

C6498801

MODEL 700™ M24

Model SWS™

Action

Barrel Length

Capacity

Order No. 5716

*Includes 1 in chamber.



M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6498801

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action 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 Action		7-12-90	KR
	Magnaflux Bolt		7-12-90	KR
615	Rollmark Caliber		7-12-90	L.S.
617	Drill and Tap Sight Holes		7/13/90	FB
618	Polish Barrel RB		7/16/90	WB
620	Apply Coatings (Barrel Action)		7-23-90	HA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		7/25/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		7/25/90	RW
	C) Inspect Ejector Hole for Chamfer		7/25/90	RW
	D) Oil Firing Pin Ass'y		7/25/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		9-11-90	GH

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			8/9/90	JK
	G) Safety Off Force	3	3	3			8/9/90	JK
	H) Trigger Pull Test & Retainability						9-11-90	JK
	I) Firing Pin Indent	.022	.022	.022			8/9/90	JK
	J) Assemble Stock						8/13/90	RW
	K) Assemble Swivel Studs						9/12/90	JK
	L) Attach Front and Rear Sight Assemblies						8/13/90	RW
	M) Iron Sight Alignment						8/13/90	RW
	N) Detach Front & Rear Sights & place in numbered container						8/13/90	RW
	O) Attach Scope to Rifle						8/13/90	RW
	P) Detach & Attach Scope 20 Times						8/13/90	RW
640	Gallery Target & Test						8/13/90	NF
	A) Time						8/13/90	NF
	B) Malfunctions						8/13/90	NF
	C) Pierced Primers						8/13/90	NF
	D) Optical Clarity of Scope						8/13/90	NF
645	Inspect for Live Ammo						8/13/90	NF
655	Final Inspection							
	A) Headspace						9/12/90	JK
	B) Trigger Pull	2.36	2.33	2.39	2.38	2.34	9-11-90	JK
	C) Function						9/12/90	JK
660	Pack						9/19/90	NF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6498801

DATE 9-11-90

TESTER JPL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.21	2.33	2.37	2.36	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.17	2.26	2.35	2.33	
PULL #3	2.34	2.32	2.35	2.39	
PULL #4	2.29	2.35	2.36	2.38	
PULL #5	2.32	2.32	2.23	2.34	
TOTAL	11.33	11.58	11.66	11.80	
AVG.	2.266	2.316	2.332	2.36	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.26	3.24		
PULL #2	3.11	3.24		
PULL #3	3.22	3.26		
PULL #4	3.22	3.24		
PULL #5	3.24	3.24		
TOTAL	16.05	16.22		
AVG.	3.21	3.244		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.18	4.46		4.21
PULL #2	4.17	4.26		4.23
PULL #3	4.19	4.27		4.23
PULL #4	4.45	4.22		4.22
PULL #5	4.43	4.20		4.27
TOTAL	21.42	21.41		21.16
AVG.	4.284	4.282		4.232

CENTROIDAL DISTANCE CALCULATIONS
 FOR RIFLE # C6498801
 14 Aug 1990

CENTROIDAL DISTANCES

0 TO	1	.122984
1 TO	2	.601739
1 TO	3	.732085
1 TO	4	.159248
1 TO	5	.249281

4ts <----FOR
 2 3

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0096
 THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.3406
 THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .340735

