

C6349148

MODEL 700TM M24

Model **5M5** TM

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: **RE00105641** Serial: C6349148 Model: M24 SWS Center Fire Caliber: 7.62 NATO Produced: 12/13/1999 Repairman: Status: Closed 12/22/2005 9:39:24 AM

Verify Repair

Address Information

Customer: Received From Return To Received From

Name: **JEFF ODELL** **JEFF ODELL**

Address 1: **BLDG M433A LEWIS AVE** **BLDG M433A LEWIS AVE**

Address 2: PO Box: PO Box:

City: **FORT DRUM** **FORT DRUM**

State: **NY** Zip Code: **13602** Country: **US** State: **NY** Zip Code: **13602** Country: **US**

FFL: ☐ ☐ ☐ ☐ ☐ ☐ ☐

Contact / Condition Problems Estimate History / Status Shipping / Billing

Contact Information

Phone: **315 774 3734**

Fax:

Email:

Comments: **REMFILE #004280**

Received Condition

Fair

Condition Notes:

CSR Notes:

Accessories Received

Code	Desc	Qty
A007	With Stud	3
A016	Scope Rings	2
A017	Scope Base	1
A028	Scope	1
A042	Adjustable Butt Pad	1

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

maglej 12/27/2005 1:04 PM CAPS NUM INS SCPL

start 2 Arms Services Repair & Estimate System

Serial Number: **C6349148**

Model: **M24 SWS**



RE00105641

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6349148.___0
FILE DATE AND TIME: 01/26/2006 12:59

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.091
The Average Y Centroid of the Five Target Set:	-0.063
The Average Point of Impact of the Five Target Set:	0.110
The Average Mean Radius of the Five Target Set:	0.792
The Distance from POA to Centroid Target #1:	0.140
The Distance from Centroid Target #2 to Centroid Target #1:	0.305
The Distance from Centroid Target #3 to Centroid Target #1:	0.286
The Distance from Centroid Target #4 to Centroid Target #1:	0.335
The Distance from Centroid Target #5 to Centroid Target #1:	0.083

SERIAL NUMBER: C6349148. __0

TARGET NUMBER: 1

FILE DATE: 01/26/2006

FILE TIME: 12:59

POINT#	X	Y
1:	0.864	-0.200
2:	0.492	-0.532
3:	0.370	-0.139
4:	-0.048	-0.518
5:	0.482	0.263
6:	-0.243	0.052
7:	-0.521	-0.120
8:	-0.814	0.016
9:	-1.279	-1.074
10:	0.015	1.034

