

06458777

MODEL 700™ M24

Model **SWS**™

Action

Barrel Length

Capacity

Order No. **5715**

\* Includes 1 in chamber.

*Remington.*

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6498777

| OP. #        | OP. NAME                                                       | READINGS | DATE    | INIT |
|--------------|----------------------------------------------------------------|----------|---------|------|
| 575 &<br>580 | Assemble Action<br>and Stock                                   | 6 29     | 90      | RW   |
| 600          | Proof                                                          | 6 29     | 90      | RW   |
| 607          | Check Headspace                                                | 6 29     | 90      | RW   |
| 610          | Dis-assemble Gun                                               | 6 29     | 90      | RW   |
| 612          | Magnaflux Barrel<br>Action                                     |          | 7-12-90 | KR   |
|              | Magnaflux Bolt                                                 |          | 7-12-90 | KR   |
| 615          | Rollmark Caliber                                               |          | 7-12-90 | G.S. |
| 617          | Drill and Tap Sight Holes                                      |          | 7/19/90 | LB   |
| 618          | Polish Barrel                                                  |          | 7/16/90 | WB   |
| 620          | Apply Coatings<br>(Barrel Action)                              |          | 7-23-90 | TJA  |
|              | Apply Coating (Bolt)                                           |          |         |      |
| 625          | Final Assembly<br>A) Clean inside of<br>Bolt Assembly          |          | 7/25/90 | RW   |
|              | B) Inspect Rear Firing<br>Pin Hole for Chamfer<br>in Bolt Head |          | 7/25/90 | RW   |
|              | C) Inspect Ejector Hole<br>for Chamfer                         |          | 7/25/90 | RW   |
|              | D) Oil Firing Pin Ass'y                                        |          | 7/25/90 | RW   |
|              | E) Adjust Trigger Pull to<br>Min Setting and Stake             |          | 8/17/90 | GL   |

| op. #        | OP. NAME                                                    | READINGS |       |       |      |      | DATE    | INIT |
|--------------|-------------------------------------------------------------|----------|-------|-------|------|------|---------|------|
| 625<br>cont. | F) Safety On Force                                          | 4        | 5     | 4     |      |      | 8/9/90  | RL   |
|              | G) Safety Off Force                                         | 3        | 3     | 3     |      |      | 8/9/90  | RL   |
|              | H) Trigger Pull Test & Retainability                        |          |       |       |      |      | 8/17/90 | RL   |
|              | I) Firing Pin Indent                                        | .0225    | .0225 | .0225 |      |      | 8/19/90 | RL   |
|              | J) Assemble Stock                                           |          |       |       |      |      | 8/20/90 | RW   |
|              | K) Assemble Swivel Studs                                    |          |       |       |      |      | 8/24/90 | QJ   |
|              | L) Attach Front and Rear Sight Assemblies                   |          |       |       |      |      | 8/20/90 | RW   |
|              | M) Iron Sight Alignment                                     |          |       |       |      |      | 8/20/90 | RW   |
|              | N) Detach Front & Rear Sights & place in numbered container |          |       |       |      |      | 8/20/90 | RW   |
|              | O) Attach Scope to Rifle                                    |          |       |       |      |      | 8/20/90 | RW   |
|              | P) Detach & Attach Scope 20 Times                           |          |       |       |      |      | 8/20/90 | RW   |
| 640          | Gallery Target & Test                                       |          |       |       |      |      | 8-20-90 | AF   |
|              | A) Time                                                     |          |       |       |      |      | 8-20-90 | AF   |
|              | B) Malfunctions                                             |          |       |       |      |      | 8-20-90 | AF   |
|              | C) Pierced Primers                                          |          |       |       |      |      | 8-20-90 | AF   |
|              | D) Optical Clarity of Scope                                 |          |       |       |      |      | 8-20-90 | AF   |
| 645          | Inspect for Live Ammo                                       |          |       |       |      |      | 8-20-90 | AF   |
| 655          | Final Inspection                                            |          |       |       |      |      |         |      |
|              | A) Headspace                                                |          |       |       |      |      | 8/29/90 | QJ   |
|              | B) Trigger Pull                                             | 2.15     | 2.13  | 2.14  | 2.15 | 2.18 | 8/29/90 | QJ   |
|              | C) Function                                                 |          |       |       |      |      | 8/29/90 | QJ   |
| 660          | Pack                                                        |          |       |       |      |      | 9/20/90 | AF   |

AVERAGE PULL FORCE BETWEEN  
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. CL498777

DATE 8/17/90

TESTER JH

|         | 2.50#<br>INITIAL | 2.50# AFTER<br>50 CYCLES | FINAL TEST &<br>TO RESET 2.50# |       | COMMENTS                                                               |
|---------|------------------|--------------------------|--------------------------------|-------|------------------------------------------------------------------------|
| PULL #1 | 2.42             | 2.35                     | 2.30                           | 2.15  | MIN. SETTING,<br>NO AVG. OF 5<br>READINGS ACCEPT-<br>ABLE LESS THAN 2# |
| PULL #2 | 2.49             | 2.36                     | 2.43                           | 2.13  |                                                                        |
| PULL #3 | 2.35             | 2.45                     | 2.35                           | 2.14  |                                                                        |
| PULL #4 | 2.37             | 2.41                     | 2.40                           | 2.15  |                                                                        |
| PULL #5 | 2.35             | 2.40                     | 2.42                           | 2.18  |                                                                        |
| TOTAL   | 11.98            | 11.97                    | 11.90                          | 10.75 |                                                                        |
| AVG.    | 2.396            | 2.394                    | 2.38                           | 2.15  |                                                                        |

|         | 3.00#<br>INITIAL | 3.00# AFTER<br>20 CYCLES |  | COMMENTS |
|---------|------------------|--------------------------|--|----------|
| PULL #1 | 3.21             | 3.47                     |  |          |
| PULL #2 | 3.21             | 3.44                     |  |          |
| PULL #3 | 3.14             | 3.40                     |  |          |
| PULL #4 | 3.20             | 3.46                     |  |          |
| PULL #5 | 3.30             | 3.46                     |  |          |
| TOTAL   | 16.06            | 17.23                    |  |          |
| AVG.    | 3.212            | 3.446                    |  |          |

|         | 4.00#<br>INITIAL | 4.00# AFTER<br>20 CYCLES | MAX SETTING<br>GREATER THAN 4# | RESET TO 4# FOR<br>TARGET & ACCURACY |
|---------|------------------|--------------------------|--------------------------------|--------------------------------------|
| PULL #1 | 4.31             | 4.30                     |                                | 4.16                                 |
| PULL #2 | 4.29             | 4.34                     |                                | 4.40                                 |
| PULL #3 | 4.26             | 4.29                     |                                | 4.15                                 |
| PULL #4 | 4.34             | 4.35                     |                                | 4.20                                 |
| PULL #5 | 4.29             | 4.37                     |                                | 4.40                                 |
| TOTAL   | 21.49            | 21.65                    |                                | 21.31                                |
| AVG.    | 4.298            | 4.33                     |                                | 4.262                                |

CENTROIDAL DISTANCE CALCULATIONS  
FOR RIFLE # C6498777  
21 Aug 1990

CENTROIDAL DISTANCES

|   |    |   |         |
|---|----|---|---------|
| 0 | TO | 1 | .253503 |
| 1 | TO | 2 | .308172 |
| 1 | TO | 3 | .167084 |
| 1 | TO | 4 | .478323 |
| 1 | TO | 5 | .150659 |

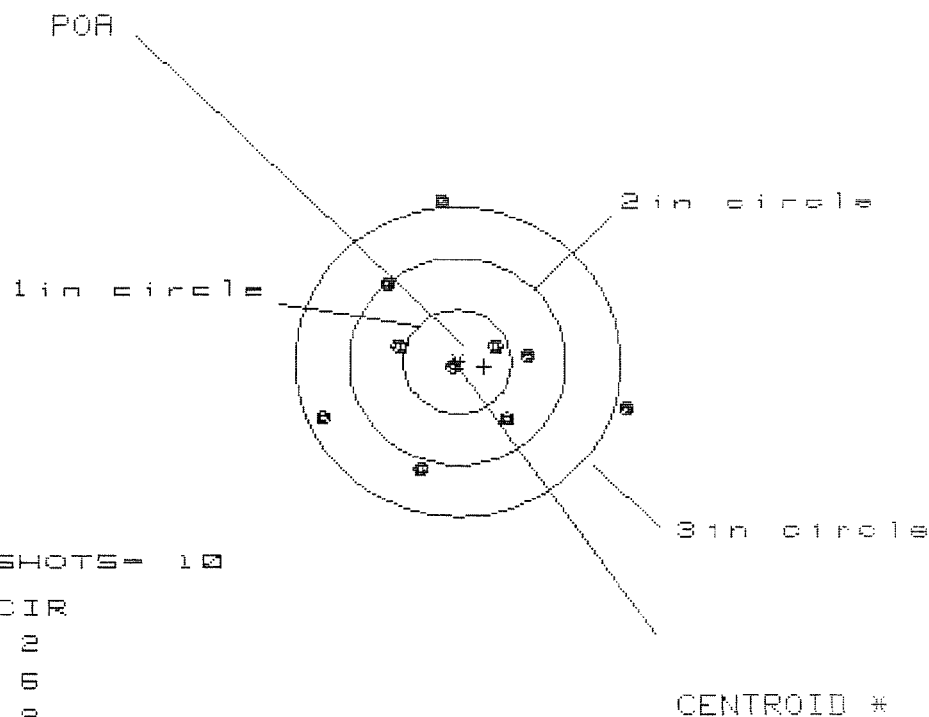
52  
34 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1202  
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .011  
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .120702  
  
THE AMR FOR THIS RIFLE IS: .878

20 Aug 1990

FILE:/PATTERNING/CENTERFIRE\_PATT/CS498777

## CENTERFIRE PATTERNS # 1



# OF SHOTS- 10

# IN CIR

1 in = 2

2 in = 6

3 in = 8

HS= 2.831

VS= 2.627

GS= 2.833

| PATTERN #                   | : | 1      |        |        |
|-----------------------------|---|--------|--------|--------|
| SHOTS (BEST OF)             | : | 10     | 9      | 8      |
| MAXIMUM X                   | : | 1.576  | .823   | .827   |
| MINIMUM X                   | : | -1.255 | -1.080 | -1.076 |
| MAXIMUM Y                   | : | 1.544  | 1.497  | .890   |
| MINIMUM Y                   | : | -1.083 | -1.130 | -.943  |
| CENTROID X                  | : | -.250  | -.425  | -.428  |
| CENTROID Y                  | : | .042   | .089   | -.098  |
| POA TO CENTROID in.         | : | .254   | .435   | .440   |
| MIN RADIUS                  | : | .077   | .127   | .155   |
| MEAN RADIUS                 | : | .907   | .829   | .743   |
| MAX RADIUS                  | : | 1.632  | 1.497  | 1.149  |
| HORIZONTAL SPREAD           | : | 2.831  | 1.903  | 1.903  |
| VERTICAL SPREAD             | : | 2.627  | 2.627  | 1.833  |
| EXTREME SPREAD              | : | 2.833  | 2.635  | 1.988  |
| NUMBER IN ONE INCH CIRCLE   | = |        | 2      |        |
| NUMBER IN TWO INCH CIRCLE   | = |        | 6      |        |
| NUMBER IN THREE INCH CIRCLE | = |        | 8      |        |

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## CENTERFIRE PATTERNS # 2

POA

1in circle

2in circle

3in circle

# OF SHOTS- 10

# IN CIR

1in = 2

2in = 8

3in = 8

HS= 2.399

VS= 2.099

GS= 2.679

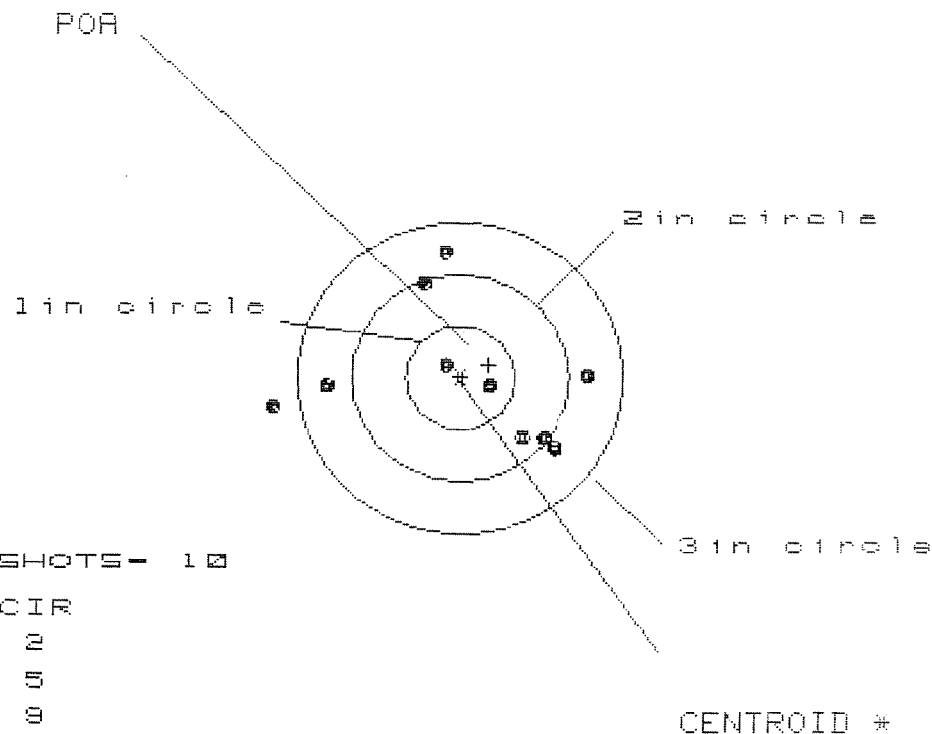
CENTROID #

| PATTERN #                   | : | 2     |       |       |
|-----------------------------|---|-------|-------|-------|
| SHOTS (BEST OF)             | : | 10    | 9     | 8     |
| MAXIMUM X                   | : | 1.669 | .615  | .624  |
| MINIMUM X                   | : | -.729 | -.544 | -.535 |
| MAXIMUM Y                   | : | 1.496 | 1.440 | .742  |
| MINIMUM Y                   | : | -.603 | -.659 | -.479 |
| CENTROID X                  | : | .039  | -.147 | -.156 |
| CENTROID Y                  | : | .149  | .205  | .025  |
| POA TO CENTROID in.         | : | .154  | .252  | .158  |
| MIN RADIUS                  | : | .230  | .082  | .199  |
| MEAN RADIUS                 | : | .760  | .622  | .496  |
| MAX RADIUS                  | : | 1.743 | 1.442 | .747  |
| HORIZONTAL SPREAD           | : | 2.399 | 1.159 | 1.159 |
| VERTICAL SPREAD             | : | 2.099 | 2.099 | 1.221 |
| EXTREME SPREAD              | : | 2.679 | 2.112 | 1.285 |
| NUMBER IN ONE INCH CIRCLE   | = |       | 2     |       |
| NUMBER IN TWO INCH CIRCLE   | = |       | 8     |       |
| NUMBER IN THREE INCH CIRCLE | = |       | 8     |       |

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## CENTERFIRE PATTERNS # 3



# OF SHOTS- 10

# IN CIR

1 in = 2

2 in = 5

3 in = 9

HS= 2.897

VS= 1.838

GS= 2.913

| PATTERN #                   | : | 3      |        |       |
|-----------------------------|---|--------|--------|-------|
| SHOTS (BEST OF)             | : | 10     | 9      | 8     |
| MAXIMUM X                   | : | 1.180  | .989   | .811  |
| MINIMUM X                   | : | -1.717 | -1.429 | -.659 |
| MAXIMUM Y                   | : | 1.205  | 1.174  | 1.157 |
| MINIMUM Y                   | : | -.633  | -.664  | -.681 |
| CENTROID X                  | : | -.269  | -.078  | .100  |
| CENTROID Y                  | : | -.124  | -.093  | -.076 |
| POA TO CENTROID in.         | : | .296   | .122   | .126  |
| MIN RADIUS                  | : | .200   | .094   | .156  |
| MEAN RADIUS                 | : | .966   | .851   | .771  |
| MAX RADIUS                  | : | 1.740  | 1.435  | 1.276 |
| HORIZONTAL SPREAD           | : | 2.897  | 2.418  | 1.470 |
| VERTICAL SPREAD             | : | 1.838  | 1.838  | 1.838 |
| EXTREME SPREAD              | : | 2.913  | 2.422  | 2.131 |
| NUMBER IN ONE INCH CIRCLE   | = |        | 2      |       |
| NUMBER IN TWO INCH CIRCLE   | = |        | 5      |       |
| NUMBER IN THREE INCH CIRCLE | = |        | 9      |       |

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## CENTERFIRE PATTERNS

# 4

POA

1 in circle

2 in circle

3 in circle

CENTROID \*

# OF SHOTS- 10

# IN CIR

1 in = 1

2 in = 7

3 in = 9

HS= 2.542

VS= 1.356

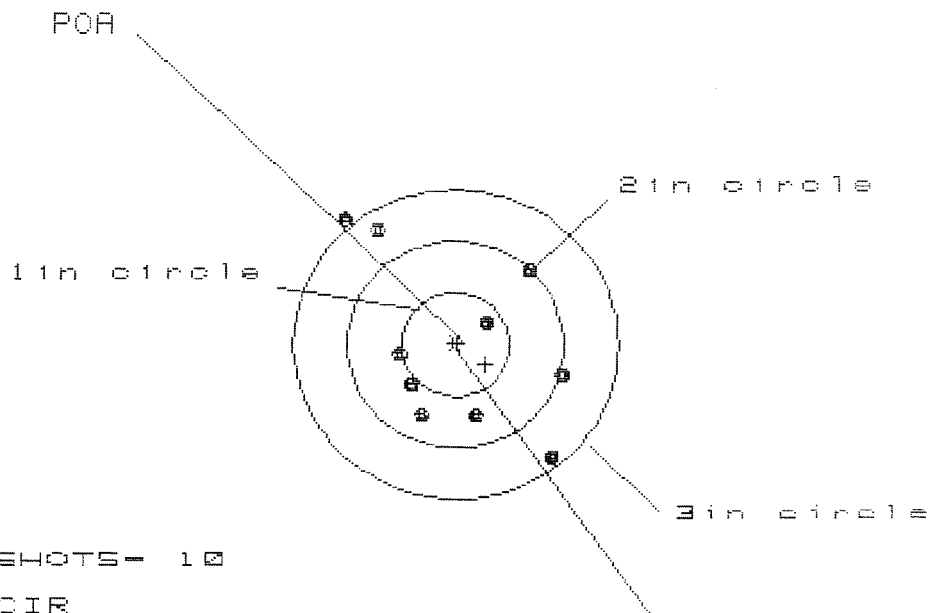
GS= 2.766

| PATTERN #                   | : | 4      |        |       |
|-----------------------------|---|--------|--------|-------|
| SHOTS (BEST OF)             | : | 10     | 9      | 8     |
| MAXIMUM X                   | : | 1.369  | 1.061  | .933  |
| MINIMUM X                   | : | -1.172 | -1.020 | -.721 |
| MAXIMUM Y                   | : | .683   | .609   | .652  |
| MINIMUM Y                   | : | -.672  | -.727  | -.684 |
| CENTROID X                  | : | .162   | .009   | .137  |
| CENTROID Y                  | : | -.201  | -.126  | -.169 |
| POA TO CENTROID in.         | : | .257   | .126   | .217  |
| MIN RADIUS                  | : | .462   | .375   | .454  |
| MEAN RADIUS                 | : | .840   | .733   | .699  |
| MAX RADIUS                  | : | 1.526  | 1.172  | 1.039 |
| HORIZONTAL SPREAD           | : | 2.542  | 2.081  | 1.654 |
| VERTICAL SPREAD             | : | 1.356  | 1.336  | 1.336 |
| EXTREME SPREAD              | : | 2.766  | 2.245  | 1.849 |
| NUMBER IN ONE INCH CIRCLE   | = |        | 1      |       |
| NUMBER IN TWO INCH CIRCLE   | = |        | 7      |       |
| NUMBER IN THREE INCH CIRCLE | = |        | 9      |       |

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## CENTERFIRE PATTERNS # 5



# OF SHOTS- 10

# IN CIR

1 in = 1

2 in = 6

3 in = 9

HS= 1.971

VS= 2.358

GS= 3.023

CENTROID \*

| PATTERN #                   | : | 5      |       |       |
|-----------------------------|---|--------|-------|-------|
| SHOTS (BEST OF)             | : | 10     | 9     | 8     |
| MAXIMUM X                   | : | .959   | .846  | .942  |
| MINIMUM X                   | : | -1.012 | -.811 | -.715 |
| MAXIMUM Y                   | : | 1.227  | 1.215 | 1.091 |
| MINIMUM Y                   | : | -1.131 | -.995 | -.635 |
| CENTROID X                  | : | -.283  | -.170 | -.266 |
| CENTROID Y                  | : | .189   | .053  | .177  |
| POA TO CENTROID in.         | : | .340   | .178  | .320  |
| MIN RADIUS                  | : | .373   | .386  | .365  |
| MEAN RADIUS                 | : | .917   | .823  | .767  |
| MAX RADIUS                  | : | 1.590  | 1.461 | 1.304 |
| HORIZONTAL SPREAD           | : | 1.971  | 1.657 | 1.657 |
| VERTICAL SPREAD             | : | 2.358  | 2.210 | 1.726 |
| EXTREME SPREAD              | : | 3.023  | 2.716 | 2.148 |
| NUMBER IN ONE INCH CIRCLE   | = | 1      |       |       |
| NUMBER IN TWO INCH CIRCLE   | = | 6      |       |       |
| NUMBER IN THREE INCH CIRCLE | = | 9      |       |       |

**Remington**<sup>®</sup>

**MODEL 700<sup>TM</sup> 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.

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**C6498777**

ORDER NO.  
**5716**

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