89	JS
660	Pack						14/00/89	JS

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. 9130

DATE 23 Mar 90

TESTER JD

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	240	236		250	MIN. SETTING,
PULL #2	239	238		245	NO AVG. OF 5
PULL #3	238	236		245	READINGS ACCEPT-
PULL #4	238	238		250	ABLE LESS THAN 2#
PULL #5	236	238		248	
TOTAL	1189	1186			
AVG.	237.8	237.2			

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	298	299		
PULL #2	297	302		
PULL #3	301	304		
PULL #4	305	300		
PULL #5	301	304		
TOTAL	1502	1509		
AVG.	300.4	301.8		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	401	402		
PULL #2	390	402		
PULL #3	402	405		
PULL #4	401	401		
PULL #5	402	401		
TOTAL	1996	2011		
AVG.	399.2	402.2		

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6349130
14 Nov 1989

CENTROIDAL DISTANCES

0 TO	1	.497874
1 TO	2	.509883
1 TO	3	.469541
1 TO	4	.286587
1 TO	5	.3386

0.15
1

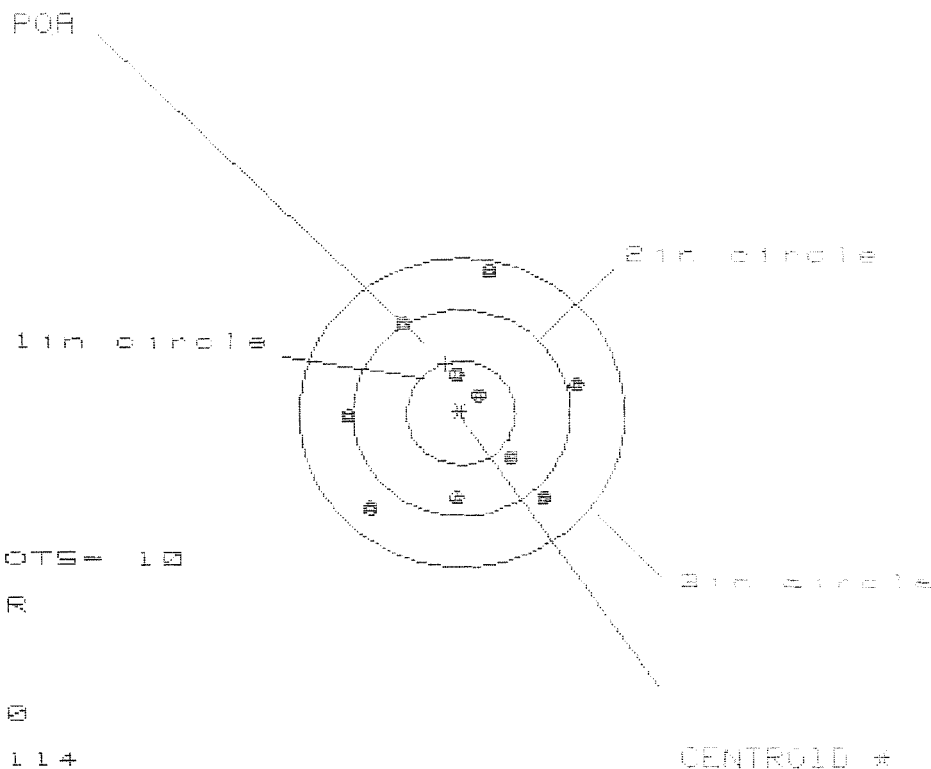
-----FOR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0042
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.2214
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .22144
THE AMR FOR THIS RIFLE IS: .9752

