

C6587541

MODEL 700™ M24

Model **SWS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

R 94-18842

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

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

OFFICE COPY

RD6925 REV. 1/94

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER

BARBER - M24 M3400022391

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

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

SERIAL NO. ~~C658774~~

DATE

7-15-96

TESTER

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#	COMMENTS
PULL #1	2.57	2.41	2.70	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.61	2.36	2.81	
PULL #3	2.54	2.43	2.65	
PULL #4	2.67	2.29	2.59	
PULL #5	2.60	2.35	2.73	
TOTAL	12.99	11.84	13.48	
AVG.	2.59	2.36	2.69	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.21	3.29		
PULL #2	3.01	3.12		
PULL #3	3.17	3.15		
PULL #4	3.25	3.08		
PULL #5	3.29	3.20		
TOTAL	15.93	15.84		
AVG.	3.18	3.16		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.11	4.22		4.31
PULL #2	4.19	4.30		4.31
PULL #3	4.11	4.24		4.34
PULL #4	4.11	4.33		4.35
PULL #5	4.19	4.23		4.35
TOTAL	20.71	21.32		21.66
AVG.	4.14	4.26		4.33

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			
	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	7	5	6			8/29/96	RW
	G) Safety Off Force	3	3	2.5			8/29/96	RW
	H) Trigger Pull Test & Retainability							
	I) Firing Pin Indent	.023	.023	.023			8/29/96	RW
	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	2.72	2.76	2.78	2.78	2.81	8-20-96	DA
	C) Function							
660	Pack							

CENTROIDAL DISTANCE CALCULATIONS
 FOR RIFLE # 05582541
 8 Jan 1980

CENTROIDAL DISTANCES

0 TO	1	.0123693
1 TO	2	.313453
1 TO	3	.26833
1 TO	4	.266248
1 TO	5	.152118

$\bar{x}_2$ <----POA

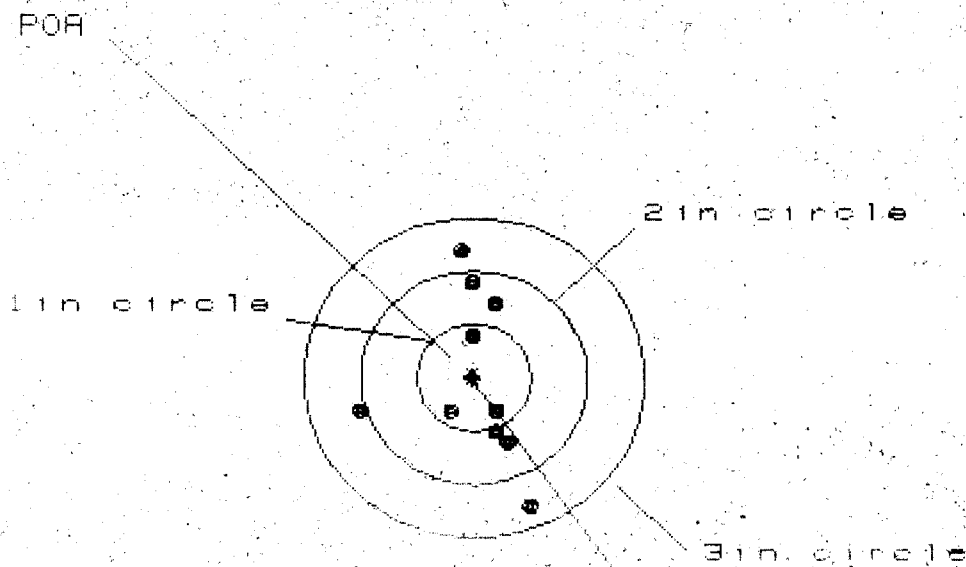
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0554
 THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1044
 THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .118188