X CENTROID: -0.068

Y CENTROID: -0.122

POA TO CENTROID: 0.140

HORZ SPREAD: 2.143

VERT SPREAD: 2.108

GROUP SPREAD: 2.473

MIN RADIUS: 0.246

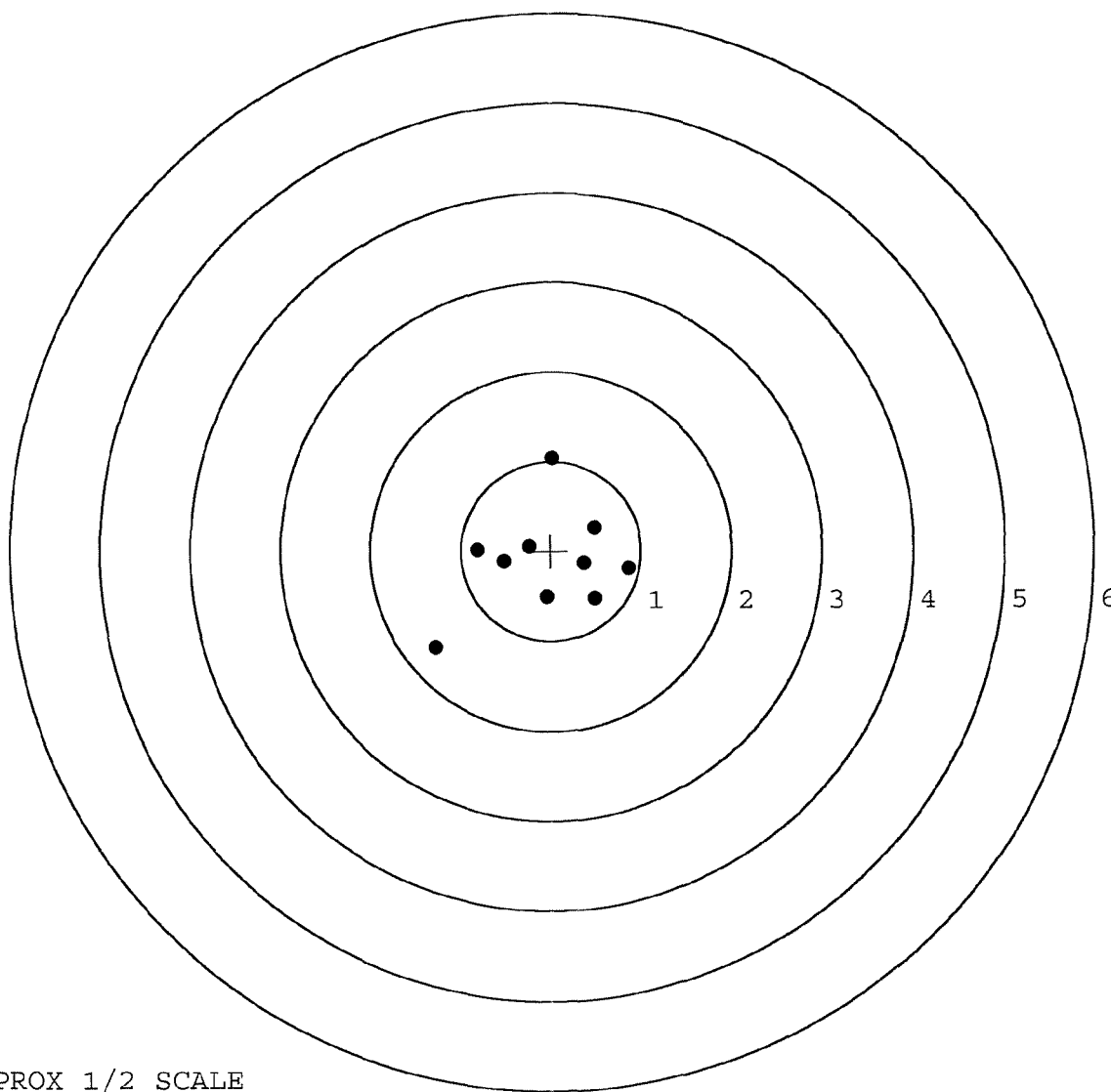
MAX RADIUS: 1.540

MEAN RADIUS: 0.729

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6349148. __0

TARGET NUMBER: 2

FILE DATE: 01/26/2006

FILE TIME: 12:59

X CENTROID: 0.237

Y CENTROID: -0.110

POA TO CENTROID: 0.261

HORZ SPREAD: 2.350

VERT SPREAD: 2.079

GROUP SPREAD: 2.783

MIN RADIUS: 0.417

MAX RADIUS: 1.627

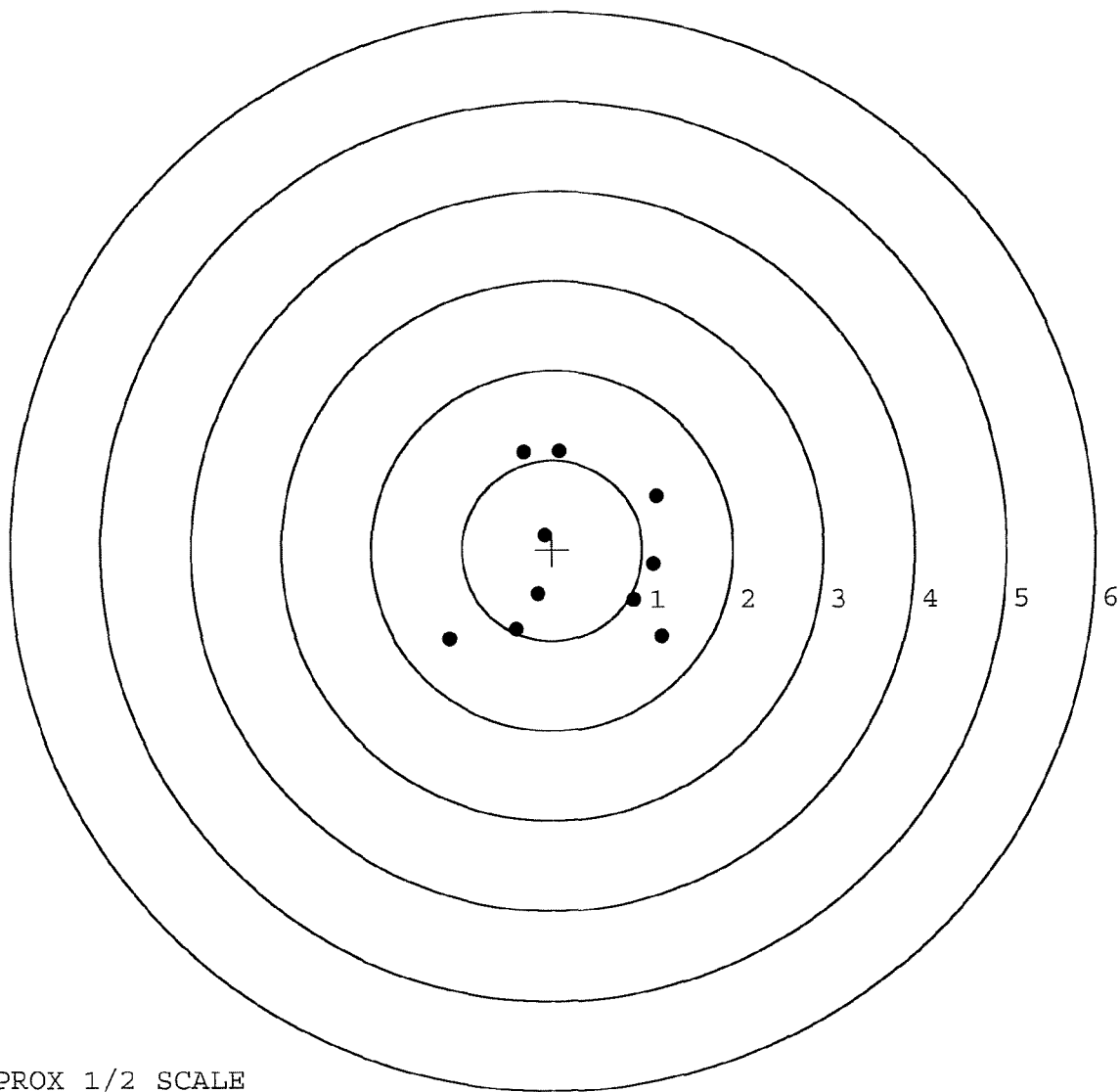
MEAN RADIUS: 1.029

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 4

in 3 IN DIAMETER: 9

POINT#	X	Y
1:	1.213	-0.963
2:	0.903	-0.559
3:	1.124	-0.170
4:	1.159	0.591
5:	-0.083	0.157
6:	-0.166	-0.491
7:	-0.410	-0.874
8:	-1.137	-0.982
9:	0.081	1.097
10:	-0.315	1.092

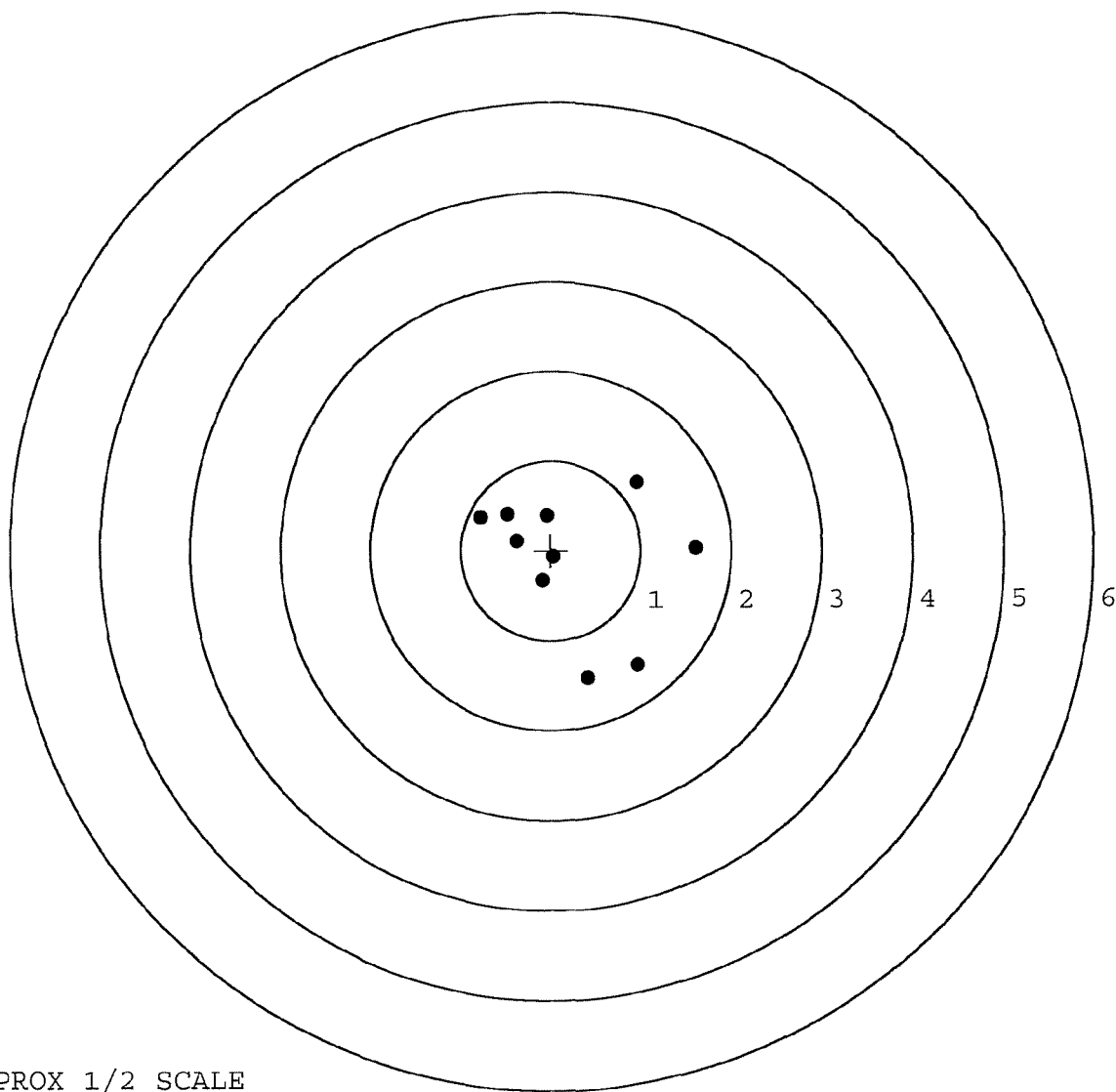


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6349148. __0
TARGET NUMBER: 3
FILE DATE: 01/26/2006
FILE TIME: 12:59

X CENTROID: 0.217
Y CENTROID: -0.103
POA TO CENTROID: 0.240
HORZ SPREAD: 2.393
VERT SPREAD: 2.170
GROUP SPREAD: 2.418
MIN RADIUS: 0.191
MAX RADIUS: 1.399
MEAN RADIUS: 0.901
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 5
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	1.610	0.026
2:	0.963	-1.275
3:	0.411	-1.416
4:	0.960	0.754
5:	-0.783	0.375
6:	-0.491	0.407
7:	-0.053	0.393
8:	-0.382	0.107
9:	0.029	-0.069
10:	-0.096	-0.334

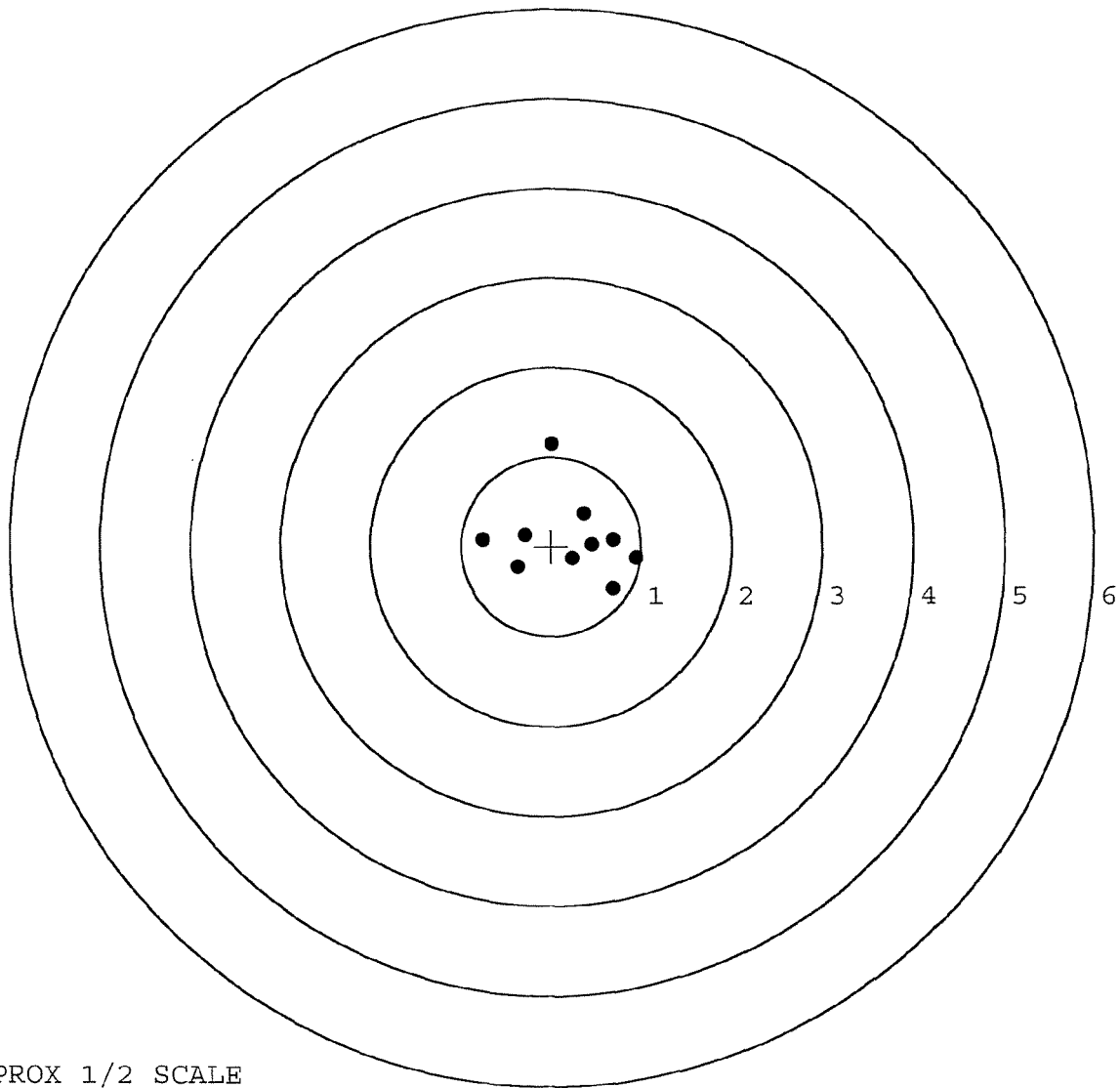


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6349148.___0
TARGET NUMBER: 4
FILE DATE: 01/26/2006
FILE TIME: 12:59

X CENTROID: 0.196
Y CENTROID: 0.085
POA TO CENTROID: 0.213
HORZ SPREAD: 1.699
VERT SPREAD: 1.621
GROUP SPREAD: 1.759
MIN RADIUS: 0.223
MAX RADIUS: 1.077
MEAN RADIUS: 0.601
IN 1 IN DIAMETER: 5
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.682	-0.477
2:	0.941	-0.131
3:	0.693	0.076
4:	0.239	-0.134
5:	0.364	0.367
6:	-0.287	0.130
7:	-0.376	-0.232
8:	-0.758	0.078
9:	0.000	1.144
10:	0.457	0.025

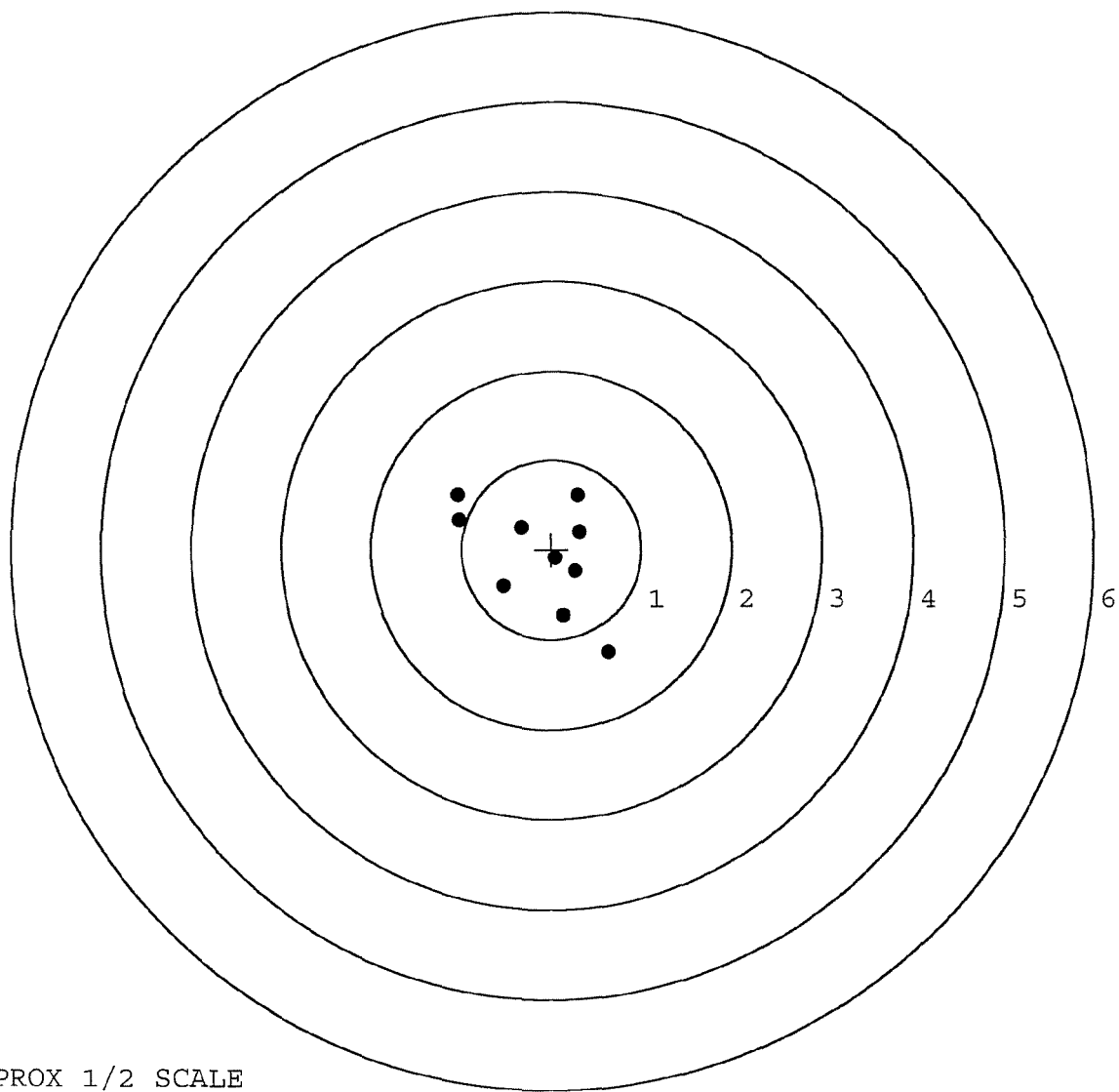


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6349148.___0
TARGET NUMBER: 5
FILE DATE: 01/26/2006
FILE TIME: 12:59

X CENTROID: -0.128
Y CENTROID: -0.064
POA TO CENTROID: 0.143
HORZ SPREAD: 1.680
VERT SPREAD: 1.751
GROUP SPREAD: 2.427
MIN RADIUS: 0.177
MAX RADIUS: 1.317
MEAN RADIUS: 0.698
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.634	-1.138
2:	0.139	-0.739
3:	-0.538	-0.408
4:	-0.344	0.245
5:	-1.029	0.333
6:	-1.046	0.613
7:	0.288	0.603
8:	0.311	0.197
9:	0.261	-0.246
10:	0.046	-0.097



TARGET APPROX 1/2 SCALE

M-24 INSPECTION CHECKLIST
CONTRACT #: DAAE-20-02-C-0149

R & E NUMBER	105641			
SERIAL NUMBER	06349148			
LOG-IN DATE	12-22-05			
OPERATION #	OPERATION NAME		DATE	INITIAL
500	DIS-ASSEMBLE GUN		12-28-05	RTZ
505	RE-BARREL		1-4-06	RTZ
560	ASSEMBLE		1-4-06	RTZ
600	PROOF	MAGNA-FLUX INSPECTED	1-4-06	AC
605	CHECK HEADSPACE	JAN 06 2006	1-4-06	AC
610	DIS-ASSEMBLE GUN		1-4-06	AC
612	MAGNAFLUX	OPERATOR <i>W. W. W.</i>	1/6/06	<i>W. W. W.</i>
510	DRILL AND TAP		1-5-06	TRW
615	ROLLMARK CALIBER		1-6-06	CW
618	ROTO-BLAST		1-6-06	LSB
620	APPLY COATINGS		1/23	HP
625	FINAL ASSEMBLY		1-26-06	RTZ
640	FUNCTION TEST AND	PASS FAIL	1-26-06	TRW
650	TARGET	PASS FAIL		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
670	FINAL INSPECTION		1-26-06	TRW
	A) HEADSPACE	PASS FAIL	1-26-06	RTZ
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	2.62 2.58 2.54 2.69 2.58	RTZ
680	F) SAFETY ON FORCE	2 LBS MIN 10 LBS	5.0 5.0 5.0	RTZ
	G) SAFETY OFF FORCE	2 LBS	3.0 3.0 3.0	RTZ
	I) FIRING PIN INDENT	.020		
690	PACK		1/26/06	1077

RECEIVING AND ESTIMATING REPORT

COMMENTS

ORDER

R 95-10944

INITIAL

CUSTOMER ORDER NO.

FJB

W/10X SCOPE SNIPER W/DEPLOYMENT KIT

ATTN:FRED MARTIN

Scope S/N 900981

DATE RECEIVED

DATE OPENED

DATE CODE

SERIAL NUMBER

NEW SERIAL NUMBER

MODEL AND GRADE

03/30/95

03/31/95

RJ 11-B9

C6349148

700 7.62

NATO

ACCESSORIES

SLING STRAP

SCOPE MNTS

SCOPE BASE

HARD CASE

SOFT CASE

FROM:

SHIP TO:

COMMANDER (W52H094138H226)
DEFENSE DIST DEPOT ANNISTON
ATTN DDAA-UR BLDG 112
ANNISTON AL 36201-5025

COMMANDER (W52H094138H226)
DEFENSE DIST DEPOT ANNISTON
ATTN DDAA-UR BLDG 112
ANNISTON AL 36201-5025

CUST NO:098397 C.O.D.L

ACCOUNT NUMBER

ACCOUNT NUMBER N/C

WRITE ☐

PROM. DATE

ESTIMATED

VIA

7-17-96

UPS

GUN CONDITION

- ☐ NEW
☐ LIGHTLY WORN
☐ WORN
☐ VERY WORN
☐ UNREPAIRABLE
☐ MARRED

REPAIR CHARGE

EXCISE

TAX

INSURANCE

UPS

PARCEL POST

TOTAL

CUSTOMER CONCERN

AMMO

FUNCTION

FINISH

ACCURACY

FIT

INSPECT

CYCLE

A1

B1

TRIGGER GROUP

B2

E1

F1

BOLT ASSY.

B3

E2

F2

BARREL ASSY.

B4

D1

E3

F3

REC. ASSY.

B5

D2

E4

F4

WOOD

C1

D3

E5

F5

METAL

C2

MAIN FAULT

PARTS

COMMENTS

✓ NEW BARREL
✓ STOCK
✓ TRIGGER ASSY
✓ FIRING PIN ASSY
✓ Front & Rear Sight Assy

REPAIRMAN

PROOF

CLEAN

TEST

TARGET

PATTERN

GALLERY TESTER

DATE

DATE

DATE

DATE

DATE

7/22/96

7/22/96

OFFICE COPY

RD6925 REV. 1/94

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

M2400108832

op. #	OP. NAME	READINGS			DATE	INIT
625 cont.	F) Safety On Force	6	6.5	6	7-17	REP
	G) Safety Off Force	5	4.5	4.5	7-17	REP
	H) Trigger Pull Test & Retainability					
	I) Firing Pin Indent	.023	.023	.0225	7-17	REP
	J) Assemble Stock				7-17	REP
	K) Assemble Swivel Studs					
	L) Attach Front and Rear Sight Assemblies					
	M) Iron Sight Alignment					
	N) Detach Front & Rear Sights & place in numbered container					
	O) Attach Scope to Rifle				7-17	REP
	P) Detach & Attach Scope 20 Times					
640	Gallery Target & Test					
	A) Time					
	B) Malfunctions					
	C) Pierced Primers					
	D) Optical Clarity of Scope					
645	Inspect for Live Ammo					
655	Final Inspection					
	A) Headspace					
	B) Trigger Pull	2.63	2.63	2.66	2.25	2.78
	C) Function				8/2	8F
660	Pack					

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

OP. #	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and Stock			
600	Proof			
607	Check Headspace			
610	Dis-assemble Gun			
612	Magnaflux Barrel Action			
	Magnaflux Bolt			
615	Rollmark Caliber			
617	Drill and Tap Sight Holes			
618	Polish Barrel			
620	Apply Coatings (Barrel Action)			
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		7-17	REP
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		7-17	REP
	C) Inspect Ejector Hole for Chamfer		7-17	REP
	D) Oil Firing Pin Ass'y		7-17	REP
	E) Adjust Trigger Pull to Min Setting and Stake			

SWS TRIGGER PULL TEST

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

SERIAL NO. C6349148
DATE 7-12-96
TESTER DA

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.70	2.61	2.64		MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.67	2.64	2.83		
PULL #3	2.82	2.55	2.95		
PULL #4	2.71	2.67	2.62		
PULL #5	2.67	2.45	2.70		
TOTAL	13.57	12.92	13.74		
AVG.	2.71	2.58	2.74		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.07	3.15		
PULL #2	3.14	3.12		
PULL #3	3.17	2.97		
PULL #4	3.16	3.18		
PULL #5	3.24	3.20		
TOTAL	15.78	15.62		
AVG.	3.15	3.12		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.09	4.05		4.04
PULL #2	4.06	4.36		4.21
PULL #3	4.15	4.10		4.30
PULL #4	4.33	4.39		4.22
PULL #5	4.38	4.17		4.34
TOTAL	21.01	21.07		21.41
AVG.	4.20	4.21		4.28

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6349148
12 Jan 1988

CENTROIDAL DISTANCES

0 TO	1	.920396
1 TO	2	1.4482
1 TO	3	.862627
1 TO	4	.951707
1 TO	5	.902442

1
5 ft 3" X ---- POA
2

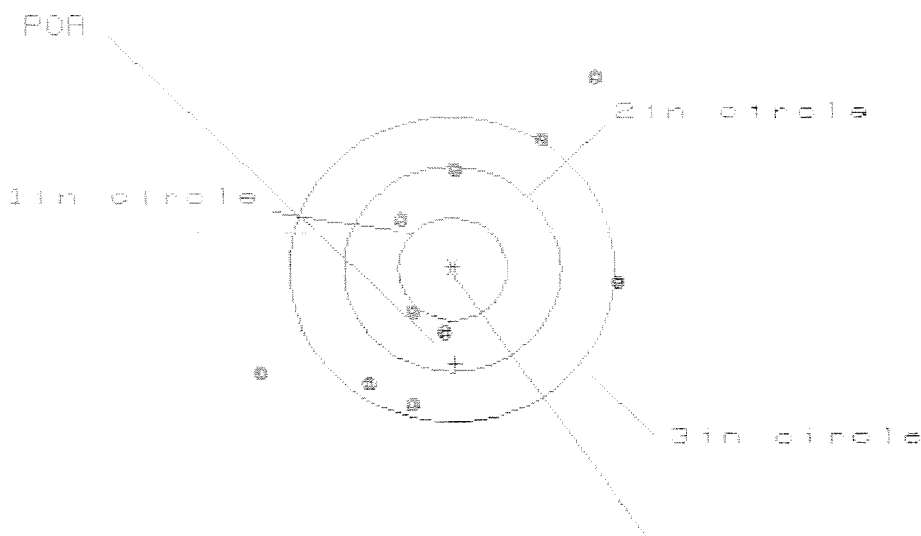
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.004
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1544
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .154452

THE AMR FOR THIS RIFLE IS: 1.156

10 Jan 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C6348148

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1in = 1

2in = 3

3in = 6

HS= 3.337

VS= 3.239

GS= 4.281

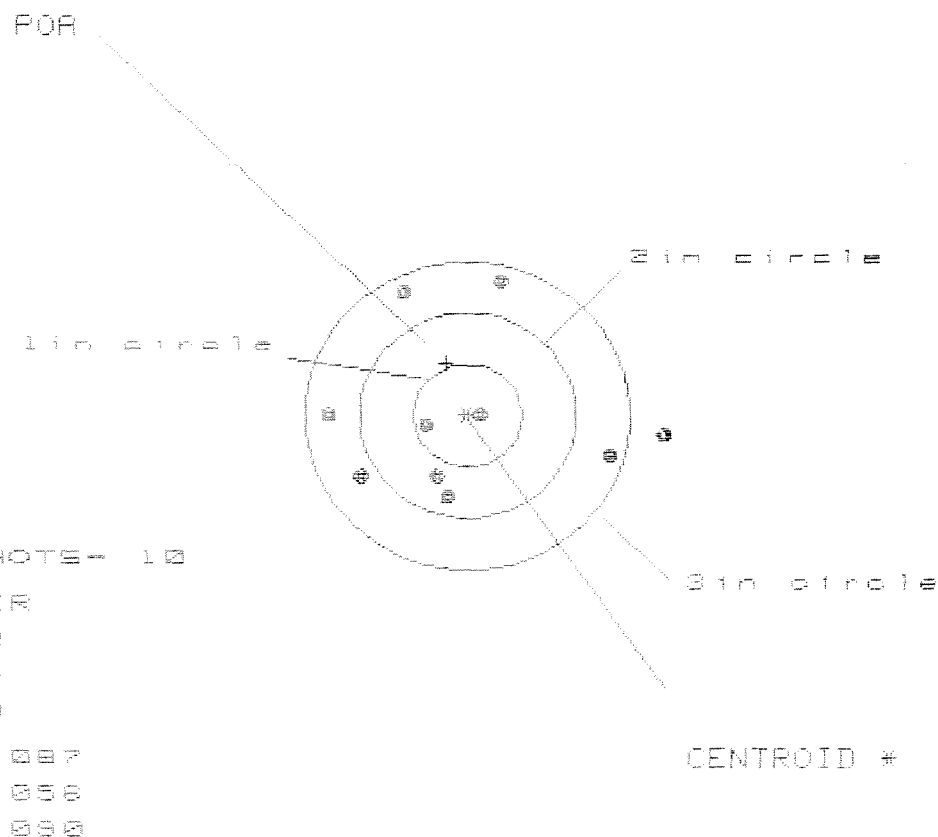
CENTROID *

PATTERN #	:	1	2	3
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.563	1.714	1.511
MINIMUM X	:	-1.774	-1.623	-1.856
MAXIMUM Y	:	1.874	1.467	1.362
MINIMUM Y	:	-1.365	-1.157	-1.262
CENTROID X	:	-.027	-.178	.025
CENTROID Y	:	.920	.712	.817
POA TO CENTROID in.	:	.921	.734	.817
MIN RADIUS	:	.570	.323	.491
MEAN RADIUS	:	1.313	1.152	1.091
MAX RADIUS	:	2.313	1.828	1.590
HORIZONTAL SPREAD	:	3.337	3.337	2.367
VERTICAL SPREAD	:	3.239	2.624	2.624
EXTREME SPREAD	:	4.281	3.511	2.929
NUMBER IN ONE INCH CIRCLE	=	0	3	6
NUMBER IN TWO INCH CIRCLE	=	0	3	6
NUMBER IN THREE INCH CIRCLE	=	0	3	6

18 Jan 1988

FILE:/PATTERNING/CENTERFIRE_PATT/08345148

CENTERFIRE PATTERNS # 2

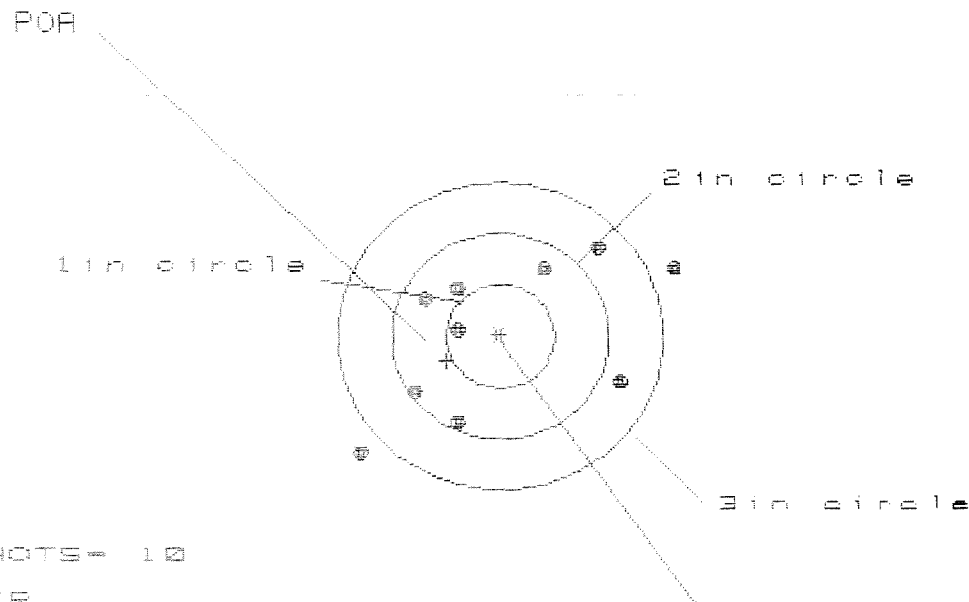


PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.819	1.559	.753
MINIMUM X	:	-1.268	-1.066	-.871
MAXIMUM Y	:	1.290	1.274	1.224
MINIMUM Y	:	-.766	-.782	-.832
CENTROID X	:	.189	-.013	-.208
CENTROID Y	:	-.512	-.496	-.446
POR TO CENTROID (in.)	:	.546	.496	.492
MIN RADIUS	:	.120	.164	.128
MEAN RADIUS	:	1.020	.960	.806
MAX RADIUS	:	1.825	1.610	1.437
HORIZONTAL SPREAD	:	3.087	2.625	1.624
VERTICAL SPREAD	:	2.056	2.056	2.056
EXTREME SPREAD	:	3.090	2.653	2.319
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		9	

18 Jan 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C8349148

CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 6

3 in = 8

HE = 2.887

VS = 2.013

GS = 3.428

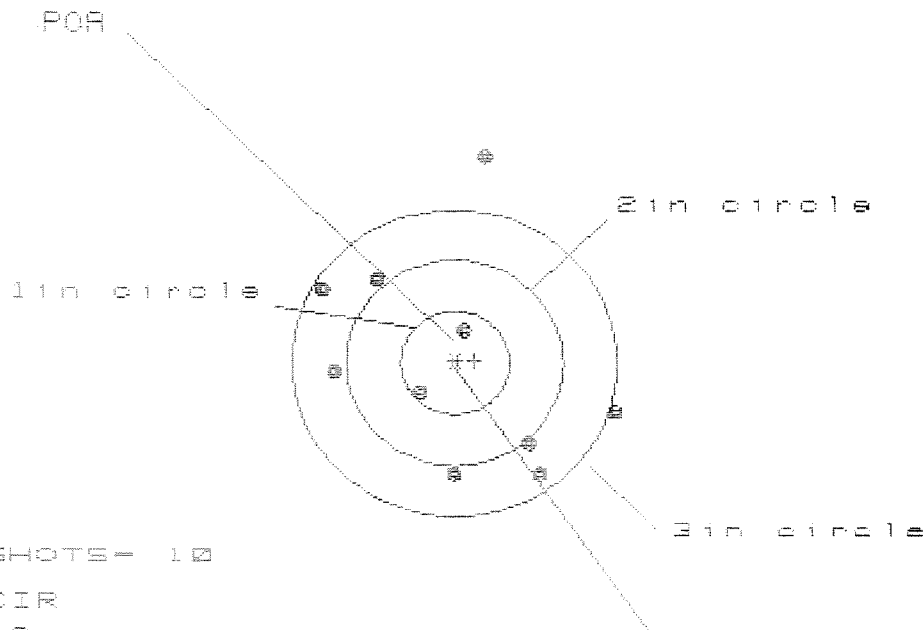
CENTROID #

PATTERN #	3	3	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.591	1.447	1.147
MINIMUM X	-1.296	-.934	-.753
MAXIMUM Y	.843	.713	.781
MINIMUM Y	-1.170	-.985	-.917
CENTROID X	.496	.640	.459
CENTROID Y	.234	.364	.296
POA TO CENTROID in.	.549	.737	.546
MIN RADIUS	.437	.552	.394
MEAN RADIUS	1.039	.961	.851
MAX RADIUS	1.746	1.547	1.259
HORIZONTAL SPREAD	2.887	2.381	1.900
VERTICAL SPREAD	2.013	1.698	1.698
EXTREME SPREAD	3.428	2.672	2.199
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		8	

18 Jan 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C8349148

CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1in = 2

2in = 2

3in = 6

HS= 2.693

VS= 3.145

GS= 3.156

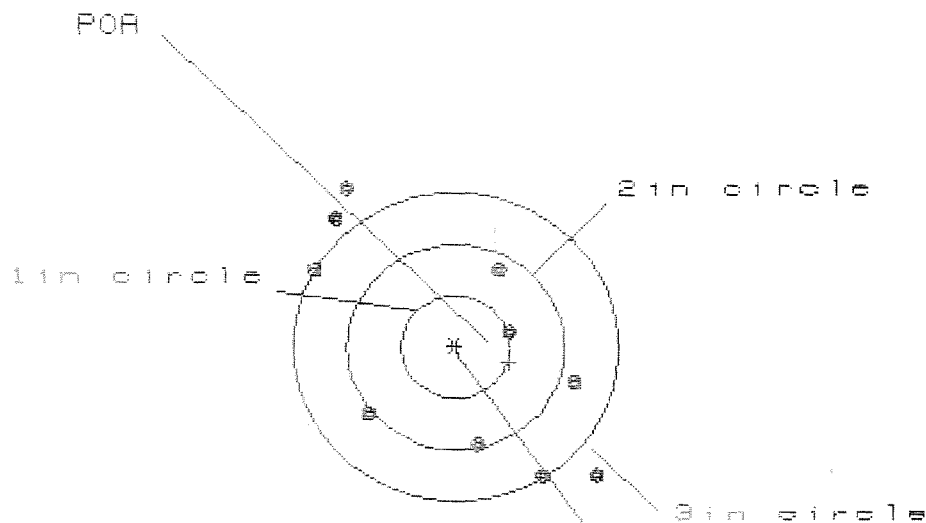
CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.510	1.539	1.045
MINIMUM X	:	-1.183	-1.154	-.961
MAXIMUM Y	:	2.043	1.052	1.015
MINIMUM Y	:	-1.102	-.875	-.912
CENTROID X	:	-.182	-.211	-.404
CENTROID Y	:	-.019	-.246	-.209
POA TO CENTROID in.	:	.183	.324	.455
MIN RADIUS	:	.282	.244	.099
MEAN RADIUS	:	1.139	1.012	.916
MAX RADIUS	:	2.061	1.568	1.361
HORIZONTAL SPREAD	:	2.693	2.693	2.006
VERTICAL SPREAD	:	3.145	1.927	1.927
EXTREME SPREAD	:	3.156	2.966	2.684
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		2	
NUMBER IN THREE INCH CIRCLE	=		8	

10 Jan 1900

FILE:/PATTERNING/CENTERFIRE_PATT/C0349148

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 1

2in = 3

3in = 6

CENTROID #

HS= 2.595

VS= 2.758

GS= 3.550

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.258	1.145	1.083
MINIMUM X	-1.337	-1.450	-1.307
MAXIMUM Y	1.519	1.452	1.323
MINIMUM Y	-1.239	-1.070	-1.199
CENTROID X	-.496	-.383	-.526
CENTROID Y	.149	-.020	.109
POA TO CENTROID in.	.518	.383	.537
MIN RADIUS	.488	.475	.529
MEAN RADIUS	1.270	1.178	1.144
MAX RADIUS	1.833	1.877	1.687
HORIZONTAL SPREAD	2.595	2.595	2.390
VERTICAL SPREAD	2.758	2.522	2.522
EXTREME SPREAD	3.550	3.408	3.132
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		3	
NUMBER IN THREE INCH CIRCLE =		6	

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6349148

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		89	RW
612	Magnaflux Barrel Action	REJECTED	11/2/89	KCR
	Magnaflux Bolt		11/2/89	KCR
615	Rollmark Caliber			
7	Drill and Tap Sight Holes			
618	Polish Barrel			
620	Apply Coatings (Barrel Action)			
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly			
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head			
	C) Inspect Ejector Hole for Chamfer			
	D) Oil Firing Pin Ass'y			
	E) Adjust Trigger Pull to Min Setting and Stake			

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

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6349148

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	11-8	89	RW
600	Proof	11-8	89	RW
607	Check Headspace	11-8	89	RW
610	Dis-assemble Gun	11-8	89	RW
612	Magnaflux Barrel Action	11-9-89		KCR
	Magnaflux Bolt	11-9-89		KCR
615	Rollmark Caliber			
617	Drill and Tap Sight Holes	11 9	89	FB
618	Polish Barrel <i>RLB</i>	11 9	89	BT
620	Apply Coatings (Barrel Action)		11-17-89	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		11/27/89	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		11/27/89	RW
	C) Inspect Ejector Hole for Chamfer		11/27/89	RW
	D) Oil Firing Pin Ass'y		11/27/89	RW
	E) Adjust Trigger Pull to Min Setting and Stake		4 Dec 89	JSS

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			4 Dec 89	JSS
	G) Safety Off Force	3	3	3			4 Dec 89	JSS
	H) Trigger Pull Test & Retainability						4 Dec 89	JSS
	I) Firing Pin Indent	1021	022	0215			4 Dec 89	JSS
	J) Assemble Stock						12/5/89	RW
	K) Assemble Swivel Studs						7 Dec 89	JSS
	L) Attach Front and Rear Sight Assemblies						12/5/89	RW
	M) Iron Sight Alignment						12/5/89	RW
	N) Detach Front & Rear Sights & place in numbered container						12/5/89	RW
	O) Attach Scope to Rifle						5 Dec 89	JSS
	P) Detach & Attach Scope 20 Times						5 Dec 89	JSS
640	Gallery Target & Test						12-5-89	A
	A) Time						12-6-89	A
	B) Malfunctions						12-6-89	A
	C) Pierced Primers						12-6-89	A
	D) Optical Clarity of Scope						12-6-89	AC
645	Inspect for Live Ammo						12-6-89	A
655	Final Inspection							
	A) Headspace						7 Dec 89	JSS
	B) Trigger Pull	268	260	248	252	259	7 Dec 89	JSS
	C) Function						7 Dec 89	JSS
660	Pack						18 Dec 89	JSS

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#
3.00# ± .75#
4.00# ± 1.00#

SERIAL NO. 06359148

DATE 3-14-90

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#	COMMENTS
PULL #1	2.35	2.31	2.24	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.39	2.33	2.44	
PULL #3	2.34	2.23	2.47	
PULL #4	2.27	2.23	2.48	
PULL #5	2.41	2.39	2.48	
TOTAL	11.76	11.49	12.11	
AVG.	2.352	2.298	2.422	

	3.00# INITIAL	3.00# AFTER 20 CYCLES	COMMENTS
PULL #1	3.37	3.43	
PULL #2	3.48	3.43	
PULL #3	3.44	3.39	
PULL #4	3.44	3.39	
PULL #5	3.46	3.25	
TOTAL	17.19	16.89	
AVG.	3.438	3.378	

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.39	4.31		
PULL #2	4.31	4.28		
PULL #3	4.18	4.20		
PULL #4	4.29	4.16		
PULL #5	4.31	4.22		
TOTAL	21.48	21.17		
AVG.	4.296	4.234		

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6349148
2 Dec 1989

CENTROIDAL DISTANCES

G TO	1	.214842
1 TO	2	.378727
1 TO	3	.120934
1 TO	4	.736577
1 TO	5	.21285

4 (----POB

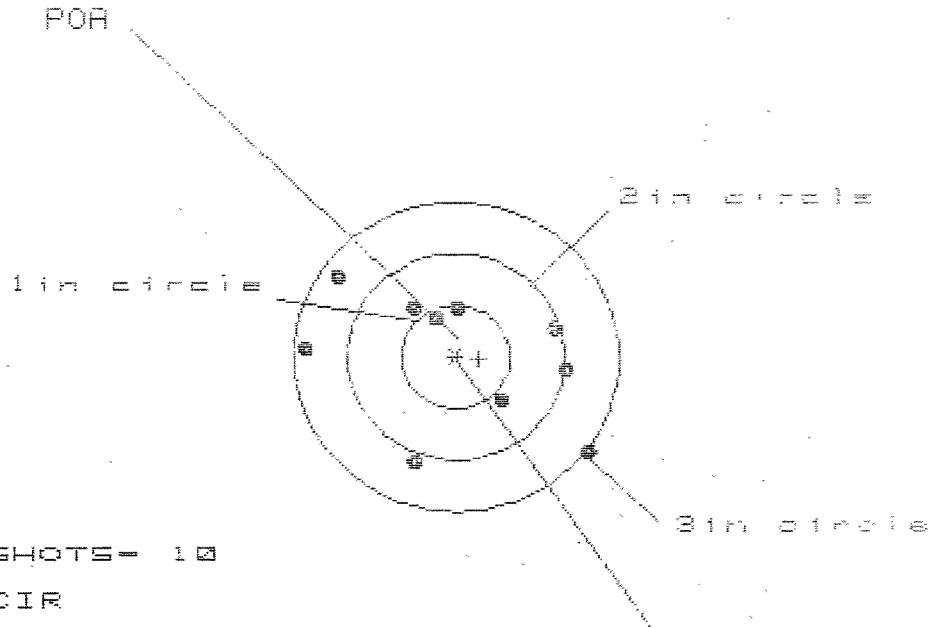
4

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0346
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1764
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .179781
THE AMR FOR THIS RIFLE IS: .9984

8 Dec 1989

FILE:/PATTERNING/CENTERFIRE_PATT/06349348

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 5

3 in = 10

HS= 2.588

VS= 1.751

GS= 2.851

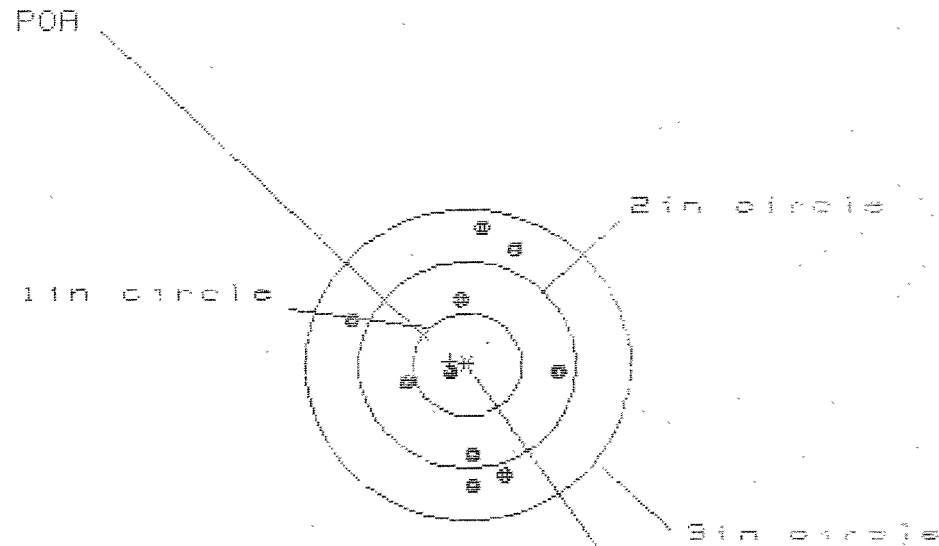
CENTROID *

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.191	1.148	.999
MINIMUM X	:	-1.397	-1.264	-1.148
MAXIMUM Y	:	.762	.662	.664
MINIMUM Y	:	-.989	-1.089	-1.087
CENTROID X	:	-.214	-.347	-.189
CENTROID Y	:	.019	.119	.117
POA TO CENTROID in.	:	.215	.367	.222
MIN RADIUS	:	.436	.287	.355
MEAN RADIUS	:	.948	.866	.696
MAX RADIUS	:	1.495	1.264	1.327
HORIZONTAL SPREAD	:	2.588	2.412	2.138
VERTICAL SPREAD	:	1.751	1.751	1.751
EXTREME SPREAD	:	2.851	2.426	2.320
NUMBER IN ONE INCH CIRCLE =			2	
NUMBER IN TWO INCH CIRCLE =			5	
NUMBER IN THREE INCH CIRCLE =			10	