14 Nov 1989

FILE:\PATTERNING\CENTERFIRE_PATT\G3348130

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1in = 2

2in = 4

3in = 10

HS= 2.114

VS= 2.262

GS= 2.507

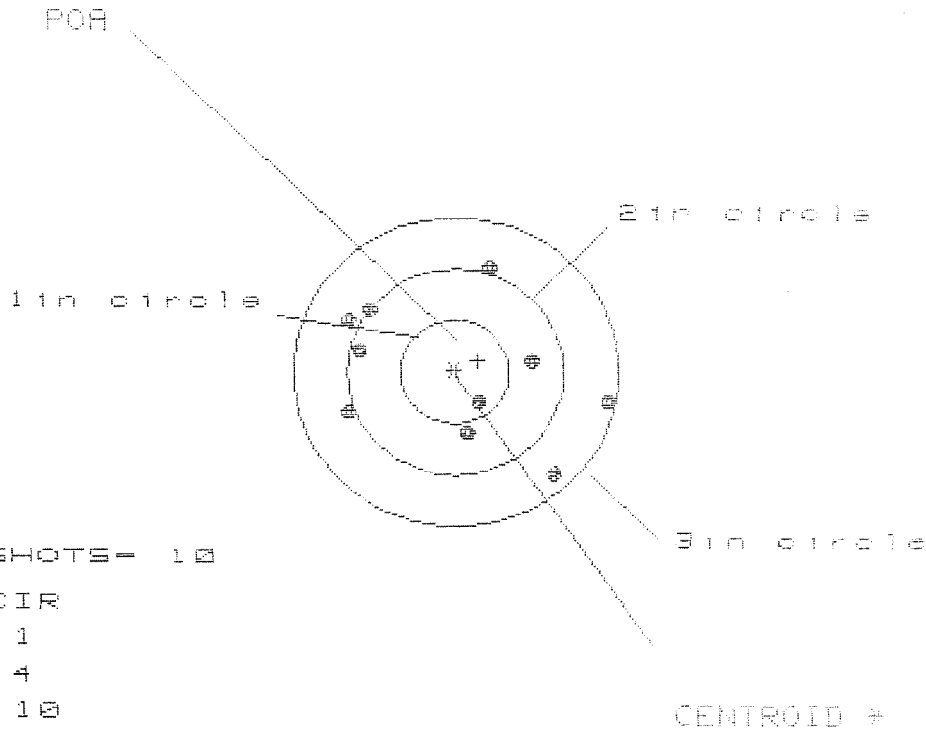
PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.034	1.059	.955
MINIMUM X	:	-1.080	-1.055	-1.159
MAXIMUM Y	:	1.335	1.045	.948
MINIMUM Y	:	-.927	-.779	-.795
CENTROID X	:	.143	.118	.222
CENTROID Y	:	-.477	-.625	-.528
POA TO CENTROID in.	:	.498	.636	.672
MIN RADIUS	:	.240	.386	.266
MEAN RADIUS	:	.906	.859	.901
MAX RADIUS	:	1.353	1.160	1.159
HORIZONTAL SPREAD	:	2.114	2.114	2.114
VERTICAL SPREAD	:	2.262	1.824	1.743
EXTREME SPREAD	:	2.507	2.213	2.126
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		10	

