

CE348957

MODEL 700™ M24

Model **SWS**™

Action

Barrel Length

Capacity

Order No. **5715**

\*Includes 1 in chamber.

*Remington*



# RECORDS CONTROL SCHEDULE

RECORDS CATEGORY OR TITLE:

126 - EMPLOYEE SUGGESTION STATUS

REPORTS

COPY "O" (OFFICIAL) ☐ "X" (EXTRA) ☒

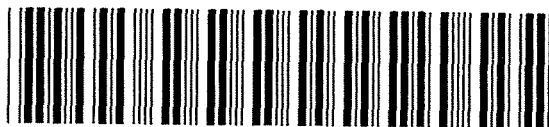
TOTAL RETENTION: 10 YEARS

GS-11050 Rev. 8/78

[illegible]

Number: **C6348957**

Model: 700



RE00044054

## SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6348957.\_\_\_0

FILE DATE AND TIME: 04/06/2002 23:17

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

|                                                             |        |
|-------------------------------------------------------------|--------|
| The Average X Centroid of the Five Target Set:              | 0.213  |
| The Average Y Centroid of the Five Target Set:              | -0.400 |
| The Average Point of Impact of the Five Target Set:         | 0.453  |
| The Average Mean Radius of the Five Target Set:             | 1.009  |
| The Distance from POA to Centroid Target #1:                | 0.154  |
| The Distance from Centroid Target #2 to Centroid Target #1: | 0.293  |
| The Distance from Centroid Target #3 to Centroid Target #1: | 0.150  |
| The Distance from Centroid Target #4 to Centroid Target #1: | 1.715  |
| The Distance from Centroid Target #5 to Centroid Target #1: | 0.258  |

SERIAL NUMBER: C6348957. 0

TARGET NUMBER: 1

FILE DATE: 04/06/2002

FILE TIME: 23:17

X CENTROID: -0.074

Y CENTROID: -0.134

POA TO CENTROID: 0.154

HORZ SPREAD: 2.019

VERT SPREAD: 2.594

GROUP SPREAD: 2.767

MIN RADIUS: 0.205

MAX RADIUS: 1.569

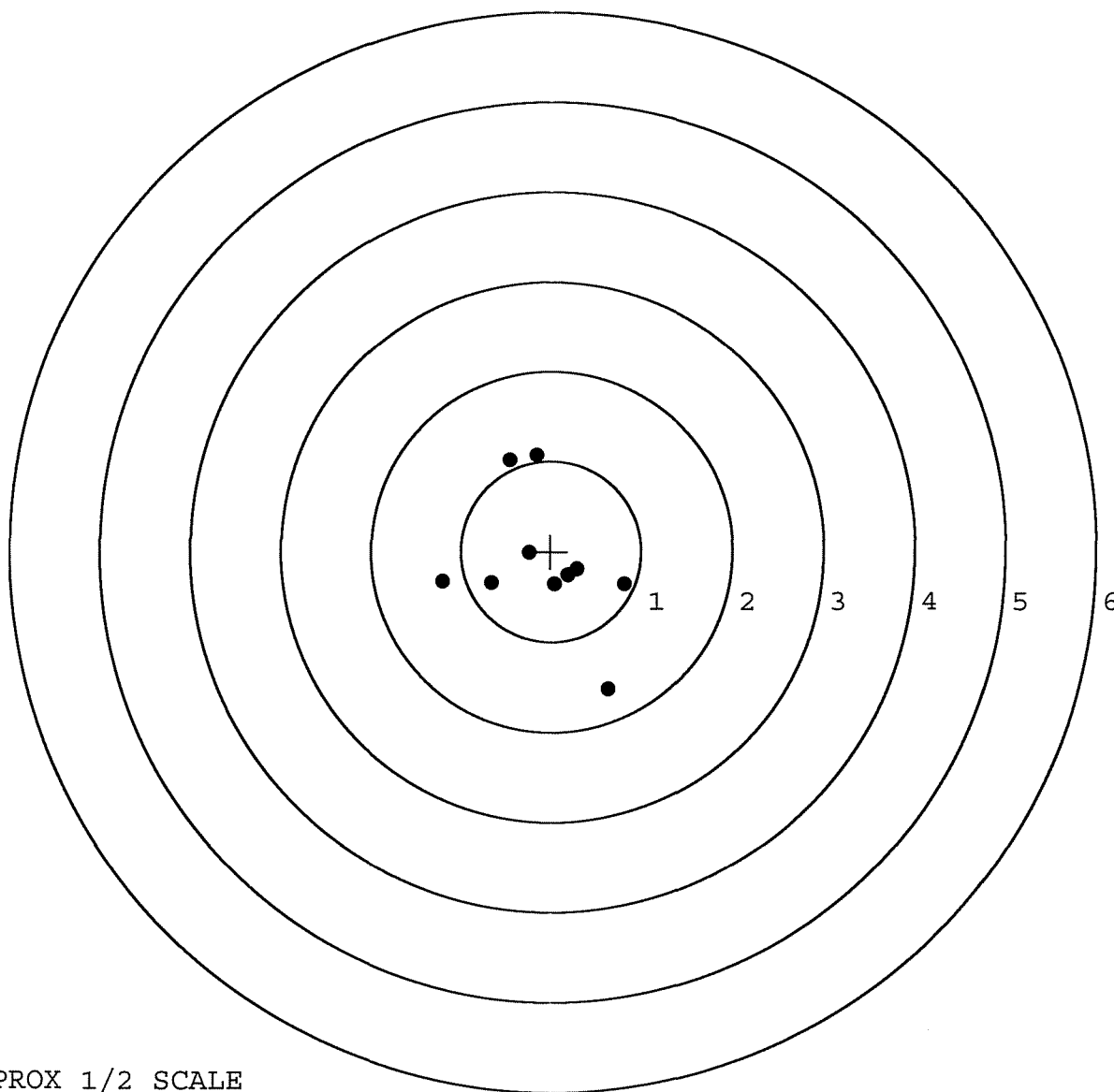
MEAN RADIUS: 0.780

# IN 1 IN DIAMETER: 4

# IN 2 IN DIAMETER: 6

# in 3 IN DIAMETER: 9

| POINT# | X      | Y      |
|--------|--------|--------|
| 1:     | 0.640  | -1.531 |
| 2:     | 0.814  | -0.365 |
| 3:     | 0.293  | -0.194 |
| 4:     | 0.046  | -0.361 |
| 5:     | -0.241 | -0.015 |
| 6:     | -0.663 | -0.347 |
| 7:     | -1.205 | -0.336 |
| 8:     | -0.463 | 1.007  |
| 9:     | -0.156 | 1.063  |
| 10:    | 0.193  | -0.265 |



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6348957. \_\_0

TARGET NUMBER: 2

FILE DATE: 04/06/2002

FILE TIME: 23:17

X CENTROID: 0.124

Y CENTROID: -0.350

POA TO CENTROID: 0.371

HORZ SPREAD: 1.458

VERT SPREAD: 4.439

GROUP SPREAD: 4.443

MIN RADIUS: 0.323

MAX RADIUS: 3.254

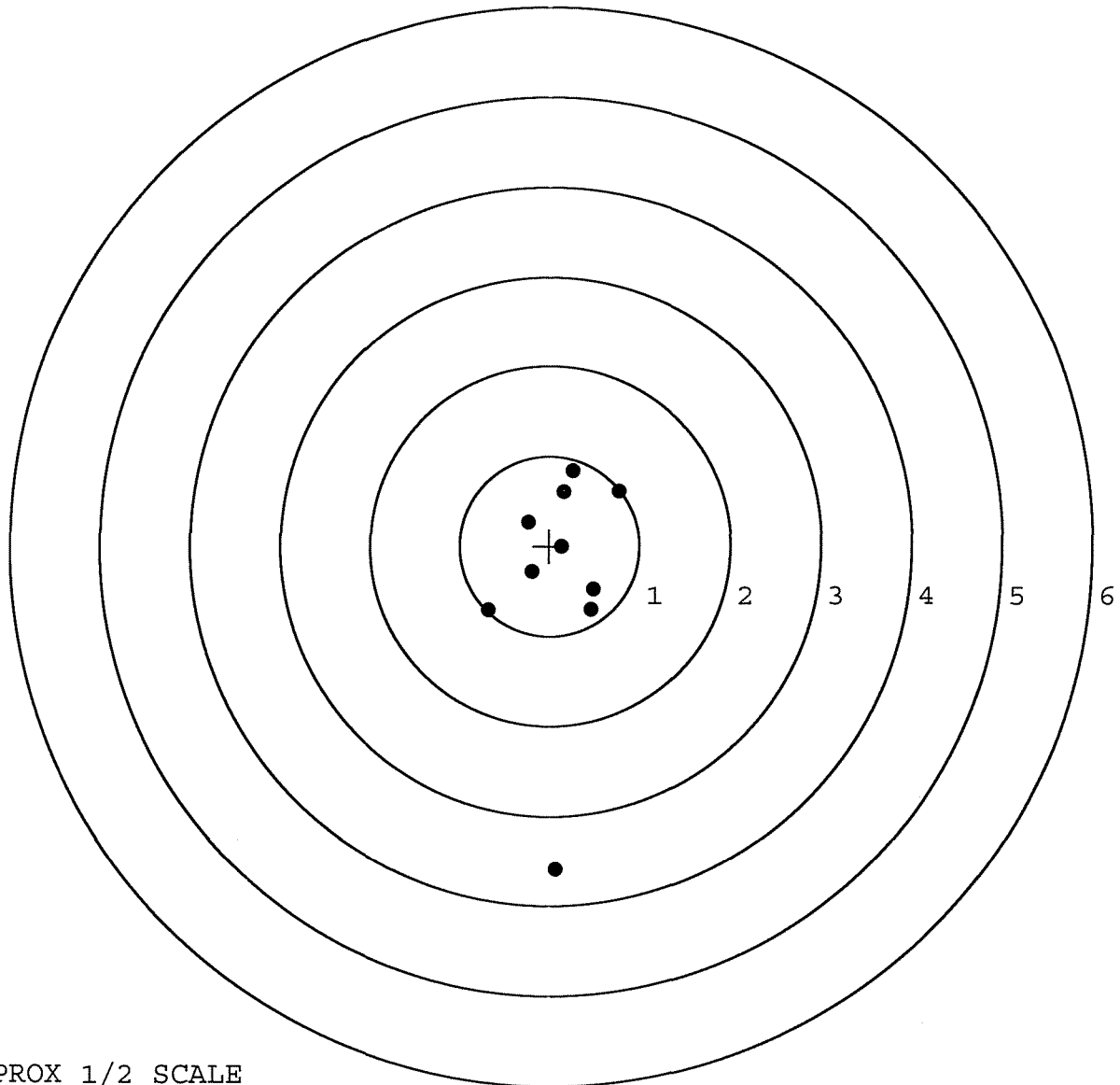
MEAN RADIUS: 0.971

# IN 1 IN DIAMETER: 4

# IN 2 IN DIAMETER: 7

# in 3 IN DIAMETER: 9

| POINT# | X      | Y      |
|--------|--------|--------|
| 1:     | 0.076  | -3.604 |
| 2:     | -0.683 | -0.714 |
| 3:     | 0.466  | -0.710 |
| 4:     | 0.491  | -0.481 |
| 5:     | -0.194 | -0.292 |
| 6:     | 0.134  | -0.011 |
| 7:     | -0.243 | 0.265  |
| 8:     | 0.159  | 0.600  |
| 9:     | 0.259  | 0.835  |
| 10:    | 0.775  | 0.613  |