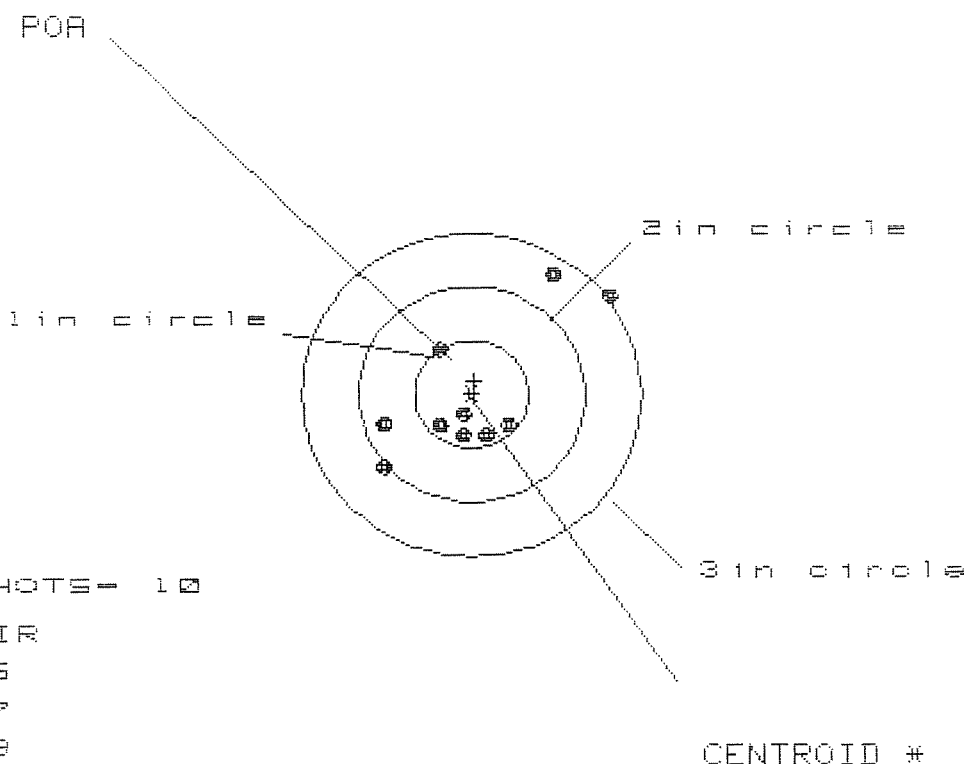
THE AMR FOR THIS RIFLE IS: .8066

13 Aug 1998

FILE:/PATTERNING/CENTERFIRE_PATT/08498801

CENTERFIRE PATTERNS

1



OF SHOTS= 10

IN CIR

1 in = 5

2 in = 7

3 in = 9

HS= 2.041

VS= 1.842

GS= 2.598

PATTERN #	:	1	2	3
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.241	.877	.602
MINIMUM X	:	-.800	-.662	-.553
MAXIMUM Y	:	1.136	1.236	.698
MINIMUM Y	:	-.706	-.606	-.452
CENTROID X	:	-.022	-.160	-.269
CENTROID Y	:	-.121	-.221	-.375
POA TO CENTROID in.	:	.123	.272	.462
MIN RADIUS	:	.175	.051	.099
MEAN RADIUS	:	.723	.579	.430
MAX RADIUS	:	1.533	1.515	.714
HORIZONTAL SPREAD	:	2.041	1.539	1.155
VERTICAL SPREAD	:	1.842	1.842	1.150
EXTREME SPREAD	:	2.598	2.400	1.253
NUMBER IN ONE INCH CIRCLE	=	5		
NUMBER IN TWO INCH CIRCLE	=	7		
NUMBER IN THREE INCH CIRCLE	=	9		

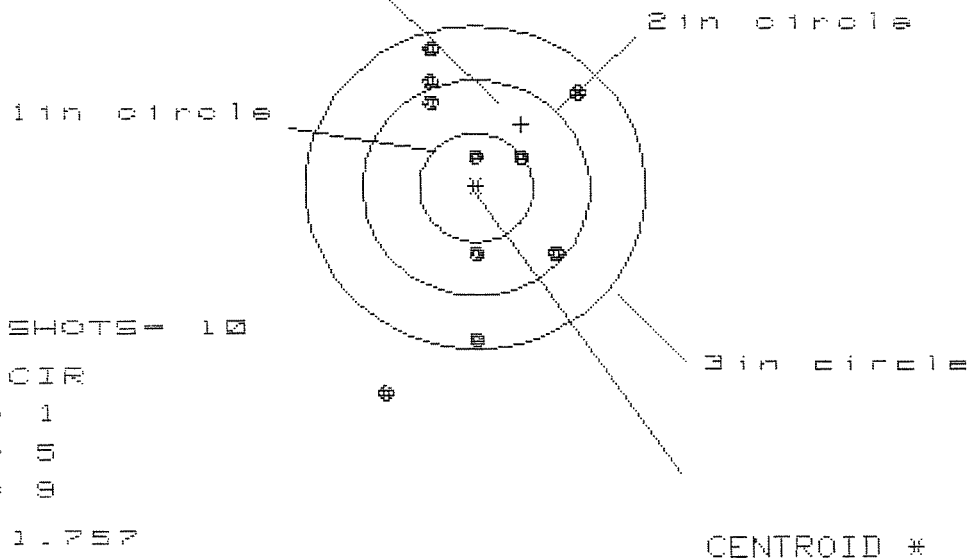
13 Aug 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6498881