14 Nov 1989

FILE:/PATTERNING/CENTERFIRE_PATT/08348130

CENTERFIRE PATTERNS

2



OF SHOTS- 10

IN CIR

1in = 1

2in = 4

3in = 10

HS= 2.393

VS= 1.966

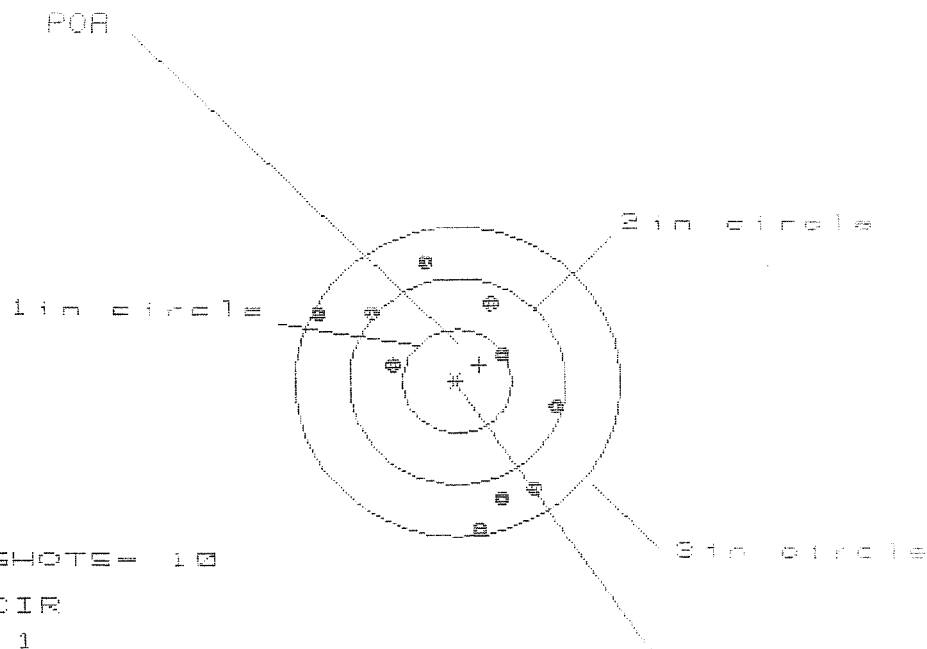
GS= 2.521

PATTERN #	2	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.383	1.032	1.032
MINIMUM X	-1.010	-0.857	-0.728
MAXIMUM Y	1.015	.988	.966
MINIMUM Y	-0.951	-0.978	-0.754
CENTROID X	-0.212	-0.365	-0.494
CENTROID Y	-0.111	-0.084	.008
POA TO CENTROID in.	.239	.375	.496
MIN RADIUS	.365	.496	.645
MEAN RADIUS	.965	.911	.834
MAX RADIUS	1.404	1.422	1.050
HORIZONTAL SPREAD	2.393	1.889	1.760
VERTICAL SPREAD	1.966	1.966	1.620
EXTREME SPREAD	2.521	2.411	1.872
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	10		

14 Nov 1989

FILE:/PATTERNING/CENTERFIRE_PATT/06945130

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 4

3 in = 9

HS= 2.201

VS= 2.639

GS= 2.687

CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.871	.724	.736
MINIMUM X	:	-1.330	-.896	-.884
MAXIMUM Y	:	1.192	1.269	1.098
MINIMUM Y	:	-1.447	-1.370	-1.213
CENTROID X	:	-.207	-.060	-.072
CENTROID Y	:	-.164	-.241	-.070
POA TO CENTROID in.	:	.264	.248	.100
MIN RADIUS	:	.486	.435	.321
MEAN RADIUS	:	1.051	.990	.915
MAX RADIUS	:	1.501	1.374	1.267
HORIZONTAL SPREAD	:	2.201	1.620	1.620
VERTICAL SPREAD	:	2.639	2.639	2.311
EXTREME SPREAD	:	2.687	2.686	2.425
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		9	

14 Nov 1988

FILE:/PATTERNING/CENTERFIRE_PATT/06845130

CENTERFIRE PATTERNS

4

POR

1in circle

2in circle

3in circle

CENTROID #

OF SHOTS = 10

IN CIR

1in = 0

2in = 4

3in = 10

HS = 2.318

VS = 2.489

GS = 2.531

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.998	.852	.798
MINIMUM X	:	-1.320	-.795	-.857
MAXIMUM Y	:	1.251	1.291	1.206
MINIMUM Y	:	-1.238	-1.198	-1.036
CENTROID X	:	.059	.205	.267
CENTROID Y	:	-.203	-.243	-.405
POR TO CENTROID in.	:	.211	.318	.485
MIN RADIUS	:	.607	.648	.577
MEAN RADIUS	:	1.016	.965	.881
MAX RADIUS	:	1.368	1.383	1.353
HORIZONTAL SPREAD	:	2.318	1.647	1.647
VERTICAL SPREAD	:	2.489	2.489	2.242
EXTREME SPREAD	:	2.531	2.531	2.301
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		10	

14 Nov 1988

FILE:/PATTERNING/CENTERFIRE_PATT/08349130

CENTERFIRE PATTERNS

5

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 1

2in = 7

3in = 10

HS= 2.053

VS= 1.871

GS= 2.703

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.198	1.029	.939
MINIMUM X	-.855	-.722	-.779
MAXIMUM Y	1.033	.953	1.029
MINIMUM Y	-.838	-.918	-.799
CENTROID X	.238	.105	.195
CENTROID Y	-.152	-.072	-.191
POA TO CENTROID in.	.283	.127	.273
MIN RADIUS	.379	.518	.369
MEAN RADIUS	.939	.884	.825
MAX RADIUS	1.401	1.195	1.125
HORIZONTAL SPREAD	2.053	1.751	1.718
VERTICAL SPREAD	1.871	1.871	1.828
EXTREME SPREAD	2.703	2.115	1.931
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	10		




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

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

MODEL 700™ H24

SERIAL NO.
C6349130

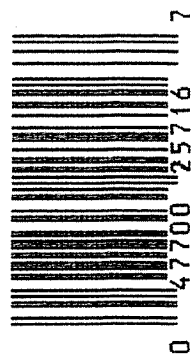
ORDER NO.
5716

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



5716 C6349130

UPC



0 47700 25716 7

Remington Test Lab, Ilion, N.Y.