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6348957. 0

TARGET NUMBER: 3

FILE DATE: 04/06/2002

FILE TIME: 23:17

X CENTROID: -0.087

Y CENTROID: -0.284

POA TO CENTROID: 0.297

HORZ SPREAD: 2.044

VERT SPREAD: 4.653

GROUP SPREAD: 4.653

MIN RADIUS: 0.527

MAX RADIUS: 2.580

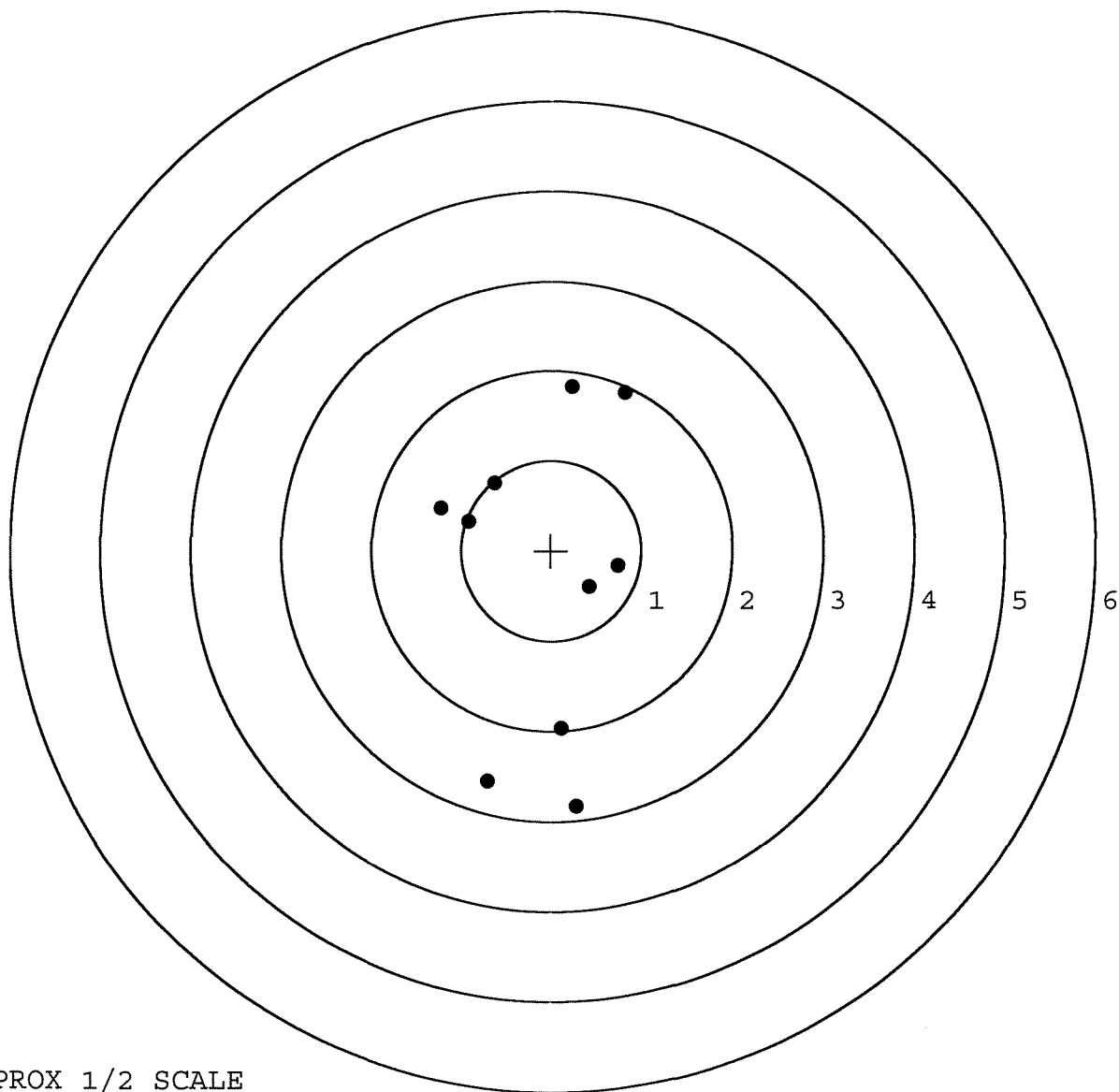
MEAN RADIUS: 1.593

# IN 1 IN DIAMETER: 0

# IN 2 IN DIAMETER: 2

# in 3 IN DIAMETER: 5

| POINT# | X      | Y      |
|--------|--------|--------|
| 1:     | 0.284  | -2.837 |
| 2:     | -0.711 | -2.566 |
| 3:     | 0.117  | -1.977 |
| 4:     | 0.425  | -0.406 |
| 5:     | 0.740  | -0.169 |
| 6:     | -0.629 | 0.749  |
| 7:     | -0.919 | 0.326  |
| 8:     | -1.227 | 0.473  |
| 9:     | 0.228  | 1.816  |
| 10:    | 0.817  | 1.750  |



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6348957. \_\_0

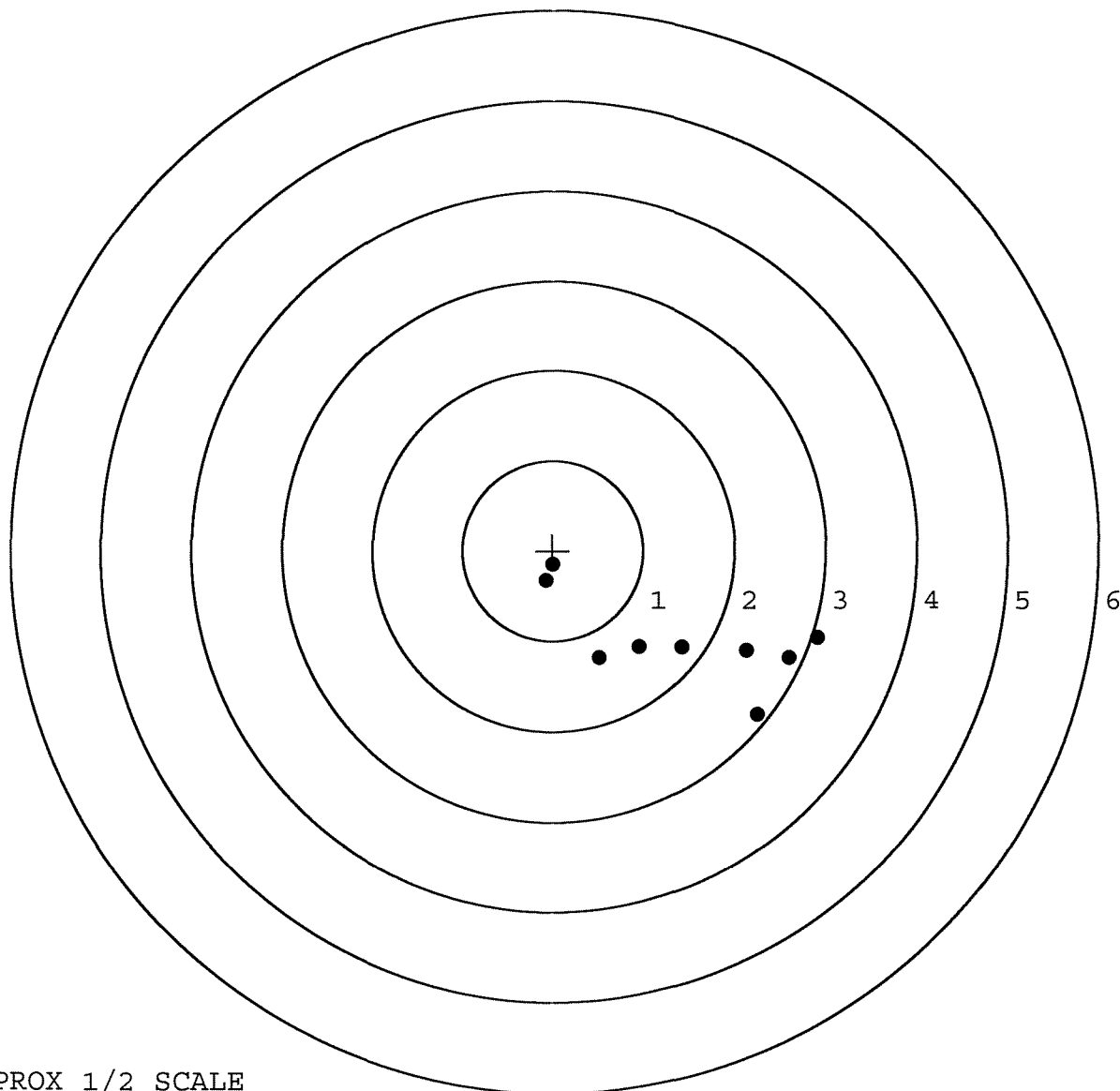
TARGET NUMBER: 4

FILE DATE: 04/06/2002

FILE TIME: 23:17

X CENTROID: 1.413  
 Y CENTROID: -0.990  
 POA TO CENTROID: 1.725  
 HORZ SPREAD: 2.983  
 VERT SPREAD: 1.816  
 GROUP SPREAD: 3.018  
 MIN RADIUS: 0.082  
 MAX RADIUS: 1.638  
 MEAN RADIUS: 1.036  
 # IN 1 IN DIAMETER: 2  
 # IN 2 IN DIAMETER: 4  
 # in 3 IN DIAMETER: 7

| POINT# | X      | Y      |
|--------|--------|--------|
| 1:     | -0.074 | -0.336 |
| 2:     | 0.520  | -1.189 |
| 3:     | 0.959  | -1.069 |
| 4:     | 1.425  | -1.071 |
| 5:     | 2.133  | -1.107 |
| 6:     | 2.595  | -1.193 |
| 7:     | 2.909  | -0.967 |
| 8:     | 2.247  | -1.816 |
| 9:     | 0.001  | -0.159 |



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6348957. \_\_0

TARGET NUMBER: 5

FILE DATE: 04/06/2002

FILE TIME: 23:17

X CENTROID: -0.309

Y CENTROID: -0.242

POA TO CENTROID: 0.392

HORZ SPREAD: 1.633

VERT SPREAD: 2.235

GROUP SPREAD: 2.274

MIN RADIUS: 0.179

MAX RADIUS: 1.417

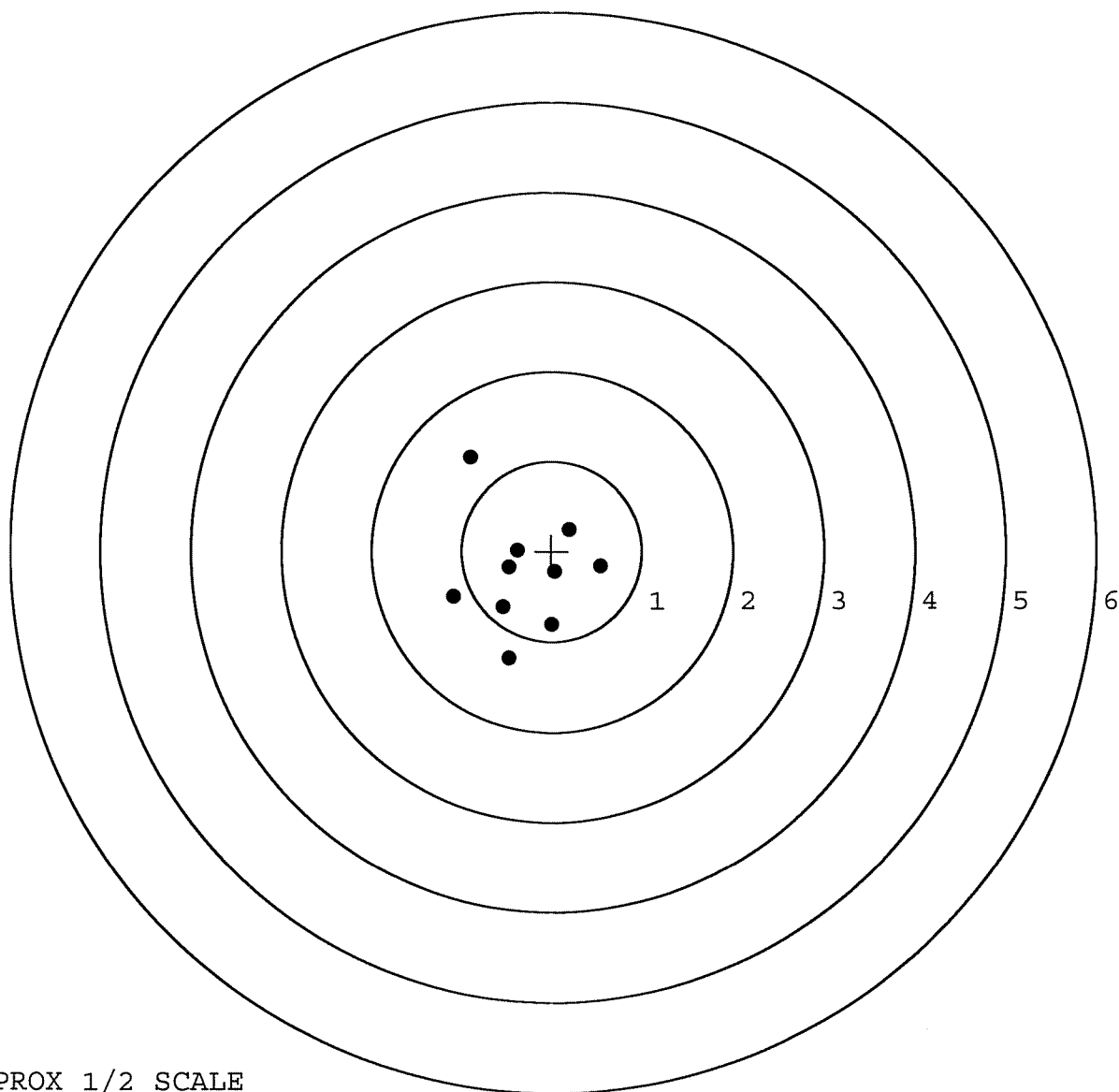
MEAN RADIUS: 0.665

# IN 1 IN DIAMETER: 4

# IN 2 IN DIAMETER: 9

# in 3 IN DIAMETER: 10

| POINT# | X      | Y      |
|--------|--------|--------|
| 1:     | 0.006  | -0.816 |
| 2:     | -0.479 | -1.189 |
| 3:     | -0.540 | -0.624 |
| 4:     | -1.091 | -0.509 |
| 5:     | -0.477 | -0.180 |
| 6:     | -0.382 | 0.008  |
| 7:     | 0.542  | -0.167 |
| 8:     | 0.196  | 0.242  |
| 9:     | -0.900 | 1.046  |
| 10:    | 0.040  | -0.227 |



TARGET APPROX 1/2 SCALE

R & E NUMBER 44054

**SERIAL NUMBER** C634895

LOG-IN DATE 3/27/02

**CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER**

BBL - 96003

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: RE00009419

Serial: C6348958 Model 700 Center Fire Caliber:  
7.62 NATO M-24 (SWS)

Repairman:

Status:

New 5/18/00 9:37:43 AM

Verify Repair

Address Information

Customer:

☒ Received From

Return To:

☐ Received From

Name: DEF DIST DEPOT ANNISTON

DEF DIST DEPOT ANNISTON

Address 1:

Address 2:

PO Box:

PO Box:

City: ANNISTON

ANNISTON

State: AL

Zip Code: 362014199

Country: US

State: AL

Zip Code: 362014199

Country: US

FFL:

Contact / Condition

Problems

Estimate

History / Status

Shipping / Billing

Contact Information

Phone:

Fax:

Email:

Comments:

Received Condition

Poor

Condition  
Notes:

CSR  
Notes:

Accessories Received

| Code | Desc        | Qty |
|------|-------------|-----|
| A007 | With Stud   | 2   |
| A008 | With Swivel | 2   |
| A010 | Hard Case   | 1   |
| A017 | Scope Base  | 1   |

Repair Search

Refresh

Close

maglet

5/18/00

12:18 PM

CAPS

NUM

INS

SCRL

Start Inb... Micr... SA... Nag... Audit R&... Ar... Prin... Re... 12:18 PM

Serial  
Number:

C6348958

Model: 700



RE00009419

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

|                     |                          |           |         |
|---------------------|--------------------------|-----------|---------|
| R & E NUMBER        |                          |           |         |
| SERIAL NUMBER       |                          | C6348958  |         |
| LOG-IN DATE         |                          | 5-11-00   |         |
| INSPECT AND VERIFY: |                          |           |         |
| OPERATION #         | OPERATION NAME           | DATE      | INITIAL |
| 550                 | DIS-ASSEMBLE GUN         | 5-15-00   | RW      |
| 560 A               | RE-BARREL AT CUSTOM SHOP |           |         |
| B                   | DRILL AND TAP            |           |         |
| C                   | POLISH                   |           |         |
| 575                 | ASSEMBLE                 |           |         |
| 600                 | PROOF                    | 5-22-00   | RW      |
| 605                 | CHECK HEADSPACE          | 5-22-00   | RW      |
| 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                   | 7-17-00   | RW      |
| 655                 | FINAL INSPECT            | 7-25-00   | RW      |
| 660                 | PACK                     |           |         |
|                     |                          |           |         |
|                     |                          | SHIP DATE |         |
| OAR INSPECTION DATE |                          |           |         |

## Final Inspection

Sn: C6348958

DATE REC'D: 5-11-00

DATE RET'D:

Auditor: RW

## 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:

Remington Test Lab, Ilion, N.Y.

Centroidal distance calculations for Rifle # c6348958  
20 Jul 2000

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0782  
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .2586  
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .270165  
  
THE AMR FOR THIS RIFLE IS: 1.126

# CENTROIDAL DISTANCES

|   |    |   |         |
|---|----|---|---------|
| 0 | TO | 1 | .440324 |
| 1 | TO | 2 | .538365 |
| 1 | TO | 3 | .176162 |
| 1 | TO | 4 | .491314 |
| 1 | TO | 5 | .289689 |

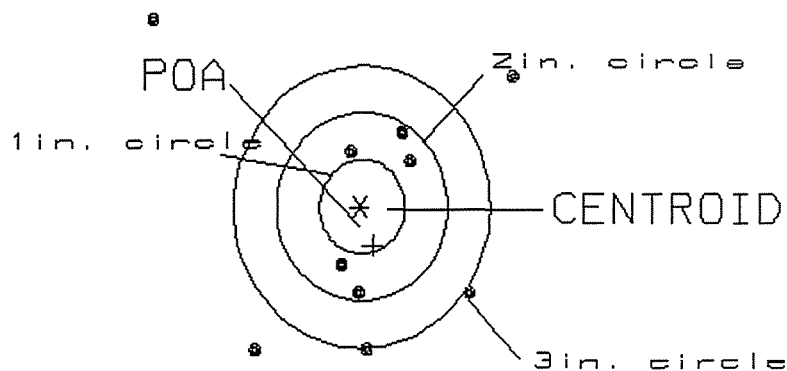
1 3 4  
5  
+2 <----POA

PATTERN #: ☐ 1 ☐  
 POA TO CENTROID: .440  
 MIN RADIUS : .610  
 MEAN RADIUS : 1.434  
 MAX RADIUS : 3.185  
 CENTROID X : -.158  
 CENTROID Y : .411

20 Jul 2000

FILE: /Hpbasic/Accuracy/Patterning/Centerfire\_Patt/c6348958

## CENTERFIRE PATTERN # 1



# OF SHOTS= 10

# IN CIRCLE

HS= 4.21

0

VS= 3.57

5

GS= 4.71

5

PATTERN #: ☐ 2 ☐

POA TO CENTROID: .142

MIN RADIUS : .318

MEAN RADIUS : 1.168

MAX RADIUS : 2.512

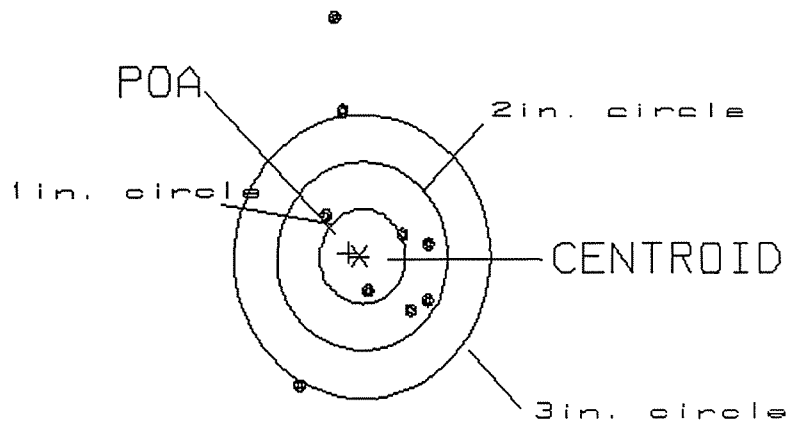
CENTROID X : .136

CENTROID Y : -.040

20 Jul 2000

FILE: /Hpbasic/Accuracy/Patterning/Centerfire\_Patt/c6348958

## CENTERFIRE PATTERN # 2



# OF SHOTS= 10

# IN CIRCLE

HS= 1.52

1

VS= 4.65

6

GS= 4.66

6

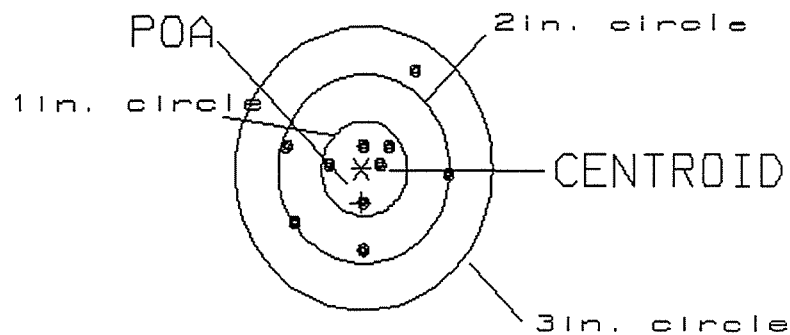
PATTERN #: ☐ 3 ☐

POA TO CENTROID: .358  
 MIN RADIUS : .162  
 MEAN RADIUS : .639  
 MAX RADIUS : 1.249  
 CENTROID X : .010  
 CENTROID Y : .358

28 Jul 2000

FILE: /Hpbasic/Accuracy/Patterning/Centerfire\_Patt/c6348958

## CENTERFIRE PATTERN # 3



# OF SHOTS= 10

# IN CIRCLE

HS= 1.89

5

VS= 1.91

9

GS= 2.15

10

PATTERN #: ☐ 4 ☐

POA TO CENTROID: .457

MIN RADIUS : .374

MEAN RADIUS : 1.109

MAX RADIUS : 2.060

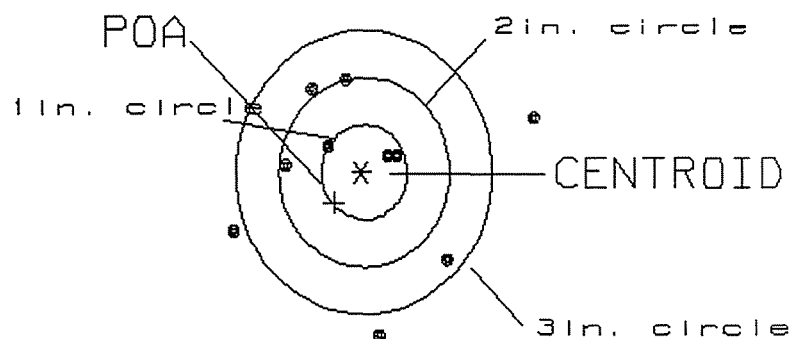
CENTROID X : .325

CENTROID Y : .321

20 Jul 2000

FILE: /Hpbasic/Accuracy/Patterning/Centerfire\_Patt/c6348958

## CENTERFIRE PATTERN # 4



# OF SHOTS= 10

# IN CIRCLE

HS= 3.47

2

VS= 2.69

4

GS= 3.68

7

PATTERN #: ☐ 5 ☐

POA TO CENTROID: .255

MIN RADIUS : .430

MEAN RADIUS : 1.280

MAX RADIUS : 2.365

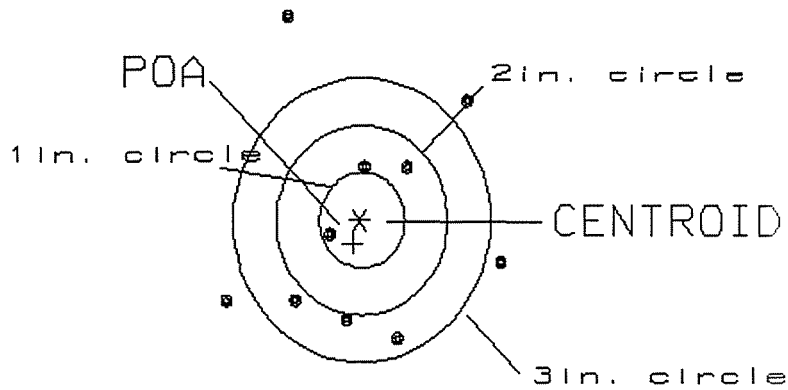
CENTROID X : .078

CENTROID Y : .243

20 Jul 2000

FILE: /Hpbasic/Accuracy/Patterning/Centerfire\_Patt/c6348958

## CENTERFIRE PATTERN # 5



# OF SHOTS= 10

# IN CIRCLE

HS= 3.14

1

VS= 3.49

3

GS= 3.70

6

**R** 95-10935

RD6925 REV. 1/94

**BARBER - M24 M2400042610**

AVERAGE PULL FORCE BETWEEN  
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6348956DATE 6-24-96TESTER DA

|         | 2.50#<br>INITIAL | 2.50# AFTER<br>50 CYCLES | FINAL TEST &<br>TO RESET 2.50# | COMMENTS                                                               |
|---------|------------------|--------------------------|--------------------------------|------------------------------------------------------------------------|
| PULL #1 | 2.66             | 2.43                     | 2.67                           | MIN. SETTING,<br>NO AVG. OF 5<br>READINGS ACCEPT-<br>ABLE LESS THAN 2# |
| PULL #2 | 2.58             | 2.33                     | 2.81                           |                                                                        |
| PULL #3 | 2.58             | 2.54                     | 2.81                           |                                                                        |
| PULL #4 | 2.58             | 2.40                     | 2.77                           |                                                                        |
| PULL #5 | 2.55             | 2.44                     | 2.86                           |                                                                        |
| TOTAL   | 12.95            | 12.14                    | 13.92                          |                                                                        |
| AVG.    | 2.59             | 2.42                     | 2.78                           |                                                                        |

|         | 3.00#<br>INITIAL | 3.00# AFTER<br>20 CYCLES | COMMENTS |
|---------|------------------|--------------------------|----------|
| PULL #1 | 3.13             | 3.01                     |          |
| PULL #2 | 3.20             | 3.09                     |          |
| PULL #3 | 3.16             | 3.26                     |          |
| PULL #4 | 3.06             | 3.06                     |          |
| PULL #5 | 3.31             | 3.15                     |          |
| TOTAL   | 15.86            | 15.57                    |          |
| AVG.    | 3.17             | 3.11                     |          |

|         | 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 | 4.11             | 4.07                     |                                | 4.13                                 |
| PULL #2 | 4.07             | 4.09                     |                                | 4.06                                 |
| PULL #3 | 4.14             | 4.00                     |                                | 4.09                                 |
| PULL #4 | 4.12             | 4.23                     |                                | 4.18                                 |
| PULL #5 | 4.03             | 4.06                     |                                | 4.22                                 |
| TOTAL   | 20.47            | 20.45                    |                                | 20.68                                |
| AVG.    | 4.09             | 4.09                     |                                | 4.13                                 |

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

| OP. #        | OP. NAME                                                       | READINGS | DATE | INITIAL |
|--------------|----------------------------------------------------------------|----------|------|---------|
| 575 &<br>580 | Assemble Action<br>and Stock                                   |          |      |         |
| 600          | Proof                                                          |          |      |         |
| 607          | Check Headspace                                                |          |      |         |
| 610          | Dis-assemble Gun                                               |          |      |         |
| 612          | Magnaflux Barrel<br>Action                                     |          |      |         |
|              | Magnaflux Bolt                                                 |          |      |         |
| 615          | Rollmark Caliber                                               |          |      |         |
| 617          | Drill and Tap Sight Holes                                      |          |      |         |
| 618          | Polish Barrel                                                  |          |      |         |
| 620          | Apply Coatings<br>(Barrel Action)                              |          |      |         |
|              | Apply Coating (Bolt)                                           |          |      |         |
| 625          | Final Assembly<br>A) Clean inside of<br>Bolt Assembly          |          | 6-26 | REP     |
|              | B) Inspect Rear Firing<br>Pin Hole for Chamfer<br>in Bolt Head |          | 6-26 | REP     |
|              | C) Inspect Ejector Hole<br>for Chamfer                         |          | 6-26 | REP     |
|              | D) Oil Firing Pin Ass'y                                        |          | 6-26 | REP     |
|              | E) Adjust Trigger Pull to<br>Min Setting and Stake             |          |      |         |

| Op. #        | OP. NAME                                                    | READINGS |       |      | DATE | INIT |
|--------------|-------------------------------------------------------------|----------|-------|------|------|------|
| 625<br>cont. | F) Safety On Force                                          | 7        | 7.5   | 7.5  | 6-26 | REP  |
|              | G) Safety Off Force                                         | 3        | 4     | 4    | 6-26 | REP  |
|              | H) Trigger Pull Test & Retainability                        |          |       |      |      |      |
|              | I) Firing Pin Indent                                        | .024     | .0235 | .024 | 6-26 | REP  |
|              | J) Assemble Stock                                           |          |       |      | 6-26 | 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                                    |          |       |      | 6-26 | 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                                             | 2.41     | 2.35  | 2.32 | 2.32 | 2.19 |
|              | C) Function                                                 |          |       |      |      |      |
| 660          | Pack                                                        |          |       |      |      |      |

CENTROIDAL DISTANCE CALCULATIONS  
FOR RIFLE # 06348956  
12 Jan 1900

CENTROIDAL DISTANCES

|      |   |         |
|------|---|---------|
| 0 TO | 1 | .178227 |
| 1 TO | 2 | .210086 |
| 1 TO | 3 | .282136 |
| 1 TO | 4 | .288647 |
| 1 TO | 5 | .169956 |

56 (---POR

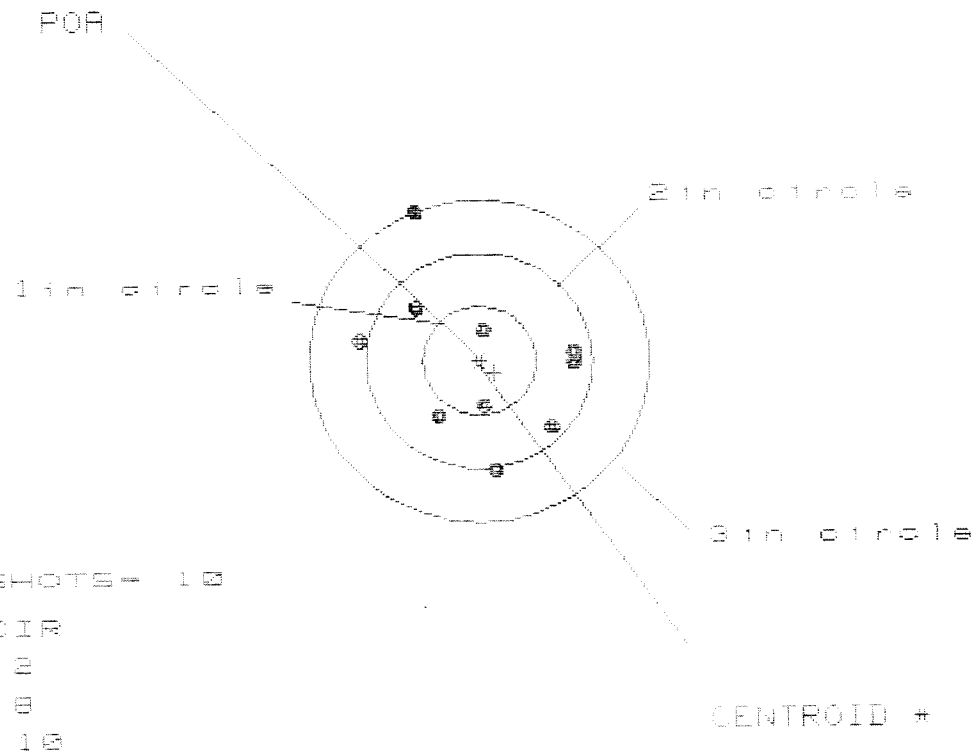
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0108  
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0556  
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0566392  
THE AMR FOR THIS RIFLE IS: .8394

18 Jan 1988

FILE:/PATTERNING/CENTERFIRE\_PATT/08348956

## CENTERFIRE PATTERNS

# 1



# OF SHOTS = 10

# IN CIR

1 in = 2

2 in = 8

3 in = 10

HS = 1.924

VS = 2.359

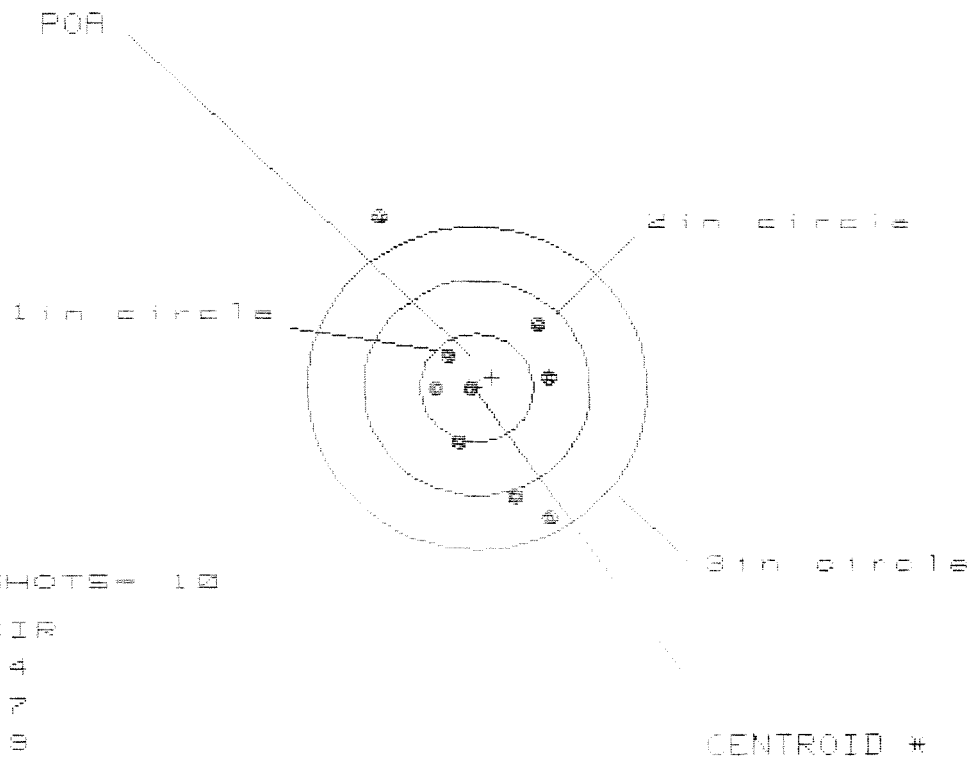
GS = 2.454

| PATTERN #                     | 1      | 2      | 3      |
|-------------------------------|--------|--------|--------|
| SHOTS (BEST OF)               | 10     | 8      |        |
| MAXIMUM X                     | .861   | .800   | .659   |
| MINIMUM X                     | -1.063 | -1.124 | -1.728 |
| MAXIMUM Y                     | 1.380  | .684   | .727   |
| MINIMUM Y                     | -.979  | -.825  | -.782  |
| CENTROID X                    | -.137  | -.076  | .065   |
| CENTROID Y                    | .114   | -.040  | -.083  |
| POA TO CENTROID in.           | .178   | .085   | .106   |
| MIN RADIUS                    | .294   | .270   | .272   |
| MEAN RADIUS                   | .820   | .723   | .650   |
| MAX RADIUS                    | 1.486  | 1.178  | 1.029  |
| HORIZONTAL SPREAD             | 1.924  | 1.924  | 1.387  |
| VERTICAL SPREAD               | 2.359  | 1.509  | 1.509  |
| EXTREME SPREAD                | 2.454  | 1.937  | 1.643  |
| NUMBER IN ONE INCH CIRCLE =   | 2      |        |        |
| NUMBER IN TWO INCH CIRCLE =   | 8      |        |        |
| NUMBER IN THREE INCH CIRCLE = | 10     |        |        |

18 Jan 1988

FILE:/PATTERNING/CENTERFIRE\_PATT/C6348956

## CENTERFIRE PATTERNS # 2



# OF SHOTS = 10

# IN CIR

1 in = 4

2 in = 7

3 in = 8

HE = 1.564

VE = 2.882

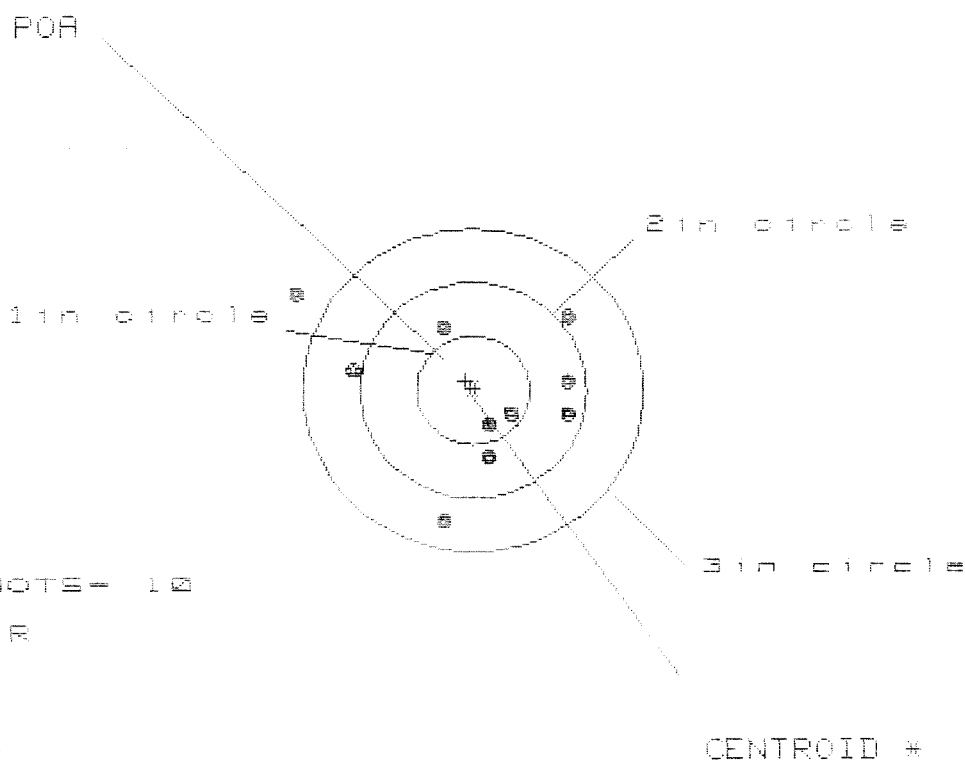
GS = 3.246

| PATTERN #                     | 1      | 2      | 3     |
|-------------------------------|--------|--------|-------|
| SHOTS (BEST OF)               | 10     | 9      | 8     |
| MAXIMUM X                     | .687   | .589   | .654  |
| MINIMUM X                     | -.877  | -.499  | -.434 |
| MAXIMUM Y                     | 1.637  | .788   | .655  |
| MINIMUM Y                     | -1.245 | -1.063 | -.940 |
| CENTROID X                    | -.143  | -.045  | -.110 |
| CENTROID Y                    | -.096  | -.278  | -.145 |
| POA TO CENTROID in.           | .172   | .281   | .182  |
| MIN RADIUS                    | .084   | .216   | .103  |
| MEAN RADIUS                   | .758   | .654   | .549  |
| MAX RADIUS                    | 1.857  | 1.183  | .978  |
| HORIZONTAL SPREAD             | 1.564  | 1.088  | 1.088 |
| VERTICAL SPREAD               | 2.882  | 1.851  | 1.595 |
| EXTREME SPREAD                | 3.246  | 1.852  | 1.516 |
| NUMBER IN ONE INCH CIRCLE =   | 4      |        |       |
| NUMBER IN TWO INCH CIRCLE =   | 7      |        |       |
| NUMBER IN THREE INCH CIRCLE = | 9      |        |       |

10 Jan 1900

FILE:/PATTERNING/CENTERFIRE\_PATT/06348956

## CENTERFIRE PATTERNS # 3



# OF SHOTS = 10

# IN CIR

1 in = 2

2 in = 6

3 in = 9

HS = 0.400

VS = 2.152

GS = 0.607

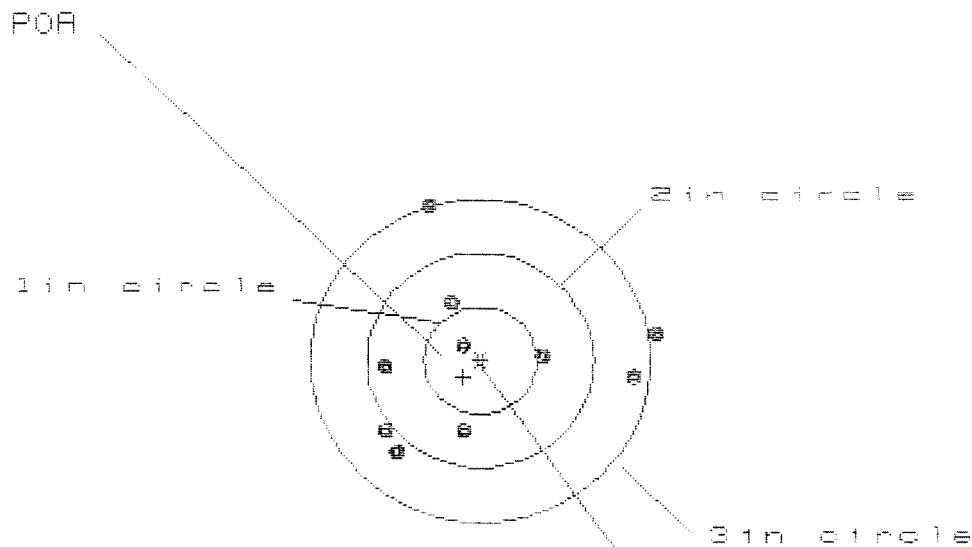
| PATTERN #                     | 1      | 2      | 3      |
|-------------------------------|--------|--------|--------|
| SHOTS (BEST OF)               | 10     | 9      | 8      |
| MAXIMUM X                     | .846   | .672   | .623   |
| MINIMUM X                     | -1.562 | -1.192 | -1.241 |
| MAXIMUM Y                     | .927   | .756   | .616   |
| MINIMUM Y                     | -1.225 | -1.122 | -.678  |
| CENTROID X                    | .063   | .237   | .286   |
| CENTROID Y                    | -.085  | -.188  | -.048  |
| POA TO CENTROID in.           | .106   | .302   | .290   |
| MIN RADIUS                    | .312   | .154   | .224   |
| MEAN RADIUS                   | .879   | .715   | .664   |
| MAX RADIUS                    | 1.816  | 1.235  | 1.255  |
| HORIZONTAL SPREAD             | 2.408  | 1.864  | 1.864  |
| VERTICAL SPREAD               | 2.152  | 1.878  | 1.294  |
| EXTREME SPREAD                | 2.607  | 2.162  | 1.914  |
| NUMBER IN ONE INCH CIRCLE =   | 2      |        |        |
| NUMBER IN TWO INCH CIRCLE =   | 6      |        |        |
| NUMBER IN THREE INCH CIRCLE = | 9      |        |        |

18 Jan 1988

FILE:/PATTERNING/CENTERFIRE\_PATT/08348956

## CENTERFIRE PATTERNS

# 4



# OF SHOTS= 10

# IN CIR

1 in = 1

2 in = 5

3 in = 8

HS= 2.367

VS= 2.302

GS= 2.528

CENTROID #

| PATTERN #                   | : | 4      |        |        |
|-----------------------------|---|--------|--------|--------|
| SHOTS (BEST OF)             | : | 10     | 9      | 8      |
| MAXIMUM X                   | : | 1.517  | 1.464  | 1.432  |
| MINIMUM X                   | : | -0.850 | -0.903 | -0.720 |
| MAXIMUM Y                   | : | 1.462  | 0.672  | 0.723  |
| MINIMUM Y                   | : | -0.840 | -0.678 | -0.627 |
| CENTROID X                  | : | 0.149  | 0.202  | 0.019  |
| CENTROID Y                  | : | 0.153  | -0.009 | -0.060 |
| POA TO CENTROID in.         | : | 0.214  | 0.202  | 0.063  |
| MIN RADIUS                  | : | 0.179  | 0.341  | 0.340  |
| MEAN RADIUS                 | : | 0.936  | 0.872  | 0.760  |
| MAX RADIUS                  | : | 1.538  | 1.519  | 1.433  |
| HORIZONTAL SPREAD           | : | 2.367  | 2.367  | 2.152  |
| VERTICAL SPREAD             | : | 2.302  | 1.350  | 1.350  |
| EXTREME SPREAD              | : | 2.528  | 2.528  | 2.209  |
| NUMBER IN ONE INCH CIRCLE   | = |        | 1      |        |
| NUMBER IN TWO INCH CIRCLE   | = |        | 5      |        |
| NUMBER IN THREE INCH CIRCLE | = |        | 8      |        |

10 Jan 1900

FILE:/PATTERNING/CENTERFIRE\_PATT/08348956

## CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

CENTROID #

# OF SHOTS = 10

# IN CIR

1in = 2

2in = 7

3in = 10

HS = 2.103

VS = 2.149

GS = 2.290

| PATTERN #                     | 5      | 9      | 8     |
|-------------------------------|--------|--------|-------|
| SHOTS (BEST OF)               | 10     | 9      | 8     |
| MAXIMUM X                     | .880   | .919   | .771  |
| MINIMUM X                     | -1.223 | -1.184 | -.908 |
| MAXIMUM Y                     | 1.247  | .801   | .771  |
| MINIMUM Y                     | -.902  | -.763  | -.793 |
| CENTROID X                    | .014   | -.025  | .123  |
| CENTROID Y                    | .192   | .053   | .083  |
| POA TO CENTROID in.           | .192   | .059   | .149  |
| MIN RADIUS                    | .285   | .414   | .310  |
| MEAN RADIUS                   | .804   | .747   | .658  |
| MAX RADIUS                    | 1.295  | 1.208  | 1.014 |
| HORIZONTAL SPREAD             | 2.103  | 2.103  | 1.679 |
| VERTICAL SPREAD               | 2.149  | 1.564  | 1.564 |
| EXTREME SPREAD                | 2.290  | 2.137  | 1.714 |
| NUMBER IN ONE INCH CIRCLE =   | 2      |        |       |
| NUMBER IN TWO INCH CIRCLE =   | 7      |        |       |
| NUMBER IN THREE INCH CIRCLE = | 10     |        |       |



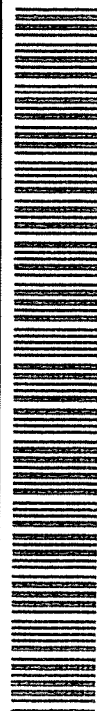

VERY IMPORTANT:  
Instruction Book  
enclosed to assure  
safe use of this  
firearm.

MODEL 700<sup>TM</sup> H24

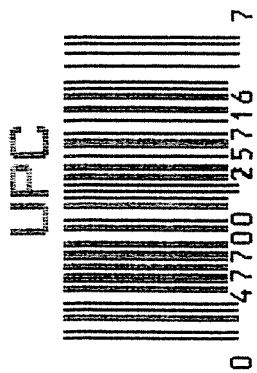
SERIAL NO.  
C6348957

ORDER NO.  
5716

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



5716 C6348957



UPC

0 47700 25716 7

GUN SERIAL # C6348957

| OP. #        | OP. NAME                                                       | READINGS | DATE     | INIT |
|--------------|----------------------------------------------------------------|----------|----------|------|
| 575 &<br>580 | Assemble Action<br>and Stock                                   | 10-9     | 89       | RW   |
| 600          | Proof                                                          | 10-9     | 89       | A.C. |
| 607          | Check Headspace                                                | 10-9     | 89       | RW   |
| 610          | Dis-assemble Gun                                               | 10-9     | 89       | RW   |
| 612          | Magnaflux Barrel<br>Action                                     |          | 10/13/89 | KCR  |
|              | Magnaflux Bolt                                                 |          | 10/13/89 | KCR  |
| 615          | Rollmark Caliber                                               |          |          |      |
| 7            | Drill and Tap Sight Holes                                      | 10 1689  |          | YB   |
| 618          | Polish Barrel <i>RB</i>                                        | 10 1689  |          | BT   |
| 620          | Apply Coatings<br>(Barrel Action)                              |          | 10-27-89 | JA   |
|              | Apply Coating (Bolt)                                           |          |          |      |
| 625          | Final Assembly<br>A) Clean inside of<br>Bolt Assembly          |          | 10/30/89 | RW   |
|              | B) Inspect Rear Firing<br>Pin Hole for Chamfer<br>in Bolt Head |          | 10/30/89 | RW   |
|              | C) Inspect Ejector Hole<br>for Chamfer                         |          | 10/30/89 | RW   |
|              | D) Oil Firing Pin Ass'y                                        |          | 10/30/89 | RW   |
|              | E) Adjust Trigger Pull to<br>Min Setting and Stake             |          | 6/10/89  | JD   |

| op. #        | OP. NAME                                                    | READINGS |      |      |      |      | DATE      | INIT |
|--------------|-------------------------------------------------------------|----------|------|------|------|------|-----------|------|
| 625<br>cont. | F) Safety On Force                                          | 5        | 5    | 5    |      |      | 11-7-89   | gfl  |
|              | G) Safety Off Force                                         | 3        | 3    | 3    |      |      | 11-7-89   | gfl  |
|              | H) Trigger Pull Test & Retainability                        |          |      |      |      |      | 6 Nov 89  | gfl  |
|              | I) Firing Pin Indent                                        | .023     | .022 | .022 |      |      | 11-7-89   | gfl  |
|              | J) Assemble Stock                                           |          |      |      |      |      | 11/7/89   | RW   |
|              | K) Assemble Swivel Studs                                    |          |      |      |      |      | 13 Nov 89 | gfl  |
|              | L) Attach Front and Rear Sight Assemblies                   |          |      |      |      |      | 11/7/89   | RW   |
|              | M) Iron Sight Alignment                                     |          |      |      |      |      | 11/7/89   | RW   |
|              | N) Detach Front & Rear Sights & place in numbered container |          |      |      |      |      | 11/7/89   | RW   |
|              | O) Attach Scope to Rifle                                    |          |      |      |      |      | 11-7-89   | gfl  |
|              | P) Detach & Attach Scope 20 Times                           |          |      |      |      |      | 11-7-89   | gfl  |
| 640          | Gallery Target & Test                                       |          |      |      |      |      | 11-9-89   | AC   |
|              | A) Time                                                     |          |      |      |      |      | 11-9-89   | AC   |
|              | B) Malfunctions                                             |          |      |      |      |      | 11-9-89   | AC   |
|              | C) Pierced Primers                                          |          |      |      |      |      | 11-9-89   | AC   |
|              | D) Optical Clarity of Scope                                 |          |      |      |      |      | 11-9-89   | AC   |
| 645          | Inspect for Live Ammo                                       |          |      |      |      |      | 11-9-89   | AC   |
| 655          | Final Inspection                                            |          |      |      |      |      |           |      |
|              | A) Headspace                                                |          |      |      |      |      | 13 Nov 89 | gfl  |
|              | B) Trigger Pull                                             | 2.70     | 2.63 | 2.78 | 2.71 | 2.73 | 13 Nov 89 | gfl  |
|              | C) Function                                                 |          |      |      |      |      | 13 Nov 89 | gfl  |
| 660          | Pack                                                        |          |      |      |      |      | 15 Dec 89 | gfl  |

AVERAGE PULL FORCE BETWEEN  
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C634 8957DATE 12 MAR 90TESTER ELB

|         | 2.50#<br>INITIAL | 2.50# AFTER<br>50 CYCLES | FINAL TEST &<br>TO RESET 2.50# |      | COMMENTS          |
|---------|------------------|--------------------------|--------------------------------|------|-------------------|
| PULL #1 | 2.51             | 2.43                     |                                | 2.87 | MIN. SETTING,     |
| PULL #2 | 2.38             | 2.42                     |                                | 2.83 | NO AVG. OF 5      |
| PULL #3 | 2.36             | 2.39                     |                                | 2.83 | READINGS ACCEPT-  |
| PULL #4 | 2.32             | 2.36                     |                                | 2.87 | ABLE LESS THAN 2# |
| PULL #5 | 2.30             | 2.38                     |                                | 2.80 |                   |
| TOTAL   | 11.87            | 11.98                    |                                |      |                   |
| AVG.    | 2.374            | 2.396                    |                                |      |                   |

|         | 3.00#<br>INITIAL | 3.00# AFTER<br>20 CYCLES |  |  | COMMENTS |
|---------|------------------|--------------------------|--|--|----------|
| PULL #1 | 3.43             | 3.29                     |  |  |          |
| PULL #2 | 3.30             | 3.31                     |  |  |          |
| PULL #3 | 3.40             | 3.29                     |  |  |          |
| PULL #4 | 3.35             | 3.28                     |  |  |          |
| PULL #5 | 3.37             | 3.28                     |  |  |          |
| TOTAL   | 16.85            | 16.45                    |  |  |          |
| AVG.    | 3.37             | 3.29                     |  |  |          |

|         | 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 | 4.29             | 4.29                     |                                |                                      |
| PULL #2 | 4.36             | 4.27                     |                                |                                      |
| PULL #3 | 4.43             | 4.26                     |                                |                                      |
| PULL #4 | 4.46             | 4.24                     |                                |                                      |
| PULL #5 | 4.49             | 4.06                     |                                |                                      |
| TOTAL   | 22.05            | 21.32                    |                                |                                      |
| AVG.    | 4.41             | 4.264                    |                                |                                      |

CENTROIDAL DISTANCE CALCULATIONS  
 FOR RIFLE # 06348957  
 10 Nov 1989

CENTROIDAL DISTANCES

|      |   |         |
|------|---|---------|
| 0 TO | 1 | .155647 |
| 1 TO | 2 | .589964 |
| 1 TO | 3 | .153264 |
| 1 TO | 4 | .500729 |
| 1 TO | 5 | .141421 |

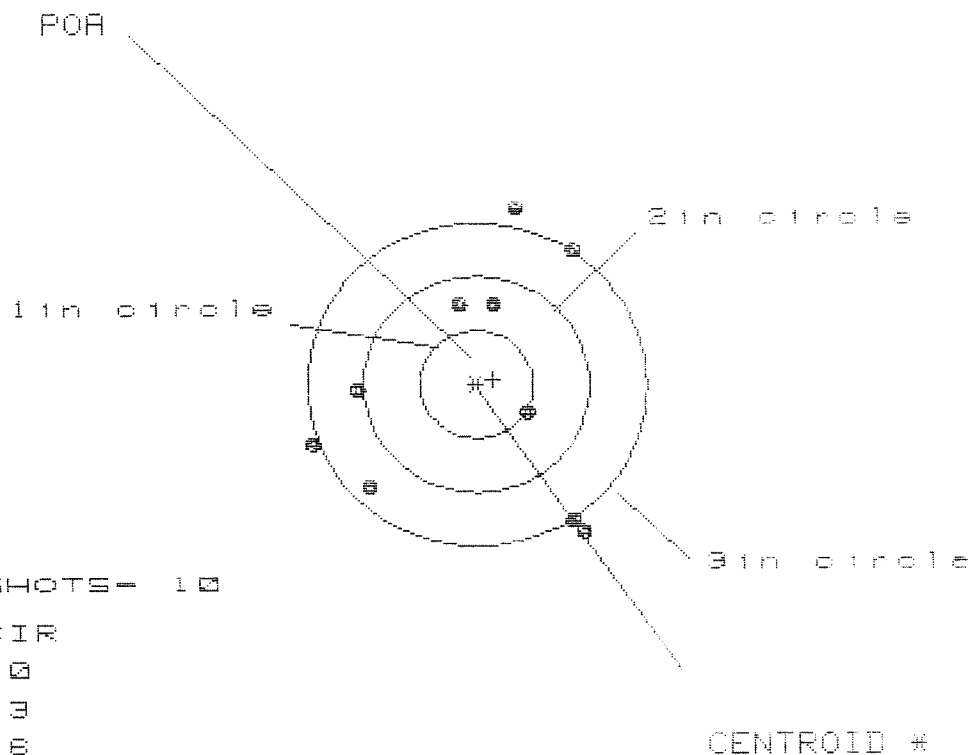
$\frac{2}{5} +$  (----FOR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0094  
 THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0724  
 THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0730077  
 THE AMR FOR THIS RIFLE IS: 1.127

18 Nov 1989

FILE:/PATTERNING/CENTERFIRE\_PATT/08348357

## CENTERFIRE PATTERNS # 1



# OF SHOTS= 10

# IN CIR

1in = 0

2in = 3

3in = 6

HS= 2.427

VS= 2.998

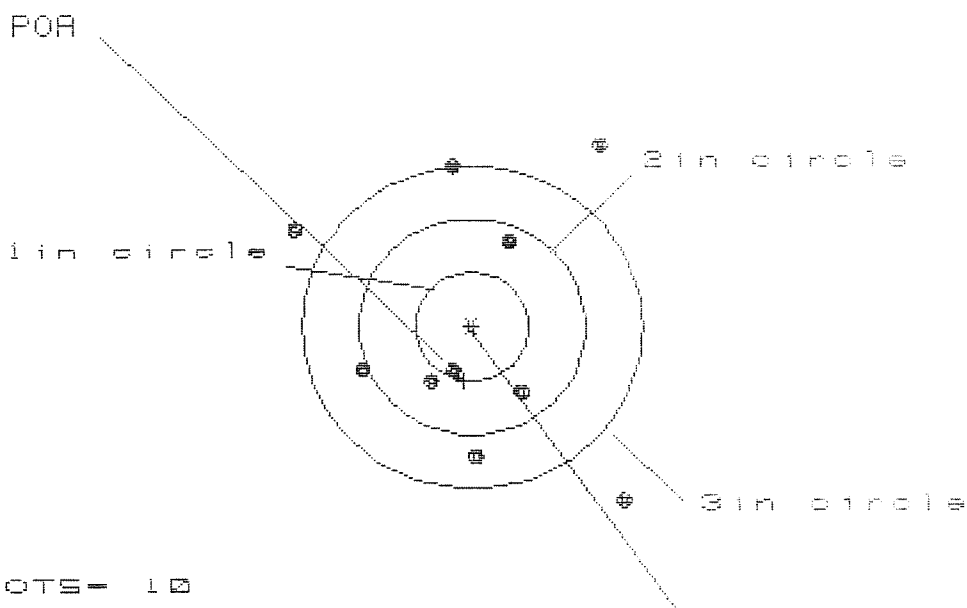
GS= 3.066

| PATTERN #                   | : | 1      |        |        |
|-----------------------------|---|--------|--------|--------|
| SHOTS (BEST OF)             | : | 10     | 9      | 8      |
| MAXIMUM X                   | : | .985   | .969   | 1.025  |
| MINIMUM X                   | : | -1.442 | -1.332 | -1.276 |
| MAXIMUM Y                   | : | 1.621  | 1.469  | 1.228  |
| MINIMUM Y                   | : | -1.377 | -1.398 | -1.215 |
| CENTROID X                  | : | -.149  | -.259  | -.315  |
| CENTROID Y                  | : | -.045  | .108   | -.075  |
| POA TO CENTROID in.         | : | .156   | .281   | .324   |
| MIN RADIUS                  | : | .515   | .592   | .659   |
| MEAN RADIUS                 | : | 1.222  | 1.148  | 1.104  |
| MAX RADIUS                  | : | 1.693  | 1.701  | 1.590  |
| HORIZONTAL SPREAD           | : | 2.427  | 2.301  | 2.301  |
| VERTICAL SPREAD             | : | 2.998  | 2.867  | 2.443  |
| EXTREME SPREAD              | : | 3.066  | 2.913  | 2.835  |
| NUMBER IN ONE INCH CIRCLE   | = |        | 0      |        |
| NUMBER IN TWO INCH CIRCLE   | = |        | 3      |        |
| NUMBER IN THREE INCH CIRCLE | = |        | 6      |        |

18 May 1989

FILE:/PATTERNING/CENTERFIRE\_PATT/06346957

## CENTERFIRE PATTERNS # 2



# OF SHOTS= 10

# IN CIR

1 in = 1

2 in = 4

3 in = 6

HS= 2.837

VS= 3.288

GS= 3.815

CENTROID #

| PATTERN #                   | : | 2      |        |        |
|-----------------------------|---|--------|--------|--------|
| SHOTS (BEST OF)             | : | 10     | 9      | 8      |
| MAXIMUM X                   | : | 1.308  | 1.285  | .719   |
| MINIMUM X                   | : | -1.529 | -1.384 | -1.223 |
| MAXIMUM Y                   | : | 1.656  | 1.475  | 1.494  |
| MINIMUM Y                   | : | -1.632 | -1.423 | -1.239 |
| CENTROID X                  | : | .067   | -.078  | -.239  |
| CENTROID Y                  | : | .504   | .685   | .501   |
| POA TO CENTROID in.         | : | .508   | .690   | .555   |
| MIN RADIUS                  | : | .490   | .632   | .459   |
| MEAN RADIUS                 | : | 1.235  | 1.149  | .998   |
| MAX RADIUS                  | : | 2.091  | 1.956  | 1.532  |
| HORIZONTAL SPREAD           | : | 2.837  | 2.669  | 1.942  |
| VERTICAL SPREAD             | : | 3.288  | 2.898  | 2.733  |
| EXTREME SPREAD              | : | 3.815  | 3.105  | 2.740  |
| NUMBER IN ONE INCH CIRCLE   | = |        | 1      |        |
| NUMBER IN TWO INCH CIRCLE   | = |        | 4      |        |
| NUMBER IN THREE INCH CIRCLE | = |        | 6      |        |

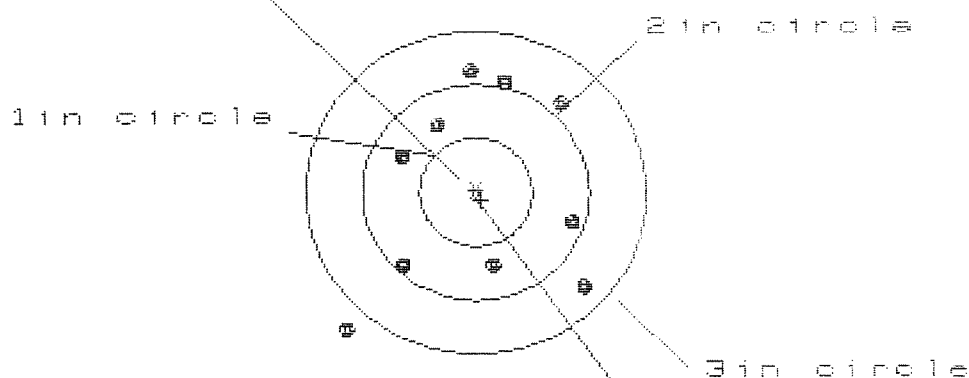
18 Nov 1989

FILE:/PATTERNING/CENTERFIRE\_PATT/08348957

## CENTERFIRE PATTERNS

# 3

POA



# OF SHOTS- 10

# IN CIR

1in = 0

2in = 5

3in = 9

HS= 2.157

VS= 2.438

GS= 2.833

CENTROID \*

| PATTERN #                     | 3      |        |       |
|-------------------------------|--------|--------|-------|
| SHOTS (BEST OF)               | 10     | 9      | 8     |
| MAXIMUM X                     | .974   | .843   | .779  |
| MINIMUM X                     | -1.183 | -.794  | -.689 |
| MAXIMUM Y                     | 1.142  | .998   | .866  |
| MINIMUM Y                     | -1.296 | -1.057 | -.980 |
| CENTROID X                    | -.050  | .081   | -.024 |
| CENTROID Y                    | .072   | .216   | .348  |
| POA TO CENTROID in.           | .088   | .231   | .349  |
| MIN RADIUS                    | .669   | .717   | .551  |
| MEAN RADIUS                   | 1.026  | .928   | .848  |
| MAX RADIUS                    | 1.755  | 1.352  | 1.141 |
| HORIZONTAL SPREAD             | 2.157  | 1.637  | 1.468 |
| VERTICAL SPREAD               | 2.438  | 2.055  | 1.846 |
| EXTREME SPREAD                | 2.833  | 2.316  | 1.995 |
| NUMBER IN ONE INCH CIRCLE =   |        | 0      |       |
| NUMBER IN TWO INCH CIRCLE =   |        | 5      |       |
| NUMBER IN THREE INCH CIRCLE = |        | 9      |       |

18 Nov 1989

FILE:/PATTERNING/CENTERFIRE\_PATT/C8348957

## CENTERFIRE PATTERNS

# 4

POA

1 in circle

2 in circle

3 in circle

CENTROID \*

# OF SHOTS- 10

# IN CIR

1 in = 1

2 in = 6

3 in = 9

HS= 2.803

VS= 1.790

GS= 2.822

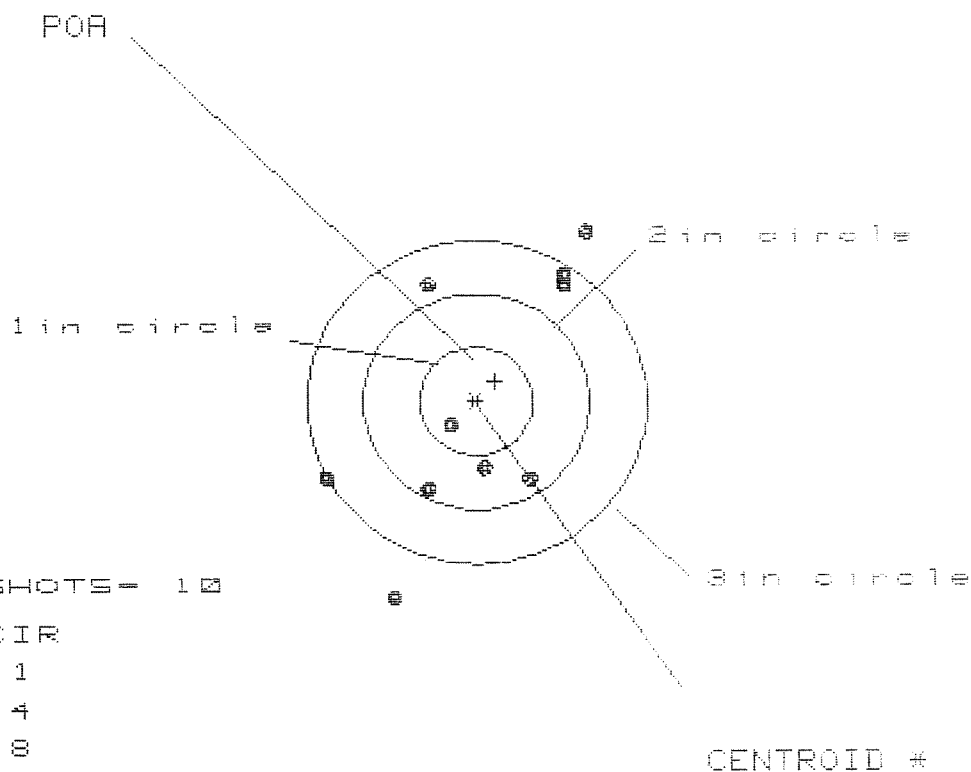
| PATTERN #                   | : | 4      |        |       |
|-----------------------------|---|--------|--------|-------|
| SHOTS (BEST OF)             | : | 10     | 9      | 8     |
| MAXIMUM X                   | : | 1.563  | 1.284  | 1.151 |
| MINIMUM X                   | : | -1.240 | -1.067 | -.758 |
| MAXIMUM Y                   | : | 1.044  | 1.040  | .996  |
| MINIMUM Y                   | : | -.746  | -.750  | -.794 |
| CENTROID X                  | : | .348   | .175   | .308  |
| CENTROID Y                  | : | .016   | .020   | .064  |
| POA TO CENTROID in.         | : | .349   | .176   | .315  |
| MIN RADIUS                  | : | .400   | .435   | .435  |
| MEAN RADIUS                 | : | .957   | .870   | .837  |
| MAX RADIUS                  | : | 1.563  | 1.303  | 1.217 |
| HORIZONTAL SPREAD           | : | 2.803  | 2.351  | 1.909 |
| VERTICAL SPREAD             | : | 1.790  | 1.790  | 1.790 |
| EXTREME SPREAD              | : | 2.822  | 2.355  | 2.240 |
| NUMBER IN ONE INCH CIRCLE   | = |        | 1      |       |
| NUMBER IN TWO INCH CIRCLE   | = |        | 6      |       |
| NUMBER IN THREE INCH CIRCLE | = |        | 9      |       |

10 Nov 1989

FILE:/PATTERNING/CENTERFIRE\_PATT/08348957

## CENTERFIRE PATTERNS

# 5



# OF SHOTS= 10

# IN CIR

1in = 1

2in = 4

3in = 8

HS= 2.296

VS= 3.401

GS= 3.820

| PATTERN #                     | 5      |        |        |
|-------------------------------|--------|--------|--------|
| SHOTS (BEST OF)               | 10     | 9      | 8      |
| MAXIMUM X                     | 1.014  | .934   | .825   |
| MINIMUM X                     | -1.282 | -1.362 | -1.245 |
| MAXIMUM Y                     | 1.562  | 1.358  | 1.175  |
| MINIMUM Y                     | -1.839 | -1.008 | -.838  |
| CENTROID X                    | -.169  | -.089  | -.206  |
| CENTROID Y                    | -.185  | .019   | -.151  |
| POA TO CENTROID in.           | .251   | .091   | .255   |
| MIN RADIUS                    | .325   | .534   | .328   |
| MEAN RADIUS                   | 1.195  | 1.126  | 1.018  |
| MAX RADIUS                    | 1.976  | 1.657  | 1.466  |
| HORIZONTAL SPREAD             | 2.296  | 2.296  | 2.070  |
| VERTICAL SPREAD               | 3.401  | 2.366  | 2.013  |
| EXTREME SPREAD                | 3.820  | 3.251  | 2.827  |
| NUMBER IN ONE INCH CIRCLE =   |        | 1      |        |
| NUMBER IN TWO INCH CIRCLE =   |        | 4      |        |
| NUMBER IN THREE INCH CIRCLE = |        | 8      |        |