CENTERFIRE PATTERNS

2

POA



OF SHOTS= 10

IN CIR

1in = 1

2in = 5

3in = 9

HS= 1.757

VS= 3.229

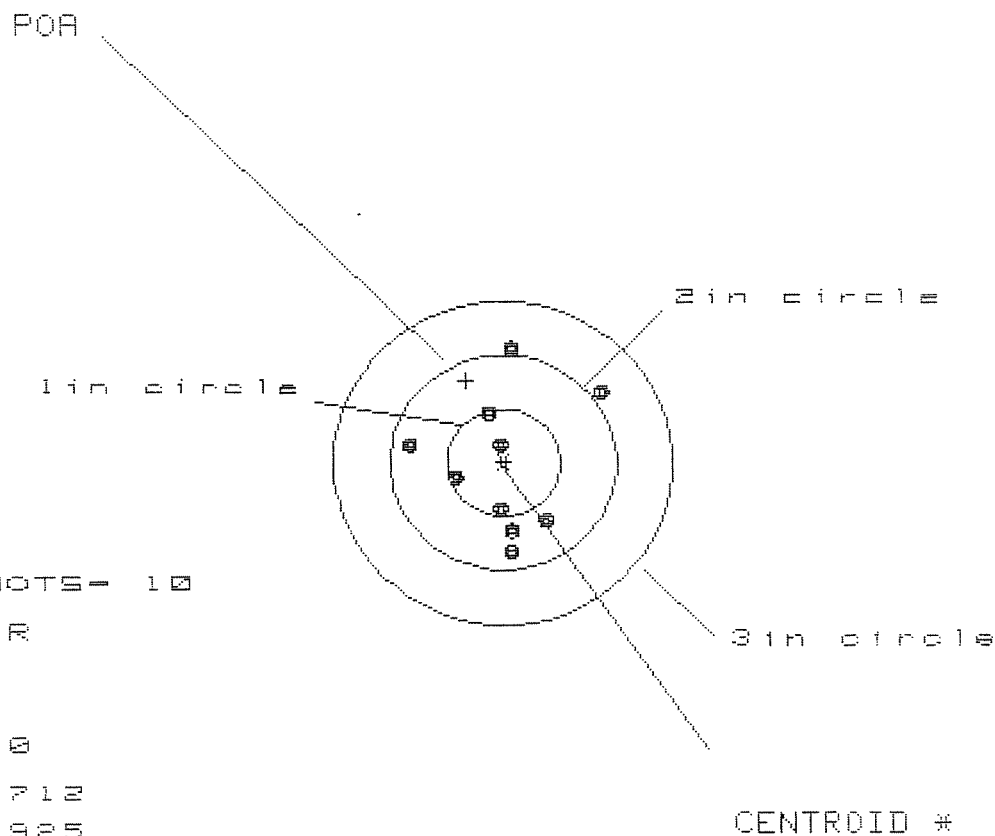
GS= 3.340

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.907	.813	.806
MINIMUM X	:	-.850	-.539	-.546
MAXIMUM Y	:	1.303	1.089	.880
MINIMUM Y	:	-1.926	-1.672	-1.019
CENTROID X	:	-.399	-.305	-.298
CENTROID Y	:	-.590	-.376	-.167
POA TO CENTROID in.	:	.713	.484	.342
MIN RADIUS	:	.329	.142	.129
MEAN RADIUS	:	1.056	.887	.762
MAX RADIUS	:	2.105	1.673	1.205
HORIZONTAL SPREAD	:	1.757	1.352	1.352
VERTICAL SPREAD	:	3.229	2.761	1.899
EXTREME SPREAD	:	3.340	2.803	2.241
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

13 Aug 1990

FILE:/PATTERNING/CENTERFIRE_PATT/06498301

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 4

2 in = 8

3 in = 10

HS= 1.712

VS= 1.925

GS= 1.925

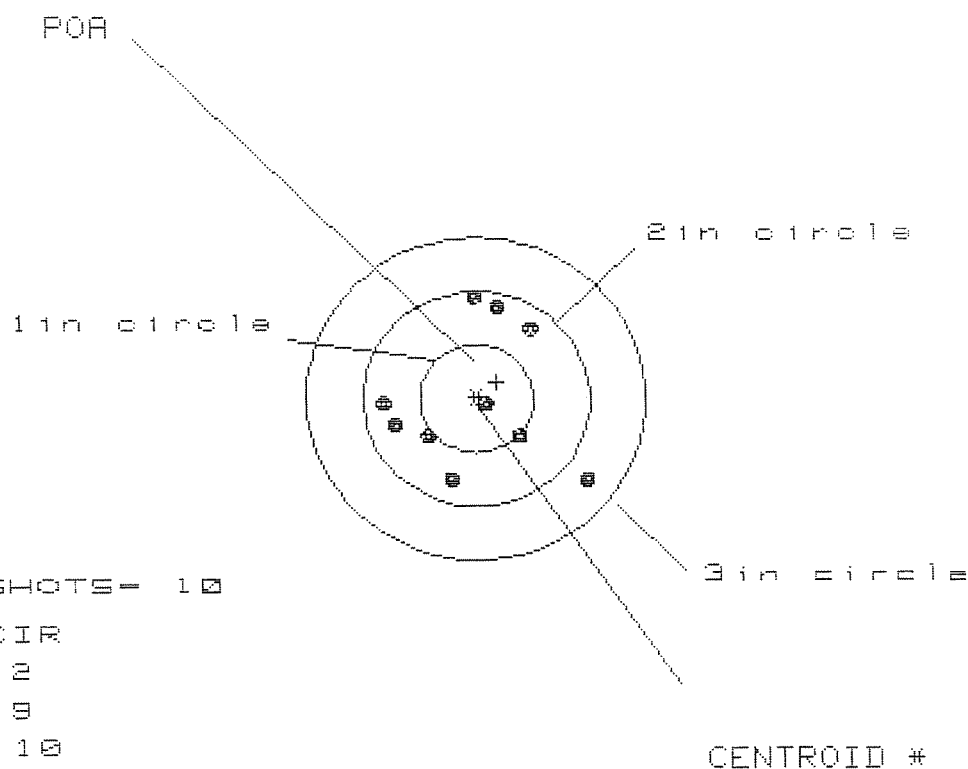
PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.899	.444	.465
MINIMUM X	:	-.813	-.713	-.692
MAXIMUM Y	:	1.095	1.169	.696
MINIMUM Y	:	-.830	-.756	-.610
CENTROID X	:	.328	.228	.207
CENTROID Y	:	-.764	-.838	-.984
POA TO CENTROID in.	:	.832	.868	1.005
MIN RADIUS	:	.164	.250	.270
MEAN RADIUS	:	.673	.609	.517
MAX RADIUS	:	1.116	1.181	.809
HORIZONTAL SPREAD	:	1.712	1.157	1.157
VERTICAL SPREAD	:	1.925	1.925	1.306
EXTREME SPREAD	:	1.925	1.925	1.358
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	

13 Aug 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6498801

CENTERFIRE PATTERNS

4



OF SHOTS = 10

IN CIR

1in = 2

2in = 9

3in = 10

HS = 1.848

VS = 1.763

GS = 1.981

CENTROID #

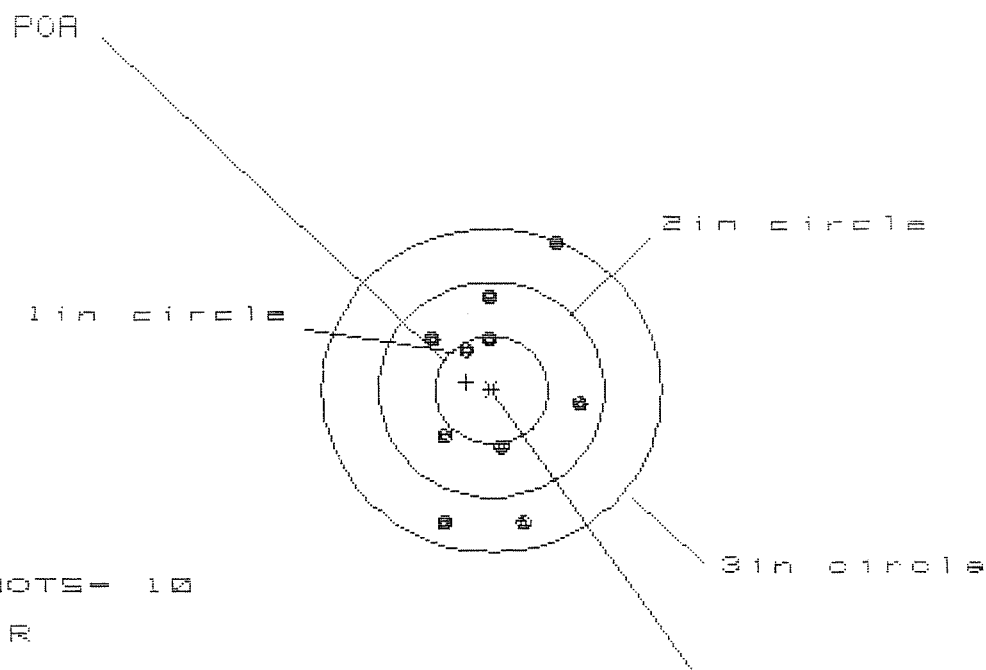
PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.826	.623	.648
MINIMUM X	:	-.822	-.788	-.691
MAXIMUM Y	:	.996	.916	.845
MINIMUM Y	:	-.768	-.847	-.733
CENTROID X	:	-.178	-.292	-.309
CENTROID Y	:	-.153	-.073	-.188
FOR TO CENTROID in.	:	.234	.301	.362
MIN RADIUS	:	.031	.166	.166
MEAN RADIUS	:	.734	.682	.633
MAX RADIUS	:	1.251	.927	.928
HORIZONTAL SPREAD	:	1.848	1.331	1.331
VERTICAL SPREAD	:	1.763	1.763	1.577
EXTREME SPREAD	:	1.981	1.776	1.617
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		9	
NUMBER IN THREE INCH CIRCLE	=		10	

13 Aug 1998

FILE:/PATTERNING/CENTERFIRE_PATT/CG49B881

CENTERFIRE PATTERNS

5



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 7

3 in = 10

HS= 1.376

VS= 2.644

GS= 2.814

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.812	.874	.824
MINIMUM X	:	-.564	-.502	-.552
MAXIMUM Y	:	1.374	.988	.851
MINIMUM Y	:	-1.270	-1.117	-1.254
CENTROID X	:	.223	.161	.211
CENTROID Y	:	-.075	-.228	-.091
POA TO CENTROID in.	:	.236	.279	.230
MIN RADIUS	:	.376	.360	.385
MEAN RADIUS	:	.847	.772	.707
MAX RADIUS	:	1.484	1.165	1.283
HORIZONTAL SPREAD	:	1.376	1.376	1.376
VERTICAL SPREAD	:	2.644	2.105	2.105
EXTREME SPREAD	:	2.814	2.130	2.130
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

Remington.



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

MODEL 700™ M24

SERIAL NO.
C6498801

ORDER NO.
5716

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

01



5716 C6498801

UPC



0 47700 25716 7

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER

BARBER - M24 M2400008026

BARBER - M24 000/98 /