Centroidal distance calculations for Rifle # c6349130
27 Feb 2001

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1332
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0056
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .133318

THE AMR FOR THIS RIFLE IS: 1.037

CENTROIDAL DISTANCES

0	TO	1	.511009
1	TO	2	.707684
1	TO	3	.529181
1	TO	4	.714906
1	TO	5	.790175

1
5 4⁻⁸ <----POA

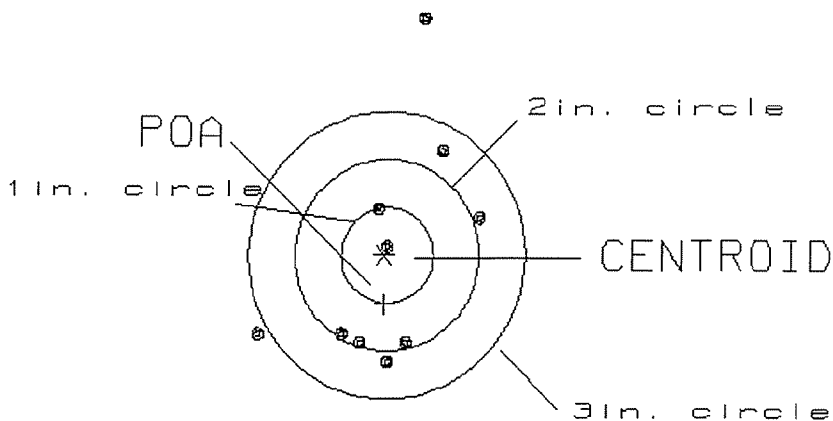
PATTERN #: ☐ 1 ☐

POA TO CENTROID: .511
 MIN RADIUS : .129
 MEAN RADIUS : 1.115
 MAX RADIUS : 2.539
 CENTROID X : -.003
 CENTROID Y : .511

27 Feb 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6349130

CENTERFIRE PATTERN # 1



OF SHOTS= 10

IN CIRCLE

HS= 2.42

2

VS= 3.61

5

GS= 3.77

8

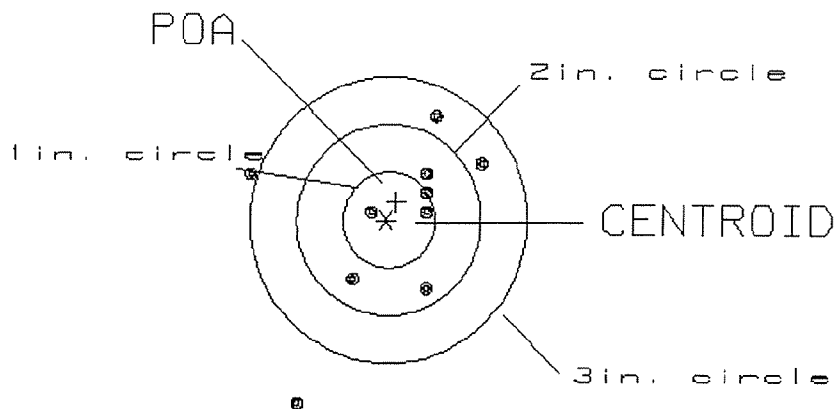
PATTERN #: ☐ 2 ☐

POA TO CENTROID: .217
 MIN RADIUS : .261
 MEAN RADIUS : .930
 MAX RADIUS : 2.122
 CENTROID X : -.107
 CENTROID Y : -.189

27 Feb 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6349130

CENTERFIRE PATTERN # 2



OF SHOTS= 10

IN CIRCLE

HS= 2.48
 VS= 3.00
 GS= 3.34

3
 6
 8

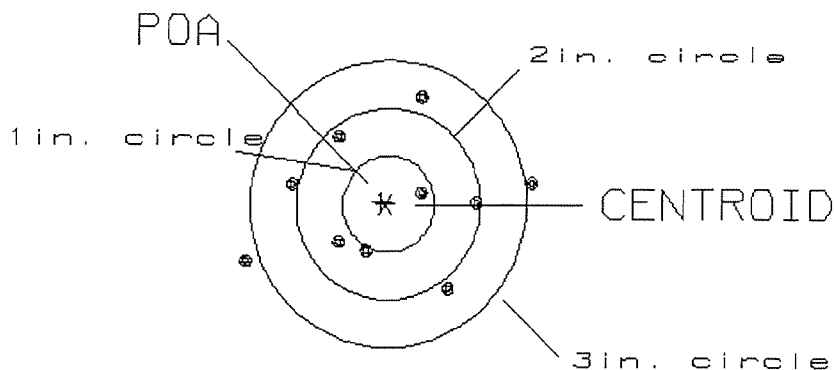
PATTERN #: 3

POA TO CENTROID: .048
 MIN RADIUS : .359
 MEAN RADIUS : .999
 MAX RADIUS : 1.619
 CENTROID X : .045
 CENTROID Y : -.016

27 Feb 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6349130

CENTERFIRE PATTERN # 3



OF SHOTS= 10

IN CIRCLE

HS= 3.03

1

VS= 2.09