THE AMR FOR THIS RIFLE IS: .9592

B Jan 1900

FILE: PHOTODUO CENTERFIRE PAT 08502541

CENTERFIRE PATTERNS # 1



OF SHOTS - 10

IN CIR

1in - 3

2in - 7

3in = 10

HS = 1.538

VS = 2.354

GS = 2.431

PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.488	.384	.376
MINIMUM X	:	-1.050	-.996	-1.004
MAXIMUM Y	:	1.149	1.016	.912
MINIMUM Y	:	-1.205	-.724	-.597
CENTROID X	:	.012	-.042	-.034
CENTROID Y	:	.003	.137	.010
POA TO CENTROID in.	:	.013	.144	.035
MIN RADIUS	:	.372	.302	.388
MEAN RADIUS	:	.765	.706	.651
MAX RADIUS	:	1.299	1.071	1.039
HORIZONTAL SPREAD	:	1.538	1.380	1.380
VERTICAL SPREAD	:	2.354	1.740	1.509
EXTREME SPREAD	:	2.431	1.797	1.588
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

8 Jan 1968

FILE: PATTERNING/CENTERFIRE_PATT/06587541

CENTERFIRE PATTERNS # 2

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS = 10

IN CIR

1in = 0

2in = 3

3in = 6

HS = 4.351

VS = 2.871

GS = 4.830

PATTERN #

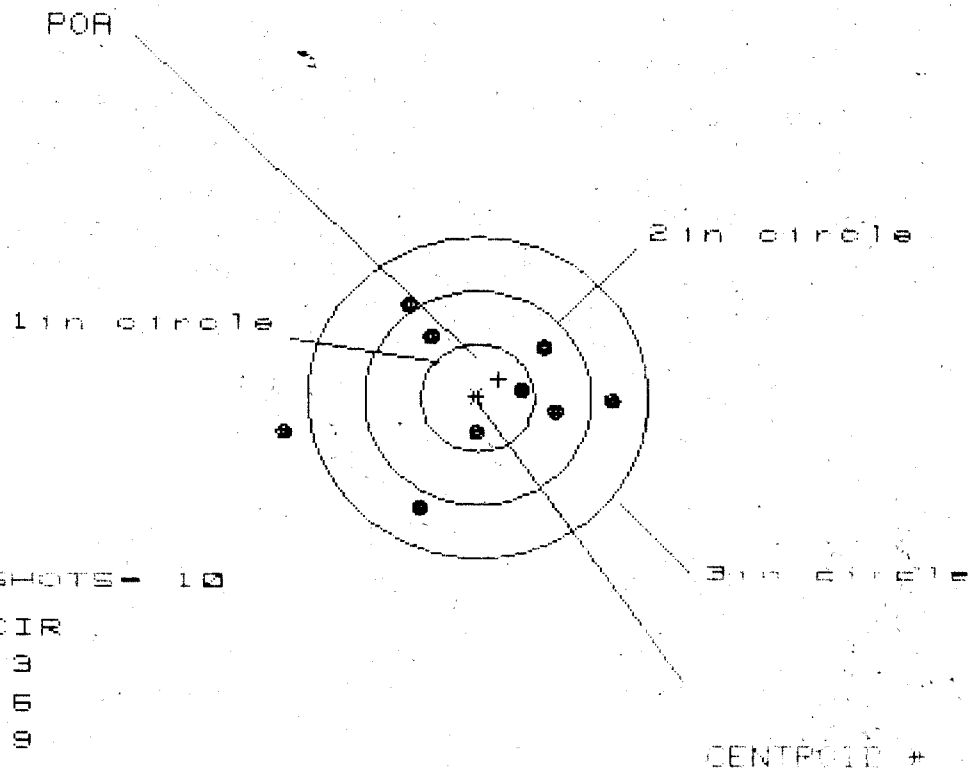
2

SHOTS (BEST OF)	10	9	8
MAXIMUM X	2.918	1.514	1.386
MINIMUM X	-1.433	-1.109	-1.237
MAXIMUM Y	1.414	1.319	.800
MINIMUM Y	-1.457	-1.552	-1.387
CENTROID X	.210	-.114	.014
CENTROID Y	-.240	-.145	-.310
POA TO CENTROID in.	.319	.185	.311
MIN RADIUS	.610	.638	.723
MEAN RADIUS	1.451	1.236	1.193
MAX RADIUS	3.040	1.819	1.756
HORIZONTAL SPREAD	4.351	2.623	2.623
VERTICAL SPREAD	2.871	2.871	2.187
EXTREME SPREAD	4.830	3.130	3.030
NUMBER IN ONE INCH CIRCLE	=	0	
NUMBER IN TWO INCH CIRCLE	=	3	
NUMBER IN THREE INCH CIRCLE	=	6	

8 Jan 1968

FILE: PATTERNING/CENTERFIRE_PATT/C6587541

CENTERFIRE PATTERNS # 3



OF SHOTS - 10

IN CIR

1 in = 3

2 in = 6

3 in = 9

HS = 2.847

VS = 1.857

GS = 2.865

CENTROID +

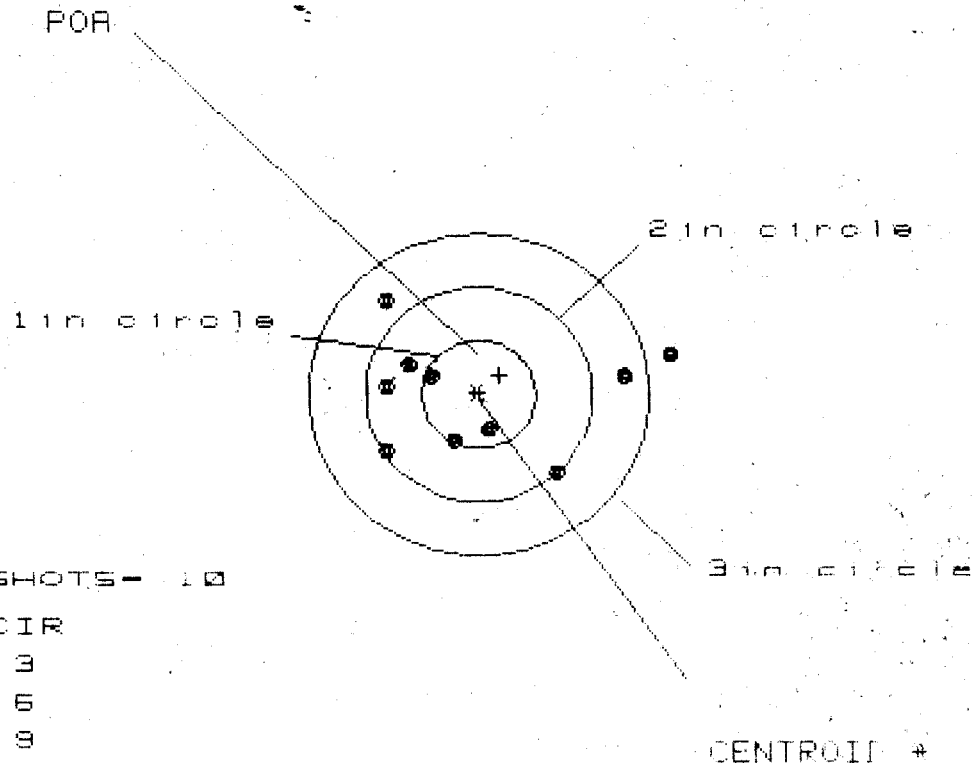
PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	1.179
MINIMUM X	-1.668
MAXIMUM Y	.829
MINIMUM Y	-1.028
CENTROID X	-.187
CENTROID Y	-.177
PDR TO CENTROID in.	.257
MIN RADIUS	.356
MEAN RADIUS	.831
MAX RADIUS	1.708
HORIZONTAL SPREAD	2.847
VERTICAL SPREAD	1.857
EXTREME SPREAD	2.865
NUMBER IN ONE INCH CIRCLE =	3
NUMBER IN TWO INCH CIRCLE =	6
NUMBER IN THREE INCH CIRCLE =	9

8 Jan 1908

FILE:/PATTERNING/CENTERFIRE_PATT/06587541

CENTERFIRE PATTERNS

4



OF SHOTS- 10

IN CIR

1 in - 3

2 in - 6

3 in - 9

HS- 2.504

VS- 1.598

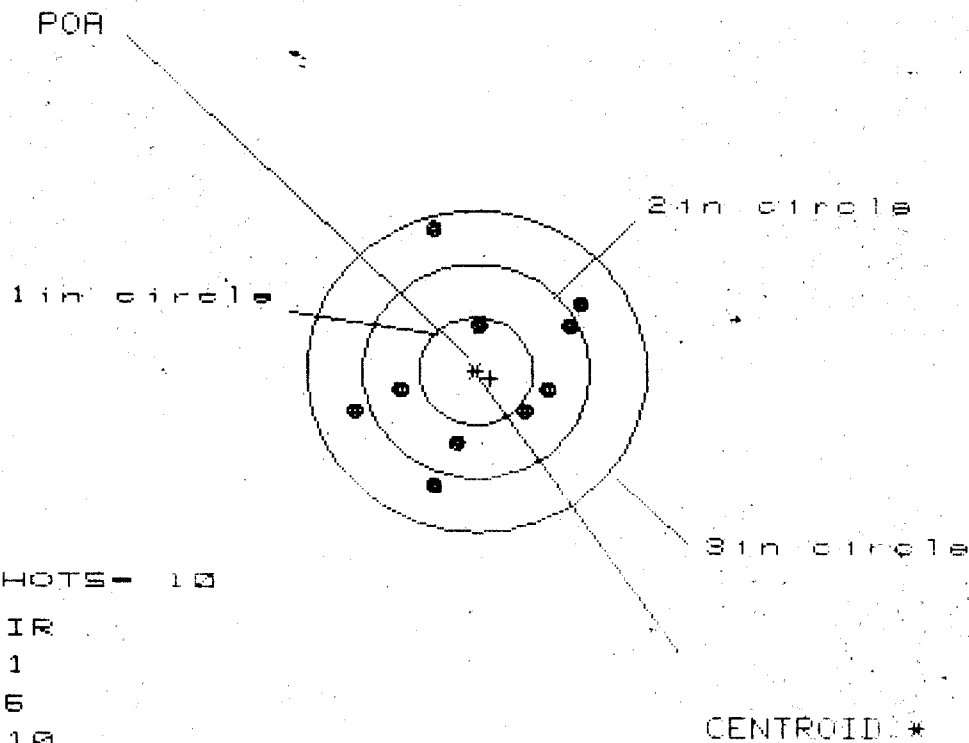
GS- 2.607

PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.650	1.457	1.057
MINIMUM X	-.854	-.671	-.489
MAXIMUM Y	.830	.876	.905
MINIMUM Y	-.768	-.722	-.693
CENTROID X	-.186	-.369	-.551
CENTROID Y	-.175	-.221	-.250
POA TO CENTROID in.	.255	.430	.605
MIN RADIUS	.315	.306	.220
MEAN RADIUS	.885	.742	.612
MAX RADIUS	1.701	1.475	1.264
HORIZONTAL SPREAD	2.504	2.128	1.546
VERTICAL SPREAD	1.598	1.598	1.098
EXTREME SPREAD	2.607	2.224	2.223
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	9		

8 Jan 1900

FILE: PATTERNING/CENTERFIRE_PATT/C6587541

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in - 1

2 in - 6

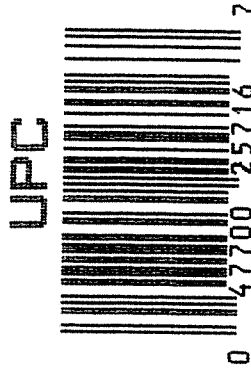
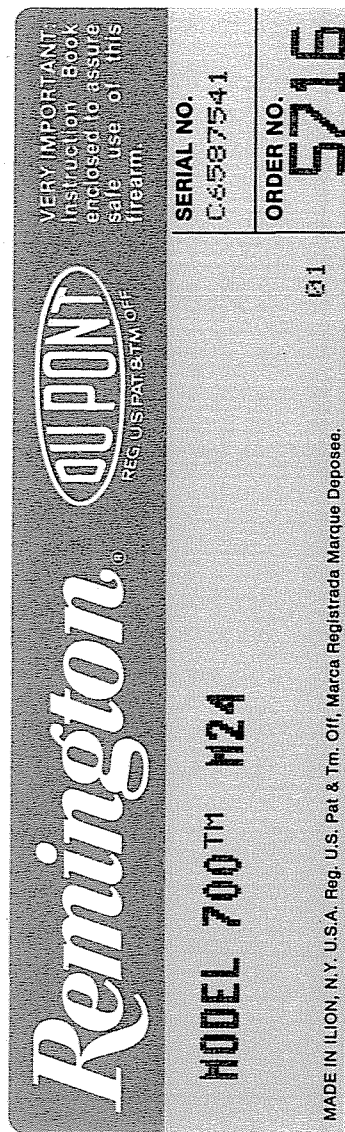
3 in = 10

HS- 2.010

VS= 2.366

GS= 2.366

PATTERN #		10	9	8
SHOTS (BEST OF)		10	9	8
MAXIMUM X		.895	.850	.705
MINIMUM X		-1.115	-1.160	-.832
MAXIMUM Y		1.317	.825	.802
MINIMUM Y		-1.049	-.903	-.926
CENTROID X		-.126	-.080	.065
CENTROID Y		.067	-.079	-.056
POA TO CENTROID in.		.143	.113	.085
MIN RADIUS		.434	.434	.329
MEAN RADIUS		.864	.789	.719
MAX RADIUS		1.378	1.185	1.101
HORIZONTAL SPREAD		2.010	2.010	1.537
VERTICAL SPREAD		2.366	1.728	1.728
EXTREME SPREAD		2.366	2.249	2.162
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	6		
NUMBER IN THREE INCH CIRCLE	=	10		



CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6587541

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	1023	90	RW
600	Proof	1023	90	RW
607	Check Headspace	1023	90	RW
610	Dis-assemble Gun	1023	90	RW
612	Magnaflux Barrel Action		10/24/90	KR
	Magnaflux Bolt		10/24/90	KR
615	Rollmark Caliber		"	JS
617	Drill and Tap Sight Holes		10/25/90	LB
618	Polish Barrel RB		10/26/90	WB
620	Apply Coatings (Barrel Action)		11-7-90	TH
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		11/12/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		11/12/90	RW
	C) Inspect Ejector Hole for Chamfer		11/12/90	RW
	D) Oil Firing Pin Ass'y		11/12/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		11/12/90	WB

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4 1/4	4 1/4	4 1/4			11/26/90	WB
	G) Safety Off Force	2 1/2	2 1/2	2 1/2			11/26/90	WB
	H) Trigger Pull Test & Retainability						11/19/90	WB
	I) Firing Pin Indent	.0225	.023	.023			11/26/90	WB
	J) Assemble Stock						11/26/90	RW
	K) Assemble Swivel Studs						11-27-90	WB
	L) Attach Front and Rear Sight Assemblies						11/26/90	RW
	M) Iron Sight Alignment						11/26/90	RW
	N) Detach Front & Rear Sights & place in numbered container						11/26/90	RW
	O) Attach Scope to Rifle						11/26/90	RW
	P) Detach & Attach Scope 20 Times						11/26/90	RW
640	Gallery Target & Test						11/26/90	NF
	A) Time						"	NF
	B) Malfunctions						"	NF
	C) Pierced Primers						"	NF
	D) Optical Clarity of Scope						"	NF
645	Inspect for Live Ammo						11/26/90	NF
655	Final Inspection							
	A) Headspace						11-27-90	WB
	B) Trigger Pull	280	292	294	292	289	11-27-90	WB
	C) Function						11-27-90	WB
660	Pack						12-18-90	DH

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6587541DATE 11/19/90TESTER WLB

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.50	2.49	2.60	2.80	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.44	2.43	2.53	2.92	
PULL #3	2.55	2.49	2.55	2.94	
PULL #4	2.39	2.48	2.36	2.92	
PULL #5	2.56	2.49	2.37	2.89	
TOTAL	12.44	12.38	12.41		
AVG.	2.49	2.47	2.48		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.21	3.08		
PULL #2	3.17	3.10		
PULL #3	3.25	3.33		
PULL #4	3.26	3.28		
PULL #5	3.28	3.22		
TOTAL	16.17	16.01		
AVG.	3.23	3.20		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.28	4.06		3.95
PULL #2	4.05	4.30		4.05
PULL #3	4.16	4.31		4.06
PULL #4	4.08	4.27		3.95
PULL #5	4.17	4.26		4.02
TOTAL	20.74	21.20		20.03
AVG.	4.15	4.24		4.01

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6587541
27 Nov 1990

CENTROIDAL DISTANCES

0 TO	1	.0574891
1 TO	2	.102108
1 TO	3	.0548179
1 TO	4	.329876
1 TO	5	.240707

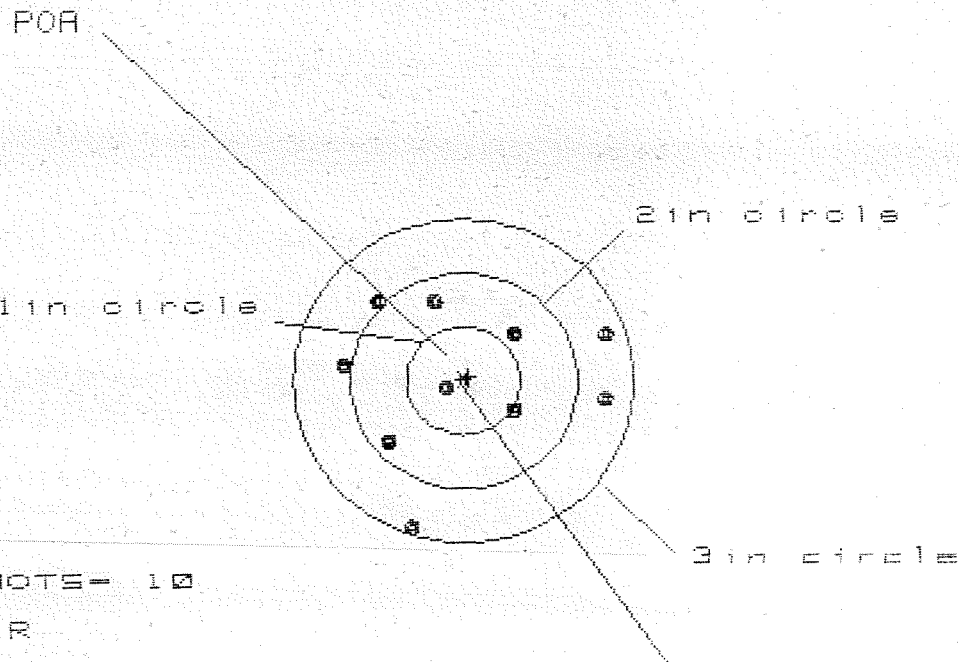
4 <----POI

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0688
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0424
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0808158
THE AMR FOR THIS RIFLE IS: 1.146

27 Nov 1990

FILE:/PATTERNING/CENTERFIRE_PATT/C6587541

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 5

3 in = 10

HS = 2.260

VS = 2.115

GS = 2.410

CENTROID *

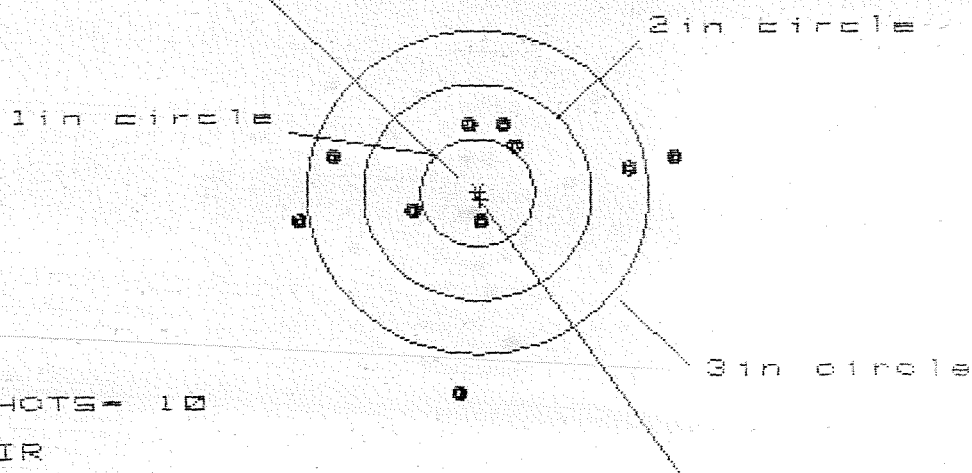
PATTERN #	1	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.205	1.158	1.300
MINIMUM X	-1.055	-1.102	-0.958
MAXIMUM Y	.769	.620	.654
MINIMUM Y	-1.345	-0.728	-0.694
CENTROID X	-0.044	.003	-0.141
CENTROID Y	-0.037	.112	.077
POA TO CENTROID in.	.058	.112	.161
MIN RADIUS	.208	.327	.209
MEAN RADIUS	.899	.835	.776
MAX RADIUS	1.412	1.206	1.337
HORIZONTAL SPREAD	2.260	2.260	2.258
VERTICAL SPREAD	2.115	1.348	1.348
EXTREME SPREAD	2.410	2.283	2.283
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	10		

27 Nov 1990

FILE:/PATTERNING/CENTERFIRE_PATT/C6587541

CENTERFIRE PATTERNS # 2

POA



OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 7

HS= 3.310

VS= 2.451

GS= 3.364

CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.728	1.706	1.560
MINIMUM X	:	-1.582	-1.604	-1.390
MAXIMUM Y	:	.602	.396	.416
MINIMUM Y	:	-1.850	-.506	-.486
CENTROID X	:	-.029	-.007	-.221
CENTROID Y	:	.064	.269	.249
POA TO CENTROID in.	:	.070	.269	.333
MIN RADIUS	:	.301	.399	.446
MEAN RADIUS	:	1.063	.943	.848
MAX RADIUS	:	1.859	1.714	1.561
HORIZONTAL SPREAD	:	3.310	3.310	2.950
VERTICAL SPREAD	:	2.451	.902	.902
EXTREME SPREAD	:	3.364	3.364	2.989
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		7	

27 Nov 1998

FILE:/PATTERNING/CENTERFIRE_PATT/06587541

CENTERFIRE PATTERNS # 3

POA

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 1

2 in = 5

3 in = 9

HS= 2.353

VS= 2.363

GS= 2.913

CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.116	.978	.837
MINIMUM X	:	-1.237	-1.196	-1.074
MAXIMUM Y	:	1.157	1.195	1.141
MINIMUM Y	:	-1.206	-1.077	-1.131
CENTROID X	:	-.030	.108	-.015
CENTROID Y	:	.016	-.112	-.058
POA TO CENTROID in.	:	.034	.156	.060
MIN RADIUS	:	.478	.604	.554
MEAN RADIUS	:	.999	.903	.881
MAX RADIUS	:	1.694	1.356	1.254
HORIZONTAL SPREAD	:	2.353	2.174	1.910
VERTICAL SPREAD	:	2.363	2.272	2.272
EXTREME SPREAD	:	2.913	2.404	2.404
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

27 Nov 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C8587541

CENTERFIRE PATTERNS

4

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS- 10

IN CIR

1 in = 0

2 in = 4

3 in = 8

HS= 4.391

VS= 2.678

GS= 4.683

PATTERN #

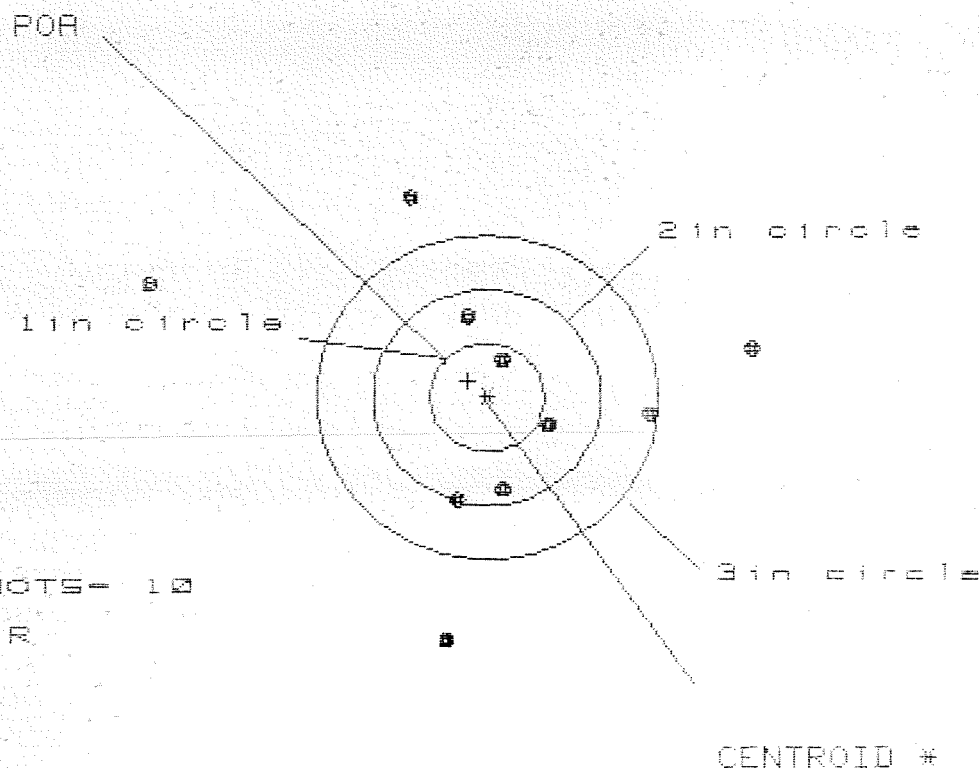
4

SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.820	1.216	1.058
MINIMUM X	:	-1.571	-1.257	-1.024
MAXIMUM Y	:	1.344	1.313	1.137
MINIMUM Y	:	-1.334	-1.365	-1.201
CENTROID X	:	.279	-.035	.123
CENTROID Y	:	-.104	-.073	-.237
POA TO CENTROID in.	:	.298	.081	.267
MIN RADIUS	:	.518	.223	.364
MEAN RADIUS	:	1.292	1.064	.969
MAX RADIUS	:	2.834	1.818	1.436
HORIZONTAL SPREAD	:	4.391	2.473	2.083
VERTICAL SPREAD	:	2.678	2.678	2.338
EXTREME SPREAD	:	4.683	3.480	2.668
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	

27 May 1998

FILE:/PATTERNING/CENTERFIRE_PATT/06587541

CENTERFIRE PATTERNS # 5



PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	2.306
MINIMUM X	-3.014
MAXIMUM Y	1.889
MINIMUM Y	-2.216
CENTROID X	.168
CENTROID Y	-.151
POA TO CENTROID in.	.226
MIN RADIUS	.396
MEAN RADIUS	1.479
MAX RADIUS	3.185
HORIZONTAL SPREAD	5.320
VERTICAL SPREAD	4.105
EXTREME SPREAD	5.350
NUMBER IN ONE INCH CIRCLE =	1
NUMBER IN TWO INCH CIRCLE =	4
NUMBER IN THREE INCH CIRCLE =	6