5 Dec 1989

FILE:/PATTERNING/CENTERFIRE_PATT/06349148

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 10

HS= 1.931

VS= 2.506

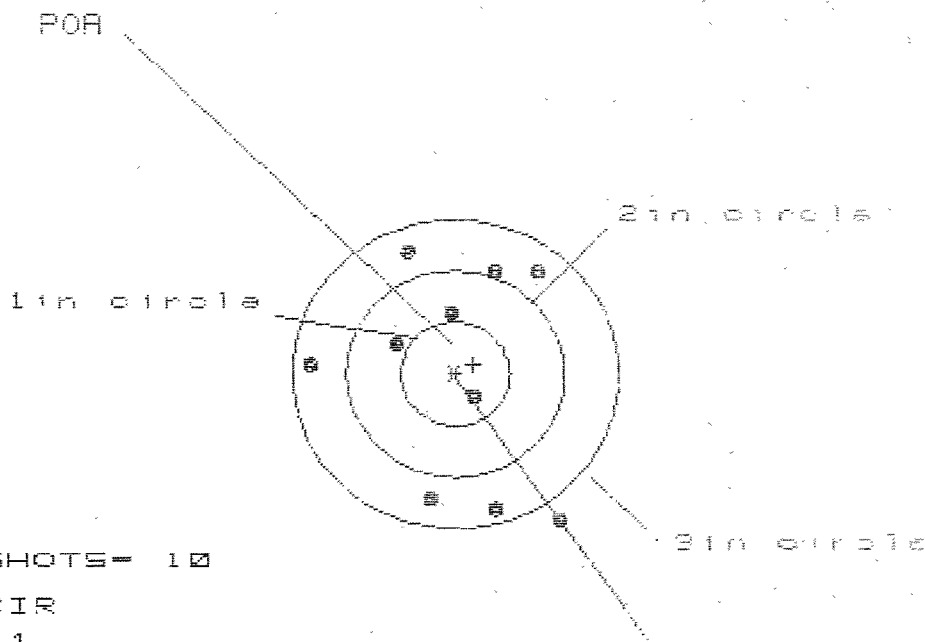
GS= 2.509

PATTERN #	2	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.829	.850	.908
MINIMUM X	-1.102	-1.081	-1.023
MAXIMUM Y	1.364	1.246	.927
MINIMUM Y	-1.142	-.990	-.834
CENTROID X	.161	.140	.082
CENTROID Y	-.034	-.196	-.342
POA TO CENTROID in.	.164	.233	.351
MIN RADIUS	.193	.145	.213
MEAN RADIUS	.914	.843	.767
MAX RADIUS	1.376	1.331	1.244
HORIZONTAL SPREAD	1.931	1.931	1.931
VERTICAL SPREAD	2.506	2.236	1.762
EXTREME SPREAD	2.509	2.270	2.045
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	10		

8 Dec 1989

FILE:/PATTERNING/CENTERFIRE_PATT/CS349143

CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 3

3 in = 6

HS = 2.313

VS = 2.611

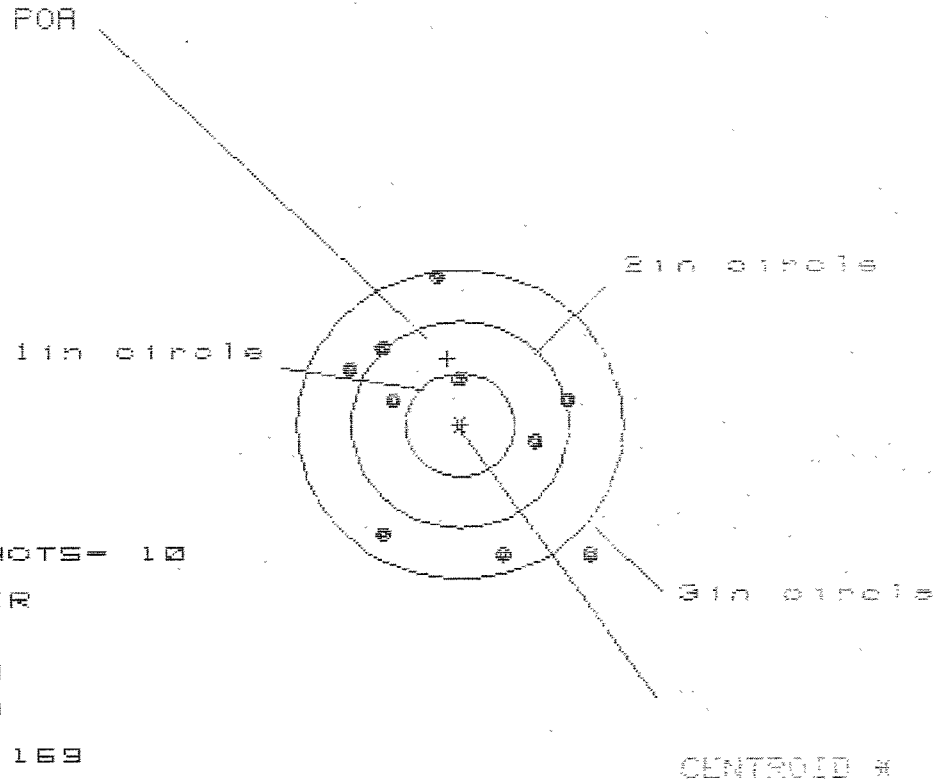
CS = 2.953

PATTERN #	:	3
SHOTS (BEST OF)	:	10
MAXIMUM X	:	.936
MINIMUM X	:	-1.377
MAXIMUM Y	:	1.157
MINIMUM Y	:	-1.454
CENTROID X	:	-0.166
CENTROID Y	:	-0.092
POA TO CENTROID in.	:	.190
MIN RADIUS	:	.252
MEAN RADIUS	:	1.070
MAX RADIUS	:	1.729
HORIZONTAL SPREAD	:	2.313
VERTICAL SPREAD	:	2.611
EXTREME SPREAD	:	2.953
NUMBER IN ONE INCH CIRCLE =	:	1
NUMBER IN TWO INCH CIRCLE =	:	3
NUMBER IN THREE INCH CIRCLE =	:	6

5 Dec 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C834B148

CENTERFIRE PATTERNS # 4



OF SHOTS- 10
 # IN CIR
 1 in - 1
 2 in - 3
 3 in - 9
 HS- 2.169
 VS- 2.707
 GS- 3.008

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.201	1.114	1.104
MINIMUM X	:	-.968	-.835	-.846
MAXIMUM Y	:	1.428	1.292	1.297
MINIMUM Y	:	-1.279	-1.415	-1.254
CENTROID X	:	.111	-.022	-.012
CENTROID Y	:	-.642	-.506	-.667
POA TO CENTROID in.	:	.652	.506	.667
MIN RADIUS	:	.413	.285	.441
MEAN RADIUS	:	1.074	.967	.941
MAX RADIUS	:	1.715	1.517	1.364
HORIZONTAL SPREAD	:	2.169	1.949	1.949
VERTICAL SPREAD	:	2.707	2.707	2.051
EXTREME SPREAD	:	3.008	2.760	2.353
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		9	

8 Dec 1989

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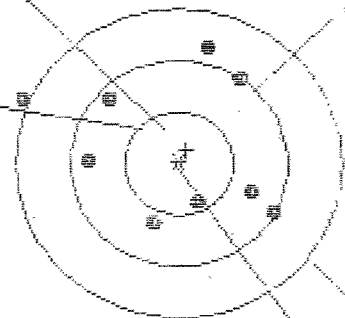
CENTERFIRE PATTERNS #. 5

POA

1in circle

2in circle

3in circle



OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 8

HS= 2.355

VS= 2.699

GS= 2.956

CENTROID #

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	.984
MINIMUM X	-1.451
MAXIMUM Y	1.894
MINIMUM Y	-1.605
CENTROID X	-.065
CENTROID Y	-.133
POA TO CENTROID in.	.148
MIN RADIUS	.380
MEAN RADIUS	.971
MAX RADIUS	1.682
HORIZONTAL SPREAD	2.355
VERTICAL SPREAD	2.699
EXTREME SPREAD	2.956
NUMBER IN ONE INCH CIRCLE =	1
NUMBER IN TWO INCH CIRCLE =	5
NUMBER IN THREE INCH CIRCLE =	8

Remington



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

MODEL 700TM H24

SERIAL NO.
C6349148

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