5

GS= 3.14

8

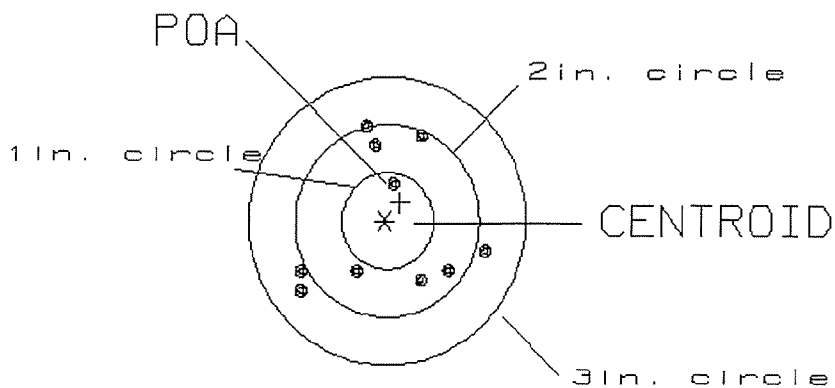
PATTERN #: ☐ 4 ☐

POA TO CENTROID: .247
 MIN RADIUS : .395
 MEAN RADIUS : .855
 MAX RADIUS : 1.164
 CENTROID X : -.162
 CENTROID Y : -.186

27 Feb 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6349130

CENTERFIRE PATTERN # 4



OF SHOTS= 10

IN CIRCLE

HS= 2.04
 VS= 1.69
 GS= 2.06

1
 6
 10

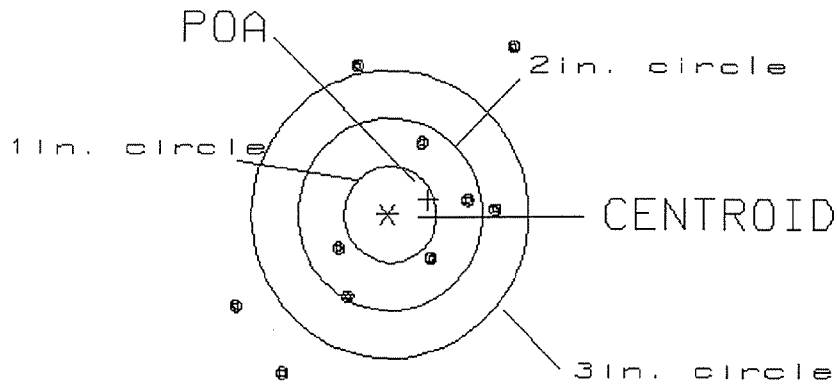
PATTERN #: ☐ 5 ☐

POA TO CENTROID: .464
 MIN RADIUS : .661
 MEAN RADIUS : 1.288
 MAX RADIUS : 2.227
 CENTROID X : -.439
 CENTROID Y : -.148

27 Feb 2001

FILE:/Hqbasic/Accuracy/Patterning/Centerfire_Patt/c6349130

CENTERFIRE PATTERN # 5



OF SHOTS= 10

IN CIRCLE

HS= 3.06
 VS= 3.36
 GS= 4.19

0
 5
 6

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

R & E NUMBER <i>21300</i>			
SERIAL NUMBER <i>C-6349130</i>			
LOG-IN DATE <i>1-22-01</i>			
INSPECT AND VERIFY:			
OPERATION #	OPERATION NAME	DATE	INITIAL
550	DIS-ASSEMBLE GUN	<i>1-27-01</i>	<i>CK</i>
560 A	RE-BARREL AT CUSTOM SHOP		
B	DRILL AND TAP		
C	POLISH		
575	ASSEMBLE		
600	PROOF	<i>1-30-01</i>	<i>CK</i>
605	CHECK HEADSPACE	<i>1-30-01</i>	<i>CK</i>
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	<i>2-7-01</i>	<i>CK</i>
655	FINAL INSPECT	<i>2-12-01</i>	<i>CK</i>
660	PACK		
		SHIP DATE	
		QAR INSPECTION DATE	

Final Inspection

S.N. C-6349130

DATE REC'D: 1-22-01

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: